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Squaring flap cut (center special) boxes

Scope

A method for squaring flap cut (center special) boxes produced by rotary diecutting on high speed printer slotters and/or flexo folder gluers.

Safety precautions

No safety precautions apply.

Content

Squaring boxes which are flap cut by rotary diecutting on high-speed printer slotters and/or folder gluers may be simplified by leaving sections of the cut flaps (labeled A and B) attached to the blank by notching the cutting rule. (See Fig. 1.) The edges of these sections remaining on the cut flaps then align with the edges of the uncut flaps (labeled C, D, E, and F) to ensure that they will be squared by the squaring device on the folder gluer. (See Fig. 2.)

The length of the scrap sections varies due to the sizes of the flap cut boxes. The sections of smaller boxes should be no longer than 0.5 in. (13 mm) less than the difference between the length and width panels. (See Fig. 3.) A maximum width of 6 in. (152 mm) for the sections is enough to square larger flap cut boxes.

After the bundles are tied, sections A and B are removed by striking them with a hammer. The scrap is easily detached from the blank because it falls into a void left between the uncut flaps. (See Fig. 3.)

This method of squaring flap cut boxes requires that the sections be removed by hand. However, it is reported that the increase in production of high-quality squared boxes more than compensates for the cost of hand stripping the scrap sections.

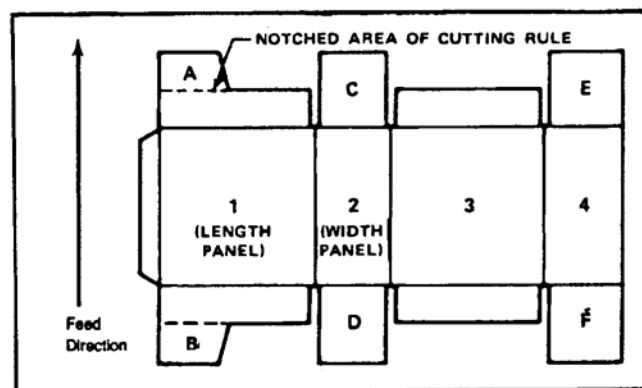


Fig. 1. Notched cutting rule.

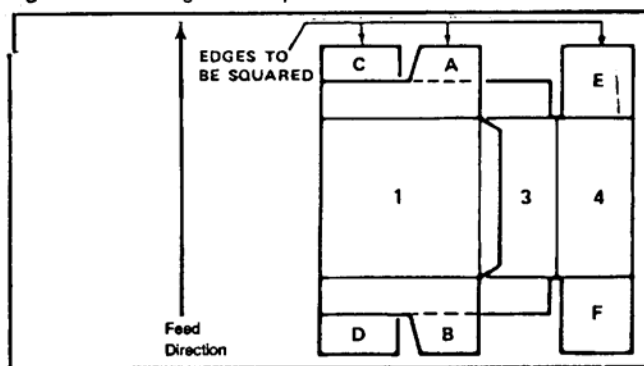


Fig. 2. Alignment of edges.

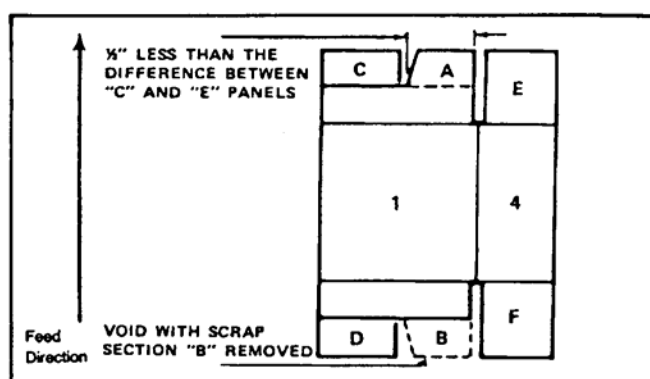


Fig. 3. Length of scrap sections.

Keywords

Flaps, Die cutters, Folder gluers, Boxes, Squared paper, Trimming

Additional information

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