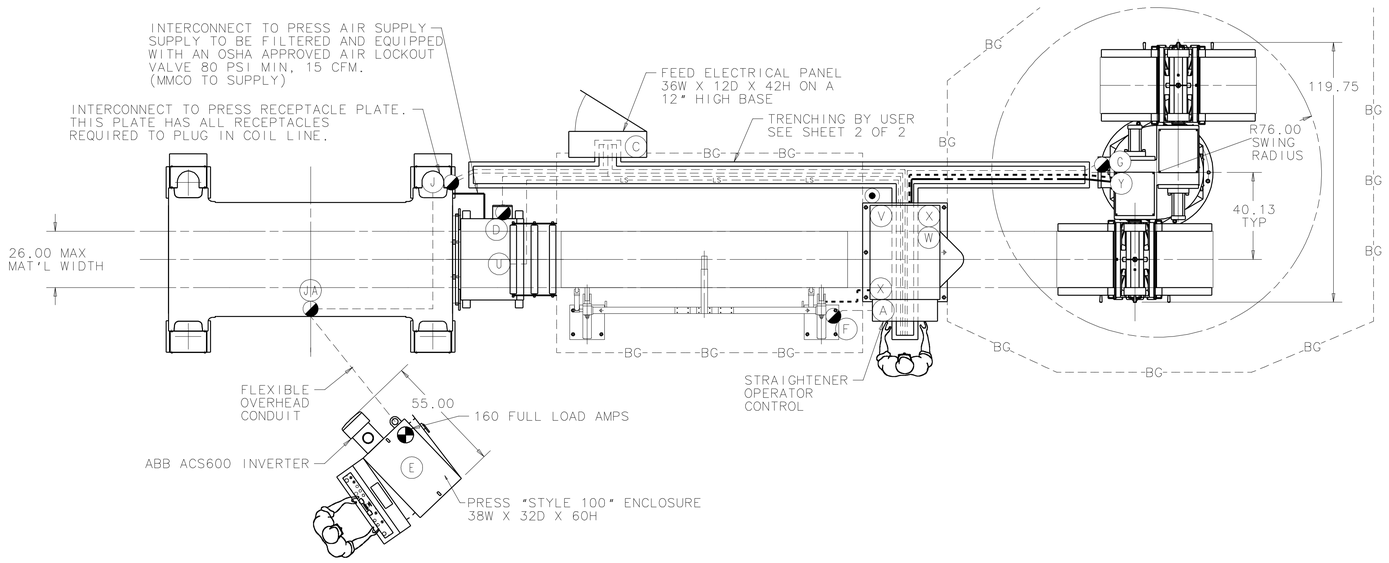
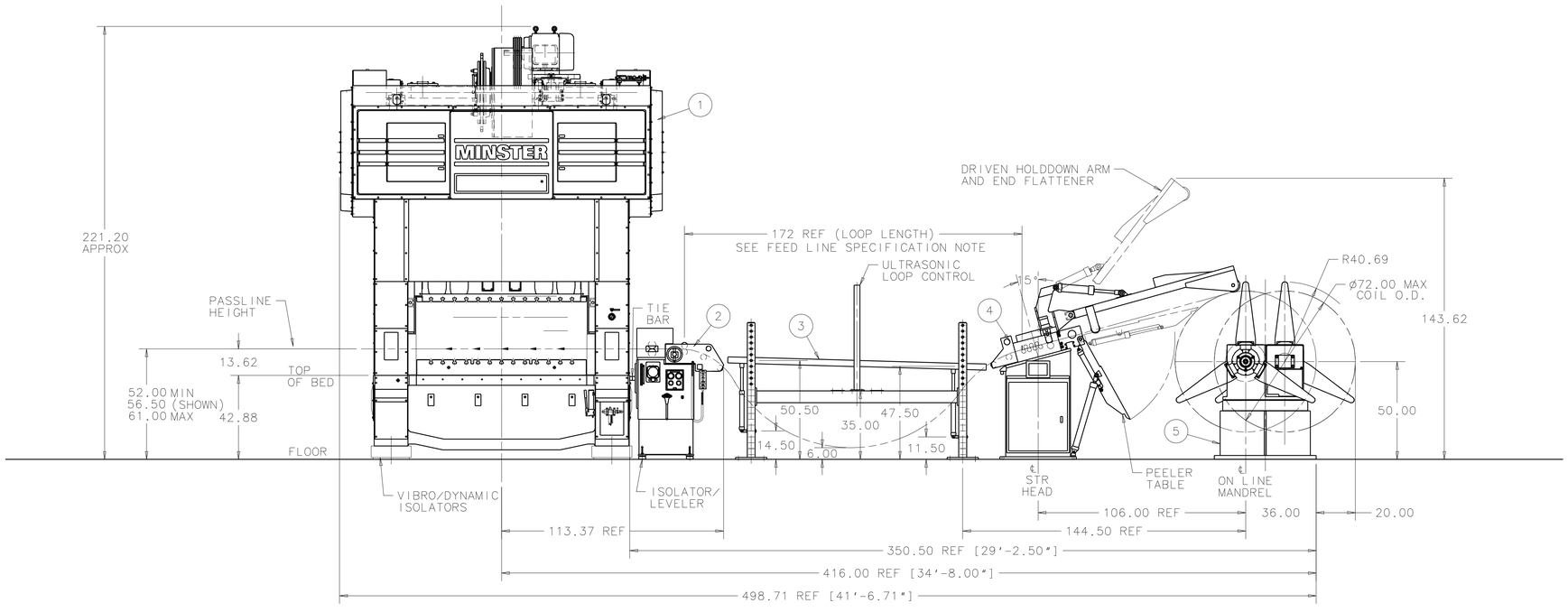
ITEM	DESCRIPTION	MODEL NUMBER	SERIAL NUMBER	REMARKS
1	MINSTER PRESS	E2H-350-86X47-SG	30186	SEE PRESS SALES ORDER FOR DETAILS
2	MINSTER MACHINE SINGLE ROLL ELECTRIC FEED	MEF4-26S	18-51108	AUTO LUBE FROM STRAIGHTENER, HAND CRANK ADJUSTABLE STOCK GUIDE, FEED OPERATOR CONTROL: PRESS PMC COIL LINE INTERCONNECT
3	MINSTER MACHINE THREADING TABLE	MTT11-26S	13-81355	
4	MINSTER MACHINE STRAIGHTENER	MSH20-26-7	13-50736	QUARTER TURN STOCK GUIDE ADJUSTMENT, AUTOMATIC LUBE SYSTEM, AUTOMATIC LUBRICATION TO FEED DRIVEN HOLDDOWN ARM (5" WIDTH) W/PEELER TABLE & END FLATTENER, COIL LINE INTERCONNECTS
5	MINSTER MACHINE SINGLE REEL	MRH10-26D	13-70850	COIL LOAD POSITION - OPPOSITE OPERATOR





