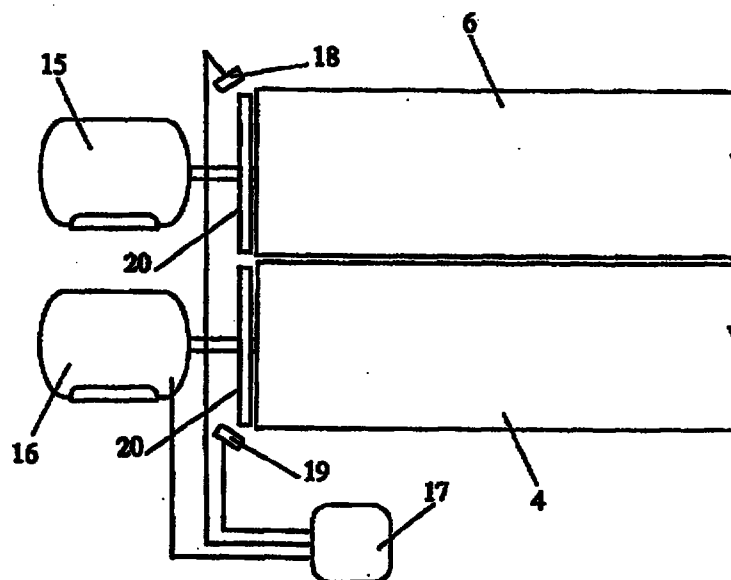


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(54) Title: BONDING TWO CORRUGATED MEDIUMS AT FLUTE TIPS ENSURING ACCURATE ALIGNMENT ✓**(57) Abstract**

This invention relates to improved methods and apparatus for forming paper board structures in which two corrugated mediums are bonded together at their flute tips. The apparatus comprises: two register rolls (4, 6) for ensuring that the mediums are brought into precise flute tip to flute tip alignment for bonding; dependent electric motors to drive the register rolls in which one roll (6) is driven by a reference motor (15) and the second register roll (4) is driven by a follower motor (16); location sensing devices (18, 19) associated with each register roll (4, 6) to measure a value related to the location of a position on the periphery of each register roll; control means (17) which compares the measured values for each register roll and if necessary adjusts the voltage or current of the follower motor (16) to maintain alignment of the flute tips of the two mediums.