

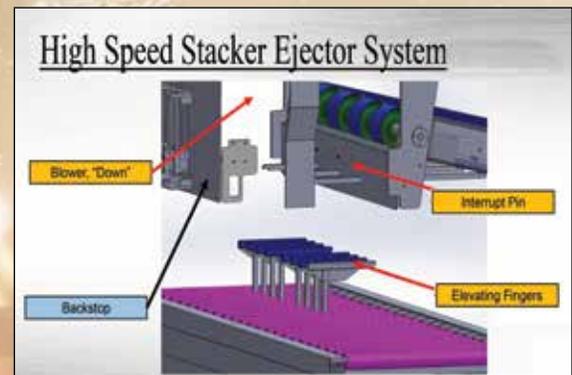
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The Corrugator

OFFICIAL MAGAZINE OF FEDERATION OF CORRUGATED BOX MANUFACTURERS OF INDIA

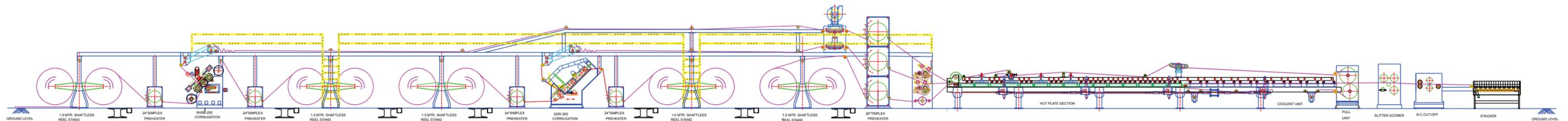
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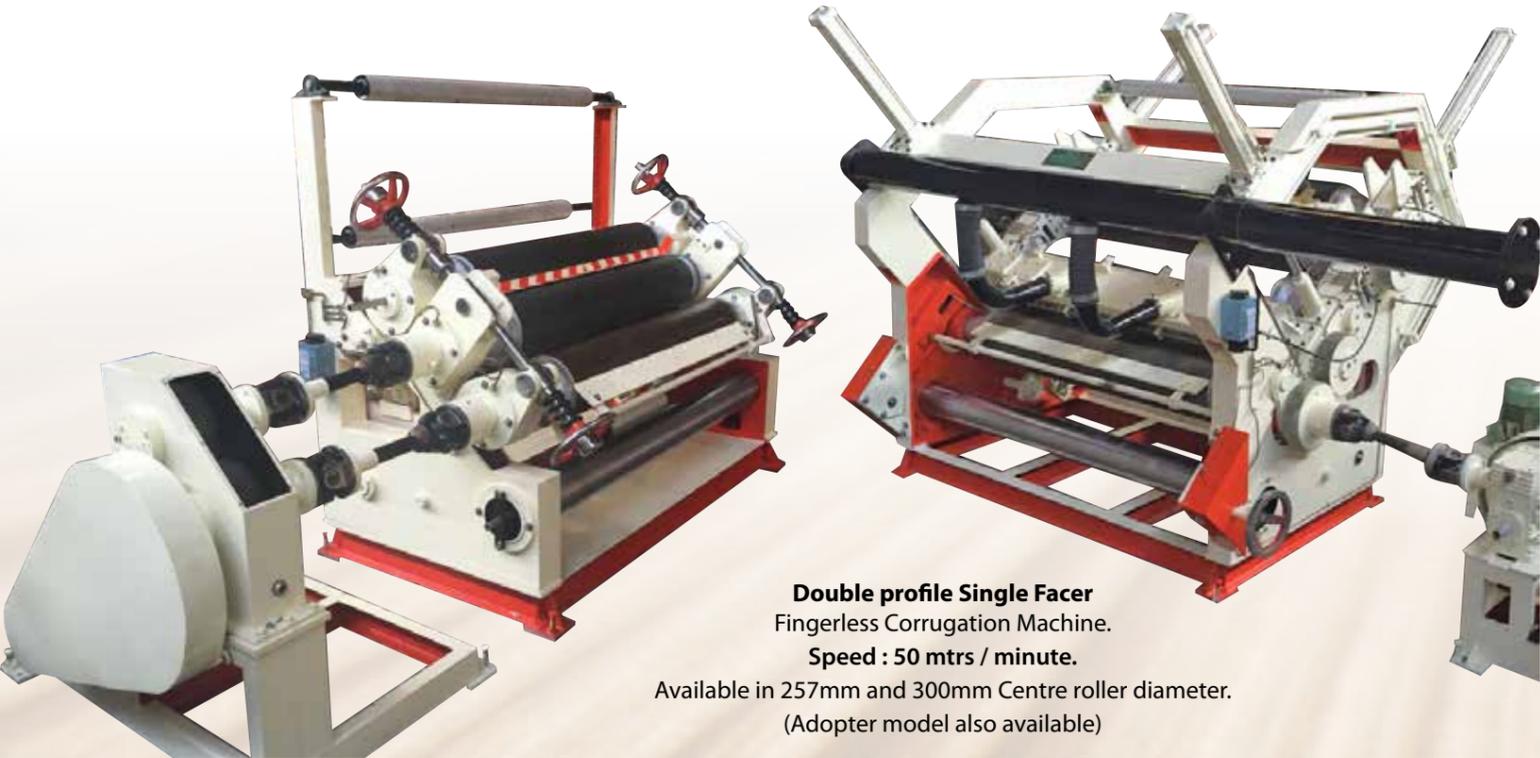
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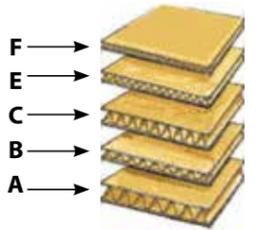
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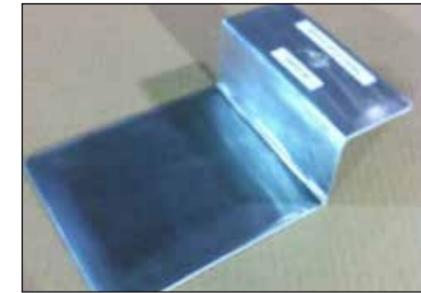
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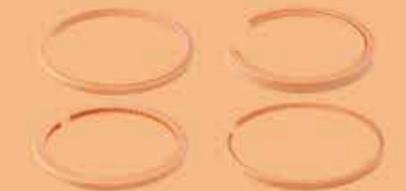
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The Indian economy remained the world's fastest growing major economy in the July-September quarter rising on the back of healthy growth in agriculture but the outlook in the quarters ahead is clouded by the impact of the government's demonetization move.

An atmosphere of uncertainty is seen all over the country. The excitement of demonetization has settled down to shrinking businesses, lack of liquidity and fear of a long period of recession. While the step taken by the Central Government is laudable, the learned view of economists casts a gloom over possible consequences.

However, on a positive note, the withdrawal of high-denomination currency notes will provide the headroom for a policy stimulus to the Indian economy in the next budget. The lower inflation following monetary contraction will pave the way for a rate cut, while the additional revenue to the government will create the headroom for a large investment stimulus.

We can look forward to these signs with hope.

The last quarter of the year has been a fairly active one for FCBM and its regional associations. EICMA organized a visit to Eco Tech Paper Mill; SICMA had organized a 2 day seminar in September 2016; Kerala

had a Seminar on 9th November 2016; WICMA organized their Annual Symposium at Daman.

These are featured under FCBM News. We are sure the momentum will continue in the following quarter.

The 45th FCBM conference was a 'Himalayan' Success by all counts.

We congratulate Team HPCBMA for organizing such a grand event in such difficult times. This issue has complete coverage of the Conference.

We do hope the Team FCBM New under the dynamic leadership of Mr. Greesh Sardana will take our Federation to even greater heights in 2017.

While all industries are bracing for a future of uncertainty with growth expected to dip in the next 2 quarters, our industry seen to be in a more optimistic position. Once the money position assumes normalcy, normal consumer spending is expected to accelerate thereby creating need for more packaging.

Packaging will continue to play a vital role in stimulatory economy. Today the consumer demands packed goods and the demand for packed goods will continue to increase as the technology brings more and more products to make life easier.

All packed goods and all farm produce need to be transported from point of production to point of consumption. Apples from Kashmir need to reach Kanyakumari and spices from Kochi have a market in Uttarakhand. And then mangoes from Ratnagiri are to be exported to Middle East. In a country like ours, where the roads are bad and distances are long – it is necessary to make boxes, designed to take the rigors of transportation.

It is here that Corrugated Packaging plays a vital note as a key player in this Complex Supply Chain Movement.

We need to explore and benefit from this growing need for boxes. We need to upgrade design and make boxes that can take the rigors of the supply chain as well as protect the products in their pristine condition.

The GST which was expected to be rolling out in April may get delayed. However, by 16th September it is set to be in place constitutionally.

Once the GST is in place the stimulus for growth will strengthen further and bring in a healthy overall growth in industry and business.

So let us all look forward to a happy, hi-growth year of 2017.

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PRESIDENT'S MESSAGE



N. X. George

Dear Friends,

As they say 'All good things have to come to an end'.

The wonderful interaction I had as President of our Federation, with you all has come to an end, when I handed over the reins of FCBM to my worthy successor Mr. Greesh Sardana.

During my tenure, I had focused on evolving FCBM into a highly respected and recognizable industry association at an international level. I can say with confidence we have succeeded to some extent. Recognition of FCBM by ICCA, TAPPI and FEFCA is a something to rejoice.

Added to that, our magazine The Corrugator was invited to be Media Partner at Super Corr Expo – the largest corrugated show in the Western Hemisphere. I attended Super Corr Expo along with a few other members.

I am sure the new President will continue to develop closer relations and interact well with these international peers to keep the flag of FCBM flying high.

Packaging Industry in India is growing at around 12%. Corrugated Box Industry is growing at a higher rate due to penetration of corrugated box in new areas like horticulture and vegetables

At the moment the Corrugated Industry faces sluggish market conditions. It is due to the fall in exports from India. Lack of expected growth in certain sectors of industry has also affected the demand for corrugated. The situation will definitely improve for the better in the future.

Corrugated box is so universal and simple that nobody give much importance to it. The fact is people and the economy as such fails to notice the importance of corrugated box. The entire products of daily use from morning tooth paste to the bed time medicine reaches every person in corrugated boxes. The entire present logistics is based, to a great extent, on corrugated boxes. Modern world can not function without corrugated boxes. Corrugated Box Manufacturers are a key economic factor to India's and world economy.

The year 2016 is ending with a lot of changes – on the financial front. Let us hope the rumblings will settle down and a calm, inspiring atmosphere will set in by early 2017. This is necessary for the growth we all want to see.

I feel gratified that I had a very satisfying and memorable experience working with you all and leading FCBM to a higher level of excellence.

Let us together keep pace with this momentum.

Wishing you all a Happy & prosperous New Year.

Yours truly,
N. X. George.





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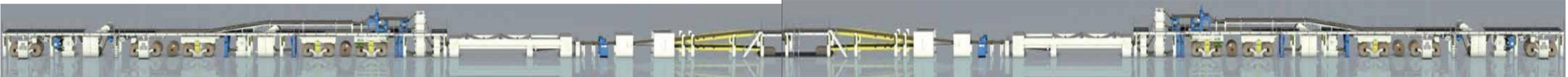
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Working Speed	50 mtr/min	80 mtr/min	100 mtr/min	50 mtr/min	80 mtr/min	100 mtr/min	100 - 150 mtr/min
Power Consumption	50 kw	60 kw	100 kw	100 kw	120 kw	150 kw	250 kw
Man Power Required	6 Nos	6 Nos	6 Nos	6-8 Nos	6-8 Nos	8-10 Nos	12 Nos
Installation Time	2 Weeks	2 Weeks	2 Weeks	3 Weeks	3 Weeks	3 Weeks	4 Weeks
Daily Production	10-15 T on	15-25 T on	30 - 40 T on	15 - 25 T on	30 - 40 T on	40 - 60 T on	60 - 100 T on
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**Meet the
 FCBM President - 2017**



Shri. Greesh Kumar Sardana is professionally a successful entrepreneur and academically a graduate in Arts from Kurukshetra University.

Being a classic entrepreneur he also liked new challenges and asked himself 'what's next'. In early 90's he was keen on exploring new line of work and hence stepped into corrugation industry. He had open-mindedness and acceptance to move his base location from a metro base in New Delhi to a small town Kala-Amb in Himachal. In partnership model he took over M/S Renuka packages, which gave him a learning field to understand the model corrugation industry. Then there was no looking back, this project had helped him set up his feet in the industry and in early 2000s he was in full bloom ready to start his own project from scratch. He has been successfully running M/S Shivalik Containers and he upgraded the infrastructure from a manually operated labor-intensive unit to smart automated manufacturing setup. His strength was setting up a mutually collaborative environment for the entire corrugation value chain to grow.

He joined NICMA in 1999 and then worked as joint secretary in NICMA. He became a member of FCBM in 1999, subsequently along with three other corrugators took responsibility of founding Himachal Pradesh Corrugated Box Manufacturers Association (HPCBMA) in 2008. He was President of HPCBMA during 2010-2012 and had actively steered the association towards having an influential presence in Indian and International Market. The vision and motto behind the foundation of this body was to bring together all the corrugated Manufacturers of the Himachal region on one platform, to get them acquainted with the new emerging technologies in and around the globe, to make them heard on international echelons. This was achieved through various international conferences and trainings which he did during his tenure as President.

He was nominated as Vice President-FCBM in 44th Conference.

He strongly believes that desires can become key to motivation but it's determination and commitment that can enable success one seeks.

Greesh Sardana.

Dear Readers,

As the newly-elected President of FCBM it gives me great pleasure to address you all through the pages of The Corrugator.

At the outset, let me express my gratitude to all members of FCBM for bestowing their faith and confidence in me to lead the Federation through 2017.

We are passing through difficult times and unprecedented conditions. It is feared that these conditions will adversely affect all businesses – including ours.

As box makers, the demand for our products i.e. boxes, is driven by general growth in consumer spending and increased demand for products and produce. Let us hope that once all this settled down to normalcy, it will be business as usual.

In the recent years, new avenues like e-commerce opened up opportunities for corrugated packaging. In fact e-commerce today forms one of the biggest customer group for many box makers.

I am hopeful such avenues will open up in the New Year and create a positive atmosphere to all of us.

As a group of box makers, we need to put together our heads and chart out a road map for the future growth of our industry.

As one of the most organized industrial bodies in India, FCBM should take lead in contributing to the overall growth of our industry.

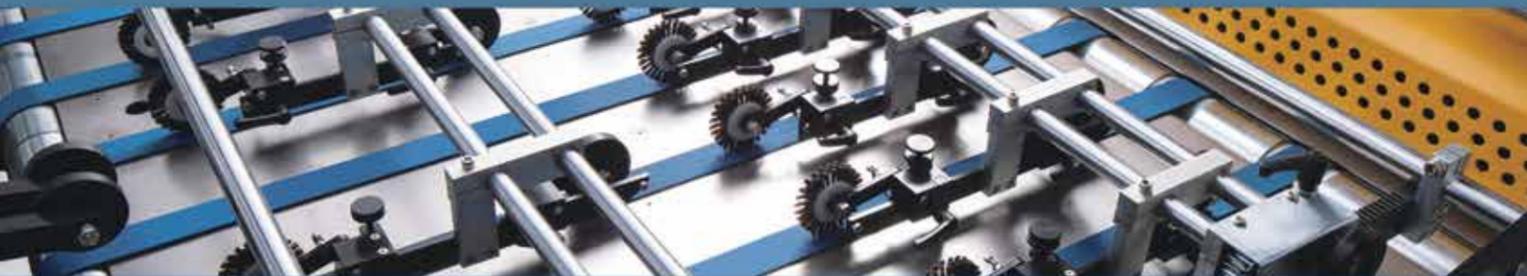
I invite suggestions from you all, on how we can plan events, meetings and seminars during the year to invite eminent people to throw light on the issues faced by our industry. I will try and implement your suggestions to the best of my abilities.

Let us together make FCBM ever vibrant and active in the fields of education, technology, testing and most importantly customer satisfaction - by making boxes that meet the growing demands of today's customers.

Greesh Sardana,
 President FCBM

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Accurate Machine Settings

In recent articles, I have focused on machine settings, maintenance, management styles and staying positive in our manufacturing environment. I am now going to discuss the specifics on some tooling that we can use in setting nips and registers. There are many different opinions on this subject and I would like to set the bar straight.



Dick Target
 "On Target Consultants"

I will begin with the feed section. How do we set the Front Stop Gauges? This setting alone in the box industry is the single largest cause of "unscheduled downtime". This is the one common denominator in all the plants that I visit around the world. Several weeks ago, I was in Santiago, Chile for an engineering conference. In the plants that we visited, each one of them was experiencing jam ups in feed sections in both Flexos and Rotary Die Cutters. The cause for this was the positioning of the tip of the fingers on the front stops relative to the top of the sheet that was being fed.

make contact and then back off a little. They eye ball the set back and unless your eyes are calibrated, the settings will not be consistent or correct. That is not only inaccurate but this type of setting does not allow for managing and producing sheets with "Normal Warp". Acceptable warp in our industry is 1/4" (6 mm) per linear foot (300 mm). It is when normal warp occurs; the sheets jam in the feed section under front stops that are set too close to the sheet.

Another cause for jam-ups can be a variation in the caliper of the sheet within one order. Sometimes, caliper variation can be as much as 0.005" (0.2 mm). This also contributes to front stop jams.

Depending on how many print stations are being used, the printing plates in the first print station can also be damaged or destroyed by sheets that are caught in the

feed section front stops. Please note: when the order calls for three or four colors, printing plates for that job become very expensive. The cost of a set of three or four printing plates can be US\$ 5000.00 per set or more.

When a jam up occurs, we now have to store all the sheets for the particular order and relocate them to some other place in the plant. When the crews relocate print-ready sheets, this adds cost and manufacturing time to the job. 10% of these sheets will be damaged every time the crews move orders around the plant. The crews now have to complete wash cycles in all the print stations, ink is wasted and the customer is

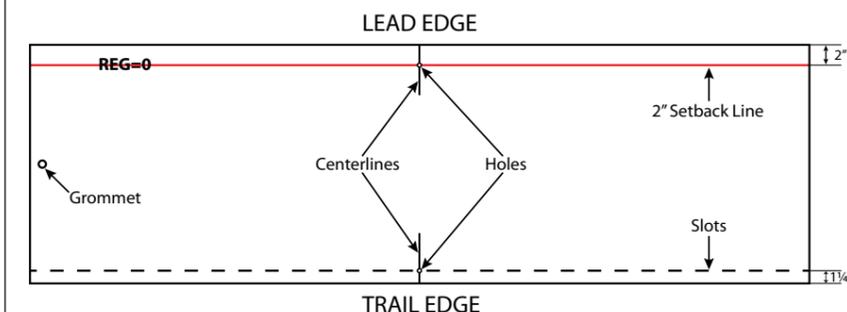


Remember the job of the front stops on any press is two fold:

- #1. Assure that one sheet feeds at a time.
- #2. Assure that the sheet travels square and perpendicular through the press.

Our Crews rarely have any consistent direction as to how to properly set these front stops. Many of the crews bring the front stop fingers down to the sheet,

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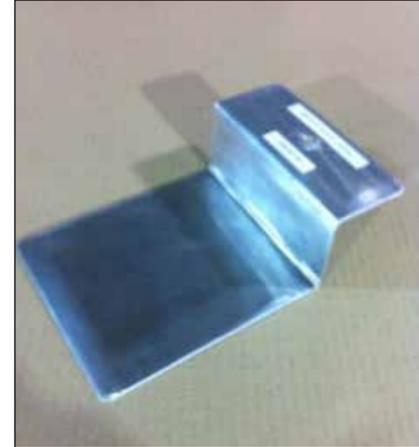
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going to be upset because the order is now late. Scheduling is affected and all other schedules are adversely affected. How do we fix this?

The answer is quite simple. The setting between the tip of the two front stops and the top of the sheet that is being fed must be standardized. The setting or clearance should be set at approximately 0.060" (1.5 mm). This is about 1/2 of the thickness of "B" Flute sheets (±). This setting works for all "B" flute sheets, "C" flute sheets and Double Wall sheets. Again, the 0.060" (1.5 mm) setting supports sheets with normal warp as well as sheet caliper variation.

Please note that sheet caliper variation is an accumulative number. This means that the variation in sheet caliper is a total of the variation in the stack of sheets in the hopper, not just the top sheet. As discussed before, this setting also allows total sheet caliper variation to pass through the feed section without affecting the transport of the sheet.

The Front Stop Gauge can be made of "16 GAUGE" sheet metal. It can be made in either a local machine shop or in your own maintenance department, depending upon their skills. See the picture for an example. The dimensions should be approximately 4 inches wide (100 mm). The handle maybe two inches (50 mm) high with the second turn the same. The length and width dimensions are not critical. The critical dimension is the thickness of the "16 GAUGE" sheet metal (0.060" or 1.5 mm). The operators now have a proper tool that enables them to accurately set both the

operator side and drive side front stops exactly the same. This will assure uniform sheet travel through the press consistently while minimizing unscheduled downtime and reducing waste.

