Flexo Printer Slotter Die-cutter
Top Printing Machine
Guangdong Dongfang Precision Science and Technology Co., Ltd (Dongfang Precision), established in 1996 and listed on the A-share in Shenzhen Stock Exchange Market in August 2011. The headquarter is located in Foshan City, Guangdong, China. The new facility ground size is 120,000 square meters and has over 1,200 employees in the world.

Dongfang Precision is a high-tech listed company committed to the manufacturing of digital and intelligent high-end equipment for “Intelligent Packaging”, “Intelligent Automation” and “High-End Core Components”. The main products of “Intelligent Packaging” include high-end corrugated line, corrugated converting machine and peripheral equipments. Besides, intelligent storage and transfer robot for “Intelligent Automation” and outboard motor, engine etc for “High-End Core Components”.

Experience accumulated for many years, Dongfang Precision now is the first comprehensive solution provider for intelligent packaging and logistics system in this industry and has established worldwide network of sales, marketing and services, be able to provide the machinery, solution and technical expertise for the corrugated line, fully automatic corrugated converting line and intelligent storage logistic management in more than 40 countries and regions around the world. Dongfang Precision is the leading brand in China by its absolute comprehensive competitiveness and ranked top 5 brands globally.

By merger and acquisition and strategic cooperation establishment, Dongfang Precision has achieved global wide development, full industrial chain extension and strategic transformation. Through the cooperation with FOSBER Group (Italy) and set up joint venture company Foster (Asia), to develop and produce high-end corrugated line for Asian market (especially for China and India), so as to achieve successfully the branding of Foster expanded worldwide further, Wholly-owned acquisition of EDF Europe s. r. l. in 2016 and provide the automatic peripheral equipment for corrugated flexo printing machine; Cooperated with Jaten Robot in 2014 and Ferretto Group (Italy) in 2015, establish a joint venture company with Ferretto to provide total solutions, which covers from intelligent packaging to intelligent storage logistics system, to global customers. Dongfang Precision is leading the development and upgrading of Chinese manufacturing industry to intelligent automation.

With the solid base of integration of intelligent packaging industrial chain, Dongfang Precision is facilitating a full scope of intelligent logistics industrial chain and leading the intelligent transformation of Chinese industry towards "Chinese Intelligent Manufacturing", to eventually achieve its strategic vision of "Intelligent Packaging, Intelligent Plant and Intelligent Manufacturing Solution Provider".

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**Top Printing Machine**

- **TOPRA GD Flexo Printer Slotter Die-cutter**
  — Top Printing, Gear drive, Vacuum Sheet Transfer
  07/08

- **TOPRA AD Flexo Printer Slotter Die-cutter**
  — Top Printing, Gear Drive, Roll-to-roll Sheet Transfer
  09/10

**Folder Gluer**

- **TOPRA FG for Top Printing Machine**
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**Stacker**

- **Standard Stacker**
  13

- **Automatic Stacker**
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- **Standard Vibrator Stacker**
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- **Automatic Vibrator Stacker**
  16

**Peripheral Equipment**

- **Pile Turner**
  17

- **Prefeeder**
  18
- Whole-owned acquisition of EDF Europe s.r.l. and established Dongfeng R&D and Sales Center in Europe.
- Looking forward to the future, Dongfeng will develop towards the directions of “Intelligent Packaging”, “Intelligent Plant” and “Intelligent Manufacturing”, continue to make new history.

In 2015
- Cooperated with Ferretto Group and established a joint venture company to provide turnkey solutions of intelligent storage logistics system to the global customers.
- Cooperated with Suzhou Parson Power and entered high-end equipment manufacturing industry.

In 2014
- Cooperated with FOSBER Group and established the joint venture company: Guangdong Fosber Intelligent Equipment CO., LTD to provide high-end corrugated paperboard production lines to the Asian market (especially the Chinese and Indian market).
- Cooperated with JATEN ROBOT and marched towards the intelligent robot industry.
- Successfully launched the three new inline products which developed by the China- German and European team of Dongfeng: APSTAR IAG2, RDC Converting Line, APSTAR HG2, FFG Inline and TOPRA GD FF Inline to the international market.

