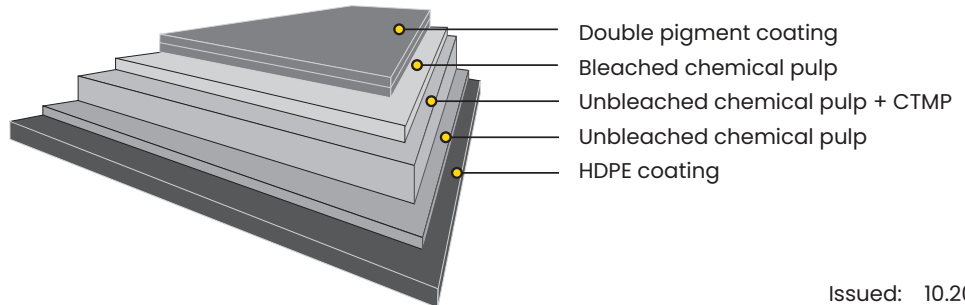


Multilayer kraft back board

CKB HDPE is a high-density, polyethylene-coated multi-layer kraft back board with a bleached chemical pulp layer on the top side and other layers made of CTMP and unbleached chemical pulp. The top side is white and the reverse is side brown, coated with HDPE.



Issued: 10.2025
Replaces: 04.2025

Technical specification

Property	Unit	Tolerance	195+30	220+30	235+30	255+30	270+30	290+30	315+30	350+30	380+30	415+30	Standard
Barrier coated board:													
Grammage	g/m ²		225	250	265	285	300	320	345	380	410	445	ISO 536
HDPE	g/m ²		30	30	30	30	30	30	30	30	30	30	
Thickness	µm		330	390	430	465	480	520	570	630	695	740	ISO 534
Baseboard:													
Grammage	g/m ²	±4%	195	220	235	255	270	290	315	350	380	415	ISO 536
Thickness	µm	±5%	300	360	400	435	450	490	540	600	665	710	ISO 534
Bending moment Taber 15° MD	mNm	-15%	7.8	12.0	15.3	20.2	24.0	29.5	37.4	46.9	56.4	77.0	
Bending moment Taber 15° CD	mNm	-15%	3.7	5.7	7.3	9.6	10.0	12.8	16.2	20.4	24.5	31.0	
Bending resistance L&W 15° MD	mN	-15%	160	250	319	416	495	611	775	971	1168	1585	ISO 2493
Bending resistance L&W 15° CD	mN	-15%	76	119	152	198	210	266	336	422	508	635	ISO 2493
Bending stiffness DIN 5° MD	mNm		14.0	22.0	28.0	38.0	43.0	56.0	71.0	96.0	109.0	163.0	
Bending stiffness DIN 5° CD	mNm		7.0	10.0	14.0	18.0	19.0	24.0	31.0	40.0	47.0	65.0	
Moisture	%	±1	7.0	7.0	7.5	7.5	7.5	8.0	8.5	9.0	9.5	9.5	ISO 287
ISO Brightness C/2°, Top	%	min. 78	80	80	80	80	80	80	80	80	80	80	ISO 2470-1
Surface Smoothness PPS10, Top	µm	max. 2.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	ISO 8791-4
Gloss 75°	%		35	35	35	35	30	30	30	30	30	30	ISO 8254-1
Scott Bond	J/m ²	min. 100	175	175	175	175	175	175	175	175	175	175	TAPPI 569 om-22
Edge Wicking	kg/m ²	max. 1.0	0.5	0.5	0.5	0.5	0.5	0.5	0.5	0.5	0.5	0.5	Mill method
Tearing resistance GM	mN		2400	3000	3300	3700	4150	4600	5100	5700	6400	6500	Tappi 496
Cobb ₆₀ , Top	g/m ²		30	30	30	30	30	30	30	30	30	30	ISO 535
Robinson chocolate test	-		< 1 for one year storage in reels/pallets										EN1230-2

Thickness: tolerance for grammage 415 g/m² is +5 %/-3.5 %.

Produced with RaZoR concept.

All properties according to 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°.

Wet tearing resistance is typically 25–30% of dry tearing resistance, except for wet strength (WS) qualities, where the wet tearing resistance is 60% of dry tearing resistance.

Multilayer kraft back board

Certificates

Quality management ISO 9001
 Environmental management ISO 14001
 Food 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

CKB HDPE is all about strong character, strong brands and strong messages. It is an ideal packaging material for applications that require improved protection against grease, such as pet food. The material offers exceptional stiffness and strength, combined with great runnability and good grease and moisture barrier. CKB HDPE is also food-safety proven. CKB HDPE can help optimize package performance, ensures high visual quality and saves materials. The HDPE coating is transparent.

Printing and finishing techniques

The product can be used with different printing techniques such as offset, flexo 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 and ink jet marking. Certificates according to PTS-DF 105/2023 and PTS-DF 103/2022 are 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 in its original cover 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.