

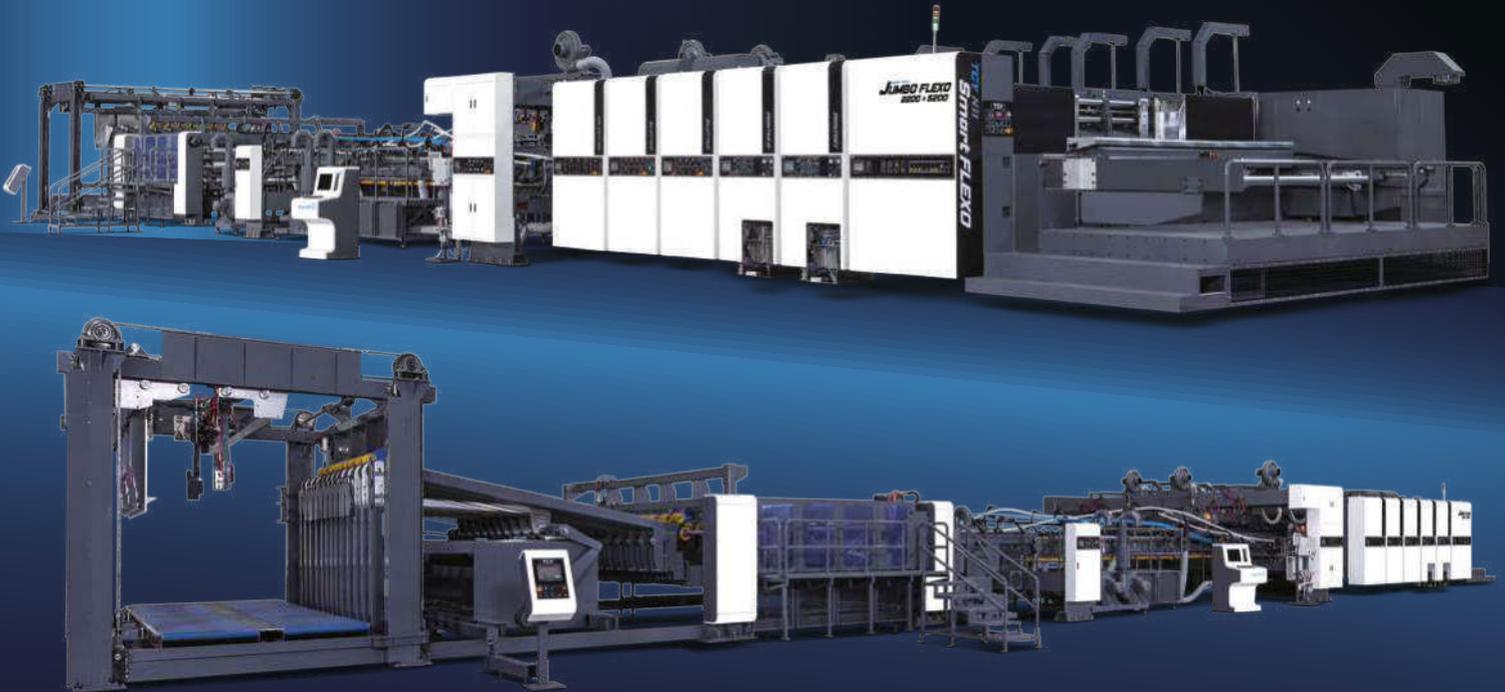
INTERNATIONAL PAPER BOARD INDUSTRY

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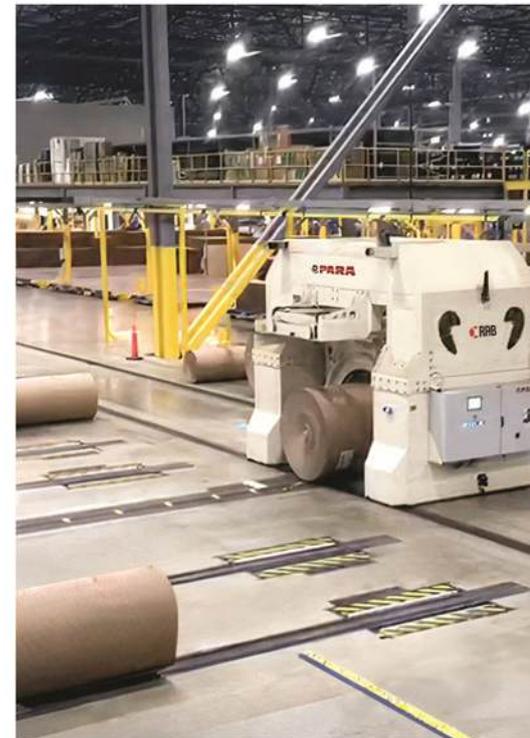
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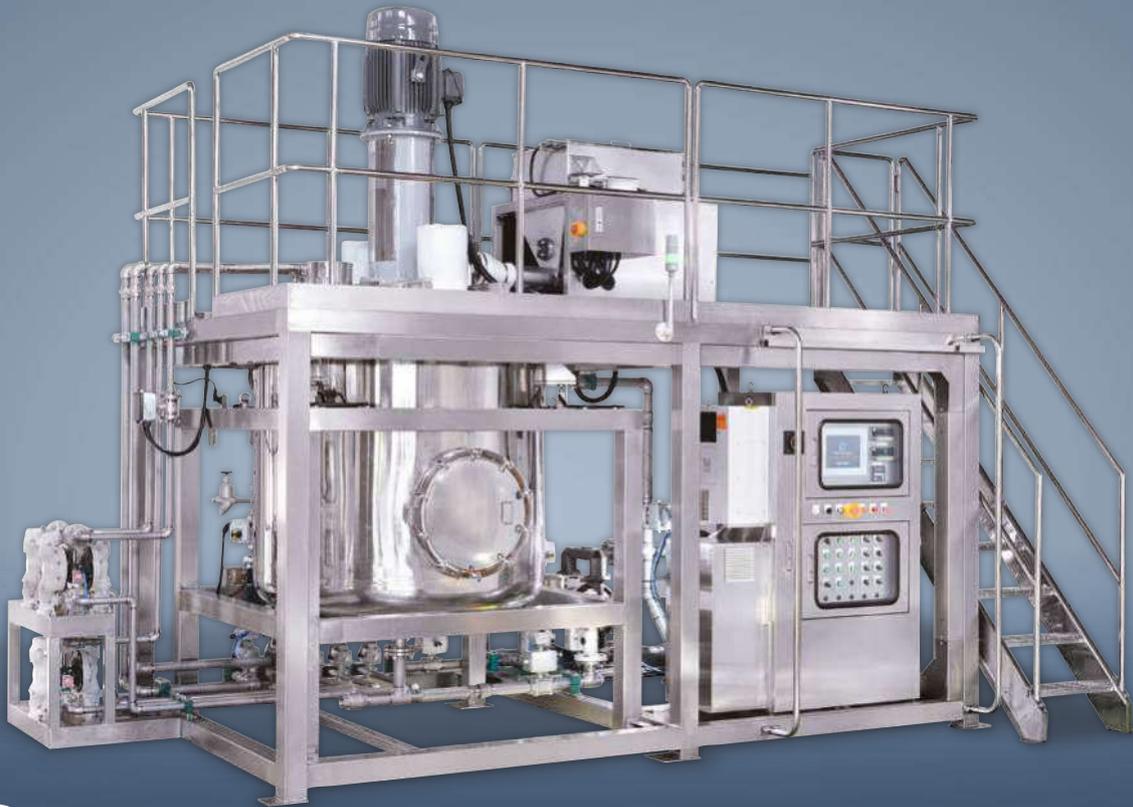


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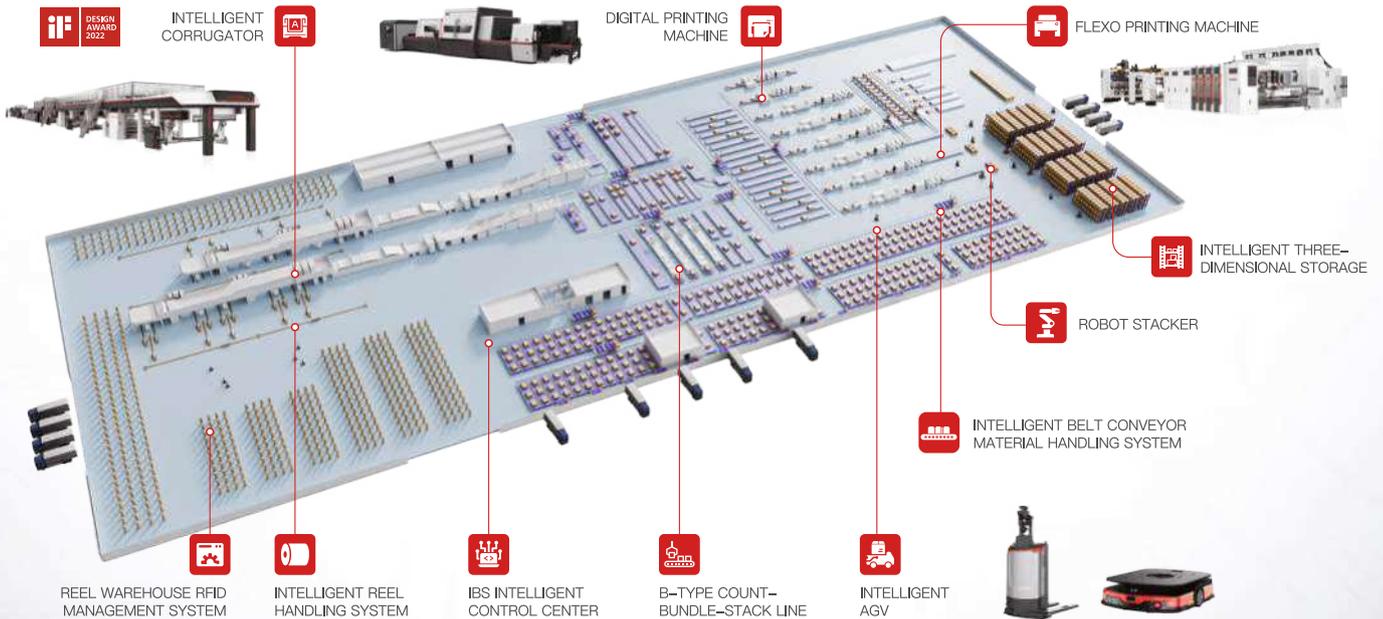


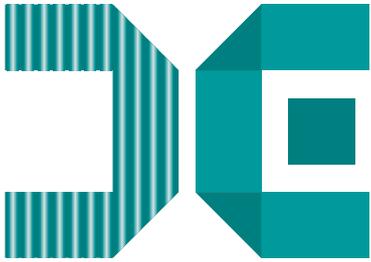
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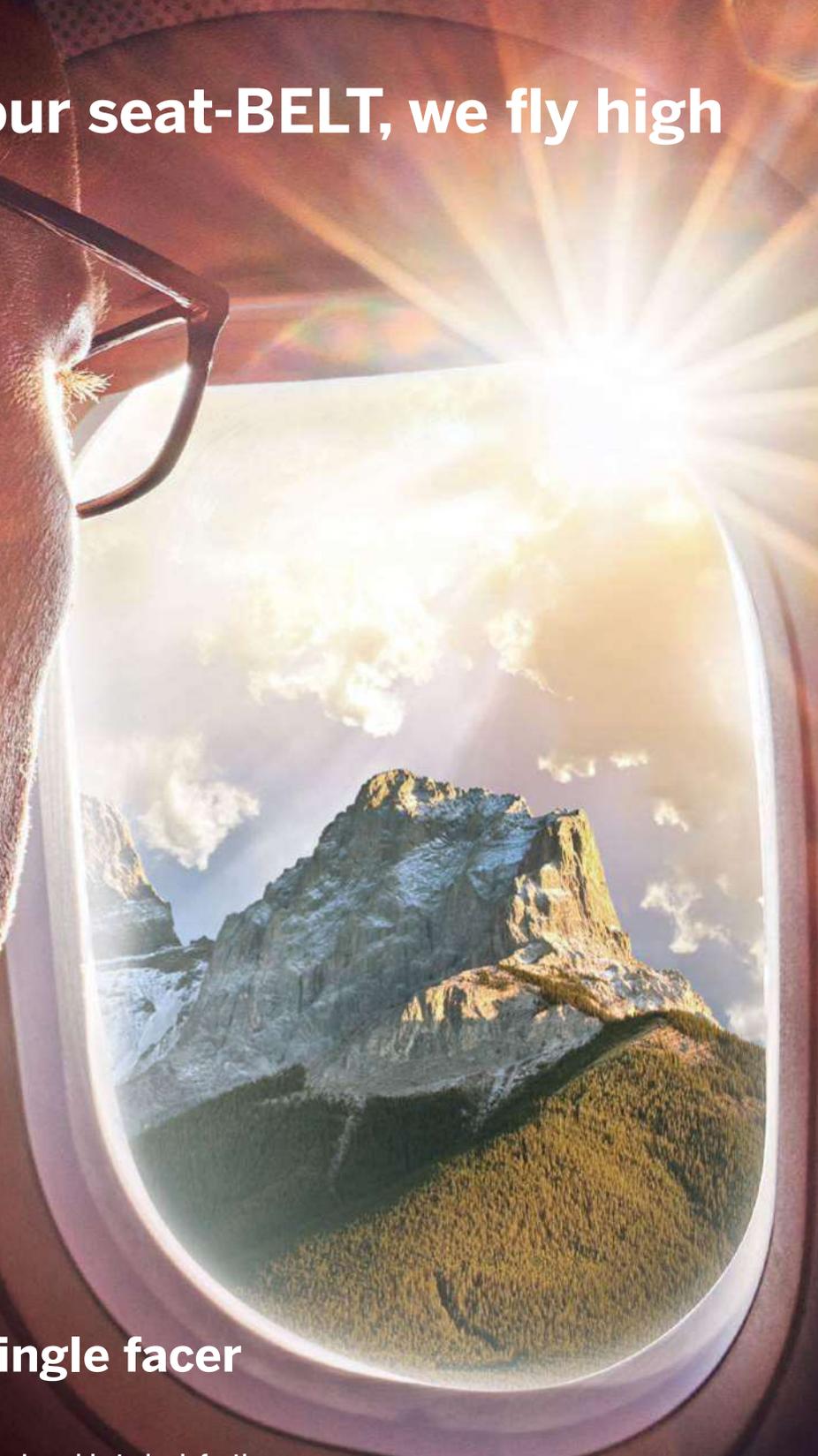


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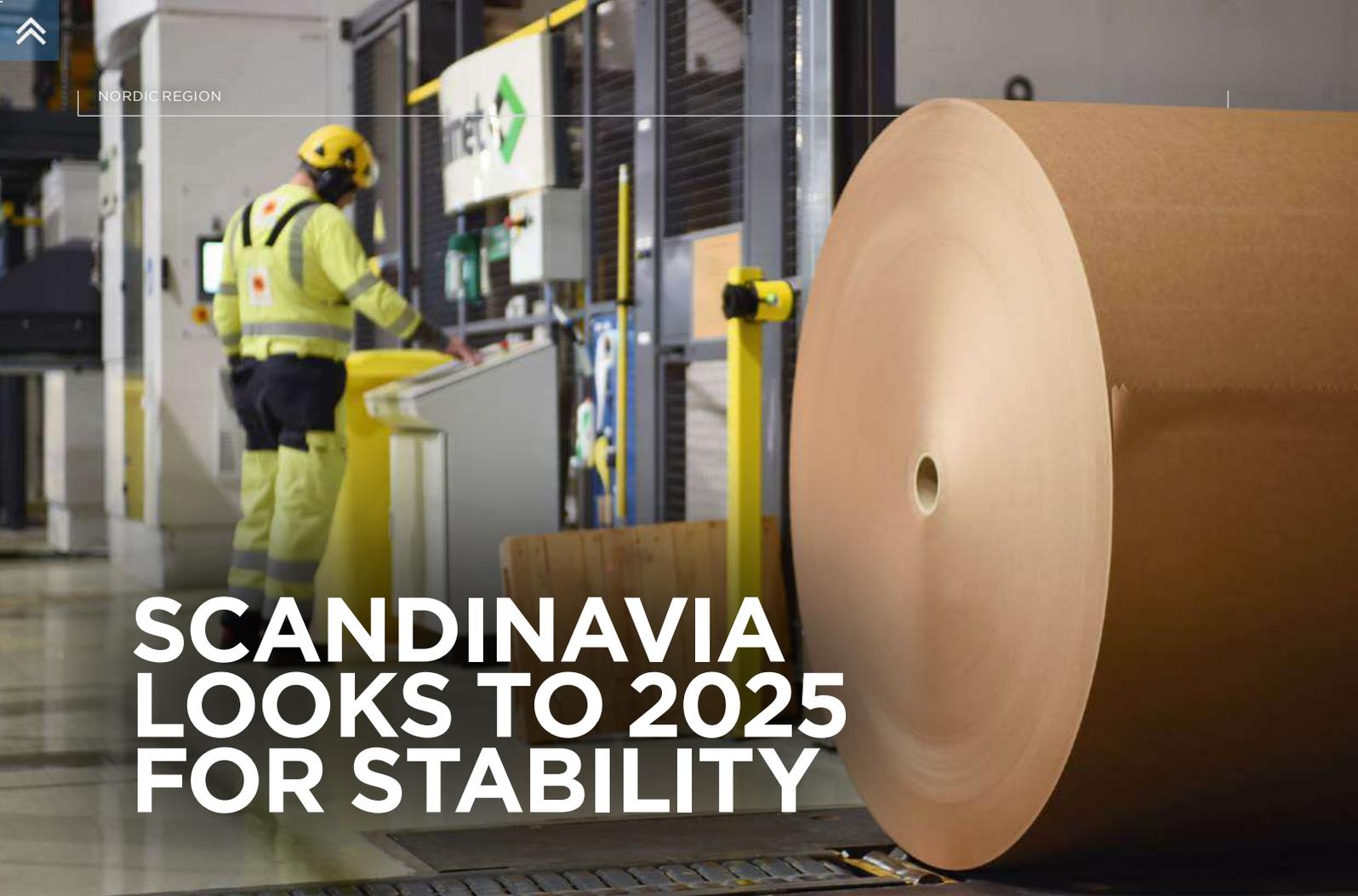
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SCANDINAVIA LOOKS TO 2025 FOR STABILITY

CORRUGATED SECTOR IN THE NORDIC STATES SHOWED SLOW GROWTH RATES IN 2024, BUT HOPES FOR BETTER THINGS THIS YEAR.

**AN ARTICLE BY
EUGENE GERDEN.**

The corrugated sector in the Nordic states showed slow growth rates last year, amid the ongoing stagnation of most of regional economies and high inflation rates. The ongoing Russian-Ukrainian conflict and associated negative consequences continue to put pressure on economies of most of Nordic states, which is also due to their geographical proximity to Russia and existing trade relations with this country in the past.

The region is home for many of industry players, both domestic and foreign, among which are [Stora Enso](#), [Kingele](#), [VPK Group](#) and others, many of which have expanded their local capacities in recent years. Most of these players are interested in the further expansion in the Nordic corrugated market, despite its high level of maturity and low growth

rates (not exceeding 1-2% depending on the country). Traditionally, the Nordic region has always been within the sphere of interests of some major global players, many of which have started to pay more attention to the local market after suspension of their investment activities in the larger markets of Russia and Ukraine.

Given that up to 20% of exports of most of regional states come from the forestry and paper industry, including corrugated board (with Russia being the major importer prior to February 2022) a serious drop of export supplies, which has been observed during 2022-2023 after the beginning of hostilities posed a threat for implementation of many regional investment projects. Still, despite this, investment activities in the Nordic corrugated sector were at generally high levels last year.



Mondi Kuopio mill

An example is Finland, where a number of investment projects were completed. Probably the most important was successfully launched last summer when [Mondi Group](#) completed its €125m investment in the Kuopio containerboard mill. It includes upgrades to the wood yard, fibre line, evaporation plant, and paper machine producing ProVantage Powerflute®, a high-performance fluting predominantly used in fresh fruit and vegetable trays and boxes. Being initially announced in 2021, there were some concerns that implementation of the project may be seriously delayed, due to economic and other issues; however the new facility was commissioned in time.

[Markus Gärtner](#), CEO, Mondi Corrugated Packaging, in an exclusive interview, has confirmed the importance of the project. “Mondi completed a €125m upgrade at our mill in Kuopio, Finland. This investment enhances production efficiency and supports the demand for high-quality

containerboard globally. Our focus remains on delivering value to customers worldwide through innovation and sustainability. Our containerboard production in Finland serves customers globally, and the ongoing drive for sustainable packaging solutions continues to influence demand across all markets.”

In 2022, Mondi announced its big plans to invest about €300m

in the expansion of its production capacities for corrugated board in Europe in the next several years. While none of Nordic states were included in those investment plans, most of analyst believe the launch of Kuopio mill is part of the bigger trend of the ever growing presence of Mondi in the EU corrugated board market.

DS Smith Strengthens

In the meantime, [DS Smith](#) has also strengthened its positions in the Finnish market by investing more than €10m in machinery and equipment at its Finnish plants, including new production machinery and equipment at its facilities in Lieliahti in Tampere. Last year, the company relocated the operations of its Turku plant to Pirkkala near Tampere and continues optimisation of its local operations this year.

DS Smith has factories in Tampere, Pirkkala, Nummela and Ii, Kuopio and Viiala in Akaa, and a sales office in Raisio. DS Smith employs around 330 people in Finland directly, and even more indirectly.



DS Smith Lieliahti



Stora Enso Tiukka Mill facility



Stora Enso Heinola Fluting mill

Ongoing for Stora Enso

Stora Enso continues the development of Tiukka Mill facility, positioning it as one of the hubs for corrugated box manufacturing in the entire Nordics region. Being located on the industrial area of more than 9000 sqm, currently the plant mostly produces corrugated board packaging for the local food and beverage sector. Corrugated sheets are supplied directly from Stora Enso's Lahti facility.

In recent months, the company has invested serious funds for transitioning its Tiukka plant from oil heating to ground heating with the goal to become the first carbon-neutral Stora Enso plant in the Nordic countries.

Ingrid Peura, an official spokeswoman of Stora Enso, talked about the strategic importance of the Nordic region for the company and its corrugated board business.

While the company has not yet completed implementation of any large-scale investment projects in the Nordic region in 2024, such a situation may change in 2025. Peura comments, "While the company has not introduced any capacity growth projects in corrugated in the Nordic area in 2024, Stora Enso is currently implementing an earlier announced bioenergy investment at its Heinola Fluting Mill in Finland with an estimated value of €30m.



Stora Enso's production site of Kristinanka punki

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Swedish Focus

In the meantime, the situation in the corrugated sector of Sweden – the largest country of the region and one of the world’s largest producers of paper and board – remains much more complex, as the current stagnation of the Swedish economics leads to reduced demand from major consuming industries.

The seriousness of the situation is reflected by the recent closure by [Stora Enso](#) of its Vikingstad facility in Linköping. The plant employed 56 people and mainly supplies customers in Sweden with corrugated packaging for retail, transport, e-commerce, consumer goods and industrial applications. As demand for corrugated board packaging is low, Stora Enso plans to consolidate operations at its two other Swedish corrugated board plants in Jönköping and Skene. [Carl Norell](#), an official spokesman of the company, said, “Vikingstad was closed in 2024 with volumes moving to two nearby production sites.”

VPK in Denmark

The Nordic region has been traditionally within the sphere of interests of VPK Group. [Henrik Hedegaard](#), Managing Director, VPK Group Denmark has said that the company continues its development, despite the existing market problems, which prevent more active growth.

Hedegaard comments, “We always are developing our competitiveness in VPK Group/ VPK Nordic/VPKDK, and 2025 is not different. Machine investments,

optimisation projects and a part of our continuous improvement programs. But because of competition, we will not go into details with specific projects or machine investments as this would be our advantage towards our current and new customers. We still have not used all the capacity available in VPKDK.”

Hedegaard does not expect a significant growth of the Danish market for corrugated board or other Nordic states in 2025. Hedegaard continues, “As we see now, it seems the market is hesitating in its growth. I have the expectation that the increase in Denmark for the growth in corrugated board will follow the same levels as the Danish government expects for the economy in 2025, which is around 1.8%. So, growth in the corrugated sector in Denmark will hopefully mirror this.”

In addition to Denmark, VPK also has a strong presence in Norway, where in September 2022 it opened its high-tech corrugated factory in Halden. According to VPK Group, the factory is built with the latest technology and uses artificial intelligence and advanced automation. ■





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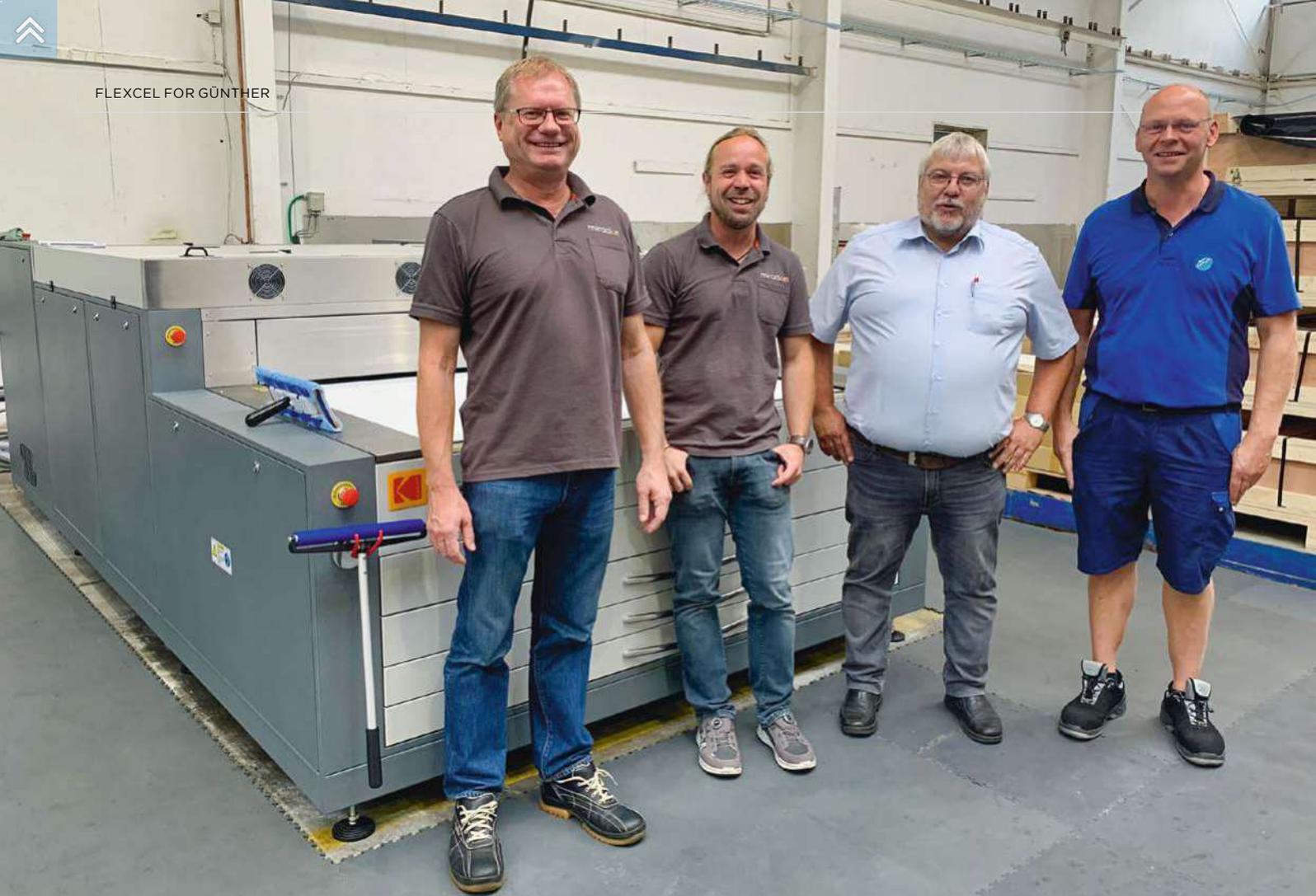
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U. GÜNTHER INVEST FOR GROWTH

FLEXCEL NX TECHNOLOGY FROM MIRACLON AN ESSENTIAL FACTOR IN THE FORMULA FOR SUCCESS.

Prepress service provider, U. Günther GmbH, headquartered in Hamburg, Germany, has always been quick to adopt innovative technologies for flexo printing while also advancing the printing process through its own technical developments and process optimisations. “Our goal is to effectively benefit all parties involved in the packaging value chain – brand owners, printers and prepress service providers. Key to achieving this is to increase

efficiency, especially when processing larger SKU series,” says Peter Tarnowski, responsible for market development and special projects at U. Günther.

Long Established and Indispensable

In line with this strategy, U. Günther has been relying on its ongoing partnership with Miraclon and FLEXCEL NX Technology for over a decade. “It is well established in our company and ensures

predictable, reliable results – both in our platemaking process and on press at packaging printers,” says Tarnowski. The prepress service provider now operates two FLEXCEL NX Wide 5080 Systems in its 4,000+ sqm flexo plate production facility in Greven, Mecklenburg-Vorpommern.

