

AUDITING YOUR CORRUGATOR FOR MAXIMIZED COMBINED BOARD STRENGTH

a preliminary survey

Before beginning an extensive benchmarking study of your corrugator or your sheet feeders' corrugator you may want to do a team exercise and take one sheet of corrugated and conduct the test we discussed in the e learning module. It's an easy start!

Below is chart for you to compare your results to temperature targets we discuss in the presentation. Record the ranges in temperatures at each station remembering that actual reading should be less than 10 degrees across the corrugator. Actual reading are sensitive to porosity, density, fibre fractionation, and chemical additions. All are degrees Fahrenheit.

Corrugator locations	Target	Actual: High-Low
Singleface liner existing the preheater	180 ⁰	
Medium entering the corrugating rolls	185 ⁰	
Singleface web liner existing the corrugating rolls	260 ⁰	
Singleface web at the flute tips existing the corrugating rolls	200 ⁰	
Doubleback liner entering the hot plates	195 ⁰	
Singleface web liner entering the hot plates	200 ⁰	
Doubleback liner exiting the hot plates	260 ⁰	
Adhesive in the glue pans	100 ⁰	