



## **1.0 Introduction**

### **PURPOSE**

This manual provides illustrations and instructions for the operation and maintenance of the Tray Box Former as manufactured by W. E. Plemons Machinery Services, Inc. Fowler, California. (See Figure 1-3)

### **CONGRATULATIONS**

Congratulations on your purchase of a Plemons Box Former built by W. E. Plemons Machinery Services, Inc. With proper care and maintenance this machine should provide many years of reliable service for your company.

### **SCOPE**

This manual is designed to provide you with all the information necessary for your maintenance people and your operators to care for this machine. With the standard equipment this machine is totally mechanical and requires no air or hydraulic power thus decreasing the potential for costly repairs and maintenance.

### **QUESTIONS OR SUGGESTIONS**

If you have any suggestions on how to improve either the machine or this manual please let us know. W. E. Plemons Machinery Services, Inc. depends on the input of valued customers like you and we want our machines to reflect and serve your needs.

Please call us at: (559) 834-1744.

Also please call if you have any trouble. We are here to assist and in most cases can correct any problems you may be having by telephone.

Thank you for your business.

# Tray Box Former



## 1.1 Specifications

In this section of the manual we have included the standard specifications of this machine along with a schematic of the machine showing the required floor space.

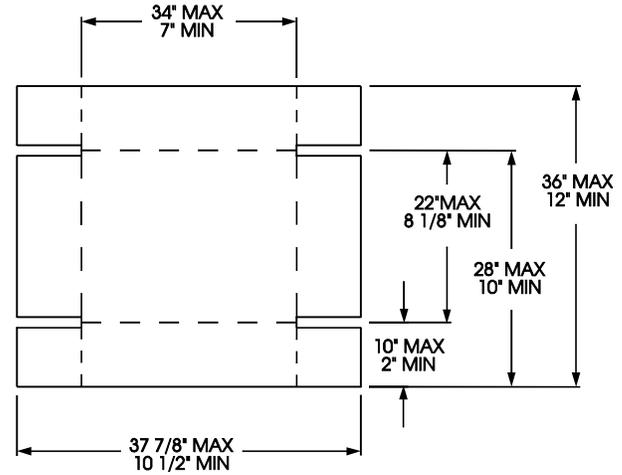
**Table 1-1: Machine Specifications**

ITEM	STANDARD BASE	WIDE BASE
WIDTH	63 1/2"	75 1/2"
LENGTH	50"	50"
HEIGHT	78 - 92"	78 - 92"
WEIGHT	1800 LBS	2100 LBS
APPROX. SPEED RANGE	0 - 60 PER MIN	0 - 60 PER MIN
ELECTRICAL STANDARD	230 V 3 PHASE - 60 Hz	
ELECTRICAL OPTIONS	208, 480 AND 600 VOLT 3 PHASE - 60 Hz <b>Single Phase Available.</b>	

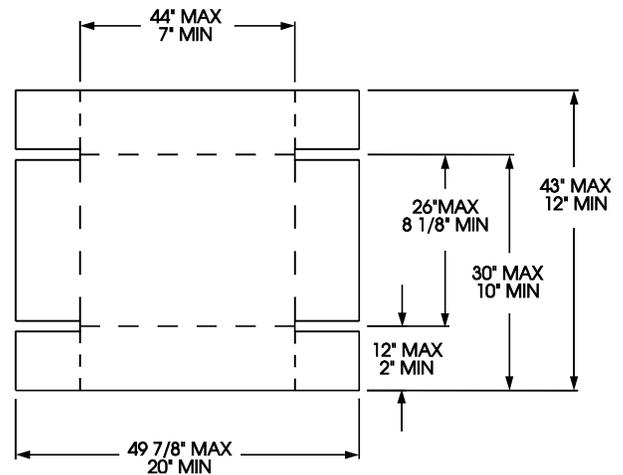
### PMS STANDARD FEATURES

- Vacuum Feed Attachment  
1 HP vacuum motor (1/3 more vacuum)
- Powder Coated Frame
- Time Delay Drive
- Down Stream Control Wiring
- Quick Change Bottom Stops
- One Piece Frame Uprights (no splices)
- One Piece Trees (no splices)
- Bearings in lower frame have seals for wash down
- "No Lube" Linear Bearings on Vacuum Feed Block
- "Lexan" Guard at Rear of Machine
- Spring Loaded Compression Rollers on Tray Machine
- Large Capacity Glue Pots (Complete melt down - 30 min.)
- Safety Interlocks on all Guards and Lower Frame Side Panels
- Nema 4x Electrical Enclosure

