



The Corrugator

OFFICIAL MAGAZINE OF FEDERATION OF CORRUGATED BOX MANUFACTURERS OF INDIA

July - September 2015



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SMART PACK & PRINT EXPO 2015
Corrugated Packaging & Printing Exhibition at KOCHI, KERALA
20-22 November, 2015

Organized by: **Kerala Corrugated Box Mfrs. Association**
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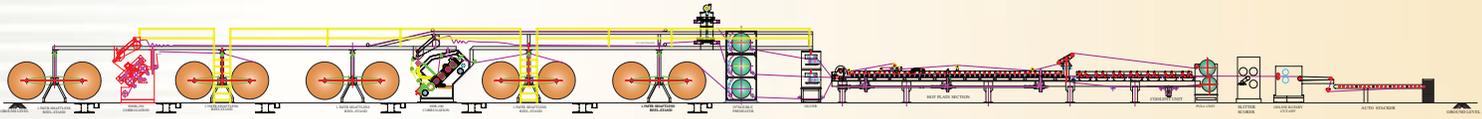
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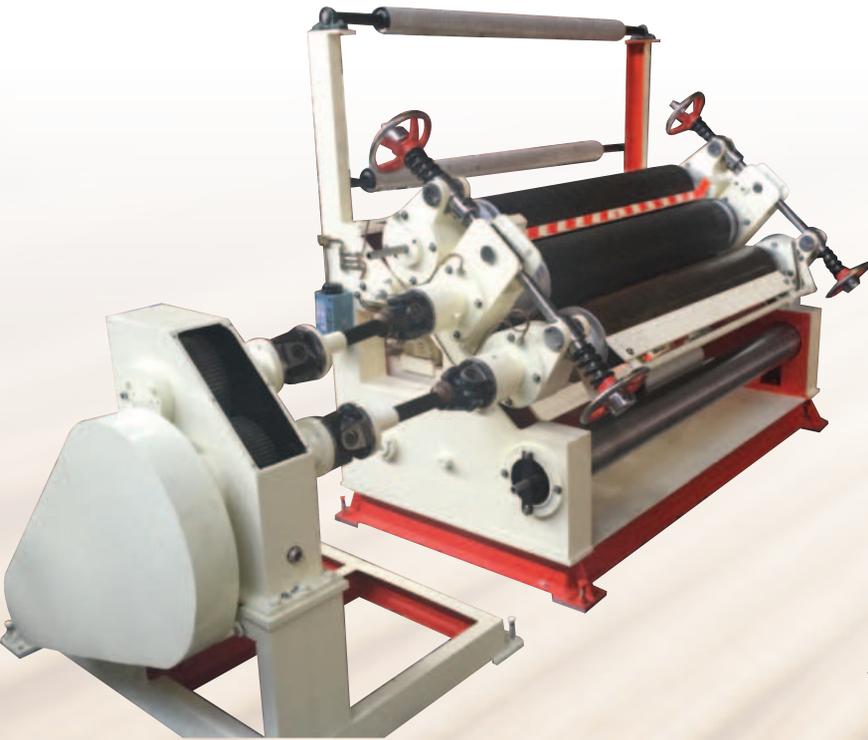
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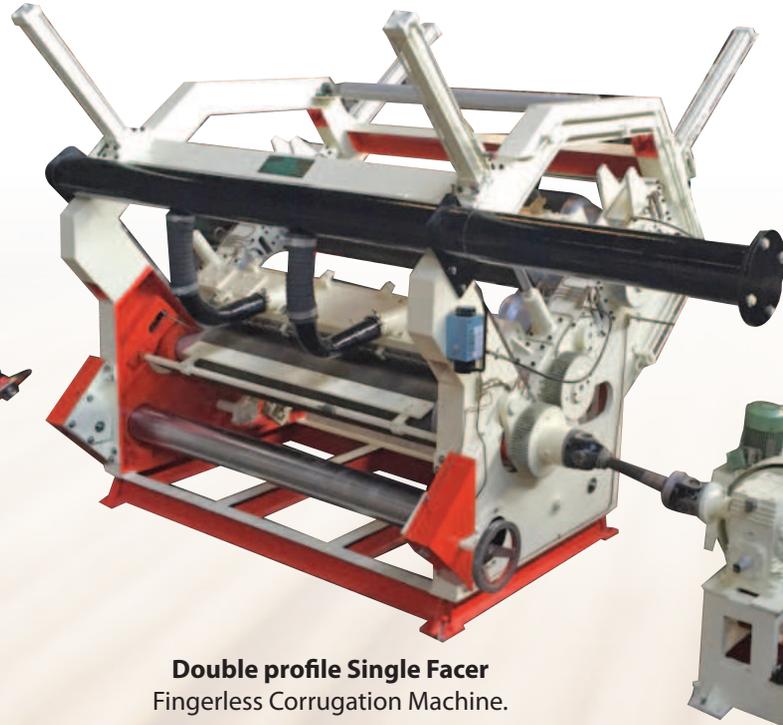
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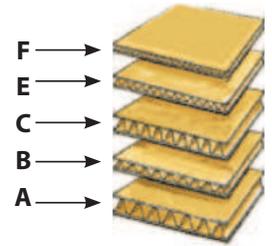
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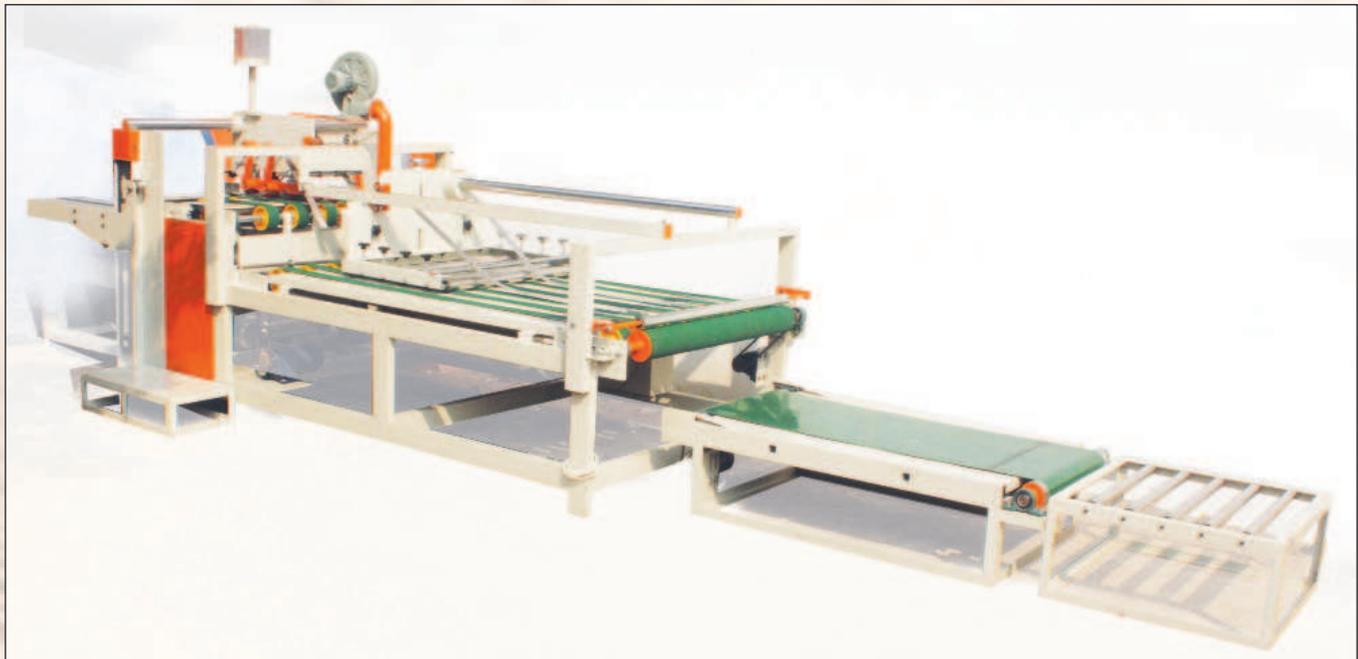
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Min. Feeding Size (mm)	350×600	350×600	350×600
Skip Feeding Size (mm)	1500×1900	1500×2300	1500×2700
Max. Printing Size (mm)	1100×1750	1100×2150	1100×2550

Guang Dong Tai Yi Packaging Machinery Co.,Ltd

Add: Xiangluo Jitingwei, Pingnan, Guicheng Street, Nanhai District, Foshan City-528251, Guangdong Province, China



Guang Dong Tai Yi Packaging Machinery Co., Ltd

TG High Speed Machine with Vacuum Transfer



TD High Speed Machine Roll to Roll Transfer



Main specifications:

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Model	TG920 (TD920)	TG924 (TD924)	TG1224 (TD1224)	TG1228 (TD1228)	TG1624 (TD1624)	TG1628 (TD1628)	TG1632 (TD1632)
Max.Machine Speed (sheets/minute)	280	250	230	220	200	180	180
Max. Feeding Size (mm)	900×2000	900×2400	1200×2400	1200×2800	1600×2400	1600×2800	1600×3200
Min. Feeding Size (mm)	300×500	300×500	365×685	365×685	450×765	450×765	450×765
Skip Feeding Size (mm)	1100×2000	1100×2400	1500×2400	1500×2800	1900×2400	1900×2800	1900×3200
Max. Printing Size (mm)	900×1960	900×2360	1200×2360	1200×2760	1600×2360	1600×2760	1600×3160
Min. Slotting size (L: mm)	230×60×230×60	230×60×230×60	260×60×260×60	260×60×260×60	280×80×280×80	280×80×280×80	280×80×280×80
Max. Slotting depth (mm)	225	225	300	300	400	400	400

Tel: (0086)-0757-8127 0573/ 8676 4263

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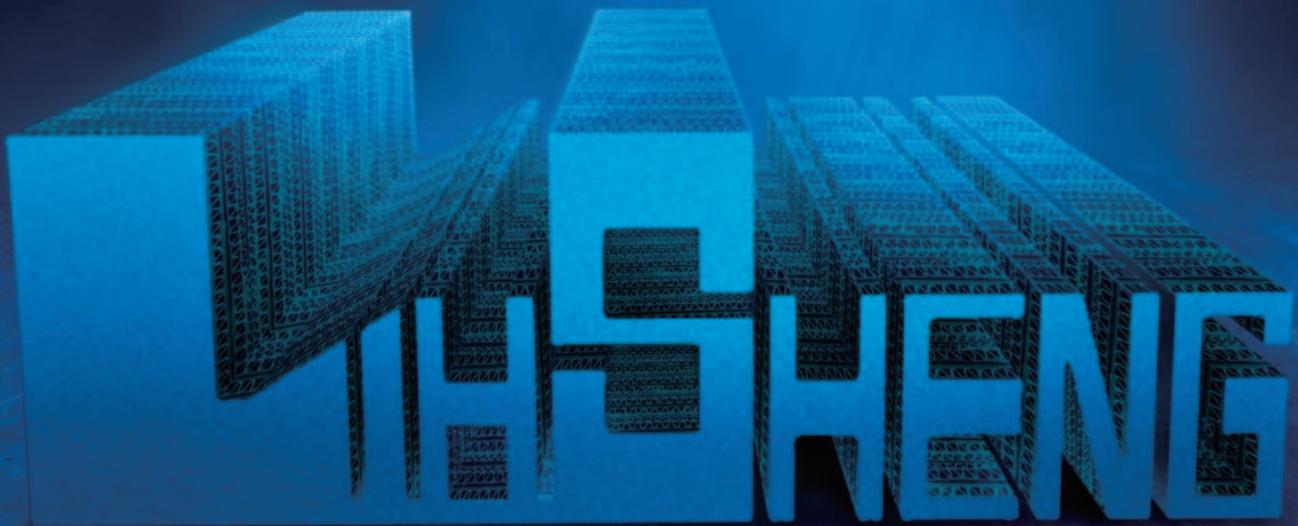
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Content Highlights



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Design & Production:

Print Links

Bldg. H-4,
Flat No. 2 (Lawn side)
Jankalyan, Bangur Nagar,
Goregaon (West),
Mumbai - 400 090.

Tel.: 2877 2890

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Printed at:

Rajesh Printouch, Mumbai



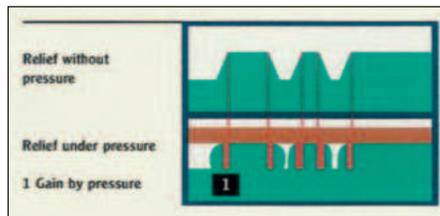
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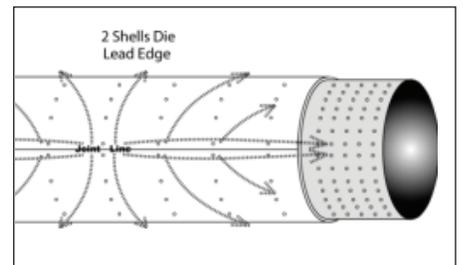
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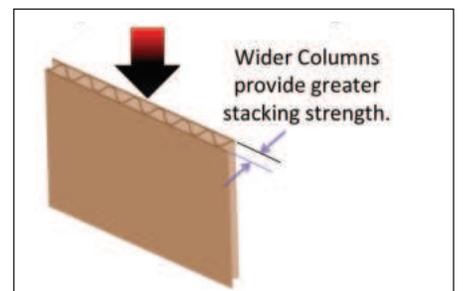
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SFSCT-CNC Series

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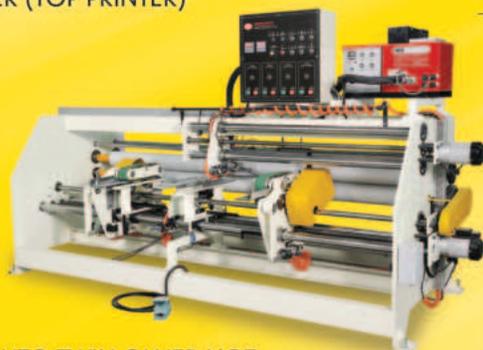


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THE EDITORS' PAGE



R. Suresh



Pulkit Shab

We are passing through volatile times due to global markets melting down. However it is good to know that India is intrinsically strong to be long affected by such global virulence in markets.

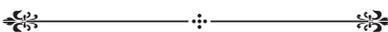
The continuing slide in the Chinese markets - combined with weakness of the rupee, strong selling by FIIs and below-normal monsoon are issues that are concerning.

Global sentiments have taken a big precedence over domestic factors. And in the next two weeks, several potential market-moving news, including the possibility of a US interest rate hike, are expected.

Finance Minister Arun Jaitley said the Factory output data showed that the economy was on the growth path. The growth in manufacturing, led by consumer durables and basic goods, is a positive development for the economy. These figures are consistent, and need to be read with the growth in indirect tax receipts. It is especially notable that simultaneously inflation has declined to 3.8%, with food inflation being only 2.2%.

Responding to 39% increase in indirect tax receipts, chief economic adviser Arvind Subramanian said it indicated that the underlying momentum in the economy continues to improve across all sectors.

Multilateral agencies including International Monetary Fund (IMF) have said India remains a bright spot against the sluggish global economy. Macroeconomic fundamentals remain sound and there are signs of a rebound in several sectors of the economy. Growth is expected to be around, 7 - 7.5% while the government is confident that it could comfortably reach 8%.



There is a general consciousness on quality upgradation in our industry. With more and more new educated entrepreneurs entering the industry, the emphasis on quality and productivity is on the increase. Added to this is the severe competition and cost cutting.

Like in any other industry, the customer has a wide choice. So it is essential that a box maker etches for himself a unique capability which would insulate him from competition. We have to evolve ourselves with innovative, capabilities and competitiveness.

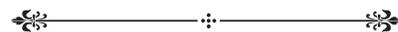
Innovation is the key to success.

Innovation cannot spring from a closed and restrictive environment. As Satya Nadella and Sundar Pichai said, "in the right setting, everything is possible."

Bringing about that right setting in our units... in our thinking... and in our management... is essential.

Survival of the fittest is more true today than anytime before. So it is essential that we survive and grow. Technology upgradation and emphasis on quality is the key.

Technical Seminars, Conferences and Educational Courses contribute to making our industry focus on quality and technology upgradation.



WICMA Symposium at Goa was a highly successful, well organized event. The FCBM Managing Committee Meeting was also hosted by WICMA. Two memorable days in the mesmerising state of Goa.



We are all now looking forward to the 44th FCBM Conference. Kerala CBMA has been making elaborate efforts to make the Conference a truly global event. We are sure members across India will congregate in large numbers and make the conference a grand success.



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PRESIDENT'S MESSAGE



P. S. Shah

Dear Friends,

I had attended a very gratifying get together at Goa.

The FCBM Managing Committee Meeting was hosted by WICMA – which had organized their Annual Event – WICMA Symposium. I was quite impressed by the way such a grand event was organized.

Speaking at the WICMA Symposium, I deliberated on the theme 'Corrugated Packaging for Perishable goods'.

Perishable goods category has a wide range of products – from fish & fish products to fruits and vegetables.

It is expected that marine products export will boost upto 6.6 billion US \$ in 2015 - 16 as against US \$ of 5.5 billion in 2014 – 15. Even the International Monetary Fund's Managing Director Christine Lagarde has said that India has the potential to double the size of it's economy by 2019 compared to 2009. So the growth of our Industry is very bright.

The journey of our industry so far has been very impressive but the road ahead is still long and we will not rest till the unmet demands of packaging in several sectors are met by innovation to the full satisfaction.

Much of our journey to development is still ahead of us and we will pursue a more sustainable path to prosperity. We do this with commitment to our future.

We are conscious of our challenges and are fully confident of leading in packaging in near future.

The turbulence in markets seem to be settling down. India is in a strong position not to be unduly affected by such a global forces. We are strong in fundamentals and despite these temporary ruffles the outlook on Indian economy continues to be strong and positive.

Industrial output growth rose 4.2% in July, faster than downwardly revised 3.8% expansion in June. The rebound was led by a turnaround in the manufacturing sector, which rose 4.7% in July compared to 2.9% growth in the year earlier period. The turnaround in consumer goods and consumer durables also augured well while the capital goods segment rose 10.6%.

An analysis of the data by the finance ministry said the manufacturing sector is slowly emerging as a leader of industrial growth.

A string of recent data has pointed to green shoots of recovery in the economy and the government is confident of achieving 8% growth in the current fiscal.

We are all eagerly awaiting our 44th FCBM Conference to be hosted by our little brother KeCBMA. 'God's own Country' will play host to the FCBM Annual Conference for the first time.

The Conference will also give me the satisfaction of having journeyed through a gratifying tenure as President of FCBM. It has been a pleasure interacting with many of you.

Let us all meet at Kochi and make the Conference a memorable one.

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Understanding Proper Machine Calibration

As we move into the last quarter of 2015, we should continue to take time to review our business models and manufacturing costs. This industry needs to continuously respond to an ever-changing market. In previous articles, I have discussed the concept of a more pro-active management style. I discussed paying closer attention to specific converting machines and their settings. Flexos and Die Cutters contribute a considerable portion to our bottom line and we need to look at ways to improve our skills and machine performance. Everyone is always looking at ways to improve throughput, produce less waste, and improve quality.

In my recent years, working in plants in many different countries and cultures, I feel that there is merit in analyzing our manufacturing style in the area of what causes our Flexos and Die Cutters to “stop.” We call that “Unscheduled Downtime”. It is important to note the fact that when machines are not running, they are adding costs to the process and producing zero revenue.

In our box plants, converting machines stop for different reasons.

- Mechanical Issues.
- Scheduling errors.
- Jam Ups.
- Improper Tooling (Worn or Damaged).
- Order Changes (Excessive Set-up Time).

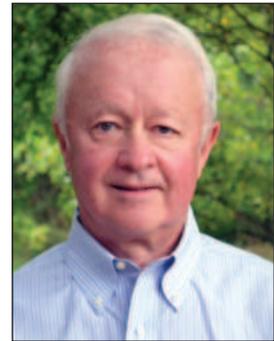
We need to manage and better understand this part of the process.

I know that our sales people work hard using all their creative skills in order to bring business to the plant. As this economy seems to be inching its way in the right direction, we must be very specific in determining what business to bring to each machine center. We should be very selective and careful so that everyone understands and respects our minimum and maximum sizes at each press. I do believe that “information type” sales meetings are

in order today just be sure that the sales people bring the right size and type business to each machine center in the plant. Our CSR people also need to focus their efforts on size scheduling, delivery information, and supplying properly designed tooling for each machine center.

How do we respond to this challenge? One way is to reduce the downtime on the floor. Generally speaking, Flexos and Die Cutters contribute \$450.00 per hour to pay the bills. This includes labor, paper, benefits, fixed costs, overhead, cutting the grass and plowing the snow. This converts to \$7.50 per minute. My point is how many extra \$7.50 minutes does each plant spend setting up the machines for the next order? We know that we charge a standard number (set-up fee) for each order but who pays for the excessive time? How do we count set-up time? When is the set-up complete? This can be a grey area and manufacturing needs to discuss this and better define these activities.

All machine manufacturers use the same basic method for machine set-up techniques. We call it the “Time and Register” settings. This calibration tool is a very simple and is the single largest tool that contributes to increasing throughput and better managing downtime in the plant. How do we do this?



Dick Target
“On Target Consultants”

The “Time” refers to zeroing the gear train in the press. The zero point on every press is in the feed section. We measure this from the point at which the lead edge of the sheet starts its journey through the press. Once that point is established and understood, we then place the Timing Dial on the operator’s side of the feed section on Zero. Note: We do this when the press is in the open position. We then go to the 1st print station and locate the Timing Dial on the side frame. Close the 1st print station to the feed section. Lock the gear train. Locate the Timing Dial and reposition the dial so that it is on the zero mark. Repeat this procedure for the 2nd Print Station to the 1st Print Station. Repeat the same exercise for all the print stations. Once again, repeat the same process for the Slotter Section and or the Die Cut Section to the last Print Station. The intention here is to have all the timing dials on zero when we close the press sections to each other. This then gives the crew the ability to open and close the various sections of the press without the pinion gears bumping heads. In order to sustain this calibration, the timing dials must always be on zero before the press is closed. If the timing marks are not on zero and are off by three inches, the register will be off by exactly three inches. This now completes the first portion of the “Time & Register” calibration setting.

Cont. on - 17

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- Rub Proofness
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- Stiffness Strength
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Super Model



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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

Two Models :

- Electronic model with 5 sample size measurement
- Manual model with 2 scales of 0-250 & 0-500 gsm.



Gann 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.



Winner of Pacmachine 2006 Award

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).



Vibration Tester

Simulates the conditions that occur on a package during transit. Gives an indication of the ability of the package to resist such transit stresses and protect packed products.



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.



Drop Tester

Determines the performance of a packed box during handling and transportation.

All Linux equipments conform to National Standards (IS, FCBM) and International Standards (TAPPI, ASTM, ISO, BS, AS/NZ, SCAN, DIN, etc.)

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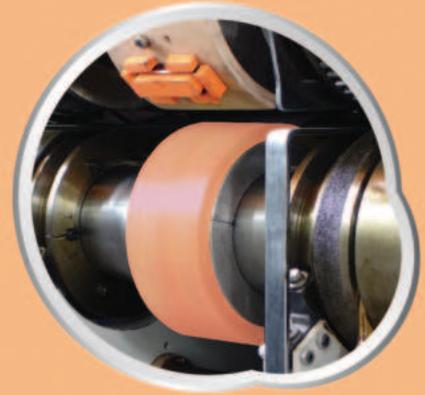
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The “Register” portion of the calibration refers to having a fixed reference point for each Register Compensator in the press to the zero point in the gear train. Specifically, this refers to each of the Print Stations, Die Cut Section, and the Slotter Section. We will now calibrate the register compensators to the gear train. By completing this calibration, we will now accurately predict the arrival time of the Lead Edge of the sheet and coordinate this point to the printing plates and cutting dies as it arrives in the various sections of the press on its journey to a finished product.

How do we do this?

First of all, we need to accurately set the height of the machine’s front stops. This assures accurate delivery of each sheet as it travels to the first print station. This correct tool for this is a Front Stop Gauge. The caliper or the gauge of this front stop should be 0.057” +/- depending on the plant. The number also changes for setting “E” Flute and Double Wall. See attached for review:

We then proceed with the following:

- Ink up the Print Stations all with different colors.
- Mount one calibration test printing plate on each print station. {Mount the plate as follows: Mount an arrow on

the Mylar where the tip of the arrow is exactly 2” (50mm) from the mounting strip.

