

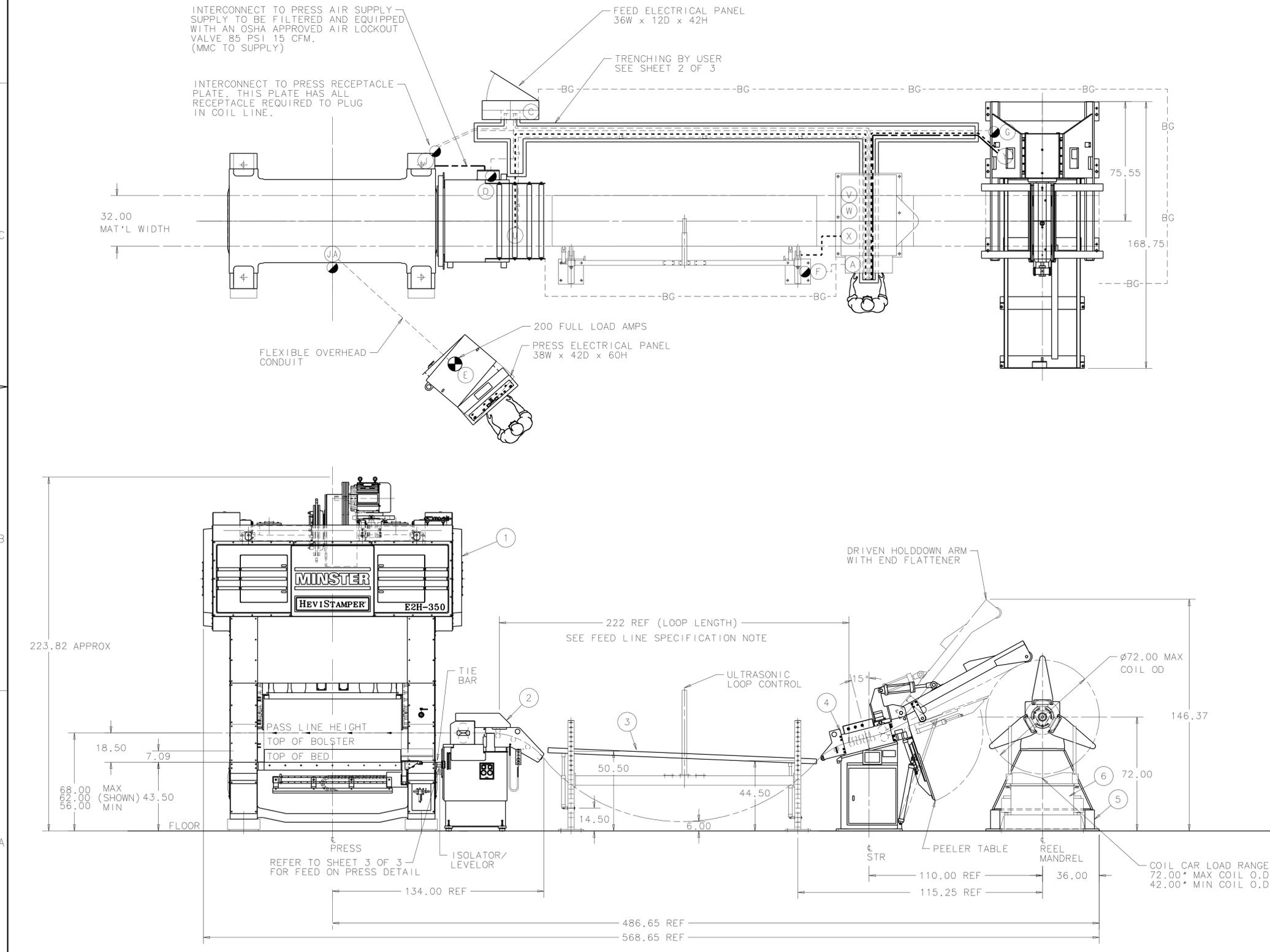
ITEM	DESCRIPTION	MODEL NUMBER	SERIAL NUMBER	REMARKS
1	MINSTER PRESS	E2H-350-86 x 47	30399	SEE PRESS SALES ORDER FOR DETAILS
2	MINSTER MACHINE SINGLE ROLL ELECTRIC FEED	MEF6-32S	18-51299	CHROME BLAST #3 ROLL FINISH, AUTOMATIC PASSLINE ADJUSTMENT, AUTOMATIC LUBRICATION FROM STRAIGHTENER, AUTOMATIC STOCK GUIDE ADJUSTMENT, COIL LINE INTERCONNECTS, PRODUCTION MANAGEMENT CONTROL THRU PRESS
3	MINSTER MACHINE THREADING TABLE	MTT14-32S	13-81405	
4	MINSTER MACHINE STRAIGHTENER	MSH30-32-7	13-50792	AUTOMATIC WORK ROLL ADJUSTMENT, AUTOMATIC STOCK GUIDE ADJUSTMENT, AUTOMATIC LUBRICATION SYSTEM, AUTOMATIC LUBRICATION TO THE FEED, ULTRASONIC LOOP CONTROL, AUTOMATIC LOOP HEIGHT ADJUSTMENT DRIVEN HOLD DOWN ARM (5" WIDTH), END FLATTENER AND PEELER TABLE, COIL LINE INTERCONNECTS
5	MINSTER MACHINE SINGLE REEL	MRH20-38S	13-70945	FIXED REEL BASE W/ MANUAL KEEPER ARMS,
6	MINSTER MACHINE COIL CAR	MCCH-35	13-90399	SPECIAL AUTOMATIC COIL LOCATING CONTROL (#4806)

