

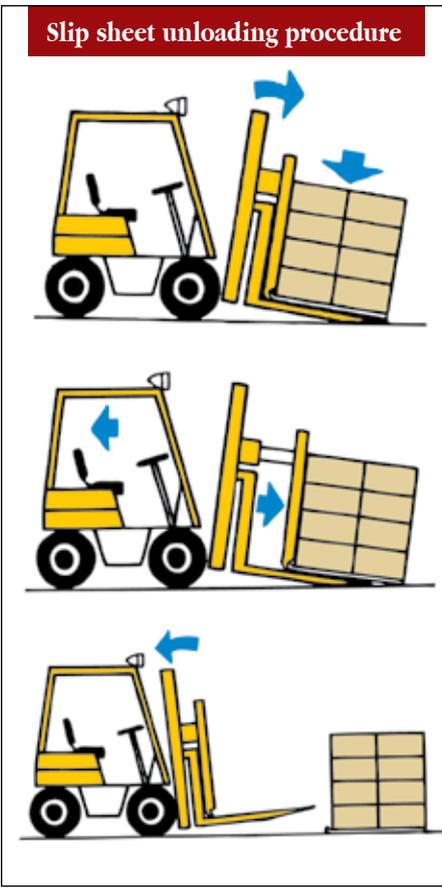
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The Corrugator

OFFICIAL MAGAZINE OF FEDERATION OF CORRUGATED BOX MANUFACTURERS OF INDIA

July - September 2017



46th FCBM Conference

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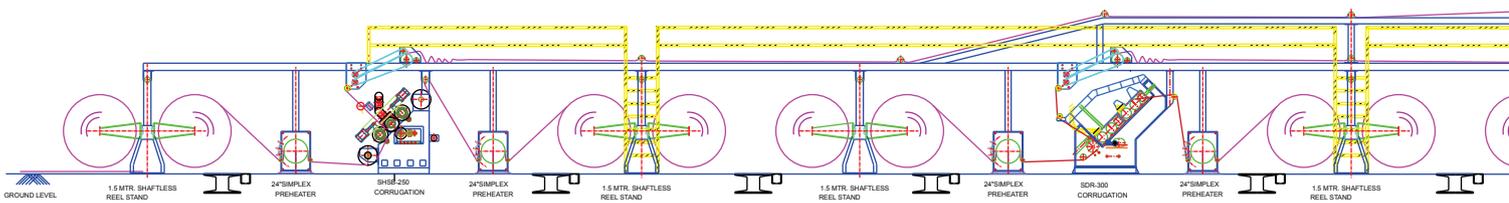
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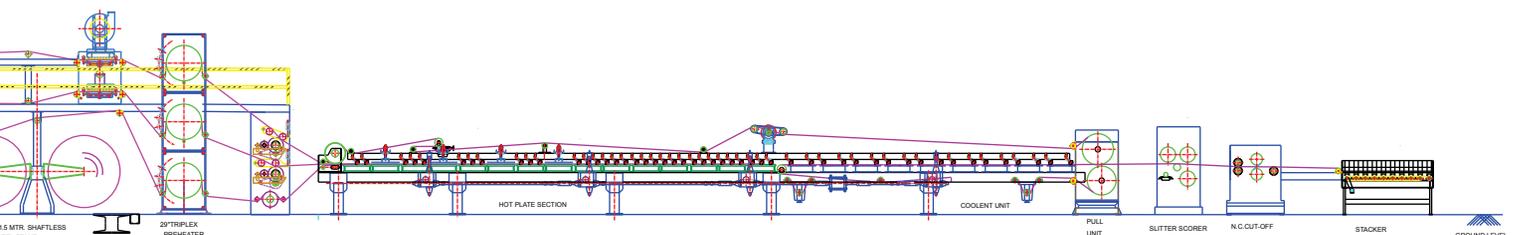
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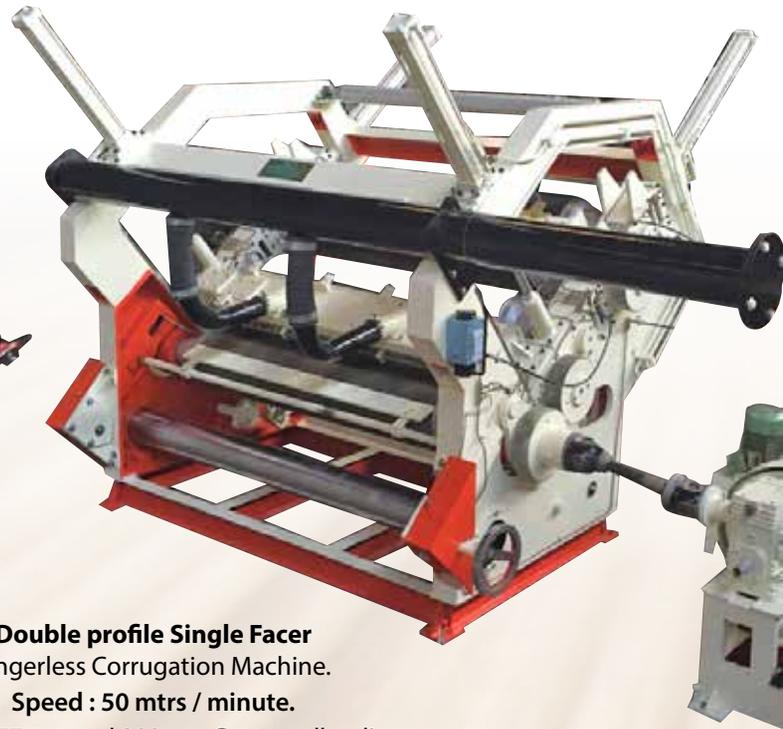
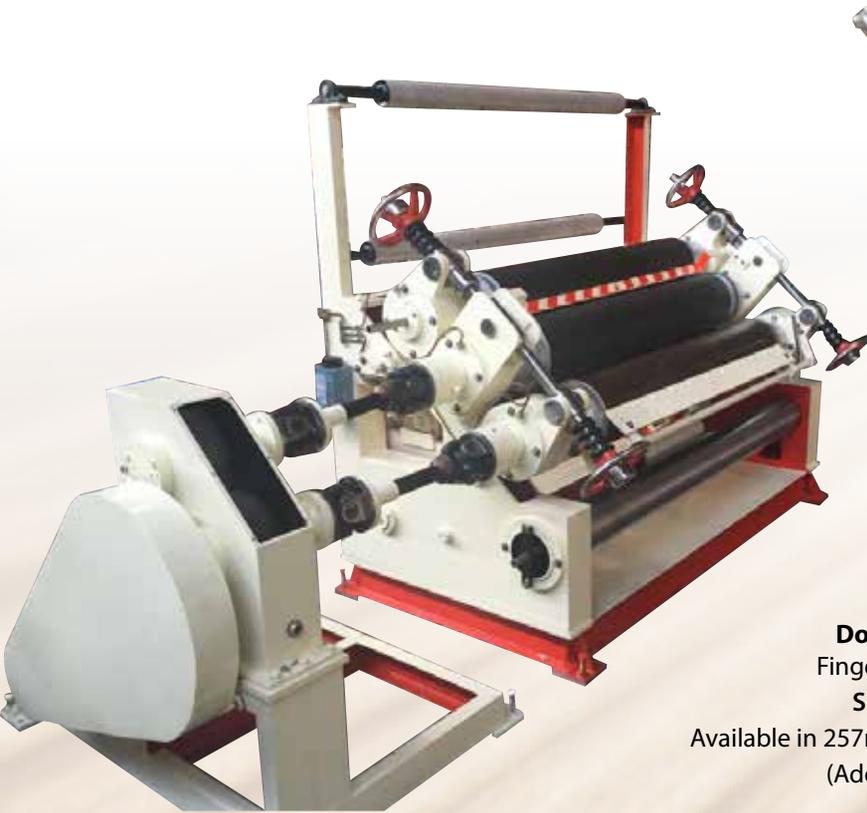
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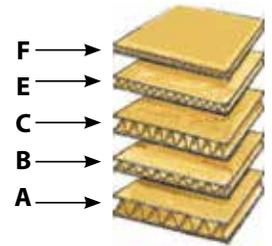
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This year and more so this quarter has witnessed an upheaval in the economy especially, with GDP coming down to a low 5.7% and industrial growth being stagnant. The launching of GST a welcome move, has also put hurdles in the smooth functioning of the industry especially, when many in the industry are struggling and focusing on conforming and compliance to the New Tax Laws – rather than on productivity and growth. Now that has been three months since GST rolled out, let's hope for smooth riding soon.

Let us hope the momentum will continue to propel industrial activity and consumer confidence which in turn will spur the growth in the packaging segment.

Our Federation and Regional Associations have organized many Meets & Seminars to help our members to understand the nuances of GST and its compliance.

Let's now get to work and implement productivity, profitability.

As in the past, our Federation and Regional Associations have been vibrant and active.

One of the significant developments has been the welcome entry of over 50 members from Coimbatore into the fold of SICBMA - a long standing issue thus resolved. The strengthening of our

Regional Associations is necessary to widen the base of FCBM.

The FCBM M.C. Meeting was held at a new location – Puri. EICMA played the host.

WICMA had held its 50th AGM on 9th Sept. As India's first Association WICMA is celebrating its Golden Jubilee this year. WICMA is also the proud host of this year's FCBM Conference at Pune.

This issue gives you a preview of the 46th FCBM Conference. We are sure members will make it a benchmark conference by participating in large numbers.

There are quite a few Packaging Shows scheduled this quarter. The IndiaCorr Expo, the exhibition dedicated to the corrugation industry ended on a high note.

ICCA and WCO 2017 Summit in Brazil will bring together corrugated industry leaders across the globe.

INDIA PACK an event created by IIP, will now be held at New Delhi with a new name India Pack Pac Process, the realigned International Pack Tech India – organized by Messe Dusseldorf.

One of the articles in this issue highlights how corrugated acts is the best choice for Shelf- Ready Packaging.

Since the last decade the shopping habits of consumers have undergone phenomenal changes.

From the neighborhood grocery stores to streamlined malls – the centres of shopping activity have seen a great shift. Besides, the online shopping has caught on creating new avenues for boxes designed for e-commerce.

Colourful corrugated boxes have replaced conventional wooden boxes for packing of fruits and vegetables.

All these factors and more have created an ever growing demand for innovative corrugated packaging solutions. The industry has very well risen up and explored these opportunities.

With the impact of demonetisation waning, implementation of GST behind us and the festival season round the corner, industrial growth is likely to improve over the next few months.

Industrial growth made a mild recovery in July with industrial output rising by an annual 1.2% in July.

Let us hope the coming months will see the resurgence of industrial activity and economic growth in general and booming days ahead for corrugated packaging.



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PRESIDENT'S MESSAGE



Greesh Sardana

**Wishing all readers a
Happy Diwali &
Prosperous New Year**



Dear Friends,

Greetings from Himachal.

It is always a pleasure for me to share my thoughts with you in the pages of The Corrugator.

My tenure as President of our great federation is on the last leg. During the year, I enjoyed meeting our members on various occasions and interacting with them.

We discussed many pending issues and try to resolve them. It has been a very gratifying time.

Despite the many ups and downs in economy, our industry has been growing at a sustained pace. As per a recent survey, the corrugated industry in India will reach a USD 5.5 billion revenue by 2020.

The shift to automatic lines and modernization of the industry is continuing at a fast pace.

At the same time, corrugators adopting semi-automatic process will continue to have their niche markets – a trend that has emerged in many countries across the world.

All this portends well for our industry.

We are now looking forward to the 46th FCBM Conference scheduled in November. I am sure our members will attend the Conference in large numbers and make it a grand success.

Bad or no packaging is one of the reasons for enormous losses in food and food products. Government is focusing on development of packaging for fresh produce and processed foods to reduce losses and to ensure that food products reach the nook and corner of India safely and in a pristine condition. This will also increase exports of fruits, vegetables and other products produced in India.

The recent visit of Japan's PM to India has catapulted the role of Japan in the infrastructure projects that are taking off with huge participation of Japan running into lakhs of crores. JICA Japanese International Co-operation Agency has surpassed World Bank and ADB in seamlessly executing large infrastructure projects in India.

Such developments will pave way for vibrant economic activity. Let us hope coming days will see accelerated growth.

The Corrugator continues to act as an effective mouthpiece of our industry by projecting the achievements technical developments, exhibitions and other matters related to the industry.

The magazine also acts as a platform for sharing your views and ideas.

Yours truly,
Greesh Sardana

Excellent!

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Smart Manufacturing.

During my recent articles, I reviewed components that influence the capabilities of our Flexos and Rotary Die Cutters. I have frequently defined calibration practices, both Centerlining and Time & Register Calibrations. Suggestions were also made to reduce maintenance costs and address “unscheduled” down time.

As we know, “unscheduled” downtime is one of the major silent costs in our manufacturing process. I am going to discuss several of the major contributors to this very expensive phenomenon and some solutions that are relatively easy to implement.

- Product Jam Ups in the Press.
- Inconsistent printing. (Clarity and Tight Register)
- Rotary Die Cutting Performance (Register and Die Board performance)



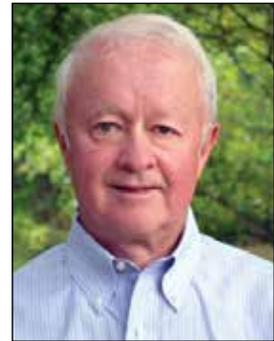
As we all increase the speeds of our converting machines, we must be sure that we never forget the quality standards that our customers are expecting. We must be sure that the sheet is properly and precisely controlled and processed as it travels through the print stations, slotter sections and the die cut section.

The following are some easy to understand suggestions that should be part of your manufacturing process.

Feed Section Controls.

Machine jams are rarely reported and are never analyzed. As the press comes to an abrupt stop, sheets are damaged. Downtime and scrap adds up and in many cases, the profit for that order is marginalized. The crew then clears the jam, removes the scrap from the slotter heads and print stations, cleans the dried

ink off the printing plates and then the crew goes on break! Sometimes, the belts in the folding section are stripped off and downtime continues to add up. Understanding and better managing the proper settings in the feed table can easily prevent the majority of these events.



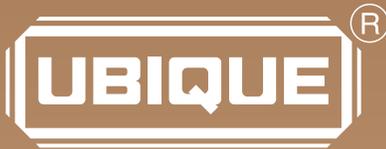
Dick Target
“On Target Consultants”

Generally speaking, there should be no more than 12 to 14 inches (300 mm to 355 mm) of sheets in the hopper in the feed section. It is important to understand that the intention here is to minimize the amount of weight on the sheet that is currently being fed by the lead edge feeder. Please note: these numbers are not set in stone as this depends on the press size, the caliper of the sheet as well as dimensions of the sheet itself. The operator and “Supervisor” should manage and understand this part of the process. Mark the up-rights on the side of the feed table so that everyone has a reference point they can use to properly manage the height of the sheets in the hopper. If there are too many sheets in the hopper and excessive weight on the sheet that is being fed, that sheet will leave late or skewed. It will then jam in the press. This is a common daily event in most plants and certainly contributes to unnecessary costs and downtime.

Part two in the feed section is understanding and implementing proper settings of both front stops. It is necessary for these two front stops to be set as follows:

0.060” (1.5 mm) above the sheet being fed. This means if the caliper of the “C” flute sheet is 0.067” (1.7 mm) then the bottom

Contd. on - 15



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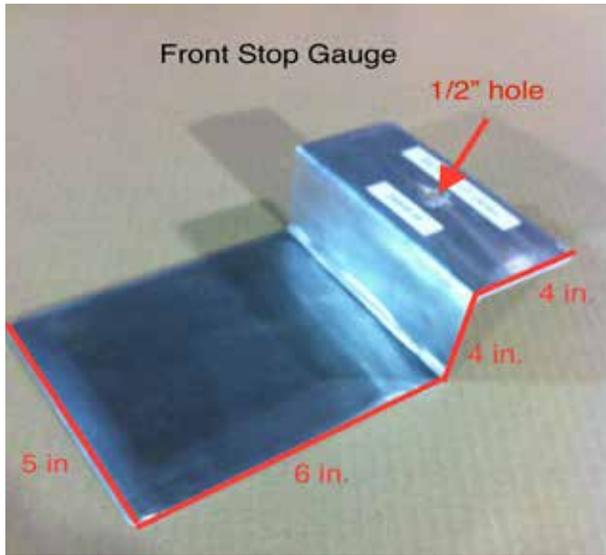
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of the front stop should be set at 0.127" (3.3 mm) above the table. An item called the Front Stop Gauge easily controls this setting.

- Remember, both front stops need to be set the same.
- I have discussed the front stop gauge in previous articles. (See August 2016 issue)
- The Front Stop Gauge generally is 0.060" (1.5 mm) thick. As the crew sets up for a new order, the following procedure should be followed:
- Place one sheet from the new order on the feed table.
- Turn the Vacuum on.
- Place the Front Stop Gauge on top of the sheet.
- Lower each Front Stop until it just touches the top of the gauge.
- This then accurately sets the space from the top of the sheet to the bottom of each front stop.
- This actually allows sheets with normal warp to be fed into the press without causing a jam.

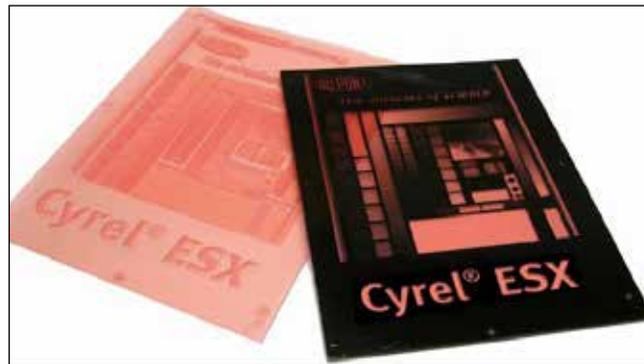
This is a very easy and manageable tool that the plants can use to decrease both scrap unscheduled downtime. Improper front stop settings can also be very costly. Feed Section jam-ups not only damage sheets but also frequently damage the printing plates in the first print station. This again adds to costs.

During the time that it takes for the crew to clear the feed section jam up, the ink dries on the plates and sheets in the folding section become scrap as they are partially folded and the glue dries on the tabs while the sheet has not been completely folded. All of this contributes to scrap and the costly item that I frequently discuss called "unscheduled" down time. This can contribute up to 1% of the plants total waste! This feed section

activity frequently goes un-reported in the plant and just becomes part of the daily routine and production activities.

Printing Plates.

I always consider the printing plates and their mounting practices the final two inches of the process. Printing and the final print job on every box is the one item that customers always critique very carefully. Anyone can make a square box but not everyone can be a good printer on that box.



One area that needs to be discussed in order to assure quality printing is the mounting methods and how we fix the printing plate to the print cylinder.

Many crews in today's market use paper tape to fix the printing plate to the print cylinder. In my opinion, that is wrong. Is it shorter and maybe easier for the crews? Yes. Does it guarantee a quality print

job with minimum downtime? NO. This is another event that produces hidden costs in the manufacturing process that is rarely identified or even discussed! Tape does not have a memory nor does it overcome the centrifugal force created by the rotation of the print cylinder. The centrifugal force of the cylinder causes the printing plate to move when it is fixed to the cylinder by tape. The result is that the crews run the press slower so as to reduce this movement in order to print with some clarity. That directly negatively affects the manufacturing cost per unit and potential margin.

Elastic bands with plastic clips do better and more precise job of securing the printing plates to cylinders at higher speeds for the smaller presses and productive speeds for the larger diameter cylinders. As the press becomes larger, the weight increases with the printing plate and the movement gets worse. It is frequently very difficult and time consuming to troubleshoot multiple color print jobs when one of the colors is either smearing or out of register due to the movement of the printing plate. If the plant only uses tape as a process to mount printing plates, the crews have no opportunity for a solution. Today's market

demands consistent color, clear and sharp printing with very close register controls. This is a silent killer in the modern industry that causes companies to loose business.

Cutting Dies.

As we now learn to better mount our printing plates, we also

need to understand and accurately mount and manage our cutting dies.

