Saje uPVC Unloading Process

Process for unloading and locating Autoflow Mk4 machine in Saje upvc

Difficulty **Hard** | Duration **4 day(s)**

Contents

Introduction

Access for machinery is limited at the Saje factory.
The machine will be delivered in the following modules, that should be unloaded from the lorry in this order

1. Electrical Cabinet
2. Machining centre base module (1.8 x 2.2m)
3. Infeed module (2.4 x 9.0m)

Items

Forklift Extensions

Prerequisites tutorials

Use protective footwear

Use protective clothing

Use protective headgear

Step 1 - Lorry Loading Schedule

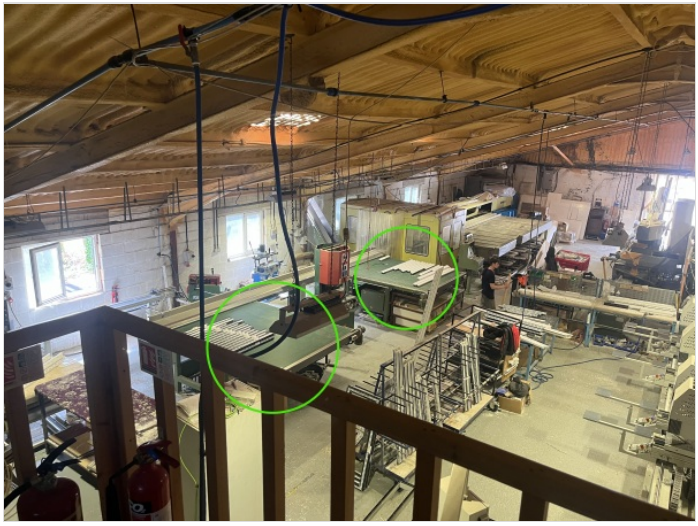
The Infeed table in particular needs to be loaded in such a way so it can be unloaded in the correct direction

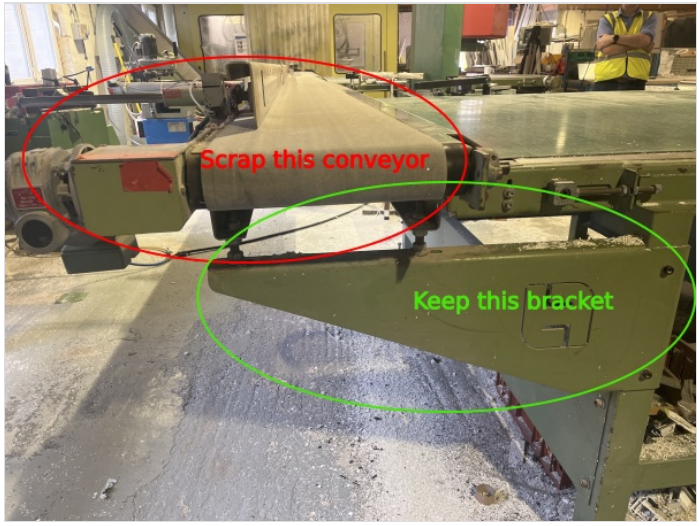
Step 2 - Machine Arrival

Thursday PM
Unload machining centre and store in Glass shed
Unload infeed and cover with Tarpaulin
Unload electrical cabinet and store inside

Step 3 - Remove the Soenen Machine

Friday
remove the Soenen machine, leaving the large outfeed conveyor tables
The Brackets on the outfeed tables will be used for the Stuga conveyors

