

THE INSTITUTE OF PAPER CHEMISTRY

Appleton, Wisconsin

SUPPLEMENTARY REPORT ON CALIPER OF SINGLE-FACED BOARD

Project 1108-17

Report 84

A Progress Report

to

FOURDRINIER KRAFT BOARD INSTITUTE, INC.

February 1, 1961

THE INSTITUTE OF PAPER CHEMISTRY

Appleton, Wisconsin

This report is supplementary to Progress Report 83 of the baseline study on corrugating medium entitled, "Continuous evaluation of corrugating medium" which provides a program whereby participating mills have the opportunity to submit rolls of medium on a regular weekly schedule for evaluation with regard to physical characteristics of the medium and of the single-faced board made from the medium. Specifically, each medium is evaluated for caliper, basis weight, and Concora flat crush. In addition each medium is fabricated into A-flute single-faced corrugated board on the Institute's corrugator to determine its runnability in terms of speed and tension, and the single-faced board obtained at maximum speed with minimum tension is evaluated for its flat crush strength.

This report is an extension of the baseline study described above and is concerned specifically with the caliper and uniformity of caliper of the single-faced board fabricated from each roll of medium. Uniformity of caliper is generally considered to be another facet of the criteria used to evaluate the runnability of corrugating medium, and the Technical Committee of the Fourdrinier Kraft Board Institute, Inc., has requested that a measurement of the uniformity of caliper be included as a part of the evaluation given each roll of corrugating medium.

The evaluation of the caliper and uniformity of caliper of the single-faced board made from each roll of corrugating medium was carried out using the five circular specimens that were subsequently tested for flat crush strength. Each specimen was five square inches in area. They were cut at intervals of approximately two feet along the central portion

of a strip of the single-faced board fabricated at maximum speed and minimum tension. On each of these five specimens, caliper measurements were made on five consecutive flutes and the caliper difference between consecutive flutes was calculated, there being four calculations of differences for each specimen. The twenty-five caliper measurements (five calipers on each of the five specimens) were averaged and are reported as the caliper for each sample of medium. Likewise, the twenty caliper differences between consecutive flutes (four caliper differences on each of the five specimens) were averaged, and the maximum, minimum, and average values are reported for each sample of corrugating medium.

The instrument for measuring the caliper of individual flutes of single-faced board consists of a bench-type thickness gage with a pressure foot $\frac{3}{8}$ inch in diameter and an anvil consisting of a plane circular surface 2 inches in diameter. The pressure foot is attached to a dial indicator which can be read to 0.0001 inch. The load on the pressure foot is 100 ± 10 grams. A caliper determination is made by inserting each five-square-inch circular specimen between the pressure foot and the anvil so that the foot rests on the second flute from one end of the specimen without touching either of the adjacent flutes. The $\frac{3}{8}$ -inch diameter of the pressure foot permits it to contact only one flute with ease. The specimen is pressed gently against the anvil, and the reading is then recorded. As mentioned previously, five consecutive flutes through the center of each specimen are calipered in this way. It should be emphasized that these calipers may not necessarily correspond to regular caliper measurements because of differences in load and other variables.

Caliper data have been obtained on the single-faced board fabricated from each of the one hundred and seven rolls of corrugating medium which were submitted for evaluation during the month of January. Also included for purposes of convenient reference are the single-face flat crush and runnability data. The current machine averages for each test are summarized in Table I for Machines A through R. A graphical presentation of the current machine caliper averages on single-faced board is shown in Figure 1, and a similar presentation of the current machine averages for the caliper difference between consecutive flutes is given in Figure 2. The test results obtained on the individual rolls of medium submitted by each company are given in Tables II through XIX for Machines A through R, respectively.

It may be seen in Figure 1 and Table I that the average caliper results for the single-faced boards varied from a low value of 194.3 points for Machine I to a high value of 198.6 points for Machines B and G. Likewise, from the results given in Table I and Figure 2, it may be noted that the average caliper difference between consecutive flutes ranged from a minimum of 1.3 points for Machine P to a maximum of 3.4 points for Machine A. The majority of the machines were associated with average caliper differences of two points or less.