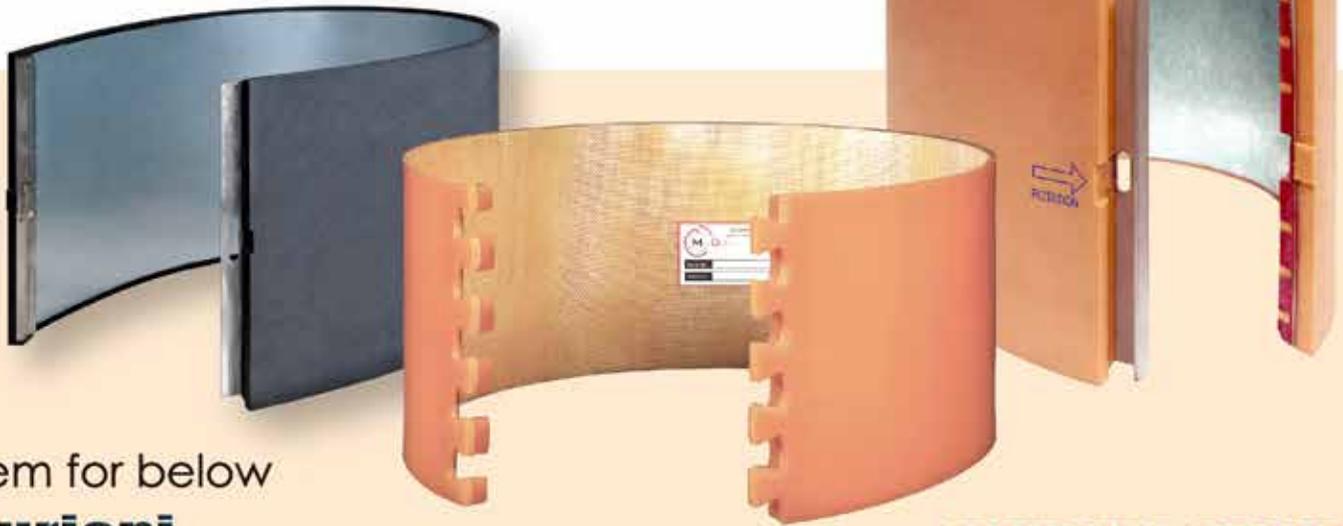
Good cutting die manufacturers properly locate as many holes in the wood as possible so that their customers can die cut accurately. We must be precise and consistent in our mounting practices on die drums. It is the responsibility of the die cutter operator to use all the holes in the




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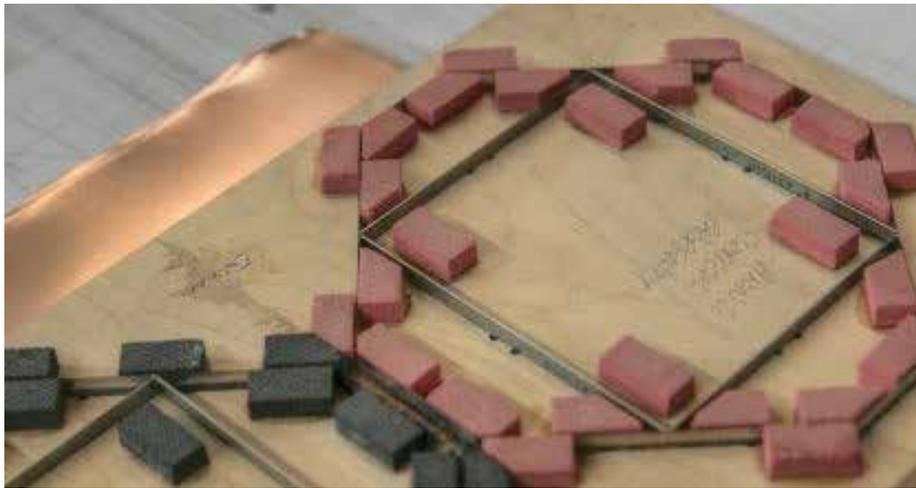
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wood during the mounting process. This will assure accurate die cutting, acceptable performance of the die board itself and a useful manufacturing life. Die boards that are not properly mounted, without utilizing all boltholes in the wood ad to manufacturing cost. Improperly mounted die boards will result in:

- Broken Bridges
- Poor Register Control
- Shorter Cutting Die Manufacturing Life
- Inaccurate sheet transfer from the last Print Station.
- Slower Speeds

In the mounting process, I just want to make a comment about the bolts that we use. The threads in the bolts that we use today must be compatible with the threads in the die drum. One should be hardened steel (50 Rc) and the other should be softer metal (35Rc). This way, the threads will secure one another in the process.

The recommendation for the bolts is Cold Rolled Steel, Grade 3.

Also, when the mounting the cutting die, it is a good practice to hand starts the bolts and then finish the job with the air gun. This will assure accurate thread engagement. It is also necessary to set the pressure on the air gun to 30- 40 PSIG. Do not use normal plant pressure without reducing the pressure at the press. If you use plant pressure (120 PSIG), you will not only strip the threads in the bolts, you will damage the inserts in the steel drum.

Properly mounted die boards will enable the crews to run their orders at productive, cost effective manufacturing speeds with minimum stoppages during the run. Multiple up orders also need the die boards to be completely mounted using all the bolt holes in order to minimize sheet length variation. This is another silent killer in manufacturing. Improperly mounted die

boards frequently go undetected without any solutions. This results in slower speeds, unscheduled downtime and adverse affects on the plants margin.

The contents of this article are directed towards the Owners and Plant Managers of Box Plants in this industry. These are basic tools that need to be understood, implemented and better managed. Operators who generally influence these decisions regarding the specifics of this article do not run or own the company. They are not responsible for the financial well being of the plant. Please consider the contents of this article and review the same with your staff. If the plant is more profitable, everyone wins!

Enjoy Your Job.

Dick Target, owner of "On Target Consultants" based in Lower Gwynedd, Pa., has been in the corrugated industry for over 35 years.

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

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

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

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

He can be reached at: dicktarget@gmail.com

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Slip sheets: Palletless load handling saves money

A slip sheet is an alternative to a wooden pallet with added advantages. PrintWeek India's Rushikesh Aravkar investigates how using slip sheets for assembling, storing and transporting goods can save costs and maximise the space utilisation

Slip sheets have been used in India for last 15 years, especially by the foodgrain, textile and engineering companies for their overseas shipments. Even then this method of load unitisation seems to have missed the eyes of the new generation packaging managers, who are on a constant lookout for cost reduction and material savings.

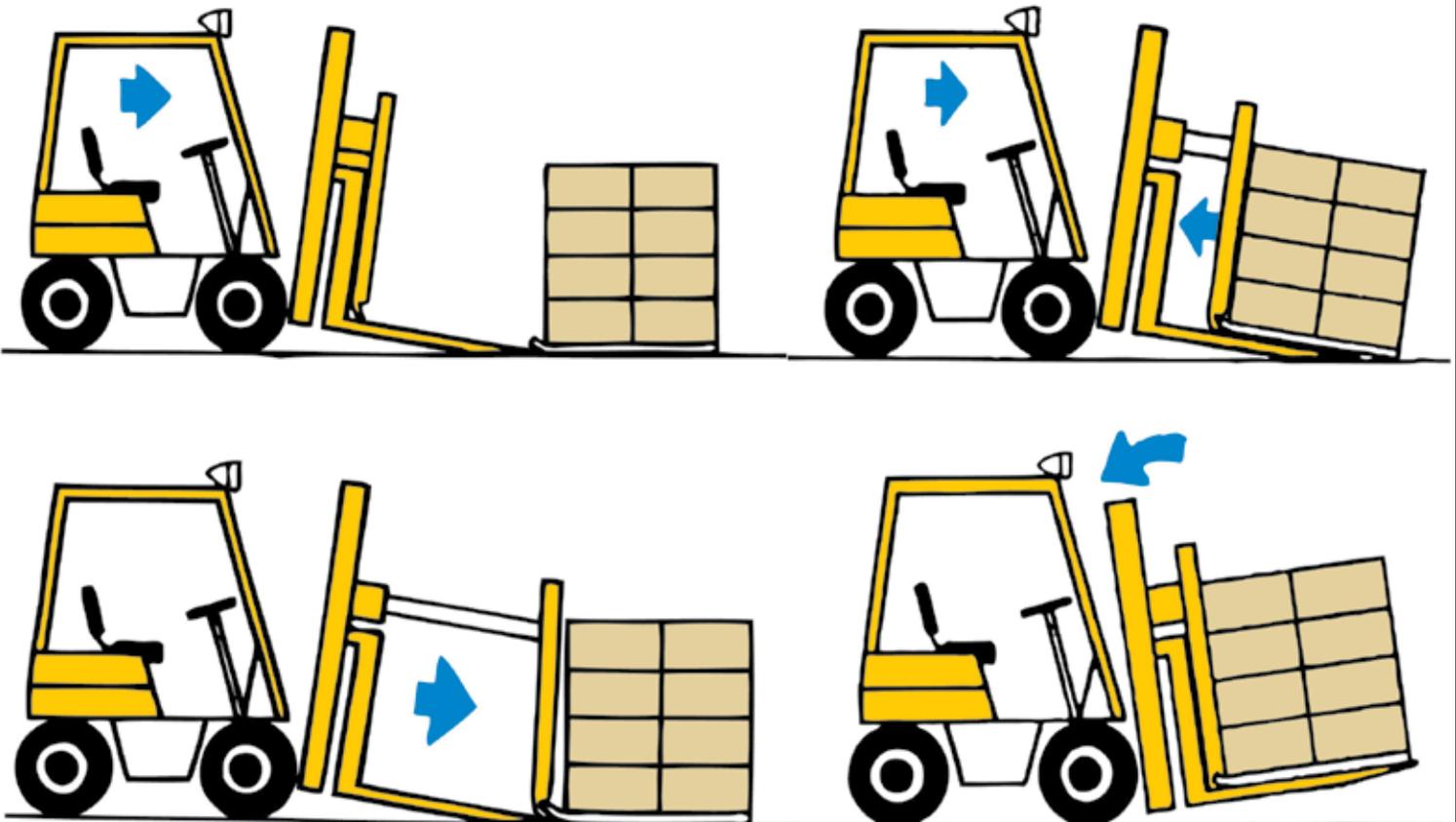
A casual survey among the packaging fraternity reveals that eight out of ten packaging managers are unaware of what a slip sheet is.

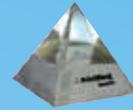
Probably, that's one of the reasons why even after being around for quite a while, a solution like slip sheet with huge potential for cost savings as well as productivity benefits has had a poor adoption rate.



Rushikesh Aravkar
Technical Editor
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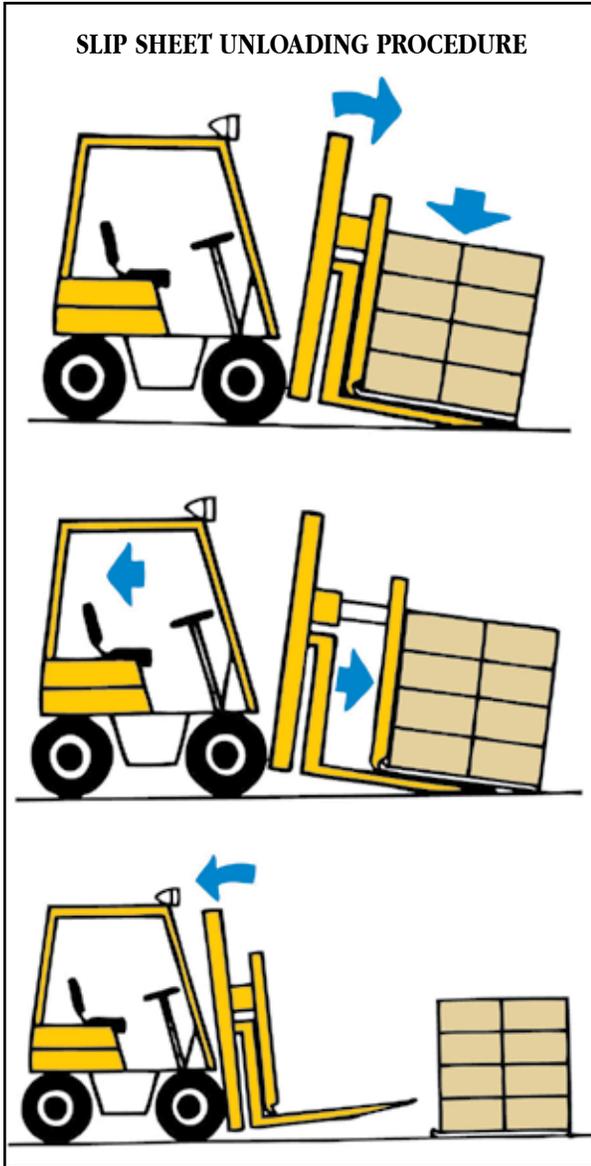
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SLIP SHEET UNLOADING PROCEDURE



Basics of a slip sheet

So, what is a slip sheet?

A slip sheet is a flat sheet of solid fibreboard, corrugated board or plastic (polyethylene) sheet with tabs on one or more sides. It can be deployed as an alternative to the traditional wooden pallets for unitisation of the load during warehouse storage and transport.

Using slip sheet requires a forklift truck with a special hydraulic push-pull attachment.

The US-based material handling equipment manufacturer, Cascade Corporation with Indian headquarters in Pune, is one of the suppliers of such push-pull attachment. Explaining the operation, Vishnu Bhagwat,

general manager at Cascade Corporation, says, "Once the shippers are stacked with load on the slip sheet, the tab is clamped by a gripper on the hydraulic arms, which then pulls the load onto the forklift tines."

"Now when the forklift moves to the desired location, the hydraulic arms push the load along with slip sheet off the tines and the gripper releases the tab."

In order to facilitate this smooth operation, the top and bottom surfaces of a slip sheet are characterised with a dual coefficient of friction (COF).

"Slip sheets are designed in such a way that the COF of the top surface is greater than that of the bottom surface. So that it doesn't suffer load shifting during loading and unloading. At the same time, the lower COF of the bottom surface enables easy loading and unloading when the hydraulic arms pull and push the slip sheet," says Ganesh Ananthakrishnan, managing

director at DSM Agencies, a Chennai-based supplier of pallet stability solutions including slip sheets.

Slip sheet v/s pallet

The palletless handling of unitised goods using slip sheets and push-pulls can save money and reduce damage.

The primary advantage of a slip sheet is the prevention of loss of box compression strength caused because of pallet overhang and deck board spacing.

Adding to benefits of using slip sheet over the pallet, Ananthakrishnan says, "The weight of a slip sheet is significantly lower than that of a pallet and this saves transportation costs. Slip sheets have

another advantage of occupying less space in containers thereby more goods can be loaded in a container. Plus unlike pallets, slip sheets do not require fumigation."

The average cost of a 1200 x1000 mm sized wooden pallet is about Rs 1,100 whereas a plastic slip sheet costs around Rs 300, which makes cheap enough to be discarded after one use.

Ram Srinivas, assistant manager – packaging development, Amneal Pharmaceuticals, who in his previous stint was involved in slip sheet implementation, says, "Slip sheet is a winner, it maximises warehouse space utilisation extensively. About 100 slip sheets can be stored in the space required for one pallet. Besides this, because pallets occupy large space, companies prefer to stagger the order of pallets, whereas slip sheets can be ordered in one go."

"Also, pallets can be easily contaminated with rodent droppings and insect as well as residues from previously carried products. Since slip sheets are flat and made of inert materials, they do not provide a medium for infestation or contamination. Slip sheets also eliminate the fire hazard associated with wooden pallets," adds Srinivas.

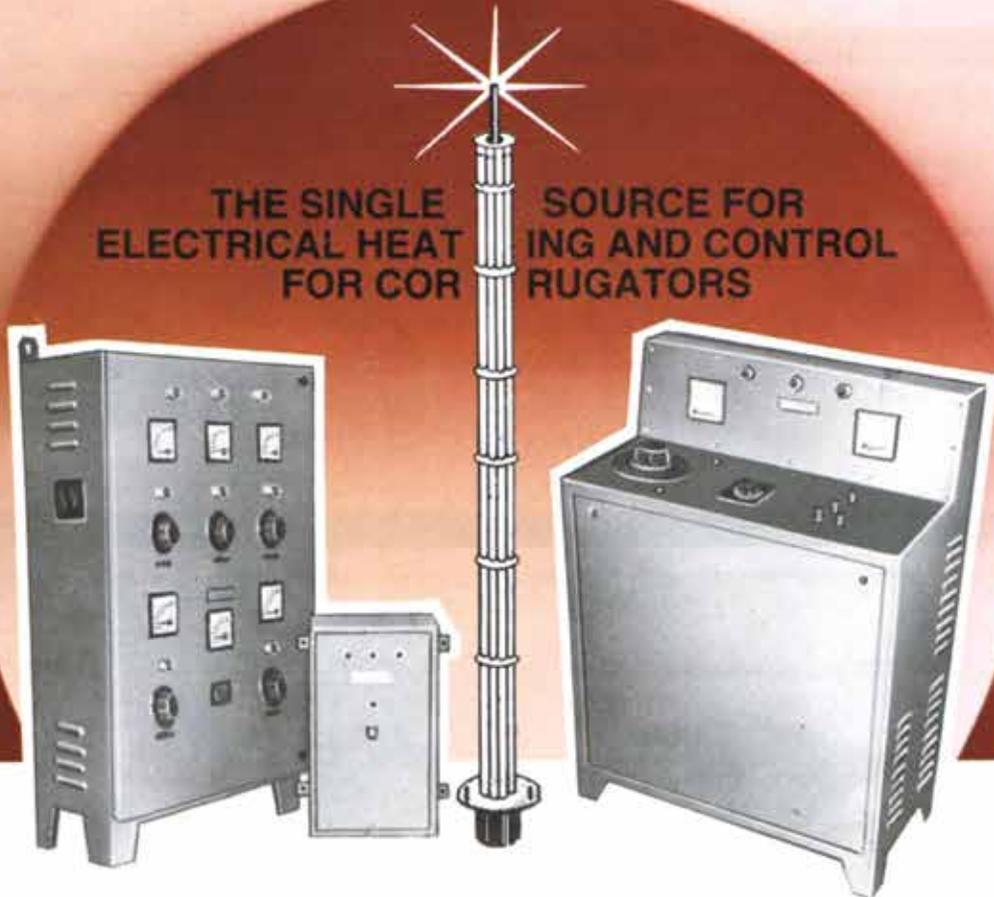
Besides these obvious benefits, companies can achieve significant logistical savings for high volumes of sea shipments in containers as well as air shipments. Srinivas explains, "Average weight of a pallet is about 18kgs. Air shipments are charged on weight basis costing Rs 250 per kg for shipments destined to the USA. Therefore eliminating pallets can earn significant cost savings."

In cases of container shipments via sea, road or rail transport, pallet removal leads additional space in the container, which if used wisely can accommodate more number of shippers per container. (Refer to case-study)

In spite of all the advantages, the humble slip sheet finds limited users in India. The primary reason, according to Bhagwat, is a lack of awareness of the concept. "Secondly, the unwillingness of companies

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to make the capital investment in the push-pull forklift truck is a deterrent. They do not realise that this one-time investment with ROI of less than three years can earn huge logistical savings.”

Ananthakrishnan says, “The Indian markets are used to pallets and the slip sheets being a relatively new concept is slow to take off. The adoption of slip sheets in India is driven by the end-user rather than the product manufacturer wanting to shift to newer technologies. If end-user decides not to accept goods on pallets and, then customers will switch to meet their customers’ requirements.”

In last 10 years, Cascade has sold more than 80 push-pull machines in India. “However, this situation is changing,” says Bhagwat. “Year on year, the number of installations continue to surge.”

Expert Talk | Kevin Howard

I love slip sheets, but only when they are the appropriate solution to the problem in question. There are some important limitations to the successful implementation of slip sheets.

So, when do slip sheets work in a supply chain? When the company either controls the two end points or when a company knows that each point within the supply chain has the equipment and training to handle their slip sheeted loads.

Environmental impact and material choices

The corrugated slip sheets are the least expensive, but also they are most likely to tear and fall apart, which can lead to product damage. I believe solid fiberboard slip sheets are the most commonly used materials. If these are used for ocean shipments, then they have to be water resistant. Also, to be strong enough for multiple handlings, many users demand virgin fibreboard (no recycled content) slip sheets. Such sheets then use virgin material and are non-recyclable due to the water resistant resin.

But my favourite is polyethylene slip sheet. It can be made with a high percentage of recycled content and then recycled at the end of its life. Some slip sheet manufacturers pay a premium for getting the used sheets back so as to recycle them into new sheets. Whether you get paid for this scrap, or simply recycle them, it’s still less expensive than disposing water-resistant paper sheets. On top of that, the plastic sheets are far more robust and resistant to tabs tearing. Plastic sheets may cost more than fiberboard sheets, but once you consider their superior performance and the difference in costs at end of life, I think plastic is a better option.

Kevin Howard is the principal consultant for the packaging consulting firm Packnomics, LLC. He can be reached at kevin.howard@packnomics.com

Case-study | Bengaluru - based food manufacturer saves millions with slip sheets

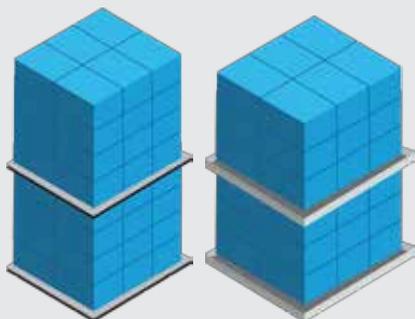
A Bengaluru-based food product manufacturer, which exports to the US market, recently implemented slip sheet for one of its high volume product, which is shipped via sea transport.

The company ships approximately 45,000 packs per month in 1,872 shippers on 104 pallets in three containers.

