

CUSTOMER
ORDER NO.

INVOICE NO. 1-261
INVOICE DATE 8/09/85

PROJECTED SHIPMENT

DATE 12/18/84

SHIPPED 8/07/85

SOLD BY Ball Pers Systemen BV

ORDER NO.

RELEASED 2/01/85 ROUTE Arrowhead Services &
Smith's Transfer to NY.

REVISED

DUNS NO. 91-000-6048

Mapro B. V.

SOLD TO Sigarenmakerstraat 8

Postbus 3070

5203 DB 's-Hertogenbosch

Nederland

SHIP TO

MAPRO B. V.

VIA ROTTERDAM

MADE IN U.S.A.

BOX 1/UP

Attention: Mr. H. A. C. Holweg

TERMS: SEE LAST PAGE FAS VESSEL NYC AREA PORT

DAC OUR ORDER NO. 26017

ORDERED	SHIPPED	DESCRIPTION	UNIT	AMOUNT
1	1	<p>E2-300-84 MINSTER "HeviStamper", Two Point, Eccentric Shaft, Progressive Die Press</p> <p><u>SPECIFICATIONS:</u></p> <p>Tonnage, heavy duty rating, 300 Dia. of ecc. shaft @ mains and ecc., 203.20-476.25 (8" - 18.75")</p> <p>Stroke of slide, 304.80 (12") Adjustment of slide, 152.40 (6") Shutheight S.D.A.U. on bolster, 533.4 (21") Shutheight S.D.A.U. on bed, 762 (30") Thickness of bolster plate, 228.6 (9") Area of slide, R-L x F-B, 2133.60 X 1219.20 (84 x 48") Area of bolster, R-L x F-B, 2133.60 X 1219.20 (84 x 48") Area of bed, R-L x F-B, 2133.60 X 1219.20 (84 x 48") Bed opening, RLxFB with (1) 3.0" rib located 10" to right of press centerline, 1981.20 x 838.23 (78" x 33") Distance between gib surfaces R-L, 2184.40 (86") Distance floor to top of bed, 1041.44 (41") Height under bed to floor, 139.70 (5.5") Upright opening F-B x as high as possible 685.80 (27") Strokes per minute (F.E. @ 40), 0-80 Motor HP and speed, 75-1500 Approx. weight, press only, 47045 (103,500 lbs.)</p> <p><u>DRIVE</u></p> <p>- Single geared. Twin driving gears on main shaft, extensions on both ends. High tensile iron main drive gears and steel pinions, totally enclosed, running in oil.</p>		

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		<p>Equipped with MINSTER combination air operated multiple disc friction clutch and brake. Clutch located on driveshaft. Includes exhaust muffler.</p> <p>Automatic flywheel brake, wired in drive stop circuit. Includes fast stopping arrangement in clutch and brake unit.</p> <p><u>NOTE:</u> Crankshaft tonnage curve and flywheel energy calculations requested with approvals.</p> <p><u>FRAME:</u></p> <p>Frame of four piece tie rod construction with crown and bed of welded steel, drilled for "Heatrex" heaters.</p> <p>Feed pads on right and on left hand side for mounting customer's feed, less roll lifter pads. Customer to supply and mount feed.</p> <p><u>MAIN SHAFT:</u></p> <p>Two point eccentric shaft forged of alloy steel.</p> <p><u>BEARING ARRANGEMENT:</u></p> <p>Main shaft bearings made of special alloy bronze. Driveshaft mounted on anti-friction bearings. Support wedges between main bearing caps and uprights.</p>		

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		<p><u>GIBS:</u></p> <p>Eight bronze lined gibs, adjustable F to B and R to L.</p> <p><u>PNEUMATIC COUNTERBALANCE:</u></p> <p>Equipped with pneumatic counterbalance system on the slide completely piped, including air controls and certified surge tank when required.</p> <p><u>SLIDE (RAM):</u></p> <p>Lower connection bearings in slide bushed with renewable bronze plug type saddle bushings. Slide face machined to customer's specifications.</p> <p><u>SLIDE ADJUSTMENT:</u></p> <p>Long barrel type motorized adjustment on slide, complete with limit switches, direct reading shutheight indicator reading in millimeters and brake motor, but exclusive of controls.</p> <p><u>BOLSTER:</u></p> <p>Cast Iron bolster plate machined to follow customer's drawing. Bolster plate to accommodate bolster inserts X-1123-972, X-1123-973, and X-1123-974. (Customer has these inserts from existing press.) Minster to provide new bolster insert machined to follow customer's drawing and with reference to previous inserts. Bolster machined to accept .015 to .020 shim stock under insert flanges.</p>		