For Tarnowski, the investment in Miraclon’s technology has meant that the company has achieved important milestones since the introduction of these

solutions. He credits the FLEXCEL NX 5080 System, the continuous development of the multi-form surface patterning they implement today, and the introduction of the larger format FLEXCEL NX Ultra 42 Solution with its solvent- and VOC-free water-based plate processing, which expands the plate format that can be used with FLEXCEL NX Ultra Processor. In 2023, U. Günther installed a FLEXCEL NX Ultra Processing System that allows them to make FLEXCEL NX Ultra Plates up to 1,067 x 1,524 mm in size. “Thanks to the larger format, we can now fulfill an entire series of plate orders,” explains Tarnowski. He adds that the sqm consumption of all FLEXCEL NX Plates has been close to or in the five-digit range for several years and that NX Ultra Plates account for around 30% of this volume.



Beneficial Technology Synergy

For U. Günther, FLEXCEL NX Technology is a key component in enabling brand owners and flexo printers to achieve modern flexo practices, including greater efficiency and improved productivity, along with the sustainability benefits it enables, as well as reduced costs and higher packaging print quality. Another component is the Impulse Screen screening technology developed by U. Günther and its sister company, Flexo-Service Cl. Jaehde, both of which are part of Grotenkamp Holding GmbH. Impulse Screen technology enables moiré-free multicolour printing without the typical flexo rosette and the printing of very fine patterns using existing or relatively coarse anilox rollers. This allows printers to achieve much



finer levels of screening, as well as excellent detail without visible halftone dots, without having to invest in anilox rollers with a higher screen ruling or modify their presses in any other way.

Impulse Screen paired with FLEXCEL NX Plates is a winning combination. Tarnowski adds, “We predominantly use FLEXCEL NX Plates for our Impulse Screen processes because, in our

experience, it produces the best results. Accurate, detailed, high-resolution reproduction of the finest elements of a motif in the highlight area is the most obvious proof. The plate properties are also extremely important when you need to print large areas with even color tones made up of two or three colors. That works very well.”

Higher Efficiency and Productivity

“With Impulse Screen and the stability of FLEXCEL NX Plates, we can reduce the consumption of inks and printing plates, as well as make-ready times in printing. Printers can also increase print

speed without compromising on quality,” explains Tarnowski. “Faster job changes, shorter make-ready times and higher print speeds are factors that increase productivity, enable sustainability benefits, and can reduce costs. This results in a scale effect that gives packaging printers who systematically exploit these advantages a huge efficiency and competitive advantage.

“We offer ECG with up to seven colours. However, we usually manage with five or six, and the printers achieve excellent results. Brand owners are increasingly open to the ECG process, including the added sustainability benefits

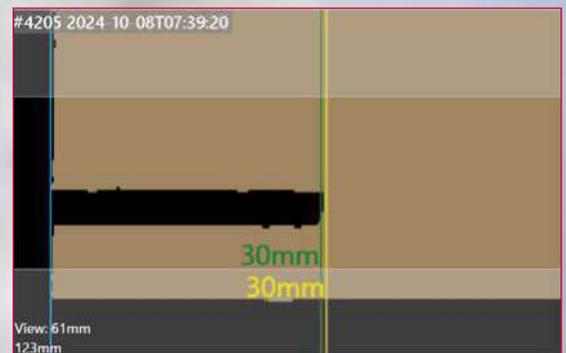
and cost savings that come along with it – proven by the over 2,000 SKUs per year for customers in the flexible packaging sector – and the trend is rising.”

“We value the close relationship and longstanding partnership with U. Gunther”, concludes Roland Hamacher, Sales Manager EMEA, Miraclon. “The company is a proven leader in enabling printers and brands to adopt and benefit from modern flexo practices, which is underscored by their continued growth and various accolades from industry associations. They set a great example of what can be achieved with the right combination of technologies.” ■

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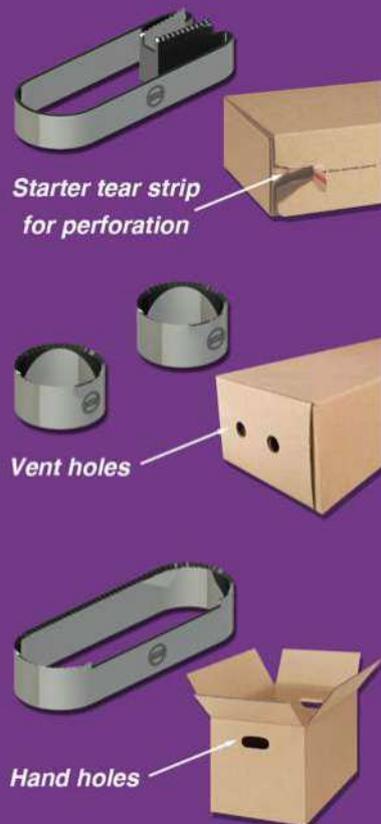
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HOW TO GET MORE FROM YOUR CORRUGATOR

BW PAPERSYSTEMS' COOL-VAC DOUBLEFACER UPGRADE ENSURES EXTENDED LIFE OF AN EXISTING CORRUGATOR FOR DS SMITH AT ITS PLANT IN GRENA, DENMARK.

From their inception, doublefacers have been an integral part of the corrugating process. Heated cast iron plates and a cotton belt were common in traditional machines to bond an outside liner to the singleface web or to combine multiple webs and the outside liner paper.

For many years the machine developments of the doublefacer were minor, or at best incremental improvements. In the 1980s, two US based OEMs made major steps in the design of doublefacers that produced a strong, well-bonded web of corrugated board with less energy than existing designs. United Container Machinery designed a new style of high

efficiency hotplate fitted with a traditional pulling section in their successful Model 600 doublefacer, while Marquip with their 'Pyrobond' changed the way doublefacers were designed by doing away with the cotton top belt and using a vacuum pulling section to pull the webs from the wet-end. The Pyrobond used weighted steel strips to create the gentle hold-



down force needed to bond the papers. The pulling was done by a Vacuum Traction Section (VTS). This combination of technologies allowed the board to cure faster, have better strength characteristics and have a low cost of ownership.

Cool-Vac

The **Cool-Vac** doublefacer is an evolution of the Marquip Pyrobond doublefacer and the United Model 600 doublefacer. The traditional United Model 600 doublefacer had an, at-the-time industry leading hotplate section. Their gun drilled steel hotplates and the capability to inject superheated steam into the web in the critical bonding area of the doublefacer helped create a strong initial bond with fewer hotplates and





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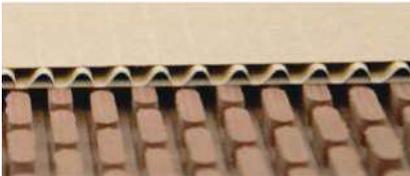
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lower energy than older designs. Combining this heating section with the revolutionary non-crushing Marquip Vacuum Traction Section gave birth to this new generation of doublefacers.



A significant portion of the pulling force on the board through the Cool-Vac doublefacer is provided by the VTS. A top belt is retained upstream of the VTS, for easy threading and to ensure a good initial bond is formed over the hotplates. The efficient and powerful VTS pulling section realized a reduction in 'footprint' length, making the Cool-Vac the ideal machine for corrugator upgrades.

Case Study

DS Smith has a site located in Grenaa, Denmark, producing approximately 200 million sqm of corrugated board annually, supplying packaging solutions to a variety of industries including Automotive, Chemicals, Pharmaceutical and Medical, Industrial Electronics & Food and Beverage. Their packaging solutions are designed to be sustainable and cost-effective, ensuring products are protected throughout the supply chain.

The Grenaa plant was experiencing several production challenges with an existing corrugator, with increased levels of warp, bonding issues and overheating of the board during the process, as well as experiencing web weave due to the long doublefacer top belt. The existing doublefacer and rotary shear were not working

to the optimum, and in some cases this can result in issues like jamming, impacting production and additional waste. Pre-print and microflute were not able to run efficiently with the existing machinery.

What Solution was Proposed?

BW Papersystems put forward for the supply and integration of a Cool-Vac doublefacer and SE1000 Rotary Shear to meet the customer requirements to run higher volumes of both microflute and pre-print. Further key drivers were board quality improvements, and production waste reductions.

Confidence in the new production set up has resulted with the plant seeing a significant reduction in machine downtime. This enables the possibility of the plant to run with narrower trim due to the stable control of the web (reduction in web weave) through the doublefacer, resulting in a significant ROI.

Both new machines were compatible within the existing footprint due to an integral design and were seamlessly integrated within the existing corrugator and customers Corrugator Process Control system.

The BWP solution exceeded all customer key decision criteria and drivers.

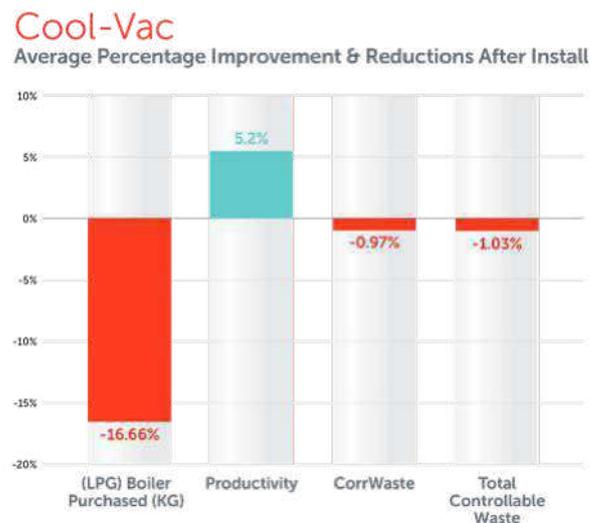
Since running with the new machinery, the plant has seen significant benefits and results, which are detailed in the graph (right):

“The new BWP Cool-Vac and

SE1000 Rotary Shear has improved our productivity and extended the life of our corrugator. Following the installation of the BWP machinery, we have seen substantial reductions in corrugator waste and warp waste, coupled with overall board TST performance increases across all board grades,” said the General Manager of DS Smith Grenaa.

He continued, “The board shape and quality of the overall product has increased significantly, this supported by increased run speeds across all grades and coupled by a large reduction in machine stops and downtime compared to our old machinery, this has resulted in us being very happy with our investment with BWP.”

He concluded, “Additionally, we have observed enhancements in our conversion throughput thanks to the improved overall board quality, along with significant savings in our overall corrugator energy consumption. All these factors have resulted in us returning a strong ROI and has enabled the plant to increase its position within the Group and further strengthen our status within the region.” ■



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RAF-PAK INVEST IN HIGH QUALITY CAPACITY

KOENIG & BAUER CELMACCH IS READY TO INSTALL A NEW FIVE COLOUR CHROMA SMART 1700 HD 5 COLOUR LINE AT CUSTOMER SITE IN POLAND.

RAF-PAK is a rapidly developing Polish family company specialising in the production of high-quality corrugated packaging. The beginnings of their business date back to 1996, when a small, fast-growing family business turned into a large enterprise with a total production, warehouse and office area of more than 20,000 sqm, gaining the trust of customers from various industrial sectors.

For over 20 years, Raf-Pak has been building a leading position in the local corrugated market through continuous quality improvement, new products, flexibility, competitive prices, short delivery times and meeting their customers' needs.

The Polish company is specialised in the production of packaging for fruit and vegetables, poultry, and in the delivery of ready-glued packaging to its customers with short lead times. They also deal with the sale and rental of folder-gluer machines.

The production plant is located in Sowin, Pleszew commune, Wielkopolska province. The company currently employs 80 people. The constant development of Raf-Pak's company is influenced by modern machines, production systems, but also the individual development of each member of the company. Raf-Pak relies on a highly-skilled and committed team, and many years of experience have shown that both small and big successes have strengthened their brand and market recognition, as evidenced by an ever-growing group of customers and millions of packaging sold.

Expanding Machine Park

To expand its own machine park, Raf-Pak chose to invest in a new **Koenig & Bauer Celmacch** Chroma Smart 1700 HD, equipped with five flexo printing units, in an off-line configuration with high pile stacker. The new investment will enable the implementation of production with a high standard of printing.

Raf-Pak had a clear idea about the new machine. Thanks to intensive and trusting discussions with Koenig & Bauer Celmacch, it quickly became clear to them that the **Chroma Smart** would meet 100% of their requirements. Chroma Smart is a perfect combination of innovation and functionality that can meet the highest expectations and European quality standards. Raf-Pak is ready to welcome its new machine, which will be installed by the end of February 2025.

By pursuing constant technological improvement and adopting exclusively finest-quality components from the European Union, Koenig & Bauer Celmacch ensures strength, reliability and high performance throughout the entire machine's life cycle. "We are always implementing new ideas. Modern technologies and functions in combination with simple and intuitive operation characterise our machines," explains **Luca Celotti**, CEO, Koenig & Bauer Celmacch. ■

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ChormaCUT X Pro
Superior Graphics fast set-up

Max Speed: 12,000 s/h

Size (max sheet): 2,800 mm

Features:

- 3 minute auto job change
- Setup while running
- Preset print and die cut
- Print and die cut inspection
- Anilox Roll Changing System (Full Automatic: 3+1)



For full features and specifications, visit koenig-bauer-celmacch.com
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we're on it.

CLOSING THE SKILLS GAP WITH EDI

PETER MACQUEEN, ASSOCIATE HEAD OF THE CREATIVE INDUSTRIES INSTITUTE AT SHEFFIELD HALLAM UNIVERSITY, EXPLAINS HOW EMBRACING EQUITY, DIVERSITY, AND INCLUSION - EDI - ALONGSIDE SUSTAINABILITY IS DRIVING A TRANSFORMATIVE SHIFT IN THE PACKAGING INDUSTRY.

The manufacturing industry, particularly within sectors like packaging, is transforming its approach to equity, diversity, and inclusion (EDI). Manufacturing has long been dominated by older white men, a trend especially prominent in senior roles throughout the 1990s and early 2000s. However, the push for a more inclusive workforce – one that better reflects the diversity of society – is gaining momentum.

Historically, industries like manufacturing have struggled to attract diverse talent, often creating a self-reinforcing cycle of exclusivity. However, apprenticeship programs are now making a tangible impact, bringing in younger, more diverse individuals and shifting the cultural landscape. In a sector where men represent about 70% of the workforce, more than half of today’s apprentices are women

– marking a significant cultural shift. This shift is also driven by job movers and career changers, who are entering the industry with fresh perspectives, often motivated by sustainability challenges that resonate with a new generation.

According to Macqueen, these changes reflect a broader industry realisation; embracing EDI is not just about ticking boxes but unlocking innovation and tackling key issues like sustainability.



Peter Macqueen, Associate Head of the Creative Industries Institute at Sheffield Hallam University

Sheffield Hallam University
Knowledge Applied



“I think it can be a sensitive subject because, for many people, the moment you turn to EDI, they’ll turn around and think you’re creating a synthetic situation,” he says. “There can be some caution around conversations in the diversity and inclusion space at times. But it’s a real issue that is widely recognised, especially in the manufacturing sector.

“When I first started in the 1990s, there were predominantly older white men in nearly every senior position in every company I worked for. In most of the junior positions, there were slightly younger white men. That’s just how it was. This is not to criticise white men, but it doesn’t mean there’s anything wrong with acknowledging that the industry needs to realise the importance of EDI. In the same way, we account for ageing populations and adjust user experiences and packaging to reflect the makeup of society, few people would disagree that industries should be more reflective of the people they serve.”

Breaking the Cycle of Exclusivity

Industries dominated by a single group often develop an exclusive atmosphere, making

“More than half of our apprentices are female. That’s significant, considering that the industry is male-dominated – many stats put the male workforce at around 70%. So, having more than half of our students be female represents a real cultural shift.”

PETER MACQUEEN, ASSOCIATE HEAD OF THE CREATIVE INDUSTRIES INSTITUTE
AT SHEFFIELD HALLAM UNIVERSITY

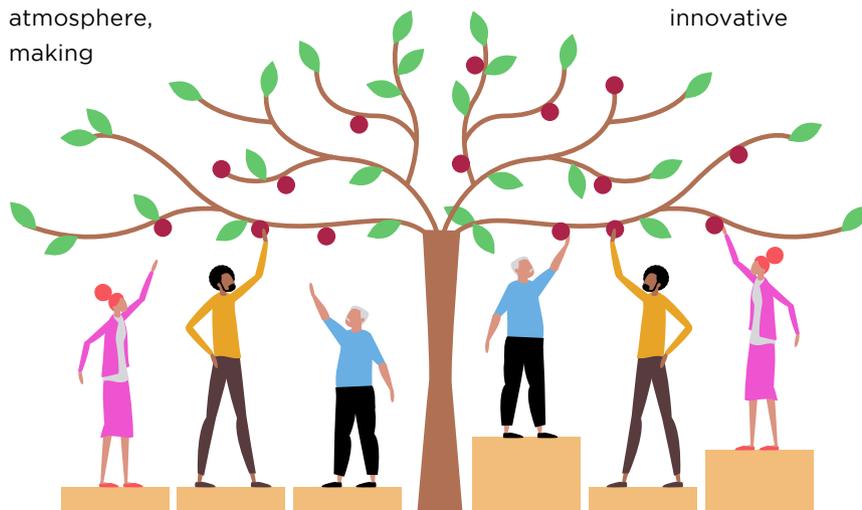
attracting diverse talent increasingly difficult and less appealing. This creates a self-perpetuating cycle where the industry appears less inclusive, further deterring underrepresented groups from joining. Shifting such an ingrained culture is a significant challenge. However, apprenticeship programmes have played a remarkable role in addressing this issue across several workplaces. The progress isn’t solely due to these programs – employers and industry partners are also eager to see their workforces become more reflective of the diverse, changing world.

Macqueen is playing a pivotal role in shaping the future of the UK packaging industry. Under his leadership, the university’s innovative

undergraduate programme prepares students to meet the demands of a rapidly evolving sector.

“More than half of our apprentices are female,” Macqueen continues. “That’s significant, considering that the industry is male-dominated – many stats put the male workforce at around 70%. So, having more than half of our students be female represents a real cultural shift. Beyond that, we’re seeing younger individuals entering the industry. In our apprenticeship program, we take a mix of mid-career upskillers and new starters to the sector. But we’re also seeing an interesting third category: job movers – people who may have worked for a few years in different roles.

“Many job movers are leaning into the programme rather than moving around. They’re considering shifting into more operational or packaging-specific roles within organisations that may not have packaging as a core business. These individuals are also signing up for the programme, which shows a demographic shift, particularly trending toward more women. Historically, it’s been easier for brands to attract a more diverse workforce, and we’re certainly seeing that trend continue.



“That tended to be the case: you’d get a more mixed picture when working in a brand portfolio. However, for manufacturers, I genuinely believe that initiatives like the apprenticeship route are attractive to young people, particularly because of the ‘learn while you earn’ perspective.”

Sustainability as a Catalyst for Diversity

These collaborations have focused on addressing key sustainability challenges, attracting a demographic that might not have previously considered roles in packaging technology or manufacturing. By emphasising the importance of sustainability, the sector has begun appealing to individuals who bring fresh perspectives and diverse backgrounds, reshaping the industry’s workforce in previously unseen ways.

This multifaceted and complex evolution underscores the tangible benefits of embracing equity, diversity, and inclusion. Macqueen believes that by leaning into EDI, organisations are addressing the immediate need for a more representative workforce and gaining access to new ideas and approaches that have long been missing.

“I think for a long time, there’s been some resistance among people working in the industry,” he adds. “It’s as if they don’t want to air their dirty laundry publicly. Discussing sustainability while advertising for a packaging role can feel like admitting there’s a problem. You wouldn’t want to advertise a sustainability lead, which implies that your current business isn’t sustainable.”

“Interconnectedness ties directly to the importance of equity, diversity, and inclusion within companies. A more inclusive workforce is better equipped to navigate the complexities of global markets and adapt to the needs of different regions.”

PETER MACQUEEN, ASSOCIATE HEAD OF THE CREATIVE INDUSTRIES INSTITUTE AT SHEFFIELD HALLAM UNIVERSITY

“But this is another area where people have been willing to shift. Few manufacturers these days are unwilling to acknowledge that there are areas where they need to improve. Companies are becoming more open about discussing their efforts and advertising the fact that they’re in the process of developing solutions.”

“This approach dovetails with public awareness – people are demanding to see sustainable change, or at least to know that companies are working toward it. They want companies to make justifiable, understandable decisions backed by science and math.”

This is a dynamic and interesting space to work in – when you can advertise a job where someone knows they’ll make a genuine, meaningful, positive impact, it makes that job more attractive.”

Over the past 50 years, the trends of the global market have profoundly reshaped industries including packaging. Today’s world is more connected than ever, with access to international communication, trade, and collaboration networks. Companies operating in the packaging sector now function within a global framework. As a result, businesses that once catered



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primarily to domestic markets must now consider diverse, international perspectives to remain competitive. The evolution of manufacturing culture reflects this shift, as brands increasingly recognise the value of a diverse workforce that can engage with global audiences.

This interconnectedness ties directly to the importance of equity, diversity, and inclusion within companies. As Macqueen suggests, a more inclusive workforce is better equipped to navigate the complexities of global markets and adapt to the needs of different regions.

“It’s easy for us to pat ourselves on the back and say, ‘Job done – we have an EDI initiative in our company,’ but that’s far from the truth. A key point about apprenticeships, for example, is not just about bringing in new starters or young people but also giving them real opportunities to lead and make changes within organisations. Otherwise, we’re just creating the appearance of inclusion and diversity.

“Change is happening, but it takes time. The progress has been real, and I hope we’ll see even more of that in this year’s Future Trailblazer Group. We’re hoping to see more diversity – not just for the sake of diversity, but because we want to see the best possible candidates. We’ll see a more reflective and broader range of applications than ever before, which will be an exciting development.”

20-Year Skills Gap

The industry is in a phase of rapid catch-up, attempting to close a 20-year skills gap that emerged largely due to the disappearance of undergraduate programs that

once provided a steady pipeline of new talent. Whether in structural design, technology, or graphics, it’s been two decades since these programs were widely available. For an industry to go that long without a dedicated stream of trained and engaged professionals is significant, creating a noticeable void in expertise.

During this period, companies had little choice but to hire whatever talent was available, often from unrelated fields. Surveys consistently show that over 60% of people working in packaging didn’t originally plan to enter the sector. Even more concerning, less than half of the workforce has an educational packaging background. In comparison, it would be unthinkable for industries like automotive or nuclear science to have such a disparity – imagine if more than half of atomic scientists lacked a degree in their field. The absence of formalised training pathways in packaging has hindered the industry’s growth and development.

“The complexity is partly because we’re not a unified sector

for job roles – we’re broad and diverse,” he continues. “But I think this skills gap may have held us back during that in-between period. It was a time of immense social change, but the industry made do.

“There were a lot of job movers during that period, and you can still see it today. From the early 2000s through the 2010s, industry events became trips to see which people were wearing a different company’s name badge each year. That was how the industry functioned – people moved from one company to another.”

He concludes, “Now, however, we’re in an interesting time. With initiatives like apprenticeships and sustainability efforts making packaging jobs more attractive, I genuinely think it’s an exciting period for the sector. We have people working in the industry now who wouldn’t have been here before, bringing new perspectives and challenging orthodoxy. It’s an exciting and bold step for everyone involved, and hopefully, we’ll start to see real, effective change as a result.” ■

“Change is happening, but it takes time. The progress has been real, and I hope we’ll see even more of that in this year’s Future Trailblazer Group. We’re hoping to see more diversity – not just for the sake of diversity, but because we want to see the best possible candidates. We’ll see a more reflective and broader range of applications than ever before, which will be an exciting development.”

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TCY EUROPE

NEW FOR 2025, A DEDICATED EUROPEAN OFFICE FOR THE TAIWANESE MANUFACTURER OF FLEXO CONVERTING LINES AND CORRUGATORS.

TCY has confirmed the launch of TCY EUROPE. This brand-new division based in Paris, France is headed-up by [Olivier Toutin](#). This new step in the TCY journey ensures European customers can be better served with convenience, speed, and efficiency.

Toutin says, "TCY is renowned worldwide for one of the largest ranges of corrugated flexo machinery. We are proud to say that with a team of full-time, locally based engineers and a dedicated warehouse stocked with spare parts, we are now able to support your machinery like never before in Europe."

Here's how TCY Europe makes customer care simpler than ever:

- 80% of parts stocked locally in Paris for QS & N-series machinery;
- YourTCY.com: online parts ordering platform with 24/48hr delivery;
- Remote machine connection & diagnostics service in Paris;
- Six technicians in Paris + one software engineer;
- Local technicians in Germany, Italy, Poland, France and the UK;
- Extensive parts inventory at TCY HQ in Taiwan.

Of course, corrugated production operates around the clock and TCY's new industry-leading service solution is designed to match the quality of the machinery they manufacture, helping its customers maximise uptime and efficiency.





QS618 Fixed Type Quick Set Up FFG

Market Success

To coincide with the launch of TCY Europe, the company are proud to note some key installations during 2024, with more to come in 2025.

In Italy, they installed two high-specification casemakers from the range:

■ **QS618 Fixed Type Quick Set Up FFG:** this is the flagship, full automatic servo driven minline casemaker, focused on fast setups and high speed production.

The QS618 is capable of two minute changeovers and 400+ sheets/minute with automatic print plate mounting and minimal operator adjustment.

■ **NB8-FFG 1600mm x 3000mm Inline Flexo Folder Gluer:** this is a special machine specification – a 1600 machine with inline FFG including an advanced top loading counter ejector,

this is a large format, fully automated mini-Jumbo casemaking line, including pre-feeder and automated material handling at the outfeed. There is minimal operator input from corrugated sheet stack to converted sheet bundles stacked on pallets ready for transportation.

NB8-FFG



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“TCY continues to invest, year on year, in manufacturing, operations and global service and support.”

KEN HSIAO, GENERAL MANAGER, TCY

In France, they installed an N-series midline casemaker:

■ **N5-FFG 1000mm x2500mm Inline Flexo Folder Gluer:**

this model delivers highly automated solutions in the more traditional open and close casemaker format.

In Germany, the company completed another installation with:

■ **NB6-FFG 1200x2750mm**

inline flexo folder gluer: this machine significantly elevated the production efficiency of the entire plant, enabling faster and more efficient processing of corrugated sheets.

“In the UK, we installed an NB6-FFG 1200x2750mm Inline Flexo Folder Gluer with bottom print, top die cut and an overall specification to produce cases with partial dies for case erected boxes,” states [Rob Garvey](#), General Manager, TCY UK Ltd.

“We’re excited to say that this customer will also install a further two machines in mid-2025 – Our QS Fixed Type Quick Set Inline Flexo Folder Gluers. This is an exciting step with our customer to significantly increase operational efficiency and meet their market demands.”

In 2024, TCY also successfully retrofitted a die-cutting line with the STK3 multi-out bundle stacker, turning the die-cutter in to a highly productive machine

centre by running reverse flute multi-outs, counted and bundle ejected to the load former.

By no means least, the company says it continues to find success with customer partners in the North American market with some exciting installation due to complete in 2025, including a high speed 39” casemaker, the largest Jumbo inline casemaker, and others.

“We are extremely proud to have placed such advanced solutions in the market during 2024 and wish to thank our customers for trusting in TCY to deliver quality machinery and service to support their growing businesses, said [Ken Hsiao](#), General Manager, TCY. “TCY continues to invest, year on year, in manufacturing, operations and global service and support all in the name of moving the dial forward for the corrugated industry and our customers.”

Hsiao concludes, “Our flexo range, already extensive from mini-line through to Jumbo solutions, continues to expand with new formats being introduced such as our N10 1800 jumbo series. TCY has been designing and manufacturing machinery for decades and has the experience and infrastructure in place to support all flexo converting machinery needs and marketplaces.”

TCY Europe can be contacted on +33 1 64 72 92 92 ■

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Edge trim can be easily shredded using edge trim fans. The processed material can be transported via conveyor belts or pneumatically to the baling or container presses for optimum recycling. Höcker Polytechnik offers suitable shredder solutions for all these applications or integrated disposal concepts, including sorting, for the entire production process.

Bulky materials, sheet goods, cardboard packaging or robust core tubes block valuable storage space and can only be fed into the company's internal disposal workflow with a great deal of effort. Shredders from Höcker Polytechnik

also provide support here, recovering valuable storage space, increasing recycling revenues and continuing to keep the company's own waste disposal centre tidy.

