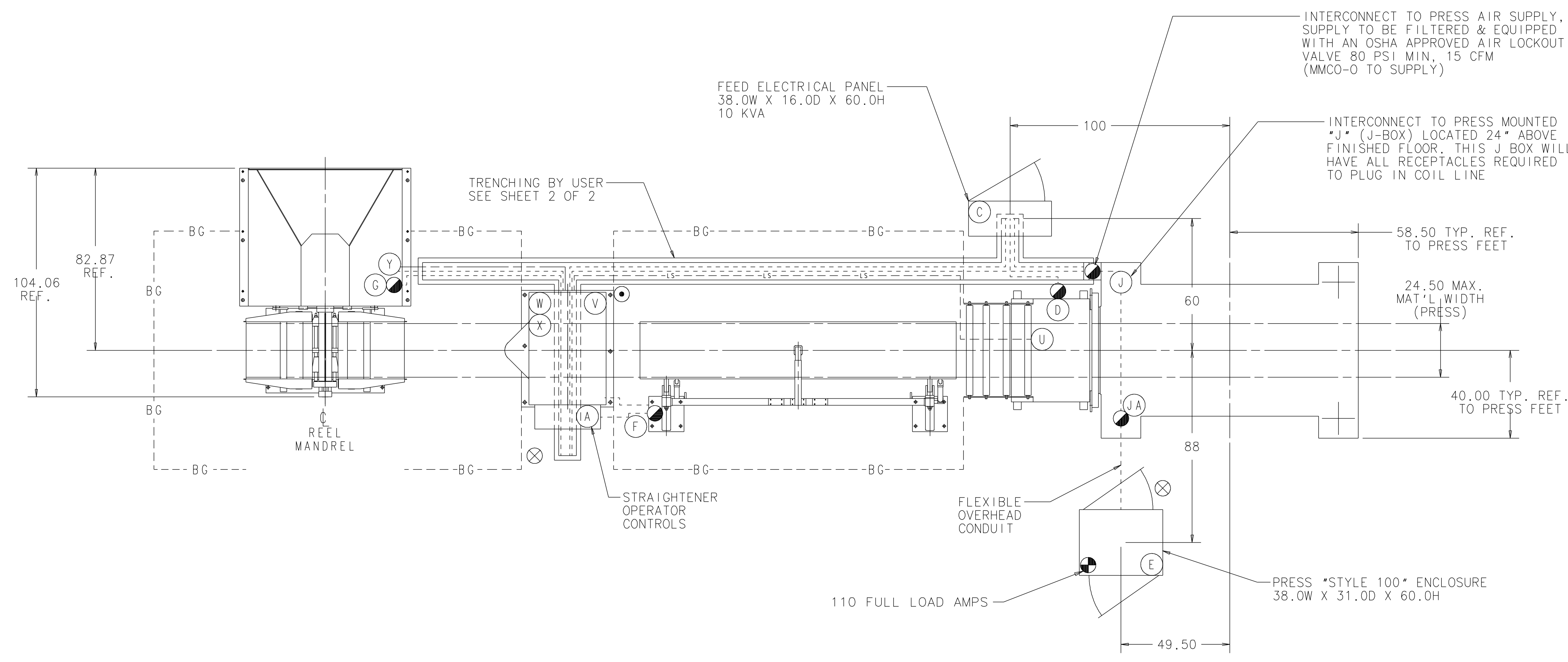


ITEM	DESCRIPTION	MODEL NUMBER	SERIAL NUMBER	REMARKS
1	MINSTER MACHINE PRESS	P2H-160G	29771	SEE PRESS SALES ORDER FOR DETAILS
2	MINSTER MACHINE SINGLE ROLL ELECTRIC FEED	MEF5-26S	18-50877	CHROME BLAST #3 ROLL FINISH, AUTOMATIC LUBRICATION FROM STRAIGHTENER, FEED OPERATOR INTERFACE: PRESS PMC, HAND CRANK ADJUSTABLE STOCK GUIDES, COIL LINE INTERCONNECTS
3	MINSTER MACHINE THREAD TABLE	MTT12-26S	13-81277	
4	MINSTER MACHINE STRAIGHTENER	MSH30-26-7	13-50581	POWERED WORK ROLL ADJUSTMENT, HAND CRANK ADJUSTABLE STOCK GUIDES, STRAIGHTENER PMC CONTROL, COIL LINE INTERCONNECTS
	MINSTER MACHINE SINGLE REEL	MR15-26S	13-70494	AUTOMATIC LUBRICATION SYSTEM, AUTOMATIC LUBRICATION TO THE FEED, DRIVEN HOLD DOWN ARM(5' WIDTH), END FLATTENER AND PEELER TABLE

