
	<b>GILES CHEMICAL ~ PREMIER MAGNESIA</b>		
	<b>Company Form</b>		
	Title: <b>Combi Set-up – Generic 2KG (6pk)</b>	Number: <b>R15-SU-100-012</b>	
	Owner: <b>Thomas Evans</b>	Revision: <b>00</b>	
	Effective Date: <b>1/4/16</b>	Page: <b>1 of 1</b>	

**Set-up Guide:** Generic 2KG (6pk)

**Hot Melt Recipes - (Generic 6 X 2KG)**

**"Glue OFF"**

**(TAPE HEAD INSTALLED)**

Case Erector Stations	Letter on Machine	Settings
Magazine Height	A	12.36
Magazine Side Rail (sq. arm side)	B	25.41
Upper Case Opening Device	C	Adjust to top of case with the right bolt beside the spring on the DIE CUT notch
Major Flap Opener (If Applicable)	D	Do Not Use
Vacuum Cups	E	Position adjustable cups as needed
Carriage Position	F	13.32 (already set in recipe)
Hold Down Plate	G	13.04
Plow / Belt Drives	H	12.53
Case Packing Conveyor	I	12.58
Machine Speed in HMI (screen display)	J	75% (already set in recipe)
<b>Sealer Settings</b>		
Belt Drive	K	12.52
Upper Glue Head	L	12.48
Support Wheels	M	Barely Touching Box
Upper Rack Assembly	N	7.75

**Troubleshooting:**

- **Sealer Tearing Flaps**
  - Adjust flap folder rods to make contact with center of major flaps (narrow box closer together; wider box further apart)
  - Upper Rack Assembly (N) may be too low – Raise in small increments until binding goes away
- **Box Gets Stuck in Drive Belts**
  - Adjust width of belts – belts may be too close together; increase distance apart
- **Installation of Sealer Tape Head**
  - Turn switch to OFF position on Blue Glue Pot
  - Turn touch screen glue button OFF (Button will change to GRAY)
    - Press E-Stop; press glue button so that it changes from GREEN to GRAY; press RESET; press START
  - Remove first set of compression rollers closest to glue head by loosening thumb screw and removing roller assembly. Insert TOP tape head into slots and lock into place with thumb screw.

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