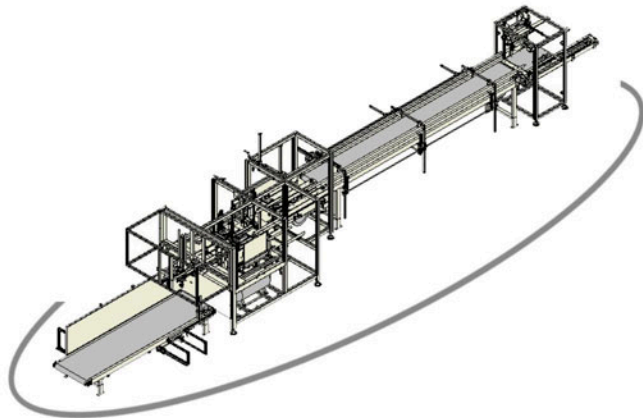


# Changeover Guide



CE 1500 XL  
Case Erector

# Basics

## Tools

-designed to assist with the Changeover process



**Lock Handle**

Lefty loosey  
Righty tighty



**Crank Handle**

Ratchet style  
both ways



**Lock Knob**

Lefty loosey  
Righty tighty



**Turn Wheel**

Turn to  
move item



**Scale**

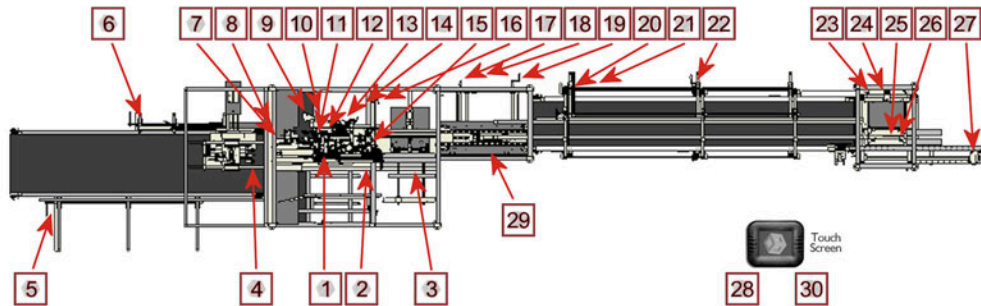
Use for  
precise alignment

## Notes

- Changeover locations (i.e. front, back, left, right) are based on the flow of the Blank/Case/Tray - as it moves through the Machine.
- To ensure Safety, make sure power is fully disabled before performing Changeover.
- Re-tighten all components firmly before resuming production.
- Consult the Machine Manual for more detail on Changeover.

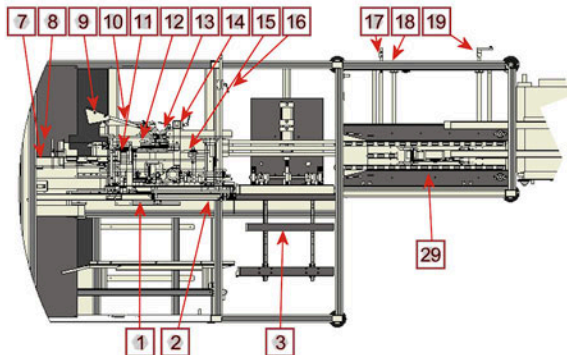


# Changeover Layout

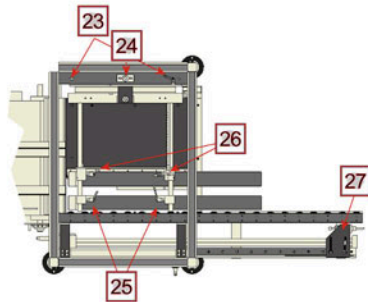


Machine Top View

# Changeover Layout



Erector / Horn / Tape  
Top View

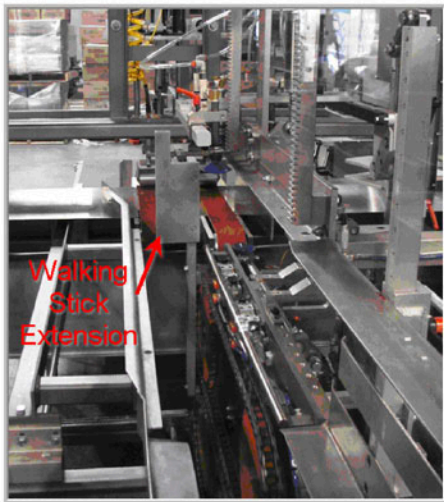
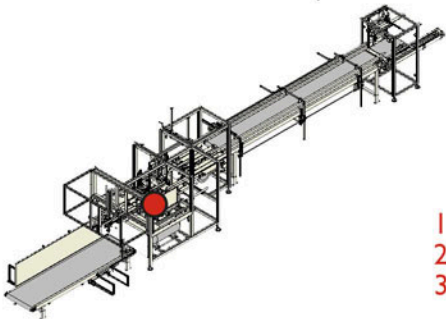


Down Elevator  
Top View

# Walking Stick Extension

\*The Walking Stick helps push the Case through the Erection Section of the machine.

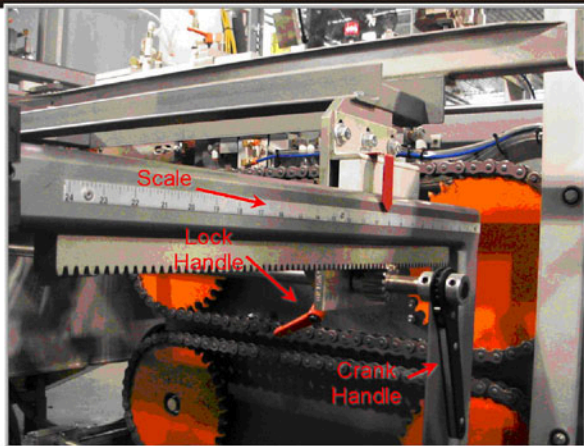
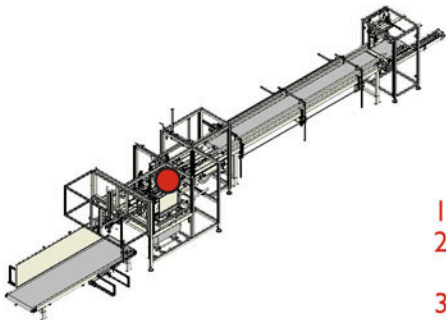
- Is an interchangeable plate that may differ, depending on the Blank sizes being run.
- Appropriate plates, of varying sizes, will be included with this machine and stamped with a size indicator.



