

Specification and technical data

AUTOMATIC BOXMAKING MACHINE (with the option of additional die cut)



BOXMATIC MANUAL 18/23 DDC-DD

CONVERTED CORRUGATED CARDBOARD

Type	single, double, try wall
Thickness range	2 - 14 mm
Specific density	400 – 1.200 g/m ²

BASIC TECHNICAL DATA

Processed corrugated cardboard sheets dimensions:

maximal sheet width	1,800/2,300	mm
minimal sheet width	300	mm
maximal sheet length	unlimited	
minimal sheet length	600	mm

Machine productivity and precision:

one out without additional die cut and print	300 - 600	pcs/hour
three out	to 2,300	pcs/hour
absolute precision (first dimension precision)	± 4	mm
relative precision (following dimension precision)	± 2	mm

The precision values are for orientation only and relate to usual box designs. The precisions are given for the distance between the given operations. The precision is granted if the maintenance of the main propulsion chain has been carried out.

Machine dimensions and weight:

length	3,070	mm
width	2,124/2,620	mm
height	1,710	mm
weight (without printing units)	4,400/5,200	kg

Mains:

power supply	3 x 400	V/50Hz
installed machine input	17.0/22.0	kW
maximal instantaneous input	9.0/11.0	kW
air pressure	0.8 - 1	MPa (8 - 10 Bar)
air consumption	50	l/min

Additional die cut:

maximal lengthwise length	230 (1x230 or 2x100 ^{*)})	mm
maximal crosswise length	1,750/2,450	mm
maximal overall knives length	1,500 ^{**)}	mm
max. die cut cycle count by surroundings temperature 25°C	1,200	cycles/hour
lengthwise dimension of wooden support	254 (1x 254 or 2x119 ^{*)})	mm
crosswise dimension of wooden support	100 ÷ 1,750/2,450	mm
thickness of wooden support	15	mm
knives height	30	mm

