



Guangzhou Smart Machinery is a national high-tech enterprise factory for the 1226/1228/1230 automatic folder gluer machine, automatic folder gluer stitcher machine factory. We have our own engineer team and after sale service team. Over the years, we have been close to customers, close to the market, constantly pushing the old and bringing the new, carefully developed a series of automatic folder gluer machine and automatic folder gluer stitcher machine.

Our company has many years of experience in developing the market and providing professional services to the printing and corrugated cardboard industries. Our machines are already exported to customers around the world.

Welcome to visit us and please feel free to contact us.

AUTOMATIC CARTON BOX FOLDER GLUER STITCHER MACHINE

APPLICATION AREA



- Appliances packing



- Ceramic tiles packing



- Seafood packing



- Pharmaceutical packing



- Furniture packing



- Hardware packing

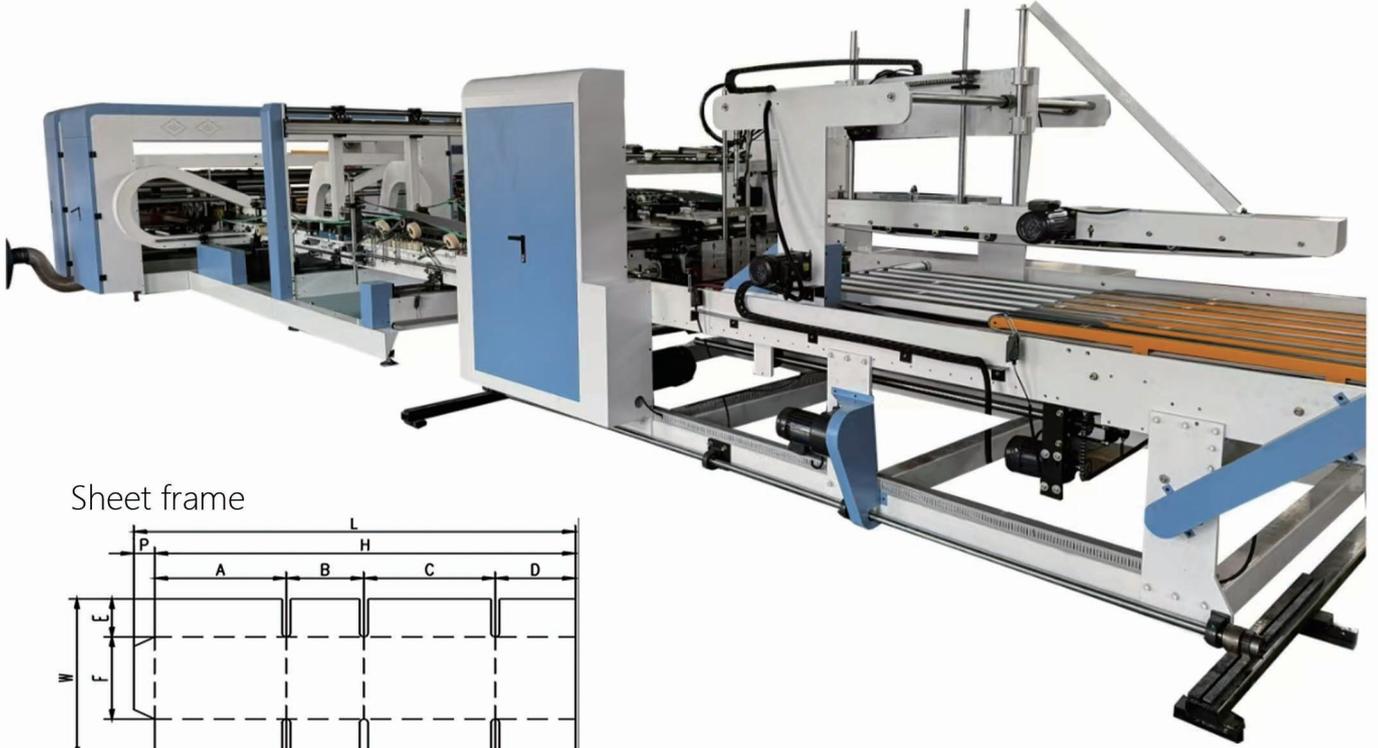


ABOUT MACHINE

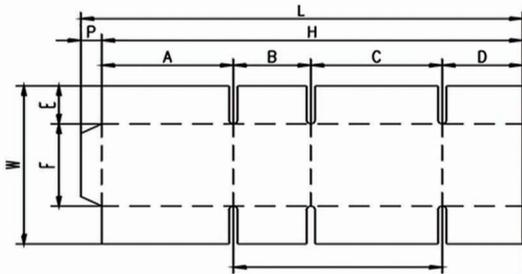
- For your corrugated carton production, you need reliable, productive and versatile equipment. With its modular design , steady and precise machine, easy to set up and operate.
- This extremely versatile folder-gluer machine allows you to produce different sizes boxes and cartons.
- All sections with independent motor driving system.Motorized carrier movement with high precision linear guides.
- Self inspection and mutual inspection to ensure the products has zero shortcomings.



