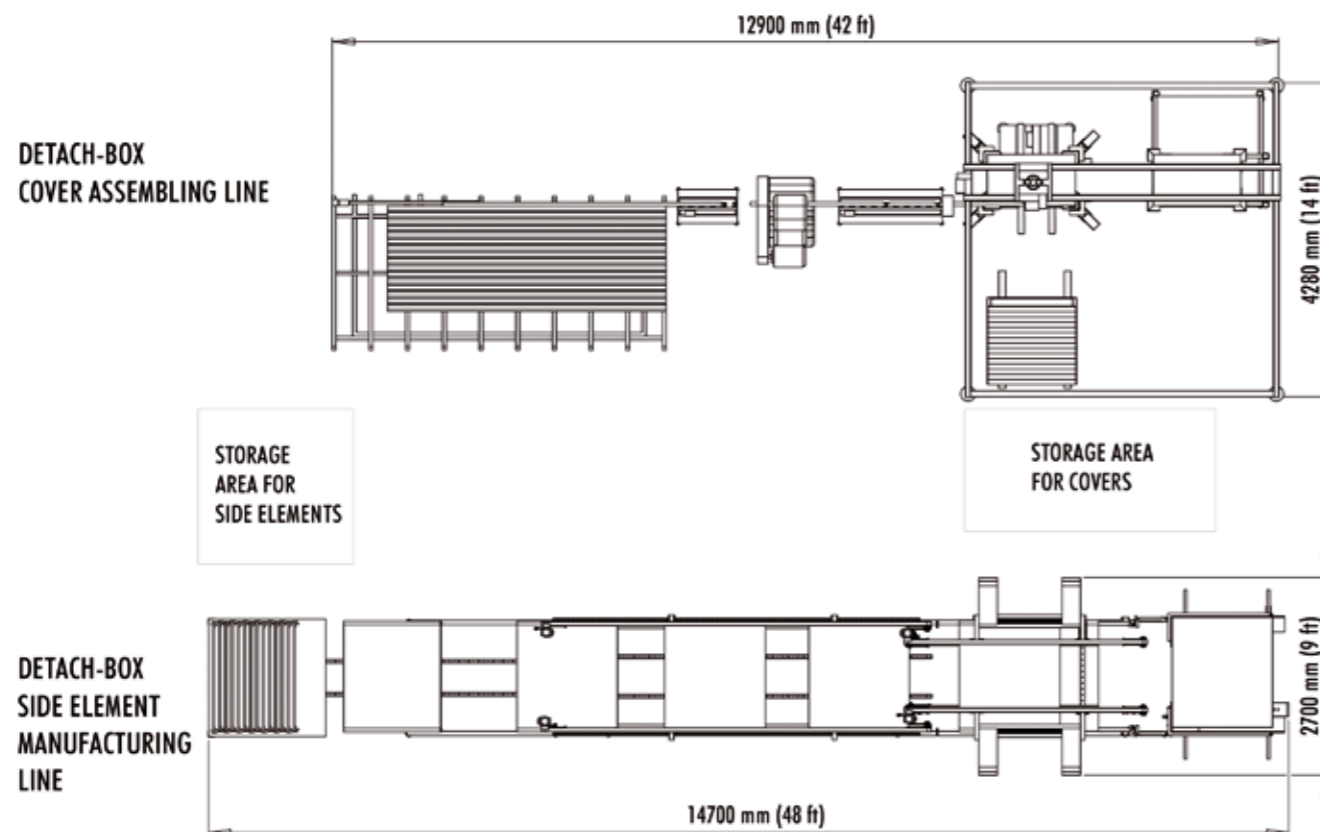


DB - 1400 FOR FLEXIBLE DETACH-BOX ELEMENT MANUFACTURING (CE-approved)

| Machine line type | Detach-Box element                 | Production capacity                              |
|-------------------|------------------------------------|--|
| DB - 1400         | Width 550 – 1400 mm (22 – 55 ")    | 500 mm (20 ") height box element 8 pcs / minute  |
|                   | Length 550 – 1500 mm (22 – 59 ")   | 1000 mm (39 ") height box element 4 pcs / minute |
|                   | Thickness 9 – 30 mm (0.35 – 1.2 ") | 1500 mm (59 ") height box element 3 pcs / minute |



ELTETE TPM LTD WORLDWIDE

Eltete TPM Engineering (as part of the Eltete TPM Group) is developing specific transport packaging materials, machinery and manufacturing technology for the transport packaging products that the Group itself manufactures. All machines, products and processes have been very well tested on the market, through the strong position of Eltete TPM Group as a global manufacturer and market leader in the transport packaging sector. Eltete TPM Engineering can offer its partners and customers a range of production concepts, machinery, manufacturing technologies and complete turnkey factory/manufacturing setups, specifically designed for Eltete TPM transport packaging materials and products.

Eltete TPM Group is a global group of companies, headquartered in Finland. Its main products are transport packaging materials (TPM) made of carton board, such as edgeboards, U-profiles, pallet runners and paper pallets. We are a global market leader in our main product sector, edgeboards. We convert more than 100,000 tonnes of paperboard every year, which goes into manufacturing our products. Today, we have a global operating structure, with local production in 14 countries, and sales to more than 50 countries. Please go to [www.eltete-tpm.com](http://www.eltete-tpm.com) for more information.

