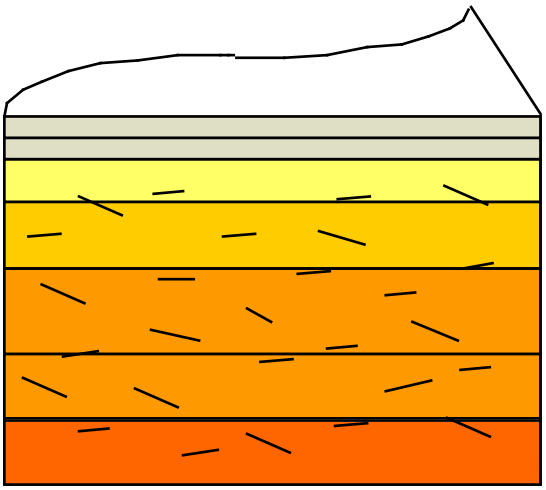
Eagle CKB Board

Coated Kraft Back



Top Coating	Blade
Base Coating	Blade
Kraft Pulp Layers	Bleached long & short fibre kraft pulp (strength & toughness) 3 middle layers combine CTMP & long fibre sulphate kraft pulp (optimal bulk) Unbleached long & short fibre kraft pulp (strength & toughness)

Basis Weight	Caliper	Bending Stiffness		Bending Resistance		Bending Moment		Moisture	Tear Resistance
gsm	µm	DIN 5° mNm MD	CD	L&W 15° MD	CD	Taber 15° MD	CD	%	GM MN
185	254	9.5	4.1	109	47	5.3	2.3	7.0	2,500
205	305	15.2	6.5	176	76	8.5	3.7	7.0	3,000
230	350	23.2	10.0	265	115	12.8	5.6	7.0	3,400
250	390	32.0	13.5	356	155	17.2	7.5	7.5	3,800
270	430	40.3	17.4	450	196	21.7	9.5	7.5	4,300
300	485	55.7	24.1	611	266	29.5	12.8	8.0	4,900
325	540	71.4	30.7	775	336	37.4	16.2	8.5	5,400
360	585	96.3	39.9	971	422	46.9	20.4	9.0	6,100
390	630	108.9	47.0	1168	508	56.4	24.5	9.5	6,800
+3/-5%	+/-5%	-15%	-15%					+/-1%	-600

Brightness	ISO PS	81 %	min 79
Whiteness	CIE (D65/10°) PS	74	min 69
b*	CIE (D65/10°) PS	2.0	
Gloss	75° PS	40 %	
Surface Smoothness PS PPS_{10}			
	230-325gsm	1.7 µm	max 2.3
	360-390gsm	2.0µm	max 2.5
Surface Roughness BS Bendtsen		1000 ml/min	max 1800
Scott-Plybond		150 J/m^2	min 100
Cobb 60	Top and Reverse	30 g/m^2	

DG 5/03

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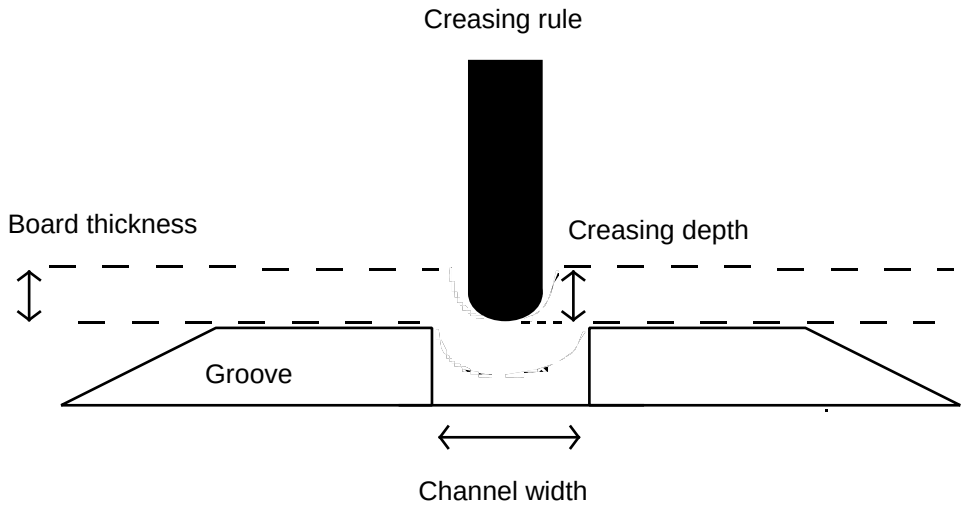
score recommendations



