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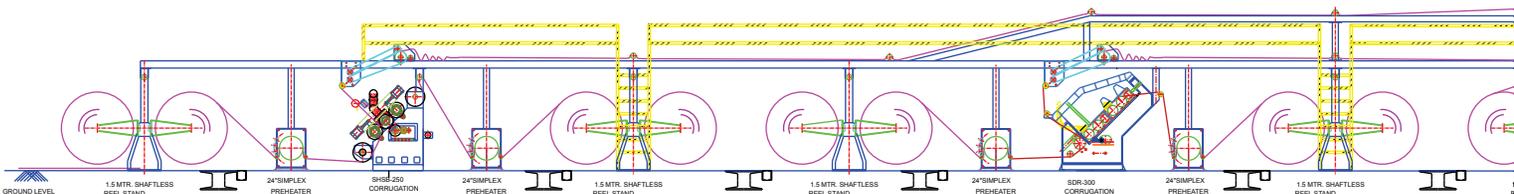
The Corrugator

OFFICIAL MAGAZINE OF FEDERATION OF CORRUGATED BOX MANUFACTURERS OF INDIA

January - March 2017



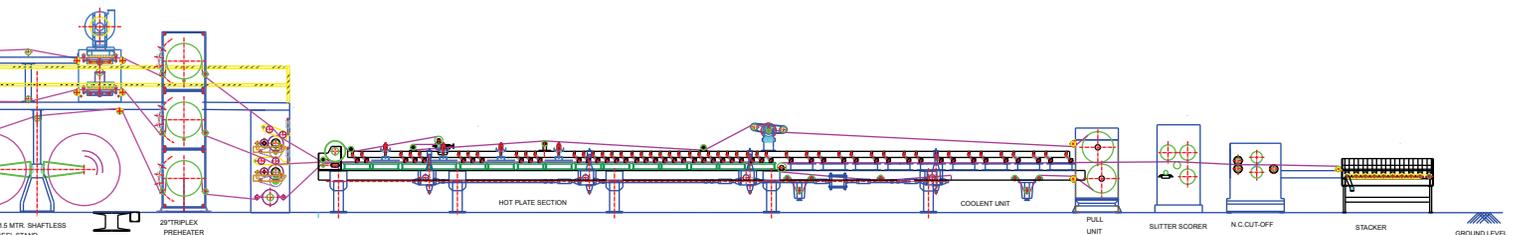
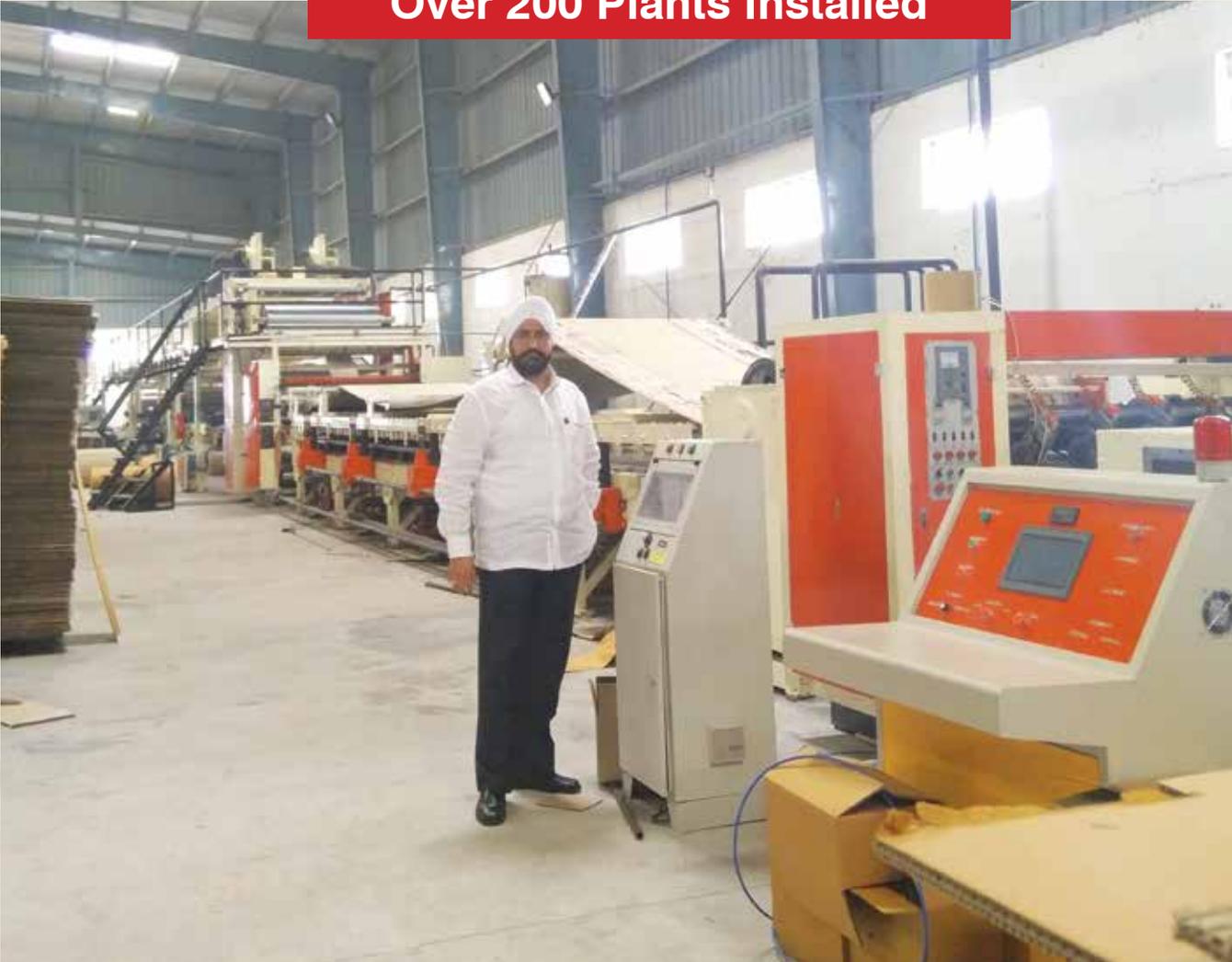
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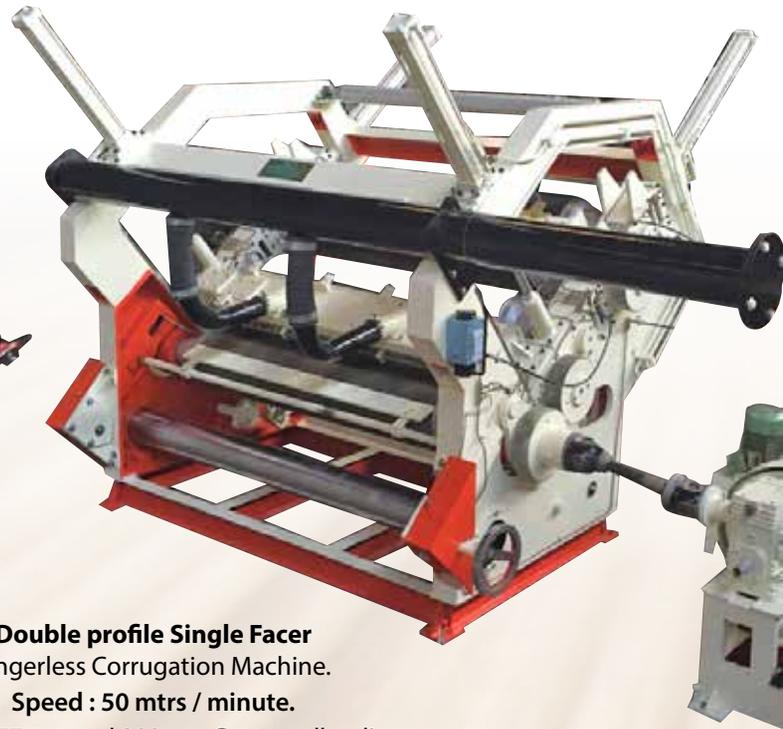
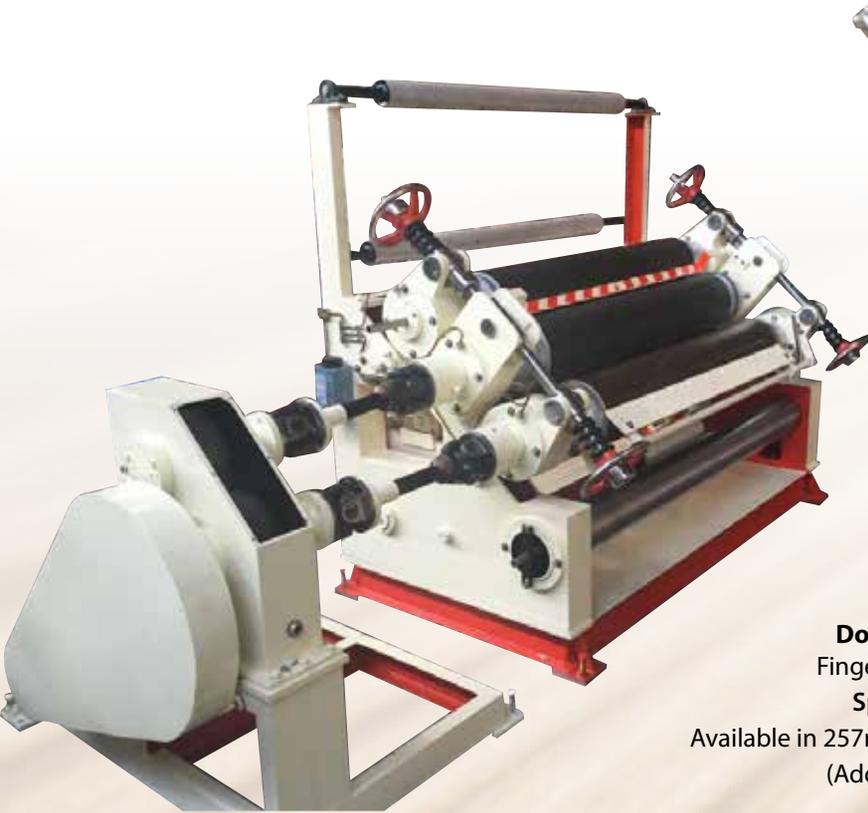
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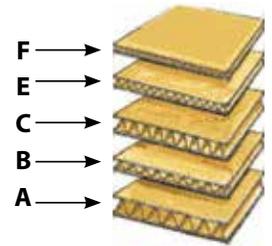
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The Corrugator

OFFICIAL MAGAZINE OF FEDERATION OF CORRUGATED BOX MANUFACTURERS OF INDIA

January - March 2016



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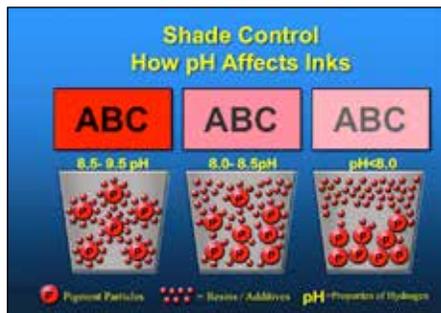
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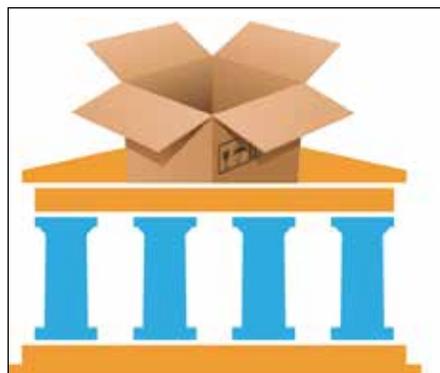
Content Highlights



17 - Understanding Inks Made Easy !!



23 -Tech Tip, Bobst Corrugated Diecutting: Cutting on the Print Side vs. Inside



25 - The Four Pillars of Packaging



31 - The Starch Preparation Center



39 - FCBM News



55 - Preventive Maintenance



67 - Dieboard Storage



75 - The Importance of Aerators

95 - Product Profile / 105 - Industry News

116 - Events



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THE EDITORS' PAGE

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Dharmendra Pandya

Susbil Sood

The first quarter of the New year has begun rather lamely – with no significant impact of the much hyped Union Budget.

The impact of demonetisation seems to have worn off with pharmaceutical retail growth bouncing back during January to double-digits at over 10%.

Despite slowdown in` economy, the trending companies like Flipkart, Facebook, Amzon and Twitter are zooming ahead!

Fuelled by increased consumer buying in smaller towns, jobs in FMCG, consumer durables, construction and real estate are witnessing growth.

With businesses scaling up and corporate reorganisations, demand for business development roles surged.

There are clear signals of FMCG/consumer durables companies recovering from the aftermath of demonetisation.

So, the 'New Normal' for India's GDP growth will be 6-7%. The government claimed 7% growth in GDP in Oct. – Dec. 2016. And the pace is estimated to continue.

If global headwinds end, India can accelerate. But as long as the headwinds blow, India's new normal will be 6-7%

growth. This could still be the fastest among major economies.

There is enormous technology talent in India and its contribution have been building software applications for global corporations, India's next path should therefore be to make the world cognitive. "Cognitive is India's future".

And the future is **Internet of Things** (IoT)– the concept of basically connecting all devices we use in our living and work to the internet.

Once this takes shape the way we do our businesses, the way we run our factories... and the way we make our Boxes will change!!

The new rule for the future will be **'Anything that can be connected will be connected'**.

Our Federation has been vibrant and active during this quarter with many regional associations reporting events of importance.

All the events are featured in this issue. We are sure the momentum of activities will continue through the year.

This issue also features a very interesting article on 'Starch Preparation' – which highlights tips for successful adhesive

preparation. We hope the readers will be 'glued' to the article.

And the 'Four Pillars of Packaging' focuses on Quality, Work Culture, Customer Service and Innovation. All these are significant factors that will spin the sustenance and growth of the Packaging Industry.

Cutting of Corrugated Board on Print Side vs Inside gives the readers useful tips on Die Cutting. Dieboard Storage is a very interesting article which elaborately describes the way Dieboards should be stored. Combined with other highly interesting articles this issue will surely will enlighten the readers.

Two global exhibitions on Corrugated will open this April – both in Shanghai – the traditional Sino Corrugated and the new I Corrugated. It will be interesting to see how these shows scheduled so close to each other will fare. For visitors, of course it will be a double benefit as they can visit both and witness large number of developments.

The new Editorial Board invites the readers to suggest of new ideas and contribute useful articles and developments to make The Corrugator even more interesting during this year.



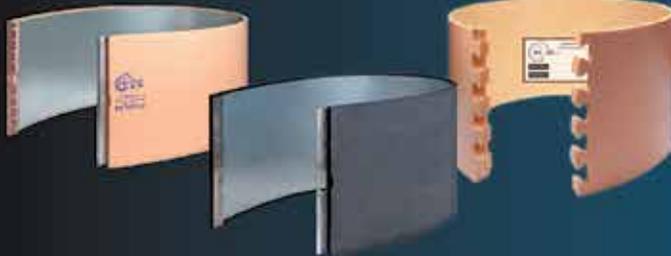
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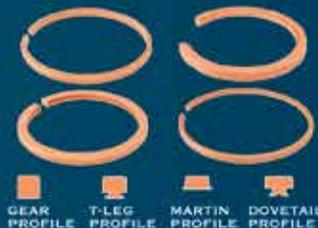
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PRESIDENT'S MESSAGE



Greesh Sardana

Dear Friends,

It is a pleasure to address you all again through the pages of The Corrugator.

Since assuming the office. I am exhilarated at experience of the fraternal feeling in our Federation. Any meeting of FCBM is like a reunion of the family!!

The RCBMA went all out to host the MC Meeting in a grand way. The seminar, the sub-committee meetings, and the MC Meeting all made it look like a mini conference.

I am sure the experience will be the same or more when other MC Meetings or seminars are held during the year – at other regional associations.

On the economic front, all seem to be shaping well.

As per RBI Governor, economic activity is expected to pick up from the latter part of the fourth quarter of 2016-17 with the remonetisation of the economy taking place at an accelerated pace. Rapid remonetisation implies swift reversal of the aggregate demand loss. Greater demand for goods will in turn create greater demands for packaging.

The Union Budget for 2017-18, while being prudent, has stepped up expenditure on infrastructure. Global growth is projected to be higher in 2017 than 2016.

These factors, along with improved monetary transmission, have markedly improved growth prospects for 2017-18 compared to the current year.

The roll out of GST is expected to further boost the economy.

Our Federation has been very active with the regional associations organizing Technical Seminars, Educational Courses, and Get Togethers.

I do hope the momentum will continue and make our Federation – even a more vibrant body working for the benefit of our members in the industry.

Come April – we have the international corrugated packaging shows at Shanghai. Our Federation has a collaborative agreement with 'Sino Corrugated'. We will be organizing delegations to visit the show.

There is also 'I Corrugated' this year around the same time in Shanghai. The organisers have made many attractive offers to visitors.

I do hope our members will visit in large numbers and derive the benefit of witnessing latest developments in corrugated packaging technology.

Yours truly,
Greesh Sardana

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LifeCradle – A Life Saving Innovation made of Corrugated

A low-cost baby incubator made out of corrugated board is creating waves across the world.

This year's Forbes India 30 Under 30 list has thrown a surprise: LifeCradle, a low-cost baby incubator using, of all things a corrugated board!

LifeCradle is designed to provide hygienic living conditions as well as the technology needed for a newborn's survival at home once it leaves neonatal care, while keeping costs down. While the base is made of cardboard, the lid, which houses the technology, can be reused at care centres.

How does LifeCradle work? + The child is discharged from the hospital in the box.

This helps the parents maintain hygienic conditions lacking in low-income, poverty-stricken areas. The lid, however, is embedded with technology to monitor the vitals and is reused by medical centers. 14e—mays,- “Dedicating one cardboard box to one child helps in containing infection problems. From a sustainability point, we can provide this to mass market as it will not have negative impact on the environment”

As for the reasons for choosing cardboard, he says: “Cardboard acts as an insulator, thus serving both the purposes in our business model. Firstly, acting as a cost-effective, readily available base and secondly, serving as a makeshift cot till the child outgrows it.”

The company is still at a product development stage and once ready will be made available to neonatal intensive care units where such facilities are not affordable.

By end-2017, Mr Sanghavi's team will be testing the prototype through an NGO in Nashik and the ISHWAR Foundation in Uttar Pradesh. He also plans to take LifeCradle to Africa and Latin America by 2022.

LifeCradle is creating news across continents, besides getting world-wide acclaim. It has already won the United Nations Sustainable Development Solution Network, Italy.

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Understanding Inks Made Easy !!

Using Color, as a measure of Quality and Product Identification is a basic requirement in our industry that needs to be continually developed and made better During this last year I have offered discussions and opinions on many components that control and directly affect both box and sheet plants in our industry.

Calibration methods have been discussed as an effective tool to properly manage the mechanical operating side of our Die Cutters and Flexos. I have also offered suggestions that will improve the performance of our tooling suppliers who manufacture Cutting Dies, Printing Plates and Inks. All of these areas of expertise are necessary ingredients that together, will contribute to our physical and financial success.

I would like to take this time to review one part of our process that is frequently a challenge to manage and that is the subject of "Flexo Inks". For all of us, this is certainly an area of opportunity and one that needs continuous discussions. There are a number of components that directly affect and control how we print color other than the Ink itself. We will first spend some time on the subject of Flexo Inks and then we will discuss the components that affect how we deliver ink to the sheet.

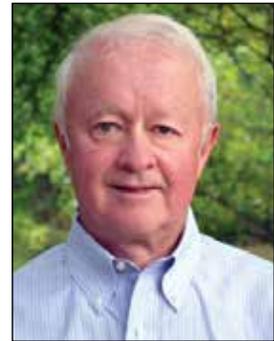
We need to first review and understand the components of ink and the mechanical relationships that exist in a chemical and water based environment. Generally speaking, there are four main ingredients in Flexo inks: Pigment—Resins—Amines—Water. We need to use these components as affective tools in order to print the colors that our customers demand. I like to speak in general terms in order to keep things simple for this discussion.

As we know the Pigment is the color. It is the most expensive ingredient in the process. Then there are the resins. They are the carriers or vehicles in the ink and they are initially responsible for transporting the pigment particles from the ink bucket through the ink pump,

to the chamber head (or nip rolls), onto the printing plates and finally to the corrugated sheet. The Amines offer an alkaline environment in the ink in order for the two components (Pigment and Resins) to have a relationship. The fourth ingredient of course is water. By the way, we call our ink "Flexographic" ink because it is a water-based product.

