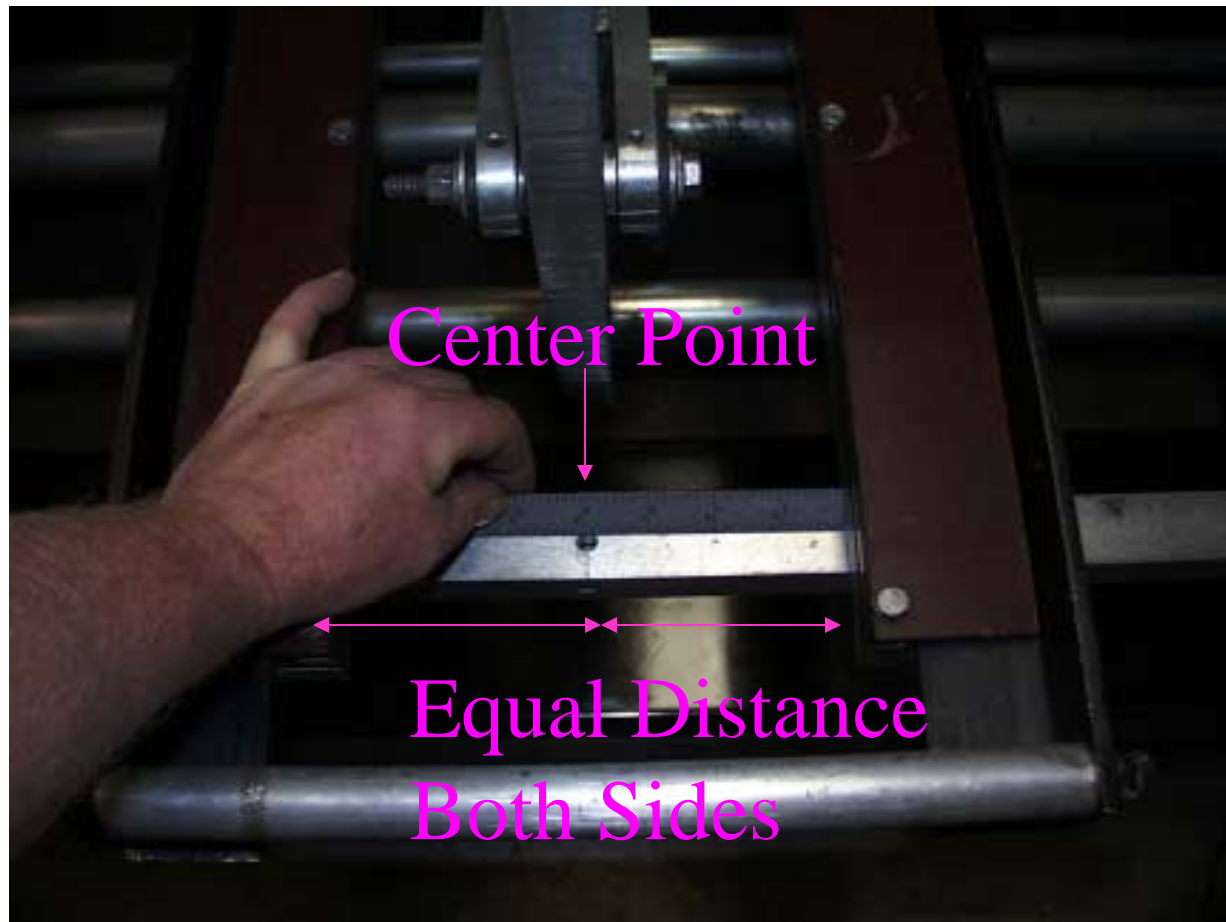


1. Size Mandrel to Paper

- With the Mandrel Out of the Machine, Fold a Blank Around the Mandrel. The Blank Should Fit Snugly Around the Mandrel.