Basis weight gsm	Board thickness µm	Ruler width mm	Channel width ** mm	Creasing depth mm
185	254	0.5	0.9	0.25
185	254	0.7	1.1	0.25
205	305	0.5	1.0	0.30
205	305	0.7	1.2	0.30
230	350	0.7	1.2	0.35
250	390	0.7	1.3	0.39
270	430	0.7	1.4	0.43
300	485	0.7	1.4	0.48
325	540	0.7	1.5	0.54
360	585	0.7	1.6	0.58
390	630	0.7	1.7	0.63

Knife height 23.80mm

** For creases parrallel to fibre orientation
For creases across fiber orientation use channel width +0.1mm

The creasing channel should be deep enough in order to avoid compression of the board in the groove during the creasing process

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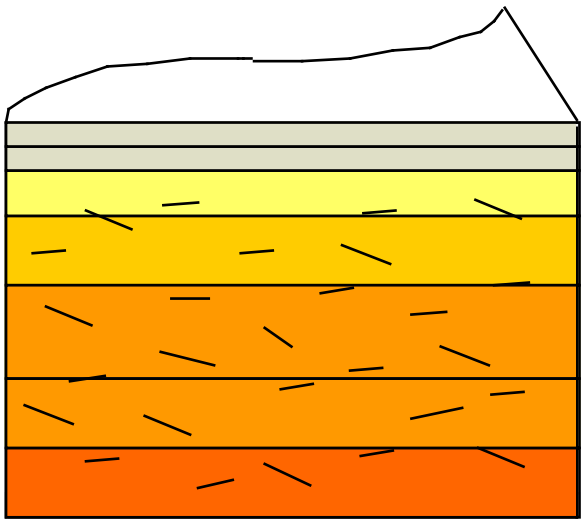

Top Coating	Blade
Base Coating	Blade
Kraft Pulp Layers	Bleached long & short fibre kraft pulp (strength & toughness)
	3 middle layers combine CTMP & long fibre sulphate kraft pulp (optimal bulk)
	Unbleached long & short fibre kraft pulp (strength & toughness)

Product Safety Certificate

We hereby certify that for the purpose to achieve high chemical and micro biological purity, only virgin fibres are used as raw material in Eagle CKB.
This is to certify that the product before conversion complies to the following.

Food contact applications

The pulp and paper manufacturing process conforms with established technology involving the use of generally recognised chemicals.

The **Eagle CKB** complies where applicable and under foreseeable conditions of use with:

- US Federal Regulations, Title 221, Part 176.170 and 176.180, Food and Drugs, Paper and Paperboard Components (April 1996)
- Emfehlungen des Bundesinstitutes für gesunheitlichen Verbraucherschultz und Verterinärmedizin (BGVV) XXXVI, Papiere, Kartons und Pappen für den Lebensmittelkontakt (December 1996)
- Warenwet, VGB 6e Suppl November 1996, Hoofdstuk II Papier en Karton
- The polyethylene used (for poly coated grades only) complies with BgVV, AIII Polyethylene, Stand 1.6.1998 and CFR, Title 21, FDA (1998), Part 177.1520.

This certificate is based upon information given by our suppliers
The certificate is valid until there is a significant change in the manufacturing process, in the product or in legislation.

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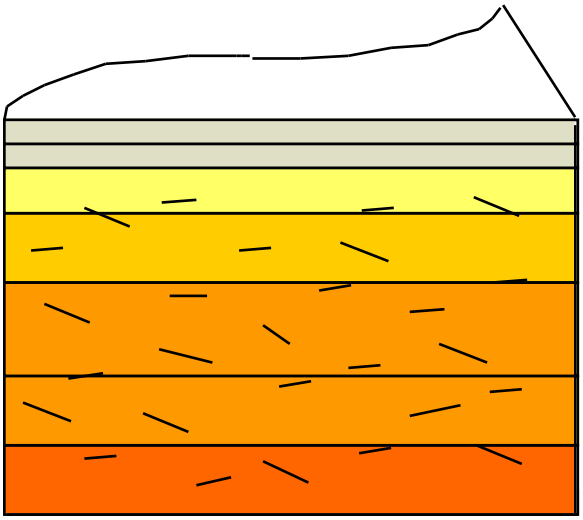

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Product Safety Certificate (cont)

Heavy Metals

Eagle CKB complies with the Packaging Waste Directive (94/62/EC), article 11, and the USA, CONEG (Coalition of Northeastern Govenors), Model toxics legislation packaging material.

Determination of the heavy metals content after wet digestion with HNO_3 has been performed by Stora Enso research with the following results:

Cadmium (Cd)	<1 mg/kg
Mercury (Hg)	<1 mg/kg
Lead (Pb)	<5 mg/kg
Chromium (Cr)	<5 mg/
Chromium (VI)	not detected

No titaniumdioxide is added during production.

