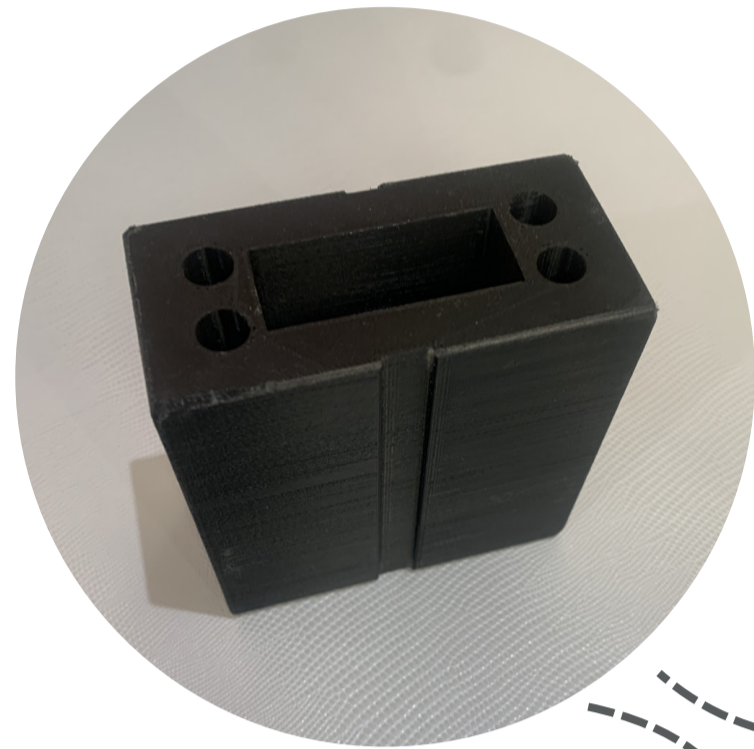


OPTIMUS PRIME

SLIP CASE AND BOTTLE BOX PRODUCTION FLOW CHART

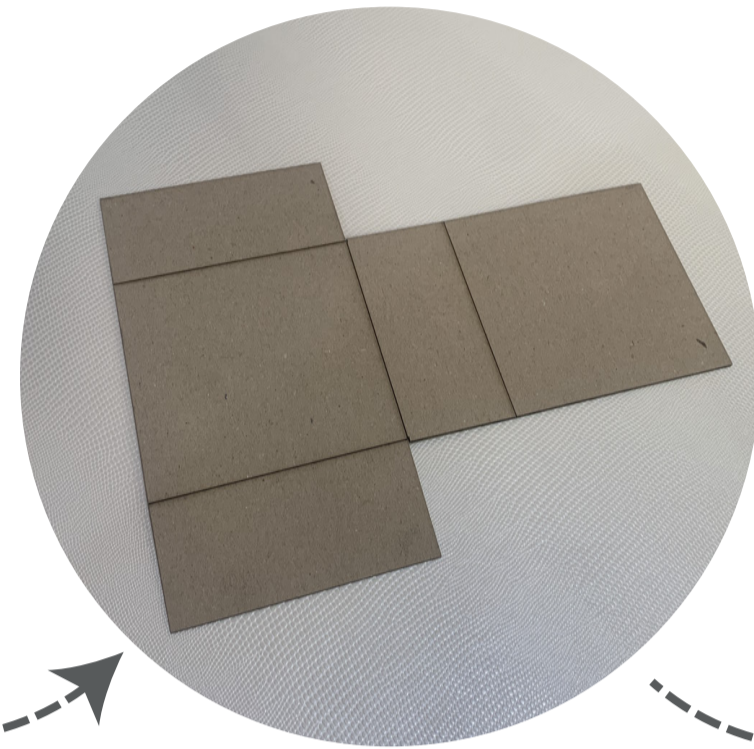
PRODUCTION FLOW

MACHINERY WE CAN SUPPLY FOR THIS PROCESS



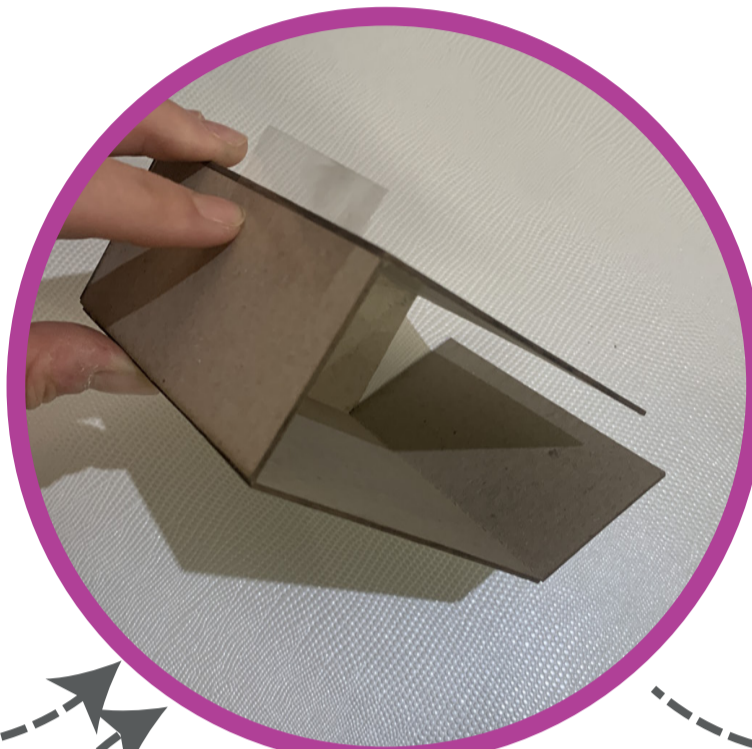
TOOL/MOULD

