

CORRUGATED WORLD

ASIA

The bimonthly publication for asia corrugated industry | February 2021

INSIDE: DONGFANG | ISOWA MARKS CENTENCERY | KADAR COMPUTER INTELLIGENT ROBOT | DOCTOR BLADE



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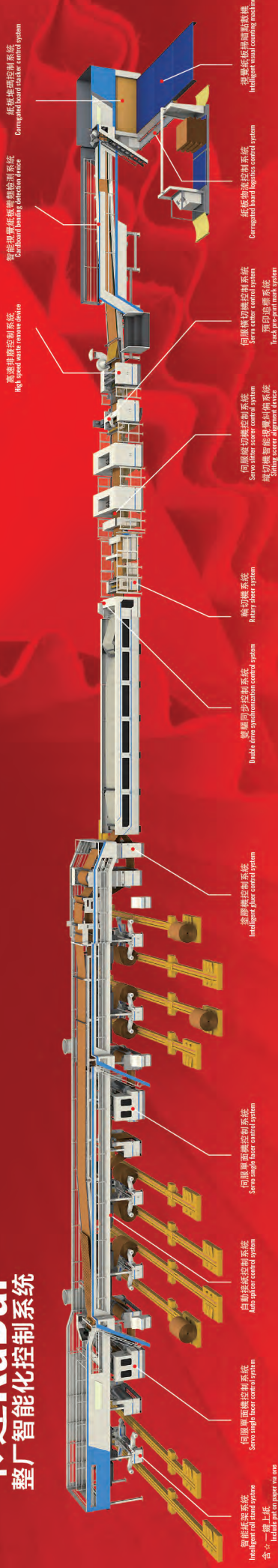
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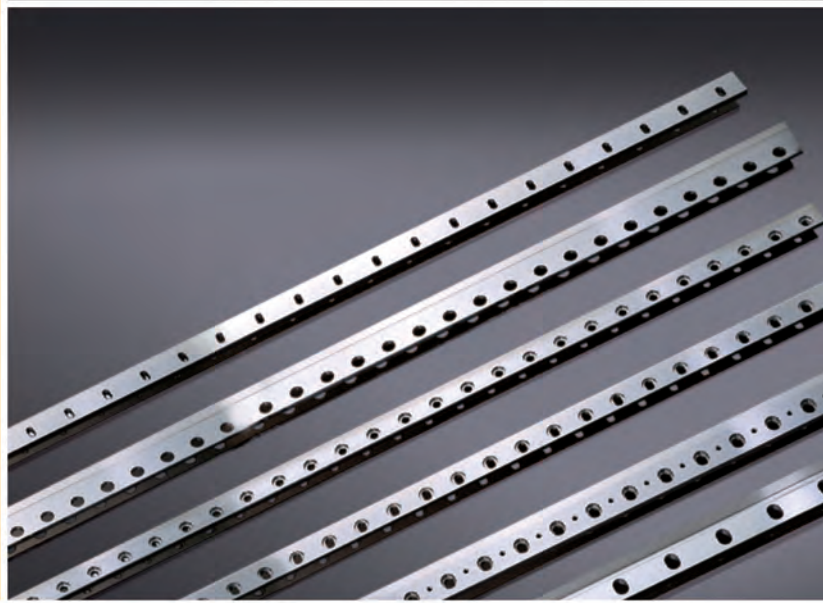
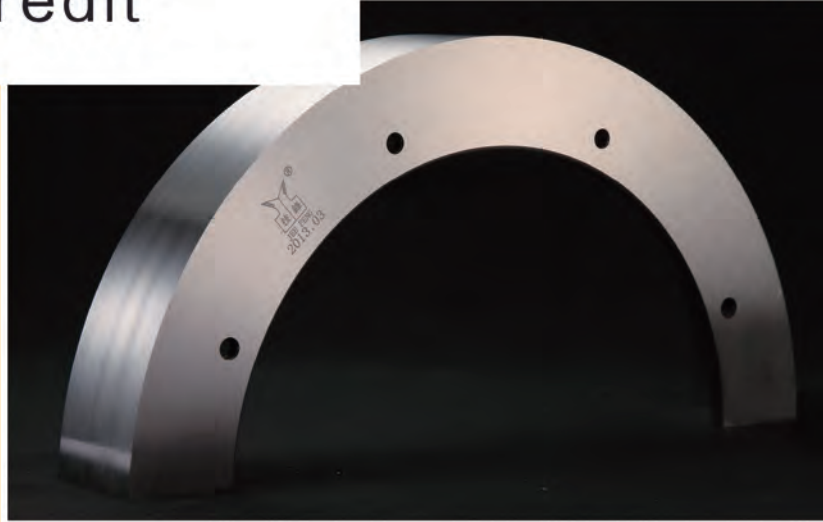
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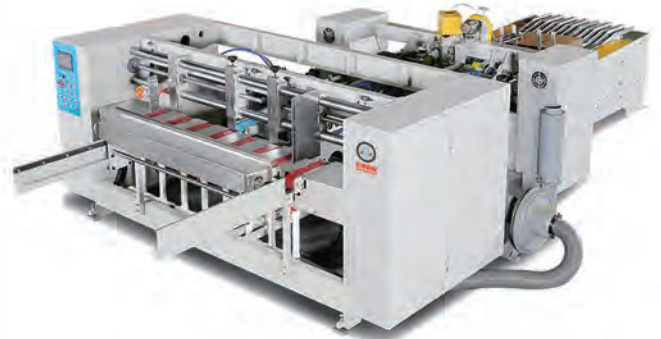
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BHS CORRUGATED ACQUIRES UNIVERSAL

With effect from September 2020, BHS Corrugated has taken over all shares of Universal Corrugated B.V. from Minda Industrieanlagen GmbH. Uwe Leopold, the former Universal plant manager, has been appointed as the new Managing Director.

With the Unifold continuous stacker, Universal has developed excellent know-how in customerspecific solutions and a strong position in the Fanfold market, which allows both parties independently of each other to optimally develop

this growing market segment in the future and to set individual priorities.

Together with the active participation of the experienced management team, almost 40 employees at the factory in Almelo, Netherlands, will be primarily involved in the ongoing development, installation, commissioning and service of fanfold systems. They will also be looking at considering special solutions for stacking of corrugated board and Honeycomb units.

UNIVERSAL HAS DEVELOPED EXCELLENT KNOW-HOW IN CUSTOMER-SPECIFIC SOLUTIONS AND A STRONG POSITION IN THE FANFOLD MARKET, WHICH ALLOWS BOTH PARTIES INDEPENDENTLY OF EACH OTHER TO OPTIMALLY DEVELOP THIS GROWING MARKET SEGMENT IN THE FUTURE AND TO SET INDIVIDUAL PRIORITIES.



△ Left to right: G ü nter Huber (Head of Business Unit Equipment, BHS Corrugated), Uwe Leopold (Managing Director, Universal Corrugated), Robert Falch (Managing Director, Minda Industrieanlagen), Lars Engel (Managing Director, BHS Corrugated) and Eberhard Falch (Company founder, Universal).



ASAHI TECH CENTER IN CHINA ADDS ESKO PLATE IMAGING SYSTEM

Asahi Photoproducts has extended its relationship with Esko through an agreement to install Esko plate imaging solutions in the Asahi Tech Center in Suzhou, near Shanghai. The agreement, which was entered into during All-in-Print China, will result in the installation of an Esko CDI Spark 4260 and an XPS Crystal 5080 in the Center.

These plate imaging solutions are supported by an Asahi AWP 230W plate processor using Asahi AWPTM CleanPrint water-washable plates to complete the industry's most balanced flexographic platemaking solution in harmony with the environment, delivering the highest possible quality for China's demanding flexo customers.

"Asahi Photoproducts has worked together with Esko in China for a decade and this agreement takes the relationship to a new level in our ability to serve the rapidly evolving flexographic market in China," said Yuji Suzuki, Asahi's Senior Manager of Customer Technical Service.

Suzuki points out that high-end print quality is increasingly required in China and many repro houses in the region still have difficulty making plates that deliver the best print quality. "One

thing we will be doing in our Tech Center with the new equipment," he says, "is creating test plates for potential customers so they can see for themselves that we can deliver the quality they need. We will also use the facility to do training and seminars for customers and potential customers."

Esko will also have access to the Tech Center, offering the possibility to Asahi's customers to learn more about how the Esko plate imaging system functions with Asahi's AWPTM CleanPrint water-washable plates. "We are pleased to continue to grow our partnership with Asahi, especially in the highly competitive Chinese market," said Rocky Zhou, General Manager for Esko in Shanghai. "The solutions being installed at the Asahi Tech Center will benefit both of our businesses as we work to continue to bring the latest state-of-the-art flexographic solutions to this region."

THE BOXMAKER ORDERS A SECOND HP PAGEWIDE C500

The BoxMaker, a US producer of digitally produced packaging, has confirmed it has purchased a second HP PageWide C500 Press to add capacity for its growing corrugated business, as the converter launches a nationwide expansion.

The multi-million-dollar investment makes The BoxMaker the first converter in the world to operate two HP C500 presses for on-demand direct-to-board production of corrugated boxes with offset quality print using true water-based inks.

"The HP C500 has proven valuable to both our business and our brands, playing a key role in doubling our business volume for digitally produced packaging and display," said Richard Brown, President and Co-Owner of The BoxMaker. "Digital print technology enables our customers greater flexibility for quick turnaround times, high-impact designs for multiple SKUs and the ability to engage consumers with marketing promotions directly integrated into their packaging. The HP C500 is proven technology that will serve as the print platform to drive our growth strategy as we continue on our journey

with HP to transform the market to digital."

The new press will be installed near Springdale, Arkansas where The BoxMaker is acquiring Tango Press, an all-digital production plant for corrugated packaging and displays. The BoxMaker offers easy ordering through its web-to-print packaging platform, fantastapack.com, which enables businesses to easily design and order high-graphic custom packaging online from a set library of box and display styles.

"The BoxMaker continues to lead innovation in packaging with successive investments in HP digital corrugated printing," said David Tomer, General Manager, Post-print corrugated, HP PageWide Industrial. "Choosing a second HP PageWide C500 press is a vote of confidence and a significant step ahead that will enable The BoxMaker to transform the corrugated market with productive, on-demand printing and capture business in this growing market."

The BoxMaker, an early adopter of HP digital print technology, also operates an HP Scitex 17000 corrugated press and two HP Indigo web presses for labels and folding cartons.



MORE INVESTMENT AT BOXES & PACKAGING LEICESTER

Just a year after UK-based The Boxes & Packaging Leicester site welcomed the arrival of an Eterna PE1620SAExtra flat bed die-cutter, it has been joined by a further new machine – a Dong Fang Topra AD1628.

This 2.8m, two colour flexo rotary die-cutter replaces an ageing YSF to bring added production capacity to the team that manufacturers corrugated packaging solutions across the East Midlands, Leicester, Nottinghamshire and beyond.

“This latest addition is a great investment for Leicester and one that was eagerly awaited,” said Gregor Troup, Managing Director, Boxes and Packaging (Leicester). “The team from M&K Trading ensured the installation was seamless, minimising down time, delivering training and ensuring the team were equipped with all the necessary skills so that full production could begin as soon as the machine was commissioned.”

With improved efficiencies in terms of setting

times and production capabilities, the new machine will assist in giving extra capacity to integrate into future growth plans for the site. Capable of handling a maximum sheet size of almost 2.8m and running at 9,000 passes per hour, it will be able to support the core business of Leicester customers with extra capacity and good print quality.

“Dong Fang has a proven track record in the industry and our expectations are high in terms of what the machine will deliver to facilitate further ongoing growth at our site,” said Troup. “Over the last 18 months there has been some significant changes at our Leicester site and combined they have enhanced our capabilities considerably.”

