

SCRAMBLED CODE LETTERS FOR PROGRESS REPORT 58  
PROJECT 1108-17

Company - Mill	Machine No.	Code Letter
The Chesapeake Corporation - West Point	1	--
Continental Can Company, Inc. - Hopewell	1	D
Crown Zellerbach Corporation - Baltimore	1	S
Baltimore	2	J
Bogalusa	4	Q
Dresden	1	I
Lebanon	2	A
International Paper Company - Bastrop	1	N
Bastrop	2	--
Georgetown	1	E
Georgetown	2	--
The Mead Corporation - Harriman	1	U
Knoxville	1	B
Lynchburg	2	P
Sylva	1	T
Muskingum Fibre Products Company - Coshocton	1	L
North Carolina Pulp Company - Plymouth	3	H
Olin Mathieson Chemical Corporation - Monroe	1	--
Monroe	2	--
Owens-Illinois Glass Company - Tomahawk	1	M
Tomahawk	2	F
Tomahawk	3	R
Big Island	1	C
Big Island	2	O
St. Joe Paper Company - Port St. Joe	1	Q
Union Bag-Camp Paper Corporation - Savannah	2	--
West Virginia Pulp and Paper Company - Covington	6	K
Covington	7	--
Charleston	--	--

THE INSTITUTE OF PAPER CHEMISTRY

Appleton, Wisconsin

SUPPLEMENTARY REPORT ON CALIPER OF SINGLE-FACED  
BOARD

Project 1108-17

Progress Report 58

to

FOURDRINIER KRAFT BOARD INSTITUTE, INC.

January 1, 1960

THE INSTITUTE OF PAPER CHEMISTRY

Appleton, Wisconsin

This report is supplementary to Progress Report 57 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 runability 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 runability 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 presser foot  $3/8$  inch in diameter and an anvil consisting of a plane circular surface 2 inches in diameter. The presser foot is attached to a dial indicator which can be read to 0.0001 inch. The load on the presser foot is  $100 \pm 10$  grams. A caliper determination is made by inserting each five-square-inch circular specimen between the presser 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  $3/8$ -inch diameter of the presser 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 twenty rolls of corrugating medium which were submitted for evaluation during the month of December. Also included for purposes of convenient reference are the single-face flat crush and runability data. The current machine averages for each test are summarized in Table I for Machines A through U. A graphical presentation of the caliper data on the single-faced board is shown in Figure 1, and a similar presentation of the data on 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 XXII for Machines A through U, 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 194.0 points for Machine S to a high value of 199.8 points for Machine G. Likewise, from the results given in Table I and Figure 2, it may be noted that the average caliper differences between consecutive flutes ranged from a minimum of 1.1 points for Machine M to a maximum of 3.2 points for Machine I. The majority of the machines were associated with average caliper differences of less than 2 points. The differences which exceed three points appear to be excessive.

TABLE I  
 SUMMARY OF CURRENT MACHINE AVERAGES  
 December, 1959

Machine	Number of Rolls	Caliper, points	Caliper Difference Between Consecutive Flutes, points	Single-Face Flat Crush, p.s.i.
A	1	198.0	2.4	34.6
B	4	198.6	2.2	32.8
C	7	197.4	1.4	32.7
D	7	197.9	1.6	31.2
E	8	196.8	1.6	34.9
F	4	197.4	1.4	31.1
G	5	199.8	2.3	29.2
H	12	197.8	1.4	33.2
I	3	197.5	3.2	30.9
J	4	194.7	2.4	32.4
K	14	197.5	1.6	32.5
L	9	197.8	3.1	34.0
M	4	196.4	1.1	30.0
N	7	196.7	1.7	34.5
O	5	198.3	1.5	32.1
P	2	199.2	1.2	33.3
Q	8	198.2	2.1	29.4
R	4	198.1	1.9	34.2
S	4	194.0	2.2	30.3
T	4	199.1	2.1	34.4
U	4	197.2	1.3	31.7
Total	120			

