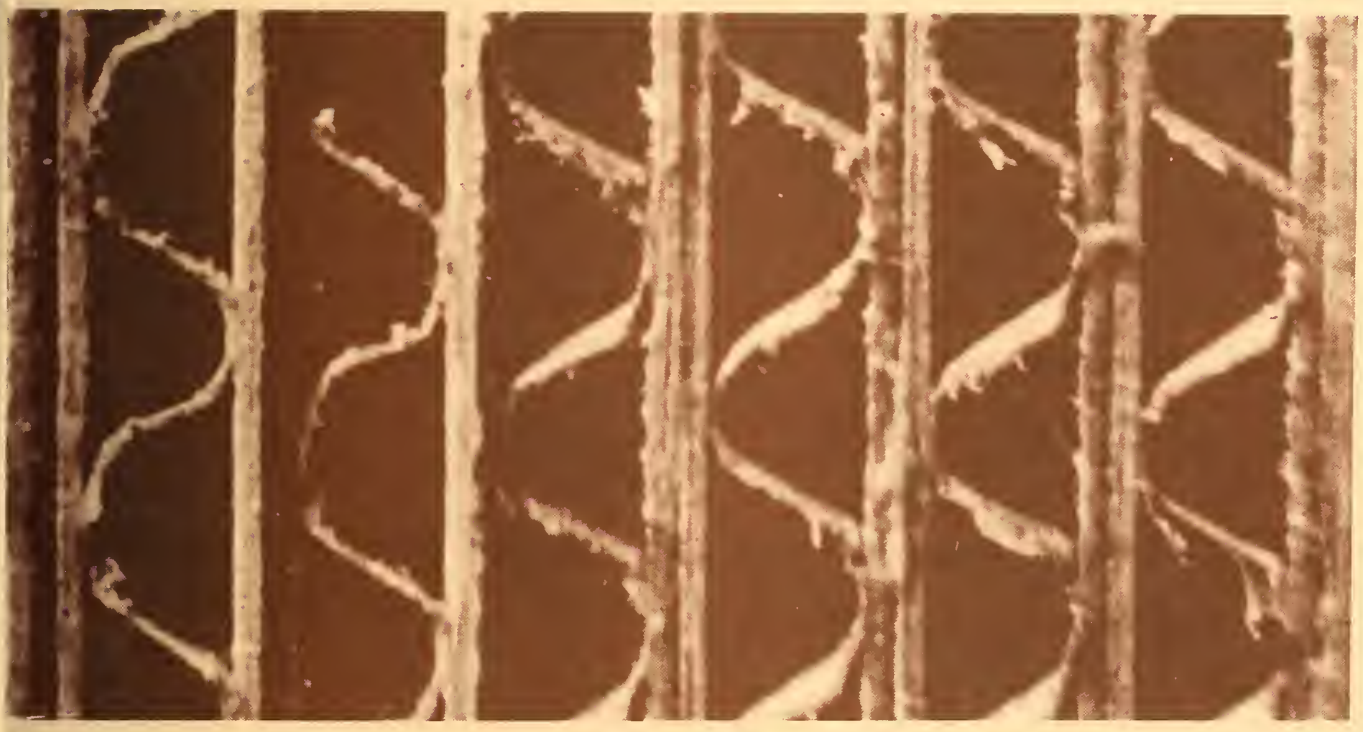
NBSIR 78-1328

CONTAINER BOARD

report no. 99
December 1977



NBS Collaborative Reference Program for Containerboard

Fourdrinier Kraft Board Group
American Paper Institute, Inc.
and U.S. Department of Commerce, National Bureau of Standards

AUTHENTICATED
U.S. GOVERNMENT
INFORMATION
GPO

NBS COLLABORATIVE REFERENCE PROGRAMS

TAPPI Paper and Board (6 times per year)

- Bursting strength
- Tearing strength
- Tensile breaking strength
- Elongation to break
- Tensile energy absorption
- Folding endurance
- Stiffness
- Air resistance
- Grammage
- Smoothness
- Surface pick strength
- K & N ink absorption
- pH
- Opacity
- Blue reflectance (brightness)
- Specular gloss, 75°
- Thickness
- Concora (flat crush)
- Ring crush

FKBG-API Containerboard (48 times per year)

- Mullen burst of linerboard
- Concora test of medium

MCCA Color and Appearance (4 times per year)

- Gloss at 60°
- Color and color difference
- Retroreflectivity

Rubber (4 times per year)

- Tensile strength, ultimate elongation and tensile stress
- Hardness
- Mooney viscosity
- Vulcanization properties

ASTM Textiles (3 times per year)

- Flammability (FF3-71 and FF5-74)

ASTM Cement (2 times per year)

- Chemical (11 chemical components)
- Physical (8 characteristics)

AASHTO Bituminous

- Asphalt cement (2 times per year)
- Cutbacks (once a year)



Collaborative Reference Programs
B360 Polymer Building
National Bureau of Standards
Washington, D.C. 20234

Rev. 4/77

CONTAINER BOARD

Collaborative Reference Program for Containerboard

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December 1977

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Fourdrinier Kraft Board Group
American Paper Institute, Inc.

