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PAPER

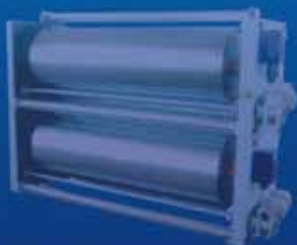
CORRUGATED

BOARD &

BOX

MAKING

MACHINERY





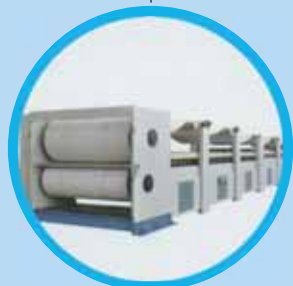
# Three, Five, Seven Layer Corrugated Paperboard Production Line



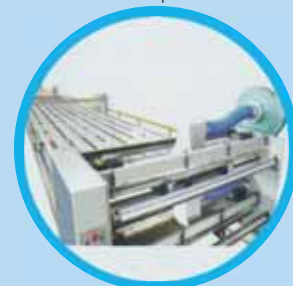
Slitter & Scorer



Gluing Machine



Double Facer Baker



Conveyor Bridge



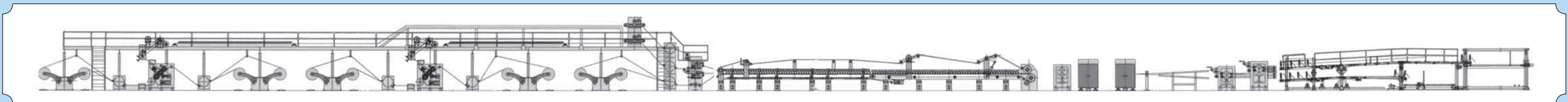
Inner Suction Single Facer



Diameter of Preheate



Hydraulic Mill Roll Stand





## Single Facer Fingerless Corrugation Machine (Boiler Model)



### Technical Specifications:

- Design speed: 60-180m/min
- Effective width: 1400mm-2500mm
- Corrugated roller diameter:  $q > 268\text{mm}$  -  $q > 300\text{mm}$  -  $q > 320\text{mm}$  -  $q > 360\text{mm}$
- Vacuum suction type pulling cardboard with wind control device.
- Glue roller and fixed roller are designed to groups guide way slippage load-unload, convenient and swift.
- Used Gimbal drive with independent gear box, transmission more stable, close style gear transmission oiliness lubricated, prolong the use life of gear.
- The upper corrugating roller, pressure roller and glue roller adopt pneumatic control.
- Flute roller and pressure roller adopt high temperature resistant lubrication grease.
- Manual adjust the gluing quantity or electric adjustment.
- The upper-lower corrugating roller are made of 48CrMo high quality alloy steel, after heat-treatment. The rigidity is HRC58-60°, the surface are whetted and plating chrome.

