

MWare® for Beverage & Food Cups

Packaging uses:

- Hot beverage cups
- Cold beverage cups
- Lidded food cups

WestRock's MWare® paperboard options for beverage and food cups are SBS-based and maintain compliance with strict global food safety standards. Strong and consistent within each roll, roll-to-roll and order-to-order means that MWare paperboards work well in all types of forming equipment for efficient converting and less waste.

MWare offers combinations of paperboard types, fiber mix and functional coatings for optimal product integrity and maximum customer satisfaction. Cups made with MWare paperboard can offer thermal stability, resistance to condensation, and liquid holdout. Seams stay clean and tight and rims are smooth with no cracking or tears. Great for cups intended for use with hot or cold foods or beverages.

MWare Balance

Paperboard and polymer options can include up to 35% post-consumer recycled fiber (PCF) or bio-based coatings, like polylactic acid (PLA), made from renewable resources. MWare Balance offers enhanced environmental performance for food service packaging.

MWare material and coating combinations provide flexible options to help meet all your customer's food service packaging needs.

Options & Features

	MWare		MWare Balance		
	SBS	SBS + LDPE	PCF	PCF + LDPE	SBS + PLA
Board Type					
Solid Bleached Sulfate (SBS)	•	•	•	•	•
Fiber Mix Options					
100% virgin wood fiber	•	•			•
Up to 35% post-consumer fiber (PCF)*			•	•	
Functional Coating Options					
LDPE – Temperatures up to 212° F/100° C		•		•	
PLA – Temperatures up to 212° F/100° C					•
Functional Features					
Water / liquid barrier		•		•	•
Oil / grease barrier		•		•	•
Sustainability Features					
USFDA-compliant PCF			•	•	
Renewable coating					•
Commercially compostable**	•		•		•

* PCF standard is 12%.

**Commercial composting facilities that accept food service packaging currently are limited. Not suitable for home composting.

Contact WestRock for details on additional paperboard and polymer options and combinations.



MWare for beverage and food cups

Solid Bleached Sulfate (SBS)

Grade Availability & Typical Board Properties														Units	Method
UNCOATED ONLY															
BOTTOM STOCK ONLY															
P1S ONLY															
P2S ONLY															
FOR HOT BEVERAGE CUPSONLY															
Caliper	U.S.	0.0070	0.0082	0.0093	0.010	0.0113	0.0124	0.0130	0.0150	0.0165	0.0180	.0180	0.0200	inches	T-411
Thickness	metric	178	208	236	254	287	315	330	381	419	457	457	508	microns	T-411
Nominal Basis Weight	U.S.	90	98	120	129	140	143	150	168	175	185	185	212	lb/3000 sq ft	
	metric	147	160	195	210	228	233	244	274	285	301	301	345	gsm	
Target Weight	U.S.	91	100	118	129	137	145	161	179	190	202	213	227	3Ksqft	T-410
	metric	148	163	192	210	223	236	262	291	309	328	346	370	gsm	
Moisture		6.5	6.5	6.5	6.5	6.5	6.5	6.5	6.5	6.7	6.7	6.5	6.5	percent	T-412
Smoothness															
Side	WS	175	200	130	130	175	280	180	225	260	280	280	270	Sheffield	T-538
	FS	185	215	120	120	160	300	165	190	225	230	190	250	Sheffield	T-538
Stiffness															
Taber 15°	MD	17	20	40	40	60	76	90	120	165	210	217	310	gcm	T-489
	CD	8	9	18	18	31	32	44	60	76	100	100	150	gcm	T-489
Tear															
Elmendorf	MD	190	200	245	245	250	370	320	310	305	370	370	365	g	T-414
	CD	205	235	265	265	310	400	360	365	340	430	430	445	g	T-414
Stretch	CD	4.3	6.0	6.0	6.0	5.6	5.8	5.0	5.0	5.4	5.0	5.0	4.7	percent	T-494
GE Brightness		84	84	84	84	84	84	84	84	84	84	84	84	percent	T-452
Color															
Hunter	L	93.5	93.5	93.5	93.5	93.5	93.5	93.5	93.5	93.5	93.5	91	93.5	L-a-b	T-524
	a	-0.3	-0.3	-0.3	-0.3	-0.3	-0.3	-0.3	-0.3	-0.3	-0.3	-0.3	-0.3	L-a-b	T-524
	b	3.3	3.3	3.3	3.3	3.3	3.3	3.3	3.3	3.3	3.3	3.3	3.3	L-a-b	T-524

Values are for paperboard only. A variety of polymer structures and thickness are available. Stiffness values shown represent measurements at the time of manufacture; field measurements are typically 3-5% higher.

LDPE Poly Configurations Available			
Thickness			
Mils	0.50	0.75	1.00
Microns	12.7	19.1	25.4
Weight			
lbs/Ream	7.2	10.8	14.4
gm/M2	12.0	18.0	24.0

Corona treatment must be requested if you will print on poly. Standard LDPE one side is 0.75 mils gloss. Standard P2S is 0.75 mils matte/0.5 mils gloss. PLA is 1 mil (30 gsm/18 lbs) P1S or P2S.

For more information, please contact your WestRock representative or visit our website at westrock.com

Certifications

Manufacturing

- ISO 9001:2008

Chain of Custody

- SFI* Chain of Custody Certified: BV-SFICOC-US08000163
- PEFC* Chain of Custody Certified: BV-PEFCOC-US08000164

Food Contact

- USFDA 21 CFR § 176.170 – Contact with Aqueous & Fatty Foods*
- USFDA 21 CFR § 176.180 – Components of Paper and Paperboard in Contact with Dry Food*

- USFDA Pasteurized Milk Ordinance, Appendix J, Section C, Process
- ISEGA Certificate of Conformity – BfR XXXVI and EU Regulation (EC) No 1935/2004
- Acceptable for use with Kosher foods

Environmental & Safety

- ISO 14001:2004 – Evadale, Texas mill only
- U.S. California Proposition 65 Compliant
- CONEG Model Heavy Metal and EC/94/62 Article 11 Compliant
- Elemental Chlorine Free (ECF) Bleached Fiber

*Contact WestRock for details of restrictions and/or limitations.

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