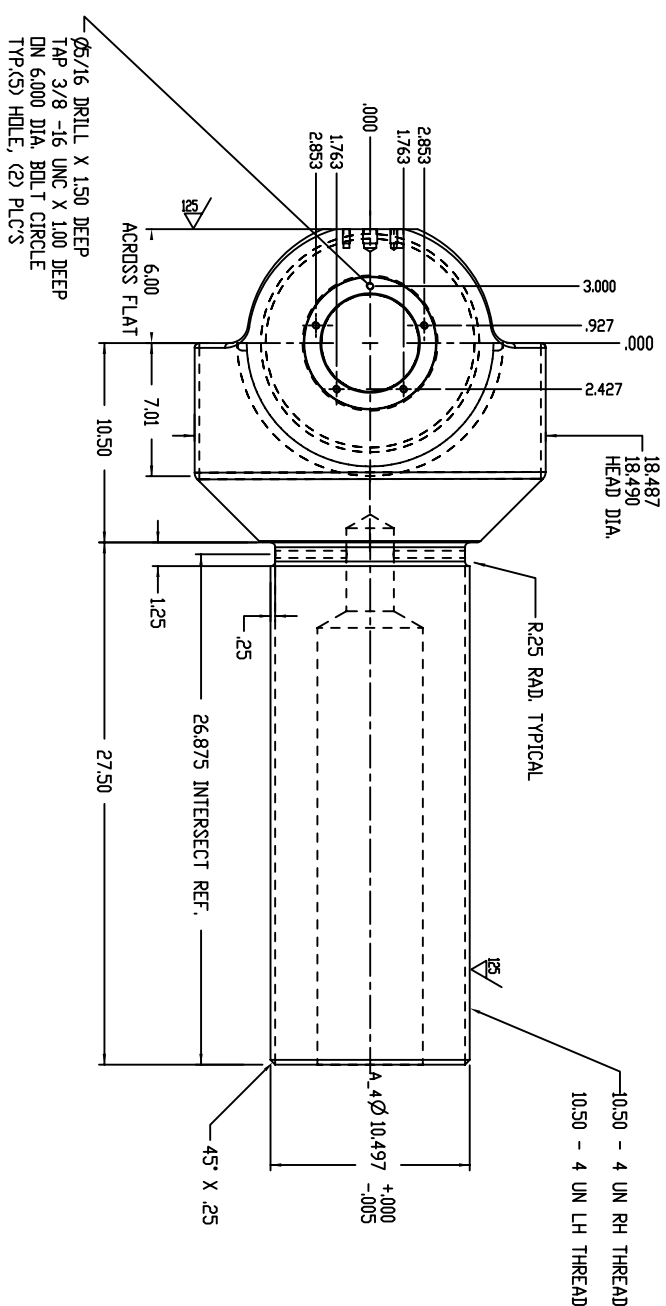
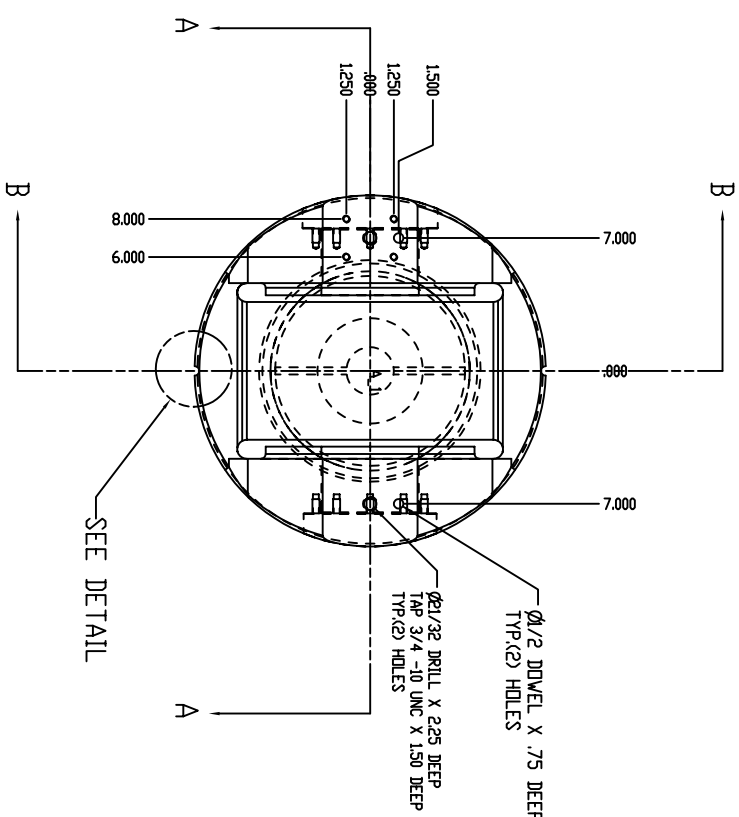
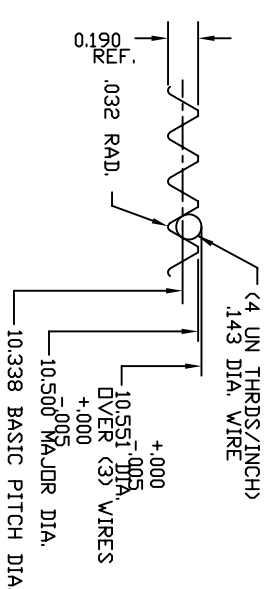