Suggested Procedure:

1. Take one sheet from the next order.
2. Lay the sheet on the feed table under both front stops.
3. Turn on the vacuum. The sheet is now snug on the feed table.
4. Place one front stop gauge on the sheet directly under the front stop.
5. Lower that front stop until it comes in contact with the gauge and until it is snug with the sheet.
6. Tighten and confirm the vertical setting of the front stop.
7. Repeat the process for the other front stop.

Now you have properly set the operators side and drive side front stops. You should repeat this set up procedure for each and every order. Please note: In today's market, we manufacture a wide range of "B" Flute products, "C" Flute products all in an attempt to satisfy our customer's requirements. There are no real standard for any flute. They are all different and unique.

Please be sure to store the gauge on the "side" of the feed table and not "on" the feed table. I assure you that if you store it on the feed table, it will find its way into the feed roll nips causing expensive damage.

We are now going to discuss proper lay out procedures for our printing plates. Used and managed properly, this method will certainly offer consistency in printing plate design, reduced set up times and overall improved through-put in the plant. It will also establish standards for your operators and crews for the many different orders they run on a wide variety of converting machines. It also establishes a standard for existing printing plates and enables the plant to bring them up to a new standard.

This layout is consistent with the Time & Register Machine Calibration that I have discussed many times. This is also supports new machine designs and standards for Flexos and Rotary Die Cutters that you may be currently purchasing or planning to purchase in the future.

We must strive to be consistent in the following areas:

Understanding the definition of "Set Back" and what it represents.

Properly identified centerline lines on both the lead and trail edges.

Properly located centerline holes on both the lead and trail edge centerline lines on the Mylar. For some reason, this industry only identifies centerline locations on the lead edge of the printing plates. We need to be more accurate in our mounting procedures. We need to be sure that the Mylar is not only secure on the print cylinder but also perpendicular to the centerline on the cylinder.

Properly positioned Grommet Holes.

Proper Slur Gauges

Impression Gauges.

Understanding Setback. The world standard is 2 inches (50 mm). This represents the distance from the mounting strip on the lead edge of the printing plate to the point at which the lead edge of the sheet touches the Mylar. This is the standard for all print cylinders around the world and is used for accurate set up procedures and register control.

Centerline Lines. It is important for all printing plates to have centerline lines mounted on both the lead edge and trail edge of the Mylar. This is an affective tool for operators to assure precise mounting techniques and accurate set up procedures. These lines should be 2 inches (50 mm) in length when possible.

Centerline Holes. These Centerline Holes should be located one inch (25 mm) from the lead edge and trail edge of the Mylar.

Contd. on - 23



Contd. from - 19

These holes enable the crews to line up the centerline lines precisely with the centerline scribe line located on all on all print cylinders. Again, this allows for precise mounting techniques and accurate set up procedures.

Grommet Holes. These should be located and evenly spaced across the trail edge of the printing plate in order to assure a secure and snug relationship between the Mylar and the print cylinder. Using these Grommet Holes along with elastic straps assures precise printing at high speeds for both small lightweight printing plates as well as heavy printing plates used on 66"(1600 mm) cylinders and larger.

Slur Gauges. Slur Gauges are pentagon design circles located on the minor flaps. They are used to assure the fact the surface

speed of the printing plate is exactly the same surface speed of the sheet as it travels through the press.

Impression Gauges. These are important indicators that confirm the fact that the offsets in the print stations are correct. They also confirm that the impression roll is parallel to the print cylinder. They need to be parallel within 0.003" (0.08 mm).

The two specific items that I discussed in this article are very important and extremely easy to manage. They both should be checked every day on each press in your plant. By managing these simple items you will not only help your crews be more productive but you will enable your plant to continue to produce a superior product in a cost effective manner.

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 has worked in 29 countries developing and guiding corrugated plants in lean manufacturing, vendor development and management training.

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

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

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

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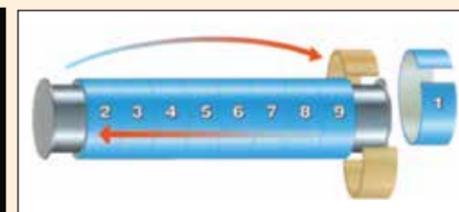
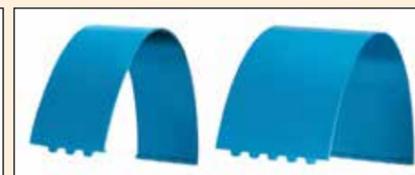
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The Sustainable Corrugated Industry

The first corrugated box was produced in the United States in 1895. Today, it's estimated that 90 percent of all products manufactured in the US ship in a corrugated box sometime during their life cycle from manufacturer to end user. Yet, we tend to take the corrugated box for granted. It is cost-effective, protective, easily shipped, has retail appeal, and is sustainable and clean.



In the produce industry, it's this last attribute that has gained recent attention. For growers, shippers and packers, food safety is essential and always top of mind, but what about the cleanliness of containers used to ship produce? The corrugated industry works hard to deliver containers that are free of foreign contamination to their customers. But there's another component of clean not seen by the naked eye called bacteria. Is bacteria present on the inside surfaces of boxes?

To answer these questions, the corrugated industry recently commissioned third-party testing and analysis that confirmed 100 percent of tested corrugated containers met acceptable sanitation levels. Experts examined 720 swab samples taken from containers produced by six different corrugated manufacturers at grower/shipper locations in three different US regions: the northwest, California, and Florida.

The US Food and Drug Administration does not have guidelines for packaging bacterial levels. Samples were tested using the cleanliness threshold of 1,000 colony forming units (CFU) as defined by Dr. Keith

Warriner from the University of Guelph, the Fodd Safety Authority of Ireland, and the New South Wales Food Authority. One hundred percent of the evaluated samples were below 1,000 CFU per swab, confirming that corrugated containers provided for food packaging meet acceptable sanitation criteria at the point of use. Typical corrugated manufacturing practices are responsible for the low levels of bacteria.

Corrugated containers are engineered for single-use specifically for the product they contain. They're designed to cushion and protect products and at the same time optimize fiber usage and reduce weight and air shipped, leading to fewer loads. After use, there's nothing to wash. The corrugated box is returned to the paper mill where the recycling process greatly reduces bacterial loading.

More than 90 percent of corrugated shipping containers produced in the US are recovered for recycling through strong commercial and residential recycling programs. Most retailers have backroom balers used to bale corrugated that is then sold to generate revenue and improve store profitability.

This continuous cycle of using boxes, recycling them and then creating new boxes, not only translates into package cleanliness, it also contributes to the sustainability of the corrugated industry, which has a long history of responsible environmental stewardship.



Dennis Colley,
 Corrugated Packaging Alliance,
 Elk Grove Village, IL, USA

Corrugated containers are made from a renewable resource, and the corrugated industry remains committed to improving its overall footprint. The first ever industry-wide life cycle assessment was published in 2010 with an update in 2014 showing reductions in 10 impact categories, including a 32 percent reduction in global warming potential.

All of this, along with a lot of innovation, contributes to making corrugated boxes unsung heroes.

Dennis Colley is President/CEO of the Fibre Box Association (FBA), a non-profit trade association representing North American manufacturers of corrugated packaging. In this role, Colley leads the organization in supporting the corrugated industry through data sharing, issues management and communications.

Colley is a graduate of the University of Alabama. He currently serves on the Boards of International Corrugated Case Association (ICCA), and the International Corrugated Packaging Foundation (ICPF).



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Rotary Dies and Mechanical Stripping

The mechanical stripping process has been around for many years, at least since the 1970s, but a recent surge of new machinery in North America has made this a hot topic for diemakers and converters. There are a lot of companies that use it now, such as Mitsubishi, Sowa, Hamada and Chicowoa.

Mechanical stripping - overview

There are different formats, but most require some mechanical levers, pins and special cutting dies you may not have seen in the past. Diagram 1 shows the Mylar of a cutting die—it's a bolt hole pattern of the knife cylinder which someone has used to lay out quite a number of levers. It gives you a nice perspective of what you are looking for. Diagrams 2 and 3 are examples of the stripping; note that the dies are engineered to leave the scrap in the board until the product is ready for ejection. You are taking the scrap out and, if you are putting any rubber on, its purpose is to eject the product (the box), not to eject the scrap. This technology is opposite to all previous flexo-folder-gluer functions.

Diagram 4 shows the mechanical stripping cycle, using the Mitsubishi machine as an example. Other machines may differ or use an entirely different process. In this case, there are three pins: one is retracted, one is partially extended and one is fully extended. There's an eccentric inside the knife cylinder. An eccentric is a disc or wheel mounted so that its axis is not centrally located on a revolving shaft in order to transform rotation into backward-and-forward motion; for example, a cam in an internal combustion engine. The stroke of this eccentric depends on the machine. Mitsubishi has three different machines, and they have three different pin sizes. The stroke of this eccentric is about 10 mm (0.39"). From the diagram, you can see that the beveled knives hold the scrap until the 7 o'clock position where the scrap actually ejects from the cutting die.



(Clock wise)
Ben Hazard, Dynamic Dies, Inc., Holland, OH, USA; **Steve Reising**, Triangle Dies and Supplies, Inc., Batavia, IL, USA; **Brent Singer**, Metsa Board Singapore Pty Ltd, Singapore; and **Paul Aliprando**, Mitsubishi Heavy Industries America, Corrugating Machinery Division, Hunt Valley, MD, USA

This is most important; you've got to get this scrap out. You don't want that scrap staying in there or it will pack, bending knives and ruining the die, especially when your machine is running about 350 boxes per minute. All OEM suppliers can recommend restrictions or speed limitations on their machines depending on the amount of rule that is in the cutting die within a certain distance. We tend to restrict it down to 300 or we restrict at 250 or even 150. However, in our experience, many converters will ignore those guidelines; they'll put the die on and expect to run it at 350, so the reality may be that your die has to be performing at 350 boxes per minute.



Diagram 1



Diagram 2



Diagram 3

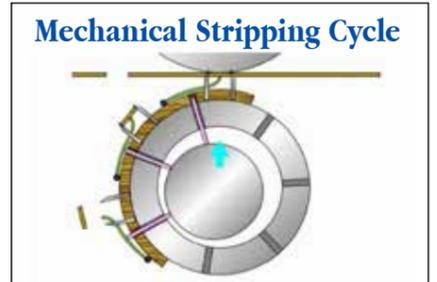


Diagram 4

Contd. on - 31

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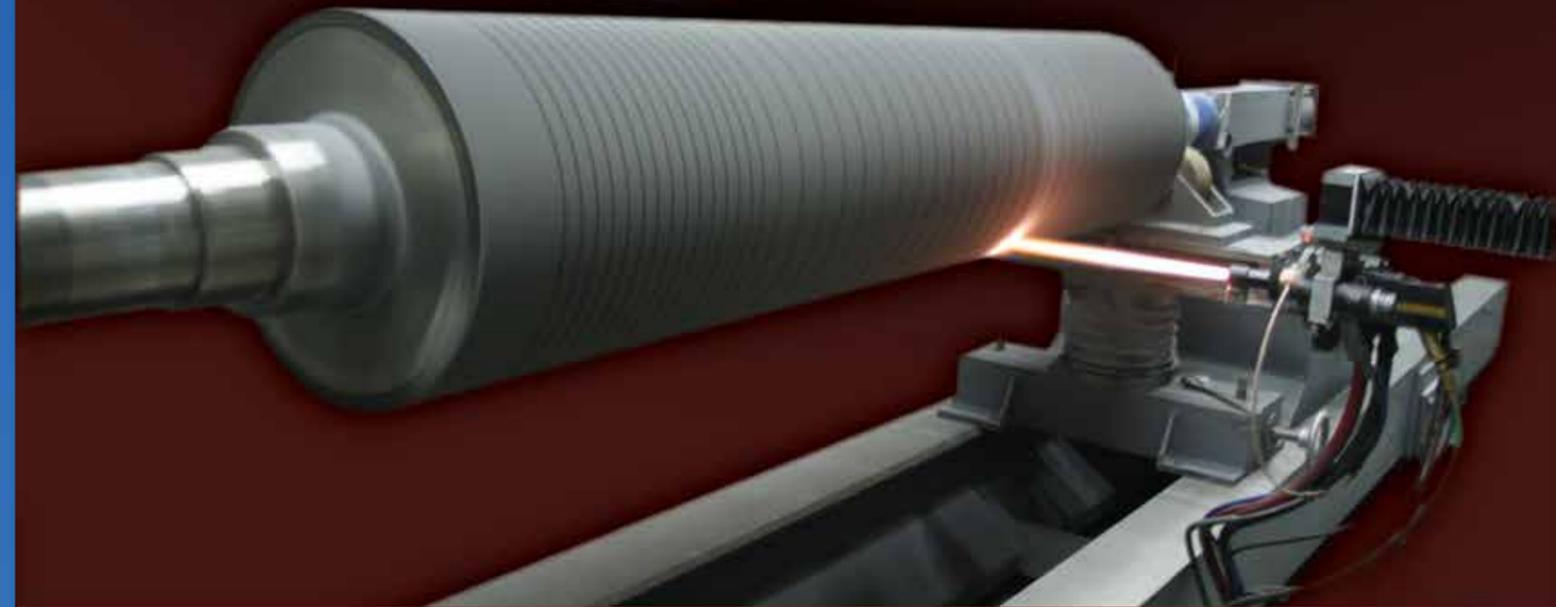
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Contd. from - 27

Diagram 5 shows how the die rule retains the scrap and then the spring pin pushes up the ejection arm, lifting up the nylon pusher and ejecting the scrap. Diagram 6 shows a sample of the cutting die on the left which makes the produce box on the right. You can see the "L" shapes; it's a locked bottom. All the requirements are done by levers. The "L" has to be split because you have a radius going through and the stroke of that pin going back varies depending on where it is on those strokes. So if you have a long piece of scrap, you will be pushing part of it out and the other part will be stopped and not even trying to come out. You're going to get a jam up. You'll have to look at splitting that scrap up. Again, the rubber is outside; you are ejecting the

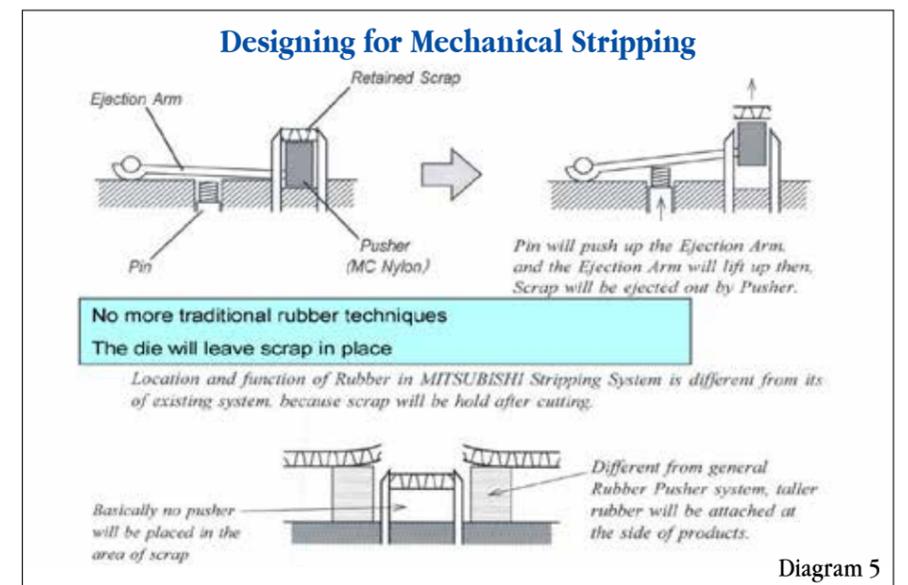


Diagram 5



Diagram 6

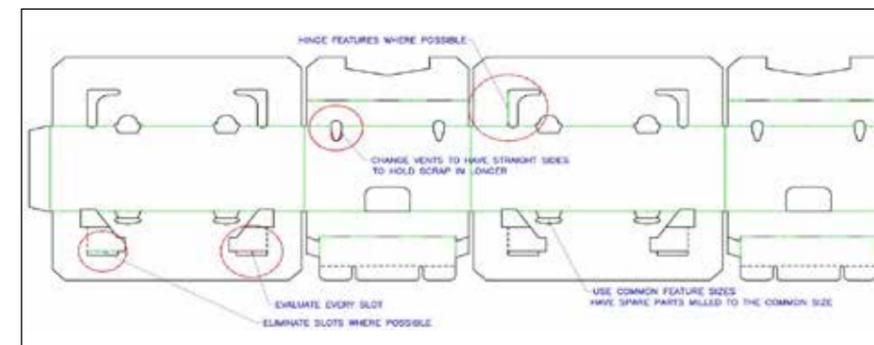


Diagram 7

product, not ejecting the scrap. One of the benefits of mechanical stripping is that it gives you 99.99% scrap ejection, which is what customers want.

To increase your success, you'll want to look at some things; for example, get away from odd shapes. In Diagram 7 you see that you hinge where you can; that "L" slot that you saw before, hinge it, so you tuck it in. Again, it eliminates a couple of levers

and each lever is costly. Let's say a lever could be \$100 USD on a cutting die, which is a cost to your customer and an issue for you if it fails. So eliminate those levers wherever you can. Again in Diagram 8, for the handles, hinge them if you can. If your customer wants a complete hand hole, talk to them about a hinge. If there are any vent holes, make sure the vent holes are over a pin; a way of getting away from levers and just having a direct pin. Try to eliminate

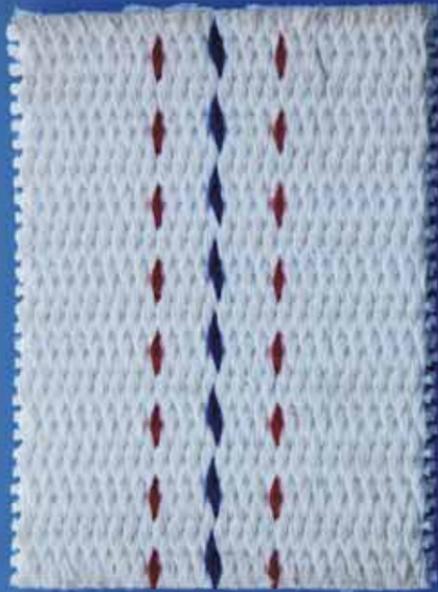
football-shaped slots in favor of deflated football shapes.

In Diagram 9 we see again to try to line up the scrap holes, especially vent holes. If you can move a vent hole in a produce box, move it. Obviously, you have print issues that you have to look at, and customers like boxes to look symmetric. So it might be a little difficult, but see what you can do there. Diagram 10 is an example of a direct pin getting away from levers and directly pushing the scrap out. Diagram 11 shows a box where the red is the location of the knife cylinder. These are bolt holes, but, again, where there is a hole or a vent hole, you should question whether you can move it. If you can move a few of these around and get them over pins, you eliminate a lever.

