
	GILES CHEMICAL ~ PREMIER MAGNESIA		
	Company Form		
	Title: Combi Set-up – Walmart 8lb. Display (4pk)	Number: R15-SU-100-007	
	Owner: Thomas Evans	Revision: 00	
	Effective Date: 1/4/16	Page: 1 of 1	

Set-up Guide: Walmart 8lb. Display (4pk)

Hot Melt Recipes - (Walmart 8lb. Display)		"Glue OFF"
(No Top Flaps on Box)		(Tape Head in Sealer NOT USED)
Case Erector Stations	Letter on Machine	Settings
Magazine Height	A	9.25
Magazine Side Rail (sq. arm side)	B	24.88
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	15.43 (already set in recipe)
Hold Down Plate	G	10
Plow / Belt Drives	H	9.50
Case Packing Conveyor	I	9.75
Machine Speed in HMI (screen display)	J	75% (already set in recipe)
Sealer Settings		
Belt Drive	K	9.50
Upper Glue Head	L	9.50
Support Wheels	M	No
Upper Rack Assembly	N	11.5 (Does Not Touch Box or Pouches)

Troubleshooting:

- **Box Gets Stuck in Drive Belts**
 - Adjust width of belts – belts may be too close together; increase distance apart

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