We need to first define what we mean when we discuss pH qualities of ink and how it affects the process. "pH meter" refers to the Hydrogen Ion properties of the ink. It defines any solution as an Acid Base, Neutral Solution or an Alkaline Solution. You can see by the description that the inks we use in our industry are on the alkaline side. (See Slide #1) All over the world the Flexo inks that we use have a pH range from 8.5pH to 9.5pH. By the way, these numbers are logarithmic by definition. This means that 8.6 is ten times more alkaline than 8.5. 8.7 is twenty times more alkaline than 8.5. So, 9.5 is actually one hundred times more alkaline than 8.5. This is important to understand as this tells us that the pH qualities of our inks are very easy to understand and manage. A pH of 9.5 is not just one point higher than a pH of 8.5. It is one hundred times more alkaline than 8.5. The differential is very large number. Properly done, pH management is a very easy process to understand and therefore easy to manage.

Now, as we said, all the pigment particles and resin particles are "inert" materials. They actually have no chemical activity themselves and are on the same par with sand or dirt. In order for them to have a proper relationship and be chemically active, they need to reside in an alkaline



Dick Target
"On Target Consultants"

environment. That is the reason for the third ingredient: Amines. (They are generally called mono-ethanol amines [MEA'S] or in some cases [D-MEA'S] or diluted MEA'S. This is dependent upon the specific formula for the ink and its color.

There are also several different types of amines that we use in the ink industry and they all relate to the speed at which the amines evaporate. Simply said there are slow, medium and fast evaporating amines. They control and help determine the drying rate of the ink on the sheet.

I would also like to point out that the Amines we use are a temperature sensitive product. When we walk past the print stations, we frequently smell the inks. Actually, we smell the amines that are evaporating from the buckets. (Remember the Pigments and Resins are inert and they have no chemical activity themselves). It is very important to understand how we manage the condition of the amines themselves depending what time of year it is as well as where we are in the country. In cooler climates (wintertime in the Northern Hemisphere) the inks



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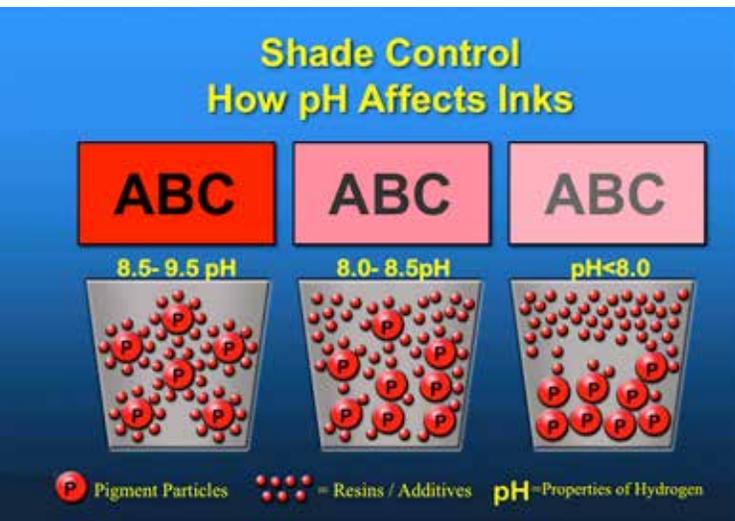
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tend to be more stable due to the lower temperatures. In the summer months, the amines evaporate much faster and the ink loses its color while the viscosity numbers tend to rise quickly. You should have this discussion with your ink suppliers so that they can properly and accurately support you throughout the year.

In the ABC slide (See Slide #1) you can see the Large Circles (Pigment) and the Small Circles (Resins) that encapsulate the pigment particles. The job of the resins (small circles) is to support the pigment particles and keep them in solution until they are delivered to the corrugated sheet. The slide on the left shows ink in its proper "Pigment/ Resins Relationship"



and the color is a 74 or 75 Red. You can see that the pH of this red ink is between 8.5 and 9.5 or just 9.0 as a reference. This is controlled by the presence of the MEA'S. I call this "Proper Ink" with its proper Pigment/Resin relationship. If this product is delivered to the sheet the color will be correct. The center view shows ink where some of the amines have evaporated and you can see that the Pigment/Resin relationship has changed and the pigment particles (more dense) are separating from the resins and falling to the bottom of the cell. At the same time, the color is now bleeding into the water losing its color density and now coloring some of the resin particles. The net difference is that the color is now changing and getting lighter. We are losing the required color that the customer is expecting. The ink is also getting thicker.

Earlier, I said that the job of the resin particles is to transport the pigment and keep it in solution during the process. The resins actually have two jobs in their whole life. The first job is to transport the pigment and their second job is to fix or glue the color to the sheet. As the resins start to separate from the pigment particles during the printing process, caused by the evaporation of the amines, the resin particles also start to touch each other. At this point they do become sticky. Properly formatted, when the ink arrives on the sheet, the pH drops while the ink ingredients separate. The pigment is then absorbed into the paper and the resins fix or glue the color to the sheet. Also at this point, the amines have totally evaporated; the water is absorbed into the sheet as well as the pigment or the color. We call this printing!

During the production day, as the amines will evaporate, this will change the viscosity of the ink. The Ink will become thicker and the color will not be correct. Over the years we have trained our operators to add "water" to the ink in order to reduce its viscosity. This is wrong. The inks became

thicker (increased viscosity) because the amines have evaporated. We then lose the proper pigment/resin relationship as the "resin" particles are now in physical contact with each other.

Note: The pH of water is generally neutral (7pH) and now we are adding a lower pH material (water) to an already disturbed ink due to the evaporation of the amines. The proper technique is to replace the ingredient that has evaporated from the solution. The product is amines or a proper pH adjuster. Your ink company should supply this adjuster. I would suggest that the crews add 2 ounces of a proper pH adjuster once an hour throughout the day. When the ink is finished and the crew is placing the ink back on the shelf, add another 2 ounces to the kit just to help sustain the proper pigment/resin relationship until the next time.

Now, let's discuss the chemistry of the sheet or the paper. This is rarely discussed in our plants. The chemistry of the paper that we print on clearly controls the printing process. The chemistry of the Kraft paper or the model white or the coated stock is generally on the acid side of the scale. This is important to understand as this explains why we use the ink that we use. Properly controlled pH ink will print consistently on an acid based paper and the printing process will complete itself. The chemistry of the paper forces evaporation of the amines, as the pigment separates from the resin particles in the printing process. The pigment particles are then absorbed into the sheet. The resin particles stick together, become sticky and then fix the color to the sheet. That is how the process works.

Color is certainly a major ingredient in our process and in most cases, properly done, it will encourage our customers to accept the order and not look for any possible defects in the box itself.

In our next article, we will discuss how to better manage the handling of our inks and proper maintenance of the cells on the anilox rolls, surface tension on the printing plates and the plumbing system. Stay tuned, as this is an important part of the process.

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 35 years.

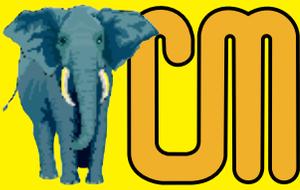
He teaches Flexo and Die Cutter Calibration "Short Courses" for TAPPI several times each year.

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

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

This article is printed in this issue with the permission of the author.

He can be reached at: dicktarget@gmail.com



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| Working Speed | 50 Mtr Per Min | 50 Mtr Per Min | 80 Mtr Per Min | 100 Mtr Per Min | 80 Mtr Per Min | 50 Mtr Per Min |
| Power Consumption | 50 kw | 100 kw | 60 kw | 100 kw | 120 kw | 50 kw |
| Man Power Required | 6 Nos | 6-8 Nos | 6 Nos | 6 Nos | 6-8 Nos | 6-8 Nos |
| Installation Time | 2 Weeks | 3 Weeks | 2 Weeks | 2 Weeks | 3 Weeks | 3 Weeks |
| Daily Production | 10-15 Ton | 10-25 Ton | 15-25 Ton | 30-40 Ton | 30-40 Ton | 40-60 Ton |
| Price Range | ~ 60 Lac | ~ 85 Lac | ~ 90 Lac | ~ 120 Lac | ~ 140 Lac | ~ 200 Lac |





Plant I:
Plot No. 335, Belur Industrial Area,
KIADB Dharwad Karnataka



Plant II:
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Area, Margao Goa



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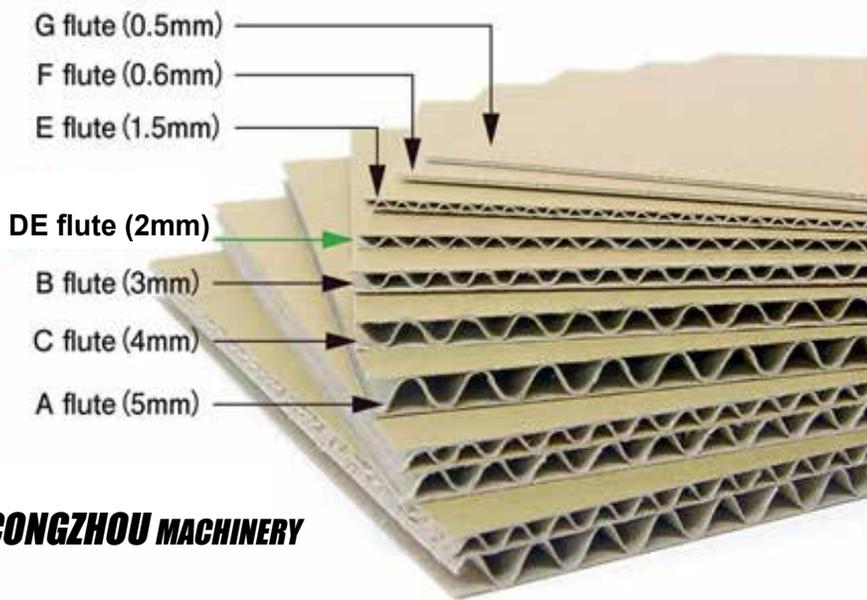


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FLUTE CHART

| Shape of Flute | A | C | BC | BC2 | B | D | DE | E | F |
|-----------------------|-----------|-----------|-----------|-----------|-----------|-----------|-----------|-----------|-----------|
| Flute Shape | UV |
| No of Flute in 300 mm | 34±2 | 38±2 | 44±2 | 48±2 | 50±2 | 66±3 | 75±3 | 96±3 | 124±3 |
| Height of Flute | 4.6-4.9 | 3.6-3.9 | 3.0-3.4 | 2.8-3.2 | 2.6-2.9 | 1.9-2.1 | 1.5-1.9 | 1.1-1.8 | 0.7-0.8 |
| Rate of Contraction | 1.51-1.59 | 1.44-1.51 | 1.42-1.49 | 1.40-1.45 | 1.36-1.42 | 1.40-1.41 | 1.35-1.40 | 1.29-1.39 | 1.22-1.26 |



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Tech Tip

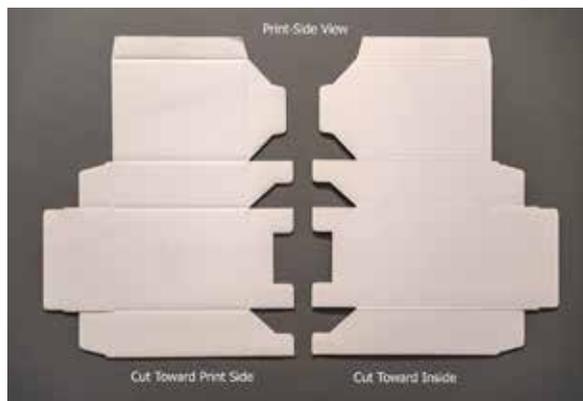
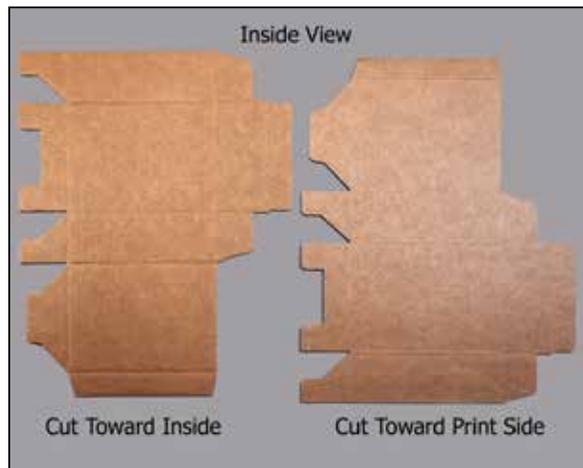
Bobst Corrugated Diecutting: Cutting on the Print Side vs. Inside

Diecutting corrugated stocks such as E-, F- and N-flutes on a Bobst platen press involves a choice of cutting direction—whether to cut toward the print side or to cut on the inside of the sheet (see Diagrams 1 and 2). Each choice has advantages and disadvantages. Certain stocks, such as B-flute, generally can only be cut toward the inside view.

Cutting toward the print side can reduce the negative impacts associated with sheet draw during the diecutting process. Cutting toward the inside of the sheet can enhance those negative effects. When cutting on the print side, the crease channel widths will be much thinner than the channel widths required for inside cutting. Also, when cutting on the print side, the crease channel materials placed on the cutting plate will contact the inside of the sheet.

Cutting toward the print side results in cleaner diecut edges with less chipping and flaking because the cutting knives will quickly cut through the print side liner before sheet draw created by the crease rule and the crease channel materials starts to pull on the diecut sheet. Also, print side cutting does not drag the printing across the crease channel materials on the cutting plate which can damage those printed surfaces.

Print side cutting results in a package that exhibits a slight “pillow” effect after folding. In print side cutting applications, the weight of the fluted medium greatly impacts the accuracy of folding in the flute direction. Heavy weight mediums tend to fold with less accuracy. If not properly designed, creases may fold on nearby flute glue lines instead of on the centers of the crease channels as intended.



Diagrams 1 and 2



Patrick Quinlan

Channel Creasing Matrix, Inc.
CCM Die Supply, Martinsburg, WV, USA

from the crease channel materials that is associated with cutting toward the inside of the corrugated sheet.

Patrick Quinlan is in Technical Sales with Channel Creasing Matrix, Inc./CCM Die Supply and is an IADD TechTeam™ member. You may reach Patrick at 1-304-616-1288 or by email at pquinlan@ccmdie.com. For more information on the IADD TechTeam, visit www.askTechTeam.org.

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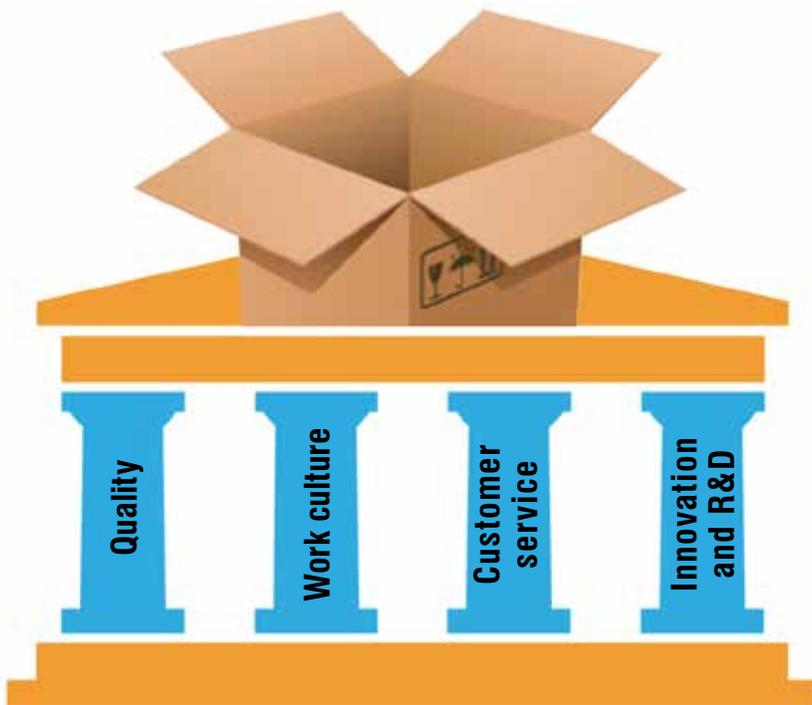
The Four Pillars of Packaging

Industry leaders come together to discuss the industry scenarios during the KMPA's Print and Beyond seminar held in Kochi, Kerala on 13 January 2017.

Ankit Tanna the presenter of the talk summarised his learnings into the four pillars of packaging. These pillars are "a must for a successful packaging company".



Ankit Tanna
Printmann Group



Quality

Quality packaging or no packaging is of the prime importance. For us, this holds true every day because it was the appreciation of our quality which gave us a genuine opportunity in packaging.

It is a clear differentiator. It's not price, its quality which will be a differentiator in packaging. Because unlike commercial printing where you are printing marketing material, in packaging, you are printing their raw material. You are representing their brand, their identity. Therefore there should be no compromise.

In the packaging industry, a lot of your clients will demand certifications. Today the carton, label and leaflet division of Printmann group is an ISO 9001:2008, PS 9000 and a BRC:IOP certified plant. The foils division is an ISO 15378 Plant with USDMF certification. Often we ask ourselves and discuss with our peers as to who is going to pay for all these costs related to the certifications. The truth is no one. But we must realise that these certifications must be done for ourselves more than doing it for the client. These certifications create a system which takes me to the next point.

Systems must work, not the people. If systems are in place, people will have to follow; since they will have a roadmap laid in front of them. Because as a business owner, you cannot ensure quality during every process.

In packaging, you will often face audits wherein the auditors check the inspection systems in your processes. These online inspection systems come at a high price. But when you see your cost sheet there is no charge for inspection systems or quality control. That is a given.

This takes me to the next point. Quality systems and implementation should not be considered as a cost but an investment. But the question you will pose is, what is the ROI? The intangible ROI is Goodwill and Loyalty.

Your clients will stay with you because your inspection systems will make the product work seamlessly on your customer's lines and hence give your customer a good night's sleep. The tangible ROI is obvious: getting rid of labour complexities.

Work culture

Quality is going to be redundant if a packaging firm is not successful in changing or implementing the workculture of the organisation.

Back in Mumbai, we say 'get rid of the Chalta hai' attitude which means I know



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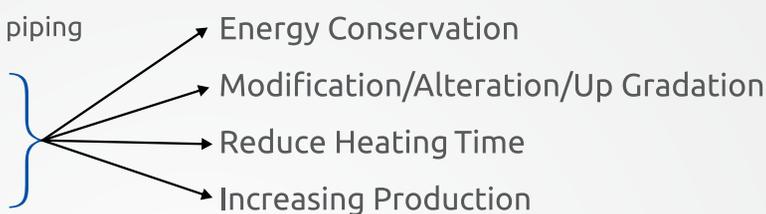
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it's not up to the mark but it is almost perfect!! In packaging, the world is binary. It is either okay or not okay. That change in attitude has to trickle down from you all the way to the helper on your machine.

In commercial printing, you will be told to use CMYK with lamination. In packaging you will be instructed "185c red, reflex blue and 376c green with benzophenone free varnish and braille height of not less than 1.6mm". Firstly, as a business owner, you must understand why this is important. Imagine a Colgate red or Bank of Baroda orange. These brands are defined by the colour on the packaging. So we must respect these colours. This mathematical reading of numbers to define colours must percolate to the operator. That is the change in culture, that packaging seeks.

In packaging you will come across migration issues. This means, the inks and varnish you are using should not migrate into the clients product. Let's be clear if the client demands it, he must pay for it. And if he is paying for it, we as packaging solution providers must implement it. If the client is not ready to pay we must refuse to use that varnish because that's where our responsibility lies. Imagine this scenario, a cereal box in which we were told to use a particular food grade varnish. For some reason, you didn't. Now that box lands into your kitchen for your child's breakfast. Scary?

That is the responsibility a packaging unit must have in its culture. At Printmann, we are into pharmaceutical packaging and we keep telling our helper that if you don't use the product mentioned in the job card or do not follow the system, then someone's life is at stake.

Trainings help in continuous improvement. Internal audits help in identifying the loopholes which disrupt the system.

And finally EHS has to be a cultural change of top management. Fire audits, fire marshalls, first aid audit, medical checkups, colour blindness tests. All these are very important.

Customer service

Packaging is a complex process. Take a carton for example. You convert the PDF

received from a 2D blueprint to a 3D carton. It involves the entire pre-press process, die-making, etc. This is followed by the printing and then die cutting; followed by braille and pasting. How will your client know the pains you go through until he sees it first-hand? Therefore invite the client over. Make him understand your processes. If he sees it, he will believe the lead time you require and the price you are quoting.

Educate the client. Because if you don't, someone else will. Discuss your costs openly, and don't try to bluff him.

