

# **Assembly of solid board boxes**

Please read before you start.

# Content

- hotmelt glue gun                      page 3 - 10
- hotmelt                                      page 11- 13
- die cuts                                      page 14 - 22
- assembly frames                      page 23
- assembly procedure                      page 24- 88
- finished product                      page 89
- end of the day                      page 90 - 93



## **Hotmelt glue gun MS 80**

Plug the glue gun into the power supply ( 220-250V)  
After  $\pm$  10 minutes the gun is heated and ready to use.



## Warning

The hotmelt gun, nozzle and glue are very hot (190° C ).

The hot glue is extremely sticky.

Risk of burning your hands or eyes.



## Putting hotmelt glue in the gun

Remove the black cap.



## **Box with hotmelt pellets**

Put the pellets into the hotmelt gun.



## Hotmelt in the gun

Fill the heated chamber with the hotmelt pellets.

Maximum filling level is to the underside of the opening.



## Put the cap on the gun

**Never** use the gun without the cap, the glue inside is **very hot** and causes serious skin burns.

The gun is now ready for use!





**Warning**

**Do not overfill!**



# Warning

Never put the gun on its side!



**Please pay attention!**

**Switch off** , during lunches or any break longer than **45 minutes**.



**Box with hotmelt pallets.**

Keep away from heat and direct sunlight!



## **Keep clean!**

Always close the bag after use.

Avoid dirt and dust in the hotmelt, this will clog the nozzle of the hotmelt gun.



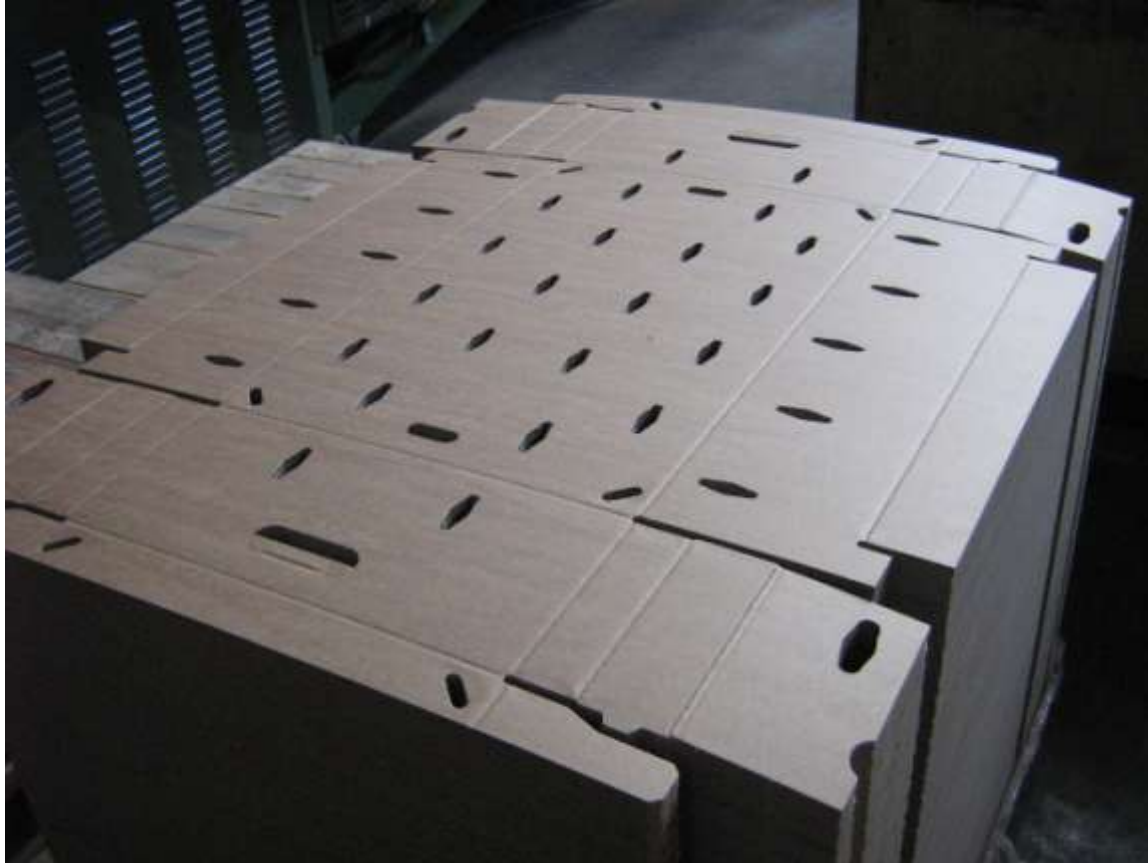
## **Close the box!**

When work is finished, close the bag inside and close the box thoroughly.



## **Pallet with die cuts**

Keep away from moisture and direct sunlight.



## **Pallet with die cuts**

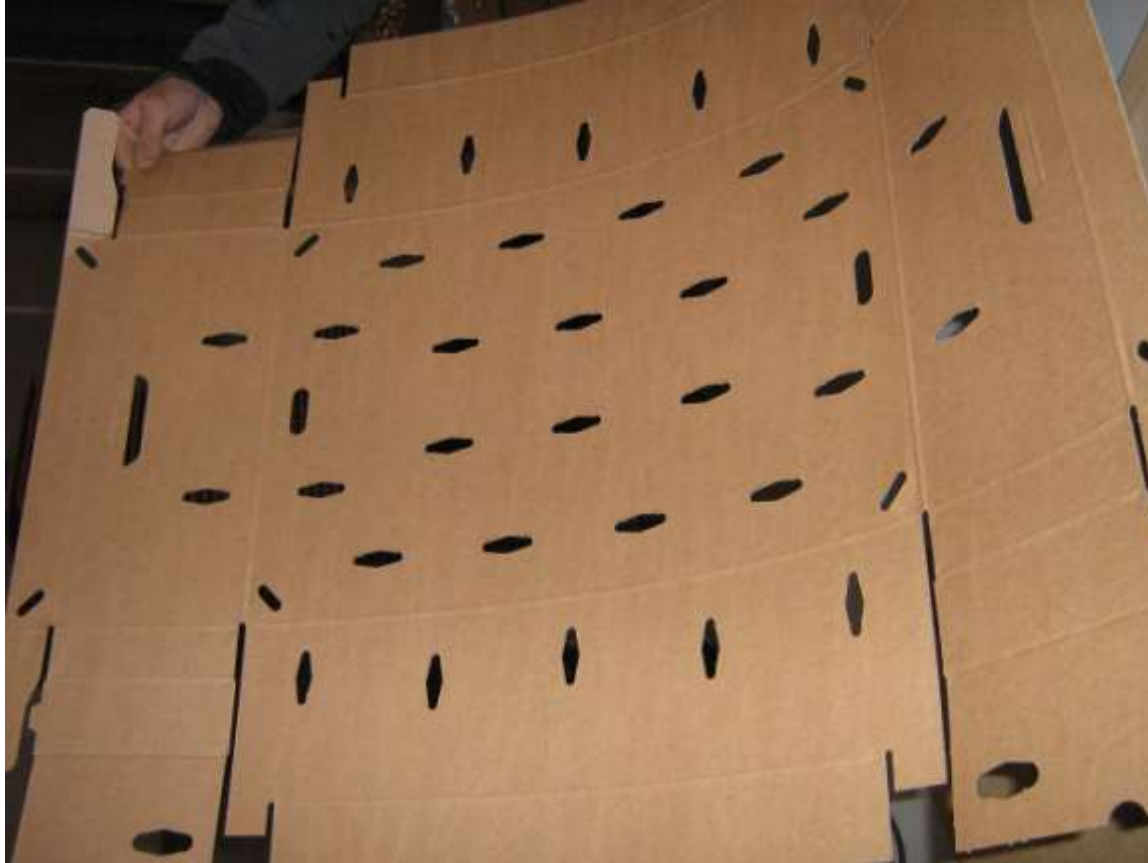
Please keep clean.





## Die cut

Take one die cut.



## Die cut

Place the die cut in position on the assembly frame.



**This side up!**

It is very important to have the right side up.



## **This side up**

The side with the bulging crease lines must be on top.



**This side up**

Please note the wide and bulging crease lines.



## **This side underneath**

The sharp crease lines must be facing down!



## **This side underneath**

The sharp crease lines must be facing down.