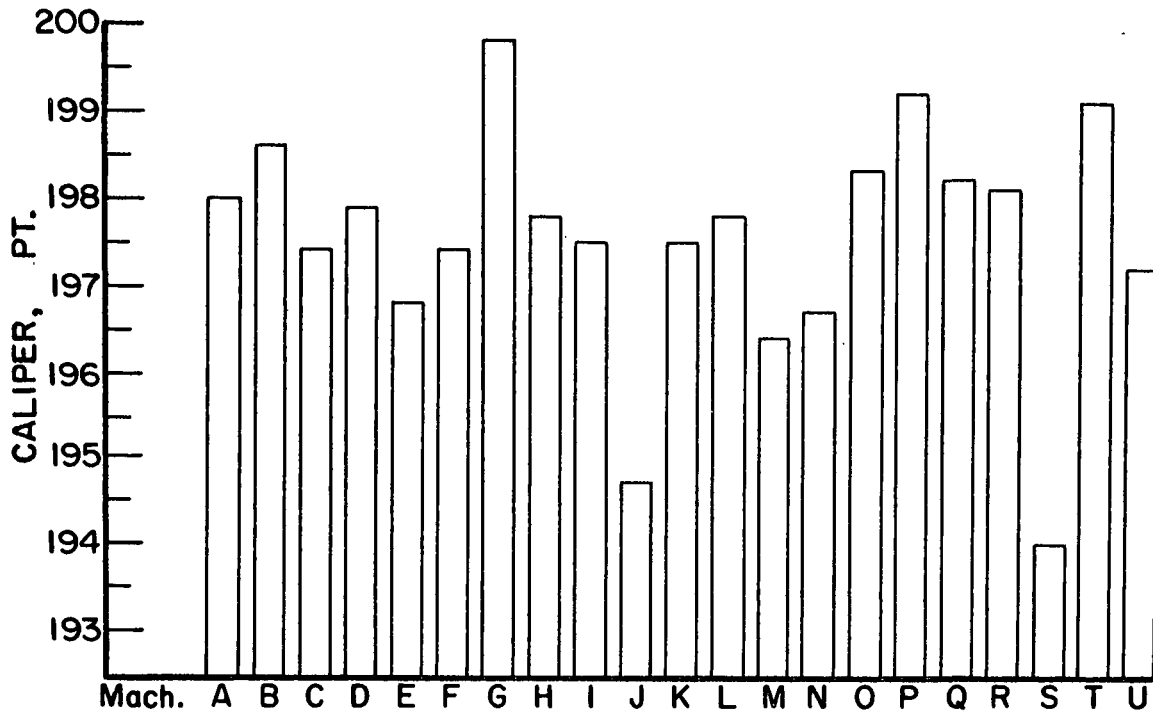


Figure 1

Comparison of Caliper Results on Single-Faced Board  
December, 1959

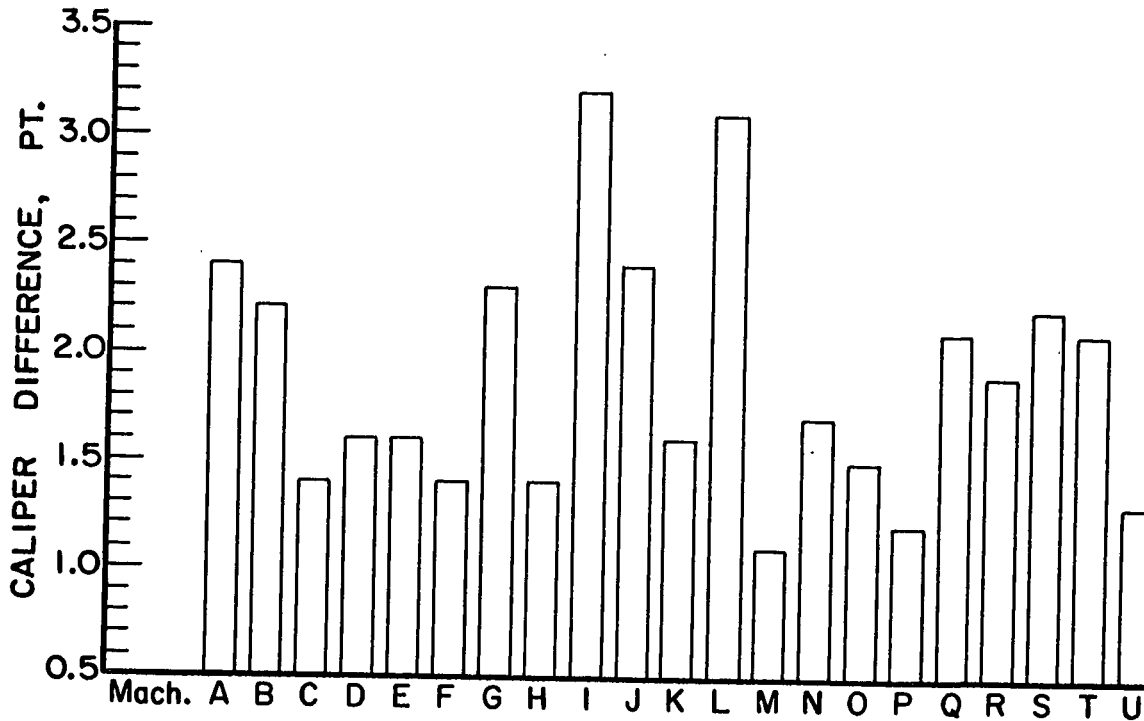


Figure 2

Comparison of the Caliper Differences Between Consecutive  
Flutes of Single-Faced Board  
December, 1959

TABLE II

SUMMARY OF TEST RESULTS FOR MACHINE A  
 December, 1959

Code	Date Made	Mill Roll No.	Cali- per, pt.	Caliper Difference Between Consecu- tive Flutes, points			Single-Face Flat Crush, p.s.i.	Runability, (Maximum Tension at 600 f.p.m.), lb./in.
				Max.	Min.	Av.		
A-1	11-29-59	2	198.0	5.1	0.1	2.4	34.6	1/2
Current Machine Av.			198.0			2.4	34.6	

TABLE III

SUMMARY OF TEST RESULTS FOR MACHINE B  
 December, 1959

B-1	11-20-59	211	198.8	6.0	0.1	1.5	32.6	1-1/2
B-2	11-20-59	212	198.7	3.8	0.0	1.9	32.6	1-1/2
B-3	12- 2-59	219	198.4	6.3	0.1	2.0	32.5	1-1/2
B-4	12- 2-59	220	198.3	7.0	0.4	3.5	33.6	1-1/2
Current Machine Av.			198.6			2.2	32.8	

TABLE IV

SUMMARY OF TEST RESULTS FOR MACHINE C  
 December, 1959

