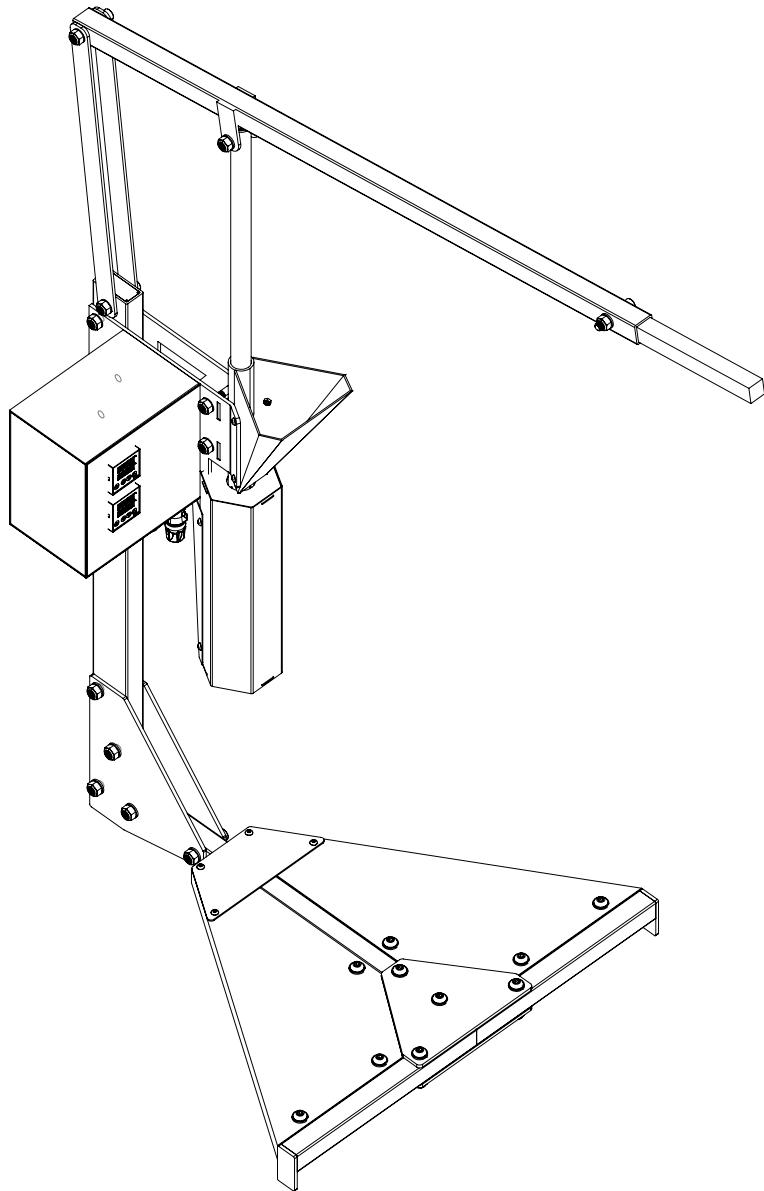




Injection Machine Assembly Guide



Prepare your tools and materials for the assembly of your Injection machine. For this you'll need all the parts you'll find in your kit. Also look for a box that says "Injection Machine fixings"

To assemble everything together you'll need the following tools:

- 17 mm spanner or adjustable spanner
- 8 mm Spanner or adjustable spanner
- Allen key set

Let's start with the base!

This is the part of the machine that prevents it from tipping over when pulling the lever.

To assemble this part you'll need the following fixings:

