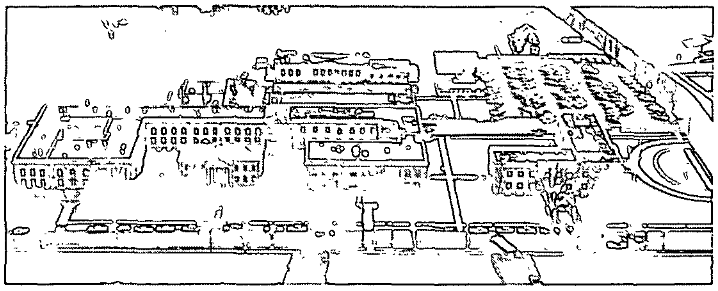

THE INSTITUTE OF PAPER CHEMISTRY, APPLETON, WISCONSIN

CONTINUOUS BASE-LINE STUDY (MODIFIED)
(MILL CORRUGATING MEDIUM DATA FOR APRIL, MAY, JUNE, 1983)

Project 2694-2

Report Fifty-Two

A Progress Report

to

FOURDRINIER KRAFT BOARD GROUP

OF THE

AMERICAN PAPER INSTITUTE

September 1, 1983

THE INSTITUTE OF PAPER CHEMISTRY
Post Office Box 1039
Appleton, Wisconsin 54912
Phone: 414/734-9251
Telex: 469289

September 1, 1983

Project 2694-2

Dear Sir:

We are enclosing a copy of the following report to the Fourdinier Kraft Board Group of the American Paper Institute:

Report Fifty-Two, Project 2694-2, a progress report entitled, "Continuous Baseline Study (Modified) of Mill Corrugating Medium Data for April, May June, 1983" dated September 1, 1983

The code identities for paper machines in your company from which data were submitted for evaluation are given on the inside of the front cover of this report.

Sincerely,

Roger H. Van Eperen
Manager, Materials Testing Laboratory
Paper Materials Division

RHV/kam

Enclosure

Georgia-Pacific Corporation

Your machine is identified in this report by the following code.

Toledo	Machine #2	L1

BASE-LINE
2nd QUARTER, 1983

THE INSTITUTE OF PAPER CHEMISTRY

Appleton, Wisconsin

CONTINUOUS BASE-LINE STUDY (MODIFIED)
(MILL CORRUGATING MEDIUM DATA FOR APRIL, MAY, JUNE, 1983)

Project 2694-2

Report Fifty-Two

A Progress Report

to

FOURDRINIER KRAFT BOARD GROUP

OF THE

AMERICAN PAPER INSTITUTE

September 1, 1983

TABLE OF CONTENTS

THE INSTITUTE OF PAPER CHEMISTRY

Appleton, Wisconsin

CONTINUOUS BASE-LINE STUDY (MODIFIED)
(MILL CORRUGATING MEDIUM DATA FOR APRIL, MAY, JUNE, 1983)

SUMMARY OF 26-LB CORRUGATING MEDIUM DATA
(MAR-JUN, 1983)

Test		MAR Total	MAR Recycled	APR Total	APR Recycled	MAY Total	MAY Recycled	JUN Total	JUN Recycled
Moisture content, %	Max.	9.4	7.4	9.3	7.3	9.4	7.3	9.4	7.4
	Min.	3.4	3.4	3.5	3.5	3.5	3.5	3.6	3.6
	Ave.	6.5(31)	5.8(13)	6.5(30)	5.8(12)	6.5(29)	5.7(13)	6.6(31)	5.7(13)
Adj. basis weight, lb/M sq ft	Max.	27.1	27.1	27.0	27.0	27.1	27.1	27.1	27.1
	Min.	25.4	25.9	25.5	25.9	25.5	26.0	24.9	24.9
	Ave.	26.4(31)	26.6(13)	26.4(30)	26.6(12)	26.4(29)	26.5(13)	26.3(31)	26.5(13)
Caliper, pt.	Max.	12.4	12.4	12.0	12.0	11.5	11.5	11.7	11.7
	Min.	7.9	7.9	7.8	7.8	7.9	7.9	8.2	8.2
	Ave.	9.6(28)	9.6(12)	9.6(27)	9.6(11)	9.6(26)	9.5(12)	9.6(28)	9.5(12)
Concora, lb	Max.	69.0	68.5	68.5	68.5	69.0	67.9	71.0	68.3
	Min.	54.0	54.0	52.8	52.8	52.2	52.2	51.3	51.3
	Ave.	60.4(31)	60.4(13)	60.3(30)	60.5(12)	60.2(29)	59.9(13)	60.8(31)	59.9(13)
CD Ring Crush, lb	Max.	38.0	37.0	35.0	35.0	34.0	34.0	34.0	34.0
	Min.	22.0	22.0	21.0	21.0	22.0	22.0	23.3	23.3
	Ave.	29.0(17)	28.2(8)	28.2(16)	26.8(7)	28.1(17)	26.9(8)	28.0(16)	26.9(7)