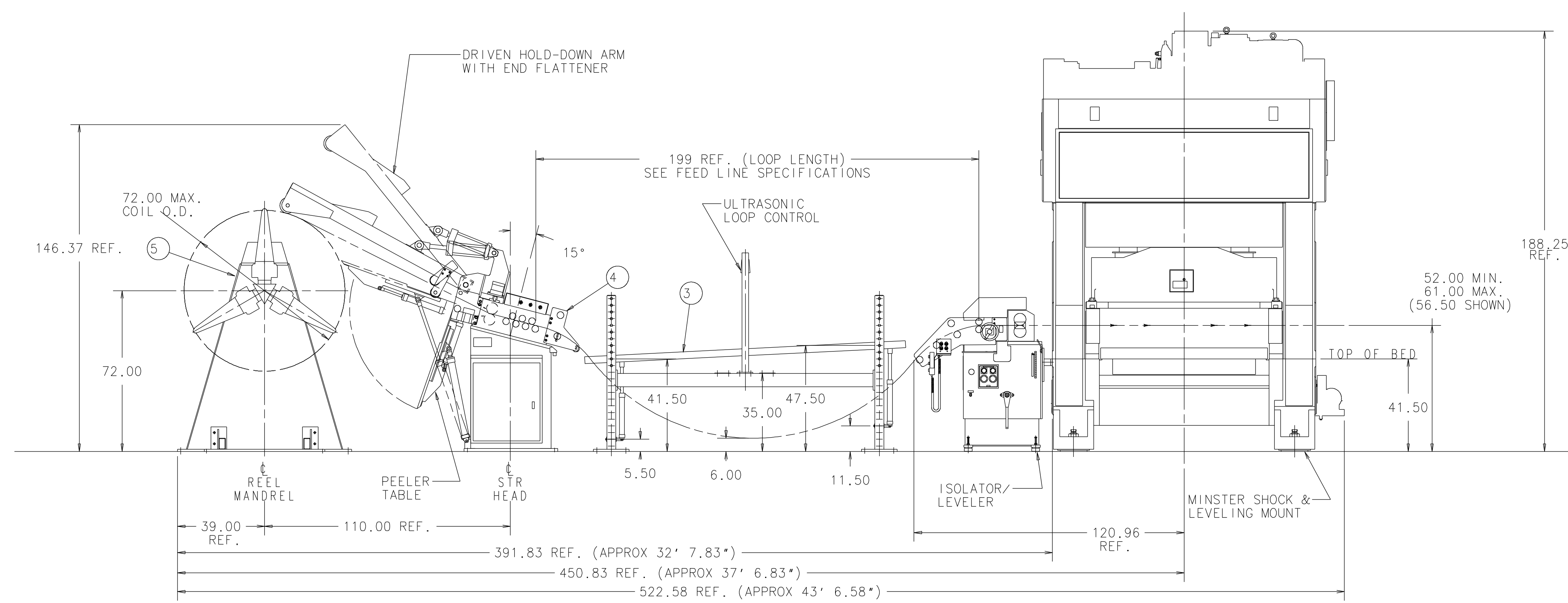
RECEPTACLE LOCATION	DESCRIPTION	RECEPTACLE LOCATION
<b>COIL LINE INTERCONNECTS</b>		
<b>ELECTRICAL</b>		
INTERCONNECT IDENTIFICATION		
A1	A1 STRAIGHTENER PANEL TO FEED PANEL.....	C7
A2	A2 STRAIGHTENER PANEL TO REEL J-BOX.....	G1
A6	A6 STRAIGHTENER PANEL TO PRESS J-BOX.....	J1
A7	A7 STRAIGHTENER PANEL TO ULTRASONIC J-BOX.....	M1
C1	C1 FEED PANEL TO PRESS J-BOX.(COMMUNICATION)...	J2
C2	C2 FEED PANEL TO PRESS J-BOX.(POWER).....	J3
C3	C3 FEED PANEL TO PRESS J-BOX.....	J4
C5	C5 FEED PANEL TO FEED J-BOX.....	D1
C8	C8 FEED PANEL TO FEED J-BOX...(MOTOR POWER CONDUIT)...	D3
C9	C9 FEED PANEL TO FEED J-BOX...(MOTOR FEEDBACK CONDUIT)...	D4
E1	E1 PRESS PANEL TO PRESS J-BOX.....	JA
<b>HYDRAULIC</b>		
X5	X5 STRAIGHTENER TO REEL.....(PRESSURE.....)	Y1
X6	X6 STRAIGHTENER TO REEL.....(TANK).....	Y2
<b>PNEUMATIC</b>		
W1	W1 STRAIGHTENER TO REEL.....	Y3
<b>LUBE</b>		
V1	V1 STRAIGHTENER TO FEED.....	U3



