Non-stop **production**



FOLDING-GLUING | FOLDING CARTON

MASTERFOLD 75 | 110

www.bobst.com

BOBST

BOBST

Empowering **flexibility**

When only the highest productivity will do: the world's fastest, automated, versatile and most ergonomic folder-gluer line. The **MASTERFOLD** can be set up in minutes and delivers efficient and reliable non-stop production of outstanding quality products.



Round-the-clock **speed and efficiency**

Unrivalled **versatility**

Immaculate boxes

MASTERFOLD 75 | 110

> At a glance
> Packaging market
> Benefits and features
  > 1 – 9
  > BOBST technology
> Specifications
  > Measurements
  > Configurations
  > Technical information
> Related Products
  > ACCUCHECK
  > ACCUBRAILLE
  > SPEEDWAVE
  > GYROBOX
  > NICK BREAKER
  > SPEEDHOOK
  > Peripherals
> Services
  > General services
  > BOBST Connect

> WATCH VIDEO

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Creating **value**

BOBST innovations
are driven by customer and brand owner needs.

> READ MORE

Functional packaging and protection
Protecting the goods in a clever way is required. Single serve, multi-packs, re-sealable, see-through.

Customization, versioning, personalization
Packaging needs to reach all segments of the society taking almost any shape and size from very short runs to reprint and long runs. All with the best color consistency.

E-commerce & omni-channels
Multiple retail formats set new requirements for packaging. On-demand production, timely delivery across multiple designs, shapes and sizes.

Sustainability
Packaging production needs to reduce its environmental carbon footprint – less waste across the entire supply chain. New and thinner substrates. Recycling and re-use are the new rules.

Faster time-to-market
A growing number of products need to reach consumers faster. Product lifetime is shorter. From product design to the consumer experience, the supply chain has to be more agile.



- At a glance
- Packaging market
- Benefits and features
  - 1 – 9
  - BOBST technology
- Specifications
  - Measurements
  - Configurations
  - Technical information
- Related Products
  - ACCUCHECK
  - ACCUBRAILLE
  - SPEEDWAVE
  - GYROBOX
  - NICK BREAKER
  - SPEEDHOOK
  - Peripherals
- Services
  - General services
  - BOBST Connect

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Perfect alignment

ACCUFEED

- Integrated blank aligner for perfect folding
- Variable speed independent drive for irregular shaped, heavy or large boxes
- Feeds all types of material
- Sets in a quarter of the time of other feeders – meaning shorter makeready times
- Reduced waste
- Less maintenance



Ultra-reliable precision

Prebreaker

- Extra long, 180° prebreaking of all boxes at high speed, regardless of material
- Extra wide lower left hand belt ensures no marking
- Upper left conveyor displacement allows for more flexibility and faster set-up



Superb versatility

Crash-lock module

- Fastest set-up time in its range
- Quick and precise for a great variety of folding options, including reinforced crash-lock bottom boxes
- Prebreaks large boxes and provides a location for additional devices
- Telescopic upper conveyors easily adjustable to box formats
- Motorized lifting frame cuts changeover times

> At a glance
> Packaging market
> Benefits and features
  > 1 – 9
  > BOBST technology
> Specifications
  > Measurements
  > Configurations
  > Technical information
> Related Products
  > ACCUCHECK
  > ACCUBRAILLE
  > SPEEDWAVE
  > GYROBOX
  > NICK BREAKER
  > SPEEDHOOK
  > Peripherals
> Services
  > General services
  > BOBST Connect

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Rapid adaptability

4 & 6-corner equipment

- Fast set-up of all types of 4 and 6-corner boxes
- Speed up to 50,000 b/h
- Quick set-up tilting frame adjusting to flap size
- Human Machine Interface SPHERE with automated positioning and remote control
- Modulated trajectory hooks for smooth and precise folding



Maximum speed

Lower gluing unit

- Oversized stainless steel glue wheel for high speed running
- Corrosion proof and long lasting
- Precise application of correct glue amount
- All components easily removable for quick cleaning
- Independently driven, saving power by allowing to mix glue without running the entire machine



Smooth progression

Folding

- Low side frame for easy access
- Belt lifting device for more flexibility
- Pneumatic central conveyors for quick format change
- Right, left or simultaneous folding
- Minimum folding device for folding down to 35 mm

> At a glance
> Packaging market
> Benefits and features
> 1 – 9
> BOBST technology
> Specifications
> Measurements
> Configurations
> Technical information
> Related Products
> ACCUCHECK
> ACCUBRAILLE
> SPEEDWAVE
> GYROBOX
> NICK BREAKER
> SPEEDHOOK
> Peripherals
> Services
> General services
> BOBST Connect

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Unique ergonomics

Unlimited access

- All parts of the production line are instantly accessible, reducing the set-up time
- Easy access open frame and platforms allow the operator to move within the machine
- For configuration with 4- & 6-corner device, light barriers ensure safety during production process



High-speed perfection

Transfer

- Independent drive for total control of the box stream
- Easily set up ACCUEJECT device, able to eject a single faulty box even at maximum speed
- Motorized transfer conveyors adaptable to complex box shapes
- Belt tensioning and adjustable height ensures a perfect box stream



Fast and steady

Delivery

- ACCUPRESS pressure control for perfect gluing of delicate and odd shaped boxes
- Independent drive for fast job changeover
- Box stream regulator for precise intervals, higher quality and faster running

> At a glance
> Packaging market
> Benefits and features
  > 1 – 9
  > BOBST technology
> Specifications
  > Measurements
  > Configurations
  > Technical information
> Related Products
  > ACCUCHECK
  > ACCUBRAILLE
  > SPEEDWAVE
  > GYROBOX
  > NICK BREAKER
  > SPEEDHOOK
  > Peripherals
> Services
  > General services
  > BOBST Connect

