

EQUIPMENT LIST

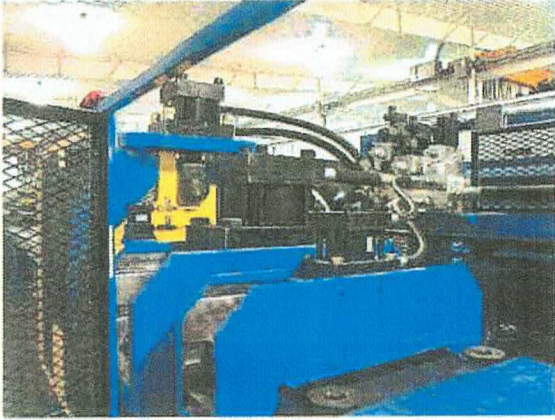
1. **Bradbury Model SRDE6.5 Stock Reel**
 - Double mandrel x 6,500 lb. capacity (per mandrel)
 - Hydraulic mandrel expansion
 - Drag brake
 - Non-powered payoff
 - 18 ½" to 21 ½" mandrel expansion

2. **Bradbury Model RS35-4-12" Roller Straightener**
 - Two (2) pinch rolls
 - Four (4) work rolls to remove coil set from material
 - 12" maximum material width
 - Exit cascade and hardened rail material guides



3. **Bradbury Model FR5-12 Feed Roll**
 - Servo driven feed rolls and encoder
 - Mounted on press base
 - 5" feed roll diameter
 - 12" maximum material width
 - Independent adjust lead-in with mechanical counter

4. **Hydraulic Press System with Three Feature Dies (36" Feeds)**
 - Two hydraulic presses total
 - One 50 ton hydraulic press and dies designed to pre-lance material for forming on 12" centers
 - One 120 ton hydraulic press to apply "H" emboss and form hole flanges on 12" centers
 - Each press includes dies for 3.625" and 6.0" products
 - 3.625" Punch Die
 - 3.625" Form Die
 - 6" Punch Die
 - 6" Form Die
 - Dies to be manually changed out when changing products
 - Form die clearance designed for 0.060" material – thinner material will be formed at a lesser angle
 - Press includes die change table – Dies can be removed from table with forklift or hoist
 - Includes slug trays to divert slugs to customer supplied scrap bins
 - Hydraulic shear
 - Includes size increase in hydraulic power unit



5. **Entry Conveyor**

- 22' conveyor length
- Powered conveyor

6. **420 STR™ Rollformer**

- 10 forming stations
- Pre-heat treated and ground 4142 HT medium carbon, medium alloy steel spindles and sleeves machined for telescopic use
- STR™ technology for fast part size adjustment
- Cross section width adjustment via jack screws and hydraulic motors
- Exclusive Bardie™ cartridge technology included
 - Provides automatic gauge adjustment without operator intervention
- AC motor, variable frequency drive (VFD mounted in main electrical cabinet)
- Geared for up to 150 FPM
- Cone drive gearboxes with single output shaft at each forming station
- Double enveloping worm gear design
- Upper arbor connected to lower arbor via spur gears
- Includes squaring lead-in guide at entry end of rollformer with secondary guide for track products
- Pneumatic, spring engaged brake with low pressure switch
- Includes jog cord on the rollformer



7. Roll Tooling

- D-2 Roll Tooling
- 60 – 62 Rc through hardened, all bore and faces ground after heat treat
- For 3.625" to 6" wide R-Stud profiles
- 1.250" leg height on 3.625" web width
- 1.625" leg height on 6.0" web width
- 0.250" return length on 3.625" web width
- 0.375" return length on 6.0" web width
- 1.188" max leg height on track products
- Straightener fixture mounted at exit end of rollformer

8. Electrical and Controls

- Beck Automation Closed Loop Controller
- Includes Citronix CIJ Inkjet printer – Print to be located on flange
- Main electrical cabinet with disconnects, fuses, motor starters, amplifiers, etc.
- All components will be mechanically and electrically integrated prior to shipment
- All wiring between components via flexible conduit

