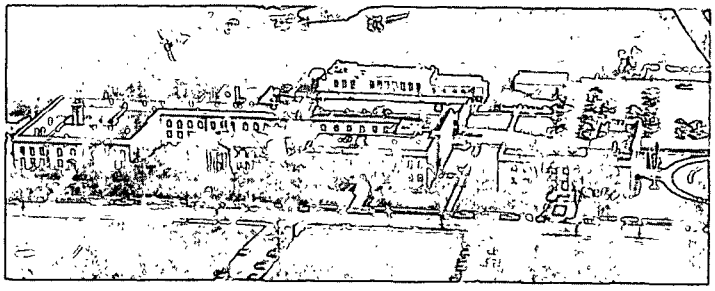
BASE-LINE
JULY-AUGUST, 1973



THE INSTITUTE OF PAPER CHEMISTRY, APPLETON, WISCONSIN

CONTINUOUS BASE-LINE STUDY (MODIFIED)
(MILL CORRUGATING MEDIUM DATA FOR JULY AND AUGUST, 1973)

Project 2694-2

Report Four

A Progress Report

to

FOURDRINIER KRAFT BOARD INSTITUTE, INC.

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October 24, 1973

THE INSTITUTE OF PAPER CHEMISTRY

Appleton, Wisconsin

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THE INSTITUTE OF PAPER CHEMISTRY

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CONTINUOUS BASE-LINE STUDY (MODIFIED)
(MILL CORRUGATING MEDIUM DATA FOR JULY AND AUGUST, 1973)

SUMMARY OF 26-LB. CORRUGATING MEDIUM DATA
(MAY-AUGUST, 1973)

Test		May	June	July	August
Moisture Content, %	Max.[a]	9.2	9.0	9.0	9.1
	Min.[a]	3.7	3.8	3.6	3.5
	Av.[b]	6.2 (34)	6.1 (34)	6.0 (35)	6.0 (34)
Adj. Basis Weight, lb./M. ft.^{2}	Max.[a]	28.0	27.9	27.7	27.9
	Min.[a]	25.8	25.9	25.9	25.7
	Av.[b]	26.5 (34)	26.5 (34)	26.5 (35)	26.5 (34)
Caliper, pt.	Max.[a]	11.3	11.1	11.0	11.0
	Min.[a]	9.0	9.0	9.0	9.0
	Av.[b]	9.9 (31)	9.8 (31)	9.8 (32)	9.9 (31)
Concora, p.s.i.	Max.[a]	47.7	47.2	49.5	49.3
	Min.[a]	33.0	34.0	33.9	33.1
	Av.[b]	38.9 (34)	38.7 (34)	38.4 (35)	38.3 (34)
Runnability Index	Max.[a]	100		100	
	Min.[a]	56		53	
	Av.[b]	83 (34)		81 (34)	

[a]Current machine average.

[b]Current FKI average, number of machines is indicated in parentheses.

INTRODUCTION

The continuous base-line study (modified) is a compilation of monthly average of mill test data obtained routinely on 26-lb. corrugating medium manufactured in the member mills of F.K.B.I., Inc. Mill data are included for moisture content, basis weight, caliper, and Concora made on the production of individual machines which produced at least 500 tons of this grade weight during a given month. In addition, the F.K.B.I. has arranged for the runnability tests to be made at The Institute of Paper Chemistry on samples submitted by each participating machine. The program allows for the submission of two samples per machine per month. Runnability index values are included in this report for samples of medium submitted to the Institute during this period.

PRESENTATION OF DATA

For the 26-lb. grade weight of corrugating medium referred to earlier, mill test averages for moisture content, basis weight, caliper, Concora, and runnability index results are compiled in the following tables.

Table Number	Description
I	Institute Test Averages of Runnability Index
II-III	Mill Test Averages on 26-Lb. Corrugating Medium

Data submitted by the participating mills relative to conditioning and testing environments are summarized in Table IV. The procedures used in calculating cumulative machine averages, machine factors, machine indexes, and FKI indexes are described in the Appendix.

