



Technical Information – 3000 Series Fabric Inspection Table

Power requirements	: 240V – 50 Hz
Safety Features	: Emergency Stop on Electrical Cabinet front end All external wiring and switches are 24V (low voltages)
Area Required	: Width : 1.6 metres + 1.0 metre either side for operating Length: 3.6 metres + 1.0 metre either side for operating
Approx Operating Speed	: At 10% Speed > 7m / min At 50% Speed > 28m / min At 100% Speed > 55m / min



OPERATION MANUAL FOR 3000 SERIES FABRIC INSPECTION TABLE



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1.0 FABRIC INSPECTION TABLE CONFIGURATIONS







Material Rollers



Electrical Cabinet



Electric Knife

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2.0 HEALTH AND SAFETY TIPS

It is very important that the Fabric Inspection Table be operated in accordance with the instructions and safety procedures outlined in this manual.

Acmeda has designed the Fabric Inspection Table with the objective of minimizing the possibility of personal injury or property damage from the proper operation of the machine. However with the nature of the table operations, there are several areas with exposed hazards, and it is the responsibility of the owner and machine operator to observe all needed precautions in the use of this machine.

✤ Fabric Loading/Unloading: For proper ergonomics, it is suggested that fabric loading and unloading should be performed by 2 people.

✤ Material Rollers: Do not place hands in between the rollers, regardless whether the machine is in operation. The rollers are driven by a powerful motor and hence safety precaution must be taken at all times.

✤ Electrical Cabinet: Open the electrical cabinet only when necessary. Touching of any wire connections may result in potential electric shock.

✤ Electric Knife (Optional Item): To cut fabric, keep hands off the cutter and run electric knife along track slowly. Always ensure the electric knife is switched off when unused.

Acmeda accepts no responsibility for personal injury or property damage due to the failure to follow all operation and safety instructions.



Emergency Stop Button on Electrical Cabinet

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3.0 EMERGENCY STOP (ES) BUTTONS

The Fabric Inspection Table is provided with Emergency Stop Button on the Main Electrical Cabinet, located at the front end of the table. If it becomes necessary to use an ES button, simply press firmly down on it. This action will abort all active operations.

Twist the Emergency Stop button until it pops back into the raised position. Start the machine again according to operation procedures as described in *4.0 - Getting Started*.



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4.0 INSTALLATION & COMMISSIONING

- 4.1 Setting Up
- 1. Lift the Fabric Inspection Table from the rear end and position it on desired position. See *Appendix A Lifting Instructions* for details.
- 2. Loop a string line on a Base Support Bar from one end to that of the other end to check if the centre Base Support Bar is levelled.
- 3. Adjust nut on the Swivel Feet as shown to raise or lower the Base Support Bar.
- 4. Use a spirit level and position it on the following locations to ensure that the table sits on a horizontal level.
 - a. On top of Front Guard Framework
 - b. On top of Rear Guard Framework
 - c. Bottom extrusions of Mid Frame
- 5. Adjust the swivel feet again to achieve horizontal level, if necessary.



Electric Foot Pedal







Power Point for

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Operating for the First Time 4.2

- 1. Remove all protective plastic wraps on the machine. Then wipe through Polycarbonate Panels with antistatic spray.
- 2. Place Electric Foot Pedal (if available) at the rear end of Fabric Inspection Table. If 2 pedals are provided, place the other on at the front end.
- 3. Plug Electric Knife (if available) socket into the power point, located on the right side of the Main Electrical Box.
- 4. Turn on the Main Power Switch and Lighting Switch.
- 5. Check if all fluorescent lights are lit.

Test Run 4.3

- 1. Keep Rollers (both front and rear) clear of fabric or any other materials during test run.
- 2. On the Control Panel, turn Speed Control Knob to 0% and press the "FWD" button.
- 3. Gradually turn the knob up to 100% and check if the 3 front rollers and rear centre roller are rotating clockwise, viewing from the left hand side of the machine.
- 4. Press the "STOP" button and turn the Speed Control Knob back to 0%.
- 5. Press the "REV" button and repeat step 3. The rollers should now be rotating anticlockwise viewing from the left hand side.
- 6. If Electromagnetic Clutch is available, there are Green and Red Buttons located on both the front and rear sides. While the front rollers are rotating, test if these buttons will engage/disengage the rear centre roller.
- 7. Test run the Electric Foot Pedal Control (if applicable) also, to ensure "FWD" pedal drives rollers clockwise and "REV" pedal drives rollers anticlockwise.



