



# The Folding Carton Specialists

CCL Healthcare now offers customers a new range of products: Digital Folding Cartons.

Our equipment is designed to print, cut and glue almost every type of digital folding carton.

In this document we invite you to familiarize yourself with digital folding carton styles used for both automation and manual assembly.

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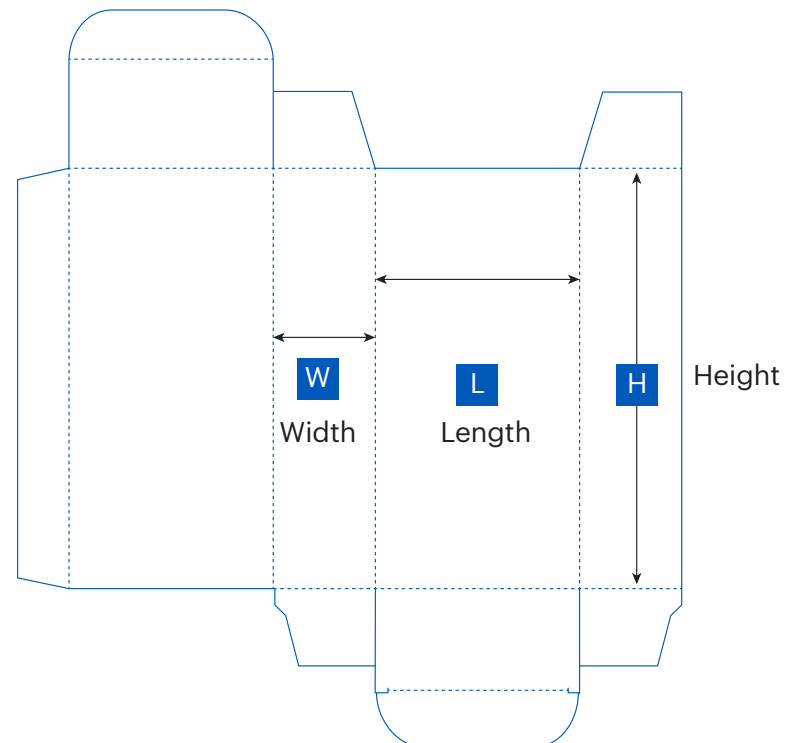
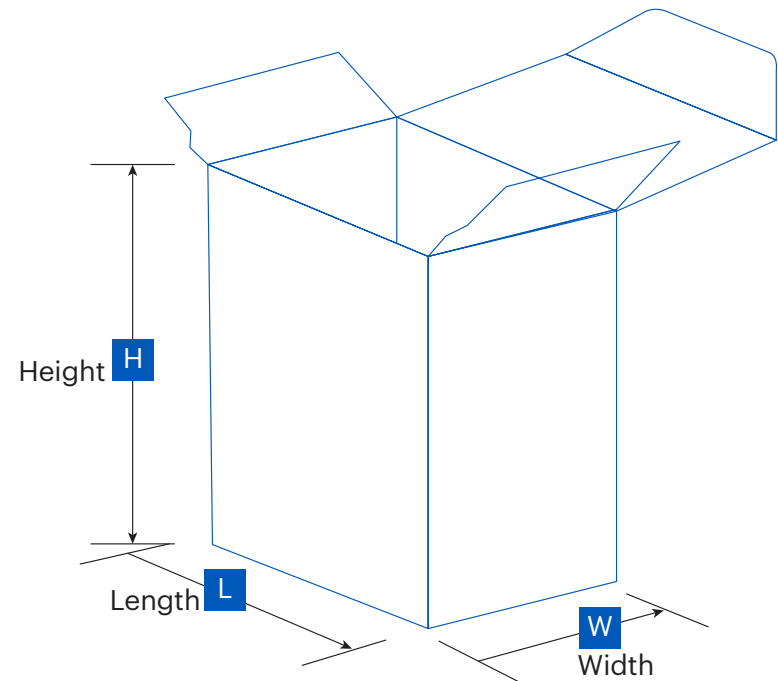
## How to Measure a Folding Carton

When requesting a quote for folding cartons, it's important to be able to provide accurate measurements. There are three dimensions to the basic folding carton: Length (L), Width (W), and Height (H). In written form, the size should appear in that order (L x W x H).

LENGTH (L) measures the longest panel dimension.

WIDTH (W) measures the dimension of the 2nd panel, the shortest.

HEIGHT (H) is the distance between the two open ends of a carton, or from the top of the carton to the bottom of the carton.



## Measuring a Tray Box

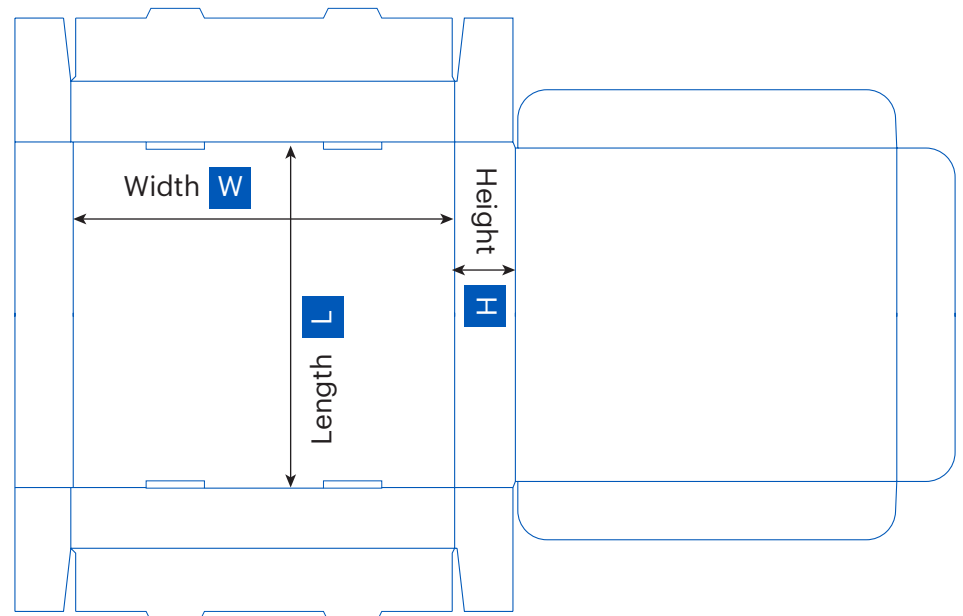
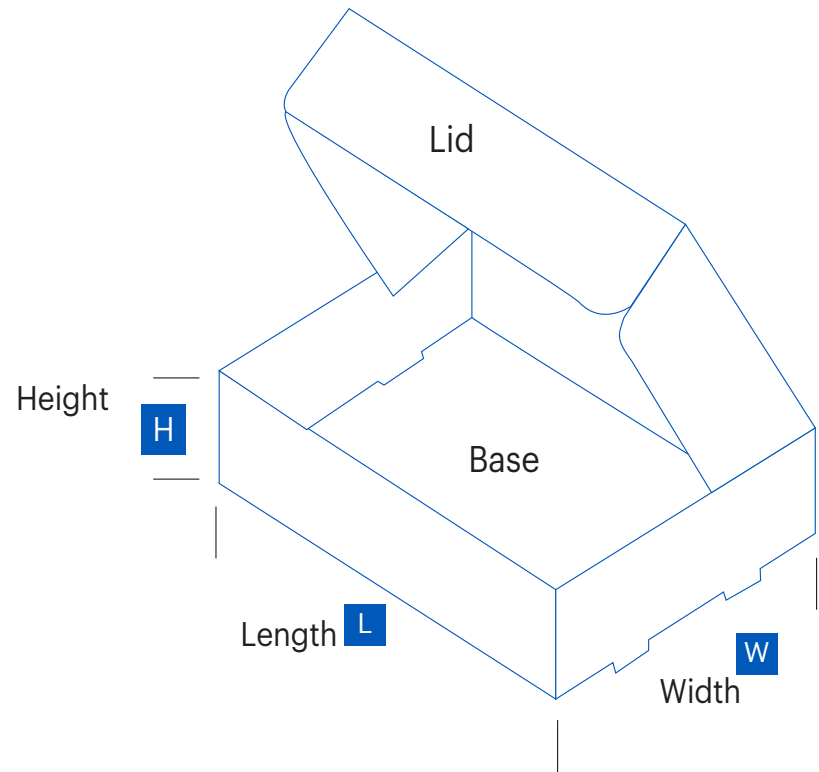
For a tray digital folding carton, the depth becomes the height. Three dimensions (sizes) also create the basic digital folding carton: length (L), width (W) and height (H).

In written formula, it will appear as (L X W X H).

LENGTH (L) is to the distance from side to side.

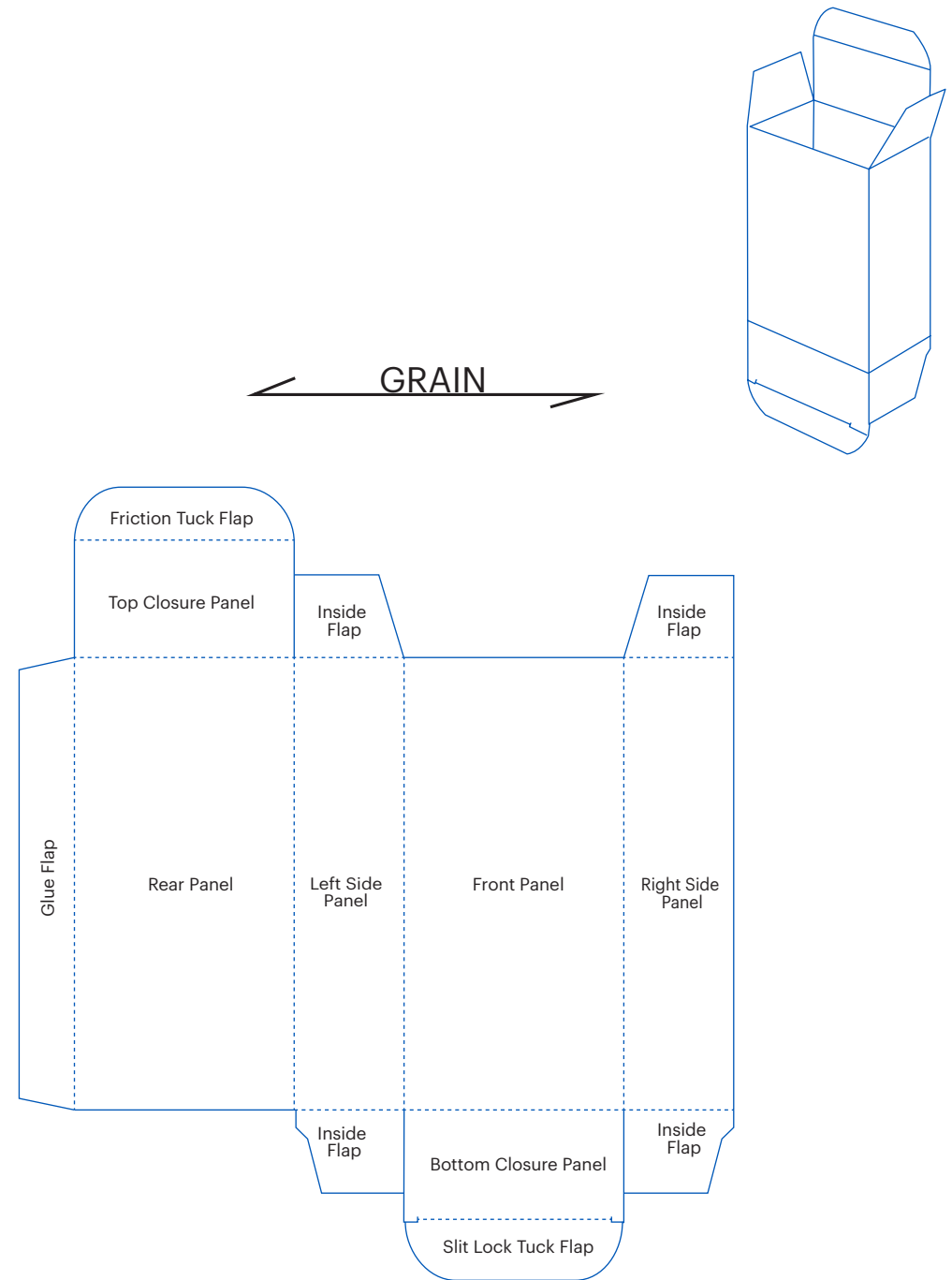
WIDTH (W) is the distance from the front of the carton to the back.

HEIGHT (H) or depth is the distance between the bottom and the lid.