- Make a test cutting die. It should be at least 8” (200 mm) square. Locate four mounting holes on each of the four corners to match the appropriate cylinder size. On the Lead Edge, draw a line between the centerline of the

Plate info the TIP of the Arrow is exactly 2” from the mounting strip



mounting holes across the wood. Mount a chevron so that the tip of the chevron just touches the zero line drawn across the wood. This becomes

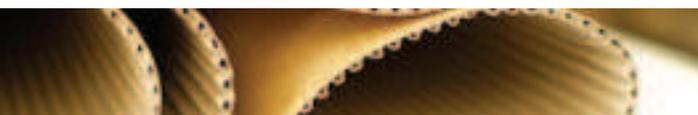
the zero point over an assigned zero row of bolt holes on the die drum. Locate and mark a zero line on the die drum. From this point on, we call this the zero row of bolt holes on the die drum. Mount this test plate on the zero row of bolt holes on the die drum.

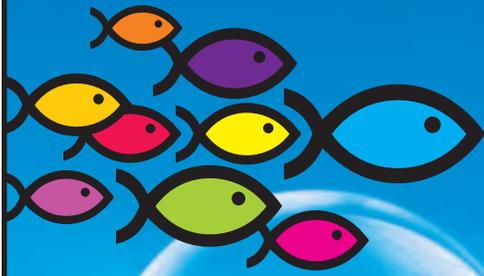
- The plant must also develop the calibration number for the cutting dies. This number is the “Zero Register Number.” This number is required as this is the tool the die maker uses in order to determine the position of the product on the wood. This also helps him decide on a one or two piece cutting die design. We will discuss this in detail in later articles.



- Set the lead slotter knife in the slotter section to 10” (250 mm).

Run several sheets through the press to confirm consistent transport. (Be sure that in the closing process all the timing marks were on zero.) On the next sheet, manipulate the registers so that all of the tips of the arrows in each of the print stations touch the lead edge of the sheet. Also, locate the chevron on the lead edge of the sheet. Adjust the slotter section so that the lead slot is exactly 10” (250 mm) long. At this point adjust all the registers so that either the dial or the computer read out is on “Zero” on the print stations and die cut section. The register on the slotter section should read 10” or 250 mm.





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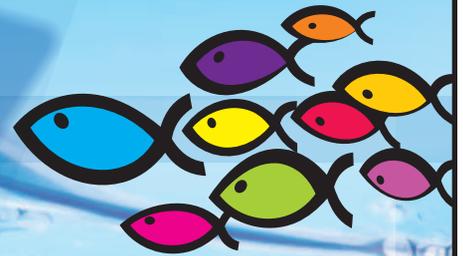


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The illustration now shows the test is complete.

We have now zeroed the register compensators to the gear train. We have established the fact that the lead edge of the sheet will arrive on each print cylinder exactly 2" (50mm) back from the mounting strip. The sheet will arrive on the zero mark on the die drum. The slotter Section in the press is also set.

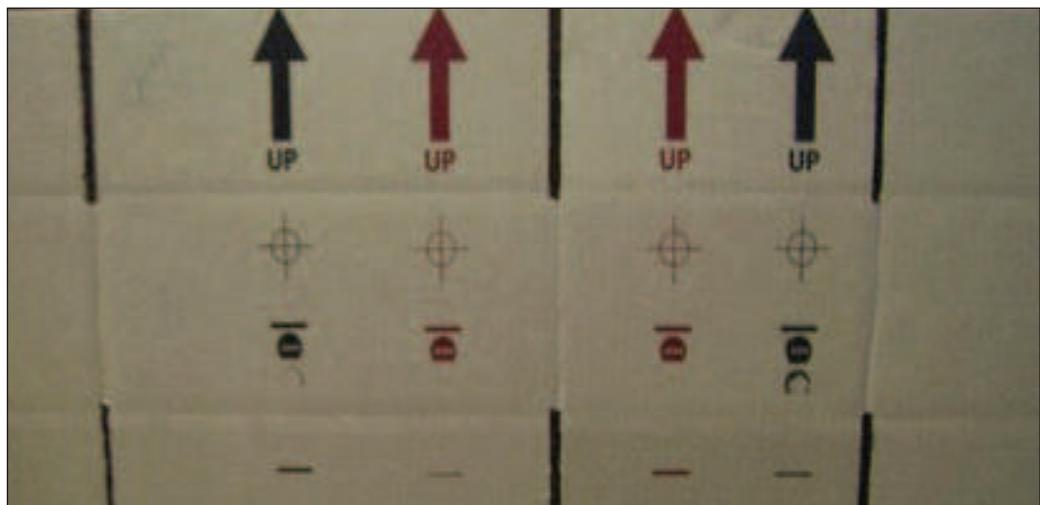
Assuming we made the printing plates with a 2" (50mm) set back and proper zero register numbers have been located on the cutting dies, the crews can now set up the next order and the first box out will be correct!

PLEASE

- 1) Finish the existing order.
- 2) Zero the Gear Train.
- 3) Complete Lock Out/ Tag Out Procedures.
- 4) Open the press.
- 5) Remove the old tooling.
- 6) Mount the new Printing Plates.
- 7) Mount the New Cutting Die.
- 8) Be sure the gear train is on Zero.
- 9) Close the Press.
- 10) Locate the Print Station Registers on Zero.
- 11) Locate the Die Cut Section register on the Zero Register number on the wood.
- 12) For an RSC, Locate the lead slot dimensions. The trailing slot falls into place as it is the lead slot plus the body

Run the first sheet. Confirm dimensions and run the order.

Properly managed, this above procedure will enable the crews to complete order changes in a controlled environment. Die Cut orders will add some additional time according to the product's design. The opportunity here is that we have given the crews predictable information with predictable tooling. They can now set up new orders consistently with proven information about their machine.



They will run one box, confirm the numbers, and run the order. This has proven to not only reduce the set up time but will also reduce the amount of scrap produced. (We define Scrap as product that does not generate an invoice).

Our next article will discuss tooling and its design. We will also review and define technical agreements between tooling and the machines they support.

A Quality Manager once said that the reason why crews spend so much time checking boxes for print register, die cut locations and slotting is that they have no confidence in their machine settings. They generally do not understand how to set registers in advance.

The "Time& Register" calibration program answers that requirement.

Take time to review this with not only your crews but your maintenance department.

There is little or no value to this calibration scheme if maintenance is not actively involved.

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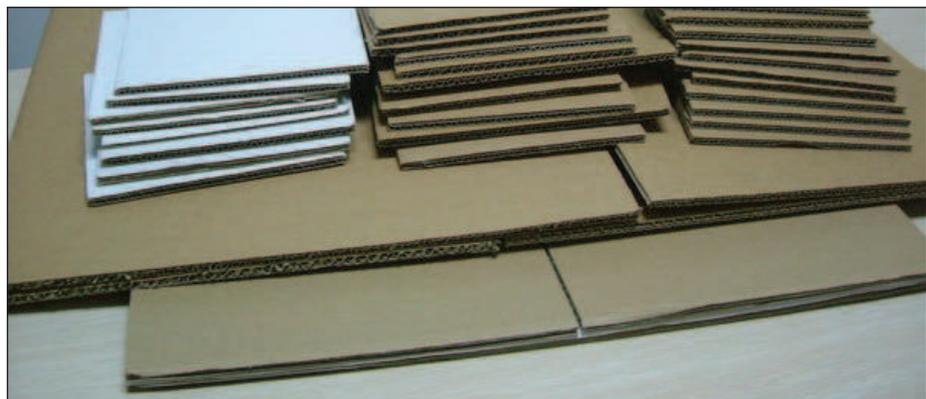
Dick Target, owner of "On Target Consultants" based in Lower Gwynedd, Pa., has been in the corrugated industry for over 35 years. He has worked in 29 countries developing and guiding corrugated plants in lean manufacturing, vendor development and management training.

He teaches Converting Short Courses for TAPPI and is an active member of TAPPI's TCC (TAPPI Consulting Council).

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

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Proper Mounting of Rotary Cutting Dies Used in Soft Anvil Corrugated Converting

A partnership between the diemaker and the diecutting crew

The steel rule dies used in converting corrugated into packaging designs, whether it is inserts, partial cut-outs in RSCs, or complex folding designs, must be mounted properly onto the steel diecut cylinder. The dies are designed to cut with a minimum amount of impression into the soft anvil covers. At the same time that the die is cutting, the creasing rule is meant to press into the corrugated stock to a predetermined depth. For the cutting and creasing rule to work properly over the entire sheet of corrugated, the rule must be seated evenly against the steel drum everywhere across the entire dieboard.

When the steel rule is originally installed in the die, the wood form must be bolted down tightly to the ruling cylinder, which is an exact replica of the cylinder on the actual diecutter. The diemaker must prepare the die carefully with every piece of rule seated completely through the wood, and with no remnants of wood particles or compressed sawdust remaining on the back of the ruling slots. If there is a wood buildup, it will create an area with higher rule. When the diemaker is finished ruling the die, the backs of all the slots have to be cleaned and then the rule reseated if necessary. If the diemaker does his job properly, this is just the beginning. The diemaker must count upon the press operator to mount the die down in the same fashion, so that all of the rule, both cutting and creasing, will be in contact with the steel drum.

Why correct mounting is so important...or how much money it will cost your company if you do not mount your dies correctly

After the die has been made in such a careful manner, it is fundamentally important to expect that it will be used properly in the diecutting operation. If the die is mounted with air pockets underneath various sections of the wood forms, there is a high probability that there will be score cracking, since the scoring rule will

be sitting up in the air. The customer will perhaps reject the job.

There is also a high probability that there will be cutting rules that will break, since they will be under a tremendous force pushing them down out of mid-air as they will try to sink down until they are resting against the steel cylinder. Pieces of rule may fly out, causing damage to other parts of the die, or to the press, or to the crew working nearby. There will be expensive down time. And there are safety issues involved.

The rule will be pushing down through the wooden bridges in the die, which can often cause the wood to crack. The rule may start to rock with every revolution of the drum, which will then break the rule. This will cause expensive and unnecessary die repairs. Once the wooden bridges are broken the rule will not hold in the die. Some dies are damaged beyond repair. You may have to buy a new die for which the customer will not be willing to pay.

There is another more subtle result of improper mounting. All of the cutting rule which is not seated will not cut as quickly or as completely as the rule that is seated nicely against the steel drum. This will cause some of the trim and scrap to hang onto the product. The loads will be dirty,



Mike Mitchell,
Die Techs Division of
Alliance Packaging, Renton, WA, USA

and once again, the customer will not be happy to receive the trim into their plant, where it may also cause them down time in their set-up machinery. The die will be blamed for this problem, when it may not be mounted down tightly.

There are even more problems created when the high areas of cutting rule are hitting into the anvil covers, causing additional and uneven wear that results in low spots and expensive early replacement of the covers. Future dies will not cut in these low spots, and there will be poor scoring in the areas of the low anvil covers. Then the operator will increase the impression pressure on future dies, causing steel rule to break unnecessarily, and causing score cracking in the areas where the anvil covers are still high.

Using the improper die-mounting procedure (which often goes unnoticed by management) causes all of these problems around the diecutting operation and reduces the profitability of the company for a long time to come.

We know that there are plenty of other problems that may need to be solved on any given day, such as warped stock, hot stock, extra liner stretch, etc. So it is best to eliminate one of the controllable variables right away. Mount the die properly.

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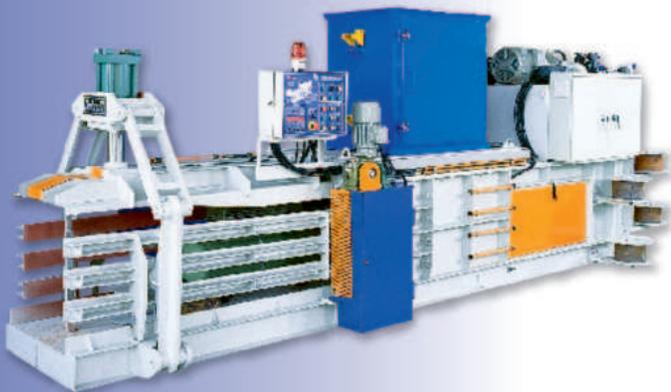
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Please do not think that valuable time is being saved by not using all the bolt holes in the die. Some dies that happen to have a perfectly fitting shell may work fine with very few bolts. But wood is an ever-changing substrate that may end up warping during climate changes during the year. Make this procedure part of the required routine. This is very important. This is not a job for the temporary helper on the crew, unless this person is well trained and understands the consequences of his actions.

How to mount the die

Mounting can be a tedious job if the die is not accurately drilled. But with a good computer controlled, laser burned, and machine drilled die, it will be a simple job, if the die-mounter learns the correct procedure from the start.

Single shell die

Start at the lead edge, screwing in bolts loosely to hold the die from falling. It is important to get the die lined up square, with the bolt holes falling exactly in the

with the idea that the wood has to go down from the center first. Think of it as if this is some plastic wrap that has to be smoothed out in all directions, starting in the middle.

It would be perfectly fine to put in all of the bolts, but do not tighten them down until the center ones are tightened first. The reason is very simple. If the four corners of the die are tightened down first, there is a good chance that there will be an air bubble under the die. Then, when you tighten the center ones last, the wood will not go down to rest on the steel drum, and in fact the wood may start to break out of the back of the die. This could cause the wood to delaminate around the bolt holes.

Multiple shell die

This procedure will be the same as for the single shell die, but after the first shell is located and square on the drum, we want to start tightening all the bolts from the joint-line first, using the same method, but gradually tightening toward the lead edge instead. After the first shell is mounted, it is a simple matter of aligning the second shell

Sometimes, when the wood may fit a little bit too tight, it may seem at first that some of the holes in the die do not line up with the holes in the steel diecut cylinder. But when this procedure is followed, the holes will magically line up as the wood is stretched out into proper position. This will not cure a badly made die, but it will help to solve the problem if the die has become warped or twisted.

If the diemaker has enough bolt holes in the die, and they are in the most important places, near the scores and near the high density cutting areas, as well as evenly distributed across the shell, many diecutting problems will be eliminated. If the person mounting the die decides to use just a few of the bolt locations, the problems will start to show up, sometimes more than others, depending upon the stock and run speeds. Why not do the best set-up possible, step-by-step? When machine time, die costs, repair costs, and high quality production is at stake, there is no question that a well made die should be used to its fullest potential. There are no shortcuts. Soft anvil diecutting only works when we follow the proven procedures. Diemakers cannot take any shortcuts when we make the die. The diecut crew should not take short cuts either. The operators should not try to use the die unless it is mounted down tight.

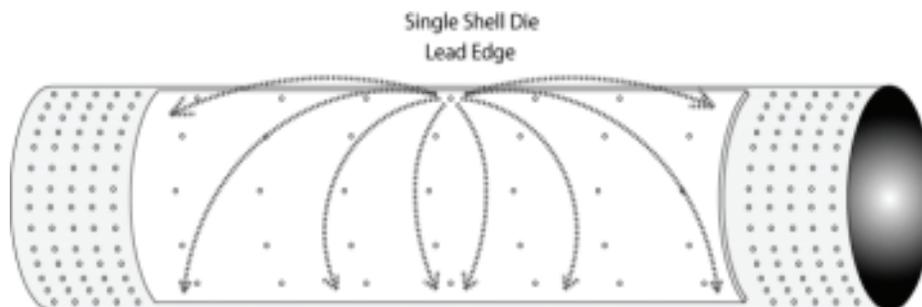
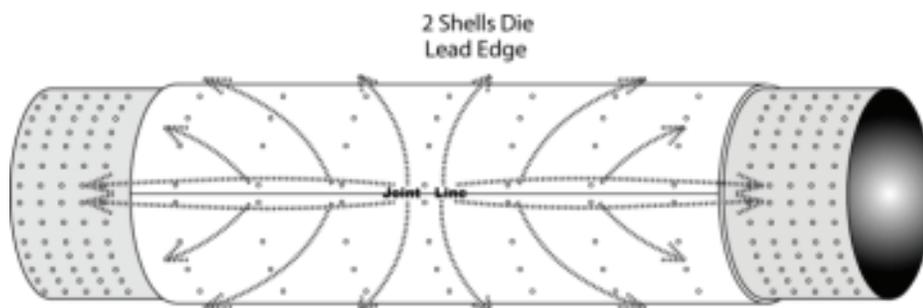
A good test to check your mounting

After mounting the rotary die, there is a good test that will give you a pretty good idea as to whether the die is mounted down tight. Using a leather rule mallet, pound on the wood in some of the areas of the die where there is no steel rule. If the sound is a dull thud, that is a good sign that

middle of the holes in the die. By using the alignment holes out on the edges of the die this is easy to do. Leave the alignment bolts loose until you are sure that the following procedure is complete. Then you can remove the alignment bolts.

The most important aspect of the whole procedure is to follow a certain pattern when tightening the bolts down. Start in the middle of the first row and tighten a few bolts to the left and right, and then go down to the next row and tighten a few bolts in the center of that row. Gradually work out to the edges and to the trail edge,

at the joint line, and following the same pattern from the joint line back to the trail edge of the die. All of the focus is directed at getting all of the air pockets squeezed out from the center of the die.





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the die is mounted tightly down. If there is a hollow sound and the mallet bounces, the die is not down tight. Maybe there is air under the die. Maybe there were not enough bolts in that area of the die.

Please, on behalf of all diemakers, I urge you to mount the dies properly. You will get more life from the die and better products. You will be able to run faster with cleaner loads. The extra time that it takes to use all the bolt holes will be worth the investment in the long term.

Did the diemaker design in enough bolt holes?

If the diemaker puts in too many holes, the crew may think that they have good reason not to use them all. But it is usually just the opposite. Some diemakers may not put in enough bolt holes. One rule of thumb suggests that there should be about 5 rows of bolts in the curved direction for a full shell on the 66" (1676mm) cutting dies. And the same general rule might recommend that across the length of the drum there

is a hole about every 8" to 10" (203mm to 254mm). This may seem like it is too many bolts to some people. I believe that it is a minimum amount. Sometimes the bolt pattern location choices fall right where the rule runs through, or right where there is a high density of scrap knives. So there are always going to be compromises to be made when the die is designed. But for high speed use, the dieboard needs to be mounted very securely, especially where there are a lot of scores and a lot of hard to cut places in the design. Please trust your diemaker's judgment and make it a rule to use all of the bolt-hole locations provided.

Mike Mitchell is General Manager of Die Techs Division of Alliance Packaging. Die Techs primarily manufactures laser cut rotary and Bobst dies for the corrugated converting industry. Their customer base is Northwest United States and Western Canada. Die Techs would like to thank IADD and their industry members for all of the technical and market trend support which they have offered over the years. To contact Mike or Die Techs, call 1-425-291-3525.

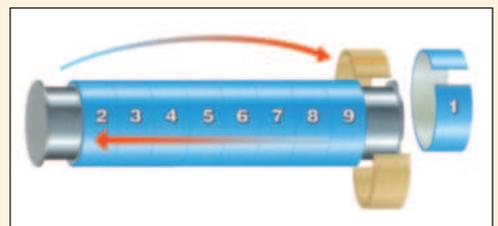
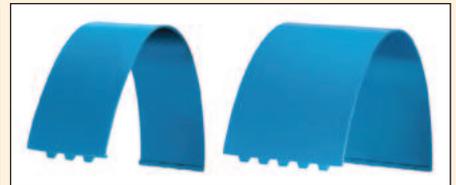
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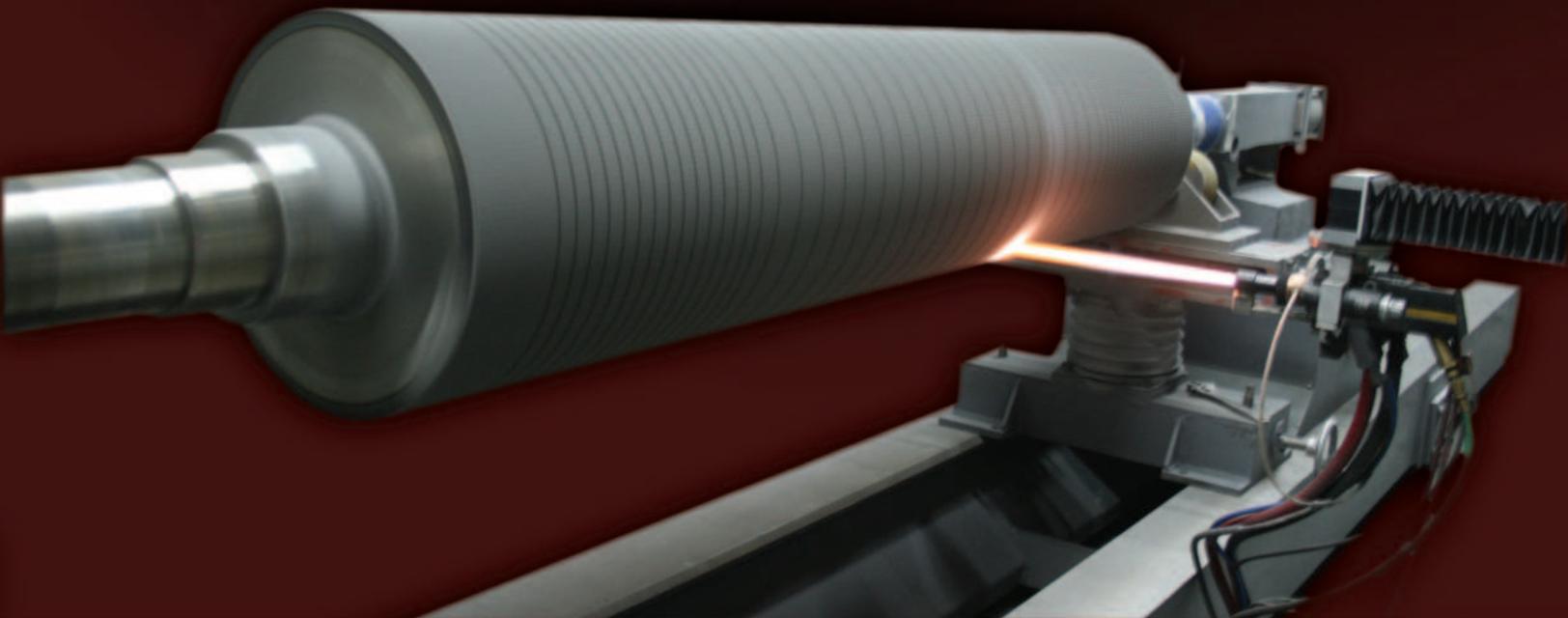
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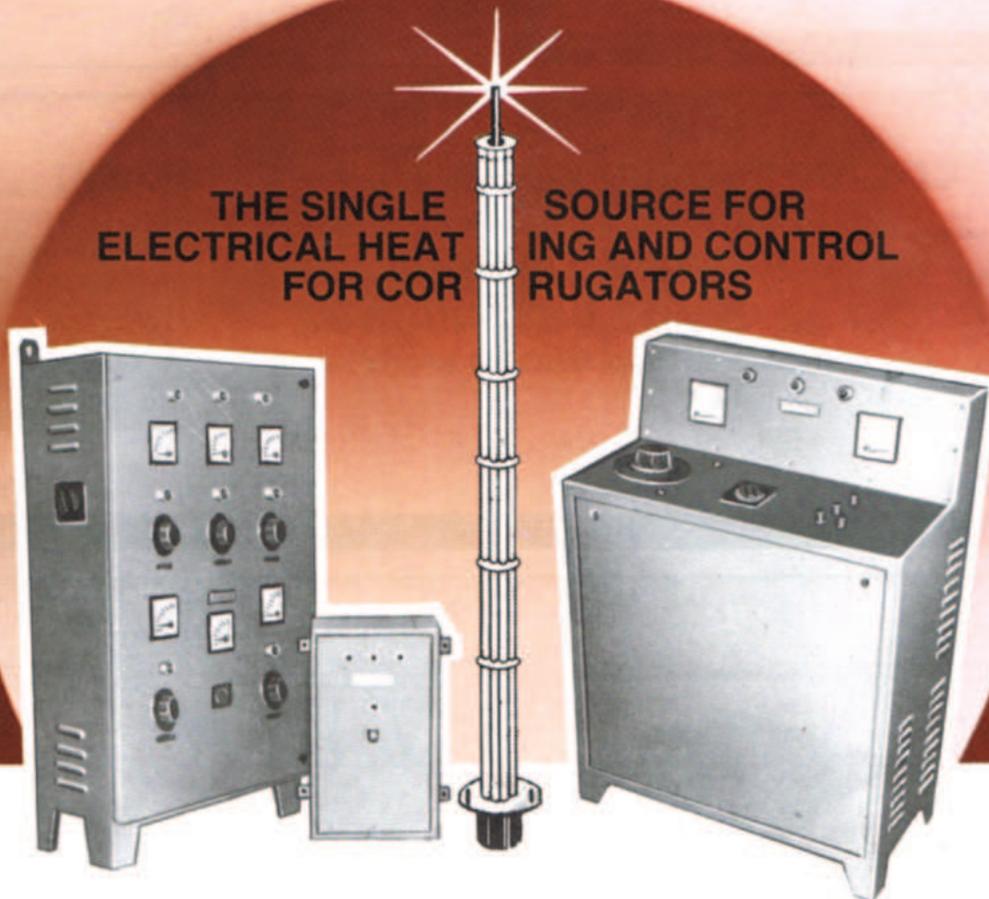
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KACBMA, Samadhan & Microsoft organize a joint event

A joint event was organized by KACBMA, Samadhan and Microsoft to showcase a vertical solution created for the corrugated box manufacturing companies in southern

Karnataka state under the aegis of Karnataka Corrugated Box Manufacturers Association.

