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The Corrugator

OFFICIAL MAGAZINE OF FEDERATION OF CORRUGATED BOX MANUFACTURERS OF INDIA

January - June 2020

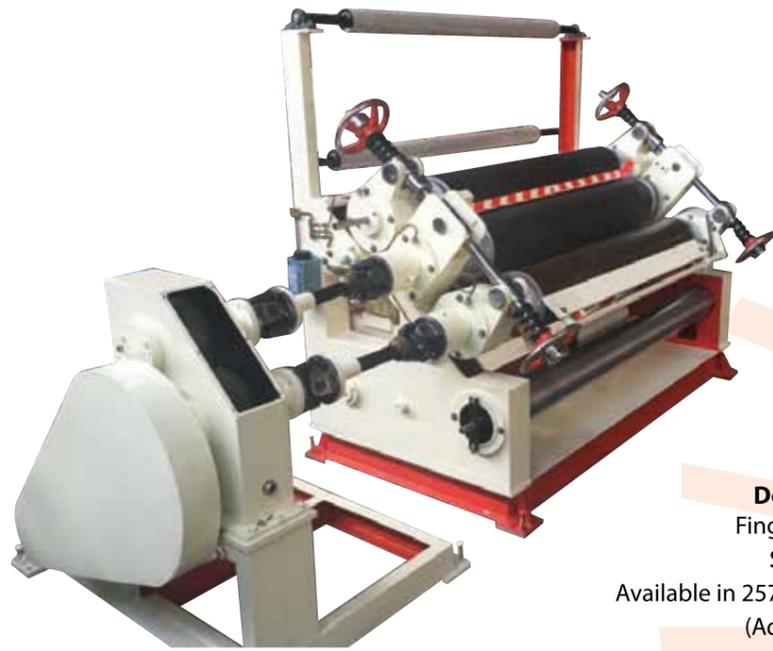
(Combined Issue)





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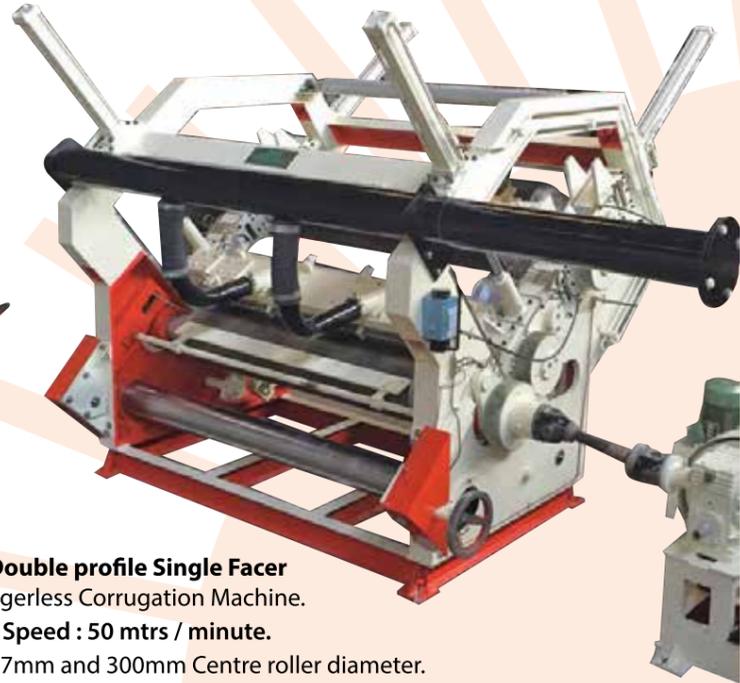
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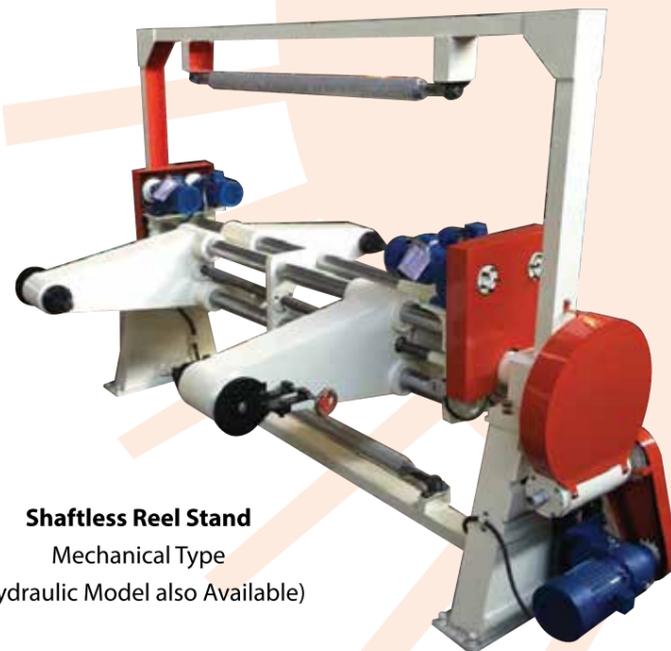
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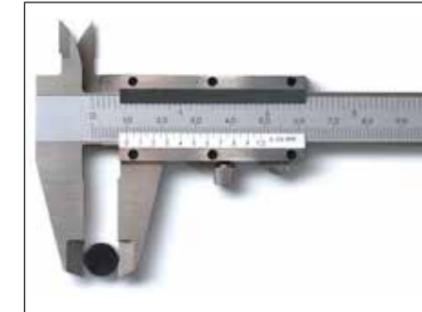
Design & Production:

Print Links

Bldg. H-4,
Flat No. 2 (Lawn side)
Jankalyan, Bangur Nagar,
Goregaon (West),
Mumbai - 400 104.
Tel.: 2877 2702 / 2890
email: greycells.nani@gmail.com

Printed at:
Rajesh Printouch
Mumbai

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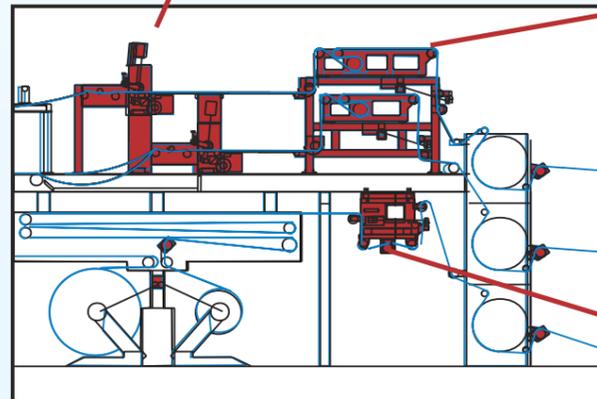


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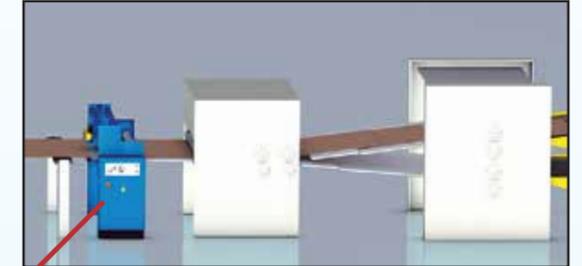
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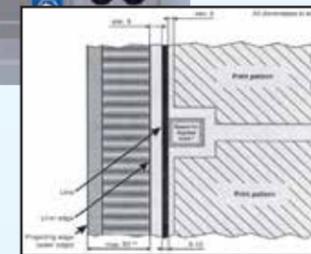
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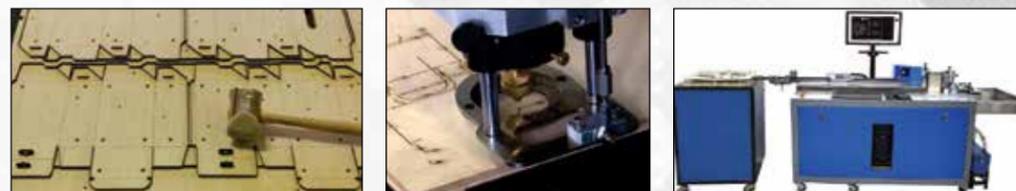
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Die Makers to The Packaging Industry

THE EDITORS' PAGE



Ashok Vyas



Hemant Saraogi



Shlok Kedia

Things have been quite disturbing since the beginning of the year. While economic downturn is impacting all businesses, the riots and unrest in Delhi and the onslaught of Corona Virus are taking their toll on economy and our day to day lives.

The silver lining is that things are slowly retuning to normal and the impact of Corona is reducing. All countries are grappling with the slowdown and making efforts to come back to prelockdown days. Let us hope normalcy and upturn in economy will soon see the light of the day.

FCBM and Regional Associations have been quite active with events and programmes organised for the benefit of members, most of it using ZOOM, and other.

KACBMA organised their first Technical Seminar in Bengaluru. Topics Chosen were quite new and useful for members.

EICMA organized Comprehensive Course 2.2 at Kolkata.

The FCBM Managing Committee Meeting hosted by MPCBMA on 2nd March at Indore was quite well attended.

The FCBM Managing Committee Members Directory in PDF form was released by the FCBM President by releasing one Printed copy symbolically.

President also released Compendiums of FCBM Practical Standards and Technical Information Booklets.

3 - day Practical Course in Testing was organized by WICMA from 9th to 11th January WICMA also organized their 44th 6 - day Certificate Course in Corrugated Packaging in February 2020.

Level II of the Comprehensive Course in Corrugated Packaging was organized by MPCBMA from 29th February to 1st March 2020.

WICMA had also organized a One Day Technical Seminar at the Golden Chariot at Vasai near Mumbai on 8th January 2020 in an effort to reach out to the corrugators in and around Vasai and other suburbs.

Mr. Haresh Mehta - Designer par Excellence from WICMA displayed a Corrugated Creation titled 'Statue of Humanity' at the popular Kala Ghoda Art Festival held in Mumbai.

All the events organized by the Regional Associations are featured in this issue under FCBM News.

Besides, this issue features very informative and interesting articles authored by experts.

'How to Box' - the series we started since last issue concludes in this issue. 'Thinking Outside (and inside) the Box' highlights how Corrugators are attracting their customers with Flexo Printed Graphics.

We regret to inform the readers that Former Director of Indian Institute of Packaging (IIP) and Chairman, SIES School of Packaging (SOP), P. V. Narayanan is no more. He passed away on 28 June 2020

'The Benefits of Corrugated box for packing of fruits and vegetables' is highlighted in an elaborate article by 'Fruit Growers Supply' - an American Company.

Readers are well aware of the efforts taken by FCBM in popularising corrugated boxes for packing of Fruits and Vegetables This article further underlines the advantages of Corrugated box for Fruits and Vegetables.

The concept of Sustainable Packaging is gaining ground and our corrugated boxes admirably meet the requirements of sustainability.

The Covid 19 Pandemic has come like a curse on humanity. It has turned lives upside down. With all measures being taken by the Governments we do hope and pray that life will return to normalcy soon.

This issue features an article wherein the author Mr. Anant Sarma describes the Industry Scenario in Lockdown Period and suggests steps to be taken during post lockdown period.

Keeping in touch with present needs, Corrugators across India have come up with Corrugated Beds - which are easy to assemble, comfortable and more importantly highly economical.

This issue features some of these innovative ideas.



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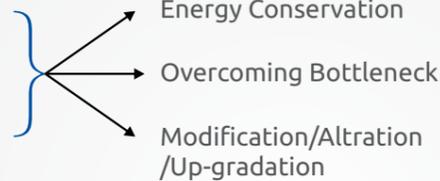
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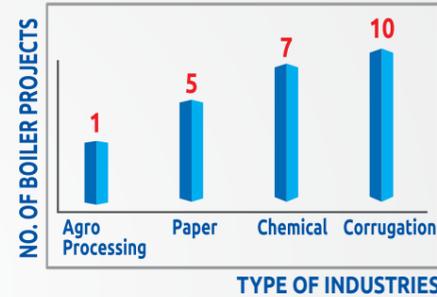
To Study Boiler, Heating System:

- ▲ Generation Area
- ▲ Distribution Area
- ▲ Utilisation Section
- ▲ Return/Recovery Area



Provide Report For:

#23 DIFFERENT BOILER PROJECTS



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PRESIDENT'S MESSAGE



V. K. DEWAN

I wish to thank each and every member of FCBM for reposing faith in me and electing me as the President of FCBM.

Looking at the current market scenario where all the sectors are performing low, this is the time we need to realise the power of this association in a better manner. FCBM equips us to have latest technological know how in the industry with the best of training courses started by our esteemed Seminar & Workshop Committee team which is headed by Shri Ram Kumar Sunkara.

Our Level 1 Course which was initiated in the term of Shri Pradip Bosmaya has already spread its wings majorly in all the regions and infact the team has even come up with further enriching Level 2 Course. This takes the duty of FCBM of imparting education to even a higher level.

Due to extraordinary circumstances prevailing across the world and continuous lockdown in India, our Corrugator team could not bring out the Jan. - Mar. 2020 issue of The Corrugator.

The present issue is updated as Jan - June 2020 issue. Hope you will appreciate, the steps taken by Team The Corrugator

I wish to see in my tenure that 100% regions should get to finish both the levels simultaneously.

And we'll make full effort to even start level 3 & level 4 in some of the regions.

As I mentioned in my speech in the AGM that I wish to kick start some programmes with respect to skill development of our labour with the help of Shri Ram Kumar Sunkara and other senior members of FCBM, so that it could deep down help each and every member of our association to streamline their production activities in a better productive manner.

Wish to see that avenues for income of FCBM should also increase whether it is from efforts of our Website Team or even from the way of collaboration with associations like IPAMA, Reeds India and many more possible associations still to get associated with our esteemed FCBM.

Since we are about to enter in our golden jubilee year celebrations and with continuous efforts put in by our Membership Drive Committee we wish to add maximum number of new members and even pursue the options to get our association connected to newer regions (states) which still haven't got connected with FCBM .

In the end, I would like to request all the members of FCBM to whole heartedly give their support with respect to their working in different committees and help our Federation reach greater heights.



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Time to review your Machine's Specifics

As we begin the New Year, I believe that it is a good time to pause and review the basic functions of all converting machines in our plants. We all know, it is quite common for each of us to have a variety of converting machines from a group of different manufacturers running side by side every day. Many of our converting machines have unique designs, individual controls and features that are machine specific.



Dick Target
"On Target Consultants"

For the last number of years, machine manufacturers have been rapidly moving towards supplying box plants around the world, Flexos and Rotary Die Cutters, with modern looking exteriors along with sophisticated computer control systems. Folding sections have been greatly improved along with new counter ejectors that offer box manufacturers the opportunity to produce quality boxes consistently at higher speeds. These designs offer box makers the ability to manage closer tolerances as a tool to satisfy customers with very specific requirements.

Let's not forget that we still have machines in our plants that are 10 + years old with manual controls and operating functions. They may or may not have worn components however, they are still required to produce a quality box and compete with the modern machines that I mentioned above. Many times, the same order is produced on the new piece of equipment one day and then on an old piece of equipment three days later. The dimensions of the boxes have to be the same as well as the color and print tolerances. ECT numbers must also be the consistent. The customer should really see no difference.

As we move forward in this very competitive industry, we cannot forget the fact that we must still understand how to manage the very basics of corrugated box manufacturing. We are still printing, slotting, scoring, folding and gluing corrugated sheets and converting them into proper shipping containers as we

have done for generations. Maybe the manufacturing methods have somewhat changed, and the speeds have increased but we're still supplying properly designed corrugated shipping containers for our customers.

I want to take some time now to discuss and review some important details:

1. Board Caliper and Caliper Loss during Manufacturing.
2. INK Management.
3. Skew
4. Printing Plates
5. Cutting Dies

Managing and understanding board caliper is certainly a very important subject and we should never forget its influence in our world of converting. We all know that a 0.170" (4.3 mm) "C" flute sheet is not always a 0.170" (4.3 mm). Be sure to check incoming stock on every order, whether it is from your own corrugator or from a sheet supplier for you sheet plant. Paper changes are a way of life on the corrugator and as the rolls are constantly being changed



so are the paper grades. [Note: Many of the rolls that are delivered to the wet end of the corrugator come from a variety of paper mills from around the country.] The order may start with a 35# liner and end up with a 39# liner or vice versa as the 39# liner was the roll stock that was next in line or one that was available. It is a common practice for corrugator crews to upgrade the paper with in one order as a tool to maintain ECT numbers. This is used as an insurance policy during paper changes as a way to guarantee box performance. This can and will change the nip setting requirements in our presses.

Remember, we can lose no more than 0.003" (0.08 mm) in board caliper during the converting process in the non-printed area of the sheet. Maybe 0.006" (0.16 mm) in the printed area of the sheet. This should be constantly checked for every order on a regular basis. As a quality check, sheets should be checked as they enter the feed section and as the sheets are delivered from the counter ejector or the stacker section in the case of a Rotary Die Cutter. I do believe that a lot of money is "lost" due to poor process checks regarding caliper loss. Many times, we ship the customer more than he needs.

I will discuss this and other calibration methods in future articles.

Contd. on - 17

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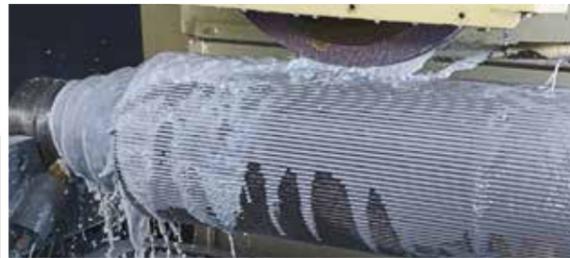
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Contd. from - 13

INK MANAGEMENT

This is probably the most important quality check that we can perform as we manage our plants. Color sells boxes and color sells the products that we are shipping in our boxes. Many plants do not have the proper understanding of color or ink management. If we ship an order to a customer and the colors that we are printing are not the same, the order will be returned. Many of our presses are printing three to five colors on every sheet. Especially orders for the display business.

The beer business is a good example. As there are so many specialty beers that are being sold today, the corrugated box does the selling on the shelf and convinces the customer to make that purchase. However, the color on the box must match the color on the label on the beer bottle!!

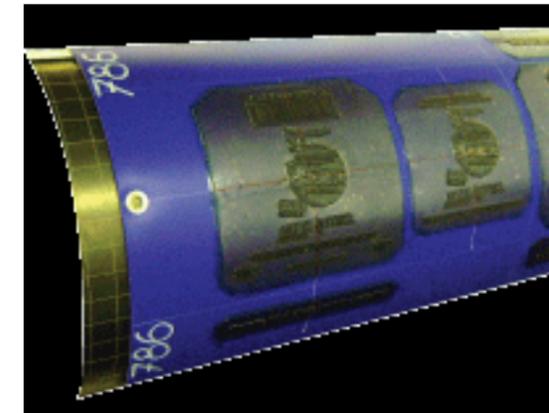
SKEW

This is an area that always needs attention. Whether you have a 15-year-old Flexo or a new design Flexo completely enclosed, box squareness is still a requirement. Many of our customers use automatic case erectors and need quality boxes that are consistently square.