TABLE I
SUMMARY OF CURRENT MACHINE AVERAGES
January, 1961

Machine	Number of Rolls	Caliper, points	Caliper Difference Between Consecutive Flutes, points	Single-Face Flat Crush, p.s.i.
A	4	196.6	3.4	32.7
B	6	198.6	1.7	30.2
C	6	196.0	2.4	28.8
D	6	195.6	2.3	30.9
E	4	198.2	2.4	30.8
F	8	195.7	1.7	33.3
G	6	198.6	1.6	29.7
H	6	195.2	2.2	37.4
I	6	194.3	1.9	32.9
J	10	195.7	1.6	33.1
K	4	198.2	2.6	31.3
L	6	198.2	1.8	29.6
M	9	196.7	2.0	32.4
N	6	196.2	1.8	27.9
O	6	196.9	1.6	31.9
P	7	196.3	1.3	32.8
Q	4	197.0	1.4	33.3
R	3	196.9	1.8	30.1
Total	107			

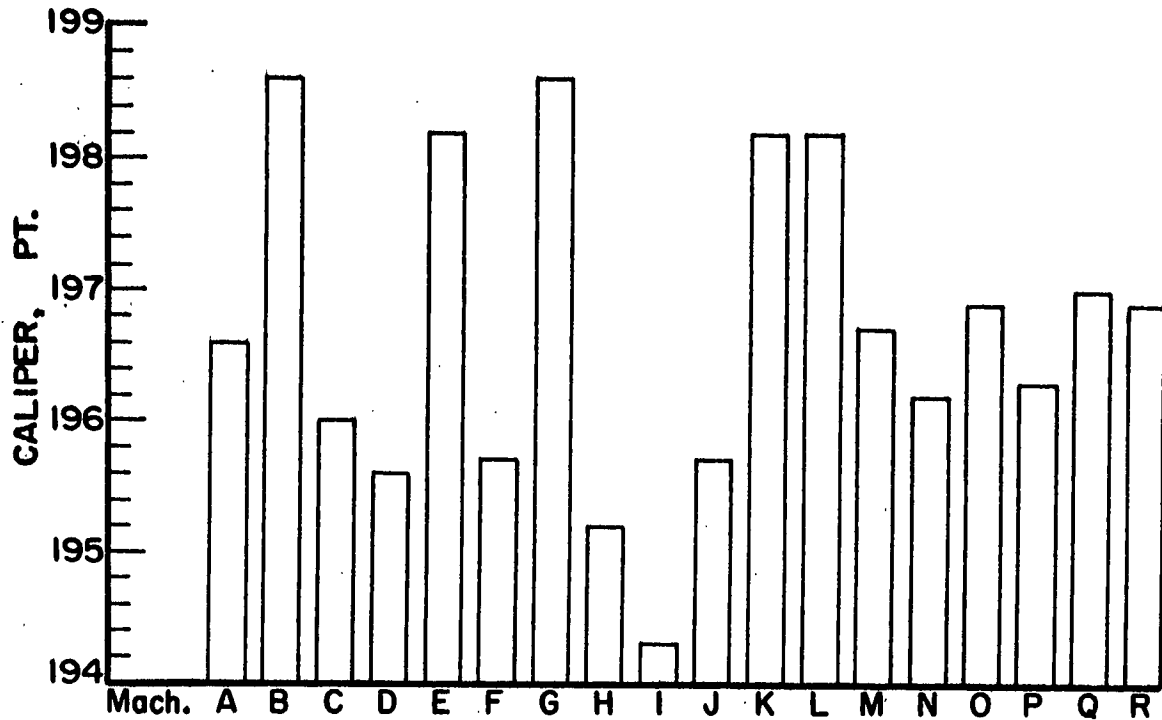


Figure 1. Comparison of Caliper Results on Single-Faced Board
January, 1961

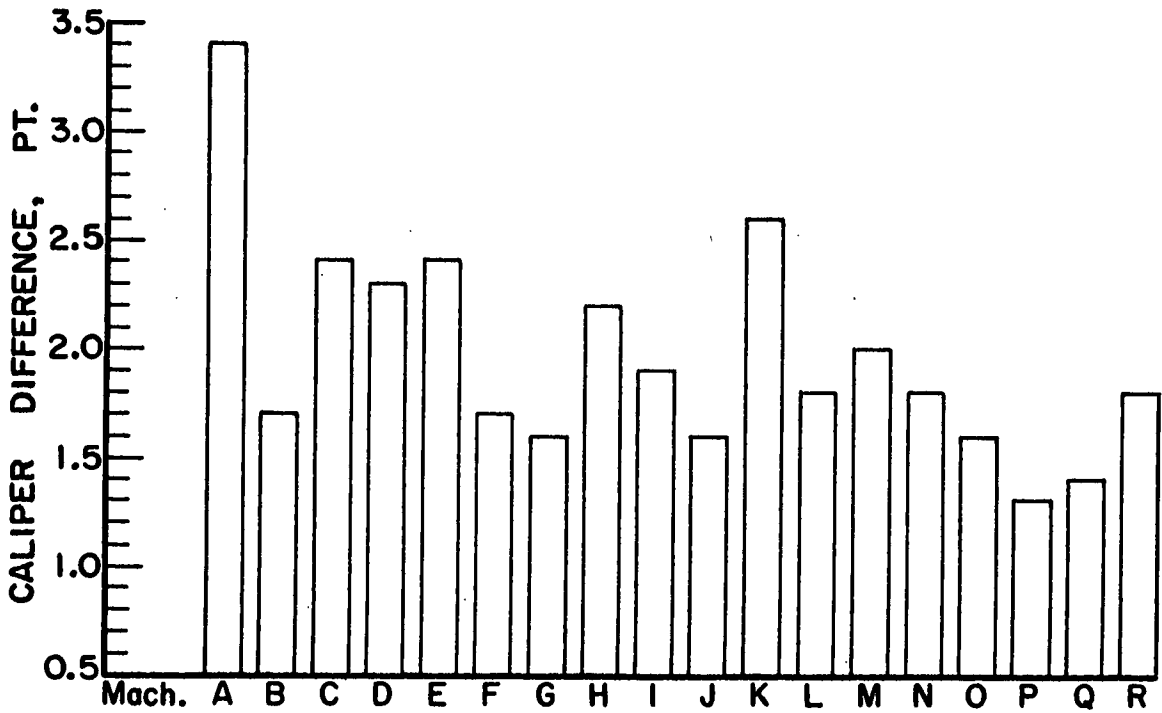


Figure 2. Comparison of the Caliper Differences Between
Consecutive Flutes of Single-Faced Board,
January, 1961

TABLE II

SUMMARY OF TEST RESULTS FOR MACHINE A
January, 1961

Code	Date Made	Mill Roll No.	Caliper, pt.	Caliper Difference Between Consecutive Flutes, pt.			Single-Face Flat Crush, p.s.i.	Runnability (Maximum Tension at 600 f.p.m.), lb./in.
				Max.	Min.	Avg.		
