

Inline and Continuous Thermoforming Machine Specifications

Lyle 50" Form & Trim Inline Thermoformer - Rebuild

Stopol Machine ID	QOUHBA1B25K3
Brand	Lyle
Manufacture Year	
Model	Rebuild
Process	Roll Fed
Maximum Trim Area	50"
Platen Stroke: Upper	7"
Platen Stroke: Lower	7"
Platen Type	
Index Drive	servo
Heat Source	Solar Ceramic Radiant panel / calrod bot
Top & Bottom Ovens	Yes
# of Top Oven Zones	
# of Bottom Oven Zones	
Controls	Relay
Stacker	No
Scrap Rewinder	No
Voltage	480 volts, 600 amps
Condition of Machine	
Material Run	
Machine Dimensions	
Hours	

Additional Notes

Lyle model 150F-RFT Form & Trim In-Line:

* Quartz top, Calrod bottom

* Gib & Way Form-Station Platen-Stabilization * System Sprocket Style Pin-Chain Sheet *
Transfer-rails Hydraulic-Index System

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- * Relay Controls
- * Rework to be Performed or New Systems to be Added..
- * New Material Roll-Support Stand & In-Feed System
- * Holds Two(2) 52"wide x 36"dia. Raw-Material Rolls
- * Electric Powered Unwind Payout System
- * Stainless-Steel Tray & In-feed Edge-Guides
- * New & Existing Oven-Heating System
- * Electric Panel Heaters - Upper-Bank Only
- * Existing Clam-Shell Oven System Multi-Zoned
- * Closed-Loop/Temperature Oven Control
- * Four-Stop Heating - 216"
- * New Pin-Chain Slide-Rails Material Transfer

System:

- * Hardened Slide-Bars Pin-Chain Guides
- #50-Roller Pin-Chain
- * Electric Servo Indexing System Splined Front Drive-Shaft
- * Form-Station(existing Lyle 150F) - Rework Gib & Way Platen Guide System Toggles & Associated Cylinders
- * Mechanical Platen Retracted-Position Stop Pads
- * 7"stroke - Lower Form-Platen 7"stroke - Upper * Form-Platen New Trim-Station - 100ton
- * Four-Post Platen Guide System
- * One Set of Double-Toggles & Balance Cylinders per Upper-Platen Mechanical
- Upper-Platen * Retracted-Position Stop Pads
- * 7"stroke - Upper Form-Platen
- * Two(2)-point Hydraulic Trim-Cylinder System * Lower-Platen 100ton Trim Capacity
- * 3"stroke - Lower-Platen
- * Electric Position Adjustment System - 30"range
- * New Scrap Web Wind-up System Scrap Web Accumulation
- * Electric Drive system
- * 60" Take-off Exit-Tray - Post Slide-Rails

New Controls

- * IMC-4000 Integrated Machine & Oven Control * System Allen-Bradley Based PLC Controls
- * Touch-Screen Operator-Interface Device Full * Ethernet Capabilities
- * Recipe-Storage

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Mold Specifications

- * Maximum Mold Size - 50"wide x 50"long * Maximum Sheet Width - 52"
- * Maximum Part Depth - 7" above sheet-line
- 2" below sheet-line
- * Maximum Tool Weights - 1000lbsperTool-Half(estimated)

Roll-Support & Powered-Unwind (New)

- * Two-up material roll-stock support system.
- * Two roll-stocks of material can be loaded onto the support-stand.
- * Two sets of 1 1-2"dia shafts with 6"core-chucks
- * Integrated into the roll-support stand is a powered unwind system.
- * The powered unwind system utilizes an electric gear-motor drive system, with pinch-rollers for uncoiling the material roll-stock.
- * 52" maximum roll-width - 30"maximum roll diameter capacity.
- * 1hp/20rpm pinch-rollers drive design, ac gear-motor direct-drive design.
- * Adjustable pinch-roller gap design.
- * Speed pot for setting pinch-roller speed, 4"/second maximum speed.
- * Sag-eye design for sensing excessive sheet sag.