We have to be sure that the boxes are manufactured "square" with the same dimensions all the time. If the feed rolls in the feed section are un-evenly worn, the box can and will travel through the press out of square and will soon be returned by your customers. We all now how costly that is!

In modern presses, the operators may not see the problem until it is too late or not see it at all.

and properly maintain them. These are critical tools that are necessary for you to print clearly, in register and produce a corrugated box that will make you proud!

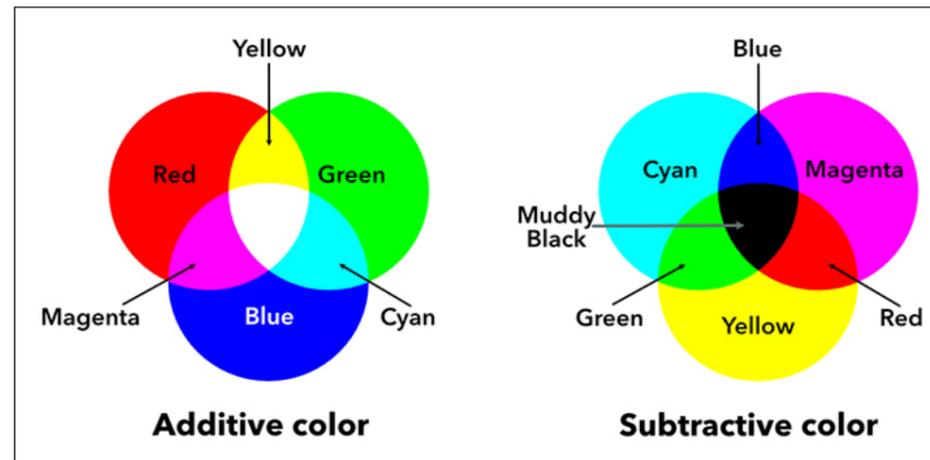


Be sure that your crews are given proper ink with the management tools for maintaining pH and alkaline properties. Make sure that the correct detergent is used in cleaning your plates (stereos or clichés) after the order is completed. Be careful to properly change the chemistry of the residual ink left on the plates (stereos or clichés) so that they can be cleaned without changing the chemistry of the photopolymer plate material. This can be an expensive mistake.

Make sure they are mounted properly with secure straps (NON-METAL CLIPS).

Depending on where the printing occurs on the sheet, you can produce a large number of boxes with poor printing due to improperly mounted printing plates (stereos or clichés). Your operators may not see the poor printing due to the machine covers until too many boxes have been made. These boxes will then be sent directly to the Hogger!

Be sure that the correct offsets are used in setting your impression rolls nips. Those requirements have not changed with the introduction of the new designed covers on the print stations. Properly set nip points will not only extend the life of your printing plates (stereos or clichés) but it will enable you to ship a better box to your customer.



With all of the on-line shopping that occurs today, the printing on that brown box must be consistent and the same all the time. Amazon, for example, is the company that enjoys a great shipping business. They offer Amazon and Amazon Prime. Amazon charges for shipping and they use "Black Printing". Amazon Prime does not charge for shipping and they use "Black and Blue Printing". It is a means of identifying the type of service they offer their customers.

My point is that printing and color management will always be important and a necessary part of our corrugated business.

Please, be sure to have an aggressive preventative maintenance program so that you can track the condition and performance of the wear items in our Flexos and Rotary Die Cutters, regardless of their age. The wheels in the lead edge feeders, for example, need constant attention. The front row of wheels always wear out first. Rotate them between the first and fourth rows to be sure the sheets are completely and uniformly fed into the feed roll nips. I will discuss this further in future articles.

PRINTING PLATES

Please stay on top of your inventory of your printing plates (stereos or clichés)



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CUTTING DIES

Please maintain your cutting dies. They require specific maintenance with proper care. Please use the correct type of pull band rubber, ejection rubber and support rubber in all your cutting dies. Keep an adequate inventory of the various types of rubber on the floor next to your converting machines so your operators can make corrections on the fly.

Train your crews and keep them current on rubbering technology. Use your cutting die supplier as a source of training and information for your crews. If they don't

offer such training and information, get someone who does!

This is one area in our manufacturing world that causes everyone excessive "unscheduled" downtime. If the cutting dies are not accurately maintained, this will be a cost that is very difficult to recover.

Please take the time and meet with your management team, floor supervisors and critical suppliers. Improve your technical relationship with them.

In future articles, I will discuss some easy to understand details on process

improvement and compatibility with new and vintage converting machines.

As always...Enjoy Your Job !!!

Dick Target, owner of "On Target Consultants" based in Lower Gwynedd, Pa., has been in the corrugated industry for over 4 decades.

He teaches Flexo and Die Cutter Calibration "Short Courses" for TAPPI several times each year.

Dick Target also writes for Corrugated Today and International PaperBoard Magazines.

The Readers will recall that he is a regular contributor to our magazine.

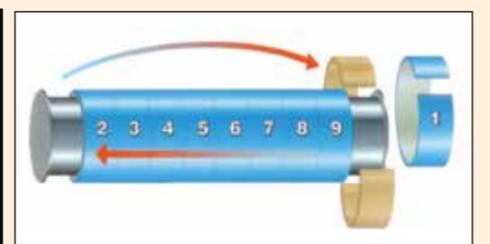
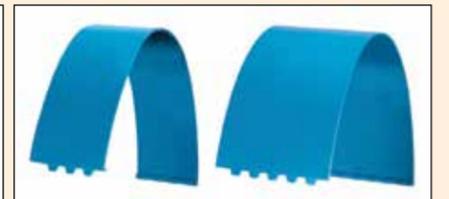
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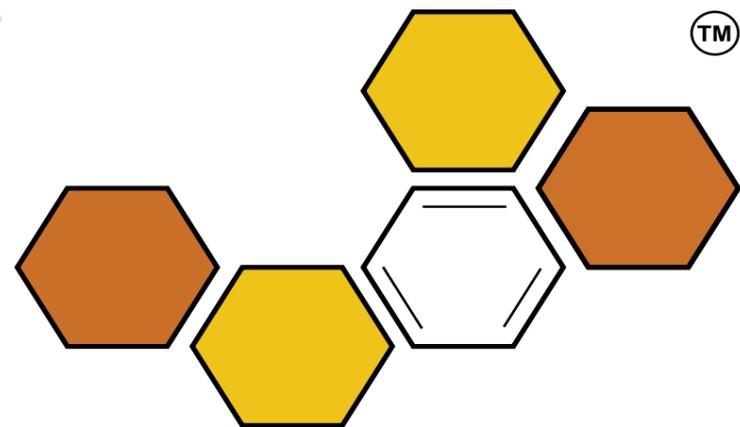
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How To Box

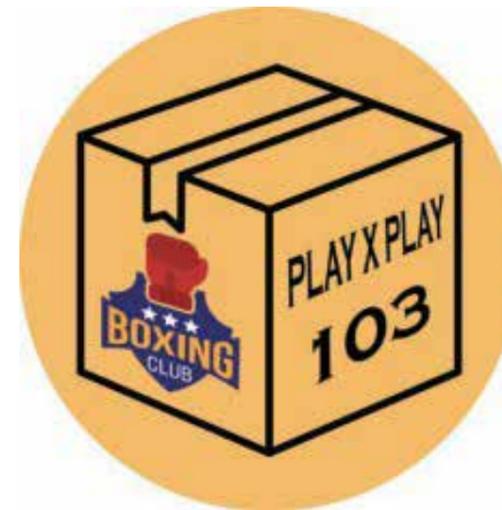
In the last issue (Oct. - Dec 2019) we had started a series Introduction which took a chosen look at the making of a corrugated (Fluted) Box.

The series is aimed at imparting a fundamental understanding of what it takes to successfully 'Box'.

Then final part of this series is presented here.



Kevin Koelsch,
Dynamic Dies, Inc.,
Holland, OH, USA



The players and their purpose

- Consumer product company (CPC)
- Ad agency/marketing for the CPC
- Box sales rep (BSR—or, phonetically, “bee-ess-er”)
- Box production managers (BPM)
- Box customer service agents (BCS)
- Box house designers (BHD)
- Cutting die vendors (CDV)
- Print plate vendors (PPV)

The plan

- What
- How
- Who
- When

The ordering

- General description and information
- Converting (boxing) equipment
- Print plate information
- Cutting die information
- Delivery expectation

The players

Consumer Products Companies

CPCs are the mighty Nestlé, Mondelez International, L’Oréal, AB InBev (Budweiser), Coca-Cola, General Electric (GE), Unilever, Tyson Foods, Procter & Gamble and the like. These companies use a lot of boxes for thousands of products. If the product isn’t actually in a corrugated container, it will most likely ship in one.

Ad Agency / Marketing

This is the integral step to package design and graphics. The marketing group uses data mining to guide them along the best path to successfully reach the consumers who purchase the goods. They create design ideas and graphic concepts.

The Ring Announcer 103

This is the third edition of a four-part series discussing how to box. If you’re just joining now, please know that our prior two articles covered the machine (inline flexo printer rotary diecutter) and the equipment (anilox rolls, ink, urethane rolls, print plates and cutting dies). In this issue, we will announce the importance of communication and collaboration. We will go through a generic look at how orders for tooling are placed, and the failure points that can ensue.

This edition will be broken up as follows, not necessarily in any order.



“In this corner! The man everyone’s betting on.”

Contd. on - 25

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Contd. from - 21

Box Sales Rep

These experts are the primary contact the CPC and/or marketing group go to when they need a box. The initial concepts are discussed and the first attempts are made to define concept to reality—quantity estimates, logistics and costs.

Box Production Managers

The actual BPMs may not be the exact contact at this stage, but the very next activity is planning the converting process that will actually take place to bring the packaging to reality and meet the CPC's requirements. Many larger, integrated companies have corporate technical staff that is tasked with the important connection from CPC concept to on-shelf reality.

Box Customer Service Agents

After the high-level planning is executed, the project is passed to these versatile communicators to organize a multitude of actions:

- Estimating project price
- Talking to schedulers
- Estimating freight and logistics
- Determining timeline
- Getting tooling quotes
- Conveying the expectations

Box House Designers

Engineering a box is not always four sides, a top and a bottom built to specific dimensions. These creative people can cut, crease, perforate and convert ideas into impressive displays, dispenser trays, carrying cases and shipping containers that morph into shelf-ready packages. Many times the BHDs work independently from the BCSs, but other times they work together, sharing the responsibilities of planning, collaborating and carrying out the execution of ordering the tools for the converting machine.

Side note: The BCSs (box customer service agents) and the BHDs (box house designers) are usually the people charged with acquiring the tooling (plates and

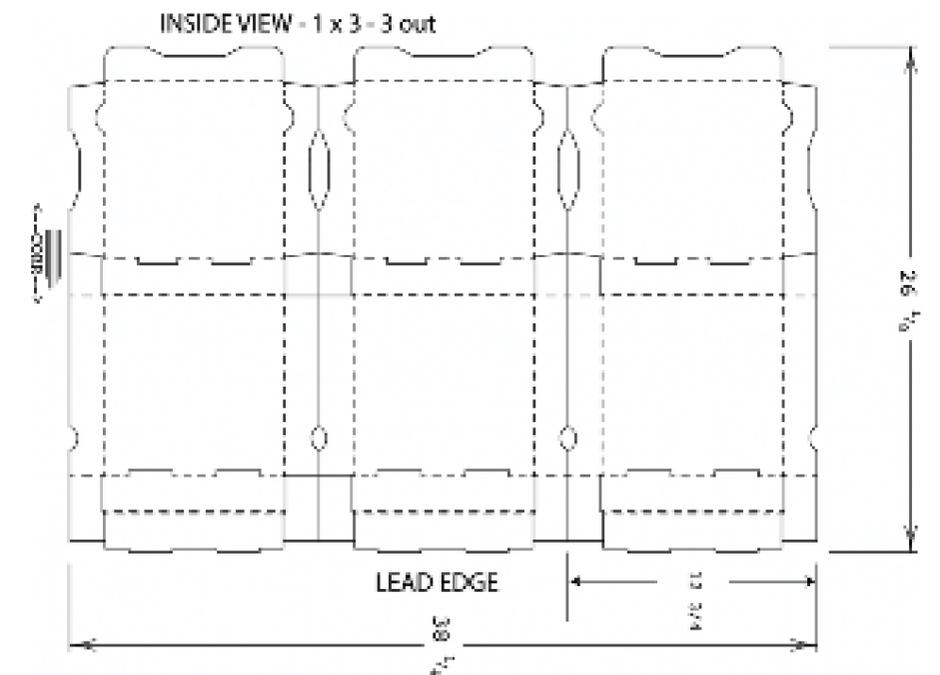


dies). These folks are relied upon for the required technical detail. Remember, the project is mostly conceptual from the CPC and the ad agency. They know “kind of” what they want. When it comes to tooling, it becomes very critical dimensionally. How knowledgeable the BCSs and BHDs are, how they collaborate with each other (when it is set up this way) and how clear the converting process is defined all have an impact on the success of the tooling

matches up to the equipment and ultimately in meeting the CPC's expectations.

Cutting die vendors and print plate vendors

The CDVs and PPVs are essential to the connection of information. The trade houses that produce tooling are generally relied upon to be the “technical lookout” for a successful plan. Many of the BCSs are great communicators, yet non-technical.





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Many of the BHDs are technical, but not communicators. Lump them together on a project and you can imagine the potential for confusion or conflicting information. The role of the tooling vendor is important because this is an outsider who will furnish a fresh, technical viewpoint to the project. The reason boxers have favorite vendors is for this very reason. They have a confidence that their favorite PPV and the CDV have an intimate knowledge of their individual and unique box operation, what works and what doesn't work. This intellectual asset is rarely acknowledged and mostly underappreciated. However, the general consensus among plate and die vendors is that appreciation is recognized by way of repeat orders and committed clients!

The Ordering

How NOT to place an order for cutting dies and print plates:

- "I want a cutting die tomorrow!"
- "I need print plates from this sketch, please."

This may seem funny, but in reality, it is often accurate. It is truly this urgent in most cases as, by the time the product company, marketing department, ad agency, distribution and box sales get organized, most of the project timeline has been exhausted and the boxer is likely already behind schedule. It is now time to order plates and dies, but all of the tiny details may or may not have yet been revealed.

The most common issue with shadow boxing is that it always seems easier when there isn't an opponent punching back. As I mentioned earlier, the trade vendors who make printing plates and cutting dies literally live by the revenue from the boxer's orders. Large box producers know this and wield a great amount of leverage with the smaller, usually independent, trade house. This condition has transformed the pre-press trade industry into something similar to your one-hour oil change operation. Box houses expect, and usually receive, custom plates and dies in two to five

days! The successful trade house must be automated, accurate and systemized to survive.

The key values to measure a print plate and cutting die vendor by are:

- Speed of delivery
- Competitive pricing
- Tooling performance

Typically, and unfortunately for the boxer, the ordering priority is usually in that order.

A common misstep is bypassing critical, pre-press alteration propositions for the print plates and cutting dies to "engineer" effective performance on press. This can be attributed to a reluctance of a box sale representative to return to the agency/marketing group to request minor design changes at this final stage. It could also be from an eroded timeline that prohibits deliberation on performance enhancement options. The easy way out is to consent to default, standard issue tooling.

Before tooling can be ordered, we must first decide on the machinery we will convert with and what material will be printed or diecut. What machinery choices do I have, what size is the machine and how can the proposed design be utilized across this equipment?

Until now, everyone who has reviewed the design and graphics has been looking at a single box. The layout may have been two-dimensional or 3D, but usually we're evaluating just the one design, a full pallet rendering or a store display model.

For box convertor planning, we need to determine the arrangement. Only a small



percentage of boxes are truly produced as a one-out. "Out"s refer to the step and repeat multiples of a design. "Up"s refer to the through-the-press or press direction and "out"s refers to across the machine or web. Examples would be: 3-out—1 x 3; 3-out—1-up x 3-out; or 3-out—one going through the machine and three running across (see Diagram 1). Not everyone uses the same terminology to describe a multiple-out arrangement, so this is one of the first bits of information that must be verified.

Once that is verified, the next question is whether the speculated layout will fit the designated machine. Very often, the parameters of what the machine will print or cut are based on the maximum or minimum sheet size the machine can handle. This can cause issues with tooling because all tools need an extra margin of wood (in the case of a cutting die) or mount material (in the case of a printing plate) beyond the finished sheet size to carry the cutting rules or print elements. With an effort to maximize machinery throughput per revolution, many items fall in the category of "dangerously close to the limits!"

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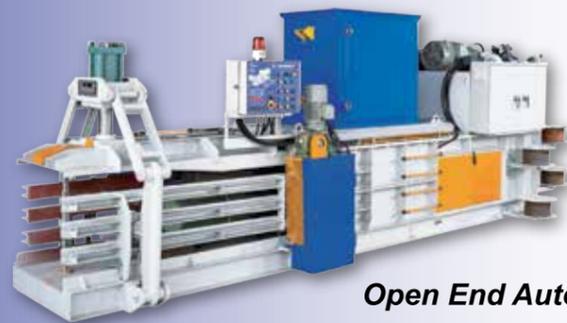
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Suppose we've gotten this far. The next piece of necessary information is the leading edge. The leading edge is the first edge through the press of the total sheet. This edge reference will relate to both the cutting die file and the art file for the plates. It might be a good time to mention the next vital information point, the view. A box designer is working from the inside of the box, while the graphic designer is working from the outside. Now, doesn't it seem like common sense that the CAD files for diecutting would be "inside view" and the structure files for the graphics would be "outside view?" Logical as that may seem, it is far from always being the case.