The latest Dong Fang installation is the sixth in the Logson group with other machines at Boxes and Packaging Doncaster, Manchester, Bristol, and two at Jardin sites in Cambridge and Sutton.



OJI BREAKS GROUND FOR NEW SITE IN CHRISTCHURCH



In November 2019, Oji Fibre Solutions confirmed it would be investing over NZ\$100m to develop a new greenfield corrugated packaging facility in Christchurch, New Zealand. All the behind the scenes work is done and the company are now breaking ground and entering the building phase.

The new facility will consist of bespoke buildings designed to house state-of-the-art production machines, material handling and peripheral equipment that will significantly improve safety, quality and food safety, whilst reducing waste.

When completed in 2021, this site will be the

South Island hub for Oji's packaging operations; producing sustainable packaging products for South Island businesses, namely the primary sector such as meat, dairy, fish, and horticulture, as well as general industry.

"The new Christchurch facility will replace our existing Shands Road operation. By investing in the best available equipment, we will improve product quality and productivity, deliver environmental improvements and provide a safer operation than is possible in the current facility," said Grant Fitzgibbon, Chief Operating Officer, Oji Fibre Solutions – Packaging.

FOURTEEN MACHINES IN ONE MONTH!

Mihara, Japan-based Mitsubishi Heavy Industries Machinery Systems has confirmed that it received a total of 14 orders for its popular EVOL flexo folder gluer in the month of November alone. The machines have been ordered by independent as well as integrated companies all around the world.

“This is a fantastic result, considering the travel restrictions and constraints we are all under due to the ongoing COVID-19 pandemic,”

says Giovanni Bettini, Sales Director of MHI Europe. “But even more encouraging is that we started December with the same momentum that we achieved globally in November. This is testament to the popularity of this range of high speed converting lines and clear indication that the build quality, reliability and high performance is truly appreciated by boxmakers all over the world.”

ANOTHER FOSBER RECORD SET IN MEXICO

Grupo Gondi has reported that on 3rd September, one of its plants set a new 8hr shift record on a 2.5m Fosber S/Line corrugator. It was recorded at the company’s plant in Cuautitlán in Mexico City. The experienced operators achieved an impressive performance of 146,934 linear meters (or 308,919 sqm).

Cuautipack Plant, a leading fully integrated corrugated packaging producer, has been part of Grupo Gondi since 2013. Due to its ecofriendly and sustainable processes, it is certified as an ‘Industria Limpia’, and was awarded by several other important entities for its quality and environmental leadership.



WEIPONG 5 COLOUR FLEXO RDC FOR CHALLENGE PACKAGING

David Williams, Managing Director of GTS (Europe) Ltd, has confirmed that the company recently secured an order for a five colour Weipong Venus 1625 SSTKB rotary die-cutter from UK-based Challenge Packaging Ltd.

The five colour rotary die-cutter is being specified as an 'inside out' machine, with three flexo units printing the outside of the sheet and two flexo units printing on the inside of the sheet. The line, which will also be equipped with Absolute chambers and Sandon anilox rolls, features an advanced stripper stacker unit for

accurate bundling or multi-out pieces. It is due to be installed in the second half of 2021.

"This is the fourth Weipong flexo converting line to be ordered in the UK," says David Williams. "This line is proving to be a really solid performer and is gaining a lot of interest with mid-sized sheet plants who are looking to grow their capacity for printed and die-cut work. It offers an excellent return on investment and with the service and support offered by GTS Europe. Existing customers are seeing good levels of output for a mid-level investment."

VALMET TO SUPPLY NEW PM TO SHANYING PAPER, GUANGDONG, IN CHINA

Valmet has confirmed it will supply a new OptiConcept M containerboard paper machine with an extensive package of automation to Shanying Paper, Guangdong at its Zhaoqing mill in China. The new line (PM 52) will produce kraftliner grades and expand Shanying Paper's business to the Guangdong area.

PM 52 is following the OptiConcept M deliveries of Shanying Huazhong PM 21, which was started up in December 2019 and PM 23, which was started up in September 2020. In addition to these, Valmet has supplied five other paper machines to Shanying International. The start-up of PM 52 is scheduled for the end of 2021.

"We are happy about the earlier references of

Huazhong PM 21 and PM 23," says Wu Ming Wu, Chairman and CEO of Shanying International. "It was really nice to see how well and seamlessly everybody worked together when optimising PM 21 and starting-up PM 23 – our people and Valmet's experts were in Zhaoqing and Valmet's experts in Europe were supporting us via remote connection."

"Our earlier references are really good, which was an excellent base for the project," says Hannu Savonen, Sales Manager, Valmet. "Valmet has proved to be flexible and reacted fast to the customer's requirements and changes. The extensive automation package will be an excellent support in the start-up and for the line optimisation after the start-up."



FOCUS ON THE MAIN BUSINESS AND BUILD A SMART MANUFACTURING LEADER

— INTERVIEW WITH TANG ZHUOLIN, THE CHAIRMAN OF DONGFANG PRECISION GROUP

Since Dongfang Precision Group acquired the Italian Fosber Group in March 2014, it has actively explored effective integration with the acquired companies and achieved remarkable results. In recent years, with the advancement of endogenous growth and extensional expansion, the number of subsidiaries of Dongfang Precision Group has been increasing year by year, and the industrial sectors, sub-sectors and geographical spans are large.

As a group with standardized and stable operation. While promoting the collaboration

and integration of business entities, how does Dongfang Precision consider operational efficiency and sustainable development? What is the future development direction? Recently, we have the honor to interview Tang Zhuolin, the Chairman of Dongfang Precision Group, who revealed the future strategic layout of Dongfang Precision for us.

Dongfang Precision has been established for more than 20 years. It grown step by step from Foshan to the world. In this process, how did you recruit and make

good use of the talents?

Tang Zhuolin:

In the early stage of enterprise development, as a private enterprise, we did have a certain degree of difficulty in attracting talents, because the paper packaging industry is different from the IT industry. So, we mainly developed through school recruitment and internal training, and they grew up with us together in the initial stage. In terms of R&D, I was the chief engineer until 2014. Of course, I am very inspired and innovative for R&D. Because I pursue high quality, all we manufacture are innovative and best quality machines.

As the company grows towards grouping and internationalization, our recruitment of talents is mainly based on the same values, mutual respect, trust, openness, sharing of multiple cultures, and seeking like-minded talents to grow together.

For the good use of talents, our group is strategically oriented. After establishing the correct strategic direction, combined with the management experience of the Group CEO and according to the strategic direction of the group, we will mobilize all resources to select and tap talents, absorb talents, retain talents, and make good use of talents through various modern management tools, such as performance appraisal and equity incentives.

With the continuous expansion of the global layout and scale of the Dongfang Precision Group, under the current covid-19 impact and the rapidly changing international market environment, how does Dongfang Precision Group coordinate quality, brand and service, so that the group can achieve sustainable and healthy development?

Tang Zhuolin:

I think there must be enough time to

settle the company's quality and brand. At present, the United States is our second largest market and Europe is our third largest market. Dongfang Precision printing presses have accumulated more than 120 installations in the United States.

As a professional equipment manufacturer, we always adhere to the spirit of craftsmanship. We have been pursuing quality and brand for decades. Our products and services have always been synonymous with high quality in the industry. Whether in developed or emerging regions, as long as customers buying our equipment is equivalent to having a peace of mind. They can focus on their factory's operation and management without worrying about the quality issues and maintenance services. Since the establishment of Dongfang, no matter how difficult and complicated the situation is, we have never lowered or sacrificed product quality and service commitment.

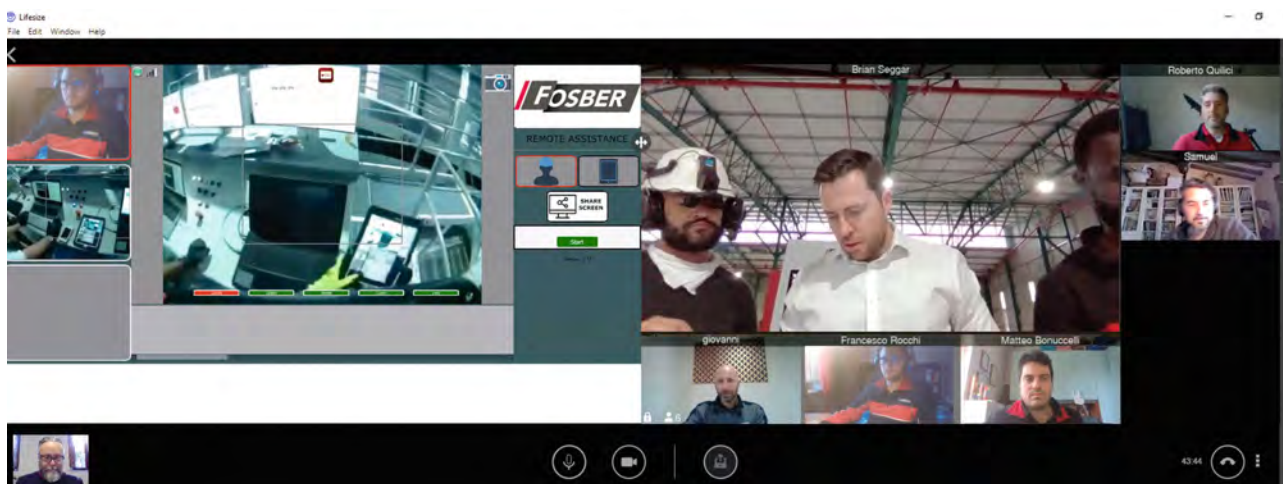
From the perspective of the stock market, as a kind of durable equipment, Dongfang Precision's products rank first in the Asia-Pacific region in terms of stock, which has accumulated a good reputation in the industry and is sustainable. Even if a machine that has been used for ten years enters the second-hand machines' market, its value is very high, which further illustrates the performance and quality of our products. It is the quality of excellence and the promise of continuous surpassing that have contributed to the position of the Dongfang Precision brand in the industry.

Today, the comprehensive strength of Dongfang Precision's high-end intelligent equipment ranks among the top three globally. In the future, how can you continue to improve in terms of R&D, service, and customer experience?

Interview of Asian Entrepreneur



△ Headquarter of Dongfang Precision Group in Foshan



△ Cloud Installation of Industry 4.0 Technology

Tang Zhuolin:

When Dongfang Precision was founded, we only made printing presses. After being listed in 2011, we have successively integrated Fosber, Tiruna, and Agnati. The equipment produced by these companies has a high degree of market recognition. The experience of the past few decades tells us that with the continuous development of the company, continuous creation of value for customers is the source of common development for both us and customers. Especially now, with the continuous development of new technologies, how to use them to help customers to upgrade, improve quality, produce and operate more efficiently, etc., has always been our development direction.

At present, we use the "Cloud Installation"

of Industry 4.0 technology in customer service, and he first trial Installation Program using Industry 4.0 technology is located in Fujian, China. At the end of February when Covid-19 situation was getting better in China and all enterprises struggling to resume opening, Fosber Asia have delivered equipment and start our installation program instantly. The project installs the first high-speed 370m/min corrugator line of Fosber Asia and it is commissioned by teams from China and Italy remotely. To ensure the smooth progress, Fosber Asia decided to make full use of its control system to start the "Cloud Installation" plan, using Industry 4.0 technology to collect and transmit machine data, so that engineers far away in Italy can clearly understand the domestic machine situation, join online

with professional knowledge and preform the installation. Due to the covid-19, "Cloud Installation" is also being implemented in other parts of the world , such as South Africa.

