

What's new is theme of Corrugated Containers Conference's workshops and presentations

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The 1989 Corrugated Containers Conference, on Oct. 29-Nov. 2, at the Disneyland Hotel, Anaheim, Calif., attracted 790 registrants to its sessions.

There were, in addition, 193 exhibitors for the Table Top Trade Fair, and 157 spouses registered for the spouses' program. During the conference, 42 companies had hospitality suites open, and a great deal of information about the sessions and other matters related to corrugating was exchanged during these social gatherings.

Edwin J. Willard, corporate manager of production systems, Longview Fibre Co., Oakland, Calif., was presented the Division Award during the conference. The award recognizes his outstanding contributions to corrugating technology. He also received the Harry J. Bettendorf Prize, which includes a \$1,000 award. The prize is funded by a gift to TAPPI by the late Harry J. Bettendorf and is awarded to the recipient of the Corrugated Containers Division Award.

Willard has distinguished himself through his leadership, initiative, and creativity in bringing about improvements in the manufacturing process during the past 40 years. His research, development, and collaborative efforts with the industry have substantially raised productivity, saved raw materials, and opened new markets. He has contributed to developments such as automatic corrugator delivery, the interface of office order entry computer systems with direct on-line corrugator dry end functions, corrugator web alignment and wet end control, and "big box lines."

Willard's patents include "Horizontal Conveyor Load Moving Approached," "Apparatus for Assembling a Batten Mounted Package," "Apparatus for Overturning Stacked Sheet Material," and "Lead-in Table for Paperboard Slitting and Transverse Cut-off Machinery." He has also written a number of technical papers and reported on his work at TAPPI conferences and Local Section meetings.

First Corrie

During the 1989 conference, the first presentation was made of the Corrie Award, which recognizes someone who has devised simple solutions to daily plant problems. The winner was Robert A. Haswell, process engineering manager, Jefferson Smurfit Corp., Louisville, Ky.

Haswell won the award for devising an alignment system for hanging rolls of liner on a corrugator.

Robb Trippsmith, Jefferson Smurfit Corp., the outgoing chairman of the division, was given a plaque by the division in recognition of his service.

Edwin J. Willard (middle), Longview Fibre Co., shows the Corrugated Containers Division Award medallion and plaque he received from Philip G. Saunders (left), Container Graphics Corp., TAPPI Board representative, and Robb Trippsmith, Jefferson Smurfit Corp., outgoing division chairman.



Outgoing chairman Certificates of Appreciation were also given to the outgoing chairmen of the division's committees. These were: William C. "Butch" Bryant, Jr., Weyerhaeuser Paper Co., Corrugated Board Technical Service; Dale K. Foote, Menasha Corp., Engineering; Richard A. Surber, Inland Container Corp., Fiberboard Shipping Container Testing; Douglas J. Muller, Haire Machinery Corp., Human Resource Development Corrugated; John F. Swant, Liberty Diversified Industries, Industrial Engineering; Ken D. McDonough, MacMillan Bloedel Inc., Printing; and Stephen R. Schmidt, Copar Corp., Production.

Special certificates of appreciation were presented to Von L. Byrd, Mead Corp.; Robert W. Elfner, Weyerhaeuser Paper Co.; Craig H. Leake, National Starch & Chemical Co.; and Walter G. Paulson, retired from Weyerhaeuser.

25-year awards

In addition to these awards, 25-year membership certificates were presented to Charles M. Douglas, Maritime Paper Products Ltd.; Leo A. Feller, Badger Paper Mills Inc.; Charles J. Gose, Jr., Westvaco Corp.; John J. Kaufman, Witco Chemical Corp.; and William J. Whitsitt, Institute of Paper Science and Technology.

Two students awarded scholarships by the division were mentioned at the awards banquet, but were not present. They were Mary R. Miller of Tell City, Ind., winner of

a \$1000 scholarship sponsored by MHI Corrugating Machinery Co., and Scott D. Clendenning of Stevens Point, Wis., winner of a \$1000 scholarship sponsored by the Bobst Group Inc.

The conference's technical session featured five speakers. The first, Charles Smith, western region sales manager, Pamarco Pacific, Inc., presented a paper entitled "Anilox Rolls — How They Relate to Today's Market." He said that to compete in today's market more technical knowledge about press operation is needed than previously. He told about the changes that have happened in the past few years and the higher quality demands currently met. He also told how to meet these demands with different engravings of anilox rolls, rubber roll hardness, ink viscosity, and proper printing plates.

Robert J. Hobbs, engineering director, Noise Reduction Ltd., spoke about "Quality Board/Quality Production Environment." His paper was an innovative presentation about noise control for the single facer operation. He covered the basic principles of noise control, source, path, and receiver and explained different solutions such as ear muffs and plugs and acoustic enclosures. He said quality circles will improve quality and production, and a quality environment will also promote quality production by improving safety, noise and ventilation around the corrugator.

Michael Buchanan, O.E.M. sales manager, The Johnson Corp., presented on the subject of "The Effects of Machine Speed as it Relates to Rotary Pressure Joints and the Effective Removal of Condensate." He addressed issues which must be satisfied in order to keep the new, high-speed corrugators hot enough to run 1000 ft/min or more and discussed different types of rotary joints. He also reviewed the stages of condensate behaviors, puddling, cascading, and rimming. He concluded with some recommendations for the new, high-speed corrugators.