You will need to 3D print your tool/mould first.



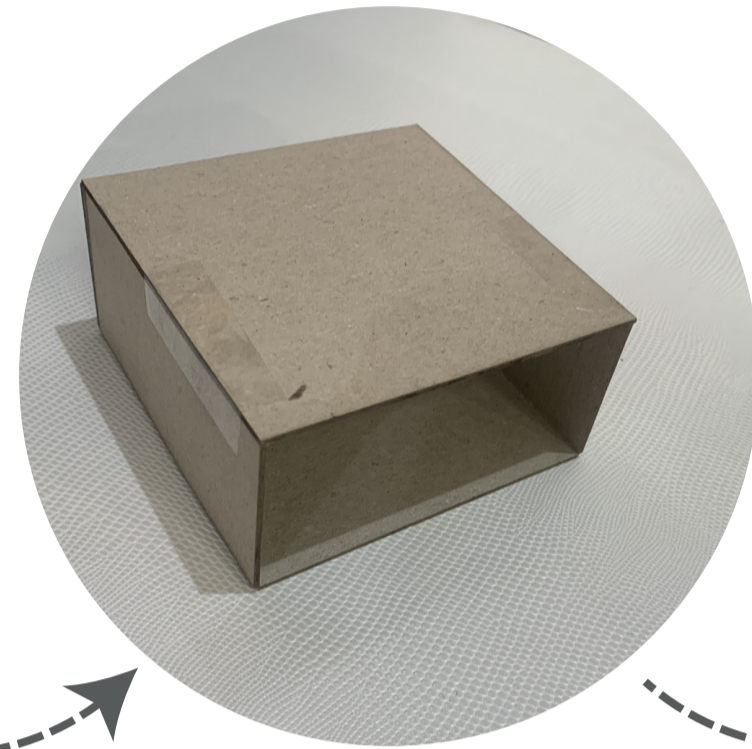
DIE CUT BOARD PREP

Having designed your box/slip case, cut out a sample to test on a plotter before getting dies made to ensure the design and size is correct.