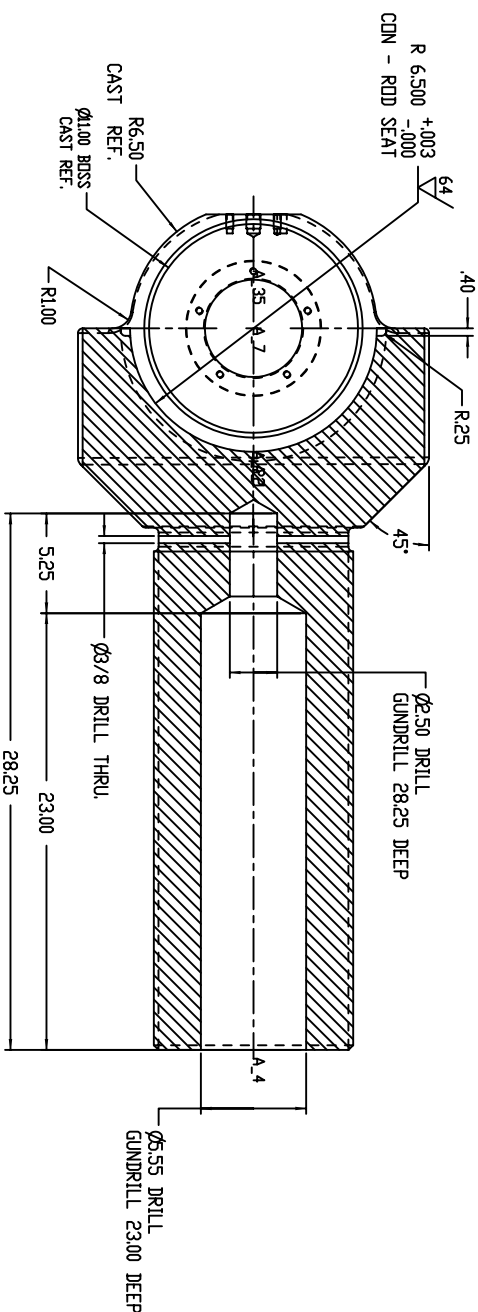
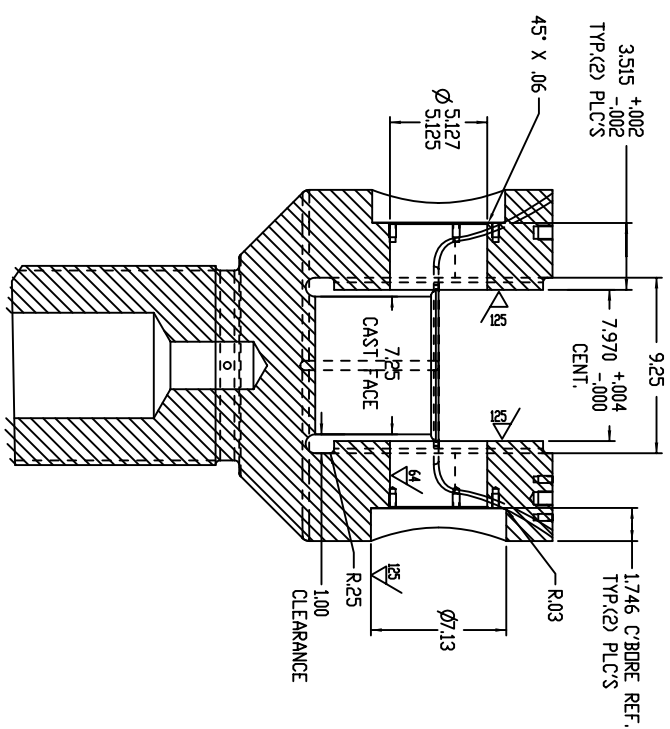



