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<th>Company - Mill</th>
<th>Machine No.</th>
<th>Code Letter</th>
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<td>--Hodge</td>
<td>1</td>
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<td>Crown Zollorbach Corporation--Baltimore</td>
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<td>M</td>
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<tr>
<td>--Baltimore</td>
<td>2</td>
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<tr>
<td>--Bogalusa</td>
<td>4</td>
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<tr>
<td>--Lebanon</td>
<td>2</td>
<td>J</td>
</tr>
<tr>
<td>International Paper Company--Arecibo</td>
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<tr>
<td>--Bastrop</td>
<td>1</td>
<td>L</td>
</tr>
<tr>
<td>--Bastrop</td>
<td>2</td>
<td>X</td>
</tr>
<tr>
<td>--Cortezan</td>
<td>1</td>
<td>C</td>
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<td>The Mound Corporation--Harrison</td>
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<td>B</td>
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<td>--Knoxville</td>
<td>1</td>
<td>G</td>
</tr>
<tr>
<td>--Lynchburg</td>
<td>2</td>
<td>F</td>
</tr>
<tr>
<td>--Sylva</td>
<td>1</td>
<td>D</td>
</tr>
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<td>Clin Mathieson Chemical Corporation--Monroe</td>
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<td>--</td>
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<tr>
<td>--Monroe</td>
<td>2</td>
<td>--</td>
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<td>Stone-Illinois Steel Company--Big Island</td>
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<tr>
<td>--Temhawen</td>
<td>1</td>
<td>P</td>
</tr>
<tr>
<td>--Temhawen</td>
<td>2</td>
<td>Q</td>
</tr>
<tr>
<td>--Temhawen</td>
<td>3</td>
<td>S</td>
</tr>
<tr>
<td>Packaging Corporation of America--Filer City</td>
<td>1</td>
<td>R</td>
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<tr>
<td>--Filer City</td>
<td>2</td>
<td>T</td>
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<tr>
<td>St. Joe Paper Company--Fort St. Joe</td>
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<td>U</td>
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<tr>
<td>St. Regis Container Corporation</td>
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<td></td>
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<tr>
<td>Hill Division--Coshocton</td>
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<tr>
<td>Union Bag-Camp Paper Corporation--Savannah</td>
<td>2</td>
<td>A</td>
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<tr>
<td>West Virginia Pulp and Paper Company--Covington</td>
<td>6</td>
<td>V</td>
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<tr>
<td>--Covington</td>
<td>7</td>
<td>--</td>
</tr>
<tr>
<td>--Charleston</td>
<td>--</td>
<td>--</td>
</tr>
<tr>
<td>Beyereheuser Company</td>
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<tr>
<td>North Carolina Division--Plymouth</td>
<td>3</td>
<td>K</td>
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CONTINUOUS EVALUATION OF CORRUGATING MEDIUM

Project 1108-17

Report 97

A Progress Report
to

FOURDRINIER KRAFT BOARD INSTITUTE, INC.

October 1, 1962
TABLE OF CONTENTS

INTRODUCTION 1

NUMBER OF ROLLS OF CORRUGATING MEDIUM SUBMITTED FOR EVALUATION FROM EACH MACHINE 2

SUMMARY OF CURRENT MACHINE AVERAGES 4

GRAPHICAL PRESENTATIONS 5

SUMMARY OF TEST RESULTS FOR INDIVIDUAL MACHINES 7

DISCUSSION OF RESULTS 20

INSTITUTE AND MILL CONCORA FLAT CRUSH TEST RESULTS 22
INTRODUCTION

As requested by the Technical Committee of the Fourdrinier Kraft Board Institute, Inc., the reports pertinent to the continuous evaluation of corrugating medium are prepared by The Institute of Paper Chemistry on a bimonthly basis instead of the previous monthly basis. This system was initiated on August 1, 1961. This seventh report under the bimonthly system presents results obtained during the months of August and September, 1962.

During this seventh bimonthly period, 170 rolls of corrugating medium representing the production of twenty-four machines were evaluated. A tabulation of the number of rolls submitted from each machine during the months of August and September, 1962, is given in Table I. In connection with the data given in Table I, it should be mentioned that, effective September 1, 1961, at the request of the Technical Committee, the limit on the number of rolls submitted for evaluation from each machine during a given month was reduced from six to four.

Each sample of corrugating medium was evaluated for basis weight, caliper, Concora flat crush (conditioned after fluting), H. and D. flat crush on single-faced board, and runnability. Runnability was measured by corrugating each roll under standardized conditions on the Institute's corrugator into A-flute board at 600 feet per minute with minimum tension. If unsatisfactory runnability occurred at this speed, the corrugator was slowed down in increments of 25 f.p.m. until satisfactory runnability was obtained—i.e., no ruptured flutes. If the medium fabricated satisfactorily at 600 f.p.m. with minimum tension, further runs were made at higher tensions to determine when cracking occurred. The higher tensions used were 0.5 lb. per inch, 1.0 lb. per inch, and 1.5 lb. per inch.
# TABLE I

**NUMBER OF ROLLS OF CORRUGATING MEDIUM SUBMITTED FOR EVALUATION FROM EACH MACHINE**  
August and September, 1962

<table>
<thead>
<tr>
<th>Machine Code</th>
<th>Number of Rolls</th>
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<tbody>
<tr>
<td>A</td>
<td>8</td>
</tr>
<tr>
<td>B</td>
<td>10</td>
</tr>
<tr>
<td>C</td>
<td>6</td>
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<tr>
<td>D</td>
<td>6</td>
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<tr>
<td>E</td>
<td>7</td>
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<tr>
<td>F</td>
<td>8</td>
</tr>
<tr>
<td>G</td>
<td>8</td>
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<tr>
<td>H</td>
<td>8</td>
</tr>
<tr>
<td>I</td>
<td>8</td>
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<tr>
<td>J</td>
<td>12</td>
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<tr>
<td>K</td>
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<tr>
<td>L</td>
<td>7</td>
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<tr>
<td>M</td>
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<td>8</td>
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<tr>
<td>O</td>
<td>4</td>
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<tr>
<td>P</td>
<td>8</td>
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<tr>
<td>Q</td>
<td>8</td>
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<tr>
<td>R</td>
<td>8</td>
</tr>
<tr>
<td>S</td>
<td>8</td>
</tr>
<tr>
<td>T</td>
<td>8</td>
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<tr>
<td>U</td>
<td>4</td>
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<tr>
<td>V</td>
<td>5</td>
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<tr>
<td>W</td>
<td>7</td>
</tr>
<tr>
<td>X</td>
<td>8</td>
</tr>
</tbody>
</table>

Total 170
Flat crush was determined on the single-faced board obtained at a speed of 600 f.p.m. with minimum tension. The flat crush results, in addition to supplying information about quality, will provide data which may be useful in studying the relationship between Concora flat crush and combined board flat crush for each participant's medium.

For each participating machine, the current machine averages associated with the current period are shown for each test in Table II and presented graphically in Fig. 1 to 4. The current machine average is the average of the test results obtained on all rolls of corrugating medium evaluated from a given machine during the current period. In addition to showing the test data obtained for the various machines, Table II also presents the current F.K.I. averages, cumulative F.K.I. averages, and the F.K.I. indexes. The current F.K.I. average for each test is the average of the test results for all machines participating in the study during a given period. The cumulative F.K.I. average for each test is determined by averaging the results for the previous twelve-month period excluding the result for the current period. The F.K.I. index for each test is obtained as follows:

\[
\frac{\text{current F.K.I. average}}{\text{cumulative F.K.I. average}} \times 100 = \text{F.K.I. index (%)}
\]

The F.K.I. index provides a ready means of comparing the current quality with previous results. An index greater than 100% indicates that current quality is higher than the average result for the previous twelve periods; an index below 100% indicates that current quality is lower than the average result for the previous twelve periods.