Shreds up to 8,000 kg per hour

The manually operated PSHSH shredder from Höcker Polytechnik can shred up to 8,000 kg of material per hour into handy, easily transportable pieces. The shredded material is then fed to an existing disposal line either via conveyor belt or via an extraction hood and can be prepared for pressing. In order to cope with such large quantities of material in everyday working life,



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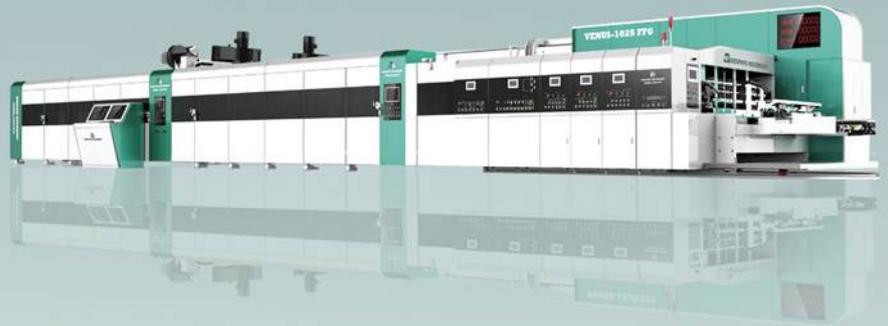
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a shredder that is manually fed with material must also be designed for optimum ergonomics when feeding the material. The operator places the cartons on the wide conveyor belt of the PHS shredder, which then automatically transports the material to the three shredder shafts, where the two preceding shafts draw the cartons to the fast-running shredding shaft with cast iron teeth or a knife shaft with high-quality knives and shred them. Meanwhile, the next material can already be loaded – saving time and increasing throughput.

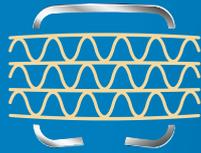
Shredding Cores for Recycling

Cores with a maximum diameter of 150 mm and wall thicknesses of up to 20 mm can be shredded in the integrated core cutter. The core is inserted, automatically drawn in and shredded. Shredded in this way, cores can also be disposed of via baling presses or container presses. If no core cutter is required, the PHS shredder offers the full range of functions excluding the core shredder. The robust PHS and PHSH shredders have been used hundreds of times worldwide and are characterised by low wear and tear and a design designed for safe working, with protection against interference at the infeed. The shredders can be flexibly configured and are available with different cutting widths and feed belt lengths. Thanks to the robust welded construction, the components designed for durability and advantages such as space-saving and safe storage of the shredded material, higher recycling proceeds and reduced labour costs, the investment in such shredders often pays for itself within a few years.

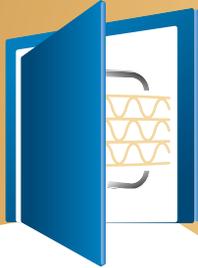
Technical Improvements in 2024

In 2024, the PHS and PHSH shredders were technically revised, the range of functions was expanded and operation is now even more comfortable. The main functions can be conveniently set and controlled at any time using the touch panel. A further safety feature now prevents the side and maintenance doors from opening before the shafts have come to a complete stop. A modern PLC control system with an integrated OPC UA communication interface works in the background. The operating status of the shredder can thus be continuously transmitted to the company's internal server environment and important information such as utilisation rates or unplanned downtimes can be easily retrieved. These Höcker Polytechnik shredders are ready for Industry 4.0.

For more information, visit www.hoecker-polytechnik.com/products/paper-cardboard-shredder ■



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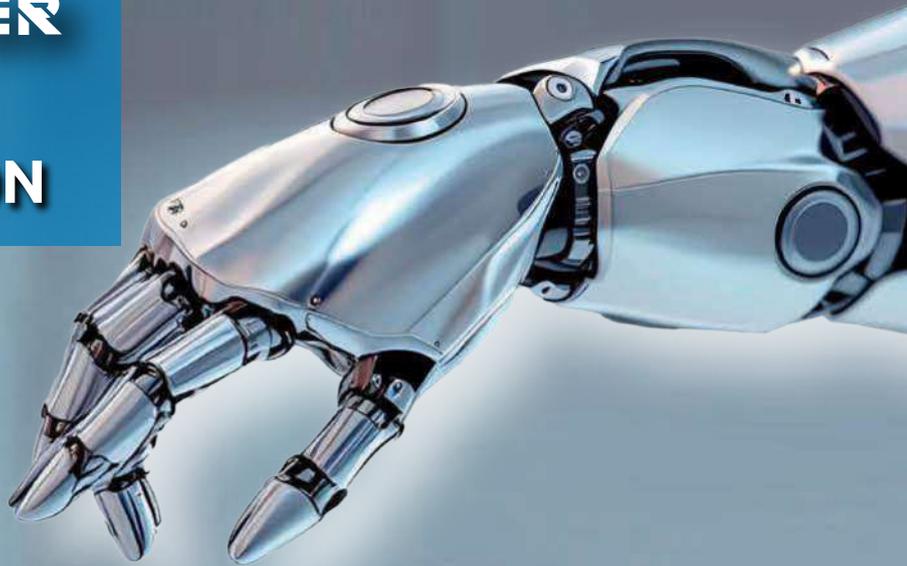
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Multi Joiner is patent pending.

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The Fossaluzza Vacuum Stripper Stacker URUS represents a revolution in the world peripherals for rotary die-cutters, combining highest levels of performance together with energy sustainability. This machine, designed to maximise productivity and optimise energy efficiency, quickly established itself as the benchmark for high-intensity production lines.

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made possible by an advanced engineering design that allows continuous and reliable operation even in the most demanding working conditions. The structural mechanical solidity, the use of top-level components in combination with the instantaneous power of brushless motors has allowed the Urus vacuum stripper stacker to establish new production standards for the rotary die-cutters lines.

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The Urus Vacuum Stripper Stacker has been specifically designed for heavy-duty applications and severe stress. As a Fossaluzza standard, great attention has been placed to reliability and durability, making it a reliable partner especially in the most intense production contexts. Its compact and robust design makes it ideal for industrial plants that require high performance, continuous operation, advanced automation and low maintenance.



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The modern corrugated box plant relies on equipment, systems and software to ensure maximum efficiency, productivity and output.

From scheduling of jobs and equipment, through to automatic material handling systems and into the finished good warehouse – never has automation had such a massive impact on running an efficient corrugated box plant operation.

Once an order is scheduled, you need to get raw materials to your corrugator and stacks of board away to the WIP. From here, stacks need to be delivered smoothly to the converting lines, along with inks and tooling, to produce the finished boxes. Once they are bundled, strapped and palletised, it is then into the finished goods storage, ready for delivery to your customer.

Automation of certain jobs within the plant also helps you reduce the risk of injury to your operators; thanks to the latest handling systems, the old way of manual loading of machines with large paper reels or stacks of board is now a thing of the past.

In the following 85+ pages, you will get caught up to speed on all the latest innovations in the overall plant management and logistics equipment and systems available today, from some of the world's leading suppliers.

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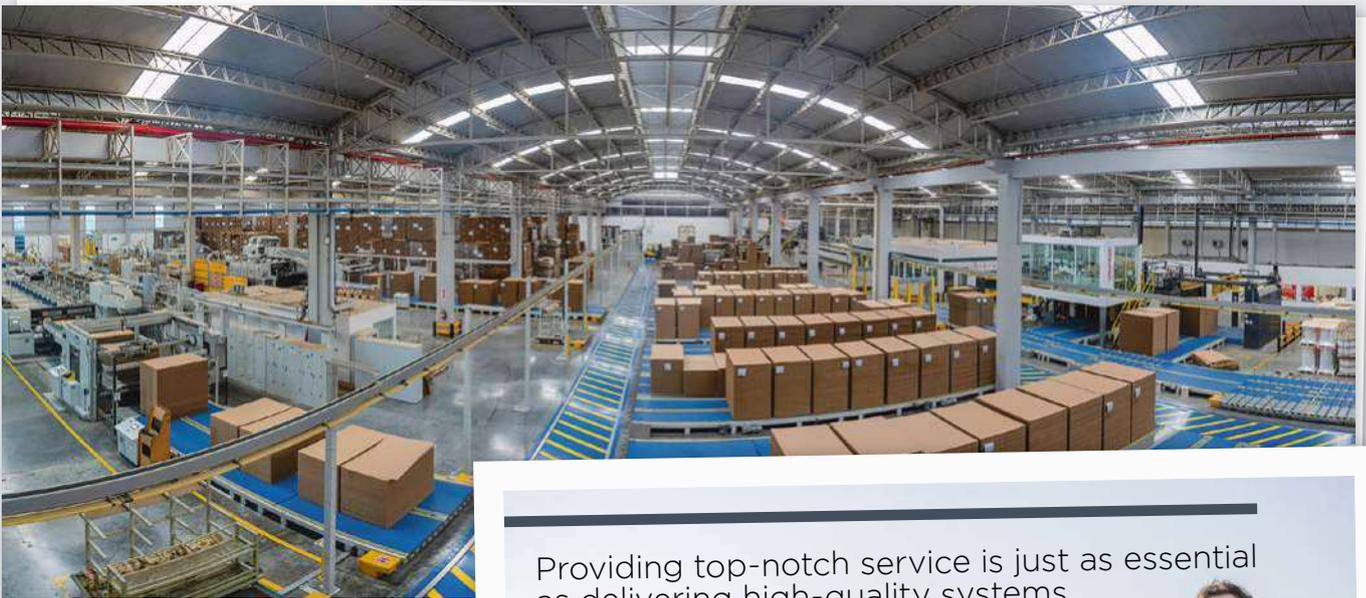
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MATERIALS HANDLING

AN UPDATE REPORT



Driving Innovation in intralogistics

Dücker Conveyor Systems GmbH stands as a leader in modern intralogistics, delivering state-of-the-art solutions for optimising production and logistics workflows. Renowned for reliability, efficiency, and exceptional quality, the company specialises in tailor-made systems designed for the corrugated board industry and beyond. By streamlining internal operations, improving production efficiency, and reducing costs, Dücker is setting new benchmarks in industrial performance. Innovation remains at the core of our philosophy, as they continuously explore new ways to enhance offerings and exceed customer expectations.

One of the cornerstones of our current growth strategy is the expansion of our service department. They recognise that providing top-notch service is just as essential as delivering high-quality systems, which is why they are investing heavily in this area.

Providing top-notch service is just as essential as delivering high-quality systems



By hiring additional technicians and enhancing customer-facing approach, Dücker aim to be more proactive in offering service solutions. Dücker sees service as a key part of its business plan. This ensures that customers receive comprehensive support throughout the entire lifecycle of the system, not just during installation.

One of its most groundbreaking initiatives involves refining programmable logic controller (PLC) processes. By simulating PLC programs before implementation, they achieve faster, more efficient, and virtually error-free system

start-ups. Testing these programs in a controlled environment allows them to address potential challenges early, ensuring seamless integration upon installation. This proactive approach not only minimises downtime and reduces errors but also provides us with the flexibility to allocate more time for customer-specific optimisations during on-site commissioning. This balance between thorough preparation and adaptability enhances the overall customer experience and ensures that the final solution meets individual needs with precision.



Looking ahead, ASCOR will also integrate data from third-party systems, unlocking new possibilities for analysing production and logistics holistically. This comprehensive approach empowers customers to uncover hidden optimisation opportunities and streamline their operations further.

Another exciting development on the horizon is the advanced simulation capabilities. Beginning in late 2025, Dücker will offer virtual testing of entire systems based on the ASCOR framework. By simulating the design and performance of a system before physical implementation, they

At the heart of technological advancements lies ASCOR, the proprietary software designed to manage production and intralogistics in corrugated factories. ASCOR's robust capabilities include visualising production processes in detail, maximising resource efficiency, and ensuring precise control of workflows. Historically, ASCOR deployments have been highly customised to meet individual project requirements. However, Dücker are now introducing a versioned and standardised core framework that separates customisations from the foundational code. On this robust foundation, they can implement customer-specific requirements more quickly and with reduced error rates, delivering tailored solutions with unparalleled efficiency. This innovative approach preserves the flexibility to cater to specific needs while ensuring the core software remains stable, upgradeable, and maintainable. This evolution not only enhances the software's power

but also simplifies updates, making it a sustainable choice for customers.

ASCOR's data collection and analysis capabilities are undergoing significant upgrades. Moving beyond simple intralogistics monitoring, they are equipping the system to gather and interpret data across a broader range of sources. This enhanced functionality allows customers to gain real-time insights into their operations, enabling data-driven decision-making and efficiency improvements.





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can identify bottlenecks, assess operational efficiency, and optimise layouts. These insights ensure flawless execution and reliability when the systems go live. Moreover, this simulation capability lays the foundation for the development of a digital twin, a virtual representation of the entire system. This digital twin will allow for real-time monitoring, performance tracking, and predictive maintenance, leading to even greater operational optimisation in the future.

One of Dücker's defining principles is its commitment to availability. While many providers focus solely on speed or

capacity, they prioritise creating solutions that maintain consistent operational performance with minimal downtime. Their systems are designed to be available over 99% of the time, ensuring customers can rely on them to support core business activities without interruptions. This focus on high availability directly increases the uptime of customers' systems, allowing them to maximise productivity and efficiency. This dedication to reliability sets them apart, highlighting the mission to deliver systems that perform day after day with dependability.

In summary, Dücker Conveyor Systems GmbH is at the forefront

of intralogistics innovation. From expanding service capabilities and refining the ASCOR software framework to pioneering advancements in data integration and simulation, they continue to push boundaries. The focus on availability and customer satisfaction ensures they deliver solutions that meet today's demands while preparing for tomorrow's challenges. As they advance, Dücker remains steadfast in its commitment to innovation, operational excellence, and long-term partnerships - helping customers achieve their goals with confidence and ease.

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Level Up Board Plants: the Success Story of DF Logistic Systems in Automated Vertical Warehouses

In the constantly evolving landscape of corrugated board production, DF Logistic Systems has emerged as a driving force, reshaping the way raw materials, intermediate products and finished goods are handled. With over 30 years history of successful implementations for industry leaders such as Saica Pack, DS Smith, International Paper and others, DF Logistic Systems is at the forefront of innovation. This success story is intimately interwoven with the integration of automated vertical storage and advanced conveyor systems, revolutionising the industry from corrugator, through WIP, pre-feeders,

stackers, palletisers and conveyor systems, to finished goods warehouse and shipping.

An Industry Overview

The corrugated business plays a dynamic and vital role in the packaging industry, serving a variety of applications in various sectors. Its core Logistics operates in three fundamental stages: the handling of raw materials (paper reels), the handling of

intermediate products (corrugated board sheets) and the production of finished products through a series of processes including packaging, strapping, stretch wrapping, pallet folding and palletising. DF Logistic Systems has not only optimised these stages, but also seamlessly integrated stacker cranes and advanced systems to improve efficiency and streamline the entire production cycle.



■ Raw Material Handling (paper reels and coils):

At an early stage, DF Logistic Systems revolutionises the storage of raw materials, namely coils, with the deployment of state-of-the-art automated vertical warehouses. At the heart of this innovation are the stacker cranes, a hallmark of DF's commitment to efficiency. These towering technological geniuses manoeuvre seamlessly within the vertical warehouse, precisely placing coils at optimum density. The result is an efficient use of space that surpasses traditional storage methods. While conveyor systems facilitate the initial flow of coils from the corrugator, the stacker cranes are responsible for facilitating retrieval, minimising downtime and significantly improving the overall efficiency of the production process.

■ Management of Intermediate Products (corrugated sheets):

WIP sheet-stacks palletising and labelling process elimination, managing a high diversity of board/order sizes and formats. As the corrugated sheets move through the WIP phase, the conveyor systems work in tandem with the advanced stacker cranes. These cranes operate with precision within the automated vertical warehouses, providing a systematic and intelligent approach to storing and retrieving corrugated sheets. Whether the sheets are palletised or unpalletised, the integration of the stacker cranes ensures fast and reliable access for downstream processing. This harmonious collaboration between conveyors and stacker cranes establishes an uninterrupted production flow, contributing significantly to operational excellence avoiding bottlenecks.

■ Finished Goods: in the final stage, finished products undergo various processes, such as packaging, strapping, bundling, pallet folding and palletising. DF Logistic Systems' automated vertical storage solutions seamlessly integrate and connect every step of this process, ensuring a cohesive and efficient workflow. However, it is the automated vertical warehouses and their automated stacker cranes that play a key role in this phase. As the guardians of the finished products, the stacker cranes store the products efficiently and safely until they are ready for dispatch. This not only ensures a cohesive and efficient workflow, but also guarantees the preservation of product quality during the storage phase, safeguarding the end products with precision and reliability.





Luis Miguel Barrientos, Sales Manager, DF Logistic Systems, says, "DF Logistic Systems' automated vertical warehouses, empowered by advanced stacker cranes, redefine the handling of raw materials, intermediate products, and finished goods in corrugated board plants. The integration of these technologies underscores our commitment to providing not just solutions but innovations that elevate the standards of efficiency and quality in the industry."

■ **Optimised Space Utilisation:**

DF Logistic Systems has been instrumental in introducing innovative solutions that optimise space utilisation in corrugated plants. By implementing high-density vertical storage systems, these warehouses maximise storage capacity without compromising accessibility. This strategic use of space improves efficiency while accommodating the diverse storage needs of corrugated board plants.

■ **Seamless Integration of WMS and WCS:**

capability of highly improving the information, traceability and material flow control. The incorporation of Warehouse Management Systems (WMS) and Warehouse Control Systems (WCS) has brought about a radical change in DF Logistic Systems' approach. This integration ensures harmonious coordination between the various warehouse processes. The

intelligent combination of WMS and WCS ensures efficient inventory management and streamlined operations, providing corrugated board plants with a comprehensive solution to optimise their warehouse activities and achieve operational excellence. DF Warehouse Management System (WMS) can also integrate in the same system the management of additional either conventional or automated storages (non standard loads, tools - rotary dies/printing plates).

■ **Improve Productivity and Quality Standards:**

the opportunity to reduce the impact of human factor in the production centre performance regarding its different processes (handling, storage, traceability, quality and information control processes). Personnel currently allocated to handling tasks that can be promoted to higher value add tasks, for example, (material

waste reduction, quality control, efficiency improvement, etc.). Embracing automation through the implementation of automated vertical warehouses not only improves productivity, but also maintains high quality standards within corrugated plants. DF Logistic Systems' expertise in developing customised solutions ensures that automation is seamlessly integrated into existing workflows, resulting in improved overall operational efficiency and customer satisfaction.

■ **Sustainable Storage Practices:**

the incorporation of stacker cranes in DF Logistic Systems' automated vertical warehouses brings a special advantage that resonates deeply with the intrinsic sustainability of the industry. By optimising space utilisation, these stacker cranes directly contribute to reducing the overall footprint of the storage facility. This eco-friendly approach aligns perfectly with the sustainability goals of corrugated board plants, reflecting a commitment to responsible resource management. Lowering the amount of raw material waste during manipulation, by eliminating human error and enabling longer runs in the corrugator. As a result, the stacker cranes not only improve efficiency, but also raise the environmental awareness of the entire production process, moving towards a greener and more sustainable future for the corrugated industry.

www.durofelguera.com



Building a Future with Technology and Craftsmanship

Emmepi Group is a leading manufacturer and developer of integrated product flow systems to the corrugated industry, with machinery ranging from handling, strapping, wrapping, peripherals to state-of-the-art robotics. Emmepi Group operates across nine European locations focussed on producing various automated handling systems including rotating roller conveyors, pre-feeders, palletisers, robots for folder-glueurs and die-cutters, stackers with vacuum conveyors, pallet inserters, wrapping machines plus other ancillary equipment. This broad product range coupled with a proactive service offering, ensures a turnkey made-to-measure solution to service today's market demands.

Two-Level Finished Goods Line

Emmepi Group is proud to be pioneers of a two-level finished goods line concept. This solution enables customers to make the most of available space, as the pallet warehouse is situated on a new, mezzanine floor level. Many

customers with ample space even opt for this arrangement since it promotes a more streamlined workflow. The clamp retrieves the

pallets from the mezzanine floor and deposits those pallets onto the ground floor; where, after being precisely centred by a pusher system, they are then positioned under the stack, ready for distributing.

This innovative new system optimises spatial efficiency and enhances the overall productivity of most packaging processes. By elevating the pallet storage area, there is more space created for other converting machinery within the ground floor footprint. The system is designed to be flexible and adaptable, ensuring that it can meet all the varying needs of our customer's diverse requirements.



Virtual Reality Systems

Emmepi Group has designed a corrugated virtual reality (VR) environment, which truly allows customers to ‘move inside the box’. This ground-breaking service has been created to assist customers who are wanting to understand the benefits and impact of a modern materials handling system on their existing packaging lines. The VR system is a recreation of a finished goods line featuring an automatic motorised cart, switches, conveyors, rollers, palletising machines, turntables, strapping machines, duplicator and wrapper. This enables individual customers to explore their future operations – in advance of making a significant

investment – from a perspective that closely resembles that new reality: a non-stop, fully automated production flow system.

This innovative VR approach not only highlights Emmepi’s technological capabilities and the future benefits of investing in its devices, but also transforms the way they engage with customers and partners in the future. By offering this complete immersion in a virtual replica of a production line, they provide a first-hand experience of the technology, innovation, attention to detail, all in advance of your main investment, giving you peace of mind that the layout you have chosen is the perfect fit for your factory’s needs.

As this VR pathway is developed, Emmepi envision a platform where servicing, equipment manuals, system training, troubleshooting and interactive demonstrations become the norm.

Robotics

The benefits of integrating robots into the corrugated packaging industry are vast and transformative. Firstly, robots enhance efficiency by performing repetitive tasks with precision and speed, leading to increased production rates and reduced human error. This automation allows human workers to focus on more complex and creative tasks, fostering innovation and job satisfaction.



HANDLING DIVISION

- Our machines:
- AUTOMATIC TRANSPORTATION** systems
-
- PALLET INSERTERS** centre
-
- AUTOMATIC WIP**



ROBOTICA DIVISION

- Our machines:
- PALLETIZER** for casemaker
-
- PALLETIZER** for folder gluer



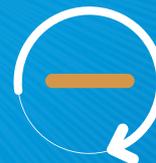
STRAPPING DIVISION

- Our machines:
- VERTICAL AUTOMATIC STRAPPING MACHINES** for sheets and for pallets
-
- AUTOMATIC STRAPPING JOGGERS** and for folder-gluer



PERIPHERAL DIVISION

- Our machines:
- PREFEEDERS** top and bottom print
-
- PALLETIZERS** fully and automatic palletizers
-
- STACKERS** and vacuum stripper



WRAPPING DIVISION

- Our machines:
- RING** wrapping machines
-
- ARM** wrapping machines



Robots contribute to improved workplace safety, as they can handle heavy lifting and can operate continuously, optimising production schedules and reducing downtime. Furthermore, the adaptability of robots enables them to handle a variety of packaging sizes and shapes, ensuring versatility in production lines.

Emmepi Group has designed a new robotic palletiser with an innovative clamping system which can palletise virtually every type of box coming off today's modern folder-glueers and casemakers. The clamp picks up the bundles by using either a mechanical blade solution or via a vacuum system or a combination of both. Customers have the flexibility to set and change these settings on the fly. The robot undertakes stack squaring and sheet inserting (bottom, middle and top) and handles rapid format changeovers. The advanced software systems that is embedded in the robotics intelligently manages the pallet stacks to immediately maximise space on the pallet and in the longer term, by using the data collected, provides valuable insights into production processes and to facilitate continual improvements.

By integrating robots into the process, companies can achieve significant cost savings as well as increased output, alongside notable waste reduction. Ultimately, the use of robots in the packaging industry not only elevates operational efficiency but also paves the way for a future where technology and human ingenuity work hand in hand to create smarter, more resilient production environments.



Through these initiatives Emmepi aim to redefine industry standards, promote continuous improvement and better satisfy the evolving needs of customers. As they pave the way for a more interactive and dynamic future, Emmepi invite you to join them in exploring the possibilities of our offer. "Whether you're a current partner or are new to our product

and service offerings, we are eager to demonstrate the unparalleled quality and expertise that Emmepi Group brings to the table. Together we can build a future where technology and craftsmanship seamlessly blend to create superior packaging solutions that exceed our customers' expectations," said Alessandro Bersanetti, President.

www.emmepigroup.com



IMS Improve Efficiency, Reliability and Introduce New Designs

During these difficult times of financial pressures, uncertainty and political changes equipment reliability and efficiency are even more important than ever.

For Interpack Machinery & Services, 2024 was a year to help customers improve efficiency and therefore the return on investment.

Sometimes that has been to install new high capacity and low power consumption conveyor systems which increase throughput and therefore ROI and production levels. This can quickly improve the margins on jobs which can be used as a 'buffer' to win more business and increase output further. Often systems can be improved

an interesting and productive range of compact robotic solutions with a great return on investment. In simple terms the robotic pre-feeder

without the need to replace whole lines of conveyor which can be even more useful to know as an infrequent hardware purchaser as many end users are. Large installations are nice for suppliers to provide, but IMS also get a great deal of satisfaction from making existing equipment more reliable and efficient.

IMS, working with their partners, offer



is fully automatic and requires less space than a traditional pre-feeder. In addition installations benefit from IMS conveyor equipment, control and guarding systems which ensures UK standards and support are provided.

Having recently partnered with Geo M Martin Co, IMS are now able to offer their products in the UK market to benefit the production of die-cut work with their equipment including improved stackers, breakers and bundle line systems.

In 2017, IMS designed and introduced a new stacker for high quality flexo printing machines, now in 2025 they will be installing the fourth complete unit in the

UK. This shows that IMS do not simply provide a single solution for customers but can provide exactly what is needed, even if it is bespoke. Retaining their in-house design, and full control of their UK manufacturing, IMS continue to make innovations to achieve the best outcome for the customer.

With their legacy products, IMS are still asked to provide sleeve Hhandling equipment for use with plastic sleeves for pallet free board storage without the need for many lanes of board storage conveyors. This system best suite sites where there is not space for enough storage conveyors or those who just don't want them. When combined with

a central automatic pallet inserter in your finished goods warehouse area this means the removal of all wooden pallets from the production area which many customers are now striving to achieve.

Phil Howarth comments, "Moving into 2025 the focus for IMS will remain on new products, improving efficiency in our customers production and ensuring that their capital expenditure is utilised wisely to increase profitability and future business opportunities for us all. With exciting new designs currently in the R&D and prototyping stage this year is going to be exhilarating."

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Pallet loading station and empty pallet robot

Reconstruction During Ongoing Production

At DS Smith Packaging Austria GmbH, Margarethen am Moos, MINDA implemented the automation of the intermediate storage and a new pallet securing line.

Project Planning as Key Factor

In advance, intensive planning was necessary to avoid any production downtime in the plant despite the extensive reconstruction. "We planned meticulously which modification steps to carry out when. Many project steps happened at the same time, and it was essential to keep to the schedule, and this was achieved thanks to Minda's carefully elaborated assembly plan," explains Patrick Baldauf, Site Operational Excellence Lead and Project Manager, DS Smith Packaging Austria. "Minda's connection plans allowed our preliminary

work such as cable routes and supply lines well ahead," adds Florian Pointinger, Maintenance & Engineering Manager.

"We could rely on the excellent project preparation at DS Smith, it simply matched," confirms Bianca Böke, Sales and Project Management, Minda.

The rebuilt components were completely dismantled and modernised to ensure process reliability for the future. Within the pallet securing line, two old units were replaced by a new pallet loading station BoP (Block on Pallet) without any production downtime, "Production downtime was not possible. Day-to-day business had to continue," says Baldauf.

The aim of the project was an increased performance in the plant through automation and installation of new components, and thus an optimization of the transport properties and the stacking patterns.

Corrugator Discharge and Machine Infeed

The area upstream the converting machines, including intermediate storage, was fully automated. Material flow tracking is now provided right from the corrugator so that every stack is visualised and identified in the plant at any time.

Regarding the machine periphery, DS Smith relies on the Minda-Advector family as pre-feeder and on the Fractor breaker line in cooperation with MuK (Maschinenbau und Konstruktion GmbH Elmshorn).

The automation of the plant offers central benefits in daily processes. For example, advance planning is easier and delivery tours can be better coordinated in the dispatch department. "Previously, we had to walk through the production area, but now the material flow can be tracked on the screen for optimal planning," notes Baldauf.

In the intermediate storage, non-driven roller conveyors were replaced by plastic chain conveyors leading to a significantly increased stack quality (no sheet walk effect) and higher sustainability by reducing waste.

Finished Goods Area and Pallet Loading Centre

The machine discharge lines were modified for parallel discharge by the 2-deck transfer car with increased performance.

The layout of the dispatch hall was completely adapted. Instead of palletising via two loading lines as before, the complete finished goods are now prepared for dispatch via one loading station and two strapping lines. The pallet securing line was adapted for optimum

material flow so that the stacks are removed centrally close to the dispatch and finished goods storage.

Minda planned the new pallet securing line based on a 3D scan in advance. "This scan was essential for the further implementation," emphasises Baldauf.

The 360° scans provided a detailed visualisation of the plant and ensured maximum planning reliability and collision control ahead. For example, structural features such as ceiling trusses, sprinklers and lighting systems in the dispatch hall could be identified directly.

The stacks from the converting hall are fed to the pallet securing line via a turntable with two separate decks, so that up to four stacks can be turned simultaneously. A right angle station transports stacks still requiring changing orientation for palletising towards the loading station.

Several blocks can be stored on the buffer section upstream the pallet loading station for a continuous flow.



Pallet loading station and platform

Pallet Loading Station BoP and Bottom Sheet Inserter

With the new installation, the capacity is achieved with just one pallet loading station so that the operating personnel can be deployed more efficiently.

