



Table of Contents

SECTION NO.	PAGE NO.	SECTION NO.	PAGE NO.
1.0 INTRODUCTION		6.0 TROUBLESHOOTING	
PURPOSE	1-1	INTRODUCTION	6-1
CONGRATULATIONS	1-1	6.1 TROUBLESHOOTING CHART	6-1
SCOPE	1-1	TABLE 6-1: TROUBLESHOOTING CHART	6-2
QUESTIONS OR SUGGESTIONS	1-1		
1.1 SPECIFICATIONS	1-2	7.0 MAINTENANCE	
TABLE 1-1: MACHINE SPECIFICATIONS	1-2	INTRODUCTION	7-1
1.2 BOX SPECIFICATIONS	1-2	7.1 PRIMARY LUBRICATION	7-1
FIGURE 1-1: STANDARD BASE	1-2	TABLE 7-1: PRIMARY LUBRICATION	7-1
FIGURE 1-2: WIDE BASE	1-2	7.2 PRIMARY MAINTENANCE	7-2
FIGURE 1-3: TRAY MATT SPECIFICATIONS	1-3	TABLE 7-2: PRIMARY MAINTENANCE	7-2
FIGURE 1-4: HEIGHT FORMULA	1-3	7.3 PROCEDURE FOR CLEANING	
STORAGE AND HANDLING PG.1	1-4	GLUE SYSTEM	7-3
STORAGE AND HANDLING PG.2	1-5	7.4 PURGING ADHESIVE PUMP	7-3
		7.5 INSTRUCTIONS FOR CHANGING	
2.0 SAFETY FEATURES		GLUE	7-3
STANDARD FEATURES	2-1	7.6 ADHESIVE APPLICATOR PUMP	
SAFETY PROCEDURES	2-1	THERMOSTAT CALIBRATION	7-4
		FIGURE 7-1: ADHESIVE APPLICATOR PUMP	
3.0 INSTALLATION		THERMOSTAT CALIBRATION	7-4
UNCRATING AND POSITIONING	3-1	8.2A PARTS & ILLUSTRATIONS	
ELECTRICAL INSTALLATION	3-1	FIGURE 8-1A	
		BASE FRAME ASSEMBLY	8-2
4.0 OPERATION		FIGURE 8-2A	
OPERATING INSTRUCTIONS	4-1	TRANSMISSION GEAR SHAFT ASSEMBLY	8-4
		FIGURE 8-3A	
5.0 SET-UP AND ADJUSTMENTS		PINION SHAFT ASSEMBLY	8-6
CONNECTING TO ELECTRIC POWER	5-1	FIGURE 8-4A	
MANDREL SET-UP	5-2	FEED POST SHAFT ASSEMBLY	8-8
ADJUSTMENT OF MANDREL GUIDES	5-3	FIGURE 8-5A	
ADJUST MANDREL RETURN STROKE	5-4	VARI-SPEED CONTROL KNOB ASSEMBLY	8-10
ADJUST SIDE COMPRESSION BARS	5-5	FIGURE 8-6A	
ADJUST QUICK CHANGE BOTTOM	5-6	"V" BELT VARI-DRIVE ASSEMBLY	8-12
STOPS AND VERTICAL GUIDE BARS	5-7	FIGURE 8-7A	
ADJUST BLANK FEED ROLL ASSEMBLY	5-8	UPRIGHT & SIDE PANEL ASSEMBLY	8-14
ADJUST BLANK REBOUND STOP	5-10	FIGURE 8-8A	
ADJUST TOP TRAY FORMING SHOES	5-11	ELECTRICAL PANEL CONDUIT ASSEMBLY	8-16
ADJUST LENGTH OF MANDREL TRAVEL	5-12	FIGURE 8-9A	
ADJUST BOX STRIPPER PAWL	5-13	ELECTRICAL BOX ASSEMBLY	8-18
ADJUST BLANK FEED PICK MECHANISM	5-14	FIGURE 8-10A	
ADJUST BLANK HOPPERS	5-15	CONTROL PANEL ASSEMBLY	8-20
ADJUST BLANK HOPPER GATE	5-16	FIGURE 8-11A	
ADJUST BLANK PICK CAM	5-17	TERMINAL RACK A ASSEMBLY	8-22
ADJUST BLANK FEED IDLE ROLLER	5-18	FIGURE 8-12A	
ADJUST CLEARANCE BETWEEN	5-19	TERMINAL RACK B ASSEMBLY	8-24
PROGRAM SEGMENT AND APPLICATOR	5-20	FIGURE 8-13A	
ADJUST ADHESIVE PROGRAM SEGMENTS	5-21	HOPPER BLADE	
ADJUSTMENT OF GLUE BEADS	5-22	MATT GUJDE ASSEMBLY	8-26
ADJUST MACHINE STOP MICRO	5-23		
MANDREL STOP BRAKE WEAR	5-24		

Table of Contents (cont'd)

<u>SECTION NO.</u>	<u>PAGE NO.</u>	<u>SECTION NO.</u>	<u>PAGE NO.</u>
8.0 PARTS LIST & ILLUSTRATIONS (CONT'D)		SECTION-A	
FIGURE 8-14A		VACUUM FEED ATTACHMENT	
LOAD RAMP KNIFE ASSEMBLY	8-28	OPTIONS	
FIGURE 8-15A			
BLANK FEED ROLL MOUNT & PROGRAMMER ASSEMBLY	8-30		
FIGURE 8-16A			
MAIN TREE GUIDE ASSEMBLY	8-32		
FIGURE 8-17A			
REBOUND STOP ASSEMBLY	8-34		
FIGURE 8-18A			
TRAY ANTI-WARP ASSEMBLY	8-36		
FIGURE 8-19A			
BLANK QUICK CHANGE ASSEMBLY	8-38		
FIGURE 8-20A			
MINOR FLAP FOLDING			
PLOW ASSEMBLY	8-40		
FIGURE 8-21A			
TOP HORIZONTAL BAR ASSEMBLY	8-42		
FIGURE 8-22A			
MANDREL GUIDE RAIL ASSEMBLY	8-44		
FIGURE 8-23A			
CON ROD/FEED POST ASSEMBLY	8-46		
FIGURE 8-24A			
FRONT GUARD ASSEMBLY	8-48		
FIGURE 8-25A			
TAKE-UP CHAIN IDLER	8-50		
FIGURE 8-26A			
LARGE CAPACITY ADHESIVE			
MELT POT ASSEMBLY	8-52		
FIGURE 8-27A			
ADHESIVE APPLICATOR			
LARGE PUMP ASSEMBLY	8-54		
FIGURE 8-28A			
ADHESIVE APPLICATOR			
MINI PUMP ASSEMBLY	8-56		