The test results obtained on the sample lots submitted from the production of individual machines during August and September, 1962, are shown in Tables III through XXVI for Machines A through X, respectively. The maximum,
<table>
<thead>
<tr>
<th>Mill Code</th>
<th>Basis Weight, lb.</th>
<th>Caliper, points</th>
<th>Concora Flat Crush, p.s.i.</th>
<th>Single-Face Flat Crush, p.s.i.</th>
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</thead>
<tbody>
<tr>
<td>A</td>
<td>27.0</td>
<td>9.2</td>
<td>38.1</td>
<td>34.3</td>
</tr>
<tr>
<td>B</td>
<td>28.0</td>
<td>10.5</td>
<td>36.7</td>
<td>35.7</td>
</tr>
<tr>
<td>C</td>
<td>27.4</td>
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<td>D</td>
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<td>E</td>
<td>26.4</td>
<td>10.5</td>
<td>41.1</td>
<td>38.5</td>
</tr>
<tr>
<td>F</td>
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<td>9.8</td>
<td>33.2</td>
<td>32.0</td>
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<td>10.9</td>
<td>34.4</td>
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<td>9.6</td>
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<td>9.7</td>
<td>37.2</td>
<td>32.9</td>
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<tr>
<td>J</td>
<td>26.7</td>
<td>9.4</td>
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<td>9.9</td>
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<td>10.8</td>
<td>40.4</td>
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<td>P</td>
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<td>10.4</td>
<td>35.8</td>
<td>33.4</td>
</tr>
<tr>
<td>Q</td>
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<td>V</td>
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<td>34.8</td>
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<td>10.1</td>
<td>38.8</td>
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<td>X</td>
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<td>10.4</td>
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<td>Current F.K.I. Average</td>
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</tr>
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<td>98.7</td>
<td>101.3</td>
<td>104.1</td>
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</tbody>
</table>
Figure 1. Comparison of Basis Weight Results

Figure 2. Comparison of Caliper Results

--- Current machine average
--- Cumulative machine average
Figure 3. Comparison of Concora Flat Crush Results

Figure 4. Comparison of Single-Face Flat Crush Results
### TABLE III

**SUMMARY OF TEST RESULTS FOR MACHINE A**  
**August and September, 1962**

<table>
<thead>
<tr>
<th>Code</th>
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<th>Roll No.</th>
<th>Basis Mill Weight, lb./M sq.ft.</th>
<th>Caliper, points</th>
<th>Concora Flat Crush, p.s.i.</th>
<th>Single-Face Flat Crush, p.s.i.</th>
<th>Runnability, maximum tension at 600 f.p.m., lb./in.</th>
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<td>9.4</td>
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<td>7-22-62</td>
<td>8- 8-62</td>
<td>505</td>
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<td>8.7</td>
<td>9.1</td>
<td>39.6</td>
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<td>9-21-62</td>
<td>511</td>
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<td>9.8</td>
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<tr>
<td></td>
<td>Cumulative Machine Average</td>
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<td>9.1</td>
<td>36.1</td>
<td>31.8</td>
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<tr>
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<td>Machine Factor, %</td>
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</tbody>
</table>

### TABLE IV

**SUMMARY OF TEST RESULTS FOR MACHINE B**  
**August and September, 1962**

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<thead>
<tr>
<th>Code</th>
<th>Made</th>
<th>Received</th>
<th>Roll No.</th>
<th>Basis Mill Weight, lb./M sq.ft.</th>
<th>Caliper, points</th>
<th>Concora Flat Crush, p.s.i.</th>
<th>Single-Face Flat Crush, p.s.i.</th>
<th>Runnability, maximum tension at 600 f.p.m., lb./in.</th>
</tr>
</thead>
<tbody>
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<td>7-27-62</td>
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<td>10.9</td>
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<td>7-20-62</td>
<td>7-27-62</td>
<td>762</td>
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<td>10.4</td>
<td>10.9</td>
<td>37.2</td>
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<tr>
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<td>8-13-62</td>
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<td>40.2</td>
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<td>8-23-62</td>
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<td>10.6</td>
<td>10.0</td>
<td>10.2</td>
<td>39.6</td>
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<td>38.4</td>
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<td>B-9</td>
<td>9-12-62</td>
<td>9-21-62</td>
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<td>11.0</td>
<td>10.3</td>
<td>10.7</td>
<td>41.4</td>
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<td>B-10</td>
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<td>9-21-62</td>
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<td>33.7</td>
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<td>Cumulative Machine Average</td>
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<td>31.4</td>
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<tr>
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<tr>
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<td>Machine Index, %</td>
<td>103.0</td>
<td>102.6</td>
<td>100.7</td>
<td>102.1</td>
<td></td>
<td></td>
<td></td>
</tr>
</tbody>
</table>
### TABLE V

**SUMMARY OF TEST RESULTS FOR MACHINE C**

August and September, 1962

<table>
<thead>
<tr>
<th>Code</th>
<th>Date Made</th>
<th>Date Received</th>
<th>Roll No.</th>
<th>Mill Basis Weight, lb./M2</th>
<th>Caliper, points</th>
<th>Concora Flat Crush, in.</th>
<th>Single-Face Flat Crush, in.</th>
<th>Runnability, maximum tension at 600 f.p.m., lb./in.</th>
</tr>
</thead>
<tbody>
<tr>
<td>C-1</td>
<td>7-16-62</td>
<td>7-30-62</td>
<td>502</td>
<td>27.4</td>
<td>10.2</td>
<td>37.8</td>
<td>41.8</td>
<td>1/2</td>
</tr>
<tr>
<td>C-2</td>
<td>7-21-62</td>
<td>8-8-62</td>
<td>503</td>
<td>27.4</td>
<td>10.9</td>
<td>35.4</td>
<td>37.3</td>
<td>1-1/2</td>
</tr>
<tr>
<td>C-3</td>
<td>8-9-62</td>
<td>9-5-62</td>
<td>504</td>
<td>26.2</td>
<td>10.5</td>
<td>33.0</td>
<td>34.9</td>
<td>1</td>
</tr>
<tr>
<td>C-4</td>
<td>8-16-62</td>
<td>9-17-62</td>
<td>505</td>
<td>27.4</td>
<td>10.8</td>
<td>35.4</td>
<td>39.2</td>
<td>1/2</td>
</tr>
<tr>
<td>C-5</td>
<td>8-22-62</td>
<td>9-17-62</td>
<td>506</td>
<td>27.9</td>
<td>10.9</td>
<td>37.8</td>
<td>39.1</td>
<td>1/2</td>
</tr>
<tr>
<td>C-6</td>
<td>8-22-62</td>
<td>9-17-62</td>
<td>507</td>
<td>27.8</td>
<td>11.0</td>
<td>38.4</td>
<td>40.8</td>
<td>1/2</td>
</tr>
</tbody>
</table>

**Current Machine Average**
- Basis Weight: 27.4
- Caliper: 10.4
- Concora Flat Crush: 38.9
- Single-Face Flat Crush: 36.4

**Cumulative Machine Average**
- Basis Weight: 27.3
- Caliper: 10.3
- Concora Flat Crush: 38.1
- Single-Face Flat Crush: 34.9

**Machine Factor, %**
- Current: 100.3
- Cumulative: 100.2

**Machine Index, %**
- Current: 100.5
- Cumulative: 100.7

### TABLE VI

**SUMMARY OF TEST RESULTS FOR MACHINE D**

August and September, 1962

<table>
<thead>
<tr>
<th>Code</th>
<th>Date Made</th>
<th>Date Received</th>
<th>Roll No.</th>
<th>Mill Basis Weight, lb./M2</th>
<th>Caliper, points</th>
<th>Concora Flat Crush, in.</th>
<th>Single-Face Flat Crush, in.</th>
<th>Runnability, maximum tension at 600 f.p.m., lb./in.</th>
</tr>
</thead>
<tbody>
<tr>
<td>D-1</td>
<td>7-25-62</td>
<td>7-30-62</td>
<td>767</td>
<td>28.7</td>
<td>11.2</td>
<td>34.8</td>
<td>38.0</td>
<td>36.0</td>
</tr>
<tr>
<td>D-2</td>
<td>7-25-62</td>
<td>7-30-62</td>
<td>768</td>
<td>28.4</td>
<td>11.3</td>
<td>37.8</td>
<td>40.0</td>
<td>36.2</td>
</tr>
<tr>
<td>D-3</td>
<td>8-8-62</td>
<td>8-21-62</td>
<td>775</td>
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<td>10.8</td>
<td>31.8</td>
<td>33.8</td>
<td>34.8</td>
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<tr>
<td>D-4</td>
<td>8-8-62</td>
<td>8-21-62</td>
<td>776</td>
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<td>11.0</td>
<td>33.6</td>
<td>34.9</td>
<td>34.6</td>
</tr>
<tr>
<td>D-5</td>
<td>8-23-62</td>
<td>8-29-62</td>
<td>783</td>
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<td>10.3</td>
<td>31.8</td>
<td>35.0</td>
<td>35.4</td>
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<td>8-23-62</td>
<td>8-30-62</td>
<td>784</td>
<td>26.2</td>
<td>10.5</td>
<td>32.4</td>
<td>34.4</td>
<td>31.6</td>
</tr>
</tbody>
</table>

**Current Machine Average**
- Basis Weight: 27.4
- Caliper: 10.6
- Concora Flat Crush: 36.0
- Single-Face Flat Crush: 33.2

**Cumulative Machine Average**
- Basis Weight: 27.4
- Caliper: 10.6
- Concora Flat Crush: 36.2
- Single-Face Flat Crush: 31.8

