

SRI LANKA STANDARD 1275:2008
ISO 3037: 2007

METHODS OF
TESTING OF CORRUGATED FIBREBOARD
FOR EDGEWISE CRUSH RESISTANCE
(UNWAXED METHOD)
(FIRST REVISION)

SRI LANKA STANDARDS INSTITUTION

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**SLS 1275:2008
ISO 3037: 2007**

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SRI LANKA.**

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EDGEWISE CRUSH RESISTANCE (UNWAXED METHOD)
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NATIONAL FOREWORD

This Sri Lanka Standard was approved by the Sectoral Committee on Chemical and Polymer Technology and authorized for adoption and publication by the Council of the Sri Lanka Standards Institution on 2008-05-26

SLS 1275 was first published in 2006 as an adoption of ISO 3037:1994. This First Revision is issued to SLS1275; since ISO 3037 has been revised and published in 2007. This First Revision is identical with ISO 3037:2007 methods of testing of corrugated fibre board for edgewise crush resistance (unwaxed edge method) published by International Organization for Standardisation.

The text of the International Standard has been accepted as suitable for publication, without deviation, as a Sri Lanka Standard. However, certain terminology and conventions are not identical with those used in

TERMINOLOGY AND CONVENTIONS

The text of the International Standard has been accepted as suitable for publication without deviation, as a Sri Lanka Standard. However certain terminology and conventions are not identical with those used in Sri Lanka Standards. Attention is therefore drawn to the following:

- a) Wherever the words ‘International Standard/publication’ appear referring to a particular standard, they should be interpreted as “Sri Lanka Standard”.
- b) The comma has been used throughout as a decimal marker. In Sri Lanka Standards it is the current practice to use the full point on the baseline as the decimal marker.

Attention is also drawn to the test temperature adopted in Sri Lanka which is 27 ± 2 ° C.

CROSS REFERENCES

International Standard

ISO 186 Paper and board - Sampling to determine average quality

ISO 187 Paper, board and pulps - Standard atmosphere for conditioning and testing and procedure for monitoring the atmosphere and conditioning of samples

ISO 13820 Paper, board and corrugated fibreboard – description and calibration of compression – testing equipment.

Corresponding Sri Lanka Standard

SLS 808 Methods for sampling of paper and board

SLS 374 Standard atmospheric conditions for conditioning and testing

No Corresponding Sri Lanka Standards

INTERNATIONAL STANDARD

ISO
3037

Fourth edition
2007-03-01

Corrugated fibreboard — Determination of edgewise crush resistance (unwaxed edge method)

*Carton ondulé — Détermination de la résistance à la compression sur
chant (méthode sans enduction de cire)*



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ISO 3037:2007(E)

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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.

International Standards are drafted in accordance with the rules given in the ISO/IEC Directives, Part 2.

The main task of technical committees is to prepare International Standards. Draft International Standards adopted by the technical committees are circulated to the member bodies for voting. Publication as an International Standard requires approval by at least 75 % of the member bodies casting a vote.

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.

ISO 3037 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 fourth edition cancels and replaces the third edition (ISO 3037:1994), which has been technically revised. Specifications for the compression testing machine have been replaced by reference to ISO 13820. Details of acceptable cutting devices have been moved to an informative annex and have been replaced by specification of the quality of cut.

Introduction

A variety of methods for the determination of edgewise crush resistance are in use in different parts of the world. These can be classified into three groups as follows:

- a) Those in which a carefully cut rectangular test piece is tested without any special treatment or modification (e.g. ISO 3037).
- b) Those in which the edges of the test piece to which the force is applied are waxed, to prevent the test result being influenced by “edge effects” (e.g. ISO 13821, *Corrugated fibreboard — Determination of edgewise crush resistance — Waxed edge method*).
- c) Those in which the test piece edges are not waxed but the shape of the test piece is such that the length is substantially reduced at a point midway between the loaded edges, in order to induce the failure to occur away from those edges.

The dimensions of the test piece vary from one group to the other and, in group c), the methods vary in the shape and method of reducing the length, and in whether or not the test piece is held in a clamp during crushing.

The methods may not give the same numerical results, but it can be shown that most of them can be used to predict the top-to-bottom compression strength which will be achieved when the board is properly converted into a transport package.

This International Standard describes a method from group a). It is intended as a method for quality measurement and quality specification purposes and is selected because it correlates with the top-to-bottom compression strength of the final transport package and because it is the simplest and most operationally convenient method, an important factor when large numbers of tests need to be conducted. However, it does not measure the actual intrinsic compressive strength of the corrugated fibreboard, giving lower results than most of the methods in groups b) and c). This systematic difference is due to edge effects.

Other methods may be used for other purposes, particularly when the object of the test is to study fundamental structural characteristics of the package.

There are methods available for calculating the edgewise crush resistance from the compression strength of the component papers.

