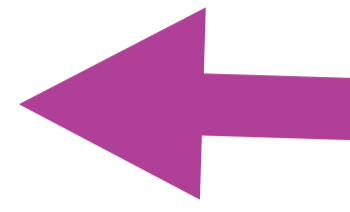
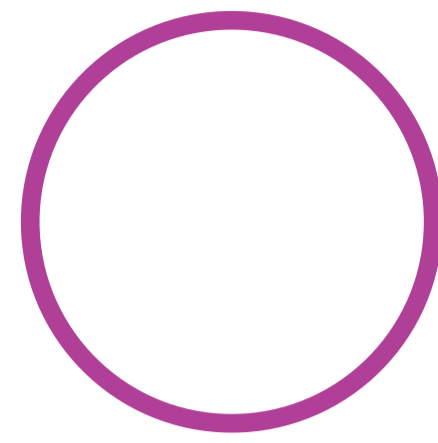


F7 DIGITAL BOX WRAPPER

LUXURY BOX PRODUCTION - LID AND BASE BOXES

PRODUCTION FLOW



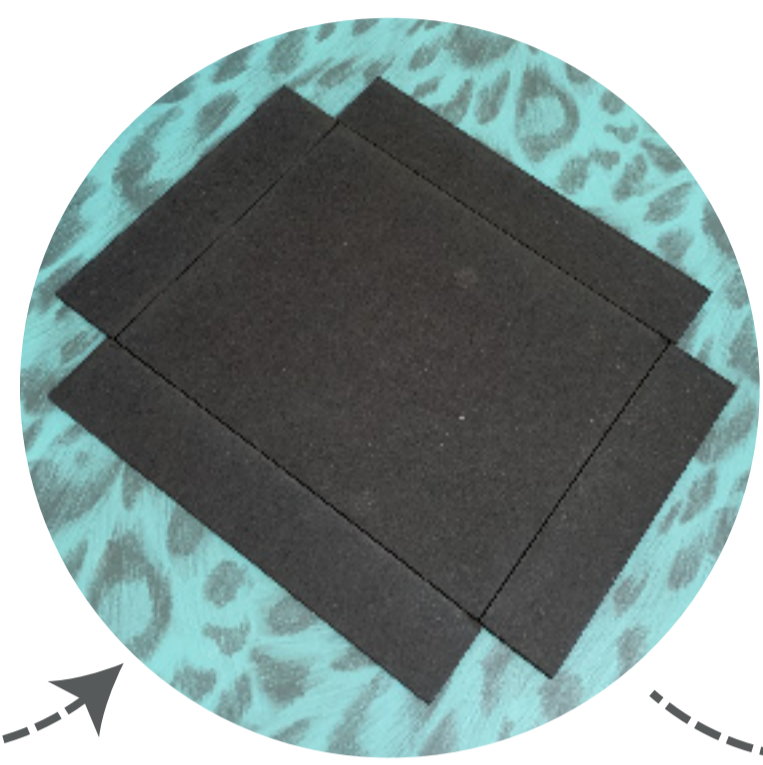
MACHINERY WE CAN SUPPLY FOR THIS PROCESS



TOOL/MOULD

You will need to 3D print or laser cut (from laser ply) your tools/moulds first. 3 pieces required: top, middle and bottom.

HQ9060
Laser Cutter
(same as ours)