ITEM	DESCRIPTION	REQ'D.

COIL LINE INTERCONNECTS

RECEPTACLE LOCATION	ELECTRICAL	INTERCONNECT IDENIFICATION	RECEPTACLE LOCATION
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 RECEPTACLE(PWR)	J1 / J1
A7	A7	STRAIGHTENER PANEL TO FEED PANEL(BLUE HOSE)	C6 / C6
A8	A8	STRAIGHTENER PANEL TO REEL J-BOX.(DBL REEL)	G2 / G2
C1	C1	FEED PANEL TO PRESS RECEPTACLE PLATE	J2 / J2
C2	C2	FEED PANEL TO PRESS RECEPTACLE (BLUE HOSE)	J3 / J3
C4	C4	FEED PANEL TO PRESS RECEPTACLE PLATE (PWR)	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
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 RESPONSIBILTY 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 LUBRICATTION SUPPLY LINES
- INDICATES ELECTRICAL DROP 480V-3Ø-60HZ, 160 F.L.A.
- 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

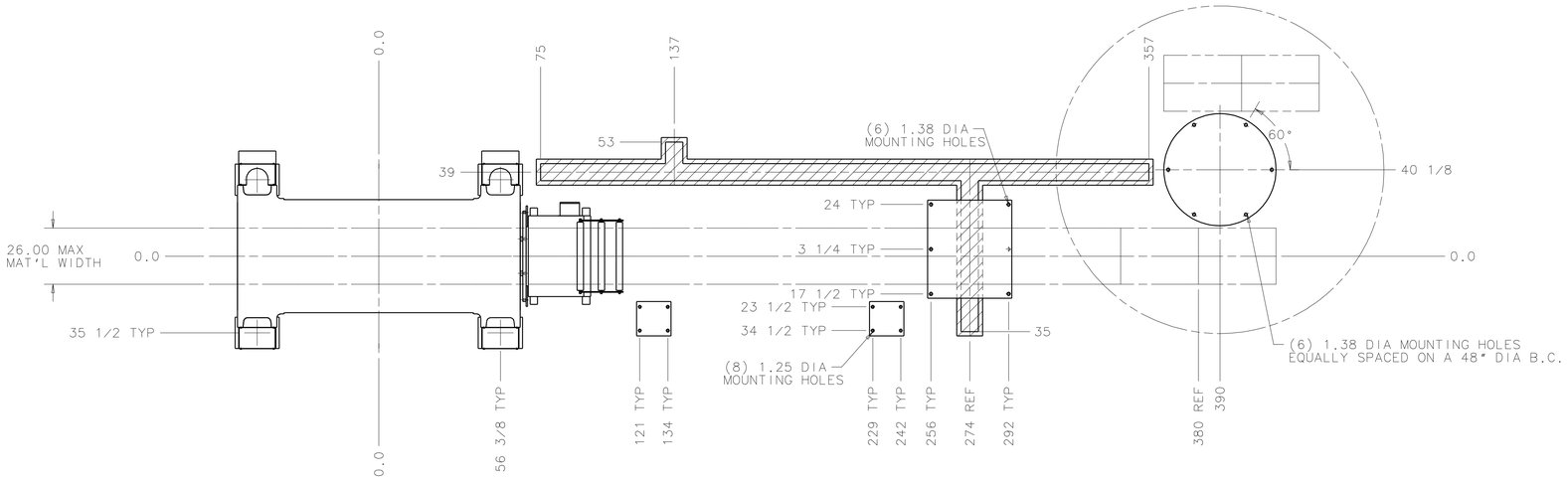
LINE DIRECTION: RIGHT TO LEFT
LINE SPEED: 40-1200 INCHES PER MINUTE
PRESS SPEED: 45-130 SPM
MAX. STOCK WIDTH: 26.00"
MIN. STOCK THICKNESS: .020"
MAX. STOCK THICKNESS: .130" (LOOP)
MAX. STOCK THICKNESS @ FULL WIDTH: .062" (STR)
MAX. STOCK WIDTH @ .130" THICKNESS: 11.00" (STR)
MAX. COIL WEIGHT: 14,000 LBS
COIL I.D. RANGE: 16.00"-20.00"
NOTE: ITEMS LISTED WITHIN "( )" INDICATES THE LIMITING FACTOR OF THE LINE CONFIGURATION

LOOP

LOOP STORAGE AVAILABLE OF APPROX 37" IS BASED ON MAX. MAT'L THICKNESS OF .130" (LOOP) WITH A RECOMMENDED MAX FEED PROGRESSION OF APPROX 15°.
NOTE: ALL LINE DATA IS CALCULATED FOR MILD STEEL (50,000 PSI YIELD STRENGTH)

