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BERCO

MANUFACTURERS AND IMPORTERS OF A COMPLETE LINE OF ENGINE REBUILDING EQUIPMENT

MODEL AB604A

AIRLESS SHOT BLASTING MACHINE

OPERATOR'S MANUAL

This is the complete set-up, operation and maintenance instruction manual on your Model AB604A. This booklet must be read thoroughly before installing or attempting to operate this machine. Damage to the machine or possible injury could occur as a result of failure to read and understand this manual thoroughly.

CONTENTS PAGE

MODEL DC80A

DUST FILTER CABINET

MEMBER

WARNING

* This machine ***must*** be installed by a qualified electrician only, and ***must*** be grounded in accordance with the National Electrical Code.

* Read the Operator's Manual carefully before attempting to operate or adjust the machine.

* Keep all safety shields in place.

* Never attempt to adjust this machine while it is in operation.

* This cleaning machine can leave blasting media on or in internal passages of parts to be cleaned.

* Cylinder heads, or any other part with hidden passages or blind holes, must be absolutely, totally dry and free from grease or oil before they are cleaned in this machine. If they are not, small amounts of steel shot may stick to these wet areas, and probably will not be visible to the operator upon inspection.

* Baking and dehydrating cylinder heads is the best way to condition them for shot blasting in order to minimize the possibility of steel shot sticking inside the hidden passages or blind holes of a cylinder head.

* Reclaimed steel shot ***MUST NOT*** be used with this machine. Reclaimed shot will create unwanted dust and will lead to poor performance of the shot blaster. The proper steel shot can be reordered from the factory when replenishment is needed.

* *IT IS THE OPERATOR'S RESPONSIBILITY TO SEE THAT STRICT QUALITY CONTROL STANDARDS ARE MAINTAINED, AND THAT CYLINDER HEADS ARE COMPLETELY FREE FROM STEEL SHOT PRIOR TO RE-ASSEMBLY. eVEN SMALL AMOUNTS OF STEEL SHOT MAY CAUSE PREMATURE FAILURE OF THE CYLINDER HEAD OR THE ENGINE THAT IT IS ASSEMBLED ONTO.*

* This machine is intended for indoor use only. This machine is not intended for outdoor use unless proper protection from the elements is provided for this machine.

* Violations of these safety rules or other improper use of this machine could lead to injury.

The AB604A operates on 208/240 Volt, 3-phase power, and will draw 36 amps on 230 Volt, 3-phase. A manual disconnect must be provided by the customer. If the disconnect is fused, the fuses should be 50 amp dual element (slow-blow) or at least 60 amp single element. Also, if a circuit breaker is used in conjunction with the disconnect, the breaker should be 60 amp. This is needed for the starting current of the motor.

OPTIONAL POWER REQUIREMENTS

230 Volt, Single Phase: If the machine has been ordered for 230 Volt single phase operation the machine will draw 50 amps. A fused disconnect should have dual element fuses rated at a minimum of 80 amps. The minimum size for a circuit breaker should be 90 amps.

480 Volt, Three Phase: If the machine has been ordered for 480 Volt three phase operation the machine will draw 14 amps. A fused disconnect should have dual element fuses rated at a minimum of 25 amps. The minimum size for a circuit breaker should be 30 amps.

ADDITIONAL INSTRUCTIONS FOR SINGLE PHASE

ELECTRICAL POWER CONNECTIONS:

Proper wire size must be used to supply full voltage to the motor to achieve full performance. On a power feed line of 25 feet or less (from power source to machine) #4 copper wire may be used. Check with qualified electrician on size of wire for line length over 25 feet. The minimum size for the circuit breaker should be 90 amps. If a fusible switch is used, dual element fuses must be used at a minimum size of 80 amps.

OPERATING NOTICE:

There are start capacitors used in the single phase motor to get it started and running up to full RPM. These capacitors generate heat on each start up and will overheat if the motor is started excessively. The motor manufacturer recommends never starting the motor over **FIVE TIMES AN HOUR.** Exceeding these limits could burn out capacitors.

As this machine coasts down it will produce a different sound. This is normal for this single phase motor as the capacitors unload. You will also notice a noise as it starts up but not as severe. The motor should run smooth as it reaches full RPM. After the impeller motor is up to full speed, the amp meter reading should be between 35 and 40 amps.

LOCATION INSTRUCTIONS

Several factors should be considered in planning for the location of your new AB604A Shot Blasting Machine.

1. Proper location of the AB604A can greatly improve the material flow of parts to be cleaned through your cleaning department and an improper location can cause a bottleneck and lost time in unnecessary material handling.

2. The machine should not be located in proximity with a spray washing machine or hot tank, as high humidity will cause erratic feeding of the AB604A.

3. The AB604A should be located in an area that has at least 78" of head room.

4. Consideration may be given to the location of the machine beneath an overhead crane or monorail hoist to facilitate loading heavy heads into the machine.

5. This machine is intended for indoor use *only.* This machine is not intended for outdoor use unless proper protection for the machine from the elements is provided. This machine should never be installed in an unprotected location, where water and moisture could come into contact with electrical components. Take the time to install the machine properly, and protect the machine from the weather.

6. The machine should be leveled and shimmed until it is solid. At least two corners should be anchored to the floor with concrete anchors, preferably diagonally opposite corners after the machine is leveled.

7. For maximum efficiency, make certain that an area at least 30" wide extending the length of the machine can be kept clear of obstructions or other machinery for ease in operating the machine.

8. Verify that a suitable wall location can be found for the customer-supplied manual disconnect switch so that it is in the operator's view when he is standing at the machine control panel.

SET-UP INSTRUCTIONS

Remove the Filter Cabinet and the AB604A from the shipping skids. The AB604A may be moved by means of lifting brackets which are located on top of the machine.
WARNING: THIS MACHINE WEIGHS APPROXIMATELY 2,000 LBS. HANDLE WITH CAUTION!

Place the machine in the desired operating location. Place the Filter Cabinet on the left side of the Shot Machine. Install the 4" dust collector hose to the back of the Filter Cabinet; the other end is attached to the dust blower, which is located on top of the Shot Blaster.