Finally, Diagrams 12 and 13 stress the importance of replacing broken hardware in order to reduce downtime. Pins wear. If a customer is using pins that are five- to six-months-old, encourage them to throw them out and get new pins. Pins will wear on the bottom where they touch the eccentric. There is a chamfer on the bottom and if that chamfer is missing, the pin is worn out. Some diemakers have gauges to check the pin length, which is something you might want to consider. Metal prongs can bend and fracture. Gates cut into



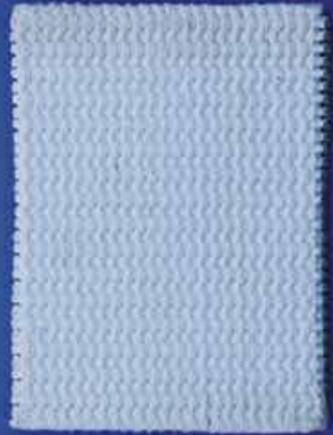
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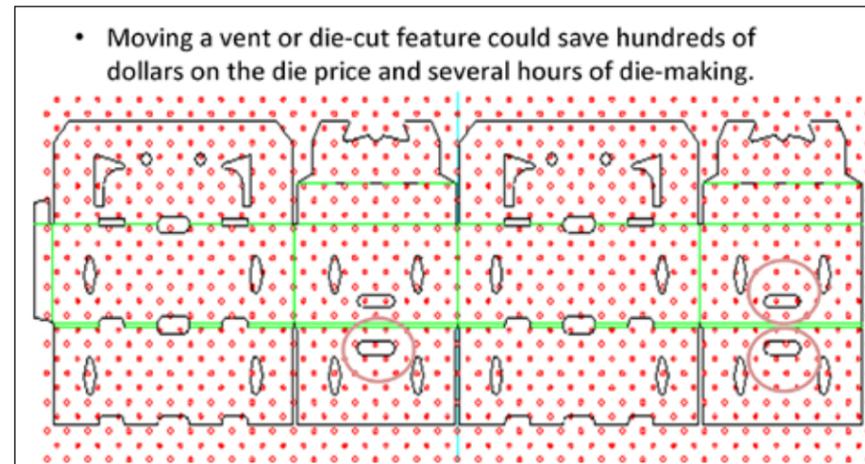


Diagram 11

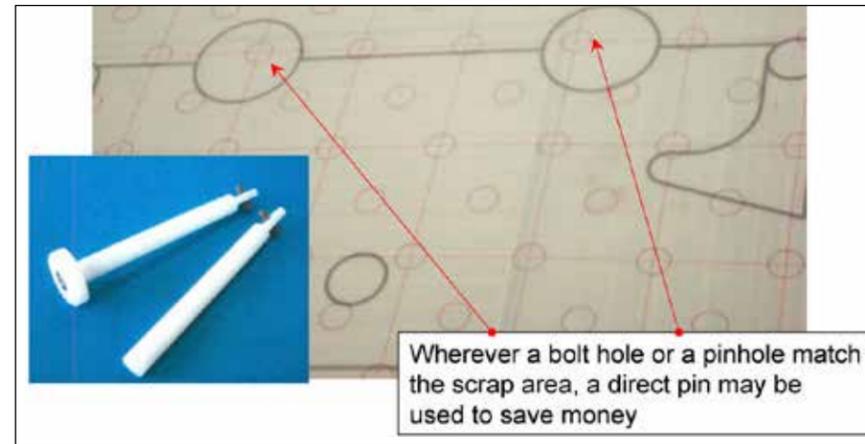


Diagram 10

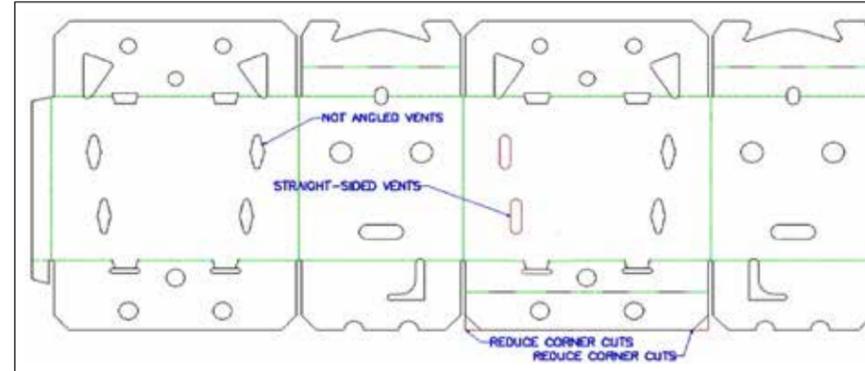


Diagram 9

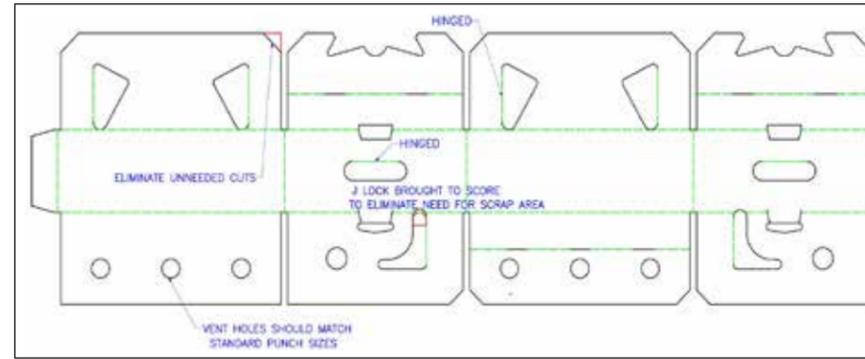


Diagram 8

the rule may break, especially when you have internal scrap that is too close to the cutting rule.

A bit about design

Let's look at a few simple steps to creating a mechanical stripping die that results in a successful run.

First, you should review your customer's specifications; a lot of the standard flexo/folder gluer/diecut situations come into play here. Confirm what is going to be in that diecut and whether there is anything outside of standard RSC/HFC (regular slotted container/half slotted container) printing. Often printing is going to make a big difference in what has got to be in that diecut and whether or not there is trim added for a print.

The second thing is to talk to the designer when you get into a design that presents itself with difficult stripping. Even better is to work with him or her before an issue comes up so they can learn a little bit about what works best on their presses. A lot of time the designers don't have a good feel for what is running on the machine.

Third is to overlay the design you're given on the standard hole pattern that is available on these cylinders and review how to tackle the most difficult area of the strip. This is the point where you determine what kind of hardware you are going to use and if you are going to use pins; from there the rest of it will kind of balance itself out. You can do a little give and take when you are looking at the design.

Fourth, using the machine; a lot of times you will get an item that presents itself with a couple of areas that you'll need to be on the die, and other areas that you want to make sure to use the machine as much as you can to its benefit. A few items that can relate to that are:

Tapered slots are very common in certain areas of the country (see Diagram 14). They are outside the range of what the machine is able to produce, so you've got to know the different options that come across. On the first taper in the example here, you



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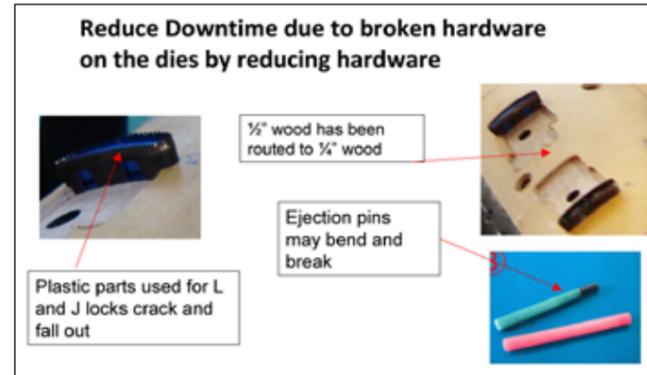


Diagram 12

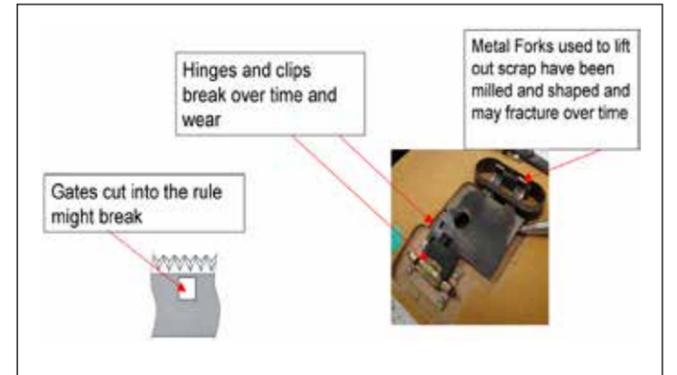


Diagram 13

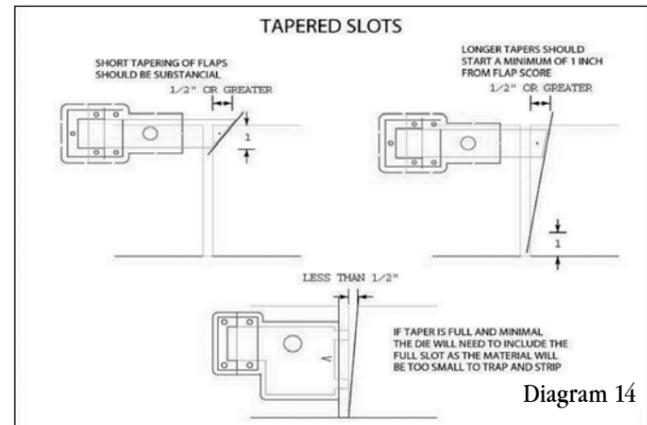


Diagram 14

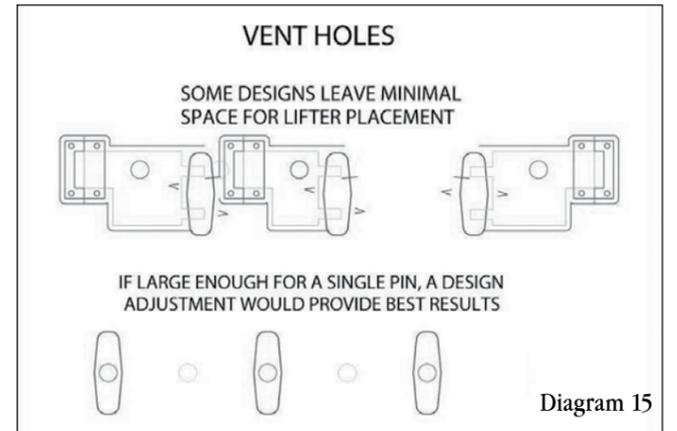


Diagram 15

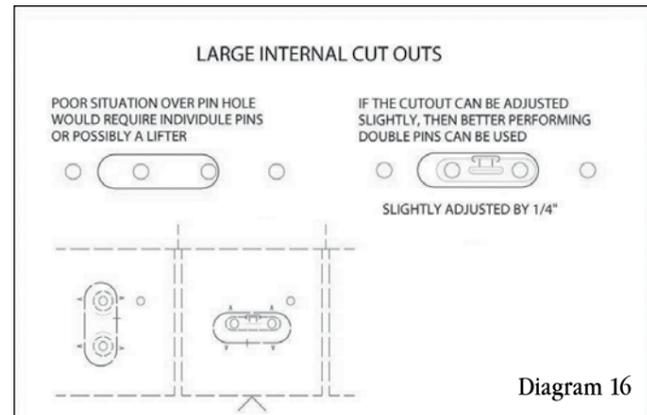


Diagram 16

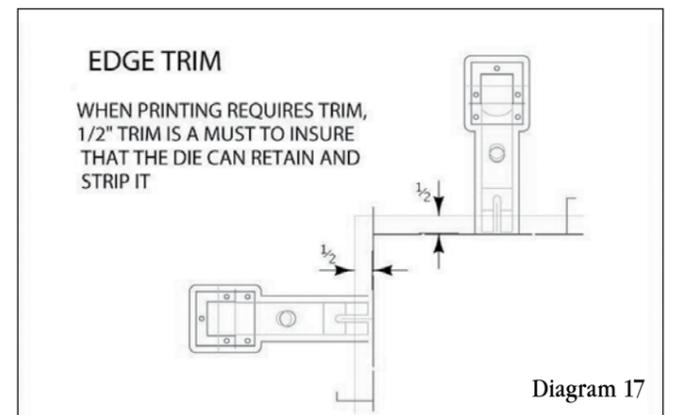


Diagram 17

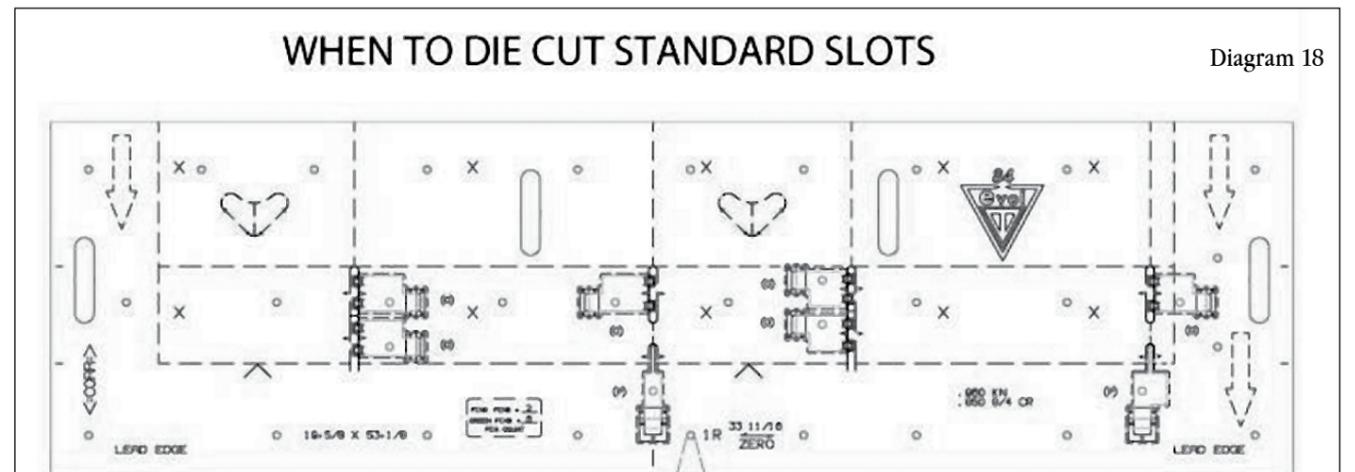
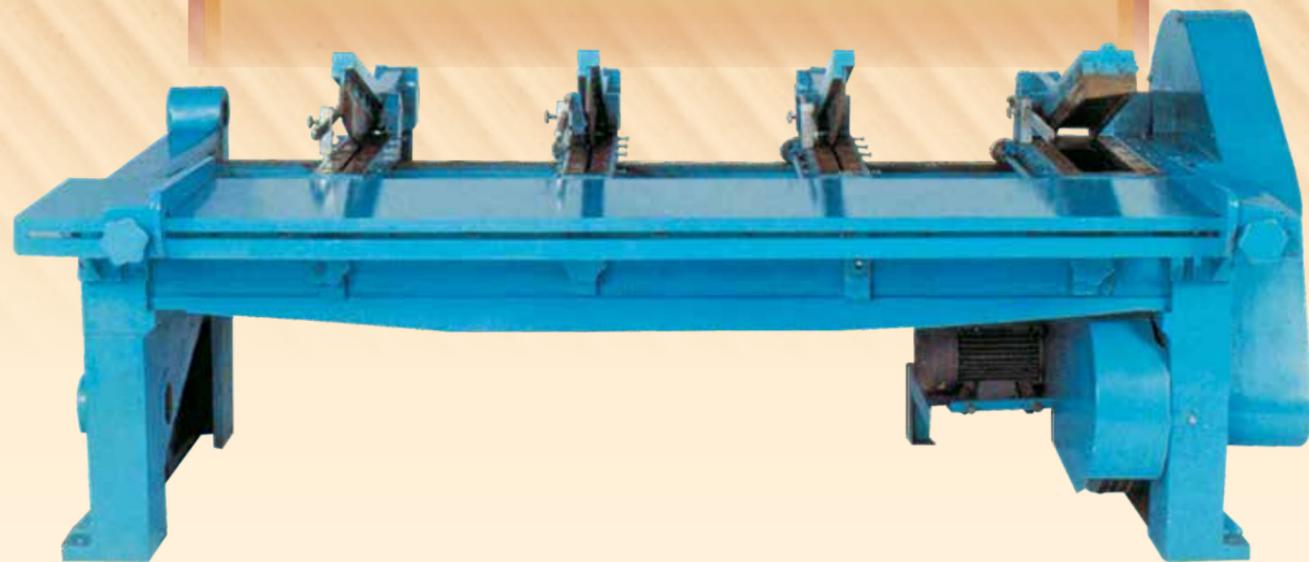


Diagram 18

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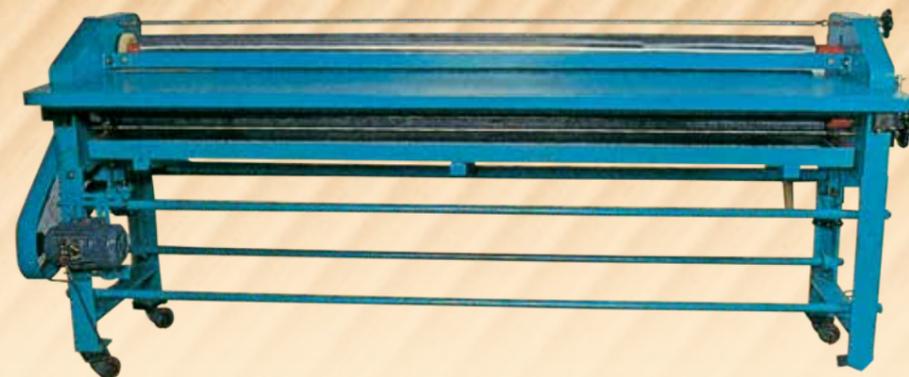
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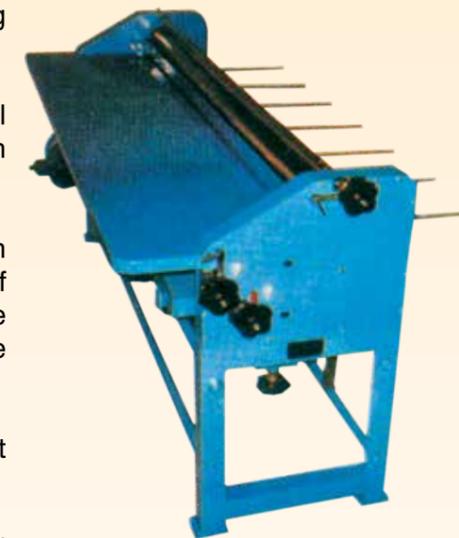
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need to have at least 0.5" (12.7 mm) or better to taper off the slot to be able trap it. Keep it to the die and strip it. In another case, you might have an option where they have a long taper. If you want to get away with the machine doing the slotting and you adding in the tapering, you want to make sure the designers are not running this taper all the way to the tip of the slot. If they run it to the tip of the slot, you'll have a little more issue on where to bend that rule so as to not cut into the rest of the box or leave that scrap not fully cut from the slotting head.

On the bottom example in Diagram 14, when we are given less than 0.5" (12.7 mm) of trim, it's a very slight taper; you are going to end up putting the whole slot in the die. There's just no way are you going to be able to take a slight little taper all the way to the tip of the slot, close into the slot and retain that onto the die.

When we get into vent holes (see Diagram 15), a lot of designs try to put in so many vent holes that it sometimes is a little bit impossible to get situated with levers. There are a number of different levers that we will use and try to make sure that we can fit them in, but if you are posed with a slot placement situation, try to get the designer to allow you to move them a little bit. If they are not involved in the printing, maybe we can move them and in this case we might have to do a little more than just putting one pin in it, but if you can get a pin centered in there and then with a little bit of material in the slot to keep it from getting trapped in, you can get that strip in a lot easier and it's a little bit more cost effective on the die end of it for the customer.

The same is true with large cutouts (see Diagram 16). Large cutouts will cause us to use a number of pins in this case. You can use single, larger head pins and there are some double bridge pins that can be used. Again, sometimes handles aren't the end of the world if they move a little bit. But it's nice to be upfront with the designers if we can move the bolt to position it over

that hole pattern. The bottom diagram is another example of what style we might use to strip that out.

Diagram 17 illustrates edge trim. This is pretty much by the book; 3/4" (19.05 mm) is what is expected, but good luck getting 3/8" to 0.5" (9.53 to 12.7 mm) from the customer's trim, you aren't going to be able to trap the scrap and keep it on the die. We need that to be able to use perf or pins or other items to catch that scrap and trim on the die.

As I was saying before about utilizing the machine, in Diagram 18 we have the bottom 0.5" (12.7 mm) of an RSC and they've got the skip slots and unislots in it. You might look at it and think that the other slots are straight, so all you've got to do is the two new unislots. The problem with this is that on the machine they can kick all the slotting heads away, so you are going to want to do the whole bank of slots in the die because they would have to go in and remove the knives, or in this case we put it all in the die, that whole front bank. This way they will do the trail edge, the standard slots and we'll take care of the front slots with the die. We'll blue tab all

the slots, and then we have some simple butterfly wing hand holes there.

Components

Let's take a look at the hardware. This is where it gets really important because your goal is to set up the tooling to make sure that it lasts as long as possible under the conditions it's going to be put through.

All of the components are color coded, which really helps. We have two different machines; we have an EVOL 84 which is a small inside ID diameter 10 5/8" (269.88 mm), and then we have an EVOL 100 with an inside ID diameter of 11 1/2" (292.1mm). There is an additional new machine that runs slightly faster, but primarily at this point it still uses the same components until the new machine release in 2016. One of the things we want to talk about here is we have a number of manufacturers that are very good at producing parts. We have the mechanical parts themselves which are sold as modular parts. Then we have the pins themselves, which the rods go inside the cylinder to form an eccentric cam, and you can see ones with springs on them and ones without springs; that's in relation to the type of hardware that it is actually lifting (see Diagrams 19 and 20).