Here is the ring announcer's cheat sheet for the absolute minimum information required to order cutting dies or printing plates for the inline flexo printer rotary diecutter:

What (pre-press products)

1. **Print plate**
 - Sheet or liquid
 - Thick or thin (basic or hi def)
 - Mounted or loose
 - Number of colors/what colors
2. **Cutting die**
 - High volume/high speed;
 - Standard class/moderate speed; or
 - One and done

How (tooling criteria)

1. **Machine (cylinder size/pitch)**
2. **Material**
 - Flute: A, B, C, E, etc.
 - Burst test or ECT
 - Flute direction related to CAD file
3. **Number of outs**
4. **Arrangement (side by side/nested/gutters)**
5. **File view (art file/die file)**
6. **Lead edge**
 - Indicate on CAD file: flutes through and flutes across

Who

- Die vendor (CDV)
- Print plate vendor (PPV)
- Ink supplier
- Converter scheduler
- Box house designer (BHD)
- Box customer service agent (BCS)

When

- Tomorrow;
- Yesterday; or
- The day before yesterday

There is a short list of info you MUST HAVE to order tooling:

1. CAD file of structure/part/design
2. Machine to be used for converting
3. Material to be processed
4. Arrangement of design
5. View of provided files (inside/outside)
6. Lead edge

All in all, when the fight is done, the ring announcer steps to the center of the ring and a microphone drops from the rafters. As the bloodied boxers look at each other though swollen eyes, the ring announcer grasps the 1950s microphone and begins to speak. Through cauliflower ears, the fighters listen as the ring announcer booms in a very baritone, distinct voice, "And the winner is...!" The referee raises your arm toward the sky. You did it! You took everything your opponent could throw in your way to knock you off course, and in the end, you prevailed.

Tune in next time for the last article of the series, "The Final Decision 104." We'll take a glimpse behind the scenes for the measurement and analysis of true performance. We'll cover how to achieve the greatness awarded to those that measure, study, adapt and constantly move forward. True champions seek longevity and repeatability. Come back next month to find out the secret.



How to Box The Final Decision 104 (aka Performance)



When the fight is all over, a team of judges, who closely scrutinized the fight in its entirety, renders the final decision. The winner is always determined through a superior optimization of the equipment, trainer and manager, which as one team support the boxer with one goal in mind—and that goal is to win the fight.

So here we are, at the last article of the series which will review performance. It absolutely makes no sense to journey through the pain and bruises of the boxing ring if there isn't a prize worth the effort in the end.

Endless hours in the gym, thousands of jump rope skips, miles of white tape, jars of Vaseline and stench-laden, sweat-soaked gear, not to mention the enduring damage



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the fighter will retain afterwards—and all for what? I suggest it is for the glory of being memorialized as the victor, the champion, but mostly to be able to prove it. Proving it is not only holding the championship belt high in the air, but also statistically engraving the accomplishment in the history books for all time. That is why we do it.

What are the things we can measure from our boxing performance with the boxing machine we refer to as the inline flexo printer rotary diecutter?

- How many square feet of paper did we chew through?
- How many boxes did we make?
- How fast did we run?
- What was the measure of our effective use of time?

What was the quality of the product?

Did we make money?

The overall performance grade will be a compilation of these criteria. I feel safe to say most boxers measure at least some of these performance points, but it is also fair to question exactly what they do with this collection of data once they have it.

Good boxers will not only review all of these data points collectively, but also constantly challenge the results. What really are the benchmarks for achievement? Why? Can we do better? How?

In over 38 years of boxing, I admit I must still be naïve and biased in my viewpoint. I may even be wrong, heaven forbid; it wouldn't be the first time. However, from this vantage point, the one criterion I think

gets the most attention (and maybe it's the only criterion) when discussing the performance of a FDC (flexo diecutter), is the board footage produced. Of course this is a reasonable measure if your boxing operation's main objective is to chew up corrugated.

How many square feet of paper did we chew through?

This, of course, is a trick question. Simply passing the paper through the press does not relate the value of the process. Unless we subtract the waste product from the total square footage run through the press over "x" amount of time, we truly can't arrive at a figure that will relate to performance.

I think many corrugated box converters lose sight of the true performance of a machine because the focus is on board footage through the operation and not one particular press. I can visualize a corporate boxer reviewing a spreadsheet from the ivory tower at HQ and showing a box plant's six converting machines throughput (internet-style, in real time) in terms of square feet produced by machine center, and then a total of the plants throughput. Then whatever the amount is, they call down to the plant manager and tell him/her that they need to double the throughput.

I'm sure it's not just that—but maybe it's also not too far fetched?

- What is really important to me is:
- How many boxes did we make?
- How fast did we run?
- What was the measure of our effective use of time?
- What was the quality of the product?

Did we make money?

These five questions are the real determiners of overall performance. They are interconnected. The "how many boxes did we make" and the "how fast did we run" are derived from two realities:

1. The rotational speed (each rotation is equal to one impression).

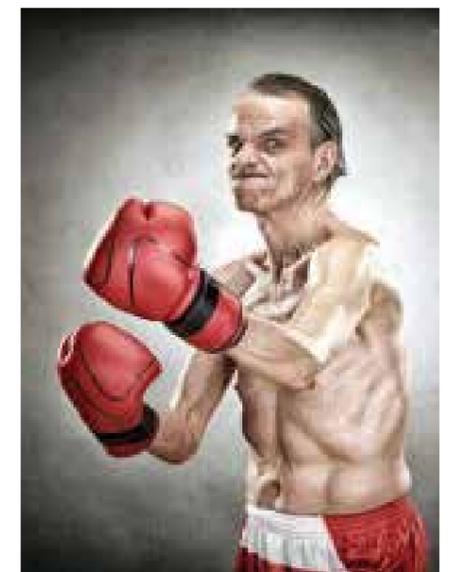
2. The number of boxes per revolution, or how well you utilized the full circumference and width of the machine's cylinder.

"Murphy's law" generally connects these two conditions. That is, small blank size and low box count per revolution result in higher rotational speeds. Optimizing the full cylinder with as many boxes as you can fit equates to slower rotational speeds in general. This is because the total area on printing, cutting and stacking pushes the limits of these individual processes. You must be able to feed, print, cut and stack in harmony. The slowest of these individual progressions will dictate the ultimate speed of the combined processes. If any one process struggles, they ALL struggle.

It isn't uncommon that running fewer boxes per revolution at top speed parallels running lots of boxes per rotation at a slower speed. Of course, the idea is to go big, go many and go fast!

The challenges here are:

- Large sheets are hard to feed, and handling requires pre-feed automation and equipment. This equipment takes up a great deal of space and does not lend itself to schedule/order changes.
- Printing a large area requires absolute parallels between anilox, plate and



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impression rolls. Any deviation here may not be so noticeable when you are only using the center portion of the rolls but when you are printing all the way across, parallel matters!

- Diecutting large blanks means a greater amount of cutting and creasing inches of steel rule and a larger plane of rubber for ejection. These two components result in greater forces to cut/crease/eject. To overcome the forces, greater penetration is applied. This tightening of the two opposing rolls reduces the operational gap. More penetration can cause machine wear, cutting die damage and part hang-ups. These conditions are present at any speed and compounded as the RPMs are pushed up.
- Stacking, folding, gluing and accumulating are the final steps of this process, and it is amazing how technologies have embraced the issues created by large, sail-like sheets of corrugated going through a machine at jet speed, being chopped into multiple pieces to then get shuffled into nice, neat and clean stacks of boxes ready for the truck

or the next operation. However, full utilization is more complex than simply acting on what theoretically CAN be done and instead involves what the realities truly are.

My advice: Someone looking only at a spreadsheet should not decide what is the most productive way to run the machine.

So let's get back to the real topic: How do we measure performance of this machinery? Factoring all of the options and results together, and then defining the planning protocol to address the new variables presented against the historic data, will be the best approach. The decision-making criteria will be:

What does the diecut and print look like? Lots of waste? Lots of angles? Rounded corners? Big, small, perforated, light weight, heavy weight...???

If we want to go with a large sheet of multiples, how well do they connect together to travel through the machine and then be separated?

How will the part(s) most effectively travel through, get printed, diecut and then stacked?

When we've decided on an arrangement or sheet size, how fast do we expect to run? With that, what is the square footage that will be accomplished?

Cutting with the flute columns running with the feed direction is more effective than running with the flutes across the cylinder. Have we factored slower speeds due to part wrapping and stacker issues in cases when the flutes are across?

Measuring performance

Machine efficiency is a final result of what the square footage yielded as a percentage of the total machine opportunity minus the wasted time and material.

Machine opportunity number

- Hours of operation
- Max RPM
- Max sheet size

What is deducted?

- Down time due to stoppage
- Set up time
- Quality rejection

What is measured?

- Actual sheet size delivered
- Run speed

- Total time to complete order
- Value of the individual parts
- Quantity of parts produced
- Quality grade of the order produced

Sheets per hour (SPH)	Machine cylinder size across		Machine cylinder size around	Available SQ FT per Revolution	% of cylinder used by die cut	Sq Ft Throughput per hour
4000	100	x	66	45.83	30.00%	55000
13000	100	x	66	45.83	75.00%	446875

Sheets per hour (SPH)	Machine cylinder size across		Machine cylinder size around	Available SQ FT per Revolution	% of cylinder used by die cut	Sq Ft Throughput per hour
5000	100	x	66	45.83	75.00%	171875
13000	100	x	66	45.83	30.00%	178750

From these measure points, an honest and fair assessment can be made about the machine performance.

In conclusion, when the total performance of a machine is considered vs. the actual realities

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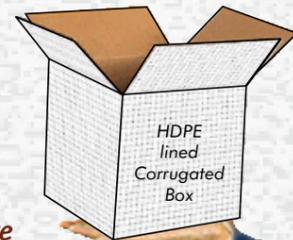


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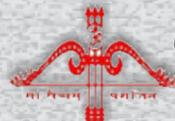


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of delivering parts against the machines potential, it is likely the buyer of a new machine will be disappointed. It is obvious that when the sale was presented, the only thing the buyer considered was how big a sheet it can take and how fast it will go.

For these reasons, large, fast machines are popular when it comes to printer/diecutters. It is also a trend to reduce the set up time with mechanical fixtures to hold the die and plates on, replacing the bolt-down, strap-on methods.

In reality, the only way you can be a champion at boxing is to study and act on all of the variables that equate to real throughput—not just the factors of theoretical throughput.

Kevin Koelsch is Vice President—Operations for Dynamic Dies, Inc. Kevin may be reached at 1-419-865-0249 or by email at kevin_k@dynamicdies.com. For more information, visit www.dynamicdies.com.

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The IADD is an international trade association serving diecutters, diemakers and industry suppliers worldwide.

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The material characteristic “compressive strength” can be determined with high accuracy using SCT because of the buckling stability provided by short test lengths of material is more reliable over traditional testing methods (Ring Crush Test, Corrugated Crush Test or Linear Crush Test).

Due to these technical advantages, recently SCT is being increasing referred worldwide. Many international paper testing laboratories recommend using the SCT to predict the final characteristics of boxes.

UBIQUE Short Span compression tester offers an easy and intuitive interface for the SCT test.



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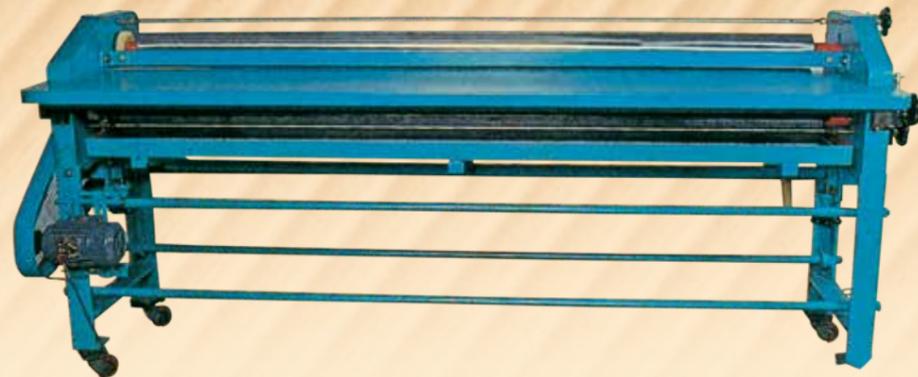
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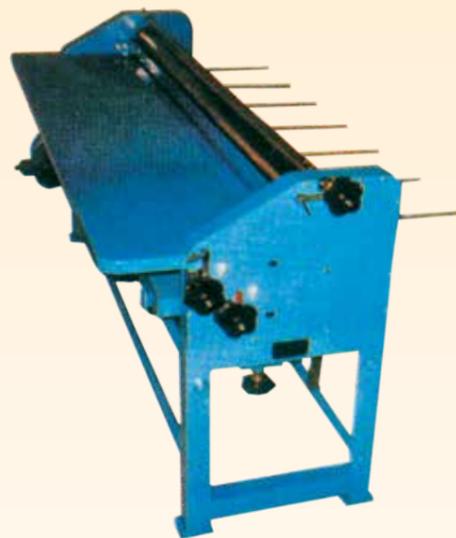


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Thinking Outside (And Inside!) The Box

The ability to flexo direct print on both sides of a corrugated sheet in one pass is generating a new level of excitement well beyond the brown shipping container. "It's cool and it's sexy and it's fun," Rob Golove, General Manager and VP of Sales of Arma Container, says. "We live in a brown world. I always say, 'Knowing someone in the corrugated business isn't so great until you need to move.' When you're able to show somebody something that has a strong marketing application then you've got something."



Jackie Schultz
Corrugated Today - Editor



Arma Container has been producing inside/outside printed boxes since 2016 with its G-Grafix flexo folder-gluer.



customer when they open up the product," Golove says. "What's nice is it gives a call to action that you could easily change almost like a coupon inside your box. We've found a lot of our customers are looking at almost 100% coverage on the outside with a message on the inside. That secures their culture with their customers. It's a phenomenal marketing tool."

New developments in corrugated printing technology are supporting this trend. Hycorr was one of the first companies to introduce a top print rotary diecutter more than 10 years ago, installing it at Genesis Packaging in Chicago. The 66-x 115-inch machine printed one color on top and three on the bottom of the sheet. Since then, Guangdong Dong Fang Precision Science & Technology Co. (represented by the Haire Group), BW Papersystems, Guangzhou Keshenglong Carton Packing Machine Co., Ltd, (KL) (represented by Global Boxmachine LLC), Latitude Machinery and SUN Automation, have introduced single pass inside/outside printing solutions.

Retailers, especially companies that sell products on-line, are looking for ways to differentiate and "wow" their customers. The box is no longer "just a box." Consumers want an "unboxing" experience.

Arma Container, a sheet plant in Deer Park, N.Y., has been printing on both sides of a sheet in one pass for several years now at the request of a customer that sells products on-line. "It's certainly the way of the future because for our customer who is an Internet company they want to deliver an extra message. They want to wow the



All G-Grafix models from BW Papersystems can be configured with single-pass double-sided printing.

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Abbott-Action's Apstar rotary diecutter has two top printing units and four bottom printing units plus a dedicated UV coating station.

Arma Container was using two machines to produce inside/out printing orders and challenged BW Papersystems in 2016 to come up with an inside/outside solution. "You had to plan to take down two machines and you had to be at least 60% through the diecutter before you could start setting up the other machine," Golove says. "Our Field Sales Manager (Stephen Weil) wondered why we couldn't have a machine that prints both sides in one pass."

As a result, Arma Container was the first installation of a G-Grafix flexo folder-gluer with top and bottom print units. The machine has two outside and one inside print stations and a diecut unit. The efficiencies gained are worth nothing: eliminated 7,496,996 additional feeds; eliminated 123MSF of dunnage needed for the first pass; eliminated 479,800 LF of strapping needed for the first pass; eliminated 4,136MSF of waste accumulated for the first pass (1.9% waste); reduced direct labor by 2749 hours; reduced indirect labor by 547 hours

Finer Printing

The Haire Group has installed Apstar flexo folder-gluers and rotary diecutters with inside print units at plants around the U.S., including Rand Whitney, Cumberland Container Corp., Akers Packaging, Acme Corrugated Box Co., Inc. and Abbott-Action, to name a few.

Abbott-Action's six-color Apstar HG2 1628 rotary diecutter has two top printing units, four bottom printing units and a servo dual slotting section in addition to the diecut section, enabling it to print two-color inside and five-color outside. A seventh print station was added after the machine was installed as a dedicated UV coating station. The configuration is one of the most sophisticated in the country.

Less than 10% of the jobs run on the new machine are inside/outside print, however, that percentage is expected to grow

significantly as the Attleboro, Mass., plant hones its printing excellence. "

The majority of the work we've done so far is one-color inside," Chuck Slingerland, Abbott-Action Vice President of Sales and Digital Operations, says. "For orders that require more than two colors on the inside we're running them on the Jetmaster (digital press from Barبران) and then running through the Apstar."

Acme Corrugated Box Co., Inc. installed an Apstar 1632 HG2 rotary diecutter at



Acme Corrugated's marketing promotion for two-sided printing

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its Hatboro, Pa., facility last year. Jeremy Cohen, Vice President of Operations, had a few accounts that wanted inside/outside print, which required two passes. With the ability to print two colors on the inside and three colors on the outside of the sheet, the new Apstar can achieve the same results in one pass.

Based on the current book of business, Cohen says he is pleased with results. “We configured this machine different from our other flexos and rotary diecutters so that I can run blow and go if I want to, but I can also do some finer printing.”

The diecutters at Abbott-Action and Acme both have dryers from JB Machinery.

“If I want to do full coverage, that’s something that we haven’t been able to do very successfully in the past,” Cohen says. One customer has a box that is full coverage black print top and bottom. “Now I can run it at more production speeds with the dryers,” he says.

In-line at High Speed

Inside/outside printing is becoming a niche market for Wasatch Container. The North Salt Lake, Utah, sheet plant began printing on both sides of the sheet about three



For inside/outside printing jobs Wasatch Container purchased a Curioni MiniPro.

years ago, running jobs in two passes. The company’s new Curioni 618 MiniPro from BW Papersystems allows it to run the same jobs in one pass. The four-color flexo folder-gluer is configured for three-color outside and one-color inside.

Ryan Frisch, Wasatch Container Sales Manager, says Wasatch purchased the

machine for two reasons. “One, we needed to invest in some modern technology, and this machine makes very good square brown boxes. It does quick setups and runs at high speeds, which is critical when you’re making RSCs. The other reason is our customers want packaging that they can connect with. They want the unboxing experience. They say one in five consumers have watched an unboxing video. I also heard a statistic that 56% of customers’ re-purchasing decisions are influenced by their interactions with the packaging. That’s all growing mainly through the e-commerce world. And retail is growing as well.”

Less than 10% of the orders produced on the Curioni are printed on both sides. “It’s business that we’re building,” Seamues Ramos, Wasatch Container Operations Manager, says. Frisch adds, “Ninety percent plus is still brown boxes because we run a lot of brown boxes. Inside printing is a value-added segment. The machine doesn’t take a whole lot more to print on the inside versus the outside.”

To achieve the same results Wasatch was double or even triple passing jobs. “We had one product where we were running it



This box from Wasatch Container won second place in the 2019 AICC Packaging Design Competition.

Contd. on - 49

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Compression Tester



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"Linux" Servo Crush Tester are designed for performing Ring Crush Test (RCT), Edge Crush Test (ECT), Flat Crush Test (FCT), Pin Adhesive Test (PAT), Concora Medium Test (CMT), Corrugated Crush Test (CCT) and other general compression tests, on a variety of materials like paper, paperboard, etc.

