



E20G

CASE ERECTOR

QUICK START GUIDE



Welcome

Welcome. And thank you for trusting **INSITE™** Packaging Automation as a partner in your packaging operations. Fifty-plus years of experience have taught us a thing or two about creating simple and reliable equipment. We've leveraged that experience to create industry-leading value within the case erector and case sealer machine categories. We hope that your experience engaging our products is as simple and reliable as the machines themselves.

Contact Us

INSITE™ General Information	
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INSITE™ Technical Support	
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Ready

Inspecting

- We have carefully inspected your Douglas packaging machine before shipment. We have crated your machine securely to ensure delivery without damage or loss of component parts.
- Upon delivery, please inspect your machine immediately for any visible damage or missing parts. Should you discover any damage or shortages, record these on the freight bill and have the delivery driver sign it.
- Uncrate the equipment as soon as possible. If you find any damage, notify the delivery carrier to return for damage inspection. The carrier will provide you with an inspection form. You should file a claim with the carrier, as they maintain responsibility for any damage that occurs during shipping.
- Please notify us if you encounter any damaged shipments. This allows us to provide you and our other customers with the best service possible.

Uncrating

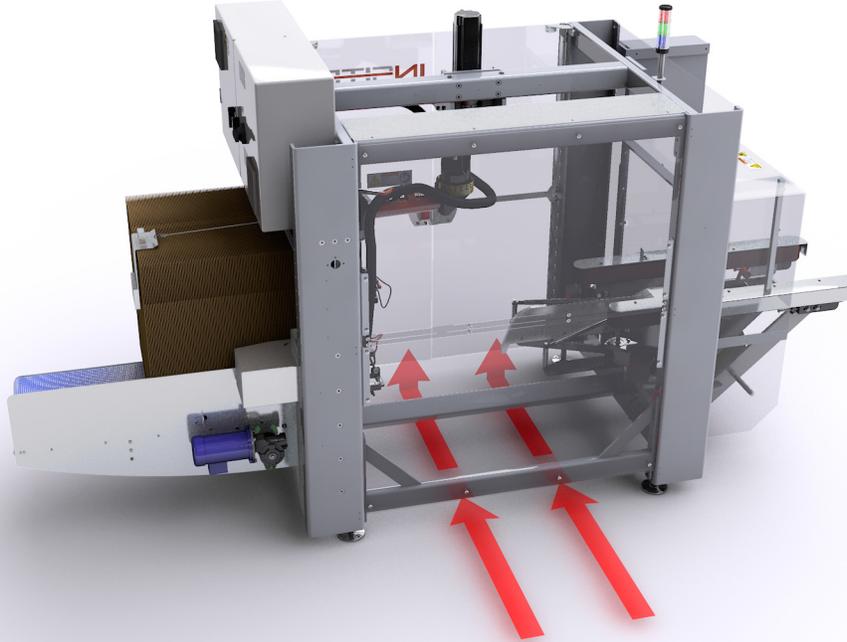
1. After you unload your machine from the delivery vehicle, place the crated machine in its permanent location before removing the shipping crate.

NOTICE

- Do not remove the bottom skid until you have moved the machine within a few feet of the exact production location. This skid makes it easier to move the machine.
 - Floor plan drawings for machine placement are measured from the machine frame and not the guard package.
2. Raise the unit from the skid. The recommended lift points consist of reinforced areas on the underside of the main frame members, near the legs.
 3. Affix any parts that may have been removed and attached to either the inside of the crate, the working surface of the machine, or the skid runners.

Moving

The machine should be lifted at the points shown below.



Aligning

For proper machine alignment, reference infeed, discharge, and all peripheral equipment, consult your plant engineer for specific instructions. This will assure alignment according to your plant's specific needs.



Be aware of pinch points. Pinch points between frames or resulting from component motion may occur during installation.

Leveling

1. Begin leveling at the infeed or discharge end of the machine, depending on any conveyors already in place.
2. The heights and adjustments needed for the machine must be the same as the infeed and discharge conveyors.
 - If the frames being leveled are made of tubing, a laser level must be used. Measure from the top or the bottom of the machine frame at each leg location, adjusting as you go. If the machine needs to be raised or lowered a considerable amount, adjust each leg a couple of turns at a time to bring the entire machine frame up or down together.
 - If the frames being leveled are made of solid bar stock, a high quality level may be used if there is no laser level.
3. Level the first frame in its place. Then slide the next frame up to the first frame and adjust until it matches the first leveled frame. Level the second frame and bolt the two together. Recheck that both frames are level after the frames are bolted together.
4. Repeat the leveling and bolting process as needed for each remaining frame of the machine.
5. After the machine is bolted together and leveled, visually check all transfer decks between the frames for proper alignment.
6. When all frames are leveled, the guard doors should all work freely. If they do not, the guard doors may need to be adjusted. Before adjusting any guard doors, recheck the machine level. Do not adjust the guard doors or switches unless the machine is level.

