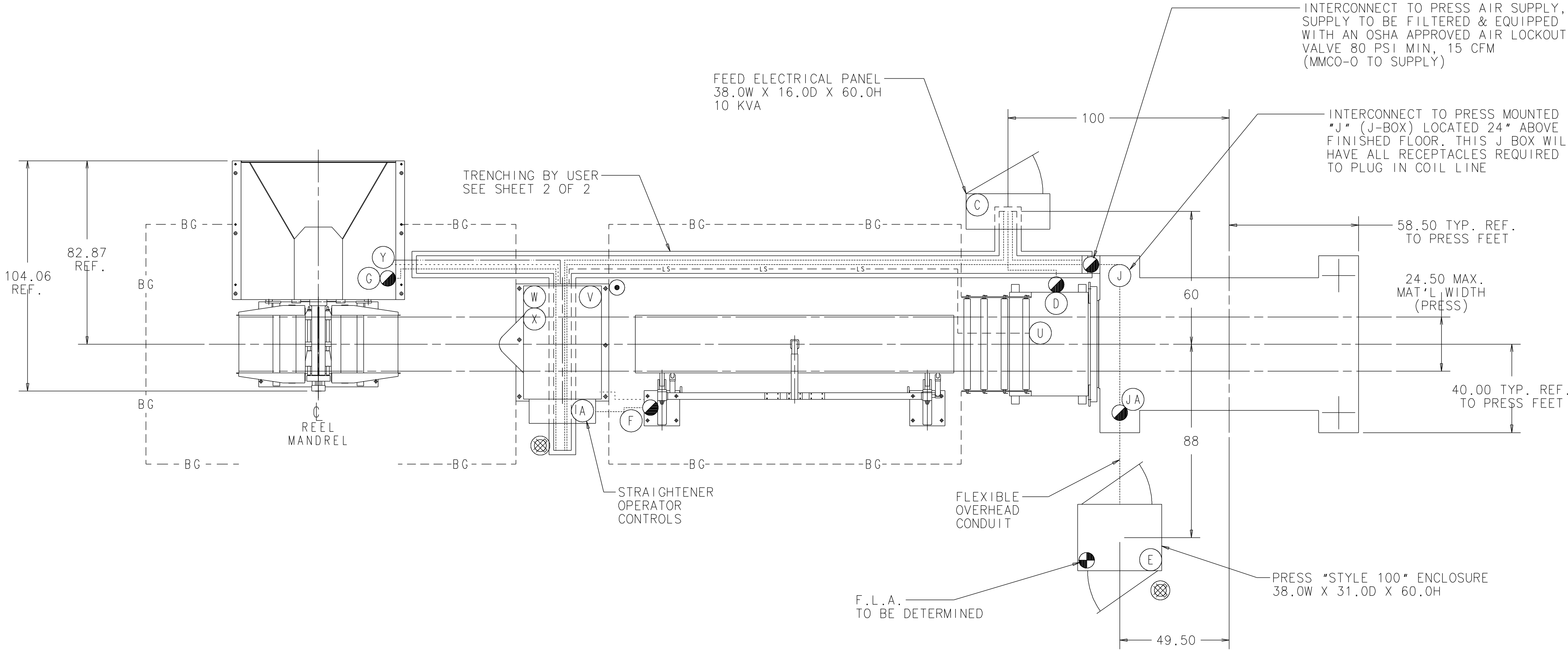


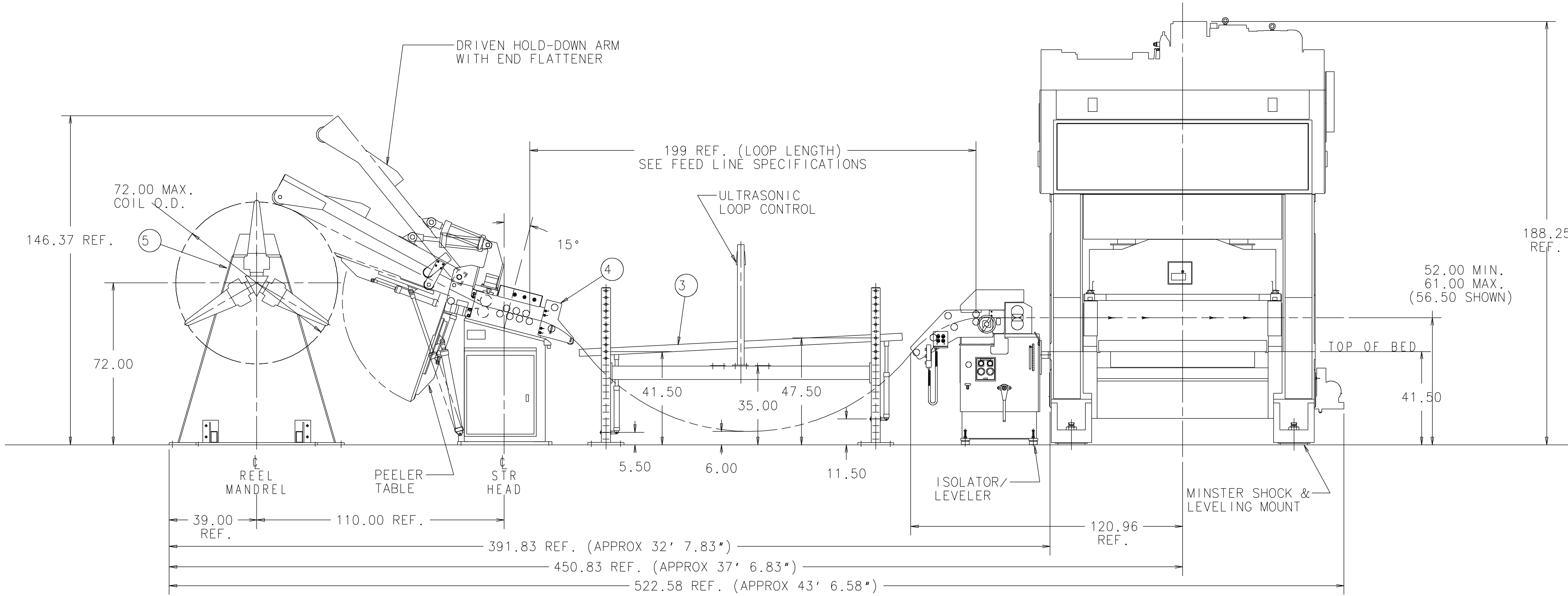
ITEM	DESCRIPTION	MODEL NUMBER	SERIAL NUMBER	REMARKS
1	MINSTER P2H-1606-75 GEARED TYPE PRESS	P2H-160G	29672	SEE PRESS SALES ORDER FOR DETAILS
2	MINSTER MACHINE SINGLE ROLL ELECTRIC FEED	MEF5-26S	18-50842	CHROME BLAST ROLL FINISH, END OF STOCK DETECTOR, FEED OPERATOR INTERFACE FOR THE MINSTER PRODUCTION MANAGEMENT CONTROL, LUBE FROM STRAIGHTENER, COIL LINE INTERCONNECTS
3	MINSTER MACHINE THREADING TABLE	MTT12-26S	13-81259	
4	MINSTER MACHINE STRAIGHTENER	MSH30-26-7	13-50558	DIG. ROLL POS READOUT, PEELER TAABLE, CLASS *A* LUBE SYSTEM, CLASS *A* LUBE TO FEED, END OF STOCK DETECTOR, DRIVEN HOLD-DOWN ARM W/ END FLATTENER (5" WIDTH), COIL LINE INTERCONNECTS
5	MINSTER MACHINE SINGLE REEL	MR15-26S	13-70632	SPECIAL COIL O.D., KEEPER ARMS, HOLDING BRAKE



RECEPTACLE LOCATION	DESCRIPTION	RECEPTACLE LOCATION
COIL LINE INTERCONNECTS		
ELECTRICAL		
INTERCONNECT IDENTIFICATION		
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.....	J1 >>> J1	
C1 <<< C1 FEED PANEL TO PRESS J-BOX.....	J2 <<< J2	
C2 <<< C2 FEED PANEL TO PRESS J-BOX.....	J3 <<< J3	
C3 <<< C3 FEED PANEL TO PRESS J-BOX.....	J4 <<< J4	
C4 >>> C4 FEED PANEL TO PRESS J-BOX.....	J5 >>> J5	
C5 <<< C5 FEED PANEL TO FEED J-BOX.....	D1 <<< D1	
C6 <<< C6 FEED PANEL TO FEED J-BOX.....	D2 <<< D2	
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	
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.