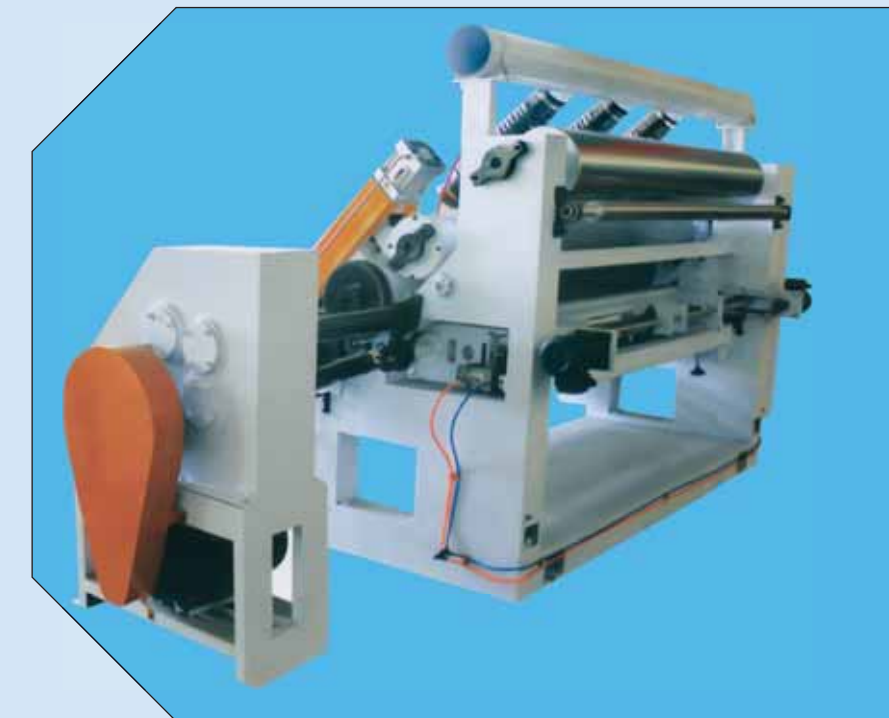
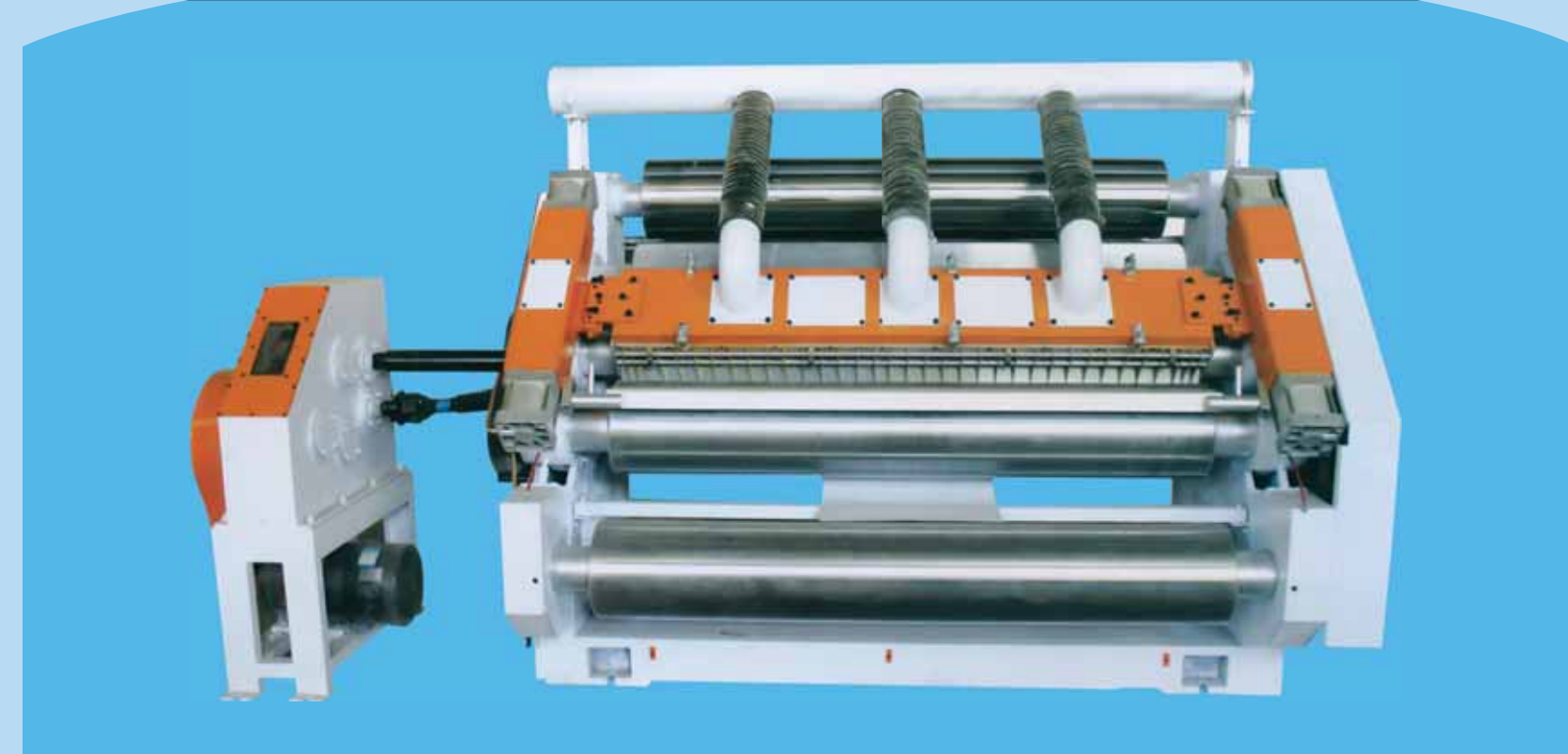
Options: Electric insulating glue device. Gluing part can separately running when machine stop to prevent from glue is dry.

