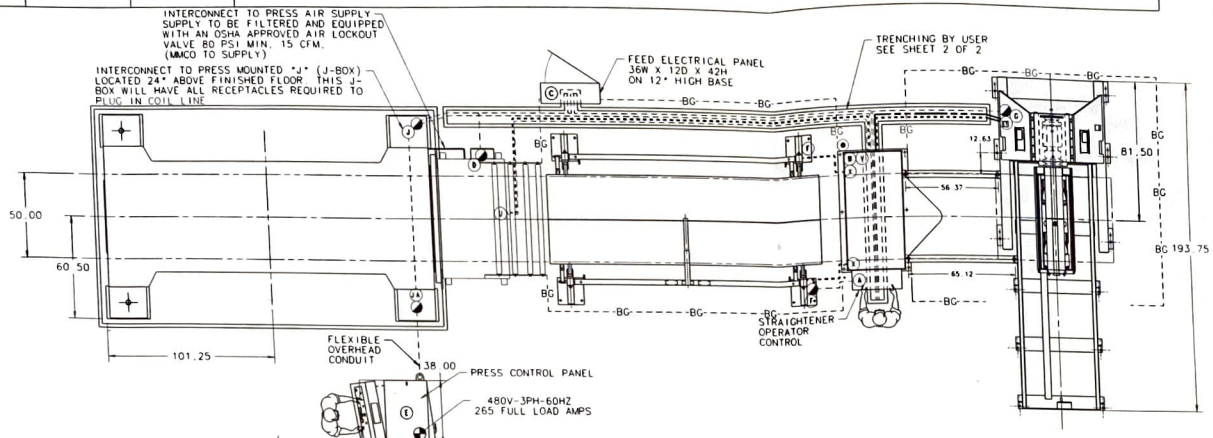
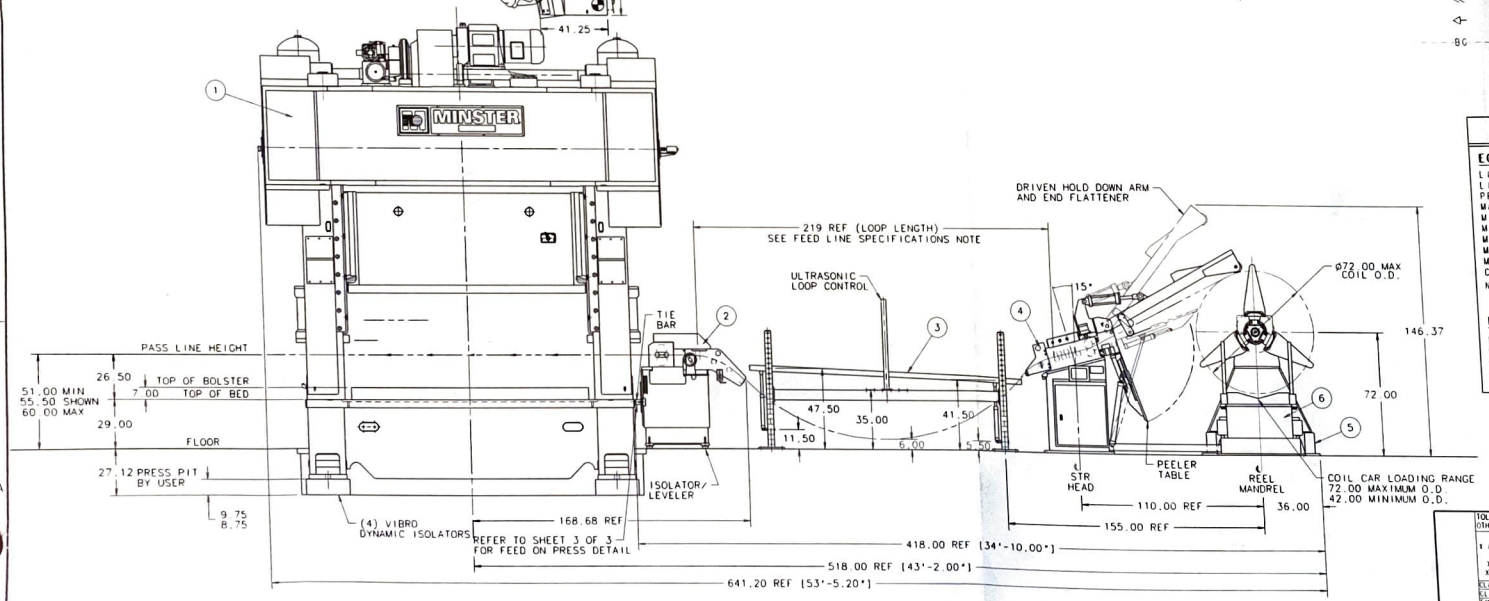
ITEM	DESCRIPTION	MODEL NUMBER	SERIAL NUMBER	REMARKS
1	MINSTER PRESS	E2-600-144X60	30276	SEE PRESS SALES ORDER FOR DETAILS
2	MINSTER MACHINE SINGLE ROLL ELECTRIC FEED	MEF7-50S	18-51161	CHROME BLAST #3 ROLL FINISH, AUTO PASSLINE ADJUSTMENT, AUTO LUBRICATION FROM STRAIGHTENER, HAND CRANK ADJUSTABLE STOCK GUIDES SPECIAL ZERO BACK LASH ROLL LIFT CYLINDER MOUNTING, PRODUCTION MANAGEMENT CONTROL THRU PRESS (PMC) SPECIAL MACHINE FINISH, COIL LINE INTERCONNECTS
3	MINSTER MACHINE THREADING TABLE	MTT14-50D	13-81380	
4	MINSTER MACHINE STRAIGHTENER	MSH30-50-7	13-50766	AUTO WORK ROLL ADJUSTMENT, CHROME BLAST #3 PINCH ROLLS, HAND CRANK ADJUSTABLE STOCK GUIDES, SPECIAL MACHINE FINISH, AUTO LUBRICATION SYSTEM AUTO LUBRICATION TO THE FEED, DRIVEN-HOLDDOWN ARM (9" WIDTH), END FLATTENER AND PEELER TABLE, AUTO LOOP HEIGHT ADJUSTMENT, STR ROLL CLEANER
5	MINSTER MACHINE SINGLE REEL	MRH30-50S	13-70895	SPECIAL MACHINE FINISH, SPECIAL STRAIGHTENER-TO-REEL TIE BAR
6	MINSTER MACHINE COIL CAR	MCCH-35	13-90372	SPECIAL MACHINE FINISH





