

# Premium gravure at **unrivalled productivity**



IN-LINE PRINTING AND CONVERTING

LEMANIC® RIVIERA ILS

At a glance

# Delivering excellence

The **LEMANIC® RIVIERA ILS** is the reference web-fed gravure printing and converting line in the market for cardboard, delivering finished blanks in a single machine pass. Highly modular it can perform a host of inline processes, bringing a whole spectrum of solutions to the packaging industry. Chosen by famous worldwide brand owners, this line continuously delivers high volumes of the most challenging jobs for the tobacco, food, liquid packaging and general folding carton industries.



**Ultimate** process versatility

**Exceptional** printing flexibility

**BOBST Connect Essential**, data and connectivity, **as standard**

**BOBST**

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# Creating value

**BOBST innovations**  
are driven by customer  
and brand owner needs.

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## 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.



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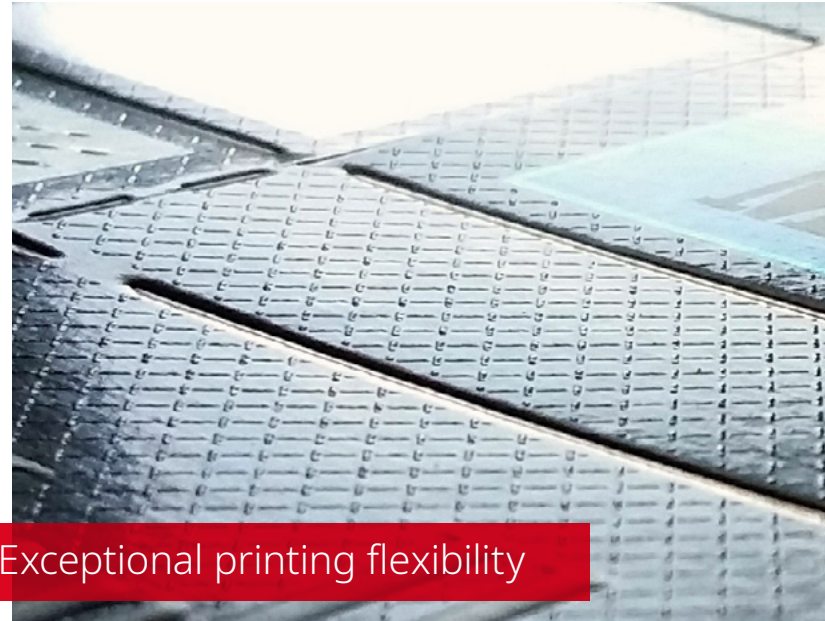
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### Ultimate process versatility

#### Exceptional configuration possibilities

- Reel to reel
- Reel to converting (flat-bed cutter-creaser, rotary die-cutter & sheeter) or any of the above combinations
- Mastering the printing & converting processes through highly automated operation and energy efficient solutions
- Striking production speeds without compromising on register accuracy
- Fully automated change-overs with off-press preparation



### Exceptional printing flexibility

#### Most efficient printing results

- Vast printing flexibility with gravure and flexo, either UV, water or solvent-based inks
- Wide range of ink types: standard CMYK, pantone, metallic, fluorescent, pearlescent, luminescent, iridescent, polychromatic, tactile and many more
- Exclusive drying capacity for minimal solvent retention
- Fully equipped printing carriage (P-cart) for highly efficient job change-overs and set-up operations

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### Exceptional reliability

The combined action of the electronic line shaft and Registron® Integrated register control delivers outstanding print-to-print and convert-to-print accuracies with the highest color consistency and repeatability.



### Economic and versatile

#### Minimize waste

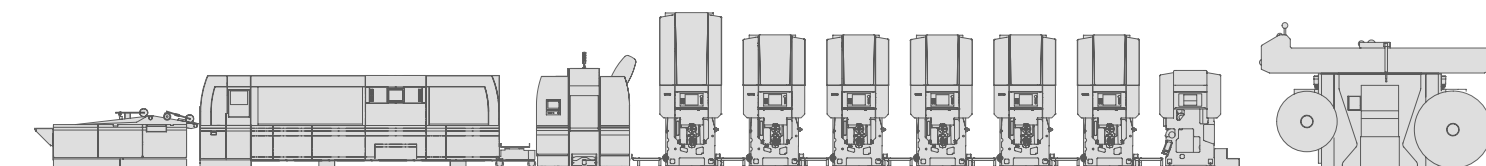
- 30% shorter web length than conventional presses
- No turn bars for back printing or before converting: presenting always the printed side up through the entire production process
- Minimal ink circulation volume
- Adapting automatically to different quality of reels