These multi-functional equipments incorporate Servo Control System which drives the compression platen steadily along the guide track to compress the specimen.



Rub Tester

To measure the rub proofness of prints on paper or board. Can also be used to measure colour transfer from printed or coated materials during rubbing.



Sutherland Ink Rub Tester (Micro Digital)

Sutherland type rub tester for ink rub test is a new type testing machine designed to measure scuffing or rubbing resistance.



Crease & Board Stiffness Tester

A multi-function tester, mainly used for measuring cardboard, color box (such as Duplex carton and Mono Carton boxes)



Internal Ply Bond Tester

For testing internal bond strength of paper board.

Can Test five samples at a time



Puncture Resistance Tester (Digital Model)

The puncture test determines the board's resistance to penetration by sharp and solid objects.

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Latitude Machinery Corp. offers inside print on all its brands of flexo folder-gluer and rotary diecutters.

through our rotary twice and then putting it through a Bobst diecutter because the diecutting was so intricate,” Ramos, says. “Now the majority of that type of business we can run in-line at high speed.”

Maximum speed on the Curioni is 22,500 sheets per hour and setup times are typically under five minutes. “For an inside print job, we’re probably looking at a seven-minute setup and we’re probably running almost five to six times as fast as what we could previously run,” he says.

“The way we grow is by offering innovative solutions like two-sided printing, and this machine is such a fast setup that we can make money running 500 boxes because of the quick setup,” Frisch says. The machine can run blank sizes ranging from 7- x 7-inch up to 23.5- x 74-inch.

While inside printing was certainly a motivating factor for purchasing a new machine, Frisch and Ramos say the more important quality was the ability to run existing business. Eighty percent of the sheet plant’s current book of business can run on the machine.

Sales Tool

Latitude Machinery Corp. is currently quoting inside print on all its brands of flexo folder-gluer and rotary diecutters with repeats from 25- through 66-inch, according to Rob Casella, Global Product and Business Development Manager, SUN Automation Group. Last year, SUN Automation became LMC’s exclusive representative in North and Central America. “Since we began working with LMC, we have seen significant activity in North America for inside print,” Casella says. “LMC has over 100 machines installed in North America and plans to install an inside print rotary diecutter unit in the first half of 2020 in the U.S.”

Diamond Box in the UK installed a five-color model 1625 rotary diecutter from LMC in 2017. It is configured with three outside and two inside print units.

“LMC is not SUN’s only solution,” Casella says. “SUN’s own engineered and built 625RDC has inside print capabilities.” The company also offers its patented Spectrum® inside print units for many

OEM machines. Recently, SUN designed, manufactured and installed a Spectrum inside print unit for a 1990’s vintage Ward rotary diecutter and will ship four more units this year for Ward and United rotary diecutters. SUN can supply Spectrum units for most rotary diecutters and flexo folder-gluer.

Global Boxmachine introduced the KL line of flexo folder-gluer and rotary diecutters with top and bottom printing capability to the North American market at SuperCorrExpo 2016. The company has sold 21 machines. Jim Schiffman, President and CEO of Global Boxmachine says the interest is very strong and the market applications for inside print continue to expand. “With the experiences I was observing over the last few years with my son opening his iPhone and posting a video on-line and with more people buying online, I just knew there was something to this,” he says.

A machine that can help deliver that “unboxing experience” is a smart marketing move, Schiffman says. “Always

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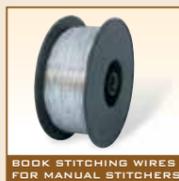
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The KL line of flexo folder-glueers and rotary diecutters from Global Boxmachine have top and bottom printing capability.

try to give your salespeople the most tools in their toolbox."

With inside printing, board converters see opportunities for higher margins. "There is a great opportunity to upsell the customer into that experience and that should come

with a higher value box. One really nice thing is no one else in our market is doing it so if you get them into it and they love it you lock them into some business," Frisch says.

Cohen agrees. "One of our salespeople came up with the idea that even if we have a customer that is just traditional outside print, maybe we can sell them on something they need to print on the inside. Then we can insulate ourselves."

Acme is taking a somewhat different approach to the market, installing a machine first and then building the business. "We have not done a ton of work yet in that space but we're starting to do more," Cohen says. "I don't know where the market is going to go yet. We bought the machine on a hedge. We think the business is out there. We didn't have enough to buy the machine based on it but at the same time this machine can do regular printing too. At the end of the day, it's about can we make some money doing this and can we make more than we would make if I was just running regular stuff."

For Alma Container, the market opportunities have been strong. "The investment has already paid for itself in three years," Golove says. "Amazon thankfully has taken all the attention of the integrateds with their blow and go strategy, leaving the smaller and medium sized Internet companies to build their customer loyalty by delivering an experience and the only way you're going to get that experience is inside the box."

Jackie Schultz is editor of *Corrugated Today* magazine and contributing editor of *Board Converting News*. She has been covering the corrugated and folding carton industries for more than 20 years. She is based in Cleveland, Ohio. Jackie may be reached at by email at jcschultz@corrugatedtoday.com



SUN Automation installed a Spectrum® inside print unit on a 1990's vintage Ward rotary diecutter.



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Specifications			
Model No.	OMEGA-23 / ES-23	OMEGA-28/ES-28	OMEGA-32/ES-32
Max. Sheet size	700 x 2,000 mm	1,200 x 2,500 mm	1,200 x 2,900 mm
Min. Sheet Size	250 x 600 mm	300 x 900mm	300 x 900 mm
M/C Dimension	2,800 x 12,000 mm	3,100 x 13,000 mm	3,500 x 13,000 mm
Max. Belt Speed	200 M/Min		
Max. Stitching Speed	120 Sheets/Min (OMEGA Model) 100 Sheets / Min (ES Model)		



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5 Environmental Advantages Of Corrugated Packaging

With more and more businesses being scrutinized for their environmental impact, it's more important than ever to turn to responsible packaging choices. When considering shipping options, brands want to know about the environmental effects of the materials they use, along with how they can reduce their carbon footprint.

With eco-friendly solutions in high-demand by consumers, brand owners are aware of the benefits of using more sustainable packaging, such as paper-based corrugated. As ethical shopping has become integral to the purchasing process, customers are now looking to select brands based largely on which ones are making a reasonable effort to be environmentally friendly.

So, if you're thinking about using corrugated packaging, here's how it might help your business support responsible sourcing while also considering the environment.

1. Corrugated packaging contains recycled content and is recyclable

The main ecological advantage of corrugated boxes is that they are made from a high percentage of recycled paper, think cartons or newspaper, and can be recycled again after they have been used. Similarly, most corrugated packaging is made without dyes or bleaches, meaning it can be disposed of more sustainably than other types of material that contain contaminants.

2. Corrugated packaging is renewable

Manufactured from paper pulp, corrugated packaging is predominately made from timber from fast-growing pine trees but can also be created from woodchips and leftover materials from a range of paper-making processes. Plus, most corrugated packaging is made up of around 70% to 100% of recycled material.

Suppliers that make large amounts of corrugated packaging usually harvest materials from managed, sustainable

forests—and replace harvested trees with seedlings to begin the process again.

3. Corrugated packaging is reusable

Not only is corrugated packaging easily recyclable and renewable, but it can also be reused as is, helping to further reduce packaging costs and the environmental impact. Many corrugated case styles are designed to be easily collapsible, and fully reusable.

Most boxes are not instantly disposed of, so why not make the most of their durability? Corrugated is known for being a solid, sturdy solution that can carry a range of weights—so cases can be used over and over for an array of products.

And when cases reach the end of the line, consumers can still reuse them for storing documents or as floor protectors when redecorating, for example. And, when they are finally done with them, consumers can simply recycle them.

4. Corrugated packaging helps to save energy

Another benefit of corrugated packaging having a high percentage of recycled components is that it requires less energy to make. Rather than producing cases from 100% virgin materials, most corrugated manufacturers make products from locally



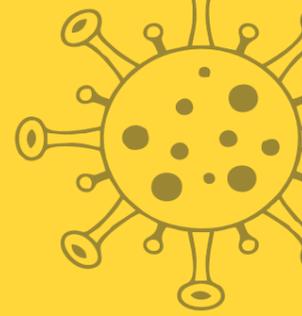
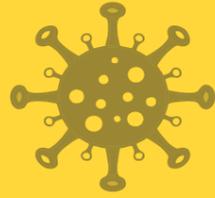
Barry Tabor
 Managing Director
 BCS

sourced recycled content—which also minimizes environmental damage caused by excessive transportation.

5. Corrugated cases offer efficient protection for your products

Many businesses today are creating right-sized boxes for their products to help cut down on the amount of material waste. Doing so can also go a long way towards helping reduce your business' carbon emissions when it comes to shipping and transport. Since boxes are usually rectangular—meaning they can easily and neatly stack with little space wasted—it allows businesses to fit more products into a smaller number of vehicles, which makes a huge difference to a company's carbon footprint.

Barry Tabor is managing director of British Converting Solutions North America LLC, which offers a range of box making machinery to suit various packaging needs. For more than 30 years, BCS has been a leading provider to international businesses, and it won The Queen's Award for Enterprise for international trade in 2016.



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The Benefits of Choosing the Right Corrugated Box Company

Packaging is a vital step in the agricultural industry that determines how produce moves from one location to another. A corrugated box is one of the most widely accepted and broadly used packaging materials in the world. Companies choose corrugated because it is superior and more flexible than other materials.

The right corrugated box company must help to deliver a proper packing box to meet your needs. Any machinery limitations that slow the process down, that create inconsistencies in the graphics or in box strength, or procedures that produce a lot of waste should be taken into consideration when choosing a corrugated supplier for your farm or produce business.



The Benefits of Picking the Right Company for Your Corrugated Box Needs

Cost Saving

There can be significant cost-savings in choosing the right corrugated manufacturer. It's not always the upfront price you should consider. A great manufacturer will work with you to understand the actual products you're shipping and fulfill your shipping requirements exactly.

Tailored Packaging

The right corrugated box company will truly understand the commodity you are shipping and any nuances that come along with it.

Important factors in choosing the best packaging include:

- The shelf life of your produce for ventilation
- Sunlight effects for proper shading
- The product weight to ensure box strength
- The number of commodities that will fit inside the box to ensure proper fit

How the box will be displayed to the end consumer to select appropriate graphics

The right corrugated box company will also work with you to understand any regulatory issues surrounding the packaging

and transport of certain products. If there are special considerations for the products such as partitioning or cushioning, these should be factored in during the design phase.

The Lowest Price Isn't Always the Lowest Price

As noted above, the right box manufacturer will make the packaging that best suits your specific shipping and display needs. They should always deliver on quality and consistency at all times and without cutting corners.

Choosing the Right Manufacturer Reduces Wasted Boxes

Selecting a corrugated box company simply because they've given you the lowest up-front quote can lead to major cost nightmares down the line. A reputable manufacturer will most likely be competitive in the marketplace as it is, and will do everything possible to ensure your box is consistently reliable — regardless of the quantity you order. This will ensure there is very little waste in their processes and will result in the best value for money.

Investing in Quality Prevents Product Spoilage

Sometimes the corrugated box company with the lowest quote (appealing as that quote may be) chooses low-quality paper suppliers for your boxes. These substandard materials then lead to trouble with the strength and durability of your product packaging over an extended production. This ultimately results in product being lost or damaged during transit and your end consumers associating your product with poor display qualities.

Your Products Need Proper Protection

Safety is an essential aspect of determining the best packaging option — especially



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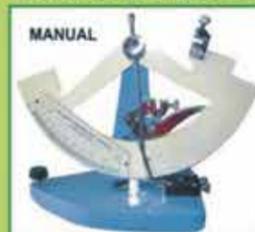
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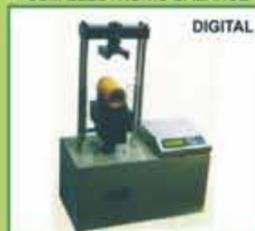
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when it comes to perishable produce and other fragile items. The design of the boxes, the materials used, and the execution of their manufacture will all play a role to help determine if the goods will be kept safe during transit.

Good corrugated box companies will take the time to explain various aspects of quality control to you and won't shy away from the topic when asked. They should focus on the consistency of their product and ensure that their processes are nearly error-proof.

See What Others Are Saying

Before signing on with a corrugated box company, be sure to check their reviews. A company that has complaints about the quality of the fiberboards is a major red flag. There is a lot of quality testing required for different packaging. It may take several designs to come up with the ideal box for your situation, but more often than not, an experienced company will

The best-corrugated box manufacturers want to help the environment by reducing paper waste, recycling waste properly, choosing non-toxic chemicals whenever possible, and selecting paper companies that support reforestation efforts.

Substandard Boxes Can Pose a Major Export Risk

Many countries have their own rules about how each package should be wrapped. Middle Eastern markets, European Union markets, Asian markets, and others have set regulatory practices that companies must follow. Attempting to make exports in packages that are not consistent with their standards could have expensive repercussions.

For example, in the European Union, apart from specifying the grading system of the product, they define labeling procedures for the box manufacturer and the owner of the shipped product. You cannot afford to miss any of these specifications.



already know what will work best as they'll have produced packaging for your product with success in the past

Sustainability Efforts

Today's most responsible corrugated box companies have a set of principles and standards that include environmental responsibility considerations. Reputable corrugated manufacturers should be sourcing the paper they use from sustainable paper companies and environmentally conscious vendors for the other materials (like glue).

The Right Corrugated Manufacturer Complies with Export Requirements

Experienced corrugated box companies understand the sensitivity of export markets. They also know how vital export markets are to your business. They don't just make boxes for the quick sale, they should actually advise you on the best packaging practices to help your company's longevity. They should help you comply with, not avoid technical requirements. This becomes especially important in an era of global trade where logistical support is usually welcome.

Consistent Boxes Utilize Space Efficiently

What happens if, through outdated machinery or bad manufacturing practices, the corrugated box company's machines incidentally reduce your boxes size by half an inch due to a cutting error? To some it may not seem like a big deal, but even as little as 1000 units translate to 500 inches of lost space. Or — at the very least — a seriously challenging box-packing situation.

If a box does not meet the specifications, attempting to stack it can bring distortions that can affect how products fit snugly into containers. If a package is supposed to be firm, it should not end up swinging back and forth, because that will increase the number of hazards.

Quality Control is Worth the Effort

Logistics demand a careful balance that boils down to one word: Efficiency. You want optimal performance at this level — especially when you are dealing with mass production. The unexpected costs can be excessively high if you are not meticulous about quality control.

How Do You Select the Right Corrugated Box Company?

When deciding on the best-corrugated box manufacturer for your packaging needs, take special note of the following recommendations:

- Pay attention to the details when discussing your box needs
- Focus on processes and ensure high-end machinery inside their box plant
- Look for experience and reputation among their support staff
- Ask for recommendations from their current top customers
- Insist on quality and consistency for the best possible packaging outcomes.

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Applications

- Soap wrapper • Corrugated boxes meant for fruits, vegetables, flowers exports. • Boxes for tea, ice cream, butter, milk powder, paneer, cheese, Dahi etc. • Corrugated boxes for Bidi, Cigarettes, Tobacco, Soap and other moisture sensitive products, Garments, Fabrics, Yarn, Fish, Meat, frozen food exports, electronic and electrical goods which are moisture sensitive, Industrial goods packing in Rainy season. • Multiwall paper bags for moisture sensitive products. • Water proofing of all paper Pouches. Replacement of tar coating, Waxing and plastic coating by this biodegradable coating.

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- Direct contact with food has no problem.
- Coated paper is heat sealable & Microwave Resistant.
- Very Fast drying, Cost effective coating for paper.
- Product Conforms to IS-17072 : 2019.

Applications

- Wrapper for Butter, Sweet, Snacks, any other milk products.
- Corrugated boxes for Fish, Meat and other frozen food exports.
- Paper Cups & Paper Plates. • Food Boxes. • Multiwall paper bags for moisture sensitive products. • Ice Cream Cups & Pouches • Paper Pouches for Food & Non Food Products.
- Replacement of tar coating, waxing and plastic coating by this biodegradable coating. • Coating on duplex board in place of PE coating. • Soap wrapper • Coating for mono- cartons. • Paper Bags for all purpose. • Paper Pouch for different products.

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Boxes That Keep Giving: Corrugated Packaging with Great Graphics

Modern-day packaging not only carries and protects products. It also promotes them by conveying information in an attractive manner. It influences customers' perception of the products and their response to them.

Packaging can be of various shapes, based on your product and logistics. It can be of different materials, such as corrugated boxes. Packaging design can also differ, depending on the impression you want to make on your customers.



Why is Packaging Design Even Important?

Product packaging is an entire industry in and of itself. It should be seen as an important part of your marketing strategy. Many multinational design agencies vie to create innovative packaging designs and strong branding messages for agricultural companies because of the huge exposure packaging receives in retail stores. Packaging design is the art of matching a vast range of products to very specific packaging solutions. As each product has different attributes such as size, weight and volume, packaging solutions also differ accordingly.

The following are some of the many factors attributed to packaging design:

Materials used in packaging, such as corrugated, fabric, paper, plastic and more

- Dimensions and durability that can affect the supply chain
- Shipping standards and regulatory compliance, which may differ from region to region
- Finishing details such as print color, quality, and finish
- Design innovation which can differentiate your brand and attract attention
- Cost, which depends on all of the other factors listed above

- Sustainability and environmental considerations such as packaging made from recycled material or can be recycled, or finding another use for the package or its material after its original purpose is fulfilled

An original and creative packaging design, consistent with your brand, can be the key to success in the modern retail arena.

The Importance of Printed Packaging

Packaging design connects structure, form, materials, color, images, typography, and all the necessary information that helps promote your product. Printed packaging is crucial as it is the last marketing impression you deliver to your customers to entice them to buy your brand over another. It is also the first thing retail buyers notice as a product reaches them. The time, energy and investment you place into printed packaging will more than pay off in improved visibility among customers in crowded retail stores plus help create a preference in the minds of your buyers. However, your packaging needs to be more than just attractive to succeed. It needs to have a few important features:

Honesty: Good packaging design does not mean depicting a product as something much better than it actually is. If you pack a small unattractive fruit in a package that shows a huge colorful one, it amounts to misrepresentation in the eyes of your target audience. This leads to dissatisfied



customers and a sullied brand image. Represent the product in the best way possible, but with honesty.

Shelf impact: On retail store arena, your product might be one among many, especially when customers see it from a distance. Your packaging has to be distinct and attractive to have shelf impact. Choose a design that pops.

