

DWG.
NO.

APPROVAL ONLY

APPROVED AND UNDERSTOOD TO BE IN COMPLIANCE WITH THE SPECIFICATIONS PROVIDED AND ANY CHANGES SO NOTED.

CO. NAME _____ DATE _____

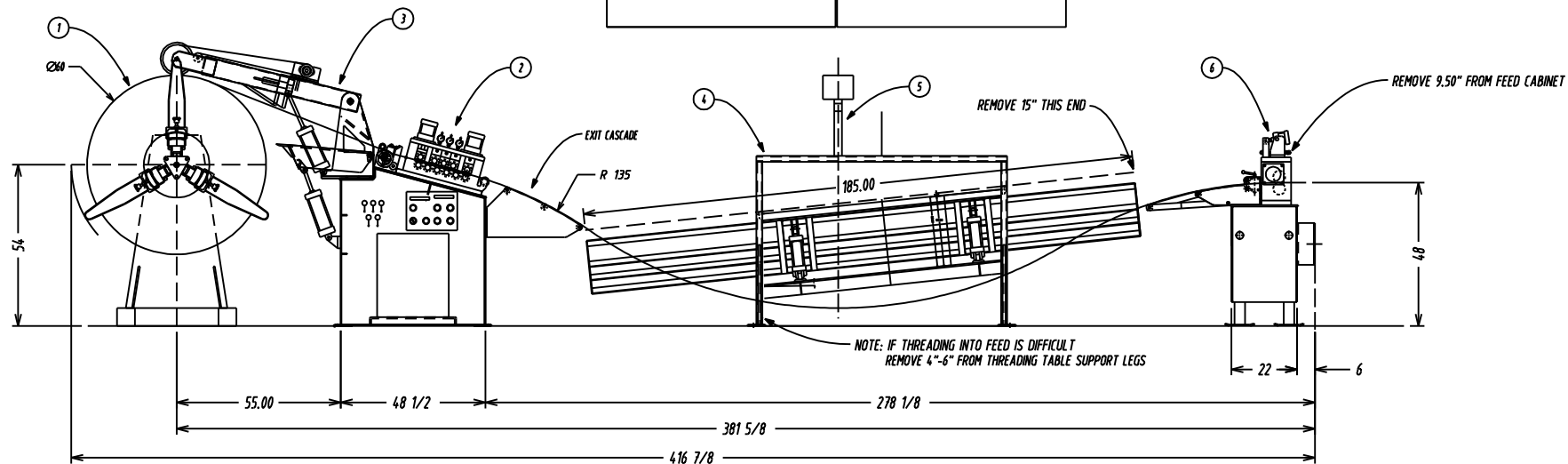
BY _____ TITLE _____



WARNING:

PERMETER GUARDING IS NECESSARY AND THE EQUIPMENT SHOULD NOT BE USED WITHOUT IT.

IT IS THE USER'S RESPONSIBILITY TO PROVIDE SUCH GUARDING IN ACCORDANCE WITH APPLICABLE LAWS AND REGULATIONS



ELEVATION VIEW

EQUIPMENT DESCRIPTION-

1. MODEL 4R-18 SINGLE STOCK REEL WITH HYDRAULIC INCHING DRIVE, HYDRAULIC EXPANSION FOR 13-17, 17-21, 21-25 COIL ID, AND 2-PRESSURE, SPRING SET POWER OFF AIR BRAKE
2. MODEL 12-HDC STOCK STRAIGHTENER WITH 50FPM MODULATING DRIVE, HANDWHEEL ADJ. EDGE GUIDES, SLANT TOP CABINET, DIAL INDICATORS, AUTO LUBE, JOG PENDANT AND AIR LIFT ENTRY/EXIT PINCH ROLLS
3. MODEL 12HDP HOLD-DOWN PEELER SYSTEM WITH HOLD-DOWN ARM FOR 4" WIDE MATERIAL, PEELER TABLE/BLADE, POWERED RIDER ROLL, HANDVALVE CONTROLS AND COIL BREAKER BAR MUST CLEAR 12:00 POSITION FOR OVERHEAD COIL LOADING
4. MODEL 12PTT1 PNEUMATIC THREADING TABLE SOLID SHEET STEEL TOP WITH HAND VALVE OPERATED CONTROLS.
5. CWP ULTRASONIC LOOP CONTROL W/HIGH/LOW SEL. SWITCH
6. MODEL SMX111-12H SERVOMAX FEED WITH +/- 4" CRANK ADJ. CABINET, 6" STAND-OFF BRACKET, SMOOTH CHROME ROLLS, POWER OFF BRAKE, AND SINGLE POINT LUBRICATION TRANSFORMER FOR 460V/3PH/60HZ

NOTES:

1. LOOPING AREA DIMENSIONS BASED ON A MAXIMUM MATERIAL THICKNESS OF .250 AT 34,000-40,000 PSI YIELD. THIS WILL PROVIDE 16" OF SLACK MATERIAL WITH PASSLINE SHOWN
2. OPERATOR CONTROL CONSOLE FOR SERVO ELECTRIC ROLL FEED NOT SHOWN IN ELEVATION VIEW FOR CLARITY.
3. SAFETY GUARDS ON UNITS NOT SHOWN FOR CLARITY.

NOTE: REMOVE 15.00" FROM FEED END OF THREADING TABLE
REMOVE 9.50" FROM FEED CABINET

CHANGES				DATE	BY
NO.					
UNLESS OTHERWISE SPECIFIED					
STANDARD TOLERANCE			DO NOT SCALE		
.00 ± .010			FILETS TO BE .05 RADIUS		
.000 ± .001			ALL DIAMETERS .03 × 45° CHAMFER		
ANGLES ± 0°-30°			REMOVE ALL SHARP EDGES AND BURRS		
NO. REQ'D PER ASSY	NEXT ASSEMBLY	MODEL OR SERIES			

DET NO.		MATERIAL			
FORMTEK INC. RPM, BOX 75 HICKLEY ROAD CLINTON, MAINE 04027					
BASIC MACHINE LAYOUT					
12" SERVO FEED LINE					
FILE: LINE-DG /STAMPCONCEPTS.DGN					
DATE	4-3-12	OWN BY	BS	CHD REF	SHT 1 OF 2
DWG. NO.	CROWN EQUIPMENT			REV A	DWG SIZE B