

GIDDINGS & LEWIS®

WORK ORDER

PAGE 2 OF 5	SALES NO. 61247
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Code	Rev	Description	Amount
		<p><u>BUILT-IN CONTOURING ROTARY TABLE</u></p> <p>Inductosyn feedback</p> <p>Number of positions ----- 360,000</p> <p>Rotary table capacity ----- 8,000 lbs. 3,630 kgs.</p> <p>Rotary table torque ----- 13,750 ft/lbs 18,640 N.M.</p> <p>Accuracy ----- ±5 seconds</p> <p>Repeatability ----- ±1.5 seconds</p> <p>Rotational speed ----- 2 RPM</p> <p>Traverse rate, per minute (x axis) --- 450 11,430</p> <p>Feed range, per minute (x axis) ----- .010-150 .25 - 3810</p> <p>Traverse rate, per minute (w axis) --- 300 7620</p> <p>Feed range, per minute (w axis) ----- .010-150 .25 - 3810</p> <p><u>WORKCHANGER</u></p> <p>Single stand carousel type workchanger modified to stop at multiple positions <u>mounted on a slide with 24" travel.</u></p> <p><u>Machine arranged to handle customer's 34" x 66" fixture.</u></p> <p>(Ref: Drawing No. 450-000-1058)</p> <p>Five pallets: Three (3) 39.4 x 39.4 (1000 x 1000)</p> <p style="padding-left: 40px;">Two (2) 39.4 x 49.2 (1000 x 1250)</p> <p>Four pallet stands</p> <p><u>MACHINE FEATURES</u></p> <p>Lubri-cool system</p> <p>Way covers on front and rear of bed and saddle</p> <p>Operator's worklight</p> <p>Replaceable hardened ways on column, bed and saddle</p> <p>Flood coolant thru spindle including external flood coolant, air blast for tool change and automatic selection from tape</p> <p><u>Note: No coolant pump required, see Barnes unit below.</u></p> <p>Machine to be arranged for customer's Barnes RD-212 chip filtration system. This unit uses a chip/coolant flume that replaces our chip conveyor. The unit also has a coolant pump to supply coolant thru spindle. Mechanical interface required to hook up to coolant pump. Electrical interface required to turn unit on with machine.</p> <p>Floor mounted coolant and chip enclosure with power door, including remote operators set-up box</p> <p>Foundation hardware kit</p> <p>NumeriProbe In-Process gauging with interface and software including: 360 degree rotational capabilities.</p> <p style="padding-left: 20px;">One (1) Spare probe head</p> <p style="padding-left: 20px;">One (1) Spare stylus</p> <p style="padding-left: 20px;">One (1) Spare battery</p> <p>NumeriDapt - Adaptive Control</p> <ul style="list-style-type: none"> - optimizes feeds automatically - monitors actual cut HP - provides automatic "shutdown" 	

We hereby certify that these goods were produced in compliance with all applicable requirements of Section 6, 7, and 12 of the Fair Labor Standards Act, as amended, and of regulations and orders of the United States Department of Labor issued under Section 14, thereof.

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		<p><u>ELECTRICAL EQUIPMENT</u></p> <p>Electrical equipment will comply with NEC and NFPA-84 electrical standards using NEMA devices.</p> <p>460 volts, 3 phase, 60 hertz.</p> <p><u>CONTROL SYSTEM</u></p> <p>Giddings & Lewis NumeriPath CNC 8000-M Numerical Control (Spec. No. CNC 8000-M 9-1-89) 1000 feet (305 M) part program storage</p> <p>NumeriStation - Hi-tech operator's station which includes 386 PC, 14" Color VGA, 40 MB hard disk, 4 MB RAM memory, 101 Key IBM compatible keyboard</p> <p>F Fixture offsets</p> <p><u>CM90 Cell Manager</u> including:</p> <p>Software integral to NumeriPath CNC 8000 Control G&L Cell management software Part selection menu Operation display pages Untended machining and workhandling</p> <p><u>PAINT</u></p> <p>Machine to be painted using Polyurethane enamel (Sherwin-Williams Polane or equivalent). Color: Pantone Cream</p> <p>E</p> <p>F TOTAL PRICE, F.O.B. Fond du Lac, Wisconsin, FREIGHT COLLECT, including installation supervision -----</p> <p><u>SPECIAL NOTES</u></p> <p>Sales Department Contact - Jim Hellwig</p> <p>Customer Contact - Gil Schumaker (J. Lee Hackett)</p> <p>Note: <u>Mechanical Engineering Department</u></p> <p>2 sets of line and foundation drawings</p> <p>Engineering Contact - <u>Fred Baldwin / Roger Rangarajan</u></p> <p>Note: <u>Electrical Engineering</u></p> <p>2 sets of electrical documentation</p>	

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		<p><u>SPECIAL NOTES</u> (Continued)</p> <p><u>Note: Manufacturing / Quality</u></p> <p>Customer visual inspection of machine with review of inspection data. One week notification to customer of runoff availability.</p> <p><u>Note: Training</u></p> <p>Programming - 2 persons Control Maintenance - 2 persons Mechanical - 2 persons</p> <p>H Three (3) days on-site operational training for CM 90 Cell Manager</p> <p>2 sets of manuals</p> <p><u>Note: Service</u></p> <p>Normal field installation supervision. Warranty 12 months from date of shipment.</p> <p>District Service Manager - R. C. Robinson</p> <p><u>Note: Shipping</u></p> <p>F.O.B. Fond du Lac, Wisconsin, Freight Collect</p> <p>F IMPORTANT: MACHINE WILL BE STORED UNTIL PAYMENT RECEIVED FROM CUSTOMER. <u>DO NOT</u> SHIP UNTIL AUTHORIZED BY SALES.</p> <p><u>Note: Accounting</u></p> <p>A</p> <ol style="list-style-type: none"> 1. Prices are firm. 2. Payment Terms <ul style="list-style-type: none"> 20% due with purchase order. 70% due thirty (30) days prior to shipment 10% due on acceptance of machine, or in sixty (60) days from date of shipment, whichever occurs first. 3. Sales tax exempt. 	

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		<p>REVISION A - 8-30-91</p> <ol style="list-style-type: none"> 1. Added customer purchase order number. 2. Added shipping address. 3. Changed Accounting Department note. <p>REVISION B - 9-10-91</p> <ol style="list-style-type: none"> 1. Clarified workchanger description and added ref. drwg. no.. 2. Changed flood coolant description and added note. 3. Added Barnes chip filtration system description. 4. DELETED chip conveyor. <p>REVISION C - 9-23-91</p> <ol style="list-style-type: none"> 1. Added expanded capacity to toolchanger. 2. Changed pricing. <p>REVISION D - 10-9-91</p> <ol style="list-style-type: none"> 1. Added date scheduled of 4-92. 2. Changed Accounting note. <p>REVISION E - 3-10-92</p> <ol style="list-style-type: none"> 1. Changed saddle travel from 22" to 21". 2. Corrected date scheduled. 3. Added paint specification. <p>REVISION F - 3-26-92</p> <ol style="list-style-type: none"> 1. Added fixture offsets. 2. Changed pricing. 3. Changed Shipping note. <p>REVISION G - 8-18-92</p> <ol style="list-style-type: none"> 1. Changed Training note. <p>REVISION H - 8-27-92</p> <ol style="list-style-type: none"> 1. Changed Training note. 	

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