

CLOVER TOOL MANUFACTURING LTD.

PRESS INFORMATION SHEET

PRESS	ASSET #	P002	P067	P068	P239	P004	P055	P216
	MANUF...	STANKO	Federal	Federal	Verson	MINSTER	WARCO	CCI
	SERIAL #	713	8A-372	8A-246	15474	50-6-4072	54116	SC1-200-003-81
	LOCATION	STAMPING	STAMPING	STAMPING	STAMPING	STAMPING	STAMPING	STAMPING
	MODEL #	KD2330	PR-0004	PR-0023	7.5 OBI	50-6-60	OPENBACK	SD-200-42x48
	TONNAGE	100	100	100	105	135	200	200
	OP SYS	N/A	N/A	N/A	Metal Form	OMRON H8PS	PRESS MASTER	LINK
TYPE OF PRESS	PROG'S & MANUAL	PROG'S & MANUAL	PROG'S & MANUAL	PROG'S & MANUAL	PROG'S & MANUAL	PROG'S & MANUAL	PROG'S & MANUAL	
MIN-MAX SHUT HIEGHT		9.5"-13.5"	13" - 16"	13 - 16"	14"-18"	10-20"	Set @ 21.125"	21.390"- 27.660"
SHUT HEIGHT STROKE DOWN, ADJUSTMENT UP BOLSTER TO RAM		13.5"	16"	16"	N/A no bolster	20"	16 1/16"	27.660"
CLOVER STANDARD SHUT HEIGHT		12.5"	N/A	N/A	N/A	20.0"	16.0"	23"
SLIDE ADJUSTMENT		4"	3"	3"	4"	10"	5"	6"
STROKE OF SLIDE		5"	3"	3"	10"	10"	10"	8"
LEFT WINDOW (W x H)		N/A	N/A	N/A	N/A	13" X 12"	N/A	22" x 28"
RIGHT WINDOW (W x H)		N/A	N/A	N/A	N/A	13" X 12"	N/A	22" x 28"
STROKES PER MIN.	MIN.	N/A	60	60	35	35	N/A	17
	MAX.	95	180	180	35	45	35	34
RAM AREA	F TO B	15.5"	9"	9"	28	32"	26"	48"
	L TO R	15.5"	24"	24"	30	55"	28"	60"
NUMBER OF K.O. BARS		1	N/A	N/A	N/A	3	1	N/A
BOLSTER AREA	F TO B	22"	28"	28"	29 1/2"	40"	34"	48"
	L TO R	33.5"	36"	36"	38 1/2"	60"	52"	60"
BOLSTER THICKNESS		2 1/4"	3 1/2"	3 7/8"	N/A	5"	4.5"	8 5/8"
RISER THICKNESS		N/A	1 1/4"	N/A	N/A	3"	N/A	N/A
T BOLT SIZE		3/4"	N/A	N/A	N/A	3/4"	5/8"	1"
" T " SLOTS	RAM	N/A	N/A	N/A	N/A	6"	12"	6"
CENTER TO CENTER	BOLSTER	N/A	N/A	N/A	N/A	6"	6"	6"
DISTANCE	BED	N/A	N/A	N/A	N/A	N/A	N/A	N/A
CLOVER STANDARD CLAMP HEIGHT		N/A	N/A	N/A	N/A	2"	2"	2"
HOLE IN BED	F TO B	8.5"	N/A	N/A	19"	10"	11"	N/A
	L TO R	8.5"	N/A	N/A	21"	35 1/2"	N/A	N/A
	# OF HOLES	1	N/A	N/A	1	1	1	N/A
FLOOR TO BOLSTER HEIGHT		36.750"	40 3/4"	41 1/2"	35 5/8"	41.875"	44 1/4"	49 1/2"
CUSHIONS		N/A	N/A	N/A	1	N/A	1	N/A
FEEDLINE CAPACITY		DO NOT USE INDIVIDUAL EQUIPMENT CAPACITY						
MAX COIL WEIGHT		N/A	N/A	N/A	6,000	4000	6,000	10,000
MAX COIL ID		N/A	N/A	N/A	20"	20"	16"	20"
MAX COIL OD		N/A	N/A	N/A	48"	50"	66"	60"
MAX WIDTH		N/A	N/A	N/A	24"	15"	48"	18"
MATERIAL THICKNESS		SEE STRAIGHTENER TAB BY PRESS NUMBER						
