

| ITEM | DESCRIPTION                               | MODEL NUMBER | SERIAL NUMBER | REMARKS  |
|------|---|--------------|---------------|--|
| 1    | MINSTER PRESS                             | E2H-350      | 29921         | SEE PRESS SALES ORDER FOR DETAILS  |
| 2    | MINSTER MACHINE SINGLE ROLL ELECTRIC FEED | MEF5-32S     | 18-50922      | CHROME BLAST #3 ROLL FINISH, AUTOMATIC LUBRICATION FROM STRAIGHTENER, FEED OPERATOR INTERFACE: PRESS PMC                 |
| 3    | MINSTER MACHINE THREADING TABLE           | MTT12-32S    | 13-81343      |  |
| 4    | MINSTER MACHINE STRAIGHTENER              | MSH30-32-7   | 13-50613      | POWERED WORK ROLL ADJUSTMENT, HAND CRANK ADJUSTABLE STOCK GUIDES, STRAIGHTENER PMC CONTROL, AUTOMATIC LUBRICATION SYSTEM |
| 5    | MINSTER MACHINE SINGLE REEL               | MRH20-38S    | 13-70694      | AUTOMATIC LUBRICATION TO THE FEED, DRIVEN HOLD DOWN ARM(5" WIDTH), END FLATTENER & PEELER TABLE, COIL LINE INTERCONNECTS |

| RECEPTACLE LOCATION            | DESCRIPTION  | RECEPTACLE LOCATION |
|--------------------------------|--|---------------------|
| <b>COIL LINE INTERCONNECTS</b> |  |                     |
| <b>ELECTRICAL</b>              |  |                     |
| 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 THREADING TABLE.....              | F1 ← F1             |
| A6                             | → A6 STRAIGHTENER PANEL TO PRESS RECEPTACLE.....             | J1 → J1             |
| A7                             | → A7 STRAIGHTENER PANEL TO FEED PANEL (BLUE HOSE).....       | C6 → C6             |
| C1                             | ← C1 FEED PANEL TO PRESS RECEPTACLE PLATE.....               | J2 ← J2             |
| C2                             | ← C2 FEED PANEL TO PRESS RECEPTACLE PLATE.....               | J3 ← J3             |
| C3                             | ← C3 FEED PANEL TO PRESS RECEPTACLE PLATE.....               | J4 ← J4             |
| C4                             | → C4 FEED PANEL TO PRESS RECEPTACLE PLATE.....               | 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             |

| <b>HYDRAULIC</b> |  |         |
|------------------|--|---------|
| X1               | → X1 STRAIGHTENER TO THREAD TABLE.....         | F2 ← F2 |
| X2               | → X2 STRAIGHTENER TO THREAD TABLE.....         | F3 ← F3 |
| X5               | → X5 STRAIGHTENER TO REEL..... (PRESSURE)..... | Y1 ← Y1 |
| X6               | → X6 STRAIGHTENER TO REEL..... (TANK).....     | Y2 ← Y2 |

| <b>PNEUMATIC</b> |                                |         |
|------------------|--------------------------------|---------|
| W1               | → W1 STRAIGHTENER TO REEL..... | Y3 ← Y3 |