A-1	7-18-60	59	192.8	8.0	0.2	3.8	33.0	1
A-2	12-9-60	81	198.5	6.6	0.2	2.6	33.8	1-1/2
A-3	12-11-60	82	196.0	6.8	0.8	3.8	34.4	1-1/2
A-4	12-15-60	83	199.0	7.4	0.4	3.3	29.6	Note a
Current Machine Av.			196.6			3.4	32.7	

TABLE III

SUMMARY OF TEST RESULTS FOR MACHINE B
January, 1961

B-1	12-21-60	439	199.0	6.2	0.3	3.1	32.0	1/2
B-2	12-21-60	440	197.6	4.6	0.2	1.7	33.9	1
B-3	1- 4-61	447	198.8	3.7	0.0	1.4	28.2	1-1/2
B-4	1- 4-61	448	199.2	4.4	0.0	1.8	27.4	1-1/2
B-5	1-18- 61	455	198.5	2.3	0.1	1.1	30.1	1-1/2
B-6	1-18- 61	456	198.2	2.5	0.5	1.3	29.8	1-1/2
Current Machine Av.			198.6			1.7	30.2	

TABLE IV

SUMMARY OF TEST RESULTS FOR MACHINE C
January, 1961

C-1	12-27-60	L-1	195.6	5.2	0.0	2.2	29.4	1-1/2
C-2	12-27-60	L-1	197.1	7.9	0.0	2.0	28.0	1-1/2
C-3	12-27-60	L-2	195.7	9.6	0.3	3.5	29.1	1-1/2
C-4	12-27-60	L-2	196.2	7.5	0.1	2.6	28.2	1-1/2
C-5	12-27-60	L-3	196.0	5.6	0.3	2.5	28.4	1-1/2
C-6	12-27-60	L-3	195.2	4.9	0.1	1.5	29.6	1-1/2
Current Machine Av.			196.0			2.4	28.8	

^a Maximum speed at which this roll could be corrugated with minimum tension was 500 f.p.m.

