

BOXXER AELS-002

BOXXER ALL IN ONE CASE PACKING SYSTEM SIDE LOAD AND TAPE

MEGABRANDS

OPERATION AND MAINTENANCE MANUAL

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TABLE OF CONTENTS

GENERAL SAFETY INFORMATION	5
INSTALLATION	6
MACHINE ORIENTATION.....	7
SEQUENCE OF OPERATION	8
STARTING THE MACHINE	9
OVERVIEW	11
1. SPLASH SCREEN.....	11
2. MAIN SCREEN	12
3. BATCH JOBS SCREEN	14
4. CHANGE OVER SCREEN.....	15
5. TOOLS SCREEN	15
6. INPUTS SCREEN	16
7. OUTPUTS SCREEN	16
8. MAINTENANCE SCREEN.....	17
9. SETUP SCREEN	18
10. PARAMETER SCREEN.....	19
11. PARAMETER VALUES	20
12. RECIPE CONFIGURATION.....	24
13. RECIPE VALUES	27
MACHINE ORIENTATION.....	43
MACHINE ADJUSTMENT PARAMETERS	44
CHANGE OVER	45
MAINTENANCE.....	63
MACHINE MAINTENANCE CHART.....	65
TROUBLESHOOTING.....	67
ERROR MESSAGES	69
LIGHT STACK COLOR CODES	73
RODLESS CYLINDER ADJUSTMENT	75
MACHINE SPECIFICATIONS	76
SPARE PARTS AND SERVICE	76
ASSEMBLY DRAWINGS	79

SAFETY

It is the Buyer's responsibility to provide adequate supervision to ensure that safe work methods are in use. It is also the responsibility of the Buyer to establish and follow a periodic and regular inspection of this machine to ensure that all parts, auxiliary equipment, and safe guards are in a safe operating condition.



SAFETY ALERT SYMBOL alerts of potential personal injury hazards. Obey all safety messages that follow this symbol to avoid possible injury or death.



DANGER indicates a hazardous situation which, if not avoided, will result in death or serious injury.



WARNING indicates a hazardous situation which, if not avoided, will result in death or serious injury.



CAUTION indicates a hazardous situation which, if not avoided, will result in minor or moderate injury.



NOTICE is used to address practices not related to personal injury.

SAFETY SYMBOLS

The following are used to warn against dangers or possible sources of danger. Become familiar with them! Failure to heed a warning could lead to personal injury and/or damage to the machinery or other equipment.



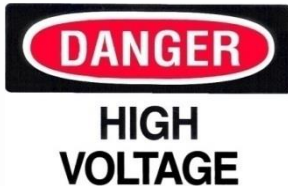
CAUTION - KEEP HANDS CLEAR: Indicates the presence of moving machinery; you should keep your hands clear of these parts while the machine is running.



DANGER - DO NOT OPEN WHILE MACHINE IS IN OPERATION: Indicates that any access door should remain closed while machine is in operation.



DANGER - DO NOT OPERATE WITHOUT GUARDS: Indicates that all guards supplied with this machine should remain attached to machine and closed. All electric interlocks to the door should remain in place and be functioning properly. Any attempt to disable these switches could cause harm to operators and personnel involved in the operation of the equipment.



DANGER - HIGH VOLTAGE: Indicates the presence of high voltage and that extreme caution should be taken when working in these areas. Always Turn off all electrical disconnects when working on the machine.



DANGER - OPEN MACHINERY: Located around the machine to warn operators and personnel that you are working in an area of the machine with working components. When this sign is viewed, the machine should be turned off and the power disconnected before attempting to access the area.



DANGER - STARTS AUTOMATICALLY: Located around the machine in areas where the machine maybe in Auto Idler mode. If the machine is on and running, it will automatically start running when the discharge is clear of product. It is advised that you remain clear of these areas when the machine is in operation.



When working on the machine, turn the power off for your safety and those around you.

Before starting the machine be sure to announce in a loud manner, "POWER ON", and be sure all personnel is clear off the machine before starting.

GENERAL SAFETY INFORMATION

This machine has been guarded for the safety of all personnel that are involved with the production process through the machine. When operating this equipment, all guard must be in place. Guards, safety switches, and interlocks should not be bypassed for any reason. Any change or modification to the safety equipment of this machine may produce a hazardous condition that could cause injury to persons working with the machine.

WARNING

Disconnecting or bypassing this machine's safety equipment will void the manufacturer's warranty.

SAFETY RULES:

1. No one should operate this equipment unless they have read the service manual and have been instructed on safety and operation of the machine.
2. All guard must be in their proper place before starting machine.
3. The operator should look to insure that the machine is clear before start-up, and call a warning, "CLEAR", to alert other personnel that the machine is being started.
4. Do not reach into the machine until it has come to a complete stop.
5. Activate an **EMERGENCY STOP** prior to clearing jams and reaching into the machine.
6. Turn the main power disconnect **OFF** and attach a padlock to assure that the power to the machine remains **OFF** when performing maintenance on the machine.
7. Wear safety glasses and gloves when working on or around pressurized glue system.
8. Do not wear loose clothing or jewelry when operating this machine.
9. Personnel should stay clear of machines with **AUTO-IDLER, auto start function**, to avoid possible injury.
10. Personnel should be familiar with the location and function of the **EMERGENCY STOP SWITCH** on the machine.
11. Electrical cabinets and boxes should not be opened unless power has been disconnected.

INSTALLATION

UNPACKING

- 1) Remove shipping container.
- 2) Remove any ties, blocks or pads that may be included.
- 3) Move machine to designated area and reassemble parts that have been removed for shipping.

AIR CONNECTION

- 4) Connect a flexible air line of suitable size (3/4" ID minimum) with a manual shut-off valve to the main air inlet
- 5) Set air regulator to 80psi.

POWER CONNECTION

- 6) Hook up the power according to the electrical schematic. A copy of this diagram will be in the electrical box and this manual.
- 7) Be sure you have the correct size electrical service to accommodate this machine.

NOTICE

Once the above procedures have been completed, you will be ready for our serviceman to finish the installation of the machine.

MACHINE ORIENTATION

This section of the manual is intended to help those who may not be familiar with packaging machine terminology. All the parts mentioned can be found on the assembly drawing located in the back of this manual.

PRELOAD STATION

This station is at the rear end of the machine and separated from it. In this station the stack of blanks is prepared while the machine is running, so when the machine is empty the stack is fed into the hopper. It is located at the rear of your machine.

HOPPER STATION

It is where the stack of blanks is elevated as the blanks are fed through the machine.

TOP SHEET FEED

This is the mechanism that picks up one blank from the top of the stack at the hopper and feed it through the rollers.

BOTTOM DRIVE

The bottom drive rollers feed the blank into the machine.

BLANK PICK UP

In this station an array of vacuum cups picks up the blank erecting the case.

REAR FOLDING STATION

This is where all the rear flaps of the case are folded in.

INFEED CONVEYOR

It receives the products from the packaging line rotating them 90° and controlling the product entry into the up stacking section of machine.

UP STACKER

It moves up and stacks the product in the packing pattern desired.

PUSHER

It moves the stacked product to the loading station.

LOADING STATION

The case is stopped at this station to be loaded with the product.

FRONT FOLDING STATION

Closes the front flaps of the case to be sealed.

SEALING STATION

Tape heads are waiting to seal the case on both ends

BOX FLIPPER

It turns the box at the discharge end of the machine so its discharge in an upstanding fashion

SEQUENCE OF OPERATION

1. The product enters on the infeed conveyor.
2. The product is received by a bumper mechanism that turns it 90°.
3. The product enters one by one the up staking station.
4. Each product is moved up and stacked in the packing pattern desired.
5. When the desired quantity of boxes stacked is reached, the products are moved up to a second stacking station.
6. At the same time the product enters the machine, a column of blanks is loaded into the preload station.
7. The column of blanks is moved into the hopper of the machine with a loading conveyor.
8. The motorized hopper moves the column of blanks upwards.
9. The top sheet feed mechanism takes one blank at a time from the top of the hopper and feeds it to the rollers in the top drive.
10. The blank stop is activated and keeps the blank in position while the bottom vacuum holds it down.
11. The blank pick up mechanism descends and pulls up the top side of the blank with a set of vacuum cups, erecting the case.
12. The minor kicker folds the minor flaps in.
13. The vacuum cups release the case.
14. The servo driven top and bottom guides move the case into the loading station.
15. Once the case is positioned in the loading station, vacuum cups pull the mayor flaps of the case.
16. Next, the flap openers pull the minor flaps out to aloud the product to be charged into the case.
17. While the front flaps are being opened the rear major flaps are being closed.
18. The side pusher will now push the column of products into the formed case waiting in the loading station.
19. The vacuum cups will release the front flaps now and the case will keep moving to the sealing station.
20. A second kicker folds the front minor flaps of the case while a plow bar mechanism closes the major folders.
21. The case enters the sealing station where two tape heads seal both ends of the case.
22. While the box leaves the machine, goes through the box flipper where the case is turned so is discharged in an up standing fashion.
23. The finished case will then exit the machine.

STARTING THE MACHINE

STEP FUNCTION: For use when testing box after size change over. The STEP setting allows you to pull and erect a blank through machine one step at a time.

1. Turn the **Power ON** Switch to the **ON** position.
2. Be sure the **E-STOP** is pulled out.
3. If the screen is not on, by touching the screen will activate back light.
4. Press the **RESET** button on front panel to activate power to machine.
5. Be sure blanks are loaded on hopper.
6. Set the **MANUAL MODE/AUTO MODE** button to **MANUAL MODE** on touch screen.
7. Set the **RUN MODE/STEP MODE** button to **STEP MODE** on touch screen.
8. Set the **FEED OFF/FEED ON** button to **FEED ON** to turn on the vacuum system on machine.
9. Press the **PRELOAD READY** button, the hopper conveyor will start moving with the stack until you arrive to the work position.
10. Press the **START** button.
11. By continually pushing the **STEP MODE** button, on the touch screen, the machine will cycle in a step by step process. This step function is used for first tray run through machine after change over for checking setting on machine before running.



RUN FUNCTION: For running the machine without auto idler function.

1. Turn the **Power ON** Switch to the **ON** position.
2. Be sure the **E-STOP** is pulled out.
3. If the screen is not on, by touching the screen will activate back light.
4. Press the **RESET** pushbutton on front panel to activate power to machine.
5. Be sure blanks are loaded on hopper.
6. Set the **MANUAL MODE/AUTO MODE** button to **MANUAL MODE** on touch screen.
7. Set the **RUN MODE/STEP MODE** button to **RUN MODE** on touch screen.
8. Set the **FEED OFF/FEED ON** button to **FEED ON** to turn on the vacuum system on machine.
9. Press the **PRELOAD READY** button, the hopper conveyor will start moving with the stack until you arrive to the work position.
10. Press the **START** button.

MACHINES WITH AUTO IDLER OPTION: For idling the machine when trays back up on discharge or on customers conveyor.

1. Turn the **Power ON** Switch to the **ON** position.
2. Be sure the **E-STOP** is pulled out.
3. If the screen is not on, by touching the screen will activate back light.
4. Press the **RESET** pushbutton on front panel to activate power to machine.
5. Be sure blanks are loaded on hopper.
6. Set the **MANUAL MODE/AUTO MODE** button to **AUTO MODE** on touch screen.
7. Set the **RUN MODE/STEP MODE** button to **RUN MODE** on touch screen.
8. Set the **FEED OFF/FEED ON** button to **FEED ON** to turn on the vacuum system on machine.
9. Press the **START** button.

PLEASE NOTE: Your machine is equipped with the AUTO IDLER FUNCTION. Located on the discharge side of you machine you will find a photo eye and cable. This photo eye should be mounted at a location where it will sense tray that is back upped in your product line. When these trays are seen by the photo eye you machine will go into idle mode until your line begins production again and the tray that is sensed moves.

OVERVIEW

The Operator Interface allows the user to perform machine functions and setup User Parameters to modify operation.

User Parameters are password protected.

1. SPLASH SCREEN



2. MAIN SCREEN



This screen allows the operation of machine functions.

The top menu bar is common to many of the screens and allows the user to navigate to the MAIN, BATCH, CHANGE OVER, TOOLS and SETUP screens.

The START pushbutton is used to turn ON the machine cycling. After an audible alarm, the machine will start to move all its mechanisms accordingly to the selected functions.

The STOP pushbutton is used to turn OFF the machine cycling. If a machine cycle is in progress, the cycle will complete and then the machine will stop.

The AUTO/MANUAL pushbutton is used to run the machine in Automatic or Manual Mode. In Manual Mode the Auto Idle sensor at the exit of the machine and all the low product sensors will be ignored. The machine continues to cycle even if cases are blocking the exit of the machine. In Auto Mode, the machine will stop cycling when the Auto Idle sensor at the exit of machine is blocked for a preset time and the low product signals will be generated accordingly.

The FEED OFF/FEED ON pushbutton inhibits the Product Stop to avoid product entering on the machine.

The RUN MODE/STEP MODE is used for continuous operations or indexes the machine in steps for diagnostic purposes. If the machine is in STEP MODE, you must use the NEXT STEP button to order the execution of the next step of the cycle.

A RESET pushbutton will turn yellow during faults demanding the operator attention to reset any fault allowing the machine to start again.

The PRELOAD READY pushbutton enables the entrance of the boxes if the hopper is empty; the button is reset when the boxes are in the position indicated by the photocell. (STACK IN POSITION).

The Jog Machine button allows jogging the Main Drive (Top and Bottom Drive) and Side Pusher for troubleshooting or removing any product from the machine.

The Index button allows the machine to complete a cycle in case a fault has occurred and it is necessary to clean the machine.



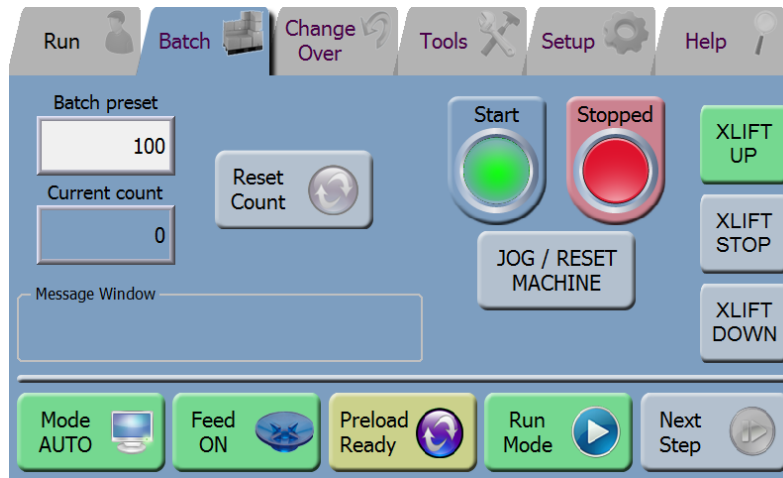
The motor jog controls are accessed by pressing NEXT PAGE:



When jogging the machine first select the direction (Forward/Reverse) on the corresponding selector switch and then press the Jog button. After an audible alarm the selected motor will start jogging at the desired speed.

3. BATCH JOBS SCREEN

Enter this screen by pressing the BATCH JOBS tab on the Menu bar.



Before and after perform a batch job, is recommended to remove all the remaining boxes on the machine and put them with the rest of the product.

The BATCH PRESET field displays and allows entry of the desired preset count of products to be completed. Once the machine is started, this value cannot be modified unless RESET COUNT button is pressed. Entering a quantity of zero will run the machine cycles continuously until the STOP button is pressed.

The BATCH COUNT field displays the number of products currently completed. When RESET COUNT button is pressed, this value is set to zero.

The START pushbutton starts machine cycle. An audible alert is invoked prior to machine motion.

The STOP pushbutton stops the machine cycle after completing the product that is in progress.

When BATCH COUNT equals BATCH PRESET the machine will automatically stop and a BATCH JOB DONE message will be displayed. The RESET COUNT button will zero the BATCH PRESET and BATCH COUNT and then the machine is allowed to start again.

4. CHANGE OVER SCREEN

Enter this screen by pressing the CHANGE OVER tab on the Menu bar.

YOU CANNOT PERFORM A CHANGE OVER WITH THE MACHINE RUNNING
STOP THE MACHINE FIRST

Box name		Change over adjustments			
C000121		1.- 7	9B.- 12.50	17.- 17.12	25.- 10.87
Box dimensions		2.- 7	10.- 10.75	18.- 11.12	26.- 11.75
Length (in):	12.37	3.- 2.00	11.- 5.25	19.- 12.00	27.- 10.75
Width (in):	10.87	4.- 12.00	12.- 17.25	20.- 12.50	28.- 11.87
Depth (in):	12.00	5.- 7	13A.- 7.00	21.- 12.00	29.- 10.75
Prod. dimensions		6.- 7	13B.- 7.00	22.- 12.50	30.- 10.87
Length (in):	12.00	7.- 11.50	14.- 17.25	23.- 22.75	31.- 10.75
Width (in):	11.50	8.- 12.50	15.- 5.25	24.- 11.75	32.- 10.75
Depth (in):	2.00	9A.- 12.50	16.- 12.50		

This screen allows selecting the tray to form and should be used on every change over. The BOX TO FORM determines the operational settings of the machine for different case sizes. It is possible to modify the BOX TO FORM by pressing the input box or using the Next Box and Previous Box buttons. The BOX TO FORM input box will be shown only when the machine has stop completely, since is not possible to change the tray size while the machine is running.

Every adjustment is identified by a number on the machine. This screen also shows every change over adjustments for the selected box. Execute the adjustments in ascendant order whenever possible.

A more detailed change over description is available by pressing the ASSISTED CHANGE OVER button.

5. TOOLS SCREEN

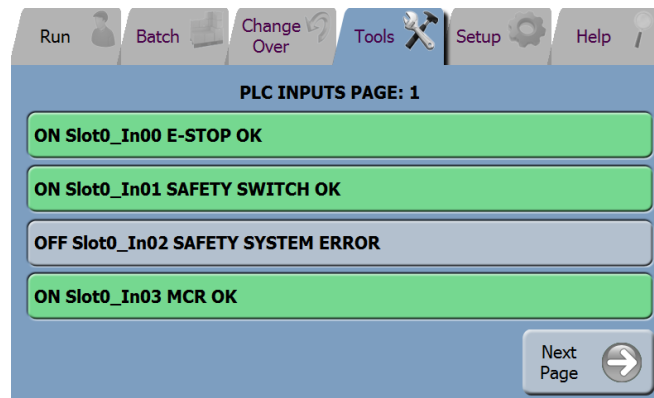
Enter this screen by pressing the TOOLS tab on the Menu bar.

INPUTS OUTPUTS MAINTENANCE

This screen is very useful to diagnose the machine. The INPUTS and OUTPUTS pushbutton switches to the inputs and outputs screen respectively where all PLC inputs and output status are displayed. The MAINTENANCE pushbutton allows entry to the maintenance screen for troubleshooting purposes.

6. INPUTS SCREEN

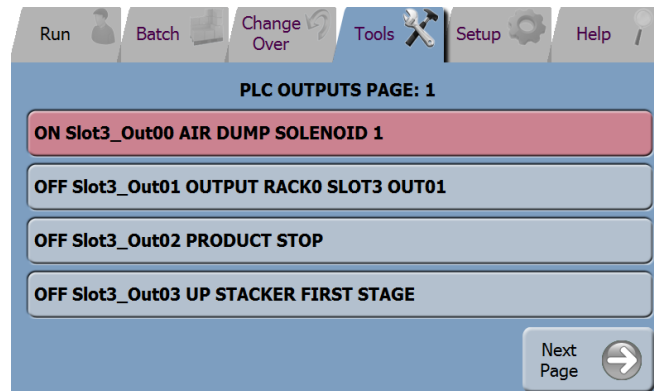
Enter this screen by pressing the TOOLS tab on the Menu bar and then press the INPUTS button.



The INPUTS SCREENS display the status of the PLC inputs.

7. OUTPUTS SCREEN

Enter this screen by pressing the TOOLS tab on the Menu bar and then press the OUTPUTS button.



The OUTPUTS SCREENS display the status of the PLC outputs.

8. MAINTENANCE SCREEN

Enter this screen by pressing the TOOLS tab on the Menu bar and then the MAINTENANCE button. When the MAINTENANCE button is pressed the Password screen is displayed. Once the correct password is entered the MAINTENANCE screen is displayed.

The screenshot shows the 'MAINTENANCE PAGE: 1' interface. At the top is a menu bar with tabs: Run, Batch, Change Over, Tools (selected), Setup, and Help. The main area is divided into two columns. The left column contains two yellow buttons: 'Force ENABLED' and 'Oscillator ENABLED'. Below these is a 'Message Window' label and a text input field. The right column is titled 'Main Drive manual control' and 'Side Pusher manual control'. Each has input fields for 'Actual position' (0.00), 'New position' (1200.00 for Main Drive, 40.00 for Side Pusher), 'Speed (%)' (25), and 'Accel (%)' (50). Below these fields are 'MOVE' buttons. At the bottom right is a 'Next Page' button with a right arrow.

The first screen is for the MAIN DRIVE and SIDE PUSHER servo system. Use caution when using these functions since all machine sequencing is bypassed. Here the maintenance personnel can move the MAIN DRIVE and SIDE PUSHER servo manually.

The rest of the maintenance screens look like the one shown below.

The screenshot shows the 'MAINTENANCE PAGE: 2' interface. The menu bar is the same as Page 1. The main area contains several buttons. On the left, 'Force ENABLED' and 'Oscillator DISABLED'. In the center, 'ON AIR DUMP SOLENOID 1' (yellow) and 'OFF PRODUCT STOP' (grey). On the right, 'OFF OUTPUT RACK0 SLOT3 OUT01' (grey) and 'OFF UPSTACKER FIRST STAGE' (grey). At the bottom left is a 'Message Window' label and a text input field. At the bottom right are 'Previous Page' (left arrow) and 'Next Page' (right arrow) buttons.

To activate an output, the Force button must be ENABLED, then is possible to turn ON and OFF an output by pressing its respective button.

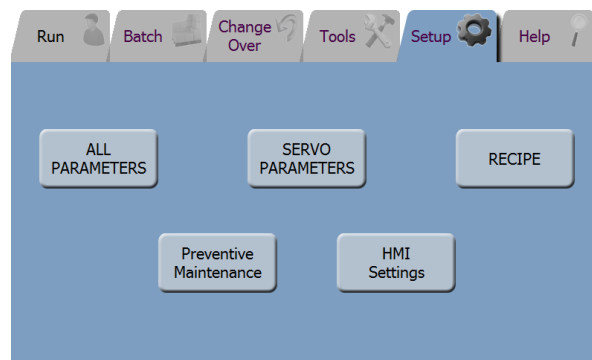
The oscillator button allows turning ON/OFF an output automatically using a desired frequency. The box for entering the ON/OFF time is showed only when the oscillator is ENABLED. This entered time is in milliseconds, thus means if a value of 1000 is entered, the outputs will be ON one second and OFF one second.

All the outputs turned ON before activating the Oscillator will remain ON, only those outputs activated after activating the Oscillator will turn ON and OFF automatically.

Caution: Use extreme caution when using this machine mode.

9. SETUP SCREEN

When the SETUP tab on the menu bar is pressed the Password screen is displayed. Once the correct password is entered the SETUP screen is displayed.

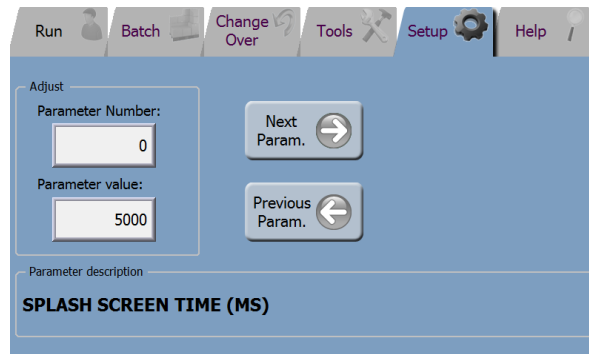


The SETTINGS pushbutton allows entry to the ALL PARAMETERS, SERVO PARAMETERS, RECIPE and HMI SETTINGS screens. The PARAMETERS pushbutton allows entry to the PARAMETERS screens. The RECIPE pushbutton allows editing machine settings specific to each product. The HMI Settings allow access to HMI settings like backlight intensity among others.

The SERVO PARAMETERS pushbutton allows access to servo parameters, these are duplicated in the list of general parameters, a change of these parameters will be updated in both.

10. PARAMETER SCREEN

Enter this screen by pressing the **SETTINGS** tab on the Menu bar, enter the correct password and then press the **PARAMETER** button on the **SETTINGS** screen.



The screenshot shows a software interface with a menu bar at the top containing 'Run', 'Batch', 'Change Over', 'Tools', 'Setup' (highlighted with a gear icon), and 'Help'. Below the menu bar is a blue panel titled 'Adjust'. Inside this panel, there are two input fields: 'Parameter Number:' with the value '0' and 'Parameter value:' with the value '5000'. To the right of these fields are two buttons: 'Next Param.' with a right-pointing arrow and 'Previous Param.' with a left-pointing arrow. At the bottom of the blue panel, there is a section labeled 'Parameter description' containing the text 'SPLASH SCREEN TIME (MS)'.

The User Parameter screen is used to setup machine parameters. This screen is password protected.

Use the arrows to change the **PARAMETER NUMBER** field. Press the **PARAMETER VALUE** input box and enter the new value. Press the **ENTER** key to save the new value.

11. PARAMETER VALUES

P. No.	Description	Default Config.	Custom Set 1	Custom Set 2
			Date:	Date:
0	SPLASH SCREEN TIME (MS)	5000		
1	MACHINE RUN DELAY (MS)	3000		
2	MACHINE JOG DELAY (MS)	3000		
3	MACHINE JOG MODE TIME (MS)	4000		
4	AUTO IDLER ON DELAY (MS)	2000		
5	AUTO IDLER OFF DELAY (MS)	0		
6	MACHINE IDLE TIME (SEC)	60		
7	BUZZER TIME OUT (MS)	10000		
8	SPARE	-		
9	SPARE	-		
10	SPARE	-		
11	BOTTOM DRIVE ZERO OFFSET (0.1MM)	2320		
12	TOP DRIVE ZERO OFFSET (0.1MM)	2320		
13	MAIN DRIVE RUNNING SPEED (1-100%)	95		
14	MAIN DRIVE RUNNING ACCELERATION (1-100%)	95		
15	MAIN DRIVE RUNNING TORQUE (1-100%)	60		
16	MAIN DRIVE MOTION DISTANCE (0.1MM)	13200		
17	MAIN DRIVE MOTION DELAY (MS)	50		
18	MAIN DRIVE SLOW SPEED DISTANCE (MM)	305		
19	SIDE PUSHER RUNNING HOME SPEED (1-100%)	30		
20	SIDE PUSHER RUNNING FORWARD SPEED (1-100%)	70		
21	SIDE PUSHER RUNNING ACCELERATION (1-100%)	45		
22	SIDE PUSHER RUNNING TORQUE (1-100%)	80		
23	SIDE PUSHER HORIZONTAL FORWARD DELAY (MS)	50		
24	SIDE PUSHER HORIZONTAL HOME DELAY (MS)	50		
25	SPARE	-		
26	SPARE	-		
27	PRODUCT STOP UP DELAY (MS)	0		
28	PRODUCT STOP DOWN DELAY (MS)	50		
29	UP STACKER FIRST STAGE UP DELAY (MS)	150		
30	UP STACKER FIRST STAGE DOWN DELAY (MS)	100		
31	UP STACKER FIRST STAGE UP JAM TIME (MS)	2000		
32	UP STACKER FIRST STAGE DOWN JAM TIME (MS)	2000		
33	UP STACKER SECOND STAGE UP DELAY (MS)	0		
34	UP STACKER SECOND STAGE DOWN DELAY (MS)	100		
35	UP STACKER SECOND STAGE UP JAM TIME (MS)	2000		

P. No.	Description	Default Config.	Custom Set 1	Custom Set 2
			Date:	Date:
36	UP STACKER SECOND STAGE DOWN JAM TIME (MS)	2000		
37	SPARE	-		
38	SIDE PUSHER VERTICAL DOWN DELAY (MS)	0		
39	SIDE PUSHER VERTICAL UP JAM TIME (MS)	2000		
40	SIDE PUSHER VERTICAL DOWN JAM TIME (MS)	2000		
41	TOP SHEET FEED VACUUM ON DELAY (MS)	0		
42	TOP SHEET FEED VACUUM OFF DELAY (MS)	250		
43	TOP SHEET FEED VERTICAL DOWN DELAY (MS)	50		
44	TOP SHEET FEED VERTICAL HOME DELAY (MS)	300		
45	TOP SHEET FEED VERTICAL DOWN JAM TIME (MS)	2000		
46	TOP SHEET FEED VERTICAL HOME JAM TIME (MS)	2000		
47	SPARE	-		
48	TOP SHEET FEED HORIZONTAL HOME DELAY (MS)	500		
49	TOP SHEET FEED HORIZONTAL FORWARD JAM TIME (MS)	2000		
50	TOP SHEET FEED HORIZONTAL HOME JAM TIME (MS)	2000		
51	SPARE	-		
52	BLANK STOP DOWN DELAY (MS)	500		
53	BOTTOM PICKUP UP DELAY (MS)	700		
54	BOTTOM PICKUP DOWN DELAY (MS)	1500		
55	ERECTING AND BOTTOM VACUUM ON DELAY (MS)	200		
56	ERECTING AND BOTTOM VACUUM OFF DELAY (MS)	650		
57	ERECTING PICKUP DOWN DELAY (MS)	500		
58	ERECTING PICKUP UP DELAY (MS)	200		
59	ERECTING PICKUP DOWN JAM TIME (MS)	2000		
60	ERECTING PICKUP UP JAM TIME (MS)	2000		
61	REAR FLAP FOLDER ON DELAY (MS)	800		
62	REAR FLAP FOLDER OFF DELAY (MS)	500		
63	MINOR KICKER ON DELAY (MS)	600		
64	MINOR KICKER OFF DELAY (MS)	500		
65	MINOR HOLDER ON DELAY (0.01MM)	8500		
66	MINOR HOLDER OFF DELAY (MS)	50		
67	RETRACTABLE PLOW BAR ON DELAY (MS)	400		
68	SPARE	-		
69	RETRACTABLE GUIDE ON DELAY (MS)	200		
70	RETRACTABLE GUIDE OFF DELAY (MS)	400		

P. No.	Description	Default Config.	Custom Set 1	Custom Set 2
			Date:	Date:
71	BOTTOM AND TOP FLAP OPENER VACUUM ON DELAY (MS)	0		
72	BOTTOM AND TOP FLAP OPENER VACUUM OFF DELAY (MS)	750		
73	BOTTOM AND TOP FLAP OPENER CYLINDER ON DELAY (MS)	275		
74	BOTTOM AND TOP FLAP OPENER CYLINDER OFF DELAY (MS)	200		
75	FLAP OPENER ON DELAY (MS)	1500		
76	FLAP OPENER OFF DELAY (MS)	600		
77	SPARE	-		
78	SECOND MINOR KICKER OFF DELAY (MS)	600		
79	SPARE	-		
80	SPARE	-		
81	SPARE	-		
82	SPARE	-		
83	SPARE	-		
84	SPARE	-		
85	INFEED CONVEYOR (VFD) ON DELAY (MS)	500		
86	INFEED CONVEYOR (VFD) OFF DELAY (MS)	500		
87	INFEED CONVEYOR (VFD) SPEED (X0.01Hz)	9000		
88	HOPPER CONVEYOR (VFD) ON DELAY (MS)	500		
89	HOPPER CONVEYOR (VFD) OFF DELAY (MS)	500		
90	HOPPER CONVEYOR (VFD) SPEED (X0.01Hz)	1500		
91	HOPPER MOTOR UP (VFD) ON DELAY (MS)	500		
92	HOPPER MOTOR UP (VFD) OFF DELAY (MS)	100		
93	HOPPER MOTOR DOWN (VFD) ON DELAY (MS)	0		
94	HOPPER MOTOR DOWN (VFD) OFF DELAY (MS)	0		
95	HOPPER MOTOR (VFD) SPEED (X0.01Hz)	2000		
96	TOP DRIVE (VFD) ON DELAY (MS)	500		
97	TOP DRIVE (VFD) OFF DELAY (MS)	500		
98	TOP DRIVE (VFD) SPEED (X0.01Hz)	2500z		
99	HOPPER FAST SPEED (X0.01Hz)	6000		
100	HOPPER UP FAST SPEED DELAY (MS)	3000		
101	SPARE	-		
102	SPARE	-		
103	SPARE	-		
104	SPARE	-		
105	BLANK PICK RETRIES	3		
106	SIDE PUSHER MOTION DISTANCE (0.001IN)	43380		
107	SPARE	-		
...	...	-		
...	...	-		
137	SPARE	-		

P. No.	Description	Default Config.	Custom Set 1	Custom Set 2
			Date:	Date:
138	JAM TIME CALIBRATION MODE (0 = OFF, 1 = ON)	0		
139	FACTORY TESTING MODE (0 = OFF, 1 = ON)	0		
140	BUZZER PATTERN - MACHINE START WARNING ON TIME (MS)	500		
141	BUZZER PATTERN - MACHINE START WARNING OFF TIME (MS)	500		
142	BUZZER PATTERN - LOW PRODUCT WARNING ON TIME (MS)	200		
143	BUZZER PATTERN - LOW PRODUCT WARNING OFF TIME (MS)	4800		
144	BUZZER PATTERN - AUTOIDLER WARNING ON TIME (MS)	500		
145	BUZZER PATTERN - AUTOIDLER WARNING OFF TIME (MS)	4500		
146	BUZZER PATTERN - BATCH DONE WARNING ON TIME (MS)	1000		
147	BUZZER PATTERN - BATCH DONE WARNING OFF TIME (MS)	1000		
148	BUZZER PATTERN - MACHINE FAULT ALARM ON TIME (MS)	1000		
149	BUZZER PATTERN - MACHINE FAULT ALARM OFF TIME (MS)	1500		

Note: The jam calibration mode is used to adjust the jam times of the cylinders automatically after adjusting any flow control. To activate this mode:

1. Set Parameter 138 = 1.
2. Go to Main Screen, set FEED to OFF and press START.
3. Run 5 or 6 empty cycles and press STOP.
4. Wait for the machine to stop completely.
5. Set Parameter 138 = 0.

To cancel the jam calibration mode press the E-Stop.

12. RECIPE CONFIGURATION

Access this screen by pressing the **SETUP** tab on the Menu bar, enter the correct password and then press the **RECIPE** button on the **SETUP** screen.

First select the **RECIPE #** in the top left of the window, all the values of the screen are updated to this value.

The screenshot shows the 'RECIPE EDITION PAGE: 1' interface. At the top, there is a menu bar with tabs: Run, Batch, Change Over, Tools, Setup (highlighted), and Help. Below the menu bar, the title 'RECIPE EDITION PAGE: 1' is displayed. The main area contains a 'Recipe #' field with the value '7' and a 'Box name' field with the value 'C000121'. To the right of these fields are 'Prev.' and 'Next' buttons. Below this, there is a section titled 'Select source and target recipe and press COPY RECIPE.' containing 'Source recipe:' and 'Target recipe:' fields, both with the value '0'. A 'COPY RECIPE' button with a circular arrow icon is positioned to the right of these fields. At the bottom right, there is a 'Next Page' button with a right-pointing arrow.

The **Prev.** and **Next** buttons allow scrolling the recipes back and forth.

The recipe copy feature allows the user to duplicate all the values on a recipe into another recipe, just enter the source and target recipe and press the **COPY RECIPE** button.

The **Next Page**, access to box and product dimensions as well as the product feeding settings:

The screenshot shows the 'RECIPE EDITION PAGE: 2' interface. The menu bar at the top is the same as in the previous page, with 'Setup' highlighted. The title 'RECIPE EDITION PAGE: 2' is displayed. The 'Recipe #' field still shows '7' and the 'Box name' field still shows 'C000121', with 'Prev.' and 'Next' buttons to the right. The main area is divided into two sections: 'Box specifications' and 'Product specifications'. The 'Box specifications' section has three fields: 'Length:' (12.37 in.), 'Width:' (10.87 in.), and 'Depth:' (12.00 in.). The 'Product specifications' section has three fields: 'Length:' (12.00 in.), 'Width:' (11.50 in.), and 'Depth:' (2.00 in.). At the bottom, there are two large buttons: 'Previous Page' with a left-pointing arrow and 'Next Page' with a right-pointing arrow.

The next 2 pages are for adjustment and actuator control.

Run Batch Change Over Tools Setup Help

RECIPE EDITION PAGE: 3

Recipe # 7 Box name C000121 Prev. Next

Upstacker adjustment
Upstacker Count : 5

Second Vacuum adjustment
ENABLE

Erecting adjustment
Ret. Plow Bar OFF Delay: 1000 ms
Blank Stop ON: 500.0 mm

Previous Page Next Page

Up stacker Count: Matches the number of boxes to be inserted.

ENABLE/DISABLE Second Vacuum: It is used to enable a second axillary vacuum during the process of forming the box. Applies for larger boxes.

Ret. Plow Bar OFF Delay: Time it takes to open the plow bar; its setting depends on the size of the box and the speed of the Main Drive.

Blank Stop ON: The ON action of the blank stop depends on the position of the Main Drive.

Run Batch Change Over Tools Setup Help

RECIPE EDITION PAGE: 4

Recipe # 7 Box name C000121 Prev. Next

Side Pusher Vertical adjustment
Side Pusher Vertical ON: 42.000 in
Top Sheet Feed Horizontal ON: 50.0 mm
Second Minor Kicker ON: 1140.0 mm

Previous Page Next Page

Side Pusher Vertical ON: The ON action of the Side Pusher Vertical depends on the position of the Side Pusher horizontal.

Top Sheet Feed Horizontal ON: The ON action of the Top Sheet Feed Horizontal depends on the position of the Main Drive.

Second Minor Kicker ON: The ON action of the Second Minor Kicker depends on the position of the Main Drive.

The last recipe's page allows adjusting all change over values.

Run Batch **Change Over** Tools Setup Help

RECIPE EDITION PAGE: 5

Recipe # Box name

Change over adjustments (in)

1.-	<input type="text" value="7"/>	6.-	<input type="text" value="7"/>	10.-	<input type="text" value="10.75"/>	14.-	<input type="text" value="17.25"/>
2.-	<input type="text" value="7"/>	7.-	<input type="text" value="11.50"/>	11.-	<input type="text" value="5.25"/>	15.-	<input type="text" value="5.25"/>
3.-	<input type="text" value="2.00"/>	8.-	<input type="text" value="12.50"/>	12.-	<input type="text" value="17.25"/>	16.-	<input type="text" value="12.50"/>
4.-	<input type="text" value="12.00"/>	9A.-	<input type="text" value="12.50"/>	13A.-	<input type="text" value="7.00"/>	17.-	<input type="text" value="17.12"/>
5.-	<input type="text" value="7"/>	9B.-	<input type="text" value="12.50"/>	13B.-	<input type="text" value="7.00"/>	18.-	<input type="text" value="11.12"/>

Run Batch **Change Over** Tools Setup Help

RECIPE EDITION PAGE: 6

Recipe # Box name

Change over adjustments (in)

19.-	<input type="text" value="12.00"/>	24.-	<input type="text" value="11.75"/>	29.-	<input type="text" value="10.75"/>
20.-	<input type="text" value="12.50"/>	25.-	<input type="text" value="10.87"/>	30.-	<input type="text" value="10.87"/>
21.-	<input type="text" value="12.00"/>	26.-	<input type="text" value="11.75"/>	31.-	<input type="text" value="10.75"/>
22.-	<input type="text" value="12.50"/>	27.-	<input type="text" value="10.75"/>	32.-	<input type="text" value="10.75"/>
23.-	<input type="text" value="22.75"/>	28.-	<input type="text" value="11.87"/>		

Finally, every adjustment is identified by a number on the machine. This screen allows editing every change over adjustment for the selected box. These values will be shown on the CHANGE OVER screen and on the CHANGE OVER HELP and are for informational purposes only.

13. RECIPE VALUES

Case #: 0	Case name:		
Description	Default Config.	Custom Set 1	Custom Set 2
		Date:	Date:
Box length			
Box width			
Box depth			
Product length			
Product width			
Product depth			
Up stacker Count			
Second Vacuum			
Retractable Plow Bar OFF Delay (ms)			
Blank Stop ON (mm)			
Side Pusher Vertical ON (in)			
Top Sheet Feed Horizontal ON (mm)			
Second Minor Kicker ON (mm)			
Changeover adjustment 1			
Changeover adjustment 2			
Changeover adjustment 3			
Changeover adjustment 4			
Changeover adjustment 5			
Changeover adjustment 6			
Changeover adjustment 7			
Changeover adjustment 8			
Changeover adjustment 9A			
Changeover adjustment 9B			
Changeover adjustment 10			
Changeover adjustment 11			
Changeover adjustment 12			
Changeover adjustment 13A			
Changeover adjustment 13B			
Changeover adjustment 14			
Changeover adjustment 15			
Changeover adjustment 16			
Changeover adjustment 17			
Changeover adjustment 18			
Changeover adjustment 19			
Changeover adjustment 20			
Changeover adjustment 21			
Changeover adjustment 22			
Changeover adjustment 23			
Changeover adjustment 24			
Changeover adjustment 25			

Changeover adjustment 26			
Changeover adjustment 27			
Changeover adjustment 28			
Changeover adjustment 29			
Changeover adjustment 30			
Changeover adjustment 31			
Changeover adjustment 32			

Case #: 1	Case name: C000266		
Description	Default Config.	Custom Set 1	Custom Set 2
		Date:	Date:
Box length	8.50		
Box width	7.50		
Box depth	8.75		
Product length	8.00		
Product width	8.00		
Product depth	3.50		
Up stacker Count	2		
Second Vacuum	DISABLE		
Retractable Plow Bar OFF Delay (ms)	1000		
Blank Stop ON (mm)	320.0		
Side Pusher Vertical ON (in)	43.00		
Top Sheet Feed Horizontal ON (mm)	50.0		
Second Minor Kicker ON (mm)	1150.0		
Changeover adjustment 1	1		
Changeover adjustment 2	1		
Changeover adjustment 3	3.50		
Changeover adjustment 4	8.25		
Changeover adjustment 5	1		
Changeover adjustment 6	13		
Changeover adjustment 7	8.62		
Changeover adjustment 8	8.00		
Changeover adjustment 9A	8.50		
Changeover adjustment 9B	8.50		
Changeover adjustment 10	7.50		
Changeover adjustment 11	3.50		
Changeover adjustment 12	12.12		
Changeover adjustment 13A	1		
Changeover adjustment 13B	1		
Changeover adjustment 14	12.12		
Changeover adjustment 15	3.50		
Changeover adjustment 16	8.50		
Changeover adjustment 17	12.62		
Changeover adjustment 18	8.00		
Changeover adjustment 19	8.50		
Changeover adjustment 20	9.75		
Changeover adjustment 21	8.75		
Changeover adjustment 22	12.12		
Changeover adjustment 23	15.50		
Changeover adjustment 24	8.75		
Changeover adjustment 25	7.50		
Changeover adjustment 26	8.75		
Changeover adjustment 27	7.50		

Changeover adjustment 28	8.36		
Changeover adjustment 29	7.50		
Changeover adjustment 30	7.50		
Changeover adjustment 31	7.50		
Changeover adjustment 32	7.50		

Case #: 2	Case name: C000300		
Description	Default Config.	Custom Set 1	Custom Set 2
		Date:	Date:
Box length	12.50		
Box width	8.00		
Box depth	10.25		
Product length	12.00		
Product width	9.62		
Product depth	2.5		
Up stacker Count	3		
Second Vacuum	ENABLE		
Retractable Plow Bar OFF Delay (ms)	1000		
Blank Stop ON (mm)	500.0		
Side Pusher Vertical ON (in)	42.00		
Top Sheet Feed Horizontal ON (mm)	50.0		
Second Minor Kicker ON (mm)	1142.0		
Changeover adjustment 1	2		
Changeover adjustment 2	2		
Changeover adjustment 3	2.50		
Changeover adjustment 4	12.00		
Changeover adjustment 5	3		
Changeover adjustment 6	12		
Changeover adjustment 7	9.75		
Changeover adjustment 8	12.00		
Changeover adjustment 9A	12.00		
Changeover adjustment 9B	12.00		
Changeover adjustment 10	8.00		
Changeover adjustment 11	3.75		
Changeover adjustment 12	14.12		
Changeover adjustment 13A	2		
Changeover adjustment 13B	2		
Changeover adjustment 14	14.12		
Changeover adjustment 15	3.87		
Changeover adjustment 16	12.50		
Changeover adjustment 17	14.12		
Changeover adjustment 18	8.25		
Changeover adjustment 19	10.25		
Changeover adjustment 20	12.50		
Changeover adjustment 21	10.25		
Changeover adjustment 22	12.50		
Changeover adjustment 23	20.00		
Changeover adjustment 24	10.00		
Changeover adjustment 25	8.00		
Changeover adjustment 26	10.25		
Changeover adjustment 27	8.00		

Changeover adjustment 28	10.18		
Changeover adjustment 29	8.00		
Changeover adjustment 30	8.18		
Changeover adjustment 31	8.50		
Changeover adjustment 32	8.00		

Case #: 3	Case name: C000174A		
Description	Default Config.	Custom Set 1	Custom Set 2
		Date:	Date:
Box length	29.50		
Box width	11.00		
Box depth	16.62		
Product length	29.00		
Product width	16.00		
Product depth	5.37		
Up stacker Count	2		
Second Vacuum	ENABLE		
Retractable Plow Bar OFF Delay (ms)	500		
Blank Stop ON (mm)	900.0		
Side Pusher Vertical ON (in)	40.750		
Top Sheet Feed Horizontal ON (mm)	40.0		
Second Minor Kicker ON (mm)	1100.0		
Changeover adjustment 1	3		
Changeover adjustment 2	3		
Changeover adjustment 3	5.25		
Changeover adjustment 4	29.00		
Changeover adjustment 5	8		
Changeover adjustment 6	6		
Changeover adjustment 7	16.25		
Changeover adjustment 8	29.00		
Changeover adjustment 9A	29.25		
Changeover adjustment 9B	29.25		
Changeover adjustment 10	11.00		
Changeover adjustment 11	5.12		
Changeover adjustment 12	22.12		
Changeover adjustment 13A	3		
Changeover adjustment 13B	3		
Changeover adjustment 14	21.87		
Changeover adjustment 15	5.37		
Changeover adjustment 16	28.12		
Changeover adjustment 17	21.75		
Changeover adjustment 18	11.62		
Changeover adjustment 19	16.50		
Changeover adjustment 20	29.50		
Changeover adjustment 21	16.50		
Changeover adjustment 22	29.50		
Changeover adjustment 23	40.12		
Changeover adjustment 24	16.25		
Changeover adjustment 25	11.12		
Changeover adjustment 26	16.50		
Changeover adjustment 27	11.00		

Changeover adjustment 28	16.50		
Changeover adjustment 29	11.00		
Changeover adjustment 30	11.06		
Changeover adjustment 31	11.00		
Changeover adjustment 32	11.00		

Case #: 4	Case name: C000170A		
Description	Default Config.	Custom Set 1	Custom Set 2
		Date:	Date:
Box length	24.50		
Box width	11.00		
Box depth	16.75		
Product length	24.00		
Product width	16.25		
Product depth	5.25		
Up stacker Count	2		
Second Vacuum	ENABLE		
Retractable Plow Bar OFF Delay (ms)	600		
Blank Stop ON (mm)	825.0		
Side Pusher Vertical ON (in)	40.750		
Top Sheet Feed Horizontal ON (mm)	30.0		
Second Minor Kicker ON (mm)	1125.0		
Changeover adjustment 1	4		
Changeover adjustment 2	4		
Changeover adjustment 3	5.25		
Changeover adjustment 4	24.00		
Changeover adjustment 5	5		
Changeover adjustment 6	8		
Changeover adjustment 7	16.00		
Changeover adjustment 8	24.00		
Changeover adjustment 9A	23.25		
Changeover adjustment 9B	23.25		
Changeover adjustment 10	11.25		
Changeover adjustment 11	5.20		
Changeover adjustment 12	22.12		
Changeover adjustment 13A	4		
Changeover adjustment 13B	4		
Changeover adjustment 14	22.00		
Changeover adjustment 15	5.25		
Changeover adjustment 16	24.50		
Changeover adjustment 17	21.75		
Changeover adjustment 18	12.00		
Changeover adjustment 19	16.50		
Changeover adjustment 20	24.50		
Changeover adjustment 21	16.62		
Changeover adjustment 22	24.50		
Changeover adjustment 23	35.25		
Changeover adjustment 24	16.50		
Changeover adjustment 25	11.25		
Changeover adjustment 26	16.75		

Changeover adjustment 27	11.76		
Changeover adjustment 28	16.50		
Changeover adjustment 29	11.25		
Changeover adjustment 30	11.25		
Changeover adjustment 31	11.25		
Changeover adjustment 32	11.25		

Case #: 5	Case name: C000235		
Description	Default Config.	Custom Set 1	Custom Set 2
		Date:	Date:
Box length	12.50		
Box width	8.00		
Box depth	10.25		
Product length	12.00		
Product width	9.62		
Product depth	2.50		
Up stacker Count	5		
Second Vacuum	DISABLE		
Retractable Plow Bar OFF Delay (ms)	1000.0		
Blank Stop ON (mm)	500.0		
Side Pusher Vertical ON (in)	42.000		
Top Sheet Feed Horizontal ON (mm)	50.0		
Second Minor Kicker ON (mm)	1140.0		
Changeover adjustment 1	2		
Changeover adjustment 2	2		
Changeover adjustment 3	2.50		
Changeover adjustment 4	12.00		
Changeover adjustment 5	2		
Changeover adjustment 6	12		
Changeover adjustment 7	9.75		
Changeover adjustment 8	12.37		
Changeover adjustment 9A	12.37		
Changeover adjustment 9B	12.37		
Changeover adjustment 10	8.00		
Changeover adjustment 11	3.75		
Changeover adjustment 12	14.12		
Changeover adjustment 13A	2		
Changeover adjustment 13B	2		
Changeover adjustment 14	14.12		
Changeover adjustment 15	3.75		
Changeover adjustment 16	12.50		
Changeover adjustment 17	14.12		
Changeover adjustment 18	8.25		
Changeover adjustment 19	10.25		
Changeover adjustment 20	12.50		
Changeover adjustment 21	10.25		
Changeover adjustment 22	11.62		
Changeover adjustment 23	20.25		
Changeover adjustment 24	10.25		
Changeover adjustment 25	8.00		
Changeover adjustment 26	10.25		

Changeover adjustment 27	8.00		
Changeover adjustment 28	10.25		
Changeover adjustment 29	8.00		
Changeover adjustment 30	8.06		
Changeover adjustment 31	8.00		
Changeover adjustment 32	8.00		

Case #: 6	Case name: C000125		
Description	Default Config.	Custom Set 1	Custom Set 2
		Date:	Date:
Box length	22.37		
Box width	13.00		
Box depth	14.50		
Product length	22.00		
Product width	14.00		
Product depth	3.00		
Up stacker Count	4		
Second Vacuum	ENABLE		
Retractable Plow Bar OFF Delay (ms)	500		
Blank Stop ON (mm)	830.0		
Side Pusher Vertical ON (in)	41.50		
Top Sheet Feed Horizontal ON (mm)	60.0		
Second Minor Kicker ON (mm)	1085.0		
Changeover adjustment 1	6		
Changeover adjustment 2	6		
Changeover adjustment 3	3.00		
Changeover adjustment 4	22.25		
Changeover adjustment 5	7		
Changeover adjustment 6	3		
Changeover adjustment 7	14.00		
Changeover adjustment 8	22.00		
Changeover adjustment 9A	21.50		
Changeover adjustment 9B	21.50		
Changeover adjustment 10	12.75		
Changeover adjustment 11	6.25		
Changeover adjustment 12	20.75		
Changeover adjustment 13A	6		
Changeover adjustment 13B	6		
Changeover adjustment 14	20.75		
Changeover adjustment 15	6.37		
Changeover adjustment 16	22.37		
Changeover adjustment 17	20.87		
Changeover adjustment 18	13.50		
Changeover adjustment 19	14.50		
Changeover adjustment 20	22.37		
Changeover adjustment 21	14.50		
Changeover adjustment 22	22.37		
Changeover adjustment 23	34.87		
Changeover adjustment 24	14.50		
Changeover adjustment 25	12.87		
Changeover adjustment 26	14.87		
Changeover adjustment 27	12.87		

Changeover adjustment 28	14.50		
Changeover adjustment 29	12.87		
Changeover adjustment 30	12.87		
Changeover adjustment 31	12.87		
Changeover adjustment 32	12.87		

Case #: 7	Case name: C000121		
Description	Default Config.	Custom Set 1	Custom Set 2
		Date:	Date:
Box length	12.37		
Box width	10.87		
Box depth	12.00		
Product length	12.00		
Product width	11.50		
Product depth	2.00		
Up stacker Count	5		
Second Vacuum	ENABLE		
Retractable Plow Bar OFF Delay (ms)	1000		
Blank Stop ON (mm)	500.0		
Side Pusher Vertical ON (in)	42.00		
Top Sheet Feed Horizontal ON (mm)	50.0		
Second Minor Kicker ON (mm)	1140.0		
Changeover adjustment 1	7		
Changeover adjustment 2	7		
Changeover adjustment 3	2.00		
Changeover adjustment 4	12.00		
Changeover adjustment 5	3		
Changeover adjustment 6	7		
Changeover adjustment 7	11.50		
Changeover adjustment 8	12.00		
Changeover adjustment 9A	12.25		
Changeover adjustment 9B	12.25		
Changeover adjustment 10	10.75		
Changeover adjustment 11	5.25		
Changeover adjustment 12	17.25		
Changeover adjustment 13A	7		
Changeover adjustment 13B	7		
Changeover adjustment 14	17.25		
Changeover adjustment 15	5.37		
Changeover adjustment 16	12.50		
Changeover adjustment 17	17.12		
Changeover adjustment 18	11.12		
Changeover adjustment 19	12.00		
Changeover adjustment 20	12.50		
Changeover adjustment 21	12.00		
Changeover adjustment 22	12.50		
Changeover adjustment 23	22.75		
Changeover adjustment 24	11.75		
Changeover adjustment 25	10.87		
Changeover adjustment 26	11.75		
Changeover adjustment 27	10.75		

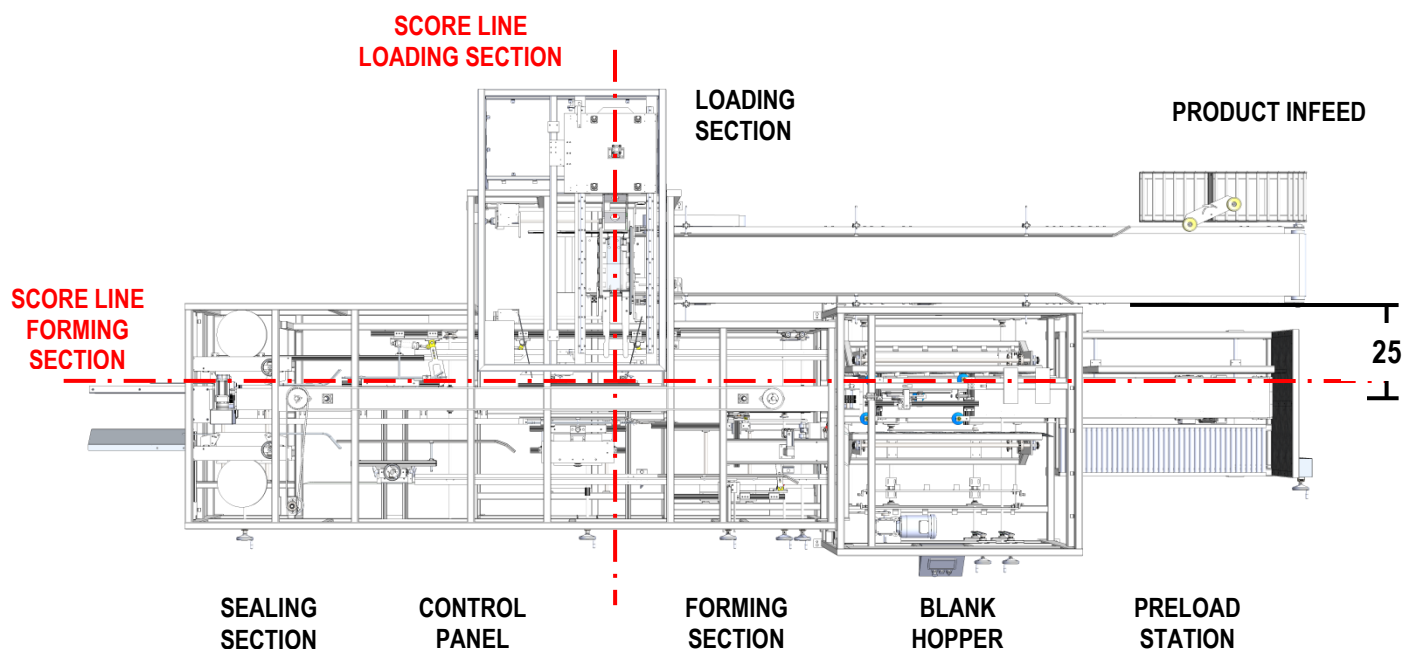
Changeover adjustment 28	11.87		
Changeover adjustment 29	10.75		
Changeover adjustment 30	10.87		
Changeover adjustment 31	10.75		
Changeover adjustment 32	10.75		

MACHINE ORIENTATION

! WARNING

DO NOT MAKE ADJUSTMENTS TO THIS MACHINE WHILE THE MACHINE IS RUNNING.