NBSIR 78-1328

Introduction

The Collaborative Reference Program for Containerboard is sponsored by the Fourdrinier Kraft Board Group (FKBG) of the American Insititute of Paper, Inc., with the cooperation of the Technical Association of the Pulp and Paper Industry (TAPPI) and the Collaborative Testing Services, Inc. In this program, samples of three weights of linerboard, nominally 26 lb, 42 lb, and 69 lb and of corrugating medium (26 lb) are randomized separately from uniform narrow rolls and packaged for distribution to the participants. Each month, sufficient test material for four weekly tests, the material for each consisting of 20 test pieces of 42 lb board and 20 test pieces of 26 or 69 lb board, the latter in alternate months, is mailed to participants for Mullen bursting strength, or for each week five sheets of corrugating medium, each sheet for four tests of Concora flat crush strength. The participants return their test results to NBS for analysis and receive two monthly reports from NBS: a "preliminary" (individualized report) comparing a laboratory's results with the industrial mean, and a longer report (as illustrated by this report) showing the data from all participants.

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E B Randall, Jr

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Collaborative Reference Programs

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January 31, 1978

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10	Concora Flat Crush, Corrugating Medium 26C2

EXPLANATION OF TABLES

Each table shows laboratory test results for Mullen bursting strength of linerboard or Concora flat crush strength of corrugating medium. The data are divided into three time spans. On the left of each table is an analysis for each week of the month. In the center is cumulative data for the month and on the right is cumulative data for up to 16 weeks.

Conservative statistical tests have been used in excluding extreme data from the analyses. Thus, where the mean (average) for one laboratory is compared with the average for many laboratories, limits have been used that would exclude only one laboratory in a hundred if all laboratories followed exactly the same testing procedure. Consequently, laboratories receiving "X" flags should review their testing procedures, instrument calibration, and control processes. Similar conservative criteria were used in flagging within-laboratory standard deviations and other statistics.

	LAB		MEANS THIS MONTH			
WEEKLY VALUES:	CODE	V	WK-1	WK-2	WK-3	WK-4

LAB CODE - Confidential laboratory identification number known only to the participant and the Collaborative Reference Program staff.

V - Code for indicating instrument type, units used, and any other variation in test procedure or conditions. A '+' in this column means a non-standard variation. Data marked '+' are not included in the combined averages for all laboratories. (see page 4).

MEANS THIS MONTH - For each laboratory each weekly mean is the average of individual test determinations, usually an average of 20 determinations.

FLAGS (following means and standard deviations) -

X - Data excluded from an AV MEAN or average standard deviation because value deviated from the AV MEAN or average standard deviation by more than 2.576 times the appropriate standard deviation. A laboratory following the prescribed test method could obtain such an extreme value by chance only one time in a hundred. Corrective action is almost certainly required.

* - Data included in the CUMULATIVE AV MEAN but the value deviated from this mean by more than 1.960 and less that 2.576 times the SD CUM MEAN. A laboratory following the prescribed test method could obtain such an extreme value by chance only one time in twenty. Corrective action may be desired.

S - This is a warning to the laboratory but does not affect inclusion or exclusion of the laboratory's results from the corresponding AV MEAN. This flag indicates an extremely high or low within-laboratory standard deviation (SDR, not shown) that could occur by chance only one time in a hundred if the laboratory is following the prescribed test method.

AV MEAN - (at bottom of table) - The average for the indicated week of the means for all laboratories, except those laboratories marked '+' in column V and those means marked with an 'X'.

SDR - (not shown) - The standard deviation of within-laboratory measurements; i.e., the Standard Deviation of the Replicate measurements made at one time in one laboratory on one package of test pieces.

AV SDR - The average for the indicated week of the SDR's of all the laboratories, except those omitted from the AV MEAN. Also an extremely high or low SDR as compared with the AV SDR based on the remaining laboratories is omitted from the AV SDR and the letter 'S' is placed after the laboratory mean for that week. The AV SDR is an index of the within-laboratory precision for repeated measurements; i.e., a measure of the ability of an average laboratory to repeat its results over a short period of time. It includes measurement error and sample variation.

SD LABS - For each week the standard deviation of the means about the AV MEAN for that week after omitting those means marked with an 'X' or noted '+' in column V. The SD LABS is an index of the among-laboratory precision of the test method as applied by the participating laboratories; i.e., a measure of the ability of laboratories to get comparable results.

NO. INCL - The number of laboratory means included in the AV MEAN for that week.

NO. OMIT - The number of laboratory means reported but omitted from AV MEAN because of non-standard equipment, environment or procedure ('+' in column V) or because of extreme results (X following mean).

NOT RCD - The number of laboratories failing to report data on time or in usable form for this week (but who reported data for at least one of the other weeks of this month), or who received test pieces from a different sample of material and whose data therefore are shown in another table of this report.

SD SHTS - (Concora only) The average for the indicated week of the among-sheet within-laboratory standard deviations. The SD SHTS is an index primarily of the variability among sheets.

VALUES THIS MONTH:

THIS MONTH
MEAN SDR SDWKS

MEAN - The average for the indicated laboratory of the reported weekly MEANS THIS MONTH.

