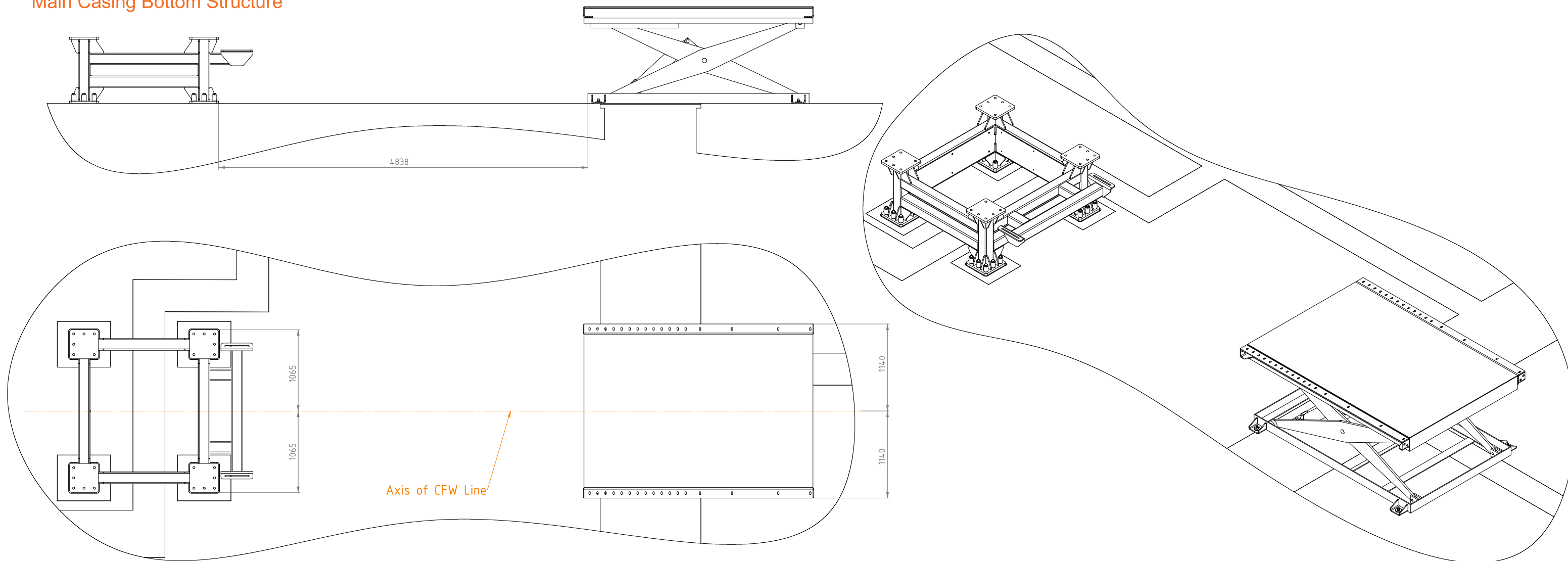


Main Casing Bottom Structure

Lifting Table Zero

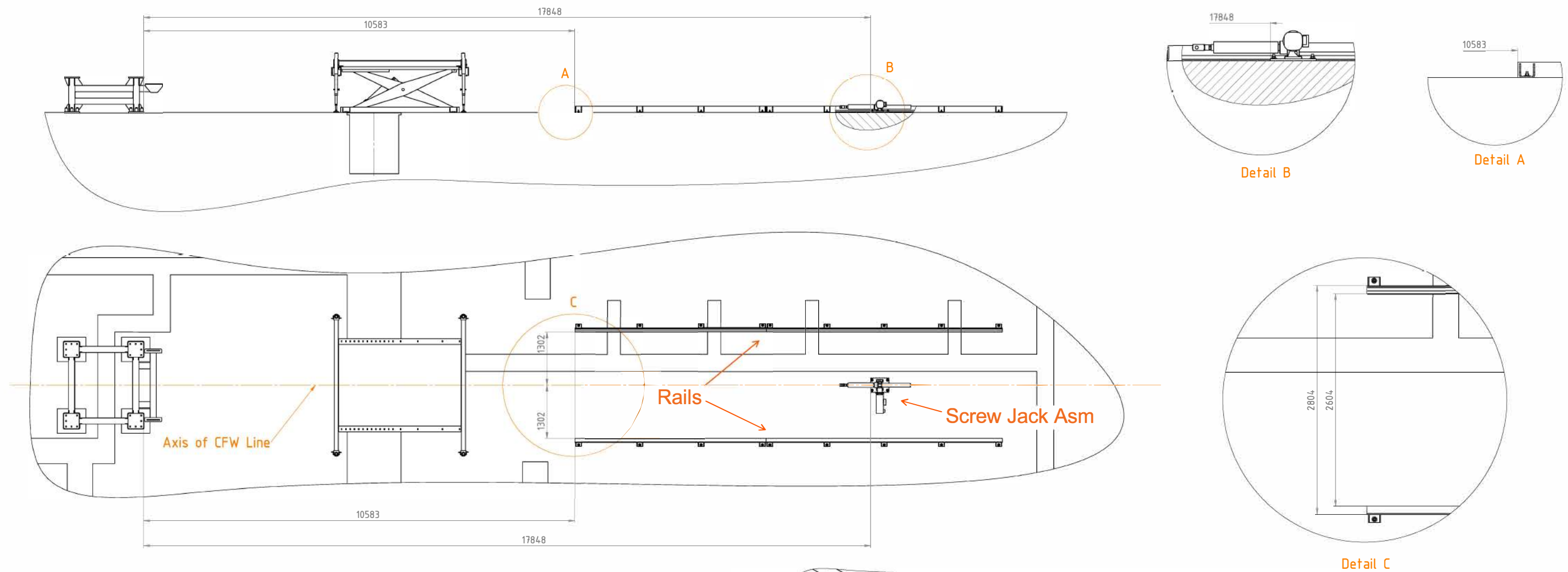


Lifting Table Zero

1. Main Casing bottom structure must be mounted to the floor according to *Main Casing Installation Procedure Steps 1 to 8*.
2. Position Lifting Table Zero as shown on the image above.
3. DO NOT FIX Lifting Table Zero to the floor until the shaft has been installed and the axis has been verified.



TOPFIBRA
EFFECTIVE FILAMENT WINDING® PIONEERS

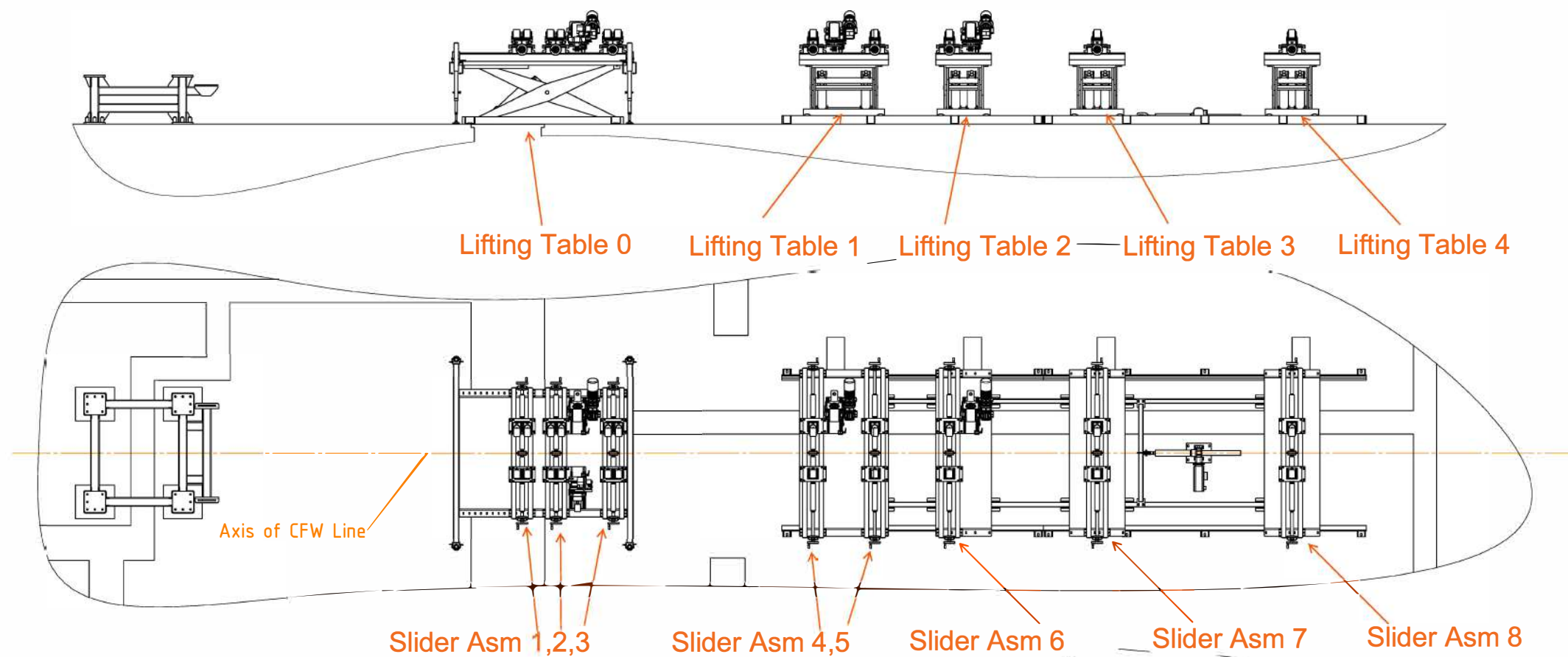


RAILS and Screw Jack Assembly

1. Place the Rails and the Screw Jack Assembly as shown.
2. Rails must be appropriately leveled with shims.
3. Rails must be positioned parallel to the axis of the E-CFW Line.
4. DO NOT FIX the Rails and the Screw Jack Assembly to the floor until the shaft has been installed and the axis has been verified!
5. Mount the supporting legs to Lifting Table Zero.