- 1 Select the appropriate Walking Stick Extension plate.
- 2 Loosen and remove the Allen Bolts.
- 3 Place the correct plate in position, insert the bolts, and re-tighten.

## Guide Rail

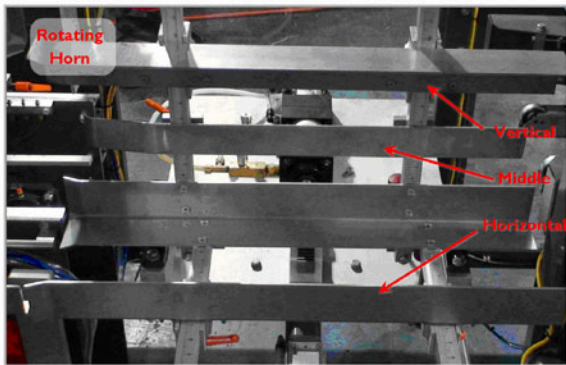
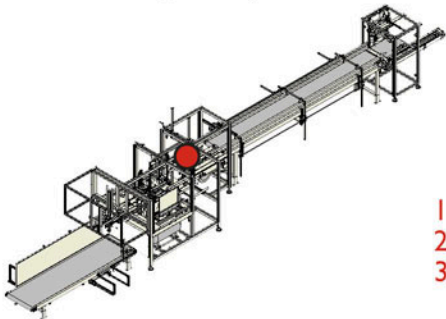
\*Located in the Erection Area - the Guide Rail keeps the side of the Blank in position, as it moves into the Erection Section.



- 1 Loosen the Lock Handle.
- 2 Using the Crank Handle, adjust to the desired setting on the Scale.
- 3 Re-tighten the Lock Handle.

# Rotating Horn

- \* The Rotating Horn is the device that flips the Case from its side to its bottom - to position it for taping.
- There are three adjustments for the Rotating Horn
  - vertical, middle, and horizontal.

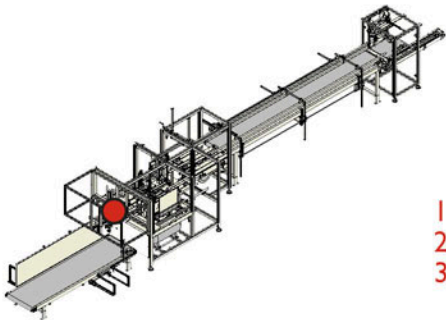
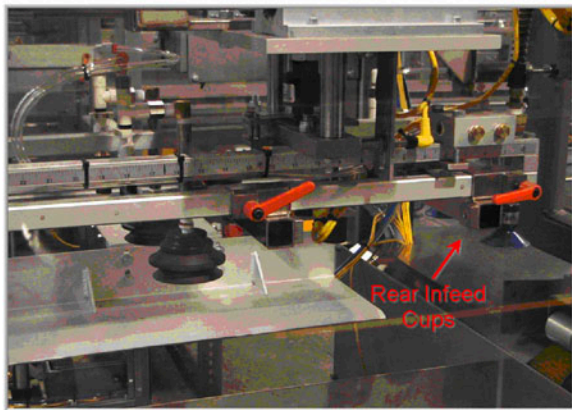


- The middle setting uses the same indicator scale as the vertical setting.

- 1 Loosen the Lock Handles.
- 2 Adjust to the desired setting on the Scale.
- 3 Re-tighten the Lock Handles.

## Rear Infeed Cups

\* The Rear Infeed Cups may need adjustment, depending on the length of the Blank.

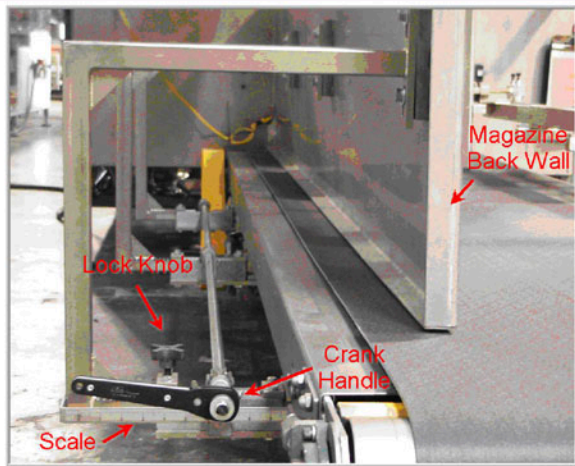
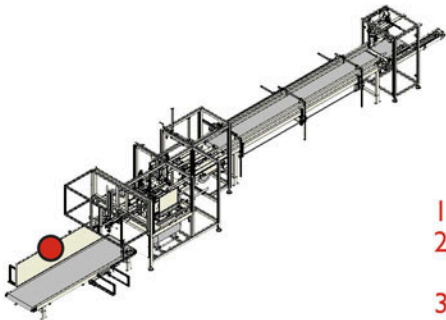


- 1 Loosen the Lock Handles.
- 2 Adjust to the desired setting on the Scale.
- 3 Re-tighten the Lock Handles.



## Magazine Back Wall

- \* The Magazine Back Wall runs along the length of the Infeed Magazine Conveyor.
- Provides a sturdy support to the stacks of Blanks waiting to be fed into the Machine.