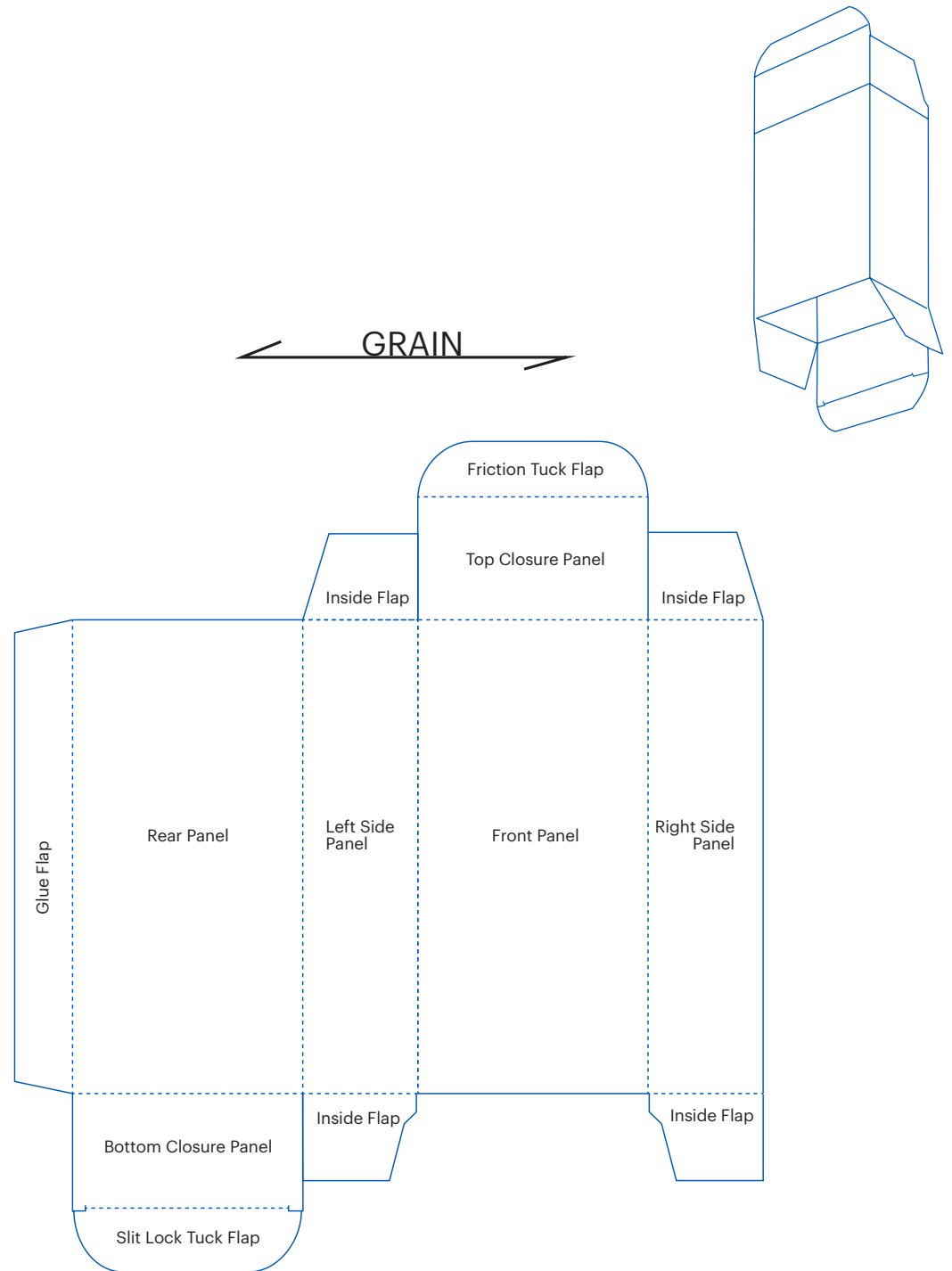
## Standard Reverse Tuck (SRT)

The joint on the Standard Reverse Tuck (also called the Reverse Tuck End or RTE) carton is located at the seam along the right side panel, in the rear. The closure panels on top and bottom swing in opposite directions, with the bottom folding in the rear and the top folding in front. This carton can be assembled either manually or by automation. With a friction lock closure on top and a slit lock tuck closure on bottom, as shown here, the carton is easy to open and close, while remaining unlikely to open inadvertently at its base.



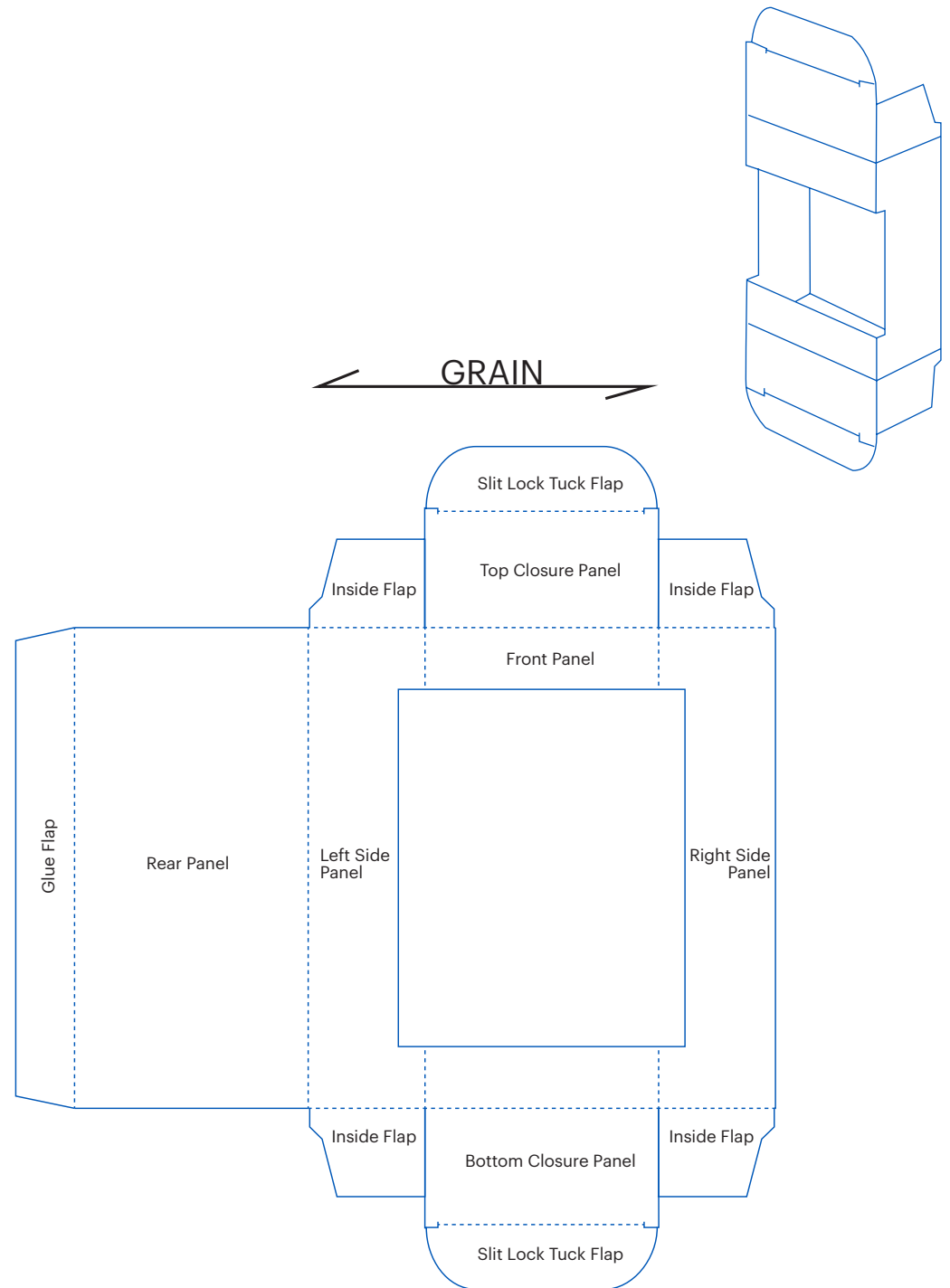
## French Reverse Tuck (FRT)

This style differs from the Standard Reverse Tuck in that the bottom closure is attached in the rear and folds/tucks towards the front of the carton while the top closure is joined in front and folds/tucks towards the rear of the carton. Shown here is a French Reverse Tuck carton with a slit lock bottom and a friction lock top. This style has a finished look and also enables substantial latitude in graphic design. Other available closure styles include the slit lock for top and bottom, and the friction lock for top and bottom.



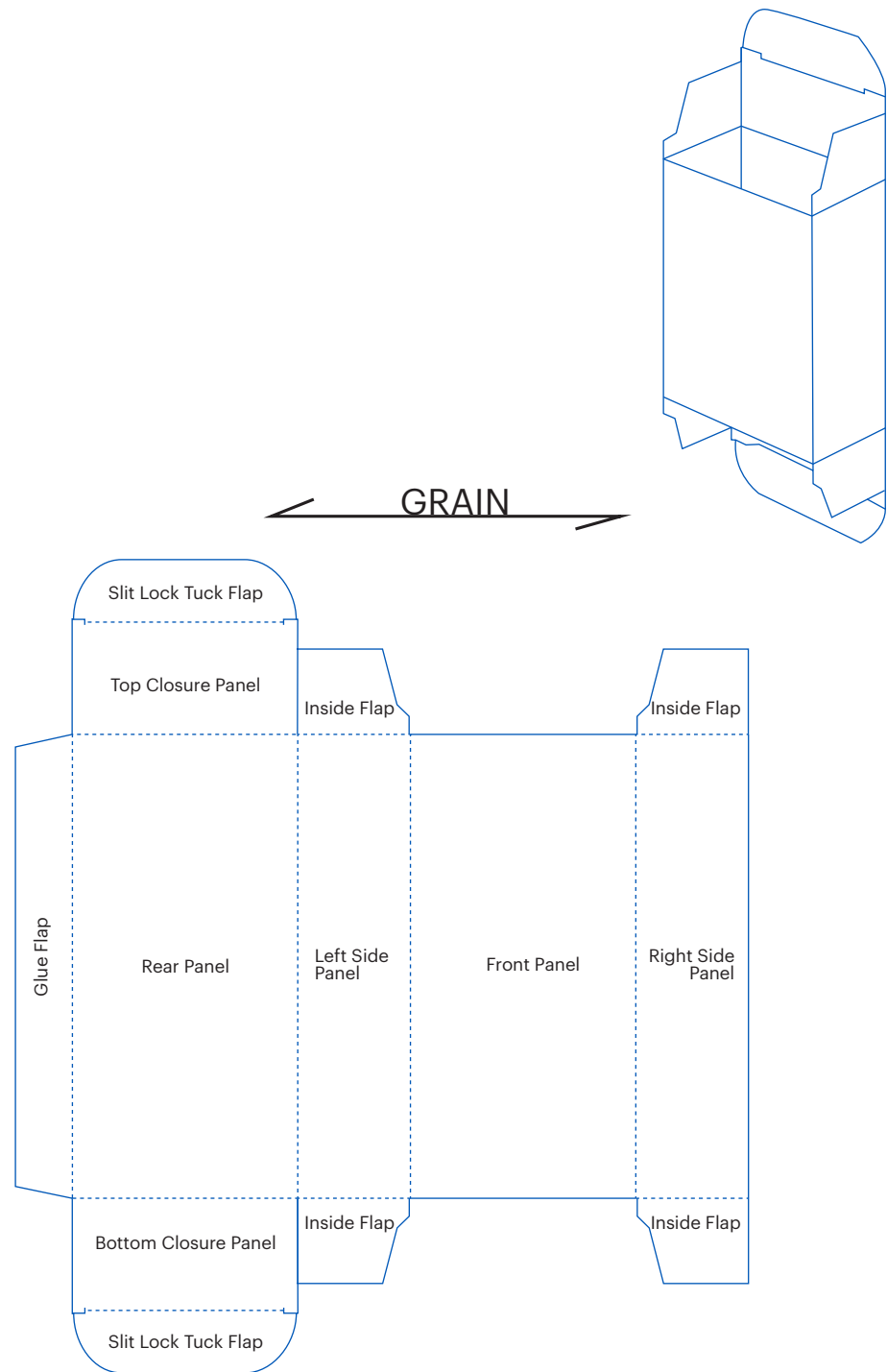
## Standard Straight Tuck (SST)

This style is suitable for products requiring a primary display panel with a large window. With fold/tuck closures in the back, the raw edges at both ends of the front display panel are concealed. The Standard Straight Tuck (also called the Straight Tuck End or STE) also eliminates any interference between the window film material and the tuck, which might occur if a reverse tuck style were to be used. This carton is suitable for manual assembling, as well as automated assembling and closing applications.



## Airplane Straight Tuck (AST)

Unlike the Standard Straight Tuck, this style features closure panels on both the top and bottom that swing from the rear to tuck in the front.