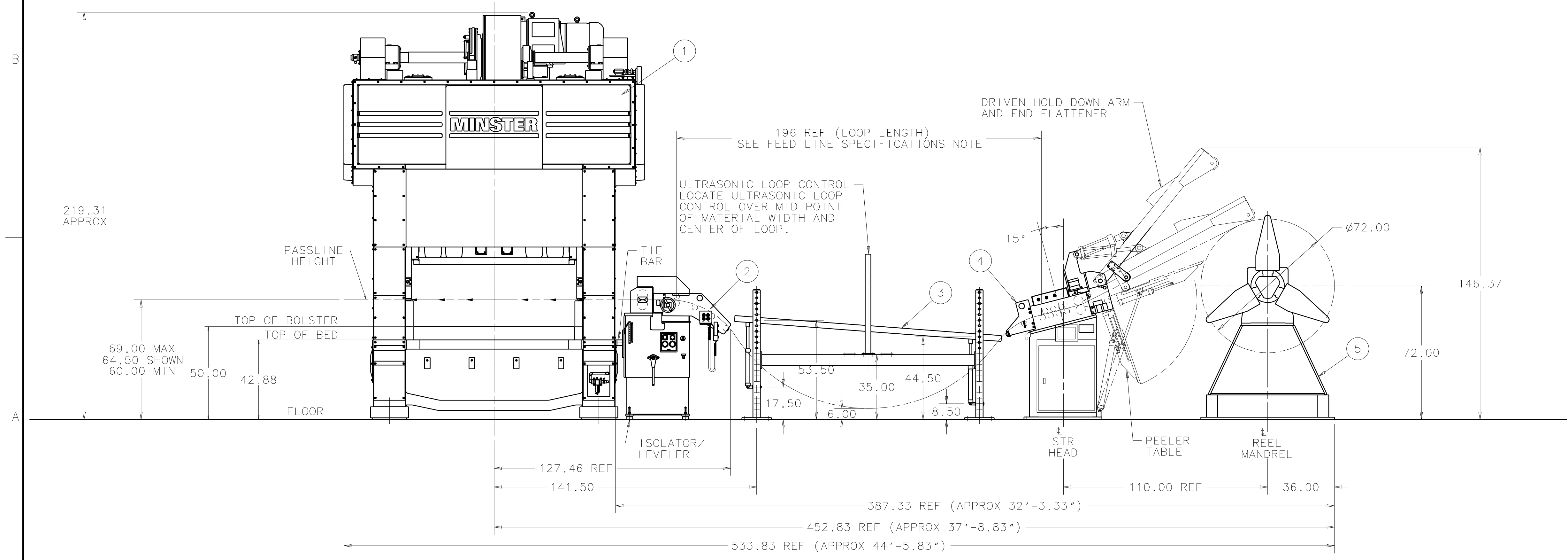
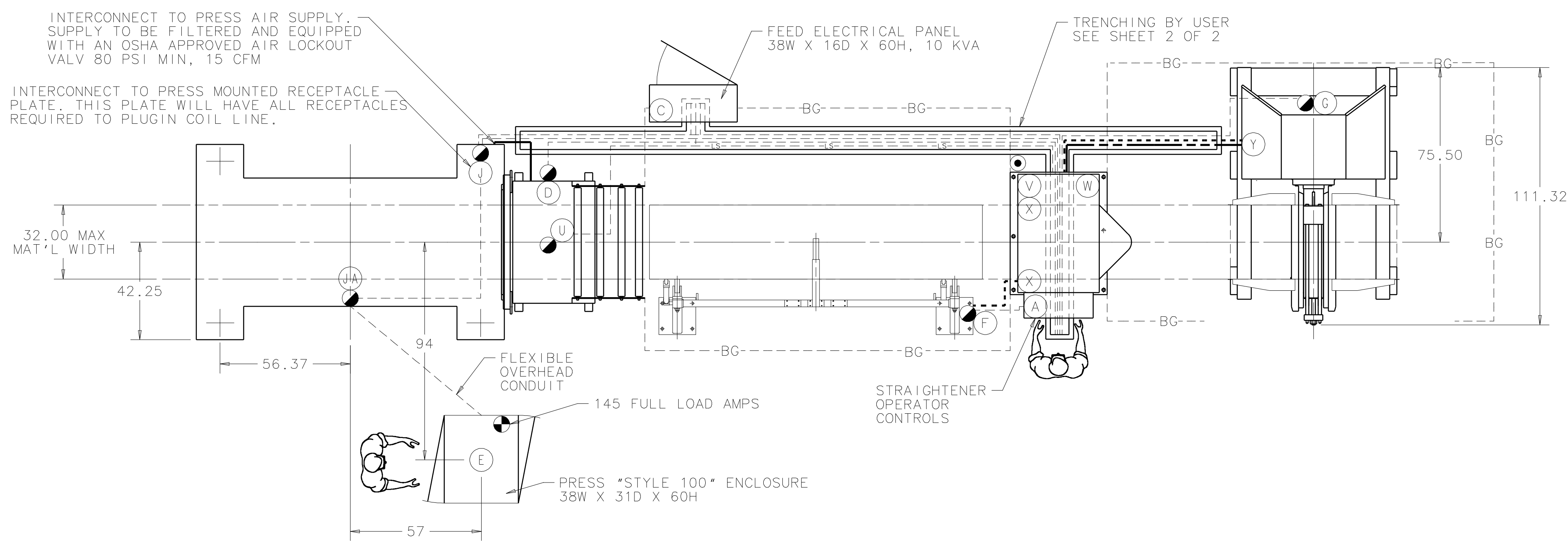
  

| <b>LUBE</b> |                                |         |
|-------------|--------------------------------|---------|
| V1          | → V1 STRAIGHTENER TO FEED..... | J3 ← J3 |

