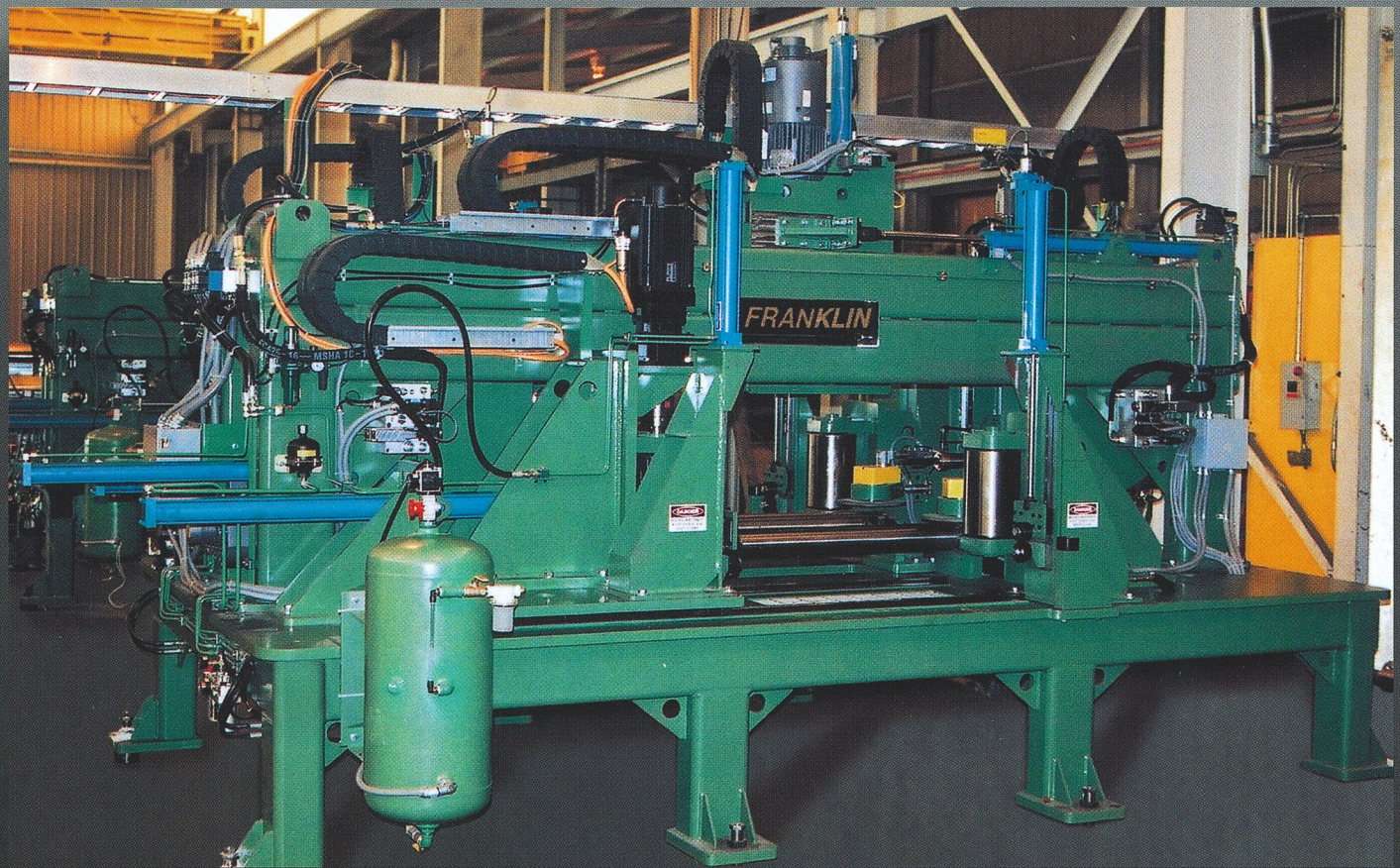


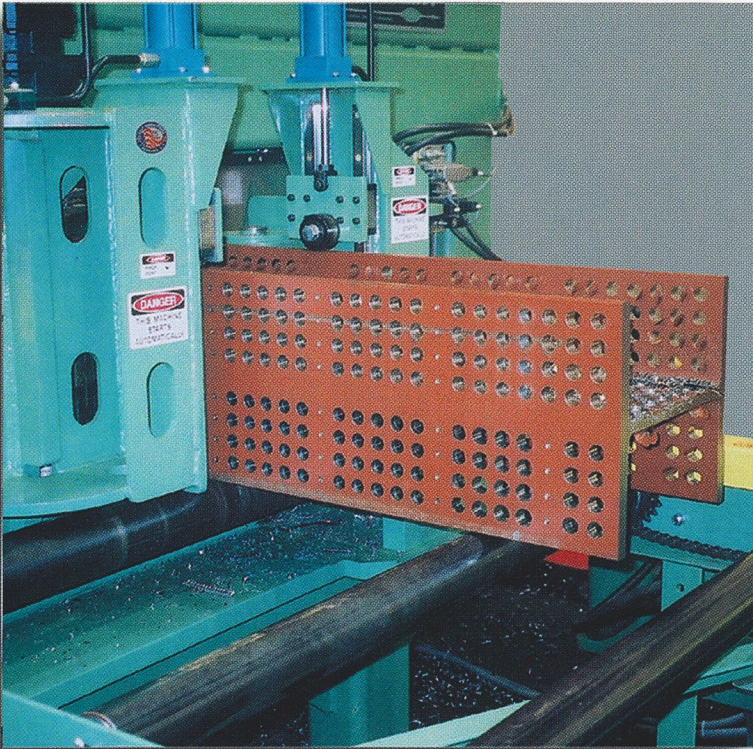


P.O. DRAWER 998/HWY 243 INDUSTRIAL PARK RUSSELLVILLE, AL 35653
PHONE 256-332-6654 FAX 256-332-0143
