

TIP 0305-44

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Counter ejector section

Scope

What are the causes and remedies for the counter ejector sections of flexo folder gluers?

Safety precautions

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

<i>Problem</i>	<i>Cause</i>	<i>Remedy</i>
Jamming at counter ejector	Loose liner	Remove defective blanks
	Skewed blanks	Adjust pull roll collars
	Sheet slippage	Worn belts—replace
	Side guides and folding rails improperly set	Adjust clearance between upper and lower folding rails
	Hold-down blower improperly positioned or inoperative	Reposition or repair
Boxes not sealing	Improperly timed spanker	Retime sprinkler
	Hold-downs improperly positioned	Reposition the hold-downs over the glue joint
	Insufficient or excessive glue film or improper glue formulation	Adjust application, or change formulation
Incorrect stacking	Too much pressure by compression bar or hold-down	Use minimum pressure from compression bar or hold-down
	Box count too high	Decrease box count
	Boxes not hitting backstop	Speed up understacker and/or reset backstop

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



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<i>Problem</i>	<i>Cause</i>	<i>Remedy</i>
Boxes not being delivered from Bottom of squaring hopper	Boxes glued together	Check glue applicator for drips
		Check for short sheets
		Check to see that glue laps are being completely cut and waste is being removed
	Box hanging up on gates	Gates too tight; adjust
Dragging blanks at pushoff	Boxes releasing from gates two at a time or wedging at gates	Gates too loose; adjust
	Boxes hang up in hopper	Backstop too tight; adjust
	Pusher partially contacting the top blank of the subsequent pile	Readjust the pusher height
Pusher operates erratically	Defective box counter	Replace counter
	Dirt on electric eye	Remove dirt from electric eye
Incorrect count	Pusher	Check pusher height and readjust if necessary
	Hold-down height incorrect	Readjust hold-down height
	Defective box counter	Replace counter
	Dirt on electric eye	Remove dirt from electric eye
Bundles not being delivered from ejector	Delivery belts not running	Turn on delivery belt drive
Boxes out of square and/or fishtailed	Pull rolls improperly set or worn	Reposition, or replace
	Squaring device improperly set	Adjust
	Blanks skewed before scored	Refer to slotting section and folding section charts

Keywords

Counters, Folder gluers, Maintenance

Additional information

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