REVISED			
SYN.	DESCRIPTION	DATE	APPROVED



APPROX. TOTAL FINISH WEIGHT:		1141 LBS
	DUCTILE IRON (90-55-06)	
ITEM QTY.	MATERIAL	PART DESCRIPTION
		WT LBS

 *EAGLE PRESS & EQUIPMENT CO. LTD.*

THIS IS ONLY TO SCALE. IF P-DRILL FORMATS DIMENSIONS DO NOT SCALE TO DRAWING DIMENSIONS, THE DIMENSIONS SPECIFIED ON THIS DRAWING SHALL BE USED.	INCHES 2 PLACE SIZE 4 PLACE SIZE	CONCRETE IDENTIFICATION THIS DRAWING IDENTIFICATION CONTAINS INFORMATION IS NOT TO BE USED FOR IDENTIFICATION PURPOSES. IT IS THE RESPONSIBILITY OF THE USER TO IDENTIFY THE DRAWING. IF THE INFORMATION IS NOT TO BE USED FOR IDENTIFICATION PURPOSES, IT IS THE RESPONSIBILITY OF THE USER TO IDENTIFY THE DRAWING.	JOB NO.	DESIGNED	DRAWN	1650 TON EAGLE PRESS ADJUSTMENT SCREW	(SHEET 1 OF 1)	REVISED	
			1207	--	GL				
			MODEL NO.	REF.	CHECKED				SCALE
			S14-1650-200-72	1019A	TB				7/32
METALSA		DATE			DRAWING NO.	261-1207		-	

DIMENSIONAL TOLERANCES UNLESS OTHERWISE SPECIFIED		INCHES		1 PLACE ±.001 2 PLACE ±.01 3 PLACE ±.02 4 PLACE ±.05 5 PLACE ±.08 6 PLACE ±.10 7 PLACE ±.12 8 PLACE ±.14 9 PLACE ±.16 10 PLACE ±.18 11 PLACE ±.20 12 PLACE ±.22 13 PLACE ±.24 14 PLACE ±.26 15 PLACE ±.28 16 PLACE ±.30 17 PLACE ±.32 18 PLACE ±.34 19 PLACE ±.36 20 PLACE ±.38 21 PLACE ±.40 22 PLACE ±.42 23 PLACE ±.44 24 PLACE ±.46 25 PLACE ±.48 26 PLACE ±.50 27 PLACE ±.52 28 PLACE ±.54 29 PLACE ±.56 30 PLACE ±.58 31 PLACE ±.60 32 PLACE ±.62 33 PLACE ±.64 34 PLACE ±.66 35 PLACE ±.68 36 PLACE ±.70 37 PLACE ±.72 38 PLACE ±.74 39 PLACE ±.76 40 PLACE ±.78 41 PLACE ±.80 42 PLACE ±.82 43 PLACE ±.84 44 PLACE ±.86 45 PLACE ±.88 46 PLACE ±.90 47 PLACE ±.92 48 PLACE ±.94 49 PLACE ±.96 50 PLACE ±.98 51 PLACE ±.100 52 PLACE ±.102 53 PLACE ±.104 54 PLACE ±.106 55 PLACE ±.108 56 PLACE ±.110 57 PLACE ±.112 58 PLACE ±.114 59 PLACE ±.116 60 PLACE ±.118 61 PLACE ±.120 62 PLACE ±.122 63 PLACE ±.124 64 PLACE ±.126 65 PLACE ±.128 66 PLACE ±.130 67 PLACE 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REPRODUCED OR USED FOR ANY OTHER PURPOSE WITHOUT THE WRITTEN PERMISSION OF THE COMPANY. IT IS TO BE KEPT IN THE COMPANY'S FILES AND IS NOT TO BE LOANED, REPRODUCED, COPIED, OR IN ANY MANNER DISCLOSED TO ANY OTHER PERSON OR ENTITY. IT IS TO BE DESTROYED WHEN NO LONGER NEEDED FOR THE COMPANY'S USE.		DIMENSIONS IN INCHES. UNLESS OTHERWISE SPECIFIED, ALL DIMENSIONS ARE TO BE HIDDEN.			
JOB NO. 1207		MODEL NO. SL4-1650-200-72		DATE 12/29/04		SCALE 1/4		DRAWING NO. M4A71062-1931		REV. NO. 0	
DESIGNED RG		CHECKED TB		REF. ---		SHEET 1 OF 1		1650 TON EAGLE PRESS PITMAN			



EAGLE PRESS & EQUIPMENT CO. LTD.

5710 O'Neil Drive
Oldcastle, Ontario, N0R 1L0
Canada

Attention: **Luis Gerardo de la Garza**

Company: **Metalsa**

Address: Carr. Miguel Aleman km 16.5 No. 100

66600 Apodaca, NL

Mexico

Re: Quote #: 1207-IKV-140520rev_b

We are pleased to submit the following for your consideration:

Scope of work:

Dispatch 1 Industrial Mechanic to provide consultation for crown and slide adjust screw re-assembly. Customer is responsible for machining, rigging and installation of all components.

Any additional time required will be billed at Eagle prevailing rates.