In December 2016, after continuous trials for over seven months, the company switched to slip sheets. It has invested in two sets of push-pull attachments one for the plant in Bengaluru and the other for the warehouse in the USA costing Rs 25-lakhs each.

Eliminating the pallet, the company was able to add two extra layers of shippers per container and thereby it was able to ship all the shippers in only two containers.

Not only did they save the material cost by eliminating the pallet but also earned logistical savings by reducing the number of containers required. The company has earned monthly material and logistical savings of worth Rs 6,42,040. It aims to recover the ROI in about eight months.



Caption: Eliminating the pallets, the company was able to add two extra layers of shippers per container and thereby it was able to ship all the shippers in only two containers

This article was first published in WhatPackaging? supplement of PrintWeek India in July 2017

About WhatPackaging?

WhatPackaging? is the labels and packaging extension of India’s leading printing industry magazine PrintWeek India.

WhatPackaging? aspires to deliver relevant content covering all elements of the packaging supply chain – from design to print production and converting to packing and filling to warehousing and logistics, and retail.

WhatPackaging?’s target readership includes: packaging technologists at end-user companies, top executives at label, carton and flexible packaging converters, designers at branding agencies and managers at packaging and labeling equipment manufacturers and suppliers.

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Scrubbers & Bundle Breakers

This article is about two terminologies that were created and are used liberally in the corrugated box making industry today—Scrubber® (Scrubber is a registered trademark and patented device of Geo. M. Martin Co.) and bundle breaker. These terms describe more of what the equipment does rather than its OEM machine ID.

Scrubbers

The term Scrubber describes a process and associated material handling equipment directly beyond the rotary diecutter to facilitate and manipulate diecut blanks for smooth, continuous stacking.

Let's begin as the equipment is employed. After the diecutter rotates and cuts the parts, the sheet is fed into the Scrubber/stacker. When a Scrubber is opened for access, you get a good look at the complexity and quantity of wheels and mechanisms involved with this elaborate sheet handler.

Diagram 1 shows the Scrubber in the ready position. This is where the diecut blanks enter a controlled path to positively carry the blanks further downstream to the hopper area, while managing speed adjustments and simultaneously introducing a gap for lingering waste to

drop. The objective is to present a steady, organized flow of diecut blanks to the stacker and eliminate any waste pieces that may travel with the finished product.

As with most modern converting equipment, the Scrubber has a touch screen interface to manage the numerous moving parts (**see Diagram 2**) which are broken into sections. The rows of wheels can be manipulated left, right, up and down. There are also fence lines of what can be described as a very course comb with long, rigid bristles—the Scrubber brushes (**see Diagram 3**). These are used to sweep away persistent waste pieces and aid in blank control to hold the sheets down to the belts of the stacker.

As with any new technology there was a learning curve. Box plants using the Scrubber technology initially instructed the diemaker to chop the waste up very



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



(Diagram 2)

small (some as small as 1.5" x 1.5" or 38mm x 38mm). The theory was that if a waste piece is small enough, even if it travels down and into the scrubber section, it will not be able to make it through. Part of the design is that the wheel rows are many and each subsequent row through the system is offset from the previous. A small piece of waste may get caught in the first set of wheels, but since the next row is offset (not directly in line), the waste piece isn't large enough to coast the required distance to catch another ride with the diecut box.

Scrap chopping the rotary die

Incorporating a grid of knives into the rotary cutting die to alter a large waste area into confetti will come with a consequence.

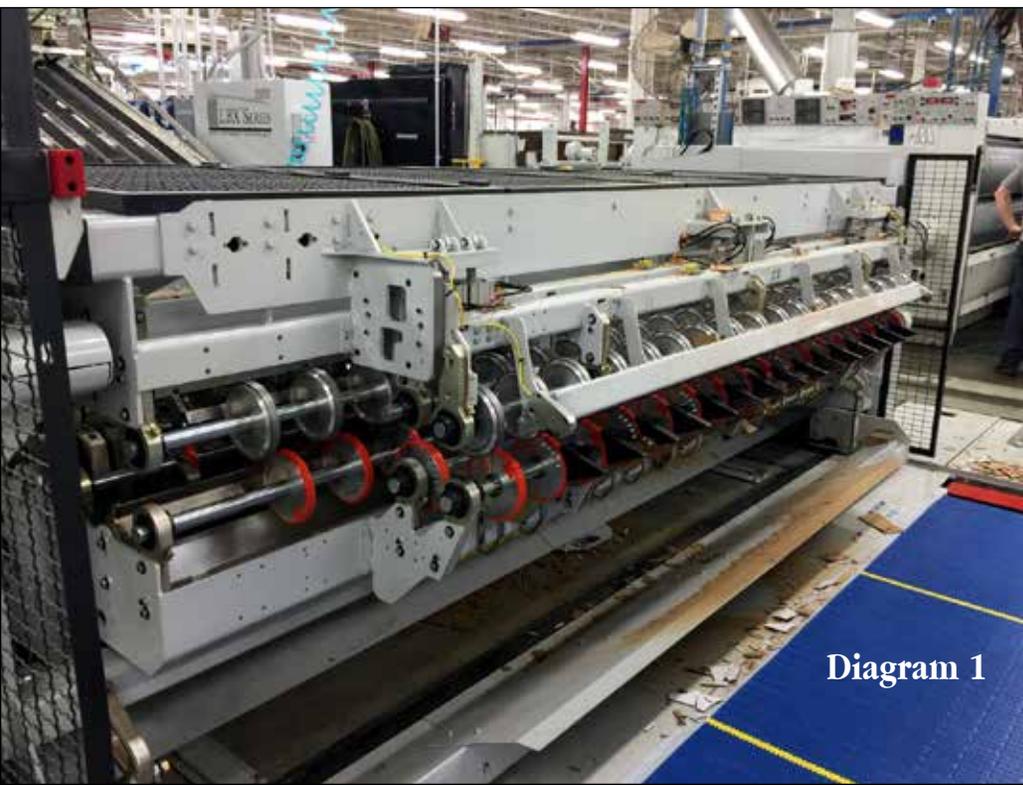


Diagram 1

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(Diagram 3)

As illustrated in **Diagram 4**, not only does this pose an issue with bolt hole placement for securing the die, but it also makes the die weak due to the smaller bridges of wood that hold the die together. Beyond that, for every knife cut and intersection that is added, an exponential increase in cut resistance results. As diecutting resistance increases, so increases the needed penetration into the anvil. Anvils will wear, excessive ejection rubber distorts parts and the machine journals themselves are subject to extreme pounding. Since

the goal is throughput, the die blanks are organized to better maximize the total cylinder area. Miniaturizing the waste dissection will only be detrimental in the long run. I understand that the OEM has restated the maximum size of 2" x 2" (50mm x 50mm). This makes a good deal of sense from many viewpoints.

Bundle breakers

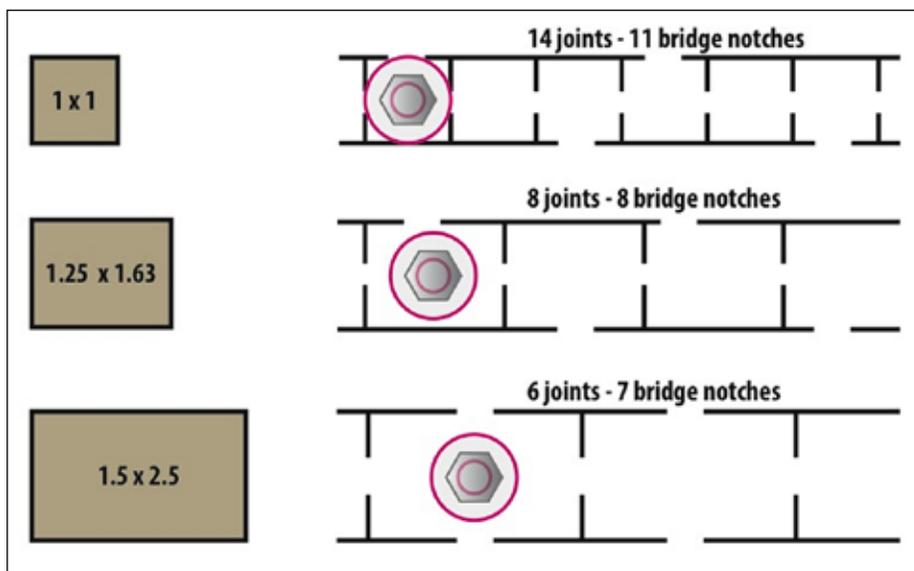
After the Scrubber section, the sheets travel along a conveyor table called the stacking deck. There are a multitude of

stacker equipment choices, but in short, this is generally a large conveyor that runs the blanks into a hopper or accumulator. The stacker will use photo eyes to detect the rising stack height. As the stack gets higher, the stacker conveyor elevates to keep the flow of blanks dropping neatly on the top of the accumulated pile. When the pile reaches the preferred height, the stack exits and the process starts over.

In maximizing the diecut cylinder area, it is often planned that many parts are ganged together on a die. They are nicked together by using perforation rules or by grinding a nick into the common knives. This converts the many parts into a single group, which in turn helps simplify the transport through the Scrubber and up the stacker. Yes, I know what you're thinking:

1. We send a big sheet into the machine.
2. We chop it up into smaller pieces.
3. We tie them back together again.
4. Finally, yes, we will break them back into individual parts (see **Diagrams 5 and 6**)!

You have to admit, it sounds challenging, yet the yield of boxes can be two to four times greater than a conventional, multiple across diecut order.



(Diagram 4)



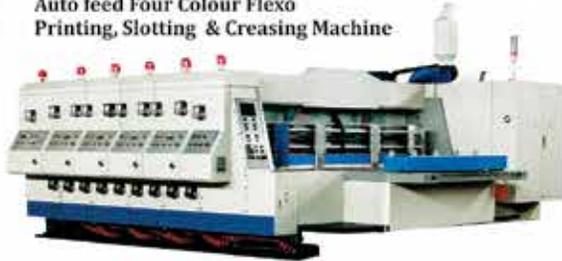
(Diagram 5)

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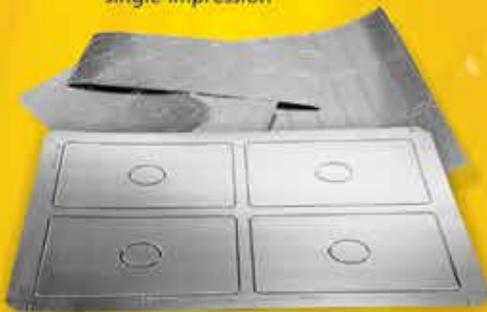
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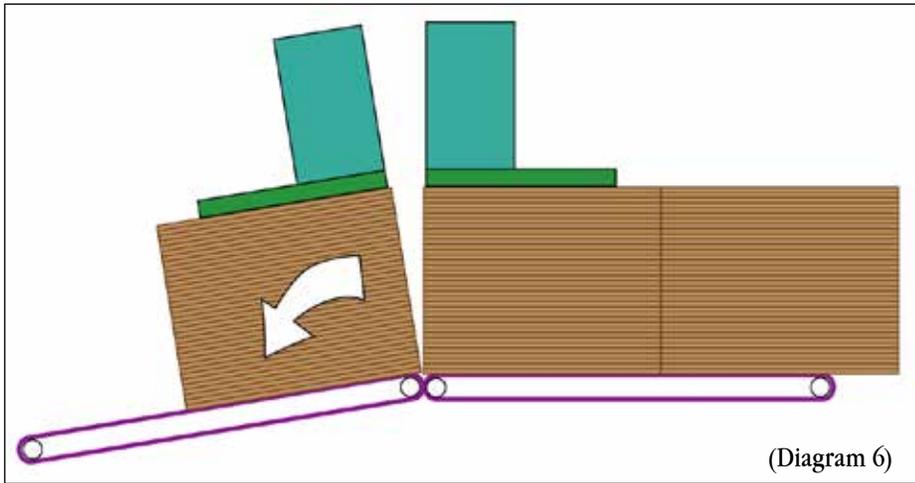
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Of course, to do this we need to incorporate another conveyor line from the stacker accumulator to the bundle breaker. This is necessary to manage the steady flow of the sheet stacks to the breaker equipment.

In most cases, the accumulated stacks will need to be rotated once and sometimes twice to get the ganged group broken back into individuals. As you can imagine, this takes a good deal of floor space. **Diagram 7** shows the separated stack moving to the palletizer.

The key decisions about bundle breaking are:

- Paper, die arrangement, feed direction related to the flutes and how you will nick the blanks together knowing that

you eventually will need to break them apart. One would prefer that the buyer never realizes that you nicked them in the first place.

- At the point where we have enough nicks between parts to carry them to the breaker in one piece, how high can you stack them without having a problem breaking them apart? Typically this is 15" (381mm) in height, yet there is a breaker supplier than can "break" bundles that exceed 16" (406mm) in height.
- At that stack height, will you be crushing the sheets with the breaker clamps, and is this stack height appropriate for the print, diecut and operational speed? Having taller bundles results in much

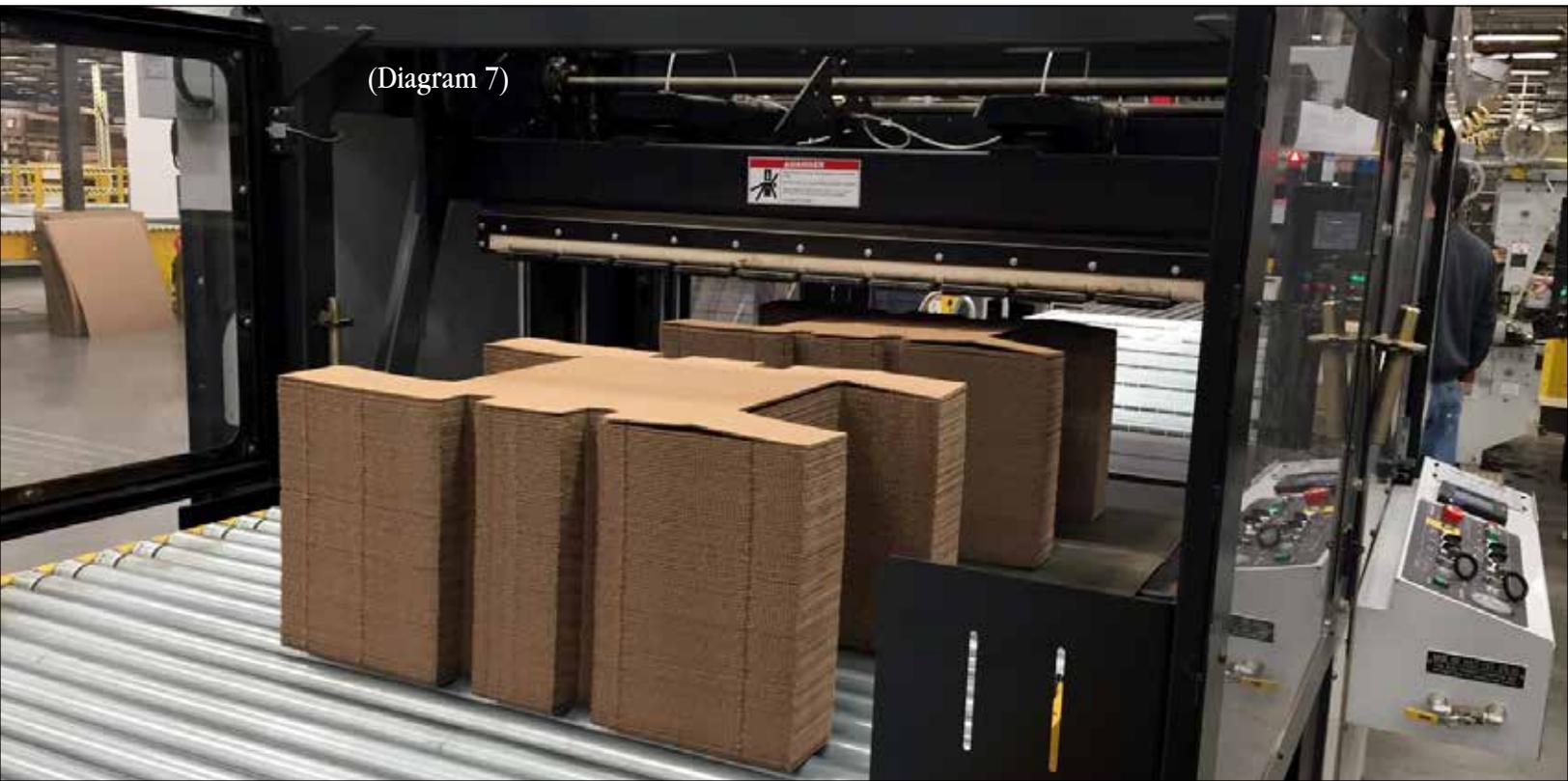
higher performance and throughput of boxes.

- After all of this, is what has been presented to the palletizer enough, or too much? Steps must be taken to ensure its top performance, or it will immediately become the system "limitation."

The key to success or failure is in creating nicks that hold the sheets together yet do not show the nick. Understanding the requirements, the holding/breaking forces and the acceptable cosmetics of the package should all be considered. There are a number of products available and knowledge-based articles to be found. Reference sources include: National Steel Rule Co.'s PERFormaX rule (www.steelrule.com) and the International Association of Diecutting and Diemaking, www.iadd.org.

Remember, the converting line performs all of the following activities in order:

1. Sheets are organized to feed the press,
2. Sheets are printed,
3. Sheets are diecut,
4. Diecuts are bundled,
5. Stacks are broken apart, and
6. Individual diecut boxes are palletized.



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All of this must be in harmony. Even if you are not familiar with the process, you can certainly harbor a guess that to get all of this to work at the same speed might be a bit of a challenge. And your guess would be right. Automation is great when it works, but in reality it is the overall coordination of these sequential activities that make the system profitable.

You will find today's technology allows for a short learning curve with instant performance improvements, and even greater performance improvements as your experience grows. The successful process requires precision cutting dies and printing plates, educated operators and optimization from beginning to end.

Kevin Koelsch is a 35-year veteran diemaker, manager and trainer. He joined Dynamic Dies, Inc. in 2013 as Vice President of Operations. Kevin can be reached at 1-419-350-3415 or by email at kevin_k@dynamicdies.com. For more information, visit www.dynamicdies.com.

This article is reproduced with permission from the International Association of Diecutting and Diemaking's monthly magazine, The Cutting Edge, March 2016.

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 600+ 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.

OBITUARY



Rex Woodville-Price

Rex Woodville-Price passed away in July. He was well known for his technical expertise, his insatiable intellectual curiosity, his dedication to serving customers, and his wry sense of humor.

He authored many technical articles for the industry's trade magazines, including *Corrugated Today*.

He had graciously permitted us to print his articles in *The Corrugator*.

Russell Smith spent 50 years in the folding carton and corrugated box industry, with the last 16 of those years as a consultant. Now retired for 10 years, he has been honored with three lifetime achievement awards (from IADD, TAPPI and Ward Machinery Co).

Our association with him over the years had helped us to make our magazine *The Corrugator* rich in value and content.



Russell Smith

The Team Corrugator expresses condolences on the sad and untimely demises of these authors.



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FCBM 4th Managing Committee Meeting, 20th August, 2017 - Puri

EICMA hosted the 4th Managing Committee Meeting of FCBM on 20th August, 2017. We were able to watch the proceedings of the meeting as special invitees on the day.

We were delighted to have with us senior members of FCBM, including Mr. Greesh Sardana, President, who graced the occasion.

45th Annual General Meeting of Eastern India Corrugated Box Manufacturers' Association

For a new entrant into the EICMA family, the 45th Annual Meeting of the Eastern India Corrugated Box Manufacturers' Association was an experience to be cherished for a long time to come. Held on 19th September, 2017, the venue needs special mention, as it was the first time



in the history of EICMA, that the AGM was held in Lord Jagannath Dham, Puri, Odisha.

The camaraderie and fellowship, hallmark of every EICMA programme, was very

much evident during the event in Puri. The AGM was held in Pramod Convention and Resorts, a boutique hotel. The setting of the banquet hall had its elegance and grandeur, yet easy and informal atmosphere. Puri, being a tourist as well as a pilgrimage





destination – members attended the AGM with family members. This year, the AGM was special, as there was a change of guard at the top. Mr. Narendra Jhunjhunwala – fondly known as Narendra Bhai, took over as the President and Mr. Mohit Bajaj was elected as the Vice President. Mr. Achyut Chandra, Hon Secretary and Mr. Nitesh Chaudhury, Treasurer, completed the new board that would take EICMA forward in the coming years. Mr. Soumitra Choudhury, Mr. Chetan Shah, Mr. Bishwa Nath Kedia, Mr. Anil Kr Agarwal, Mr. Pradip Agarwal, Mr. Arun Jhanwar, Mr. Sorav Jhawar were elected as Managing Committee Members for the current year. Yours truly, was also elected in the newly formed committee – for the first time.

