

Corrugated mailer

ROLL-END TUCK-FRONT · ONE PIECE · TAPE-FREE

CP-MLR-0806 203 × 152 × 76 mm

CP-MLR-1209 305 × 229 × 102 mm

CP-MLR-1814 457 × 356 × 152 mm

PROJECT	CATALOG NO.	TYPE	DATE
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PRODUCT DESCRIPTION

A one-piece roll-end tuck-front mailer that folds flat and locks without tape or glue. The double-thickness rolled ends give the box its stiffness, so the same board grade carries a heavier load than a plain slotted equivalent, and the tuck front opens cleanly for the customer without a knife.

Construction

- One-piece roll-end tuck-front blank, die-cut and creased flat
- Rolled side walls are double thickness and form integral corner posts
- Front flap tucks into a die-cut lock; no tape, glue or staple
- Makes up in one motion at the bench, no former or jig required

Board and materials

- 32 ECT B-flute kraft at 0806 and 1209; 44 ECT BC-flute at 1814
- Caliper 3.2 mm B-flute, 4.5 mm BC-flute
- Uncoated kraft liner both faces, no wax and no plastic laminate
- Starch adhesive throughout; the whole box is one material stream

Performance

- Burst strength 1,400 kPa
- Maximum gross load 9 kg, rising to 16 kg at the 1814 size
- Rolled ends carry the stack; contents are not part of the load path
- Flat-pack thickness 7 mm, so a bundle of fifty stands 350 mm high

Closure and handling

- Tuck lock closes and reopens without tools
- Opens without a knife, so the contents cannot be cut on unboxing
- Reclosable for a return trip without a second consumable
- Tape is optional and only for tamper evidence — see accessories

Printing

- Water-based flexo direct to uncoated kraft, no barrier coat
- One or two colours outside; interior print available on the same pass
- Print area stops 12 mm short of every crease and the lock die-cut
- Plain kraft is the stock condition and carries no set-up charge

Tolerances

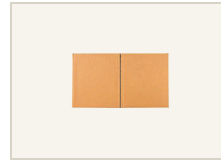
- Internal dimensions ±1.5 mm on the die, all three sizes
- Board caliper ±0.2 mm B-flute, ±0.3 mm BC-flute
- Crease position ±1 mm; a crease outside that will not roll true
- Printed colour to a signed drawdown, not to a screen proof

Applications

- Direct-to-consumer orders of rigid or boxed goods
- Anything that needs a defined cavity rather than a wrap
- Categories with a return leg — the box goes back in itself
- Subscription and repeat despatch, where bench speed compounds



Three-quarter, closed



Top · Face panel, seamed · Flat blank

SPECIFY

Specify by size first. Board grade follows the size: the two smaller boxes run on B-flute, and the 457 mm box steps up to BC to hold its span. A BC build is not offered at 0806 or 1209 because the rolled end would not close cleanly on the heavier caliper.

32 ECT

B-FLUTE

TAPE-FREE CLOSURE

WATER-BASED INK

AT A GLANCE

Format	Roll-end tuck-front, one piece
Sizes	3 – 203 to 457 mm
Board	32 ECT B · 44 ECT BC
Closure	Die-cut tuck lock
Consumables to close	None
Maximum gross load	9 kg · 16 kg at 1814

See also. Every mark this family holds, what each one certifies and the recycled figure by weight are on the features and benefits sheet.

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BUILD THE CODE

SERIES	SIZE	BOARD	PRINT	PACK
CP-MLR	0806 203 × 152 × 76 mm	B 32 ECT B-flute	K Plain kraft	50 Bundle of 50
	1209 305 × 229 × 102 mm	BC 44 ECT BC-flute	1C One colour, outside	PL Pallet, 6 per layer
	1814 457 × 356 × 152 mm	—	2C Two colour, outside	—
			IN Interior print, adds to 1C or 2C	

Example

CP-MLR-1209-B-1C-50

305 × 229 × 102 mm internal, 32 ECT B-flute kraft, one colour water-based flexo outside, bundled fifty.

- BC board is available at 1814 only. B board is available at 0806 and 1209 only.
- IN is a suffix on 1C or 2C, not a print option on its own: CP-MLR-1209-B-1C-IN-50.
- Pallet packing replaces the bundle wrap; the count per pallet is on the acknowledgement.