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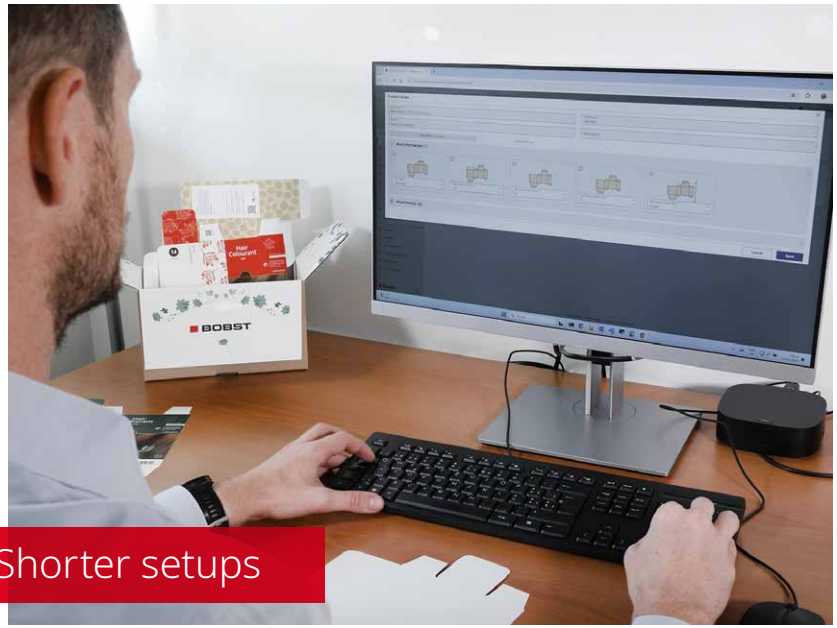
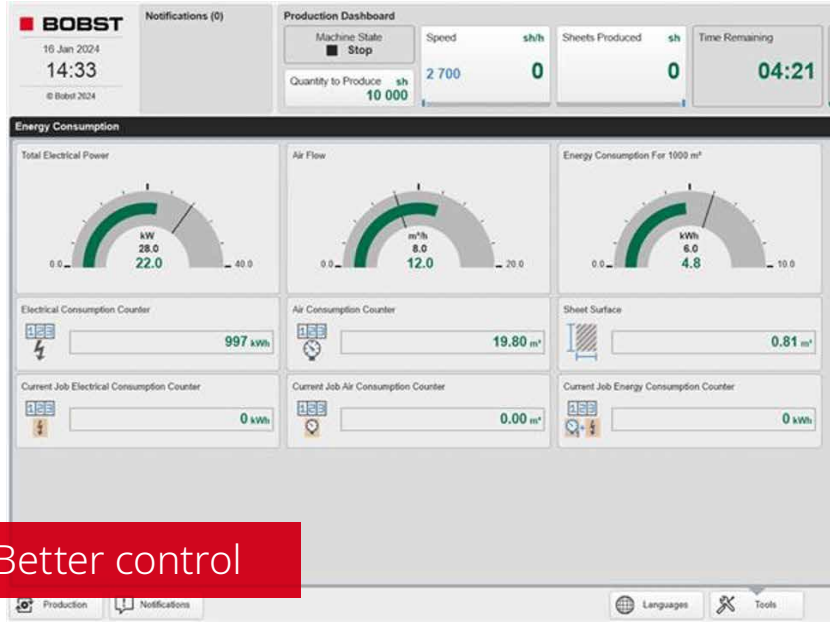


Shorter setups

Job and Recipe Management Workflow
Connects the HMI SPHERE via the BOBST Connect platform directly to the back office, where job recipes can be managed away from the production floor. Then, the job recipes are sent to the production lines and equipments, ready to be downloaded.

This system allows to increase uptime and proactively prepare shifts. Taking into account changes occuring during production, it ensures production consistency and continuous improvements across different shifts and operators. It also gives a real-time follow-up of the packaging production progress.



Better control

Monitoring and management
Analyse and improve your production workflow and planning with > BOBST Connect Essential.
With Performance Management and Equipment Monitoring, reports provide data which give insights into productivity and output quality as well as a comprehensive production overview of all connected machines.

Energy Monitoring allows to control the air and electricity consumption of the machine and identify eventual energy saving measures.

> At a glance
> Packaging market
> Benefits and features
  > 1 – 9
  > BOBST technology
> Specifications
  > Measurements
  > Configurations
  > Technical information
> Related Products
  > ACCUCHECK
  > ACCUBRAILLE
  > SPEEDWAVE
  > GYROBOX
  > NICK BREAKER
  > SPEEDHOOK
  > Peripherals
> Services
  > General services
  > BOBST Connect

Print responsibly

Data is not binding.
Non-contractual pictures.
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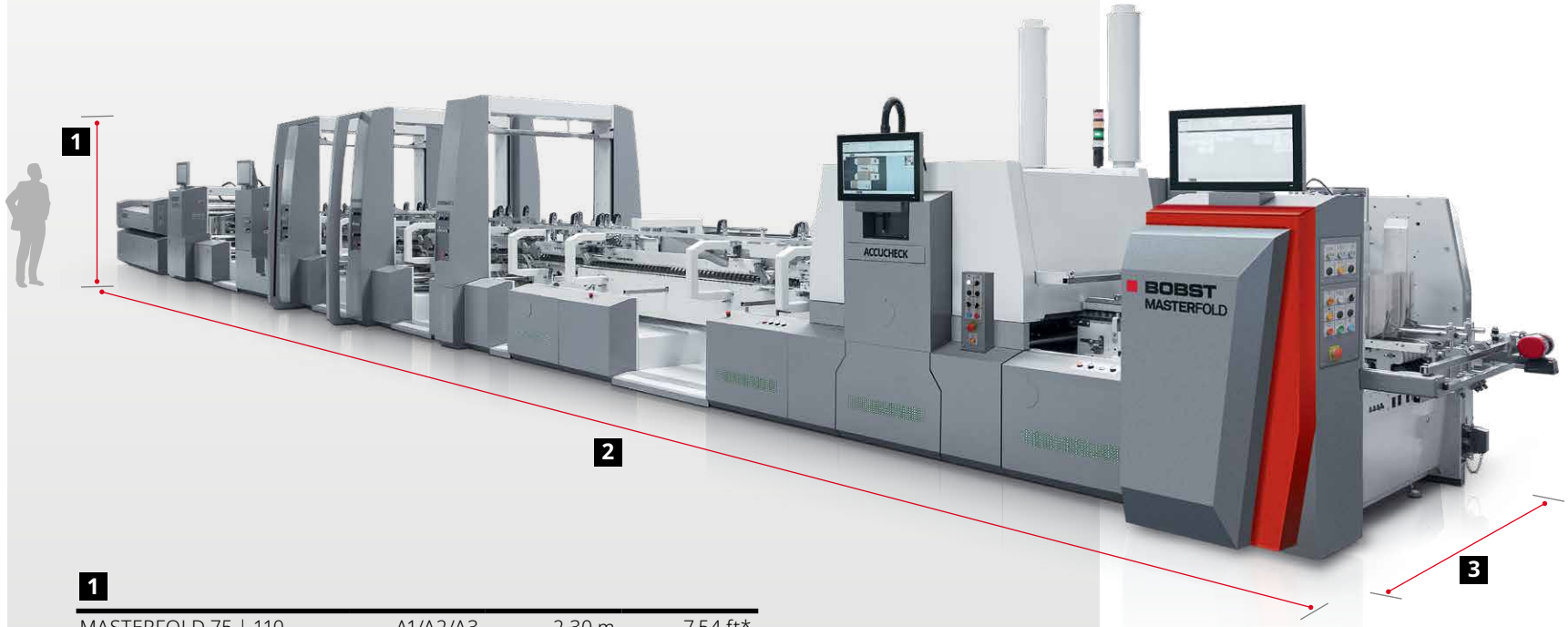
BUPC-MFD110-EN-0125