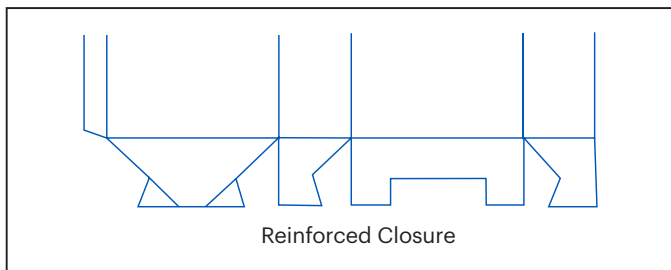
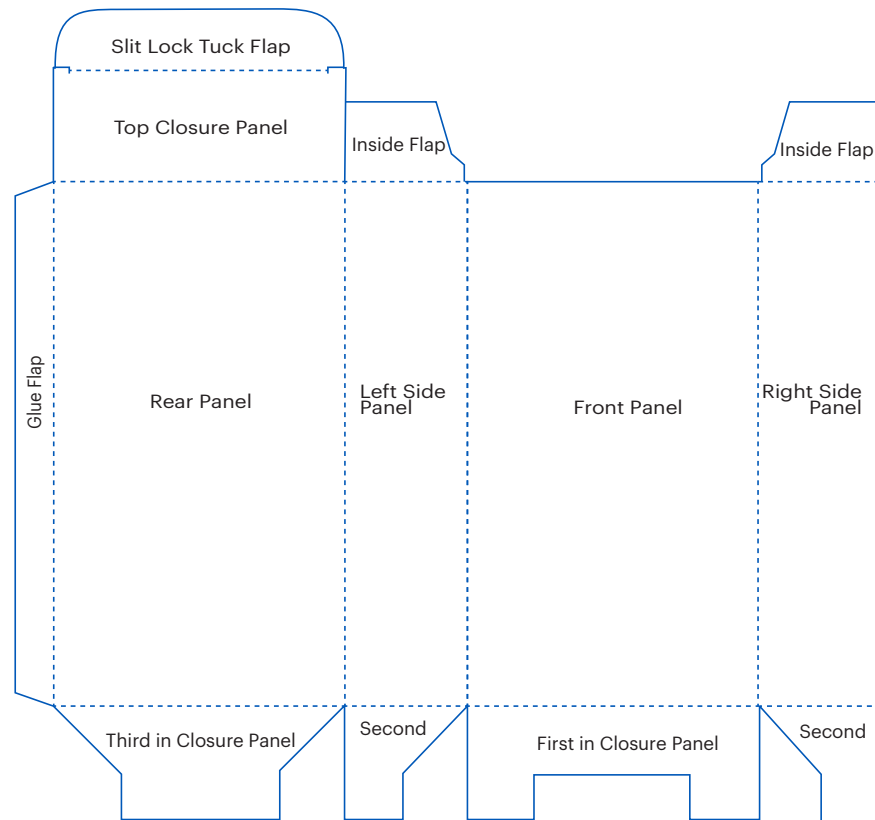
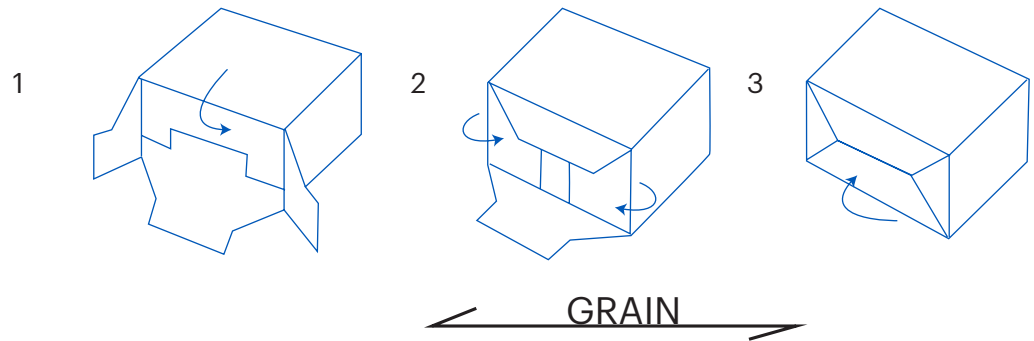




## Houghland Snap Lock Bottom

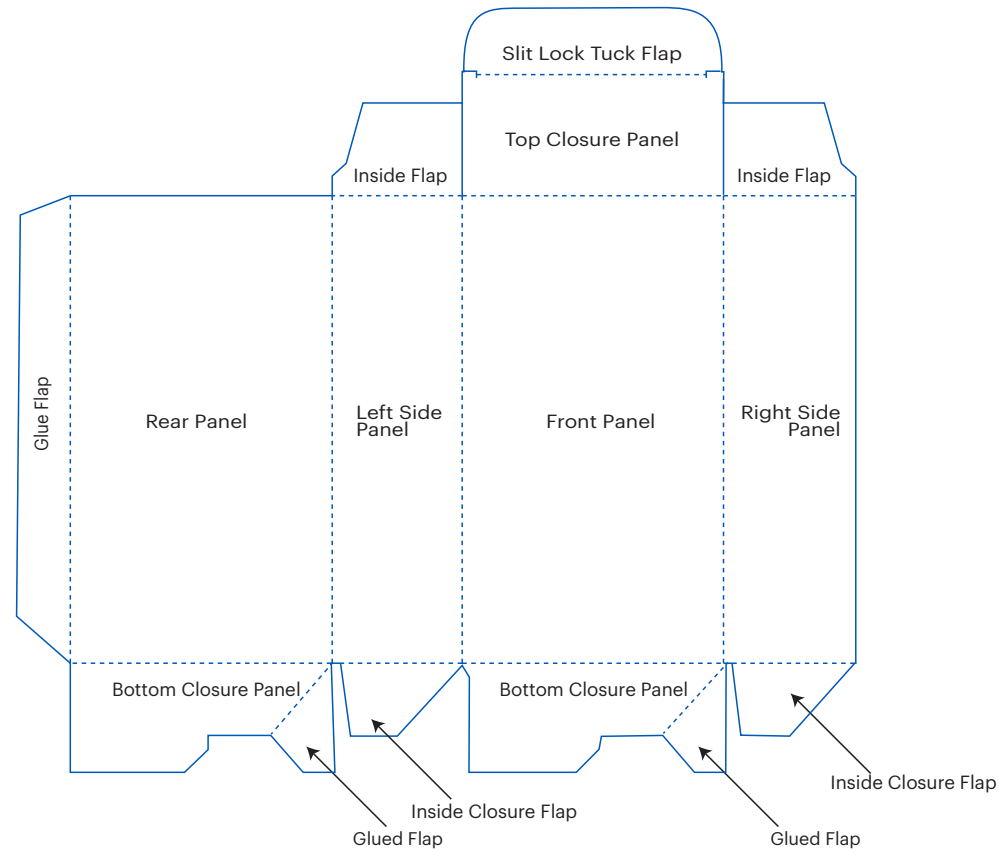
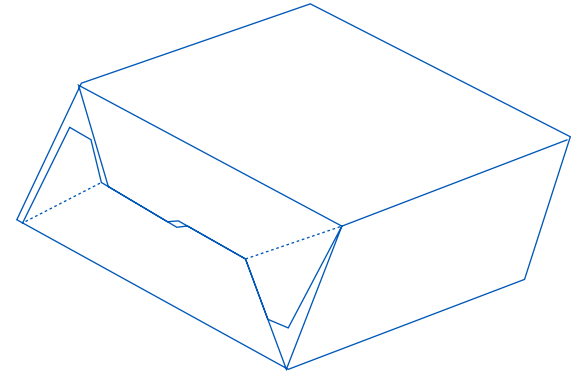
Originally known by its inventor's name (Houghland), this style is more generally known today as the 1-2-3 closure or Snap lock. Usually paired with a top tuck closure, the 1-2-3 is almost always employed as a bottom closure, and is assembled and sealed manually. This closure style may be applied in a shallow-depth or tube-style counter display carton.

Closing Sequence



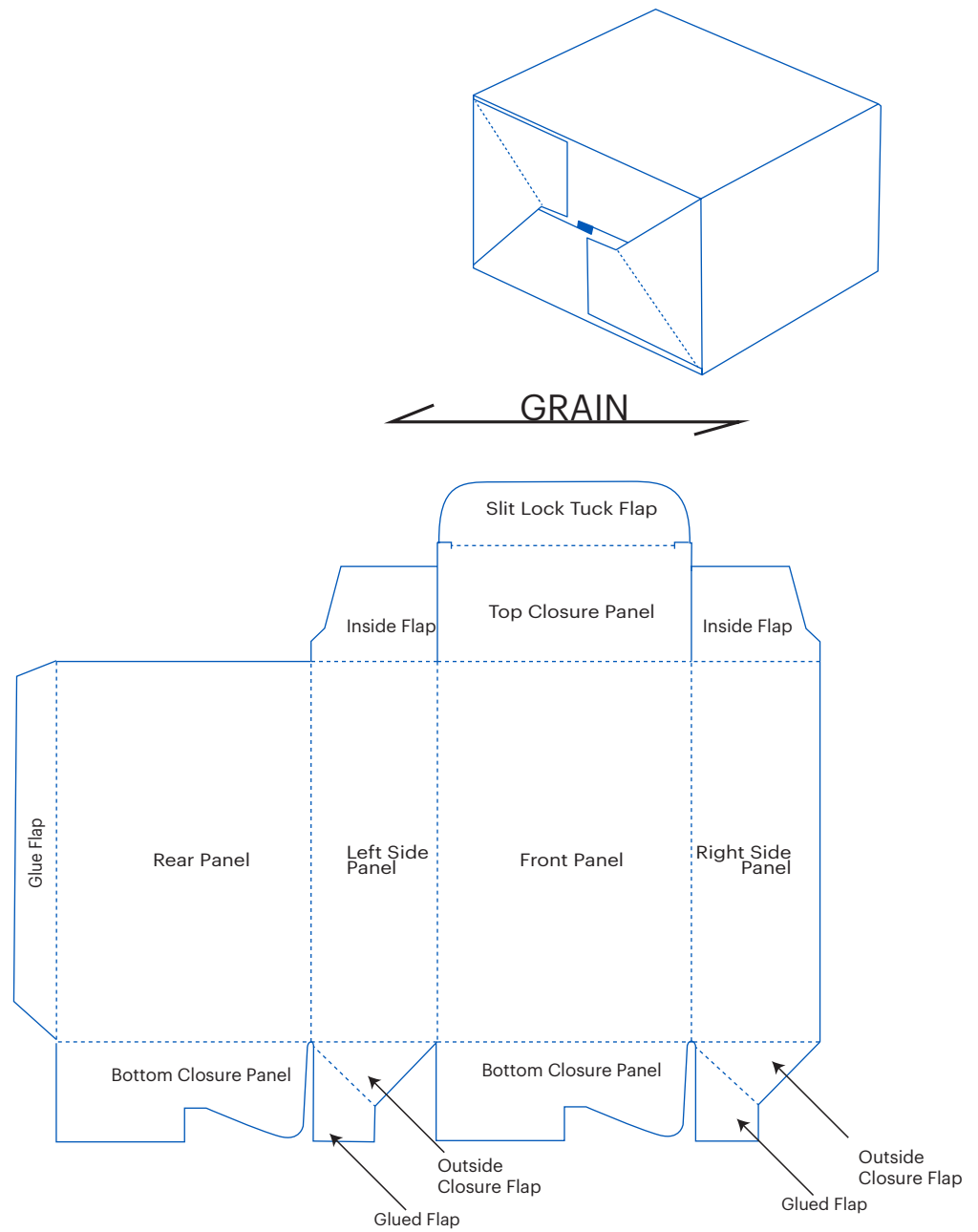
## Hymes Lock, Automatic Bottom

Pre-glued in the converter's facility, the Hymes Lock, Automatic Bottom (Crash Lock, Economy or Popcorn Bottom) style is assembled by hand. It is generally employed when quick setup is required for smaller production volumes that do not warrant investing in automatic packaging equipment.



## Infold Automatic Bottom

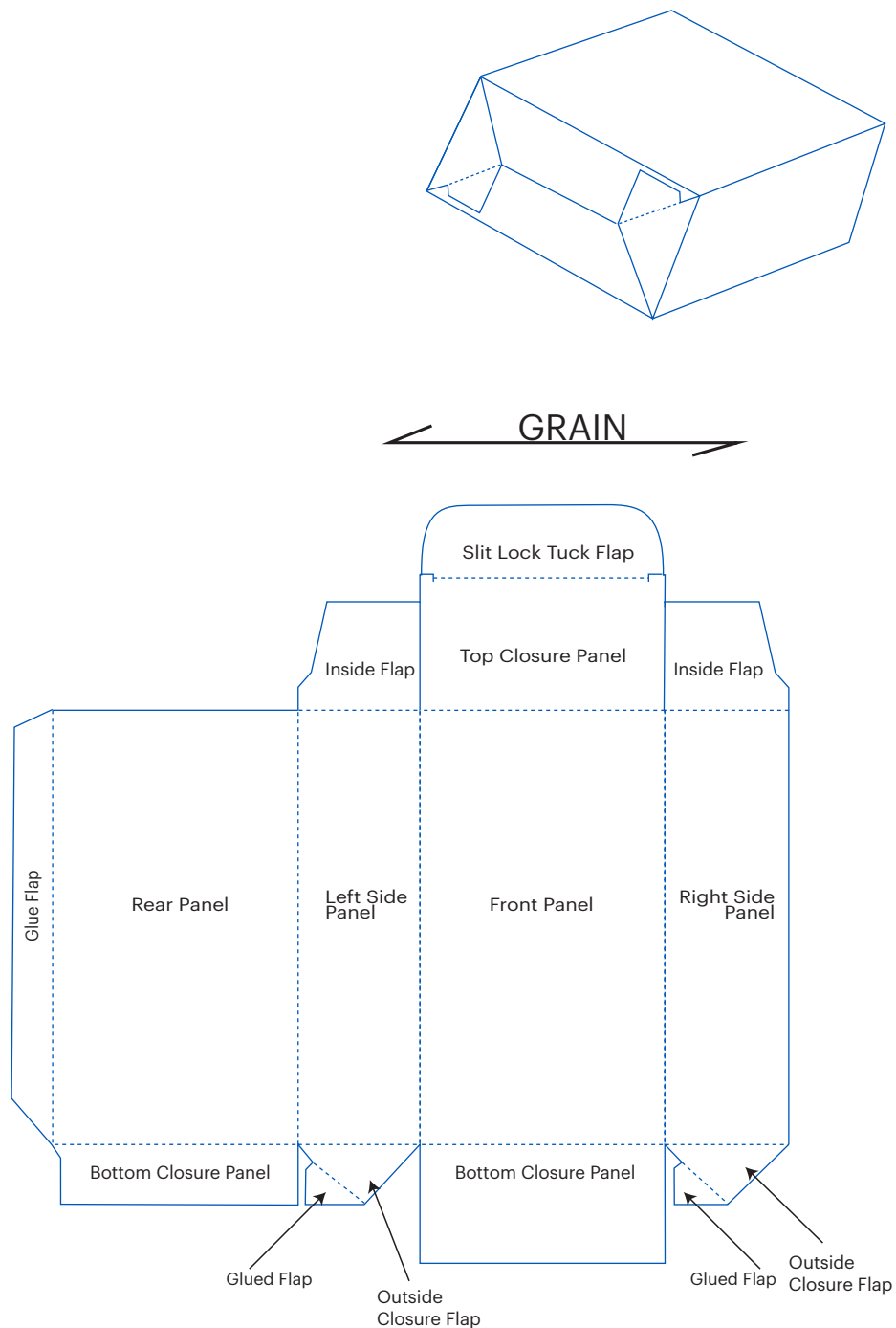
This style differs from the Hymes or Crash Lock in the placement of the fold line. While the Hymes lock features a diagonal fold on the major closure panel, the infold style's diagonal fold line is on the minor end closure flap.