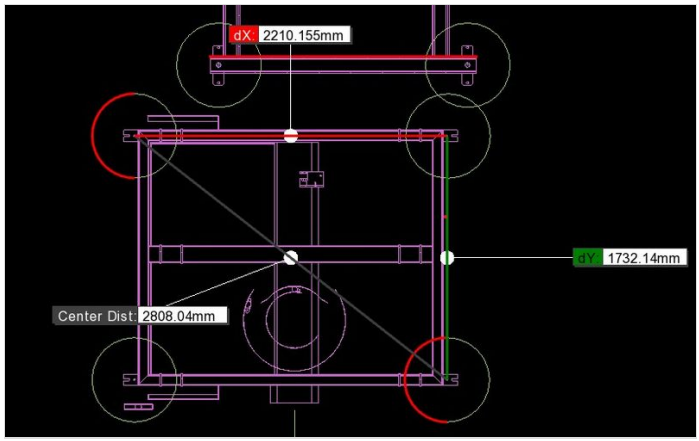


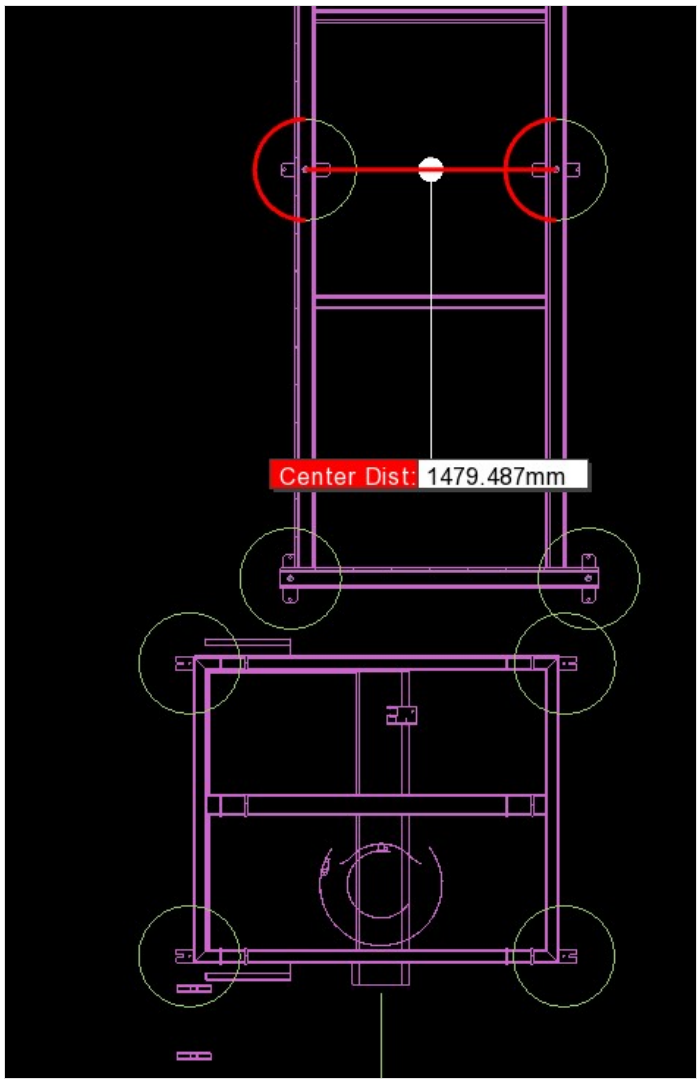


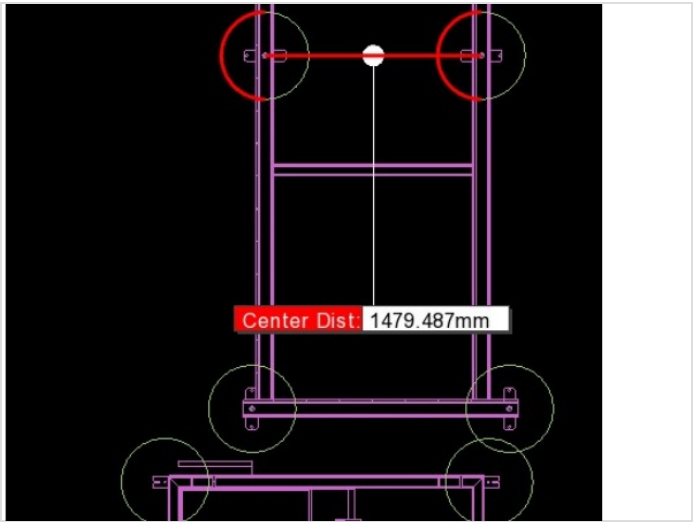
Step 4 - Prepare the floor