In 2013
- We developed automatic flexo folder gluers for bottom printer (BFG).
- Started the acquisition of 60% stake of FOSBER (Italy).
- Together with EDF Europe s.r.l. to develop fully automatic production line (FlexyFeed, IFP, PRM, FLEXYPAL) and put on the domestic market.

In 2012
- Global initiative for successful research and development on eight color printer die-cutter equipment in top flexo printing - TOPRA PD-S.
- Took on the science and technology plan projects of Guangdong province - The key technology and application demonstration of numerical control packaging and printing machinery products.

In 2011
- Dongfeng went public in A share stock market successfully.
- We were identified as Guangdong Provincial Enterprise Technology Center.

In 2010
- We developed top printer slitter die-cutter with gear drive and vacuum transfer (TOPRA GD).
- We developed top printer slitter die-cutter with independent servo motor drive, unit fixed and vacuum transfer (TOPRA FD).
- We developed bottom fixed printer with independent servo motor drive and vacuum transfer (APSTAR HBL).
- We developed automatic Flexo Folder Gluer for top printer (TFG).
- We have been given the title of National High-Tech Enterprise.

In 2009
- We developed top printer slitter die-cutter with independent servo motor drive and vacuum transfer.

In 2008
- We developed bottom printer slitter die-cutter with independent servo motor drive and vacuum transfer.

In 2005
- We applied technology of servo motor drive to die-cutter unit.

In 2003
- Our products were sold to Europe market and launched in the international market.

In 1998
- We developed the first top board printer slitter die-cutter with lead edge feeder and vacuum transfer in China.

In 1997
- We developed the first printer slitter die-cutter with kick feeder.

In 1996
- We developed the first flexo printer.
**Features:**
Produced by Panasonic design philosophy and CE certified, TOPRA GD features movable units, vacuum sheet transfer for accurately presenting of printing paper on the board, with one-piece glass-plate printing register. Optional drying devices of Hot Air, IR or UV facilitate full screen coated paper printing. Touch screen PLC is equipped for frequent order store, remote maintenance and fast trouble shooting. Automatic lubrication system keep lubricant of all units at the same level. Furthermore, central dust-collecting system is installed.
Applicable to screen printing on coated paperboards or normal printing on kraft paperboards.
Adaptable to inline work with register or folder glazer.

**Feeder Unit**
- Continuous and skip feeding are available.
- Edge feeder with adjustable feed stroke.
- Variable frequency control driven vacuum suction and pressure to match different sizes of paperboard.
- Integral vacuum sheet cleaner with two rows of brushes for removing dust from the print surface of the paperboard.
- Roll to Roll transfer (Standard). Vacuum transfer (Optional).
- Vacuum Transfer for stable feeding (Optional).

**Printer Unit**
- Vacuum transfer system with rollers.
- Matttchless or quick-look plate mounting system (Alternative).
- Printing registration accuracy ±0.5mm.
- Doctor blade (single or double) auto roller ink nip system.
- Recyling system of double-acting diaphragm pump to supply maximum ink.
- Auto washing system included with wash-while-run capability for fast and efficient ink cleanup.
- Auto register reset system after printing plates are cleaned.
- Ink saving function: 0.5%-1.0% of ink can be saved each time when change or wash the ink (for roll to roll ink nip system).
- Highly-efficient and environment-protective recycling system of dual ink pump and doctor blade. Ink on anilox roll and doctor blade can be reclaimed and washed in short time (10 minutes), saving water resources.
- Inter-changeable Hot Air dryer or IR dryer can be installed in each printer unit (Optional).
- Special processing technique applied on impression roll for better feeding accuracy.
- Printing plate deviation correction device (Optional).