Corrugated fibreboard — Determination of edgewise crush resistance (unwaxed edge method)

1 Scope

This International Standard specifies an unwaxed edge method for the determination of the edgewise crush resistance of corrugated fibreboard. It is applicable to all corrugated fibreboard grades.

2 Normative references

The following referenced documents are indispensable for the application of this document. For dated references, only the edition cited applies. For undated references, the latest edition of the referenced document (including any amendments) applies.

ISO 186, *Paper and board — Sampling to determine average quality*

ISO 187, *Paper and board — Standard atmosphere for conditioning and testing and procedure for monitoring the atmosphere and conditioning of samples*

ISO 13820, *Paper, board and corrugated fibreboard — Description and calibration of compression-testing equipment*

3 Terms and definitions

For the purposes of this document, the following terms and definitions apply.

3.1

edgewise crush resistance

maximum force per unit length that a test piece of corrugated fibreboard can support until the onset of failure when a compressive force is applied parallel to the flutes

4 Principle

A rectangular test piece of corrugated fibreboard, placed between the platens of a compression tester with the flutes perpendicular to the surfaces of the platens, is subjected to an increasing compressive force until failure occurs. The maximum force sustained by the test piece is measured.

5 Apparatus

5.1 Fixed-platen compression testing machine as described in ISO 13820. It is preferable to avoid the use of emery paper on the platens.

While it is safer to avoid the use of emery paper on the platens, because it is a requirement of other test methods, the platens may be faced with very fine emery paper of a grade not coarser than 00. Where this is done, due regard should be paid to maintaining the flatness and parallelism requirements specified for the faces.

5.2 Cutting device, such as a high-speed table saw or Billerud-type cutter (see Annex A), capable of cutting test pieces to the quality of cut described in 8.3 and 8.4.

5.3 Guide blocks, two rectangular, smooth-finished, blocks of dimensions approximately 20 mm x 20 mm x 100 mm, to support the test piece and keep it perpendicular to the platen surfaces. It is advisable to fit each guide block with a probe, to enable each block to be moved safely during the test.

6 Sampling

If the average quality of a lot of corrugated fibreboard is to be determined, sampling shall be carried out in accordance with ISO 186. If another type of sample is to be tested, make sure that the test pieces taken are representative of the sample received.

7 Conditioning

The sample shall be conditioned in accordance with ISO 187.

8 Preparation of test pieces

8.1 Prepare the test pieces in the same atmospheric conditions as used to condition the sample.

8.2 Using a sharp blade and a procedure that ensures the cuts are parallel, cut, from the sample, specimens with the following dimensions: 100,0 mm \pm 0,5 mm in the direction perpendicular to the flutes and 70 mm to 300 mm in the direction parallel to the flutes, such that test pieces can be obtained from an undamaged area of the sample.

8.3 From undamaged areas of the specimens (8.2), using an appropriate cutting device (5.2), cut sufficient test pieces 25,0 mm \pm 0,5 mm in the direction parallel to the flutes, so that 10 valid tests are obtained. Each test piece will then measure 25,0 mm \pm 0,5 mm in height (the direction of the flutes) and 100,0 mm \pm 0,5 mm in length (the direction perpendicular to the flutes).

If a Billerud-type cutter (5.2) is used, insert the uncut strip until it almost contacts the end stop, and ensure that a sufficient length of strip extends on the other side of the blades and that the edge is in contact with the squareness guide.

Irrespective of the method of cutting, the edges subjected to load shall be cleanly cut, straight, parallel and perpendicular to the board surfaces (8.4).

8.4 Test piece quality. Each test piece shall be examined for quality.

The width of the test piece shall not vary by more than 0,1 mm along its length.

Cleanness of cut is judged by inspection of the test pieces. Flutes shall show no discernible distortion, and the cut edges shall not be furry or have loose fibres visible when inspected under normal laboratory conditions, i.e. under room lighting with no magnification.

Straightness, parallelism and perpendicularity may be judged by the following procedure.

Stand two test pieces on their cut edges on a plane surface with two of their faces almost touching. With perfectly flat board, the two adjacent faces should appear flat and parallel to each other over their whole surface. If the board is warped, this may not be so, but the test pieces are acceptable if they stand vertically on their bottom edges, if the top cut surfaces appear flat and parallel to each other and at right angles to the liner surfaces close to the cut, and if the cut ends of the test pieces appear to be in the same plane. It should not be possible to see light under the cut edge of either test piece, when a load of about 1 N (equivalent to light finger pressure) is applied to the top edge.

Rotate one test piece end-for-end (rotate 180° about its vertical axis) and invert it (rotate 180° about its horizontal axis), then invert the other test piece. In each configuration, the criteria of the preceding paragraph shall apply.

Test other pairs of test pieces in the same way.