Oven-Heating System: (New & Rework)

- * Heated area is 51"wide by 216"long, four-stop oven-heating system.
- * Heaters consist of cloth-face(upper oven-heating bank) and calrod/tubular(lower oven-heating bank) high-efficiency electric panel-heaters.
- * Cloth-face electric panel-heaters in the upper heating-bank as follows_ 16each - 6" x 51" 6120watts 480vac single-phase
10each - 12" x 51" 12,240watts 480vac single-phase
- * Clean and repair/replace lower-bank calrod heating elements as necessary.
- * Add new rail-heaters, calrod/tubular heater elements as follows... 2each - 210"sheath length 12,000watts 480vac single-phase
- * Watt density of 20watts/sq.in. per upper oven-heating bank, as existing for the lower oven-heating bank.
- * Oven-heating control zones.
Upper-Bank - 26zones
Lower-Bank - 2lzones
- * All zones controlled individually on a closed-loop temperature control basis. i) Solid-state

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Inline and Continuous Thermoforming Machine Specifications

relays for high-volt switching.

- * All zones use "K" type thermocouples for closed-loop temperature control.
- * Repair the existing oven-frame structure and clam-shell style opening & closing system for the upper & lower oven-heating banks, as necessary.
- 1) Upper & lower oven-heating banks are adjustable toward and away from the form-station for varying mold lengths & maintenance/set-up access to the form-station.

Servo Index and Pin-Chain Material Transfer Rails: (New)

- * Material-transfer rails have hardened steel slide-bars and use #50 single-strand roller pin-chain.
- * Water-cooled cooling-tubes utilize a special v-track pin-guide system for maintaining material grip.
- * Splined front drive-shaft and threaded rail adjusters front and rear for easy adjustment of rail widths, electrically actuated(see "k").
- * One rail-stabilizer for controlling the bow of the rails at the rear of the form-station, two rail-stabilizer for controlling the bow of the rails at the front & rear of the trim-station,
- * All rail width adjusters are manually/hand operated.
- * Allen-Bradley Electric servo index control system.
- * Servo-motor is direct coupled to a high-efficiency gear-box drive system.
- * The servo-motor and gear-box are directly coupled to the splined drive-shaft system.
- * Automatic air pin-chain tensioning system.
- * Integration of the existing lubrication system for lubricating the pin-chain rollers through the rear-end hardened in-feed guide-bar at the point of contact.
- * 5" pierce wheels at the in-feed end of the machine, adjustable piercing depth.
- * A high wattage edge rail-heater will be installed on the inside edge of each pin-chain slide-rail system, individually controlled, closed-loop control.

Form Station: (Rework)

- * The existing Lyle 150-F form-station has upper & lower form-platens.
- * Upper form-platen has an 7" stroke, the lower form-platen has an 7" stroke.
- * The form-station upper & lower form-platens utilize a pair of toggles with 2 toggle-pins.
- * The toggles use pneumatic-cylinders for actuation, and each form-platen has a pneumatic balance cylinder.
- * Each form-platen utilizes a gib & way style platen guide/stabilization system.
- * Replace toggle-pins & toggle-bushings.
- * Review platen guide-bushings & misc. components.

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- * Rebuild toggle & balance-assist cylinders.
- * Replace air-hoses.
- * Review adjustable upper-head system.
- * Mold related valves will be rebuilt or replaced, i.e. vacuum-bleed, main-vacuum, air-eject, pressure-form & pressure-form exhaust, as necessary.
- * (1) The pressure-form circuit will utilize a manually adjustable pressure switch. m) Mold changes will be permitted from the front of the form-station. o) 10001bs maximum tooling weight allowance per platen.

Trim Station: (New)