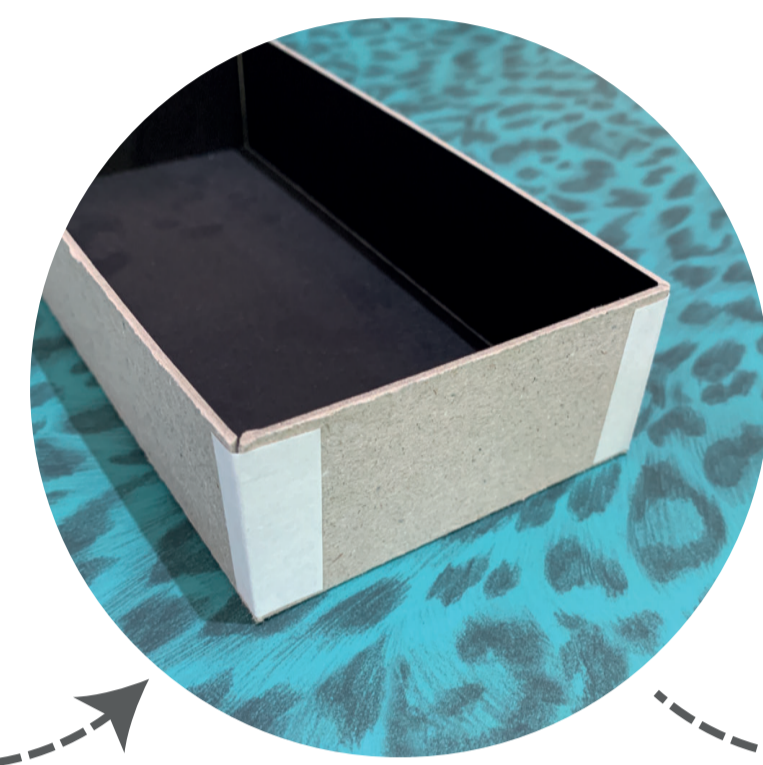
DIE CUT BOARD PREP

Having designed your box, cut out a sample to test using a plotter (Zund/Dyss etc) before getting dies made to ensure the design and size is correct.



FORMING & TAPING

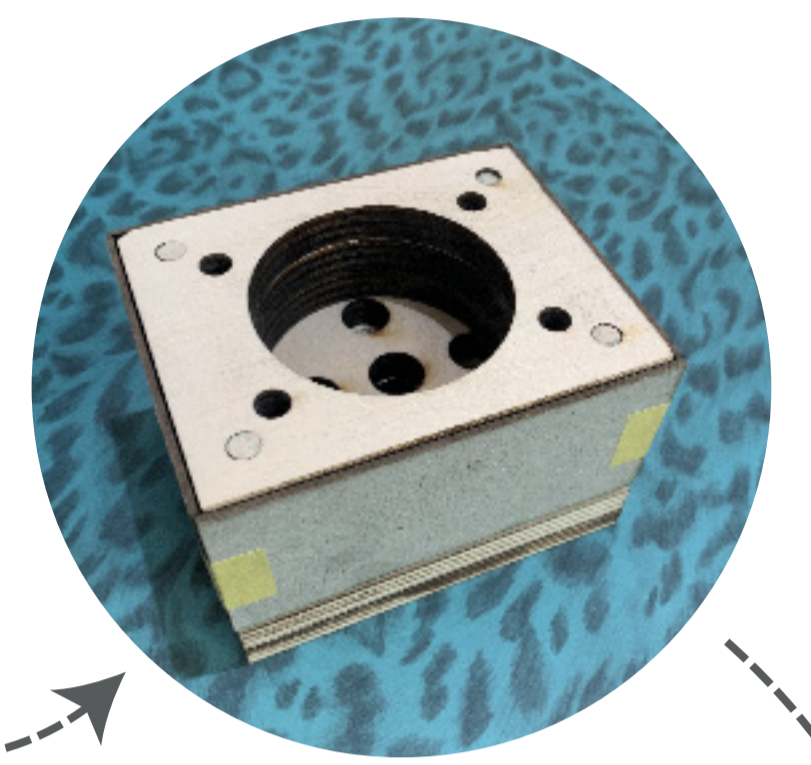
Fold the sides up and then tape them to form your box/slip case



