

TIP 0305-42

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Folding section

Scope

What are the causes and remedies for folding sections of Flexo Folder Gluers?

Safety precautions

Warning-Follow all manufacturers safety instructions at all times. When removing defective material insure that all lock out/tag out procedures are followed.

Content

Folding section

<i>Problem</i>	<i>Cause</i>	<i>Remedy</i>
Insufficient glue being applied to box	Out of glue	Replenish glue supply.
	Insufficient flow of glue	Increase flow from pump or clean lines.
	Contaminated glue mechanism	Clean as required.
	Kinked hose	Remove kink.
	Poor pump output	Check and replace impeller as necessary.
	Viscosity too high	Check viscosity against manufacturer's Recommendation.
	Excessive clearance between applicator and pressure wheel	Adjust to proper gap.

TIP Category: Automatically Periodically Reviewed (Ten-year review)



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<i>Problem</i>	<i>Cause</i>	<i>Remedy</i>
Leaking glue shoe	Too little clearance between applicator and pressure wheel	Adjust to proper gap.
	Viscosity too low	Check against manufacturer's minimum recommendation.
	Metering shoe not seated properly on wheel	Remove any buildup of dried glue, scrap, or paper dust. Ensure maximum viscosity of manufacturer is not exceeded.
	Return hose kinked	Remove kink.
	Metering shoe not seated properly on glue wheel	Remove any buildup of dried glue, scrap, or paper dust. Adjust fit.
	Improper glue viscosity	Ensure maximum/minimum viscosity is not exceeded.
Inconsistent folding; fishtailing	Excessive glue	Reduce flow.
	Shoe and/or wheel worn or damaged	Replace as necessary.
	Upper or lower folding rails not properly positioned	Check dimensions and adjust as necessary.
	Carrying belts not equally tensioned	Adjust belt tensioning device and equalize both sides.
	Improper folding motion	Adjust to more gradual, continuous fold.
	Slot and crease alignment incorrect	Align score to center of slot.
	Improper score	Set for proper scoring.
	Worn belts	Replace as necessary.
	For upper belt folders; upper belt speed inconsistent with lower belt speed	If available, trim upper belt speed with rheostat; check and adjust synchronization with tachnometer.
	Folding rails out of parallel	Reparallel folding rails.

