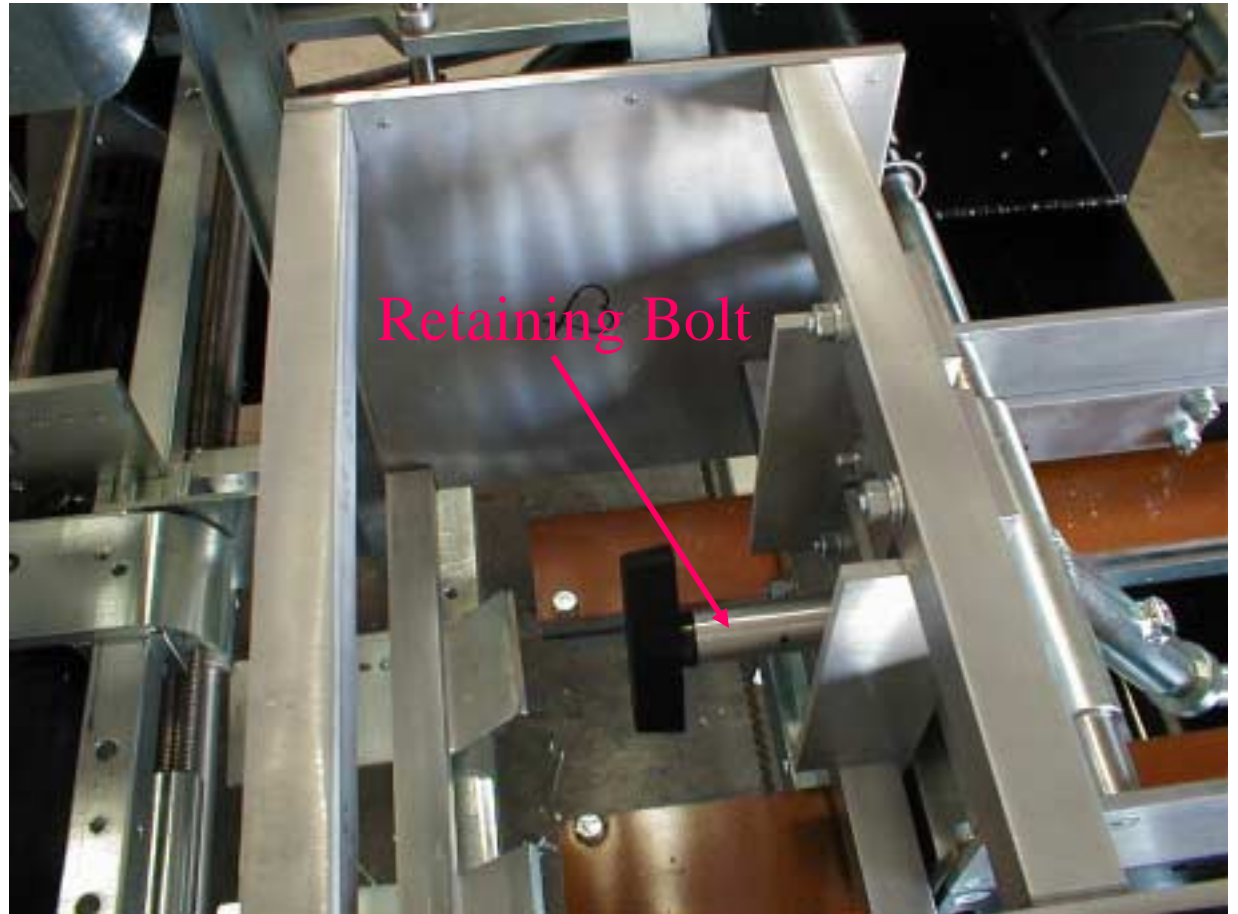
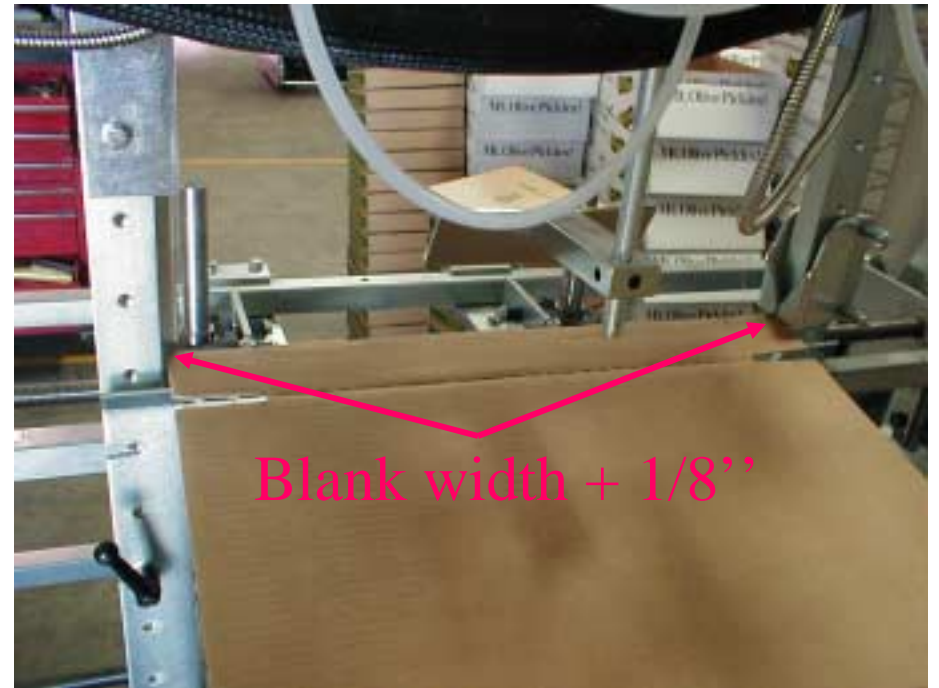