TABLE V

SUMMARY OF TEST RESULTS FOR MACHINE D
 January, 1961

Code	Date Made	Mill Roll No.	Caliper, pt.	Caliper Difference Between Consecutive Flutes, pt.			Single-Face Flat Crush, p.s.i.	Runnability (Maximum Tension at 600 f.p.m.), lb./in.
				Max.	Min.	Av.		
D-1	12- 3-60	413	196.1	3.5	0.3	1.5	30.4	Note a
D-2	12- 4-60	414	196.8	7.5	0.5	2.9	31.1	Note b
D-3	12- 7-60	415	195.8	4.9	0.3	2.2	34.6	1/2
D-4	12-11-60	416	195.6	6.0	0.5	2.4	31.5	1/2
D-5	12-20-60	417	192.0	8.1	0.0	2.7	26.8	Note b
D-6	1- 8-61	418	197.1	5.3	0.0	2.0	30.8	1-1/2
Current Machine Av.			195.6			2.3	30.9	

TABLE VI

SUMMARY OF TEST RESULTS FOR MACHINE E
 January, 1961

E-1	12-22-60	359	199.0	7.5	0.0	3.8	30.1	1-1/2
E-2	12-29-60	360	199.4	5.8	0.2	1.7	29.4	1-1/2
E-3	1- 4-61	361	196.9	6.6	0.0	2.3	31.8	1-1/2
E-4	1- 12-61	362	197.3	5.5	0.5	2.0	32.0	1-1/2
Current Machine Av.			198.2			2.4	30.8	

^a Maximum speed at which this roll could be corrugated with minimum tension was 400 f.p.m.

^b Maximum speed at which this roll could be corrugated with minimum tension was 550 f.p.m.

TABLE VII

SUMMARY OF TEST RESULTS FOR MACHINE F
January, 1961

Code	Date Made	Mill Roll No.	Caliper, pt.	Caliper Difference Between Consecutive Flutes, pt.			Single-Face Flat Crush, p.s.i.	Runnability (Maximum Tension at 600 f.p.m.), lb./in.
				Max.	Min.	Av.		
F-1	12- 5-60	149	196.0	7.0	0.0	2.7	35.1	Note a
F-2	12- 7-60	229	196.5	3.5	0.2	1.7	33.6	Min.
F-3	12-14-60	446	195.3	2.8	0.1	1.0	35.5	1/2
F-4	12-16-60	517	196.6	2.3	0.0	0.9	34.9	1/2
F-5	12-19-60	619	194.0	7.0	0.1	2.9	32.3	Note b
F-6	12-30-60	757	195.8	2.5	0.0	1.1	30.9	1
F-7	1- 4-61	100	195.7	4.0	0.0	1.9	31.8	1/2
F-8	1- 6-61	158	196.0	3.6	0.0	1.3	32.0	1
Current Machine Av.			195.7			1.7	33.3	

TABLE VIII

SUMMARY OF TEST RESULTS FOR MACHINE G
January, 1961

G-1	12-22-60	437	198.2	4.3	0.0	1.9	32.2	1-1/2
G-2	12-22-60	438	198.7	2.4	0.3	1.1	30.5	1-1/2
G-3	1- 6-61	445	198.8	3.3	0.0	1.5	29.4	1-1/2
G-4	1- 6-61	446	199.2	5.0	0.2	1.9	28.2	1-1/2
G-5	1-17-61	453	198.0	3.8	0.3	1.8	28.7	1-1/2
G-6	1-17-61	454	198.9	3.6	0.0	1.4	29.0	1-1/2
Current Machine Av.			198.6			1.6	29.7	

^a Maximum speed at which this roll could be corrugated with minimum tension was 425 f.p.m.

^b Maximum speed at which this roll could be corrugated with minimum tension was 575 f.p.m.