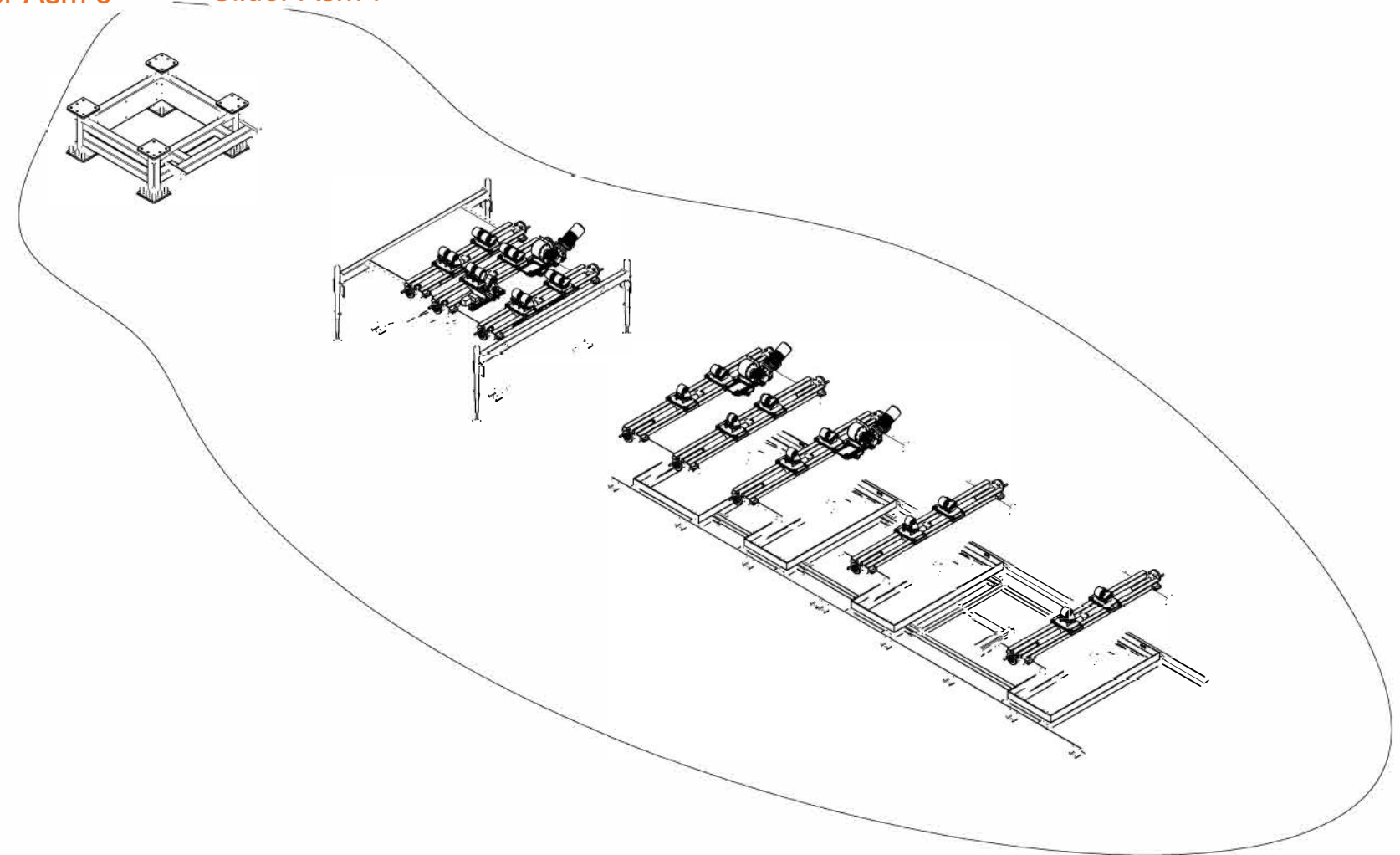


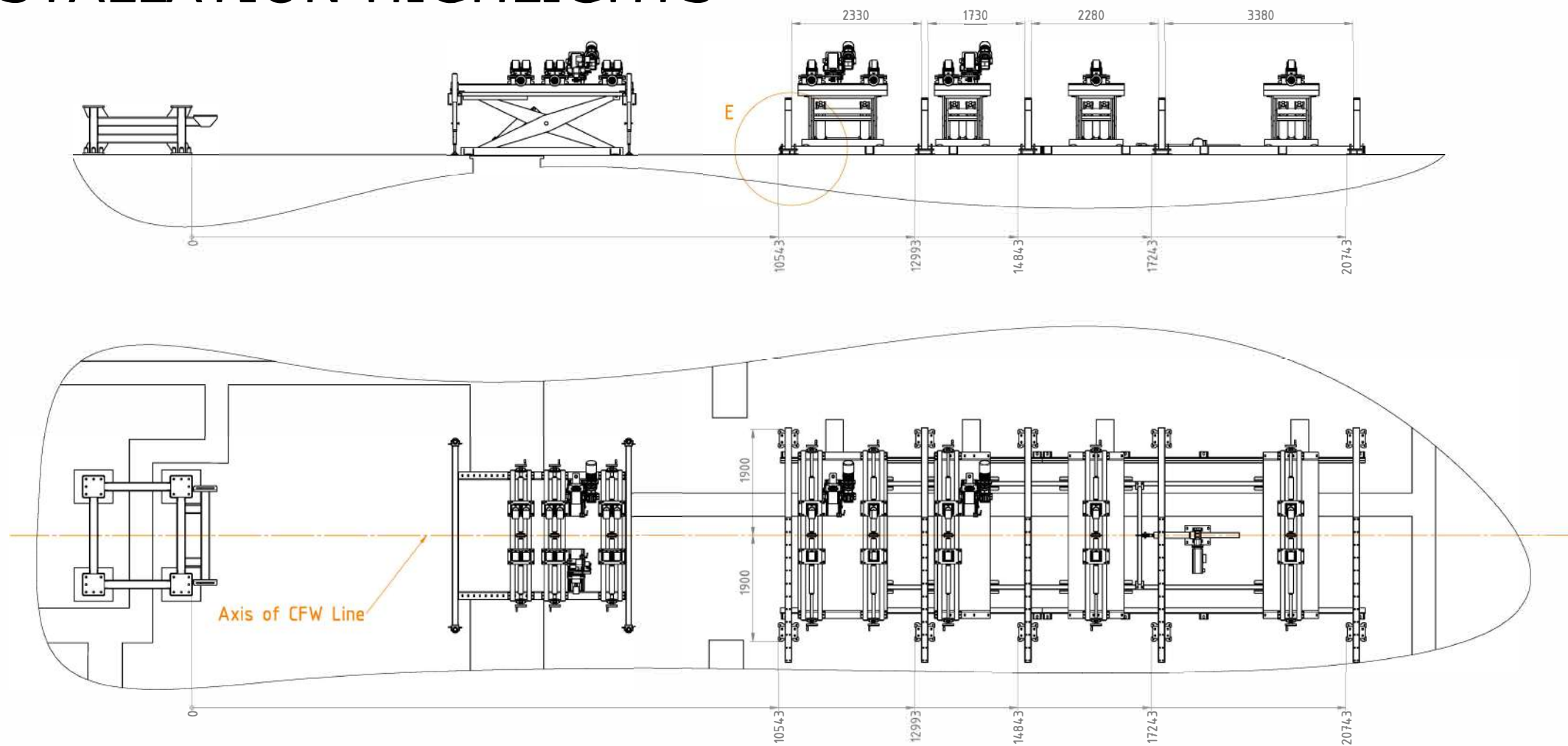
TOPFIBRA
EFFECTIVE FILAMENT WINDING® PIONEERS



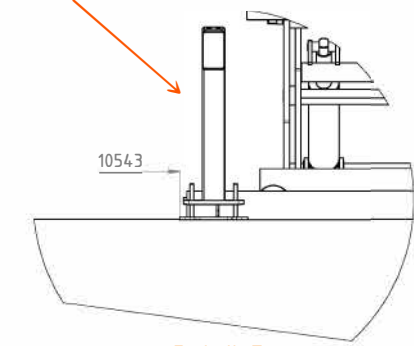
Lifting Tables and Slider Assemblies

1. For the next steps please refer to the drawing for Lifting Tables Area DRW_T02113-01_RevB.
2. Position Lifting Tables 1-4 on the Rails as shown.
3. Connect Lifting Tables with Linkages.
4. Connect Screw Jack Assembly with the Lifting Tables.
5. Position the Slider Assemblies on the Lifting Table Zero.