The machine should be turned off and the shutoff valve to the pneumatic lines closed to assure the safety of the operator when making these adjustments.

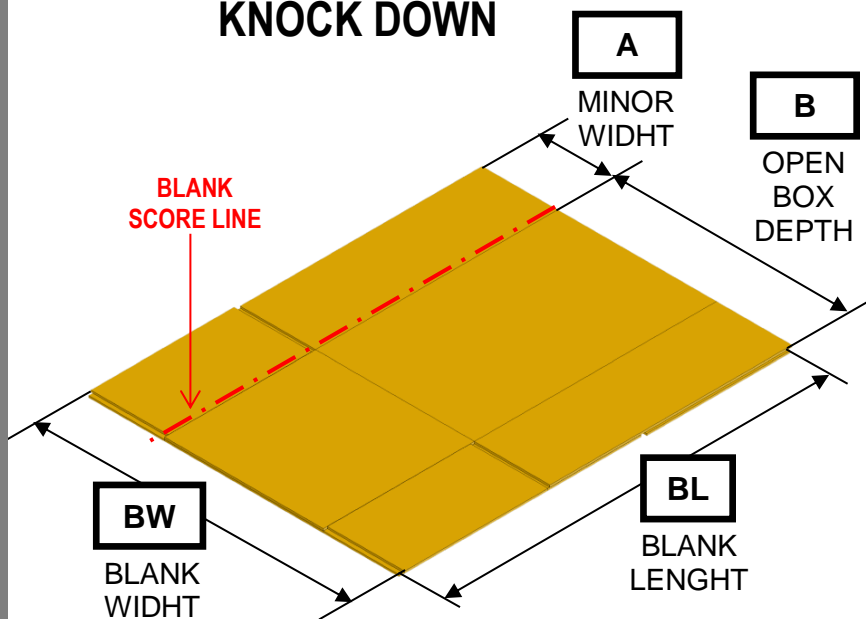


LOCATION OF SCORE LINES

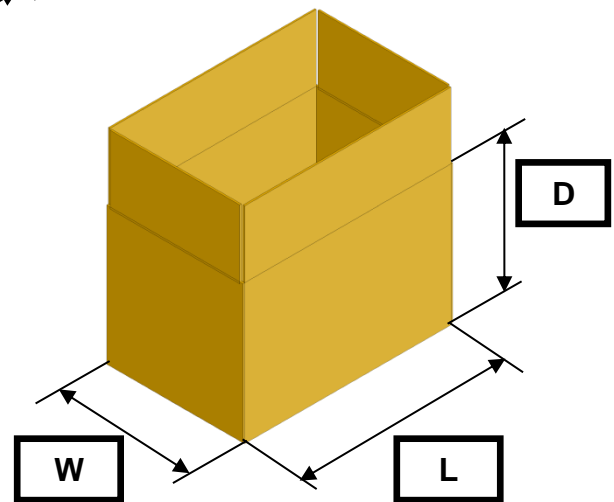
The detail above shows the relationship of the blank to the machine. When changing over from one size tray to the other the blank must be located in the machine on the centerlines as shown. The width of the blank will always be located with the edge in the hopper score line. The width of the erected case must be lined up with the center of the erecting station. All adjustments will converge to these center line locations.

MACHINE ADJUSTMENT PARAMETERS

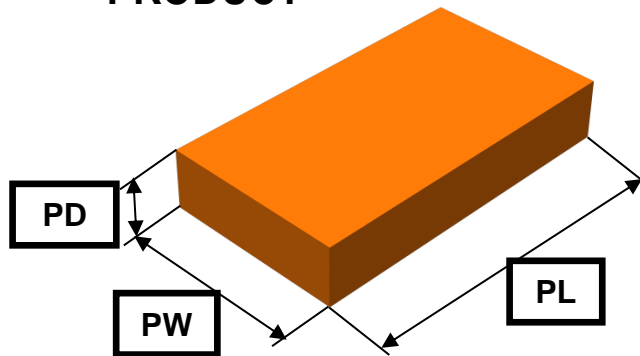
KNOCK DOWN



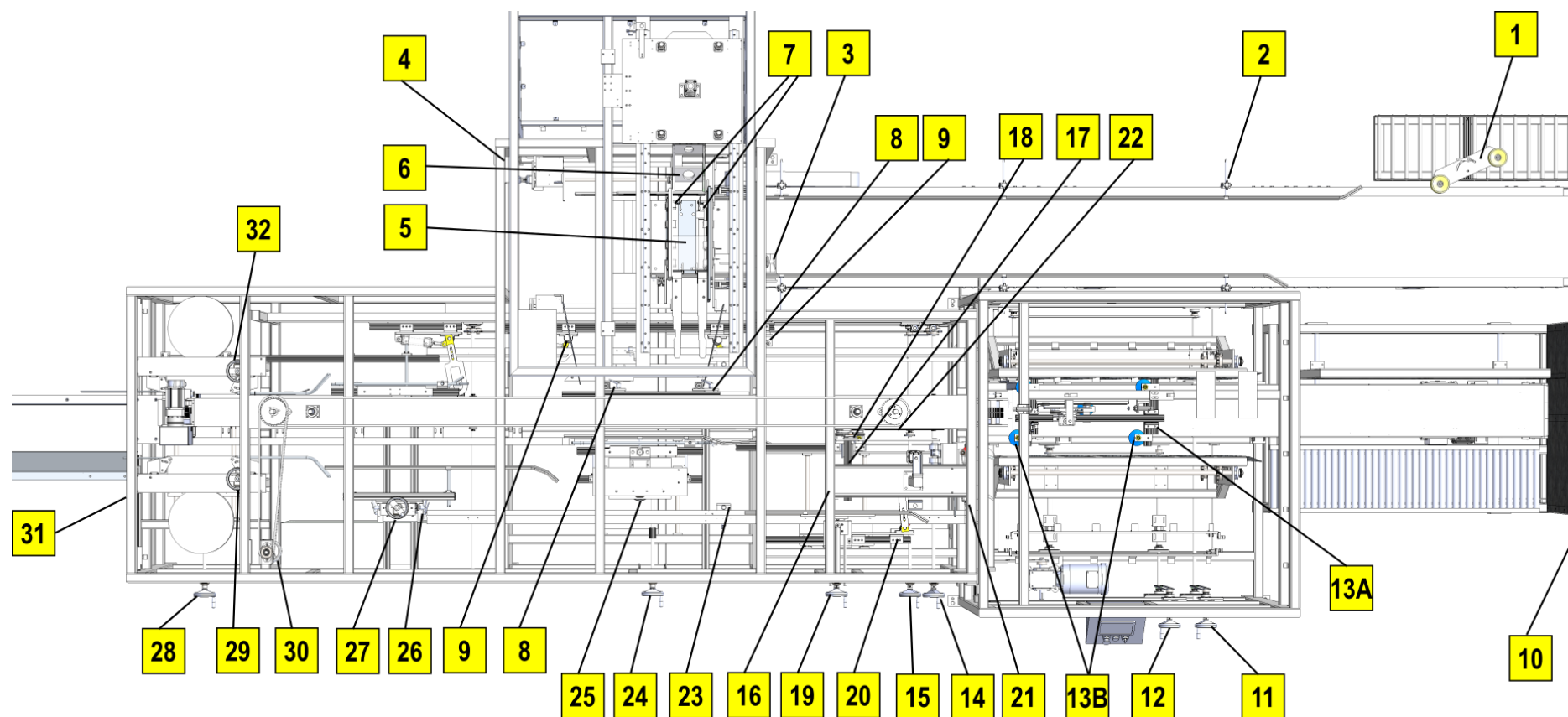
CASE



PRODUCT



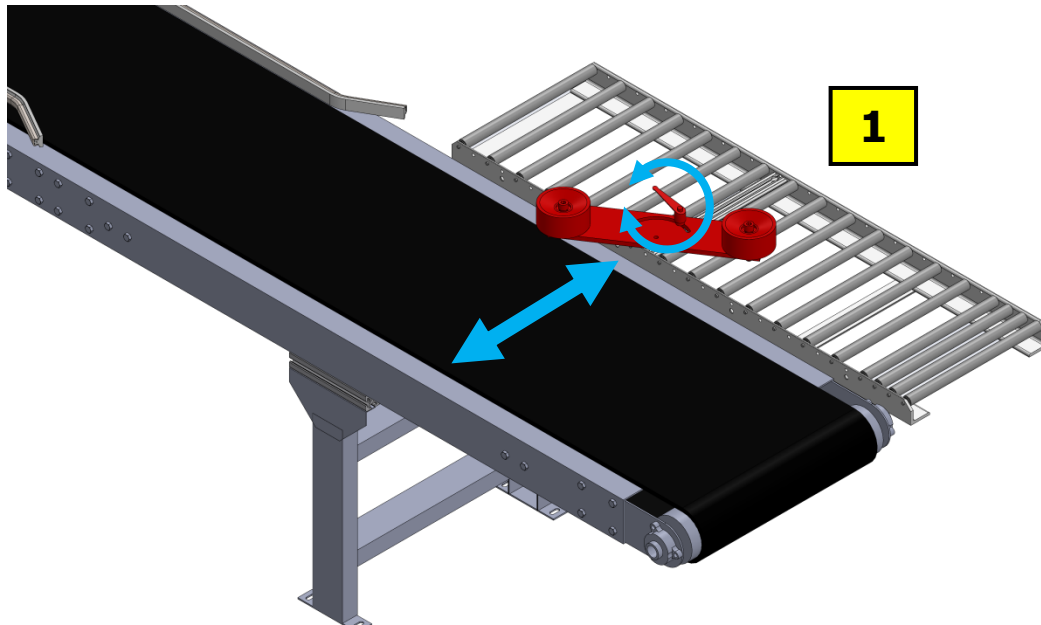
CHANGE OVER



1. PRODUCT BUMPER ADJUSTMENT

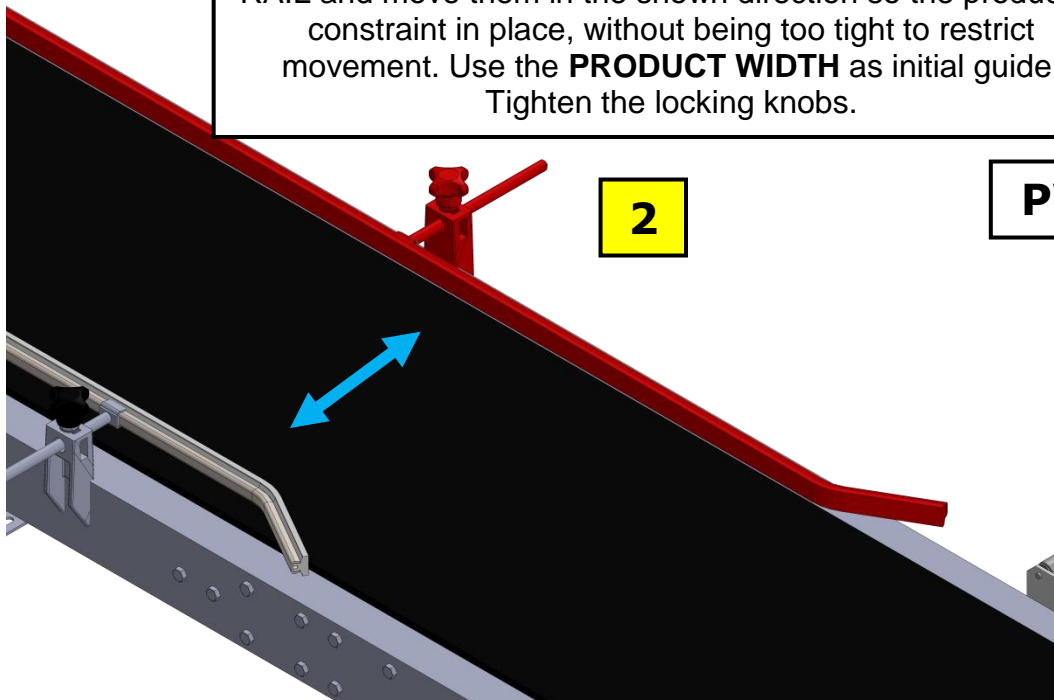


Loosen the locking handle and adjust PRODUCT BUMPER



2. CONVEYOR GUIDE RAIL ADJUSTMENT

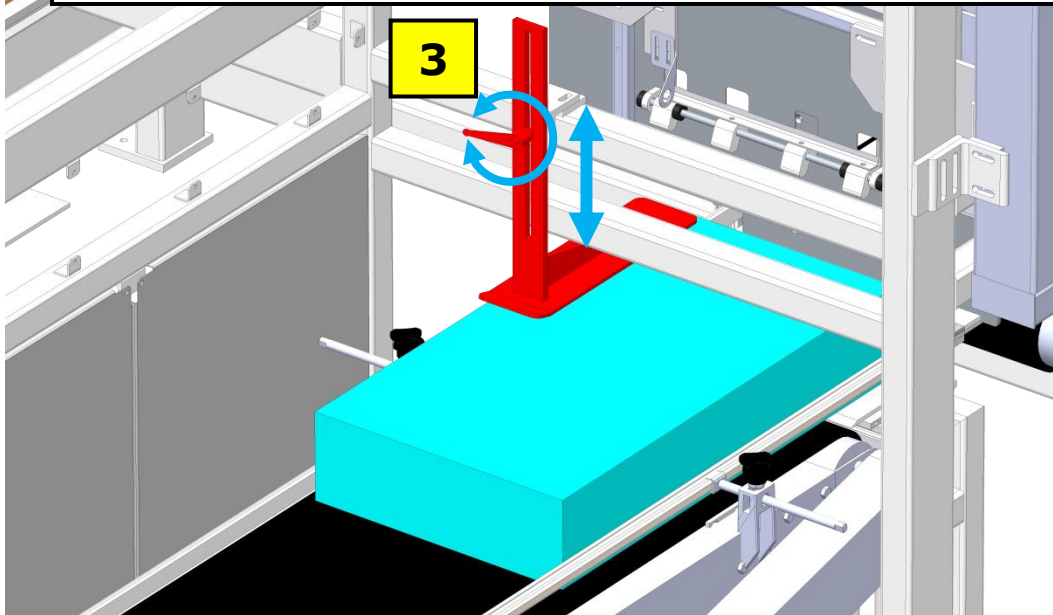
Loosen the locking knobs of the outer CONVEYOR GUIDE RAIL and move them in the shown direction so the product is constraint in place, without being too tight to restrict movement. Use the **PRODUCT WIDTH** as initial guide. Tighten the locking knobs.



3. PRODUCT HOLD ADJUSTMENT



Loosen the locking handle and adjust the PRODUCT HOLD in the shown direction. Keep a distance of $\frac{1}{4}$ " between the product hold and the product. Tighten the locking handle.



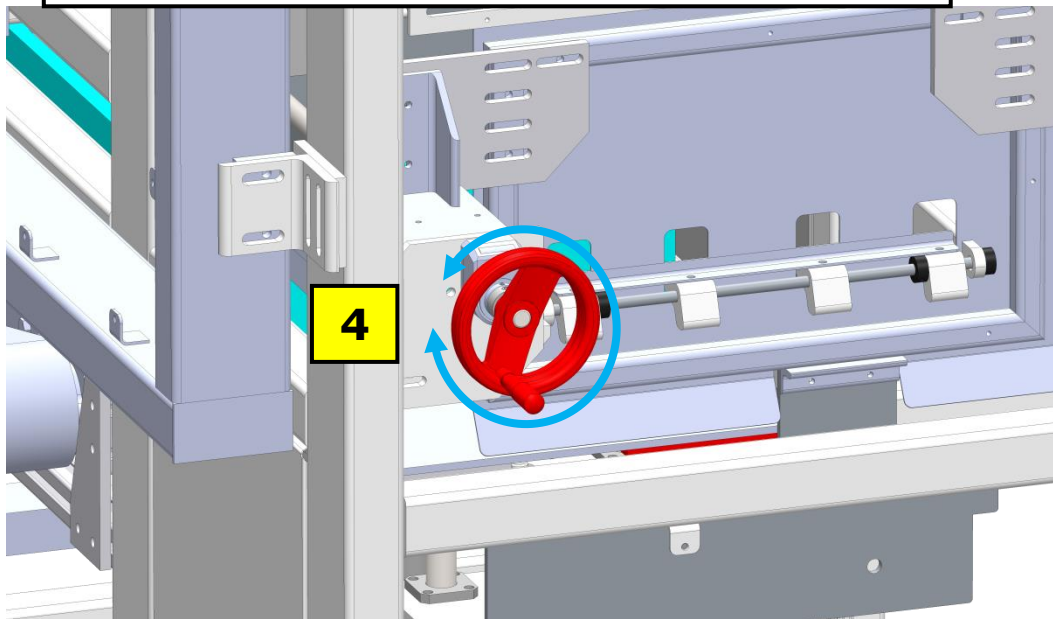
4. UP STACKING SIDE GUIDE ADJUSTMENT



Turn the hand-wheel and adjust the UP STACKING SIDE GUIDE to **PRODUCT LENGTH (PL)** in the dial indicator according to product to run.



PL

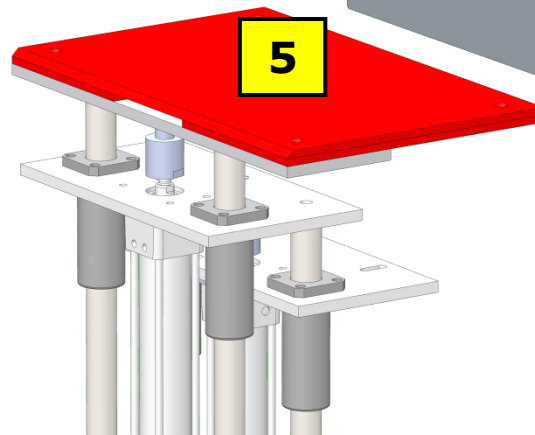


When changing to a larger product proceed to adjust step 8 before opening the up stacking side guide.

5. UP STACKER ASSEMBLY



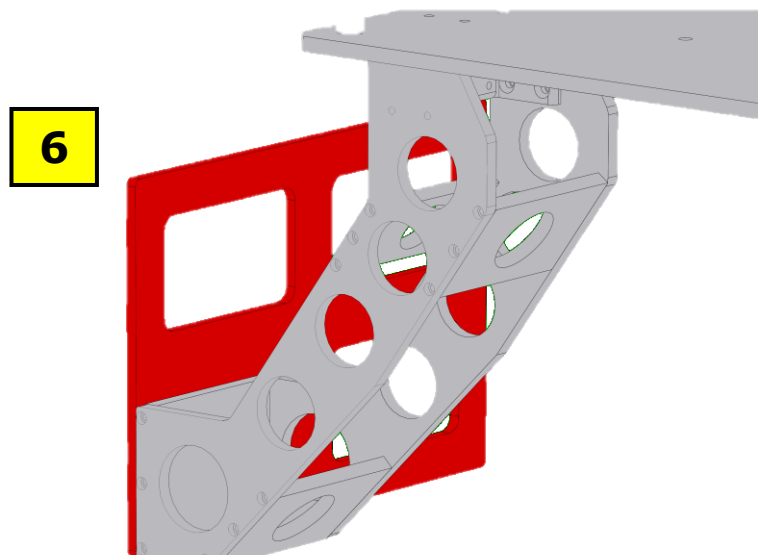
Loosen the nuts and remove the UP STACKER PLATE and replace it with the plate fitted to the **PRODUCT** to run. Tighten the nuts.



6. SIDE PUSHER ASSEMBLY



Loosen the nuts and remove the SIDE PUSHER PLATE and replace it with the plate fitted to the **CASE** to run. Tighten the nuts.



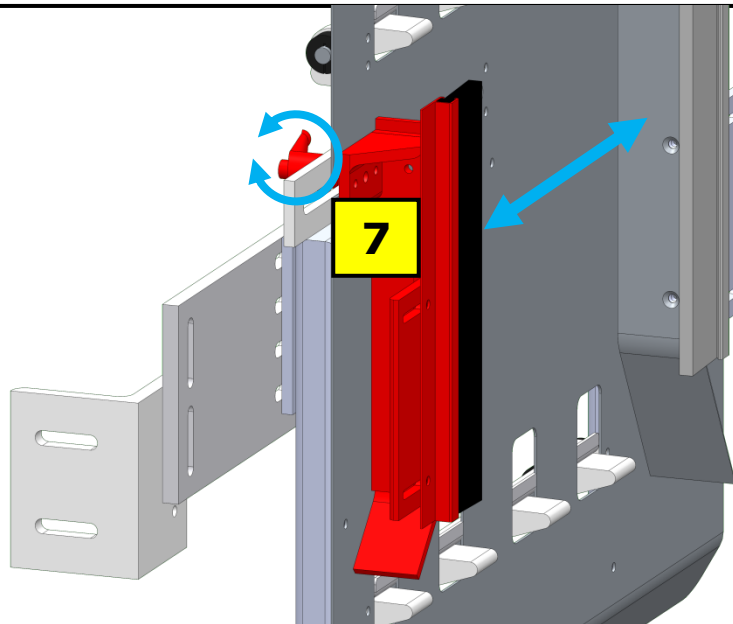
7. PRODUCT REAR GUIDE



Loosen the locking handle. Move the **PRODUCT REAR GUIDE** to **PRODUCT WIDTH (PW)** on the scale. Tighten the locking handle. Do this on both guides.



= **PW**



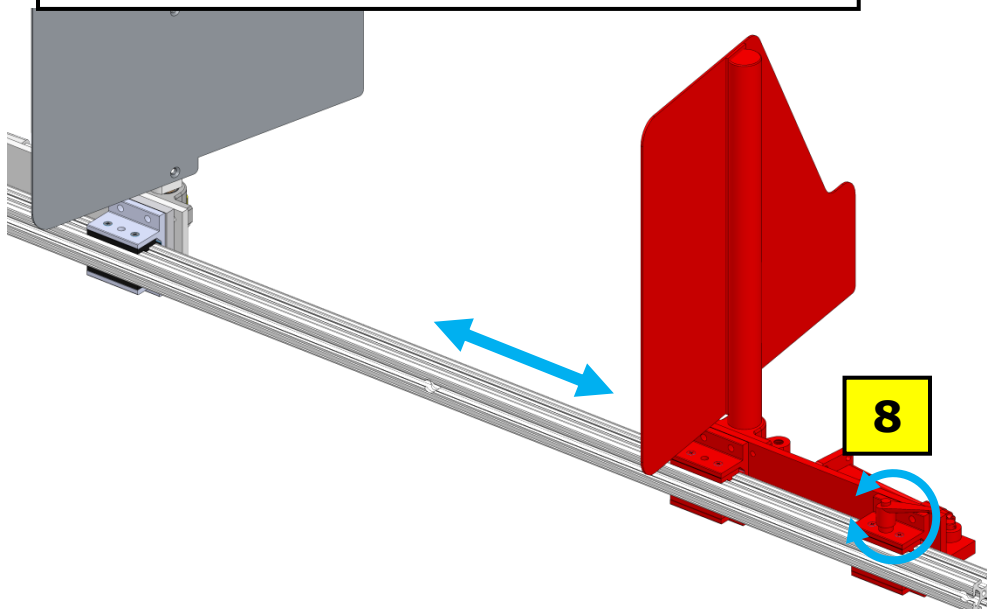
8. FLAP OPENER ADJUSTMENT



Loosen the locking handle and adjust the **FLAP OPENER** in the shown direction to show **CASE LENGTH (L)** on the scale. Tighten the locking handle.



= **L**



When changing to a smaller box make sure to adjust step 4 before moving the flap opener.

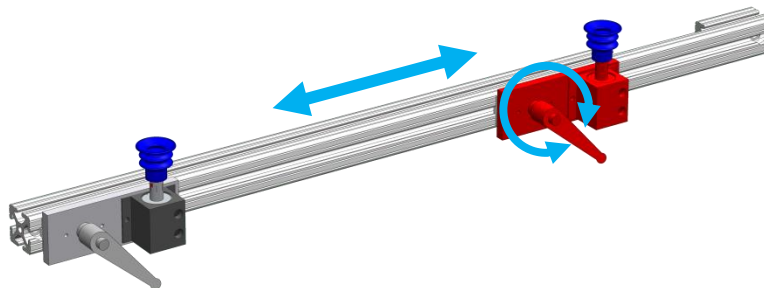
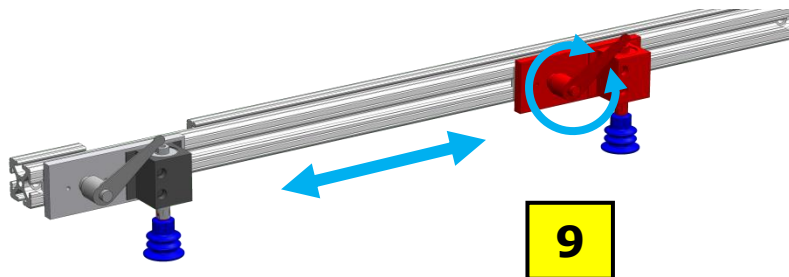
9. FLAP HOLDER ASSEMBLY



Loosen the locking handles and adjust the FLAP HOLDER in the shown direction to **CASE LENGTH (L)** on the scale. Tighten the locking handle.



= **L**



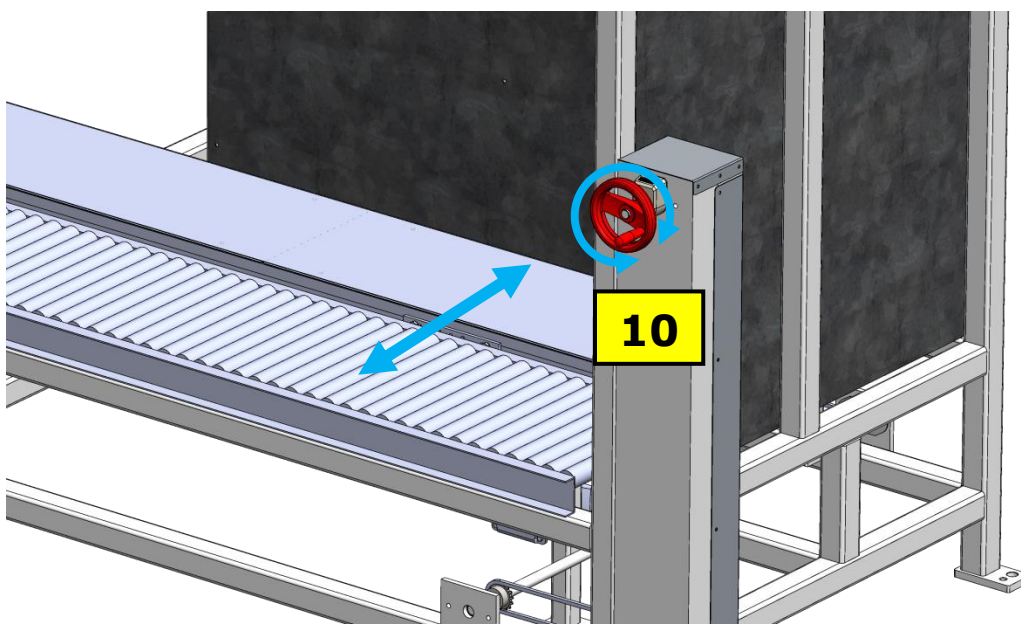
10. PRELOAD STATION ADJUSTMENT



Turn the hand-wheel and adjust the PRELOAD STATION to **CASE WIDTH (W)** in the dial indicator according to blank to run.



= **W**



11. HOPPER RIGTH GUIDE ADJUSTMENT



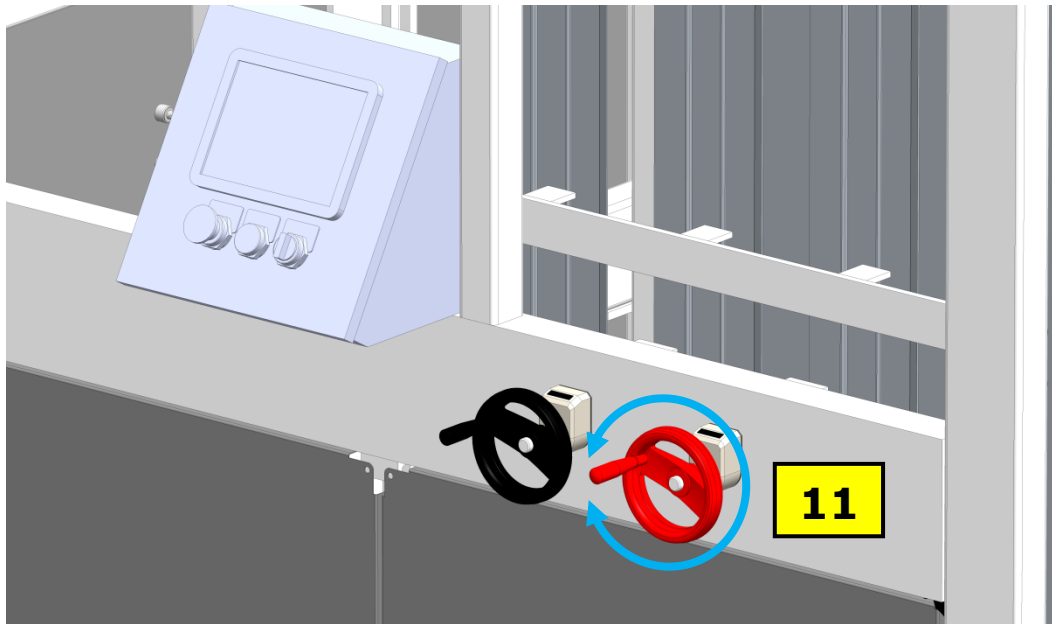
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Turn the hand-wheel and adjust the HOPPER RIGHT GUIDE to **MINOR WIDTH (A)** in the dial indicator.



=

A



12. HOPPER LEFT GUIDE ADJUSTMENT



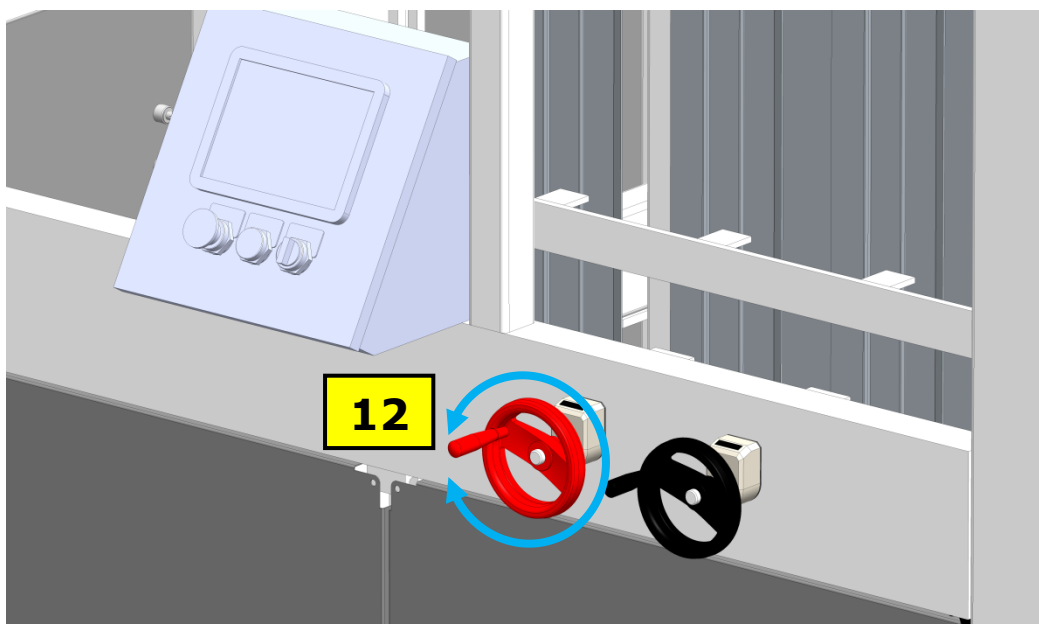
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Turn the hand-wheel and adjust the HOPPER RIGHT GUIDE to **OPEN CASE DEPTH (B)** in the dial indicator.



=

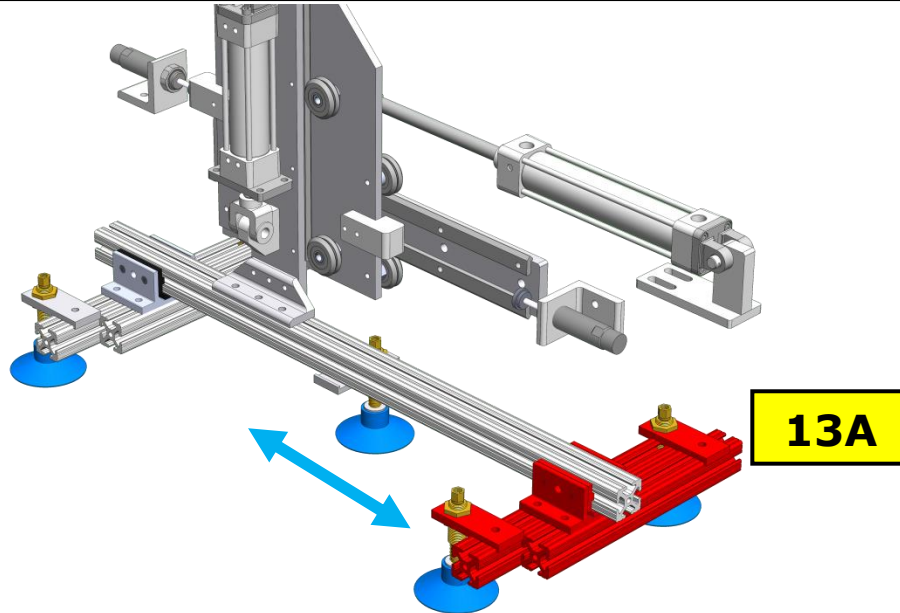
B



13A. TOP SHEET FEED VACUUM CUPS ADJUSTMENT



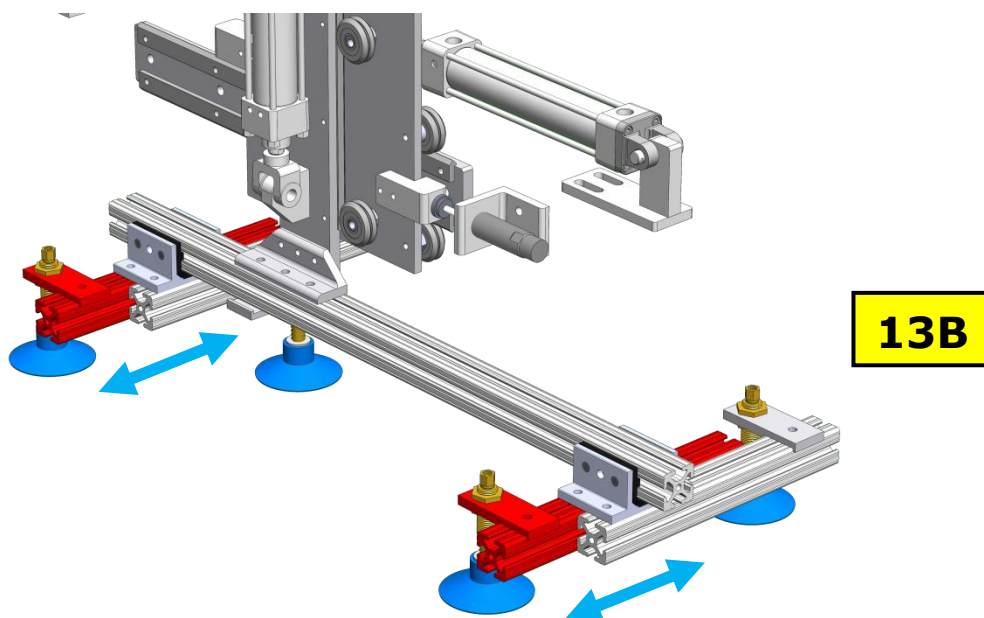
Loosen the nuts and adjust the vacuum cups distance to cover the blank as much as possible. Make sure the suction cups are clear of the score lines of the blank. Tighten the nuts.



13B. TOP SHEET FEED ADJUSTMENT



Loosen the nuts and adjust the vacuum cup arms so the vacuum cups are centered in the blank flaps. Make sure the suction cups are clear of the score lines of the blank. Tighten the nuts.



14. LEFT GUIDE RAIL ADJUSTMENT



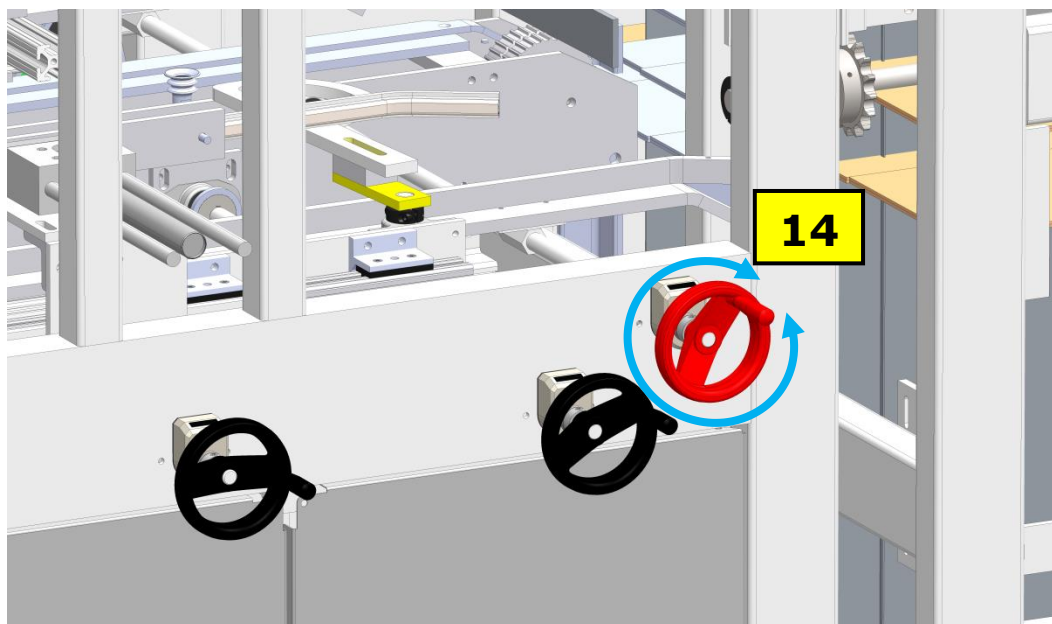
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Turn the hand-wheel and adjust the LEFT GUIDE RAIL to **OPEN CASE DEPTH (B)**. Use the dial indicator for opening or closing the guide according to blank to run.



=

B



15. RIGHT GUIDE RAIL ADJUSTMENT



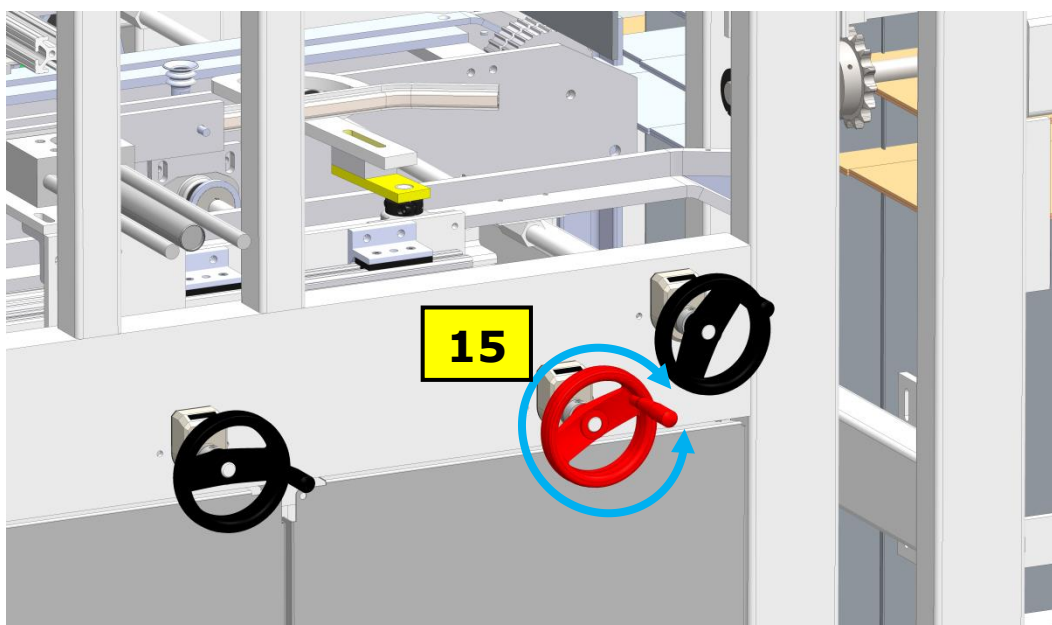
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Turn the hand-wheel and adjust the RIGHT GUIDE RAIL to **MINOR WIDTH (A)**. Use the dial indicator for opening or closing the guide according to blank to run.



=

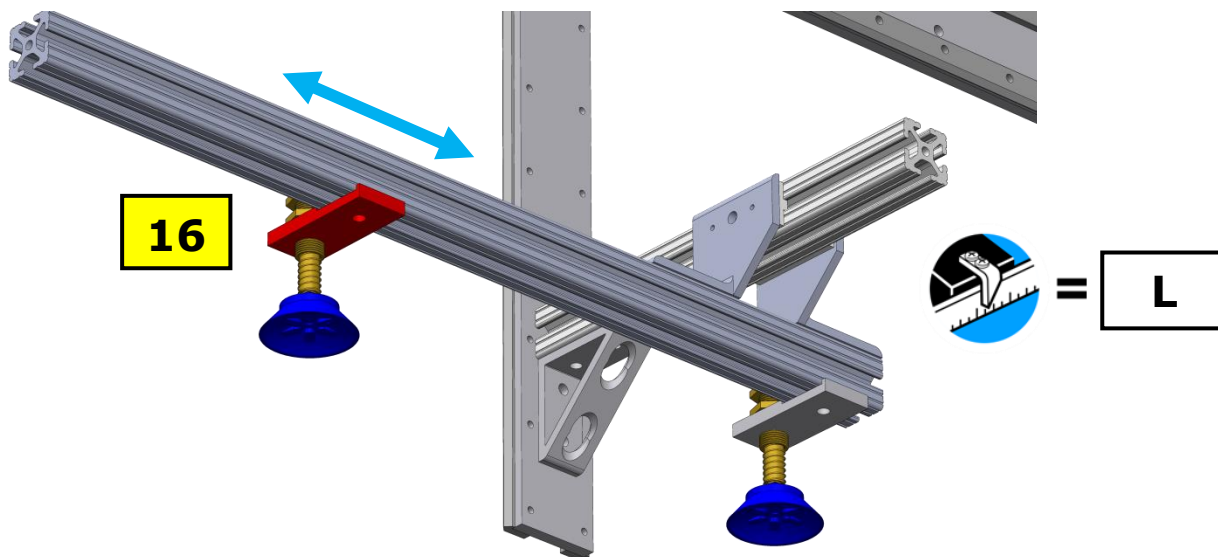
A



16. BLANK PICK UP VACUUM CUPS ADJUSTMENT



Loosen the nuts and adjust the vacuum cup to **CASE LENGTH** on the scale. Make sure the suction cups are clear of the score lines of the blank. Tighten the nuts.



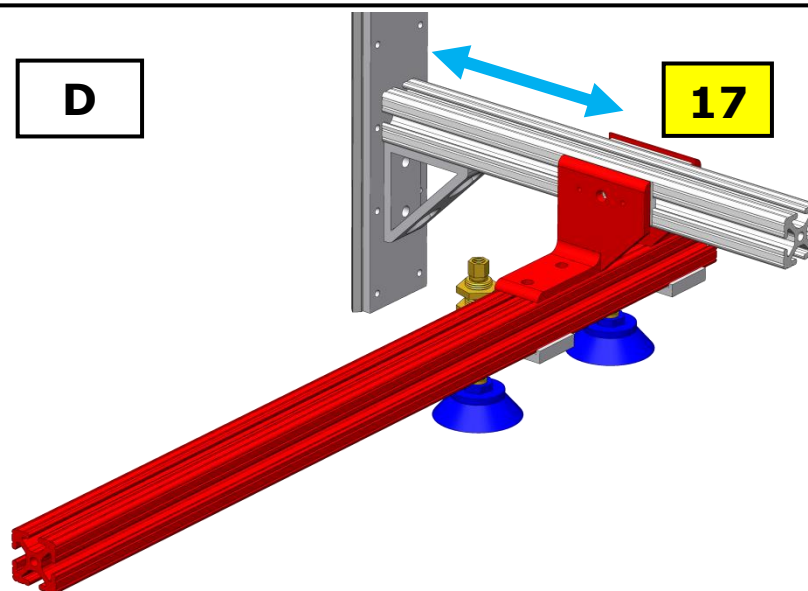
17. BLANK PICK UP ADJUSTMENT



Loosen the nuts and adjust the BLANK PICK UP in the shown direction to **CASE DEPTH (D)**. Make sure the suction cups are clear of the score lines of the blank. Tighten the nuts.



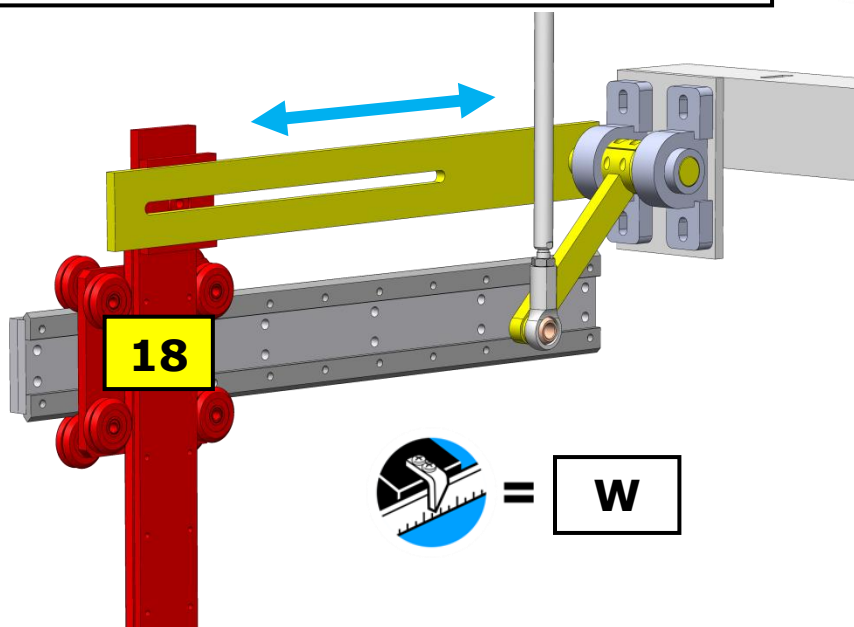
= **D**



18. BLANK PICK UP BAR ADJUSTMENT



Loosen the nut and adjust the BLANK PICK UP BAR in the direction shown to **CASE WIDTH (W)** on the scale. Tighten the nut.