Also simultaneously keep listening to your client. Try to follow their path. If you see they are successful, then you can grow with them.

Never lose respect, printers have this huge respect deficit.

As a community, we must work towards reducing the trust deficit. We must reach a point where we are seen as partners and not just vendors

Innovation and R&D

At Printmann we treat innovation as part of our customer service. It is my duty to come up with new products or tweak processes to better my services. But how does one innovate? After all, innovation is quite a subjective thing. It means different things for the people in the value chain. It can be very different for someone at the brand end of the packaging sector to someone at the technical end.

Therefore stay in touch with your clients product / packaging development team. There will be no need for an idea generation at your end. All of you have to do, is listen to their concepts and then you need to execute it with your R&D.

Secondly, visit or participate in your industry and your client's exhibitions to study the trends. It is crucial to know what the techniques, materials and technology relating to print for the packaging sector. Also, it is a good time to pick the brains of the decision-makers about things like green eco-friendly packaging and understanding how they do their filling, packing, fulfilment and logistics services.

Third, walk into a supermarket to see the packaging available in the market.

Compare them to your products. Strip open the carton and challenge yourself to make it better. Look at the embellishment. An important area for producing value-added products is in special finishes. This is where the demand is on the up. It depends on the sector but we are seeing a lot more use of embellishments, such as foiling, by brands that are differentiating their products. With extra finishes come at an extra cost, and as such, the mindset of the brand owner is crucial. While some customers are focused solely on price, others are more open to the potential sales uplift that a slightly higher spend on a fancier packaging can deliver.

Printing is a means to product creation Before I end I would like to quote a line in the invite of today's seminar that 'Printing is a means to product creation'. I agree. I say, always respect the product creation/ value addition you are doing. You are converting a mere piece of paper into a beautiful carton which is going to enhance your customers brand. The day you start respecting this credo, is the day your clients will respect your work and you.

Ankit Tanna the director of Printmann Group, specialises in four verticals: cartons, leaflets (which includes inserts, medi-guides and outserts (for the US Market), self-adhesive labels on bottles and most recently aluminium foil which is blister and strip packs. Ankit Tanna has served the organisation for seven years. He spoke about how a mid-sized firm could make a transition to packaging. He said, "The ROI on quality is goodwill and customer satisfaction."

This was presented during KMPA's Print & Beyond Seminar held at Kochi, Kerala.

This talk is featured here with the permission of Print Week. It was first featured in Print Week February 2017 issue.

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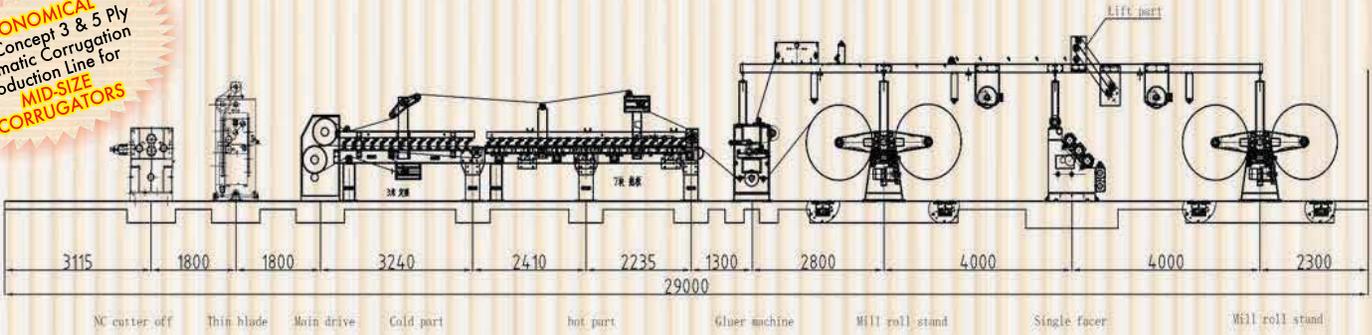
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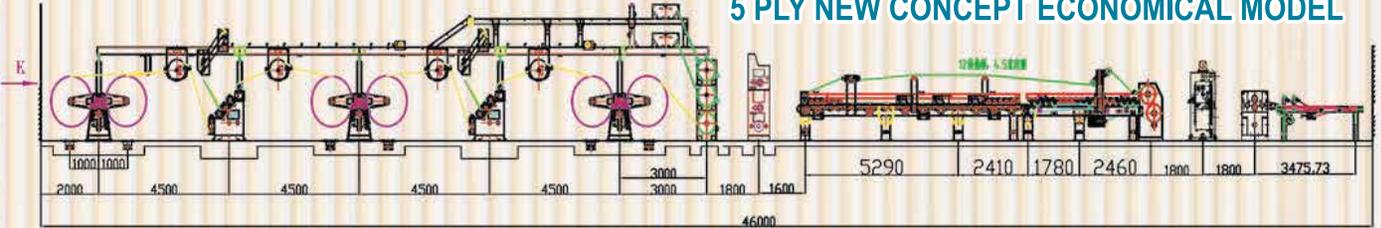
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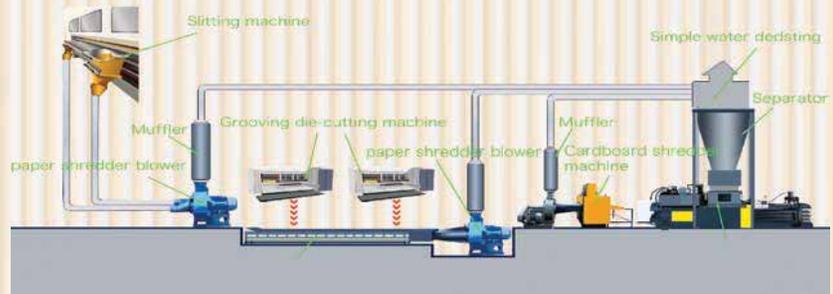
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The Starch Preparation Center

Starch adhesive is literally the glue that holds the board together. Although successful adhesive preparation in large part depends on formulation, the starch kitchen is a vital part of that process. Here are some things to consider in order to ensure it is able to operate consistently and with precision.

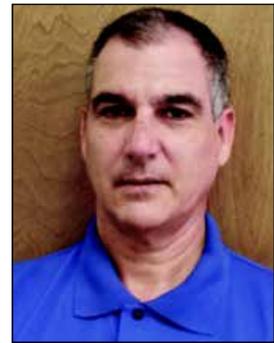


For an adhesive formula to deliver its intended parameters in a predictable fashion, its ingredients must be added in a repeatable manner. Most modern high shear mixers add the requested amount of an ingredient by weighing it. They use an electronic weight sensing device that takes advantage of the phenomenon that when a conductive metal is put under a force, its conductance changes in a very predictable manner. The device is called a strain gauge or more commonly, a load cell.

Most mixers have two sets of load cells. The large ones on the mixing tank are for weighing the starch and the water. A smaller range set is used for measuring the caustic and the borax, which are added in smaller quantities and require more precision. Load cells need to be calibrated regularly to ensure the proper functioning/accurate weigh of the mixer. Variations in ingredient weights will cause fluctuations in viscosity and gel temperature.

A quick way to check the load cells is to place sacks of borax (usually 50 lbs) on top of the mixer and see if the scale readout increases correspondingly. Obviously, this is not a substitute for a proper calibration, but can still be useful in diagnosing a problem.

Make sure nothing is touching or resting against the mixer tank because this will disturb the accuracy of the load cells. It would be like leaning on the wall while



Rex Woodville - Price
Special Projects Manager
HarperLove, Charlotte, N. C.

standing on a bathroom scale; you won't get an accurate weight. Hoses, and such should have enough slack to allow free movement of the mixer tank. The starch discharge chute or sock should be loose and have a little bit of sag. We don't want the mixer hanging from the sock, as this will alter weight accuracy and repeatability. Keeping the mixer clean will prevent many problems. Although the kitchen's weight control system will tare or re-zero itself before initiating a new batch, buildup of material in the tank will cause problems when the amount is excessive. Any caked up material that falls into the batch during the primary portion will affect viscosity.



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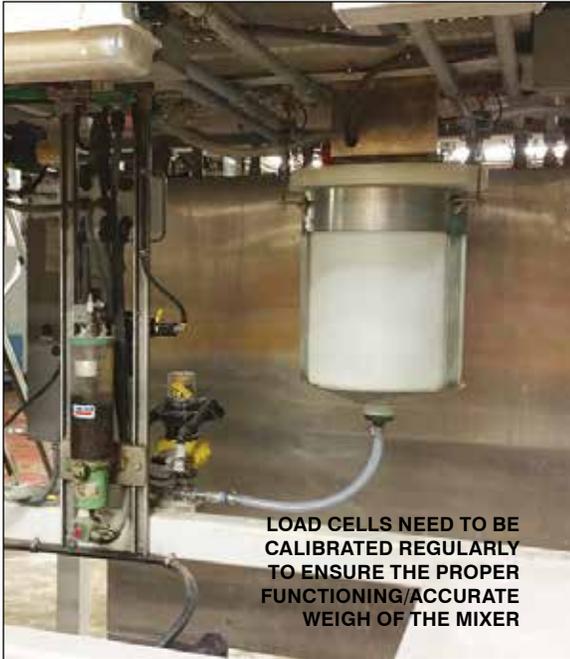
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LOAD CELLS NEED TO BE CALIBRATED REGULARLY TO ENSURE THE PROPER FUNCTIONING/ACCURATE WEIGH OF THE MIXER

Leaking water valves will add extra water. This will dilute the adhesive, lowering viscosity and solids content.

Leaking steam valves can release extra vapor inside the mixing tank and foul the borax discharge auger or starch delivery chutes. Steam leaking into the adhesive will cause localized gelling, often evident as fisheyes or gel balls.

Although not strictly part of the starch kitchen, the storage tanks need some love too. Clean the screens regularly to avoid them plugging up and overflowing.

Once they start to overflow, they no longer function as a strainer and allow debris to fall into the tank and continue to circulate in the distribution system.

It is a well-documented phenomenon that adhesive viscosity varies with temperature; therefore it is important to keep the adhesive at a stable temperature. Changes in viscosity will affect application rate. This is the job of the Temperature and Viscosity Control system (TVC). Temperature of TVC water should be at least 15 degrees (F) below the gel temp of the adhesive to prevent gelling on the heat exchange coils.

Supplying the glue pans with sufficient and consistent adhesive is paramount to operating a corrugator efficiently.

Any raw starch leftover in the mixer at the beginning of a batch will become primary starch and increase viscosity. It is important to check that the mixer empties completely.

Most starch kitchens will produce a finished batch report, which shows the amounts called for in the formula (target) and the actual quantity delivered in that batch. It is useful to check these reports regularly and note any disparities. Alarm reports also hold useful information about the health of the starch kitchen.

Breather socks should be kept clean. They should feel soft to the touch, not stiff and impregnated with dust. As the ingredients are added to the mixer, air is displaced and must exit. If the sock does not allow this warm, humid air to exit, it will go out through the borax auger or the starch discharge chute and can cause problems. Borax in particular is hygroscopic and can clump up if exposed to humidity.

Ensure that all air regulators are set to the correct pressure specified by the manufacturer. Insufficient pneumatic pressure can cause inconsistencies in the quantity of product delivered. Air valves require sufficient loading pressure to function properly.



SCREENS SHOULD BE CLEANED REGULARLY.



For this to happen, the adhesive preparation equipment must be kept in good running order through periodic care and maintenance.

Rex Woodville - Price is Special Projects Manager for HarperLove, Charlotte, N.C. He has been in the corrugated industry for 26 years as a Project Engineer for Interfic, Sales Engineer for Goettsch, and Packaging Maintenance Engineer for Chiquita's Packaging Division.

Originally published in Corrugated Today May-June 2016. Printed here with the permission of the author.

Cold Gum Mixing Machine

The Advance Starch Glue Preparing Technology in Square

| | | Capacities | | | | |
|----------------------|--------|------------|----------|----------|----------|-----------|
| | | 200 Kgs. | 400 Kgs. | 600 Kgs. | 800 Kgs. | 1000 Kgs. |
| Gum Stirrer Size: | Length | 20.5" | 24" | 27" | 30" | 31" |
| | Width | 20.5" | 24" | 27" | 30" | 31" |
| | Height | 30" | 44" | 52" | 56" | 65" |

Salient Features

| |
|----------------------------|
| Most Modern and Versatile |
| High Shear Mixing Agitator |
| Compact Design |
| Sturdy Fabricated Unit |

Benefits

| |
|--|
| High Shear Mixing efficiency |
| Stable Viscosity, Consistence Product |
| Low wastage in handling & transferring |
| Improved Product Quality as compared to the Round Tank |
| No Maintenance Cost as in the case of Pulley System |



Our organization has supplied more than 200 Cold Gum Mixing / Stirrer Machine to our valued customer which is our appreciated achievement.

For more information on our products and to watch our Cold Gum Mixing / Stirrer Machine video log onto our website [www. balajienterprisesindia.com](http://www.balajienterprisesindia.com)

We also sell-out Corrugation and Pasting Gum Liquid plant unit with One year free service and support

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Salient Features

| |
|---|
| Fast Drying Property. |
| After drying, sheet does not delaminate. |
| Liquid Gum Quality does not deteriorate up to 4-5 days. |
| Best Tackiness. |
| Added Strength. |
| Prompt Services are assured |

Method Of Preparation

| |
|---|
| Take out Caustic Soda Packet from the bag |
| Take 100 Lts. water. |
| Start Stirrer & insert the powder. |
| Stir for 2 minutes. |
| Insert Caustic Soda. |
| Stir for 30 minutes. |
| Add 70 Lts. Water. |
| Set the Viscosity as mentioned below |

Technical Specifications

| | CG30 / CG35 / CG40 | PG30 / PG35 / PG40 / PG50 | PG50 | DDG40 / DDG50 |
|---|-------------------------------|---------------------------|-----------------------------|---|
| Purpose | For Corrugation Sheet Bonding | For Pasting Sheet Bonding | For Flute Laminator Machine | For 3 PLY / 5 PLY / 7 PLY Automatic Plant |
| PH of Liquid Gum | 9-10 | 12-13 | 12-13 | 9-10 |
| Viscosity of Liquid Gum (As B4 Visco Cup) | 28-32 | 28-32 | 40-45 | 50-55 |
| Powder's colour | Off White | Off White | Off White | Off White |
| Liquid Gum's Colour | White | Honey Shade | Honey Shade | White |

Note – Method of preparation for PG50, DDG 40 and DDG 50 differs slightly.

Results

CG in 30/ 35/ 40 Kgs. which will give 200 Kgs. liquid Gum for application.

PG in 30/ 35/ 40/ 50 Kgs. which will give 200 Kgs. liquid Gum for application.

DDG in 40/ 50 Kgs. which will give 200 Kgs. liquid Gum for application.

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- Auto and semi auto flute laminator machine.
- Semi auto 1- piece and 2-piece box stitching machine.
- Lead edge feed, kicker feed and chain feed rotary slotting, creasing and slitting machine.
- Lead edge feed, kicker feed and chain feed rotary die cutting machine.
- Thin blade slitter, scorer machine.
- Pasting machine.
- Platen punching Machines.
- Sheet pressing machine.
- Manual stitching machine.
- Auto bundling machine.
- Heating systems for automatic paperboard production lines and single facers.

Semi Auto Flute Laminating Machine



Semi Auto Folder Gluer Machine

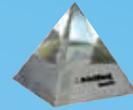


Semi auto box stitching machine (Single piece & Two piece)



Finger Type Single Facer





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KeCBMA AGM & Technical Seminar

The 37th Annual General Body Meeting of the KeCBMA along with a Technical Seminar was organised on 9-11-2016 at Cochin Palace Hotel, Ernakulam. Mr. I.A. Peter, Chairman, R&D, FCBM inaugurated the Technical Seminar. Mr. Ramkumar Sunkara, Co-Chairman, R&D of FCBM was the main faculty for the seminar.

The First Session of the Seminar on "How to increase the margins in cost competitive environment" was presented by Mr. Ramkumar Sunkara.

The Second Session on "Testing Parameters" was presented by Mr. I.A. Peter.

Mr. Ramkumar Sunkara spoke with the help of video presentations for more than 3 hours continuously. This was followed by an interactive session also. About 100 corrugators were present at the seminar. Mr. Ramkumar Sunkara spoke in a scientific manner with examples which was very much appreciated by all the participants.

Mr. I.A. Peter also gave a very knowledgeable presentation on testing equipments available for the corrugated packaging industry and its utility for the production of quality boards and boxes. Mementos were presented to the Faculties.

The Annual General Body Meeting started at 8.15 p.m. Mr. Xavier Jose, President, KeCBMA welcomed the members. He spoke on the latest activities and achievements of the association and also about the new projects being planned

by the association. Mr. K. J. Pratheesh, Secretary presented the minutes of the previous annual general body meeting and also annual report of the Association. Mr. Bejoy Cyriac, Treasurer presented the audited accounts for the 2014-15 and 2015-16 and also the conference account and the same were adopted with applause.

The existing team of office bearers were re-elected for next one year. Mr. G. Rajeev offered vote of thanks.

The meeting ended at 10 p.m. followed by dinner and fellowship.





APCMA Conclave on GST

On 18th January APCMA organized a conclave on GST in conjunction with its AGM. Almost 50 members participated. Invitation was extended to Paper mills as well and 8 Paper mills attended.

Senior Dy. Commissioner, Mr Srinivas Rao who has been participating in the Council meetings on behalf of Telangana, hence is very keyed into all the happenings headed the panel. His presentation was very lucid, and encompassing. It was a very good and informative presentation. Another speaker was Mr. B. Shankar who was with the association earlier in 2015. He too gave in-depth analysis of the short comings on GST.

The highlights of the two presentations were:

1. 1 July is the date D Day.
2. A very important development is consensus is forming on inclusion of Real Estate in GST Regime. This will be a major boost to economy and a big effort in reduction of Black money.
3. Alcohol and Petroleum are the major items out of GST.
4. 3rd Version of the Draft laws as a final step to the final law will be out in next 2/3 weeks. The Association must study this in detail and respond where needed.
5. Transition Provision to ensure smooth move to GST regime will be formulated and implemented before the D Day.
6. Towards smooth transition all old legacy issues from Sales Tax and Vat are proposed to be resolved by some sort of One Time Settlement.

7. Every assessee will need to file 3 returns; One for PURCHASES with full details by 10th; Second for SUPPLY by 15th and Final Similar to the current monthly returns by 20th.
8. Almost all Taxes and Cess will be subsumed in GST but R&D cess will not be a part.
9. A Rates Settlement Committee has been formed with 6 Commissioners from States and 6 from CBEC. Telangana Comm. Tax Commissioner is part of Committee so also Amit Mitra of West Bengal and Karnataka.
10. The issue of Paper and Corrugated Boxes being in preferential category and need to maintain the same position was discussed at length and the associations reasoning was appreciated.

APCMA is getting ready a Memorandum to be given locally. Suggest the other States give similar representation.



Mr. D. Srinivas Rao talking about GST and audience paying rapt attention



Special Meeting for Paper Price Increase

APCMA Organised a special meeting to deliberate on the impact of Increase of prices of Kraft Paper on 22nd February 2017



APCMA has handed over their representation to Telangana Commercial Tax Commissioner regarding the fitments of Corrugated Boxes and all articles of Paper and also all packaging materials to be in the preferential rate of @12%.

After discussions the Commissioner agreed to the view that till all products are not brought into GST net, there is need for Packaging to be at preferential rate. He has assured his support during the meeting.



Seminar on Packaging of Horticultural Produce, Processed Foods, Handloom, Handicrafts and other Cottage Industry Products

Organised by EICMA, under the aegis of FCBM

In association with : District Industries Centre, Bankura

Supported by : Bankura District Chamber of Commerce and Industries.

Venue: Minority Hall, Bankura Town, Date: 20th January, 2017 at 10 AM.

Bankura District, situated at about 230 km from Kolkata, is famous for its Terracotta and Dokra handicrafts. However, the district also produces substantial quantity of Mango and Tomato. The district administration is actively promoting organic farming in wasteland, which has attracted young and educated entrepreneurs to invest in such projects. Presently, the area under organic farming for just mango is 1000 Hectares – an example of the interest shown by investors in Bankura. Apart from fruits and vegetables and handicrafts, other industries in Bankura include eggs, tiles, Steel Furniture and packaged water.