## **Assembly frames**

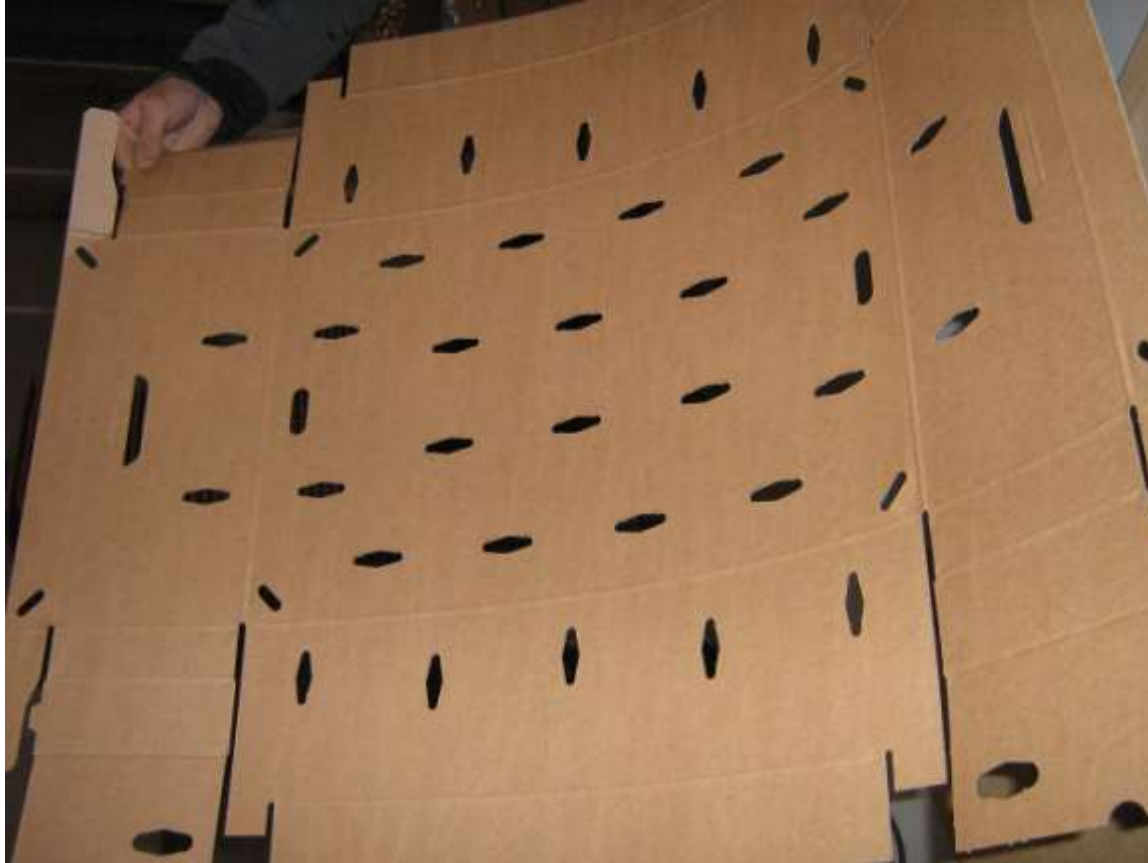
Two separate assembly frames are supplied.





## **Assembly frame I**

The assembly starts with frame I.



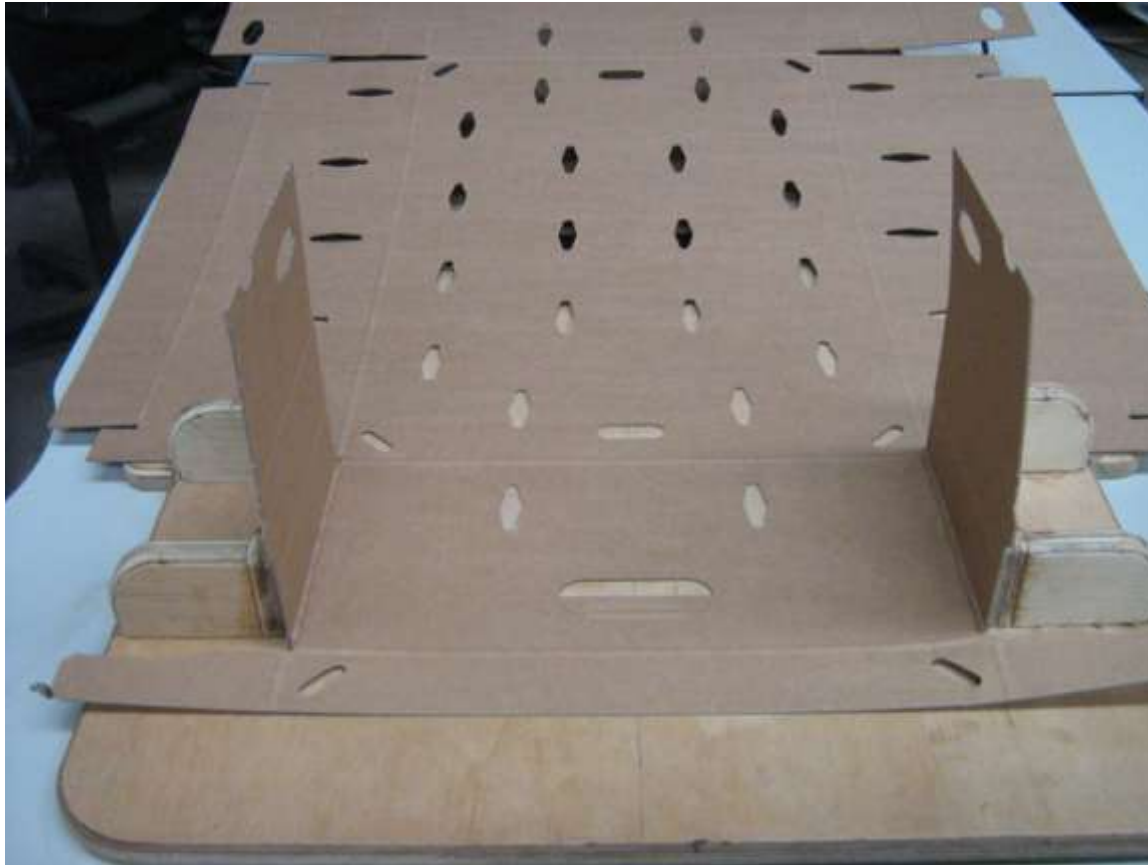
## 1. Die cut on the frame

Phase 1; place the die cut in the right position on the assembly frame.  
Please make sure the right side is up.



## **2. Folding the corner pieces up**

Phase 2; push the die cut down and fold the corner pieces up.



## **2. Folding the corner pieces**

Phase 3; two corner pieces are folded.



## 2. Folding the corner pieces

Phase 4; please fold all **four** corner pieces.



## 2. Folding the corner pieces

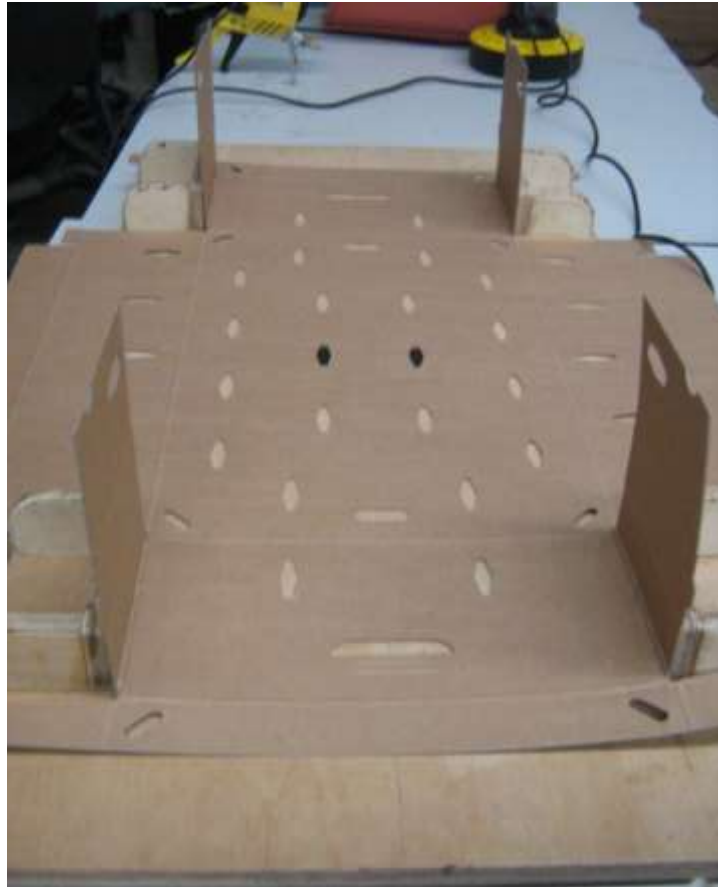
Phase 4; fold all **four** corner pieces.



## 2. Folding the corner pieces

Phase 4; fold all **four** pieces upright.

