

Function Description

Overlapped Cartons

If "Overlap" is turned ON (on the Off/On Page) then the system will shut the machine down for an overlap when it gets to the reject trigger. It will only try and reject the overlap (2nd carton) if it was detected as overlapped at a PREVIOUS trigger ("trigger X long by XX.X"), and then SEPERATED by the time it reaches the reject trigger....

This actually happens quite a lot, if it is "only just" overlapping (5 or 10mm) - because the trombone is running so much faster, it tends to pull the overlaps apart.

The theory behind this is that the front carton is "may or may not" be good - but all stations would have received a trigger, so it was glued/detected fully, and it is treated the same as any other carton. The back carton though is always assumed as bad, because it's leading edge was not visible (for at least one of the stations), so we do not KNOW if it is good or bad, thus IF it pulls apart and becomes a separate carton again, we always reject it.

If we were to instead shut the machine down, it would be difficult for the operator to see WHY - the cartons in the trombone section would all appear to be OK... there is then a big risk that the operator would just restart the machine, and the second carton (which MAY be bad) would be allowed to pass through the machine...

The only way to get around their issue would be to shut down for the overlap earlier. All systems have the option of detecting (shutting down) for overlaps at the feed (if turned on), and on newer systems ANY trigger (even triggers not assigned to another station) can be assigned as an overlap detector from the trigger page in System setup. In all of these cases, the gluer will be stopped as soon as the overlap is detected (because otherwise it may separate again and then be allowed through by the operator just like I described above).