In terms of customer experience, the digital communication module we have combined with the AR visual recognition technology of virtual reality has achieved global machine cloud installation. The four-in-one Industry 4.0 technology of intelligent identification, intelligent diagnosis, intelligent correction and self-learning can detect machine operating conditions online in real time, warn machine failures, and provide correction schemes to escort the safe, efficient and stable operation of each machine. Our self-developed production management system and other software tailored for customers, with its high degree of automation, is suitable for all machines, and can automatically set production orders for all order specifications and parameters without manual calculations , as well as fast changeover and generate reports automatically to help customers break through capacity bottlenecks.

With the high efficiency, stability and high intelligence , the Smart Corrugator Line manufactured by Fosber, the FFG

manufactured by Dongfang Precision and the robot manufactured by Jiateng have greatly reduced the dependence on people, improved the flexibility and adaptability of production, and completely changed the existing model of corrugated packaging industry that relied on manpower , which is small and scattered. We can help customers expand their scale, increase efficiency and production to develop into a centralized big and strong industry leader, and further enhance their competitive advantages and industry structure.



△ JATEN Robot

The greater the capacity of an enterprise, the greater the responsibility. Covid-19 has swept the world this year. It is understood that Dongfang Precision Group also bravely assumes social responsibilities



△ Product line of Fosber

and actively assists the society in fighting against covid-19. How do you understand the relationship between corporate social responsibility and corporate development?

Tang Zhuolin:

When the company we operate has grown to a certain scale, we can't just focus on our personal wealth. As a leader in the industry and a listed company, we're continuing to perform our social responsibilities as our global layout continues to improve and the company develops.

Since the outbreak of covid-19 this year, we have donated aid funds through the Nanhai District Enterprise Listing Promotion Association at the first time, and donated medical professional masks and protective clothing to Dawu County, Hubei, Lianyuan City, Hunan Province, and Foshan First People's Hospital, Dongfang Precision's volunteer team also participated in a large number of social services.

After the outbreak of covid-19 overseas, we donated 70,000 medical masks, 10,000 KN95 masks, and 1,000 protective suits to local hospitals and government agencies in Lucca, Italy. The local media in Lucca also reported on our chivalrous deed. We also donated a batch of masks to our subsidiaries Tiruna & agnati. In addition, a lot of protective materials were donated to customers and friends in Italy, Spain, and Nigeria.

These actions have also won unanimous praise from customers, colleagues and local communities all over the world. In short, the greater the ability, the greater the responsibility. Dongfang Precision's mission is to become an industrial group with high influence, customer trust, shareholder trust, and employee respect in its field. Dongfang is willing to always contribute to the progress and development of society.

So, I think we must build a company

with core competitiveness and sustainable development. Only in this way can we continue to fulfill our social responsibilities and create greater value for the society, employees, and shareholders.

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Fosber, la capogruppo cinese invia 80mila mascherine per San Luca e forze dell'ordine **foto**

Massimiliano Bianchi: "Ci sentiamo in dovere di fare la nostra parte"

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Commenta Stampa Invia notizia 2 mihi

Più informazioni su dispositivi di protezione donazione dongfang forze dell'ordine fosber mascherine massimiliano bianchi lucca

da Ninni P I Z Z E R I A **consegna a domicilio** in un raggio di 5/6 km



Sin dal principio dell'epidemia, Fosber ha avuto come obiettivo primario la sicurezza ed il benessere di dipendenti, clienti e dell'intera comunità. Per questo motivo l'azienda ha chiesto supporto alla capogruppo **DongFang Precision**, con sede a Foshan, per la fornitura di **80mila mascherine**.

60mila verranno recapitate all'ospedale **San Luca di Lucca** per dare un aiuto a Oss, medici e infermieri che stanno combattendo una battaglia in primissima linea, quotidianamente. Le altre **20mila sono destinate a polizia e carabinieri** che nelle ultime difficili settimane pattugliano le strade. A queste si sommano anche **500 tute**, che verranno consegnate al personale sanitario del nosocomio locale. Una prima parte dei materiali è stata consegnata all'Asl Toscana Nord oggi, venerdì 20 marzo.

△ Dongfang Precision donated medical supplies to Italy

China's paper packaging industry is small and fragmented, and its concentration is not as high as that of the European and American markets. Now, Dongfang Precision is the industry leader in China. In your opinion, what is the future trend of China's paper packaging industry upgrading and development?

Tang Zhuolin:

At present, affected by the low entry barriers and limited service radius of the corrugated packaging industry, China's

paper packaging industry has a scattered production capacity layout and extremely low market concentration. The top five companies have a market share of less than 10%, compared with 40%-80% of CR5 market share in Europe and the United States, there is still much space for improvement in concentration.

With the tightening of China's environmental protection policies, rising labor costs, the development of e-commerce, and the continuous improvement of the automation level of processors, end users have put forward higher and higher requirements for the quality, delivery speed, and cost-effectiveness of corrugated packaging.

As far as the corrugated packaging industry is concerned, the corrugator plant and sheet plant with weak management capabilities and poor profits will be quickly replaced, and their original market shares will be gradually replaced by leading companies in the industry. Increasing concentration will be an inevitable trend. Judging from the actual market situation in recent years, industry concentration is accelerating. Data from the National Bureau of Statistics has further verified this point. The number of enterprises above designated size in the paper and paperboard manufacturing industry has decreased by more than 300 within five years, and the trend of industry consolidation is obvious.

Due to the high efficiency, high quality, cost reduction, environmental protection and energy saving, convenient management and other considerations, especially affected by the covid-19 epidemic this year, the demand of large paper packaging groups for fully automatic factories is growing rapidly, which puts forward higher requirements for the automation and informatization level of the whole plant. At present, there is no overall solution provider for intelligent

paper packaging enterprises in the market. Dongfang Precision is relying on its deep understanding of the industry for many years to provide complete factory solutions for large corrugated packaging groups.

At the same time, this part of the market demand will promote the upgrading of industry technology and equipment, accelerate the integration of downstream industries. This trend will be further transmitted to the corrugated board manufacturing and printing equipment, further accelerate the increase of equipment industry concentration, and eliminate equipment manufacturers with low technical content and low production efficiency. The trend of increasing concentration in the corrugated packaging industry places higher demands on packaging equipment suppliers. In the pursuit of industry competitiveness, Dongfang Precision adheres to the business tenet of committed to becoming the world's leading provider of integrated solutions for intelligent packaging equipment and high-end core components, and at the same time leads the industry in the layout of intelligent whole plants for paper packaging plants solution.

After years of intensive cultivation and experience, the brands of Dongfang Precision and its subsidiaries are among the best in the industry. The products are also known in the industry for high performance, high intelligence, high stability and reliability. Our service-oriented manufacturing enterprise model also offers customers high-quality technical support and after-sales service, that achieve multiple premiums in reputation, service and cost-effectiveness. With its leading advantages, we steadily seizes the structural opportunities brought about by the integration of downstream industries.

Interview of Asian Entrepreneur



△ The overall solution and process of Dongfang Precision Smart Factory.

When a enterprise moves towards marketization, competition will inevitably come. How does Dongfang Precision participate in the competition, and how to seize the market and respond to market challenges?

Tang Zhuolin:

Being at the forefront of the industry and seizing opportunities is the foundation of our continuous development over the years. We carried out a global market layout earlier and went out one step ahead of time. We did not put eggs in a basket. We have balanced R&D, production and service centers in Asia, North America and Europe, which can be closer to our customers and response to complex and volatile political and economic situation steadily. In order to meet the needs of different customers, we not only have high-end products, but also mid-end products, as well as cost-effective configurations. We can use a vast product portfolio to meet the needs of customers in various regions.

The layout of the entire industrial chain of smart packaging has further enhanced our core competitiveness in the market. Whether it is a corrugator line, a printing press, or peripheral equipment, our products are at the forefront of the industry in terms of automation and intelligence, and the equipment itself has a very high degree of data information processing.

In 2018, Dongfang Precision 's stock was included in the MSCI Index and the

FTSE Russell Index, becoming a benchmark enterprise in capital operation, which is more conducive to us integrating high-quality resources and seizing market opportunities.

Dongfang Precision is the only manufacturer in the industry with high-end paperboard production lines and printing presses. We have the industry and capital to help customers open the information isolated island, help them use industrial Internet and digital technology and realize the digital transformation, as well as promote the large-scale development of enterprises and further enhance the industry structure.

000651.SZ	格力电器
600185.SH	格力地产
600206.SH	有研新材
002292.SZ	奥飞娱乐
000690.SZ	宝新能源
002611.SZ	东方精工
000539.SZ	粤电力A
603328.SH	依顿电子
000712.SZ	锦龙股份
002930.SZ	宏川智慧

△ Dongfang Precision's stock is included in the MSCI index

600563	法拉电子	002625	光启技术	000488	晨鸣纸业
600559	老白干酒	002624	完美世界	000429	粤高速A
600557	康缘药业	002619	艾格拉斯	000426	兴业矿业
600549	厦门钨业	002618	丹邦科技	000425	徐工机械
600548	深高速	002614	奥佳华	000423	东阿阿胶
600547	山东黄金	002611	东方精工	000413	东旭光电
600545	卓郎智能	002608	江苏国信	000402	金融街
600536	中国软件	002603	以岭药业	000401	冀东水泥
600535	天士力	002601	龙蟠佰利	000400	许继电气
600531	豫光金铅	002600	领益智造	000338	潍柴动力

△ Dongfang Precision stocks included in the FTSE Russell Index



△ Overall solution for smart packaging system



ISOWA CELEBRATES 100TH ANNIVERSARY WITH ADVENTURE, REBRAND, NEW LOGO

BY HIDEYUKI ISOWA, PRESIDENT OF ISOWA CORPORATION IN AICHI, JAPAN.



△ Hideyuki Isowa, President of ISOWA Corporation

Thanks to your continuous and warm support, ISOWA is celebrating its 100th Anniversary in 2020. I would like to extend my most sincere thanks and share some of our company's history. Since our founding,

we have always strived to express our corporate identity, openly declaring who we are, what we are and what we want to be to the world. Today this is called 'branding'.

To establish the brand, consistency is essential in good products, services, our corporate philosophy and action policy. Furthermore, it should be obvious for all customers, subcontractors and employees through characters, words, visuals and designs.

With Isowa's traditions of diligence, faithfulness and persistent development, which were inherited from our predecessors, our corporate philosophy and action policies have been understood and shared with the Isowa people. As more of them brought these ideals into action, a better and more fertile corporate culture has been cultivated.

The most important factors for a brand, of course, are good products and good



services. Regardless of how admirable a corporate philosophy or culture we have, we can not be a great brand if our products and services don't reach the highest level. We are confident that we have been keeping our consistency in our corporate philosophy, action policies, statements and sending messages internally and externally. This is one of the great factors of our success during our corporate culture revolution. I believe this has been reflected in the evolution of our brand and our logo, which we have changed to celebrate our 100th Anniversary.

The history of ISOWA's logo began a century ago with the founding of Minoda Iron Works. Ancestors of the Isowa family were shipbuilders on the Shima peninsula, where they have a legend that gods on a log were cast up on the shore at Shima and since then, shipbuilding has been prosperous there. Considering the family name of Isowa is derived from 'ship/wheel of seashore', it might be fate that our first logo was that of a treasure ship.

After World War II, the company name

was changed to Isowa Industry. At that time the logo was a treasure ship with 'IS mark' designed like a \$ mark by Eichi Isowa, the second generation of the company, while he was under medical treatment for tuberculosis.



The 'IS mark' remained until our 70th Anniversary, when the company name was changed from Isowa Industry to Isowa Corporation. We also changed the corporate colour to purple blue from sky blue. The height of the logo was shortened a little, widened along the base, and the traditional 'IS mark' was removed.

