

BASIC ASSEMBLY INSTRUCTIONS FOR THE 44" X 64" RIGID TWIN TWIN STATION



UN-PACKING MACHINE FROM CRATE

The machine was shipped in (3) basic assemblies. The top heat main pressing frame-the left extension rail assembly-the right extension rail assembly.

Great care must be taken while removing assemblies to insure proper assembly and machine function when completed.



LEFT
EXTENSION
RAIL
ASSEMBLY

RIGHT
EXTENSION
RAIL
ASSEMBLY

MAIN TOP
HEAT
PRESSING
STATION

REMOVING LEFT AND RIGHT EXTENSION RAIL ASSEMBLIES FROM MAIN CRATE

Both the Left and Right extension rail assemblies are attached to the main crate by the use of metal brackets. These brackets are looked on the bottom of each assembly to attach to the bottom crate, as well as above to brace the two assemblies together by the use of a 2" x 4" timber across the top connecting the two. Carefully remove the lag bolts and carefully lift each section-then move outward away from the machine press. Once the extension rail assembly is away from the crate, carefully rest on the floor. See pictures below of the bracketing



EXTENSION RAIL ASSEMBLY
UN PACKED FROM CRATE



LOWER ANGLE BRACKET BRACING

PUTTING THE MACHINE TOGETHER

At this point, all (3) main assemblies have been removed from the crate and unpack. Follow these basic steps in assembly.

1. Locate the MAIN pressing station in the area you want the machine to finally be positioned in your shop. Make sure you leave at least (84") to the left and to the right of the main pressing station. Locate the machine on a flat solid floor. Some customer's may want to have the machine on casters. However, it is better to have the machine resting on the floor without. If you desire to move the machine-NOTE: you will need to have the proper power cording to be able to detach from the disconnect. This can be costly. Lift the machine to attach the casters if in fact you want to have the machine mobile.
2. Carefully remove all shipping timbers and wrapping from the main pressing station. You will see that under the heater block is (1) complete load vehicle with the 2nd load vehicles top aluminum plate placed on top.(A load vehicle is the shuttle table that you load your work on. NOTE: It is made up of the top aluminum plate with (4) roller bearing assemblies. One underneath each of the 4 corners of the plate. You need to remove any shipping cardboard and strapping from these plates.
3. Next, carefully remove the single aluminum plate that is NOT attached to anything and set carefully on the ground away from the press. (rest on some wood timbers) At this point you should only have (1) of the load complete load vehicles under the heater block area. For shipping, they maybe wood or cardboard supporting the aluminum plate of this complete vehicle. You need to carefully lift and remove any lower cardboard that might be supporting it.
4. Carefully bring over to the machine the complete LEFT extension rail assembly. You will be connecting the left rail assembly to the MIDDLE rail assembly on the machine. This UNION is done with union plates attached to the MIDDLE rail assembly. There is one union plate on the outside of the two rails and a small union plate that is located on the bottom to tie the two assemblies together.



5. You will need to adjust the leveling feet on the extension assembly. By using a standard level. Adjust the leveling feet to the extension assembly to make sure it is level with the main middle rail assembly. The goal is to have the guide rails of the two lined perfectly with each other and the rail to be level.
6. Once the Left side is attached, please proceed with attaching the right extension rail assembly.



7. With both the left and right side rail assemblies attached to the mid rail of the press and have been leveled and confirmed that the center distance between guide rail is equal throughout, you should be able to roll the one complete load vehicle back and forth on the extension rails. NOTE: Make sure the rubber bumper end stops on either end or attached before testing.(Prevent the load vehicle from rolling off the end.)
8. You will note that marked with a black marker on the complete load vehicle's aluminum front edge plate, it will say either (LEFT) or (RIGHT). This will let you know which load vehicle it is as you are looking at the front of the machine. On one of the rail extension assemblies will be marked as well to help you know how to assemble. The 2nd load vehicle now needs to be assembled. We start with rolling the rolling bearing assemblies that were on the extension rails to a spacing close to what the 1st complete assembly had.
9. There is a "ROLLING SPACER TUBE" that was shipped on the rail assembly. You want to make sure that this spacer tube will be "between" the two complete load vehicles. This rolling spacer tube has rubber bumpers on either end of it and maintains proper spacing between the load vehicles while using the press.



