
	GILES CHEMICAL ~ PREMIER MAGNESIA		
	Company Form		
	Title: Combi Set-up - Members Mark 7lb.	Number: R15-SU-100-001	
	Owner: Thomas Evans	Revision: 00	
	Effective Date: 1/4/16	Page: 1 of 1	

Set-up Guide: Members Mark 7lb. (2pk)

Hot Melt Recipes - (Members Mark 2 X 7LB)

"Glue ON" – Lights up GREEN

(Touch Screen & Blue Glue Pot)

Case Erector Stations	Letter on Machine	Settings
Magazine Height	A	6.88
Magazine Side Rail (sq. arm side)	B	18.77
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	11.55 (already set in recipe)
Hold Down Plate	G	10.13
Plow / Belt Drives	H	7.35
Case Packing Conveyor	I	7.35
Machine Speed in HMI (screen display)	J	100% (already set in recipe)
Sealer Settings		
Belt Drive	K	7.33
Upper Glue Head	L	7.59
Support Wheels	M	Barely Touching Box
Upper Rack Assembly	N	6.55

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
- **Not Firing Glue in Sealer**
 - Check that glue pot is full (Never use glue that has touched the floor)
 - Check that glue pot is ON and temperature is at 340 deg.
 - Check touch screen on case erector to verify glue button is lit up GREEN
 - If not, press E-Stop; press glue button so that it lights up GREEN; press RESET; press START
 - Check that air is connected and all valves are in the ON position. Check to see if filters are full of water. Verify 40 psi on inside gauge of sealer.

Controlled Document

Only those quality documents viewed through the Giles Chemical electronic Documentation System are officially controlled. All other copies, whether viewed through another computer program or a printed version, are not controlled and, therefore, the Quality Unit at Giles assumes no responsibility for accuracy of the document.