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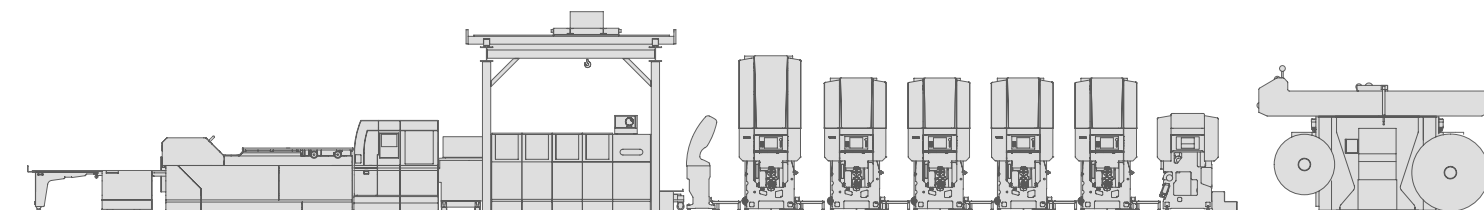
Line specifications	LEMANIC® RIVIERA ILS - FCC 82 HS		LEMANIC® RIVIERA ILS - SHEETER	
Paper and board	200 – 500 g/m <sup>2</sup>	8 – 32 points	80 – 500 g/m <sup>2</sup>	4 – 32 points
Web width	410 – 820 mm	16.1 – 32.2 in	410 – 820 mm	16.1 – 32.2 in
Ink types	Solvent-based	Solvent-based	Solvent-based	Solvent-based
	Water-based	Water-based	Water-based	Water-based
	UV curable	UV curable	UV curable	UV curable
Number of printing units	up to 14 units	up to 14 units	up to 14 units	up to 14 units
Heating system	Electrical/steam/thermal oil	Electrical/steam/thermal oil	Electrical/steam/thermal oil	Electrical/steam/thermal oil
Production speed, up to	250m/min	820 ft/min	300 m/min	984 ft/min
Option max speed, up to	-	-	350 m/min	1150 ft/min
Printing feed-up	410 - 820 mm	16.1 - 32.2 in	410 - 820 mm	16.1 - 32.2 in
Converting feed-up	365 - 750 mm	14.3 - 29.5 in	410 - 1060 mm	16.1 - 41.7 in
	365 - 820 mm in sheeting mode	14.3 - 32.2 in in sheeting mode		
Unwinding diameter	paper	-	1200 mm	48 in
	board	1850 mm	1850 mm	72.8 in
Core diameter	paper	-	152.4 mm	6 in
	board	300 mm	300 mm	12 in
Web tension	paper	-	0.12 to 0.5 kN/m	0.68 to 2.85 P/LI*
	board	Up to 1.5 kN/m	Up to 1.5 kN/m	Up to 8.57 P/LI*
<b>Option reel-to-reel/rewinder in by-pass</b>				
Paper and board	70 – 500g/m <sup>2</sup>	4 - 32 points	-	-
Production speed, up to	300 m/min (option 400 m/min)	984 ft/min (option 1312 m/min)	-	-

All technical data is subject to change without notice  
 \*P/LI - Pounds per linear inch  
 Metric figures prevail

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### Line specifications

### LEMANIC® RIVIERA ILS - DRIVE & V-DRIVE

Paper and board	180 – 500 g/m <sup>2</sup>	8 – 32 points
Web width	410 – 850 mm	16.1 – 33.5 in
Ink types	Solvent-based	Solvent-based
	Water-based	Water-based
	UV curable	UV curable
Number of printing units	up to 14 units	up to 14 units
Heating system	Electrical/steam/thermal oil	Electrical/steam/thermal oil
Production speed, up to	275 m/min	902 ft/min
Option max speed, up to	400 m/min	1312 ft/min
Printing feed-up	410 - 820 mm	16.1 - 32.2 in
Converting feed-up	750 - 1280 mm	30 - 50 in
Unwinding diameter	paper	-
	board	1850 mm
Core diameter	paper	-
	board	300 mm
Web tension	paper	-
	board	Up to 1.5 kN/m

### Option reel-to-reel/rewinder in by-pass

Paper and board	70 – 500 g/m <sup>2</sup>	4 - 32 points
Production speed, up to	300 m/min (option 400 m/min)	984 ft/min (option 1312 ft/min)

