



## 4.0 Operation

### OPERATING INSTRUCTIONS

The key to successful operation of your Tray Box Former by Plemons is to maintain a full supply of corrugated blanks in the hopper and to keep the adhesive in the glue pots to a level of at least one-half to three-quarters full. Also, as any good operator knows, you use all of your senses when operating a machine. You listen for unusual sounds such as squeaks and squeals that may indicate a need for lubrication or evidence of a bad bearing. If you note any unusual odors such as those "HOT SMELLS" that may indicate an over-heated electrical component and you should always observe the machine for loose parts or defective material that may cause machine problems.

The good operator makes certain he has kept the machine in adjustment and properly maintained to insure the successful operation of the machine. Refer to the Trouble Shooting Guide for any corrections that might be needed.

On the initial start-up of the machine set the "JOG-RUN" switch in the "JOG" position. Set the "HAND-OFF-RUN" switch to the "HAND" position. Jog the machine through the complete cycle to make certain the machine is properly set-up and clear of shipping dunnage. Then place the "JOG-RUN" switch to the "RUN" position and press the "START" button. Next turn the "HAND-OFF-AUTO" switch to the "OFF" position. This will stop the machine in the correct starting position for normal operation. Now load the hopper with blanks, check to make certain the adhesive level in the glue pots is proper and you are ready to run.

Some areas to watch during operation are the quality of the corrugated material and the glue supply. As you open each bundle of corrugated blanks inspect the bundle for torn or damaged blanks, excessive warp or any variations that can cause machine jamming. When opening the glue containers to fill the glue pots make certain there is no foreign matter in the glue supply and be sure to close the container to reduce the risk of contamination. Always keep the glue pot lids closed to avoid contamination of the glue pots.

Daily shut down of the machine should start with turning the "HAND-OFF-AUTO" switch to "OFF". Turn the main power switch to the "OFF" position to insure that power to the adhesive melt heaters is disconnected. This will prevent charring and damage to the system. Perform the necessary daily maintenance and clean-up the area. You are now insured of a smooth start-up the next day.

# Tray Box Former

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