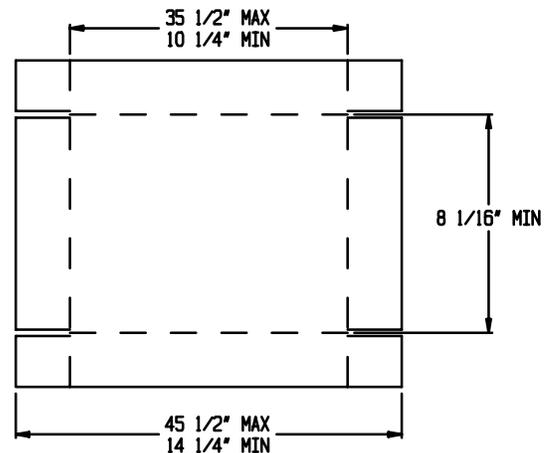
## 1.2 Box Specifications



**Figure 1-1: Standard Base**



**Figure 1-2: Wide Base**



**Figure 1-3: Kwik Change**

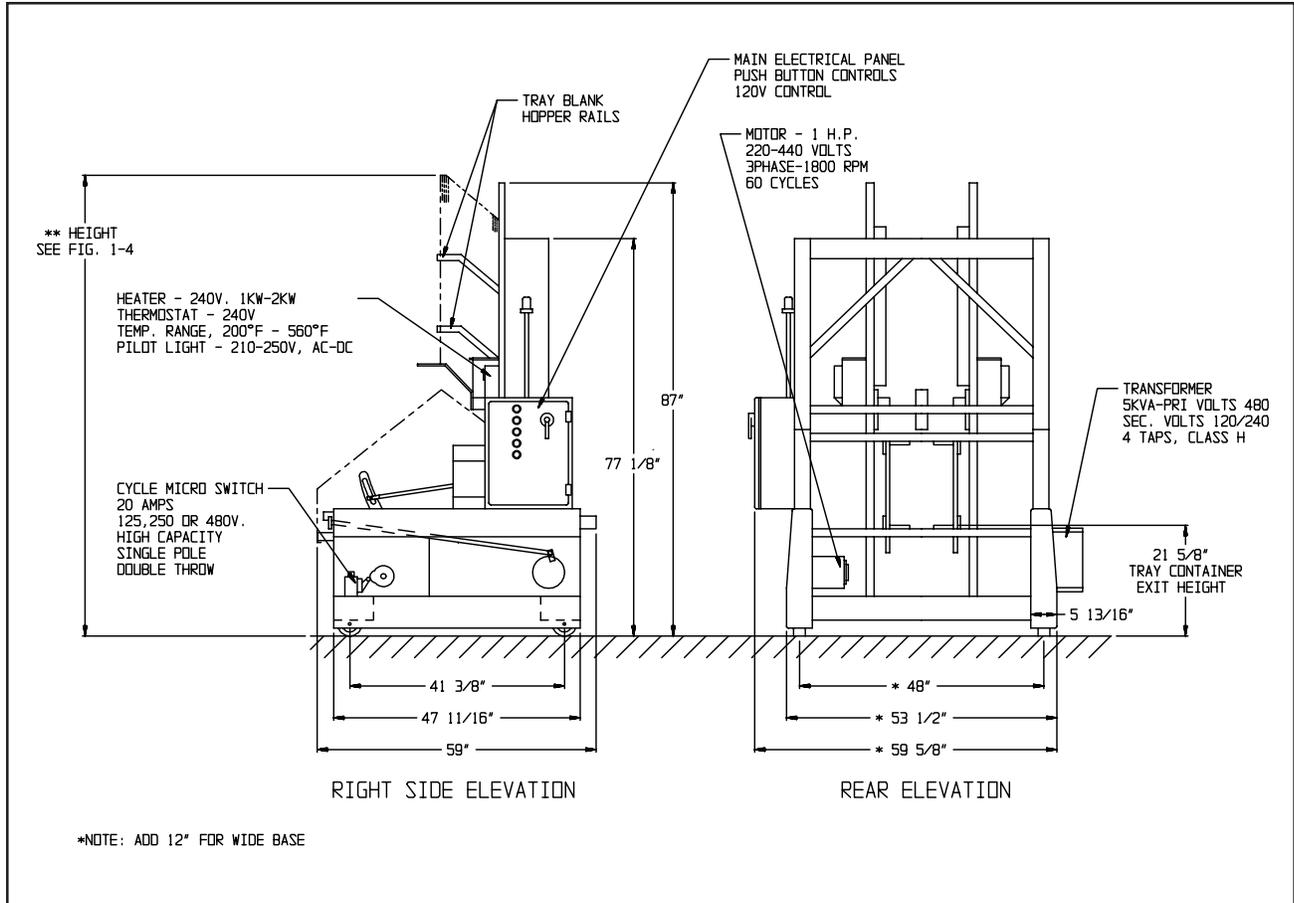


Figure 1-3: Tray Matt Specifications

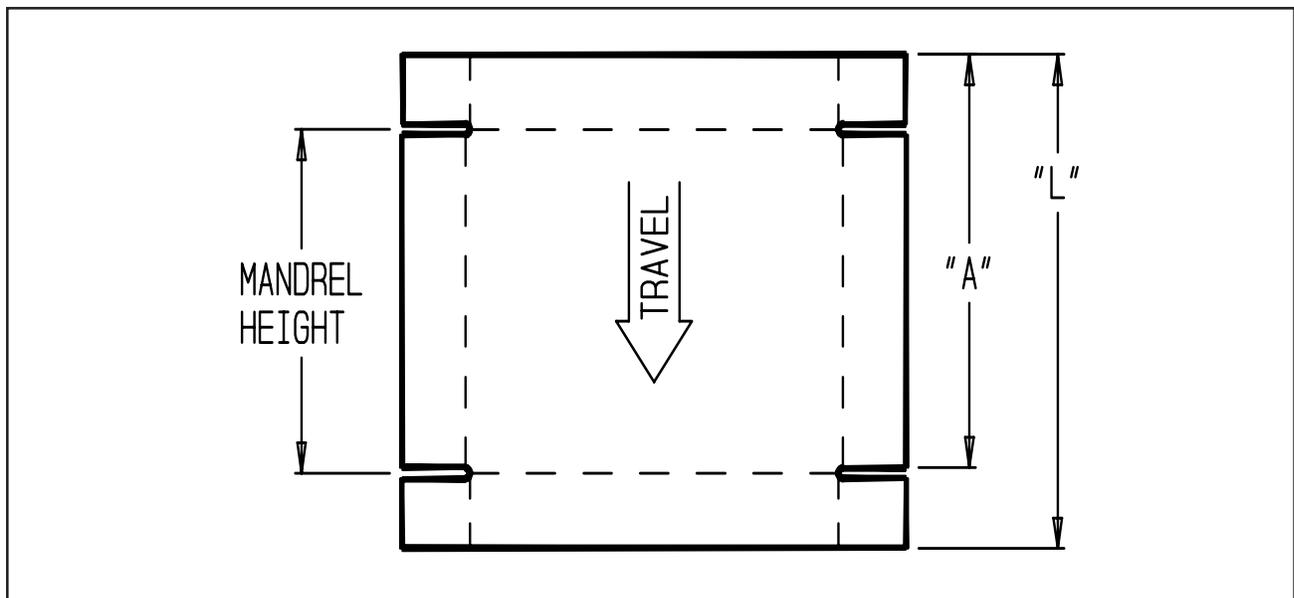


Figure 1-4: Height Formula

\*\*HEIGHT=36 1/2" + A + L

## ***STORAGE and HANDLING SUGGESTIONS for CORRUGATED CONTAINER BLANKS***

Corrugated container blanks can be damaged beyond use if good handling practices are not used. The