At our 80th Anniversary, we started our corporate culture revolution. Then, at our 90th Anniversary, we set our concepts: 'Bring

results from corporate culture revolution in the midst of day-to-day operations' and 'I Machine: human friendly and Kikai friendly'. In the development of machines with these concepts, we built a strong reputation among our customers. The word spread and this resulted in attention from new customers who were not interested in our products before.

ISOWA®

Now we are celebrating our 100th Anniversary with a new logo that expresses our future direction visually. The metallic silver at the centre shows our roots in the Iron industry, and our tradition and pride as a 100-year-old machine manufacturer of corrugators and finishing equipment. The blue at the bottom expresses our corporate philosophy: 'Creating a company with the best corporate culture in the world that makes us and our families happy.' Originally, philosophy is not visually perceptible, but as it has been spread to all Isowa employees, it shows its shape by their actions, little by little. The blue graduation at the bottom reflects this idea.

ISOWA

The last colour is red. Our philosophy is not providing new value or benefits to our customers if we let it just be a philosophical idea. To deliver our philosophy, huge energy is necessary and indispensable. We can never gain that energy by external enforcement. Red is newly introduced as an accent to express our people, who declared to bring our machines and our services to a premium level, with the main purpose of preventive maintenance and to bring results from the corporate culture revolution in the midst of day-to-day operations.

Today our action policy is 'Quickness and Interaction':

- Take the Initiative: Accepting challenges is the highest of virtues.
- Extend a hand: Nurturing mutual trust and communication among people.
- Brighten the atmosphere: Creating a frank and open working environment.

Let's continue to take one more step forward together and onward to another 100 years!





Kadar Computer Intelligent Robot, Empower Smart Factory With Palletizer

In recent years, with the increasing competition in the paper packaging industry, shorter order delivery time, increasing labor costs year by year, and higher product quality requirements, the intelligent production of corrugated boxes become extremely urgent.

"Software and hardware" empower corrugated packaging converters to build smart factories

Kadar Computer Co., Ltd. (hereinafter referred to as: Kadar Computer) is a high-tech enterprise specializing in the development and production of computer control systems for corrugated paperboard and corrugated boxes.

Its corrugator control system, production management system, workshop management system, visual scanning counting machine, AI autonomous learning system, and energy consumption system are sold in dozens of countries and regions around the world.

As an enabler for enterprise digitization and intelligence, for more than 30 years since its establishment, Kadar Computer has not only made continuous progress in the research and development of corrugated packaging machinery control systems, but also has continued to make efforts in the "intelligent solutions for carton production".

With the development of traditional manufacturing intelligence and the deep integration of digitization, informatization and traditional manufacturing, Kadar Computer established the "Smart Logistics" project and the "Smart Palletizing System" project in 2015 and 2019. Through continuous communication with customers, combined with more than 30 years of industry experience, Kadar Computer launched an intelligent robot palletizing system for corrugated box.

At this point, Kadar Computer can help corrugated packaging companies to build smart factories with integrated solutions for the whole factory.



Intelligent Robot – Palletizer for corrugated box

Nowadays, due to the different types of packaging, factory environment and market demand of various paper packaging companies, palletizing has become an urgent problem for converters, and the market's demand for palletizing flexibility is also increasing, which affected many aspects of packaging, and the back end of the production line is no exception.

The Kadar intelligent robot project is led by a doctoral supervisor of Huazhong University of Science and Technology who has been deeply involved in the field of robotics for many years. The equipment has complete

functions and strong compatibility. It can seamlessly connect with the previous process, grab order information in advance, and realize the automatic order change function without manual Intervention, it can reduce labor costs for enterprises and improve production efficiency.

The complete set of electrical control system is come from Siemens/Schneider, and the bus control mode is adopted, which makes the control faster and more accurate with more stronger and more stable antijamming capability. Each part of the machinery is made of high-end materials, the robot arm is come from ABB, and the supporting logistics rollers are made of high strength stainless steel materials, the safety fence is of professional level, and the other supporting facilities are also enhanced versions.

Kadar Computer, Intelligent manufacturing creates the future

Currently, China's demographic dividend is gradually disappearing. We are now vigorously cultivating smart industries, improving smart manufacturing levels and promoting smart applications. Chinese paper packaging companies are undergoing an upgrade from "manufacturing" to "intelligent manufacturing". The key is to realize intelligent, informatized, and digital manufacturing through "software + hardware".

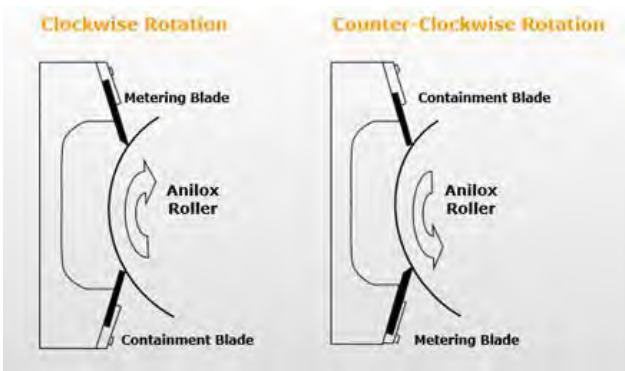
In the future, the corrugated box production model driven by intelligence will be the main direction to enhance competitiveness. Kadar Computer adheres to the business philosophy of "Intelligent inheritance, made by Kadar", with a view to the future, and gradually develops into a supplier of professional and complete plant-wide intelligent solutions in China's paper packaging industry.



The Way to Install Your Doctor Blade in Enclosed Chamber System

In the corrugated market, correct doctor blade installation is critical to optimize press performance and contain costs. If blades are installed properly, the printer will benefit from maximum blade and anilox life and consistent print results. Incorrect installation will result in accelerated blade and anilox wear, chamber leaks, increased press downtime and waste. Many factors influence blade installation such as blade positioning, orientation, angle, alignment and pressure.

Blade Positioning and Orientation

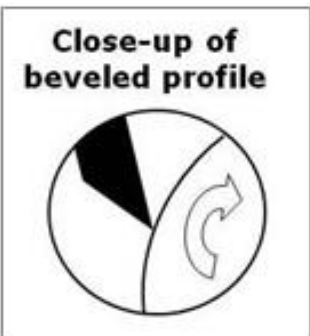


When installing doctor blades, the metering and containment blades must be positioned correctly for best results. Depending on the rotation of the anilox roll, the metering blade could be positioned on the top or the bottom of the chamber. It is important to remember that the metering blade is always the last blade to contact the roller prior to transferring to the plate, and the containment blade is installed in the opposite location.

If the metering blade and containment

blade are installed in the wrong position, the metering blade will not achieve the appropriate point of contact with the roll and remove the correct amount of ink before transfer.

The bevel tip should point away from the roll or towards the chamber when a blade is being installed to prevent streaking. The anilox roll and doctor blades were designed to work together and proper blade positioning and orientation are essential to their mutual performance.

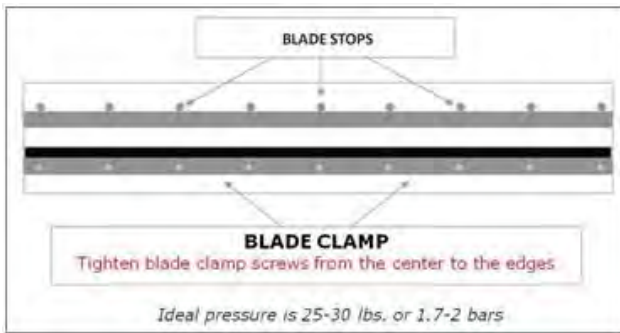


Blade Angle

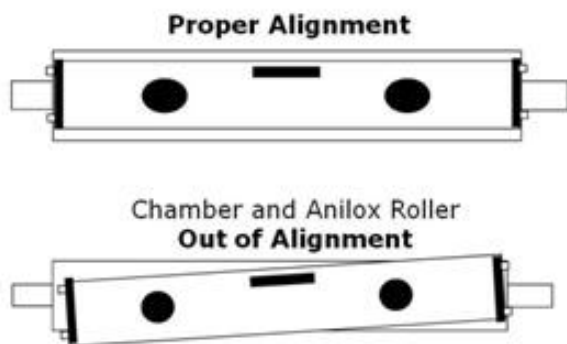
The blade contact angle is the angle at which the blade comes into contact with the anilox roll. Ideally, the contact angle should be 30° tangent to the anilox roll circumference for optimal performance. If the angle is less than 30°, a larger part of the blade's edge will come into contact with the roll and the contact area will be too big to meter properly. Likewise, if the contact angle is greater than 30°, the blade will not provide the best possible metering.

Blade Alignment and Pressure

A properly installed doctor blade will have uniform, balanced contact with the anilox



roll and remove ink consistently across its surface. When a blade is properly aligned, light pressure with the roll is all that's needed to produce a consistent wiping action. The recommended pressure is 25 to 30 lbs. or 1.7 to 2 bars. Upon installation, a blade should be tightened beginning in the center and then outward toward the edges. The clamps should not be over-tightened or the blade may buckle. Using the correct amount of pressure will not only ensure good metering performance but will also extend blade and anilox life. If a blade is installed with too much pressure, the tip is forced to bend over and it loses a good contact point with the roll. When this happens, the anilox roll is flooded with ink.



If the blade is not properly aligned, its contact with the anilox roll is uneven along the length of the roll. This can be caused by blade holder misalignment, poor doctor blade seating in the holder, or uneven pressure adjustment on the sides of the chamber or bolts securing the doctor blade. When this occurs, the operator will often crank down on the pressure until the full length of the doctor blade is forced into contact with the roll. The

excess pressure and increased friction cause accelerated blade and anilox wear. Press operators may also attempt to resolve chamber leaks by moving the chamber closer to the anilox roll. This often intensifies the problem by forcing ink out



of the ends of the chamber. Instead, choosing the correct end seals and replacing them regularly can prevent leaks. To avoid problems arising from excessive blade pressure, blade pressure should never be increased to resolve issues relating to improper blade alignment or chamber leaks.

To ensure that systems are aligned, follow these steps:

1. Place 2 blades in the chamber without end seals.
2. Slowly engage the blades against the roller.
3. Make sure that both blades contact the roller at the same time. If they don't, adjust the system so they do.
4. Repeat for both drive side and operator side of the press.
5. Set the chamber so it can travel no more than 1/8" after the blades make contact with the anilox roller.

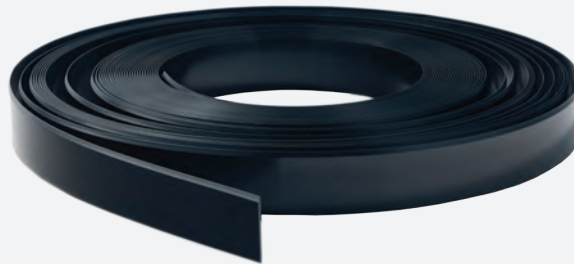
In corrugated applications, correct doctor blade installation is essential to ensure good transfer of ink to the plate and prolong doctor blade and anilox roll life. Training of press operators in proper installation techniques will ensure optimal blade performance, reduced costs and consistent print results.

TRUPOINT
GREEN®



With better stiffness, greater creep resistance and longer blade life, the Green doctor blade is the perfect replacement for UHMW and steel blades for moderate printing.

TRUPOINT
DURAPPOINT™



with

Technology

This innovative doctor blade is a next-generation UHMW product offering significantly increased run time, superior blade life and consistent ink metering throughout the life of the blade.

TRUPOINT
UHMW™



For more information or to request a free sample:
go.flexoconcepts.com/CW





LITHO LAMINATORS

Litho laminated packs in B, E, F and N or G flute continue to show market growth as they displace unit containers, multipacks, shelf ready transit outers and continue to dominate the decorative sector. Strong marketing of laminated fineflute packs is helping to fuel that growth – with the finer microfluted grades set to take an increasing market share. This is a trend that is being seen across the whole of Europe and USA.