Obtain the services of a qualified electrician to provide power to the machine. (See utility requirement, Page 2.) The electrical line should be attached to terminals L1, L2 and L3 on the power distribution block. A 110 Volt line for control voltage needs to be hooked up to the terminal adjacent to the power distribution block. After the power has been hooked up and turned on, check the rotation of the impeller. Proper rotation is clockwise when you are facing the front of the machine. (In order to start the impeller, both doors must be closed, the thirty-minute timer turned on and the start button pressed. See Operation Instructions for further details.)

After the machine has been correctly wired, it is ready to be loaded with shot. Shot should be added to the right and/or left side of the impeller housing and blades. Do not pour shot directly into the impeller housing as this will tend to slug the impeller on initial start up. One hundred pounds may be adequate to start. Additional shot, if needed, may be added while the machine is running. (See Operating Instructions.)

OPERATING INSTRUCTIONS

**ALL PARTS MUST BE ABSOLUTELY <u>DRY</u>
AND FREE FROM GREASE AND OIL BEFORE
CLEANING THEM IN THIS MACHINE.**

Load the heads into the head fixtures following these steps:

1. Press the "*jog*" button to rotate the head fixture directly in front of the door opening.

2. Remove the V-shaped snap-in rods from the head fixture set-up.

3. Place the head on the flat set of bars.

4. Secure the head using the V-shaped bars.

5. Repeat steps 1 through 4 for any additional cylinder heads.

6. After the head/s is/are securely in the head fixtures, press "*jog*" button again to rotate the head fixture assembly at least one full revolution to verify that the parts will clear the cabinet and are securely in place.

7. After the heads have been loaded into the cabinet, the machine is now ready to start the cleaning cycle. Both doors must be closed and the handle in the latched position. Set the timer on the electrical panel to the desired cleaning time and press "*start*" button. This will start the impeller motor along with the head fixture motor and the dust suction blower.

8. After the impeller motor is up to full speed, the amp meter reading should be between 21 and 27 amps for 230 Volt 3-phase service, between 11 and 13 amps for 480 Volt 3-phase service and between 35 and 40 amps for 230 Volt single phase service. The amp reading is an indication of the amount of shot being thrown by the impeller blades. If the amp reading is below that indicated, more shot must be added to the air baffle located on the right side of the cabinet. Shot should be added while the indicated above is reached. <u>DO NOT OVERFILL!</u>

9. Once the cleaning cycle has begun, it may be stopped at any time by either turning the timer knob to "*zero*" or by depressing the red "*stop*" button.

10. After the cleaning cycle times out, the head fixture will continue to run on the shake-out cycle. The shake-out cycle is used to remove the greatest portion of shot from the heads. The length of time that the shake-out cycle operates is adjustable on the timer located inside the electrical panel.

11. The doors may be opened before the shake-out cycle has completed but doing so will interrupt the cycle and stop the head fixture.

12. When the cleaning cycle and shake-out cycle have been completed, the heads may be removed from the cabinet. This will be done by "*jogging*" the head fixture so that the head rack is directly in front of the door, thus making cleaned heads easily removable.

13. After the heads have gone through the shake-out cycle, the small amount of shot still hidden in the head can be removed by a shot removal tumbler, compressed air or flushed out by placing the heads in a spray washer for a couple of minutes. A magnet should be placed in the filter system to catch any steel shot.

There are start capacitors used in the single phase motor to get it started and running up to full RPM. These capacitors generate heat on each start up and will overheat if the motor is started excessively. The motor manufacturer recommends never starting the motor over **FIVE TIMES AN HOUR.** Exceeding these limits could burn out the capacitors.

As this machine coasts down it will produce a different sound. This is normal for this single phase motor as the capacitors unload. You will also notice a noise as it starts up but not as severe. The motor should run smooth as it reaches fur RPM.

MAINTENANCE INSTRUCTIONS

Various parts of the AB604A are subjected to a very abrasive environment and will at some point require replacement. These parts include the impeller blades, head racks and rods, deflector and impeller housing. These components are manufactured from special alloy materials and subjected to specific treatments to insure their proper function and life. For this reason, under *no* circumstances should replacement parts other than those manufactured specifically for the AB604A be used.

The bearings on the ends of the center cabinet shaft (right and left side) should be lubricated once every 1,000 hours of operation or approximately once every 6 months. The bearings on the end of the thrower wheel shaft (front and back) should be lubricated every 50 hours of use. Grease amount on both sets of these bearings should be very light. Too much grease will ruin the seals in the bearings resulting in a very short life. ***WARNING: IT IS BETTER TO NOT GREASE THAN TO OVER-GREASE AS TOO MUCH GREASE WILL RUIN THE BEARING SEALS AND RESULT IN BEARING FAILURE.***

The gearmotor oil level should be checked every month and replenished with gear oil if necessary.

The center cabinet shaft is driven by a chain. The idler shaft of this chain system has a grease fitting exposed through the chain guard. This fitting should be greased monthly. Chain lube should be applied to the chain every 3 months minimum. The tension of the chain drive may be adjusted by loosening the four bolts securing the gearmotor to the cabinet and sliding it to a position which reduces the slack in the chain.

The filter cabinet is provided with a shaker handle which agitates the filter bags and causes them to drop excess dust accumulation into the pan located at the bottom of the unit. The shaker should be operated at least twice daily and the tray emptied when necessary. Excessive dust coming out of the DC80A cabinet usually indicates a clogged filter cabinet; the shaker should then be operated.

Periodic cleaning and replacement of the filter bags will be necessary. Excessive shot consumption may be caused by shot being drawn into the dust collector.

As mentioned earlier, the AB604A is supplied with one door safety switch which requires that the doors be closed and latched before the impeller will operate. If the impeller motor does not start, the switch may need adjustment. This is done by loosening the lock nuts and advancing the switch slightly.

DO NOT, UNDER ANY CIRCUMSTANCE,
REMOVE THE DOOR INTERLOCK SAFETY SWITCH
FROM THE OPERATIONAL CIRCUIT.

The twin drive belts for the impeller blades should be checked for tightness. An adjusting bolt on the motor mount plate is provided so belts can be adjusted without pry bars or moving the motor sheave alignment. If the belts are worn, they must be replaced as a pair.

CHANGING OF BLADES

Changing blades on the Model Ab604A is not a common job and need only be done after heavy use of the machine and excessive wear on the blades. Wear on the blades will result in a longer cleaning cycle. To return the performance of the machine back to original, follow these steps for ease of blade removal and installation:

1. Remove the two 3/8" nuts in the drain plate cover. Drain all the shot from the machine. If shot does not run out easily, the blades can be rocked back and forth by hand to knock shot out of the drain hole.

