

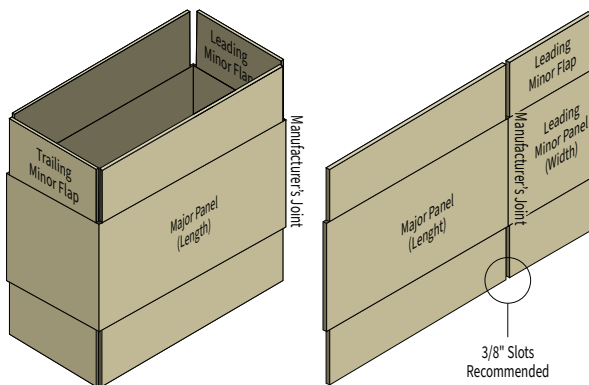
RECOMMENDED CORRUGATED SPECIFICATIONS

Whenever a process is automated, some changes must be made to the corrugate design for proper operation. Please immediately inform all your corrugate suppliers that you will be automating your corrugate folding and closing methods. Also, Combi recommends noting “cases must be manufactured to machine tolerances” on all your corrugate purchase orders.

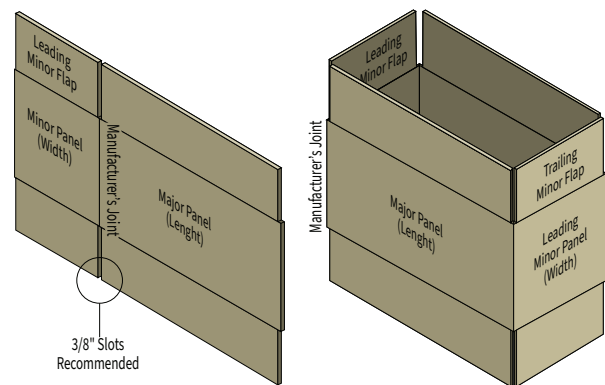
1. **CASE HAND:** Combi Packaging follows the ANSI Technical Report for Packaging Machinery prepared by PMMI. Note the case hand can dictate the flow of the machine and vice versa. Combi determines the direction of flow to be the direction the case travels while facing the control panel.

NOTE: Manufacturer’s Seal or Certificate is always on the bottom panel.

Left Hand Case



Right Hand Case



2. **SCORING:** For Regular Scored and Slotted Style Cases, Combi recommends “point to point” or “male to male” scoring on all end scores. For Die-Cut Style Cases, Combi recommends “high-rule, deep scoring” on end scores. Taper the minor flaps 1/4”-1/2” to avoid interference with major flaps. Offset the minor flaps from the major flaps by one caliper thickness of board.
3. **DOUBLE WALL CASES:** Specify “Crushed Relief Scoring”. Corrugated over 200-pound test corrugate may require extra heavy score lines. Some manufacturers call this “Point to Point” or “Male to Male”.
4. **SLOT WIDTH:** Slots must be clean-cut with a recommended minimum width of 3/8”. Slot width variance at the manufacturer joint (skew) should not exceed 3/16”. Slots shall extend passed the score lines a minimum of 3/16”.
5. **EXCESS GLUE:** Cases with glued manufacturer’s joint must be free of excess glue.
6. **FLAP LENGTH:** The flap length is to be made shy cut. When the major flaps are folded, there shall be a minimum 1/8” gap between them.
7. **WARPAGE:** -1/4” per foot is the maximum allowable warp when case is placed on flat surface. Bow is measured at the center of case.
8. **STORAGE:** Store knockdown cases in clean, warm, and dry location. “First In – First Out” inventory methods are recommended.