There is a genuine lack of awareness and also availability of suitable packaging for the artisans, local traders and growers of Bankura, resulting in phenomenal wastages and under-realisation of value of their products. With proactive support from District Industries Centre, Bankura and Bankura District Chamber of Commerce & Industries, EICMA organised a Seminar on Packaging of Horticultural Produce, Processed Foods, Handicrafts and other Cottage Industry Products in Bankura on 20th January, 2017. The programme was attended by Mrs. Moumita Godara Basu, District Magistrate, Bankura, Dr. (Mrs.) MouSen, Dy. Director & General Manager, D.I.C., Bankura, Mr. Madhusudan Daripa, General Secretary, Bankura District Chamber of Commerce & Industries, Officers of Agricultural Marketing and Horticultural Department, Govt. of West Bengal, local artisans, traders, farmers and young entrepreneurs from Bankura district.

Eight members of EICMA from Kolkata drove to Bankura the previous evening,



for the Seminar. Mr. Prabir Sarkar (Barjora Packaging) – EICMA member, co-ordinated the entire arrangements locally. During the inaugural session, Mrs. Moumita Godara Basu, DM, Bankura, talked about the growing market of Bankura handicrafts and Industry and the hardships faced by local craftsmen and traders due to primitive and inadequate packaging or complete lack of it, so much so that – even Government officials like her find it difficult to get proper packaging materials

at the time of transfer. She said, as an example, 15 Lac eggs were produced per day in Bankura that are inadequately packed presently. She emphasised on the fact that, there is a good demand for packaging in Bankura district and local entrepreneurs may be encouraged to become dealers for packaging.

Dr. (Mrs.) MouSen, Bankura, thanked EICMA for their initiative in organising the much needed seminar and personally



urged each member of the audience to bring forth their packaging concerns to the EICMA members for a solution. During her speech, she was clear in expressing that, artisans today are aware of the necessity of good packaging, yet they were handicapped by the dearth of facilities in the district, which could be capitalised by the corrugating fraternity.

Mr. Madhusudan Daripa, General Secretary, Bankura District Chamber of Commerce & Industries, said his Chamber would act as a bridge between the local traders and EICMA and assured all assistance. He urged EICMA members to extend all possible help in developing and sourcing of packaging materials for local craftsmen, farmers and traders of Bankura, who are facing substantial loss in business due to lack of proper packaging. Mr. Daripa also informed that, a grade of Bankura Mango, Amrapali, had won an award at the Mango show in New Delhi.



Mr. Milan Dey, President of the Eastern India Corrugated Box Manufacturers' Association and Chairman – New Market Development Committee – FCBM, said, EICMA and FCBM stand committed to the cause of corrugated packaging and their endeavour to introduce corrugated packaging for horticultural produce and handicrafts. He assured the gathering that, EICMA, with the help of FCBM would develop and provide packaging solutions for the local trade in Bankura. If required, EICMA would also provide training for entrepreneurs, as requested by DM, Bankura and GM – D.I.C., Bankura.



Mr. Achyut Chandra, Secretary, EICMA, started the technical session, with a presentation on application of corrugated boxes in various fields, including handicrafts and horticultural produce. His presentation included EICMA's efforts in Haldibari (for tomato) and Malda (for mango), including the various tests done before arriving at the specification of boxes.

Mr. Chandra gave a world perspective on the use of corrugated boxes and the need for Indian growers to move from primitive wooden boxes to a more eco-friendly packaging like corrugated boxes. He also impressed upon the district administration to ensure proper collection of waste paper, in any form and sent back to the Paper

Mills for recycling. This would ease the import burden of the country.

Mr. Hemant Saraogi, Past President – EICMA, made a pictorial presentation titled “Corrugated Boxes – A Packaging Solution”. Apart from enumerating the advantages of using corrugated packaging, his practical approach in communicating with the local delegates was well appreciated. Mr. Saraogi suggested that local employment may be generated by involving them in waste paper collection which may be sold to Paper Mills situated in close proximity of Bankura District. Mr. Saraogi used the opportunity to play the Bengali version of the video to promote packaging of fruits and vegetables in corrugated boxes, developed by EICMA, with assistance from FCBM.



The technical session was followed by an interactive session, where local artisans and growers sought individual solution to their packaging issues. Most of them carried samples of their product – sarees, tiles, terracotta handicrafts, Conch Shell articles, pickles, etc., for the convenience of EICMA members, taking their questions. There were about 150 local delegates who attended the seminar and each one of them interacted personally with the EICMA delegation. Their spontaneity and willingness to use proper packaging were quite evident. The seminar was followed by lunch, hosted by EICMA.

The seminar was very satisfying and encouraging for EICMA who promised all support to the local trade in Bankura, by way of developing and catering to their packaging needs.

*Compiled by Soumitra Choudhury
Managing Committee Member EICMA*





Practical Course in Testing held on 23 to 25 Jan, 2017 at WICMA R&D Centre

In keeping with its winning streak of Educational Courses, WICMA R & D Centre conducted the Practical Course in Testing on 23-25 January 2017.

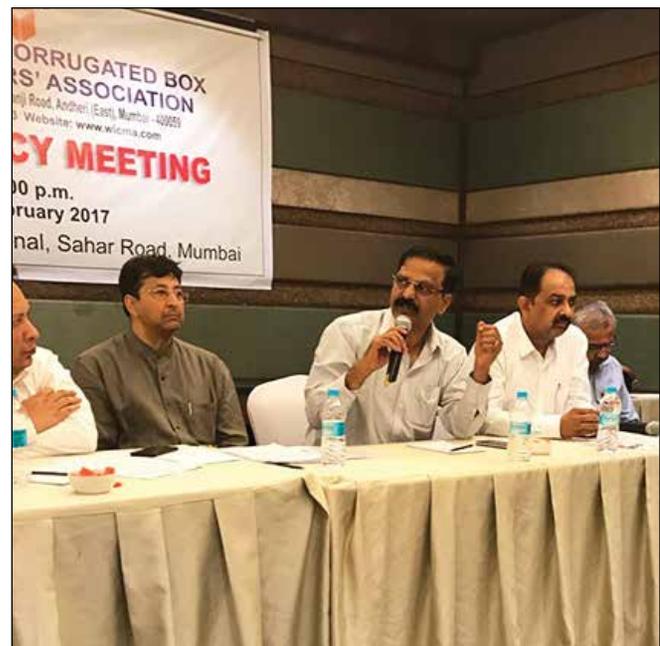
9 Members and 1 Non- Member attended the course.

Students came from Mumbai, Nagapur and Aurangabad.



Emergency Meeting

WICMA organised an Emergency Meeting on 3rd February 2017 in Mumbai to discuss the situation arising out of increase in prices of Kraft Paper.



Conference conducted by Marathwada Division at Aurangabad

Print Pack Conference 2017 was organised by Department of Printing Technology & Graphics Arts and WICMA Marathwada Division on 14th FEB 2017.

The Venue was Dr. B. A. M. U Campus, Aurangabad

“PRINT PACK” was an National Conference on Printing for Packaging with focus on A Multi - Dimensional Approach’.

Seminar was conducted by 4 eminent Speakers in 3 Sessions.

Mr. Sunil Gupta, President WICMA, was the Chief Guest.

Conference was very fruitful and successful due to active participation of members of Marathwada Division.





RCBMA Hosts 2nd FCBM Managing Committee Meeting at Jaipur

The 2nd Managing Committee of FCBM for the year 2017-18 was organized on 10-11th February at Hotel Holiday Inn, Jaipur. RCBMA hosted the event. This MC Meeting witnessed an unprecedented attendance of more than 60 members from all over the country.

The eHandbook on Excise and Service Tax as Relevant to the Corrugated Box Industry 2017-18 was released at the hands of President, Greesh Sardana.

The Managing committee discussed various other issues concerning the Corrugated Industry. The warm hospitality and meticulous arrangements by the young RCBMA host team was appreciated by all attendees of the meeting.

Preceding the Managing Committee Meeting, a Technical Seminar cum Exhibition was held for the benefit of the RCBMA and FCBM members present. This Meeting and Seminar cum Exhibition was a collective effort of Team RCBMA and was seen as a practice for organization of the FCBM Conference to be held in Jaipur in the year 2019.

RCBMA Invited Shri Manohar Shetty and Shri Ram Kumar Sunkara to deliberate on two hot topics of the season :-



- GST and its implications on the Corrugated Industry
- BS, COBB and RCT and their importance in a Corrugated Box in today's time

The session started with the felicitation of FCBM office bearers by senior RCBMA members and office holders.

Shri Manohar Shetty made a presentation on GST highlighting the changes that it would bring in the compliances and its pros and cons. It caught the attention of many members as major points highlighted by Shri Shetty were unknown to them. This was certainly a wakeup call for the audience to know more about the future of taxation and its impact on their business.

Shri Ram Kumar Sunkara enlightened the audience with the importance of RCT, COBB and BS in a corrugated box. He told the audience how the box has moved from a BS based specification to a BCT based specification. The customer today is interested in the BCT based specification. He taught the audience the calculation of BCT and optimization of cost of the box.

FCBM President Mr. Greesh Sardana launched the new logo and website of



RCBMA with this event. RCBMA also felicitated its members for the exemplary work done by them for RCBMA.

This event was attended by more than 70 RCBMA members and around 70 FCBM members. Around 17 sponsors from all over the country displayed their products in the exhibition. The exhibition saw a decent footfall of visitors.

The Seminar was followed by a musical performance by a Rajasthan Gypsy band which was enjoyed thoroughly by the audience. Cocktail and dinner followed.





Felicitations to FCBM Office Bearers

FCBM Managing Committee Members' Directory 2017 and E-HandBook on Excise & Service Tax as relevant to Corrugated Box Industry were released by President FCBM.



Cultural Programmes





Emergency PMCC Meeting In Mumbai

An emergency meeting of the Paper Mill Co-ordination Committee was held on 10th March 2017 at Hotel Atithi, Mumbai to discuss the current kraft paper price scenario. The Meeting was attended by the Federation's Office bearers, PMCC Chairman, Shri Mukesh Jain and

members and other senior members of the Federation. Shri Kirit Modi, (President-ICCMA) was invited and he also attended the meeting.

The market dynamics of kraft paper was analyzed and discussed. For the last several years, kraft paper prices saw an upward trend from the end of December till about April after which the price stabilized. This year, the increase in the price of Imported OCC and also local waste had an impact on the input cost of paper.

The collective closure by paper mills created artificial demand and scarcity,

which had an added impact on the price. The Federation strongly protested against mill closures which have caused untold hardships to corrugators and severely disrupted their production and delivery schedules.

Some of the members wanted to take stringent actions against mills closure. But it was concluded by all that as a first step, FCBM will request mills to refrain from closures. However if they persist, then FCBM & ICCMA will take further steps i.e. informing the Govt. agencies/ PMO and advertising in newspapers against the mills' closures.

It was decided that Customer awareness must be created on a large scale about the increase in the cost of inputs and conversion costs necessitating increase in box prices.

Joint action by FCBM and ICCMA to publicize the issue was proposed and accepted. A National press campaign would be jointly conducted. Ads would be taken out in prominent national English dailies and press releases would be issued in Regional dailies and Online Publications. **The campaign would highlight the problems caused by mill closures, the increase in the kraft paper prices and request box customers to increase prices.**



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Design speed: 300m/min
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Low strength of paper.

High moisture in rain reason.

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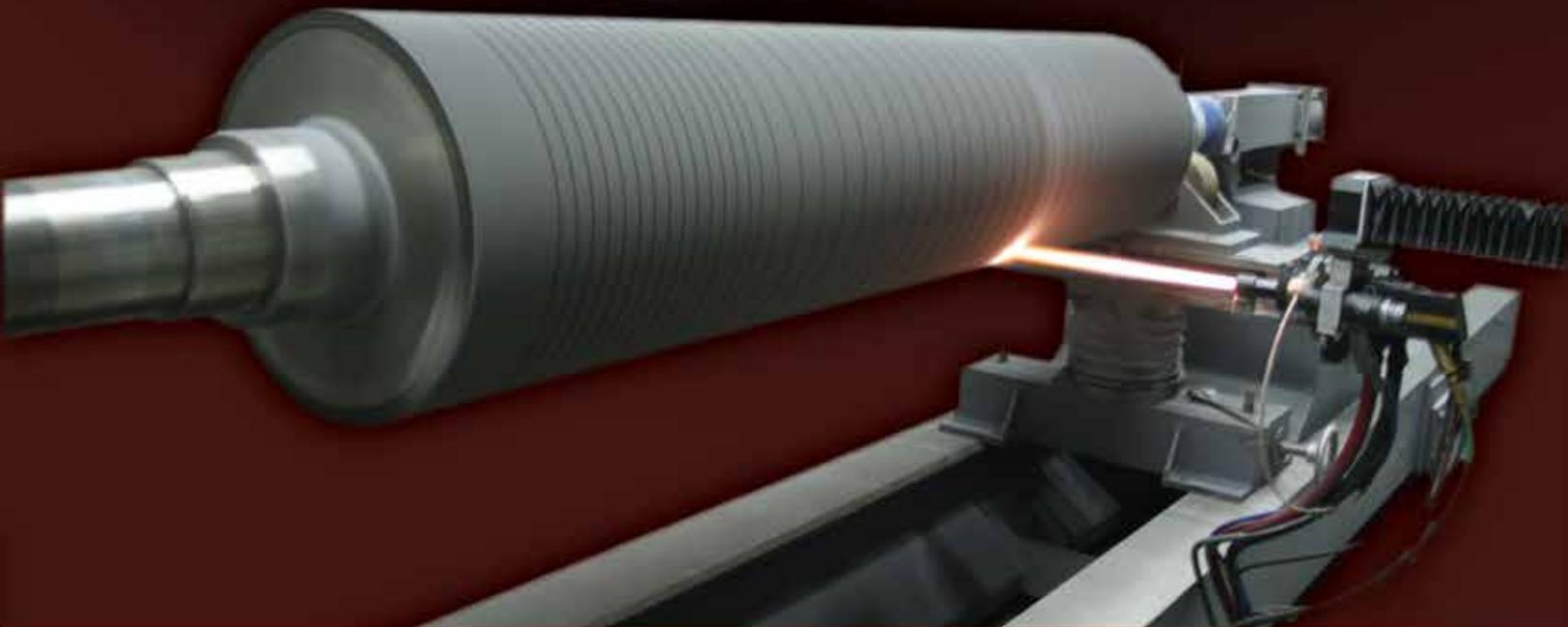


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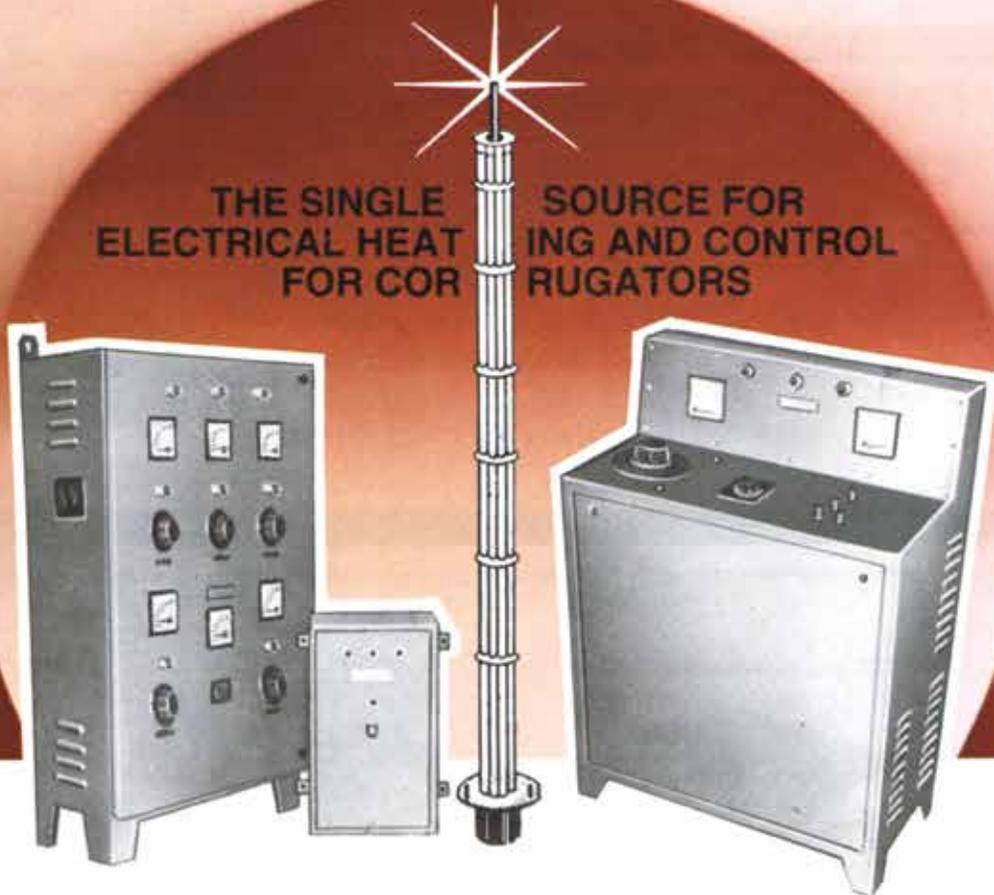
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Preventive Maintenance of Machinery – Two View Points

View I: Micromain

There are two types of maintenance strategies employed by companies that rely on equipment – reactive maintenance and preventive maintenance. Reactive maintenance goes by the “if it isn’t broken, don’t fix it” motto, a strategy that can sometimes save money short term but often ends up costing even more in the long run.

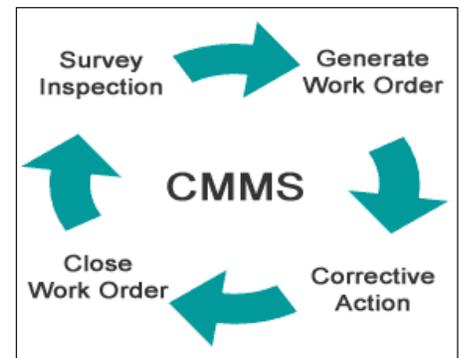
Preventive maintenance, on the other hand, is a carefully designed maintenance program (often using CMMS software) where maintenance tasks are performed routinely in order to avoid larger, costly fixes down the line.

Many maintenance professionals have recognized the benefits of preventive maintenance and are now turning to preventive maintenance software for ongoing equipment upkeep. Here is a look at 7 reasons why preventive maintenance is a much better alternative to reactive maintenance.

Cost Savings

Companies that rely solely on reactive maintenance are essentially waiting for a problem to happen, and this can often be a very costly move. Unplanned downtime

can result in idle employees, halting the production line, missed deadlines, and – for property managers of hotels, resorts, school campuses and other consumer facing industries – long-term damage to their brand. An unexpected failure can also mean having to pay technicians overtime and having to pay out extra money for overnight delivery of parts. A preventive maintenance program is meant to avoid these problems through long-term maintenance tasks that are planned for using CMMS software.



A preventive maintenance plan can save a company money because efforts will be focused on preventing equipment failure rather than responding to emergencies, and preventive maintenance is usually much cheaper and faster than big fixes. Maintenance managers can use CMMS software to set up a maintenance program, which simplifies the transition from reactive to preventive maintenance and is also very cost effective.

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condition, it creates many hazards, unsafe working conditions and even emergency situations where workers are injured. Preventive maintenance improves the safety of equipment and therefore the safety of company workers resulting in fewer on the job injuries and accidents.

Increased Equipment Efficiency

CMMS software can help plan routine maintenance such as inspections, oil and fluid changes, part replacements and more. These little fixes can help equipment to run much more efficiently. In turn, a company will benefit from fuel and energy savings because equipment will be running at peak performance.

Decreased Equipment Downtime

While almost all maintenance tasks require some equipment downtime, a preventive maintenance program can decrease and optimize that downtime. For example, a company doesn't experience unexpected downtime as much as if they were to rely solely on reactive maintenance. Companies can also use CMMS software to pre-plan maintenance tasks at optimal times so the downtime experienced is less troublesome. Decreasing equipment downtime is a benefit that saves time in maintenance and day-to-day operations.

Improved Reliability

Preventive maintenance can also help a company to be a more reliable business partner. Customers can count on a company to deliver products, materials, or service on time, without unnecessary delays. A resort with broken air conditioning will not succeed for long. By always offering a reliable product or service, a company can enhance its customer service and improve its reputation.

Conservation of Assets

Most equipment these days is certainly not cheap, but the better a company cares for its equipment, the longer it will last. Preventive maintenance will prolong the life of equipment so a company can get more hours out the equipment, resulting in reduced costs and increased profit.



The numerous benefits of preventive maintenance has caused many maintenance managers to shift from reactive maintenance to a regular, routine preventive maintenance plan meant to prevent problems and optimize equipment. Today's CMMS software helps facilitate preventive maintenance by helping schedule maintenance tasks and keep organized records of all inspections and fixes. Preventive maintenance is the best option for companies that want to succeed long term, and therefore understand that they need a long term plan for proper equipment upkeep.

preventive maintenance program is potentially risky, so it must be administered and performed properly to be successful. This paper will examine both the benefits and risks of preventive maintenance and offer some ideas on how to make it successful. We will start with a definition of preventive maintenance.

