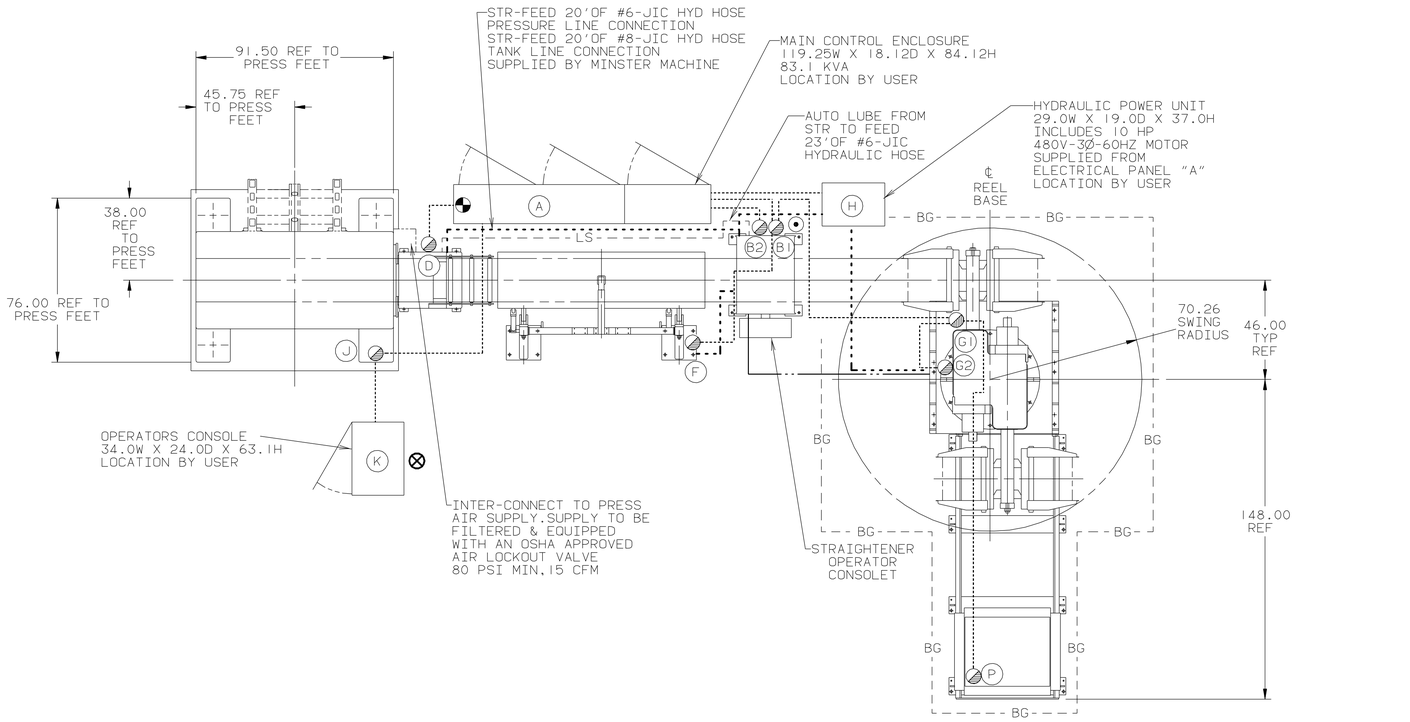
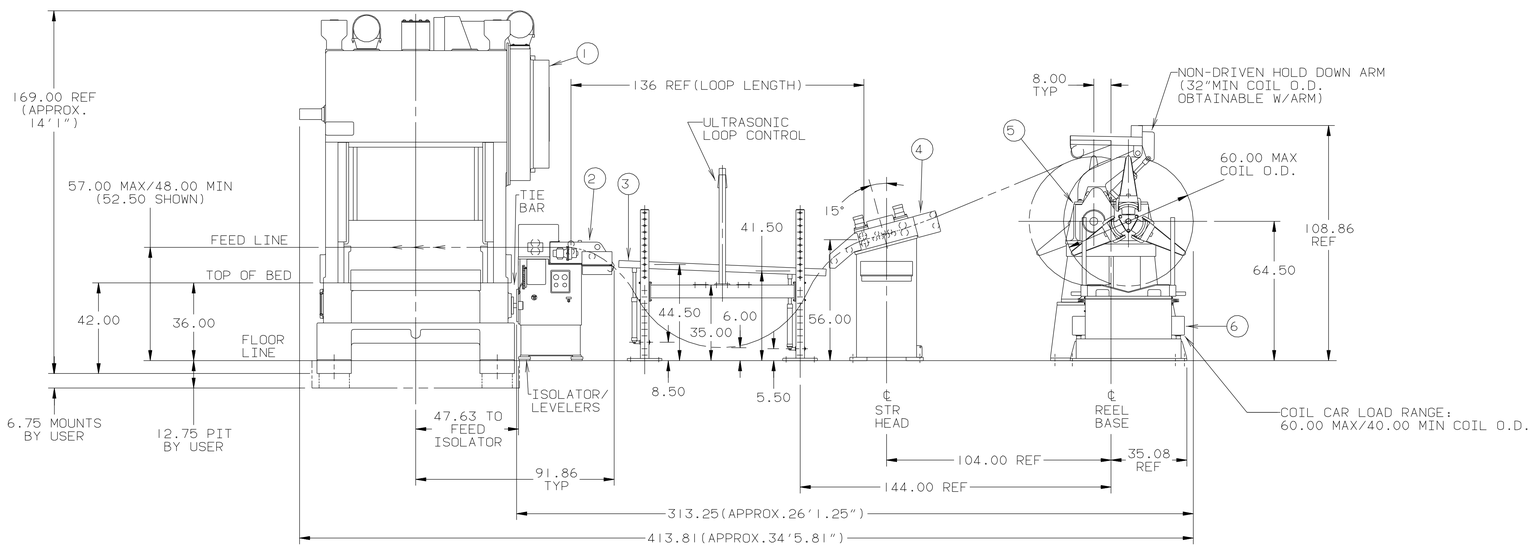
ITEM	DESCRIPTION	MODEL NUMBER	SERIAL NUMBER	REMARKS
1	MINSTER "PIECE-MAKER" PRESS	P2-150-60	28673	
2	MINSTER MACHINE SINGLE ROLL ELECTRIC FEED	MEF4-20	18-50555	MTR PASS LINE ADJ,END OF STK DET,LUBE FROM STR,SMOOTH CHROME ROLL FIN,PASS LINE MTG CLAMPS,DIG PASS LINE READOUT,MTR STK GUIDE ADJ,DIG STK GUIDE READOUT & PLC SFTWR/SPECIAL CONT FEATURES
3	MINSTER MACHINE THREADING TABLE	MTT8-26S	13-81112	
4	MINSTER MACHINE STRAIGHTENER	MS20-20-7	13-50302	MTR WORK ROLL ADJ,DIG ROLL POS READOUT,CLASS'A'LUBE SYS,LUBE TO FEED,MTR STK GUIDE ADJ,DIG STK GUIDE READOUT,AC SERVO STR DR & ULTRASONIC LOOP CONTROL
5	MINSTER MACHINE DOUBLE REEL	MR10-20D	13-70354	OPT'L COIL I.D.EXP OF 16"-20",JOG DR,TWO SETS OF SPC KPRS & THREE SPACER BLOCKS,NON-DR HOLD DOWN ARM & SPECIAL BASE FOR DBL REEL
6	MINSTER MACHINE COIL CAR	MCC2-35	13-90098	