With cutters of the high-speed saw and Billerud type (Annex A) and any other type of cutter, where relevant, these checks should be done when the cutter is first used to establish that it is operating correctly. Thereafter, the checks should be done periodically to ensure that the cutter remains in good condition.

NOTE The quality of test piece cutting can have a significant effect on the test results and it is therefore essential that this be maintained to the highest possible standard.

9 Procedure

Conduct the tests in the standard atmosphere that was used in Clause 7.

With the platens of the compression tester (5.1) conveniently separated, place the test piece on one of its 100 mm cut edges onto the lower platen. Support it by placing a guide block (5.3) on each side. The guide blocks may be relocated away from the test piece when the load reaches about 50 N. They may be either left on the platen or removed from it. If applicable, take whatever action is appropriate to ensure that the weight of the guide blocks does not contribute to the force reading.

Operate the tester until the test piece fails.

Record, to the nearest 1 N, the maximum force, F_{\max} , developed up to the moment when instant failure occurs. Repeat the test on sufficient test pieces, so that at least 10 valid results are obtained.

10 Calculation

10.1 Calculate the mean maximum force, \bar{F}_{\max} , and standard deviation, $s_{F_{\max}}$.

10.2 Calculate the edgewise crush resistance R , expressed in kilonewtons per metre, to the nearest 0,01 kN/m using the equation

$$R = \frac{\bar{F}_{\max}}{l} \quad (1)$$

where

\bar{F}_{\max} is the mean maximum force, in newtons;

l is the length of the test piece, in millimetres (100 mm).

10.3 Calculate the standard deviation of the edgewise crush resistance, s_R , expressed in kilonewtons per metre, to the nearest 0,01 kN/m, using the equation;

$$s_R = \frac{s_{F_{\max}}}{l} \quad (2)$$

where

$s_{F_{\max}}$ is the standard deviation of the maximum force, in newtons;

l is the length of the test piece, in millimetres (100 mm).

11 Precision

At present, it is not possible to provide details of the repeatability and reproducibility which may be expected with this method.

12 Test report

The test report shall include the following information:

- a) a reference to this International Standard;
- b) the date and place of testing;
- c) the type of compression tester used;
- d) the type of cutter used;
- e) identification of the sample and description of the product tested;
- f) the conditioning atmosphere used;
- g) the edgewise crush resistance and its standard deviation;
- h) the number of replicate tests;
- i) any other information which may assist in the interpretation of the results.

Annex A (informative)

Examples of suitable cutting devices

A.1 High-speed table saw equipped with a small-tooth, no-set, hollow ground blade and minimum clearance throatplate, and with the saw blade at 90° to the table supporting the sample.

A.2 Billerud-type cutter fitted with flat, straight, parallel and freshly sharpened blades approximately 0,5 mm thick, sharpened to a bevel of about 3 mm. If single-bevel blades are used, the blades should be mounted so that the plane sides of the blades face each other, i.e. inwards. The blades of such a cutter must be kept in good alignment. A Billerud-type cutter is usually unsuitable for cutting test pieces from triple-wall board and some heavyweight double-wall board.

It is recommended that the blades of this type of cutter should not be used more than 50 times between sharpenings.

NOTE In a study by Ernst and Graf (Ernst U. and Graf E., *Das Papier* Vol. 45 (9) 545 (1991)), in some cases, it was found that there was a significant difference between the strength of test pieces cut using a single-bevel blade and those cut using a double-bevel blade. For some samples, the results obtained using a single-bevel blade were higher and for some they were lower.

SRI LANKA STANDARDS INSTITUTION

The Sri Lanka Standards Institution (SLSI) is the National Standards Organization of Sri Lanka established under the Sri Lanka Standards Institution Act No. 6 of 1984 which repealed and replaced the Bureau of Ceylon Standards Act No. 38 of 1964. The Institution functions under the Ministry of Science & Technology.

The principal objects of the Institution as set out in the Act are to prepare standards and promote their adoption, to provide facilities for examination and testing of products, to operate a Certification Marks Scheme, to certify the quality of products meant for local consumption or exports and to promote standardization and quality control by educational, consultancy and research activity.

The Institution is financed by Government grants, and by the income from the sale of its publications and other services offered for Industry and Business Sector. Financial and administrative control is vested in a Council appointed in accordance with the provisions of the Act.

The development and formulation of National Standards is carried out by Technical Experts and representatives of other interest groups, assisted by the permanent officers of the Institution. These Technical Committees are appointed under the purview of the Sectoral Committees which in turn are appointed by the Council. The Sectoral Committees give the final Technical approval for the Draft National Standards prior to the approval by the Council of the SLSI.

All members of the Technical and Sectoral Committees render their services in an honorary capacity. In this process the Institution endeavours to ensure adequate representation of all view points.

In the International field the Institution represents Sri Lanka in the International Organization for Standardization (ISO), and participates in such fields of standardization as are of special interest to Sri Lanka.

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