**Machine Factor, %**
- Current: 100.0
- Cumulative: 99.4

**Machine Index, %**
- Current: 100.6
- Cumulative: 103.5
<table>
<thead>
<tr>
<th>Date Made</th>
<th>Received</th>
<th>Code</th>
<th>Test Results for Machine E</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td></td>
<td></td>
<td>7-25-62 8-10-62 670 26.6</td>
</tr>
<tr>
<td></td>
<td></td>
<td></td>
<td>7-25-62 8-14-62 671 27.1</td>
</tr>
<tr>
<td></td>
<td></td>
<td></td>
<td>7-25-62 8-29-62 672 27.1</td>
</tr>
<tr>
<td></td>
<td></td>
<td></td>
<td>7-25-62 9-10-62 673 27.1</td>
</tr>
<tr>
<td></td>
<td></td>
<td></td>
<td>7-25-62 9-16-62 674 27.1</td>
</tr>
<tr>
<td></td>
<td></td>
<td></td>
<td>7-25-62 9-4-62 675 27.1</td>
</tr>
</tbody>
</table>

<table>
<thead>
<tr>
<th>Date Made</th>
<th>Received</th>
<th>Code</th>
<th>Test Results for Machine F</th>
</tr>
</thead>
<tbody>
<tr>
<td>Aug 20-62</td>
<td>7-20-62</td>
<td>F-1</td>
<td>7-20-62 8-20-62 70 27.4</td>
</tr>
<tr>
<td></td>
<td></td>
<td></td>
<td>7-20-62 8-30-62 71 27.2</td>
</tr>
<tr>
<td></td>
<td></td>
<td></td>
<td>7-20-62 8-20-62 72 27.9</td>
</tr>
<tr>
<td></td>
<td></td>
<td></td>
<td>7-20-62 9-17-62 73 28.9</td>
</tr>
<tr>
<td></td>
<td></td>
<td></td>
<td>7-20-62 9-17-62 74 29.1</td>
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<td></td>
<td>7-20-62 9-17-62 75 29.1</td>
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<td></td>
<td></td>
<td>7-20-62 9-17-62 76 29.1</td>
</tr>
<tr>
<td></td>
<td></td>
<td></td>
<td>7-20-62 9-17-62 77 29.1</td>
</tr>
</tbody>
</table>
### TABLE IX

**SUMMARY OF TEST RESULTS FOR MACHINE G**  
August and September, 1962

<table>
<thead>
<tr>
<th>Code</th>
<th>Date Made</th>
<th>Date Received</th>
<th>Roll No.</th>
<th>Basis Weight, lb./M sq.ft.</th>
<th>Caliper, points</th>
<th>Concora Flat Crush, p.s.i.</th>
<th>Single-Face Flat Crush, p.s.i.</th>
<th>Runnability, maximum tension at 600 f.p.m., lb./in.</th>
</tr>
</thead>
<tbody>
<tr>
<td>G-1</td>
<td>7-26-62</td>
<td>8-2-62</td>
<td>763</td>
<td>25.2</td>
<td>10.9</td>
<td>34.2</td>
<td>33.7</td>
<td>11/2</td>
</tr>
<tr>
<td>G-2</td>
<td>7-26-62</td>
<td>8-2-62</td>
<td>764</td>
<td>26.2</td>
<td>11.0</td>
<td>40.2</td>
<td>36.7</td>
<td>1-1/2</td>
</tr>
<tr>
<td>G-3</td>
<td>8-7-62</td>
<td>8-15-62</td>
<td>771</td>
<td>26.6</td>
<td>13.0</td>
<td>36.6</td>
<td>34.3</td>
<td>1</td>
</tr>
<tr>
<td>G-4</td>
<td>8-7-62</td>
<td>8-15-62</td>
<td>772</td>
<td>26.3</td>
<td>12.5</td>
<td>33.0</td>
<td>32.3</td>
<td>1</td>
</tr>
<tr>
<td>G-5</td>
<td>8-13-62</td>
<td>8-21-62</td>
<td>779</td>
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<td>12.2</td>
<td>34.2</td>
<td>31.6</td>
<td>1-1/2</td>
</tr>
<tr>
<td>G-6</td>
<td>8-13-62</td>
<td>8-21-62</td>
<td>780</td>
<td>25.6</td>
<td>13.2</td>
<td>40.2</td>
<td>35.9</td>
<td>1</td>
</tr>
<tr>
<td>G-7</td>
<td>9-4-62</td>
<td>9-12-62</td>
<td>787</td>
<td>26.5</td>
<td>11.0</td>
<td>37.8</td>
<td>35.9</td>
<td>1</td>
</tr>
<tr>
<td>G-8</td>
<td>9-4-62</td>
<td>9-12-62</td>
<td>788</td>
<td>26.4</td>
<td>11.1</td>
<td>36.0</td>
<td>34.4</td>
<td>1/2</td>
</tr>
</tbody>
</table>

**Current Machine Average**  
26.2  
**Cumulative Machine Average**  
26.7  
**Machine Factor, %**  
98.1  
**Machine Index, %**  
96.4

### TABLE X

**SUMMARY OF TEST RESULTS FOR MACHINE H**  
August and September, 1962

<table>
<thead>
<tr>
<th>Code</th>
<th>Date Made</th>
<th>Date Received</th>
<th>Roll No.</th>
<th>Basis Weight, lb./M sq.ft.</th>
<th>Caliper, points</th>
<th>Concora Flat Crush, p.s.i.</th>
<th>Single-Face Flat Crush, p.s.i.</th>
<th>Runnability, maximum tension at 600 f.p.m., lb./in.</th>
</tr>
</thead>
<tbody>
<tr>
<td>H-1</td>
<td>7-4-62</td>
<td>8-3-62</td>
<td>--</td>
<td>30.6</td>
<td>10.3</td>
<td>40.2</td>
<td>38.3</td>
<td>1-1/2</td>
</tr>
<tr>
<td>H-2</td>
<td>7-12-62</td>
<td>8-3-62</td>
<td>--</td>
<td>28.7</td>
<td>9.9</td>
<td>36.0</td>
<td>35.3</td>
<td>1-1/2</td>
</tr>
<tr>
<td>H-3</td>
<td>7-13-62</td>
<td>8-3-62</td>
<td>--</td>
<td>30.5</td>
<td>10.1</td>
<td>42.0</td>
<td>37.7</td>
<td>1-1/2</td>
</tr>
<tr>
<td>H-4</td>
<td>7-14-62</td>
<td>8-3-62</td>
<td>--</td>
<td>28.4</td>
<td>9.9</td>
<td>38.4</td>
<td>36.5</td>
<td>1-1/2</td>
</tr>
<tr>
<td>H-5</td>
<td>8-21-62</td>
<td>9-7-62</td>
<td>142</td>
<td>29.8</td>
<td>10.0</td>
<td>34.2</td>
<td>33.2</td>
<td>1-1/2</td>
</tr>
<tr>
<td>H-6</td>
<td>8-21-62</td>
<td>9-7-62</td>
<td>143</td>
<td>29.0</td>
<td>10.0</td>
<td>34.8</td>
<td>33.0</td>
<td>1-1/2</td>
</tr>
<tr>
<td>H-7</td>
<td>8-22-62</td>
<td>9-7-62</td>
<td>144</td>
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<td>10.0</td>
<td>36.0</td>
<td>34.8</td>
<td>1-1/2</td>
</tr>
<tr>
<td>H-8</td>
<td>8-22-62</td>
<td>9-7-62</td>
<td>145</td>
<td>30.6</td>
<td>9.9</td>
<td>34.8</td>
<td>33.5</td>
<td>1-1/2</td>
</tr>
</tbody>
</table>

**Current Machine Average**  
29.6  
**Cumulative Machine Average**  
27.7  
**Machine Factor, %**  
106.9  
**Machine Index, %**  
108.8
### TABLE XI

