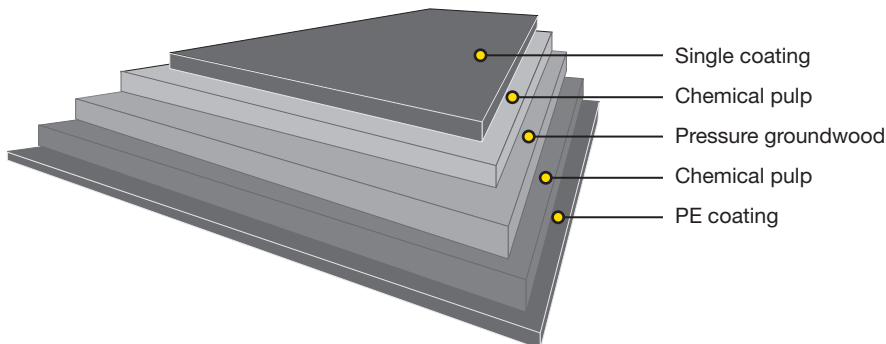


Tamfold PE is a polyethylene-coated GC2 board. The board has chemical pulp layers on both sides and pressure groundwood in the middle layer. The top is white and the reverse is cream, coated with transparent PE. Tamfold PE is also available hard-sized (HS).



Issued: 08.2017  
Cancels: 12.2013

### Technical specification

Property/Unit	Tolerance	190+15	200+15	210+15	220+15	230+15	240+15	250+15	260+15	275+15	300+15	325+15	Standards
<b>Polymer coated board:</b>													
Grammage, g/m <sup>2</sup>		205	215	225	235	245	255	265	275	290	315	340	ISO 536
Polymer reverse, g/m <sup>2</sup>		15	15	15	15	15	15	15	15	15	15	15	Mill method
Thickness, µm		365	390	415	435	455	475	495	515	555	615	665	ISO 536
<b>Baseboard:</b>													
Grammage, g/m <sup>2</sup>	±4%	190	200	210	220	230	240	250	260	275	300	325	ISO 536
Thickness, µm	±4% or max. ±20µm	350	375	400	420	440	460	480	500	540	600	650	ISO 534
Bending moment Taber 15° MD, mNm	-10%	8.7	10.2	12.4	14.1	15.7	17.5	19.9	21.9	25.8	32.9	39.7	ISO 2493
Bending moment Taber 15° CD, mNm	-10%	4.6	5.5	6.6	7.5	8.3	9.3	10.5	11.6	13.6	17.3	20.9	
Bending resistance L&W 15° MD, mN	-10%	180	211	257	292	325	362	412	453	534	681	822	
Bending resistance L&W 15° CD, mN	-10%	95	114	137	155	172	193	217	240	282	358	433	
Bending stiffness DIN 5° MD, mNm	-10%	17.4	20.3	24.7	28.1	31.3	34.9	39.7	43.7	51.5	65.6	79.2	DIN 53121
Bending stiffness DIN 5° CD, mNm	-10%	9.2	11.0	13.2	15.0	16.6	18.6	20.9	23.1	27.1	34.5	41.7	
Moisture, %	±1	7.5	8.0	8.0	8.0	8.0	8.0	8.0	8.0	8.5	8.5	9.2	ISO 287
ISO Brightness C/2°, %, Top	min. 78	80	80	80	80	80	80	80	80	80	80	80	ISO 2470-1
Surface Smoothness PPS 10, µm, Top	max. 2.8	2.4	2.4	2.4	2.4	2.4	2.4	2.4	2.4	2.4	2.4	2.4	ISO 8791-4
Scott Bond, J/m <sup>2</sup>	min. 100	130	130	130	130	130	130	130	130	130	130	130	TAPPI 569
Edge wicking*, g/mm.m		<1.0	<1.0	<1.0	<1.0	<1.0	<1.0	<1.0	<1.0	<1.0	<2.0	<2.0	
Robinson chocolate test		max. 0.5 for one year storage in reels/pallets											EN 1230-2

OBA not added

\*) For hard-sized

All properties according to Ingerois and Forshaga Mills' 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.

### Certificates

Quality management ISO 9001  
Environmental management ISO 14001  
Product safety FSSC 22000  
Health and safety OHSAS 18001  
Energy management ISO 50001



FSC and PEFC certified board available upon request.



Paperboard is recyclable

### Key characteristics and main enduses

Tamfold PE provides excellent value, runnability and performance in applications that require protection against humidity. The continuous product development of Tamfold has resulted in excellent stiffness and bulk attributes, and the board also performs well in printing and converting processes, including digital printing, laser and inkjet coding. Tamfold offers excellent value for the money, thanks to its exceptional yield. Tamfold PE helps optimize package performance and saves materials, thus helping to reduce food waste.

### 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 and ink jet marking. Certificates according to PTS-DF 105/2013 and PTS-DF 103/2011 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 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.

