

Two-Ply Corrugated-Board Single-Facer Line

Complete Turnkey Business Proposal



Made-in-China supplier reference: real two-ply corrugated-board single-facer line equipment.

1,400-1,800 mm screened web width	30-60 m/min entry design speed	1 flute launch profile	10-16 entry workforce
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Prepared for investment planning in Afghanistan and regional export markets. Final specifications, pricing, civil works, and utility loads require supplier quotation and site survey.

Executive Summary

A medium industrial paper-converting line producing two-ply single-face corrugated board from one fluting-paper web and one liner web through roll receiving, reel stands, web tension control, preheating, corrugating-roll forming, starch preparation and application, pressure bonding, bridge or take-off control, rotary or NC sheet cutting, stacking, moisture conditioning and quality release. Two-ply board is an intermediate sheet or wrapping product, not a rigid shipping carton by itself.

Why this project fits Afghanistan

- Single-face board serves protective wrapping, furniture, glass, food separators and lamination markets.
- Local conversion shortens lead time for Afghan packaging users.
- One flute and controlled width reduce roll and tooling complexity.
- Paper price, steam efficiency and waste determine economics more than rated line speed.

Sanaatchi delivery scope

- Factory setup planning, supplier pre-qualification, and technical comparison
- Complete production-line and individual equipment supply
- Factory layout, utilities, civil-work coordination, installation, and commissioning
- Raw-material sourcing, trial-batch qualification, and repeat supply planning
- International logistics, customs documentation, operator training, spare parts, and after-sales support

Recommended configuration

Enter only with confirmed buyers for single-face sheets or rolls. Screen an 1,400-1,800 mm, 30-60 m/min line with two hydraulic or shaftless roll stands, preheaters, one supported single facer for a selected flute, starch kitchen, pressure/vacuum system, NC cut-off and stacker. Include paper-roll handling, steam or electric thermal system, moisture control and laboratory instruments.

Manufacturing Process & Product Portfolio

Integrated process flow



Target products

Product	Typical specification	Primary market
Two-ply single-face corrugated sheet	Approved width, flute, cut length, moisture, bond and warp	Protective packaging, separators and downstream laminators
Single-face corrugated roll	Approved roll width, diameter, tension, flute and moisture	Flexible wrapping and converters with roll-fed processes

This line uses two paper webs and does not produce three- or five-ply shipping board without a separate liner-lamination or corrugator section. Supplier acceptance records paper grades, basis weights, speed, steam or heater conditions, starch solids/viscosity, flute geometry, bond, warp, cut accuracy, waste and energy. Imported paper working capital may exceed machinery cash needs.

Core Equipment Schedule

Step	Equipment	Function	Indicative parameter
1	Two reel stands and roll handling	Feeds liner and fluting paper safely	Width and roll-mass rated
2	Preheaters and web-tension controls	Conditions moisture and stabilises webs	Paper-specific settings
3	Single facer and corrugating rolls	Forms one flute and bonds liner	One launch flute profile
4	Starch kitchen and glue unit	Prepares and meters corrugating adhesive	Controlled solids and viscosity
5	Steam or electric thermal system	Supplies stable forming heat	Site energy study
6	NC cut-off and stacker or rewinder	Forms ordered sheets or rolls	Buyer format
7	Paper laboratory	Tests basis weight, moisture, bond and compression	Incoming and finished release

Equipment models are indicative and will be matched to the selected capacity, local raw-material tests, available utilities, and preferred automation level.

Reference Equipment Gallery



Made-in-China supplier reference: real two-ply corrugated-board single-facer line equipment.



Made-in-China supplier reference: second real machine configuration for two-ply corrugated-board single-facer line.

Images are supplier references for configuration discussion; final equipment appearance and model may differ.

Plant, Raw Materials & Utility Requirements

Raw materials

- Specified fluting medium and liner paper rolls
- Corrugating starch, approved additives and water
- Cores, wrap, straps, pallets and labels
- Corrugating-roll, bearing, knife and glue-system spares

Utilities & infrastructure

- Stable three-phase power and line control supply
- Steam boiler with treated water or approved electric heating
- Humidity-controlled paper-roll and product warehouse
- Roll-handling truck, hoist and safe reel-change area
- Starch preparation water, drainage and ventilation

Quality, safety and environmental controls

- Release paper basis weight, moisture and strength
- Control roll alignment, tension and preheat
- Measure starch solids, viscosity and temperature
- Inspect flute profile, bond and warp
- Verify cut length, width, stacking and waste
- Trace every order to both paper reels and adhesive batch

A final factory layout must reserve safe forklift routes, maintenance clearances, raw-material segregation, finished-goods storage, fire protection, ventilation, and future expansion space.

Indicative Investment & Implementation Plan

LOW-ENTRY CONFIGURATION

The lowest credible line uses one flute profile, moderate speed and manual roll logistics with safe lifting. Three/five-ply lamination, printing, building, boiler house and imported paper working capital are excluded.

Component	Indicative range	Notes
Roll stands, preheaters and single facer	US\$55k-135k	1,400-1,800 mm entry line
Starch, thermal, cut-off and stacker systems	US\$35k-95k	One sheet or roll route
Roll handling, laboratory and utilities	US\$22k-65k	Paper and steam controls
Freight, installation, commissioning and spares	US\$30k-85k	Specialist alignment required
Indicative installed project total	US\$142k-380k	Building, boiler fuel and paper stock excluded

Implementation sequence

Phase 1	2-5 weeks	Confirm product specification, representative raw material, buyer, capacity, site and utilities
Phase 2	3-7 weeks	Run supplier trials with the buyer material and freeze the balanced machine, tooling and utility scope
Phase 3	8-22 weeks	Manufacture or refurbish, inspect, document and ship the contracted equipment
Phase 4	3-12 weeks	Install, commission, train operators and pass material-specific acceptance tests

Ranges are planning targets for a low-cost entry configuration, exclude land, and remain subject to confirmed capacity, supplier quotation, freight, duties, exchange rates and site conditions.

Next Steps & Contact Information

Recommended next steps

- Confirm target products, hourly output, and packaging formats
- Test representative raw materials and document quality requirements
- Complete site survey covering electricity, water, fuel, drainage, roads, and warehouse space
- Request comparable technical and commercial quotations from shortlisted suppliers
- Finalize financing, logistics, installation, training, and spare-parts plan

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Research and image references

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