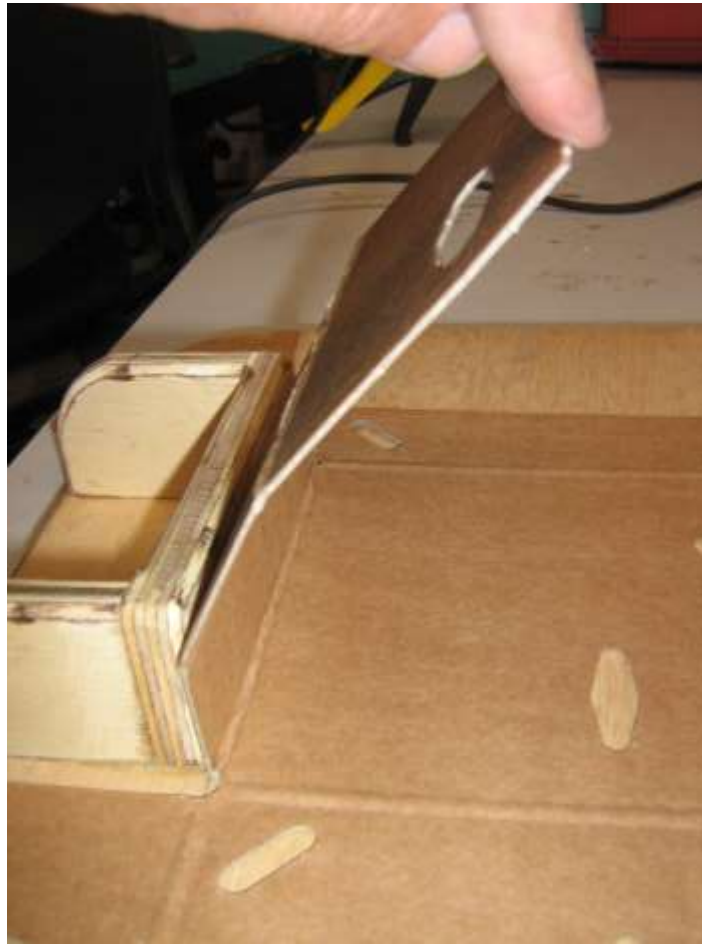




## **2. Folding the corner pieces**

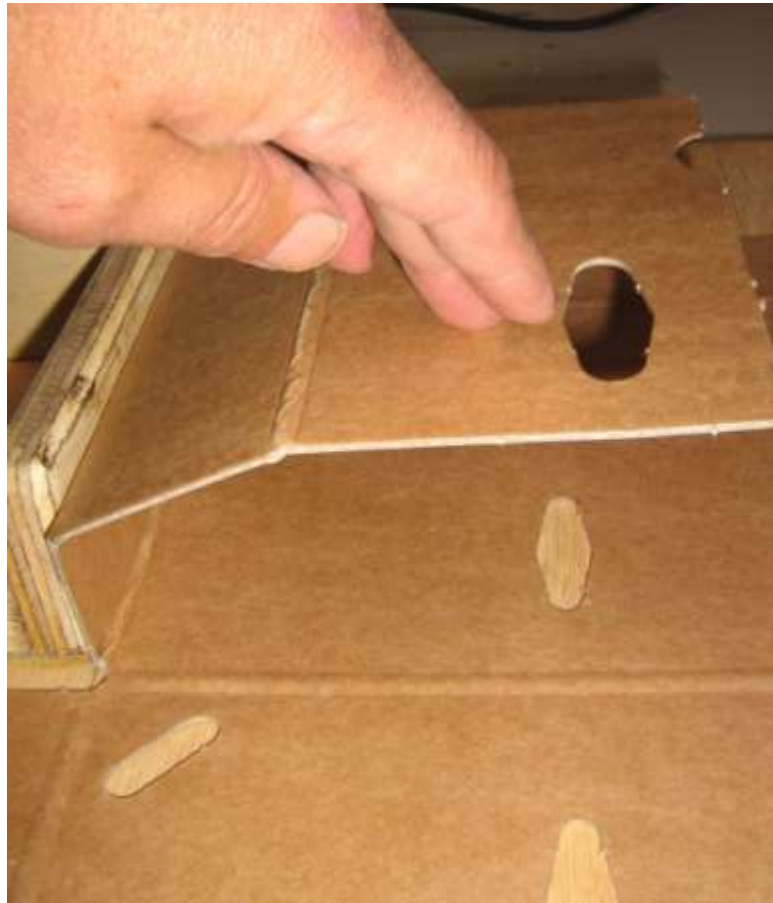
Phase 5; the die cut rests on the bottom of the frame with all four corner pieces facing upwards.





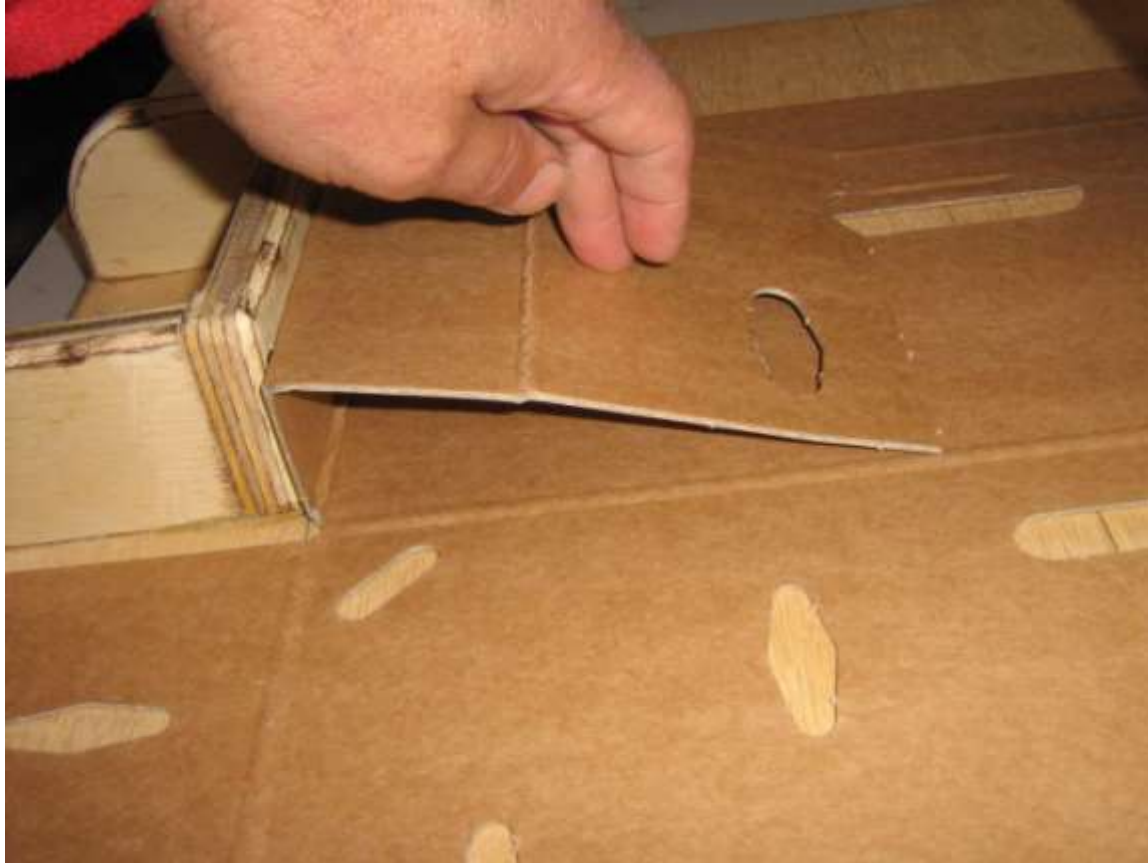
### **3. Creating the columns**

Phase 1; fold the corner piece down.



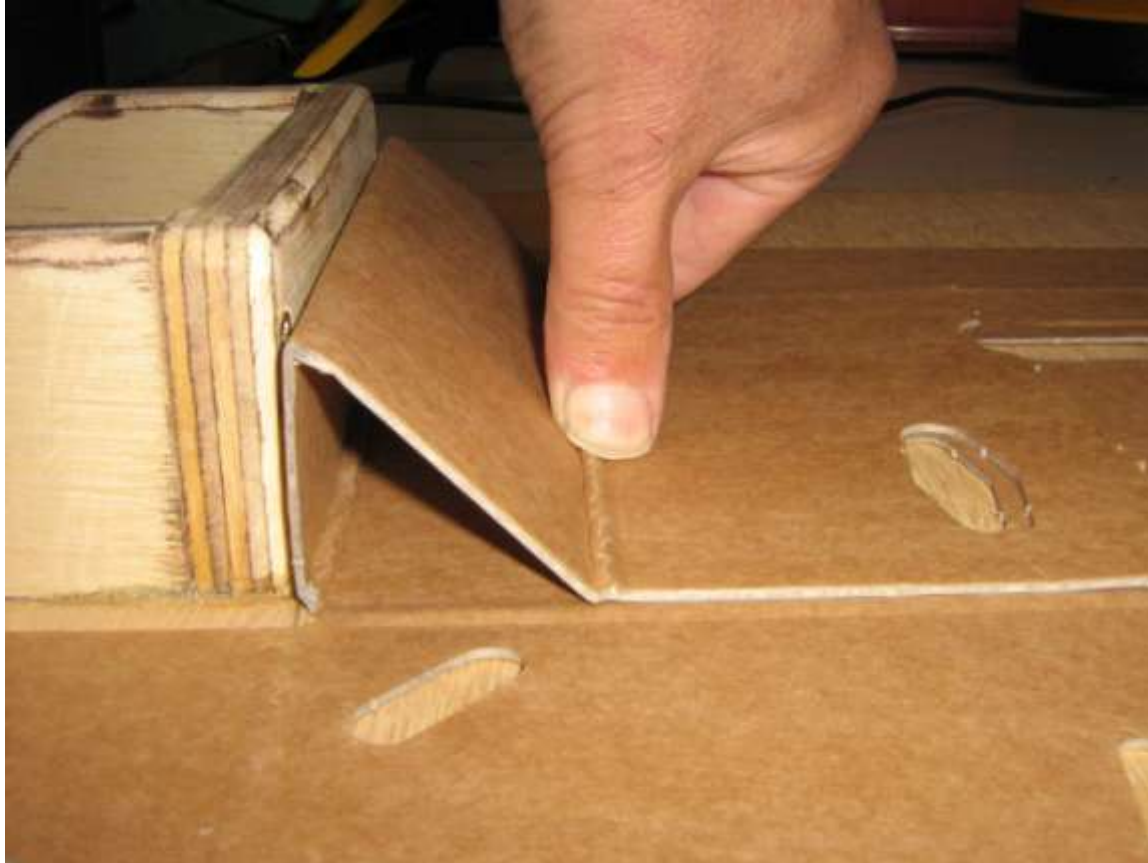
### **3.Creating the columns**

Phase 2; press the piece further down.