**SUMMARY OF TEST RESULTS FOR MACHINE I**
August and September, 1962

<table>
<thead>
<tr>
<th>Roll Code</th>
<th>Date Made</th>
<th>Date Received</th>
<th>Basis Weight, lb./M²</th>
<th>Caliper, points</th>
<th>Concora Flat Crush, p.s.i.</th>
<th>Single-Face Flat Crush, p.s.i.</th>
<th>Runnability, maximum tension at 600 f.p.m., lb./in.</th>
</tr>
</thead>
<tbody>
<tr>
<td>I-1</td>
<td>7-21-62</td>
<td>8-3-62</td>
<td>141</td>
<td>10.9</td>
<td>41.4</td>
<td>37.0</td>
<td>1/2</td>
</tr>
<tr>
<td>I-2</td>
<td>7-21-62</td>
<td>8-3-62</td>
<td>142</td>
<td>10.1</td>
<td>37.8</td>
<td>35.2</td>
<td>1/2</td>
</tr>
<tr>
<td>I-3</td>
<td>7-22-62</td>
<td>8-3-62</td>
<td>143</td>
<td>10.5</td>
<td>38.4</td>
<td>35.4</td>
<td>1/2</td>
</tr>
<tr>
<td>I-4</td>
<td>7-22-62</td>
<td>8-3-62</td>
<td>144</td>
<td>10.1</td>
<td>36.6</td>
<td>33.0</td>
<td>1/2</td>
</tr>
<tr>
<td>I-5</td>
<td>8-12-62</td>
<td>9-7-62</td>
<td>145</td>
<td>9.8</td>
<td>40.2</td>
<td>35.4</td>
<td>1/2</td>
</tr>
<tr>
<td>I-6</td>
<td>8-13-62</td>
<td>9-7-62</td>
<td>146</td>
<td>9.8</td>
<td>40.2</td>
<td>37.2</td>
<td>1/2</td>
</tr>
<tr>
<td>I-7</td>
<td>8-13-62</td>
<td>9-7-62</td>
<td>147</td>
<td>10.0</td>
<td>40.2</td>
<td>34.8</td>
<td>1/2</td>
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<tr>
<td>I-8</td>
<td>8-12-62</td>
<td>9-7-62</td>
<td>148</td>
<td>9.9</td>
<td>39.0</td>
<td>34.2</td>
<td>1/2</td>
</tr>
</tbody>
</table>

Current Machine Average: 27.2
Cumulative Machine Average: 27.8
Machine Factor, %: 98.0
Machine Index, %: 100.0

### TABLE XII

**SUMMARY OF TEST RESULTS FOR MACHINE J**
August and September, 1962

<table>
<thead>
<tr>
<th>Roll Code</th>
<th>Date Made</th>
<th>Date Received</th>
<th>Basis Weight, lb./M²</th>
<th>Caliper, points</th>
<th>Concora Flat Crush, p.s.i.</th>
<th>Single-Face Flat Crush, p.s.i.</th>
<th>Runnability, maximum tension at 600 f.p.m., lb./in.</th>
</tr>
</thead>
<tbody>
<tr>
<td>J-1</td>
<td>7-18-62</td>
<td>8-6-62</td>
<td>26.0</td>
<td>10.5</td>
<td>35.4</td>
<td>31.0</td>
<td>1-1/2</td>
</tr>
<tr>
<td>J-2</td>
<td>7-18-62</td>
<td>8-6-62</td>
<td>28.2</td>
<td>10.2</td>
<td>38.4</td>
<td>38.9</td>
<td>1-1/2</td>
</tr>
<tr>
<td>J-3</td>
<td>7-18-62</td>
<td>8-6-62</td>
<td>27.6</td>
<td>9.5</td>
<td>35.4</td>
<td>32.8</td>
<td>1/2</td>
</tr>
<tr>
<td>J-4</td>
<td>7-19-62</td>
<td>8-6-62</td>
<td>27.0</td>
<td>9.9</td>
<td>38.4</td>
<td>35.2</td>
<td>1/2</td>
</tr>
<tr>
<td>J-5</td>
<td>9-6-62</td>
<td>9-20-62</td>
<td>27.2</td>
<td>10.0</td>
<td>37.8</td>
<td>35.6</td>
<td>1/2</td>
</tr>
<tr>
<td>J-6</td>
<td>9-6-62</td>
<td>9-20-62</td>
<td>27.6</td>
<td>9.7</td>
<td>40.2</td>
<td>36.2</td>
<td>1/2</td>
</tr>
<tr>
<td>J-7</td>
<td>9-6-62</td>
<td>9-20-62</td>
<td>25.6</td>
<td>8.3</td>
<td>34.8</td>
<td>31.4</td>
<td>1/2</td>
</tr>
<tr>
<td>J-8</td>
<td>9-7-62</td>
<td>9-20-62</td>
<td>25.7</td>
<td>9.0</td>
<td>34.8</td>
<td>32.3</td>
<td>1/2</td>
</tr>
<tr>
<td>J-9</td>
<td>9-7-62</td>
<td>9-20-62</td>
<td>26.2</td>
<td>10.0</td>
<td>36.0</td>
<td>31.4</td>
<td>1/2</td>
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<tr>
<td>J-10</td>
<td>9-10-62</td>
<td>9-20-62</td>
<td>26.2</td>
<td>10.0</td>
<td>36.0</td>
<td>32.3</td>
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</tr>
<tr>
<td>J-11</td>
<td>9-12-62</td>
<td>9-20-62</td>
<td>26.8</td>
<td>10.0</td>
<td>32.4</td>
<td>28.2</td>
<td>1/2</td>
</tr>
<tr>
<td>J-12</td>
<td>9-12-62</td>
<td>9-20-62</td>
<td>26.4</td>
<td>9.9</td>
<td>32.4</td>
<td>28.2</td>
<td>1/2</td>
</tr>
</tbody>
</table>

Current Machine Average: 26.7
Cumulative Machine Average: 27.1
Machine Factor, %: 98.7
Machine Index, %: 98.1

*Note: Maximum speed at which this roll could be corrugated with minimum tension was 575 f.p.m.*
### TABLE XIII

**SUMMARY OF TEST RESULTS FOR MACHINE K**

**August and September, 1962**

<table>
<thead>
<tr>
<th>Roll No.</th>
<th>Code</th>
<th>Date Made</th>
<th>Date Received</th>
<th>Basis Weight, lb./M</th>
<th>Caliper, points</th>
<th>Concora Flat Crush, p.s.i.</th>
<th>Single-Face Flat Crush, p.s.i.</th>
<th>Runnability, maximum tension at 600 f.p.m., lb./in.</th>
</tr>
</thead>
<tbody>
<tr>
<td>51</td>
<td>K-1</td>
<td>5-22-62</td>
<td>8- 8-62</td>
<td>28.1</td>
<td>10.7</td>
<td>39.6 36.6 37.8</td>
<td>38.4 36.0 37.0</td>
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<td>8- 8-62</td>
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<td>9.9</td>
<td>42.0 35.4 38.6</td>
<td>38.6 37.4 37.9</td>
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</tr>
</tbody>
</table>

Current Machine Average: 27.6
Cumulative Machine Average: 27.2
Machine Factor, %: 101.5
Machine Index, %: 101.5

### TABLE XIV

**SUMMARY OF TEST RESULTS FOR MACHINE L**

**August and September, 1962**

<table>
<thead>
<tr>
<th>Roll No.</th>
<th>Code</th>
<th>Date Made</th>
<th>Date Received</th>
<th>Basis Weight, lb./M</th>
<th>Caliper, points</th>
<th>Concora Flat Crush, p.s.i.</th>
<th>Single-Face Flat Crush, p.s.i.</th>
<th>Runnability, maximum tension at 600 f.p.m., lb./in.</th>
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<tbody>
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<td>8- 9-62</td>
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<td>36.6 34.0 35.7</td>
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<tr>
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<td>8- 1-62</td>
<td>8- 9-62</td>
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<td>10.9</td>
<td>10.5 44.4 37.8 39.5</td>
<td>38.8 33.8 36.7</td>
<td>1-1/2</td>
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<td>L-3</td>
<td>8- 7-62</td>
<td>8-21-62</td>
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<td>10.5 40.8 37.8 39.1</td>
<td>40.2 37.6 38.5</td>
<td>1-1/2</td>
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<td>L-4</td>
<td>8-14-62</td>
<td>8-21-62</td>
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<td>9-24-62</td>
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<td>42.0 39.0 40.4</td>
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<td>10.8 45.6 42.6 43.7</td>
<td>39.6 39.0 39.3</td>
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</tr>
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</table>

Current Machine Average: 26.7
Cumulative Machine Average: 28.2
Machine Factor, %: 94.9
Machine Index, %: 98.1

Report 97
Foundry Industry Research Institute
### TABLE XV
#### SUMMARY OF TEST RESULTS FOR MACHINE M
August and September, 1962

<table>
<thead>
<tr>
<th>Mill Code</th>
<th>Date Made</th>
<th>Date Received</th>
<th>Roll No.</th>
<th>Basis Weight, lb./M sq.ft.</th>
<th>Caliper, points Max.</th>
<th>Min.</th>
<th>Av.</th>
<th>Concera Flat Crush, p.s.i. Max.</th>
<th>Min.</th>
<th>Av.</th>
<th>Single-Face Flat Crush, p.s.i. Max.</th>
<th>Min.</th>
<th>Av.</th>
<th>Runnability, maximum tension at 600 f.p.m., lb./in.</th>
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<td>M-2</td>
<td>8-9-62</td>
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<tr>
<td>Cumulative Machine Average</td>
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### TABLE XVI
#### SUMMARY OF TEST RESULTS FOR MACHINE N
August and September, 1962