Under-roll Orientation



Lift Counter Up, Feed Through



Under-roll Orientation



Press forward to create tension

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5.0 GETTING STARTED

- 1. Place fabric roll on the Rear Roller Assembly, in an under-roll orientation as shown. Always try to centralize the roll with respect to the width of table to achieve best result.
- 2. Lift the Metering Counter up so that it is kept clear from the Polycarbonate Panels.
- 3. Feed fabric over the Slave Roller, under the Metering Counter, and under-roll an empty fabric cone on the Front Rollers Assembly.
- 4. Place down the Metering Counter and reset it to 0.
- 5. If Clutch is available, ensure that it is disengaged.
- 6. Tape the fabric end onto the empty cone properly and start the rolling and inspection process by pressing "FWD" button. ALWAYS start from the lowest speed.
- 7. It is VERY IMPORTANT to monitor the initial rolled-up result to ensure there is enough tension on the fabric. Help create more tension on the initial winding by pressing forward against the fabric roll as shown.
- If the fabric rolls up loosely, reverse (REV) the rollers. But if Clutch is available, it needs to be engaged before reversing. Note that the rewinding process is only designed to readjust the fabric roll for not more than 1m. In any case, if rewinding does not help, restart the operation.
- 9. Several situations may occur if operating procedures are not followed correctly. Refer *5.0 Troubleshooting Guide* for solutions.
- 10. Gradually turn up the Speed Control knob to complete cycle.
- 11. Alternatively, operator can use Electric Foot Pedal to control steps 5-8 above.

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6.0 TROUBLESHOOTING GUIDE

PROBLEM	POSSIBLE CAUSE / SOLUTIONS
Target roller winds up loosely	 Not enough tension on the setup. Apply brake on Slave Roller to improve result. Operating speed too fast, restart process from 0% speed, and gradually increasing to a decent speed. Disengage clutch to reduce the feeding speed of the rear fabric roll.
Coning Effect	 Front and rear fabric rolls are not lined up properly. Rewind and reposition the fabric. Too much movement on fabric roll during operation, slow down the roller speed. Tap the cone or material into position lightly.
Material rollers not moving	 Emergency Stop activated. Twist and pull up ES button.
Material cut quality is poor or material is not cutting through completely	 The cutting blade is becoming dull and needs to be replaced. The material is not pulled tight enough for cutting. Apply more tension to the setup.
Metering Counter not spinning properly	 Counter wheels are dusty with not enough friction against fabric materials. Clean up wheels. Wheels are not levelled. Loosen the tightening handle and reposition the counter.



Slave Roller Brake



Reposition Fabric / Push Cone into Position



Loosen handle to adjust position ACMEDA ENGINEERING



7.0 INVERTER PARAMETERS SETTING

A frequency inverter is installed inside the Electrical Cabinet, of which the parameters were already preset accordingly for optimum performance. Under normal operation, DO NOT change any parameters.

Following are the preset parameters for your reference:

Code No.	Acmeda Setting												
C01	0.0	C13	0.5	C24	0.0	C50	0.0	c01	5.0	c61	-	c82	0.0
C02	0.0	C14	2.0	C31	0.0	C53	103.0	c03	5.0	c62	-	c86	0.0
CE1	7.0	C15	50.0	C34	0.0	C54	0.0	c06	0.0	c63	-	c87	100.0
CE2	6.0	C16	6.0	C36	4.0	C59	16.8	c20	100.0	c70	0.0	d25	5.0
CE3	3.0	C17	0.0	C37	20.0	C70	5.0	c38	0.0	c71	0.0	d38	0.0
C08	1.0	C18	3.0	C38	30.0	C71	0.0	c40	0.0	c78	5.0	d46	0.0
C10	0.0	C21	0.0	C39	40.0	C94	0.0	c42	1.0	c79	125.0	d47	0.0
C11	50.0	C22	150.0	C46	16.7	C99	2.1	c60	0.0	c81	0.0		
C12	3.0												



Inverter inside Electrical Cabinet

APPENDIX A – Lifting Instructions



FABRIC INSPECTION TABLE - 3000 SERIES

LIFTING INSTRUCTIONS

1. Check for two 40X40 hollow tubes below the fluorescent lights as shown.

IMPORTANT

- ENSURE THE TWO TUBES ARE FASTENED IN PLACE.
- From the rear end, place forkarms underneath these extrusions, and raise the table up slowly.

IMPORTANT

- DO NOT HIT THE ELECTRICAL CABINET WHEN PLACING FORKARMS.
- CENTRALIZE FORKARMS TO ENSURE STABILITY.
- Move table to desired location and place it down slowly. Hollow tubes can be removed or be remained for future relocation.

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APPENDIX B – Inverter Parameters Setting



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Code		Possi	ble Settings	
No.	Name	Lenze	Selection	IMPORTANT
C 00	Password entry	0	0 999	Visible only when password is active (see C94)
103	Setpoint source		0 Analog input (terminal 8; see C34)	
			1 Code c40	Observe notes about c40
605	Load Lenze setting		0 No action/loading complete	C02 = 1 4 only possible with DFF
			1 Load 50 Hz Lenze settings	 C02 = 2 : C11, C15 = 60 Hz
			2 Load 60 Hz Lenze settings	
			3 Load OEM settings	
			4 Translate	
		▲	WARNING! C02 = 1 3 overwrites all settings! TRIF CE1CE3. NOTE If an EPM that contains data from a prev converts the data to the current version.	² circuitry may be disabled! Check codes rious software version is installed, C02 = 4
CE I	Configuration -	1	1 Activate fixed setpoint 1 (JOG1)	Use C37 C39 to adjust fixed setuciots
	Digital Input E1		2 Activate fixed setpoint 2 (JOG2)	 Activate JOG3: Both terminals = HIGH
			3 DC braking (DCB)	See also C36
			4 Direction of rotation	LOW = CW rotation HIGH = CCW rotation
			5 Quick stop	Controlled deceleration to standstill, active LOW; Set decel rate in C13 or c03
CE2	Configuration -	4	6 CW rotation 7 CCW rotation	CW rotation = LOW and CCW rotation = LOW: Quick stop; Open-circuit protected
	Digital Input E2		8 UP (setpoint ramp-up)	UP = LOW and DOWN = LOW: Quick
			9 DOWN (setpoint ramp-down)	stop, ose momentary NC contacts
CE3	Configuration - Digital Input E3	3	10 TRIP set	Active LOW, triggers EE P (motor coasts to standstill) NOTE: NC thermal contact from the motor can be used to trigger this input
			11 TRIP reset	See also c70
			12 Accel/decel 2	See c01 and c03
			13 Deactivate PI	Disables PI function for manual control
			14 Activate fixed PI setpoint 1	 Use C37C39 to adjust fixed setpoints Activate fixed PI setpoint 3: Both terminals = HIGH
		1	Note A CFG fault will occur under the following • E1E3 settings are duplicated (each s • One input is set to UP and another is r) conditions: setting can only be used once) not set to DOWN, or vice-versa

