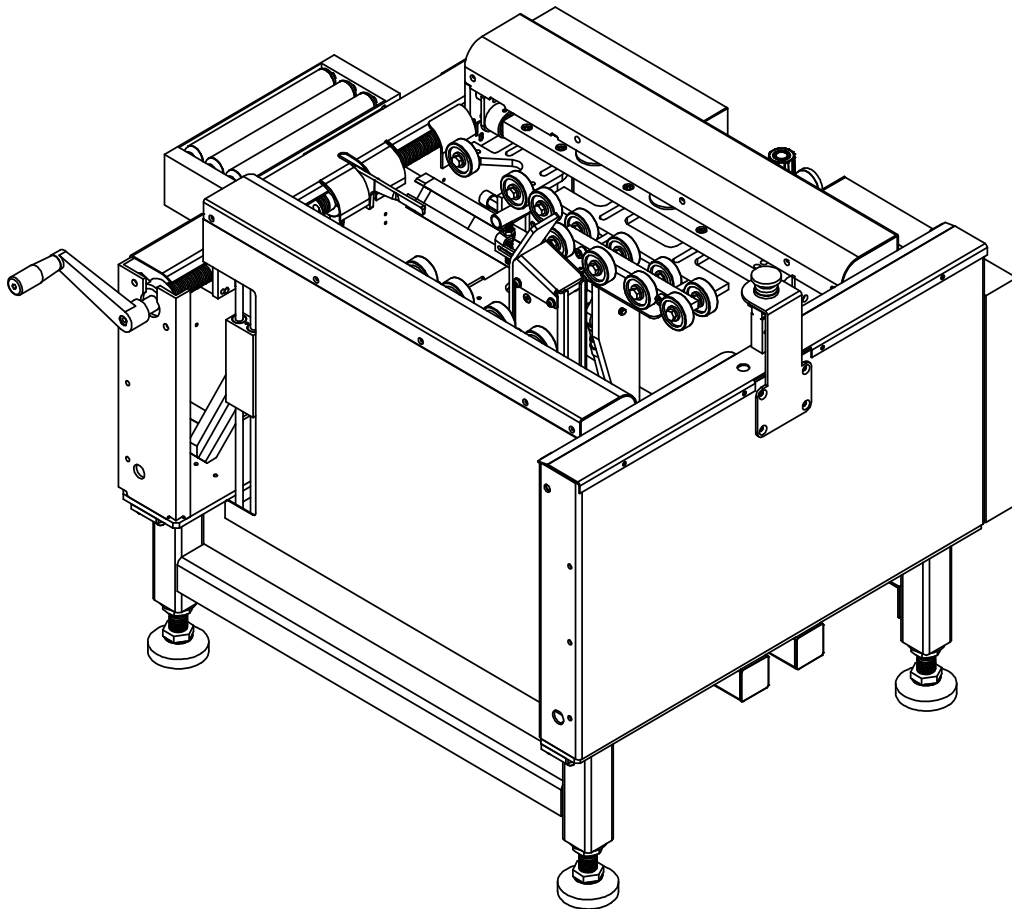


EX-CF

Industrial Semi-Automatic Case Former

User Guide



EASTEY®

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EX-CF

Industrial Semi-Automatic Case Former

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P/N EXCF1000 Rev. D

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Eastey
7041 Boone Ave. N.
Brooklyn Park, MN 55428

Phone: (763) 428-4846; Fax (763) 795-8867; 1-800-835-9344
www.eastey.com

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We Help Companies Deliver Products to the World

Thank you for choosing the Eastey Industrial Semi-Automatic Case Former for your packaging needs. Eastey is part of Engage Technologies, an ISO 9001-2015 certified company that has steadily built a solid reputation for quality since 1979. Engage is known for providing rugged, durable, reliable packaging equipment to help companies deliver their products to the world.

Each Engage Technologies company – Squid Ink, Eastey, and American Film & Machinery (AFM), focuses on a different part of the packaging section of the production line.

ENGAGE *technologies corporation*



Squid Ink (www.SquidInk.com)

Coding and marking equipment, inks, and fluids for product identification and traceability



Eastey (www.Eastey.com)

Automated shrink wrapping and bundling, automated case sealing, case erecting and product handling



AFM (www.AFMSleeves.com)

Automated shrink sleeve labeling equipment, tamper-evident banding equipment, shrink tunnels and shrink sleeve consumables

When you purchase your packaging equipment from the Engage Technologies family of companies, you can feel confident that you have a machine that is first in quality and built to last. Thank you for choosing us for your packaging needs.

Safety

Safety Precautions

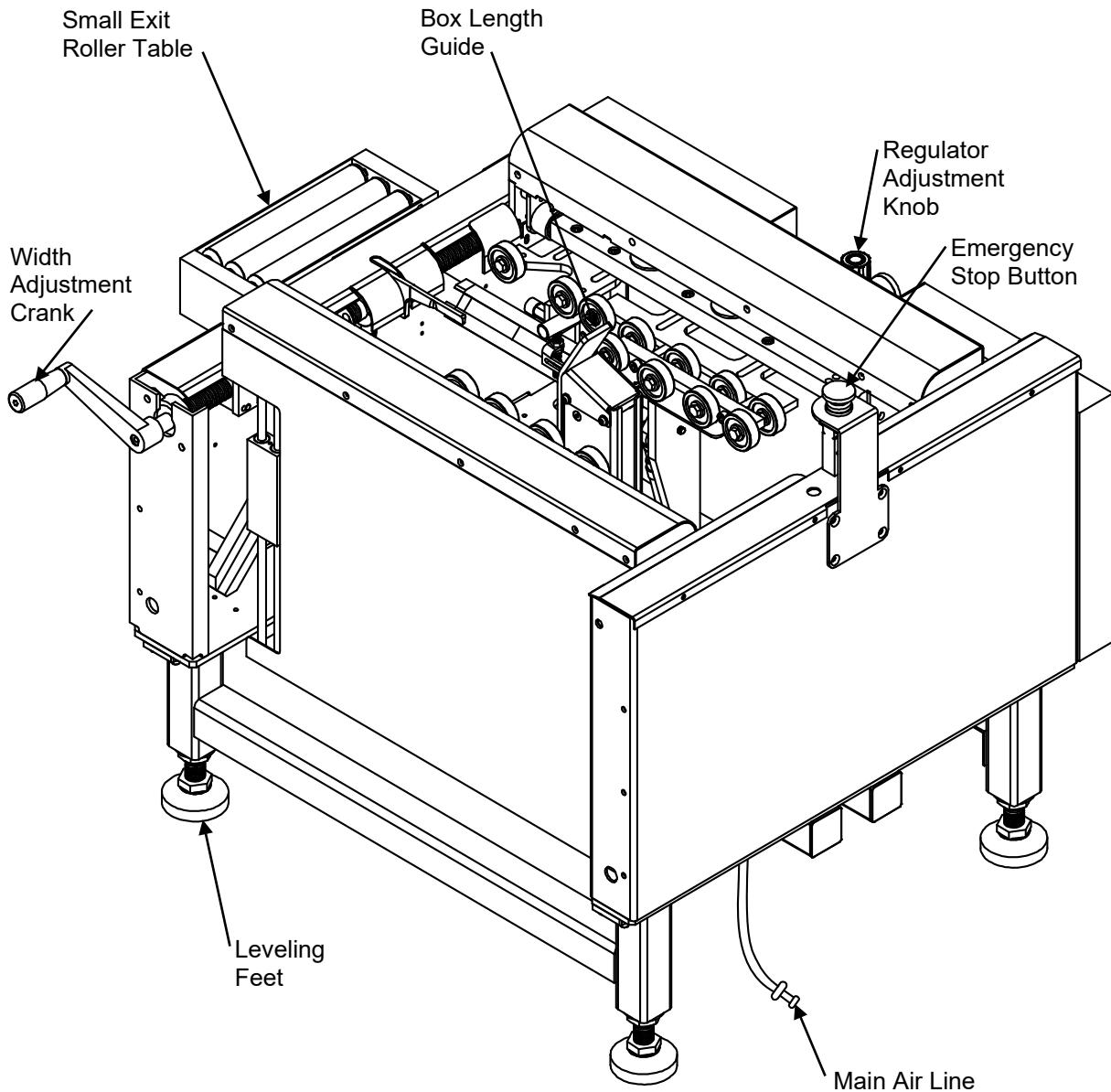
Before installing, operating or servicing this equipment, please read the following precautions carefully:

- This machine is equipped with moving parts. Do not place hands near the rear of this unit when the flap folders are moving as fingers may be pinched where belts enter the frame.
- Do not by-pass any factory-designed safety features such as, interlocks and/or switches, etc.
- Never provide service or clear a box jam when machine is running. Activate the red emergency stop button by pressing it down then shut off and disconnect the air supply and make sure the machine is secure before attempting to clear a jam or perform any adjustment or maintenance.
- Do not place hands or body inside the confines of the machine.
- Do not wear loose clothing such as ties, scarves, jewelry etc. Long hair should be pulled back and/or covered while operating this machine.