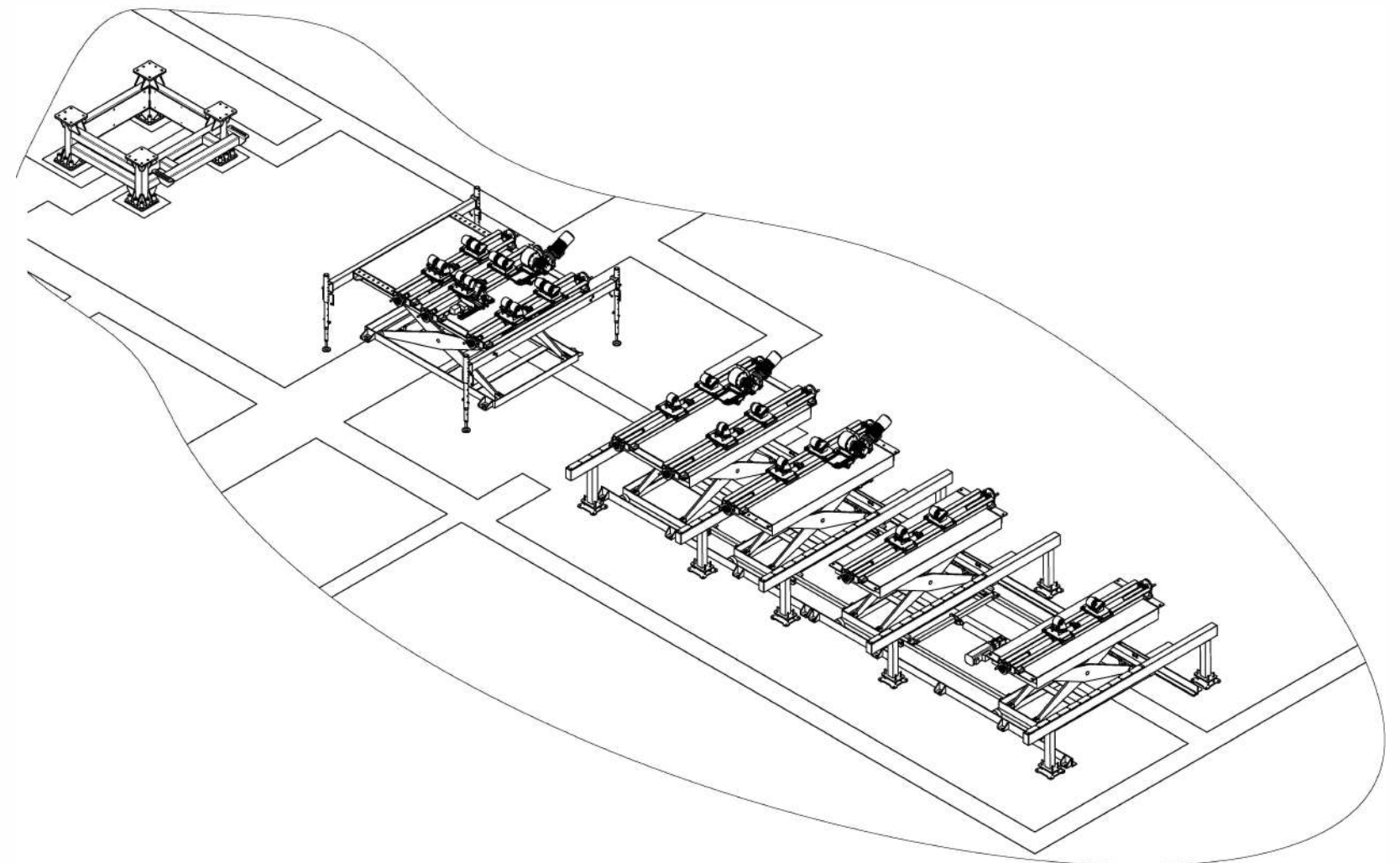
Production Table Beam



Detail E

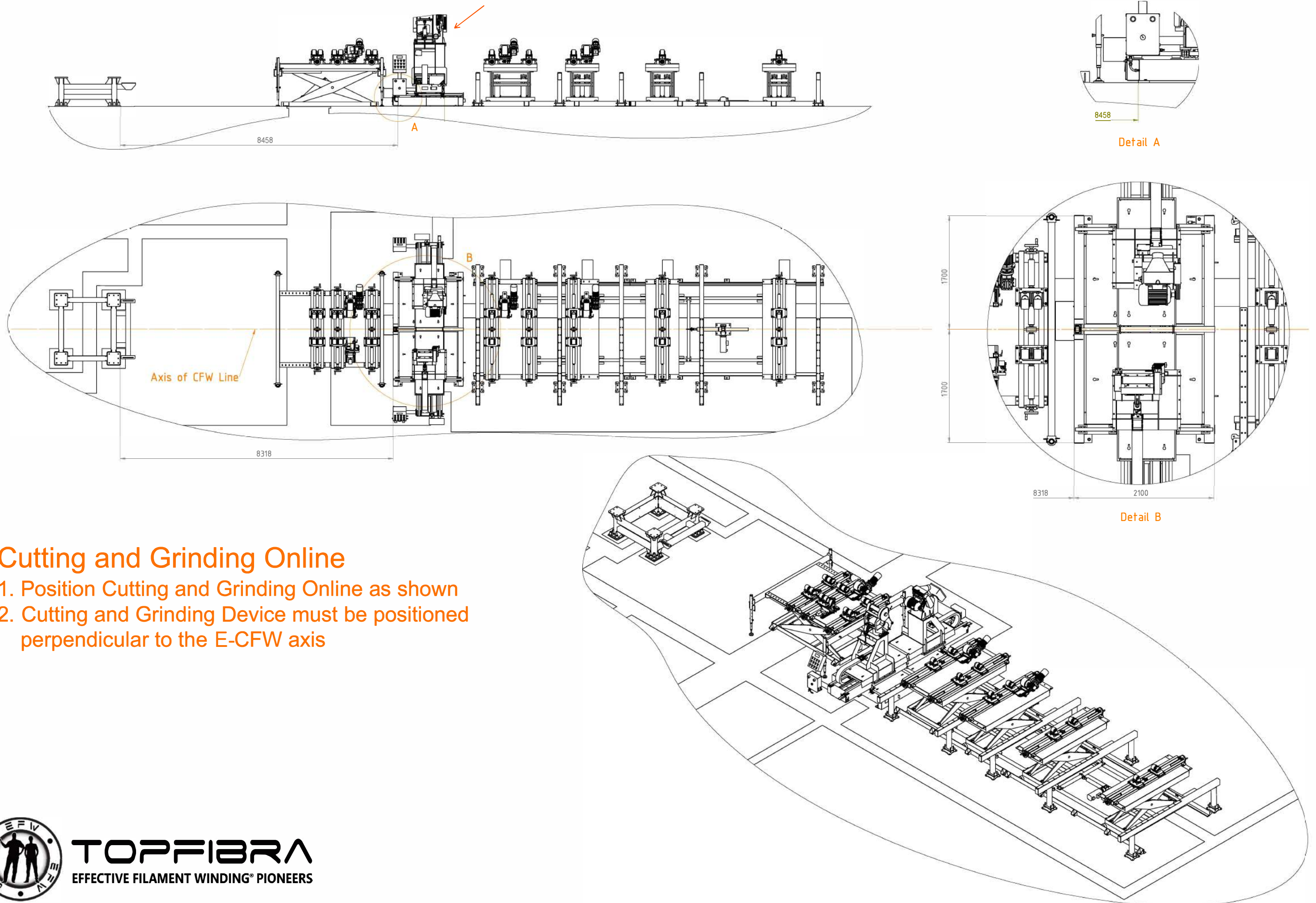
Production Table Beams

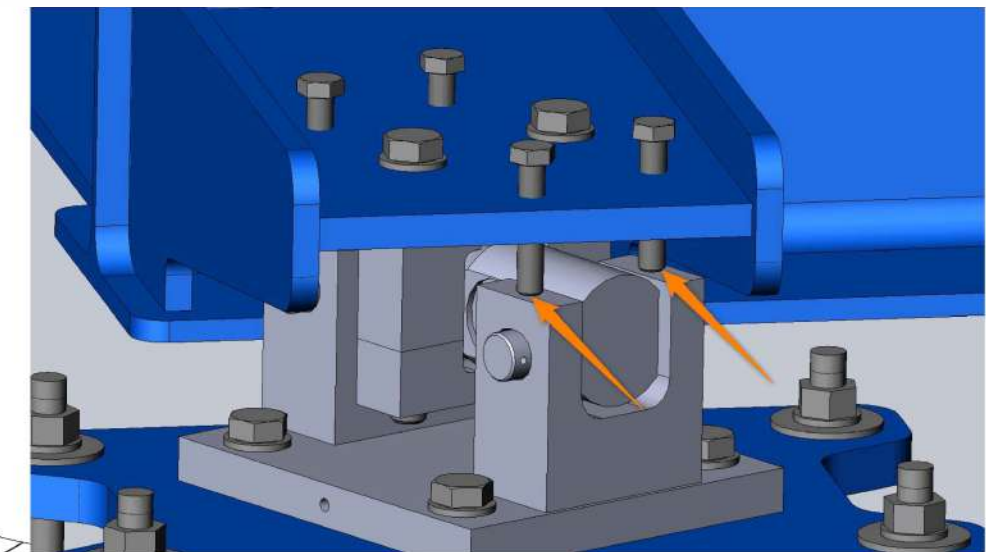
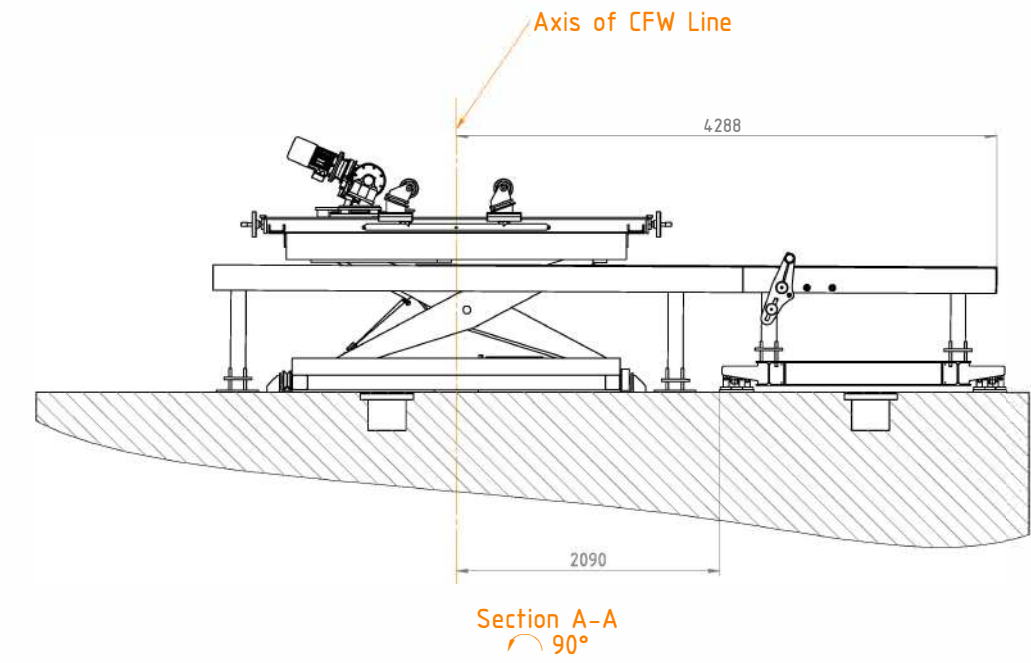
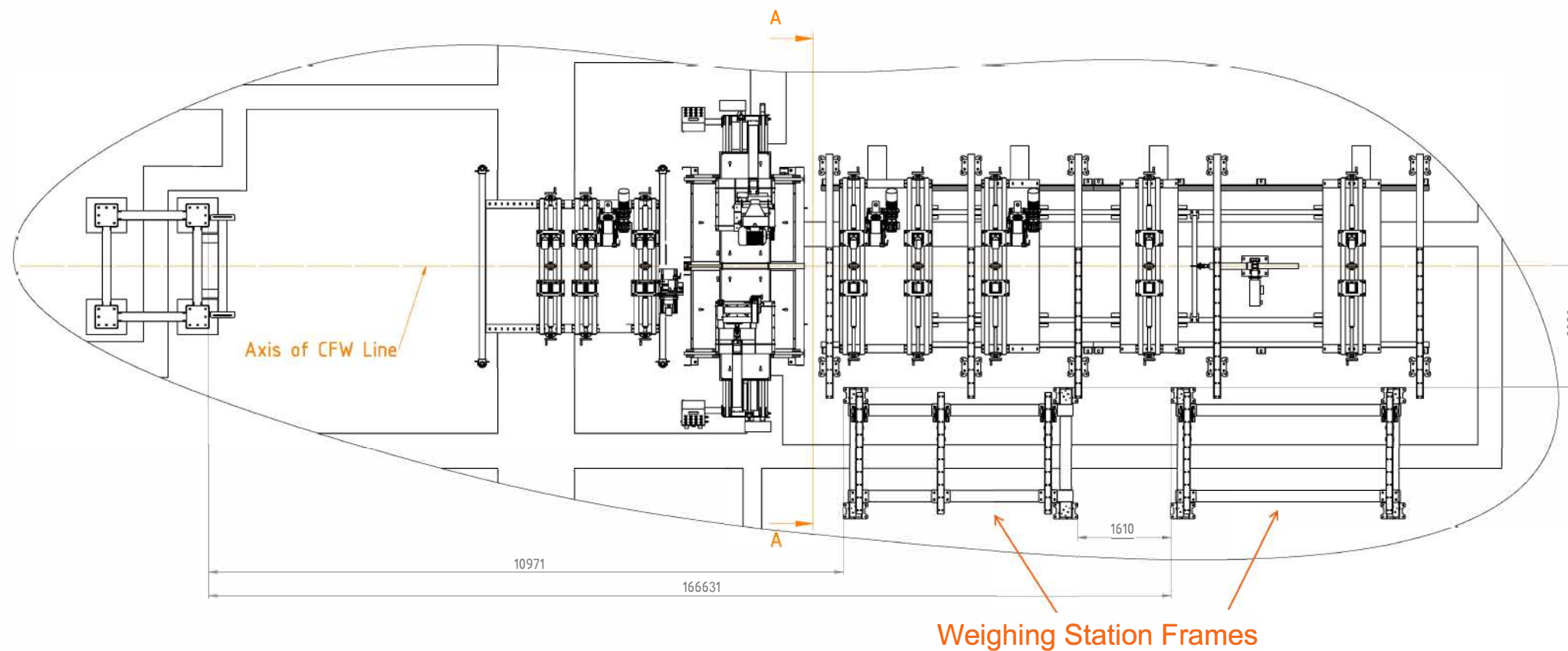
1. Place 5x Production Table Beam as shown.
2. Beams must be positioned perpendicular to the E-CFW axis.