Risk substances

During production no additionof formaldehyde is made

The following test results can be reported:

PCB	not detectable
PCP	<0.1 ppb
Dioxin content	<1 ppt TCDD TEQ-Nordic

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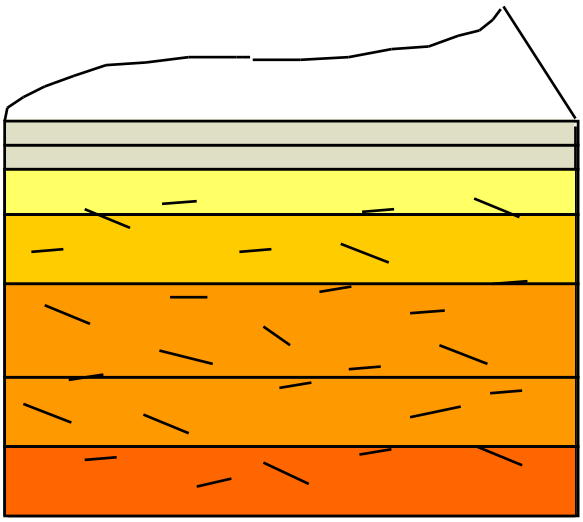

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Product Safety Certificate (cont)

Frozen Food Applications

Eagle CKB is being used successfully for a variety of deep frozen food applications, where the goods are frozen in plastic bags and packed in non PE-coated **Eagle CKB**.

Examples include pizza, hamburger and readymade meals.