COIL LINE INTERCONNECTS

RECEPTACLE LOCATION	INTERCONNECT IDENTIFICATION	RECEPTACLE LOCATION
ELECTRICAL		
A1 <<-> A1	STRAIGHTENER PANEL TO FEED PANEL	C7 <<-> C7
A2 <<-> A2	STRAIGHTENER PANEL TO REEL J-BOX	G1 <<-> G1
A3 <<-> A3	STRAIGHTENER PANEL TO THREAD TABLE J-BOX	F1 <<-> F1
A6 ->>> A6	STRAIGHTENER PANEL TO PRESS J-BOX (POWER)	J1 ->>> J1
A7 ->>> A7	STRAIGHTENER PANEL TO FEED PANEL(BLUE HOSE)	C6 ->>> C6
C1 <<-> C1	FEED PANEL TO PRESS J-BOX	J2 <<-> J2
C2 <<-> C2	FEED PANEL TO PRESS J-BOX (BLUE HOSE)	J3 <<-> J3
C4 ->>> C4	FEED PANEL TO PRESS J-BOX (POWER)	J5 ->>> J5
C5 <<-> C5	FEED PANEL TO FEED J-BOX	D1 <<-> D1
C8 <<-> C8	FEED PANEL TO FEED J-BOX (MOTOR POWER CONDUIT)	D3 <<-> D3
C9 <<-> C9	FEED PANEL TO FEED J-BOX (MOTOR FEEDBACK CONDUIT)	D4 <<-> D4
E1 <<-> E1	PRESS PANEL TO PRESS J-BOX	JA <<-> JA
HYDRAULIC		
X1 ->>> X1	STRAIGHTENER TO THREAD TABLE ....A	F2 <<-> F2
X2 ->>> X2	STRAIGHTENER TO THREAD TABLE ....B	F3 <<-> F3
X3 ->>> X3	STRAIGHTENER TO THREAD TABLE ....A	F4 <<-> F4
X4 ->>> X4	STRAIGHTENER TO THREAD TABLE ....B	F5 <<-> F5
X5 ->>> X5	STRAIGHTENER TO REEL (PRESSURE)	Y1 <<-> Y1
X6 ->>> X6	STRAIGHTENER TO REEL (TANK)	Y2 <<-> Y2
X5 ->>> X5	STRAIGHTENER TO FEED (PRESSURE)	U1 <<-> U1
X6 ->>> X6	STRAIGHTENER TO FEED (TANK)	U2 <<-> U2
PNEUMATIC		
W1 ->>> W1	STRAIGHTENER TO REEL	Y3 <<-> Y3
LUBE		
V1 ->>> V1	STRAIGHTENER TO FEED	U3 <<-> U3