19. MINOR KICKER WIDTH ADJUSTMENT



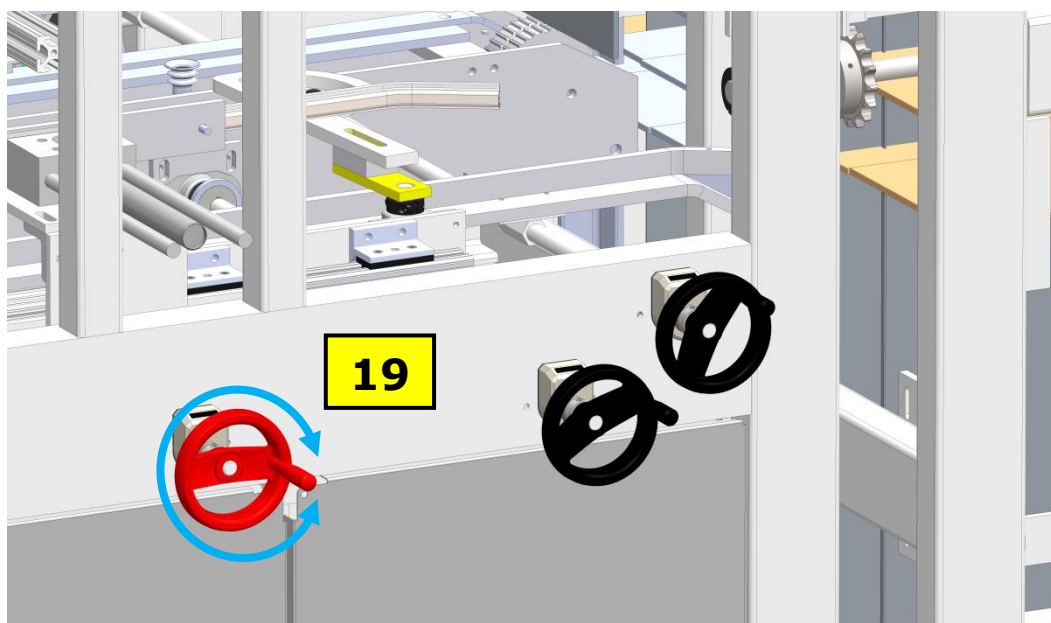
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Turn the hand-wheel and adjust the MINOR KICKER to **CASE DEPTH (D)**. Use the dial indicator for opening or closing the guide according to blank to run.



=

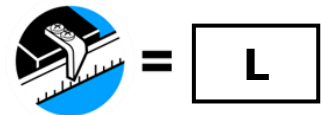
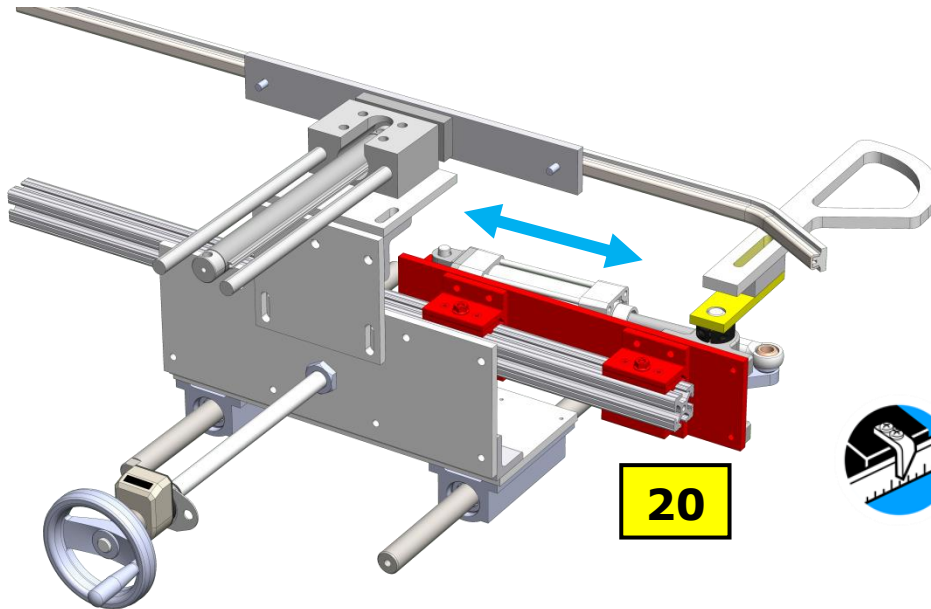
D



20. MINOR KICKER LENGTH ADJUSTMENT



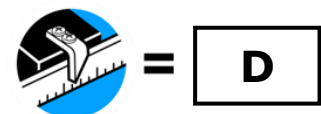
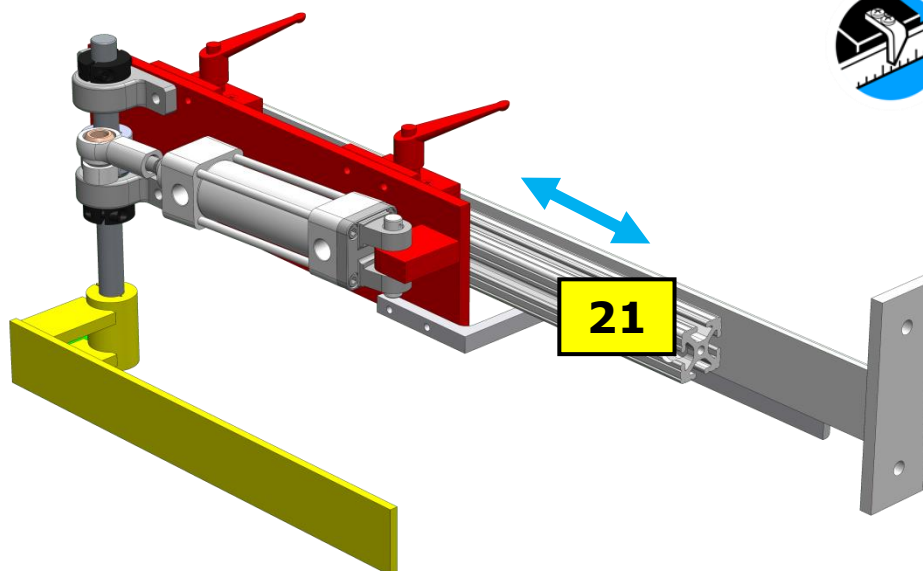
Loosen the nuts and adjust the MINOR KICKER in the direction shown to **CASE LENGTH (L)** on the scale. Tighten the nuts.



21. REAR FLAP FOLDER



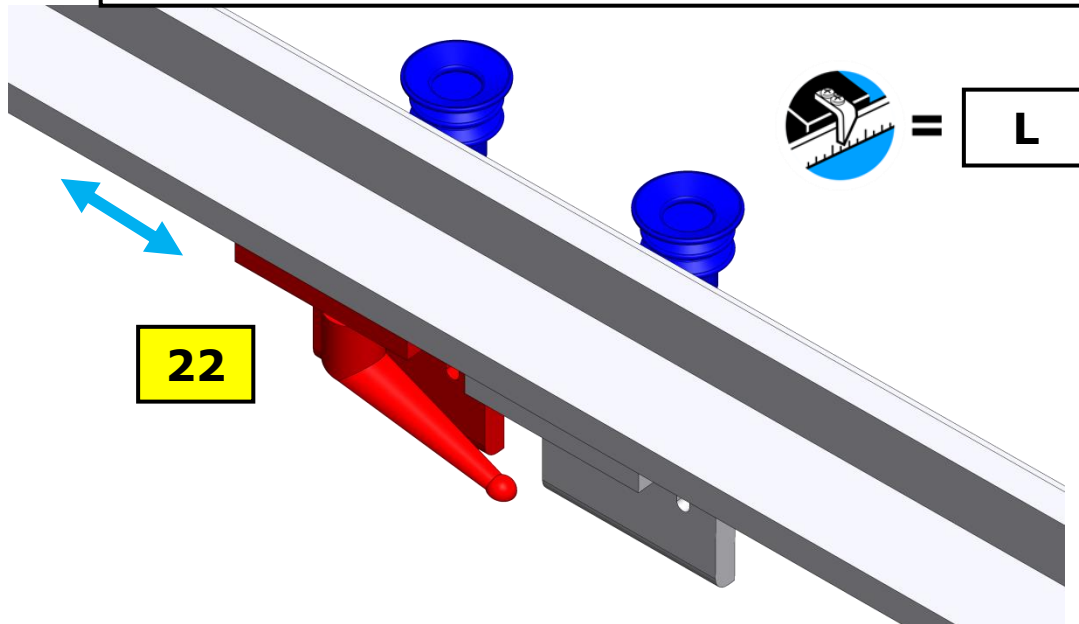
Loosen the locking handles and adjust the REAR FLAP FOLDER in the direction shown to **CASE DEPTH (D)** on the scale. Tighten the locking handles.



22. BOTTOM VACUUM ADJUSTMENT



Loosen the locking handle and adjust the BOTTOM VACUUM in the direction shown to **CASE LENGTH (L)** on the scale. Tighten the locking handle.



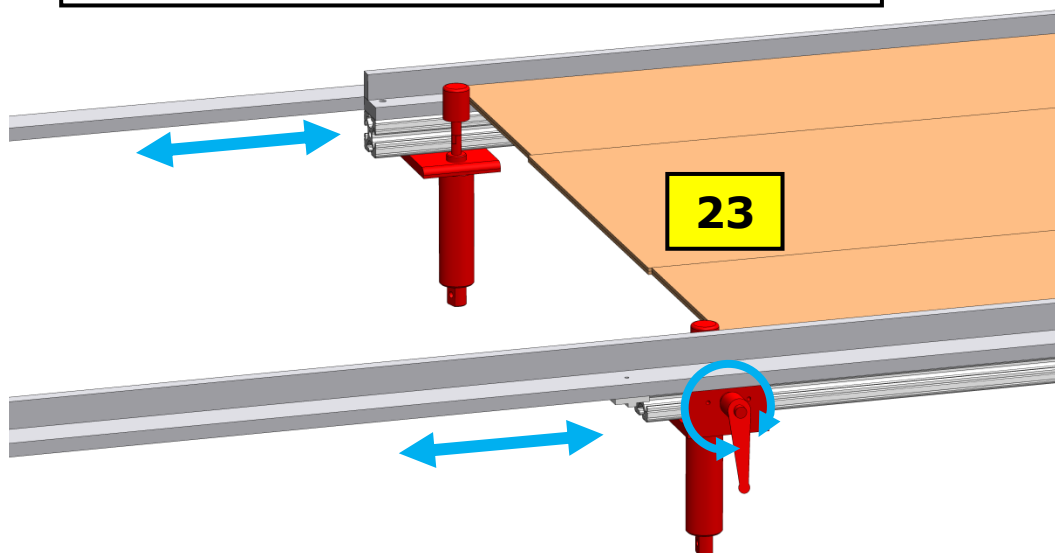
23. BLANK STOP ADJUSTMENT



Loosen the locking handles and adjust the BLANK STOP in the shown direction to show **BLANK LENGTH (BL)** on the scale. Tighten the locking handle.



= **BL**



24. PLOW BAR HORIZONTAL ADJUSTMENT



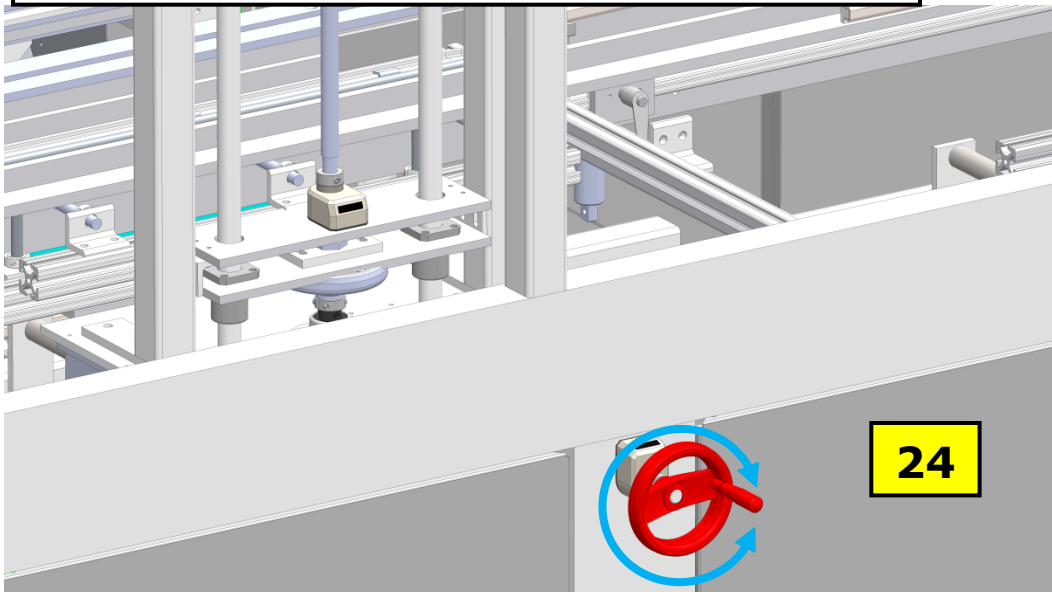
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Turn the hand-wheel and adjust the PLOW BAR ASSEMBLY to **CASE DEPTH (D)**. Use the dial indicator for opening or closing the guide according to blank to run.



=

D



25. PLOW BAR VERTICAL ADJUSTMENT



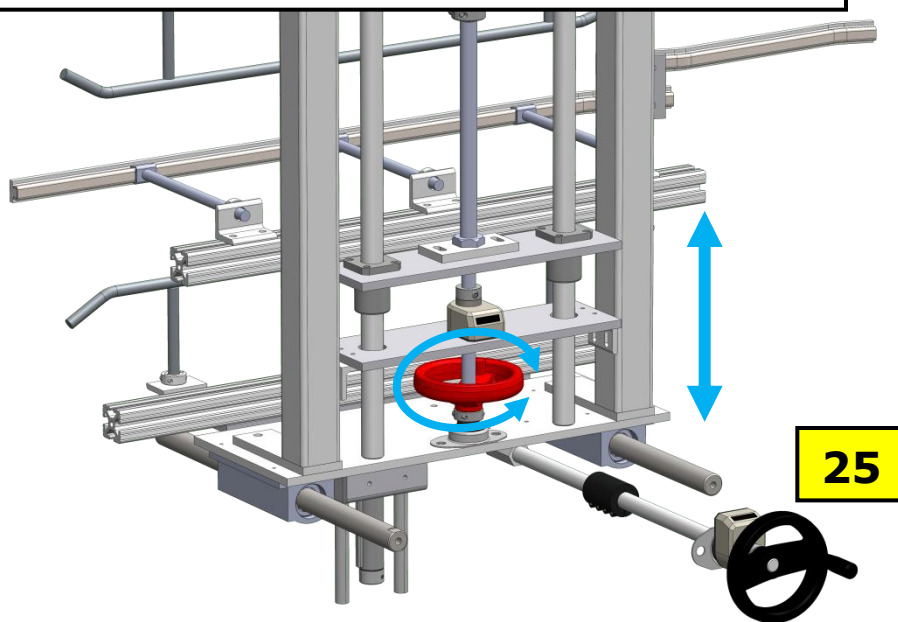
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Turn the hand-wheel and adjust the PLOW BAR ASSEMBLY to **CASE WIDTH (W)**. Use the dial indicator for opening or closing the guide according to blank to run.



=

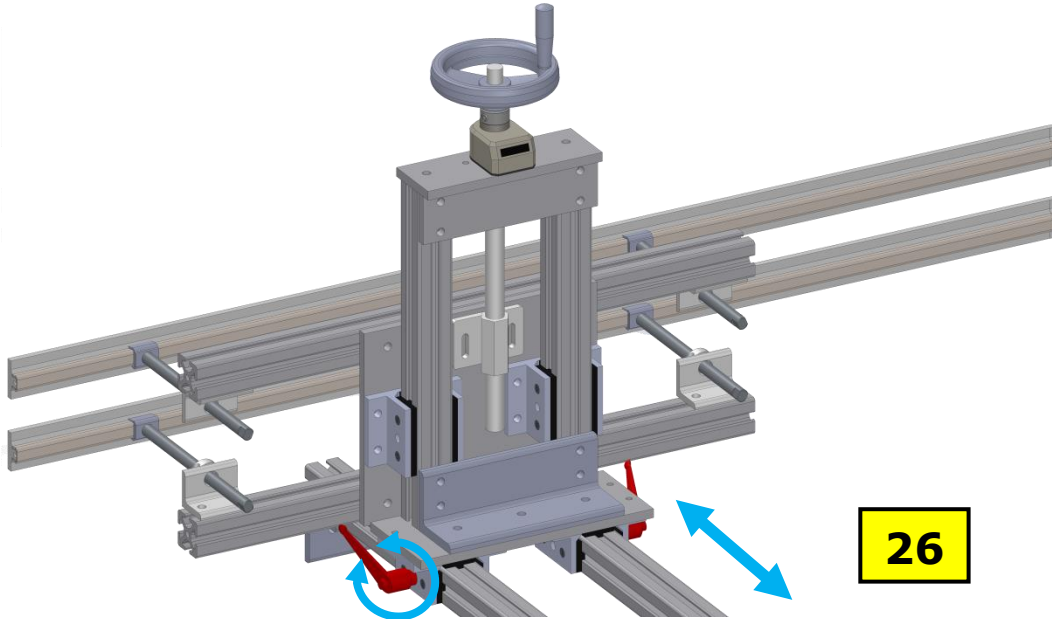
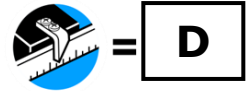
W



26. MAJOR HOLDER HORIZONTAL ADJUSTMENT



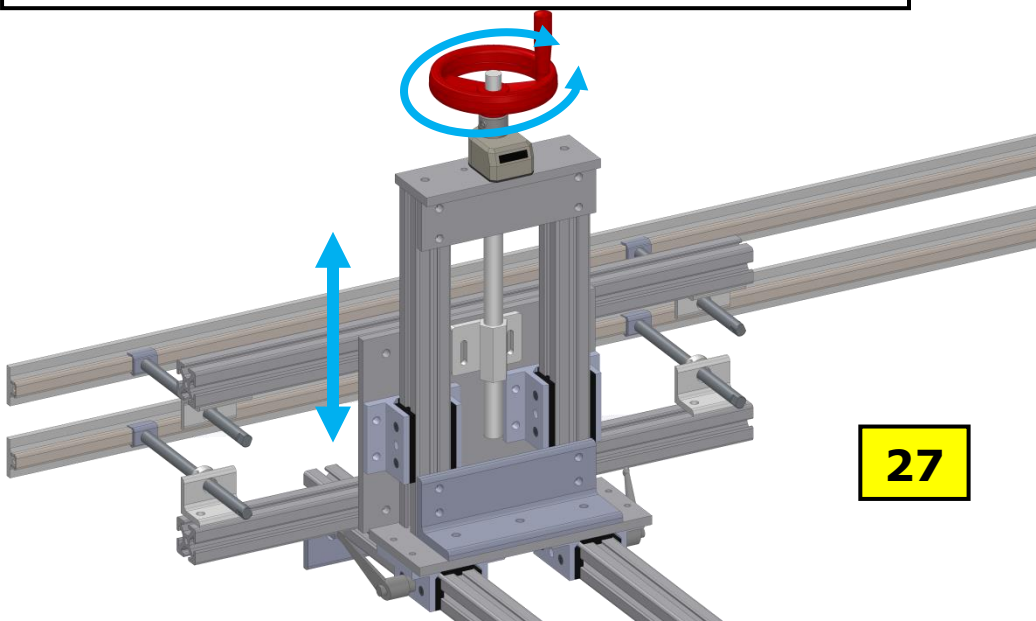
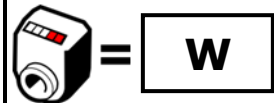
Loosen the locking handles and adjust the MAJOR HOLDER ASSEMBLY to **CASE DEPTH (D)** on the scale. Tighten the locking handles.



27. MAJOR HOLDER VERTICAL ADJUSTMENT



Turn the hand-wheel and adjust the MAJOR HOLDER ASSEMBLY to **CASE WIDTH (W)**. Use the dial indicator for opening or closing the guide according to blank to run.



28. LEFT TAPE HEAD HORIZONTAL ADJUSTMENT



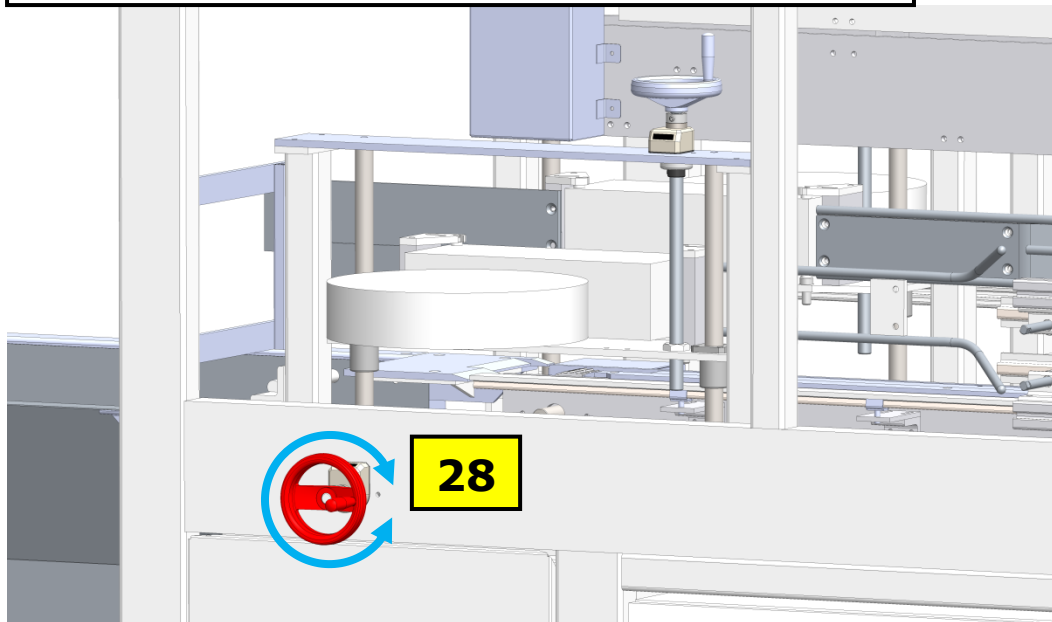
=

Turn the hand-wheel and adjust the TAPE HEAD to **CASE DEPTH (D)**. Use the dial indicator for opening or closing the guide according to blank to run.



=

D



29. LEFT TAPE HEAD VERTICAL ADJUSTMENT



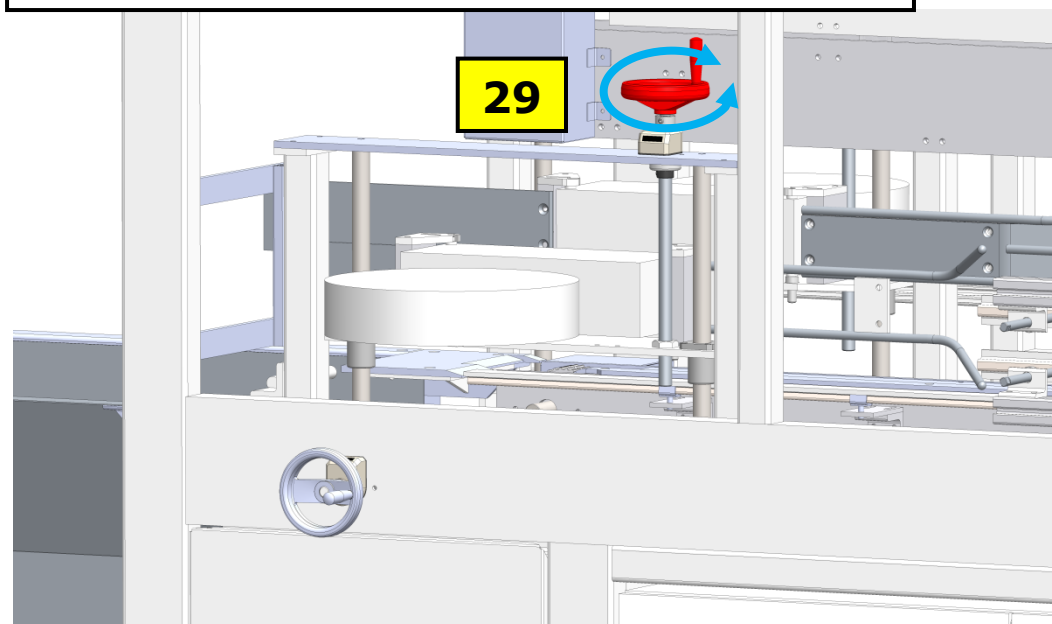
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Turn the hand-wheel and adjust the TAPE HEAD to **CASE WIDTH (W)**. Use the dial indicator for opening or closing the guide according to blank to run.



=

W



30. TOP GUIDE ADJUSTMENT



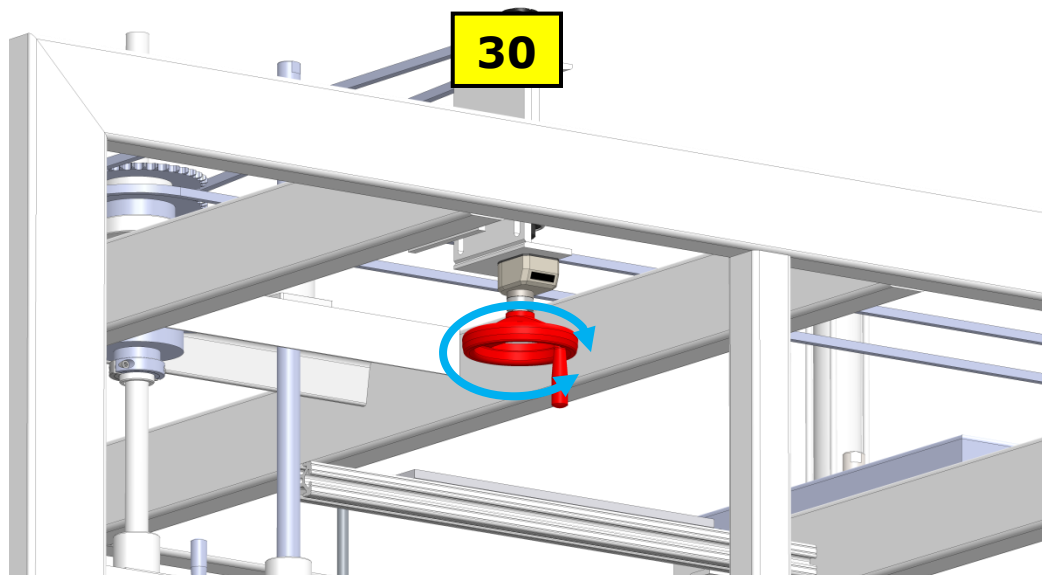
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Turn the hand-wheel and adjust the TOP GUIDE to **CASE WIDTH (W)**. Use the dial indicator



=

W



31. BOX FLIPPER ADJUSTMENT

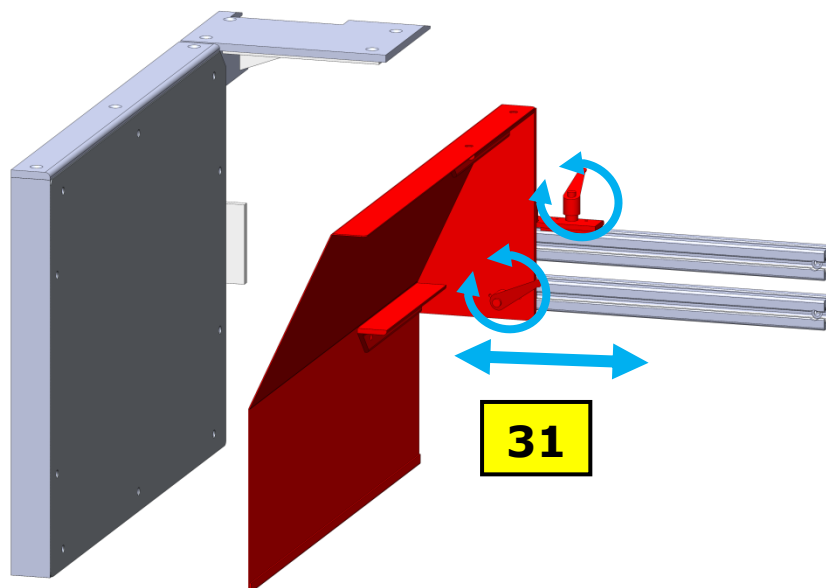


Loosen the locking handles and adjust the BOX FLIPPER GUIDE to **CASE WIDTH (W)** on the scale. Tighten the locking handles.



=

W



32. RIGHT TAPE HEAD VERTICAL ADJUSTMENT



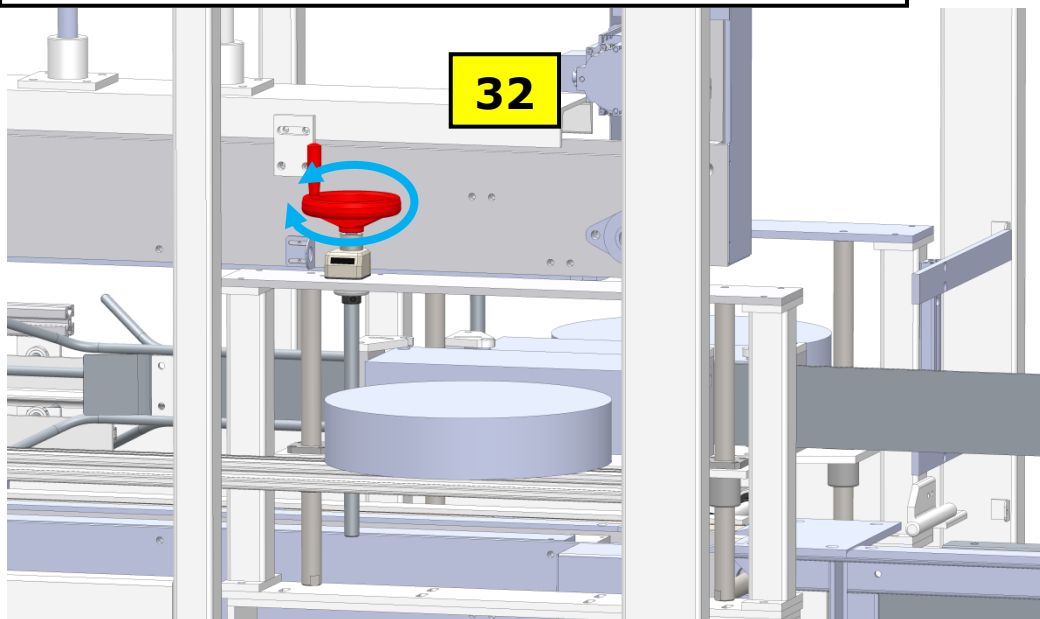
=

Turn the hand-wheel and adjust the TAPE HEAD to **CASE WIDTH (W)**. Use the dial indicator for opening or closing the guide according to blank to run.



=

W



MAINTENANCE

DAILY CHECK LIST

1. Check for loose nuts or bolt. Retighten.
2. Check all air lines for cracks and leaks.
3. Check for loosen or broken electrical cables.
4. Check all doors are closed and secure to the machine. Be sure that all safety interlocks on the doors are functioning properly.
5. Clean all corrugated board pieces from the machine.
6. Remove all excess glue from guide rails and folding bars.

WARNING

Leaving panels off the machine or overriding safety interlocks could cause injury to operator or bystanders near the machine.

BEARINGS

All the bearings supplied with this machine are self-lubricating or are sealed bearings; they require no lubrication.

The ball bushing pillow block on the blank pull down assembly will require a small amount of grease or oil to operate. For most applications, lubricant is recommended to prevent wearing and rusting of the bearing surfaces. When linear speed is high, light oil should be used and the bearing should be prevented from running dry for prolong periods of time. A medium- or heavy- oil, or light grease, has greater adhesion properties that afford longer bearing protection and minimize sealing problems. Thomson LinearLube is recommended for use with these bearings.

PNEUMATIC LINES

Check that the regulator on your machine is set to 80psi before operating your machine.

Check for water build up in filter canister and remove if required

Check oil build up in reclassifier silencer, located on frame for all exhaust, for oil build up.

Check oil level in lubricator and fill if required. Use class 1 turbine oil (with no additive) ISO VG32, or class 2 turbine oil ISO VG32 in the following table.

Example of brands of lubricant manufacturers (as of February 2015)

Lubricant manufacturer	Lubricant brands	Note
Idemitsu Kosan Co., Ltd.	Diana Fresia S32	Class 1 turbine oil, ISO VG32
JX Nippon Oil & Energy Corporation	Turbine Oil 32	Class 1 turbine oil, ISO VG32
COSMO OIL CO., LTD	Cosmo Turbine 32	Class 1 turbine oil, ISO VG32
Kygnus Sekiyu K.K.	Turbine Oil 32	Class 1 turbine oil, ISO VG32
FUJI KOSAN COMPANY, LTD.	Fucoal Turbine 32	Class 1 turbine oil, ISO VG32
SHOWA SHELL SEKIYU K. K.	(Vitoria oil 32) ^{*1)}	
Exxon Mobil Corporation	Mobil DTE Oil Light VG32	Class 2 turbine oil, ISO VG32 ^{*2)}

*1) The () indicates the product equivalent to class 1 turbine oil ISO VG32.

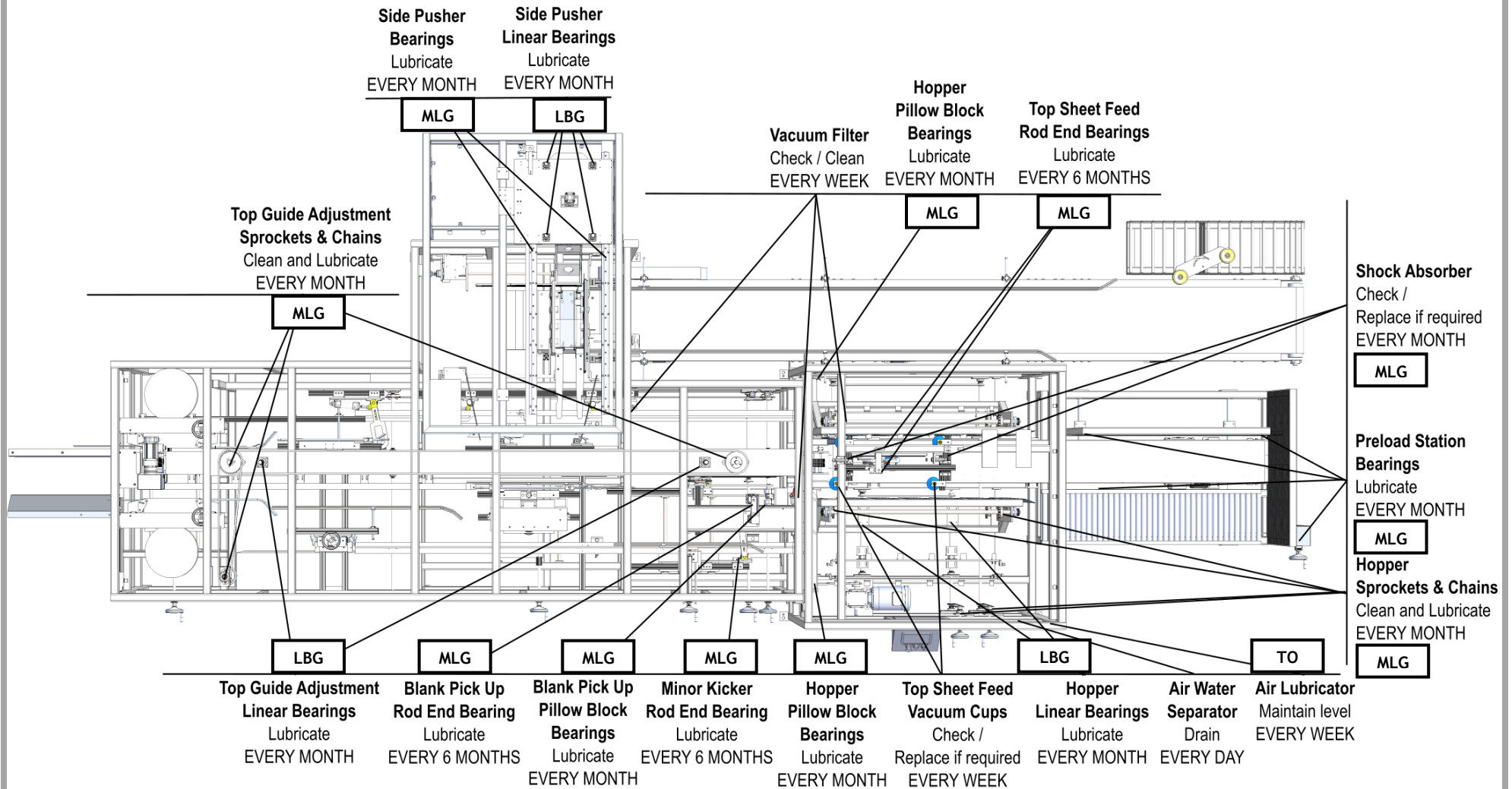
*2) This is a class 2 turbine oil (additive) allowed for use. Please contact SMC regarding other class 2 turbine oil.

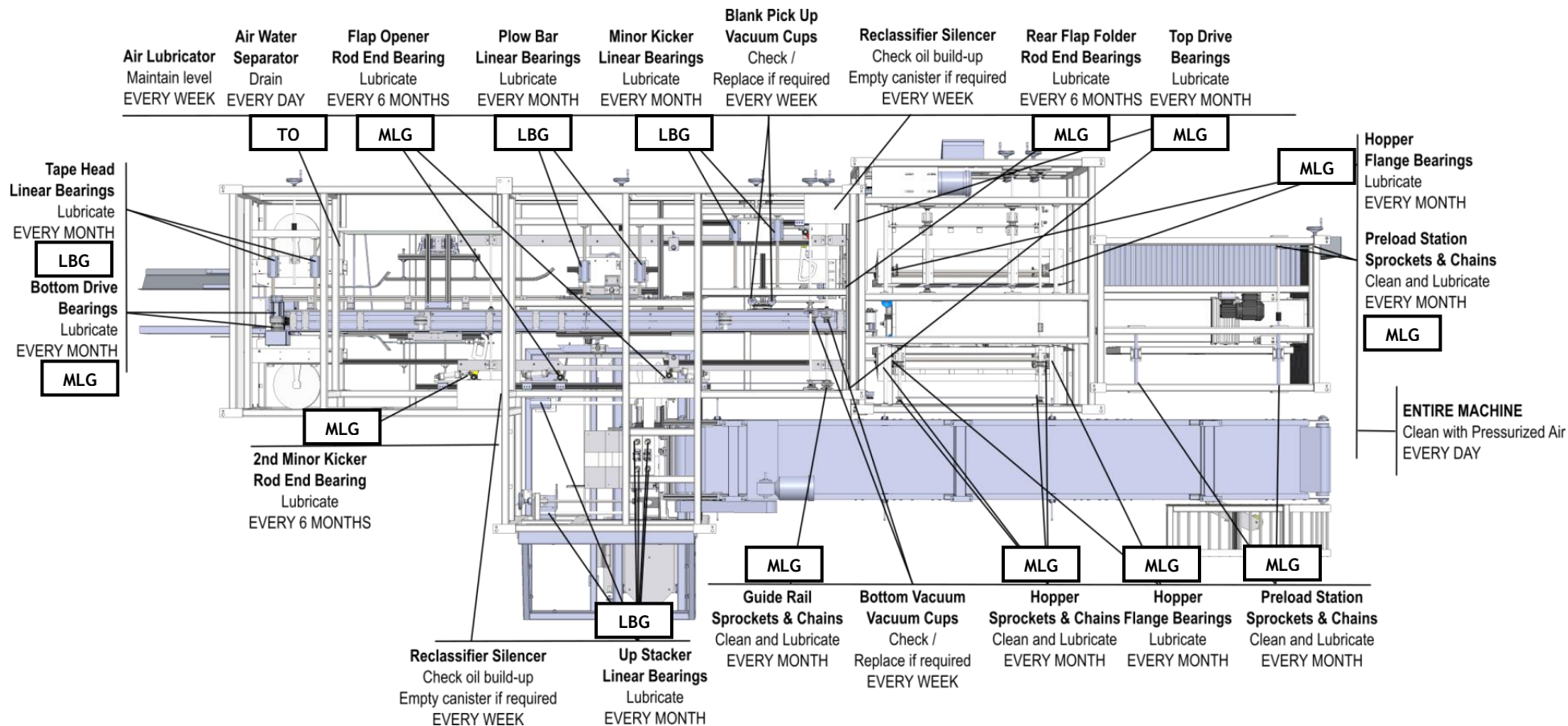
Source: <http://www.smcworld.com/pl/en/oil.jsp>

**The name of the lubricant manufacturer and the lubricant brand may change.
Please contact each of the companies for details.**

Once lubricant is utilized within the system, since the original lubricant applied within the product during manufacturing will be washed away, please continue to supply lubrication to the system. Without continued lubrication, malfunctions could occur.

MACHINE MAINTENANCE CHART





TROUBLESHOOTING

TROUBLESHOOTING

PROBLEM	PROBABLE SOLUTION
General	<ol style="list-style-type: none">1. Be sure that you have made the correct adjustment to the machine and that the case blank moves through the machine properly.2. Make sure that all handles are tight.3. Listen for unusual sound from the machine and determine where the problem is coming from.4. Use the assembly drawing and electrical schematic to determine and pinpoint the parts that you are having problems with.
Hopper Conveyor will not run	<ol style="list-style-type: none">1. Be sure you have power to machine.2. Check the if the timing belt reducer is connected properly.3. Check fuses in line L1,L2 and L3.
Any air cylinder does not operate	<ol style="list-style-type: none">1. Check that you have sufficient air to machine.2. Check air pressure on regulator is set to 80psi.3. Check for loose, cracked, or warn air lines.4. Check that valve is operating properly, try activating valve with manual override set screw to operate valve. If valve does not operate replace.
Blank does not pull from hopper properly	<ol style="list-style-type: none">1. Check for broken or warn out vacuum cups.2. Check that transfer cylinder for vacuum cups moves required distance. Check for interference in carriage movement.3. Check that vacuum valve is operating properly.4. Check that the vacuum pump is operating properly. This may require to clean filter or possible loosen and remove debris inside pump.5. Check that the stack of blanks is at the proper pickup level, check the photocell that controls that level

Blank fails to erected	<ol style="list-style-type: none"> 1. Check for broken or worn out vacuum cups. 2. Check that erecting cylinders for vacuum cups moves required distance. Check for interference in carriage movement. 3. Check that vacuum valves are operating properly for top and bottom vacuum cups. 4. Check that the vacuum pumps are operating properly. This may require to clean filters or possibly loosen and remove debris inside pumps, top and bottom.
Erected box is not being transferred between stations	<ol style="list-style-type: none"> 1. Check if both driving belts, top and bottom, are working 2. Check if the pusher logs are correctly attached to the belt 3. Check belts for breaks or cracks.
Product is not properly inserted	<ol style="list-style-type: none"> 1. Check if vacuum is working for top and bottom flap openers 2. Check minor openers mechanisms 3. Check if retractable guide is getting out of the way when inserting
Box is not being sealed	<ol style="list-style-type: none"> 1. Check if the minor flaps are folded inside the major flaps 2. Check if the tape head ran out of adhesive tape 3. Check the centering of the tape to the box 4. Refer to the tape head manual for troubleshooting
Machine stops at the middle of the cycle	<ol style="list-style-type: none"> 1. Check if the machine is on STEP mode: change it to RUN mode. 2. Check if FEED is OFF: set FEED to ON. 3. Check the in-feed conveyor has enough products.

ERROR MESSAGES



















ERROR MESSAGE	PROBLEM	PROBABLE SOLUTION
SAFETY SYSTEM ERROR	THE SAFETY CONTROLLER (SC1) HAS FAILED.	<ol style="list-style-type: none"> 1. CHECK CONTROLLER STATUS. 2. CHECK THE 24V VOLTAGES FROM THE SOURCE DC. 3. CHECK THAT THE CONNECTION FROM THE CONTROLLER TO THE PLC DIGITAL INPUT MODULE IS CORRECT.
LOW AIR PRESSURE	THE AIR PRESSURE IS BELOW THE VALUE OF ADJUSTMENT IN THE PRESSURE SWITCH	<ol style="list-style-type: none"> 1. CHECK THE WORK PRESSURE. 2. CHECK VALUES ADJUSTED IN THE PRESSURE SWITCH. 3. CHECK THE 24V VOLTAGES FROM THE SOURCE. 4. CHECK THAT THE CONNECTION FROM THE PRESSURE SWITCH TO THE PLC DIGITAL INPUT MODULE IS CORRECT.
EMERGENCY STOP PB--PRESSED	EMERGENCY STOP IS PRESSED	<ol style="list-style-type: none"> 1. PULL OUT THE BUTTON AND PRESS THE RESET BUTTON TO ALLOW THE AIR INTO THE MACHINE.
DOOR XS-- OPEN	A DOOR HAS BEEN OPENED	<ol style="list-style-type: none"> 1. CHECK IF ANY DOOR IS OPEN. 2. CHECK THE 24V VOLTAGES FROM THE SOURCE. 3. CHECK THAT THE CONNECTION FROM THE SAFETY DOOR TO THE SAFETY CONTROLLER IS CORRECT.
TEST MODE ENABLED	THE MACHINE IS IN A WORKING MODE, IN WHICH ALL PHOTOCCEL INHIBITS, BUT CONTINUES THE SEQUENCE, SOME FAILURES DO NOT OPERATE.	<ol style="list-style-type: none"> 1. THIS MODE ONLY TO USE TO CHECK FUNCTIONAL OF THE MACHINE. 2. TO CHANGE THIS MODE, ACCESS PARAMETER 139 AND SET IT TO 0 VALUES.
BOTTOM SERVO DRIVE FAULT	THE TORQUE LIMIT ADJUSTED IN THE HMI HAS BEEN OVERCOME, BECAUSE THE MAIN DRIVER IS STUCK	<ol style="list-style-type: none"> 1. CHECK IF ANY BOX IS STUCK IN THE MACHINE. 2. CHECK IF BOTH CLEATS UP AND DOWN ON THE MAIN DRIVER MOVE FREELY, USE THE JOG FUNCTION TO CHECK THAT. 3. CHECK VALUES ADJUSTED IN THE HMI (PARAMETER # 15).
TOP SERVO DRIVE FAULT		
SIDE PUSHER SERVO DRIVE FAULT	THE TORQUE LIMIT ADJUSTED IN THE HMI HAS BEEN OVERCOME, BECAUSE THE SIDE PUSHER IS STUCK	<ol style="list-style-type: none"> 1. CHECK IF ANY BOX IS STUCK ON THE UPSTACKING STATION. 2. CHECK IF THE FLAP IS PROPERLY OPENED. 3. CHECK VALUES ADJUSTED IN THE HMI (PARAMETER # 22). 4. CHECK THE BOX IS CORRECTLY IN THE LOADING STATION.
UP STACKER FIRST STAGE GOING UP JAM	THE UP STACKER FIRST STAGE IS STUCK WHEN MOVING UP	<ol style="list-style-type: none"> 1. CHECK IF ANY BOX IS STUCK ON THE FIRST STAGE. 2. CHECK IF UP PROXIMITY (PROX5) IS WORKING PROPERLY; CHANGE THE MACHINE TO THE MAINTENANCE MODE TO CHECK THIS.

		3. CHECK THAT THE TIME SET IN THE HMI FOR THIS FAILURE IS THE CORRECT (PARAMETER # 31). 4. CHECK WORK PRESSURE.
UP STACKER FIRST STAGE GOING DOWN JAM	THE UP STACKER FIRST STAGE IS STUCK WHEN MOVING DOWN	1. CHECK IF ANY BOX IS STUCK ON THE FIRST STAGE. 2. CHECK IF DOWN PROXIMITY (PROX4) IS WORKING PROPERLY; CHANGE THE MACHINE TO THE MAINTENANCE MODE TO CHECK THIS. 3. CHECK THAT THE TIME SET IN THE HMI FOR THIS FAILURE IS THE CORRECT (PARAMETER # 32). 4. CHECK THE WORK PRESSURE.
UP STACKER SECOND STAGE GOING UP JAM	THE UP STACKER SECOND STAGE IS STUCK WHEN MOVING UP	1. CHECK IF ANY BOX IS STUCK ON THE SECOND STAGE. 2. CHECK IF UP PROXIMITY (PROX7) IS WORKING PROPERLY; CHANGE THE MACHINE TO THE MAINTENANCE MODE TO CHECK THIS. 3. CHECK THAT THE TIME SET IN THE HMI FOR THIS FAILURE IS THE CORRECT (PARAMETER # 35). 4. CHECK THE WORK PRESSURE.
UP STACKER SECOND STAGE GOING DOWN JAM	THE DOWN STACKER SECOND STAGE IS STUCK WHEN MOVING DOWN	1. CHECK IF ANY BOX IS STUCK ON THE SECOND STAGE. 2. CHECK IF DOWN PROXIMITY (PROX6) IS WORKING PROPERLY; CHANGE THE MACHINE TO THE MAINTENANCE MODE TO CHECK THIS. 3. CHECK THAT THE TIME SET IN THE HMI FOR THIS FAILURE IS THE CORRECT (PARAMETER # 36). 4. CHECK THE WORK PRESSURE.
SIDE PUSHER VERTICAL MOVING DOWN JAM	THE VERTICAL SIDE PUSHER IS STUCK WHEN MOVING DOWN	1. CHECK IF DOWN PROXIMITY (PROX8) IS WORKING PROPERLY; CHANGE THE MACHINE TO THE MAINTENANCE MODE TO CHECK THIS. 2. CHECK THAT THE TIME SET IN THE HMI FOR THIS FAILURE IS THE CORRECT (PARAMETER # 40). 3. CHECK THE WORK PRESSURE.
SIDE PUSHER VERTICAL MOVING UP JAM	THE VERTICAL SIDE PUSHER IS STUCK WHEN MOVING UP	1. CHECK IF UP PROXIMITY (PROX9) IS WORKING PROPERLY; CHANGE THE MACHINE TO THE MAINTENANCE MODE TO CHECK THIS. 2. CHECK THAT THE TIME SET IN THE HMI FOR THIS FAILURE IS THE CORRECT (PARAMETER # 39). 3. CHECK THE WORK PRESSURE.
TOP SHEET FEED VERTICAL MOVING DOWN JAM	THE VERTICAL TOP SHEET FEED IS STUCK WHEN MOVING DOWN	1. CHECK IF THE HOPPER HAS THE RIGHT LEVEL. 2. CHECK IF DOWN PROXIMITY (PROX13) IS WORKING PROPERLY; CHANGE THE MACHINE TO THE MAINTENANCE MODE TO CHECK THIS. 3. CHECK THAT THE TIME SET IN THE HMI FOR THIS FAILURE IS THE CORRECT (PARAMETER # 45). 4. CHECK THE WORK PRESSURE.