View II: RCI

What is Preventive Maintenance?

Preventive maintenance is planned maintenance of plant and equipment that is designed to improve equipment life and avoid any unplanned maintenance



The way we think about Preventive Maintenance (PM). has changed

It has caused some to question whether it is even necessary to do preventive maintenance. The truth is most manufacturing facilities would benefit from a good preventive maintenance program. It would be especially beneficial for those plants that rely on breakdown or run-to-failure maintenance. But, a

activity. PM includes painting, lubrication, cleaning, adjusting, and minor component replacement to extend the life of equipment and facilities. Its purpose is to minimize breakdowns and excessive depreciation. Neither equipment nor facilities should be allowed to go to the breaking point. In its simplest form, preventive maintenance can be compared to the service schedule for an automobile.



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A bona fide preventive maintenance program should include:

1. Non-destructive testing.
2. Periodic inspection.
3. Preplanned maintenance activities.
4. Maintenance to correct deficiencies found through testing or inspections.

The amount of preventive maintenance needed at a facility varies greatly. It can range from a walk through inspection of facilities and equipment noting deficiencies for later correction up to computers that actually shut down equipment after a certain number of hours or a certain number of units produced, etc.

Many reasons exist for establishing a PM program. Listed below are a few of these. Whenever any of these reasons are present, a PM program is likely needed.

Reasons for Preventive Maintenance

- Increased Automation
- Business loss due to production delays
- Reduction of insurance inventories
- Longer equipment life
- Production of a higher quality product
- Just-in-time manufacturing
- Reduction in equipment redundancies
- Cell dependencies
- Minimize energy consumption (5% less)
- Need for a more organized, planned maintenance function

PM on the Run - Summary

- Safety is the 1st priority.
- Shut down, manually bypass and PM any equipment you can.
- Set up a written Running PM for each piece equipment in your facility.
- Planning cannot be overstated in this situation.
- Make assignments according to experience, talent, and ability.
- Be innovative, look for new equipment and products that shortens the task time.



Why Have a PM Program

The most important reason for a PM program is reduced costs as seen in these many ways.

- Reduced production downtime, resulting in fewer machine breakdowns.
- Better conservation of assets and increased life expectancy of assets, thereby eliminating premature replacement of machinery and equipment.
- Reduced overtime costs and more economical use of maintenance workers due to working on a scheduled basis instead of a crash basis to repair breakdowns.
- Timely, routine repairs circumvent fewer large-scale repairs.
- Reduced cost of repairs by reducing secondary failures. When parts fail in service, they usually damage other parts.
- Reduced product rejects, rework, and scrap due to better overall equipment condition.
- Identification of equipment with excessive maintenance costs, indicating the need for corrective maintenance, operator training, or replacement of obsolete equipment.
- Improved safety and quality conditions.

If it cannot be shown that a preventive maintenance program will reduce costs, there is probably no good reason other than safety to have a PM program.

The Law of PM Programs: There are many advantages for having a good preventive maintenance program. The advantages apply to every kind and size of plant. The law of PM programs is that the higher the value of plant assets and equipment per square foot of plant, the greater will be the return on a PM program. For instance, downtime in an automobile plant assembly line at one time cost \$10,000 per minute. Relating this to lost production time an automobile manufacturer reported that the establishment of a PM program in their 16 assembly plants reduced downtime from 300 hours per year to 25 hours per year. With results such as this no well-managed plant can afford not to develop a PM program.1



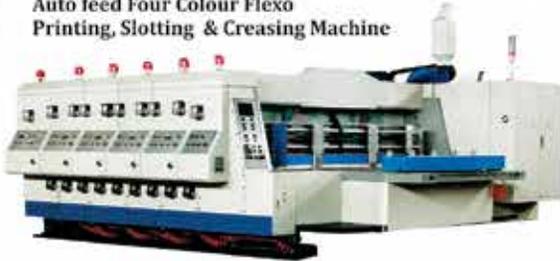
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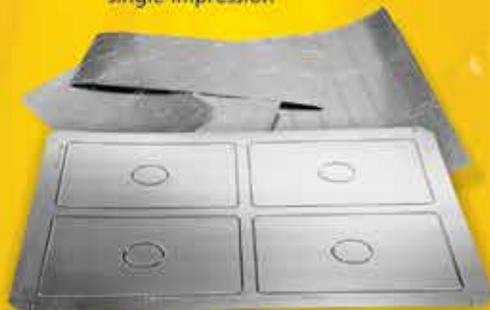
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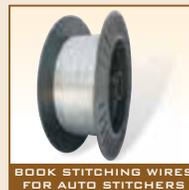
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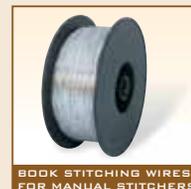
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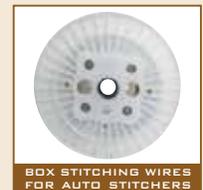
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Preventive Maintenance Program Risks

As mentioned in the beginning of this report, preventive maintenance does involve risk. The risk here refers to the potential for creating defects of various types while performing the PM task. In other words, human errors committed during the PM task and infant mortality of newly installed components eventually lead to additional failures of the equipment on which the PM was performed. Frequently, these failures occur very soon after the PM is performed. Typically, the following errors or damage occur during PM's and other types of maintenance outages.

- Damage to an adjacent equipment during a PM task
- Damage to the equipment receiving the PM task to include such things as:
- Damage during the performance of an inspection, repair, adjustment, or installation of a replacement part.
- Installing material that is defective, incorrectly installing a replacement part, or incorrectly reassembling material.
- Reintroducing infant mortality by installing new parts or materials.
- Damage due to an error in reinstalling equipment into its original location.

Especially disturbing about these types of errors is the fact that they go unnoticed – until they cause an unplanned shutdown. There is some published data that illustrates this point. It comes from the fossil-fuel power industry.

A review of the data from fossil-fueled power plants that examined the frequency and duration of forced outages after a planned or forced maintenance outage reinforces this concept. That data showed that of 3146 maintenance outages, 1772 of them occurred in less than one week after a maintenance outage. Clearly, this is pretty strong evidence that suggests that in 56% of the cases, unplanned maintenance outages were caused by errors committed during a recent maintenance outage.

Having performed and supervised many industrial PM's, I also support this concept. I can remember many instances where it would take days after a PM was performed to get everything back to normal. This was particularly true when many components that came in contact with the product being produced were replaced. I remember working with the quality people on many occasions to insure that every position on a multiple position machine was once again producing first quality product. Many times it required adjusting and/or replacing components that were adjusted or replaced on the PM.

How to Have a Successful PM Program

The key to a successful Preventive Maintenance (PM) program is scheduling and execution. Scheduling should be automated to the maximum extent possible. Priority should be given to preventive maintenance and a very aggressive program to monitor the schedule and ensure that the work is completed according to schedule should be in place.

Preventive Maintenance Execution:
Traditional preventive maintenance was based on the concept of the bathtub curve.

That is, new parts went through three stages, an infant mortality stage, a fairly long run stage, and a wear-out stage. The PM concept was to replace these parts before they entered the wear-out phase. Unfortunately, Reliability Centered Maintenance based on research done by United Airlines and the rest of the aircraft industry showed that very few non-structural components exhibit bathtub curve characteristics. Their research showed that only about 11% of all components exhibit wear-out characteristics, but 72% of components do exhibit infant mortality characteristics. These same characteristics have been shown to apply in Department of Defense systems as well as power plant systems. It is very likely that they apply universally as well. Therefore, they should be taken into account when configuring preventive maintenance on industrial equipment.

In order to have a successful PM program, the message is clear. The PM should focus on cleaning, lubrication, and correcting deficiencies found through testing and inspections. When there is a need to adjust or replace components, it should be done by highly trained and motivated professionals. Predetermined parts replacement should be minimal and done only where statistical evidence clearly





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indicates wear-out characteristics. In the absence of data to support component replacement, an age exploration program or the collection of data for statistical analysis to determine when to replace components should be initiated. Borrowing from the Japanese, lubrication points should be clearly marked with bright red circles to ensure that lubrication tasks are not missed. Cleaning should be carried out to remove dust, dirt, and grime because these things mask defects that can cause unplanned maintenance outages.

Motivating Preventive Maintenance Workers:
A quality preventive maintenance program requires a highly motivated preventive maintenance crew. To provide proper motivation, the following activities are suggested:

- Establish inspection and preventive maintenance as a recognized, important part of the overall maintenance program.

- Assign competent, responsible people to the preventive maintenance program.
- Follow-up to assure quality performance and to show everyone that management does care.
- Provide training in precision maintenance practices and training in the right techniques and procedures for preventive maintenance on specific equipment.
- Set high standards.
- Publicize reduced costs with improved up-time and revenues, which are the result of effective preventive maintenance.

In addition to explaining the importance of a good preventive maintenance program and the benefits that can be derived from it, training is probably the most effective motivational tool available to the maintenance supervisor.

Maintenance and training professionals have estimated that a company should spend \$1200 per year for training of supervisors and \$1000 per year for each crafts person. In fact, due to advances in technology, if the company has not provided any training for craftspeople in the past 18 months, their skills have become dated.

Conclusion

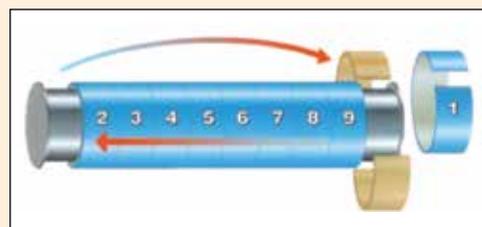
It is possible to have a successful preventive maintenance program. From a cost reduction viewpoint it is essential, but it does entail risk. When the proper care is taken, the risks, however, can be minimized. In order to minimize risk, preventive maintenance has to be carefully planned and carried out by well-trained and motivated workers. The biggest benefits of a PM program occur through painting, lubrication, cleaning and adjusting, and minor component replacement to extend the life of equipment and facilities.

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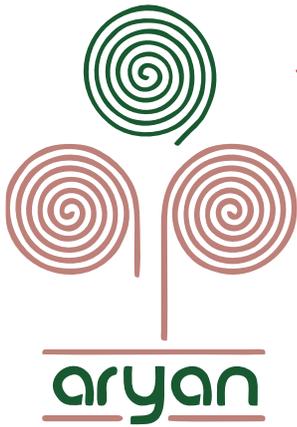
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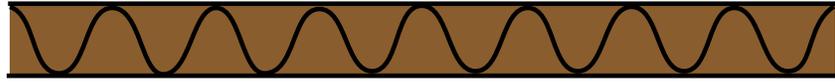
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A-Flute

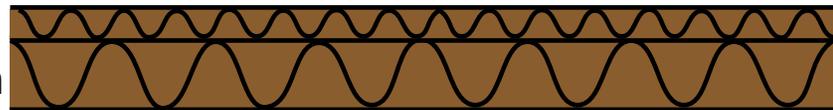


B-Flute



AB-Flute

7.5 to
7.8 mm



**" We offer Sheets manufactured on a
state of the art , modern**

European FOSBER automatic 5 ply corrugation line "

Maximum width : 2400 mm

Maximum Length : 4500 mm

Flutes : 3 ply or 5 ply , A+B Flute

Board Height : ~ 8.0 mm

Paper Gsm's : 80 to 400



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Dieboard Storage

It Pays to Store Dieboards Right

You spend a lot on your dieboards, so it pays to store them right!

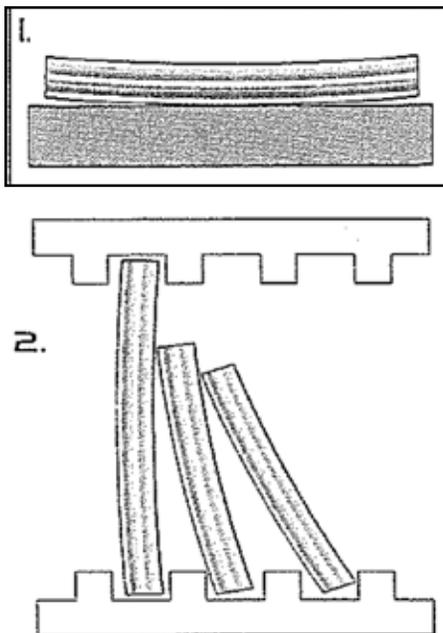
Considering the investment in laser cut tooling and the importance of optimal performance when the tool is used and reused, it is critical to store steel rule dieboards effectively. The problem is how do we store dieboards in such a way that they are easily accessible and yet protected from warping, cupping and twisting?

Flat storage

The traditional approach, a legacy of the multi-piece block dieboard era, was to store the dieboard flat on retractable wood shevles in a rack. Although this is convenient when used with an effective record location system, the dieboard has one surface protected from changes in moisture levels and one surface exposed. The result was the board would generally warp upward as the upper layers of the board gradually dried out or lost moisture (see Diagram 1).

Vertical storage

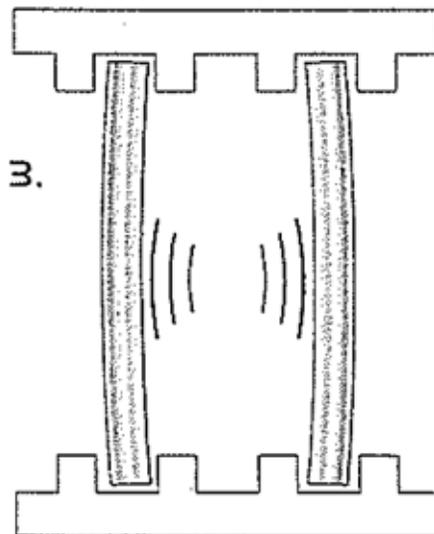
The most common approach requires storing dieboards vertically in a rack.



The problem in storing the board vertically, as shown in Diagram 2, was the great variety in board sizes made the use of the upper and lower track inconvenient and the results were usually as shown in Diagram 3 where multiple dieboards are stored leaning against each other to ensure consistent warping and damage!

Suspended storage

The most effective method of storing multiple sized dieboards is to suspend them in a standard racking component using pins inserted through holes laser cut into the dieboard. This has the advantage of easy dieboard insertion and removal and the ability to handle any dieboard size; and the exposure of all surfaces to the atmosphere ensures balanced moisture levels and board flatness (see Diagram 4).



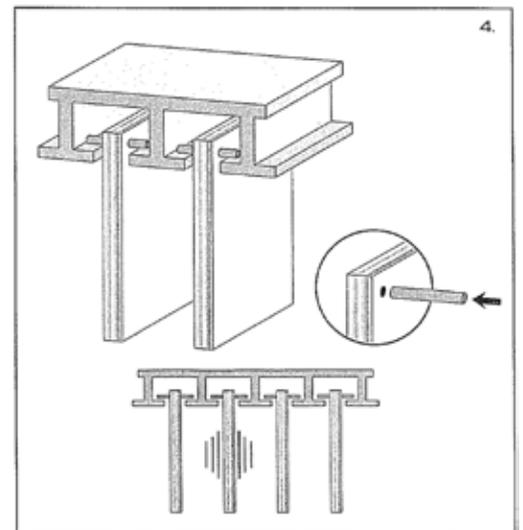
Kevin Carey

Die-Cutting Works, Inc., Seattle, WA, USA

Henderson Original rotary die storage

Rotary cutting dies are stored easily and efficiently in the Original Henderson storage rack. Dies are nested for maximum die storage in a minimum of space, and are safely kept and securely centered with our exclusive "lip" slide design (see Diagram 5). Plus our die location system, using Henderson labels, makes retrieval fast and easy.

Original rotary die storage rack systems are 80" high x 80" deep (203 x 203cm), with different widths to accommodate different die diameters. Original racks



Contd. on - 71



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- Edge Crush
- Ring Crush
- GSM / Substance
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- Tensile Strength
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Bursting Strength is a widely used measure of resistance to rupture in various packaging materials like Paper, Paperboard, Corrugated board, Nonwovens, Textiles, Geotextiles, Films, Tissues etc.

Models :

- Standard • Super • Double head • Eco Digi
- Micro digital • Micro print • Micro PC
- Available in two measuring ranges : 0-5 to 0-75 kg/cm².



GSM (Substance) Tester
Electronic model with 5 sample size measurement



Equinox Moisture Meter
Hand held Digital Moisture Meter imported from Germany for instant moisture results.



Compression Tester



Winner of Pacmachine 2008 Award

Four Models :

- Micro Print PC
- Micro Print (Microprocessor based Model with Printer Port)
- Micro Digital
- Touch Screen Display Micro PC

Compression Strength of a Box, Container, Tube, Drum, Bottle etc., gives a reliable indication of the overall performance of the package - besides indicating its ability to resist external compression loads during transit and storage.

Linux Compression Tester – MicroPC Touch Screen Model is an Indian Industry First and can be used for testing of Packages for stacking load, transit load bearing capacity.



Tensile Tester

Suitable to test tensile strength of paper, films, foils, rubber etc. Available in capacities ranging from 1gm. to 1000kgs. Various tests like tensile, adhesion, peel (90/180 degree) can be performed.



Tear Tester

Measures the force required to tear multiple sheets of paper



Puncture Resistance Tester

Five different scales to analyze materials of variable thickness.



Cobb Tester

Determining water absorptiveness of papers, boards etc.



Crush Tester

For testing paper, corrugated board and its components as well as performing compression tests on small packages.

Suitable to measure : Flat Crush Test (FCT), Ring Crush Test (RCT), Edgewise Crush Test (ECT), Pin Adhesion Test (PAT), Concora Medium Test (CMT) and Corrugating Crush Test (CCT).

Winner of Pacmachine 2006 Award



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.



Short Span Compression Tester (Sct Tester)

Equipment designed to perform Shot Span Compression Test and determining the compression strength on Fluting Medium and Test Liner papers within the grammage range of 100-400 g/m² units.

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Diagram 5

are also available in half-heights and half-depth configurations (see Diagram 6).

Each Original rotary die storage rack accommodates up to 16 cutting dies in multiple sizes. While only six common die sizes are shown, racks can be manufactured by our factory to fit any size die requirement.

The die transportation cart for Original rotary racks (see Diagram 7) features heavy-duty construction and allows for the transfer of six 66" (168cm) dies. The cart measures 48" (122cm) long and 54-1/2" (138cm) high, and comes in a variety of widths to accommodate different diameters. Each cart has a 500 lb (228kg) load capacity and sturdy 3/4" (1.9cm) plywood shelving at top and bottom so that smaller dies as well as other materials can be transported at the same time.

An "XL" cart is also available for 66" (168cm) dies that is 54-1/2" (138cm) high x 80" (203cm) deep and has six wheels—four swivel and two stationary (XL cart not pictured).

Henderson DRO and EVOL rotary die storage

Wagner Die Supply can supply specialized Henderson Storage Systems for just about any type of die, including DRO rotary dies (see Diagram 8) and EVOL rotary dies (see Diagram 9). These heavy-duty units are designed to be sturdy, durable and versatile. Transfer carts are also available.



Diagram 6

Henderson platen and Bobst die storage

Henderson's Bobst and platen die storage systems' adjustable racks allow for the safe, efficient storage of hundreds of dies, regardless of size and weight.

By using an inverted "T" and double "L" design, platen and Bobst dies are securely stored hanging on two pins (see Diagrams 10, 11 and 12). Position the beams based on your most commonly sized dies, and you will maximize the number of dies stored on each rack.

Both platen and Bobst storage sections can be combined on a single rack, and a label locator system makes die retrieval quick and easy,

Platen die storage racks store up to 177 dies, and the Bobst racks up to 90 dies. Standard units are 12' (3.7m) high (different frame heights are available), 10' (3m) long and 48" or 60" (122 to 152cm) deep. 5,000 lbs (2,268kg) can be carried on the lower 5" (12.7cm) channel beams, 6' (1.8m) from the floor, while the two upper 4" (10cm) channel beams can each hold up to 2,500 lbs (1,134kg).



Diagram 7

Each storage system is designed for maximum support, constructed of heavy gauge steel and triple-welded for superior strength and durability. They are easy to assemble using the heavy duty hardware that's provided with each unit.

Support pins are available in 3/16" (4.8mm) diameter by 1-5/8" (41.3mm) in length (see Diagram 13). To install support pins, drill 13/64" (5.16mm) diameter holes 7/16" (11.11mm) from top edge of the wood, on-center near the front and rear of the die. Pins are available in packs of 100.