Max. and Min. values are current machine averages.
Ave. value is current F.K.B.G. average, number of machines is indicated in parentheses.

INTRODUCTION

The continuous base-line study (modified) is a compilation of monthly averages of mill test data obtained routinely on 26-lb corrugating medium manufactured in the member mills of F.K.B.G. Mill data are included for moisture content, basis weight, caliper, Concora, and C.D. Ring Crush made on the production of individual machines which produced at least 500 tons of this grade weight during a given month.

PRESENTATION OF DATA

For the 26-lb grade weight of corrugating medium referred to earlier, data on conditioning and testing environments, mill test averages for moisture content, adjusted basis weight, caliper, Concora, and C.D. Ring Crush results are compiled in the following tables.

Table Number	Description
I-II-III-IV	Mill Test Averages on 26-Lb Corrugating Medium
V	Data on Conditioning and Testing Environments

The procedure used in calculating cumulative machine averages, machine factors, machine indexes, and F.K.B.G. indexes are described in the Appendix.

It should be explained that the number of machines for which data are compiled in each table for a specified month varies for these reasons: a machine must have (a) produced at least 500 tons of 26-lb corrugating medium during the specified month, or (b) produced 500 tons of 26-lb corrugating medium during any one or more of the 12 months prior to the specified month (so that a cumulative average is available), to be included in a given table.

