



Board Quality Problems on the Doubleface Side

Hot Plate Section Article 2

In the last article, we indicated there would be a series of articles focused on board defects which occur on the DB side of the sheet. This is the second article of that series.

As we discussed, not all defects on the DB side are bonding-related. We will also cover warp, wrinkles, peelers, and other defects on the DB side.

One of the most common issues found by our technical specialists are problems coming from problems with the inability to properly hold the flute tip in “intimate” contact with the DB liner through the bonding process. During the bonding process, once you have applied starch to the flute tip at the glue machine, you must next bring the flute tips into contact with the bonding side of the DB liner. Once you do so, you must hold them in contact throughout the bonding process. Any disturbance in this area can and will result in one or more types of DB bonding defects.

First, let’s discuss the pressure system (or ballast) utilized to bring the flute tips in contact and then hold them in contact. The next section will discuss the different types of hot plates and temperatures.

Most machines have a DB belt driven by pulleys that pull the DB liner off the roll stands and the web off the bridge. This belt (in most cases) is in contact with the SF side of the web, and the weight of the belt provides a portion of the pressure or ballast to hold the flute tips in contact. Above the belt are the pressure rollers, shoes, plates, air plenum, airbags, etc., which exert downforce on the belt and thus onto the web. This adds more downforce on the flute tip to the DB liner. This is a critical setting and needs to be consistent across the width of the machine for all paper widths. Failure to do so results in defects like loose edges, brown glue lines, zipper board, low pin adhesion, etc...

For more detail on the impact of your belt and pressure system, please contact one of CCI's Technical Specialists at 800-669-7589 or solutions@corrugatedchemicals.com.

“Stay tuned” for part 3 of this series, in which we will cover Hot Plates and Temperatures.



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