

Remove machine modules off truck

There are two modules. The heating section with the electrical panels and the forming section.



The forming section is shown on the more left side of this picture. It was loaded on the back of the trailer. It has a pallet of components packed inside. The forming section is the front of the machine.

The heating section is loaded closest to the truck. It is the back of the thermoforming machine.



Another view of the heating section (opposite side).

The machine was loaded from the side of the trailer with a forklift with extra long skids.



Another picture of the modules on the truck.

Heating module is closest to truck. Forming module has the blue aluminum composite material near the base.



This is the forming module.

First you carefully unload both modules off the truck. Unload from the side. We usually have extra guys around to make sure load is and stays safe and there are plenty of clearances.

Then inside the forming module is a pallet with:

- Fans
- Top Cylinders
- Shafts for the top frame.
- Extras: Box with extra bolts and mounting materials. Box of Blue lines and vacuum line connectors and extra clamps form clamping frame.

IMPORTANT: The control box is temporarily mounted on inside section of heating of machine.

Remove control box and set aside with the cables and wiring attached.

Begin assembly: Take two modules of machine and put together. On both sides of machine are mounting plates/flange plates. Push/slide both modules together. When 100% together, using bolts left in channel secure two modules together.



Bracket hold machine.

Once machine modules are joined and bolted, take cylinders out of white SMC Boxes and mount on top front forming section and to the mounting plates (Using the bolts there).

Mount fans to the back top channel to the machine as shown in picture.



This is where fans mount on the back channel.

Put in electrical and airlines

There is a cable running from bottom of machine through wired track, leave a service loop for it to go to machine.



Shows "service loop".

"Loop cable to bottom and front secured with clamps. Secure cable to clamp along the bottom to the front of the machine. Leave a service loop."

Re-Mount Control Box

The Control Box is removed from back and remounted on front using gusset with bolts already attached.



There is a gusset bracket on the front of the machine. Slide the control box into gusset.

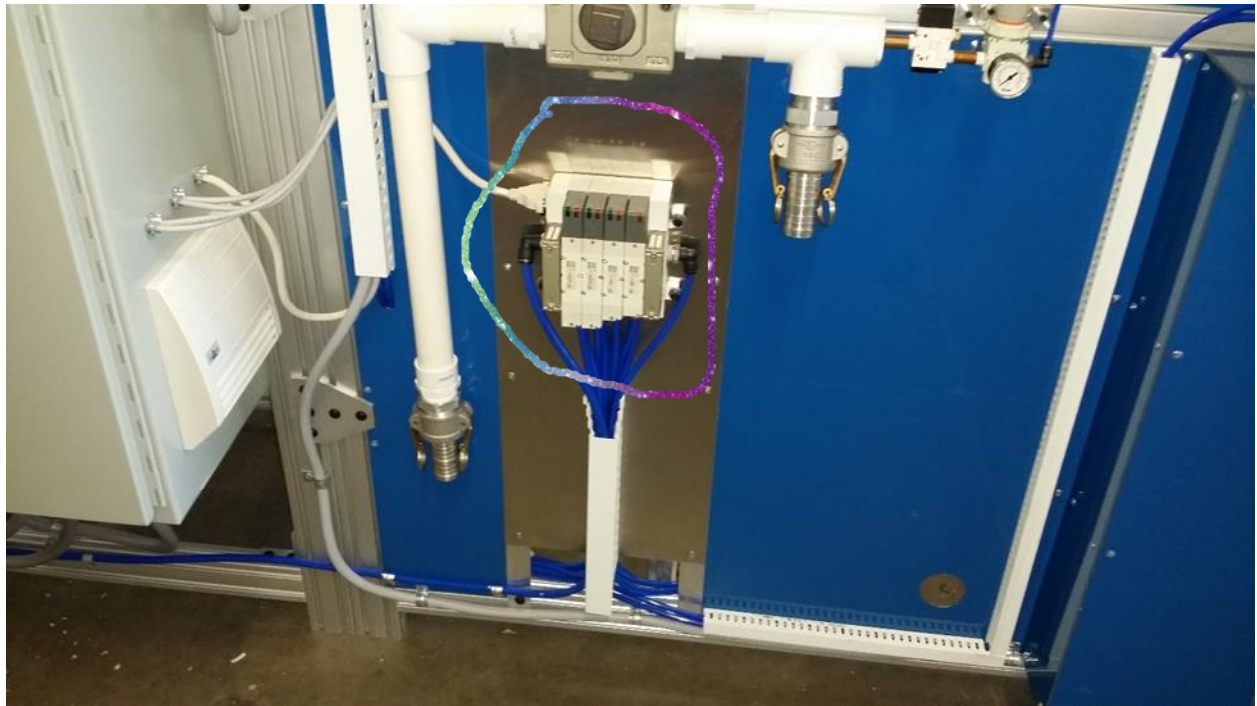
The picture on right shows how it is mounted.

After control box is mounted, there is a limit switch (black with silver plate) connected to the front control box cable.



Power Line running to the control module secure with clips.

Now the front section control box is done, we will focus on all valves.



Control Block.

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Power and air lines.