Flexibility: Your packaging design should be able to accommodate a new product or even a few changes to the product it was customized for. It's always more cost effective if your packaging allows for slight variations in product size without adverse effects to cost or appeal.

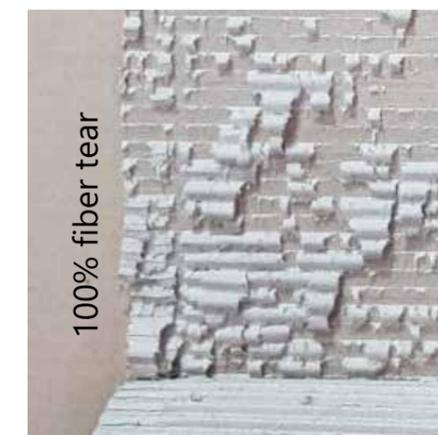
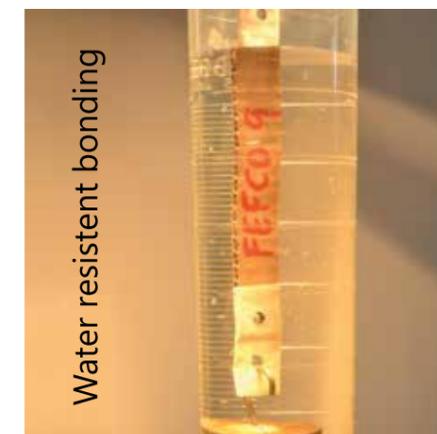
Branding: Successful packaging design is such that it becomes so intertwined with the product it carries that they are no longer seen as separate objects. Packaging is a mark of your brand's promise. Everything on it should be in your brand's custom typeface and colors.

Marketing: You can use printed packaging to promote a product's freshness, its

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various uses, and production. Add an element of pleasant surprise for them by printing a discount code or a free service.

Transparency: Customers buy products they trust. So, it is important to provide more information and clarity about your product. Printed packaging helps you to provide information on contents as well as size, model, quantity, expiry date, etc. This fosters trust and loyalty.

Differentiation: Great packaging distinguishes your product from the many thousands of products in stores worldwide. A plain brown corrugated box comes alive with exceptional design, innovative structure and an impressive finish. Find the type of packaging that suits different markets and use it to promote your product. It should address all customer requirements and influence their choices to help influence their buying behavior.

Sales: Consumers are much more likely to notice and purchase products with great

packaging design over an array of similar items. They appreciate unique, thoughtful printed material. Choose an uniquely identifiable design that your customers will remember and continue to look for.

Environmental safety: If your product and packaging are eco-friendly, print the eco-friendly symbol on your packaging. Retailers and customers will be able to identify your brand as an ethical and socially responsible one. It will also give you an edge over your competitors.

Corrugated Boxes with Graphics

The machinery used to make boxes is now highly advanced and agile. This means that corrugated boxes can be made of any size or shape and in any quantity at great speed. They can also be made in an array of different colors and with different finishes.

The corrugated packaging sector is now developing systems and processes to address digital printing requirements.

Such cutting-edge capabilities help the sector to offer far greater customization in packaging material. You can choose boxes of plain or colorful exteriors and interiors.

Corrugated surfaces are also suitable for high-quality printing. The surfaces of corrugated boxes absorb ink and retain it well. You can embellish your messages with various graphics and design elements that boost your brand equity. You can also personalize them according to customer preferences. This is sure to win the ever-changing attention of your customers and set you apart in the fast-growing competitive market.

Custom-printed corrugated boxes are much more than just packaging with words and images on cartons. They are beacons that instantly steer the attention of your target audience to your brand. These boxes reinforce and associate your brand. The advantages they offer can help increase the growth and profitability of your business.

Corrugated Packaging: Recyclable and Sustainable

When choosing a packaging type for transporting your products, the environmental footprint and ease of recycling of that packaging is an important consideration for your business as well as the retailer and end-user. Here are three reasons to choose recyclable corrugated cardboard for transporting your produce to market:

1. Made with Sustainable Materials

Essentially made from paper, corrugated cardboard is one of the most natural packaging materials in existence and also the most lightweight. To make corrugated cardboard, wood pulp undergoes a chemical process that breaks down the fibers. These fibers are then used to make the paper that is used in our fiberboard boxes.

In the United States of America, the timber used for producing corrugated cardboard is generally sourced from certified sustainable forests similar to the ones



managed by FGS. These forests are planted with several different species to ensure biodiversity and a healthy habitat for animals. They are harvested gradually and are promptly replanted to ensure timber and habitat for future generations.

To reduce our reliance on virgin timber and close the recycling loop, corrugated cardboard is often made from recycled paper products that can make up 30–100 percent of the finished material.

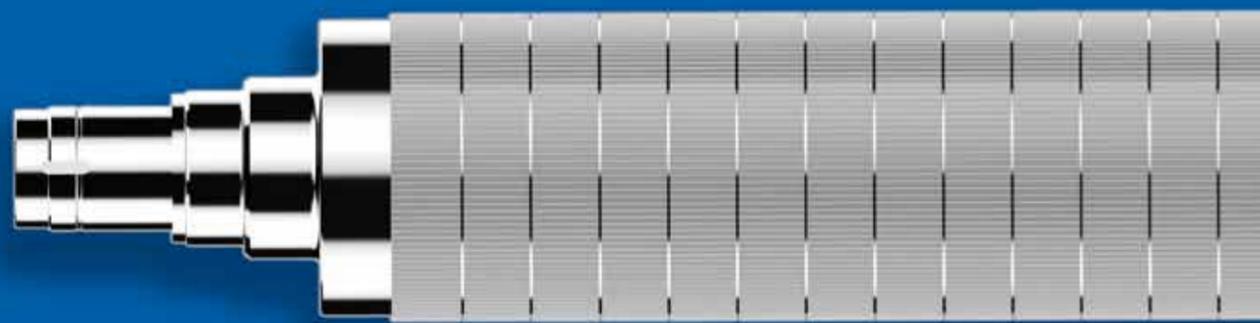


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About HAILI CORRUGATED ROLL
HAILI CORRUGATED ROLL (CHANGZHOU) MANUFACTURE CO., LTD, established in the end of 2015, is a professional corrugated roll manufacturer reborn by the complete taken over of "HAILI CORRUGATED ROLL" by BHS GROUP also gets fully supported by BHS.

2. Biodegradable Glues, Waxes, and Dyes

When people ask the question "can you recycle corrugated cardboard," they are often concerned about the ingredients used in the box's binding agents and treatments. Fortunately, newer formulas have enabled us to manufacture corrugated cardboard boxes using cornstarch adhesives, natural wax, and environmentally-friendly dyes that break down easily in the corrugated cardboard box recycling process.

3. 100% Recyclable

Biodegradable materials and modern technology make it easier than ever to recycle your corrugated cardboard packaging. According to Recyclebank®, removing the packing tape and labels from corrugated cardboard boxes before recycling is generally not necessary, as the tape will either be removed by workers at the recycling plant or will come away naturally when the box is soaked and the paper converted into a pulp slurry.

Before recycling your corrugated cardboard, consider reusing the boxes or offering them to customers for packing their shopping and/or to anyone who is moving house. Once the box has reached the end of its life, simply collapse it down and separate it for recycling.

The Difference Between Corrugated Fiberboard and Cardboard

Understanding the differences between cardboard vs corrugated fiberboard is an essential first step to take as you choose storage and shipping solutions. While the two materials are often referenced interchangeably, they're actually quite different from each other.

Corrugated offers some significant advantages over traditional cardboard, ensuring that your produce gets from point A to B without any issues. Read on to discover the important differences between corrugated cardboard vs regular cardboard.

Corrugated Is More Durable

Traditional cardboard is a thicker, heavier version of paper stock or pulp. For example, a cereal box is made from cardboard. Corrugated, on the other hand, might be made with cardboard materials, but the overall design and structure is much more durable.

The biggest difference between cardboard vs corrugated fiberboard is that corrugated is made with three layers. There's a ruffled, fluted material sandwiched between the inner and outer cardboard layers, providing exceptional strength that can withstand severe wear and tear throughout the packing, storing, shipping, and retail display processes.

Corrugated Is Better for the Environment



be practical physically or financially.

That's the major difference between corrugated cardboard vs regular cardboard:

Corrugated is biodegradable and contains no dyes or bleaches, so it can be composted and recycled effectively. At Fruit Growers Supply, we partner with supply chain vendors who source materials primarily from sustainable forests. Unlike traditional cardboard boxes, corrugated cartons can be reused over and over again, saving you money while reducing your carbon footprint.

Corrugated Is Lightweight and Flexible

When considering the weight of cardboard vs corrugated fiberboard, it's important to keep the overall strength-to-weight ratio in mind. While cardboard is a lighter material in general, corrugated is going to be much more rugged at the same weight.

The ruffled inner layer offers incredible strength and flexibility while keeping the overall weight of the container down. In order to achieve the same amount of strength as corrugated, you would need to use a much heavier cardboard that wouldn't

Corrugated is designed with the unique needs of the end user in mind, while regular cardboard is simply a means to an end. That's not to say that regular cardboard doesn't have its place; it's just not suited for heavy duty applications.

Corrugated Is Customizable

As you learn about cardboard vs corrugated, remember that it's all about context. If you're packaging cereal, corrugated wouldn't be the right choice. If you're shipping fruits and veggies, corrugated is the best choice, by far.

The great thing about corrugated is that there are endless customizations and combinations available. Say you're shipping apples to a retail store. Not only can we provide tough, lightweight shipping containers, but the retailer can also use those same shipping containers as retail displays. We deliver custom corrugated solutions that align with your unique challenges and goals.

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Corrugated Equipment And Systems In Paper Industry

A corrugator or corrugation equipment is best defined as a set of machines that is designed to bring together three, five or seven sheets of paper in a continuous process to form a single, double or triple wall board. The corrugated boxes are an essential aspect of everyday life. It provides an easy to use and renewable source of packaging for virtually all products. A corrugated cardboard is one of those things that you see it every day. The corrugated paper board containers are used extensively in the packaging of industrial as well as consumer goods.

The demand for corrugated boxes is encouraging, with proper packing and with growth of industries whose main products are in cosmetics, soaps, automobile components, crockery, glassware, pharmaceuticals and biscuits etc. The business of corrugated box is totally dependent upon the manufacturing segment (all kinds of goods, from foodstuff to refrigerators) of our economy. As the corrugated boxes cannot be shipped long distances economically, hence, box plants are normally placed close to manufacturing sites. It's necessary to have a very good high quality corrugation equipment, to start a corrugated box manufacturing machine. There could be various challenges, once you start a corrugated box manufacturing business, such as planning your production according to your schedule and capacity, managing the wastage, quality assurance for your raw materials and finished goods, on-time dispatch to your customers.

There are various corrugation equipment and systems used in paper industry. Few of them to include are :

- Conveyor Roller and Belt
- Automatic Folder Gluer Machine
- Drum Winding Machine
- Paper Machine Breast Roll
- Roller Pressing Machine

- Wire Rolls Machine
- Felt Rolling Machine

A) Conveyor Roller and Belt

These rollers can be used in pallet handling, gravity roller conveyor, in wash down applications in chemical and food handling industries etc.



B) Automatic Folder Gluer Machines

This type of corrugation equipment in paper industry is suited especially for bulk production. They are very robust and also used for stampings. The specially designed worm mechanism along with conveyor



coating unit of these machines ensures smooth up and down movement. Also provide suspension mechanism.

Features:

- A heating and normalizing unit through fans
- A separate drying unit can be connected to provide more drying time to the product
- Working width of conveyor is 24 inch
- For greater efficiency, a separate drying unit that is 18ft, can be connected with unit
- More beneficial for the clutches, brakes and any type of stamping manufacturers
- Length of the machine is generally 6 meters
- A high production rate in coating on the surface
- A durable and high featured control panel

With easy operation and less experience, it's suitable to paste all kinds of sheets and corrugated cardboard. But, you have to fast enough to change carton height and width. The ideal pasting size would be 260mm. It's a perfect machine for carton factory.

Within 30 years, the corrugated products have been sold to customers in more

Contd. on - 73

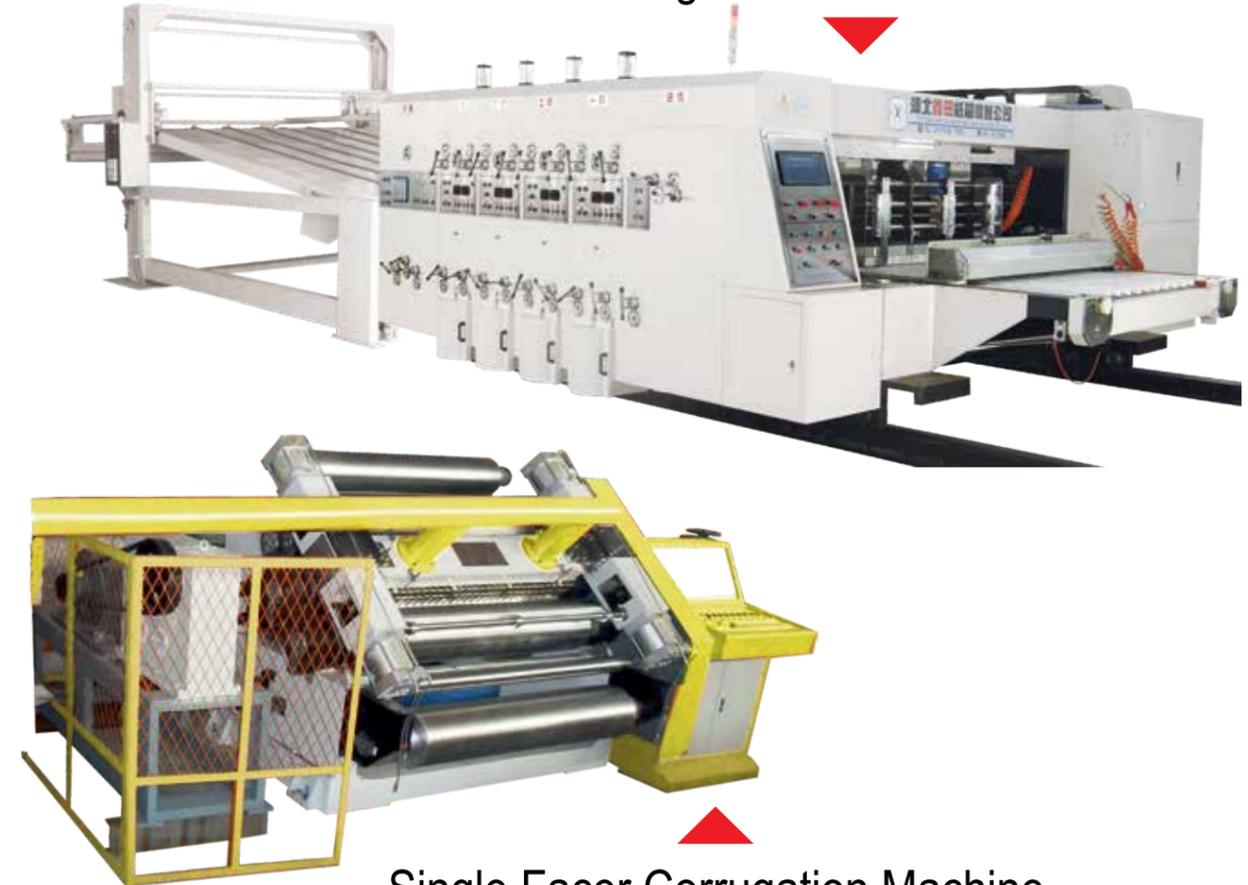


Folder Gluer and Stitcher Machine

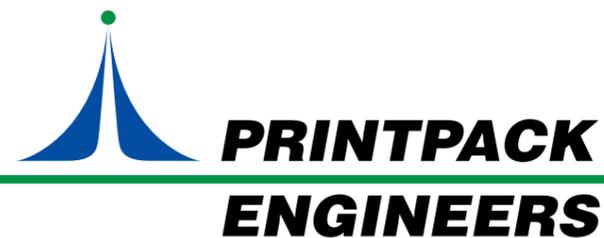


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than 90 countries by Taiwan-based Ming Wei Paperware Machinery Co. Ltd. The company's products mainly include flexo printing machines, conveyor and auxiliary machines, corrugated cardboard making equipment, and in-line printing slotter die cutter machine. The company also specializes in manufacturing and designing turnkey plan on customers.

C) Drum Winding Machine

The winder drums, this type of corrugation equipment, are used in the paper machine re-winder.



Features:

- Can lift up to 15 tonnes
- Have a capacity tuning up to 15m in length and 1.3m in diameter

UK's leading independent roll manufacturer, Cope Engineering (Radcliffe) Limited (CERL) provides bearing assemblies and also rolls pullers, rotary unions, seals and gears can also be provided if required. The company specializes in the manufacture of rollers



for the pulp and paper industry. Apart from this, it also undertakes general machining and precision engineering for a wide range of industries.

D) Paper Machine Breast Roll

Breast rolls, a type of corrugation equipment, are used in the forming section of a paper machine. The features are same as drum winding machine.



E) Roller Pressing Machine

The press rolls are used in a press section of a paper machine. Features are same as drum winding machine and paper machine breast roll.



G) Felt Rolling Machine

Two types of felt rolling machines are used : wet and dry. The wet felt rolls are used in the press section of a paper machine, whereas the dry felt rolls are used in the drying section of a paper machine. Features are same as drum winding machine, paper machine breast roll, roller pressing machine and wire rolls.

Market Insights :

As per TMR analysts, a steady growth rising at a 3.6 % CAGR, is expected to be seen from the global corrugated boxes, during the forecast period, from 2017 to 2022. By the end of the forecast period, the market is anticipated to attain the valuation of US\$ 115.15 bn.

The increasing popularity of online sales has been witnessed as a trend and a key driver by the global packaging industry, for packaging products in the

F) Wire Rolls

The wire rolls are used in the forming section of a paper machine. Features are same as drum winding machine, paper machine breast roll and roller pressing machine.



global market. The popularity and success of online requires safe shipment of products. The e-commerce companies and online retailers will be compelled to implement new packaging techniques and use different types of corrugated boxes.

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FCBM News



Comprehensive Course In Corrugated Packaging 2.0 Hosted by Eicma at the Park, Kolkata

It was with lot of enthusiasm the Comprehensive Course 2.0 kicked off at The Park, on the 21st and 22nd February, 2020. After the success of the course 1.0 it was nice to see almost 100+ members turnout for this event. What was more eye catching was the substantial participation of Gen X and their enthusiasm and hunger for knowledge.



The program as usual was brilliantly conducted by our own professor & stalwart of our industry Shri Ramkumar Sunkara and his equally brilliant team of Shri Amit Jain and Shri Dharmendra Pandya.