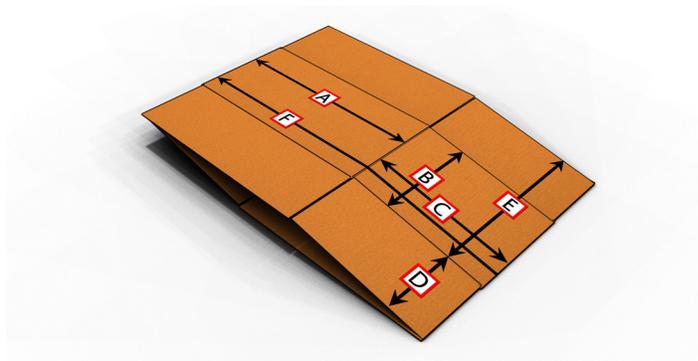
Set

Power & Air Requirements

14A FLA - Glue / 480V 3Ø / 60 HZ

12A FLA - Tape / 480V 3Ø / 60 HZ

Case Measurements



	Direction of Travel (A)	Vertical (B)	Across Machine (C)
Minimum	9.5 inches	4 inches	5.5 inches
Maximum	18 inches	16 inches	16 inches

Changeover Adjustments



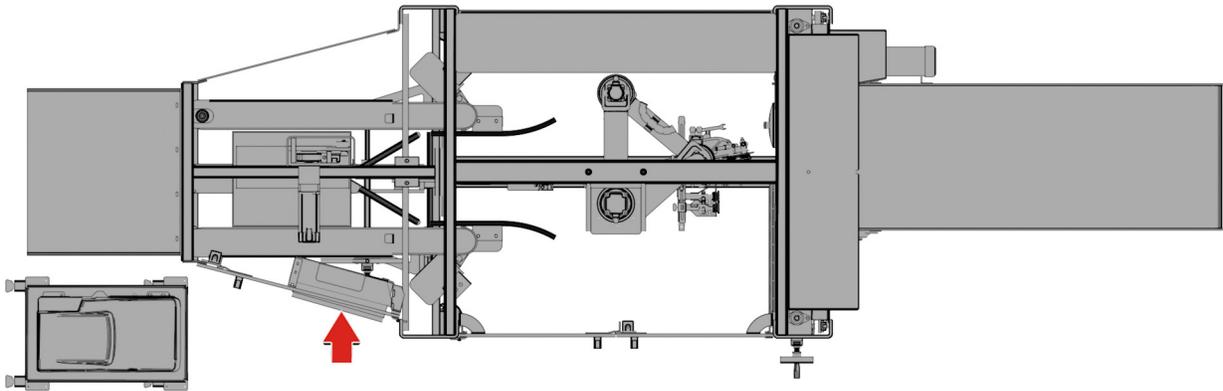
WARNING

All personnel must read and familiarize themselves with the safety precautions before attempting to adjust the machine. Failure to observe these precautions may result in damage to the machine or serious personal injury.

The changeover adjustment chart found on the documentation USB jump drive reflects the machine's original factory settings and can be easily updated to reflect the most current settings. If assistance is needed, please contact our Technical Service Department at 320-763-5507 or email service@douglas-machine.com.

Adjustment 1: Recipe Creation

◀ Left Hand Machine



Make adjustments to the machine before adding case blanks. The machine must be empty to avoid damage.

1. Press the Case Length Value field and enter the length of the case.
2. Press the Case Width Value field and enter the width of the case.
3. Press the Case Height Value field and enter the height of the case.
4. Press the Calculate Recipe button.

(continued)

Douglas
Recipe Creation
3/2/2018 8:15:17 AM

Menu
X
Message Appears Here
Reset

Active: s...s

Dimensions	Value	Units
Case Length	###.##	S...S
Case Width	###.##	S...S
Case Height	###.##	S...S
Pick Adjust X	###.##	S...S
Pick Adjust Y	###.##	S...S
Pick Adjust R	###.##	S...S
Drop Adjust X	###.##	S...S
Drop Adjust Y	###.##	S...S
Drop Adjust R	###.##	S...S
Rack Open Adjust	###.##	S...S