## Full Flap Automatic Bottom

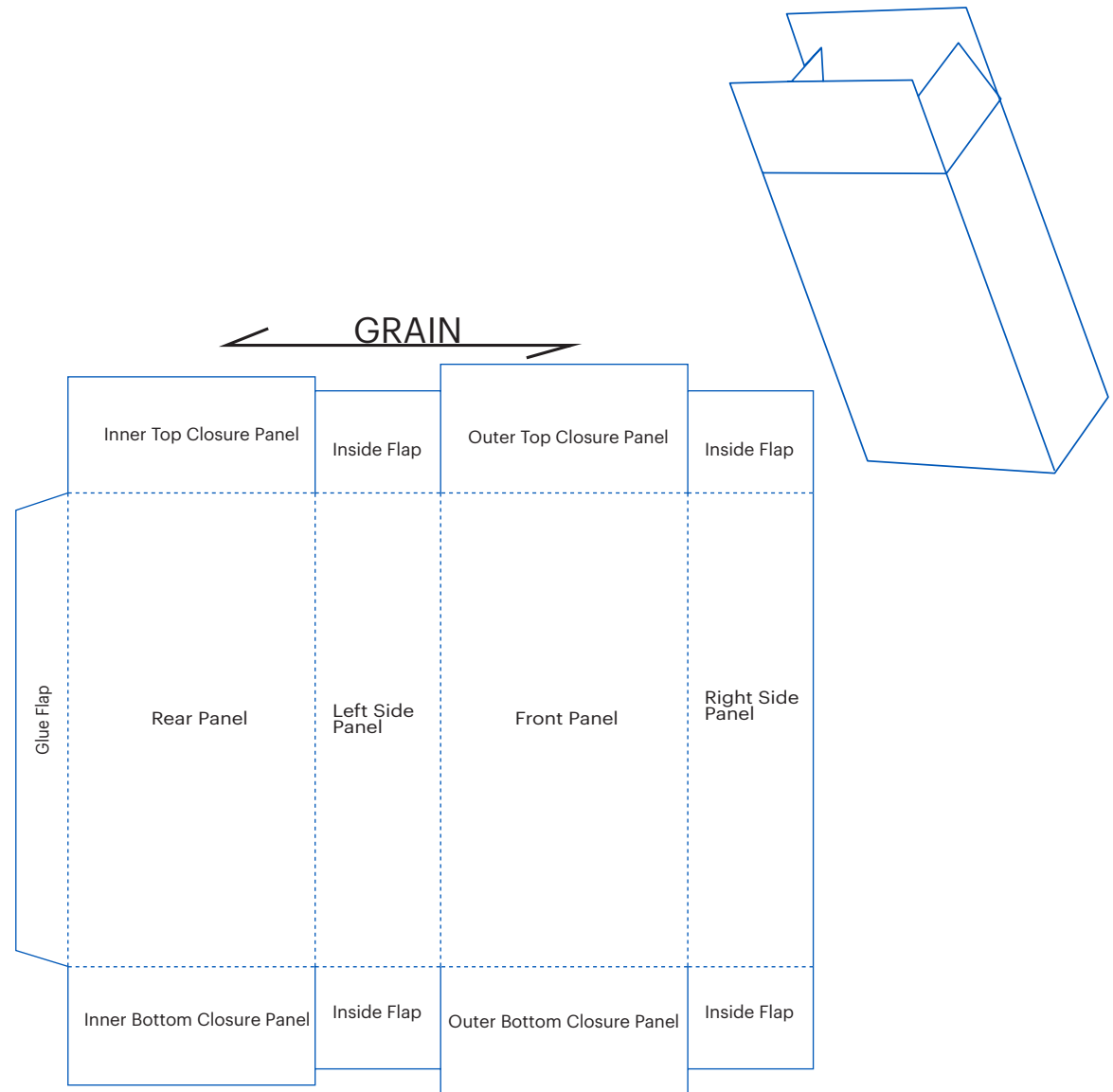
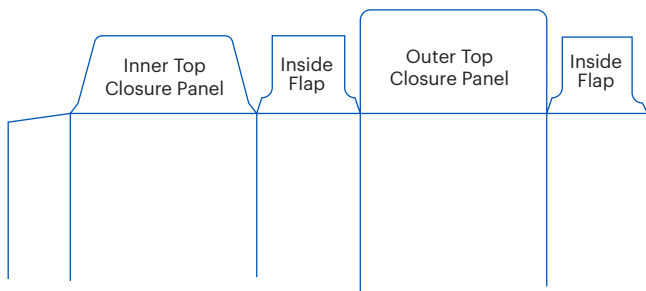
The Full Flap Automatic Bottom style is a great alternative to the Hymes or Crash Lock when the contents are heavier or their weight is concentrated on the central axis lengthwise.

This style is assembled by hand and is generally employed when quick setup is required for smaller production volumes that do not warrant investing in automatic packaging equipment.



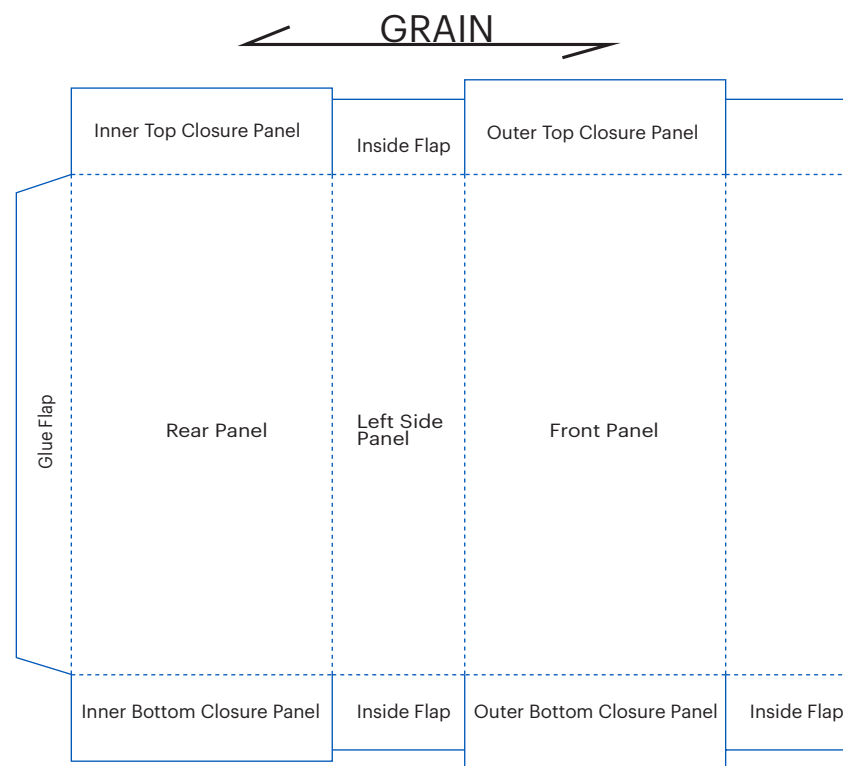
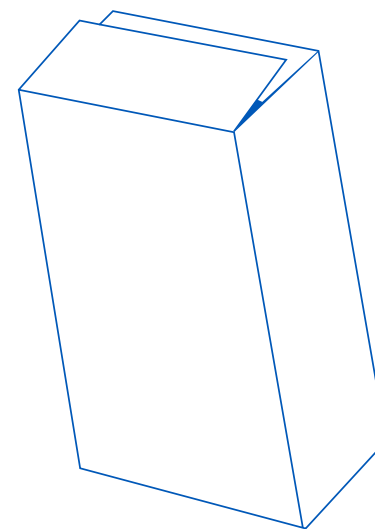
## Full Overlap Seal End (FOSE)

This carton is generally assembled, filled and sealed on automatic, horizontal or vertical packaging equipment. The usual sequence for closure is inside flaps in first, followed by the inner closure panels and finally the outer closure panels. Some sift-resistant variations of this style require the inner closure panels to be tucked down first, with the inside flaps next and the outer closure panels last.



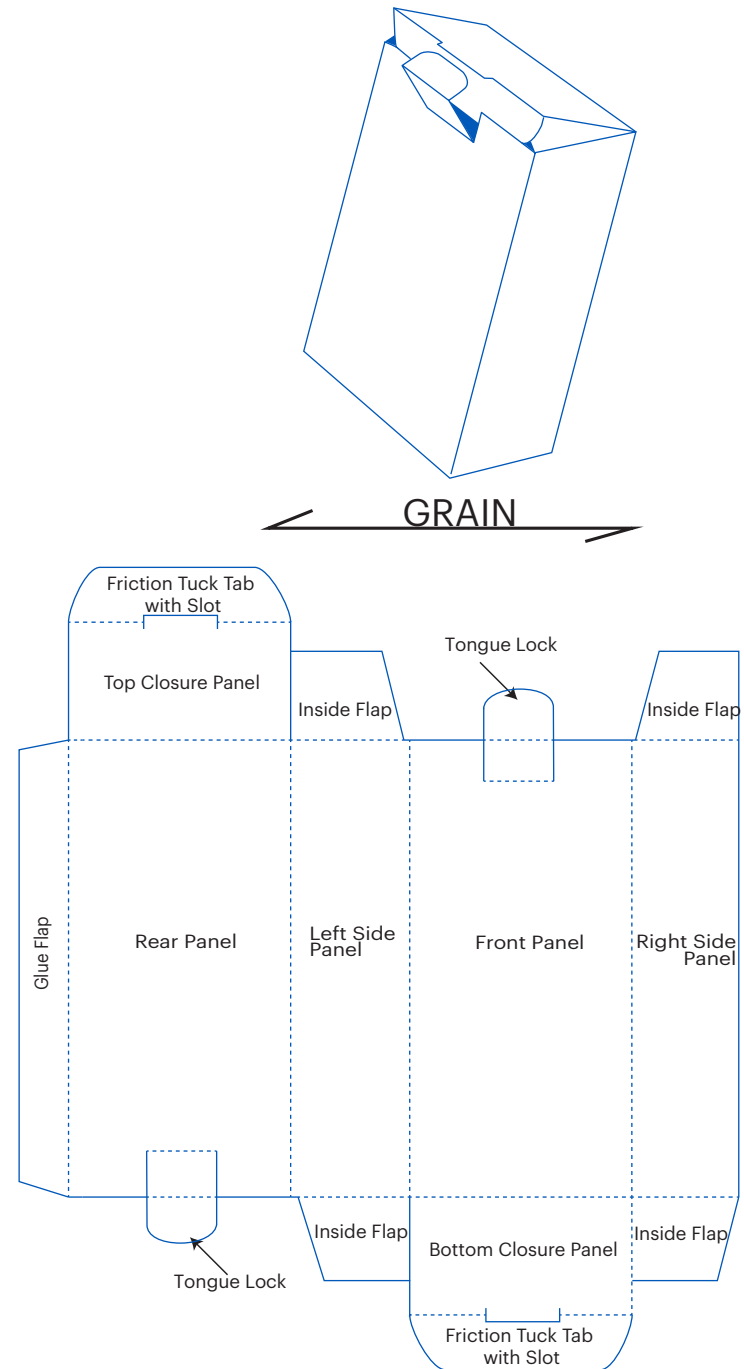
## Partial Overlap Seal End

This style features closure panels on top and bottom that are just wide enough to overlap with an adhesive seal, as compared to the FOSE, which features full-width top and bottom closure panels.



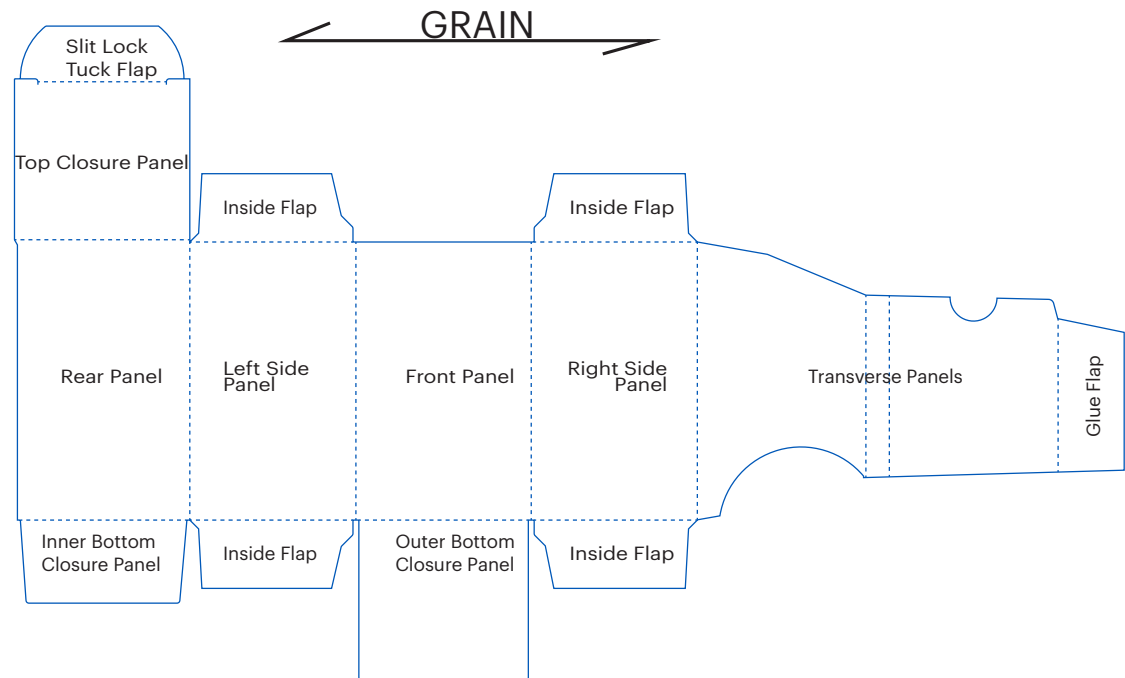
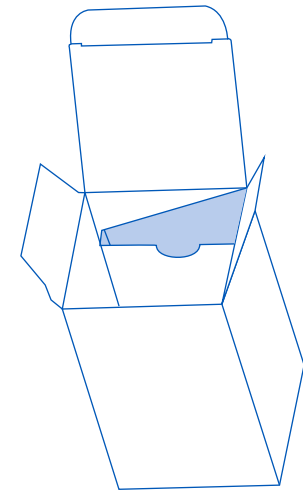
## Tuck and Tongue

This style is generally assembled, filled and sealed manually. The Tuck and Tongue carton is designed to withstand rough handling without disengaging.