Mr. Hemant Saraogi made a “spirited” presentation on the outgoing President – Mr. Milan Dey and Mr. Soumitra Chowdhury also had a few words to say, before seeing off Milan da. While handing over the illustrious EICMA Baton, Mr. Milan Dey said that, after 4 years as EICMA President, he was happy to hand over charge to the most deserving person – Mr. Jhunjhunwala to take EICMA to greater heights.

The newly elected President of the Association, Shri Narendra Kumar Jhunjhunwala in his address observed that the 45th AGM is a special event for EICMA to raise the profile of the Association on the national stage. In this regard he specially thanked the support of the Past Presidents and members of the Managing Committee. He specially thanked the immediate Past President, Shri Milan Kumar Dey for his wonderful tenure and leadership as the President for taking the activities of the Chamber to an enviable height. In the context, he specially urged that ‘we must work collectively and effectively within our Association’.

Mr. Ram Kumar Sunkara made a Presentation on the the 46th FCBM Conference to be hosted by WICMA. This being a special occasion - WICMA is celebrating its Golden Jubilee year, Mr. Sunkara invited everyone present to attend the Conference at JW Marriott, Pune between 17th and 19th November, 2017. The theme of the Conference reflects the vision of our Prime Minister for ‘Emerging New India’ which will open up new opportunities for growth for everyone.

Mr. Harish Madan made a Presentation on the forthcoming ICCMA Congress and IndiaCorr Expo 2017 to be held between 14th and 16th September, 2017 at India Expo Mart, Greater Noida, Delhi-NCR.

Mr. R. G. Agarwala, apprised the house of the implications of GST.

The AGM ended with a hearty vote of thanks by Mr. Mohit Bajaj.

The evening programme on 19th August was hosted at the picturesque lawn of the hotel and thankfully the weather Gods answered our prayers for a dry evening. The heady cocktail of retro music, sumptuous food and the sound of the splashing waves made the evening a truly memorable one. Soumitra da’s rendition of old Hindi and English songs and Mohit Ji’s standup acts were added flavours, enjoyed by all, including the FCBM Managing Committee Members and their family.

EICMA hosted the 4th Managing Committee Meeting of FCBM on 20th August, 2017. We were able to watch the proceedings of the meeting as special invitees on the day.

While the men were at work, the ladies had a fun-filled event, very efficiently designed by the first lady, Mrs. Bina Jhunjhunwala.

As the delegates began to depart after lunch on 20th, realization started to sink in – the extent of effort and planning that went into hosting this event held over two days, in Puri. Being part of the team from the very beginning, we were reminded that there should be no lapses on the hospitality front and needless to mention, Team EICMA, once again, came out in flying colours.

Well, yours truly had to endure a long drive back from Puri with Milan da, Soumitra da and Achyut da, finally reaching home at 3am. It may have been a tiring endeavor but a hugely satisfying one.

Compiled By: **Rajarshee Datta**





SICBMA Activities

In the month of June, we conducted another round of Meeting on GST, as more rules and procedures were notified since our first meeting on GST in the month of April. This meeting was inaugurated by Smt. B. Maheshwari, I.A.S., Joint Commissioner (Administration), Commercial Taxes Department, Tamilnadu and more than 100 members attended the same.

In month of July we had an Extra-Ordinary General Body (EGM) Meeting to take decision on Proposed SICBMA Complex at Ambattur, Chennai and amend our Bye-Law to make provision to create SICBMA Chapters. The meeting had sufficient quorum and both the proposals sailed through successfully. On the sidelines of EGM, we introduced a new initiative, SICBMA Raw Material Wing which helps members to buy Kraft Paper jointly and enjoy better service and pricing from Mills. This proposal was well received by the members and will soon be operational.

Welcome to Coimbatore Members

Following the amendments of Bye-Law we invited Coimbatore Corrugators to officially be part of SICBMA as Coimbatore Chapter. They have gladly agreed and the process of Chapter Formation is underway.

Till date 53 Coimbatore Members joined FCBM. Finally, a long pending impasse in the industry has been overcome and a new era dawns. Soon we expect to have more Chapters and bring more Corrugators under the fold of SICBMA.

We have started the preparatory work for FCBM Conference 2018.

Hope to finalize the venue and date soon.



**SICBMA Coimbatore Chapter,
AGM held at Thirupur held on
17th September 2017**

SICBMA, President K. Rajasankkar, Secretary, G. Rajkumar, Past Presidents A. P. Anburaj, K. Krishna Reddy, were the special guests.

The first major event after the Coimbatore members entered the fold of SICBMA.



Cricket Dhamaka

Conducted on 10 September 2017, it was really amazing, filled with inspiring enthusiasm among our members.

Excellent arrangements... starting from Ground, Food, Banner, T-Shirts, Cups and most importantly the jubilant mood of players.

It was really worth taking this effort.





45th AGM and Conference of GCBMA held in Goa

10-11 September 2017

It was a great pleasure, to organise the 45th AGM and Conference in Goa- the preferred destination in India. The event was spread over 2 days. More than 250 members participated enthusiastically.

The 1st day i.e. 10th September was dedicated to the Technical Seminar. The subject was 'Fluting Parameters'. Mr. Ram Kumar Sunkara explained the subject in detail.

Members were treated to a Cultural Programme and Gala Dinner in the evening.

On 11th, before the AGM all the sponsors and organisers were felicitated by President Prahladbhai Patel, members of WICMA and members of GCBMA.

In the 45th AGM, Mr. Prahlad Patel was unanimously elected again, as President.

Other office bearers elected are:

Mr. Amrut Patel - VP I,
Mr. Sunil Purswani - VP II;
Mr. Deepak Patel – Hon. Secretary,
Mr. Mansukh Patel - Hon. Secretary I,
Mr. Pankaj Yadav – Hon. Secretary II and
Mr. Vijay Patel – Hon. Treasure.

Mr. Prahlad Patel informed the house that GCBMA has become No 1, in terms of membership in the All India FCBM Family.

Programme ended with National Anthem.

After the AGM, members enjoyed a Lunch.

On 11th evening there was gala dinner and cultural programme – a perfect end to the great two days of togetherness among members.

The AGM and Conference were a grand success.



Team GCBMA led by President Prahladbhai and other office bearers deserve hearty congratulations for organising such a wonderful programme – to the delight of all members.

As reported by -
Sunil Purswani –GCBMA- VP II





SEMINAR on GST

UPCBMA organised a Seminar on GST on 27th June.

Commissioner Central Excise & Service Tax, Noida Shri. Manmohan Singh IRS and Addl. Commissioner, Noida Shri. Kumar Prashant IAS headed this seminar.

More than 150 Corrugators from Noida and nearby areas attended and derived the benefit.



WICMA Marathwada Division organises SEMINAR on GST

A seminar was organized by Marathwada Division at Hotel Ajanta Ambassador, Aurangabad on 25th June.

The subject was “UNDERSTANDING AND IMPLEMENTING GST – For Paper Packaging & Allied industries”

Seminar was conducted with the following sessions.

1. Govt officials and Tally Solutions Pvt. Ltd. spoke on the compliance of GST
2. Shri Gautamji Nandawat; a renowned Chartered Accountant was the speaker.

All the speakers with their indepth knowledge about GST explained the impact of GST on our industry and how to prepare ourselves for this taxation reform. Also software related issues were addressed by a representative from Tally.

Members highly appreciated the presentations.

Attendance was in large numbers along with their staff members.

The seminar was followed by Hi-Tea





WELCOME TO THE **50th ANNUAL GENERAL MEETING** at 3.00 pm, on Saturday, 9th September 2017 at Hotel Sai Palace, Chakala Andheri (E) Mumbai **(FOR WICMA MEMBERS ONLY)**

WICMA AGM

WICMA held its 50th Annual General Meeting on 9th September at Hotel Sai Palace, Mumbai.

A specially gold embossed cover for the Annual Report was prepared to highlight the golden jubilee year of the Association.

WICMA is the largest and first organisation of corrugated box makers in India to have completed 50 years of its service to Corrugated Box Makers.





46th FCBM Conference

JW Marriott Hotel, Pune INDIA

Organised by : **WICMA** - in their **GOLDEN JUBILEE** Year



Corrugated Packaging for the **Emerging NEW INDIA**

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An opportunity to consult experts to get a new insight into problems related to Corrugated Packaging.

OTHER HIGHLIGHTS

- ◆ 5 Technical Sessions.
- ◆ Super Ambience.
- ◆ Cultural Programmes.
- ◆ Exhibition Showcasing New developments.
- ◆ Visit planned to BOBST Manufacturing facility.
- ◆ Local sightseeing programmes.
- ◆ Visit to Shirdi & Mahabaleshwar Hill Station for interested members.



For more details & participation forms log on to conference.wicma.com



46th Conference of Federation of Corrugated Box Manufacturers of India

17-19, November 2017 - JW Marriott Hotel, Pune, INDIA



Synchronising Event



Registration

For online registration, please log on to conference.wicma.com
For more than one participant, please make photo copies to fill details of each participant

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Please use separate form for each Participant & Family

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Spot	8500	1530	10030
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Guest	10000	1800	11800
Guest Spouse	8000	1440	9440
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- Note:**
- Cheques/ DDs should be drawn in favour of **Western India Corrugated Box Manufacturers' Association** and sent to WICMA Office.
 - Alternatively, cheque/cash may be deposited at any branch of **Bank of Baroda**, as per details mentioned below:
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 - For confirmation, copy of receipted Bank pay-in slip or NEFT/RTGS counterfoil must be sent to WICMA Office with full transaction details, by email or post.
 - For Registrations received after 1st November, 2017, Registration Kit will be given subject to availability.
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Care and Maintenance of Cutting Dies

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Check in procedure

1. As soon as new dies are received, check to see if they fit the dimensions of the original pattern, print or sample originally sent to your diemaker. Check test cuts from the dies to ensure that the measurements are correct.
2. The next step would be to check the identification of the die, such as the die number, size, style and pattern date. Cutting dies may also be color-coded according to styles, types or sizes. A simple check of the die to its master pattern will ensure that the correct coding data is on it. This can save considerable problems later in production.
3. The last check in procedure is to store the die in its assigned storage area. This ensures that it is protected and can be easily found.

Care during use

In many situations, diecutters on piece work tend to treat the dies rough for the sake of speed.

The basics of good diecutting are: using cutting dies that are maintained in a sharp condition and in good repair; on cutting surfaces that are well groomed and flat; and cutting only as much material in one diecut that will not overload the die and cause it to “explode” open.

Several factors can eliminate die problems before they begin:

1. A common cause of die failure is improper pad use. Diecutters should distribute their cutting over the total area of the cutting surface. Most operators, however, tend to use only



the front center portion of the cutting pad. After extended use, the cutting pad is worn away in the front center of the cutting surface. Now the diecutter is cutting on an uneven surface, creating a strain on the die and requiring more pressure to get a clean cut. Eventually, the die becomes warped out of shape and could finally break.

2. A common cause of die failure involving large dies on clicker-type machines is diecutting with a die that is larger in area than the head of the cutting press. For example, a diecutter has to diecut a large piece that is 32" (812.8mm) long and the head of the press is only 16" or 24" (406.4 or 609.6mm) wide. The operator then has to move the head over on one end of the die and make an impression and then swing the head of the machine to the other end of the die and make another impression. This practice results in making the die bow like a banana and creates strain and possibly breakage. If it is not practical to use the die on a press that has a head big enough to cover the whole die, the diecutter must accept potential die breakage or consider inverted cutting where the die is edge up on the machine bed with the pad on the beam. If more and more large-sized dies are

being used, it would pay to invest in a larger press that best handles this type of die cutting.

3. Another reason for die breakage is catching the die with a glancing blow. This happens on single post clicker machines when the operator, in order to speed up production, trips the beam while it is being swung over the die. The result is that the die is hit in an angular direction.
4. Often, due to an uneven cutting surface situation, an operator will increase the cutting pressure on his press to give deeper penetration into the cutting surface. Since only a minimum amount of penetration is required for efficient clean diecutting, if an operator finds that he needs to dig his die deep into a cutting surface, this indicates that either the die is dull, the cutting surface is not in the best of condition or that a different type of cutting surface is required for the job.
5. There are times when a die gets stuck in a cutting surface. If it is necessary to force a die out of a cutting surface, use a rawhide mallet or a plastic-tipped hammer. Never hit a die with a metal hammer.

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6. While cutting, it is often necessary to lay the die down while spreading out material on the clicker press or rearranging the material to be diecut. It is very important to have a “sitting spot” for the die while it is not in use so the cutting edge can be protected to avoid nicking and dulling, and prevent the die from being accidentally dropped.
7. After a diecutter is finished with a particular die, it should be returned to its original storage area and not allowed to lie around in the cutting area where it could be damaged. If the die requires sharpening or repair, it should be taken out of service and immediately fixed and not allowed to wait for the next time it is required only to find it is unserviceable.

Storage of cutting dies

The storage of cutting dies is of prime importance in maintaining their good condition. It is wise to store a set of dies with the identification markings clearly visible so that the correct die can be easily picked out of a set. This is where the proper code markings and color coding pay a dividend.

Dies should be stored in an area that is accessible to the die presses, but not in the way of the flow of materials to be cut. Also, the dies should be stored in an area that is dry and away from moisture. If the dies are going to be stored for a long period of time, in humid situations, it is best to give them a light coating of oil or some sort of preservative like WD-40 to prevent rusting.

There are many possible methods of die storage. Whatever storage system utilized, it is satisfactory as long as steps are taken to protect the dies from one another so there is no cutting edge to cutting edge contact of the dies in storage. If cutting dies must be stacked, put cardboard between them and limit the stack to two high.

Maintenance of cutting dies

Preventive maintenance is the key to long and efficient die life. With proper care

during use, adequate storage and simple inspection after each use, dies should give many years of service.

If a die gets dull from constant use, it should be sharpened. Ideally, when dies require resharpener, they should be returned to your diemaker for resharpener or reconditioning. Your diemaker knows how to best put a new edge onto a die and make it perform like new.

An advantage of clicker and high dies is that they can be resharpener many times to extend their working life. Generally, steel rule dies are not resharpener but are returned and the steel rule blade is simply replaced in the die.

Many firms periodically evaluate which dies are currently being utilized or expected to be used in the future or on a long-term basis. They then schedule to return these dies to us for resharpener or reconditioning, usually when the dies are temporarily out of service, between production requirements or at the vacation or inventory period when production is down. The dies are shipped off to us on the last day of work before the shutdown. The dies are then serviced by either resharpener or reconditioning and returned before the plant operations start again, so no time is lost in production.

Repairing broken or damaged dies

Whenever a die breaks, there is generally some contributing factor. Was the diecutter using the die properly? Was the cutting surface in good repair? Was the die pushed beyond its capabilities by trying to cut too many layers of material? Did the die give way due to a manufacturing fault of the die? These are some of the factors to look for when excessive breakage occurs.

One major error that some people do for expedience is send the die out to the local welding shop and have the die temporarily brazed with bronze. Never, never braze a die to repair it. An all steel die should always be welded. Each time a die is repaired by welding, it is most important that the die also be re-tempered.

When there are occasions where a die is damaged or knocked out of fit or shape, it is best to return the die to your diemaker for correction. When dies are returned, make certain that they are individually wrapped and packed so that during shipment extra damage will not occur. Also, include the original patterns to the dies, or the tin templates, so that the die can be repaired to its original shape and maintain its accuracy.

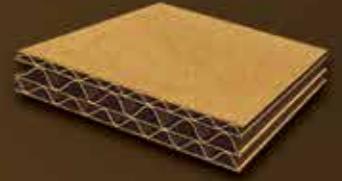
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Furniture out of cardboards for a sustainable future

Paper Shaper, a Mumbai-based corrugated cardboard manufacturing firm, is offering an alternate and sustainable solution to wooden and furniture made of other materials. It is the brainchild of Haresh Mehta.

From cradle to coffin and in between, chairs, tables, beds, storages surround us—either built from wood or from the combination of wood, plastic, and metal. Every year, with the growing population, millions of trees are fell to make furniture. However, forests can no longer meet this increasing demand and such heavy deforestation is detrimental to the environment. Though plastic furniture is a substitute for wood, the cost to the environment is much more. There is a need for alternative solutions that are sustainable and eco-friendly and cater well to our requirements.

Trying to find an alternative material that meets all the requirements of wooden furniture and at the same time is eco-



friendly, Mumbai-based Haresh Mehta came up with Paper Shaper. Under this brand name, he designs and manufactures furniture made out of corrugated

cardboard. This furniture is portable, durable, easy to assemble and store, recyclable, and costs less in comparison to furniture made of any other material.





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From a college dropout to an innovator

Haresh (64) hails from a Gujarati family that runs a packaging business. For the young Haresh, making money out of his family business did not hold as much appeal as sitting in a corner of his factory to twist, cut and assemble cardboard sheets into different shapes. Being a college dropout had marked Haresh as a failure for those around him, but all the while, there was an idea germinating in his mind. He followed it with total commitment and eventually came up with 'Paper Shaper'. Haresh completely believes in having faith in one's passion and calls himself a rebel who refuses conventionality.

From cradle to coffin and everything in-between

The furniture designed by Haresh is apt for an urban life as it is durable, lightweight, portable, and trendy. When not in use, one can just dismantle it and store it without wasting much space. The range of cardboard furniture covers cradles, chairs, storages, organisers, and even coffins. These coffins make it possible for a person to leave this world in an eco-friendly way as the boxes decompose faster than the wooden ones. At the same time, using cardboard furniture can significantly reduce the cutting of trees.

I have been toying with the idea for nearly 25 years, but the decision to launch the brand Paper Shaper online in May 2017 is relatively new. It was hard to convince people that corrugated furniture is sturdy and durable as the storage boxes they



see in grocery stores are flimsy. I made a rocking chair out of the boxes and made people sit on it to alter their perception about cardboard furniture, says Haresh Mehta.

Paper Shaper is a bootstrapped company. The product price range starts at Rs 3,000 and the furniture is delivered globally. The company expects to have a revenue base of Rs 30-40 crore in the coming five years. To market the niche idea of cardboard furniture, Haresh has launched a range of children's furniture online. While the wooden furniture available in the market is bulky with sharp edges, cardboard furniture is light and safe for children. It can also lead them to fun activities as they can assemble their own furniture, thus attaining a sense of belonging to it. In addition, they also get to shift their furniture according to their convenience.

The portable eco-friendly Loo Box

Sanitation is a huge problem in our country. While travelling long distances, finding a place to attend to nature's call is a big deal. The roadside toilets are also stinky and unhygienic. To solve this problem, Haresh has invented a portable toilet with corrugated cardboard. These toilets are lightweight, portable, easy to use, and at the same time eco-friendly.

The Loo Box is a solution to the problem of sanitation in India. It is also made of corrugated cardboard like all other furniture designed by me. It is lightweight, and can be folded and carried easily. Every aspect of this concept has been designed keeping the environment in mind. It can be handy for travellers and elderly at home, adds Haresh.

His innovative designs have earned him recognition and few of his clients include big brands like Camlin, Philips, Bajaj, Raymond, Gini & Jony. Through Paper Shaper, Haresh wants to cater to a wider market, given that his company is popular only in Mumbai. With more innovation and a wider category of items, he wishes to help people adopt sustainable furniture solutions.

Source: yourstory.com





03
Manufacturing Plant

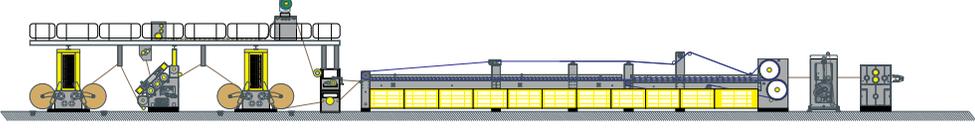
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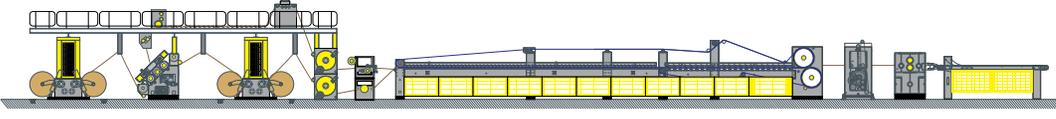
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Mini Plant designed & developed by CM for small corrugators converting 100 - 200 Tons / Month using 50-100 MP with Manual / Semi Auto Plant.



What are the Benefits MINI PLANT?
Production: 500 - 1000 Tons / Month
Man Power: 4-6
Quality: Excellent Board Quality
Shed Requirement: Existing (30 x 20 Mtr)



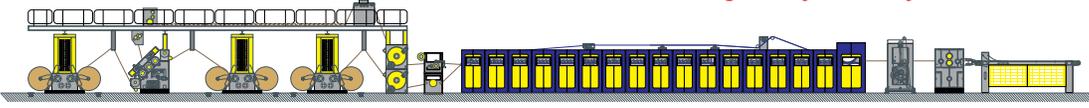
What is COMPACT 03 PLY PLANT?
Compact Plant is a little automated plant designed & developed by CM for medium corrugators converting 100 - 200 Tons / Month using 50-100 MP with Semi Auto Plant.



