

Description

This invention relates to a method of forming a corrugated paper board panel according to the preamble of claim 1 which is based on FR—A—393 156.

The corrugated box plays a major role in modern physical distribution systems and the top to bottom compression strength of the box under sustained loads is one of the main functional requirements.

Conventional corrugated paper board consists of alternate layers of corrugated medium (flutes) and liners. Reference is made to the following types of construction.

Single face—one layer of flutes adhered to one liner.

Single wall—one layer of flutes adhered between two liners.

Double wall—two layers of flutes adhered between three liners.

The conventional flute boards are given their usual designations and have the characteristics:

Flute type	Flutes/metre	Flute height mm
A	110—120	4.0—4.8
C	127—140	2.8—3.7
B	150—167	1.8—2.5
E	295—327	1.5—1.8

The work of McKee [McKee, R. C., Gander, J. W. and Wachuta, J. R., "Compressive strength formula for corrugated boxes", Paperboard Packaging 48 (8): 149 (1963)], using the principles of engineering mechanics, led to a simplified compression formula that has greatly influenced the last two decades' development of linerboards and corrugating mediums. This formula is based on an empirical relationship between critical buckling loads and ultimate failure loads.

The most important combined paper board property influencing top to bottom compression strength was shown to be edge compression strength in the direction parallel to the flutes. The flexural stiffness properties, in both directions, were also shown to be of importance. These simple guidelines to box performance were highlighted to concentrate attention on the most important aspects of board quality in achieving maximum compression strength, and these guidelines have served the industry well.

However, it is generally recognised that actual box performance can differ significantly from that predicted by the McKee equation, particularly when changes in furnish or the balance of board properties are involved, even though the simple guidelines are maintained.

This invention is predicated on the discovery that the resistance to local buckling of the liner on the inside of the box is a better measure of the critical failure property of the board than edge compression strength. More correctly, it is the liner on the concave side of the buckled (but not yet failed) box panel. Because the contents of the box prevent inward buckling, this is normally the inside liner. It follows that thicker boards of unconventional construction could have higher compression strength to board weight ratios than would have been expected from the McKee formula.

To this end the present invention provides a method of forming a corrugated paperboard panel having two inner corrugated layers bonded at their flute tips wherein two strips of paperboard are separately passed over corrugating rollers to form two fluted layers, adhesive is applied to the peaks of at least one of the fluted layers and the fluted layers are aligned and brought into contact to bond the two fluted layers together at the peak of the flutes characterised by directly supporting at least one of the fluted layers until they are securely bonded together to maintain the alignment of the flute peaks and subsequently bonding two flat sheets to the fluted layers to form the two outer liners.

This method is based on the discovery that by increasing the paper board thickness and concentrating the board's strength in the outer liners gives the best improvement in the compression to weight ratio. Conventional double wall board achieves this increased thickness aim, but the centre liner contributes nothing towards bending stiffness and inside liner buckling strength. Accordingly the elimination of the centre liner further improves the compression to weight ratio.

Two possible methods of construction of corrugated paper boards of this invention are disclosed in Figures 1 and 2.

Figures 3, 4 and 5 illustrate test results comparing the corrugated board made by the method of this invention with the prior art.

Figure 6 illustrates a schematic arrangement for manufacturing the corrugated board.

Two possible constructions are shown in Figures 1 and 2 and have been called the X-flute structure.

A computer model was used to calculate the expected compression strength of a structure consisting of four panels of corrugated board joined by creases at the vertical edges. Such a structure is termed a collar and differs from a box in that the horizontal edges of the vertical panels are assumed to be hard and inflexible rather than the relatively soft creased horizontal edges of the panels of a box. The collar assumed for this exercise was 390 mm long by 390 mm wide by 290 mm high. The boards compared were

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conventional single wall with two 215 g/m² liners, one 117 g/m² corrugating medium and an X-flute board with two 130 g/m² liners and two 117 g/m² corrugating mediums. Total grammage of both boards was the same at 600 g/m².

Results predicted are shown in Table 1.

TABLE 1

Structure	Compression strength, N
Standard board	5290
X-flute	8090

Based on these predicted results, which show about a 50 percent improvement in compression strength for the X-flute construction, laboratory samples of X-flute board were made up into collars for compression testing and confirmation of the predicted results.

The board components for X-flute construction were two, single faced boards using 140 g/m² liners and 117 g/m² of conventional "C" flute mediums. These were carefully glued together, flute tip to flute tip.

