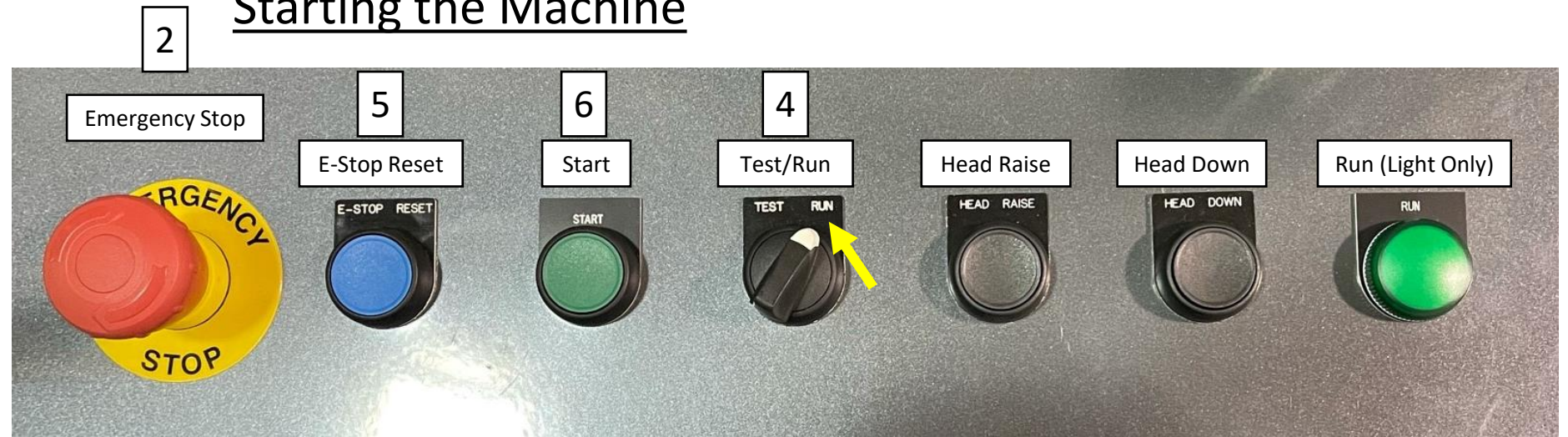
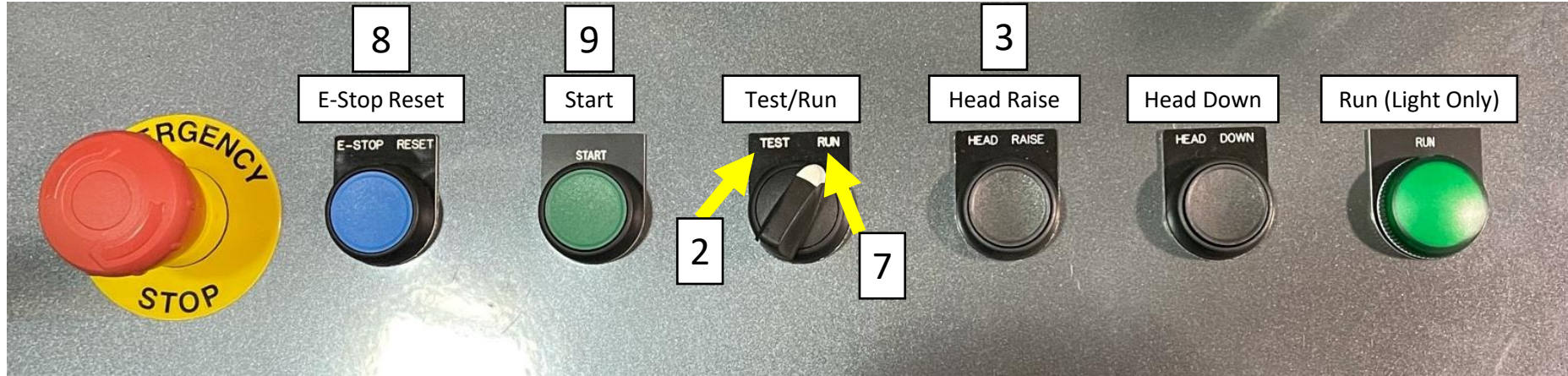