TOPFIBRA
EFFECTIVE FILAMENT WINDING® PIONEERS

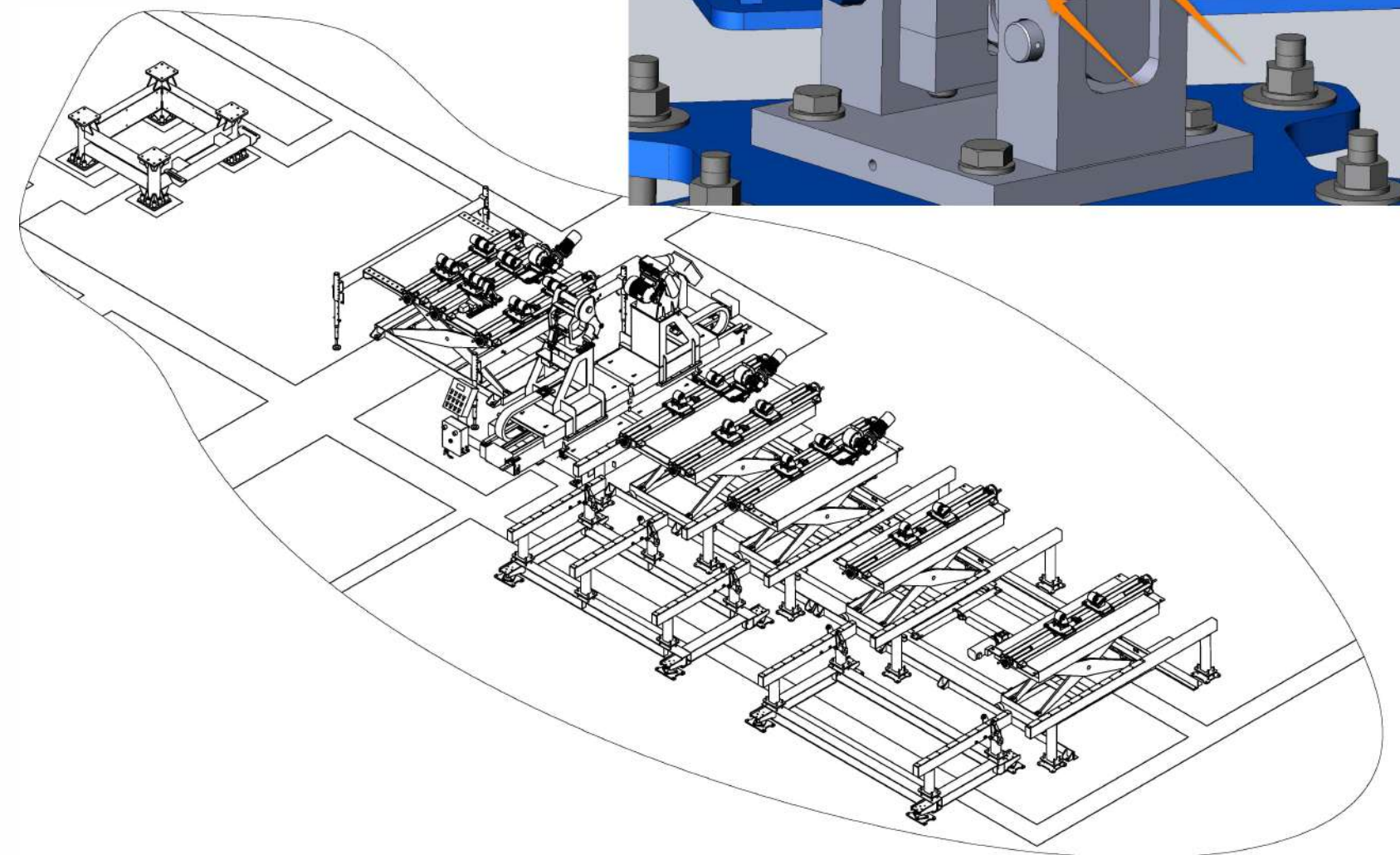
Cutting and Grinding Online Unit



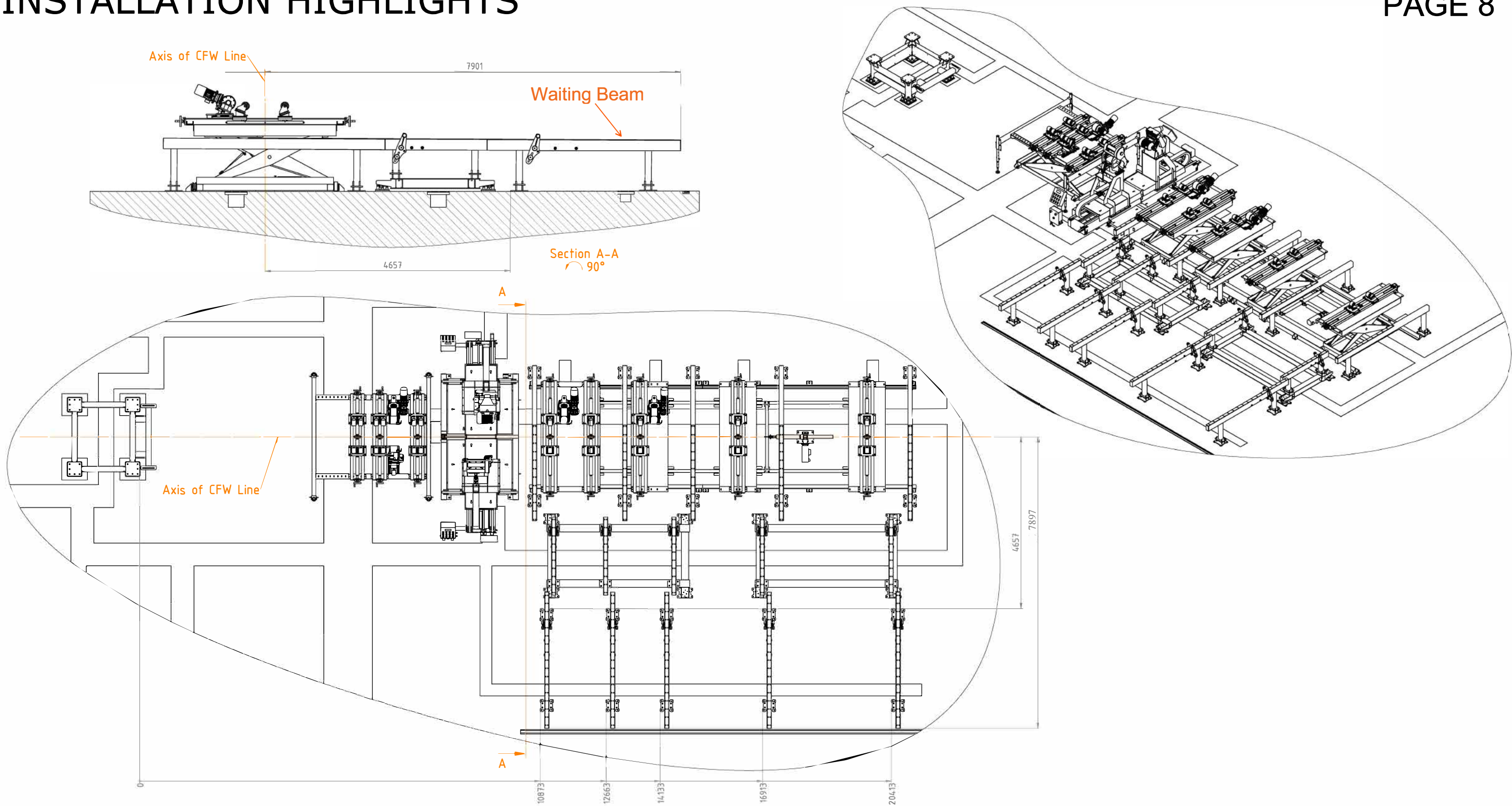


Weighing Station Frame

1. Before moving or lifting the Frame make sure the sensors are gently locked with the four screws as shown on the image beside (screw the bolts in until they touch the top surface of the sensor and add a maximum of a quarter turn of tension).
2. Position the Weighing Station Frame as shown.
3. If more info is needed please refer to drawing T02114-01.



TOPFIBRA
EFFECTIVE FILAMENT WINDING® PIONEERS



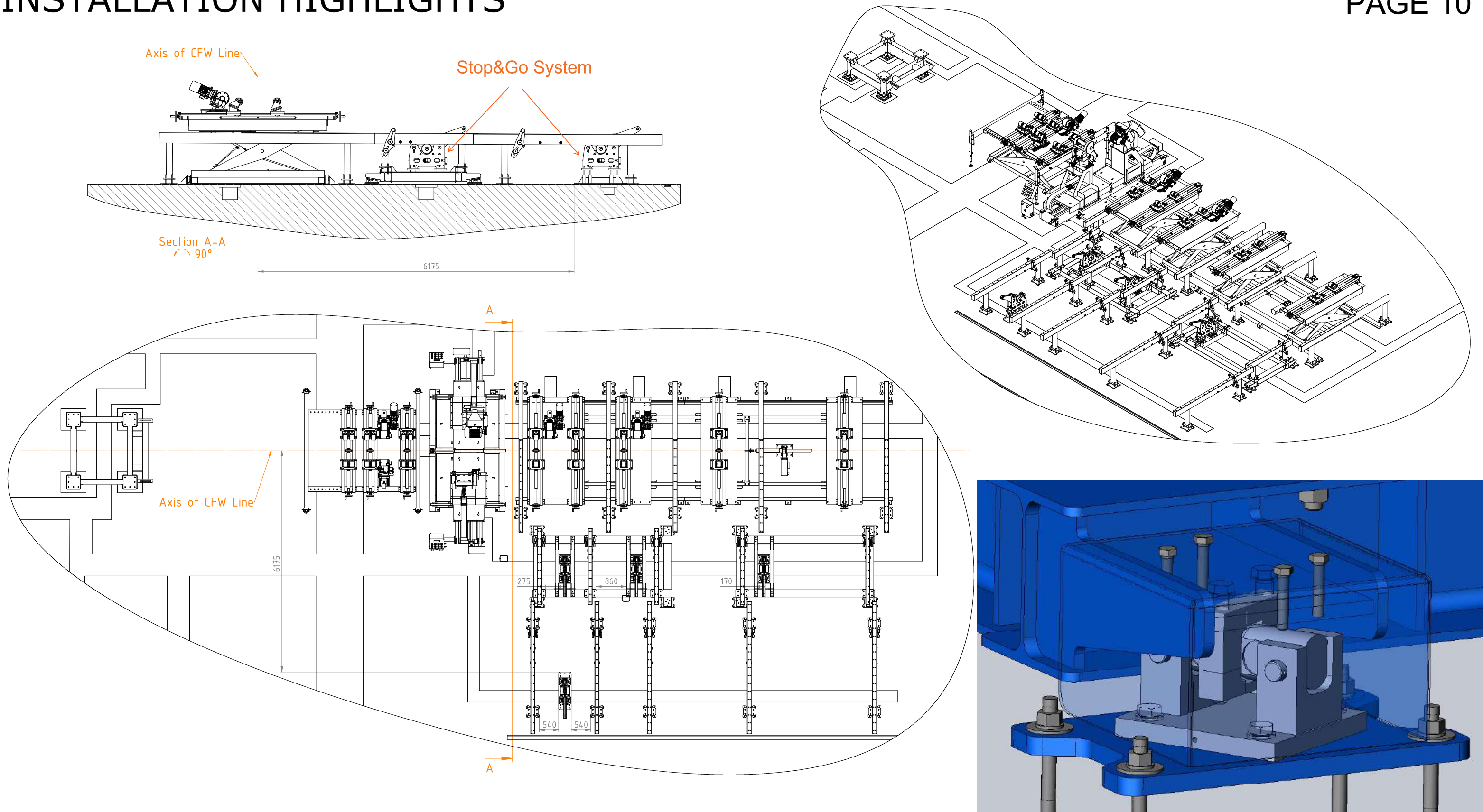
Waiting Station Beams

1. Position the Waiting Station Beams as shown
2. If more info is needed please refer to drawing T02114-01
3. DO NOT FIX the Waiting Station Beams until you verify the Trolley's loading and unloading state