following suggestions may be helpful in maintaining the quality and usefulness of your corrugated box investment.

Check your blanks to be sure that all slots, holes, and score lines are to your specifications. Inspect for any damage from shipping and improper bundling procedures. Check that all stripping material has been removed from the slots, and holes, etc. (Figure 1 and 2)

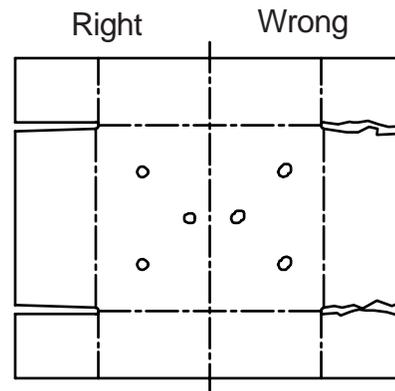
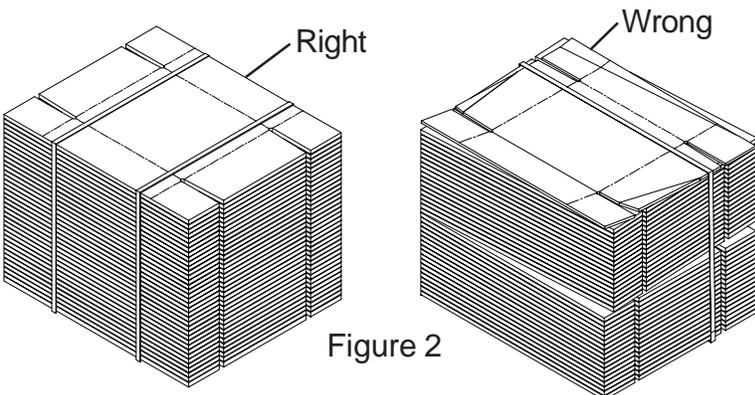
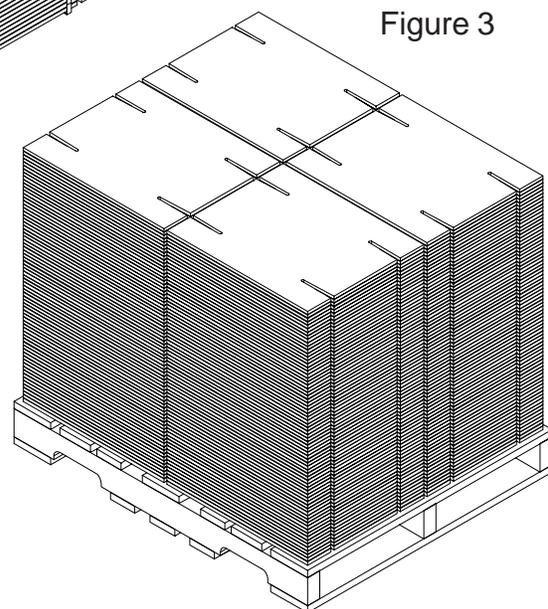