> At a glance
> Packaging market
> Benefits and features
  > 1 – 9
  > BOBST technology
> Specifications
  > Measurements
  > Configurations
  > Technical information
> Related Products
  > ACCUCHECK
  > ACCUBRAILLE
  > SPEEDWAVE
  > GYROBOX
  > NICK BREAKER
  > SPEEDHOOK
  > Peripherals
> Services
  > General services
  > BOBST Connect



1

MASTERFOLD 75 | 110	A1/A2/A3	2.30 m	7.54 ft*

2

MASTERFOLD 75 | 110	A1	14.77 m	48.45 ft*
	A2	16.76 m	54.98 ft*
MASTERFOLD 110	A3	18.84 m	61.81 ft*

3

MASTERFOLD 75	A1/A2	2.06 m	6.72 ft*
MASTERFOLD 110	A1/A2	2.40 m	7.87 ft*
MASTERFOLD 110	A3	2.70 m	8.85 ft*

*Values without can vary according to configuration.

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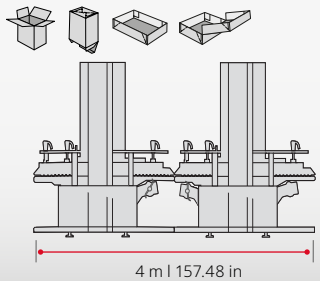
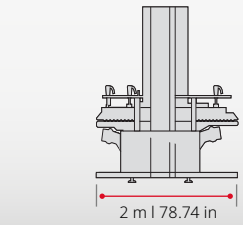
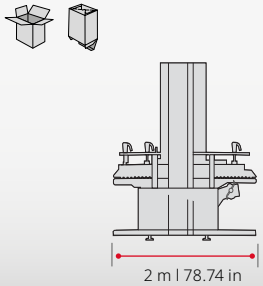
Combifolder
A3 MASTERFOLD 110



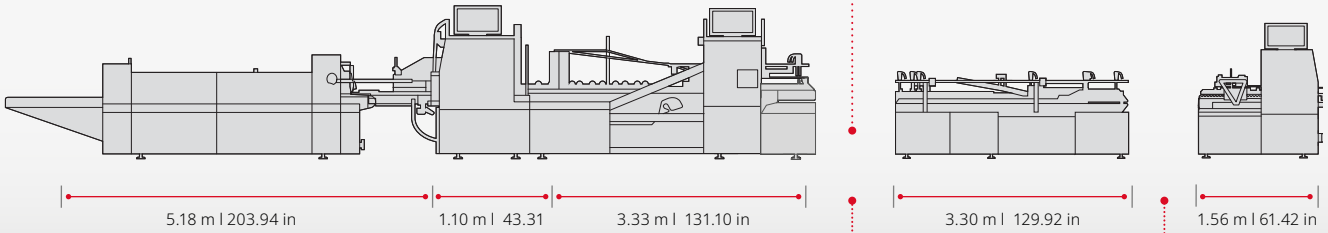
SPEEDWAVE
A1l2 MASTERFOLD 75|110



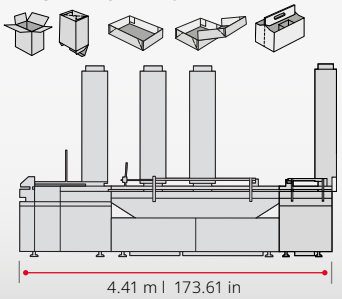
Crash-lock bottom
A2 MASTERFOLD 75|110



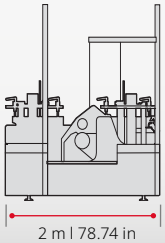
A1 **MASTERFOLD 75|110**



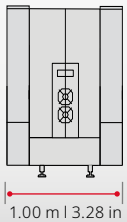
GYROBOX
MASTERFOLD 110



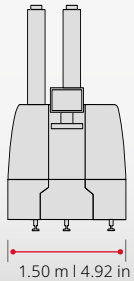
NICK BREAKER
MASTERFOLD 110



ACCUBRAILLE
A1l2l3 MASTERFOLD 75|110



ACCUCHECK
A1l2l3 MASTERFOLD 75|110



All configurations must be validated by a technical specialist to confirm compatibility of any added.

