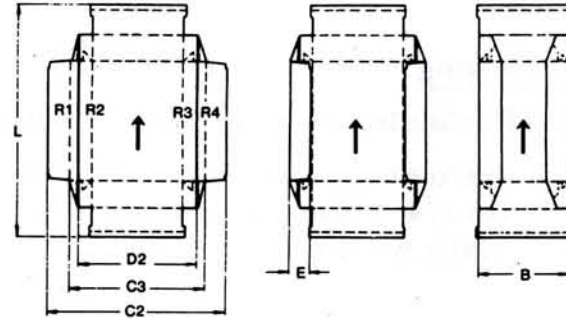
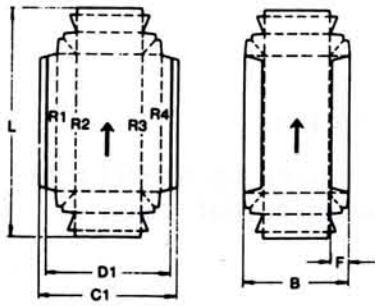


3. Double sidewall cartons

3.1 Conventional double sidewall cartons

3.2 Compound folded double sidewall cartons  
(corner gluing effect)



		B		C <sub>1</sub>	C <sub>2</sub>	C <sub>3</sub>	D <sub>1</sub>		D <sub>2</sub>		E*	F*	L	
		min.	max.	max.	max.	max.	min.	max.	min.	max.	min.	min.	min.	max.
DIANA 40-1	mm	60	370	400	400	340	75	390	75	320	30	15	85	750 <sup>+</sup>
	Inch	2 <sup>3</sup> / <sub>8</sub>	14 <sup>9</sup> / <sub>16</sub>	15 <sup>3</sup> / <sub>4</sub>	15 <sup>3</sup> / <sub>4</sub>	13 <sup>3</sup> / <sub>8</sub>	3	15 <sup>3</sup> / <sub>8</sub>	3	12 <sup>5</sup> / <sub>8</sub>	1 <sup>3</sup> / <sub>16</sub>	5/8	3 <sup>3</sup> / <sub>8</sub>	29 <sup>1</sup> / <sub>2</sub>
DIANA 70-1	mm	60	610	790	790	710	75	780	75	750	30	15	85	750 <sup>+</sup>
	Inch	2 <sup>3</sup> / <sub>8</sub>	24	31 <sup>1</sup> / <sub>8</sub>	31 <sup>1</sup> / <sub>8</sub>	28	3	30 <sup>3</sup> / <sub>4</sub>	3	29 <sup>1</sup> / <sub>2</sub>	1 <sup>3</sup> / <sub>16</sub>	5/8	3 <sup>3</sup> / <sub>8</sub>	29 <sup>1</sup> / <sub>2</sub>
DIANA 90-1	mm	60	610	915	915	710	75	905	75	840	30	15	85	750 <sup>+</sup>
	Inch	2 <sup>3</sup> / <sub>8</sub>	24	36	36	28	3	35 <sup>5</sup> / <sub>8</sub>	3	33 <sup>1</sup> / <sub>16</sub>	1 <sup>3</sup> / <sub>16</sub>	5/8	3 <sup>3</sup> / <sub>8</sub>	29 <sup>1</sup> / <sub>2</sub>

\* E max. =  $\frac{C_2}{6}$

\* F max. =  $\frac{C_1}{6}$

+ Compound folded double sidewall cartons: L max. = 600 mm (23 3/8")

General:

The borderline values of the size range and the board basis weight cannot in every case coincide in the same blank.

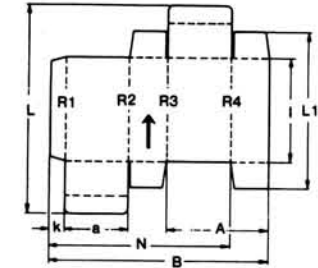
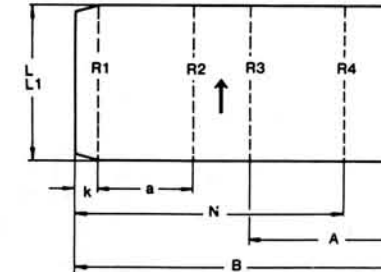
All statements made in this technical information bulletin are based on the present state of design and technology. We reserve the right to make technical alterations at any time without special notice.

For Great Britain, size limitations due to special guarding may have to be considered.

With these bulletins JAGENBERG inform the folding carton industry from time to time about new machines, new equipment and new methods.

Adjustment Ranges of the Folding Carton Gluers  
DIANA 40-1, DIANA 70-1 and DIANA 90-1

1. Conventional Folding Cartons



		a		a+k	A		B		k		l	L	L <sub>1</sub>	N	
		min.	max.	max.	min.	max.	min.	max.	min.	max.	min.	max.	min.	max.	
DIANA 40-1	mm	10*	25	190	20*	35	45*	75	400	5	40	40	750 <sup>+</sup>	55	390
	Inch	3/8	1	7 1/2	3/4	1 3/8	1 3/4	3	15 3/4	3/16	1 9/16	1 9/16	29 1/2	2 3/16	15 3/8
DIANA 70-1	mm	10*	25	360	20*	35	45*	75	790	5	40	40	750 <sup>+</sup>	55	720
	Inch	3/8	1	14 3/16	3/4	1 3/8	1 3/4	3	31 1/8	3/16	1 9/16	1 9/16	29 1/2	2 3/16	28 3/8
DIANA 90-1	mm	10*	25	360	20*	35	45*	75	915	5	40	40	750 <sup>+</sup>	55	760
	Inch	3/8	1	14 3/16	3/4	1 3/8	1 3/4	3	36	3/16	1 9/16	1 9/16	29 1/2	2 3/16	29 7/8

