

Supplement: E-Flute phase box instructions page 1

CORRUGATED E-FLUTE PHASE BOX—AFRICA & ASIA—MICHAELLE BIDDLE, 2003 REV 2019

Using Corrugated E-Flute this box is suitable for boxes greater than .75" in thickness.

Construct a measuring jig: Cut 1 strip of E-Flute board 9" (22,5 cm) long and 1" (2,5 cm) wide. Cut this stripe into three pieces — 4" (10 cm), 3" (7,5 cm) and 2" (5 cm). Glue all three strips together with one end flush. The other end will then be stepped. Mark the longest strip 1 BT (board thickness), middle strip 2 BT and shortest strip 3 BT.

Step 1: On another narrow piece of scrap E-Flute mark the **Width** of item (W) + 1 BT, **Height** of item (H) and **Thickness** of item (T).

Step 2: To determine the size of board needed – $WIDTH = 7/16" + 2W + 3T$ $HEIGHT = 5/16" + 1H + 2T$. **The board blank should be .5" larger than these dimensions.**

Step 3: When using E-Flute the grain of the board can be ignored.

Step 4: Square a piece of board. This square should be the lower left hand corner of the board. Mark the square corner with a square □

Measurement Formular – using a sharpened pencil mark first measurement with a short line, second measurement with a longer line. Longer lines are scoring & fold lines.

On bottom of board: T+1BT; W+2BT; 1T+2BT; W+1BT; T+1BT

Left side of board: T+1BT; H+3BT; T+1BT

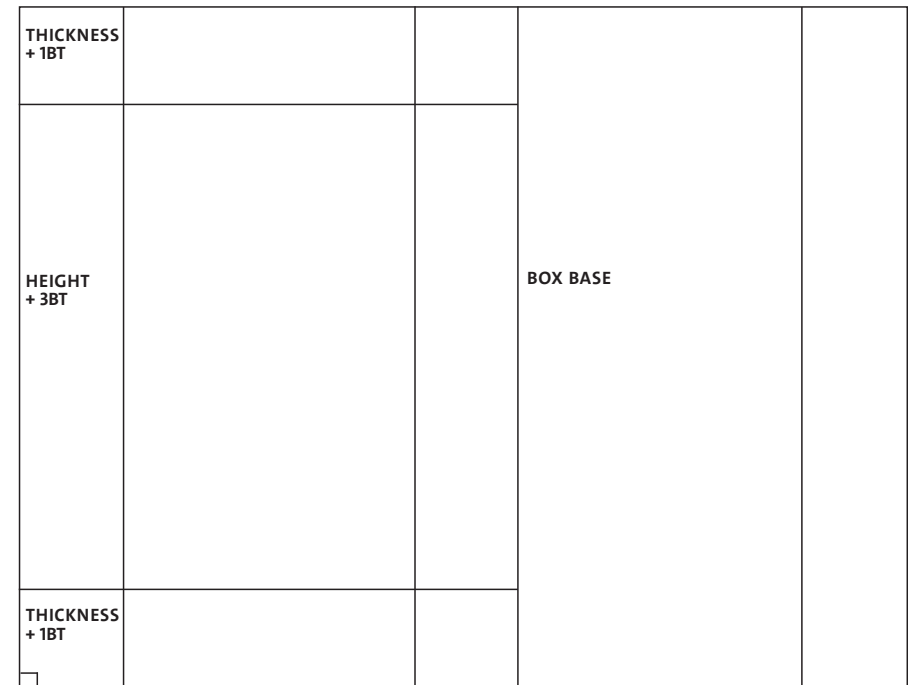
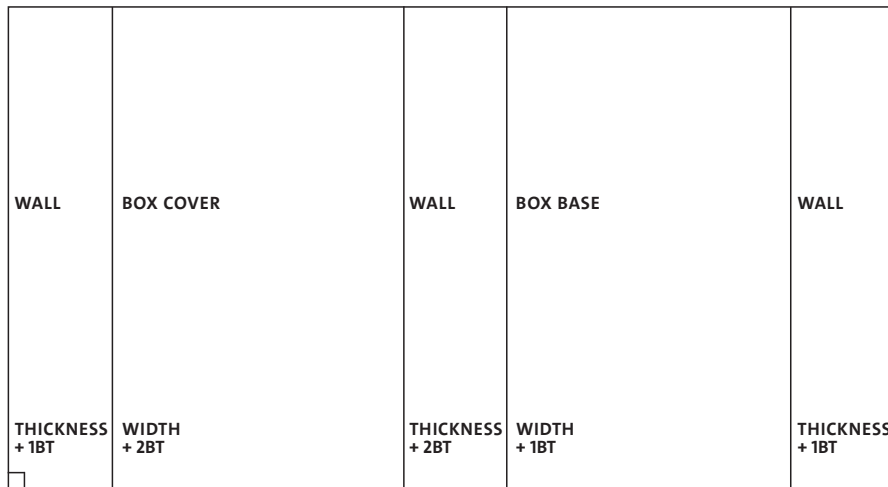
Step 5 – see diagram: Transfer longer bottom board marks to 3BT line. Trim away excess board. Connect longer pencilmarks and score. Keeping □ mark on lower left – there should be 4 vertical score lines

Step 6 – see diagram: Transfer side of board longer marks to third vertical score line. Trim away excess board. Connect longer pencil marks and score.