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Hardware - Pins

- Colored dots next to lever ensure right pin for the job



- Right colored pins for the dot indicated on the die board

Evol 84

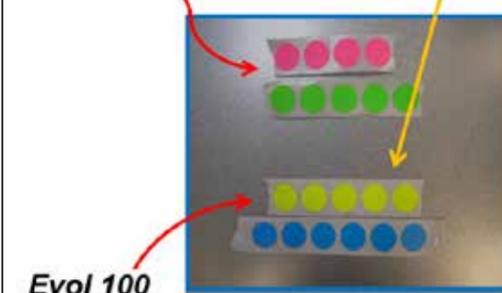


Diagram 19

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Hardware - parts



Mechanical Stripping Arms

❖ see sample sheet

Spring & Solid Pins for Mechanical Hardware

❖ Colors indicate machine Evol 84 or 100

Direct Stripping Pins

Also known as:

- ❖ Plungers
- ❖ Mushroom pins
- ❖ pushers

Diagram 20

Pin - Identification

- Different colored pins
- Pins are different in length
- Plywood different in diameter



Diagram 23

Hardware - Levers

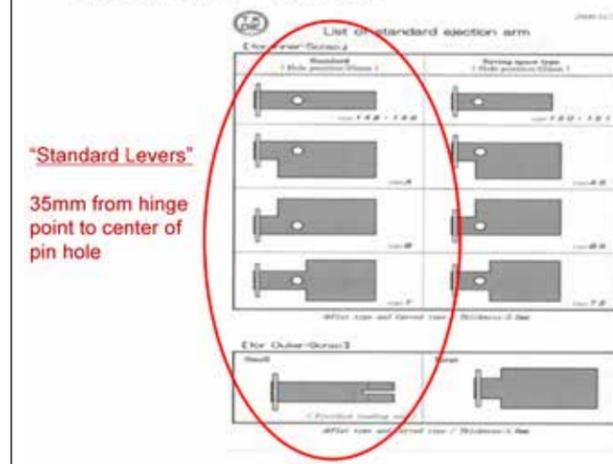


Diagram 21

MHI Evol 100

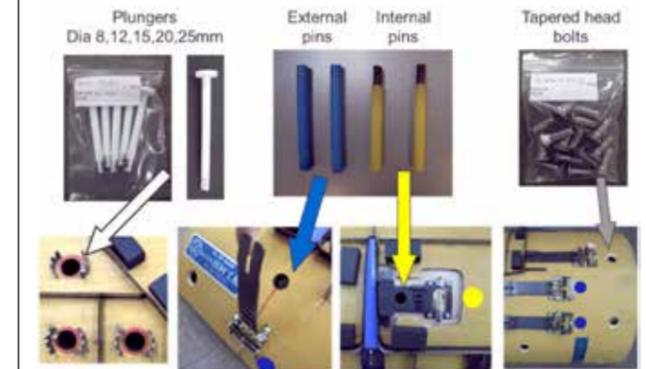


Diagram 24

Hardware - Levers

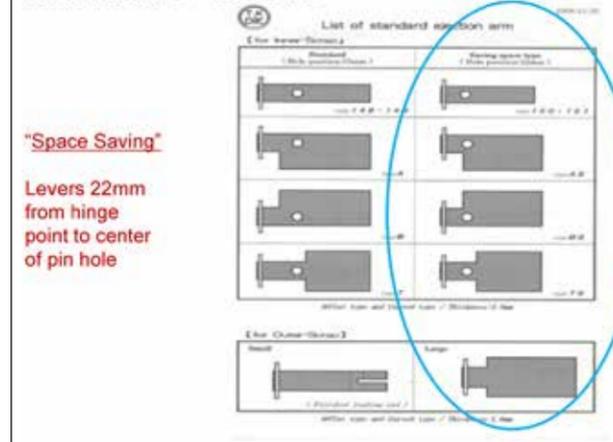


Diagram 22

Pin - locations / mounting

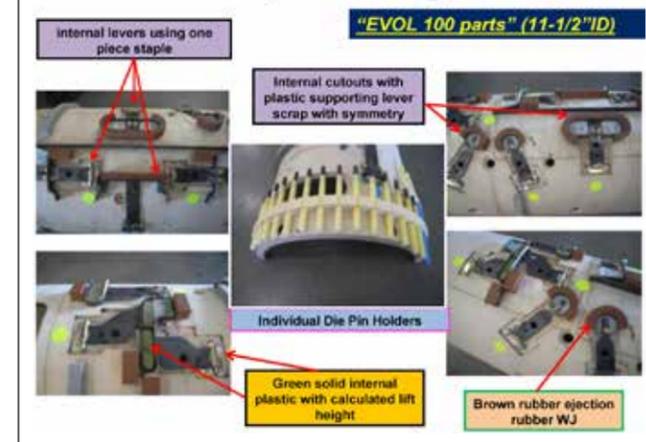


Diagram 25

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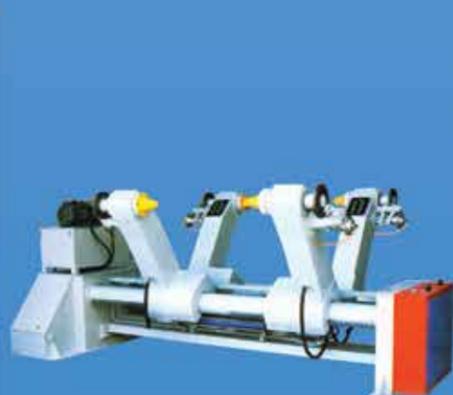
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So it's either external trim or internal trim. These component parts will create and cover everything we need to do on a cutting die as we make the hardware.

Diagram 21 shows the fact that the distance from the lever's mounting point to the center of the hole is 35 mm (1.38"). Why is that critical? Because it's the standard setting that doesn't move. To change the lift point, we then have another set of levers (see Diagram 22) the same shape of the lift point; changing the hole center gives us the ability to move and shorten up the lift point depending on the angle or the shape of direction that you are trying to get to. There is a whole set of rules that go with manufacturing the dies themselves, so you must learn those limitations and what those restrictions are.

Pin identification is where you normally get into a debate with your customer; the biggest thing is that edging (see Diagram 23). Note where we mounted the pins; on the edge of the dieboard. There are some particular views that we all have when we become a manufacturer; we like to give the customer the pins themselves because at least we know they are going to work the first time. As we said previously, if the bottom of the pin has a little radius, a little chamfer, that chamfer is gone; the biggest problem is you put a pin in and the pin is too short, then the pin doesn't lift to the right height on the hardware and it doesn't eject the scrap. The first piece of scrap stays in the die; as do the second, third, fourth and fifth. At this point we've just ruined our brand new die.

In Diagram 23 you also see the difference in the color pins for the EVOL 84 and EVOL 100; they are differently color coded to make reasonably sure the operator won't get them in the wrong place. Yellow pins with springs are internal levers and are 99 mm (3.9"); blue pins are solid (external levers) and are 101.5 mm (4"); and white pins are plungers (internal; 8, 12, 15, 20 and 30 mm [0.31", 0.47", 0.59", 0.79" and 1.2"] in diameter) and are 108 mm (4.25"). Our recommendation is that every die have an exact number of pins allocated to the

die and placed in the pin holder for each individual cutting die.

Diagram 24 shows what we call a plunger or a mushroom pin. So for these, for example, we would have a hole, a punch or a vent hole. You just want a lot more body in the area; it still fits in the same hole, but it's a bigger surface area at the top. These come in preset sizes, so we supply them already pre-made and in a lot of cases the customers are now asking these tops to be color coded to make it easier for the operator to not forget which one goes in the right spot. We try to make it as easy as possible. Again, they are all colored blue, yellow, etc., but the first thing is where do they all go?

As you can see, the blue ones would go into an external lead. This is going to spring load—strap on it, and it literally acts like a mouse trap. The blue pin goes on the outside so they can be lifted all the way up and dropped underneath. The spring pin needs to go into a hole that has already been created in the hardware and there is a little bracket that comes across the top which closes the hole up, and that's how it stops the pin from coming up. If the operator loses them or forgets to put it in or doesn't follow the frame sequence, they'll fly out the first time around. The plunger goes into a hole. It's got

retainer perf holding the trim onto the die, and then the plunger will come up as it rises up around the center cam and actually push the scrap off the retainer. You can see the trim knife on the side; we have specific colored dots next to the hardware to show what color pin goes in where.

Diagram 25 shows another shot of the different variations of plastic. That's another component. This plastic or nylon has to be solid enough to take the pressure off of compression against the anvil without squashing and squeezing the size of it. We also have to have rubber around the dies; in fact this is a brown rubber and there are a number of other rubbers that we are using today, depending on the customer, so we have got to have rubber to be able to eject the product away from the knife at high speed and retain longevity properties to wear, heat, dust and fast rebound and recovery.

Diagrams 26 and 27 emphasize the importance of color coding the die and reinserting the pins in a pin holder after each run. Some companies will throw all the pins into a bin in a cupboard and then say you have to check them, they are all different sizes. Instead we made a very simple gauge cut on a laser for all the different pin points so we can organize our pins and control our own prices.

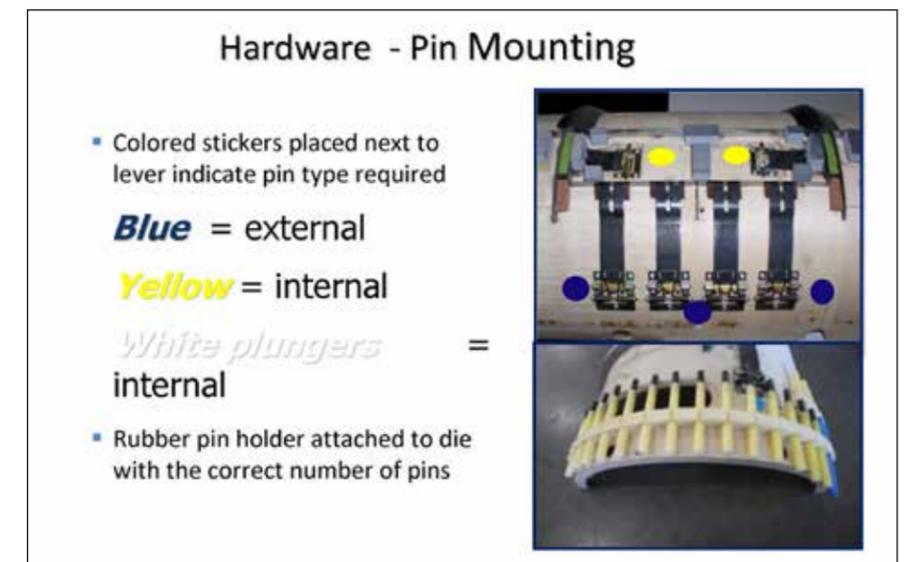


Diagram 26

Contd. on - 47



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Diagram 27

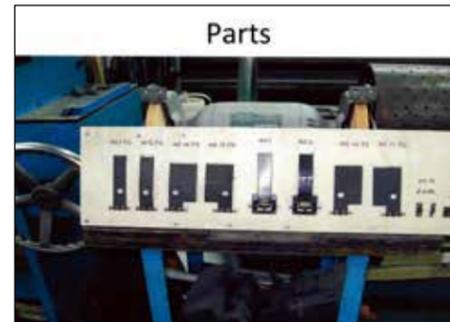


Diagram 28

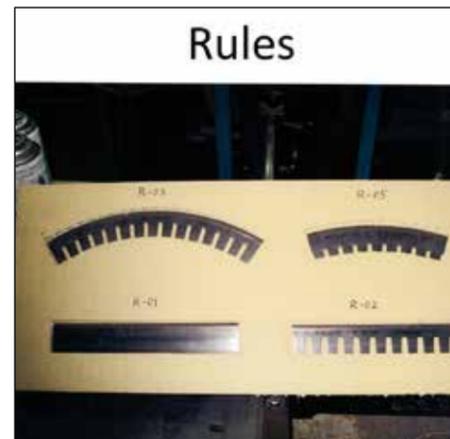


Diagram 29



Diagram 30

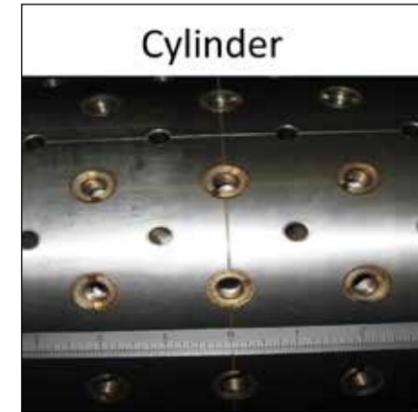


Diagram 31



Diagram 32



Diagram 33

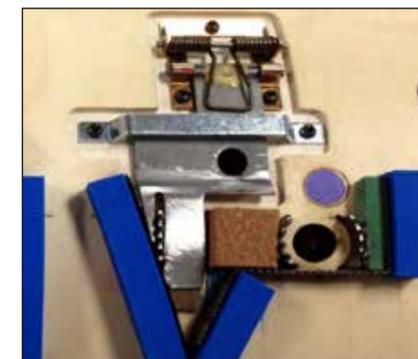


Diagram 34

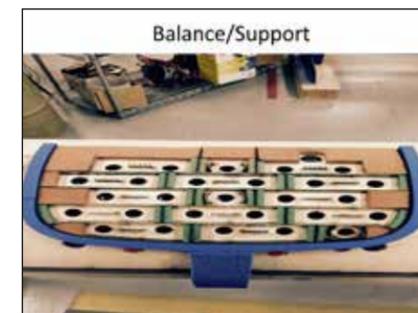


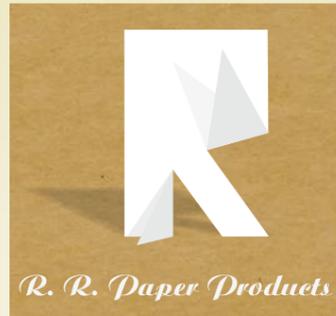
Diagram 35

Mechanical stripping parts

Let's take a look at some of the parts. We were asked to get really old pictures, and these were some of the oldest pictures I could find of some of the parts from Mitsubishi (see Diagram 28). If you have small centers, lefts and rights or long centers without holes, these are just some of the components that you use that you have to manipulate and manufacture to actually fit into the dieboards. Some of the rules that you use (see Diagram 29) are still notched rule; you can use 0.5" (12.7 mm) bottom notched when you are stripping exterior scrap or products like that. When you go into interior scrap is when you want to drop down to either a no notch rule or a 1/4" (50.8 mm) bottom notched rule to give proper distance to put that gate hole in that rule. Diagram 30 shows some of the ejectors. These are kind of what it all started with; it was pretty simple. There were a few ejectors and then there were the plastic areas that you would modify to put inside slots or cutouts.

Diagram 31 is a picture of an actual cylinder. The bolt holes are 25 mm (0.98") apart and then directly in between all those holes, what we call the EVOL holes, you can use either one of those holes to put a pin in. Obviously, you want to try to set up your dies to run all the EVOL dies first because as you can see with the bolt holes, you have the threads in there and the threads tend to wear the pins out a little quicker. So you want to try and place everything for an EVOL hole, but the bolt holes are an option in order to get the best stripping.

Diagrams 32 and 33 are restrictor brackets. You want to put these on all your components when you are coming in from the trailing edge of exterior scrap. What happens is the centrifugal force in the length of the flipper as it comes around will actually hit the anvil and rip the flippers off. So these are designed as just a bent piece of metal with a couple of screw holes; you can see one in place in Diagram 34. This represents the back trail edge; we put a restrictor bracket on here. You lift this up



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manually by putting a screwdriver in the hole to make sure you are getting a little bit past the perf to make sure it's going to eject it off. That's when you locate your bracket. Your bracket is going to restrict the height. Use a pin with a spring when you are using a restrictor bracket.

Diagram 35 shows a job where they are just taking a cutout window. As far as rubbering techniques, what you want to utilize on an EVOL is opposite of a rotary. In rotary you want to stay your standard 1 1/2" (38.1 mm) away from your cutouts where you want to retain the scrap, so you rubber right up against the knife all the way through. And then each individual piece of scrap you want to support that rubber and balance the load because here you are only taking it out with one pin. You need to have a balance here and a balance here [again, maybe someone needs to put arrows], so when this pin comes up, the scrap cannot bend up. You want it to be able to all come up and have something there for it to resist to let that pin function. So here you use a standard 2 pin plastic; we have 2 pin, 1 pin, 2 pin. But you definitely want to make sure that you balance all your scrap on there.

You need to test your parts before shipping (see Diagram 36). What you can do is pound a piece of corrugated in the cutout and then you can use a screwdriver



Diagram 36



Diagram 37

in that hole to actuate that lever and watch that piece of scrap tip out. You want to make sure that it is pushing it out completely and it's not catching or leaning on one. If it is, then you want to put a piece of support rubber in there like the previous diagram. Diagram 37 is a different view. This was taken from a slow motion video; in it you would see that there is support rubber on the ends of that mushroom and the lever is actually bent all the way up inside the stem. So you want to test those and make sure that everything is functioning properly before you ship them out.

Bottom line

At 350 boxes per minute, how much room is there for error? The answer will always be none.

To sum this up, you have to make a decision; this is a range of tooling and dies where you are either in it or out of it. You commit to investing and preparing yourself to build tooling because of your customers' demands on this equipment. They're going to want tooling that works 365 days of the year even though there are a number of variables that you can't control, but you have to have and make the investment up front. It's time consuming, so you have to make the commitment to either be in or out of it. There is no half way of doing this.

Ben Hazard is a Corporate Product Specialist at Dynamic Dies, Inc. and can be reached at 1-419-865-0249 or ben_h@dynamicdies.com.

Steve Reising is a CAD Manager/Field Technician at Triangle Dies and Supplies, Inc. and can be reached at 1-630-454-3200 or sreising@tridie.com.

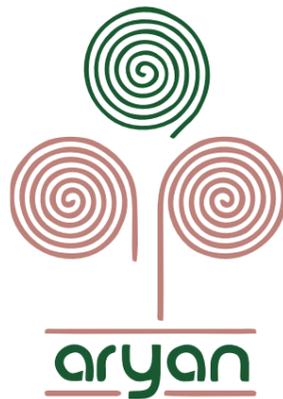
Brent Singer is the Technical Services Manager at Metsa Board Singapore Pty Ltd and can be reached at +65 6222 0660 or brent.singer@metsagroup.com.

Paul Aliprando is the VP, Sales and Marketing at Mitsubishi Heavy Industries America, Inc. and can be reached at 1-410-584-7990 or paliprando@mhicorr.com.

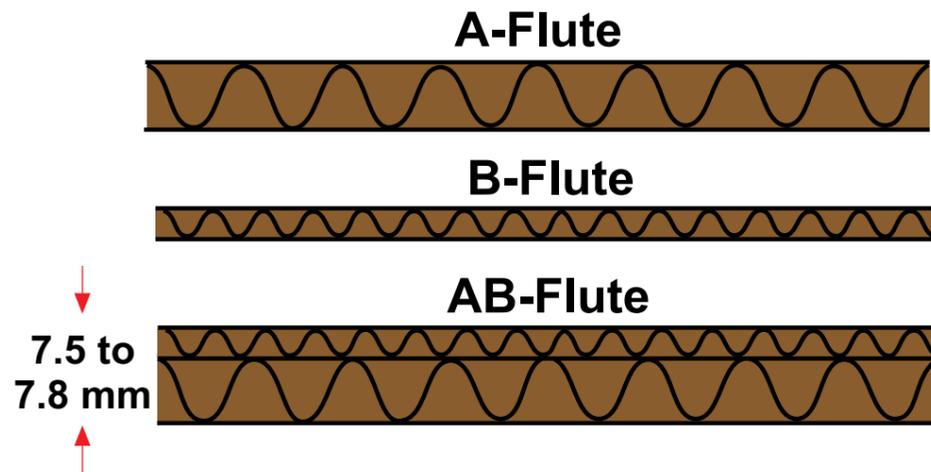
This article is reprinted with permission from the International Association of Diecutting and Diemaking's monthly magazine, The Cutting Edge, February 2016.

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 550+ 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.

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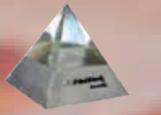
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Icorrugated Expo 2017

29 March - 2 April

Shanghai · Hongqiao



National Convention and Exhibition Center (Shanghai)



Robby He

CEO of Icorrugated Media - Founder of the first corrugated show in China, 2001 Sino Corrugated Expo

Organizer of Icorrugated Expo 2017, Icorrugated Media, the most influential media company in China's corrugated industry, also founder of Sino-Corrugated Expo-first professional corrugated Exhibition in China.

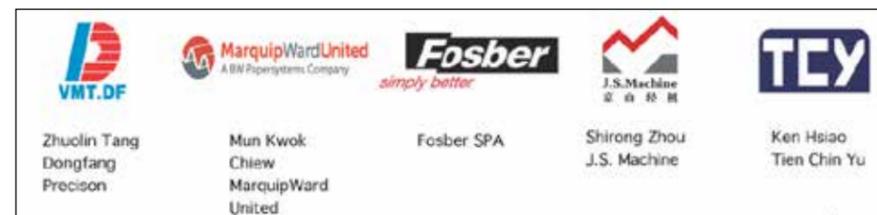
In 2001, China's first professional media company in corrugated industry - Publisher of China's first corrugated industry professional magazine Global Corrugated Industry, Shanghai - Shanghai, India and t and the Icorrugated Media, lunched China's first corrugated exhibition Sino-Corrugated Expo in September which attracted 150 Chinese equipment manufacturers and 7000 professional audience's participation.

In 2002, Shanghai - Shanghai, India and t and the Icorrugated media cooperated with Singapore Reed Exhibition to set "Shanghai Reed-Huayin International Exhibition Co., Ltd."

In 2008, due to different understandings of the future development in the industry and the different future exhibition development strategies, Icorrugated Media ended cooperation with Singapore Reed Expo, transferred all the shares and signed a seven-year non-compete agreement with Reed Expo.