Within the double loading station for sheets or finished goods, for example, a large block can be placed on pallet patterns or two smaller blocks with the

same width can be palletised within one cycle.

Accessibility to the loading station for the operators was also important as the forklift traffic must not be crossed. For safe access, a platform was erected to reach the loading station via a bridge. This was also planned and delivered by Minda.

When optimising the layout, Minda always focuses on the overall planning for the customer, leading to intelligent layouts, for example for customer-specific escape route planning.

Following the material flow, a new bottom sheet inserter was installed downstream the pallet loading station to place the top pallets or cover sheets. Due to the building conditions, especially the ceiling beams, a customised design was required for the installation.

With sustainability in mind, many well-kept existing components were reused on site and integrated into the new control system. In addition to strapping machines, stretch wrappers are also integrated into the finished goods line.



Turntable with two separate decks

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Performance by Automation

Thanks to the specific preparation and cooperation of the project management teams, the innovations could be implemented during ongoing operation.

The decisive factor was the planning ahead, which was visualised by a precisely customised assembly plan. "The assembly plan was crucial for our personnel planning," adds Pointinger. Even though there was a maintenance team, the day-to-day business should not be neglected by the large-scale reconstruction.

"It's a giant task to plan such a project. Thanks to the assembly planning, all preliminary work on

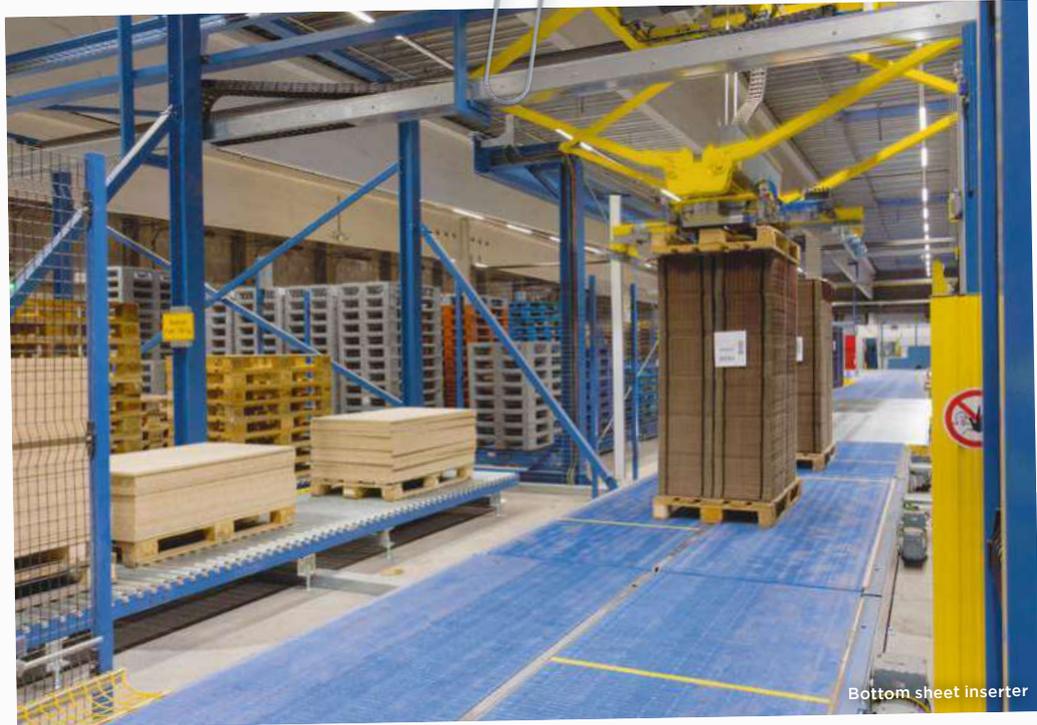
our part ran smoothly and any bottlenecks were mitigated in advance," says Baldauf.

The final result confirms Baldauf's decision for Minda as partner for the complete automation of the plant, "We already had positive experiences with Minda in the past and are

familiar with the company's strengths and expertise. There is a well-engineered concept behind."

"The reliability of low-maintenance components and the aimed support by Minda technicians when required are also convincing for us," concludes Pointinger.

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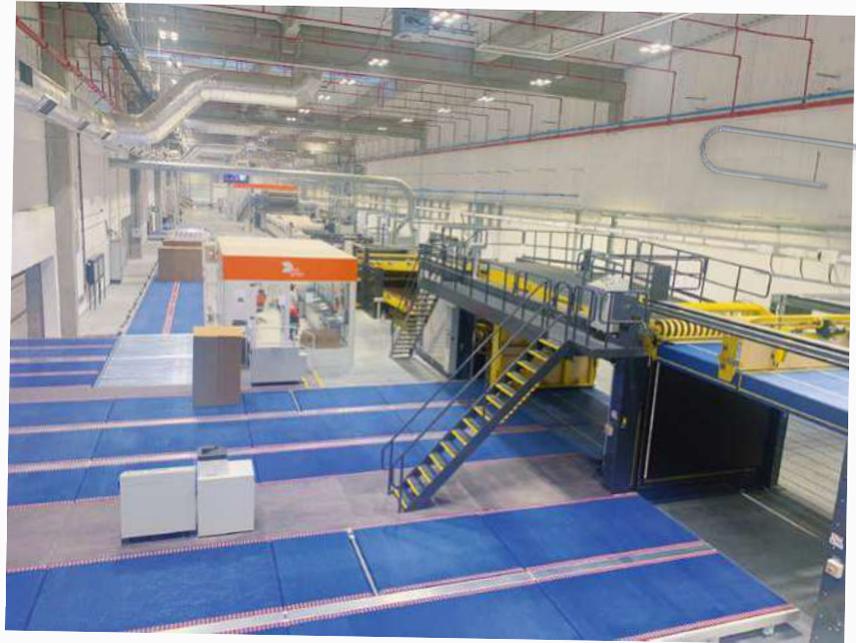
'Made in Italy'

NEE is well known as manufacturer of cut off exit conveyors and down stackers for different speed ranges and corrugator deckle. The care they take in the design and the technical solutions make the difference for customers around the world.

The company has a broad portfolio of materials handling solutions, all of which help box plants to increase overall efficiency, speed up the production process and reduce waste. NEE is a specialist in designing and manufacturing advanced solutions.

For almost 25 years, the company has been manufacturing robotic palletisers for the corrugated industry and is able to propose solutions for

casemakers, die-cutters and for special applications. They also manufacture pre-feeders for the fastest converting machines available in the market.





In terms of the latest innovations, the company has been paying close attention to multi level WIP and storage solutions. For example, to make the two floors work effectively in the converting area, NEE use dedicated elevators for material movement and not elevators on the shuttle cars. The two floor design makes sense whenever the space in the plant assigned to WIP is narrow.



All of the pictures of WIP shown here are taken from plants operating in fully automatic mode, under supervision software written by NEE.

At the end of line, NEE offers complete pallet inserter system, complete with a robot that brings the pallet from the storage area and drops them into the machine.

Examples of NEE materials handling systems can be found in corrugated box plants all around the world.

www.ne-engineering.it



HANDLING MADE CREATIVE



N.E. Engineering is the Italian company leader in designing and manufacturing material handling system for corrugated board plants and paper mills. The great success collected worldwide comes out from the innovative design and the professional skills of designers and technicians. The experience combined with brilliant ideas makes the good mix to achieve successful results. Our equipment can be easily integrated into existing or green field plants, offering immediate results like productivity growth, better production quality, more flexibility and the faster service.



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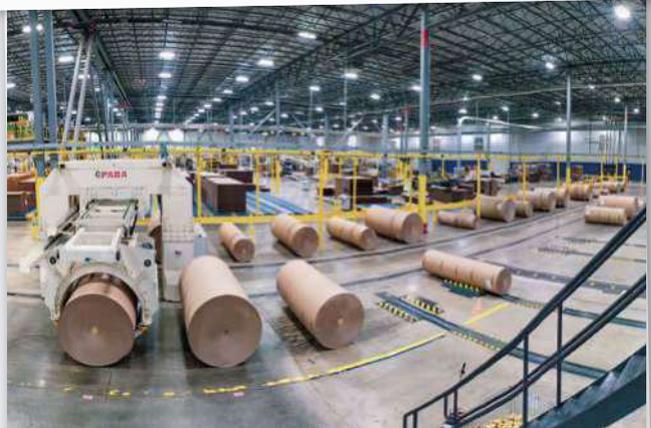
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Automated Production Methods

Para was founded in 1976. From the beginning, the company did not hide its industrial ethics: its goal was to exploit the full potential of automated production methods, constantly monitoring the changes in an increasingly global market.

Para offers a highly qualified team of over 80 people and a hundred external collaborators and subcontractors to support all of its national and international customers spread across Europe, Middle East, Mediterranean Africa, Russia, United States, South America and Australia.

Para also dedicates its production resources to international supplies, being strongly involved in important projects for many multinationals and large privately owned companies.



The Para production is set out as a wide, diversified choice with smart technical solutions and includes any answers for material handling and peripheral machinery for the corrugated board industry, with many patents registered. A comprehensive range that includes corrugator take off, WIP storage on acetal conveyors or vertical multi-level storage, vertical storage for paper reels, paper reel feeder distributor to the corrugator, FBDC, RDC and FFG pre-feeders and palletisers, bundles breakers, stackers and vacuum stripper stackers, pallet inserters.



In Para, materials of the best and leading brands are used, assembled exclusively in the HQ workshop in Florence by highly specialised technicians trained and supervised by managers with decades of experience. This gives the certainty of a reliable product, execute, and verified with standardised internal procedures which have improved over time.

Para's goal is to offer personalised technical assistance with services such as scheduled maintenance, corrective actions and safety checks, to ensure the maximum performance of the devices of the machinery throughout the life cycle, prevent breakdowns and reduce downtime, thus ensuring the best performance of the devices and protecting customers in their investment.

Thanks to an attentive after-sales service, Para is able to remotely connect to all its machines for immediate assistance. In case of need, all the spare parts of devices are available in stock to have an immediate response to the customer's request.

www.parasrl.com



SEEMI moves it, for you

Founded in 1964, SEEMI SAS, based in France, remains one of the world leaders in the design and manufacture of automated materials handling systems, automatised and supervised for the corrugated industry.

Celebrating 60 years of experience, the company is well known for the high quality of its products but also its capacity to respond to specific projects with custom-made solutions. It continues its growth and has developed a large customer base, handling projects of different sizes all over the world.

In constant search of innovation, the company's mechanical, electrical, R&D and sales departments are in an evolution dynamism, to be able to propose day after day to the customers the best solutions for their projects and requirements.

From Simple to Complex Solutions

Seemi offers typical handling solutions, from simple to most complex:

- Corrugator discharge, with flexibility given to running speeds and load building areas;
- Paper roll conveyors for corrugators;
- WIP;
- Intermediate and finished good storage;
- Infeed and outfeed of all converting machines,

with operators' working space optimisation;

- Semi-automatic palletizers (PSA);
- Centralised full-automatic pallet loaders (CENTREPOSE double or simple);
- Empty pallet dispensers;
- Revolving units;
- Elevators;
- Strapping and wrapping lines;
- Horizontal and vertical dynamic storage;
- Automation, with connections to existing materials and internal software;
- Full or partial supervision of your production, software-controlled systems and RFID solutions to follow the products;
- Interface with vertical storages;
- And many other machines designed and assembled at the wish of our partners.





Materials handling and Pallet loading



Loadpoint DIECUTTER



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Search 'SEEMI'
or scan the QR code





Seemi has developed a long-term partnership with some of its competitors, providing machines for them to integrate in their systems. Elevators, Top Protections Dispensers, Centreposes, Corner Pad Inserters or Revolving units, all of those machines have been successfully integrated in famous handling-systems actors systems for their own customers.

How to replace material in a factory already equipped without stopping the production? Seemi has the solution. Today the corrugated factories' performance is dependent of a good production, good quality of the finished goods, and is 24/7 running without major stops. For important modifications of the handling system in the factories, that is an obstacle, especially when the products transit through one line, one main shuttle car.

To solve this problem and to replace existing equipment, Seemi has a specific method: phasing. It means cutting the project

(installation and start up) in several steps (phases), sometimes more than 15, to permit a low level of perturbation of the production.

Many methods are used from Seemi to phase a project and the list is not exhaustive.

It can be:

- Putting provisory material (recovered conveyors or conveyors to be replaced after to insure a temporary junction);
- Ensuring the temporary transfer of the products with forklifts;
- Making the strategic junctions during potential weekends or weeks without production;
- Thinking about the ways to place the new material safely during the production, dealing with operators;
- Installing bar codes-readers or temporary supervision to follow the products before the final installation.

And many more! Each phasing is tailor made, and a custom solution after discussions with the customer. It is Seemi's expertise, with many years of experience.

This method is a competitive advantage, because it considers all the customers' needs. Seemi do not hesitate to recover material, and they make longer projects and rotation of installation teams, to ensure fewer stops of the factory and the optimum cadence during the work.

Working from Two Production Sites

Seemi has 85 employees, and can always count on CDLA (welding and folding company), UDLA

and Deville Besse (precision machining companies), both based in France close to Angouleme and belonging to Vigneras Group, to be able to propose shorter delays and high-quality standard for parts, and qualitative production.

To accompany its growth, Seemi has invested in a new factory close to Angouleme, in which has been installed an automatic cleaning-painting-drying line for all the parts before assembling, and a manual painting cabin dedicated to big formats. The assembly of conveyors is realised on this site, and the assembly of special machines is still made on the historical site of La Couronne, where remains also the cutting laser machines, the welding, folding and preparation of the parts, and the wiring of the electrical cabinets. The new site has been built to be extended in the future, with a large capacity of production and storage.

With a strong sales team and a worldwide network of agents representing Seemi for many years, the company is always attentive to its customers' requirements and requests. Its innovative and tailor-made handling solutions are the result of extensive experience and the continuous search for innovation by its integrated mechanical, electrical and automation R&D departments.

Also, always using new generation technologies for all materials, and focused on continuous improvement, Seemi daily guidelines are performance, optimisation, and service to their customers worldwide.

www.seemi.com

“Perfection is achieved not when there is nothing more to add,
but when there is nothing left to take away.”

- Antoine de Saint-Exupéry

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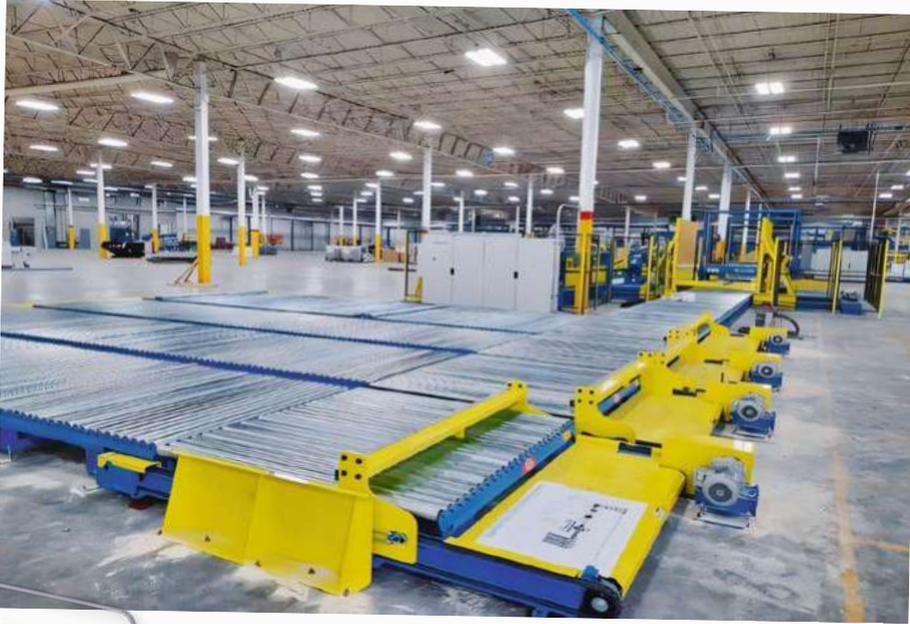
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progress they've achieved means that they can supply high-quality products and solutions to all sectors of the paper industries worldwide. As a true independent supplier, they offer you the best conveyor belt system for the job.

TE's integrated conveyor system incorporates with most sophisticated computers, PLC's and the best electrical systems the industry can offer. This strategy has proved extremely beneficial and has certainly contributed to its continued success over the years. Moreover, TE are the first company in the Taiwanese sector to build a nation-wide handling system with so many installations worldwide.

The conveyor system industries is a highly price-competitive market, and in order to survive you must be able to produce a high-quality system for a low price. Which is why TE invested so much time and money in research and development, not only to compete for export customers, but it is also crucial in the international market.

www.conveyor.com.tw

Recognised Industry Leader from Taiwan

Taiwan Endurance Co Ltd was established in 1967 as a corrugated, paper mill, and tissues handling system company.

For more than four decades, TE have been committed to a philosophy of high quality and excellent service in its effort to become one of Asia's leading conveyor belt system manufacture.

Today, the company produces a wide range of conveyor system for tissue rolls, paper rolls, and corrugated board facilities within Taiwan. The technological



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Automatic Board Handling System
for Corrugated Industry**



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Contact us



Fully Automated Cut-to-Size Goods Warehouses Reduce Manpower, Production Costs and Space Requirements

Maximum efficiency and automation are crucial competitive advantages for corrugated manufacturers.

The focus here should also be on warehouse logistics: advanced automated warehouse systems for cut-to-size goods complement the automation advantages of high-performance modern corrugators. They also reduce manual activities on the storage side and further minimise manpower requirements. Such intermediate storage systems increase the batch sizes that can be produced on the corrugator and reduce costly setup times. They can be used to produce and strategically store cut-to-size goods in maximum batch sizes, creating new and more efficient possibilities in the area of production planning.

Automated intralogistics significantly increases the storage capacity for cut-to-size and finished goods in existing plants. It can provide crucial support for the processes of corrugated cardboard manufacturers. Automated warehouses for cut-to-size goods decouple sheet production and processing.

Minimal Footprint, Maximal Capacity

One challenge facing the industry is the amount of space required to store large stacks of corrugated board. This space is not available for the continuous expansion of



The corrugated cardboard industry benefits from the material-friendly and space-saving high-bay warehouses from Westfalia Technologies and their flexible channel assignment.

production lines for new customised packaging. Existing warehouses can quickly become cramped.

For a large, well-known manufacturer of corrugated packaging, the German intralogistics specialist Westfalia Technologies GmbH & Co. KG has now – after the successful automation in 2023 – further developed an automated intermediate storage system in a second greenfield project with a go-live in 2025. The storage system can efficiently store cut-to-size goods in sizes ranging from 500 x 800mm up to unusual large formats of 2500 x 5500mm in high density.

The automated storage system stores stacks of different cut-to-size goods on multiple levels, reducing the floor space required for maximum storage volume while protecting the material. It accelerates the throughput of cut-to-size goods and thus the overall throughput times in production. All while reducing space, manpower and energy requirements and increasing flexibility in production and processing.

Shorter Distances Between Warehouse and Corrugator

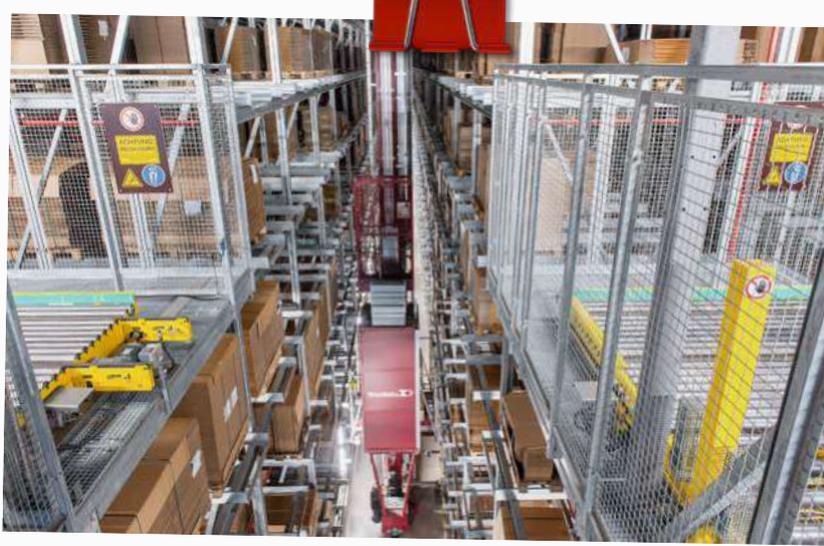
The compact, customised design allows intermediate storage to be placed close to the corrugator. This reduces the transport distances

for material and goods, the space required for transport routes, the times for supplying the processing lines and the intralogistics costs.

Instead of being stored on one level as before, the cut-to-size goods can then be stored on several levels in the same area. This increases storage density. Transportation logistics and storage space can be significantly reduced, with a considerable impact on the carbon dioxide balance.

Westfalia cut-to-size goods warehouses decouple corrugated board production from converting, enable flexible production planning and help to achieve the optimal ratio between productivity and set-up times. Costs are reduced while throughput times are kept short and the maximum output of corrugated cardboard products of consistently high quality is achieved.

If an intermediate warehouse has a centre block, all storage channels of this centre block can be accessed from the two adjacent storage aisles. Since a storage and retrieval machine (SRM) in such a layout can completely replace the second SRM during the maintenance of individual storage areas, warehouse operations and production are hardly interrupted due to the redundant access to almost every storage location.



View into the storage and retrieval machine (SRM) aisle with handover from the automated conveyor system.

Advanced Storage Algorithms and Components

The high-performance warehouse execution system (WES) Savanna. NET®, which can cover the entire warehouse management and material flow control if needed, efficiently arranges the cut-to-size goods and stores, transfers and retrieves them using proven algorithms for efficient routing. It makes the best possible use of the space and ensures that the cut-to-size goods are available just in time at the converting line.

Modern drives, sensors and control technology also ensure considerable cost savings on the storage side, as wear and tear on durable technologies is reduced and energy is intelligently stored, transferred and saved. Westfalia storage systems use the latest technologies in intralogistics.

Westfalia's WES can be seamlessly connected to common ERP software and material flow control software for conveyor and production systems. Functions can be integrated on a modular basis as required.

Automated WES-controlled storage systems for cut-to-size goods also enable precise inventory management and maximum storage transparency. Accurate inventory figures are available in real time for order management, production planning and the purchase of raw materials. The reordering of

paper and other raw materials can be strategically automated. The flow of information is optimised, planning is simplified.

Careful Handling of Materials

Westfalia offers systems optimised for palletless storage. Load handling devices are designed for high storage accuracy and high speeds as well as the transport of heavy, bulky corrugated formats.

Transport with telescopic forks or Westfalia's proprietary Satellite® system for palletless, multi-deep storage efficiently prevents deformation and damage to sensitive cut-to-size goods.

A conveyor system transfers palletless stacks of corrugated cardboard to the Satellite® load handling device.

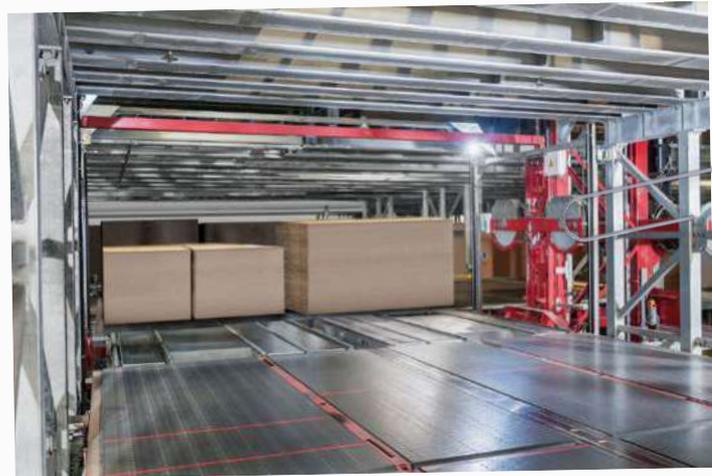
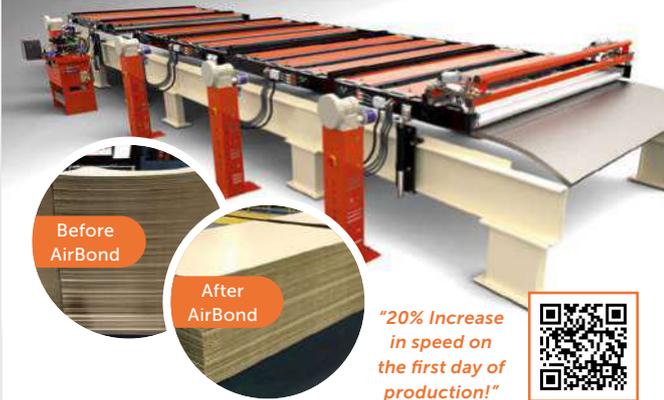


Illustration of Satellite® Storage System with external and flexible middle block.

AIRBOND

Double Backer Heat Transfer System

- Increase Corrugator Speed
- Reduce Waste
- Improved & Consistent Quality



"20% Increase in speed on the first day of production!"



Corrugator Speed Increase
5-25%

Conversion Throughput Increase
2-8%

Waste Reduction
0.5-2%

- Upgrade Weight Roll & Shoe Systems
- Even & Efficient Heat Xfer
- Low Maintenance
- Simple Automatic Operation



- Temperature Controlled Warp Arms
- Glue Gap Control
- Steam Zone Control
- Enhanced Process Control



- Reduce Steam & Starch
- Quick Installation
- Fast Return on Investment
- ... **AND MUCH MORE!**



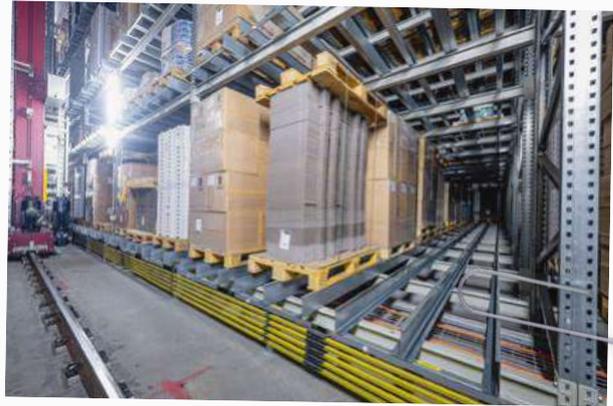
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The Satellite® travels from the storage and retrieval machine into the multi-deep storage channels of the packaging warehouse at Züger Frischkäse AG. The high capacity makes it possible to stock a large amount of packaging at favorable market prices.

Multiple rail systems in the storage channels provide additional support for stacks of cut-to-size goods. Sensitive cut-to-size goods pass through the automated cut-to-size goods warehouse in the best possible condition.

In summary, an automated warehouse system for cut-to-size goods offers several advantages for cost-effective, efficient production and storage of corrugated board and products, while reducing the need for skilled labour.

- Reduction of manual tasks after the corrugator in the interface to the warehouse logistics;
- Decoupling of corrugated cardboard production and corrugated cardboard processing;
- Flexible production planning;
- Optimisation of corrugator productivity: larger batches, shorter setup times, automated supply and disposal;
- Higher efficiency and lower costs through intralogistics automation;
- Higher availability of cut-to-size goods and higher storage density;
- Maximum storage volume on a minimal footprint;
- Storage system can be expanded as needed;
- Fewer manpower requirements in intralogistics and throughout production;
- Relief of the existing personnel by controlling logistics tasks instead of physically demanding manual storage activities;
- Minimal interruption of storage and production processes due to minimized set-up and maintenance times.

www.westfaliaeurope.com



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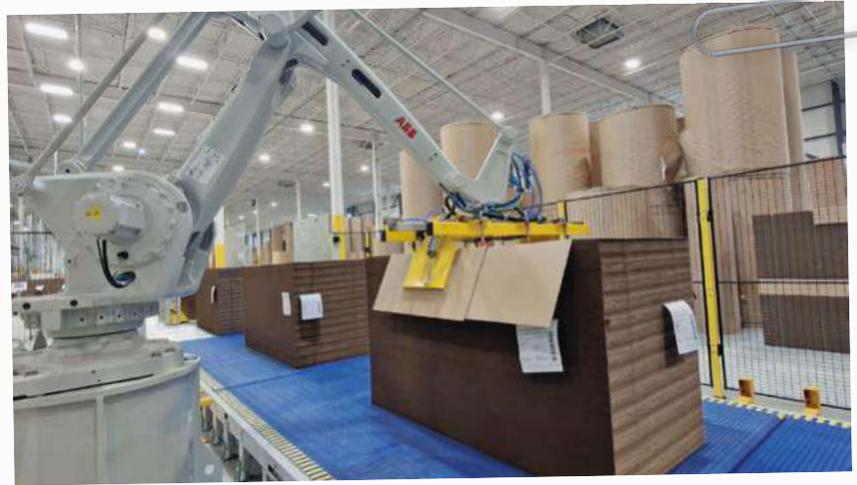
Global Design
Local Support



Continued Evolution in Automation

2024 was an exciting year for WSA USA as they designed and commissioned some of the most advanced and automated plants in the industry. The company continues to add to its automation solutions available for customers.