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<th>Mill Code</th>
<th>Date Made</th>
<th>Date Received</th>
<th>Roll No.</th>
<th>Basis Weight, lb./M sq.ft.</th>
<th>Caliper, points Max.</th>
<th>Min.</th>
<th>Av.</th>
<th>Concera Flat Crush, p.s.i. Max.</th>
<th>Min.</th>
<th>Av.</th>
<th>Single-Face Flat Crush, p.s.i. Max.</th>
<th>Min.</th>
<th>Av.</th>
<th>Runnability, maximum tension at 600 f.p.m., lb./in.</th>
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<tbody>
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<td>N-1</td>
<td>7-26-62</td>
<td>8-6-62</td>
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<td>26.3</td>
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<td>7-26-62</td>
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<td>43.2</td>
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<td>8-20-62</td>
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<td>30.4</td>
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<td>9-4-62</td>
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<td>10.3</td>
<td>9.7</td>
<td>10.0</td>
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<td>36.2</td>
<td>32.2</td>
<td>33.9</td>
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<tr>
<td>Cumulative Machine Average</td>
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<td>32.5</td>
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<td>101.7</td>
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<tr>
<td>Machine Index, %</td>
<td>98.3</td>
<td>96.7</td>
<td>103.5</td>
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</tr>
</tbody>
</table>
### TABLE XVII

**SUMMARY OF TEST RESULTS FOR MACHINE 0**  
August and September, 1962

<table>
<thead>
<tr>
<th>Code</th>
<th>Date Made</th>
<th>Date Received</th>
<th>Mill Roll No.</th>
<th>Basis Weight, lb./M²</th>
<th>Caliper, Max. Points</th>
<th>Concora Flat Crush, p.s.i. Max.</th>
<th>Min. Av.</th>
<th>Single-Face Flat Crush, p.s.i. Max.</th>
<th>Min. Av.</th>
<th>Runnability, maximum tension at 600 f.p.m., lb./in.</th>
</tr>
</thead>
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<td>8-29-62</td>
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<td>35.6</td>
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<td>31.8 33.1 1-1/2</td>
</tr>
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<td>8-29-62</td>
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<td>10.8</td>
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<td>36.0 36.6 1-1/2</td>
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<td>38.3</td>
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<td>34.8 35.6 1-1/2</td>
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<tr>
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<td>39.6</td>
<td>37.4</td>
<td>34.0 35.4 1-1/2</td>
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</table>

Current Machine Average 26.8 10.1 38.1 35.2
Cumulative Machine Average 26.8 10.4 36.4 33.1
Machine Factor, % 100.0 96.8 104.5 106.2
Machine Index, % 98.5 98.0 104.3 106.6

### TABLE XVIII

**SUMMARY OF TEST RESULTS FOR MACHINE P**  
August and September, 1962

<table>
<thead>
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<th>Roll No.</th>
<th>Date Made</th>
<th>Date Received</th>
<th>Basis Weight, lb./M²</th>
<th>Caliper, Max. Points</th>
<th>Concora Flat Crush, p.s.i. Max.</th>
<th>Min. Av.</th>
<th>Single-Face Flat Crush, p.s.i. Max.</th>
<th>Min. Av.</th>
<th>Runnability, maximum tension at 600 f.p.m., lb./in.</th>
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<td>32.4</td>
<td>35.5</td>
<td>34.8</td>
<td>33.2 34.2 1-1/2</td>
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<td>32.0 32.3 1-1/2</td>
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<td>8-11-62</td>
<td>8-17-62</td>
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<td>36.0</td>
<td>37.8</td>
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Current Machine Average 26.7 10.4 35.8 33.4
Cumulative Machine Average 27.0 10.3 37.1 33.7
Machine Factor, % 99.2 101.0 96.4 99.0
Machine Index, % 98.3 100.8 98.0 101.2
### TABLE XIX

**SUMMARY OF TEST RESULTS FOR MACHINE Q**

August and September, 1962

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<tr>
<th>Code</th>
<th>Date Made</th>
<th>Date Received</th>
<th>Roll No.</th>
<th>Basis Weight, lb/M sq.ft.</th>
<th>Caliper, points</th>
<th>Concora Flat Crush, p.s.i. Max. Min. Av.</th>
<th>Single-Face Flat Crush, p.s.i. Max. Min. Av.</th>
<th>Runnability, maximum tension at 600 f.p.m., lb./in.</th>
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</thead>
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<td>8-15-62</td>
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<td>10.0</td>
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<td>38.4 34.8 37.1</td>
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<td>8-16-62</td>
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<td>10.2</td>
<td>38.4 35.4 36.5</td>
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</table>

**Current Machine Average** 27.0 10.4 38.6 35.1

**Cumulative Machine Average** 26.7 10.2 37.8 33.9

**Machine Factor, %** 101.3 101.7 102.1 103.8

**Machine Index, %** 99.4 101.3 105.7 106.5

### TABLE XX

**SUMMARY OF TEST RESULTS FOR MACHINE R**

August and September, 1962

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<td>11.1</td>
<td>11.3</td>
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**Current Machine Average** 26.5 10.6 34.1 31.8

**Cumulative Machine Average** 26.4 10.1 34.1 30.6

**Machine Factor, %** 100.6 105.5 100.0 103.8

**Machine Index, %** 97.5 103.6 93.6 96.3
### TABLE XXI

**SUMMARY OF TEST RESULTS FOR MACHINE S**  
August and September, 1962

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<th>Code</th>
<th>Date Made</th>
<th>Date Received</th>
<th>Mill Roll No.</th>
<th>Basis Weight, lb./M sq.ft.</th>
<th>Caliper, points</th>
<th>Concra Flat Crush, p.s.i. Max. Min. Av.</th>
<th>Single-Face Flat Crush, p.s.i. Max. Min. Av.</th>
<th>Runnability, maximum tension at 600 f.p.m., lb./in.</th>
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<tr>
<td>S-1</td>
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<td>10.3</td>
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<td>8-10-62</td>
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<td>34.6 30.8 32.8</td>
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<td>34.8 30.0 32.4</td>
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Current Machine Average: 27.2  
Cumulative Machine Average: 27.3  
Machine Factor, %: 99.5  
Machine Index, %: 100.0

### TABLE XXII

**SUMMARY OF TEST RESULTS FOR MACHINE T**  
August and September, 1962

<table>
<thead>
<tr>
<th>Roll</th>
<th>Date Made</th>
<th>Date Received</th>
<th>Mill Roll No.</th>
<th>Basis Weight, lb./M sq.ft.</th>
<th>Caliper, points</th>
<th>Concra Flat Crush, p.s.i. Max. Min. Av.</th>
<th>Single-Face Flat Crush, p.s.i. Max. Min. Av.</th>
<th>Runnability, maximum tension at 600 f.p.m., lb./in.</th>
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<tbody>
<tr>
<td>T-1</td>
<td>7-31-62</td>
<td>8-6-62</td>
<td>28</td>
<td>26.3</td>
<td>10.3</td>
<td>36.0 32.4 34.8</td>
<td>35.6 31.0 32.0</td>
<td>1-1/2</td>
</tr>
<tr>
<td>T-2</td>
<td>8-4-62</td>
<td>8-9-62</td>
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<td>38.4 33.6 37.0</td>
<td>33.6 31.4 33.0</td>
<td>1-1/2</td>
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</tbody>
</table>

Current Machine Average: 26.8  
Cumulative Machine Average: 26.6  
Machine Factor, %: 100.5  
Machine Index, %: 98.3

- T: 102.4  
- S: 103.9  
- R: 101.4
### TABLE XXIII
SUMMARY OF TEST RESULTS FOR MACHINE U
August and September, 1962

<table>
<thead>
<tr>
<th>Mill Code</th>
<th>Date Made</th>
<th>Date Received</th>
<th>Roll No.</th>
<th>Basis Weight, lb./M sq.ft</th>
<th>Caliper Points</th>
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<th>Max.</th>
<th>Min.</th>
<th>Av.</th>
<th>Single-Face Flat Crush, p.s.i.</th>
<th>Max.</th>
<th>Min.</th>
<th>Av.</th>
<th>Runnability, maximum tension at 600 f.p.m., lb./in.</th>
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</table>

Current Machine Average
Cumulative Machine Average
Machine Factor, %
Machine Index, %

<table>
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<th>Mill Code</th>
<th>Date Made</th>
<th>Date Received</th>
<th>Roll No.</th>
<th>Basis Weight, lb./M sq.ft</th>
<th>Caliper Points</th>
<th>Concora Flat Crush, p.s.i.</th>
<th>Max.</th>
<th>Min.</th>
<th>Av.</th>
<th>Single-Face Flat Crush, p.s.i.</th>
<th>Max.</th>
<th>Min.</th>
<th>Av.</th>
<th>Runnability, maximum tension at 600 f.p.m., lb./in.</th>
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<td>10.0</td>
<td>10.2</td>
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<td>32.4</td>
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<td>10.0</td>
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<td>37.4</td>
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<td>36.4</td>
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</table>