SDR - The average for the indicated laboratory of the weekly SDRs for the current month.

SDWKS - For the indicated laboratory, the standard deviation among the laboratory's weekly MEANS THIS MONTH (including those means marked with an 'X').

CUMULATIVE VALUES:

CUMULATIVE
MEAN SDR SDWKS WKS

MEAN - The average for the indicated laboratory of all its weekly means for the number of weeks indicated, including those for the current month. An '*' or 'X' following this CUMULATIVE MEAN indicates the laboratory is running consistently low or high. (See above for explanation of these flags).

SDR - The average for the indicated laboratory of the weekly SDRs for the indicated number of weeks.

SDWKS - For the indicated laboratory, the standard deviation among the laboratory's weekly means (including those means marked with an 'X'). SDWKS is an index of the week to week precision; i.e., a measure of the ability of a laboratory to repeat its results from week to week.

WKS - Number of weeks for which usable results have been reported by that laboratory. At most, 16 weeks of data are included.

GRAND AVERAGES:

GRAND AVERAGES
THIS MONTH CUMULATIVE 12 WEEKS

THIS MONTH - Averages for the four weeks of the quantities shown to the left.

CUMULATIVE - Averages for the indicated number of weeks, including the four weeks of the current month.

AV SDWKS - The average of the SDWKS for all laboratories excluding those marked '+' in column V or with an 'X' following the corresponding THIS MONTH or CUMULATIVE MEAN or SDWKS.

SD CUM MEAN - The larger of either (1) the standard deviation of the CUMULATIVE MEANS about the average CUMULATIVE MEAN after omitting those CUMULATIVE MEANS marked with an 'X' or with a '+' in column V, or (2) the CUMULATIVE SD LABS divided by the square root of the number of weeks cumulated. The former will be appreciably larger than the latter only when there are persistent systematic differences among the laboratories.

INSTRUMENT CODES FOR MULLEN BURST TESTERS (Column V)

CODE	DESCRIPTION
A	Unknown Model, assumed to be Model AH, Hydraulic Clamp
B	Model A, Air Operated Clamp
C	Model A, Hand Operated Clamp
D	Model AH, with Pressure Transducer
E	Model A, Converted to AH
F	Model AH, Hydraulic Clamp
G	Model A, Hydraulic Clamp
Z	Unknown Model, Please Describe Instrument Make and Model

If an incorrect instrument code has been assigned to your laboratory, please inform us.

Use of Average Mean as a Reference Standard

A large supply of linerboard in three weights was randomized and placed in sealed packages ready for shipment. The supply for each weight of board was divided into several narrow "rolls" or cross-machine "positions" of a larger roll, and each position was separately randomized. Each package contains test pieces from one position only. The position is designated by the number following the letter in the code marked on the package. Thus 42H 1 indicates that this package contains 42 lb board from position 1 of lot H. Samples from the first position are distributed until exhausted, then from the second position, and so forth for each weight of board. Thus for short periods of time (several weeks to months), the samples that the participants test are from the same position of a lot, and for a longer period from the same lot.

The three weights of linerboard distributed in this program may be used as reference standards. The best reference values are the cumulative grand AV MEANs in the latest reports. These values are given at the bottom right of each table. For each weight of board, comparisons should be made first for measurements made on the same position, i.e., for checking your current measurement, use grand AV MEANs that have the same position code as on the packages being tested. The position is shown in the upper left corner of the table. If no report is yet available on the current position, grand AV MEANs from previously tested positions of the same lot may be used as approximate reference values.

Similarly a large supply of a 26 lb corrugating medium was randomized, after dividing into several narrow rolls or positions. The above discussion for linerboard also applies to the corrugating medium.

We are currently using the third lot of linerboard and the second lot of corrugating medium:

Lot	Material	Codes	Used
1	linerboard	A,B,C	October 1969 - April 1973
2	linerboard	D,E,F	September 1972 - September 1976
3	linerboard	G,H,I	October 1976 -
1	corrugating medium	(A)	May 1973 - March 1976
2	corrugating medium	B	April 1976 - February 1977
3	corrugating medium	C	March 1977 -