TOP SHEET FEED VERTICAL MOVING UP JAM	THE VERTICAL TOP SHEET FEED IS STUCK WHEN MOVING UP	<ol style="list-style-type: none"> 1. CHECK IF UP PROXIMITY (PROX12) IS WORKING PROPERLY; CHANGE THE MACHINE TO THE MAINTENANCE MODE TO CHECK THIS. 2. CHECK THAT THE TIME SET IN THE HMI FOR THIS FAILURE IS THE CORRECT (PARAMETER # 46). 3. CHECK THE WORK PRESSURE.
TOP SHEET FEED HORIZONTAL MOVING FORWARD JAM	THE HORIZONTAL TOP SHEET FEED IS STUCK WHEN MOVING FORWARD	<ol style="list-style-type: none"> 1. CHECK THE POSITION OF THE ROLLER WITH REGARD THE BLANK AT THE ENTRANCE. 2. CHECK IF POSITION OF VACUUM CUP IS THE RIGHT. 3. CHECK IF FORWARD PROXIMITY (PROX14) IS WORKING PROPERLY; CHANGE THE MACHINE TO THE MAINTENANCE MODE TO CHECK THIS. 4. CHECK THAT THE TIME SET IN THE HMI FOR THIS FAILURE IS THE CORRECT (PARAMETER # 49). 5. CHECK THE WORK PRESSURE.
TOP SHEET FEED HORIZONTAL MOVING HOME JAM	THE HORIZONTAL TOP SHEET FEED IS STUCK WHEN MOVING HOME.	<ol style="list-style-type: none"> 1. CHECK IF HOME PROXIMITY (PROX15) IS WORKING PROPERLY; CHANGE THE MACHINE TO THE MAINTENANCE MODE TO CHECK THIS. 2. CHECK THAT THE TIME SET IN THE HMI FOR THIS FAILURE IS THE CORRECT (PARAMETER # 50). 3. CHECK THE WORK PRESSURE.
HOPPER OVERTRAVEL	THE HOPPER'S TRAVEL UP HAS EXCEEDED THE PERMISSIBLE LEVEL ADJUSTED WITH THE SWICH LIMIT.	<ol style="list-style-type: none"> 1. CHECK IF THE HOPPER HAS THE RIGHT LEVEL. 2. CHANGE THE MACHINE IN MAINTENANCE MODE AND CHECK THE FUNCTIONALITY OF THE SWICH LIMIT.
ERECTING PICKUP MOVING DOWN JAM	THE ERECTING PICKUP IS STUCK WHEN MOVING DOWN.	<ol style="list-style-type: none"> 1. CHECK IF DOWN PROXIMITY IS WORKING PROPERLY; CHANGE THE MACHINE TO THE MAINTENANCE MODE TO CHECK THIS. 2. CHECK THAT THE TIME SET IN THE HMI FOR THIS FAILURE IS THE CORRECT (PARAMETER # 59). 3. CHECK THE WORK PRESSURE
ERECTING PICKUP MOVING HOME JAM	THE ERECTING PICKUP IS STUCK WHEN MOVING UP.	<ol style="list-style-type: none"> 1. CHECK IF UP PROXIMITY IS WORKING PROPERLY; CHANGE THE MACHINE TO THE MAINTENANCE MODE TO CHECK THIS. 2. CHECK THAT THE TIME SET IN THE HMI FOR THIS FAILURE IS THE CORRECT (PARAMETER # 60). 3. CHECK WORK PRESSURE
FAILED TO PICK A BLANK	THE TOP SHEET FEED VERTICAL MOVED SEVERAL TIMES (PARAMETER # 105) DOWN AND FAILED A PICK BLANK	<ol style="list-style-type: none"> 1. CHECK THE SETTING TIME FOR THE VACUUM CUP (ON AND OFF DELAY) PARAMETER # 41, 42. 2. CHECK THE DISTANCE BETWEEN THE VACUUM CUPS AND THE FIRST BOX THAT DETERMINES THE HOPPER LEVEL. 3. CHECK THAT PE8 (BLANK LOADED AT TOP SHEET FEEDER) WORKS CORRECTLY.
BLANK FAILED TO	THE BLANK FAILED TO REACH	<ol style="list-style-type: none"> 1. CHECK THE POSITION OF THE BLANK AT THE

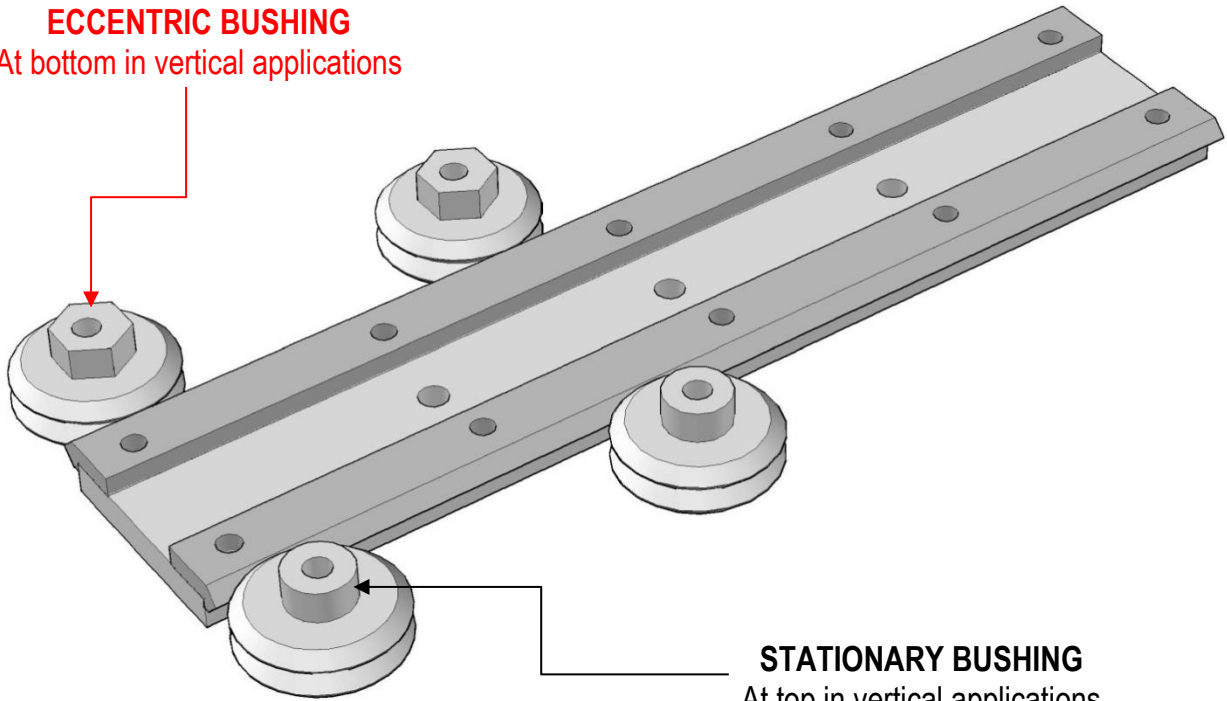
REACH INDEX	THE ERECTING STATION	<p>ENTRANCE OF THE ROLLERS.</p> <ol style="list-style-type: none"> CHECK THE SETTING TIME FOR THE VACUUM CUP (OFF DELAY) PARAMETER # 42. CHECK THAT PE9 (BLANK READY TO INDEX) WORKS CORRECTLY.
FAILED TO ERECT A BLANK	THE BLANK PICK UP MOVING UP FAILED TO ERECT THE CASE CORRECTLY	<ol style="list-style-type: none"> CHECK THE SETTING TIME FOR THE VACUUM CUP (ON AND OFF DELAY) PARAMETER # 55, 56. CHECK THAT PE10 (BLANK ERECTED) WORKS CORRECTLY.
BOX FAILED TO REACH LOADING STATION	THE ERECTED BOX FAILED TO REACH THE LOADING STATION	<ol style="list-style-type: none"> CHECK THE FUNCTIONALITY OF THE MINOR HOLDER AND RETRACTABLE PLOW BAR. CHECK THAT PE11 (BOX READY TO LOADING STATION) WORKS CORRECTLY.
FAILED TO INSERT PRODUCT	PRODUCT WAS NOT CORRECTLY INSERTED INTO THE BOX	<ol style="list-style-type: none"> CHECK IF THE BOX IS CORRECTLY POSITIONED IN THE LOADING STATION, FOR THIS VERIFY THE PARAMETER 16 (MAIN DRIVE MOTION DISTANCE) CHECK THAT THE RECIPE SELECTED IS CORRECT FOR THE BOX THAT IS RUNNING. CHECK THE TRAVEL OF THE SIDE PUSHER HORIZONTAL, PARAMETER 106 (SIDE PUSHER MOTION DISTANCE).
BOX FAILED TO REACH PLOW BAR	THE BOX MOVING TO THE PLOW BARS FAILED TO REACH THEM.	<ol style="list-style-type: none"> CHECK THE FUNCTIONALITY OF THE RETRACTABLE PLOW BAR AND THE SECOND MINOR KICKER. CHECK THAT THE RECIPE SELECTED IS CORRECT FOR THE BOX THAT IS RUNNING. CHECK THAT PE12 (BOX AT PLOW BAR) WORKS CORRECTLY.
BOX FAILED TO REACH TAPE HEAD	THE BOX MOVING TO TAPE HEAD AND FAILED TO REACH THEM.	<ol style="list-style-type: none"> CHECK THE FUNCTIONALITY OF THE RETRACTABLE PLOW BAR AND THE SECOND MINOR KICKER. CHECK MECHANICAL ADJUSTMENTS OF THE TAPE HEAD. CHECK THAT PE13 (BOX AT TAPE HEAD) WORKS CORRECTLY.
CLEAN MACHINE BEFORE START	THE MACHINE NEEDS TO PERFORM HOME, REMOVE THE ENTIRE PRODUCT INSIDE THE MACHINE.	

LIGHT STACK COLOR CODES (IF INSTALLED)

COLORS	DESCRIPTION
 Off  Off  Flashing	Machine starting -or- Machine in <u>Auto Idler</u> mode.
 Off  Off  On	Machine running OK
 Flashing  Flashing  Flashing	Batch done (You must press the RESET COUNT button on the BATCH screen to start the machine again)
 Off  On  On	Machine running in low hopper
 Flashing  Flashing  Off	Reload Hopper. Press RESET button on screen to acknowledge the alarm
 Flashing  Off  Off	Machine Fault. Read the machine status on the Touch Screen for more information

V-WHEEL ADJUSTMENT

ECCENTRIC BUSHING
At bottom in vertical applications



STATIONARY BUSHING
At top in vertical applications

Fit Up Adjustment

The stationary bushings determine the alignment of the system. They should carry the major load whenever possible. Wheels should be configured such that the load is predominantly radial whenever possible.

Normal adjustment is obtained by rotation the eccentric bushings until all free play is removed from the carriage assembly. When the eccentrics are adjusted and the carriage plate is held firmly in place, one should be able to rotate, by hand, any of the four guide wheels in the system against its mating track. If rotation is not possible, preload on the wheels should be reduced accordingly. Over tightening of the eccentric adjustment could result in premature bearing failure. Such a condition can exert a force greater than the load rating of the wheel.

RODLESS CYLINDER ADJUSTMENT

CUSHION NEEDLE ADJUSTMENT

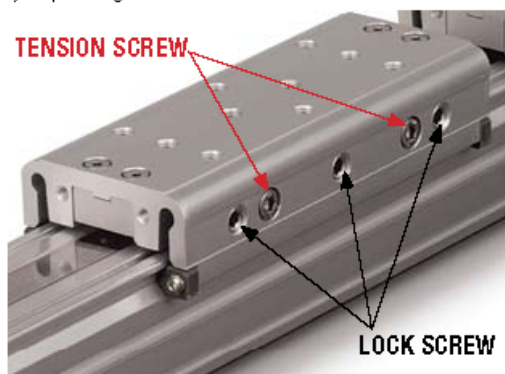


Adjust the cushion needle in the cylinder heads carefully to obtain proper deceleration for your particular application. Proper cushion needle adjustment is achieved when the carrier reaches the end of travel at a velocity approaching

zero. If the carrier reaches the end of stroke at velocity, then the cushion needs to be increased by turning the cushion needle screw clockwise. If the carrier stalls or bounces (quickly oscillating directions) before it reaches the end of stroke, then the cushion needs to be decreased by turning the cushion needle screw counterclockwise. Improper cushion adjustment may cause premature failure of the actuator. Call Tolomatic with any questions.

S SOLID BEARING CARRIER ADJUSTMENT

The S solid bearing carrier will provide for maximum life when properly adjusted. The carrier design contains both tension and lock screws. The tension screws control the amount of pressure placed on the carrier bearings. The lock screws lock the tension screws in place and provide fine adjustment of the carrier bearings. The number of tension and lock screws will vary depending on the bore size of the actuator.



1. Fully loosen all tension and lock screws. They do not need to be removed, just fully loosened.
2. Tighten tension screws on both sides of carrier roughly 1/8 to 1/4 turn clockwise past where the screw starts to feel snug. The carrier should be very difficult or impossible to move by hand.
3. Next, adjust the lock screws on both sides of the carrier roughly 1/8 to 1/4 turn clockwise past where the screw starts to engage.
4. Ideal carrier tension is achieved when the carrier feels snug in relation to the tube. No rocking motion should be present. The carrier should be loose enough to be moved by hand over the entire length of the actuator. If after this process the carrier has become too loose, equally adjust all of the lock screws with a slight 1/32 turn counter-clockwise. A carrier that is adjusted too tight will increase the breakaway pressure required for motion; in extreme cases no motion will occur when air is applied.

During the service life, this process may need to be repeated. Keeping the carrier properly adjusted will prolong the life of the S solid bearing system.

MXP16

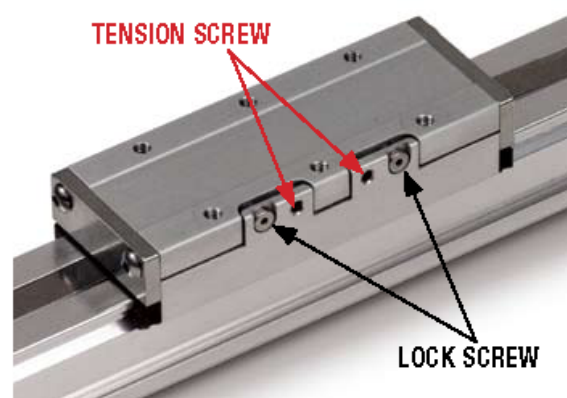


NOTE: MXP16S requires a different carrier adjustment procedure, see below.

Tools Required:

Inch Models: 1/16 inch and 2.5mm Hex Wrench (Key)
Metric Models: 2 and 2.5 mm Hex Wrench (Key)

1. Loosen endplate screws on both ends of the carrier.
2. Fully loosen all tension and lock screws. They do not need to be removed, just fully loosened.



3. Tighten tension screws by turning them clockwise until the carrier is just tight enough so that no side-to-side rocking motion is present and it can easily be moved by hand over the entire stroke length with no hesitation. Very little torque on the screws is required to obtain this condition.

Note: The Tension Screws are the small set screw style fastener. The Lock Screws are the larger, low head, hex drive screws.

4. Tighten lock screws by turning them clockwise until tight. The carrier should feel snug in relation to the tube, with no side-to-side rocking motion present. If the carrier becomes too loose, loosen the lock screws, tighten the tension screws and then retighten the lock screws.

6. Once ideal carrier tension is achieved, fully tighten end plate screws on both ends of the carrier.

Allen wrench sizes for carrier adjustment, Solid bearing actuators

	Tension Screw		Lock Screw	
	in	mm	in	mm
16	1/16	2	1/16	2
25	5/32	4	1/8	3
32	5/32	4	3/32	2
40	5/32	4	1/8	3
50	3/16	4	3/32	2.5
63	1/4	5	3/16	5

MACHINE SPECIFICATIONS

Machine type	BOXXER ALL IN ONE CASE PACKER SYSTEM SIDE LOAD AND TAPE
Model	AELS-002
Serial Number	16399
VOLTAGE	240 VAC / 3 PHASE / 60 Hz
AMPS	40 A
CONTROL VOLTAGE	24 VDC
AIR REQUIREMENT	36 SCFM @ 80psi
AIR CONNECTION TO MACHINE	$\frac{3}{4}$ " Pipe @ 100psi minimum

SPARE PARTS AND SERVICE

For general information and parts contact:

EAGLE PACKAGING MACHINERY, LLC

4760 NW 128th Street, Miami, FL 33014

Phone: 305-622-4070 Fax: 305-688-7772

parts@eaglepm.com

It is necessary that before you contact EAGLE for parts or service, that you know the **Machine Model and Serial Number** (BOXXER ALL IN ONE CASE PACKING SYSTEM (S/N 16399)).

1. Locate the assembly the part is being ordered for. At the end of this manual is a complete set of assembly drawings to assist you in finding these parts.
2. Once you have the assembly drawing, locate the item number of the part you want to order and write down the part number from the bill of materials.
3. When calling **EAGLE** for parts, please provide:
 - a. Machine model and serial number
 - b. Assembly part number and description
 - c. Item number, part number and description

SUGGESTED SPARE PARTS

QTY	PART NO	DESCRIPTION
1	BRPB-100	1" PILLOW BLOCK 1-5/16" SHAFT HEIGHT 4' CENTER ON MTG HOLES
2	BRF2-100	1" 2-BOLT FLANGE BEARING
4	CF-3/4-SB	CAM FOLLOWER
2	SKIT-150	SEAL KIT FOR 1-1/2" CYLINDER
2	LC-200	LEVEL COMPENSATOR
4	W3X	SEALED V-WHEEL BEARINGS
6	VC-15	VACUUM CUP $\varnothing 3.4"$ $\varnothing 0.62$ HOLE
1	240H100	TIMING BELT
2	BB1.0X2.0X.50 SEALED RATED	1.00 ID X 2.00 OD X .50 WIDE SEALED BALL BEARING
14	TB INSERT NUT	BELT INSERTS NUTS
2	SKIT-200	SEAL KIT FOR 2" BORE CYLINDER
4	VC-70 1/8NPT	VACUUM CUP, STYLE F, 2.51 DIA X 1.37 DEEP, WITH 1/8NPT TAP
2	UDR-20-1B	AIR CYLINDER, 1-1/4" X 1" W/BUMPERS
2	ACFB1.1X 1/2 HOLS	1-1/8 BORE X .50 INCH STROKE HOLLOW SHAFT 1/8 NPT THREAD BOTH ENDS, DOUBLE ACTING
4	VC-BX35P 1/8 FEM	VACUUM CUP
1	TE-0910-CMT1	AIR CYLINDER
1	PB3-750-B	3/4" PILLOW BLOCK BEARING (FRICTION)
2	9240-AT10-50-K6	TIMING BELT
1	TE-094-CMT1	AIR CYLINDER
1	SDR-20-1-B	1-1/4 BORE X 1 IN STROKE AIR CYLINDER, DOUBLE ACTING, NOSE MOUNT
2	U-LHFSW1.00	LINEAR BEARING DOUBLE
2	SPB-16-OPN	1" SUPER BALL BUSHING PILLOW BLOCK OPEN
2	HAMMER HEAD 1.0 (GRAY)	BUMPER
2	BB075X1.75.50	3/4 ID X 1-3/4OD X 1/2 WIDE DOUBLE SHIELDED BALL BEARING
2	BB0.62X1.375.438	5/8 ID X 1-3/8OD X 7/16 WIDE SEALED BALL BEARING
12FT	BELTING H100	H Urethane Belting H Trade Size, 1/2" Pitch, 1" Width
1	FLEX COUP HUB 22-5/8 ZB RW	ELASTOMER COUPLING WITH CLAMPING HUB 22mm X 5/8

1	BRF2-150	DODGE 1-1/2, 2-BOLT FLANGE BEARING W/ 5-21/32 BETWEEN HOLES AND 1-7/8 MAX HEIGHT
1	390H100	1/2 PITCH X 1" WIDE GEAR BELT x 39" LONG
1	TE-091-BM	AIR CYLINDER, 1-1/16" X 1" THRUSTER ASSEMBLY
1	VQ4501-5 3 POS	AIR VALVE, 3 POSITION, DOUBLE SOLENOID, PRESSURE CENTER,RUBBER SEALS, 24VDC
2	VQ4101-5B REP2P4W24VDC	STACK VALVE 2-POSITON 4-WAY..24VDC
2	E2	VACUUM FILTER ELEMENT
2	SAV-GLU-24DC	PNEUMATIC VALVE 3 WAY, 2 POSIITON
1	AD SSIDIS1NO1NC	SAFETY SWITCH TONGUE INTLK 31.5mm 90-DEG ADJ HEAD 1 N.O./1 N.C. PLAS
1	AA RELAY SAFE 4NO 1NC	SAFETY RELAY, PLUG-IN, 4PST-NO, DPST-NC, 6 A, FORCIBLY-GUIDED CONTACTS
1	SIE E-STOP	MAINTAINED PUSH BUTTON ILLUMINATED,24VDC LED RD, MUSHROOM CAP RED 60mm
1	SIE BLK NC	NORMALLY CLOSED CONTACT BLOCK
1	SIE BLK NO	NORMALLY OPEN CONTACT BLOCK
1	PHQ12AB6FF30Q5	SENSOR Bipolar (NPN & PNP), Background Suppression (Fixed), 30mm, M12.
1	PHQ4XTKLAF600-Q8	Laser Adjustable Field, 1 PNP/NPN with IO-Link Communication; 1 PNP, 600 mm, M12.
1	PHQS18VP6LAFQ5	PHOTOCELL PNP, LASER ADJUSTABLE FIELD
1	PHQS18AB6AF300Q5	ADJUSTABLE FIELD BACKGROUND SUPPRESSION
1	D-A53-Z	D-A53-Z SMC DC-REED SW. 24VDC,
1	AD IND PROX PNP NONC	INDUC PROX 18mm PNP 8mm RNG 4-WIRE DC N.O./N.C. M12 Q/D SHIELDED
1	AA OMRDRV1HP240TP	1HP AC VECTOR DRIVE 240V 3 PH INPUT 3 PH OUT
1	AA G5 DRV 15H	53-R88DKN15HECT - OMRON G5 ECAT SERVO DRIVE 1.5KW 200V
1	AA G5 DRV 30H	OMRON G5 ECAT SERVO DRIVE 3000W 200V
1	AA SRVMTR 1500W	53-R88MK1K530HS2 - OMRON SERVOMOTOR 1.5KW,240V,3000rpm
1	AA SRVMTR 3000W	OMRON SERVOMOTOR 3 kW,240V,3000rpm.

ASSEMBLY DRAWINGS

ASSEMBLY NUMBER	DESCRIPTION
ABLS-002	MAIN ASSEMBLY
ABLS-002-02	HOPPER ASSEMBLY
ABLS-002-03	TOP SHEET FEED ASSEMBLY
ABLS-002-04	BOTTOM DRIVE ASSEMBLY
ABLS-002-05	BLANK PICKUP ASSEMBLY
ABLS-002-06	GUIDE RAIL ASSEMBLY
ABLS-002-07	BOTTOM VACUUM ASSEMBLY
ABLS-002-08	MINOR KICKER ASSEMBLY
ABLS-002-09	TOP GUIDE ASSEMBLY
ABLS-002-10	SECOND MINOR KICKER ASSEMBLY
ABLS-002-11	PLOW BAR ASSEMBLY
ABLS-002-12	TAPE HEAD SUPPORT RH ASSEMBLY
ABLS-002-13	TAPE HEAD SUPPORT LH ASSEMBLY
ABLS-002-14	INFEED CONVEYOR ASSEMBLY
ABLS-002-15	UP STACKING ASSEMBLY
ABLS-002-16	SIDE PUSHER ASSEMBLY
ABLS-002-17	FLAP OPENER ASSEMBLY
ABLS-002-18	TOP TRANSFER ASSEMBLY
ABLS-002-20	PRODUCT HOLD ASSEMBLY
ABLS-002-21	TOP GUIDE ASSEMBLY
ABLS-002-22	HOPPER CONVEYOR ASSEMBLY
ABLS-002-23	TOP DRIVE ASSEMBLY
ABLS-002-24	BOX FLIPPER ASSEMBLY
ABLS-002-25	REAR FLAP FOLDER ASSEMBLY
ABLS-002-26	FRONT PLOW BAR ASSEMBLY
ABLS-002-27	BOTTOM FLAP OPENER ASSEMBLY
ABLS-002-29	MAJOR HOLDER ASSEMBLY
ABLS-002-30	PNEUMATIC SCHEMATIC
ABLS-004-99	ELECTRICAL SCHEMATIC

UP STACKING SUGGESTED RANGE FOR PLATES

PLATE	PRODUCT SIZE RANGE (LENGTH*)	
	FROM	UP TO
1	8.00	8.00
2	9.63	10.30
3	11.50	13.50
4	14.00	15.38
5	16.00	18.00
6	18.75	19.38
7	20.00	23.38
8	24.00	29.00

*Dimensions in inches

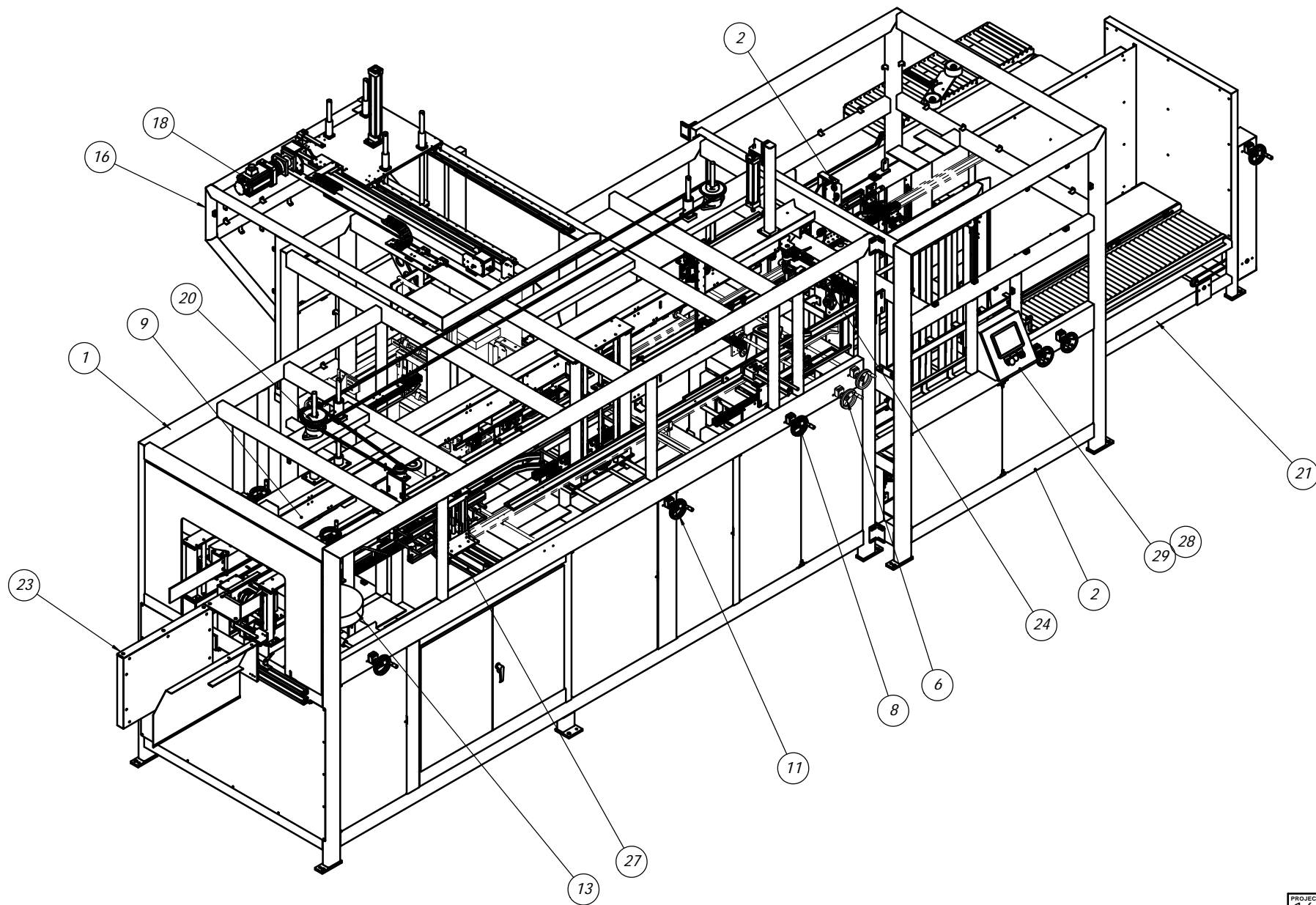
SIDE PUSHER SUGGESTED RANGE FOR PLATES

PLATE			PRODUCT		MASTER CASE		
#	LENGTH*	WIDTH*	PACK SIZE	ID	ID	LENGTH*	WIDTH*
1	19	13	4	CXN65-9665	C000130	21.63	14.63
			4	CXP09-9964	C000130	21.63	14.63
			4	DBK72-9964	C000352	20.63	14.63
2	13	10.5	4	CNV41-9964	C000190	14.13	12.88
3	21	10.5	4	CNV42-9964	C000125	22.50	12.75
4	11	9.5	5	DYF23-9564	C000263	13.47	11.25
			5	DXD73-9564	C000287	13.33	11.13
			3	DKX85-927A	C000347	12.13	11.88
			4	DPL01-9665	C000350	14.63	11.95
			2	CNF59-9964	C000241	12.50	11.13
			2	DXH42-9665	C000301	19.63	11.13
5	19	9.5	2	CXP12-9224	C000170A	24.63	11.13
			2	DPY44-XQ1B	C000170A	24.63	11.13
			2	DPY46-XQ1B	C000247	20.50	11.13
6	28	9.5	2	DBL81-9553	C000174A	29.50	11.00
7	9	8.5	5	DCN51-XT16A	C000119	12.00	10.50
			5	CND27-966A	C000119	12.00	10.50
			5	CND27-966A	C000119	12.00	10.50
			5	CNC82-9154	C000121	12.50	10.81
			4	DPF63-944A	C000146B	12.50	10.50
			4	DPF63-969A	C000146B	12.50	10.50
			4	DXY15-9694	C000146B	12.50	10.50
			4	DPF81-9765	C000150A	14.50	10.63
			5	CNF81-9765	C000225	12.50	10.88
			5	DPJ10-9154	C000235	10.63	10.13
			5	DRV32-9224	C000248	12.38	10.50
			4	DXV87-9694	C000288	13.33	10.26
			2	DXH37-9993	C000351	12.13	10.63
			2	CPC44-9964	C000351	12.13	10.63
8	14	8.5	4	CYY58-9964	C000108	18.75	10.75
			3	DKX85-911A	C000134	15.88	10.50
			4	DPD81-9765	C000176	18.63	10.63
			2	CNR75-9964	C000181A	15.50	10.50
			4	DMX55-9224	C000187	16.63	10.63
			2	DPJ56-9224	C000207	15.63	10.63
			2	DPJ58-9393	C000227	19.25	10.50
			4	DPH82-9964	C000233	19.88	10.50
			4	DPJ13-9154	C000236	18.50	10.63

			4	DPF83-9154	C000254	19.88	10.50
			4	DPF82-9154	C000255	18.50	10.50
9	9	7.5	4	DPJ11-9964	C000253	12.50	9.63
			4	DWY39-9964	C000286	13.33	9.75
			2	DYC55-9993	C000346	10.63	9.13
10	14	7.5	4	CNG69-9154	C000124	19.88	9.48
			4	CYR78-XQ1D	C000178	19.88	9.48
			2	DXH35-9694	C000269	15.50	9.50
			4	CNG68-9444	C000345	18.63	9.73
			4	DPK34-9224	C954181	16.63	9.63
11	20	7.5	3	CNG71-9964	C000103	23.88	9.88
			2	DRC62-9665	C000264	24.50	9.50
			3	CNT39-9765	C000126	21.50	9.50
			3	CNG87-9154	C000126	21.50	9.50
			2	DPY51-XQ1B	C000245	23.38	10.50
			2	DPY51-9964	C000245	23.38	10.50
12	9	6.5	3	DPL00-9665	C000300	12.13	8.00
			2	CYR55-996A	C000164	13.25	8.13
			2	DPY42-9964	C000249	10.50	8.50
			2	DKX86-9343	C000349	12.13	8.13
			2	DPY50-9964	C000252	14.50	8.50
			2	DCJ17-9974	C000262	12.00	8.50
13	7	6	2	DWR74-9665	C000266	8.50	7.50
			2	DWR78-9665	C000268	12.50	7.50
14	14	6	2	DWR76-9665	C000267	16.50	7.50
			2	DCJ10-996A	C000353	20.63	7.63

*Dimensions in inches

MAI01 ORDERS IN PROGRESS 16398 BOXER ALL IN ONE - MEGABRANDS 1-Mechanical



PROJECT
16398-16401

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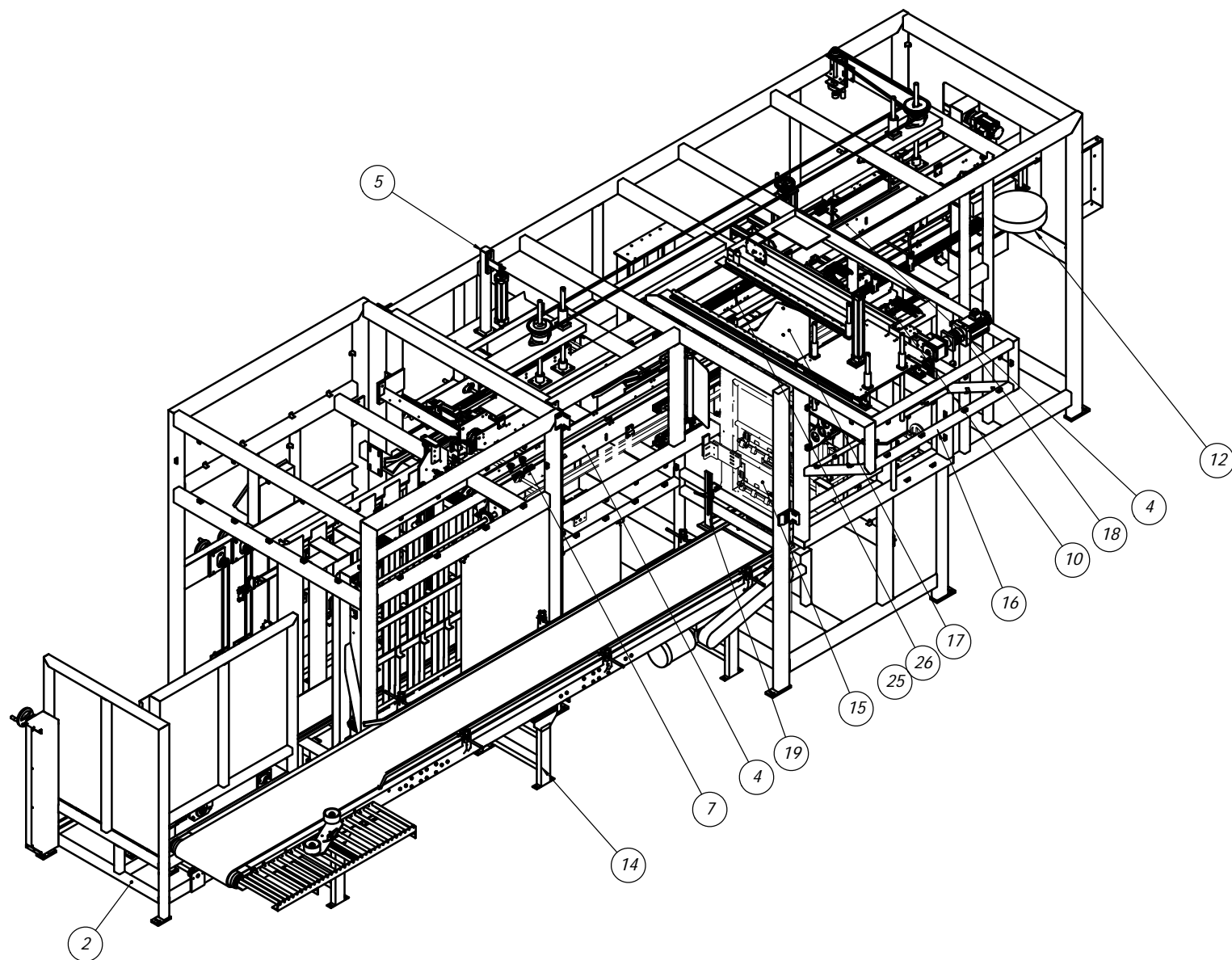
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EAGLE
Packaging Machinery, LLC.

4760 NW 128th STREET
MIAMI, FLORIDA 33054
305-622-4070

PART NAME		MAIN ASSEMBLY	
MACHINE MODEL		CASE ERECTOR LOADER SEALER	
DWG NO.		AELS-002	
DESIGN		JFdez	
DRAWN		V.Guzzo	
DATE		4/19/2017	
SHEET		1 of 3	

MA101 ORDERS IN PROGRESS 16398 BOXER ALL IN ONE - MEGABRANDS 11-Mechanical



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305-622-4070

PROJECT
16398-16401

PART NAME		MAIN ASSEMBLY	
MACHINE MODEL		CASE ERECTOR LOADER SEALER	
DWG NO.		AELS-002	
DESIGN	JFdez	DRAWN	V.Guzzo
DATE	4/19/2017	SHEET	2 of 3

MA101 ORDERS IN PROGRESS 16398 BOXER ALL IN ONE - MEGA BRANDS 11-Mechanical

ASSEMBLY BILL OF MATERIALS			
ITEM	QTY.	PartNo	Description
1	1	AELS-002-01-01	FRAME WELDMENT
2	1	AELS-002-02	HOPPER ASSEMBLY
3	1	AELS-002-03	TOP SHEET FEED
4	1	AELS-002-04	BOTTOM DRIVE
5	1	AELS-002-05	BLANK PICKUP
6	1	AELS-002-06	GUIDE RAIL
7	1	AELS-002-07	BOTTOM VACUUM
8	1	AELS-002-08	MINOR KICKER ASSY
9	1	AELS-002-09	TOP GUIDE
10	1	AELS-002-10	2ND MINOR KICKER
11	1	AELS-002-11	PLOW BAR ASSY
12	1	AELS-002-12	TAPE HEAD SUPPORT RH ASSY
13	1	AELS-002-13	TAPE HEAD SUPPORT LH ASSY
14	1	AELS-002-14	INFEED CONVEYOR
15	1	AELS-002-15	UP STACKING
16	1	AELS-002-16	SIDE PUSHER
17	1	AELS-002-17	FLAP OPENER ASSY
18	1	AELS-002-18	TOP TRANSFER
19	1	AELS-002-20	PRODUCT HOLD
20	1	AELS-002-21	TOP GUIDE ADJUSTMENT
21	1	AELS-002-22	HOPPER CONVEYOR ASSEMBLY
22	1	AELS-002-23	TOP DRIVE ASSEMBLY
23	1	AELS-002-24	BOX FLIPPER
24	1	AELS-002-25	REAR FLAP FOLDER
25	1	AELS-002-26	FRONT PLOW BAR
26	1	AELS-002-27	BOTTOM FLAP OPENER
27	1	AELS-002-29	MAJOR HOLDER
28	1	AELS-002-30	PNEUMATIC SCHEMATIC
29	1	AHL-072-99	ELECTRICAL SCHEMATIC

PROJECT
16398-16401

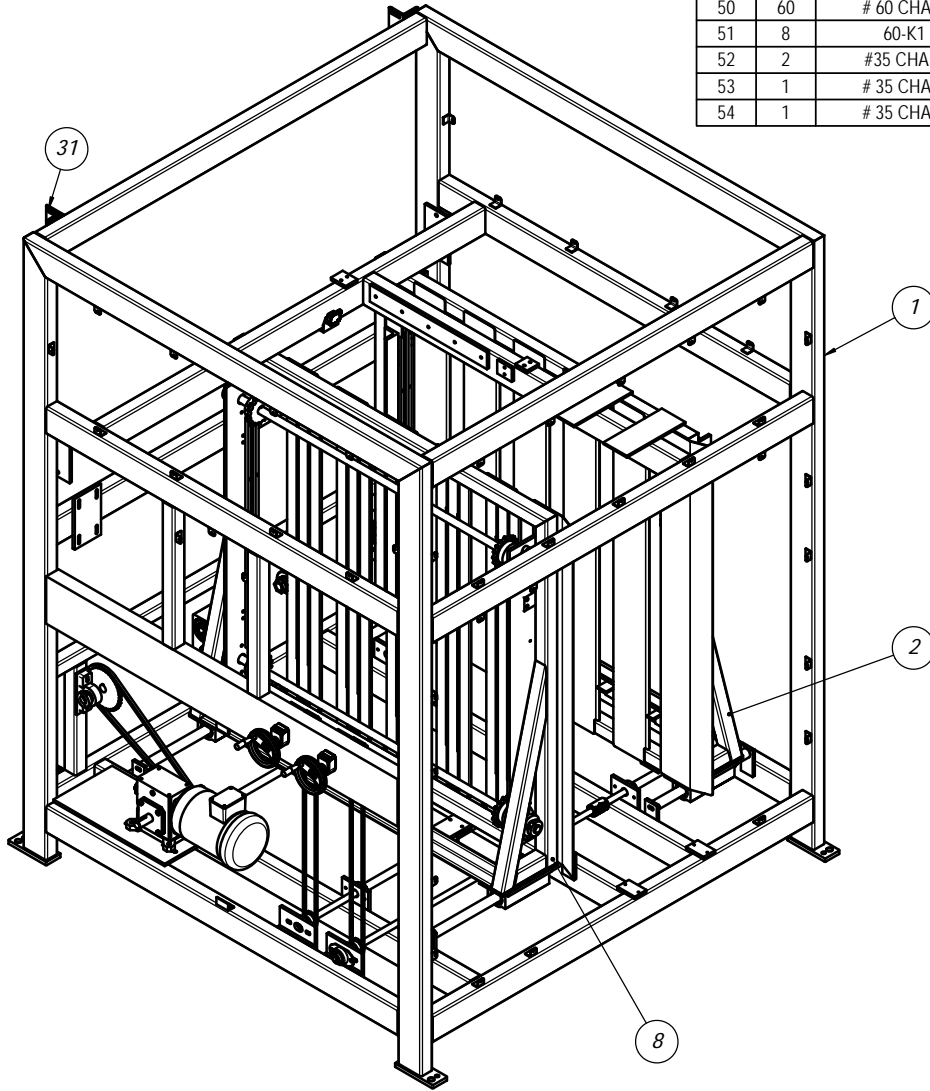
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LLC.

EAGLE
Packaging Machinery, LLC.
4760 NW 128th STREET
MIAMI, FLORIDA 33054
305-622-4070

PART NAME			
MAIN ASSEMBLY			
MACHINE MODEL			
CASE ERECTOR LOADER SEALER			
DWG NO.			REV
AELS-002			-
DESIGN	DRAWN	DATE	SHEET
JFdez	V.Guzzo	4/19/2017	3 OF 3

MA01 ORDERS IN PROGRESS\639W BOXER ALL IN ONE - MEGABRANDS\1-Mechanical1-Assembly\1



ASSEMBLY BILL OF MATERIALS			
ITEM	QTY.	PartNo	Description
44	2	DIAL IND 1 CW	DIAL INDICATOR
45	2	HANDW 5" PLAST	HAND WHEEL, Ø4.92" W /PLASTIC HANDLE
46	1	COUP 0.75 NO KEYWAY	COUPLING 3/4X3/4
47	1	#40 CHAIN	#40 CHAIN X 191 LINKS(95.5)
48	1	40B18	40B18 SPROCKET X BORE W/ KEYWAY
49	8	35B16 3/4 W KEY	SPROCKET
50	60	# 60 CHAIN	# 60 CHAIN X 120 LINKS (90)
51	8	60-K1	60-K-1 ATTACHMENT LINK.
52	2	#35 CHAIN	#35 CHAIN X 346 LINKS(129.75)
53	1	# 35 CHAIN	# 35 CHAIN X 295 LINKS(110 5/8)
54	1	# 35 CHAIN	35 CHAIN X 466 LINKS(174-3/4)

ASSEMBLY BILL OF MATERIALS			
ITEM	QTY.	PartNo	Description
1	1	AELS-002-01-02	HOPPER FRAME WELDMENT
2	1	AELS-002-02-01	SUPPORT FRAME RH
3	4	AELS-002-02-02	SUPPORT PLATE
4	8	AELS-002-02-03	TRACK
5	8	AELS-002-02-04	SPROCKET MODIFICATION
6	2	AELS-002-02-05	DRIVE SHAFT
7	4	AELS-002-02-06	LEDGE SUPPORT
8	1	AELS-002-02-09	SUPPORT FRAME LH
9	2	AELS-002-02-10	DRIVEN SHAFT
10	8	AELS-002-02-11	ADJUSTING NUT SUPPORT
11	2	AELS-002-02-12	LINEAR SHAFT SHORT
12	2	AELS-002-02-13	LINEAR SHAFT LONG
13	2	AELS-002-02-14-1	ADJUSTING NUT
14	2	AELS-002-02-14-2	ADJUSTING NUT LH
15	1	AELS-002-02-16-1	REDUCER BASE
16	1	AELS-002-02-16-2	REDUCER BASE
17	4	AELS-002-02-17	TOP BEARING SUPPORT
18	2	AELS-002-02-18	ENTRANCE GUIDE
19	10	AELS-002-02-19	SIDE GUIDE
20	1	AELS-002-02-20	ADJUSTING SHAFT LONG RH
21	1	AELS-002-02-21	ADJUSTING SCREW SHORT RH
22	1	AELS-002-02-22	ADJUSTING SHAFT LONG LH
23	1	AELS-002-02-23	ADJUSTING SHAFT SHORT LH
24	1	AELS-002-02-24	ADJUSTING HUB
25	1	AELS-002-02-25	ADJUSTING EXTENSION SHAFT
26	2	AELS-002-02-26	TOP BEARING SHAFT
27	1	AELS-002-02-28	DRIVEN SPROCKET MODIFICATION
28	1	AELS-002-02-29	FRONT GUIDE
29	2	AELS-002-02-30	FRONT GUIDE SUPPORT
30	1	AELS-002-02-31	PHOTOCELL SUPPORT
31	4	AELS-002-00-11	CONNECTING ANGLE
32	1	1HP 1725 56C	1HP, 1800 RPM, 56C FACE LESS FEET, 3/60/230/460V
33	1	TMQ821-60-D-56C	GEAR REDUCER MODEL TMQ821,60:1 REDUCTION, SHAFT BOTH SIDES, 56C MOTOR MOUNT
34	2	BRPB-100	PILLOW BLOCK BEARING DIA 1"
35	1	RA1.00 RH	SLIDE RITE GEAR BOX, 1:1 RATIO, RIGHT HAND, 1.00 DIA SHAFT, 1/4 X 1/8 KEYWAY
36	1	RA1.00 LH	SLIDE RITE GEAR BOX, 1:1 RATIO, LEFT HAND, 1.00 DIA SHAFT, 1/4 X 1/8 KEYWAY
37	1	TRANT 1.00	1 DIA TRANTORQUE
38	8	BRF2-100	BEARING
39	10	COL 1.00-2P	2-PIECE CLAMP-ON COLLAR FOR 1" Ø SHAFT
40	16	CF-3/4-SB	CAM FOLLOWER
41	4	TWN-20	LINEAR BEARING
42	14	BRF2-075 LIGHT	3/4" 2-BOLT FLANGE BEARING LIGHT
43	2	SETCOL 0.625	SET COLLAR

PROJECT 16398

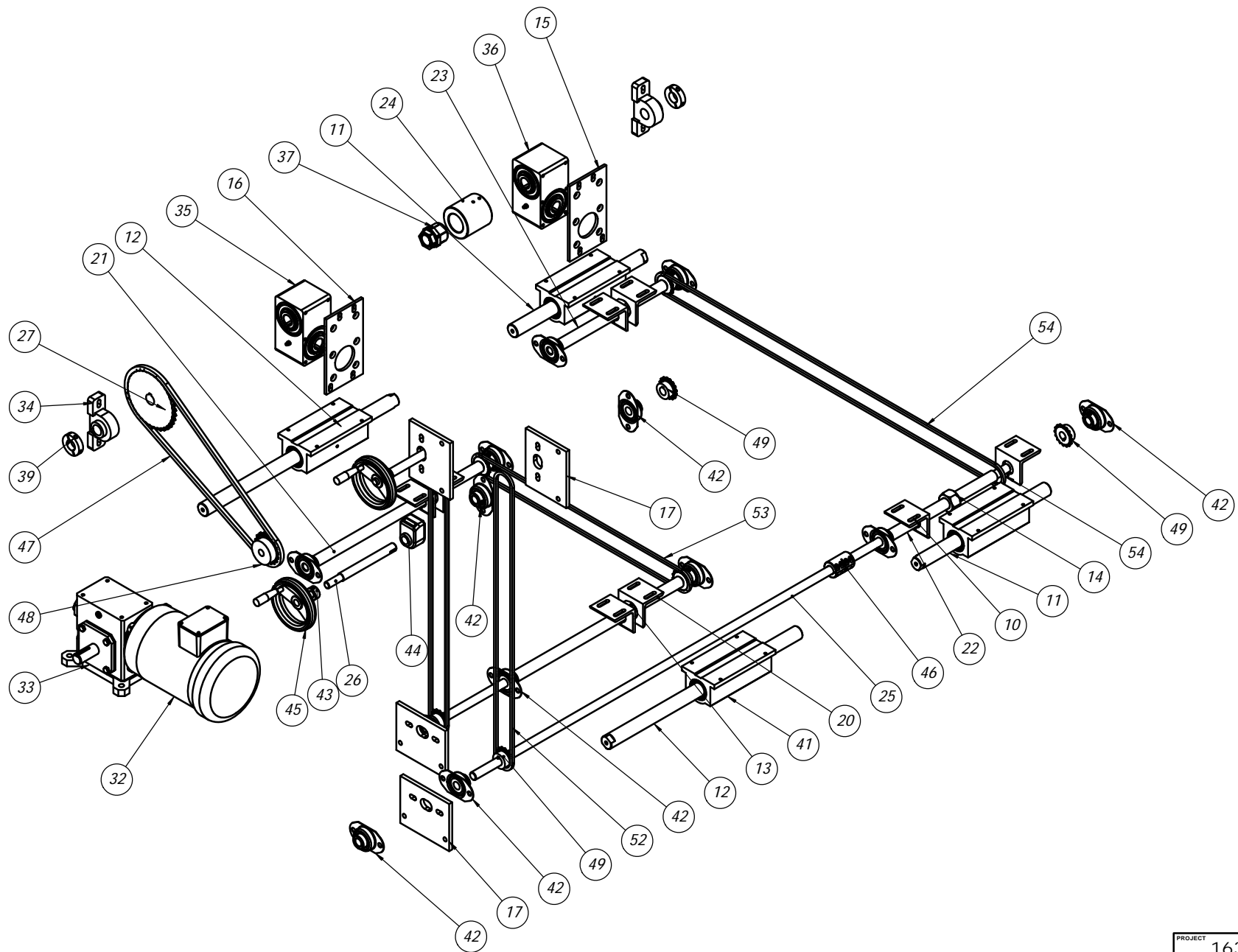
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EAGLE
Packaging Machinery, LLC.
4760 NW 128th STREET
MIAMI, FLORIDA 33054
305-622-4070

PART NAME		HOPPER ASSEMBLY	
MACHINE MODEL		CASE PACKER	
DWG NO.		AELS-002-02	
DESIGN	DRAWN	DATE	SHEET
	JFdez	4/28/2017	1 of 3



PROJECT 16399

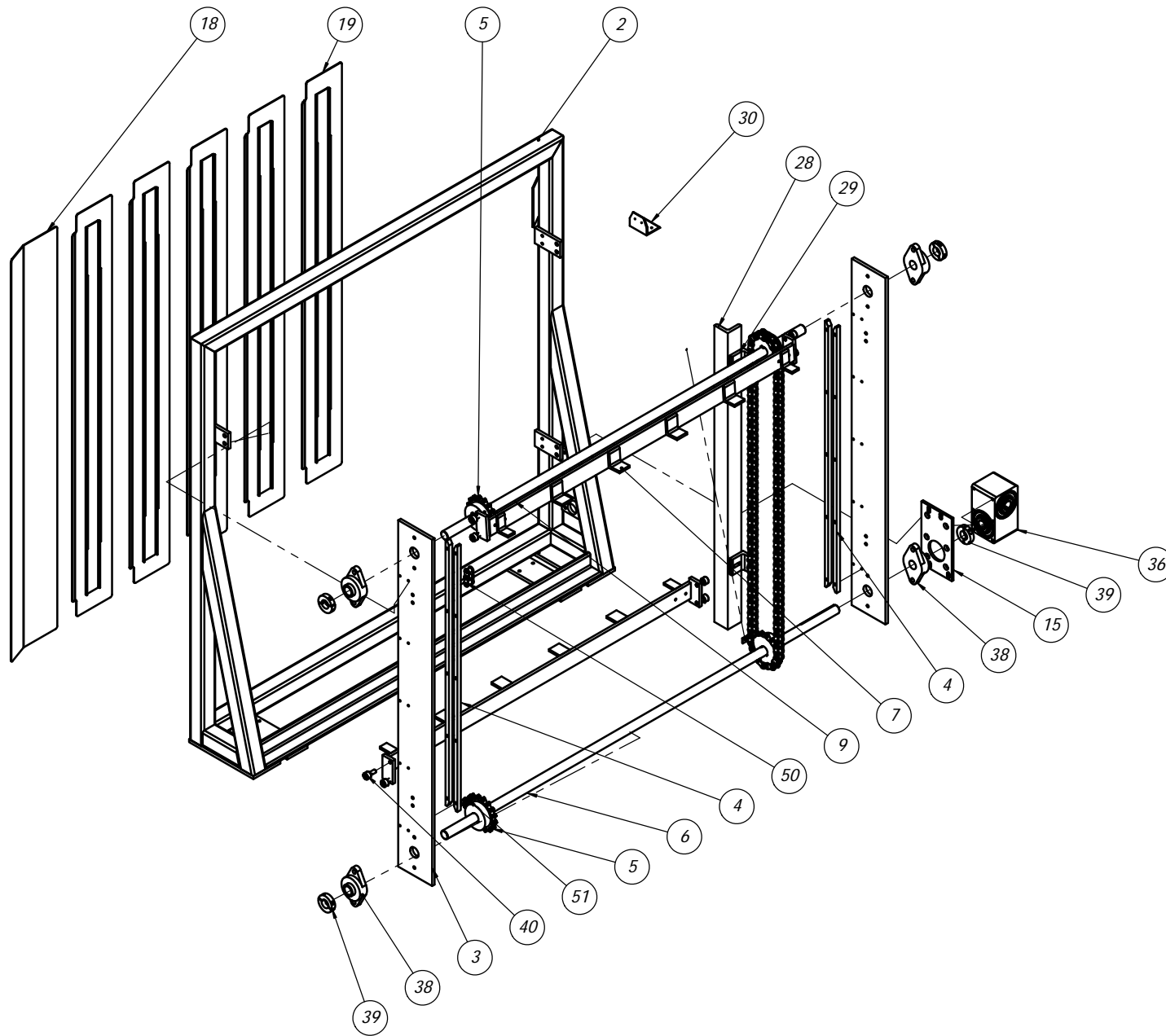
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Packaging Machinery, LLC.
4760 NW 128th STREET
MIAMI, FLORIDA 33054
305-622-4070