TABLE I

RUNNABILITY TESTER RESULTS

CODE	SAMPLE ONE DATE MADE	SAMPLE ONE RUNNABILITY INDEX	SAMPLE TWO DATE MADE	SAMPLE TWO RUNNABILITY INDEX	SAMPLE THREE DATE MADE	SAMPLE THREE RUNNABILITY INDEX	SAMPLE FOUR DATE MADE	SAMPLE FOUR RUNNABILITY INDEX	AVERAGE RUNNABILITY INDEX
A1	7-10-73	58	7-27-73	67	8- 6-73	64	8-29-73	66	64
B1	7-18-73	63	7-30-73	69	8- -73	66		*	66
C1	7-12-73	77	7-18-73	80	8-15-73	87		*	81
D1	7-18-73	78		*		*		*	78
E1	7-23-73	100	8-31-73	100		*		*	100
F1	7-11-73	82	7-24-73	89	8- 7-73	83	8-20-73	98	88
G1	7-11-73	56	7-27-73	61	8- 6-73	61	8-29-73	70	62
H1	7-26-73	78	8-24-73	68	8-30-73	72		*	73
I1	7-17-73	76	8-24-73	80	8-31-73	75		*	77
J1		98		*		*		*	98
K1	7- 6-73	93	7-26-73	96	8- 6-73	90	8-27-73	83	91
L1	7-24-73	77	8- 8-73	87	8-31-73	59		*	74
M1	7- 9-73	62	7-23-73	54	8- 2-73	57	8-22-73	63	59
N1	7-18-73	99	7-29-73	99	8-27-73	98	8-29-73	100	99
O1	7- 2-73	54	7- 4-73	57	8-16-73	74	8-29-73	71	64
P1	7-12-73	61	7-20-73	65	8-20-73	63		68	64
Q1		*		*		*		*	*
R1	7-14-73	60	7-28-73	64	8- 1-73	60	8-29-73	55	60
S1	7-11-73	66	7-26-73	72	8- 6-73	69	8-29-73	74	70
T1	7-25-73	98	8-13-73	98	8-30-73	93		*	96
U1	7-31-73	100	8-20-73	100		*		*	100
V1	7- -73	72	8- -73	68		*		*	70
W1	7-20-73	48	7-28-73	56	8- 4-73	55	8-29-73	53	53
X1	7- 3-73	92	7-27-73	97		*		*	95
Y1	7- 9-73	88	7-16-73	89		91		97	91
Z1	7- 3-73	66	7-23-73	62	8- 8-73	65	8-20-73	69	66
A2	8- 7-73	98	8-23-73	97		*		*	98
B2	7-23-73	100	8-20-73	100		*		*	100
C2	7- 3-73	98	7-12-73	93	8- 6-73	81	8-27-73	76	87
D2	7- -73	82	8- -73	71		*		*	77
E2	7- 9-73	96	7-19-73	99	8- 8-73	73	8-21-73	74	86
F2	7- 2-73	90	7- 3-73	88		*		*	89
G2	7-13-73	100	7-25-73	100	8-17-73	99	8-24-73	100	100
H2	7-16-73	94	7-22-73	98	8- 7-73	100	8-20-73	96	97
I2	7-20-73	82	7-30-7	83	8- 6-7	83	8-21-73	81	82

Minimum	53
Maximum	100
FKI Average	81 (34)

*- No sample submitted.

Note- Number in parentheses is number of machines included in average.