		N/A	N/A	N/A	.100"	.120"	.200"	.250"
FEEDER USE FEEDLINE CAPACITY								
ASSET #		N/A	N/A	N/A	P240	P015	P016	P221
TYPE		N/A	N/A	N/A	ROLL FEED	ROLL FEED	ROLL FEED	ROLL FEED
MAX.	WIDTH	N/A	N/A	N/A	16"	18"	30"	18"
	THICKNESS	N/A	N/A	N/A	0.100"	0.125 @ 12"	.225" @ 12"	.250" @ 12"
MIN MAX FEED ABOVE BOLSTER		N/A	N/A	N/A	6 1/2" - 15 1/4"	6 1/2" - 11"	N/A	13" - 19"
CLOVER STANDARD FEED HEIGHT		N/A	N/A	N/A	N/A	11.5"	N/A	17"
DIRECTION OF FEED		N/A	N/A	N/A	R-L	L - R	R-L	R-L
MAX. STROKE		N/A	N/A	N/A	NO LIMIT	NO LIMIT	N/A	NO LIMIT
MANUFACTURER		N/A	N/A	N/A	CWP	MECON	MECON	MECON
STRAIGHTENER USE FEEDLINE CAPACITY								
ASSET #		N/A	N/A	N/A	P240	P043	P016	P222
MANUFACTURER		N/A	N/A	N/A	COOPER	ROWE	MECON	MECON
MAX. 30,000 PSI	WIDTH	N/A	N/A	N/A	16"	15"	30"	18"
	THICKNESS	N/A	N/A	N/A	.100"	0.125	.225 @ 12"	.250"
DECOILER USE FEEDLINE CAPACITY								
ASSET #		N/A	N/A	N/A	P071	P043	P072	P222
MANUFACTURER		N/A	N/A	N/A	AMERICAN	ROWE	AMERICAN	MECON

CRADEL OR MANDREL	N/A	N/A	N/A	MANDREL	CRADEL	MANDREL	CRADEL
COIL I.D.	N/A	N/A	N/A	20"	20"	16"	20"
COIL O.D.	N/A	N/A	N/A	48"	50"	66"	60"
MAX MATERIAL THICKNESS	N/A	N/A	N/A	.100"	0.120"	.200"	.250"
COIL UNWINDING UNDER OVER	N/A	N/A	N/A	OVER	OVER	UNDER	OVER
CAPACITY IN LBS.	N/A	N/A	N/A	6,000	4000	6,000	10,000
MAX. COIL WIDTH	N/A	N/A	N/A	24"	15"	48"	18"

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PRESS INFORMATION SHEET

PRESS	ASSET #	P005	P007	P039	P 103	P217	P176
	MANUF...	WARCO	B.B.	W+M	BLISS	Blow	Blow
	SERIAL #	65-1662-10A	91125	1283-1379	49190 - 2	SDG-400-496-99	SDG-400-573-03
	LOCATION	STAMPING	STAMPING	STAMPING	STAMPING	STAMPING	STAMPING
	MODEL #	SC4-300-108-72	SS2-400	H108-4-16	SC2 - 400 - 84 x 48	SC2-400-72-48	SC2-400-108-54
	TONNAGE	300	400	400	400	400	400
	OP SYS	OMRON H8PS	SMART PAC 2	SMART PAC 2	PRESSLINE	LINK	SMART PAC 3
TYPE OF PRESS	PROG'S & MANUAL	PROG'S & MANUAL	PROG'S & MANUAL	PROG'S & MANUAL	PROG'S & MANUAL	PROG'S & MANUAL	
MIN-MAX SHUT HIEGHT	20.5" - 26.25"	18.120 -27.50"	28.125"-38.750"	17"-27"	19 3/4"-30 1/16"	14" - 24"	
SHUT HEIGHT STROKE DOWN, ADJUSTMENT UP BOLSTER TO RAM	26.25"	27.5	38.750"	27"	30 1/16"	24"	
CLOVER STANDARD SHUT HEIGHT	26.0"	26.0"	N/A	24"	21"	21"	
