

Corrugated box conversion, presented the right way.



Cardboard

Solutions for all types of corrugated cardboard

4 Colors

High quality flexographic printing

CMYK

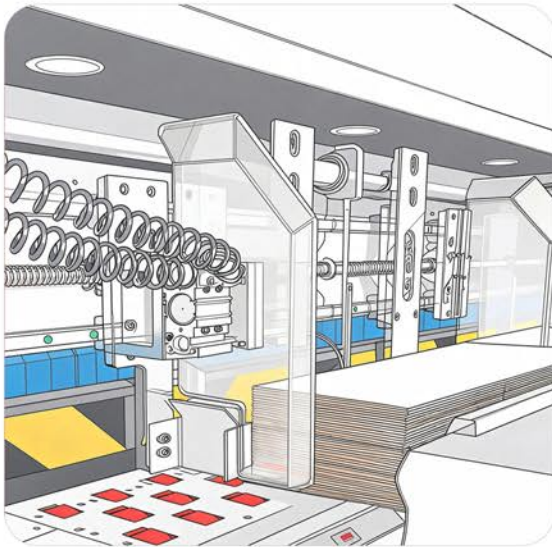
300 pcs/min

Design speed on selected models

BS-ST is a full automatic vacuum transfer servo feeder printer slotter die cutter designed for high-speed corrugated carton production, with servo-driven lead edge feeding, vacuum transfer printing, computerized slotting, and servo rotary die cutting in one line

RAW MATERIAL

corrugated board and flute compatibility



The BS-ST line is presented here for single-wall corrugated cardboard sheets, also called 3-ply board: one fluted medium between two linerboards. This is the standard format for a wide range of shipping cartons, printed transport boxes, and many die-cut corrugated packs.



*supports 3-ply single-wall corrugated sheets across common flute profiles depending on box specification and production requirements

Maximum Thickness is 13mm

FLUTE TYPE	APPROX. THICKNESS	TYPICAL USE VALUE
A flute	About 5 mm	High cushioning and good stacking support
B flute	About 3 mm	Good crush resistance and common transit packaging
C flute	About 4 mm	Balanced strength and cushioning for general use
E flute	About 1.5 mm	Finer profile with a smoother printable surface
F flute	About 1 mm	Compact, fine flute for light retail-style packs

Corrugated Flute Types

E Flute
1.1-2 mm



B Flute
2.5-3 mm



C Flute
3.5-4 mm



A Flute
4.5-5 mm



BC Flute
6-7 mm



AB Flute
8-9 mm



BE Flute
3.6-5 mm



PRINTING

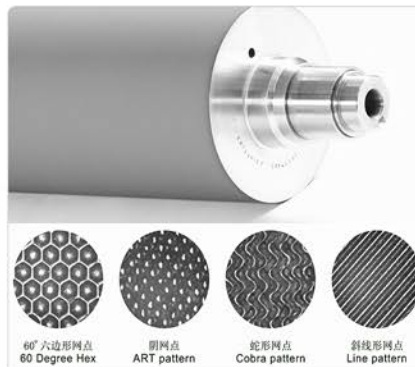
Flexographic printing process for corrugated packaging

Vacuum Printing Unit

- The vacuum transfer adopted for the whole process feeding is able to feed the cardboard smoothly and precisely which improve the printing precise.
- The gap between vacuum cabinet and printing roller adjusted by PLC and touch screen.
- Automatic reposition after washing the printing template during the printing procession.
- Automatic pneumatic lifting gear working with feeding system
- Printing plate roller traverse PLC control adjustment, movement range $\pm 5\text{mm}$

Flexographic printing is a relief printing process using flexible plates mounted on rotating cylinders. Ink is measured by the anilox roller, transferred to the printing plate, and then applied onto the corrugated sheet as it moves through the press.

Customizable Anilox Rollers



Printing Plates Used



MACHINE SECTIONS

Feeding, slotting, and die cutting architecture

Servo Feeding Unit

- Lead-edge feeding concept for stable sheet entry.
- Vacuum-assisted sheet handling for accuracy on corrugated board.
- Gap adjustment and controlled feeding pressure to protect board integrity.