2. Remove fixturing rods so access to blades can be gained. With dry air, blow off any shot which might be on the blades. With the blades clean, they are now ready for removal.

3. Using a 3/4" socket with an extension and break-over bar, the three 1/2" x 1-1/4" grade 5 bolts can be removed from each blade. Do not save the bolts; they should never be reused.

4. After the blades have been removed, blow out the tapped holes with dry air and chase the threads with a 1/2"-13 N.C. tap. Reverse above steps to install new blades.

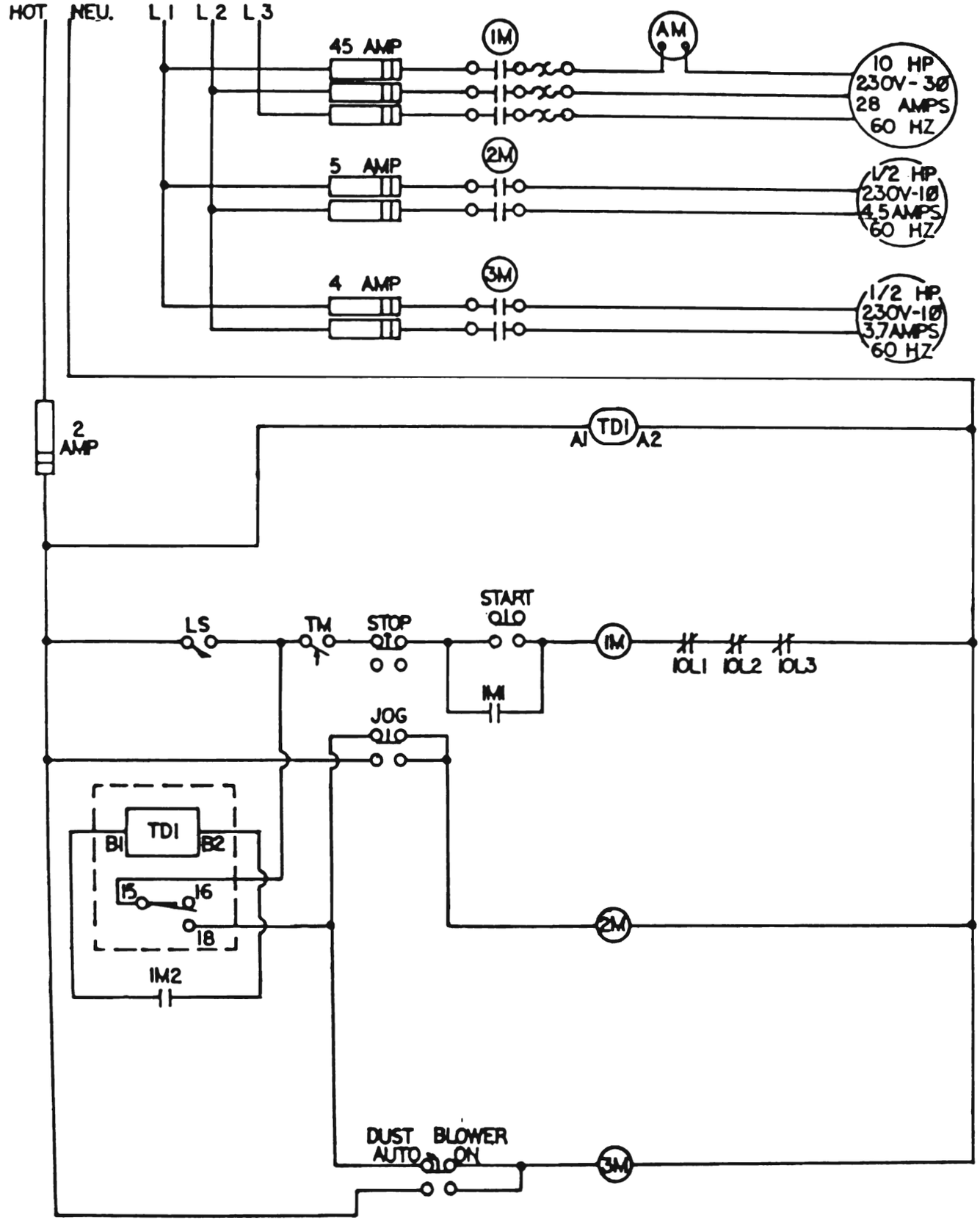
5. New blade bolts should be torqued to 80 ft. lbs. minimum.

6. You can easily ruin the threads in the hub, and, therefore, the hub, by tightening the blade bolts down into holes that have not been thoroughly cleaned of steel shot. When in doubt, clean the threads again.