Recipe Calculation Percent:
###

Calculate Recipe

Changeover Position

Changeover Settings

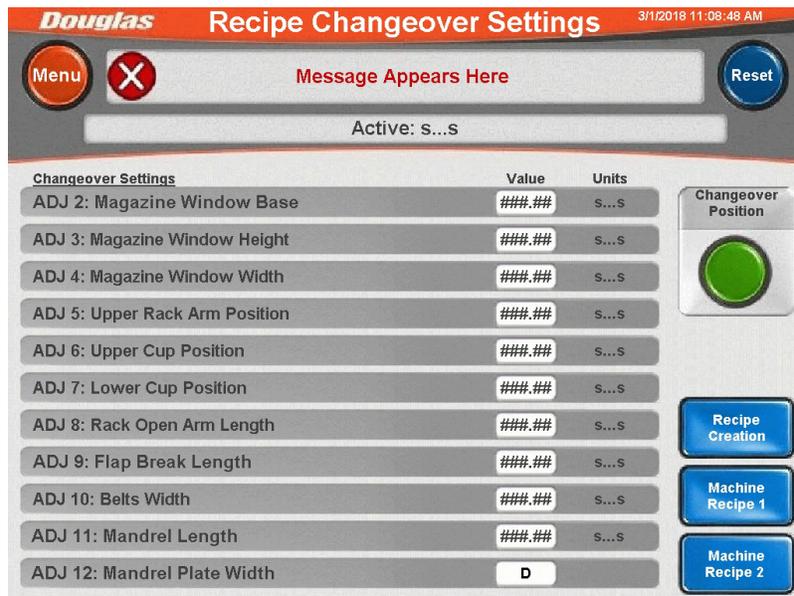
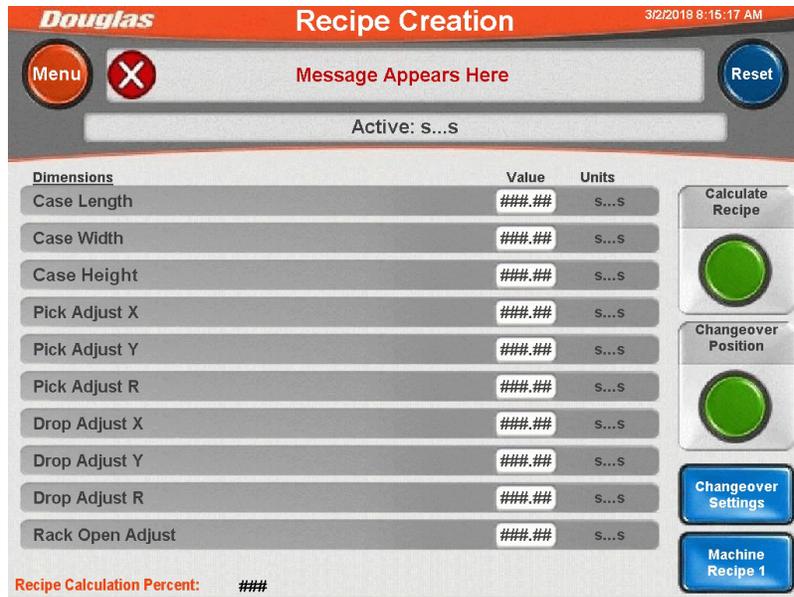
Machine Recipe 1

Adjustment 1: Recipe Creation (continued)

The Calculate Recipe button will turn into a red Cancel Calculation button while the machine is calculating the changeover settings for the new recipe. The Recipe Calculation Percent display tells you how much of that calculation has been completed.

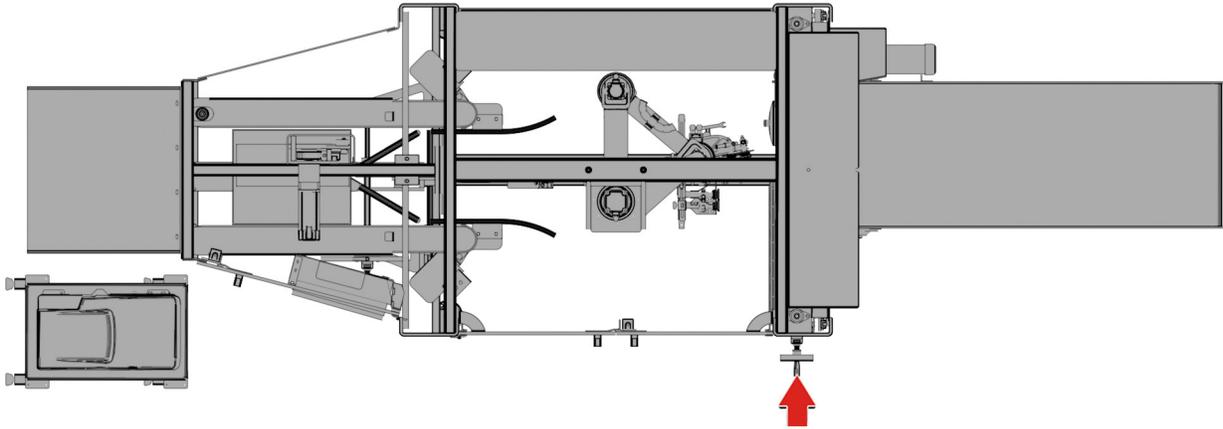
5. Press the Changeover Position button. The robot arm will move to its changeover position near the guard door.

6. Press the Recipe Changeover button to open the Recipe Changeover Settings Screen. The changeover settings for the current recipe will display.