> At a glance
> Packaging market
> Benefits and features
  > 1 – 9
  > BOBST technology
> Specifications
  > Measurements
  > Configurations
  > Technical information
> Related Products
  > ACCUCHECK
  > ACCUBRAILLE
  > SPEEDWAVE
  > GYROBOX
  > NICK BREAKER
  > SPEEDHOOK
  > Peripherals
> Services
  > General services
  > BOBST Connect

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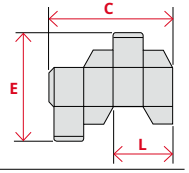
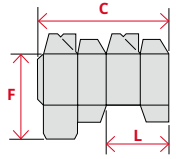
Box sizes — MASTERFOLD 75 | 110

Straight line boxes	Min./mm	Min./inch	Max./mm	Max./inch
C	76	4.96	750 | 1,100	29.52 | 43.30
E	60	2.36	800 | 800	31.49 | 31.49
L	35	2.36	360 | 535	14.17 | 21.06

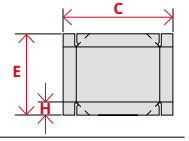


Crash-lock bottom boxes	Min./mm	Min./inch	Max./mm	Max./inch
C	146	5.74	750 | 1,100	29.52 | 43.30
F			800 | 800	31.49 | 31.49
L	70	1.57	360 | 535	14.17 | 21.06

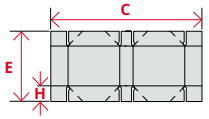


Box sizes — MASTERFOLD 110

4-corner boxes	Min./mm	Min./inch	Max./mm	Max./inch
C	130	5.11	1,100	43.30
E	110	4.33	900	35.43
H	20	0.78	200	7.87



6-corner boxes	Min./mm	Min./inch	Max./mm	Max./inch
C	250	9.84	1,100	43.30
E	130	5.11	900	35.43
H	30	1.18	155	6.10



Convertible stock — MASTERFOLD 75 | 110

Carton or solid board, up to	800 g/m²	.049 in
Corrugated board	N–F–E	N–F–E
Thickness of folded box, max.	15 mm	0.59 in

Drive system	m/min	ft/min
Inching speed	15	49.20
Operating speed	600	1,968

MASTERFOLD 75 A1/A2

Operating speed with high speed option A-011	20-700	65-2,296

MASTERFOLD 75 | 110

> At a glance
> Packaging market
> Benefits and features
> > 1 – 9
> > BOBST technology
> Specifications
> > Measurements
> > Configurations
> > Technical information
> Related Products
> > ACCUCHECK
> > ACCUBRAILLE
> > SPEEDWAVE
> > GYROBOX
> > NICK BREAKER
> > SPEEDHOOK
> > Peripherals
> Services
> > General services
> > BOBST Connect

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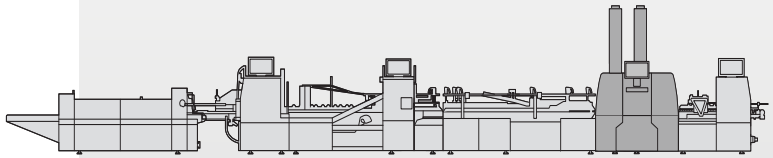
Zero-fault packaging

> The **ACCUCHECK** carefully checks carton blanks for defects and guarantees complete quality consistency. Based on the 30 year experience of BOBST REGISTRON® technology, this highly flexible tool allows you to inspect different box areas according to various quality criteria, while remaining easy and quick to operate.





Impeccable results

Faultless boxes
- Ability to deliver zero-defect products
- More than 30 years knowledge in image processing
- Automatic and accurate ejection of faulty boxes at any speed
- Dust elimination device, avoiding unnecessary box rejection and ensuring perfect box quality



Complete quality consistency

Ensuring client satisfaction
- 100% quality controlled production
- Fully integrated into the folding-gluing process
- PDF conformity
- Makes sure clients' quality requests are perfectly met



Exceptional performance

Amazing inspection capabilities
- Fastest quality control inline
- Full inspection capabilities for any format
- Smart text identification using machine learning
- Value-added productivity
- Patented lighting system

> At a glance
> Packaging market
> Benefits and features
  > 1 – 9
  > BOBST technology
> Specifications
  > Measurements
  > Configurations
  > Technical information
> Related Products
  > ACCUCHECK
  > ACCUBRAILLE
  > SPEEDWAVE
  > GYROBOX
  > NICK BREAKER
  > SPEEDHOOK
  > Peripherals
> Services
  > General services
  > BOBST Connect

Print responsibly

Data is not binding.
Non-contractual pictures.
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Bespoke quality control

Highly flexible

- Customer-specific inspection modes
- Precise definition of control sensitivity through dedicated zones
- Several operating modes for customized setting and easy operation, to perfectly adapt to any quality criterion
- PDF quality control reporting according to customer validation targets



Cutting costs

Increased efficiency

- In-line system, avoiding an extra step in your production process
- Short and efficient quality control process, cutting running costs of quality checks
- Less waste: eliminates only boxes which do not correspond to specific quality criteria
- Energy-efficient motors



Simple to use

Quick setups

- Inspection parameters can be saved and recalled for quick setups
- Repeat order sets within seconds
- Optional additional screens for full visibility along the production process
- With the Job and Recipe Management Workflow, inspection parameters can be managed in the back office and sent to the ACCUCHECK to be downloaded, allowing a faster setup and better control consistency

> At a glance
> Packaging market
> Benefits and features
  > 1 – 9
  > BOBST technology
> Specifications
  > Measurements
  > Configurations
  > Technical information
> Related Products
  > ACCUCHECK
  > ACCUBRAILLE
  > SPEEDWAVE
  > GYROBOX
  > NICK BREAKER
  > SPEEDHOOK
  > Peripherals
> Services
  > General services
  > BOBST Connect

Related products – Technical information

Technical data	ACCUCHECK on MASTERFOLD 75 | 110	
Inspection zone, up to	400 x 400 mm	15.75 x 15.75 in
With option extension zone increase	800 x 800 mm	31.50 x 31.50 in
Inspection speed, up to (high speed mode)	350 m/min. (500 m/min)	1,448 ft/min. (1,640 ft/min).
Device length	1.5 m	4.92 ft

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> At a glance
> Packaging market
> Benefits and features
  > 1 – 9
  > BOBST technology
> Specifications
  > Measurements
  > Configurations
  > Technical information
> Related Products
  > ACCUCHECK
  > ACCUBRAILLE
  > SPEEDWAVE
  > GYROBOX
  > NICK BREAKER
  > SPEEDHOOK
  > Peripherals
> Services
  > General services
  > BOBST Connect

Inspection capabilities

Inspection capabilities include stable and accurate color measurement, precise register control of print, embossing, foil, cut patterns and enhanced text inspection, regardless of text pose or color as well as advanced control of finishes such as hot foil, embossing or varnish.