Introduction

Semi-Automatic Case Former Overview

The Easteley Semi-Automatic Case Former is very easy to set up and operate. The EX-CF uses air pressure for operation. There are no electrical components on the EX-CF Case Former.



Specifications

EX-CF Semi-Automatic Case Former Machine Specifications			
Machine Dimensions	Machine Length: 41.6 in. (105.6 cm) Machine Width: 37.4 in. (95.0 cm) Machine Height: 32.3 in. (82.0 cm) – See Adjustment below.		
Machine Net Weight	285 lbs. (129 kg)		
Air Requirements	30 L/min. (6kg/cm ² , 80psi)		
Case Dimensions	Case Length	Case Width	Case Depth
Minimum Box Size	8 in. (20.3 cm)	6 in. (15.3 cm)	3.5 in. (8.9 cm)
Maximum Box Size	25.5 in. (64.7 cm)	19 in. (48.2 cm)	No Height Limit

EX-CF Specifications

Machinery Makeup: Industrial strength 12-gauge steel, powder coated for durability, with stainless steel wear surfaces.

Conveyor Height Adjustment: 23.75 in. (60.3 mm) to 29.75 in. (75.6 cm) with leveling legs; 27.75 in. (692mm) to 33.25 in. (845mm) with optional casters.

EX-CF Features

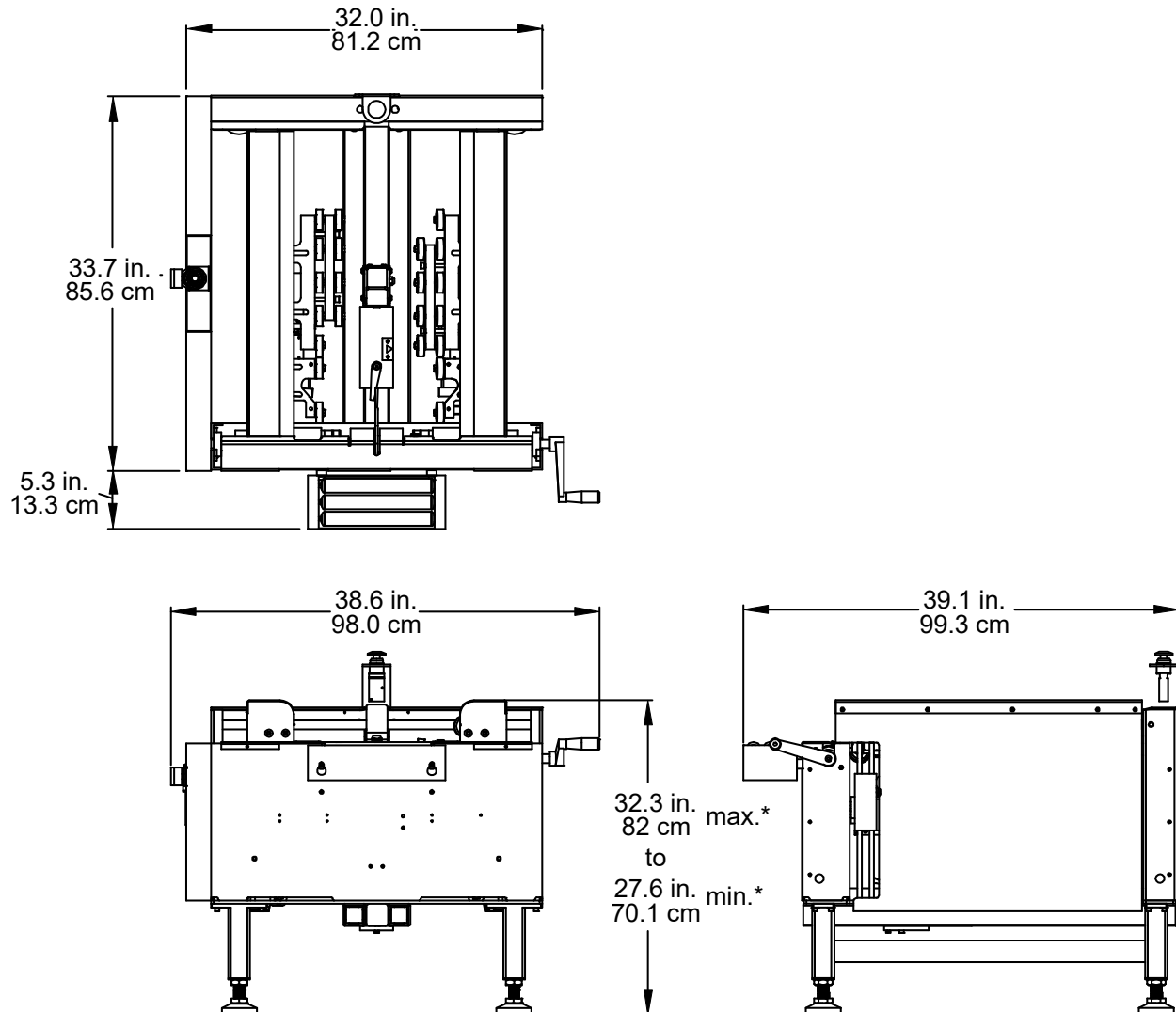
- Plug-in and go operation
- No electrical requirements — Air only operation with emergency stop
- Adjustable side guides
- Adjustable foot extensions
- Fast and easy box size changes with adjustable folding/revolving crank handle
- Low maintenance
- Accommodates wide case size range
- Roller extension included for wide boxes
- Small exit roller table included

Options

- Optional casters are available for movement within your plant

Dimensions

All dimensions are shown in inches and centimeters.



***Note:** Height dimension values are shown with leveling legs. Optional casters add 3.5 inches to maximum and minimum height.

Installation

Location Requirements

When installing the EX-CF Case Former please be aware of the following considerations:

1. The mounting surface is flat and level.
2. Adjoining equipment height.
3. Alignment with packaging line.
4. Adequate clean air supply nearby at required CFM and PSI pressure. Supply must be clean factory air and will be lubricated by the FRL (Filter Regulator Lubricator) unit on the machine.

When the EX-CF Case Former is positioned in the operating location you will need access to:

1. The emergency stop switch.
2. Height and width adjustments.

The machine should be placed on a flat, level floor so that it does not rock or move. We recommend that the machine be securely locked in place when used.

Carefully unpack the outer container. Avoid damaging the machine body.

Remove the shipping bolts that secure the EX-CF Case Former to the shipping pallet.

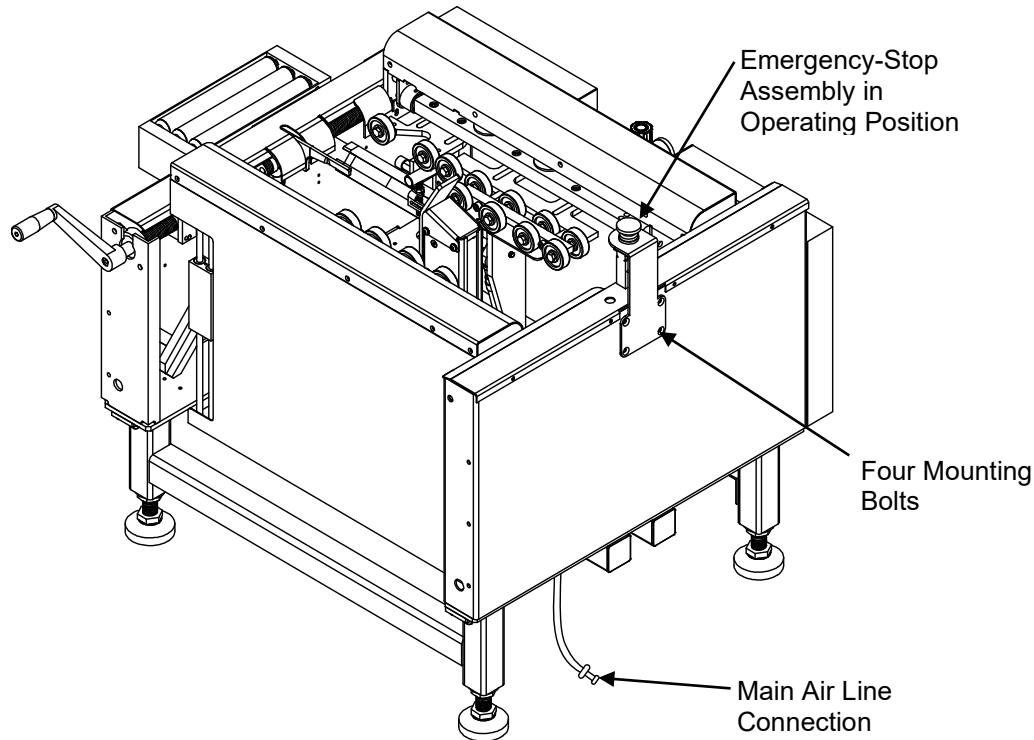
Lift the Case Former off the pallet.