Adjustment 2: Magazine Window Base

◀ Left Hand Machine

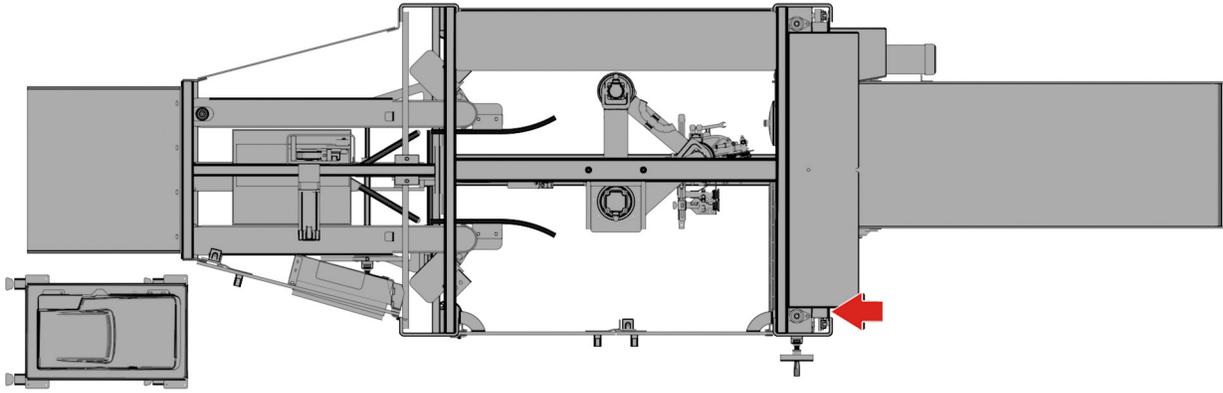


1. Turn the handratchet to the correct position indicator setting.



Adjustment 3: Magazine Window Height

◀ Left Hand Machine

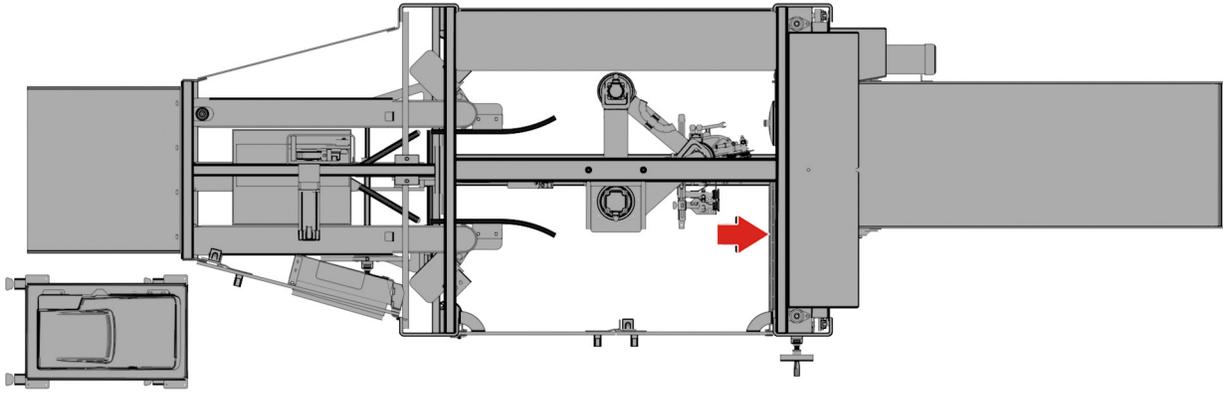


1. Pull the pin.
2. Use the handle to position the magazine window height to the correct scale setting.
3. Push in the pin to secure.



Adjustment 4: Magazine Window Width

◀ Left Hand Machine

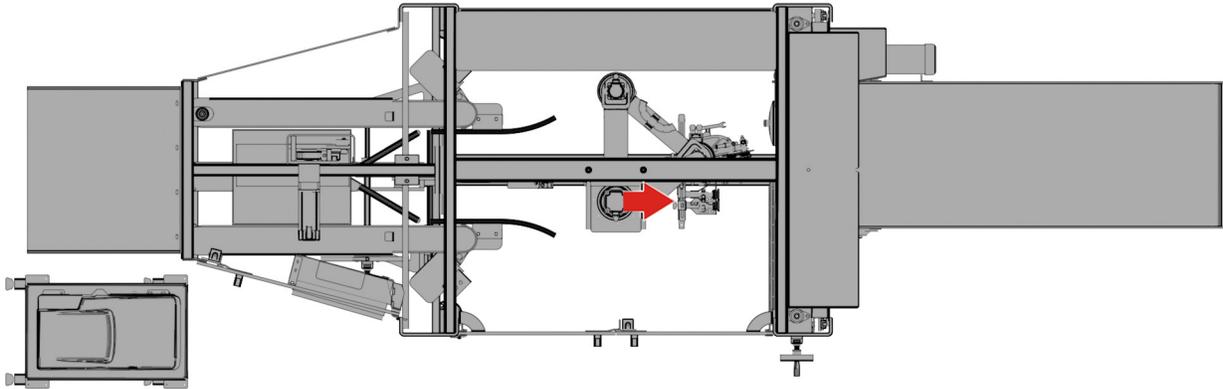


1. Unlatch the clamp.
2. Use the handle to position the magazine window width to the correct scale setting.
3. Latch the clamp to secure.