### **3. Creating the columns**

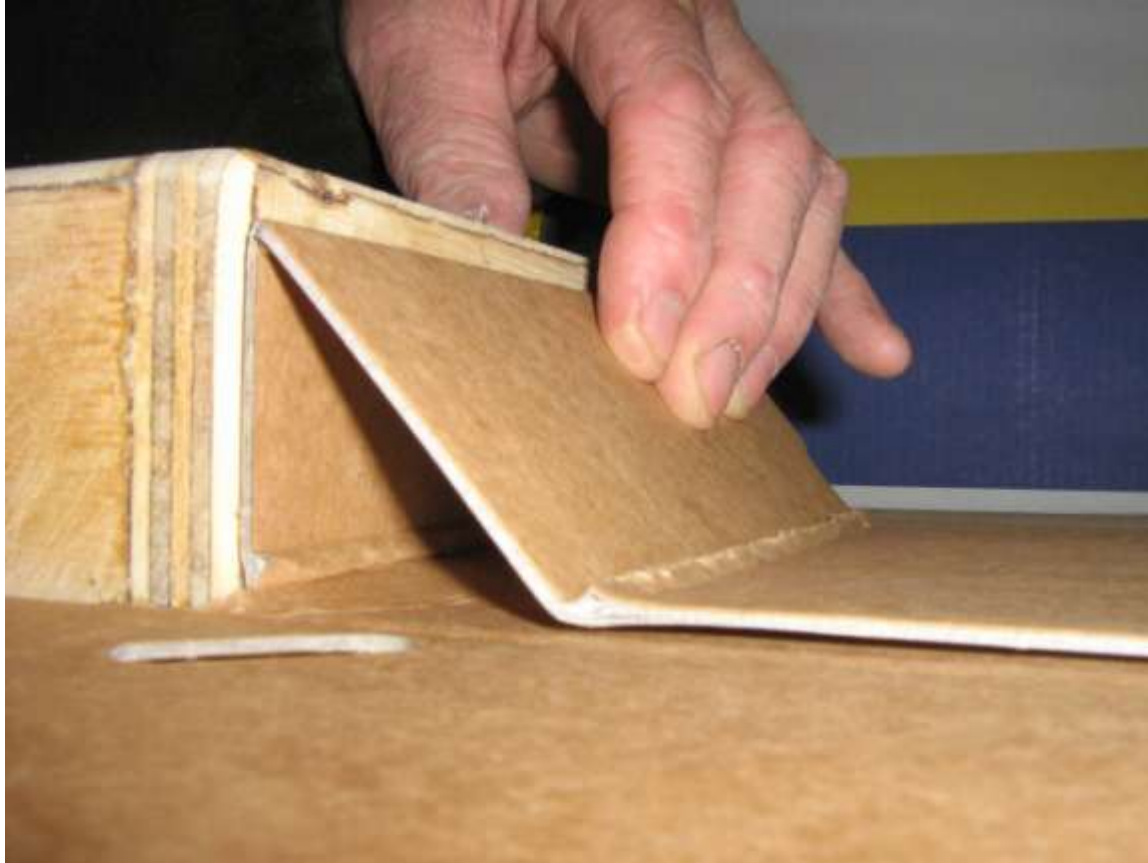
Phase 3; press further down.



### **3. Creating the columns**

Phase 4; press the middle crease line down and form a triangular column.

Use the assembly support to form a rectangular triangle.



### **3. Creating the columns**

Phase 4; make sure the column touches the support on the assembly frame.



### **3. Creating the columns**

Phase 5; lift the corner piece and apply two lines of glue.



### 3. Creating the columns

Phase 5 ; apply two lines of glue.

**Please watch out! The glue is very HOT!**

**Do NOT touch!**



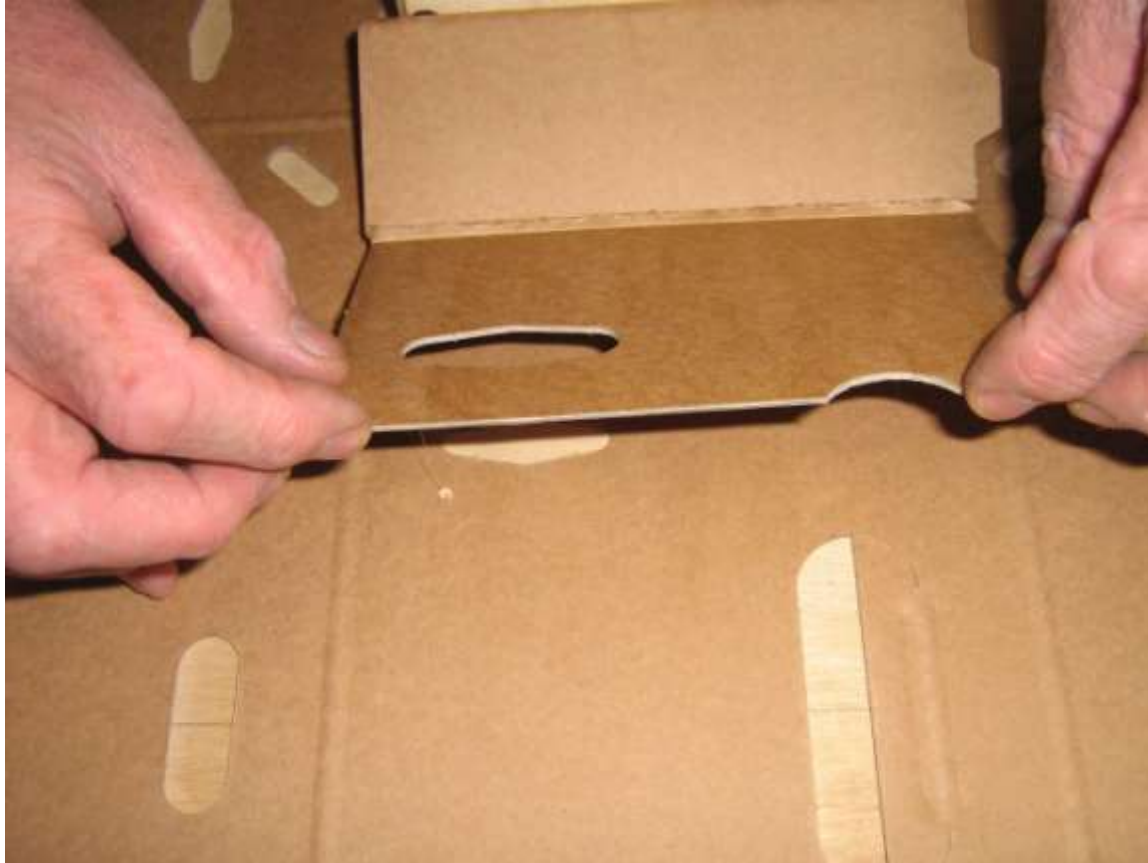


### **3. Creating the columns**

Phase 6; press down the corner piece.