SLIDE ADJUSTMENT	6"	10"	10.625"	10"	10"	10"	
STROKE OF SLIDE	18"	10"	16"	12"	10"	12"	
LEFT WINDOW (W x H)	44"X24"	36.5" X 34.75"	22"x21"	25" x 20"	30" x 23"	38" x 25"	
RIGHT WINDOW (W x H)	44"X24"	36.5" X 35.25"	22"x21"	25" x 20"	30" x 23"	38" x 25"	
STROKES PER MIN.	MIN.	15	15	15	20	20	25
	MAX.	30	40	25	38	50	50
RAM AREA	F TO B	72"	48"	60"	48"	48"	54"
	L TO R	108"	96"	108"	84"	72"	106.5"
NUMBER OF K.O. BARS	N/A	N/A	N/A	N/A	N/A	N/A	
BOLSTER AREA	F TO B	72"	48"	60"	48"	72"	54"
	L TO R	108"	96"	108"	84"	48"	108"
BOLSTER THICKNESS	6"	8"	7 1/2"	6 1/4"	8"	7"	
RISER THICKNESS	N/A	N/A	N/A	N/A	N/A	N/A	
T BOLT SIZE	1"	1"	1"	1"	1"	1"	
" T " SLOTS	RAM	6"	6"	6"	6"	6"	6"
CENTER TO CENTER	BOLSTER	6"	6"	6"	6"	6"	6"
DISTANCE	BED	12"	N/A	N/A	N/A	N/A	N/A
CLOVER STANDARD CLAMP HEIGHT		2"	2"	2"	2"	2"	2"
HOLE IN BED	F TO B	N/A	17"	N/A	N/A	N/A	N/A
	L TO R	N/A	15"	N/A	N/A	N/A	N/A
# OF HOLES		N/A	4	N/A	N/A	N/A	
FLOOR TO BOLSTER HEIGHT		43"	45"	24"	48"	44 1/2"	44 1/4"
CUSHIONS		N/A	N/A	N/A	N/A	N/A	N/A
FEEDLINE CAPICITY	DO NOT USE INDIVIDUAL EQUIPMENT CAPACITY						
MAX COIL WEIGHT	25000	8000	N/A	8,000	10,000	15,000	
MAX COIL ID	36"	20"	N/A	20"	20"	18"	
MAX COIL OD	48"	48"	N/A	48"	60"	64"	
MAX WIDTH	48"	31"	N/A	24"	18"	23"	
MATERIAL THICKNESS	SEE STRAIGHTENER TAB BY PRESS NUMBER						
	.250"	0.150"	N/A	0.150"	.225"	0.300"	
FEEDER USE FEEDLINE CAPACITY							
ASSET #	P014	P012	N/A	P104	P013	P051	
TYPE	ROLL FEED	ROLL FEED	N/A	ROLL FEED	ROLL FEED	ROLL FEED	
MAX.	WIDTH	36"	30"	N/A	24"	23"	30"
	THICKNESS	0.250 @ 12"	0.250 @ 12"	N/A	0.225 @ 12"	.225" @ 12"	.375" @ 12"
MIN MAX FEED ABOVE BOLSTER	12" - 21"	12" - 18"	N/A	6" - 18"	8.5" - 19.5"	9 1/2"-19 3/4"	
CLOVER STANDARD FEED HEIGHT	13.5"	13.5"	N/A	14"	11"	15"	
DIRECTION OF FEED	R - L	R - L	N/A	R - L	R-L	L-R	
MAX. STROKE	NO LIMIT	NO LIMIT	N/A	NO LIMIT	NO LIMIT	NO LIMIT	
MANUFACTURER	MECON	MECON	N/A	MECON	MECON	MECON	
STRAIGHTENER USE FEEDLINE CAPACITY							
ASSET #	P185	P128	N/A	P 105	P225	P141	
MANUFACTURER	MECON	ROWE	N/A	ROWE	MECON	PERFECTO	
MAX. 30,000 PSI	WIDTH	60"	30"	N/A	30"	18"	23"
	THICKNESS	0.035" - 0.330"	.020" - .150"	N/A	0.020" - 0.150"	.250"	0.300"
DECOILER USE FEEDLINE CAPACITY							
ASSET #	P186	P128	N/A	P 105	P225	P141	
MANUFACTURER	MECON	ROWE	N/A	ROWE	MECON	PERFECTO	