REPORT NO. 99

BURSTING STRENGTH (MULLEN), PSI

LAB CODE	V	MEANS THIS MONTH WK-1	WK-2	WK-3	WK-4	THIS MONTH MEAN	SDR	SDWKS	CUMULATIVE MEAN	SDR	SDWKS	WKS
100	A	122.6	123.7	121.6	119.5	121.9	9.2	1.8	122.4	8.8	1.5	10
101	F	120.4	120.9	120.6	119.9	120.4	5.0	.4	118.2	5.2	2.4	10
103	A	116.4	118.6S	120.4	120.2	118.9	6.8	1.8	115.5	8.5	4.5	10
105	A	114.8	111.8	115.1	117.3	114.8	9.7	2.3	116.7	10.1	3.8	10
106	A	121.4	118.9	122.1	119.0	120.4	9.3	1.6	120.2	10.8	1.5	10
107	C	122.6	123.9	116.9	125.8	122.3	8.4	3.8	121.0	8.3	2.7	10
108	D	123.0	123.7	119.6	127.2	123.4	11.3	3.1	124.3	10.2	2.6	10
109	F	120.2	122.4	120.2	120.5	120.8	10.5	1.1	118.2	10.0	2.8	10
110	D	124.4	127.5	118.5	115.4	121.5	7.4	5.5	121.0	7.3	4.4	6
111	D	120.8	122.1	117.5	126.2	121.7	8.7	3.6	122.5	10.1	3.6	10
112	A	123.7	129.0	129.7X	119.0	125.4	11.6	5.0	124.9	10.8	4.4	10
113	B	121.4	120.5	121.3	119.8	120.8	8.1	.7	121.1	7.3	1.3	10
114	C	125.5	126.1	121.4	126.2	124.8	9.8	2.3	123.9	10.7	2.3	10
115	B	121.1	124.5	121.5	124.1	122.8	7.4	1.8	120.4	8.3	2.9	10
116	B	121.9	121.7	119.5	119.2	120.6	8.3	1.4	119.7	8.3	1.7	7
117	A	119.6	117.9	115.3	114.7	116.9	7.0	2.3	119.0	7.9	3.0	10
119	A	118.1	118.7			118.4	10.2	.4	117.7	9.2	5.7	6
120	B	125.8	124.6	114.9	118.7	121.1	9.1	5.2	119.2	10.8	3.5	10
121	D	124.6	122.0	128.0	119.0	123.4	8.5	3.8	125.3*	8.1	4.0	10
123	A	126.0	125.5	124.3		125.3	10.2	.9	125.8*	9.2	1.8	9
125	F	120.4	125.7	118.8	121.7	121.7	6.7	3.0	120.4	7.5	2.9	10
127	A	123.8	123.2	121.2	121.3	122.4	6.9	1.3	122.6	6.2	1.1	10
128	F	118.4	127.5	122.6	125.8	123.6	9.0	4.0	122.9	8.7	2.6	10
129	A	120.4	123.7	117.0	125.5	121.6	8.4	3.8	119.9	7.1	2.9	10
130	A	121.9	123.3	125.0	123.7	123.5	9.8	1.3	124.8	9.0	2.2	10
131	B	125.1	120.2S	116.2	116.4	119.5	11.7	4.2	120.0	10.5	4.2	10
133	B	121.4	121.1	119.2	117.9	119.9	7.5	1.6	119.8	8.0	1.4	10
134	F	115.9	117.5	120.4	125.8	119.9	8.0	4.4	118.9	7.5	3.1	10
135	A	118.0	118.6	118.2	120.4	118.8	10.0	1.1	120.4	9.9	2.8	10
136	A	116.0	116.6	116.7	116.5	116.5	6.7	.3	116.4	6.7	.8	8
137	F	113.3	115.1	116.4	116.2	115.3	9.3	1.4	117.0	10.0	2.3	10
138	A	122.4	128.3	125.0	126.5	125.6	10.1	2.5	126.9X	9.8	2.8	10
139	B	121.5	124.3	123.0	122.4	122.8	10.6	1.2	120.4	9.5	2.4	10
140	F	114.1	115.7	117.1	115.8	115.7	5.8	1.2	118.3	5.5	5.2	10
141	F	118.6	117.1	114.3	114.6	116.2	6.8	2.0	115.8	6.7	3.6	8
142	C	123.4	121.2	121.4	126.0	123.0	8.2	2.2	121.9	8.8	2.0	10
143	B	122.2	121.7	121.0	122.0	121.8	7.5	.5	122.2	7.9	2.3	9
145	F	122.2	122.9		119.1	121.4	7.0	2.0	120.7	6.6	2.4	6
147	A	116.8	118.9	115.3	118.5S	117.4	12.0	1.7	118.0	11.0	1.3	10
149	F	121.4	127.9	119.8	116.3	121.4	9.0	4.9	121.2	9.6	3.2	10
151	F	119.2	121.0			120.1	6.3	1.2	120.9	7.5	.8	7
153	F		130.1	129.4X	128.5	129.3X	7.2	.8	129.9X	7.6	.9	7
155	F	120.5	119.3	121.2	117.9	119.7	8.4	1.5	117.3	8.1	3.2	10
157	A	110.6X	117.5	110.9		113.0	8.8	3.9	116.9	8.5	5.2	9
159	A	120.1	121.7	118.3	117.6	119.4	8.1	1.9	117.8	9.5	2.3	10
161	A	125.7	122.5			124.1	9.9	2.2	120.7	10.5	4.7	6
165	B	111.9X	112.5	122.3		115.6	9.6	5.9	115.9	9.3	4.2	9
166	F	117.0	121.4	111.7	114.7	116.2	9.7	4.1	115.9	7.6	3.6	10
167	F	115.2	115.8	115.7	119.4	116.5	6.4	1.9	117.8	6.2	3.0	10
168	A	115.5	109.5X	115.5S	118.2	114.7	12.8	3.7	122.3	10.5	7.0X	10
169	A	120.5	120.4	122.6	123.6	121.8	9.5	1.6	121.1	9.1	1.4	10
170	A	117.4	119.9	113.4	116.2	116.7	8.9	2.7	120.7	9.6	4.2	10
171	A	118.7	121.5	122.6	117.8	120.2	7.7	2.3	119.2	7.3	1.8	10
172	A	121.1	121.5	121.2	120.3	121.0	6.9	.5	122.5	6.7	1.6	10
173	A	122.4	122.5S	123.8	125.0	123.4	4.4	1.2	122.2	5.7	1.4	10