Laminators are available as semi-automatic sheet to sheet machines – for single face laminating, spot and full labelling, spot and full chipboard laminating, dual label mounting and windowing – through to full in-line laminators akin to a short, narrow width corrugator.

Expanded Portfolio

BOBST has expanded its litholaminator

portfolio with a series of sheet-to-sheet laminators that cover all market segments - from high quality yet simple manual setup machines to high-end, ultra-high performance, fully MATIC production lines.

A new sheet feeder has been developed to support the machines. It uses proven Bobst suction head technology and 'Touch Screen' operation panels, along with other key features and technologies.



△ Masterstar

The flagship of the new family of sheet-to-sheet laminators is MASTERSTAR. Offering the highest output, it is automated and versatile, capable of producing excellent laminated board quality and performance. Its 'Power Aligner' system is used for individual and dynamic sheet registration in both directions. Special features and a large choice of options will make this automatic sheet-to-sheet laminator a competitive and efficient display and packaging producer. Smart options deliver 'zero-fault' production, perfect humidity and total accuracy. 'Gapro Nano', 'Power Aligner' and 'Matic' set-up come as standard.

The fully automatic single face pre-feeder is optional and completes a one operator system.



△ Gapro Nano

The new EXPERTSTAR is a versatile performer. A user-friendly and ergonomic machine which can be configured to operate at high speed or as the ultimate display runner, it is perfect for double-sided lamination using a double register system. Many options are available to adapt to the desired application. Expertstar can be equipped with a single face pre-feeder for full 'Matic' operation.

The new NOVASTAR is a good quality, manual set-up machine which is easy to operate. With an optional 'Gapro Nano', providing low glue consumption and a

running speed of up to 6,000 sheets per hour, it is suitable for short run work as well as packaging orders. Several options are available, such as a humidification system in order to produce perfect sheets.

Bobst has already installed Beta machines in Germany and Poland and will begin production of these new products for the second half of 2020.

The company is experiencing an increase in demand for web-to-web applications for litho-laminated board packaging caused by the availability of pre-printed (digital and flexo) webs. Material is being used for short runs and is finding its way into large format, high quality sheets for offline digital printers – even web-to-web on to double wall is available.



△ Novastar

Double wall combinations are used mainly in the POS and display markets, as well as in larger packaging formats, which require greater strength and robustness.

The premium 1650mm MASTERFLUTE TOUCH and EXPERTFLUTE TOUCH solutions are used by the world's leading producers of litho-laminated products.

Masterflute Touch and Expertflute Touch can be configured for a range of applications including sheet-to-web lamination, high speed in-line double-wall laminating, the conversion of pre-printed liner and web-to-web laminating. The systems can be configured for offset sheet lengths of 1650mm or 2050mm and up to 2200mm for web to web applications.

Novaf flute is the entry-level Inline laminator suited to growing markets for 1450mm paper width. Supplied with a new MF150 cassette Module Facer, it incorporates 'Touch Screen' operations but requires a manual set-up. The web laminator unit on the Novaf flute is new and enables pre-printed web conversion which is currently being commissioned in China.

www.bobst.com



△ MasterFlute Touch

Customer-Driven Solutions

Lamina System have been producing and selling litho laminating machines for nearly 40 years and today, the company has machines in around 110 countries worldwide.

The company produces machines for all kinds of customers, from smaller businesses to larger integrators. "We are listening to our customers' needs and always try to find a good solution for them," says Peter Hjalmarsson, Managing Director.

He continues, "Our range of laminating machines cover the complete range, from manual, compact machines that are ideal for getting you started, through semi-automatic machines, where the bottom feeder is automatic and the top sheet is fed by the operator. We then also offer fully-automatic machines. In this range, Lamina have a lot of different options depending what kind of material and also what speed the customer desires."

Customers can choose different options to the machine – pressure belt, flip flop turner, down stacker or glue container system, for example. These options can be added into the machine later on as well, giving customers the chance for the machine to be enhanced as capacities grow.



△ Fasline Edge



△ Lamina SA



△ Lamina FA 800500

"The benefits with our machines include quick set up time, excellent registration up to 0.2mm, userfriendly set-up and operation as

well as low glue and electricity consumption and easy cleaning," adds Hjalmarsson. "We have spare parts in stock and our technicians are always ready to support."

Due to the postponement of this year's Drupa, Lamina will invite customers to an Open House at its premises in Borås, Sweden so that they can show and test run machines. If you are interested in more information regarding this event, please send an email to sales@laminasystem.com.

www.laminasystem.com

Busy period

CONTROL-ING® Laminators has had a busy second half of 2019 in terms of sales and installations, but the most important strategical activity has been the set-up of an Asian branch in Taiwan.

Control-ing Taiwan is taking care of sales in the whole of Asia with its own manufacturing facility, where machines will be built under licence of Controlling Spain, especially adapted to the particular local market requirements.



△ Control-ing Taiwan



△ Machine acceptance

A complete in-line laminator has been installed in Taiwan as a demonstration machine for those companies interested to acquire such equipment in Asia.

The machine acceptance of a complete new laminator line (including web to web with cut to mark), took place in the second half of 2019.

Currently in the company's workshop is an upgrade of an existing Control-ing sheet-to-sheet laminator. It is being built so that the finished machine will be able to do both sheet to sheet and reel to sheet jobs. Installation is planned for the second half of 2020.

Customers are increasingly interested to equip their existing machines with the CONTROL-ING® double wall system on the laminator, which produces flat board. Those who are interested can check the machine that is running at a plant in Germany for more than five years with this device.

Meanwhile, the 'Flying Carpet' single face board sheeter/stacker developed by Control-ing is drawing attention from all kinds of industries and not only for board applications. The machine that transports the sheets by vacuum 'hanging from the ceiling' from the moment of being cut until being stacked and thus 100% under control for a perfect positioning, has the following special features:

- Working width: 1850mm;
- Up to three sheets on the width by means of thin blade slitting with side trim;
- Carbon fibre, double rotating helical cross cut knife;
- Automatic Non-Stop device for pallet change;
- Ability to run in-line with a single facer;
- Open flute-up or open flute-down;
- Ejection of bad sheets by a push button from a remote control;
- Possibility to run solid board.

The machine model is called RDV and video images are available to be able to understand this special transport and stacking concept for non-rigid sheets.

CONTROL-ING® laminators are manufactured by Simon Corrugated Machinery s.l. in Spain.

The company has released a new company brochure for customers who prefer to have a physical document in their hands rather than getting only digitalised information. For those interested to receive such a brochure, please request one from sales@control-ing.com.

www.control-ing.com

Successful Collaboration

In 2009, a successful cooperation between BP Agnati and Stock brought to the market a new level of high speed inline laminators. This new technology has been appreciated by the market and numerous companies have purchased this new LithoLiner as it became a proven combination with the highest quality and performance.

At the beginning of 2020, Fosber Group acquired 60% of the business of BP Agnati srl. The result is an even stronger company technically and financially, with a worldwide presence both in corrugated board production and the folding carton and specialty board production.

The combination of Quantum Corrugated and Stock offers high quality finished laminated sheets with high performance. The machine is equipped with the newest technology and is designed for a speed of up to 220m per min or 12,000 sheets per hr and equipped with a fully automatic set-up. A special feature of this equipment is the capacity to bring together ultralight single face web (60 + 40 gsm) with the printed top sheet (110 gsm).



△ Quantum Agnati inline laminator
Developed with Stock

The machine has an innovative design without mechanical registration, making it suitable for high laminating performance ('On-The-Fly' mode) at highest precision. Both sheets – the printed and carrier sheet – are scanned on the flow, before being laminated together and the printed sheet can then be re-adjusted compared to the carrier sheet. Before the laminating process, the single face web will be glued and cut into sheet. The laminating process is a sheet-to-sheet lamination. Further benefits are maintainability and ease of operation together with a state-of-the-art computerised format set-up. A conveyor system for an automatic pallet change is included for the printed sheet feeder as well as for the down-stacker to reduce the efforts of the operators for a pallet change. The rotary knife with connected direct drive system and two cut-off knife cylinders with helical blades offers easy access for cleaning, readjusting and replacing of the knife blades.

The line is equipped with a mechanical lateral printed sheet alignment to a side guide; a gluing unit with reversible glue metering roller for easy access and cleaning and ensures minimum glue application; PC-control with internet remote access capabilities (Ethernet port) for service and troubleshooting; pallet conveyor systems are available for the printed sheet feeder, as well as for the down-stacker.



△ Quantum Agnati

A more recent development is the automatic non-stop device for the printed sheet feeder, which allows an efficient high speed stack change and enhances the production of the LithoLiner.

As an option, the machine can be equipped with an additional flip-flop, a sheet feeder – with or without prefeeder – for sheet-to-sheet laminating, a reel-to-reel device for laminating a preprinted liner or including a second gluing unit for producing double corrugated board (four layers) to be laminated inline. An optional sheet feeder for sheet-to-sheet lamination with the same inline-machine is also available.

The equipment can be easily customized to meet different production's demands, including laminating on double board.

A key element of a LithoLiner wetend is the single facer group. The proven Quantum Corrugated Vantage Single Facer features an excellent dynamic stability at all speeds and allows it to produce a single faced web with any flute profile, thanks to the possibility of changing the corrugating rolls, assembled in a cartridge, in only five minutes. The high quality of the single faced web is further improved by the lack of pressure marks thanks to the exclusive solid non-metallic pressure roll installed on the VSF. The widest range of papers can be run, from the heaviest to the lightest papers, thanks to the reduced and

adjustable crown on the lower corrugating roll and the reduced labyrinth between the corrugating rolls for a better flute formation – always resulting in the highest quality. A further advantage of the VSF single facer is the low cost of ownership. Preheaters and preconditioners are integrated in the single facer for a more compact machine. All wrap arms are temperature controlled and all working parameters are memorised in recipes based on flutes and paper combination.

The Quantum Corrugated mill roll stands and the high speed splicers, which are equipped with a push-pull device to eliminate web wrinkles – typical when running ultra-light papers – allows high speed production without the need to slow down, even with light weight papers. An automatic paper and glue dam alignment system is available as an option.

The proven performance of this combination has resulted in the sales of the Litholiner to many companies across Europe and overseas in the last few years.

www.bpagnati.com

New Innovations

STOCK Maschinenbau GmbH of Germany has always incorporated the newest technology into its machines and extended the line of equipment offered. Stock offers full sheet laminators, spot labeling machines, sheeter stackers for single face and carton material. Extra care has been taken in the manufacture of all machines to provide fast set-up, modular design, high durability and minimum waste.

The company has increased its range of laminators with a new innovative series of sheetfed laminators, with electronically controlled sheet registration for meeting the highest demands for laminating accuracy

and productivity. The new model – SLOTF-laminator – with its ‘On-The-Fly’ registration (electronic set-up of the sheet overlap) is suitable for laminating all common materials, edge to edge, or with overlap, for the production of POS boxes, display and puzzles with high speed and high accuracy. The newest development is a fully automatic machine without mechanical front lays, combined with lateral adjustment of the top and substrate sheets for high performance and high accuracy. The machine is suitable for thin top sheets and material savings, because the surrounding sheet overhang is less than 3mm.

The laminator runs at speeds up to 10,000 sheets per hr. Without the use of mechanical front stops there are no more impression marks to the front edge of the sheets, neither for the first lamination process nor for the counter lamination. Manual adjustment – requiring time for the adjustment of the front stops – is eliminated. The machine can be equipped with a prefeeder for the automatic non-stop substrate sheet feeding. The largest format is capable of processing a maximum sheet size of 2050 x 1510mm. The latest

fully automatic sheetfed SLOTF, including an electronic register and fully automatic set-up, as well as a pre-feeder for the substrate sheets, was installed at a European converting company.