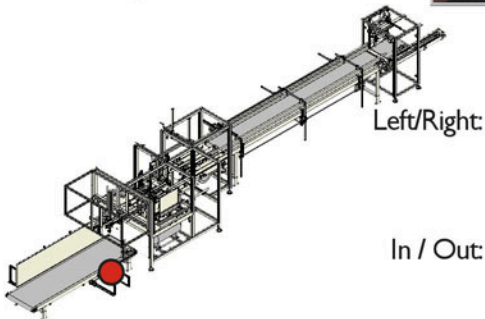
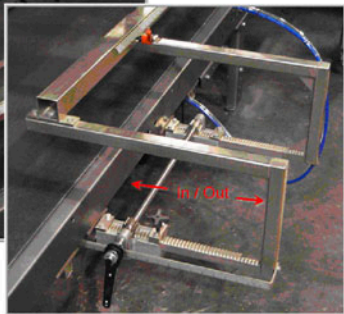
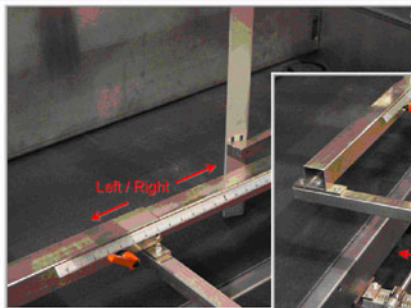


- 1 Loosen the Lock Knob.
- 2 Using the Crank Handle, adjust to the desired setting on the Scale.
- 3 Re-tighten the Lock Knob.

# Tamper (Top)

\* Located on the Infeed Magazine Conveyor, the Tamper helps support the outside corner of the Blank stack.

- Has independent settings for
  - Left/Right & In/Out.



Left/Right:

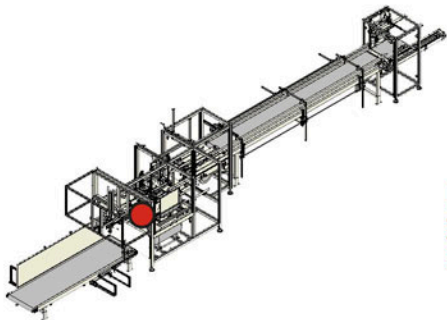
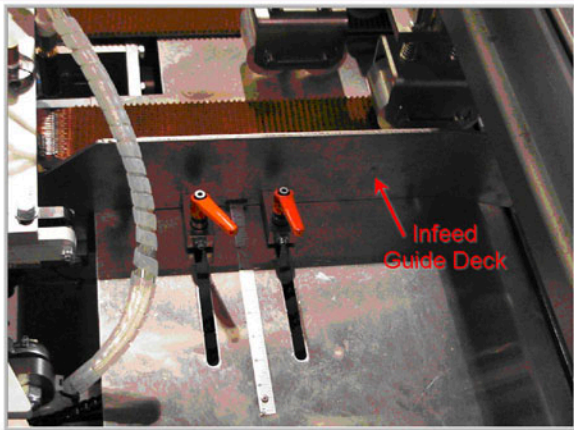
- 1 Loosen the Lock Handle.
- 2 Adjust to the desired Scale setting.
- 3 Re-tighten the Lock Handle.

In / Out:

- 1 Loosen the Lock Knob.
- 2 Using the Crank Handle, adjust to the desired setting on the Scale.
- 3 Re-tighten the Lock Knob.

## Infeed Guide Deck

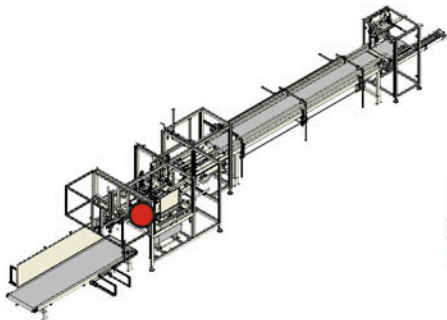
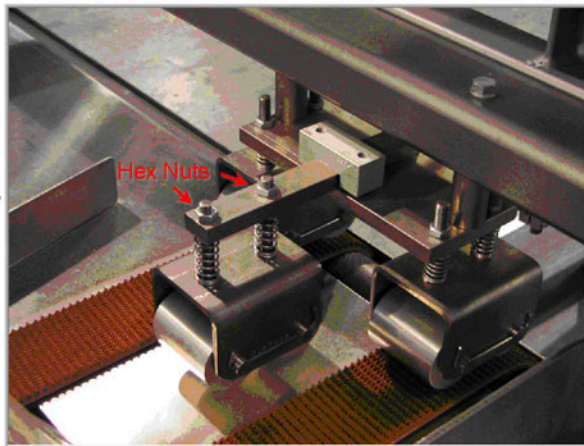
\* Located just past the Pinch Rollers, in the entryway of the Erection Section, the Infeed Guide Deck provides a guide wall for the Blank being fed into the Machine.



- 1 Loosen the Lock Handles.
- 2 Adjust to the desired setting on the Scale.
- 3 Re-tighten the Lock Handles.

## Auxiliary Roller

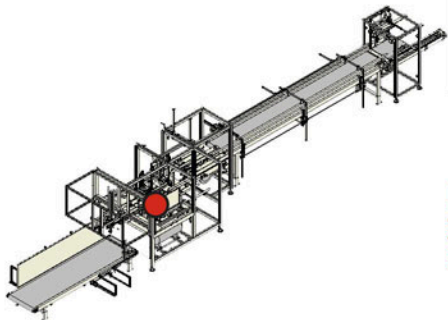
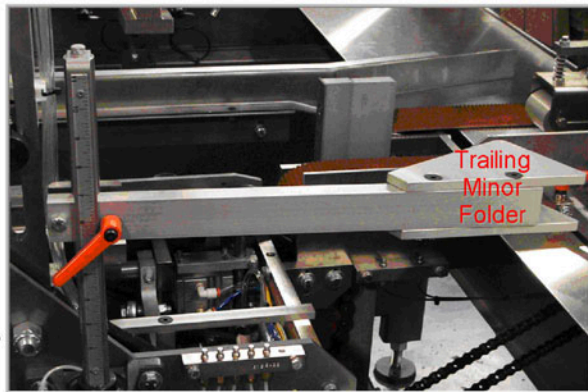
- \* The Pinch Rollers help keep the Blank in proper position during infeed.
- If the Pinch Roller is designated as OFF, ONLY the center roller is removed.