# Mandrel Head

The mandrel head is changed by removing the retaining bolt from the front of the mandrel and lifting it off the alignment pins,



# Vertical Trees



The vertical trees are set the width of the blank plus 1/8''

# Blank Hoppers



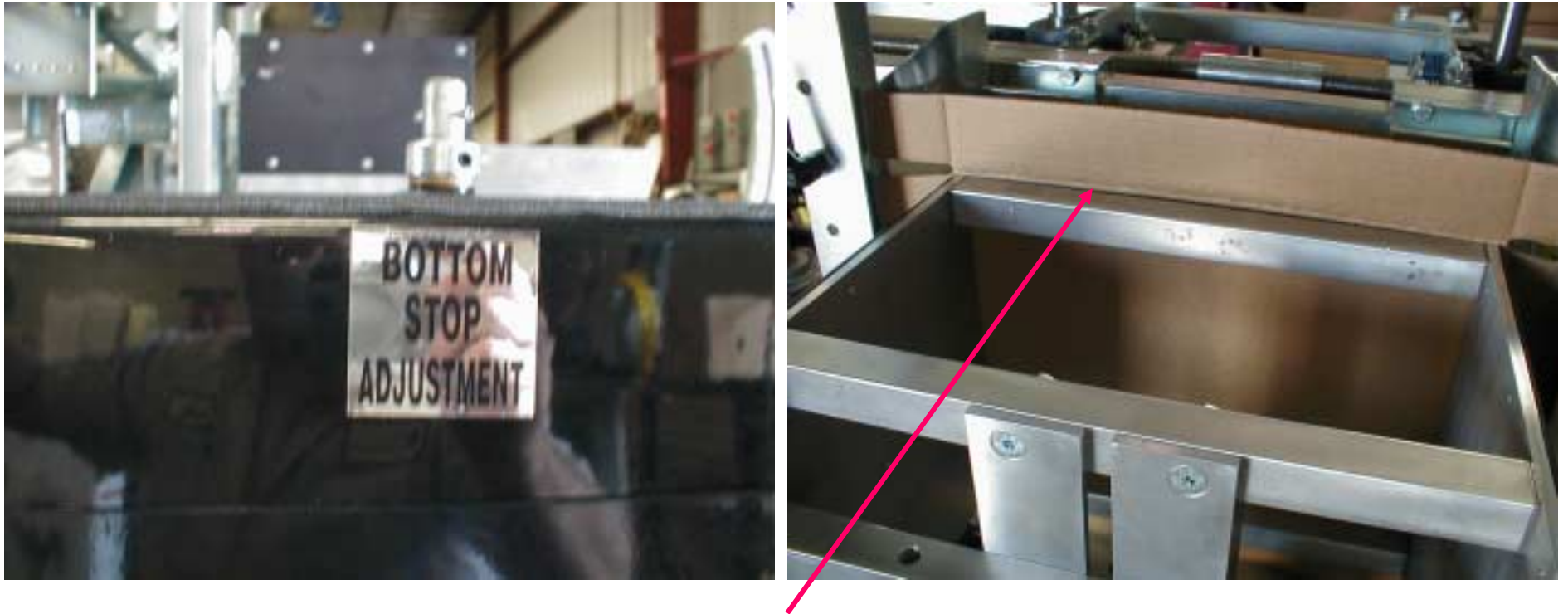
With Blank setting on the Blank Support adjust the Hopper Blade Support Bars up or down until the Blank Support Blades or Hoppers are in the center of the cut-out slots on the Blank.

# Side Compression



The side compression is set two thick nesses of the blank

# Bottom Stops



The bottom stop are set so that with a blank resting on them, the top score line is just slightly above the mandrel

# Top Compression



Adjusts the top Tray Forming Shoes up or down until you have one Blank thickness plus 1/32 inch clearance between the top of the Mandrel and the Tray Forming Shoes.

# Forward Stroke



With the Mandrel Operating Arm at the end of its forming stroke, loosen the 3/8 bolt Adjust this yoke up or down in the slot until the top edge of the tray ends have a clearance of 1/8 inch to 1/4 inch past the Tray Stripper Pawls at all four (4) corners of the tray. Re-tighten the 3/8 yoke bolt to the operating arm.

# Standard Mandrel

A standard tray mandrel is used when a box is to be run that is under minimum size for the quick change mandrel head & carriage assembly. When this setup is used the remainder of the machine setup will remain the same.





# Change Glue Pattern

1. Press Button marked USE
2. Scroll up or down until desired pattern number is shown
3. Press enter button