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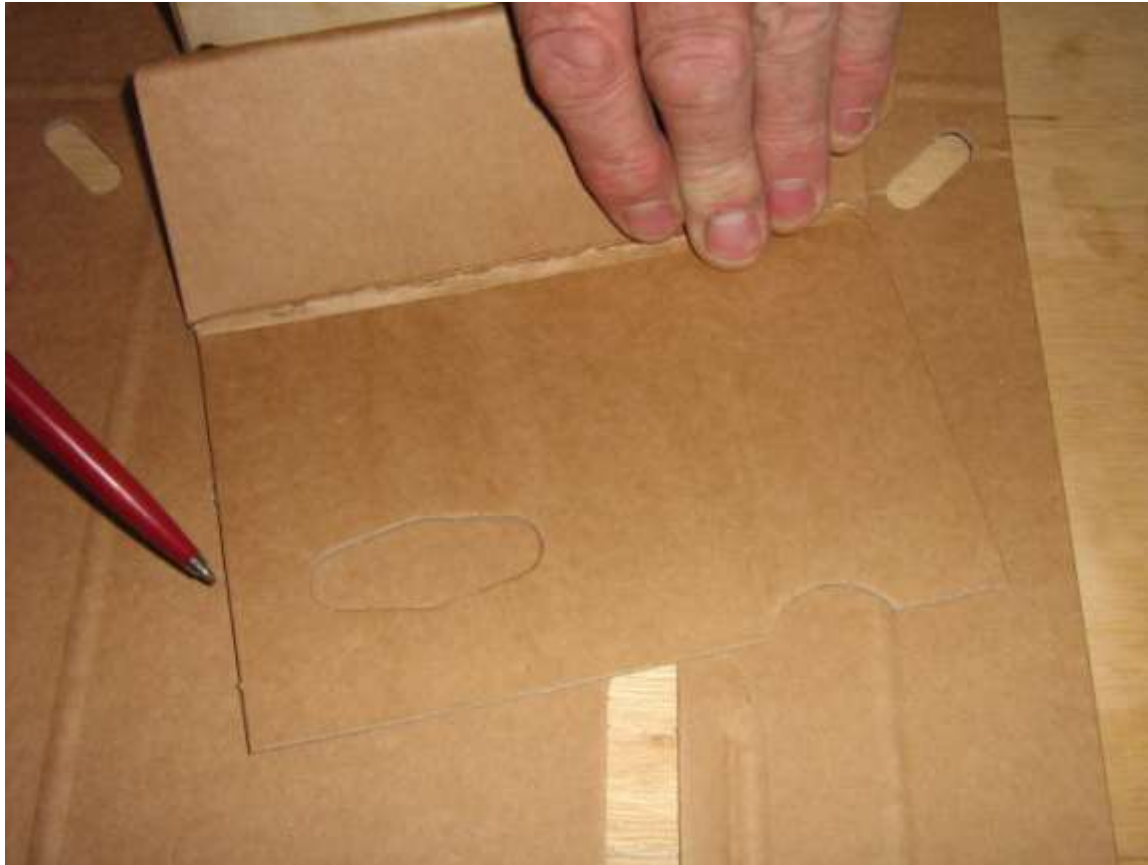
### **3. Creating the columns**

Do not wait too long as the glue will cool down and will not stick anymore!



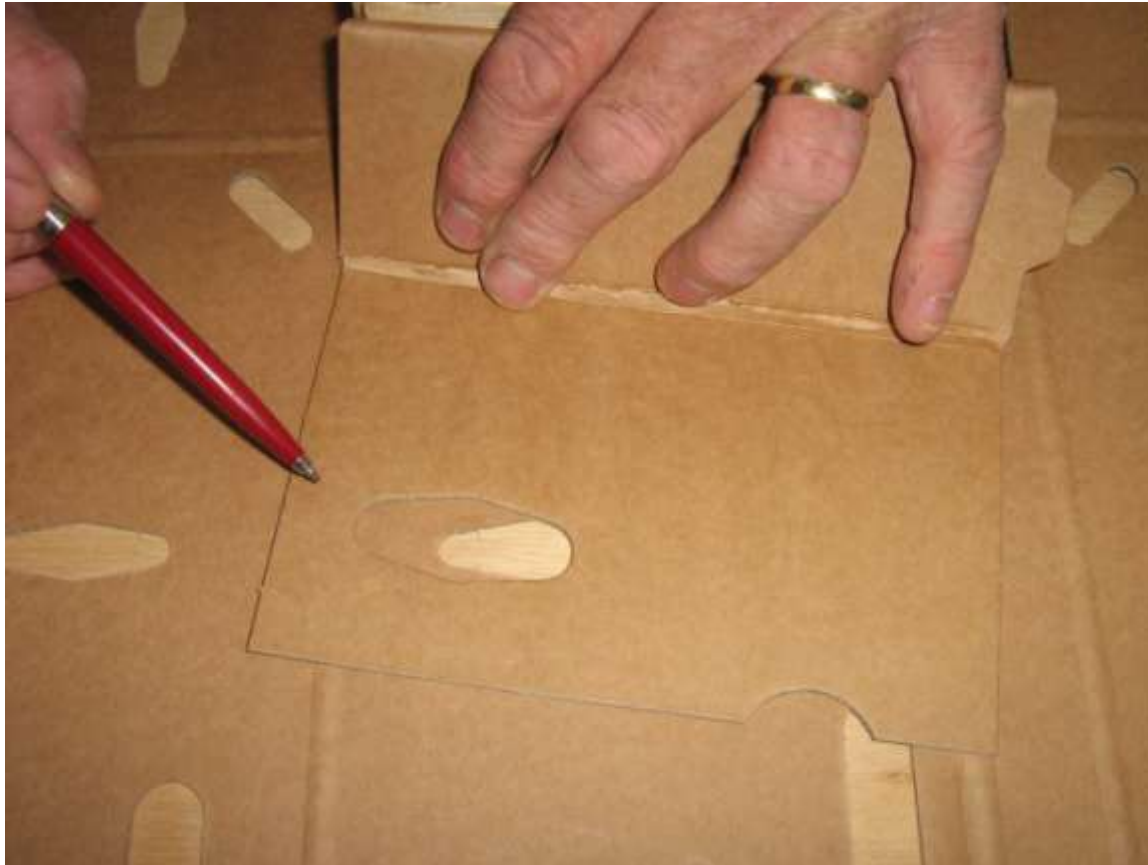
### **3. Creating the columns**

Make sure the corner touches the support.



### 3. Creating the columns

Make sure you do **not** glue the corner piece in this position.



### **3. Creating the columns**

Or in this position.



### **3. Creating the columns**

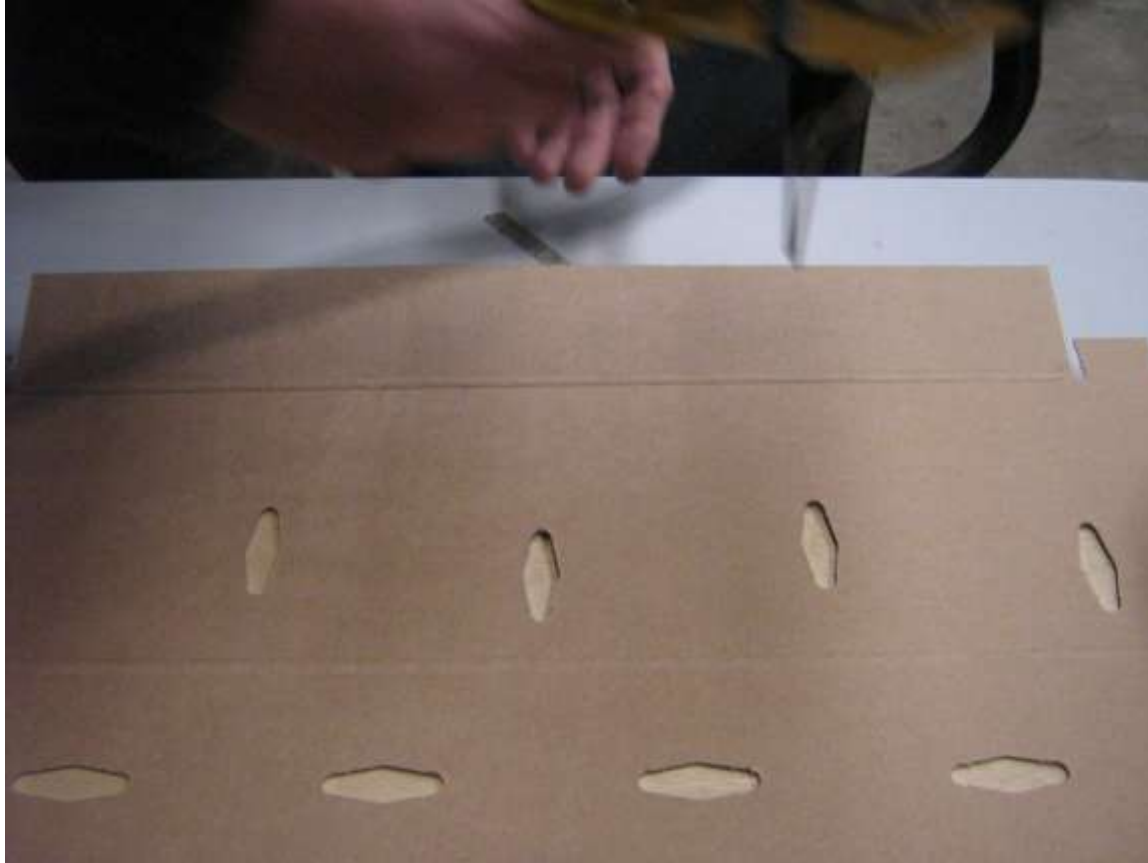
In the right position, the holes should line up.

**Repeat this procedure on all four corners.**



#### **4. Creating the double sides**

The lower long side must be folded and glued into position as showed.



## **4. Creating the double sides**

Phase 1; take the long side flap.



#### **4. Creating the double sides**

Phase 2; apply glue along the outer edge of the flap.