- 1 Loosen and remove the two Hex Nuts.
- 2 Lower the Pinch Roller and remove.
- 3 Store in a place with other Machine components.

# Trailing Minor Folder

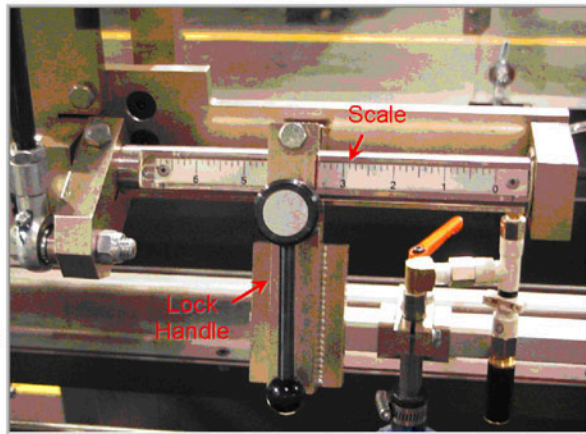
\* The Trailing Minor Folder folds the Minor Flap that is closest to the Pinch Rollers.



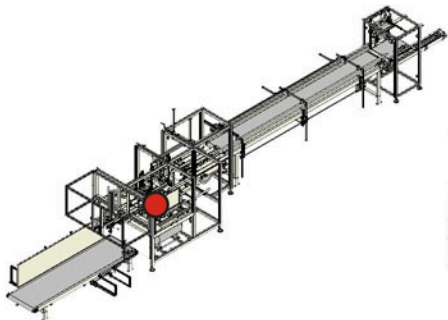
- 1 Loosen the Lock Handle.
- 2 Adjust to the desired Scale setting.
- 3 Re-tighten the Lock Handle.

# Upper Major

\* Located inside the Erection Section, the Upper Major folds the top-most Major Flap.



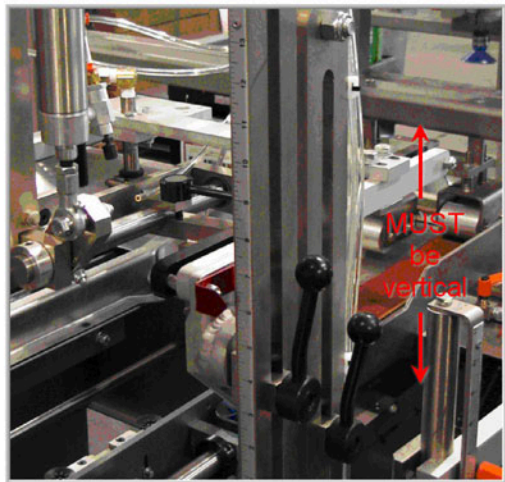
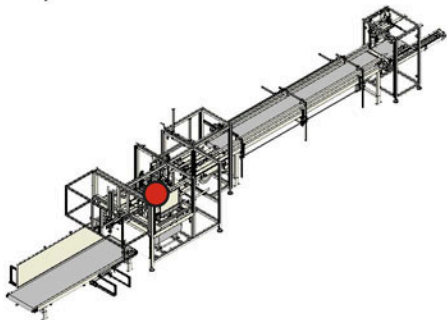
- 1 Loosen the Lock Handle.
- 2 Adjust to the desired Scale setting.
- 3 Re-tighten the Lock Handle.





# Erector Cups

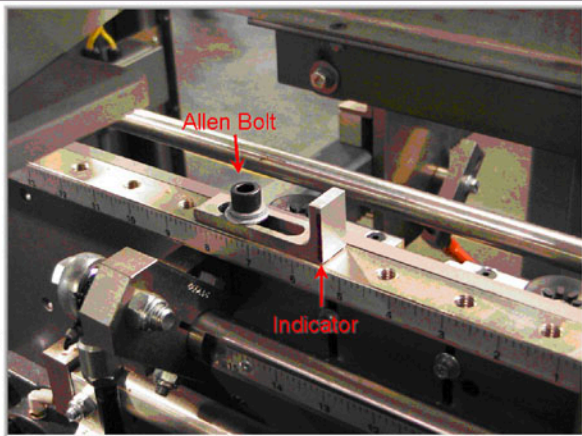
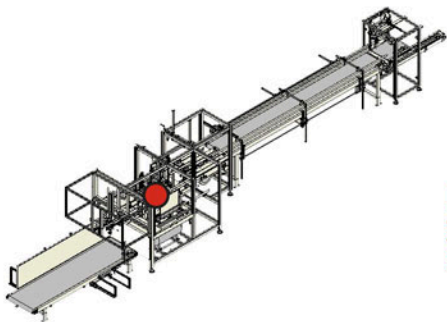
- \* The Erector Cups are the upper set of Vacuum Cups that pull open the Blank in the Erection Section.
- The Erector Cup adjustment **MUST** be done while the adjusting arms are in a *vertical* position.



- 1 Loosen the Lock Handles.
- 2 Adjust to the desired Scale setting.
- 3 Re-tighten the Lock Handles.

## Box Stop

\* Located inside the Erection Section, the Box Stop provides a stopping point for the loading Blank, just before it is erected.

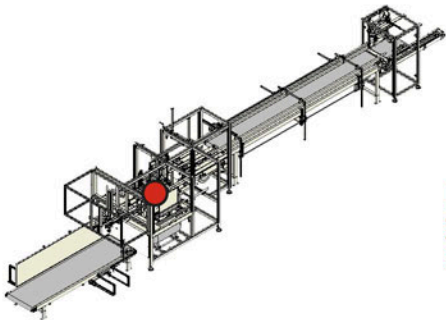
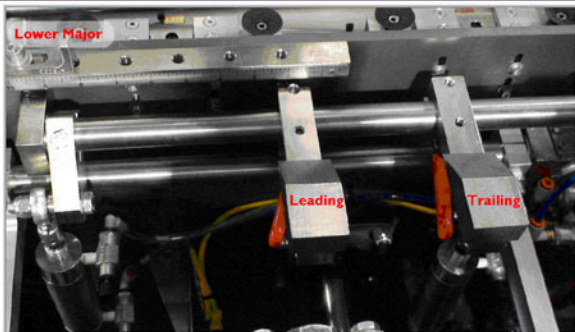


- 1 Loosen the Allen Bolt.
- 2 Adjust to the desired Scale setting.
- 3 Re-tighten the Allen Bolt.



