

Quick Reference Rigging, Installation & Start-up Guide

Sunrise K-Series and Dual-Cylinder Ironworkers



Metal
Fabricating
Machinery

Ironworkers

CNC Punch
and Shear

Horizontal
Benders

Angle and Plate
Processing Lines

SUNRISE

Quick Reference Rigging, Installation & Start-up Guide

At Trilogy Machinery

After passing our pre-delivery inspection and testing process, your machine is carefully shrink-wrapped along with its operating manuals, tooling, electric back gauge assembly, LED work light, toolbox, foot pedals, and more.

Any additional accessories, such as press brake attachments, may be strapped to the machine, or on a pallet alongside.

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 weight chart below to properly unload your machine from the truck



and move it into its final position. Please note that the machines are very top-heavy, and using a forklift under the machine is not recommended and may result in injury. Care should be taken to secure the

machine properly if using a forklift is the only option. Always use best practices for forklifts and confirm the capacities required before lifting.

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, and unloading.



Recommended Lifting Method – Overhead Crane:

Using appropriately sized* lifting straps or chains and hooks that are in good condition, connect the lifting hook to the integrated lifting eye on top of the machine to lift and move the unit into position.

*Rating is based on local and federal regulations

Approximate Shipping Weight (LBS)*

	Single Cylinder			Dual Cylinder		
	M	K	KB/KBN	S	KD	SD
IW-50	2,075	2,100	–	–	–	–
IW-66	–	2,925	3,160	4,300	–	5,250
IW-88	–	–	–	5,210	–	6,360
IW-95	–	–	–	–	6,400	–
IW-110	–	–	–	7,025	–	8,175
IW-135	–	–	–	7,925	–	9,375
IW-185	–	–	–	–	–	11,600

*Approximate weights do not include additional accessories such as press brake attachments, or other items that may add hundreds of additional pounds. Always refer to the bill of lading for the actual weight.

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 temporary wooden shipping support legs and place the machine in the desired location.

- This machine requires a level concrete foundation. While leveling bolts are included with the machine, the use of anchors and plates (if required) plus their installation are the responsibility of the owner.
- Once secured & leveled, the machine should not shift or move during normal operation.

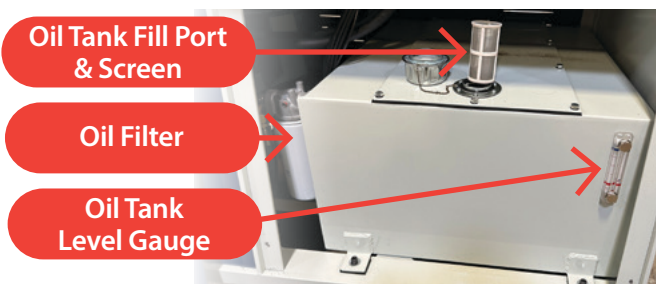
Hydraulic Oil

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

- The tank and gauge are located on the side opposite the control panel behind a blue panel (pictured below) – a 4mm Allen wrench is required to remove the panel fasteners to access this area.
- Your new machine will be properly filled with ISO-46 hydraulic oil* to the $\frac{3}{4}$ level by Trilogy Machinery prior to delivery.

* When allowed by local laws, does not apply to ocean freight items

- During operation, the oil level may fluctuate 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 3/4 on the site glass.

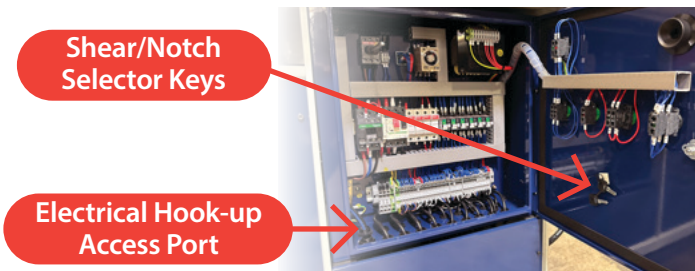
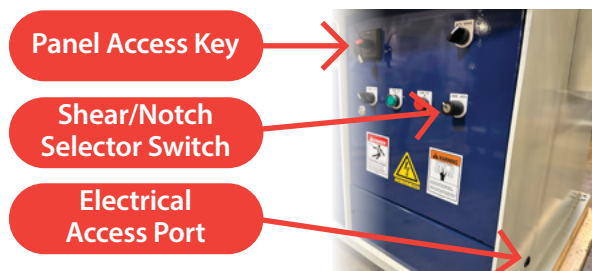


Electrical Connection

Should be performed by a licensed electrician only.

- The amp rating of your machine is listed inside the electric panel door. Always confirm the proper breaker size, and always use a slow blow breaker.
- Power leads should be delivered to the machine within conduit.

- Be sure to match the voltage supplied with the voltage specified for your machine.
- The electrician should confirm the proper rotation of the main motor. Failure to confirm rotation will result in motor burnout or failure.
- Full compliance with Local, State and Federal electrical and fire codes is the responsibility of the owner.



Complete Installation**

- Install tooling and back gauge.
- Start the machine and always be sure to test the punch and die in jog mode to confirm alignment.
- Perform any remaining checks needed from above.

- DO NOT REMOVE OR MODIFY any of the guards or other safety equipment or safety decals. If damaged, replace immediately.
- Operate the machine safely per the operator's manual.
- All hardware is metric and most tools needed are supplied in the toolbox provided.

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.

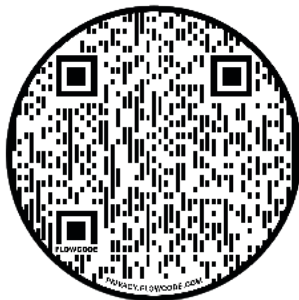
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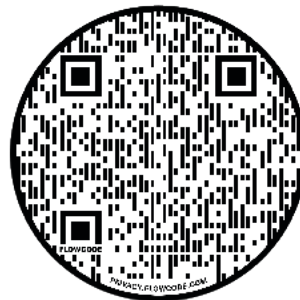
Quick Links



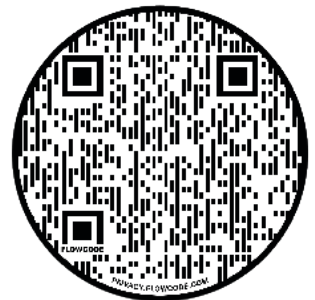
**Sunrise
K-Series Manual**



**Sunrise K-Series
Start-Up and Training Video**



**Sunrise
Dual-Cylinder Manual**



**Sunrise Dual-Cylinder
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Contact Information



Technical Support and Service

Service@trilogymachinery.com

Sunrise Parts

Parts@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