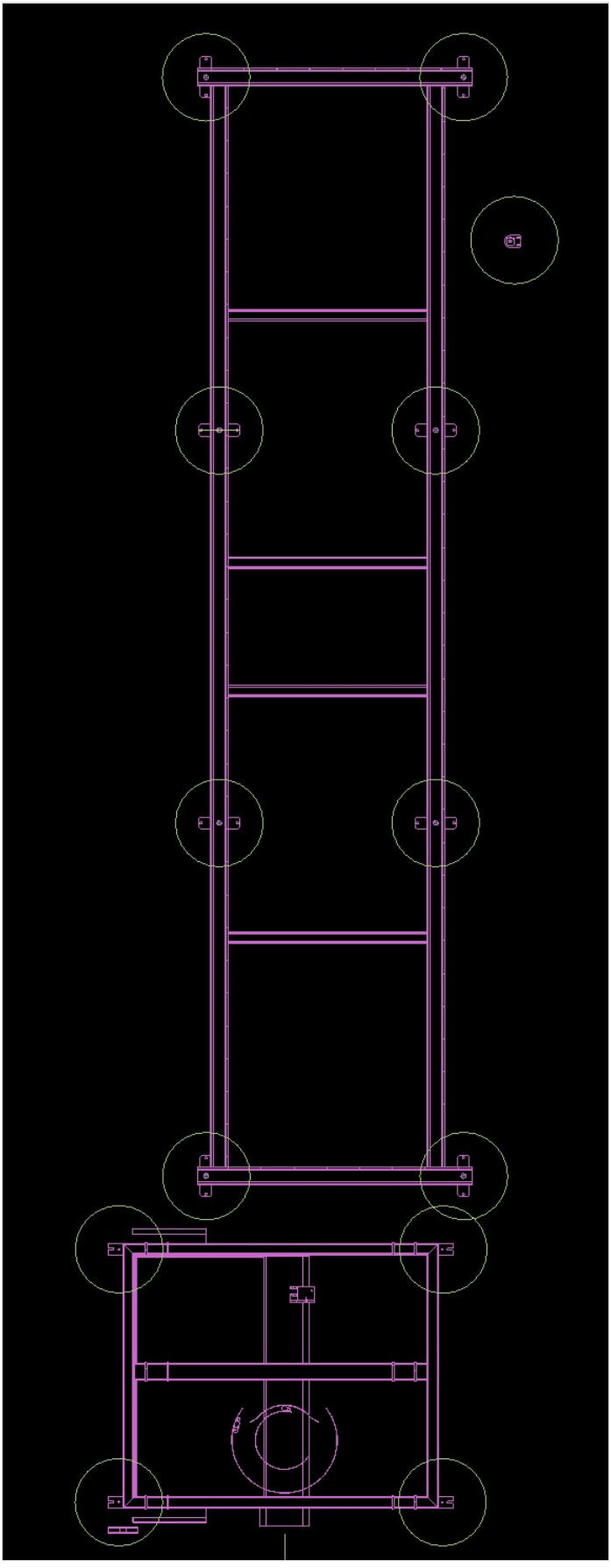
The datum points for loading have already been marked on the floor.
Using these datum points, mark the position of the remainder of the floor pads