TOPFIBRA
EFFECTIVE FILAMENT WINDING® PIONEERS

	TOPFIBRA SPECIAL PLASTIC WELDING PROCESS	TOPFIBRA d.o.o. Ulica 26. marta 27, 10118 Podgorica, Biserica, 81 www.topfibra.me Phone: +382 9 200 1000		MATERIAL: Assembly CLAS. (ISO 9001):	
		Title - Dimensions - Standard Weighing and Waiting Station Area		COATINGS:	
		WEIGHT: 456.74 kg			
		DESIGNED	George Jovic	DATE	1.06.2022
		CHECKED	Pavlo Filipovic	DATE	1.06.2022
		APPROVED	Miroslav Petrovic	DATE	1.06.2022
Doc. Type	Document No.	Revision	Additional drawings: ISO 15775		
DRW	T02114-01	A	General Tolerances UNF ISO 2768-1		
			Form. & Fin. UNF ISO 2768-1		
			Scale	Sheet	Size
			1:20	1	A1

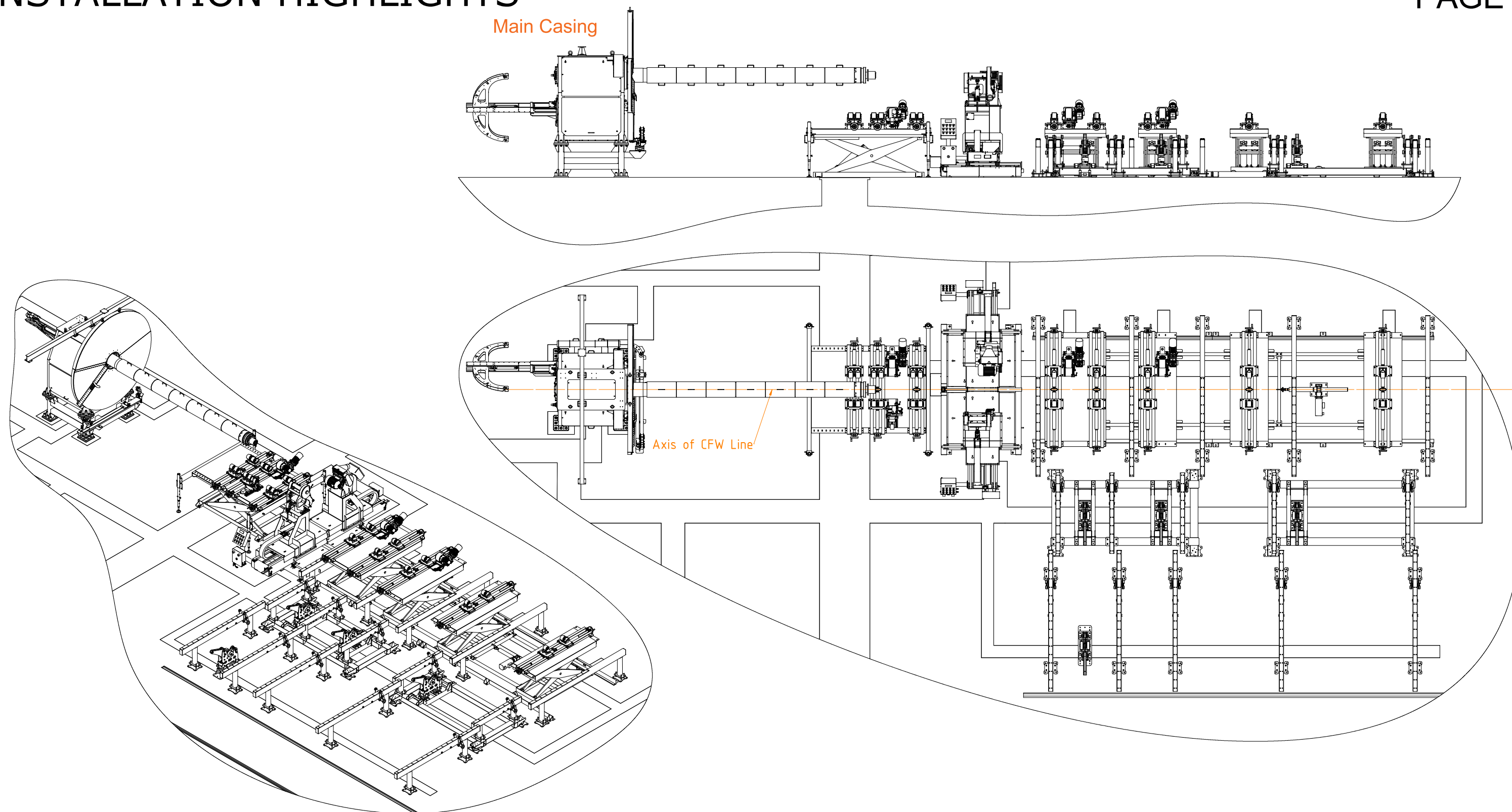


Stop&Go System

1. Position the Stop&Go System as shown.
2. Drill holes into the Weighing Frame.
3. Unscrew the locking bolts of sensors and add the covers for sensors.



TOPFIBRA
EFFECTIVE FILAMENT WINDING® PIONEERS

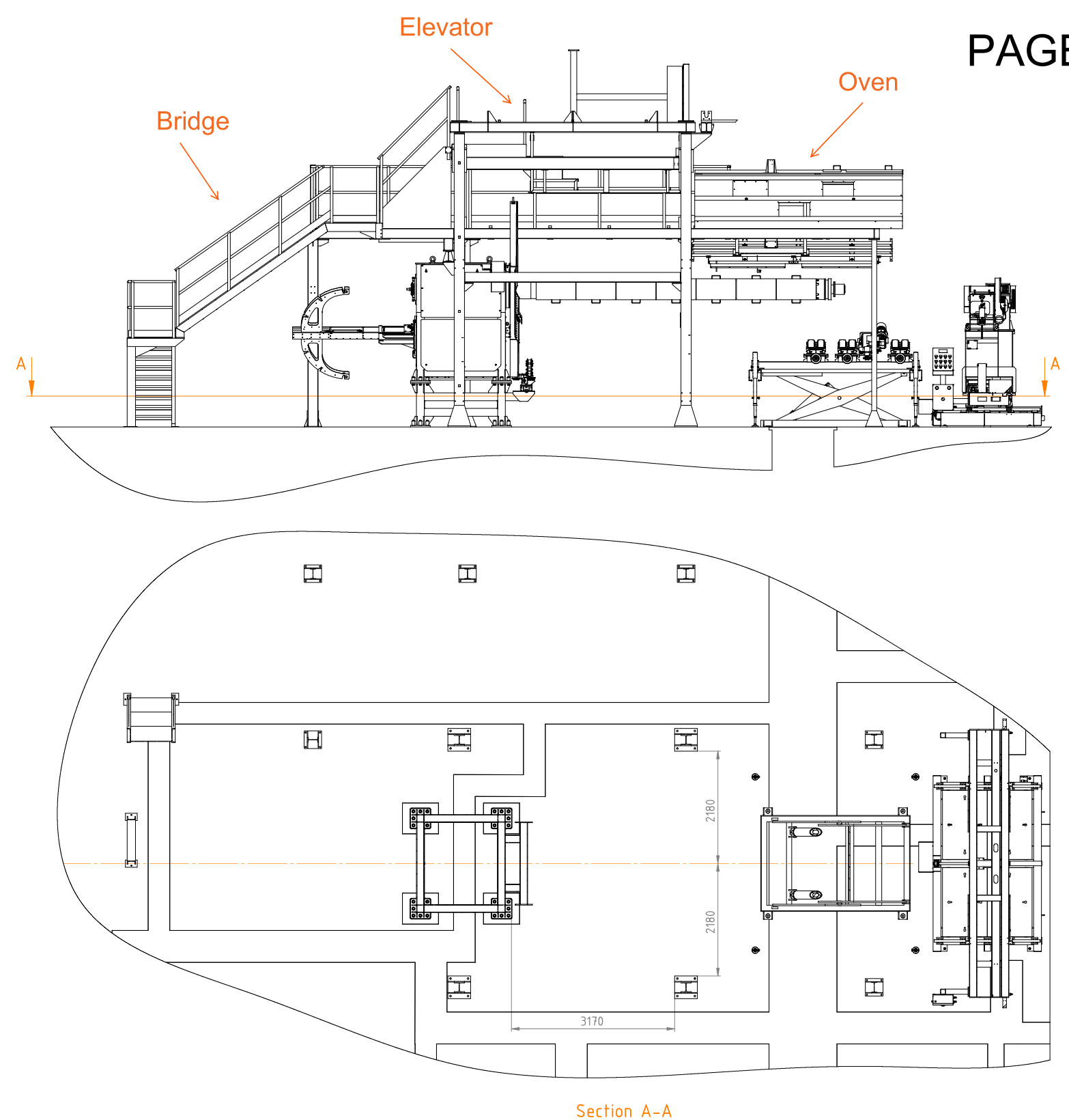
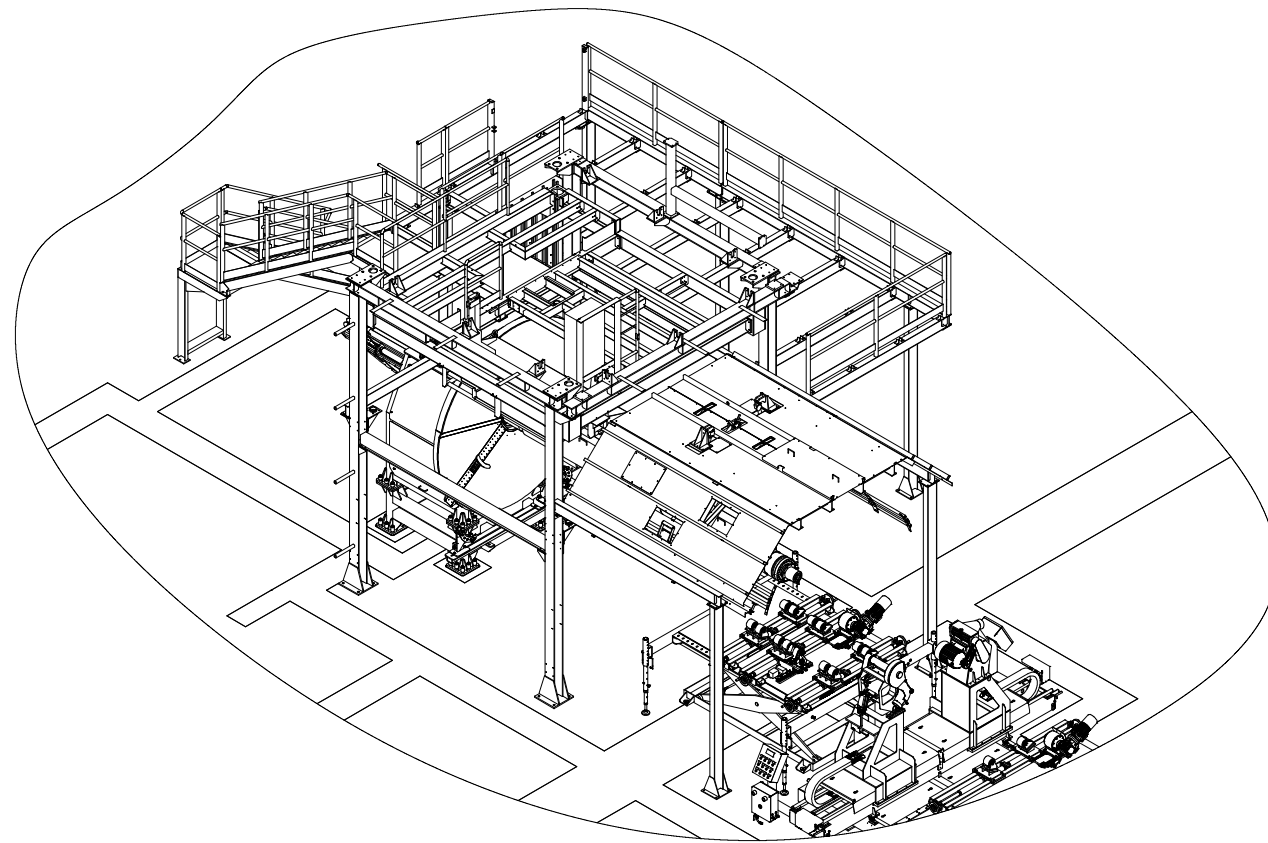


Main Casing Assembly

1. Before proceeding the Main Casing Assembly has to be completed according to *Main Casing Installation Procedure*.
2. At this point axis of the shaft should be verified.
3. After axis verification the previously placed equipment can be fixated to the floor.



