

DATE: 01/23/98
*02/18/98

ORDER SPECIFICATION SHEET

CUSTOMER: Komatsu America Ind. Corp.
CUSTOMER P.O.# KLO-1912
CUST. ADD: 199 East Thorndale Ave.
Wood Dale, IL 60191

PERFECTO: 98005
QUOTATION #: 18900-KOM
PREPARED BY: DBS
ORDERS: 98001-98005
REF: 94334-94338

PERFECTO MODEL FES70060 CABINET MOUNTED, SINGLE ROLL,
ELECTRONIC FEED

FEED TO BE USED WITH A: KOMATSU PRESS.
PRESS SPEED: 30 - 80 S.P.M.

SPECIFICATIONS:

Feed Capacity in Pre-Straightened Steel (See below), (See Note 2)
Max. Thickness: .250 X 24 - 38,000 PSI Yield
10 GA. (.1345) X 60 - 45,000 PSI Yield
12 GA. (.1046) X 48 - 45,000 PSI Yield

Max. Width: 60"

Feed roll 7" diameter by full width

Feed length capability: 0 to 99.999 inches with feed length setting
controlled by keypad.

Roll position repeatability \pm .003 at 1200" per minute line speed.
Drive will be Indramat A.C. Servo Motor with controller.

PRODUCTION RATE (180 DEGREE FEED CYCLE)

16 Inches----- 30 S.P.M.
4 Inches----- 80 S.P.M.
***13 Inches----- 40 S.P.M. w/.25 X 24**

MECHANICAL FEATURES:

FEED ROLLS:

Rolls are hardened and have a chrome blast finish. Rolls are
mounted in permanently sealed bearings. Upper feed roll is driven
through cluster gearing. Lower feed roll is belt driven by Gates
"Poly Chain" to motor.

ROLL LIFTERS:

Upper roll is mounted in a rocker assembly with hold down pressure
provided by air cylinders. Roll release is accomplished by spring
force and air pressure. Manual Control is by selector switch.
Lifting is timed and controlled through the press rotary switch.

ANTI BACK UP ROLL ASSEMBLY:

Air loaded roll with integral one way clutch. Increases feed
accuracy when not using pilots and protects pilots and punches when
pulling material from a heavy loop.

FEED DRIVE TRAIN:

Drive is mounted above roll assembly for compact design.

SPECIFICATIONS CONTINUED:

LUBRICATION:

Rollers have permanently lubed, sealed for life bearings. Cluster gearing lubrication is thru an automatic grease dispenser.

MOTORIZED STOCK GUIDE ADJUSTMENT:

Air motors are used to power the adjusting screws for positioning the stock guides. Individual motors are used to allow off center positioning. A digital readout shows position of each stock guide.

CATENARY SUPPORT:

Unit is located on entrance side to assist material in entering feed rolls.

CABINET MOUNT - ADJ PASSLINE:

Feed assembly is mounted on rigid, welded steel cabinet which is designed for bolting to floor. Cabinet is mounted on screw jacks which are driven from one point located opposite operator's side. A ratchet wrench is included for adjustment. Cabinet back has finished surface for attaching connecting brackets to press. Tie bars by Perfecto. Pass line above floor 62" \pm 6".

FEED CONTROLS LOCATED ON ELECTRICAL CONSOLE PANEL INCLUDE:

CTA - Control Keypad	Cycle - Start and Stop
Control - On and off	Feed rolls - open, close and auto
Feed - On and off	Emergency stop
Drive - Fault/Clear	Back Up rolls-Open and close
Manual - Setup and auto	

Console cabinet is a Nema 12 enclosure with fused disconnect. The feed will require two poles on the press rotary cam switch for automatic feed initiate and roll lift.

DRIVE SPECIFICATIONS AND FEATURES INCLUDE:

A.C. Drive Motor has high resolution digital position feedback to the motion controller for increased accuracy. Isolation transformer located outside of cabinet or console.

PENDANT CONTROL - (8 Ft Curly Cord):

Hand held pendant control allows operator to manually (forward/reverse) stock thru the die while standing next to the die at operator's work station.

FEED LENGTH READ OUT:

Read out displays variation of actual lengths fed, vs desired feed length. This gives the operator a visual indication of the feeding accuracy. This feature also includes an anti-runaway control. In the event that the feed drive does misfeed up to \pm 1.0" or run away, the line will automatically shut off. Requires interconnections between the feed and press control.

SPECIFICATIONS CONTINUED:

GUARDING:

To Perfecto's interpretation of ANSI B11.18.

PAINT: Komatsu Cream (82PT-383)

LINE DIRECTION: Left to Right Feeding Back to Front on Press

VOLTAGE: 440-3-60

DELIVERY: 5-29-98

SHIP VIA: Best Way F.O.B. Piqua, Ohio

SHIP TO: Simpson Strong Tie
1425 Moonstone Street
Brea, CA 92661

MARK FOR: P.O. KLO-1912
S/N 98005

NOTE:

- 1) Scribe centerline on equipment.
- 2) 80% of material run will be 12 GA. (.1046)
10% of material run will be .250
1% of material run will be 10 GA. (1345)
- 3) Press prints to follow.