A total of 61 owners of businesses from Bengaluru, Mysore, Mangalore etc. attended the seminar.

KACBMA Members visit to Auto Plant

Karnataka Corrugated Box Manufacturers Association had organized a visit to an Auto Plant for the benefit of its members. They had organized two Kraft Paper Mill visit – Gugan Papers and Subam Paper Mills in 2014 and 2015 respectively.

The members were invited to MNM Triplewall Containers Pvt. Ltd. The directors took the members around the plant and explained in detail the facilities and the activity.



View of the audience



Group photo during a Plant Visit



For more than 30 years, ICCA has sponsored a biennial Management Conference to allow worldwide corrugated industry executives to come together and share information, in a legal manner, on appropriate issues.



Carl Bobm, M.L. Agarwal, Ankit Agarwal, Anil Kumar Reddy and other Foreign Delegates



Anil Kumar Reddy with President-Elect Jose Soares, Icca during the Summit



With Carl Bobm and MVM Bharat



The 2015 ICCA/WCO Global Summit was held during April 13 - 17, 2015 at the Grand Hyatt Taipei, Taiwan and the Mandarin Oriental, Shanghai, China.

The Summit was sponsored by Cheng Loong Corporation and included a VIP Tour of SinoCorrugated.

Mr. M.L. Agarwal made a presentation on behalf of FCBM



A Presentation during ICCA Summit on behalf of FCBM



A Pioneering Achievement by PMCC. A Historic Event for the FCBM Members.

Inauguration of Linear Measurement System at Tirumala Venkateshawara Paper, Mancherial, Telangana.

Members will be pleased to know that Tirumala Venkateshawara Paper in Telangana has installed the Linear Measurement System.

The system was inaugurated by FCBM President Mr. P.S. Shah on 25th August, 2015

Continuous efforts of the PMCC, and all members, over the years has now borne fruit.

Pursuant to the continued efforts in getting paper mills to provide length/ meterage of paper in each roll as part of quality assurance and cost control; M/s Tirumala Venkateshawara Paper & Board Pvt. Ltd; Mancherial have installed required equipment and will be providing length of each roll soon.

Team APCMA / ACCTS has been rigorously following it up after the June PMCC meeting and as a result, one paper mill has come forward and is trying to implement our request.

Once again, we would like to thank team APCMA / ACCTS for coming forward and hosting the occasion.

It was a historic moment for FCBM and a learning exercise, for all members who joined the programme.



President Mr. P.S. Shah inaugurating the system



Mr. M. L. Agarwal speaking on the occasion



Looking at the system working



Members at the paper mill

FCBM Managing Committee Meeting



After the general discussion on matters as per agenda. Mr. George, Vice President I, invited members to the forthcoming FCBM Conference.

Veteran Mr. R. Muthaiyah, regarded as the God Father of KeCBMA, made a special appear to all members to make the maiden Conference hosted by KeCBMA a memorable success.

He urged all regional associations to participate in large numbers.



Mr. R. Muthaiyah, urging members to make the Kerala Conference a success

A few pictures of Managing Committee meeting in progress





3 & 4 September 2015
Hotel Cidade de Goa
Panaji, Goa

THEME - Corrugated Packaging for Perishable Goods

PLATINUM

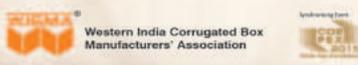


DIAMOND



SILVER





As the sea waves in Goa, it was a tidal wave of delegates, exhibitors and others who inundated the Registration Desk.



Registration

The symposium was truly an 'enriching experience with packaging experts'.

A record-breaking event with over 330 registrations and a sold out Corplex Exhibition.

The inaugural programme set the tone for the Symposium. Mr. Vinod Chowdhury, President WICMA welcomed the gathering.

In his address – Mr. Vincent Mathias, Chairman, Symposium elaborated on the planning of the event and expressed his gratitude to everyone who contributed to it's success.



The Chief Guest Mr. Francisco D'souza, the Deputy Chief Minister of Goa lighting the Lamp



Mr. Vincent Mathias, Chairman - Symposium, speaking on the occasion

Mr. P. S. Shah, President FCBM congratulated WICMA on organizing such grand event.

Mr. Sundeep Bambolkar talked about the importance of quality.

Mr. Francisco D'Souza, Deputy Chief Minister of Goa talked about the survival



Mr. Sundeep Bambolkar, the Guest of Honour speaking on the occasion

of the fittest and the importance of creating niche in a competitive environment.

Mr. Ashok Vyas proposed a Vote of thanks.

In emotion packed moment Mr. Deepak Killawala was presented the Lifetime Achievement Award by the Chief Guest.

Mementoes were present to the Chief Guest and Guest of Honour.



Mr. Deepak Killawala receiving the Life Time Achievement Award from the Chief Guest

Annual General Meeting

At the AGM a new team was elected to lead WICMA in the coming year. Mr. Sunil Gupta took over as President of WICMA for the year 2015-16.



Mr. Vinod Chowdbury Pinning the in-coming President Mr. Sunil Gupta

Power Packed Technical Sessions

Eminent speaker and industry experts threw light on various subject of interest.

The Technical Sessions spread over the rest of the day had eminent speakers throwing light on various subjects of interest to the corrugators.

A very melodious programme of music regaled the audience in the evening.

On the second day i.e. 4th September, Mr. Ram Kumar Sunkara had a very vibrant interactive session.



Some of the Speakers

WICMA Team 2015-16

Sunil Gupta	President
Sandeep Agrawal	Vice-President
Shahzad Sheikh	Hon. Secretary
Yogesh Shah	Hon. Treasurer
Vinod M. Chowdhury	Ex-Officio



Corpex 2015 – A view of exhibition





Why you shouldn't miss the 44th FCBM Conference

- FCBM Conference being held for the first time in Kerala – the God's own country.
- Well-appointed Le Meridian Enjoy the luxury of hospitality at Le Meridian
- Large delegations and expected from Sri Lanka, Malaysia, China and Taiwan
- Well designed, power-packed Technical Sessions.
- Smart Pack Expo – The Super Exhibition in a large space.
- Smart Pack Book – the Souvenir with a difference.
- Enjoyable fun-filled outings and cultural Programmes.

And more!

“PACKAGING TOMORROW, FUTURISTIC IDEAS AND SOLUTIONS”

Day 1 - 20th November, 2015

Hotel check In

Award entries receiving

Exhibition inauguration

Lunch

FCBM Managing Committee Meeting

Seminar Session I

Tea

Inauguration of Conference

Cultural programame

Fellowship & Gala Dinner

Day 2 - 21st November, 2015

Breakfast

Seminar Session II

Tea

Seminar Session III

Lunch

Seminar Session IV

Buyer Seller meet

City site seeing for spouses

Visit Exhibition stalls

Cultural Programme

Family members meet

Fellowship & Gala Dinner

DAY 3 - 22 nd NOVEMBER, 2015

Breakfast

Seminar Session V

Tea

Annual General Meeting & Election

Lunch

New Managing Committee Meeting

2.30 p.m. Conference ends



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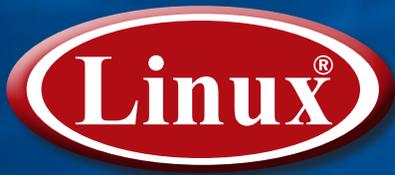
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- Overload protection (Preset)
- System BF calculation for Paper

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Packaging on the move

Global packaging is getting driven by many visible, invisible factors and it's moving for sure. Paper and board packaging is set to gulp the largest chunk; Indian pulp and paper industry may read many prolific omens in this.

The packaging industry, as per almost all reports and market surveys, is growing stronger mainly because of improved consumption practices all across the globe. A report published in 2008 by World Packaging Organization says there are 100,000 companies active in the global packaging manufacturing industry, creating as many as 5 million jobs. These numbers must have risen by now as the industry continues to expand briskly. From food and beverage products to pharmaceuticals to FMCG to electronics to furniture and a myriad of other industrial and consumer durables, packaging has a prominent role to play in the value chain.

...globally, paper and paper board rigid packaging products form the largest segment of the packaging market, totaling some USD 210 billion in 2010 and estimated to grow to USD 250 billion by 2016.

Paper and board packaging, most significantly, had the largest share of global packaging with sales of USD165 billion in 2003, equating to 38 percent of the market. In the same report of 2008, WPO forecasts that paper and board will remain the single largest element of the market into 2009, growing at an annual rate of around 4 percent in real terms, driven on the one hand by rising demand in fast-growth national markets as well as steady growth in secondary/bulk packaging across the globe.

WPO's stand seems vindicated by more recent estimates by Smithers Pira (Pira International formerly), which says, globally, paper and paper board rigid

packaging products form the largest segment of the packaging market, totaling some USD 210 billion in 2010 and estimated to grow to USD 250 billion by 2016.

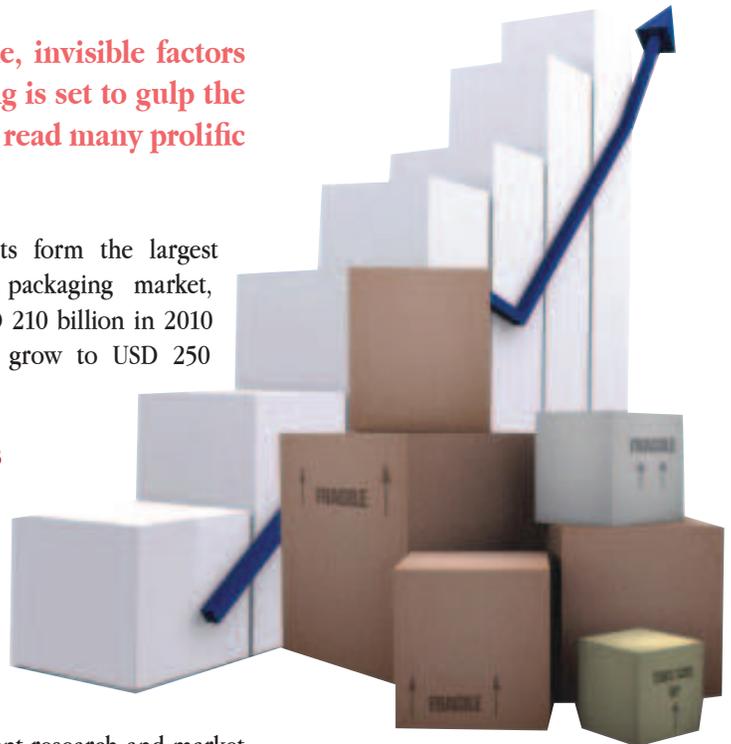
Global Trends

The global packaging industry turnover at present may have little variations here and there as reported by different research and market report agencies. However, major forecasts and trends point to vigorous growth scenario in near-term future.

...global packaging industry would touch USD 1 trillion mark by 2018.



Smithers Pira, an authority on the packaging, paper and print industry supply chains, claims that global packaging industry would touch USD 1 trillion mark by 2018. According to Pira, the global



packaging market stood at USD 799 billion in 2012, increasing by 1 percent over 2011. Sales are projected to increase by 3 percent in real terms for 2013 to USD 824 billion. Pira forecasts annual growth of 4 percent per year to 2018 in the world packaging market, with sales to reach over 1 trillion US dollars by 2018.

Whatsoever industry sizes have been conjectured by WPO, Pira or other reports, the global packaging industry today stands at more than USD 800 billion as per central tendency measure of all such varying data.

As per WPO report in 2008, North American markets, including the USA, Canada and Mexico, accounted for the largest share of global packaging at USD 132 billion (32 percent), ahead of Western Europe (26 percent) and Asia (26 percent). The overall share of European markets, however, exceeded that of North America at USD 137 billion, equating to a 33 percent share. The fastest growing markets in dollar terms

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have been in Eastern Europe, growing at an annual rate of 16 percent in the period 1999-2003, principally as a result of strong sales growth in Russia, Poland and other markets during 2003 – as well as the effect of exchange rate movements.

However, according to Pira's 2013 report, sales of packaging are concentrated in Asia, which accounted for 36 percent of the total in value terms in 2012. North America and Western Europe totalled shares of 23 percent and 22 percent respectively. In 2012, Eastern Europe was the fourth largest consumer of packaging with a global share of 6 percent, closely followed by South and Central America with 5 percent. The Middle East represents 3 percent of the global demand for packaging, while Africa and Australasia each have a 2 percent share. According to the study, this segmentation of the market is expected to change significantly by 2018; Asia is predicted to represent over 40 percent of global demand, while North America and Western Europe lose out noticeably.

Asia is predicted to represent over 40 percent of global demand, while North America and Western Europe lose out noticeably.

What is quite conspicuous in these two reports, separated in time by about 5 years, is the shift of global packaging share towards Asia. The share of Asian packaging market will keep increasing in coming times as suggested by other reports also.

Indian Picture

India is the sixth largest packaging market in the world, with sales of USD 24.6 billion in 2011 as per the Indian Institute of Packaging (IIP), an autonomous body under the commerce and industry ministry. The IPI's 2013-14 annual report says that the packaging Industry is expected to grow at a CARG of 12.3 percent to become the fourth largest global market, with sales of USD 43.7 billion in 2016.

...packaging Industry is expected to grow at a CARG of 12.3 percent to become the fourth largest global market, with sales of USD 43.7 billion in 2016.

Asian market has been doing well lately with especially the Chinese and Indian packaging markets growing strongly throughout 1999-2003 as per WPO. China ranked as the world's third largest market for packaging products at around USD 32.1 billion in 2003. However, in 2010, China became second largest user of packaging with USD 80 billion and the US retained its position as the largest with USD 137 billion.

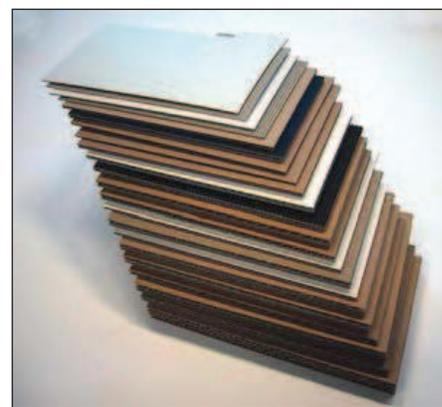
IPI sees the next phase of growth for the industry coming from e-commerce, as more traditional retailers also take to online selling. The institute also said the USD 24.6 billion (in 2011) market, which was growing at is about 13-15 percent had a great potential as India's per capita consumption of packaging was just 4.3 kg, compared with 6 kg for China and 19 kg for Taiwan. In other words, India's per capita annual packaging expenditure was USD 20 in 2011, which is significantly lower than the top 20 market average of USD 347.6. The Low per capita expenditure offers a huge business opportunity for packaging company. The Indian food processing market is one of the largest in the world in terms of production, consumption and growth prospects.

Packaging, especially flexible packaging, is maturing in North America and Western Europe, but not in India or other economies of Asia. India and China are the fastest-growing national markets for consumer flexible packaging according to Pira, together accounting for 44 percent of world flexible packaging consumption growth during the forecast period. India is on a growth path and that's great news for the packaging industry as well. The growing economy with growing aspirations and dispensing incomes means growth for packaging industry.

India and China are the fastest-growing national markets for consumer flexible packaging according to Pira, together accounting for 44 percent of world flexible packaging consumption growth...

Paper and Paper Board Packaging

Packaging encompasses a wide range of material types across paper, board, plastic, metal, glass, wood and other materials. Paper and paperboard packaging is fast emerging trend in the packaging industry. It is gaining importance in many regions as it is environment friendly and cost-effective. Paperboard is thicker with a high weight per unit area and is made in multiple layers. It is mostly used to make containers such as boxes, cartons, and trays for packaging and shipping and is seldom used for direct food contact.



The various types of paperboard are white board, solid board, chip board, and fiber board. The vendors in the Global Paper and Paperboard Container and Packaging market are continuously offering new packaging patterns that can prevent the contamination of products such as food or beverages.

The largest share of global packaging was accounted for paper and board packaging with sales of USD 165 billion in 2003 constituting 38 percent of the market, as per WPO reports published in 2008. This report further says that paper and board packaging will remain the single largest element of the market into 2009, with a 38 percent share at USD 216 billion – growing at an annual rate of 4.2 percent in real terms, driven on the one hand by rising demand in fast-growth national markets as well as steady growth in secondary/ bulk packaging in developed markets in line with overall industrial activity.



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** BHS Booth C-17 ** ICCMA Congress ** BHS Product Launch **

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In addition to our presence on booth we are proud to point out further program highlights as well. One of them will be our participation in the **ICCMA Congress 2015**. BHS Corrugated will hold a speech on the **6th between 04.30 pm – 05.15 pm** with the topic **“The key of success for economical performance in Indian Corrugating Industry”**. Besides that we will officially **launch a new product** in the evening of the **7th of October** which is designed especially for the Indian market requirements.

BHS Corrugated is looking forward to your visit in Greater Noida!



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The 2008 WPO report further stipulated that aside from the Middle East, the fastest growing regional markets will be found in Eastern Europe, South America and Asia where annual growth of the order of 6 percent is anticipated. Asia's share of the market is set to rise from 34 percent to 36 percent, with strong growth in China – overtaking Japan to become the second largest market with sales of USD 30 billion by 2009 – as well as Indonesia (growing at almost 10 percent annually to USD 5.4 billion) and India (growing at an annual rate of 12 percent to reach almost USD 4.5 billion).

The above trend as indicated by WPO ring true as corroborated by more recent Pöyry, June 2014 forecast which says the strongest growth in consumer board will be in Asia during 2013-2025. China and Asia Pacific are set to register a CAGR of 5.4 percent in consumer board segment by almost doubling the output from 7.9 to 14.8 million tonnes during this period.

... global paper and paperboard container and packaging market is to grow at a CAGR of 6.50 percent over the period 2014-2019.

According to Market Research Report, global paper and paperboard container and packaging market is to grow at a CAGR of 6.50 percent over the period 2014-2019.

Within the paper and paperboard packaging important sub-segments, which are going to see better days ahead, are folding carton packaging, release liners, corrugated board packaging, liquid paperboard packaging, food contact paper and board, etc.



According to recent reports of Smithers Pira, actual consumption of carton board amounted to 47 million tonnes in 2012, worth USD 140 billion, and is forecast to grow by 5.1 percent annually, to reach 63 million tonnes, valued at USD 184 billion, by 2018. For the report, Pira collected information from almost 400 cartonboard manufacturers and more than 300 converters across the global market. Healthcare products are the single largest users of folding cartons, followed by tobacco.

Pira's separate report for release liners says the demand is forecast to increase to some USD 13 billion by 2019, amounting to almost 48 billion square metres and showing average annual growth of around 4.5 percent over this period.



Demand for corrugated packaging material is expected to increase more than 4 percent annually over the next five years to reach USD 176 billion by 2019 as per Pira's exclusive report dedicated to corrugated packaging. This report is somewhat consistent with another report by Persistence Market Research (PMR) which says the global corrugated packaging market is estimated to reach USD 173.6 billion (£113bn) by 2020. TechNavio's analysts forecast the global corrugated box packaging market is to grow at a CAGR of 3.98 percent over the period 2014-2019 which is also somewhat in line with Pira and PMR reports.



With regard to food contact paper and board Pira says that between 2009 and 2011 the market for paper and board used in food contact applications grew by an average of more than 6 percent annually, reaching a total of nearly USD 50.4 billion in 2011. This market is expected to increase by around 4 percent annually over the next five years, totaling more than USD 63.7 billion by 2017, with growth fuelled largely by the growing focus on sustainability.



In India, comparatively, paper and paper board accounts for around 10 percent of the total packaging materials which is far below the global ratio and has immense scope for improvement.

Key Drivers: Paper and Paper Board Packaging

Global packaging demands are fast increasing owing to macro level drivers like population growth, emerging middle class, world-wide demand for safe food, innovation and of course sustainability. If we recall the WPO report 2008, it said that paper and board packaging will remain the single largest element of the market driven on the one hand by rising demand in fast-growth national markets as well as steady growth in secondary/bulk packaging in developed markets in line with overall industrial activity.

While the economy plays a central role in influencing the size and growth of the packaging market, there are a number of other factors which can be seen as having a direct or at least indirect influence on paper and board packaging demand or, at any rate, the nature of this demand, irrespective of the performance of the economy.

Cont. on - 47

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These may include the increasing requirement for convenience among consumers, rising health awareness among consumers, the trend towards 'on-the-go' lifestyles among increasingly time-poor consumers, growing requirements for brand enhancement/differentiation in an increasingly competitive environment, etc. On the other hand, climate change combat and carbon footprint issues, consolidation and globalization of retailers, e-Commerce, and growing pharmaceutical market are some very conspicuous drivers driving the need of paper and board packaging.

The corrugated packaging market is thriving mainly due to growing end-user industries, including food, medicine, consumer durables, rubber, and petroleum. Benefits associated with corrugated packaging such as sustainability and low cost makes it one of the preferred modes of packaging across various industries. Emerging markets are said to offer tremendous growth opportunities for the corrugated packaging market due to increasing population and growing demand for consumer products in these regions.



China, Japan, India, and Indonesia are the major corrugated packaging material producers in Asia Pacific.

China, Japan, India, and Indonesia are the major corrugated packaging material producers in Asia Pacific. The US leads the corrugated packaging material production in North America while the European market is dominated by Italy, France, Germany, Spain, the UK, and Poland. Brazil and Turkey feature among the leading corrugated packaging material producers in Rest of the World (RoW).

In India, the paper packaging products are an important part of the overall



packaging industry. Again, the growth in the India paper packaging industry has been largely impelled by the augmenting demand for better quality of paper packaging products and changing consumer preferences. Increasing demand for paper packaging products along with high urban population growth, rising disposable incomes and paper production in India are anticipated to further stimulate

the country's overall paper packaging industry in the following years.

A higher demand for paper packaging products, especially an increased trend in the usage of folding cartons, has been observed in India.

A higher demand for paper packaging products, especially an increased trend in the usage of folding cartons, has been observed in India. The increase in the folding cartons has been observed on account of factors such as increasing FMCG and the food & beverage sector. The corrugated box market has been increasing mainly due to development of the country's logistics sector and escalating exports in the country.

Other paper and board sub-segments are getting driven by above factors only. Organized retail and emerging e-Commerce scenario are two prominent future drivers of this sector. Presently, the growth in organized retail and e-Commerce is spurring the demand for packaging about 12-14 percent a year.

**e-Commerce:
An Ascending Driver**

e-Commerce is growing by double digits. e-Commerce companies are increasingly growing conscious about protective packaging. For them, the cost of the damaged goods is much higher than the cost of protective packaging. On the consumer side also, a well-packaged

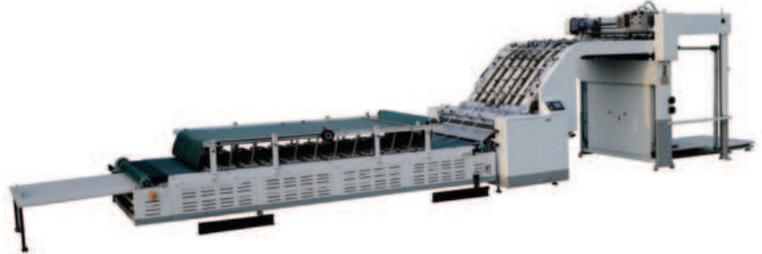


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delivery drives satisfaction. These overall are fuelling the packaging demands by e-Commerce companies.

e-Commerce companies are increasingly growing conscious about protective packaging. For them, the cost of the damaged goods is much higher than the cost of protective packaging.



