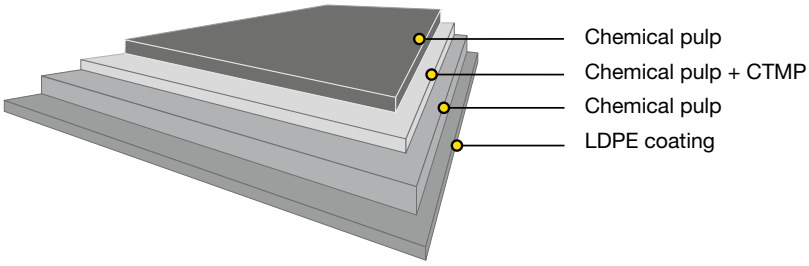
Cupforma Natura™ PE

Bleached cup board with PE coating

Cupforma Natura PE is a virgin-fibre bleached board with a three layer fibre construction and with CTMP (chemi-thermomechanical pulp) in the middle layer and LDPE coating on the reverse side.



Issued: 05.2024
Cancels: 04.2023

Technical specification

Typical properties, US										
Polymer coated board:		3.1+34.8	3.1+37.7	3.1+39.9	3.1+43.8	3.1+47.5	3.1+53.2	3.1+60.4	3.1+67.6	
Nominal basis weight, lb/1000 sq. Ft.		37.9	40.8	43.0	46.9	50.6	56.3	63.5	70.7	
LDPE reverse, lb/1000 sq. Ft.		3.1	3.1	3.1	3.1	3.1	3.1	3.1	3.1	
Caliper, pt		8.9	10.2	11.2	12.2	13.4	15.0	16.5	18.1	
Baseboard:										
Nominal basis weight, lb/1000 sq. Ft.		34.8	37.7	39.9	43.8	47.5	53.3	60.4	67.6	
Caliper, pt		8.5	9.8	10.8	11.8	13.0	14.6	16.1	17.7	
Typical properties, Metric	Tolerance									Method
Polymer coated board:		170+15	184+15	195+15	214+15	232+15	260+15	295+15	330+15	
Nominal basis weight, g/m²	±5%	185	199	210	229	247	275	310	345	ISO 536
LDPE reverse, g/m²	±2	15	15	15	15	15	15	15	15	Mill method
Thickness, µm	±6%	225	260	285	310	340	380	420	460	ISO 534
Baseboard:										
Nominal basis weight, g/m²	±4%	170	184	195	214	232	260	295	330	ISO 536
Thickness, µm	±5%	215	250	275	300	330	370	410	450	ISO 534
Bending resistance L&W 15° MD, mN	min -25%	65	105	130	160	215	290	380	500	ISO 2493-1
Bending resistance L&W 15° CD, mN	min -25%	28	43	55	75	95	130	170	230	
Moisture %	min 7.0%	9.0	8.0	8.0	8.0	8.0	8.0	8.0	8.0	ISO 287
Brightness D65/10, %, Top	min 80	84	84	84	84	84	84	84	84	ISO 2470-2
Surface Smoothness, Bendtsen, ml/min	max 400	150	200	250	250	300	300	300	300	ISO 8791-2
Stretch CD, %	min 4.5%	6.0	6.0	6.0	6.0	6.0	6.0	6.0	6.0	ISO 1924-3

All properties according to Imatra Mill measurements from board machine production.
Laboratory test climate 23°C/50% RH (according to ISO 187).
Tolerances based upon 95% confidence limits, apply to delivered reel/pallet average.

Cupforma™ by Stora Enso

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Certificates

Quality management ISO 9001
Environmental management ISO 14001
Product safety FSSC 22000
Occupational health and safety ISO 45001
Energy management ISO 50001

FSC and PEFC certified board available upon request.

Paperboard can be recycled

Key characteristics and main enduses

Cupforma Natura PE is designed especially for cups. It is food-safe and the baseboard is made with renewable materials. Cupforma Natura PE works smoothly and consistently in cup converting. It is also economical as the board's structure provides the required stiffness; resulting in light, yet functional cups. Cupforma Natura PE delivers excellent results in flexographic, offset and digital printing. Combined with LDPE coating on the reverse side, Cupforma Natura PE is sealed easily into a cup, and is perfect for a hot cup for e.g.coffee-to-go.

Printing and finishing techniques

The product can be used for different printing techniques such as offset, flexo and digital printing. It is important to check possible limitations of the printing and converting equipment and ensure that the basis weight of the board fits the tooling to be used. Since a wide variety of digital printing equipment is available in the market, it is important that a new commercial digital print job is always preceded by a trial run, including all required printing and converting process phases.

Storage recommendations

For optimal printing results, the moisture proof wrapping should not be removed until the board has reached the temperature of the press room.

Pallet/Reel Weight (kg)	Difference in temperature between board and press room (press room temp. approx. 68°F)		
	50°F	68°F	86°F
881 lbs	2 days	2 days	3 days
1763 lbs	2 days	3 days	4 days
2645 lbs	2 days	4 days	5 days

The product properties, according to the specifications, are guaranteed for 12 months after the production date. In order to ensure product safety, the product must be well wrapped and stored indoors, sheltered from rain and snow. The recommended storage conditions are 50–55% relative humidity and 68–73.4°F.

For the Corona treatment, we recommend using the board within 12 months of the production date; after this period, the treatment level should be tested before printing or gluing.