ITEM	DESCRIPTION	REQ'D.

NOTES:

1) ITEMS TO BE SUPPLIED BY USER:
TUBE FOR INTERCONNECTIONS,PIPE,
HOSES,CONDUIT & WIRE.

ELECTRICAL APPROXIMATIONS ARE AS FOLLOWS:

A-B1 MAIN CONTROL ENCLOSURE TO STRAIGHTENER ELECTRICAL TERMINAL BOX (CONTROL WIRING)

A-B2 MAIN CONTROL ENCLOSURE TO STRAIGHTENER AUXILARY ELECTRICAL TERMINAL BOX (MOTOR WIRING)

A-D MAIN CONTROL ENCLOSURE TO FEED ELECTRICAL TERMINAL BOX

A-H MAIN CONTROL ENCLOSURE TO REEL HYDRAULIC POWER UNIT

A-J -K MAIN CONTROL ENCLOSURE TO OPERATORS CONSOLE

B1-G1 STRAIGHTENER ELECTRICAL TERMINAL BOX TO REEL ELECTRICAL TERMINAL BOX

B1-F STRAIGHTENER ELECTRICAL TERMINAL BOX TO THREADING TABLE ELECTRICAL TERMINAL BOX

G1-G2 REEL ELECTRICAL TERMINAL BOX TO REEL ELECTRICAL TERMINAL BOX (CONNECTION SUPPLIED BY MMCO)

G1-P REEL ELECTRICAL TERMINAL BOX TO COIL CAR ELECTRICAL TERMINAL BOX (CONNECTION SUPPLIED BY MMCO)

..... INDICATES ELECTRICAL SUPPLY LINES
—·— INDICATES PNEUMATIC SUPPLY LINES
- - - - INDICATES HYDRAULIC SUPPLY LINES LINES FROM STR TO FEED SUPPLIED BY MMCO AS NOTED