CRADEL OR MANDREL	MANDREL	CRADEL	N/A	CRADEL	CRADEL	CRADEL	
COIL I.D.	20"	20"	N/A	20"	20"	18"	
COIL O.D.	48"	48"	N/A	48"	60"	64"	
MAX MATERIAL THICKNESS	0.21"	0.150"	N/A	0.150"	.250"	.375"	
COIL UNWINDING UNDER OVER	OVER	OVER	N/A	OVER	OVER	OVER	
CAPACITY IN LBS.	25,000	8000	N/A	8000	10,000	15,000	
MAX. COIL WIDTH	48"	31"	N/A	30"	18"	23"	

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PRESS INFORMATION SHEET

PRESS	ASSET #	P009	P118	P130	P171	P290	P10	P170	P172	P282
	MANUF...	B.B.	PTC	SCHULER	BLOW	KOMATSU	PTC	PTC	PTC	EAGLE
	SERIAL #	00117	04-129-N49	55557-1	SDG-600-393-96	1ME002	02-121-P27	02-120-P25	02-122-P26	
	LOCATION	STAMPING	STAMPING	STAMPING	STAMPING	Stamping	STAMPING	STAMPING	STAMPING	Stamping
	MODEL #	SS2-600	CL2-600 196 X 60	SE2-660 120 X 60	SC2-600-120x72	L2M-600-3BM	BL2-800-206 X 60	CL4-800 168x72	BL2-800-206x48	SE4-1650-240-96
	TONNAGE	600	600	600	600	660	800	800	800	1650
	OP SYS	ALLEN BRADLY	OMNI LINK 2	SMART PAC 2	SMART PAC 2	KOMATSU	OMNI LINK	SMART PAC 2	SMART PAC 2	Allen-Bradley
TYPE OF PRESS	PROG'S & MANUAL	PROG'S & MANUAL	PROG'S & MANUAL	PROG'S & MANUAL	PROG'S & MANUAL	PROG'S & MANUAL	PROG'S & MANUAL	PROG'S & MANUAL	PROG'S & TRANS	
MIN-MAX SHUT HIEGHT		22-34"	24"-36"	25.5"-35.5"	26"- 36.5"	21.6"- 27.5"	28"-36"	36"-48"	28" - 36"	36"-50"
SHUT HEIGHT STROKE DOWN, ADJUSTMENT UP BOLSTER TO RAM		34"	36"	35.5"	36.5"	27.56"	36"	48"	36"	68"
CLOVER STANDARD SHUT HEIGHT		32"	32"	32"	32"	32"	36"	36"	36"	50"
SLIDE ADJUSTMENT		12"	12"	10"	10"	5.906"	8"	12"	8"	14"
STROKE OF SLIDE		14"	14"	16"	18"	7.87"	12"	24"	12"	28"
LEFT WINDOW (W x H)		52"x44"	70" X OPEN	42" X OPEN	60" x 34"		68" X OPEN	80" x OPEN	56" x OPEN	
RIGHT WINDOW (W x H)		52"x44"	70" X OPEN	42" X OPEN	60" x 34"		68" X OPEN	80" x OPEN	56" x OPEN	
STROKES PER MIN.	MIN.	25	15	15	20	30	15	10	15	10
	MAX.	50	50	60	40	80	50	30	45	30
RAM AREA	F TO B	60"	60"	60"	72"	47.25"	60"	72"	48"	96
	L TO R	144"	196"	120"	120"	96.5"	206"	168"	206"	240
NUMBER OF K.O. BARS		N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A
BOLSTER AREA	F TO B	60"	60"	65"	72"	51.2"	60"	72"	48"	96
	L TO R	145"	196"	120"	120"	96.5"	206"	168"	206"	240
BOLSTER THICKNESS		9"	9"	9 1/2"	8"	11.4"	10" / 6"	10"	10"	18"
