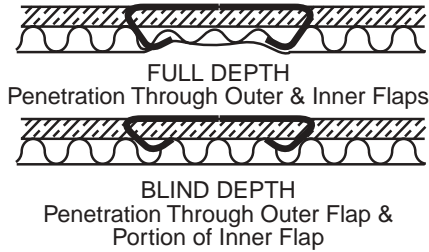


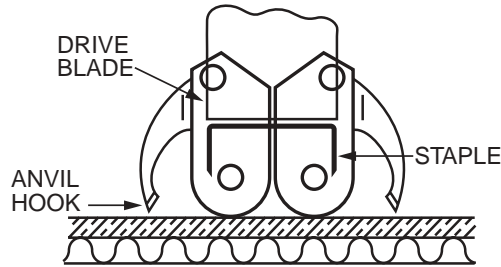
STAPLE LENGTH SELECTION BY CORRUGATED THICKNESS

Various staple leg lengths have been designed to penetrate through both the outer and inner carton flap layers, tightly clinching the flaps together without tearing the inner flap liner. Quality stapling tools are adjustable to permit a single staple leg length to work for varying thicknesses of corrugated. Although actual testing is the only true way to determine the correct leg length required for a particular application, as a general rule, the following leg lengths may be used for cartons constructed of the various minimum burst strength/edge crush (ECT) materials listed below:

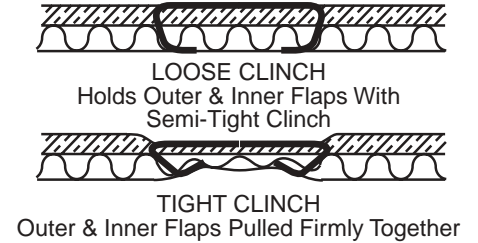
STAPLE PENETRATION



STAPLERS ADJUST FOR DEPTH AND/OR CLINCH OF STAPLES IN SECONDS!



STAPLE CLINCH



| CARTON Burst/ECT | RECOMMENDED Leg Length/Penetration Setting | MAX. WEIGHT OF SHIPMENT ^② | MAX. COMBINED INCHES (length + width + depth) ^② |
|-----------------------|--|--------------------------------------|--|
| 125SW/23 | Material generally too thin for staple usage | 20 lbs. | 40 inches |
| 150SW/26 | Material generally too thin for staple usage | 35 | 50 |
| 175SW/29 | Use 1/2" leg/Full or shallow setting | 50 | 60 |
| 200SW/32 ^① | Use 5/8" leg/Full or shallow setting | 65 | 75 |
| 250SW/40 | Use 5/8" leg/Full setting | 80 | 85 |
| 275SW/44 | Use 5/8" leg/Full setting | 95 | 95 |
| 350SW/55 | Use 3/4" leg/Full or shallow setting | 120 | 105 |
| 200DW/42 | Use 3/4" leg/Full setting | 80 lbs. | 85 inches |
| 275DW/48 ^① | Use 3/4" leg/Full setting | 100 | 95 |
| 350DW/51 | Use 3/4" or 7/8" leg/Full or shallow setting | 120 | 105 |
| 400DW/61 | Use 7/8" leg/Full setting | 140 | 110 |
| 500DW/71 | Use 7/8" or 1" leg/Full setting | 160 | 115 |
| 600DW/82 | Use 1" or 1-1/8" leg/Full setting | 180 | 120 |
| 700TW/67 | Use 1-1/8" or 1-1/4" leg/Full or shallow setting | 240 lbs. | 110 inches |
| 900TW/80 | Use 1-1/4" or 1-3/8" leg/Full or shallow setting | 260 | 115 |
| 1100TW/90 | Use 1-3/8" leg/Full setting | 280 | 120 |
| 1300TW/112 | Use 1-3/8" leg/Full setting | 300 | 125 |

① Indicates most commonly used single and double wall corrugated.

② Information supplied by Association of Independent Corrugated Converters



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