Automatic 1226/1228/1230 folder gluer machine

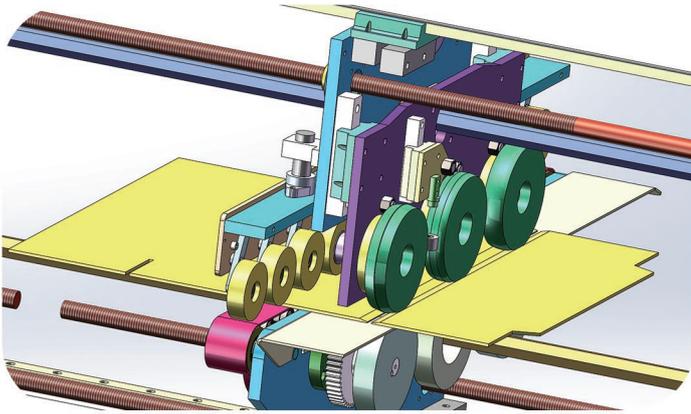


Sheet frame

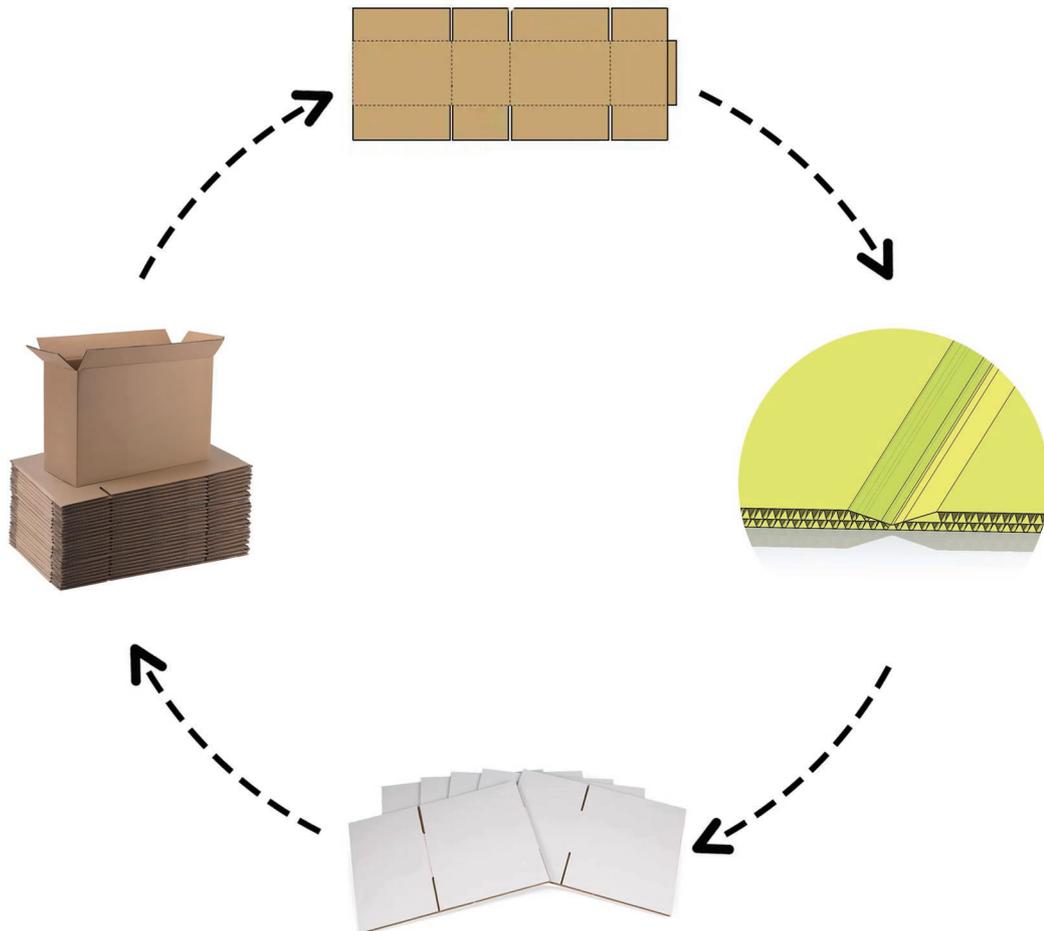


型号 Model	2400*1200	2600*1200	2800*1200	3000*1200
最大纸张尺寸(A+B)*(mm) Max cardboard size (A+B)*(mm)	2400	2600	2800	3000
最小纸张尺寸(A+B)*(mm) Min cardboard size (A+B)*(mm)	420	420	420	420
最大纸箱长 Amm Max carton length Amm	420	420	420	420
最小纸箱长 Amm Min carton length Amm	130	130	130	130
最大纸箱宽 Bmm Max carton width Bmm	650	650	650	650
最小纸箱宽 Bmm Min carton width Bmm	80	80	80	80
最大纸张高 (W) (mm) Max paper height (W) (mm)	1200	1200	1200	1200
最小纸张高 (W) (mm) Min paper height (W) (mm)	170	170	170	170
最大摇盖尺寸 E (mm) Max cap size E (mm)	430	430	430	430
最小摇盖尺寸 E (mm) Min cap size E (mm)	50	50	50	50
最大高度 F (mm) Max carton height F (mm)	700	700	700	700
最小高度 F (mm) Min carton height F (mm)	100	100	100	100

Carton data:mm

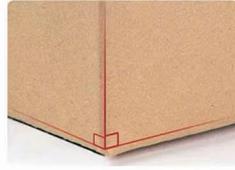


- 1.This part compose by pre-creaser rollers, creaser rollers and forming rollers.
- 2.The two sides guide plates automatically adjust the width, pressure device and adapt to the thickness of cardboard.
- 3.Re-press the scoring lines straight to ensure the folding more accurate and carton folding better.
- 4.Innovative design rollers can better solve the forming of cardboard and no crush of the creasing.