BOX BLANK

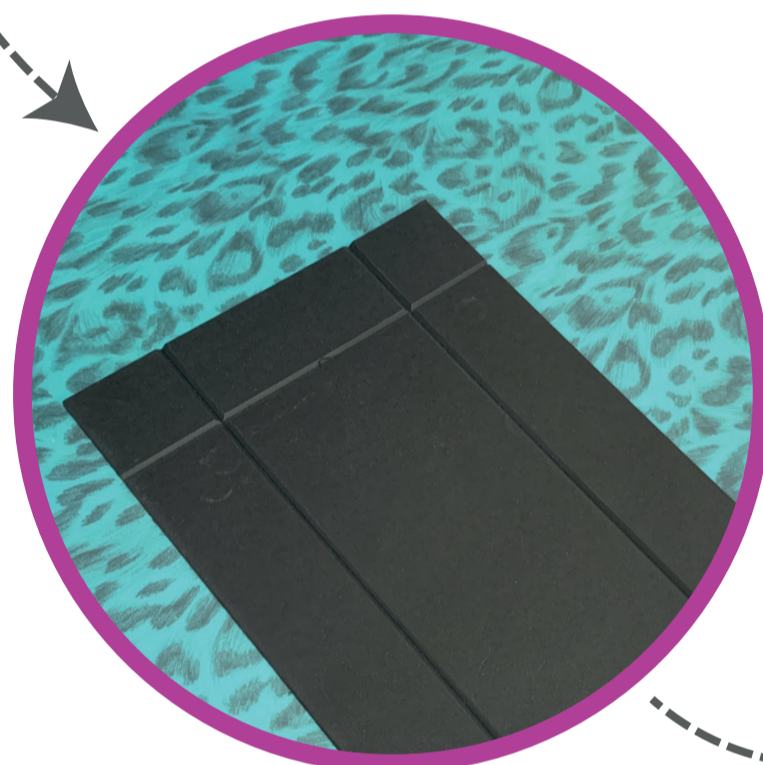
You now have a box blank ready for testing

Corner Taper
(1 corner at a time)



TOOL FITTING

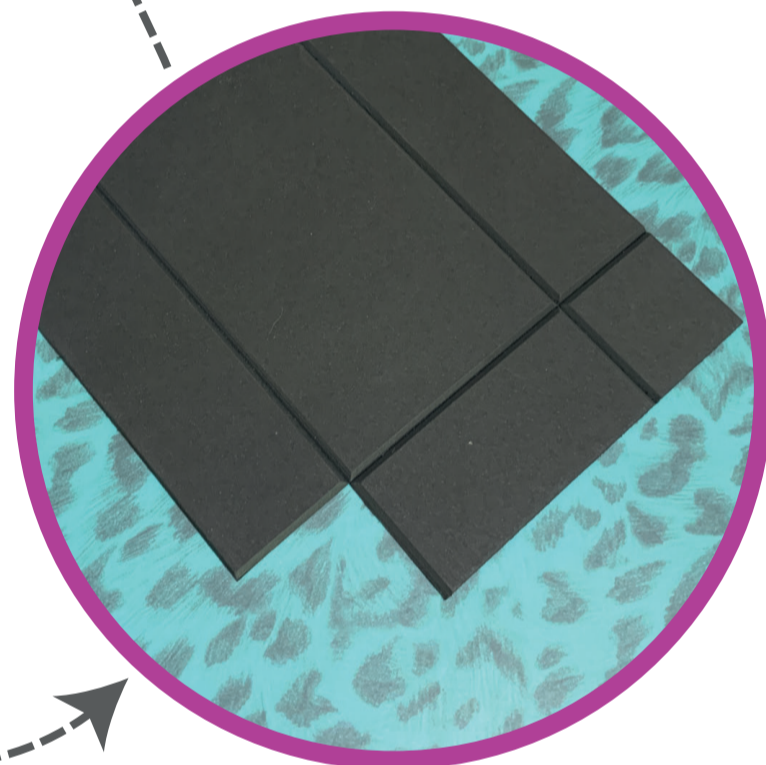
Check that your box blank is a nice fit onto your tool/mould. It needs to be able to slide in and out with ease. 0.5mm clearance should be fine.



GROOVED BOARD PREP

Having designed your box it's time to groove a couple of boards to ensure the design and size is correct.