INTERCONNECT NOTE

ALL COMPONENTS FOR THE INTERCONNECTION OF HYDRAULIC, PNEUMATIC AND ELECTRICAL BETWEEN PIECES OF EQUIPMENT ARE SUPPLIED BY MINSTER IT IS THE USERS RESPONSIBILITY TO SUPPLY THE REQUIRED ELECTRICAL AND PNEUMATIC SHOP SUPPLY DROPS AS SPECIFIED.

SYMBOL KEY

- INDICATES ELECTRICAL SUPPLY LINES
- INDICATES PNEUMATIC SUPPLY LINES
- INDICATES HYDRAULIC SUPPLY LINES
- LS — INDICATES LUBRICATION SUPPLY LINES
- INDICATES ELECTRICAL DROP 480V-3ø-60HZ
- INDICATES PNEUMATIC DROP 80 PSI, 4 CFM
- INDICATES OPERATOR POSITION
- INDICATES ELECTRICAL TERMINAL BOX
- INDICATES RECEPTACLE WITH FEMALE INSERT
- INDICATES PLUG WITH MALE INSERT
- BG — INDICATES BARRIER GUARDING. ACTUAL BARRIER GUARDING PLACEMENT MAY VARY WITH EACH INSTALLATION. IT IS THE USERS FULL RESPONSIBILITY TO PROVIDE ADEQUATE COIL LINE BARRIER GUARDING PER ANSI B11.18 SPECIFICATIONS AND ALL OTHER APPLICABLE SAFETY STANDARDS.

FEED LINE SPECIFICATIONS

EQUIPMENT

LINE DIRECTION: RIGHT TO LEFT
LINE SPEED: 40-1200 INCHES PER MINUTE
PRESS SPEED: 25-50 SPM
MAX. STOCK WIDTH: 50"
MIN. STOCK THICKNESS: .030"
MAX. STOCK THICKNESS: .240" (LOOP)
MAX. STOCK THICKNESS @ FULL WIDTH: .094" (STR)
MAX. STOCK WIDTH @ .240" THICKNESS: 25" (STR)
MAX. COIL WEIGHT: 31,000 LBS
COIL I.D. RANGE: 20" - 24"
NOTE: ITEMS LISTED WITHIN "( )" INDICATES THE LIMITING FACTOR OF THE LINE CONFIGURATION

LOOP

LOOP STORAGE AVAILABLE OF APPROX. 28" IS BASED ON MAX. MAT'L THICKNESS OF .240" (LOOP) WITH A RECOMMENDED MAX. FEED PROGRESSION OF APPROX. 11"

NOTE: ALL LINE DATA IS CALCULATED FOR MILD STEEL (50,000 PSI YIELD STRENGTH)

TOLERANCES UNLESS OTHERWISE SPECIFIED
MACHINING
1 AND 2 PL ± .100
X.XX ± .010
X.XXX ± .001
X.XXXX ± .0005
CLASS 2B THDS (UNC)
CLASS 6H THDS (UNJ)
FINISH 125 MICROINCHES
BREAK SHARP CORNERS .03
√ .015 √ .015 ⊥ .010

THE MINSTER MACHINE CO.
BEAUTOR, S.C., U.S.A.

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PART NAME: L/O, FLOORPLAN 30276
ACEMCO AUTOMOTIVE
REFERENCE NUMBER
GROUP TECH NUMBER: 9999

SUPERSEDES
SUPERSEDED BY
PATTERN PART NUMBER
ESTIMATED WEIGHT
MATERIAL
DRAWING SCALE: 0312
SHEET NO. 1 OF 3

DRAWING DATE: 2004-08-05
DRAWN BY: KSS
CHECKED BY: XXX
LAST REVISED BY
LAST REVISION DATE
REVISION LEVEL: 000
PART NUMBER: 1272-227