TABLE I

AVERAGES OF ROUTINE MILL QUALITY CONTROL DATA FOR 26 LB. CORRUGATING MEDIUM

APRIL, 1983

	MOISTURE CONTENT, PERCENT				ADJ. BASIS WT.,*A LB./M SQ. FT.				CALIPER, PT.				CONCORA TEST LB.			
	MACHINE DATA				MACHINE DATA				MACHINE DATA				MACHINE DATA			
CODE *E	CUR. AV.	CUM. AV.	FACT. *B	IND. *C	CUR. AV.	CUM. AV.	FACT. *B	IND. *C	CUR. AV.	CUM. AV.	FACT. *B	IND. *C	CUR. AV.	CUM. AV.	FACT. *B	IND. *C
A1	5.5	5.7	96.5	84.6	26.5	26.3	100.8	100.4	9.1	8.9	102.2	94.8	64.7	63.4	102.0	105.1
B1	7.5	7.4	101.4	115.4	26.2	26.2	100.0	99.2	10.2	10.5	97.1	106.2	56.0	57.2	97.9	91.8
H1	7.5	7.2	101.4	112.3	26.5	26.4	100.4	100.4	9.8	9.6	102.1	102.1	62.0	62.0	100.0	101.6
K1(R)	7.0	6.9	101.4	107.7	26.3	26.4	99.6	99.6	9.4	9.3	101.1	97.9	68.5	58.9	99.4	112.3
L1(R)	7.3	7.1	102.8	112.3	25.9	26.3	98.5	98.1	12.0	11.5	104.3	125.0	60.3	61.7	97.7	98.3
U1	6.8	6.8	100.0	104.6	26.3	26.3	100.0	99.6	9.0	8.8	102.3	93.8	58.3	60.8	95.9	95.6
V1(R)	6.5	6.5	100.0	100.0	26.4	26.4	100.0	100.0	9.6	9.6	100.0	100.0	60.5	60.6	99.8	99.2
W1	5.8	5.8	100.0	89.2	26.5	26.5	100.0	100.4	9.7	10.1	96.0	101.0	60.0	61.4	97.7	98.4
X1		7.4				26.3								57.3		
Z1	6.3	6.7	94.0	96.9	26.5	26.4	100.4	100.4	9.3	9.8	94.9	96.9	54.0	61.2	88.2	83.5
C2	6.5	7.0	92.8	100.0	26.5	26.3	100.8	100.4	9.4	9.0	104.4	97.9	68.0	68.8	98.8	111.5
D2	8.0	8.2	97.6	123.1	25.9	26.1	99.2	98.1	10.3	10.2	101.0	107.3	62.2	63.1	98.6	102.0
F2(R)	5.3	5.3	100.0	81.5	26.8	26.7	100.4	101.5	10.6	9.8	108.2	110.4	60.4	59.6	101.3	99.0
G2	8.2	8.2	100.0	126.2	26.1	26.1	100.0	98.9	8.3	9.1	91.2	86.4	60.0	60.8	98.7	93.4
O2(R)	4.5	4.4	102.3	69.2	26.8	26.9	99.6	101.5	9.6	9.6	100.0	100.0	60.0	59.2	101.4	93.4
Q2		7.1				26.1				8.9				69.4		
A3(R)	6.4	6.5	98.5	98.5	26.5	26.4	100.4	100.4	10.1	10.1	100.0	105.2	60.3	60.6	99.5	98.8
B3	7.4	7.6	97.4	113.8	26.3	26.2	100.4	99.6		10.4			58.0	58.0	100.0	95.1
E3(R)	5.6	5.7	98.2	86.2	26.5	26.4	100.4	100.4	9.5	9.5	100.0	99.0	63.8	64.8	98.4	104.6
Q3		7.2				26.2				8.9				65.2		
R3(R)	6.0	6.2	96.8	92.3	26.5	26.6	99.6	100.4	9.0	9.0	100.0	93.8	62.0	62.2	99.7	101.6
V3(R)	6.0	6.0	100.0	92.3	26.6	26.9	98.9	100.8	9.0	9.0	100.0	93.8	52.8	52.2	101.1	86.6
W3	6.9	7.4	93.2	106.2	26.6	26.4	100.8	100.8		10.6			59.0	58.8	100.3	96.7
A4	7.2	7.2	100.0	110.8	26.4	26.4	100.0	100.0	8.9	8.9	100.0	92.7	59.2	60.8	97.4	97.0
C4	7.3	7.2	101.4	112.3	26.2	26.2	100.0	99.2	10.2	10.1	101.0	106.2	56.0	57.4	97.6	91.8
D4	6.6	6.8	97.0	101.5	26.4	26.2	100.8	100.0	10.1	9.9	102.0	105.2	58.0	57.1	101.6	95.1
E4(R)	4.3	4.5	95.6	66.2	26.9	27.1	99.3	101.9	9.0	9.0	100.0	93.8	53.7	53.1	101.1	88.0
F4	7.4	7.4	100.0	113.8	26.4	26.3	100.4	100.0	10.4	10.4	100.0	108.3	59.8	60.5	98.8	98.0
G4	9.3	9.4	98.9	143.1	25.5	25.4	100.4	96.6	9.7	9.7	100.0	101.0	65.0	65.0	100.0	105.6
H4	7.0	7.0	100.0	107.7	26.2	26.2	100.0	99.2	8.9	9.1	97.8	92.7	61.0	60.8	100.3	100.0
I4(R)	7.1	7.2	98.6	109.2	26.4	26.2	100.3	100.0					62.0	61.9	100.2	101.6
L4(R)		5.4				26.3				9.2				56.4		
Q4	5.5	5.6	98.2	84.6	26.0	26.0	100.0	98.5	10.0	9.8	102.0	104.2	62.0	63.5	97.6	101.6
S4(R)	3.5	3.6	97.2	53.8	27.0	27.1	99.6	102.3	7.8	8.0	97.5	81.2	61.6	61.1	100.8	101.0

FKBG DATA

	TOTAL	RECYCLED	TOTAL	RECYCLED	TOTAL	RECYCLED	TOTAL	RECYCLED
CUR. AV	6.5	5.8	26.4	26.6	9.6	9.6	60.3	60.5
CUM. AV	6.5	5.7	26.4	26.6	9.6	9.4	61.0	60.0
IND. *D	100.0	101.8	100.0	100.0	100.0	102.1	98.8	100.8

(*)-- NOTES A, B, C, D, AND E, ARE GIVEN IN APPENDIX.