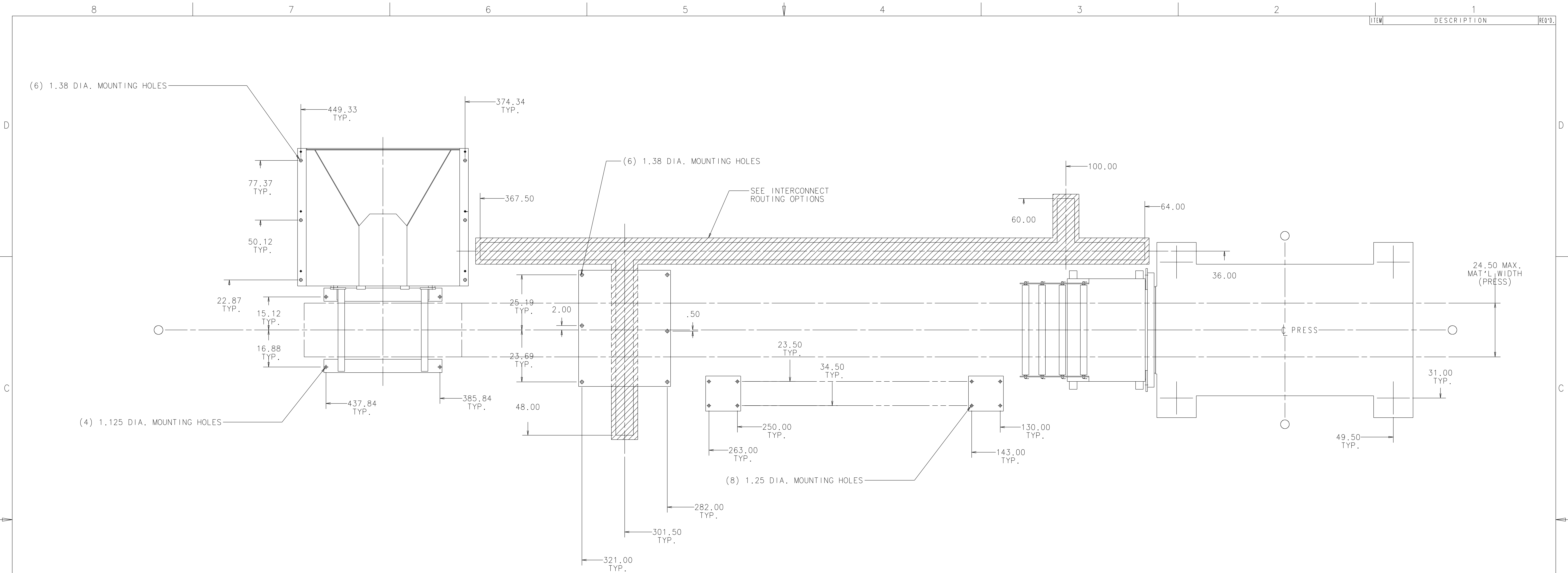
SYMBOL KEY	
-----	INDICATES ELECTRICAL SUPPLY LINES
-----	INDICATES PNEUMATIC SUPPLY LINES
-----	INDICATES HYDRAULIC SUPPLY LINES
--LS--	INDICATES LUBRICATION SUPPLY LINES
⊗	INDICATES ELECTRICAL DROP 480V-3Ø-60HZ
⊙	INDICATES PNEUMATIC DROP 80 PSI, 4 CFM
⊗	INDICATES OPERATOR POSITION
⊙	INDICATES ELECTRICAL TERMINAL BOX
<<	INDICATES PLUG W/ FEMALE INSERT
>>	INDICATES PLUG W/ 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