TABLE II

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

JULY, 1973

	MOISTURE CONTENT, PERCENT				ADJ. BASIS WT.,*A LB./ M SQ. FT.				CALIPER, PT.				CONCORA TEST, P.S.I.			
	MACHINE DATA				MACHINE DATA				MACHINE DATA				MACHINE DATA			
CODE	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	7.3	6.7	109.0	121.7	27.5	27.7	99.3	103.4	10.2	10.5	97.1	103.0	36.6	36.8	99.4	93.6
B1	9.0	9.2	97.8	150.0	25.9	25.8	100.4	97.4	10.7	10.8	99.1	108.1	41.4	39.4	105.1	105.9
C1	5.2	5.0	104.0	86.7	26.3	26.2	100.4	98.9	11.0	11.1	99.1	111.1	38.5	39.1	98.5	98.5
D1	5.9	5.6	105.4	98.3	26.1	26.4	98.9	98.1	9.0	9.1	98.9	90.9	35.9	38.3	93.7	91.8
E1	6.2	6.2	100.0	103.3	26.7	26.6	100.4	100.4	9.0	9.2	97.8	90.9	49.5	48.3	102.5	126.6
F1	6.3	6.3	100.0	105.0	27.3	27.2	100.4	102.6	10.3	10.0	103.0	104.0	42.8	43.0	99.5	109.5
G1	6.9	6.9	100.0	115.0	26.2	26.2	100.0	98.5	10.5	10.9	96.3	106.1	34.2	32.3	105.9	87.5
H1	7.1	7.2	98.6	118.3	26.9	26.5	101.5	101.1	9.9	10.4	95.2	100.0	39.3	39.4	99.7	100.5
I1	5.8	6.2	93.5	96.7	26.9	26.2	102.7	101.1	—				39.1	38.3	102.1	100.0
J1	6.5	6.8	95.6	108.3	26.2	26.3	99.6	98.5	9.0	9.2	97.8	90.9	37.8	38.2	99.0	96.7
K1	6.3	6.2	101.6	105.0	26.0	26.2	99.2	97.7	10.5	10.7	98.1	106.1	33.9	36.5	92.9	86.7
L1	6.9	6.6	104.5	115.0	26.4	26.5	99.6	99.2	—				38.3	38.6	99.2	98.0
M1	5.1	5.2	98.1	85.0	26.8	26.5	101.1	100.8	9.5	9.5	100.0	96.0	38.2	37.0	103.2	97.7
N1	6.3	6.0	105.0	105.0	26.0	26.4	98.5	97.7	9.4	9.3	101.1	94.9	38.5	39.8	96.7	98.5
O1	6.9	7.0	98.6	115.0	25.9	25.8	100.4	97.4	10.3	10.2	101.0	104.0	43.8	43.6	100.4	112.0
P1	6.4	6.2	103.2	106.7	26.4	26.5	99.6	99.2	10.1	10.2	99.0	102.0	40.0	39.3	101.8	102.3
Q1	3.9			65.0	27.1			101.9	9.2			92.9	36.1			92.3
R1	5.5	5.3	103.8	91.7	26.2	26.4	99.2	98.5	9.5	9.1	104.4	96.0	34.9	37.0	94.3	89.2
S1	6.8	6.9	98.6	113.3	26.3	26.3	100.0	98.9	10.9	11.4	95.6	110.1	34.8	34.1	102.0	89.0
T1	6.8	6.4	106.2	113.3	26.4	26.3	100.4	99.2	10.0	10.7	93.4	101.0	40.2	41.0	98.0	102.8
U1	3.8	3.9	97.4	63.3	27.7	27.9	99.3	104.1	9.1	9.1	100.0	91.9	37.0	37.4	98.9	94.6
V1	3.6	3.9	92.3	60.0	27.1	27.1	100.0	101.9	9.1	9.1	100.0	91.9	36.2	36.2	100.0	92.6
W1	5.7	5.1	111.8	95.0	26.5	26.4	100.4	99.6	9.5	9.5	100.0	96.0	37.4	38.1	98.2	95.6
X1	5.7	5.6	101.8	95.0	26.3	26.2	100.4	98.9	9.7	9.3	104.3	98.0	44.0	43.2	101.8	112.5
Y1	3.8	4.5	84.4	63.3	26.3	26.5	99.2	98.9	9.9	9.8	101.0	100.0	40.9	38.9	105.1	104.6
Z1	7.2	6.9	104.3	120.0	26.5	26.5	100.0	99.6	10.4	10.2	102.0	105.0	40.1	40.3	99.5	102.6
A2	5.9	5.5	107.3	98.3	27.3	27.4	99.6	102.6	9.5	9.7	97.9	96.0	38.3	40.0	95.8	98.0
B2	6.2	6.3	98.4	103.3	26.3	26.9	97.8	98.9	9.1	9.2	98.9	91.9	37.0	38.0	97.4	94.6
C2	6.7	6.1	109.8	111.7	25.9	26.2	98.8	97.4	10.6	10.9	97.2	107.1	33.9	38.1	89.0	86.7
D2	3.8	4.0	95.0	63.3	27.5	27.5	100.0	103.4	10.0	9.7	103.1	101.0	36.6	36.1	101.4	93.6
E2	6.1	5.8	105.2	101.7	26.1	26.2	99.6	98.1	9.5	9.6	99.0	96.0	40.8	42.1	96.9	104.3
F2	5.9	6.0	98.3	98.3	26.2	26.3	99.6	98.5	9.9	10.2	97.0	100.0	35.4	35.4	100.0	90.5
G2	6.3	6.1	103.3	105.0	26.0	26.3	98.8	97.7	9.3	9.2	101.1	93.9	38.4	39.8	96.5	98.2
H2	5.3	5.4	98.1	88.3	26.7	26.6	100.4	100.4	10.0	9.2	108.7	101.0	38.3	38.2	100.3	98.0
I2	5.9	6.5	90.8	98.3	26.4	26.4	100.0	99.2	—				37.8	39.6	95.4	96.7
FKI DATA																
CUR. AV.	6.0				26.5				9.8				38.4			
CUM. AV.	6.0				26.6				9.9				39.1			
IND. *D	100.0				99.6				99.0				98.2			