Two conventional commercial boards were selected with grammages close to the made up experimental X-flute structure. The first of these comprised 2×240 g/m² liners and a 117 g/m² conventional "A" flute, and the second 2×293 g/m² liners and a 117 g/m² conventional "C" flute. The X-flute and the conventional board were made into collars 400 mm long by 400 mm wide by 270 mm high.

Test results are shown in Table 2.

TABLE 2

Test property	Experimental board	Conventional boards	
	"X" Flute	"A" Flute	"C" Flute
Liners, g/m ²	140	240	293
Medium(s), g/m ²	2×117	117	117
Combined board grammage, g/m ²	673	651	728
Combined board thickness, um	7550	4620	4340
Edge crush test (ECT), kN/m	6.5	5.9	7.3
Board hardness, kPa*	91	47	113
Collar compression, N	7870	4130	5340

*Hardness is a measure of the resistance of the fluted structure to crushing perpendicular to the plane of the sheet.

The collar compression tests as shown in this table confirm the 50 percent improvement in top to bottom compression of the X-flute construction predicted by the model. This result would not have been predicted by the McKee formula.

In a further series of test laboratory samples of X-flute and conventional single wall and double wall boards were made in the laboratory from various component combinations. Some combinations were made into collars, some into boxes, some into both collars and boxes.

Selected test results on these materials are shown in Tables 3 and 4 and Figures 3, 4, and 5. The bending stiffness and buckling load measurements were made on beams 75 mm wide loaded at the centre of a 230 mm wide span.

The figures listed in brackets in Tables 3 and 4 are the percentage advantage of X-flute per unit of corrugated board weight compared with the conventional material.

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TABLE 3

X-flute versus conventional single wall corrugated board
C-flute and 117 g/m² corrugating medium used throughout

	Single wall	X Flute 1	X Flute 2
Liners, g/m ²	210	117	140
Total board components, g/m ²	590	573	620
Collar compression strength, N	4812	Not avail.	7254 (43%)
Box compression strength	3999	4744 (22%)	Not avail.
Bending stiffness, Nm			
Machine direction	9.1	9.7 (10%)	12.5 (31%)
Cross direction	4.6	7.4 (66%)	8.6 (78%)

TABLE 4

X-Flute versus conventional double wall corrugated board
C Flute and 117 g/m² medium used throughout

	Double wall	X-Flute
Outside liners, g/m ²	155	210
Inside liners, g/m ²	117	Not applic.
Total board components	766	759
Collar compression strength, N	9392	10190 (10%)
Box compression strength, N	6589	7425 (14%)
Bending stiffness, Nm		
Machine direction	13.4	24.7 (86%)
Cross direction	11.4	15.9 (41%)
Buckling load, N		
Machine direction	11.1	24.1 (119%)

For these materials the advantage of X-flute over conventional single wall board in collar compression strength to board weight ratio was between 40 and 50%. The X-flute advantage over single wall in box compression, although less than in collar compression, was over 20%.

Compared with conventional double wall boards, X-flute had 10 to 15% higher collar and box compression strength to board weight ratios.

A disadvantage of conventional double wall board at low board weights is that the need to provide a centre liner means that the outside liners must be below in weight and the board is therefore susceptible to failure by buckling of these outside liners between the flute tips. The test results for MD buckling load shown in Table 4 and Figure 5 show the large advantage of X-flute in this respect. X-flute therefore has a lower combined board grammage limit before the liners become susceptible to failure by buckling between the flute tips.

Further advantages of X-flute compared to double wall board are that it requires one less component and one less glue line.

This invention is not restricted to the combining tip to tip of any of the conventional A, B, C or E flute shapes, but also covers the combining of unconventional flute structures such as flat tip flutes. Figure 2 illustrates such a flat tip flute structure.

The main thrust of the invention is to provide a means of increasing corrugated board thickness and of

concentrating strength on the outer liners without introducing structural weaknesses such as low flute crushing strength, low flute shear strength or excessive flute tip to flute tip distances.

A method of forming an X-flute construction is illustrated in Figure 6. The two mediums are corrugated in conventional corrugating rolls and combined prior to the liner being attached.

5 The liner 10, the liner 11 and the centre mediums 12 and 13 are brought together to form the X-flute board 14.

The medium 12 is passed into the labyrinth corrugating rollers 15 and 17 to form the corrugated medium which is held to roller 17 by vacuum box 19.

10 Medium 13 similarly passes into the labyrinth between corrugating roller 16 and 18 to form the corrugating medium which is held to roller 18 by vacuum box 20 and is coated with glue by applicator station 21.

The mediums 12 and 13 are bonded together at the contact point between the corrugating rollers 17 and 18 which are synchronized to ensure bonding at the tips of the flutes. Each of the rollers 15, 16, 17 or 18 may be heated to assist flute formation and glue bonding.