All technical data is subject to change without notice

\*P/LI - Pounds per linear inch

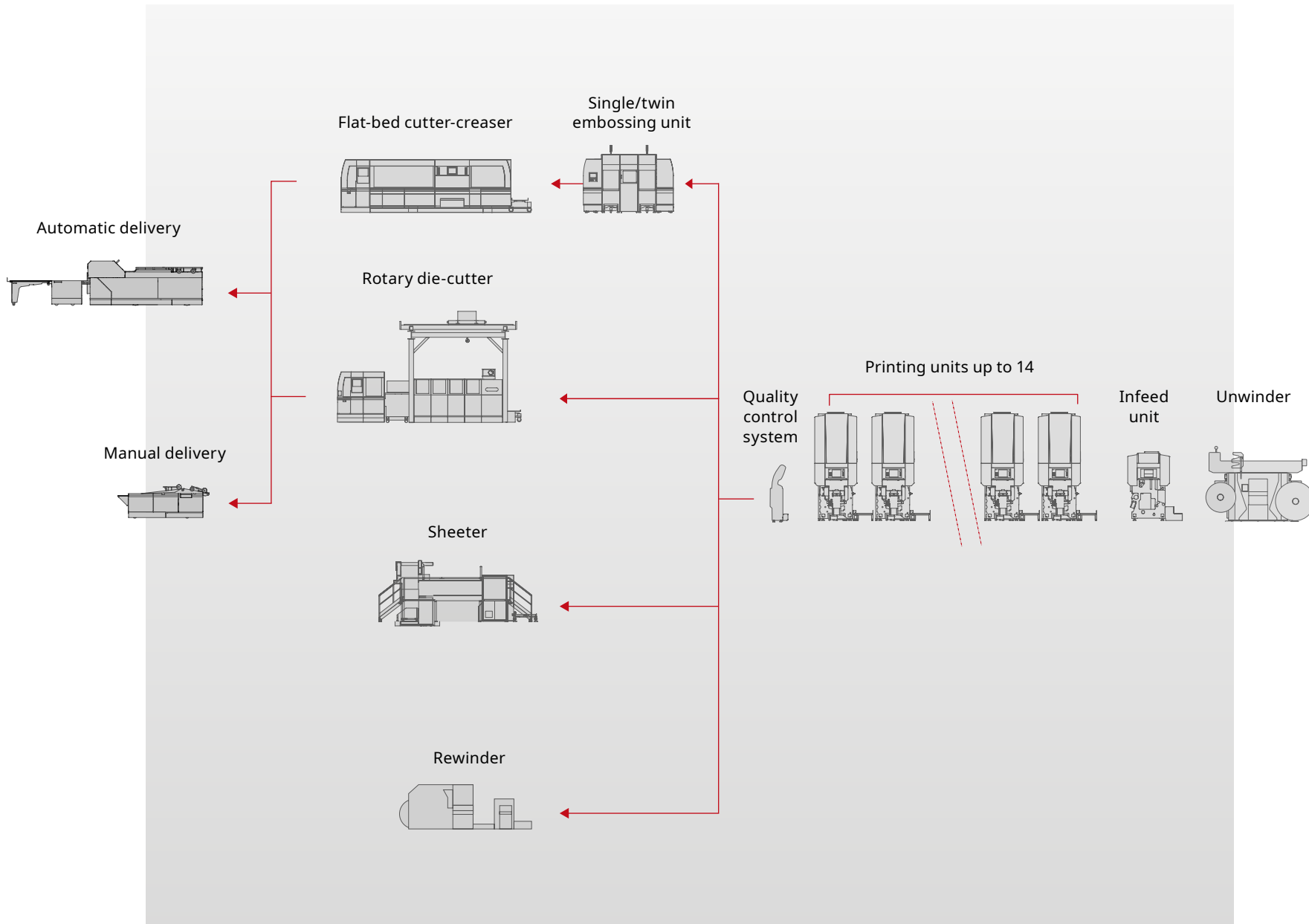
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## Related products 1 - 3



### > LEMANIC® DRIVE

The rotary converting method is the most consistent in terms of quality and the most cost-effective for high volumes. The DRIVE rotary die-cutter unit is designed to provide dynamic stability up to 400 m/min. The effective production speed of the DRIVE system results in a production capacity of more than 2.5 billion saleable blanks per year.

The LEMANIC® DRIVE is a modular system providing the flexibility to meet future production needs. The system consists of one to four independently driven converting stations, delivering multiple embossing, creasing, and cutting solutions. The V-DRIVE version (variable adjustment of the tool width from 550 mm to 850 mm) allows users to reduce tooling cost by adapting the tools to the exact web width.



### > LEMANIC® FCC 82 HS - FLAT-BED CUTTER-CREASER

In a market with frequently changing box sizes and introducing new shapes, the LEMANIC® FCC 82 HS flat-bed cutter-creaser is ideally suited for high flexibility combined with low cost tooling, resulting in cost-effective operation.

