

# MODEL 30

## THERMOFORMER AND TRIM PRESS



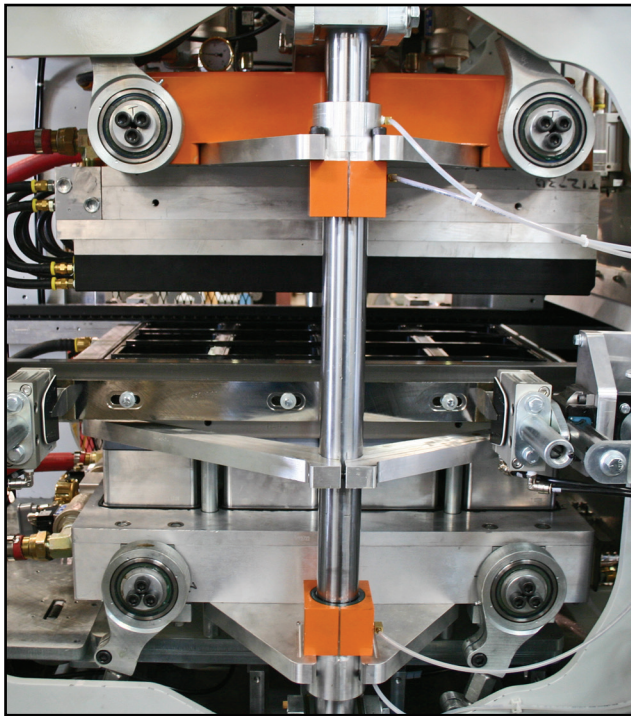
**Irwin**  
Research & Development, Inc.  
**THE ORIGINAL TECHNOLOGY**  
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## THERMOFORMER AND TRIM PRESS

**The Irwin Research and Development Model 30 Thermoformer is designed with continually improving technologies, resulting in a flexible and comprehensive machine for PP, filled PP, APET, CPET, HIPS, OPS, and PS foam processing.**



**Former Side View**

Our patented process control software, "Ballerina", is a crucial part of the Model 30's flexibility, accuracy, and productivity. "Ballerina" is configured for maximum control and power with a Windows XPE® based operating system that incorporates, in cad-cam fashion, point to point construction of a motor motion profile.

**The Model 30 accommodates up to a 32" (813mm) wide mold width for rigid or foam production.**

The Former is available in a configuration utilizing a conventional platen set for mold mounting. This configuration is intended for up to 4" (102mm) deep rigid or foam products. A second Model 30 configuration for deep draw products eliminates platens in favor of connecting the former rod ends directly to the mold. This allows for up to 7" (178mm) deep rigid products in a compact and rigid frame. The mold is specifically designed for this application with innovations that provide a drastic reduction in air consumption, positive clamping, and superior cooling resulting in unparalleled

process control and forming speeds.

Optional entrance and exit sheet cut off knives offer safe and consistent methods of cutting the sheet in case of tunnel melt downs and in preparing the leading edge for feeding into the trim press. A separate water temperature control system for the chain rails allows a higher degree of edge heat control. For fast and effortless adjustment the chain rails can be moved via an electric motor at the feed drive shaft and via low friction ball bearing ways in the forming station. The former chain rail adjust points allow on "the fly" tapering of the chain rails for use in sag control.

**NT Type Mold**





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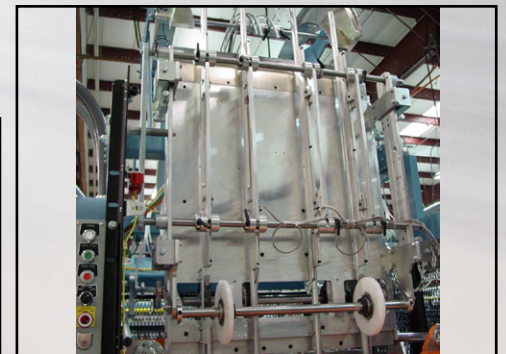
### *Trim Press*