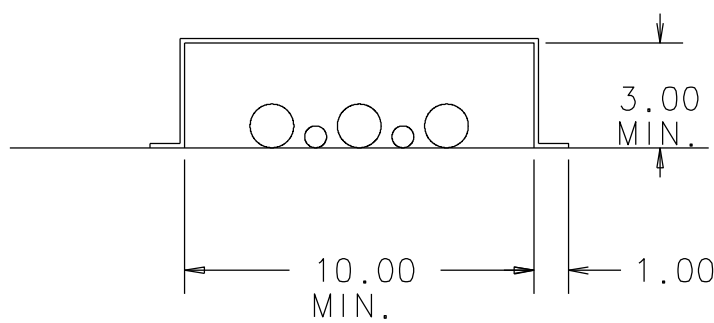
EQUIPMENT	
LINE DIRECTION: LEFT TO RIGHT	
LINE SPEED: 40-1200 INCHES PER MINUTE	
PRESS SPEED: 150 SPM	
MAX. STOCK WIDTH: 24.50 (PRESS)	
MIN. STOCK THICKNESS: .020"	
MAX. STOCK THICKNESS: .203 (LOOP)	
MAX. STOCK THICKNESS * FULL WIDTH: .125 (FEED)	
MAX. STOCK WIDTH * FULL THICKNESS: 5" (STR)	
MAX. COIL WEIGHT: 15,000 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. 31' IS BASED ON MAX. MAT'L THICKNESS OF .203 WITH A RECOMMENDED MAX. FEED PROGRESSION OF APPROX. 13'	
NOTE: ALL LINE DATA IS CALCULATED FOR MILD STEEL (50,000 YIELD STRENGTH)	

TOLERANCES UNLESS OTHERWISE SPECIFIED MACHINING X AND X.X ±.100 X.XX ±.010 X.XXX ±.001 X.XXXX ±.0005	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 CONSENT OF THE MINSTER MACHINE COMPANY IS PROHIBITED. ALL RIGHTS RESERVED.	SUPERSEDES	DRAWING DATE
		SUPERSEDED BY	1999-02-25
CLASS 2B THDS (INCH) CLASS 6H THDS (MM) FINISH 125 MICRONS BREAK SHARP CORNERS .03	LAYOUT, FLOOR PLAN	PATTERN PART NUMBER	DRAWN BY
ZL015	OMEGA MOTION	ESTIMATED WEIGHT	DLH
GROUP TECH. NUMBER	6083-838	MATERIAL	CHECKED BY
SHEET NO. 1	DRAWING SCALE .031	LAST REVISED BY	PRM
OF SHEETS 2	PART NUMBER	LAST REVISION DATE	DLH
	1206-975	REVISION LEVEL	002