## Double Facer Corrugation Machine



- Designed speed: 150m/min
- Corrugator roll diameter: 320mm
- Available width: 1600mm-2200mm
- Heat source: steam
- Vacuum suction system provide perfect flute shape.
- Double flutes structure, one flute unit working and another pre heating. Operate the switch of the clutch to change flute rapidly.
- Block design of the gluing unit with frequency conversing drive, straight guide-way slipping, hydraulic lock, pneumatic movement of the glue trough, electric control of dividing glue. Motorized glue application, and digital read out.

## Single Facer Corrugation Machine (Heater Model)

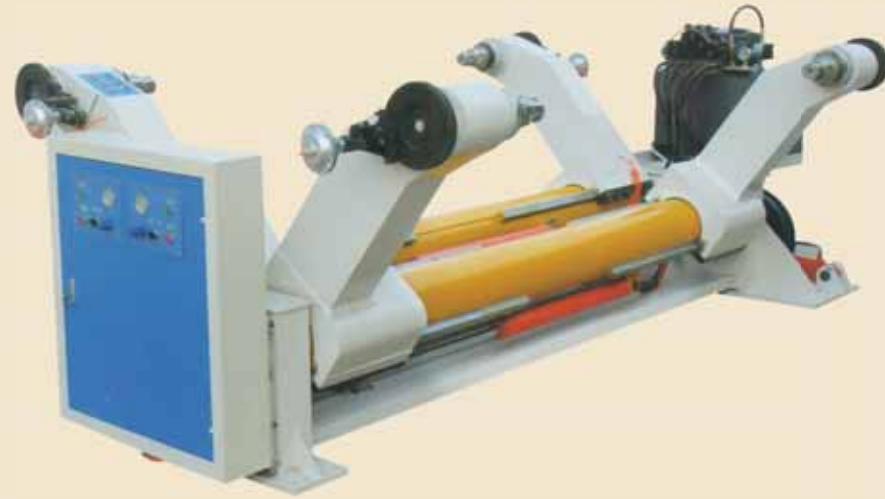


### Technical Data

- Corrugated roller:  $\phi 260/270/280$  mm
- Speed 0-100 m/min
- Effective width: 1400mm (55) in 1600mm (in 63)
- Pieces of heat for liquefied petroleum gas heating or electric heating