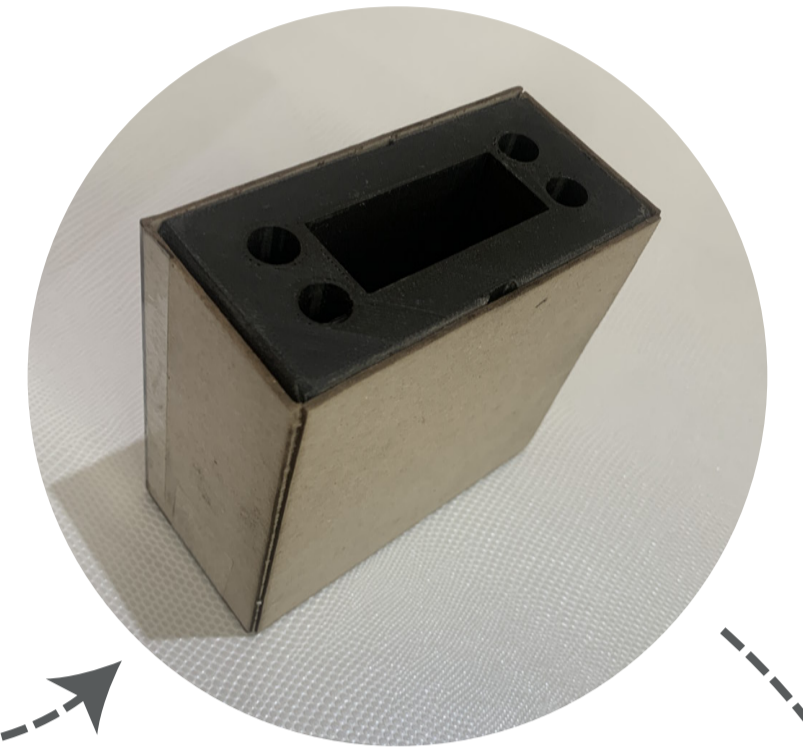
FORMING & TAPING

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



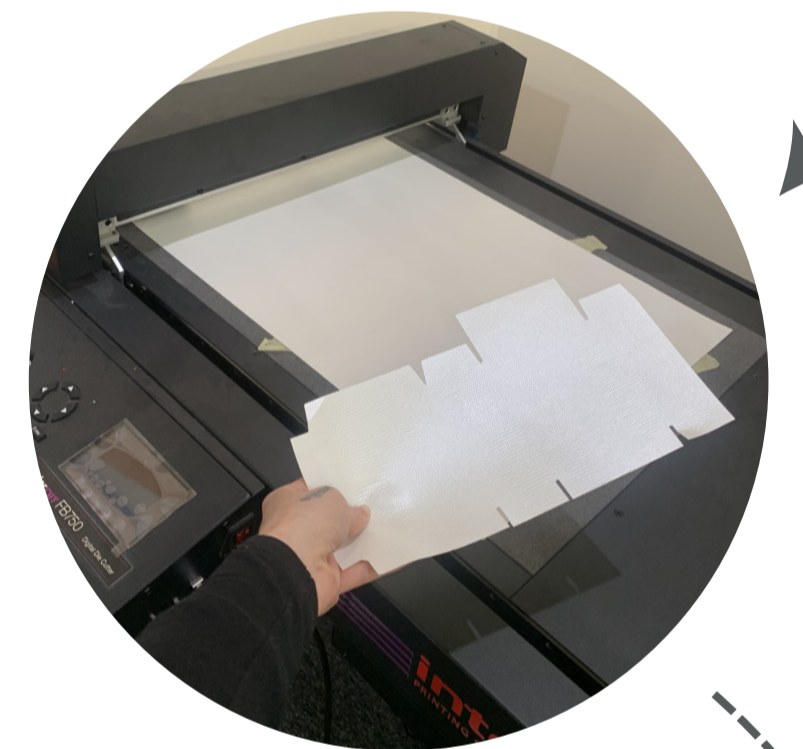
BOX BLANK

You now have a box blank ready for testing



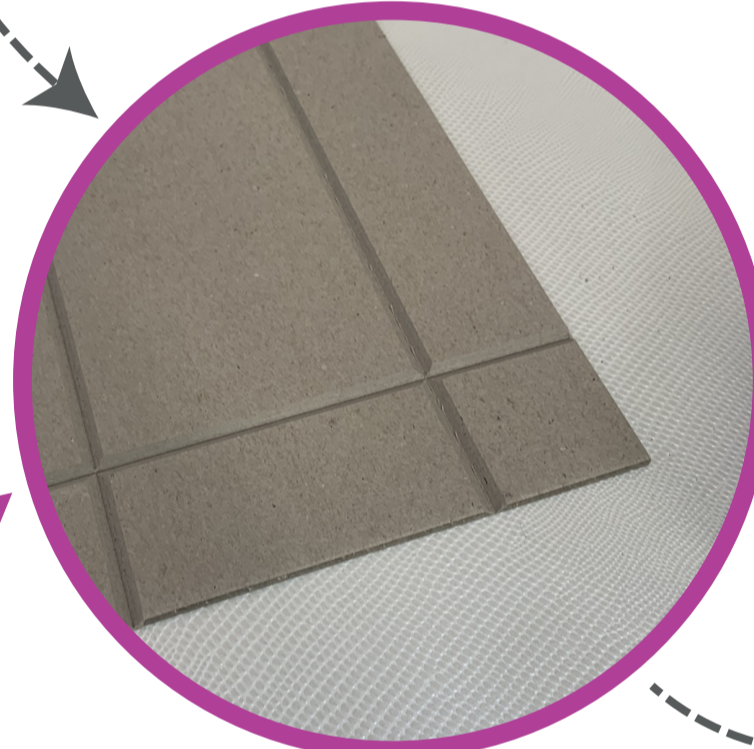
TOOL FITTING

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.