## Lower Major

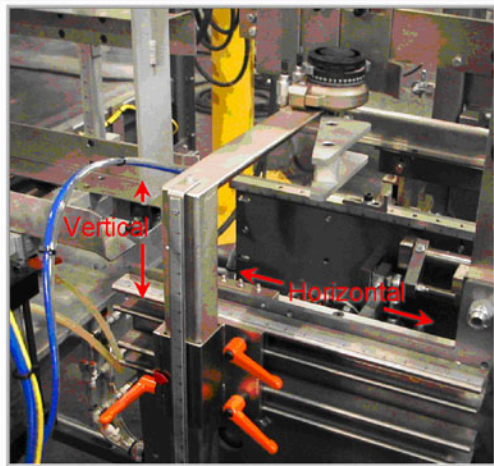
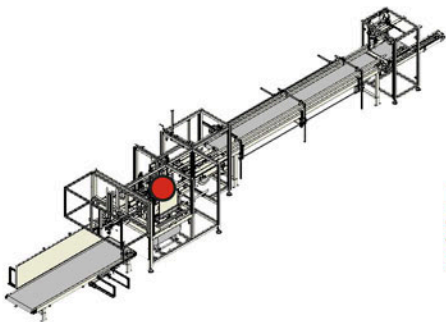
- \* Located inside the Erection Section, the Lower Major folds the bottom-most Major Flap.
- There are two Lower Major settings: Leading & Trailing



- 1 Loosen the Lock Handle.
- 2 Adjust to the desired Scale setting.
- 3 Re-tighten the Lock Handle.

## Leading Minor

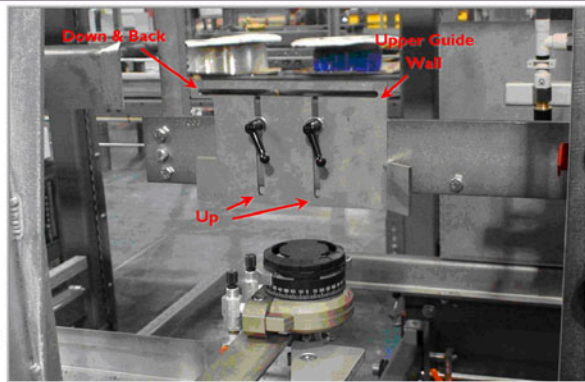
- \* The Leading Minor folds the Minor Flap that is on the front, or leading side of the Case - as it travels through the Machine.
- There are two Leading Minor settings: Horizontal & Vertical



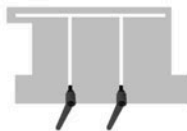
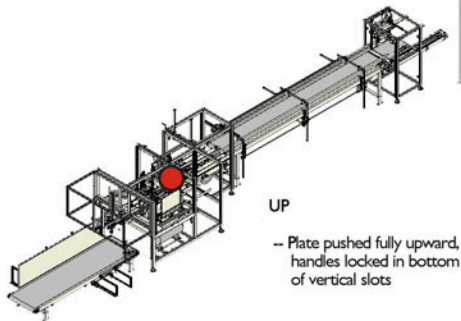
- 1 Loosen the Lock Handles.
- 2 Adjust to the desired Scale setting.
- 3 Re-tighten the Lock Handles.

# Upper Guide Wall

\* The Upper Guide Wall provides a reinforcement to the Upper Major Flaps, as it moves through the end of the Erection Section and into the Rotating Horn.



- 1 Loosen the Lock Handles.
- 2 Adjust to the desired position.
- 3 Re-tighten the Lock Handles.

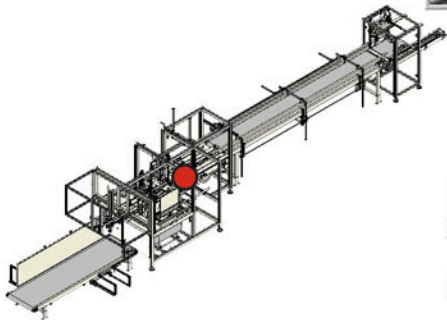
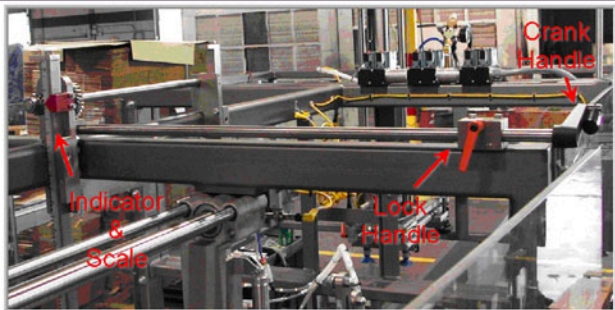


Down & Back  
-- Plate pushed down and to left, handles locked at right-most horizontal position.



## Upper Section

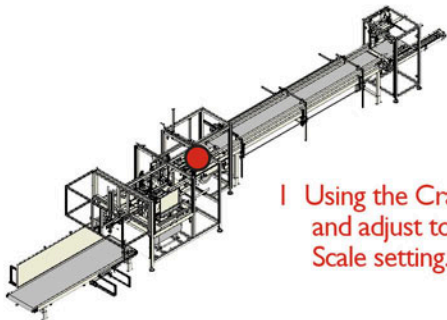
\* The adjustments for the Upper Section are located on the upper-most area of the Machine, between the Erection Section and the Taping Section.



