

NAME _____

DATE _____

Cut apart the following steps for manufacturing a corrugated box. Sequence them in a way that shows the process from beginning to end. (Hint: The steps may not form one straight line.)



Trees are harvested and cut into logs. For each tree harvested, three trees are planted to ensure forest sustainability for decades to come.

A



A die cutter slots, scores, and cuts the containerboard into box blanks, which are flat, pre-cut sheets of corrugated material.

B



Certified forests meet sustainability standards for environmental, social, and economic criteria. The journey of wood fiber from a certified forest is documented to guarantee that forest products, such as corrugated boxes, come from a sustainable source. However, not all forests are certified.

C



Logs are sent to a mill, where they are tumbled to remove the bark and then chipped into small pieces.

D

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Corrugated boxes are emptied, flattened, and recycled. Corrugated packaging is the most widely recycled material worldwide. In the U.S. alone, nearly 80% of all corrugated material is recycled.

E



The pulp moves through a series of rollers that press and dry the fibers to form large rolls of paper.

F



A specialized machine—the Flexo Folder Gluer—prints graphic designs and other information on the box blank, and then folds and glues the box.

G



Paper rolls are transported to the box plant, where they will be transformed into corrugated boxes.

H

CAREER CORNER

SALES REPRESENTATIVES sell corrugated packaging and display solutions to new and repeat customers. They research and determine needs to make recommendations and answer customer questions.

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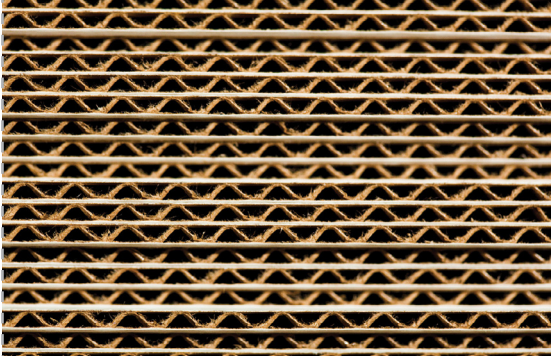
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At the mill, recycled corrugated boxes are deinked, cleaned, and warmed to make recycled paper pulp.

I



Medium and liner can be combined in a variety of ways to make single-, double-, or even triple-wall.

J



Pulp from recycled corrugated boxes is added to the mixture. Pulp for corrugated boxes contains four renewable ingredients: wood fiber (pulp), recycled fiber, water, and starch.

K



All boxes containing certified fiber receive a forest product certification label. This label lets consumers know that the corrugated box is made from sustainable forest resources.

L



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Recycled corrugated boxes accumulate at recycling centers and are distributed to paper recycling mills. On average, four out of five corrugated boxes are recycled to make a new box.

M



Foresters monitor growing trees to ensure the forest remains healthy and continues to provide a range of benefits, including wildlife habitat, recreation, and future wood products.

N



At the box plant, a corrugator machine uses paper, steam, and adhesive to make corrugated board, which has a wavy, fluted middle layer (called “medium”) and smooth outer layers (called “liner”).

O



The mill uses grinders or chemicals to separate individual fibers, making a soupy mixture called “pulp.”

P

CAREER CORNER

PRODUCTION WORKERS are an important part of the box-making process. They might conduct quality checks, feed and stack sheets at various machines, and help set up machines for special orders.

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