****Special Note****

Eagle does not offer any warranties and is not responsible for the repairs being made by Metalsa or Metalsa's subcontractor

Daily Rates based on 8 hrs / day:

- Week day rate 8 hrs / day 9am – 5pm Mon – Fri: \$1,000.00
- Saturday rate 8 hrs 9am – 5pm: \$1,600.00 / day
- Sunday / holiday rate: 8 hrs / day 9am – 5pm: \$2,400.00 / day
- Out of town stand by rate for weekends \$1,000.00 / day

Daily labor cost breakdown:

Tues May 27 – Travel day – \$1,000.00

Wed May 28 – Fri May 30 – on site (8hrs) – \$1,000.00 x 3 = \$3,000.00

Sat. May 31 – On site (8hrs) - \$1,600.00

Sun Jun 1 – (stand by) - \$1,000.00 / on site (8hrs) \$2,400.00

Mon Jun 2 – Thurs Jun 5 – On site (hrs / day) \$1,000.00 x 4 = \$4,000.00

Fri Jun 6 – on site (8hrs) \$1,000.00

Sat Jun 7 – travel day – \$1,600.00

Expenses: \$5,606.00

Total cost (Stand by on Sunday) = \$18,806.00 USD

Option 4 hrs on Sunday = additional \$ 800.00 USD

Terms: Payment with P.O.

Delivery: May 27 – June 7 2014

Thank you for the opportunity to quote on this project

Best regards,

Igor Varga

Service Manger

Eagle Press & Equipment Co. Ltd.

* If additional time is required the following rates will apply:
Labour Rates: As per Eagle 2012 Rate Schedule
Straight time rate applies: 7:00 am to 3:30 pm Mon. - Fri.
Double time rate applies: after 3:30PM. & Saturdays
Triple time rate applies: Sundays & Holidays
Fluid disposal / fluid fills, man lifts, rigging and crane equipment are not included

Repair Warranty:

Terms Goods replaced and repairs performed by **Eagle Press & Equipment Co.** are warranted to be free from defects in material and workmanship respectively under normal use for a period of six (6) months from the date of delivery. Re-used and/or purchased items incorporated into repairs and/or rebuilds will be guaranteed only in so far and to the extent that the manufacturer of these items guarantees them to **Eagle Press & Equipment Co. (E.P. & E.)**. This warranty is limited to supplying the buyer (F.O.B. point of manufacture) replacement goods and parts, which have been found to be defective under examination by **E.P. & E.** authorized representatives. The buyer shall prepay transportation charges on material or equipment returned to **E.P. & E.** for examination, reworking and/or replacement. It will be the responsibility of the buyer to arrange at his/her expense adequate lifting and moving facilities (if heavy lifts are required) to carry out repairs and/or adjustments at his/her facility. **E.P. & E. will not, under any circumstances, be liable for damages and/or injuries which may be incurred by the buyer, its agents, or employees as a result of delays, defective workmanship or material supplied under this order.** If at any time the buyer misuses, alters or changes, in any manner, any item, part, operating characteristic, or safe guarding device or if preventive maintenance is not carried out as required, that action nullifies all warranties herein previously expressed in writing and buyer agrees to indemnify and hold harmless **E.P. & E.** from and against all damages (direct, consequential, or indirect), liabilities or obligations which were previously agreed upon or otherwise that the buyer may incur or sustain. There are no conditions, terms, agreements, representations or warranties inferred or implied except as are expressly contained herein in writing. **E.P. & E.** shall in no event be held liable for any indirect, special or consequential damages such as down time or the like. Buyer shall be responsible for all safety devices and guards required to comply with legislation governing occupational health and safety matters and the use of equipment. This is the entire warranty granted by **E.P. & E.** and any amendments thereto, to be effective, shall be in writing and signed by buyer and **E.P. & E.**

Indemnification:

It will be the buyer's responsibility to supply and ensure, in accordance with all applicable health and safety legislation in buyer's jurisdiction, the use of a properly applied and adjusted point of operation safety device on every operation performed on its presses. Without limiting the generality of the foregoing the buyer shall use and shall require the use of all necessary safety devices and guards as well as safety procedures, in any event and not less than required in buyer's jurisdiction. If the buyer fails to comply with safe operating procedures and/or modifies or removes any safe-guarding devices or breaches any health or safety legislation, buyer agrees to indemnify and hold **E.P. & E.** harmless from any damages, liability or obligation to persons or articles, injured or damaged directly or indirectly in connection with the operation of the equipment.

In the event of any incident or malfunction involving an EAGLE PRESS, the buyer shall, within 30 days of an accident, notify **E.P. & E.** and shall cooperate fully with **E.P. & E.** in investigating and determining the cause of any such accident or malfunction failing which

E. P. & E. is released from all warranties to buyer.

Service to Our Customers:

All service warranty work rendered will be completed during **E. P. & E.** regular working hours. Any work requiring overtime hours will be the responsibility of the buyer.


