

Quick Reference Rigging, Installation & Start-up Guide

LEMAS – 3 Roll & 4 Roll Plate Bending Rolls



Metal
Fabricating
Machinery

Ironworkers

CNC Punch
and Shear

Horizontal
Benders

Angle and Plate
Processing Lines

LEMAS

www.TrilogyMachinery.com

Quick Reference Delivery, Rigging & Start-up Guide

At Trilogy Machinery

After passing our multi-point pre-delivery inspection and testing process, your machine is carefully shrinkwrapped and secured on a pallet.

The machine is then strapped to a flatbed trailer as shown to the right and tarped for protection.



Unloading at your location

It is the owner's responsibility to properly rig the machine off the truck bed and into place. Follow this basic guide and the approximate machine weight, (scan code for weight table) to properly unload your machine from the truck and move it into its final position. Please refer to your bill of lading for the actual shipping weight, which will include the wood pallet, and other accessories.



Recommended Lifting Method – Forklift:

Use of a forklift is recommended to remove the machine from the flatbed and place in its final location (see picture).

- The machine will be centered on the flatbed for shipping. The forks must be able to reach from the edge of the trailer through to the opposite side of the shipping pallet for lifting. 8-foot fork length is recommended.
- This off-set distance must be accounted for when selecting the appropriate lifting weight capacity of the forklift.



WARNING: It is the owner's responsibility to ensure full compliance with all Local, State and Federal safety laws and requirements during machine movement, lifting, loading & unloading.

Placement/Leveling/Anchoring

Reference the installation guide in the owner's manual for full details and requirements.

- Ensure the area around the machine location is clean and clear allowing 360-degree access.
- Before final placement, remove the machine from the wooden shipping pallet and place the machine in the desired location.
- This machine requires a level concrete foundation. While leveling bolts are included with the machine, the provision of anchors and plates (if required) plus their installation is the responsibility of the owner.
- NOTE: The machine should not shift or move during normal operation once the base has been leveled and anchored properly.



www.TrilogyMachinery.com
888.988.7655

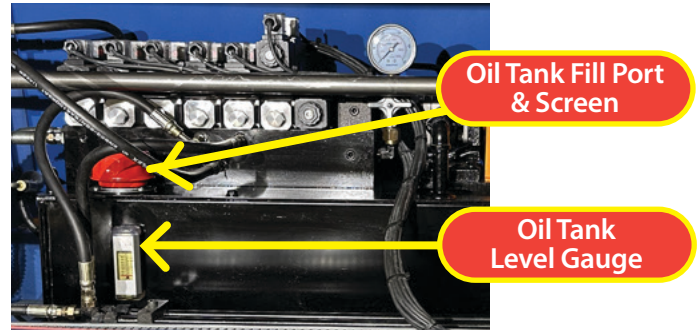


Hydraulic Oil

The oil tank cap features a breather valve, and a small pool of oil might form around the top of the tank, during transport. This is normal – please wipe away with a dry cloth.

- The tank and gauge are located on the same side as the control panel – a 4mm Allen wrench, included in the toolbox, is required to remove the panel fasteners to access.
- Your new machine will be properly filled with hydraulic oil to the $\frac{3}{4}$ level by Trilogy Machinery prior to delivery/install.
- During operation, the oil level may fluctuate to a minor degree above or below the $\frac{3}{4}$ mark which is normal.

- NOTE: When changing the oil on the machine in the future, only use ISO 46 type Hydraulic oil (any brand) and fill to the $\frac{3}{4}$ mark on the site glass.



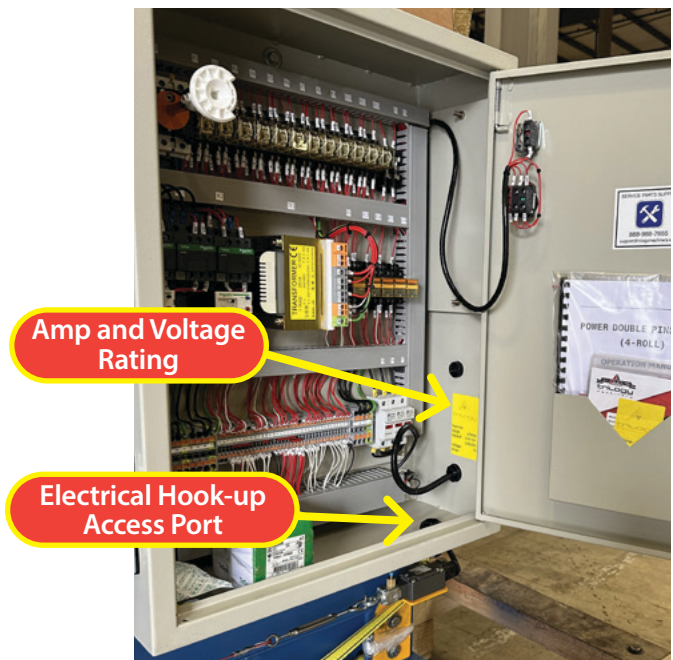
4-TR 200/6 pictured

Electrical Connection

Electric Power hook-up should be performed by a licensed electrician only.

- The AMP and voltage rating of your machine is listed inside the electric box. Always confirm the proper breaker size from the building that feeds the machine, and always use a slow blow breaker.
- Power leads should be delivered to the machine electrical control box (pictured here) from underneath within conduit.
- Be sure to match the voltage supplied with the voltage specified for your machine. The machine voltage data will be on a decal on the exterior electrical box door.
- The electrician should confirm the proper rotation of the main drive motor and hydraulic drive motor. Failure to confirm rotation could result in hydraulic pump damage and/or failure.
- NOTE: Full compliance with Local, State and Federal electrical and fire codes is necessary for the owner.

Electric Box



Complete Installation*

- It is the owner's responsibility to install, adjust & test the machine's emergency-stop trip wire prior to operation of the machine. The owner should adjust/tighten the wire as necessary to ensure easy of activation.
- Start the machine and perform any remaining checks needed from above.
- DO NOT REMOVE OR MODIFY any of the safety equipment or safety decals. If damaged, replace immediately.
- Operate the machine safely per the operation manual.
- NOTE: All hardware on machine is metric – most tools needed are supplied in the machine toolbox included.
- The use of a foot pedal on a bending roll violates our warranty, and our terms and conditions.

*** IMPORTANT: Be sure to scan the QR codes on the front of the machine to access training videos, schematics and manuals!**

Trilogy Machinery Advantages

YOUR METAL FABRICATING MACHINERY SPECIALISTS

Since 2009, we have been committed to providing our customers the highest level of professionalism, integrity and service. This commitment is what helped us to achieve our reputation as a leader in the metal fabricating machinery industry.

www.TrilogyMachinery.com



Links to Training Manuals and Videos



LEMAS
3-Roll Manual



LEMAS 3-Roll
Start-Up and Training Video



LEMAS
4-Roll Manual



LEMAS 4-Roll
Start-Up and Training Video

Contact Information



Technical Support and Service

Service@trilogymachinery.com

LEMAS Parts

Parts@trilogymachinery.com

Product Inquiries

Inquiry@trilogymachinery.com



Office and Showroom

4610 Mercedes Drive, Belcamp, Maryland 21017

PO Box 70, Belcamp, Maryland USA 21017



410.272.3600 | 888.988.7655



FAX 410.272.3601

www.TrilogyMachinery.com
888.988.7655