LINERBOARD 42#S | COLLABORATIVE REFERENCE PROGRAM | DECEMBER 1977

REPORT NO. 99

BURSTING STRENGTH (MULLEN), PSI

LAB CODE	V	MEANS THIS MONTH WK-1	WK-2	WK-3	WK-4	THIS MONTH MEAN	SDR	SDWKS	CUMULATIVE MEAN	SDR	SDWKS	WKS
174	A	115.3	124.2	120.9	119.4	120.0	11.6	3.7	120.6	10.7	2.6	10
175	A	123.9	128.3	130.1X		127.4	7.8	3.2	122.5	8.5	5.4	9
176	A	117.7	118.8	119.2	114.8	117.6	9.0	2.0	118.5	8.6	3.0	10
177	A	117.3	108.7X			113.0	9.1	6.0	111.6X	8.8	5.0	7
178	A	124.2	118.8	121.2		121.4	7.3	2.7	123.9	8.2	2.9	9
182	A	118.9	119.2	118.2	118.4	118.7	8.7	.4	119.3	8.9	2.5	10
184	F	121.3	116.6	122.7	120.5	120.3	7.9	2.6	121.9	9.2	2.6	10
186	E	116.5	118.4	121.8		118.9	6.6	2.7	117.9	6.6	3.0	9
188	E	122.6	122.6	118.9	119.4	120.9	8.1	2.0	120.4	7.6	2.2	10
198	B	118.6				118.6	6.6		118.1	7.1	1.7	6
274	A	120.6	121.9	121.5	122.7	121.7	6.8	.9	121.6	6.9	1.3	10
283	A	121.6	121.3	122.6	122.0	121.9	5.1	.6	121.1	5.6	.9	10
287	C	122.6	122.3	115.2	120.2	120.1	8.1	3.4	118.0	8.8	3.9	10
313	A	126.8	128.5	128.9	129.6	128.4X	7.8	1.2	127.3X	7.4	2.4	9
327	F	113.8	114.7	114.2	122.5	116.3	9.9	4.2	118.5	9.8	3.3	10
350	F	121.2	121.4S	121.9	110.4XS	118.7	11.6	5.5	117.8	9.9	3.8	10
375	G	123.1	116.8	118.9	118.3	119.3	8.0	2.7	120.0	8.7	3.3	10
562	A	123.2	121.2	119.1	122.0	121.4	9.7	1.7	125.1	10.3	5.1	10
568	A	116.6	115.9	116.7	110.1X	114.8	9.9	3.2	119.6	10.1	5.8	10
569	A	115.2	116.8	120.0	115.6	116.9	7.8	2.2	119.6	8.6	4.3	10
590	A	120.7	114.3	98.6X	98.8X	108.1X	9.4	11.2	112.5X	9.3	7.5X	10

	WK-1	WK-2	WK-3	WK-4
AV MEAN	120.4	121.2	119.5	120.5
AV SDR	8.4	8.6	8.5	8.4
SD LABS	3.3	4.0	3.5	3.8
NO.INCL	73	73	66	62
NO.OMIT	2	2	4	3
NOT RCD	1	1	6	11

GRAND AVERAGES

	THIS MONTH	CUMULATIVE 10 WEEKS
AV MEAN	120.4	120.3
AV SDR	8.5	8.4
SD LABS	3.6	3.7
NO.INCL	68.5	68.8
AV SDWKS	2.5	2.9
SD CUM MEAN		2.5