**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.

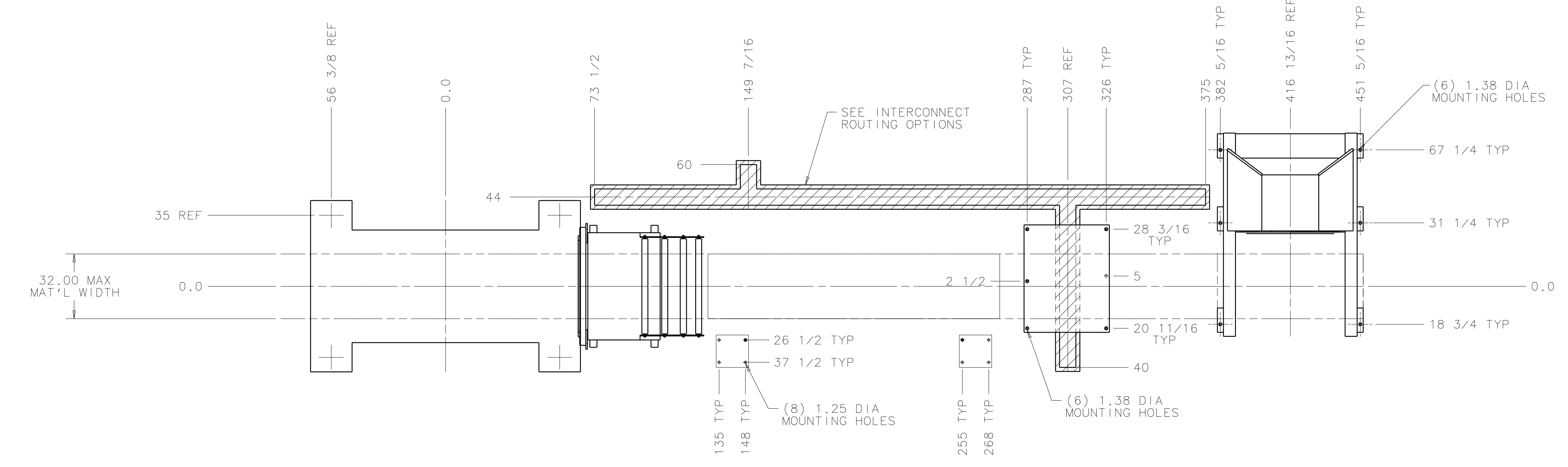
**SYMBOL KEY**

- INDICATES ELECTRICAL SUPPLY LINES
- INDICATES PNEUMATIC SUPPLY LINES
- INDICATES HYDRAULIC SUPPLY LINES
- LS----- INDICATES LUBRICATION SUPPLY LINES
- ⊕ INDICATES ELECTRICAL DROP 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 USER'S FULL RESPONSIBILITY TO PROVIDE ADEQUATE COIL LINE BARRIER GUARDING PER ANSI B11.18 SPECIFICATIONS AND ALL OTHER APPLICABLE SAFETY STANDARDS.



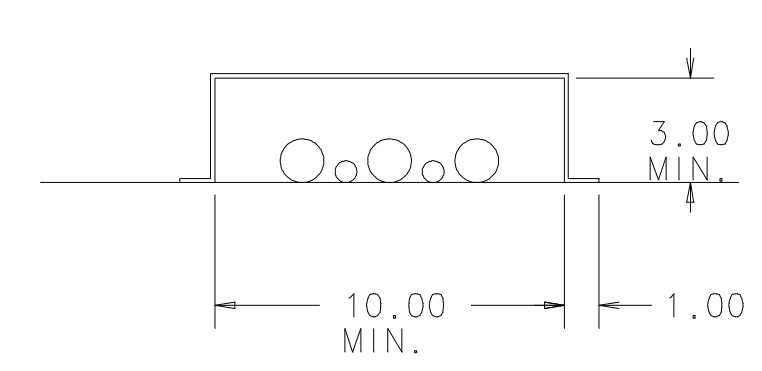
| <b>FEED LINE SPECIFICATIONS</b>   |  |
|---|--|
| <b>EQUIPMENT</b>  |  |
| LINE DIRECTION: RIGHT TO LEFT   |  |
| LINE SPEED: 40-1200 INCHES PER MINUTE   |  |
| PRESS SPEED: 45-90 SPM  |  |
| MAX. STOCK WIDTH: 32"   |  |
| MIN. STOCK THICKNESS: .020"   |  |
| MAX. STOCK THICKNESS: .188" (LOOP)  |  |
| MAX. STOCK THICKNESS * FULL WIDTH: .125" (FEED)   |  |
| MAX. STOCK WIDTH * .188" THICKNESS: 18" (STR)   |  |
| MAX. COIL WEIGHT: 24,000 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 36" IS BASED ON MAX MAT'L THICKNESS OF .188" (LOOP) WITH A RECOMMENDED MAX FEED PROGRESSION OF APPROX 15". |  |
| NOTE: ALL LINE DATA IS CALCULATED FOR MILD STEEL (50,000 PSI YIELD STRENGTH)  |  |

