

ADVANCED ADHESIVES REPORT

YOUR CORRUGATING NEWSLETTER FROM HARPERLOVE

November 2017

Troubleshooting Starch Application

Producing flat, dry, well-bonded corrugated requires proper and consistent starch application. Achieving optimal starch application depends on the glue roll cell condition, proper gap settings, and roll alignment. If the glue roll cells aren't clean and in good condition or if the gaps between rolls aren't parallel and correct, you can expect bonding issues, warp, delamination, and excessive starch consumption.

Glue Roll Condition

Glue rolls need to be clean and free of debris, such as calcium build-up or dried starch in the cells. The cells also need to be in good physical condition. Most traditional cells are only 0.009" deep, and they can be damaged from impacting the corrugating roll. Achieving an even and consistent glue pattern requires that the glue cells be consistent across the full web. Cells that are worn or damaged can cause uneven starch application, which leads to "S" warp and bonding issues across the web. As you can see below, the first picture shows good cells with sharp profiles; the second picture shows worn cells; and

the third picture shows cells that have been destroyed from encountering the corrugator roll. The cells can also be damaged at the doublebacker if the contact/hold-down bar and rider roll are not set correctly and impact the glue roll. Most contact bars should be set 0.060" from the bottom of the shoes to the top of the glue roll. If the plant runs micro flute then the shoes should be set at 0.030" to 0.040".

As you can see, as the cell walls start to wear the cells become shallower. The starch will then start to film on top of the glue roll instead of filling the cells. This leads to improper and inconsistent amounts of starch being applied to the medium.

Furthermore, worn cells increase the tendency of the starch to sling off the glue roll onto the medium, which leads to post warm issues and wet board.

Gap Settings

The gap between the glue roll and corrugator roll must be set correctly. If this gap is set too wide (i.e., much wider

than the thickness of the medium), the operators will need to add more starch to be able to contact the medium. When this happens, the starch is more prone to sling off the roll onto the medium resulting in board quality issues. If this gap is too close it can cause fracturing of the flute tips which will result in lower pins and ECT values. The glue roll to corrugator roll gap should be changed every time the grade of medium changes.

As a glue roll wears, operators generally will change the gap settings to increase



Harper Love Adhesives Manual

Peipei Pang



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