C-1	10-26-59	1961	198.0	3.0	0.1	1.3	33.7	1-1/2
C-2	10-30-59	2256	198.3	3.9	0.1	1.5	30.5	1-1/2
C-3	11- 4-59	313	196.5	3.2	0.1	1.5	32.3	1-1/2
C-4	11- 5-59	359	196.8	3.0	0.0	1.2	34.9	1-1/2
C-5	11- 7-59	507	196.2	3.0	0.0	1.5	32.5	1
C-6	11-16-59	1119	197.3	3.2	0.1	1.2	30.6	1-1/2
C-7	11-21-59	1398	198.6	3.5	0.0	1.3	34.1	1-1/2
Current Machine Av.			197.4			1.4	32.7	

TABLE V

SUMMARY OF TEST RESULTS FOR MACHINE D  
 December, 1959

Code	Date Made	Mill Roll No.	Caliper, pt.	Caliper Difference Between Consecutive Flutes, points			Single-Face Flat Crush, p.s.i.	Runability, (Maximum Tension at 600 f.p.m.), lb./in.
				Max.	Min.	Av.		
D-1	11-17-59	221	198.1	2.7	0.0	1.2	33.1	1-1/2
D-2	11-24-59	222	198.1	3.8	0.3	1.6	32.2	1-1/2
D-3	11-27-59	223	198.2	3.4	0.2	1.8	32.7	1-1/2
D-4	12- 1-59	224	198.5	5.2	0.0	2.1	30.7	1
D-5	12- 3-59	225	197.5	5.0	0.0	1.8	30.7	1-1/2
D-6	12--7-59	226	197.4	4.0	0.1	1.4	30.8	1-1/2
D-7	12- 9-59	227	197.2	3.0	0.0	1.1	28.2	1-1/2
Current Machine Av.			197.9			1.6	31.2	