With the globalisation and the need to match global standards the MSME sector often lacks the infrastructure for R&D to upgrade their knowledge to stay floated in the current market scenario. The two day



course was the perfect platform to cover this lacunae.

Apart from the course there was ample social mingling and camaraderie on the side lines catching up on industry and social issues and of course backed by sumptuous meals and beverages in between provided by the Park.

The icing on the cake was that Shri Vijay Dewan, President FCBM flying down from Rajasthan to give away certificates to all participants personally. The other major event was hosting of a test at the end of the course and to be noted was four participants scoring full marks and all from the GEN X. So we can be assured the industry would be in the hands of brilliant next generation.

Last but not the least special mention must be made for Shri Rajarshee Datta and his team who was the convenor of the program and for conducting everything to perfection.

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Technical Seminar on the 22nd of January 2020

KACBMA organised their first technical Seminar on the 22nd of January 2020 for the year 2019-20 at The Pride Hotel, Bengaluru.

Topics:

- Fire Protection and Emergency Preparedness Speaker :** Mr. Sachin Suvarna (Trainer from M/s. When It Strikes Crisis Management Pvt. Ltd.) who has given more than 1500 such presentations to many large multinational companies and large corporate clientele in Karnataka agreed to our request and gave a wonderful presentation to our association.
- Compliance :** What it means to our Business (Prepared by Mr. Amit Agarwal and Presented by Mr. Manish Bothra)
- GST :** Change in GST laws (Speaker: Mr. Manohar Shetty)

According to Karnataka Fire Department and NBC law a building more than 500 sq. mtr should have adhere to the compliance.





2nd FCBM Managing Committee Meeting at Indore

The 2nd FCBM Managing Committee Meeting of the year was held on 2nd March 2020 at the Sheraton Grand Palace Hotel, Indore. The sub-committee meetings were held on the previous day i.e. 1st March 2020. The Managing Committee deliberated on various issues concerning the Corrugated Box Manufacturing Industry and planned activities for the ensuing year. The R&D Sub-committee released 2 volumes each comprising a collection of FCBM practical standards and Technical Information booklets respectively.

The meeting ended with a vote of thanks for the hospitality and arrangements of hosts. MPCBMA



Release of Compendium



Prior to the MC Meeting on 3rd March the PMCC Committee, chaired by Shri. Alok Agarwal met with the representatives of Local Paper Mills and Paper Traders. During the meeting quality issues related to kraft paper were discussed and solutions were suggested.

Contd. on - 82

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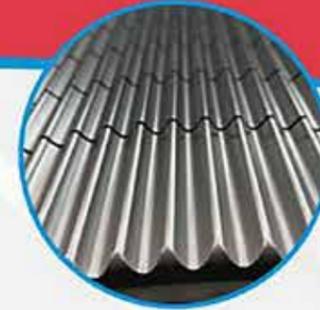
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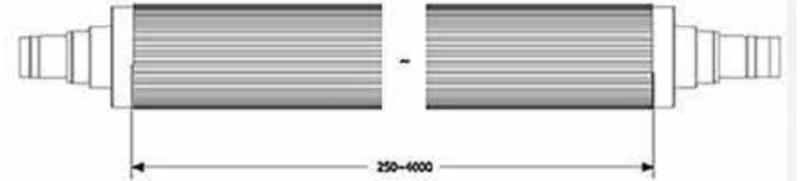
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C	41±3	3.5-4.0 1.44-1.51
CB	45±3	3.0-3.5 1.42-1.49
B	50±4	2.5-3.0 1.36-1.42
BE	66±3	1.9-2.1 1.40-1.41
E	93±6	1.1-2.0 1.29-1.39
F	136±20	0.6-0.9 1.22-1.26
G	185±12	0.5-0.65 1.20-1.25
N	200±15	0.4-0.5 1.15-?
O	267±7	0.25-0.35 1.14-?



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Full Time Comprehensive Course in Corrugated Packaging - Level 2

MPCBMA hosted 2 day Full Time Comprehensive Course in Corrugated Packaging Level 2 at Hotel Sheraton Grand Palace, Indore on 29th Feb -1st March 2020, which was organised by Workshop Sub Committee with the support of FCBM.

The workshop was well attended by 86 Students who represented 65 member units.

Faculty members Shri Dharmendra Pandya alongwith Shri Ram Kumar Sunkara (Chairman, R & D, Workshop Sub Committee) and Shri Amit Jain (Co-Chairman, Workshop Sub Committee) have taught different subjects related to FCT, SCT, CS of the box. In addition to above subjects they have covered subjects like Packaging of Fruits & flowers, International codes etc.

The course was attended by mix of old & young generation entrepreneurs who were excited to attend course at local level.

Shri V. K. Dewan, President, FCBM was present at the valedictory function on 1st March, 2020 and gave Certificate of Participation to all the participants. Shri Milan Dey, Shri Vineet Jain,

Shri Deenu Shetty, Shri Rohit Bubna, Shri K. Arunachallam, Shri S. J. Ajmera also graced the occasion.

MPCBMA is looking forward to organise such type of courses in next few months which helps members to gain immense knowledge.

MPCBMA has got 9 new lifetime members during this workshop and we are looking forward to get 25 new members in next 2-3 months.



Certificate Course

WICMA R & D Centre organized 44th Certificate Course in Corrugated Packaging – Intermediate Level – 2 at WICMA Auditorium, Mumbai from 03.02.2020 to 08.02.2020.

The Course, spread over 6 days covered various subjects such as raw materials, manufacture, quality control, costing, printing innovations, in depth understanding of Compression Strength, among other subjects. Besides, there were practical demonstrations of QC tests & plant visits to Automatic plant and Paper Mill.

29 students attended the course. Students from places like Mumbai, Delhi, Thane, Thrissur, Boisar, Ahmedabad, Noida, Aurangabad, Vapi, Khopoli, Gujrat, Noida, Jalgaon, Ludhiana, Amritsar, Nashik, Belgaum, Jogeshwari, Goregaon, Palghar, Andhra Pradesh, attended the course.

22 students were from outside the Mumbai.

This course was supported by Federation of Corrugated Box Manufacturers Association (FCBM) and Indian Institute of Packaging (I.I.P.) participated as 'knowledge partner'.

The successful students of the course will be awarded the performance certificates.

Two outstanding students i.e. Mr. Sachit Chowdhary from Paper Pac, Ludhiana and Mrs. Surbhi Modi from Packers Products, Delhi will be awarded 'Shri Mansukhbhai Seth – WICMA Education Award' and 'Shri G. B. Chamaria – WICMA Education Award' respectively for outstanding performances.



Practical Course in Testing

The practical testing course held from 9th to 11th January 2020 was attended by 7 participants hailing from Thane, Belgaum, Pune and Virar.



One – Day Technical Seminar at Vasai

The Technical Seminar organized at Vasai on 8th January 2020 was a grand success.

Over 130 corrugated box makers from in and around Vasai participated. 41 New members joined WICMA.

They have been formally made members from 1st April, but they will receive benefits of membership of WICMA right from the day of Seminar itself.

Learned Speakers from across the industry and related organisations spoke on various subjects which were well received by the audience.



Seminars & Workshops

Keeping up with needs and technology.

During the lockdown period. Our Seminars and Workshops Committee, headed by Shri Ramkumar Sunkara and ably supported by Shri Amit Jain, and Shri Surendra Jain, held digital workshops on various problems and issues that a corrugator regularly faces.

The Subjects and the Speakers names are in the Table.

The sessions saw an average number of participants of over 170, with one session touching a peak of 460.

The Federation is grateful to the team and speakers for sparing their time and sharing valuable knowledge.

These sessions were very much sought after and proved immensely popular.

Subject	Speaker
General Q/A	Mr. Amit Jain
RCT	Mr. Amit Jain
Board Printing and Printing Machine	Mr. Sanjay Bothra
Semi-Auto Machine Maintenance	Mr. Sanjay Bothra
RCT	Mr. Amit Jain
Small Automation and Costing	Mr. Amit Jain / Mr. Sanjay Bothra
Property of Liner	Mr. Amit Jain
Inventory Control	Mr. Amit Jain
Open Session Q/A	Mr. Amit Jain / Mr. Sanjay Bothra / Mr. Rajat Gulati / etc.
Heating Arrangement	Mr. Ashu (hot temp)
Roll of Adhesive	Mr. Bhaskar Reddy
Corrugation to Pasting Machine	Mr. Anil Loya
Flexo Printing Stereo Technology	Mr. Deepanshu Goyal
Corrugation Machinery	Mr. Sandeep Nagpal
Pasting Machine Adhesive	Mr. Amit Jain
Quality Testing in Corrugation Unit	Mr. Shahzad Sheikh
Solar Energy	Mr. Pratap Puranik
Quality Parameters of Corrugated Boards and Boxes	Mr. Ram Kumar Sunkara
Heating Required in Semi and Fully Auto	Mr. Ram Kumar Sunkara
Why Fluting Paper Should Be of Different Grade	Mr. Ram Kumar Sunkara
Design Innovative Boxes	Mr. Dharmendra Pandya
Water Based Ink and etc	Mr. Nitin Shroff
Real Bursting Strength of Box	Mr. Ram Kumar Sunkara
How to Improve CS	Mr. Ram Kumar Sunkara



The Spirit of EICMA Lives On...

The nationwide lockdown due to Covid19 infection started with all the ingredients of a novel. It had the suspense, drama and a bit of hilarious exchanges amongst the members. The professional colleagues who normally communicated once in a while became a single family under the WhatsApp group. Members who remained elusive became active.

But on a serious note what bothered everyone was an ambience of uncertainty. It started with everyone's curiosity of how and when can everyone's manufacturing activity start. The eeriness of being locked within walls without social connects added to psychological pressure. Confusing and conflicting versions flying around social media added fuel to the fire. But as days rolled into weeks the reality of the hard truth seeped in. The exchanges between members started becoming serious both on professional and social point of view. The news of increasing infections and deaths due to the virus were definitely disturbing and affected normal thinking.

As weeks rolled EICMA members got to some constructive activity aided by FCBM. There were zoom classes organized by our parent body FCBM on technical matters to taxations and other allied industrial issues post corona. So quite a few evenings the members were kept busy with these activities. The daily bulletins and notifications of both the Central and State governments were shared in the group followed by serious analysis and interpretation of the same. Two Managing Committee Meetings were also held using platform like "Go Meeting" & "Zoom".

There were some lighter and entertaining moments of sharing quiz, music and movie contents. The icing on the cake was the brain child of our President, Shri Mohit Bajaj releasing a motivational musical video **MUSKURAYEGA INDIA** involving the participation of number of members both young & old and all through digital platform. The video was very well appreciated nationally in FCBM fraternity.





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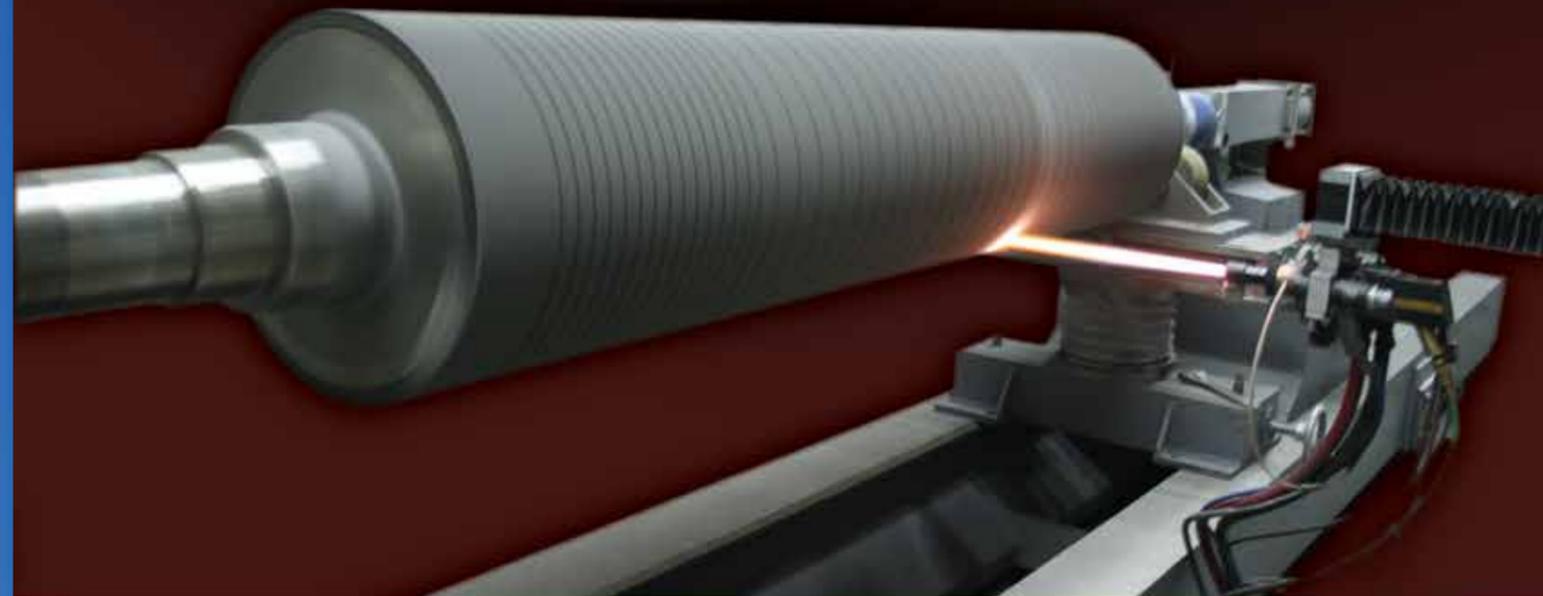
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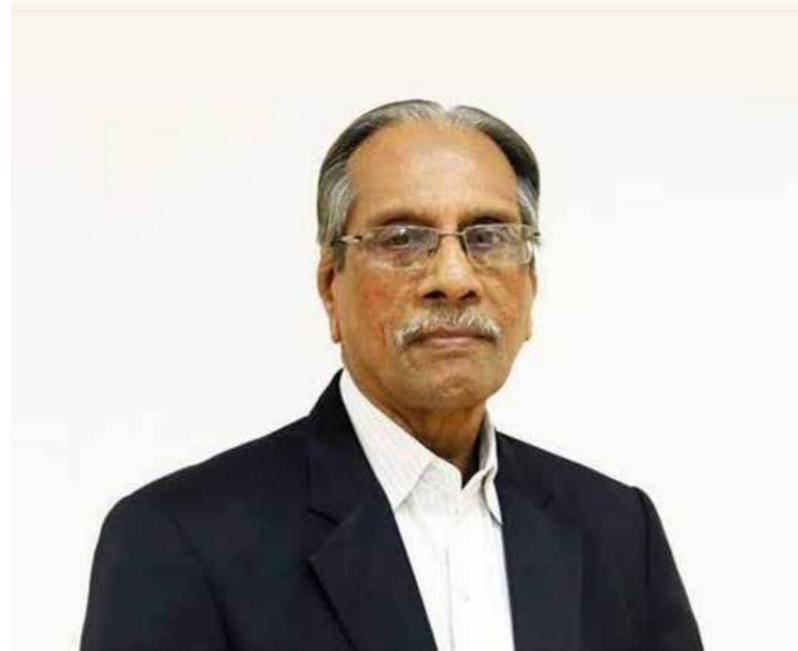
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PV Narayanan - A Pillar of the Packaging Industry is no more.

We regret to inform all members that the doyen of packaging Mr. P. V. Narayanan breathed his last on 28th June 2020.

A highly knowledgeable and respected personality in Packaging, Mr. Narayanan joined IIP in 1967 and went on to become its Director in 1992. After an illustrious period of over 3 decades at IIP, he became one of the founding members of the School of Packaging (SOP) under the flag of SIES (South Indian Education Society).

He was also closely associated with FCBM and WICMA.

Readers may recall that Mr. P. V. Narayanan was the Chief Guest at our 46th FCBM Conference held at Pune.

The industry will forever remember his contribution to the development of Packaging. Our Condolences to the bereaved family.

Narayanan is renowned as a mentor and a visionary who made a vital contribution in transforming the Indian packaging landscape.

He helmed SIES SOP and was instrumental in building it as a robust packaging platform.

Tributes from Veterans in Corrugated Packaging Industry



Mr. B.A. Shab is a pioneer and leader who stands tall as the most respected person of the corrugated packaging industry.

He initiated many new ideas and projects for the benefit of the industry.

The Corrugator was nurtured and groomed by him - which today is regarded as an industry magazine of international level.

Very soft spoken but loud and clear about technicalities and technology of packaging, having in depth knowledge Mr. P.V. Narayanan, Ex Director of Indian Institute of Packaging was an Institution by himself.

I have known PVN since last more than five decades from the time of inception of Indian Institute of Packaging in 1967. I had the privilege and pleasure of appointing PVN as Director of IIP during my tenure as Chairman of the Institute.

His contribution to the development of packaging and Indian Institute of Packaging is enormous and invaluable.

As a Director of IIP he had very cordial relations with members of Governing Body of IIP and always gave very constructive suggestions.

I had the pleasure of interacting with him a lot during his association with IIP and after he retired from IIP.

After his retirement from IIP, PV Narayanan started SIES School of Packaging (SIES SOP) and groomed it as a renowned Institute of Packaging.

He held the top position of Chairman, SIES SOP.

It is very sad that God snatched a very brilliant and humble human being Mr. P.V. Narayanan from us.

Let us pray to Almighty to rest the departed soul in eternal peace.



Mr. P.D. Shab, is regarded as the encyclopedia of the packaging industry.

Known for his in-depth knowledge and Meticulous analysis of problems, he always offered viable solutions.

Mr. Pankaj Shab initiated many ideas like corrugated Packaging Standard, Educational courses etc. to cite of few pioneering projects of WICMA and FCBM.

28 June was a sad day for the global packaging industry as it lost a packaging technocrat – Prof P V Narayanan. He has left a rich legacy in the field of Education and Training. Till last day, he was contributing to his passion as Chairman, SIES School of Packaging & Packaging Technology Centre, Navi Mumbai.

One of them, relating to Corrugated Industry, was compiling and publishing first ever Industry Survey. Our Industry got the first glimpse of the sectoral market dimensions.

There are many ideas, initiatives, memories where PVN's industry friendly support was evident.

In addition to his tireless service to our industry in India, he made a significant contribution in International Packaging Forum. He was Secretary General first and later Vice President, Asian Packaging Federation. On Global platform, he became Vice President/Chairman (Education Committee) – World Packaging Organisation.

