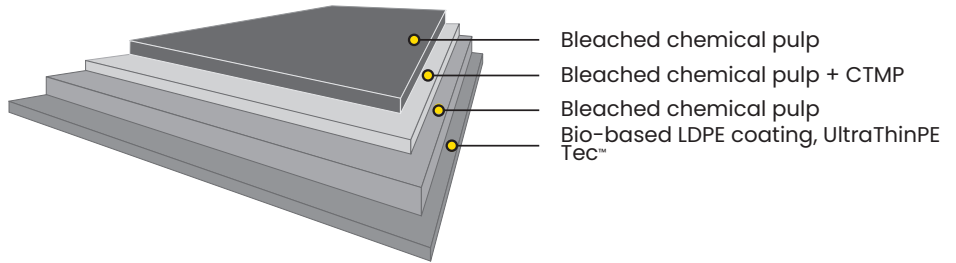


Cupforma Natura™ PE Green

Bleached cup board with bio-based PE coating, UltraThinPE Tec™

Cupforma Natura PE Green is a virgin-fibre bleached cup board with a three layer fibre construction with CTMP (chemi-thermomechanical pulp) in the middle layer and bio-based LDPE coating produced with UltraThinPE Tec™ on the reverse side.



Issued: 03/2026
Replaces: 11/2025

Technical specification

Property	Unit	Tolerance	170+11	184+11	195+11	214+11	232+11	260+11	295+11	330+11	Standard
Barrier coated board:											
Grammage	g/m ²	±5%	181	195	206	225	243	271	306	341	ISO 536
Polymer, Reverse	g/m ²	±1.0	11	11	11	11	11	11	11	11	Mill method
Thickness	µm	±6%	220	255	280	305	335	375	415	455	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	ISO 2493
Moisture	%	min 7.0%	9.0	8.0	8.0	8.0	8.0	8.0	8.0	8.0	ISO 287
ISO 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
Tensile stretch CD	%	min 4.5%	6.0	6.0	6.0	6.0	6.0	6.0	6.0	6.0	ISO 1924-3

Surface Smoothness Bendtsen max. tolerance in the lowest substance is 300ml/min.

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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.



Confirmation based on the EN 16640 standard.



Paperboard can be recycled

Key characteristics and main enduses

Cupforma Natura PE Green is designed especially for cups. It is food-safe and the baseboard and coating are based on renewable materials. Cupforma Natura PE Green 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 Green delivers excellent results in flexographic, offset and digital printing. Combined with bio-based LDPE coating on the reverse side, Cupforma Natura PE Green can be sealed as easy as with traditional LDPE 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. 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.