	•	Possi	ble Settings		IMPORTANT				
No.	Name	Lenze	Selection		IMPORTANT				
C09	Configuration - Relay output	1	Relay is energized if 0 Ready 1 Fault 2 Motor is running - CV 4 Motor is running - CV 5 Output frequency = 0 6 Frequency setpoint rr 7 Threshold (C17) exc 8 Current limit (motor 0 Gedback within min. (d46, d47) range 10 Feedback outside mi (d46, d47) range	V rotation CW rotation b Hz eached eeded or generator /max alarm n/max alarm					
כוס	Minimum output frequency	0.0	0.0 {Hz}	500	 Output frequency at 0% analog setpoint C10 not active for fixed setpoints or setpoint selection via c40 				
C ()	Maximum output frequency	50.0	7.5 {Hz}	500	 Output frequency at 100% analog setpoint C11 is never exceeded 				
		\triangle	WARNING! Consult motor/machine	manufacturer be	fore operating above rated frequency.				
			Overspeeding the motor personnel!	/machine may c	ause damage to equipment and injury to				
C (2	Acceleration time 1	5.0	Overspeeding the motor personnel! 0.0 {s}	/machine may c	e C12 = frequency change 0 HzC11 C13 = frequency change C110 Hz				
C 12	Acceleration time 1 Deceleration time 1	5.0 5.0	Overspeeding the motor personnel! 0.0 {s} 0.0 {s}	/machine may c 999 999	 C12 = frequency change 0 HzC11 C13 = frequency change 0 HzC11 C13 = frequency change C110 Hz For S-ramp accel/decel, adjust c82 				
C 12 C 13 C M	Acceleration time 1 Deceleration time 1 Operating Mode	5.0 5.0 2	Overspeeding the motor personnel! 0.0 {s} 0.0 {s} 0 Linear characteristic Auto-Boost 1 Square-law character Auto-Boost 2 Linear characteristic Vers boost	/machine may c 999 999 with eristic with with constant	 ause damage to equipment and injury to C12 = frequency change 0 HzC11 C13 = frequency change C110 Hz For S-ramp accel/decel, adjust c82 Linear characteristic: for standard applications Square-law characteristic: for fans and pumps with square-law load characteristic Auto boost: load-dependent output voltage for low-loss operation 				
C 12 C 13 C M	Acceleration time 1 Deceleration time 1 Operating Mode	5.0 5.0 2	Overspeeding the motor personnel! 0.0 {s} 0.0 {s} 0.1 (s) 0.2 Linear characteristic Auto-Boost 1 Square-law characteristic Auto-Boost 2 Linear characteristic V _{min} boost 3 Square-law charact constant V _{min} boost	/machine may c 999 999 with eristic with with constant eristic with	 ause damage to equipment and injury to C12 = frequency change 0 HzC11 C13 = frequency change C110 Hz For S-ramp accel/decel, adjust c82 Linear characteristic: for standard applications Square-law characteristic: for fans and pumps with square-law load characteristic Auto boost: load-dependent output voltage for low-loss operation 				
C 12 C 13 C 14	Acceleration time 1 Deceleration time 1 Operating Mode	5.0 5.0 2 50.0	Overspeeding the motor personnel! 0.0 {s} 0.0 {s} 0 Linear characteristic Auto-Boost 1 Square-law characteristic Vauto-Boost 2 Linear characteristic Vauto-Boost 3 Square-law characteristic Vmin boost 3 Square-law characteristic Vmin boost 25.0 {Hz} Set the rated motor freq (nameplate) for standard	/machine may c 999 999 e with eristic with eristic with eristic with 999 uency d applications	ause damage to equipment and injury to • C12 = frequency change 0 HzC11 • C13 = frequency change C110 Hz • For S-ramp accel/decel, adjust c82 • Linear characteristic: for standard applications • Square-law characteristic: for fans and pumps with square-law load characteristic • Auto boost: load-dependent output voltage for low-loss operation				
С (2 С (3 С (7 С (75 С (75)	Acceleration time 1 Deceleration time 1 Operating Mode V/f reference point V/min boost (optimization of torque behavior)	5.0 5.0 2 50.0 6.0	Overspeeding the motor personnel! 0.0 {s} 0.0 {s} 0 Linear characteristic Auto-Boost 1 Square-law characteristic Vmin boost 2 Linear characteristic Vmin boost 3 Square-law characteristic constant Vmin boost 25.0 {Hz} Set the rated motor frequering (nameplate) for standard for should run at slip (approx. 5 Hz), increase motor current (C54) = 0.	/machine may c 999 999 with eristic with eristic with 999 uency d applications 40.0 g: The unloaded frequency C16 until 8 x rated motor	 ause damage to equipment and injury to C12 = frequency change 0 HzC11 C13 = frequency change C110 Hz For S-ramp accel/decel, adjust c82 Linear characteristic: for standard applications Square-law characteristic: for fans and pumps with square-law load characteristic Auto boost: load-dependent output voltage for low-loss operation 				

