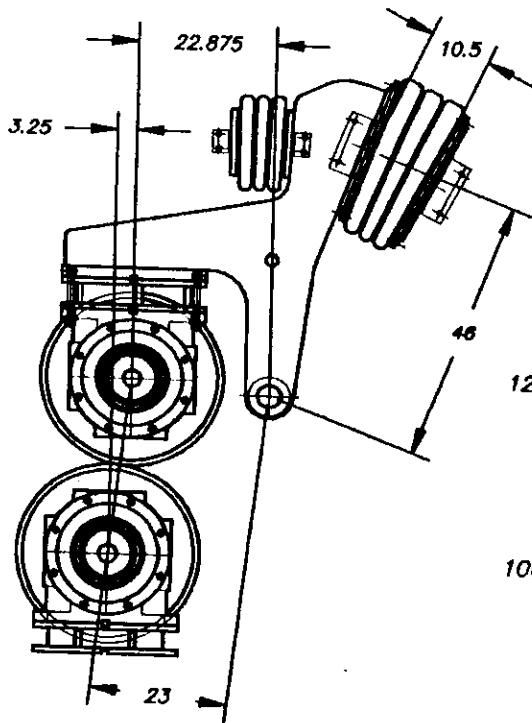
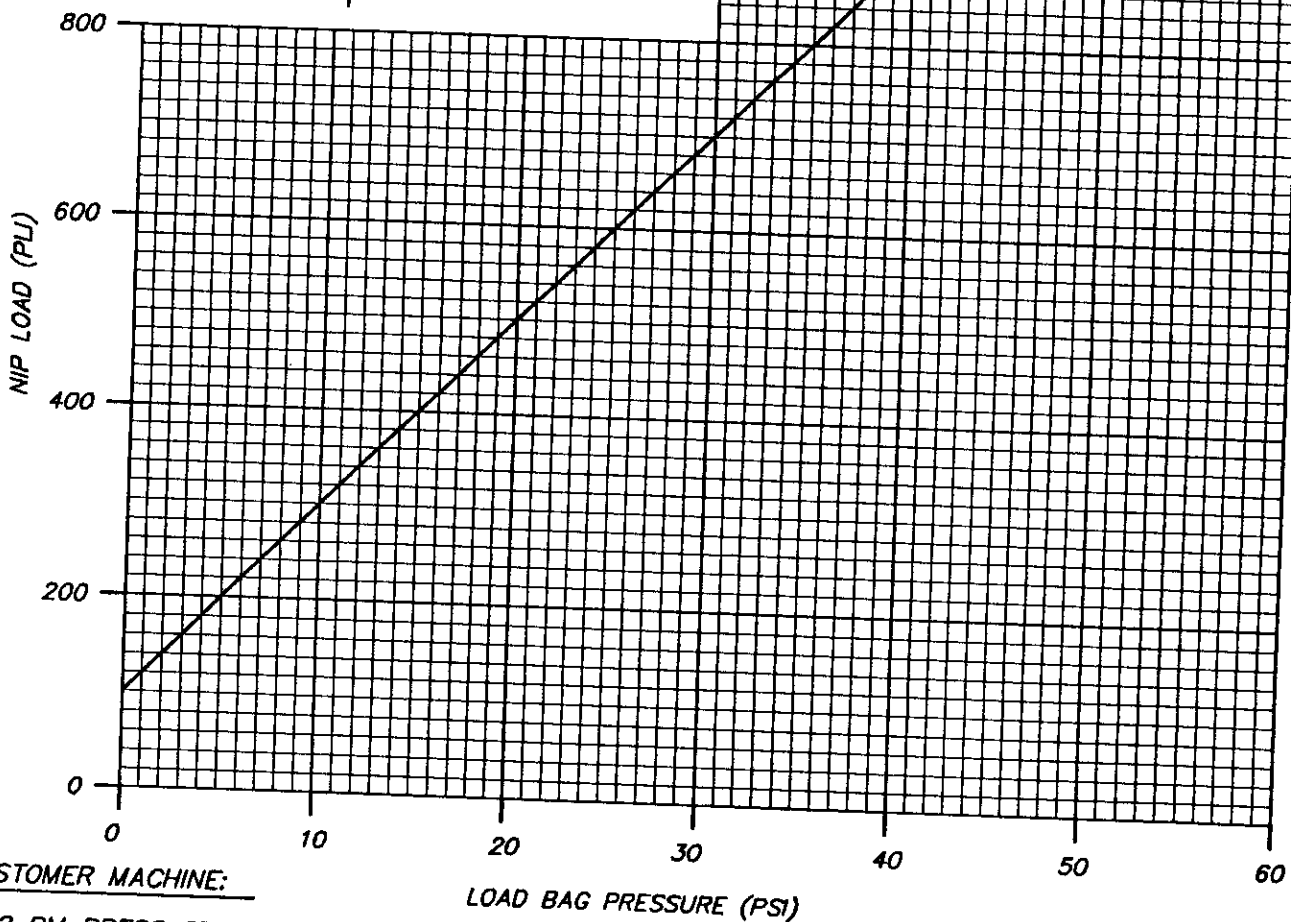


LOADING CURVE



AIR BAG: #319
SET HEIGHT: 10.5



CUSTOMER MACHINE:

#2 PM PRESS SECTION
MENASHA CORPORATION
OTSEGO, MI
S.O. #53936
P.O. #520168

SIMON-LG INDUSTRIES
INCORPORATED

WAGONTOWN, PA
19376 U.S.A.