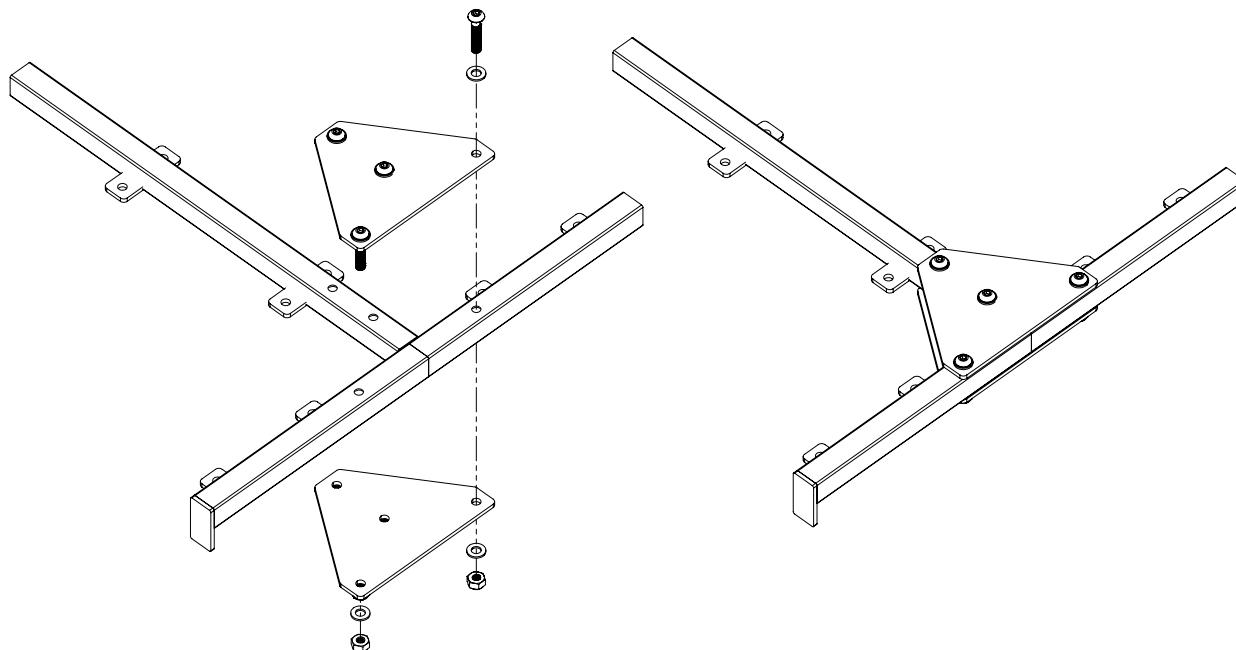
- 4x M10 60 mm Button head bolts

- 8x M10 washers

- 4x M10 nuts

Now put together the parts to create a "sandwich" like you can see on the diagram.

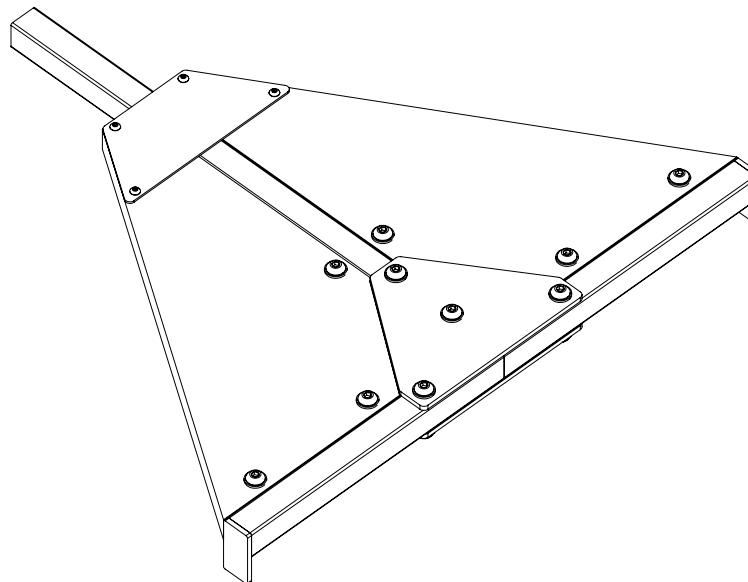
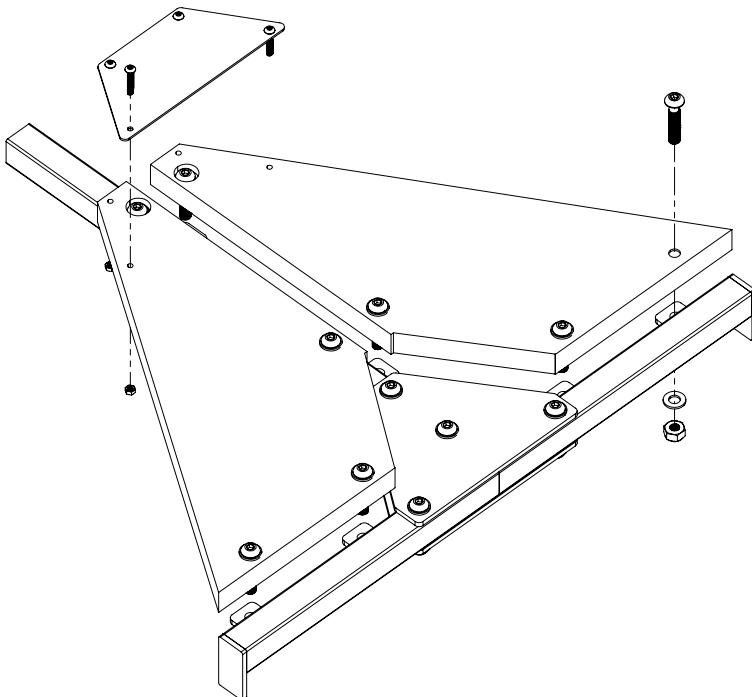
Remember! The order for bolting is: Bolt, washer, plate, tube, plate, washer, nut.