Prefolding in R1 up to 180° on all machines

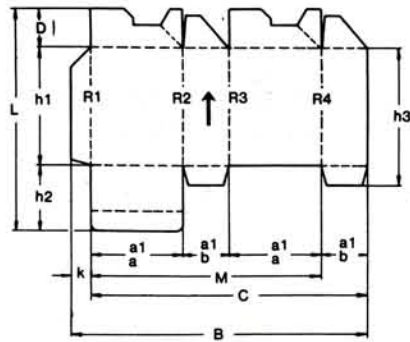
\* with miniature carton attachment

+ prefolding in crease line R3 limited when L is between 600 mm and 750 mm (23 3/8" and 29 1/2"). In this case, samples to be submitted.

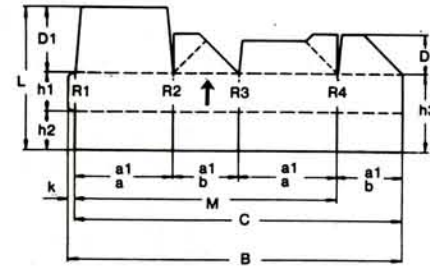


Adjustment Ranges of the Folding Carton Gluers  
 DIANA 40-1, DIANA 70-1 and DIANA 90-1

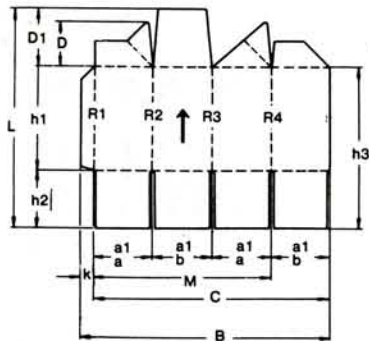
2. Lockbottom cartons



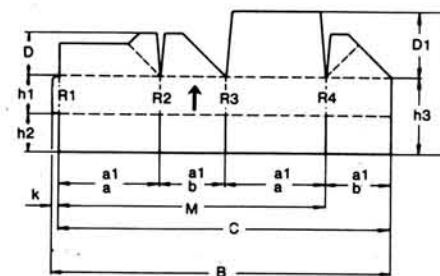
Conventional lockbottom carton



Lockbottom carton with reinforcing base panel Type I



Lockbottom carton with square cross section



Lockbottom carton with reinforcing base panel Type II

Limitations and supplementary information

1. a 1 applies only for lockbottom cartons with square cross section
2. Grain
  - 2.1 Should be at right angles to blank travel direction when  $h1 : C$  is greater than 1 : 4, i.e. 1 : 5, 1 : 6, etc.
  - 2.2 Should be parallel to blank travel direction when  $h1 : C$  is less than 1 : 4, i.e. 1 : 3, 1 : 2 etc. or the base flaps are shorter than 40 mm (1 1/2")
3. Prefolding
  - 3.1 Prefolding in R1 up to  $180^\circ$  without size limitation.
  - + 3.2 Prefolding in R3 up to  $180^\circ$  for lockbottom cartons up to 400 mm (15 3/4") blank length, up to a side ratio (carton height : open blank width) of 1 : 6
4. Maximum side ratio for  $h1 : C$  (carton height : open blank width)  
 1 : 6, if tuck-in unit is not used.  
 When using tuck-in unit, the maximum side ratio is 1 : 12 for the DIANA 70-1 and 90-1
5.  $h3$  is also valid for blanks without dust flaps.
6. For lockbottom cartons with reinforcing base panels Type I, the following limitation must be observed:

$$b \text{ min.} = 70 \text{ mm (2 3/4")}$$

		a	a	a1	b	B		D		D <sub>1</sub>		h1	h2	h3	k		L	M	
		min.	max.	min.	min.	min.	max.	min.	max.	max.		min.	max.	min.	min.	max.	max.	max.	
DIANA 40-1	mm	60	165	45	30	190	400	22	75	100		50	1.6 · h3	55	10	40	750 <sup>+</sup>	360	DIANA 40-1
	Inch	2 3/8	6 1/2	1 3/4	1 3/16	7 1/2	15 3/4	7/8	3	4		2	1.6 · h3	2 3/16	3/8	1 9/16	29 1/2	14 3/16	
DIANA 70-1	mm	60	370	45	30	190	790	22	150	175		50	1.6 · h3	55	10	40	750 <sup>+</sup>	700	DIANA 70-1
	Inch	2 3/8	14 9/16	1 3/4	1 3/16	7 1/2	31 1/8	7/8	5 7/8	6 7/8		2	1.6 · h3	2 3/16	3/8	1 9/16	29 1/2	27 1/2	
DIANA 90-1	mm	60	400	45	30	190	885	22	150	175		50	1.6 · h3	55	10	40	750 <sup>+</sup>	720	DIANA 90-1
	Inch	2 3/8	15 3/4	1 3/4	1 3/16	7 1/2	34 7/8	7/8	5 7/8	6 7/8		2	1.6 · h3	2 3/16	3/8	1 9/16	29 1/2	28 3/8	