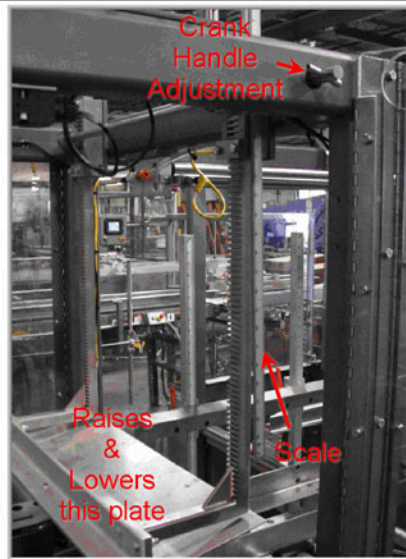
- 1 Loosen the Lock Handle.
- 2 Using the Crank Handle, adjust to the desired Scale setting.
- 3 Re-tighten the Lock Handle.

# Tape Top Guide

\* Located at the entryway of the Taping Section, the Tape Top Guide keeps the Case in place and provides top pressure during the taping process.

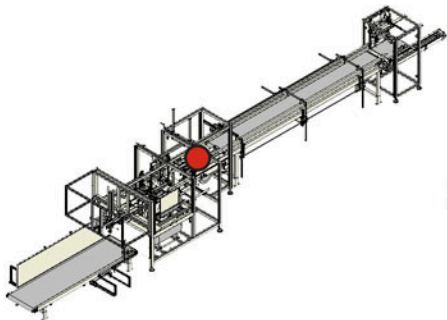
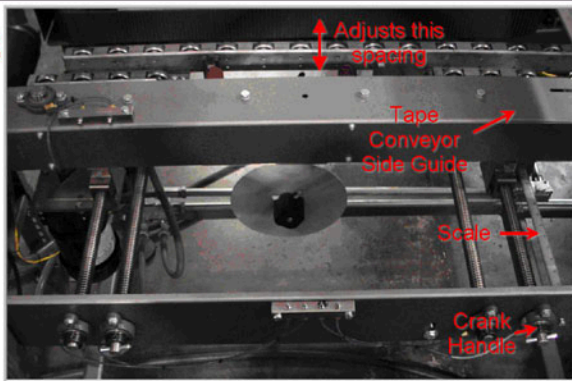


I Using the Crank Handle, turn and adjust to the desired Scale setting.



## Tape Conveyor Side Belt

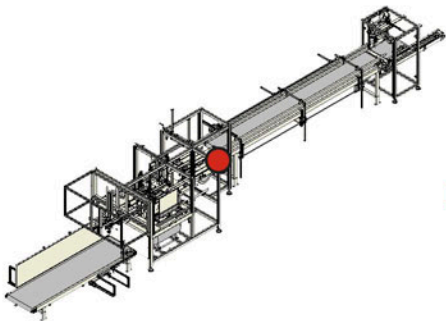
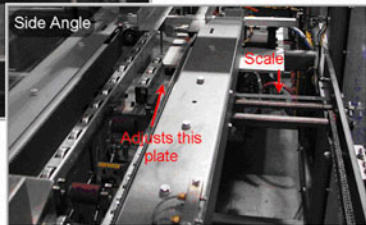
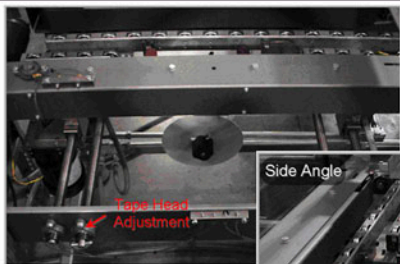
\* The Tape Conveyor Side Belt supports the sides of the Case through the Taping Section.



I Using the Crank Handle, turn and adjust to the desired Scale setting.

# Tape Head

\* The Tape Head uses the left-hand Crank - located in the same area as the Tape Conveyor Side Guide adjustment.



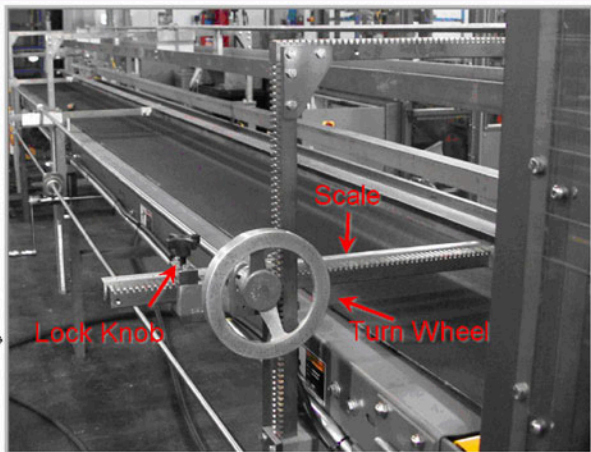
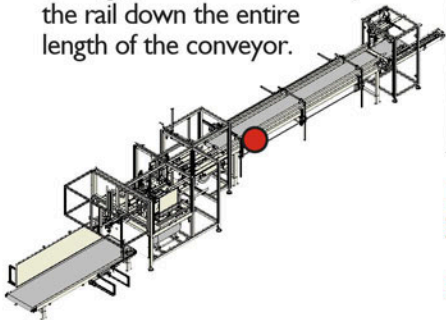
I Using the Crank Handle, turn and adjust to the desired Scale setting.



# Conveyor Side Lower

\* Located on the Discharge Conveyor, the Conveyor Side Lower provides a support rail on the side of the Cases, as they travel down the conveyor.

- This single Turn Wheel will adjust the rail down the entire length of the conveyor.

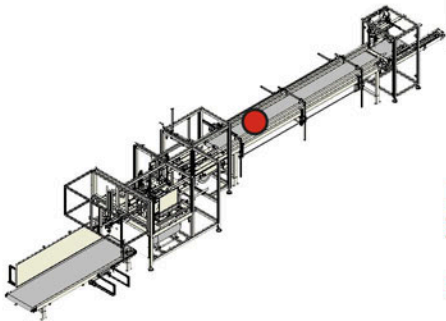


- 1 Loosen the Lock Knob.
- 2 Using the Turn Wheel, rotate until the desired Scale setting is reached.
- 3 Re-tighten the Lock Knob.