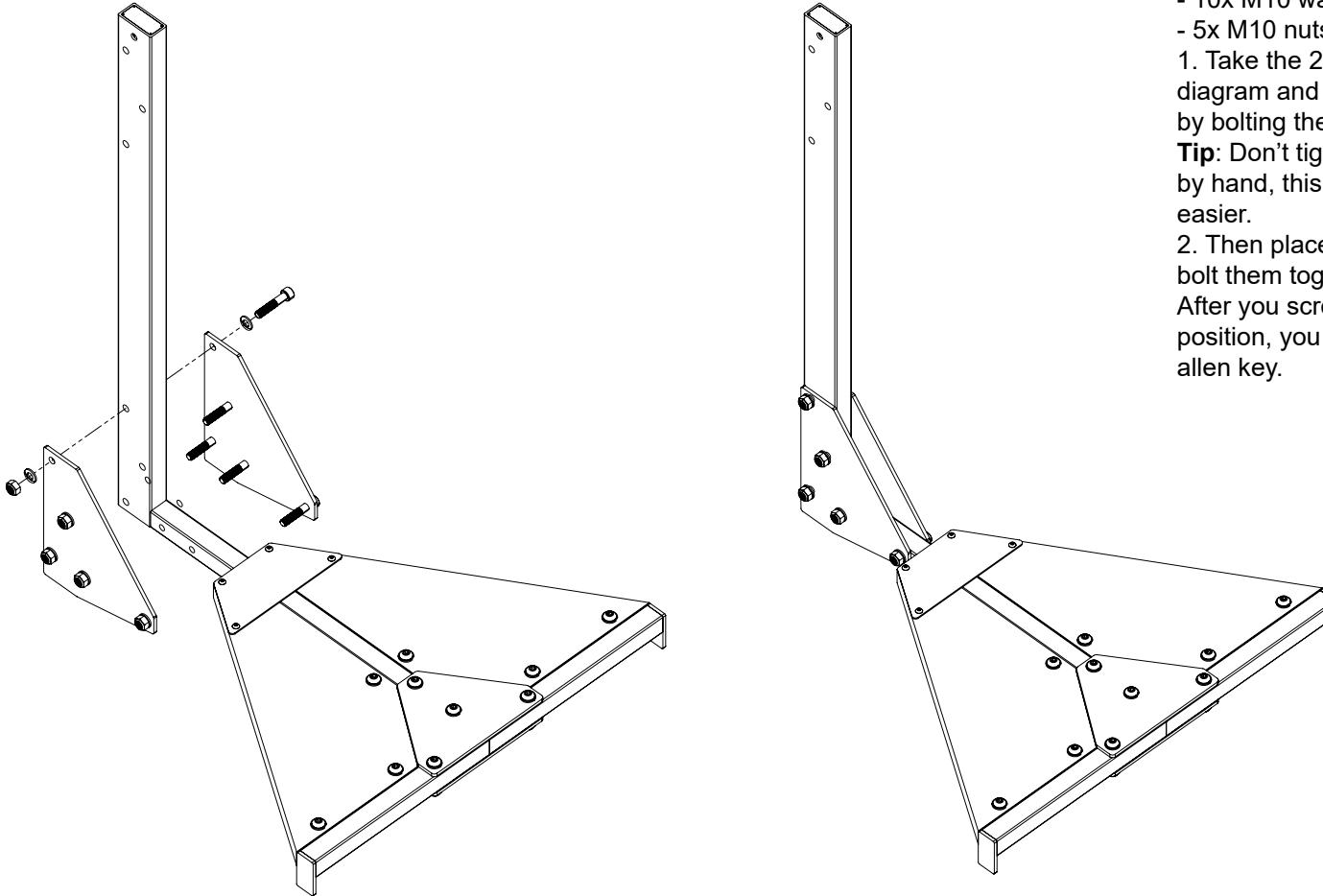


1. Now is time to attach the wood to the base. In your kit you'll find 2 pieces of wood, each of them have a message written that indicates what side faces down. Make sure you read this message before attaching the wood to the base.

2. You'll need x4 M10 button head 30 mm bolts and x4 M10 nuts and washer per side.