The machines are distinguished by solid construction, modular design, laminating accuracy, short set-up times, little maintenance and operating comfort and safety. A number of additional units can be added to increase automation, including non-stop down-stacker, a batch pile turner (flip-flop) and prefeeder. The machines are designed to be versatile to run single and double face corrugated, solidboard, foamboard, plastics and more.

A machine with non-stop substrate sheet feeding was developed for producing high value added boxes for spirits, champagne and beverage boxes.

The newest edition to the Stock family of machines is the high-speed inline (reel-to-sheet) laminating machine, which it has developed with Agnati/Quantum Corrugated, illustrated below.

www.stock-maschinenbau.de



△ REEL TO SHEET Laminator

Research on the Method of Testing the Rub Resistance of Printed Ink Layer

Hangzhou PNSHAR Technology R&D Center Bruce Sunny

In daily life, products with good printing quality give people the impression of good quality and high-end, especially medium and high-end exquisite tobacco, wine, cosmetics, health care products, food, medicine and other products that have particularly high requirements for printing. The concept of the environment protection continues to gain popularity, the traditional ink printing can no longer meet the current high-speed, environmentally friendly printing requirements. Some end users directly require suppliers to use solid, environmentally friendly UV inks for printing. If the printing effect is far from the standard, the product will be returned or the supplier qualification will be cancelled! Therefore, in order to ensure the stability of the printing color and the rub resistance of the ink layer, many packaging printing plants generally use some testing instruments such as reflection densitometers, friction testers, etc. to test the printing quality. The physical property of ink layer rub resistance is a must for printing companies such as medium and high-end color cartons and color boxes to test this item.

There are specific provisions in the product standard for the rub resistance of the ink layer of printed matter, such as GB/T 7706-2008, JIS. K.5701-1:2000, ASTM. D5264, TAPPI. T830-2011.

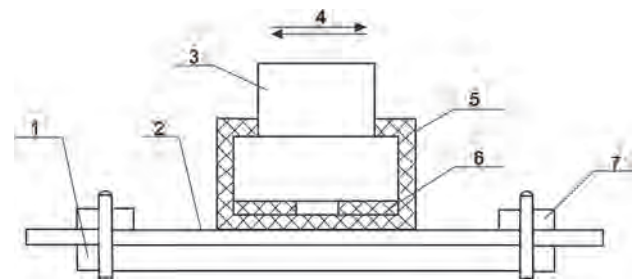
1. Apparatus

The rub resistance test of the ink layer

requires the use of a friction tester and a reflection densitometer

1) Requirements for rub resistance tester

The rub table adopts a rigid plastic body with a surface roughness of not less than $1.60\mu\text{m}$, and has a device to fix the sample; the rub body adopts two rubbers with a thickness of 8mm, a hardness of 50HS \square 53HS, and a size of 25mm \times 50mm, and two rub bodies has a 45mm inner space; The rub speed of the test is 43 times/min \pm 2 times/min, and the stroke is about 60mm. For example, Pnshar PN-PIDF ink rub tester, which is an upgraded version of PN-PID ink rub tester, the display adopts a more fashionable capacitive touch screen with a WIFI module, and the test data can be automatically uploaded to the cloud server under the network condition. The schematic diagram of the friction testing machine is shown in Figure 1.



△ Figure 1 Schematic diagram of ink rub tester

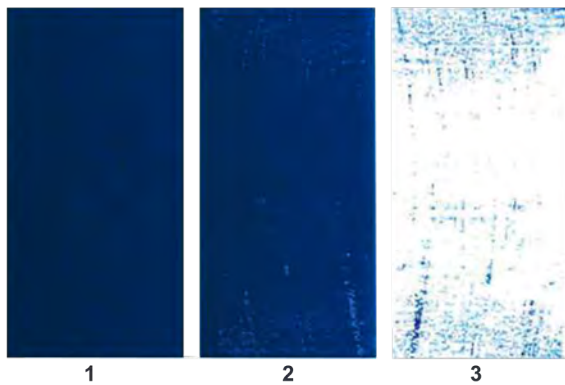
- 1—Friction table 2—Sample 3—Load 4—Run Direction 5—Friction paper 6—Friction Block 7—Sample Holder

2) Reflection Density Meter

Use a reflection densitometer that conforms to GB/T 23649 and use the method specified in GB/T 18722 For example, X-Rite Spectrodensitometer X-Rite Series 500 can measure CMYK four-color density with an accuracy of 0.001D.

2. Test principle

Test principle: Fix the rubbing paper on the rub body, and fix the sample to be tested on the rub table, so that a certain friction force is generated between them. The rub test is performed on the sample by setting the friction speed and friction times The naked eye or reflection densitometer compares the ink layer wear or ink density change before and after rubbing to judge the wear resistance of the sample. The schematic diagram of the comparison before and after friction is shown in Figure 2 below.



△ Figure 2

1. Before rubbing
2. After rubbing
3. Rubbing paper after rubbing

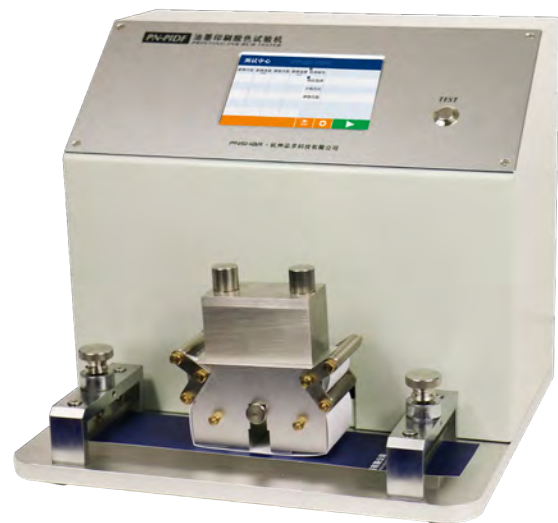
3. Test conditions

- (1) The rubbing paper is 80g/m² clean offset paper with a width of 50mm.
- (2) The load is 20N±0.2N.
- (3) The rubbing frequency is 43 times/

min±2 times/min, and the stroke is about 60mm.

4. Test procedure

- 1) Prepare rubbing paper and sample
The sample cut to a certain size and fix it on the rubbing table, and the area of the sample layer to be tested should be larger than the area rubbed by the rub body. Generally, the size of friction paper is 210mm×50mm, and the size of sample is 280mm×60mm.
- 2) Place rubbing paper and sample
Fix the sample on the rubbing table and fix the rubbing paper on the rub body.



△ Figure 3 PN-PIDF Ink rub tester

3) Parameter setting

Select the B gear 43 times/min and set the rubbing times.

4) Test

Before the test, use a reflection densitometer to test the color density of the sample to be rubbed, measure 3 points and take the average value D₀; on the ink rub tester, press the "test" button to execute the test, when the set times of tests is reached, it will automatically stop and the screen Display "test completed"; after the test is completed,

use a reflection densitometer to test the color density of the ink layer with the most severe friction of the rubbed sample, measure 3 points and take the average value, and count it as D .

5) Test results

Formula for calculating rub resistance of ink layer:

$$A_s = \frac{D}{D_0} \times 100\% \quad \dots\dots\dots(1)$$

Here:

A_s --- The rub resistance of the ink layer

D --- Average density value of the sample after rubbing

D_0 --- Average density value of the sample before rubbing

After the test is over, you can also observe the ink adhesion on the rubbing paper to judge the rub resistance of the friction sample. The sample with strong rub resistance is still very clear after repeated rubbing, and the ink will not be stained with the rubbing paper in contact with it; Samples with poor rub resistance, after repeated rubbing, become fuzzy, have obvious scratches, fade and other undesirable phenomena, and the ink will stain

the rubbing paper that comes in contact with it..

5.Comparison different standards

At present, the international standards for rub resistance are mainly Japanese standard JIS K 5701-1, American standard ASTM D5264, TAPPI T830, and national standard GB/T 7706. The frequency and load of the domestic and foreign standards are shown in Table 1.

It can be seen from this table that the rubbing load of different standards is different, and the conversion relationship is as follows:

$$1 \text{ kg}=9.80665 \text{ N} =2.202 \text{ lb} \quad 1 \text{ N}=0.101971 \text{ kg}=0.225 \text{ lb}$$

The conversion process is as follows:

$$\text{GB/T 7706-2008: } 20 \text{ N}=0.225 \times 20=4.5 \text{ lb}$$

$$\text{JIS K 5701-1-2000:}$$

$$908\text{g}=0.908 \times 2.202=1.999416 \text{ lb} \approx 2 \text{ lb}$$

$$\text{ASTM D5264-1998:}$$

$$0.91\text{kg}=0.91 \times 2.202=2.00382 \approx 2 \text{ lb} \quad 1.81\text{kg}=$$

$$1.81 \times 2.2023.98562=3.98562 \approx 4 \text{ lb}$$

$$\text{TAPPI T830-2011:}$$

$$908\text{g}=0.908 \times 2.202=1.999416 \text{ lb} \approx 2 \text{ lb}$$

$$1816\text{g}=1.816 \times 2.202=3.998832 \approx 4 \text{ lb}$$

It can be seen from Table 1 that the rubbing speed of different standards is also different, but the rubbing speed of 42 times/min and (43±2) times/min can be considered the

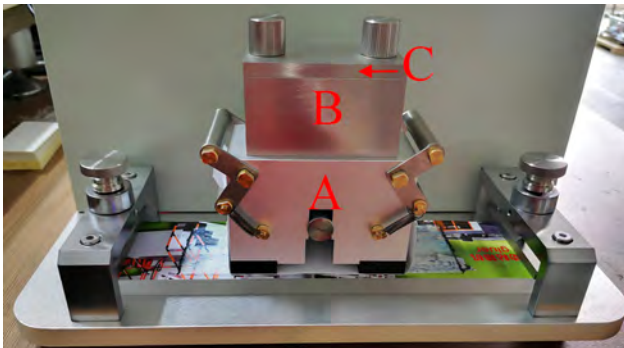
Table 1

Standard	Rubbing speed (r/min)	Load	Note
GB/T 7706-2008	(43 ± 2)	20N ± 0.2N	4.4-LB
JIS K 5701-1-2000	(43 ± 2)	908g ± 10g	2-LB
ASTM D5264-1998	21、42、85、106	0.91kg、1.81kg	2-LB、4-LB
TAPPI T830-2011	21、42、85、100	908g ± 45g、1816g ± 90g	2-LB、4-LB

same, we call it the standard rubbing speed. In order to adapt to materials with poor rub resistance, the rub speed can be reduced by half to 21 times/min; for materials with higher rub resistance, it can be doubled to 85 times/min; for super rub-resistant materials, the speed can be increased again. The 106 and 100 times/min in ASTM and TAPPI standards are about 2.5 times the standard speed; in addition to increasing the speed, you can also increase the load. The load of 4LB is exactly twice that of 2LB. For materials with good wear resistance, we can save test time and improve efficiency by increasing speed and load.

6. Load composition of Pnshar rub body

The composition of the rub body: A lower rub body, B middle rub body, C upper rub body (including the above 2 screws)



△ Figure 4 Rub body

20N: Lower rub body A+Middle rub body B+Upper rub body C

2Lb: Lower rub body A

4Lb: Lower rub body A + middle rub body B

7. Factors affecting ink rub resistance

There are many factors that affect the rub resistance of inks, and they are also very complex, but it is super simple to consider from the three angles of ink itself, printing paper and printing environment temperature and humidity. The rub resistance of the ink

itself is mainly reflected in the cohesion and adhesion of the ink. When the cohesion and adhesion of the ink decrease, the rub resistance of the ink becomes worse. High rub resistance UV surface oil can be used to improve the rub resistance. Adjust process parameters or replace materials to ensure the adhesion of UV primer. At the same time, it is also affected by the temperature and humidity of the printing environment. In humid weather, the printing machine is prone to blurring and deinking. This is because the weather and humidity cause the sample to become damp and soft, and the printing machine must increase the pressure. When the ink is transferred to the paper, due to the high humidity of the corrugated cardboard, it is easier for the font to expand, causing blurred printing or deinking. In addition to the ink itself, it is also affected by the water absorption of the printed paper. Paper has low water absorption, accordingly water absorption of the ink naturally decreases. The ink floats on the surface and it is easy to cause deinking. If it is known that the paper has poor water absorption, then it is necessary to start with the tile thread process to improve.