9. Accessories

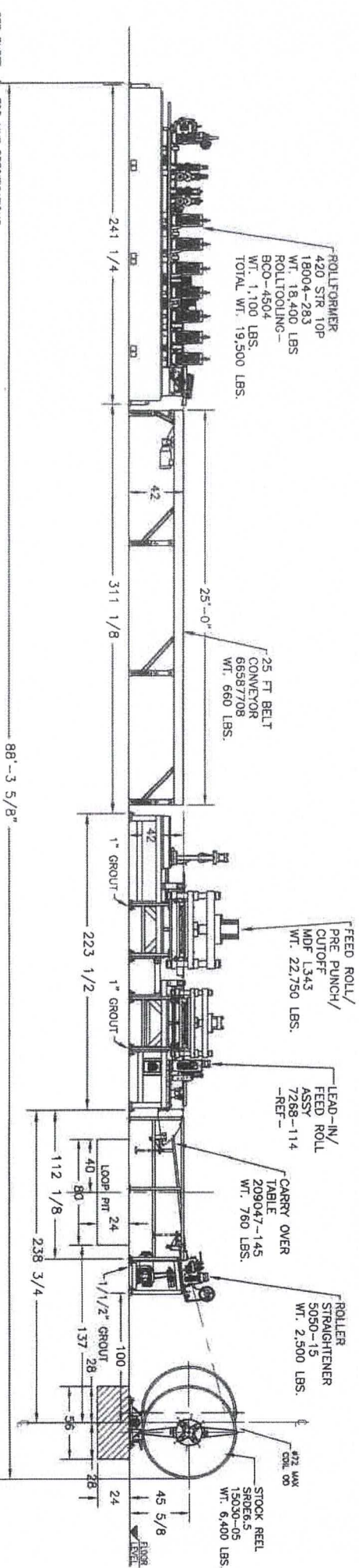
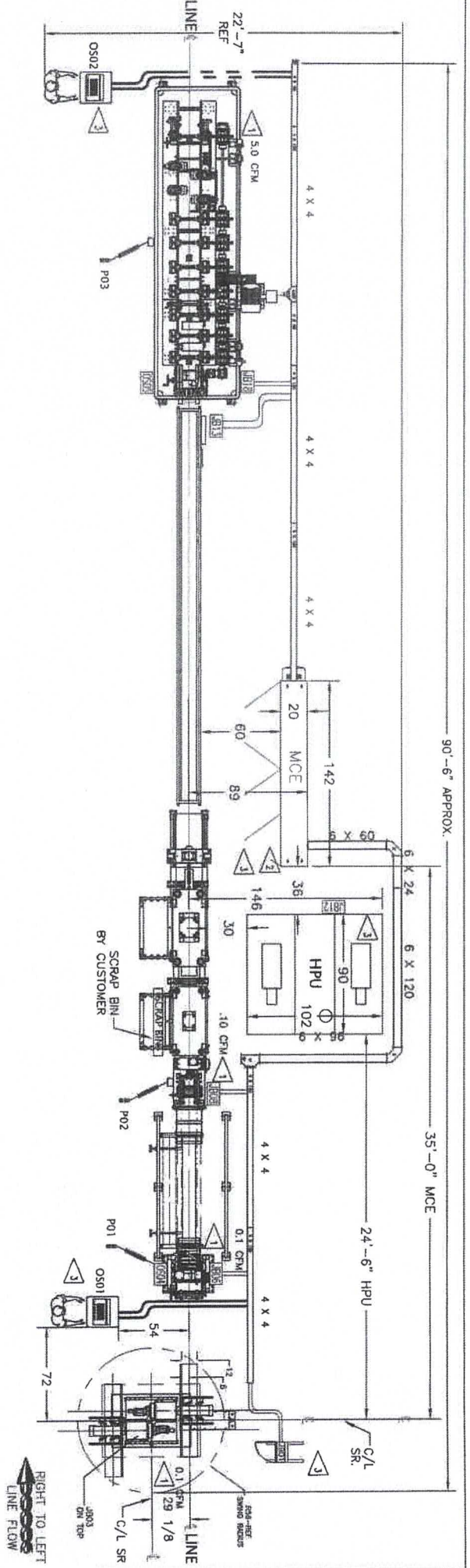
- One copy of operator, service & parts manuals
- 2 year warranty on manufactured parts
- Test material supplied by customer
- One Bradbury technician onsite for 10 days for installation assistance and line start-up

10. One Bradbury technician onsite for 10 days for installation assistance and line start-up

Changes to the original Purchase Order must be submitted and acknowledged in writing by both parties.