During 2008-2015, Icorrugated Media has created the industry's first online portal "Icorrugated Cartons" and has 70,000 subscribers till now

5 Famous Exhibitors Exclusively Support Icorrugated Expo 2017.



It is Icorrugated Media's profession and big influence in corrugated industry that got affirmation among corrugated market, and that's also why on Jun, 2016, Dong Fang, Fosber, J.S. Machine, TCY and Marquip Ward United made a joint announcement that they would give exclusively support to Icorrugated Expo 2017.

(Exclusively: only attend Icorrugated Expo 2017 during March-April, 2017)



Innovation, Profession and Concentration 80,299 Sqm Exhibition Area - Icorrugated Expo 2017

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Many innovations in Icorrugated Expo 2017, like focusing on intelligent manufacturing, special zone exhibition, multi-language guide service, 1,000 square meters global reception center, China-European International Technology Summit, International cocktail party and so on. After 16 years accumulation, Icorrugated Media has become the most influential media company in

China's corrugated industry. This exposition has got strong support from most corrugated manufacturers in China, and they attend Icorrugated in large area.

Top 30 Exhibitors of Icorrugated Expo 2017

Dong Fang Precision+Fosber | Auto Packing | Tcy | Ke Sheng Long | J.S. Corrugating Century | Mei Guang | Jin Chang | Kaituo-Nc | Justu | Shanghai Corrugated | Tai Yi Jia Jie, Ju Xing | Cheng Yuan | Yoco | Zhen Xing | Ned | Hong Hai | Jiu Feng | Kadar Marquip Ward United | Shang Yin, Yong Hui | Wam | Li Fei | Cang Hai | Hsieh Hsu Ji Xing | Sinovan | Fu Li | Yong Zhou

Update 1st December 2016

More than 150 exhibitors have confirmed participation in Icorrugated Expo 2017.

Total exhibition area 31,000 square meters.

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Up to now, Visitors from more than 30 countries and regions, including Thailand, India, Vietnam, Malaysia, Singapore, Myanmar, Russia, Indonesia, Italy, Spain, Poland, Greece, Egypt, South Africa, Saudi Arabia, Nigeria, Algeria, Argentina, Argentina, Brazil, the United States, Japan, Korea, Uzbekistan, Kyrgyzstan, Ukraine, Turkey, Belgium and so on, nearly 2,000 people have enrolled in Icorrugated Expo 2017 and could enjoy the above services.

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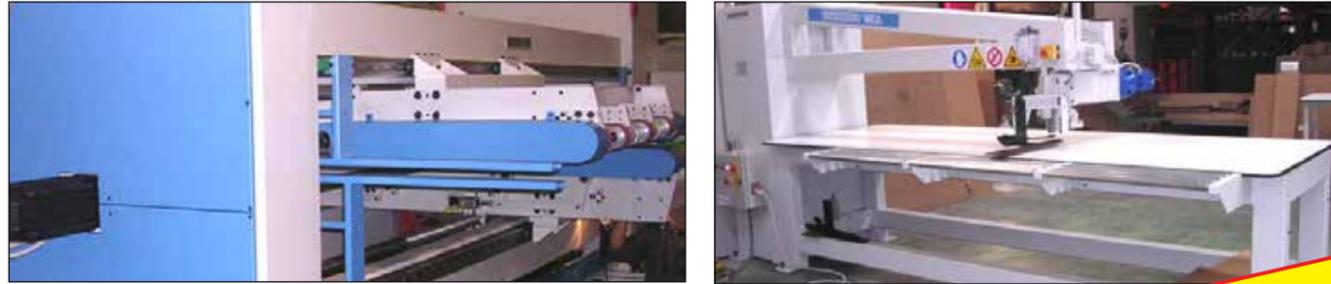
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FCBM News



SICBMA held seminars on 24th & 25th September 2016 at Shelter Beach Resorts, Chennai on the topics of "Packaging of Fresh Fruits & Vegetables" and "Enhancing Profitability in our Industry".

Shri R. Kollappan, Jt. Director, IIP and Shri Ramkumar Sunkara were the speakers.



Mr. Kollappan, Joint Director, IIP, Speaking during the Seminar on New Market Development.



IDFC - latest banking facilities for Micro, Small Scale Industries.



Speaker - Mr. Ram Kumar Sankara



Distribution of subsidy, Rs.10 Lakhs for China, Thailand travellers.



FCBM President Mr. N.X. George, visit to SICBMA Lab on 4th October.



IIP Technical Training Programme, SICBMA arranged concessional tariff for SICBMA members.



Students' visit to SICBMA Lab, to acquire more knowledge about packaging parameters.

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Panel Discussion



One of the Speaker's



This year's Symposium was yet another successful event organized by WICMA. Over 200 members and others participated as delegates.

Table Top Exhibition had 22 stalls. Besides vendors, IDFC Bank was one of the new Exhibitors.

Hotel Deltin Daman had an excellent ambiance. Mellowed Cultural Programme delighted the audience.

Elections were held for WICMA and the new team took over. Mr. Sunil Gupta was re-elected as President and Mr. Vinay Patel is the new Vice President.

The Technical Sessions and the Panel Discussion were very interesting and beneficial! Participants interacted with speakers and Panel Members.

One of The Technical Sessions was on a new subject 'Preventive Measures – Fire Safety' where speakers elaborated on how to prevent fire, how to ensure insurance cover and how to claim.

The other Technical Session was devoted to Improvement Measures in a corrugated plant.

Visit to Gayathrishakti Paper & Board Mills at Vapi, was yet another new initiative of this year's Symposium.



Lighting of Lamp



Inauguration of CORPEX 2017

Lifetime Achievement Award to Mr. Arun Goel





Corrugator Connect @ EcoTech, Guwahati

A Report - By Arpit Sanwaria (EICMA)

Ask your customers to be part of the solution, and don't view them as part of the problem.

- Alan Weiss

With this vision, EcoTech Paper mill invited corrugators from all over India to visit their plant on 23rd, September, 2016 for a visit to their Mill and an interactive session on the current scenario and the future prospects of the corrugation industry.



A group of about 80 people comprising of EICMA members including local corrugators from Assam, paper dealers, consultants graced the occasion helping in sharing the knowledge between Paper Mills & Corrugation Industry, and searching the way forward to a better future together. The delegation was headed by our EICMA president Sri Milan Dey.

We reached Guwahati around 8 am in the morning and were enthusiastically welcomed by Mr. Vikas Kradria from EcoTech who had arranged for a quick and comfortable transfer to Hotel Raddison Blu where a sumptuous breakfast was ready for us. With rooms already checked in we quickly freshened up and departed for the plant visit.

At the plant we were humbly greeted by Shri Bajrang Lohia, Partner and Mr. Pradip Jain, Working Partner of Ecotech.

The plant visit was lead by Mr. R. K. Verma, Vice President, Technical, who showed us the entire manufacturing process and quality check procedures with complete transparency and was happy to answer to any of our questions.



The state of art machinery, intellectual work force, stringent quality check practices and amazing house-keeping clearly displayed the mill's superiority and its hunger for unceasingly evolving and providing the best for its customers.



Apart from being well-heeled with cutting-edge line of machineries, the online GSM control devices, linear meterage markings on reel, size press for producing High RCT paper, 32 stage drier system were just few of EcoTech's prized possessions that you do not get to see in many paper mills. Their ample stock of raw materials and an extensive gamut of finished products ensures quick and uninterrupted supply to suit the diverse demands of corrugators.

After the visit and enjoying the lavish buffet lunch hosted by Eco Tech, there was a brief presentation by Mr. Pradip Jain informing us about the Lohia Group, EcoTech's parent company and various other leading brands under the group; the Journey of EcoTech Paper Mill, how it grew from barren land to a producer of 180 tons of paper per day in a short span of 30 months and the dedicated team responsible for this laudable success.

The presentation was followed by an interactive session between Team EcoTech, represented by Sri Pawan Rajput, Manager Quality Control, Sri R. K. Verma, VP, Technical, and Team EICMA represented by Sri Kirit Modi and Sri Ram Kumar Sunkara, with the entire audience participating in the deliberations.



The Session was chaired by Sri Milan Dey. The discussion raised important issues from using Gum Paper Tapes for joints to mentioning linear meterage in the Test Reports and helped EcoTech understand the customer requirements better as well as assisted the Corrugators to learn the new developments coming up in the paper industry and prepare accordingly to get better quality outputs at optimized costs.

Following the session, the attendees headed back to the hotel to get some rest and freshen up for a River Cruise & Gala Dinner on River Brahmaputra organized by Eco Tech.

The folk performance and musical band arranged onboard was a real delight. To top it up, the event was starred and bought to life by "sher-o-shairy", dance and karaoke by our own talented members.



The next day started early with a visit to the holy Kamakhya Devi temple. Post breakfast, an interactive conference was organized by EICMA. Over 100 Corrugators, representing EICMA, NECA, Paper Dealers and Eco Tech Paper attended the programme. Sri. Ram Kumar Sunkara made a presentation on "How to increase Margin in this cost competitive environment". Sri Sunkara, in his usual affable style held the audience in captivity for over an hour. His opinions were really informative on how we can optimize our profits by

improving our costing methods, reducing wastage, better financial management and many more detailed suggestions. This was followed by panel discussion - WhatsUp in the corrugation industry. Moderated by Sri Hemant Saraogi, Past President of EICMA, the panel included Sri Bajrang Lohia, Partner of EcoTech Paper, Sri Kirit Modi, Senior member of EICMA, Sri Bharath Kedia, Past President and Excise & Taxation Committee Chairman of EICMA, Sri Aditya



Agarwal, EICMA member from Guwahati, Sri Mahesh Jalan, EICMA member from Patna, Sri Anil Agarwal, EICMA member from Siliguri, Sri Mohit Bajaj, Managing Committee Member of EICMA and Sri Milan Dey, EICMA President. The discussions ranged from - the viability of huge investments made in the Corrugation Industry, the co-existence of Auto and Semi-auto Plants, the possible impact of the upcoming GST, the need to collaborate and exchange ideas regularly with Paper manufacturers to the advantages of joining EICMA/FCBM. Sri Saraogi ensured that the audience participated fully by making the discussions open to all.



The vote of thanks was given by Mr. Bharat Kedia, who rightfully said that words were not enough to thank Team Eco Tech for such warm hospitality and their wonderful initiative. He thanked Sri Mohit Bajaj who gave his precious time in co-ordinating between EICMA members and also Sri Manmohan Saraogi, Sri Aditya Agarwal, Sri Pradip Arya, Sri Nitesh Jain and the entire Corrugation fraternity for lending their extensive support locally in organizing the conference and also helping our association grow stronger by bringing new members to our association.

"Coming together is a beginning. Keeping together is progress. Working together is success."

- Henry Ford



Contd. on - 64

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Lighting of Lamp



Inaugural Address



Mr. Gagan Kapoor, President, HPCBMS

much-awaited show of industry, all the messy hours' image just got vanished and that time I just exclaimed with the word "WOW".

Trust me, Hosting such mega show when you are completely tied up with business commitments, political career and family responsibilities seemed little impractical to me initially, but pivot motivation behind hosting and organizing this show

was to make my entire HP corrugated team recognized on the National & International arena and to get the world around acquainted with the innovations being made in and around the corrugation industry of Himachal Pradesh, Punjab & Haryana.

My proximity with FCBM Members has always won me accolades and receiving the host status for 45th Conference of FCBM



Welcome Address



Thematic Address



Address by FCBM President - Elect



Presidential Address

Phenomenally relaxed now but this was not the situation when my TEAM HPCBMA was handed over with responsibility to conduct 45th Conference of FCBM. Lots of hard-work and time both have been invested by my entire team and it has been entirely a roller-coaster ride during the time; we had enjoyed an amalgamation bunch of feelings during the planning and execution of show and that helped us in developing an inexplicable and striking connection linking all of us mentally and emotionally for life now. And when I checked the number of registrations turned up for this



It was 'House Full' Section of enthusiastic audience



Keynote Address



Inauguration of Corru Show India 2016



Harlalka Award



B.K. Dosbi Award



Corrustar Award



Lifetime Achievement Award



Memento Presentation



Release of Souvenir



was one of them, as this had been offered to us observing the persistent and multi-dimensional functioning of the team. And I am overwhelmed and thankful to FCBM and my Team who stood always there as a support system to make this show happen successfully.

Prefect Preparations

Lots of preparations were made to make the travel and stay of all the delegates and their families a comfortable one. During their stay, tour plans like Shimla-chail, Mata Vaishno Devi (the most famous religious place of Himachal Pradesh), Chandigarh City Tour and much more were planned for them. Every detail of

Conference was well supervised and screened by Mr. M.L. Agarwal, Mr. Anil K. Reddy and Ms. Indumathy pre and during conference. I owe a lot to this trio in a big way. Undoubtedly Mr. M.L. Agarwal and Mr. Reddy have been the strongest pillars of the show. And a great deal of planning and execution was equally invested in the designing of Exhibition hangers, stalls and the placement of the heavy-load machinery. Moment I entered the exhibition hanger, my hands just got raised by themselves in appreciation for my team wholly lead by Mr. Aditya Sood.

If we look at the complete planning and execution of this show, one person who

worked diligently and all behind the curtains was Mr. Sushil Sood, who put his ideas forward with conviction. Team HPCBMA is highly thankful to him for all his support.

Inauguration

Three-days Conference was inaugurated by Shri Mukesh Agnihotri, Cabinet Minister for Industries, Labour and Employment, Information and Public Relations and Parliamentary Affairs. And he promised us roping in his personal efforts for the further development of Corrugation Industry which was further very exhilarating moment for the team.

Contd. on - 70



Managing Committee Meeting



Day 2. Chief Guest His Excellency Shri Acharya Dev Virat ji Governor of Himachal Pradesh on the dais



Lighting of Lamp



Governor's Address



Presentation of Mementoes to Exhibitors



Motivational Talks: Swami Param Tegji & Pujya Swami Gnan Vatsalji



Memento Presentation



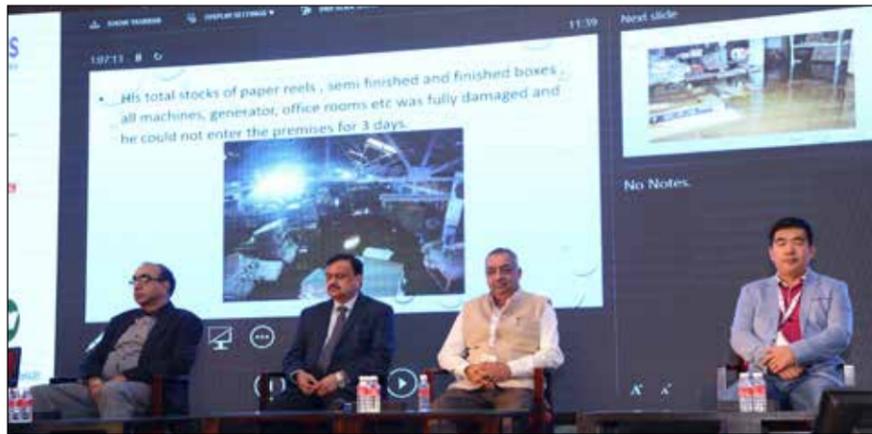
Corru-show India 2016, a concurrent show to 45th Conference of FCBM was inaugurated by Shri Surendra Nath Tripathi Ji, Additional Secretary and Development Commissioner, Union Minister of MSME, GOI and addressing the audience there, he promised to open up two new Technology centers in Himachal and Haryana each.

DAY - 2

His Excellency Honorable Sh Acharya Dev Vrat Ji, Governor Himachal Pradesh graced the occasion with his grand presence as CHIEF GUEST on the Second day of the Conference and addressed the audience while confabulating much elaborately on industrial developments of the state.

CORRU - SHOW

Fortunately, Corru-show has also been received very well by the exhibitors and visitors here during the tough time of unexpected Demonetization issue. 80+ Exhibitors from all across the globe made their presence and 30+ live machinery were put on display. Delegates and Business associates were astonished to witness the splendid mélange of technology and development in terms of Machinery, innovations and techniques that we are implementing in our units at Himachal, Punjab and Haryana. They have decisively included North India in the ambit of their future potential business plans.



Change of Guard



Felicitation of Shri Greesb Sardana



Fashion Show conceived by Mr. Dbarmendra Pandya

Actually there has always been a perception that Himachal Industry is all manual irrespective of the fact that most of the plants have been transformed from manual to automated plants; But during their visits to few corrugated plants, this perception of the industry people has changed completely and now they have their own plans to open new business avenues in and around Himachal.

At this Conference and Corru- Show, where the business talks swayed the major time of the industry people during daytime, Entertainment by the renowned singers during the evening After-parties offered the relaxing moments to all. Prominent personalities of FCBM and all Regional Associations were felicitated by HPCBMA in a graceful manner during

all three days of Conference. Here I would convey my special thanks to the presidents of all Regional Associations who contributed remarkably in the execution of the show with their whole-hearted presence and participation throughout the show.

TEAM FCBM 2017



Gresh Sardana
President



Pradip Bosmaya
Vice President - I



K. Arunachallam
Vice President - II



Bharat Parekh
Hon. Secretary



Vinay Patel
Hon. Treasurer



N. X. George
Ex-Officio

To recognize Excellence in Corrugated Packaging, Corru-star awards were awarded to the winners in different six categories.

Technical Sessions

Technical sessions and showcase talks by the renowned speakers of the industry were the most important aspect of this conference; they threw light on the various technical and related issues prevalent within the industry.

Future Box being the main theme for the conference, Mr. Milan Dey held the reins for the very first technical session that was further followed by Mr. Thomas Andersson, Mr. Urban Andersson, Mr. Graham Racey, Mr. Hongfeng Sha and Mr. Peter on various topics.

Second Technical session was initiated by Moderator Mr. Ankit Aggarwal and the list of speakers was as following: Mr. Avtar Singh Matharu, Mr. Barun Banerjee, Mr. AK Chatterjee, Mr. Anil Gulati, Mr. Sachin Chandsarkar, Mr. Akshay Jain, Mr. P.S.R. Prasad, Mr. Anders Isaksson, Mr. Chiran Shastry. And the show talks on the second day of the conference were conducted by Ms. Sinsia Xing, Mr. Bian Yan Qing and Mr. Miao Shijia.

And the last day witnessed the technical session on "Natural Calamities-Prevention and Protection" that was well moderated by Mr. K. Arunachallam having Mr. Rajiv Gulati, Mr. Karunakaran, Mr. Baolin ZHAO, Mr. H. V. Tiwari and Mr. Jain on the speaker dais.

Apart from these technical sessions, Motivational Talks by Swami Param Teg ji from Art of Living and Pujya Swami Gnan Vatsal ji were fondly paid attention by present audience.

Fashion Show

Models proudly displayed apparels made from Kraft & Corrugated board.

The Fashion Show by Mr. Dharmendra Pandya – the designer par excellence took the participants into the realm of fashion and fantasy.

After seeing this larger-than-life event happening in reality, I would love to thank Chairman Conference Mr. Mukesh Jain for managing everything at the conference from day one to the concluding day. He is a man of words and always fulfills his commitments with complete authority in his command and generosity in his demeanor. And this is what he did at the Show too and result

is in front of us- A GRAND SUCCESSFUL CONFERENCE BY HPCBMA.

On the last day of the conference, while bidding adieu to my pals, I was full of emotions but I am sure that this farewell to the delegates will mark the beginning of new phase in our industry development.

And yes of course I would like to thank few of the most important people of my trustworthy cavalcade, who worked ceaselessly on and off-screen day night to see this event happening on grand level. My hearty thanks to

Mr. Devender Sehgal: Past President, Mr. Hemraj Chaudhary, Mr. Rajiv Gulati, Mr. Daulat Ram Thakur, Mr. Rana, Mr. Manoj Bindal, Mr. Anirudh Aggarwal, Mr. Hariom Khanna, Mr. Ajay Chaudhary, and last but not the least Mr. Aditya Sood, Mr. Ramesh Sharma, Ms. Damini and Ms. Zeena Aggarwal.

GAGAN KAPOOR
PRESIDENT HPCBMA

If we evaluate the show as per the statistics, numbers speak volumes

1500 Exhibition Visitors | 800 Registrations | 80 Exhibitors

30+ Running Machinery on Display | 25 Mega Event Partners

Huge Coverage in leading Newspapers

Grants and Aids for Industry Development by Government Authorities.



Event Statistics

- Corru-show India 2016 was inaugurated by ADC, MSME, GOI Shri Surendra Nath Tripathi.
- 45th Conference was inaugurated by Shri Mukesh Agnihotri, Cabinet Minister for Industries, Labour and Employment, Information and Public Relations and Parliamentary Affairs.

- Acharya Dev Vrat Ji, Governor Himachal Pradesh graced the occasion with his presence as CHIEF GUEST on the Second day of the Conference.
- More than 5000 Visitors travelled down from all across India and Globe to witness the much sought-after event of the Corrugated Industry.

