

Courrugation Technical Guidlines

RCT → RING CRUSH TEST

- It is the measure of force required to crush a strip of paper (cut in a predefined size) and is tested in the machine by crushing.
- It is in the shape of a ring.
- Typical measuring unit – KN/m

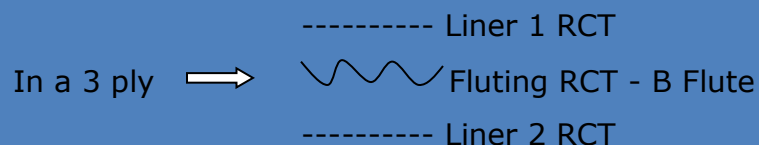
Examples of market available RCT values:

BF	GSM	MILL	TYPICAL RCT VALUES
22/24	180	Subham	1.70 to 1.80 KN/m
18	150	Devikiran	0.80 to 0.85 KN/m
18	180	Devikiran	1.10 to 1.20 KN/m

ECT → EDGE CRUSH TEST

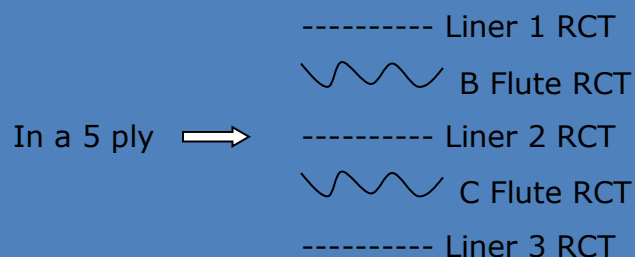
- It is a measure of the compressive force required to crush a rectangular pieces of corrugated board of predefined size. Units (KN/m).
- It can also be arrived at theoretically by considering factors such as RCT of each paper in the board, flute height and no of ply in the board.

For example:



Take up factor for B flute

$$3 \text{ ply ECT} = \text{Liner 1 RCT} + 1.35 \times \text{Fluting RCT} + \text{Liner 2 RCT}$$



Take up factor B - flute - 1.35
(Narrow)

Take up factor C - flute - 1.45

5 ply ECT = Liner 1 RCT + 1.35 x B Flute RCT + Liner 2 RCT + 1.45 x C Flute RCT
+ Liner 3 RCT

BCT → Box Compression Test

- It is a measure of compression strength / force required to crush the box.
- It can also be measured through the following formula.

$$\text{BCT} = \text{ECT} \times 0.76 \times \frac{\sqrt{(L + W) \times 2 \times \text{Caliper of board (in mm)}}}{\text{Perimeter of box}}$$

Height of box is irrelevant.

Caliper of board for a B+C flute combination is 7 mm.

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