In a recent interview for a magazine, Mr. Jerome Peribere, CEO, Sealed Air Corporation said, “We are working hard and e-Commerce is a segment which is extraordinarily growing for us. If you order your iPhone 6 through an e-Commerce site then it would be delivered in a Sealed Air packaging. It has a very good cushioning and is extremely aesthetic. e-Commerce is a division of our protective packaging division and contributes around 20 per cent of our protective packaging sales.” This feeling was echoed by others too in the industry.

“I have absolutely no doubt that in India, e-Commerce will do (to modern trade) what mobile phones have done to the telecom industry. We are going to leapfrog modern trade and hyper markets and go from mom-and-pop stores to e-Commerce,” Harish Manwani, non-executive chairman, Hindustan Unilever Ltd (HUL), and former chief operating officer, Unilever Plc., the world’s second-largest consumer products maker, said at Nielsen’s Consumer 360 conference in Mumbai recently.

“I have absolutely no doubt that in India, e-Commerce will do (to modern trade) what mobile phones have done to the telecom industry...”

And even as modern trade struggles to go beyond the cities—there are over 50 with a population in excess of a million—e-Commerce marketplaces such as Flipkart, Snapdeal and Amazon have already started delivering deep into the interiors. Amazon India delivers to all of India’s 19,000 pin codes through a tie-up with India Post. Flipkart delivers to 1,000 cities, covering 10,000-15,000 pin codes. Snapdeal also covers all the pin codes in the country. All this sounds good for the future of packaging in India.

In a recent development, US packaging giants RockTenn and MeadWestvaco were rolled into USD 16 billion merger. “There’s significant opportunity around the world for us to grow as we see more activity in emerging markets,” MeadWestvaco Chief Executive John Luke said citing India, Brazil and China as growth regions owing to flurry in e-Commerce and online retail segment. Demand for the corrugated boxes made by both firms has risen sharply amid an internet shopping boom. Global e-Commerce sales are expected to have risen 20 percent to USD 1.5 trillion in 2014, according to industry data firm eMarketer.

One of the largest greenfield projects in packaging board will go on stream in Tamil Nadu when Tamil Nadu Newsprint and Papers Ltd commissions its two-lakh-tonne a year factory by the year end. The unit will make high-end packaging board used in a wide range of industries including pharmaceuticals, food and consumer electronics. “We believe the growth momentum is more in the board sector than in the paper sector. Paper growth is roughly 6 to 7 percent only. e-Commerce and retail segment is growing generating more demand for the packaging. We, therefore, believe, as per the study we conducted, that the demand for the paper board will be about 12 to 14 percent per annum. So, we have taken a conscious decision of going for a board plant,” said Mr. A. Velliangiri, Deputy Managing Director, TNPL.

“We believe the growth momentum is more in the board sector than in the

paper sector. Paper growth is roughly 6 to 7 percent only. e-Commerce and retail segment is growing generating more demand for the packaging...”

Dr. Prodipto Ghosh, Distinguished Fellow & Director, TERI is of the opinion that paper packaging may serve as biodegradable substitute of plastic packaging and that e-Commerce is emerging as an opportunity for the paper industry. He was recently speaking at IPPTA’s Annual Seminar in Hyderabad and said, “The e-Commerce industry is rapidly taking off. It is now a multi-billion dollar industry in India just in few years. Many of us have started buying whole pile of things online. But, the e-Commerce sector has, in nature of its functions, many more requirements of packaging than traditional retail.

“e-Commerce has to package everything for transport. I think that the pulp and paper industry can creatively engage with this growing sector to identify new types of packaging that can also be recycled and reused...”

“e-Commerce has to package everything for transport. I think that the pulp and paper industry can creatively engage with this growing sector to identify new types of packaging that can also be recycled and reused. This also goes to the question of plastic packaging where, through proper R&D, a biodegradable substitute of plastic packaging can be evolved.”

As of now the major players in this segment are ITC, Century Paper, Khanna Paper and JK, according to industry sources. However, the future packaging landscape may see more players surface to tap the growth by virtue of demands generated by e-Commerce.

We acknowledge that this article was first published in PaperMart Apr- May 2015 issue.

We sincerely thank the Editors of the magazine for giving us the permission to reprint this article.

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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	PG30 /PG35/ PG40 / PG50	PG50	DDG40 / DDG50
Purpose	For Corrugation Sheet Bonding	For Pasting Sheet Bonding	For Automatic Sheet Pasting Machine	For 3 PLY/ 5PLY/ 7PLY 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.

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Creases Follow Flutes in E-Flute

International Association of Diecutting and Diemaking, Crystal Lake, IL, USA

IADD TechTeam™ – Ticket 1107

Process : Diecutting—Flat Steel Rule Die—Carton

Material : Corrugated Paper Micro-Flute

Question

When creasing E-flute material, the creasing rule tends to follow vacant areas in the flutes and thus creases the material in the wrong area. We are somewhat new to this. We have had some success over the few years we have been doing this but we have a carton here that needs to line-up consistently! We do have cushion crease rubber on the die and have tested several heights to stabilize the product prior to creasing rule contact. Still, the rule tends to follow the flutes. We are using a three point crease on a two point body, and have tried .889"-.907" (22.58mm - 23.03mm). Cannot go any higher! Please help if you can!



Answer

TechTeam™ would suggest using matrix if you have not already tried it. In my experience, the Cushion Crease works well with thicker flutes such as B or C flute but in small flutes it tends to create more of a rolling action as you described.

Typically 32 ECT or 200# test E-flute crushes down to a .037" (.940mm) caliper thickness. If you subtract that from the .937" (23.8mm) cut height, that would put you at about .900" (22.86mm) for

the crease height if you are using a matrix. Without the matrix, (again, in our experience) we have found we need to use .915" (23.24mm) height.

If you have a label on this product, that will change everything depending on the thickness of the label and dependent on whether it is adhered to a single face or a single wall material. (In this case, the material does have a liner of .010" (.254mm) solid bleach. If the label is adhered to single wall, then you will need to subtract the thickness of the label (.010") from the crease height, meaning that with matrix we would suggest an .890" (22.60mm) crease height and without matrix we would suggest a .905" (22.99mm) height. If the label is adhered to single face, then the crush caliper should be around .034" (.86mm) thus raising the crease height back to the original numbers we gave you.



We would also suggest that you try placing the creasing rules in the opposite direction than normal processing (radius bevel faces up). In other words, place the crease rules into the die so the non-rounded sharp edges face up and make contact with the material. Make sure the flat rule tip direction has sharp 90° degree corners and are deburred. This will tend to grab the paper as it being processed and will allow for less

slipping. Perhaps, combined with the above suggestions, you may find a full proof solution to your slipping crease problem.

The International Association of Diecutting and Diemaking's TechTeam™ is a panel of industry experts who quickly and thoroughly answer IADD members' toughest technical questions. For more information on TechTeam™ visit www.iadd.org.

This article is reprinted with permission from the IADD's monthly magazine, The Cutting Edge, March 2007.

The IADD is an international trade association serving diecutters, diemakers and industry suppliers worldwide. IADD provides conferences, educational and training programs, a monthly magazine, online resource library of 500+ technical articles, industry experts to answer technical questions, publications and training manuals, recommended specifications, online used equipment marketplace, videos and more. IADD also co-presents Odyssey, a bi-annual trade show and innovative concept in technical training featuring a hands-on Techshop where training programs come alive in an actual working diemaking and diecutting facility inside the exhibit area. Visit www.iadd.org or call 1-815-455-7519 for more information about IADD.

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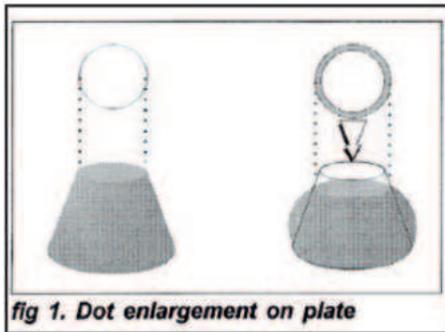
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The Real Source of Dot Gain?

The Problem

I came across the following images when preparing a print training session for a customer.

The images show that dot gain in print can be linked to the deformation of the dot on a plate during printing. This is what's commonly believed — but is it true? I'm sceptical about this being the sole reason for dot gain. Yes, it's likely that the dot on a plate deforms as it's put under stress, but is this deformation enough to explain the dot gain in a printed image?



Why would the dot on a plate deform as shown above when corrugated board is likely to deform far more easily than the plate, especially as the plate is usually mounted on a foam backing.

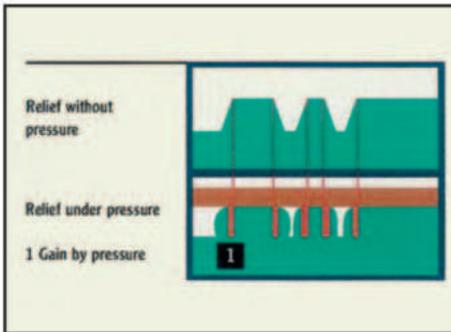
And then you need to ask, is the volume of the dot constant when it deforms? The fact is that the increase in diameter due to the compression of a dot (as shown in the image) is not equivalent to dot gain we see in print. So how can we establish the true source of dot gain?

The Test

During last year, I was asked by a customer if I could measure the glue consumption on a flexo folder gluer. I developed a system that measures the actual glue consumption independently and provides a value for glue consumed per box.

The system worked that well that I also used it for measuring ink consumption during printing. Again, success — although it showed more than just ink consumption. It also showed the start-up affects on ink circulation and how much ink is really in circulation. The ink transfer measured is completely different to what the industry generally thinks.

The first comment you get when measuring inline ink consumption is that it's not possible. People give a thousand reasons why it can't be done.



However, a measuring method should not be criticised before it has been tested. A measuring method can only be considered to have failed if after testing it provides no logical answer.

Before testing the system on a machine, I checked the reading speed and accuracy. No problems up to 55,000 sheets per hour. Faster than that I was not able to test — however, according to specifications of the hardware used it will work up to 300,000 sheets per hour. The accuracy is achieved using rather complicated maths and collecting a large amount of readings. So, the lower the ink transfer, the higher the number of readings needed for an accurate ink/glue transfer value. For glue consumption, this is around 1,000 products. For ink, around 500 depending on the start-up effect.



Wilbert Streefland
Technology Coaching

I tested the ink transfer measuring system using different full tone area sizes. The ink consumption data collected correlated well with the change in full tone area when using the same paper, screen roll and ink. After that, I started to do more controlled tests. One of them was comparing full tone print and halftone print. (Note that I use metric dimensions for the test results.) The comparison of full tone and halftone started with printing a full tone area of 0.4488 sqm and measuring ink consumption. Next, I changed the plate and printed a halftone area of 0.17952 sqm. (You calculated right — it's a 40 per cent coverage.) The halftone area had a line count of 22 l/cm. All printing was done on the same Whitetop Kraftliner using the same screen roll and ink. Machine settings were also stable. So let's look at what was found.

The result

Remember that I will only quote two values for ink transfer, but it's based on a large amount of data collected. The ink transfer measured was:

- Full tone area = 1.739 g/sheet
- Halftone area = 1.287 g/sheet

The results look logical, as the value for the halftone area is lower. This value can be normalised and transformed in to a wet ink film layer using the ink density (kg/dm³) and the printing area on the plate.

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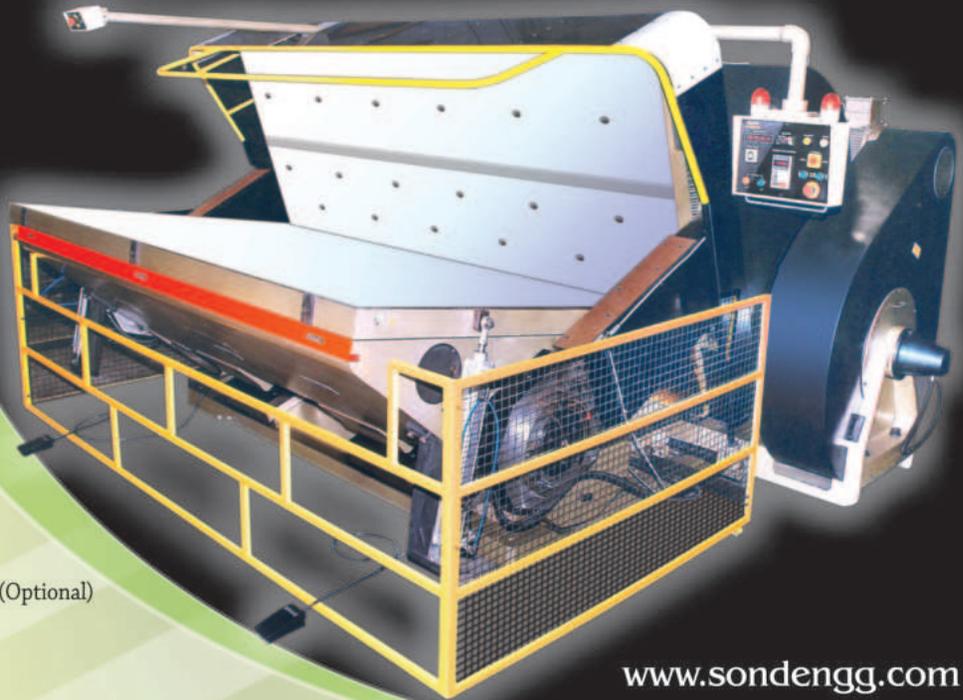
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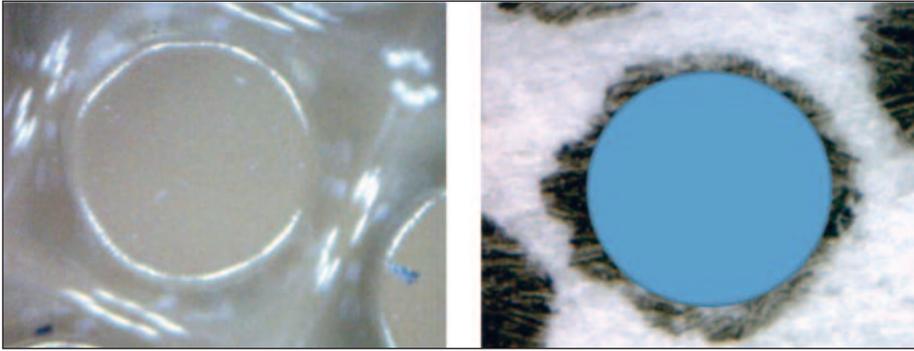
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The following values were calculated for the wet ink film transferred:

- Full tone area = 3.600 pm
- Halftone area = 6.867 pm

We see that the relative ink transfer of the printing area is much higher for the halftone area — one might have assumed that they needed to be similar. Even so, this value is still logical, as the wet ink film available on the screen roll was 11.7 pm. It should be noted that only 30.8 per cent of the available ink is transferred to the paper for the full tone area but is 58.7 per cent for the halftone area.

Let's now look at the printed result to see what these ink transfer results tell us. The following images show the halftone dot on the plate and the printed halftone dot.

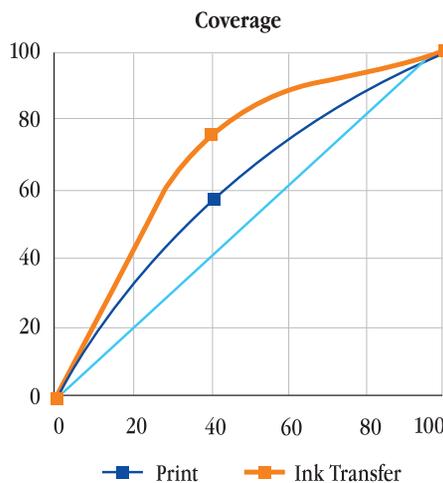
A measuring method can only be considered to have failed after testing the data provided resulting in no logical answer.

I measured the actual dot size on the plate and calculated the coverage the same way in which I analysed the print. The measured 38.8 per cent on the plate is very close to the target of 40 per cent. It showed that the measuring procedure for coverage is acceptable. Using the same method for the dots in print gave a value of 57.8 per cent. (Using image analysis resulted in a value of 54.4 per cent — only minor differences.) I have also put a circle, representing the size of the dot, on the plate over the printed dot to give you an idea of the gain.

It is also possible to calculate coverage for the halftone area based on the ink transfer values measured for the full tone and

halftone area. We can do this if we assume that the wet ink film thickness is identical when printing full tone and halftone. This would result in a predicted halftone coverage of 76.3 per cent! At this coverage, the printed dots would 'melt' together and you would only see 'negative' dots as unprinted areas.

The graph below shows the coverage curve based on the printed dot size and the coverage predicted using the ink transfer data.



Is what we see logical? To some extent, yes, as we know what happens when printing on coated liner — dot gain is larger for coated liner than uncoated liner when using the same settings (screen roll, ink and plate). This can mostly be observed from printed results. But, if you do controlled ink transfer tests then it will show that when using the same ink, screen roll and full tone plate, less ink is transferred when printing on coated liner than when printing on uncoated liner — and we record more dot gain for coated liners.

It is therefore still likely that the ink transfer test results are correct. So, when printing halftones, more ink is transferred than expected and most of this ink is not contributing to the dot size but disappears in the paper. Why? Well, one hypothesis could be that the pressure per unit area for a halftone area is higher than for a full tone area. The pressure between paper and print plate applied on the ink when printing is higher when printing a dot than a full tone area. This is supported by the visual 'donut' shape dot when printing on coated liner. The ink is squeezed to the sides of the dot.

Conclusion

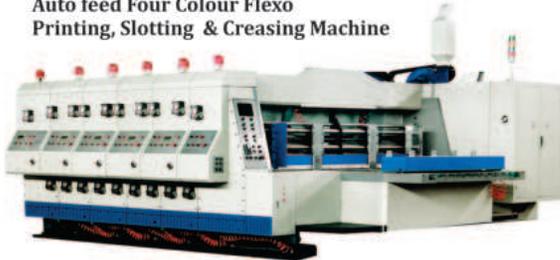
The tests done give us a new insight into what happens when printing. It also shows that it is likely that dot gain for 99 per cent of the time is linked to the amount of ink transferred. That makes deformation of the dot on the plate unlikely to be the sole source for dot gain. That might sound logical, but what about the impact on ink transfer by the screen roll, paper and ink.

The screen roll dictates how much ink is available for transfer. The engraving will influence the release of ink. But can it influence the ink release difference between full tone and halftone so that more or less ink is realised when printing halftone? This needs more testing. The impact on ink transfer by paper and ink also needs more testing before correct answers can be provided.

Mr. Streefland has worked in the corrugated industry since 1992. During this time, he has been technology development manager for SCA Packaging as well as technical manager at Stork Screens. He started technology coaching BVBA in 2005. The readers will recall that he has been regularly contributing articles to this magazine. Wilbert Streefland can be contacted on: wilbert@tcbvba.be



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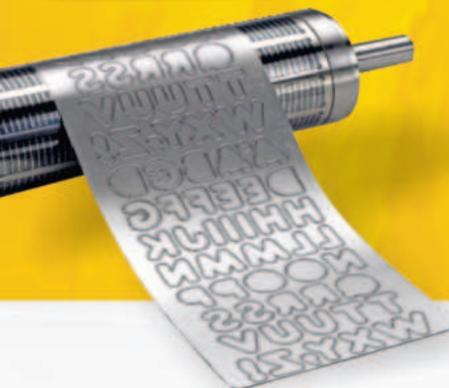
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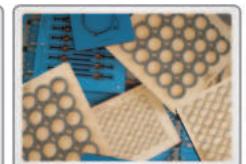
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BOOK STITCHING WIRES FOR AUTO STITCHERS



BOOK STITCHING WIRES FOR MANUAL STITCHERS



BOX STITCHING WIRES FOR AUTO STITCHERS

Manufacturers of : "JYOTI" Brand Stitching Wire

Prime

WIRES PVT. LTD.

PLOT NO. 89, SURVEY NO. 66, OPP. JAY EQUIPMENT PVT. LTD., NEAR SUNITA TOOLS, WALIV FATA, SATIVALI ROAD, VASAI (EAST),
DIST. THANE - 401 208. MAHARASHTRA (INDIA) • PH: 99678 88837 / 93230 23024 • TELE FAX: +91 - 022-2888 7841

E: primewirespl@gmail.com • info@jyotistitchingwires.com

www.jyotistitchingwires.com

Paccess -at the heart of Managed Packaging

**MANAGED PACKAGING
MORE THAN PACKAGING**

SUPPLIER COORDINATION
QUALITY ASSURANCE
PERFORMANCE MONITORING

PACKAGING OPTIMIZATION
PACKAGING IMPLEMENTATION
+ PACKAGING

BUSINESS MODEL:

- Price per packaging unit (management and services included)
- Mandated program for your OEM suppliers



Anders Isaksson
PACCESS, VP Sales and Production

With Managed Packaging, you get the combination of packaging and management services to make your supply chain more competitive.

We provide your OEM suppliers with packaging optimized for your specific supply chain requirements – not theirs

We ensure your OEM suppliers are appropriately trained and work effectively with your packaging – even if you change suppliers

We assure quality and monitor performance of your packaging to ensure your competitiveness – and we continuously look out for further improvements

Big brand names like H&M, GAP and NIKE see the simplicity and financial sense in Managed Packaging by PACCESS. This is what they get with us as their mandated packaging supplier...

THE VALUE OF MANAGED PACKAGING

↑

\$1
invested
gets you
\$10
in return

Operational savings Management simplicity Sustainability performance Revenue generation

On average, every dollar you invest in Managed Packaging – on top of your regular packaging supply – generates ten dollars in pure profit.

At PACCESS we go right to the heart of your supply chain to achieve

- Operational Savings
- Management Simplicity
- Sustainability Performance
- Revenue Generation
- What outcomes can you expect from managed packaging by PACCESS?



Here are some typical operational savings of Managed Packaging by PACCESS

- 15% ocean freight savings – thanks to compact packaging with less empty air inside
- 30% air freight savings – thanks to compact and lighter packaging – less weight
- 50% improved product protections – fewer damaged goods
- Package reuse – 80% fewer outbound cartons purchased domestically

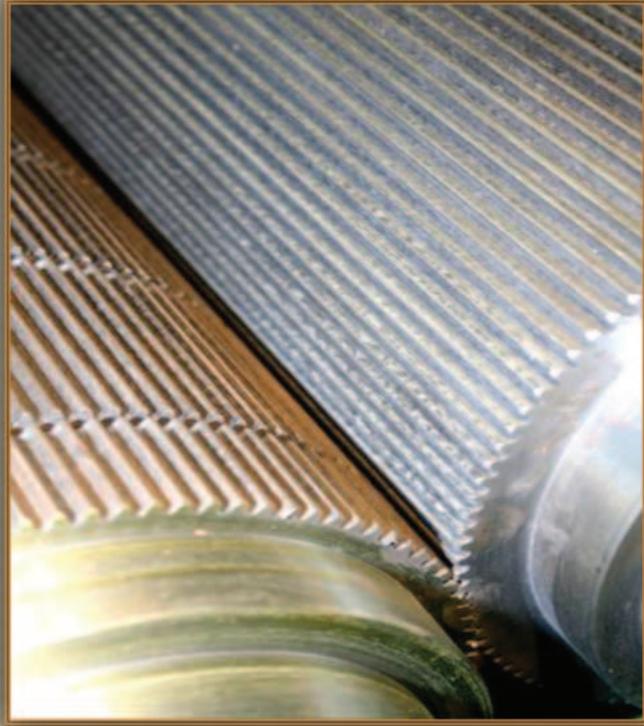
Cont. on - 65



B K G Corrugated

(Corrugated Division of B K Gears Pvt Ltd)

Start Up India - Stand Up India



CORRUGATED ROLLER -

B.K.G Corrugated Is the first and the only Indian Company to Manufacture New as well as Re-Work Induction Hardened High Precision Grounded Tungsten Coated Corrugated Flute Rollers at competitive prices keeping in mind all the cost effective measures directly benefitting Corrugators Across The Globe. We always strive to develop the best Flute Profiles meeting the specific requirements of customers. Consequently we are well known for our Grinding and Coating Quality.

