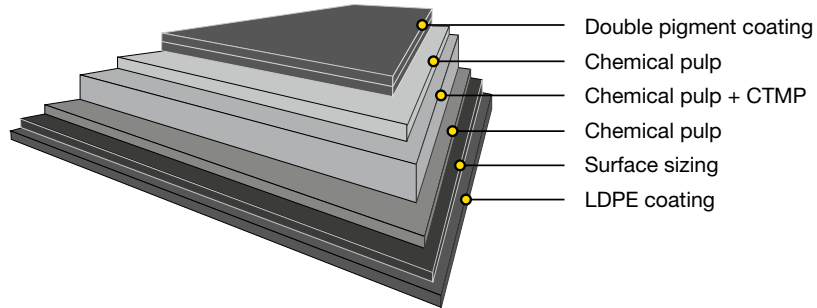


## Fully coated CTMP board with polymer coating

Performa Natura PE is a board with a three layer fibre construction and with CTMP (chemi-thermomechanical pulp) in the middle layer and a double-pigment-coated top side. The board has LDPE coating on its reverse side.



Issued: 02.2024  
Cancels: 09.2017

### Technical specification

Property / Unit	Tolerance	195+20	210+20	230+20	255+20	270+20	295+20	320+20	350+20	Standard
<b>Polymer coated board:</b>										
Grammage, g/m <sup>2</sup>		215	230	250	275	290	315	340	370	ISO 536
LDPE Reverse, g/m <sup>2</sup>		20	20	20	20	20	20	20	20	Mill method
Thickness, µm		278	298	338	368	408	448	488	528	ISO 534
<b>Baseboard:</b>										
Grammage, g/m <sup>2</sup>	±4%	195	210	230	255	270	295	320	350	ISO 536
Thickness, µm	±4%	260	280	320	350	390	430	470	510	ISO 534
Bending resistance L&W 15° MD, mN	-15%	120	155	215	270	360	475	600	760	ISO 2493
Bending resistance L&W 15° CD, mN	-15%	55	70	95	125	170	210	270	340	
Bending moment Taber 15° MD, mNm	-15%	5.8	7.5	10.4	13.0	17.4	22.9	29.0	36.7	
Bending moment Taber 15° CD, mNm	-15%	2.7	3.4	4.6	6.0	8.2	10.1	13.0	16.4	
Bending stiffness DIN 5° MD, mNm	-15%	10.2	13.2	18.3	23.0	30.6	40.4	51.0	64.6	
Bending stiffness DIN 5° CD, mNm	-15%	4.7	6.0	8.1	10.6	14.5	17.9	23.0	28.9	
Moisture, %		6.5	6.5	6.5	6.5	6.5	6.5	6.5	6.5	ISO 287
ISO Brightness C/2°, %, Top		85	85	85	85	85	85	85	85	ISO 2470-1
Brightness D65/10°, %, Top		85	85	85	85	85	85	85	85	ISO 2470-2
Surface Smoothness, PPS 10, µm, Top		1.2	1.2	1.2	1.2	1.2	1.2	1.2	1.2	ISO 8791-4
Gloss 75°, %		45	45	45	45	45	45	45	45	ISO 8254-1
Scott Bond, J/m <sup>2</sup>		200	200	200	200	200	200	200	200	TAPPI 569
Robinson chocolate test		max 0.5 for one year storage in reels/pallet								EN 1230-2
OBA not added										

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.  
Bending moment Taber 15° and Bending resistance L&W 15° are binding, Bending stiffness DIN 5° are indicative.  
Bending moment Taber 15° calculated from Bending resistance L&W 15°.



# Performa Natura™ PE

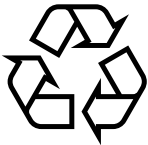
Fully coated CTMP board with polymer coating

## Certificates

- Quality management ISO 9001
- Environmental management ISO 14001
- Product safety FSC 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

Performa Natura PE features a technically advanced structure for good runnability in converting and packaging design. No optical brightening additives are used in production of Performa Natura PE. As an OBA non-added board Performa Natura PE is highly suitable for food and chocolate packaging. The LDPE coated board is typically used for frozen and chilled food products.

## Printing and finishing techniques

The product can be used with different printing techniques such as offset, flexo, rotogravure and digital printing. In digital printing, the product is suitable for several different sheet- or web-fed presses. Inkjet, dry or liquid toner technology can be used, although in some cases, pretreatment of the substrate might be required. The latest certification status can be verified on the press manufacturer's website or with local Stora Enso representatives. It is important to check the limitations of the equipment, particularly because of the exceptional difference in the thickness and stiffness of board compared with paper in the same grammages. When running thicker substrates, the press manufacturer's recommendations should be referred to for optimal grain direction. Essentially all of the same finishing processes apply to both digitally printed and offset printed work. Since a wide variety of digital printing equipment is available in the market, it is important that a new commercial print job is always preceded by a trial run, including all required printing and converting process phases. The product works very well with different finishing techniques, such as embossing, hot foil stamping and others. It is suitable for laser coding. Certificate according to PTS-DF 105/2019 is available upon request.

## 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.

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.