What are the Benefits COMPACT PLANT?
Production: 800 - 1500 Tons / Month
Man Power: 4-6
Quality: Excellent Board Quality
Shed Requirement: Existing (40 x 30 Mtr)



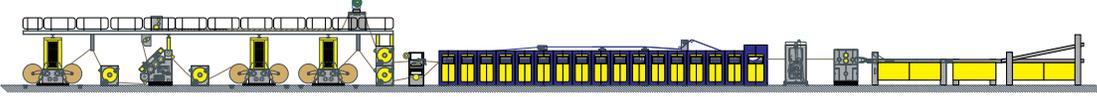
What is STANDARD 03 PLY PLANT?
Standard Plant is a complete automated plant designed & developed for Middle Level Corrugators converting 500 - 1000 Tons / Month using 50-80 MP with Semi / Auto Plant. Having Quality / Quantity Issue.



What are the Benefits STANDARD PLANT?
Production: 1000 - 2000 Tons / Month
Man Power: 6-8
Quality: Excellent Board Quality
Shed Requirement: Existing (50 x 40 Mtr)



What is PREMIUM 03 PLY PLANT?
Premium Plant is a Highly automated plant designed & developed for Corrugators needing Large Production with Quality Board.



What are the Benefits PREMIUM PLANT?
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Quality: Excellent Board Quality
Shed Requirement: Existing (80 x 50 Mtr)





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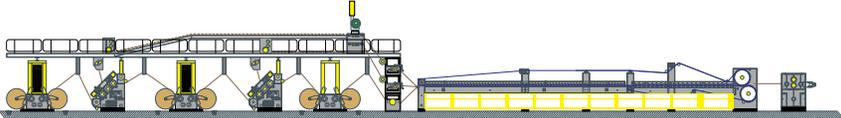


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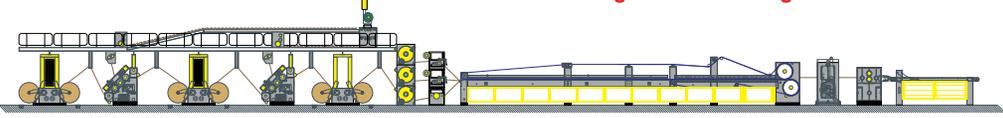
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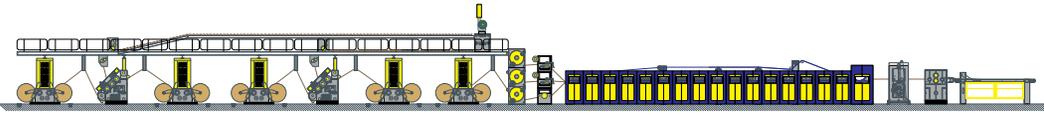
What is MINI 05 PLY PLANT?
Mini Plant designed & developed by CM for small corrugators converting
100 - 200 Tons / Month using 50-100 MP with Manual / Semi Auto Plant.

Why MINI PLANT?
Production: 500 - 1000 Tons / Month
Man Power: 6-8
Quality: Excellent Board Quality
Shed Requirement: Existing (40 x 25 Mtr)



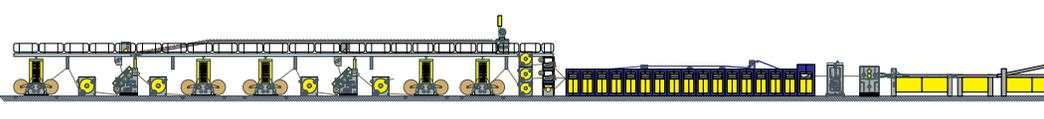
What is COMPACT 05 PLY PLANT?
Compact Plant is a little automated plant designed & developed by CM for small / medium
corrugators converting 100 - 200 Tons / Month using 50-100 MP with Semi Auto Plant.

What are the Benefits COMPACT PLANT?
Production: 800 - 1500 Tons / Month
Man Power: 8-10
Quality: Excellent Board Quality
Shed Requirement: Existing (50 x 40 Mtr)



What is STANDARD 05 PLY PLANT?
Standard Plant is a complete automated plant designed & developed for Middle Level
Corrugators converting 500 - 1000 Tons / Month using 50-80 MP with Semi / Auto Plant.

What are the Benefits STANDARD PLANT?
Production: 1000 - 2000 Tons / Month
Man Power: 8-10
Quality: Excellent Board Quality
Shed Requirement: Existing (70 x 50 Mtr)



What is PREMIUM 05 PLY PLANT?
Premium Plant is a Highly automated plant designed & developed for Corrugators
needing Large Production with Quality Board.

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Corrugated Board in United Nations Development Programme

Flashback-Remember your childhood when all the fruits and vegetables were packed in and brought in bamboo baskets in our homes as packaging materials. Besides that many consumer items like Pot, Utensils, Chatai, Mats, Curtains, Partitions and many more items of daily use we had been using were all made of bamboo.

Have you ever thought, that who were making all these things and from where it had been brought.Yes it had been brought from the villages where skilled villagers made it every day from using bamboo stripes knitting and made several daily useful things as describe above and earn sufficient daily wages and money for their survival that was their “Gruha Uddyog”. That “Gruha Uddyog” were run by various NGO’s and still running. That survival of small business were only possible because of three major factors one availability of raw material second their working skilled and third one was domestic market.

Today almost all old bamboo strips knitted packaging products like Tockaries, Baskets, Mats Partitions are been replaced by various types of latest and better packaging material like Plastic, Paper, Corrugated boxes, carton etc. in the name of development and deforestation as

well lack of bamboo and their cost. This leads to effect on their “Gruha Uddyog”, unemployment in the skilled villagers and hence today they are jobless and becoming poor, their sources of income is been come to an end.

I felt that we corrugators are also a part of that chain knowingly or unknowingly snatched their small old basket packaging business “Gruha Uddyog” in the race of new developed corrugated boxes packaging for fruits and vegetable. Hence I thought why not give something back to the skilled villagers who have still that skill of knitting by just replacing bamboo strips and using corrugated board strips to make Baskets, Curtains, Tockari, mats and many more decorative things with the help of NGO’s to sustain their ability of knitting skill and give back them to run their own small business of packaging. Yes coloured corrugated board strips with water resistance coating by knitting can be used in making various products with low cost.

With this Social and noble innovative idea and to promote corrugated board in the field of “Gruha Uddyog” ,I decided to took part in the Technology fair organised by UNDP/GEF/SGP during SGP Pan India Meet at Centre for Environment Education (CEE) , Ahmedabad from 15th to 17th March-2017.



Mr. Dharmendra Pandya,
Viva Packaging Products, Ahmedabad

This Innovative Technology Fair was designed as a meeting place for local communities, innovations incubators, neo engineers, neo architects, innovators and investors, the Fair would engage various stakeholders to explore newer business opportunities and collaborative ventures to provide technological solutions to environmental problems. This initiative aims to promote livelihoods and social entrepreneurship for sustainable development amongst grassroots innovators.



This concepts of knitting and using corrugated strips for making such products were appreciated by the Individuals, Organizations, promising audience like Community Practitioners, Professionals from the CSOs, NGOs, Government Representatives, Policy Makers,



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Stir for 30 minutes.
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Technical Specifications				
	CG30 / CG35 / CG40	PG30 / PG35 / PG40 / PG50	PG50	DDG40 / DDG50
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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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CG in 30/ 35/ 40 Kgs. which will give 200 Kgs. liquid Gum for application.

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United Nations Development (UNDP) Sr. Program Coordinator India Mr Prabhjot Sodhi discussed with Mr Dharmendra Pandya

Officials from the UNDP and other UN Organizations, Heads and Representatives from Business Houses, Development and Sustainability Practitioners, Subject Experts and Researchers, Innovations incubation Agencies more than 200 NGOs from all over India.

GEF/UNDP SGP India Meet, UNDP/GEF Small Grants Programme is a global corporate programme implemented by the United Nations Development Programme (UNDP) on behalf of the Global Environment Facility (GEF). The SGP works in partnership with the Ministry of Environment, Forest and Climate Change (MoEF& CC), Government of India. Small Grants Programme (GEF UNDP/SGP) globally in 122 countries is funded by Global Environment Facility (GEF).

In ECO(Everything Cardboard Offer) , Mr. Dharmendra Pandya showcased many Innovative useful non packaging products like “Biodegradable Toilet”(Urine diversion dry toilet) which is an immediate aid for the Earthquake victims as temporary toilet facility kit to avoid epidemic which generally hit due to lack of proper sanitation facilities reached to the affected area. This innovation has been awarded Corrustar Award of FCBM, Recognition by India Innovation Initiative-i3 in National Fair.

Besides this “Biodegradable Toilet”, innovative Cardboard foldable Chairs, Low cost Maths Toys, Cardboard Partition, Curtains, Mats, Basket and many more low cost products were showcased.

My Social aim was to promote low cost cardboard innovation amongst the interested NGOs. Who can further get the small grant from SGP/UNDP and start making low cost cardboard products like Cardboard Mat, Tockari, Basket, Curtain and many more decorative items and to keep the villagers knitting skill live and give them work to earn money and to survive back their old “Gruha Uddyog”.



Leading News Paper of Gujarat like Divya Bhaskar, Gujarat Samachar, Sandesh cover this UNDP/SGP Technology Fair selected innovations.



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Our design experts frequently conduct store checks for our customers to identify improvement opportunities. They understand the difference a few seconds make in the replenishment process, or the impact a well-designed opening system can have on work-safety and a clean and neat impression of the shelves. Also optimal shelf space utilisation is key when then offering a set of optimal design ideas to the customer.

The store efficiency and sales impact is always at our forefront in the concept development. We then strive to combine the ideal design with utmost transport, storage, filling and packaging efficiency to create a true TCO champion in Shelf Ready Packaging.

We have established a strong position in SRP consulting and support retail enterprises in establishing standards that simplify their processes and support their growth.

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Source: www.mondigroup.com



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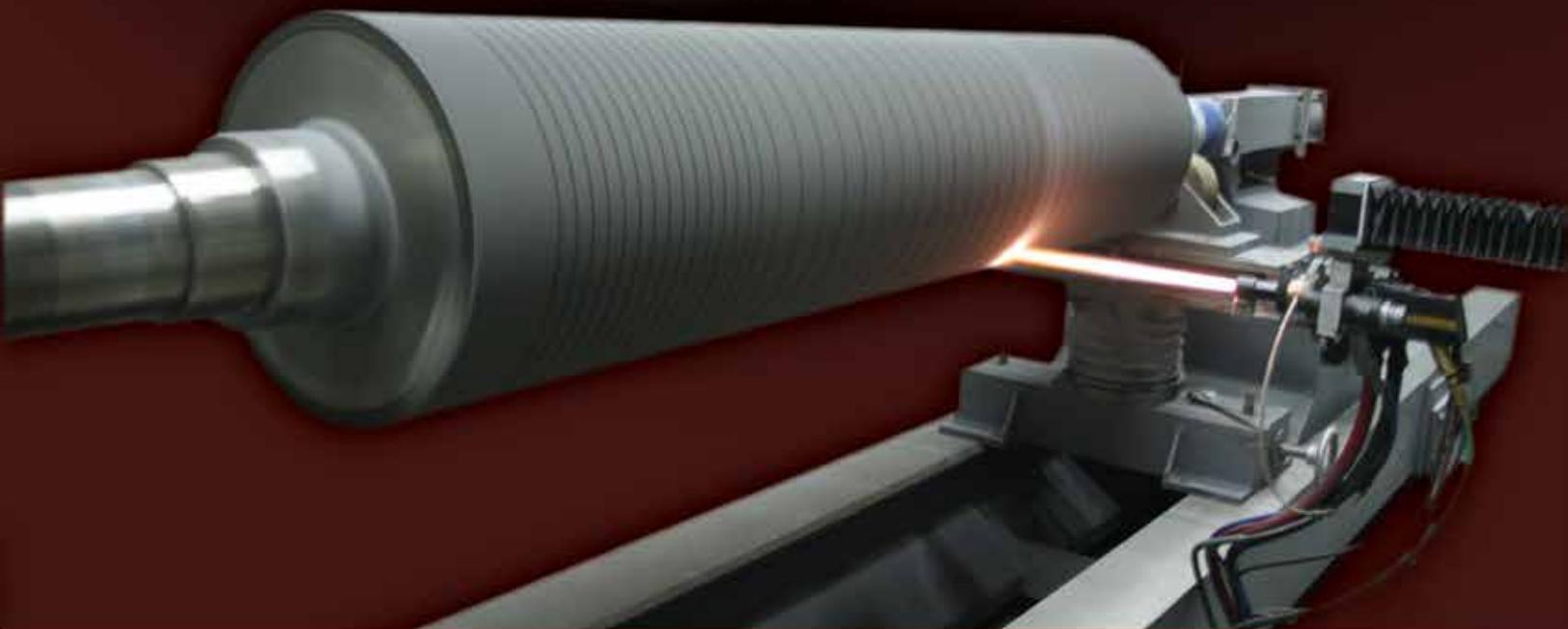


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Spotlight on... Corrugated | Packaging in 2017

Simon Creasey reports on how the corrugated sector is likely to perform in 2017 and what challenges are on the horizon.

To the uninitiated corrugated doesn't seem like the sexiest packaging sector. However, if you scratch beneath the surface you will find a hotbed of innovation and a sector that's enjoying steady growth.

Globally the market is expected to be worth an estimated \$226bn this year, according to Smithers Pira's report *The Future of Global Corrugated Packaging to 2021*. Smithers Pira expects the value of the corrugated market to reach \$269bn in 2021 thanks to year-on-year growth of 3.6% – slightly down on the 4.3% growth rate recorded in the period 2009-15.

Much of the recent growth of corrugated has been driven by global market leader China, with the US a close second. However, the UK corrugated sector continues to perform strongly with the country boasting a circa 2% global market share.

So what's driven this growth, how does the UK market shape up and what are the major obstacles that stand in the sector's way going forward?

In the last couple of decades the UK corrugated sector has undergone a seismic shift. Historically it was heavily reliant on producers of white and brown goods, but as manufacturing of these products increasingly shifted to the Far East, volumes started to dwindle – not surprisingly this global shift in production coincided with China's rise as market leader.

Food and drink boost

However, in the last few years corrugated has bounced back strongly thanks to its growing use by the food and drink sector – one packaging expert estimates that UK food and businesses account for around 65% of corrugated volumes.



Coinciding with this shift in customer demographics, the make-up of the corrugated industry has also witnessed significant changes. In the last decade or so the industry has undergone high levels of consolidation leading to a UK market dominated by five key players: DS Smith, Smurfit Kappa, Saica, Rigid Containers and Logson.

The consolidation trend continued this year although on a slightly smaller scale than in the past, says Nick Mockett, head of packaging M&A at Moorgate Capital, who points to Saica's acquisition of Americk and Logson's purchase of Boxshop. Mockett expects to see further consolidation going forward.

"There is still a fairly long tail of smaller companies which may fit into the portfolio of larger players," he explains. "There have been rumours of major north American corrugated businesses looking to bolster its European operations via a big deal. We have also been working with Asian players

looking to invest up to 5bn in European fibre packaging."

In addition to splashing the cash to acquire other complementary businesses these companies have also invested heavily in technology and upgrading their facilities in recent years. Partly to deliver efficiencies – the CPI estimates the UK corrugated industry has driven up productivity by 40% in the last decade – and partly to deliver innovative new products to market.

This innovation comes in many different guises, according to Andrew Barnetson, director of packaging affairs at the Confederation of Paper Industries. He cites the recent addition of a new fluting grade that sits between two other grades and the growing use of 'woolcool' – lambs wool used for thermal insulation – by pharmaceutical and food companies as evidence of innovation in the corrugated sector.



"This isn't necessarily what most people think of as innovation," says Barnetson. "People want sexy new boxes, they want something that's bling and has a 'wow' factor and there are occasions when the industry has created a 'wow' factor box. For instance, one of our members has produced a box that can hold a crate of beer, but the box is lined so it's waterproof which means that when you open it out

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you can use it as an ice box. That's got the 'wow' factor."

Another area where the industry has made impressive headway is in the lightweighting of corrugated materials.

"In the period 2004-15 the average weight of paper going into corrugated boxes decreased by 10% without any loss of strength," says Barnetson. "So the industry is using less material, creating small boxes and offering greater space efficiency."

Another area that's seen significant levels of innovation is the production of retail ready packaging. These packs have been one the biggest growth drivers for corrugated in the last decade and it's a trend that Smithers Pira predicts will continue to grow in the next few years. In the company's Future of Global Retail-Ready Packaging to 2021 report it estimates the segment will grow by around 4% per annum on average over the next five years and be worth \$67.6bn by 2021 – \$48.1bn of this will be in corrugated formats.

"Retail ready packaging has been one of the success stories of recent years," says Barnetson. "You've essentially got a presentation box that when done properly can look very attractive, provide additional information and present the product in a particular way."



Home ready

While retail ready, or 'shelf ready' packs as some people refer to them, are now a well-established presence in the food and drink industry, they've also spawned a rapidly growing new market segment: home ready packaging.



"In the past multipacks have been fairly non-functional," says Benjamin Punchard, senior global packaging analyst at Mintel. "They're essentially big bags with lots of smaller bags inside, but now the drive is towards 'how can we present this better in the home so that it isn't something that people just shove in the cupboard – it's something that people will be prepared to put on the side in the kitchen.' As a result the product becomes more front of mind, people will consume it quicker and they will repurchase sooner. It's all about improving the multipack experience."

Punchard has also noticed retailers and packaging manufacturers investing more time and energy into making improvements to e-commerce packaging. He thinks this is down to long-standing customer dissatisfaction with traditional e-commerce packs.

"Consumers are generally not happy with what they're getting at the moment," he explains. "The quality hasn't been very good, damage rates have been quite high and packs are difficult to open."

It's a challenge that corrugated manufacturers like Rigid Containers are already rising to, with Julian Freeman, Rigid's group sales and marketing director,

saying that e-commerce and retail ready packaging continues to be the driving force in terms of growth for the company.

"For e-commerce requirements, the emphasis here is still on predominantly plain, fit for purpose corrugated packs, but the innovation here is in the tear-tape

application and re-application that allow for easy return of goods, should they not be suitable for the consumer, and an increased focus on inside print to deliver a marketing message to the customer during the 'unboxing experiencing,'" says Freeman.

Mockett also believes e-commerce presents a major opportunity for the corrugated sector as it is the preferred medium for transit packaging affording protection and design differentiation. However, there is a slight conflict of interest surrounding consumer expectations of this type of packaging.

"Consumers typically state that they want less packaging, but they may not fully appreciate the role that the packaging takes in protecting the product," says Mockett. "The brands, particularly online shopping, have to try to balance out the amount of packaging used, the safe delivery of the products and also the appearance of the package when consumers first come into contact with it. This last area strikes me as one of opportunity as the consumer cannot be influenced on the web the way they can in a real shop. Perhaps we will see more design content, tactile finishes and interactive packaging as a consequence."

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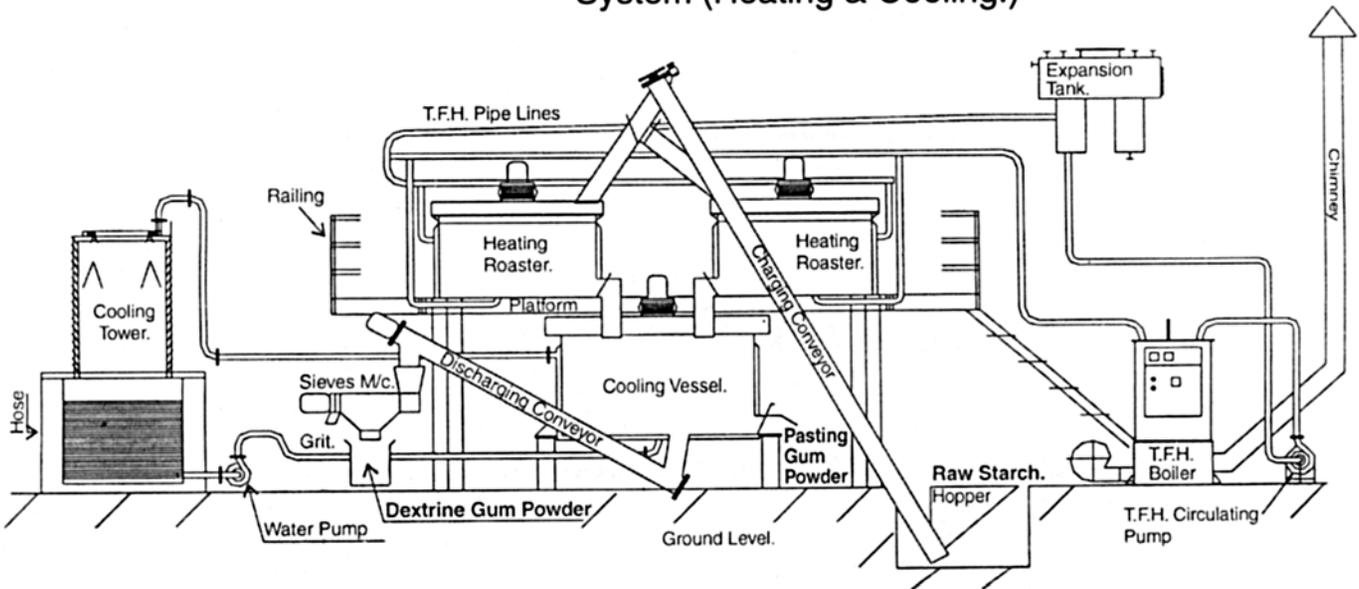
PLANT CAPACITY : 2 Tones / 4 Tones Per Shift

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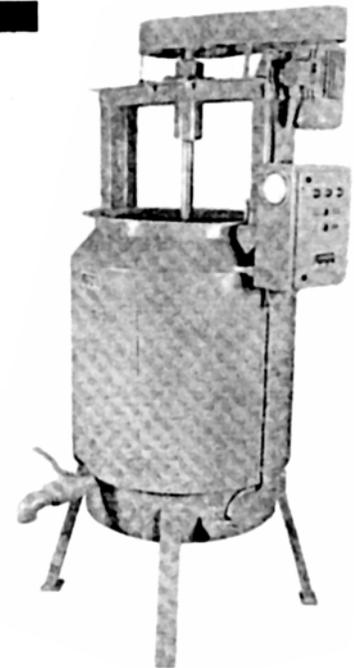
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Three challenges facing corrugated in 2017

Brexit

The same broad economic and social trends hang over the corrugated sector as they do every other industry sector, with the ongoing uncertainty set to have a lingering impact on businesses' decision making. The UK corrugated sector is dominated by some major multi-national companies, so when it comes to future investment decisions like where to build new factories, the terms of the UK's exit from the EU could have an impact on these decisions.

