



Mill Paperboard Specifications Roll Quality Specifications – Liner and Medium

Objective: Expectations are shipments that are free from damage and run efficiently on the corrugator.

SPECIFICATIONS (rev. 7-31-20)

- Roll Cores:** Length: -0", +1/8"
Wall thickness: .250" minimum
Roll core plugs: Core plugs required on each end
Diameter: 4" ID
**** No spliced cores allowed****
- Winding conditions:** Rolls must have a straight edge – No variation over +/- 1/8"

Splices: Identification: Marked on both ends of the roll:
- Maximum 2 splices per roll
 - No splices within 2" of the top
 - No 2 splices within 1" of each other
 - No splices within 6" of the core
- Roll Diameter:** Not to exceed Target of 58 1/2" / must not go below 54" w/o customer permission
[Rail must be ~58" (57 1/2" to 58 1/2") to create stagger for optimum loading]
- Proper Width:** Maximum + 1/8", less than ordered width spec will not acceptable
- Hardness:** Target = 40 (Roll Average), maximum variation of 15, cull below 25 single point
- Banding:** Metal Banding: 3/8" – Bite-edge type, or 3/8" PET Plastic type
- Liner – One band placed on each end, 1/2" to 1 1/2" from the edge
 - Medium - One band placed on each end, 1/2" to 1 1/2" from the edge.
 - One band in the center of rolls over 70" for both rolls.
- Labeling:** Must be legible: Minimum 1 label per roll placed on the bottom 1/3 of the roll
- Car Loading:** Compliance with New Indy shipping / handling roll quality specifications:
- Clean and dry – Free of odor, contaminants and leaks
 - Must be loaded so the cars can be unloaded from either side
 - Double door cars preferred – Minimum 10' doors
 - Stacked or blocking rolls cannot be placed in a doorway
 - Rolls must have at least 2" of clearance to the car ceiling
 - Rolls loaded in doorways must be positioned so a dock plate can be inserted
- Information:**
- Shipping tallies placed in car: Accurate content and identification of rolls
 - Placards provided if needed
 - ASN, EDI shipping notice provided in real time

NEW INDY

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