For More Details: Please feel free to contact, we will be happy to help you:

Mr. Raghav Thapar @ +91-98116-68695

Email: bkgcorrugated@gmail.com

Web Page: www.bkgcorrugated.com

Skype: [bkgcorrugated](https://www.skype.com/en/contacts/bkgcorrugated)

DISCOVER MORE AT:





B.K.G Corrugated

(Corrugated Division of B.K Gears Pvt Ltd)

Make In India - Made In India



We Preliminary Test and Certify our Products.



HVOF THREE DIMENSIONAL ROBOTIC TUNGSTEN COATING (GRADE - 4)	LIFE OR PRODUCTION QUANTITY (Million Meters)
COATING THICKNESS (Microns)	28 - 36 Linear
55 - 65 Microns	

For More Details: Please feel free to contact, we will be happy to help you:

Mr. Raghav Thapar @ +91-98116-68695

Email: bkgcorrugated@gmail.com

Web Page: www.bkgcorrugated.com

Skype: [bkgcorrugated](https://www.skype.com/people/bkgcorrugated)



COLD GUM MIXING MACHINE

The Advance Starch Glue Preparing Technology



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INDIA. Pin. 388 121

Phone : +912692236357, +912692239495.

Mobile : +919824018853

Web : www.npmachinery.in

E-Mail : info@npmachinery.in, prakash@npmachinery.in, npmegum@yahoo.co.in



Managed Packaging by PACCESS makes life easier for you with a single point of contact.

- We take care of the packaging-related issues with your OEM suppliers
- Our packaging experts will stay in touch with them directly

We also deliver measurable sustainability improvements!

Reduced carbon footprint thanks to improved loading efficiency. On average, we save:

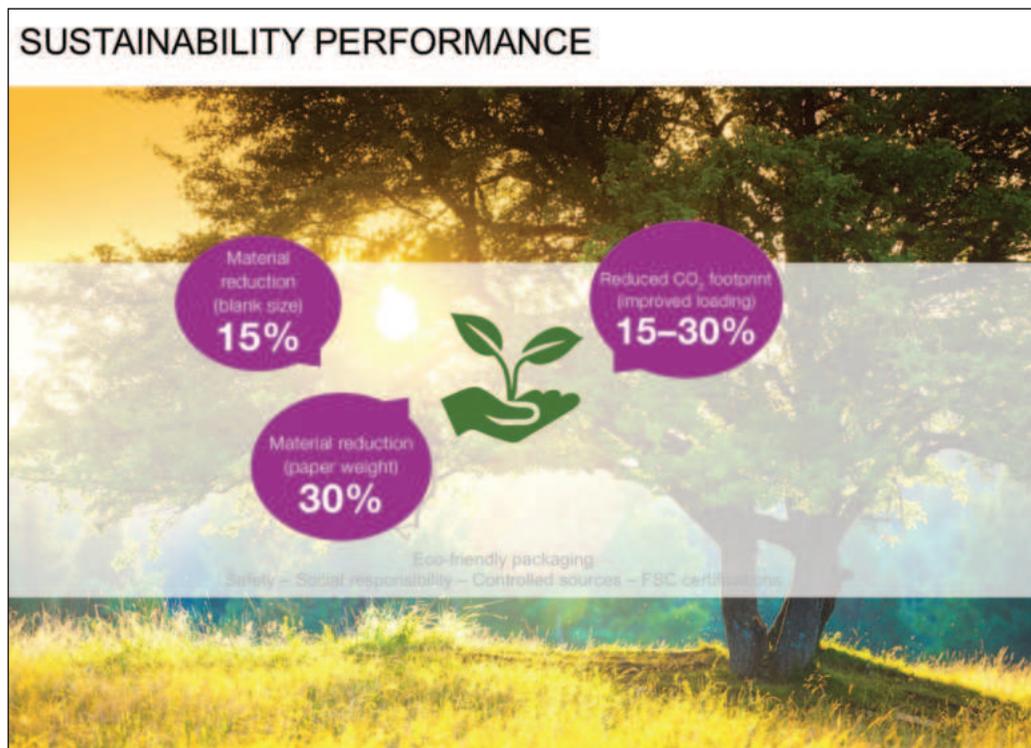
- 15% CO2 from ocean freight – thanks to compact packaging with less empty air inside
- 30% CO2 from air freight – thanks to compact and lighter packaging – less weight

We also help you reduce consumption of packaging material:

- 15% blank size reduction – thanks to more compact packaging
- 30% paper density reduction – thanks to lightweighting and more compact packaging

Eco-friendly packaging

- 100% renewable
- 100% recyclable
- 100% biodegradable



Social responsibility

BillerudKorsnäs' Code of Conduct – based on the UN Declaration on Human Rights and other international guidelines* – emphasises the importance of personal responsibility for good business ethics and for showing care and respect for the people and communities we touch. This always involves combating corruption fighting

child labour, protecting the environment and safeguarding the rights of employees.

**UN Global Compact (www.unglobalcompact.org) the OECD's guidelines for multinational companies and the ILO's convention on decent working conditions.*





MING WEI GROUP



ORanda



THE NO.1 CHOICE IN CHINA

The Concept of Extreme Value



T.LONG-618 MINI IN LINE (Fixed Type)



Computerized Flexo Printer Slotter Folder Gluer T.LONG-1 / 2 IN LINE



High Speed Corrugator Line

MAX-250/300



Baling Press



Conveyor System



MING WEI PAPERWARE MACHINERY CO., LTD. No. 1, Qingquan Rd., Shalu District, Taichung City 433, Taiwan TEL: +886-4-26153117 FAX: +886-4-26154017 www.mingwei.com.tw E-mail: mwcoldt@ms15.hinet.net General Manager Mr. Chien Fu Chuan's Phone Number: +886-988057839



MING WEI MACHINERY (DONGGUAN) CO., LTD. Fu Min Industry Area, Da Lang Zhen, Dongguan City, Guangdong Province, China TEL: +86-769-82979100 FAX: +86-769-82979110 E-MAIL: mwdg999@163.com Contact person: China Operation CEO Mr. Tu Hong An Phone Number: +86-13510365010

SHANDONG MING WEI PACKAGE MACHINERY CO., LTD. 8, Zhuhai Street, Economic Development Area, Haiyang City, Shandong Province, China TEL: +86-535-3206388 FAX: +86-535-3206377 www.qdmingwei.com E-mail: sdmw88@163.com General Manager Mr. Liu Ming De's Phone Number: +86-13805326737

DUBAI BRANCH P.O. BOX 26985 DUBAI U.A.E TEL: +971-4-2270354, 2288061 FAX: +971-4-2246572 MOBILE: +971-50-6457615 E-mail: mwzhaoguang@hotmail.com

REVENUE GENERATION



- This can lead to an 20-40% increased sales conversion according to the global association for marketing at retail – POPAI (Point of Purchase Advertising International)*
- PACCESS can help you translate more of your creative design intents onto the real consumer-facing packaging thanks to excellence in packaging implementation and quality assurance.
- This is how we make a difference to your sales conversion rate. We call this factor – Design Intent to Real Impact

Finally, we can help you boost revenues. For instance we can help you:

- Increase speed to market – faster packaging implementation
- Help you get greater return on your packaging design initiatives – by excellence in packaging implementation and quality assurance

Speed to market

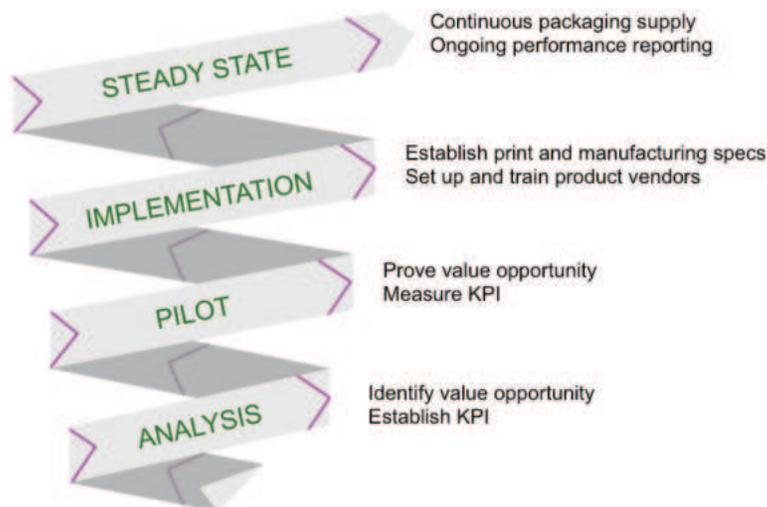
- Would you benefit from faster packaging implementation – and speed to market?
- How would you turn this agility into your advantage?

Design intent to real impact

- Superior shelf impact and point-of-sales campaigns create stronger shopper attention in-store

- Even a small improvement has a great impact on your profitability – and should not be neglected. What would a 2% difference – i.e. 2% top line growth – mean for your business?

HOW WE DELIVER



We deliver Managed Packaging in three distinct steps:

- Analysis
- Pilot
- Steady state

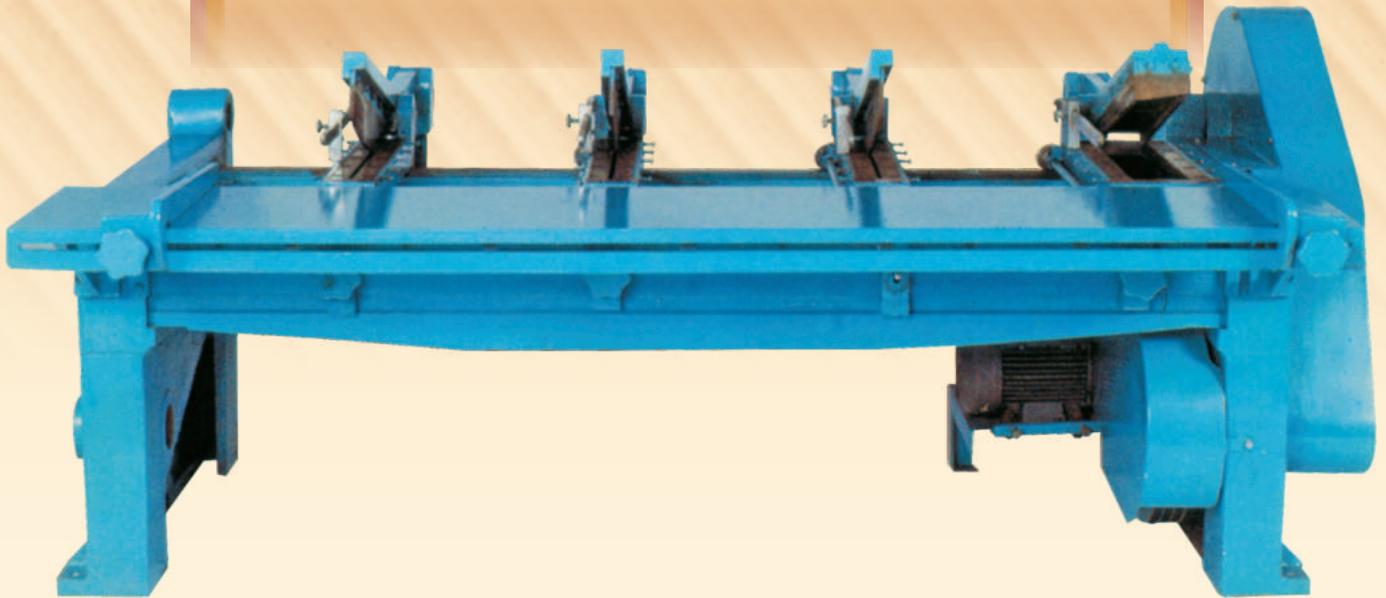
Once the packaging solution is implemented, we continuously look for further improvements to your packaging. That's why we like to visualize our model as an upward moving spiral.

Cont. on - 71

KESHAKA®

ECENTRIC SLOTTER

*For Fine Finishing and
Superior Performance*



FEATURES

- Built robust with excellent finish in the true Keshaka Tradition
- Eccentric Roller is finely ground, duly hard chromed plated, for easy movement of arms.
- Eccentric System placed on rear side, unlike in conventional machines, where it is placed overhead.
- Drive motor placed inside the machine, saving floor space
- Machine consists of 3 sets of slotting arms and one corner cutting arm.
- Arms fall in stepped descending manner, ensuring superior quality finish.



Due to continuous improvement,
specifications are subject
to change without notice.

Manufacturers :

KESHAKA WORKS

14, Ishwar Bhavan, 'A' Road, Churchgate, Mumbai - 400 020.
Tel.: 22040083, 25823857, 25837517 TeleFax: 022-22871412
E-mail: poddar_kamal@yahoo.com Web Site: www.keshaka.com

KESHAKA®

Corrugated Board Sheet Pasting Machine



FEATURES

- Only on one side, two hand wheels are provided in the machine for setting gum rollers and pressure rollers instead of 4 hand-wheels provided in conventional machine
- Gum and pressure-rollers automatically set on the other side of the machine. No need to set the roller on the other side.
- Gum and pressure rollers can be set in microns as desired.
- Saves time and gum and the final product dries soon because of the minimum gum application
- All rollers are balanced, ground and hard chrome plated regulating life of the machine
- All rollers are fitted with ball bearings resulting in smooth running
- Rubber seals provided on both sides of the rollers for protection of ball bearings from water while cleaning the machine after the end of shift.
- Robust construction and excellent finish.
- Available in sizes of 65", 75" and 85". Other sizes as required can be supplied on request.



Manufacturers :

KESHAKA WORKS

14, Ishwar Bhavan, 'A' Road, Churchgate, Mumbai - 400 020.

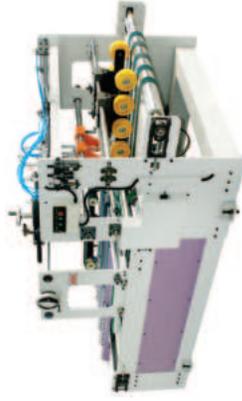
Tel.: 22040083, 25823857, 25837517 TeleFax: 022-22871412

E-mail: poddar_kamal@yahoo.com Web Site: www.keshaka.com

INSUN



AUTO FOLDER GLUER + DOUBLE STITCHER + COUNTER EJECTOR + BUNDLER



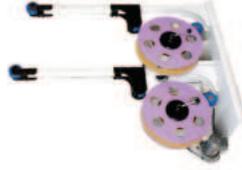
Counter Ejector



Stitcher



Strapping



Wire Holder

Manufactured by
INSUN Co., Ltd.
64, Hwanggeum 2-Ro,
Yangchon-Eup,
Gimpo-City, Gyeonggi-Do,
Korea 415-843
Tel : +82 32 564 5013
Fax : +82 31 997 5014
Email : insun@insunco.com
www.insunco.com

INSUN

India Office

Address : PLOT NO. 26, METHA NAGAR,
M.M.C. POST, CHENNAI - 600 051.
Mobile : +91 98849 50600

Specifications			
Model No.	ES - 25	ES-28	ES-32
Max. Sheet Size	1,000 x 2,200 mm	1,200 x 2,500 mm	1,200 x 2,900 mm
Min. Sheet Size	300 x 900 mm	300 x 900 mm	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		180 M/Min	
Max. Stitching Speed		85 Sheets/Min	
Main Power		15 Kw	
Sheet Thickness		Corrugated Board 3 - 10 mm	



SEGMENTS



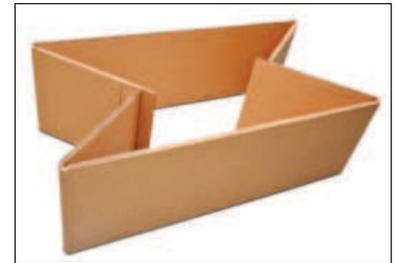
Apparel



Footwear



Toys



Heavy Duty



Home Improvement



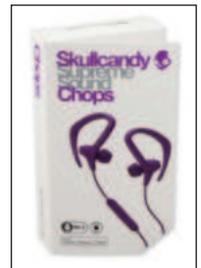
Automotive



Fresh Produce



Sporting Goods



Other

EXAMPLE OF HOW TO GET MORE FOR LESS

Lap top box suitable for air freight



Cont. on - 75



agnati
impianti per cartone ondulato
corrugating machinery

INNOVATION IN CORRUGATED FOR TOTAL QUALITY & SAVING



SUPERIOR TECHNOLOGY COMBINED WITH SUSTAINABLE SOLUTIONS

- Higher Performance
- Higher Reliability
- Perfect Quality
- Lower Energy Consumption
- Lower Costs of Ownership
- 24/7 Service



ADVANCED CORRUGATORS - AUTOMATION SYSTEMS - CORRUGATING ROLLS - SPARE PARTS & SERVICES

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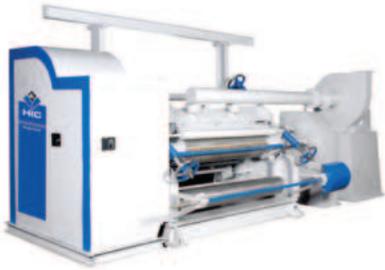
HIC SALES INC. India

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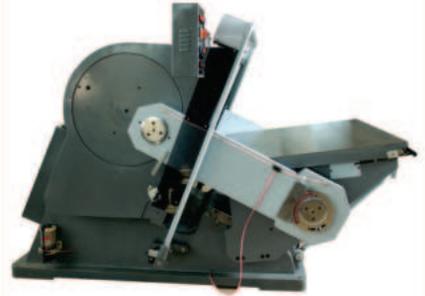
Innovative, Economic Solutions...



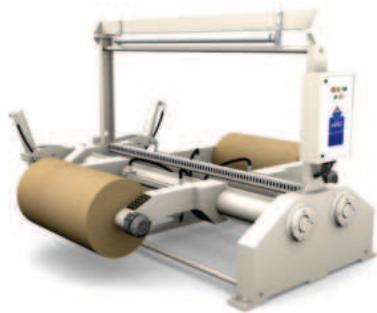
FINGER LESS SINGLE FACER



DOUBLE FACER

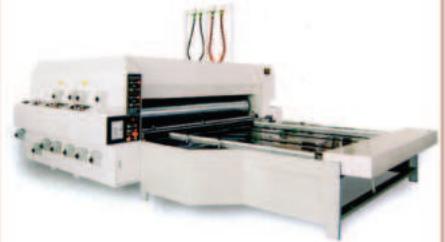


DIE CUTTING & CREASING MACHINE



SHAFTLESS HYDRAULIC MILL ROLL STAND

**Corrugated
Board
& Box Making
Machines**



FLEXO PRINTER



'India's Fastest 5 Ply Combined Automatic Paper Corrugated Board Making Plant with Production Speed of **125 Meter Per Minute** Running at **Aggarwal Corrukrafts Pvt. Ltd.**

HIC MACHINERY CO.

Near Verka Milk Plant, Verka, Amritsar - 143501 Punjab (INDIA)

E-mail: hicmcs2@gmail.com, hicmco1@yahoo.com

Off.: +91 183 2263041 **Sales:** 95018 51111, 95016 45555, 95016 25555

Service: +91 95015 73333 / 95015 93333 / 95010 87444 **Elec. Service:** 95010 89444

www.hic-corrugated.com



More than 100 Successful
Installation Across India.



AS 009 - Semi Auto 2 pcs. Box Stitcher



AS 016 - Semi Auto Stitcher
AS 016A- Semi Auto Stitcher with Servo Drive



Optional Available:
Auto Wire Feeder for 30kg Coil

AS 027 - Semi Auto Gluer



AS 2009 S/G - Fully Auto Stitcher / Gluer



TCM

TCM - Made in Taiwan

High Speed Automatic
&
Semi-Automatic
Stitching and Gluing Machines

Salient Features of TCM

Two Piece Box Stitcher AS 009 with (servo drive)

- 1) Made in Taiwan
- 2) High Speed Stitching
- 3) No Training Required
- 4) With Touch Screen Menu
- 5) Three minute quick order change
- 6) Single/ Double and Tie nail stitching (//////, // // // //, // // // //)
- 7) Max Sheet Size: 3000(L+W)x2 = 6000 x 2850mm
- 8) Automatic Counter Ejector

Semi Auto Stitcher

AS016A with (Servo Drive & Touch Screen)

- 1) Made in Taiwan
- 2) High Speed Stitching
- 3) No Training Required
- 4) One minute quick order change
- 5) Single/ Double and Tie nail stitching (//////, // // // //, // // // //)
- 6) Max Sheet Size: 3700 x 1515mm
- 7) Automatic Counter Ejector

Semi Auto Gluer AS 027

- 1) Made in Taiwan
- 2) Roller type gluing (continuous gluing) or Extrusion type: 2 or 3 line extrusion with PLC
- 3) Outside flap Gluing possible in Extrusion type
- 4) No Training Required
- 5) Max Sheet Size: 2740 x 1515mm
- 6) Automatic Counter Ejector

Complete Sales and Service Support by



SUPACK AUTOMATION

Pattni Bldg., Ground Floor,
Dhebar Road, Rajkot - 360001
Gujarat - INDIA

Email : sa@supack.com

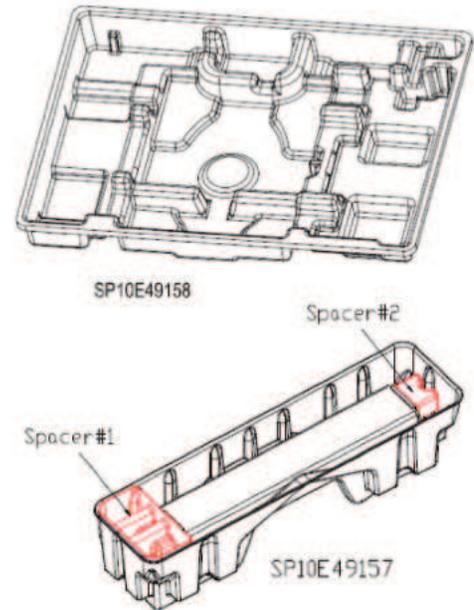
Contact: Mitul A Shah

Phone: +91 281 2783331

Mobile: +91 98242 20250

CURRENT SOLUTION

- Current Packaging gross weight approx. 3.2kg
- The laptop and battery weight approx. 1.8kg
- The charger and manual weight approx. 700g
- Box weight approx. 370g
- Oasis pulp tray weight 145g
- Plastic RLDPE inserts weigh together 180g



SUMMARY WEIGHT SAVING POTENTIAL PER UNIT

	MOC [gram]	Inserts [gram]	Tray [gram]	Sum [gram]	Air Freight* [US\$]	Freight saving [US\$]
Current	365	180	145	690	1,73	0
Suggestion 1	320	126	70	516	1,29	0,44
Suggestion 2	245	126	70	441	1,10	0,63

*) Based on Air Freight Cost 2.5 US\$ / kg

Suggestion 1: MOC (Master Outside Carton)

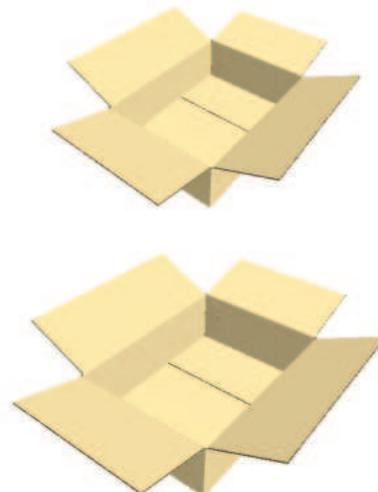
Current

- Standard FEFCO 0201 388x290x126
- Total weight approx. 365 g (640g/m²)
- BCT ≈ 400 kg, ECT ≈ 50, burst ≈ 300
- Board 250KL/100M/250KL*

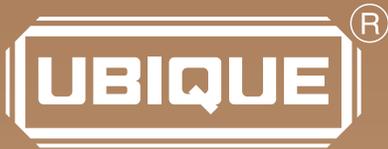
*) US kraftliner and local recycled medium

Suggested

- Standard FEFCO 0201 388x290x126
- Total weight 320g (560g/m²)
- BCT ≈ 410 kg, ECT ≈ 57, burst ≈ 245
- Board 100% virgin fibre FSC
- **Weight reduction 45g or 12%**



Cont. on - 79



The Widest Range of Testing Equipments,

Saurashtra – a trusted name in Testing Equipments

Pioneers in the development of testing equipments, Saurashtra has etched for itself a premier position in the field of testing of packaging materials and packages. Since over 25 years, Saurashtra continues to enjoy the trust and confidence of manufacturers and users of packagings as well as leading institutes and laboratories. Today there are over 7000 satisfied customers in India and abroad using equipments of Saurashtra.