EMAIL: fmiinc@fmi-solutions.com



FRANKLIN HD 145 X 44



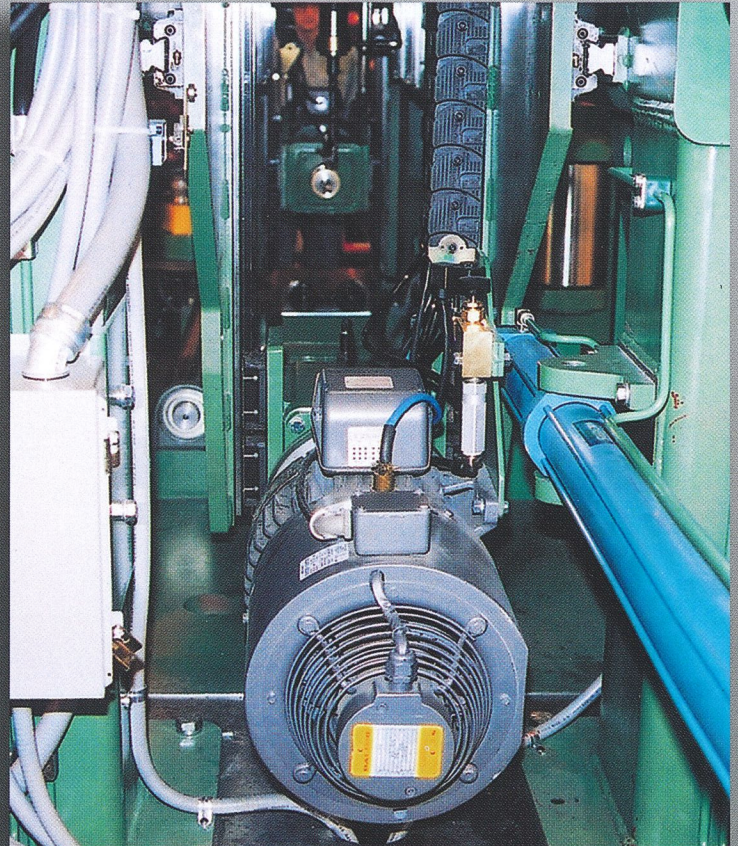


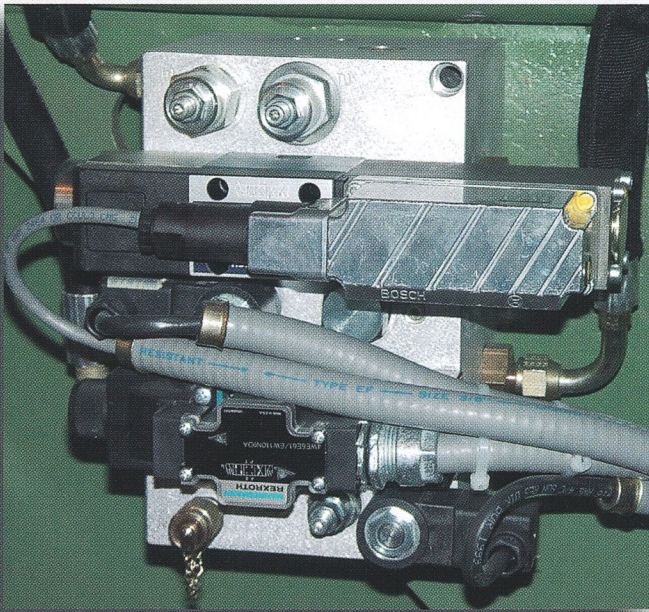
DUAL AXIS PINCH ROLL DRIVE for infeed and outfeed measuring.

