



evolution in corrugated

*Fosber Spa //*

Via Provinciale per Camaiore 27-28 - 55060 Monsagrati - Lucca - Italy  
T + 39 0583 3891 - F + 39 0583 389205 - www.fosber.it - info@fosber.it

*Fosber America Inc. //*

1333 Parkview Road - Green Bay - Wisconsin 54304 - USA  
T +1 920 339 6100 - F +1 920 339 6110 - www.fosber.com -  
sales@fosber.com

*Fosber China. //*

No.38 Quanxing Road - Wuqing Development Area  
301700 Tianjin - China  
T +86 22 5961 1668 - F +86 22 5961 1669 - info@fosber.cn

*Affiliated Companies:*

*Fosber Australia //*

3 Champagne Rise - Chirnside Park Vic 3116 - Australia  
T +61 3 9727 5192 - F +61 3 9727 5192 - ao012513@bigpond.net.au

*Fosber do Brazil //*

Rua Tabajaras, 672 - salas 1 e 5 - 80320-310 Curitiba - Brazil  
T +55 41 244 7804 - F +55 41 244 8772 - anapaula@fosberbr.com.br

*Fosber Deutschland //*

Aschaffburger Weg 8 - D-63128 Dietzenbach - Germany  
T +49 6074 4828222 - F +49 6074 4828223 - berger-peter@t-online.de

*Fosber Espana //*

P.A.E. Asuaran - Edificio Enekuri Oficinas, 2º piso Departamento, 16  
- 48950 Erandiao (Vizcaya) - Spain  
T +34 944 711 681 - F +34 944 711 679 - embider@sarenet.es

*Fosber France //*

49 Rue Tronchet - 69006 Lyon - France  
T +33 478 89 1856 - F +33 478 89 8652 - jackpall@club-internet.fr

*Fosber LatinoAmerica//*

Carrera 19 A # 122 - 33 - Suite # 33 - Bogota - Colombia  
T + 57 1 601 5105 - F + 57 1 601 5105 - fosberamericalatina@hotmail.com

*Fosber Mexico//*

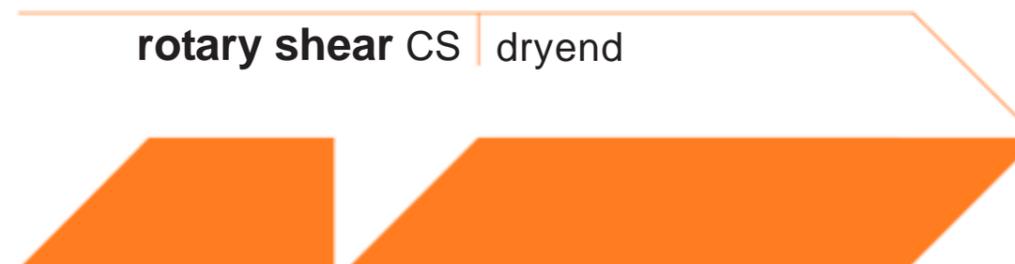
Asunción # 10 53040 Las Americas - Naucalpan - Estado de México  
T +52 55 55 60 87 15 - F +52 55 55 60 87 15 -  
fosberamericalatina\_mx@hotmail.com

*Fosber UK //*

5 Shepherds Way - Sudbrooke - Lincs - LN2 2FE - England  
T +44 1522 752497 - F +44 1522 752272 - tstraker@fosber.it

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Fosber's patented CONSTANT SYSTEM order change allows a true gapless order change on two knife levels through the cut-off knife. The problems of conventional order changes are eliminated by removing the need to sever the web at the rotary shear. This unique order change sequence requires the installation of the CONSTANT SYSTEM Rotary Shear with the Fosber TWIN automatic slitter scorer.

The CONSTANT SYSTEM Rotary Shear operates as a standard blade to soft anvil rotary shear in all respects except that the knife shaft has a series of 26 segmented blades which can be independently activated into cut mode. The lower anvil shaft is covered with sectioned polyurethane sleeves with a male to female locking design, for easy removal and replacement. The waste expulsion section is identical to a standard rotary shear, consisting of a pneumatically indexed diverter plate, an expulsion nip roll and a high-grip expulsion belt as well as an upper no-crush roller which applies positive pressure on the board at waste discharge.

The CONSTANT SYSTEM Rotary shear can operate as a conventional shear, chopping out waste or making a full width single cut to initiate a conventional order change, as well as gapless order change mode. In CONSTANT SYSTEM order change mode, individual blades are engaged to cut selected areas across the web. At order change, the required blades are indexed and the knife bar makes a single turn, cutting the web at only the side trim locations and the central area between the upper knife and lower knife web-divided points for the old and new order. When the order change area of the web reaches the Fosber TWIN slitter, the trim and dividing slitting heads are activated to create an overlap of the old order and new order divide slits while all other scores and slit heads are lifted out of the board line.

Fosber's CONSTANT SYSTEM Order change simply and effectively unifies the old and new orders so that a continuous flow of board runs through the web at all times – including order change. This eliminates problems associated with other order change methods such as: Reduced speed for order change, High acceleration of the old order, Jam ups due to leading edge at the slitter or knife, web weave, sheet variation at order change, and switching of measuring devices. The risk of Jam-ups is eliminated.

## rotary shear CS dryend

### technical features

Max. cutting speed	250 mpm.
Waste expulsion speed	Up to 250 mpm.
Max. paper width	1800 - 2500 - 2800 mm.