2. Center Mandrel in Machine (Equal Distance Both Sides)

- With the Mandrel Installed in the Machine, Slide the Mandrel From Side to Side until an Equal Measurement Is Obtained From the Center Hole on the Frame Spreader Bars on Both Sides in the Front and the Back.



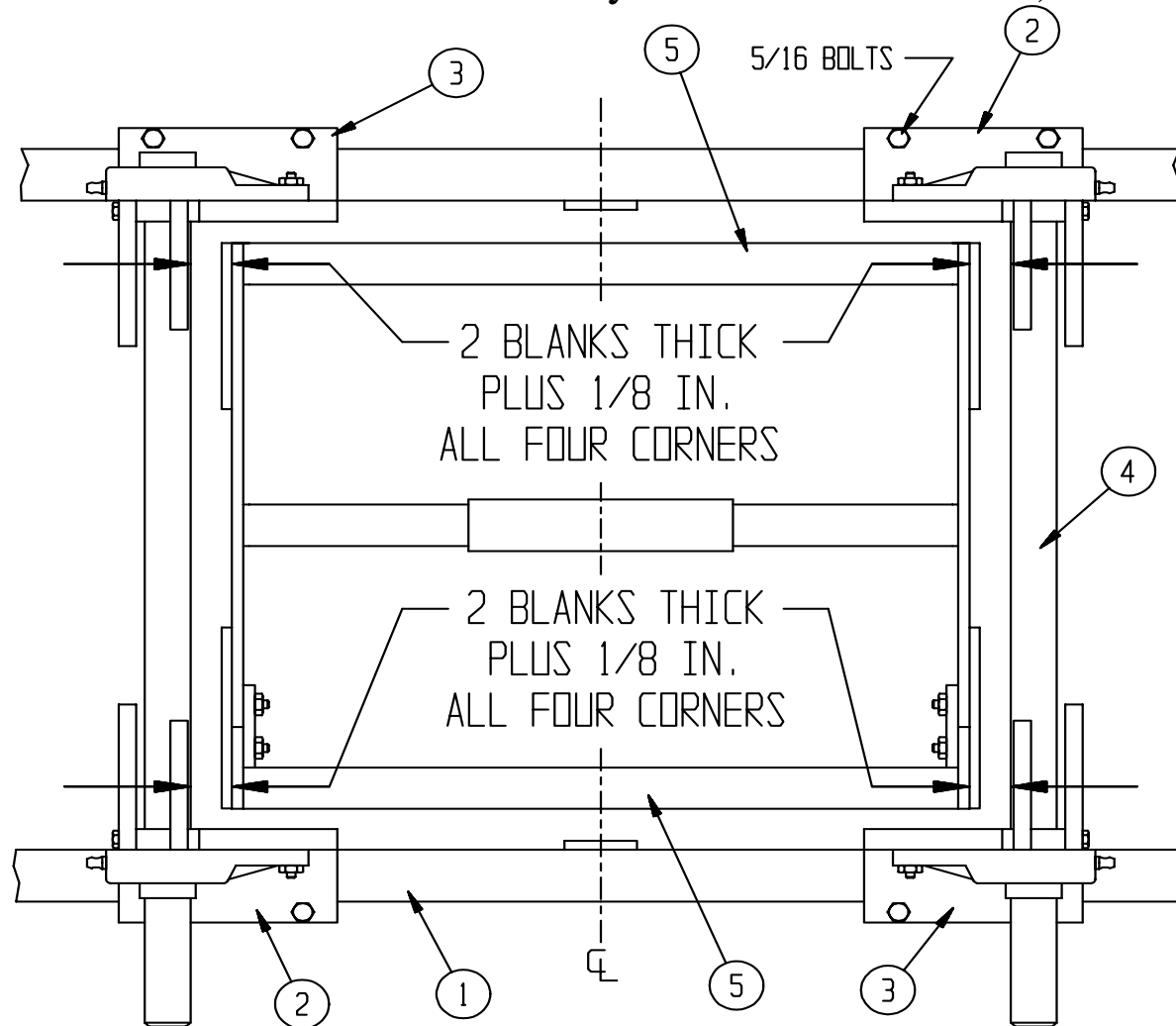
3. Set mandrel rear position

- With the mandrel installed in the machine, jog the machine until the feed post arm is in the rear most position. At this point slide the mandrel forward or back on the con rod until a 1/8'' gap is obtained between the bottom mandrel spreader bar and the front of the mandrel guides.