Lines to the air blocks.

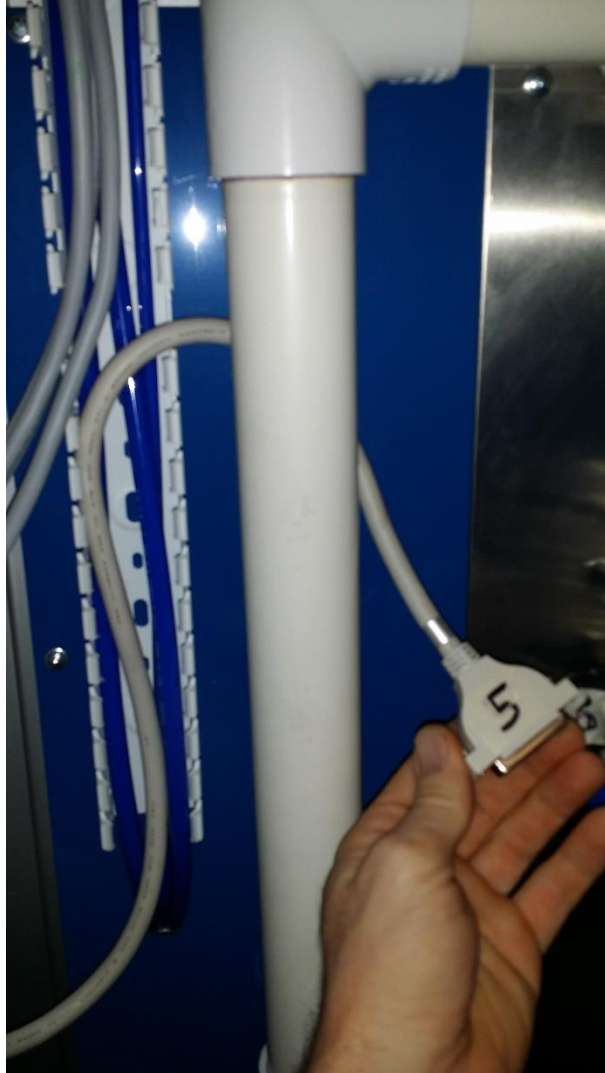
On the front left side are the vacuum valves and the air valves.

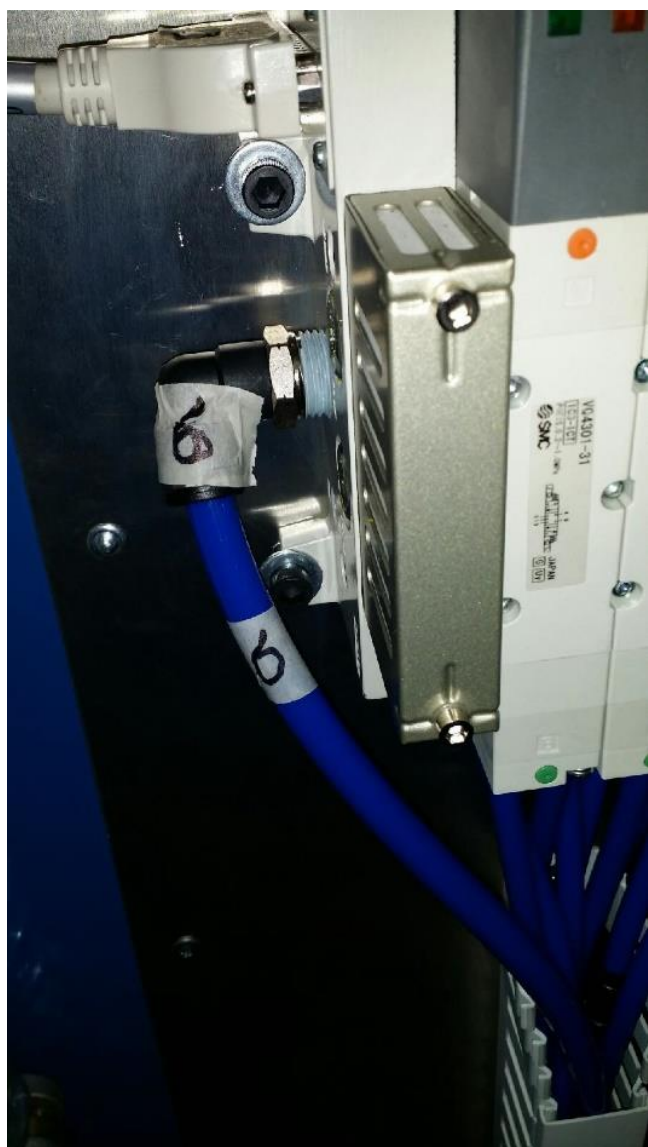
Connect #1 through #6, in the pictures and as marked on the components.













Air lines to air blocks.

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Go back to the heating section of the machine. Remove the back panel as labeled. Take two shafts and slide them through the mounting brackets in the back of machine.

Then go through at the joined sections of the two modules. Use the bolts provided to go up through the bottom of the shaft mounting bracket and with two screws on each side of the shaft.



Two bolts on side and Two bolts on the bottom to secure.