DRAWING NO. A-10425-4

G: 53936 \ A4250400

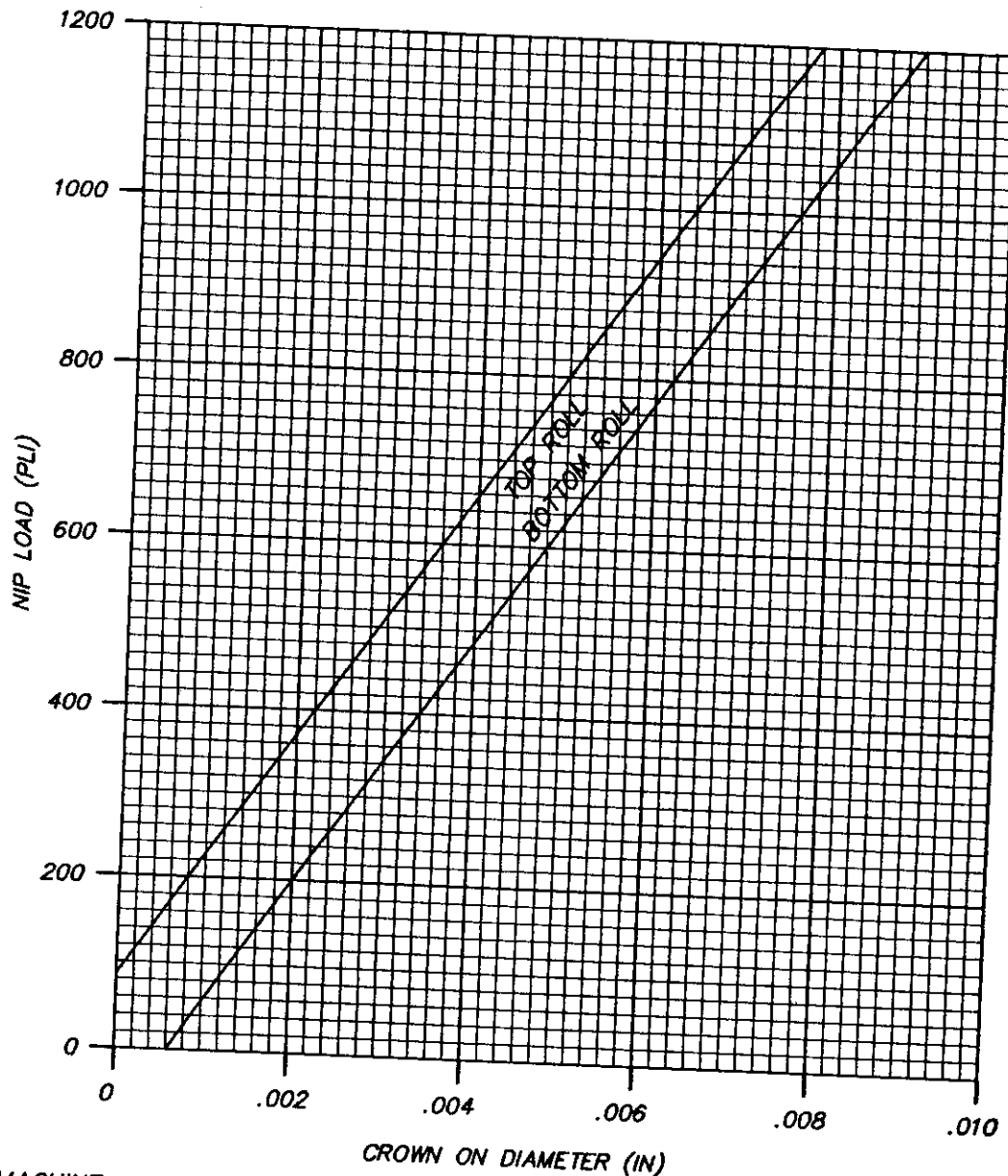
06/09/95 - 09:56 AM

CROWN CURVE

CROWN CURVES ARE CALCULATED. CORRECT CROWN CURVES AFTER START-UP
NIP IMPRESSIONS, AS NECESSARY

ROLLS SUPPLIED WITH CROWNS OF .004 AND .010 AS FOLLOWS:

1PTR @ 600 PLI - .0036	2PTR @ 1000 PLI - .0064	DRILLED ROLLS:	SMOOTH ROLLS:
1PBR @ 600 PLI - .0048	2PBR @ 1000 PLI - .0076	.0084/2 = .0042	.014 - .004 = .010
TOTAL CROWN REQ'D .0084	TOTAL CROWN REQ'D .0140	USE .004	USE .010



CUSTOMER MACHINE:

#2 PM PRESS SECTION
MENASHA CORPORATION
OTSEGO, MI
S.O. #53936
P.O. #520168

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INCORPORATED

WAGONTOWN, PA
19376 U.S.A.

DRAWING NO. A-10424-4

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06/C^/95 - 11:13 AM