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		<p><u>CUSHION</u></p> <p>Equipped with 1 internally guided, sliding type, pneumatic die cushion, having a total capacity of approximately 30.7 tons at 100 PSI air pressure. Complete with regulating accessories, replaceable steel pressure pin plate on top of pressure pad. Sliding is accomplished by rack and pinion. Cushion stroke 76.20 MM (3").</p> <p>Equipped with air operated, electrically timed, lost oil lube system for above cushion system, <u>in place of one shot system.</u></p> <p><u>LUBRICATION:</u></p> <p>MINSTER patented "Monitorflow" recirculating oil lubrication system with continuous flow to all main and connection bearings, driveshaft bearings, gears, gibs, and counterbalance cylinders. Flow to all the main and connection bearings is constantly monitored so that loss of flow caused by blockage between the sensor and the bearings is sensed and indicator lights signal the location of the clogged line. The "Monitorflow" system also signals faults due to broken lines throughout the system, clogged filters, low oil level in reservoir, inadequate flow, or faulty pump. Any fault signal turns off the clutch control stopping the slide. The "Monitorflow" system includes pump, motor and controls, sensors, indicator lights, and dual filters with replaceable cartridges. Filter cartridges are replaceable with lube system running.</p>		

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ORDERED	SHIPPED	DESCRIPTION	UNIT	AMOUNT
		<p><u>GENERAL:</u></p> <p>Press painted Vista Green. Arranged for grooved V-belt motor drive, including motor plate, belts and sheave, but exclusive of motor and motor control. Includes one set of four, Vibro-Dynamics free standing isolator/leveling type press mounts.</p> <p>Legend plates to be in Dutch.</p> <p>Press Serial No.: E2-300-26017</p>		

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1	1	<p>MINSTER CENTRALIZED MOTOR AND CLUTCH CONTROL PANEL, NEMA Type 12 enclosure, built to MINSTER's interpretation of ANSI - B11.1 - 1982 and to NFPA #79 Specifications. Also meets NEC and CSA Standards.</p> <p>Main panel contains the press clutch control circuit, plus a circuit breaker, reversing slide adjustment starter, and a Size No. 4 magnetic reversing drive starter for system voltage:</p> <p>380 Volts, 3 Phase, 50 Cycle</p> <p>Main panel includes Wye-Delta starting system to be used in conjunction with the magnetic starter described above.</p> <p>Main control panel located in floor mounted cabinet. (Customer to supply connecting leads and conduit between press and main panel - customer to specify terminal box location on press.)</p> <p>Press to be wired and piped for high pressure inching arrangement.</p> <p>The setup units, including the motor control units, motor on pilot light, lube fault light, and clutch selector switch to select Inching, Single Stroke, or Continuous operation. Setup units located: ON SWINGING PENDANT</p> <p>Basic set of operator buttons, including two hand Inching arrangement, two guarded Run buttons to operate press, continuous "Arm/Ready" red illuminated button, Top Stop button, and Stop Control button. This group of buttons located:</p>		

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		<p>ON SWINGING PENDANT</p> <p>Additional Stop button located: ON L.H. FRONT UPRIGHT ON R.H. REAR UPRIGHT</p> <p>Allen Bradley Style "EF" Rotary Limit Switch and motion detector for press control with the following poles: 10 Adjustable In Motion</p> <p>MINSTER Tandem Clutch Air Valve with detector switches and control unit.</p> <p>2 Safety block receptacles, less blocks and chain.</p> <p>6-Digit electronic digital counter, lock-reset type.</p> <p>2 Die check receptacles in press stop circuit.</p> <p>Includes electronic zero speed switch for Eddy current drive to prevent reversing drive while in motion.</p> <p>Barrier guard receptacle on front and rear of press.</p> <p>Clutch and motor control circuits, including push-buttons operate on 110 VAC from control transformer which has a minimum of 100 VA extra capacity for machine lighting.</p>		

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1	1	75 HP, 1500 RPM, 50 cycle, Wye Delta, Eddy Current Drive. Clutch portion is open frame -- motor portion is TEFC, "U" type, complete with tachometer. Includes MINSTER excitation unit, remote speed control, remote speed indicator located in setup station. Includes torque limit control.		
TOTAL PRICE, EACH, F.O.B., MINSTER, OHIO, U.S.A.....				
Cost of Inland Freight, Export Boxing and Pier Delivery.....				
TOTAL PRICE, EACH, F.A.S. VESSEL, N.Y.C. AREA PORT..				
LESS PAYMENT RECEIVED.....				
BALANCE DUE.....				
TERMS OF PAYMENT:				
20% with order.				
70% on shipment from Minster.				
10% on completion of installation or 30 Days from delivery into customer's plant.				
THE MINSTER MACHINE COMPANY				
Dennis Cattell Regional Manager International Group				