MODEL AB604A

NOTE : CUSTOMER IS TO PROVIDE MAIN DISCONNECT LINE VOLTAGE INPUT 230V-3Ø

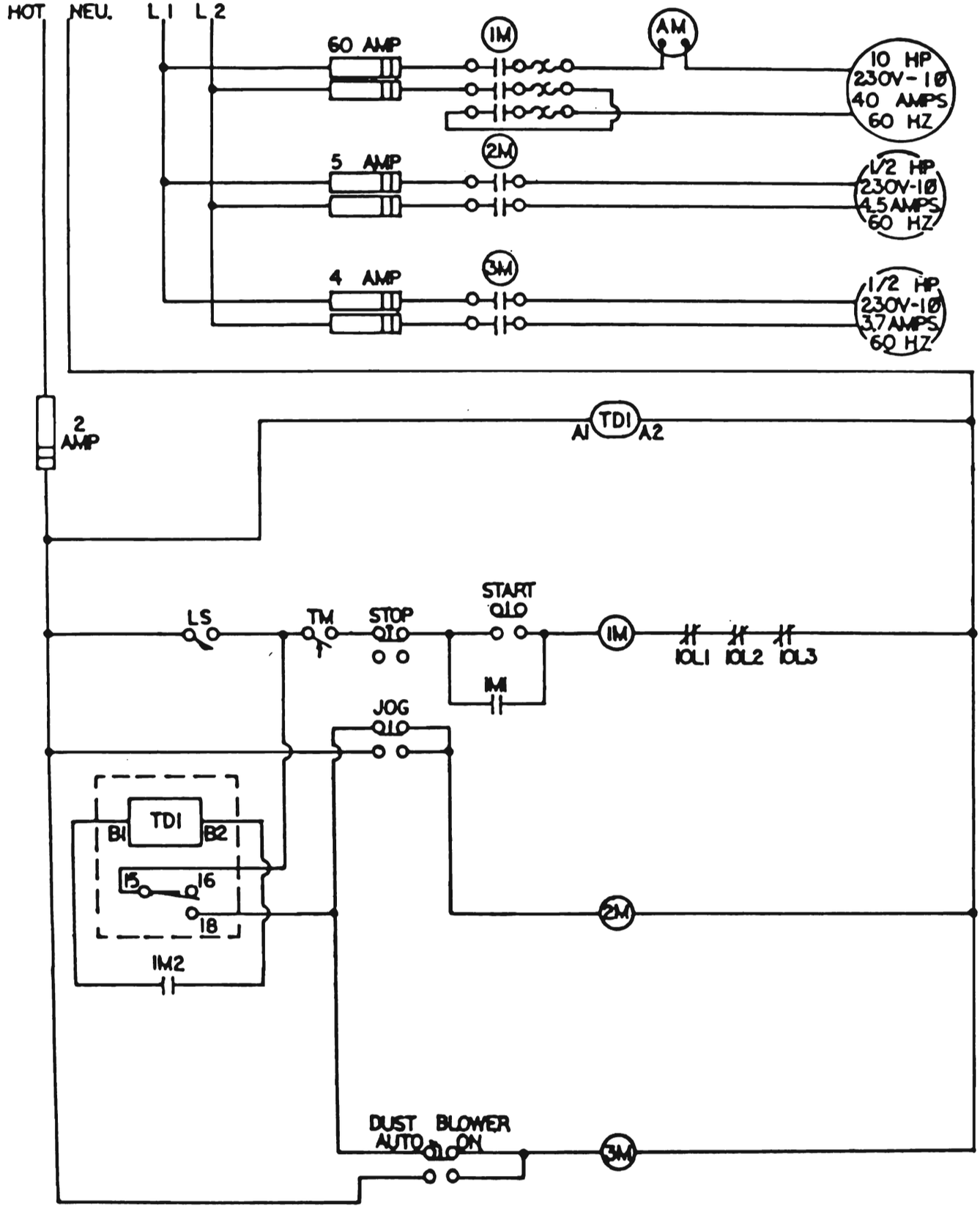
FULL LOAD AMPERE DRAW IS 36 AT 230V-3Ø INPUT 5/15/84



MODEL AB604A

NOTE : CUSTOMER IS TO PROVIDE MAIN DISCONNECT LINE VOLTAGE INPUT 230V-1Ø

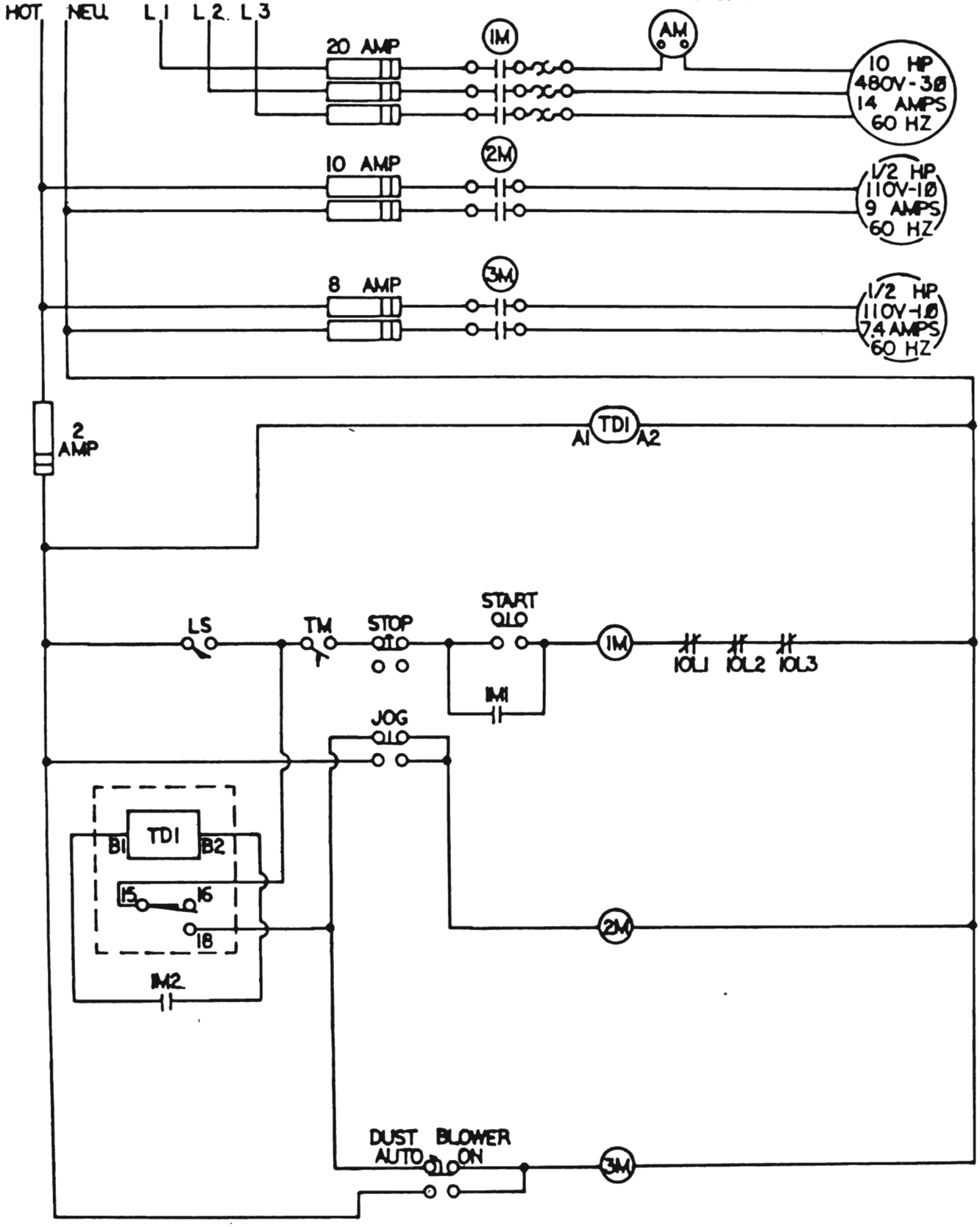
FULL LOAD AMPERE DRAW IS 50 AT 230V-1Ø INPUT 5/15/84



