

WAC 296-17A-2401 Classification 2401.

2401-00 Paper, pulp, or wood fiber: Manufacturing

Applies to:

Businesses making paper from raw materials.

Paper manufacturers may make finished products from the paper they manufacture which is included in this classification when done by employees of employers subject to this classification.

Raw materials used include, but are not limited to:

- Bleach and dye;
- Cotton fiber;
- Kraft paper;
- Recycled paper;
- Water;
- Wood chips.

Equipment includes, but is not limited to:

- Choppers;
- Conveyor systems;
- Cutting machinery;
- Forklifts;
- Papermaking machines;
- Scales;
- Spraying systems;
- Vats and tanks;
- Winders and rewinders.

Work activities and processes include, but are not limited to:

- Monitoring automated paper mills from computerized control rooms. Many of the employees are electricians and control technicians;
- Mashing wood chips into fiber;
- Heating, washing, draining and impregnating wood chips with chemicals to separate natural binder fibers from the cellulose fibers, then chopping into tiny particles and further cleaning;
- Adding bleach and water and holding the fibrous mixture in tanks to relax and fluff to a natural state;
- Filtering to remove the water and allow the fibrous mixture to coagulate;
- Adding ingredients to increase strength;
- Spraying the mixture onto the papermaking machinery where it winds through the various sections at high speed;
- During the first stage of papermaking the pulp is mostly water;
- Spinning on wire mesh, the water is suctioned out;
- Winding the paper around felt-covered rollers, where the machine moves the paper through an enclosed, heated room (oven), drying the paper;
- Rolling the dried paper from the oven, smoothing on rollers, rewinding into smaller rolls and cutting into desired lengths and widths.

Exclusions:

- Manufacturing wood chips is classified in 2903;
- Manufacturing abrasive cloth or paper (emery cloth/sandpaper) is classified in 3708.

2401-03 Corrugated and fiberboard container: Manufacturing

Applies to:

Businesses manufacturing boxes and cartons made of corrugated cardboard.

Materials used include, but are not limited to:

- Coating resins;
- Corrugated cardboard;
- Glue;
- Ink;
- Staples;
- Tape.

Machinery used includes, but is not limited to:

- Balers;
- Box-making machinery;
- Corrugators;
- Die cutters or other cutting machines;
- Forklifts;
- Laminators;
- Printing presses;
- Sheeters;
- Shredders;
- Slitters;
- Slotters;
- Winders or rewinders.

Work activities and processes include, but are not limited to:

- Currogating cardboard for use in the manufacturer's own products or purchasing corrugated cardboard from others;
- Applying coatings or laminating the manufacturer's own products when done by employees of employers subject to this classification;
- Cutting materials to size and shape;
- Printing on materials;
- Scoring or creasing materials;
- Cutting or slotting box corners;
- Folding sides of boxes;
- Taping bottom pieces of boxes together;
- Cutting polystyrene foam (Styrofoam) into packing pieces if their customers want them as a packaging unit. This incidental activity is included within the scope of this classification when done by employees of an employer subject to this classification.

Exclusions:

- Businesses engaged mainly in corrugating, laminating, oiling or coating paper are classified in 2401-04;
- Manufacturing abrasive cloth or paper (emery cloth/sandpaper) is classified in 3708.

2401-04 Paper coating, corrugating, laminating, oiling, or embossing

Applies to:

- Businesses manufacturing corrugated cardboard or paper.
- Businesses coating, laminating, oiling, or embossing paper, chipboard, or cardboard for others.

Work activities and processes include, but are not limited to:

- Corrugated cardboard making - Feeding three (or more) rolls of kraft paper simultaneously into a corrugating machine. Spraying steam onto the middle sheet as it winds around grooved rollers, forming grooves. Applying glue to the tips of the grooves and running the middle sheet between the other two sheets to form corrugated cardboard.

The rest of the process involves heating, drying, curing, scoring and cutting the cardboard.

- Coating cardboard or paper - Mixing coating materials, pouring the mixture into troughs of coating machines. The paper then passes over rollers through the coating mixtures.