TABLE II

AVERAGES OF ROUTINE MILL QUALITY CONTROL DATA FOR 26 LB. CORRUGATING MEDIUM

MAY, 1983

CODE	MOISTURE CONTENT, PERCENT — MACHINE DATA				ADJ. BASIS WT.,*A LB./M SQ. FT. — MACHINE DATA				CALIPER, PT. — MACHINE DATA				CONCORA TEST LB. — MACHINE DATA			
*E	CUR. AV.	CUM. AV.	FACT. *B	IND. *C	CUR. AV.	CUM. AV.	FACT. *B	IND. *C	CUR. AV.	CUM. AV.	FACT. *B	IND. *C	CUR. AV.	CUM. AV.	FACT. *B	IND. *C
A1		5.7				26.3				8.9				63.5		
B1	7.4	7.4	100.0	113.8	26.3	26.2	100.4	99.6	10.1	10.5	96.2	105.2	56.0	57.0	98.2	92.0
H1	7.4	7.2	102.8	113.8	26.3	26.4	99.6	99.6	10.2	9.7	105.2	106.2	61.0	62.0	98.4	100.2
K1(R)	7.0	6.9	101.4	107.7	26.3	26.4	99.6	99.6	9.5	9.3	102.2	99.0	67.9	68.9	98.5	111.5
L1(R)	7.2	7.1	101.4	110.8	26.0	26.2	99.2	98.5	11.5	11.5	99.1	119.8	61.3	61.6	99.5	100.6
U1	6.7	6.8	98.5	103.1	26.4	26.3	100.4	100.0	9.3	8.8	105.7	96.9	60.6	60.5	100.2	99.5
V1(R)	5.8	6.5	89.2	89.2	26.5	26.4	100.4	100.4	9.8	9.6	102.1	102.1	60.3	60.6	99.5	99.0
W1	6.0	5.8	103.4	92.3	26.3	26.4	99.6	99.6	9.7	10.0	97.0	101.0	59.0	61.2	96.4	95.9
X1		7.4				26.5								58.5		
Z1	6.3	6.6	95.4	96.9	26.5	26.4	100.4	100.4	9.3	9.8	94.9	96.9	54.0	60.4	89.4	88.7
C2	5.9	6.9	85.5	90.8	26.8	26.4	101.5	101.5	9.4	9.1	103.3	97.9	69.0	68.8	100.3	113.3
D2	9.4	8.2	114.6	144.6	25.7	26.1	98.5	97.3	10.2	10.2	100.0	106.2	63.0	63.1	99.8	103.4
F2(R)	5.5	5.2	105.8	84.6	26.9	26.7	100.7	101.9	10.3	9.8	105.1	107.3	59.1	59.7	99.0	97.0
G2	8.4	8.2	102.4	129.2	25.9	26.1	99.2	98.1	8.6	9.0	95.6	89.6	61.0	60.7	100.5	100.2
O2(R)	4.1	4.4	93.2	63.1	27.0	26.9	100.4	102.3	9.3	9.5	97.9	96.9	59.7	59.2	100.8	98.0
Q2		7.1				26.1				8.9				69.4		
A3(R)	5.8	6.5	89.2	89.2	26.6	26.4	100.3	100.8	10.1	10.1	100.0	105.2	60.1	60.5	99.3	93.7
B3	7.5	7.5	100.0	115.4	26.4	26.2	100.8	100.0					58.0	58.2	99.6	95.2
E3(R)	5.6	5.7	98.2	86.2	26.5	26.4	100.4	100.4	9.5	9.5	100.0	99.0	64.3	64.7	99.4	105.6
O3		7.0				26.2				8.8				65.5		
R3(R)	6.2	6.2	100.0	95.4	26.5	26.6	99.6	100.4	9.1	9.0	101.1	94.8	62.0	62.2	99.7	101.8
V3(R)	6.0	6.0	100.0	92.3	26.7	26.9	99.2	101.1	9.0	9.0	100.0	93.8	52.2	52.4	99.6	85.7
W3	7.2	7.3	98.6	110.8	26.5	26.5	100.0	100.4					60.0	59.2	101.4	98.5
A4	7.0	7.2	97.2	107.7	26.7	26.4	101.1	101.1	8.9	8.9	100.0	92.7	65.2	60.8	107.2	107.1
C4	7.3	7.2	101.4	112.3	26.1	26.2	99.6	98.9	10.2	10.1	101.0	106.2	56.0	57.3	97.7	92.0
D4	6.7	6.8	98.5	103.1	26.3	26.2	100.4	99.6	10.0	10.0	100.0	104.2	58.0	57.1	101.6	95.2
E4(R)	4.5	4.4	102.3	69.2	26.7	27.1	98.5	101.1	9.0	9.0	100.0	93.8	52.3	53.2	98.3	85.9
F4	7.4	7.4	100.0	113.8	26.3	26.3	100.0	99.6	10.5	10.4	101.0	109.4	59.7	60.4	98.8	98.0
G4	9.2	9.4	97.9	141.5	25.5	25.5	100.0	96.6	9.6	9.7	99.0	100.0	66.4	65.1	102.0	109.0
H4		7.0				26.3				9.0				60.2		
I4(R)	7.3	7.2	101.4	112.3	26.1	26.3	99.2	98.9					62.0	61.8	100.3	101.8
L4(R)	5.7	5.4	105.6	87.7	26.1	26.3	99.2	98.9	8.9	9.2	96.7	92.7	57.0	56.4	101.1	93.6
Q4	5.4	5.5	98.2	83.1	26.2	26.0	100.8	99.2	10.1	9.8	103.1	105.2	62.0	63.2	98.1	101.8
S4(R)	3.5	3.6	97.2	53.8	27.1	27.1	100.0	102.6	7.9	8.0	98.8	82.3	60.2	61.2	98.4	98.8