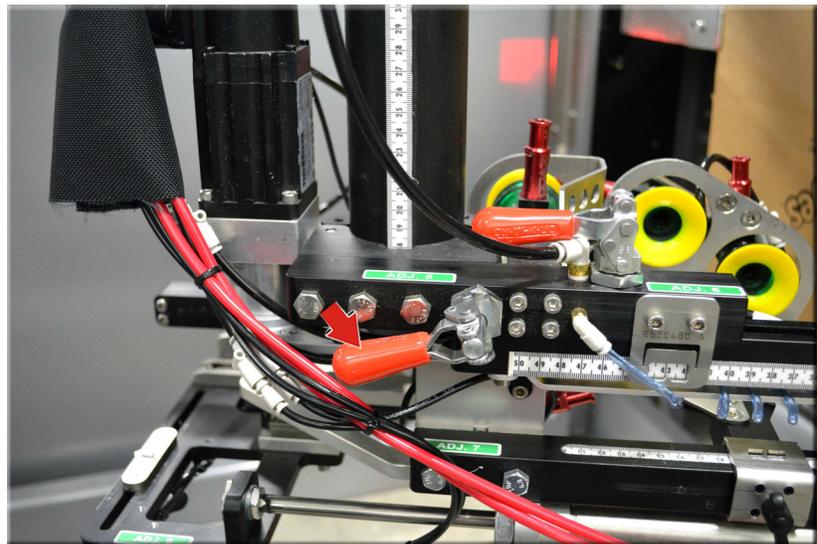


Adjustment 5: Lower Cup Position

◀ Left Hand Machine

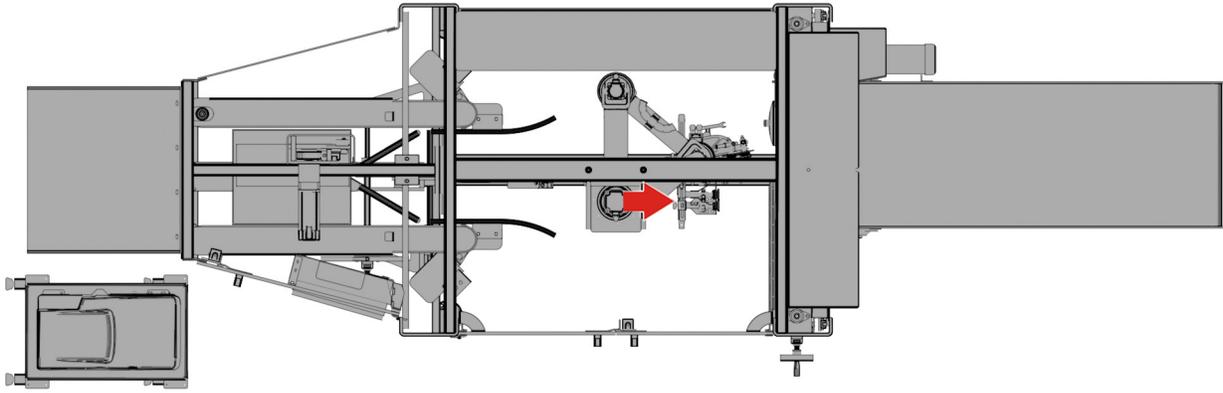


1. Unlatch the clamp.
2. Position the lower cups to the correct scale setting.
3. Latch the clamp to secure.

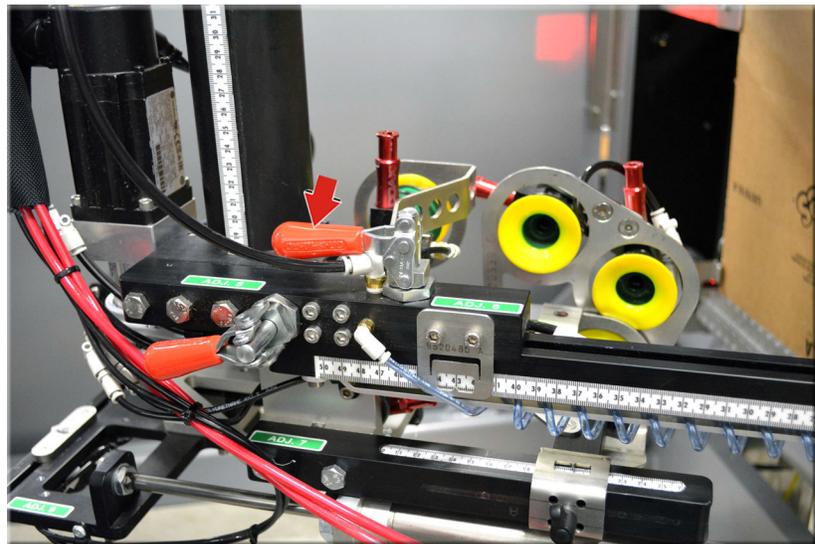


Adjustment 6: Upper Cup Position

◀ Left Hand Machine

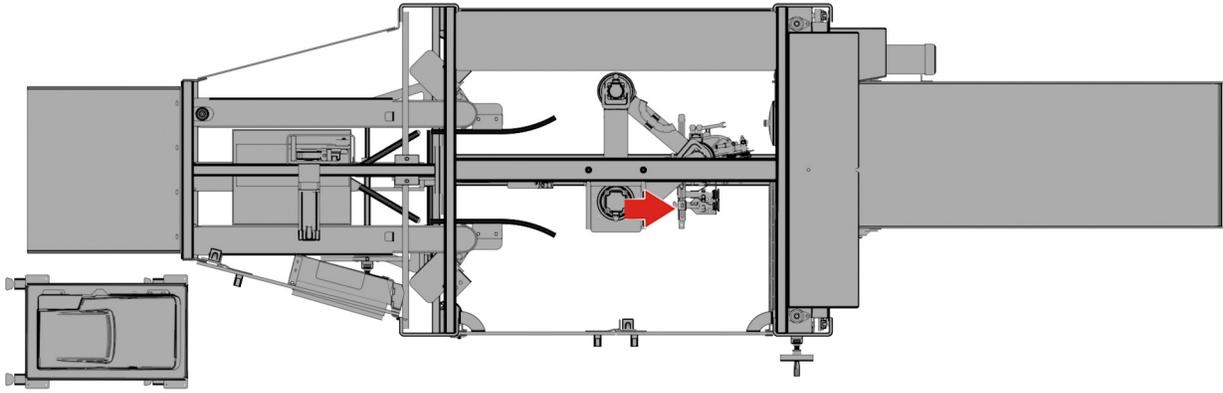


1. Unlatch the clamp
2. Position the upper cups to the correct scale setting.