MODEL AB604A

NOTE : CUSTOMER IS TO PROVIDE MAIN DISCONNECT LINE VOLTAGE INPUT 480V-3Ø

FULL LOAD AMPERE DRAW IS 14 AT 480V-3Ø INPUT 5/15/84



SERVICE PARTS LISTING
MODEL AB604A

No.	Part#	Description	Qty.
1.	KI 2653	Motor Mount	1
2.	KI 2671	Damper W.A.	1
3.	KI 3519	Belt Cover	1
4.	KI 3523	Limit Switch Cab Lid	1
5.	KI 3542	Chain Guard W.A.	1
6.	KI 3569	Housing W.A.	1
7.	KI 3570	Thrower Wheel Shaft	1
8.	KI 3571	Thrower Wheel Blades	4
9.	KI 3572	Deflector	1
10.	KI 3578	Left Door W.A.	1
11.	KI 3579	Right Door W.A.	1
12.	KI 3759	Door Handle	1
13.	KI 3784	Hopper Clean-out W.A.	1
14.	KI 3807	Thrower Hub Key	1
15.	KI 3808	Sheave Hub Key	1
16.	KI 3809	Large Sprocket Key	1
17.	KI 3810	Enclosure to Coupler Conduit	1
18.	KI 3811	Coupler to Motor Conduit	1
19.	KI 3812	Enclosure to Limit Switch Conduit	1
20.	KI 3813	Gearmotor Conduit	1
21.	KI 3814	Blower Motor Conduit	1
22.	KI 3817	Blower Motor Sub-Assembly	1
23.	KI 4126	Head Fixture Rods	3
24.	KI 4133	Left Wheel W.A.	1
25.	KI 4134	Right Wheel W.A.	1
26.	KI 4136	Head Rack W.A.	4
27.	KI 4137	Head Rack Bar W.A.	4
28.	KI 4139	Door Trip Latch W.A.	1
29.	KI 4140	Basket Rod W.A.	6
30.	KI 4144	Trip Lever Bolt	1
31.	KI 5252	2-Position Selector Switch 1-NO/1-NC	1
32.	KI 5253	Green Push Button Switch 1-NO	1
33.	KI 5254	Red Mushroom Push Button 1-NO/1-NC	1
34.	KI 5259	Green Push Button Switch 1-NO/1-NC	1
35.	KI 101-034	3/8" x 3/4" Hex Bolt	4
36.	KI 101-035	3/8" x 1" Hex Bolt	18
37.	KI 101-051	1/2" x 1-1/4" Hex Bolt	4
38.	KI 101-054	1/2" x 2" Hex Bolt Grade 5	8
39.	KI 101-066	1/2" x 1-1/4" Hex Bolt Grade 5	12
40.	KI 101-076	3/8" x 1-1/4" Hex Bolt Grade 5	2
41.	KI 102-007	5/16" Lock Washer	14
42.	KI 102-008	5/16" Flat Washer	15
43.	KI 102-011	3/8" Flat Washer	18
44.	KI 102-012	3/8" Lock Washer	41
45.	KI 102-020	1/2" Flat Washer	4
46.	KI 102-021	1/2" Lock Washer	24

SERVICE PARTS LISTING
MODEL AB604A (CONT'D)

No.	Part#	Description	Qty.
47.	KI 103-007	5/16" Hex Nut	14
48.	KI 103-014	3/8" Hex Nut	38
49.	KI 103-019	3/8" Nylock Nut	1
50.	KI 103-027	1/2" Hex Nut	13
51.	KI 103-030	1/2" Jam Nut	3
52.	KI 105-011	Worm Gear Clamp 4-3/32" x 6"	1
53.	KI 107-011	1/2" x 3" Thumb Screw	1
54.	KI 108-038	3/8" x 1/2" Set Screw	3
55.	KI 108-049	1/2" x 5/8" x 3/8" Shoulder Bolt	1
56.	KI 108-061	3/8" x 3/8" x 5/16" Shoulder Bolt	1
57.	KI 108-068	1/2"-13 x 1-1/2" Set Screw	2
58.	KI 109-045	Enclosure Latch	2
59.	KI 112-026	#8 x 3/4" Self Tapping Screw	6
60.	KI 112-045	#10-24 Hex Nut	2
61.	KI 112-051	#10-24 x 1-1/2" Machine Screw	2
62.	KI 112-081	#8 x 3/8" Self Tapping Screw	7
63.	KI 112-082	#8 x 1/2" Self Tapping Screw	16
64.	KI 214-076	3/4" x 1/2" Hex Bushing	2
65.	KI 219-002	3/8" Box Connector	2
66.	KI 219-003	3/8" 90° Box Connector	2
67.	KI 219-053	1/2" Aluminum Nipple	1
68.	KI 219-071	1/2" 90° Lt Box Connector	3
69.	KI 219-072	1/2" Lt Box Connector	1
70.	KI 219-077	3/4" Box Connector	2
71.	KI 219-080	3/4" Tiger Lock Nut	2
72.	KI 321-009	Shaft Collars	2
73.	KI 321-065	1-11/16" 4-Bolt Flange Mount Bearing	4
74.	KI 322-563	21/32" x 66" V-Belt	2
75.	KI 322-873	7" 2-Groove Sheave	1
→ 76.	KI 322-874	1-11/16" QD Hub ←	1
77.	KI 322-876	7-3/4" 2-Groove Sheave	1
78.	KI 322-877	1-3/8" QD Hub	1
79.	KI 323-200	#40 Roller Chain	69"
80.	KI 323-201	#40 Connector Link	1
81.	KI 323-210	#40 12-Tooth Sprocket	1
82.	KI 323-216	#40 70-Tooth Sprocket	1
83.	KI 323-217	#40 19-Tooth Sprocket	1
84.	KI 323-218	1" Idler Shaft	1
85.	KI 323-219	1" x 4" Idler Tensioner	1
86.	KI 323-220	#40 Tapper Lock Hub	1
87.	KI 403-070	1/4" x 1/4" Ferrule Fitting	2
88.	KI 403-127	1/4" Copper Tubing	24"
89.	KI 531-033	1/2 hp Gearmotor	1
90.	KI 531-034	1/2 hp Motor	1
91.	KI 531-070	10 hp Motor	1
92.	KI 533-025	2-Pole Power Relay 110 Volt Coil	2
93.	KI 533-061	30 Amp Contactor	1

