

FRIESE's comprehensive service begins with the complimentary PACE

***P.A.C.E (Profile Analysis and Comparison Estimate) Report***

A PACE can be generated for any single facer and outlines how FRIESE corrugating rolls can improve your corrugated board quality and plant productivity.

**Most companies want to save medium without sacrificing the mechanical values – especially ECT.**

In the attached PACE(s) the first column notes the actual profile in use. The remaining columns note a few options that are available. Please note the medium savings (TUF), tension value, and the corresponding mechanical values. In most cases we can produce a stronger combined board using less paper!



# PACE: (Profile Analysis and Comparison Estimate)

## BHS Bandleader/ C9 Profile

		<b>C<sub>9</sub></b>	<b>Friese Rockwelle</b>		
			I	II	III Super C9
		500 / 325	500 / 325	500 / 325	500 / 325
corrugating roll diameter	in mm	500 / 325	500 / 325	500 / 325	500 / 325
fluting height	in mm	3.61	3.7	3.6	3.5
pitch	in mm	8.300	8.300	8.300	8.300
number of teeth		189 / 123	189 / 123	189 / 123	189 / 123
tension factor	in %	100.0	105.0	97.0	90.1
tension		6.25	6.56	6.06	5.63
take-up factor		<b>1.385</b>	<b>1.399</b>	<b>1.38</b>	<b>1.361</b>
fluting paper saving	in %	0.0	-1.0	0.4	1.4
<b>mechanical strength</b>					
BCT-value	in %	100.0	101.7	99.7	97.8
FCT-value	in %	100.0	96.4	101.4	106.8
ECT-value	in %	100.0	100.4	99.8	99.27



# PACE: (Profile Analysis and Comparison Estimate)

## Fosber Smart / C flute

		Actual	option I	Tungsten option II	option III
corrugating roll diameter	in mm	540 / 325	542,5 / 325	542,5 / 325	542,5 / 325
fluting height	in mm	3.63	3.70	3.63	3.55
fluting height	inch	0.143	0.146	0.143	0.140
pitch	in mm	8.08	8.31	8.31	8.31
number of teeth		210 / 128	205 / 123	205 / 123	205 / 123
tension factor	in %	100.0	85.4	82.2	79.4
tension		7.81	6.67	6.42	6.2
<b>take-up factor</b>		<b>1.409</b>	<b>1.396</b>	<b>1.385</b>	<b>1.373</b>
fluting paper saving	in %	0.0	0.9	1.7	2.5
<b>mechanical strength</b>					
ECT-value	in %	100.0	100.9	100.7	100.3
BCT-value	in %	100.0	101.8	100.7	99.2
FCT-value	in %	100.0	96.4	99.2	102.3



# PACE: (Profile Analysis and Comparison Estimate)

## Vanguard 600M / B flute

		Actual	option I	Tungsten option II	option III
corrugating roll diameter	in mm	<b>406 / 406</b>	<b>407 / 407</b>	<b>407 / 407</b>	<b>407 / 407</b>
fluting height	in mm	2.49	2.60	2.50	2.40
fluting height	inch	0.098	0.102	0.098	0.094
pitch	in mm	6.44	6.60	6.60	6.60
number of teeth		198	194	194	194
tension factor	in %	100.0	97.0	89.0	81.2
tension		6.64	6.44	5.91	5.39
<b>take-up factor</b>		<b>1.319</b>	<b>1.323</b>	<b>1.302</b>	<b>1.282</b>
fluting paper saving	in %	0.0	-0.3	1.3	2.8
<b>mechanical strength</b>					
ECT-value	in %	100.0	100.6	100.3	100.0
BCT-value	in %	100.0	102.8	100.5	98.2
FCT-value	in %	100.0	92.6	99.2	106.7