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 (POWER)...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 J-BOX.....J2 <<< J2	
C2 <<< C2	FEED PANEL TO PRESS J-BOX... (BLUE HOSE)...J3 <<< J3	
C4 <<< C4	FEED PANEL TO PRESS J-BOX... (POWER)...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	

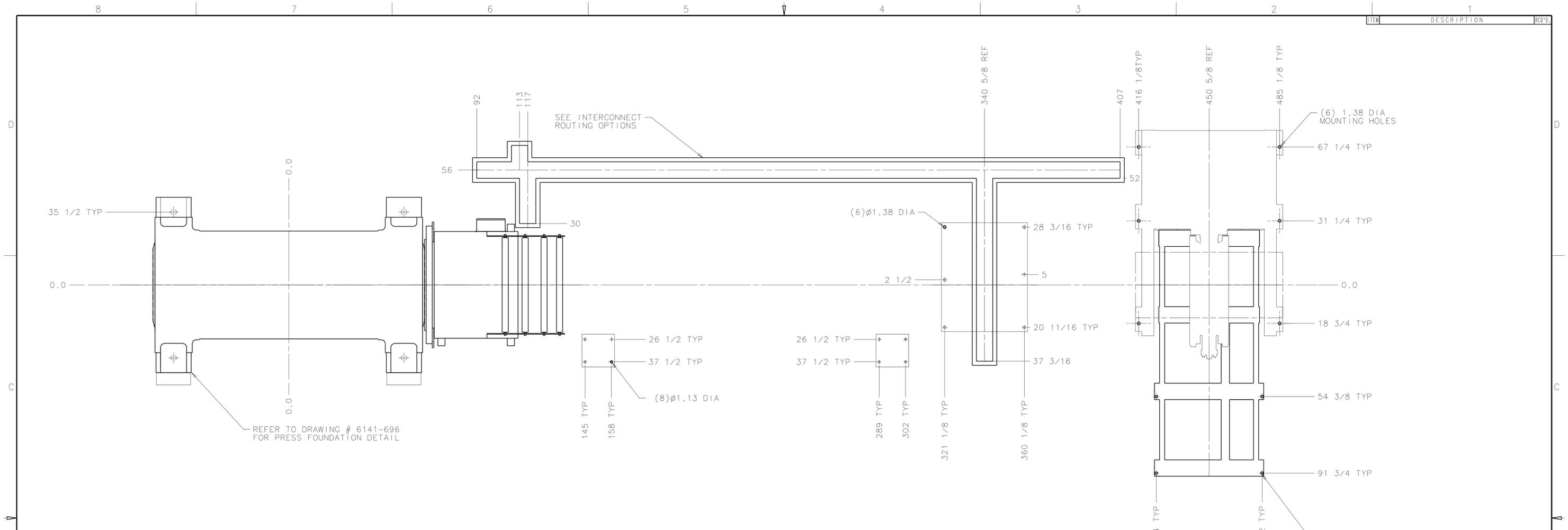
INTERCONNECT NOTE
 ALL COMPONENTS FOR THE INTERCONNECTION OF HYDRAULIC, PNEUMATIC, AND ELECTRICAL BETWEEN PIECES OF EQUIPMENT ARE SUPPLIED BY MINSTER. IT IS THE USER'S RESPONSIBILITY TO SUPPLY THE REQUIRED ELECTRICAL AND PNEUMATIC SHOP SUPPLY DROPS AS SPECIFIED.