SIZES, MINIMUM ORDER AND LISTINGS

CODE	INTERNAL SIZE, L × W × D	MINIMUM · LEAD	LISTINGS
CP-MLR-0806	203 × 152 × 76 mm	500 · 3 days	  
CP-MLR-1209	305 × 229 × 102 mm	500 · 3 days	  
CP-MLR-1814	457 × 356 × 152 mm	250 · 5 days	  

Minimum order and lead time are held against each size in the catalogue record and are shown in the table above. Lead time runs from artwork approval, not from order receipt.

ACCESSORIES, ORDERING

CODE	ITEM	MINIMUM	LEAD
CP-TP-G70	Water-activated paper tape	12 rolls	3 days
CP-VF-HC24	Honeycomb wrap, 600 mm roll	6 rolls	4 days
CP-VF-CR18	Crinkle paper fill	4 cartons	2 days
CP-DIV-0909	Cell divider, 9 cell	250	6 days

What each accessory is for, and how it goes in, is on the assembly instructions.

CUSTOM SIZES

Outside the three sizes. A bespoke internal size runs on the same die family at a 5,000 minimum and a 6 week lead, including one sample round. Quote the internal size you need in L × W × D order and in millimetres; a sample blank comes back before the die is cut.

ARTWORK AND PROOFING

REQUIREMENT	
Supply format	Vector PDF or AI, fonts outlined, 1:1 scale
Dieline	Issued by CambiumPak on order; artwork is laid to the issued dieline, not to a redrawn one
Colour	Spot to a signed drawdown. Water-based flexo on uncoated kraft shifts warm; screen proofs are indicative only
Minimum type	6 pt positive, 8 pt reversed out of a solid
Keep-clear	12 mm from every crease and from the lock die-cut
Proof round	One PDF proof, one production sample on request; a sample round adds 3 days to the lead

Artwork received after 14:00 is logged the next working day. The lead times in the table above run from artwork approval, not from the day the file arrives.

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MECHANICAL PERFORMANCE, BY SIZE

	CP-MLR-0806	CP-MLR-1209	CP-MLR-1814
Board grade	32 ECT B-flute	32 ECT B-flute	44 ECT BC-flute
Caliper	3.2 mm	3.2 mm	4.5 mm
Burst strength	1,400 kPa	1,400 kPa	1,400 kPa
Maximum gross load	9 kg	9 kg	16 kg
Top-load compression, made up	1.8 kN	1.6 kN	2.4 kN
Stack height, 48 h at 23 °C / 50 % RH	9 high	8 high	6 high
Free-fall drop, loaded to rating	900 mm	900 mm	1,200 mm
Flat-pack thickness	7 mm	7 mm	7 mm

TEST CONDITIONS

- Compression is measured on a made-up empty box, front flap tucked, platen parallel, 12.7 mm per minute.
- Stack height assumes an evenly loaded box on a flat pallet and no overhang. Overhang of 20 mm removes roughly a third of the stack.
- Drop height is the rated height for the 1814 size under DropRated D3. The two smaller sizes are dropped to the same protocol but are not listed to it.
- All figures are provisional. Nothing on this sheet has been through an independent test house.

RELATIVE CAPACITY

Maximum gross load

CP-MLR-0806		9 kg
CP-MLR-1209		9 kg
CP-MLR-1814		16 kg

Top-load compression, made up

CP-MLR-0806		1.8 kN
CP-MLR-1209		1.6 kN
CP-MLR-1814		2.4 kN

SERVICE AND STORAGE

Service temperature	−20 °C to 60 °C
Storage humidity	40 – 60 % RH
Wet strength	None – keep dry
Shelf life, flat	24 months in original wrap

BOARD SPECIFICATION

Board grade, 0806 / 1209	32 ECT B-flute kraft
Board grade, 1814	44 ECT BC-flute kraft
Burst strength	1,400 kPa
Max gross load	9 kg · 16 kg at 1814
Closure	Tuck lock, no tape

CHOOSING A SIZE BY CONTENT

CONTENT WEIGHT	LONGEST CONTENT DIMENSION	SPECIFY
Up to 4 kg	Under 190 mm	CP-MLR-0806
Up to 9 kg	190 to 290 mm	CP-MLR-1209
Up to 16 kg	290 to 440 mm	CP-MLR-1814
Over 16 kg	Any	CP-CTN-RSC1 or RSC2 — not a mailer

Content dimension allows 12 mm of void fill on the long axis. If the content is closer than that to the internal length, step up a size rather than compressing the fill.