Sterling

Rising inflation caused by the recent fall in the value of sterling (which in turn was caused by the EU referendum vote) looks set to cause a slowdown in the economy and possibly even a recession. Corrugated packaging is used in consumption items (like food) and also for consumer durables (like washing machines) so if the economy slows consumers may defer spending on big ticket items, which could have a knock on effect on corrugated volumes.

E-Commerce

The rise of online retail presents a major opportunity, but it also presents a significant challenge, with retailers looking for innovative new packaging that can be used to deliver and return goods safely.



Source: [https:// www.packagingnews.co.uk/ features/ spotlight-on-corrugated-packaging-in-2017-06-01-2017](https://www.packagingnews.co.uk/features/spotlight-on-corrugated-packaging-in-2017-06-01-2017)

This opportunity is one that hasn't escaped the attention of Barnetson who thinks e-commerce packs will change significantly over the coming years.

"Where else can you put attractive printing for home delivery packaging? So you might take a box that's brown or has a basic black ink on the outside and then, when you get the box home, you get the 'wow' factor when you open it up with the opportunity to print additional information or personalisation on the side of the packaging. This is a new opportunity for corrugated and we need to tap on that opportunity."

The Brexit challenge

While there are plenty of growth opportunities for the corrugated sector to tap into going forward there are also significant challenges ahead. The longer term impact of Brexit remains unknown, but in the short term the fall in the value of sterling caused by the EU referendum has had a knock on effect, says Freeman.

"The Brexit vote had an immediate impact on the industry, as the value of the pound versus the euro put pressure on not only the supply of raw materials (paper), but also on the cost of buying new machines from European manufacturers," he explains.

Mockett adds that there is still plenty of room for optimism despite the uncertainty caused by the UK's future Brexit plans – especially given the fact that corrugated tends to be made within reasonably close proximity of its customers as there's "no sense in shipping air".

"As the UK economy has performed better than most G7 economies since the Brexit vote, the UK corrugated industry should not be on the rocks," believes Mockett. "As UK exports are cheaper priced in foreign currency terms the industry may experience a boost from packing up the products being exported."

It's an optimism shared by Freeman. "Our business has been good this year, showing growth in terms of volume. Like all corrugated players, there continues to be pressure on the margins, but relative stability in paper prices over the last 12 months has helped us to steer a steady course."

In short, the corrugated sector may face lots of challenges in the months and years ahead, but it looks as if these hurdles are going to be more than offset by the growing number of untapped opportunities there are out there.



Shear LINE



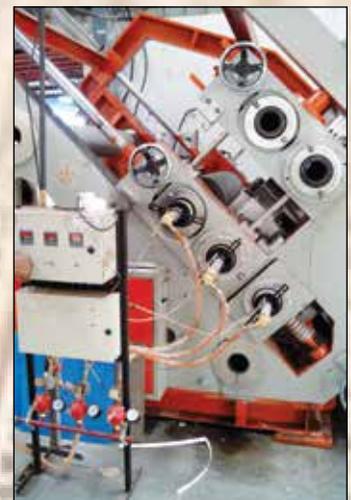
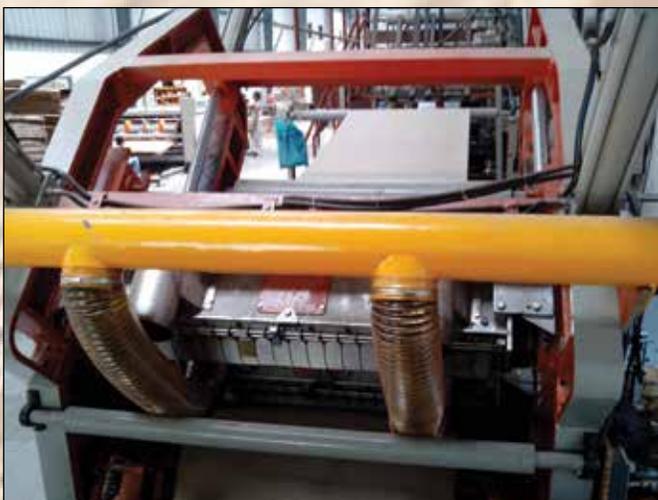
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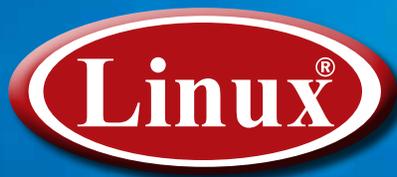
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The Packaging Waste Challenge for a new E-commerce World

Michael Zabaneh

E-commerce is accounting for an increasingly larger proportion of the retail sector and offers a high level of convenience in terms of being able to shop anywhere at any time. Yet one of the biggest challenges facing the online industry is packaging sustainability as waste from product distribution and sales shifts from retail stores to homes. This mega-trend was one of the key topics discussed at the SustPack 2017 Conference held a few weeks ago in Scottsdale, Arizona.



...both producers and online retailers will need to closely examine packaging material usage and waste throughout product life cycles.

Given the recent trends towards circular economy and sustainable materials management driven by regulatory, industry and consumer pressures, both producers and online retailers will need to closely examine packaging material usage and waste throughout product life cycles — from product packaging and design, to logistics methods, to end-of-life management. Meeting this challenge will need a holistic approach to product packaging means, including the use of recyclable or renewable materials and creating the right type and size of package for the product and its shipping environment.

The shift of waste concerns from physical stores to virtual stores

The e-commerce sales channel is witnessing continued growth and companies are preparing to account for its impact in their sales and changing consumer preferences. Companies are moving towards omni-channel distribution—the integration of both online and in-store consumer experiences. In the U.S. e-commerce grew by 23.7% in 2016 while retail sales overall grew only 6% (according to the U.S. Department of Commerce). In addition, e-commerce sales between 2014 and 2018 are expected to grow a cumulative of 88.4%. In 2016, global B2C e-commerce turnover reached \$2,671 billion with goods sold online comprising 7% of total retail of goods. This sales growth will mean more packaging waste shifting to homes. This shift will also mean a greater amount of

residential tonnage for municipalities and waste management service providers to account for.

It is believed that a greater percentage of packaging associated with these purchases, primarily old corrugated containers (OCC) and plastic, ends up in landfills. OCC, plastic, and various types of void fill are the materials most commonly used for e-commerce shipping packaging and for the larger parcel shipping industry. Products are handled on an average of five times in a traditional retail supply chain, while in the e-commerce network, products tend to be handled manually and may potentially be handled 20 times or more. Increased handling means greater potential for damages. Consequently, many producers have increased packaging to protect their products in shipping. But this is not the only solution, and certainly not the most sustainable one.

Amazon driving “right sized packaging”

On the side of e-commerce retailers, Amazon, the World's largest online retailer, has recognized this growing trend and has taken action to optimize packaging design for e-commerce. One of the key issues that e-commerce companies experience is that packaging designed to stand out and display well and protect against theft in the retail environment is not optimal for online fulfillment. The classical retail oriented packaging is oversized, expensive and unsustainable.



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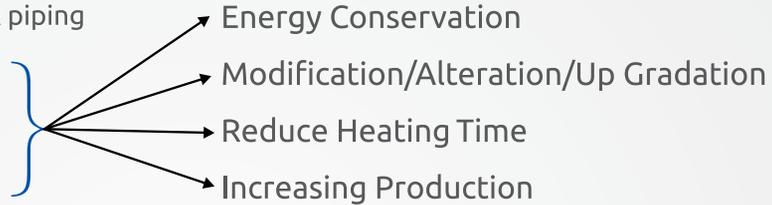
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Packaging that was designed to stand out and protect against theft in the retail environment is oversized, expensive and highly unsustainable for a changing world.

With a large proportion of packaging waste beginning to shift from retailers to homes, the company is tackling this mega-trend with the development of right-sized and tailor made packaging. The “frustration-free packaging” criteria is part of the Amazon Packaging Certification Program and in 2016, collectively eliminated nearly 83 million corrugated boxes. Amazon is using their Certification Program to engage and educate industry on the benefits of more sustainable and “right-sized” packaging including reduced environmental impact, reduced damages and minimized costs throughout the supply chain, and customer satisfaction.

Dell Case Study: Sustainable material use in packaging

On the side of producers, Dell has taken advantage of the Internet to develop its distribution and sales strategy around online sales platform. The company decided to reduce wasteful packaging after hearing complaints from customers about excessive and non-recyclable shipping boxes and packaging materials back in 2008.

The company reduced its box sizes by about 10%, developed bamboo cushioning—a fast-growing material that can be composted or



recycled as paper – to replace foam, and also began making packaging with wheat straw, which is produced from agricultural waste and mushrooms, in collaboration with Ecovative, a New York-based company aiming to replace plastic foam with materials made from mycelium, or mushroom roots. The bamboo and wheat straw materials eliminated 20m pounds of packaging and saved around \$18m in reduced energy, water, transportation and production costs. At the same time, greenhouse gas emissions fell by an estimated 8%. By 2020, Dell plans to scale these efforts up to 100% sustainable packaging.

In an evolving retail marketplace, companies will need to consider a lifecycle approach in terms of designing product and packaging to meet varying requirements of online and offline retailers, growing customer preferences and a changing

regulatory landscape. Both online retailers and producers will need to work together amidst this changing landscape and take a close look at their products, packaging materials, processes, logistics and end of life management in order to drive material efficiencies and reduced greenhouse gas emissions.

Source : Internet



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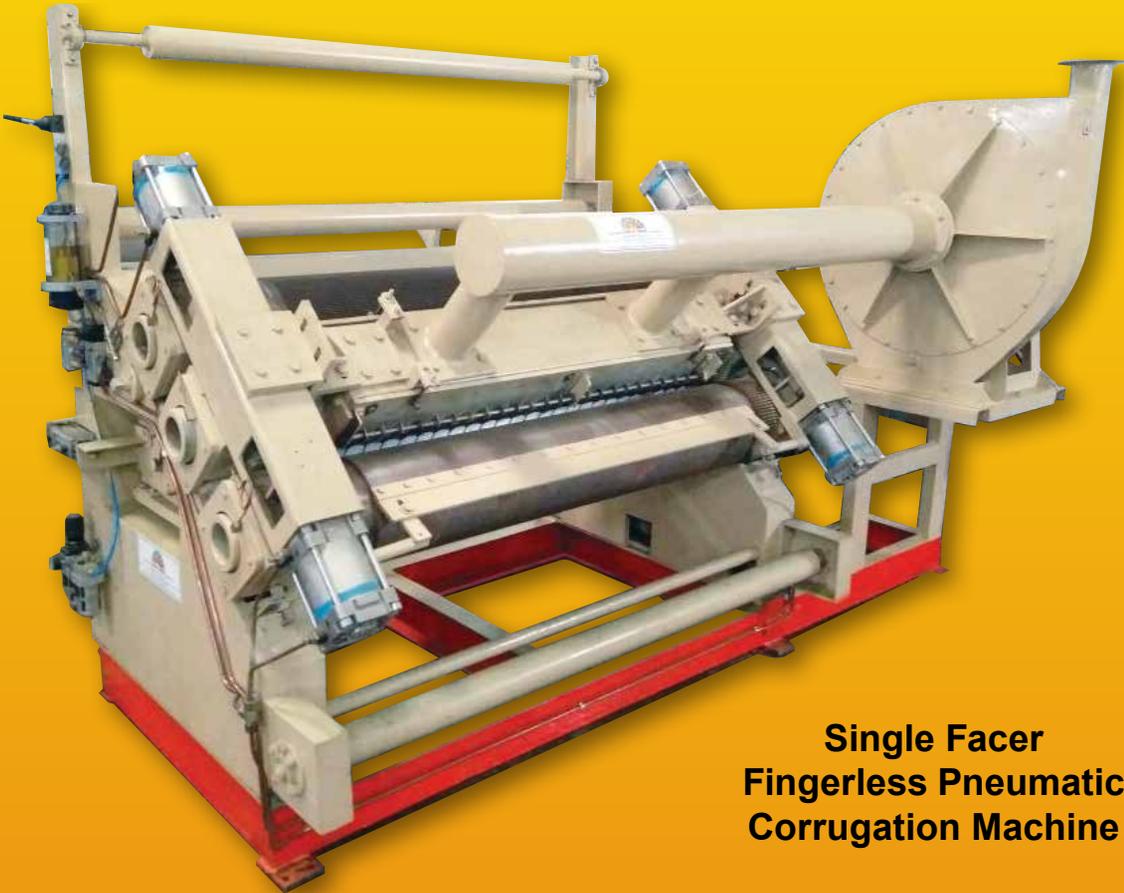
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M/C Dimension	2,800 x 12,000 mm	3,100 x 13,000 mm	3,500 x 13,000 mm
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Product Profile

Fresh fruit delivered at home

As consumers increasingly shop on-line, retailers are coming up with ways to deliver fresh food quickly and efficiently so that the produce remains fresh without getting damaged underway.

The retailer Carrefour had this lightweight corrugated packaging specially designed for the purpose of packaging fresh fruits ordered on-line that will then be packed with the rest of the customer's purchase. There are 3 possible box sizes holding approximately 1kg, 750 g and 500 g of fruit.

The on-line orders are prepared up to 24h in advance before being transported to the customer and will be in transit from the retailer to the customer for distances of under 30km. The corrugated permits a good ventilation of the products while they are in the stored in the cooling chamber, avoiding moisture and so keeping the fruit in good condition. In the box, the fruit is in direct contact with the corrugated, which will protect it from damage during transport because of the unique cushioning effect corrugated provides. After use, the corrugated box can be re-used and/or recycled.

The packaging is a winner of the Worldstar Packaging Awards. More... <https://www.worldstar.org/winners/2017/food?page=1>



Clever corrugated cake box



This corrugated cake box is both an innovative and environmentally friendly way to package cakes for ease of use for consumers and retailers. The ergonomic design facilitates ease when extracting or replacing either the entire cake or one of the slices.

The barrier coating is water based and fully recyclable. The attractive box can be frozen and it has a good oil/moisture resistance as well as thermal insulation that is so important for keeping foods fresh at all times of the year.

The company producing the cake box sources the raw materials that include recycled fibres, from local suppliers.

The cake box is a winner of the Worldstar Packaging awards. <http://bit.ly/2sFYzwV>

NO NONOCARRIER in the glue for the corrugated boards

SRS does not sell or manufacture a No Carrier starch mixing system. Why?

When the No Carrier system was introduced and our partner Ringwood also started to manufacture these systems the positive arguments were:

- Viscosity control
- Stable viscosity
- Little splashing
- High speed
- Use of waste water

After some time the industry found out that there are also several limitations:

- Starch can only be corn starch and must be of good quality
- pH value of water (waste water) must be controlled since variation results in different gel points
- Low gel temperatures are not possible
- System supplier controls the recipes.

In most countries use of untreated waste water is not allowed or considered not acceptable. The viscosity measuring unit needs to function perfectly since it triggers steps in the program. Because of the limitations and sometimes poorly working viscosity meters (very sensitive to cleaning) other hybrid systems were developed. Systems like Minocar, Pristin etc.

With the introduction of the Hi-Shear mixing system, like the ones SRS supplies, and the possibility to quickly make batches

Contd. on - 83



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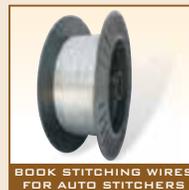
G.I. STITCHING WIRES



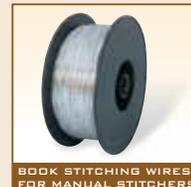
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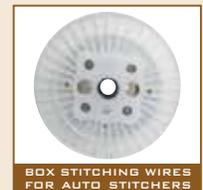
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BOOK STITCHING WIRES FOR MANUAL STITCHERS



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AS 027 - Semi Auto Gluer



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- 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
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- 5) Max Sheet Size: 2740 x 1515mm
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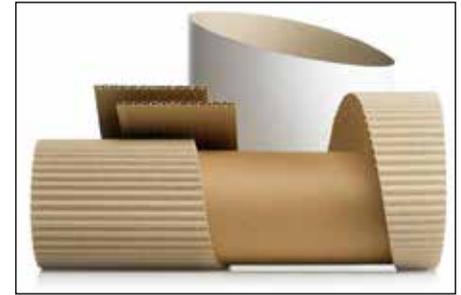
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For high speed or high size press paper, specially modified starch is used as carrier part to stabilize viscosity, improve bonding and setting time, and increase production speed.

SRS in China, and Ringwood in the USA, have, therefore decided that, although the initial

All of our products are made from recycled fibres and 100% recyclable.



Brown Liner Grades

The right product for every application

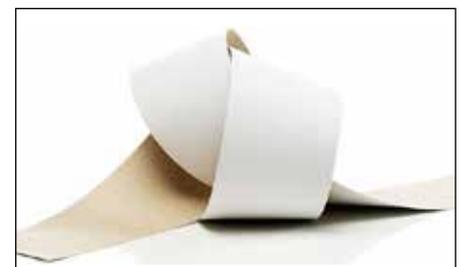
Today's applications require testliners that address a range of priorities. Suitable strength must combine with consistency, reliability and excellent printability - all in a cost effective solution. DS Smith Liners present exceptional attributes to meet these demands:



White Liner Grades

Devoted significant resources to successfully addressing the technical challenges of white top test liner production. The world-class clean and smooth sheets of White Liners are key for packaging solutions with attractive brightness and brilliant colours.

The Liner grades are suitable for the most innovative and challenging packaging designs.



of glue with different recipes dependent on where it was used, the proven Stein hall process became the preferred choice for most, if not all, boxplants in Europe and the USA.

- These new Hi-shear systems gave exact viscosities since the dosing of ingredients was done within tight limits.
- Viscosity stability because of Hi-Shear in the system rather than in the recirculation
- Low gel points possible
- All starches possible, corn, wheat, potato, tapioca, peas, cassava etc.
- User can easily change recipe
- High speeds, sometimes with additives
- Use of (treated) waste water

High performance plants worldwide have tried using the "new" No Carrier process and stopped doing so with a clear and convincing argument:

The required viscosity is indeed correct, however gelpoints, which we consider much more important, were all over the place and gave us serious problems in reaching maximum speeds.

Carrier-system offers the flexibility to adjust glue properties (viscosity, gel temp, rheological properties, and bonding) through carrier part.

arguments were positive for a No Carrier system, supplying these systems is not giving the results to the user that make long term sense. We also found that quite a number of systems are being used as Stein hall systems after all, while the software remains closed for users. This may make sense if the user wants the supplier of the system to be the only one that can change recipes and advise on which ingredients (additives) are necessary to make the system perform well.

The author, Peter Theel, founder and co owner of SRS, the maker of the High Shear, single tank, automatic glue kitchen used for making glue for the corrugated carton industry worldwide. With over 700 installations world wide, and a score plus in India, and with four decades of experience in the industry, including presenting papers in various forums, the comments by the author are from his personal experience of using various types of adhesives, and various types of starch to make the adhesives. He has been a regular visitor to India for over a decade.

Recycled Corrugated Case Materials by DS Smith

The corrugated case materials are supplied to the packaging industry for conversion into corrugated board and boxes.

The corrugated board consists of an outer liner paper and an inner liner paper, with medium / fluting paper in the middle.