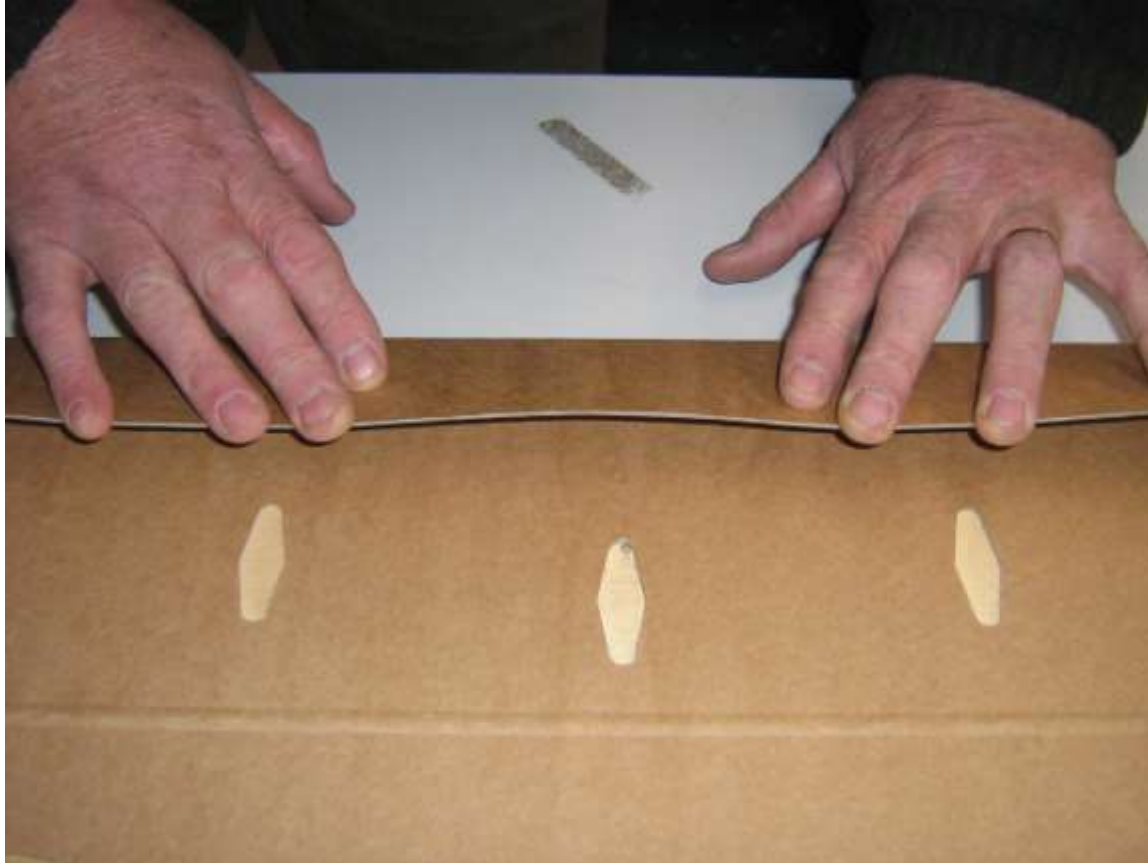
#### **4. Creating the double sides**

Phase 2; make sure there is sufficient glue on the corners of the flaps.



#### **4. Creating the double sides**

Phase 3; fold the long flap up.



#### **4. Creating the double sides**

Phase 4; fold the long flap down.



#### **4. Creating the double sides**

Phase 5; press down firmly and evenly along the whole length!



#### **4. Creating the double sides**

Phase 5; make sure the corners are well glued.



#### **4. Creating the double sides**

**Repeat on both sides.**



## **End of the assembly on frame I**

At the end of this step the die cut must have;

- four folded and glued columns.
- both long sides must be folded and glued.



## **End of step I**

Take the die cut out of the frame.





## End of step I

Remove the die cut from the frame.



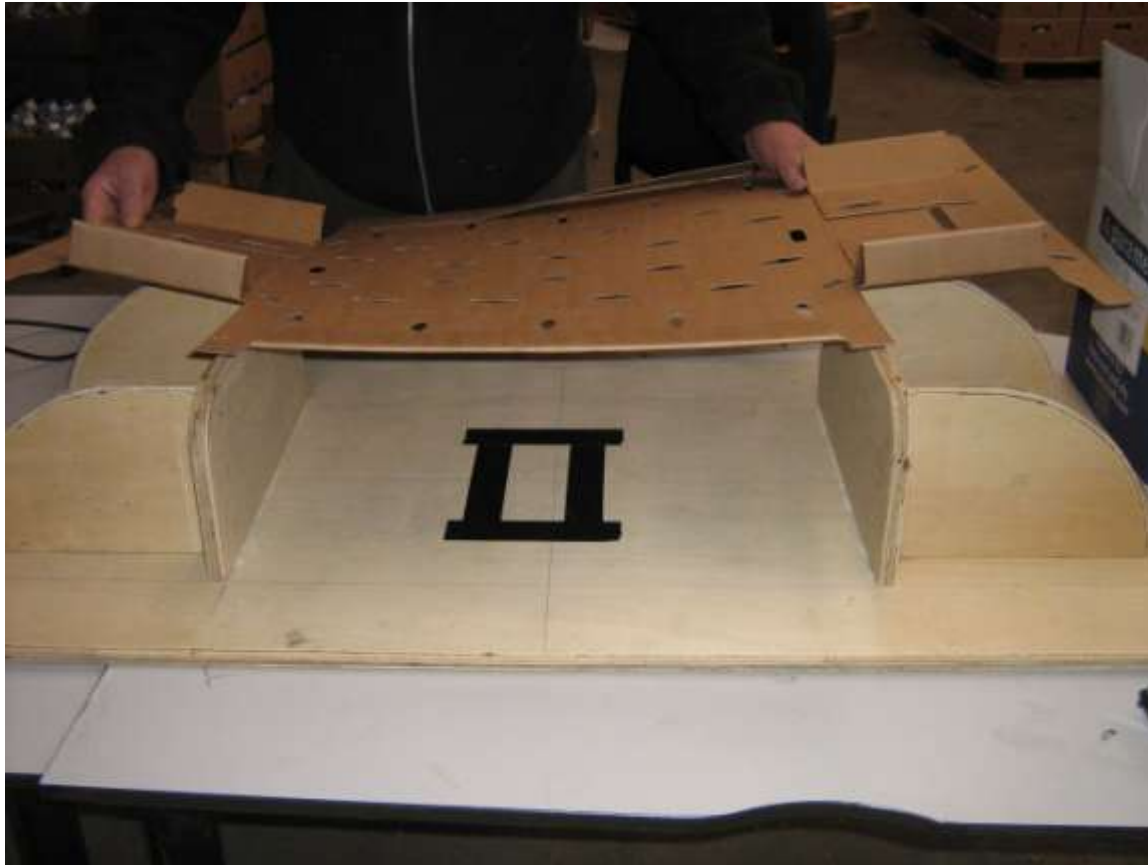
## **End of step I**

This is what it should look like.



## **Assembly frame II**

The assembly process continues in frame II.



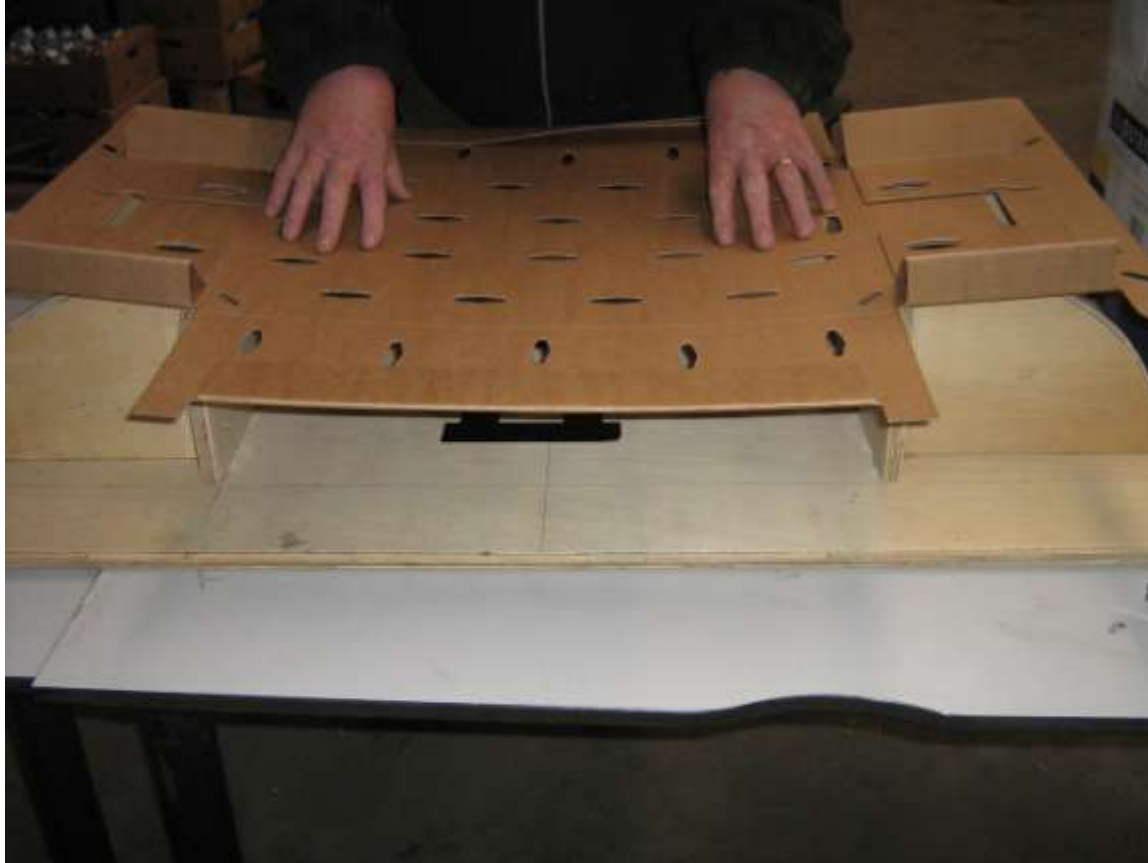
## 5. Creating the corners

Phase 1; put the die cut made in step I on the frame.



