

DWG. NO. D-103021				
DATE	EC. NO.	SYM.	REVISION	BY
9-18-93		A	UPDATE PER APPROVAL	JAS

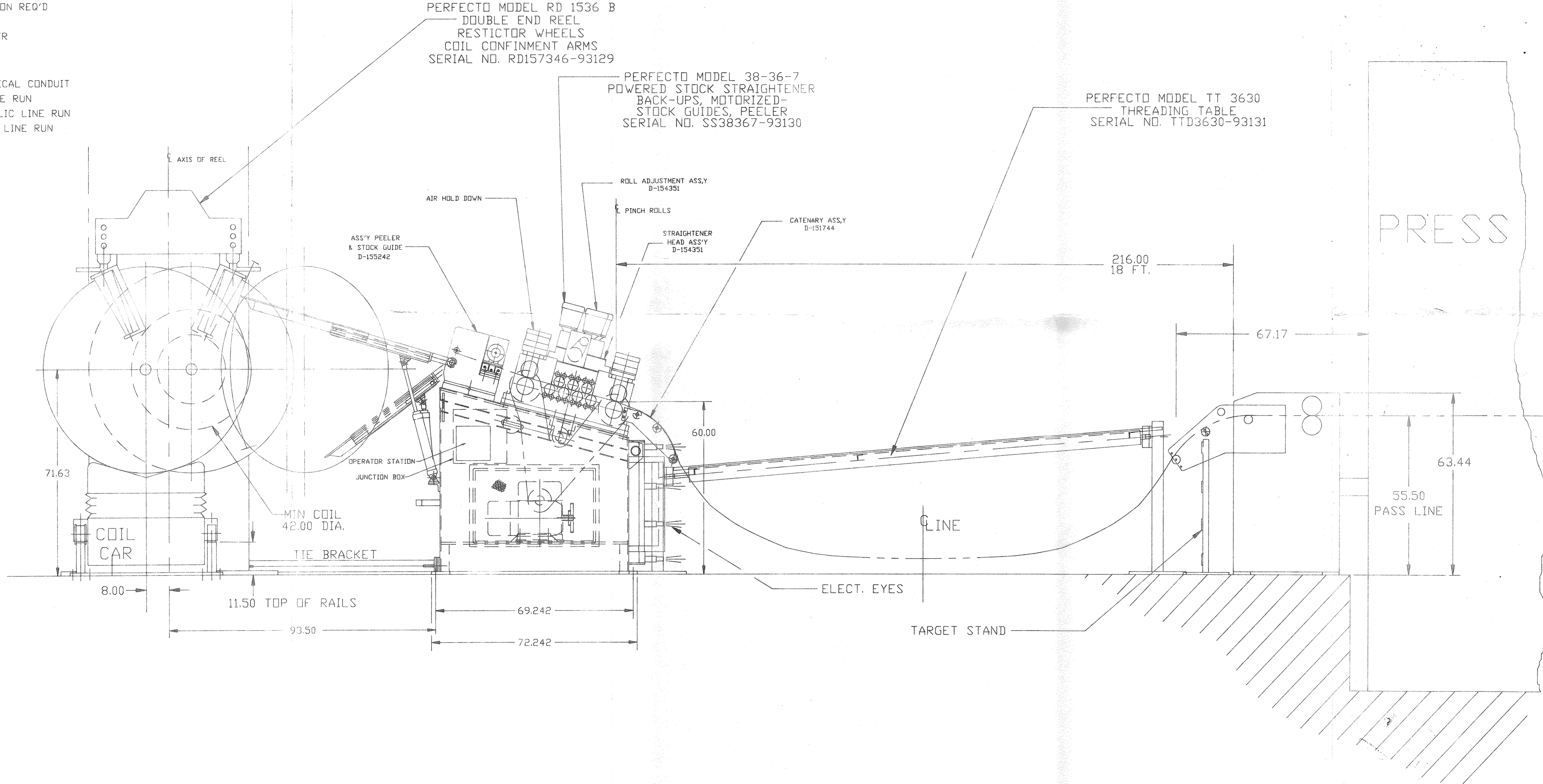
COIL DATA:
 MIN. O.D. 42.00 MAX. O.D. 72.00
 MIN. I.D. 20.00 MAX. I.D. 24.00
 MAX. THK. .375
 MAX. WIDTH 36.00 STRAIGHTENER
 MAX. WIDTH 36.00 THRD. TABLE
 MAX. WIDTH 36.00 REEL & CAR
 MAX. WIDTH 32.00 FEED UNIT
 MAX. WEIGHT LBS. 15,000

