



WINDLESGROUP



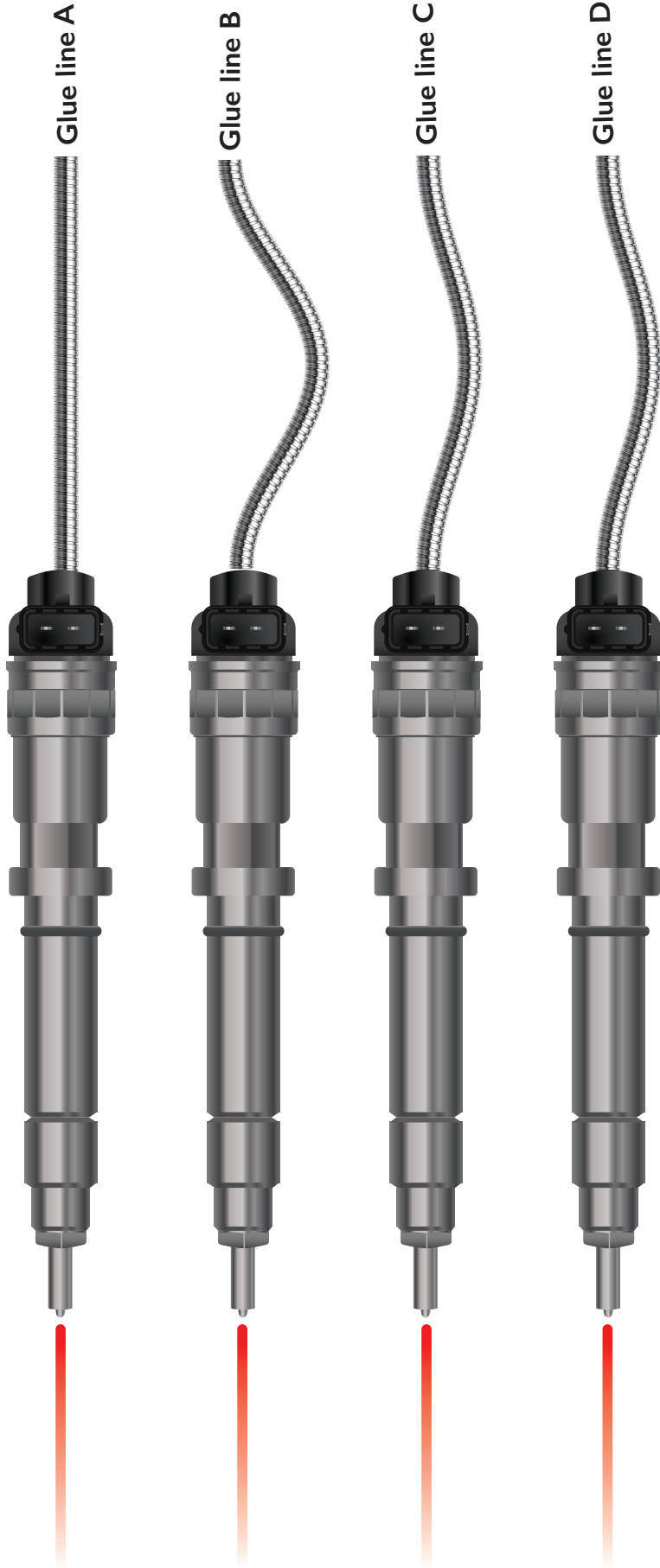
Windles Group are continually developing and expanding our production facilities. This is to both provide a fully holistic offering to our clients, as well as offering new and exciting finishes to design with.

A recent addition to our factory-floor is an extensive and high-speed glue line system by **Bobst**. A very versatile piece of equipment that now allows us to efficiently glue packaging, crash-lock cartons, sleeves, advent calendars, o-rings, and bespoke greeting cards among many other products.

This handy guide - **Don't Get Stuck** - takes you through the technicalities and tolerances associated with the new machine. Please refer to these when developing your next product design. If there is something that you feel sits outside these guidelines, then please get in touch, as our ethos is to always *listen, try, develop and create*.

