

Attachment VG - 2



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## Sheetfeeding

### Glossary of terms

TERM	DEFINITION
Chop edge	The length of the sheet
Cobb Test	Test to determine the weight increase of a material exposed to water for a given time
Deckle	The width of the paper or board being run on a corrugator
Double wall board	A combination of two layers of board. The board therefore comprises of: liner/fluting/liner/fluting/liner
Edge crush test	A corrugated board strength test of vertical crush resistance
Enhanced Fluting	A substitute to standard fluting that adds strength and performance to the material
Exposed Flute	A double wall material with the outside liner removed
Flute	A single ridge in the fluting medium or on a corrugator roll
Fluting profile	The shape of the corrugations
Grammage	Weight of paper specified as g/m <sup>2</sup> (grams per square metre)
Liner Outer	Paper used for the outside of the corrugated board
Liner Inner	Paper used for the inside of the corrugated board
Mottled	A paper liner with an off white appearance
Microflute	F, N fluting medium (see AbbeyLite)
Single face	One piece of fluting glued to one liner only
Single wall	A board combination comprising of: liner/flute/liner
Slit edge	The edge of the sheet that has the flute running parallel with it. It is also known as the width of the material

### Common flute profiles

<b>FLUTE FORM</b>	<b>NOMINAL HEIGH EXCLUDING LINERS (MM)</b>
* N	0.50mm
F	0.75mm
* E	1.2mm
R	1.7mm
B	2.9mm
NE	1.8mm
EB	4.2mm
EE	2.5mm

## Paper grades for the outer and inner liners

<b>ABBAY REF</b>	<b>LINERS</b>
Y	Clay coated liner
W	White Top Kraft liner (WTK)
D	White Top recycled liner (WTT)
FBK	Fully Bleached Kraft liner
M	Mottled Kraft liner
K	Brown Kraft liner
L	Higher performance recycled liner (TL2)
T	Fully recycled liner (TL3)
C	Waste based liner
DL	Colour dyed natural liner
EL	Virgin fibre colour, embossed liner
AF	Foiled liner
BB	Brown barrier liner
PT	100% pre-print liner
PW	Pre-printed wallpaper liner
PR	Cut to register Pre-print

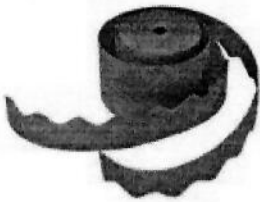
CL	Acrylic liner
AW	Printed AbbeyWrap rolls
BW	White barrier liner
DP	Digital printed liner
CS	Premium Coated AbbeyLite liner



## R-Flute®

R-Flute® delivers an improved printing substrate, machine line efficiencies and dramatic savings in logistics, whilst continuing to offer comparable performance characteristics.

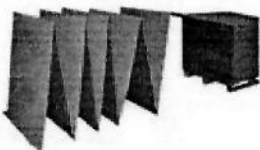
[Read more about R-flute](#)



## Abbey Single Face

This material is predominantly used in litho laminating applications. When combined with a printed top sheet, it provides additional strength and protection to a product.

[Read more about AbbeySingleFace](#)



## Fanfold

A completely versatile packaging material that delivers supply chain benefits by reducing stock inventory and material waste

Read more about Fanfold

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DS Smith Sheetfeeding > Insights > Glossary of terms

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<https://www.dssmith.com/sheetfeeding/insights/glossary-of-terms>

# Material Grades

Corrugated board is available in many different material grades with varying paper weights and finishes. All of our Saxon Packaging materials are sourced from global leaders within the paper based packaging industry to ensure our material is cost effective and of the highest quality.

Standard finishes include KRAFT (brown) white and mottled/oyster, LT (recycled paper) [...]

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Standard finishes include KRAFT (brown) white and mottled/oyster, LT (recycled paper) and TEST (recycled inner liner). White papers can be coated to provide superior substrate for greater print quality.

Standard paper thickness start at 125gsm (grams per square metre) and increase to 150gsm, 200gsm and 300gsm. Different flute weights are also available and depend on the strength of material required.

Standard flute profiles that we work with are Micro, E, S, B, C, BC and EB. Each of these materials are mentioned in greater detail below:



## 'Micro' Flute

750 – 900 microns (0.75mm – 0.9mm) in thickness and is used for high quality printed cartons, can be directly litho printed and is typically used for high quality shelf ready packaging, excellent printing surface.