FKBG DATA

	TOTAL	RECYCLED	TOTAL	RECYCLED	TOTAL	RECYCLED	TOTAL	RECYCLED
CUR. AV	6.5	5.7	26.4	26.5	9.6	9.5	60.2	59.9
CUM. AV	6.5	5.7	26.4	26.6	9.6	9.4	60.9	60.0
IND. *D	100.0	100.0	100.0	99.6	100.0	101.1	98.8	99.8

(*)-- NOTES A, B, C, D, AND E, ARE GIVEN IN APPENDIX.

TABLE III

AVERAGES OF ROUTINE MILL QUALITY CONTROL DATA FOR 26 LB. CORRUGATING MEDIUM

JUNE, 1983

	MOISTURE CONTENT, PERCENT				ADJ. BASIS WT.,*A LB./M SQ. FT.				CALIPER, PT.				CONCORA TEST LB.			
	MACHINE DATA				MACHINE DATA				MACHINE DATA				MACHINE DATA			
CODE *E	CUR. AV.	CUM. AV.	FACT. *B	IND. *C	CUR. AV.	CUM. AV.	FACT. *B	IND. *C	CUR. AV.	CUM. AV.	FACT. *B	IND. *C	CUR. AV.	CUM. AV.	FACT. *B	IND. *C
A1		5.7				26.3				8.9				63.6		
B1	7.5	7.4	101.4	115.4	26.3	26.2	100.4	99.6	10.0	10.5	95.2	104.2	57.0	56.8	100.4	93.8
H1	7.4	7.3	101.4	113.8	26.3	26.4	99.6	99.6	10.2	9.9	103.0	106.2	61.0	61.7	98.9	100.3
K1(R)	7.0	6.9	101.4	107.7	26.4	26.4	100.0	100.0	9.6	9.3	103.2	100.0	68.3	68.7	99.4	112.3
L1(R)	7.2	7.1	101.4	110.8	26.0	26.2	99.2	98.5	11.7	11.6	100.9	121.9	61.7	51.5	100.3	101.5
U1	6.7	6.8	98.5	103.1	26.7	26.3	101.5	101.1	9.1	8.8	103.4	94.8	63.1	60.4	104.5	103.8
V1(R)	5.8	6.4	90.6	89.2	26.5	26.4	100.4	100.4	9.7	9.6	101.0	101.0	60.6	60.6	100.0	99.7
W1	6.1	5.8	105.2	93.8	26.5	26.4	100.4	100.4	9.6	10.0	96.0	100.0	60.0	61.0	98.4	98.7
X1		7.4				26.7								58.0		
Z1	6.4	6.6	97.0	98.5	26.6	26.3	101.1	100.8	9.4	9.7	96.9	97.9	53.0	59.8	88.6	87.2
C2	5.9	6.8	86.8	90.8	26.3	26.4	99.6	99.6	9.4	9.2	102.2	97.9	69.0	68.6	100.6	113.5
D2	8.5	8.3	102.4	130.8	25.9	26.0	99.6	98.1	10.2	10.2	100.0	106.2	64.6	63.1	102.4	106.2
F2(R)	5.4	5.2	103.8	83.1	26.9	26.8	100.4	101.9	10.0	9.8	102.0	104.2	59.3	59.6	99.5	97.5
G2	8.3	8.2	101.2	127.7	26.0	26.1	99.6	98.5	8.8	9.0	97.8	91.7	60.0	60.6	99.0	98.7
O2(R)	4.3	4.4	97.7	66.2	27.1	26.9	100.7	102.6	9.8	9.5	103.2	102.1	59.0	59.3	99.5	97.0