Attention! The EX-CF Case Former is a very heavy piece of equipment and will require a forklift or several people to move safely off the shipping pallet.

To avoid damage the EX-CF is shipped with the Emergency Stop button bolted to the inside of the frame.

Attention! Do not connect the main air-supply to the case former while installing and connecting the E-Stop assembly.

Remove the E-Stop button assembly from the shipping position and install it in the operating position on the outside of the frame.



After the E-Stop button has been mounted in the operating position, making sure the red emergency e-stop button is pressed down (off), connect the two air-lines to the E-Stop assembly.

Air pressure should be set to 80 PSI (6 kg/cm²) for most applications, with a minimum setting of 65 PSI (4.5 kg/cm²) and a maximum of 100 PSI (7 kg/cm²).

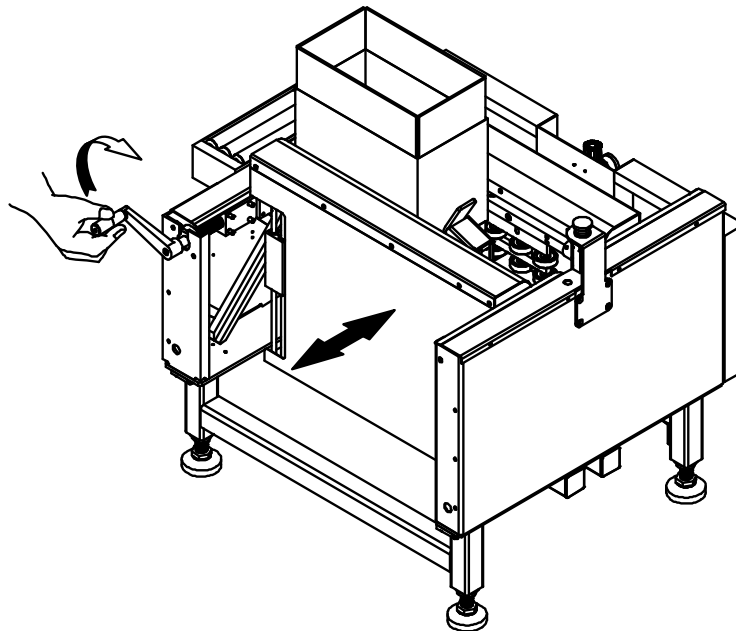
Adjustments

There are two major adjustments when setting up the EX-CF Case Former, width adjustment and a length adjustment. There is also an adjustment for the major (long) flap folding plates. After the initial set up the major flap folder plates need only be readjusted if there is a large change in box size.

Caution! Disconnect the main air supply before making any adjustments or changes. Ensure that the emergency stop button is pushed down in the off position.

Case Width

Attach the supplied hand crank to the square shaft on either side of the machine.

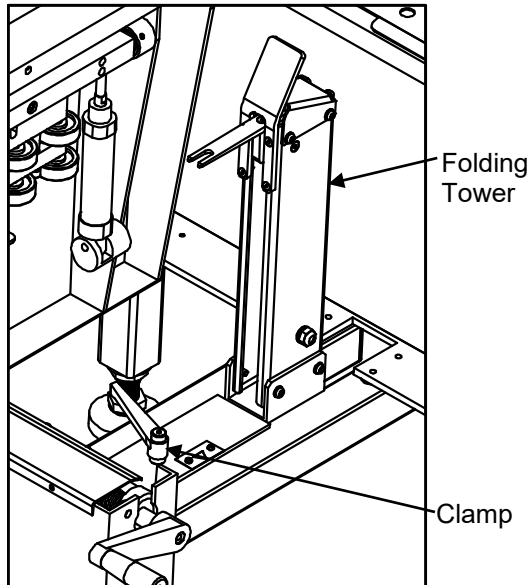


Adjust the width to be wider than the case.

Open a case from a blank flat and insert it into the machine.

Crank in the width adjustment until the red case hold-down rollers are lightly gripping the sides of the case. It should be easy to insert and remove a case but the case should still be maintaining contact with the body switch roller until the case leaves the machine.

Case Length



Remove the case and loosen the clamp that is located at the base of and in front of the minor (short) flap folding tower.

Reinsert the case into the machine and position it $\frac{1}{2}$ " back from the minor flap folder at the exit end of the machine.

Push the tower forward until it just contacts the back of the case.

Remove the case and tighten the "tower" clamp.

Major Flap Folder Plates

The major flap folding plates and wheels may need to be extended to provide additional support for wide heavy cases or retracted for narrow ones.

Note: Sliding the plates in towards the machine center increases the case bottom support but limits the minimum width adjustment when the major flap folder wheels contact the minor folder tower. Also, extended folder plates in the down position will wedge against the bottom control valve/flap opener bracket as the machine is adjusted for minimum width. If forced, either of these conditions can damage machine components.

There are two major folder plates on each side of the machine, one small and one large that are adjusted independently.

Loosen the four socket-head cap screws on each side that hold the major folder roller plates in place. Slide the front [large] folder to the desired position and retighten the screws.

Adjust the rear [small] major folder plate. Make sure that the plate will not contact the "floor" switch valve arm as it moves through its arc. For wide cases, the small folder plate will not be able to be extended as far as the large plate and has a separate adjustment for this reason.

Operation

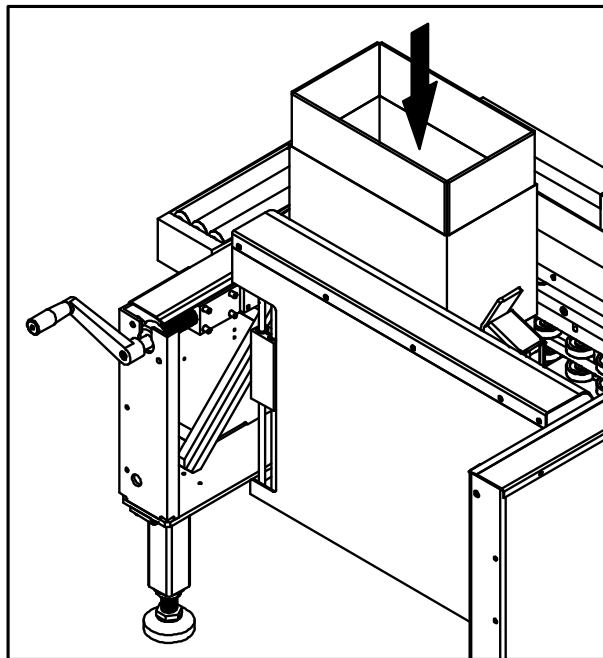
Starting the EX-CF Case Former

Before starting, hand swing all moving part to check adjustment and for any mechanical interference.

Caution: Make sure the main air supply valve is shut off and the red Emergency Stop button is pushed down before connecting the main air supply to the machine.

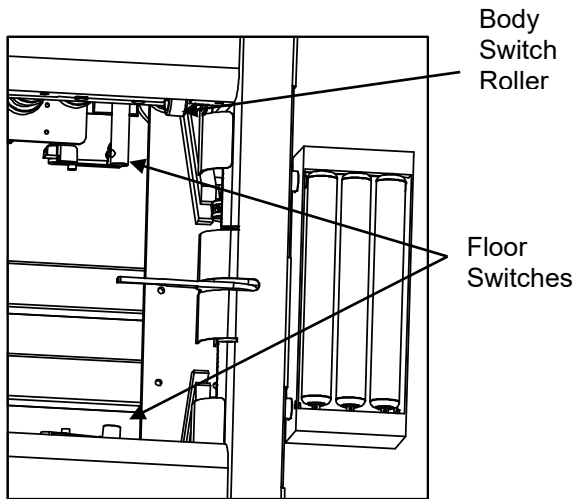
Connect the air supply line to the EX-CF case former and turn on the main supply valve keeping hands clear of all moving parts.

Erecting a Case

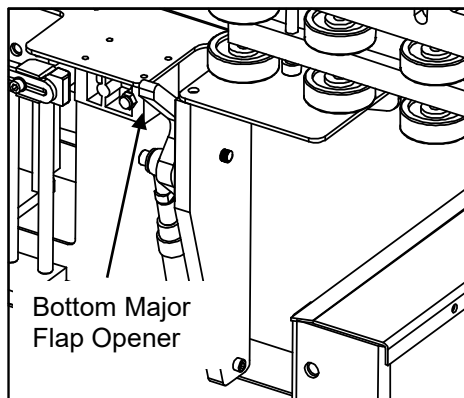


1. Open a case so that it is fairly square.
2. Place the open bottom into the EX-CF, pushing the case all the way down to depress the floor switches.
3. The machine will first fold the front and rear end minor flaps, then the two side major flaps. The case is held in place and is ready to fill if desired.
4. When filled, or if the case is just erected for filling downstream, push it out of the packing station to the next operation.
5. As the end of the case breaks contact with the "switch roller", the EX-CF will automatically reset ready for the next case.