Concluding remarks: The rub resistance of the ink layer of printed matter is an important index of printing performance. The quantitative detection of testing instruments is beneficial to control the quality of printed matter. In addition, through the comparison of different standards, Pnshar PN-PIDF ink rub tester technology has reached the international advanced level and can meet the needs of domestic and foreign markets.



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T: +86 769 82202255
F: +86 769 83483638

Contact: Louis Ho

HP: +65 9750 0348

E-mail: louis.ho@bwpapersystems.com



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A NOTE TO BOX PLANT OWNERS AND GMs


BY DICK TARGET

“ON TARGET” CONSULTANTS

Over the past several years, I have written many articles that discussed machine calibration, ink management and suggestions on how to improve your suppliers' performance and consistency. In today's competitive market, we need to stay ahead of the curve. Competition is not just in North America but in many countries in the EU and around the world. China, Vietnam, Korea, New Zealand (wine products) and India to name a few. As box makers, we must be aware and understand the manufacturing methods and board combinations that the world is using. The paper combinations are no longer the same standards that we have used over the last 50+ years. The standards are a moving target and

again, we must understand and respect what everyone is doing. We are all customers as well as competitors and there is a lot to learn from what we see and consume.

In most of the European community, shippers, manufacturers and consumers are all taxed on waste, trash and items that are thrown away. This adds to everyone's personal costs as they must absorb and make this part of their daily lives. This taxing practice has been a driving force in reducing the weight of boxes by reducing fibre content. From this, we have learned that lighter weight shipping containers can work as they do satisfy and or exceed customers' packaging and shipping requirements.



HOW CLOSELY ARE YOU
MONITORING MACHINE
PERFORMANCE?

AS I HAVE WORKED IN OVER 250 BOX PLANTS AROUND THE WORLD IN 38+ COUNTRIES, THE ATTITUDE IN MOST PLANTS IS THAT SOMEONE ELSE IS TAKING CARE OF THIS PARTICULAR MATTER.

In order to take advantage of this practice, we as managers and owners must focus and carefully watch the operations and machine settings that occur in our plants every day. We work and live in an industry where the details are sometimes overlooked or not taken seriously. As I have worked in over 250 box plants around the world in 38+ countries, the attitude in most plants is that someone else is taking care of this particular task of monitoring machine settings. Top management is too busy overseeing the entire operation and getting orders; production managers are busy scheduling and floor supervisors are busy expediting orders, finding stock, locating tooling while machine operators are responding to the lineup and daily production requirements.

As manufacturers of corrugated products, it is necessary to have consistency in all machine settings regardless of their size (in both machine width and roll diameters). It is a common practice for plants to run the same orders from big customers, week after week, on different flexos and die-cutters on the floor depending on the scheduling for that particular day. These boxes have to be made all the same. Note: The people in the scheduling department also have no specific knowledge of the nip's settings or offsets from machine to machine.

They never go to the floor as they are busy doing their job. Based on this fact, it can be difficult to offer consistency for our customers week to week.

Some vertically integrated box plant

customers actually tell their box suppliers which flexos and rotary die-cutters to run their orders. Our customers need boxes that not only work but boxes that are manufactured with consistency. Customers know that there are differences in the machines as they are also manufacturers of many different products and they do understand our challenges.

Some plants print the names of their crews on the flaps as a way of showing that their operators are proud of their work. This identifies the crew and the unique machine centre.

As I previously mentioned, the manufacturing world market is aggressively moving toward an environment where everyone producing corrugated products is using both lighter weight liners and mediums. This has forced the industry to be more sensitive to machine settings. It is not unusual in the U.S. to use liners and mediums that are too heavy and exceed the ECT requirements that customers need. The main cause for this is that the nip settings, specifically in the feed sections of the flexos and rotary die-cutters are improperly set.

When we take an order from a competitor, we just copy the box and hopefully cost it in such a matter that we earn the business. We frequently do not complete testing while establishing the necessary basis weight. The bottom line is that we produce a box that exceeds our customers' requirements as we don't understand the requirement. This adds to our overall manufacturing costs.

THE MANUFACTURING WORLD MARKET IS MOVING TOWARD AN ENVIRONMENT WHERE EVERYONE PRODUCING CORRUGATED PRODUCTS IS USING BOTH LIGHTER WEIGHT LINERS AND MEDIUMS. THIS HAS FORCED THE INDUSTRY TO BE MORE SENSITIVE TO MACHINE SETTINGS.



△ Crews and maintenance departments should have a complete and accurate understanding of the machine offsets for the feed rolls, impression rolls in the print stations, score heads in the slotter sections and nips in the die-cut sections.

Proper Machine Settings

Now back to proper machine settings. Crews and maintenance departments should have a complete and accurate understanding of the machine offsets for their feed rolls, impression rolls in the print stations, score heads in the slotter sections and nips in the diecut sections. We must also not forget the folder entrance section's nips in the folding sections of the flexos.

Assuming the standard for C-flute is 4.0mm, it is a requirement to have the offset nip setting for the feed rolls set at 3mm in order for the feed section to do its job. The 1.0mm offset will allow the press to accurately feed the sheets at high speeds and in register without excessive caliper loss. Depending where we are in the world, this number might be slightly different due to the Sheffield

Number on the surface on the liners. (This is especially important when producing boxes with lightweight liners.)

In the converting process, no more than 0.08mm caliper loss in the non-printed area of the sheet is acceptable. No more than 0.16mm is an acceptable caliper loss in the printed area of the sheet.

If the nip rolls in the feed section are not properly set to obtain these objectives and the sheets are crushed beyond an acceptable standard, the rest of the machine settings are not going to be correct. The liability for this can be extensive.



△ Proper machine settings are necessary to print machine-readable bar codes.

The impression rolls now have to be set differently and individually for each order all the time due to the inconsistency of the sheet caliper as it arrives from the feed section. The crews try to judge what the setting will be based on, what they see and not what the caliper of the sheet is as it arrives in the print stations. The net result will be poor printing, inconsistent bar codes and printing plates that will wear out prematurely.

PLEASE TAKE THE TIME TO UNDERSTAND WHAT IS GOING ON IN YOUR PLANT. BE SURE THAT YOUR ENTIRE TEAM UNDERSTANDS THE REQUIREMENTS.

Here are the offset requirements:

Feed section: For C-flute 1.3mm less than board caliper.

Pull collar machines: Board caliper minus 0.6mm

Impression rolls: Paper caliper 4mm + printing plate thickness 7mm less 0.050mm for crush = 11mm

Slotter section: Score heads set them to 0.100mm.

Slotter heads: 0.254mm less than board caliper Folder entrance nip rolls: 2.54mm

The urethane score heads will have difficulty in producing consistent and accurate scores in the sheet, making it very difficult for the customer to precisely fold the flaps in automatic case erectors. In today's market, this is critical.

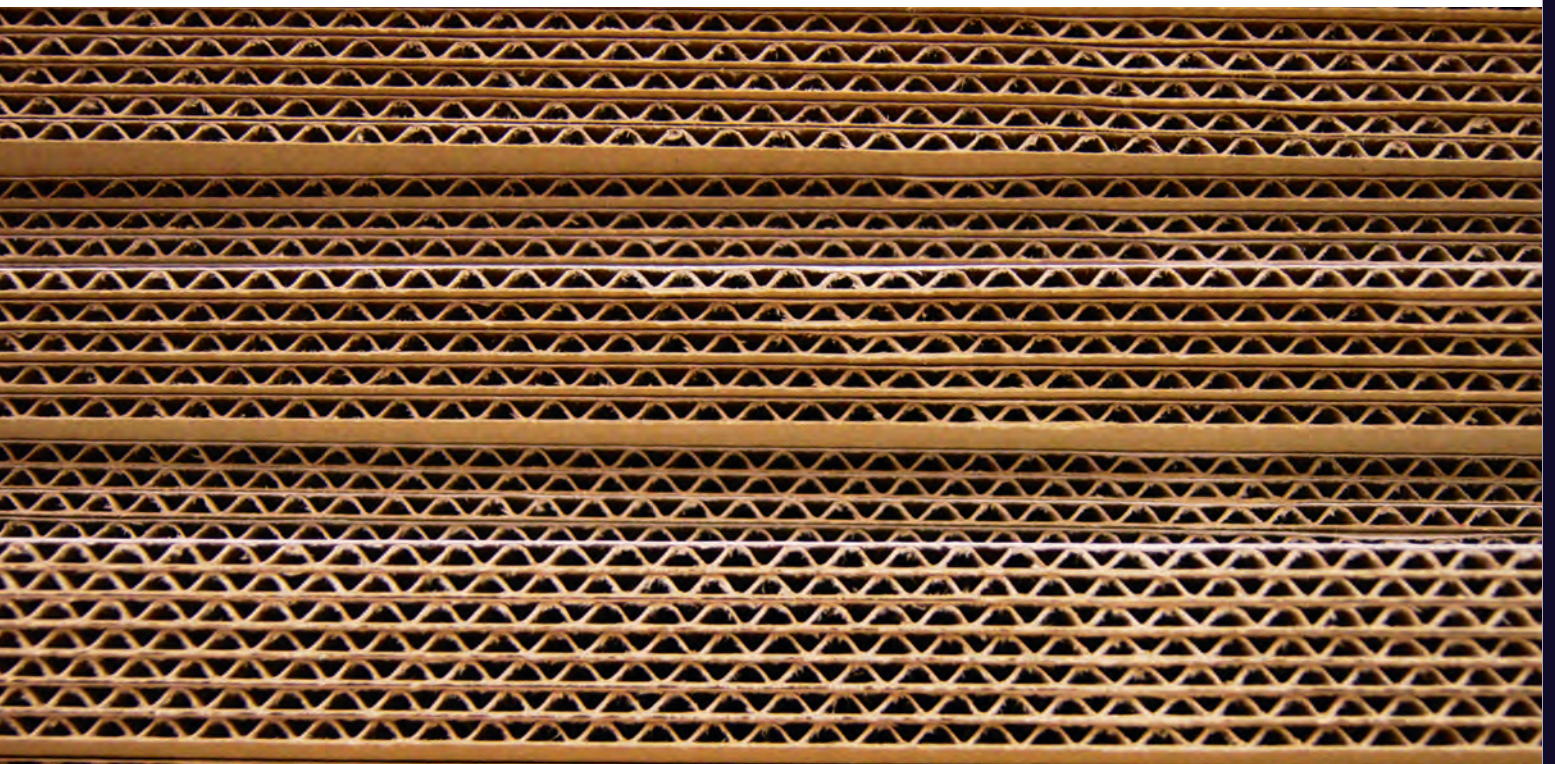
All these factors directly affect manufacturing costs, contribute to unscheduled downtime and can result in a disappointing bottom line. Think about this: When a dissatisfied customer returns a trailer load of finished boxes (maybe 7000 boxes) that did not satisfy his or her requirements, who

pays for the replacement order? Considering the fact that a strong percentage of the cost is paper followed by labour, this can be a huge cost that the plant pays for directly.