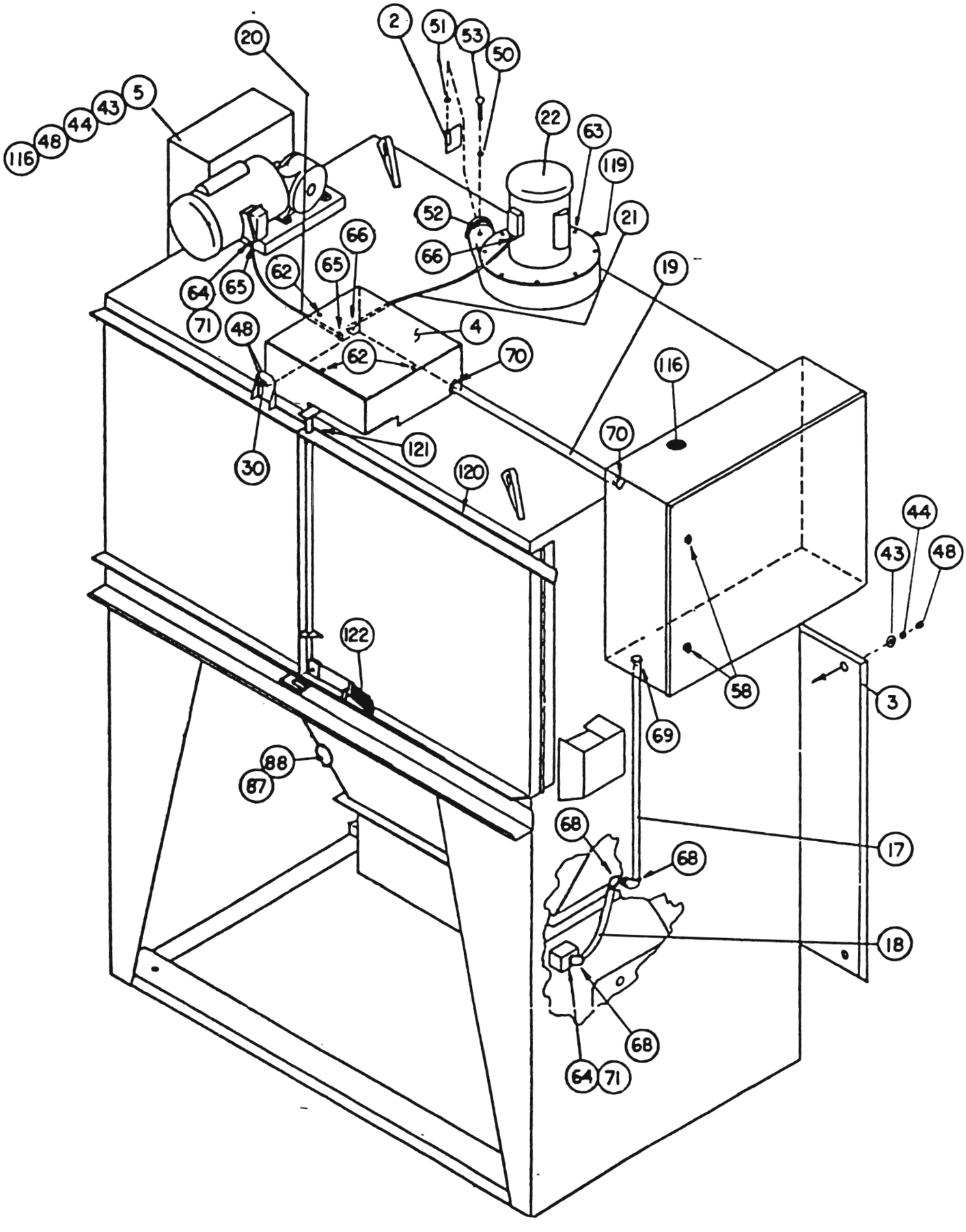
SERVICE PARTS LISTING
MODEL AB604A (CONT'D)

No.	Part#	Description	Qty.
94.	KI 535-086	24-32 Amp Overload Relay	1
95.	KI 535-102	3-Pole 1/10-30 Amp Fuse Block	1
96.	KI 535-103	2-Pole 1/10-30 Amp Fuse Block	1
97.	KI 535-104	3-Pole 31-60 Amp Fuse Block	1
98.	KI 535-161	2 Amp Fuse	1
99.	KI 535-166	45 Amp Fuse	3
100.	KI 535-176	4 Amp Fuse	2
101.	KI 535-177	5 Amp Fuse	2
102.	KI 535-300	Power Distribution Block	1
103.	KI 536-001	16 ga. Wire	5"
104.	KI 536-085	Terminal Block	2
105.	KI 536-086	End Piece for 536-085	1
106.	KI 537-018	1-Sec to 10-Min Delay Relay	1
107.	KI 538-006	30-Minute Manual Timer	1
108.	KI 538-027	1-NO/1-NC Adder Block	1
109.	KI 538-055	Push Button Limit Switch	1
110.	KI 540-014	0-50 Ammeter	1
111.	KI 540-023	35mm Mount Rail	4-1/8"
112.	KI 540-101	Legend Plate: Start	1
113.	KI 540-109	Legend Plate: Wheel Motor Stop	1
114.	KI 540-110	Legend Plate: Blower/Auto/On	1
115.	KI 540-111	Legend Plate: Head Fixture Jog	1
116.	KI 656-036	1-3/4" Plastic Plug	3
117.	KI 656-047	V-Seal	1
118.	KI 656-049	V-Seal	2
119.	KI 658-001	12" O.D. Foam Gasket	1
120.	KI 659-014	1/4" x 1" Felt Sealing Strip	*140"
121.	KI 659-018	1/8" x 1/2" Foam Sealing Strip	24"
122.	KI 808-016	1" Hand Grip	1
123.	KI 808-035	10-5/8" x 5/8" Bore Aluminum Fan	1
124.	KI 808-094	Adjustable Motor Mount	1
125.	KI 809-022	Wheel Hub	1
126.	KI 809-026	Right End Rubber Shield	1
127.	KI 658-021**	Adhesive	1