Extra hard and compressive



Standard 90°



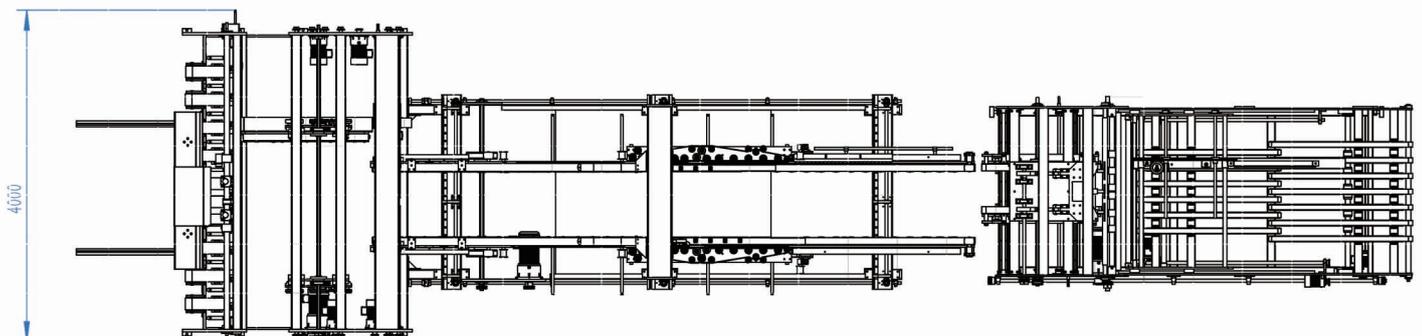
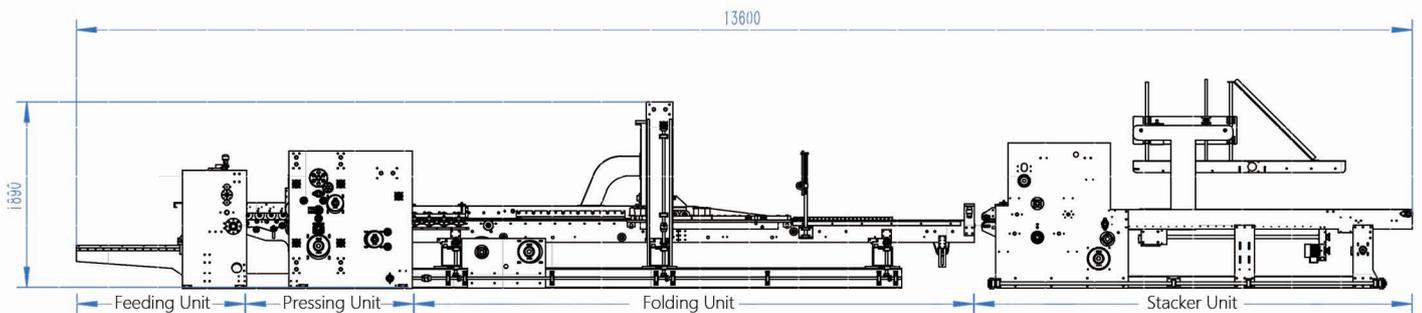
Strong adhesive



Thickened special corrugated



1. Composed with four parts: vacuum paper feeding section, paper pressing scoring section, gluing folding section and counting stacking output section.
2. Electric adjustment, only need to input three data (length, width, height dimensions) on the touch screen, the machine automatically adjusted to the position.
3. The operation is simple and reliable, the highest speed of the carton is 180m/ min, and the average
4. speed of the carton is 150m/min. High speed energy saving and labor cost saving.
5. Automatic paper feeding, automatic gluing and automatic folding, correction counting, stacking.
6. With secondary correction function, guarantee folding precision, eliminate fish tails and reduce the scrap rate.
7. With different speed correction, the folding is more precise.
8. Carton output quantity can be set, automatically counts, shapes, stacks, and output, which can easily connect with auto strapping machine.