APPENDIX B – Inverter Parameters Setting

Code Possible Settings

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						IMPORTANT
No.	Name	Lenze	Selection			
C 18	Chopper frequency	2	0 4 kHz			 As chopper frequency is increased, motor paise is decreased.
			1 6 kHz			Observe derating in Section 2.2
			2 8 kHz			 Automatic derating to 4 kHz at 1.2 xIr
			3 10 kHz			
C2 I	Slip compensation	0.0	0.0	{%}	40.0	Change C21 until the motor speed no longer changes between no load and maximum load
C55	Current limit	150	30 Reference: sm	{%} d rated output cu	150 urrent	 When the limit value is reached, either the acceleration time increases or the output frequency decreases
C24	Accel boost	0.0	0.0	{%}	20.0	Accel boost is only active during acceleration
C3 (Analog input dead band	0	0 Enabled 1 Disabled			C31 = 0 activates dead band for analog input. When analog signal is within dead band, controller's output = 0.0 Hz and display will read 5LP
C.34	Configuration -	0	0 010 V			
	analog input		1 05 V			
			2 020 mA			
			3 420 mA			
			4 420 mA	monitored		Will trigger 5d5 fault if signal falls below 2 mA
C36	Voltage - DC injection brake (DCB)	4.0	0.0	{%}	50.0	 See CE1CE3 and c06 Confirm motor suitability for use with DC braking
ទោ	Fixed setpoint 1 (JOG 1)	20.0	0.0	{Hz}	999	When PI is active (see d38), C37C39 are fixed PI setpoints
C 38	Fixed setpoint 2 (JOG 2)	30.0	0.0	{Hz}	999	
C 39	Fixed setpoint 3 (JOG 3)	40.0	0.0	{Hz}	999	
648	Frequency setpoint		0.0	{Hz}	500	Display: Setpoint via analog input, function UP/DOWN
C50	Output frequency		0.0	{Hz}	500	Display
[53	DC bus voltage		0.0	{%}	255	Display
654	Motor current		0.0	{%}	255	Display
C59	PI feedback		c86	{%}	c87	Display
מרס	Proportional gain	5.0	0.0	{%}	99.9	
[[]]	Integral gain	0.0	0.0	{s}	99.9	
C94	User password	0	0 Changing from will start at 763	"0" (no passwor	999 d), value	When set to a value other than 0, must enter password at C00 to access parameters
F99	Software version					Display, format: x.yz

Code		Possi	ble Settings		IMPORTANT
No.	Name	Lenze	Selection		IMPORTANT
eØ (Acceleration time 2	5.0	0.0 {s}	999	 Activated using CE1CE3 c01 = frequency change 0 HzC11
e03	Deceleration time 2	5.0	0.0 {s}	999	 c03 = frequency change C110 Hz For S-ramp accel/decel, adjust c82
c06	Holding time - automatic DC injection brake (Auto-DCB)	0.0	0.0 {s} 0.0 = not active 999 = continuous brake	999	 Automatic motor braking below 0.1 Hz by means of motor DC current for the entire holding time (afterwards: U, V, W inhibited) Confirm motor suitability for use with DC braking
c2D	I ^a t switch-off (thermal motor monitoring)	100	30 {%} 100% = <i>smd</i> rated output curre	100 nt	 Triggers DC5 fault when motor current exceeds c20 for too long c20 = motor current rating x 100 smd output rating Example: if motor = 6.4amps and smd = 7.0amps, then c20 = 91%
		⚠	WARNING! Maximum setting is rated motor motor protection!	current ((see nameplate). Does not provide full
c30	Actual PI setpoint		c86	c87	Display
c40	Frequency setpoint via keys	0.0	0.0 {Hz}	500	Only active if C01 = 1
e42	Start condition (with mains on)	1	0 Start after LOW-HIGH char terminal 28	nge at	See also c70
			WARNING! Automatic starting/restarting ma personnell Automatic starting/r inaccessible to personnel.	ay cause estarting	damage to equipment and/or injury to should only be used on equipment that is
c60	Mode selection for c61	0	0 Monitoring only		$c60 = 1$ allows the keys \bigcirc to adjust speed setpoint (c40) while monitoring
_			i wonitoring and editing		c61
c6 /	Present status/error	-	status/error message		 Display Befer to Section 5 for explanation of
c82 c83	Last error Last error but one		error message		status and error messages
e70	Configuration TRIP reset (error reset)	0	0 TRIP reset after LOW-HIGH change at terminal 28, main switching, or after LOW-HIC change at digital input "TRI	H ns GH P reset"	
			1 Auto-TRIP reset		 Auto-TRIP reset after the time set in c71 More than 8 errors in 10 minutes will trigger r5£ fault
			WARNING! Automatic starting/restarting ma personnel! Automatic starting/r inaccessible to personnel.	ay cause estarting	damage to equipment and/or injury to should only be used on equipment that is