**Single-Shaft Slutter Unit**
- Single shaft with double knives, the internal gear drive adjusts the height of the box and prevents the lubricant oil from spilling or leaking onto the paperboard.
- The slitting box moves along linear bearing driven by lead screws for more flexible and precise movement.
- The structure of the glue tab knives can cut 3-layer or 5-layer paperboard without adjustment.
- Pre-cutter and creaser to minimize score cracking and promote better folding accuracy.
- Hand hole-punching dies are available.
- Single Shaft Double Creaser (Optional). Normal Creaser plus Big Creaser may optimize creasing on thick and heavy paperboard, results in better folding.

**Single-Shaft with Double Creasers Slutter Unit (Optional)**
- Single shaft with double creasers, improve the box shaping and folding.
- The slitting box moves along linear guides driven by lead screws for more flexible and precise movement.
- The structure of the glue tab knives can cut 3-layer or 5-layer paperboard without adjustment.
- Highly-efficient and environment-protective recycling system of dual ink pump and doctor blade. Ink on anilox roll and doctor blade can be reclaimed and washed in short time (10 minutes), saving water resources.
- Inter-changeable Hot Air dryer or IR dryer can be installed in each printer unit (Optional).
- Special processing technique applied on impression roll for better feeding accuracy.
- Printing plate deviation correction device (Optional).

**Die-cutter Unit**
- Quick die mount system (Optional).
- Side to side oscillation of anvil cylinder (50mm).
- Anvil trimming device keeps surface of anvil cover flat and smooth. Automatic speed compensation control of anvil drum keeps cartons and die cutting plate identical.
- Independent motor drive compensation-speed of anvil drum at range of ±3mm when printing of normal cartons is performed.

**Specifications subject to change without advance notification.**
Features:
Produced by European design philosophy and CE certified, TOPRA AD features movable units and roll-to-roll sheet transfer. With a remarkable ink saving function, the machine is energy-efficient. Touchscreen PLC is equipped for frequent order storage, remote maintenance and fast trouble shooting. Gap adjustment of pull rolls, impressing rolls, rubber rolls and anvil rolls applies self-lock. Automatic lubrication system keeps lubricant of all units at the same level.

Specifications subject to change without advance notification.

<table>
<thead>
<tr>
<th>Item</th>
<th>Model</th>
<th>TOPRA AD290</th>
<th>TOPRA AD924</th>
<th>TOPRA AD1224</th>
<th>TOPRA AD1228</th>
<th>TOPRA AD1624</th>
<th>TOPRA AD1628</th>
<th>TOPRA AD1632</th>
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<td>250</td>
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</table>

**Feeder Unit**
- Continuous and skip feeding are available.
- Load edge feeder with adjustable feed stroke.
- Variable frequency drive control of vacuum suction and pressure to match different sizes of paperboard.
- Integral vacuum shaft cleaner with two rows of brushes for removing dust from the print surface of the paperboard.

**Printer Unit**
- Roll-to-roll sheet transfer.
- Matthews or quick-lock plate mounting system (Alternative).
- Printing registration accuracy: 2.0, 5.5mm.
- Doctor blade (chamber or single) or Roll-to-roll inking system.
- Dual diaphragm pump for ink supply (Doctor blade inking system).
- Single diaphragm pump for ink supply (Roll-to-roll inking system).
- Auto washing system included with wash-white-run capability for fast and efficient ink cleanup.
- Auto register reset system after printing plates are cleaned.
- Ink saving function: 0.4-0.5kg of ink can be saved each time when change or wash the ink (for roll to roll inking system).
- Quick-set pull collars.

**Single-Shaft Slitter Unit**
- Single shaft with double knives, the internal gear drive adjust the height of the box and prevents the lubricant oil from splashing or leaking onto the paperboard.
- The slotting boss moves along linear bearing driven by lead screws for more flexible and precise movement.
- The structure of the glue tab knives can cut 3-layer or 5-layer paperboard without adjustment.
- Pre-creeper and creeper to minimize score cracking and promote better folding accuracy.
- Hand hole-punching dies are available.
- Single Shaft Double Creaser (Optional). Normal Creaser plus Big Creaser may optimize creasing on thick and heavy paperboard, results in better folding.