Automatic 1226/1228/1230 folder gluer ststicher machine



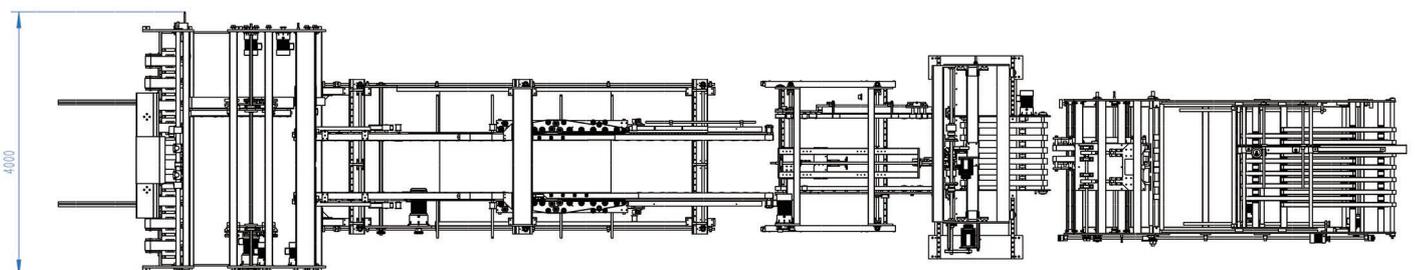
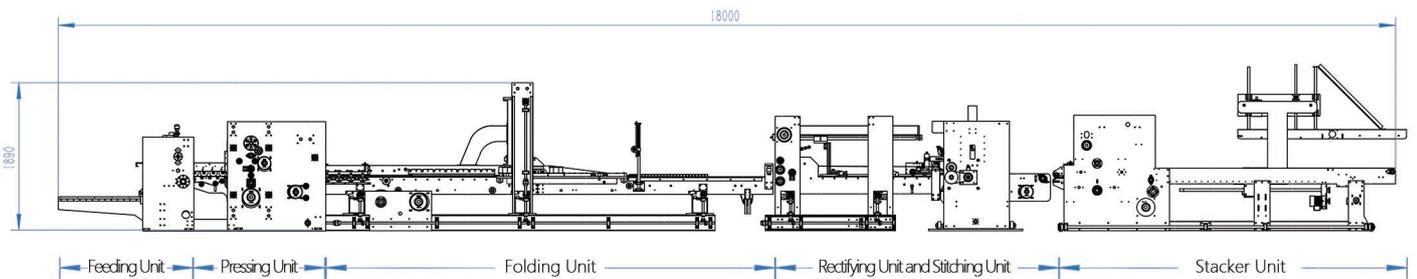
型号 Model	2400*1200	2600*1200	2800*1200	3000*1200
最大纸张尺寸(A+B)*2(mm) Max cardboard size (A+B)*2(mm)	2400	2600	2800	3000
最小纸张尺寸(A+B)*2(mm) Min cardboard size (A+B)*2(mm)	420	420	420	420
最大纸箱长 Amm Max carton length Amm	420	420	420	420
最小纸箱长 Amm Min carton length Amm	280	280	280	280
最大纸箱宽 Bmm Max carton width Bmm	650	650	650	650
最小纸箱宽 Bmm Min carton width Bmm	150	150	150	150
最大纸张高(W)(mm) Max paper height (W)(mm)	1200	1200	1200	1200
最小纸张高(W)(mm) Min paper height (W)(mm)	300	300	300	300
最大摇盖尺寸 E (mm) Max cap size E (mm)	430	430	430	430
最小摇盖尺寸 E (mm) Min cap size E (mm)	50	50	50	50
最大高度 F (mm) Max carton height F (mm)	700	700	700	700
最小高度 F (mm) Min carton height F (mm)	100	100	100	100

Carton data:mm

Stitching Unit



1. 3-5minutes setting,quickly to shift orders
2. Nail distance 30-90mm
3. One machine two functions, stitching & gluing
- 4.Suited for cover or without cover box
5. 20kg big wire feeder
6. Suited for 3/5layers, A B.C or AB flute
7. Fully set servo controlling system,stable nail distanceSquaring section,no fish tail





Feeding Section

- Belt vacuum transfer+ feeding rollers, which makes sure feeding precision
- Left and right side baffles are motorized adjustment
- The feeding belt tightness can be adjusted individually to avoid the feeding crookedly caused by loosen



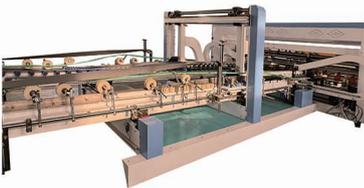
Individual Creasing Scoring Section

1. Individual creasing scoring parts for the 3ply(A B C flute), 5 ply, 7ply cardboard
2. Separate creasing scoring unite, Individual motor control. split.
3. This part compose by pre-creaser rollers, creaser rollers and forming rollers.
4. Innovative design rollers increase carton fold quality and avoid creaser split.