The order is: Bolt, wood, metal wood holder, washer, nut.





Now we need to bolt together the connectors that are going to fix the base to the vertical beam (30x60 mm). To assemble this part you'll need the following fixings:

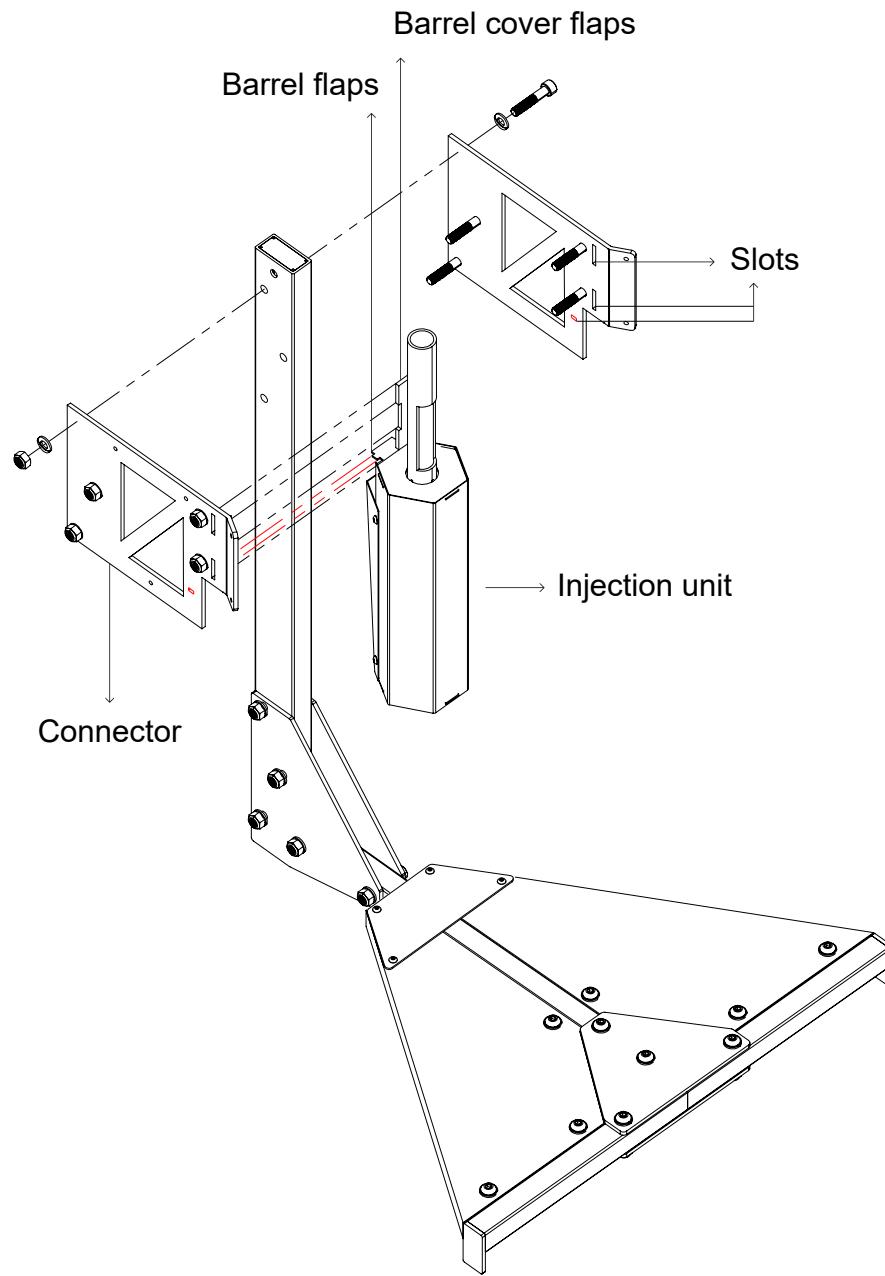
- 5x M10 60 mm Allen head bolts
- 10x M10 washers
- 5x M10 nuts