Current Machine Average
Cumulative Machine Average
Machine Factor, %
Machine Index, %
### TABLE XXV

**SUMMARY OF TEST RESULTS FOR MACHINE W**
August and September, 1962

| Mill Code | Date Made | Roll No. | Date Received | Basis Weight, lb./M sq.ft. | Caliper, Max. | Min. | Av. | Concora Flat Crush, p.s.i. Max. | Min. | Av. | Single-Face Flat Crush, p.s.i. Max. | Min. | Av. | Runnability, maximum tension at 600 f.p.m., lb./in. |
|-----------|-----------|----------|---------------|---------------------------|---------------|------|-----|-------------------------------|------|-----|---------------------------------|------|-----|---------------------------------|------|-----|
| W-1       | 7-19-62   | 8-8-62   | 278           | 27.1                      | 10.1          | 9.5  | 9.9 | 43.2                          | 40.8 | 41.9 | 39.0                            | 37.6 | 38.2 | 1-1/2                             |
| W-2       | 7-23-62   | 8-8-62   | 413           | 27.6                      | 10.1          | 9.0  | 9.7 | 42.6                          | 36.0 | 39.4 | 36.4                            | 33.0 | 34.4 | Min.                              |
| W-3       | 7-30-62   | 9-4-62   | 602           | 26.6                      | 10.8          | 10.0 | 10.3 | 40.8                          | 34.2 | 36.4 | 36.8                            | 35.4 | 36.7 | 1-1/2                             |
| W-4       | 8-3-62    | 9-4-62   | 68            | 27.6                      | 10.5          | 9.8  | 10.0 | 40.2                          | 37.8 | 39.0 | 38.8                            | 36.6 | 37.4 | 1-1/2                             |
| W-5       | 8-9-62    | 9-4-62   | 239           | 26.9                      | 10.9          | 9.4  | 10.1 | 40.2                          | 36.0 | 38.0 | 38.6                            | 36.4 | 37.3 | 1                                 |
| W-6       | 8-17-62   | 9-19-62  | 454           | 26.6                      | 10.8          | 10.0 | 10.2 | 42.0                          | 34.8 | 38.0 | 38.2                            | 33.8 | 36.5 | 1                                 |
| W-7       | 8-21-62   | 9-19-62  | 581           | 27.1                      | 11.1          | 10.2 | 10.7 | 40.8                          | 37.2 | 38.9 | 37.6                            | 35.4 | 36.4 | Min.                              |

Current Machine Average | 27.1 | 10.1 | 38.8 |
Cumulative Machine Average | 26.8 | 9.8  | 34.8 |
Machine Factor, % | 101.2 | 103.1 | 104.4 |
Machine Index, % | 99.5 | 98.5 | 111.2 |

### TABLE XXVI

**SUMMARY OF TEST RESULTS FOR MACHINE X**
August and September, 1962

| Mill Code | Date Made | Roll No. | Date Received | Basis Weight, lb./M sq.ft. | Caliper, Max. | Min. | Av. | Concora Flat Crush, p.s.i. Max. | Min. | Av. | Single-Face Flat Crush, p.s.i. Max. | Min. | Av. | Runnability, maximum tension at 600 f.p.m., lb./in. |
|-----------|-----------|----------|---------------|---------------------------|---------------|------|-----|-------------------------------|------|-----|---------------------------------|------|-----|---------------------------------|------|-----|
| X-1       | 7-25-62   | 8-2-62   | 321           | 26.0                      | 10.9          | 10.0 | 10.2 | 44.4                          | 41.4 | 42.7 | 40.8                            | 37.4 | 38.6 | 1-1/2                             |
| X-2       | 7-31-62   | 8-10-62  | 322           | 26.0                      | 10.9          | 10.0 | 10.3 | 42.6                          | 39.0 | 40.8 | 37.6                            | 36.0 | 36.8 | 1-1/2                             |
| X-3       | 8-8-62    | 8-14-62  | 323           | 26.8                      | 11.0          | 9.1  | 10.2 | 44.4                          | 40.8 | 42.5 | 39.8                            | 38.0 | 39.0 | 1-1/2                             |
| X-4       | 8-14-62   | 8-27-62  | 324           | 26.8                      | 11.7          | 10.3 | 11.1 | 40.8                          | 36.6 | 38.9 | 36.6                            | 34.4 | 35.8 | 1-1/2                             |
| X-5       | 8-23-62   | 8-30-62  | 325           | 25.8                      | 11.0          | 10.0 | 10.5 | 41.4                          | 37.2 | 39.1 | 38.4                            | 37.0 | 37.7 | 1-1/2                             |
| X-6       | 8-28-62   | 9-7-62   | 326           | 25.4                      | 10.2          | 9.5  | 9.9  | 41.4                          | 35.4 | 39.4 | 36.8                            | 36.0 | 36.4 | 1-1/2                             |
| X-7       | 9-5-62    | 9-12-62  | 327           | 26.3                      | 11.0          | 10.0 | 10.5 | 41.4                          | 37.2 | 39.1 | 36.4                            | 34.0 | 35.0 | 1-1/2                             |
| X-8       | 9-19-62   | 9-25-62  | 328           | 26.6                      | 11.0          | 10.0 | 10.5 | 40.2                          | 37.2 | 38.9 | 36.6                            | 34.0 | 35.1 | 1-1/2                             |

Current Machine Average | 26.2 | 10.4 | 40.2 |
Cumulative Machine Average | 26.7 | 10.7 | 38.6 |
Machine Factor, % | 98.2 | 97.0 | 104.1 |
Machine Index, % | 96.3 | 101.1 | 110.1 | 111.6 |
minimum, and average test results obtained on each sample lot are shown for all tests except basis weight for which only the average is shown; in addition the over-all average result for all sample lots submitted from a given machine is shown for each test. The latter over-all averages are reported as "current machine averages". A cumulative machine average is also shown and is calculated by averaging the current machine averages for the previous twelve periods (excluding the current period). Also shown for each machine in Tables III to XXVI are the machine factor and machine index which are defined as follows:

\[
\frac{\text{current machine average}}{\text{cumulative machine average}} \times 100 = \text{machine factor (\%)}
\]

\[
\frac{\text{current machine average}}{\text{cumulative F.K.I. average}} \times 100 = \text{machine index (\%)}
\]

The machine factor and machine index provide a means for comparing the current machine average with either the previous results for that particular machine or with the cumulative results for all machines--i.e., the cumulative F.K.I. average.
DISCUSSION OF RESULTS

Shown below from Table II are the maximum and minimum current machine averages noted for each test during the current period (August and September, 1962); the current machine average is the average of the results obtained on all rolls submitted from a given machine during the current period. Also given for each test is the current F.K.I. average which is determined by averaging the current machine averages for the current period and is indicative of the test level being maintained by the industry as a whole to the extent that the industry is represented by the participating machines:

<table>
<thead>
<tr>
<th>Basis wt., lb.</th>
<th>Maximum Current</th>
<th>Minimum Current</th>
<th>Current F.K.I. Average</th>
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<tbody>
<tr>
<td></td>
<td>Machine Average</td>
<td>Machine Average</td>
<td></td>
</tr>
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<td>26.0</td>
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<td>32.7</td>
<td>36.9</td>
<td></td>
</tr>
<tr>
<td>38.5</td>
<td>31.3</td>
<td>34.4</td>
<td></td>
</tr>
</tbody>
</table>

The runnability data for the 170 rolls evaluated during the current period are summarized as follows:

<table>
<thead>
<tr>
<th>Runnability</th>
<th>Number of Rolls</th>
<th>Percentage of Total Rolls</th>
</tr>
</thead>
<tbody>
<tr>
<td>Less than 600 f.p.m. with minimum tension</td>
<td>1</td>
<td>0.6</td>
</tr>
<tr>
<td>600 f.p.m. -- minimum tension</td>
<td>7</td>
<td>4.1</td>
</tr>
<tr>
<td>600 f.p.m. --1/2 lb. per in. tension</td>
<td>21</td>
<td>12.4</td>
</tr>
<tr>
<td>600 f.p.m. -- 1 lb. per in. tension</td>
<td>28</td>
<td>16.5</td>
</tr>
<tr>
<td>600 f.p.m. -- 1-1/2 lb. per in. tension</td>
<td>113</td>
<td>66.5</td>
</tr>
</tbody>
</table>
In Table XXVII a comparison of Institute and mill Concora flat crush test results obtained on conditioned specimens is given for each machine for the current period. The inclusion of these comparisons is made possible by the fact that interested participants submit their Concora flat crush test results to The Institute of Paper Chemistry. This affords each participant the opportunity to review the level of agreement for his data with the levels shown for the other participants. Data sheets for supplying this information may be obtained from the Institute. Comparisons of this kind are a helpful adjunct to other calibration procedures. Shown in Table XXVII are (1) the Institute and mill Concora averages for each roll included in these comparisons, (2) the difference between the roll average based on Institute data and that based on mill data, (3) the Institute and mill averages based on all rolls included in the comparison, and (4) the difference between these over-all averages.