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Diagram 8



Diagram 9

Platen and Bobst die transportation carts feature heavy duty construction, and are 48" (122cm) long, 62" (157cm) high and 27" (69cm) wide (see Diagram 14). They feature a 3/4" (1.9cm) plywood top and bottom so that smaller dies and other materials can be transported at the same time. The platen version can transport up to 11 cutting dies, while the Bobst cart moves three sets of dies and stripping boards.

EasiBlank™ hangers allow completed EasiBlank™ tooling to be stored in Henderson storage systems for platen dies, and transported in Henderson transportation carts for platen dies. Hanging brackets include thumb screws for easy and secure installation (see Diagrams 15 and 16). Hangers come in sets of two, one for the front and one for the rear of the blanker.



Diagram 10



Diagram 11

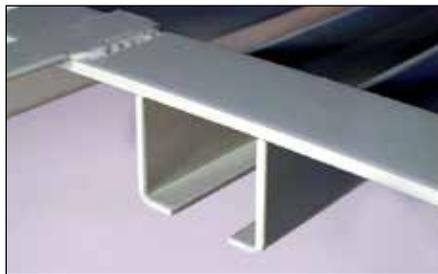


Diagram 12



Diagram 13

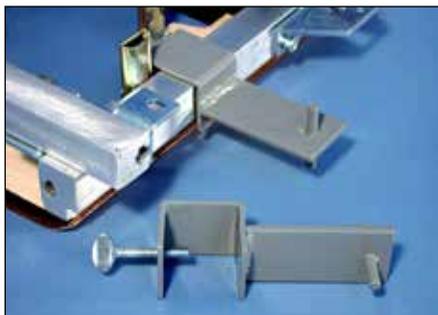


Diagram 14



Diagram 15



Diagram 16

Kevin Carey is the Technical Director of Die-Cutting Works, Inc., for productive excellence in diemaking, diecutting and converting. He may be reached at 1-518-932-7856 or by email at kevin@dieinfo.com.

For more information on Henderson storage systems, visit www.wagnerdiesupply.com.

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To be continued ... in April June 2017 Issue



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The Importance of Aerators and Pile Turners

In folding carton and corrugated plants the importance of having an aerator and pile turner is critical to the production of your diecutting equipment. These machines can be complex to simple, manual to automatic.

Equipment such as an aerator and pile turner can be integrated inline with modern printing presses, corrugator lines, laminators and all types of diecutting machines with which we are most familiar. Many types are available—portable, flush-mounted, pit models, in-feed and out-feed conveyor lines and pallet inserters—and are for use automatically (unmanned) in many modern automated plants around the world.

The types of aerators and pile turners include:

- Portable load turner
- Portable aerator and load turner
- Floor-mounted aerator and load turner
- Pit-mounted aerator and load turner

- Manual, semi-automatic and automatic
- Advanced systems integrated with existing printing presses, corrugator lines and diecutters
- Programmable aerators and load turners, which store repeat runs and settings

Aerator and pile turners need to be robust in nature; in our business, we are producing more products than ever, equipment efficiency is up and through put is increasing every day. During the box producing process, there are many hiccups that can occur that will affect your throughput: bad piles, sheets stuck together, different stock thicknesses within the pile, wrong pallets and damaged



John Dickison
Bobst North America Inc.,
Roseland, NJ, USA

sheets, usually near the bottom of the stack near the pallet.

Some systems are very advanced—they do not require human intervention and are totally interfaced within your operation, preparing loads for printing, diecutting and laminating with the help of advanced conveyor systems. These devices need to lift loads from 1,500 lbs (680kg).

Let's discuss the benefits of an aerator/pile turner within our converting processes.

Contd. on - 79



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- Longer machine life and less wear & tear of rollers by avoiding unnecessary heating.
- Reduction in over all electricity load.

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- Electricity savings due to usage of Precision-wound resistance wire, sized by a computer program resulting in uniform heating
- Higher durability and longevity due to stainless steel sheath material frame
- Greater operator safety due to Coil Insulation
- Lower break-down times due to easy replaceability of the heating rods

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Printing press operation

Printing presses today are running 18,000 sheets an hour, six pallets on average an hour. Some operations and printing presses require special pallets. When paperboard is coming from an outside vendor it arrives on wooden pallets; these need to be removed and replaced with non-stop pallets (see Diagram 1). Non-stop pallets are made of plastic and usually kept within the operation, not coming from the paper supplier.

Damaged loads need to be repaired—many times when paperboard is trucked in, the straps holding the loads together

loosen or break and loads can be in bad shape. All this can be repaired with a load turner. Damaged loads can be turned and aerated, bad sheets removed and the pallet changed. In advanced operations, the pallet changing can be automated with pallet storage and changing devices. (See Diagram 2) for automatic pallet exchange prior to printing using a load turner.

Flat diecutting operation

In diecutting, load turners provide many benefits. It's imperative these machine perform to their rated speed without stops; when compared to printing presses they

run only 2/3 as fast as the printing press. Many operations require two cutters for every printing press.

Feeder stops are common in this type of operation—in the printing operation, ink can be wet and coatings, especially UV coatings, can cause issues. Powder is used to coat each sheet to keep them from sticking together. But as physics plays a role, the weight of the sheets pressing against one another at times causes the sheets to stick together. Sometimes the loads will sit for long periods of time, days or weeks, and maybe even in the back of a hot tractor trailer. Ink and UV will dry; sheets will stick together. In diecutting we cannot process two sheets together—the feeder will pick them up and send them down the feed table; at the point the gripper bar will take the sheet, the machine will stop as the double sheet detector does its job.

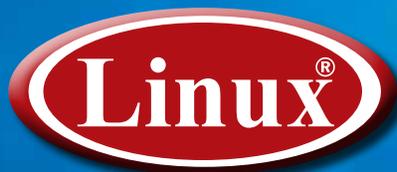
Feeder stops are common without an aerator in place. Each stop can be a few minutes long, and with each stop, the machine will take time to get up to speed again. Imagine five stops an hour on a 9,000 sheets per hour machine, each stop losing three minutes, for a total of 15 minutes of lost time. That is machine time worth \$250 USD an hour, so it is \$62 USD worth of stops. Look at it this way: on a 40" (101.6mm) machine at 9,000 SPH hour, 15 minutes of stops equals 2,250 sheets lost. If those finished sheets are



Diagram 2

Contd. on - 83





New

Crush Resistance Tester

Latest Innovation from Linux



LINUX CRUSH TESTER SERVO SUPREME MODEL

"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.

Specifications:

- Measuring range (Optional): 500 kgf
- Measuring Unit: kgf, lbf & N
- Least count: 0.1 kgf
- Deflection least count: 0.01 mm
- Accuracy: $\pm 0.4\%$ FS
- Test speed: 12.5 mm/min (changeable)
- Location Speed: 200 mm/min
- Platen Size: 130 X 130 mm
- Space between compression plate: 100 mm
- Supplied with attachments for testing RCT, ECT FCT. Other attachments at extra cost.
- Power: 0.75kw, 220 VAC, 50Hz Single Phase.

Standards:

Conforming to various National and International Standards

Features :

- The machine has Servo based control system capable of highly accurate precise load measurements and rapid data acquisition.
- High-stiffness and precision alignment from a linear bearing and integrated column design for more accurate results.
- The integral user interface consists of a control console with large, positive action cap sense keypad, allowing test to be performed at the touch of a button.
- Machine can be operated through PC and Control Panel.
- Used modern design idea of mechanical and electrical integration.
- Report is directly printed from the built-in Thermal printer
- A group of 12 test can be performed for report.
- Data management is easy. Users can create their own specific identification numbers and view data at any time. Stored data can be re-displayed or printed as a table, histogram, or a control chart.
- Accept or reject validation.
- Average of test results on report.
- Programmable User Name, Product Name, vender/ Customer Name, Codes, Lot Number etc.
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Diagram 3

All this is done with an aerator and pile turner.

Some corrugated printers deliver the load in batches—a batch printed side down and a batch printed side up. In this scenario, it is a manual operation to take the batches and either make them all printed side up or all printed side down. If you have an aerator, at this point it is not necessary for too much care to be taken in making a perfect load, just quickly stack them in the turner, which makes a good load when done.

Repair of loads

Many times loads are damaged in shipping. Loads can become damaged by fork trucks or straps or pallets breaking (see Diagrams 8 and 9). All this can be effectively and efficiently repaired with an aerator and pile turner: place the load on the turner, rotate with slight pressure and let the machine work its magic. Once you have the load back where it should be, you can loosen the pressure and remove damaged sheets and replace the pallet. You can also take many smaller loads with pallets, stack them in the turner and rotate to remove pallets and combine them into one load.

Advanced aerating and pile turning

For the most part, I've spoken about manual or semi-automatic aerators and pile turners. In advanced paper converting plants, there are more integrated systems moving finished printed loads to on-pallet conveyors to storage lines and then into the aerator and pile turner, where the pallets can be changed if necessary and aerated before entering the feeder of the cutter (see Diagram 10). Empty pallets can

worth just \$1 USD each, you lost \$2,250 invoiced dollars. It is clear the return on investment for a pile turner is not long, and the benefit is easily proven.

Loads coming from outside vendors that are already printed will be on wooden skids and these need to be changed out as well, preparing the load before diecutting. Aerating the load, separating the sheets and blowing out the powder from printing will eliminate feeder stops from sheets that are stuck together. In (Diagram 3), sheets are being fed into a diecutter running 12,000 SPH; aerating is more important for this to be successful. Without an aerator, diecutting operators need to fan sheets by hand prior to cutting. In (Diagram 4), the pile needs some work; the sheet will not feed properly, even for the US Mint. In (Diagram 5), the US Mint is aerating sheets with a light paper attachment. Note the green non-stop pallet in place. By preparing the load this way, the diecutting operator can reduce feeder stops due to sheets stuck together.

Corrugated operation

Pile turners are useful in corrugated operations as well, and I will talk about a few different processes. Corrugators who are laminating top sheets for printing can use aerators and turners. Top sheets are usually thin, approximately 0.010" (0.25mm), and it can be difficult to get a good pile needed for feeding and laminating. The highlighted area of (Diagram 6) shows sheets ready for laminating; (Diagram 7) shows feeding corrugated sheets in a flat bed diecutter with the printed side down. Aerating them will certainly help in feeding them.

Corrugated flexo printers are using vacuum transfer with the printing being done on the bottom of the board, and these sheets are delivered onto a pallet printed side down.

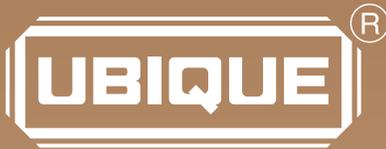
Some folding carton diecutters can cut corrugated board; that said, these are cut printed side up, so the load needs to be turned and, of course, the pallet aligned.

Diagram 4



Diagram 5





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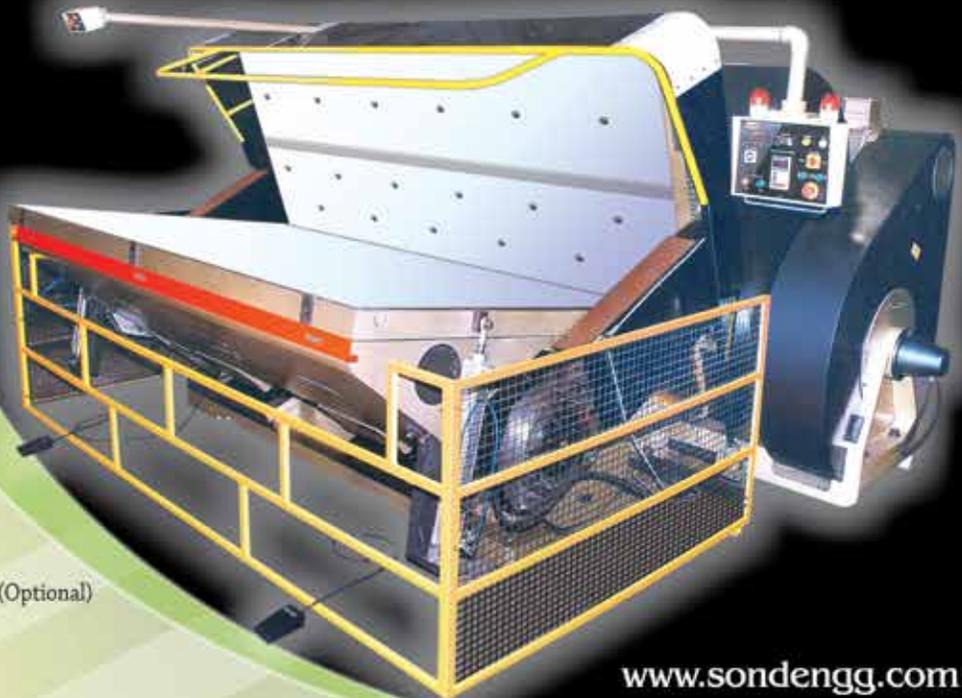
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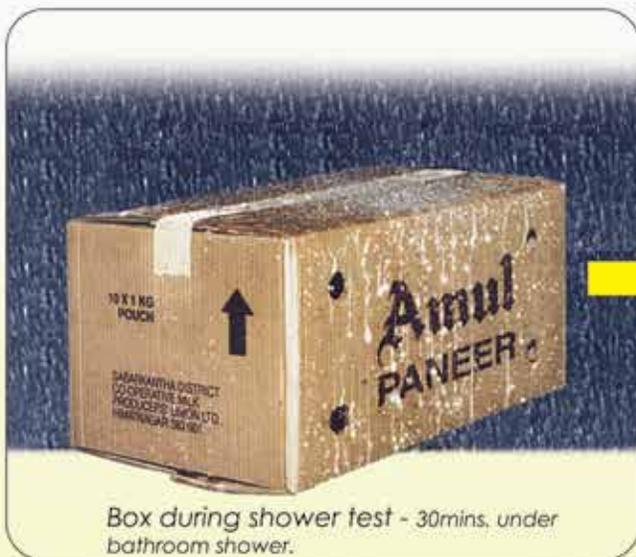
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| Cobb value | 35.0 | 19.0 | 15.5 | 8.5 | 2.5 |
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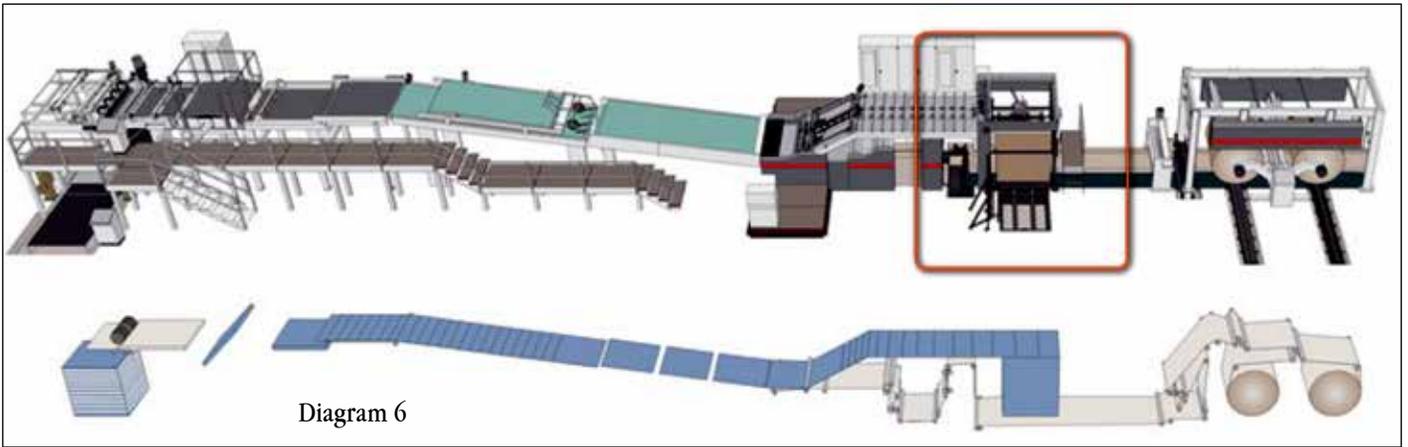
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be automatically removed and cycle to the end of the cutter for finished loads, all without the intervention of a human. This saves valuable time and reduces machine stops, allowing the customer to maintain a profitable product flow of material.



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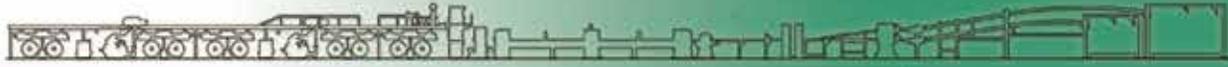
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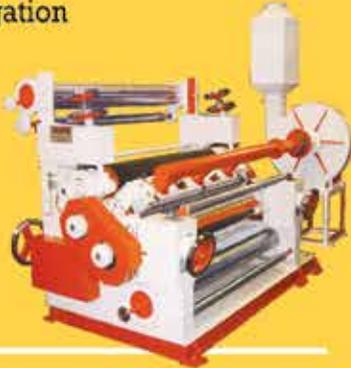
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Product Profile

Bennett Packaging Offers Affordable pallet skirts for digital printing

Bennett's digitally-printed pallet skirts offer higher print quality and improved speed-to-market.



Pallet Skirts, or Pallet Wraps, are produced out of corrugate and are designed to wrap around the bottom portion of a pallet display. Often seen in club stores, other than to cover up the pallet itself, pallet skirts are great marketing tools. With four, large panels to showcase the product, reinforce the brand and point out the product benefits, the entire story can be told.

Bennet packaging of Kansas City introduced a pallet skirt promotion to other corrugate converters in response to the increased discussion of digital printing for retail packaging and displays.

Bennett invested in a 6-color, production-speed, single-pass direct-to-digital printer from Barberan in 2015. Since the printer's installation, testing and experimentation

with color matching and board has been completed to optimize the output.

They are happy to share their experience and learning on Digital Printers in the industry that are either considering the purchase of digital printing equipment, or have clients that are asking about digital printing options.

A Welch's pallet skirt, produced by Bennett Packaging was recently recognized in the package PRINTING Excellence Awards with a second place overall in the "Best in Show" category. One of the competition judges stated: "The deep purple, life-like grapes had incredible detail in the graphics. Direct to corrugated digital is so new, it is amazing to see this level of print quality."

Bennett also walked away with first, second, and third place awards in the "Corrugated Digital Print" category.

Bennett's clients are experiencing higher print quality and an increased speed-to-market, according to the company. The users also have creative flexibility for regional messaging or testing, and there is a reduction in raw materials by taking out the litho-labels from the project.

Source: Internet

Chroma Print for DS Smith Celmach install a Chroma Print High Tech 2100 HBL in Galicia

Written by Daniel Brunton

Luca Celotti, Marketing Manager for

Celmach, has confirmed the company recently started up a Chroma Print High Tech 2100 HBL at DS Smith's plant in Vilagarcia de Arosa (Pontevedra). This is the latest model Chroma High Tech, with a format of 2100 x 1300mm; it is equipped with three colours, but has been delivered in such a way that additional printing units can be added at a later date.

This Chroma Print is equipped with a direct drive belt feeder controlled by Siemens independent motors, which is suitable for fine flute corrugated board. The press also features a quick set-up system for the changing of the stereo during production, as well as the new Celmach wash up system managed by Siemens PLC with double peristaltic pumps. The machine is also equipped with a Celmach infrared drying system and sheet ejector for quality control.

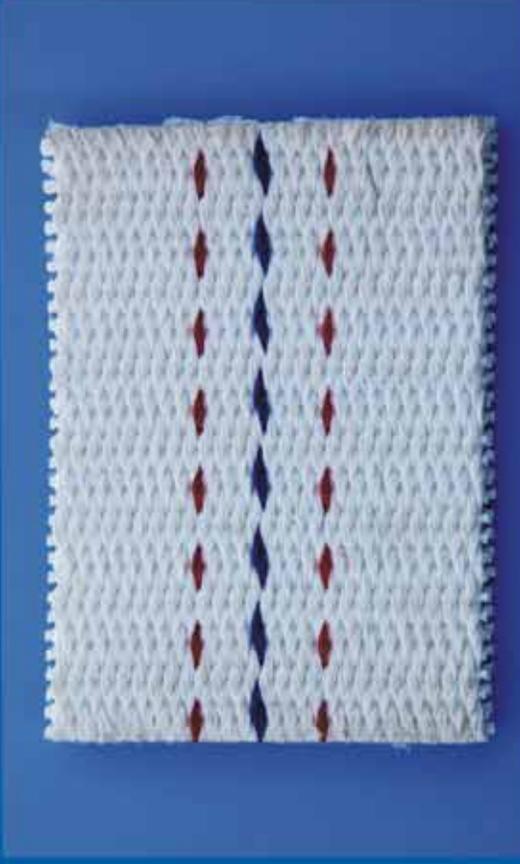
"Chroma Print allows DS Smith Galicia to have significant additional capacity thanks to the quality of printing achieved in this new machine," explains Mr Celotti "Capacity increases can also be achieved thanks to being able to prepare the next job during production."