- Oiling or waxing cardboard or paper - These processes are similar to coating, but the oils or waxes are heated prior to being applied to the paper. After saturation, the paper is dried, then finished by calendering (smoothed by being pressed through large rollers), slitting to desired widths, and rewinding or sheeting to size.

- Laminating paper - Feeding a paste or glue between layers of paper, pressing them together, drying and finishing by winding into rolls, or cutting, slitting or die cutting to size and shape.

- Embossing paper - Winding paper on embossing rollers that perforate designs in it. Raw materials include, but are not limited to, kraft paper, chipboard, glues, waxes, resins and other coating liquids.

Machinery used includes, but is not limited to:

- Machinery that moves paper through glue baths, finishing applications, squeeze rollers, corrugating or embossing rollers, drying ovens, cutting devices, laminators, and/or stacking equipment;

- Forklifts;

- Balers;

- Shredders.

Exclusions:

- Manufacturing paper, pulp or wood fiber is classified in 2401-00;

- Manufacturing corrugated and fiber board containers is classified in 2401-03;

- Manufacturing abrasive cloth or paper (emery cloth/sandpaper) is classified in 3708.

Special note: This classification differs from classification 2401-03 in that making corrugated cardboard or laminating, oiling, or coating cardboard products made by others is the main activity in classification 2401-04 while such supporting operations in classification 2401-03 are incidental to the manufacture of the product.

2401-08 Paper goods, N.O.C.: Manufacturing

Applies to:

Manufacturing of heavy-grade, paper-based products, which are not covered by another classification (N.O.C.).

Products manufactured range widely and include, but are not limited to:

- Commercial air filters;

- Display boards;

- Milk cartons;

- Panels;

- Paper-mache items;

- Spiral tubes - Spiral tubes range in size from small cores for paper towels to large tubes used by the construction industry to form concrete.

Materials used include, but are not limited to:

- Chemicals;

- Chipboard;

- Glue;
- Inks and dyes;
- Paper;
- Materials such as lightweight wire, or small parts made of plastic, polystyrene foam (Styrofoam), or textiles could be used as auxiliary pieces of the finished product.

Machinery includes, but is not limited to:

- Balers;
- Conveyors;
- Cutting, drilling, or punching machines;
- Embossers;
- Gluers;
- Grinders;
- Heated presses;
- Heat-sealing machines;
- Laminators;
- Ovens;
- Packaging equipment;
- Printing presses;
- Sheeters;
- Shredders;
- Slitters;
- Slotters;
- Vacuum machines;
- Vats and beaters;
- Winders and rewinders;
- Wire-bending equipment.

Work activities and processes include:

Depending on the product being made, processes are similar to one or more of those described in the other paper products manufacturing classifications.

Exclusions:

- Manufacturing paper, pulp, or wood fiber is classified in 2401-00.

[Statutory Authority: RCW 51.04.020 and 51.16.035. WSR 24-23-081, s 296-17A-2401, filed 11/19/24, effective 1/1/25. WSR 07-01-014, recodified as § 296-17A-2401, filed 12/8/06, effective 12/8/06. Statutory Authority: RCW 51.16.035. WSR 98-18-042, § 296-17-567, filed 8/28/98, effective 10/1/98; WSR 96-12-039, § 296-17-567, filed 5/31/96, effective 7/1/96. Statutory Authority: RCW 51.04.020(1) and 51.16.035. WSR 91-12-014, § 296-17-567, filed 5/31/91, effective 7/1/91; WSR 89-24-051 (Order 89-22), § 296-17-567, filed 12/1/89, effective 1/1/90. Statutory Authority: RCW 51.16.035. WSR 88-12-050 (Order 88-06), § 296-17-567, filed 5/31/88, effective 7/1/88; WSR 87-24-060 (Order 87-26), § 296-17-567, filed 12/1/87, effective 1/1/88; WSR 85-24-032 (Order 85-33), § 296-17-567, filed 11/27/85, effective 1/1/86. Statutory Authority: RCW 51.04.030 and 51.16.035. WSR 79-12-086 (Order 79-18), § 296-17-567, filed 11/30/79, effective 1/1/80; Order 77-27, § 296-17-567, filed 11/30/77, effective 1/1/78; Order 73-22, § 296-17-567, filed 11/9/73, effective 1/1/74.]