Acknowledgement of Indebtedness and Repairer's Lien:

The customer hereby acknowledges the indebtedness to be specified and agrees to pay **E. P. & E.** in full for all amounts owing as a result of this repair. **E. P. & E.** may retain a repair lien at any time securing the balance pursuant to the Repair and Storage Liens Act, R.S.O. 1990 or equivalent with all the rights of a lien and without limitation, the right to repossess and retain or repossess and sell the subject goods to satisfy the amount owing and its costs incurred in connection therewith. Interest on past due account is 2% per month.

EAGLE PRESS & EQUIPMENT CO. LTD.

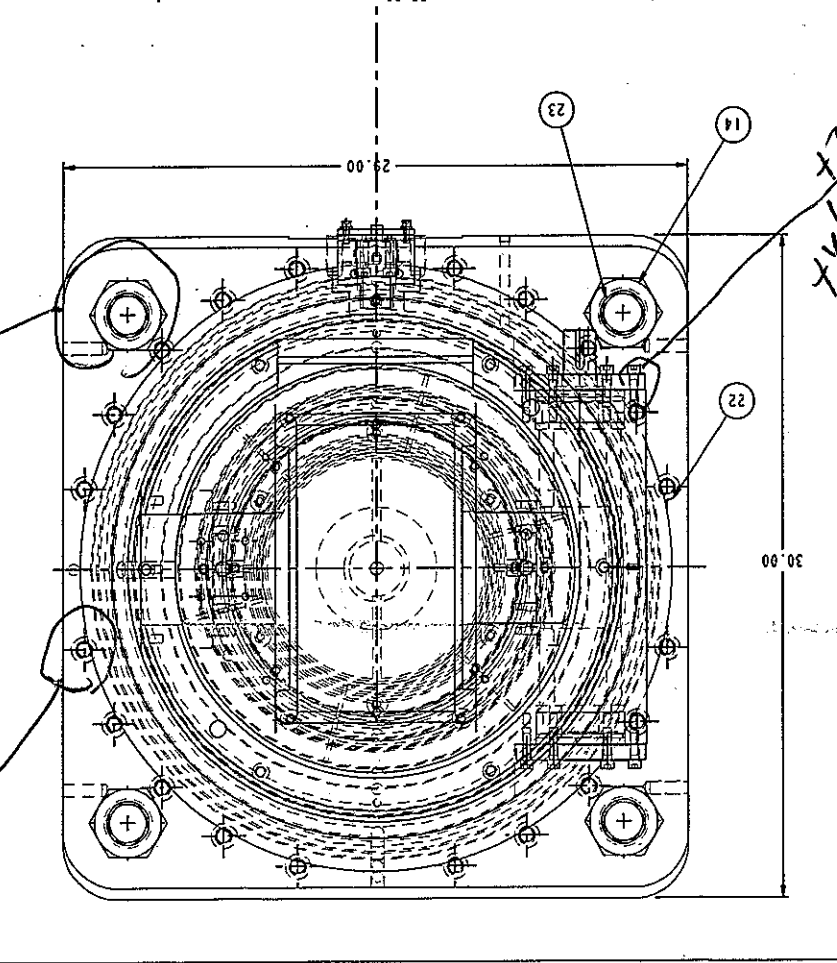
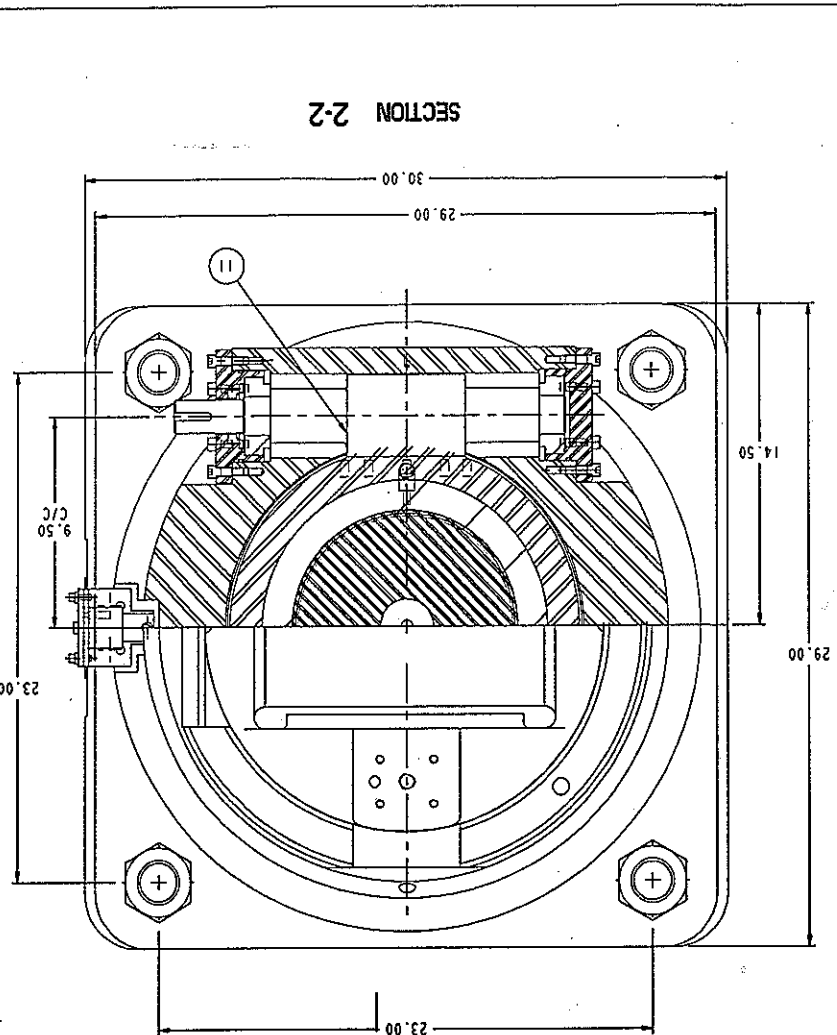
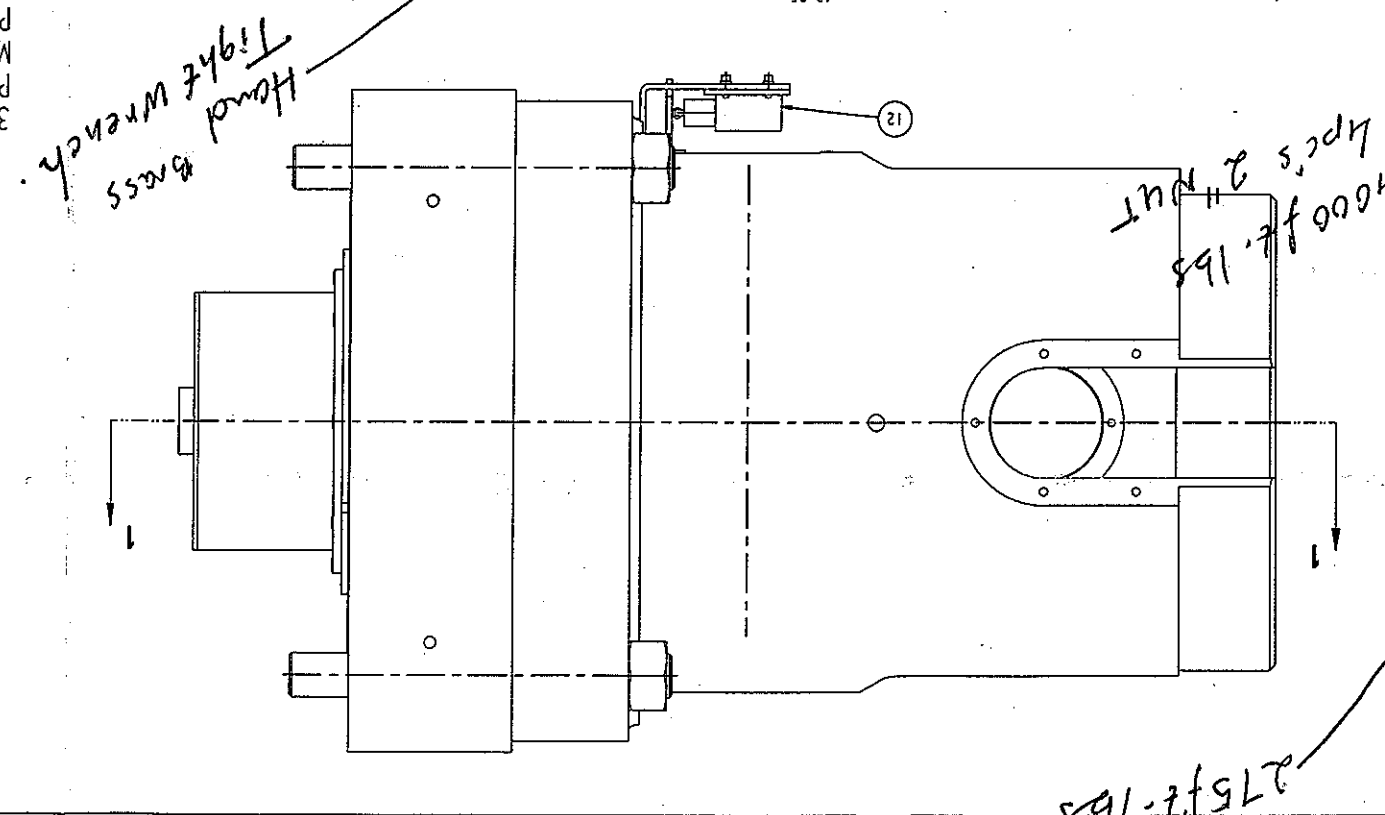
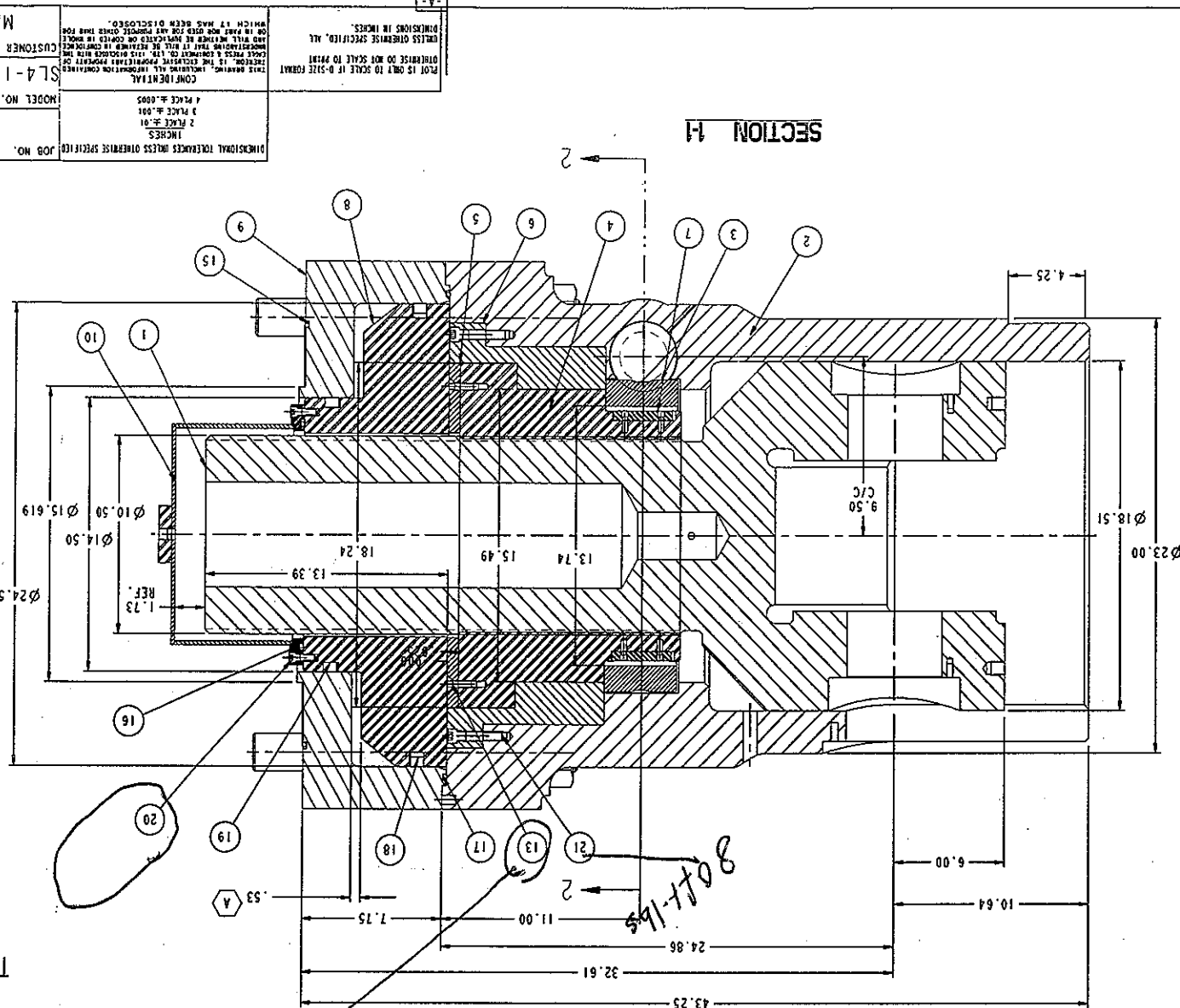
FASTENER SEATING TORQUE TABLE