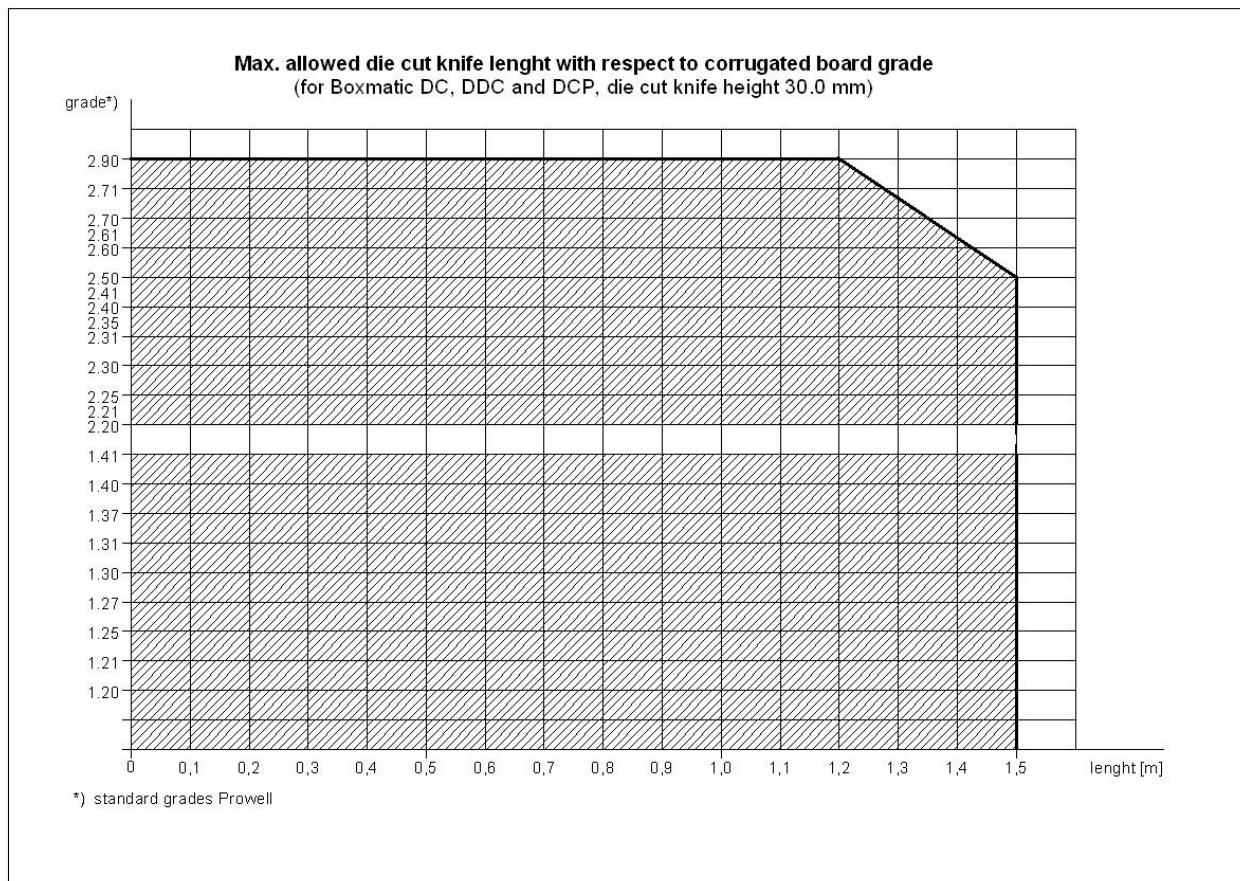
^{*)} variant DCPE-D

^{**)} see diagram

Other parameters:

working temperature	10 - 30	°C
maximal relative humidity	70	%
recommended temperature and relative humidity	20, 60	°C, %

***) diagram:



COMPONENTS

Servomotors
Electromotors
Gear box
Pneumatic elements
Electronics

OMRON Japan
LENZE Austria
LENZE Austria
FESTO Germany
OMRON Japan

CHARACTERIZATION

Machine for production of Corrugated Regular Slotted Boxes and cut sizes BOXMATIC M18/23 DDC-DD has been designed for professional efficient semi-automatic production of basic types of slotted Boxes and offers the possibility of additional die-cutting (i.e. hand holes, cross boxes) from single wall, double wall, try wall corrugated board. The machine can also produce dividers, crease wrappers or just slit and crease the board.

Boxes according to FEFCO (in one pass):

0200, 0201, 0202, 0203, 0204, 0205, 0206, 0208, 0209, 0210, 0211, 0212, 0214, 0225, 0228, 0229, 0230, 0231,

0300, 0301, 0302, 0306, 0310, 0312, 0313, 0320, 0325, 0331

0400, 0401, 0402, 0403, 0404, 0405,

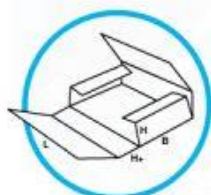
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0501, 0502, 0503, 0504, 0505, 0507, 0509, 0510, 0511, 0512,

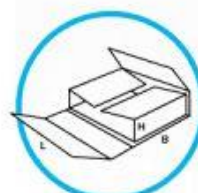
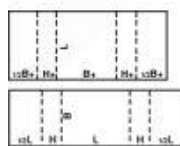
0601, 0602, 0605, 0606, 0607, 0608, 0610, 0615, 0616, 0620, 0621,

řada 09...

and many other types of boxes according to possibilities of the machine



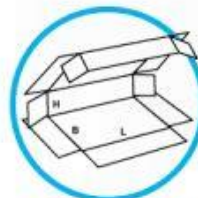
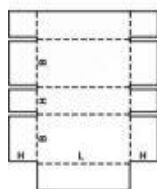
FEFCO_0401



FEFCO_0404



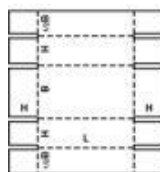
FEFCO_0402



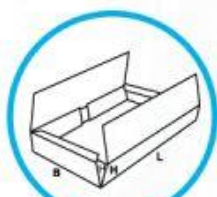
FEFCO_0410



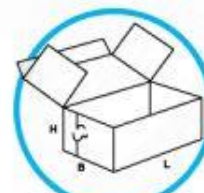
FEFCO_0403



FEFCO_0411



FEFCO_0412



FEFCO_0442

SPECIFICATION

The main machine consists from basic module on which is possible provide the following operations:

- **slotting and creasing** across
- **creasing** along
- **cutting** across with the possibility of **glue flap cutting** at the same time (production of FEFCO 02..)
- **slitting** along
- **multi out** across and along



The part of machine is a **Manual feeding table MF**. The manual feeder enables to load the different board format into machine.



Two double die cut sections (2x230mm or 4x100mm) in variant DDC-DD. It allows to use four different tools for additional cutting and other operations on the box or two big tools for faster production and larger shape cuts.



Later one is possible to install on the machine also options for three out (options). Dimensions of the boxes are programmed through an intuitive touch screen. According to the entered parameters, the machine performs "one up" die-cutting, slotting and creasing, "cutting to length" or alternatively, multiple out cartons across the board and cutting of glue flap in longitudinal direction. The positions of printing units, die-cutting tools, slotting and creasing knives, creasing and cutting wheels and flap knives in transversal direction are easy to adjust manually. The machine is quick and easy to set up. The machine is most perfect for runs 10 - 5,000 boxes long.