Contd. on - 87

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- Drastic reduction in electricity consumption while corrugating smaller size paper widths.
- Zero blister formation at the edge of the fluting ensuring a high quality 2 ply output.
- Capital Savings by eliminating the need of buying different sizes of corrugation machines.
- Longer machine life and less wear & tear of rollers by avoiding unnecessary heating.
- Reduction in over all electricity load.

Tubular Heating System

- Electricity savings due to usage of Precision-wound resistance wire, sized by a computer program resulting in uniform heating
- Higher durability and longevity due to stainless steel sheath material frame
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1. Binder : It sticks or holds different layers of paper together to form a board.
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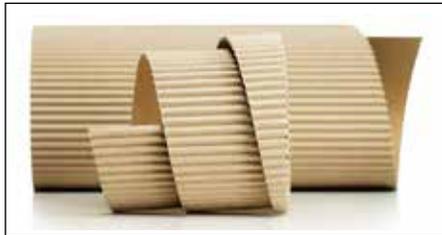
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Dual Use is a twin purpose paper that provides Liner 2 performance which can also be used as a medium. Born from a drive to reduce inventory, Dual Use can be used in combination or independently, delivering consistent results.



Dual Use grades perform well during both the corrugator and conversion process, meaning they can be utilised to their full potential in both sheet feeding and conventional printing sectors. Dual Use is made from recycled fibres and is 100% recyclable which provides an effective and efficient switch from virgin fibre products. Available in a wide range of basis weights from 85 to 145gsm.

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

STELDA AR500

HC500AR Case Sealer

Welbound HC500 AR is the fastest, Fully Automatic Random Case sealer employing hotmelt glue for sealing shipper cartons. Boxes of different sizes, coming in from multiple production lines are channelized into the HC500AR case sealer, thereby saving space, investments and labour. The machine will measure the case dimensions and adjust the settings automatically. Based on the programs that can be stored, even the gluing pattern is picked based on the box specifications including the weight.

The machine is manufactured by Mumbai Based Company Impel Services P. Ltd.

Salient Features

- Fully automated with no manual intervention
- Built as per international safety standards
- PLC Controlled with facility for storage of number of programs based on varying case sizes and weights
- Automatic centralizing system; measurement of all dimensions prior to entry of the box into the machine
- Height and width adjustments through pneumatics – rugged and easy to maintain
- Product counter and totalizer (with password access)
- Jam detection
- Production information system
- Power saving mode.

- Possibility to fine-tune the start and stop flap closing device
- Electrical requirement 4Kw- 3 Phase 440V 50Hz
- Air consumption 10 litre per case (approximately 5.5 CFM)
- Air pressure 6 bar
- Speed 13-15 cases per minute
- Can be also programmed to run in preset mode with higher speeds
- Optional bar code reading system for machine make-ready

BOX DIMENSIONS

Maximum (L x W x H):
650 mm x 500 mm x 500 mm

Minimum (L x W x H):
200 mm x 200 mm x 200 mm

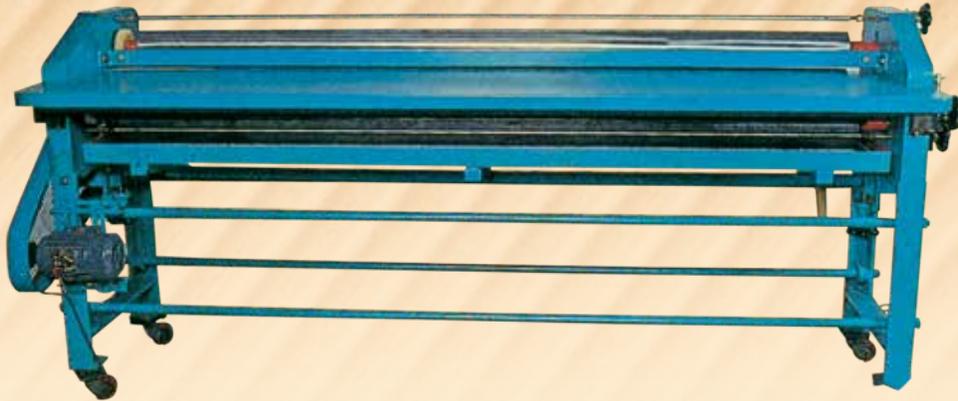
Impel Services P. Ltd is part of the Welbound group – a leading supplier of machines and solutions in South Asia. With the technical support of OEM partners like Nordson and Henkel we manufacture case sealing machines with multiple sealing technologies for markets requiring inline automation, flexibility and assurance of transit protection.

Impel manufactures case sealing and packing machines under the brand of STELDA® (acronym for Security Tamper Evidence and Low Damages in Transit). The current portfolio includes Preset and Random case sealers with options of Hot melt glue, Cold Glue and self-adhesive tapes. Case Erectors and Case Packers also come from the STELDA® family of machines. STELDA AR 500 is probably the most versatile and valuable case sealer available that stands out for its high end automation features made available with simple and robust engineering. The machines can support remote real time monitoring of the operations. As corporate members of OMAC and being part of OMAC technical advisory board, the company



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- Gum and pressure rollers can be set in microns as desired.
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Tel.: 22040083, 25823857, 25837517 TeleFax: 022-22871412

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

look forward to work closely with others for development of guidelines for machine automation.

In Interpack 2017, the automatic, all random STELDA AR500 Case sealer with multiple sealing options grabbed the attention of many. The Company is seeking the partnership of global technology leaders.

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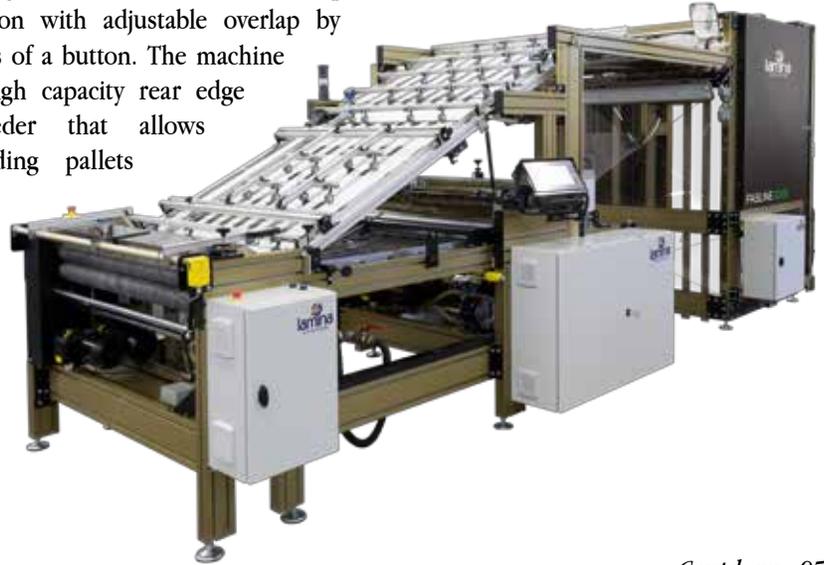
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FEEDER Suction cup picker top and non-stop belt for bottom.

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

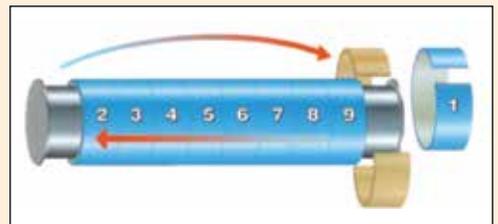


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MCFG Box Maker



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EDGE PROTECTOR MAKING MACHINE



SYKM-M FLEXP BOX MAKER
(VACUUM TRANSFER, TOP PRINTING/BOTTOM PRINTING)



SYKM-L FLEXP BOX MAKER
(STANDARD)

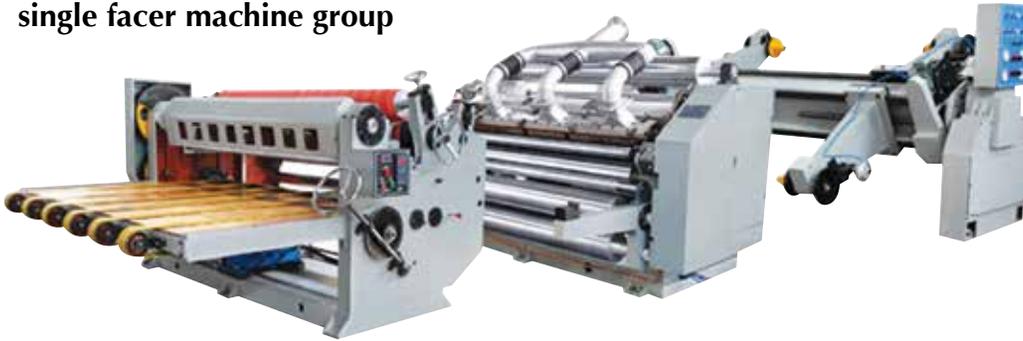


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- Platen punching Machines.
- Sheet pressing machine.
- Manual stitching machine.
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Semi Auto Flute Laminating Machine



Semi Auto Folder Gluer Machine



Semi auto box stitching machine
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Finger Type Single Facer



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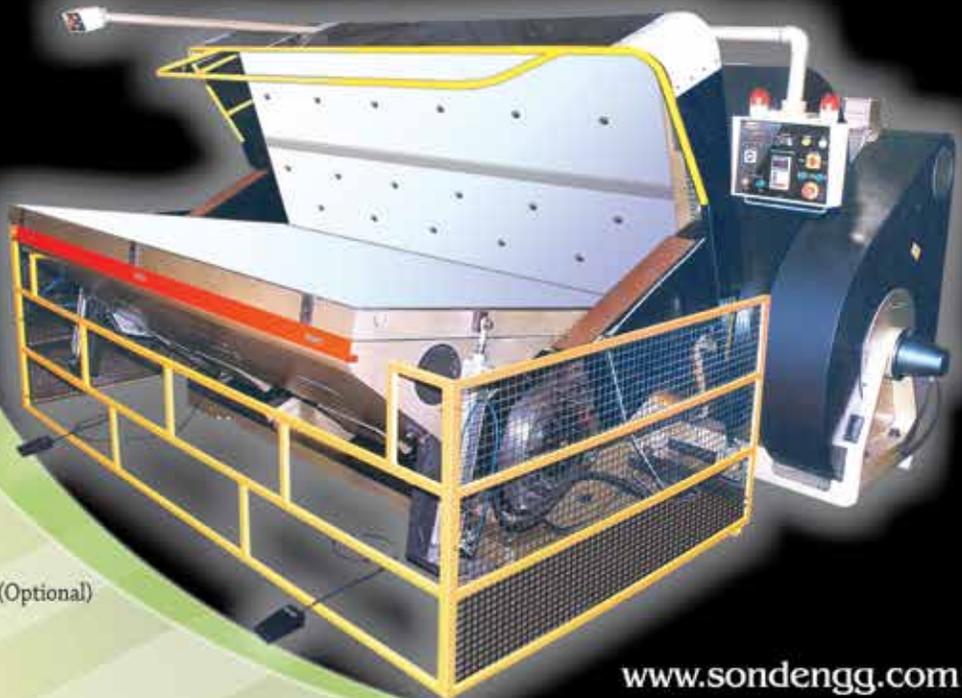
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A range of solutions offered by PACKSIZE

USA based company Packsize provides a wide range of corrugated box making machines designed to help your save time and increase productivity, while decreasing costs and carbon footprint. Here are some of their sustainable box making machine solutions.

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The right-sized flat box created by a Packsize machine includes a glue flap of varying types depending on the box design. Securing this glue flap is an essential part of the box-making process and is typically done with a hot melt adhesive.

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a seamless customer experience. This pneumatic-powered machine and PackNet. Server® production and optimization software, along with Packsize accessories and consumables, provides a complete sustainable packaging solution to companies requiring customized cartons and faster throughput.

The iQ Fusion 2® features a multi-patented horizontal outfeed and table that give a single operator the ability to transition from box creation to box induction without a significant increase in cycle time. This ergonomic enhancement also improves operator productivity.

In the more compact iQ3™, Packsize retains all-of-the best functions and features of the iQ Fusion 2®. The iQ3™ custom box-making machine gives retailers with real estate and others struggling to manage the increasing volume of online orders an effective ship-from-store strategy. The

iQ3™ can operate as a self-contained On Demand Packaging® system due to enhanced waste handling and the option to include an integrated air compressor.

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More Details <http://www.au.packsize.com>



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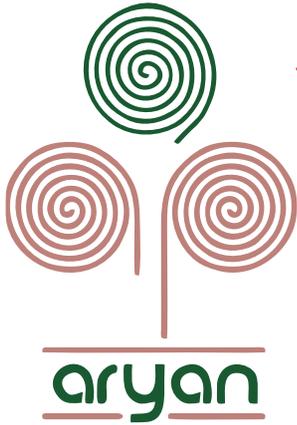


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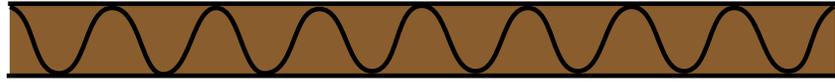
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A-Flute

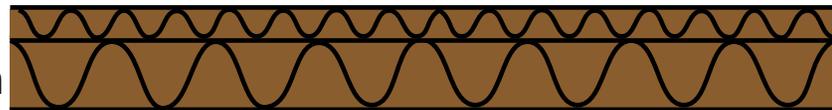


B-Flute



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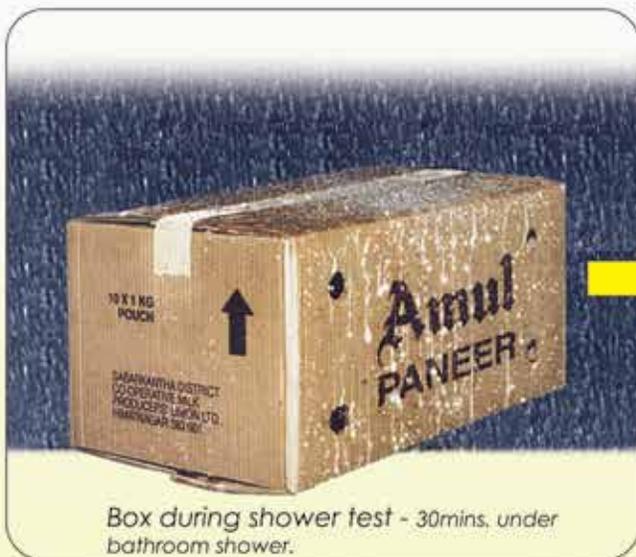
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		10	15	20	30
B/F	14.9	16.5	17.6	18.2	19.47
Cobb value	35.0	19.0	15.5	8.5	2.5
Gloss	18.36	18.26	18.17	18.2	18.28
GSM	147.5	148.5	149.0	149.5	149.5

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Smurfit Kappa reaches new milestone with 'Supply Smart' service

Smurfit Kappa's 'SupplySmart' service has reached 50,000 supply chains, taking optimisation of packaging to a new level. The industry-leading service uses evidence-based analytics and insights, to work with businesses to benchmark risk and optimise efficiency in their supply chain.

'SupplySmart' is the first service of its kind that combines big data from over 50,000 supply chains in over 30 countries with creative solutions, expert knowledge and years of practical experience. The service enables businesses to reduce logistics costs, streamline production and lower packaging costs without compromising on performance.

This large supply chain database, combined with an industry-leading research lab (certified by the International Safe Transit Association (ISTA)), means the cost optimisation solutions are scientifically proven and come with minimal risk to the customer.

Arco Berkenbosch, Vice President Innovation and Development, Smurfit Kappa, said: "Trial and error just simply isn't enough in today's business environment. Our customers need solutions that are state-of-the-art and proven. We've spent the last decade gathering data and analysing supply chains from well-known retailers to more challenging parcel deliveries.

'SupplySmart' is already being used 150 times a day for leading companies around the world to increase efficiency within their supply chain."

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

Vijayawada's carton maker JC Graphics bolsters die-cutting capacity

In a bid to boost its die-cutting capacity Vijayawada-based JC Graphics has invested in a MK Easymatrix 106 CS die-cutter. The equipment was supplied by Heidelberg India.

Karunakar and Dinakar of JC Graphics with the MK Easymatrix



Karunakar, managing director of JC Graphics, said, "With motorised cutting pressure adjustment for up to 260 tonnes, the Easymatrix 106CS performs die-cutting and embossing operations at a speed of 7,700 sheets per hour. We are impressed by its capability to handle substrates with thickness ranging from 0.1 mm to 2 mm and corrugated board up to 4mm without any changes in the feeder."

The machine boasts of non-stop rake delivery, which enables uninterrupted production during pile changes and a Quick-Lock system that ensures rapid and precise positioning of tools on the stripping frame thereby eliminating time-consuming, manual re-positioning of tools for each production run.

Established in 1990, JC Graphics caters to the packaging requirements of the food,



pharma and FMCG companies with marquee names like Godrej, Rickett Benkiser and JK Industries on its roster.

Over the last few years, the company has been consolidating its position in

the carton packaging space. In 2014, the company invested in a brand new Heidelberg CD 102 UV press that so as to manufacture specialised MetPET cartons. Then in the following year, the company shored up its post-press department with an investment in Bobst Expertfold folder-gluer and Wen Chyuan offline coater and MetPET lamination machine and H&H window patching machine.

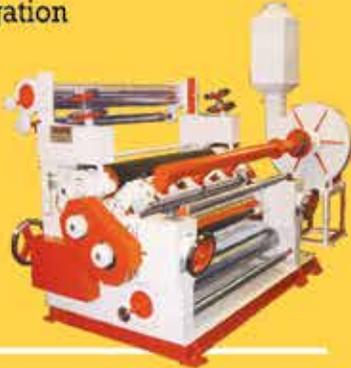
The same year JC Graphics was credited with an ISO 12647-2:2013 certification from Heidelberg. The company became the first and only Indian print firm with this certification, after the German manufacturer certified 150 print shops worldwide.

Source : www.printweek.in

Contd. on - 102

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Demystifying the inventory-led and marketplace e-commerce models

There have been so many changes in the Indian e-commerce industry since its beginnings in 1997. Today, Indian e-commerce has developed itself in many different areas. It was predicted that the e-commerce industry would grow to \$16 billion by the end of 2015, and this was a successful prediction.

The fact is that all the major changes of the industry took place in the period of the last five years.

Indian e-commerce is about to complete a successful 10 years. The inventory-led and marketplace e-commerce models are both major parts of the Indian e-commerce industry, but play different roles in the market. There are some differences in the functions and advantages of these models, and they, therefore, serve different purposes. The e-commerce industry has experienced many different changes. eBay was the first participant in this industry. Afterwards, Flipkart entered as a homegrown player and changed from inventory-led to a completely efficient marketplace model. Snapdeal shifted from an everyday deals site to an internet-based marketplace. The market would later also see the entrance of American e-commerce giant Amazon.

Difference between these two e-commerce models

The new FDI policy rules and regulations in the e-commerce market have permitted 100 percent FDI in the e-commerce marketplace model under the automatic route. However, no FDI is permitted in the inventory model.

Marketplace: A true e-commerce marketplace adheres to the standards and directions of a zero inventory model. Some classic examples are Naaptol, eBay and Shopclues. The e-commerce marketplace becomes a digital platform for consumers and merchants without warehousing the

products. Marketplaces do offer shipment, delivery and payment help to merchants by tying up with some selected logistics companies and financial institutions.

Inventory: Shopping websites where online buyers choose from among products owned by the online shopping company or shopping website take care of the whole process end-to-end, starting with product purchase, warehousing and ending with product dispatch..

In India, there is no doubt that being in complete control of the product (i.e. having physical warehousing or inventory) empowers a player in the space with an unrivaled post-purchase shopper experience. If you have the product in your complete control, then, supposing that your systems and procedures are robust, you: (i) have total transparency and visibility into your stock level, (ii) know where the product is physically placed, and (iii) control the picking, packing and shipping procedure. This implies that you minimise the probability of accepting the order at the time when you don't have the product. It additionally implies that you can streamline dispatch time. Being in control of the product empowers you to deliver quicker, with a higher level precision, and respond efficiently to client inquiries about delivery and shipping status.

What are these two models?

Ware House Show at Inventory led Model

Whenever an e-commerce organisation maintains its very own distribution centre to stock inventory and dispatch orders

straight to the customer's doorstep, it is called warehouse show or inventory-led.

When Flipkart started, its operations followed a warehouse model, with WS Retail playing a central role. Over time, they embraced the marketplace model to scale range and variety.

Market place Model

If an e-commerce organisation encourages a dealer to set up a store, display products, maintain stock and send orders directly to clients, it follows the marketplace model. The platform facilitator (the e-commerce organisation) charges a commission on orders (running from 5 to 30 percent on the basis of class and category) from merchants. Popular e-commerce organisations like Amazon, Flipkart and Snapdeal follow the marketplace model.