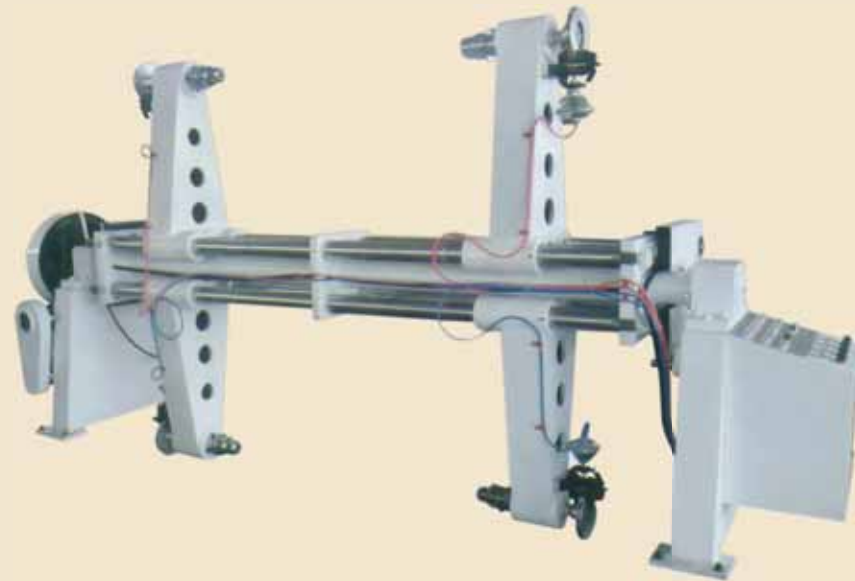
## Hydraulic Shaftless Mill Roll Stand



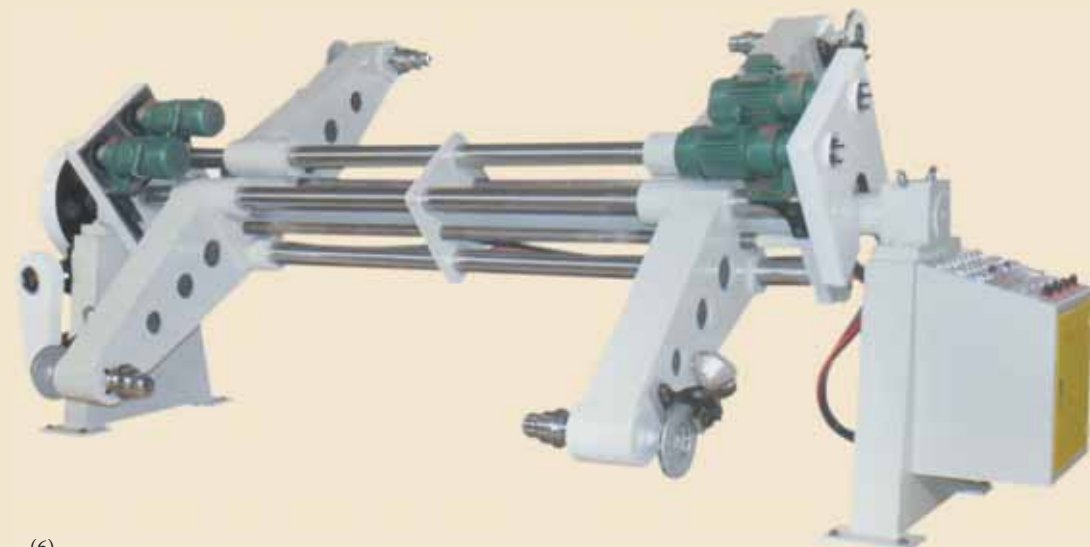
- Maximum diameter Dia 1500 mm
- Effective width 1400mm - 25mm
- Pneumatic brake control of web tension.
- Taper centre, stretch centre is optional.
- Hydraulic control of the lifting and lowering, clamping, releasing, right left movement.

## Electrical Shaftless Mill Roll Stand (with Panel)

- Maximum diameter 1500 mm
- Range of width 1400mm - 1800mm
- Pneumatic or manual control of web tension.
- Taper centre, stretch centre is optional.
- Motorized lifting and lowering, clamping, releasing, right-left adjustment of the reel paper.

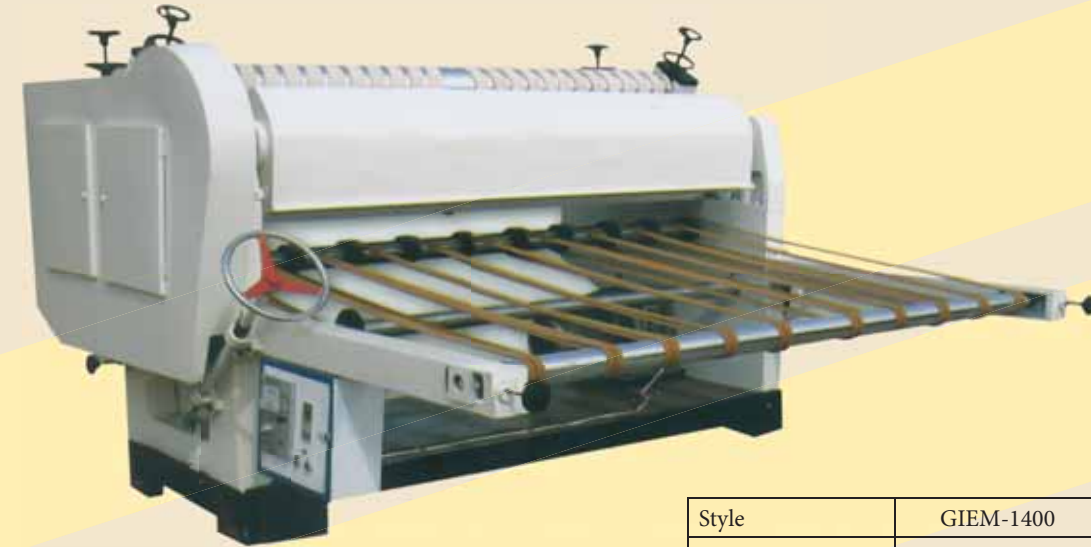


## Electrical Shaftless Mill Roll Stand (with Motor)



- Maximum diameter 1500 mm
- Range of width 1400mm - 1800mm
- Pneumatic or manual control of web tension.
- Taper centre, stretch centre is optional.
- Motorized lifting and lowering, clamping, releasing, right-left adjustment of the reel paper.