- SYMBOL KEY**
- INDICATES ELECTRICAL SUPPLY LINES
 - INDICATES PNEUMATIC SUPPLY LINES
 - INDICATES HYDRAULIC SUPPLY LINES
 - LS----- INDICATES LUBRICATION SUPPLY LINES
 - INDICATES ELECTRICAL DROP
 - 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 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	
EQUIPMENT	
LINE DIRECTION: RIGHT TO LEFT	
LINE SPEED: 40-1200 INCHES PER MINUTE	
PRESS SPEED: 120-150 SPM	
MAX. STOCK WIDTH: 32.00"	
MIN. STOCK THICKNESS: .020"	
MAX. STOCK THICKNESS: .237" (LOOP)	
MAX. STOCK THICKNESS * FULL WIDTH: .151"	
MAX. STOCK WIDTH * FULL THICKNESS: 8.71"	
MAX. COIL WEIGHT: 24,000 LBS	
COIL I.D. RANGE: 18.0 - 22.0"	
NOTE: ITEMS LISTED WITHIN * () INDICATES THE LIMITING FACTOR OF THE LINE CONFIGURATION	
LOOP	
LOOP STORAGE AVAILABLE OF APPROX. 32' IS BASED ON MAX. MAT'L THICKNESS OF .237" WITH A RECOMMENDED MAX. FEED PROGRESSION OF APPROX. 12'	
NOTE: ALL LINE DATA IS CALCULATED FOR MILD STEEL (50,000 PSI YIELD STRENGTH)	



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MACHINING		SUPERSEDED BY	2005-09-29
X AND X.X ± .100	PATTERN PART NUMBER	CHECKED BY	LSP
X.XX ± .010	LSP	ESTIMATED WEIGHT	LAST REVISED BY
X.XXX ± .001	PART NAME	MATERIAL	LSP
X.XXXX ± .0005	L/O FLOORPLAN	REFERENCE NUMBER	LAST REVISION DATE
CLASS 2B THDS (INCH)	BRUNK INDUSTRIES - 30399	DRAWING SCALE	2006-10-23
CLASS 6H THDS (MM)		REVISION LEVEL	001
FINISH 125 MICRONS		SHEET NO.	3
BREAK SHARP CORNERS .03	GROUP TECH. NUMBER	OF SHEETS	1272-553
[Z].015 [Z].015 [Z].015	9999		

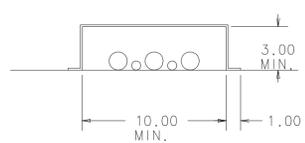


EQUIPMENT MOUNTING DETAIL

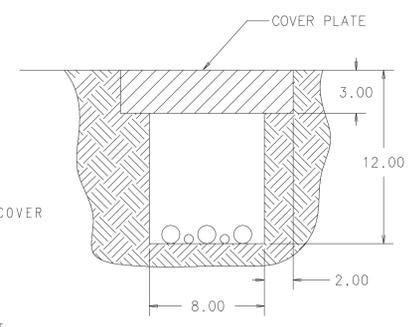
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INTERCONNECT ROUTING OPTIONS

ABOVE FLOOR INTERCONNECT COVER



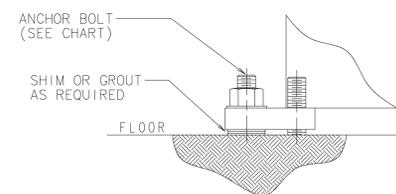
BELOW FLOOR INTERCONNECT TRENCH



- 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.