Step 7 – follow diagrams

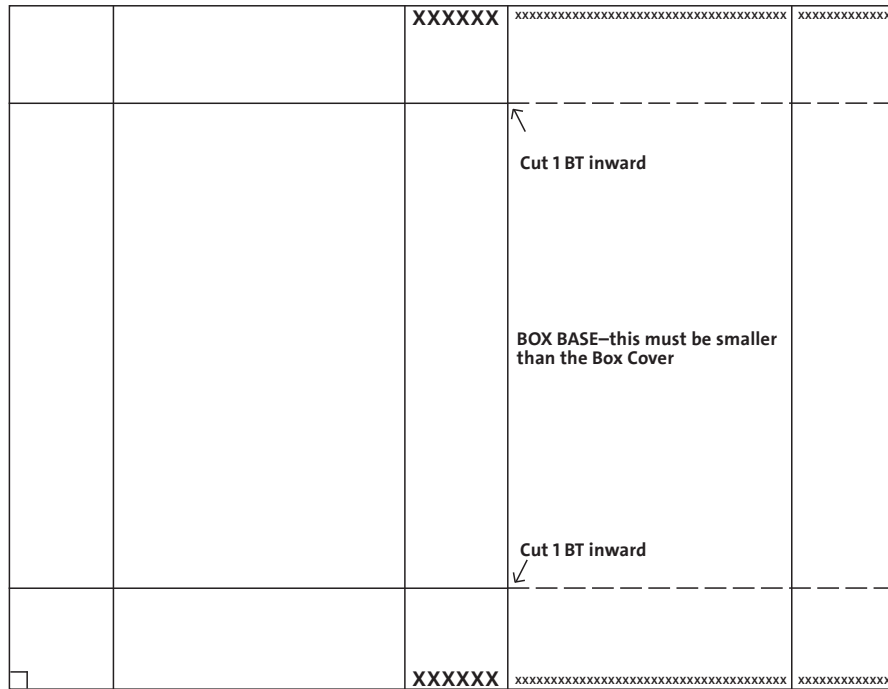
Step 5: Starting at the squared corner mark the vertical dimensions as given in the drawing. Trim the board on the right using the last vertical measurement. Using the carpenter's square score the vertical lines using the pouncing (tailors') wheel or a folder.

Step 6: Starting at the squared corner mark the horizontal dimensions as given in the drawing. Cut the board on the top using the last horizontal measurement. Using the square score the horizontal lines up to the beginning of the BOOK TRAYBASE using the pouncing wheel or a folder.

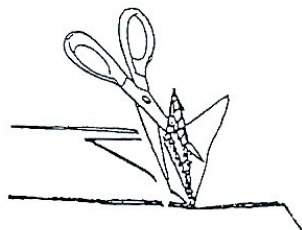


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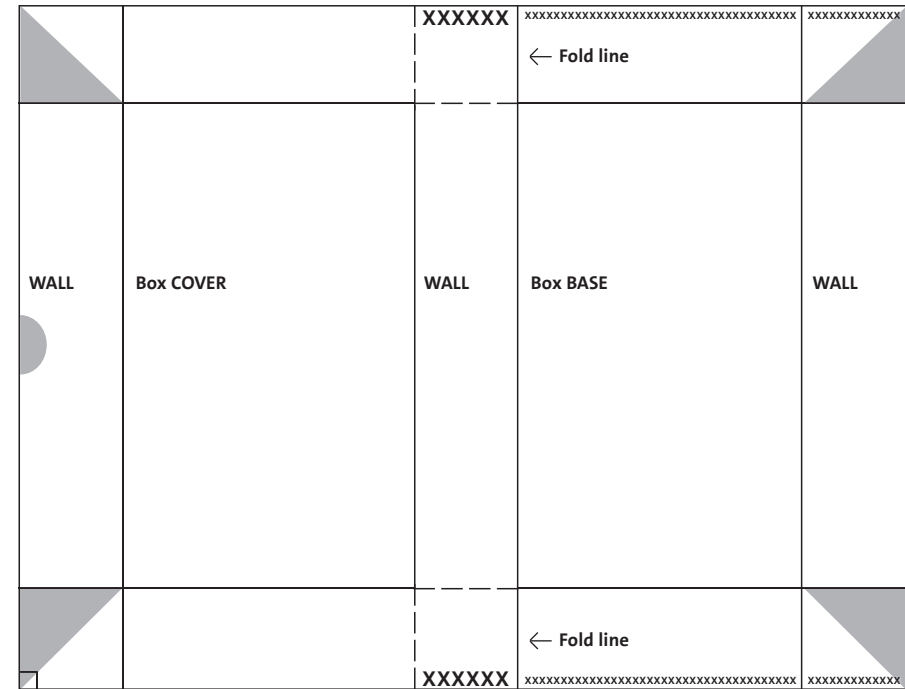
Step 7: Box base must be smaller than the cover tray so the two trays will nest inside one another when the box is closed. Use the BT measuring jig to move the upper and lower book tray walls inward by 1BT. Go over these lines with the folder. Cut away one BT at the XXXXX.



Step 9: The corrugated board is constructed of two outer layers surrounding a layer of corrugated core. Use a spatula to separate the outer layers from the corrugated core on the four corners. Fold the outer layers back on the scored line. Use scissors to carefully cut away the corrugated core. DO NOT CUT THROUGH THE OUTER LAYERS of the E-Flute Board.



Step 8: Cut away the shaded areas and cut a thumb notch on the box cover fore-edge as shown. Cut along dotted lines. This square is turned inward to seal the spine of the box.



Step 10: Use PVA to glue the corner tabs in place. Push the inner tabs well down into the corner joints to form a sharp 90 degree angle. Allow to dry at least a couple of hours before placing the item in the box.