REPORT NO. 99

BURSTING STRENGTH (MULLEN), PSI

LAB CODE	V	MEANS THIS MONTH WK-1	WK-2	WK-3	WK-4	THIS MONTH MEAN	SDR	SDWKS	CUMULATIVE MEAN	SDR	SDWKS	WKS
100	A	76.3	73.5	72.7	72.9	73.9	7.7	1.7	74.1	7.1	1.8	16
101	F	74.3	74.7	74.5	75.0	74.6	6.0	.3	74.8	6.1	1.1	12
103	A	74.6	74.1	76.4	75.7	75.2	5.6	1.0	73.7	6.0	1.6	15
105	A	72.0	74.9	71.1	75.9	73.5	7.8	2.3	73.5	7.7	2.5	12
106	A	73.1	76.2	72.7	74.4	74.1	7.1	1.6	74.0	7.6	2.2	16
107	C	75.0	76.0	76.8	73.4	75.3	6.7	1.5	75.5	7.0	1.7	16
108	D	72.9S	77.6	75.9	76.2	75.7	7.7	2.0	75.2	8.0	2.7	16
109	F	73.7	73.7	74.0	73.7	73.8	7.0	.2	73.7	6.6	.7	16
110	D	78.9	81.1	80.0	72.3	78.1	6.4	3.9	77.7	6.6	2.8	15
111	D	77.7	78.5	76.3	76.6	77.3	6.0	1.0	78.7	7.3	2.5	16
112	A	76.7	77.5	78.7	74.9	77.0	6.7	1.6	76.1	7.0	1.5	15
113	B	74.3	74.5	74.6	75.0	74.6	6.3	.3	75.1	6.2	.9	16
114	C	76.7	77.3	72.5	80.0	76.6	8.0	3.1	76.4	6.5	2.5	16
115	B	73.1	72.1	72.2	72.5	72.5	5.7	.4	72.2	6.7	1.8	15
116	B	76.9	76.7	73.9	77.5	76.3	8.7	1.6	75.7	7.2	2.4	13
117	A	81.3	76.9	74.7	77.2	77.5	6.3	2.7	76.2	5.5	2.6	16
119	A	76.4	77.0			76.7	5.6	.5	72.9	6.8	3.1	12
120	B	73.7	76.2	77.2	82.1	77.3	6.1	3.5	73.8	6.9	3.1	16
121	D	78.1	78.6	82.6X	77.4	79.2	8.0	2.3	78.7	8.0	3.5	16
123	A	78.4	83.0X	80.1		80.5	6.4	2.4	74.8	6.9	4.9X	15
125	F	75.3	80.7	78.7S	74.8	77.4	7.9	2.8	78.1	6.9	2.5	16
127	A	72.9	75.3	74.9	75.8	74.7	5.1	1.3	74.3	5.1	1.0	16
128	F	81.1	83.4X	77.2	78.5	80.0	6.5	2.8	77.7	7.2	2.8	16
129	A	75.2S	74.9S	77.8	78.4	76.6	6.7	1.8	74.7	4.4X	2.1	15
130	A	80.1	81.4	80.5	78.8	80.2	7.6	1.1	79.8*	7.6	1.6	15
131	B	72.2	73.5	70.2	74.1	72.5	8.8	1.7	74.0	8.3	4.0	16
133	B	75.9	73.8	75.7	73.9	74.8	6.6	1.1	73.4	6.2	2.3	16
134	F	76.6	74.3	76.8	78.4	76.5	7.5	1.7	74.0	7.1	2.6	16
135	A	72.5	70.6	73.1	72.3	72.1	8.7	1.1	71.6	8.1	3.1	15
136	A	72.4	74.2	71.3	72.4	72.6	6.3	1.2	73.7	5.9	1.0	12
137	F	67.7	69.1	69.7	68.5	68.8X	8.1	.9	70.4*	7.4	2.2	15
138	A	80.2	75.8S	79.9	79.8	79.0	9.6	2.1	78.8	8.1	2.2	16
139	B	76.1	76.3	73.4	72.2	74.5	9.5	2.0	75.7	8.1	1.6	16
140	F	74.9	71.0	76.5	74.4	74.2	4.4	2.3	75.6	5.9	1.8	16
141	F	72.5	71.8	72.7	72.7	72.4	5.5	.4	73.0	4.9	.8	12
142	C	68.6	70.6	73.4	75.8	72.1	7.1	3.2	72.2	8.1	2.4	16
143	B	74.2	75.6	75.6	75.5	75.2	7.7	.7	73.8	6.8	2.0	16
145	F	82.0	75.9		81.7	79.9	6.4	3.5	77.9	6.0	3.8	9
147	A	71.8	68.2	70.6	71.7	70.6	8.2	1.7	74.7	7.3	3.0	16
149	F	77.5	81.1	76.4	73.0	77.0	6.0	3.4	78.2	6.2	2.5	15
151	F	75.0	77.5			76.3	7.2	1.8	75.5	6.6	1.0	14
153	E		76.0	76.0	75.5	75.8	4.6	.3	76.6	5.3	1.2	15
155	F	74.5	72.7	74.3	71.9	73.4	6.7	1.2	73.4	6.5	1.4	15
157	A	78.0	76.4	73.1		75.8	7.9	2.5	78.5	7.8	5.7X	15
159	A	73.3	72.7	72.0	73.5	72.9	7.3	.7	72.8	7.7	1.7	15
161	A	74.9	77.9			76.4	8.7	2.2	75.7	7.6	2.8	10
165	B	71.9	70.0	76.2		72.7	7.2	3.3	72.9	7.2	3.3	15
166	F	69.7	71.5	70.2	71.6	70.8	6.7	1.0	74.1	6.3	3.9	16
167	F	74.1	76.1	72.8	73.5	74.1	6.3	1.4	74.5	5.3	2.5	16
168	A	68.3	64.6X	69.7S	64.0X	66.7X	9.8	2.8	74.7	8.6	5.5X	16
169	A	80.0	78.6	80.4	81.3	80.1	8.2	1.1	79.0*	7.8	1.7	15
170	A	73.1	76.5	72.2	71.6	73.4	9.2	2.2	73.4	8.2	2.0	16
171	A	71.3	73.4	73.6	75.3	73.4	7.1	1.6	72.6	7.0	1.6	15
172	A	74.7	78.7	77.5	76.4	76.8	6.5	1.7	76.6	6.5	2.0	16
173	A	74.2	75.5	76.2	78.4	76.1	6.2	1.8	76.0	6.4	1.2	15