With a wide range of equipments for scientific and accurate testing of paper, paperboard, corrugated boards & boxes, Saurashtra stands out as a single window for testing equipments - ably supported by technical backup and prompt service.

Now, Saurashtra also offers equipments for testing plastics and other packaging materials as well as engineering and automobile industry.

Figures Speak for Precision and Performance !

- Over 50 Years of Experience in Corrugated Packaging
- Over 40 Years Experience in Testing Equipments
- Over 15000 Equipments Supplied in India
- Over 200 Equipments Supplied in International Market
- Over 7000 Satisfied Customers in India and Overseas
- Over 2000 Customers in 400 cities being offered after-sales-service across India

Other Equipments available

- Specimen Cutter for GSM, Ring Crush & Edge Crush Tests
- Specimen Maker (Flutter) for Concora Medium Test
- Dart Impact Tester
- Torque Tester
- Air Permeability Tester

All Digital Models are also available with Integrated Computerised Touch Screen Control Panel

Box Compression Strength Testers



Measures ability of the container to resist external compression loads during transit and storage. The ultimate test for determining overall quality and performance of the packages.

Available in:

UBC1M/1T - Digital Model

UBC1M/1T-P - Microprocessor based Digital Model

UBC1M/1T-TS - Fully automatic with computerised touch screen control panel Model

Bursting Strength Testers



Available:

2-in-1 Type, Paper Tester & Board Tester in Various models like Dual Pressure gauge model, Digital economy model, Fully Automatic Digital Model, Fully Automatic Microprocessor based Digital Model, Fully Automatic with computerised touch screen control panel.

Two-in-One Digital Economy Model Paper & Board Tester

- Two Diaphragm Seats
- Digital Indication of readings
- Peak Hold facility
- Manual Clamping

Crush Tester



Useful for determining Edge Crush, Flat Crush, Pin (Ply) Adhesion of Corrugated Board and Ring Crush and CMT of Paper and Paperboard.

Available in:

UCR - Digital Model,

UCR-P Microprocessor based Digital Model

UCR-TS Fully automatic with computerised touch screen control panel.

Conforming to National and International Standards

<p>Puncture Resistance Tester</p> <p>Gives reliable indication to evaluate fabrication factors along with material values in a composite fashion.</p>  <p>Available in: UPR - Analogue Type UCR - DIGITAL Microprocessor based Digital Model</p>	<p>COBB Tester</p>  <p>Determines water absorption/penetration (cobb value) of paper and paperboard as specified in standards.</p> <p>Model: UCOB</p>	<p>Substance Indicator</p>  <p>Measures directly substance of paper, paperboard and other materials in terms of G.S.M.</p>
<p>Caliper Thickness Gauge</p>  <p>Measures Caliper thickness of variety of materials.</p> <p>Available: UCTG01 & UCTG01-D With 10mm capacity and least count of 0.01 mm UCTG001 & UCTG001-D With 1mm capacity and least count of 0.001 mm UCTG002-D With 20mm capacity and least count of 0.001 mm</p>	<p>Internal Ply Bond Tester</p>  <p>To Determine the Internal Bond Strength of Paper, Board and Laminates</p> <p>Model: UIBST Microprocessor based Digital Model supplied with Sample Preparation Station as per the standards.</p>	<p>Sample Cutter</p>  <p>Model: USC for preparing various paper samples for GSM, RCT etc...</p>

Introducing PAPER MOISTURE INDICATOR

Features	
Pre-set Material Modes	View Saved Reading
<ul style="list-style-type: none"> ◆ Paper (4.7- 18.2%) ◆ Arbitrary (8 - 100%) ◆ Baled scrap paper (6-40%) 	<ul style="list-style-type: none"> ◆ Total Reading ◆ Min Reading ◆ Max Reading ◆ Average reading
<ul style="list-style-type: none"> ● Easy to operate 	With Attachments can be used for Waste Paper
<ul style="list-style-type: none"> ● Hand held equipment 	Total Memory of 300 readings (100 readings in each mode)
<ul style="list-style-type: none"> ● Direct Instant reading 	Low battery Indicator
<ul style="list-style-type: none"> ● Back Lit 2 line LCD Display. 	Buzzer sound to alert for out of range readings



Model: U2100

Marketed by:



SAURASHTRA SYSTOPACK PVT. LTD.

CIN-U33123MH1998PTC113502

102 & 104, Shilpin Centre, 40, G. D. Ambekar Road, Wadala, Mumbai - 400 031, India.

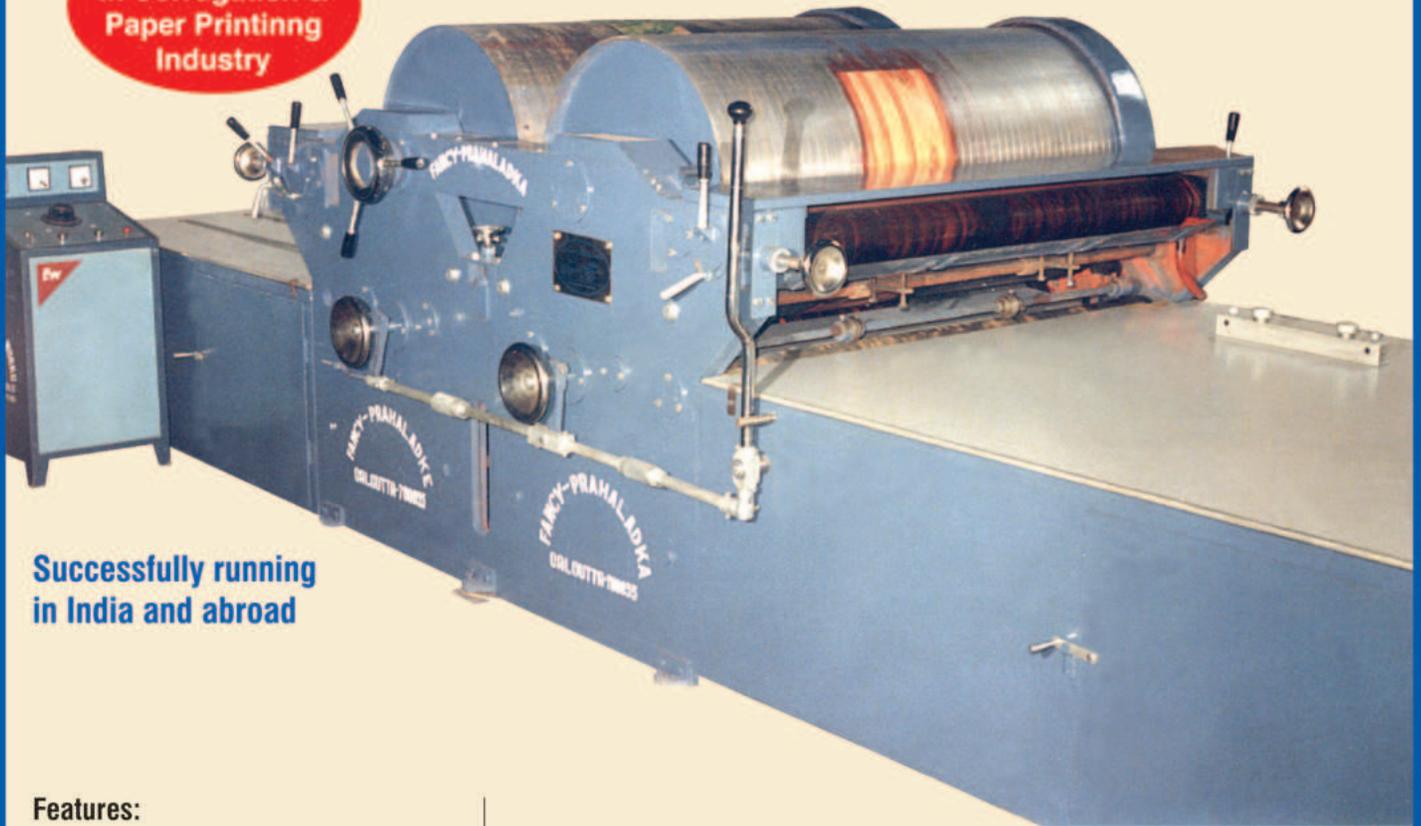
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Sheet Fed Flexo Graphic Printing Machine

A Revolution
in Corrugation &
Paper Printing
Industry



Successfully running
in India and abroad

Features:

- Most modern and versatile
- All controls of feed paper are grouped together and placed within easy reach of the operator
- Smooth and low noise operation
- Reliable After Sales Service

Advantages:

- Easy to operate
- Sharp and clear printing
- No folding of paper and board required

- Small sizes can be printed in double and triple ups
- Negligible job setup time
- No drying time required
- Low ink consumption
- Reduces ink, electricity cost substantially
- Variable speed drive
- Can operate both with spirit-based and water-based inks

We also Manufacture:

- Roto Gravure Printing Machine
- Flexo Graphic Printing Machine
- Slitting Machine
- Corrugated Sheet Dryer
- Lamination
- Printing, Packing & Allied Machinery



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55B, Kali Temple Road, Kolkata - 700 026.

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Fax: 91-33-2455 5182 / 4452

E-mail: pioneerpackaging@vsnl.com

Website: www.fancyprahladka.com



Manufactured by:

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5, Bireswar Dhole Lane,
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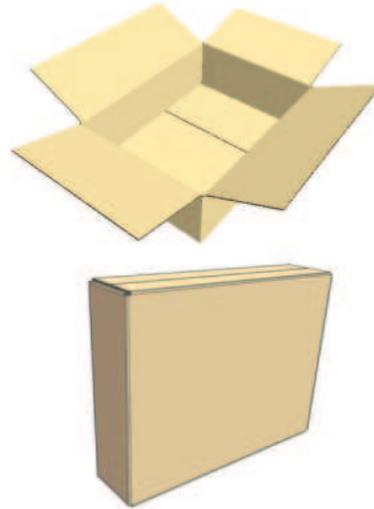
Suggestion 2: MOC (Master Outside Carton)

Current

- Standard FEFCO 0201 388x290x126
- Total weight approx. 365 g (640g/m²)
- BCT ≈ 400 kg (stacked 9 high)

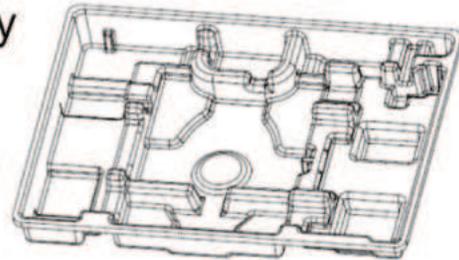
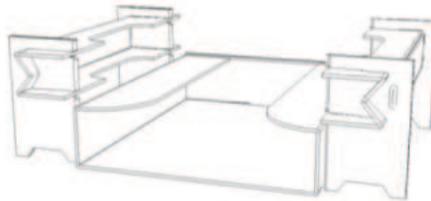
Suggested

- Standard FEFCO 0201 **388x126x290**
- Total weight 245g (560g/m²)
- BCT ≈ 250 kg (stacked 4 high)
- **Weight reduction 120g or 33%**



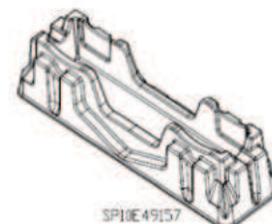
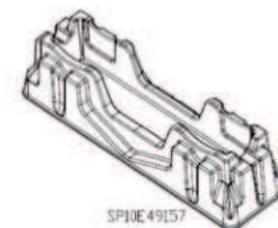
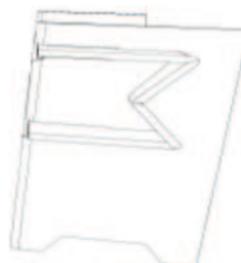
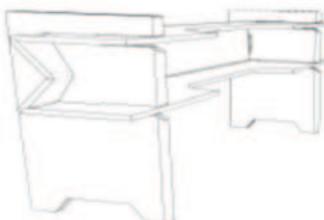
Corrugated Tray vs Oasis Pulp Tray

- Current OCC-solution weight 145g
- Tray to hold battery and publications weight 70g
- Weight reduction 75g or 52%



Corrugated Insert vs Current RLDPE Solution

- Current RLDPE-solution total weight 180g
- 3 piece corrugated solution total weight 126g
- Weight reduction 54g or 30%



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The longest continuous history and tradition of Innovation Leadership,
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and True Partnership with customer



Single Facer Paper
Corrugating Machine with
Twin Flute



Sheet Pasting
(4 Roller) Machine



Rotary Sheet Cutter



Oblique Type Single Phase
Paper Corrugating Machine



4 Bar Rotary Cutting
& Creasing Machine



3 Col Auto Feeder Flexo
Printer Slotter Creaser with Stacker



Two Colour Board Printing Machine



Regular Sticking Machine



Single Colour Craft
Paper Printing Machine



Eccentric Slotter



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SUMMARY FREIGHT SAVING POTENTIAL

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- New solution 2.75kg
- Freight = US\$ 2.5Kg
- Savings when 4 500 000 computers delivered

US\$ 4 961 000



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Anders Isaksson has been working for Paccess during the last two and a half years as VP Sales and Production. Before joining Billerud Korsnas and Paccess he was working within the corrugated industry for 26 years in different positions.

4 years in the production, on the corrugator, at flatbed die cut and

printing line, at the inline machine, he has done some 5 years in the calculation and order prepare department. Purchaser, planner and production manager for about 3 years. Structural designer for about 4 years. Sales and Key account manager for 6 years. During the last 4 years he worked as a plant manager for

two plants, one in Sweden and one in Norway. Managing total production of about 120 000 000 m2 or 60 000 tons yearly with a total of 350 employees.

This is a presentation made during Corrupack Summit 2015 held at Hyderabad and hosted by APCMA.

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The Crushless Corrugator

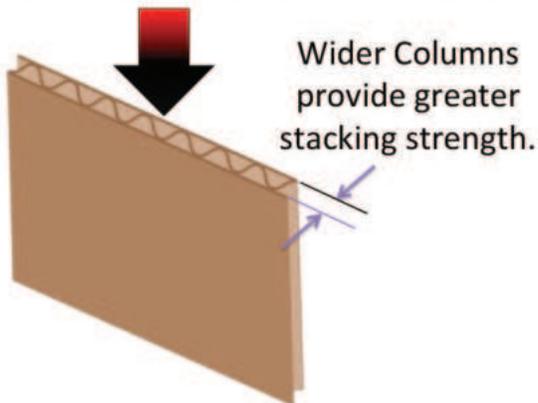
Defining Characteristic of Corrugated:

- Stacking Strength to Weight Ratio



Jack Johnson
V. P. Sales - New Markets
MarquipWardUnited

Board Caliper Provides Column Strength



McKee Equation for Box Top-to-Bottom Compression

- $TBC = 2.028 ECT^{.746} \times FSI^{.254} \times Z^{.492}$

Where: ECT = Edge Crush Test
FSI = Flexural Stiffness Index
Z = Box Perimeter

Impact of Crush on Corrugated

- Reduces Caliper
- Reduces ECT
- Affects Flexural Stiffness
- Softens Board
- Reduces Stacking Strength

Payback for Elimination of Crush

- Crush Adversely affects ECT and FSI
- ECT and FSI are proportional to fiber content
- Eliminating crush allows fiber reduction

Tons per year run	=	80,000
Cost Per Ton	X	\$500
Paper/Fiber Cost per year	=	\$40,000,000
% Fiber Savings	X	1%
Fiber Savings per year	=	\$400,000

HOKO - The No.1 Brand In Stitching Wires!



HOKO brand stitching wires are available in Galvanized, Copper Coated, Pure Brass, Pure Copper, & Rust-Resistant Finishes. In Round, Flat and Narrow Flat Sizes.

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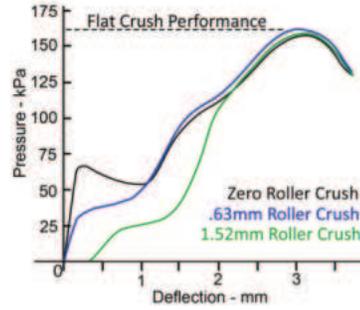
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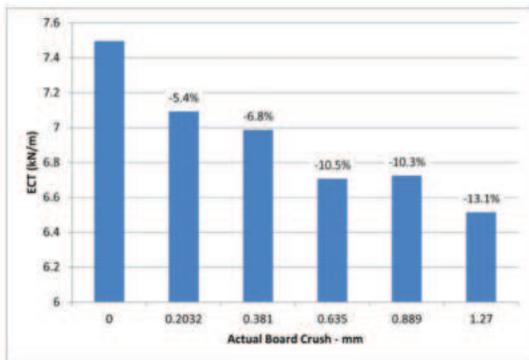
Measuring the Impact of Crush



Roller Crush versus FCT



ECT versus Crush



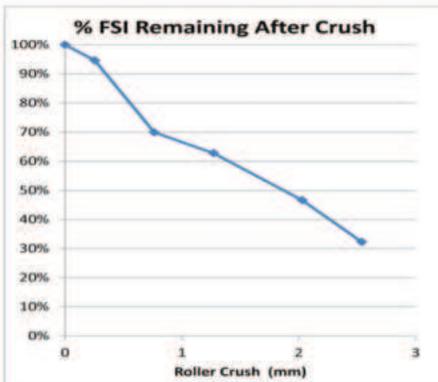
Sources of Crush on the Corrugator

Roller Nips and Belt Nips

- Rider Roll on Glue Machine
- Traction Section of Doublefacer
- Infeed Pull Roll on Knife
- Exit Pull Roll on Knife
- Stacker Infeed Nip Roll



Flexural Stiffness versus Crush



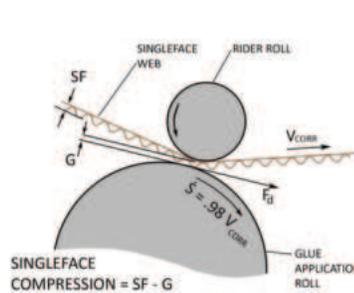
MarquipWardUnited Components Developed to Eliminate Crush

- Eagle Glue Machine with SoftTouch™
- Cool Vac Doublefacer with VTS
- Tail Tracker Measuring Wheel
- Dual Driven Nip Knife Outfeed
- Dual Driven Nip Stacker Infeed

Caliper Loss versus Roller Crush

Roller Crush (microns)	Measured Caliper Loss (microns)
254	81
508	145
762	208
1016	249

Schematic of Glue Machine with Soft Touch™



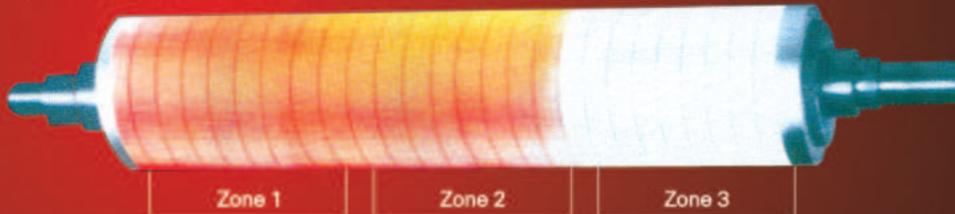
- Glue Roll Drive maintains glue Applicator Roll at 98% Corrugator Speed.
- SFW compression causes drag on the glue applicator roll, reducing the need for drive current.
- Drive Current/SFW Compression relationship allows choice of target drive current to achieve minimal desired SFW compression

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Zone Heating System



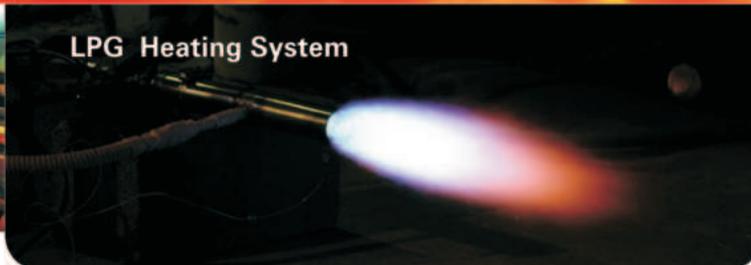
Tubular Heating System



Digital Temperature Controller



LPG Heating System



Hot-Temp Heating Systems

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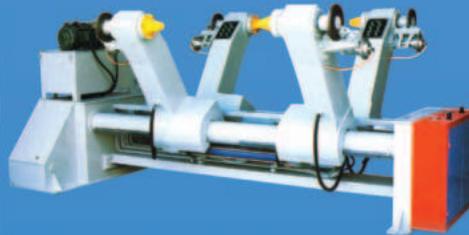
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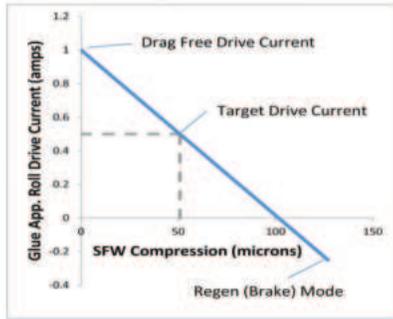
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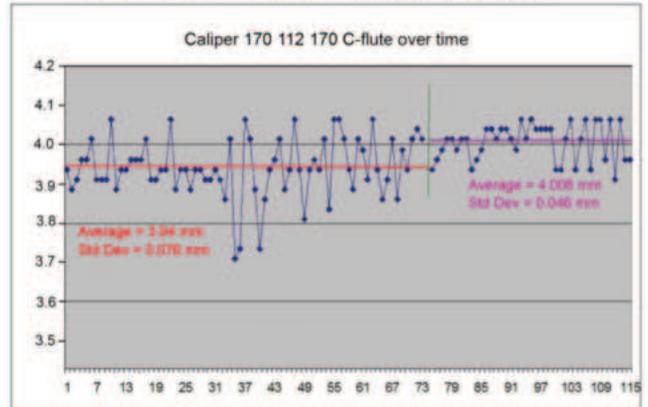
Cool Vac Doublefacer with Vacuum Traction Section



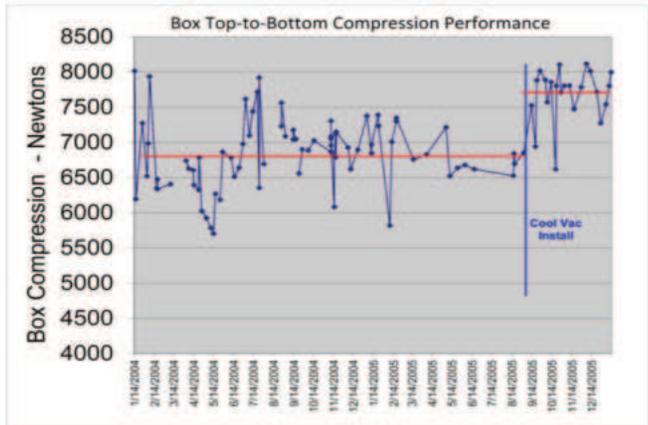
Vacuum Traction Section Belt



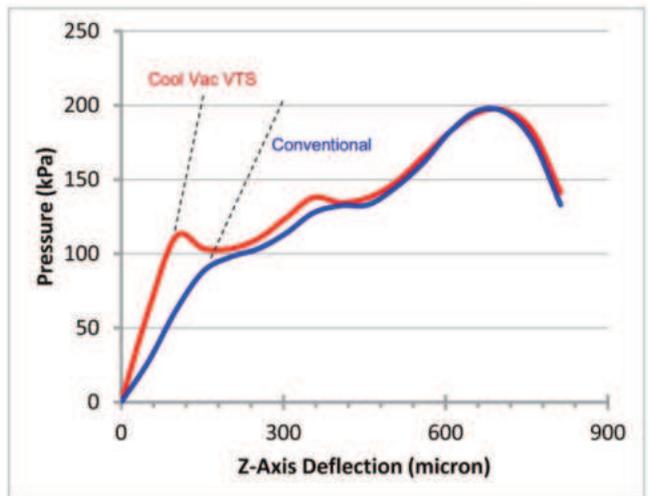
Caliper Gain with Cool Vac Doublefacer with VTS



