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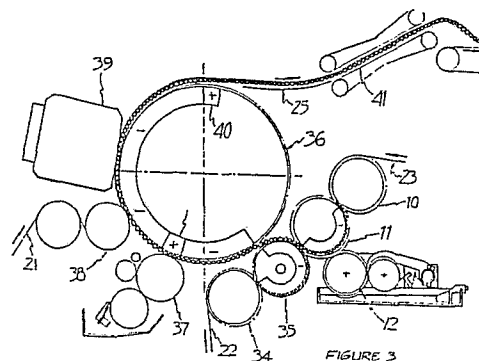
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## 54 Manufacturing corrugated board.

57 A conventional single faced corrugated board manufacturing plant is modified to produce corrugated board having two fluted mediums bonded at their flute tips. In addition to the existing corrugating rolls (10, 11) a further pair of corrugating rolls (34, 35) synchronized with the existing pair are provided so that the corrugated mediums (22, 23) are contacted at their flute tips. An additional mill roll stand is provided for the second fluted medium. A carrier roll (36) is provided adjacent to the pairs of corrugating rolls to take off the bonded fluted mediums and provide support and prevent uncontrolled movement of the flute to flute structure during the development of the adhesion bond. Adhesive applicators (37) are provided to apply adhesive to one of the mediums prior to the flute tip to flute tip bonding and to coat the flute tips of the bonded fluted structure on the carrier roll for bonding to the inner (21). An additional guide roll (38) is provided to allow tangential approach for the liner onto the flute to flute structure carried by the carrier roll. Radiant energy is used to assist in bonding the inner to the flute tip structure enabling a low pressure bonding technique to be used.





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# EUROPEAN SEARCH REPORT

Application Number

EP 88 30 1228

DOCUMENTS CONSIDERED TO BE RELEVANT			
Category	Citation of document with indication, where appropriate, of relevant passages	Relevant to claim	CLASSIFICATION OF THE APPLICATION (Int. Cl.4)
X	FR-A- 393 156 (SUTRE) * Whole document *	1	B 31 F 1/28
P,X D	AU-B- 567 833 (AMCOR) * Whole document *	1-4	
X	DE-C- 473 855 (A. ARBIN) * Page 3, lines 9-60; figure 7 *	4	
A		2	
A	EP-A-0 104 372 (W. PETERS) * Claims 1,2; figures *	3	
			TECHNICAL FIELDS SEARCHED (Int. Cl.4)
			B 31 F
The present search report has been drawn up for all claims			
Place of search THE HAGUE		Date of completion of the search 01-07-1988	Examiner KORTH C-F.F.A.
<b>CATEGORY OF CITED DOCUMENTS</b> X : particularly relevant if taken alone Y : particularly relevant if combined with another document of the same category A : technological background O : non-written disclosure P : intermediate document T : theory or principle underlying the invention E : earlier patent document, but published on, or after the filing date D : document cited in the application L : document cited for other reasons & : member of the same patent family, corresponding document			