TABLE VI

SUMMARY OF TEST RESULTS FOR MACHINE E  
 December, 1959

E-1	11-17-59	364	195.5	3.9	0.0	1.6	35.4	1
E-2	11-20-59	365	196.9	6.6	0.3	2.7	37.0	1-1/2
E-3	11-25-59	366	196.8	2.5	0.0	1.2	35.1	1-1/2
E-4	11-26-59	367	196.4	2.9	0.1	0.9	33.5	1-1/2
E-5	12- 1-59	368	197.7	4.0	0.1	1.9	35.3	1
E-6	12- 3-59	369	197.2	3.0	0.1	1.3	34.0	1-1/2
E-7	12- 9-59	370	198.7	4.0	0.3	1.8	34.4	1-1/2
E-8	12-11-59	371	195.6	3.3	0.1	1.3	34.3	1-1/2
Current Machine Av.			196.8			1.6	34.9	

TABLE VII

SUMMARY OF TEST RESULTS FOR MACHINE F  
 December, 1959

F-1	11-10-59	--	197.4	4.1	0.1	1.8	33.4	1
F-2	11-18-59	--	197.3	2.3	0.1	1.2	31.6	1/2
F-3	11-26-59	--	197.9	3.1	0.1	1.5	29.0	1
F-4	12- 2-59	--	196.8	2.6	0.0	1.1	30.2	1/2
Current Machine Av.			197.4			1.4	31.1	

TABLE VIII

SUMMARY OF TEST RESULTS FOR MACHINE G  
December, 1959

Code	Date Made	Mill Roll No.	Cali- per, pt.	Caliper Difference Between Consecutive Flutes, points			Single-Face Flat Crush, p.s.i.	Runability (Maximum Tension at 600 f.p.m.), lb./in.
				Max.	Min.	Av.		
G-1	11-18-59	12	201.3	4.1	0.4	1.6	28.3	1
G-2	11-24-59	13	197.5	6.0	0.3	3.0	34.0	1/2
G-3	11-25-59	14	198.4	5.0	0.0	1.7	31.2	1/2
G-4	12- 2-59	15	200.8	5.0	0.2	2.2	23.2	1/2
G-5	12- 4-59	16	201.0	6.3	0.5	3.0	29.4	Min.
Current Machine Av.			199.8			2.3	29.2	

TABLE IX

SUMMARY OF TEST RESULTS FOR MACHINE H  
December, 1959

H-1	11- 6-59	175	197.9	4.5	0.4	1.7	36.7	1/2
H-2	11-10-59	301	197.6	3.8	0.0	1.0	30.7	1
H-3	11-12-59	364	196.9	4.7	0.0	1.3	31.5	1/2
H-4	11-14-59	429	197.1	2.1	0.0	1.0	30.8	1/2
H-5	11-20-59	617	196.3	4.3	0.2	2.1	34.3	1
H-6	11-25-59	786	198.8	2.5	0.0	1.3	37.4	1
H-7	11-27-59	849	199.7	5.2	0.3	2.5	35.6	1-1/2
H-8	12- 3-59	58	197.8	2.4	0.0	0.9	33.6	1-1/2
H-9	12- 4-59	91	198.4	3.2	0.0	1.2	31.5	1-1/2
H-10	12- 8-59	217	196.4	3.9	0.3	1.5	35.8	1-1/2
H-11	12-11-59	304	197.2	1.7	0.0	0.5	30.6	1-1/2
H-12	12-14-59	391	199.3	4.4	0.0	2.1	30.1	1/2
Current Machine Av.			197.8			1.4	33.2	

TABLE X

SUMMARY OF TEST RESULTS FOR MACHINE I  
December, 1959

I-1	12- 1-59	1	197.5	7.7	0.0	2.8	32.8	1-1/2
I-2	12- 8-59	2	197.4	11.0	0.5	4.2	29.3	1-1/2
I-3	12-11-59	3	197.5	11.1	0.2	2.7	30.6	1-1/2
Current Machine Av.			197.5			3.2	30.9	

TABLE XI

SUMMARY OF TEST RESULTS FOR MACHINE J  
December, 1959

Code	Date Made	Mill Roll No.	Caliper, pt.	Caliper Difference Between Consecutive Flutes, points			Single-Face Flat Crush, p.s.i.	Runability (Maximum Tension at 600 f.p.m.), lb./in.
				Max.	Min.	Av.		
J-1	11-23-59	1	195.4	6.8	0.0	2.1	30.1	1-1/2
J-2	11-24-59	2	194.7	4.4	0.5	2.3	33.8	1-1/2
J-3	12-15-59	3	194.0	8.7	0.1	2.7	35.1	1-1/2
J-4	12-16-59	4	194.7	6.8	0.2	2.5	30.7	1-1/2
Current Machine Av.			194.7			2.4	32.4	