> ...Note this may be a large quick set pad



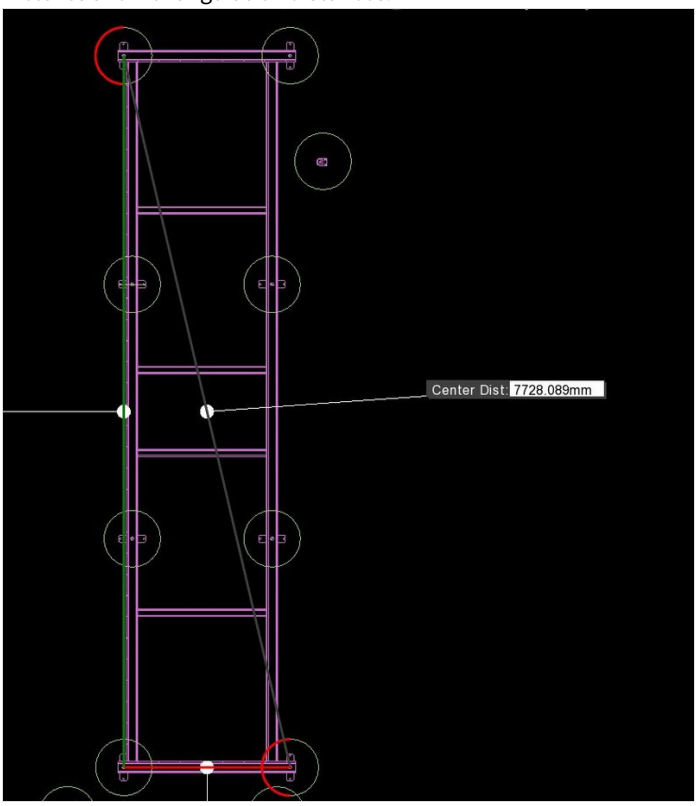


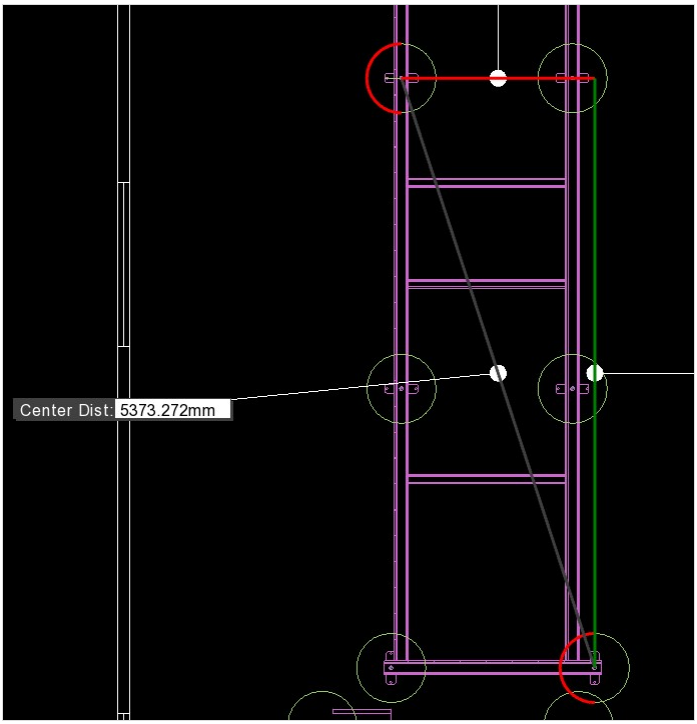

Center Dist: 1479.487mm

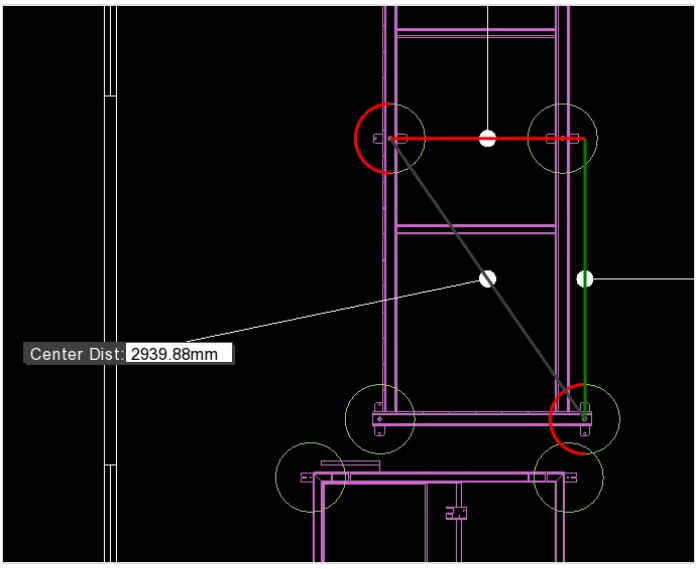


Step 5 - Triangulation for Infeed Pads

Pictures show triangulation distances.







Step 6 - Prepare the Machine Pads / Piles

Friday:

> ...Using shuttering in the pad holes will enable the height of the pad to be increased to correct the "run off" of the floor.

> ...this instruction can be ignored if a large pad is set

- Pad size 300mm x 300mm (or similar)
- Pad Depth 300-500mm
- Use shuttering or large diameter soil pipe
- Find the highest point, string a level agcross to the other pads
- Fill shuttering with quick set cement to +/- 15mm of level

> ...The machining table has levelling feet, but the run off of the current cow shed floor may prove challenging for the range of the levelling. Using the shuttering to create taller plies will solve this problem easily and inexpensively

Step 7 - Prepare transport axle

Stuga will supply a wheeled all-terrain axle
this axle is designed to form a "wheelbarrow" using the forklift as the driver / opposite end. This will enable the heavy machine units to be carefully wheeled over the rough terrain

> ...Take care to attach the axle to the load correctly and securely

Step 8 - Clear the inside area

Including the chop saw table
Leaving a clear route for the 2.4m x 7.5m table to roll in

