

STAMPING - THERMOFORMING LINE

automotive decorative parts

This line is designed for the thermoforming of sandwich material, textiles and thermoplastics. A frame, with spikes mounted on a rail, crosses the three machine stations of the production line. The frame is used for the material transfer.

This transfer between the stations is manually actuated. Three frames are permanently installed in the machine, and allow a continuous running.

The material heating

The operator manually transfers the frame under the infrared heating device. During this working cycle step, the material is heated between two panels, regulated on 72 zones. An extractor, integrated in this station, extracts outward the generated smokes.

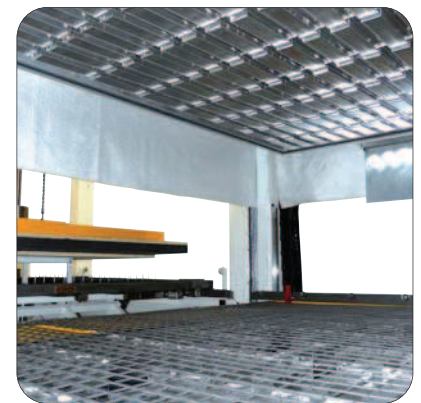
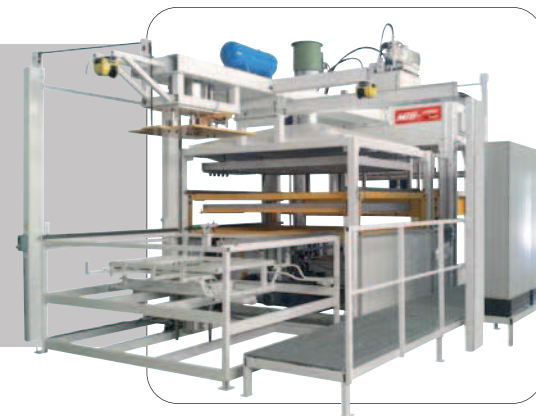
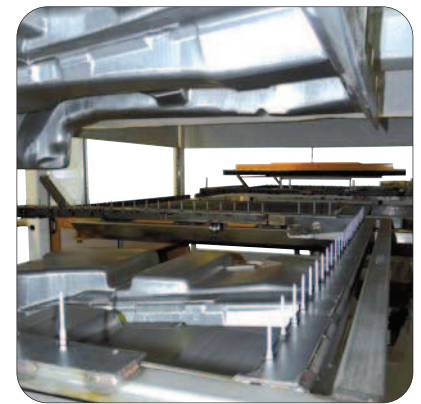
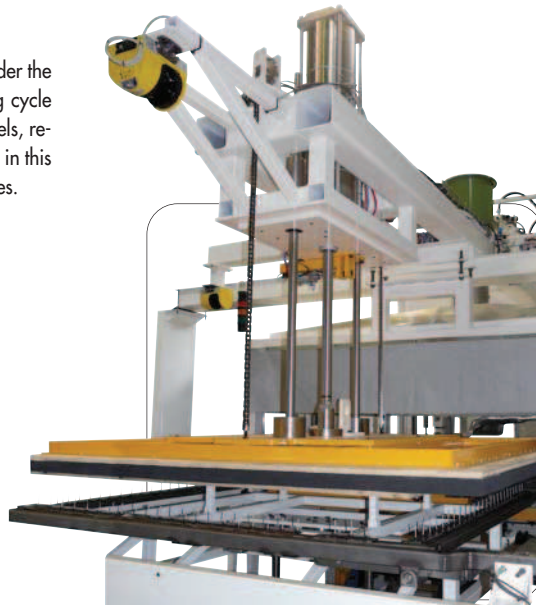
Forming and cooling

On the last working zone, the heated material is thermoformed under the press between the two moulds shapes, which are watercooled.

This production process with transfer, material infra-red heating device and thermoforming is well-know and often used on composite industry.

CHARACTERISTICS

- Closing force 50 tons
- Clearance : 1 400 mm.
- Closing speed : 200 mm/s.
- Output : 90 sec per part t.
- Part t dimensions : 2500x1800x400 mm.
- 72 heating zones with 200 kW
- 2 I.R. heating panels (up/down).



- 1 - Material loading/finish part unloading area
- 2 - Material frame hooking
- 3 - Infra red furnace
- 4 - Forming press