--BG-- INDICATES BARRIER GUARDING TO BE SUPPLIED BY USER
--LS-- INDICATES LUBE SUPPLY LINES SUPPLIED BY MMCO INSTALLED BY USER

◔ INDICATES ELECTRICAL DROP 480V-3Ø-60HZ

⊙ INDICATES PNEUMATIC DROP 80 PSI,4 CFM

⊗ INDICATES OPERATOR

◍ INDICATES ELECTRICAL TERMINAL BOX

2) FOUNDATION ENGINEERING IS RESPONSIBILITY OF USER

FEED LINE EQUIPMENT DATA

LINE DIRECTION: RIGHT-LEFT
LINE SPEED(I.P.M): 60-600
MAX.STOCK WIDTH: 20"
MIN.STOCK THICKNESS: .020"
MAX.STOCK THICKNESS @ FULL WIDTH: .090"(FEED)
MAX.STOCK THICKNESS: .187"(FEED)
MAX.STOCK WIDTH @ FULL THICKNESS: 9"(FEED)
MAX.COIL WEIGHT: 10,000 LBS
COIL I.D. RANGE: 16-20"

LINE DATA

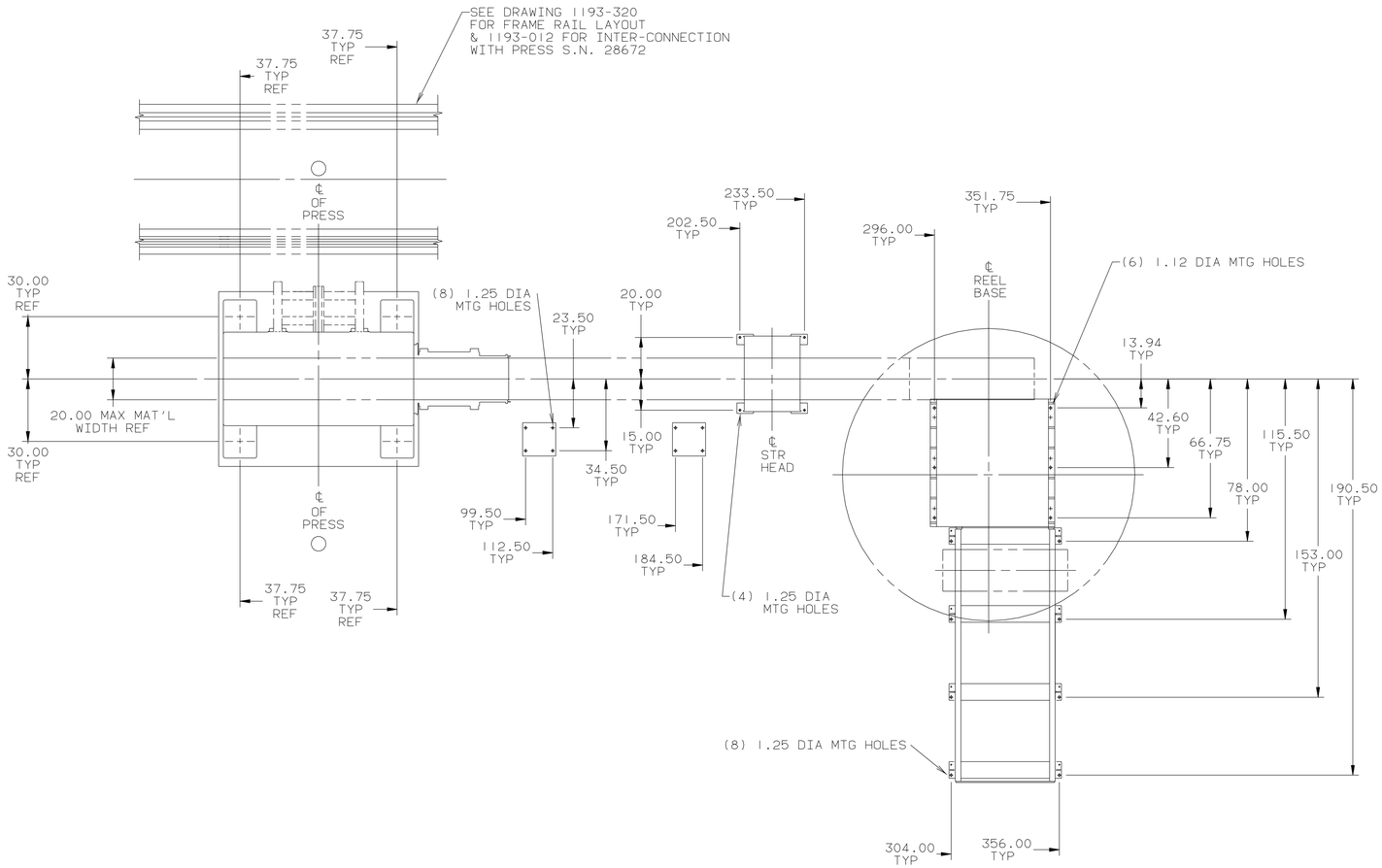
LOOP STORAGE AVAILABLE OF 41" IS BASED ON MAX. MAT'L THICKNESS OF .062" WITH A RECOMMENDED MAX. FEED PROGRESSION OF 16"