LINE DATA:
 MAX. LINE SPEED IPM 800 FPM 67
 MIN. LINE SPEED IPM 300 FPM 25
 FEED DIRECTION L TO R
 VOLTAGE 480 PH 3 HZ 60
 KVA 60 APX. PSI 80 CFM 10

- INSTALLATION INSTRUCTIONS
1. FEED ROLLS SHALL BE PARALLEL TO DIE WITHIN .005 TOTAL INDICATOR READOUT.
 2. LOOP CONTROL STAND ROLLS OR LUBRICATOR ROLLS SHALL BE PARALLEL TO FEED ROLLS WITHIN .030 TOTAL INDICATOR READOUT.
 3. REEL MANDREL SHAFT SHALL BE PARALLEL TO LOOP CONTROL STAND ROLLS OR LUBRICATOR ROLLS WITHIN .030 TOTAL INDICATOR READOUT.
 4. ZERO ON REEL SCALE MUST MATCH CENTERLINE OF STOCK.
 5. COIL CAR TRACK SHALL BE PARALLEL TO REEL MANDREL WITHIN .030 TOTAL INDICATOR READOUT.
 6. CENTERLINE OF EQUIPMENT SHALL BE PERPENDICULAR TO PRESS AND DIE WITHIN .030 TOTAL INDICATOR READOUT.
 7. CENTERLINES SHOULD ALSO BE CHECKED FROM ROLL SURFACES.
 8. DO NOT ASSUME EQUIPMENT IS IN FINAL ALIGNMENT BECAUSE IT IS BOLTED DOWN ACCORDING TO FLOOR PLAN PARALLELISM BETWEEN ROLLS AND SHAFTS MUST BE MAINTAINED.
 9. DO NOT FINAL ALIGN DOUBLE END REELS UNTIL UNDER POWER AND SURE SHOTPIN IS IN PLACE.
 10. DO NOT GROUT EQUIPMENT UNTIL FINAL ALIGNMENT IS COMPLETE.
 11. ALL INTERCONNECTIONS SHALL BE IN ACCORDANCE WITH (N.E.C. APT 300) J.I.C. AND ALL OTHER STATE AND LOCAL CODES.
 12. IT IS RECOMMENDED THAT THE MOUNTING HOLES BE SPOTTED IN THE FLOOR AT THE TIME OF INSTALLATION.

NOTE:
 CENTERLINE OF FEED AND PRESS TO BE PARALLEL TO NORTH AND SOUTH COLUMN LINES IN PLANT.

- KEY:
- ⊕ AIR SUPPLY CONNECTION .50" PIPE
 - ⊙ ELECTRICAL POWER CONNECTION
 - ⊠ ELECTRICAL JUNCTION BOX
 - ⊗ FURNISHED BY USER
 - ⌒ FLEXIBLE CONNECTION REQ'D
 - ANCHOR BOLT
 - ☆ DETERMINED BY USER
 - LOCATE BY USER
- E--- ELECTRICAL CONDUIT
 ---A--- AIR LINE RUN
 ---H--- HYDRAULIC LINE RUN
 ---G--- GREASE LINE RUN



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REF: D-102812

MACHINE NOTES 1. REMOVE ALL UNNECESSARY SHARP EDGES 2. MARK PART NO. ALL DETAILS		ITEM/SYS	QTY.	IDENTITY NO.	DESCRIPTION	MANUFACTURER & NO. SIZE
SUGGESTED SUPPLIER		INCHES	MILLIMETERS	CHECK	TITLE FLOOR PLAN ATWOOD AUTOMOTIVE STOCKTON, IL	
XX	*04	X	*01	APP.	BY J.A.S. DATE 8-16-93	
XXX	*004	XX	*001	APP.	JOB NO. 93128-31	
XXXX	*0004			SCALE 1=20	SHT. A OF B DRAWING NO. D-103021	
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