EX-CF Operating Cycle

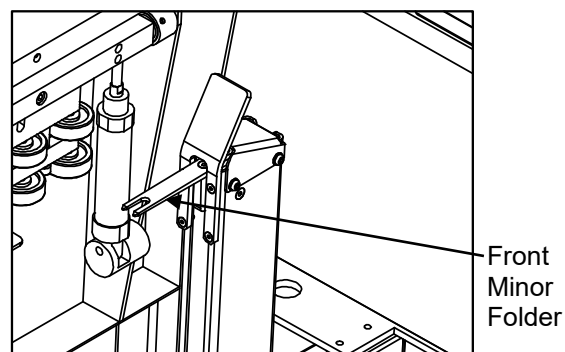
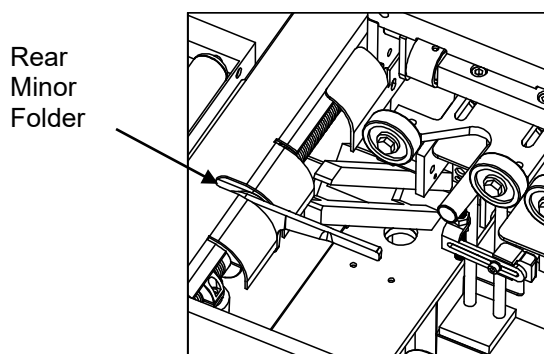


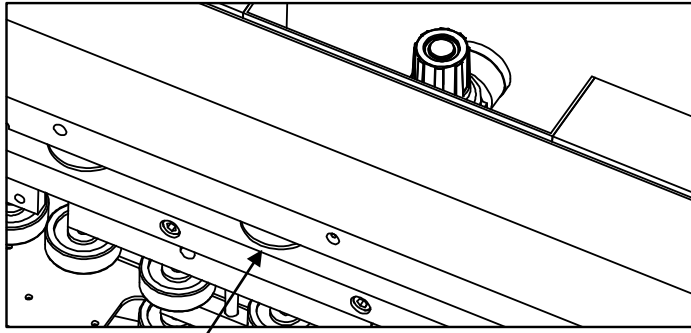
1. The bottom edges of the major flaps depress the actuators of the two "floor" switch valves and the side of the case depresses the wheeled body switch valve. All three switches must be actuated for the machine cycle to start.



2. The two small levers of the major (side) flap openers momentarily open the bottom major flaps wider to clear the minor (end) flaps.

3. The minor flap folds up both end flaps on the box bottom. The rear [case exit end] folder retracts immediately, the front [tower] folder remains extended until the case exits the machine to help support the end of the case.





Major Folder (Right
Hand Shown)

4. The major flap folders then fold up both side flaps of the bottom and stay in position to support the box for packing.

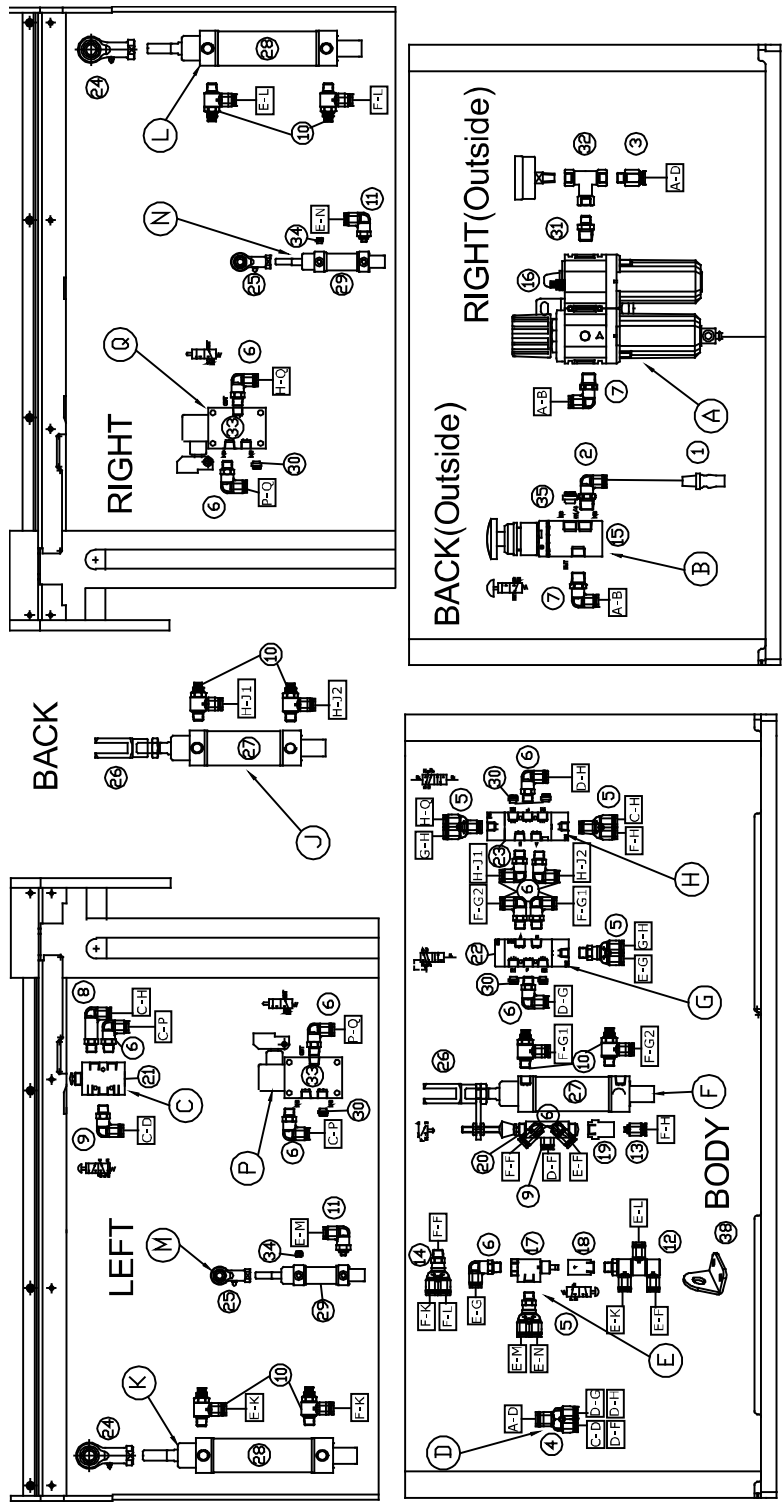
5. Pushing the box out of the machine breaks contact with the body switch inside the packing station. The machine then resets, ready for the next case.

Troubleshooting

Problem	Solution
Case releases, all flaps drop, during folding or packing cycle.	<p>Check that width adjustment is correct. If it is too wide, the wheeled “switch roller” that contacts the side of the case will reset and cause the machine to return to the start position.</p> <p>Shaking the box to level the contents can cause the body switch to reset.</p> <p>Check that the body switch is correctly adjusted and secured in the frame for proper box contact and that the contact wheel is firmly attached.</p>
Minor flaps fail to fold fully and return to home position and may try to fold again.	<p>Check that the actuator arms attached to the floor switches (mounted on floor plates) are not out of position or loose. Both of them should be in a position to be pushed down fully by the bottom flaps of the open box.</p>
Major flaps have difficulty folding and cause inner edges of minor flaps to be folded over.	<p>Check that the air pressure is adequate and that the air pressure does not drop during the cycle.</p> <p>Check that the flow controls on the small major flap opening cylinders are set so that they will momentarily open the major flaps wider and allow the minor flaps to clear the inside of the major flaps before releasing.</p>
Back or front case collapses inward during minor flap folding.	<p>Be sure that the case width setting does not hold the box too tightly.</p> <p>Check the air pressure and volume.</p> <p>Check that the scoring on the box is adequate and promotes folding.</p> <p>Check that the flow controls on the minor flap folding cylinders are set for a fast enough speed of the minor flap folders. Excessive speed, however, can cause damage of the folder arms.</p>
Packed case fails to transfer smoothly from packing station into case sealer.	<p>Check the height of the rollers at the out feed end of the packing station and that the box clears the machine frame.</p> <p>Check that the machines are aligned accurately, i.e. that the belt surfaces line up with the insides of the packing station when in the vertical position. Use a long straight-edge to check the alignment.</p>

