

# The Corrugated Box-Making Process



The production of corrugated boxes begins much like any other paper product. Wood (1) from trees harvested from responsibly managed forests and fiber (2) recovered from paper recycling centers are processed into pulp and made into paper at a paper mill (3). In this process, two different types of brown paper (kraft) are produced:

liner and medium. (4) These two special papers are fed into a corrugator (5) which presses flutes into the medium and adheres liner to either one or both sides of that medium with starch-based glue adhesive, producing combined board or corrugate. Additional sets of fluted medium and liner can be added to create a double wall

or triple wall product. The corrugated board is then fed through a dryer (6) to remove moisture and set the adhesive. The dry corrugated board can then be trimmed, slit, scored (7) and cut into sheets (8) for printing and converting (9-10). Often the corrugated sheets are printed to label, brand or promote the products that

will be in the finished box. After converting, trimmings and scrap are recovered and sent to the recycling center for processing. In the final step the converted products are bundled (11) and delivered to the customer.