FASTENER DIA.	TORQUE
(in)	(lb x ft)
3/8	30
1/2	80
5/8	150
3/4	275
7/8	460
1	700
1 1/8	825
1 1/4	1200
1 1/2	2100
1 3/4	3300
2	5000

SYM.	DESCRIPTION	DATE	APPROVED
	0.53 WAS 0.75	2/15/05	18

APPROX. TOTAL WEIGHT:		5686.9 V 3	
23	4	STUD	STUD (GRADE B7)
22	20	SHCS, 104	SHCS
21	6	SHCS, 102	SHCS
20	8	SHCS, 101	SHCS
19	1	POLYPAR 6	PARKER POLYPAR SEAL
18	1	POLYPAR	PARKER POLYPAR SEAL
17	1	O-RING, STRIP	Ø 1.14" O-RING STRIP
16	1	O-RING, 2.452	O-RING NO 2-452
15	1	O-RING-2471	O-RING-2-471
14	4	HEX, NUT	Ø2.00 - 4.5 UNC
13	12	FHS CS	FHSMS (BRASS)
12	1	1201, 290	HYD/O L/SWITCH ASSY
11	1	1201, 270	WORM SHAFT ASSEMBLY
10	1	1201, 269	BONNET
9	1	1201, 268	PISTON HOUSING
8	1	1201, 267	PISTON
7	2	1201, 266	DRIVE KEY
6	1	1201, 265	SPACER
5	1	1201, 264A	WEAR PLATE
4	1	1201, 264	ADJUSTING NUT
3	1	1201, 263	WORM GEAR
2	1	1201, 262	BARREL HOUSING
1	1	1201, 261	ADJUSTING SCREW
		WT. LBS	