Figure 1

The storage pallet should have a solid deck with some kind of full covering. Store with blanks FLAT. If "on edge" position is required, do so only when they are ready to be formed. Use an alternate bundle stacking pattern. (Figure 3)

Do not "over stack" the blanks too high, stand on, or throw bundles of blanks. Tension straps too tight can cause deformation and "crush" damage to the edges of the blanks. (Figure 2 and 3)



## ***STORAGE and HANDLING SUGGESTIONS for CORRUGATED CONTAINER BLANKS***

Store the unused blanks under cover in a protected atmosphere, away from temperature and humidity extremes. Moisture from puddles on the floor, condensation from pipes, humidity from open air and rain can cause damage to these blanks.

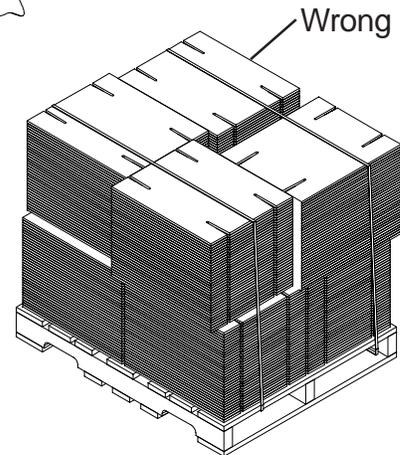
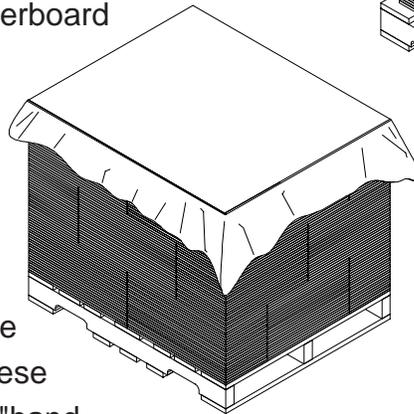
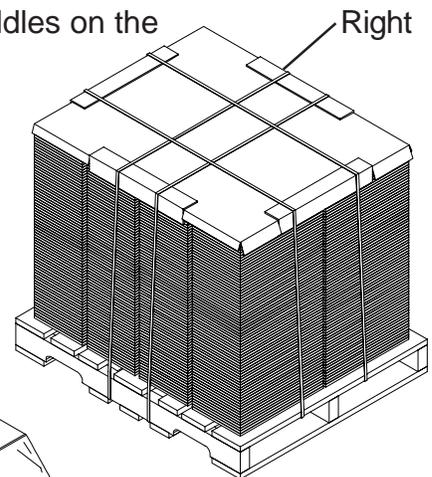
Absorption of moisture from high humidity can cause increase in the friction of the liner board, causing boxes to stick in automatic forming machinery. Moisture also softens the paperboard causing a reduction in its stress resistant quality.

Uneven absorption of moisture can cause warping making these blanks difficult to use without "hand straightening" and sometimes impossible to use in automatic machinery.

Excessive moisture or water can soften or dissolve the corrugated adhesive. With this condition, a box will literally fall apart. Extreme cold can result in brittleness with cracking and ruptures in the flaps causing the box to be more fragile, while heat can reduce the moisture content and cause the same destructive problems.

Develop a " FIRST IN / FIRST OUT " usage rotation plan. Using identifiers on the pallets will help you rotate your stock. This will help eliminate dead stock from your inventory.

Information for this article was taken from the  
Fibre Box Handbook, produced by the Fibre Box Association



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