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APPENDIX - B



Code		Possi	ble Settings		IMPORTANT			
No.	Name	Lenze	Selection			IMPORTANT		
e7 I	Auto-TRIP reset delay	0.0	0.0	{s}	60.0	See c70		
e78	Operating time counter		Display Total time in stat	us "Start"		0999 h: format xxx 10009999 h: format x.xx (x1000)		
c79	Mains connection time counter		Display Total time of mai	ins = on		1000099999 h: format xx.x (x1000)		
e8 I	PI setpoint	0.0	c86		c87			
c82	S-ramp integration time	0.0	0.0	{s}	50.0	 c82 = 0.0: Linear accel/decel ramp c82 > 0.0: Adjusts S-ramp curve for smoother ramp 		
c85	Minimum feedback	0.0	0.0		999	 Select feedback signal at C34 		
e₿∏	Maximum feedback	100	0.0		999	 If feedback is reverse-acting, set c86>c87 		
425	PI setpoint accel/ decel	5.0	0.0	{s}	999	Sets rate of change for PI setpoint		
438	PI mode	0	0 PI disabled					
			1 PI enabled:	normal-acting		When feedback (terminal 8) exceeds setpoint, speed decreases		
			2 PI enabled:	reverse-acting		When feedback (terminal 8) exceeds setpoint, speed increases		
dHS	Feedback minimum alarm	0.0	0.0		999			
ън	Feedback maximum alarm	0.0	0.0		999	See C08, selections 9 and 10		

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			REVISIONS					
APPENDIX - C		REV.		DESCRIPTION		DATE	Di	RAWN
		A	ADD T-SLO	OT NUTS TO ASSEMBLY, MISSED	OUT PREVIOUSLY.	14/01/2010	0	G. HII
<image/>			TM93-	-0000-002618	ITEM T-SLO	T NUT 8 M8	3	6
	F	3	TM92-	SHCS-0M8040	M8 X 4			6
		2	TM10-	-3000-512000	BODY FRAM	SSEMBLY	Y	3
	F	ITEM NC	D. P.	ART NUMBER	DESCI	RIPTION		QTY.
	DETAILS DATE		1 Ľ	TITLE: MAIN FRAM	E ASSEMBLY			
3	DRAWN: GERRY HII 14/01/2010		t [PART NUMBER:	ТМ10-3000-51000	0		
	CHECKED:			DRAWING NUMBER	R: TM10-3000	-510000-A		FR ANGES
DETAIL A	APPROVED:	ACM		MATERIAL: N/A			SENERAL TO OR SIZES AND	GEOMETRY
SCALE 1:5	SAMPLE:	ENG	INEERING	FINISH: N/A			0.5-2000 = ISO > 2000 = ISO	0 2768 fH
	DIE NO:			COLOUR	UNSPECIFIED RADIU	JS: 0.5mm	-2000 - 130	2700 1111
	PROPRIETARY & CONFIDENTIAL THE INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PRO	PERTY OF ACM	MEDA	WEIGHT:	DO NOT SCA	ALE (UNLESS OTHERW	SE SPECIFIED)
	AUSTRALIA. ANY REPRODUCTION IN PART OR WHOLE WITHOUT TH PERMISSION OF ACMEDA AUSTRALIA IS PROHIBITED.	IE WRITTEN		C COPYRIGHT 2006	DIMENSIONS IN M (UNLESS OTHERWISE	SPECIFIED)	SCALE: 1:50 Sheet 1 OF 1	SIZE: A3 REV. : A