PART NAME		HOPPER ASSEMBLY	
MACHINE MODEL		CASE PACKER	
DWG NO.		AELS-002-02	
DESIGN	DRAWN	DATE	SHEET
	JFdez	4/28/2017	2 OF 3



PROJECT 16399

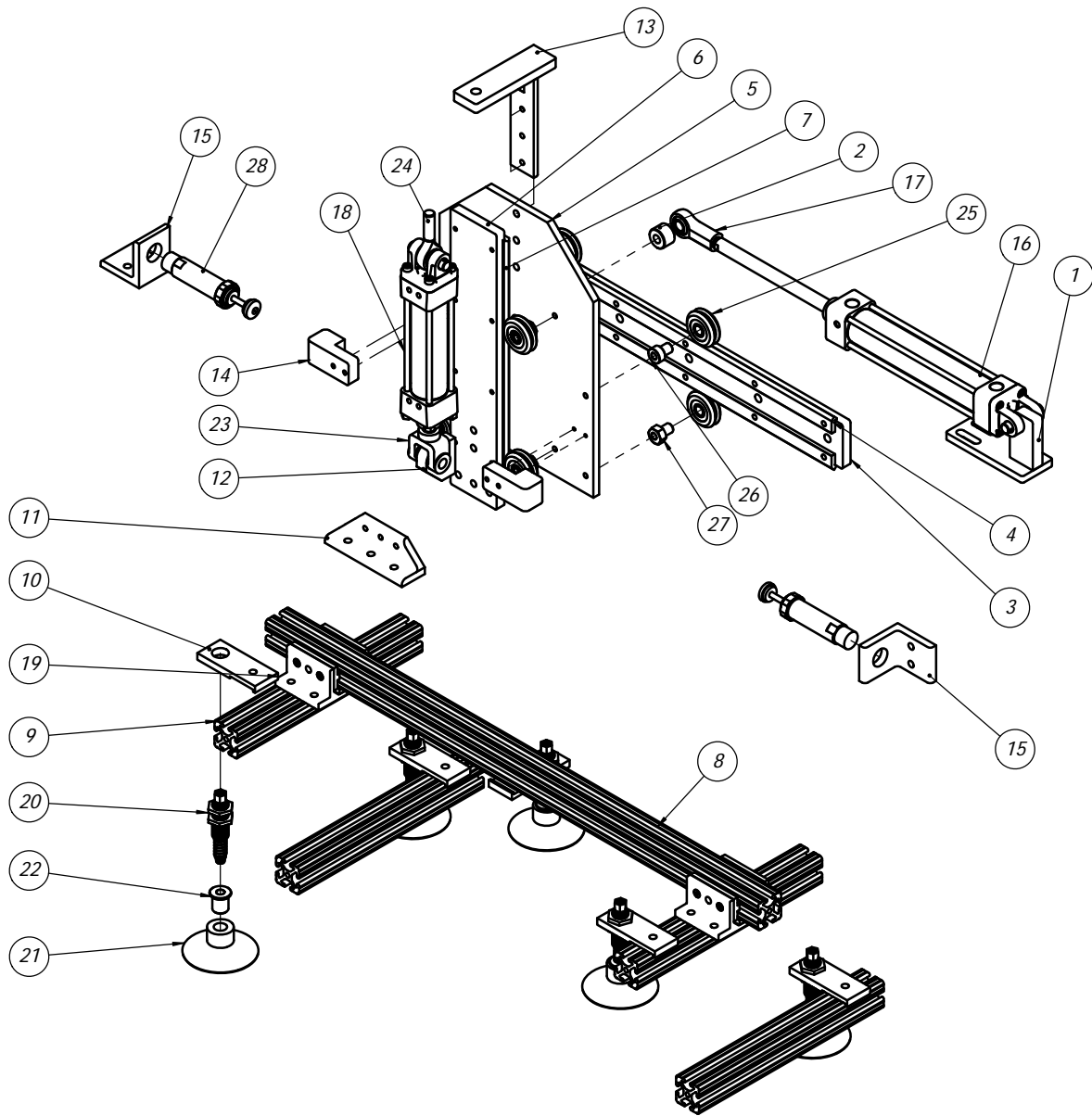
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EAGLE
Packaging Machinery, LLC.
4760 NW 128th STREET
MIAMI, FLORIDA 33054
305-622-4070

PART NAME		HOPPER ASSEMBLY	
MACHINE MODEL		CASE PACKER	
DWG NO.		AELS-002-02	
DESIGN		REV -	
DRAWN	JFdez	DATE	4/28/2017
		SHEET	3 of 3



ASSEMBLY BILL OF MATERIALS

ITEM	QTY.	PartNo	Description
1	1	AELS-002-03-01	CYLINDER BASE
2	1	AELS-002-03-02	CONNECT BAR
3	1	AELS-002-03-03	HORIZONTAL TRACK BASE
4	2	AELS-002-03-04	HORIZONTAL TRACK
5	1	AELS-002-03-05	CARRIAGE
6	1	AELS-002-03-06	VERTICAL TRACK BASE
7	2	AELS-002-03-07	VERTICAL TRACK
8	1	AELS-002-03-08	MAIN BEAM
9	4	AELS-002-03-09	SUPPORT BEAM
10	5	AELS-002-03-10	VAC CUP MOUNT
11	1	AELS-002-03-11	SUPPORT ANGLE
12	1	AELS-002-03-12	CYLINDER END MOUNT
13	1	AELS-002-03-13	CYLINDER MOUNT
14	2	AELS-002-03-15	SHOCK STRICKER
15	2	AELS-002-03-16	SHOCK BASE
16	1	SACRC15X7 A1D	AIR CYLINDER 1.5 X 7
17	1	REF50-20-RH	1/2-20 FEMALE ROD END BRG, RH
18	1	SACFF15X4	AIR CYLINDER
19	2	6525 SNG LIN BRG 1515	LINEAR BEARING
20	5	LC-200 (KIT)	LEVEL COMPENSATOR LIT (LC-200,251,252)
21	5	VC-15	VACUUM CUP
22	5	STD-002-1022	VACUUM CUP ADAP 1/8 FR VC-13/VC-15
23	1	RC1/2-20	ROD CLEVIS
24	1	REM50-20-RH	ROD END BEARING
25	8	W3X	#3 V-WHEEL
26	4	B3	STATIONARY BUSHING
27	4	BX3SS	ADJUSTABLE BUSHING
28	2	MA 600-B	SHOCK ABSORBER

PROPRIETARY PROPERTY

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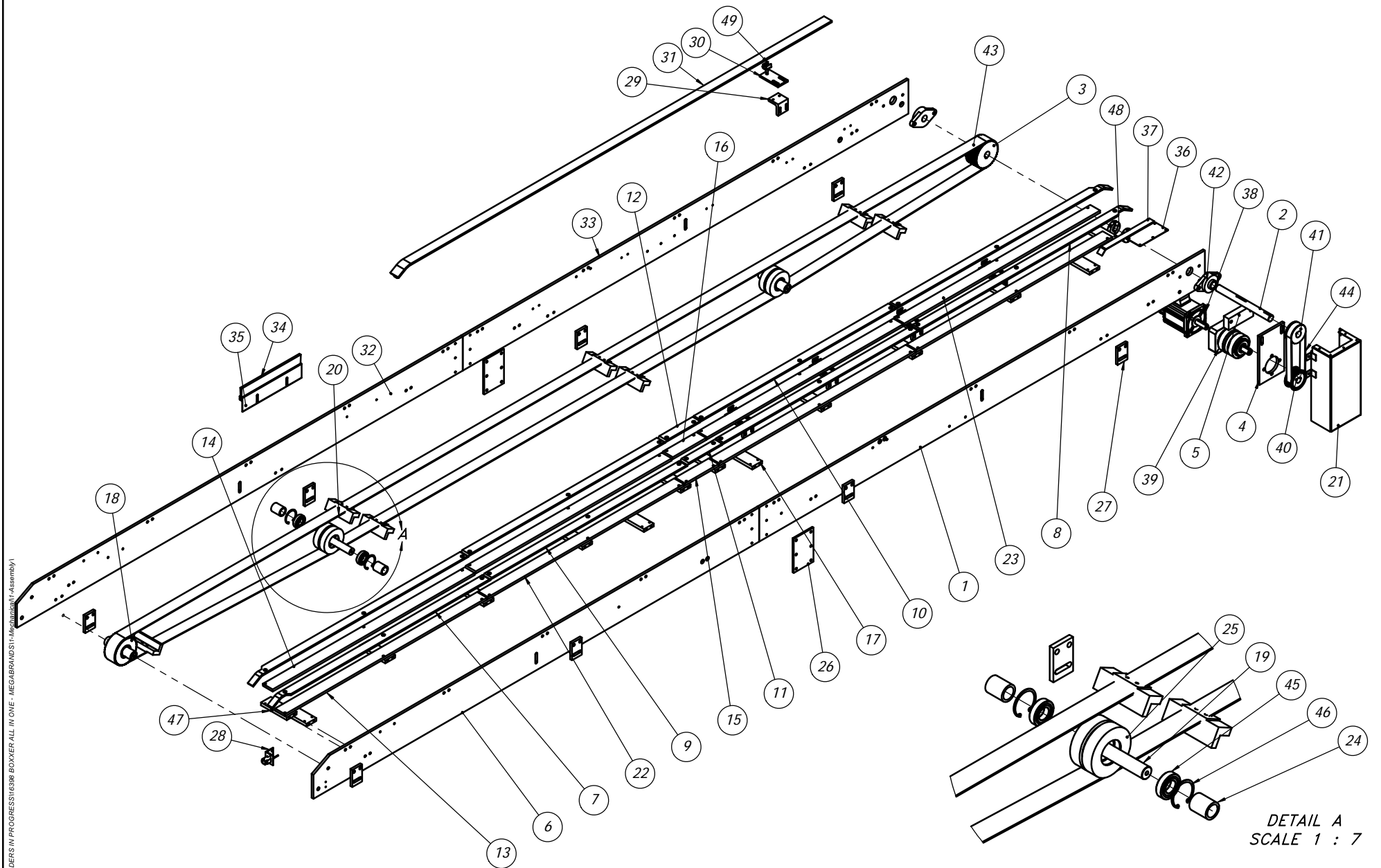
EAGLE
Packaging Machinery, LLC.

4760 NW 128th STREET
MIAMI, FLORIDA 33054
305-622-4070

PROJECT 16399

PART NAME	TOP SHEET FEED		
MACHINE MODEL	BOXSER ALL IN ONE		
DWG NO.	AELS-002-03		
DESIGN	DRAWN V.Guzzo	DATE 4/28/2017	SHEET 1 of 1

MA101 ORDERS IN PROGRESS 16399 BOXER ALL IN ONE - MEGABRANDS 11-Megabrand (1-Assembly)



DETAIL A
SCALE 1 : 7

PROJECT
16399

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EAGLE
Packaging Machinery, LLC.

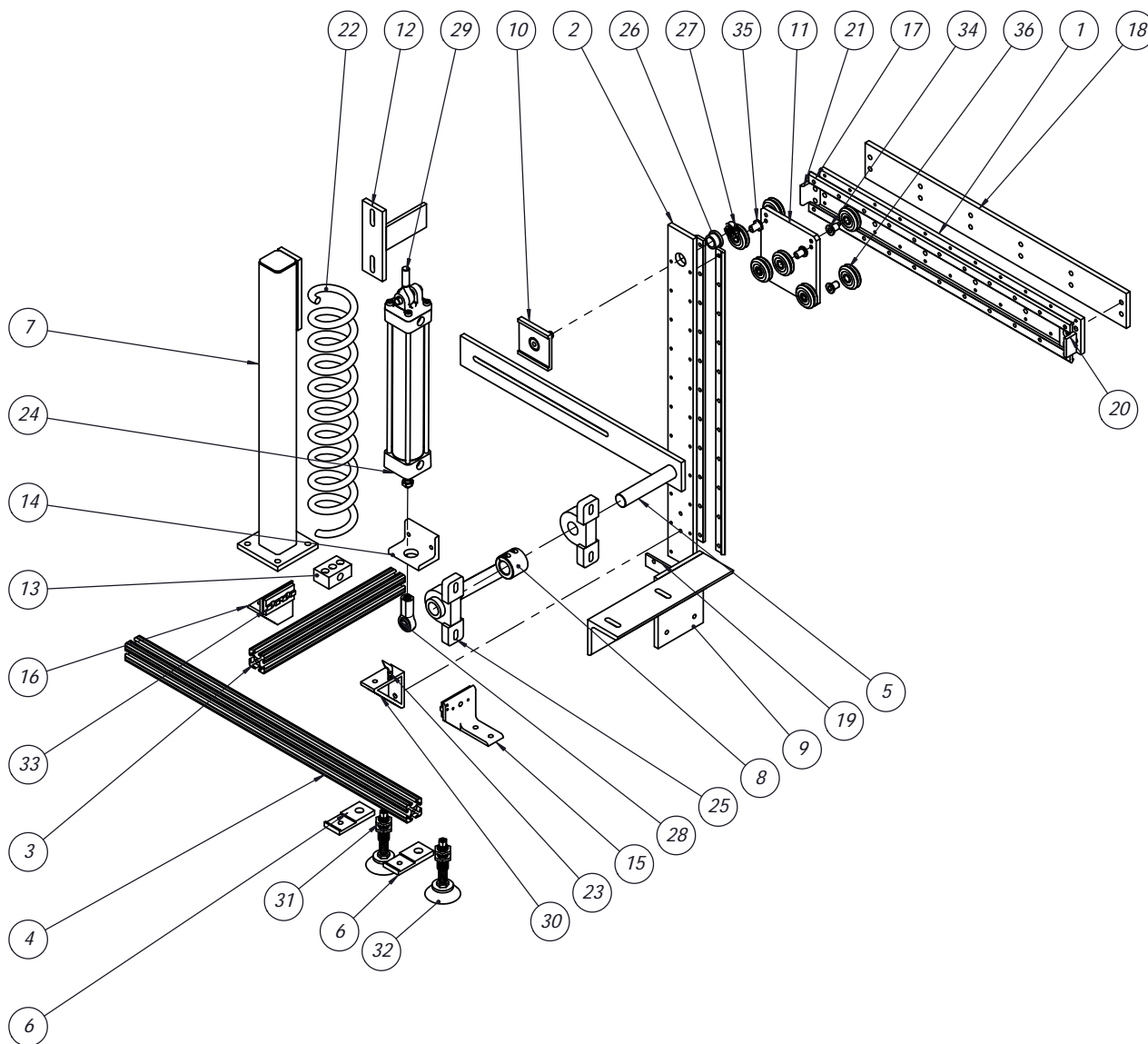
4760 NW 128th STREET
MIAMI, FLORIDA 33054
305-622-4070

PART NAME		BOTTOM DRIVE	
MACHINE MODEL		CASE PACKER	
DWG NO.		AELS-002-04	
DESIGN	DRAWN	DATE	SHEET
	JFdez	5/26/2017	1 OF 2

M101 ORDERS IN PROGRESS\639W BOXER ALL IN ONE - MEGABRANDS\1-Mechanical1-Assembly\1

ASSEMBLY BILL OF MATERIALS				ASSEMBLY BILL OF MATERIALS			
ITEM	QTY.	PartNo	Description	ITEM	QTY.	PartNo	Description
38	1	AA SRVMTR 1500W	SERVOMOTOR	1	1	AELS-002-04-01	SIDE PLATE END
39	1	AA GEARBX 8-1 1.5K	GEAR BOX	2	1	AELS-002-04-02	DRIVE SHAFT
40	1	18H100-22 W/KEY	<i>TIMING PULLEY 18 TEETH, 1" WIDE, 22 mm BORE</i>	3	1	AELS-002-04-03	DRIVE PULLEY
41	1	18H100-100 W/KEY	TIMING PULLEY	4	1	AELS-002-04-04	DRIVE SUPPORT
42	2	BRF2-100	BEARING	5	1	AELS-002-04-05	SUPPORT SPACER
43	1	9240-AT10-50-K6	TIMING BELT	6	1	AELS-002-04-06	SIDE PLATE START
44	1	240H100	TIMING BELT	7	2	AELS-002-04-07-1	LUG GUIDE
45	6	BB1.0X2.0X.50	<i>1.00 ID X 2.00 OD X .50 WIDE SEALED BALL BEARING</i>	8	2	AELS-002-04-07-2	LUG GUIDE
46	6	SNAPRING 2.00	INTERNAL RETAINING RING ø2.00	9	2	AELS-002-04-08-1	LUG GUIDE EXTENSION
47	14	TB INSERT NUT	BELT INSERT NUTS	10	2	AELS-002-04-08-2	LUG GUIDE EXTENSION
48	2	COL 1.00-2P	<i>2-PIECE CLAMP-ON COLLAR FOR 1" Ø SHAFT</i>	11	1	AELS-002-04-09-1	LUG GUIDE SHORT
49	5	VG-018-01 .675LG	CLIP (RAIL MOUNTING) 5/16 UNC X 5/8" LG	12	1	AELS-002-04-09-2	LUG GUIDE SHORT
				13	1	AELS-002-04-10-1	BELT SUPPORT LONG
				14	1	AELS-002-04-10-2	BELT SUPPORT LONG
				15	1	AELS-002-04-11-1	BELT SUPPORT SHORT
				16	1	AELS-002-04-11-2	BELT SUPPORT SHORT
				17	14	AELS-002-04-12	CONNECTING PLATE
				18	1	AELS-002-04-13	IDLER PULLEY
				19	3	AELS-002-04-14	TENSIONER SHAFT
				20	7	AELS-002-04-15	PUSHER LOG
				21	1	AELS-002-04-16	BOTTOM COVER
				22	3	AELS-002-04-17-1	BELT SUPPORT EXTENSION
				23	3	AELS-002-04-17-1	BELT SUPPORT EXTENSION
				24	6	AELS-002-04-18	SHAFT SPACER
				25	2	AELS-002-04-19	TENSIONER PULLEY
				26	2	AELS-002-04-20	JOINT PLATE
				27	8	AELS-002-04-21	SUPPORT PLATE
				28	1	AELS-002-04-22	PHOTOCELL SUPORT
				29	5	AELS-002-04-23	BOTTOM GUIDE ANGLE
				30	5	AELS-002-04-24	BOTTOM GUIDE PLATE
				31	1	AELS-002-04-25	TEE GUIDE RAIL
				32	1	AELS-002-04-26	SIDE PLATE START-2
				33	1	AELS-002-04-27	SIDE PLATE END-2
				34	1	AELS-002-04-28	BRUSH
				35	1	AELS-002-04-29	BRUSH HOLDER
				36	1	AELS-002-04-30	COVER LID
				37	1	AELS-002-09-06-1	TOP EXTIR HOLDER

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PART NAME		BOTTOM DRIVE																						
MACHINE MODEL		CASE PACKER																						
DWG NO.	AELS-002-04		REV -																					
DESIGN	DRAWN	DATE	SHEET																					
	JFdez	4/28/2017	2 of 2																					



ASSEMBLY BILL OF MATERIALS			
ITEM	QTY.	PartNo	Description
1	1	AELS-002-05-01	HORIZONTAL TRACK SUPPORT
2	1	AELS-002-05-02	VERTICAL TRACK SUPPORT
3	1	AELS-002-05-03	ADJUSTING BEAM
4	1	AELS-002-05-04	ADJUSTING ARM
5	1	AELS-002-05-05	PIVOT ARM
6	2	AELS-002-05-06	VACUUM CUP SUPPORT
7	1	AELS-002-05-07	CYLINDER BASE
8	1	AELS-002-05-08	CRANK
9	1	AELS-002-05-09	BEARING MOUNTING BRACKET
10	1	AELS-002-05-10	SLIDE
11	1	AELS-002-05-11	CARRIAGE
12	1	AELS-002-05-12	CYLINDER BRACKET
13	1	AELS-002-05-13	MANIFOLD
14	1	AELS-002-05-14	COIL SUPPORT
15	1	AELS-002-05-15-1	BEAM SUPPORT
16	1	AELS-002-05-15-1	BEAM SUPPORT
17	4	AELS-002-05-17	VEE TRACK
18	1	AELS-002-05-18	TRACK SUPPORT SPACER
19	1	AELS-002-05-19	VERTICAL TRACK SUPPORT ANGLE
20	1	AELS-002-05-20	HORIZONTAL TRACK SUPPORT ANGLE-2
21	1	AELS-002-05-21	HORIZONTAL TRACK SUPPORT ANGLE
22	1	AELS-002-05-22	AIR HOSE
23	1	STD-002-1052-2	LH AND RH SCALE INDICATOR
24	1	SACRC20X10AID	AIR CYLINDER, 2" X 10", DBL REAR CLEVIS
25	2	BRPB-100	PILLOW BLOCK BEARING DIA 1"
26	1	075-100-062FLBU	BRONZE BEARING
27	1	COL THREADED 1/2-20	COLLAR 1-PC CLAMP-ON 1/2-20
28	1	REF50-20-RH	1/2-20 FEMALE ROD END BRG, RH
29	1	REM50-20-RH	ROD END BEARING
30	1	CORNER GUSSET 4 HOLE	BRACKET
31	2	LC-200 (KIT)	LEVEL COMPENSATOR LIT (LC-200,251,252)
32	2	VC-70 1/8NPT	VACUUM CUP
33	2	BRG PAD 6817 1515	BEARING PAD 15 SERIES
34	4	3PWBC	STATIONARY BUSHING NARROW
35	4	3PWBX	ADJUSTABLE BUSHING NARROW
36	8	W3X	#3 V-WHEEL

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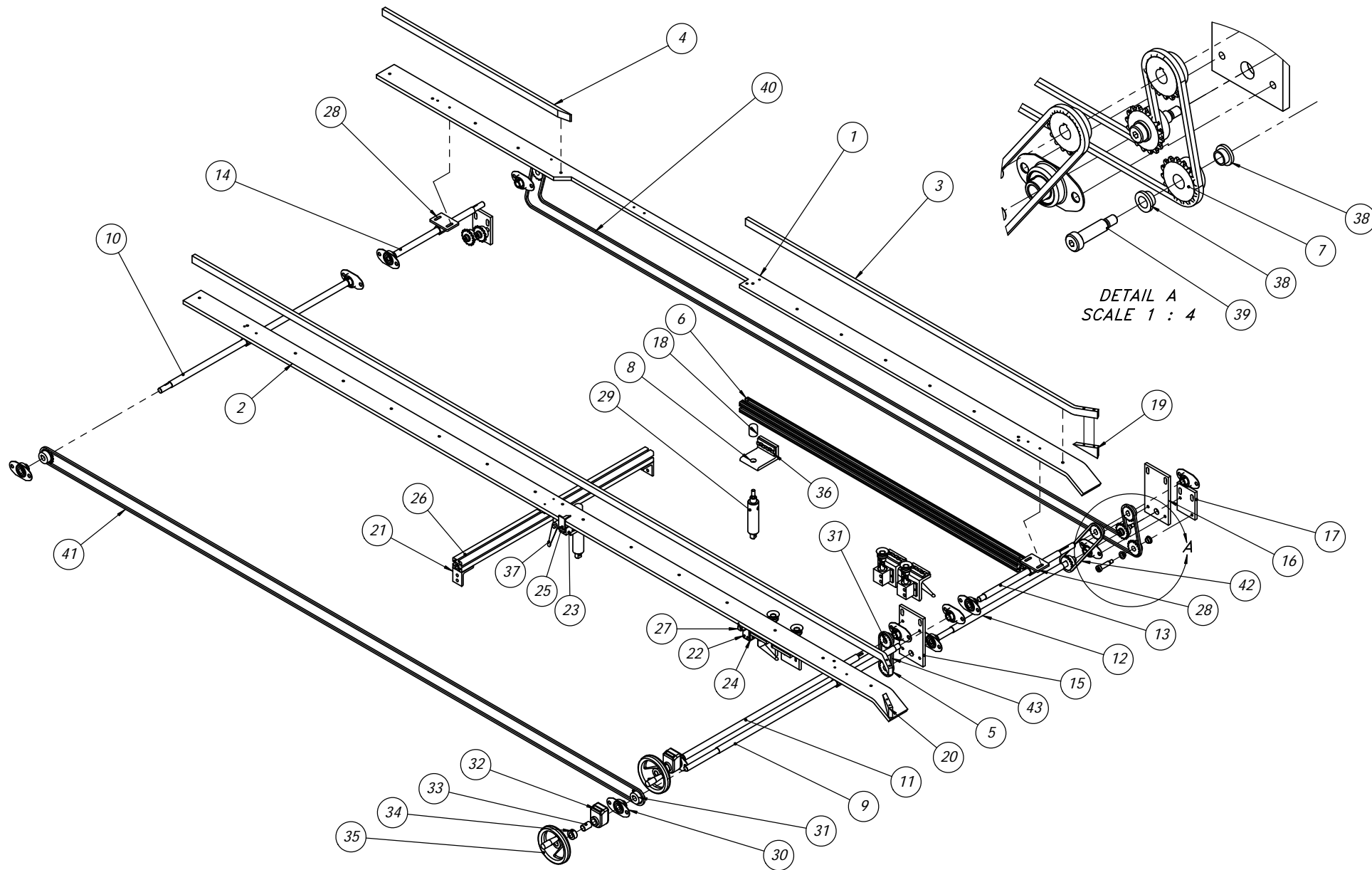
EAGLE
Packaging Machinery, LLC.

4760 NW 128th STREET
MIAMI, FLORIDA 33054
305-622-4070

PROJECT
16399

PART NAME	BLANK PICKUP		
MACHINE MODEL	CASE PACKER		
DWG NO.	AELS-002-05		REV -
DESIGN	DRAWN JFdez	DATE 6/6/2017	SHEET 1 of 1

M101 ORDERS IN PROGRESS 16399 BOXER ALL IN ONE - MEGABRANDS 1-Mechanical1-Assembly



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Packaging Machinery, LLC.

4760 NW 128th STREET
MIAMI, FLORIDA 33054
305-622-4070

PROJECT 16399

PART NAME		GUIDE RAIL	
MACHINE MODEL		CASE PACKER	
DWG NO.		AELS-002-06	
DESIGN	DRAWN	DATE	SHEET
	JFdez	4/28/2017	1 of 2

MA101 ORDERS IN PROGRESS\1639M BOXER ALL IN ONE - MEGABRANDS\1-Mechanical1-Assembly\1

ASSEMBLY BILL OF MATERIALS			
ITEM	QTY.	PartNo	Description
1	1	AELS-002-06-01	GUIDE RAIL RIGHT
2	1	AELS-002-06-02	GUIDE RAIL LEFT
3	1	AELS-002-06-03	START SIDE GUIDE
4	1	AELS-002-06-04	END SIDE GUIDE
5	1	AELS-002-06-05	SIDE GUIDE LEFT
6	2	AELS-002-06-06	SLIDE
7	4	AELS-002-06-07	SPROCKET MODIFICATION
8	2	AELS-002-06-08	CYLINDER BASE
9	1	AELS-002-06-09	ADJUSTING SCREW LEFT DRIVE
10	1	AELS-002-06-10	ADJUSTING SCREW LEFT DRIVEN
11	1	AELS-002-06-11	SHAFT EXTENSION LONG
12	1	AELS-002-06-12	SHAFT EXTENSION SHORT
13	1	AELS-002-06-13	ADJUSTING SCREW RIGHT DRIVE
14	1	AELS-002-06-14	ADJUSTING SCREW RIGHT DRIVEN
15	1	AELS-002-06-15	BEARING BRACKET "A"
16	1	AELS-002-06-16	BEARING BRACKET "B"
17	2	AELS-002-06-17	BEARING BRACKET "C"
18	2	AELS-002-06-18	END STOP
19	1	AELS-002-06-19-1	GUSSET
20	1	AELS-002-06-19-2	GUSSET
21	2	AELS-002-06-20	SLIDE SUPPORT ANGLE
22	1	AELS-002-06-21	BRACKET ANGLE
23	1	AELS-002-06-22	SPACER
24	1	AELS-002-06-23	SPACER
25	1	AELS-002-06-24	ANGLE IND
26	1	AELS-002-29-02	HORIZONTAL SLIDE
27	1	STD-002-1052 -1 / -2	LH AND RH SCALE INDICATOR
28	4	STD-400-1404-1	RAIL ADJUSTMENT BRKT
29	2	UDR-20-1B	AIR CYLINDER
30	12	BRF2-062 LIGHT	5/8" 2-BOLT FLANGE BEARING LIGHT
31	8	35B16 5/8 W KEY	SPROCKET
32	2	DIAL IND 1 CW	DIAL INDICATOR
33	2	RB52 3/4-5/8	BUSHING
34	2	SETCOL 0.625	SET COLLAR
35	2	HANDW 5" PLAST	HAND WHEEL, Ø4.92" W /PLASTIC HANDLE
36	3	BRG PAD 6817 1515	BEARING PAD 15 SERIES
37	1	ZCL-3031	LOCK HANDLE 5/16-18
38	8	05-062-038FLBU	BRONZE BEARING
39	4	1/2X1-1/2 shoulder	SHOULDER BOLT
40	1	35 CHAIN	#35 CHAIN X 226.875 (605 LINKS)
41	1	35 CHAIN	#35 CHAIN X 205.5 (548 LINKS)
42	1	35 CHAIN	#35 CHAIN X 22.875 (61 LINKS)
43	1	35 CHAIN	#35 CHAIN X 13.5 (36 LINKS)

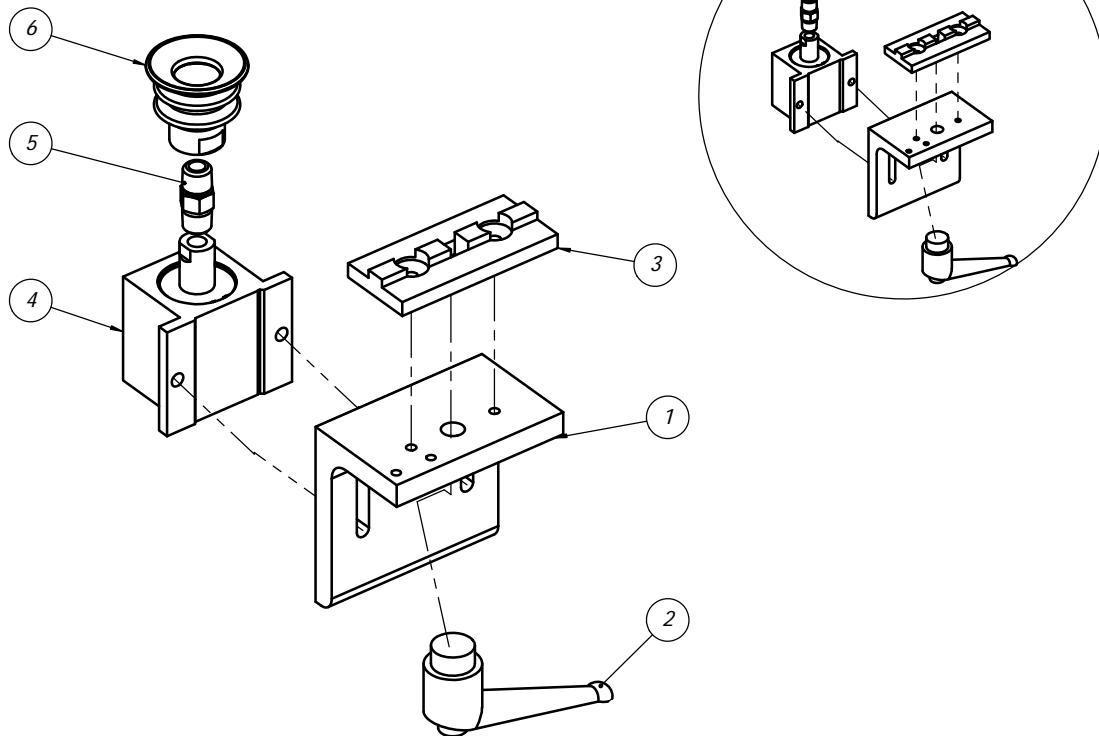
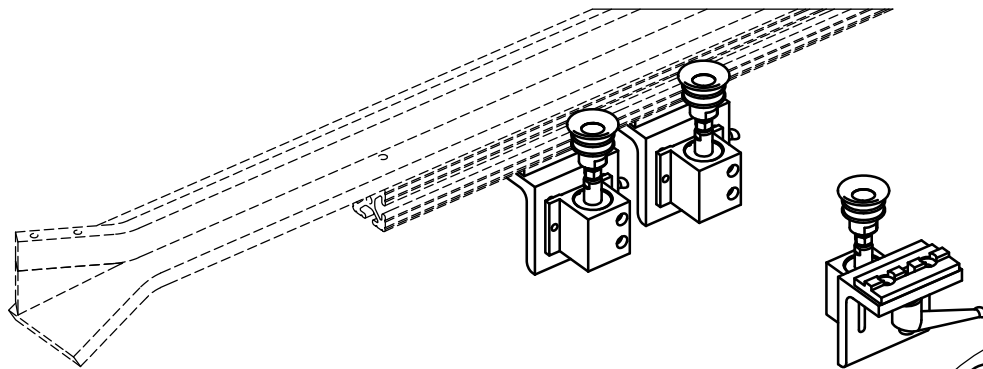
PROJECT 16399

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4760 NW 128th STREET
MIAMI, FLORIDA 33054
305-622-4070

PART NAME		GUIDE RAIL	
MACHINE MODEL		CASE PACKER	
DWG NO.		AELS-002-06	
DESIGN		DRAWN JFdez	
DATE		4/28/2017	
SHEET		2 of 2	



DETAIL A
SCALE 1 : 2

ASSEMBLY BILL OF MATERIALS

ITEM	QTY.	PartNo	Description
1	4	AELS-002-07-01	CYLINDER BASE
2	4	ZCL-3031	LOCK HANDLE 5/16-18
3	4	BRG PAD 6817 1515	BEARING PAD 15 SERIES
4	4	ACFB1.1X 1/2 HOL	AIR CYLINDER
5	4	1/8 HEX NIPPLE	1/8 HIGH-PRESSURE STEEL NIPPLE
6	4	VC-BX35P 1/8 FEM	VACUUM CUP

M101 ORDERS IN PROGRESS 16399 BOXER ALL IN ONE - MEGABRANDS 1-Mechanical1-Assembly1

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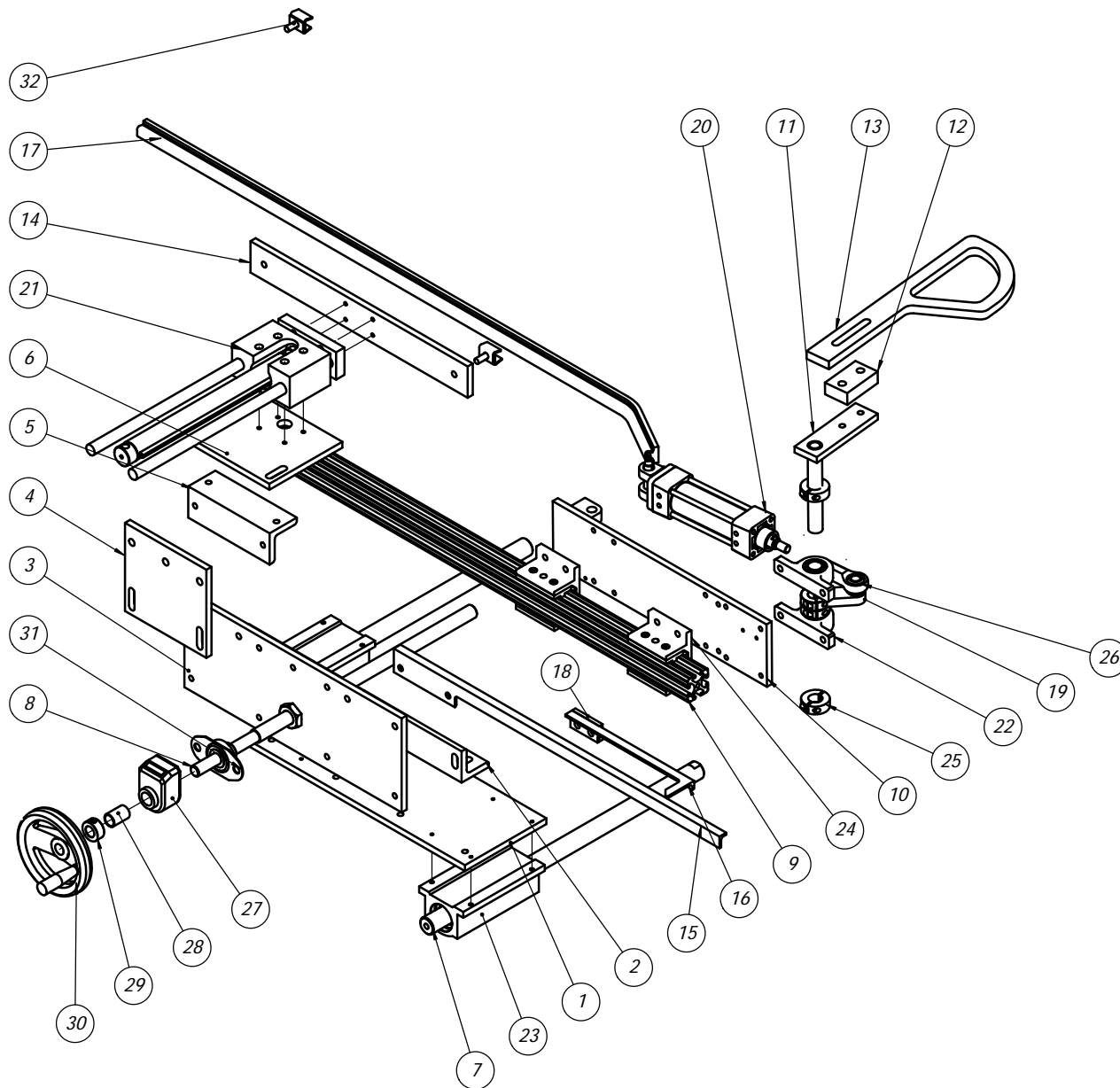
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4760 NW 128th STREET
MIAMI, FLORIDA 33054
305-622-4070

PROJECT
16399

PART NAME		BOTTOM VACUUM	
MACHINE MODEL		CASE PACKER	
DWG NO.		AELS-002-07	
DESIGN	DRAWN	DATE	SHEET
	JFdez	4/28/2017	1 OF 1



ASSEMBLY BILL OF MATERIALS

ITEM	QTY.	PartNo	Description
1	1	AELS-002-08-01	CARRIAGE
2	1	AELS-002-08-02	SUPPORT ANGLE
3	1	AELS-002-08-03	ADJUSTING PLATE
4	1	AELS-002-08-04	CYLINDER VERTICAL BASE
5	1	AELS-002-08-05	CONNECTING ANGLE
6	1	AELS-002-08-06	CYLINDER HORIZONTAL PLATE
7	2	AELS-002-08-07	LINEAR SHAFT
8	1	AELS-002-08-08	ADJUSTING SHAFT
9	1	AELS-002-08-09	SLIDING BEAM
10	1	AELS-002-08-10	CYLINDER BASE
11	1	AELS-002-08-11	PIVOT
12	1	AELS-002-08-12	SPACER
13	1	AELS-002-08-13	MINOR FOLDER
14	1	AELS-002-08-14	MINOR HOLDER SUPPORT
15	1	AELS-002-08-15	SCALE SUPPORT
16	1	AELS-002-08-16	SCALE ARROW
17	1	AELS-002-08-18	TEE GUIDE RAIL
18	1	AELS-002-08-19	SCALE SPACER
19	1	STD-200-1106	FOLDER CRANK
20	1	SACRC15X3 A1D	AIR CYLINDER, 1-1/2" X 3", DBL REAR CLEVIS
21	1	TE-0910-CMT1	AIR CYLINDER
22	2	PB3-750-B	BEARING, PILLOW BLOCK, 3/4"
23	2	IG-TWN-16	LINEAR BEARING
24	2	6525 SNG LIN BRG 1515	LINEAR BEARING
25	2	COL 0.75-2P	3/4" TWO-PIECE CLAMP-ON COLLAR (STEEL)
26	1	REF50-20-RH	1/2-20 FEMALE ROD END BRG, RH
27	1	DIAL IND 1 CW	DIAL INDICATOR
28	1	RB52 3/4-5/8	BUSHING
29	1	SETCOL 0.625	SET COLLAR
30	1	HANDW 5" PLAST	HAND WHEEL, Ø4.92" W / PLASTIC HANDLE
31	1	BRF2-062 LIGHT	5/8" 2-BOLT FLANGE BEARING LIGHT
32	2	VG-018-01 .675LG	CLIP (RAIL MOUNTING) 5/16 UNC X 5/8" LG

PROJECT 16399

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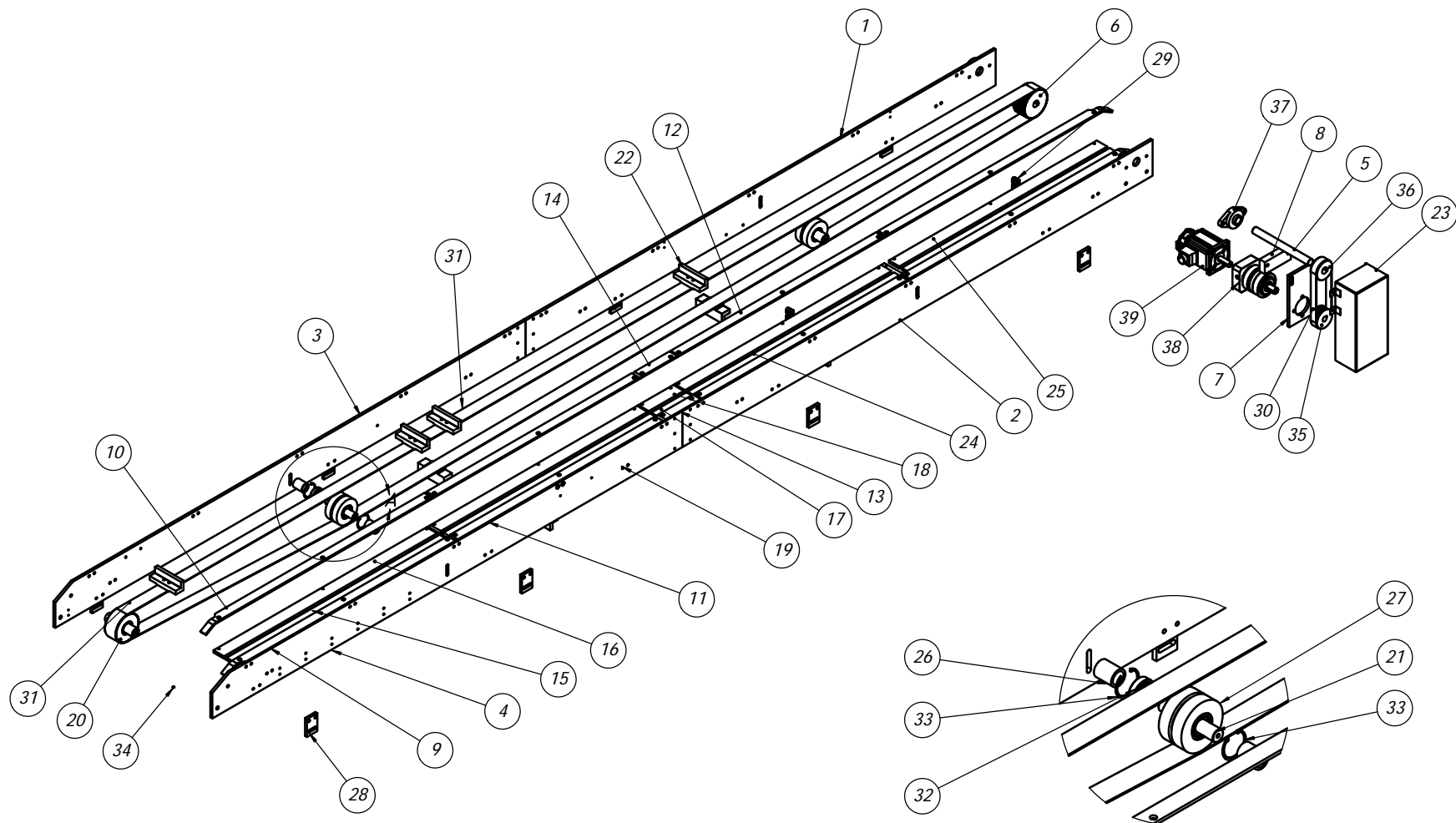
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4760 NW 128th STREET
MIAMI, FLORIDA 33054
305-622-4070

PART NAME		MINOR KICKER ASSY	
MACHINE MODEL		CASE PACKER	
DWG NO.		AELS-002-08	
DESIGN	DRAWN	DATE	SHEET
	JFdez	4/28/2017	1 of 1

MAI01 ORDERS IN PROGRESS BOXER ALL IN ONE - MEGABRANDS1-Mechanical-Assembly1



DETAIL A
SCALE 1 : 8

PROJECT 16399

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305-622-4070

PART NAME		TOP GUIDE	
MACHINE MODEL		BOXXER ALL IN ONE	
DWG NO.		AELS-002-09	
DESIGN	DRAWN	DATE	SHEET
	V. Guzzo	4/28/2017	1 OF 2

MA01 ORDERS IN PROGRESS\639W BOXER ALL IN ONE - MEGA BRANDS\1-Mechanical1-Assembly\1

ASSEMBLY BILL OF MATERIALS

ITEM	QTY.	PartNo	Description
1	1	AELS-002-09-02	SIDE PLATE END
2	1	AELS-002-09-03	SIDE PLATE END-2
3	1	AELS-002-09-04	SIDE PLATE START
4	1	AELS-002-09-05	SIDE PLATE START-2
5	1	AELS-002-04-02	DRIVE SHAFT
6	1	AELS-002-04-03	DRIVE PULLEY
7	1	AELS-002-04-04	DRIVE SUPPORT
8	1	AELS-002-04-05	SUPPORT SPACER
9	2	AELS-002-04-07-1	LUG GUIDE
10	2	AELS-002-04-07-2	LUG GUIDE
11	2	AELS-002-04-08-1	LUG GUIDE EXTENSION
12	2	AELS-002-04-08-2	LUG GUIDE EXTENSION
13	1	AELS-002-04-09-1	LUG GUIDE SHORT
14	1	AELS-002-04-09-2	LUG GUIDE SHORT
15	1	AELS-002-04-10-1	BELT SUPPORT LONG
16	1	AELS-002-04-10-2	BELT SUPPORT LONG
17	1	AELS-002-04-11-1	BELT SUPPORT SHORT
18	1	AELS-002-04-11-2	BELT SUPPORT SHORT
19	14	AELS-002-04-12	CONNECTING PLATE
20	1	AELS-002-04-13	IDLER PULLEY
21	3	AELS-002-04-14	TENSIONER SHAFT
22	9	AELS-002-04-15	PUSHER LOG
23	1	AELS-002-09-07	COVER
24	3	AELS-002-04-17-1	BELT SUPPORT EXTENSION
25	3	AELS-002-04-17-1	BELT SUPPORT EXTENSION
26	6	AELS-002-04-18	SHAFT SPACER
27	2	AELS-002-04-19	TENSIONER PULLEY
28	8	AELS-002-04-21	SUPPORT PLATE
29	2	STD-002-1002	SUPPORT
30	1	240H100	TIMING BELT
31	1	9240-AT10-50-K6	TIMING BELT
32	6	BB1.0X2.0X.50	1.00 ID X 2.00 OD X .50 WIDE SEALED BALL BEARING
33	6	SNAPRING 2.00	INTERNAL RETAINING RING ø2.00
34	14	TB INSERT NUT	BELT INSERT NUT
35	1	18H100-20 W/KEY	TIMING PULLEY
36	1	18H100-100 W/KEY	TIMING PULLEY
37	2	BRF2-100	BEARING
38	1	AA GEARBX 8-1 1.5K	GEAR BOX
39	1	AA SRVMTR 1500W	SERVOMOTOR

PROJECT 16399

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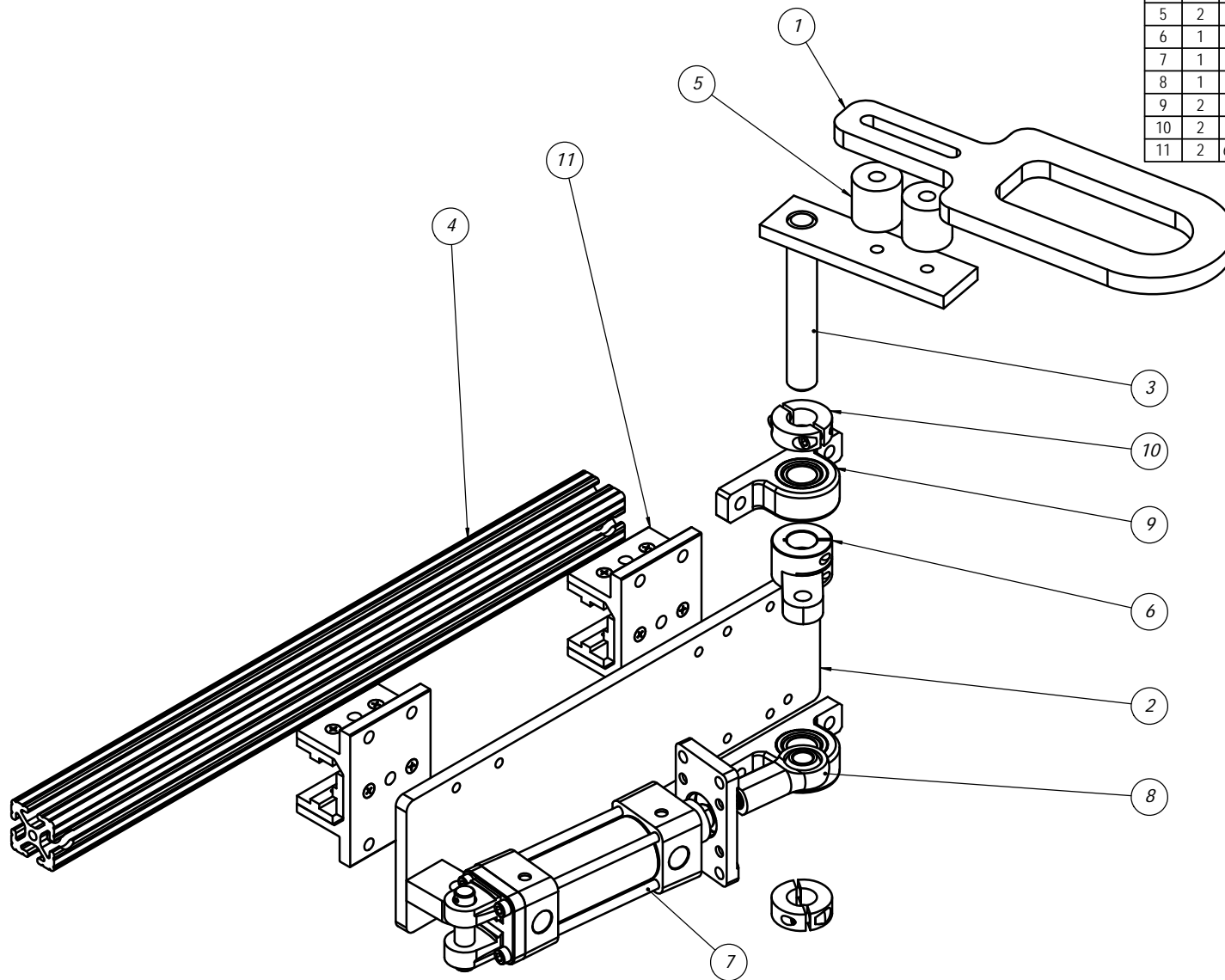
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MIAMI, FLORIDA 33054
305-622-4070

PART NAME		TOP GUIDE	
MACHINE MODEL		BOXXER ALL IN ONE	
DWG NO.		AELS-002-09	REV -
DESIGN	DRAWN	V. Guzzo	DATE 4/28/2017 SHEET 2 OF 2

M101 ORDERS IN PROGRESS\16399 BOXER ALL IN ONE - MEGABRANDS\1-Mechanical\1-Assembly\1



ASSEMBLY BILL OF MATERIALS			
ITEM	QTY.	PartNo	Description
1	1	AELS-002-10-01	MINOR FOLDER
2	1	AELS-002-10-03	SUPPORT PLATE
3	1	AELS-002-10-04	PIVOT
4	1	AELS-002-10-05	FOLDER SLIDE
5	2	AELS-002-10-06	SPACER
6	1	AELS-002-17-06	CRANK
7	1	SACRC15X2 A1D	AIR CYLINDER, 1.5" X 2"
8	1	REF50-20-RH	1/2-20 FEMALE ROD END BRG, RH
9	2	PB3-750-B	BEARING, PILLOW BLOCK, 3/4"
10	2	COL 0.75-2P	3/4" TWO-PIECE CLAMP-ON COLLAR (STEEL)
11	2	6525 SNG LIN BRG 1515	LINEAR BEARING