## Folding carton with Integrated Separator

The digital folding carton with integrated separator is designed to create a barrier between separate packaged components. It includes a structure of division formed by one or several panels, each having a perpendicular flap in every extremity of that panel so as to adhere to the internal surface of the walls of the carton. We arrange these transverse panels by means of grooves, which form one or several compartment.

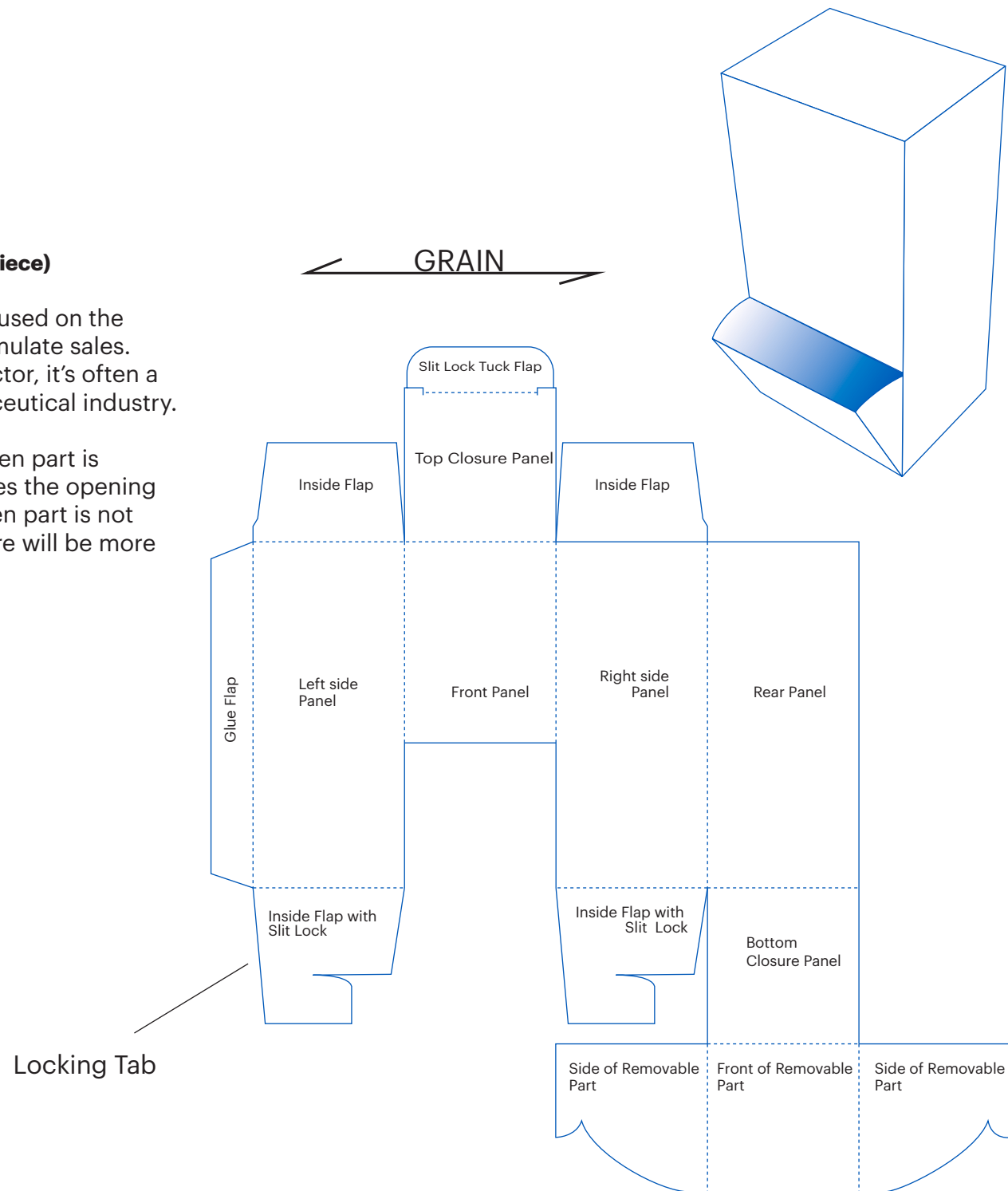




## Dispenser Style Carton (1 piece)

The dispenser style carton is often used on the counter near a cash register to stimulate sales. Used by the retail and the food sector, it's often a staple of the medical and pharmaceutical industry.

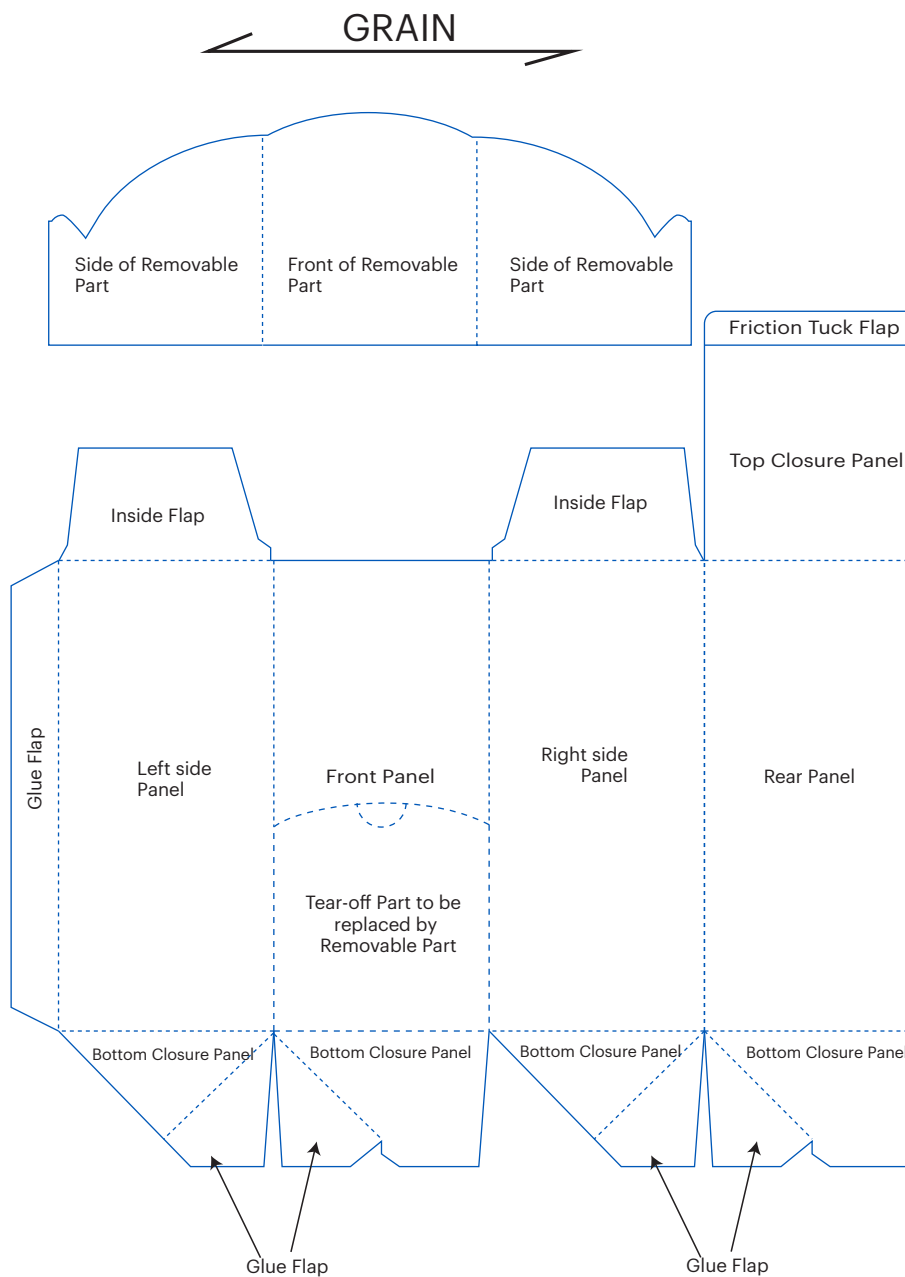
In the illustrated model, the fall open part is integrated in the carton what makes the opening and closing possible. If the fall open part is not integrated, the opening and closure will be more difficult (see next page).



## Dispenser Style Carton (2 pieces)

These dispenser style cartons have the ability to conveniently pour out contents quickly and easily.

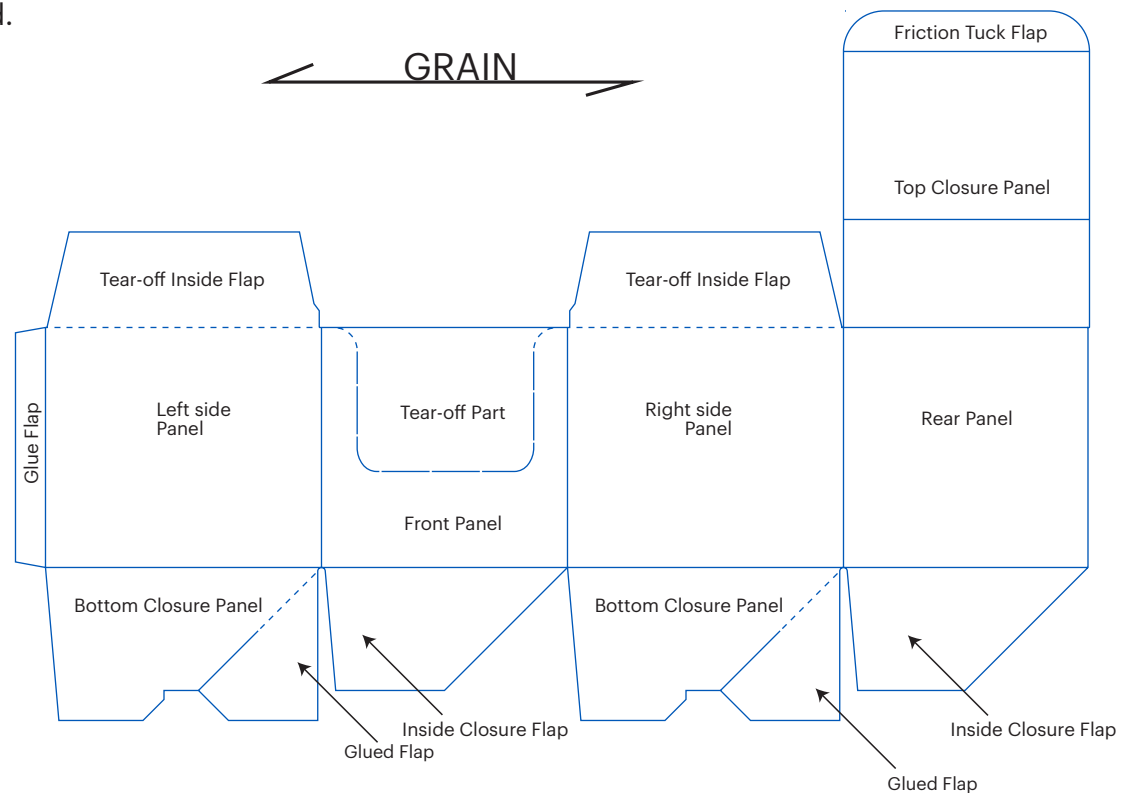
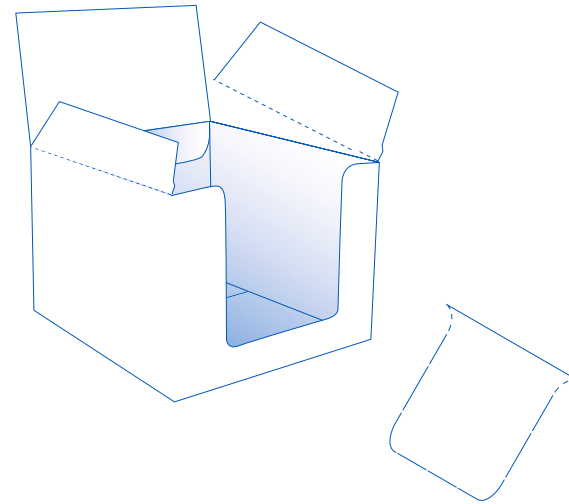
Frequently used in conjunction with auto bottom structures, these cartons feature a distinctive design that offers a number of benefits. One of these advantages: a bottom which can be formed automatically for fast packaging. Also, the flat bottom and body of this carton save space of storing.



## Counter Display

A Counter Display Carton is designed to provide a point-of-purchase unit for holding a number of individual packages or products.