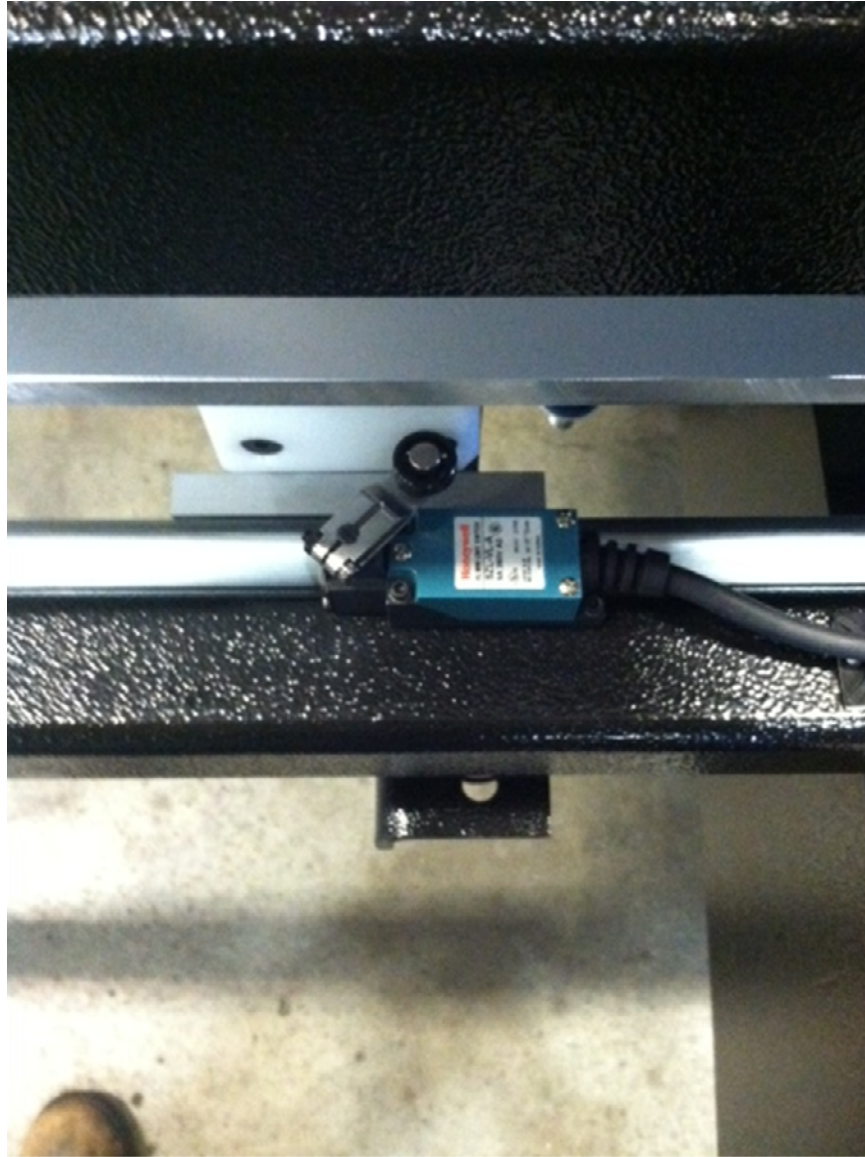
ROLLING SPACER TUBE
POSITIONED BETWEEN THE TWO LOAD VEHICLES ON THE FRONT RAILS

10. Once you have confirmed your LEFT'S and RIGHT'S are correct, and you have the roller bearing assemblies spaced, Lift up the 2nd aluminum plate that you had placed on the floor and carefully lower it onto the top of the (4) rolling bearing assemblies you had spaced. You will not that in marker, they are marked to match up with its proper rolling bearing assembly.
11. Once the all of the aluminum plates threaded holes line up with the roller bearings holes, attach the shoulder bolts and blue springs just like that of the complete assembly. (See Below)



SHOULDER BOLT AND SPRING ATTACHED TO THE ROLLER BEARING
ASSEMBLY ENGAGED TO THE RAIL

12. You now should have the LEFT and the RIGHT load vehicles on the machine with the rolling spacer tube rolling freely between the two of them.
13. We next need to make sure the rear timer indexing lever switch is properly engaging with the load vehicles as you roll them left to right. This lever switch makes sure that there is a load vehicle under the heater block before you are able to activate the machine. This switch should be activated when one of the load vehicles is in place to be pressed. (See Below)



14. Once you have made sure that the load vehicles are properly assembled and that the rear lever switch is being activated once a load vehicle is in place, you can attach the power to the electrical disconnect and connect the air line to the air filter on the back of the press. The serial tag on the machine will give you the proper voltage and amperage with phase needed for your machine.

If you have any questions or have assembly questions, please contact the factory at

1-800-525-6766