Step 9 - Clear Outside Unloading Area

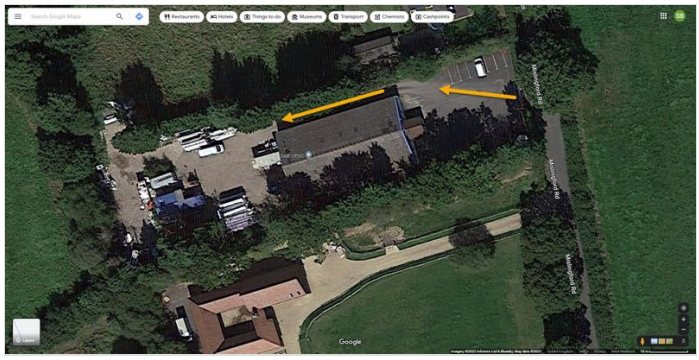
The full width of this route will need to be cleared

Step 10 - Imporvements to step into building

If possible, improve the access pathway.
Potentially find a ramp system for the step into the unit

Step 11 - Lorry to reverse along RHS of building

Monday:
Lorry to reverse along right side of building (when viewed from front)
This allow easy unloading access for forklift to unload to ground, and align components with door



Step 12 - Machining Centre

The machining centre should be unloaded first

Step 13 - Machining Centre Guard

The guard is a clam shell design that encases the machine in 2 parts from front and rear

Step 14 - Infeed Table

- Infeed should lifted to align with rear door
- Bogey on lead end
- Forlift moves to rear end
- Forklift to shunt infeed able into factory
- 2 Off pallet trucks to manouvre into position

Step 15 - Conveyor Table1

Conveyor table should attach to existing Soenen Brackets
Position of conveyor 1 adjusted to machining centre, leaving gap of 25mm
Height adjust on Soenen Brackets

Step 16 - Conveyor Table2

Conveyor table should attach to existing Soenen Brackets
Additional leg for long conveyor to support
Position of conveyor 2 adjusted to Conveyor 1, leaving gap of 10mm
Height adjust on Soenen Brackets

Step 17 - Conveyor Control Cabinets

Remove old Conveyor control back plate
Premade Backplates fit inside
Rewire as indicated in drawings