PROJECT 16399

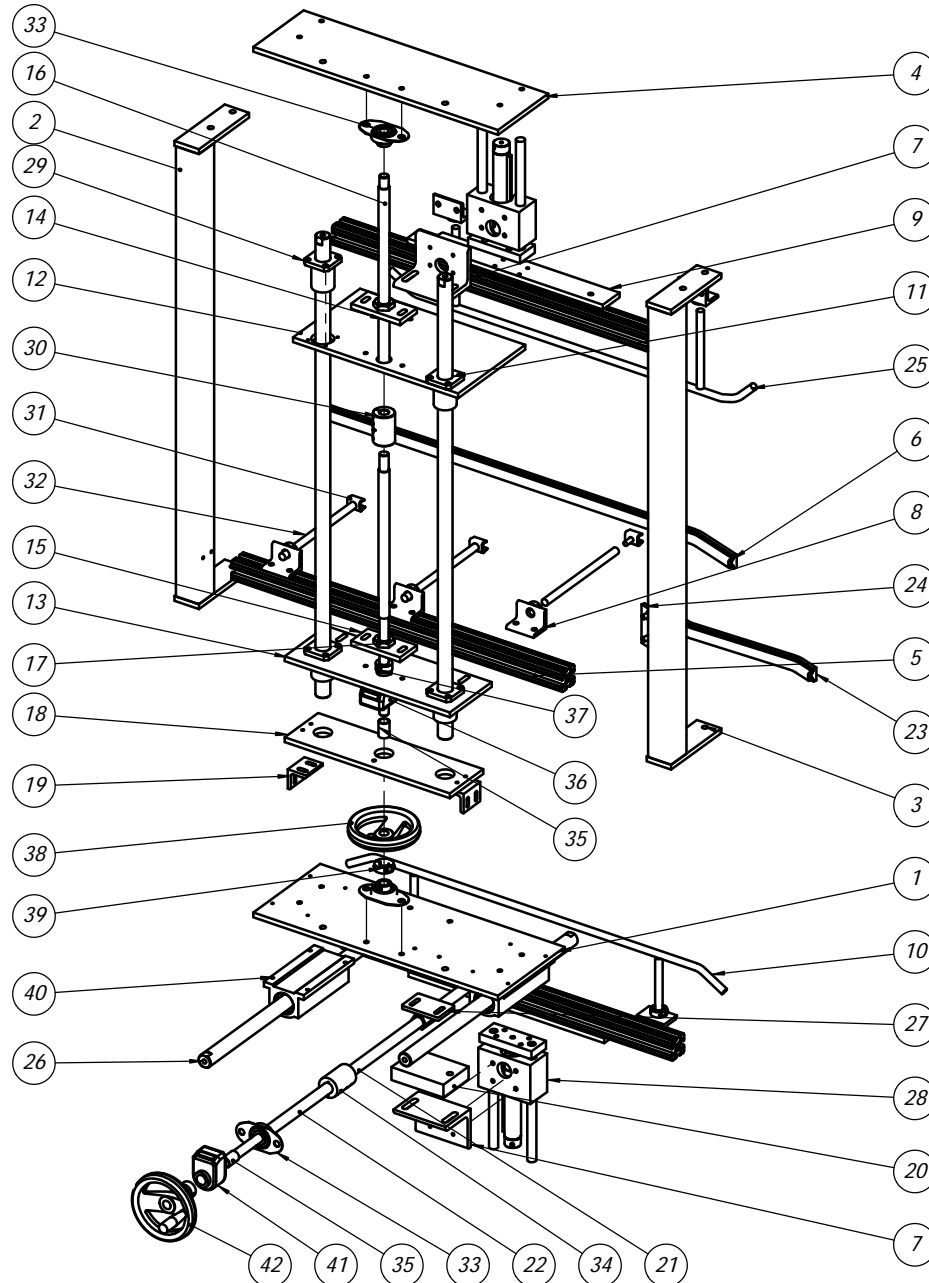
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MIAMI, FLORIDA 33054
305-622-4070

PART NAME		2ND MINOR KICKER	
MACHINE MODEL		BOXXER ALL IN ONE	
DWG NO.		AELS-002-10	
DESIGN	DRAWN	DATE	SHEET
	V.Guzzo	4/28/2017	1 OF 1



ASSEMBLY BILL OF MATERIALS

ITEM	QTY.	PartNo	Description
1	1	AELS-002-11-01	CARRIAGE
2	1	AELS-002-11-02-1	COLUMN
3	1	AELS-002-11-02-2	COLUMN
4	1	AELS-002-11-03	TOP PLATE
5	3	AELS-002-11-04	ADJUSTING BAR
6	1	AELS-002-11-05	TEE GUIDE RAIL
7	2	AELS-002-11-07	CYLINDER BASE
8	7	AELS-002-11-08	BAR SUPPORT
9	2	AELS-002-11-09	MOUNTING PLATE
10	1	AELS-002-11-10	PLOW BAR
11	2	AELS-002-11-11	VERTICAL SHAFT
12	1	AELS-002-11-12	TOP MOVABLE PLATE
13	1	AELS-002-11-13	BOTTOM MOVABLE PLATE
14	1	AELS-002-11-14	TOP ADJUSTING NUT
15	1	AELS-002-11-15	BOTTOM ADJUSTING NUT
16	1	AELS-002-11-16	TOP ADJUSTING SCREW
17	1	AELS-002-11-17	BOTTOM ADJUSTING SCREW
18	1	AELS-002-11-18	DIAL INDICATOR BASE
19	2	AELS-002-11-19	DIAL SUPPORT ANGLE
20	1	AELS-002-11-20	SPACER
21	1	AELS-002-11-21	HORIZONTAL ADJUSTING SCREW
22	1	AELS-002-11-22	HORIZONTAL SHAFT EXTENSION
23	1	AELS-002-11-23	TEE GUIDE RAIL
24	1	AELS-002-11-24	MINOR HOLDER PLATE
25	1	AELS-002-11-25	UPPER PLOW BAR
26	2	AELS-002-08-07	LINEAR SHAFT
27	1	STD-400-1404-1	RAIL ADJUSTMENT BRKT
28	2	TE-094-CMT1	AIR CYLINDER
29	4	U-LHFS1.00	LINEAR BUSHING
30	1	COUP 0.75x.62	COUPLING DIFFERENT DIAM. 5/8" X 3/4"
31	7	VG-018-01 .675LG	CLIP (RAIL MOUNTING) 5/16 UNC X 5/8" LG
32	3	VG-212-12-516	ADJUSTING ROD DIA 1/2" X 12L
33	3	BRF2-062 LIGHT	5/8" 2-BOLT FLANGE BEARING LIGHT
34	1	COUP 0.75 NO KEYWAY	1-PC CLAMP-ON COUPLING W/O KEYWAY 3/4" ID
35	2	RB52 3/4-5/8	BUSHING
36	1	DIAL IND #DWN 1 CW	DIAL INDICATOR
37	2	SETCOL 0.625	SET COLLAR
38	1	HANDW 5" PLAST	HAND WHEEL, Ø4.92" W /PLASTIC HANDLE
39	1	COL 0.62 2P	COLLAR DIA 5/8", 2 PC
40	2	IG-TWN-16	LINEAR BEARING
41	1	DIAL IND 1 CW	DIAL INDICATOR
42	1	HANDW 5" PLAST	HAND WHEEL, Ø4.92" W /PLASTIC HANDLE

PROJECT 16399

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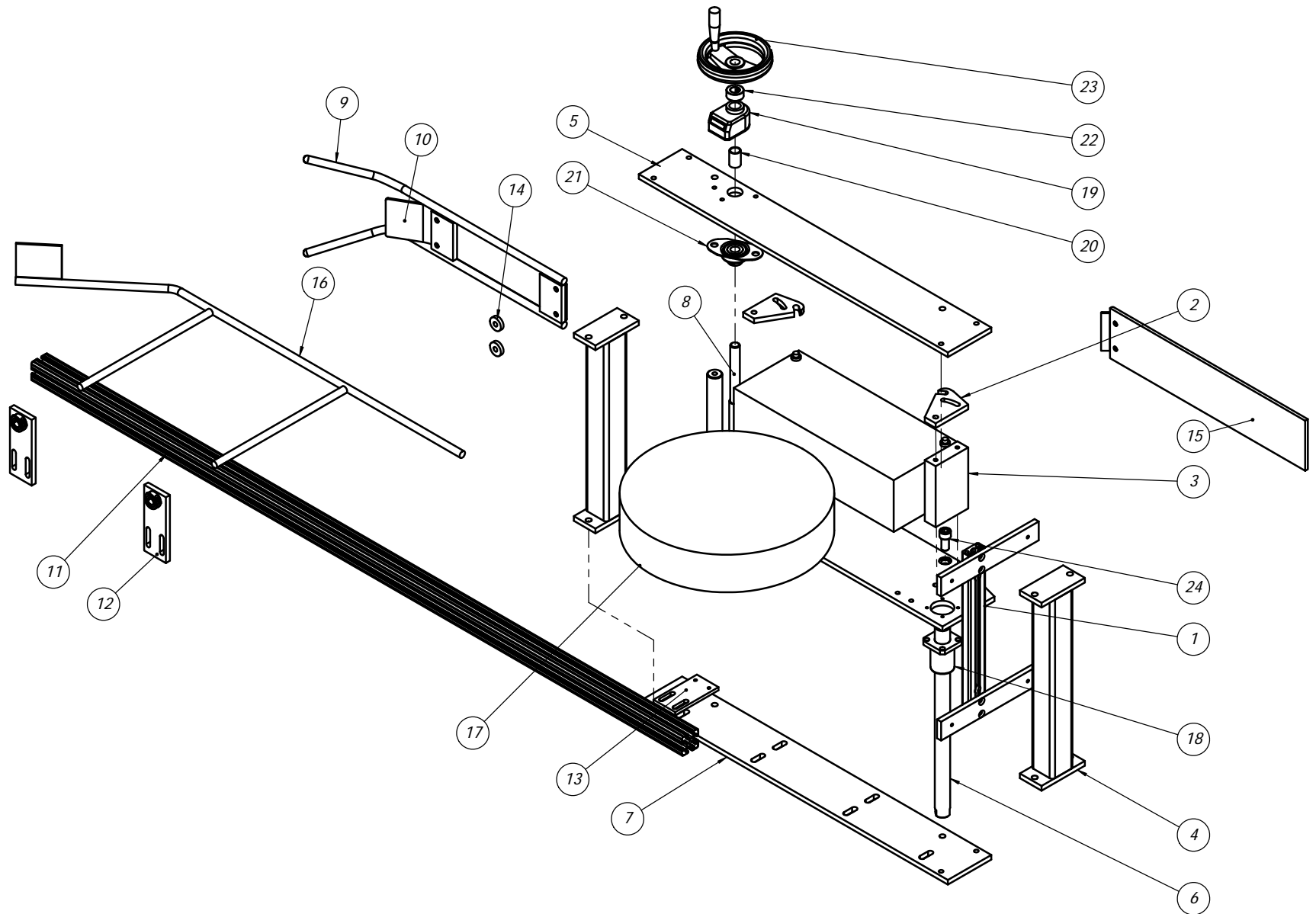
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305-622-4070

PART NAME	PLOW BAR ASSY		
MACHINE MODEL	CASE PACKER		
DWG NO.	AELS-002-11		
DESIGN	DRAWN JFdez	DATE 4/28/2017	SHEET 1 of 1

M101 ORDERS IN PROGRESS 16399 BOXER ALL IN ONE - MEGABRANDS 1-Mechanical1-Assembly1



PROJECT 16399

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305-622-4070

PART NAME		TAPE HEAD SUPPORT RH ASSY		
MACHINE MODEL		CASE PACKER		
DWG NO.		AELS-002-12		
DESIGN	DRAWN	DATE	SHEET	REV
	JFdez	4/28/2017	1 of 2	-

MAI01 ORDERS IN PROGRESS 16399 BOXER ALL IN ONE - MEGA BRANDS 1-Mechanical1-Assembly1

ASSEMBLY BILL OF MATERIALS			
ITEM	QTY.	PartNo	Description
1	1	AELS-002-12-01-2	TAPE HEAD BASE
2	2	AELS-002-12-02	TOP BRACKET
3	2	AELS-002-12-03	SUPPORT BLOCK
4	2	AELS-002-12-04	COLUMN
5	1	AELS-002-12-05-1	TOP PLATE
6	2	AELS-002-12-06	GUIDE SHAFT
7	1	AELS-002-12-07	BOTTOM PLATE
8	1	AELS-002-12-08	ADJUSTING SCREW
9	1	AELS-002-12-09	FOLDING EXTENSION
10	1	AELS-002-12-10	CENTER FOLDER
11	1	AELS-002-12-11	BEAM
12	2	AELS-002-12-12	BAR SUPPORT
13	2	AELS-002-12-13	SUPPORT
14	2	AELS-002-12-14	SPACER
15	1	AELS-002-12-15	REAR GUIDE
16	1	AELS-002-29-08	LARGE PLOW BAR
17	1	DEKKA 23 RH	TAPE HEAD RIGHT HAND
18	2	U-LHFS1.00	LINEAR BUSHING
19	1	DIAL IND #DWN 1 CW	DIAL INDICATOR
20	1	RB52 3/4-5/8	BUSHING
21	1	BRF2-062 LIGHT	5/8" 2-BOLT FLANGE BEARING LIGHT
22	1	SETCOL 0.625	SET COLLAR
23	1	HANDW 5" PLAST	HAND WHEEL, Ø4.92" W /PLASTIC HANDLE
24	2	1/2-13 X 1 SHCS	SOCKET HEAD CAP SCREW
25	1	AELS-002-12-18	PLEXIGLASS SPACER
26	2	AELS-002-12-19	PLEXIGLASS SUPPORT

PROJECT 16399

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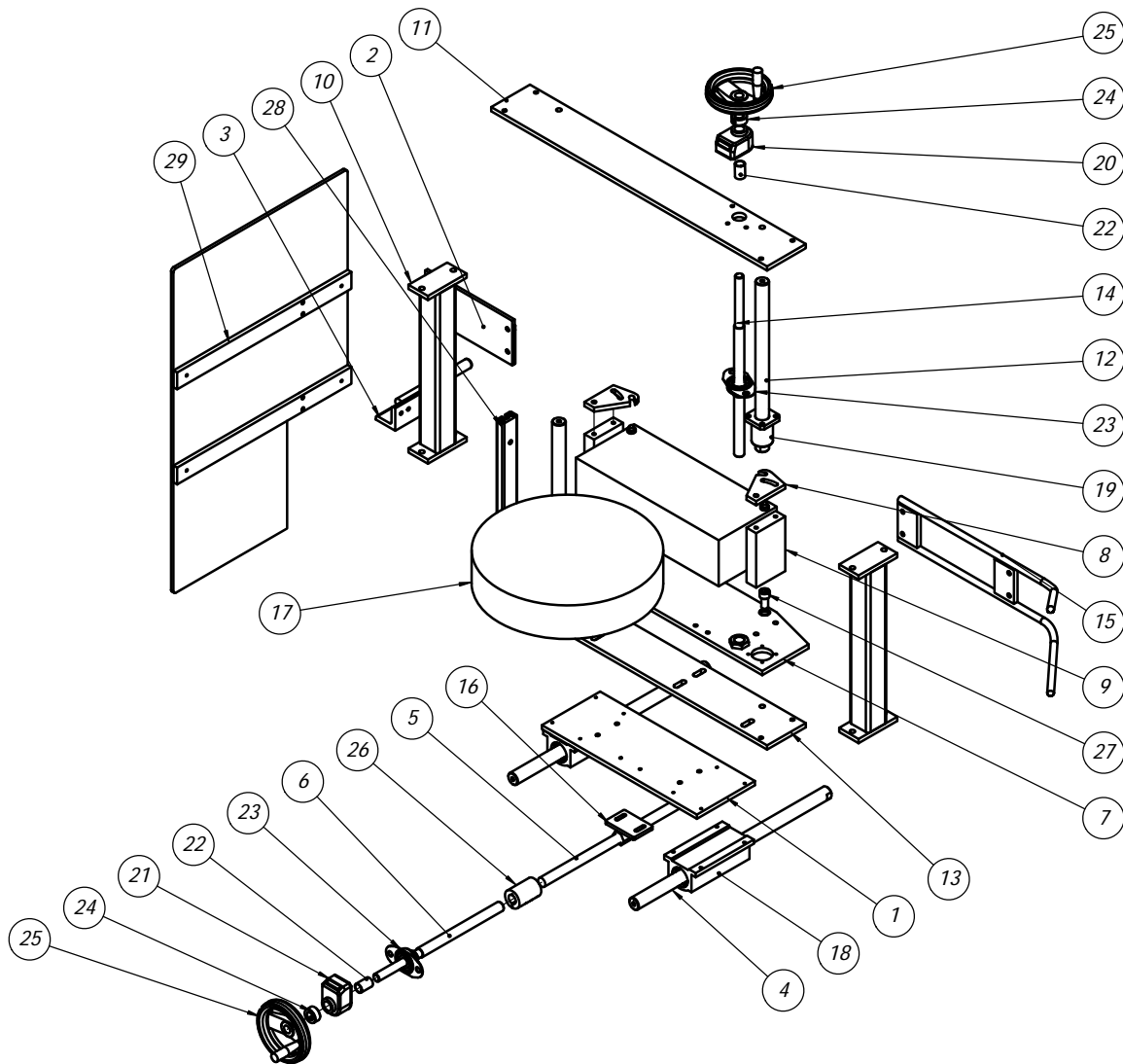
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MIAMI, FLORIDA 33054
305-622-4070

PART NAME		TAPE HEAD SUPPORT RH ASSY	
MACHINE MODEL		CASE PACKER	
DWG NO.	AELS-002-12		REV -
DESIGN	DRAWN JFdez	DATE 4/28/2017	SHEET 2 OF 2



ASSEMBLY BILL OF MATERIALS			
ITEM	QTY.	PartNo	Description
1	1	AELS-002-13-01	CARRIAGE
2	1	AELS-002-13-03	REAR GUIDE
3	1	AELS-002-13-04	SUPPORT BAR
4	2	AELS-002-08-07	LINEAR SHAFT
5	1	AELS-002-11-21	HORIZONTAL ADJUSTING SCREW
6	1	AELS-002-11-22	HORIZONTAL SHAFT EXTENSION
7	1	AELS-002-12-01-1	TAPE HEAD BASE
8	2	AELS-002-12-02	TOP BRACKET
9	2	AELS-002-12-03	SUPPORT BLOCK
10	2	AELS-002-12-04	COLUMN
11	1	AELS-002-12-05-2	TOP PLATE
12	2	AELS-002-12-06	GUIDE SHAFT
13	1	AELS-002-12-07	BOTTOM PLATE
14	1	AELS-002-12-08	ADJUSTING SCREW
15	1	AELS-002-12-09	FOLDING EXTENSION
16	1	STD-400-1404-1	RAIL ADJUSTMENT BRKT
17	1	DEKKA 23 LH	TAPE HEAD LEFT HAND
18	2	IG-TWN-16	LINEAR BEARING
19	2	U-LHFS1.00	LINEAR BUSHING
20	1	DIAL IND #DWN 1 CW	DIAL INDICATOR
21	1	DIAL IND 1 CW	DIAL INDICATOR
22	2	RB52 3/4-5/8	BUSHING
23	2	BRF2-062 LIGHT	5/8\" 2-BOLT FLANGE BEARING LIGHT
24	2	SETCOL 0.625	SET COLLAR
25	2	HANDW 5\" PLAST	HAND WHEEL, Ø4.92\" W / PLASTIC HANDLE
26	1	COUP 0.75 NO KEYWAY	1-PC CLAMP-ON COUPLING W/O KEYWAY 3/4\" ID
27	1	1/2-13 X 1 SHCS	SOCKET HEAD CAP SCREW
28	1	AELS-002-13-05	PLEXIGLASS SPACER
29	2	AELS-002-13-06	PLEXIGLASS SUPPORT

PROPRIETARY PROPERTY

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305-622-4070

PROJECT
16399

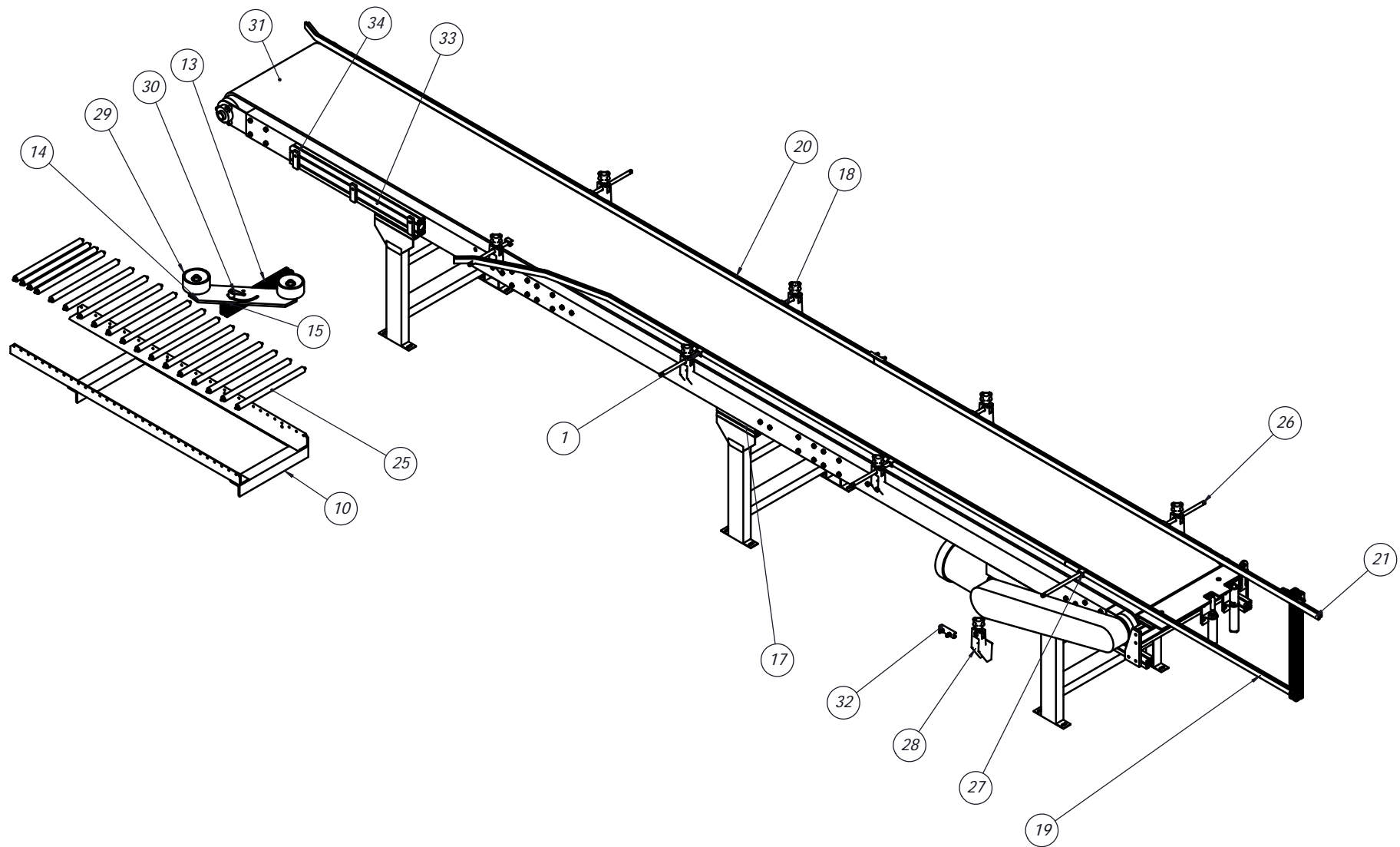
PART NAME
TAPE HEAD SUPPORT LH ASSY

MACHINE MODEL
CASE PACKER

DWG NO.
AELS-002-13

DESIGN
DRAWN JFdez
DATE 5/26/2017
SHEET 1 of 1

M101 ORDERS IN PROGRESS 16399 BOXER ALL IN ONE - MEGABRANDS 1-Mechanical1-Assembly1



PROJECT
16399

PROPRIETARY PROPERTY

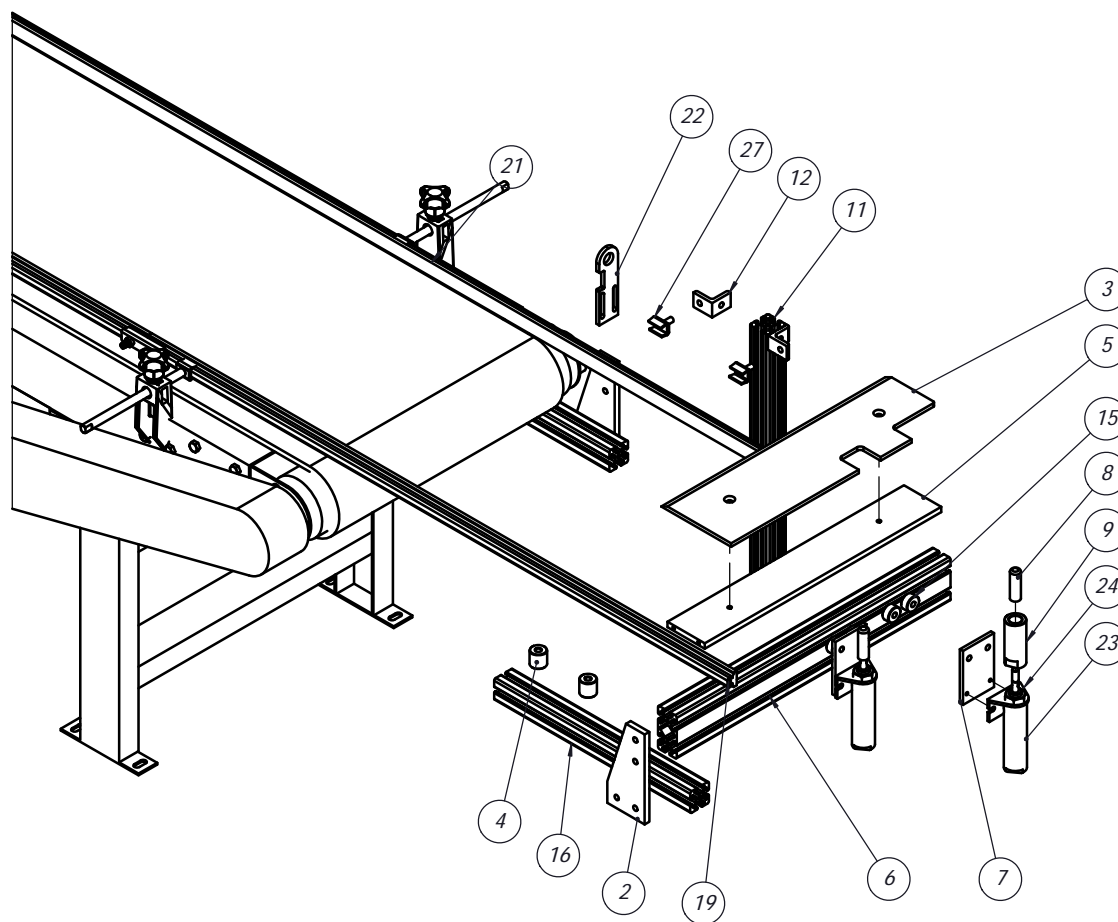
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305-622-4070

PART NAME		INFEED CONVEYOR	
MACHINE MODEL		BOXXER ALL IN ONE	
DWG NO.		AELS-002-14	
DESIGN	DRAWN	DATE	SHEET
	V. Guzzo	6/28/2017	1 of 2

MA101 ORDERS IN PROGRESS\639M BOXER ALL IN ONE - MEGABRANDS\1-Mechanical1-Assembly\1



ASSEMBLY BILL OF MATERIALS			
ITEM	QTY.	PartNo	Description
1	1	AELS-002-14-01	GUIDE
2	2	AELS-002-14-02	MOUNTING BRACKET
3	1	AELS-002-14-03	TRANSFER PLATE
4	4	AELS-002-14-04	SPACER
5	1	AELS-002-14-05	BOTTOM SUPPORT
6	1	AELS-002-14-06	STOP SUPPORT
7	2	AELS-002-14-07	STOP PLATE
8	2	AELS-002-14-08	PLUNGE
9	2	AELS-002-14-09	HUB
10	1	AELS-002-14-11	CONVEYOR FRAME
11	1	AELS-002-14-13	GUIDE STIFFENER
12	2	AELS-002-14-14	GUIDE SUPPORT ANGLE
13	1	AELS-002-14-15	SUPPORT BEAM
14	1	AELS-002-14-16	BUMPER BASE
15	6	AELS-002-14-17	BUMPER SPACER
16	2	AELS-002-14-18	SIDE BOTTOM SUPPORT
17	6	AELS-002-14-19	LEG SPACER
18	2	AELS-002-14-21	MODIFIED ROD
19	1	AELS-002-14-22	OUTSIDE GUIDE END
20	1	AELS-002-14-23	INSIDE GUIDE START
21	1	AELS-002-14-24	INSIDE GUIDE END
22	1	AELS-002-14-25	PHOTOCELL SUPPORT
23	2	SDR-20-1-MB	AIR CYLINDER
24	2	FB-2491	CYLINDER BRACKET
25	18	0.75GR X 13-7/8	3/4" DIA ROLLER X 13-7/8"
26	6	VG-212-8-516	1/2 ADJUSTING ROD X 8" LONG 1X 5/16 UNC
27	10	VG-018-01 .675LG	CLIP (RAIL MOUNTING) 5/16 UNC X 5/8" LG
28	8	VG-210-12	SUPPORT BRACKET
29	2	4X2CRB YELLOW	4" RUBBER ROLLER
30	1	ZCL-3031	LOCK HANDLE 5/16-18
31	1	TA-16'OALX22OAW	CONVEYOR 22" OAW X 16 OAL
32	2	VG-118-03	RAIL SPLICE CLAMP
33	1	AELS-002-14-26	BEAM
34	3	AELS-002-14-27	SPACER

PROJECT
16399

PROPRIETARY PROPERTY

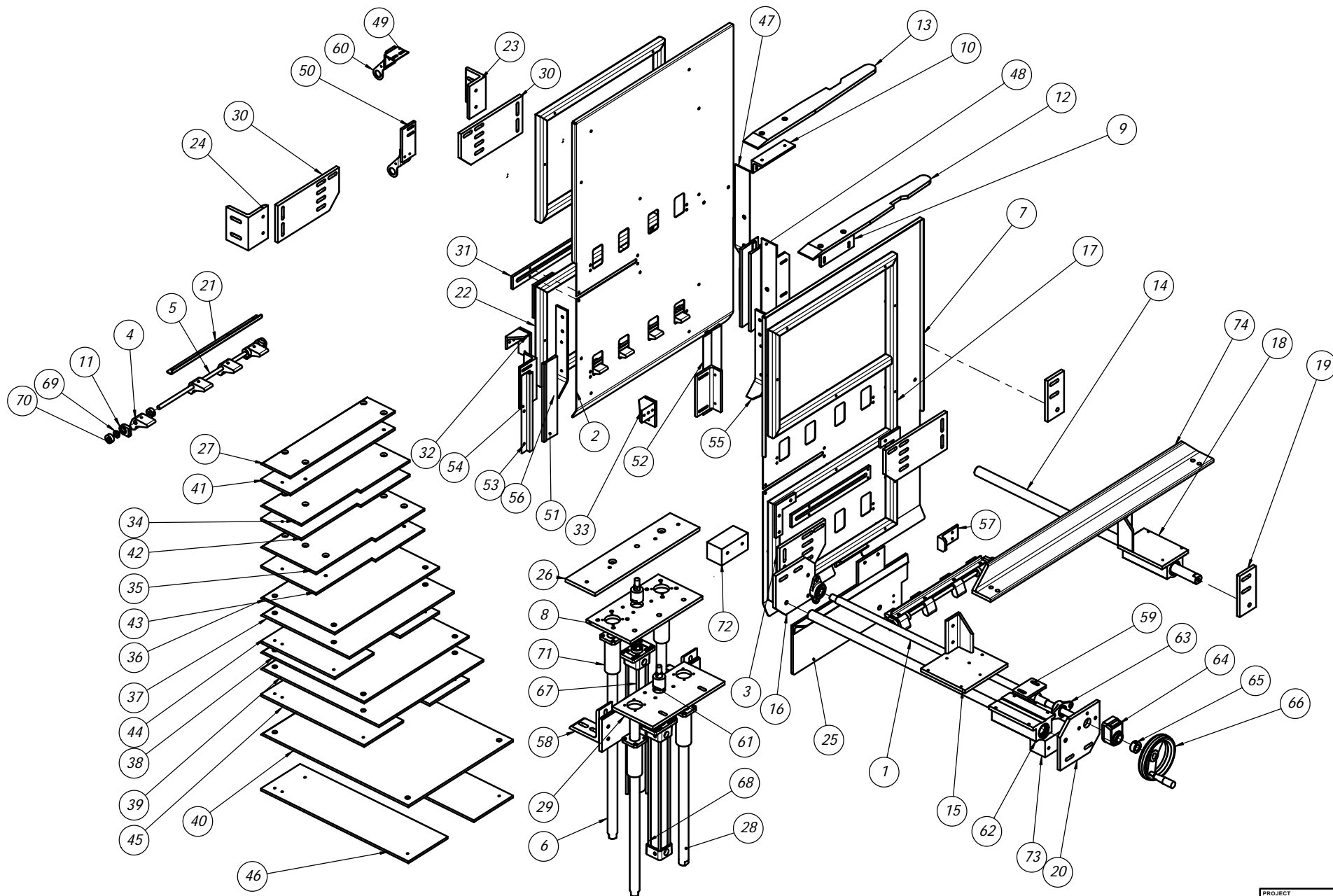
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305-622-4070

PART NAME		INFEEED CONVEYOR	
MACHINE MODEL		BOXSER ALL IN ONE	
DWG NO.		AELS-002-14	
DESIGN	DRAWN	DATE	SHEET
	V.Guzzo	6/28/2017	2 OF 2

MAI01 ORDERS IN PROGRESS\639W BOXER ALL IN ONE - MEGABRANDS\1-Mechanical1-Assembly\1



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305-622-4070

PROJECT 16399

PART NAME		UP STACKING	
MACHINE MODEL		BOXER ALL IN ONE	
DWG NO.		AELS-002-15	
DESIGN	DRAWN	DATE	SHEET
	V. Guzzo	5/26/2017	1 of 2

M101 ORDERS IN PROGRESS\639W BOXER ALL IN ONE - MEGABRANDS\1-Mechanical1-Assembly\1

ASSEMBLY BILL OF MATERIALS				ASSEMBLY BILL OF MATERIALS			
ITEM	QTY.	PartNo	Description	ITEM	QTY.	PartNo	Description
41	1	AELS-002-15-43	BASE PLATE SMALL	1	1	AELS-002-15-01	ADJUSTING SCREW
42	1	AELS-002-15-44	BASE PLATE MEDIUM	2	1	AELS-002-15-02	SIDE BASE PLATE
43	1	AELS-002-15-45	BASE PLATE LARGE	3	1	AELS-002-15-03	FIXED PLATE MOUNT
44	4	AELS-002-15-46	BASE PLATE IV	4	16	AELS-002-15-04	TRAY HOLDER
45	4	AELS-002-15-47	BASE PLATE V	5	4	AELS-002-15-05	TRAY HOLDER AXIS
46	2	AELS-002-15-48	BASE PLATE VI	6	2	AELS-002-15-06	GUIDE ROD
47	1	AELS-002-15-50	BACK GUIDE	7	1	AELS-002-15-07	SIDE ADJSUTABLE PLATE
48	1	AELS-002-15-50-2	BACK GUIDE	8	1	AELS-002-15-08	CYLINDER BASE
49	1	AELS-002-15-52	PHOTOCELL BRACKET	9	1	AELS-002-15-09-1	SUPPORT ANGLE
50	1	AELS-002-15-53	BRACKET	10	1	AELS-002-15-09-2	SUPPORT ANGLE
51	4	AELS-002-15-54	BRUSH	11	8	AELS-002-15-10	TRAY HOLDER PIVOT
52	2	AELS-002-15-55-1	BRUSH HOLDER	12	1	AELS-002-15-12-1	EXTENSION ARM
53	2	AELS-002-15-55-2	BRUSH HOLDER	13	1	AELS-002-15-12-2	EXTENSION ARM
54	4	AELS-002-15-56	BRUSH SUPPORT	14	2	AELS-002-15-14	SIDE GUIDE ROD
55	1	AELS-002-15-57-1	FRONT GUIDE	15	1	AELS-002-15-15	SIDE GUIDE ARM
56	1	AELS-002-15-57-2	FRONT GUIDE	16	1	AELS-002-15-16	BEARING SUPPORT
57	1	AELS-002-15-58	PHOTOCELL BRACKET	17	1	AELS-002-15-17	SIDE PLATE FRAME
58	2	AELS-002-15-59	STIFFENER ANGLE	18	1	AELS-002-15-18	GUIDE RAIL 2
59	1	STD-400-1404-1	RAIL ADJUSTMENT BRKT	19	2	AELS-002-15-19	BEARING SUPPORT
60	2	STD-002-1003	OFFSET RIGHT HAND MOUNTING BRACKET	20	1	AELS-002-15-20	BEARING SUPPORT 3
61	2	RA1/2-20 (MC)	CYLINDER ROD ALIGNER 1/2-20	21	4	AELS-002-15-21	TRAY HOLDER STOP
62	2	TWN-16	LINEAR BEARING	22	1	AELS-002-15-23	SIDE PLATE FRAME
63	2	HF3-625-B	SELF ALIGNING BRONZE BEARING	23	1	AELS-002-15-24	MOUNTING ANGLE
64	1	DIAL IND 1 CW	DIAL INDICATOR	24	1	AELS-002-15-25	MOUNTING ANGLE
65	1	SETCOL 0.625	SET COLLAR	25	1	AELS-002-15-26	PRODUCT STOP PLATE
66	1	HANDW 5" PLAST	HAND WHEEL, Ø4.92" W /PLASTIC HANDLE	26	1	AELS-002-15-27	BASE PLATE
67	1	SACFF15X14	AIR CYLINDER, 1-1/2" X 14", FRONT FLANGE	27	1	AELS-002-15-28	SLIDE PLATE
68	1	SACFF15X12	AIR CYLINDER, 1-1/2" X 12", FRONT FLANGE	28	2	AELS-002-15-30	GUIDE ROD
69	8	038-050-050FLBU	BRONZE BEARING	29	1	AELS-002-15-31	CYLINDER BASE
70	16	COL 0.38.1P-SLT	ONE-PIECE 3/8 CLAMP-ON COLLAR STEEL	30	3	AELS-002-15-32-1	FIXED PLATE MOUNT
71	4	U-LHFSW1.00	FLANGED LINER BUSHING DOUBLE, 1"	31	2	AELS-002-15-33	SLOT GUIDE
72	1	AELS-002-15-60	SPACER	32	1	AELS-002-15-35-1	FRONT GUIDE ANGLE
73	1	AELS-002-15-61	SPACER	33	1	AELS-002-15-35-2	FRONT GUIDE ANGLE
74	1	AELS-002-15-62	STIFFENER	34	1	AELS-002-15-36	SLIDE PLATE MEDIUM
				35	1	AELS-002-15-37	SLIDE PLATE LARGE
				36	1	AELS-002-15-38	SLIDE PLATE IV
				37	1	AELS-002-15-39	SLIDE PLATE V
				38	1	AELS-002-15-40	SLIDE PLATE VI
				39	1	AELS-002-15-41	SLIDE PLATE VII
				40	1	AELS-002-15-42	SLIDE PLATE VIII

PROJECT 16399

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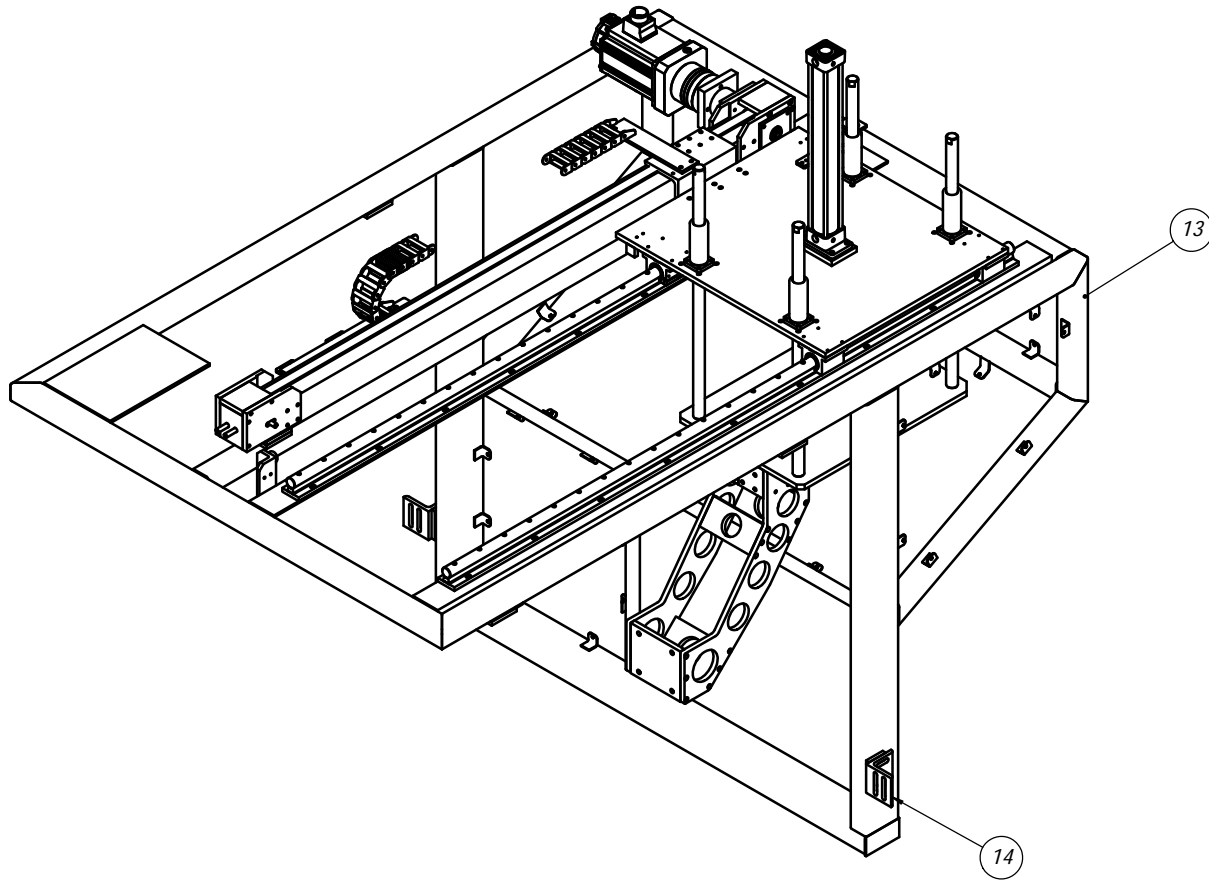
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305-622-4070

PART NAME		UP STACKING	
MACHINE MODEL		BOXSER ALL IN ONE	
DWG NO.		AELS-002-15	
DESIGN		REV -	
DRAWN		V.Guzzo	
DATE		5/26/2017	
SHEET		2 of 2	

MA101 ORDERS IN PROGRESS\16399 BOXER ALL IN ONE - MEGABRANDS\1-Mechanical1-Assembly\1



ASSEMBLY BILL OF MATERIALS

ITEM	QTY.	PartNo	Description
1	2	AELS-002-16-01	ARM
2	1	AELS-002-16-02	JOINT PLATE-1
3	1	AELS-002-16-03	JOINT PLATE-2
4	4	AELS-002-16-04	GUIDE ROD
5	1	AELS-002-16-05	MTG ANGLE
6	1	AELS-002-16-06	PLATE
7	1	AELS-002-16-07	PUSHER CYLINDER MTG BASE
8	2	AELS-002-16-08	JOINT PLATE-3
9	1	AELS-002-16-09-1	JOINT ANGLE
10	1	AELS-002-16-09-2	JOINT ANGLE
11	2	AELS-002-16-10	GUIDE RAIL BASE
12	1	AELS-002-16-11	SIDE ANGLE
13	1	AELS-002-16-12	FRAME
14	2	AELS-002-16-13	SUPPORT ANGLE FRAME
15	1	AELS-002-16-15	PLATE-1
16	1	AELS-002-16-16	PLATE-2
17	1	AELS-002-16-17	PLATE-3
18	1	AELS-002-16-18	PLATE-4
19	1	AELS-002-16-19	PLATE-5
20	1	AELS-002-16-20	PLATE-6
21	1	AELS-002-16-21	PLATE-7
22	1	AELS-002-16-22	PLATE-8
23	1	AELS-002-16-23	PLATE-9
24	1	AELS-002-16-24	PLATE-10
25	1	AELS-002-16-25	PLATE-11
26	1	AELS-002-16-26	PLATE-12
27	1	AELS-002-16-27	PLATE-13
28	1	AELS-002-16-28	PLATE-14
29	2	AELS-002-16-29	SHOCK STRIKER
30	1	AELS-002-16-30-1	BUMPER SUPPORT
31	1	AELS-002-16-30-2	BUMPER SUPPORT
32	1	AELS-002-16-31	HOME PLATE
33	1	AELS-002-16-32	HOME PLATE ANGLE
34	1	AELS-002-16-33	CYLINDER SPACER
35	1	AELS-002-18-24	BACKUP CLAMP ANGLE
36	4	SPB-16-OPN	1" SUPER BALL BUSHING PILLOW BLOCK OPEN
37	1	SACFF2X16	AIR CYLINDER, 2" X 16", FRONT FLANGE
38	4	U-LHFSW1.00	FLANGED LINER BUSHING DOUBLE, 1"
39	1	RA1/2-20 (MC)	CYLINDER ROD ALIGNER 1/2-20
40	2	LSR16-PD CTL x 68	ø1" 60 CASE THOMPSON LINEAR RACE X 68"
41	2	HAMMER HEAD 1.0 (GRAY)	BUMPER

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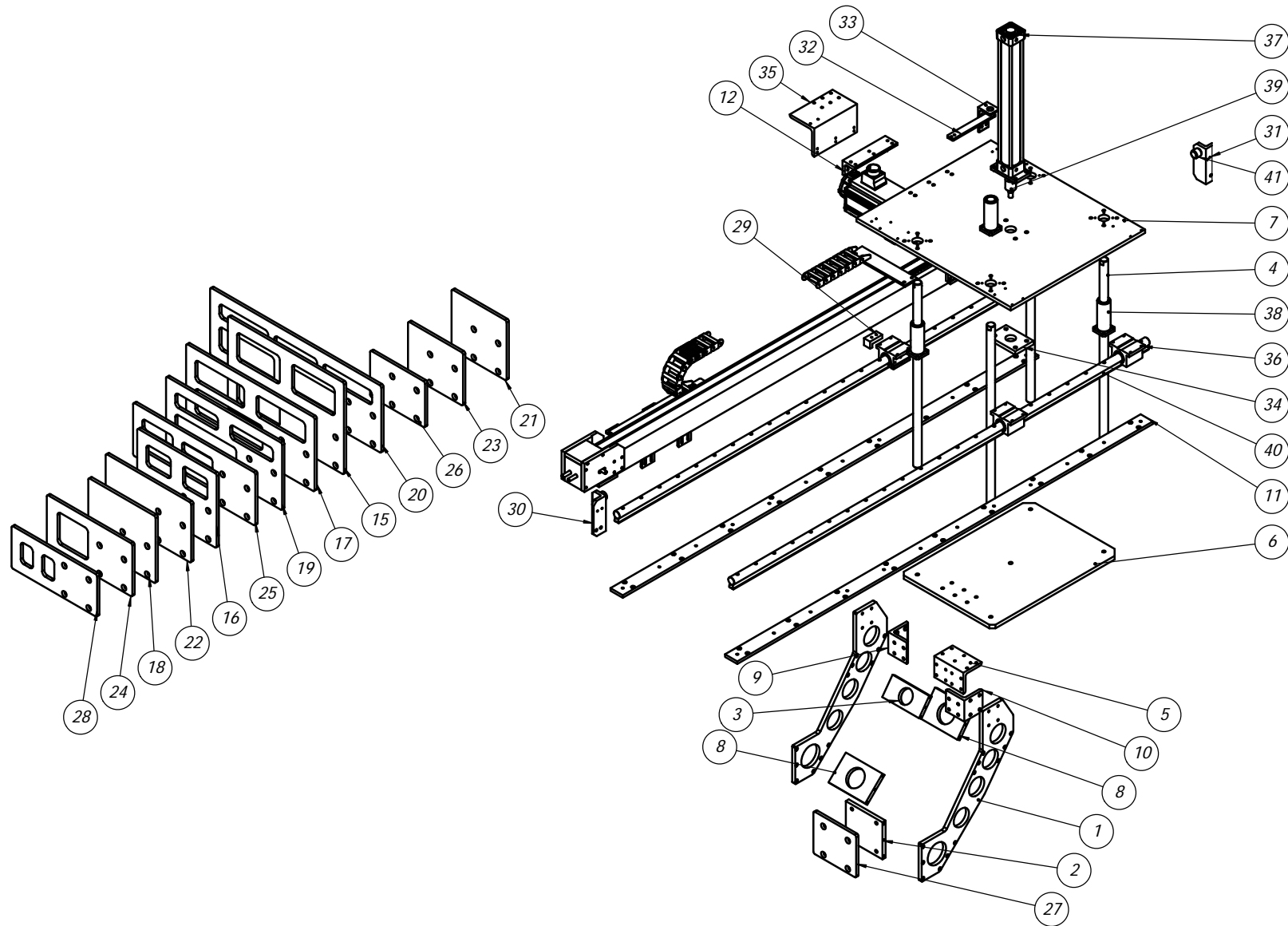
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305-622-4070

PROJECT
16399

PART NAME		SIDE PUSHER	
MACHINE MODEL		BOXSER ALL IN ONE	
DWG NO.		AELS-002-16	
DESIGN	DRAWN	DATE	SHEET
	V. Guzzo	5/2/2017	1 OF 2



PROJECT 16399

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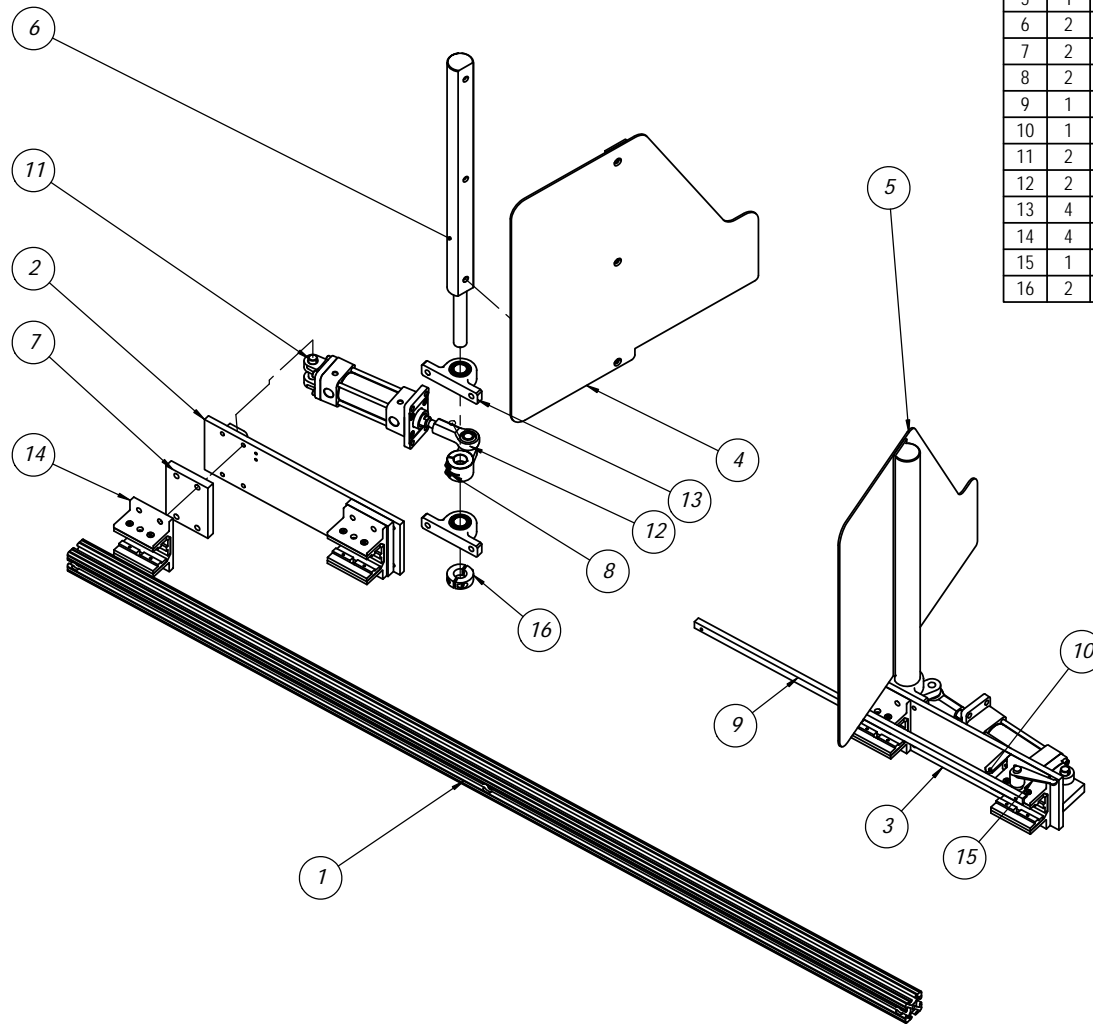
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MIAMI, FLORIDA 33054
305-622-4070