Parts List

Pneumatic Parts



Drawing Date: February 21, 2009

Drawing Reference: EX-CF-116-01-H

EX-CF Pneumatic Parts

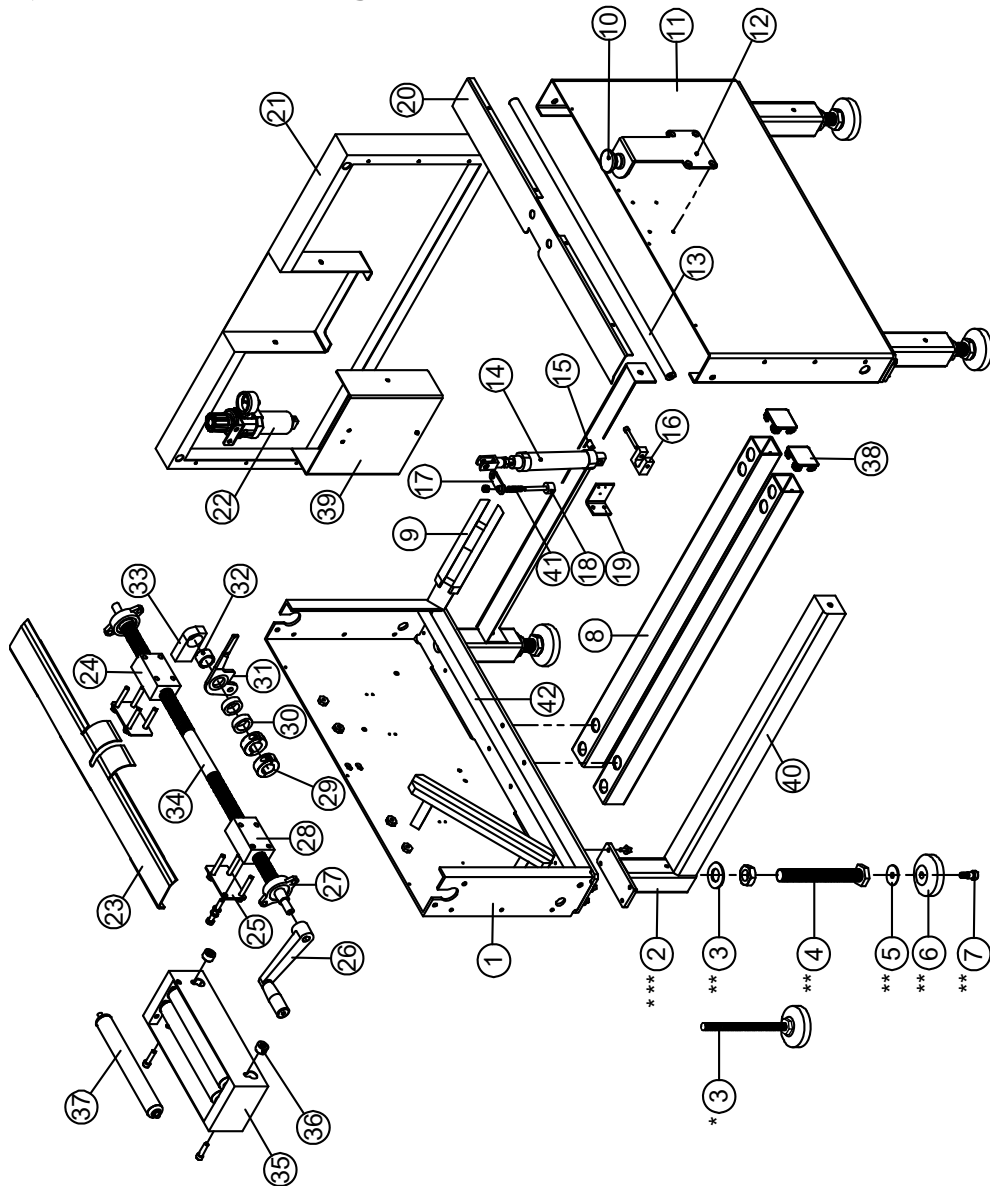
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Item	Part Number	Description	Quantity
1	5005237	Air Tube Connector PP-20	1
2	5001820-1	Elbow, Male PL8-02	1
3	5005200	Connector Male PC8-1	1
4	5005205	Air Valve port PRG8-6	1
5	5005254	Air Valve port PX6-01	4
6	5005238	Elbow Connector PL6-01	14
7	5001819-1	Elbow Connector PL6-02	2
8	5005244	Elbow Connector PLL6-01	1
9	5005245	Elbow Connector PL6-01M	2
10	5001796	Flow Control JSC6-01A	8
11	5005240	Elbow Connector PL6-M5	2
12	5005208	Three-way Connector PHT6-01	1
13	5005239	Adaptor PC6-M5	1
14	5005246	Two-way Connector PY-6	1
15	5001815	Air Valve MVMC-210-3EB25-8A-25(Red)	1
16	5001815	FRL System MAFR300-8A-D	1
17	5001795	Air Valve MVHF-3P-NO	1
18	5005210	Adaptor MVHF-AP6A	1
19	5005038	Adaptor MVHA-34A	1
20	5001893	Valve MVHA-41PP	1
21	5005251	Valve MVHA-41P	1
22	5002112	Valve	1
23	5005200	Valve MVAA-180-4A2	1
24	5002145	Eye Rod Link PHS-10 (M10×1.25)	2
25	5002123	Eye Rod Link PHS-6 (M6×1.0)	2
26	5001821-1	Clevis Y-MCMA 32 (M10)	2
27	5001821	Cylinder MCMA-11-32-50	2
28	5001906	Cylinder MCMA-11-32-75	2
29	5001798	Cylinder MCMA-15-16-25	2
30	5002101	1/8"MSL-S-01	6
31	5005235	Bushing 1/4" T*1/8" TBCN-0201	1
32	5005243	Tee Forged Male Branch 1/8"×1/8"×1/8" BTF-001	1
33	5001799	Air Valve VM830-01-13	2
34	5005236	M5MSL-S-M5	2
35	5001815-1	1/4"MSL-S-02	1
38	5005689	L Mount MVHF-LB	1

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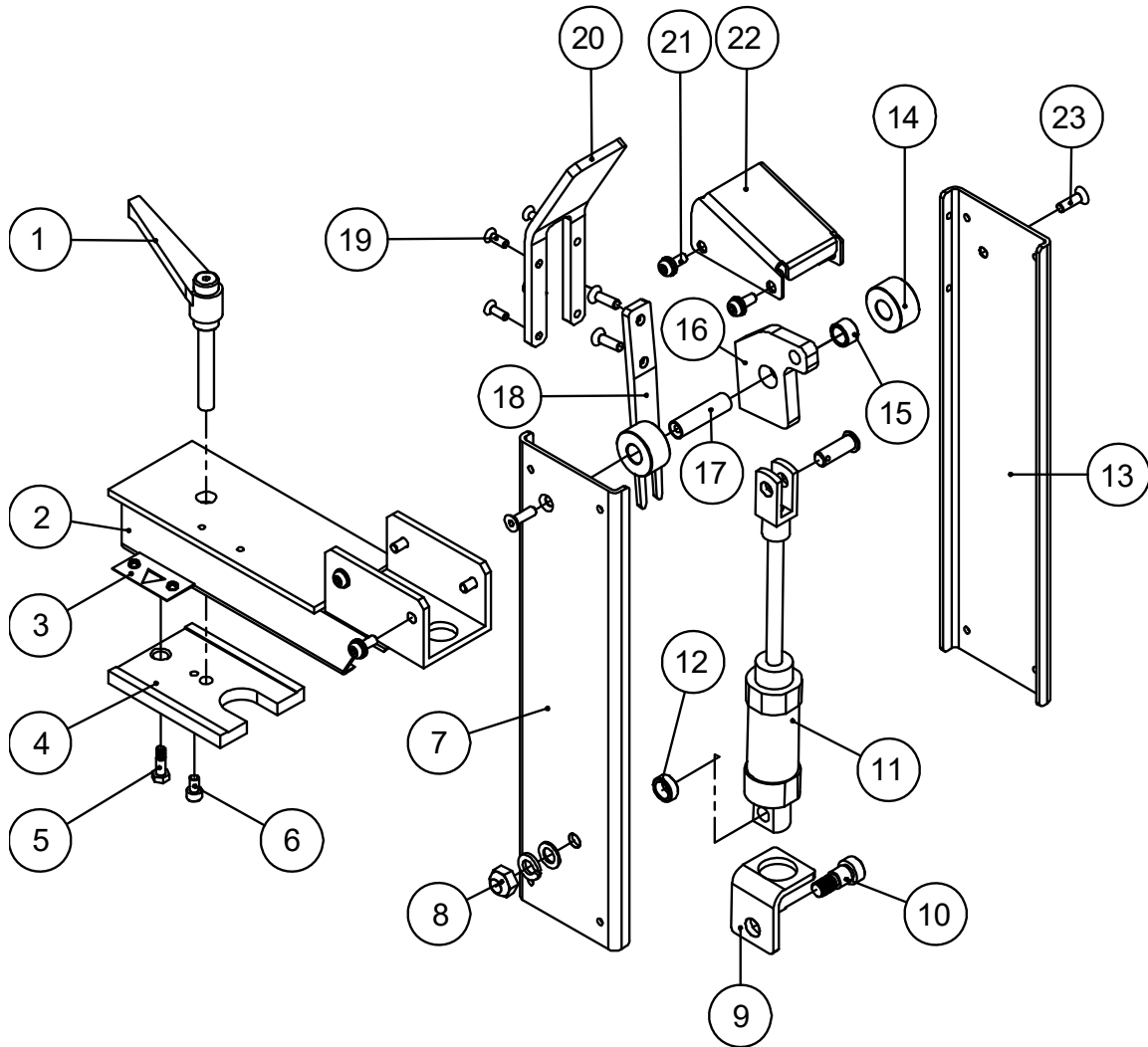
Frame, Front Assembly