Smart print control
- Missing print
- Text error
- Code default
- Color variation

Registration
- Cut to print
- Text alignment
- Foil to print
- Emboss to print

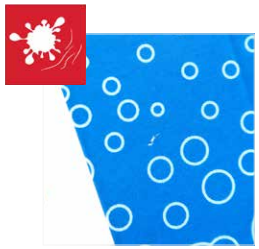
Imperfection
- Splash
- Spot
- Scratch
- Fine line
- Stripe

Integrity
- Carton damage
- Dust
- Oil
- External element

Embellishment
- Missing foil
- Varnish presence
- Embossing absence





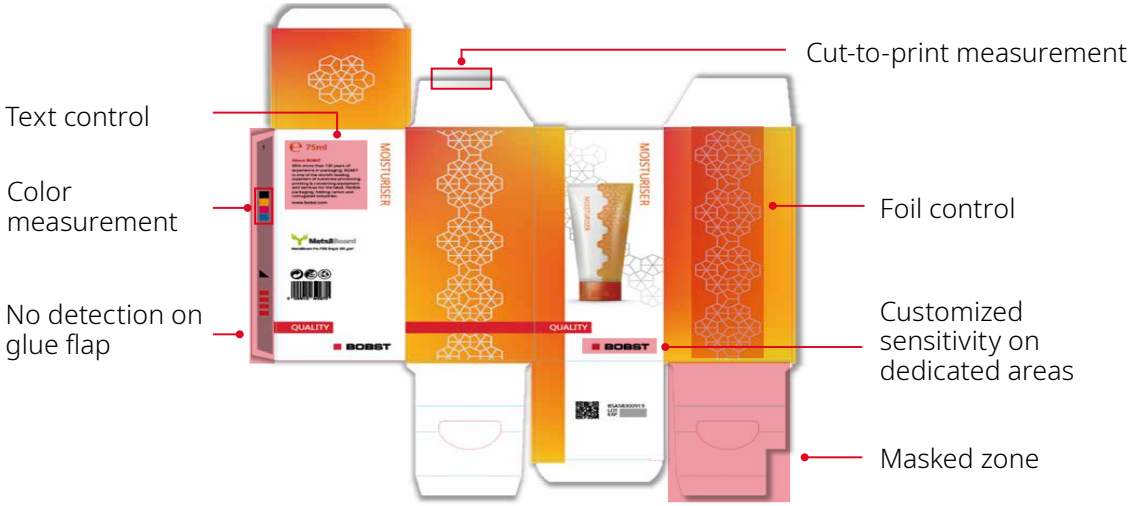






Inspection by zone

The global control sensitivity can be adjusted within 3 pre-set quality levels. Moreover, you can customize the blank control areas according to the required defect type and adapt the control sensitivity depending on your needs.



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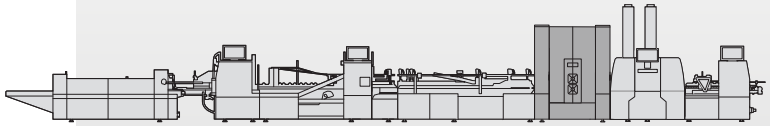
Guaranteed box compliance

> ACCUBRAILLE is a patented additional unit which allows you to emboss braille onto all four panels of a carton, even across the running direction, and to emboss images, letters and/or numbers.





Multiple possibilities

Embossing
- Up to 8 lines and 4 panels, as well as transverse embossing
- Consistent, long-lasting dot definition
- Inline embossing enables smooth feeding of dot-free blanks (no interlocking)



High efficiency

Set-up
- Quick and easy tool mounting system
- Saves extensive set-up time on the die-cutter
- Small footprint
- Cost-effective
- Up to 115,000 b/h



Easy handling

Ergonomics
- Device can be installed on the left and/or right side
- Automatic tool synchronization
- Motorized dot height adjustment
- Embarked doors for perfect safety

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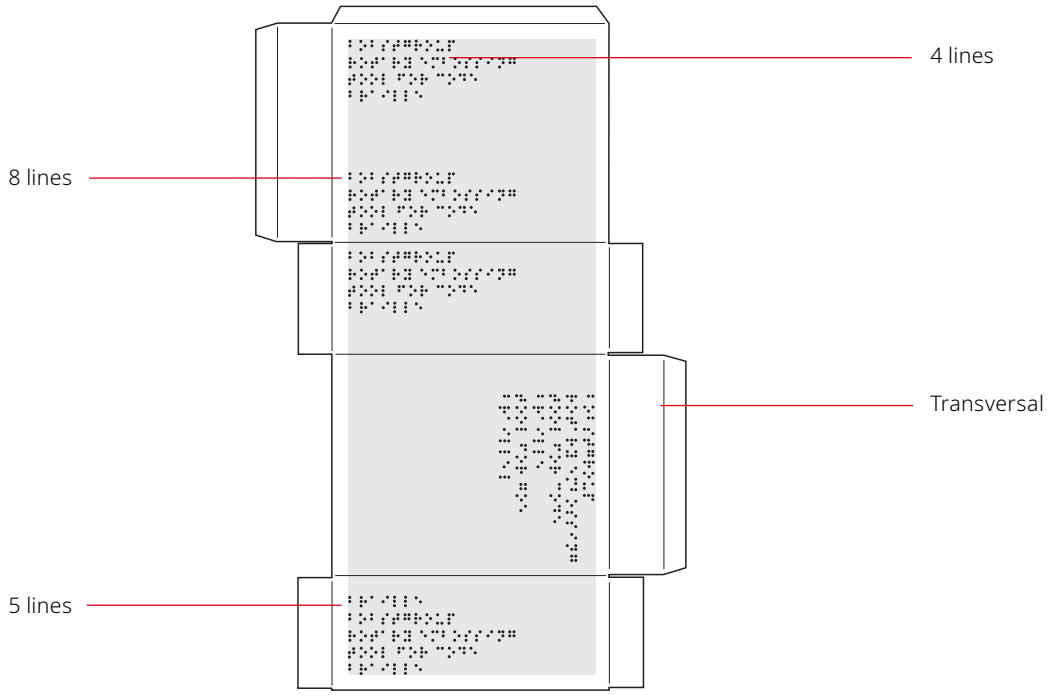
General data	ACCUBRAILLE on MASTERFOLD 75 | 110	
Braille		Marburg Medium
Material	200 - 500 g/m²	.010 - .023 in
Device	Left and/or right side	
Speed	up to 115,000 b/h	
Device length	1 m	3.28 ft
Device width	1.92 m	6.29 ft