4. Set side compression

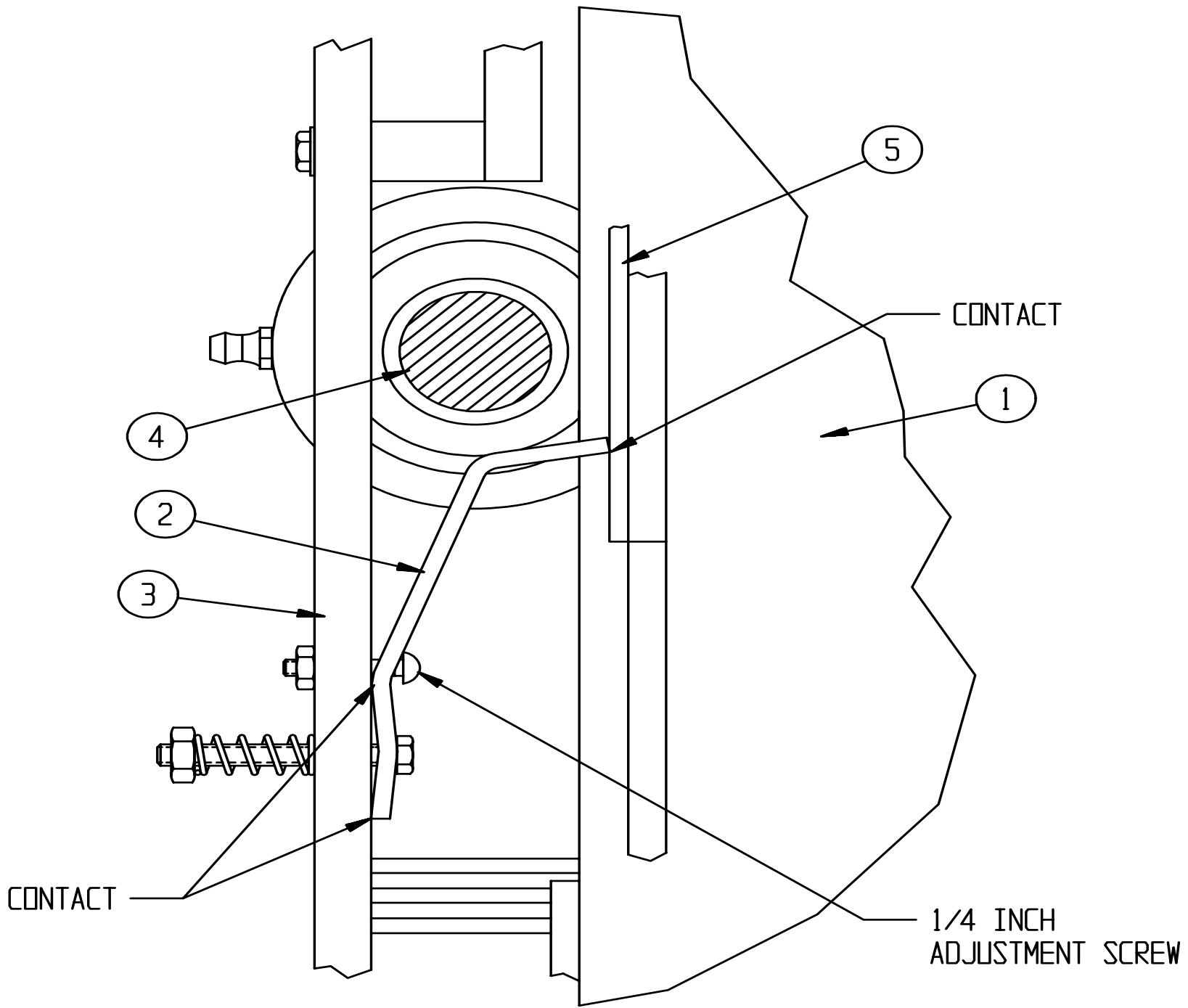
Two blank thickness' + 1/8" from edge of the compression rollers to the side of the mandrel (note if mandrel wear plates go all the way to the front of the mandrel then the clearance is only two blank thickness')