TOPFIBRA
EFFECTIVE FILAMENT WINDING® PIONEERS

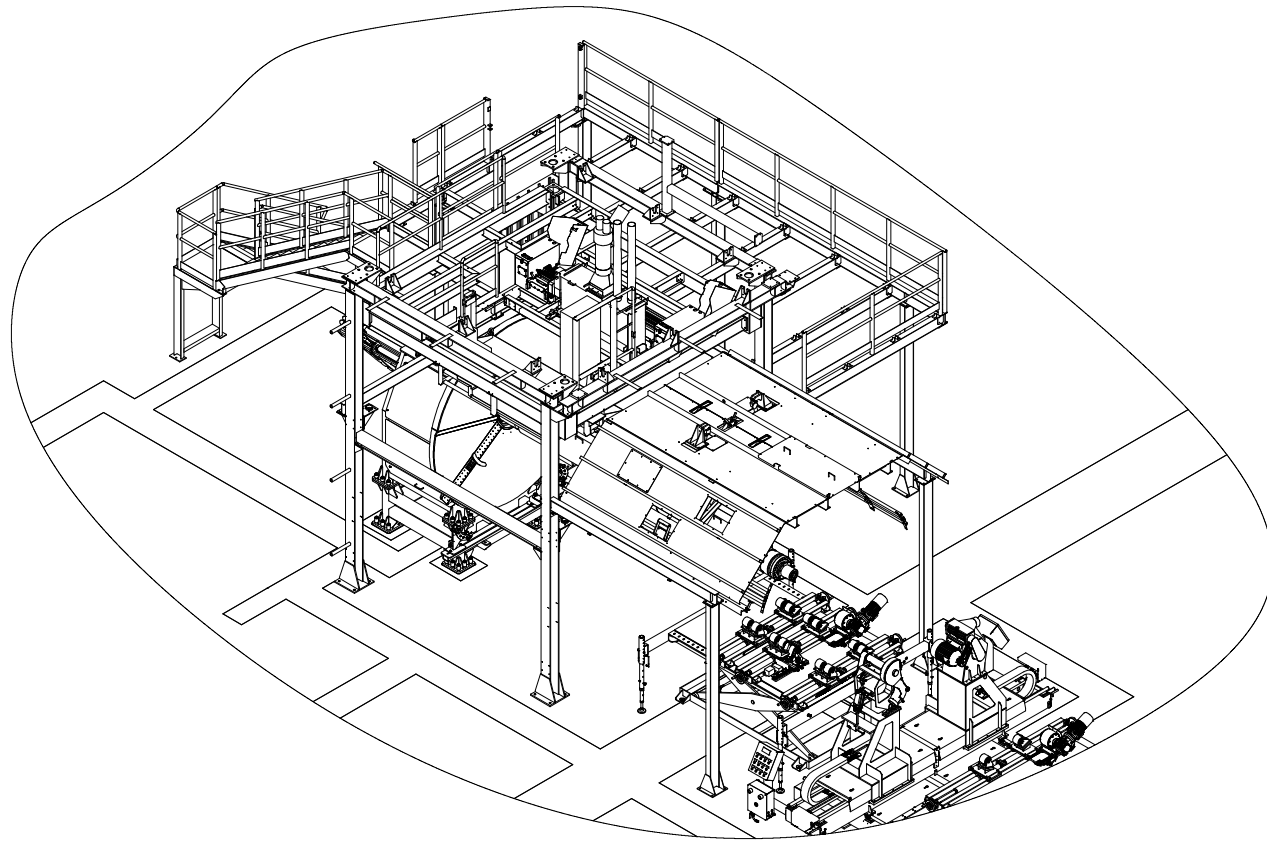


Elevator, Bridge and Oven

1. Make sure that the assembling of the Main Casing has been finished and that the Shaft is in position.
2. Position the Elevator Assembly as shown on the image above.
3. Assemble the Bridge and connect it to the Elevator structure.
4. Position the Oven and connect it to the Elevator structure.

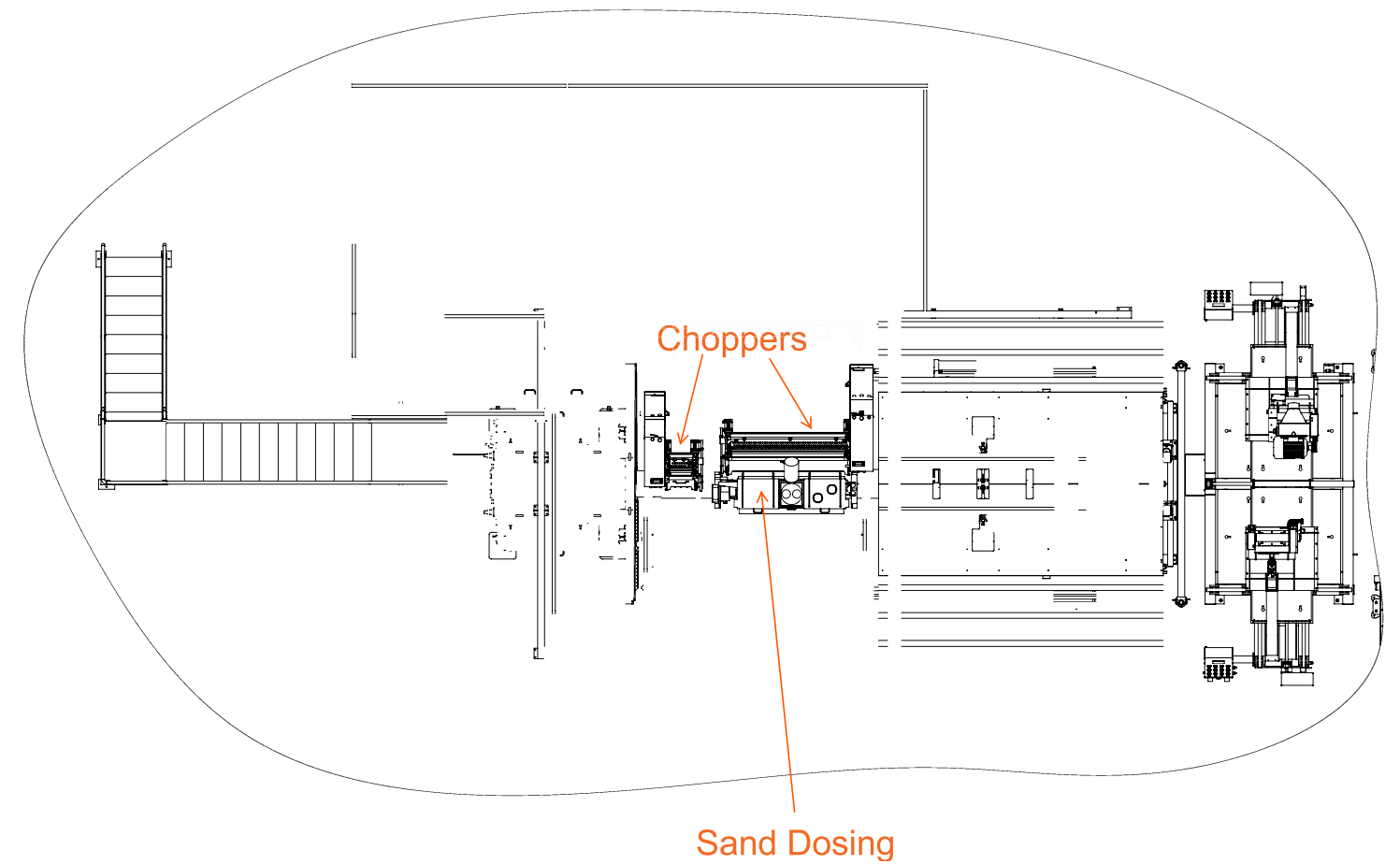
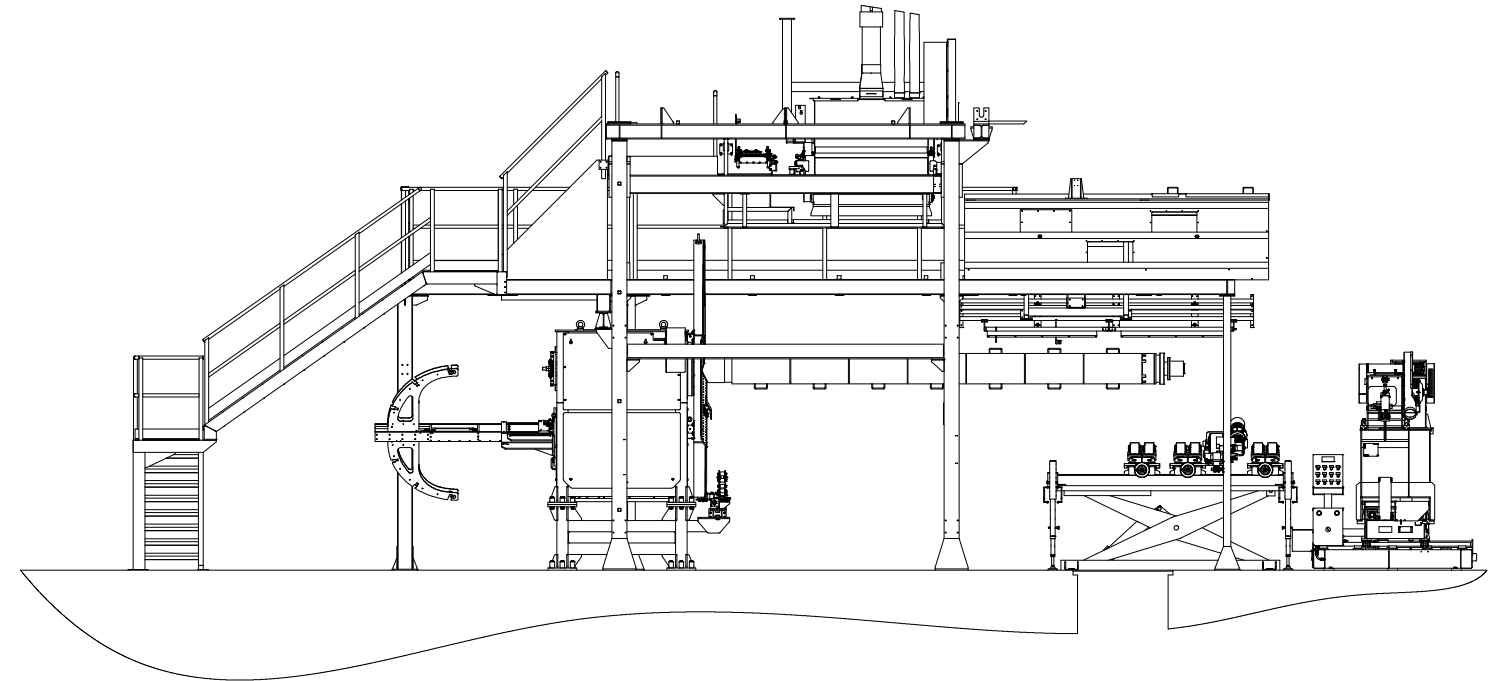