NOTE- NOTES A, B, C, AND D, ARE GIVEN IN APPENDIX.

TABLE III

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

AUGUST, 1973

	MOISTURE CONTENT, PERCENT				ADJ. BASIS WT.,*A LB./ M SQ. FT.				CALIPER, PT.				CONCORA TEST, P.S.I.			
	MACHINE DATA				MACHINE DATA				MACHINE DATA				MACHINE DATA			
CODE	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	7.2	6.8	105.9	120.0	27.9	27.7	100.7	104.9	10.2	10.4	98.1	103.0	36.6	36.7	99.7	93.8
B1	9.1	9.1	100.0	151.7	25.7	25.8	99.6	96.6	10.7	10.8	99.1	108.1	39.6	39.8	99.5	101.5
C1	5.1	5.0	102.0	85.0	26.3	26.2	100.4	98.9	11.0	11.1	99.1	111.1	38.8	39.0	99.5	99.5
D1	—	5.6			—	26.3			—	9.1			—	38.0		
E1	6.4	6.2	103.2	106.7	26.9	26.6	101.1	101.1	9.0	9.1	98.9	90.9	49.3	48.5	101.6	126.4
F1	6.1	6.3	96.8	101.7	27.3	27.2	100.4	102.6	10.4	10.0	104.0	105.0	44.1	43.0	102.6	113.1
G1	7.0	6.9	101.4	116.7	25.9	26.2	98.8	97.4	10.9	10.8	100.9	110.1	34.8	32.5	107.1	89.2
H1	7.3	7.2	101.4	121.7	26.4	26.5	99.6	99.2	9.7	10.3	94.2	98.0	38.3	39.4	97.2	98.2
I1	5.6	6.2	90.3	93.3	26.6	26.3	101.1	100.0	—				38.1	38.4	99.2	97.7
J1	6.5	6.8	95.6	108.3	26.2	26.3	99.6	98.5	9.0	9.2	97.8	90.9	37.2	38.1	97.6	95.4
K1	6.5	6.2	104.8	108.3	26.4	26.1	101.1	99.2	10.4	10.7	97.2	105.0	33.1	36.1	91.7	84.9
L1	7.5	6.6	113.6	125.0	26.1	26.5	98.5	98.1	—				37.5	38.6	97.2	96.2
M1	5.3	5.2	101.9	88.3	26.4	26.6	99.2	99.2	9.3	9.5	97.9	93.9	37.3	37.6	99.2	95.6
N1	6.1	6.1	100.0	101.7	26.3	26.3	100.0	98.9	9.5	9.3	102.2	96.0	37.4	39.5	94.7	95.9
O1	6.9	6.9	100.0	115.0	26.0	25.8	100.8	97.7	10.3	10.2	101.0	104.0	43.8	43.6	100.4	112.3
P1	6.1	6.2	98.4	101.7	26.6	26.5	100.4	100.0	10.5	10.2	102.9	106.1	39.0	39.5	98.7	100.0
Q1	5.5	3.9	141.0	91.7	27.2	27.1	100.4	102.2	9.3	9.2	101.1	93.9	36.2	36.1	100.3	92.8