Item	Part Number	Description	Quantity
1	5005227	Front Frame	1
*2	5002865	Frame Support M16 — *Current Model Only	4
**2	5002858	Frame Support M24 — **Earlier Model Only	4
**3	5002859	Washer — **Earlier Model Only	4
**4	5002130	Supporting Spindle — **Earlier Model Only	4
**5	5002861	Washer — **Earlier Model Only	4
**6	5002862	Supporting Cup — **Earlier Model Only	4
**7	5002863	Bolt — **Earlier Model Only	4
8	5005224	Bottom Frame	2

Item	Part Number	Description	Quantity
9	5005228	Guide Assembly	2
10	5001795	EMG Stop/ Start Switch	1
11	5005226	Rear Frame	1
12	5005220	Start/Stop Base Frame	1
13	5005221	Rear Guide Spindle	1
14	5001821	Cylinder	1
14	5001821-1	Cylinder connector	1
15	5005242	Spacer	1
16	5005211	Cylinder Mount	1
17	5001924	Connecting Plate	1
18	5001907	Spindle	1
19	5005215	Valve mount base	1
20	5005690	Rear Frame Cover Plate	1
21	5005225	Outer Frame (RH)	1
22	5001820	Air F.R.L. MAFR300-8A-D	1
23	5001994	Front Frame Cover plate	1
24	5001943	Nut. Acem screw L.H.	1
25	5001997	Plate with Nuts	2
26	5001710.1	Handle	1
27	5001998	Bearing UFL004	2
28	5001942	Nut Acme Screw (R.H)	1
29	5001965	Lock Collar	2
30	5001964	Spacer	2
*31	5001908	Rear Kicker with Bearing — *Current design replaces earlier	1
32	5001908-1	Copper Ring	1
33	5001963	Guide Spindle supporter	1
34	5001959	Front Guide Spindle	1
35	5005691	Exit roller frame	1
36	5005692	Ring	2
37	5001718	Roller Short	3
38	5005693	Square Tube Plug	4
39	5005693	Air F.R.L. Fixed Seat	1
40	5005695	Auxiliary leg	2
41	5001800	Spring	1
42	5005221	Rear Guide Spindle	1

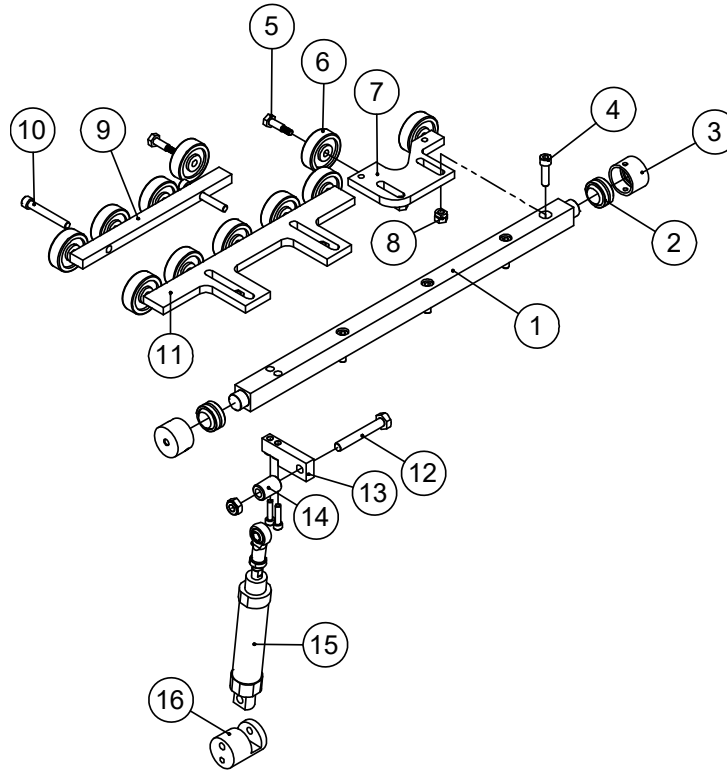
Slide Spindle Unit



Item	Part Number	Description	Quantity
1	5001817	Handle (M10×P1.5)	1
2	5005223	Tower Sliding Base	1
3	5005247	Length Pointer	1
4	5001628	Sliding Bottom Mount	1
5	5001629	Bolt	1
6	5005229	Screw M6×10L	1
7	5005219	Tower Plate LH	1
8	5001897	Lock Nut Nylon	1
9	5001923	Cylinder Mount	1
10	5002863	bolt	1

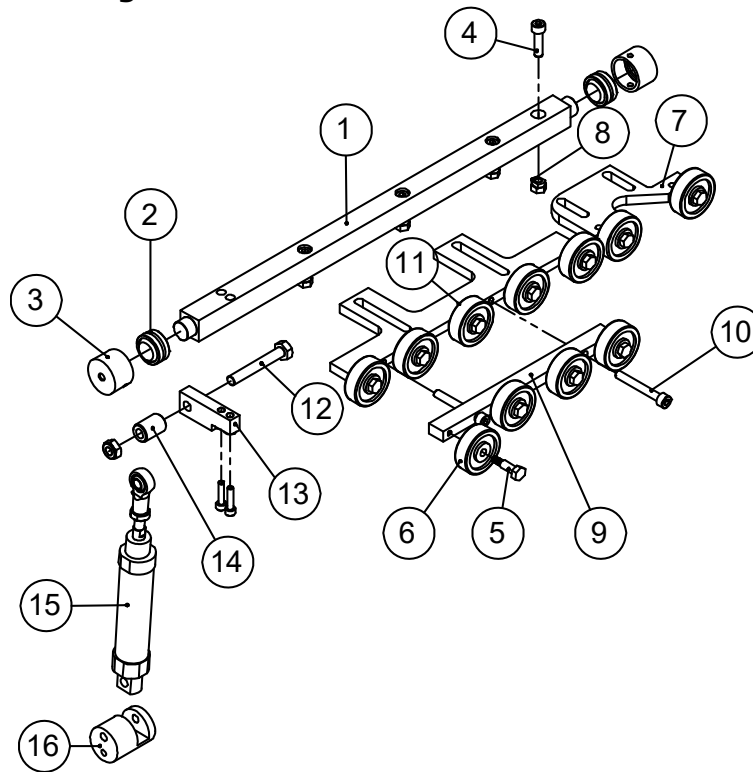
Item	Part Number	Description	Quantity
11	5001821	Cylinder	1
	5001821-1	Clevis	1
12	5005241	Cylinder Spacer	1
13	5005218	Tower Plate RH	1
14	5001961	Spacer	2
15	5001935	Bushing	1
16	5001909	Kicker Base Plate	1
17	5001962	Center rod	1
18	5005207	Kicker plate (rear)	1
19	5005232	Screw M5×12L	4
20	5002120	Top Guiding plate	1
21	5005234	Screw M6×16L	4
22	5005206	Tower top cover	1
23	5005233	Screw M6×20L	1