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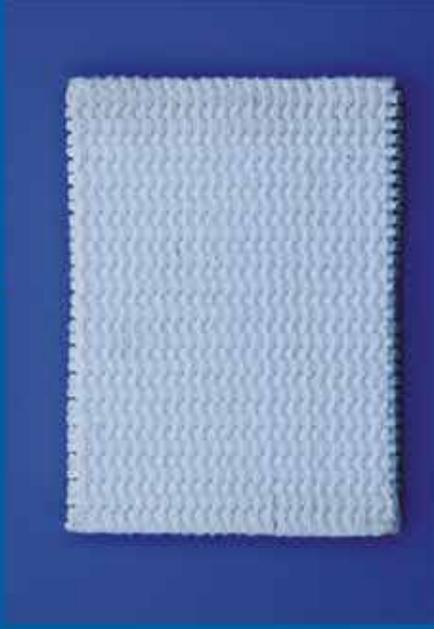
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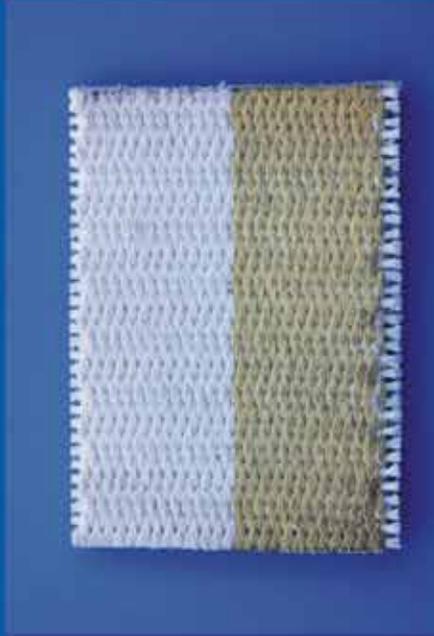
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Mr Celotti continues, “We have had some good success in the Spanish market. Over the last few months, some of the leading Spanish companies have put their trust in our technology by placing orders for the new model of Chroma Print. With the first installation at DS Smith in Galicia, we are proud of this success, proving once again that our machines are a good alternative. The fact that leading international groups are buying our machines confirms our technological solutions are helping boxplants to become more efficient and produce higher quality work.”

DS Smith Tailor-Makes Boxes To Reduce Packaging Waste

It is reported that packaging and recycling company DS Smith will be trialling a machine that can create boxes to fit the specific dimensions of particular products, following an industry-wide trend of eliminating unnecessary packaging.

Its machine is less wasteful, able to tailor-make packaging, and could cut shipping costs for retailers by half. It can produce 1,000 bespoke boxes per hour – about a tenth of the speed of a traditional box-making machine.

Excessive packaging is an environmental and logistical problem for many retailers. Online retailers, such as Amazon, often get criticised for sending small items in swathes of bubble wrap and oversized boxes.

“For an e-retailer with a reasonable range of products to sell, it is very difficult to



stock enough different sizes of standard cartons to cover all the possibilities without having some wasted space at least some of the time,” the publication quoted DS Smith chief Miles Roberts as saying.

Empty space in packaging takes up extra room on transport trucks, costing retailers more to ship, as pricing is based on volume, rather than weight.

If the technology is successful, such machines could become more mainstream, as the online shopping industry tries to reduce its environmental impact.

Source: *Internet*

EMBA 245QS Ultima offers capacity & flexibility

The fully integrated servo platform and modular design of the EMBA 245 QS Ultima™ offers outstanding capacity and flexibility. Fast and cost-efficient, the EMBA 245 QS Ultima™ can produce all types of boxes, from the simplest brown box to the highest quality printing and most complex die-cut formats. The EMBA Operator



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Source: <http://www.emba.com>

CONPRINTA goes digital

CONPRINTA, a market leader in industrial preprint, is complementing digital preprinting technology to meet industry demands perfectly. The advantages of digital print are quite interesting for the corrugated industry as they fulfill the desire for economical short runs and higher end graphics. Nonetheless, the corrugated industry seeks low cost production and effectiveness. As a matter of fact, digital ink costs for boxes with extensive color coverage are much higher than like-for-like ink costs of conventional flexographic printing ink for the same color coverage.

CONPRINTA has addressed this inherent challenge of digital preprint systems by developing and launching its CONPRINTA SVS unit. With this unique CONPRINTA system, users cannot only apply inline spot overprint varnish but also classic flexographic inks. Double Print? No, CONPRINTA will only print on those areas of the image where digital would cause extensive ink consumptions. Digital printing technology would assure highest end screen graphics and variable data (customization). Resulting flexo plate costs are minimized as flexo setup and plate



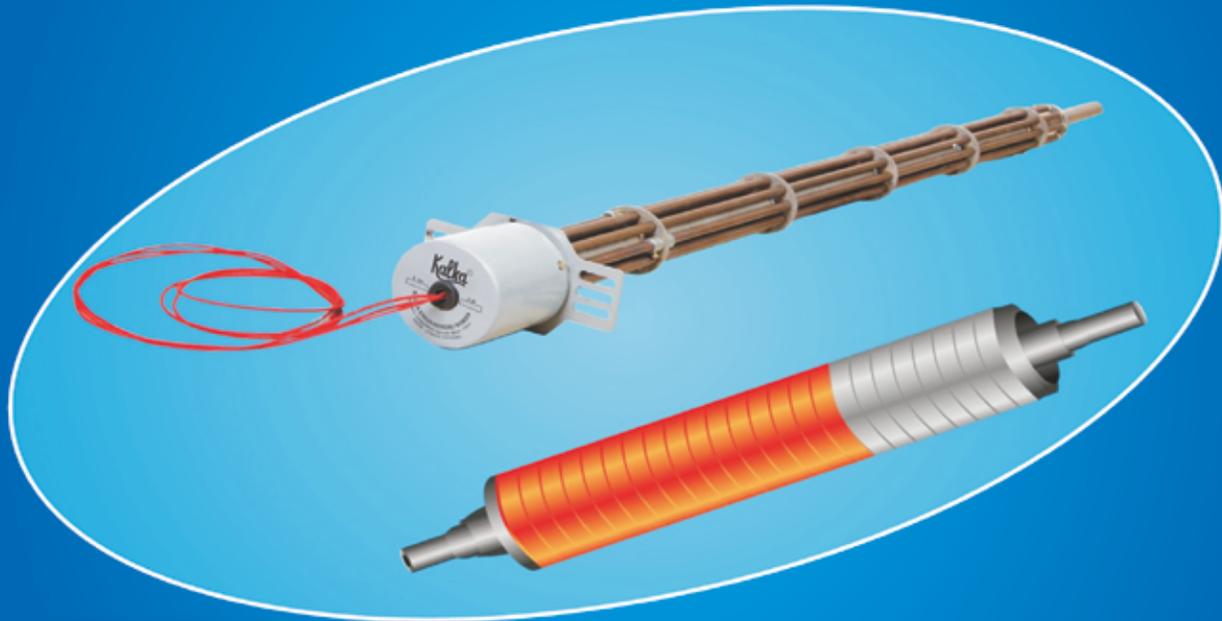
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Easy to install and easy to maintain.

No need of separate machine for small and big sizes thus a big saving in small investment.

Reduce wear and tear of machine by avoiding unnecessary heat.

PANEL BOARD WITH TEMPERATURE CONTROLLER

Temperature controller helps in reducing electricity consumption & wastage by automatically switch off the heating after reaching at desired temperature

TUBULAR HEATING SYSTEM

Insulated with Magnesium oxide Powder

Insulated powder is compressed by swager for long life

Tube used are SS 304/ Incoly tube

80/20 Nichrome alloy wire from U.K. for Element

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Website : kalkaheater.com

is limited to just a few inline spot colors. Due to the unique CONPRINTA “Change on the Fly” system, the conventional CONPRINTA deck can be quickly set and changed to a different spot color or OPV varnish. The result is a real inline “Hybrid” where Digital and Flexo image parts can be combined for the ultimate benefit of the user.

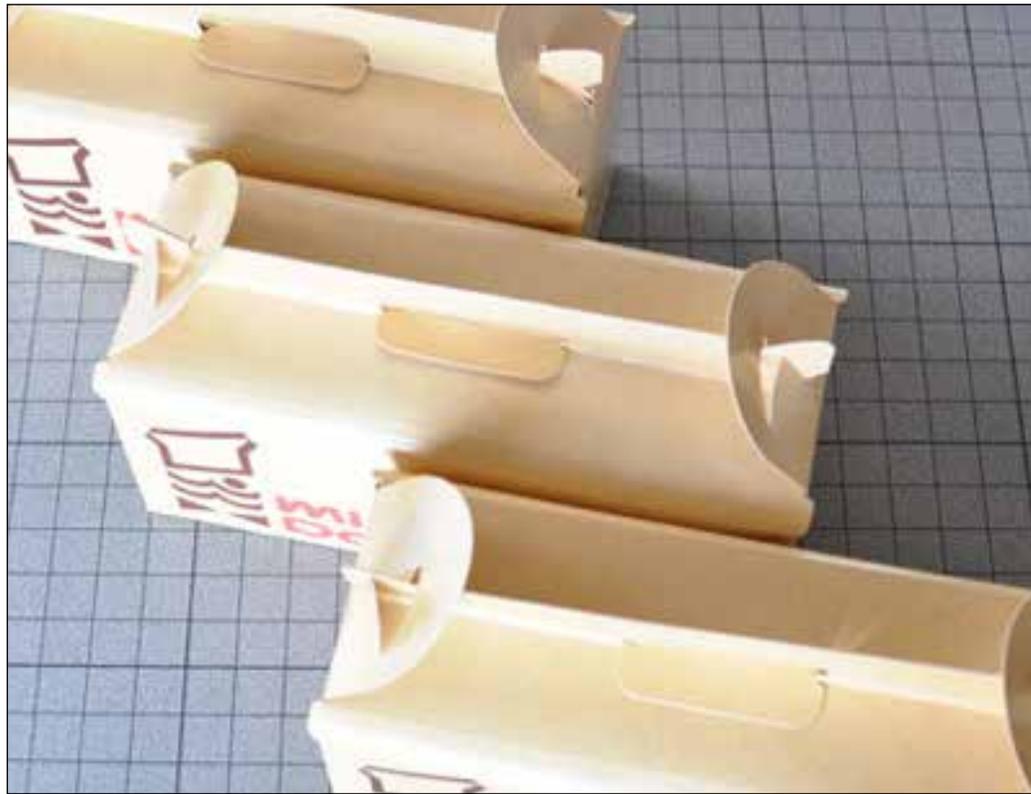
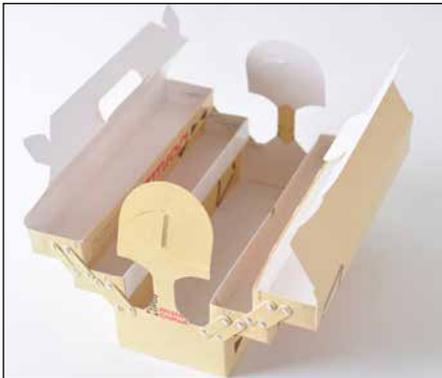
With its open architecture, CONPRINTA virtually hits no limits to be linked with digital roll-to-roll printing technology.

At CONPRINTA, we define the benchmark when it comes to cost-effective and highly flexible on demand graphic box production.

Source: <http://www.container-board.com>

Mister Donut - The Box Creates Large Transformation and Unexpected Luxury!

Once in Taiwan there was a wave of people queuing up for Mister Donut at the Japanese Donut Store. It also made the people for developing the habit of eating



a variety of different flavors of donuts as afternoon tea dessert.

Another choice - in the external packaging also provides a drawable carton to facilitate the guests to pick their choice of donuts.

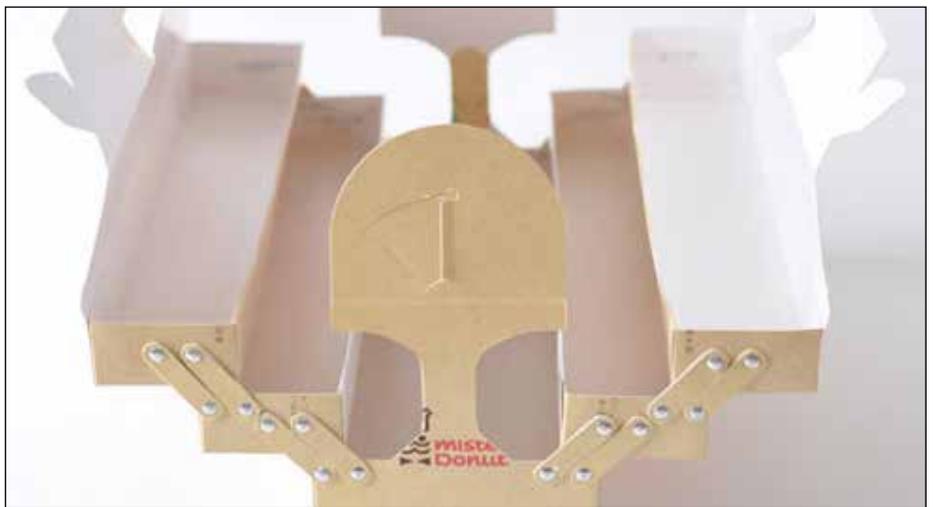
At first glance, Mister Donut’s outer box is not so new, and from the details you will find the carton seems to have been cut into three layers, and in the side there is a similar rivet device.

The carton opened, actually shows a super-expansion of the layers of space, ‘like a Tool Box’!

The original design uses three large boxes to create the transformation, in order to innovate such a surprising paper toolbox!

After the transformation, the carton can be used by ladies to keep some personal things in a total of five compartments.

If you enjoy donuts really, seeing such a creative carton should also be very interesting!



Contd. on - 103



Quality and

ELCorruMatic® TCCM – Total Corrugator Control Module

The quality module with positive effect on the productivity

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- Temperature control
- Moisture measuring
- Glue gap control
- Paper gap control
- Control of the contact pressures in the Single Facer
- Control of the pressure elements in the Double backer

For any query, please contact :

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The productivity module with positive effect on the quality

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- Splice synchronisation
- Master roll splice
- Splice tracing

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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) | | |

Mirri Wows Retail Brands With Unboxing Experience as Luxury E-Commerce Packaging is Unveiled

As the trend for unboxing luxury packages has been sweeping the internet, with YouTube now featuring almost 40 million videos, the world leading supplier of metallic paper and board, Mirri (a division of Celloglas), has launched a new product, expanding on their traditional services and highlighting their commitment to innovation in support of luxury retailers and their creative agencies.



Celloglas has launched the Mirri Wow Pack, providing bespoke luxury e-commerce packaging, after conversations with some of the UK's leading luxury brands looking to improve their omni-channel retail experience.

With an array of industry research illustrating that consumers rank packaging almost equal to the brand when it comes to what's important for overall satisfaction with a product ; that consumers are likely to repeat purchase from an online merchant that delivers premium packaging; and that half of customers expect online orders to arrive in premium packaging if that same retailer provides branded packaging in-store, the Mirri Wow Pack has been launched to help luxury brands deliver better e-commerce experiences.

Mark Askham, Mirri Development Manager at Celloglas said: "With the luxury eCommerce market predicted to grow to 70 billion by 2025 it's long overdue for luxury retailers to ask themselves: why are only 4% of luxury sales eCommerce? Consumers are expecting more than the standard brown cardboard box from omni-channel retail now - it really is time to up the anti".

As well as being a way to add value to a product, the Mirri Wow Pack also provides added protection of the product inside due to the qualities of the metpol, ensuring the product is delivered to customers in excellent condition, and should it need to be returned, the packaging helps ensure items remain in a condition suitable for re-sale, reducing loss from returns that have been damaged during transition. The box also features a tear-off section which reveals an adhesive strip, allowing the customer to easily re-package their returns.

"Often overlooked by brand managers, packaging can play a major role in "non-conscious priming," the sensory and environmental factors that give consumers emotional cues on the context and "premiumness" of their experience. The key concepts in the integrated sensory approach of sensory branding, sensory congruence and sensory experience need to be addressed within e-commerce packaging".

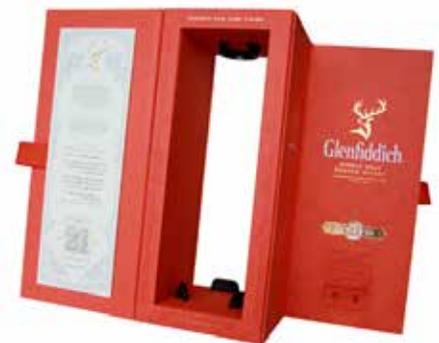
Conprinta goes even bigger

Pre-print press now available in 2.8m

Conprinta has now added a 2.8m pre-print machine to its product range. The requirements of the corrugated industry for a 2.8m wide printing system has led us them to this development.

The first 2.8m machine is due to be installed at a customer site in the summer of 2017. The press features Conprinta's patented Belt Technology, meaning the use of sleeves or cylinders is not necessary. By using light-weight belts, set-up is significantly easier compared to conventional printing systems, so that even shorter orders can be produced economically.

"This flexibility of handling many short orders has enabled a new generation of preprint systems, known as 'Hybrid' systems. Our print and varnishing units are ordered in-line with digital web-fed printing systems to enable the optimum in quality, cost and delivery flexibility by combining digital inkjet and analogue flexo. Customers can react to the trend towards smaller batch sizes, customisation, faster response times and simpler order processing.



CORRUGATED MOBILE STAND

Corrugated is a fascinating material. Besides facilitating making boxes for a variety of products, it inspires you to create things 'Out of the box' - like furniture, partitions and more.

Here is what a School Kid 'Crafted out of Kraft'!

Created by Ms. Gurleen R. Bburjee

GUM POWDER PLANT FOR PASTING & DEXTRINE

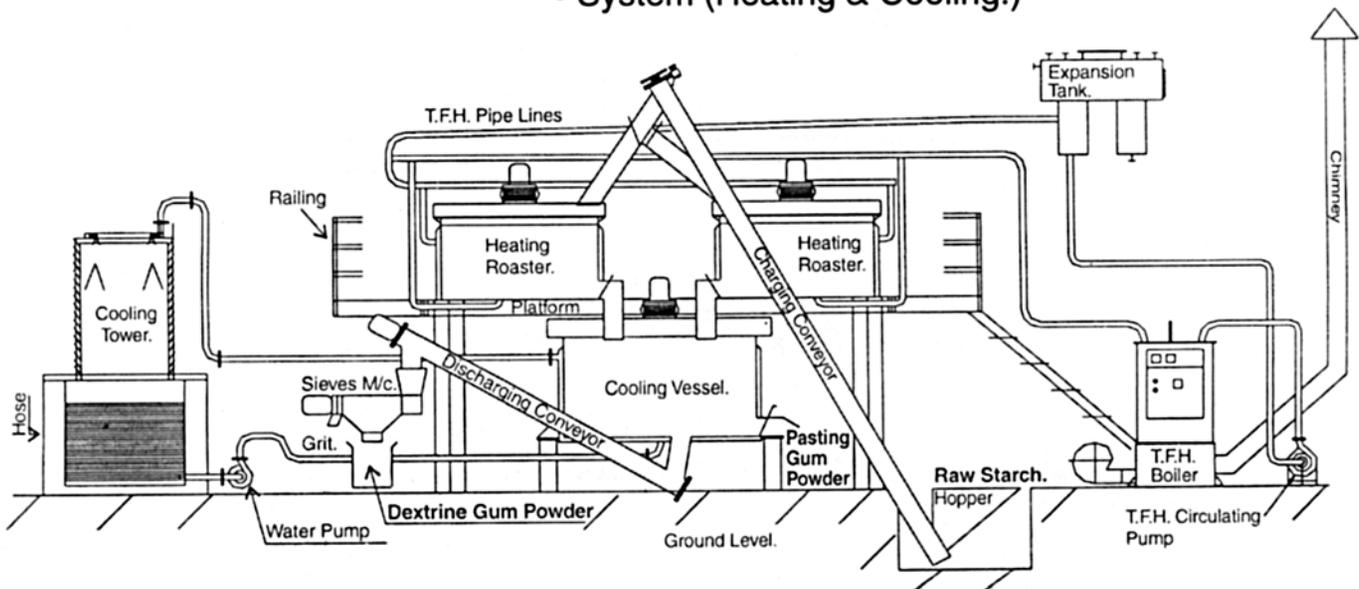
PLANT CAPACITY : 2 Tones / 4 Tones Per Shift

Feature:

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

OTHER PRODUCTS.