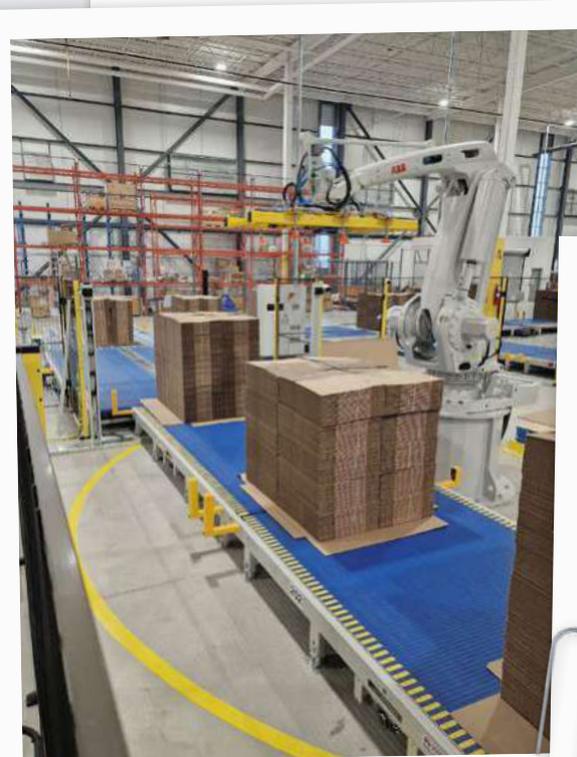
One such example is the new WSA Automatic Robotic Top Pad Inserter & Label Applicator designed for finished goods lines and sheet lines. This system features an ABB Robot with special vacuum gripper head, measures each unit, automatically places customisable dunnage patterns on top of each stack, folds the dunnage down and has an option to automatically apply a load tag. No longer do you need to rely on an operator to apply top dunnage, fold the sheets down and apply a load tag. This is a game



changer which further promotes full automation in plants. WSA's goal is to eliminate the menial tasks and continue to advance automation. Now running in North America.

WSA USA is also a North American leader in Vertical AS/RS Storage

solutions for WIP and Finished Goods applications. They have the first three installations running successfully in the USA at plants in the Midwest and Northeast with more to come in 2025 and beyond. These high-capacity systems support the largest and most automated plants in the





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CONTACT

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jimmcl@wsa-usa.com
to get started.



industry. The benefits include an increase in corrugator efficiency, significantly reduced product handling and waste, increased storage capacity, greatly improved energy consumption, reduction in plant footprint and building construction costs to name a few. If you are planning a new greenfield or looking to upgrade an existing facility there is no economic reason not to consider vertical storage.

WSA USA also continues to advance Finished Goods Solutions with its new Pallet Inserter and Load Tiering Device. In one compact machine, you can automatically stack two units and place on one pallet. Or palletise individual units as required. Its another example of how WSA USA automate customers' processes. Why ask a fork lift driver to double stack a unit and place on a pallet if this can be done with automation?

The WSA iFAS Factory Automation System seamlessly integrates material handling system with the plants ERP system and other OEM equipment from corrugator takeoff through WIP and throughout the finished goods line and warehouse with advanced order tracking and automation. All supported by the company's US based team which provides intimate customer support. This is one of the most advanced Industry

4.0 Smart Factory systems available running in many plants across North America today.

When we think about the future of our finished goods warehouses, WSA USA see high bay fully automated dark warehouse storage and retrieval systems and a fully automated truck staging and loading process. They have this technology available to industry today. Fully automated truck loading in eight minutes which is already used in other industries.

Validation Through 3D Digital Twin Simulation

"How do we know if this layout and investment will support a planned business mix and company goals and objectives? Can we present this to the board with true confidence in the end results? Trust the factual data and not the salesman."

WSA USA, they take a different approach to a new greenfield or major plant upgrade with our Digital Twin Simulation Team. In the simulation module, WSA USA create a digital twin of the exact planned CAD layout, include all of the specifications of the converting machines, corrugator and ancillary equipment, input all the order data statistics from your ERP system, factor in shifts, scheduled and unscheduled downtime, PM's and

much more. They include details from A-Z including number of fork lift drivers in shipping, truck loading times etc. "What happens next year if I replace an older machine with a new high speed flexo or die-cutter? What if I upgrade my corrugator to a higher speed." WSA USA maintain your layout in digital form to be able to have intelligent and educated discussions now and in the future as your business grows or changes.

WSA USA also offers a full complement of peripheral solutions from pre-feeders, robotic palletizers, bundle breakers and bundle line systems, pairing corners, load formers and so much more. WSA USA sees themselves as an automation partner in every aspect; not just in conveyance and storage systems but also in peripherals.

Jim McLaughlin, President, says, "What I am most proud of beyond all of our advances in our automation solutions is the team we have assembled for 2025 and beyond and in our approach to how we manage our projects and installations. We are different. I am told that regularly. We have a very intense focus on project management from inception to completion. No small detail is spared which helps ensure we meet every customer expectation and more and that we stay on time and on budget".

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High-graphic printing precision.
Full servo motor drive.



Bundle Stacker

High production efficiency.
High quality piling.





Combo trolley

Easy Handling of Tools Between Factory & Storage

Whether you need to transport your die-cutting tools horizontally or vertically – BCM has the solution.

Maximise productivity, improve workflow and ensure a safe, efficient and user-friendly way of transporting tools between the ground floor and second level. BCM specialise in custom made storage and handling solutions for the corrugated, flexible and folding carton industries.

Vertical Transport Units

Going up or down? BCM's vertical transport units are the ideal solution when you need to transport cutting dies, flexo stereotypes or printing sleeves between floor levels inside the factory. Specifically, the elevator ensures easy, safe and efficient transport of production material, such as dies and printing plates,

between storage and production areas when they are situated on different floors. On this basis, the operators can easily use the elevator to reduce the transportation time and avoid damage to

the production material or themselves during transport.

This electric elevator is specially designed for manufacturers who need to transport tools up to a mezzanine.

It is designed for BCM-designed trolleys with tools to fit perfectly inside. Please note that this is not intended to carry people. It helps to make work more efficient as you can transport several rotary dies at a time and helps to improve the working environment.

If the customer has the BCM storage on a mezzanine, which is on top of the converting line where dies and printing plates are needed, they recommend having multiple elevators. With

one elevator between each of the two converting machines, flat bed, die or rotary die-cutters, it serves two machines, and the customer avoids needing transportation of tools at the production level.



Vertical transport unit

LOOKING TO OPTIMIZE YOUR STORAGE LAYOUT?

At BCM we design our solutions in 3D software and collaborate with architects and other suppliers in order to layout a new and improved factory.

OPTIMIZE YOUR PRODUCTION EFFICIENCY

Logistics solutions for tooling ✓

Flatbed dies, rotary dies, printing plates & rack design ✓

Compliant with insurance policy ✓

Sprinkler system design ✓



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how we can help

More than 25 years of experience!

bcmtranstech.com



Rotary die trolley



Print plate trolleys

The trolleys are easy to operate and move due to durable and light weight construction of uni-profiles. They can contain your entire production set of, for example, printing plates in one unit for safe, simple and efficient handling. The trolleys have

labour in tooling logistics with BCM Tooling Trolleys. All trolleys can be configured for transportation on any existing conveyor system.

Smart Storage Solutions

BCM Transtech has a long and successful history in designing, manufacturing and implementing storage and handling solutions worldwide. Whether it be a fully automatic computer-controlled storage system, or a transport trolley.

www.bcmtranstech.com

Transport Trolleys

The BCM trolleys are constructed to ensure safe and efficient transport of flatbed dies, rotary dies and printing plates between the storage and the converting lines in the production. They can be designed to fit the customer's requirements and built so the operator can reduce the transportation time between storage and production. Specifically, the operator has easy access to all the tools so that the trolleys can be efficiently loaded and unloaded.

large rubber wheels with front-mounted brakes to ensure stable and safe operation. Uni-profiles are maintenance-free and easy to keep clean.

Transporting Tools on Conveyors?

Reduce manual



Conveyor trolley



Professional Dedication In Top Corrugator Dry-end

For **22** Years
2003-2025



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Boosting Automation in Corrugated Production with Robotics

Utilising robotic technology for pre-feeding, palletising, and packing can help packaging converters tackle the multitude of challenges in corrugated production. Accurate and efficient handling of sheets, blank piles, and finished boxes through the implementation of process automation with robotics will not only reduce costs, limit waste, and ensure top quality, but also ease the workload on operators and avoid bottlenecks in the production workflow.

BOBST has taken the next decisive step towards realising its vision for the future of packaging production – a future built on automation, digitalization, connectivity and sustainability with Bobst Robotic solutions. Peripheral robotic solutions for automated

materials handling are available for Bobst folder-glueers, flatbed die-cutters, and flexo folder glueers. User-friendly and easy to operate, these industry-leading solutions include Bobst ROBLOADER and ROBOPALLETIZER, along with robots ensuring the safe transport and accurate labeling of pallets.

“Bobst is one of the only suppliers to offer complete and highly flexible equipment solutions for the corrugated board industry, allowing customers to configure fully automated packaging production lines with the help of the latest developments in robotic materials handling,” stated Gilbert Joux, Product Management Director Peripherals. “Bobst Robotic systems add enormous value for our customers, helping them to mitigate staffing challenges, alleviate time and cost pressures, increase efficiencies, reduce material waste, and offer

much better working conditions for the operators.”

Automated Material Feeding

Bobst Roboloader automates the transfer of blank piles, eliminating the need for any manual intervention at the feeder. The robot ensures regular and consistent supply to match top machine speeds, enabling optimal production line productivity. There are different types of Roboloader designed for various loading needs, which means customers can choose the feeding robot that best suits their machine and workflow.

Accurate feeding is essential to the integrity of the corrugated sheet. The robots ensure precise and centred shingle feeding or the perfect positioning of sheet and blank stacks. If needed, six-axis robots with mechanical gripper provide the capability to overturn the batches.

Palletising Blanks and Boxes

Meanwhile at the end of the converting line, the finished blanks or boxes must be handled with equal care and precision. Bobst Robopalletizer stacks the piles or batches in various patterns, completely automating the palletising process. These highly versatile robots offer tailor-made solutions according to each customer's needs, thanks to several gripper types and the option to combine various robots.

Different layering options ensure that blank piles, as well as banded and non-banded box batches, are palletised to match speed requirements, while preserving product quality and ensuring stability for safe transport. Two peripherals can be combined to leverage top machine speeds, such as connecting a Robopalletizer FG (for folder-glue) with SPEEDPACK and

its banding/strapping solutions for automated settings.

Safe Pallet Wrapping and Labelling

Once the pallets are complete, they must be prepared for their journey to the customer. Each pallet should be secured so the load is fully protected during transport. It must also be labelled correctly to avoid any shipping errors.

BOBST ROBOTOP, WRAPPER and ROBOLABEL automate these important steps, safeguarding quality, speeding up the wrapping process, and ensuring that the pallets can travel securely to the right destination.

Robotics is the Future

In summary, with the power of robotics, converters can leverage a wide range of benefits when it comes to materials handling. Robotic technologies are essential

for aligning production speed and volume with the advanced capabilities of Bobst's corrugated packaging lines.

By strategically investing in robotics, Bobst has unlocked end-to-end automation for its customers in line with the company's future vision. "Our robotic solutions allow converters to maximise the potential of their equipment, helping them meet ever-tightening deadlines and demands for fault-free packaging with minimal waste. Robotics bring exceptional value by boosting productivity and, crucially, by addressing any sustainability concerns," concluded Joux. "With Bobst Robotic solutions, we're paving the way for fully automated box plants where manual errors in materials handling are a thing of the past and waste is kept to an absolute minimum."

www.bobst.com



Robotic Solutions Specialists

C-TECH, located in the Netherlands, offers 100% automation on multipoint folder gluers for corrugated and high quality laminated board with robotfeeding, robopackers and robotpalletisers and also robotprefeeders and robotpalletisers for flexo folder gluers.

The Robopacker, with the first generation installed in 2017, automates the collecting and strapping of all type of boxes behind any type of folder gluer and replaces the manual take-off that is limiting the speed of the folder gluers.

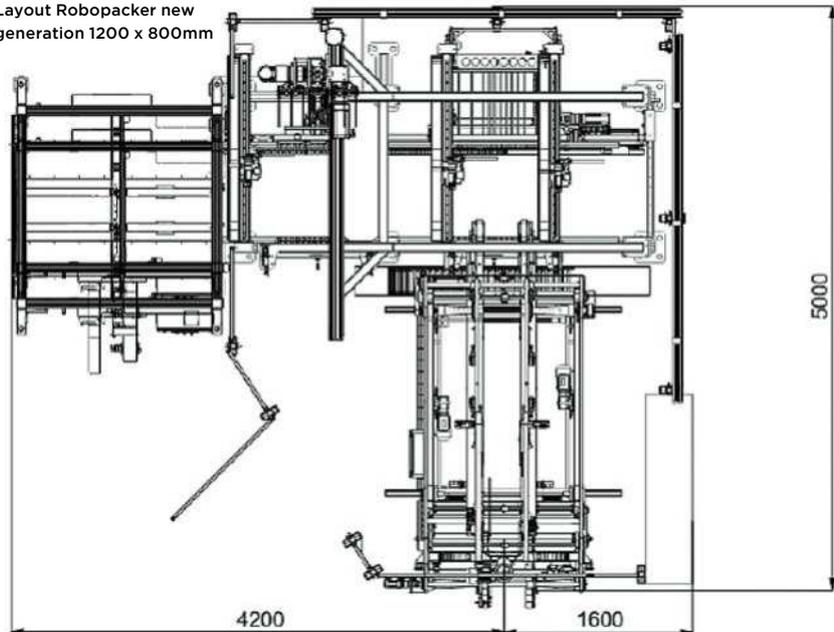
Even disproportionate low and large crashlocks in high quality laminated board are turned and strapped into inverted bundles with no damages.

The Robopacker has a 100% servo-driven automatic setup with no manual adjustments needed: 1 min set-up time for repeat jobs and our customers report an average of 4 mins for a new job. It can handle boxes from 200 x 120mm up to 1,200 x 1,200mm and even 1,600 x 1,200mm for centred 4 corner boxes.

With a minimal length behind the folder gluer of 5,000mm (Robopacker 800) or 5,400mm (Robopacker 1200) and with the choice of a left-out or right-out version it offers you the best flexibility for automation also in limited spaces.

For e-commerce boxes with a taping machine in angle behind the folder gluer, the complete robopacker with SMB strapper can be mounted on a platform to move it behind the two exits: inline with the folder gluer or at the exit of the taper.

Layout Robopacker new generation 1200 x 800mm



In order to make automation work, a machine should preferably be able to handle all products in order to avoid shifting to manual take-off or manual palletising as much as possible.

C-TECH developed its palletiser in such a way that also difficult slippery boxes can be palletised and transported safely after

palletisation. The new generation of palletiser has a mechanical squaring device to align each stacked level.

More than 100 specially developed palletising patterns are included to guarantee the best possible stability and to obtain the shortest set-up time for the operators. Also for FFG's the

Robotpalletiser with pre-stacker for higher speeds offers a flexible solution especially for chimney stacking patterns (no loss of speed) or when available space is limited.



C-TECH installed the first Robotfeeders on multi-point gluers in the corrugated industry in 2013 for feeding all type of boxes. Also crashlock die-cuts that are nested on the pallet can be fed with a turning station and prefeeder for higher speeds.

The Robotfeeders can also be used as pre-feeder in front of FFG's, flatbed die-cutters and laminating machines for die-cuts and sheets



with minimal sizes 300 x 200mm up to 3,000 x 1,200mm.

C-TECH is 100 % owned by the VALTECH GROUP in Belgium. Belgium-based BOX-OFFICE B.V. is marketing the robot automation solutions from C-TECH.

www.box-office.be

Platen – beam cleaning system for all automatic diecutters



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- > **Up to 70% less patching**
- > **Up to 50% less set-up time**
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Advantages of our system

- > No need for a skilled technician
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box-office
BVBA / SPRL

Quality, Reliability, Ergonomics and Low-Maintenance

Duecker Prefeeder BV, well known for its line of pre-feeders that meet highest standards in terms of quality, reliability, ergonomics and low-maintenance. Their pre-feeders are present around the globe, from Australia to USA and from Brazil to every country in Europe. Most major groups and many sheet-converting producers are running Duecker pre-feeders, with commitment to “Do-as-we-promise” and “single contact person approach”.

They have recently introduced the latest addition to the machine portfolio: the PAF1600, a state-of-art high speed fully automatic palletiser, designed to run behind worlds fastest casemakers up to 28 bundles/minute.

The pre-feeders and palletisers are manufactured entirely in the Netherlands, using latest production methods following a modular design concept, enabling the company to maintain relatively short lead times. The machines are assembled from a set of basic parts, used in all machine types. This ensures keeping spare parts at customers’ facilities to a minimum, saving cost.

The portfolio includes two types of pre-feeder and the fully-automatic Palletiser PAF1600, including the game-changing ‘Magic Table’. Without exception the full range of machine-types is capable of running at highest possible speeds independent of board grade and flute-thickness.

DPF pre-feeders stand for a robust machine specifically designed to feed all known bottom-printing, up-folding converting machines, FFG, RDC and flatbeds.



DPF2100



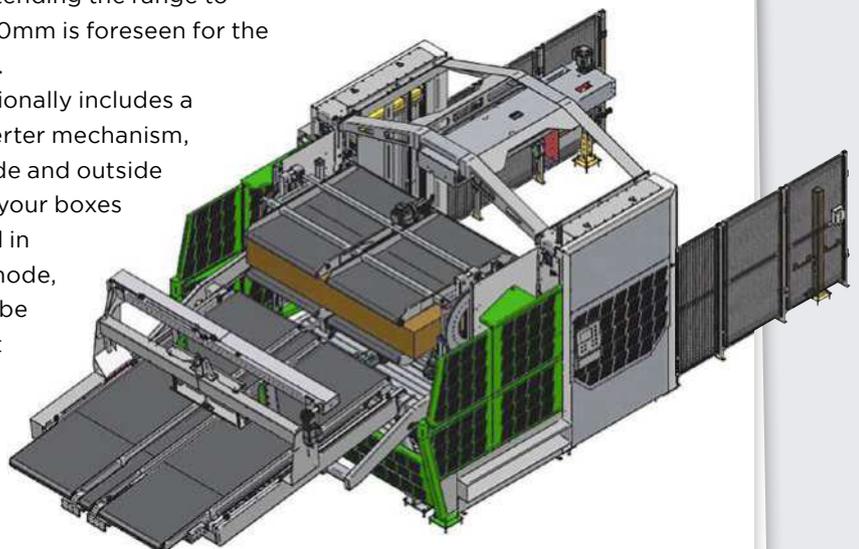
DPF2500

DPF range starts at DPF 1700x1100mm capabilities for the smaller range of flatbeds and narrow printers, to DPF 3200x2000mm for wide flexo folder gluers and rotary die-cutters. Extending the range to 3600x2000mm is foreseen for the near future.

DPF optionally includes a bundle inverter mechanism, should inside and outside printing of your boxes be required in dual pass mode, sheets can be fed without inverting in a first pass, then brought back to the

pre-feeder and fed while inverting during the second pass.

DPF pre-feeders are commissioned in conjunction with many brands of new as well as older converting machines.



DPF2800 & Inverter



SENSE & SIMPLICITY

Our prefeeders keep going when your operators stop

Our prefeeders feed all sheets in a continuous shingle, at high speeds, to all converting machines, top and bottom printing. *Side loading is available when space is limited.*



WATCH THE VIDEO
HERE OR SCAN THE
QR CODE BELOW



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The Netherlands
T. +31 653 71 01 83
E. erikm@duecker-prefeeder.com

 www.duecker-prefeeder.com

Imagine a casemaker, running at highest ever achieved speeds? Our Prefeeder are capable of keeping up with such speeds, no matter E-flute or BC flute. Short installation and commissioning times are key to keeping up with your production pace.

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to play
the video





DLF29

DLF pre-feeders are designed to supply sheets to top-printing, down-folding converting machines at highest possible speeds, top speed is reaching 30,000 sheets per hr while running doublewall sheets.

DLF range starts at DLF18 (1600x600mm) capabilities for narrow top-printers, to DLF29 (3000x1400mm) for wide top-printing folder gluers.

Both types of pre-feeders are flexible when it comes to integration in space saving circumstances, side loading of stacks is available for both DPF and DLF to achieve a minimum-length machine. Infeed conveyors of flat-top plastic belt type can be supplied to any length or width when required as a part of supply to the pre-feeders, controls will be integrated in the pre-feeder's controls in such cases.

Capabilities to exchange sheet and production data with all known converting machines are optional, as well as data exchange with the Dücker ASCOR WIP conveyor systems. ASCOR will be seamlessly integrated to signal the pre-feeders

that a running job is finished, resulting in a truly automatic setup procedure allowing the operators working at another part of the converting line.

DPF and DLF pre-feeder standard features include full width telescopic belts supporting maximum and minimum width sheets fully, continuous shingling functionality to guarantee optimum

sheet guidance into the converting machine, remote VPN modules for online support, a flat top belt waste conveyor enabling waste sheets to pile up without having operators removing waste sheet(s) following every stack change. Heavy duty main frames and solid metal machine parts to ensure reliable and lasting piece of equipment.

DP Palletisers

The latest in palletising in corrugated factories is here, emphasising the importance of optimising space and manpower in converting bays. With converting machines growing in length and space becoming a premium, the need for efficient solutions is evident.

The increasing scarcity and cost of manpower further highlight the necessity for innovative approaches. Investing in a fully-automatic palletiser emerges as a logical choice, offering significant benefits in space utilisation and labor efficiency.



Palletiser



Palletiser - Small Bundles

Smallest factory footprint layouts, that is what the company have designed the PAF series for. Energy consumption is kept to a minimum.

The latest developments in palletising technology address these challenges effectively. In close collaboration with cellulation GmbH, the company have redefined layer-composing and raised productivity to the next level.

Key features include: no stopping and starting of bundles as the layer is composed, full data communication to converting machines, ultra-fast order changes, one of the smallest footprints in the industry, little power consumption and safety arrangements not standing in operator's way.

Fast Commissioning Installations

Last but not least, pre-feeders installation and commissioning takes a maximum of three days, resulting in minor production stops. This is the result of testing thoroughly within Duecker's facilities before shipment commences. Palletiser installation and commissioning takes maximum five days. Furthermore, the pre-feeders and palletisers are not entirely disassembled, but 'folded together' without loosening cables and further machine parts, keeping the risk of wrong assembly at the final destination to a minimum.

Retrofits:

Several retrofits for pre-feeders and rotary die-cut stackers are available:

- PLC retrofits for existing pre-feeders include: Siemens S5 to S7-TIA and Siemens S7 to S7-TIA, as well as older generations of Dutch build Prefeeders running on GE-Fanuc to S7-TIA.
- Stacker upgrades for turning up-stackers into high speed down stackers. Typically useful in case an automatic palletiser is considered for which high quality bundles need to be produced at higher running speeds. These upgrades include a conversion to zero-interrupt bundle (or stack) changes, eliminating ink-smearing while running empty.
- Stacker retrofits behind printers, be it high or low board line types. Zero-interrupt comes as standard, typically useful when fast running printers are disconnected from slower flatbed die-cutters. It can produce bundles and stacks, on pallets or slipsheets. Peripheral equipment such as conveyors and pallet supply

systems are available to integrate complete systems.

Future Developments

Starting Q2 2025, a full range of semi-automatic loadformers will be available, complementary to the company's range of pre-feeders.

Ergonomics are subject to continuous improvements and will always be at the highest level possible, using state of the art hard and software capabilities.

"Our goal is to enhance reliability and operator friendliness when running a any converting machine, increasing productivity and lowering maintenance cost as part of our dedication to building our machines in a modular way," explains Erik Meulendijks, Sales Manager. "As the digital printers are becoming more popular, we are now developing a pre-feeder, again based on our proven DPF concept, to eliminate operators feeding sheets manually. In 2022, we commissioned a stacker running behind a digital printer, including all benefits such as data communications for automatic setups, zero-interrupted production and all features required to run sheets that are longer-than-wide."

www.duecker-prefeeder.com



Digital stacker



Production bottlenecks? Not anymore. The Importance of a 'Pull Approach' in logistics

In the corrugated industry, the evolution of production technologies has significantly increased the speed and efficiency of manufacturing lines. Modern machinery can output a vast quantity of product with incredible precision in no time. This progress also brings significant challenges to logistics management at the end of the lines. To address this issue, the way of thinking it is by adopting a pull approach. This strategy not only mitigates inefficiencies, but also improves operational performance and customer satisfaction.

Understanding the Push vs. Pull Paradigm

The push approach in logistics operates on forecasts and schedules, producing goods based on anticipated demand. While this method can maximise machine utilisation, it often results in overproduction, inventory buildup, and bottlenecks when

the downstream processes cannot keep pace.

In contrast, the pull approach is rooted in lean manufacturing principles. Production is initiated only when there is a clear demand from the next stage in the supply chain or the end customer. In the context of corrugated board companies, where production lines are becoming increasingly fast, precise and efficient, the pull approach ensures that output aligns closely with downstream capabilities, reducing waste and inefficiencies. By producing only what is needed when it is needed, companies can maintain a balanced flow, especially when production speeds increase.

The Challenges of High-Speed Lines

Modern corrugated board production lines are marvels of engineering, capable of producing thousands of square metres of board per hour. However, this high-speed capability

can overwhelm downstream processes. When production outpaces the downstream capacity, the result is often:

- **Under leverage:** the production lines are not expressing their real potential output;
- **Bottlenecks:** the downstream stages, become overwhelmed, causing delays and disruptions;
- **Quality risks:** rushed handling or prolonged storage may compromise the quality of the boards; down stream bottleneck will eventually affect the core such as the corrugator line and the WIP;
- **Increased costs:** waste of time, handling complexity, and waste disposal. The most evident result of these pattern brings less profitability.

Implementing a Pull Approach in Logistics

Transitioning to a pull approach requires a strategic overhaul of production and logistics processes. Here are key steps to facilitate the shift:

- **Demand forecasting and real-time data:** while the pull approach minimises reliance on forecasts, accurate demand forecasting is still essential for strategic planning. Implementing real-time data systems can provide visibility, for this reason the OPC/UA communication protocol has become the industrial standard for every high-end machine producers;
- **Flexible production scheduling:** invest in systems and processes that allow for quick adjustments to production schedules based on actual demand. Modular production setups and automation can enhance flexibility;

- **Invest for the future:** a successful pull system depends on the reliability and the expertise of machine manufactures who knows exactly how to manage these elements to achieve lean principles and fostering a culture of continuous improvement.

Fossaluzza's Solution

To further support the pull approach, Fossaluzza has introduced a new version of its double pallet inserter MBA. A groundbreaking pallet inserter, fully reengineered to address the most intense and productive environment, with a flexibility and customisation at its heart that has always characterise the fully independent Italian brand over for over half a century. This fully servo-controlled machine is equipped with brushless technology, onboard electric cabinets and air, delivers exceptional performance metrics:

- **Speed:** handles a maximum of 200 pallets per hour, ensuring seamless alignment with high-speed production lines;
- **Flexibility:** manage up to ten different pallet sizes storages and can store up to six pallets beneath each stack;
- **Connectivity:** features OPC/UA server data reception and transmission for real-time integration with plant systems, ensuring tracking and data management.



- **Durability:** designed for heavy-duty operation in 24/7, three-shift environments, guaranteeing reliability and smooth operations.
 - **Dimensions:** up to an incredible maximum stacks size of 5,000 x 2,800mm.
- By preventing bottlenecks and maintaining a continuous flow of materials, the double

pallet inserter enhances overall plant efficiency. This state-of-the-art machine embodies the principles of the family owned Fossaluzza's brand: performances, flexibility and durability. Ensuring that pallets management aligns with the actual demand and downstream logistics capacities.

www.fossaluzza.com



Innovative Designs, Durable Equipment

Geo. M. Martin Company has been a trusted industry name for nearly a century. Geo. Martin is known for innovative designs, durable equipment, commitment to outstanding customer support, and unsurpassed service. The company products range from globally popular rotary die-cut stackers and bundle separators, to specialty stackers, and a complete array of nicked bundle line components.

Today's high-speed rotary die-cutters have the ability to easily convert over 9MSM/hour. To maximise throughput they require reliable stackers and subsequent takeaway systems that can move finished product downstream at maximum velocity without creating bottlenecks or unexpected stoppages. Geo. Martin products are designed to maximise throughput and meet or exceed the takeaway requirements of the fastest rotary die cutter or flexo folder-gluer lines.

Productivity and Versatility

The rotary die-cut stackers remain the company's cornerstone products. From the classic Valu-Stack and Select RDC Stackers, to most modern state-of-the-art, high-performance LBX and SBX SCRUBBER® Stackers, Geo. Martin has a stacker model suited for any budget or stacking requirement.

LBX Scrubber Stacker offers the most feature robust solution and combines unmatched sheet control with superior scrap removal at maximum speeds to produce perfectly formed stacks and bundles with virtually no scrap.



