Standard Operating Procedure (SOP)

This SOP should be consulted during all operations & maintenance of the equipment, however, does not replace the necessary training performed by authorized personnel prior to usage.

<table>
<thead>
<tr>
<th>Equipment Manufacturer:</th>
<th>Formech</th>
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</thead>
<tbody>
<tr>
<td>Model:</td>
<td>Compac Mini</td>
</tr>
<tr>
<td>Process:</td>
<td>Heating, Melting, Molding</td>
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<tr>
<td>Process comments:</td>
<td>This machine heats plastic and uses a mold and vacuum pressure to obtain the desired object.</td>
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</tbody>
</table>

Typical Process Flow Chart:

- Press the power switch ON
- Wait 10-15 minutes for the heaters to reach their operating temperature
- With the heater back and the mold table in the up position, place your mold on it
- Place the table into the lower position by pushing the table lever away from you
- Position a sheet of plastic over the aperture. The plastic should be placed over the white seals around the aperture
- Pull the clamp frame down and close the material clamps
- Adjust the screws on the material clamps if needed
- Set the timer down to zero using the "Down" button to help you establish the time for the heating cycle. If the cycle time is known, press the "Up" button to the right time
- Pull the heater forward over the plastic
- Push the heater back slightly to test the softness of the plastic
- Turn on the vacuum pump and raise the table until you can feel it lock into place
- Let the finished moulding cool down a little before pulling the release valve downwards
- Lower the table and switch off the vacuum
- Release the material clamps to remove the finished molding

Important Reminders:

- Only use for vacuum forming plastic.
- Wear gloves to avoid getting burnt.
- Make sure the clamps are tightened firmly.

Related google search keywords: Thermoforming, Molding, Formech, Vacuum forming, Compac Mini