MAIN ADVANTAGES OF BOXMATIC MANUAL 18/23 DDC-DD

1. **Versatility** of the machine, **short set up time** when processing many different orders (5 - 15) minutes, which allows to produce small quantity orders.
2. Production of **large size boxes** (max width of board – 1.8/2.3 m, up to unlimited length)
3. **Effective production** of FEFCO 401, 402, 403, 410, 411, 412 boxes.
4. **Favorable utility - price ratio.**
5. **No special maintenance** requirement

BASIC EQUIPMENT OF BOXMATIC MANUAL 18 DDC-DD

1. Main machine Boxmatic M18 DDC-DD (basic and additional section of die cut)

including basic tools:

- | | | | | |
|-----|---|-----------|---|----------|
| 1.1 | Transverse Slotting Knives (thickness 6 or 8 mm): | 98 mm | - | 6 pairs |
| 1.2 | Transverse Creasing Knives (thickness 6 or 8 mm): | 140 mm | - | 4 pcs |
| | | 100 mm | - | 6 pcs |
| | | 80 mm | - | 3 pcs |
| | | 60 mm | - | 3 pcs |
| | | 50 mm | - | 3 pcs |
| | | 40 mm | - | 3 pcs |
| 1.3 | Longitudinal Double Creasing Wheels | | - | 2 pairs |
| 1.4 | Longitudinal Slitting Wheel incl. Knives 132 mm | | - | 2 pairs |
| 1.5 | Shifting Wheel, larger | | - | 2 pairs |
| 1.6 | Glue Flap Knives including holder: | 35 mm | - | 1 pair |
| | | 50 mm | - | 1 pair |
| 1.7 | Die cut form drawers: | 230x15 mm | - | 2 pc |
| | | 100x15 mm | - | 4 pcs |
| 1.8 | Die Cut Clamps: | 230x15 mm | - | 6 pairs |
| | | 100x15 mm | - | 12 pairs |

BASIC EQUIPMENT OF BOXMATIC M23 DDC-DD

1. Main machine Boxmatic 23 DDC-DD (basic and additional section of die cut)

including basic tools:

- | | | | | |
|-----|---|-----------|---|----------|
| 1.1 | Transverse Slotting Knives (thickness 6 or 8 mm): | 98 mm | - | 9 pairs |
| 1.2 | Transverse Creasing Knives (thickness 6 or 8 mm): | 140 mm | - | 8 pcs |
| | | 100 mm | - | 6 pcs |
| | | 80 mm | - | 4 pcs |
| | | 60 mm | - | 4 pcs |
| | | 50 mm | - | 3 pcs |
| | | 40 mm | - | 3 pcs |
| 1.3 | Longitudinal Double Creasing Wheels | | - | 2 pairs |
| 1.4 | Longitudinal Slitting Wheel incl. Knives 132 mm | | - | 2 pairs |
| 1.5 | Shifting Wheel, larger | | - | 2 pairs |
| 1.6 | Glue Flap Knives including holder: | 35 mm | - | 1 pair |
| | | 50 mm | - | 1 pair |
| 1.7 | Die cut form drawers: | 230x15 mm | - | 2 pc |
| | | 100x15 mm | - | 4 pcs |
| 1.8 | Die Cut Clamps: | 230x15 mm | - | 8 pairs |
| | | 100x15 mm | - | 16 pairs |

ADDITIONAL EQUIPMENT (OPTION)

1. Waste bin WB18, BMC18 line
Waste bin WB23, BMC23 line

2. Option for three out, BMC M18 line
 - Transverse Slotting Knives (thickness 6 or 8 mm):

78 mm	-	2 pairs
58 mm	-	2 pairs
40 mm	-	1 pair
 - Longitudinal Double Creasing Wheels - 4 pairs
 - Longitudinal Slitting Wheel incl. Knives 132 mm - 2 pairs
 - Glue Flap Knives including holder:

35 mm	-	2 pairs
50 mm	-	2 pairs

3. Option for three out, BMC M23 line
 - Transverse Slotting Knives (thickness 6 or 8 mm):

78 mm	-	3 pairs
58 mm	-	3 pairs
40 mm	-	1 pair
 - Longitudinal Double Creasing Wheels - 4 pairs
 - Longitudinal Slitting Wheel incl. Knives 132 mm - 2 pairs
 - Glue Flap Knives including holder:

35 mm	-	2 pairs
50 mm	-	2 pairs