- * Maximum tool/mold size is 50"wide x 50"long.
- * Maximum trimming pressure 100tons.
- * Four-post platen guides of 3" shafting.
- * Two reinforcement connecting bars between the trim-head and trim-base.
- * A double-toggle system for the upper trim-platen with 2 t,2" toggle pins.
- * An 7"bore actuator-cylinder will be used for the double-toggle actuator.
- * Two 6"bore pneumatic assist cylinders for the upper trim-platen.
- * Two 7"bore hydraulic cylinders for the lower trim-platen actuation.
- * strokes are... 7" upper trim-platen
3" lower trim-platen
- * (2) 7"bore 3"stroke hydraulic-cylinders will be integrated into the lower trim-platen for the trim-cut operation.
- * The lower trim-platen will have a proportional control-valve for movement control.
- 1) Distance between trim-platen surfaces is 18 1/4" with both platens in the extended(closed).
- * 9 1/8" from the face of each trim-platen to sheet-line.
- * Each trim-platen has a surface ground solid-plate steel face design.
- * Platen tool-mounting bolt pattern to be supplied by the customer.
- * Platen is 48"long in sheet-travel direction.
- * Trim-station has an electrically adjustable positioning device with a 30" travel in sheet-index direction.

Exit-Tray (New)

- * Stainless steel parts tray is 96"long.
- * Parts tray is fixed in position at the end of the machine. c) Parts tray has a return roller at the exit edge.

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Scrap Wind-up: (New)

- * Scrap windup system is driven by an electric-motor.
- * The electric-motor and a #40 roller-chain drive a set of scrap-windup forks. c) The electric-motor starts at initiation of the index and ends with an adjustable timer function.
- * An on/off control switch for the scrap-windup will be located at the end of the machine for the operator.

Pneumatic & Vacuum: (Used & New)

- * New 5hp Busch vacuum-pump adding to the existing reservoir-tank for the vacuum supply system.
- * 1 1/2"npt main-vacuum and vacuum-bleed valves.
- * The vacuum-bleed valve circuit includes a ball-valve for adjusting air-flow.
- * 3/4"npt pressure-form and pressure-form exhaust control valves.
- * The pressure-form circuit includes a manually adjusted pressure-switch for controlling forming pressure.
- * 3/4"npt air-eject control valve.
- * The air-eject circuit includes a pressure-regulator and ball-valve for adjusting air-flow.
- * New/used 1 1.5npt main-air FRL supply, clean-up as necessary.
- * Rebuild existing form-station platen control valves & cylinders.
- * Pneumatic installations all performed to national codes and industry standards.
- * Brand name components - Parker, Mac Valves, Numatics.

Hydraulic: (New)

- * 15hp 3000psi rated hydraulic power unit will power the 2each7"bore Hydraulic trim-cylinders.
- * The hydraulic power unit will include an 30gallon reservoir.
- * The hydraulic power-unit uses a case-drain cooling-system.

Electrical: (New)

- * Electrical requirements - 480volts 3phase, 600amps(fused@700amps)
- * Electrical installations all performed to national codes and industry standards.
- * Brand name components - Allen-Bradley, ABB, Square-D.

Automatic Lubrication System: (Used & New)

- * Automatic lubrication system for all form & trim station toggle short-arms and guide-posts.
- * Lube system also used for slide-rails pin-chain/slide-bars lubrication.
- * Utilize existing lubrication system for form-station and pin-chain/slide-bars lubrication,

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Inline and Continuous Thermoforming Machine Specifications

repair as needed.

- * Also integrate existing lubrication system for trim-station toggle-arms and guide-posts.
- * The lubrication system uses a low-viscosity grade "0" grease.
- * Function of the automatic-lubrication system is set and controlled through the operator interface control screen.

Controls: (New)

- * IMC-4000 integrated machine control system using the Allen-Bradley Electric servo-index and Allen-Bradley compact-logic PLC for the machines control system.
- * Touch-screen operator interface module - 8"(Red-Lion).
- * Recipe storage capabilities, 100recipes.
- * All oven zones are controlled by the Red-Lion interface screen and a series of Red-Lion dual-loop controllers for a closed-loop temperature control system.
- * All machine mechanical functions are set through On-Delay & Off-Delay timers scaled for "on & off" functioning with form dwell adjustment for variations.
- * Servo index acceleration, speed and distance are adjustable through the Operator-interface touch-screen.
- * An Ethernet-device will be installed for direct connect to the O.E.M. or your factory network.
- * Add Vortex-Cooler to existing control panel.
- * LH control side of the machine.

Safety:

- * Utilize existing and new guards.
- * All guards are sectional with hinged-doors and/or roller-doors that that by-pass slide next to each other.

Pictures

Video No

Price Please call for pricing.

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