PART NAME		SIDE PUSHER	
MACHINE MODEL		BOXXER ALL IN ONE	
DWG NO.		AELS-002-16	
DESIGN	DRAWN	DATE	SHEET
	V. Guzzo	5/2/2017	2 of 2

M101 ORDERS IN PROGRESS 16399 BOXER ALL IN ONE - MEGA BRANDS 1-Mechanical1-Assembly1



ASSEMBLY BILL OF MATERIALS			
ITEM	QTY.	PartNo	Description
1	1	AELS-002-17-01	SUPPORT BEAM
2	1	AELS-002-17-02-1	FIX BEARING SUPPORT
3	1	AELS-002-17-02-2	FIX BEARING SUPPORT
4	1	AELS-002-17-03-1	FLAP OPENER
5	1	AELS-002-17-03-2	FLAP OPENER
6	2	AELS-002-17-04	SHAFT
7	2	AELS-002-17-05	SPACER
8	2	AELS-002-17-06	CRANK
9	1	AELS-002-17-07	SCALE ANGLE
10	1	AELS-002-17-08	SCALE INDICATOR
11	2	SACRC15X2 A1D	AIR CYLINDER, 1.5" X 2"
12	2	REF50-20-RH	1/2-20 FEMALE ROD END BRG, RH
13	4	PB3-750-B	BEARING, PILLOW BLOCK, 3/4"
14	4	6525 SNG LIN BRG 1515	LINEAR BEARING
15	1	ZCL-3031	LOCK HANDLE 5/16-18
16	2	COL 0.75-2P	3/4" TWO-PIECE CLAMP-ON COLLAR (STEEL)

PROPRIETARY PROPERTY

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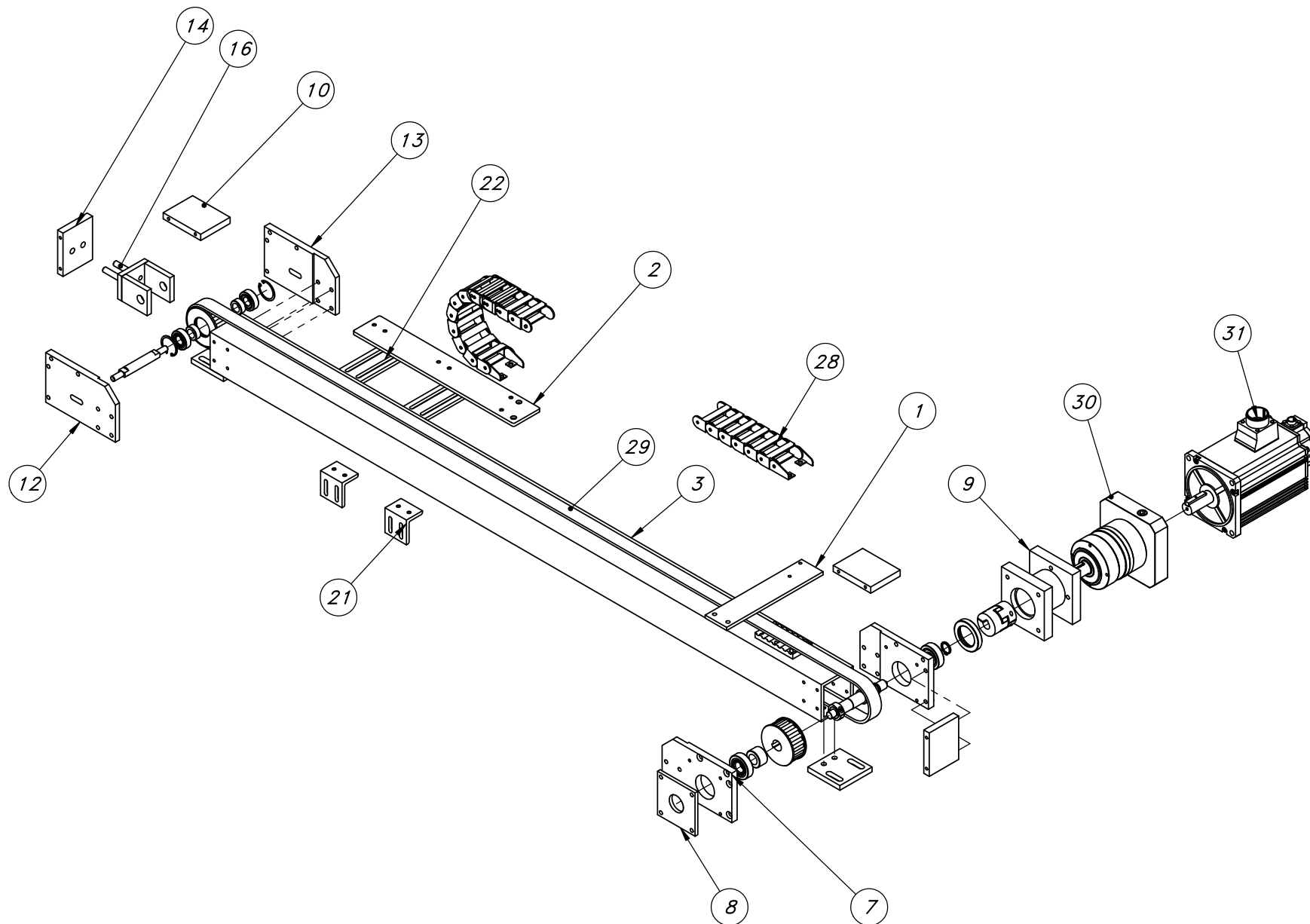
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305-622-4070

PROJECT
16399

PART NAME		FLAP OPENER ASSY	
MACHINE MODEL		CASE PACKER	
DWG NO.		AELS-002-17	
DESIGN	DRAWN	DATE	SHEET
	JFdez	5/2/2017	1 OF 1

M101 ORDERS IN PROGRESS 16399 BOXER ALL IN ONE - MEGABRANDS 1-Mechanical1-Assembly1



PROJECT 16399

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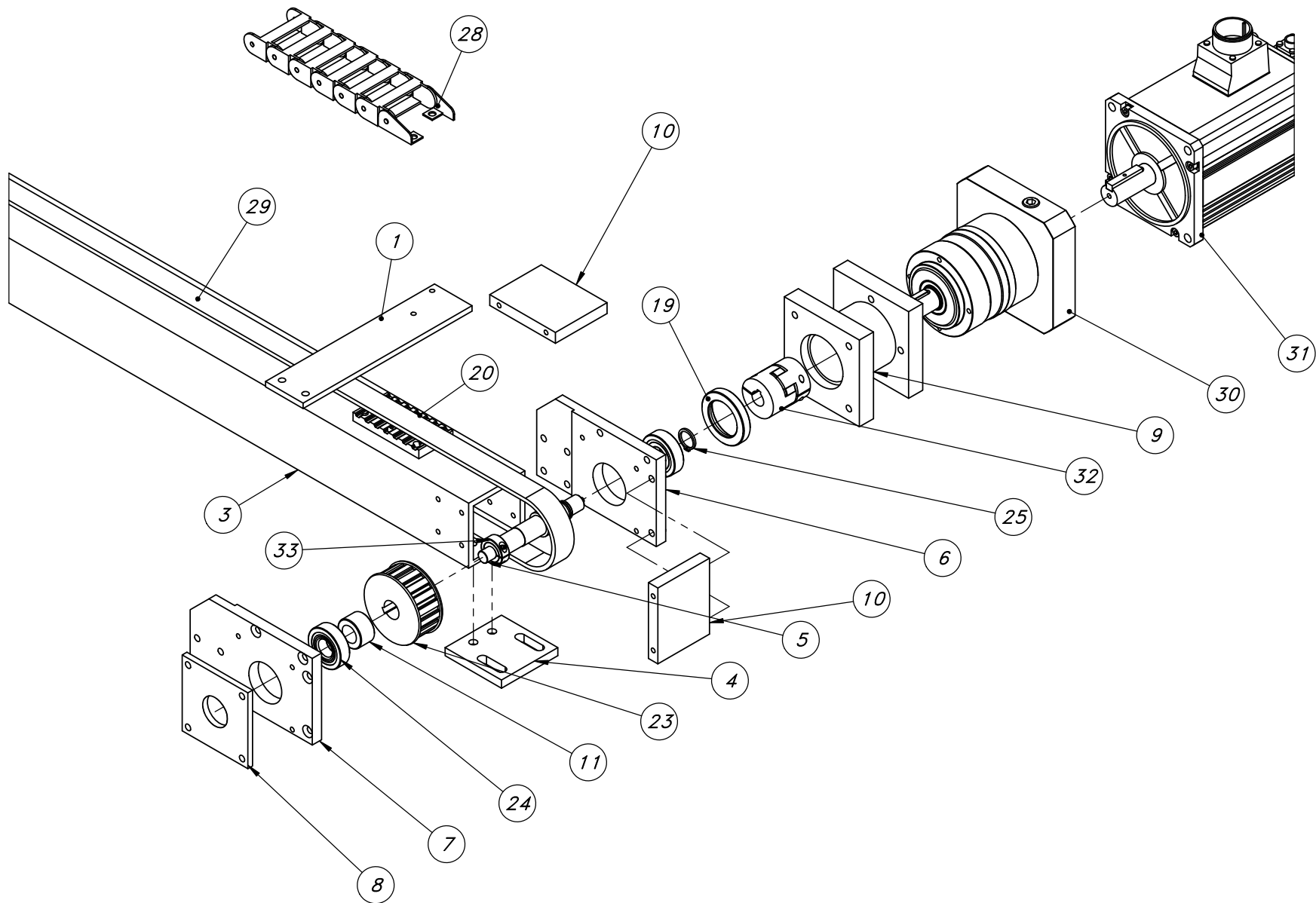
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PART NAME		TOP TRANSFER ASSEMBLY	
MACHINE MODEL		BOXER ALL IN ONE	
DWG NO.		AELS-002-18	
DESIGN	DRAWN	DATE	SHEET
	JFdez	5/2/2017	1 of 3



PROJECT 16399

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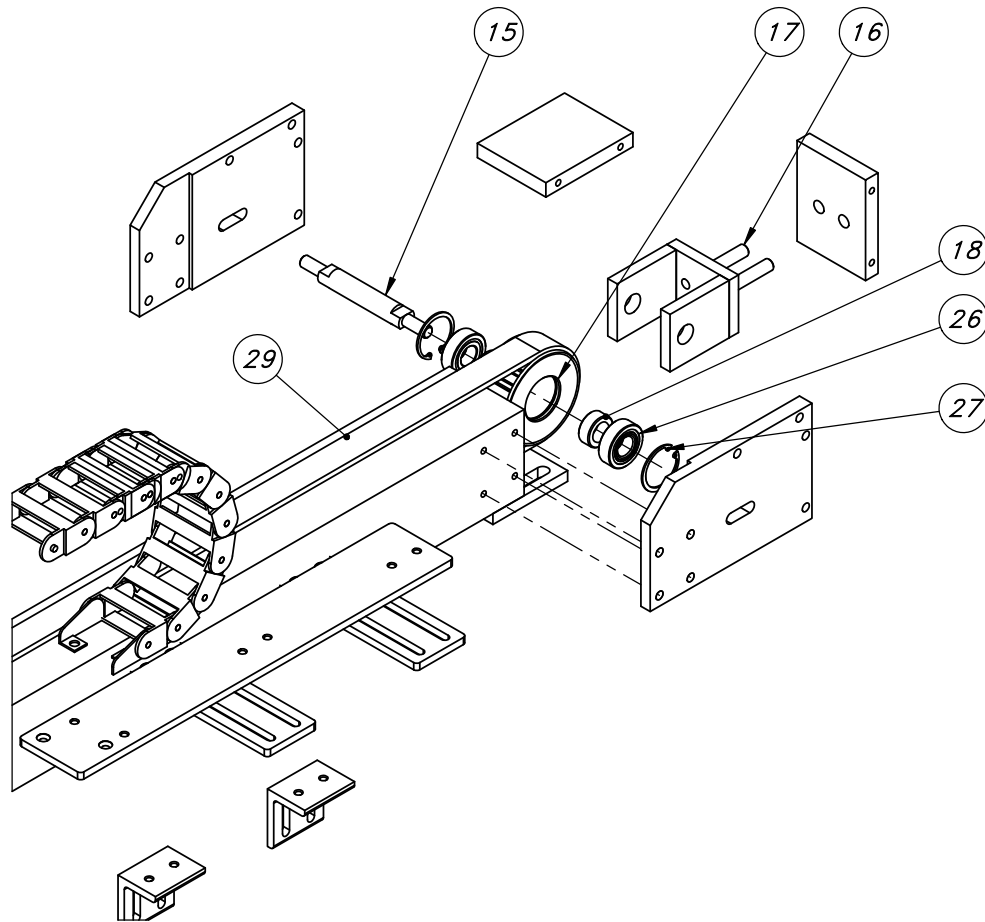
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MIAMI, FLORIDA 33054
305-622-4070

PART NAME		TOP TRANSFER ASSEMBLY	
MACHINE MODEL		BOXER ALL IN ONE	
DWG NO.		AELS-002-18	
DESIGN	DRAWN	DATE	SHEET
	JFdez	5/2/2017	2 OF 3

MA101 ORDERS IN PROGRESS\639W BOXER ALL IN ONE - MEGABRANDS\1-Mechanical1-Assembly\1



ASSEMBLY BILL OF MATERIALS

ITEM	HE AD 1/Q TY.	PartNo	Description
1	1	AELS-002-18-15	CABLE CARRIER PLATE
2	1	AELS-002-18-16	CABLE CARRIER END PLATE
3	1	AELS-002-18-17	FRAME TUBE
4	2	AELS-002-18-18	SUPPORT PLATE
5	1	AELS-002-18-19	DRIVE SHAFT
6	1	AELS-002-18-20-1	SIDE MOTOR PLATE
7	1	AELS-002-18-20-2	SIDE MOTOR PLATE
8	1	AELS-002-18-21	END CAP
9	1	AELS-002-18-22	MOTOR SPACER
10	3	AELS-002-18-23	DRIVE VERTICAL SPACER
11	1	AELS-002-18-25	SHAFT SPACER
12	1	AELS-002-18-26-1	IDLER SIDE PLATE
13	1	AELS-002-18-26-2	IDLER SIDE PLATE
14	1	AELS-002-18-27	IDLER END PLATE
15	1	AELS-002-18-28	ILDER SHAFT
16	1	AELS-002-18-29	TENSIONER
17	1	AELS-002-18-30	IDLER PULLEY MODIFICATION
18	2	AELS-002-18-31	IDLER SPACER
19	1	AELS-002-18-32	FRONT WASHER
20	1	AELS-002-18-33	CLAMP MODIFICATION
21	2	AELS-002-18-34-1	END PLATE SUPPORT ANGLE
22	2	AELS-002-18-34-2	END PLATE SUPPORT
23	1	18H100-20 W/KEY	TIMING PULLEY
24	2	BB075X1.75.50	BALL BEARING
25	1	SNAPRING 3/4	RETAINING RING EXTERNAL 3/4
26	2	BB0.62X1.375.438	BALL BEARING
27	2	SNAPRING INNER 1-3/8	RETAINING RING INTERNAL 1-3/8
28	1	H&C Cable Through	CABLE CARRIER
29	1	BELTING H100	H Urethane Belting H Trade Size, 1/2" Pitch, 1" Width X 12 FT
30	1	AA GEARBX 4-1 3K	GEAR REDUCER, 4:1 FOR OMRON 3KW SERVO MOTOR
31	1	AA SRVMTR 3000W BRK	MOTOR
32	1	FLEX COUP HUB 22-5/8 ZB RW	ELASTOMER COUPLING WITH CLAMPING HUB 22mm X 5/8
33	1	COL THREADED 1/2-20	COLLAR 1-PC CLAMP-ON 1/2-20

PROJECT 16399

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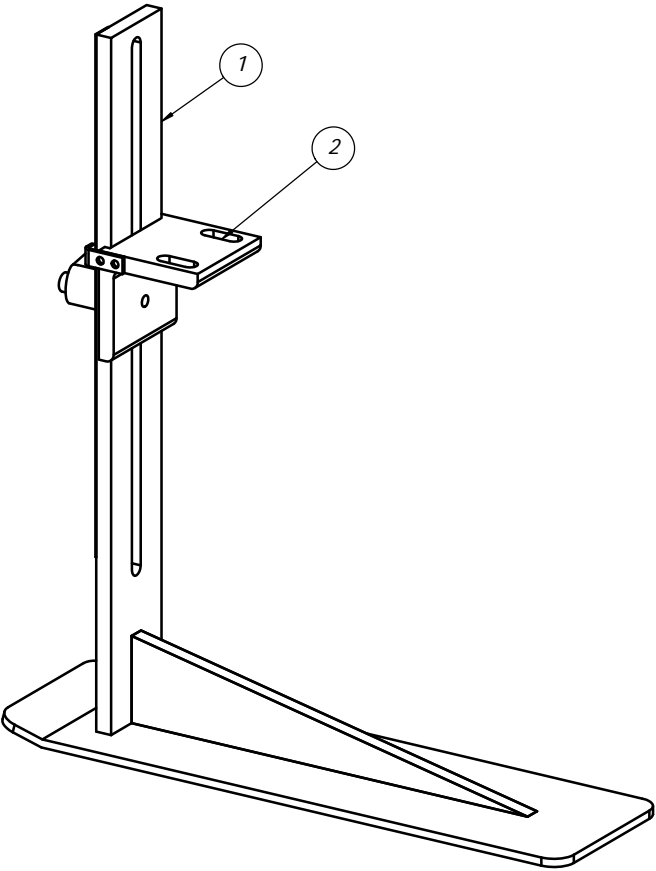
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MIAMI, FLORIDA 33054
305-622-4070

PART NAME		TOP TRANSFER ASSEMBLY	
MACHINE MODEL		BOXSER ALL IN ONE	
DWG NO.		AELS-002-18	
DESIGN	DRAWN	DATE	SHEET
	JFdez	5/2/2017	3 OF 3

MA101 ORDERS IN PROGRESS 16399 BOXER ALL IN ONE - MEGA BRANDS 1-Mechanical1-Assembly1

ASSEMBLY BILL OF MATERIALS			
ITEM	QTY.	PartNo	Description
1	1	AELS-002-20-03	ADJUSTING BAR
2	1	AELS-002-20-05	ANGLE
3	1	STD-002-1052 -1 / -2	LH AND RH SCALE INDICATOR
4	1	ZCL-3031	LOCK HANDLE 5/16-18



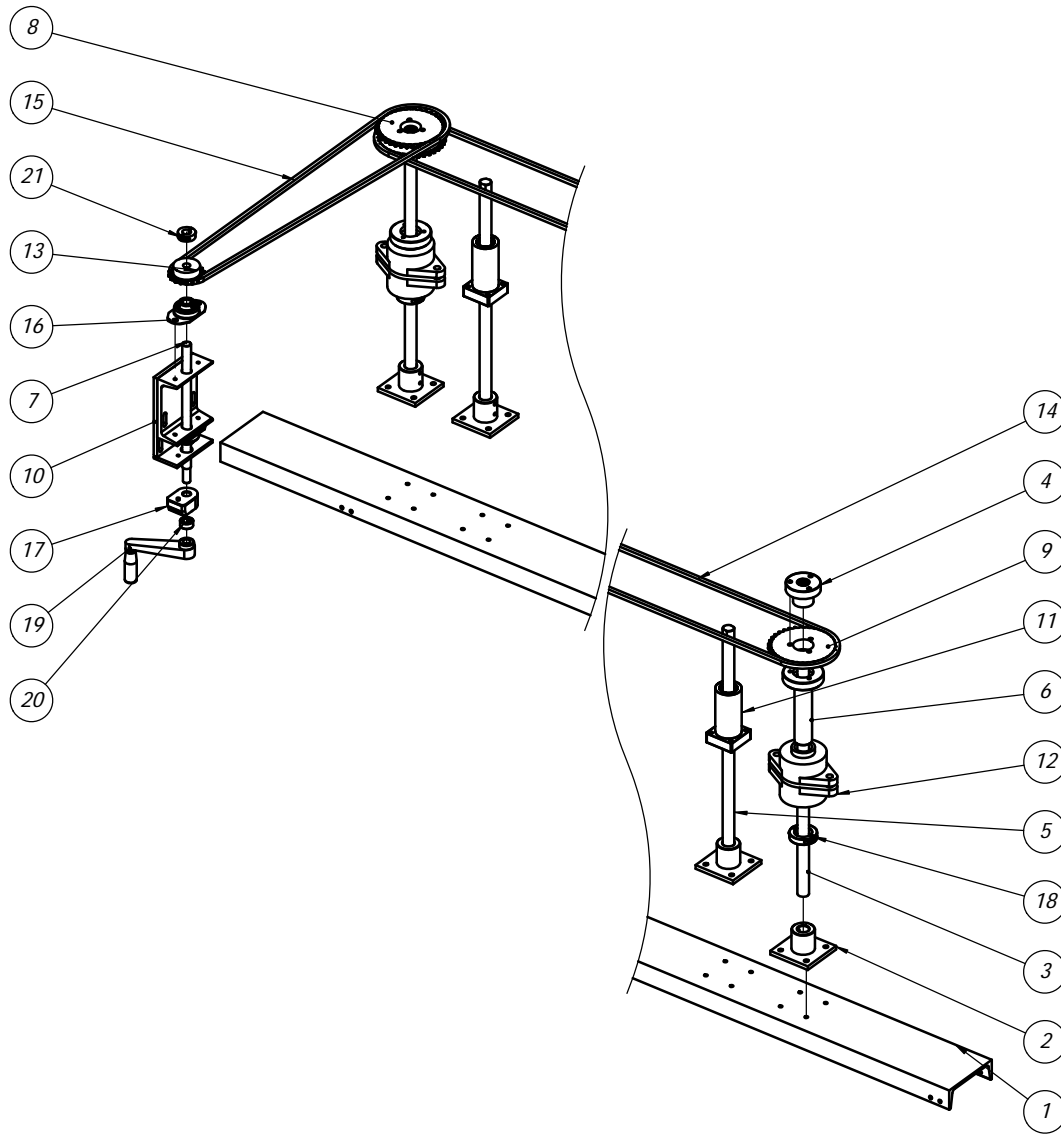
PROJECT 16399

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305-622-4070

PART NAME		PRODUCT HOLD	
MACHINE MODEL		BOXXER ALL IN ONE	
DWG NO.		AELS-002-20	
DESIGN		DRAWN	REV
		V. Guzzo	-
		DATE	SHEET
		4/3/2017	1 OF 1



ASSEMBLY BILL OF MATERIALS			
ITEM	QTY.	PartNo	Description
1	1	AELS-002-21-01	SUPPORT BEAM
2	4	AELS-002-21-02	SUPPORT BRACKET
3	2	AELS-002-21-03	ADJUSTING SCREW
4	2	AELS-002-21-04	ADJUSTING NUT
5	2	AELS-002-21-05	GUIDE SHAFT
6	2	AELS-002-21-06	HUB
7	1	AELS-002-21-07	DRIVE SHAFT
8	1	AELS-002-21-08	DRIVEN SPROCKET
9	2	AELS-002-21-09	ADJUSTING SPROCKET
10	1	AELS-002-21-10	BRACKET
11	2	SSUTFB-16	LINEAR BEARING
12	4	BRF2-150	BEARING
13	1	40B18	40B18 SPROCKET X BORE W/ KEYWAY
14	1	40 CHAIN	#40 CHAIN X 279.5 (559 LINKS)
15	1	40 CHAIN	#40 CHAIN X 72.5 (145 LINKS)
16	2	BRF2-075 LIGHT	3/4" 2-BOLT FLANGE BEARING LIGHT
17	1	DIAL IND 2 CCW	DIAL INDICATOR
18	2	COL 1.50 2PC	COLLAR DIA 1-1/2" 2 PIECES
19	1	5BB96	CRANK HANDLE WITH 5/8 DIAMETER BORE
20	1	SETCOL 0.625	SET COLLAR
21	1	COL 0.75-2P	3/4" TWO-PIECE CLAMP-ON COLLAR (STEEL)

PROJECT 16399

PROPRIETARY PROPERTY

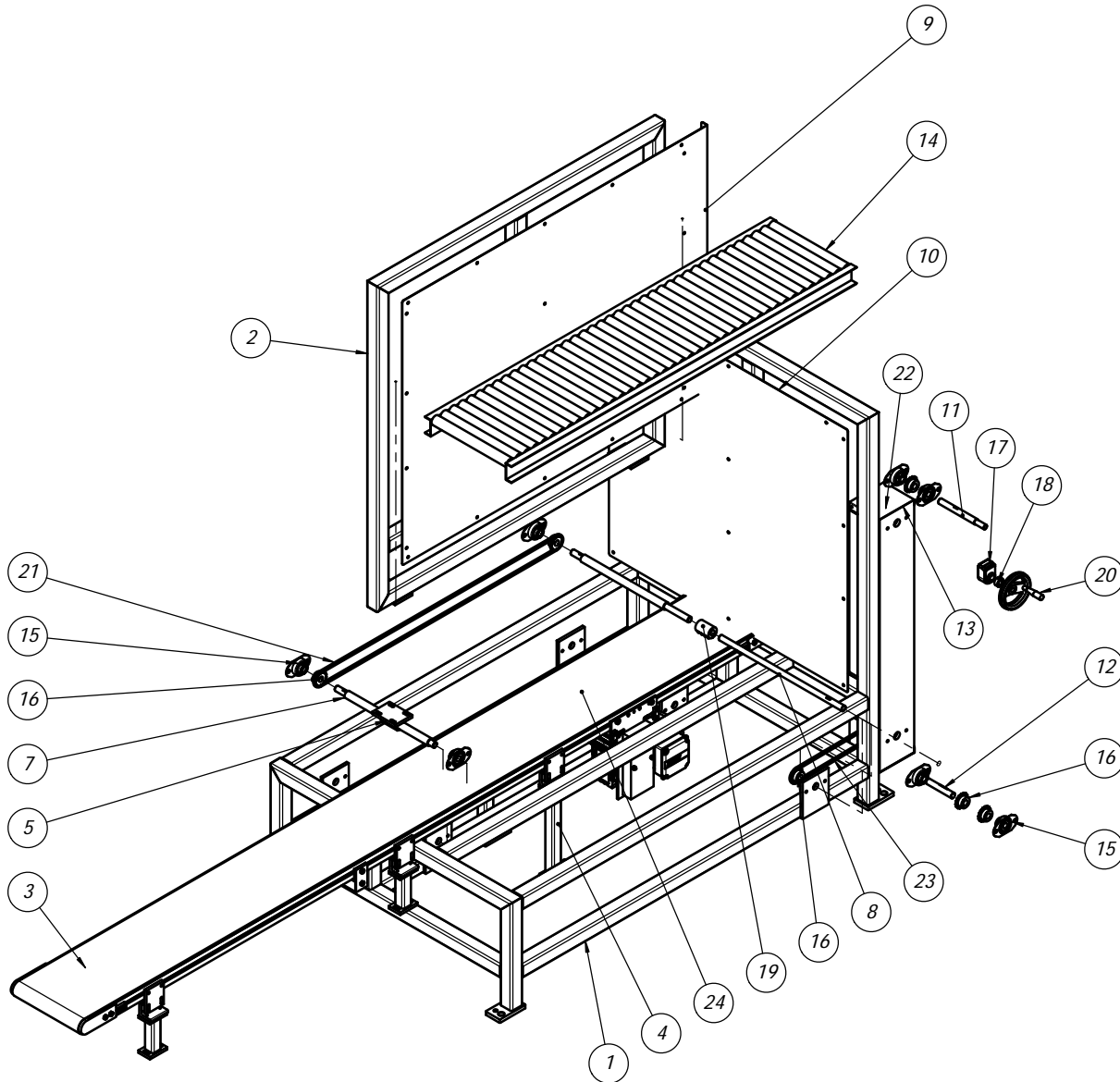
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305-622-4070

PART NAME		TOP GUIDE ADJUSTMENT	
MACHINE MODEL		CASE PACKER	
DWG NO.		AELS-002-21	
DESIGN	DRAWN	DATE	SHEET
	JFdez	5/2/2017	1 OF 1

MAI01 ORDERS IN PROGRESS\639W BOXER ALL IN ONE - MEGABRANDS\1-Mechanical1-Assembly\1



ASSEMBLY BILL OF MATERIALS			
ITEM	QTY.	PartNo	Description
1	1	AELS-002-22-01	HOPPER CONVEYOR FRAME
2	1	AELS-002-22-02	MOVABLE FRAME
3	4	AELS-002-22-03	SHORT LEG
4	2	AELS-002-22-04	LONG LEG
5	2	AELS-002-22-05	ADJUSTING NUT
6	1	AELS-002-22-06	ADJUSTING SCREW LONG
7	1	AELS-002-22-07	ADJUSTING SCREW SHORT
8	1	AELS-002-22-08	SHAFT EXTENSION
9	1	AELS-002-22-09	SIDE PLATE
10	1	AELS-002-22-10	REAR PLATE.SLDPRT
11	1	AELS-002-22-11	HANDWHEEL SHAFT
12	1	AELS-002-22-12	IDLER SHAFT SHORT
13	1	AELS-002-22-13	CHAIN COVER
14	1	SSR-15-3-5	GRAVITY ROLLER CONVEYOR
15	9	BRF2-075 LIGHT	3/4" 2-BOLT FLANGE BEARING LIGHT
16	6	35B16 3/4 W KEY	SPROCKET
17	1	DIAL IND 1/2 CCW	DIAL INDICATOR
18	1	SETCOL 0.625	SET COLLAR
19	1	COUP 0.75 NO KEYWAY	1-PC CLAMP-ON COUPLING W/O KEYWAY 3/4" ID
20	1	HANDW 5" PLAST	HAND WHEEL, Ø4.92" W /PLASTIC HANDLE
21	1	35 CHAIN	#35 CHAIN X 87.75" (234 LINKS)
22	1	35 CHAIN	#35 CHAIN X 69.375 (185 LINKS)
23	1	35 CHAIN	#35 CHAIN X 34.5 (92 LINKS)
24	1	MK-2000-12X120-MID	CONVEYOR 12" WIDE X 10' LONG, MID DRIVE
25	7	AELS-002-22-15	CONVEYOR BRACKET
26	6	AELS-002-22-14	SUPPORT ANGLE
27	6	AELS-002-22-16	CONVEYOR SPACER

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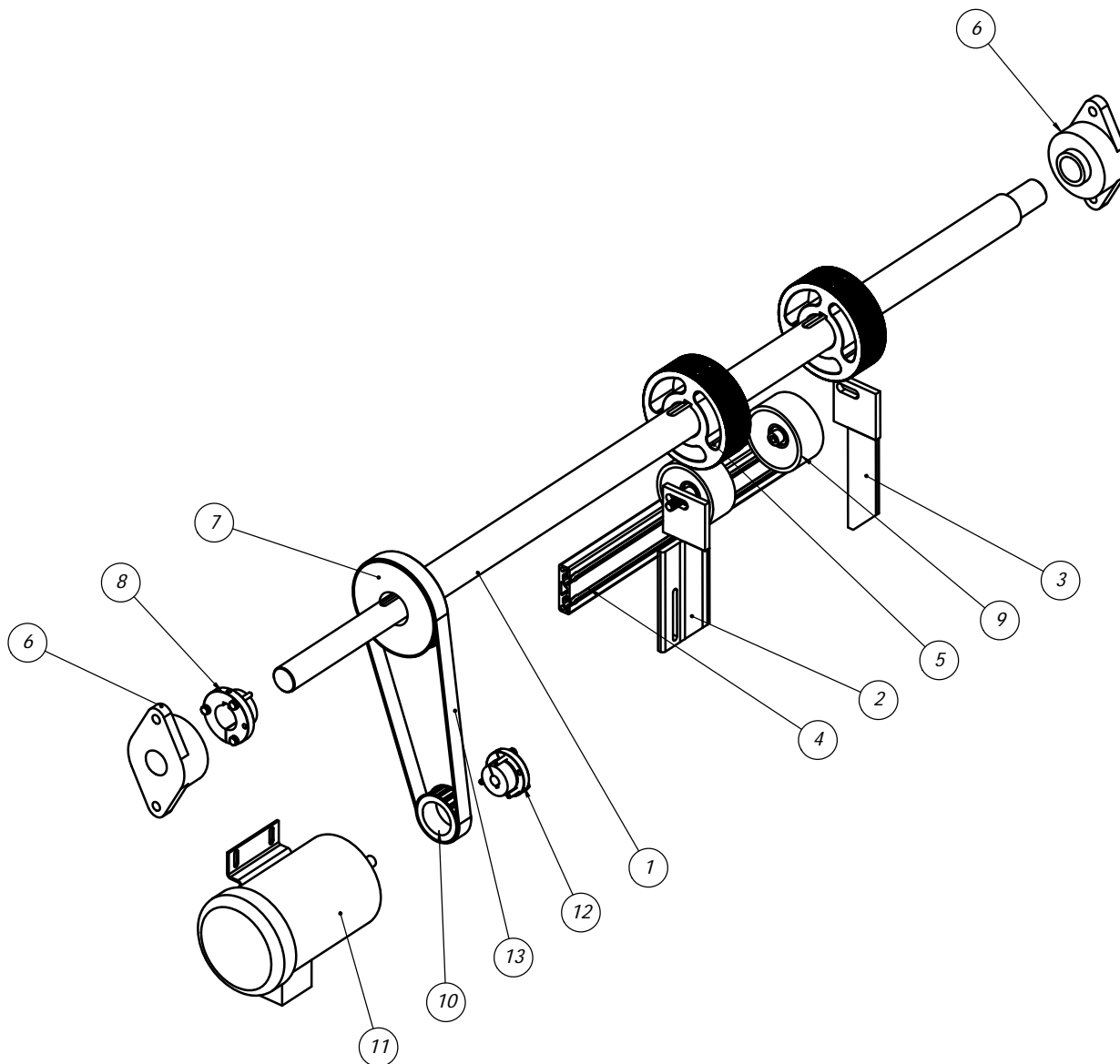
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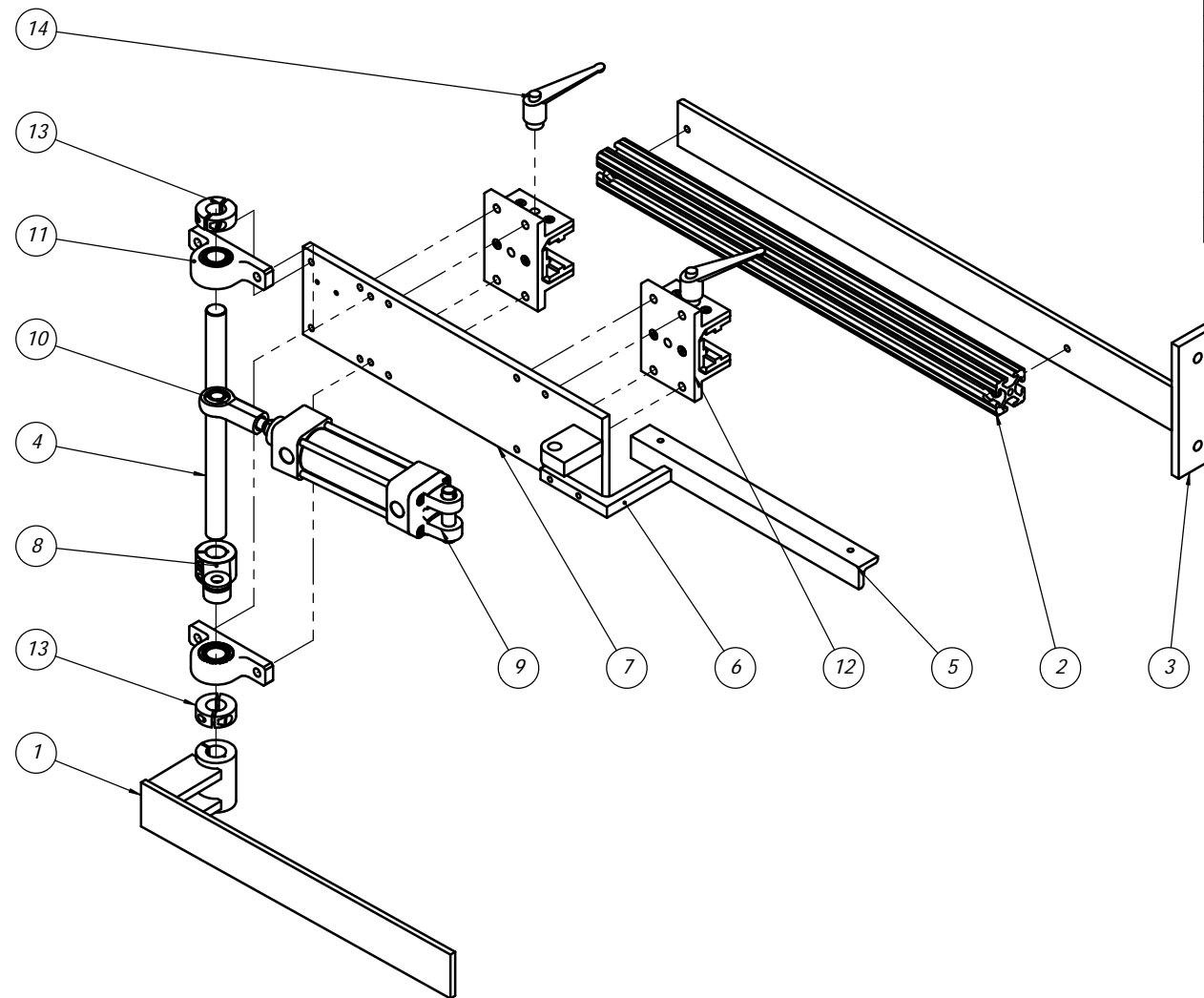
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4760 NW 128th STREET
MIAMI, FLORIDA 33054
305-622-4070

PROJECT
16399

PART NAME	HOPPER CONVEYOR		
MACHINE MODEL	CASE PACKER		
DWG NO.	AELS-002-22		
DESIGN	DRAWN JFdez	DATE 4/28/2017	SHEET 1 of 1



M101 ORDERS IN PROGRESS\639W BOXER ALL IN ONE - MEGABRANDS\1-Mechanical1-Assembly\1



ASSEMBLY BILL OF MATERIALS			
ITEM	QTY.	PartNo	Description
1	1	AELS-002-25-01	FOLDER
2	1	AELS-002-25-02	SLIDE
3	1	AELS-002-25-03	SUPPORT BRACKET
4	1	AELS-002-25-04	SHAFT
5	1	AELS-002-25-05	SCALE SUPPORT
6	1	AELS-002-25-06	SCALE ARROW
7	1	AELS-002-08-10	CYLINDER BASE
8	1	STD-200-1106	FOLDER CRANK
9	1	SACRC15X3 A1D	AIR CYLINDER, 1-1/2" X 3", DBL REAR CLEVIS
10	1	REF50-20-RH	1/2-20 FEMALE ROD END BRG, RH
11	2	PB3-750-B	BEARING, PILLOW BLOCK, 3/4"
12	2	6525 SNG LIN BRG 1515	LINEAR BEARING
13	2	COL 0.75-2P	3/4" TWO-PIECE CLAMP-ON COLLAR (STEEL)
14	2	ZCL-3031	LOCK HANDLE 5/16-18

PROPRIETARY PROPERTY

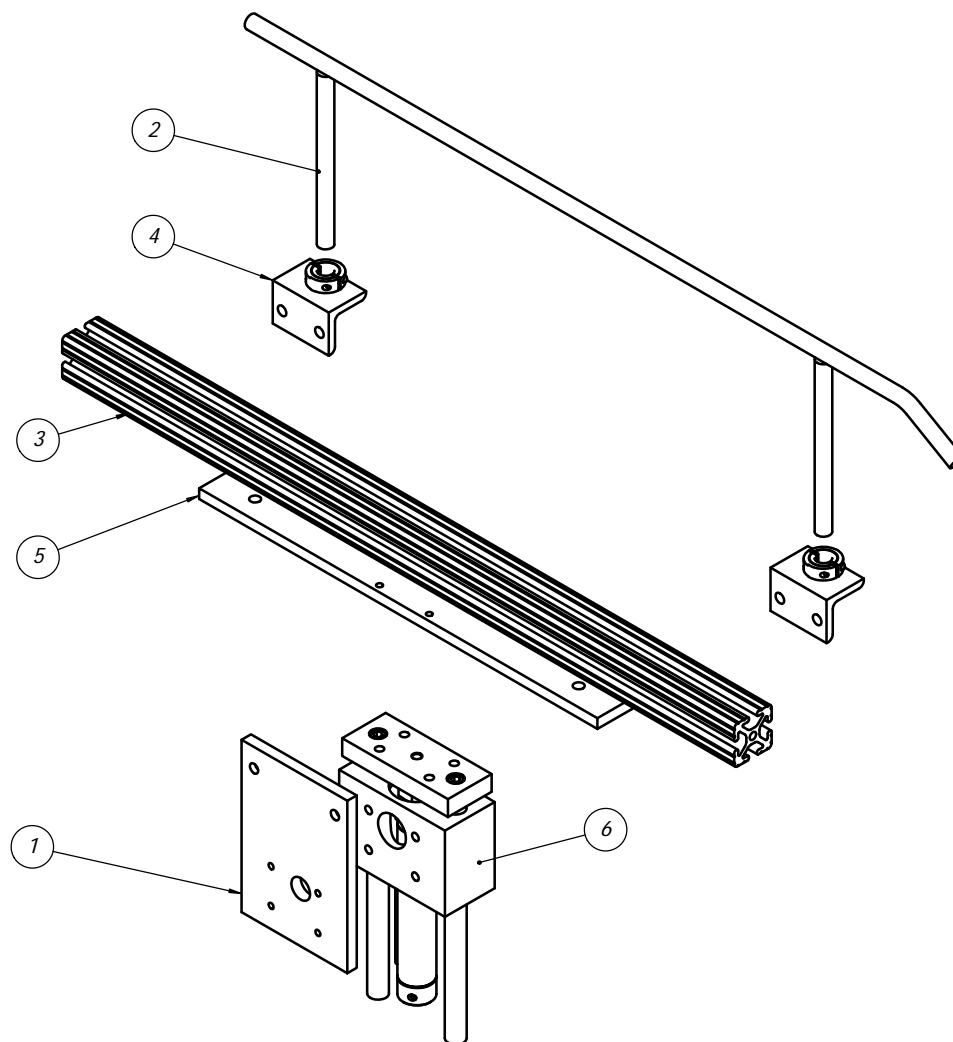
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PROJECT
16399

PART NAME		REAR FLAP FOLDER	
MACHINE MODEL		CASE PACKER	
DWG NO.		AELS-002-25	
DESIGN	DRAWN	DATE	SHEET
	JFdez	5/2/2017	1 OF 1



ASSEMBLY BILL OF MATERIALS					
ITEM	QTY.	PartNo	Description		
1	2	AELS-002-26-01	FRONT PLOW BAR		
2	2	AELS-002-26-02	PLOW BAR		
3	2	AELS-002-11-04	ADJUSTING BAR		
4	4	AELS-002-11-08	BAR SUPPORT		
5	2	AELS-002-11-09	MOUNTING PLATE		
6	2	TE-094-CMT1	AIR CYLINDER		

MA101 ORDERS IN PROGRESS16399 BOXER ALL IN ONE - MEGABRANDS1-Mechanical1-Assembly1

PROJECT 16399

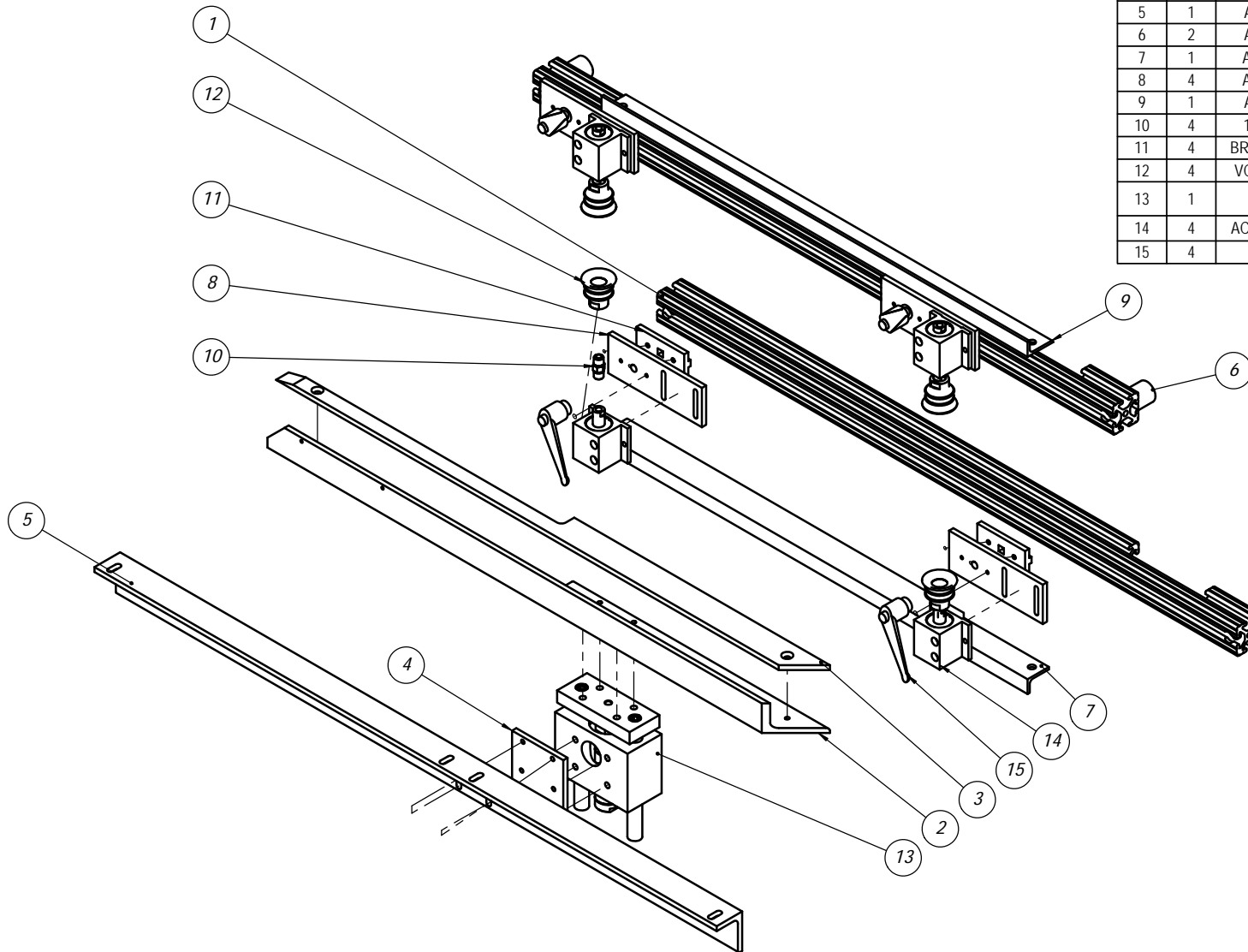
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MIAMI, FLORIDA 33054
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PART NAME		FRONT PLOW BAR			
MACHINE MODEL		BOXER ALL IN ONE			
DWG NO.		AELS-002-26			
DESIGN	DRAWN	DATE	SHEET	REV	
	V.Guzzo	5/2/2017	1 OF 1	-	



ASSEMBLY BILL OF MATERIALS			
ITEM	QTY.	PartNo	Description
1	2	AELS-002-27-01	SLOTTED PROFILE
2	1	AELS-002-27-02	RETRACTIBLE GUIDE RAIL
3	1	AELS-002-27-03	GUIDE PLATE
4	1	AELS-002-27-04	CYLINDER BASE
5	1	AELS-002-27-05	MOUNTING ANGLE
6	2	AELS-002-27-02	SPACER
7	1	AELS-002-27-08	SCALE ANGLE
8	4	AELS-002-24-09	CYLINDER BASE
9	1	AELS-002-27-10	SCALE ANGLE-2
10	4	1/8 HEX NIPPLE	1/8 HIGH-PRESSURE STEEL NIPPLE
11	4	BRG PAD 6817 1515	BEARING PAD 15 SERIES
12	4	VC-BX35P 1/8 FEM	VACUUM CUP
13	1	TE-091-BM	AIR CYLINDER, 1-1/16" X 1" THRUSTER ASSEMBLY
14	4	ACFB1.1X 1/2 HOLDS	AIR CYLINDER
15	4	ZCL-3031	LOCK HANDLE 5/16-18

PROJECT 16399

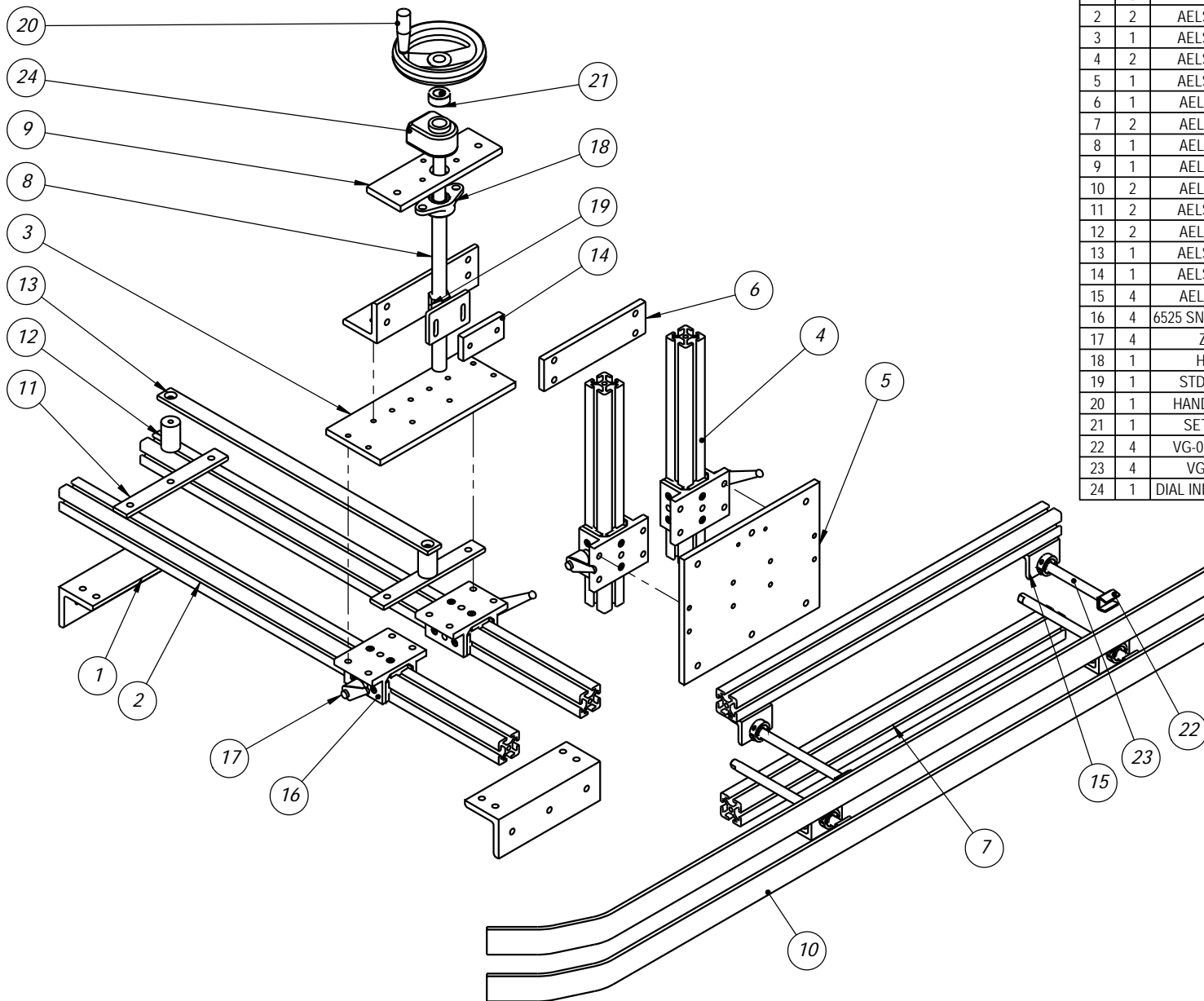
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PART NAME		BOTTOM FLAP OPENER	
MACHINE MODEL		BOXER ALL IN ONE	
DWG NO.		AELS-002-27	
DESIGN	DRAWN	DATE	SHEET
	V. Guzzo	5/2/2017	1 OF 1