- Maximum X axis speed.....130 FPM
- Infeed hydraulic pinch roll drive for measuring and driving the leading section of material.
- Pressure switch material detection for side clamp to automatically find the width.
- Vertical hold-down rolls on both sides.
- Precision measuring wheel for overall X axis length and hole location.
- X Axis length accuracy..... +/- .030
- AC servo drive system synchronized with infeed / outfeed conveyors.
- Outfeed pinch roll drive system for measuring and driving the trailing end of material complete with all above features.
- Pinch roll clamps are self adjusting to individual section sizes automatically.

FRANKLIN MODEL HD-145 x 10V SPINDLE

Rapid Advance	700 IPM
Retract Speed	420 IPM
Spindle Motor (AC Variable)	10 HP
Drill Feed Rate CNC Servo	0 to 30" IPM
Spindle RPM Speeds (Variable)	0 to 1800 RPM
Drill Capacity (Maximum)	1-9/16"
Hi-Pressure Air/Coolant Mist	Thru Bit
Position Feed Back	Total Enclosed Linear Transducer



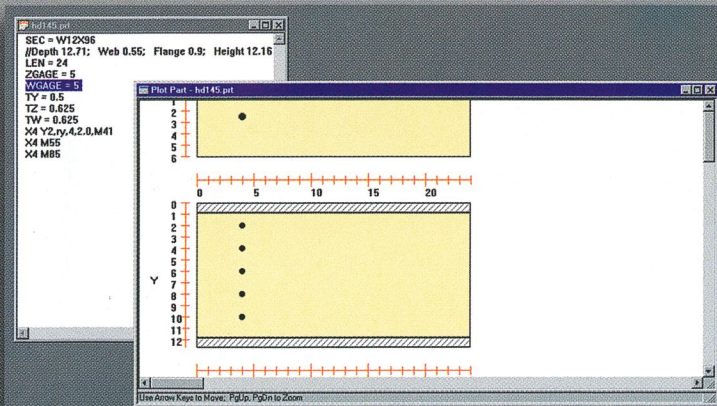


SERVO SPINDLE FEED

- Auto-drill calibrates and automatically detects drill length with low pressure sensing.
- Precision feed rate control up to 30 in/min.
- Rapid advance speeds up to 700 IPM.
- Variable feed pressure is adjustable per each spindle for hi-performance drilling.
- Internal cartridge design for precision pressure control.

AC SERVO DRIVES

- Closed Loop AC Servo positioning for length X axis measuring and hi-capacity conveyor control
- Digital control system with analog interface
- Extensive diagnostic options
- Current limit
- Velocity limit
- Control loop settings



FRANKLIN CNC CONTROLS

- Windows 2000 based PC controls developed and designed by Franklin Manufacturing, Inc.
- Data format is a basic ASCII Text file that can be generated by most any detail software from DXF files.
- Material section tables and drill feed charts provide quick accurate cycle times.
- Machine parameters and offsets are all handled thru the Franklin CNC software.

CONVEYOR AND MATERIAL HANDLING SPECIFICATIONS

CONVEYOR SYSTEMS	CONVEYOR WIDTH	PASS LINE	ROLL DIAMETER	AXLES	DRIVE CHAIN
300 lb. / ft.	Approx. 50" (41" useable)	40"	3 1/2" OD	1 1/16" Hex	RC 60
500 lb. / ft.	Approx. 58 1/2" (45" useable)	40"	4 1/2" OD	1 7/16" CR Shafting	RC 80
750 lb. / ft.	Approx. 60" (45" useable)	40"	6 5/8" OD	1 15/16" CR Shafting	RC 80

NOTE: — Due to continuous improvement in design some information or specifications are subject to change without notice.
— Some guards and or warning devices may not be in place for clarity.

LIFT ARM TRANSFER SYSTEM

Weight Capacity (300 lb. / ft. system)	115,000 lb.
(750 lb. / ft. system)	200,000 lb.
Main Table Chain	81 x
Lift Arm Chain (300 lb. / ft. system)	RC 80
(750 lb. / ft. system)	RC 80-2
Capacity of Air Bag Used in Raising Pivot Arm / Per Air Bag	6,000 lbs. @ 60 PSI

DUAL END LOADING LIFT ARMS

- 300 – 750 lbs. / ft. capacity
- Air bag lifts
- Hi-torque hydraulic winch drives
- RC80 chain runners
- Various material lengths up to 80 ft.
- Engineered systems based on customers layout requirements.



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