Q2	6.7	7.1	94.4	103.1	26.1	26.1	100.0	98.9	9.0	8.9	101.1	93.8	71.0	70.0	101.4	116.8
A3(R)	5.8	6.4	90.6	89.2	26.6	26.4	100.8	100.8	10.2	10.1	101.0	106.2	59.9	60.4	99.2	98.5
B3	7.8	7.5	104.0	120.0	26.3	26.3	100.0	99.6					57.0	57.7	98.8	93.8
E3(R)	5.7	5.7	100.0	87.7	26.5	26.5	100.0	100.4	9.5	9.5	100.0	99.0	64.0	64.7	98.9	105.3
O3	6.8	7.2	94.4	104.6	26.1	26.2	99.6	98.9	8.9	8.8	101.1	92.7	68.0	66.0	103.0	111.8
R3(R)	6.0	6.2	96.8	92.3	26.6	26.6	100.0	100.8	9.0	9.0	100.0	93.8	65.0	62.2	104.5	106.9
V3(R)	6.0	6.0	100.0	92.3	26.8	26.9	99.6	101.5	9.0	9.0	100.0	93.8	52.5	52.4	100.2	86.3
W3	8.0	7.3	109.6	123.1	26.3	26.5	99.2	99.6					58.0	59.0	98.3	95.4
A4	7.0	7.2	97.2	107.7	26.8	26.4	101.5	101.5	9.1	8.9	102.2	94.8	64.6	61.0	105.9	106.2
C4	7.3	7.2	101.4	112.3	26.2	26.2	100.0	99.2	9.9	10.2	97.0	103.1	57.0	57.2	99.6	93.8
D4	6.8	6.8	100.0	104.6	26.3	26.2	100.4	99.6	10.2	10.0	102.0	106.2	58.0	57.1	101.6	95.6
E4(R)	4.3	4.4	97.7	66.2	26.8	27.1	98.9	101.5	9.0	9.0	100.0	93.8	51.3	53.2	96.4	84.4
F4	7.4	7.4	100.0	113.8	26.1	26.3	99.2	98.9	10.6	10.4	101.9	110.4	59.6	60.3	98.8	98.0
G4	9.4	9.4	100.0	144.6	25.5	25.5	100.0	96.6	9.6	9.7	99.0	100.0	64.4	65.2	98.8	105.9
H4		6.9				26.3				9.1				60.0		
I4(R)	7.4	7.2	102.8	113.8	26.0	26.2	99.2	98.5					62.2	61.7	100.8	102.3
L4(R)	6.2	5.5	112.7	95.4	24.9	26.3	94.7	94.3	8.6	9.2	93.5	89.6	55.0	56.5	97.3	90.5
Q4	5.5	5.5	100.0	84.6	26.1	26.0	100.4	98.9	10.0	9.8	102.0	104.2	62.0	62.9	98.6	102.0
S4(R)	3.6	3.6	100.0	55.4	27.1	27.1	100.0	102.6	8.2	8.0	102.5	85.4	60.4	61.3	98.5	99.3

FKBG DATA

	TOTAL	RECYCLED	TOTAL	RECYCLED	TOTAL	RECYCLED	TOTAL	RECYCLED
CUR. AV	6.6	5.7	26.3	26.5	9.6	9.5	60.8	59.9
CUM. AV	6.5	5.7	26.4	26.6	9.6	9.5	60.8	60.0
IND. *D	101.5	100.0	99.6	99.6	100.0	100.0	100.0	99.8

(*)-- NOTES A, B, C, D, AND E, ARE GIVEN IN APPENDIX.