**Single-Shaft with Double Creasers Slitter Unit (Optional)**
- Single shaft with double creasers, improve the box shaping and folding.
- The slotting boss moves along linear guides driven by lead screws for more flexible and precise movement.
- The structure of the glue tab knives can cut 3-layer or 5-layer paperboard without adjustment.
- Pre-creeper, big creaser and creeper to improve the creasing quality, minimize score cracking and promote better folding accuracy.
- Hand hole-punching dies are available for option.

**Die-cutter Unit**
- Quick die mount system (Optional).
- Side to side oscillation of anvil cylinder (50mm).
- Anvil trimming device keeps surface of anvil cover flat and smooth. Anvil drum speed can be controlled to keep cartons and die cutting plate identical.
- Independent motor drive compensates speed of anvil drum at range of 1:3 when printing of normal cartons is performed.
Features:
- Folder Giler for top printing machine.
- New Design Concept: Real thickness pressure adjustment for no crush box transportation, not necessary manual adjustment, especially at the cardboard thickness change.
- Top transfer belts combined with pulley section and vacuum section.
- Bottom transfer belts driven by the independent motors for precise sheet control.
- New “Sandwich Belts” and “Side Squaring Belts” improve the flatness and gap on box.
- Glue emission system: VALCO ERO (Optional).
- Counter ejector is driven by the servo motors which control the quantity of the papers accurately.

Models Suited to TOPRA FG
- TOPRA GD: 920, 924, 1224, 1228
- TOPRA AD: 920, 924, 1224, 1228

Main Specification

<table>
<thead>
<tr>
<th>Item</th>
<th>Model</th>
<th>FG 2000</th>
<th>FG 2400</th>
<th>FG 1224</th>
<th>FG 1228</th>
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<tr>
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<td>Glue flap side 130</td>
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<td>&lt;45</td>
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</table>

Specifications subject to change without advance notification.

Coating(ges/pc bundle): 5, 10, 15, 20, 25, 30
Max. machine speed:
5 pcs: 1200(pcs/min)
10 pcs: 2500(pcs/min)
15 pcs: 3500(pcs/min)
20 pcs: 3500(pcs/min)
>25 pcs: 3500(pcs/min)

Paperboard ejection height(mm): 1000
Standard Stacker

- Stacked height up to 1700mm. Connection arms can be operated manually or automatically.
- Connection’s speed is normally the same as feeding speed. It can also be adjusted independently.
- Pneumatic side jogger makes paperboards in order and squared.
- Sprocket and chain structure controls the up and down of transport bed that prevents the collecting hub from falling. This makes operation safer.
- A pneumatically controlled plate will be pop-up to hold the coming paperboard, when the pile reaches a pre-set height.
- Transfer belts are rough-flat belts, improving adhesive power and preventing paperboard from falling.
- The tension of the belts for connection arm can be adjusted independently, the upper of connection unit is equipped with 2 sets of 0.37kw air blowers for clean paper scraps.

Automatic Stacker

- Stacked height up to 1700mm. Connection arms can be operated manually or automatically.
- Connection’s speed is normally the same as feeding speed. It can also be adjusted independently.
- Pneumatic side jogger makes paperboards in order and squared.
- Sprocket and chain structure controls the up and down of transport bed that prevents the collecting hub from falling. This makes operation safer.
- A pneumatically controlled plate will be pop-up to hold the coming paperboard, when the pile reaches a pre-set height.
- Transfer belts are rough-flat belts, improving adhesive power and preventing paperboard from falling.

Main Specification

<table>
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<tr>
<th>Model</th>
<th>Specification(mm)</th>
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<tbody>
<tr>
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<tr>
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Specifications subject to change without advance notification.