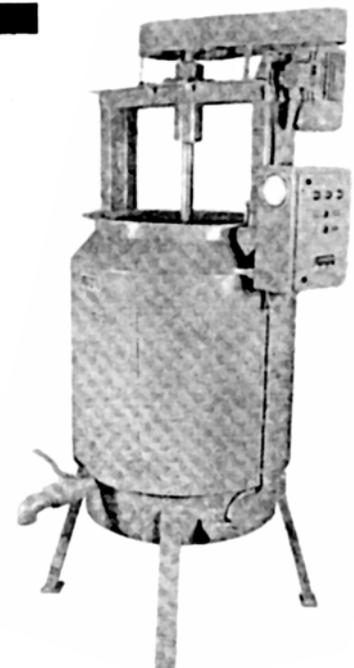
- Liquid Gum mfg. Plant
- Gum Cooking Vessel.
- Synthetic Resin Plants.
- Fast Cooling System.



GUM MIXING (COOKING) VESSEL

Total solution For Cooking the Gum from powder Adhesives

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- To boil Glue
 - To Cook Gum / starch
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 - Lower Labour cost / maximum time saving.
 - 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.
 - Long Life
 - Lowest Maintenance.
 - No consumption of heating oil.
 - No electrical Hazards.
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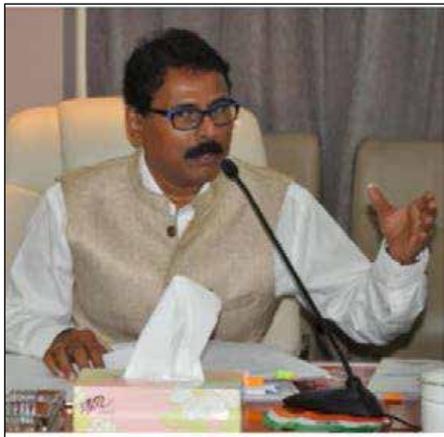


Industry News

FAPGA News

FAPGA (Forum of Asia Pacific Graphic Arts) held its 15th conference at Shanghai during Oct. 2016. The four day conference was filled with very useful seminars presented by world renowned speakers on printing and packaging technology.

In the words of Peter Lane, President FAPGA The present trend shows that the commercial printing, on a global basis, is on the increase despite the strong presence of internet in everyday life.



The export figures of printed materials from developing countries to under developing countries are very high compared to previous years. Those printers who are hesitant in changing their conventional method to the changed technology are facing some problems. It is essential that we have to move with the change and add the services that are relevant to modern business so as to ensure the existence.

Mr. R. Suresh, Our Chief Editor is the Secretary General of FAPGA .



J. S. Machine holds JETS300 corrugator Open House in Turkey

Written by Daniel Brunton

Stay on top of the latest and greatest

On 17th-18th December, J. S. Machine held a dedicated Open House event to showcase its JETS 300 corrugator. The event was held at J. S. Machine customer, Atasan Ambalaj in Turkey. Over 70 customers from five countries attended the show.

The installation of the corrugator was started in August and the machine was put into full production in November.

This corrugator is designed to run at 300m per min. with a working width of 1.8m.

The manufacturer explains that the JETS300 corrugator has many features to assist in the efficient production of high quality corrugated board. Thanks to its intelligent controls, less labor is needed to run the line, it is energy efficient, all of which brings greater ROI for companies who choose this machine. During the show, the corrugator was seen running at an average speed of 286m/min for single wall board production.

Source: International Paper Board Industry



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Collaboration between Messe Düsseldorf India and the Indian Institute of Packaging from 2017



New event Pacprocess India in combination with the established IndiaPack with accompanying ISPI Conference

The organisers, Messe Düsseldorf India and the Indian Institute of Packaging (IIP), have agreed a collaborative venture. From next year onwards, the two organisers will bundle their expertise in the packaging sector and the related processing industry with a focus on the Indian market. In October 2017, a combination of Pacprocess India, now realigned by Messe Düsseldorf India and IndiaPack, an event created by IIP and well established in the Indian market, is planned for New Delhi. Pacprocess is a further development of the International PackTech India, previously organised with the involvement of Messe Düsseldorf until 2016.

In the future, Messe Düsseldorf and its Indian subsidiary will be responsible for the strategy, conceptual planning and implementation of the trade fairs as well as for national and international marketing. The events form part of the interpack alliance, comprising the international events of Messe Düsseldorf in the areas of processing and packaging. The trade fair trio will be supplemented by a conference, the International Summit for Packaging Industry (ISPI), planned and organised by IIP.

Source: Internet

Mondi Receives Two WorldStar 2017 Packaging Awards

International packaging and paper producer Mondi has received two WorldStar 2017 awards for its IceBox and Queen Display designs.

The celebrated designs come from facilities within its corrugated packing segment: Mondi Tire Kutsan, in Turkey, for its Queen Display; and Mondi Grünburg, in Austria, for its IceBox design.

The 100% recyclable Icebox format got the top spot in the Food category. It is coated with a special paper surface treatment



(Mondi's Paratherm mix) to improve the performance of the corrugated box in cooling and freezing situations. It also amplifies the effect of ice packs and crushed ice and absorbs any meltwater.

Queen Display, which won in the Point of Sale category, is an environmentally friendly concept for the floriculture sector. The corrugated board prevents damage to flowers during transport and doubles as a stylish display solution. In addition to preventing flower damage and waste during shipment, the packaging uses 51% less material than other options.

The product innovation manager at Mondi Corrugated Packaging, commented, "We are proud that two of our designs received acknowledgment from the international jury at the WorldStar Awards 2017, as they underline the potential of paper-based material in developing innovative packaging solutions. For us, this award is a

proof of our passion for developing cutting-edge solutions in a sustainable way."

This year's WorldStar Awards competition had entries of over 291 packaging projects from 35 different countries.

Winners will be celebrated on 4 May 2017 in Dusseldorf, as part of the Interpack 2017 exhibition.

Source: Internet

Henkel sets compelling ambition for 2020 and beyond

Henkel presented its new strategic priorities and financial ambition, which will shape Henkel until 2020 and beyond – summarized as "Henkel 2020+". Based on its strong foundation, Henkel aims to generate continued profitable growth by focusing on four strategic priorities: Driving growth, accelerating digitalization, increasing agility, and funding growth.

"We will build our future on a strong foundation, which will enable us to



generate sustainable profitable growth in the coming years. We have an excellent track record of outperforming our markets, a balanced and well-diversified business portfolio with exciting brands, innovative technologies and leading positions in highly attractive markets and categories – and a passionate global team with a strong culture, common purpose and shared values," says Hans Van Bylen, Chief Executive Officer of Henkel.

Source: www.henkel.com

Contd. on - 111

Shear LINE



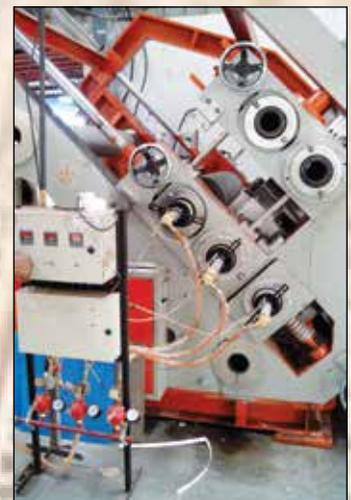
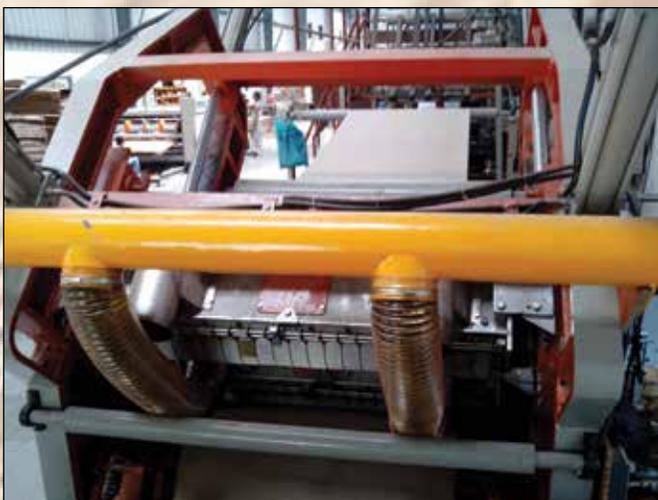
New

Fingerless Double Profile Single Facer



Superior Technical Features

- **Design Speed:** 70Mt/Min.
- **Available Sizes:** 12" [300 mm] AND 14" [350mm]
- Vacuum Suction Fingerless Design driven by heavy duty blower provides perfect flute formation
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- Corrugated Rolls Made of Special Alloy Steel.
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THE FUTURE OF FRESH PRODUCE PACKAGING

The future of fresh produce packaging is in focus in the latest issue of Stora Enso's Viewpoint. This Viewpoint edition covers trends in consumer preferences and packaging for the fruits and vegetables category as well as how these are impacting business for brand owners and retailers.

Category volume growth is stagnant. A telling example is Poland which has strong GDP growth, but the volumes

for fresh produce declined by -1% CAGR between 2010-2015 and the forecast up until 2020 is a mere 2% CAGR. Neighboring markets show similar growth patterns.

“Key for creating value in the fresh produce category is to understand how consumer desires can be translated into new and better packaged products. Packaging innovation can help both by driving topline growth and increasing margins by reducing waste levels,” says Björn Thunström, SVP Marketing & Innovation, division Packaging Solutions. “An obvious

conclusion from talking to leading retailers is that they expect increased use of packaging in this category.

The report highlights three key topics that shape packaging strategies in the fresh produce category:

1. Consumer desires as a route to value growth – Consumers want to lead a healthy life and fruits and vegetables can be the answer, but not the way they used to. Consumers want a better quality of life and this means convenience.
2. Retailers expect more packaging, not less – Selling packaged fruits and vegetables rather than in bulk has many advantages. The quality and freshness can be increased. Waste can be reduced. Prices can be increased.
3. How packaging innovation can make fresh produce more valuable – Several examples are provided on how packaging can make fresh produce tastier and more premium, but also help consumers navigate busy shelves.

Source: www.storaensopack.com



Corrugated for packing apparels

Innovative way of packing a shirt is designed to delight the customer.

The pack turns into a hanger for display in a retail store



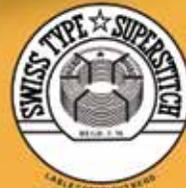
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FCBM Publications

| | |
|--------|---|
| 3:90 | Corrugated Box Manufactures' Practical Standards – Standard Test Method for Bursting Strength of Corrugated fibre board |
| 4:90 | Proceedings – Technical Sessions of Conference 1982 – 1990 |
| 6:91 | Corrugated Box Manufactures' Practical Standards – Standard Test Method for Puncture Resistance of Corrugated fibre board |
| 7:91 | Corrugated Box Manufactures' Practical Standards – Nomenclature: A Glossary of Terms related to the Corrugated Packaging Industry |
| 8:92 | Corrugated Box Manufactures' Practical Standards – Standard Test Method for Water Absorption (COBB Method) |
| 9:92 | Technical Information Booklet – Variable Speed Drives for Corrugated Machines Standardisation of Electric Motors for Corrugated Box Manufacturing Units |
| 10:93 | Corrugated Box Manufactures' Practical Standards – Standard Test Method for Grammage of Kraft paper and Corrugated Fibre board |
| 11:94 | Technical Information Booklet – Adhesives |
| 12:94 | Technical Information Booklet – Box Styles |
| 14:96 | Corrugated Box Manufactures' Practical Standards – Standard Test Method for Compression Strength of Corrugated Box |
| 15:97 | Corrugated Packaging Brochure |
| 16:97 | Technical Information Booklet – Industry Survey - 1996 |
| 17:97 | Operational Manual ACS (Ver 4.2) (Account Computing System) |
| 18:98 | Technical Information Booklet – Industry Survey - 1997 |
| 19:98 | Corrugated Box Manufactures' Practical Standards – Standard Test Method for Ring Crush Resistance of Paper and Paper board |
| 20:99 | Technical Information Booklet – Industry Survey - 1998 |
| 21:99 | Corrugated Box Manufactures' Practical Standards – Standard Test Method for Moisture Content in Paper and Paper board |
| 22:00 | Technical Information Booklet – Industry Survey - 1999 |
| R 1:00 | Corrugated Box Manufactures' Practical Standards – Box Dimensions, Styles, Mfrs. Joints |
| 23:02 | Technical Information Booklet – Industry Survey - 2001 |
| 24:02 | Project Report (Full Version) |
| | i) A study on the Important Properties of Kraft paper at Different Climatic Conditions |
| | ii) A study on the influence of Properties of Kraft paper on the Properties of Corrugated Board and Box at various climatic conditions |

| | |
|-------|---|
| 25:02 | Project Report (Condensed Version) |
| | i) A study on the Important Properties of Kraft paper at Different Climatic Conditions |
| | ii) A study on the influence of Properties of Kraft paper on the Properties of Corrugated Board and Box at various climatic conditions. |
| 26:03 | Technical Information Booklet – Industry Survey – 2002 |
| 27:03 | Proceedings – Technical Sessions of 31st Conference 2002, Mumbai |
| 28:03 | Proceedings – Technical Sessions of 30th Conference 2001, Chennai |
| 29:04 | Corrugated Box Manufactures' Practical Standards – Standard Test Method for Thickness of Board |
| 30:04 | Technical Information Booklet – Industry Survey – 2003 |
| 31:05 | Proceedings – Technical Sessions of 32nd Conference 2003 |
| 32:05 | Proceedings – Technical Sessions of 33rd Conference 2004 |
| 33:05 | Technical Information Booklet – Industry Survey – 2004 |
| 34:06 | Proceedings – Technical Sessions of 34th Conference 2005, Bangalore |
| 35:06 | Technical Information Booklet – Industry Survey – 2005 |
| 36:06 | Technical Information Booklet – Units of Measurement and Conversion Factors |
| 37:06 | Technical Information Booklet – International Rules for Corrugated Board and Cases |
| 38:07 | Proceedings – Technical Sessions of 35th Conference 2006 |
| 39:07 | Technical Information Booklet – Restricted Heavy Metals Specification in packaging Material |
| 40:07 | Technical Information Booklet - Guidelines for- Designing Heat Transfer System using Heat Transfer Fluids |
| 41:08 | Proceedings – Technical Sessions of 36th Conference 200 |
| 42:10 | Proceedings – Technical Sessions of 38th Conference 2009 |
| 43:11 | Proceedings – Technical Sessions of 39th Conference 2010 – Interactive DVD |
| 44:11 | Technical Information Booklet - Industry Survey - 2010 |
| 45:12 | Proceedings – Technical Sessions of 40th Conference 2011 – Interactive DVD |
| 46:12 | Technical Information Booklet – Scoring Allowances and Blank Size |
| 47:14 | Technical Information Booklet – Tolerances for Regular slotted containers (RSC) |



7 Dedicated Production Solutions at SinoCorrugated 2017-Exclusive Interview with General Manager of SinoCorrugated: Mr. Alex Wang

SinoCorrugated 2017 will be grandly launched on April 11-14 at the Shanghai New International Expo Centre in China as the focus of Chinese corrugated packaging industry in 2017. The show will be held together with SinoFoldingCarton 2017 and China Packaging Container Expo 2017 to occupy 8 exhibition halls with nearly 110,000 square meters of exhibition areas. Its scale has far exceeded SinoCorrugated 2015: by the end of January 2017, 93.4% of the overall exhibition areas have been filled, while 442 Chinese and international leading brands are confirmed as SinoCorrugated 2017 exhibitors.

Meanwhile, as of February 17, the onsite pre-registration number has been boosted up to 50,841 persons, which covers diverse professional buyers with high purchasing power. In general, the quantity of both exhibitors and audiences will far surplus SinoCorrugated 2015. I believe that SinoCorrugated 2017 will be one of the most rewarding professional corrugated expo throughout the history.

For the sake of providing suitable production and management solutions for Chinese and international packaging enterprises at different levels of development, and to systematically display the future of the industry, SinoCorrugated 2017 will showcase 7 effective production & management solutions featuring cutting-edge processing technology:



Solution for Raw Paper Procurement and Management Solution for Energy Saving, Pollution Reduction and Waste Collection & Recycling Solution for Intelligent and Cost Effective Paper Board Manufacturing Corrugated Box Pre-Printing Solution Solution for small-batch ordering and digital printing of corrugated boxes Solution for Efficient Printing & Converting module Integration Solution for Intelligent Logistic and Storage Management Equipment Configuration

These selected solutions aim to resolve challenges in the contemporary folding carton and corrugated industry, covering the entire corrugated packaging production chain: from the raw paper procurement –

corrugated board production - printing - die cutting - stitching and gluing - intelligent logistics – to delivery of finished products. There will be a suitable solution available for every corrugated packaging enterprises at SinoCorrugated 2017. Packaging enterprises at various stages of development can find customized solutions for their own benefits.

It is believed that SinoCorrugated 2017 will be one of the most rewarding professional corrugated expo throughout the history. Let us look forward to hearing good news about the International Exhibitor Pavilions, exciting onsite events and registration of international buyers at SinoCorrugated 2017.



The 3-in-1 Mega Expo for the Whole Packaging Industry Chain

Nearly **110,000** sqm exhibition area

Nearly **1,100** exhibitors

65,000 local and international visitors

Some **1,800** corrugated and folding carton manufacturing equipment

Nearly **1,200** kinds of consumables



SinoCorrugated 2017

Shanghai New International Expo Center, China April 11-14, 2017

Concurrent Exhibitions



Organizer



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Strategic Cooperative Partners



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Organizer



Forthcoming Events

29 March - 02 April 2017



Icorrugated Expo 2017

National Exhibition and Convention Center
Shanghai - China

Many innovations in Icorrugated Expo 2017, like focusing on intelligent manufacturing, special zone exhibition, multi-language guide service, 1,000 square meters global reception center, China-European International Technology Summit.

Shanghai Icorrugated Exhibition Services Co., Ltd.

Delegation Association Service & Cooperation:

Contact : Vurtne Luo
Mail : vurtneluo@icorrugated.com
Tel. : 0086 13438982223

11 - 14 April 2017



Shanghai

New International Expo Center, China

Reed Exhibitions will host SinoCorrugated 2017 from April 11 to 14 in the Shanghai New International Expo Center, China. The exhibition area will increase to 11,000 sqm for a show expected to achieve better results than even the outstanding 2015 edition.

For information, please contact:

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Fax: +86-21-2231 7183

Email sinsia.xing@reedexpo.com.cn

4-10 May 2017



interpack is the essential event for the food, beverage, confectionery, bakery, pharmaceutical, cosmetics, non-food and industrial goods sectors. No other trade fair in the world presents the entire supply chain. At no other trade fair does the packaging industry provide all sectors with tailored solutions and innovative designs based on such a variety of materials, and it is, of course, THE event for the packaging industry.

4-6 August 2017



PackPlus 2017

Pragati Maidan, New Delhi, India.

The packaging market in India will see next level of growth with the ten fold rise in Indian middle class population and the world's giant multinationals taking rapid strides in India's food, beverage, health and beauty, and pharmaceuticals sectors.

With every edition, PackPlus is emerging more successfully as a business platform for both visitors and exhibitors. Explore a gallore of opportunities related to packaging converting, processing and supply chain industries.

17 - 19th October 2017

ICCA AND WCO – 2017 SUMMIT

Venue: the Costao Do Santinho Resort in Florianopolis, Brazil. Hosted by Klabin S. A., the event will include general meeting sessions with speakers from around the globe addressing containerboard and corrugated issues and opportunities, networking and social events including a spouse/companion tour and a Klabin paper mill tour.

The Global Summit brings together containerboard and corrugated industry leaders from around the globe. The 2017 event builds on the success of previous Summits. For additional information: www.iccanet.org

26-28 October 2017



Pragati Maidan,
New Delhi / India

The organisers, Messe Düsseldorf India and the Indian Institute of Packaging (IIP), have agreed a collaborative venture. From next year onwards, the two organisers will bundle their expertise in the packaging sector and the related processing industry with a focus on the Indian market. In October 2017, a combination of pacprocess India, now realigned by Messe Düsseldorf India and IndiaPack, an event created by IIP and well established in the Indian market, is planned for New Delhi. pacprocess is a further development of the International PackTech India, previously organised with the involvement of Messe Düsseldorf until 2016.





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Booth: N3A15
Date: 11-14 April, 2017
Venue: Shanghai New International Expo Centre