The Concora flat crush data shown in Table XXVII are summarized in Part I of Table XXVIII where for each machine the following information is given: (1) Current machine average based on Institute data, (2) current machine average based on mill data, (3) the average difference—that is, the difference between the current machine average based on Institute data and that based on mill data and (4) the maximum difference encountered in comparing Institute and mill test averages for individual rolls. In Part II of Table XXVIII the average differences given in Part I have been converted to per cent. Comparative data from the previous two reports are also included in Part II of Table XXVIII. It may be seen in Part II of Table XXVIII that, for the current period, the highest average difference of 12.2% was associated with Machine I and the lowest of 0.6% with Machine G.

In Table XXIX a summary of the agreement between Institute and mill Concora flat crush data is given for the current period, and comparative data
TABLE XXVII

INSTITUTE AND MILL CONCORA FLAT CRUSH TEST RESULTS ON INDIVIDUAL ROLLS FOR AUGUST AND SEPTEMBER, 1962

<table>
<thead>
<tr>
<th>Machine A</th>
<th>Machine B</th>
<th>Machine C</th>
</tr>
</thead>
<tbody>
<tr>
<td>Roll No.</td>
<td>Date</td>
<td>Institute Flat Crush, p.s.i.</td>
</tr>
<tr>
<td>A-1</td>
<td>508</td>
<td>7-20-62</td>
</tr>
<tr>
<td>A-2</td>
<td>507</td>
<td>7-22-62</td>
</tr>
<tr>
<td>A-3</td>
<td>506</td>
<td>8- 2-62</td>
</tr>
<tr>
<td>A-4</td>
<td>507</td>
<td>8- 3-62</td>
</tr>
<tr>
<td>A-5</td>
<td>508</td>
<td>8- 5-62</td>
</tr>
<tr>
<td>A-6</td>
<td>509</td>
<td>9- 7-62</td>
</tr>
<tr>
<td>A-7</td>
<td>510</td>
<td>9- 9-62</td>
</tr>
<tr>
<td>A-8</td>
<td>511</td>
<td>9-11-62</td>
</tr>
</tbody>
</table>

Current Machine Av. | 38.1 | 39.4 | +1.3 | Current Machine Av. | 36.7 | 36.3 | -0.4 | Current Machine Av. | 38.9 | 41.8 | +2.9 |

<table>
<thead>
<tr>
<th>Machine D</th>
<th>Machine E</th>
<th>Machine F</th>
</tr>
</thead>
<tbody>
<tr>
<td>Roll No.</td>
<td>Date</td>
<td>Institute Flat Crush, p.s.i.</td>
</tr>
<tr>
<td>D-1</td>
<td>767</td>
<td>7-25-62</td>
</tr>
<tr>
<td>D-2</td>
<td>768</td>
<td>7-25-62</td>
</tr>
<tr>
<td>D-3</td>
<td>775</td>
<td>8- 8-62</td>
</tr>
<tr>
<td>D-4</td>
<td>776</td>
<td>8- 8-62</td>
</tr>
<tr>
<td>D-5</td>
<td>783</td>
<td>8-23-62</td>
</tr>
<tr>
<td>D-6</td>
<td>784</td>
<td>8-23-62</td>
</tr>
<tr>
<td>D-7</td>
<td>785</td>
<td>9- 4-62</td>
</tr>
</tbody>
</table>

Current Machine Av. | 36.0 | 36.8 | +0.8 | Current Machine Av. | 41.1 | 40.4 | -0.7 | Current Machine Av. | 33.2 | 35.3 | +2.1 |

<table>
<thead>
<tr>
<th>Machine G</th>
<th>Machine H</th>
<th>Machine I</th>
</tr>
</thead>
<tbody>
<tr>
<td>Roll No.</td>
<td>Date</td>
<td>Institute Flat Crush, p.s.i.</td>
</tr>
<tr>
<td>G-1</td>
<td>763</td>
<td>7-26-62</td>
</tr>
<tr>
<td>G-2</td>
<td>764</td>
<td>7-26-62</td>
</tr>
<tr>
<td>G-3</td>
<td>771</td>
<td>8- 7-62</td>
</tr>
<tr>
<td>G-4</td>
<td>772</td>
<td>8- 7-62</td>
</tr>
<tr>
<td>G-5</td>
<td>779</td>
<td>8-13-62</td>
</tr>
<tr>
<td>G-6</td>
<td>780</td>
<td>8-13-62</td>
</tr>
<tr>
<td>G-7</td>
<td>787</td>
<td>9- 4-62</td>
</tr>
<tr>
<td>G-8</td>
<td>789</td>
<td>9- 4-62</td>
</tr>
</tbody>
</table>

Current Machine Av. | 34.4 | 34.2 | -0.2 | Current Machine Av. | 35.6 | 32.5 | -1.3 | Current Machine Av. | 37.8 | 33.2 | -4.6 |

*a This difference is the amount in p.s.i. units by which the mill result is higher or lower than the Institute result.
TABLE XXVII (Continued)
INSTITUTE AND MILL CONCORA FLAT CRUSH TEST RESULTS ON INDIVIDUAL ROLLS FOR AUGUST AND SEPTEMBER, 1962

<table>
<thead>
<tr>
<th>Machine L</th>
<th>Concora Flat Crush, p.s.i.</th>
<th>Machine M</th>
<th>Concora Flat Crush, p.s.i.</th>
<th>Machine N</th>
<th>Concora Flat Crush, p.s.i.</th>
<th>Machine O</th>
<th>Concora Flat Crush, p.s.i.</th>
</tr>
</thead>
<tbody>
<tr>
<td>Code No.</td>
<td>Roll Date</td>
<td>Made</td>
<td>Institute</td>
<td>Mill</td>
<td>Difference</td>
<td>Code No.</td>
<td>Roll Date</td>
</tr>
<tr>
<td>P-1</td>
<td>8- 8-62</td>
<td>35.3</td>
<td>36.2</td>
<td>+0.7</td>
<td></td>
<td>Q-1</td>
<td>8- 3-62</td>
</tr>
<tr>
<td>P-2</td>
<td>8- 8-62</td>
<td>35.2</td>
<td>37.8</td>
<td>+2.6</td>
<td></td>
<td>Q-2</td>
<td>8- 9-62</td>
</tr>
<tr>
<td>P-3</td>
<td>8-11-62</td>
<td>35.6</td>
<td>35.9</td>
<td>-2.3</td>
<td></td>
<td>Q-3</td>
<td>8-16-62</td>
</tr>
<tr>
<td>P-4</td>
<td>8-13-62</td>
<td>37.8</td>
<td>37.2</td>
<td>-0.6</td>
<td></td>
<td>Q-4</td>
<td>8-16-62</td>
</tr>
<tr>
<td>P-5</td>
<td>9- 9-62</td>
<td>36.6</td>
<td>35.6</td>
<td>-1.0</td>
<td></td>
<td>P-5</td>
<td>9- 6-62</td>
</tr>
<tr>
<td>P-6</td>
<td>9- 9-62</td>
<td>37.6</td>
<td>36.0</td>
<td>-0.7</td>
<td></td>
<td>P-6</td>
<td>9- 9-62</td>
</tr>
<tr>
<td>P-7</td>
<td>9-10-62</td>
<td>36.3</td>
<td>35.4</td>
<td>-0.9</td>
<td></td>
<td>P-7</td>
<td>9-14-62</td>
</tr>
<tr>
<td>P-8</td>
<td>9-20-62</td>
<td>35.5</td>
<td>36.5</td>
<td>+1.0</td>
<td></td>
<td>P-8</td>
<td>9-14-62</td>
</tr>
<tr>
<td></td>
<td>Current Machine Av. 35.8</td>
<td>36.4</td>
<td>+0.6</td>
<td></td>
<td></td>
<td></td>
<td>Current Machine Av. 38.6</td>
</tr>
</tbody>
</table>