High intensity inks

Werner Sattler, director of technical sales, BCM Inks, presented about "High Intensity Inks for Improved Quality." He had with him several quality printing samples, which drew much attention. He explained the theory behind high solid inks and told how to make them work in a printing operation. He also discussed finger printing a press, ink film, viscosities, printing plates, and color sequences.

Robert L. Nebeling, manager, corrugated equipment, Bobst Group Inc., then spoke about "Laminating Added Value for Added Profit," another technique for achieving quality graphics. He said graphics are becoming more and more important in the corrugated industry and discussed a variety of printing techniques used to make attractive, high quality containers. He emphasized laminating as a very important technique for a growing segment of the corrugated industry.

Richard A. Surber, corporate technical director, Inland Container Corp., presented a thought provoking paper entitled "The Compression Test — How Wrong Can I Be and Still Be Right?" The paper summarized his work on a committee project and continued the quality theme of the technical session with a new twist.

Surber looked at the quality of the test procedures used

to measure quality. He discussed the variability in most test procedures and pointed out that most test procedures make estimates of the true value of quality. The precision statement, he said, is a statement of inherent quality and inherent variability of a test procedure. It is used to judge whether or not two different test results are the same or not.

He then told about the committee work done by the Fiberboard Shipping Container Testing Committee to measure the precision statement of the compression test of corrugated boxes. He said the variability in this test is large and related two techniques for dealing with this problem.

Feed rolls

The speakers at a workshop entitled "Limited Crush Feed Rolls," sponsored by the Printing Committee, included Ren Cousino of Universal Urethane Products, Inc. and Joe Ferma of Permaflex Rollers, Inc., each of whom gave a presentation about his company's method of manufacturing limited crush feed rolls. Bob Elfner of Weyerhaeuser Paper Co. gave an end user's view. Richard White of Harper Corp. of America moderated the workshop.

Additional applications for limited crush roll coverings were discussed as well as the different methods for making them. Other applications mentioned were hold down ballast rolls for the cut off knife, hold down rolls for flexos, and pull rolls for flexos and rider rolls. Using these rolls reduces flute crushing and distortion, which improves printing quality by creating a flatter sheet. Other benefits are scrap reduction and improved stackability.

A relatively new application for rider rolls on the corrugator was also discussed. It was stated that using a heat resistant silicone covering prevents the build up of starch on the roll's outer surface. The silicone also reduces crushing as the board passes through the double backer glue station.

Workshop two dealt with "Automation of Testing and Data Analysis in a Box Plant." Four panelists presented information about statistical quality control (SQC) in measuring and controlling specific variables in a process.

A step-wise approach to SQC was: start with manual control to get involvement and training; progress to the use of personal computers with the appropriate software in order to improve accuracy and statistical analysis; and facilitate data collection with data collection devices and ongoing quality control with on-line systems, including minicomputers linked to a mainframe computer.

Corrugator application

An application of SQC and statistical process control (SPC) on a corrugator was presented. It included specific information about caliper, starch viscosity, and adhesive gap measurement. SPC can do trend analysis and produces error-free data, an immediate display of process variability, and management reports. The use of a central collection "black box" for various inputs from the process was also explained. The unit presented could accommodate ten inputs.

In the following question and answer session it was stated that software can measure viscosity, starch gel

temperature and similar factors. It was also stated that the payout with box waste at 6-12% could be a 2-3% reduction in two to three years. It was mentioned that the English have developed a very linear gauge that bounces at 0.003 in. and is steady at 0.010 in.

The Human Resource Development Corrugated Committee's workshop focused on leadership and training. It was co-sponsored by seven companies and attended by 120 people.

The instructor was Patricia Zigarmi of Blanchard Training and Development, Inc. Zigarmi is the co-author of Ken Blanchard's best seller, "Leadership and the One Minute Manager."

A survey of the audience's reaction to the workshop showed overwhelmingly excellent reviews as well as suggestions for courses about time management and stress management.

Steam systems

Workshop four dealt with "Steam Distribution Systems Now and in the Future." It was sponsored by the Engineering Committee and drew more than 100 attendees. The workshop began with a generic overview of steam system background and application by the moderator, John Telesca of Southern Container Corp. The overview included an explanation and slide presentation of the steam systems in use today in the corrugated industry.

Seven panelists then gave highly professional and informative presentations, supported by slides of schematics and installations. Afterwards, there was an active question and answer session, which resulted in some very interesting discussions about steam systems and applications, variations, equipment and concepts.

The Folding Carton/Set-up Box Committee held a workshop about "SPC Implementation in a Folding Carton Plant." The workshop was co-sponsored by the Pacific Coast Paper Box Manufacturers Association and included a tour of the House of Packaging's facilities in the City of Industry, Calif.

The workshop's co-moderators were William R. Marshall of Waldorf Corp. and John Franck of the House of Packaging.

Representatives of commercial users accounts, such as Giorgio Perfume, 3M Co., and Chevron/Ortho Chemical Co., provided insights about what users of folding cartons require for certification and for process control. Donald L. Dewar, QC International, talked about how to organize operations in order to economically implement SPC methods.

The workshop's highlights were presentations by L. T. Piland, Gulf States Paper Corp., and Bob Lee, James River Corp., about the results of implementing SPC methods in specific folding carton plants. These converter "proof statements" were beneficial to everyone. The presentations got into the nuts and bolts of how to implement SPC in the plant; the advantages and disadvantages to beware of, and the results to expect. □