|                                       |   |                |                    |
|---------------------------------------|---|----------------|--------------------|
| TOLERANCES UNLESS OTHERWISE SPECIFIED | <b>THE MINSTER MACHINE CO.</b><br>BEAUFORT, S.C., U.S.A.<br><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     | DRAWING DATE       |
| MACHINING                             |   | SUPERSEDED BY  | 2000-01-21         |
| X AND X.X ±.100                       | PATTERN PART NUMBER   | DLH            | CHECKED BY         |
| X.XX ±.010                            | PART NAME   | L/O, FLOORPLAN | FRM                |
| X.XXX ±.001                           | ESTIMATED WEIGHT  |                | LAST REVISED BY    |
| X.XXXX ±.0005                         | MATERIAL  | OMEGA MOTION   | KSS                |
| CLASS 2B THDS (INCH)                  | REFERENCE NUMBER  |                | LAST REVISION DATE |
| CLASS 6H THDS (MM)                    | DRAWING SCALE   | .0312          | 2002-03-07         |
| FINISH: .125 MICROINCHES              | SHEET NUMBER  | 1              | REVISION LEVEL     |
| BREAK SHARP CORNERS .03               | GROUP TECH. NUMBER  | 9999           | 000                |
| [ZL015][ZL015][ZL015]                 | SHEET NO.   | 2              | PART NUMBER        |
|                                       | OF SHEETS   |                | 1215-301           |



**INTERCONNECT ROUTING OPTIONS**

**ABOVE FLOOR INTERCONNECT COVER**



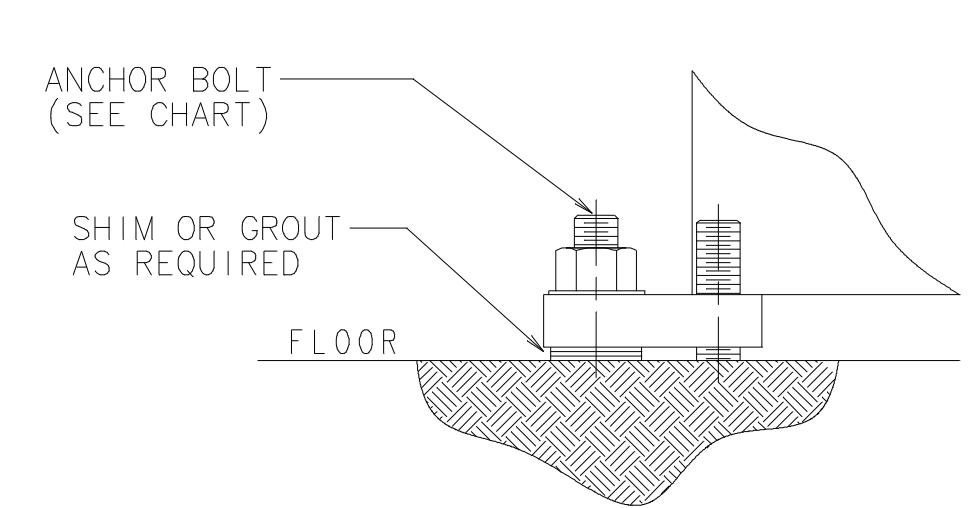
**BELOW FLOOR INTERCONNECT TRENCH**



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               |

**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<br>X AND X.X ±.100<br>X.XX ±.010<br>X.XXX ±.001<br>X.XXXX ±.0005                       |  | SUPERSEDED BY  | 2000-01-21             |
| CLASS 2B THDS (INCH)<br>CLASS 6H THDS (MM)<br>FINISH .125 MICROINCHES<br>BREAK SHARP CORNERS .03 | PART NAME  | L/O, FLOORPLAN | CHECKED BY<br>PRM      |
|  | GROUP TECH. NUMBER   | 9999           | ESTIMATED WEIGHT       |
|  |  |                | LAST REVISED BY<br>KSS |
|  |  |                | MATERIAL               |
|  |  |                | LAST REVISION DATE     |
|  |  |                | OMEGA MOTION           |
|  |  |                | REFERENCE NUMBER       |
|  |  |                | DRAWING SCALE          |
|  |  |                | .0312                  |
|  |  |                | REVISION LEVEL         |
|  |  |                | 000                    |
|  |  |                | SHEET NO.              |
|  |  |                | 2                      |
|  |  |                | OF SHEETS              |
|  |  |                | PART NUMBER            |
|  |  |                | 1215-301               |