National Steel Rule
PERFormaX

The things to remember are that **fiber content and flute direction matter**. "Detach only" and "Bend and Detach" are very different features of a structural design.

- Detach only lines parallel to the direction of corrugation, will require the least percentage of hold such as 945 or 955
- Diagonal lines will require a little more hold percentages such as 955 or 860
- Directly Across the corrugation will require even more hold percentage therefore 860 or 763
- Flaps that are folding/bending across the corrugation will require the most hold percentage therefore 763 or 568 is often used.

Mullen grade board typically will be most difficult to tear (low hold %)
ECT grades perhaps a little easier (medium hold %)
Low fiber/"compressed dust" (high hold%)

Influential factors to successfully choose the best SRP/ RRP Rules

Combined Board:

- **Flute Profile**
- **Basis Weight**
- **Fiber Quality (long fiber vs "compressed dust")**
- **Tensile strength**
- **Coatings, Additives and Laminations**
- **Moisture content**

Structural Design

- **Flute direction, WC . XC , Diagonal**
- **Distance from a folding Score**
- **Is Perf on a Flap Closure**
- **Point of Opening. (Beginning the Tear)**
- **Direct Tear or "Bend first" then Detach**

Structural Integrity, Warehouse and Transportation

- **Is the carton supporting the load**
- **Are the contents supporting the load**
- **Accelerated Creep**
- **Multiple terminal shipments /excessive handling**

Cutting Die and Machine Conditions

- **Securely Bolted to Cylinder**
- **Machine is parallel and cutting evenly**
- **Consistent Anvil conditions**