1. Take the 2 connectors that you can see on the diagram and place them parallel to each other, start by bolting them to the base first.

Tip: Don't tighten the bolts very hard at this point, just by hand, this will allow you to place the 30x60 beam easier.

2. Then place the 30x60 beam between the plates and bolt them together.

After you screw all the bolts in their corresponding position, you can tighten them all with a spanner and allen key.



Time to prepare the injection barrel to connect it to the rest of the frame.

To assemble this part you'll need the following fixings:

- 5x M10 60 mm Allen head bolts

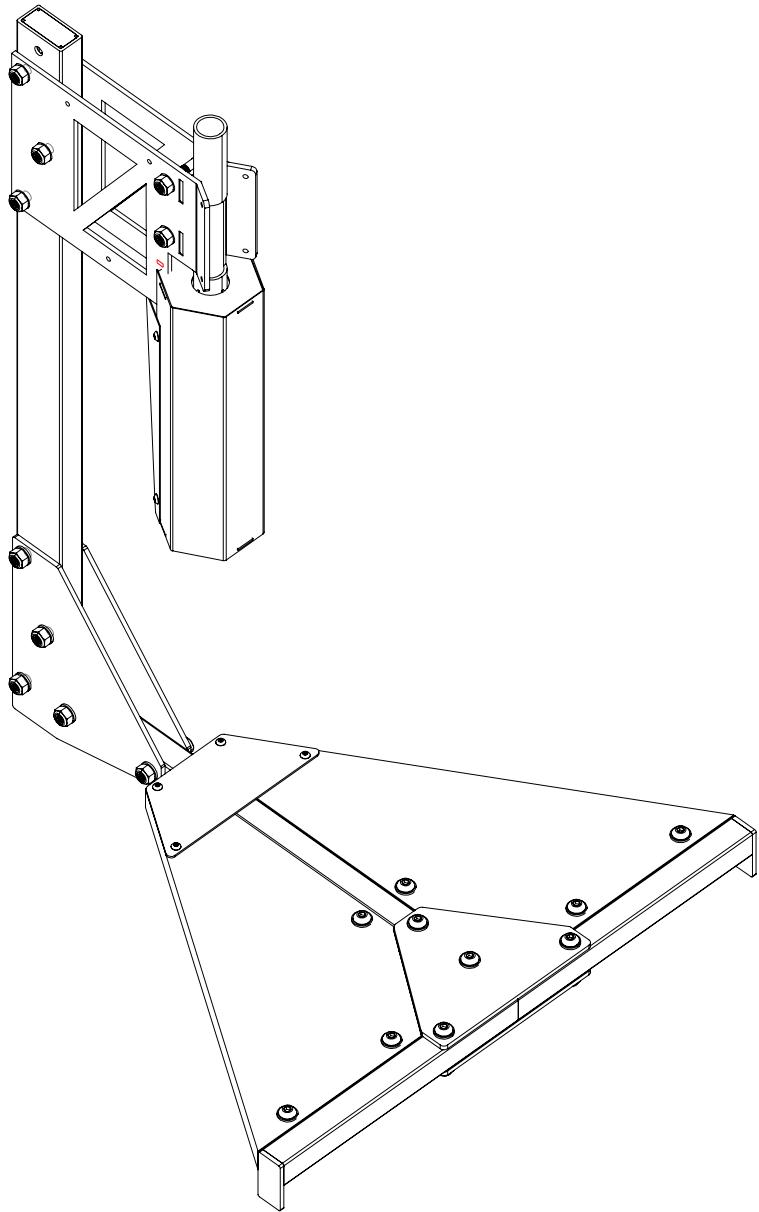
- 10x M10 washers

- 5x M10 nuts

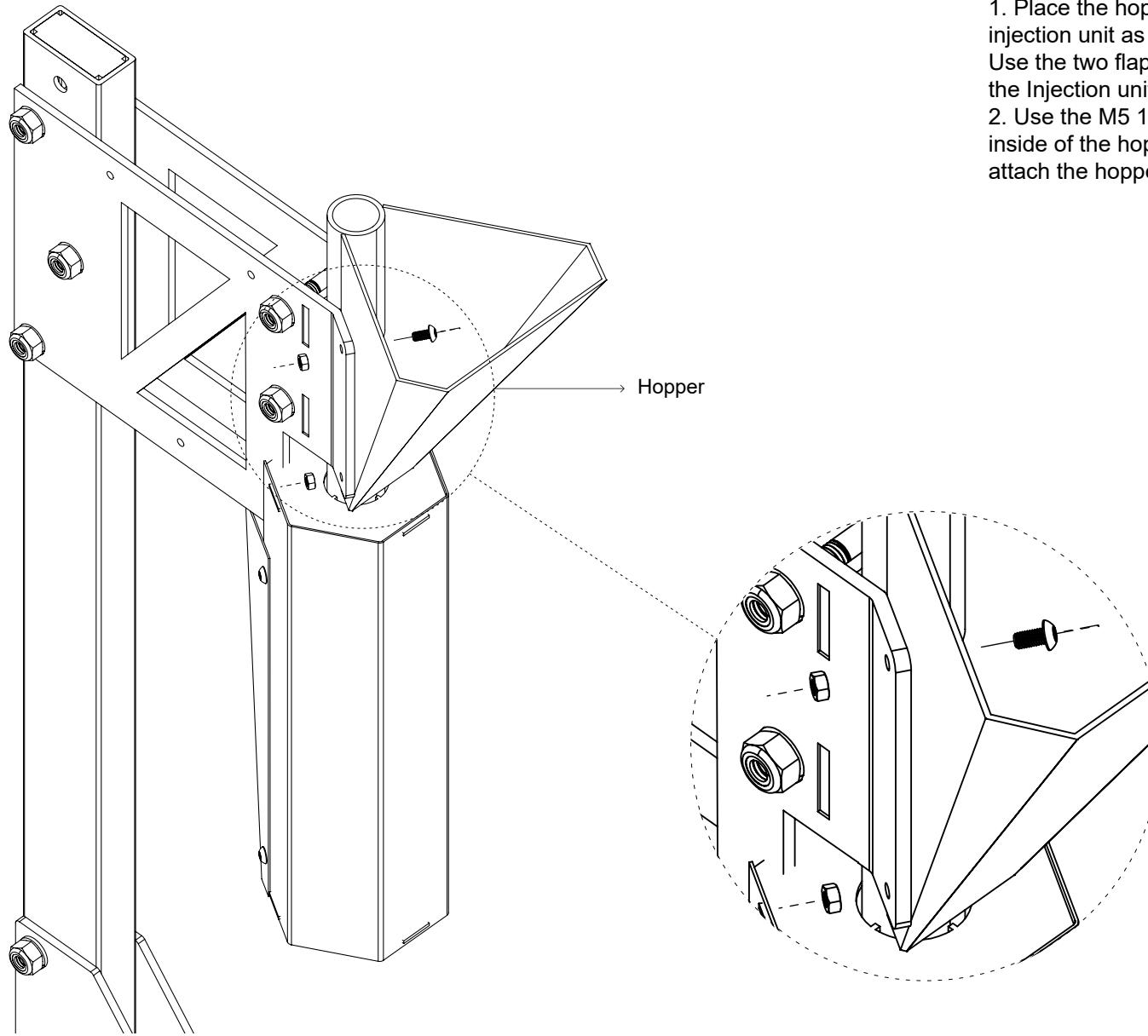
1. Take the 2 connectors and place one on each side of the Injection Unit making sure the bent part is pointing outwards.

2. Attach the plates by sliding the slots of the connectors onto the flaps of the barrel plate and barrel cover. Once the slots are aligned with the flaps, use the bolts to secure the plates in place. **Tip:** Don't tighten the bolts very hard at this point, just by hand, this will allow you to have more flexibility when placing the plates on each side of the 30x60 beam.