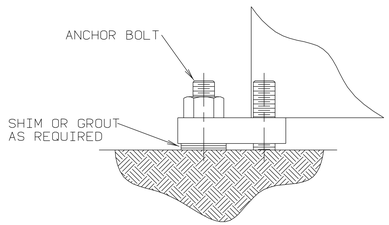
NOTE: ALL LINE DATA IS CALCULATED FOR MILD STEEL

3) REFER TO DRWG 1193-012 FOR CORRECT INTER-CONNECTION WITH PRESS S.N. 28672

EST. WEIGHT	RAW MATERIAL WEIGHT	UNLESS OTHERWISE SPECIFIED	THE MINSTER MACHINE CO.	LAST REV. DATE 11-29-95
GROUP TECH NO		DIMENSION / TOLERANCE	BEAUFORT, SOUTH CAROLINA	REV. LEVEL 001	CHANGED BY LEB
REFERENCE NO		X AND X.X 0.100	©1995 THE MINSTER MACHINE COMPANY THIS DOCUMENT IS THE EXCLUSIVE PROPERTY OF THE MINSTER MACHINE COMPANY ANY DISCLOSURE, DISTRIBUTION AND/OR REPRODUCTION WITHOUT THE EXPRESS WRITTEN CONSENT OF THE MINSTER MACHINE COMPANY IS PROHIBITED ALL RIGHTS RESERVED		
SUPERSEDED BY		X.XX 0.010			
SUPERSEDES		X.XXX 0.001			
PATTERN FILE NO		X.XXXX 0.0005	DATE 01-18-95	DRAWN BY IDS	CHECKED BY PRM	SCALE .031
PATTERN BASIC NO		FINISH 125 MICROINCHES	NAME OF PART L/O,FLOOR PLAN		
		BREAK SHARP CORNERS 0.03	MATERIAL	PATT NO	SHEET 1 OF 2
			NO REQ'D D	PART NO 1193-011	

ITEM	DESCRIPTION	REQ'D.





LEVELING & ANCHORING DETAIL

AFTER MACHINE HAS BEEN LEVELED, SHIM OR GROUT UNDER THE FOOT AT THE ANCHOR LOCATION AS SHOWN

ANCHORING SPECIFICATIONS FOR MATERIAL HANDLING EQUIPMENT

ANCHOR HOLE	ANCHOR SIZE	MINIMUM ULTIMATE PULLOUT
0.625	0.500	7,000 LBS
0.750	0.625	9,000 LBS
0.875	0.750	12,000 LBS
1.00	0.875	18,000 LBS
1.125-1.250	1.00	20,000 LBS
1.375-1.500	1.25	27,000 LBS

NOTE: IT IS THE CUSTOMERS RESPONSIBILITY TO FURNISH ADEQUATE FOUNDATION AND HARDWARE TO ANCHOR EQUIPMENT TO THE ABOVE SPECIFICATIONS. ABOVE SPECIFICATIONS ARE FOR MATERIAL HANDLING EQUIPMENT.
FOR SPECIFICATIONS ON MOUNTING PRESSES REFER TO MINSTER PRESS INFORMATION.

EST. WEIGHT | RAW MATERIAL WEIGHT
GROUP TECH NO
REFERENCE NO
SUPERSEDED BY
SUPERSEDES
PATTERN FILE NO
PATTERN BASIC NO

UNLESS OTHERWISE SPECIFIED	
DIMENSION	TOLERANCE ±
X AND X.X	0.100
X.XX	0.010
X.XXX	0.001
X.XXXX	0.0005
FINISH 125 MICROINCHES	
BREAK SHARP CORNERS 0.03	

THE MINSTER MACHINE CO. | LAST REV. DATE 11-29-95

BEAUFORT, SOUTH CAROLINA | REV. LEVEL 001 | CHANGED BY LEB

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DATE	DRAWN BY	CHECKED BY	SCALE
01-18-95	IDS	PRM	.031

NAME OF PART: L/O, FLOOR PLAN

MATERIAL | PATT. NO | SHEET 2 OF 2

NO. REQ'D: D | PART NO: 1193-011