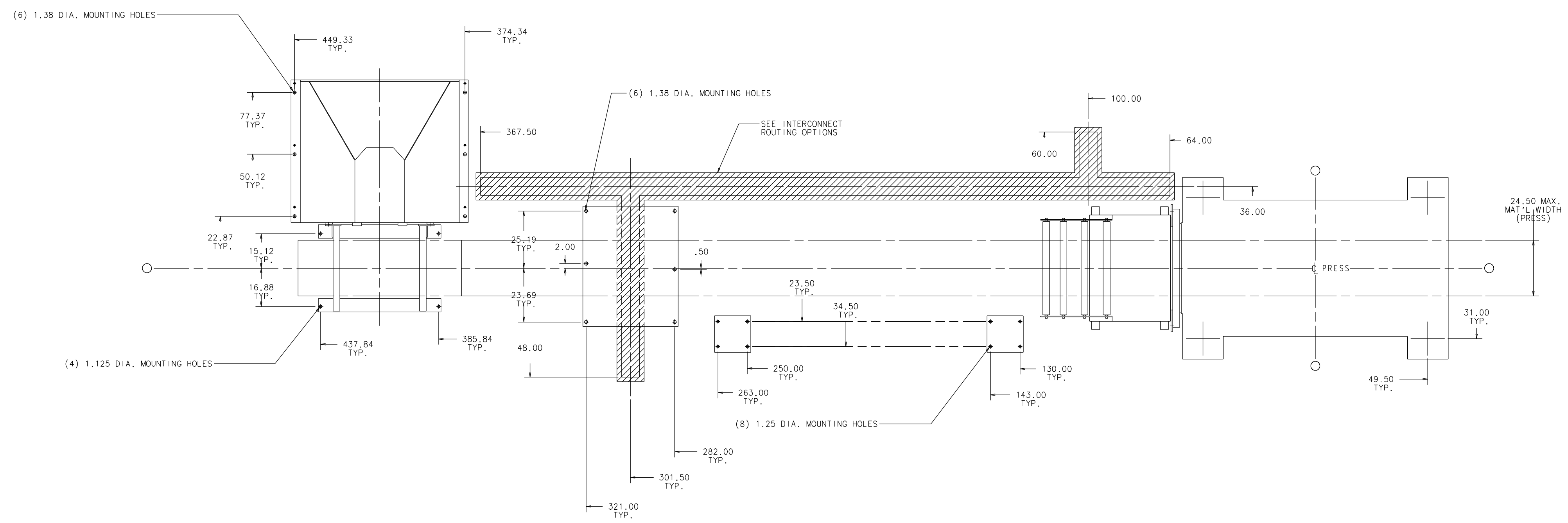
**INTERCONNECT NOTE**  
 ALL COMPONENTS FOR THE INTERCONNECTION OF HYDRAULIC, PNEUMATIC, AND ELECTRICAL BETWEEN PIECES OF EQUIPMENT ARE SUPPLIED BY MINSTER. IT IS THE USER'S RESPONSIBILITY TO SUPPLY THE REQUIRED ELECTRICAL AND PNEUMATIC SHOP SUPPLY DROPS AS SPECIFIED.