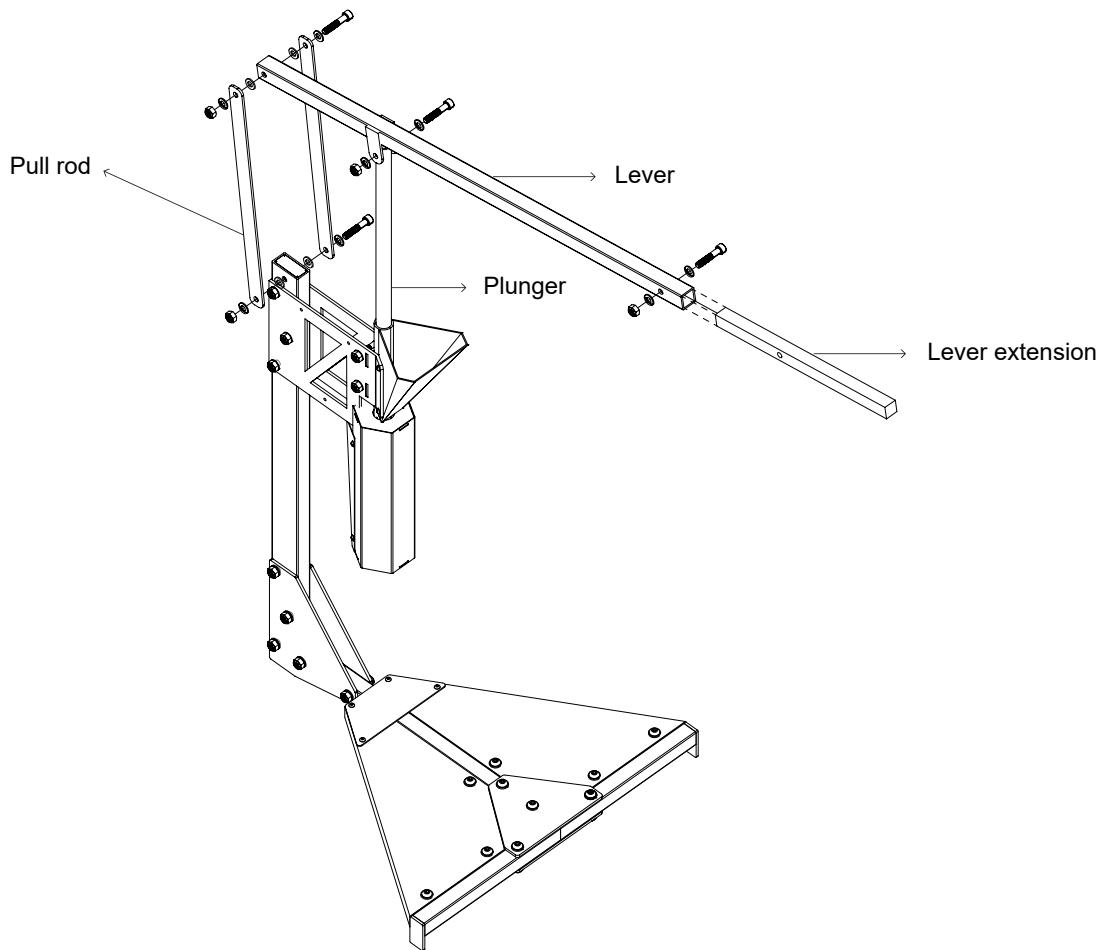
3. Attach the whole unit to the rest of the frame.



After you attached the Injection unit to the rest of the frame, now you can tighten the bolts using a spanner and allen key. Make sure everything is tight and steady.



1. Place the hopper in the front top part of the injection unit as you can see on the diagram below. Use the two flaps on the sides to attach the hopper to the Injection unit.
2. Use the M5 10 mm Button head bolts (from the inside of the hopper) and nuts (on the outside) to attach the hopper to the flaps.

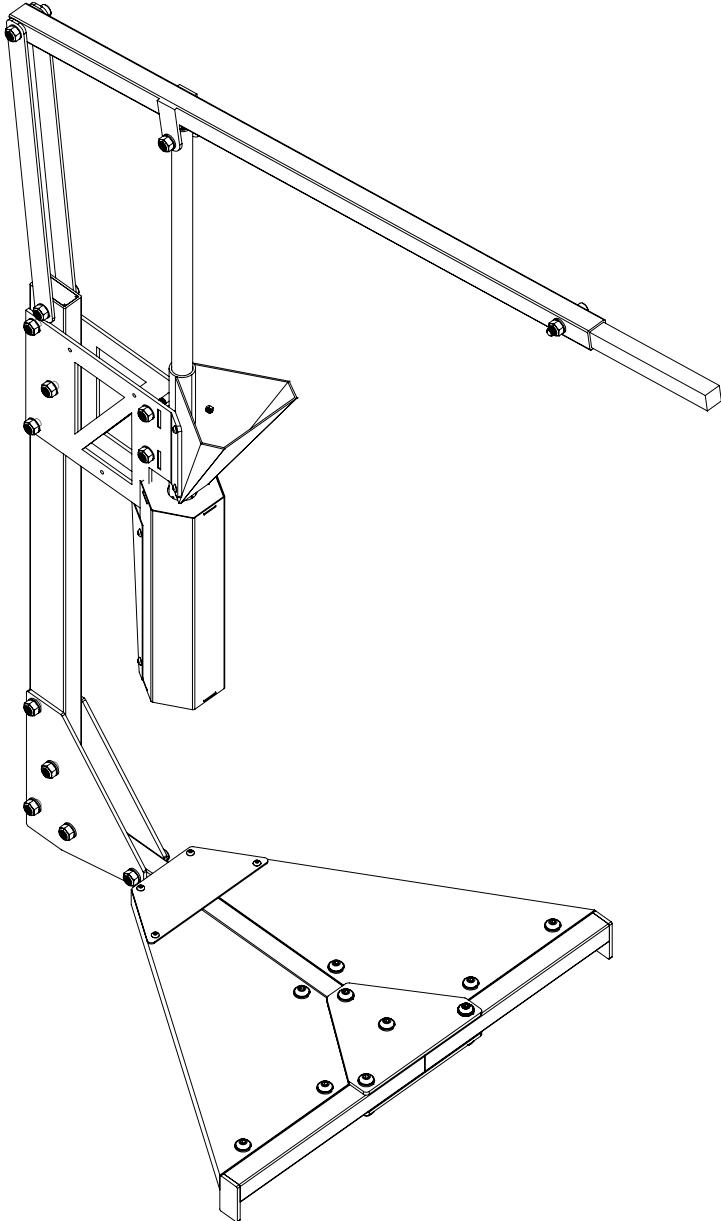


To assemble this part you'll need the following fixings:

- 3x M10 60 mm Allen head bolts
- 1x M10 50 mm Allen head bolt
- 12x M10 washers
- 4x M10 locking nuts

1. First you need to bolt together the lever with the 2 pull rods. The order for bolting is: Bolt, washer, pull rod, washer, lever, washer, pull rod, washer, locking nut.
2. Then you need to introduce the plunger in the Injection barrel and connect the plunger to the lever. The order for bolting is: Bolt, washer, lever flap, plunger, lever flap, washer, locking nut.
4. Bolt the other end of the pull rods to the 30x60 beam. The order for bolting is: Bolt, washer, pull rod, washer, beam, washer, pull rod, washer, locking nut.
5. Take the stainless steel 25x25 square tube (Lever extension) and introduce it into the lever and secure it with bolts and nuts as you can see on the diagram. The order for bolting is: Bolt, washer, lever, lever extension, lever, washer, nut.

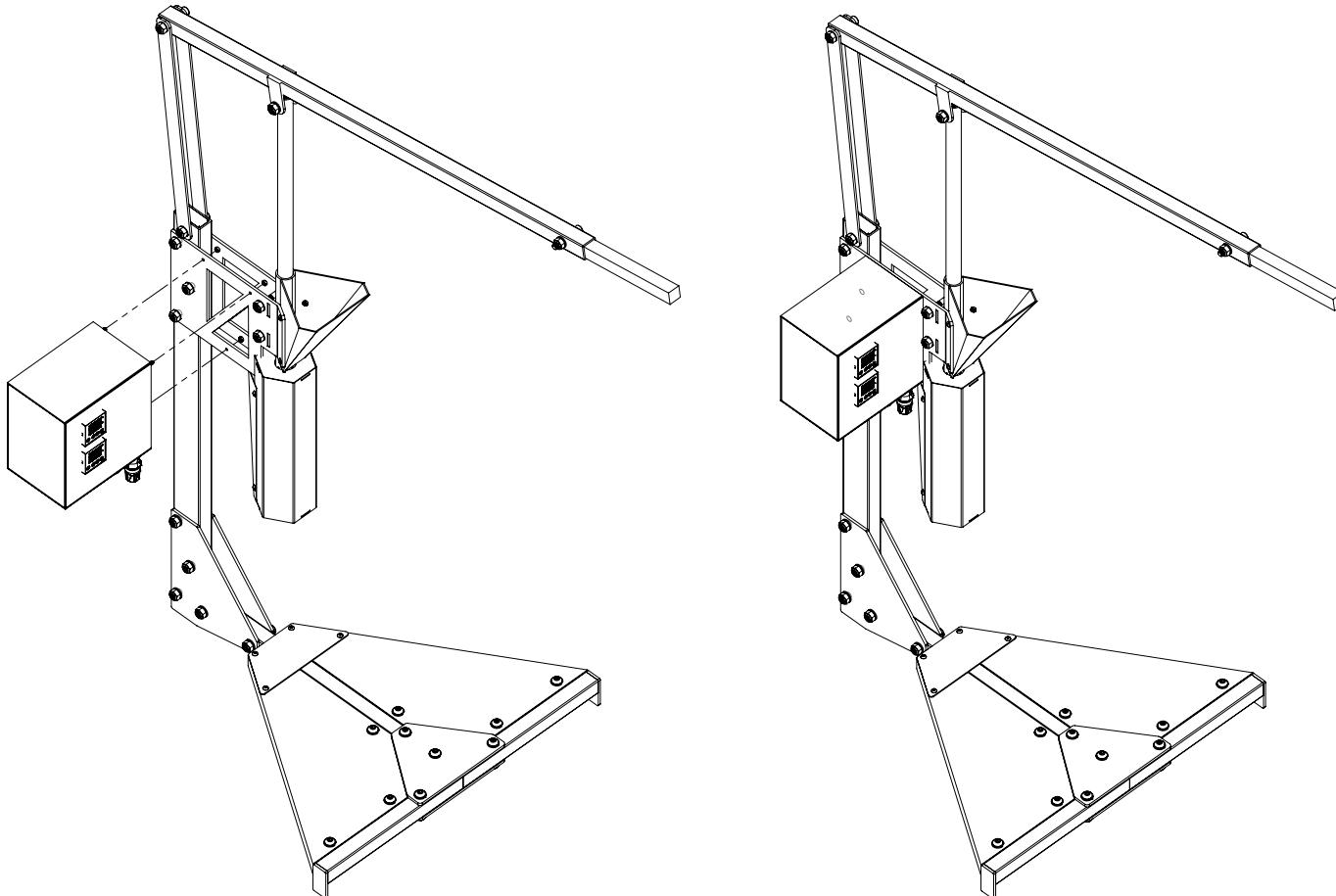
Note: We use locking nuts in this section to be able to secure the nuts without having to tighten them fully, because these are going to be the moving parts of the machine, therefore, we need some space between the parts for this to happen. If you tighten them too much you won't be able to pull the lever up and down easily.



