

WORK ORDER - FINAL ISSUE

CUSTOMER: SALES. NO. 043497

DESCRIPTION: VERTICAL PREHEAT OVEN #3 I.D. NO. 104800006

W.O. DATE: 6/25/99 P.O. DATE: 6/25/99

SHIP DATE: 9/2/99

CC: ENGINEERING
MANUFACTURING
PURCHASING
ACCOUNTING
SALES

PROVIDE THE FOLLOWING:

- + ONE (1) VERTICAL PRE-HEAT OVEN
- + TWO SETS OF QUARTZ PANELS, VERTICAL ORIENTATION
- + OVENS TO BE MINIMUM 43" W. X 80" TALL
- + OVENS TO BE POWER DRIVEN IN AND OUT
- + PROVIDE AUTO OVEN RETRACT IF THE FORMER SHUTS DOWN OR AN E-STOP IS PRESSED
- + EACH OVEN TO BE SPLIT INTO 2 EQUAL WIDTH ZONES FOR A TOTAL OF 8 ZONES, WITH SOLID STATE TEMPERATURE CONTROLLERS, THERMOCOUPLE FEEDBACK (TYPE K)
- + FREE STANDING CONTROL SYSTEM
- + PROVIDE LOCKING CASTERS ON PRE-HEAT OVEN ON ALL FOUR CORNERS
- + POWER NIP SHEET PAYOUT
- + LOCATE DAN FOSS CONTROLLER ON LOAD SIDE, ACCESSIBLE WHILE THREADING SHEET INTO THE NIP WHEELS

PRE-HEAT OVEN #3 WORK ORDER
SALES NO. 043497
PAGE 2

- + LOCATE LOAD/RUN SWITCH SAME AS ABOVE
- + PROVIDE SELECTOR SWITCH TO MANUALLY OPEN/CLOSE NIP WHEELS DURING THREAD UP
- + PROVIDE METHOD TO REGULATE PRECISELY THE SPEED OF MATERIAL PAYOUT TO MINIMIZE STARTS AND STOPS TO KEEP UNIFORM HEATING
- + PROVIDE ABILITY TO MOMENTARILY RELEASE THE NIP WHEELS FROM THE DRIVE TO ALLOW THE MATERIAL TO STRAIGHTEN OUT
- + PROVIDE STAINLESS STEEL SUPPORT PAN TO KEEP MATERIAL FROM CONTACTING THE FLOOR AT THE INFEED END
- + NEED SHEET SIDE GUIDES ON ALL ROLLERS
- + 3,000 LB ROLLS ON CARTS FOR INVENTORY