BRADBURY GENERAL SPECIFICATIONS**R-Stud Product LINE****3 5/8" Finished and 6" Finished Width**

Material	:	Galvanized Steel – G60
Material Strength	:	50KSI Yield Maximum
	:	40KSI Yield Minimum
Thickness	:	0.021" Minimum, 0.060" Maximum
Entry Coil Weight	:	6,500 lbs.
Entry Coil I.D.	:	19" Minimum, 21" Maximum
Entry Coil O.D.	:	60"
Rollformer Speed	:	Variable to 150 FPM
Press Speed	:	40 Strokes per Minute
Throughput (Finished Product)	:	120 FPM Maximum– Based on press system that includes dies for lancing and forming three features per press stroke – This rate is based on part lengths between 8' and 20'. – 1' increments
Length Tolerance	:	+/- 0.063"
Hole Tolerance	:	+/- 0.063"
Line Direction	:	Left to Right
Mode of Operation	:	Pre-Punch & Pre-Cut
Cut Length	:	8' Minimum, 20' Maximum – 1' increments only
Power Requirements	:	Drive: 460 Volts, 60 Cycles, 3 Phase
	:	Control: 24 Volts, DC
	:	Air: 80 PSI Minimum, (Clean & Dry, by Customer)
	:	Hydraulics: 1500 PSI Working Pressure
Estimated Full Load Amps	:	350 – Based on line with all options included



ROLLFORMER
 420 STR 10P
 18004-283
 WT. 18,400 LBS
 ROLLTOOLING-
 BCO-4504
 WT. 1,100 LBS.
 TOTAL WT. 19,500 LBS.

25 FT BELT
 CONVEYOR
 65587708
 WT. 660 LBS.

FEED ROLL/
 PRE PUNCH/
 CUTOFF
 MDP L343
 WT. 22,750 LBS.

LEAD-IN/
 FEED ROLL
 ASSY
 7268-114
 -REF-
 WT. 22,750 LBS.

CARRY OVER
 TABLE
 209047-145
 WT. 760 LBS.

ROLLER
 STRAIGHTENER
 5050-15
 WT. 2,500 LBS.

STOCK REEL
 209047-5
 WT. 6,400 LBS.

SEE SHEET 1 FOR LINE SPECIFICATIONS
 SEE SHEET 2 FOR LINE LAYOUT
 SEE SHEET 3 FOR FOUNDATION LAYOUT
 SEE SHEET 4 FOR CONDUIT LAYOUT

1 APPROXIMATE LOCATION OF
 SHOP AIR CONNECTION

2 APPROXIMATE LOCATION OF
 480 VOLT, 3 PHASE, 40 HZ
 ELECTRICAL CONNECTION

3 TO BE LOCATED AND
 MOUNTED BY CUSTOMER

NOTE: THIS DIAGRAM INDICATES ORIGIN AND DESTINATION OF
 CONDUIT ACTUAL ROUTING OF CONDUIT AND PLACEMENT OF JUNCTION
 BOXES AND OPERATOR STATIONS TO BE CONVENIENT AND WILL VARY.

CENTERLINE MARKS ARE TO BE STAMPED ON THE ENTRY AND EXIT END OF EACH COMPONENT.

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XX	±.070		
XX	±.080		
XX	±.090		
XX	±.100		

DATE 12-3-15		DESIGNER	APPROVED BY
SCALE NONE			
TRACK/STUD ROLLFORM LINE			
LINE LAYOUT			
THE BRADBURY COMPANY, INC.		R/LB	
AIR INDUSTRIAL PARK, MOUNDVILLE, MS 39107 U.S.A.		PART NO. D-5011258	