Embossing



> At a glance
> Packaging market
> Benefits and features
  > 1 – 9
  > BOBST technology
> Specifications
  > Measurements
  > Configurations
  > Technical information
> Related Products
  > ACCUCHECK
  > ACCUBRAILLE
  > SPEEDWAVE
  > GYROBOX
  > NICK BREAKER
  > SPEEDHOOK
  > Peripherals
> Services
  > General services
  > BOBST Connect

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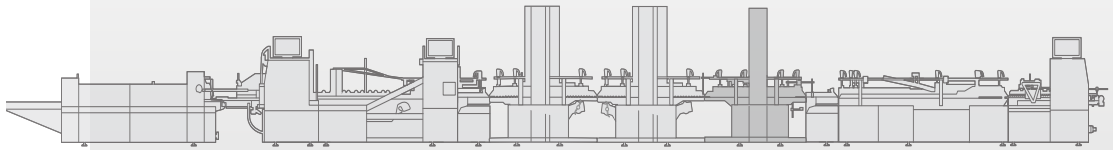
BOBST

Exceptional **folding quality**

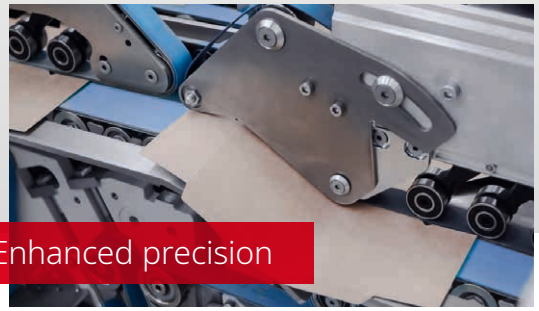
SPEEDWAVE is a BOBST patented device that simplifies the setting of crash-lock and various other special boxes on your MASTERFOLD 75 and 110, saving you time while simultaneously delivering exceptional folding quality and drastically increasing your productivity.





Easy setting

Set-up
- Greatly reduced setting times
- Motorization of the wave
- Lower lateral guides move into position with the wave
- Memorization of the wave position with job data in the BOBST Human Machine Interface (HMI) SPHERE



Enhanced precision

Production
- Quick and precise electronic set-up
- Graduated scale for precise setting of the wave
- Exceptional folding quality



Improved functionality

Machine
- Reduced downtime
- Hook-free folding for a more stable folding process throughout the speed range
- Better consistency
- Less noise
- Less maintenance

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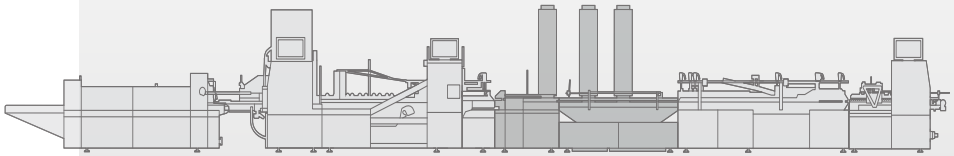
BOBST

Simplifying complexity

GYROBOX is a supplementary module for the MASTERFOLD 110. It revolutionizes the production of complex boxes. Rotating blanks in line between two folding processes, in one single pass, it makes the folding-gluing of complicated carton packaging quick and easy and delivers exceptional end-product quality. GYROBOX boosts the efficiency of your production process.





Efficient and productive

Complex boxes in one go

- Rotates blanks from 0° to 180° in any direction
- Produces complex boxes, such as double-folded boxes, rapidly and in one single pass
- Simplifies the production process and cuts down costs



Easy setting

Production

- Simple to set-up
- Can be left in line, even when not needed
- No hindrance and no loss of speed when running standard boxes



High-quality speciality boxes

Versatility

- Superb quality of the final product
- Maximizes creativity, productivity and efficiency
- Increases diversification, flexibility
- Opens up new markets

> At a glance
> Packaging market
> Benefits and features
  > 1 – 9
  > BOBST technology
> Specifications
  > Measurements
  > Configurations
  > Technical information
> Related Products
  > ACCUCHECK
  > ACCUBRAILLE
  > SPEEDWAVE
  > GYROBOX
  > NICK BREAKER
  > SPEEDHOOK
  > Peripherals
> Services
  > General services
  > BOBST Connect

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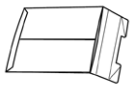
Dimensions		GYROBOX on MASTERFOLD 110
Length with GYROBOX	26.61 m	87.30 ft
Width and height		same as MASTERFOLD

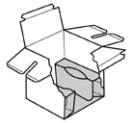
Convertible stock		
Corrugated and solid board, up to		as for MASTERFOLD
Solid board, min.	220 g/m²	.010 in

Drive system		
Inching speed, min.	15 m/min.	49.20 ft/min.
Operating speed with GYROBOX in use, max.	500 m/min.	1,476 ft/min.
Thickness of the folded box, max.	15 mm	.59 in

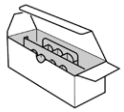
Additional box capabilities (depending on configuration)



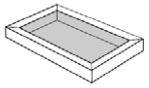
Envelope with side flaps



Box with inner holders



Partition boxes



Double-wall box



Reinforced crash-lock bottom box

> At a glance
> Packaging market
> Benefits and features
  > 1 – 9
  > BOBST technology
> Specifications
  > Measurements
  > Configurations
  > Technical information
> Related Products
  > ACCUCHECK
  > ACCUBRAILLE
  > SPEEDWAVE
  > GYROBOX
  > NICK BREAKER
  > SPEEDHOOK
  > Peripherals
> Services
  > General services
  > BOBST Connect

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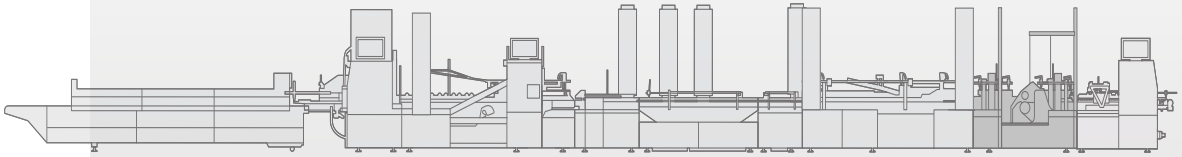
BOBST

Fast and **efficient**

NICK BREAKER is a device destined for the MASTERFOLD 110, particularly in combination with the GYROBOX. Placed immediately after the feeder, it enables the in-line breaking of nicks which hold flaps together, enabling the boxes to be folded and erected with precision.





