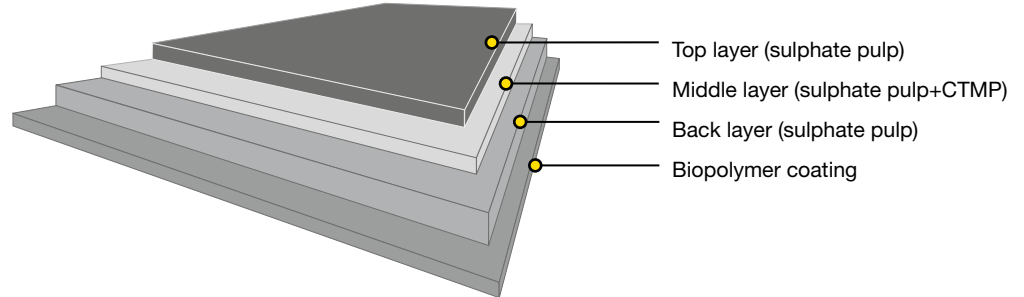


Cupforma Natura™ Bio

Bleached cup board, industrially compostable

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



Issued: 09.2023
Cancels: 05.2023

Technical specification

Polymer coated board:	Tolerance	170+25	184+25	195+25	214+25	232+25	260+25	295+25	330+25	Standard
Grammage, g/m ²	±6%	195	209	220	239	257	285	320	355	ISO 536
Bio reverse, g/m ²	min 24	25	25	25	25	25	25	25	25	Mill method
Thickness, µm	±6%	235	270	295	320	350	390	430	470	ISO 534
Baseboard:										
Grammage, g/m ²	±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
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 2471-2
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



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Certificates

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



FSC and PEFC certified board available upon request.



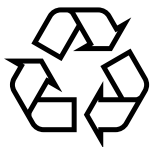
Industrially compostable according to EN 13432 standard.



Industrial compostable according to ASTM 6868 standard.



Biobased according to EN 16640 standard.



Paperboard can be recycled

Key characteristics and main enduses

Cupforma Natura Bio is a sustainable choice; a high-quality carton board designed especially for cups. It is food-safe, ecological, and 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. Combined with Bio coating, Cupforma Natura is sealed easily into a cup, and is used for hot drinks, for e.g. coffee-to-go. This product is compostable in industrial composting and can be collected together with food waste in most collecting schemes.

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. 20°C)		
	10°C	20°C	30°C
400 kg	2 days	2 days	3 days
800 kg	2 days	3 days	4 days
1200 kg	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 20-23° C.