The Model 30 Trim Press is another in the line of the highly successfully and patented NT style trim presses. It joins the proven 28NT, 50NT, 50 NT VTS, 36 Magnum NT, 44NT VTS, and Magnum NT. The lightweight, aluminum-cast platen is driven from four points and in turn drives a linear motion treadle with two connecting rods. The platen, treadle, and tooling are counterbalanced to enhance cutting tonnage, platen/tooling parallelism, and press stability at higher speeds. It also features automatic sheet adjust at the canopy feed, servo pick and a self-feed, "auto start" treadle, which allows automatic threading of the sheet into the treadle sheet guides. The optional linear, rack and pinion driven, servo ejector is highly responsive system for use in tap eject and count eject functions. The Model 30 is the answer to your lower speed, high tonnage applications and your higher speed, up to 200rpm, lighter gauge applications

The technicians in the Irwin Customer Service Department, the fastest most responsive support team in the industry, back the Model 30. In the event of any system failure, Irwin will work with you to provide fast, effective solutions, minimizing down time and returning your machine to full production.



Servo Eject



Servo Pick Index



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## SPECIFICATIONS

### Thermoformer

Entrance Cut Off Knife

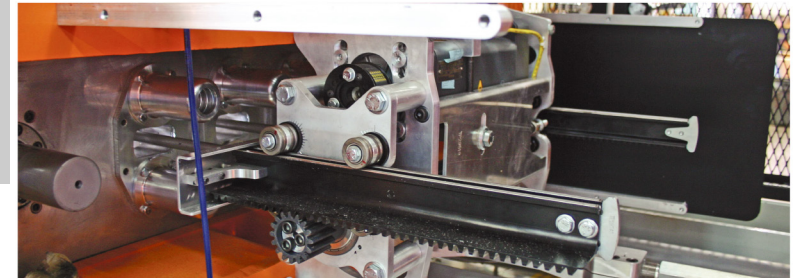


Exit Cut Off Knife

<b>Material Index</b>	<b>Max. Chain Speed</b>	150"/sec. (3810mm/sec.)
	<b>Sheet Width</b>	Max.: 34" (850mm) Min.: 18" (457mm)
	<b>Cut Off Knife</b>	Optional(Entrance & Exit)
<b>Heat Tunnel</b>	<b>Length</b>	200" - 220" (5080mm - 5588mm)
	<b>Heating Element</b>	5/8"(16mm) Diameter Cal Rods
	<b>Temperature Control</b>	Standard B&R X20 PID Control System: +2° at 600°F +1 at 316°C
<b>Former</b>	<b>Sheet Width</b>	34" Maximum (850mm), 18" Minimum (457mm)
	<b>Max. Mold Size</b>	32" Wide (813mm), 40" Long (1016mm)
	<b>Depth of Draw</b>	Platens 4"(101mm) W/O platen 7" (178mm)
	<b>Press Rating</b>	60 Tons
	<b>Shut Height</b>	W/ Platens 14" (356mm) W/O Platens 18" (457mm)
	<b>Platen Travel</b>	8.5" (216mm) Max. Top Platen 8" (203mm) Max. Bottom Platen

### Trim Press

<b>Sheet Width</b>	Maximum 34" (864mm)
<b>Product Depth</b>	Maximum 7" (178mm)
<b>Stroke</b>	6" (152mm) Standard
<b>Maximum Cutting Force</b>	27.5 Tons
<b>Standard Platen Opening</b>	Index Direction 14" (356mm) [20" (508mm) optional], Across Sheet 38.5" (998mm)
<b>Dry Cycle Speed</b>	1-200 cpm
<b>Servo Pick</b>	Standard
<b>Servo Canopy</b>	Standard
<b>Self Feed Treadle(Auto Start)</b>	Standard
<b>Counter Balance Platen Motion</b>	Standard
<b>Shut Height</b>	6" (152.4mm) to 13" (330mm)
<b>Platen Stroke</b>	4" (101.6mm) to 10" (254mm)
<b>Servo Ejector</b>	Optional (Linear Rack/Pinion)



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