Second Precreasing Section

1. The cartons produced no fish tails and not Crush of Slot Edge of Corrugated Sheet.
2. The inner side of the cardboard box is driven by the power belt on the outside of the inclined rubber wheel, thereby effectively ensuring the precision of the cardboard box closure.



Folding Section

1. Imported wear-resistant rubber belt conveyor board, longer use;
2. Paperboard correction device and line pressing device, line pressing wheel adjustable suitable for paperboard thickness of 2-8mm



Rectifying Unit and Stitching Unit

1. Stitching head speed 1000nails/min
2. Servo motor control flap, speed fast accurately
3. Robot control after flap, control no fish tail
4. Auto wire feeder supply, save more time for feeding wire, increasing efficiency
5. Single nail, double nails, strengthen nail can be stitched one-time
6. Stitching distance 30mm-120mm can be adjusted by need

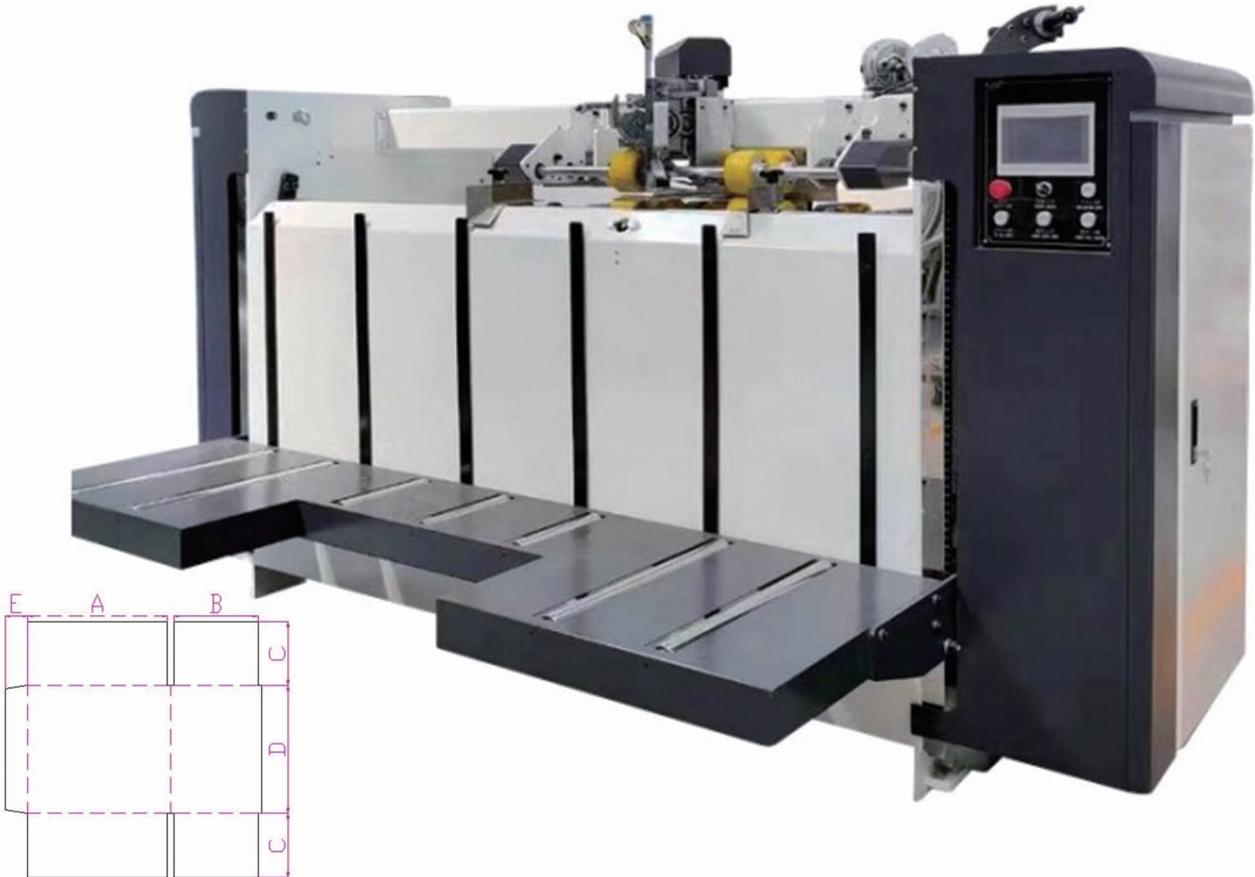


Counting Section

- The principle of counting and stacking is simple and reliable. The whole electric transverse movement of the stacking part ensures the stable output of the carton with large offset mouth



Semi-auto two piece stitching machine

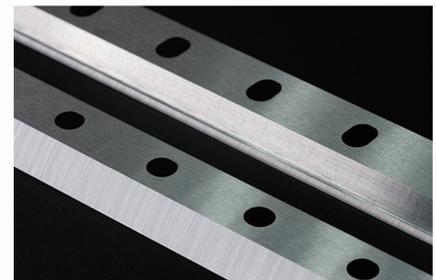


Model	2100(1600)	2600(2100)	3000(2500)	3500(3000)
Max sheet size(A+B) * 2(mm)	3200	4200	5000	6000
Min sheet size(A+B) * 2(mm)	1060	1060	1060	1060
Max sheet length A(mm)	1350	1850	2350	2850
Min sheet length A(mm)	275	275	275	275
Max sheet width B(mm)	1000	1000	1200	1500
Min sheet width B(mm)	140	140	140	140