## Automatic High Speed NC Cutter



Style	GIEM-1400	GIEM-1600	GIEM-1800
Work Speed	30-160m/min	30-160m/min	30-160m/min
Corrugating Flute Files	(U/V) A, C, B, E, F	(U/V) A, C, B, E, F	(U/V) A, C, B, E, F
Mode of Heated	Steam, Oil, electric, gas-fired	Steam, Oil, electric, gas-fired	Steam, Oil, electric, gas-fired

## Automatic High Speed NC Cutter (for 5 Ply)

- Max. design speed: Straight knives 80m/min.
- Effective width: 1400mm-2500mm.
- Length of cutting cardboard: 500-9999mm, Precision of cutting cardboard:  $\pm 1$  mm.
- Short diameter of knife shaft, high average speed better to improve the productivity.
- Transmission system adopts oil pump auto-Cyc lubricate.
- Exact and adjustable no gap gear assure knife-edge joggle exactly. Incision quality good, beeline degree high, protect knife.
- NC. automatic follow the cardboard transmission speed and keeping synchronization.
- NC. reserve groups of orders, and auto-complete as the procedure or according as preferential condition, the screen display various production message.





## Rotary Die Cutting Machine (Lead Edge Feeder)



- Die-cutting roller is the high quality steel materials, 30mm thickness, balance correction, hard-chrome plating.
- Wallboard is high-quality cast iron material, 50mm thickness, and large processing center production.
- Soft-roll automatic grinding institutions improve rubber sleeve to pouches repeat usage and can grinding 3-4 times.
  - Line speed automatic compensation to ensure that each batch of cardboard boxes full of die-size line
  - The rubber is CUE polyurethane from America, easy to install and can die-cutting 12million times.
- Mechanical soft roll about 40 mm lateral movement, the pads wear uniform.
- Six level grinding gears used 40cr material, low noise, long life.
- Die-cutting roller cylinder automatic separation devices to reduce rubber wear.

Model	Max feeding of paper(mm)	Min feeding of paper(mm)	Thickness of feeding pape	Feeding speed (pcs/min)	Power of main motor	Machine weight
GIEM1700	1700 x 1200	350 x 500	11mm	30-120	4.0kw	4500kg
GIEM2000	2000 x 1200	350 x 500	11mm	30-120	5.5kw	5000kg
GIEM2100	2100 x 1400	400 x 600	11mm	50-160	7.5kw	5500kg
GIEM2400	2400 x 1400	400 x 600	11mm	50-160	7.5kw	6000kg
GIEM2500	2500 x 1400	500 x 600	11mm	30-100	11 kw	7000kg

## Rotary Die Cutting Machine (Chain Feeding)



- This machine is exclusive equipment for die cutting and molding, suitable for the manufacturing of colorful cartons, boxes and other package products of abnormal shape.
- It adopts the double roller pressing and urethane soft template; die cutting speed difference servo makes up the linear velocity automatically, once completing the paperboard and the siding, slotting, punching, creasing and folding of the corrugated paper of medium and small thickness.
- The machine adopts the vacuum adsorption feeding facility; the main machine adjusts the speed by electromagnetism and the die cutting phase by computer, featuring high precision of die cutting, high speed and convenient operation.

	Unit	GIEM-1900	GIEM-1900	GIEM-2100	GIEM-2400
Max speed	Pieces/min	60	60	60	60
Max paperboard size	mm	1400 x 1600	1400x 1900	1400 x 2100	1400 x 2400
Max cutting size	mm	1400 x 1350	1350x 1750	1350 x 1950	1350 x 2200
Thickness of paperboard	mm	2-10	2-10	2-10	2-10

## Automatic Stacker



- Effective width: 1400mm-2500mm, Design Speed: 80m/min-120m/min
- Mechanical configuration: Slitter and N.C helical knife and stacker
- Min. cutting length: 300mm Max. cutting length: 9999mm
- cutting accuracy:  $\pm 1$  mm (uniform speed)  $\pm 1.5$ mm (non-uniform speed)
- Five group  $\phi 160$  round knife.
- Memory of 200 orders, man-machine interface, the screen displays information available, easy for machine operator modify or cancel order at any time.
- Adopt Germany KEB servo system and high-performance synchronous servo motor.
- Helical knives structure with HSS knife edge, serration type knife and scissor cutting with less shear force, to keep the knives long life
- Host base and machine frame adopt grey cast iron, to keep machine strong and stable

## RS4 Combined Rotary Slotting Machine



This series on corrugated board cut paper, roll the line ,slice the corner open the slot machine, is comprehensive production equipment which integrate several process such as cutting corner line and slicing the side, electric phase, the machine characteristic is feeding single paperboard one by one, general flexural paperboard is applicable too.