RH Fold Assembly



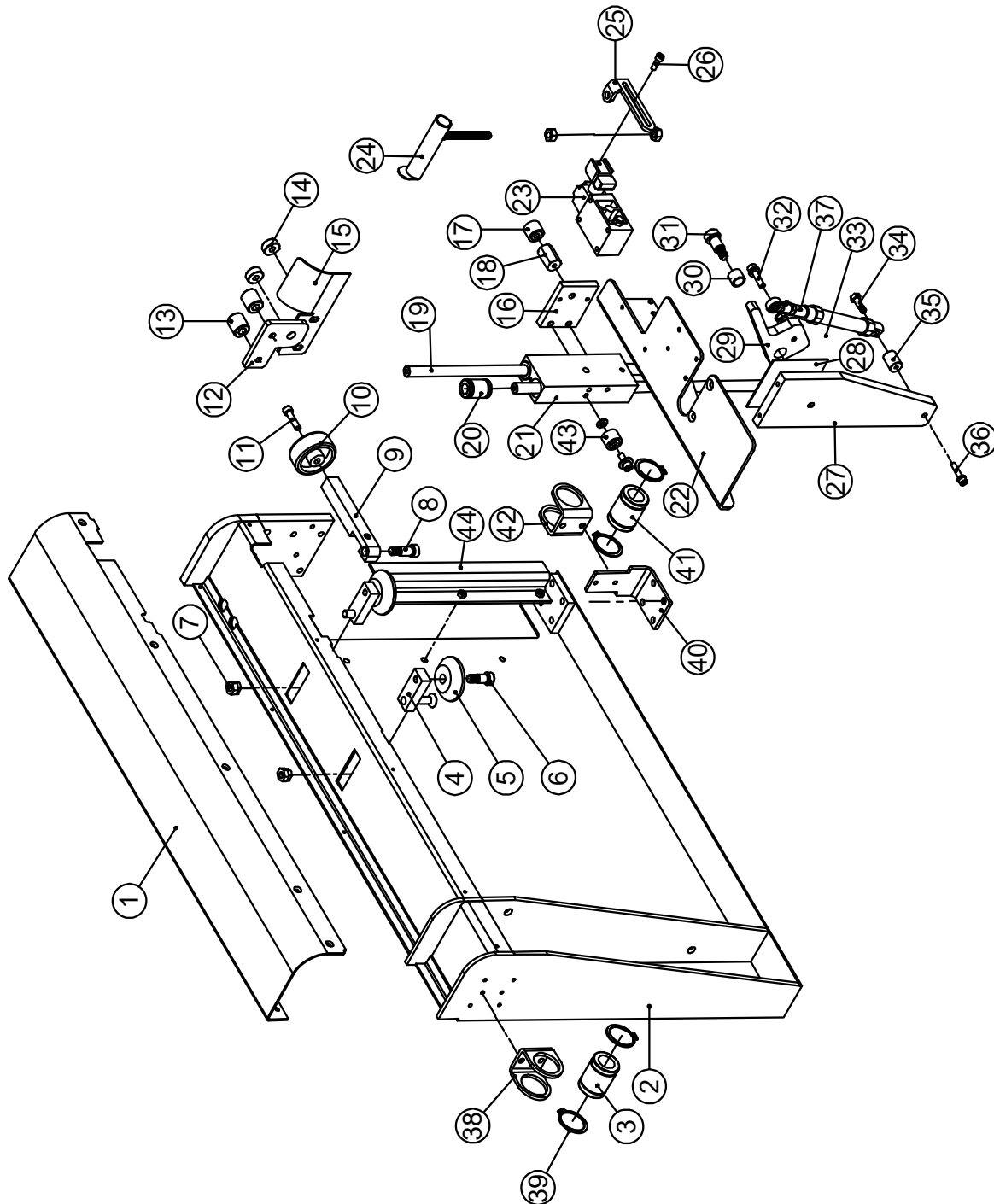
Item	Part Number	Description	Quantity
1	5005214	Caster Arm	1
2	5002115	Ball Bearing Linear CF	2
3	5005249	Bearing Housing	2
4	5001864	Screw M8×30L & Nut	4
5	5002114	Bolt Shoulder CF	11
6	5002103	Wheel Cray Box Slide CF	11
7	5002134	Caster Plate (small) CF	1
8	5005020	Bolt	2
9	5005216	Ext. Caster plate	1
10	5005230	Screw M8 × 60L	2
11	5002135	Caster Plate (Large) CF	1
12	5005231	Hex Screw M10 × 70L	1
13	5005213	Cylinder Lever Bar	1
14	5005696	Spacer	1
15	5001906	Cylinder Major Flap CF	1
15	5002145	Eye Rod Link PHS10 M10 × 1.25	1
16	5005212	Cylinder Mount	1

LH Fold Assembly



Item	Part Number	Description	Quantity
1	5005214	Caster Arm	1
2	5002115	Ball Bearing	2
3	5005249	Bearing Housing	2
4	5001864	Screw M8 × 30L	4
5	5002114	Screw	11
6	5002103	Wheel	11
7	5002134	Caster Plate (small)	1
8	5005020	Nut	2
9	5005216	Ext. Caster plate	1
10	5005230	Screw M8 × 60L	2
11	5002135	Caster Plate (Large)	1
12	5005231	Hex Screw M10 × 70L	1
13	5005213	Cylinder Lever Bar	1
14	5005696	Spacer	1
15	5001906	Cylinder	1
15	5002145	Eye Rod Link PHS10 M10 × 1.25	1
16	5005212	Cylinder Mount	1

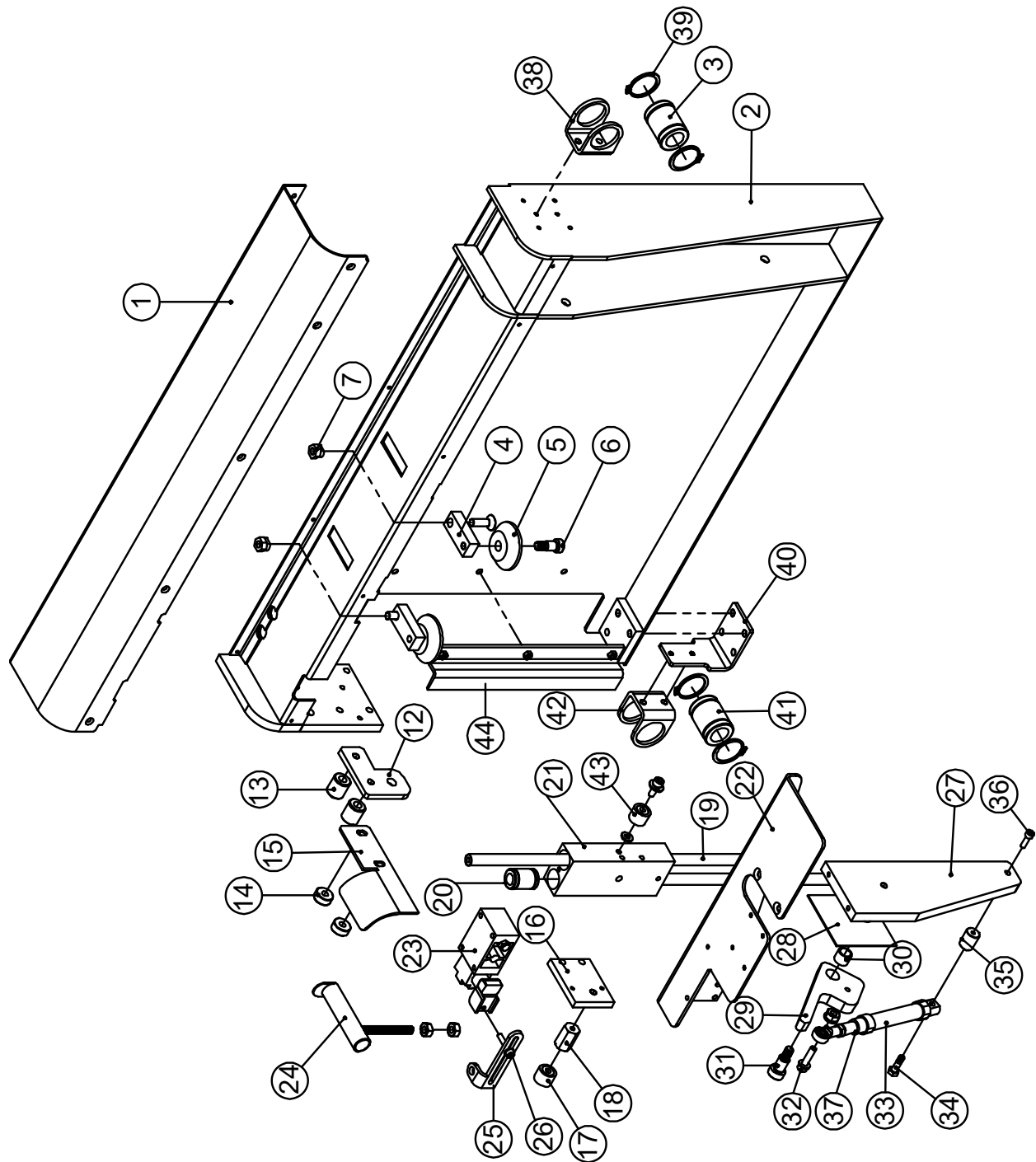
Frame, Left Side Assembly



Item	Part Number	Description	Quantity
1	5005016	Left side Frame Cover	1
2	5002215	Left side Frame	1
3	5001802	Linear Bearing LM-20UU	1
4	5005018	Mount Base	2
5	5001801	Roller	2
6	5005019	Screw	2
7	5005020	Bolt	2
8	5005021	Bolt	1
9	5002829	Switch lever	1
10	5002113	Switch Roller	1
11	5002830	Screw M6*25L	1
12	5005022	Mount	1
13	5005023	Spacer	2
14	5005024	Spacer	2
15	5002115	Case Guide (LH)	1
16	5005025	Mount	1
17	5002209	Roller	1
18	5002126	Spacer	1
19	5005026	Spindle	2
20	5001941	Linear Bearing LM-12UU	4
21	5005027	Slide Plate	1
22	8005028	Left Mount Plate	1
23	5001799	Valve Assy. L.H.	1
24	5002119	Active Lever	1
25	5001822	Control Leverl (LH)	1
26	5005029	Screw M5*20L	1
27	5005030	LH Flap Opener Mount	1
28	5005031	Sheet	1
29	5002121	Flap Opener Lever	1
30	5001925	Spacer	1
31	5002122	Bushing	1
32	5002830	Screw M6*25L	1
33	5001798	Cylinder	1
34	5002123	Eye rod Link	1
35	5001629	Bolt	1
36	5005032	Spacer	1

