How Corrugator Misalignment Causes Costly Issues & Directly Impacts Product Quality

Presented by
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What Factors Impact Corrugator Performance?

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- Inexperienced operator and/or maintenance personnel
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- Process management
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- Materials
- Inexperienced operator and/or maintenance personnel
- Process management
- Misalignment of components
Issues Associated with Component Misalignment

- Baggy edges
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- Poor web tracking or web breaks
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- Warp/twist warp
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- Crush
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- Inconsistent board caliper
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• Inconsistent board caliper
• High scrap (waste) levels
Issues Associated with Component Misalignment

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- Poor web tracking or web breaks
- Warp/twist warp
- Crush
- Inconsistent board caliper
- High scrap (waste) levels
- Lower operating speeds
How Misalignment Directly Impacts Product Quality

Two adjacent rolls misaligned to one another
How Misalignment Directly Impacts Product Quality

Two adjacent rolls misaligned to one another

Baggy edges or loose web

Loose/Baggy Edge (Operator Side)
How Misalignment Directly Impacts Product Quality

- Two adjacent rolls misaligned to one another
- Baggy edges or loose web
- Paper tension differences

Uneven Tension
How Misalignment Directly Impacts Product Quality

- Two adjacent rolls misaligned to one another
- Baggy edges or loose web
- Paper tension differences
- Heat transfer variations across product
How Misalignment Directly Impacts Product Quality

- Two adjacent rolls misaligned to one another
- Baggy edges or loose web
- Paper tension differences
- Heat transfer variations across product
- Moisture imbalance within the sheet
How Misalignment Directly Impacts Product Quality

- Two adjacent rolls misaligned to one another
- Baggy edges or loose web
- Paper tension differences
- Heat transfer variations across product
- Moisture imbalance within the sheet
- Bonding process
How Misalignment Directly Impacts Product Quality

Warp/Twist Warp

- Normal Warp
- Reverse Warp
- “S” Warp
- Twist Warp
- Edge Warp
- Long Warp (down)
How Misalignment Directly Impacts Product Quality

Crush

- Can be a result of too much force applied from the top belt of the double backer
- Is also attributed to large deviations between adjacent hot plate elevations – specifically when the lead-out edge of a hot plate is lower in elevation than the lead-in edge of the next hot plate
Thank you for watching!

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