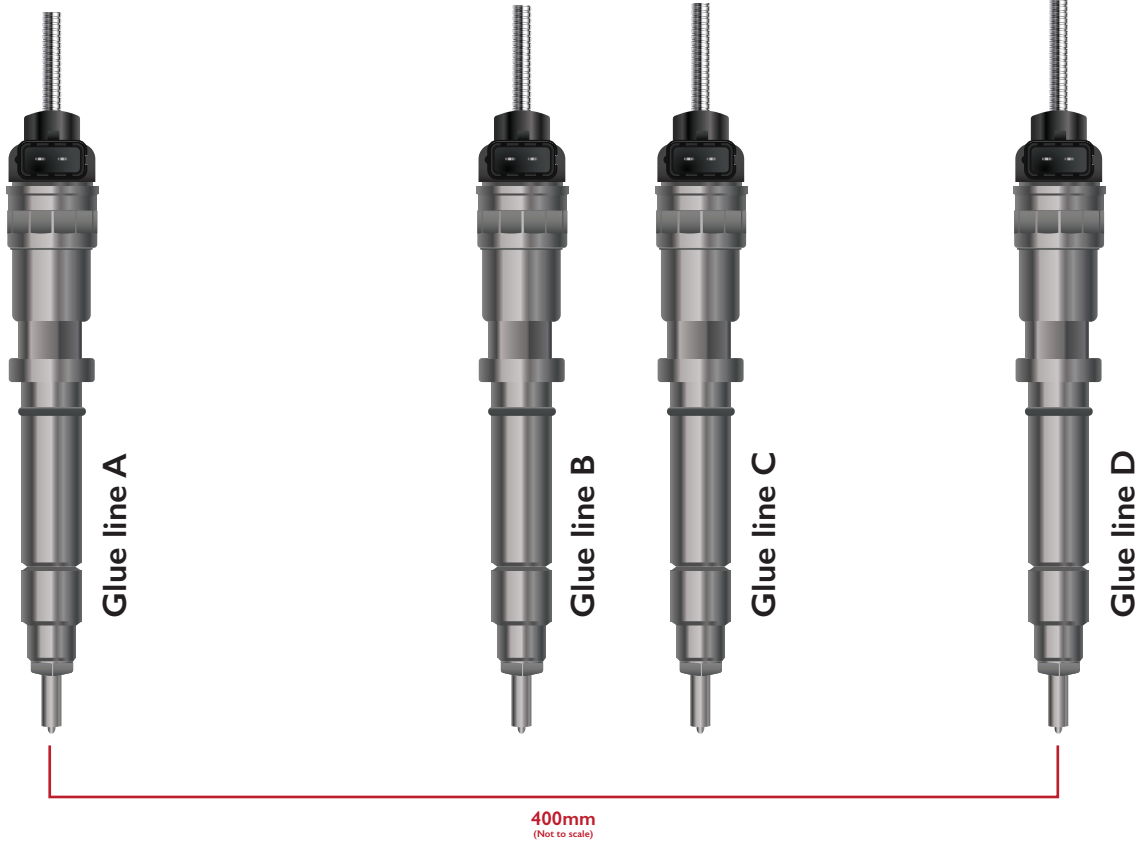


AMOUNT OF GLUE LINES

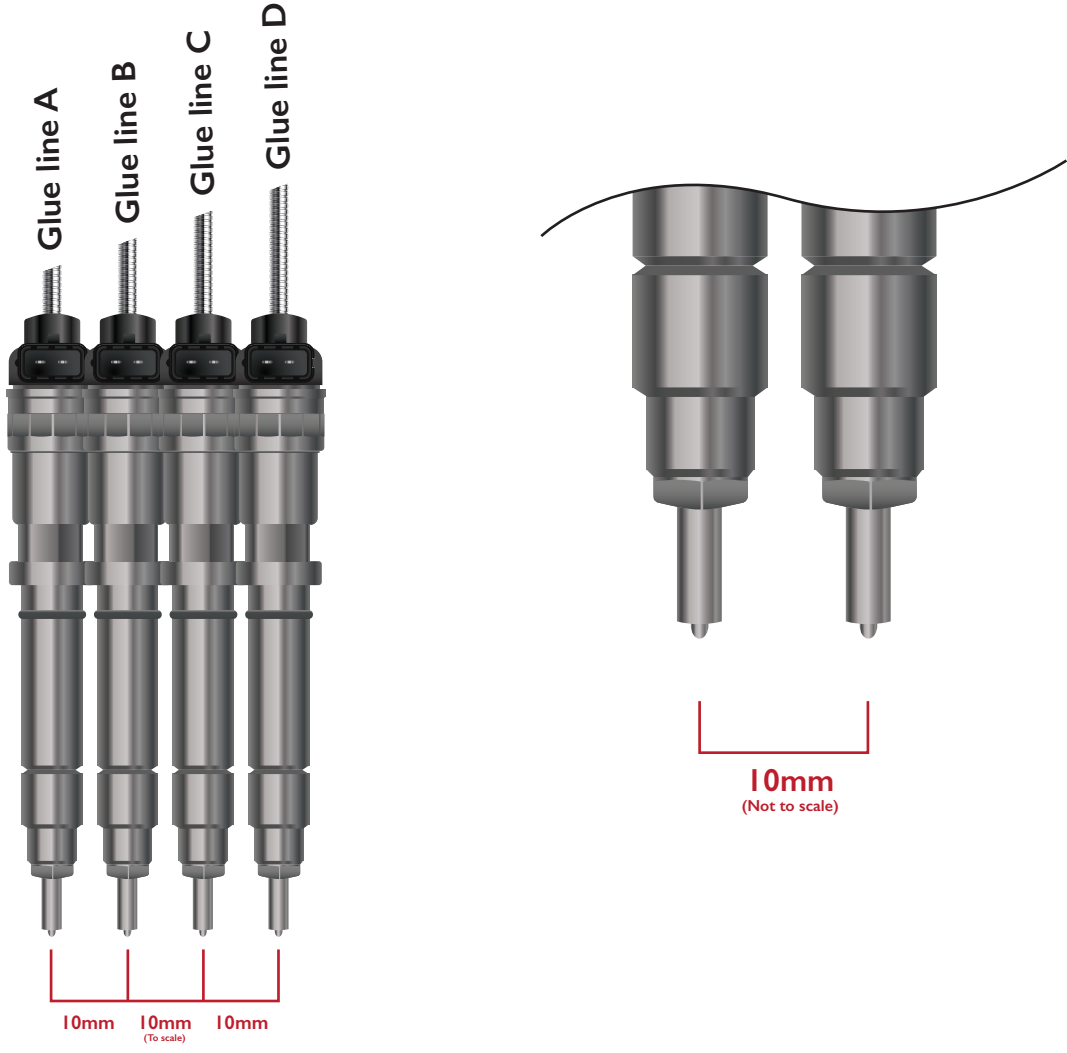


You have the option to use up to a maximum of 4 glue lines on your product design. We recommend using the minimal amount of glue lines to help with efficiency and costings. More can be added with further investment and if the production run requires.