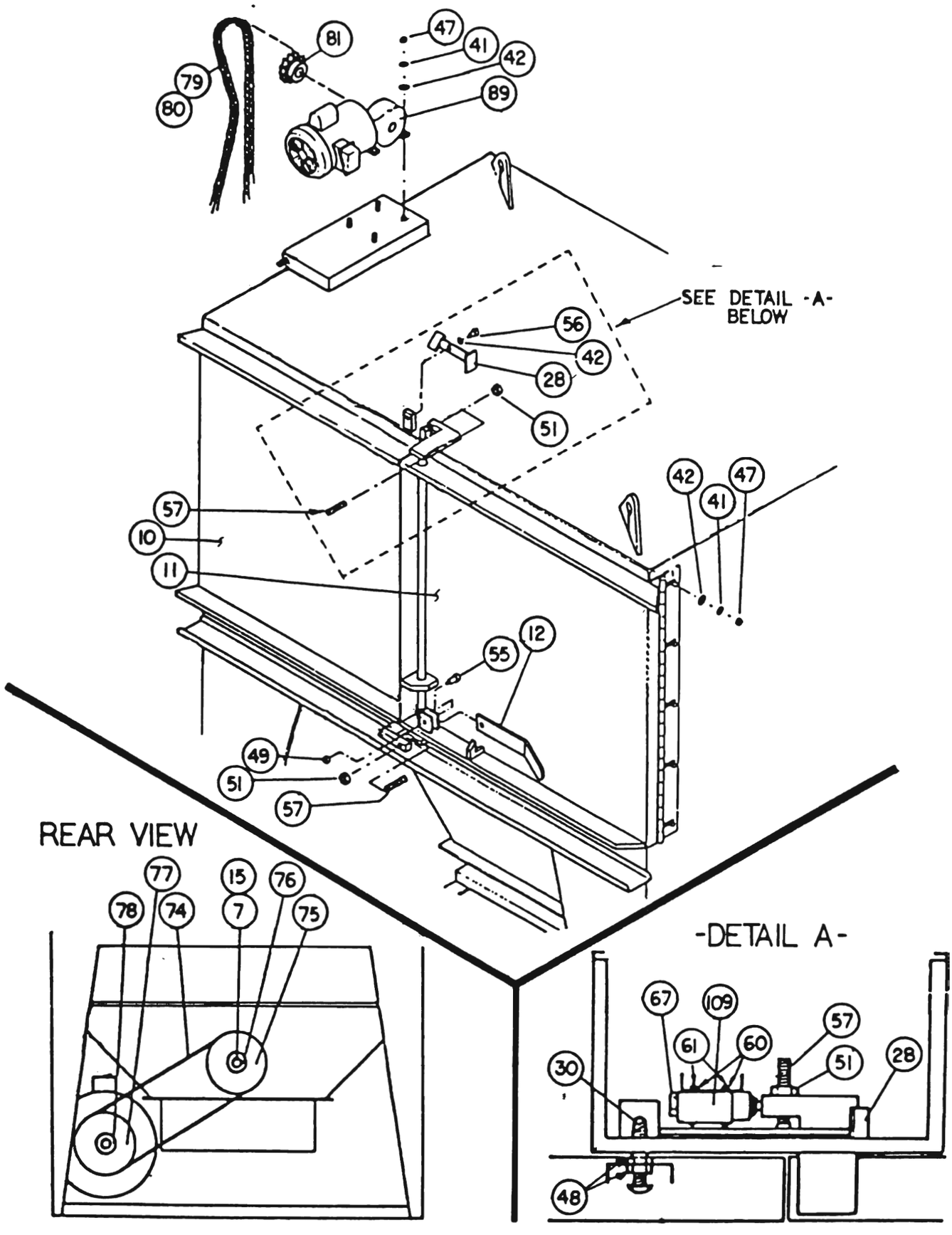
** NOT SHOWN ON DRAWING

* Order KI 658-021 to install

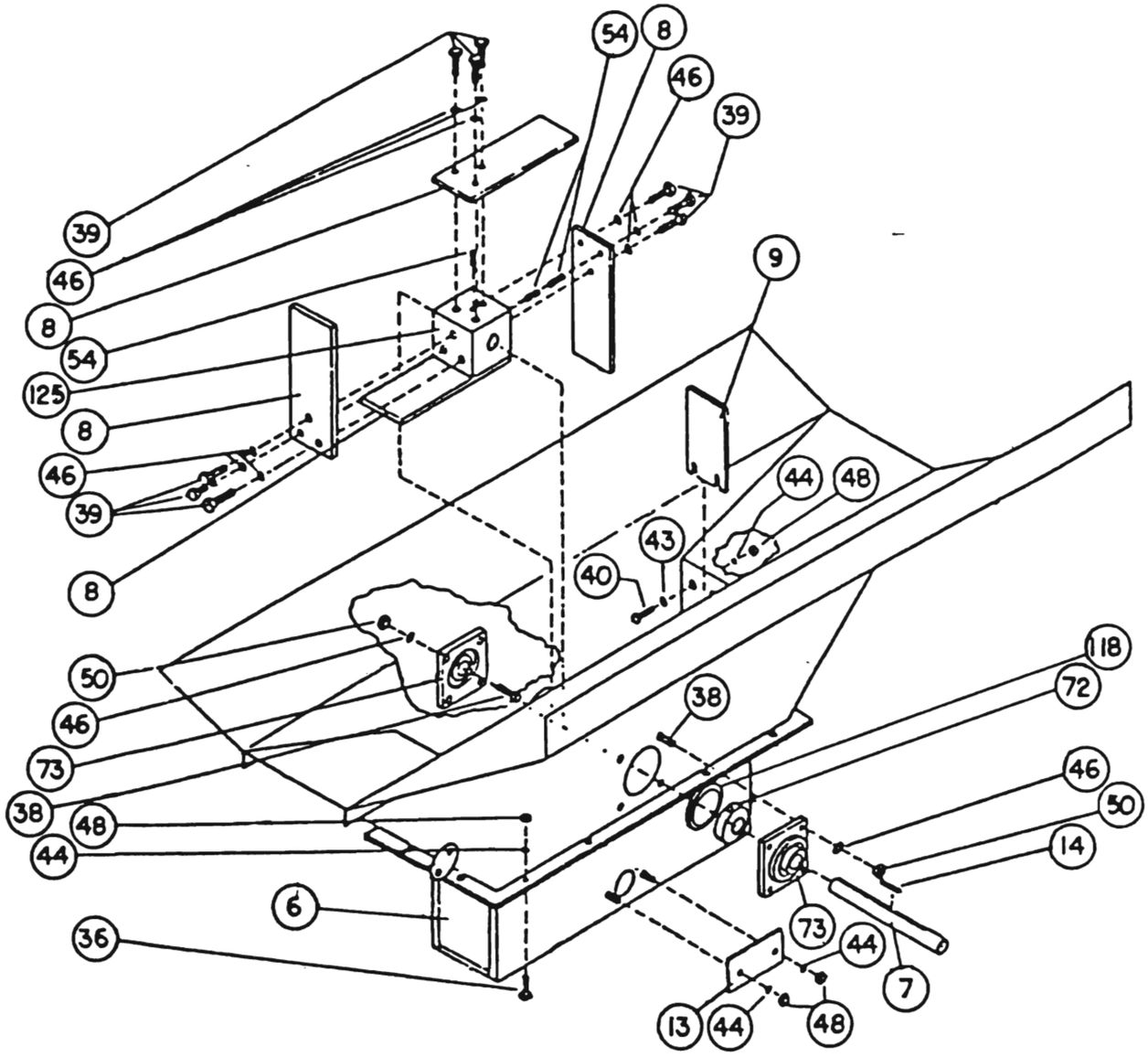
AB 604A