R1	5.7	5.3	107.5	95.0	26.3	26.4	99.6	98.9	9.5	9.2	103.3	96.0	33.6	36.7	91.6	86.2
S1	6.8	6.8	100.0	113.3	26.3	26.3	100.0	98.9	10.9	11.4	95.6	110.1	34.8	34.2	101.8	89.2
T1	6.7	6.5	103.1	111.7	26.3	26.3	100.0	98.9	11.0	10.6	103.8	111.1	39.6	40.9	96.8	101.5
U1	3.8	3.8	100.0	63.3	27.8	27.9	99.6	104.5	9.3	9.1	102.2	93.9	37.5	37.4	100.3	96.2
V1	3.5	3.9	89.7	58.3	27.2	27.1	100.4	102.2	9.1	9.1	100.0	91.9	36.1	36.2	99.7	92.6
W1	5.5	5.2	105.8	91.7	26.2	26.4	99.2	98.5	9.6	9.5	101.0	97.0	37.2	38.0	97.9	95.4
X1	5.9	5.6	105.4	98.3	26.2	26.2	100.0	98.5	9.6	9.4	102.1	97.0	43.4	43.4	100.0	111.3
Y1	3.6	4.3	83.7	60.0	26.3	26.5	99.2	98.9	9.6	9.9	97.0	97.0	38.9	39.3	99.0	99.7
Z1	7.1	6.9	102.9	118.3	26.6	26.5	100.4	100.0	10.4	10.2	102.0	105.0	40.2	40.2	100.0	103.1
A2	5.7	5.6	101.8	95.0	27.1	27.4	98.9	101.9	9.3	9.7	95.9	93.9	37.4	39.7	94.2	95.9
B2	6.1	6.2	98.4	101.7	26.5	26.8	98.9	99.6	9.1	9.1	100.0	91.9	38.3	37.9	101.0	98.2
C2	6.2	6.2	100.0	103.3	26.3	26.2	100.4	98.9	10.7	10.8	99.1	108.1	36.4	37.4	97.3	93.3
D2	3.5	3.9	89.7	58.3	27.6	27.5	100.4	103.8	9.6	9.7	99.0	97.0	35.7	36.2	98.6	91.5
E2	6.2	5.8	106.9	103.3	26.2	26.2	100.0	98.5	9.6	9.6	100.0	97.0	42.0	41.9	100.2	107.7
F2	5.8	6.0	96.7	96.7	26.1	26.3	99.2	98.1	9.9	10.1	98.0	100.0	35.0	35.4	98.9	89.7
G2	6.0	6.1	98.4	100.0	26.2	26.2	100.0	98.5	9.4	9.3	101.1	94.9	38.0	39.5	96.2	97.4
H2	5.5	5.4	101.8	91.7	26.6	26.6	100.0	100.0	9.7	9.4	103.2	98.0	36.9	38.2	96.6	94.6
I2	6.2	6.4	96.9	103.3	26.4	26.4	100.0	99.2	—				39.6	39.3	100.8	101.5
FKI DATA																
CUR. AV.	6.0				26.5				9.9				38.3			
CUM. AV.	6.0				26.6				9.9				39.0			
IND. *D	100.0				99.6				100.0				98.2			

NOTE- NOTES A, B, C, AND D, ARE GIVEN IN APPENDIX.