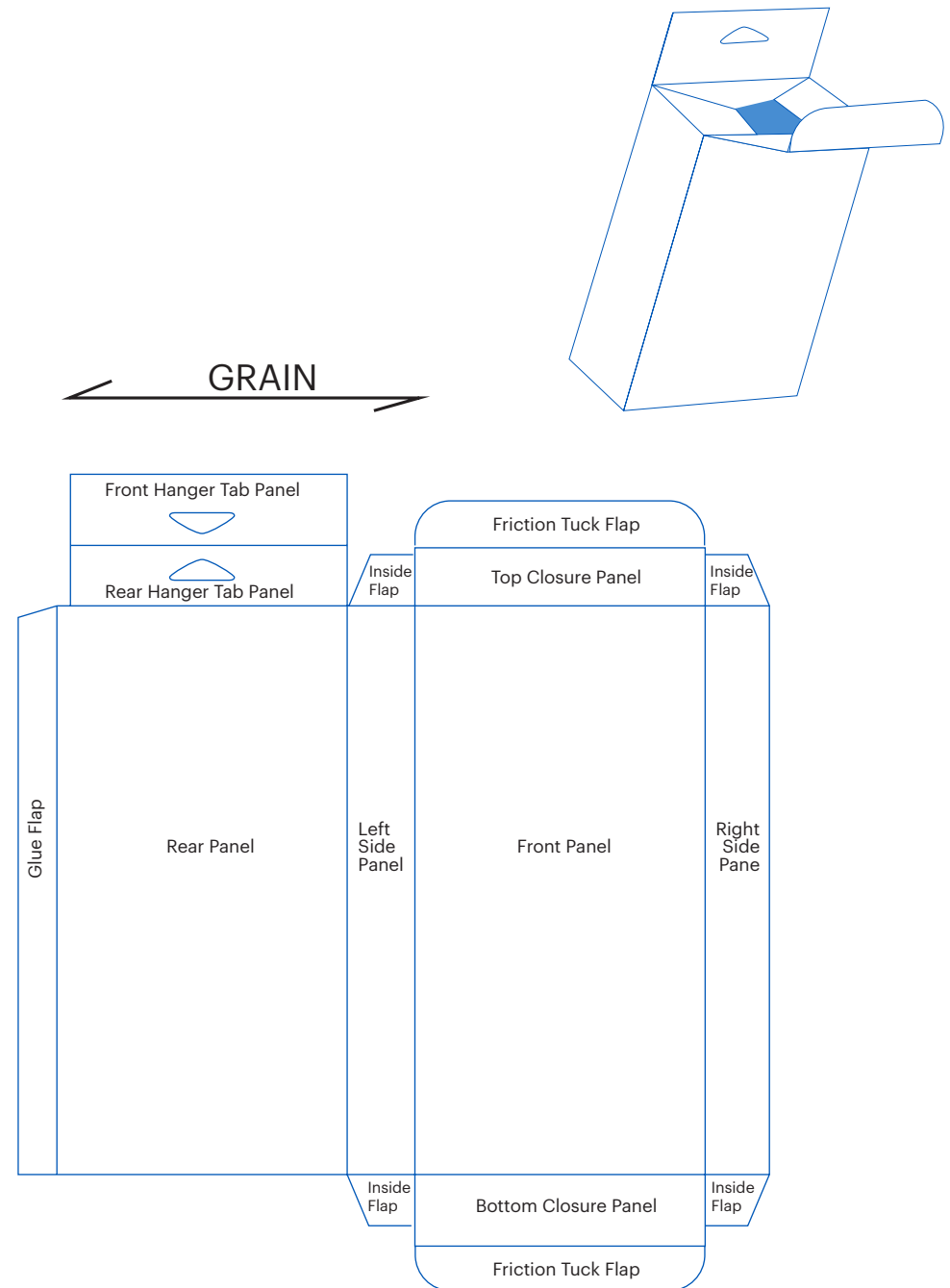
It does not need to be glued. The retailer simply opens the top of the carton and folds the lid back for easy advertising. The front panel as well as the inside flaps can be torn-off so visibility is easier and accessibility to the product is improved.



## Standard Straight Tuck (SST) with Hanger Tab

The SST with Hanger Tab carton is used for small and light products. It is an ideal stand-alone package to be placed on a hook.

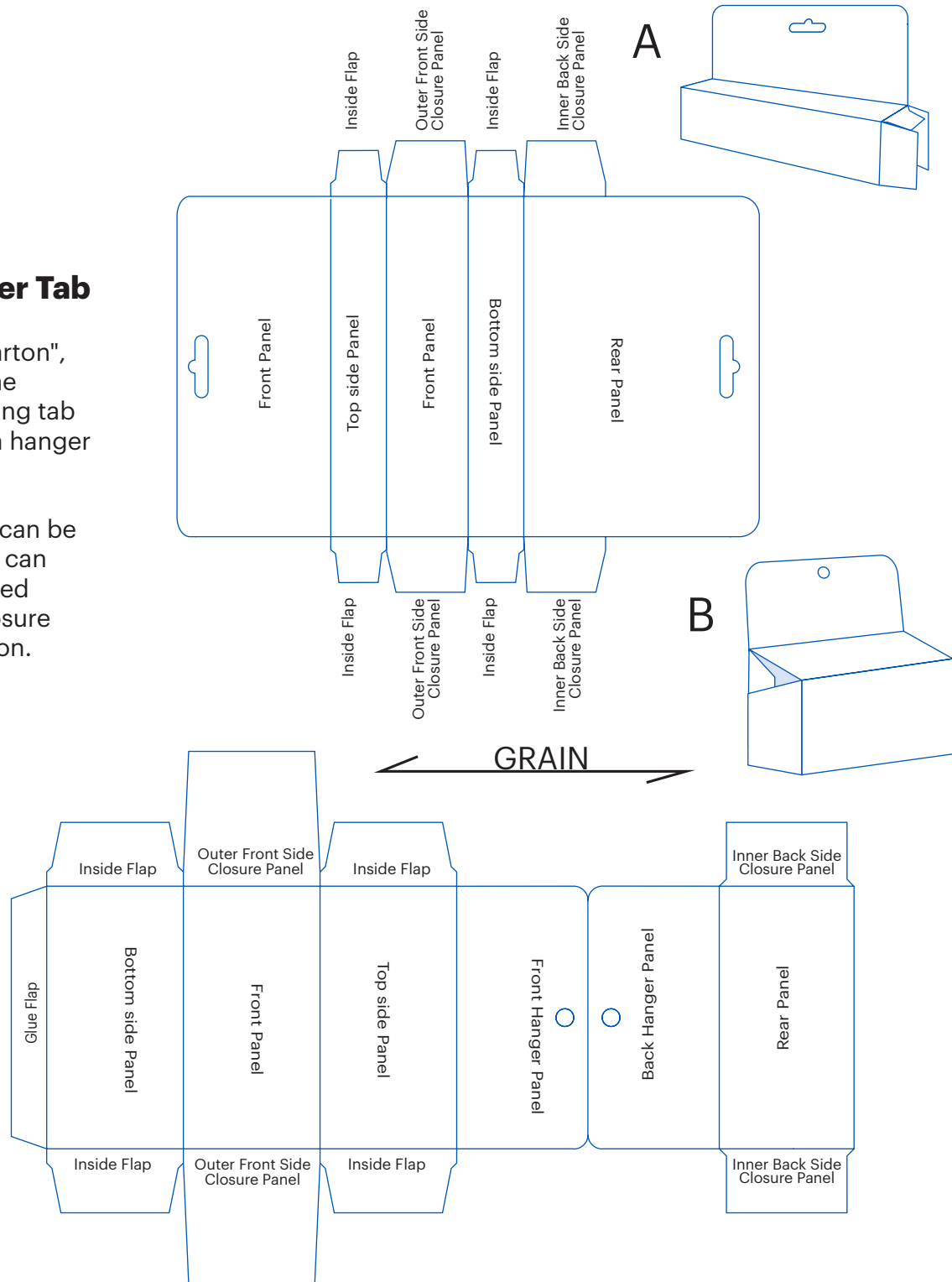
A perforated panel (perfs here called notches) with a fold will be added to the back panel. When the panel is folded up, notches are generally aligned and the front panel sealed to the back panel to create and secure the hanger tab. A window can be added on the front panel for better visibility of the product.



## Overlap Seal End with Side Hanger Tab

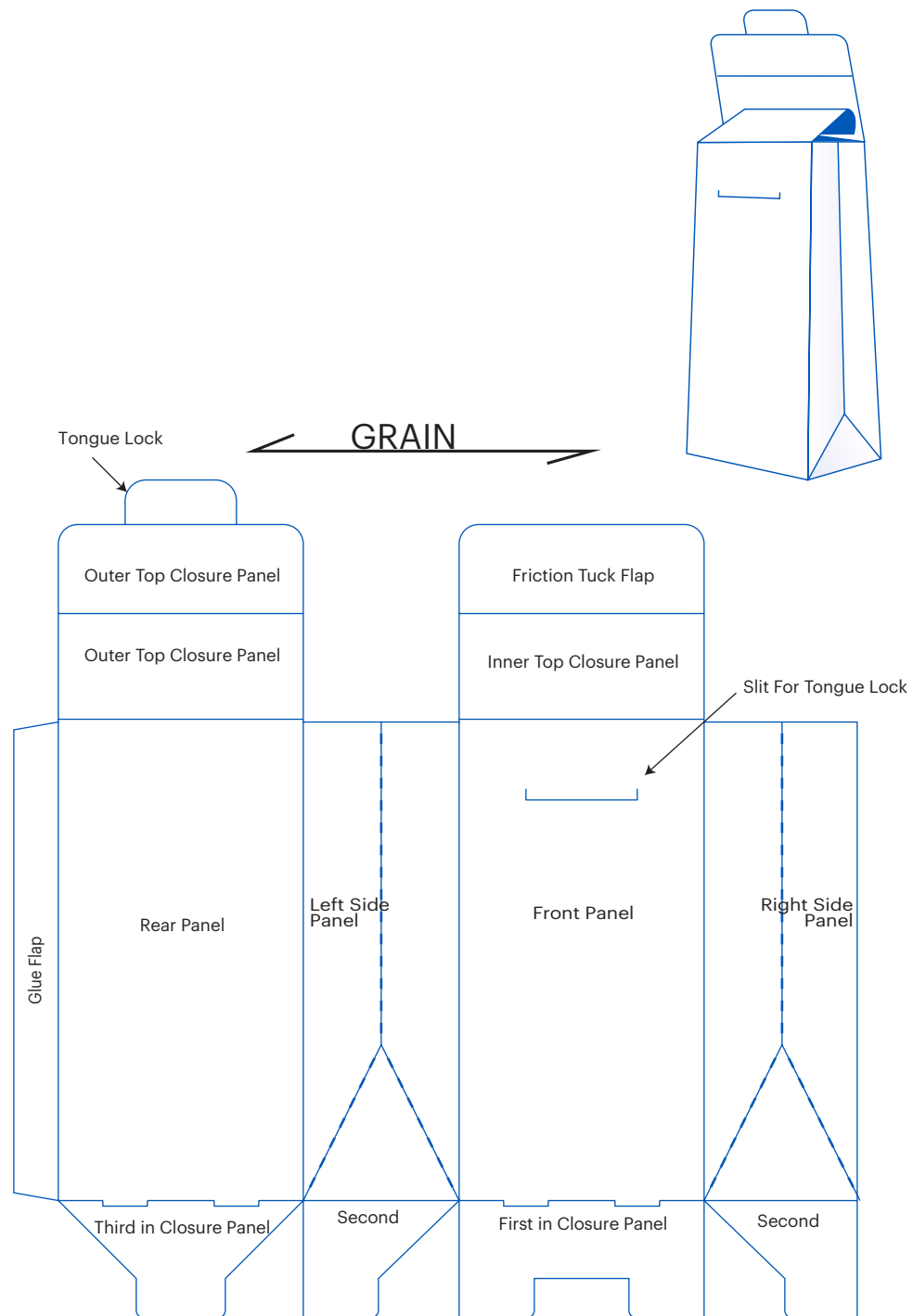
This carton style, also called the "5 panel carton", is often used to develop a header panel. The structure also includes a rear card with a hang tab notch which allows the card to be used as a hanger tab.

Style B: this carton has a hanger panel that can be folded up on one of the sides of the carton, can be assembled, filled and sealed on automated packaging equipment. The order for the closure is the same as that of a regular overlap carton.



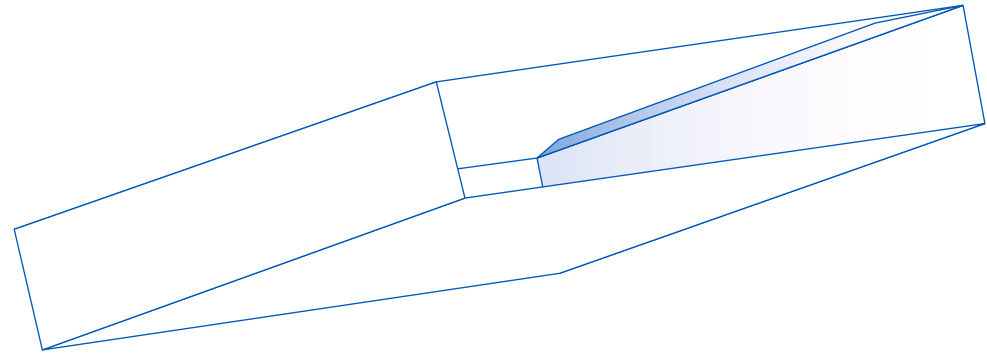
## Bag Carton with Auto Bottom

The Bag Carton with 1-2-3 Bottom is primarily used for custom cosmetic cartons and custom food cartons. It can be made with an Auto Bottom, glued on the bottom by the cartons manufacturer and allows for quick loading.