3. Latch the clamp to secure.



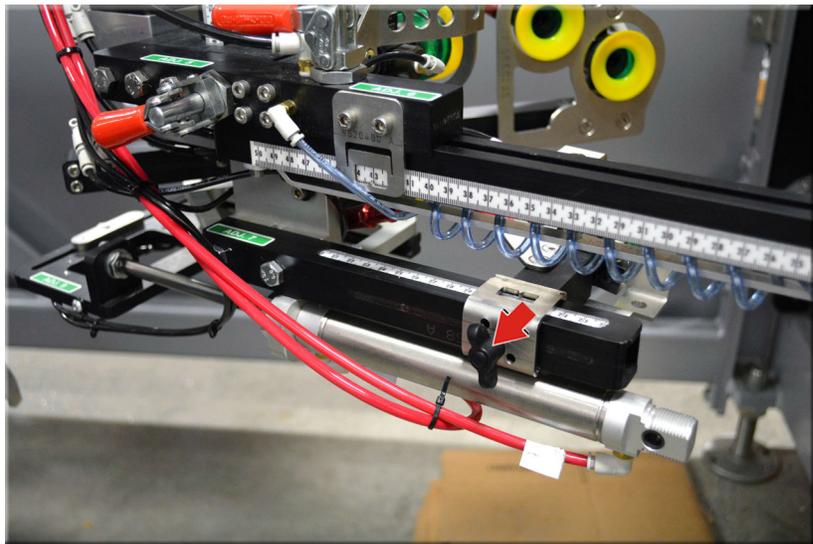
Adjustment 7: Rack Open Arm Length

◀ Left Hand Machine



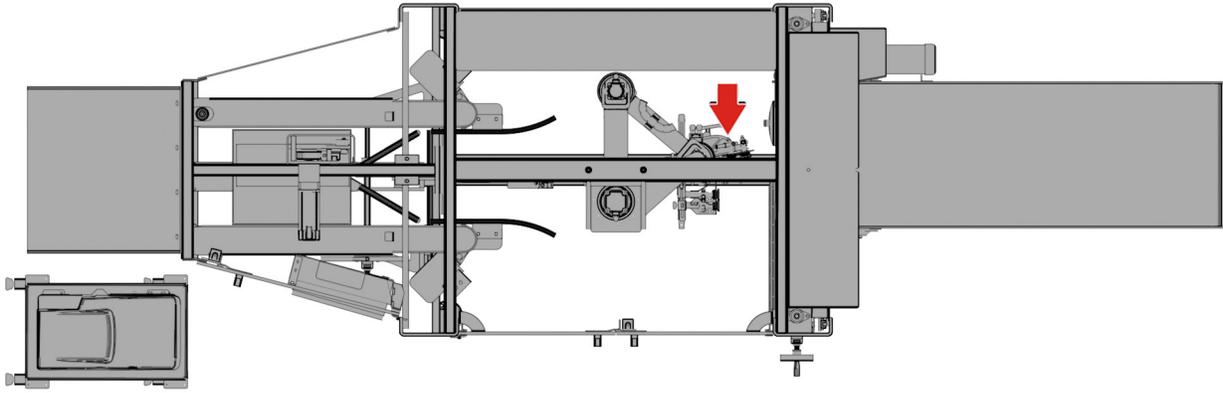
For cases shorter than 12" long, remove the Rack Open Arm Length change part. This direction will display on the HMI.

1. Loosen the hand knob.
2. Position the Rack Open Arm Length to the correct scale setting. (Remove the arm if you are running a case shorter than 12" long.)
3. Tighten the hand knob to secure.



