

UNLESS OTHERWISE SPECIFIED, TORQUE ALL FASTENERS (EXCLUDING SWING BOLTS) TO THE FOLLOWING. TORQUE ALL FASTENERS TO SPEC. "B"

|            |      |          |            |       |          |
|------------|------|----------|------------|-------|----------|
| 1/2"-----  | 20.  | FT.-LBS. | 1-3/8"---- | 420.  | FT.-LBS. |
| 5/8"-----  | 40.  | FT.-LBS. | 1-1/2"---- | 550.  | FT.-LBS. |
| 3/4"-----  | 65.  | FT.-LBS. | 1-3/4"---- | 870.  | FT.-LBS. |
| 7/8"-----  | 110. | FT.-LBS. | 2"-----    | 1300. | FT.-LBS. |
| 1"-----    | 160. | FT.-LBS. | 2-1/4"---- | 1900. | FT.-LBS. |
| 1-1/8"---- | 225. | FT.-LBS. | 2-1/2"---- | 2600. | FT.-LBS. |
| 1-1/4"---- | 320. | FT.-LBS. |            |       |          |

THE MAGNITUDE OF THE TIGHTENING STRESS FOR A GIVEN TORQUE VARIES CONSIDERABLY WITH THE TYPE OF LUBRICATION USED. WHENEVER THESE SPECIFICATIONS ARE USED, BOTH THE THREADS AND THE FACE OF THE NUT OR THE FACE OF THE HEAD OF THE BOLTS OR CAPSCREWS MUST BE THOROUGHLY BUT LIGHTLY LUBRICATED WITH ADHERON THREAD LUBE #AD1094. UNDER NO CIRCUMSTANCES ARE THESE TORQUES TO BE USED WITH NO LUBRICATION OR WITH LUBRICANTS SUCH AS MOLY-LUBE, "NEVER-SEIZE", ETC. EXCEPTION -- THE THREADS ON THE END OF THE STUD BEING INSERTED INTO A TAPPED HOLE SHOULD HAVE ONLY A VERY LIGHT FILM OF OIL.

REFERENCE DRAWINGS:

36 LB REEL ELEVATION.....MR3-FR-117  
36 LB REEL B/M.....MR4-193-444

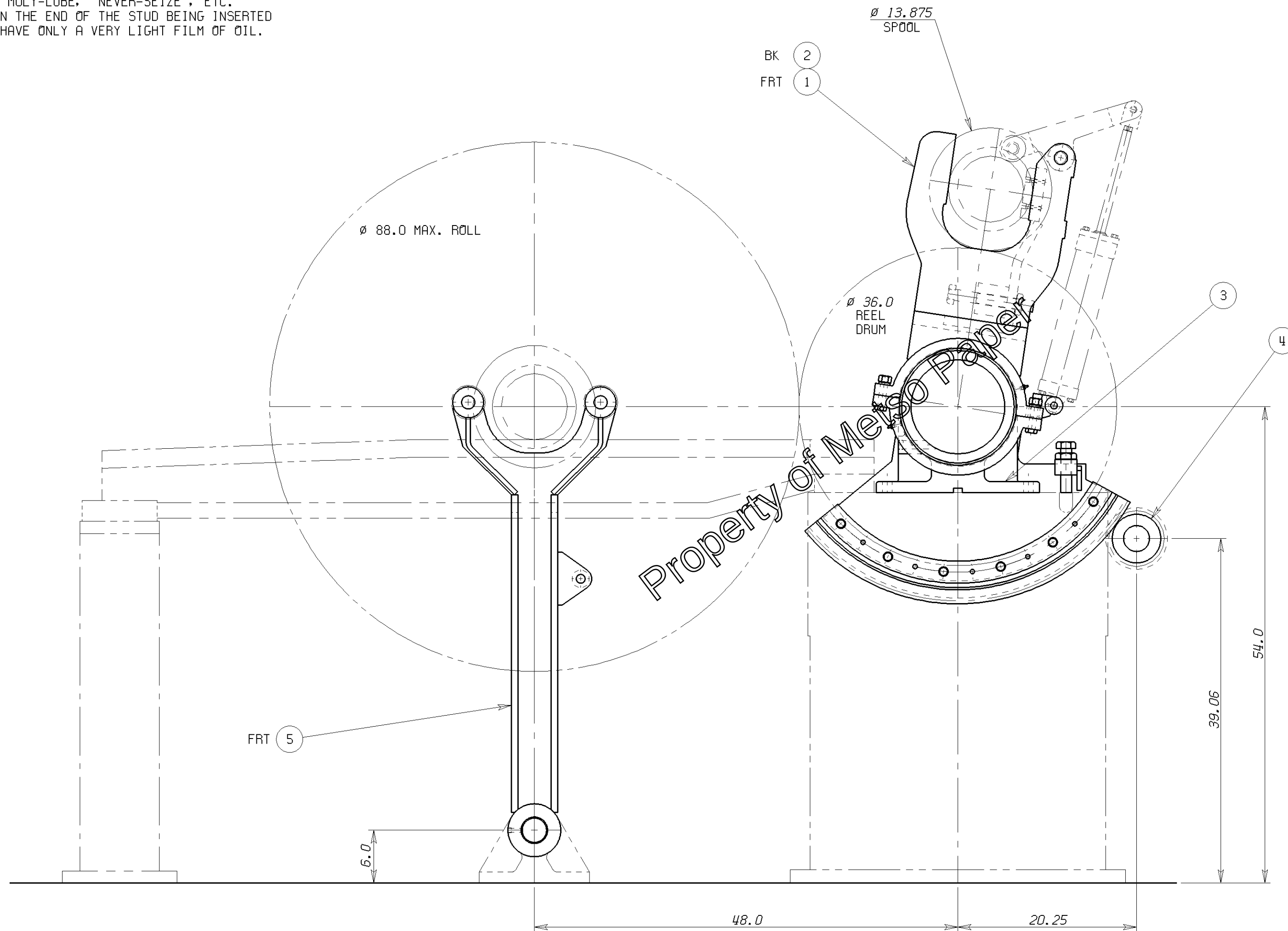
PAINT REFERENCE:

PAINT SPECIFICATIONS PER ES.CHAP000747.B  
AND INMEC STANDARD APPLICATION SPECS.

STANDARD TOP COAT #F073-GB19A (BLUE BAY)

UNIT PAINT CODES

10 NO PAINT  
20 PAINT REQUIRED  
26 SAFETY ORANGE PAINT REQUIRED  
#73-CA26  
27 SAFETY YELLOW PAINT REQUIRED  
#73-BV57



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CERTIFIED 18-FEB-02

|                         |  |                         |                     |                                          |               |                 |                 |                                               |  |
|-------------------------|--|-------------------------|---------------------|------------------------------------------|---------------|-----------------|-----------------|-----------------------------------------------|--|
| U OF M<br>IN            |  | PROJECTION<br>3RD ANGLE | ORDER NO.<br>460027 | CUSTOMER NAME<br>SPRAGUE PAPERBOARD INC. |               | MACH. NO.<br>1  |                 | STATELINE SERVICE CENTER BELOIT, WI 53511 USA |  |
| DRAWN DATE<br>18-FEB-02 |  | CRIT.                   | FILE NO.            | MILL<br>VERSAILIES, CT                   |               | SCALE<br>1:10   |                 | PNT<br>10                                     |  |
| MACH SERIES<br>A444     |  | C-O                     | DEPT. NO.<br>542    | DRAWN<br>DXD                             | CHK'D.<br>DXD | APP'D. 1<br>GEO | APP'D. 2<br>GEO | REFERENCE DRAWING                             |  |
| BNC<br>60-9900          |  | M-O                     | DATE<br>18-FEB-02   | TITLE<br>REBUILD, REEL                   |               |                 |                 | IDENTIFICATION NUMBER<br>STAMA00065           |  |
| REVISION                |  | DESCRIPTION             |                     |                                          |               |                 |                 |                                               |  |

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A, DXD/STAMA00065  
DXD 18 FEB 2002 SULDS-staa198: /cadd/2000frn/460027  
INFO AT PLOT TIME: BEL-CA00