Max sheet high(C+D+C)(mm)	2500	2500	2500	2500
Min sheet high(C+D+C)(mm)	350	350	350	350
Max cap size C(mm)	560	560	560	560
Min cap size C(mm)	50	50	50	50
Max high D(mm)	2000	2000	2000	2000
MIN HIGHT D(mm)	150	450	150	150
Max width E(mm)	40	40	40	40
Stitching pitch mm	30-120	30-120	30-120	30-120
Number of nails	1-99	1-99	1-99	1-99
Stitching speed(stitch/mim)	500	500	500	500
Machine weight(T)	2.5	20.8	3	3.5

Spiral knife Series

Introduction to properties of common mechanical blade steel!

Material			Hardness	Performance
D2	SKD11	X165CrMoV12	59-60°	uniceealcold working mold steel with good wear resistance and a service life of 10 to 15 million cuts
M2	SKH51		62-66°	It has high hardness, fine and uniform carbides, high toughness, good cutting performance, and a service life of 10 to 20 million cuts
M3		ASP-23	63-66°	The crystal is extremely fine, wear--resistant, and has high toughness, with a service life of 20 to 25 million cuts



Typical size

Cutter name	Specifications	Model
N.C Cutter	2275*40/36*10	JS
N.C Cutter	2543*30*8	BHS
N.C Cutter	2580*38/36*10	K&H
N.C Cutter	1900*52 /42.5*10	LIANHAUR
N.C Cutter	1890*40.5*10	WANLIAN
N.C Cutter	2330*38*10	HZJM
N.C Cutter	1890*39*8	JASTU
N.C Cutter	2600*35/32*10	KAI TUO
N.C Cutter	2642*31.7/31*9.5/8	MARQUIP
N.C Cutter	2300*38/35.5*10/9	HSIEH HSU



Common usage issues with spiral knives

1. First and second cutting.

① The installation of the knife is closely related, as the angle is not properly installed, resulting in the upper blade scraping the back of the lower blade.