TABLE IX

SUMMARY OF TEST RESULTS FOR MACHINE H
January, 1961

Code	Date Made	Mill Roll No.	Caliper, pt.	Caliper Difference Between Consecutive Flutes, pt.			Single-Face Flat Crush, p.s.i.	Runnability (Maximum Tension at 600 f.p.m.), lb./in.
				Max.	Min.	Av.		
H-1	12-19-60	603	194.9	5.0	0.0	2.6	38.5	1-1/2
H-2	12-22-60	604	196.4	5.4	0.0	2.2	39.3	1/2
H-3	1-10-61	605	193.0	4.5	0.3	1.6	37.4	1/2
H-4	1-12-61	606	194.9	6.9	0.1	2.9	36.4	1
H-5	1-19-61	607	196.0	3.8	0.2	1.7	34.1	1-1/2
H-6	1-20-61	608	196.0	5.2	0.4	2.4	38.7	1-1/2
Current Machine Av.			195.2			2.2	37.4	

TABLE X

SUMMARY OF TEST RESULTS FOR MACHINE I
January, 1961

I-1	1-3-61	53	194.9	3.8	0.0	2.0	32.6	1-1/2
I-2	1-3-61	54	194.0	4.1	0.3	1.7	33.6	1-1/2
I-3	1-3-61	55	197.2	5.0	0.4	2.3	29.2	1-1/2
I-4	1-4-61	56	193.2	4.5	0.2	1.8	32.4	1-1/2
I-5	1-4-61	57	192.9	3.5	0.1	1.6	34.4	1-1/2
I-6	1-4-61	58	193.7	3.8	0.3	1.9	35.1	1-1/2
Current Machine Av.			194.3			1.9	32.9	

TABLE XI

SUMMARY OF TEST RESULTS FOR MACHINE J
January, 1961

J-1	12-15-60	--	196.7	4.5	0.0	1.6	33.7	1
J-2	12-17-60	--	196.4	4.5	0.2	2.3	32.5	1-1/2
J-3	12-20-60	--	195.9	4.7	0.1	2.0	33.5	1
J-4	12-21-60	--	193.9	5.8	0.0	2.4	33.5	1/2
J-5		--	196.3	2.8	0.1	1.1	33.3	1-1/2
J-6	1-10-61	--	194.8	4.1	0.0	1.2	31.4	1-1/2
J-7	1-11-61	--	197.0	3.3	0.1	1.3	30.1	1
J-8	1-12-61	--	196.0	3.5	0.0	1.1	33.4	1
J-9	1-13-61	--	195.4	4.0	0.0	1.4	36.0	1
J-10	1-14-61	--	194.8	3.0	0.0	1.3	33.9	1
Current Machine Av.			195.7			1.6	33.1	

TABLE XII

SUMMARY OF TEST RESULTS FOR MACHINE K
January, 1961

Code	Date Made	Mill Roll No.	Caliper, pt.	Caliper Difference Between Consecutive Flutes, pt.			Single-Face Flat Crush, p.s.i.	Runnability (Maximum Tension at 600 f.p.m.), lb./in.
				Max.	Min.	Avg.		
K-1	12-20-60	433	198.4	4.6	0.2	2.1	31.5	1-1/2
K-2	12-20-60	434	198.2	5.1	0.6	3.2	32.1	1-1/2
K-3	1-12-61	449	197.3	5.0	0.4	2.3	32.5	1
K-4	1-12-61	450	198.8	8.3	0.2	2.7	29.2	1
Current Machine Av.			198.2			2.6	31.3	

TABLE XIII

SUMMARY OF TEST RESULTS FOR MACHINE L
January, 1961

L-1	12-15-60	53	196.2	6.2	0.0	2.3	31.4	1-1/2
L-2	12-15-60	54	194.8	5.8	0.2	1.9	27.9	1-1/2
L-3	1- 4-61	52	200.8	4.8	0.5	1.9	29.6	1-1/2
L-4	1- 4-61	53	201.6	3.0	0.5	1.7	30.3	1-1/2
L-5	1- 4-61	54	199.9	5.5	0.0	1.7	30.4	1-1/2
L-6	1- 5-61	55	195.7	3.3	0.2	1.5	28.2	1-1/2
Current Machine Av.			198.2			1.8	29.6	

