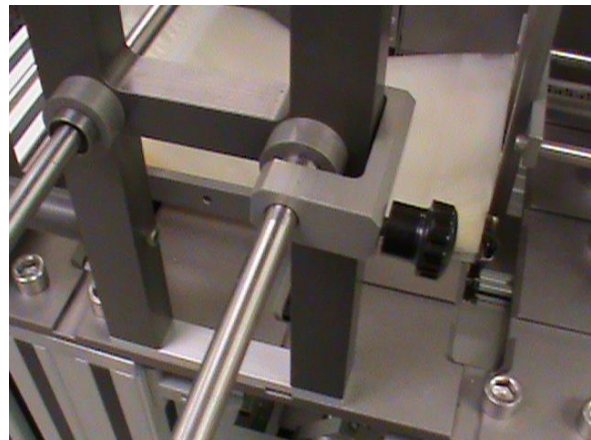


## ***ADJUSTABLE POUCH MAGAZINE***

The pouch magazine of the system is designed and intended to accommodate a variety of pouch sizes. It is easily adjusted without the use of tools by loosening thumb screws and sliding guide rails into place. The pouch is always justified toward the operator and against the fixed wall of the magazine. The bottom and side guide rails can then be adjusted to within about 1/8" of the pouch and the thumbscrews tightened.

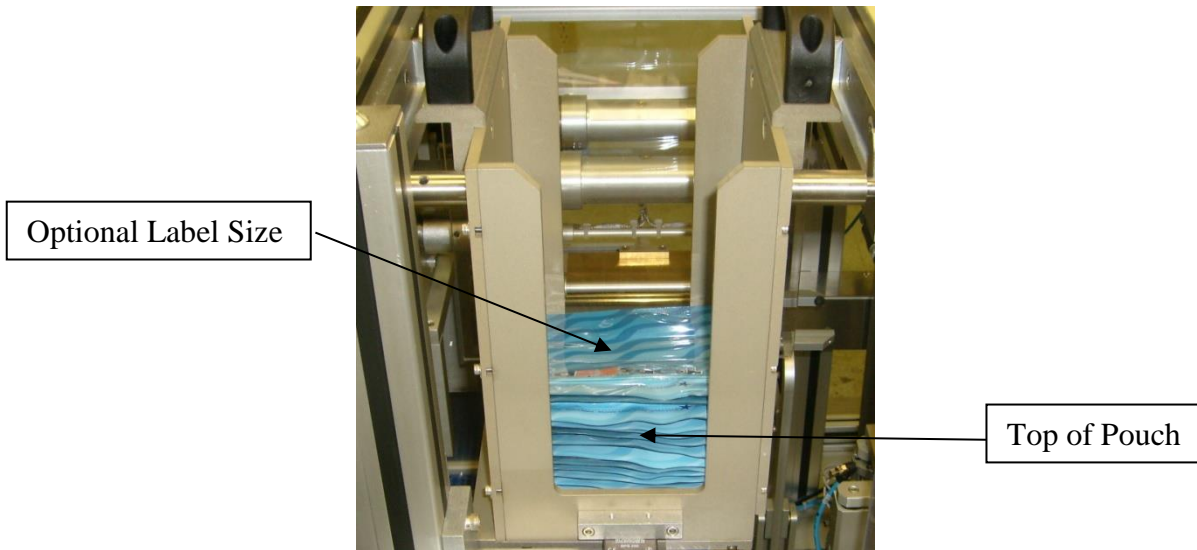


Pouches can be loaded into the magazine without interrupting machine operation. If the magazine is depleted of pouches, the system will generate a vacuum error while trying to remove a pouch and halt operation. The pouch feed arm will try to remove a pouch three (3) times before halting operation. This is to ensure that the pouches are depleted and allows the system to continue if pouches are present.

There are adjustment fingers located on the side / bottom of the magazine where the pouch is removed from the stack. These fingers help retain the rest of the stack during removal of the bottom pouch. These fingers should be adjusted as low as possible but not to interfere with the vacuum plate and its cups. If interference exists, pouches will be ripped off the leading cups or you may hear a slight clicking as the pouch is removed from the magazine. The magazine may also jump a bit during removal. Any of these conditions require adjusting one or more of the fingers a bit higher. The fingers should be adjusted so they are approximately level with the top of the base plate.

## ***POUCH CONDITIONING & MAGAZINE LOADING***

Pouches are to be loaded with the (optional) label side facing up and the open end facing toward the operator as shown below. Any zippers must be presented OPEN.



Pouches should be handled in a comfortable number and quickly stacked so that top (open end) edges are somewhat aligned. Non-zipper pouches require far less care and can be handled like a deck of cards during conditioning.



Make sure all pouches are facing the same way and that they are loaded into the magazine as neat as possible. When the magazine is completely empty, it is recommended to carefully place 2 or 3 pouches in position to create a good base, then load small stacks of about 20 pouches on top of those. The total number of pouches that a magazine can successfully hold is dependent on pouch size, configuration, and stability.

If the top edges of the pouches have any curl to them, it is best to try and flatten them out (within reason) before loading. The flatter the pouches are before being loaded into the magazine, the better the system will perform.