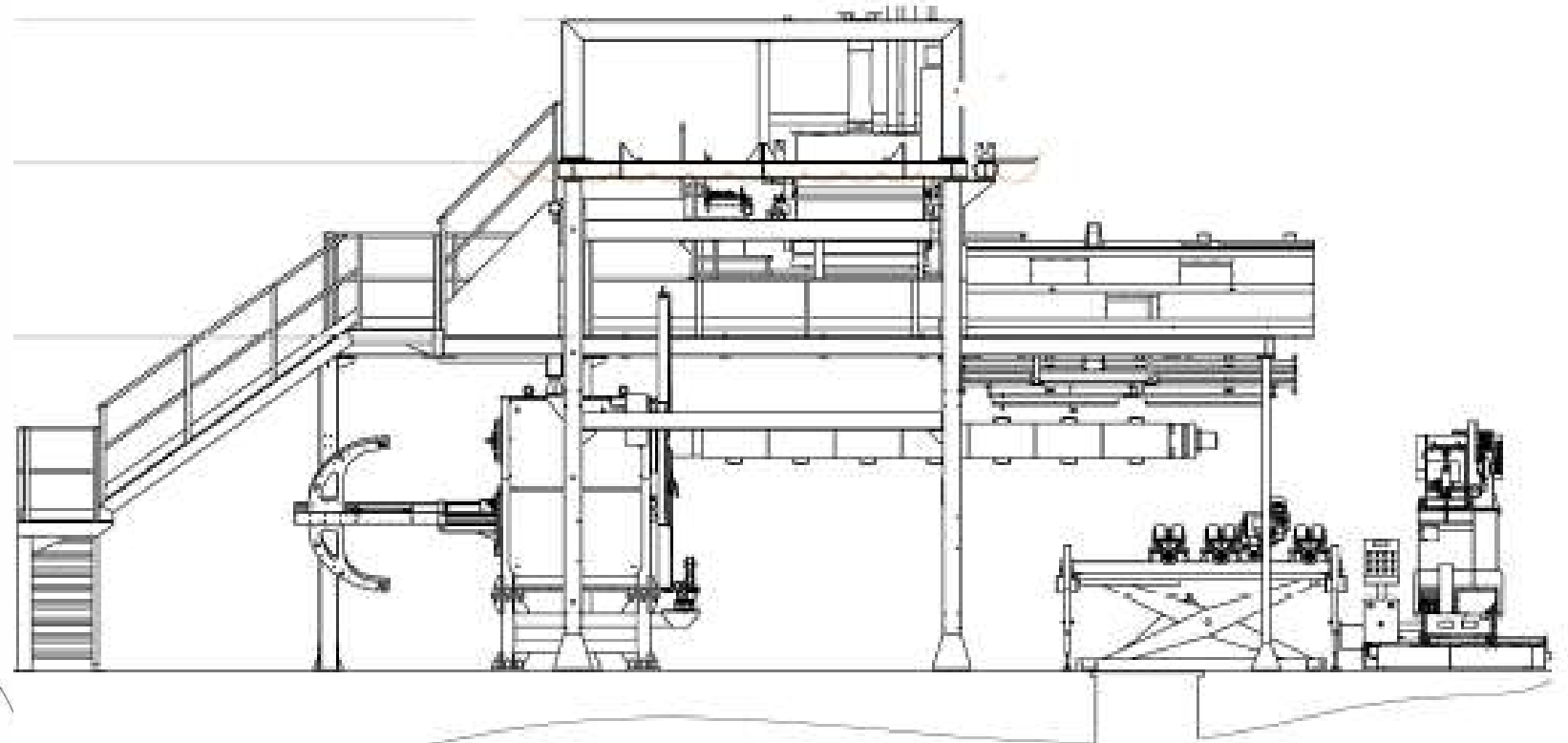
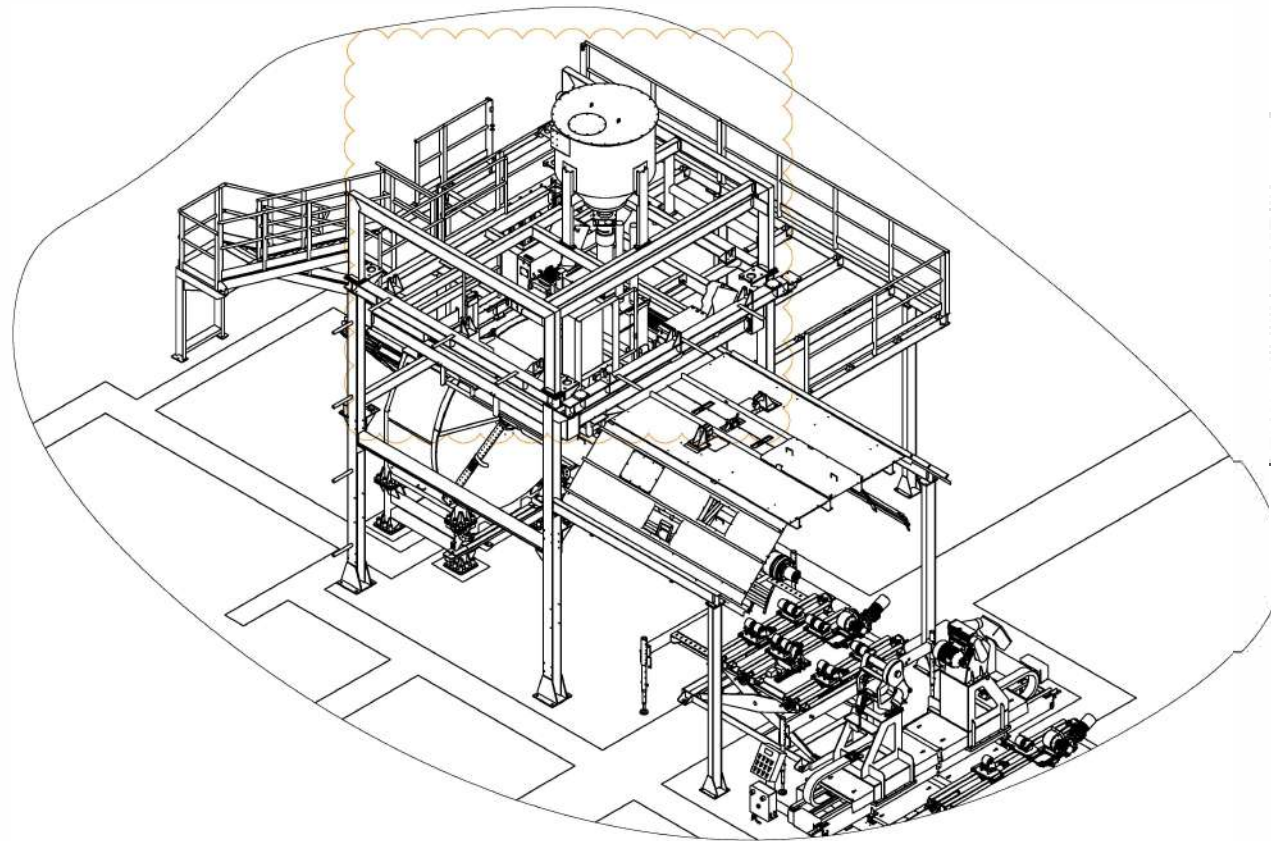
TOPFIBRA
EFFECTIVE FILAMENT WINDING® PIONEERS



Sand Dosing and Choppers

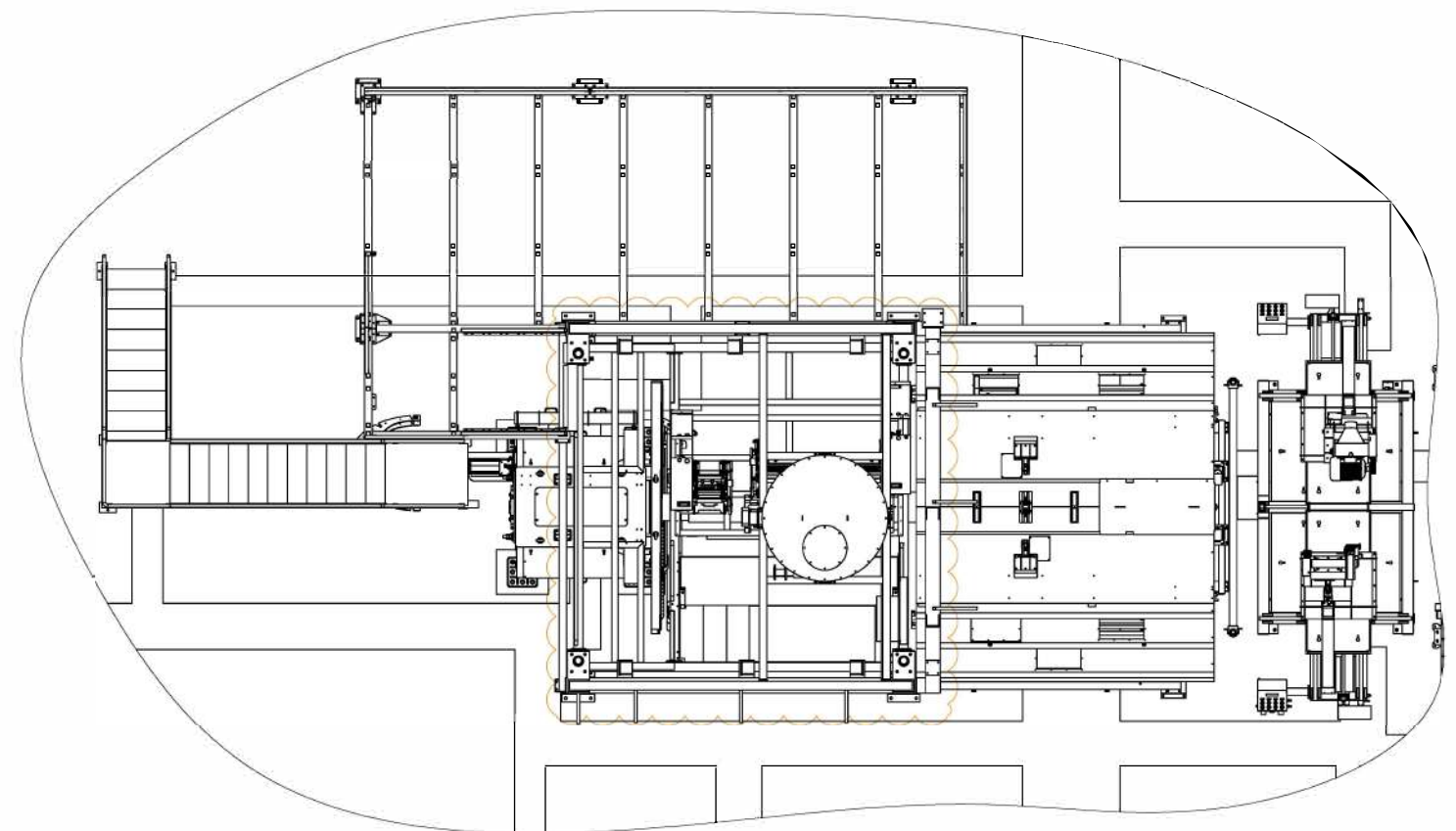
1. Place the Sand Dosing Device and the Chopper Devices on top of the Elevator before placing the Elevator's top structure.