One of the most prestigious Packaging Research Organisations globally is IAPRI – International Association of Packaging Research Institutes. IAPRI had organised its first ever Asia conference at Singapore in 2000. Since that time, PVN had been trying to bring IAPRI to hold a conference in India. Some 20 years later, he succeeded. During May 25 – 28, 2021, IAPRI will hold its first conference in India. **Quite an achievement but one which he will not witness!**

Many of his peers and friends in Industry fondly changed his name to say P in PVN stands for **Packaging**. So profound was his in-depth knowledge of packaging industry.

Industry will miss you, PVN. Om Shanti Shanti.

Corrugated Hospital Beds

To meet the Present day needs of Increasing Requirement

Jayna's Corrugated Medical Beds

Mumbai-based Jayna Packaging has introduced a medical bed made from corrugated fibre board to address the shortage of hospital beds.

Haresh Mehta of Jayna Packaging has come up with a recyclable, lightweight and cost-effective solution – a medical bed made of corrugated fiberboard.

According to Mehta, the lightweight bed can withstand up to 300 kgs, and can be assembled easily. The bed can also be sanitised and withstand daily mopping. Also, Studies Show that Covid-19 virus can survive only for 12 hours on paper, whereas up to 72 hours on plastic and metal.



Aryan Paper Group launched a Corrugated Bed

Vapi-based paper mill Aryan Paper Group recently launched a corrugated board-based beds to address the shortage of beds in hospitals. The company said the emergency bed is made from Kraft paper-based corrugated board using high strength paper.



Hospital Bed from Viva Packaging Products

Viva packaging products Ahmedabad innovated Corrugated board hospital bed with all basic features required for hospital bed and unique design of engineering



Dhawan Brothers, Bhiwadi

Vikram Dhawan, who along with his brother came up with the design while they were stuck at home during the country's months-long lockdown.

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Corrugated Box Making Industry Lockdown Scenario - Anant Sarma

We have, as expected, entered the second phase of lockdown. Several carton making facilities are working since the last two weeks or more, and that bodes well because, even during shutdown, there is demand for cartons and they have been declared essential commodities atleast to the extent they are producing cartons for packing of essential items, including food and health care products.

To the extent the industry supplies packaging for essential commodities, I believe the temporary stoppage is over though I know that none of these factories will, for several months, and atleast the third quarter of our current financial year, be stretched.

However, I do foresee a continuing demand in India for carton, though like all industries, excepting perhaps food and health care, there will be a demand shrink. This is because the world economy is likely to shrink, according to UNCTAD, by 6% whereas the Indian economy is projected to grow at 2.1%, the Brazilian economy by 2.3% and the Chinese economy by 1% - of course far less than what we are used to.

The growth in Indian economy has to come, during the current FY, basically from essential consumption goods including food related, medicines, medical equipment both of the investment variety as well as the consumables variety such as PPEs and other health care products. Of course, automotive, aerospace, transport (other than goods transport), petroleum, hospitality, travel and other sectors will shrink, which means the remaining sectors will grow more than 2% yoy to achieve the projected Indian growth of 2.1% While I mention this I cannot but share the thoughts expressed by an America based Indian economist. He predicted that the automobile sector in the US will take off well because many people may want to avoid public transport as a way of social distancing. This will be good for our automotive component sector – but I do not see either similar though and buying processes in automobiles happening for Indian domestic consumption, nor I see a substantial growth in Indian auto component export because,

unless one is already an existing vendor, development of new vendor as OEM takes upward of 18 months. Therefore, the Chinese component vendors will gain in case American auto industry revives fast, not the Indian. I know this personally because until recently I was also connected with development of Indian sources for auto components for the US market.

I have been reading as well as listening to a lot of talk on the way forward for the economy in India in the immediate term, short term and medium term. I have also been thinking about the consequent impact on our industry. I will send my thoughts on this to you shortly.

But, in the meantime, I would like to ask all of you to increase your preventive maintenance of equipment, and ensure that breakdowns are avoided, or atleast predicted in advance, because, in the immediate term, non-essential courier deliveries are likely to remain locked out, and it will be difficult to obtain spares not only from outside India, but even within India. And, obviously, even repair specialists cannot travel within India. Caution should be the mantra. You will not want to miss on any supplies due to breakdown, because most of your customers have multiple vendors, and, in the immediate and short terms, all of us will use our capacities only partially.

I also suspect that there will be some shortage of labour, mainly because migrant labour might have left. And whatever remains will be in demand especially since agriculture harvesting season is on. Of course packaging industry will not have demand for 24 x 7 operation atleast in the immediate and short term; but there will still be demand for casual labour, and this may be time to rationalise use of manpower and get into the habit of working with less manpower per ton of board produced. Optimising the use of available limited manpower will give an opportunity to tighten the belts, and moving forward, one should keep the belt tightened. Irrespective of whether they are labour on the rolls or contract labour.

Corona virus in India would not have been eliminated from India by the end of the month when the lifting on lockdown may start in stages. In fact I feel that it will be almost the end of the year before we breathe a sigh of relief on the health front. My suggestion to all factory management is to ensure that everyone – including the owners – are thermal scanned before being allowed into the plant and also before exiting the plant. The reason for thermal imaging before exiting the plant is to make sure that the person going out of the plant is also within the permissible body temperature range even when he leaves. If he is not, then an alarm should ring. It may then be good to have him sent for further tests immediately, and the vigil doubled during the next shift.

I request each one of you to pay special attention to this because even if one of your employee gets the virus, your factory will be asked to be locked down. I am sure you do not want this, and you should take preemptive steps. In addition to the factory getting into the Government's notice, your customers may boycott in case your factory is quarantined. Social distancing, of course, is recommended but in our industry – and especially in maintenance or even in manufacturing – it may not be possible to avoid a minimum group of 2. Please make sure that they wear PPE.

All surroundings in and around the plant should be kept very clean; I will particularly sensitise and sanitise the workers' washrooms, because, in developing world, including India, much is to be desired in sanitation. Spending money on having a person 24 x 7 (one person per shift) to keep this area clean – as is done in airports etc. – will not be stretching too far because, on a back of the envelop calculation, assuming this to be a contract employee, the wage will not go by more than 2% of the total wage bill – well worth spending. Once all of us get into this habit, going forward, we may thank the virus for having upgraded our factory environment.

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- 3) No Training Required
- 4) One minute quick order change
- 5) Single/ Double and Tie nail stitching (|||||, || || || ||, || || || ||)
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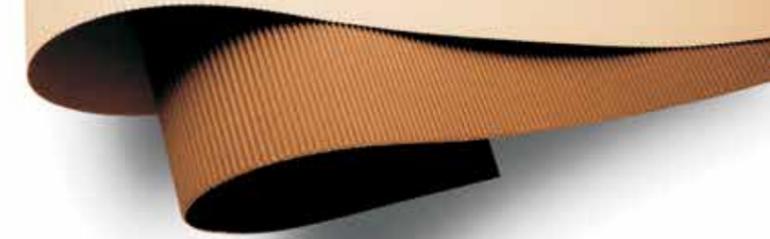
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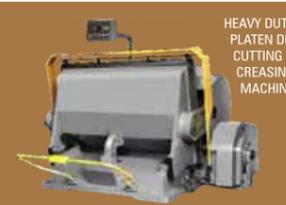
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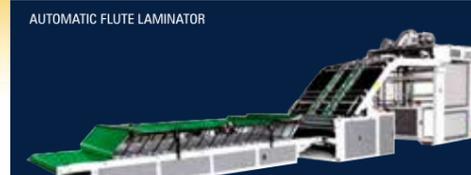


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Industry News

Design Guidance for the Recyclability of Paper-Based Packaging

A few weeks ago, Dennis Colley, FBA's President and CEO, attended a recycling conference where a Senior Packaging Engineer at a major brand asked if a package for one of their new products was recyclable. Her intent was to specify a box that was fully recyclable, but she wasn't sure if the non-fiber components of the box would create any issues for paper mills. Her question is one that the industry hears often and one that is currently being addressed.

Fibre Box Association has joined a collaborative group of industry leaders across the supply chain who are working closely with the American Forest & Paper Association to develop a design guidance for recyclability of paper-based packaging. The technical guidance will indicate the ease with which non-fiber elements used in paper-based packaging can be recycled. These non-fiber elements include items such as coatings, inks, adhesives, tapes, labels, applied and additive barriers/laminates (e.g., poly, poly-foil, clay coatings, varnishes, wax, wet strength, etc.), enhancements (e.g., foil stamping, window elements, susceptors, tear strips, etc.) and plastics. Four categories will be used to rate the acceptance of these materials into the recycling stream: (1) easily recycled; (2) affects recyclability, but acceptable; (3) recyclable under varying conditions; (4) not recyclable.

The work follows similar activity conducted in Europe last fall. In November, The Confederation of European Paper Industries (CEPI) published Paper-Based Packaging Recyclability Guidelines. The Guidelines are intended to help brand-owners, retailers and others "specify and design paper-based packaging in a way

to ensure high quality recycling by the paper industry." To learn more about the CEPI guidelines, visit: http://www.cepi.org/recyclability_guidelines.

A survey of U.S. paper and paperboard mills is currently underway to collect data about the recyclability of the non-fiber elements noted earlier and the results of the study should be completed by the end of the second quarter 2020. If any of these elements are found to be in categories 3 or 4, then the next question becomes: can they be composted rather than landfilled? FBA will keep you updated as the project progresses.

www.fiberbox.org

Corrugated Packaging Industry Promotion Program Gets a New Look

"Boxes. The Most Extraordinary Ordinary Thing in the World."



The corrugated packaging industry today unveils a new look and feel for its promotion program, updated to reflect evolving market trends like e-commerce, printing technology advancements, and shifting dynamics in recycling and sustainability. The promotion program began in 2017 to raise awareness and elevate appreciation for the ubiquitous, humble corrugated cardboard box and its role in everyday life.

"The rise of e-commerce has created greater consumer awareness of packaging,"

said Rachel Kenyon, vice president of the Fibre Box Association (FBA). "Many of the packages that used to be shipped to stores are now arriving on consumer doorsteps and we believe it's the right time to be reminding people about the extraordinary benefits of corrugated cardboard boxes."

The ability of a box to withstand the rigors of transport through an increasingly complex supply chain is crucial for protecting the product inside – and supporting the brand behind it. This means it has to arrive in pristine condition and graphics on the box need to provide a mobile billboard for the brand. In addition, it is more important than ever for consumers to understand corrugated packaging's environmental impact and the importance of why and how to recycle the box after use.

"Corrugated cardboard boxes have been around for more than a century – but advances in technology, from papermaking and printing techniques to sustainable manufacturing and recovery processes have been taking place behind the scenes the whole time," said Kenyon. "It's important that we share our progress with box users and consumers, so they can feel good about choosing, receiving, using and recycling corrugated cardboard packaging."

The program update rolls out a new industry tagline, "Boxes. The Most Extraordinary Ordinary Thing in the World." It highlights benefits and attributes of corrugated cardboard boxes, including their merchandising value, their versatility as a transport container – particularly in the new age of e-commerce, and their sustainability.

New ads launch on October 1, 2019 in trade media that serves key box-buying markets, a new website landing page at <http://www.boxesareextraordinary.com>, a brand

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The program is funded by FBA's member companies, who manufacture corrugated packaging products throughout North America, and industry suppliers. "At a time when supply chains are flexing and adapting to meet the needs of new market trends, we are thrilled to introduce these new materials now," said Kenyon.

www.corrugated.org

Brands face losing customers over excess packaging warns Mondy

New research from paper packaging giant Mondy warns that brands face losing customers over excess packaging.

According to Mondy's online survey of over 2,000 people aged 16-75 across the UK conducted by Ipsos MORI, the majority of British consumers say they would switch to a different brand if it uses less packaging

say they would switch to a different brand because it uses less packaging, in comparison to only 5/10 consumers in London (54%), Scotland (53%) and Wales (47%)

- Women are leading in the drive to switch: 61% of British women would switch brands for one with less packaging when shopping for food and everyday household items, with 54% of men saying the same.
- Xennials are more likely to switch brand for less packaging than Baby Boomers and Gen X: Just under two thirds (65%) of 35-44 year olds, the generation known as Xennials, say they would switch to a different brand because it uses less packaging. In comparison, only 54% of ten Generation Xers, aged between 45 and 54, and Baby Boomers (52%), aged between 55 and 75, say the same

Sara Sizer, group communication and marketing director at Mondy, said: "It



than other do. Southerners outside of London are the most likely to make the switch, with Londoners, Scots and the Welsh trailing behind.

The main results show:

- Brands face losing customers over excessive packaging: 58% of British consumers say that when shopping for food and everyday household items, they would switch to a different brand because it uses less packaging
- Southerners come out on top: 62% of southerners outside of London

is encouraging to see that consumers are willing to make different choices to accommodate more sustainable packaging. For brands, the survey results highlight the importance of incorporating sustainability in their packaging development and production.

"Mondy works with its customers to create EcoSolutions – an approach that creates bespoke packaging solutions that will ensure businesses can protect the product, promote the brand and deliver on their sustainable packaging commitments."

www.packagingnews.co.uk

8 Industries Where Corrugated Boxes are Used as Packaging Material

Corrugated boxes are renowned for their structural rigidity as well as the cushioning they offer, making them ideal for packaging fragile articles. Corrugated packaging offers unmatched advantages when compared to other types of packaging as you can have custom corrugated boxes made according to your personal business needs.

Corrugated boxes are the most suited for packing a wide variety of products regardless of their size and shape. They are versatile enough to transport and cushion perishable and fragile products. Corrugated boxes are made of kraft paper and can be re-used, re-pulped and remade into recyclable attributes which contribute to environmental protection.

1. Food

A research conducted by The University of Bologna discovered that corrugated packaging supports food safety and prevent bacterial infections. The research further discovered that corrugated containers were most effective at keeping fruits and vegetables fresher for longer. Other than the freshness factor, corrugated containers were also found to be able to prevent the spread of bacteria which get trapped in the fibers of the corrugated containers.

2. Office Supply/Stationery

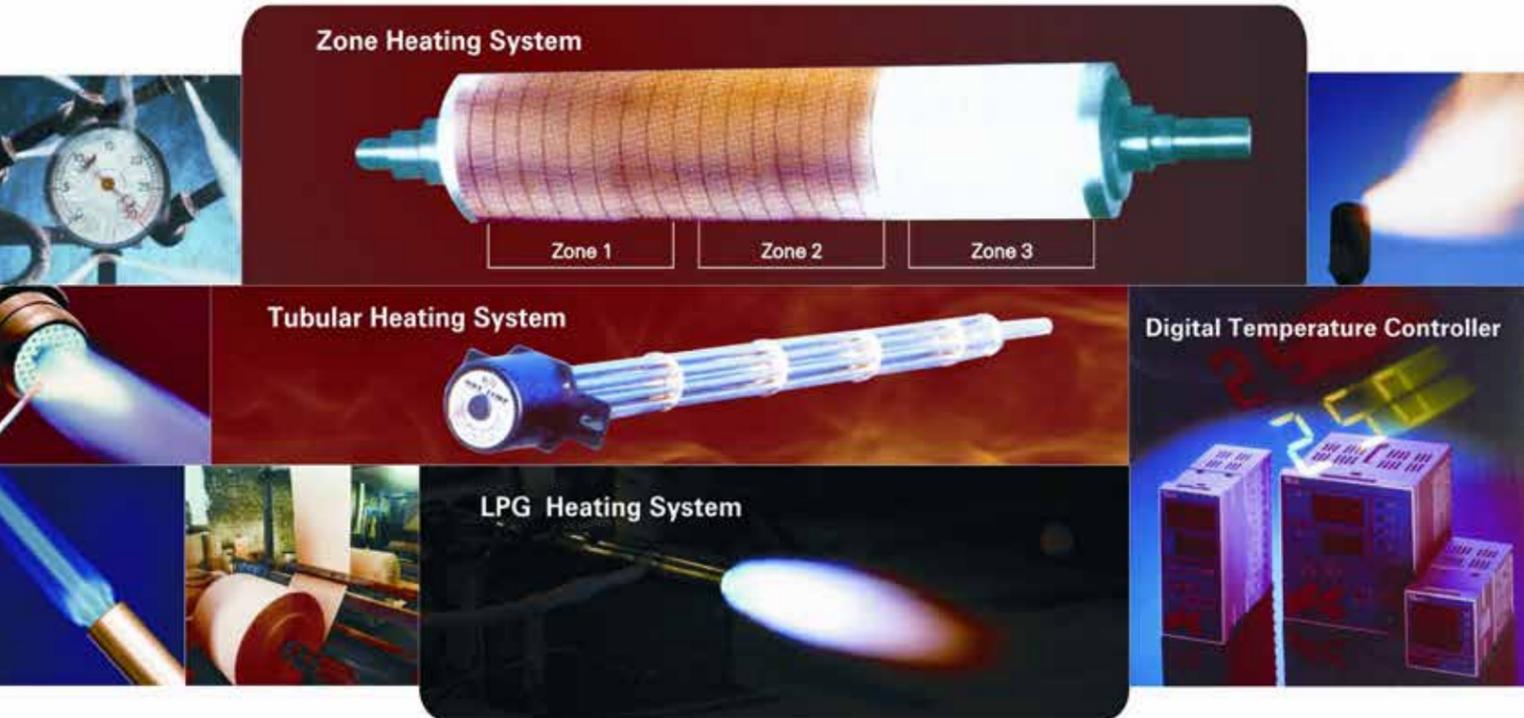
Corrugated boxes are used to package office supplies and stationery. You can simply pack all kinds of office supplies in corrugated boxes without any fear of them getting damaged.

3. Industrial Supply and Logistics

Corrugated packaging is said to be one of the best things to have happened to the packaging industry due to various advantages of corrugated boxes. They can be used to transport industrial products with ease due to the fact that all you have to do is pack your products into corrugated boxes which are easily available on the market.