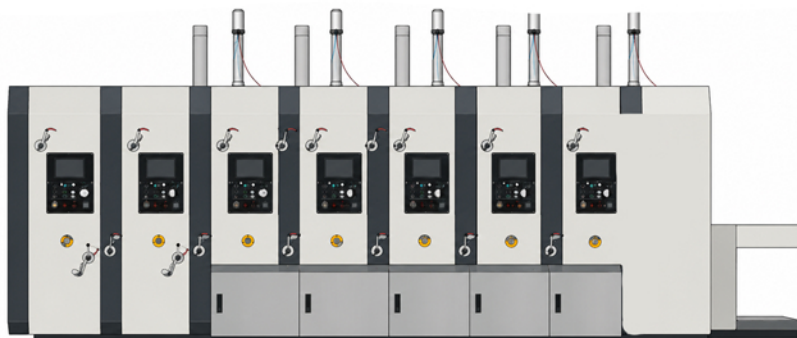
Slotting Unit

- Creasing and slotting preparation for box forming accuracy.
- PLC-guided movement of knives and slotting holders.
- Touch-screen phase and gap adjustment for setup efficiency.



Rotary Die Cutting

- Servo rotary die cutting system with phase control.
- Suitable for repeatable shaped production on corrugated sheets.
- Can be presented with custom cylindrical die tooling examples.



SPECIFICATIONS

BS-ST technical information

MODEL	BS-ST920	BS-ST922	BS-ST1224	BS-ST1228	BS-ST1428
Maximum paper size	920x2000mm	920x2200mm	1200x2400mm	1200x2600mm	1400x2600mm
Minimum paper size	300x680mm	300x680mm	350x680mm	350x680mm	430x680mm
Maximum printing size	920x1800mm	920x2000mm	1200x2200mm	1200x2400mm	1400x2400mm
Design speed of machine	300pcs/min	300pcs/min	250pcs/min	250pcs/min	200pcs/min
Economic speed of machine	0-250pcs/min	0-250pcs/min	0-200pcs/min	0-200pcs/min	0-180pcs/min
Printing paper type	A.B.C.E.A/B.B/C and A/B/C flute (The maximum gap is 13mm)				
Printing plate thickness(plus cushion)	4.8-7.2mm				
Diameter of printing roller(including printing plate)	300mm	300mm	405mm	405mm	480mm
Standard printing thickness	1.5-12mm				

ADDITIONAL INFORMATION

Other architecture

Die Cutting Molds

Rotary die cutting for corrugated packaging commonly uses cylindrical wooden dies carrying the cutting rule pattern. This makes it easier for a client to understand that the machine supports repeated industrial shapes, not only straight-line cutting.



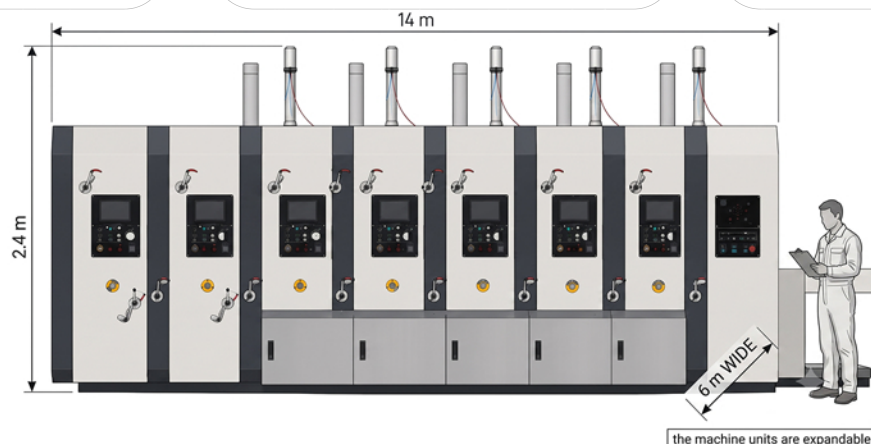
Full PLC Control

- Full control of your machine
- Simple and intuitive set-up
- Color touch screen



European Parts

The electrical section is equipped with high-grade European components from Schneider, and Siemens, ensuring stable performance, reliability, and long-term durability.



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