LBX: SCRUBBER
Rotary Die Cutter Stacker

The LBX offer an automation solution for converters looking to maximise productivity, minimise set-up times, and optimise human resources.

SBX Scrubber Stacker offers superior sheet control with enhanced scrap removal. The SBX Series offers a high output material handling solution for converters who require high performance, exceptional scrap removal capabilities, perfectly square strap-ready stacks or bundles, but may not require the level of automation and extra high-speed performance provided by the LBX Series machines.

The patented layboy Scrubber Technology combines unmatched sheet control with superior scrap removal. The Scrubber layboy is the perfect solution for converters looking to maximise the throughput of their die-cutters, as well as those serving food packaging markets and customers with automated packing lines. Scrubber Technology can be applied to new, as well as existing Martin Stackers.



SBX: Scrubber Rotary Die Cutter Stacker

Innovation Leader

SmartShingle is the latest innovation and the AICC/Board Converting News "2024 Innovator of the Year" winner. SmartShingle minimises, and in many cases eliminates the feed interrupt time required to successfully perform the stack/bundle change cycle. Converting lines no longer need to sacrifice production during the discharge cycle. At near top die-cutter speed, converters lose 6-7 sheets during each stack or bundle change cycle. For full stacks that change once every minute or two, this can amount to 180-420 lost sheets per hour. When bundling with 2-3 bundle changes/min, this can add up to 1260 lost sheets/hour. SmartShingle saves valuable production time on any order. Large orders can see increases in productivity. Other advantages include increased print quality, as over-inking or under-inking issues are also eliminated, and reduced wear on anilox system components.

MAXIMIZE DIE CUTTER UTILIZATION

with HIGH-SPEED BREAKING

up to 92" maximum operating width



LEARN MORE

www.geomartin.com

- Separate bundles with straight, interleaved, and nested die-cut configurations
- Auto-Compensating Gapless Platen, eliminates upper edge roll and marking
- Quick setup with single point order entry
- Batch Mode improves speed and stability of narrow bundles
- Smooth excel-decel further enhances bundle stability

and a **FULL** range of bundle line components



Quik-Corner III (multidirectional roller ball)



Stop-n-Square



Twin Bundle Rotator



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- **SmartView™ BSS** – Board Surveillance System minimises operator fallibility. The system consists of four cameras set at strategic transition points, which record video of the board flow. When needed, the video can be replayed in slow motion to clearly display the cause of an event, such as a jam up. This allows the operator to accurately identify where adjustments may be needed and eliminates much of the guesswork, thus resulting in less downtime.
- **Automated Hopper and Pozi-Sync Tampers** – now available for new or existing Martin Stackers. The auto-set Front-End feature allows the backstop, crossbar, and side tampers to be automatically positioned.
- **Servo Rack and Servo Curtain Accumulator** – the updated systems have been re-engineered for increased reliability, smooth performance, and extended life span.
- **Geo. Martin Diverters (SQC and SQX)** ensure loads are virtually scrap defect free, in addition to enhancing safety and productivity of die cutter lines.
- **SQC system** automatically removes sheets from the stackers board line and diverts them to the operator side of the stacker for operator inspection. SQC can be integrated with the Length Quality Control (LQC) system for ‘on the fly’ operator side ejection of single or multiple short sheets or samples for safe and easy quality control inspection.
- **SQX Diverter** combines the features of SQC with additional scrap removal capabilities.

Placed behind an LBX Scrubber, SQX further enhances the Scrubber’s already superior scrap removal capabilities to deliver virtually scrap-free boxes (well under 1%) making it ideal for scrap critical operations such as auto packing lines. SQX and SQC can also be placed on new or existing Select® and/or ValuStak™ Stackers, allowing them to take advantage of these enhanced capabilities.

- The **LQC system** is excellent for quality conscience converters, especially those serving automatic packing lines. LQC scans the sheets and compares the length to a predetermined tolerance. When out of spec boxes are detected, the feed is interrupted allowing the operator to manually pull the bad sheets, or automatically eject sheets when used with the SQC or SQX systems.

For Nicked and Unnicked Bundles

Geo. Martin’s Quik-Break™III (QBIII) nicked bundle separator makes it possible for converters to maximise

the output of their rotary die-cutters, flexo folder-gluers, and flatbed die-cutters. QBIII’s dual airbag platens provide an even and positive gripping force to maintain the integrity, and stack quality of nicked bundles during the separation process. A gapless upper platen prevents edge rolling and marking on small width bundles, even when running uneven bundle heights side by side. The QBIII also features automatic platen offset for nested bundles and automatic bundle height sensing to minimise breaker platen travel for faster cycle times.

To maintain bundle integrity during transit, the QBIII features adjustable speeds and smooth acceleration/deceleration for tall bundle stability. ‘Batch Mode’ improves breaker cycle times on narrow items by indexing between separated bundles and discharging them as a group.

The QBIII is offered in a 68” (1727mm) model and an extra-wide 92” (2337mm) model. The 92” model can accommodate two 46” (1168mm) wide bundle logs side by side, making it the perfect high-performance machine for pizza boxes, wraps, and other



Quik-Break III nicked bundle separator with Quik-Park Flat Belt

wide format die cuts. It offers faster separation of wider sheets/bundles, lower bundle counts, and handling of thicker board calipers through its ability to break multiple side by side units.

The Ball Belt Transfer™ Conveyor (BBT) allows the formation of large 2-up bundles logs such as large pizza boxes or multiple rows of smaller logs up to 92" (2,337mm) when used with the 92" Quik-Break III. This versatile system allows bundles/stacks to move straight through, or feed in either the left or right direction. For complex dual bundle line systems, bundle logs can be fed in alternating directions for maximum throughput and productivity.

The BBT is available in fixed, 'Bundle Only' version or in a pitless scissor lift configuration that allows running of bundles or full stacks. The system features EzStart accel/ decel to maintain bundle/stack integrity during the transfer cycle. BBT operating parameters can be stored with the job recipe to reduce setup time on recurring jobs.

Geo. M. Martin Company offers a full range of automated nicked and unnicked bundle line components including multi-directional cornering devices, squaring devices, bundle rotators and inverters, flat and roller conveyor systems, shrink-wrap tunnels, load formers, and much more.

www.geomartin.com

Ball Belt Transfer (BBT) in scissor lift configuration



Best Fit Approach

"We won't sell you what we have – we'll sell you what you need."

Mike Irving, Managing Director



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Allrounder in Front of Converting Machines

After the market expressed their wishes and requirements to MINDA regarding machine peripherals more than 10 years ago, the last gap in converting machines was closed. Minda decided to launch a Prefeeder to the market that differed from the previous models as it primarily took the customer's circumstances into account.

After a longer preparation and conception phase, the pre-feeder ADVECTOR was launched, combining the required features such as short installation length, lateral infeed and a continuous rubberised chain on the telescopic table in full working width.

Initially, Minda did not want to launch this product to the whole market, but set up the prototype at one customer only. They succeeded with Kunert Wellpappenfabrik in Bad Neustadt. Minda convinced the group's technical manager of the idea and the concept. It was installed in front of a 3200 inline machine and was a success for both sides. A sheet feeder with lateral infeed and an output of up to 20,000 sheets per hour – the Advector 3200. Only a

few points had to be revised, and follow-up orders came.

Nowadays, Minda covers the entire range. The Advector is available in working widths of 1,700, 2,100, 2,400, 2,800, 3,200 and, since 2024, also in 3,600mm, with a choice of working depths of 1,300, 1,700 and 2,200 mm.

The success of the machine can also be read in figures: the 100th prefeeder was already produced and installed at a customer. Of course, development went on. Minda are currently in the third generation of development. This means that they have moved away from individual production. The Prefeeder are now produced in series in a continuous flow production.

Combining Flexibility and Standard

Minda sticks to its goal of customer-specific solutions along the way. Regardless of the machine manufacturer, the Advector now stands in front of a wide range of different processing machines. This valuable experience has resulted in a product with extensive features giving every processing line the best possible performance.

Each Advector stands out due to its wide range of configuration options and cost-optimised production. Lateral infeed from the left, from the right or straight ahead. Apart from the infeed direction, the operating side can be selected, too. The customer decides whether the stacks should enter without or with a pallet. The discharge of residual sheets or pallets is possible in different directions. Overall, Minda achieves a wide range of options and many configuration possibilities for the Advector. A wide rubberised plastic chain on the telescopic table and the adaptation to highboard lines are only small milestones compared to the Advector verto and Advector brevis.

The Advecto verto is supplied with a package turner between the lifting table and the shingling gate.



Rubberised wide plastic chain on the telescopic table



ADVECTOR verto with turning function in front of the infeed

Thus allowing corrugated board sheets to be turned before entering the processing machine. This option is particularly interesting for Top Printer machines and for inside and outside printing with double pass.

The Advector brevis is specially adapted to the conditions and functions of a flatbed die-cutter. Due to the already limited output of 7,500 sheets per hour, here the focus was placed on a compact

design and therefore a small space requirement. Perfect for any flatbed die-cutter and corresponding machines with the right output. A benefit for the customer: installation work and transportation to the construction site are reduced to a minimum.

The Prefeeder Advector achieves outputs of over 20,000 sheets per hr, depending on the sheet types, the incoming stack

height, quality and flatness. The peak output can be called up at maximum stack heights and for single flutes. Output values between 20,000 and 25,000 sheets per hr are achieved under optimum conditions.

Optimisation of Set-Up Times

Progressive development and market requirements between our customers and their end customers result in ever smaller but recurring batch sizes. Simply optimising performance to sheets per hr is only a partial solution, as set-up times are becoming a decisive factor with decreasing quantities. By extended interfaces and data exchange with various manufacturers of processing machines, we influence the reduction of set-up times. This optimisation can be rounded off by an automatic system for initial filling. Thus, manual feeding of first sheets in the infeed area of the processing machine is a thing of the past.

A flexible material infeed and the option of feeding stacks with or without pallets are advantages that have already been mentioned before. Furthermore, the Prefeeder is explicitly dependent on an electrical and pneumatic power supply. The absence of hydraulics results in lower maintenance costs.

A balanced energy concept is a milestone on the way to sustainability.

www.minda.com



ADVECTOR brevis specially adapted to flatbed die-cutters

Where Innovation Meets Safety!

Efficient material handling systems play a critical role for companies in the paper and corrugated industry, ensuring the safe transportation and storage of rolls and carts within their facilities. These systems not only protect materials during production and distribution but also offer substantial operational benefits, including increased productivity, improved warehouse performance, reduced labor costs, and enhanced workplace safety.

Prioritising health and safety is essential in the production environment to protect employees at all times. The manual handling of heavy loads, such as lifting, carrying, or pushing rolls, poses serious risks. As outlined in Technical Standards ISO 11228, Ergonomic Manual Handling Part 2, excessive physical effort required for tasks like pushing and pulling can lead to injuries. These standards highlight the recommended limits and guidelines for safe manual handling practices to prevent strain and accidents.

Even forklifts, commonly used for material transport, are not without risk and high-potential accidents can occur despite strict precautionary measures. Recognising these challenges, businesses increasingly turn to alternative material handling solutions that reduce the need for manual labour while improving safety and efficiency.

The Moviroll Roll Pusher

In 2014, Renova responded to industry demands and client

feedback by introducing a great solution: the Moviroll roll pusher. As one of the first roll pushers to feature lithium battery technology, the Moviroll redefined standards for safety, efficiency, and ease of use. Over the years, the Moviroll has evolved into a versatile range of models, available in both pneumatic and battery-powered versions, and supported by a variety of dedicated accessories.

Specifically designed to move heavy rolls of paper and corrugated materials with minimal effort, the Moviroll reduces operator fatigue, enhances workplace safety, and optimises operations. Its smooth and precise roll movement not only prevents injuries but also ensures safe, controlled handling, making it an indispensable tool for modern material handling needs.

Renova has established itself as a leading developer of cutting-edge solutions for material handling. With a deep understanding of the challenges faced by industries such as paper, corrugated, and tissue manufacturing, the company created its flagship product: the Moviroll roll pushers. These innovative machines are designed to efficiently, safely, and ergonomically handle heavy rolls, effortlessly moving loads of up to 20,000 kg and diameters as large as 4,500mm. Their ease of use and versatility

make them indispensable on production floors.

Versatile Features for Modern Operations

Moviroll roll pushers are engineered with advanced features to ensure smooth operation and efficiency. Built for durability, they are equipped with oversized wheels that effortlessly navigate obstacles like debris and gaps on plant floors. Their ergonomic design, featuring intuitive forward and reverse controls, provides operators with easy and reliable handling, even in challenging environments such as dusty or wet conditions.

Battery performance is maximised with a built-in LED indicator that alerts operators when recharging is needed, while an on/off button helps conserve power during idle periods.

Powered by high-performance lithium batteries, Moviroll pushers combine eco-friendliness with efficiency. These long-lasting batteries, capable of providing up to 50 working hours on a single charge, offer more than 500 charge cycles and a recharge time of less than four hours. This durability enables extended use across multiple shifts, making Moviroll a reliable, efficient, and cost-effective material handling solution that also supports environmentally sustainable operations.



Tailored Models for Specific Needs

To cater to the diverse demands of the paper and corrugated industries, Renova has refined the Moviroll range into two specialised models:

- The Moviroll MRE, is ideal for industries seeking flexibility and freedom of movement. Thanks to its 24V lithium battery, the MRE offers cordless operation, making it perfect for manoeuvring rolls in confined spaces or areas where pneumatic connections or electrical cables would be restrictive. Compact yet powerful, it ensures effortless handling of medium-to-large rolls.
- The MRE XS is the ultimate solution. Equipped with a 48V lithium battery, this model delivers the extra power required to handle larger and heavier rolls. It also features a flexible handle that can be adjusted to two heights (850 mm or 920 mm), ensuring ergonomic operation even during demanding tasks such as when the need of separating two rolls arises. The latest enhancements to the Moviroll MRE XS series, including an energy-saving auto switch-off display that extends battery life and an anti-rollback system



Moviroll MRE XS

that holds rolls securely for up to five seconds after releasing the accelerator, significantly boost safety, efficiency, and user convenience. These upgrades underscore Renova's commitment to delivering reliable, high-performance equipment that consistently exceeds operator expectations, solidifying its reputation as a global leader in material handling solutions.

Made in Italy

Renova's Moviroll pushers combine cutting-edge technology with sustainability and durability. Each unit is designed, manufactured, and assembled at Renova's headquarters in Italy, ensuring full control over quality and production. This vertical integration not only guarantees adherence to the highest standards, certified by TUV-ISO 9001, but also allows Renova to offer competitive pricing.

Built for long-term reliability, Moviroll pushers are maintenance-free, providing consistent performance throughout their lifespan. To further demonstrate its commitment to quality, Renova offers a comprehensive two-year warranty covering the machine, battery, and charger, underscoring the durability and dependability of its products.

www.renova-srl.com



Moviroll MRE XS



Strong paper bands are environmentally friendly and protect surfaces and edges

Extra-Strong Paper Bands Bundle Heavy Stacks Securely

Strapping stacks of corrugated board, cardboard or paper with wide bands and ultrasonic sealing technology from ATS offers proven advantages over strapping with conventional PP and PET bands. The wide bands – up to 30mm in width – protect the surfaces and edges of corrugated and folding cartons, displays and other products. This minimises waste and simplifies handling. This is a key competitive advantage that is especially important for high-value packaging (for example, highly finished packaging for cosmetics or high-value toys, food, or consumer electronics). And unlike thermal processes, ultrasonic sealing transfers energy directly to the material being sealed, rather than transferring it in the form of thermal energy. Banding machines with ultrasonic sealing technology are ready to use with no warm-up time, generate no heat, and significantly reduce energy consumption.

Strapping Corrugated and Cardboard Stacks

Now that film strapping has long been established and proven for strapping stacks of corrugated board and cardboard, the demand for paper strapping is growing rapidly. In addition to the well-known advantages that paper strapping offers over conventional strapping, as mentioned above, paper banding also offers other benefits. In particular, there are environmental benefits; paper is a sustainable resource made from renewable raw materials with closed and proven recycling

loops. According to the latest report from the European Paper Recycling Council (EPRC), 70.5% of the paper and cardboard consumed and collected in Europe was recycled in 2022. This means that paper already outperforms any other material in terms of recycling. By comparison, the recycling rate for plastics in Europe is currently around 30%, depending on the source of information.

ATS-Tanner has an extra strong banding paper in its range that is particularly suitable for the corrugated board. For applications where very tight and tear resistant strapping is required, two papers have proven to be particularly suitable; a 30mm wide and 120 gsm kraft paper with a TruePaper coating (PBS12030TP) and a kraft paper, also 30mm wide and 120 gsm thick, with a plastic coating (PBS12030PP). Both papers are



Fully automatic banding system US-2000 TRC-900 with jumbo dispenser from ATS

extremely tear resistant and in combination with ATS' ultrasonic sealing technology, provide an extremely strong seal and therefore high tensile strength. Bundling stacks weighing up to 15 kg is no problem with either paper. The paper with the TruePaper coating, exclusively available from ATS, can be assigned the recycling code PAP 22 and can be recycled in the normal paper cycle.

OEMs integrating ATS banding technology

Examples of machines available with ATS ultrasonic banding technology include



Standalone banding machine
US-2000 AST-MDM from ATS

BOBST's automatic packaging machine, SPEEDPACK, Bahmüller's POWERPACKER, and Mosca's UCB corrugated strapping machine.

They can all be ordered with optional integrated banding machines from ATS instead of conventional strapping machines. ATS-Tanner Banding Systems offers the US-2000 AST-MDM stand-alone banding machine and the US-2000 TRC-900 fully automatic banding machine with jumbo dispenser. Both machines have a 900 x 500mm arch and process 30mm wide paper or film bands.

www.ats-tanner.com

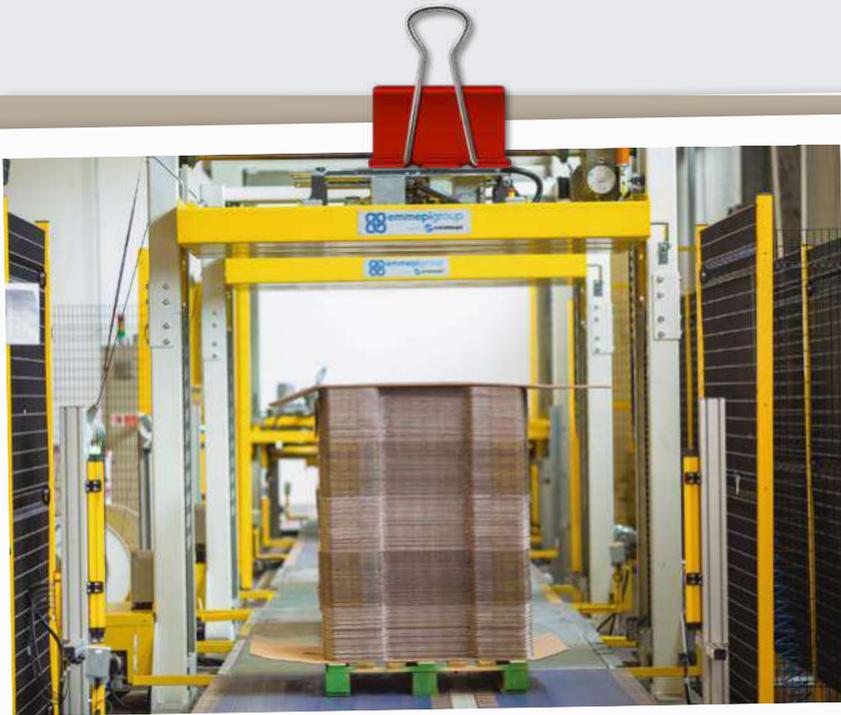


**Extra-strong, eco-friendly
paper bundling**



**Find out why paper banding is
better than conventional strapping**





roller conveyors, pre-feeders, palletisers, robots for folder-glueers and die-cutters, stackers with vacuum conveyors, pallet inserters, wrapping machines plus other ancillary equipment. This broad product range coupled with a proactive service offering, ensures a turnkey made-to-measure solution to service today's market demands.

Emmepi Group manufactures strapping machines exclusively for the corrugated industry. Consequently, each of the machines is tailored to a particular type of production within the sector. For instance, the strapping presses vary based on their intended use, whether for strapping die-cut blanks, conventional boxes or sheet board.

The robust strapping machines can accommodate all types of strapping (PET and PP), allowing customers the flexibility to select equipment based on a quality-price ratio. This flexibility is

Global Appeal for Strapping Solutions 'Made in Italy'

Emmepi Group is a global leader of integrated product flow systems to the corrugated industry, with

machinery ranging from handling, strapping, wrapping, peripherals to state-of-the-art robotics. Emmepi Group operates across nine European locations focussed on producing various automated handling systems including rotating



part of Emmepi's commitment to providing tailored solutions that enhance efficiency and productivity for customers.

In addition to their versatility, the strapping machines are designed with modern, user-friendly interfaces and advanced safety features, ensuring ease of operation and peace of mind. We continuously innovate our designs to incorporate the latest technology, aiming to reduce downtime and auto-diarise maintenance requirements, thus allowing converters to focus on their core activities without interruptions.

Emmepi's specialised approach ensures that each machine is finely tuned to meet the individual requirements of its intended use, providing optimal performance and efficiency. This level of customisation reflects the company's commitment to quality and innovation, as they continuously strive to meet the evolving needs of our customers. By focusing solely on corrugated board, the company maintain a depth of expertise that allows them to deliver solutions that are fit-for-purpose, reliable and cutting-edge.

The programming and setting of the operation parameters are controlled via a touchscreen display; this facility informs the operator about the machine's functioning, alerts them about any issues, and offers instant diagnostic information. Additionally, there is an optional feature for remote technical assistance.

All power control systems are constructed using solid-state components, enhancing the machine's already exceptional reliability. The strappers are available in various widths and



heights, allowing for better customisation to meet customer's exacting specifications.

Since the strapping division is integrated within Emmepi Group, the strapping machines can seamlessly connect using a plug and play system. The management system overseeing numbers of straps, types of pressing and the insertion of protection materials can be automatically controlled by the supervision system within the live production flow.

The company's team of engineers work diligently to incorporate the latest advancements in technology into the machines, ensuring they remain at the forefront of the industry. Whether it's enhancing speed, improving precision, or increasing durability, each machine is designed with the end user's needs in mind. This dedication to excellence in all that they do not only strengthens Emmepi's position in the marketplace but also reinforces their reputation as

a leader in the field of materials handling machinery within the corrugated industry.

Moreover, Emmepi Group is dedicated to offering exceptional customer support, providing training and troubleshooting services to ensure that customers can maximise the potential of their investments. Through this comprehensive approach, they aim to build long-lasting partnerships based on trust, reliability, and mutual success. They continue to invest in research and development to ensure that machines not only meet but exceed industry standards.

Emmepi Group has installed more than 3,000 strapping machines to date in the global corrugated market. Customerse mainly span Europe, Central and South America, as well as North Africa; they will be expanding our reach beyond these regions too over the months and years to come. www.emmepigroup.com

The Synergy of Strapping and Wrapping Technology

Corrugated packaging needs to perform better than ever before. Products must be transported safely without damage. At the same time, the focus is on sustainability and efficiency. Mosca offers an innovative solution that meets these requirements: the combination of strapping and wrapping technology. This synergy provides optimal protection for palletised corrugated-board products, reduces material consumption, and makes processes more efficient.

A combination of pallet packing press and ring wrapper provides optimal protection for palletised corrugated products. The requirements for corrugated packaging are as diverse as the products themselves. Mosca offers flexible solutions that can be adapted to the individual needs of each customer. Whether it is particularly large or heavy goods or products with irregular shapes, Mosca finds the right solution. The combination of strapping and stretch film enables customised packaging that provides optimal protection while also simplifying transport.

“With the acquisition of Movitec GmbH in 2021, we expanded our portfolio to include innovative ring wrapping systems,” explains Christian Schaefer, Sales Manager for Corrugated Board and Graphics, Mosca. “While many companies rely on either strapping or wrapping, the two technologies offer enormous potential when combined. This applies especially to securing sensitive corrugated board products.” Mosca recognised the potential: Mosca and Movitec



had already successfully installed several end-of-line systems in the paper industry that combined strapping and wrapping even before the acquisition.

Combining Strapping and Wrapping

The combination of these two technologies is particularly advantageous for products that require stable bundling on one hand and protection against environmental influences such as rain, splash water and dust on the other. “By combining strapping and wrapping, we achieve maximum protection and optimised sustainability,” explains Schaefer. The strapping system provides the necessary bundle stability, which means that less stretch film is needed. In many cases, a single layer of film is sufficient to reliably protect the product from external influences.

Robust Strapping Technology

In the corrugated industry, the combined system typically consists of a pallet packing press and a ring wrapper. These strapping machines are specially designed to meet the industry’s requirements and ensure efficient securing even at high production speeds. In a single step, the pallet packing press presses the products onto the pallet, creates a stable bundle and

straps it with a PET strap. Mosca’s pallet packing presses achieve forces of up to 33,000 N or 55,000 N and provide high compression to secure the products safely on the pallet. This enables more efficient transportation because more material fits in the same space.

The machines use Mosca’s SoniXs technology, an ultrasonic technology that consumes significantly less energy and generates no emissions compared to conventional heat-welding techniques. For sensitive products, additional edge protection can be inserted from above and below to prevent the straps from cutting into the material. This configuration can secure up to 185 pallets per hour or up to 220 pallets per hour without edge protection.

Efficient Stretch-Wrapping Solutions

The wrapping step is equally efficiently carried out by the system’s ring wrapper. The Movitec Saturn S6, a flexible ring stretch wrapper, pre-stretches and wraps the film around the products with the desired number of layers and tension. Depending on the product and the required number of layers, the Saturn S6 can wrap up to 120 pallets per hour. This system can be easily integrated into existing lines and enables quick preparation of pallets for shipping.

Reliably secured with **Mosca End-of-Line Solutions**

Whether strapping, banding or stretch wrapping; we get your products safely on their way to your customer's destination. We take care of bundling, transport securing and product protection to ensure your products arrive safely and in perfect condition.



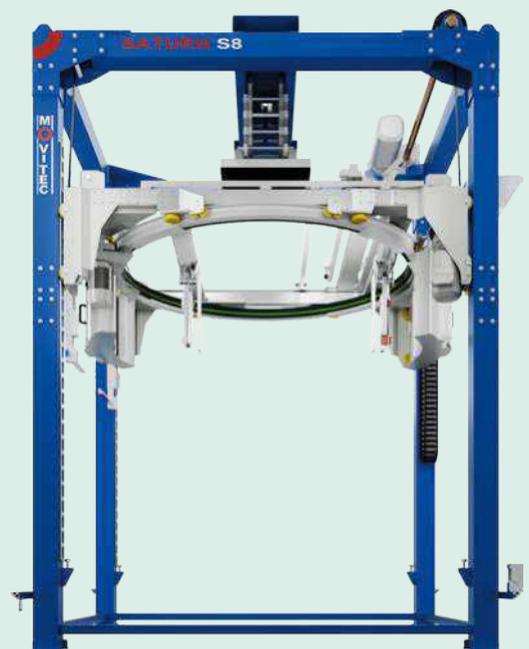
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Versatile Portfolio for Corrugated

Mosca offers pallet packing presses and a wide range of other strapping machines that are suitable for both palletised products and smaller bundles. The machines cover the need for high-performance solutions for large production lines as well as requirements for medium and small production environments.

An outstanding example of inline strapping technology is the

Mosca UATRI-2 XT. It is specially designed for large production lines for folding boxes and offers a high degree of automation. The UATRI-2 XT was the first Mosca inline machine to be equipped with the SoniXs technology, which enables energy-saving and emission-free sealing of the strapping. The fully automatic MCB-2 XT also uses inline technology, but with a traditional heat welding system.

For particularly complex and delicate folding boxes, such as 4

or 6-corner boxes, Mosca offers the SoniXs UCB. This machine can be equipped with a strapping unit and/or a banding unit to bundle products without damage. It takes only a few minutes to switch between strapping and banding.

Functionality for all needs

For smaller production lines or users with less demanding strapping requirements, Mosca offers a range of compact, automatic and fully automatic machines. The entry-level RO-M Fusion is suitable for smaller applications such as 4 and 6-point folding boxes or corrugated stacks and uses a heat-welding system to seal the strap. The SoniXs MP-6 T and SoniXs MC-6, on the other hand, are suitable for larger folding boxes and corrugated stacks and use Mosca's ultrasonic technology. Another fully automatic solution is the SoniXs TRC-6, which can be used behind rotary and flatbed die-cutters, as well as behind any flexo printing and gluing machine where cross-strapping is possible. The SoniXs TRC-6 with five-sided product alignment is particularly suitable for larger bundles of corrugated board products.

"Our goal is to precisely meet the needs of our customers in the corrugated board industry," concludes Schaefer. "That's why we offer tailor-made solutions for every production size and advise our customers on the best packaging options, materials and how to increase their sustainability. We are always looking for new technologies or innovative combinations of existing applications to offer even more efficient solutions."