RISER THICKNESS		N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A
T BOLT SIZE		1"	1"	1"	1"	1"	1"	1"	1"	1"
" T " SLOTS	RAM	6"	6"	6"	6"	6"	6"	6"	6"	6"
	BOLSTER	6"	6"	6"	6"	6"	6"	6"	6"	6"
CENTER TO CENTER	BOLSTER	6"	6"	6"	6"	6"	6"	6"	6"	6"
DISTANCE		N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A
CLOVER STANDARD CLAMP HEIGHT		2"	2"	2"	2"	2"	2"	2"	2"	
HOLE IN BED	F TO B	13"	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A
	L TO R	19.250"	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A
# OF HOLES		5	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A
FLOOR TO BOLSTER HEIGHT		44 1/2"	34"	27"	29 1/2"		24 3/8"	28 1/2"	28 1/2"	
CUSHIONS		N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A
FEEDLINE CAPACITY										
DO NOT USE INDIVIDUAL EQUIPMENT CAPACITY										
MAX COIL WEIGHT		20 000	20,000	20,000	12,000	15,000	20,000	30,000	10,000	40,000
MAX COIL ID		18"	24"	24"	20"	19.25"	24"	24"	18" - 22"	18 1/2"
MAX COIL OD		72"	69"	60"	60"	72"	65"	72"	72"	
MAX WIDTH		48"	48"	26"	40"	24"	48"	58"	23.5"	72"
SEE STRAIGHTENER TAB BY PRESS NUMBER										
MATERIAL THICKNESS		.200"	.350"	0.315"	.190"	.475"	.200"	.250"	.200"	
FEEDER USE FEEDLINE CAPACITY										
ASSET #		P017	P119	P140	P131	P295	P089	P252	P187	P283
TYPE		ROLL FEED	ROLL FEED	ROLL FEED	ROLL FEED	SERVO FEED	ROLL FEED	ROLL FEED	ROLL FEED	ROLL FEED
MAX.	WIDTH	48"	48"	36"	48"	24"	48"	58"	23.5"	72"
	THICKNESS	0.250 @ 12"	.350" @ 12"	0.500" @ 12"	.200" @ 12"	.250"	0.225" @ 12"	0.500" @ 12"	0.200"	.315"
MIN MAX FEED ABOVE BOLSTER		15"-23.5"	14"-24"	12"-28"	12" - 17"		12" - 24"	20"-32"	12" - 22"	27.5" x 38"
CLOVER STANDARD FEED HEIGHT		20"	20"	20"	13.5"		20"	30"	21.5"	
DIRECTION OF FEED		L - R	L - R	R - L	R-L		L - R	R-L	L-R	L-R
MAX. STROKE		NO LIMIT	NO LIMIT	NO LIMIT	NO LIMIT		NO LIMIT	NO LIMIT	NO LIMIT	NO LIMIT
MANUFACTURER		MECON	MECON	MECON	MECON		MECON	MECON	BARRIE WELDING	MECON
STRAIGHTENER USE FEEDLINE CAPACITY										
ASSET #		P053	P119	P022	P042	P291	P089	P251 C	P263	P284
MANUFACTURER		MECON	MECON	PERFECTO	ROWE	COE	MECON	MECON	MECON	MECON
MAX. 30,000 PSI	WIDTH	48"	48"	26"	40"	24"	48"	60"	24"	72"
	THICKNESS	0.020"-0.250"	.350" @ 12"	0.035"-0.315" X 18"W	.190"	.475"	.225" @ 12"	.250 @ 12"	.450" @ 12"	.315"