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<th>Model</th>
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<td>1600X3200</td>
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<tr>
<td>3600</td>
<td>1600X3600</td>
</tr>
</tbody>
</table>

Specifications subject to change without advance notification.
**Standard Vibrator Stacker**

- Stacked height up to 1700mm. Connection arms can be operated manually or automatically.
- Connection’s speed is normally the same as feeding speed. It can also be adjusted independently.
- Pneumatic side jogger makes paperboards in order and squared.
- Sprocket and chain structure controls the up and down of transport bed that prevents the collecting hub from failing. This makes operation safer.
- A pneumatic controlled plate will be pop-up to hold the coming paperboard, when the pile reaches a pre-set height.
- Equipped with 3 section belts conveying paperboard, the front with 6 units belts, the middle and the back with rough-top flat belts. The rough-top belts can improve adhesive power and prevent paperboard from failing.
- Both the upper of middle and front convey belts are equipped with 2 sets 0.77kw scap air blowers, totally 4 sets. The upper of vibrating section with 1 set 2.2kw scap air blower. The upper of round belt in vibrating section with 1 set brush to clean scaps.
- The bottom of vibrating section is equipped with scaps conveying device to convey the scaps at the bottom of vibrating section to the front of the stacker.

**Main Specification**

<table>
<thead>
<tr>
<th>Model</th>
<th>Specification(mm)</th>
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<tbody>
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<tr>
<td>2400</td>
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<tr>
<td>2800</td>
<td>1200X2800</td>
</tr>
<tr>
<td>3200</td>
<td>1600X3200</td>
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</table>

Specifications subject to change without advance notification.

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**Automatic Vibrator Stacker**

- Stacked height up to 1700mm. Connection arms can be operated manually or automatically.
- Connection’s speed is normally the same as feeding speed. It can also be adjusted independently.
- Pneumatic side jogger makes paperboards in order and squared.
- Sprocket and chain structure controls the up and down of transport bed that prevents the collecting hub from failing. This makes operation safer.
- A pneumatic controlled plate will be pop-up to hold the coming paperboard, when the pile reaches a pre-set height.
- Equipped with 3 section belts conveying paperboard, the front with 6 units belts, the middle and the back with rough-top flat belts. The rough-top belts can improve adhesive power and prevent paperboard from failing.
- The bottom of vibrating section equipped with scaps conveying device to convey the scaps at the bottom of vibrating section to the front of the stacker.

**Main Specification**

<table>
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<th>Model</th>
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<tr>
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</tr>
<tr>
<td>3200</td>
<td>1600X3200</td>
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</table>

Specifications subject to change without advance notification.
**Peripheral Equipment**

**Features:**
- PLC control.
- Fully electrical, no hydraulic.
- Fast and strong.
- No pit necessary.
- Smooth transportation with belt to avoid paper damage.
- High safety standard, CE certified.
- Can be equipped:
  - After corrugated line:
  - In front of prefoder/punter;
  - In front of stitching/gluing machine.

**Pile Turner**
- Light curtain for high safety standard
- Belts for smooth transportation

**Prefeeder**
- Automatic and easy operation.
- Guarantee constant speed in the working process.
- Assemble on wheels to let printer open.
- Automatically bundle centering, electric control to guarantee constant height of bundles.
- Able to work with warp paperboards.
- Be able to work with top printing machine when equipped with Pile Turner.

**Main Specification**

<table>
<thead>
<tr>
<th>Model</th>
<th>Min. Paper Size(mm)</th>
<th>Max. Paper Size(mm)</th>
<th>Max. Load(T)</th>
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<tbody>
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Specifications subject to change without advance notification.

**Main Specification**

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<td>B flute, 250pcs/min</td>
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<td>FR1632</td>
<td>250(W)x750(W)x200(H)</td>
<td>1800(W)x3200(W)x2000(H)</td>
<td>BC flute, 150pcs/min</td>
</tr>
</tbody>
</table>

Specifications subject to change without advance notification.