- Show was attended by the who's who of the industry and it proved a lucrative platform for all the participants and audience present there in one way or other.
- Corru-show India 2016, a concurrent exhibition on Corrugated Paper and related Industries attracted visitors from in and around Punjab, Himachal Pradesh and Haryana and other parts of the globe as well.
- Technical sessions, show case talks by the renowned speakers of the industry threw light on the various technical and related issues prevalent within the industry.

Brands Associated with the show were benefitted:

- To maximize their brand exposure among the target audience.
- To create an increased awareness and positioning of their brands within and outside industry.
- To meet high-end and net-worth audience.
- Having great atmosphere for engaging, brand building, Networking and establishing business alliances with new Clients from Himachal Pradesh, Punjab, Haryana and nearby areas. In total, a thorough customized event to best meet their marketing objectives.





Quality and Productivity

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The quality module with positive effect on the productivity

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- Paper gap control
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- End of roll splice
- Splice synchronisation
- Master roll splice
- Splice tracing

For any query, please contact :

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

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

Figures Speak for Precision and Performance !

- Over 50 Years of Experience in Corrugated Packaging
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- Over 15000 Equipments Supplied in India
- Over 200 Equipments Supplied in International Market
- Over 7000 Satisfied Customers in India and Overseas
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Other Equipments available

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

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

Box Compression Strength Testers



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

Available in:
UBC1M/1T - Digital Model
UBC1M/1T-P - Microprocessor based Digital Model
UBC1M/1T-TS - Fully automatic with computerised touch screen control panel Model

Bursting Strength Testers



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

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

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

Crush Tester



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

Available in:
UCR - Digital Model,
UCR-P Microprocessor based Digital Model
UCR-TS Fully automatic with computerised touch screen control panel.

Conforming to National and International Standards

Puncture Resistance Tester

Gives reliable indication to evaluate fabrication factors along with material values in a composite fashion.

Available in:
UPR - Analogue Type
UCR - DIGITAL
 Microprocessor based Digital Model



COBB Tester

Determines water absorption/penetration (cobb value) of paper and paperboard as specified in standards.



Model: UCOB

Substance Indicator

Measures directly substance of paper, paperboard and other materials in terms of G.S.M.



Caliper Thickness Gauge



Measures Caliper thickness of variety of materials.

Available:
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 With 10mm capacity and least count of 0.01 mm
UCTG001 & UCTG001-D
 With 1mm capacity and least count of 0.001 mm
UCTG002-D
 With 20mm capacity and least count of 0.001 mm

Internal Ply Bond Tester



To Determine the Internal Bond Strength of Paper, Board and Laminates

Model: UIBST Microprocessor based Digital Model supplied with Sample Preparation Station as per the standards.

Sample Cutter



Model: USC for preparing various paper samples for GSM, RCT etc...

Introducing PAPER MOISTURE INDICATOR



Moisture content is most critical parameter in Paper, Paperboard, Corrugated Board, all Paper products, Solid fibreboard etc... UBIQUE Paper Moisture Indicator is an ideal equipment to determine percentage of Moisture Content Present. UBIQUE has introduced a reliable latest technology and equally trust worthy as other UBIQUE testing equipment.

Product Code: U2100

Crush Tester – Signature Model



UCR-TS-SN

Our Signature Model Crush Tester is the most advanced Crush tester offering the widest range of crush tests. The new customized Operating Interface offers unparalleled features for the for the delicate tests on the machine.

The machine offers the following tests:

- Standard Tests:**
- Ring Crush Test of Paper
 - Flat Crush Test of Corrugated Board
 - Edge Crush Test of Corrugated Board
 - Operator Defined test (Customizable test)
- Optional Tests:**
- Corrugated Crush Test (requires Sample Fluter)
 - Corrugated Medium Test (requires Sample Fluter)
 - Pin Adhesion Test
 - Score quality Test

Short Span Compressive Test (SCT)

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

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

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



Product Code: USCT

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Board Defects; effects on downstream production.

Something that still is a pleasant surprise when I am running an additive trial, is to hear someone from the conversion department say; "I don't know what you guys are doing on the corrugator, but the board is looking great. We had an excellent shift last night."



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



Finishing equipment, particularly the feed section, is sensitive to board quality. Newer presses like the Evol, the Hamada or the DRO die-cutter are even more sensitive to substandard board because of the speeds at which they run. Just as an exotic car needs a smooth road to reach its top speeds, a high tech flexo needs good board to achieve its potential production rate

Detection

Defects in finished board are generally very difficult to detect in the stacks at the presses and are usually not noticed until

the board has problems running through the converting equipment. Even if the problem is found, it is very difficult to remove individual sheets from the stacks. Obviously the goal should be to produce board without any defects, but if bonding problems do occur, the defective sheets should be culled at the corrugator.

Cost

The further along any manufacturing process we travel, the costlier that waste becomes because we have added more cost to the product. This additional cost not

only includes raw material, but also labor and energy. It is not just the ink in a finished box that makes it more expensive, it is also the labor of the operator and the energy cost of running the piece of converting equipment (electricity, compressed air, lighting). We have also used consumable items on the finishing equipment, things like anvil blankets and printing plates which have an established service life and are part of the cost of the finished product.

Delamination

Delamination of any type can cause issues with converting equipment, but edge delamination can be particularly problematic. Board with a marginal bond on the edges may appear to be acceptable when coming off the corrugator, but once it has dried and is subjected to the manipulation of the folding rails it can pop open causing jam-ups in the flexos. Even





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

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worse is when you don't catch this problem in your plant and it is your customer's case erectors that make the board delaminate. Inspecting the board exiting the corrugator and having Pin Adhesion values checked regularly will help identify problems with brittle bond.

Washboarding

Excessive adhesive application will usually cause washboarding, particularly with lighter liners. This uneven board surface will make it difficult to get even printing. Operators will often resort to increasing printing pressure to get even coverage. This may crush the board and reduce its mechanical properties, particularly ECT and BCT.



“Washboarding” Board with an uneven surface will not print well.

Warp

The traditional belief was that lead edge feeders tolerated a small amount of down-warp and that converting equipment with kicker type feeders tolerated a small amount of up-warp. While this is true to some extent, it does vary from machine to machine. The goal coming out of the corrugator should be to produce for the flattest board possible. Less than 2% of length (20 mm per meter) is typically considered an attainable goal. Remember that in most cases the board will be run through the converting equipment perpendicular to the direction it ran on the corrugator, so side to side warp becomes end to end warp.

Post warp

Board that exited the corrugator flat, may warp later as it waits to be converted.

Having the board exit the corrugating process with a high enough temperature will ensure that board is dry enough to stay flat. Board will continue to lose free moisture after it comes out of the corrugator and may change its warp profile if there is a significant moisture unbalance. The goal is to produce board with a balanced moisture content that will be stable. Excessive adhesive application is often a contributor to post warp.

Blisters or wrinkles

These can be a particularly pernicious problem because often they occur in the center of the sheet and thus present few indications of their presence when the board is in stacks. Singlefacer operators will often detect the defect as the web goes up onto the bridge. Blisters at the doublebacker, though less common will usually only be detected by a vigilant stacker operator.



Routine board-moisture checks should be implemented to ensure board moisture controls are kept within desirable levels.

In addition to productivity and waste goals, one of the primary objectives of the corrugator, should be, delivering top-quality board to the converting department. Flat, well-bonded sheets that are free of defects will greatly improve the productivity and waste of the converting equipment by reducing jam-ups and lost time.

Board Moisture

Wet board has less flat crush strength and may be crushed during the converting process. Flatbed die-cutters have particular difficulties obtaining a clean cut on board that is wet.

By contrast board that is too dry will have problems in flexo folder gluers, because the scores have tendency to crack.

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

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Packaging for distribution in India: Why it needs to be robust?

Packaging consultant, Kevin Howard, during his 17-year appointment with HP, visited India to investigate why HP printers and the packaging routinely failed in India. Interestingly enough, it suffered very little damage in the rest of the world. This case-study uncovers the hazards of the Indian distribution and logistics pipeline.

Kevin Howard
Packaging and testing consultant



Are your boxes ready for this? Many products depend upon bicycle rickshaws and open tuk-tuks for the last mile of delivery, even if it's raining



Hewlett-Packard is the largest manufacturer of inkjet printers in the world. I was the senior packaging engineer for HP for over 17 years, before leaving and starting my own consulting company in 2005. HP saw great opportunities for selling products into the Indian marketplace and decided in the early 2000s to increase sales by bringing a very low-cost printer to the market, one which had been selling worldwide by the millions since 1999. This particular printer was small, light weight, and had successfully shipped to dozens of countries, along with significant sales through the internet, meaning they had been shipped as single units in very high quantities, and yet suffered an extremely low damage rate everywhere. As a result, it was quite a surprise to find failure rates about 100 times higher in India than the

worldwide average. The first thought by many was that material handlers in India must have been dropping this printer from higher drop heights, and be doing it more often, than any other supply chain. Some people suggested that we should change the internal cushioning from moulded EPS (expanded polystyrene, which is the least expensive type of foam), to PE (polyethylene, which costs 2-3 times as much), and perhaps increase the size of the box to accommodate more cushioning. Either increasing the cost of materials or increasing box size would have added up to millions of dollars of extra costs.

Whereas many companies may jump to conclusions and attempt to fix problems without knowing as much as they should, HP took a different approach. Questions that came to mind included:

1. What exactly were the types of damages being experienced?
2. Had we ever seen that type of damage in our laboratory testing?
3. What was the root cause of the damages?
4. If we were to simply believe that more or better cushioning was needed, what laboratory tests should we verify it with?

After all, the current packaging passed our current tests, so it wouldn't make sense to simply subject new/improved packaging to the same test. Good laboratory testing is able to replicate consistent failures found in the field, but so far, HP hadn't been provided good data on what the problems actually were.

With the above questions in mind, I set off for India in September 2003. The plan, over a span of two weeks, was to visit a variety of sites in and around Mumbai, Delhi,

Contd. on - 87

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Super Model



Micro Print Model



ECO Digi Model



Double Head Model

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Models :

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



GSM (Substance) Tester

Electronic model with 5 sample size measurement



Gann Moisture Meter

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

Compression Tester



Winner of Pacmachine 2008 Award

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.

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- Micro Print PC
- Micro Print (Microprocessor based Model with Printer Port)
- Micro Digital
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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.



Drop Tester

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



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.



Vibration Tester

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

Box after shower test.

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- Superior water-proofing properties
- **Non toxic, food grade**
- No change of properties between (-)45 deg. C to 150 deg. C.
- **Environment friendly - The coating is bio-degradable and coated paper can be recycled directly**
- Coating is flexible - does not crack on folding

Comparative Properties:

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

Applications:

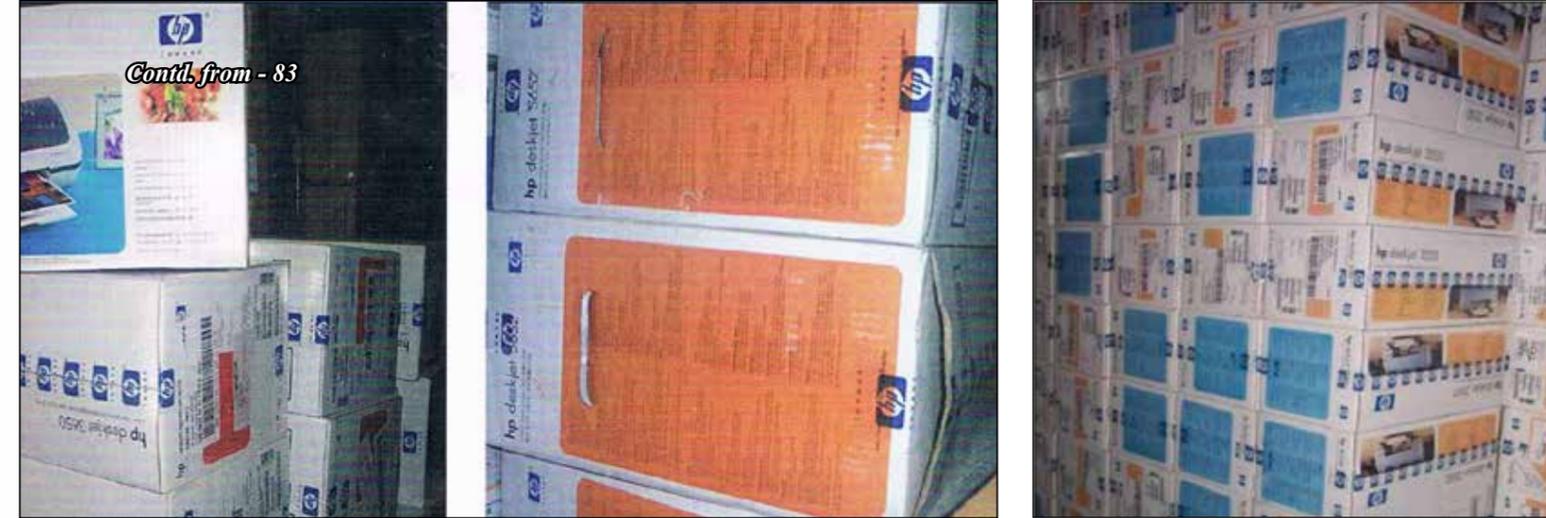
- Water proofing of corrugated boxes for packing of :
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 - Tea, ice cream, butter, milk powder, paneer, cheese, Dahi.
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Boxes stacked on their sides can't support compressive load and there is straining of tapes

Lucknow and Bangalore, seeing a total of 22 different kinds of warehouses and distribution centres for HP, distributors, freight forwarders, wholesalers and retailers, along with many stores, and attempt to better understand why some HP products had very little damage while this particular printer had extraordinarily high failure rates. Afterwards, return home, initiate new tests that replicate the consistent failures found, then develop new designs that pass those improved tests, implement the new designs, then return to India in a year to see how the new designs are performing.

What we found

First, the stories were true. This inexpensive inkjet printer had far more apparent damage to the packaging and the product than any other HP product travelling in India and exhibited damages not seen anywhere else in the world. Were our qualification tests lower than other HP product lines? Were our products more fragile than others? Was the packaging really not as robust as that used by other product lines? The answers surprised us...

Anyone who ships products through India should know the following about why it might be one of the harshest supply chains in the world:

Climate: Heat and humidity can be extreme. In June 2003, three months before I arrived, there was a three week span where temperatures hovered between 115

to 125 F in portions of the country. During my stay, it was commonly in the more than 90 F to low triple digits, with 90% humidity. High temperatures and humidity degrade paper-based packaging, such as corrugated boxes, but it also affects the varnish used on the outside of boxes. Many products depend on bicycle rickshaws and open tuk-tuks for the last mile of delivery, even if it's raining. Are your boxes ready for that?

Dust: We found deposits of dust everywhere throughout distribution, homes and businesses, coating the outside of boxes, but also the inside of products. Dust acts like sandpaper: if boxes are vibrating against each other in the back of a truck, and dust particles are between the boxes, then abrasion occurs. Have your bare products been tested with a coating of dust? I'm a great believer that engineers can design almost anything, but only if they know what they must design for.

Though all HP products arrived into India on pallets, virtually all products were stripped off of pallets once they left the main distribution centre. From then on out, all products were handled one at a time, in every warehouse and every truck.

Without pallets and unitisation, the only way to stack boxes beyond arms' reach is to step on top of other boxes. Were your boxes ever tested for being stepped on? Our's weren't. Also, in depalletising everything, boxes are commonly turned onto their broadest face, even though the corrugated

fluting is then in the wrong direction. If the flaps aren't at the top and bottom of a box that is supporting a compressive load, then the tape holding the flaps shut becomes an important component in surviving compression.

Infrastructure: More developed nations have extensive networks of paved roads in good condition, along with modern trucks. Many countries in Asia, such as China, Malaysia, Thailand, Singapore and others, have improved infrastructures to help commerce be more efficient. China, which built its first 33 miles of freeway in 1987, now has over 70,000 miles of freeway, which is slightly more than the US. In contrast, India has about 800 miles of expressway. Not only are the vast majority of roads in India sub-par, but the trucks lack the softer rides found in places that have better roads. The combination of bad roads, long distances and poor trucks add up to intense levels of vibration not found in most other large economies.

Supply chain taxes: India has a unique system of taxing products that enter large cities, even if those products are ultimately then shifted to some other city to meet customer demand. As a result, the largest distributors and wholesalers have been forced to set up warehouses both at the outer edges of metropolitan areas (to avoid paying a 5-6% tax) and then other warehouses within the city to hold onto fast moving products. Due to the extremely slow roads, let alone the



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3ad Singapore pallet – thinner and fewer boards



time it takes to pack a truck one box at a time vs a full pallet at a time, they need to have these different piles of products. If the extra tax didn't exist, there'd be fewer warehouses and fewer handlings. Prior to the first trip to India, the HP supply chain manager provided a supply chain map, which should have been indicative of the number of handlings the products would be exposed to. Only by observing first hand how products moved through the country, did we discover this excise tax and additional movements from one warehouse to another, let alone additional tiers of the supply chain.

Labels: Other than the main HP distribution centres, virtually no one else used electronic scanning to receive products

step stools; virtually no palletisation/unitisation, thus greatly increasing the number of individual handlings of each product, and having no protection from stretch wrapping that is normally found on unitised loads; road vibration levels that are unparalleled for intensity due to rough roads and poor truck equipment, with boxes bouncing around unfettered, experiencing dramatic impacts from potholes and rough roads. But, even with these difficulties, why did one particular product experience far more damage than others?

By observing first hand how products were being handled, and seeing that some products had virtually no problems while mine had consistent problems,

and account for their movements. Instead, people wrote on clip boards what came in, what left, and where it was sent. Every stop along the way would apply a new label on one of the end panels of the box. Is your box ready for lots of labels, thus covering, perhaps, important marketing and product information?

Surprise discoveries

Clearly, the supply chain in India is difficult: extreme levels of temperature, humidity and dust; compression compounded by people commonly stepping on boxes used as

I also noticed one other detail: 100% of the problematic printers came from just one manufacturing site in Thailand. Was that a coincidence? No! It turned out this site was not using materials specified on the engineering drawings. For instance, pallets had fewer deck boards, and used thinner wood, than was specified.

As a result, the corners of boxes fell within the gaps between boards, thus dramatically reducing their compression strength 30-50%. Also, with fewer boards, when a forklift picked up the load, the deck boards bowed upwards, causing boxes to crease mid-panel, from the bottom up, thus further reducing compression strength of the box. We also discovered this factory was using thinner outer liner on boxes than required, along with sub-par varnish. In contrast, HP boxes from other sites used heavier paper weight and more robust, shiny varnish. We conducted testing in our laboratory on Thai-made boxes and successfully replicated the vibration problems seen in India. By establishing the correct vibration input for stacked boxes rubbing on each other, we then made this new test the base line for future products going to India. We also established a rub test for the varnish. We discovered the standard ASTM D-5264 rub test was vastly insufficient to replicate the problems seen on a wide scale basis in India, so we increased the loading and the number of rubs for future varnishes to surpass.

We also discovered that the tape used on these boxes was not what we had specified. Though it looked like tape, the quality was significantly lower than the 3M tape we had expected. The Thai tape broke easily on impact and came loose when the box was turned on its side and compressed, forcing the flaps outward. Once we saw that virtually 100% of boxes are turned onto their broadest face during distribution, we realised we needed to test and design for this condition. Simple improvements to the pallet, tape, varnish and box material completely eliminated all of the problems we had witnessed in India.



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Do you remember what was said at the beginning of this article about the initial reaction to damages? Where many thought it must have been because of high drops and more of them? In two weeks of travel in 2003, and then a return trip a year later, I never witnessed even one printer being dropped. I'm sure that drops do occur, but I don't think it's a major reason that contributed to the high damage rates seen initially. Ultimately, we did not change the cushioning material or the box size, and yet damage rates dropped to the worldwide average.

Recommendations

Very few companies actually know how their products are handled and what types of damages consistently occur in distribution. Some companies attempt very expensive and time-consuming measurements of the distribution system, believing they can use data acquisition recorders to capture the shock, vibration, temperature and humidity conditions their products are subjected to. These data systems do a very good job of recording events, and especially events that are continuous, but they're terrible for defining drops, which happen only occasionally, and never record compression, which was a leading cause of failures for the HP products. Even if drop impact was the main problem someone wanted to record, it would take hundreds of product recordings to find the input levels leading to the damages in the field. In contrast, with direct field observation, it becomes rather obvious, in very short order, what the consistent problems are and the root causes of those problems. First-hand observation also allows something very precious: understanding why other products are not failing similar inputs. From my perspective, damage replication in the lab is the fastest and best method for reducing damages and overall costs.

I have travelled all around the world following products through supply chains. No two products are exactly the same,

and their supply chains certainly aren't exactly the same. I had an experience where large screen TVs from Asia were coming to the US. One manufacturer was having far more damages than another, even for the exact same size TVs coming from the same Asian country and into the same distribution centre in the US. How could that happen? It turned out that one arrived on slip-sheets and the other on pallets. My client didn't have the slip-sheet equipment, so used clamp trucks to pull those large sets off the ocean containers, while the other products on pallets were simply lifted off with forklifts. The clamping onto the screen face caused the damage. My client then ordered push-pull equipment for their distribution centres. Though my client was obviously a part of these warehouses, it was only through my direct observation that the problem was identified. The client had initially assumed the sets must have been lower quality than their competitors' sets and believed the damages must have happened on the way to the US, but the reality was that they had caused the damages themselves.