DECOILER USE FEEDLINE CAPACITY										
ASSET #		P053	P120	P022	P042	P292	P090	P250	P264	P285
MANUFACTURER		MECON	MECON	PERFECTO	ROWE	COE	MECON	MECON	MECON	MECON
CRADREL OR MANDREL		MANDREL	MANDREL	CRADREL	CRADREL	MANDREL	MANDREL	MANDREL	MANDREL	MANDREL
COIL I.D.		18"	24"	20"	20"	19.25"	24"	24"	18" - 22"	18 1/2"
COIL O.D.		72"	69"	60"	60"	72"	65"	72"	72"	72"
MAX MATERIAL THICKNESS		0.200"	0.350"	0.315"	.190"	.475"	0.200"	0.500"	.250"	.315"
COIL UNWINDING UNDER OVER		OVER	UNDER	OVER	OVER	OVER	UNDER	OVER	OVER	OVER
CAPACITY IN LBS.		20 000	20,000	20,000	12,000	15,000	20,000	30,000	10,000	40,000
MAX. COIL WIDTH		48"	48"	26"	40"	24"	48"	60"	24"	72"

Equip	DESCRIPTION	EQTYPE	YS PSI	12"	18"	24"	30"	36"	48"	60"	72"
P010	PTC 800 WEST P010	FEEDER STRAIGHTENER	30000	.250"	.235"	.220"	.205"	.180"	.150"	N/A	N/A
P089	FEEDER STRAIGHTENER P089(P010)	FEEDER STRAIGHTENER	60000	.198"	.187"	.175"	.163"	.143"	.119"	N/A	N/A
MECON	400FSP48L	2644N209	90000	.173"	.163"	.153"	.142"	.125"	.104"	N/A	N/A
P118	PTC 600 P118	FEEDER STRAIGHTENER	30000	.350"	.335"	.320"	.300"	.280"	.260"	.230"	.200"
P119	FEEDER STRAIGHTENER P119(P118)		50000	.295"	.283"	.270"	.253"	.236"	.219"	.194"	.169"
MECON	600FSP481	2981N02	80000	.252"	.242"	.231"	.216"	.202"	.188"	.166"	.144"
P170	PTC 800 TALL P170	STRAIGHTENER	30000	.320"	.320"	.300"	.270"	.240"	.210"	.180"	N/A
P251	STRAIGHTENER P251 (P170)		60000	.254"	.254"	.238"	.214"	.191"	.167"	.143"	N/A
MECON	5-4STR609	4219N002	90000	.222"	.222"	.208"	.187"	.166"	.146"	.125"	N/A
P005	WARCO 300 P005	STRAIGHTENER	30000	.279"	.266"	.252"	.239"	.225"	.212"	.171"	N/A
P185	STRAIGHTENER P185 (P005)		50000	.235"	.224"	.213"	.201"	.190"	.178"	.144"	N/A
MECON	575F60-1	1044	80000	.201"	.192"	.182"	.172"	.162"	.153"	.123"	N/A
P172	PTC 800 RAIL P172	STRAIGHTENER	30000	.250"	.250"	.250"	N/A	N/A	N/A	N/A	N/A
P263	STRAIGHTENER (P172)		60000	.198"	.198"	.198"	N/A	N/A	N/A	N/A	N/A
MECON	4STR24-9	4116N02	90000	.173"	.173"	.173"	N/A	N/A	N/A	N/A	N/A
P009	BB 600 P009	STRAIGHTENER	30000	.250"	.235"	.220"	.205"	.180"	.150"	N/A	N/A
P053	STRAIGHTENER (P009)		60000	.198"	.187"	.175"	.163"	.143"	.119"	N/A	N/A
MECON	4STR48CB	2409N227	90000	.173"	.163"	.153"	.142"	.125"	.104"	N/A	N/A