					REVISIONS								
	APP	ENDIX - C		F	EV.	DESCRIPTION		DATE	C	RAWN			
				2	A THIS - SHO	FT CAP 8 FOR LIGHTING AND P ASSY LEVEL. DW MOUNTING DETAILS OF FLU	erspex frames to Joro lights.	29/03/20	010	G. HII			
EUCH TO REACE RAR						KEEP	RIGHT PLANE A A	VIEW ND B PARALLE					
FLUSH TO BRAC	CE BAR	80		80	5	DETAIL A SCALE 1 : 5 TM93-0000-002601 TM10-3000-523000	CAP 8 40X40 NYLON SUPPO	ORT ASSEME	BLY	6			
A CONTRACT					3	TM10-3000-521000	LIGHTING FRA	AME ASSEM	BLY	1			
			TAIL B	y	2	TM10-3000-522000	PERSPEX FRAM		LY	1			
		,,											
	DFT	Alls	DATE:	<u> </u>	TITLE	LIGHTING & PERSPEX FRAI	ME ASSEMBLY			Qrii.			
	DRAWN:		10/11/2008			NIIMBER: TM10-3000-520	000						
	CHECKED:			T	DRAW	ING NUMBER: TM10-30	00-520000-A		GENERAL TO	LERANCES:			
					RIAL: N/A			For sizes and	geometry				
				FINISH:	N/A			>2000 = ISO	2768 m H.				
	DIE NO:				COLOI	JR: N/A	UNSPECIFIED RADIL	JS: 0.5mm	(UNLESS OTHERW	SE SPECIFIED)			
	PROPRIETARY & C	CONFIDENTIAL	DRAWING IS THE		WEIGH	Γ:	DO NOT SCALE		SCALE: 1:50	SIZE: A4			
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APPENDIX - C SPROCKET ARRANGEMENT FOR STANDARD SETUP SPROCKET ARRANGEMENT FOR CLUTCH SETUP APPROXIMATE LOCATIONS OF FRAME SUPPORT BRACKET ADJUST AT FINAL ASSEMBLY 0 21 TM93-0000-002618 ITEM T-SLOT NUT 8 M8 0 20 TM92-SHCS-0M8016 M8 X 16 SHCS 19 TM92-SHCS-0M6016 M6 X 16 SHCS 18 TM91-3000-535000 FRAME SUPPORT BRACKET TM93-0000-041940 17 ITEM T-SLOT NUT 6 St M6: 0.0.419.40 33 0 592 3192 16 TM92-BHZP-0M6012 M6 X 12 BUTTON HEAD CAP SCREW ZP 15 TM92-FTWS-0000M6 M6 FLAT WASHER 14 TM94-3000-248265 ROLLERS CHAIN DRIVE /W CUTOUT 13 3/8 SIMPLEX CHAIN - 06B1 TM93-3800-000006 12 TM92-GRUB-0M6008 M6 X 8 GRUB SCREWS 11 TM93-9028-007002 CHAIN SPROCKET WITH 6MM KEYWAY 10 TM92-MTNT-0000M8 M8 HEX NUT 9 TM92-SHCS-0M8035 M8 X 35 SHCS 8 TM92-FTWS-0000M8 M8 FLAT WASHER 7 TM10-3000-533000 MOTOR SHAFT ASSEMBLY 6 TM10-3000-534000 MOTOR & GEARBOX ASSEMBLY 5 TM10-3000-532000 ROLLER ASSEMBLY FOR 2 SPROCKETS 4 TM10-3000-531000 ROLLER ASSEMBLY FOR 1 SPROCKET 3 TM10-9014-245263 ROLLERS MOUNTING ASSEMBLY - MOTOR END MOTORISED ROLLERS MOUNTING PLATE ASSEMBLY 2 TM10-9014-245262 OPP END 1 TM91-4200-LB7077 ROLLER MOUNTING FRAME ITEM NO. PART NUMBER DESCRIPTION DETAILS DATE TITLE: MOTORISED FRONT ROLLERS DRAWN: TM10-3000-530000 Gerry Hii 22/01/2010 PART NUMBER: DRAWING NUMBER: CHECKED: TM10-3000-530000-A GENERAL TOLERANCES: MATERIAL: N/A APPROVED: FOR SIZES AND GEOMETRY ACMEDA FINISH: N/A SAMPLE: 0.5-2000 = ISO 2768 fH ENGINEERING COLOUR: /A >2000 = ISO 2768 mH **UNSPECIFIED RADIUS: 0.5mm** DIE NO: (UNLESS OTHERWISE SPECIFIED) WEIGHT: DO NOT SCALE **PROPRIETARY & CONFIDENTIAL** THE INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF ACMEDA SCALE: 1:20 AUSTRALIA. ANY REPRODUCTION IN PART OR WHOLE WITHOUT THE WRITTEN PERMISSION OF ACMEDA AUSTRALIA IS PROHIBITED. DIMENSIONS IN MILLIMETERS C COPYRIGHT 2006

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SIZE: A3

REV. : A

Sheet 2 OF 2

(UNLESS OTHERWISE SPECIFIED)