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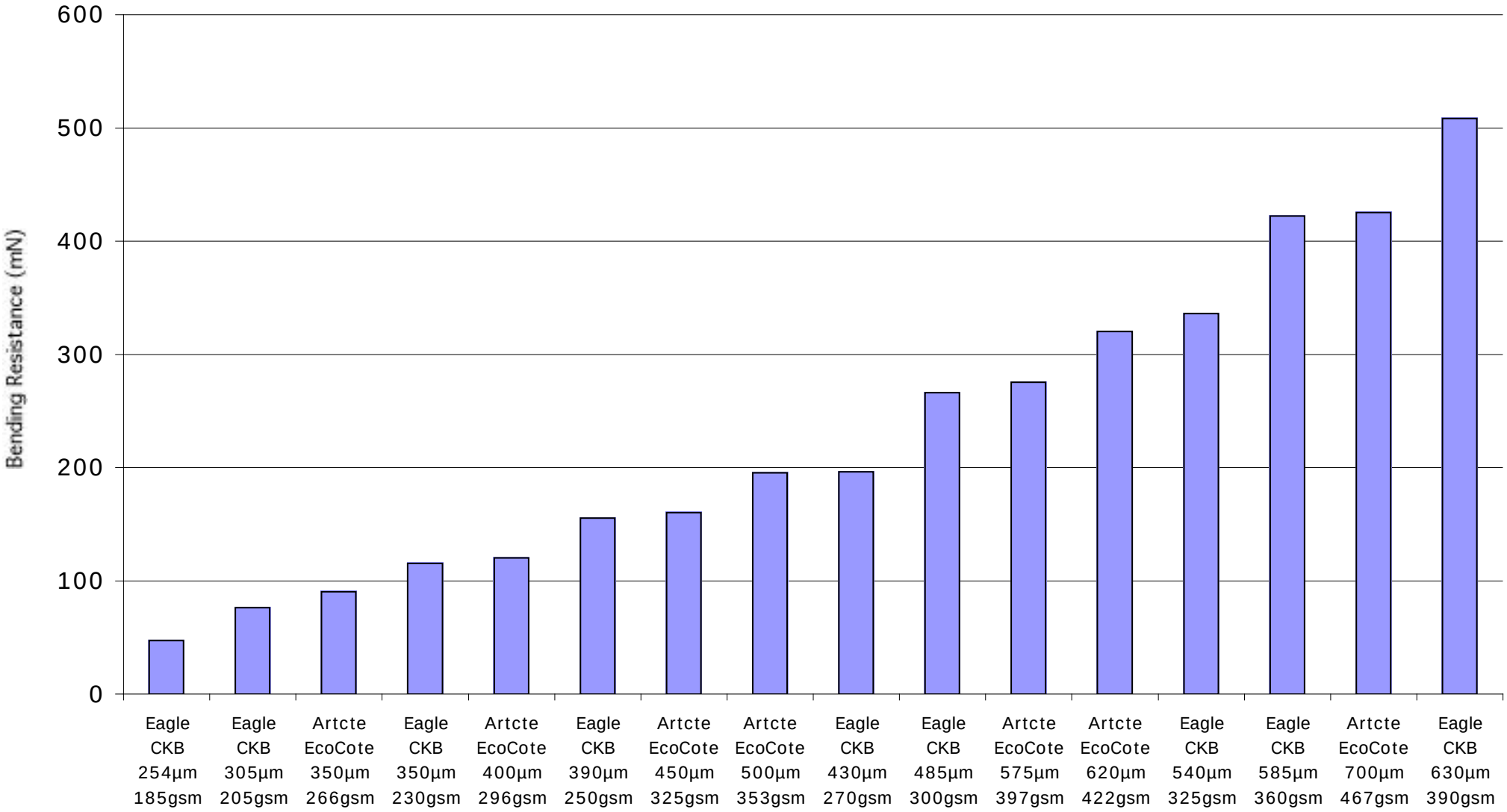
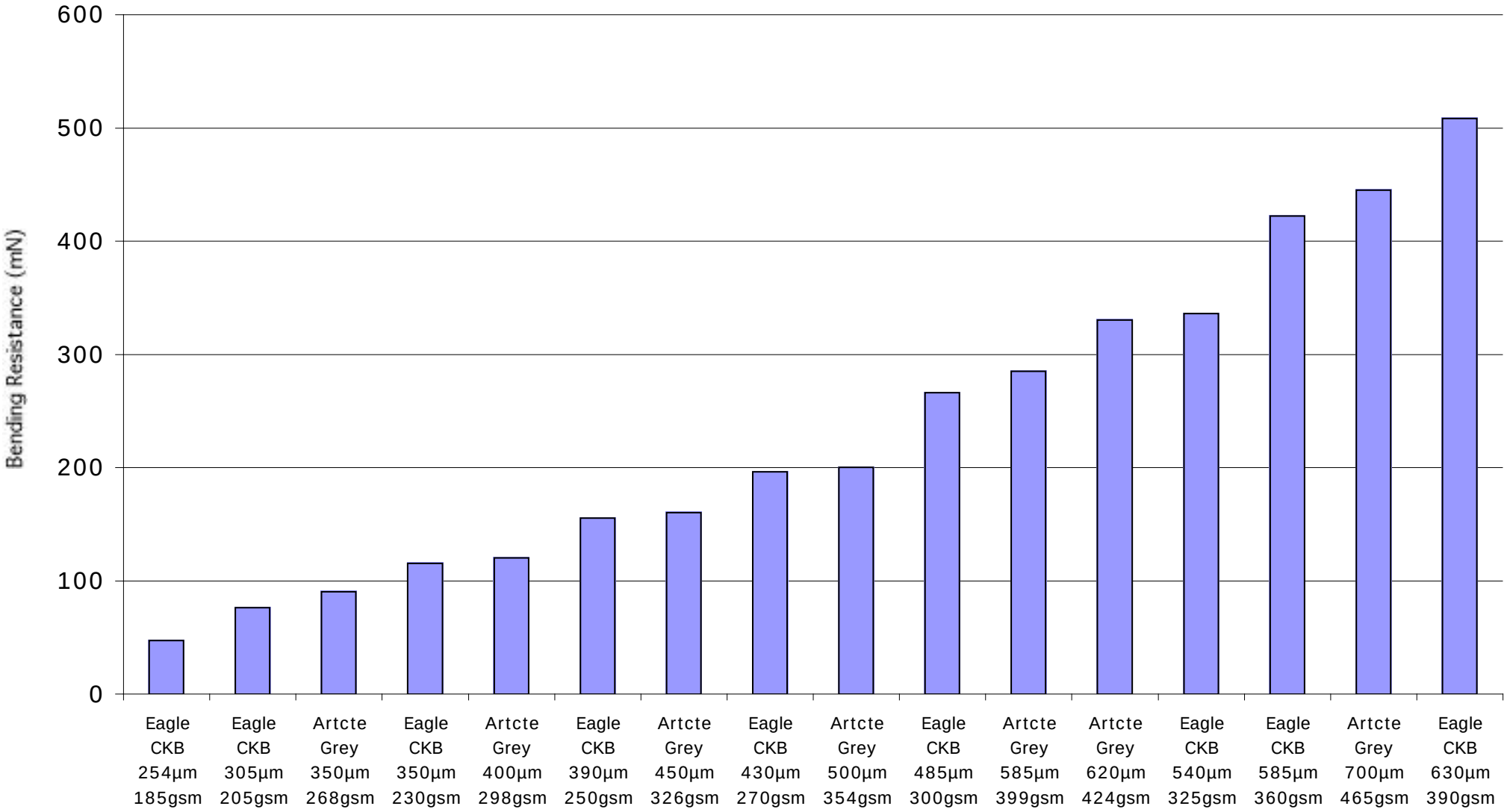
Board CD Stiffness

Eagle CKB vs Artcote Eco-Cote



Board CD Stiffness

Eagle CKB vs Artcote Grey



Board CD Stiffness

Eagle CKB vs Artcote Kraft