TABLE IV

AVERAGES OF ROUTINE MILL QUALITY CONTROL DATA FOR 26 LB. CORRUGATING MEDIUM

RING COMPRESSION, LBS.

	APRIL, 1983				MAY, 1983				JUNE, 1983			
	MACHINE DATA				MACHINE DATA				MACHINE DATA			
	CUR. AV.	CUM. AV.	FACT. *B	IND. *C	CUR. AV.	CUM. AV.	FACT. *B	IND. *C	CUR. AV.	CUM. AV.	FACT. *B	IND. *C
A1												
B1	27.0	26.3	102.7	93.1	28.0	26.5	105.7	97.2	28.0	26.8	104.5	97.6
H1	34.0	38.0	89.5	117.2	31.0	36.0	86.1	107.6	32.0	34.3	93.3	111.5
K1(R)												
L1(R)	21.0	22.0	95.4	72.4	23.0	21.5	107.0	79.9	27.0	22.0	122.7	94.1
U1	26.1	26.1	100.0	90.0	28.1	26.1	107.7	97.6	25.8	26.5	97.4	89.9
V1(R)												
W1	29.0	29.0	100.0	100.0	28.0	29.0	96.6	97.2	27.0	28.8	93.8	94.1
X1												
Z1												
C2												
D2												
F2(R)	23.5	24.5	95.9	81.0	22.6	24.0	94.2	78.5	23.3	23.5	99.1	81.2
G2												
Q2(R)	23.6	24.9	94.8	81.4	22.0	24.2	90.9	76.4	23.5	23.5	100.0	81.9
J2												
A3(R)												
B3	31.0	30.0	103.3	106.9	32.0	30.5	104.9	111.1	31.0	31.0	100.0	108.0
E3(R)	31.6	32.1	98.4	109.0	29.9	32.0	93.4	103.8	29.6	31.5	93.7	103.1
Q3												
R3(R)	35.0	36.0	97.2	120.7	33.0	35.8	92.2	114.6		35.2		
V3(R)	24.0	26.0	92.3	82.8	23.0	25.5	90.2	79.9	24.0	25.0	96.0	83.6
W3	28.0	28.0	100.0	96.6	28.0	28.0	100.0	97.2	28.0	28.0	100.0	97.6
A4												
C4	26.0	26.0	100.0	89.6	27.0	26.0	103.8	93.8	27.0	26.2	103.0	94.1
D4	29.0	27.7	104.7	100.0	28.6	28.0	102.1	99.3	27.0	28.1	96.1	94.1
E4(R)	29.0	29.0	100.0	100.0	28.0	29.0	96.6	97.2	27.0	28.8	93.8	94.1
F4												
G4												
H4												
I4(R)												
L4(R)		36.0			34.0	36.0	94.4	118.0	34.0	35.0	97.1	118.5
Q4	33.0	32.3	102.2	113.8	32.0	32.5	98.5	111.1	33.0	32.4	101.8	115.0
S4(R)												

FKBG DATA

	TOTAL	RECYCLED	TOTAL	RECYCLED	TOTAL	RECYCLED
CUR. AV	28.2	26.8	28.1	26.9	28.0	26.9
CUM. AV	29.0	30.3	28.8	29.4	28.7	28.9
IND. *D	97.2	83.4	97.6	91.5	97.6	93.1

(*)-- NOTES A, B, C, D, AND E, ARE GIVEN IN APPENDIX.