Slicing the Corner, opens the slot knife can 360 degree positive turn and reverse turn, circularly convenient to adjust ,reliable to lock and open slot precisely ,the adjusting function designed compactly durable and long using life

Max. paper. Siz	mm	1250X2200 /2400/2500	1450X2200 /2400/260C
Min. paper. Size	mm	350mm	400mm
cardboard thickness	mm	2-11mm	2-11mm
Slot width	mm	7	7
Max speed	Pes /min	60	50

## High Speed Multiple Printing, Slotting and Die Cutting Machine



- Whole machine electric parts were chosen from famous brands for good quality and steady performance.
- Complete machine baffle and important parts were made of tempered metal to reduce metal deformation force, and parts were made by high precision centers and ground by digital-controlled grinding.
- All transmission axles and rollers are made of high-quality steel, tempered, and dynamically balanced. Plates are made of nickel-chrome and ground on the surface.
- All transmission gears are made of 45# alloy steel, which is ground after heat treatment. It is made by rubbing, so it still maintains high topping precision.
- The whole machine undergoes spray lubrication, featuring a double oil pipe balance system.
- Whole machine working interval adjustment, self-lock worm wheel and worm device, fast and convenient.
- Option Ceramix Anilox roller, Stacker

	Unit	1030 × 1900 / 2300 (φ 360)		1200 × 1900 / 2300 (φ 420)		1400 × 2300 / 2700 (φ 480)		1700 × 2300 / 2700 (φ 560)	
Inboard width size	mm	2200	2600	2200	2600	2600	3000	2600	3000
Max. paper size	mm	1080 × 2000	1080 × 2400	1200 × 2000	1200 × 2400	1500 × 2400	1500 × 2800	1750 × 2400	1750 × 2800
Min. finish size	mm	260 × 610	260 × 610	380 × 640	380 × 640	380 × 640	380 × 640	450 × 720	450 × 720
Max. printing size	mm	1030 × 1900	1030 × 2300	1200 × 1900	1200 × 2300	1450 × 2300	1450 × 2700	1700 × 2300	1700 × 2700
Thickness of printing plate	mm	6		7.2		7.2		7.2	
Complete machine baffle thickness	mm	50		40		40		40	
Max Speed	Pieces/min	110		110		100		80	
Economic speed	Pieces/min	100		100		90		70	
Topping precision	mm	±0.5		±0.5		±0.5		±0.5	
Slotting precision	mm	± 1.5		± 1.5		± 1.5		± 1.5	
Slotting depth	mm	250		300		300		400	
Min. slotting interval	mm	205 × 60 × 205 × 60		260 × 60 × 260 × 60		260 × 60 × 260 × 60		280 × 80 × 280 × 80	

Rotary Die Cutting Unit



Printing Unit



Slotting Unit





## Chain Feeding Printing, Slotting Machine



It adopt the combination chain-paper feeding style. ♦ Adopt planet type electric phase 360 degree adjusting, while revolving or stopping can be adjust quickly and accurately. ♦ When machine stopped working, inker roller auto separate with printing roller, avoid spoiled the printing roller. ♦ Inker roller have the separately turn device to prevent ink dried when machine stopped work. ♦ Pneumatic locking, electrically separation. ♦ Ink supply by pneumatic diaphragm pump. ♦ Main transmission gear made by 45# steel after high frequency quenching. ♦ Transmission part adopt sprinkle lubricating system, ensure the machine precise and use life.