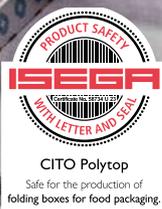
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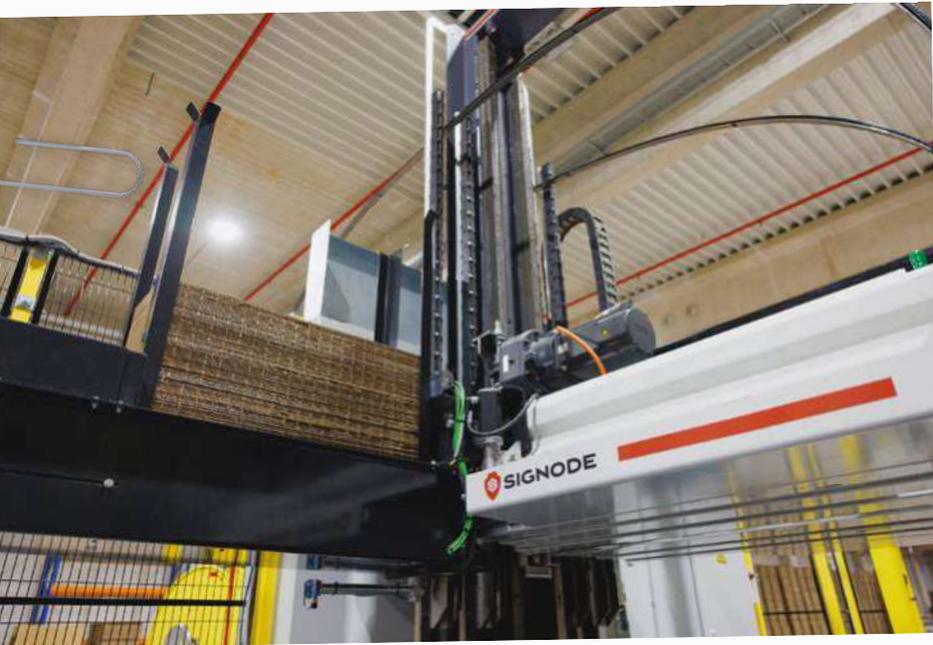
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lines moving efficiently while maintaining the secure strapping you rely on.

Consistent, Reliable Compression and Strapping

A key feature of the GCU-2600 is its upgraded compression system, which provides consistent pressure across every package. This provides secure strapping that holds up during transport and handling. Additionally, the machine is equipped with advanced tension controls, making it easy to adjust for different load sizes and materials.

For operations dealing with varied packaging requirements, this flexibility is a valuable asset, helping to maintain quality without constant adjustments or reconfigurations.

The Next Generation of Strapping Solutions

In the fast-paced world of corrugated packaging, staying ahead means using equipment that works smarter, faster, and better. That's exactly what Signode delivers with the GCU-2600, the next generation of their trusted GCU-NG compression strapping machine.

Building on Proven Reliability

The GCU-NG has been a mainstay in many packaging operations, delivering dependable performance across various applications. The GCU-2600 takes that solid foundation and adds meaningful upgrades, including improved compression, better control systems, and enhanced versatility. These updates make it easier to keep production

Designed to Make your Work Easier

The GCU-2600 introduces several thoughtful updates that enhance day-to-day operations:

- **User-Friendly control panel:** the HMI interface provides real-time data for setup and operation. Its self-diagnostic capabilities help quickly identify and resolve any issues, reducing downtime;

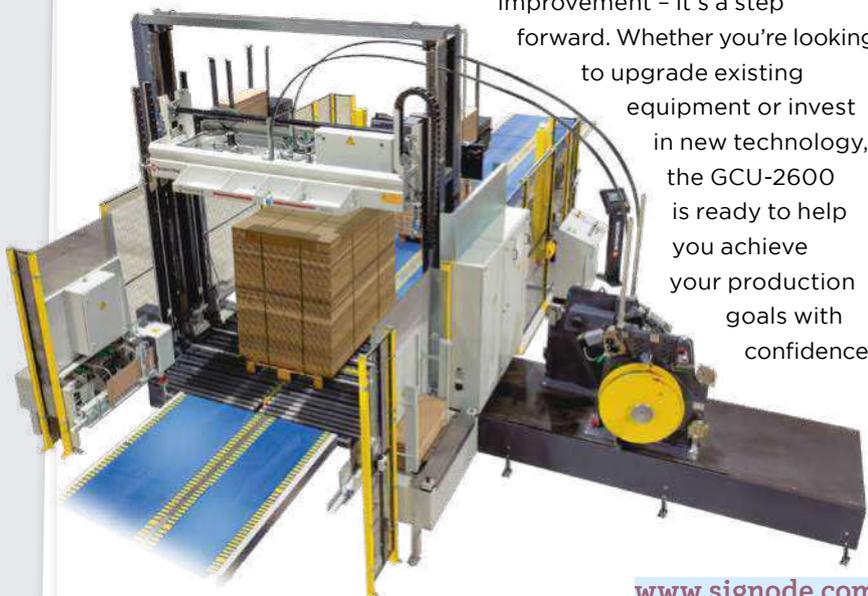


- **Automatic strap feeding:** reloading strapping is as simple as pressing a button, minimising interruptions and keeping operations running smoothly;
- **Durable sealing heads:** the MH modular sealing heads handle PET strapping with minimal wear and tear, increasing long-term reliability.

Flexibility to Adapt

One of the GCU-2600's standout features is its modular design. It supports up to four chute systems and two bayonets, allowing it to handle a wide range of packaging sizes and configurations. This flexibility allows it to meet both current and future needs without requiring significant adjustments or additional equipment.

For manufacturers managing diverse packaging requirements, the GCU-2600 provides the adaptability necessary to maintain efficiency across various product lines.



www.signode.com

Sustainability and Cost Savings

As sustainability becomes a priority across industries, the GCU-2600 is designed to align with these goals. Its energy-efficient design reduces power consumption, helping to lower both environmental impact and operating costs.

Additionally, the machine's precise strapping process minimises waste, enabling efficient use of materials and further contributing to cost savings.

A Smarter, Stronger Solution

For those familiar with the GCU-NG, the GCU-2600 offers practical upgrades that make everyday operations smoother and more efficient. For newcomers to Signode's machines, it provides a dependable and flexible solution that meets the demands of modern corrugated packaging.

With its focus on usability, reliability, and sustainability, the GCU-2600 isn't just an improvement – it's a step forward. Whether you're looking to upgrade existing equipment or invest in new technology, the GCU-2600 is ready to help you achieve your production goals with confidence.

INSPIRATION | INNOVATION | INFORMATION

THE PACKAGING PORTAL

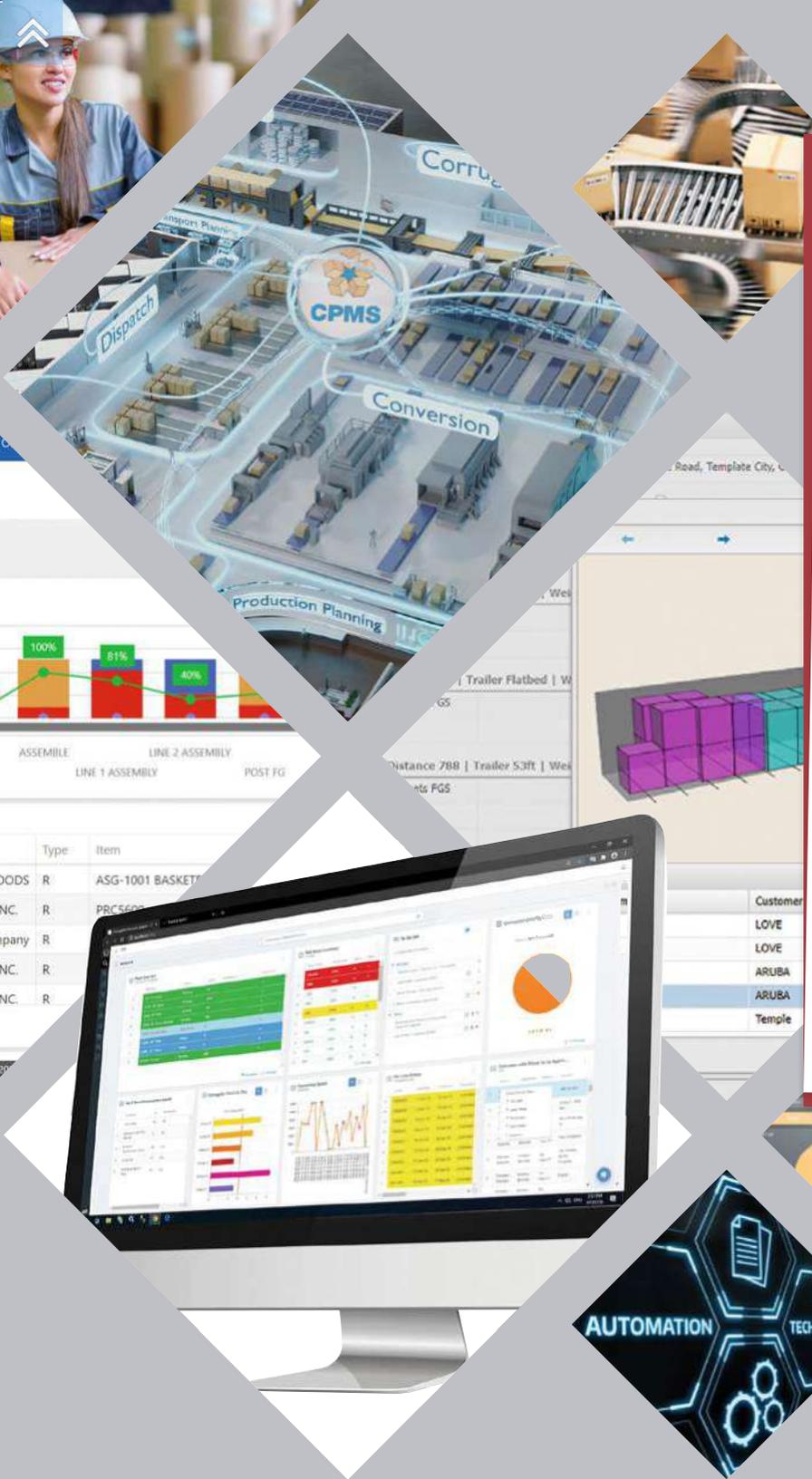
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THE BRUNTON REPORT



The modern corrugated box plant relies on intricate systems and software to ensure maximum efficiency, productivity and output. Industry-specific software systems allow you to plan the optimum scheduling of jobs and equipment, prior to production of corrugated board, scheduling into conversion and then into the finished goods department. Never has software had such a massive impact on running an efficient operation.

Computer systems will allow you to schedule, track progress, cost estimate and control your inventory. Thanks to the use of mobile apps and secure connectivity through a standard web browser, users of these systems can access information on plant performance and so much more, whether at the factory, in an office or from a remote location.

With a wide range of offerings from a multitude of vendors, the following pages cover systems available from some of the leading providers of computer systems that have been specifically designed for use in the corrugated packaging environment.

PLANT SCHEDULING

AN UPDATE REPORT

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Empowering Packaging Companies with Digital, Industry-Leading Capabilities

As a new administration settles into the White House, speculation on what the future holds runs the gamut. The next twelve months contain a plethora of economic mysteries that could take the US, and the corrugated industry, in any number of directions and require immediate attention. As new details continue to come out, questions of what things will look like in 2025 begin to take shape, including:

- Will prices go up due to new tariffs?
- Will supply chains be disrupted due growing global tensions?
- Will tax cuts help spur economic and business growth?

With the economic outlook so uncertain, it is more important than ever to future-proof your business so you can weather whatever the upcoming administrative and regulatory landscape brings. By implementing a fully integrated packaging MES and ERP solution, you can more efficiently run your operations, drive cost savings, increase productivity, improve on-time delivery, and boost customer satisfaction, all while laying the foundation for economic resilience.

Packaging Automation Made Easy

From sheet and box plants to display and specialty packaging manufacturers, Kiwiplan empowers packaging companies with digital, industry-leading capabilities that help:

- Maximise throughput with enhanced visibility and automated tracking and scheduling.

- Increase efficiency by integrating shipping and production planning.
- Save time and improve value by keeping your entire factory floor connected and up to date.
- Improve product quality, accuracy, and on-time deliveries with advanced automation.

Automatic 24/7 scheduling

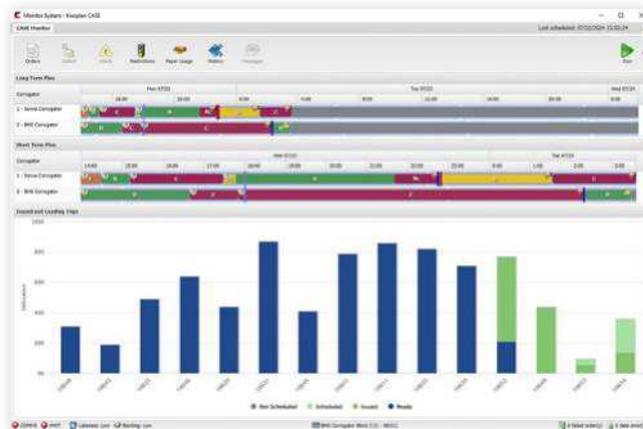
As one of the only solutions that offers automatic 24/7 scheduling, Kiwiplan helps minimise bottle and manual entry by automatically updating corrugator and truck schedules based on product changes or delays. Plans are automatically 15 minutes for jobs due in the next 90 days, continuously producing the most cost-effective schedules. Key modules include:

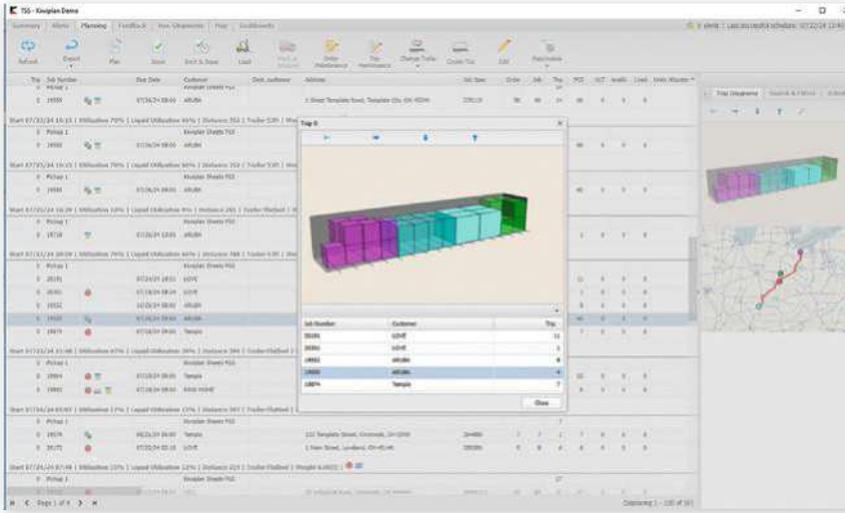
- **Continuous Automatic Scheduling (CASE):** with CASE solution, you can automatically react to changing circumstances in your plant with automatic corrugator scheduling. By automatically reacting to low WIP, predicted lateness, backlog levels, and more, CASE helps maximise throughput and produce up to a truckload more per day; increase web width



and wet-end run length; and reduce side trim, no no-stock downtime in converting, and labour requirements

- **Truck Scheduling (TSS):** keep your shipments optimised and on-time with our Truck Scheduling System. TSS automatically communicates shipping requirements to the production planning system (PCS), providing integration between your shipping and production plans that is real-time, automated, dynamic, and constantly adjusting. This module maximises truck utilisation, optimises truck routes, ensures trucks are loaded as planned, helps avoid over and under shipping, and reduces manual errors. Whether you ship 2 or more than 30 or more than 30 trucks a day, TSS automates and maximises the efficiency of your shipping process. Key Benefits: increase trailer utilisation and production by up to 20%.





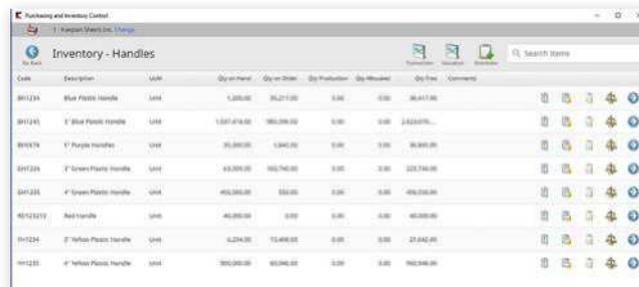
Optimise productivity and enterprise-wide visibility

As a fully integrated system, Kiwiplan allows you to manage multiple plants in a single system. Streamline and centralise key processes, including costing, estimating, customer service, and scheduling. Combined with automatic multiple plant routing, and enterprise-wide inventory and order management, Kiwiplan gives you an all-in-one view that will optimise your organisation. Key modules include:

■ **Enterprise Sales Processing (ESP):** deliver an improved customer experience and maximize operational efficiency with our fully integrated ERP solution Enterprise Sales Processing. Easily centralize and standardize everything from estimating, pricing, and order entry to inventory management, product design, and tracking product revision. Maximise visibility by managing multiple plants in a single system,

providing an all-in-one view into your entire organisation.

■ **Purchasing Inventory Control (PIC):** displays real-time inventory for any material in the manufacturing process, increasing visibility and streamlining processes across your organisation. With this module, you can digitally manage inventory from purchase through allocation; manage inventory across multiple plants and locations; maintain accurate inventory with stock take and inventory adjustment features; and improve accuracy with 3-way reconciliation for sheet purchases (ordered, BOL, received).



Drive improvements and product quality

With a full data warehouse at your fingertips, Kiwiplan provides

valuable insights with robust reporting capabilities. Make accurate and timely decisions for process improvements and optimise your reporting by consolidating data from multiple plants and third-party systems.

Combined with Machine Data Collection solution, one of the most accurate data collection tools on the market, you can drive operation efficiency with real-time data, including setup start and completion times, job finish time, setup waste, quantity produced, downtime details, and more.

Increase throughput and reduce waste

Kiwiplan offers fully automatic tracking capabilities that provide superior work-in-process and finished goods inventory management. From creation and storage through loading and shipping, our solutions can help minimize loading errors and increase billing accuracy. Key module is Unit Load Tracking (ULT). Manage and track WIP and FGS inventory more effectively while minimising loading errors and increasing billing accuracy. This module helps improve your

shipping process, reduce lost inventory, and eliminate manual data entry by automatically tracking the creation, movement, storage, loading, and shipping of WIP and FGS using bar-coded load tags, vehicle-mounted

unites and radio frequency scanning technology. Decrease WIP by up to 25% www.advantive.com

Innovation & Integration Powering the Packaging Industry

Since 1981, Amtech has consistently delivered innovative technology solutions for the corrugated and packaging industries. Amtech's fully integrated family of software helps packaging manufacturers achieve operational excellence and improved bottom-line results throughout their entire business.

Amtech is focused on the packaging manufacturer exclusively, driving value specific to the industry. With an entire suite that includes ERP with financial modules, scheduling, business intelligence, and MES functionality, Amtech helps corrugated manufacturers optimise their plant operations from the front office to the shipping dock. Amtech integrates the packaging value chain by ensuring both corrugators and converters can understand delivery times, allowing confident available-to-promise dates.

Amtech's focus on making both sheet plants and corrugator plants become more efficient is demonstrated in their scheduling products: Advanced Planning Board and Corrugator Solutions Scheduling.

For sheet plants, Amtech last year introduced its newest version of Advanced Planning Board, with AI-based scheduling algorithms and a brand-new user experience. For corrugators, Corrugating Solutions Scheduling remains the industry standard for trimming corrugators.

Advanced Planning Board Overview

Focusing on doing more with less. Amtech's Advanced Planning Board (APB) is an automated and integrated planning system designed to reduce manual work for schedulers. By utilising scheduling optimisation technology, planning departments can focus on exceptions rather than routine tasks.

The intelligent scheduling system functions as an automation tool for operations, similar to the machines on the plant floor. By handling repetitive scheduling tasks, it allows teams to focus on exceptions and enhance overall efficiency. This automation enables greater impact, allowing businesses to manage higher volumes with

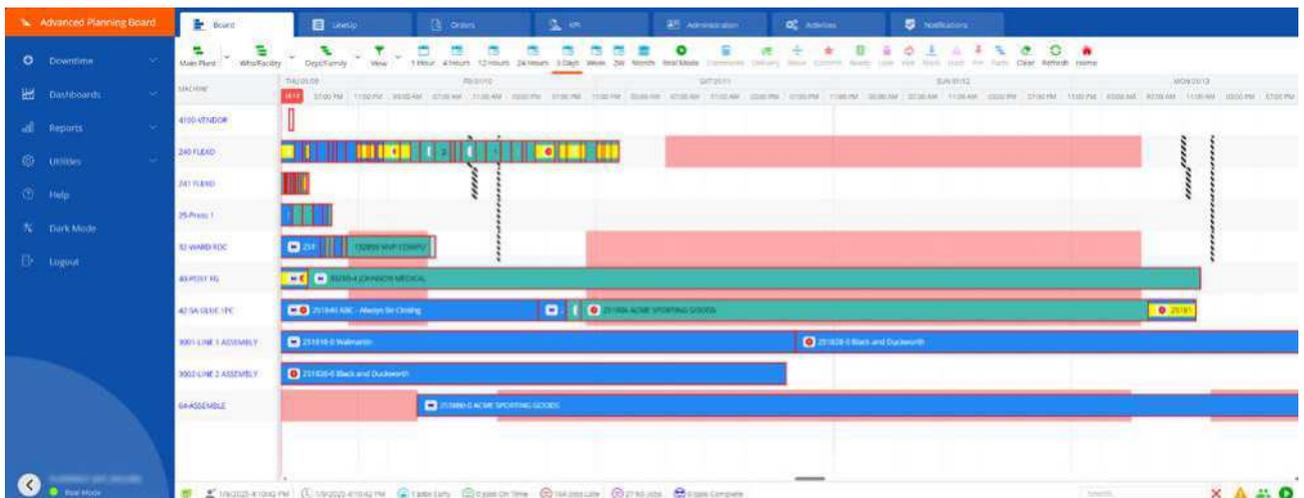
existing resources. The production process can be extended through real-time data integration with Amtech's Scorekeeper product.

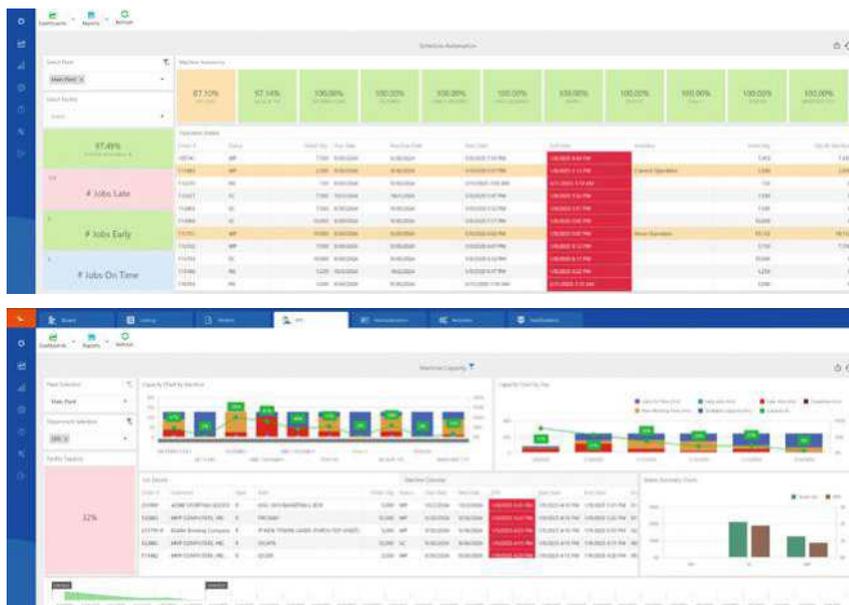
Supporting scheduling across multiple plants in a single instance, APB offers complete visibility and control over the entire production network. Whether operating from a single site or managing a global operation, the scheduling solution is scalable to meet diverse needs.

Visibility Enables Optimisation

The system also offers precise, Gantt Chart displays that visualise layers of linear operations, giving real-time insights into manufacturing activities. Key areas such as run sequences, processing times, and stock availability at each machine centre are displayed, allowing users to quickly assess how changes in the schedule will affect daily production.

Additionally, the system features an intuitive user interface that simplifies scheduling tasks. One-click drill-downs, global searches, and custom filters make it fast and easy to access relevant data and functions.





Easy to Understand Dashboards

Machine capacity charts provide real-time, graphical information about equipment backlog states and next available delivery dates. This enhances internal communication and helps set accurate customer expectations.

Embedded alerts track job statuses, while electronic flags can be added as ‘special messaging’ for orders, such as ‘press-ready’, ‘dies approved’ and ‘materials’. This improves cross-departmental communication and ensures jobs stay on track and on schedule.

To monitor key metrics and identify opportunities for improvement, the scheduling system includes interactive KPI dashboards. These help planning departments assess the performance of automation relative to machine capacity and identify areas where scheduling optimisations are needed to improve overall performance.

Trust the Automation

Leveraging machine learning, the intelligent scheduling system

continuously analyses historical data and product similarities to optimise scheduling efficiency. Multi-operation jobs are sequenced correctly across all machine centres, considering the full product structure. Inventory transfers between machines are scheduled just-in-time to reduce work-in-progress.

Comprehensive Integration Across Operations

The Corrugator Scheduling system seamlessly integrates with the Amtech family of solutions, creating a unified platform that connects all aspects of the production process. This integration ensures that real-time roll stock consumption data is available, provides visibility into customer due dates and order statuses, and establishes an interconnected workflow between converting equipment and corrugator operations.

Cost Optimisation and Efficiency Gains

By leveraging advanced scheduling algorithms, the system reduces costs and maximises the use of available

resources. It achieves lower-cost production runs, optimises the utilisation of converting equipment, and minimises waste through trim optimisation and efficient roll stock management.

Better Decision-Making

Unlike many traditional systems that rely on near-time data, Amtech’s solution uses real-time information to empower decision-makers. This feature helps create accurate and timely schedules, proactively identify and address bottlenecks, and reduce reliance on guesswork and manual interventions.

Customisable Algorithms

Every business has individual requirements, and the Corrugator Scheduling system’s adjustable algorithms cater to these needs. Users can develop tailored scheduling strategies that factor in costs, splits, and machine availability, apply weighted solutions for optimal outcomes, and simplify complex scheduling tasks with intuitive tools.

Enhanced Communication through Virtual Assistant

The built-in virtual assistant facilitates seamless communication and notifications, keeping everyone informed and aligned. Instant alerts notify users about new orders, order changes, or schedule conflicts, while messaging capabilities streamline communication between schedulers, customer service representatives, and the production team. Real-time notifications provide updates on roll stock limitations or combined trim pools.

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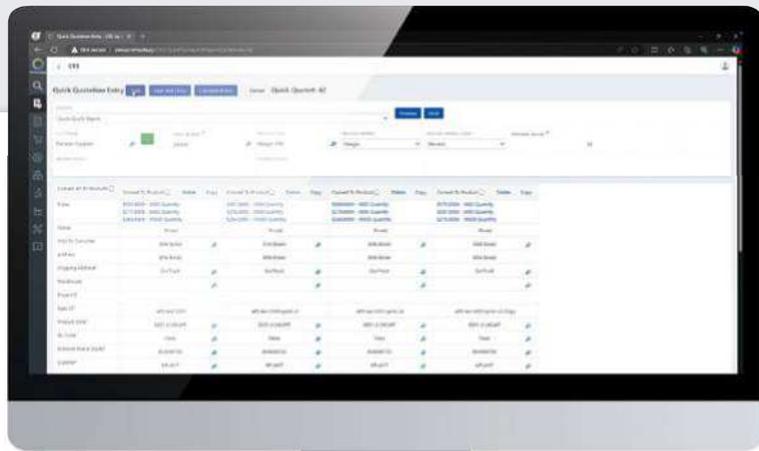
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Driving Efficiency and Innovation in Plant Management

In the fast-paced and evolving world of the corrugated industry, industry-specific solutions are no longer optional – they are essential. Addressing the needs of corrugated board manufacturers and converters, ePS Packaging, the packaging operating unit of eProductivity Software (ePS), continues to innovate tools designed to transform plant management. With over four decades of expertise, ePS' Corrugated Suite offers a comprehensive portfolio of solutions that optimise workflows, enhance decision-making, and deliver actionable insights from real-time data.

Industry-Specific ERP

At the heart of the suite is the Corrugated Business System (CBS), a robust ERP solution tailored specifically for corrugated. CBS enables precise cost modelling, allowing manufacturers to make informed product margins and profitability decisions. CBS provides the granular insights needed to thrive in a sector where operational efficiency directly impacts success.



CBS' QuickQuote feature – create quotes in minutes, not hours

One standout feature within CBS is Quick Quote, a tool that revolutionises how corrugated manufacturers respond to customer demands for fast and accurate quotations in minutes. By eliminating manual, time-intensive processes, Quick Quote empowers businesses to handle high-volume, standard product estimates with unmatched speed and efficiency, driving greater productivity and customer satisfaction.