And this is how your injection machine should look like at this point.

Test the lever by pulling it up and down and make sure it moves smoothly.

1. Get the electronic box and place it on the left side of the machine. The box already has 3x M5 bolts on it that fit in the holes of the connector plate.
2. Use the M5 nuts to secure it in place and tighten them with the 8mm spanner or an adjustable one.



Look at the bottom of your electronics box. This is where you'll connect the cables that come out from the Injection unit.

There are 4 heating elements and 2 thermocouples, the 3 top heating elements work with one of the thermocouples (all these heating elements and thermocouple are wrapped in yellow) and the bottom heating element goes with the other thermocouple (These last 2 are wrapped together in blue).

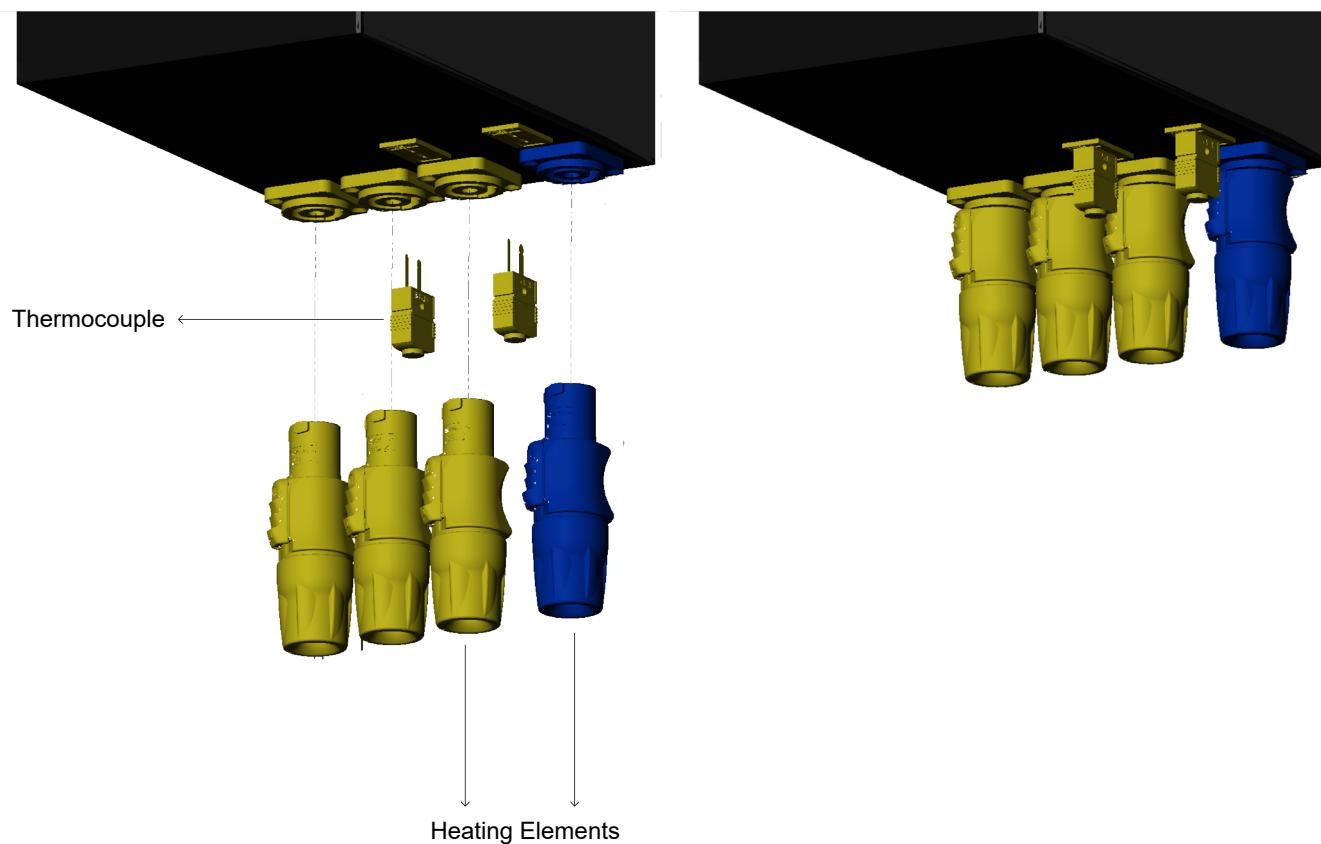
Lets start with the blue:

Connect the blue plug (heating element) in the blue socket and the thermocouple that's attached with it, into the socket that's right in front of it.

Lets continue with the yellow

First plug in the heating element that's wrapped together with the thermocouple and, same as the one before, plug the thermocouple to the socket that's right in front of the heating element.

Now plug in the other 2 remaining heating elements to the other sockets (doesn't matter the order).





Nearly done, hurray!

Now you'll need to connect the cable that's going to provide the power to the machine. After you plug in the cable in the socket, now you can turn on your machine and start melting some plastic!

Happy melting :)!