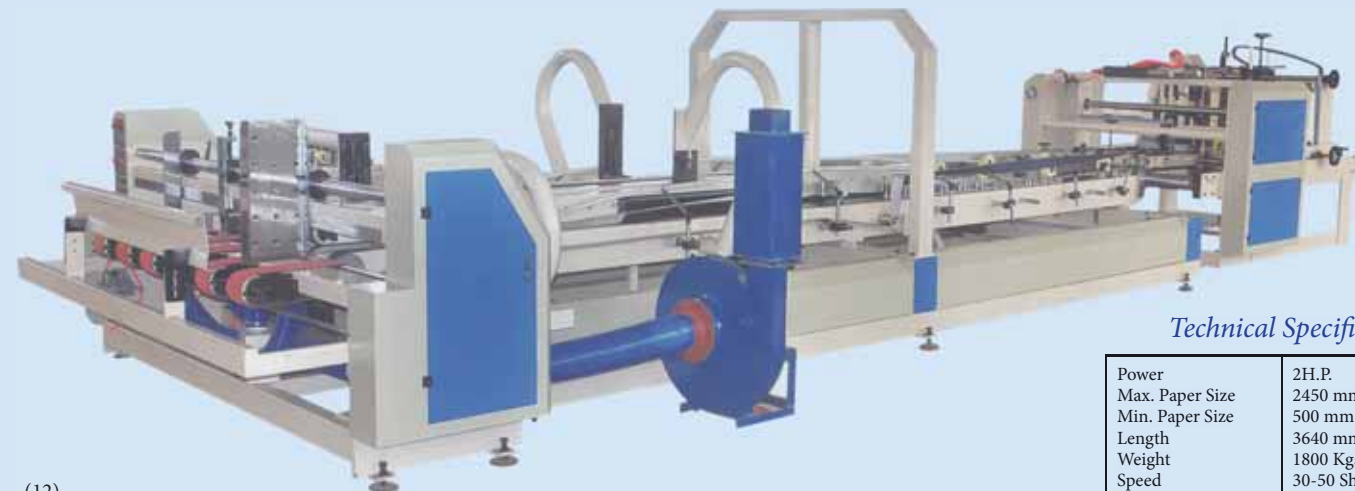
## High Speed Stitching Machine

Model	BDJ-2000
Max paper size	1515x3560mm
Min paper size	300x606mm
Stitching distance	30-120mm
Nails NO	1-99 nails
Working speed	500 nail/min
weight	2000kg
Total power	2.8kw
Stacking height	900mm
Wire size	2.0x(0.65-0.75)mm



## Semi Automatic Folder Gluer

This machine is suitable for gluing & pasting of corrugated box flap instead of stitching. The unique feature of the machine is that it can be used for both inside & outside pasting. Two piece cartons can also be glued and pasted with the help of this machine. Easy to use, One minute quick order change.



### Technical Specifications

Power	2H.P.
Max. Paper Size	2450 mm
Min. Paper Size	500 mm
Length	3640 mm
Weight	1800 Kgs.
Speed	30-50 Sheets/Min

## Thin Blade Paper Slitting and Creasing Machine

- Adopt thin knife separate cutting (The thickness is only 1 mm). Installed with automatic and hand grinding wheel grinding to keep the knife edge sharp and the separate—cut paper— board smooth and tiny.
- After pre—pressing, separate cutting and creasing the paperboard we will accomplish the requirement of the product. The pressed trace do not arouse the trace tearing phenomenon.

### Technical Data

	2000	2500
Width of the applied Paperboard (mm)	2000	2500
Max. Speed of Paperboard (m/min)	141	141
Times of Paper Partitioning	4	4
Min. Separate Cutting Width/Creasing Width (mm)	200	200
External Diameter of Thin & Round Knife (mm)	260	260
Thickness of Thin & Round Knife (mm)	1	1
Power Required (Kw)	4	4
Weight (Kg)	3000	3500



## Die Punching Machine with Automatic Feeder



## Box Stitching Machine



Changing the size within one minute ♦ Easy operation and no needs of experiences ♦ The machine could be stapled single nail ♦ Feeding department automatic count, when get the bundle then send to tie up. ♦ Operation by the touching screen ♦ Adopting servo control system ♦ Distance of each nail can reach 120mm ♦ Having cover or no cover could be nailed ♦ The distance of nails could input by the touching screen directly  
The ♦ ss of the paper could be adjusted automatically



## Double Color Printing and Rotary Die Cutting Machine



Model	GIEM-2400	GIEM-2600	GIEM-2800
Wall Diameter	2347	2547	2747
Max. paper coverage area	2200 × 1450	2400 × 1450	2600 × 1450
Effective printing area	2000 × 1450	2200 × 1450	2400 × 1450
Finish Speed (pieces/min)	0-60	0-60	0-60
Main Motor (H.P.)	5.5	5.5	7.5
Thickness of printing plank	4-7	4-7	4-7

## Semi Automatic Folder Gluing Machine

Semi-automatic gluer is new-type environmental equipment, mainly used in carton sticking, abandon the traditional copper stapling method, raised the productivity, and the product quality is good. Main machine frame: machine frame ascend and descend worktable, front part convey equipment, front part amending equipment, middle part convey equipment, middle part press together equipment, finished product side output equipment, electrical controlling equipment.