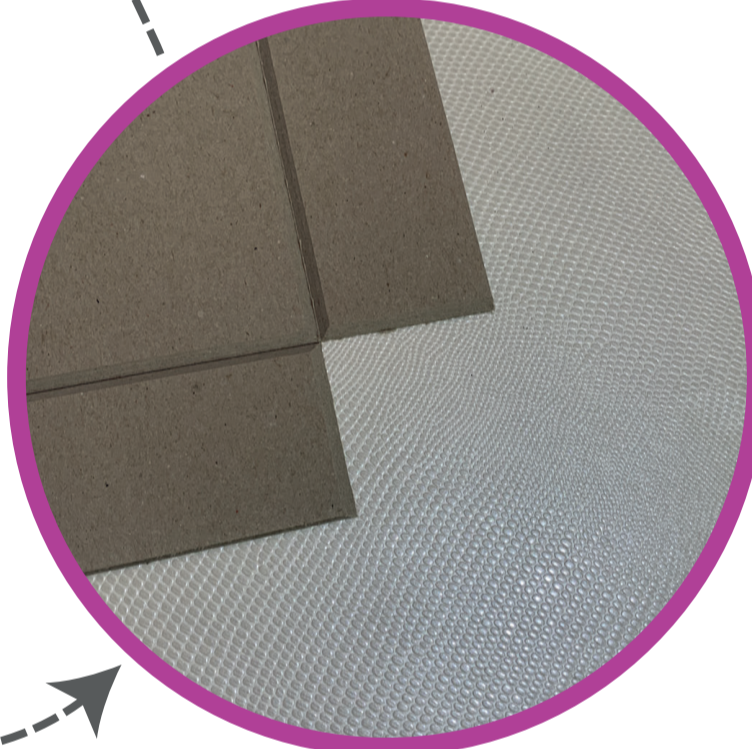
COVER MATERIAL PREP

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.



GROOVED BOARD PREP

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



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 slip case/bottle box

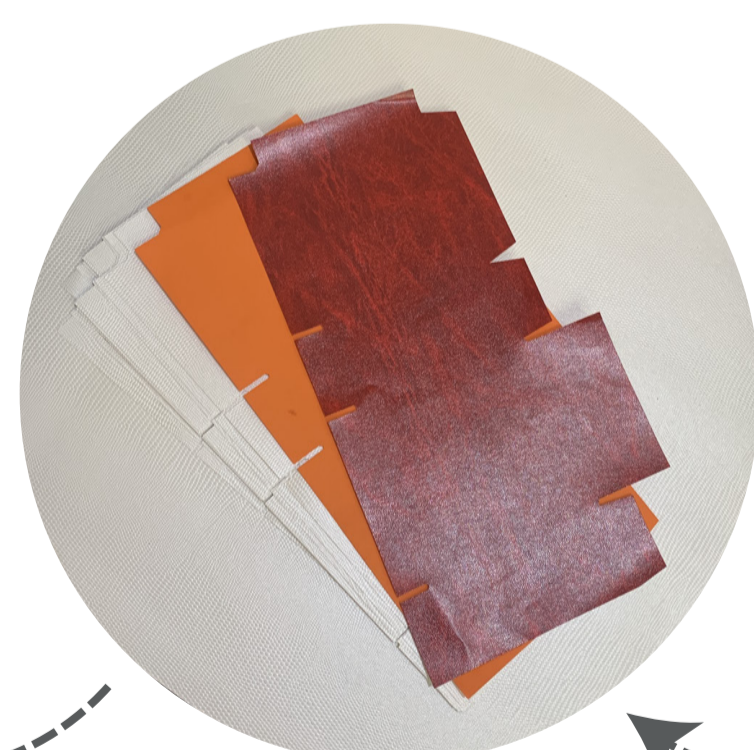
Optimus Prime

Gluing Machine (with viscosity)