5. Set striper clearance

Adjust the striper so that they just clear the mandrel. NOTE this has to be done after the side compression is set.



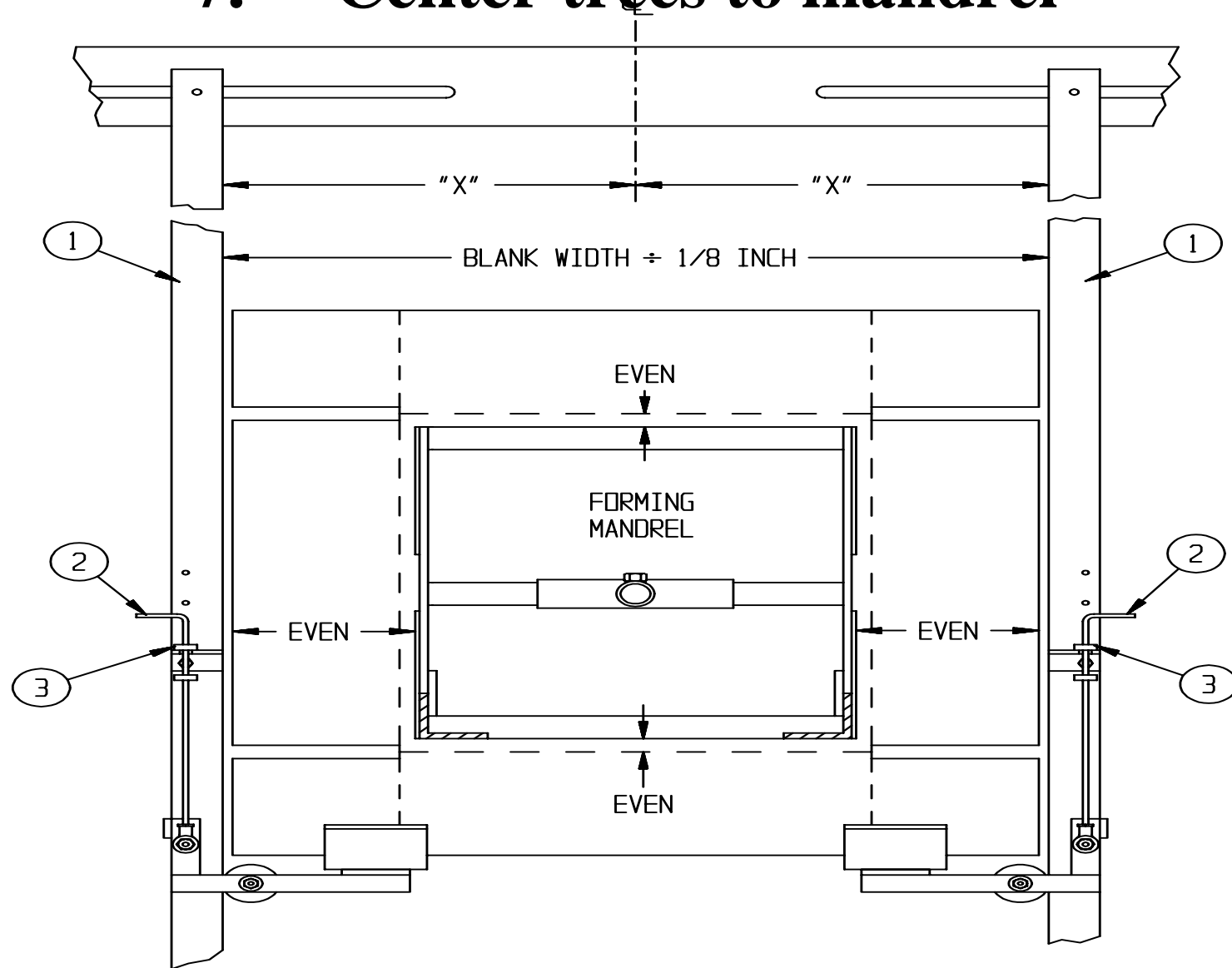


6. Center trees on top

Width of blank + 1/8" divide in half = distance from center



7. Center trees to mandrel



ADJUST VERTICAL GUIDE BARS (trees)

To adjust the Vertical Guide Bars, measure the overall width of the Blank and add 1/8 inch; this establishes the distance between the bars. After establishing this dimension, subtract the overall width measurement of the Mandrel. Then divide by 2 the remainder after the subtraction step (See Example Below). This method will give the required distance between the outside of the Mandrel and the inside of the Vertical Guide Bars. The distance should be equal on both sides. This assures that the lower part of the Vertical Guide Bars have been adjusted properly. Run a Blank down the Vertical Guide bars to check clearances set.

Example:

Tray Blank Overall Dimension	18 13/16"
Vertical Guide Bar Clearance	+ 1/8"
Distance between Vertical Guide Bar	18 15/16"
Overall Width of Mandrel	- 14 1/16"
	= 4 7/8"

Divide by 2 $4 \frac{7}{8}'' \div 2 = 2 \frac{7}{16}''$

Dimension from outside of Mandrel to inside edge of Vertical Guide Bars should be $2 \frac{7}{16}''$.

(Dimension should be equal on each side.)

9. Set Upper Hopper Blades

Set Hoppers So That Blades Are in Center of Slot in Paper



10. Set vacuum feed timing