## 'E' Flute

1100 – 1200 microns (1.1mm – 1.2mm) in thickness and gives excellent crush resistance and compression strength. It provides a high quality surface to print upon and is most commonly used in smaller cartons and die-cuts applications.



## 'S' Flute

2300 microns (2.3mm) in thickness S flute is balanced perfectly for both retail and transit packaging. It sits between E and B Flutes to provide the performance characteristics of B Flute, whilst producing the outstanding printability and strong crush resistance of E Flute.



#### **'B' Flute**

2700 – 2900 microns (2.7mm – 2.9mm) in thickness and probably the most common type of fluting. Seen in all types of applications including die-cut and regular cases it gives a good all-round performance.



#### **'C' Flute**

3500 – 3700 microns (3.5mm – 3.7mm) in thickness it offers greater compression strength than 'B' flute thus giving slightly better stacking strength for lighter products. It can be prone to more crushing if used in the wrong application.



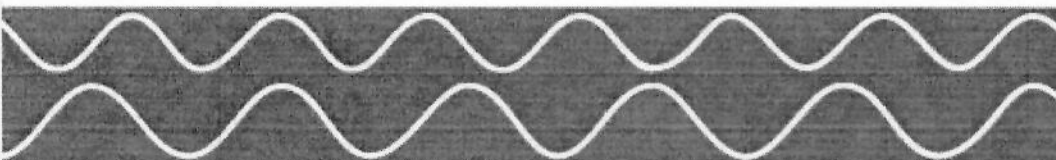
#### **'EB' Flute**

3800 – 4100 microns (3.8mm – 4.1mm) in thickness this is a double wall material combining the fine 'E' flute and the commonly used 'B' flute. The results give an excellent performance level in both print finish and impact protection.

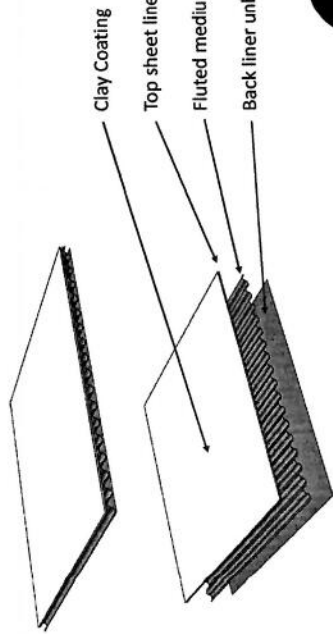


#### **'BC' Flute**

6200 – 6600 microns (6.2mm – 6.6mm) in thickness this is another double wall material that marries two flute profiles together – 'B' and 'C', both giving excellent all round performances this material is most often seen in shipping cases where a high protection level is required.



# Microflute



Sourcing of wood fibres & pulping process

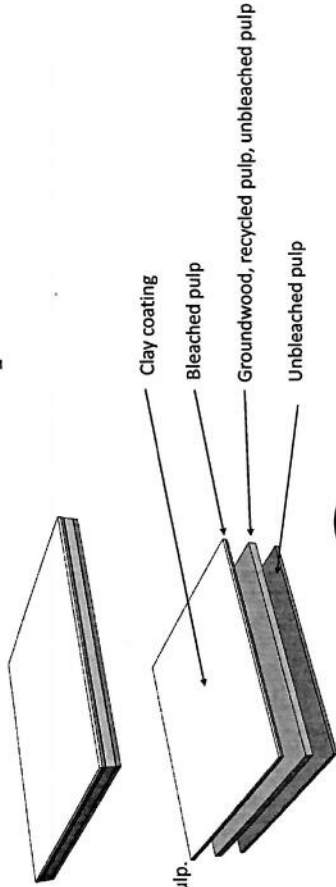
Sheet construction/paper making

Print outer layer then corrugate, and adhere the three layers

End-user conversion – die cut & glue

Customer sales

# Manufacture Process



Sourcing wood fibres & pulping process

Sheet construction/paper making, layering, coating

Bring together and adhere the three or more paper layers to form the solid paperboard sheet

End user conversion – print, die cut, glue

Customer sales