② When the spiral cutter is combined, it must be on the horizontal line. If the upper and lower cutters are not on the same horizontal line, normal cutting cannot be performed.

2. Burst mouth

Most of them are electrical control issues, caused by excessive torque and instantaneous tool speed.

3. Cut continuously in the same place

The circumferential clearance between the two gears was not adjusted properly, resulting in

4. Continuous cutting in different places

The paper feeding speed on both sides of the production line is unstable. For example, if the speed drops from 55 Crpm to 600 rpm,

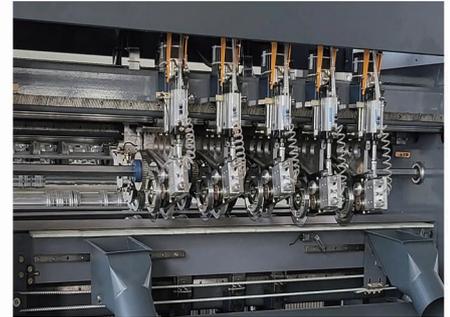
the speed is unstable, like stalling. If there is a difference of ± 5 yards, it will occur.



Tungsten Steel Knife Series

Typical size

Items	Common sizes OD*ID*T(mm)	Holes	Available for machine
1	φ230*φ110*1.1	6(孔 holes)*φ9	FOSBER
2	φ230*φ135*1.1	4 键槽 key slots	FOSBER
3	φ220*φ115*1	3(孔 holes)*φ9	AGNATI
4	φ240*φ32*1.2	2(孔 holes)*φ8.5	BHS
5	φ240*φ115*1	3(孔 holes)*φ9	AGNATI
6	φ250*φ150*0.8		PETERS
7	φ257*φ135*1.1		FOSBER
8	φ260*φ112*1.5	6(孔holes)*φ11	ORANDA
9	φ260*φ140*1.5		ISOWA
10	φ260*φ168.3*1.2	8(孔 holes)*φ10.5	MARQUIP
11	φ270*φ168.3*1.5	8(孔 holes)*φ10.5	HSIEH HSU
12	φ270*φ140*1.3	6(孔holes)*φ11	VATANMAKEINA
13	φ270*φ170*1.3	8(孔 holes)*φ10.5	YULI
14	φ280*φ160*1	6(孔 holes)*φ7.5	MITSUBISHI
15	φ280*φ202*1.4	6(孔 holes)*φ8	MITSUBISHI
16	φ265*φ170*1.5	8(孔 holes)*φ10.5	FOSBER
17	φ300*φ112*1.2	6(孔 holes)*φ11	TCY



Common problems in the use of corrugated paper vertical cutting knife

Problem 1: The short lifespan of corrugated board blades.

A. Is the grain size of the grinding wheel adequate? Too coarse a grain size of grinding wheel shortens the lifespan/performance time of blades

B. Excessive grinding: the grinding interval is too short or the grinding pressure is too high.

Problem 2: The edges of corrugated boards cut by blades show burrs and dents.

A. Please check the cutting edge of your blade. Is the cutting-edge sharp enough?

B. The corrugated board is too wet.

Problem 3: Breakage of blades.

A. incorrect assembly e a, deformed flange plate' wrong screwing will cause the breakage of blades.

B. Unstable swing grinding wheels break the blades; please check the bearing of the grinding wheels

C. The problem may be caused by collision with other hard objects.

Problem 4: Chips on the cutting edge after the grinding.

A. Unstable swing grinding wheels may cause this problem, even break the blades

B. A collision with hard objects may cause the chips on the cutting edge.

Problem 5: The edge of corrugated board is not straight

A. The hardness of the blade and corrugated board might not match



Guangzhou Smart Import & Export Co.,Ltd

Add: 611room 6 floor kaixuan building 56# zhongcun street panyu Guangzhou city ,China

Tel: +86-15632772928

Web: www.gz-smart machinery.cool

Whatsapp: 0086-15632772928

Email: info@gz-smartmachinery.com

Sarah@gz-smartmachienry.com