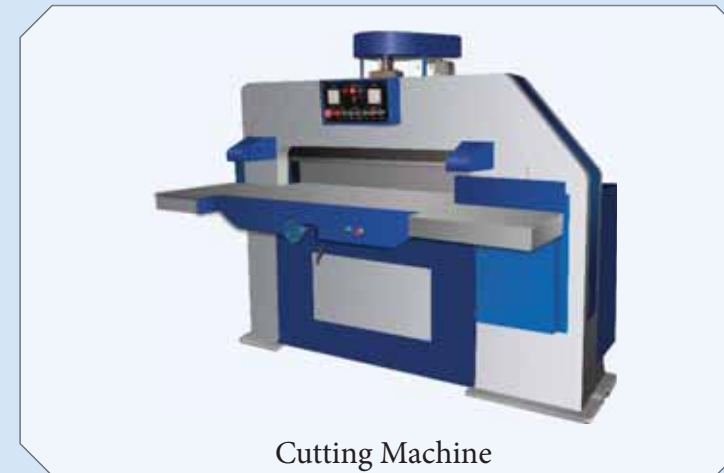
Specification	GIEM-2600
Max size(length+width) x 2	2600mm
Min size(length+width) x 2	340mm
Max size (width+height) x 2	1515mm
Min size((width+height) x 2	240mm
Paper height	900mm
Engine power	2.2kw
Machinery speed	40m/min



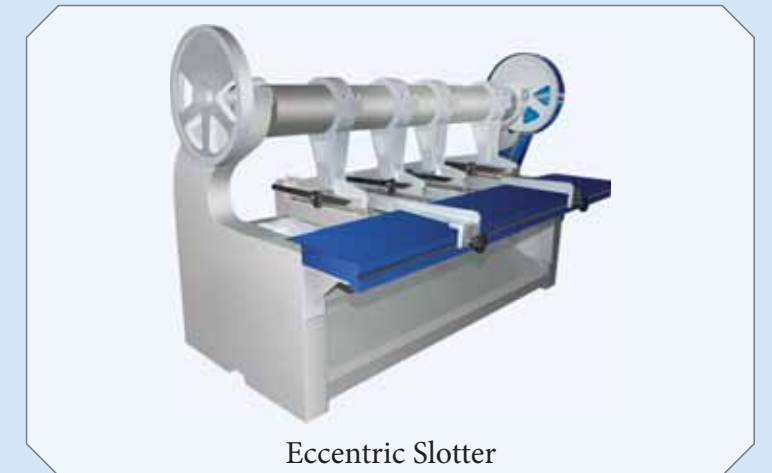
Corrugation Machine



Die Punching Machine



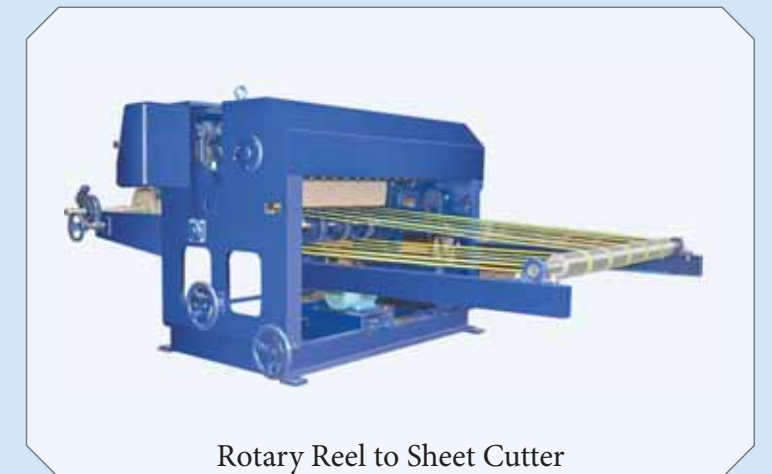
Cutting Machine



Eccentric Slotter



Four Bar Rotary Cutting & Creasing Machine



Rotary Reel to Sheet Cutter



Sheet Pasting Machine



Stitching Machine





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