## 5. Creating the corners

Phase 1; put the die cut on the frame with the columns facing up.



## 5. Creating the corners

Phase 2; push the die cut into the supports.



## 5. Creating the corners

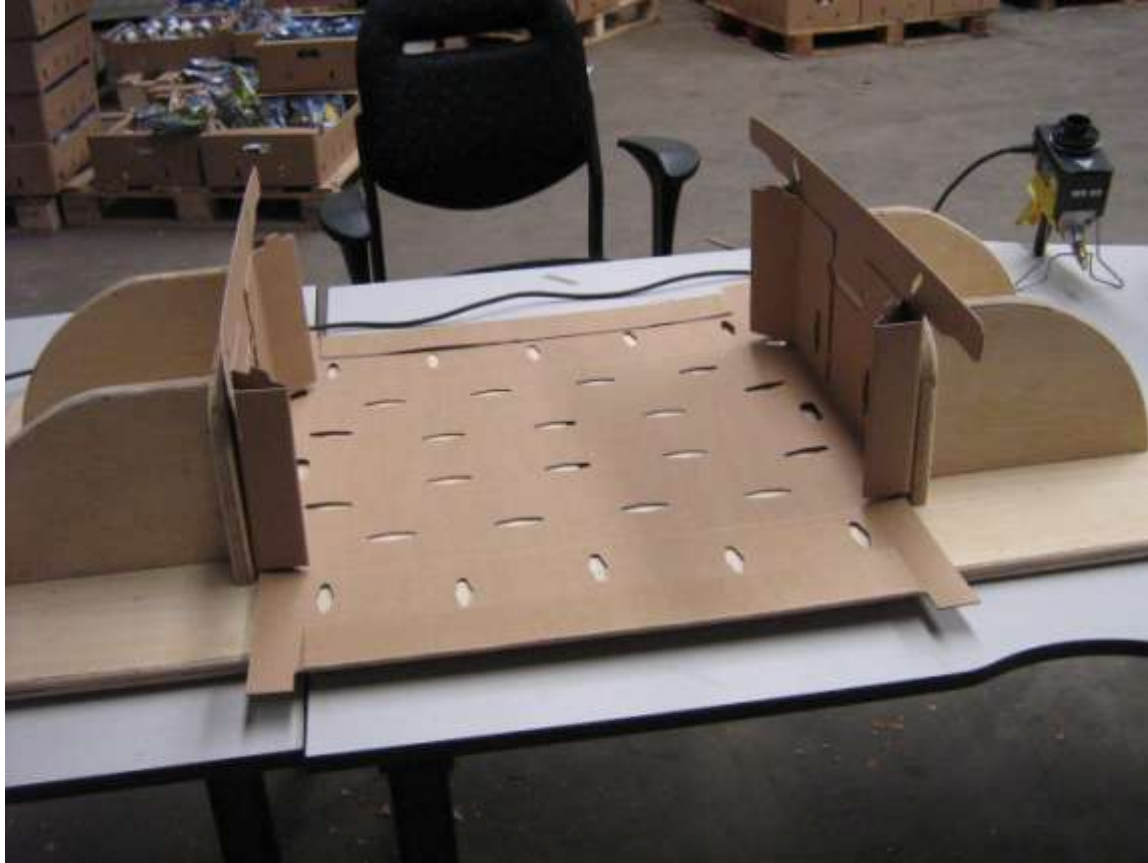
Phase2: either both sides down simultaneously



## 5. Creating the corners

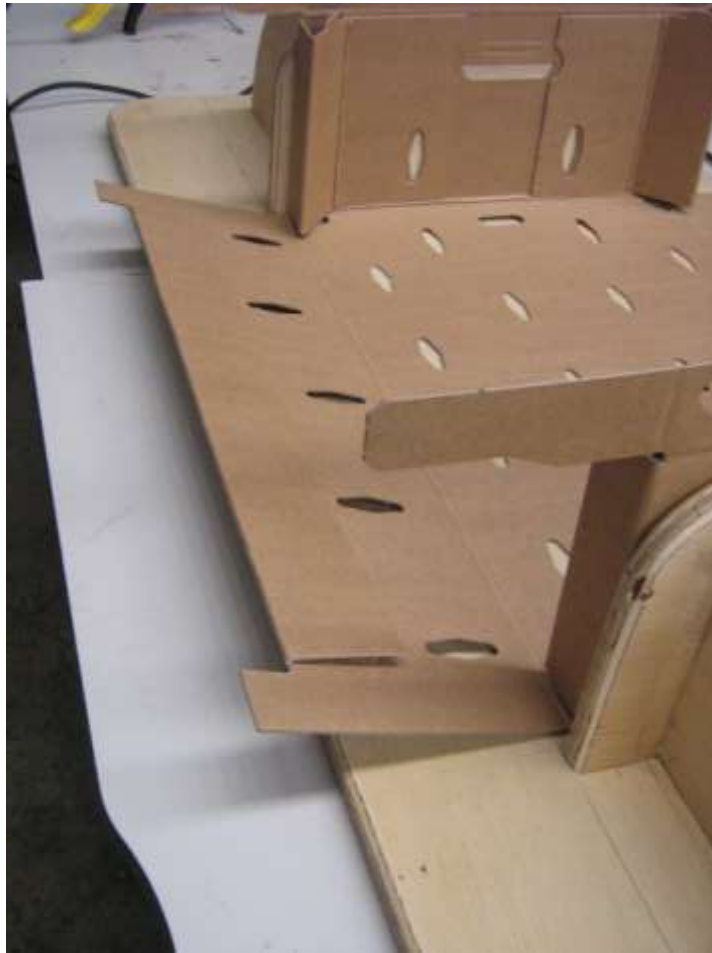
Phase2; or one side first.





## 5. Creating the corners

Phase 3; the die cut must be pushed down **completely**.



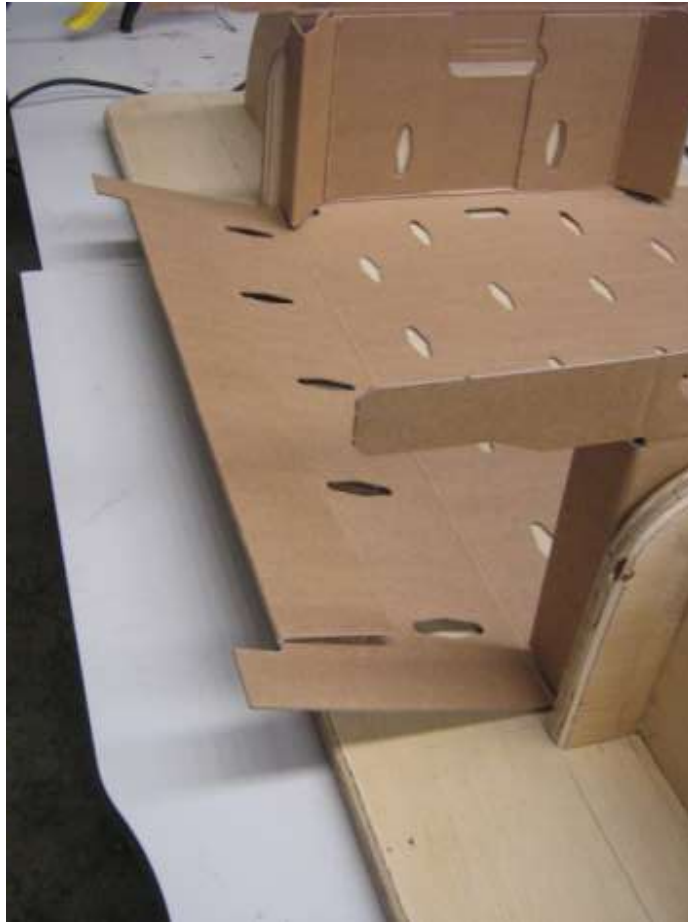
## 5. Creating the corners

Phase 3; like this.



## 5. Creating the corners

Phase 4; make sure the die cut is positioned exactly in between the supports on the frame.