Item	Part Number	Description	Quantity
37	5005029	Screw M5 × 20L	1
38	5005033	Cylinder spacer	1
39	5005034	Bearing seat	1
40	5005035	RING STW-32	2
41	5005036	Bearing support	1
42	5001802	Linear Bearing LM-20UU	1
43	5005034	Bearing seat	1
44	5002209	Roller	1

Frame, Right Side Assembly

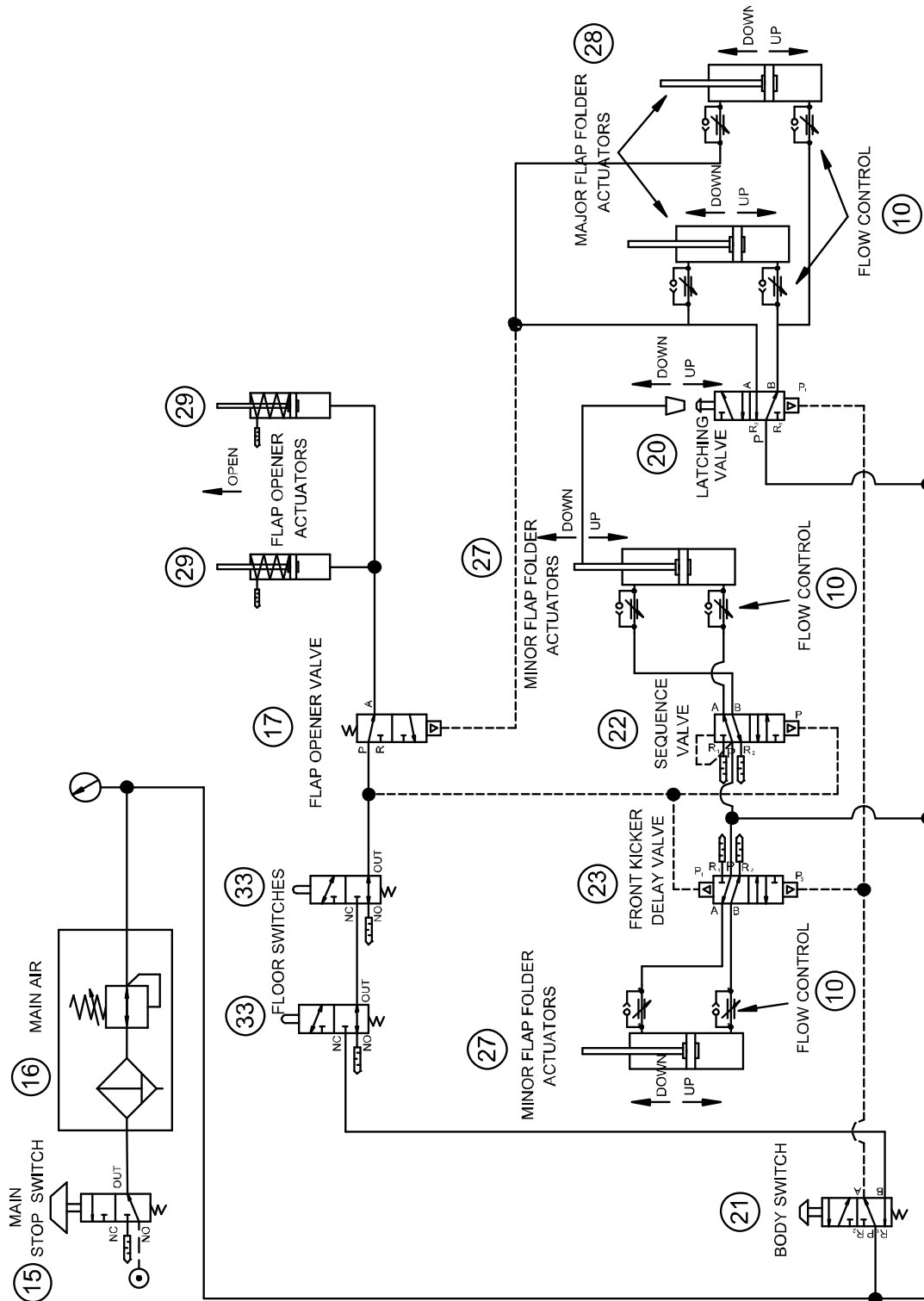


Item	Part Number	Description	Quantity
1	5002203	Right side Frame Cover	1
2	5002204	Right Side Frame	1
3	5001802	Linear Bearing LM-20UU	1
4	5005018	Mount Base	2
5	5001801	Roller	2
6	5005019	Screw	2
7	5005020	Bolt	2
8			
9			
10			
11			
12	5005022	Mount	1
13	5005023	Spacer	2
14	5005024	Spacer	2
15	5005209	Case Guide (RH)	1
16	5005025	Mount	1
17	5002209	Roller	1
18	5002126	Spacer	1
19	5005026	Spindle	2
20	5001941	Linear Bearing LM-12UU	4
21	5005027	Slider plate	1
22	5005217	Right Mount Plate	1
23	5001799	Valve Assy.	1
24	5002119	Active Lever	1
25	5001823	Control Lever (RH)	1
26	5005029	Screw M5*20L	1
27	5005030	RH flap opener mount	1
28	5005031	Sheet	1
29	5002121	Flap Opener Lever	1
30	5001925	Spacer	1
31	5002122	Bushing	1
32	5002830	Screw M6*25L	1
33	5001798	Cylinder	1
33	5002123	Eye Rod Link	1
34	5001629	Bolt	1
35	5005032	Spacer	1

36	5005029	Screw M5 × 20L	1
37	5005013	Cylinder Spacer	1
38	5005034	Bearing seat	1
39	5005035	Ring STW-32	2
40	5005036	Bearing support	1
41	5001802	Linear Bearing LM-20UU	1
42	5005034	Bearing seat	1
43	5002209	Roller CF	1
44	5005057	Track Pieces	1

Appendix A: Air Diagram

Pneumatic Schematic



Warranty Statement

EX-CF Case Former

Warranty Statement

Eastey warrants that all of the products it ships will be in good working order and free from defects in material and workmanship and will conform to the published specifications for that product.

Warranty Period

1 year (Except for moving parts which are subject to normal wear, tear and replacement which are warranted to be free from defects in material and workmanship.)

Case Forming Quality

Case-forming quality achieved in a given application is dependent on the installation, the material handling, and the maintenance provided. Eastey makes no warranty that the case forming quality achieved in an application will be the same as that achieved on a test piece in our demo facility.

Shipping Policy

Customer pays all incoming shipping. If the item is defective and under warranty, Eastey pays return shipping charges for least costly method. If expedited shipping is desired, customer must furnish his shipping account and shipping fees will be charged to that account.

Warranty Verification

If you conclude that a product may be defective and may be covered by warranty, obtain a Return Material Authorization number by calling our technical support number (toll free at 1-800-835-9344, or 763-428-4846 or Fax: 763-795-8867 or e-mail: info@eastey.com). Once an RMA number has been obtained, return the defective item to Eastey. Eastey will analyze the item and, if found to be defective, we will, at our option replace or repair the item. If the item is found to not be eligible for warranty, you will be notified and may decide on disposition. Defective items will be replaced or repaired as promptly as possible.

Warranty Eligibility

The warranty provided by Eastey is only to the original buyer.

Limited Warranty

THE ABOVE WARRANTY IS EXCLUSIVE AND IN LIEU OF ALL OTHER WARRANTIES, WHETHER EXPRESSED OR IMPLIED, INCLUDING THE IMPLIED WARRANTIES OF MERCHANTABILITY, FITNESS FOR A PARTICULAR PURPOSE AND NONINFRINGEMENT.

Disclaimer of Damages

REGARDLESS OF WHETHER ANY REMEDY SET FORTH HEREIN FAILS OF ITS ESSENTIAL PURPOSE, IN NO EVENT WILL EASTEY. BE LIABLE FOR ANY

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317-841-1126 INFO@HOTMELTUNITS.COM

SPECIAL, CONSEQUENTIAL, INDIRECT OR SIMILAR DAMAGES, INCLUDING LOST PROFIT OR LOST OPPORTUNITIES OF ANY TYPE ARISING OUT OF THE USE OR INABILITY TO USE THESE PRODUCTS EVEN IF EASTEY ENTERPRISES, INC. HAS BEEN ADVISED OF THE POSSIBILITY OF SUCH DAMAGES.

PACKAGING PLUS
317-841-1126 INFO@HOTMELTUNITS.COM

Customer Support

Eastey Technical Service

For help setting up or operating the EX-CF Semi-Automatic Case Former, please contact Eastey Technical Service at one of the numbers listed below.

Toll-Free Phone	800-835-9344
Phone	763-428-4846
Fax	763-795-8867
E-mail	info@eastey.com
Web	www.eastey.com

Thank you again for your purchase of Eastey products. We are pleased to be a part of your packaging needs.