GLUE LINE DISTANCES MAXIMUM

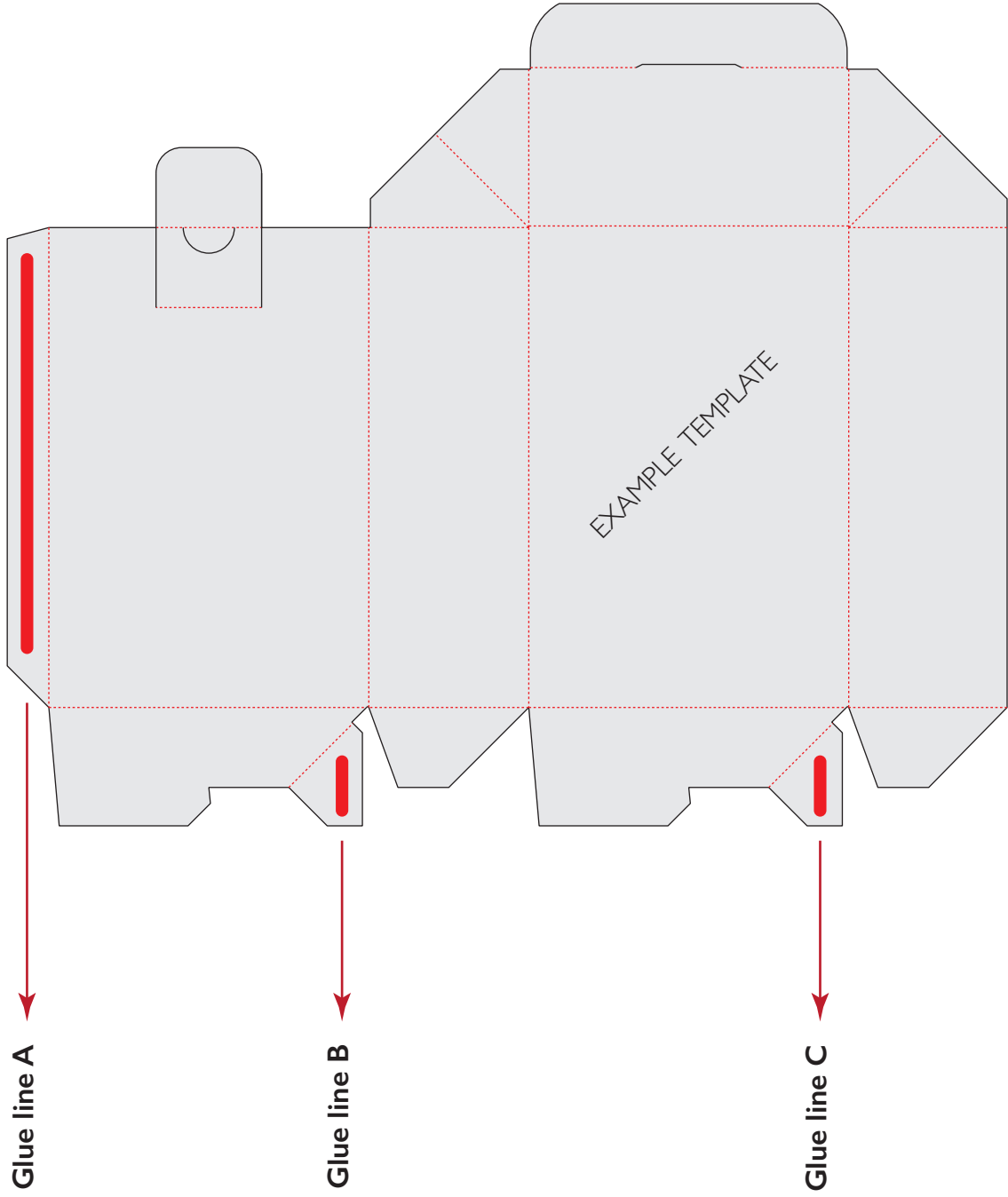


GLUE LINE DISTANCES MINIMUM

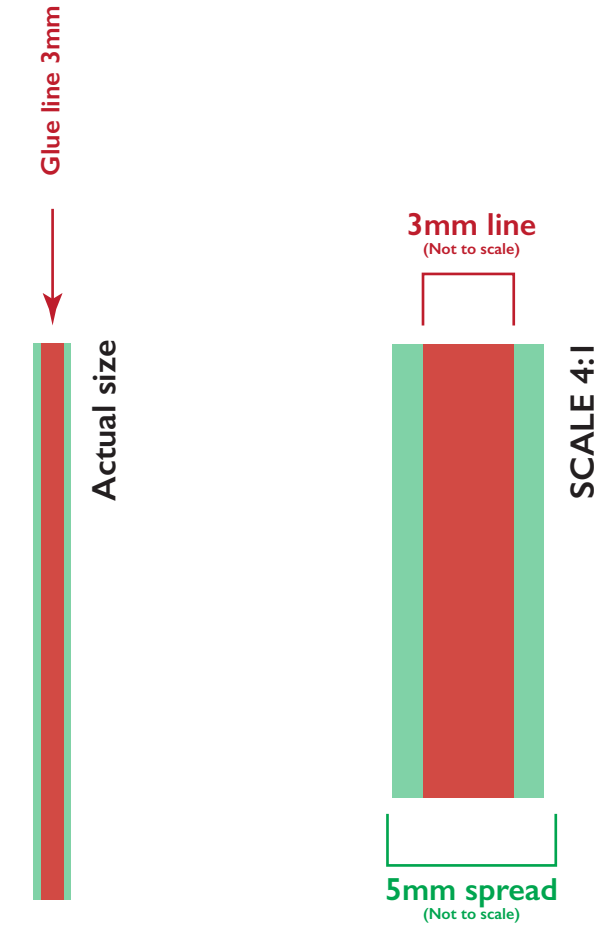


USING PARALLEL GLUE LINES

The glue lines must always be designed and planned to run parallel. They can not taper or run at differing angles. Perpendicular lines are possible, but would require a secondary pass through the machine. We would always want to check the product template before we agree to produce perpendicular glue-lines.

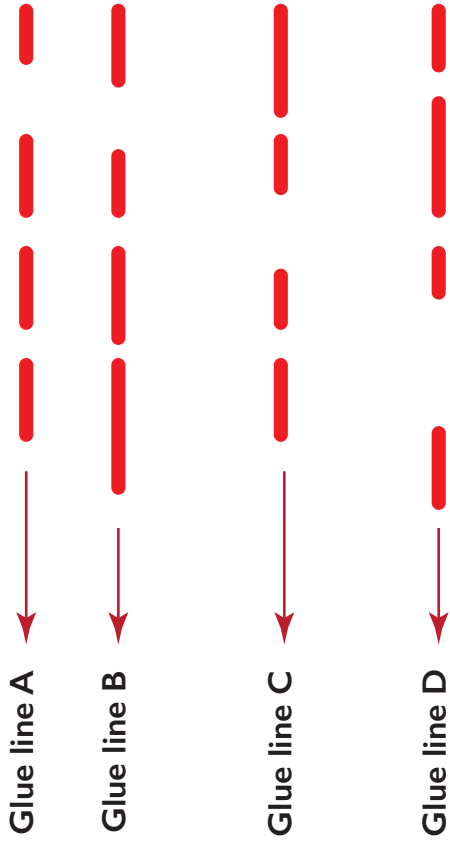


INDIVIDUAL GLUE LINE WIDTHS + SPREAD



The glue lines are 3mm wide at point of application, but do spread to 5mm when the surfaces are squeezed, so please allow for this when designing your product, and how close the glue lines are to edges or die-cut windows/crease/perforations.

LINE FREQUENCY



As long as the glue lines remain parallel you have full flexibility on the frequency of glue points along those lines. We are able to stop/start the glue points very accurately within +/- 0.5mm

DIRECTION OF MACHINE LINES

Glue lines always run length-ways and parallel to the flow of the machine.