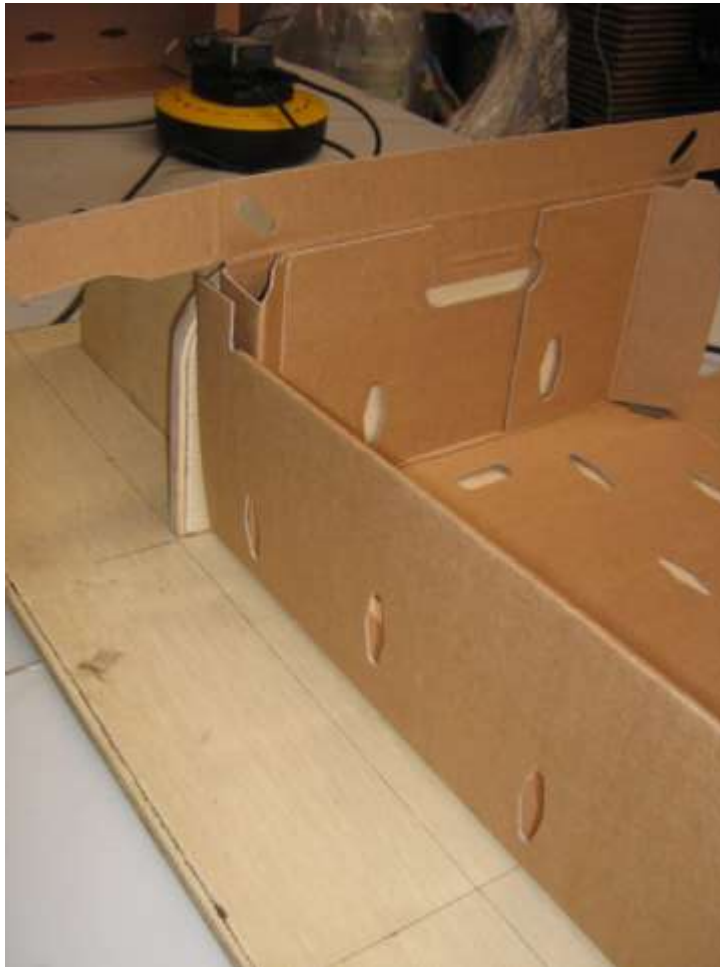
## 5. Creating the corners

Phase 5; fold the long side up.



## **5. Creating the corners**

Phase 5; fold the long side further up.



## 5. Creating the corners

Phase 6; fold up to the columns.

Then fold down completely.



## 5. Creating the corners

Phase 7; apply glue to the side, opposite the column.



## 5. Creating the corners

Phase 7; Apply one line of glue along the whole length.

Apply glue on the left and on the right corner.





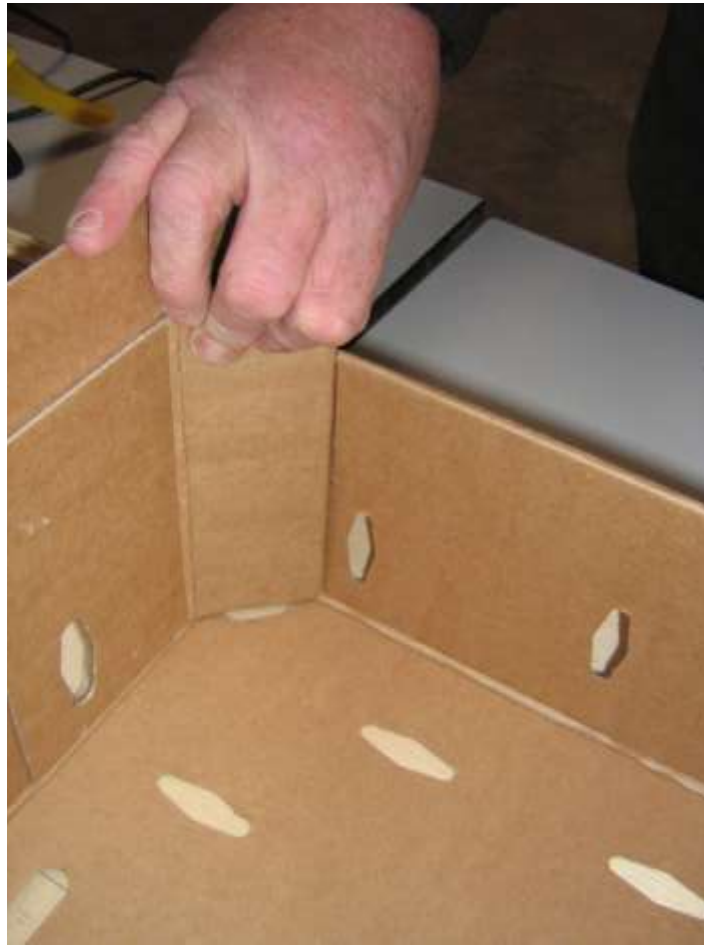
## 5. Creating the corners

Phase 8; fold the side up.



## **5. Creating the corners**

Phase 8; fold the side up towards the column



## **5. Creating the corners**

Phase 9; push the side evenly against the column.



## 5. Creating the corners

Phase 9 ; push both sides evenly against the columns.



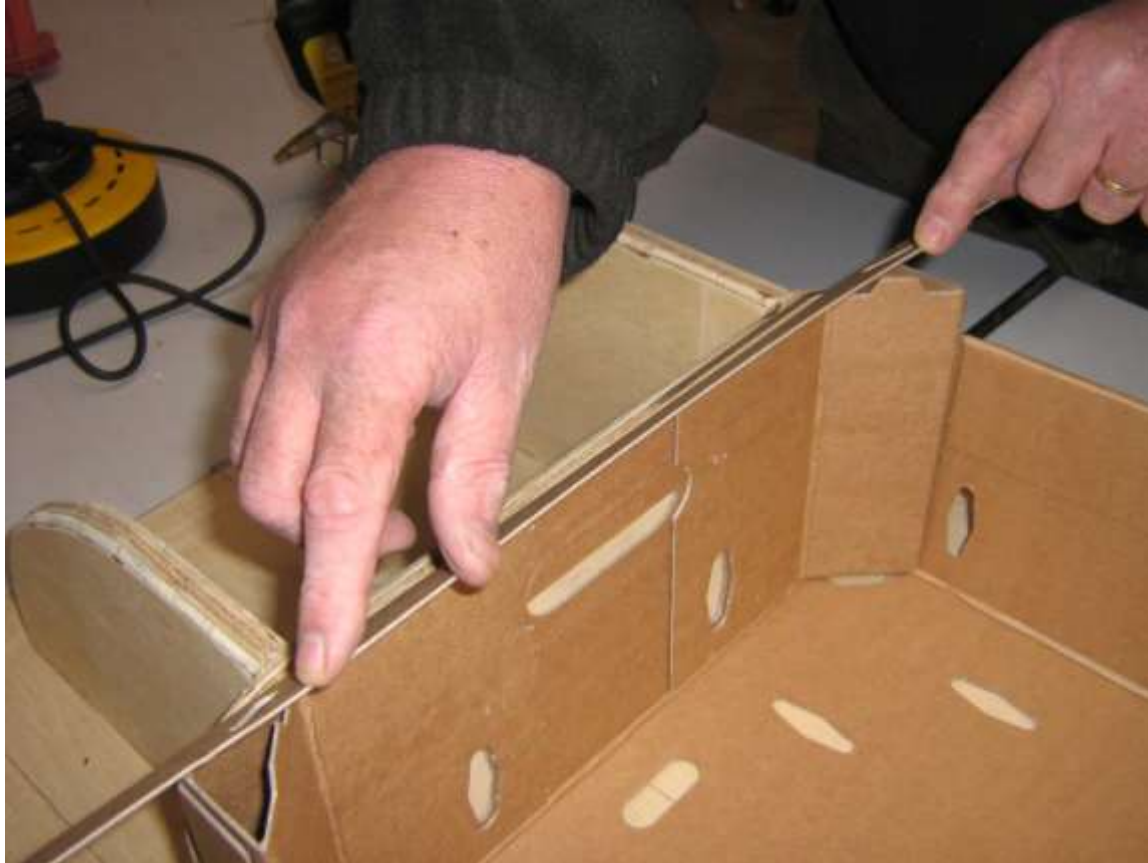
## 5. Creating the corners

Phase 10; repeat on the opposite side.



## 6. Creating the stacking platform

Phase 1; fold the flap down.



## 6. Creating the stacking platform

Phase 2; push further down.



## 6. Creating the stacking platform

Phase 3; fold completely down, onto the columns.





## 6. Creating the stacking platform

Phase 4 ; repeat the fold on the opposite side.



## 6. Creating the stacking platform

Phase 5 ; fold back the flaps of the platform.



## 6. Creating the stacking platform

Phase 6; fold down completely.



## **6. Creating the stacking platform**

Phase 7; apply one line of glue.



## **6. Creating the stacking platform**

Phase 8; fold the flap upwards.



## **6. Creating the stacking platform**

Phase 9 ; fold it further down.





## 6. Creating the stacking platform

Phase 10; press the flap against the outside of the corner.

**Phase 11; Repeat on all four corners!**



## **6.Creating the stacking platform**

Do not glue out of line!





## 6. Creating the stacking platform

Do not glue out of line!

# Finished product

This is what a stack of boxes should look like after the assembly process.





## **End of the day**

Disconnect the hotmelt gun from the power supply.



## **End of the day**

Close the bag with hot melt thoroughly



## **End of the day**

Close the box like this.



## End of the day

Remove all glue from the assembly frames.

Use a **blunt** tool.

**Please do not damage the frames!**