
	<b>GILES CHEMICAL ~ PREMIER MAGNESIA</b>		
	<b>Company Form</b>		
	Title: <b>Combi Set-up – Dr Teal's 6lb. Club</b>	Number: <b>R15-SU-100-002</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:** Dr Teal's 6lb. Club (2pk)

**Hot Melt Recipes - (Dr Teal's 2 x 6LB)**

**"Glue ON" – Lights up GREEN  
(Touch Screen & Blue Glue Pot)**

Case Erector Stations	Letter on Machine	Settings
Magazine Height	<b>A</b>	<b>7.85</b>
Magazine Side Rail (sq. arm side)	<b>B</b>	<b>17.31</b>
Upper Case Opening Device	<b>C</b>	<b>Adjust to top of case with the right bolt beside the spring on the DIE CUT notch</b>
Major Flap Opener (If Applicable)	<b>D</b>	<b>Do Not Use</b>
Vacuum Cups	<b>E</b>	<b>Position adjustable cups as needed</b>
Carriage Position	<b>F</b>	<b>9.4 (already set in recipe)</b>
Hold Down Plate	<b>G</b>	<b>10.26</b>
Plow / Belt Drives	<b>H</b>	<b>8.11</b>
Case Packing Conveyor	<b>I</b>	<b>8.24</b>
Machine Speed in HMI (screen display)	<b>J</b>	<b>100% (already set in recipe)</b>
<b>Sealer Settings</b>		
Belt Drive	<b>K</b>	<b>8.11</b>
Upper Glue Head	<b>L</b>	<b>8.35</b>
Support Wheels	<b>M</b>	<b>Barely Touching Box</b>
Upper Rack Assembly	<b>N</b>	<b>6.82</b>

**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.

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