TABLE V

DATA ON CONDITIONING AND TESTING ENVIRONMENTS

APRIL, MAY, JUNE, 1983

	Conditioning Environment				Testing Environment
	Are Quality Samples	Procedure			Are Quality Samples Tested
Code	Conditioned Before Testing?	Time	Temp., °F	RH, %	Under Controlled Conditions of Temperature & Humidity?
A1	No	--	--	--	No
B1	No	--	--	--	No
H1	No	--	--	--	Yes: 72 ± 2°F; 50 ± 1% RH
K1	No	--	--	--	Yes: 70 ± 1°F; 50 ± 1% RH
L1	No	--	--	--	Yes: 70 ± 2°F; 50 ± 2% RH
U1	Yes	20 min	--	--	Yes: 72 ± 2°F; 50 ± 2% RH
V1	No	--	--	--	Yes: 72 ± 4°F; 50 ± 5% RH
W1	No	--	--	--	Yes: 73 ± 1°F; 50 ± 2% RH
X1	No data was submitted for this quarter				
Z1	No	--	--	--	Yes
C2	No	--	--	--	Yes: 73 ± 2°F; 50 ± 2% RH
D2	No	--	--	--	Yes: 72 ± 3°F; 50 ± 2% RH
F2	No	--	--	--	Yes: 70 ± 1°F; 50 ± 2% RH
G2	No	--	--	--	Yes: 70 ± 2°F; 50 ± 10% RH
O2	No	--	--	--	Yes: 70 ± 1°F; 50 ± 2% RH
Q2	No	--	--	--	Yes: 73 ± 2°F; 50 ± 2% RH
A3	No	--	--	--	Yes: 72 ± 4°F; 50 ± 5% RH
B3	No	--	--	--	Yes: 73 ± 2°F; 50 ± 2% RH
E3	No	--	--	--	Yes: 72 ± 2°F; 50 ± 3% RH
O3	No	--	--	--	Yes: 73 ± 2°F; 50 ± 2% RH
R3	No	--	--	--	No
V3	No	--	--	--	Yes: 73 ± 3°F; 50 ± 2% RH
W3	No	--	--	--	Yes: 73 ± 2°F; 50 ± 2% RH
A4	No	--	--	--	No
C4	No	--	--	--	No
D4	No	--	--	--	No
E4	No	--	--	--	Yes: 73 ± 3°F; 50 ± 2% RH
F4	No	--	--	--	Yes: 70 ± 2°F; 50 ± 2% RH
G4	No	--	--	--	Yes: 70 ± 3°F; 50 ± 3% RH
H4	No	--	--	--	No
I4	No	--	--	--	Yes: 72 ± 2°F; 50 ± 5% RH
L4	Yes	20 min	--	--	Yes: 72 ± 3-5°F; 50 ± 2% RH
Q4	No	--	--	--	Yes: 73 ± 2°F; 50 ± 2% RH
S4	No	--	--	--	Yes: 73 ± 2°F; 50 ± 5% RH

THE INSTITUTE OF PAPER CHEMISTRY

Roger H. Van Eperen
Roger H. Van Eperen
Research Associate
Paper Materials Division

Approved by

Gary A. Baum
Gary A. Baum
Director
Paper Materials Division

APPENDIX

NOTES A, B, C, D, AND E, USED IN TABULATIONS OF MILL DATA

Notes A, B, C, D, and E, used in the tables of mill data are given below; these notes define the procedure used in calculating adjusted basis weight, machine factor, machine index, and F.K.B.G. index. It should be stressed that each formula is applicable only to a specific physical property of corrugating medium.

Note A: Adjusted basis weight (ABW) = reported weight (RBW) adjusted to moisture content of 7.8%:

$$\text{ABW} = \text{RBW}\left[\frac{(100 - \text{reported moisture content, \%})}{(100 - 7.8)}\right]$$

Note B: $\text{Machine factor (\%)} = \left[\frac{\text{Current machine average}}{\text{Cumulative machine average}}\right] \cdot 100$ <u>where</u>

$$\text{Cumulative machine average} = \sum \frac{\text{CMA's}^{a}\text{ for previous 12 months excluding CMA for current month}}{12}$$

Note C: $\text{Machine index (\%)} = \left[\frac{\text{Current machine average}}{\text{Cumulative F.K.B.G. total average}}\right] \cdot 100$ <u>where</u>

$$\text{Cumulative F.K.B.G. average} = \sum \frac{\text{CFKBGA's}^{b}\text{ for previous 12 months excluding CFKBGA for current month}}{12}$$

Note D: $\text{F.K.B.G. index (\%)} = \left[\frac{\text{Current F.K.B.G. average}}{\text{Cumulative F.K.B.G. average}}\right] \cdot 100$ <u>where</u>

$$\text{Current F.K.B.G. average} = \sum \frac{\text{CMA's}^{a}\text{ for current month for all machines}}{\text{Number of machines}}$$

Note E: (R) - Indicates a medium manufactured from recylced fibers.

[a] CMA = current machine average for a specific physical property of 26-lb corrugating medium obtained during a given month on a specific machine.

[b] CFKBGA = current F.K.B.G. average for a specific physical property of 26-lb corrugating medium obtained during a given month.