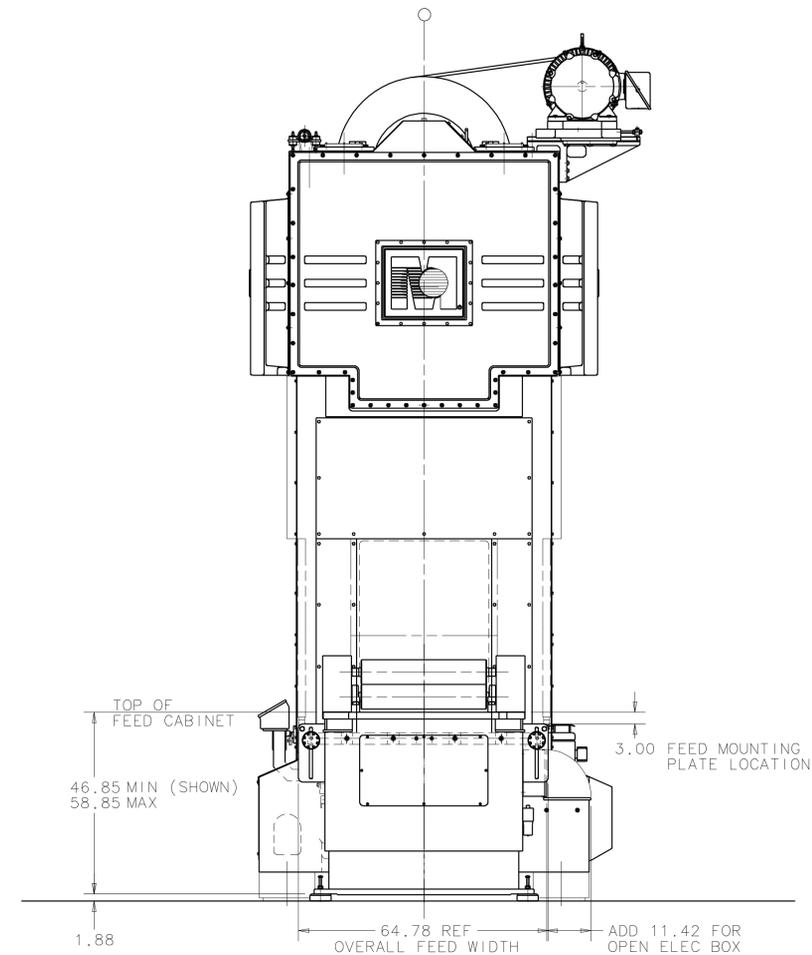
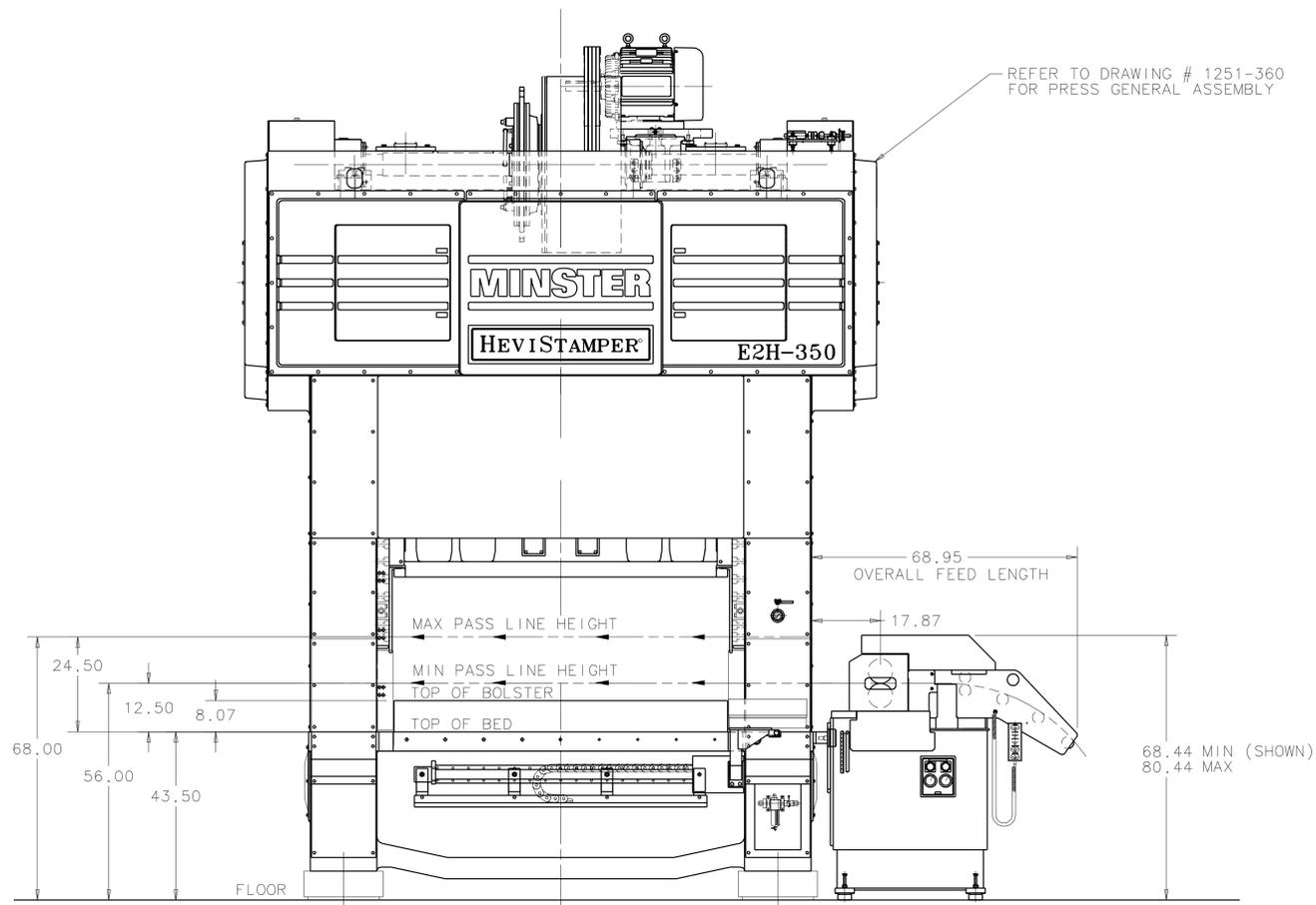
ANCHORING SPECIFICATIONS