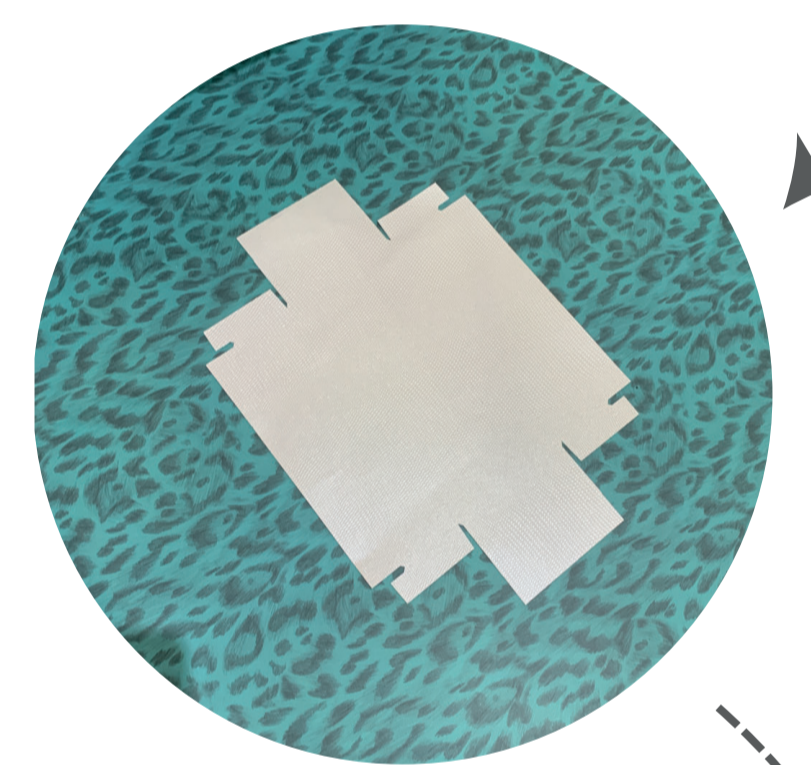
1000 Groover
(semi-auto)
or **1200B Groover**
(automatic)



GROOVED BOARD PREP

Once your board is grooved, you will need to remove the waste corners so that you can fold the sides up to form the box. Or kiss cut your boards first so the waste corners fall out.

Corner Cutter



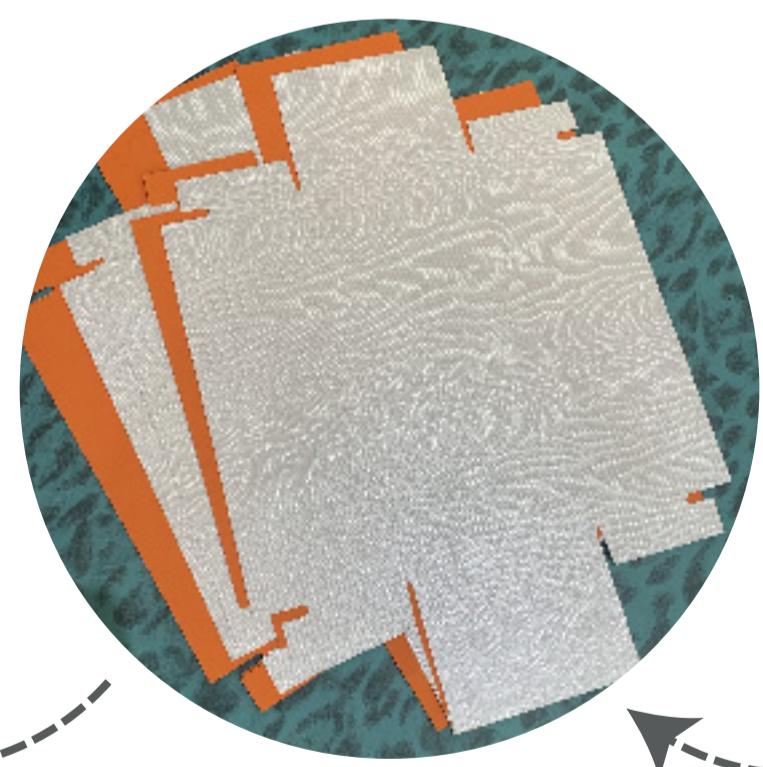
COVER MATERIAL PREP

Using a plotter, cut a couple of sheets out to test the sheet design. I use an Intec plotter, but Zund, Dyss, Kongsberg etc all work fine.