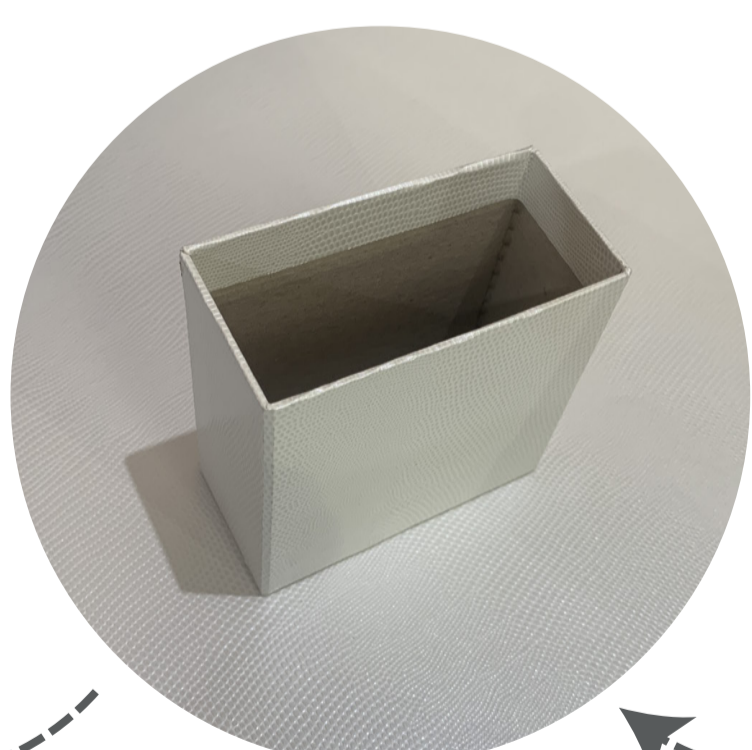
PRODUCTION COMPLETE

Your bottle boxes or slip cases are now ready to be packed up and delivered to your customer!



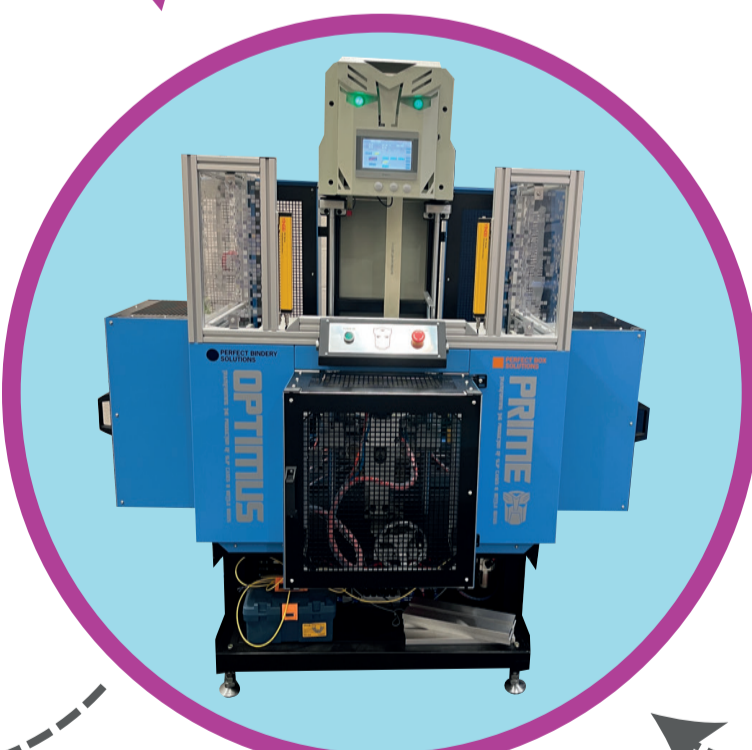
DIES

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 processes again for a production run, rather than for testing > taping > gluing > wrapping etc.



QUALITY CONTROL

You will now need to check the wrapped box/slip case 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 Optimus Prime and installed the tool/mould earlier, place the box blank and glued sheet onto the tool/mould and do a trial wrap. Inside tucking can be completed by hand or by using another machine specifically for this process.



GLUE

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