Enhancing Productivity through MES

The integration of MES within the suite revolutionises plant management by automating production processes

and offering real-time visibility into plant floor operations. MES eliminates manual data entry errors, streamlines workflows, and ensures seamless communication between departments. With its ability to provide instant access to production data, MES empowers manufacturers to make proactive decisions, reduce downtime, and optimise resource utilisation.

Optimising Roll Stock Management

Paper is a significant cost factor, and managing it efficiently is critical. CorrTrac®, a roll stock inventory management module within the suite, tracks paper from order placement to consumption. This real-time tracking minimises waste, prevents over-ordering, and enables better inventory planning. Supported by the Roll Stock Analysis (RSA) service, manufacturers can achieve substantial cost savings, with some clients reporting reductions exceeding \$230,000 annually.



Corrugated Business System (CBS) ePS' industry-specific ERP





CorrTrac tracks paper from order placement to consumption, helping manufacturers achieve substantial cost savings.

Daniele Plazzi, Chief Innovation Officer, FEPA S.p.A. Italy, comments, “The ePS team’s work to help integrate into our SAP solution has transformed how we work. A Purchase Order is created and automatically sent to CorrTrac with all the required details included to guide production from the purchasing department.

“All inbound logistics are sent back via CorrTrac to SAP. All movement from the warehouse to the corrugator and vice versa is tracked. Rolls are scanned to identify supplier, amount, and location, and the roll’s movements are tracked and reported back to SAP via CorrTrac.

“We can see what stock is available versus what is in consumption. Butt rolls are calculated and returned to the warehouse; again, all data linking via CorrTrac to SAP. We can reflect consumption and stock availability in real time – our inventory has never been so easy to navigate, nor so lean,” concludes Plazzi.

Real-Time Data for Smarter Decisions

Access to real-time plant floor data has become a cornerstone of modern manufacturing. The suite leverages this data to provide actionable business intelligence,

helping manufacturers monitor production metrics, identify inefficiencies, and implement corrective actions swiftly. This data-driven approach ensures plants can meet JIT production demands while maintaining high-quality standards.

Flexible Scheduling and Lean Manufacturing

CorrPlan® and CorrTrim®, key scheduling modules, exemplify the flexibility required in today’s market. CorrPlan enables planners to develop cost-effective production schedules, balance inventory, and sequence orders to maximise efficiency. CorrTrim optimises corrugator scheduling, reducing trim waste and energy consumption. These tools allow manufacturers to adopt lean manufacturing practices and rapidly respond to shifting market dynamics.

A Commitment to Innovation and Sustainability

As the industry faces increasing demands from brand owners and pressures from the supply chain, ePS Packaging’s solutions provide a clear path to innovation and sustainability. By integrating advanced technology with operational expertise, ePS equips manufacturers with tools that enhance productivity and

reduce environmental impact. The adaptability of the Corrugated Suite ensures seamless integration into existing ERP systems or full-scale deployment for a comprehensive transformation.

Paul Cooper, Director, ePS Packaging, explains, “Our solutions empower plants to decide which orders to run, when, and how – essential tools for achieving lean manufacturing. By combining automation with data and actionable insights, manufacturers gain plant-wide visibility to adapt and respond efficiently.

“Automation and Industry 5.0 are not just trends; they represent the future of manufacturing. Investing in these technologies enables our customers to ‘do more with less,’ optimising resources, reducing waste, and driving profitability. The transformation unfolding across the EMEA region is inspiring, as manufacturers embrace innovation to meet evolving demands.

“At ePS Packaging, we are committed to supporting this journey by providing solutions that not only enhance operational control but also elevate the EMEA region as a global leader in corrugated manufacturing, fostering sustainability and operational excellence.”

He concludes, “As the corrugated industry evolves, ePS Packaging remains a trusted partner, delivering solutions that address today’s challenges and anticipate tomorrow’s needs. By combining real-time insights, robust roll stock management, and flexible scheduling tools, ePS Packaging ensures that corrugated manufacturers can thrive in a competitive, dynamic, and sustainable market.”

www.epssw.com



Eduardo Andrade, Managing Director

Revolutionising Plant Management with a Comprehensive Packaging Solution

For over three decades, SPOCS, developed by KMSS, has been a trusted ally for sheet plants. Known for its robust functionality and user-friendly design, SPOCS has helped many packaging companies streamline their operations and drive efficiency. But in today's dynamic packaging industry, where businesses demand ever more from their systems, SPOCS is stepping up its game.

By investing heavily in innovation, KMSS is transforming SPOCS into a complete solution, capable of supporting not just traditional operations but the diverse needs of modern packaging businesses.

Breaking New Ground: Corrugator Scheduling

One of the most significant recent developments in SPOCS is the addition of corrugator scheduling. This new feature enables businesses to manage the entire production process – from corrugation to conversion – seamlessly within one system.

The Corrugator scheduling module simplifies the complex task of planning production runs, optimising machine utilisation, and

reducing waste. By integrating this functionality, SPOCS now caters to plants producing a wide variety of corrugated products, eliminating the need for multiple scheduling tools and ensuring the smooth flow of operations.

Embracing the Full Spectrum of Packaging

While corrugated boxes remain at the core of many packaging businesses, many sheet plants also offer a diverse range of products like timber pallets and crates. However, managing these products often requires separate systems or manual processes, leading to duplication of effort, inefficiencies, and the risk of errors.

Recognising this gap, the KMSS team is hard at work to bring everything packaging into one system. The vision is clear: a single solution that fits all the needs of a packaging business.

By integrating the management of timber products and other packaging solutions into SPOCS, KMSS is paving the way for true operational

unification. Businesses can now manage their entire portfolio – regardless of material or product type – within a single platform, saving time, reducing complexity, and enhancing overall productivity.

This integration not only reduces overheads but also improves customer service. Sales teams gain instant visibility into product availability and lead times, while production teams benefit from streamlined workflows that minimise delays. Such cohesion is critical for businesses aiming to maintain a competitive edge in a fast-paced industry.

Global Reach to India, Middle East and Australia

KMSS's commitment to innovation is matched by its ambition to



grow globally. They grow without losing the personal touch which is the company's signature. The UK remains its main market, with a growing customer base well supported by local support, development and management teams. With the increasing adoption of SPOCS, KMSS is expanding its operations to India, Middle East and Australia. These regions represent thriving markets with demands for integrated packaging solutions.

The expansion brings KMSS closer to its customers, allowing for localised support and the ability to tailor SPOCS to meet regional requirements. By establishing a presence in these markets, KMSS is well-positioned to serve a broader customer base, fostering stronger partnerships and contributing to the growth of packaging businesses worldwide.

Efficiency Through Innovation

At its core, the evolution of SPOCS is about addressing the real-world challenges faced by packaging businesses. Key benefits of this all-encompassing approach include:

- **Eliminating duplication of work:** with all products managed within one system, businesses no longer need to replicate tasks or maintain separate records;
- **Improved visibility:** a centralised system provides a bird's-eye view of operations, enabling better decision-making and more accurate forecasting;
- **Streamlined workflows:** automated processes ensure that tasks flow seamlessly across departments and product lines, from order intake to delivery;
- **Cost savings:** efficiency gains translate directly into financial benefits, from reduced labour costs to minimised waste.

A Collaborative Approach to Innovation

KMSS's approach to software development is highly collaborative, involving extensive feedback from its customers. KMSS has the flexibility to adapt quickly to changing needs and maintain closer contact with its customers. This ensures that new functionalities not only meet current needs but anticipate future challenges.

Being independent also allows KMSS to tailor its solutions to the requirements of each customer, whether that means adding custom features, integrating with existing systems, or providing

dedicated support. This personalised approach is one of the key reasons why SPOCS remains a trusted solution for packaging businesses.

The decision to expand SPOCS into a more comprehensive solution came after engaging with customers who expressed frustrations about using separate applications at group level or to manage different production areas. This proactive engagement with the industry is a hallmark of KMSS's commitment to its clients' success.

In a world where efficiency and adaptability are key to success, SPOCS is setting a new standard for plant management in the packaging industry. With its recent innovations, SPOCS is now more than just an ERP system; it's a comprehensive solution that empowers businesses to thrive in an ever-changing market.

As KMSS continues to invest in SPOCS's development, the message to packaging companies is clear: whatever your needs, SPOCS is ready to deliver.

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Helping Companies Embrace Market Dynamics

OMP applies advanced techniques and data science to help packaging companies embrace market dynamics by planning their supply chains more proactively.

The corrugated packaging industry is currently witnessing rapid change. Demand is increasingly volatile and often seems quite unpredictable. Lot sizes are getting smaller, and mass customisation is a continuing trend. Sustainability is receiving more attention from the public at large and consequently also from packaging customers.

With its expertise in supply chain planning optimisation and extensive experience in a whole range of sectors including the packaging industry, OMP offers many possibilities for the super-agile packaging company of the future to manage all this. Here are just some of the approaches to increase value for customers.

Planning for Success by Planning Ahead

Packaging manufacturers have to continually evolve their products and services to meet its end users' needs. As a provider of long-term solution to the industry, OMP is

constantly broadening its offering to help customers deliver orders to perfection. The company offer solutions for customers to be proactive both in the short-term and the longer-term, producing more stable planning for the manufacturing process, with better efficiency, less waste, and happy end-users.

Corrugator trimming and conversion scheduling are no longer enough of a differentiator in today's market. To stay competitive, packaging manufacturers must extend their planning horizons to weeks and months rather than the typical norm of just hours and days. Sales and operations planning (S&OP) is becoming even more important as a result of industry consolidation, with bigger companies often operating multiple sites within the same geographical region.

Industry First

OMP's forecasting and S&OP solution for packaging manufacturers allows customers to have full control of their longer-term planning. The commercial objectives can be balanced with operational capabilities and capacity. An optimal S&OP

solution should also move the business forward to target every opportunity to generate healthy margins, all while respecting customer service level agreements.

Packaging manufacturers operating multiple sites face tough decisions about which plant should run which lines of business. With the shift to online shopping, the demand for boxes has been increasing at a time when the demand for new machinery is not being met. As a result, companies need to find ways to get more throughput from existing equipment. By implementing S&OP, they decide with confidence what is manufactured by each facility, leading to greater throughput and profitability. OMP like to call it value-based planning.

Box makers face a challenge when contemplating an S&OP implementation. They typically manufacture thousands of different products for countless customers where planning on a longer-term horizon using individual SKUs is just not practical. OMP's S&OP solves this problem with a business-ready solution.

The S&OP exercise includes decisions such as sourcing, capacity and resource allocation, inventory management, and demand shaping, and involves the areas of supply, manufacturing, and distribution. Such a wide variety of use cases requires a solution that facilitates easy evaluation and the ability to compare wildly diverse situations. OMP helps companies achieve this through scenario management adjusted precisely to the organisation, with comparison by volume as well as financials.

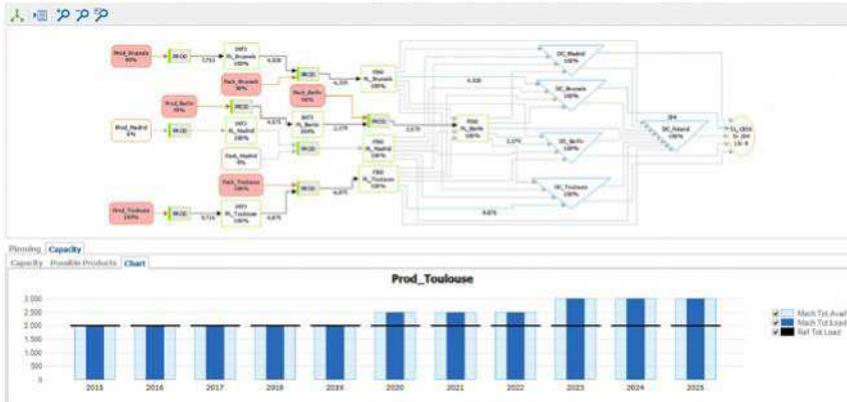


Figure 1: Digital twin visualising the full end-to-end supply chain

		Base		Scenarios					
		1. Base		0. Previous Month		2. Sourcing		3. Capacity	
		Value	Diff	Value	Diff	Value	Diff	Value	Diff
I. Revenue	Revenues	81,962,220	0	79,209,973	-2,752,246	85,632,444	3,670,225	85,632,444	3,670,225
II. COGS	Total COGS	70,019,884	0	69,469,161	-550,723	73,319,382	3,299,498	72,849,917	2,830,034
	Inventory Cost	-4,810,320	0	-4,968,555	158,235	-4,810,320	0	-4,810,320	0
	Production Cost	41,828,404	0	41,288,105	-540,299	44,083,447	2,255,044	43,704,631	1,876,227
	Supply Cost	14,321,259	0	14,321,259	0	14,929,141	607,882	14,905,553	584,294
	Transport Cost	9,059,901	0	8,891,242	-168,659	9,496,473	436,572	9,429,414	369,513
III. Gross Profit	Gross Profit	11,942,336	0	9,740,813	-2,201,524	12,313,063	370,727	12,782,527	840,191
IV. Fixed Cost	Investment Cost	0	0	0	0	0	0	458,000	-458,000
V. EBIT	EBIT	11,942,336	0	9,740,813	-2,201,524	12,313,063	370,727	12,324,527	382,191
VI. Taxation	Taxation	1,194,234	0	974,081	-220,152	1,231,306	37,073	1,232,453	38,219
VII. Net Profit	Net Profit After Tax	10,748,103	0	8,766,731	-1,981,371	11,081,757	333,654	11,092,074	-343,972
VIII. Extra's	Inv. Adherence %	100	0	104	-4	100	0	100	0
	Machine Bottlenecks	14	0	15	1	14	0	0	-14
	Tot. Lost Sales Vol.	38,947	0	69,468	30,521	0	-38,947	0	-38,947

Figure 2: What-if scenario comparison

Smart Solvers to Increase Profitability

Much more can be done to improve supply chain planning performance using science. OMP also has a vast range of smart mathematical solvers allowing companies to optimise their production processes in myriad ways.

A prime example is the corrugator optimiser, designed to increase machine utilisation,

improve throughput, and reduce trim waste. OMP's intelligent application of science enables its customers to minimise overall costs at the same time meeting service level commitments.

Increase Supply Chain Performance

In recent years, OMP has used this advanced solver to conduct

studies around corrugator investment and paper width optimisation. To accommodate market changes and continuously seek profitable improvements, many customers have asked OMP to help them align the paper width mix with actual order demand, paper supply, and corrugator capabilities.

Larger groups have harmonised their paper widths across the supply network, resulting in lower stock levels and higher material yield at the mills with limited impact on box plants. Other packaging sites have invested in corrugator improvements as a best fit for their anticipated growth, while others managed to considerably reduce trim and paper costs by re-adjusting their portfolio of paper widths.

All of these successes were achieved using OMP CorLab, which can facilitate studies assessing the strategic impact of changes in such parameters as corrugators, paper widths, and new markets. Sophisticated built-in data analysis, automatic simulation management, and advanced scenario comparison reporting make it easy to conduct high-level assessments of decisions made to improve strategic supply chain performance.

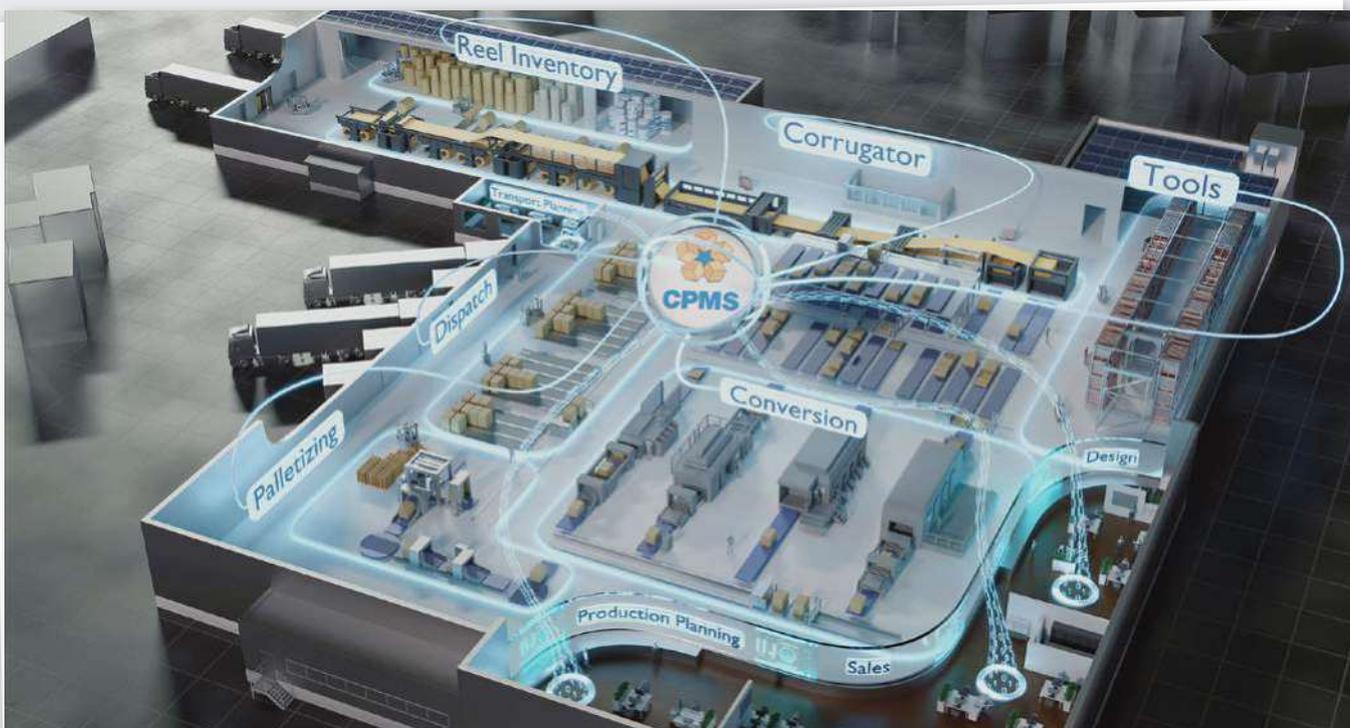
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Future-Oriented Platform

WITRON, headquartered in Bavaria, Germany, has restructured its software offering for packaging companies with the delivery of CPMS Version 7 (Corrugated Packaging Management System).

Witron CPMS is a business unit within WITRON Logistik + Informatik GmbH dedicated to the packaging business. The scope of delivery of this enhanced suite of applications will be presented along with the latest enhancements at the upcoming FEFCO Technical Seminar in Rome later this year.

CPMS is more than just a business software solution. It enables the operation of a digital factory, as shown in the graphic layout, by providing a comprehensive Digital Access Layer (DAL) with options for connecting third party applications, shop floor conveyors and machines through various technologies.

The CPMS DAL supports web service technologies, broadcast and network protocols, and direct communication with machine PLCs, among others, using open standards established in Industry 4.0.

As a result, CPMS enables the full integration of information and material flows throughout the supply chain. This includes the use of automated guided vehicles and robots on the shop floor.

The special architecture of CPMS DAL allows customers to continuously upgrade CPMS through enhancement packages without affecting the integration software.

The core package modules of CPMS Integrated – Sales, Manufacturing and Logistics – are enhanced by add-on modules that also use the DAL for communication. The main add-on modules of CPMS are the Mobile App, the Forecaster+Optimizer, the EDI Messenger and the embedded Development Workbench. The

workbench allows customisation of the business application to a certain extent using standard SQL language. CPMS digitally maps the entire value chain of a packaging plant with a consistent data model.

As an industry-specific information system, CPMS is used for a wide range of packaging operations, from traditional transport packaging to multi-part point-of-sale displays, and supports all types of printing technologies from pre-print to post-print in flexo and digital mode.

Companies with multiple production sites benefit from the CPMS Multiplant option, which enables centralised capacity control with harmonised reference data.

As a result, CPMS is a future-oriented platform for the packaging industry, exchanging comprehensive process data with machines and partners in the supply chain for overall optimisation.

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Printer Slotters

- 10000 Midas MD Mini Printer Slotter.
Year: 2021, size 1800x600,
lead edge feeder, one print unit,
quick set slot and crease with
motorised adjustment, sheet stacker
- 8797 PIEMONTE 2700 x 1300mm,
prime feed, three flexo, slot, diecut
- 9962 TCY 6PA Printer Slotter, 2750 x
1200mm, Sun lead edge feeder,
two top prints with ceramic rolls,
twin slot and crease unit with
preset system, rotary diecut unit,
vibrator strapper and sheet stacker
- 9400 KIRBY MPS 2800 x 1300mm,
Sun lead edge feeder, two print
units, motorised slot
- 9106 TCY 6PS 3000 x 1200mm,
lead edge feeder, two print units,
preset slotter, diecut unit
- 9161 Piemonte 3300 x 1300mm,
Sun lead edge feeder, two flexo
print units, motorised slotter
- 9986 TECASSA 3600 x 1600, lead edge
feeder, two colour, vac. Transfer,
slot, diecut, beater stacker

Gluing / Stitching

- NM100 **NEW** MIDAS MD Arm sticther, 1800mm
- 9972 Planet 2000x1000 Auto Folder
Gluer - Quma Glue system

- 9345 Kirby Fully Automatic Folder Gluer,
2050x1050mm, Quma glue system
- NM101 **NEW** MIDAS MD semi auto gluer,
2300mm
- 8785 EMBA UVZ/RTZ, 2940 x 1250mm,
full width squaring, c/ejector,
electronic glue
- 9340 Kirby Semi Auto Gluer, 3000mm,
rebuilt 2019
- 10008 SODEME Oscil Two Piece Stitcher/
Gluer. Size 5600mm (2800x2),
rising feed table, top and bottom
stitching heads, Nordsen hot melt
glue system, take off conveyor

Slitting/Slotting/Creasing

- 9954 Klett Beam slotter,
500mm slot depth, open ended
- 10004 Kirby Beam Slotter.
610mm, long Slot
- NM103 **NEW** Midas MD Slitter Creaser,
2600mm

Diecutting

- 10005 Bobst SPO 1600. Features:
prefeeder, two print units, transfer
section, 1600 diecutter, breaker

- 9999 Century CT Plus, fully auto diecutter,
size 1650 x 1200mm, lead edge
feeder, 450 Ton diecut station,
corrugated 0.8-8.5mm, speed 5500
per hr, 100% stripping with centreline,
batch ejector, machine was built in
2016 and has been well maintained

Digital Printing

- 9399 Wonderjet Digital Printer,
2400mm width, 24 head, built 2016,
speed 0.9m/s, sheet stacker,
automatic feeder, water based
ink, maximum image size 600 x
2400mm, maximum material
size 1800 x 2400mm, print
resolution 180 DPI or above,
material thickness 1.5mm to 35mm
- 9987 WONDERJET Plus Model
Single pass with UV dryer,
coater and stacker

Short Run Boxmaking

- 9998 GOPPERT SRE Boxmaker,
2500mm, heavy duty. Slit, slot,
crease, cross chop. New automatic
feeder available
- 9750 Rapidex 2500 x 9000mm, Maxibox.
Built 1990 and rebuilt 2018.
Hand fed with extended roller
support, inline slit knives, 600mm
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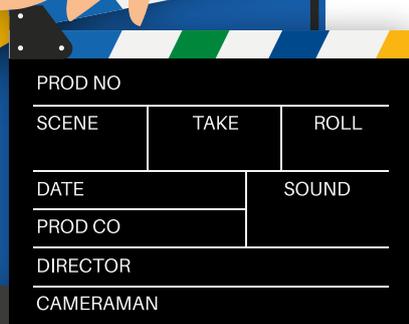
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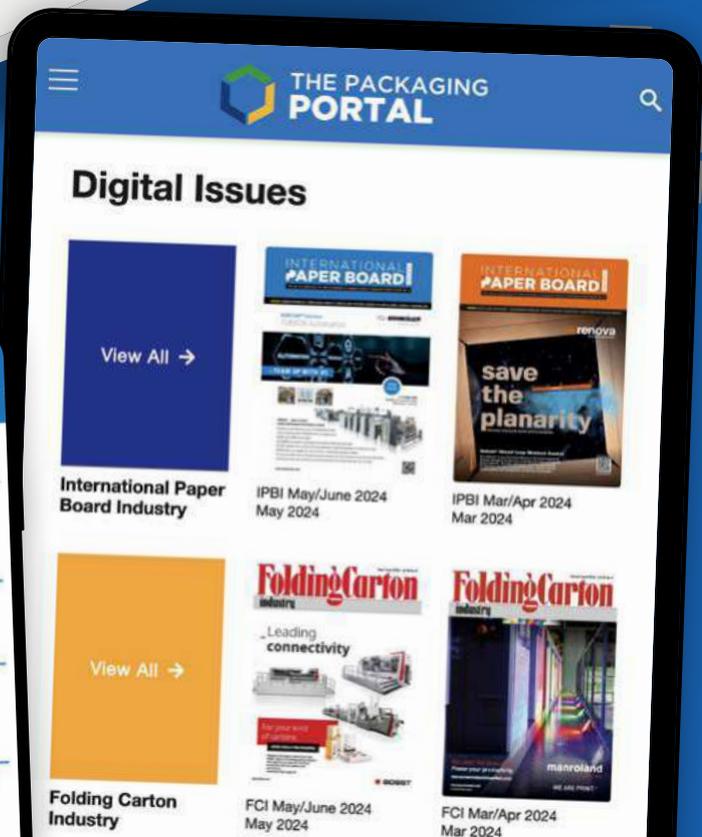
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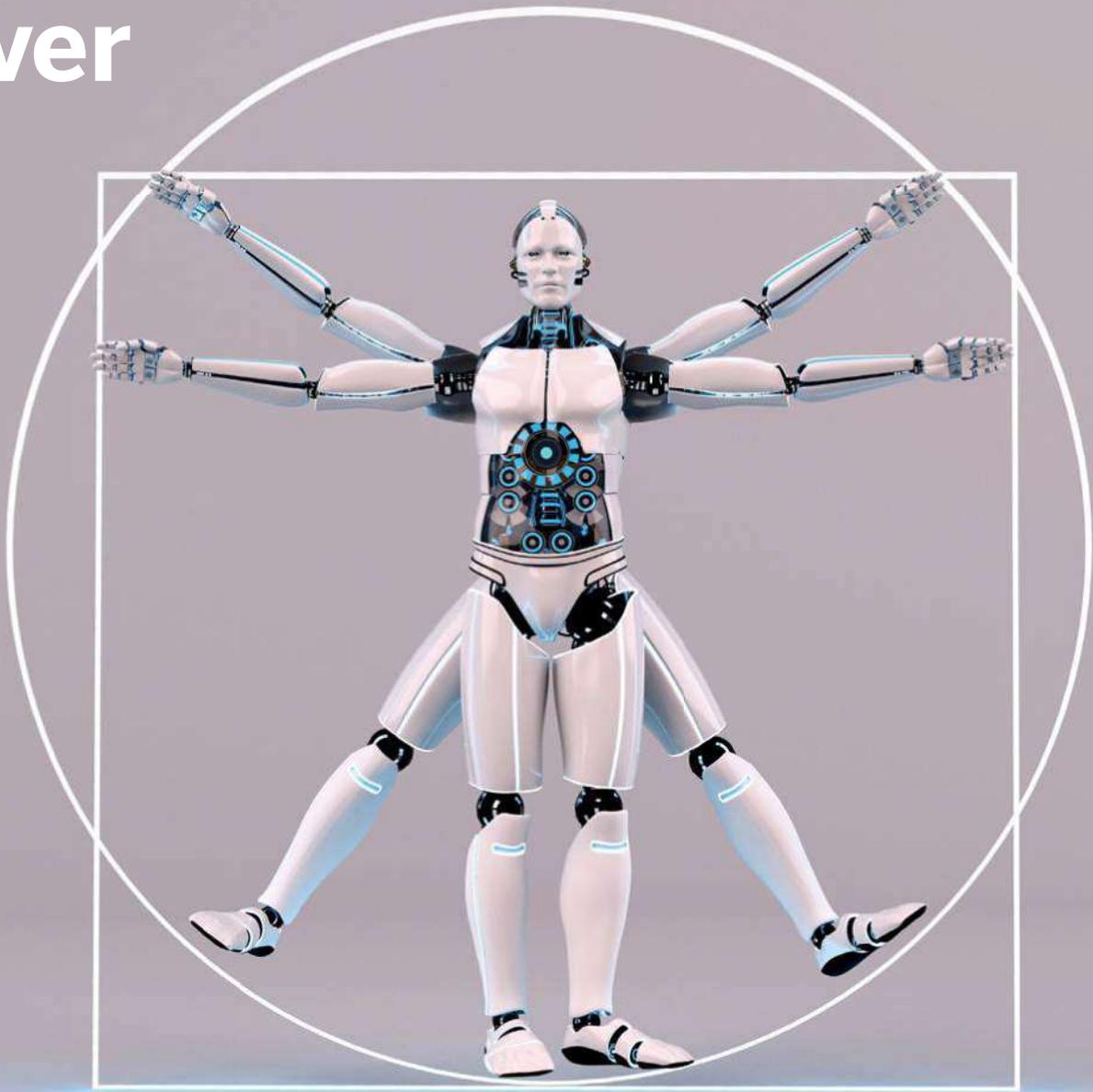


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