EAGLE PRESS & EQUIPMENT CO. LTD.

[illegible]

30 ft. - 15 ft.
Hand height
Rack +

7/5/98
4/3 - 2008

4600 ft. 198
4600 ft. 198

Hand Tight Wrench.

75 TONS REQ'D / RAM ADJUSTMENT
PISTON FACE = 306 SQ. IN
MINIMUM HYDRAULIC PRESSURE = 2500 PSI
RECHARGED @ 1490 PSI
TOTAL OIL (4) REQ'D/PRESS



Hydraulic OLV Protector System Design Information

Dec 10, 2004

Eagle Press
1650 Ton
for Metals

Quotation #: Q-9131
JIT Job #:
Inquiry #: RFQ

Customer Data

Enter the following data for your press and overload cylinder parameters

Inner diameter of cylinder(s): 14.5 inches
Outer diameter of cylinder(s): 24.5 inches
Number of overload cylinder(s): 4
Maximum Press Speed: 26 S.P.M.

Press Stroke Length: 18 inches
Capacity Point, Y: .5 inches
Press Tonnage: 1650 tons
Cylinder Stroke, S: .75P inches

**** Please sign and date below for confirmation of data. ****

Signature: per T. Boros 9/1/2004

Date: _____

STEP #1

Velocity of the slide overload cylinder(s) V1, at capacity point Y must be known to determine relief flow rate through the OLV Protector Valve. Estimated slide velocity in feet per minute is ... 40.27 ft/min. Enter the actual slide velocity if different from the estimated value 42.0 ft/min.

STEP #2

Optimum flow rate through the OLV Protector Valve ranges from 150 ~200 m/sec. Using the number of OLV Protector Valves and cylinder dimensions, the upper and lower limits of the orifice diameter, d, are as follows:

Minimum orifice diameter: 23.17 mm (@ 200 m/sec flow rate)

Maximum orifice diameter: 26.75 mm (@ 150 m/sec flow rate)

OLV Protector Orifice Diameter d (mm): 24.5

Number of Valve(s): 2

Effective orifice diameter, d_{eff} , is: 34.6 mm

STEP #3

Relief Flow Rate is determined to be V2 = 179 m/sec

STEP #4

Calculation of the pressure settings for the OLV Protector Valve System

Hydraulic overload relief pressure @ 110% press tonnage, $P_r = 2963$ psi

Recommended SR Pump Unit: SR100-20-BB46

Maximum regulated balance air pressure to OLV Protector, $P_b = 74$ psi

Number of pumps: 2 Est. Charge Time: 122 seconds

Hydraulic preload pressure (SR Pump output pressure) = (see below) psi

Required Reservoir Capacity: 15.91 US gallons
(Minimum 4X total volume of overload cylinders).

Enter the maximum preload pressure if a low-preload pressure system is desired: 1300 psi

Preload pressure must be less than press cylinder pressure at specified press tonnage.

Required pneumatic supply pressure for the SR100-20-BB46 pump to deliver 1300psi preload pressure is: 57 psi

SR OLV Protector Adjustment Table for: R24.5-209-1-95-70-EQ36

Hydraulic Relief Pressure, $P_r = 21.74 P_b + 1349$ psi ($= 21.74 P_b + 95 \text{ Kg/cm}^2$)

Press Output	OLV Balance Pressure
1815 tons (110%)	74 psi
1732 tons (105%)	68 psi
1650 tons (100%)	61 psi
1567 tons (95%)	55 psi
1485 tons (90%)	49 psi
1402 tons (85%)	43 psi
1320 tons (80%)	37 psi
1237 tons (75%)	30 psi
1155 tons (70%)	24 psi
1072 tons (65%)	18 psi
990 tons (60%)	12 psi

Designer's Notes

- Minimum air pressure to SR Pump unit is 2 kgf/cm^2 [28 psi]. Pump will stall below this value.
- Reservoir capacity should be at least four (4) times the total cylinder volume(s).
- Separate air regulator is recommended for the SR Pump if a low preload pressure system is required.
- Bleeding off the regulated air balance pressure, P_b , when the preload pressure is greater than 1349 psi will dump the overload system to the reservoir.