Once consistent failures are identified, it's important to establish laboratory testing that replicates the failures, using the least amount of input possible. For sophisticated electro-mechanical products, I like to establish bare product fragility parameters. Understanding how components fail from shock and vibration can often lead to lower cost solutions than increasing the cost of throwaway protective packaging. Once damages are replicated in the lab, then this new test must become the baseline for future products and packages to survive.

Finally, as seen in the India study, one should verify if all materials are to specification. The poor material used was a total surprise, but in investigating it further, there was an altruistic explanation: people who didn't know better, were simply attempting to reduce material costs. I love the idea of reducing costs, but doing

so without verification testing can lead to extraordinarily high failure costs.

If you distribute products worldwide, and you use only one package design for the entire world, and you have no damage when shipping in India, then this is a clear indication that you are wasting money on excessive packaging for products going to the US, Japan, Europe and perhaps many other places. My printer boxes for India had to increase their compression strength compared to the rest of the world, but sales in India were a small fraction of the overall sales. Increasing costs to survive specific distribution inputs makes sense... it's cheaper than high damage rates... but it makes no sense to foist those additional costs onto products that don't need them.

Kevin Howard is a packaging and testing consultant. Howard has extensive international experience, has Bachelor of Science and Master of Science degrees in Packaging from Michigan State University, has taught at both Michigan State and in China's first school of packaging, The Northwest Institute of Light Industry, and has worked for nearly 50 companies, reducing costs by the tens of millions of dollars for his clients. Kevin was the ASTM (American Society of Testing and Materials) chairman for 20 years on the task group for Vibration Testing of Packaged Products, D-999, and sits on the ISTA (International Safe Transit Association) education committee.

This feature was first published in PRINTWEEK INDIA.

The author, Kevin Howard can be reached at kevin.howard@packnomics.com and the LinkedIn profile is www.linkedin.com/in/kevin/howard



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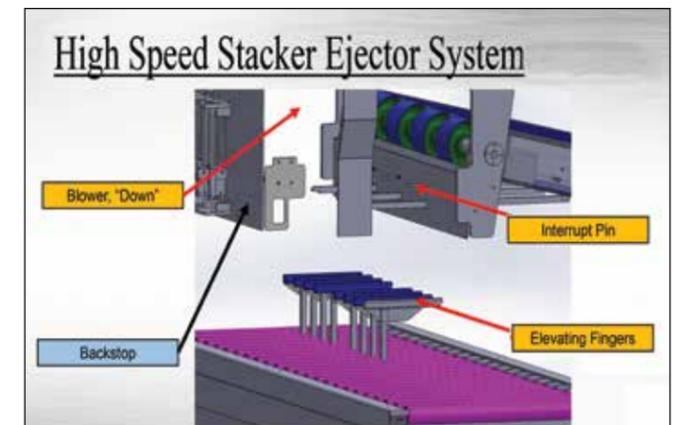
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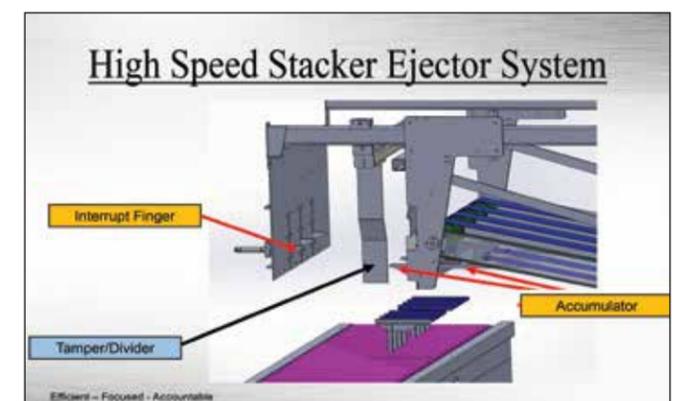
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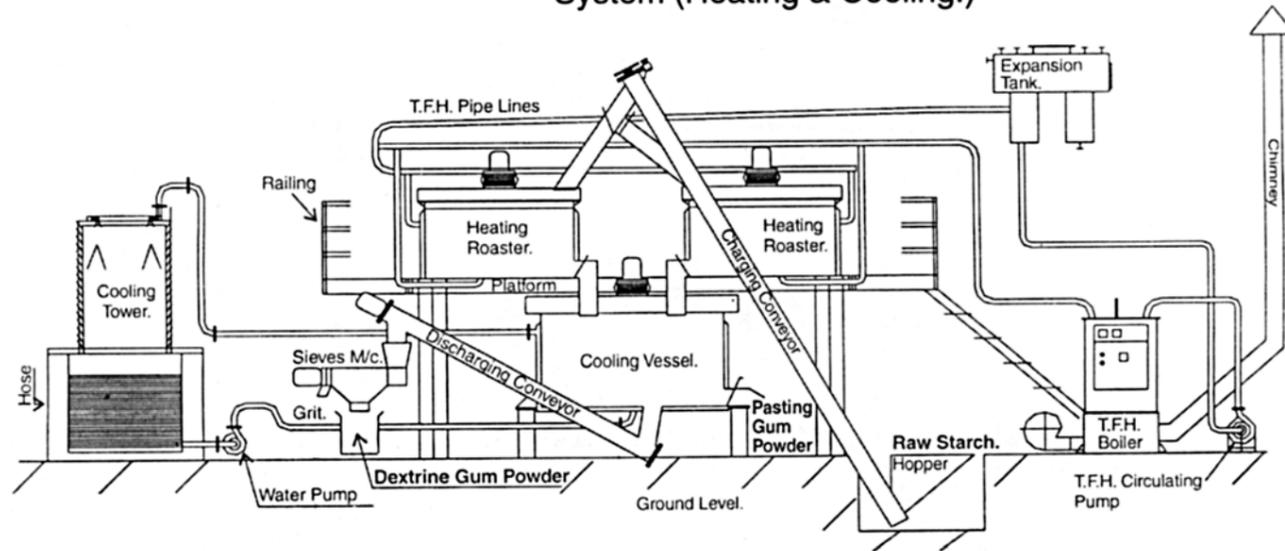
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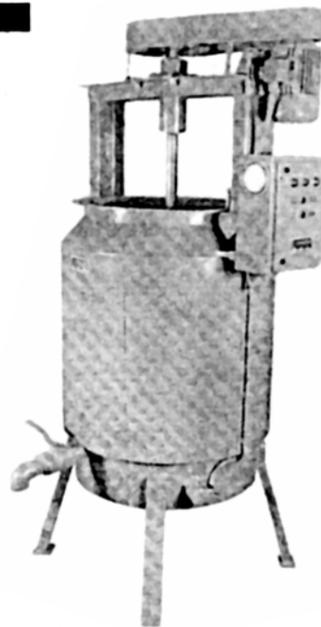
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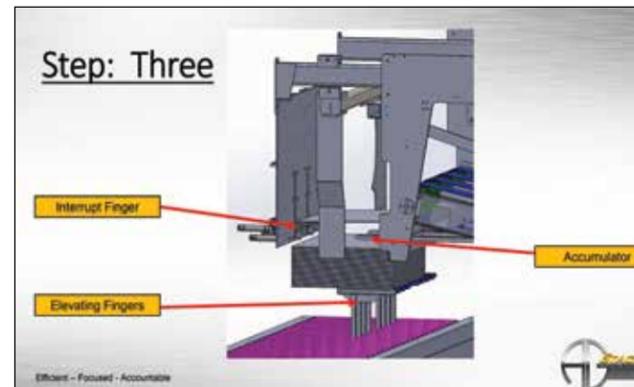
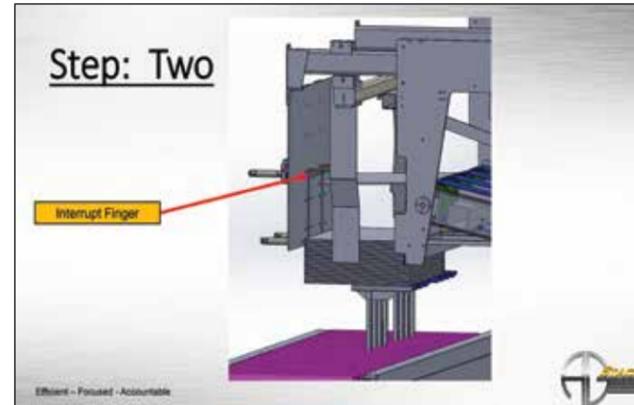
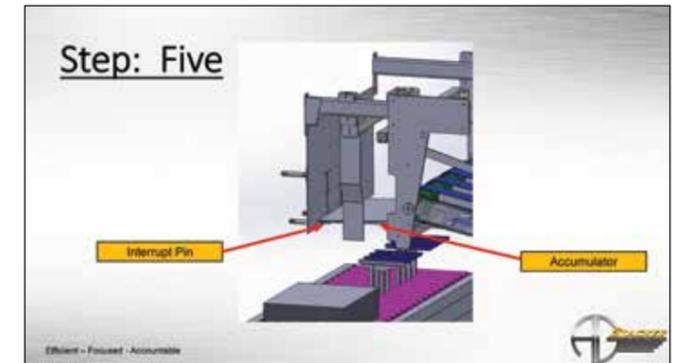
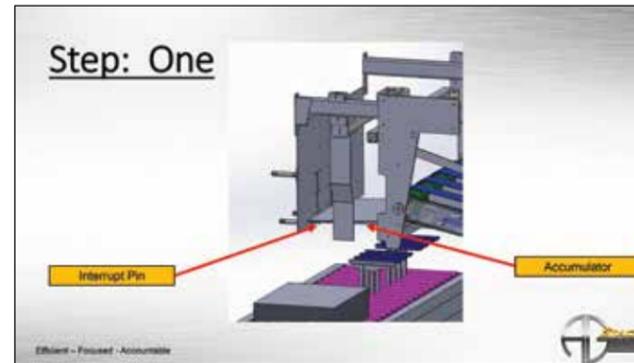
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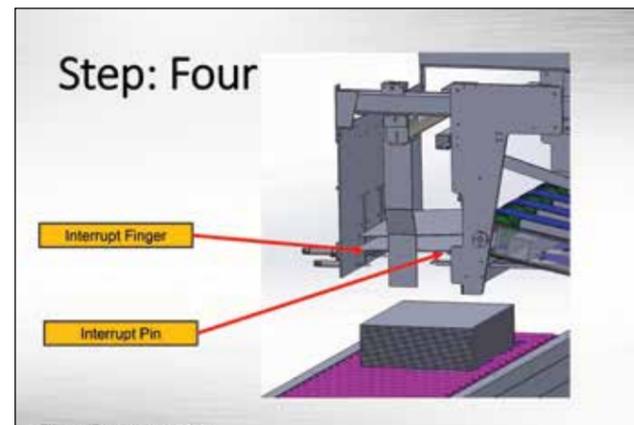
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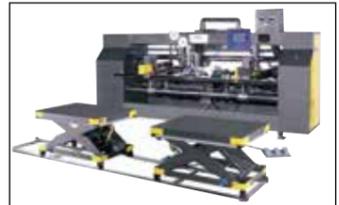
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Prompt Services are assured

Method Of Preparation

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

Technical Specifications

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

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

Results

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

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

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

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Industry News

FBA teams with corrugated industry suppliers To promote the corrugated packaging industry

The Fibre Box Association (FBA), a non-profit trade association representing North American manufacturers of corrugated packaging. Is pleased to announce its partnering with corrugated industry suppliers to launch a five-year Corrugated Industry Promotion Program beginning in January 2017.



The purpose of the Corrugated Industry Promotion Program is to enhance, elevate and change perceptions toward the corrugated packaging industry and its products. The program will inform target audiences about the benefits of corrugated packaging and will correct misinformation that exists about the industry. The program will recognize that the overall health and well-being of the industry is important to both manufacturers and their suppliers.

To launch the program, FBA reached out to a select group of leading industry suppliers who it felt were best positioned to help focus attention on the industry effort. Suppliers who have pledged to support the program include Amtech, BHS Corrugated North America, Bobst, EFI, Fosber America, MarquipWardUnited/BW Papersystems, Mitsubishi Heavy Industries America, Inc., Sun Automation Group and Sun Chemical.

“We’re very pleased that such an outstanding group of corrugated industry suppliers have pledged to support the

Corrugated Industry Promotion Program,” said Pete Watson, President and Chief Executive Officer at Greif and Chairman of the FBA Board of Directors. “Their support demonstrates a true commitment to the corrugated industry. We look forward to working together to further the industry’s overall health and well-being.”

The association has been running a successful outreach program aimed at the produce market since late 2014. The new program will allow the association to expand its reach to additional markets for corrugated packaging.

Unicor, Kabra pact will bring corrugated pipe technology to India

Germany’s Unicor GmbH and India’s Kabra Extrusiontechnik Ltd. announced a partnership at K 2016 that will have Kabra making Unicor’s corrugated pipe extrusion machinery for the fast-growing Indian market.

The partnership was announced Oct. 21 at K and is designed to provide lower-cost versions of Unicor equipment aimed at India and surrounding countries.

“For us, it will be a real big step,” said Klaus Kaufmann, managing director of Hassfurt, Germany-based Unicor. “Because we are giving our complete drawings and expertise to a partner, it is really like a marriage.”

In an interview at Unicor’s booth, Kaufmann said the deal does not include any equity investment by either company.

Mumbai-based Kabra, which makes extrusion machinery for some pipe and blown films, does not manufacture corrugated pipe extrusion equipment.

The agreement covers equipment covering a range of sizes, from 3-millimeters diameter



Caroline Seidel From left: SV Kabra, Unicor Managing Director Klaus Kaufmann and Kabra Vice President Divyesh Shah at K 2016.

technical pipe to 2.4-meter diameter drainage pipe. It will be manufactured in Kabra’s factories in Daman, India.

A news release said the partnership aims to offer “value for money solutions in India as well as other strategic markets.”

Unicor showed a sample of small corrugated tubes at its booth at K 2016.

Kaufmann said Kabra is a globally well-known firm — it currently has a technology partnership with Battenfeld-Cincinnati Austria GmbH — and is experienced at



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adapting European technology for the Indian market.

He said existing Unicor equipment would be too expensive for India, but the company wants to tap into that market.

"It is always hard to predict but we have promising projects on the way," Kaufmann said. He said the partnership has already provided leads to Unicor.

"India is the fastest-growing economy in the world at the moment," said Deepak Sabherwal, a consultant for Unicor, who helped broker the agreement. "We want to be part of that."

In the joint statement, Kabra said it sees the agreement as providing a single source for technology in corrugated pipe.

"This agreement represents our joint commitment to provide customers with a single source for the latest technology equipment, supported by strong after sales and service," said Anand Kabra, managing director of KET.

The agreement covers India and neighboring countries in the Indian subcontinent but could be expanded on a project basis to other countries, Kaufmann said: "There are also some markets in Africa where Kabra has really good contacts."

Drupa 2016: Focused Indian presence!

Drupa saw an increasing level of quality of Indian visitors. People coming to our stand knew what to ask. They were serious"

Appadurai of HP expressed satisfaction at the improving level of Indian visitors at trade shows, he said "They now do their homework well and know what to enquire". Obviously it is clear that trade shows are no more seen as reasons for tourism. They are serious business for our business men.



Quality Assurance is Key to Maximising Corrugated Recycling Rates

The Confederation of Paper Industries (CPI) Corrugated Sector is urging the waste industry and local authorities to do more to achieve greater collection consistency to help reverse the rise in recycling rejection rates, due to cross contamination.

CPI believes that the increasing use of co-mingled collections has contributed to the increase in household waste in England that had been rejected from materials recycling facilities – 338,000 tonnes in 2014/15 compared to 184,000 tonnes in 2011/12 – according to a recent BBC report following a Freedom of Information request.



The Corrugated Industry is proud of its recycling heritage – every year, over 80% of the material is recycled, which if laid flat would cover an area the size of Greater London three times over – but if corrugated, a valuable and reusable material, is contaminated through councils' collection process it can end up being treated as waste and lost to the industry.

There are those in waste management that insist co-mingling can be justified providing there is a sorting mechanism in place, however CPI considers source separation as the most effective process to maintain material quality.

Director of Packaging Affairs, Andy Barnetson, says that the rising reject rates partially reflects a "growing impatience" among paper mills about the quality of the material they are receiving and then having to shoulder the cost burden of contamination.

He said: "The vast majority of the material recovered from the back of retailers' stores is Corrugated, and that's pretty clean. The core area of concern for us is post domestic where there's been a lack of clarity and consistency over methodology for household collection which has led to a decline in quality.

"Increasing energy, water, sorting and waste disposal costs have focused re-processors on the impact of poor quality recycled corrugated. The Corrugated Industry favours separation at source but a clear and consistent approach to collection, such as that being advocated by WRAP, would provide clarity and simplicity for councils and the public."

He added: "While the declining quality of secondary fibre for recycling post domestic is impacting on the Corrugated Industry there are encouraging signs of initiatives to rationalise collection systems technologies throughout the country, such as the WRAP Consistency Programme, which suggests that the direction of travel may be changing."

Not only is recycling corrugated beneficial to the environment and to the nation's carbon footprint, it has a commercial value and is essential to the Corrugated Industry. Even though the UK corrugated sector is already surpassing Government and EU targets, recycling it ensures that fibres, which would otherwise be lost, can be reused on secondary packaging.

From a domestic perspective, awareness of the benefits of recycling is generally on the increase, but around 50% of English authorities employ a co-mingle system when councils should be encouraging more households to separate corrugated from other recyclables, particularly glass and plastic.

Contd. on - 113

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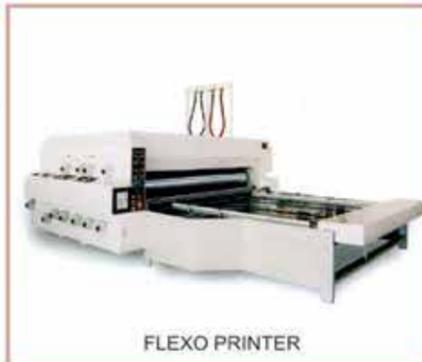


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Rising quality issues and flat-lining recycling rates pose big challenges. Even though CPI argues that the advent of co-mingled collections effectively cross-contaminates everything, the Corrugated Industry's resolve to continue to reduce its impact on the planet and further boost recycling is unwavering.

More info: www.paper.org.uk

Smurfit Kappa enters the Record Books

Smurfit Kappa has entered the record books by making the world's largest cardboard box. Measuring a staggering 40 metres by 20 metres, it was designed and manufactured by a team of creative thinkers in the Smurfit Kappa van Dam plant in the Netherlands.

The challenge was to make a box big enough to eclipse the previous world record set in 2014 in the US. The enormous cardboard construction, which was a feat of design and engineering, was unveiled at a special event for staff and customers at the plant in Helmond.

Speaking at the event, General Manager of Smurfit Kappa van Dam plant Wim Peeters said: "It's not every day that you set a world record so there was a lot of excitement when it was confirmed by Guinness. We're used to making extra-large boxes every day but this one was in a league of its own!"



The record-breaking box has already gone on to be recycled and will be turned into new packaging for one of Smurfit Kappa's customers in just 14 days. The Smurfit Kappa van Dam plant designs, manufactures and

supplies corrugated cardboard packaging and specialises in extra large, heavy duty packaging for a range of sectors including food, automotive and logistics.

World's Biggest Box in Numbers

- Weight 1400kg
- Number of staples used 3000
- Circumference 120 metres
- Height 20 metres
- Width 40 metres
- Length of double-sided tape 100 metres

Source : Paper Mart Oct-Nov.'16 Issue

Smurfit Kappa wins five design awards for its innovative packaging products at 2016 Red Dot Award

Smurfit Kappa has walked away with five of the most prestigious design awards from the internationally recognised Red Dot Award for Communication Design.

From over 17,000 entries from 46 different countries, the Smurfit Kappa products stood out for their outstanding and game-changing designs. Previous winners include global brands such as Apple, Samsung and Phillips.

Smurfit Kappa teams from Germany, Poland and Spain, created a series of unique designs helping to elevate consumer experience.

The team in Germany rose to the challenge of creating a packaging solution that would encourage both healthy eating habits and sustainable behaviour. The result was the "Cardboard Playground" – a ground-breaking design for apples which transforms into a fun toy for children.



The German team also came up with clever packaging for eggs which removes the need for consumers to open the pack to check if any are broken.



For pet-lovers in Poland the traditional plastic cat carrier was turned into an eco-alternative. Made entirely from cardboard, 'Catventure', transforms from cat carrier to cosy home in one swift and simple move.



The second Polish winner was the 'SoFruPack' which transports fruit punnets securely to keep them fresh and unspoilt.



The challenge of carrying a pair of heavy bottles safely and easily was solved through the handy 'Strong Grip' container in Spain.