- SYMBOL KEY**
- INDICATES ELECTRICAL SUPPLY LINES
  - INDICATES PNEUMATIC SUPPLY LINES
  - INDICATES HYDRAULIC SUPPLY LINES
  - - - - - INDICATES LUBRICATION SUPPLY LINES
  - ⊗ INDICATES ELECTRICAL DROP  
480V-3φ-60HZ, 110 FULL LOAD AMPS
  - ⊙ 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 USER'S FULL RESPONSIBILITY TO PROVIDE ADEQUATE COIL LINE BARRIER GUARDING PER ANSI B11.18 SPECIFICATIONS AND ALL OTHER APPLICABLE SAFETY STANDARDS.

FEED LINE SPECIFICATIONS	
<b>EQUIPMENT</b>	
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: .230 (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	
<b>LOOP</b>	
LOOP STORAGE AVAILABLE OF APPROX. 31' IS BASED ON MAX. MAT'L THICKNESS OF .230 (LOOP) WITH A RECOMMENDED MAX. FEED PROGRESSION OF APPROX. 13'	
NOTE: ALL LINE DATA IS CALCULATED FOR MILD STEEL (50,000 YIELD STRENGTH)	

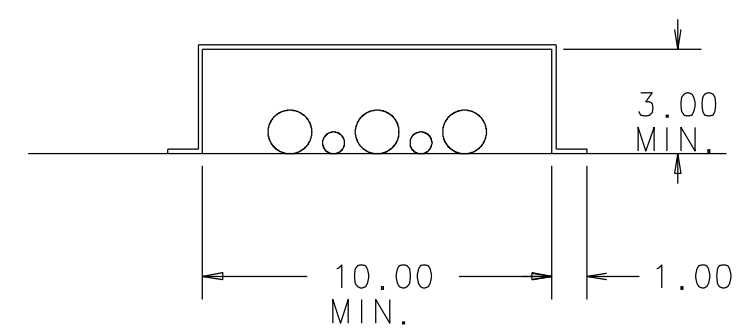


TOLERANCES UNLESS OTHERWISE SPECIFIED	<b>THE MINSTER MACHINE CO.</b> BEAUFORT, S.C. U.S.A. <small>© THE MINSTER MACHINE CO. THIS DOCUMENT IS THE EXCLUSIVE PROPERTY OF THE MINSTER MACHINE CO. ANY DISCLOSURE, DISTRIBUTION AND/OR REPRODUCTION WITHOUT THE EXPRESS WRITTEN CONSENT OF THE MINSTER MACHINE COMPANY IS PROHIBITED. ALL RIGHTS RESERVED.</small>	SUPERSEDES	1999-05-18
MACHINING		PATTERN PART NUMBER	DRAWN BY
X AND X.X ±.100		ESTIMATED WEIGHT	CHECKED BY
X.XX ±.010			DLH
X.XXX ±.001			LAST REVISED BY
X.XXXX ±.0005			DLH
CLASS 2B THDS (INCH)	LAYOUT, FLOOR PLAN	MATERIAL	LAST REVISION DATE
CLASS 6H THDS (MM)	OMEGA MOTION		2000-01-05
FINISH 125 MICROINCHES	REFERENCE NUMBER	DRAWING SCALE	REVISION LEVEL
BREAK SHARP CORNERS .03	6083-838	.031	001
[Z].015 [Z].015 [Z].015	GROUP TECH. NUMBER	SHEET NO.	PART NUMBER
	9999	1	1215-173