Starting the Machine



1. Turn on the MAIN POWER
2. Make sure all EMERGENCY STOP switches are disengaged by turning them $\frac{1}{4}$ rotation until they “pop up”
3. Make sure all protective doors (4) are closed completely
4. Place the TEST/RUN SWITCH in RUN
5. Press E-STOP RESET (BLUE) button
 1. The machine will power on the air and the rear kicker with raise
 2. The indexing gate at the front of the machine will move into the “UP” position
6. Press the START (GREEN) BUTTON
 1. The head will reset and move to “HOME”
7. Press the START (GREEN) BUTTON a second time
 1. The belts will begin to run
8. Allow boxes to feed to the indexing gate
9. The top head will adjust to the proper height, the gate will drop and the box will be inducted for sealing

Clearing a Jam



1. When a box jams the machine will shut down (time out)
2. Turn TEST/RUN switch to TEST
3. Press HEAD RAISE button until head indexes completely UP
4. Slide open the door open closest to the jam
5. Clear the jammed box
6. Slide the door completely closed
7. Turn TEST/RUN switch to RUN
8. Press the E-STOP RESET button (BLUE)
9. Press START (GREEN)
10. Feed cases

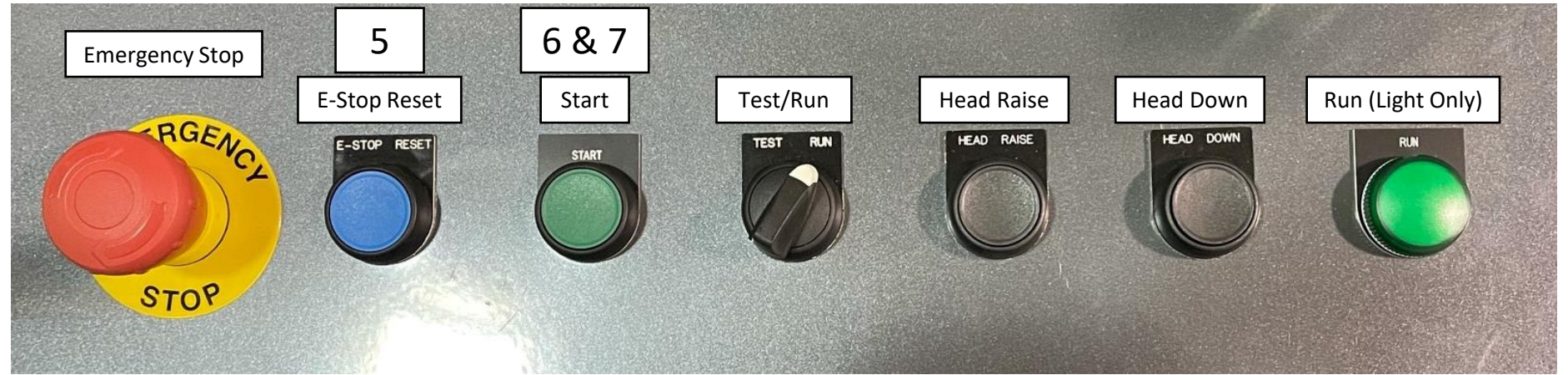
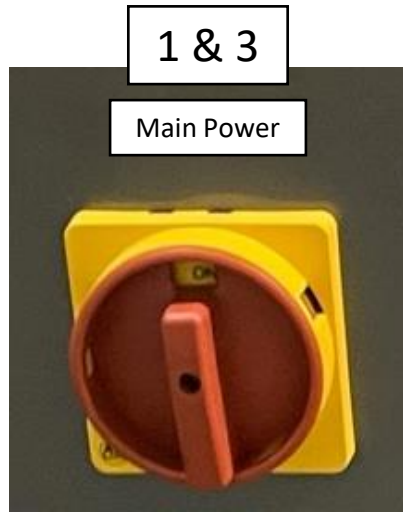
Soft Resetting the Machine



Soft Reset

1. Press the EMERGENCY STOP
2. Disengage the EMERGENCY STOP by $\frac{1}{4}$ turning the knob until it pops up
3. Press the E-STOP RESET (BLUE)
4. Press the START button (GREEN)
5. Feed cases

Hard Resetting the Machine



Hard Reset

1. Turn MAIN POWER to OFF
2. Wait 10 seconds
3. Turn MAIN POWER to ON
4. Wait 30 seconds for machine to cycle through start up
5. Press E-STOP RESET (BLUE) button
 - The machine will power on the air and the rear kicker with raise
 - The indexing gate at the front of the machine will move into the “UP” position
6. Press the START (GREEN) BUTTON
 - The head will reset and move to “HOME”
7. Press the START (GREEN) BUTTON a second time
 - The belts will begin to run
8. Feed cases