I am discussing some of the machine setting details in this article, as I want the management team to learn and understand what the requirements are in order to run a productive flexo and die-cutter operation while running a profitable plant. Everyone must be on the same page from the top down. I do understand that many of the machines that we use today are computer controlled and are automatically set, but the settings must be accurate. The machine suppliers do not always understand the thickness of your printing plates or cutting dies. So, the nip settings may not be correct in your print stations or die-cut sections. Make sure that you close that loop.

Please take the time to understand what is going on in your plant. Be sure that your entire team understands the requirements. Make sure that you understand the maximum performance of your converting machines.

As always, Enjoy your job!





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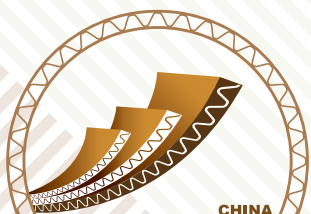
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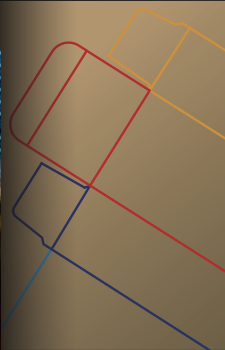
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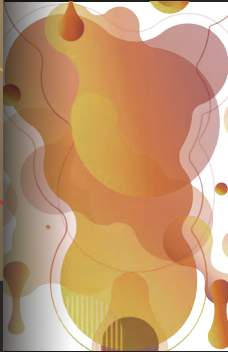
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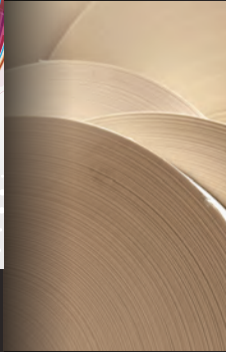
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	<p>Shanghai Dinglong Machinery Co.,Ltd. Address: No.501 Fengxiu Road, Fengxian, Shanghai, P.R.China Tel: +86-021-67180698 Fax: +86-021-67181278 Web: www.shdljx.com</p>	<p>FFG Printing Machine</p>	
	<p>Kadar Computer CO., LTD China address: Taiying Industrial Park, Hongmei Town, Dongguan City, Guangdong Province, China Tel: +86-0769-85901555 Fax: +86-0769-85925811 Web: www.kadarnc.com E-mail: kadarlan@163.net; kadarsales@163.com</p>	<p>Production Management and Control Corrugating Roller</p>	
	<p>Kadar Computer CO., LTD Taiwan address: 18F-2, NO.77, Sec. 1, Xintai 5th RD., Xizhi Dist, New Taipei City 221, Taiwan Tel: +886-2-26982222 Fax: +886-2-26982121 Web: www.kadarnc.com E-mail: kadarlan@163.net; kadarsales@163.com</p>	<p>Production Management and Control Corrugating Roller</p>	
	<p>Qingdao Kaituo-NC Equipment Co., Ltd. Address: Room1707, Plage Mansion Bld. 2, Shenzhen Road No.230, Laoshan District, 266101 Qingdao ChinaAttn: Peter/ Ma GangExport Sales Director Tel: 0086-532-8897 789 E-mail: sales@kaituo.cn Mobile: 0086-13791989283, 18562782959</p>	<p>Dry End of Corrugator</p>	



Special Note:

1. The certified suppliers of China Packaging Federation Paper Products Committee refer to the members of China Packaging Federation Paper Products Committee and the Industry Brand Suppliers;
2. China Packaging Federation Paper Products Committee will provide active coordination in case that Asian corrugated manufactures have comments or suggestions on after-sales service issues after purchasing the products made by the above-mentioned certified suppliers;
3. If Asian carton box factories want to purchase the products made by the above brands, CPFPPC will give positive and professional recommendations.

	<p>Yixing Tianhao Roll Manufacture Co.,Ltd Address: 33 West Shenxing Rd.,Nancao Town,Yixing City,Jiangsu Prov.,China. P.O.Box:214217 Tel: 0510-87854868 Fax: 0510-87854186 Web: www.thzg.cn/www.tianhao-cn.com E-mail: web888@tianhao-cn.com Name: Haoliang Wang Mobile: 13570105110 E-mail: 416181296@qq.com</p>	<p>Corrugating Roller</p>	
	<p>Shanghai Juer Packaging Machinery Co.,Ltd. Contant: Edward Tel: 18939708350 E-mail: Edward_sh@126.com Contant: Mr.wu Tel: 13311803046 E-mail: 1811588392@qq.com</p>	<p>Feeding Equipment</p>	
	<p>Century Machinery Co.,Ltd. Address: No.6,Xinchuan Street,Anqiu City,Shandong Province,China Contant: Cathy Tel: 18365625151 E-mail: sales@century-pack.com Web: www.century-pack.com</p>	<p>Die-cutter</p>	
	<p>GUANGDONG WANLIAN PRECISION SCIENCE & TECHNOLOGY CO.,LTD Address: NO.7Huanzhen Road East,Beijiao Industrial Zone, Shunde,Foshan,Guangdong,China.P.C:528311 Contact: Crystal Luo Mobile: 13924886028 Tel: 0757-26633878 26603232 Fax: 0757-26636731 Web: http://www.wljx.com E-mail: market@wljx.com</p>	<p>Corrugator</p>	
	<p>GuangZhou KingTau Machinery & Electronics Equipment Co.,LTD. Address: No.10 YuHua Road JiuYu Development Area Xintang GuangZhou City Tel: 020-82679230 Fax: 020-82675950 E-mail: Email: Edward_sh@126.com Mobile: 15221280650</p>	<p>Digital Printing Machine</p>	

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- 3.If Asian carton box factories want to purchase the products made by the above brands, CPFPPC will give positive and professional recommendations.

	<p>Flexo Concepts Address: 100 Armstrong Rd STE 103, Plymouth, MA 02360, USA Tel: USA: +1 508-830-9506 Contact: Steve Kao ASIA: +886-970540928 Fax: +86-21-5970 2566 Web: www.flexoconcepts.com E-Mail: info@flexoconcepts / skao@flexoconcepts</p>	<p>Doctor Blade</p>	
	<p>Guangzhou Xiaohua Packaging Machinery Co.,Ltd Address: Xinling Road,Shiji Town,PanYu District, GuangZhou city,GuangDong Province,China Tel: +86-020-33553870 Fax: +86-020-34553871 Web: www.xh-world.com E-mail: xhjd@vip.163.com</p>	<p>Starch Kitchen of Corrugator</p>	
	<p>GUANGDONG DONGGUAN JIUFENG CARTON MACHINERY CO.,LTD Address: 1 Street Kuishu Road,Xiaoxiang,WanJiang Town,Dongguan City,Guangdong Provice,China Contant: Chen Shi Yu Tel: 0769-22171998 E-mail: sales@gddgjf.com/888@gddgjf.co Web: www.gddgjf.cn</p>	<p>Printing Machine</p>	
	<p>JIUFENG(INTERNATIONAL)INDUSTRY LIMITED Address: Rooms 05-15,13A/F,South Tower,World Finance Centre,Habour City,17 Canton Road,Tsim Sha Tsim Sha Tsui,Kowloon,Hong Kong. Contant: Chen Shi Yu Tel: 0769-22171998 E-mail: sales@gddgjf.com/888@gddgjf.co Web: www.gddgjf.cn</p>	<p>Printing Machine</p>	
	<p>HANGZHOU PNSHAR TECHNOLOGY CO.,LTD. Address: 2-6 NO.948 Donxing Road, Hangzhou, Zhejiang P.R. China Tel: 0086-18366260007 Fax: 0086-571-8835 1263</p>	<p>Corrugated Testing Machine</p>	

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- 3.If Asian carton box factories want to purchase the products made by the above brands, CPFPPC will give positive and professional recommendations.

 <p>HSIEH HSU MACHINERY CO., LTD Address: No.141, Lu Chu St., Lu Chu Li, Lu Chu Dist., Tao Yuan City, Taiwan. Tel: +886-3-3221314 Fax: +886-3-3226206 E-mail: hsiehhsu@ms16.hinet.net Web: http://www.hsiehhsu.com.tw</p>	<p>Corrugator</p>	
 <p>C.U.E. ASIA LIMITED Address: 12/F, Allied Kajima Building, 138 Gloucester Road, Wanchai, Hong Kong Tel: +86-137-0634-8282; +86-137-0898-2028 Web: www.cue-asia.com E-mail: monica.cao@cue-asia.com</p>	<p>Anvil Cover</p>	
 <p>Jiangsu Newkuani Technology Co.,LTD Address: Beihai Road,Jingang,town,Zhangjiagang City, Jiangsu Province China Tel: +86-512-58775998 Fax: +86-512-58757998 E-mail: Nkuani@163.com David Yu Mobile: 18205059801 Web: www.newkuani.com</p>	<p>Materials Handling</p>	
 <p>Jiangsu Xutian Environmental Protection Machinery Co., Ltd. Address: No.158, Qingnian East Road, Xiting Industry Park, Tongzhou District, Nantong,Jiangsu,China Tel: 0513-86831966 Fax: 0513-86831900 E-mail: sales@xtbaler.com Mobile: 18068992889 Nancy Chen Web: www.xtbaler.com www.xtpack.com</p>	<p>Waste Paper Packing Machine</p>	
 <p>Kenhua Baler Machinery Manufactory (H.K.) Limited Address: No.561,Qiaolong Road,Qiaotou Town,Dongguan City,Guangdong Province,China Tel: 769-81039183/83349603 Fax: 769-83349602 E-mail: info@kenhua.com / cindy.tang@kenhua.com Mobile: +86-15916836688 +86-17827328688 +86-13902612230 Web: www.chinabaler.com</p>	<p>Strapping Machine</p>	

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- 3.If Asian carton box factories want to purchase the products made by the above brands, CPFPPC will give positive and professional recommendations.

 <p>JEE FENG</p>	<p>Dongguan Jee Feng Cutter Co., Ltd. Address: No. 2, Haitian 2nd Road, Caibai Management Zone, Daojiao Town, Dongguan Tel: +86 769-88333678 Fax: +86 769-88333748 E-mail: jeeffeng@jeeffeng.com</p>	<p>Knife</p>	
	<p>BW Papersystems Seng Avenue# 04-07 UE Print Media HUB Address: Singapore 534 167 Tel: +65 6382 6912 Fax: +65 6382 6913 Website: www.bwpapersystems.com</p>	<p>Corrugator</p>	
	<p>BW Papersystems Dongguan K&H Machinery Co. Ltd Address: Guohai Road, Chen Wubei Village, Changping Town,Dongguan, Guangdong, China Tel: +86 769 82202255 Fax: +86 769 83483638 Contact: Louis Ho HP: +65 9750 0348 E-mail: louis.ho@bwpapersystems.com</p>	<p>Corrugator</p>	
 <p>启德</p>	<p>Dongguan Qide Machinery Co.Ltd Contact: Miss Gao +86 13790355968 Mr.Yu +86 18929479168 Oversea: Talon Lai +86 13686669384 E-mail: lai@qidemachinery.com</p>	<p>Nailing Machine</p>	

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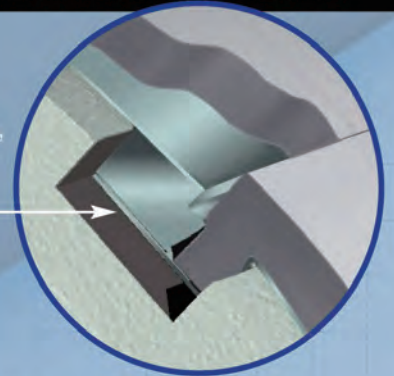
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Headquarter: Room1707, Plage Mansion Bld. 2, Laoshan District, 266101 Qingdao China

Production base: Lingang Industrial Park, Qingdao, China