# Conveyor Side Upper

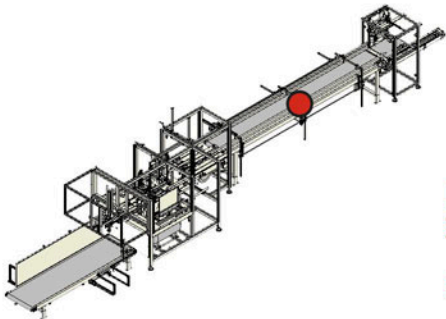
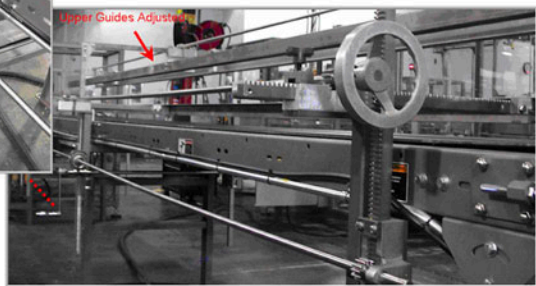
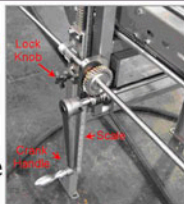
\* The adjustments for the Conveyor Side Upper are located above the bed of the Discharge Conveyor.



- 1 Loosen the Lock Knob.
- 2 Using the Turn Wheel, rotate until the desired Scale setting is reached.
- 3 Re-tighten the Lock Knob.

# Conveyor Side Top

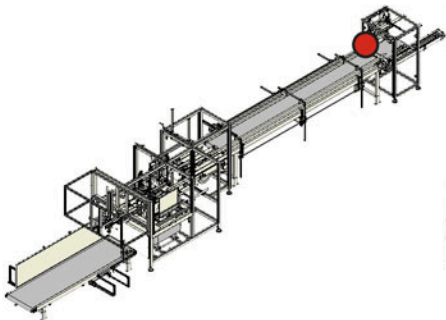
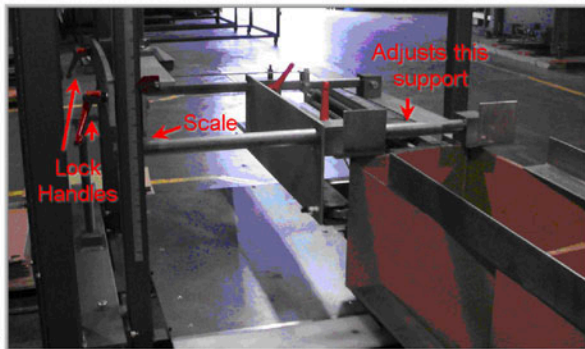
\* Adjusting the Conveyor Side Top will vertically move the upper guides of the Discharge Conveyor.



- 1 Loosen the Lock Knob.
- 2 Using the Turn Wheel, rotate until the desired Scale setting is reached.
- 3 Re-tighten the Lock Knob.

# Transfer Top Support

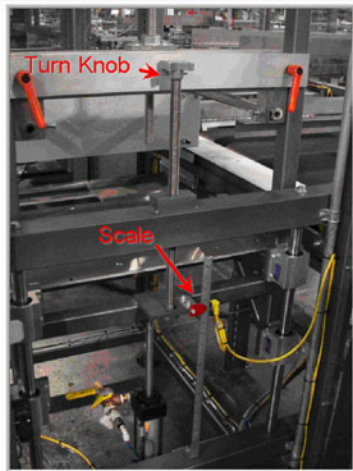
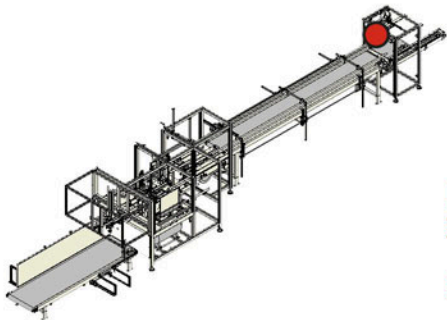
\* The Transfer Top Support helps keep the Case in position when transitioning from the Discharge Conveyor to the Down Elevator.



- 1 Loosen the Lock Handles.
- 2 Adjust to the desired Scale setting.
- 3 Re-tighten the Lock Handles.

# Elevator Cylinder Stop

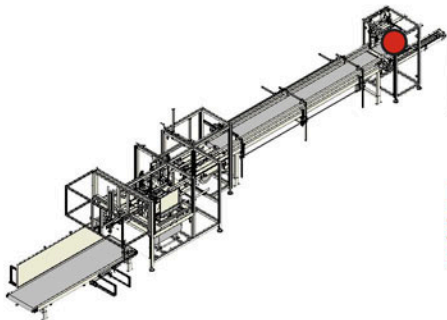
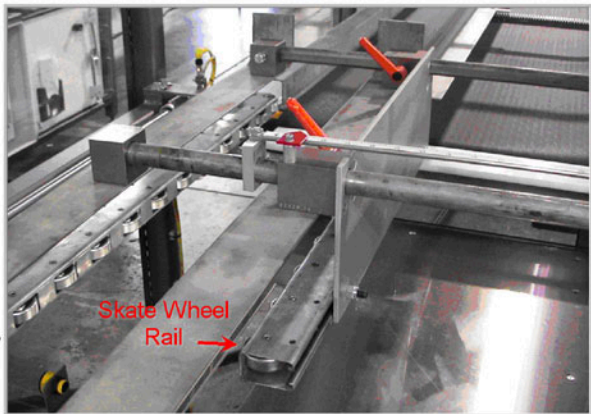
\* The Elevator Cylinder Stop is located on the side of the Down Elevator. This provides a lower stop point for the movement of the elevator.



- 1 Loosen the Lock Handles.
- 2 Rotate the Turn Knob until the desired Scale setting is reached.
- 3 Re-tighten the Lock Handles.