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.

<p>TOLERANCES UNLESS OTHERWISE SPECIFIED:</p> <p>MACHINING</p> <p>X AND X.X ±.100</p> <p>X.XX ±.010</p> <p>X.XXX ±.001</p> <p>X.XXXX ±.0005</p>	<p>THE MINSTER MACHINE CO. BEAUFORT, S.C. U.S.A.</p> <p><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></p>	<p>SUPERSEDES: _____</p> <p>SUPERSEDED BY: _____</p> <p>PATTERN PART NUMBER: _____</p> <p>PART NAME: L/O FLOORPLAN</p> <p>MATERIAL: _____</p> <p>REFERENCE NUMBER: BRUNK INDUSTRIES - 30399</p> <p>GROUP TECH. NUMBER: 9999</p>	<p>DRAWING DATE: 2005-09-29</p> <p>DRAWN BY: LSP</p> <p>CHECKED BY: LSP</p> <p>LAST REVISED BY: LSP</p> <p>LAST REVISION DATE: 2006-10-23</p> <p>REVISION LEVEL: 001</p> <p>SHEET NO. 2 OF SHEETS</p> <p>PART NUMBER: 1272-553</p>
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FEED ON PRESS DETAIL
VIEW SCALE: .0312

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X.XX ±.010	LSP	LSP	LSP
X.XXX ±.001		ESTIMATED WEIGHT	LAST REVISED BY
X.XXXX ±.0005		LSP	LSP
CLASS 2B THDS (INCH)		MATERIAL	LAST REVISION DATE
CLASS 6H THDS (MM)	BRUNK INDUSTRIES - 30399		2006-10-23
FINISH 125 MICRONS	REFERENCE NUMBER	DRAWING SCALE	REVISION LEVEL
BREAK SHARP CORNERS .03		.0312	001
[Z].015 [Z].015 [Z].015	GROUP TECH. NUMBER	SHEET NO.	PART NUMBER
	9999	3 / 3	1272-553
		OF SHEETS	