\bigcirc		REVISIONS								
		PENDIX - C		REV.	I	DESCRIPTION		DATE	Di	RAWN
				A	ADD M8 SHCS A	ND T-SLOT NUTS TO	O ASSEMBLY	21/01/2010	0	G. HII
e de la construcción de la const							6	3		
		Г	12	TM92 0000	002/18	ITEM		148		4
		F	12	TM10-3000	-547000	CHAIN		MRLY		1
		F	11	TM92-SHC	S-0M8030	Criv di	M8 X 30 SHCS			4
		F	10	TM92-SHC	S-0M6030		M6 X 30 SHCS			8
		F	9	TM92-CTSK	-0M8020	M8 X	20 COUNTERS	UNK		8
		F	8	TM92-GRU	B-0M6008	M6	X 8 GRUB SCRE	WS		1
		F	7	TM93-9028	-007002	CHAIN SPRC	OCKET WITH 6M	M KEYWA	Y	1
		F	6	TM91-3000	-546000	TIG	HTENING BLOC	CK		4
			5	TM10-3000	-544000	ROUNE	O CONNECTING	ROD		2
			4	TM10-3000	-545000	SQUAR	E CONNECTING	G ROD		1
			3	TM10-3000	-543000	REAR ROLLE	ERS MOUNTING	ASSEMBL	Y	2
			2	TM10-3000	-541000	CENTR	RE ROLLER ASSE	MBLY		1
			1	TM10-3000	-542000	FREE SPIN	NING ROLLER A	SSEMBLY		2
			ITEM NO.	PART N	UMBER		DESCRIPTION		(QTY.
	DETAILS	DATE	6 -	-1	TITLE: RE	AR ROLLERS N	MAIN ASSEMBLY			
	DRAWN: GERRY H	III 31/10/2008	LALA		PART NUM	BER: TM1	10-3000-540000			
	CHECKED:				DRAWING I	NUMBER:	TM10-3000-54	0000-A		
	APPROVED:		A		MATERIAL:	N/A		GE	NERAL TOL	GEOMETRY
	SAMPLE:				FINISH: N	/A		0.	5-2000 = IS	O 2768 fH
	DIE NO:				COLOUR:	N/A UN	SPECIFIED RADIUS: 0).5mm >	2000 = ISO	2768 mH
	PROPRIETARY & CONFIDENTIAL	L			WEIGHT:		DO NOT SCALE	(UN	LESS OTHERWI	ISE SPECIFIED)
	THE INFORMATION CONTAINED AUSTRALIA. ANY REPRODUCTIO PERMISSION OF ACMEDA AUST	D IN THIS DRAWING IS THE ON IN PART OR WHOLE W IRALIA IS PROHIBITED.	E SOLE PROPERTY OF	ACMEDA EN	C COPYRIGE	HT 2006 DI	IMENSIONS IN MILLI (UNLESS OTHERWISE SPE	METERS CIFIED) Sh	ALE: 1:50 eet 1 OF 1	SIZE: A3 REV. : A

APPENDIX - C									
Image: Constrained state stat									
			Ļ	7	TM92-SHC	S-0M8035	M8 X 35 SHCS		2
(4)			F	0	TM91 2000	555000			2
			F	 	TM10-3000-	554000	BRAKE ASSEMBLY		2
			F	3	TM10-3000-	55200R	LAVE ROLLER BRACKET AS	Y - RH	1
(3)			F	2	TM10-3000-	55200L	LAVE ROLLER BRACKET AS	SY - LH	1
A C			F	1	TM10-3000-	551000	SLAVE ROLLER ASSEMB	Y	1
				ITEM NO.	PART N	IUMBER	DESCRIPTION		QTY.
	DETA	LS	DATE	ф. г	_	TITLE: SLAVE R	OLLER WITH BRAKE		
	DRAWN:	Gerry Hii	30/10/2008	L W L	\square	PART NUMBER:	TM10-3000-550000		
	CHECKED:					DRAWING NUM	BER: TM10-3000-550000-0	GENERAL T	DI ERANCES
	APPROVED:				CMEDA			FOR SIZES AN	D GEOMETRY
	DIE NO:			$\mathbf{\nabla}$	ENGINEERING		LINSPECIEIED RADIUS: 0.5mm	>2000 = IS	0 2768 fH
						WEIGHT:	DO NOT SCALE	(UNLESS OTHER	WISE SPECIFIED)
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DETAILS DATE:		DATE:		TITLE: OPERATING CONTROL PANEL						
DRAWN:	Gerry Hii	11/11/2008	$ \Psi = \neg$							
CHECKED:				DRAWING NUMBER: TM10-30	00-560000-1	GENERAL TOLERANCES:				
APPROVED:				MATERIAL: N/A		0.5-2000 = ISO 2768 fH				
SAMPLE:				FINISH: N/A	>2000 = ISO 2768 m H.					
DIE NO:				COLOUR: N/A UNSPECIFIED RADIUS: 0.5mm		UNLESS OTHERWI	SE SPECIFIED)			
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			REVISIONS								
APPENDIX - C				. DESCRIPTION	E D	RAWN					
			1	REMOVE CABINET MOUNTING F MOVED TO BASE FRAME ASSY	RAME FROM ASSY, IM10-3000-511000 24/02/2	010	G. HII				
			4	TM93-0000-002618	ITEM T-SLOT NUT	8 M8	4				
			3	TM92-FTWS-0000M8	M8 FLAT WASH	ER	4				
			2	TM92-SHCS-0M8016	M8 X 16 SHC	S	4				
			1	N/A	SUPPLIED ELECTRICAL	CABINET	1				
			TEM NO.	PART NUMBER	DESCRIPTION	1	QTY.				
DETAILS	DATE:		-1	TITLE: ELECTRICAL CABINET WITH	H MOUNTING FRAME						
DRAWN: Gerry Hii	11/11/2008	Ψ'		PART NUMBER: TM10-3000-570	0000						
CHECKED:				DRAWING NUMBER: TM10-30	00-570000-1	GENERAL TOL	ERANCES:				
				MATERIAL: N/A		- For sizes and 0.5-2000 = IS	geometry O 2768 fH				
SAMPLE:			SINEERING	FINISH: N/A		>2000 = ISO 2	2768 m H.				
DIE NO:				COLOUR: N/A	UNSPECIFIED RADIUS: 0.5mm		SE SPECIFIED)				
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		APPENDIX	(- C								
(4) (2)											
			1//		5	TM92-FTWS-0000M6	M6 FLAT WASHER		1		
					4	TM92-SHCS-0M6030	M6 X 30 SHCS		1		
	3				3	TM91-3000-590000	METERING COUNTER		1		
	\bigcirc				2	TM91-3000-592000	EXTENSION SHAFT, 135.7	MM	1		
					1	TM10-3000-591000	COUNTER BRACKET ASSE/	MBLY	1		
				ITEN	ΛNO.	PART NUMBER	DESCRIPTION		QTY.		
	DET	AILS	DATE:		$ \rightarrow $	TITLE: METERING COUNTER /W H	IOLDING BRACKET ASSEMBLY				
	DRAWN:	Gerry Hii	21/11/2008	Ψ.		PART NUMBER: TM10-3000-590000					
	CHECKED:					DRAWING NUMBER: TM10-30	GENERAL TOLERANCES:				
	APPROVED: SAMPLE:			MEDA GINEERING	MATERIAL: N/A	0.5-2000 = IS	0 2768 fH				
			-		FINISH: N/A >2000 = ISO 276						
	DIE NO:					COLOUR: N/A	UNSPECIFIED RADIUS: 0.5mm	S: 0.5mm (UNLESS OTHERWISE			
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						REVISIONS							
					REV.			DESCRIPTION	DATE	DRAWN			
					Α		ADD COMMENT	17/03/2010	G. HII				
						В	CHANGE FR	OM USING STD FASTENING SET 8	29/04/2010	G. HII			
RIGHT VIEW	5	$-1(+0.5) \\ 0$		2 NOTE: FIT ASSEM	BLY TO FROM		4 4 7 6 DF MAIN FR	DETAIL A AME (TM10-3000-510000)	27/04/2010	G. HII			
					8	TM92-B	H00-0M8016	M8 X 16 BUTTON HEAD CAP S	CREW	5			
					7	TM92-F	TWS-0000M8	M8 FLAT WASHER		5			
					6	TM93-0	000-002618	ITEM T-SLOT NUT 8 M8	-	5			
					5	TM10-3	000-623000	ANGLE BRACKET - HANDKNIFE		5			
	DETAIL B				4	TM93-0	000-002623	T-SLOT NUT 8 ST M6		5			
					3	1M92-C	CISK-0M6012	COUNTER SINK CAP SCREW N	16 X 12	5			
					2	TM91-3	000-622000	HAND KNIFE CUTTING EDGE -	3240MM	1			
						11V171-3							
	DET	AILS	DATE:	$\triangle \square$	TITLE: HAND	KNIFE C	CUTTING SET	UP ASSEMBLY	•	di.			
	DRAWN:	GERRY HII	5/11/2008	\mathbb{A}	PART NUME	BER: TM	110-3000-620	000					
	CHECKED:				DRAWING N	UMBE	R: <i>TM10-300</i>	00-620000-В	GENERAL TO	LERANCES:			
				MATERIAL:	N/A			0.5-2000 = IS	0 2768 fH				
	SAMPLE:			-	FINISH: N/A				>2000 = ISO	2768 m H.			
	DIE NO:				COLOUR: N/	A		UNSPECIFIED RADIUS: 0.5mm	(UNLESS OTHERWI	SE SPECIFIED)			
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Apdx D