Extreme precision

Perfect in-line nick breaking

- The upper and lower tool supporting axes are driven by an electronically synchronized motor
- The speed of the axes is modulated
- The position of the conveyors can be adapted lengthwise



Convenience

Rapid set-up

- The open disks can easily be exchanged, saving time
- Convenient registration of the blank parameters for the programming of the tool supporting axis via the HMI SPHERE for speedier set-up and more precision



Increased productivity

Smooth production

- Perfect nick breaking allows boxes to be processed easily
- Less production jams and waste, increasing uptime and saving cost
- Outstanding quality of the finished boxes

> At a glance
> Packaging market
> Benefits and features
  > 1 – 9
  > BOBST technology
> Specifications
  > Measurements
  > Configurations
  > Technical information
> Related Products
  > ACCUCHECK
  > ACCUBRAILLE
  > SPEEDWAVE
  > GYROBOX
  > NICK BREAKER
  > SPEEDHOOK
  > Peripherals
> Services
  > General services
  > BOBST Connect

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Dimensions		NICK BREAKER on MASTERFOLD 110
Length with GYROBOX & NICK BREAKER	21.30 m	69.88 ft
Width and height		same as MASTERFOLD

Convertible stock		
Corrugated and solid board, up to		as for MASTERFOLD
Solid board, min.	220 g/m²	.010 in

Drive system		
Inching speed, min.	15 m/min.	49.20 ft/min.
Operating speed with NICK BREAKER in use, max.	350 m/min.	1,448.29 ft/min.



> At a glance
> Packaging market
> Benefits and features
  > 1 – 9
  > BOBST technology
> Specifications
  > Measurements
  > Configurations
  > Technical information
> Related Products
  > ACCUCHECK
  > ACCUBRAILLE
  > SPEEDWAVE
  > GYROBOX
  > NICK BREAKER
  > SPEEDHOOK
  > Peripherals
> Services
  > General services
  > BOBST Connect

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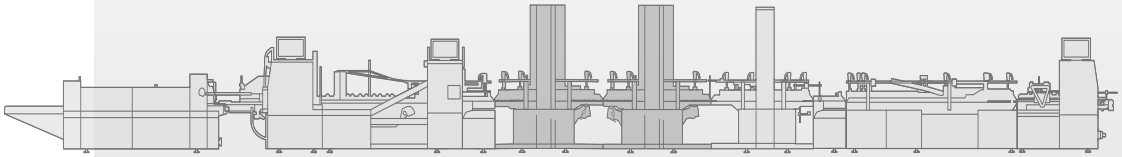
BOBST

Boosting productivity

SPEEDHOOK is a high performance, cutting edge solution for getting even more from your MASTERFOLD 110. Two sets of newly designed hooks are easily installed and ensure fast and precise folding at high speed.





Getting more

Performance

- Consistent, high-speed folding of 4 & 6-corner boxes
- Production increased by up to 50,000 b/h



Flexible and easy

New technology

- Two sets of lightweight hooks and shafts
- Easily positioned, allowing for great flexibility



Top quality

Folding

- Perfect control of back flap fold-over
- Precise folding quality

> At a glance
> Packaging market
> Benefits and features
  > 1 – 9
  > BOBST technology
> Specifications
  > Measurements
  > Configurations
  > Technical information
> Related Products
  > ACCUCHECK
  > ACCUBRAILLE
  > SPEEDWAVE
  > GYROBOX
  > NICK BREAKER
  > SPEEDHOOK
  > Peripherals
> Services
  > General services
  > BOBST Connect

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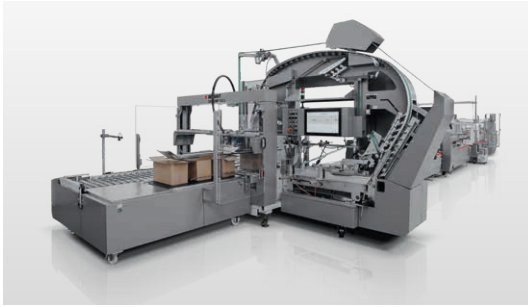
> EASYFEEDER / BATCH INVERTER 4

For continuous and faster feeding of blanks. Makes feeding easier and simpler, boosting production and reducing cost.



> CARTONPACK 4

For the highest productivity: allows you to pack a wide range of boxes into shipping containers with speed and precision.

> At a glance
> Packaging market
> Benefits and features
  > 1 – 9
  > BOBST technology
> Specifications
  > Measurements
  > Configurations
  > Technical information
> Related Products
  > ACCUCHECK
  > ACCUBRAILLE
  > SPEEDWAVE
  > GYROBOX
  > NICK BREAKER
  > SPEEDHOOK
  > Peripherals
> Services
  > General services
  > BOBST Connect

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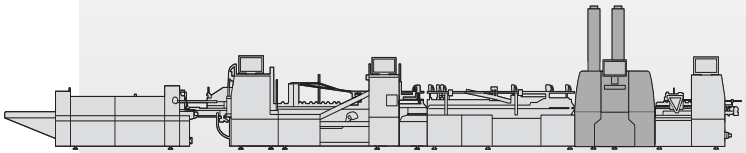
BOBST

Pioneering **connectivity**

Achieving zero-fault quality has never been easier with the **ACCUCHECK Recipe Management**. This features allows instant programming, easy setup, and increases shop floor productivity, while providing your company with a smooth entry into the data-driven world. Job can be prepared before production starts, from anywhere.





