
**Corrugating medium — Determination
of the flat crush resistance after
laboratory fluting —**

**Part 2:
B-flute**

*Papier cannelure — Détermination de la résistance à la compression
à plat après cannelage en laboratoire —*

Partie 2: Cannelure B

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Published in Switzerland

Contents

Page

Foreword	iv
Introduction	vi
1 Scope	1
2 Normative references	1
3 Terms and definitions	1
4 Principle	2
5 Apparatus	2
6 Sampling	4
7 Conditioning	4
8 Preparation of test pieces	4
9 Procedure	5
9.1 General.....	5
9.2 Testing immediately after fluting.....	5
9.3 Testing after 30 min of reconditioning.....	5
9.4 Fluting and testing.....	5
10 Expression of results	6
10.1 Flat crush resistance.....	6
10.2 Flat crush resistance index.....	6
11 Test report	6
Annex A (informative) Maintenance of fluting rolls (horizontal type)	8
Annex B (informative) Precision data	9
Bibliography	11

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Foreword

ISO (the International Organization for Standardization) is a worldwide federation of national standards bodies (ISO member bodies). The work of preparing International Standards is normally carried out through ISO technical committees. Each member body interested in a subject for which a technical committee has been established has the right to be represented on that committee. International organizations, governmental and non-governmental, in liaison with ISO, also take part in the work. ISO collaborates closely with the International Electrotechnical Commission (IEC) on all matters of electrotechnical standardization.

The procedures used to develop this document and those intended for its further maintenance are described in the ISO/IEC Directives, Part 1. In particular, the different approval criteria needed for the different types of ISO documents should be noted. This document was drafted in accordance with the editorial rules of the ISO/IEC Directives, Part 2 (see www.iso.org/directives).

Attention is drawn to the possibility that some of the elements of this document may be the subject of patent rights. ISO shall not be held responsible for identifying any or all such patent rights. Details of any patent rights identified during the development of the document will be in the Introduction and/or on the ISO list of patent declarations received (see www.iso.org/patents).

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For an explanation of the voluntary nature of standards, the meaning of ISO specific terms and expressions related to conformity assessment, as well as information about ISO's adherence to the World Trade Organization (WTO) principles in the Technical Barriers to Trade (TBT) see www.iso.org/iso/foreword.html.

This document was prepared by Technical Committee ISO/TC 6, *Paper, board and pulps*, Subcommittee SC 2, *Test methods and quality specifications for paper and board*.

This document cancels and replaces ISO 7263:2011, which has been technically revised.

This document adds a version of the test method covering the use of a B-flute fluter, expanding the flexibility of the technical approach using the same general methodology. Prior to this revision of the method, ISO 7263 allowed only for the use of A-flute equipment. That method is maintained as ISO 7263-1.

The main changes compared with ISO 7263:2011 are as follows:

- ISO 7263 has been divided into two parts due to technical developments to allow both A-flute (Part 1) and B-flute (Part 2) performance to be tested;
- [Clause 1](#): the scope has been modified;
- [Clause 2](#): normative references have been changed;
- [5.2](#): measurements for B-flute have been added;
- [5.3](#): description of rack and comb has been modified;
- [5.3: Figure 3](#) has been added;
- [5.5](#): description of flat crush tester has been modified;
- [Clause 7](#) has been modified;
- [Clause 7](#): this document requires conditioning of samples where testing will be carried out immediately after fluting, not only where test pieces will be reconditioned before testing;
- [Clause 8](#) has been modified;

- [9.2](#): for testing immediately after fluting the time between fluted test piece discharge and initial application of force has been increased to a more realistic level;
- [Clause 11](#): precision with more detailed description of precision data according to ISO/TR 24498 and TAPPI T 1200 has been moved to informative [Annex B](#);
- Test report is now [Clause 11](#) and has been updated;
- [Annex B](#): precision data according to ISO/TR 24498 and TAPPI T 1200 has been added.

A list of all parts in the ISO 7263 series can be found on the ISO website.

Any feedback or questions on this document should be directed to the user's national standards body. A complete listing of these bodies can be found at www.iso.org/members.html.

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Introduction

The flat crush resistance of laboratory-fluted corrugating medium is regarded as a property indicating the potential flat crush resistance of corrugated fibreboard made from that medium. The corrugated medium is fluted by passing it between heated rollers. Two different test procedures are used:

- a) the fluted corrugating medium is compressed immediately after fluting (i.e. 15 s to 25 s after fluting);
- b) the fluted corrugating medium is conditioned for 30 min to 35 min under standard laboratory test conditions before being compressed.

Since considerable advantages are claimed for both procedures and both are widely used, the ISO 7263 series describes both procedures. Procedure a) generally gives considerably higher results than those obtained with procedure b). The differences in results are claimed to be caused by the lower moisture content (and thus higher stiffness) of the unconditioned fluted corrugating medium, and/or the change in flute profile which occurs during the conditioning period.

ISO 7263-1[6] describes the testing method for the A-flute geometry.

This document describes the testing method for the B-flute geometry.

The option of using an A- or B-flute geometry is to be determined by the producer and/or the end-use customer; it is not required for any particular flute structure.

A method for determining the flat crush resistance of manufactured corrugated fibreboard is given in ISO 3035[3].

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