

TIP 0305-04

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Introduction to flexo folder gluer/rotary diecutter TIPS

Scope

There is universal agreement regarding the need for improvement of both output and return on investment of flexo folder gluer/rotary die cutters in the corrugated box industry. Only a few of the more than 1600 boxplants in the United States and Canada achieve maximum utilization or optimum production from their flexo folder gluer/rotary diecutters.

The Flexo Folder Gluer and Rotary Die Cutting Subcommittees of the Production Committee of the TAPPI Corrugated Containers Division have identified five major areas in which increased knowledge and better practices can lead to higher productivity and greater return on investment. These committees have been commissioned to publish a series of TIPS outlining recommended action to attain these objectives.

Safety precautions

Use safety devices provided by machine manufacturer or established lock out procedures.

Topic areas

The major areas to be covered are:

- I. Pre-installation
- II. Installation, Training, and Startup
- III. Operation
- IV. Planned Maintenance
- V. Common Operating Problems and Probable Solutions

Statistics from individual and industry sources confirm the need for better management of flexo folder gluer and rotary die cutter operations. Some data relating to the variance in setup times between the top performers in throughput and average performers is shown below (source – 2005 TAPPI/FBA Corrugated Productivity and Waste Survey Report).

TIP Category: Data and Calculations



Documents

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	<u>Top 15%</u>	<u>Average</u>	<u>Top 15% Setup time/ Industry Average Time</u>
<u>Flexo Folder Gluers</u>			
Up to 28 x 72" (710 x 1830mm)	15.2	21.6	70%
Up to 40 x 100" (1020 x 2540mm)	17.8	24.0	74%
Up to 50 x 135" (1270 x 3430mm)	18.4	25.8	71%
66" (1676mm)	31.3	39.9	78%
75" (1905mm)	26.2	39.2	67%
<u>Flexo Rotary Diecutters</u>			
Up to 66 x 80" (1680 x 2030mm)	20.7	29.6	70%
Up to 66 x 115" (1680 x 2920mm)	24.5	32.9	76%
over 115" (2920mm)	21.1	27.7	- 76%

The Committee firmly believes that significant industry-wide improvements in flexo folder gluer/rotary die cutter productivity can be made without major capital investments in many instances (no matter what brand is involved, how old it is, whether its operation is manual or electronically controlled) by utilizing the practices outlined in these TIPs.

Index of TIPs

TAPPI Technical Information Papers (TIPs) are continually reviewed and updated. Therefore, the best resource to see the full list of TIPs written for flexo folder gluers/rotary die cutters is the TAPPI web site, where the numerical listing and the subject index for these documents is continually updated.

Go to the TAPPI main page (www.tappi.org), click on the link to "Standards." On the Standards page, scroll down to the bottom to the list of "General Information Documents," then click on "Numerical Index for TIPs." The TIPs that begin with "0305" are those that pertain to corrugated production. The list of TIPs relevant to flexo folder gluers/rotary die cutters begins with this TIP (0305-04) and continues from there. This list on the web will show the current status of each TIP, with either the year of the current revision or the date on which the TIP was withdrawn.

Keywords

Folder gluers, Die cutters, Rotary machines

Additional information

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