Performance
- Instant programming
- Easy setup
- Significantly reduces setup
- Higher shop floor productivity due to remote job setup



New technology
- Integrated within BOBST Connect
- Two sets of lightweight hooks and shafts
- Easily positioned, allowing for great flexibility



Perfect quality
- Leverages artworks' PDF data
- Increases quality & reduces human errors
- Better production quality because setup is done by more competent and informed people.

> At a glance
> Packaging market
> Benefits and features
  > 1 – 9
  > BOBST technology
> Specifications
  > Measurements
  > Configurations
  > Technical information
> Related Products
  > ACCUCHECK
  > ACCUBRAILLE
  > SPEEDWAVE
  > GYROBOX
  > NICK BREAKER
  > SPEEDHOOK
  > Peripherals
> Services
  > General services
  > BOBST Connect

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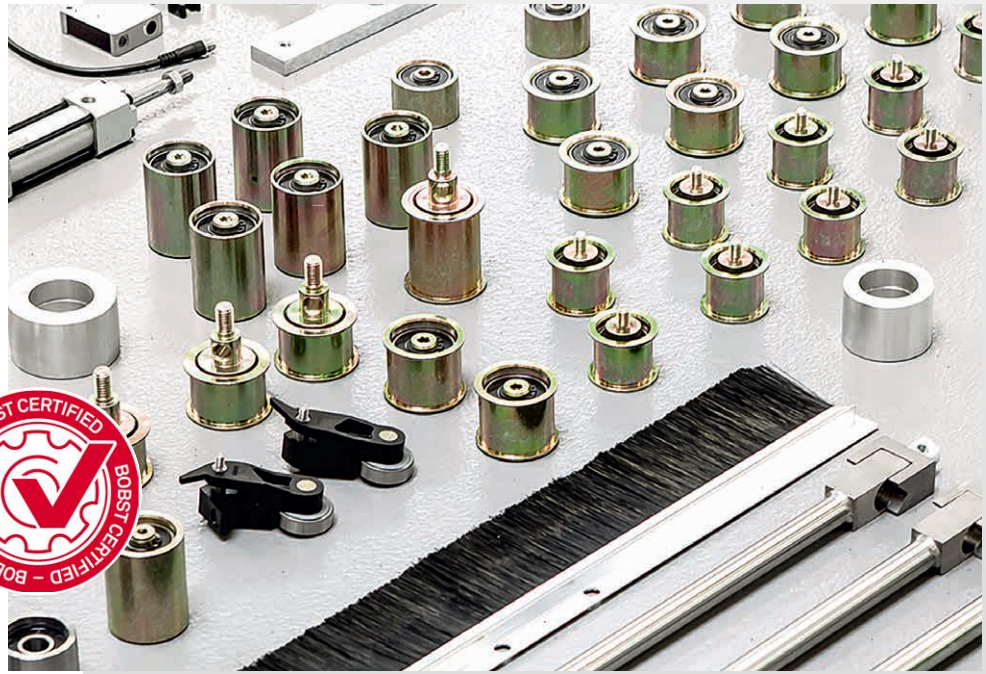
BOBST

Maintaining **excellence**

Expert services for all your equipment.
Improve your processes, boost your productivity and enhance your expertise with a complete range of services from BOBST.



Maintenance Plus

- Scheduled maintenance with BOBST certified technicians
- Preventative intervention, maximizing machine uptime
- Optimum performance over the equipment lifetime

> WATCH VIDEO

Approved parts and logistics

- BOBST Original and Certified parts, and consumables
- Quality assurance, and extended maintenance intervals
- Worldwide distribution, and full availability where and when you need it

> LEARN MORE

Machine upgrades

- Additional features, configured for your machine
- Enhanced functionality, connectivity and capability
- Future-proofing your investment, maintaining competitive advantage

> LEARN MORE

> At a glance
> Packaging market
> Benefits and features
  > 1 – 9
  > BOBST technology
> Specifications
  > Measurements
  > Configurations
  > Technical information
> Related Products
  > ACCUCHECK
  > ACCUBRAILLE
  > SPEEDWAVE
  > GYROBOX
  > NICK BREAKER
  > SPEEDHOOK
  > Peripherals
> Services
  > General services
  > BOBST Connect

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BOBST

Digital age manufacturing happening with BOBST Connect

BOBST Connect is an end-to-end, user-centric digital platform that enhances and increases your packaging productivity. It's designed to help you make the most of the data your machine generates, improving efficiency across your value chain.

As well as exceptional data insights, BOBST Connect helps to orchestrate and improve your whole production process, from your PDF to the finished product and quality report. It brings data and digital services together in one fully connected platform, with machine insights and expertise built in.

All of this is available to you as part of BOBST Connect Essential, the first subscription level that you receive when you purchase a new BOBST machine.



Performance analysis
- Production insights, including interaction of OEE components
- Identify and eliminate performance gaps

Accurate reporting
- Meaningful insights on OEE and downtime
- Accurately measure target speed and quality losses
- Trend analysis over time

Progress indicator
- Highlights extensive production deviations
- Empowers timely interventions

Remote assistance
- Priority access to technical specialists
- Video with Augmented Reality expert support based on real-time data
- Available 24/7 (optional)

Shift management
- Optimize planning time
- Deliver overall resource efficiency

> At a glance
> Packaging market
> Benefits and features
  > 1 – 9
  > BOBST technology
> Specifications
  > Measurements
  > Configurations
  > Technical information
> Related Products
  > ACCUCHECK
  > ACCUBRAILLE
  > SPEEDWAVE
  > GYROBOX
  > NICK BREAKER
  > SPEEDHOOK
  > Peripherals
> Services
  > General services
  > BOBST Connect

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Non-stop **production**

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> At a glance
> Packaging market
> Benefits and features
  > 1 – 9
  > BOBST technology
> Specifications
  > Measurements
  > Configurations
  > Technical information
> Related Products
  > ACCUCHECK
  > ACCUBRAILLE
  > SPEEDWAVE
  > GYROBOX
  > NICK BREAKER
  > SPEEDHOOK
  > Peripherals
> Services
  > General services
  > BOBST Connect

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