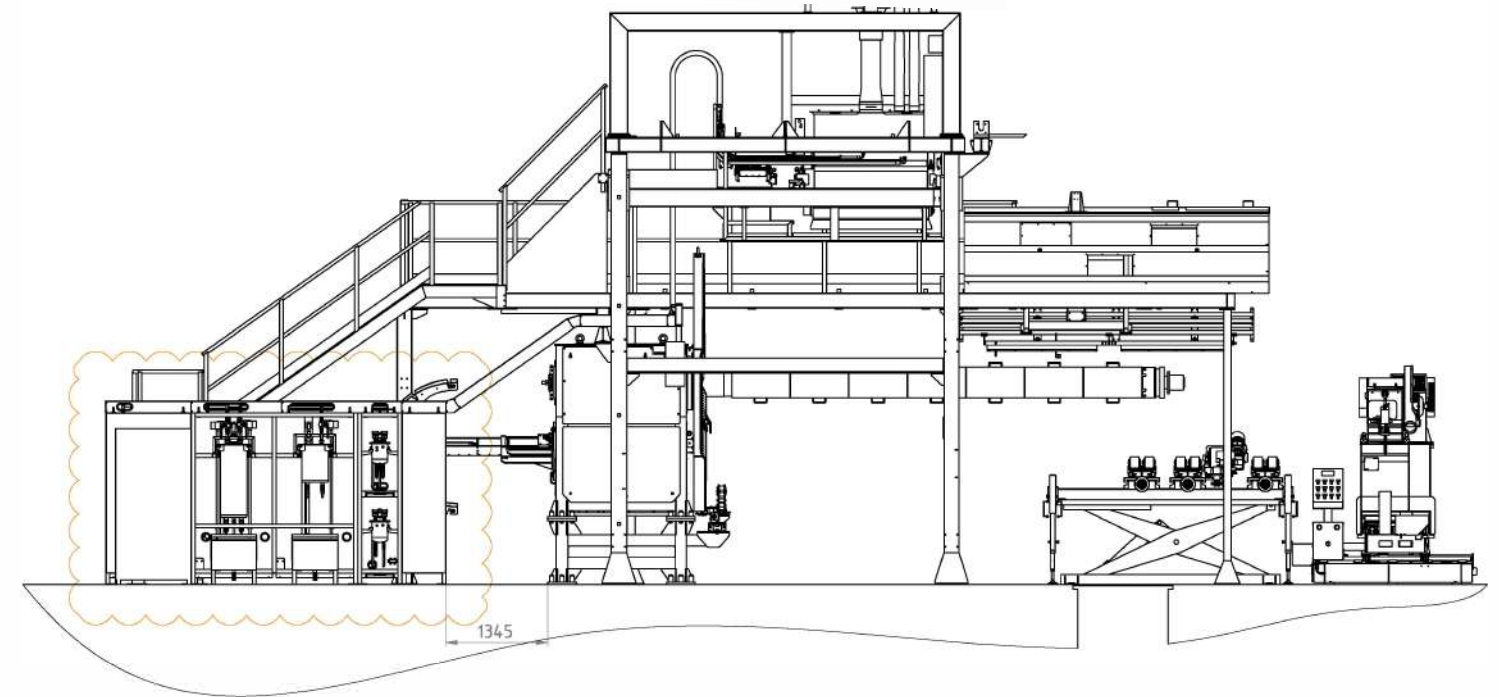
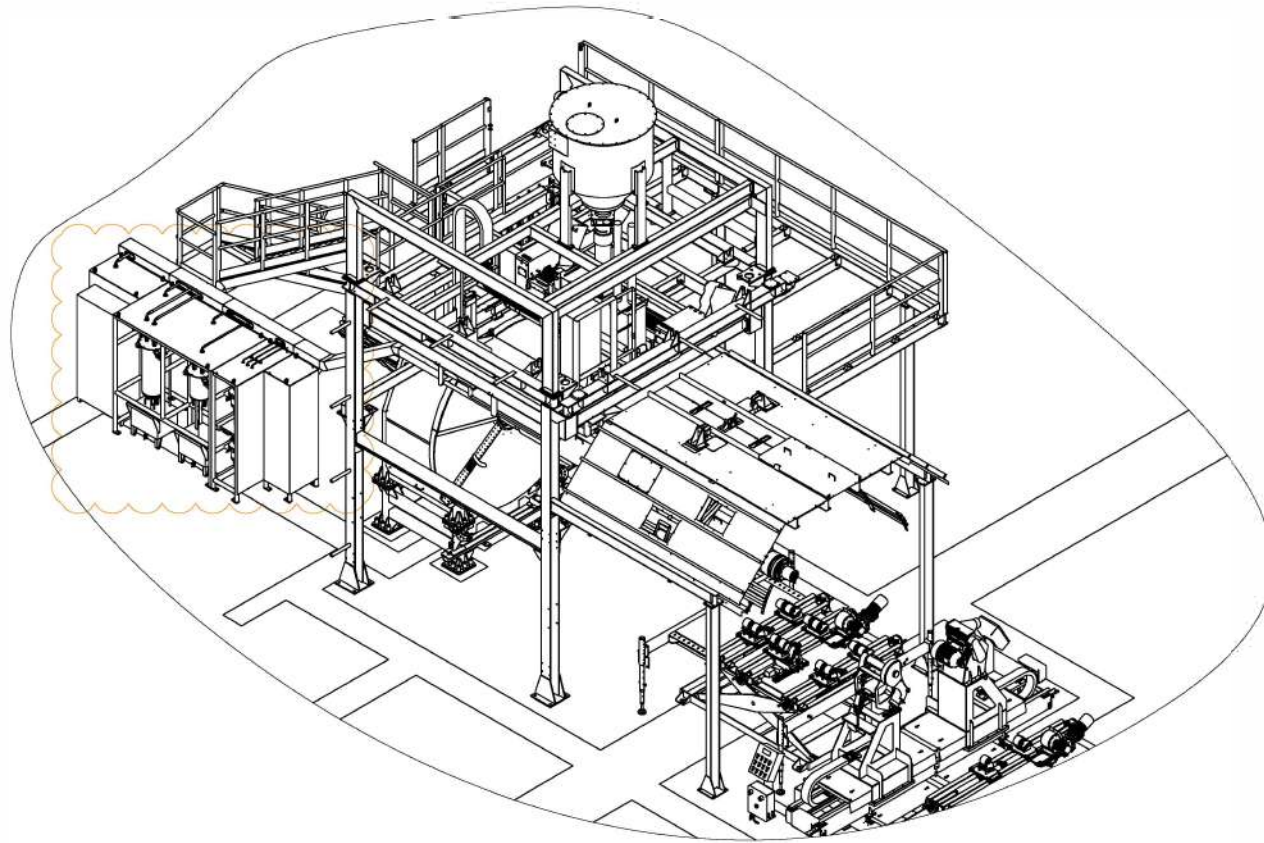


Elevator Top Structure and Sand Receiver

1. Install the Elevator's Top Structure to the Elevator.
2. Install the Sand receiver (see sand Layout)
3. Start with the installation of the Sand Transfer Pipes

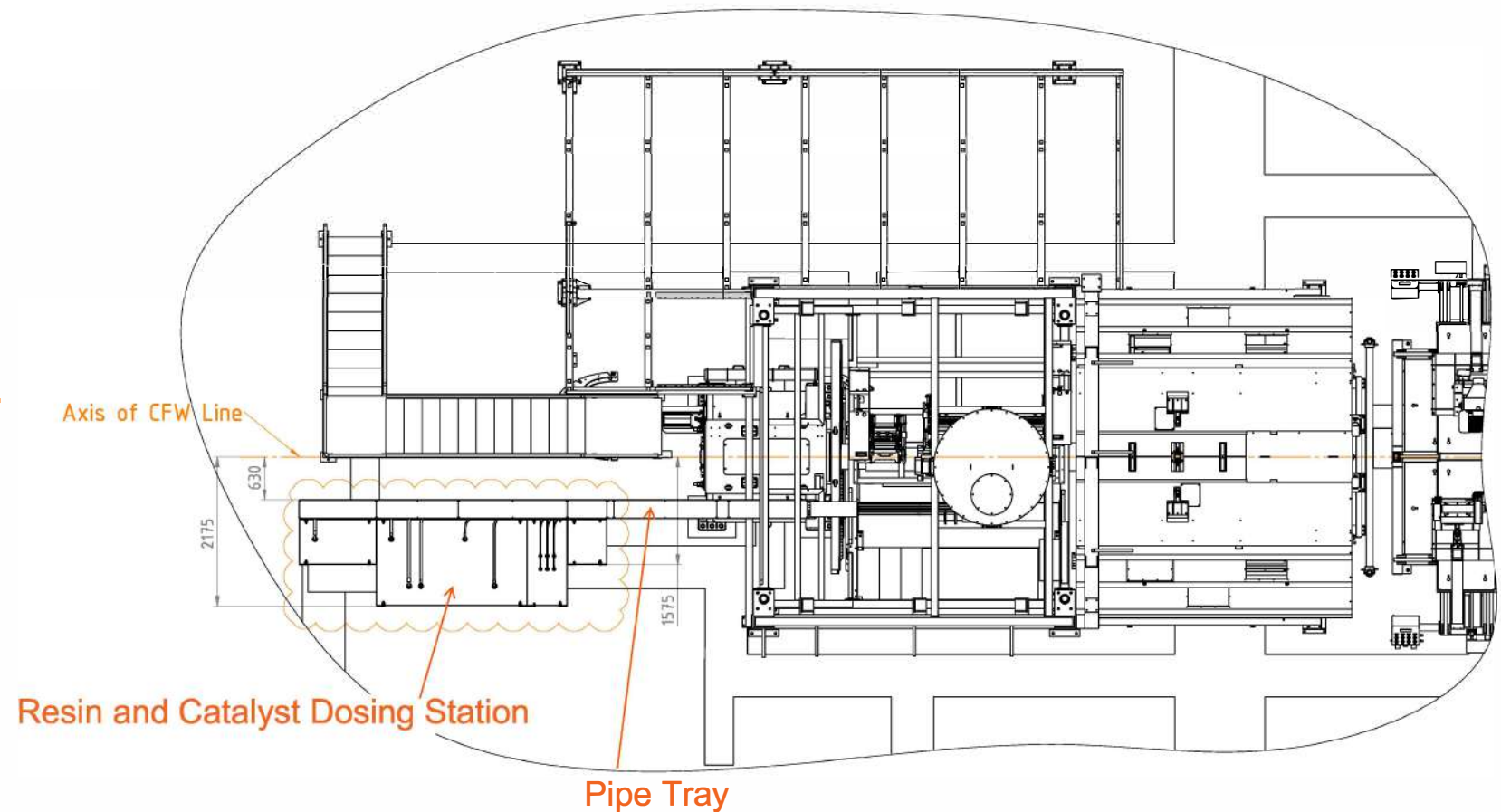


TOPFIBRA
EFFECTIVE FILAMENT WINDING® PIONEERS



Resin and Catalyst Dosing Station and Pipe Tray

1. Position the Dosing Station as shown on the image.
2. Add the Pipe Tray to the top of the Dosing Station and attach to the top plate of Main Casing.



TOPFIBRA
EFFECTIVE FILAMENT WINDING® PIONEERS