TABLE XIV

SUMMARY OF TEST RESULTS FOR MACHINE M
January, 1961

M-1	12-17-60	--	197.5	4.4	0.0	1.9	35.5	1-1/2
M-2	12-19-60	--	196.3	4.0	0.4	1.7	33.8	1
M-3	12-20-60	--	196.7	4.5	0.1	1.6	32.6	1/2
M-4	12-28-60	--	195.0	6.0	0.4	3.3	31.9	Min.
M-5	1-10-61	--	197.3	3.8	0.0	1.6	28.0	1/2
M-6	1-12-61	--	195.2	3.6	0.2	1.6	33.3	1
M-7	1-13-61	--	196.9	4.5	0.1	2.2	31.4	1
M-8	1-14-61	--	197.5	5.9	0.1	3.0	33.4	1
M-9	1-17-61	--	197.7	3.6	0.0	1.4	31.4	1-1/2
Current Machine Av.			196.7			2.0	32.4	

TABLE XV

SUMMARY OF TEST RESULTS FOR MACHINE N
January, 1961

Code	Date Made	Mill Roll No.	Caliper, pt.	Caliper Difference Between Consecutive Flutes, pt.			Single-Face Flat Crush, p.s.i.	Runnability (Maximum Tension at 600 f.p.m.), lb./in.
				Max.	Min.	Av.		
N-1	9-21-60	114	195.7	4.6	0.1	1.7	27.1	1/2
N-2	12-13-60	129	196.6	4.0	0.0	1.1	27.5	1
N-3	12-20-60	131	196.6	2.9	0.1	1.2	27.8	1
N-4	1- 1-61	132	196.4	7.5	0.2	2.2	27.2	1/2
N-5	1- 6-61	133	195.6	5.7	0.1	2.2	28.1	1/2
N-6	1- 9-61	134	196.6	5.5	0.1	2.4	29.5	1/2
Current Machine Av.			196.2			1.8	27.9	

TABLE XVI

SUMMARY OF TEST RESULTS FOR MACHINE O
January, 1961

O-1	12-20-60	435	197.8	3.7	0.1	1.7	34.3	1-1/2
O-2	12-20-60	436	197.3	3.3	0.3	1.6	31.2	1-1/2
O-3	12-29-60	443	197.3	5.0	0.0	1.3	29.6	1-1/2
O-4	12-29-60	444	197.8	4.0	0.3	1.6	30.4	1-1/2
O-5	1-18-61	451	195.9	3.0	0.0	1.0	31.6	1-1/2
O-6	1- 18-61	452	195.3	4.4	0.0	2.1	34.6	1-1/2
Current Machine Av.			196.9			1.6	31.9	

TABLE XVII

SUMMARY OF TEST RESULTS FOR MACHINE P
January, 1961

P-1	12-19-60	--	198.1	3.8	0.0	1.5	30.8	1-1/2
P-2	12-20-60	--	195.3	2.3	0.2	1.0	34.5	1-1/2
P-3	12-28-60	--	195.6	3.5	0.0	1.3	31.8	1/2
P-4	1-11-61	--	196.4	3.2	0.2	1.5	32.4	1-1/2
P-5	1-12-61	--	196.8	2.5	0.0	1.4	32.8	1-1/2
P-6	1-13-61	--	196.0	3.3	0.1	1.3	33.6	1-1/2
P-7	1-14-61	--	195.9	4.3	0.0	1.2	33.8	1-1/2
Current Machine Av.			196.3			1.3	32.8	

TABLE XVIII

SUMMARY OF TEST RESULTS FOR MACHINE Q
 January, 1961

Code	Date Made	Mill Roll No.	Cali- per, pt.	Caliper Difference Between Consecu- tive Flutes, pt.			Single-Face Flat Crush, p.s.i.	Runnability (Maximum Ten- sion at 600 f.p.m.), lb./in.
				Max.	Min.	Av.		
Q-1	12-14-60	297	196.4	3.5	0.1	1.7	33.6	1/2
Q-2	1- 3-61	298	196.9	4.4	0.1	1.7	33.5	1-1/2
Q-3	1-12-61	299	197.2	3.7	0.0	1.1	32.0	1-1/2
Q-4	1-16-61	300	197.7	3.3	0.0	1.3	34.2	1-1/2
Current Machine Av.			197.0			1.4	33.3	

TABLE XIX

SUMMARY OF TEST RESULTS FOR MACHINE R
 January, 1961

R-1	12-14-60	2011	196.8	4.1	0.2	2.2	29.2	1-1/2
R-2	12-31-60	3108	197.0	3.1	0.0	1.3	30.0	1
R-3	12-31-60	3114	196.8	4.6	0.0	1.8	31.2	1
Current Machine Av.			196.9			1.8	30.1	

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