15 The combined mediums 12 and 13 are then transferred to the synchronised corrugated roller 24 under the influence of the vacuum box 25. Glue is applied to the fluted medium by station 27.

The liner 11 is fed over roller 28 and onto the roller 24 to bond the combined mediums 12 and 13 to the liner 11. Drying of the glue while the liners 11 and mediums 12 and 13 are still on roller 24 can be assisted by application of energy from an external heat or microwave source.

20 The liner 10 is passed onto the belt 35 which is run over rollers 36 and 37. This enables the top liner 10 to be bonded to the combined mediums 12 and 13 which have been coated with glue at applicator station 34. The thus formed corrugated board is fed between belts 29 and 35 and withdrawn. The belt 29 runs on rollers 30 and 31 and provides counter pressure to belt 35. Energy to dry the final adhesive application can be applied either at the belts 29 and 35 or subsequently.

25 Any or all of the components may be preheated, moistened or pretreated before entering the process to assist forming and bonding or impart special properties to the made up board.

The corrugating roll 24 may require only machined grooves rather than fully shaped corrugations. Since this roll is not required to form the corrugations, it does not have to be made from hardened or chromium plated steel as do the corrugating rollers 15, 16, 17 and 18. A non-metallic material may be 30 suitable.

In this basic method of forming X-flute, the roll 24 in Figure 6 may be replaced by a synchronised belt.

Another variation of this basic method would be to dispense with roll 24 in Figure 6 and join the first liner 11 to the two bonded together mediums 12 and 13 while these are retained in corrugating roller 17.

35 1) The X-flute construction achieves greater board thickness combined with greater concentration of strength in the outer liners than conventional corrugated forms.

2) The board of this invention fulfills the other structural requirements of a fluted structure, namely adequate resistance to flute crushing, adequate shear stiffness and acceptably small flute tip to flute tip distances.

40 3) The X-flute structure provides 20—50% higher box and collar compression strength to board weight ratios than comparable conventional single wall boards.

4) The X-flute structure provides over 10% higher box and collar compression strength to board weight ratios than comparable conventional double wall boards.

5) The X-flute board has 10—90% higher bending stiffness per unit board weight than conventional boards, depending on direction of testing and board construction.

45 6) The X-flute board has up to 120% better resistance to buckling load per unit board weight than conventional double wall board.

Claim

50 A method of forming a corrugated paperboard panel having two inner corrugated layers bonded at their flute tips wherein two strips of paperboard are separately passed over corrugating rollers to form two fluted layers, adhesive is applied to the peaks of at least one of the fluted layers and the fluted layers are aligned and brought into contact to bond the two fluted layers together at the peak of the flutes characterised by directly supporting at least one of the fluted layers until they are securely bonded together 55 to maintain the alignment of the flute peaks and subsequently bonding two flat sheets to the fluted layers to form the two outer liners.

Patentanspruch

60 Verfahren zum Herstellen einer Wellpappenplatte mit zwei inneren gewellten Schichten, die an ihren Wellenspitzen miteinander verbunden sind, wobei zwei Streifen aus Pappe getrennt über geriffelte Walzen zur Ausbildung von gewellten Schichten geführt werden, Klebstoff auf die Spitzen von mindestens einer der gewellten Schichten aufgetragen sowie die gewellten Schichten ausgerichtet und miteinander in Kontakt gebracht werden, um die beiden gewellten Schichten an den Wellenspitzen miteinander zu 65 verbinden, dadurch gekennzeichnet, daß mindestens eine der gewellten Schichten direkt unterstützt wird.

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bis sie sicher miteinander verbunden sind, um die Ausrichtung der Wellenspitzen aufrechtzuerhalten, und anschließend zwei flache Platten mit den gewellten Schichten verbunden werden, um die zwei Außenschichten zu bilden.

5 Revendication

Procédé pour réaliser une plaque de carton ondulé présentant deux couches intérieures ondulées, liées par les sommets de leurs nervures, procédé selon lequel, deux bandes de carton sont passées séparément sur des cylindres ondateurs pour la formation de deux couches nervurées, un adhésif est appliqué sur les crêtes d'au moins l'une des couches nervurées et les couches nervurées sont alignées et amenées en contact pour être liées l'une à l'autre au niveau des crêtes de leurs nervures, caractérisé en ce que l'on supporte directement au moins l'une des couches nervurées jusqu'à ce que celles-ci soient fermement liées ensemble pour maintenir l'alignement des crêtes des nervures et l'on assemble ensuite deux feuilles plates aux couches nervurées pour former les deux revêtements extérieurs.

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