Apdx D

RISK ASSESSMENT FOR FABRIC INSPECTION TABLE (3000 SERIES)										
ltem No	Description	Code	Highest Risk Value	Risk Rank	Comments					
1	Main Frame Assembly	TM10-3000-510000	8	Low	Complies with Standard					
2	Fluoro Frame Assembly	TM10-3000-521000	4	Low	Complies with Standard					
3	Perspex Frame Assembly	TM10-3000-522000	12	Medium	Complies with Standard					
4	Fluoroscent Lights	TM94-3000-FL1200	16	Medium	Complies with Standard					
5	Motorised Front Rollers	TM10-3000-530000	8	Low	Complies with Standard					
6	Motor Assembly	TM10-3000-534000	16	Medium	Complies with Standard					
7	Rear Rollers Assembly	TM10-3000-540000	8	Low	Complies with Standard					
8	Chain Guard Assembly	TM10-3000-547000	4	Low	Complies with Standard					
9	Slave Roller Assembly	TM10-3000-550000	8	Low	Complies with Standard					
10	Control Panel Assembly	TM10-3000-560000	4	Low	Complies with Standard					
11	Electrical Cabinet	TM10-3000-570000	24	High	Complies with Standard					
12	Power On/Off Switch	N/A	8	Low	Complies with Standard					
13	Lighting On/Off Switch	N/A	8	Low	Complies with Standard					
14	Emergency Stop	N/A	8	Low	Complies with Standard					
15	Frequency Inverter	1	16	Medium	Complies with Standard					
16	Electrical Wiring & Cables	N/A	16	Medium	Complies with Standard					
17	Electric Knife Cutting Setup	TM10-3000-580000	16	Medium	Complies with Standard					
18	Electric Knife Socket Switch	N/A	8	Low	Complies with Standard					
19	Metering Counter	TM10-3000-590000	2	Low	Complies with Standard					
20	Hand Knife Cutting Setup	TM10-3000-620000	6	Low	Complies with Standard					
21	Foot Pedal Control	TM10-3000-610000	16	Medium	Complies with Standard					