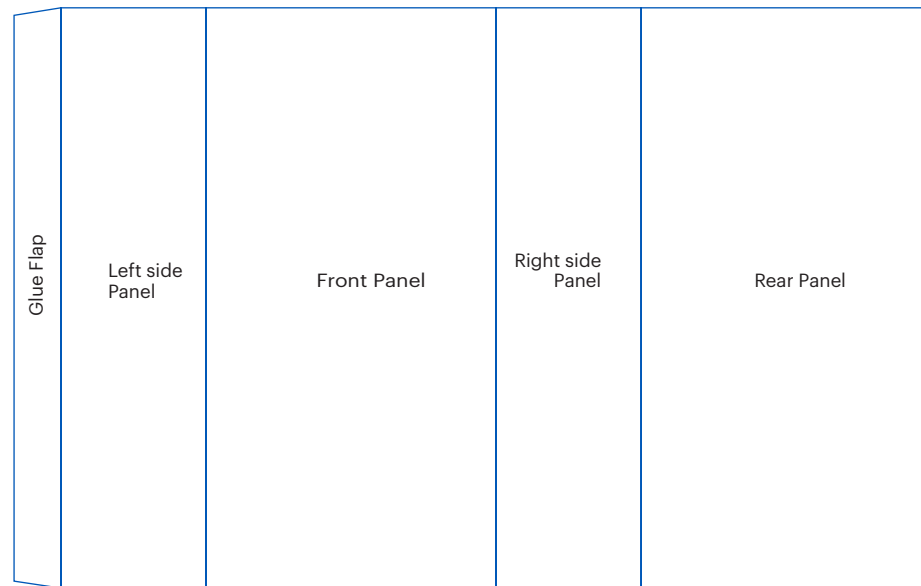


## Sleeve

The Sleeve is a tubular form, usually opened at both ends, and made in various shapes, which is then slipped over an item. This style can be used as a decorative cover or to offer protection for the product.

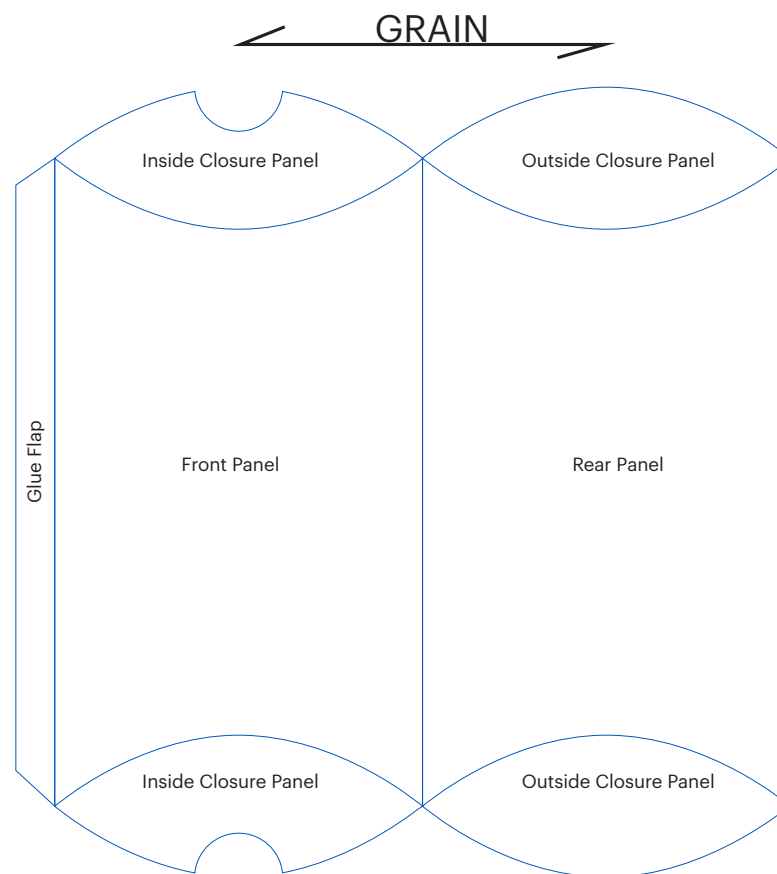
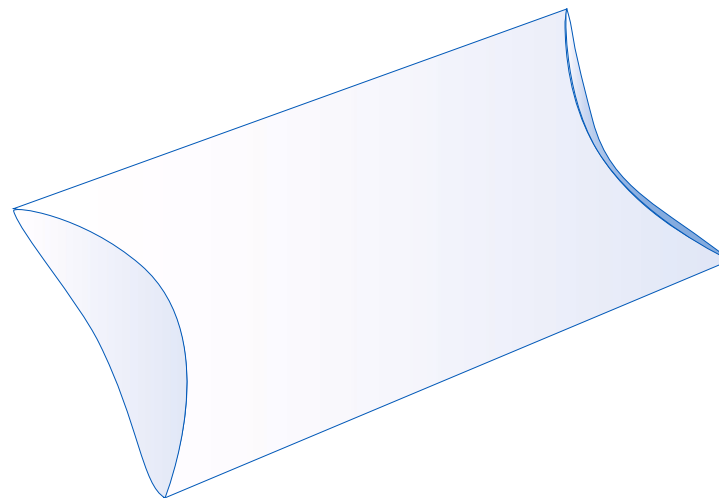


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## Pillow Box

A pillow carton is a unique shape and is used for custom cosmetic cartons, candy cartons and more.

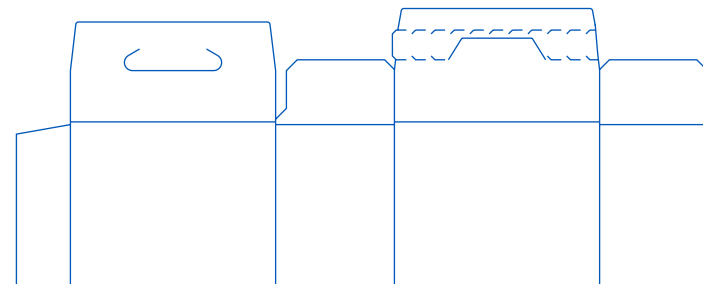
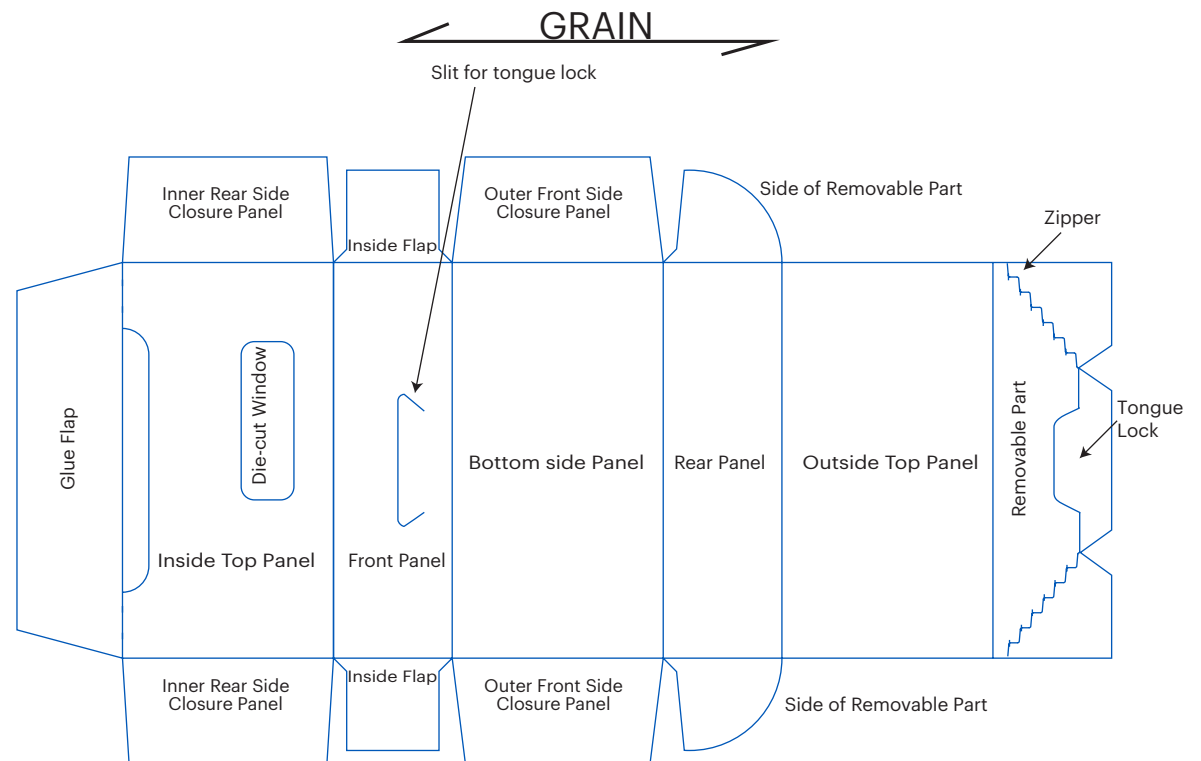
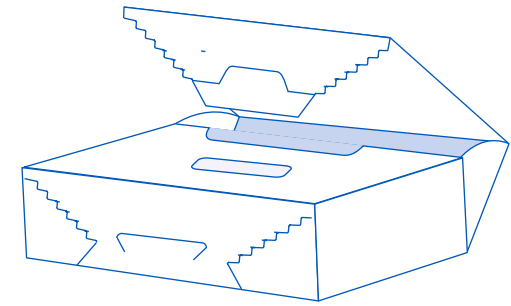




## Reclosable Carton

A reclosable folding carton has at least one tamper-evident closure, which uses a lid flap with an insertion tab, a cover tab, and a cutout. The tamper-evident closure is closed by machine without the need for gluing. The tamper-evident closure can only be opened by destroying the tamper-evident closure seal. The insertion tab is constructed of at least one tear-o tab and connected by at least one predetermined break line along one edge. The first time the tamper-evident closure is opened, the insertion tab moves with the cover tab within the cut out. When the insertion tab moves beyond the breaking point at least one tear-o tab will partially tear along the first predetermined break line.

Alternatively, the cover tab is constructed of at least one second predetermined break line and a tamper-evident closure. When the reclosable folding carton is opened for the first time, the insertion tab in the cut-out of the of cover tab, moves the insertion tab beyond the breaking point. Which then causes the cover tab to partially tear along the second predetermined break line.



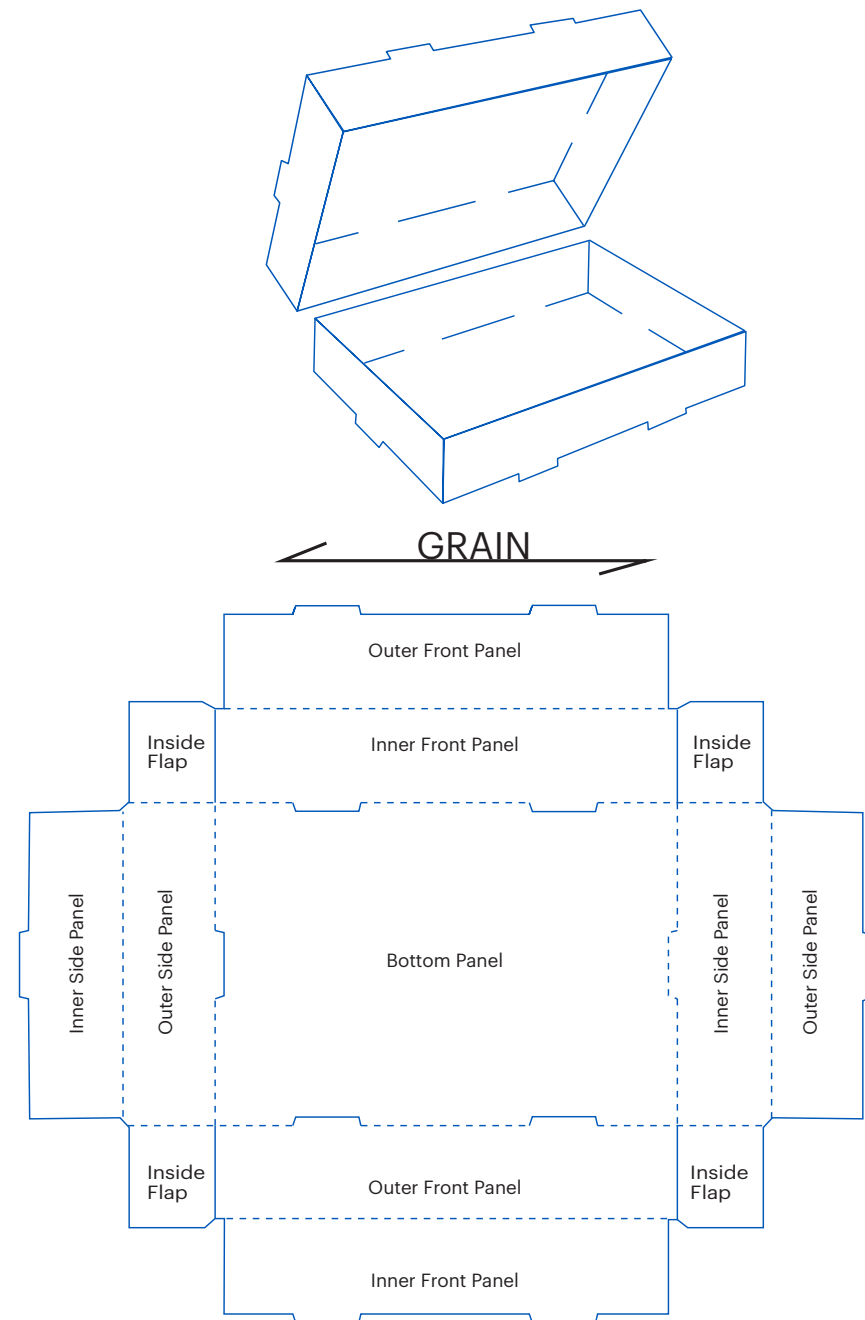


There is a wide variety of styles and designs in digital folding cartons:  
almost everything is possible according to your imagination and  
especially your needs.