Top to Bottom Compression Improvement with Cool Vac Doublefacer with VTS



Hardness Improvement with Cool Vac with VTS





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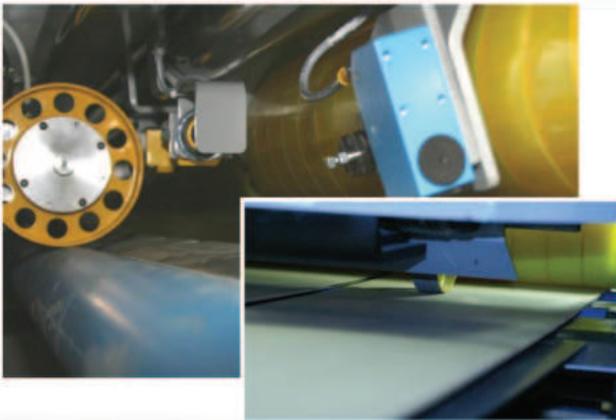
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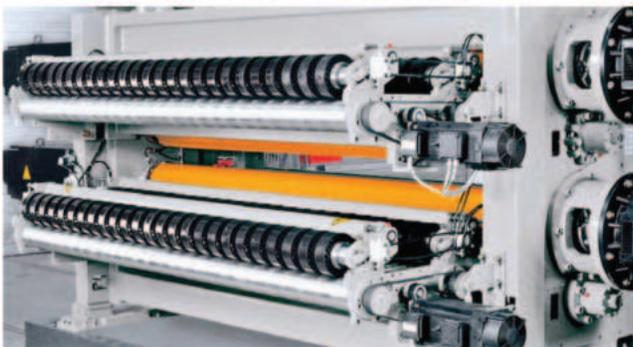
Measuring Roll Causes Crush



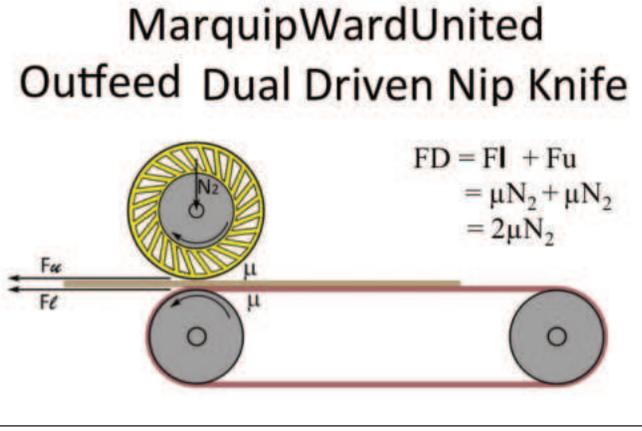
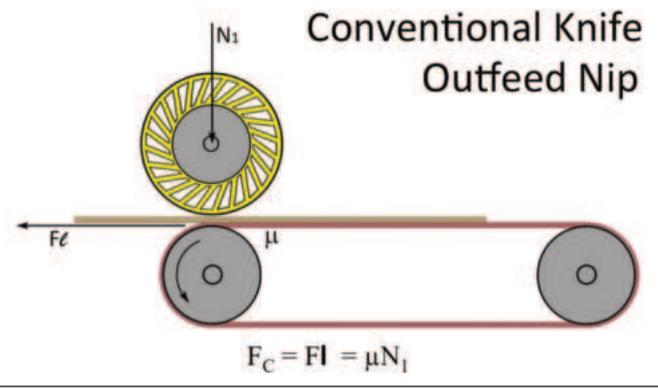
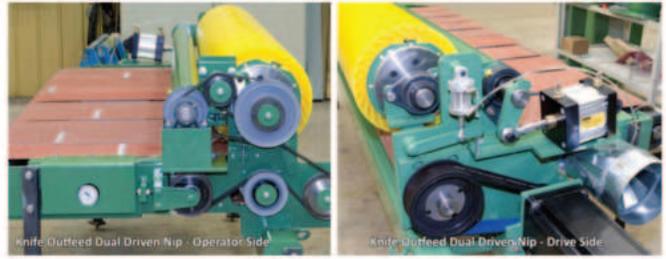
MarquipWardUnited TailTracker Eliminates Crush



Knife Outfeed Pull Roll Nip Causes Crush



Marquip WardUnited Dual Driven Nip Knife Outfeed



Dual Driven Nip uses 1/2 Nip Force

$$F_c = F_D$$

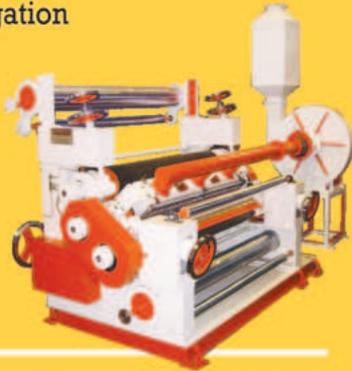
$$\mu N_1 = 2\mu N_2$$

$$N_2 = 2N_1$$

Cont. on - 95

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Fingerless Model



Rotary Creaser Slotter Machine



Single Facer Paper Corrugation Machine



Semi-auto High
Speed Stitching
Machine



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Corrugation
Machine
Fingerless Model



Thin Knife Slitter Scorer



Shaftless Reel Stand



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Two Colour



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Flexo Board Printing Machine
Four Colour



Fully Automatic Flute Laminator



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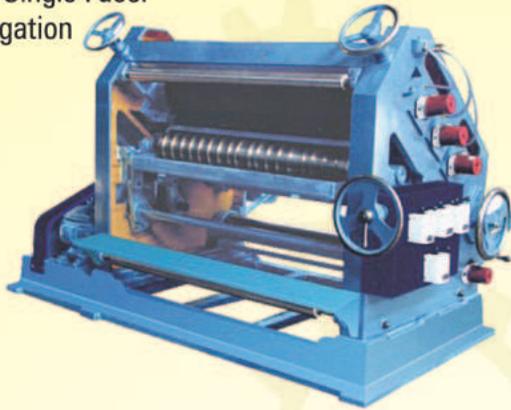
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Dual Driven Nip Stacker Infeed



Summary of Crushless Corrugator

Crush on the Corrugator is caused by roller nips and belts at:

1. Glue Roll on the Glue Machine
2. Traction Section of the Doublefacer
3. Infeed Pull Roll of the Knife
4. Exit pull Roll of the Knife
5. Stacker Infeed Nip

Summary of Crushless Corrugator

Crush Adversely Affects Board Quality

1. Reduction in Caliper
2. Reduced ECT
3. Reduced FSI
4. Softening of the Board
5. Reduction in Top to Bottom Compression

Summary of Crushless Corrugator

MarquipWardUnited Technology Eliminates Crush

1. SoftTouch™ at the Glue Machine
2. Vacuum Traction Section of the Cool Vac Doublefacer
3. Tail Tracker web wheel at infeed of the knife
4. Dual Driven Nip (DDN) at Knife Exit Pull Roll
5. DDN at Entrance to the Stacker

Marquip WardUnited Crushless Corrugator



Jack Johnson-VP Sales-New Markets is Bachelor of Science degree in Electrical Engineering from MSOE in 1981. After graduation, he has been developing corrugated board manufacturing centers which optimize performance of corrugated shipping containers on a World-wide basis.

Starting in Latin America, moving to Europe and EMEA, and then on to Asia, employed by Marquip Ward United, LLC, division of Barry-Webmiller, with all activities specifically focused on the manufacturing and development of packaging solutions.

This is a presentation by MarquipWardUnited, a BW Paper Systems Company, made during Corrupack Summit 2015 held at Hyderabad and hosted by APCMA.

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Industry News

ABB delivers global collaborative production management system to KPAQ's kraft paper mill in St. Francisville, LA

ABB, the leading power and automation technology group has successfully delivered a Collaborative Production Management (CPM) system to KPAQ Industries, LLC at their mill located in St. Francisville, Louisiana.

KPAQ's new CPM system has been integrated to their existing ERP system, various production systems and accounting systems allowing KPAQ to fully utilize ABB's cpmPlus solutions for sales/order management, production planning, production management, decision support and product tracking.

As a result, KPAQ will now be able to streamline their entire operation as all mill functions will be handled in one comprehensive system allowing a single point of access to all pertinent production data. The system will also be able to efficiently scale to correspond with

KPAQ's production growth and potential expansion.

"We had a highly customized system that did not fit our current work environment. The configurable architecture that ABB provides will allow for all the tools and reporting needed for decision making and efficient action," stated Jeff Rake, KPAQ COO.

ABB's Collaborative Production Management (CPM) solutions integrate various manufacturing systems, providing real-time visibility, execution, tracking, reporting, and optimizing of manufacturing processes.

The ABB Global CPM Product provided to KPAQ has been proven to reduce "order-to-cash" time for customer's manufacturing operations, improve throughput, reduce inventory and optimize business processes.

A key benefit of using ABB's CPM system is that KPAQ can streamline its entire operation, handling all mill functions in one comprehensive system to have a single point of access to all production data. The system will also be able to efficiently scale to correspond with KPAQ's production growth and potential expansion.

Beer in wood and cardboard

Unlike more and more wines, beer is still not bottled in cardboard boxes. However, this might change soon. Due to an increasing number of web-based orders, in particular, endeavours are now in progress to reduce the weight of beer packaging as efficiently as possible. A folding box made of recycled corrugated cardboard will soon be competing with



plastic crates. It would not be the first time that the material is changed: metal was followed by wood, and wood by plastic. What's so special about the beerbox is its folding technique, as the box size can be flexibly adjusted to suit requirements, thus simplifying the shipping procedure for breweries and beverage distributors. The design of this innovative box is plain and monotone, avoiding any unnecessary environmental impact due to intensive colour printing.

Bags vs. bottles: pros and cons

Although natural cork enthusiasts find it difficult to admit, bags in boxes are growing in popularity, even among quality wine producers. A wine box is essentially a film-coated plastic bag with a plastic tap. The benefit of this packaging over its energy-intensive competitor, glass, is



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- ✓ Multi layer kraft liner with triple wire: 18 to 45 B.F. with high RCT
- ✓ Top white kraft liner with high brightness
- ✓ Range of GSM – 140 to 450
- ✓ Finish Deckle: 3800mm



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that it emits less carbon dioxide during the manufacturing process and that it is less heavy, so that savings can be made in shipping and customs duties. The questions that are still in dispute are the product life and the taste of the product. While some experts are convinced that a corrugated cardboard box has a particularly long life due to its almost hermetically resealable tap, others believe that this actually shortens its life. Undesirable changes to the fermentation process can modify the taste and cause the drink to become undrinkable more quickly.

Source: *Packaging Technology June-July 15*

Erhardt+Leimer and AVT Announce Signing of Strategic Alliance Agreement

Erhardt+Leimer and AVT Announce Signing of Strategic Alliance Agreement to Provide Wider Range of Integrated Automation Solutions for the Printing and Converting Industries

AVT acquires Erhardt+Leimer's print inspection products; E+L and AVT to offer both Helios and NYSCAN solutions to both companies' customers Erhardt+Leimer, a leader in system solutions and process control equipment to web-based industries and AVT(Advanced Vision Technology),



a leader in print inspection, print process control, and quality assurance, have announced signing and closing of the Alliance agreement between the two companies that will broaden product portfolios and strengthen services for customers of both companies, including end users and OEMs, through solutions born of the two companies' combined experience and technological skills.

As announced by the two companies recently, in a first step AVT will acquire E+L's automatic print inspection solutions and will assume the responsibility to

develop and manage these solutions for both companies' customers in the Label and Packaging applications, including the corrugated segment. In return E+L will be entitled to future earn outs and a cash payment as per the set terms. As part of the agreement, Dr. Michael Proeller, E+L's CEO, will be appointed Chairman of AVT's Advisory Board and serve as an observer on AVT's Board of Directors.

Being an integration specialist, E+L is the ideal partner for the realization of complex automation and inspection solutions. Each company will then offer solutions from both AVT and E+L to all customers.

Combined Technological Expertise Benefits Customers & OEMs

One major achievement of this strategic alliance will be the level of technological know-how it unites. E+L's expertise in web, press and vision systems combined with AVT's inspection, press control and workflow management capabilities will enable the companies to offer unsurpassed end-to-end quality control solutions. The new joint portfolio includes comprehensive solutions such as

The alliance instantly becomes a leading supplier and innovator for the corrugated industry's fast-developing quality control needs. Existing products for corrugated printing will be further enhanced, and plans are in the works to introduce several additional offerings.

Source: *www.erhardt-leimer.com*

FEFCO Launches Standards for Converting Equipment

FEFCO launched its new book presenting 43 conversion equipment standards developed under the guidance of the FEFCO Production Committee, during their workshop in May 2015.

FEFCO Standards for Converting Equipment – Technical Specification for Equipment and Processes was produced because the members of the Production Committee identified Quality as one of the most important parameters.

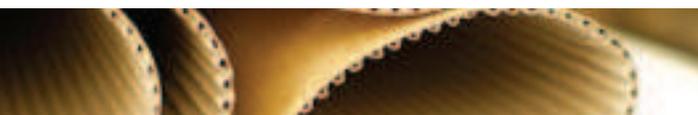


Quality can only be achieved if the equipment and processes are in line with the specifications of the equipment that has been ordered. With this in mind this group of highly motivated industry representatives, which directs FEFCO's technical work, decided to put together these standards to help the industry with the following:

- Enable the like-for-like comparison of equipment properties as described in the 43 standards.
- Avoid the under or over specifying of equipment and products produced and also help define what is needed.
- Help customer and supplier to agree on a level when equipment is ordered and check it when it is delivered.
- Measure and record over time the state of equipment. This also allows for the measurement of the impact of maintenance.
- Set quantitative targets for process improvement for existing and new technologies.

More than 60 delegates attended the Workshop on Acceptance Procedures for Converting Equipment. On the occasion of this workshop the FEFCO book of Standards was distributed to the participants. Later this year, the book will be more widely spread and will be handed out to the 800 delegates who are expected to attend the next FEFCO Technical Seminar (Barcelona, 28 - 30 October 2015). After this seminar it will be available on the FEFCO website.

Cont. on - 103



Shear LINE



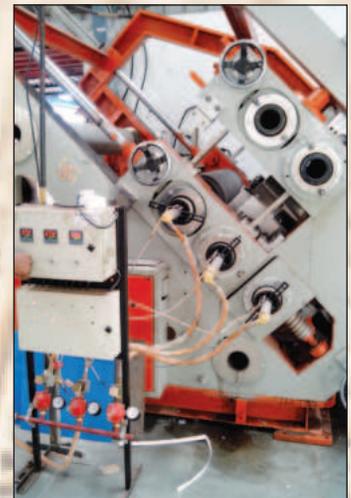
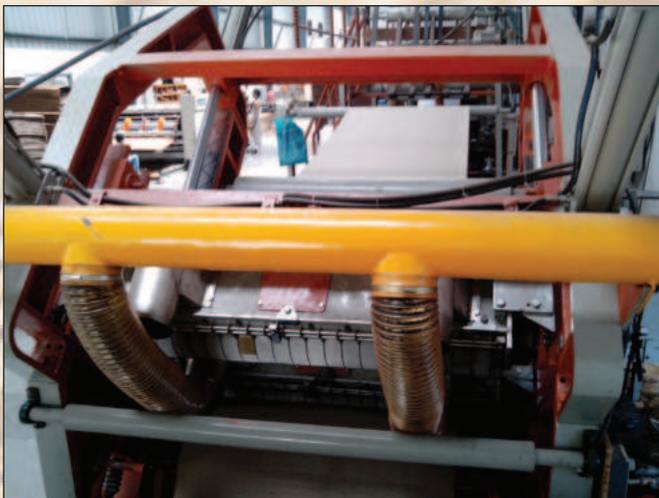
New

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
- **Pressure Roll Dia:** 305mm.
- **Twin Flute Structure:** One Flute Unit working and another ready for immediate order change.
- Heavy Duty Quick Roll Change Cassette System controlled by Hydraulic System for change of flute rolls.
- Corrugated Rolls Made of Special Alloy Steel.
- Built in Pre heating & Pre-conditioning Rollers ensures absolutely secure bonding.
- Heavy duty Hydraulic Power pack.
- Gum Circulating System.
- A. C. Drive for speed control.
- **Available Width:** 1200-2200mm.
- **Flute Profiles:** A,B,C,E, or as per requirement.



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MACHINES THAT MAKE BETTER BOXES *from* DOSHI



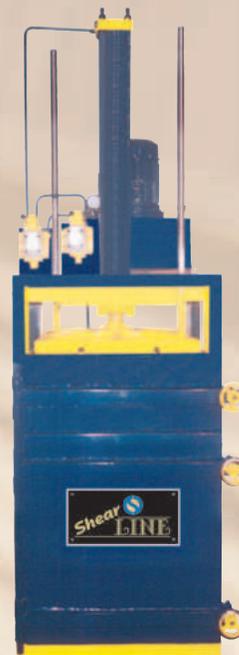
3-Colour Flexo Printer



Flat Bed Die Cutter

Super Shear Line is dedicated to the development and manufacture of innovative machines for the corrugated packaging industry.

In keeping with the trend of the industry which is swiftly switching to Automatic Process – we have developed complete In-line Corrugators, ranging from- 32” 3ply Eflute Plant to 80” 5ply Plant with Numerical Control System



Hydraulic Waste Baling Machine



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SHENYANG DEMAO INDUSTRY BELT CO. LTD. (CHINA)



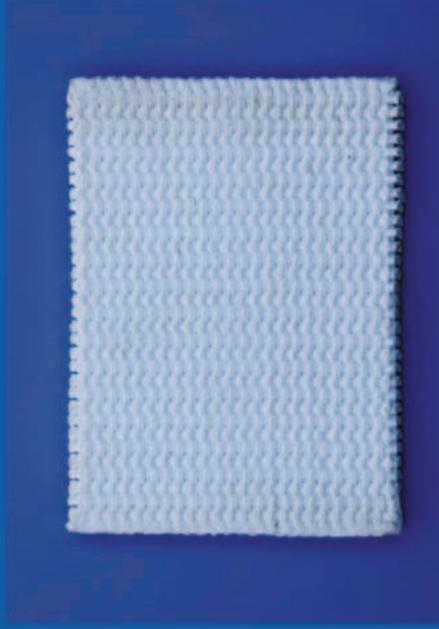
Flocking joint



High-speed corrugated belt



Middle-speed corrugated belt



Traction belt



High-speed Kevlar belt

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Email : osmarketing@yahoo.com, arvindshahi@gmail.com

During this one day event, end-users and suppliers gave useful presentations and shared their experiences and support for implementing these standards. They discovered that it could help them to identify equipment problems and by solving them this could potentially improve overall equipment productivity.

- Marc Van Damme - VPK (FEFCO Production Committee Chairman) chaired the workshop and furthermore was the person who initiated, guided and monitored the whole project.
- Wilbert Streefland (Technology Coaching), author of the book; introduced the 43 standards. He concluded the day by disclosing the pass/fail results of machine tests using some of the standards.
- Richard Coward (Rigid Containers) shared his long experience in equipment purchasing.
- Jan Lindstrom (MarquipwardUnited) showed how MWU uses the standards for checking printing equipment.
- Anello Meloro and Dominique Ravot (BOBST) presented their work on die cutting and what needs testing.
- Ulrich Wolz (Bahmüller) explained the impact of the standards on the folding of boxes.
- Klaus Lüke (Klinge Papierwerke) shared some practical experience by presenting test results using these standards.
- Mats Nilsson (Dücker Corrpap) explained how to use the standards when testing the breaking and palletising process.

Angelika Christ, FEFCO Secretary General, commented "This collaborative work is an excellent example of what our work at FEFCO is all about: gathering industry know-how for the benefit of all!" She also highlighted that this book is a living document and will be updated whenever needed or appropriate.

Finnish pulp and paperboard production continues to grow

Up 1 per cent in the first half of 2015

Production of pulp and packaging paperboard grew in the first half of the year in Finland, according to figures from Finnish Forest Industries. The volume of printing and writing paper production remained almost unchanged from the previous year's level, but softwood sawn timber production contracted. Upcoming industrial policy decisions will have a significant impact on the competitiveness of Finland's forest-based sector.



"A comprehensive societal agreement is needed alongside very moderate pay rises in the next few years if we want Finnish competitiveness to recover. This would enable us to narrow the gap that has developed between Finland and our key competitor countries. Promoting favourable operating prerequisites for the forest-based sector, the most important component of the bioeconomy, makes it possible to realise the expectations that have been placed on the bioeconomy as a driving force for overall economic activity," the Director General of the Finnish Forest Industries Federation says.

Long-term and consistent industrial policies are a prerequisite for the realisation of the forest-based sector's numerous investment projects.

"Concrete action is needed to spur the bioeconomy. Measures with rapid impact must be taken in order to get timber

flowing and safeguard the industry's raw material supplies. The emissions trading compensation included in the Programme for Government should also be introduced quickly. In addition, infrastructure investments must target basic road maintenance, the lower-level road network and boost the efficiency of track transports that strengthen the bioeconomy," he adds.

The forest-based sector plays a significant role in the generation of export revenues for Finland. Forest industry products accounted for 21.7% of national exports in January-May.

Some 5.3 million tonnes of paper and paperboard was produced in Finland in January-June, just under one percent more than in the corresponding period of 2014.

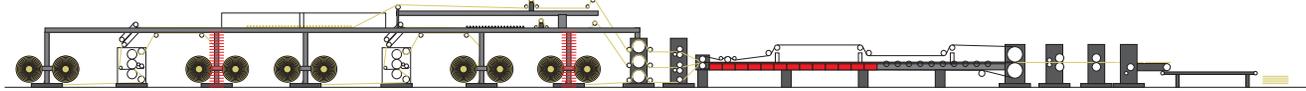
About 3 million tonnes of printing and writing paper was produced in Finland during the first half of the year. Output was almost unchanged from the corresponding period of 2014.

Production of paperboard for packaging applications continued to grow steadily. Some 1.6 million tonnes of paperboard was produced in January-June, over 5% more than one year earlier.

Pulp production increased in the first half of the year. Finnish pulp production totalled 3.6 million tonnes in January-June, almost 3% more than in the corresponding period of 2014.

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

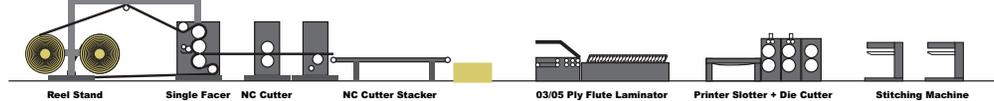
We manufacture following types of 03/05/07 Ply Automatic Box Making Plants for Indian Markets:



	03 Ply Automatic Plant			05 Ply Automatic Plant			07 Ply Automatic Plant		
	Sizes	Speed	Price	Sizes	Speed	Price	Sizes	Speed	Price
Economic Plant	1200-1800 mm	60-100 mtr/m	70-100 Lac	1200-2000 mm	50-120 mtr/m	125-180 Lac	1400-2000 mm	60-100 mtr/m	180-260 Lac
Premium Plant	1200-2200 mm	60-250 mtr/m	100-250 Lac	1400-2400 mm	60-250 mtr/m	150-300 Lac	1400-2400 mm	100-250 mtr/m	220-400 Lac

Indicative Price

We manufacture following types of Semi Automatic Box Making Plants for Indian Markets:



Semi Auto (Base Plant)			Semi Auto (Economic Plant)			Semi Auto (Premium Plant)		
Sizes	Prod Capacity	Price	Sizes	Prod Capacity	Price	Sizes	Prod Capacity	Price
1200-1800 mm	5-8 Ton/Day	20-50 Lac	1200-1800 mm	10-15 Ton/Day	30-70 Lac	1200-2000 mm	15-25 Ton/Day	50-100 Lac

Other Machineries We Manufacture



Shaftless Electric Reel Stand

Shaft-less Reel Stand provide complete solutions on the followings:

- Reel Loading and reel tightening remotely.
- Reel Alignment take no time.
- No manual operation.
- Reduce loading | Unloading time.
- No damage to the reel and reduce wastage.

Corrugation Machine provide complete solutions on the followings:

- No Manual adjustments required.
- All pressure are remotely provided on control panel for smooth operation.
- No Patta (Belt) required to control the glue | Gum.
- AC Drive provided on control panel for smooth operations
- Heaters consume 40% less power than tube heaters.