TABLE XII

SUMMARY OF TEST RESULTS FOR MACHINE K  
December, 1959

K-1	10-24-59	45	197.7	5.0	0.0	1.3	32.9	1-1/2
K-2	10-26-59	46	196.2	4.5	0.3	1.5	31.2	1
K-3	10-29-59	47	197.6	6.4	0.1	1.9	32.6	1
K-4	11- 5-59	48	197.1	3.7	0.1	1.5	32.8	1-1/2
K-5	11-11-59	49	197.0	3.5	0.1	1.1	31.7	1
K-6	11-16-59	50	198.2	4.2	0.3	1.9	30.5	1
K-7	11-21-59	51	197.4	3.7	0.0	1.8	32.0	1
K-8	11-24-59	52	196.8	4.4	0.2	1.9	33.8	1-1/2
K-9	11-25-59	53	196.9	3.5	0.0	1.0	32.0	1
K-10	12- 1-59	54	197.4	4.7	0.0	2.0	33.6	1-1/2
K-11	12- 6-59	55	197.5	3.6	0.0	1.5	32.1	1-1/2
K-12	12-10-59	56	198.5	3.9	0.0	1.7	33.3	1-1/2
K-13	12-12-59	57	198.6	4.4	0.2	2.1	34.0	1-1/2
K-14		58	198.5	4.7	0.3	1.8	32.2	1-1/2
Current Machine Av.			197.5			1.6	32.5	

TABLE XIII

SUMMARY OF TEST RESULTS FOR MACHINE L  
December, 1959

L-1	11-18-59	288	197.3	8.4	0.3	3.0	32.5	1/2
L-2	11-21-59	289	197.2	6.5	0.3	2.8	35.4	1
L-3	11-24-59	290	197.5	9.2	0.1	4.5	33.4	1
L-4	11-27-59	291	198.5	8.0	0.1	3.5	33.7	1-1/2
L-5	12- 1-59	292	198.4	8.9	0.0	4.6	33.2	1
L-6	12- 3-59	293	198.3	6.1	0.0	2.1	34.3	1-1/2
L-7	12- 9-59	294	198.4	6.8	0.8	4.2	34.7	1
L-8	12-11-59	295	194.2	7.0	0.0	1.6	37.7	1-1/2
L-9	12-16-59	296	200.7	5.8	0.2	2.0	31.1	1-1/2
Current Machine Av.			197.8			3.1	34.0	

TABLE XIV

SUMMARY OF TEST RESULTS FOR MACHINE M  
 December, 1959

Code	Date Made	Mill Roll No.	Cali- per, pt.	Caliper Differences Between Consecutive Flutes, points			Single-Face Flat Crush, p.s.i.	Runability (Maximum Tension at 600 f.p.m.), lb./in.
				Max.	Min.	Av.		
M-1	11-11-59	--	196.7	2.7	0.1	1.1	30.5	1
M-2	11-17-59	--	197.3	4.0	0.0	1.2	30.4	1/2
M-3	11-27-59	--	196.0	3.1	0.0	1.2	29.6	1/2
M-4	12- 3-59	--	195.5	2.1	0.0	0.8	29.4	1
Current Machine Av.			196.4			1.1	30.0	

TABLE XV

SUMMARY OF TEST RESULTS FOR MACHINE N  
 December, 1959

N-1	11-24-59	522	195.9	5.5	0.2	2.3	33.9	1-1/2
N-2	11-27-59	523	195.9	4.2	0.1	1.6	33.7	1-1/2
N-3	12- 1-59	524	197.5	3.0	0.0	1.0	33.3	1-1/2
N-4	12- 8-59	525	197.2	3.9	0.0	1.6	35.8	1-1/2
N-5	12-11-59	526	195.1	4.2	0.2	1.3	36.0	1/2
N-6	12-17-59	527	197.9	6.0	0.0	2.7	35.1	1-1/2
N-7	12-18-59	528	197.3	3.9	0.0	1.6	33.4	1-1/2
Current Machine Av.			196.7			1.7	34.5	