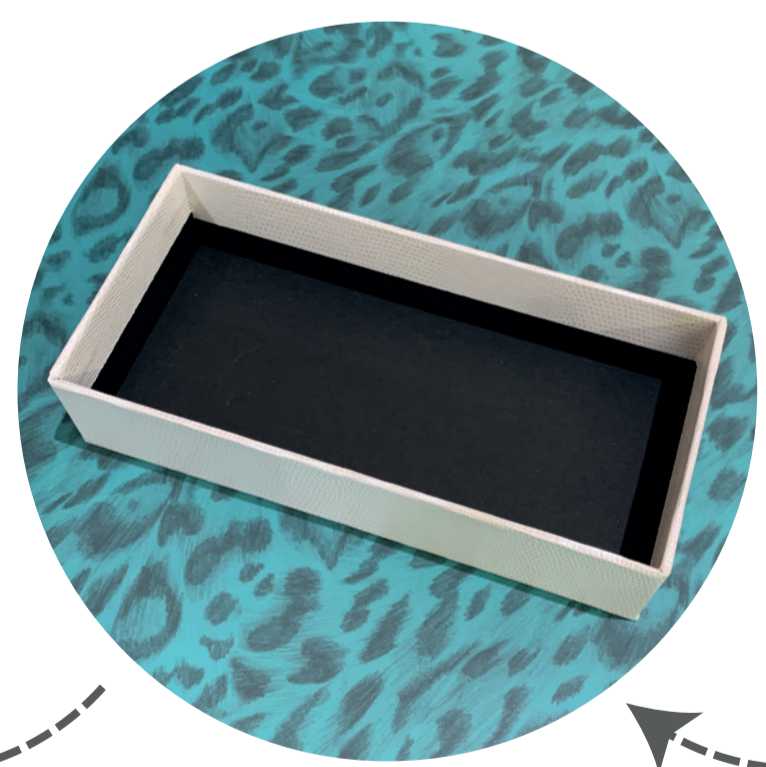
PRODUCTION COMPLETE

Your luxury boxes are now ready to be packed up and delivered to your customer!



DIES

Time to get your dies made if you are happy with the sheet design (and board design if you're not grooving the boards). Repeat the test processes for both lid and base to ensure they are a good fit and then repeat for a production run, rather than for testing > taping > gluing > wrapping etc.



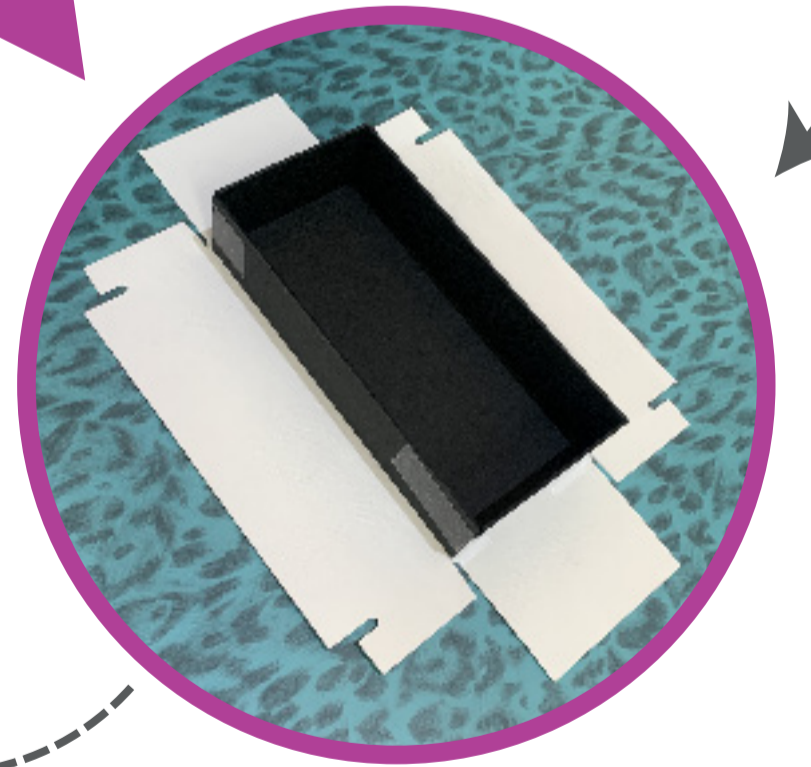
QUALITY CONTROL

You will now need to check the wrapped box to ensure no grey board is showing and that there isn't too much material on the inside tucking. If you have these issues, you will need to amend your design and do another test... keep testing until 100% happy



WRAPPING

Having set up the F7 and installed the tool/mould earlier, place the box blank and glued sheet onto the tool/mould and do a trial wrap.



GLUE

Glue out a sheet of cut cover material using hot animal glue, or vegan glue heated to 30°. Place the box onto the glued sheet in position.