<table>
<thead>
<tr>
<th></th>
<th></th>
<th></th>
<th></th>
<th></th>
<th></th>
<th></th>
<th></th>
</tr>
</thead>
<tbody>
<tr>
<td>Code No.</td>
<td>Roll Date</td>
<td>Made</td>
<td>Institute</td>
<td>Mill</td>
<td>Difference</td>
<td>Code No.</td>
<td>Roll Date</td>
</tr>
<tr>
<td>S-1</td>
<td>8- 6-62</td>
<td>35.5</td>
<td>36.4</td>
<td>+0.9</td>
<td></td>
<td>T-1</td>
<td>8-31-62</td>
</tr>
<tr>
<td>S-2</td>
<td>8- 9-62</td>
<td>37.3</td>
<td>37.7</td>
<td>+1.4</td>
<td></td>
<td>T-2</td>
<td>8-4-62</td>
</tr>
<tr>
<td>S-3</td>
<td>8-10-62</td>
<td>35.5</td>
<td>35.3</td>
<td>-0.2</td>
<td></td>
<td>T-3</td>
<td>8-13-62</td>
</tr>
<tr>
<td>S-4</td>
<td>8-17-62</td>
<td>34.6</td>
<td>35.2</td>
<td>+0.6</td>
<td></td>
<td>T-4</td>
<td>8-19-62</td>
</tr>
<tr>
<td>S-5</td>
<td>9-10-62</td>
<td>37.8</td>
<td>37.7</td>
<td>-0.7</td>
<td></td>
<td>T-5</td>
<td>9-26-62</td>
</tr>
<tr>
<td>S-6</td>
<td>9-14-62</td>
<td>35.5</td>
<td>34.9</td>
<td>-1.6</td>
<td></td>
<td>T-6</td>
<td>9- 6-62</td>
</tr>
<tr>
<td>S-7</td>
<td>9-17-62</td>
<td>36.7</td>
<td>38.8</td>
<td>+2.1</td>
<td></td>
<td>T-7</td>
<td>9-10-62</td>
</tr>
<tr>
<td>S-8</td>
<td>9-19-62</td>
<td>35.0</td>
<td>35.0</td>
<td>-1.5</td>
<td></td>
<td>T-8</td>
<td>9-17-62</td>
</tr>
<tr>
<td></td>
<td>Current Machine Av. 36.4</td>
<td>35.8</td>
<td>-0.6</td>
<td></td>
<td></td>
<td></td>
<td>Current Machine Av. 36.5</td>
</tr>
</tbody>
</table>

<table>
<thead>
<tr>
<th>Machine W</th>
<th>Concora Flat Crush, p.s.i.</th>
<th>Machine X</th>
<th>Concora Flat Crush, p.s.i.</th>
</tr>
</thead>
<tbody>
<tr>
<td>Code No.</td>
<td>Roll Date</td>
<td>Made</td>
<td>Difference</td>
</tr>
<tr>
<td>W-1</td>
<td>7-19-62</td>
<td>31.9</td>
<td>40.0</td>
</tr>
<tr>
<td>W-2</td>
<td>7-23-62</td>
<td>30.4</td>
<td>39.4</td>
</tr>
<tr>
<td>W-3</td>
<td>7-30-62</td>
<td>36.4</td>
<td>37.9</td>
</tr>
<tr>
<td>W-4</td>
<td>8- 3-62</td>
<td>39.0</td>
<td>38.8</td>
</tr>
<tr>
<td>W-5</td>
<td>8- 9-62</td>
<td>34.0</td>
<td>40.6</td>
</tr>
<tr>
<td>W-6</td>
<td>8-17-62</td>
<td>38.0</td>
<td>37.4</td>
</tr>
<tr>
<td>W-7</td>
<td>8-21-62</td>
<td>39.4</td>
<td>41.4</td>
</tr>
<tr>
<td></td>
<td>Current Machine Av. 37.1</td>
<td>38.2</td>
<td>+1.1</td>
</tr>
</tbody>
</table>

*This difference is the amount in p.s.i. units by which the mill result is higher or lower than the Institute result.
### TABLE XXVIII

#### PART I: A COMPARATIVE SUMMARY FOR EACH MACHINE OF THE CONCORJA FLAT CRUSH AVERAGES BASED ON INSTITUTE DATA AND THOSE BASED ON MILL DATA

| Number of Rolls Compared | 8 | 10 | 6 | 6 | 7 | 8 | 8 | 4 | 4 | 4 | 0 | 0 | 7 | 0 | 8 | 4 | 8 | 8 | 8 | 8 | 8 | 8 | 8 | 8 | 8 | 7 | 8 |

Concorja Flat Crush, p.s.i.

- **Current Machine Av. (Institute)**
  - 38.1 36.7 38.9 36.0 41.1 33.2 34.4 33.6 37.8 -- -- 40.4 -- 37.8 38.1 35.8 38.6 34.1 36.4 36.5 32.7 37.1 38.8 40.2
- **Current Machine Av. (Mill)**
  - 39.4 36.3 41.8 36.8 40.4 35.3 34.2 32.3 33.2 -- -- 35.7 -- 38.8 35.2 36.4 37.5 34.7 35.8 36.8 34.5 38.2 40.1 39.2
- **Average Difference**
  - +1.3 -0.4 +2.9 +0.8 -0.7 +2.1 -0.2 -1.5 -4.6 -- -- -4.7 -- +1.0 +2.9 +0.6 -1.1 +0.6 +0.3 +1.0 +1.8 +1.1 +1.3 +1.0
- **Maximum Difference**
  - +2.3 -4.0 +5.9 +2.8 -2.6 +3.7 -3.3 -2.8 -4.6 -- -- -7.1 -- +3.6 -3.6 +2.6 -4.3 -1.6 +5.3 +8.9 +8.9 +6.6 +4.0 +2.7

#### PART II: A TABULATION FOR EACH MACHINE OF THE AVERAGE DIFFERENCE (PER CENT) BETWEEN THE CONCORJA FLAT CRUSH BASED ON INSTITUTE DATA AND THAT BASED ON MILL DATA

<table>
<thead>
<tr>
<th></th>
<th>Current Report (August and September)</th>
<th>96th Report (June and July)</th>
<th>99th Report (April and May)</th>
</tr>
</thead>
<tbody>
<tr>
<td>Average Difference, %</td>
<td>+3.4 -1.1 +7.5 -2.2 -1.7 +6.3 -0.6 -3.9 -12.2 -- -- -11.6 -- +2.6 -7.6 +1.7 -2.8 +1.8 -1.6 +0.8 +5.5 +3.0 +3.4 -2.5</td>
<td>+5.4 -3.4 +7.6 +6.9 -2.2 +8.2 +2.1 -- -- -3.4 -- +1.5 -3.1 +4.6 -0.7 +1.7 +4.3 +2.2 +4.0 +1.4 +5.0 +2.1</td>
<td>+2.1 -3.6 +3.9 -- +0.8 +11.7 -7.5 -- -- -0.8 -- +0.8 -6.6 -2.2 -0.8 -6.6 -0.5 +1.4 +6.9 +1.7 +3.5 +3.1</td>
</tr>
</tbody>
</table>

---

*Comparisons based on current machine average include only those rolls for which mill data were submitted.

*Average difference is the difference between the current machine average based on Institute test results and that based on mill test results with the Institute test results used as the reference. See Table XXVII.

*Maximum difference is the greatest difference encountered in comparing Institute and mill test averages for individual rolls. See Table XXVII.

*Average difference (per cent) is computed by dividing the average difference in p.s.i. (shown above in Part I of this table) by the Institute current machine average and multiplying the result by 100.
from the previous bimonthly period are also included. The data shown for the current period indicate that agreement between Institute and mill Concora data was good. It may be seen in Table XXIX that, for the current period, 9.5% of the comparisons of Institute and mill data differed by 1% or less, 42.9% of the comparisons differed by 2.5% or less, and 71.4% of the comparisons differed by 5% or less; agreement at the 1, 2.5 and 5% levels is comparable to the agreement for the previous period at these levels; however, agreement at the 5 and 10% levels for the current period is not quite as good as that noted for the previous period. Also, the maximum difference of 12.2% noted for the current period is somewhat higher than the maximum difference of 8.2% noted for the previous period.

**TABLE XXIX**

<table>
<thead>
<tr>
<th>Average Percentage Difference Between Institute and Mill Concora Flat Crush Test Results&lt;sup&gt;a&lt;/sup&gt;</th>
<th>Percentage of All Machines Included Within the Indicated Range</th>
</tr>
</thead>
<tbody>
<tr>
<td>Previous Period&lt;sup&gt;b&lt;/sup&gt;</td>
<td>Current Period&lt;sup&gt;c&lt;/sup&gt;</td>
</tr>
<tr>
<td>+ 1.0</td>
<td>5.3</td>
</tr>
<tr>
<td>+ 2.5</td>
<td>42.1</td>
</tr>
<tr>
<td>+ 5.0</td>
<td>84.2</td>
</tr>
<tr>
<td>+10.0</td>
<td>100.0&lt;sup&gt;d&lt;/sup&gt;</td>
</tr>
<tr>
<td>+12.2</td>
<td></td>
</tr>
</tbody>
</table>

<sup>a</sup>The average obtained at the Institute was used as the reference in the calculation of the percentage differences.
<sup>b</sup>June and July, 1962.
<sup>c</sup>August and September, 1962.
<sup>d</sup>Maximum percentage difference was 8.2.