Timing is set as follows: On the backstroke of the mandrel, stop the mandrel when the face of the mandrel is even with the center of the trees. At this point the vacuum feed assembly needs to be at its lowest position of travel on the round support rod. To achieve this remove the vacuum gear guard and remove the small pinion gear and let the vacuum assembly fall to the down position. Replace the pinion gear this will put the machine back in time. Once the vacuum feed timing has been set, reset the glue pattern.

11. Set vacuum cup rear position

The rear vacuum cup position is set as follows: With the vacuum motor on and the machine in the jog position pick a blank, jog the blank down in-till the linkage assembly is on the strait up and down portion of the “s” cam. At this point the blank needs to be resting next to the blank support guides that are bolted to the trees. Move the set collar on the vacuum cup tube in-till this is achieved.



13. Set bottom stops

- With a blank in front of the mandrel, move the bottom stops up or down so that the top score is even with the top of the mandrel.



14. Set top compression

- Move the top compression up or down so that there is roughly 1/16" clearance from the formed box and the forming shoe.



15. Set pushers (if applicable)

- With a blank in front of the mandrel, jog the mandrel forward in-till the cam follower on the pusher tomahawk is on the high point of the pusher cam. At this point slide the pusher pawl forward in-till the minor flap of the box is setting squarely in the bottom of the box. (Be careful not to push the box off of the mandrel)

16. Set Mandrel Forward Stroke

- With a Blank in Front of the Mandrel Jog the Blank Into the Forming Chamber In-till the Back Edge of the Box Goes Past the Stripers by $\frac{1}{4}$ ". Move the Con-rod up or Down in the Slot in the Feed Post Arm until This Is Achieved.