Pros and cons

Inventory-led Model

Pros –

- Speedier delivery
- Better quality control
- Best customer experience and trust

Cons –

- Difficult to scale (but not impossible)
- High fixed costs
- Restricted cash flow

Marketplace Model

Pros –

- Highly scalable
- Investor-friendly
- Wide product portfolio
- Large number of sellers

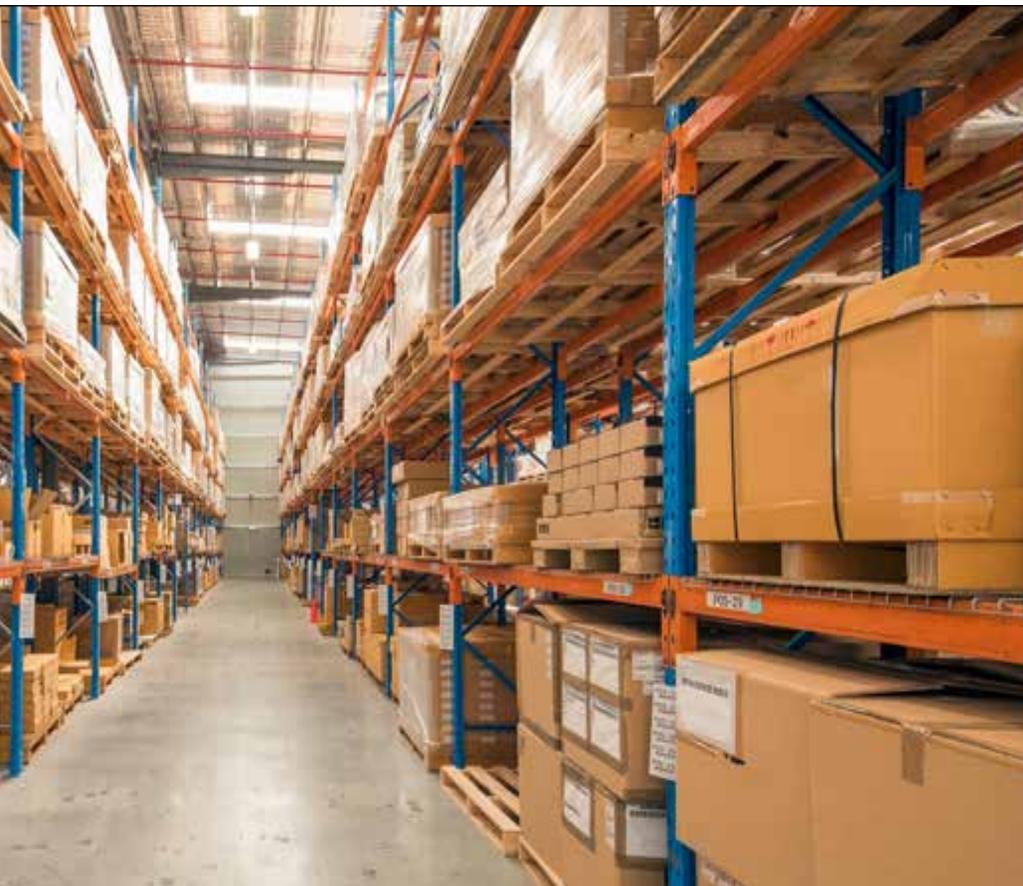
Cons –

- Difficult to conduct quality checks
- Shipping costs are higher
- Difficult to build customer trust and loyalty

Which e-commerce model works best in India?

When we talk about India, we see that a huge part of the population has low trust in the internet. Usually, the marketplace model is very costly and troublesome. The market-based stock model usually grasps the quality of customary physical models, with minimised exposure to the hazards of sourcing and warehousing. Substantial scale stock and high productivity don't appear to go together.

For instance, for a 30 percent gross edge business, the working costs stretch to around 45-50 percent. Marketplace pioneers, like Myntra, Amazon and Flipkart, are working in the marketplace space for extra customers, expanded benefits and reduced inventory-based glitches.



The e-commerce market initially followed the inventory model. However, due to the current Indian FDI laws, Flipkart and Amazon are moving towards the hybrid model, practically being marketplaces while still having a stake in large sellers on their platforms. This model is being seen as a “beyond any doubt approach” to profitability, as there is less capital requirement. It also gives the right level of control towards client experience.

Experienced experts, who have been watching the development of the e-commerce market in India and keeping a tab on the foreign e-commerce marketplace model, deduce that the e-commerce business in India is gradually moving to the marketplace-led model from the inventory-led model.

Source: - Internet

Contd. on - 107



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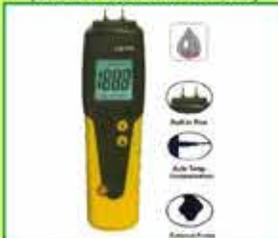
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Corrugated industry makes strides in reducing environmental impact

A new life-cycle assessment from the Corrugated Packaging Alliance notes advancements made between 2006 and 2014 in GHG reduction, recovery rates, water usage, and more.

The Corrugated Packaging Alliance has released a new U.S. corrugated industry life-cycle assessment (LCA), which shows the corrugated industry's environmental progress.

"The LCA results demonstrate the efforts our mills and converting facilities are making to reduce the industry's supply chain impact on the environment," says CPA Executive Director Dennis Colley. "Sustainable forest procurement, along with the high old corrugated containers [OCC] recovery rate provide for a well-balanced system of fiber and supports the sustainability of our industry's products."

The LCA examined the effects of a 1-kg industry-average corrugated product manufactured in 2014 on seven environmental impact indicators, including global warming potential (greenhouse gas emissions), eutrophication, acidification, smog, ozone depletion, respiratory effects, and fossil fuel depletion, and four inventory indicators, including water use, water consumption, renewable energy demand, and non-renewable energy demand.

The corrugated industry reduced its GHG emissions by 35% between 2006 and 2014. The reduction was driven by increased OCC recovery and use of energy generated

from renewable, carbon-neutral biomass and decreased overall use of fossil fuels.

The recovery rate for OCC increased from 72% in 2006 to 89.5% in 2014. As more is recovered, less goes to landfill, thereby reducing methane emissions.

Other notable improvements between 2006 and 2014 include a 29% reduction in the effects of nutrient releases on receiving waters and soils (eutrophication); a 23% reduction in photo-chemical ozone creation; a 21% reduction in water use; and a 21% reduction in respiratory related effects.

The peer-reviewed study, commissioned by the CPA and conducted by the National Council for Air and Stream Improvement is the third study in a series of industry LCAs. It was conducted in accordance with ISO 14040/44 standards and guidelines for life-cycle assessment studies.

Source: <https://www.packworld.com>

Europe's Corrugated-Packaging Industry Set For Consolidation

The European corrugated-packaging industry is expected to enter a period of consolidation, according to recent research from Rabobank.

Some ten mergers and acquisitions have been announced between January and June 2017, and around 110 notable deals have taken place in the sector since 2010, which, the bank says, has been prompted by "slim margins and firms' need for a wider geographical presence".

It expects that European producers will continue to look for opportunities overseas, such as DS Smith's recent acquisition of Interstate Resources in the US.

"The European market has witnessed some notable M&A deals in recent years, but we expect more in the future, as firms respond to headwinds in what is still a very fragmented sector," said Natasha Valeeva, supply-chain analyst at Rabobank.



"We don't, however, expect this consolidation to happen quite as quickly as in the US. The rate of M&A is being slowed by factors such as high valuations and family-owned companies not ready to sell yet."

Future Trends

The five largest corrugated-packaging producers – Smurfit Kappa, DS Smith, Saica, Mondi and Prinzhorn – only hold about a third of the market share in Europe.

Rabobank notes that the market is far more fragmented among its competitors, with roughly 46% of the sector supplied by producers that have less than 2% market share, and so there is scope for further consolidation in the future.

"As market trends, such as environmental footprint, sustainability, access to recycled material, and food safety make it more difficult for smaller players to cope with growing investment necessities, it is inevitable that further market consolidation will happen," said Tjard Westbroek, global sector head of supply chains at Rabobank.

"Over the coming years, we expect smaller producers to be acquired by the bigger players, especially if they're based across key customer locations on the Continent. We think the key aim for larger companies is to be strategic in their locations, making sure they're able to benefit from economies of scale and avoid unnecessary transportation costs," Westbroek added.

Source: www.esmmagazine.com

Contd. on - 111





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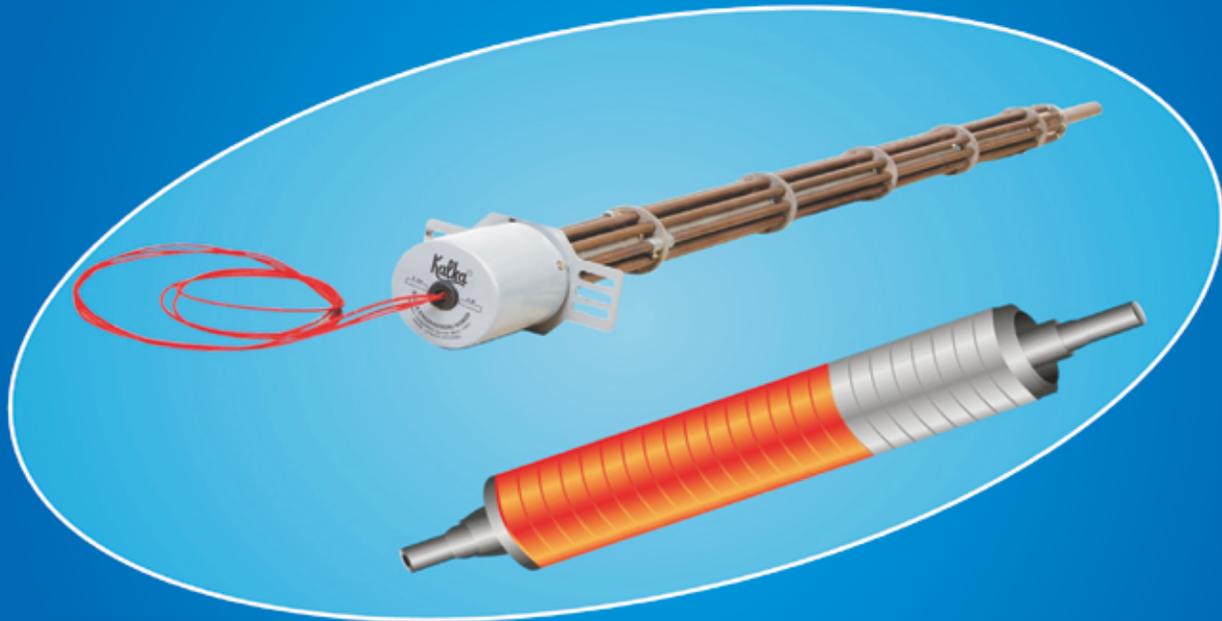
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Reduce wear and tear of machine by avoiding unnecessary heat.

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Tube used are SS 304/ Incoly tube

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DS Smith releases film exploring closed loop of corrugated recycling

DS Smith has released a short film showing the journey of recycled paper fibre around the Supply Cycle of its Packaging, Recycling and Paper Divisions. 'Box to Box in 14 Days' follows the two-week journey of a corrugated box as it's made, used, collected, recycled and manufactured again through DS Smith's packaging, recycling and papermaking operations.

in getting customer products visible and accessible on retailer shelves. Following a box on this journey, the film looks at how fibre is collected, recycled and manufactured into new packaging products. We are proud to be one of Europe's leading paper and corrugated manufacturers, managing over five million tonnes of recycling every year. 'Box to Box in 14 Days' is the story of how we do that. Using some clever filming techniques, the viewer can actually look inside the paper machines that recycle the fibre. The film brings Closed Loop



In demonstrating its closed loop model, the film embodies the company's reputation as a leading supplier of sustainable packaging solutions. By managing over five million tonnes of fibre for recycling across Europe every year, DS Smith prevents around 360,000 trees* from being cut down. 'Box to Box in 14 Days' shows how.

The video was filmed at a number of locations, including a DS Smith recycling facility, paper mill, packaging plant, design studio, and on both Retailer and FMCG customer sites.

Tim Price, Marketing Director of DS Smith's Paper and Recycling Divisions, said, "The film of 'Box to Box in 14 Days' allows us to demonstrate the DS Smith Supply Cycle, from the point that packaging is designed, through to its use

Recycling to life, and is a great way of engaging our colleagues, customers and wider stakeholders in the part they play in this great story."

Vanessa van Dongen, Marketing Director of DS Smith Packaging Europe, said, "DS Smith is a leading supplier of sustainable packaging solutions, so we are delighted to be able to show how our packaging is designed, produced, brings value to our customers and recycled into more boxes. Throughout our Supply Cycle, from design through to recycling, we provide sustainable solutions for our business, our customers and our environment."

<http://www.thepackagingportal.com>

Thimm Display wins two POPAI Gold and Bronze Awards

04.07.2017 Thimm Display wins two awards at the POPAI D-A-CH Awards Ceremony 2017. The displays won gold and bronze awards in the "Beauty, Fragrance" and "Food, Convenience Products and Confectionery" categories. Both solutions reflect the high level of expertise in the development and production of display stands.



POPAI (Point of Purchase Advertising International) D-A-CH Award 2017: Two awards for THIMM Display

Gold Winner: "False Lash Epic Mascara" stand display

Thimm Display developed a floor-standing display for the product launch of the new 3-zone mascara brush from Max Factor. The colour, design and finish of this floor-standing display create a direct connection to the glamorous mascara. The focus of the display is the innovative mascara brush with all its associated information. The over-sized golden mascara made out of coated cardboard film reflects the high value of the Max Factor brand. A high-gloss UV coating finish is used. The actual sales surface itself is positioned in the very centre with the products presented on two levels. The display is an effective support to a luxuriously designed campaign.



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Higher Bulk With Lower Raw Material Usage: Voith's EcoCal Plus Reduces Production Costs In Board Manufacturing

With the new EcoCal Plus calender, Voith is ensuring that papermakers can produce high-grade board products with high stability and lower basis weight. The special thermal smoothing of the EcoCal Plus allows raw material savings of up to 3.5 percent. In addition, the process results in an improved surface structure of the paper.

The demand for board grades with maximum possible bulk has been growing steadily over the last few years. With lightweight and stable board products, significant cost savings can be achieved for example in the mail-order business. At the same time, board packaging products are increasingly important for advertising of consumer goods by focusing attention on the package contents which indirectly support its sales. Good printability and surface quality are just as important as stability and low weight. Both properties are positively influenced by the EcoCal Plus calender.

For the production of these board grades, the manufacturers usually use high fresh fiber content. Secondary fibers are only added in some cases. Lower basis weights and maintaining or improving board properties are therefore crucial for lowering resource consumption and production costs on the manufacturer side.

The new Voith EcoCal Plus calender is ensuring that papermakers can produce high-grade board products with high stability but with low raw material use. It can be integrated into existing plants as part of an upgrade.

Thermal smoothing key to paper quality The hard nip calender plays a decisive role in the manufacturing of high-quality, stable board with low basis weight. It smoothes the paper surface and gives the board a uniform surface. This is where Voith's EcoCal Plus comes in. The machine calender used for pre-calendering makes use of the fact that surfaces can be smoothed more easily when moisturized and warm. Voith thus equipped the EcoCal Plus with an external induction-heated system that additionally heats the thermo roll to a temperature of up to 260°C. This is considerably higher than the temperatures of conventional systems with 200°C. The EcoCal Plus also has an additional nozzle moisturizer for intensifying the bulk-preserving smoothing effect by regulating the paper web temperature.

More bulk and better surface structure With thermal smoothing, less mechanical force must be applied to the paper web. As a result, the bulk loss is much lower than with conventional calendering. Paper smoothed with the EcoCal Plus thus has a higher specific volume. The process has another advantage: through the optimum interplay between temperature, moisture, and line load, the board surface structure is optimized. This is especially important for the packaging of high-grade foodstuffs,

cosmetics, electronics, and medical products. The uniform surface and the higher stiffness greatly ease the tasks of board finishing and printing.

Cost savings through lower fiber consumption The moisture and temperature gradients used in calendering with the EcoCal Plus require only a negligible amount of additional energy. However, this is more than balanced by the economic advantages

offered by the EcoCal Plus. The EcoCal Plus technology allows papermakers to reduce their fiber consumption. This saving greatly improves the cost efficiency of the plant: an annual production of 500,000 tonnes with a one-percent saving in raw materials use translates into savings of around 250,000 euros per month for the manufacturer. In practice, the savings potential is much higher: EcoCal Plus calenders have been in operation since 2011 and have achieved bulk savings of up to 3.5% due to the uniqueness of the technology. Thus, the break-even point for investment in the technology can be reached after half a year, depending on the machine size. Alternatively, with the EcoCal Plus, lower-cost raw materials can be used to achieve the same board quality, which also drastically lowers production costs.

The EcoCal Plus calender can be integrated into existing plants as an upgrade. Especially practical is the ability of the calender to be installed in a short period of time during a planned shutdown. In new plants the technology provides great efficiency right from the start.

Voith Paper is a group division of Voith and is one of the leading partners and pioneers in the paper industry. Through constant innovations, Voith Paper is optimizing the paper manufacturing process, focusing on developing resource-saving products to reduce the use of energy, water and fibers. Furthermore, Voith Paper offers a broad service portfolio for all sections of the paper manufacturing process.

For 150 years, Voith's technologies have been inspiring customers, business partners and employees around the world. Founded in 1867, Voith today has around 19,000 employees, sales of 4.3 billion and locations in more than 60 countries worldwide and is thus one of the largest family-owned companies in Europe. Being a technology leader, Voith sets standards in the markets of energy, oil & gas, paper, raw materials and transport & automotive.

Source: <http://www.pulp-paperworld.com>





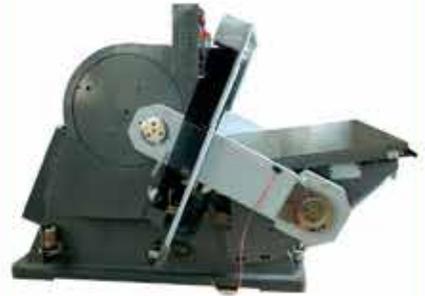
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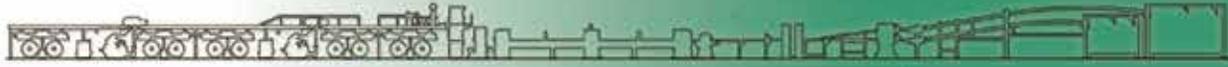
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- Tensile Strength
- Rub Proofness
- Tear Strength
- Stiffness Strength
- Caliper Thickness
- Drop Resistance
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Super Model



Micro Print Model



Clamp N Print Model



Double Head Model

Bursting Strength Testers

Bursting Strength is a widely used measure of resistance to rupture in various packaging materials like Paper, Paperboard, Corrugated board, Nonwovens, Textiles, Geotextiles, Films, Tissues etc.

Models :

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



GSM (Substance) Tester

Electronic model with 5 sample size measurement



Equinox Moisture Meter

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



Compression Tester



Winner of Pacmachine 2008 Award

Four Models :

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

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

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



Tensile Tester

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



Tear Tester

Measures the force required to tear multiple sheets of paper



Puncture Resistance Tester

Five different scales to analyze materials of variable thickness.



Cobb Tester

Determining water absorptiveness of papers, boards etc.



Crush Tester

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

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

Winner of Pacmachine 2006 Award



Rub Tester

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



Sutherland Ink Rub Tester (Micro Digital)

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



Short Span Compression Tester (Sct Tester)

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

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Forthcoming Events

16 - 18 October 2017



TAPPI CorrExpo 2017

Rhode Island Convention Center and Omni Hotel, in Providence, RI, USA.

Gathered together in one easily accessible location, you can visit many different suppliers without incurring multiple trips and associated costs. At the same time, you'll also see many new industry products and innovations designed to help you – and your teams – do your jobs better.

Great learning opportunities with the technical sessions, panel discussions and pre-conference workshops where you can earn CEU credits, too.

Networking: Meeting and interacting with peers and other industry experts remains one of the top reasons attendees flock to CorrExpo.

11 - 13 October 2017



A conference and trade show for the European Corrugated industry

The Seminar will bring together buyers and suppliers of Corrugated packaging machinery & systems from all Europe and beyond:

Reed Messe Wien, Messeplatz 1, PF 277, A-1020 Wien (Austria) - www.messecongress.at

17 - 19 October 2017

ICCA AND WCO – 2017 SUMMIT

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

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

26-28 October 2017



Pragati Maidan, New Delhi / India

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

46th Conference of Federation of Corrugated Box Manufacturers of India

17-19, November 2017 - JW Marriott Hotel, Pune, INDIA



FCBM Conference is an annual event of great importance to the Corrugated Packaging Industry where every one connected with Corrugated Packaging Industry congregate and exchange ideas by interacting with each other, besides getting an opportunity to listen to celebrated experts in the field. It is also an occasion that strengthens fraternity and fellowship. The Technical Sessions will be structured on the Conference Theme and experts from world over, who are authorities in their fields, will throw light on various issues concerning the industry. The deliberations, interaction and discussions will surely help us to take our manufacturing and management processes to meet the expectations of the 'Emerging New India'.

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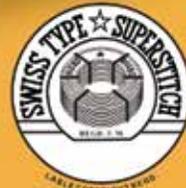
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