TEST METHODS

FIGURE	METHOD	CONDITIONING
Edge crush, ECT	Board tested on the flute, 25 mm specimen, loaded to failure	23 °C / 50 % RH, 24 h
Burst strength	Diaphragm burst on the combined board, both liners	23 °C / 50 % RH, 24 h
Top-load compression	Made-up empty box, front flap tucked, platen parallel, 12.7 mm per minute	23 °C / 50 % RH, 24 h
Stack height	Dead load held 48 h, evenly loaded box, flat pallet, no overhang	23 °C / 50 % RH
Free-fall drop	Corner, edge and face sequence, loaded to the rated gross weight	23 °C / 50 % RH, 24 h

Methods are stated so the figures can be reproduced, not because the results have been through an independent house. Until they have, every figure on this sheet is provisional.

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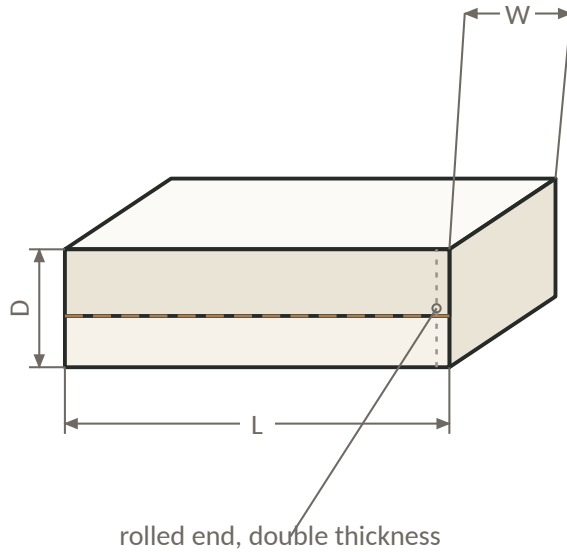
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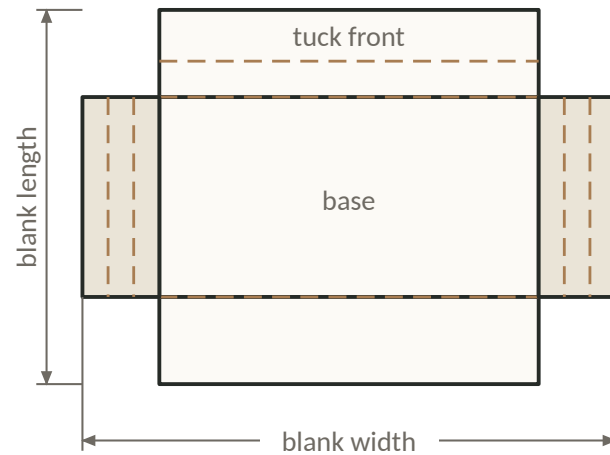
CP-MLR-1814 457 × 356 × 152 mm

MADE UP, INTERNAL

MADE UP



BLANK



solid = cut · dashed = score · $L \times W \times D$ in mm, three sizes — see table

Every dimension on this sheet is internal, in millimetres, in length × width × depth order. Blank size is the flat die-cut sheet before creasing and is given for print planning only.

MEASUREMENTS

Internal, 0806	203 × 152 × 76 mm
Internal, 1209	305 × 229 × 102 mm
Internal, 1814	457 × 356 × 152 mm
Blank size, 1209	610 × 470 mm
Board caliper	3.2 mm B · 4.5 mm BC
Flat-pack thickness	7 mm

FLAT BLANK AND PRINT

Blank size, 0806	430 × 340 mm
Blank size, 1209	610 × 470 mm
Blank size, 1814	890 × 690 mm
Print area inset from crease	12 mm
Lock die-cut, all sizes	38 × 6 mm
Crease radius	1.5 mm B-flute · 2.2 mm BC-flute

PALLETISATION

Pallet	1200 × 1000 mm
Bundles per layer	6
Layers per pallet	8
Pallet height, wrapped	1,450 mm



Three-quarter, closed



Top



Face panel, seamed



Flat blank