TABLE IV

DATA ON CONDITIONING AND TESTING ENVIRONMENTS

JULY-AND AUGUST, 1973

Code	Conditioning Environment: Are Quality Samples Conditioned Before Testing?	Procedure: Time	Procedure: R.H., %	Procedure: Temp., °F.	Testing Environment: Are Quality Samples Tested Under Controlled Conditions of Temperature & Humidity?
A1	No	--	--	--	Yes: 73 ± 2°F.; 50 ± 2% R.H.
B1	No	--	--	--	Yes: 73 ± 2°F.; 50 ± 2% R.H.
C1	No	--	--	--	Yes: 73 ± 1°F.; 50 ± 1% R.H.
D1	No	--	--	--	No
E1	No	--	--	--	No
F1	Yes	20 min.	--	--	Yes: 73 ± 2°F.; 50 ± 2% R.H.
G1	No	--	--	--	Yes: 73 ± 2°F.; 50 ± 2% R.H.
H1	No	--	--	--	No
I1	No	--	--	--	No
J1	No	--	--	--	Yes: 76 ± 5°F.; 55 ± 6% R.H.
K1	No	--	--	--	No
L1	No	--	--	--	No
M1	No	--	--	--	No
N1	No	--	--	--	Yes: 73 ± 3.5°F.; 50 ± 2% R.H.
O1	No	--	--	--	No
P1	No	--	--	--	Yes: 73 ± 2°F.; 50 ± 5% R.H.
Q1	Yes	20 min.	--	--	Yes: 73 ± 2°F.; 50 ± 2% R.H.
R1	No	--	--	--	No
S1	No	--	--	--	Yes: 73 ± 2°F.; 50 ± 2% R.H.
T1	No	--	--	--	Yes: 74 ± 1°F.; 50 ± 1% R.H.
U1	No	--	--	--	Yes: 73 ± 3°F.; 50 ± 2% R.H.
V1	No	--	--	--	No
W1	No	--	--	--	No
X1	No	--	--	--	Yes: 73 ± 3°F.; 50 ± 2% R.H.
Y1	No	--	--	--	No
Z1	No	--	--	--	Yes: 72 ± 2°F.; 50 ± 2% R.H.
A2	No	--	--	--	Yes: 73 ± 2°F.; ambient
B2	No	--	--	--	Yes: 73 ± 3°F.; 50 ± 2% R.H.
C2	No	--	--	--	No
D2	No	--	--	--	No
E2	No	--	--	--	No
F2	Yes	20 min.	72	50	Yes: 72 ± 2°F.; 50 ± 2% R.H.
G2	No	--	--	--	Yes: 73 ± 3.5°F.; 50 ± 2% R.H.
H2	No	--	--	--	Yes: 73 ± 3.5°F.; 50 ± 2% R.H.
I2	No	--	--	--	Yes: 72 ± 2°F.; 50 ± 5% R.H.

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.

THE INSTITUTE OF PAPER CHEMISTRY

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APPENDIX

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

Notes A, B, C, and D, 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 FKI index. It should be stressed that each formula is applicable only to a specific physical property of a specific grade weight of linerboard.

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

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

Note C: Machine index (%) = $\left[\frac{\text{Current machine average}}{\text{Cumulative FKI average}} \right] \cdot 100$ where

$$\text{Cumulative FKI average} = \sum \frac{\text{CFKIA's}^{b} \text{ for previous 12 months excluding CFKIA for current month}}{12}$$

Note D: FKI index (%) = $\left[\frac{\text{Current FKI average}}{\text{Cumulative FKI average}} \right] \cdot 100$ where

$$\text{Current FKI average} = \sum \frac{\text{CMA's}^{a} \text{ for current month for all machines}}{\text{Number of machines}}$$

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