Adjustment 8: Upper Rack Arm Position

◀ Left Hand Machine

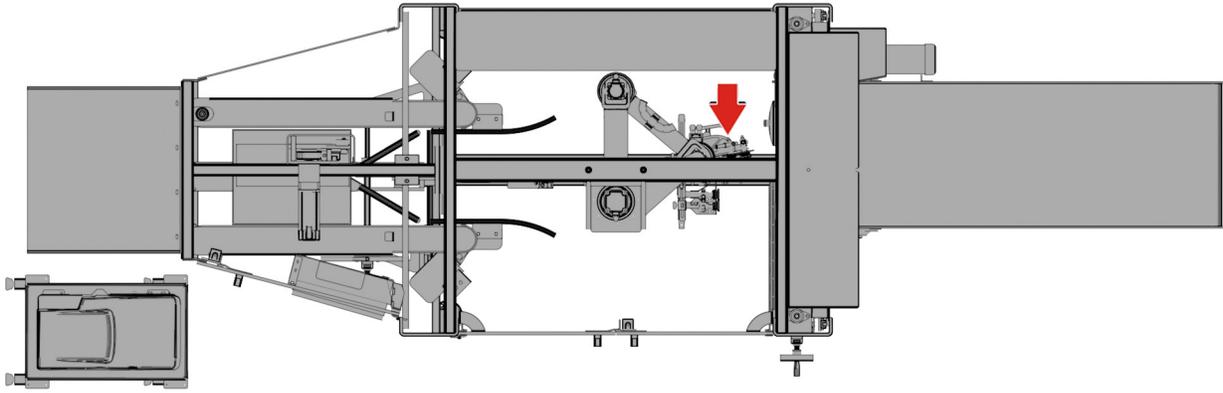


1. Loosen the hand knob.
2. Position the upper rack arm to the correct scale setting.
3. Tighten the hand knob to secure.

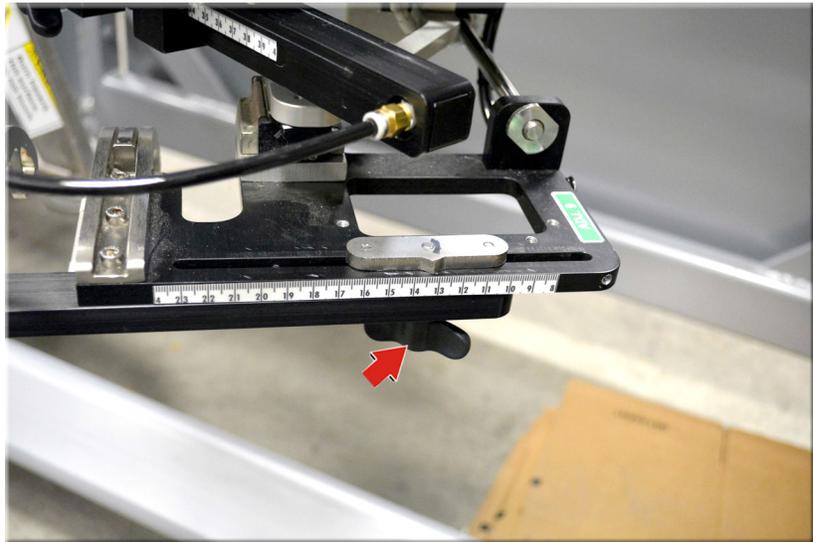


Adjustment 9: Flap Break Length

◀ Left Hand Machine

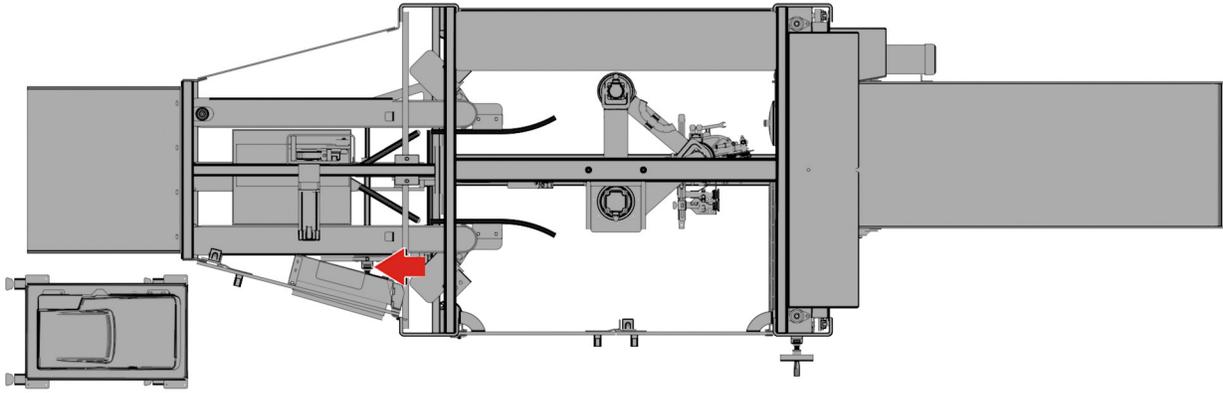


1. Loosen the hand knob.
2. Position the flap break length to the correct scale setting.
3. Tighten the hand knob to secure.