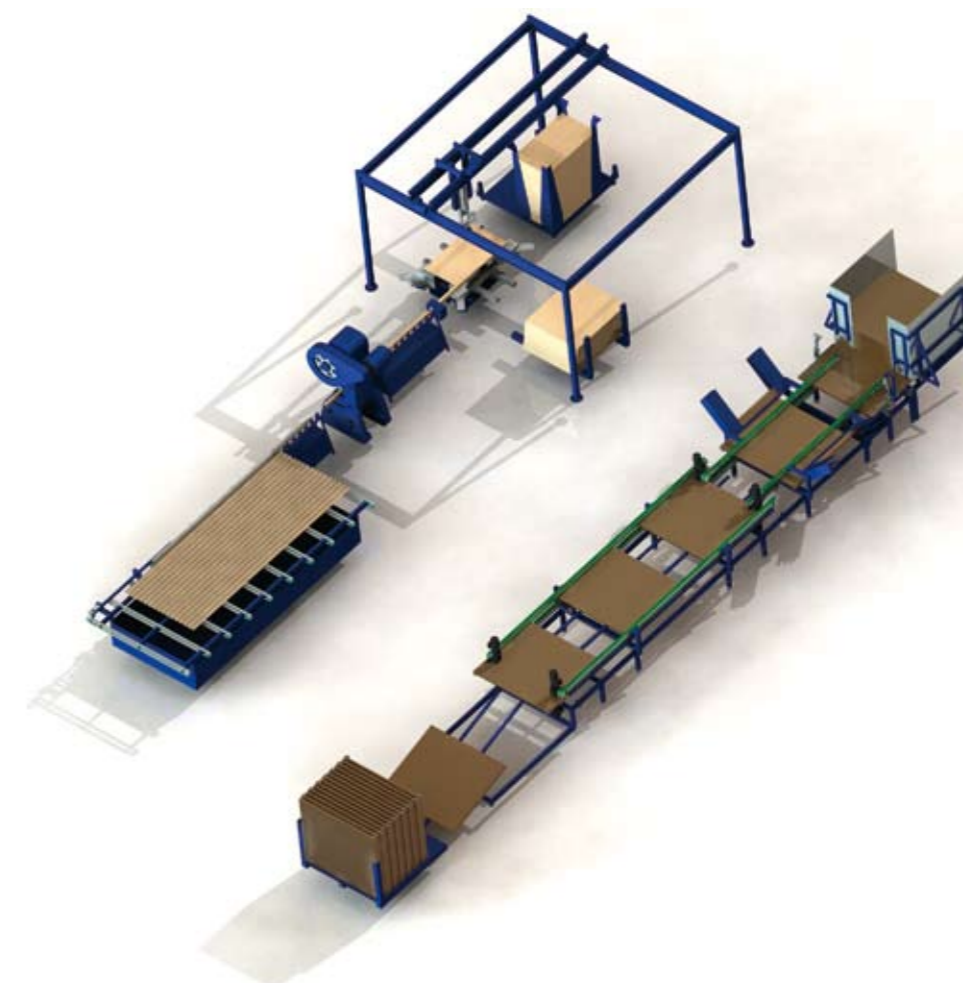


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# DB - 1400

for flexible detach-box element manufacturing

The optimal woodless packaging solution from Eltete TPM LTD.



Different solutions using detach-box packaging.



**HOISTING SYSTEM**

The HC boards are moved automatically on to the rotating jig-table by a hoisting system equipped with suction cups.

**COVER-ASSEMBLY MACHINE LINE**

**RACK FOR HC BOARDS**

The HC boards are guided to a certain position while stacking.

**ROTATING JIG TABLE**

On the rotating jig table, the HC board is held in position with suction cups, while edgeboard is rotated around it.

**STORAGE**

After the pressing process (done by the rotating jig table), the hoisting system lifts the cover off the jig table and lays it down in the storage area.

**GLUING UNIT**

In the gluing unit, edgeboard is sprayed with a combination of two glues: one holds the components in position immediately after they have been pressed together. The other takes more time to dry, but takes care of most of the stress after drying.

**SIDE-ELEMENT PRODUCTION LINE**

**DIE-CUTTING MACHINE**

"V"-shape slots are cut into the top of edgeboard, so that it can be bent into a square by the rotating jig table.

**RACK FOR HC BOARDS**

Can be used for thicknesses between 9 – 30 mm (0.35 – 1.2 "). Total stacking height is 750 mm (2.5 ft).

**COLLECTION AREA**

Edgeboards (manufactured and cut to a suitable length by the edgeboard machine line) are collected here. A feeder system sends the edgeboard to a die-cutting machine.

**GLUING UNIT**

Adhesive strips are simultaneously applied to both sides of the HC board. Pneumatic guns dispensing cold adhesive are equipped with nozzle covers, which prevent adhesive skinning over the nozzle when it is not dispensing.

**EDGEBOARD RACKS**

Adjustable for edgeboard lengths between 550 – 1500 mm (22 – 59 "), equal to the length of the HC board. Each rack has a stacking capacity of up to 90 edgeboards.

**EDGEBOARD FEEDER SYSTEM**

Each edgeboard is fed on to the HC board by an efficient PLC-controlled feeder system.

**STORAGE UNIT**

There are several ways to store Detach-Box elements. One way is to lift them on to a pallet, which can then be wrapped in strapping foil.

**PRESSING CONVEYORS**

After assembling the edgeboards into position on the glued HC board, Detach-Box elements go through the pressing conveyors at a rate of approximately one per minute. They are then ready for storage.

The entire right side of the production line follows the width of the HC board. This can vary between 550 – 1400 mm (22 – 55 ").