All five products were recognised by Red Dot for their innovative designs, use of sustainable materials and consumer

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convenience. Helping customers meet and exceed consumer needs is what drives Smurfit Kappa and its designers each and every day.

Arco Berkenbosch, Vice President, Innovation and Development, Smurfit Kappa said: "We are very proud and honoured to have won five coveted Red Dot Awards and to be recognised in the most prestigious field of design. These awards are testament to our world-class designers who are setting the global benchmark for creativity and innovation."

The Red Dot Design awards celebrate and recognise outstanding design quality and were started in 1955.

The 2016 awards were selected by a jury of 26 industry experts during an extensive evaluation and appraisal process lasting several days. The jury consists of well-known designers as well as respected professors and journalists in the design industry.

Source: *Packaging Technology* -
Sept- Oct- 16 Issue

Stora Enso plans consolidation of corrugated packaging production in Finland

Stora Enso plans to consolidate manufacturing of corrugated packaging in Finland to its Lahti plant. The objective is to improve profitability and competitiveness by creating a centre of excellence for corrugated packaging in Lahti.

As part of the possible consolidation, Stora Enso would invest approximately EUR 19 million in new machinery and supporting infrastructure in Lahti, where the most important individual investment item is a new corrugator. The proposed project is planned to start in November 2016 and is expected to be finalised by the end of the first quarter 2018.

According to the plan, the Heinola Corrugated plant would be closed permanently and packaging manufacturing transferred to the Lahti plant. Co-determination negotiations will start within Lahti and Heinola corrugated plants.

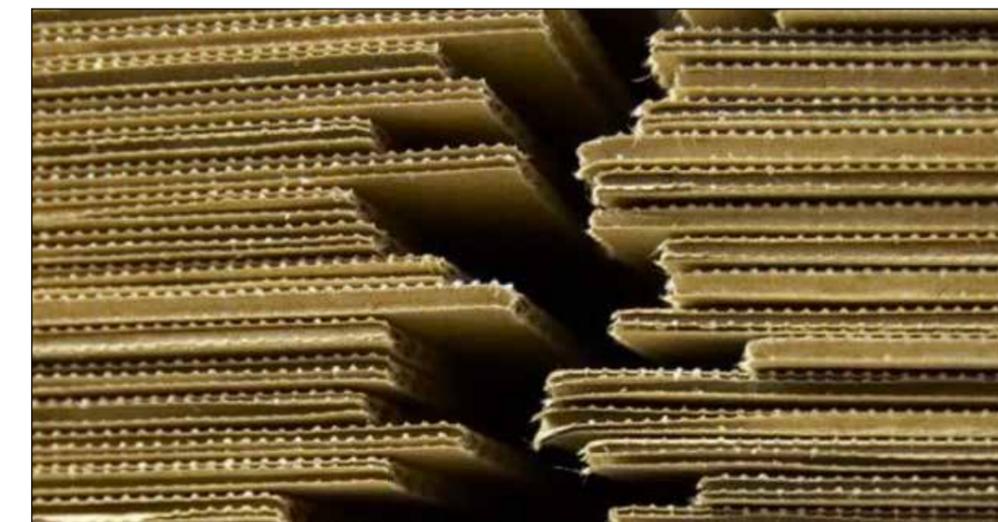
"The plan to potentially consolidate our corrugated operations in Finland is largely driven by the need to improve profitability and strengthen our competitive edge. In addition to the planned investment, our strong infrastructure in Lahti would provide us with a world-class asset base to better serve our customers," says Peter



Torstensson, SVP and Head of Corrugated Nordics, Division Packaging Solutions.

The possible personnel reduction within the corrugated plants in Lahti and Heinola combined is about 60 persons. Decisions regarding the planned consolidation, closure and employee reduction will be taken after the co-determination negotiations have been concluded. The corrugated packaging production at the Kristiinankaupunki plant will be continued. The Heinola Fluting mill for container board will not be affected.

The plan will have a negative impact of approximately EUR 9 million which will be recorded as an item affecting comparability (IAC) in Stora Enso's third quarter 2016 results.





REVIEW



SuperCorrExpo® 2016 by the numbers:




4 action-packed days of keynotes, round-robin sessions, workshops, and networking events

5,000+ industry professionals from the U.S. and 57 countries around the world




Over 28% of attendees are unique buying companies from all corners of corrugated manufacturing

348 exhibiting companies spread out on the largest show floor in show history



Exhibition



Presentations



Product Profile

HB Fuller promotes hotmelt pressure-sensitive adhesives

With the company investing in adhesive manufacturing in India, demonstrating its commitment to bring global adhesive innovation within reach of local converters, HB Fuller is working towards meeting new contacts and strengthening existing relationships at its stall at Labelexpo India 2016.



“At HB Fuller, we know that the condition of the labels on which a manufacturer’s brand is displayed plays an important role in maintaining that brand’s value and reputation,” said Melanie Lack, HB Fuller’s business development manager.

She added that the company is determined to protect brands by designing specialist adhesives that keep labels firmly in place throughout the product journey – however long it might be and however difficult the conditions. “Our extensive research and development, balanced with the ability to respond to customers’ specific and changing needs, will ensure continuous innovation to tackle new challenges,” Lack added.

For speciality and premium labels and tapes, Lunamelt™ HL 2838 has a wide performance spectrum and delivers pressure-sensitive adhesive performance on difficult surfaces, such as virgin and

recycled corrugated boxes in both low and high-temperature conditions.

Additionally, both adhesives are delivering performance on courier envelopes, demand driven by the rapid expansion of eTailers and internet shopping. Swift®melt 1911 and Lunamelt™ HL 2838 are successfully providing the required strong bond to ensure packages remain secure during shipment.

The company’s extensive pressure-sensitive adhesive line-up contains hotmelt, solvent-based and water-based formulations for production of many different kinds of tape, label and protective film.

Source: PrintWeek

Esko Launches CorruSpeed Tool - Meets With Market Enthusiasm

Taking digital finishing of corrugated board to a new level of quality and productivity

At drupa 2016, Esko (www.esko.com) launched the CorruSpeed tool, a brand-new tool for its Kongsberg family of cutting tables designed for high-speed cutting of corrugated board without oscillating. The result is cleaner, more accurate cuts comparable to conventional die cutting, bringing the highest quality of digital finishing to the corrugated market. Tools are available for Kongsberg C Series, X Series, XP and XE cutting tables.

“We saw very high enthusiasm for these new tools at drupa,” says Knut Johansen, Product Manager of Esko, “and have seen fast adoption both as add-on tools for existing Kongsberg tables as well as inclusion in the sale of new tables. Digital cutting of corrugated board has been problematic in both the packaging and signage markets due to the tendency for digital cuts to leave burrs or tags on corrugated board that detract from the



quality of the final product. With these new tools, that barrier is eliminated. It is silent and results in a smooth cut similar to conventional die cutting by enabling more aggressive pre-crushed lines that prevent the liner from cracking. It has set a new benchmark in digital finishing.”

The new CorruSpeed cutting tools include an innovative floating foot with spring-loaded adjustable pressure that enables cutting of a wide variety of corrugated board types up to 7mm double wall BC flutes. This allows it to crush down on the liner, preventing it from cracking and creating a cleaner cut. It also means that cuts can be accomplished at high speed, improving productivity and throughput. A side or top gauge clearly indicates the level of crushing pressure being applied.

“Real-world experience with these new cutting tools demonstrates both an improvement in cutting quality and a significant time savings, even with corrugated board that has a high level of recycled content,” adds Johansen. “This is a breakthrough product that is unmatched in the marketplace and is another example of Esko’s dedication to playing a leading role in the world of digital finishing for packaging, signs and display graphics.”

The Esko CorruSpeed cutting tools for Kongsberg tables are readily available globally through Esko direct sales and reseller channels.

For more information, visit www.esko.com

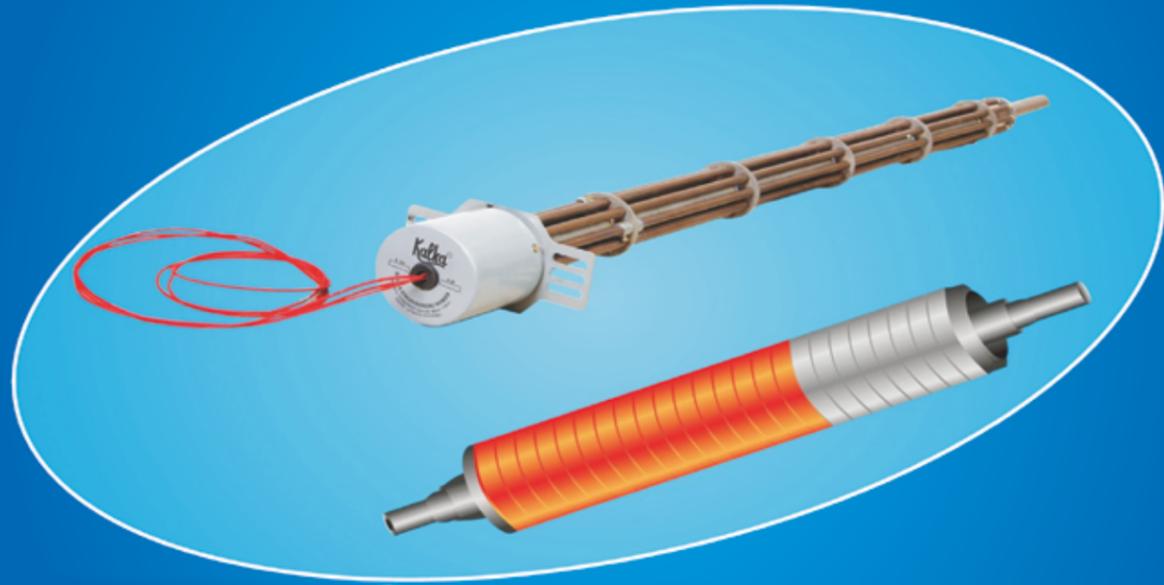


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Jayna Packaging wins Printweek's Innovative Printer of the year Award 2016.

Jayna Packaging has done his bit in promoting the Swachh Bharat Concept. He has designed a Loo box which is made entirely of corrugated board.

The Kit consists of a portable commode and a sleeve for privacy. Compostable, biodegradable bags, hand sanitizer and tissues are provided. It is light weigh foldable and convenient to hold. Seves as a carry pack while travelling. Can be used anytime, anywhere during emergencies?

Innovation is very desi and economical.

Congratulations to Jayna for winning Print week's is Innovative Printer.



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Innovation "Made in Germany"

Muhlen Sohn introduces all new drum lagging

Muhlen Sohn presents a new, cutting-edge drum lagging at the 2016 SuperCorrExpo Non-hazardous, adhesive-free application significantly reduces overall installation time Muhlen Sohn steadily growth on the American market.

Muhlen Sohn, the global leader in the corrugated industry announced their latest innovation at the 2016 SuperCorrExpo in Orlando, FL.

The newly developed SUPER WRAP LAG was presented before an expert industry audience and is expected to begin shipping in 2017.

Cutting-edge technology meets the highest standards

The adhesive-free application of the lagging allows installation time to be reduced significantly, resulting in installations up to ten times faster than traditional applications. Additionally, due to the self-tensioning properties of the material, very few fastening points are required. Therefore, the lagging cannot slip and can be exchanged easily without leaving any residue behind.

"We are delighted to be able to showcase our newly developed SUPER WRAP LAG to the expert audience at the 2016 SuperCorrExpo. With this innovative product, we offer our American and international customers, as usual, the highest German quality" says Armin Birzele, Sales Director at Muhlen Sohn.

The family owned company was founded in 1880, in Blaustein, Germany. Their various products are used in over 100 countries worldwide. Since 2006, the company is also represented in the US market and employs more than 30 employees at its facility in Anderson, Indiana. In the coming years, the company plans to continue the expansion of its market position within the USA.

Source: <http://www.mublen-sohn.com>



Ten reasons for coming to SinoCorrugated 2017!

Reason 1: 16 years of brand guarantee is trustworthy

SinoCorrugated 2017 is organized by Reed Exhibitions, the world's leading exhibition company dedicated to the global corrugated industry for more than 20 years and rooted in Chinese market for 16 years. SinoCorrugated organized by Reed Exhibitions has been successfully held for 8 sessions, the SinoCorrugated South has 7 years of history that attracted over 150,000 visitors, and the middle and high level management of almost all large integrated corrugator factories had visited the corrugated exhibition organized by Reed Exhibitions.

Reason 2: Three exhibitions of corrugated, folding carton and container over the same period

SinoCorrugated 2017 will be held with SinoFoldingCarton 2017 and China Packaging Container Expo 2017 at the same time, it will be of an unprecedented scale! It will not only fully display the full sets of production and manufacturing equipment covering the entire chain of packaging industry, but also display the raw materials and various consumables, as well as the packaging containers of paper, plastic, metal and glass materials.

Reason 3: Well-known brands at home and abroad gather together

SinoCorrugated 2017 received the strong support of numerous domestic and foreign exhibitors, almost all influential famous brands of good reputation that you know and understand can be seen in the SinoCorrugated 2017 platform.

Reason 4: There is always a choice suitable for you

According to preliminary statistics, there will be more than 1,100 exhibitors, more than 1,800 sets of high performance equipment and more than 1,000 kinds of supplies will appear in SinoCorrugated 2017.

Reason 5: Six international exhibition groups are incoming

SinoCorrugated 2017 attracts the world's well-known equipment factories from afar for its internationalization and professionalism, they not only want to seek for domestic customers, but also emphasize many overseas customers in the SinoCorrugated 2017. You will also see 6 exhibition groups from Germany, the United States, Italy, Spain, Japan and India in the exhibition, they will display the advanced production process of corrugated boxes and folding cartons that represent the world's corrugated packaging industry and help you experience the highly efficient and intelligent production mode in the information and intelligence era, quickly learn the world's leading technology and solutions and master the new trend of international corrugated packaging industry.

Exhibition groups from German: BHS, Re-China, Mühlen-Sohn, Leimer, MOSCA, FRIESE GMBH, etc.

Exhibition groups from the United States: United States Valco Melton, SUN Automation, Albany, Goettsch International Inc., etc.

Exhibition groups from Italy: Renovasrl, PENTA BOX SRL, TERDECA srl, Policart s.r.l., etc.

Exhibition groups from Spain: Rodicut Industry S.A.U, Boix, Talleres Serra S.A., Dilunna sheeting roll, etc.

Exhibition groups from Japan: Fujio Conveyor Industry Corporation, MHI, ASAHI, etc.

Exhibition groups from India: SAMADHAN, etc.

Reason 6: Concentrated display in featured exhibition area

In the future, the terminal packaging will be bound to move towards the three major development directions of green environmental protection packaging, customized packaging and smart packaging.

Reason 7: The gurus from global industry will gather together, don't miss the rare opportunity

SinoCorrugated 2017 is an international "social salon" in the whole industry, which is the best choice for you to make business friends and quickly expand your contacts.

Reason 8: Dozens of technical trainings and forum activities are wonderful

SinoCorrugated 2017 is not only a platform for exhibition and trade of equipment, but also a platform for international technical exchange and learning.

Reason 9: Face more than 80000 end users and hundreds of millions of orders

China Packaging Container Expo 2017 that will be held over the same period of SinoCorrugated 2017 will be jointly held by Reed Exhibitions and China Packaging Federation, which will invite more than 8000 development and procurement decision-makers from the terminal industries, including the food, beverage, cosmetics, household appliances, electronic digital, gifts, e-business and logistics to visit the exhibition!

Reason 10: Full range of services before, during and after the exhibition

From April 11 to April 14, all visitors with the intention of purchase will have the opportunity to become "TAP guest" of SinoCorrugated 2017. TAP guest will not only enjoy the exclusive room presented by Reed Exhibitions, but also enjoy customized travel, meet exclusive target exhibitors, participate in the one-to-one trade matching and other various customized services,

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

Nearly **110,000** sqm exhibition area

Nearly **1,100** exhibitors

65,000 local and international visitors

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

Nearly **1,200** kinds of consumables

SinoCorrugated 2017

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



Concurrent Exhibitions



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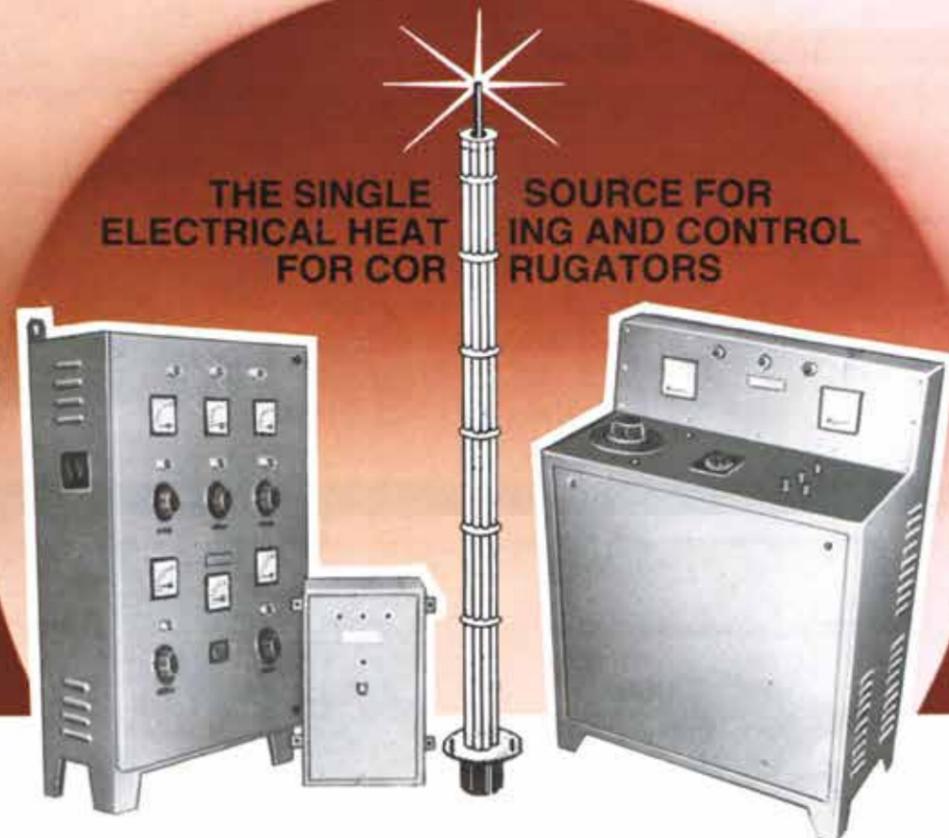


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Hotron means "electrical heating & control too"

Hotron Heaters offer features that make them stand apart:

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- Proper Assembly of unit prevents frequent burning.
- Proper assembly of unit having flanges and Strong Central Support. Prevents sagging.
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- Panel mounted indicators & meters indicate status and performance of heaters.
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We shall be pleased to offer free technical advice and recommend most ideal heaters for your corrugating machines

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www.hotron.net



Forthcoming Events

04-08 February 2017



India Expo Centre,
Greater Noida, Delhi NCR

Indian Printing, Packaging and Allied Machinery Manufacturers' Association (IPAMA), founded in 1988 and was registered in Delhi in 1991. IPAMA is an independent organisation serving the needs of the Printing, Packaging and Allied Industries in a rapidly changing marketplace. IPAMA operates from its own sprawling building with ultra-modern facilities at NOIDA in the neighborhood of New Delhi capital of India.

IPAMA is today in the centre-stage, playing a pivotal role in the policy making of exports and imports, in collaboration with Government agencies, CII, FICCI, ASSOCHAM and FIEO.

21-23 March 2017



Munich Trade Fair Centre, Germany

CCE International 2017 will be the third edition of Europe's only dedicated trade fair for the Corrugated and Folding Carton Industry. The exhibition has by now become renowned for bringing together manufacturers and suppliers of machines, accessories and services with a targeted audience of buyers and users of such equipment.

29 March - 02 April 2017



Icorrugated Expo 2017

National Exhibition and Convention Center
Shanghai - China

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

Shanghai Icorrugated Exhibition Services Co., Ltd.

Delegation Association Service & Cooperation:

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

11 - 14 April 2017



Shanghai
New International Expo Center, China

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

For press information, please contact:

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Tel: +86-21-2231 7065

Fax: +86-21-2231 7183

Email sinsia.xing@reedexpo.com.cn

4-10 May 2017



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

4-6 August 2017



PackPlus 2017

Pragati Maidan, New Delhi, India.

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

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AS 009 - Semi Auto 2 pcs. Box Stitcher



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



Optional Available:
Auto Wire Feeder for 30kg Coil

AS 027 - Semi Auto Gluer



AS 2009 S/G - Fully Auto Stitcher / Gluer



TCM - Made in Taiwan

High Speed Automatic
&
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Stitching and Gluing Machines

Salient Features of TCM

Two Piece Box Stitcher AS 009 with (servo drive)

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

Semi Auto Stitcher
AS016A with (Servo Drive & Touch Screen)

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

Semi Auto Gluer AS 027

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

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- Recycled wash water for glue mixing
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