Adjustment 10: Belts Width

◀ Left Hand Machine

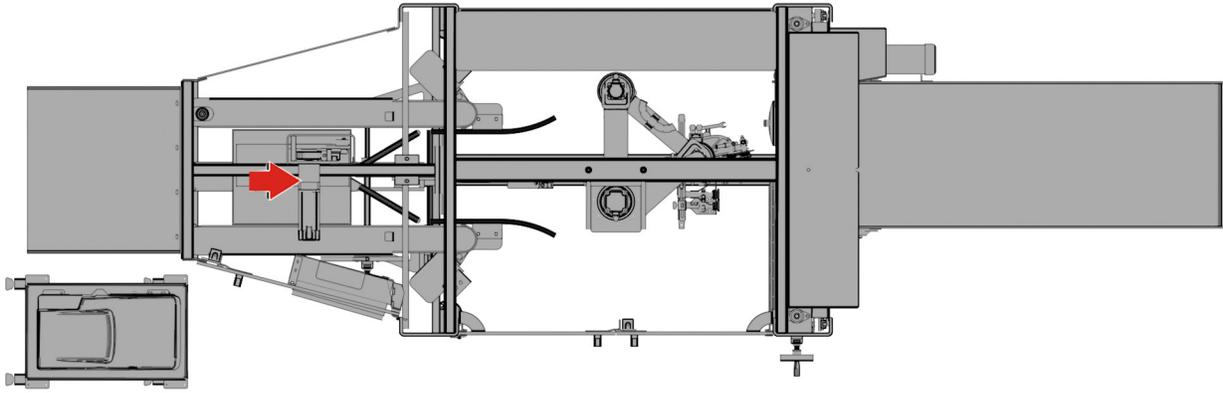


1. Loosen the handlever.
2. Turn the handwheel to the correct position indicator setting.
3. Tighten the handlever to secure.



Adjustment 11: Mandrel DOT

◀ Left Hand Machine

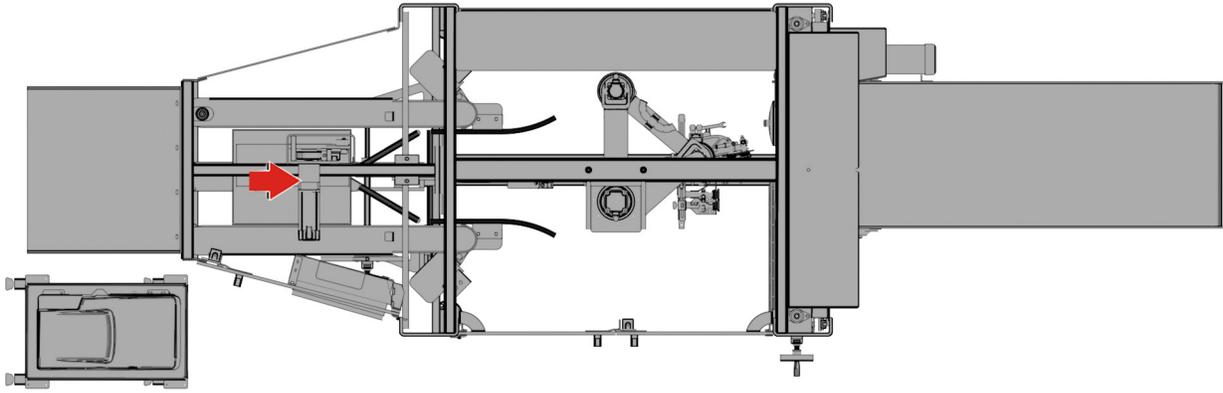


1. Loosen the handlever.
2. Position the mandrel DOT to the correct scale setting.



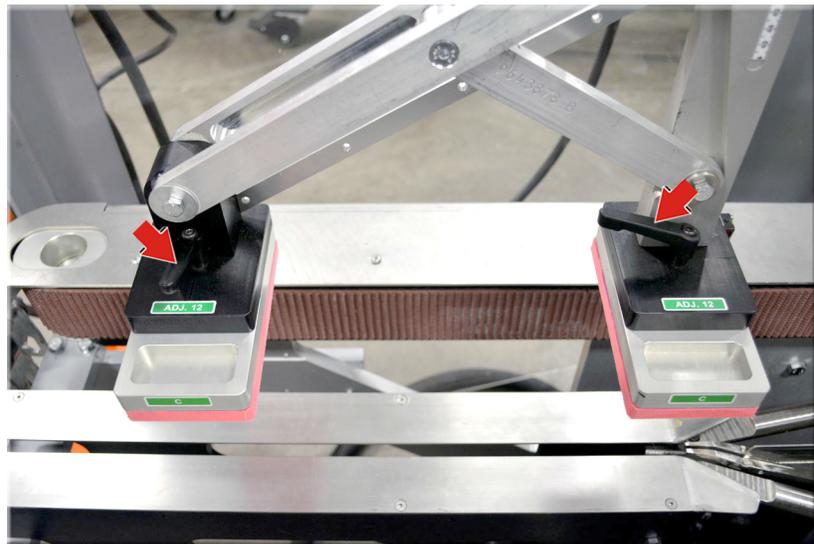
Adjustment 12: Mandrel Plate

◀ Left Hand Machine



At each adjustment location (two total):

1. Loosen the handlever.
2. Remove the mandrel plate chage part and replace it with the correct change part.
3. Tighten the handlever to secure.



Go

NOTICE

Before operating the machine, all personnel must read and familiarize themselves with the safety precautions in the Safety section of the Owner's Manual. Failure to follow these precautions may result in damage to the machine and/or serious personal injury.

Machine Startup

1. Make sure the machine has power.
2. Turn the main disconnect to the On position.
3. If needed, set up a new recipe on the Recipe Creation Screen.
4. Complete the changeover adjustments as outlined in the Changeover section of the manual.
5. On the Machine Controls - Auto Screen, press the Machine Start button.

Machine Shutdown

1. On the Machine Controls - Auto Screen, press the Cycle Stop button.
2. Power down the HMI.
3. Turn the main disconnect to the Off position..



DANGER

Personnel entering the guard package without first locking out the power risk accidental restart and potential serious injury or death. Do not enter the machine without first performing the lockout/tagout procedure required by your facility.