BOBST flat-bed cutter-creaser sets new standards in accuracy and consistency, quick set-up times and waste reduction. The new web loop system guarantees 100% web tension control for consistent production speeds up to 370 strokes/min or 22'200 strokes/h. Perfect control and transport of converted blanks at the platen outfeed guarantees accurate stripping and flow consistency.



### > LEMANIC® SEPARATOR

LEMANIC® SEPARATOR is a fully automated module. It spreads the blanks break the nicks to achieve aligned and homogeneous shingled streams for continuous production output. Thanks to its ultra fast set-up in only three minutes, it contributes in adding up to 30% of additional productivity. The SEPARATOR can eject single defect blank when detected by the BOBST quality control system, at any production speed.

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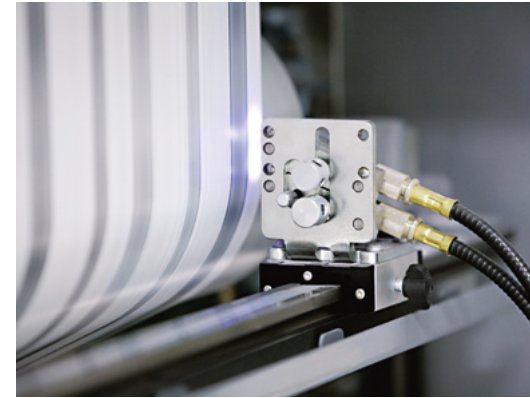
### > Registron® iQ 400

Registron® iQ 400 is the gateway to zero fault quality production levels for international brands. This in-line quality inspection system is fully integrated in the LEMANIC® lines, scanning 100% of the web surface at all speeds, 100% of the time. Thanks to secured pre-set quality levels, each job is screened with customized parameters and preventive warning levels. Eventual defects are automatically classified, recorded, tracked and even ejected down to a single blank at full production speed.



### > LEMANIC® SLEEVEEXPERT

LEMANIC® SLEEVEEXPERT is an independent servo driven embossing unit. Equipped with the Registron® control system, it guarantees incomparable embossing accuracy and a tangible value-added features to the packaging. The SLEEVEEXPERT has been designed to combine quality production with ease of use. The sleeve tooling technology allows quick job changeover from the operator side without cutting the web. Thus allowing lower cost, faster changeovers and lead times. Solid embossing tools may be used as well, exempt from any gears and cassette.



### > Registron® S 6100 D

Registron® ensures optimum product quality with tight and consistent accuracy for all registered processes. Fully integrated in the LEMANIC® lines, it ensures minimal waste for all production steps, regardless of the press configuration. Its highly advanced set of features deals with a broad range of applications including virgin, recycled and holographic laminated boards, very low contrast varnishes and even in-setting for pre-printed board.

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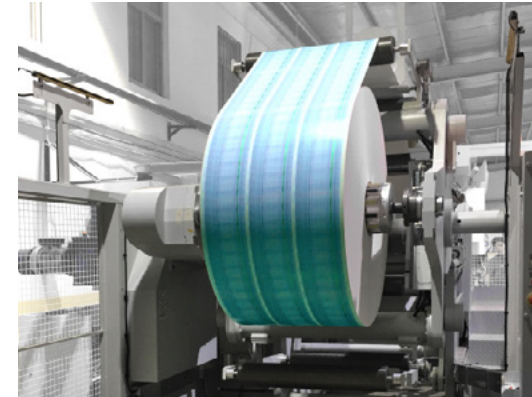
### > LEMANIC® SPEEDFLOW

LEMANIC® SPEEDFLOW is an automatic delivery module creating perfect piles of blanks, printed side up. The SPEEDFLOW processes up to five metric tons of stacked piles in a working day. This leads to optimum production, reduction of operator interventions and is ideally suited for linking to automated palletization systems.



### > SHEETER

The LEMANIC® SHEETER is suitable for many applications, including low volume productions such as product launches and jobs requiring off-line value-adding processes. The sheets are perfectly registered by the integrated Registron® control, combined with the side trimming knives, thus ensuring the requirements for downstream processes like hot-foil stamping, silk-screen printing, offset over-printing and die-cutting, among others. The sheeter's cutting head is adapted to its applications for a sustainable clean cut at high speeds over a broad grammage range. Productivity is increased further with features such as sheet rejection gate or integrated fast palette exchange system.



### > REWINDER

Add process flexibility. Paper or light board can be processed by rewinding the printed substrate thus opening up to other market segments.

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# 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.



## Maintain your Investment

- 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

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## Machine upgrades

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

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# 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

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