The models presented previously have one or several glue joints; however,  
we also offer a variety of models for instances where gluing will not be part  
of the manufacturing process. These cartons require a manual assembly.  
This is mostly the case for trays, cards and counter displays.

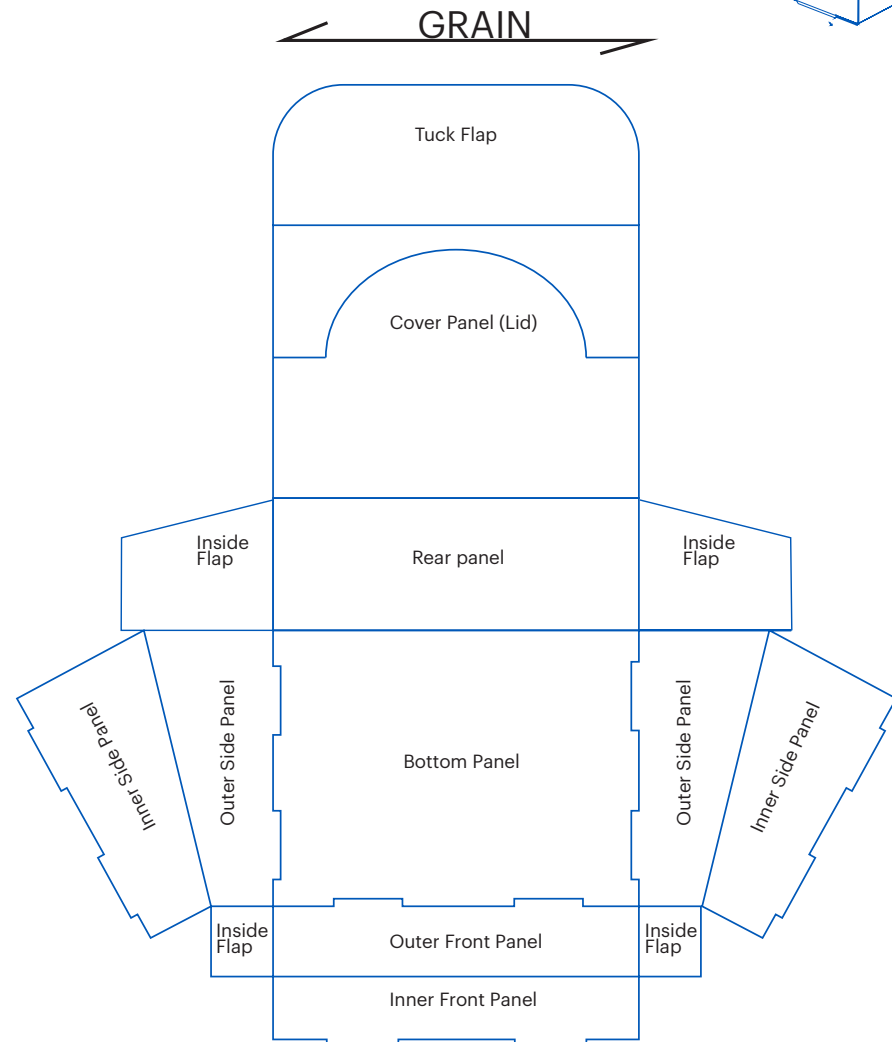
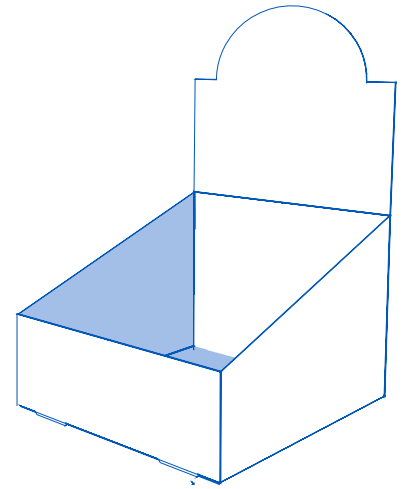
## Tray Carton

The tray is often used to house a quantity of products and makes transportation easier. It can also be used as packaging, combined with a plastic film or with a lid (usually made with the same design, size adjusted to fit on top of the lower tray).



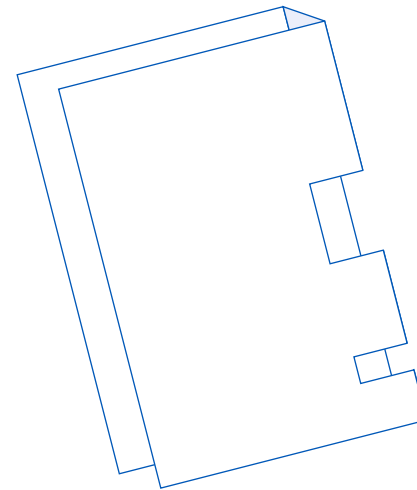
## Counter Display

A Counter Display can be completely assembled manually. It does not need to be glued. Flaps as well as inner panels strengthen the structure. The cover panel (lid) will also double as a header, offering both visibility and advertising for the product.

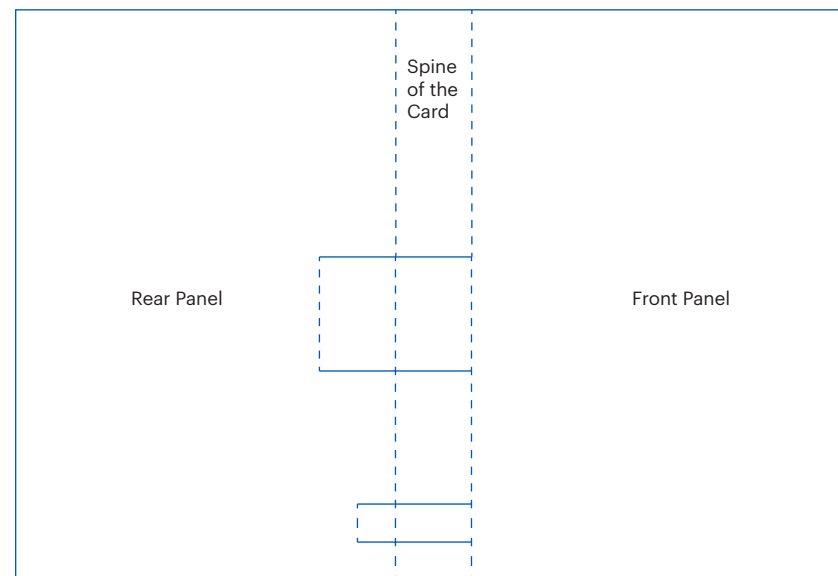


## Card

The card can be an original way to present a product. It can contain, at the same time, a sample of the product as well as its description.



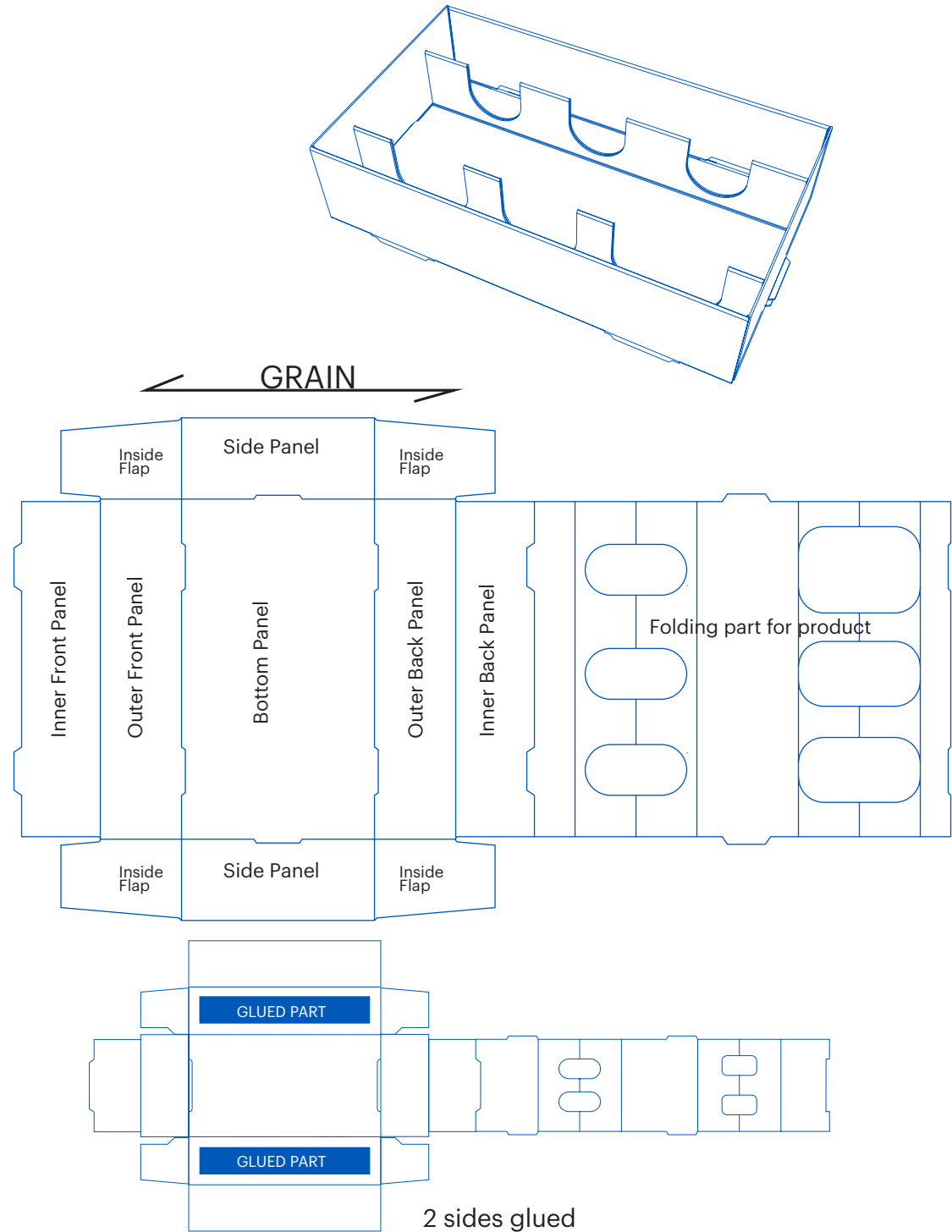
Back View



Outside view

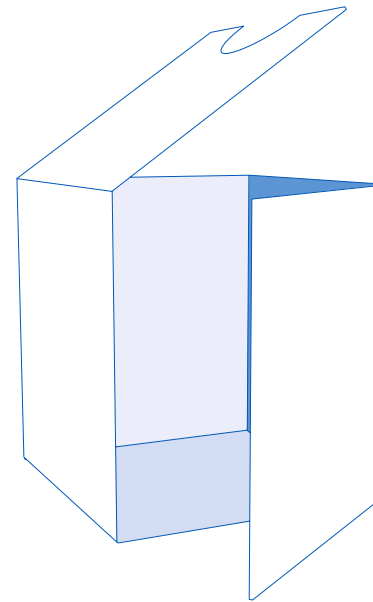
## Tray

Apart from product transportation, the tray can also be made for a specific product so it will fit into a carton, reusable or not. This style of tray could also have a design where two of the sides would be glued. However, some manual assembly remains unavoidable.

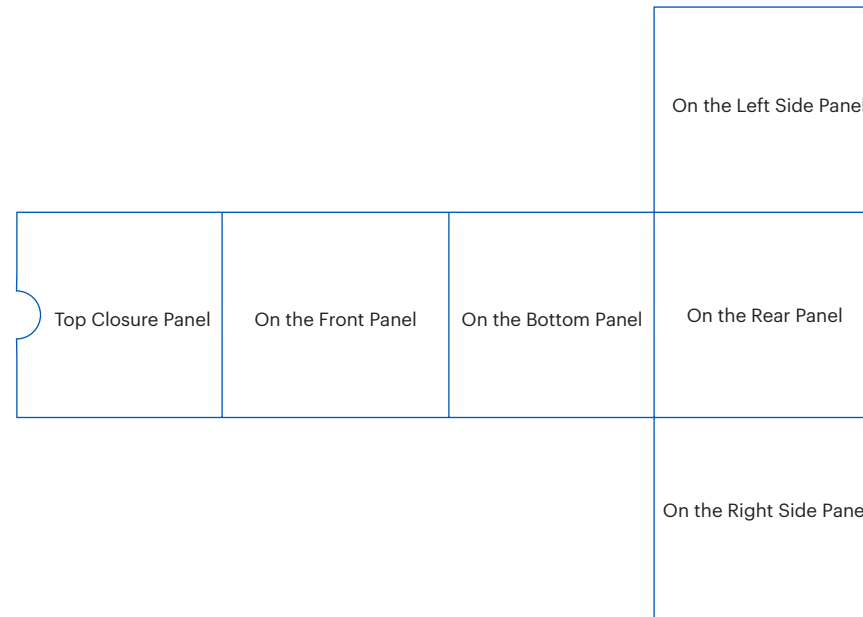


## Inner Pad

An inner pad is used to protect the product. It can be used as a separator or to strengthen the carton. The example shown here, placed in a carton in the right way, will increase the strength, protect the product and will not prevent the closure of the carton.



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Innovative Printing and Packaging

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