TABLE XVI

SUMMARY OF TEST RESULTS FOR MACHINE O  
 December, 1959

O-1	10-27-59	2155	197.9	2.4	0.1	1.2	31.9	1-1/2
O-2	11- 1-59	17	198.1	4.5	0.0	1.5	32.2	1-1/2
O-3	11- 4-59	273	198.0	3.3	0.0	1.2	33.1	1-1/2
O-4	11-18-59	1394	199.3	3.0	0.2	1.6	30.5	1-1/2
O-5	11-21-59	--	198.3	4.7	0.0	1.8	32.7	1-1/2
Current Machine Av.			198.3			1.5	32.1	

TABLE XVII

SUMMARY OF TEST RESULTS FOR MACHINE P  
December, 1959

Code	Date Made	Mill Roll No.	Cali- per, pt.	Caliper Differences Between Consecutive Flutes, points			Single-Face Flat Crush, p.s.i.	Runability (Maximum Tension at 600 f.p.m.), lb./in.
				Max.	Min.	Av.		
P-1	11-27-59	213	199.5	3.4	0.0	1.5	33.6	1-1/2
P-2	11-27-59	214	198.8	3.5	0.1	0.9	33.0	1-1/2
Current Machine Av.			199.2			1.2	33.3	

TABLE XVIII

SUMMARY OF TEST RESULTS FOR MACHINE Q  
December, 1959

Q-1	12- 5-59	43	198.7	3.5	0.3	1.8	29.1	1.
Q-2	12- 5-59	44	198.4	4.4	0.3	2.4	27.9	1
Q-3	12-17-59	45	197.5	6.3	0.3	2.0	31.2	1/2
Q-4	12-17-59	46	197.5	4.6	0.0	2.0	30.1	1/2
Q-5	12-17-59	47	198.3	8.4	0.3	2.9	29.2	1
Q-6	12-17-59	48	198.9	2.9	0.3	1.6	29.3	1-1/2
Q-7	12-17-59	49	198.1	6.8	0.1	2.5	29.7	1-1/2
Q-8	12-17-59	50	198.4	6.1	0.3	1.9	28.7	1-1/2
Current Machine Av.			198.2			2.1	29.4	

TABLE XIX

SUMMARY OF TEST RESULTS FOR MACHINE R  
December, 1959

R-1	11-12-59	--	197.4	4.3	0.0	1.6	35.4	1/2
R-2	11-20-59	--	197.8	6.9	0.3	2.4	34.5	Min.
R-3	11-25-59	--	197.9	3.7	0.1	1.6	32.7	1/2
R-4	12- 1-59	--	199.3	4.3	0.5	2.0	34.2	1/2
Current Machine Av.			198.1			1.9	34.2	

TABLE XX

SUMMARY OF TEST RESULTS FOR MACHINE S  
 December, 1959

Code	Date Made	Mill Roll No.	Caliper, pt.	Caliper Differences Between Consecutive Flutes, points			Single-Face Flat Crush, p.s.i.	Runability (Maximum Tension at 600 f.p.m.), lb./in.
				Max.	Min.	Av.		
S-1	11-18-59	1	196.0	4.9	0.0	2.4	28.2	1-1/2
S-2	11-19-59	2	196.1	1.7	0.0	0.7	31.1	1-1/2
S-3	12- 8-59	3	192.8	8.8	0.2	3.7	31.5	1
S-4	12- 9-59	4	191.3	4.8	0.3	1.9	30.5	1/2
Current Machine Av.			194.0			2.2	30.3	

TABLE XXI

SUMMARY OF TEST RESULTS FOR MACHINE T  
 December, 1959

T-1	11-25-59	213	198.9	6.2	0.1	1.9	34.2	1-1/2
T-2	11-25-59	214	199.0	10.2	0.1	2.2	33.3	1-1/2
T-3	12-11-59	221	199.6	4.0	0.1	2.0	34.4	1-1/2
T-4	12-11-59	222	198.9	6.3	0.3	2.2	35.6	1-1/2
Current Machine Av.			199.1			2.1	34.4	

TABLE XXII

SUMMARY OF TEST RESULTS FOR MACHINE U  
 December, 1959

U-1	11-17-59	209	199.2	4.5	0.0	1.7	29.1	1-1/2
U-2	11-17-59	210	198.5	2.0	0.0	1.1	31.4	1-1/2
U-3	12- 2-59	217	196.1	3.2	0.0	1.2	33.1	1-1/2
U-4	12- 2-59	218	195.1	3.0	0.2	1.1	33.3	1-1/2
Current Machine Av.			197.2			1.3	31.7	

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