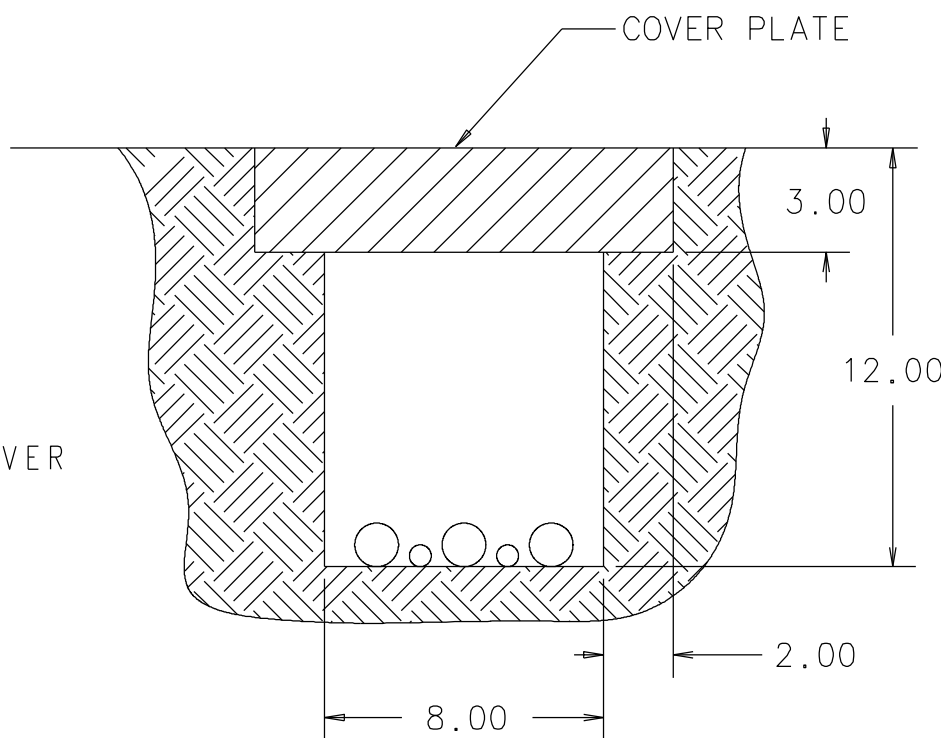


INTERCONNECT ROUTING OPTIONS

ABOVE FLOOR
INTERCONNECT COVER



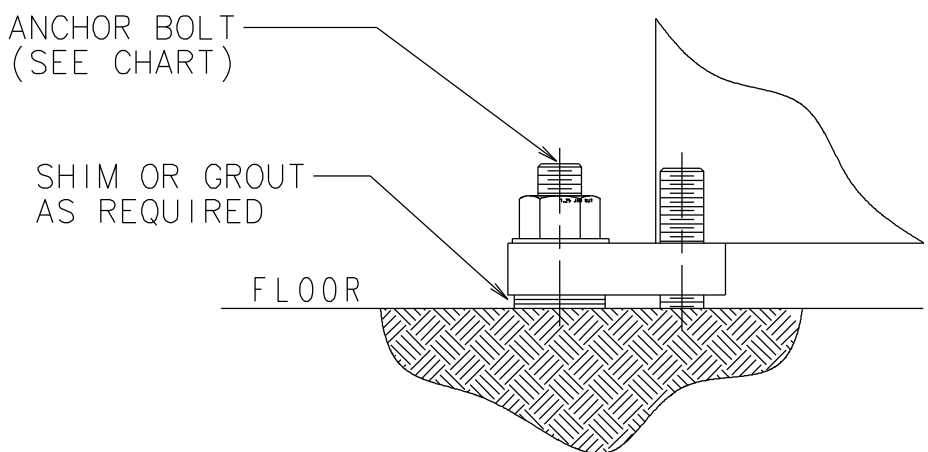
BELOW FLOOR
INTERCONNECT TRENCH



- 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



- 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.

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

FOUNDA

ALL FOUNDATION WORK
OF THE USER. THIS
TRENCHING, FLOOR CO
ANCHORING.

TOLERANCES UNLESS OTHERWISE SPECIFIED	THE MINSTER MACHINE CO. BEAUFORT, S.C. U.S.A.	SUPERSEDES	DRAWING DATE
MACHINING	DISCLAIMER: THIS DOCUMENT IS THE EXCLUSIVE PROPERTY OF THE MINSTER MACHINE CO. ANY DISCLOSURE, DISTRIBUTION AND/OR REPRODUCTION WITHOUT THE EXPRESS WRITTEN CONSENT OF THE MINSTER MACHINE COMPANY IS PROHIBITED. ALL RIGHTS RESERVED.	SUPERSEDED BY	1999-02-25
X AND X.X ±.100	PART NAME	PATTERN PART NUMBER	DRAWN BY
X.XX ±.010	LAYOUT, FLOOR PLAN	ESTIMATED WEIGHT	CHECKED BY
X.XXX ±.001	OMEGA MOTION	MATERIAL	DLH
X.XXXX ±.0005	REFERENCE NUMBER	LAST REVISED BY	DLH
CLASS 2B THDS (INCH)	6083-838	LAST REVISION DATE	1999-06-01
CLASS 6H THDS (MM)	GROUP TECH. NUMBER	DRAWING SCALE	REVISION LEVEL
FINISH 125 MICROINCHES	2	.031	002
BREAK SHARP CORNERS .03	SHEET NO.	PART NUMBER	
21.015	2	1206-975	
21.015	OF SHEETS		