# Top Hold Down

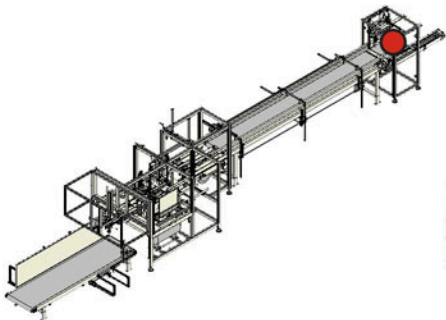
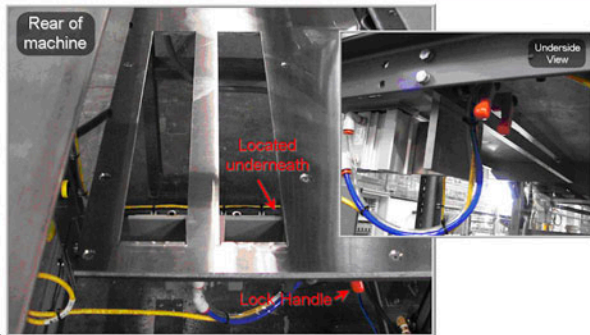
\* Located at the Down Elevator, the Top Hold Down provides side support to the Case.



- 1 Loosen the Lock Handles.
- 2 Adjust to the desired Scale setting.
- 3 Re-tighten the Lock Handles.

## Case Stop

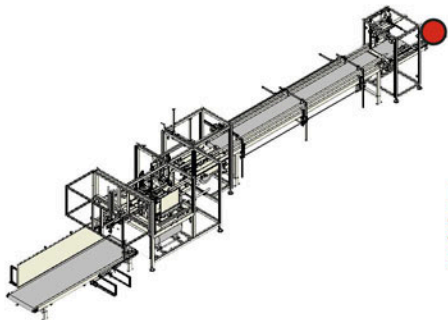
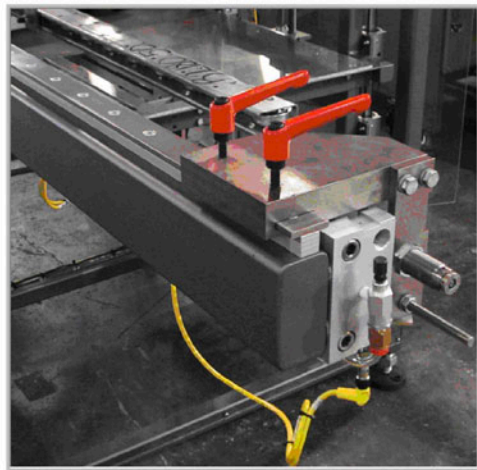
\* Located at the end of the Machine, the adjustments for the Case Stop are located on the underside of the Down Elevator bed.



- 1 Loosen the Lock Handles.
- 2 Adjust to the desired Scale setting.
- 3 Re-tighten the Lock Handles.

# Case Transfer Stop

\* Located at the end of the Machine, past the elevator, the adjustments for the Case Transfer Stop are easily visible.

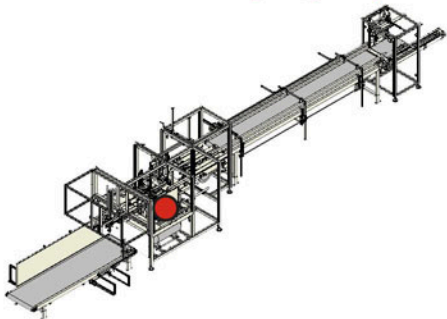


- 1 Loosen the Lock Handles.
- 2 Adjust to the desired Scale setting.
- 3 Re-tighten the Lock Handles.

# Thumbwheel Setting

\* The Thumbwheel Setting (or Box Selection) is located on the Touch Screen.

- 1 From the Main Menu, select Box Recipes.
- 2 At the Box Select Screen, do one of the following:
  - Use the Next & Previous keys to select desired box.
  - Use the Enter Recipe key to input desired box.

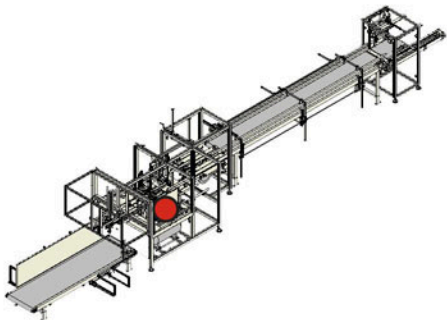


BOX SELECT			
SELECT NEXT BOX	SELECT PREVIOUS BOX	CURRENT RECIPE SELECTED	PRESS TO ACCESS MACHINE DEFAULT SETTINGS
OR ENTER RECIPE #			PRESS TO SAVE (RECIPE SETTINGS HAVE CHANGED)
1	0		
RETURN TO CONTROL		RETURN TO MENU	



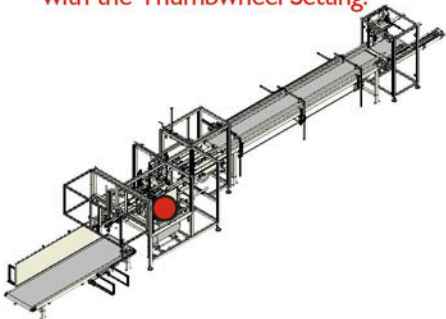
## Tape (Yes/No)

\* For applications where taping is NOT required, the Tape Head must be lowered, out of the alignment for Case processing.

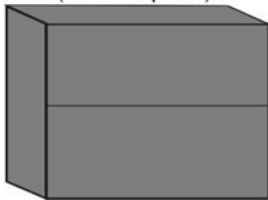


## Reverse (Yes/No)

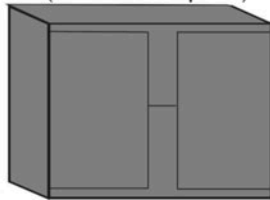
- \* Reverse (Yes/No) is an indicator of the Flap folding sequence of the Minor and Major Flaps.
- The *default* folding sequence has the Minor Flaps on the inside, the Major Flaps on the outside. A **Yes** for reverse indicates that the Minor Flaps will now be on the outside.
- Reverse (Yes/No) setting will automatically adapt with the Thumbwheel Setting.



Major Flaps Outside  
(Default Sequence)



Minor Flaps Outside  
(Reverse 'Yes' Sequence)



# SMURFIT-STONE

*Automated Packaging Systems*



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