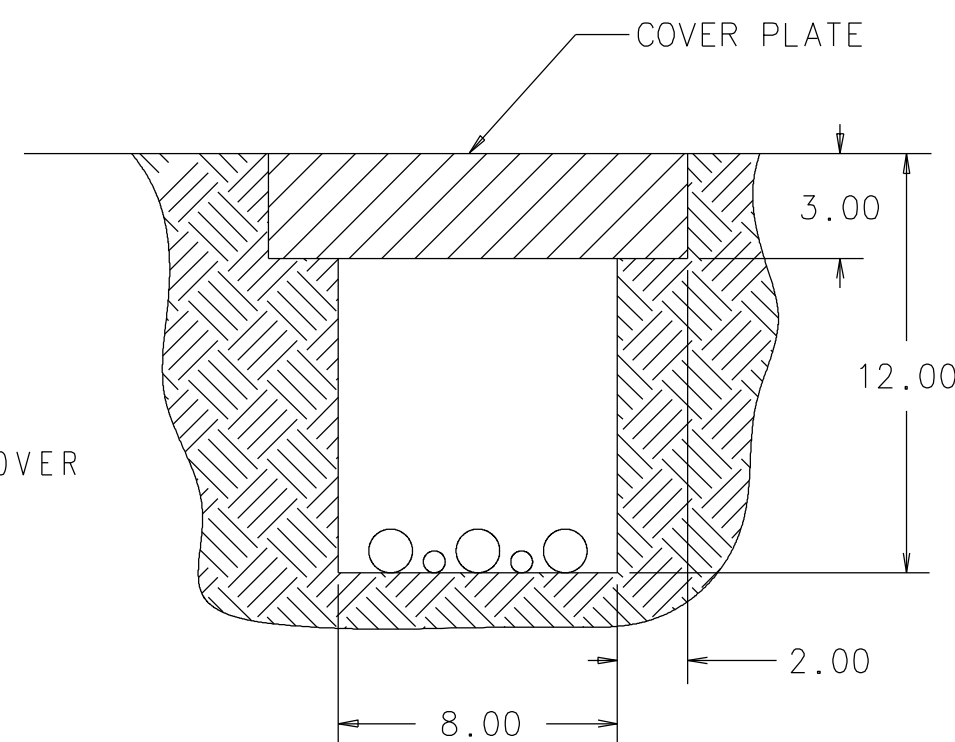


**INTERCONNECT ROUTING OPTIONS**

**ABOVE FLOOR INTERCONNECT COVER**



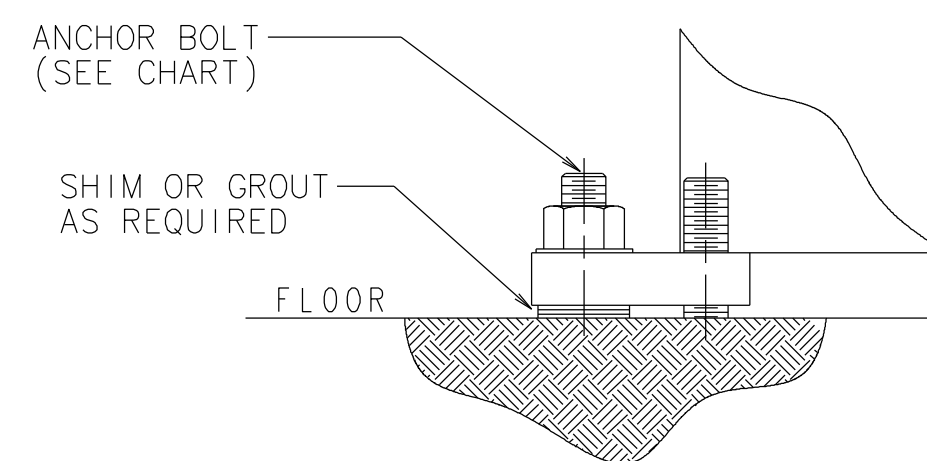
**BELOW FLOOR INTERCONNECT TRENCH**



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

**EQUIPMENT LEVELING & ANCHORING**

**ANCHORING DETAIL**



- NOTE:
- AFTER MACHINE HAS BEEN LEVELED, SHIM OR GROUT UNDER THE FOOT AT THE ANCHOR LOCATION AS SHOWN.
  - IT IS THE CUSTOMERS RESPONSIBILITY TO FURNISH ADEQUATE FOUNDATION AND HARDWARE TO ANCHOR EQUIPMENT TO THE ABOVE SPECIFICATIONS.
  - 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

**FOUNDATION WORK**

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

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MACHINING		SUPERSEDED BY	1999-05-18
X AND X.X ±.100	LAYOUT, FLOOR PLAN OMEGA MOTION REFERENCE NUMBER 6083-838 GROUP TECH. NUMBER 9999	PATTERN PART NUMBER	CHECKED BY
X.XX ±.010		ESTIMATED WEIGHT	DLH
X.XXX ±.001		MATERIAL	LAST REVISION DATE
X.XXXX ±.0005		FINISH 125 MICROINCHES	2000-01-05
		DRAWING SCALE	REVISION LEVEL
		.031	001
		SHEET NO.	PART NUMBER
		2 / 2	1215-173
		OF SHEETS	