LINERBOARD 26G2 COLLABORATIVE REFERENCE PROGRAM DECEMBER 1977

REPORT NO. 99

BURSTING STRENGTH (MULLEN), PSI

LAB CODE	V	MEANS THIS MONTH WK-1	WK-2	WK-3	WK-4	THIS MONTH MEAN	SDR	SDWKS	CUMULATIVE MEAN	SDR	SDWKS	WKS
174	A	68.6	69.9	73.0	73.5	71.3	7.1	2.4	71.2	6.9	2.1	16
175	A	80.5	83.8X	91.0X		85.1X	7.4	5.4	76.8	7.2	5.8X	15
176	A	72.8	76.7	71.4	74.6	73.9	7.2	2.3	74.5	7.6	2.1	16
177	A	75.4	72.9			74.2	6.7	1.8	72.6	6.4	4.4X	13
178	A	71.4	68.6	73.5		71.2	7.4	2.5	76.1	7.3	3.4	15
182	A	78.2	74.8	75.5	73.9	75.6	8.0	1.9	76.5	7.9	2.7	16
184	F	76.3	74.5	78.3	79.6	77.2	6.6	2.2	75.2	6.5	2.4	15
186	E	73.1	73.5	73.9		73.5	4.3	.4	74.3	4.7	1.4	15
188	E	75.6	74.0	73.8	74.9	74.6	7.4	.8	76.0	6.3	1.5	16
198	B	75.4				75.4	5.8		73.8	6.9	1.9	13
274	A	74.9	74.7	74.8	75.2	74.9	5.2	.2	74.2	4.9	.6	16
283	A	73.2	76.5	75.5	76.4	75.4	6.3	1.5	74.5	5.4	1.2	16
287	C	76.5	77.9	76.7	77.4	77.1	6.1	.7	76.1	7.4	3.6	16
313	A	86.4X	88.1X	86.5X	85.7X	86.7X	6.0	1.0	86.8X	5.6	.9	8
327	F	75.5	76.3	77.4	73.8	75.8	7.0	1.5	77.0	7.5	2.2	16
350	F	76.1	74.3	72.8	73.3S	74.1	7.9	1.5	74.8	7.5	1.8	16
375	G	72.9	72.3	75.3	77.8	74.6	7.9	2.5	74.8	8.3	2.5	16
562	A	76.3	76.0	76.1	80.0	77.1	7.2	1.9	77.2	7.7	1.9	8
568	A	71.6	72.4S	73.2	71.2	72.1	7.5	.9	73.4	7.3	1.7	16
569	A	71.9	73.1	73.2	74.8	73.3	6.3	1.2	73.6	6.5	2.3	16
590	A	69.3	73.8	62.2X	60.5X	66.4X	7.4	6.2	69.1X	6.5	4.2	15

	WK-1	WK-2	WK-3	WK-4	GRAND AVERAGES THIS MONTH	CUMULATIVE 16 WEEKS
AV MEAN	74.8	75.0	74.8	75.4	AV MEAN 75.0	75.0
AV SDR	7.0	7.1	6.8	6.8	AV SDR 6.9	6.9
SD LABS	3.1	2.9	2.7	2.9	SD LABS 2.9	2.8
NO.INCL	74	70	66	62	NO.INCL 68.0	69.4
NO.OMIT	1	5	4	3	AV SDWKS 1.8	2.1
NOT RCD	1	1	6	11	SD CUM MEAN	2.0