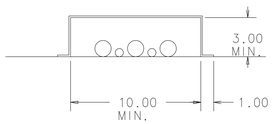
TOLERANCES UNLESS OTHERWISE SPECIFIED MACHINING X AND X.X ±.100 X.XX ±.010 X.XXX ±.001 X.XXXX ±.0005 CLASS 2B THDS (INCH) CLASS 6H THDS (MM) FINISH 125 MICRONCHES BREAK SHARP CORNERS .03 ⌭.015 ⌭.015 ⊥.015	THE MINSTER MACHINE CO. BEAUFORT, S.C. U.S.A. ©THE MINSTER MACHINE CO. THIS DOCUMENT IS THE EXCLUSIVE PROPERTY OF THE MINSTER MACHINE CO. ANY DISCLOSURE, DISTRIBUTION AND/OR REPRODUCTION WITHOUT THE EXPRESS WRITTEN CONCENT OF THE MINSTER MACHINE COMPANY IS PROHIBITED. ALL RIGHTS RESERVED. PART NAME L/O, FLOORPLAN REFERENCE NUMBER GROUP TECH. NUMBER 9999	SUPERSEDES SUPERSEDED BY PATTERN PART NUMBER ESTIMATED WEIGHT MATERIAL DRAWING SCALE .03125 D SHEET NO. 1 OF 2 SHEETS	DRAWING DATE 2003-02-24 DRAWN BY KSS CHECKED BY XXX LAST REVISED BY KSS LAST REVISION DATE 2003-03-11 REVISION LEVEL 001 PART NUMBER 1271-592

ITEM	DESCRIPTION	REQ'D.

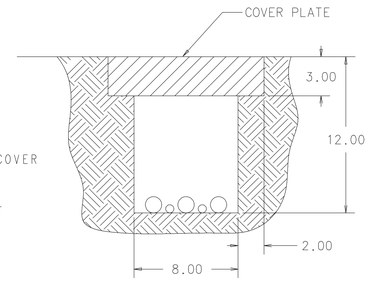


INTERCONNECT ROUTING OPTIONS

ABOVE FLOOR
INTERCONNECT COVER



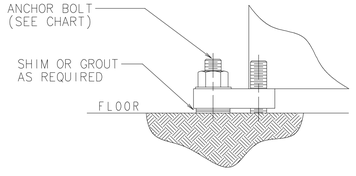
BELOW FLOOR
INTERCONNECT TRENCH



NOTE:
1. IT IS THE CUSTOMERS RESPONSIBILITY TO PROVIDE THE REQUIRED TRENCHING, FLOOR COVER PLATES AND/OR INTERCONNECT COVERS.
2. IT IS THE CUSTOMERS RESPONSIBILITY TO ABIDE BY ALL DIMENSIONAL DATA ON THIS FLOORPLAN TO ASSURE PROPER INTERCONNECT

EQUIPMENT LEVELING & ANCHORING

ANCHORING DETAIL



ANCHORING SPECIFICATIONS

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
1.375-1.50	1.25	27,000 LBS

NOTE:
1. AFTER MACHINE HAS BEEN LEVELED, SHIM OR GROUT UNDER THE FOOT AT THE ANCHOR LOCATION AS SHOWN.
2. IT IS THE CUSTOMERS RESPONSIBILITY TO FURNISH ADEQUATE FOUNDATION AND HARDWARE TO ANCHOR EQUIPMENT TO THE ABOVE SPECIFICATIONS.
3. FOR SPECIFICATIONS ON MOUNTING PRESSES REFER TO MINSTER PRESS INFORMATION.

FOUNDATION WORK

ALL FOUNDATION WORK IS THE RESPONSIBILITY OF THE USER. THIS INCLUDES ANY AND ALL PITS, TRENCHING, FLOOR COVER PLATES, AND EQUIPMENT ANCHORING.

TOLERANCES UNLESS OTHERWISE SPECIFIED
MACHINING
X AND X.X ±.100
X.XX ±.010
X.XXX ±.001
X.XXXX ±.0005
CLASS 2B THDS (INCH)
CLASS 6H THDS (MM)
FINISH 125 MICROINCHES
BREAK SHARP CORNERS .03
⌀.015 ∠.015 ⊥.015

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

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PART NAME: L/O, FLOORPLAN
REFERENCE NUMBER
GROUP TECH. NUMBER: 9999
SUPERSEDES
SUPERSEDED BY
PATTERN PART NUMBER
ESTIMATED WEIGHT
MATERIAL
DRAWING SCALE: .03125
SHEET NO. 2 / 2 OF SHEETS
DRAWING DATE: 2003-02-24
DRAWN BY: KSS
CHECKED BY: XXX
LAST REVISED BY: KSS
LAST REVISION DATE: 2003-03-11
REVISION LEVEL: 001
PART NUMBER: 1271-592