Corrugation Machine



Automatic Pasting Machine

Flute Laminator provide complete pasting solution:

- Flute Laminators replaces manual pasting machine
- It gives better quality and Quantity.
- This machine is for mass production.
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- AC Drive provided on control panel for smooth operations.

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Printer Slotter Die Cutter at the PRICE of Chain Feeder

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- AC Drive provided on control panel for smooth operations.
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Inline Carton Folder Gluer

High Speed Printer Die Cutter - Inline Folder Gluer

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Paper and forest product companies' profitability increasing

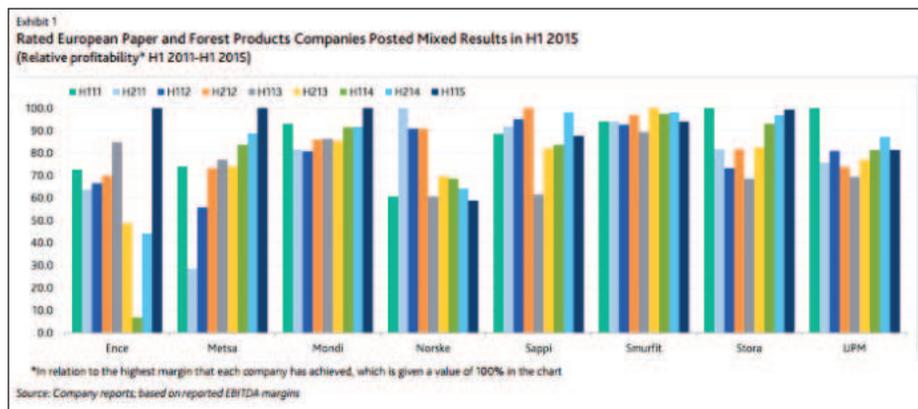
A new research report from Moody shows that, amid continued pressure on the paper industry, European paper and forest products companies that have diversified away from the mature European publication paper market and invested in new growth areas saw improved profitability in the first half of 2015.

“Companies such as Mondi Plc and Metsa Board Corporation have made sizeable investments in related segments, such as specialty paper and paper packaging, with higher margins and growth prospects, allowing them to generally outperform their peers that still have a relatively high exposure to the mature European publication paper market,” says Matthias Volkmer, a Moody's Vice President - Senior Analyst.

The report discusses companies such as Mondi Plc, Smurfit Kappa Group plc, UPM-Kymmene, Metsa Board Corporation, Stora Enso Oyj, Norske Skog, Ence Energia y Celulosa, Lecta and Portucel.

While some European pulp producers have benefited from the weaker euro -- as pulp is a US-dollar traded commodity while their costs are mainly in euros -- a ramp-up in pulp production could exert pressure on pulp prices in the second half of 2015.

Source: www.pulpapernews.com



The BOBST Corporate app is now available for Smartphones

The BOBST Corporate app, which gives quick and easy access to information such as Annual Reports, Annual Profiles and Sustainability Reports, has been completely redesigned, with versions now available for both Apple iOS and Android. With more users wanting information on the move, the app now also supports Smartphones on both operating systems, having previously only been compatible with Apple iPads.



Smurfit Kappa paper mill recognised for continual sustainability innovation

The District of Aachen, one of Europe's leading regions for science and research, has awarded Smurfit Kappa's Zülpich paper mill in western Germany a prestigious innovation prize in recognition of its outstanding sustainability performance.

The AC² Innovation Award recognises businesses that have made an exceptional contribution to innovation. Winners are traditionally drawn from the automotive or medical sectors, but the judging panel – which consisted of eminent university



professors including the Chancellor of the RWTH University of Aachen and senior business leaders – created a special Jury Prize for the recycled paper facility.

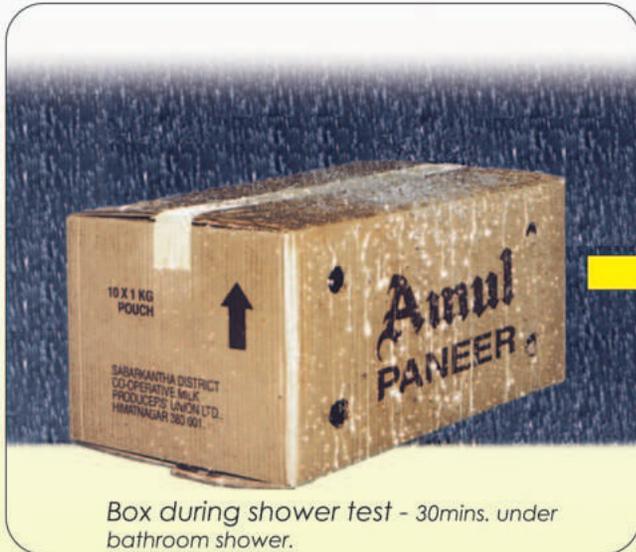
Smurfit Kappa's Zülpich paper mill impressed the jury with its sustainable and profitable operational approach. The mill operates a closed loop for production water which, due to local restrictions around returning water to the environment, ensures that zero water waste is emitted from the mill. It also captures the biogas produced from the water cycle as a by-product, and burns this for energy to power production. Finally, a multi-fuelled boiler uses unrecoverable waste to burn as fuel.

The recognition by the District of Aachen of the Zülpich paper mill is the latest example of Smurfit Kappa's commitment to designing and enabling truly circular systems, and to using sustainability as a driver for business value.

Source: www.smurfitkappa.com

WE RETURN YOUR MONEY, if we cannot prove it.

META-CHEM brings you the import substitute paper water-proof chemical, for the first time in the country. It performs even better than the imported chemical, resulting in far higher water resistance and increase in burst strength of the coated paper, **AT ONLY A FRACTION OF THE COST.**



Box during shower test - 30mins. under bathroom shower.



Box after shower test.

Special features:

- The chemical can be supplied transparent or lightly coloured in various shades as per requirement.
- Application is simple
- High coverage
- Superior water-proofing properties
- **Non toxic, food grade**
- No change of properties between (-)45 deg. C to 150 deg. C.
- **Environment friendly - The coating is bio-degradable and coated paper can be recycled directly**
- Coating is flexible - does not crack on folding

Comparative Properties:

	Plain paper	coating - ml/sq. mtr.			
		10	15	20	30
B/F	14.9	16.5	17.6	18.2	19.47
Cobb value	35.0	19.0	15.5	8.5	2.5
Gloss	18.36	18.26	18.17	18.2	18.28
GSM	147.5	148.5	149.0	149.5	149.5

Applications:

- Water proofing of corrugated boxes for packing of :
 - Fruits, vegetables, flowers
 - Tea, ice cream, butter, milk powder, paneer, cheese, Dahi.
 - Bidi, cigarette, tobacco, soap
 - Garments, fabrics, yarns
 - Fish, meat and other frozen food exports
 - Electronic and electrical goods
 - Any other moisture sensitive product
- Multi-wall paper bags for packing of moisture sensitive products
- Electrical insulation paper coating
- Anti-fungal coating for soap wrapper
- Export packing requiring recyclable water proof coating
- Fabric coating for Raincoat, Tarpaulin, Car cover, etc.

We also manufacture and supply Oil & Grease Resistant Paper Coating chemical with "Bio-degradable & Recyclable Food Grade" property.



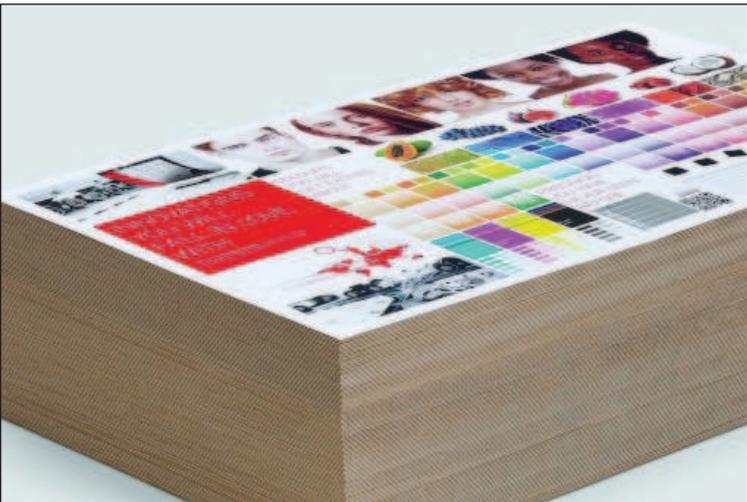
Meta-Chem Chemical Industries

Plot no. C-11, Unit - 4, NICE,
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Tel: (0253) 6603493; Telefax: (0253) 2353327;
E-mail: metachem1@bsnl.in; info@metachempaints.com

Product Profile

BOBST digital printing press for corrugated board - Schumacher Packaging becomes the second beta site

Designed and built in Switzerland, the BOBST digital printing press for corrugated board prints images, graphics, codes and text, which can vary from sheet to sheet. Production speeds can reach 200 meters per minute, with a maximum sheet width of 1.3 meters. Applications include serialization, personalized packs, versioned packaging, customized corrugated products, and medium to short-runs of conventional boxes and displays.



Incorporating Kodak Stream Inkjet Technology, the BOBST press delivers four-color digital print directly onto corrugated board and print run lengths can be from a single sheet to several thousand. The collaboration between technology leaders BOBST and Kodak has produced a digital press which exhibits a combination of print quality, speed and versatility which will allow converters to better respond to an increasingly dynamic market.

Jean-Pascal Bobst, CEO of Bobst Group, said, "The print technology choices that

corrugated packaging manufacturers have had available to them, up until now, have determined the markets they can serve. Our new solution changes all this because one printing press can open up a huge range of markets, from long runs of boxes featuring variable data to very short runs of bespoke packs and displays - as well giving access to a large number of mid-volume opportunities. And all this is delivered at high speed, with close to offset quality. It means that corrugated packaging manufacturers will be able to enter all sorts of existing and new markets."

The Kodak Stream Inkjet Technology used in the BOBST digital printing press has a number of characteristics that make it ideal for corrugated packaging production. This continuous inkjet printing technology provides greater throw distance compared to drop-on-demand inkjet enabling print on a wide range of substrate thicknesses; its high speed continuous jetting makes the press more responsive and so able to print variable data

at faster speeds; and the technology uses water-based inks which are food compliant, compatible with a wide range of coated and uncoated substrates and more environmentally friendly. The jetting modules are self-maintaining and, when they need to be replaced, can be refurbished and recycled with minimal waste.

Philippe Milliet, Head of Business Unit Sheet-fed, added, "Brand owners want more flexibility, especially at the late stage, as well as equal or better print quality.

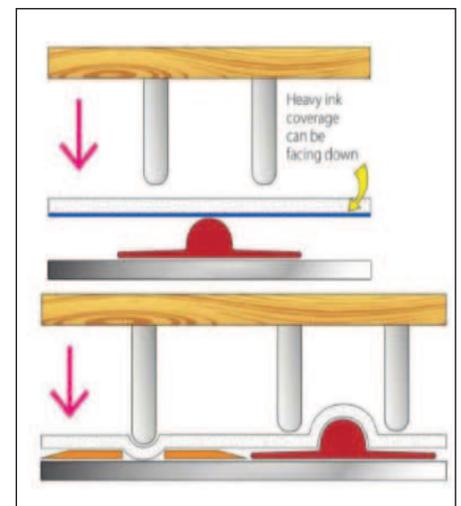
They also aim to increase engagement with consumers, while at the same time keeping costs under control. Our digital solution gives our customers the ability to deliver all that using one machine."

Source: www.bobst.com

C&T Matrix Announce Product Improvements To Reverse Bend Matrix

C&T Matrix is pleased to announce recent improvements to its range of REVERSE BEND MATRIX. Designed to fulfil the increase in demand for a reverse bend matrix, this product is ideal for board, corrugated and fluted materials, for all types of packaging or POS applications and now features an improved and flexible locator.

Unlike traditional products, C&T Reverse Bend prevents cracking problems associated with full ink coverage by creasing from the unprinted side of the sheet. The design means concertina folds are also now possible in one pass, avoiding the need for two separate passes. This improves registration of the creases and prevents potential damage to the sheet which a second pass may create.



Cont. on - 111

Turnkey Engineering Solutions

Vacuum absorption fingerless type high speed single facer machine group



Single facers also available in finger type economic models from 1200 upto 2500mm widths in electric, hot oil and steam heating system.

High speed PLC based fully auto 4 color printer slotter with rotary die cutting, lead edge feeding system:



Also available in Lead Edge Feed, Kicker feed and chain feed systems without PLC in various sizes.

AUTOMATIC CORRUGATED PAPERBOARD PLANT



We offer high quality 3 ply, 5 ply and 7 ply automatic corrugated paperboard plant with widths from 1400mm upto 2500mm and production speeds from 60 mtrs. upto 250mtrs/ min. in various flute combinations as per customer's choice.



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to the Corrugated Packaging Industry

Our excellent infrastructure available at the Navi Mumbai facility, an emphasis to offer only good quality machines to our customers backed up by vast experienced technical support team to deliver efficient and prompt after sales service and maintaining adequate essential spares for all machines that we offer, helps us in serving our domestic and international customers in a better way.

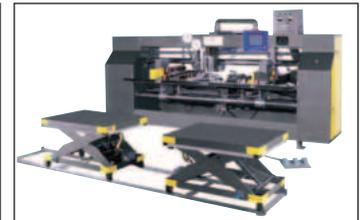
Other products:

- Auto and semi auto folder gluer machine.
- 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



The collaboration with an international Die manufacturing company has given our company the right skills, expertise and technological support to manufacture Rotary Dies of all types. The high quality imported raw materials are used for better productivity and accuracy.

Our highly experienced technical team will be able to provide packaging expertise to assist with all aspects of die making design.

We provide highly personalized Die making service for short delivery times.



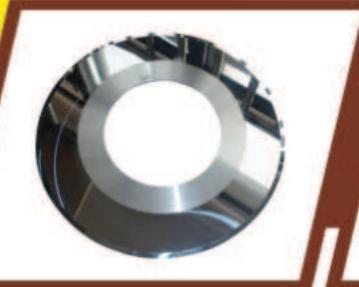
Rotary Dies



**The Right Skills,
Expertise
Technological Support
With An International
Die Manufacturing
Collaboration**



Rs4/ Slotter Blades



Thin Blades



Grinding Wheel



**Non-crush Wheels
(Sun Wheels)**



**Lead Edge
Feed Rubber**

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Factory and correspondence address :
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Building No. C-15, Gala No. 4, Owali,
Bhiwandi - 421302. • M - 9322336111

A new improved locator has been developed by C&T Matrix which features a flexible design. This enables the locator to fit an even greater variety of rule widths (between 1mm). This gives a better fit over a wider range of creasing rule, taking up a better tolerance.

Simon Shenton, Managing Director at C&T Matrix said “Over the last 18 months Reverse Bend sales have grown, especially in the corrugated and packaging sectors, not just here in the UK but globally. We have observed the growing need, expressed by customers, for a superior reverse bend product. The new locator gives an improved creasing result, over a wider range of rule and is ideal for solid areas of print, eliminating cracking issues.”

C&T Reverse Bend is available in several sizes with both standard and extra strong tape. All reverse bend products are 75cm long. UK stock enables quick delivery over an extended range of types.

For further details regarding C&T Matrix and its innovative creasing matrix solutions visit www.candtmatrix.co.uk

DuPont Packaging Graphics Introduces New Cyrel® Easy Plate Technology

Simplifies Flexographic Platemaking with Built-in Flat Top Dots

DuPont Packaging Graphics (DuPont) recently announced the market launch of a new flexographic printing plate technology platform – DuPont™ Cyrel® Easy. This new technology platform simplifies the prepress process by building the flat top digital dot directly into the plate, resulting in increased productivity and consistency. This is part of an on-going effort by DuPont to drive progress in the flexographic printing industry by improving quality, sustainability and productivity.

By building flat top dot capability directly into Cyrel® Easy plates, DuPont helps making it fast and simple to enhance productivity, while delivering world-class print quality.

For flexographic printers, converters and tradeshops looking for increased productivity, DuPont™ Cyrel® FAST thermal and solvent platemaking system efficiency and consistency is increased by removing the flat top dot processing step and its associated cost. The result is a technology platform that offers customers the choice of both smooth and engineered surface plates that deliver high ink transfer and color saturation, regardless of existing workflow.

Cyrel® Easy technology is currently in market testing at select DuPont customers around the world, and commercial sales of the first generation of printing plates from the Cyrel® Easy platform are scheduled for the third quarter of 2015.

Source: www.dupont.com

DS Smith tests desks made entirely from corrugated board

“It’s very practical and sturdy”

DS Smith’s UK Packaging Division has created a prototype standing desk made entirely from corrugated board. The desk was produced for a member of staff who was interested in making lifestyle changes in response to a specific health need.

Commercially available standing desk solutions can be expensive – costing anything up to £3,000 a time. However one DS Smith employee thought that the engineering skills and innovative materials at the heart of the company’s packaging operation could produce something that was just as effective at significantly lower cost.

After a few initial prototypes the design team produced an entirely free standing desk made from corrugated board, that is strong enough to support a computer and all the technology and paperwork that normally sit on a desk. Being made from corrugated board means it is also entirely sustainable and more cost effective than wooden or plastic alternatives.

“This is a great example of the ongoing innovation that lies within our business – our teams have that same enthusiasm to help customers overcome challenges and to deliver continuous improvement for them,” said Tony Foster, Sales and Marketing Director, at DS Smith’s UK packaging division. “We innovate every day in every way, and it’s great to see this having a positive impact on our own teams as well as the wider industry.”

The employee himself is delighted with the result, and he now uses the desk every day. He said: “It’s very practical and sturdy - it’s amazing what we can achieve when faced with a challenge!”

<http://www.pulpapernews.com>



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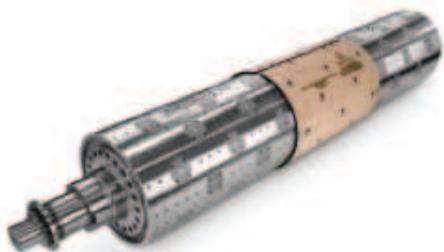
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Need to increase your storage space?

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SERRA has three generations of experience in the corrugated industry and offers radical improvements for any rotary die-cutter in the market (provided both as retrofits and through any OEM). With SERRA you can increase productivity by reducing set-up time, improve in quality with perfect die-cutting, improve workplace safety by effortlessly lifting any die, and optimize die storage space by incorporating the new SERRASTOCK®.



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Set-up times can be reduced to the minimum with the help of the SERRAPID system. A die can be locked onto the die cylinder within 30 seconds, without the need of screws. Thus, working hours become more productive.

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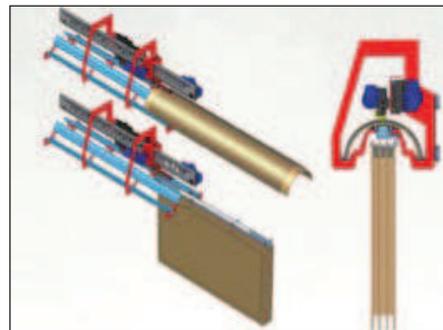
SERRASTOCK®

With an ever-increasing number of dies, how can one overcome the problem of overflowing the storage area? The answer is to arrange them optimally in a tile fashion. It provides the more compact storage system in the market.

SERRASTOCK metal shelves which are designed to store flat or rotary dies. The versatile shelving system allows you to store the right proportion of flat and rotary dies according to your growing needs.

The trans-elevator places and retrieves both types of dies from shelves automatically. It's Hybrid Head can even handle different diameter rotary dies. For maximum space efficiency, place two shelves in front of each other and the Hybrid Head can deliver to both sides.

SERRASTOCK Storage System with its Hybrid Head.

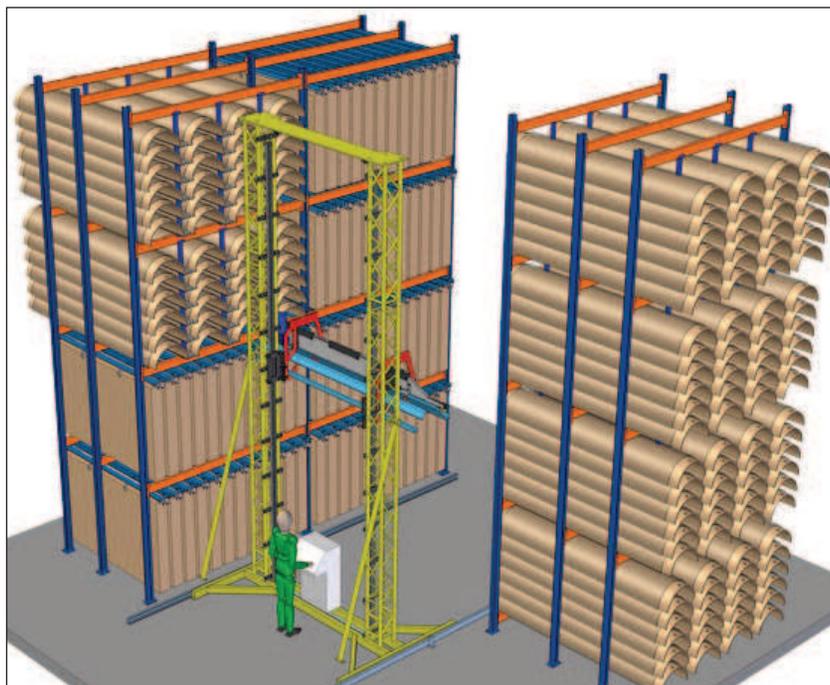


Hanging flat dies for storage has many advantages. Gravity helps to avoid die deformation and preserves the blades, since dies no longer need to be placed into drawers.

The Hybrid Head can accommodate rotary dies (from 7 10mm up to 2 185mm) in the same structure. It preserves blades from damage and keeps perfect curvature of the shell.

It is a weightless die manipulator that allows one person to safely change any size die by holding its handles, which is adaptable to all die cutters. Once transported to the die storage area by the transport trolley, the SERRASTOCK does the heavy lifting. It is available with different levels of automation.

For more info visit: www.serra.com.es



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Forthcoming Events

8 - 11 October 2015



**Bombay Exhibition Centre,
Goregaon (E), Mumbai, INDIA**

INDIAPACK has grown as a brand to be reckoned with Indian Packaging Industry and world over after the successes of previous editions. Recognizing that the new trends and developments are essential for the industry's better future, the Indian Institute of Packaging, through INDIAPACK seeks to provide a perfect platform to bring the packaging industry under one roof. With the support expected from Ministry of Commerce & Industry, Ministry of Food Processing Industry and Ministry of Textiles, Govt. of India and many trade associations from India and abroad including World Packaging Organisation and Asian Packaging Federation, INDIAPACK is all set to continue the success story.

1 - 4 November, 2015



**Paperex 2015
Pragati Maidan, New Delhi**

The 12th edition of Paperex – Paperex 2015, scheduled for 1st Nov – 4th Nov, 2015 in New Delhi, is the largest Exhibition and Conference in Asia for pulp and paper technology.

17 - 20 November 2015



**Messe Düsseldorf Introduces
New 'SWOP - Shanghai World of
Packaging' in 2015**

Messe Düsseldorf has enhanced its successful product family of international packaging trade shows with new events in an exciting market:

SWOP - Shanghai World of Packaging, to be launched from November 17 - 20 November 2015 at the Shanghai New Exhibition Center (SNIEC)

20 - 22 November, 2015



**44th FCBM CONFERENCE
Le Meridian Hotel, Kochi.**

44TH; Conference of the Federation of Corrugated Box Mfrs. of India is being held from 20th to 22nd November, 2015 at Le Meridian Hotel, Kochi. It is an established and proven fact that this annual event of the Federation is an excellent platform for meeting major corrugated packaging manufacturers from India and neighboring countries. The three day programme will comprise of Annual meeting, technical seminars, Exhibition, cultural programme etc. The event will be organised by Kerala Corrugated Box Manufacturers Association.

www.keralacbma.org

9 - 12 December 2015



Pamex 2015

Bombay Exhibition Centre, India

The exhibition will showcase generation next technologies from worldwide solution providers across various categories like pre-press, in-press and post press segments. The Show will host dedicated pavilions for label & narrow web printing and presses; paper & board converting and corrugated machinery & equipment. Flexo & gravure printing, digital presses, web offset presses, sheet fed offset presses and signage machinery & process equipment will widely be displayed at the event.

31 May - 10 June 2016



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