REPORT NO. 99

FLAT CRUSH STRENGTH (CONCORA), LB

LAB CODE V	MEANS THIS MONTH WK-1	WK-2	WK-3	WK-4	THIS MONTH MEAN	SDR	SDWKS	CUMULATIVE MEAN	SDR	SDWKS	WKS
100	63.9	63.2	62.2	62.3	62.9	2.5	.8	63.3	2.7	1.2	12
102	63.3	63.1	63.0	64.4	63.5	2.7	.7	63.2	2.6	.5	8
105	62.2	64.2	61.3	61.9	62.4	3.5	1.3	65.0	3.7	4.4X	12
106	65.2	64.3	62.2S	64.1	63.9	3.5	1.3	65.2	3.5	1.6	12
110	60.2	63.1	61.8	62.7	62.0	2.8	1.3	63.4	2.5	2.1	8
113	64.6	63.0	62.7	65.2	63.9	2.6	1.2	63.6	2.7	.9	12
114	62.1	62.7	63.6	63.4	63.0	3.2	.7	62.5	3.0	1.2	12
115	65.5	66.6	67.7	63.3	65.8	2.6	1.9	64.0	2.5	2.0	12
116	60.9	61.6	61.0	61.0	61.1	2.1	.3	61.2	2.2	.4	10
119	62.6	61.8			62.2	3.0	.6	62.4	3.2	1.1	8
120	66.8	62.6	69.0X	65.4	66.0	3.1	2.7	63.9	3.2	2.7X	12
125	68.7X	68.9X	66.3	66.3	67.5	2.9	1.4	67.2*	3.0	1.7	12
128	62.0	61.7	61.6	61.0	61.6	3.2	.4	62.1	3.0	.8	12
138	63.8	65.3	64.1	65.1	64.6	3.3	.7	64.7	3.4	1.0	12
140	64.9	65.4	62.1	63.9	64.1	2.9	1.5	64.2	3.1	1.2	12
143	62.0	61.2	61.7		61.6	2.1	.4	62.1	2.6	.7	11
161	65.8	68.4X			67.1	3.4	1.8	65.5	3.4	2.0	6
164	62.0	64.4	62.1		62.9	2.6	1.3	62.9	2.8	.9	11
167	63.7	63.3	63.2	64.2	63.6	2.6	.5	64.1	2.8	.8	12
177	59.5	63.1			61.3	2.4	2.5	62.1	2.4	1.7	9
182	62.6	64.9	67.6	68.9X	66.0	3.0	2.8	64.7	2.9	1.9	12
188	60.1	61.3	62.4	61.7	61.4	1.9	.9	61.6	2.3	.9	12
198	61.7				61.7	3.3		63.0	3.6	1.5	9
237	62.3	59.9	61.7	62.6	61.7	3.0	1.2	62.4	2.9	1.0	12
269	61.6	62.3	61.4	61.1	61.6	1.8	.5	61.9	2.3	1.0	12
274	63.4	63.3	63.4	63.3	63.4	1.8	.0	63.7	1.8	.4	12
283	64.0	64.5	63.5	64.1	64.0	1.9	.4	64.0	1.9	.3	12
284	65.2	64.0	62.7	64.2	64.1	3.4	1.0	64.2	3.2	1.6	12
287	63.9	64.6	66.1	66.5	65.3	3.4	1.2	65.3	3.8	1.0	12
292	61.3	61.3	60.5	63.5	61.7	2.6	1.3	61.1	2.6	1.4	12
350	66.0	67.0	65.0	71.0XS	67.3	3.5	2.6	66.8*	2.7	1.7	12
351	61.2	62.1	67.1	63.3	63.5	1.9	2.6	61.7	2.0	2.0	12
353	62.7	62.4	64.0		63.1	2.4	.9	63.5	2.5	1.3	11
355	62.9	62.0	57.5X	61.3	60.9	2.8	2.4	61.8	2.6	1.7	12
357	61.6	63.9	64.3	62.6	63.1	2.4	1.2	63.4	2.2	.9	11
361	63.7	63.1	63.8	63.7	63.6	2.1	.3	64.3	2.1	1.3	10
363	60.5	60.1S	62.5	61.1	61.1	3.5	1.0	61.4	3.2	1.1	12
365	60.9	58.8X	60.7	62.2	60.7	2.6	1.4	59.8*	2.7	1.6	12
369	63.7	62.6	62.2	62.8	62.8	2.9	.7	63.0	2.9	.7	12
377	63.5	61.8			62.7	2.2	1.2	63.5	2.9	1.8	10
379	61.3	63.4	63.6		62.8	3.2	1.3	63.6	3.1	1.6	11
381	61.7	62.8	62.3	63.1	62.5	2.3	.6	62.2	2.6	.8	12
383	65.4	62.5	61.7	62.2	63.0	3.0	1.6	63.1	3.0	1.4	12
385	66.9	62.3	61.2	64.5	63.7	2.8	2.5	62.5	3.1	2.3	12
387	62.5	62.3	63.4	61.3	62.4	2.9	.9	63.1	2.9	1.7	12
391	60.8	64.2	64.4	64.4	63.5	2.4	1.8	62.8	2.6	2.1	11
393	63.9	62.3	64.3	63.4	63.5	2.5	.9	63.0	2.3	.8	12
395	64.9	64.5	65.5	64.7	64.9	2.8	.4	65.0	3.0	.8	11
397	64.7	64.8	65.3	65.8	65.2	3.0	.5	64.4	2.9	1.6	12
399	65.6	63.0	59.7	61.0	62.3	2.2	2.5	62.1	2.6	1.8	12
555	68.3X	67.1S	66.0	66.4	67.0	3.8	1.0	67.0*	3.8	1.0	4
562	61.8	63.7	64.6S	62.1	63.1	3.8	1.3	63.6	3.5	1.1	12
568	62.4	62.3	61.2	64.3	62.6	2.8	1.3	61.2	3.1	1.4	12
572	68.3X	64.9	68.2	66.0	66.9	3.3	1.7	65.8	3.5	1.7	10
578	61.7	38.8X	62.7	63.8	56.7X	2.8	12.0	61.7	3.2	7.8X	12
579	64.2	66.5S	67.9	66.9	66.4	3.6	1.6	66.4*	3.6	1.6	4

	WK-1	WK-2	WK-3	WK-4
AV MEAN	63.1	63.3	63.4	63.5
AV SDR	2.7	2.6	2.8	2.8
SD LABS	1.8	1.6	2.1	1.6
NO.INCL	53	51	49	45
NO.OMIT	3	4	2	2
NOT RCD	0	1	5	9
SD SHTS	2.0	1.9	2.1	1.9

GRAND AVERAGES

	THIS MONTH	CUMULATIVE 12 WEEKS
AV MEAN	63.3	63.2
AV SDR	2.7	2.8
SD LABS	1.8	1.8
NO.INCL	49.5	50.7
AV SDWKS	1.4	1.3
SD CUM MEAN		1.6

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