Contd. on - 109

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GUM POWDER PLANT FOR PASTING & DEXTRINE

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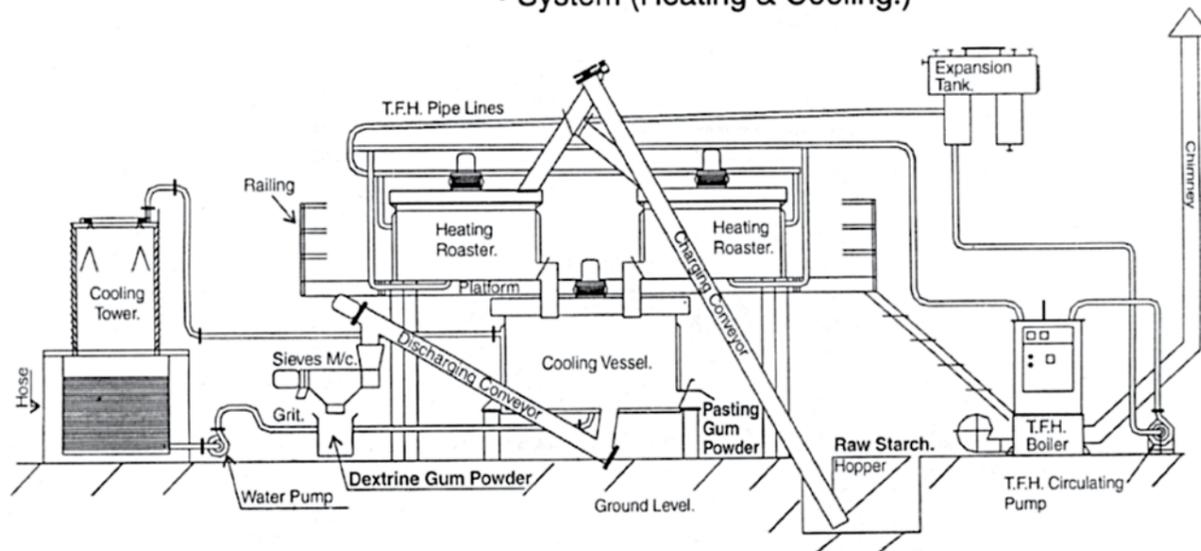
Feature:

- Increases Production Capacity.
- Decreases Fuel Consumption.
- High Mixing & Roasting Capacity.
- No Explosion Hazards.
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- low labour Cost.
- Fast & Easy
- Charging & Bag
- Filling System
- Immediate Transferring
- System (Heating & Cooling.)

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- Liquid Gum mfg. Plant
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- Synthetic Resin Plants.
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- To Cook Gum / starch

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- Produces best quality products.

- Reduces consumption of gum.

- No pollution.

- Low wastage of Raw Material and product.

- Reduces cost of Inventories.

- Minimize the cost of production.

FEATURES : - Compact Unit.

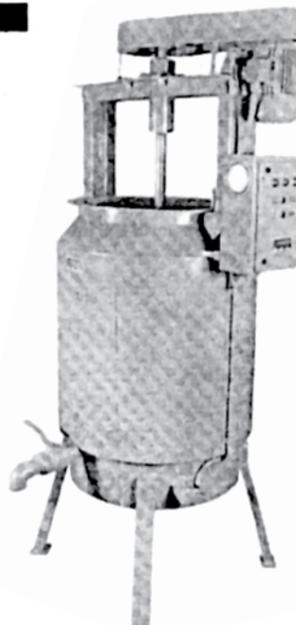
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4. Textiles

Corrugated boxes are available in different sizes and designs and are ideal for transporting all kinds of products- even textiles.

5. Electronic Products

Electronic items are usually quite fragile which makes it all the more important for them to be packaged in a way that will protect them against any shocks that they're bound to experience while in transit. Delicate electronic devices should all be packed in boxes that are of superlative quality.

6. E-commerce

Presentation is of utmost importance in the e-commerce industry. Corrugates boxes used in the e-commerce industry can be customized with unique design, style and brand quirkiness which will help you increase and improve your marketing and branding through your packaging.

7. Healthcare

Packaging medication in corrugated boxes is a good way to ensure that your medicines reach its destination safely and at the right temperature which the box can naturally maintain. When it comes to transporting lots of tiny and valuable goods from one place to another then the corrugated boxes are the best option. These boxes can help you in transporting multiple goods at a single time without damaging the contents of the box.

8. Relocation

If you are moving and are thinking of hiring a movers and packers company to help you then it is best that you ensure that they use corrugated boxes for shifting your belongings. The best thing about using corrugated boxes is that they do not break under the weight ensuring that your belongings remain undamaged, thus making your shifting process much faster.

www.packingsupply.in

L-PACK Eyes Expansion -

Adds EMBA 215QS Ultima

L-PACK, one of Russia's largest paper and corrugated producers based in the Lipetsk region, is continuing active modernisation of its capabilities, by installing new equipment and upgrades to existing machines.



Russian paper and packaging group accelerates investment plans, including a new EMBA 215QS Ultima

As part of this expansion plan, the company successfully completed installation of a new EMBA 215QS Ultima at the end of last year. Interestingly, the company has already set a new record for the production of boxes on the new machine; some 278,385 units were produced within a 12-hour shift, with 11 order changes.

The newly commissioned 215QS Ultima is the second such machine at the plant, joining a similar model that was installed at the plant several years ago. The Swedish OEM launched the 215QS Ultima in 2017 and the flexo folder gluer has a maximum speed of 33,000 boxes per hour (550 per minute). During our interview, L-Pack described the newly commissioned Emba 215QS Ultima as one of the most advanced and fastest 2.0m format machines in the industry. Its maximum format is 750 x 2150mm and it can be equipped with up to six printing units.



Left to right: Sergey Romanov (Deputy Director General for Development), Andrei Frolov (Production Manager), Maxim Markov (4th grade master controller) and Alexei Meshcherin (Converting Department Manager).

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2	Cotton Industries
3	Spinning Mill

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The new technology involves innumerable number of innovative techniques to improve the die quality. Immaculate computer aided designing, precision laser cutting, optimum knife joints, perfect rule fit in the Die board, perfect ejection rubber are just a few quality features to mention.

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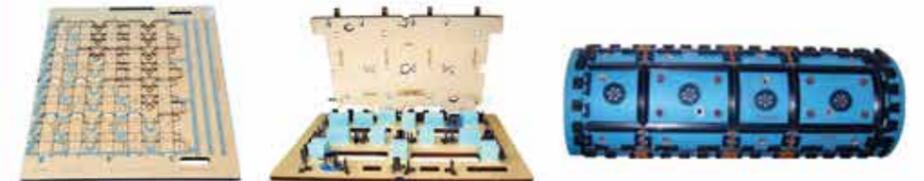
Rotary plywood shells, flat plywood, cutting & creasing steel rules, ejection rubber, special-steel counter plates, embossing Die plates and other accessories are imported from Europe.

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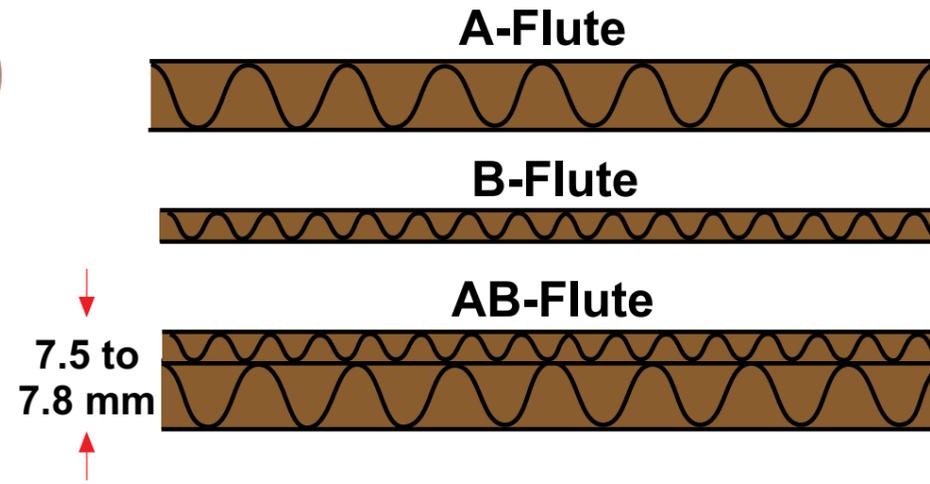
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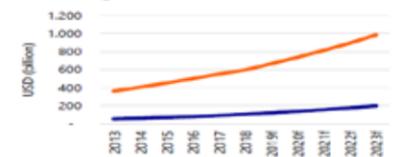
Product Profile

High- Speed Corrugator

As a member of the BRICS, the booming economy of India leads to its thriving in retail and e-commerce business. Store retailing will grow at a 10.5% CAGR, to reach USD 984bn by 2023, which further leads to the corrugated packaging consumption to rise to a historical new level. As the graph shows, containerboard capacity has grown at a 3.5% CAGR over last decade.

Currently, India is ranked 15th country for its paper and paperboard production in the world and converts 2 million tons

Figure 1: Indian packaged food & beverage and store-retailing market size trends, 2013-2023f



Source: Euromonitor, Rabobank 2019

Figure 4: Imports of virgin and recycled containerboard in India, 2014-2019



Source: Government of India, Rabobank 2019

kraft paper into corrugated boxes per year. However, imports will continue to support domestic corrugated paper packaging requirements, especially in virgin containerboard. The Indian production capability and usage per capital of corrugated boxes is below the world level, showing a wide scope for the market.

More and more in-line automatic plants set up to meet the demand of improving large-scale integrated production capacities and product quality. Even though, according to the survey, Indian corrugators are not highly automatic and the designed

speed is between 50mpm -250 mpm, so the capabilities of manufacturers in this market also differs.

Now there are around 250-270 Automatic plants in India and India is seeing another renaissance in Corrugated world where Indian industry is changing from basic automatic corrugator to High Automatic Corrugators having speeds of 150-300 mtr/min.



The Pro/Line is supplied in three working widths of 2.2m, 2.5m and 2.8m. The models are configured to operate at either 250 mpm or 300 mpm.

As a specialist of high-speed corrugator, Fosber has reduced the center of gravity and mechanical vibration during high-speed operation through optimizing mechanical structure design which will not generate machine resonance in the design speed.

What's more, all the high speed rotary components strictly abide to the ISO 1940-1 standard.



Besides, the Corrugator Line has the ability change orders under high- speed operation by applying the American Rockwell electrical control system and Fosber's independently developed Syncro Production Management system. The power source and transmission parts are designed to have high safety factor and strong load capacity, which can realize short-term acceleration and deceleration.

These systematic, mechanical, and electrical design factors cooperate tacitly to bring Pro/Line with high speed and high performance.

Fosber, as a specialist of high-speed corrugator, fully understands market demands and always delivers the up-to-date technology to guarantee its customers with high performance, improved productivity, dramatically reduced complexity, and enhanced reliability.

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Geo. Martin offers SBX stacker

The SBX operates seamlessly, reportedly at two to three times greater speed than the majority of conventional stackers. This is particularly important when running up to 4-out, non-nicked multiple outs, because these can actually be separated on the deck without the need, on many items, for a separate bundle breaker function down the line.

Set-up from one job to the next can be done in eight to 12 minutes. The automatic recall of all settings from an earlier job of almost every function substantially reduces set-up time. This includes the SBX's ability to auto-adjust between varying board calipers. "So a job change can go from doublewall to E-flute based on a single command from the control console.

A key factor is the SBX utilises Scrubber® technology for the near complete elimination of scrap. This reduces labour because scrap seldom needs to be manually removed before having a stack head out for the customer.

At all times sheet control and positive handling is possible, because jams and

stops are all but eliminated, the SBX enables to produce much more square footage in less time.

In addition, as part of the SBX Scrubber configuration. Martin's new SQC (Sheet Quality Control) diverter module. The diverter makes pulling a sample much simpler and safer. At any time, even during full speed operation, the push of a button ejects a sample for inspection.

"Innovation leads us," he continues. "From a production standpoint one of the most attractive features of this particular diverter is that it can be pre-set to output a sample at specific intervals, say every 100



sheets, 1000 sheets or whatever is needed to assure the quality. It's also very useful at the start of a new run because the SQC can be set to divert the first sheet up to any number required to pull out those initially over or under inked.

"The SBX in combination with the SQC allows for the highest levels of production speeds without compromising quality or safety and that's an excellent combination.

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- Simple, quick and accurate job repetitions
- Excellent price/performance ratio

A long-term asset

- Robust, reliable machine, built to last
- Access to BOBST tooling solutions, service and spare parts network

Benefits and features

FEEDER

- Pull or push sheet registration system, allowing precise sheet register
- Feed table plate reduces static and delivers smoother sheet travel
- Optional non-stop feeder optimizes the machine's net output
- Lateral ramps, designed for smooth sheet introduction and consistent feeding

Advanced HMI SPHERE

- Large 22" full color Human Machine Interface (HMI)
- Simple step-by-step procedure guides the operator through the job set-up process
- All settings appear on one screen for more convenient and intuitive navigation

AUTOPLATEN®

- Smoothest sheets acceleration drastically limiting number and size of nicks
- Automatic equipment centering, locking for chase and supporting plate, ensuring perfect quality achievement of cutting and creasing
- Motorized cutting force adjustment on demand

Perfect In-Line Stripping

- Even delicate or light materials are stripped perfectly at high speed
- Integrated quick-lock system ensuring



fast and easy job changeovers

- Fine adjustment of tooling for precise stripping quality
- Motorized lifting of the upper frame

CENTERLINE® System

- Quick and easy fitting of dedicated tools into the machine allowing simple, quick and accurate job repetitions
- Radically reduces job preparation, changeover and repeat times
- Quick-lock die-cutting chase for quick and easy setting

Perfect Piling and Stacking Delivery

- Optional automatic non-stop delivery for continuous production
- Perfect stacking of all types and sizes of materials
- Blower sheet hold-down device controlled by the HMI, ensuring an ideal shape of the pile

www.bobst.com



Stora Enso targets foodservice with new barrier boards

Stora Enso is launching barrier boards that it claims will replace plastic in food packaging.

Aqua and Aqua+ are said to be fluorochemical-free and used to produce paperboard for cups and foodservice packaging without a plastic layer.

The paper manufacturer added that Aqua is grease resistant while Aqua+ is both liquid and grease resistant.



“The new barriers are aimed at retailers and brand owners who want to improve recyclability of their food packaging to meet eco-conscious consumers’ demands. The materials are suitable for paper cups, ice cream packaging and fast, frozen and dry food packaging”, said Ebba Mannheimer, head of business, new barrier solutions, division packaging materials at Stora Enso.

The company said that the surface of the Aqua products is finished with “water-based dispersion technology, enabling the board to be liquid and grease resistant while breaking down in a recycling process like paper”.

In addition, Stora Enso said that it offers two different baseboards with the dispersion barrier: CKB Nude Aqua is a

natural brown kraft board for short-contact food packaging applications, including fast food and dry food; and Cupforma Natura Aqua+, a material for paper cups, available with a dispersion barrier on one side for hot drinks or on two sides for cold drinks and ice cream packaging. Stora Enso added that the materials can be printed and converted on existing machine lines.

www.packagingnews.co.uk

Certified for food packaging

Stay on top of the latest and greatest Cito Ultimate creasing system

Cito’s high-performance creasing system, ‘Ultimate’, is now available with certification that shows it is safe for the manufacture of food packaging

“We are aware of our responsibility for human health, safe and reliable production processes and sustainable products,” explains Jürgen Mariën, Managing Director. “With our certified materials, we offer packaging manufacturers quality products, which they can use safely for the production of food packaging.”

During the manufacture of the packaging, particles of material that come into contact with it are abraded and deposited on or in the packaging material. This also applies to

the creasing matrix, which is placed on the cutting plate and comes into direct contact with the packaging material during the cutting and creasing process. ‘Ultimate’ can therefore be used with a clear conscience for the production of food packaging.

The certified creasing systems combine production safety with product safety, meaning it is safe to use for the manufacture of folding cartons for foods. It also conforms to the EU Directive for food contact materials (EC No. 1935/2004 Art. 3 and 17).

Besides its ISEGA certification, ‘Ultimate’ also offers the following features:

- Flexible coating on a sturdy base for consistently high crease quality, from the first to the last sheet, even for large runs;
- All versions with SG technology;
- Reduces cracking of the crease;
- Ideal for repeat jobs or for archiving in combination with cutting plates
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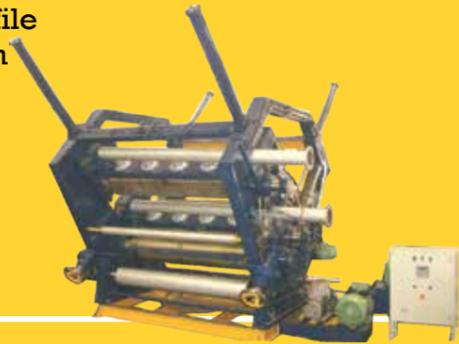
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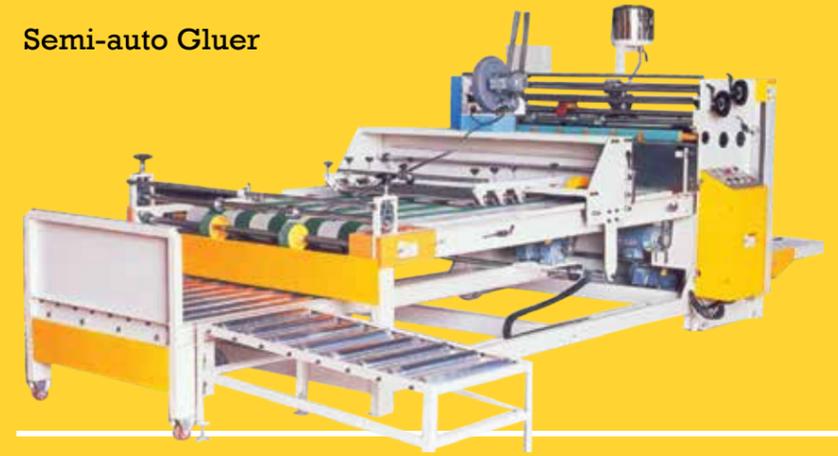
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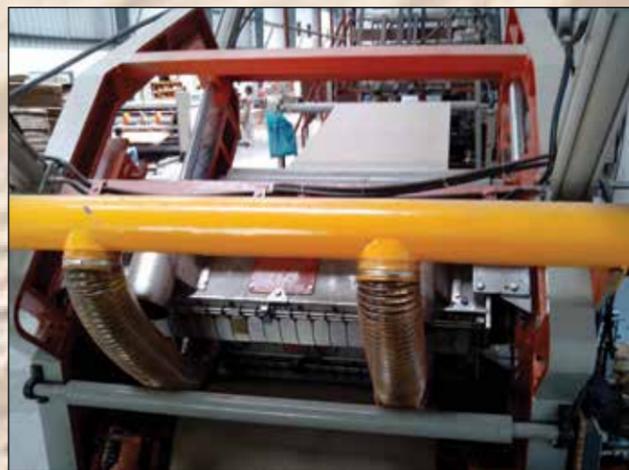
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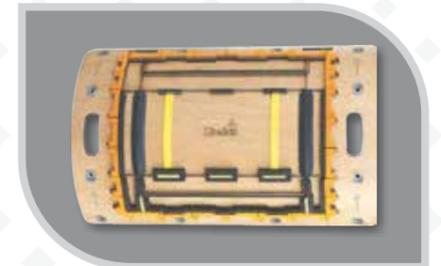
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