ASSEMBLY BILL OF MATERIALS			
ITEM	QTY.	PartNo	Description
1	3	AELS-002-29-01	SUPPORT ANGLE
2	2	AELS-002-29-02	HORIZONTAL SLIDE
3	1	AELS-002-29-03	HORIZONTAL CARRIAGE
4	2	AELS-002-29-04	VERTICAL SLIDE
5	1	AELS-002-29-05	VERTICAL CARRIAGE
6	1	AELS-002-29-06	JONING PLATE
7	2	AELS-002-29-07	SUPPORT BEAM
8	1	AELS-002-29-09	Default<As Machined>
9	1	AELS-002-29-10	TOP PLATE
10	2	AELS-002-29-11	PLOW BAR
11	2	AELS-002-29-12	BEAM PLATE
12	2	AELS-002-29-13	SPACER
13	1	AELS-002-29-14	SCALE BASE
14	1	AELS-002-20-08	SPACER
15	4	AELS-002-11-08	BAR SUPPORT
16	4	6525 SNG LIN BRG 1515	LINEAR BEARING
17	4	ZCL-3031	LOCK HANDLE 5/16-18
18	1	HF3-625-B	SELF ALIGNING BRONZE BEARING
19	1	STD-400-1404-1	RAIL ADJUSTMENT BRKT
20	1	HANDW 5" PLAST	HAND WHEEL, Ø4.92" W /PLASTIC HANDLE
21	1	SETCOL 0.625	SET COLLAR
22	4	VG-018-01 .675LG	CLIP (RAIL MOUNTING) 5/16 UNC X 5/8" LG
23	4	VG-212-8-516	1/2" ADJUSTING ROD
24	1	DIAL IND #DWN 1/2 CW	DIAL INDICATOR

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MIAMI, FLORIDA 33054
305-622-4070

PART NAME		MAJOR HOLDER	
MACHINE MODEL		CASE PACKER	
DWG NO.		AELS-002-29	
DESIGN	DRAWN	DATE	SHEET
	JFdez	5/26/2017	1 of 1

D

C

B

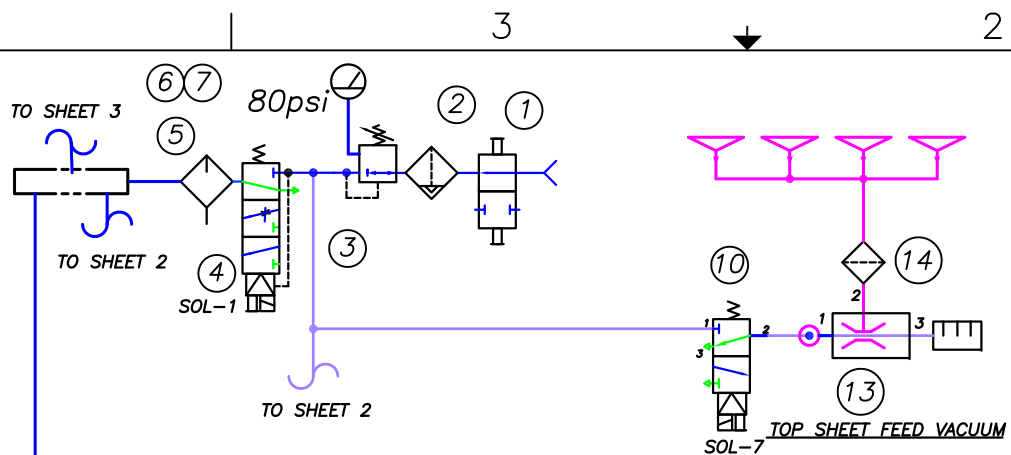
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D

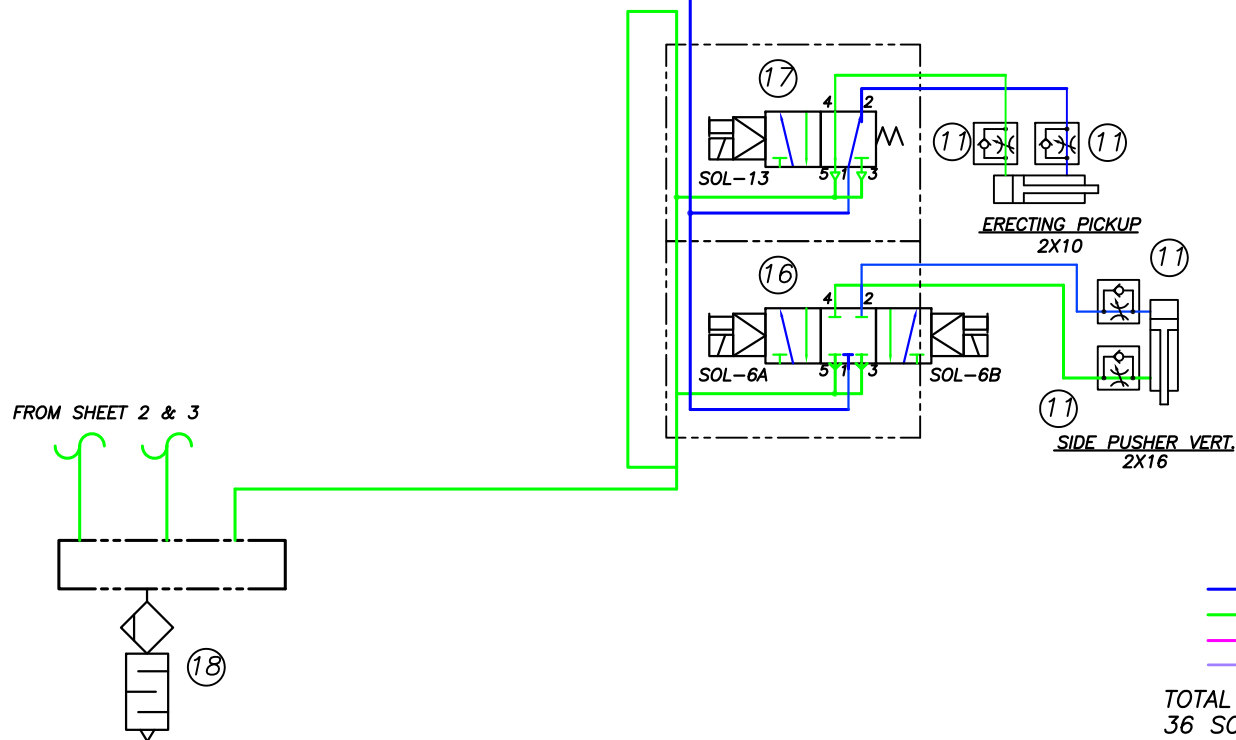
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B

A



ITEM	QTY	PART NUMBER	DESCRIPTION
1	1	075 LO*	3/4 LOCK OUT VALVE
2	1	075 FILTER	3/4 FILTER
3	1	075 REG	3/4 REGULATOR
4	1	075 SS	3/4 SOFT START VALVE
5	1	075 LU	3/4 LUBRICATOR
6	2	075 SPACER	3/4 SPACER
7	2	075 T-BRACKET	3/4 T SPACER
8	1	W5Q41-04	W5Q41-06N11T T O WITH..(4) VQ4101-5B 24VDC
9	2	W5Q41-06HL	6-STATION MANIFOLD WITH T-KIT TERMINAL
10	3	SAV-GLU-24DC	SOLENOID VALVE 4-WAY 3-PORT 2-POS - 1/4 NPT
11	18	NAS3/8X3/8UNFLCTROL	3/8 T BG X 3/8 NPT UNIVERSAL FLOW CONTROL
12	36	NAS1/4X1/8UNFCTROL	1/4 T BG X 1/8 NPT UNIVERSAL FLOW CONTROL
13	3	120L	VACUUM PUMP
14	3	FLPT-1/2F	VACUUM FILTER 1/2 NPT FEMALE
15	1	22N9DCV-24VDC	2-WAY NORMALLY CLOSED, DIRECT ACTING
16	1	VQ4501-5 3 POS	AIR VALVE, 3 POSITION, DOUBLE SOLENOID,
17	16	VQ4101-5B REP2P4W24VDC	STACK VALVE 2-POSITION 4-WAY..24VDC
18	1	075 EXH CLR	EXHAUST CLEANER, WITH 3/4 NPT FEMALE
19	4	NAS3/8X3/8INLFCTROL	INLINE SPEED CONTRL 3/8 TUBE X 3/8 TUBE

**LEGEND**

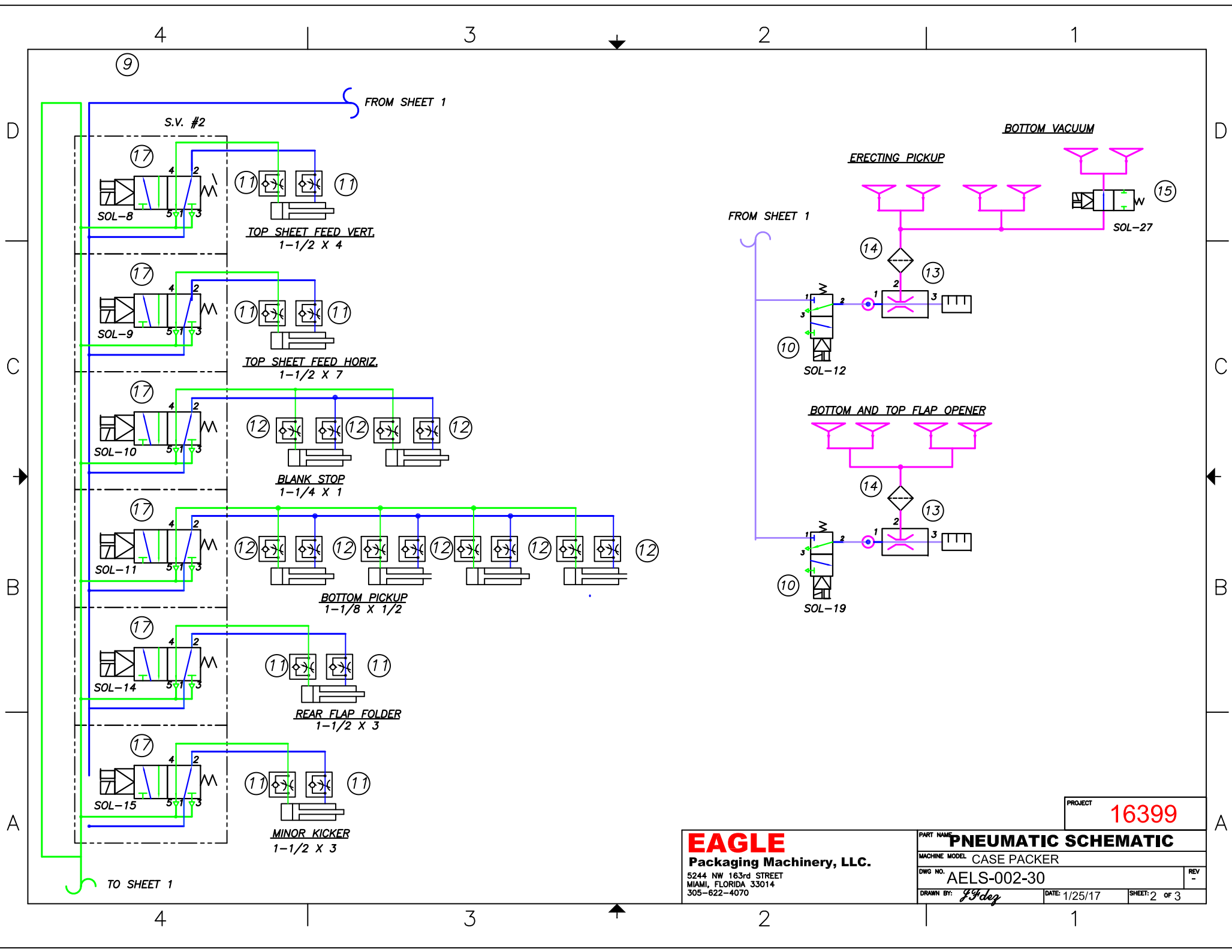
- 80 PSI AIR
- EXHAUST
- VACUUM
- OILESS

TOTAL AIR CONSUMPTION
36 SCFM @ 80 psi

PROJECT
16399

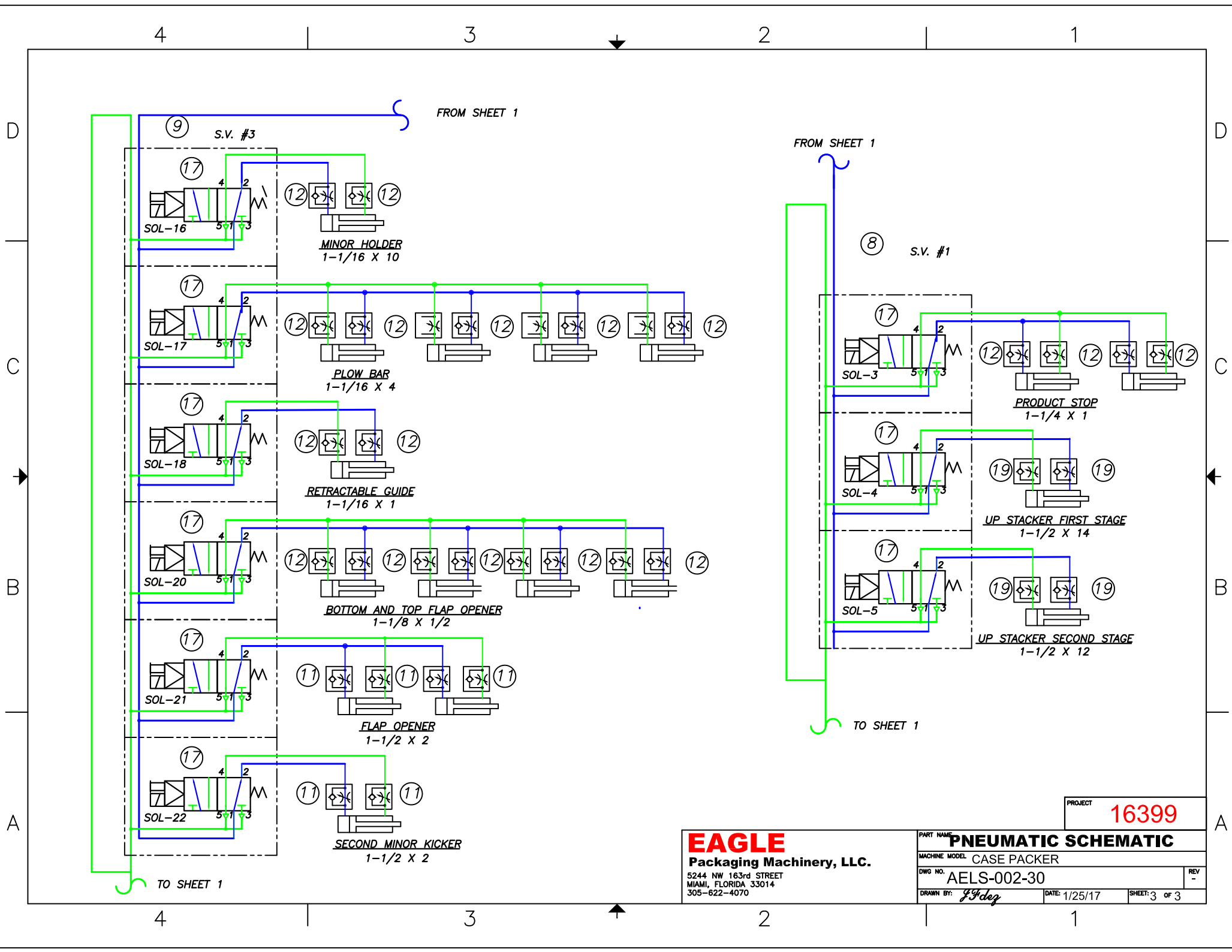
EAGLE
Packaging Machinery, LLC.
5244 NW 163rd STREET
MIAMI, FLORIDA 33014
305-622-4070

PART NAME	PNEUMATIC SCHEMATIC		
MACHINE MODEL	CASE PACKER		
DWG NO.	AELS-002-30		
DRAWN BY:	J. J. J.	DATE:	1/25/17
SHEET:	1	OF	3



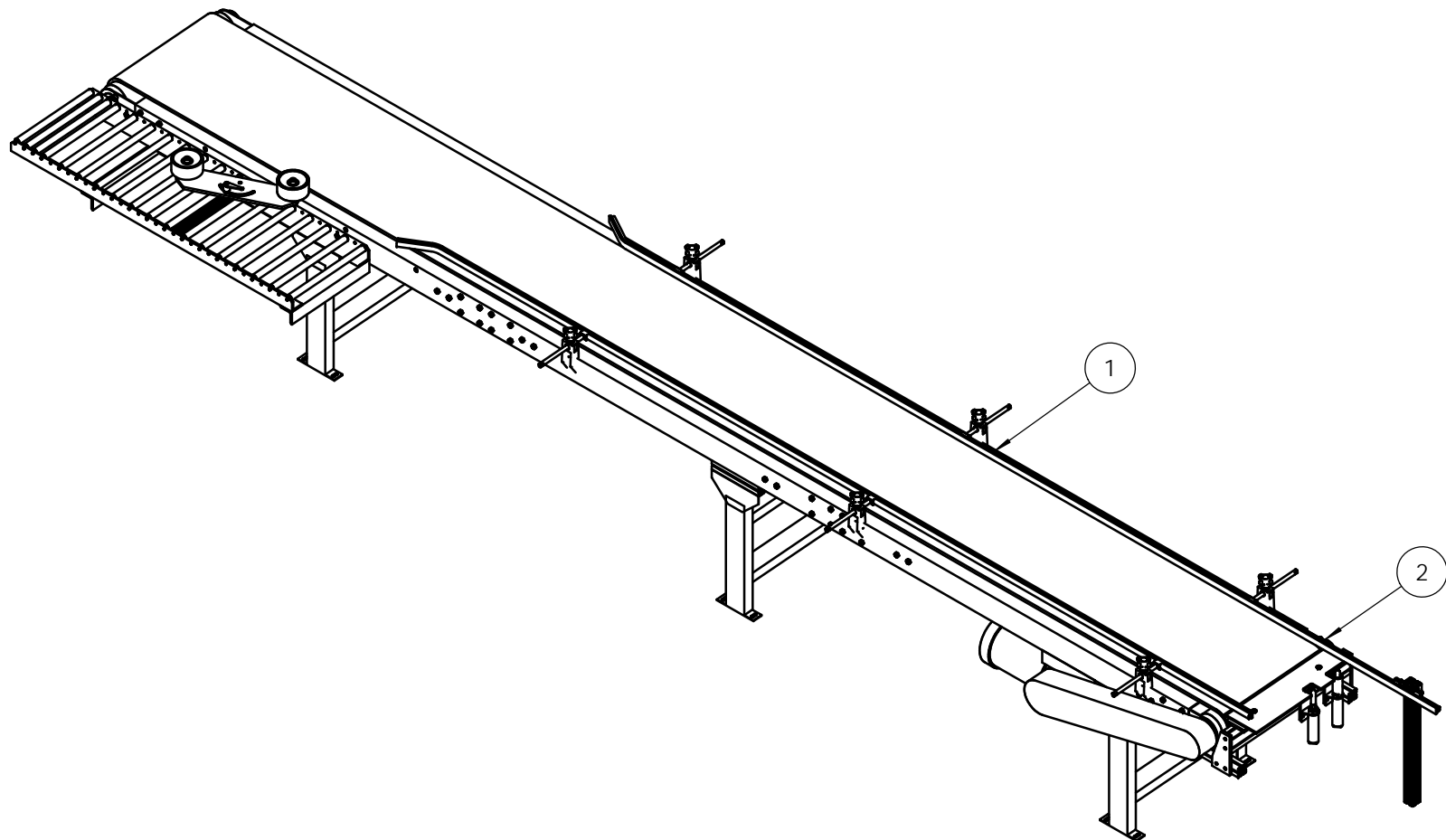
EAGLE
Packaging Machinery, LLC.
5244 NW 163rd STREET
MIAMI, FLORIDA 33014
305-622-4070

PART NAME		PNEUMATIC SCHEMATIC	
MACHINE MODEL		CASE PACKER	
DWG NO.		AELS-002-30	
DRAWN BY:		J.F. Deq	
DATE:		1/25/17	SHEET: 2 OF 3



EAGLE
Packaging Machinery, LLC.
5244 NW 163rd STREET
MIAMI, FLORIDA 33014
305-622-4070

PART NAME		PNEUMATIC SCHEMATIC	
MACHINE MODEL		CASE PACKER	
DWG NO.		AELS-002-30	
DRAWN BY:		J. J. Dege	REV -
DATE:		1/25/17	SHEET: 3 OF 3



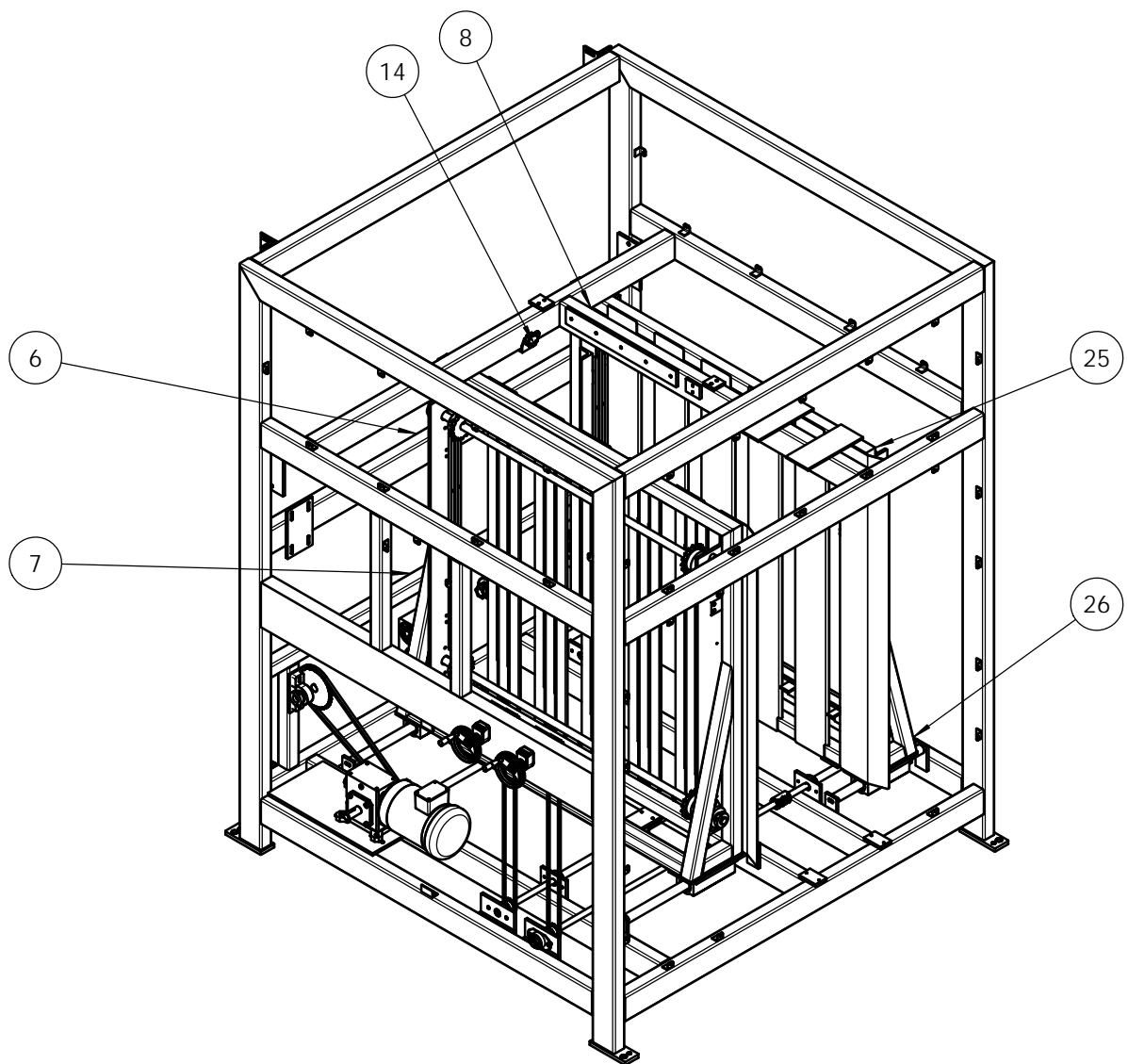
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MIAMI, FLORIDA 33054
305-622-4070

PART NAME		SENSOR SCHEMATIC	
MACHINE MODEL		BOXXER ALL IN ONE	
DWG NO.		AELS-002-31	
DESIGN	DRAWN	DATE	SHEET
	V. Guzzo	5/4/2017	1 of 10



PROJECT 16399

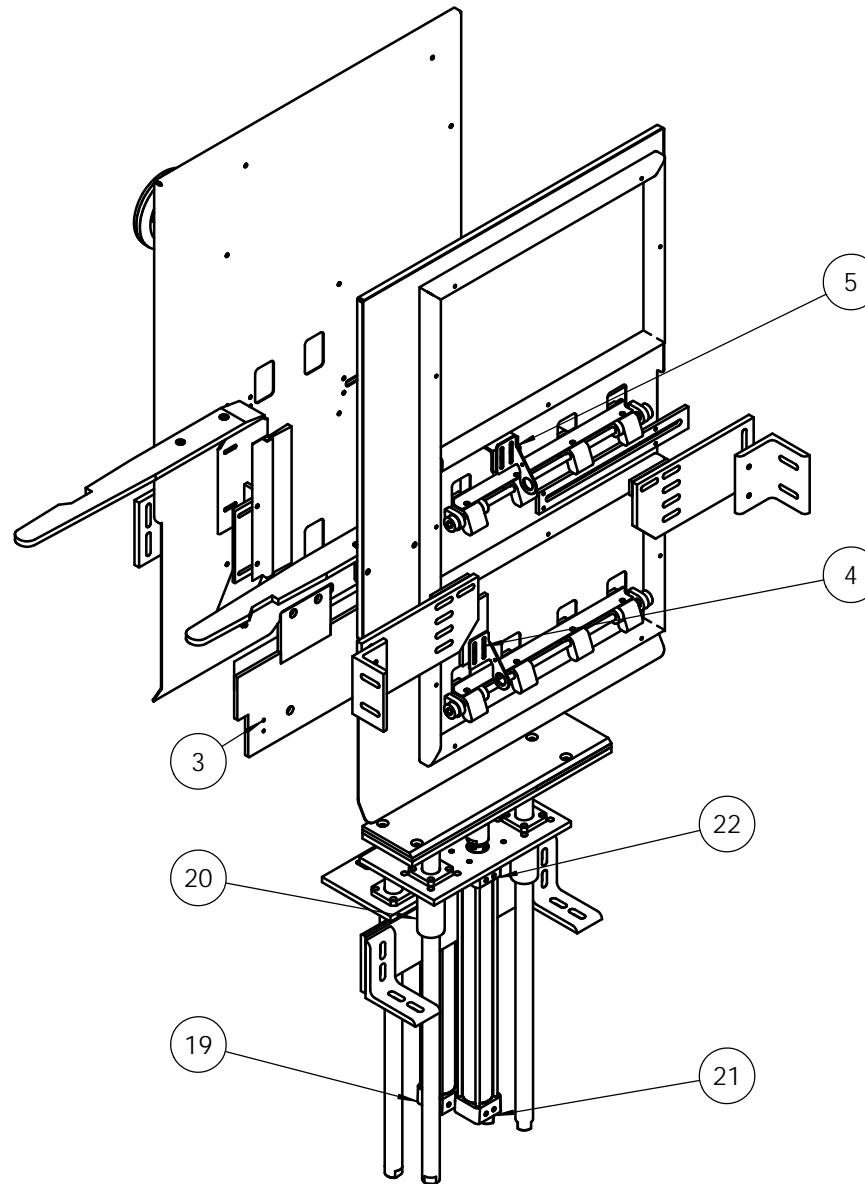
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MIAMI, FLORIDA 33054
305-622-4070

PART NAME		SENSOR SCHEMATIC		
MACHINE MODEL		BOXSER ALL IN ONE		
DWG NO.		AELS-002-31		REV -
DESIGN	DRAWN	DATE	SHEET	
	V. Guzzo	5/4/2017	2 of 10	



PROJECT 16399

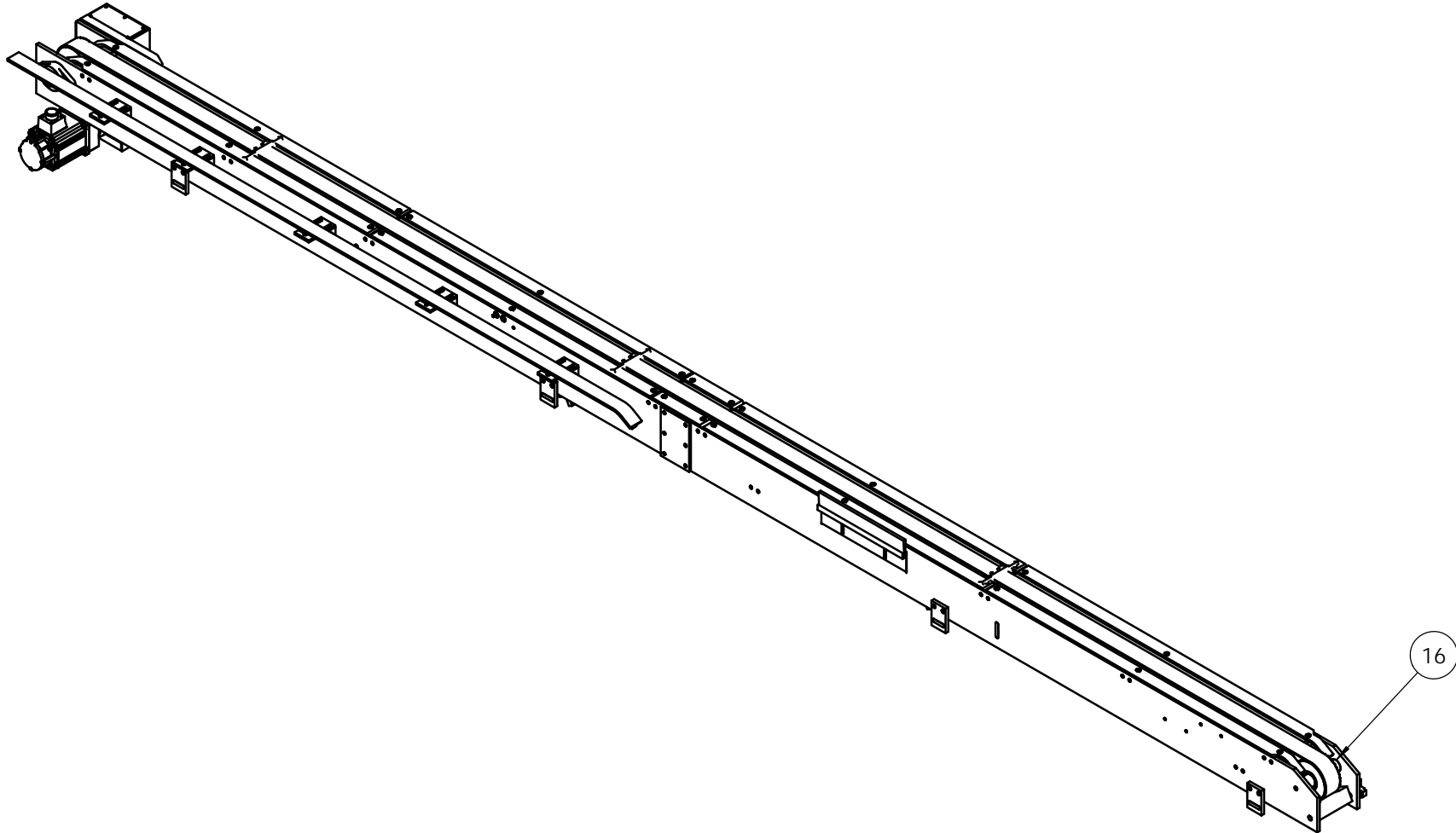
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EAGLE
Packaging Machinery, LLC.
4760 NW 128th STREET
MIAMI, FLORIDA 33054
305-622-4070

PART NAME		SENSOR SCHEMATIC		
MACHINE MODEL		BOXXER ALL IN ONE		
DWG NO.		AELS-002-31		REV -
DESIGN	DRAWN	DATE	SHEET	
	V. Guzzo	5/4/2017	3 of 10	



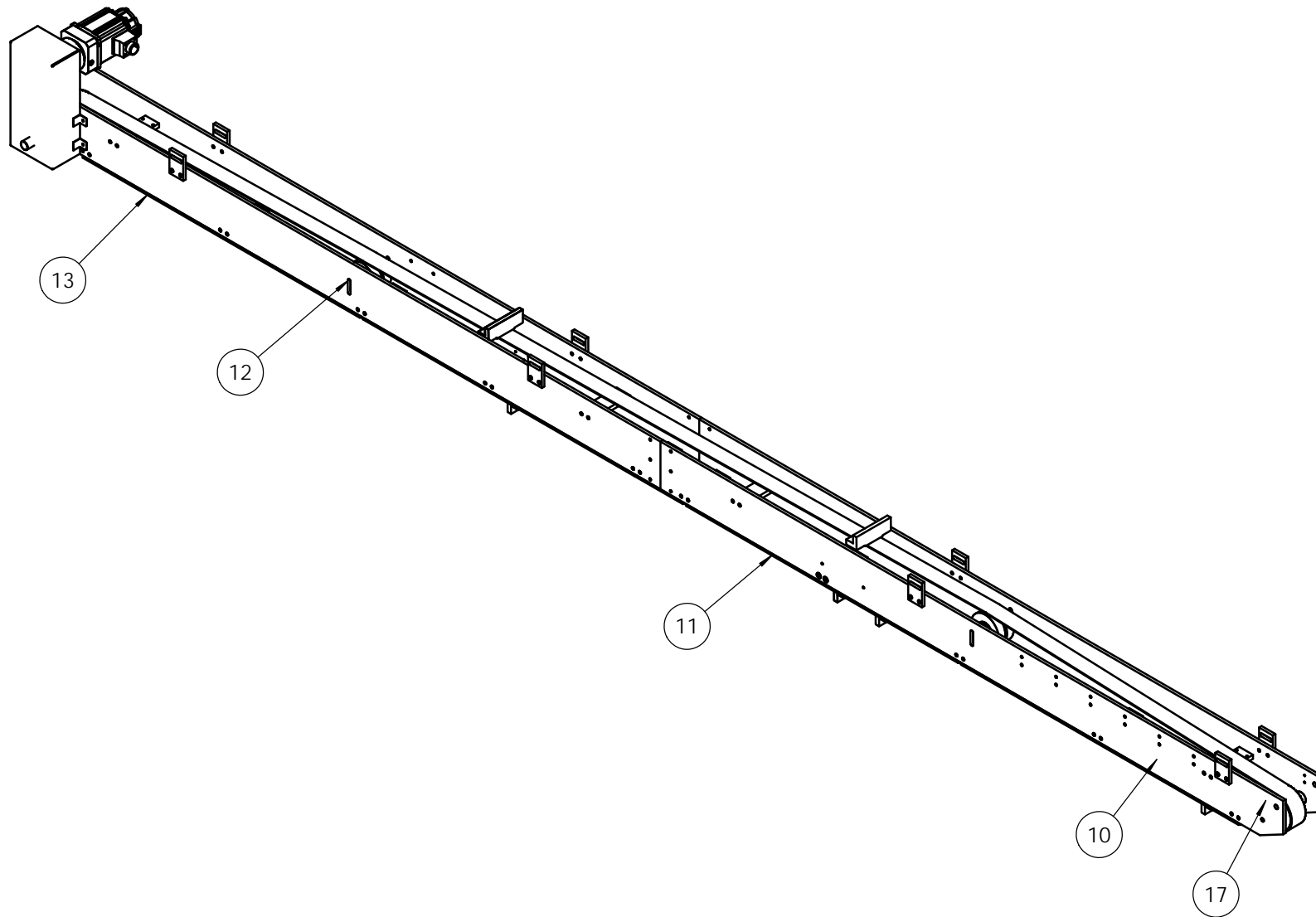
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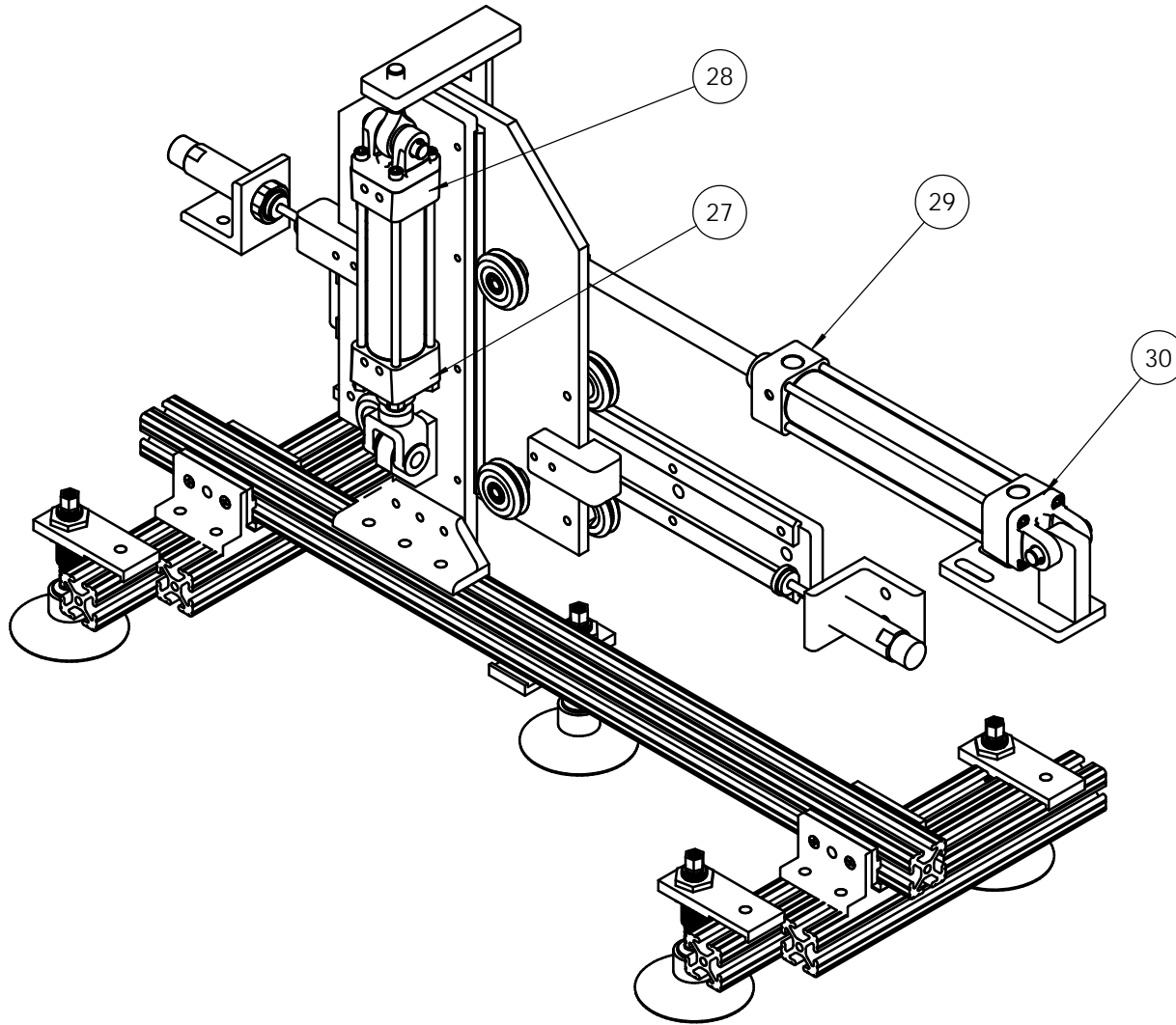
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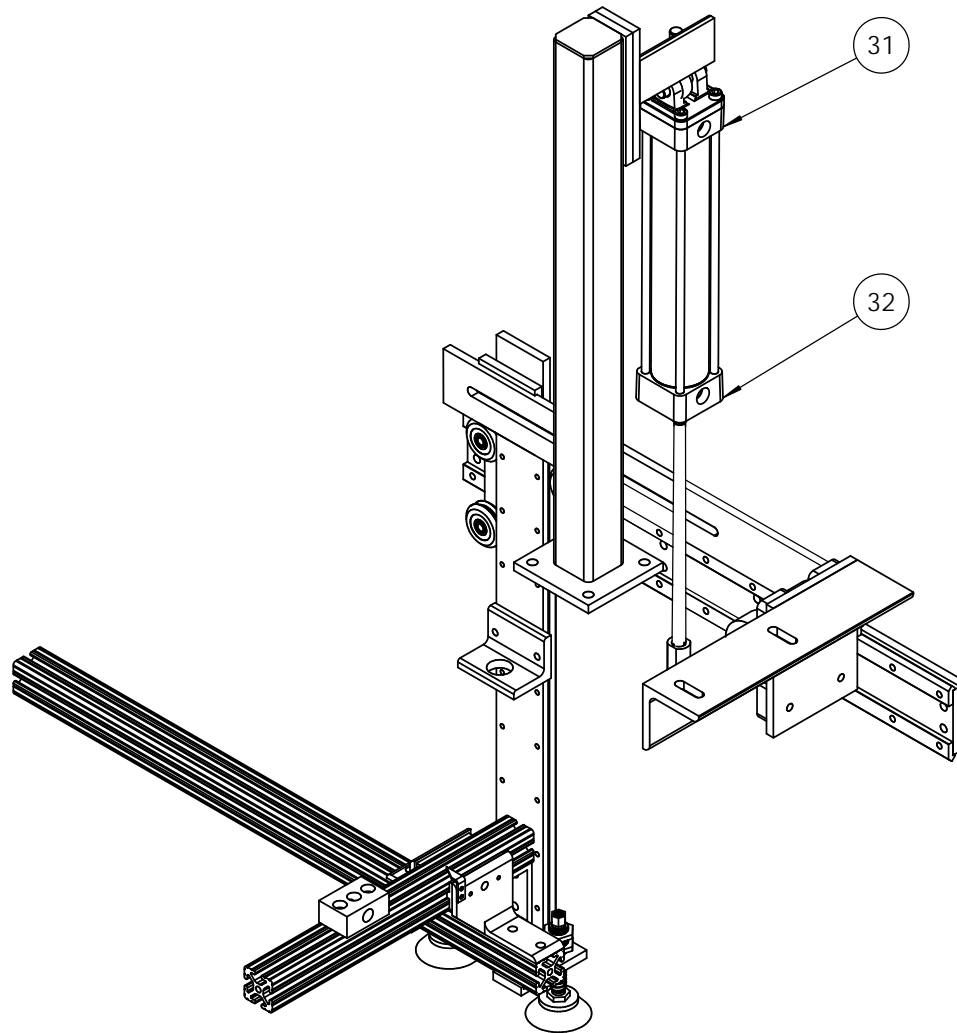
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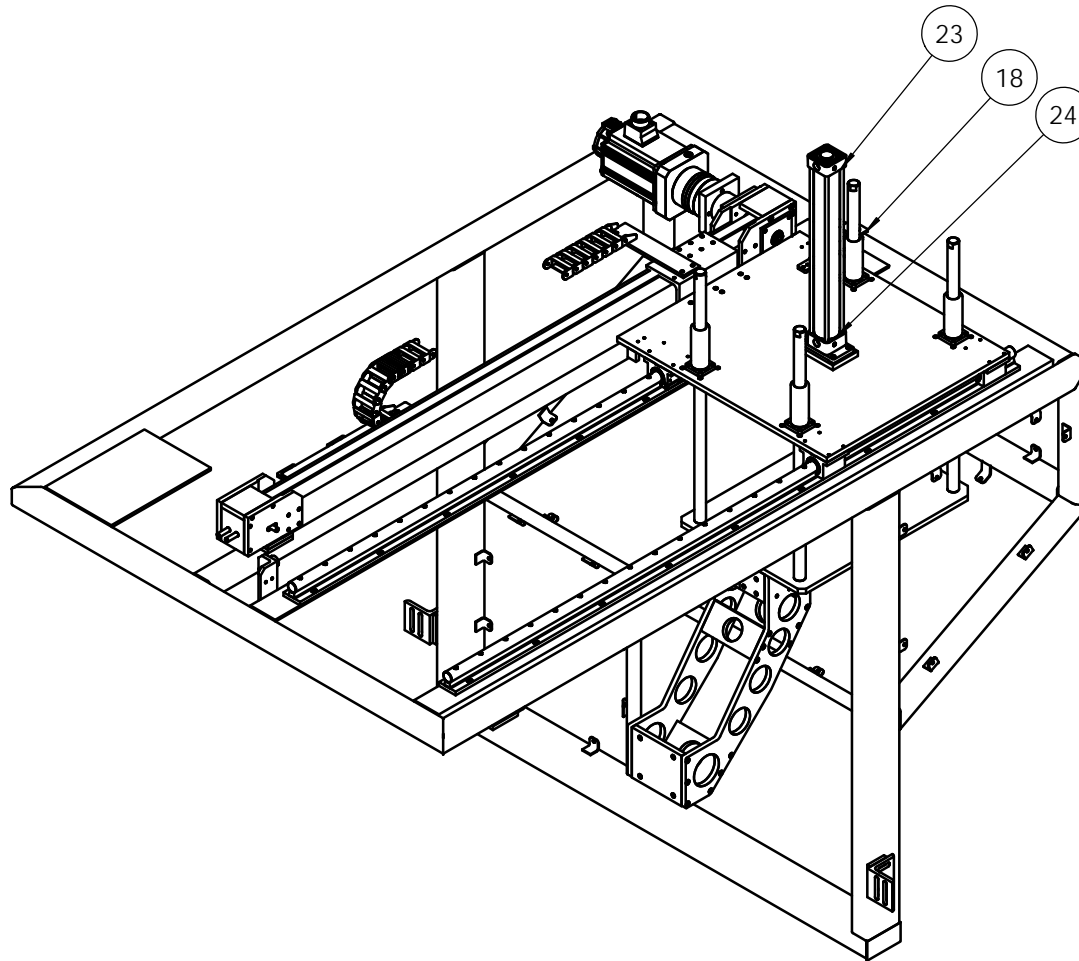
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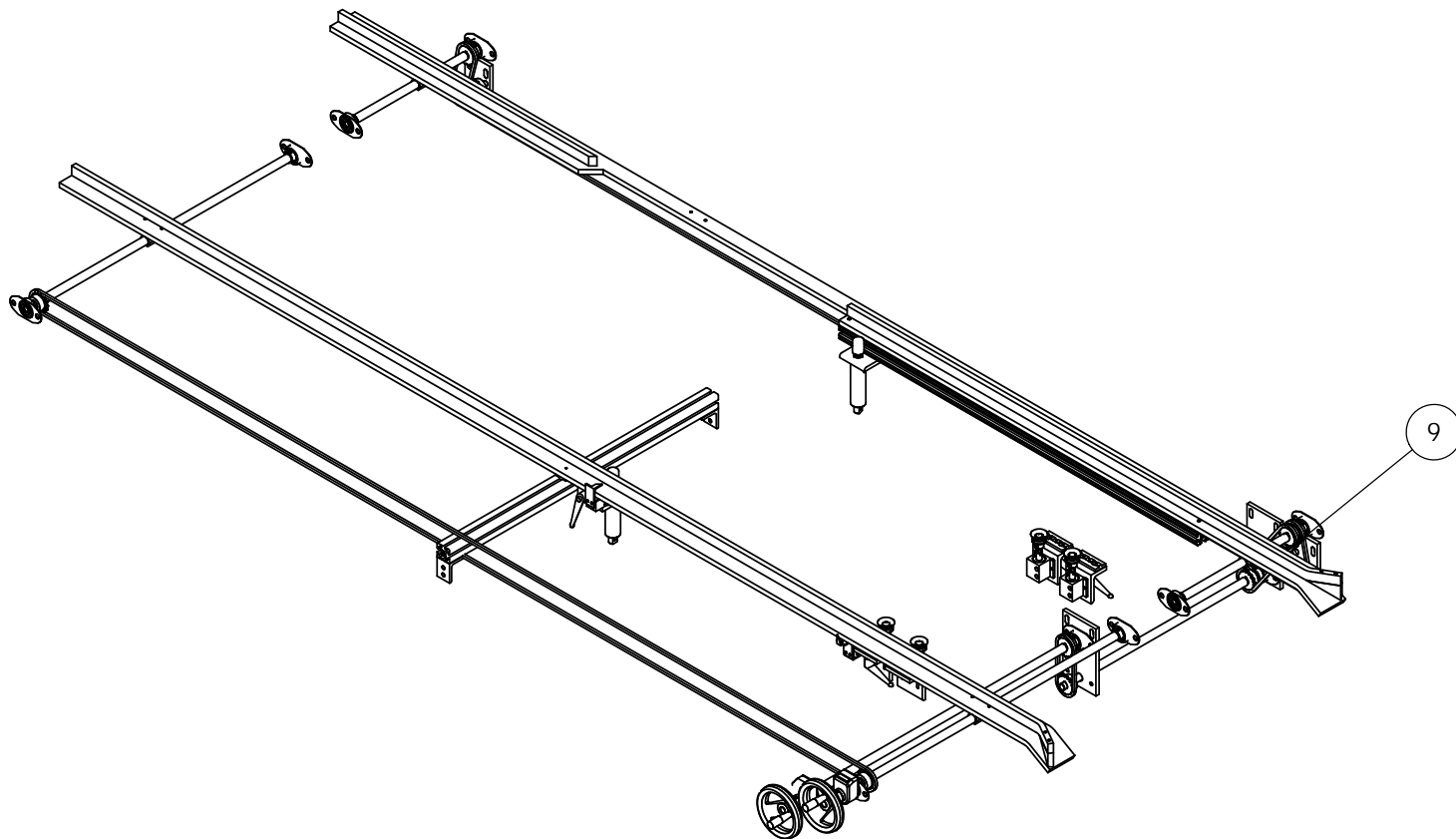
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DESIGN	DRAWN V. Guzzo	DATE 5/4/2017	SHEET 9	OF 10

			ASSEMBLY BILL OF MATERIALS		
			ITEM	DESCRIPTION	FUNCTION
			1	PE1	LOW PRODUCT AT INFEED CONVEYOR
			2	PE2	PRODUCT AT STOP
			3	PE3	PRODUCT AT UP STACKER LEVEL 0
			4	PE4	PRODUCT AT UP STACKER LEVEL 1
			5	PE5	PRODUCT AT UP STACKER LEVEL 2
			6	PE6	INITIAL HOPPER LEVEL
			7	PE7	STACK IN POSITION
			8	PE8	BLANK LOADED AT TOP SHEET FEEDER
			9	PE9	BLANK READY TO INDEX
			10	PE10	BLANK ERECTED
			11	PE11	BOX READY TO LOADING STATION
			12	PE12	BOX AT PLOW BAR
			13	PE13	BOX AT TAPE HEAD
			14	PE14	HOPPER DRIVE OVERTRAVEL
			15	PE16	AUTO IDLER
			16	PE17	HOME SENSOR BOTTOM DRIVE
			17	PE18	HOME SENSOR TOP DRIVE
			18	PROX 3	HOME SENSOR SIDE PUSHER
			19	PROX 4	UP STACKER FIRST HOME
			20	PROX 5	UP STACKER FIRST UP
			21	PROX 6	UP STACKER SECOND HOME
			22	PROX 7	UP STACKER SECOND UP
			23	PROX 8	SIDE PUSHER VERTICAL HOME
			24	PROX 9	SIDE PUSHER VERTICAL UP
			25	PROX 10	HOPPER DRIVE UP
			26	PROX 11	LOW HOPPER
			27	PROX 12	TOP SHEET FEEDER VERTICAL HOME
			28	PROX 13	TOP SHEET FEED VERTICAL DOWN
			29	PROX 14	TOP SHEET FEED HORIZONTAL FORWARD
			30	PROX 15	TOP SHEET FEED HORIZONTAL HOME
			31	PROX 16	ERECTING PICKUP HOME
			32	PROX 17	ERECTING PICKUP DOWN
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