MACHINE ASS'Y



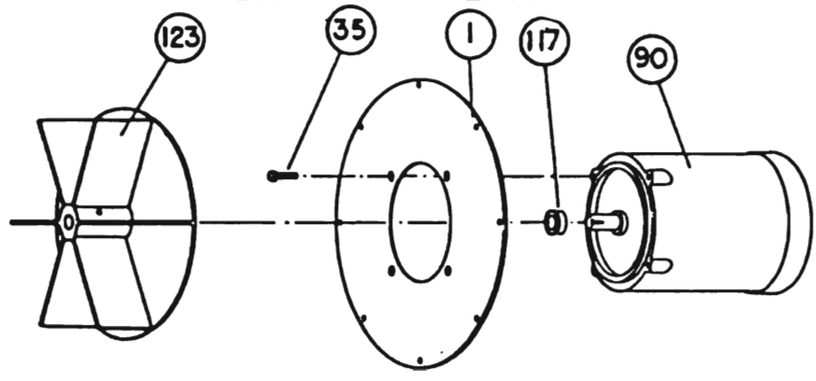
AB 604A
MACHINE ASS'Y



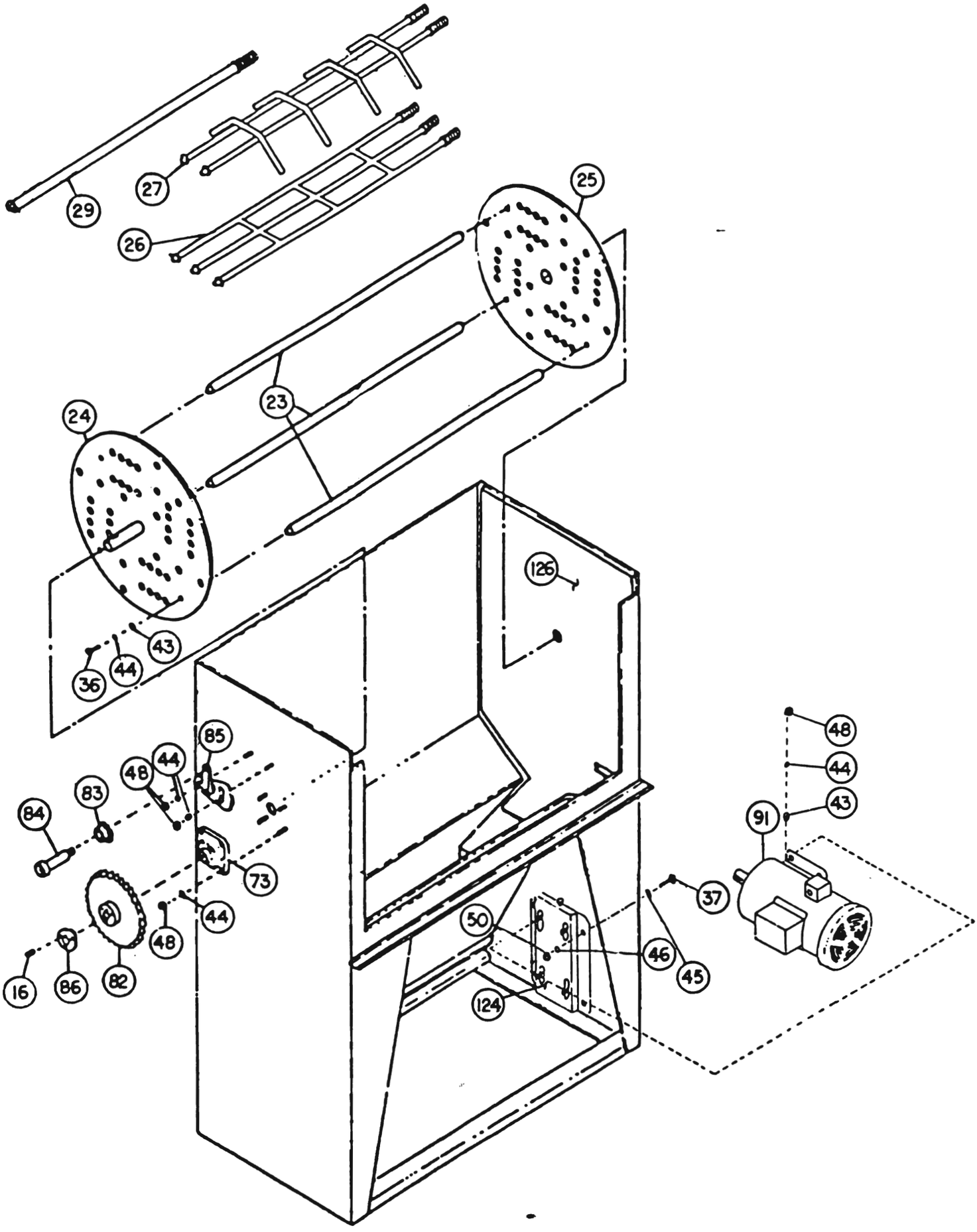
AB 604A
MACHINE ASS'Y



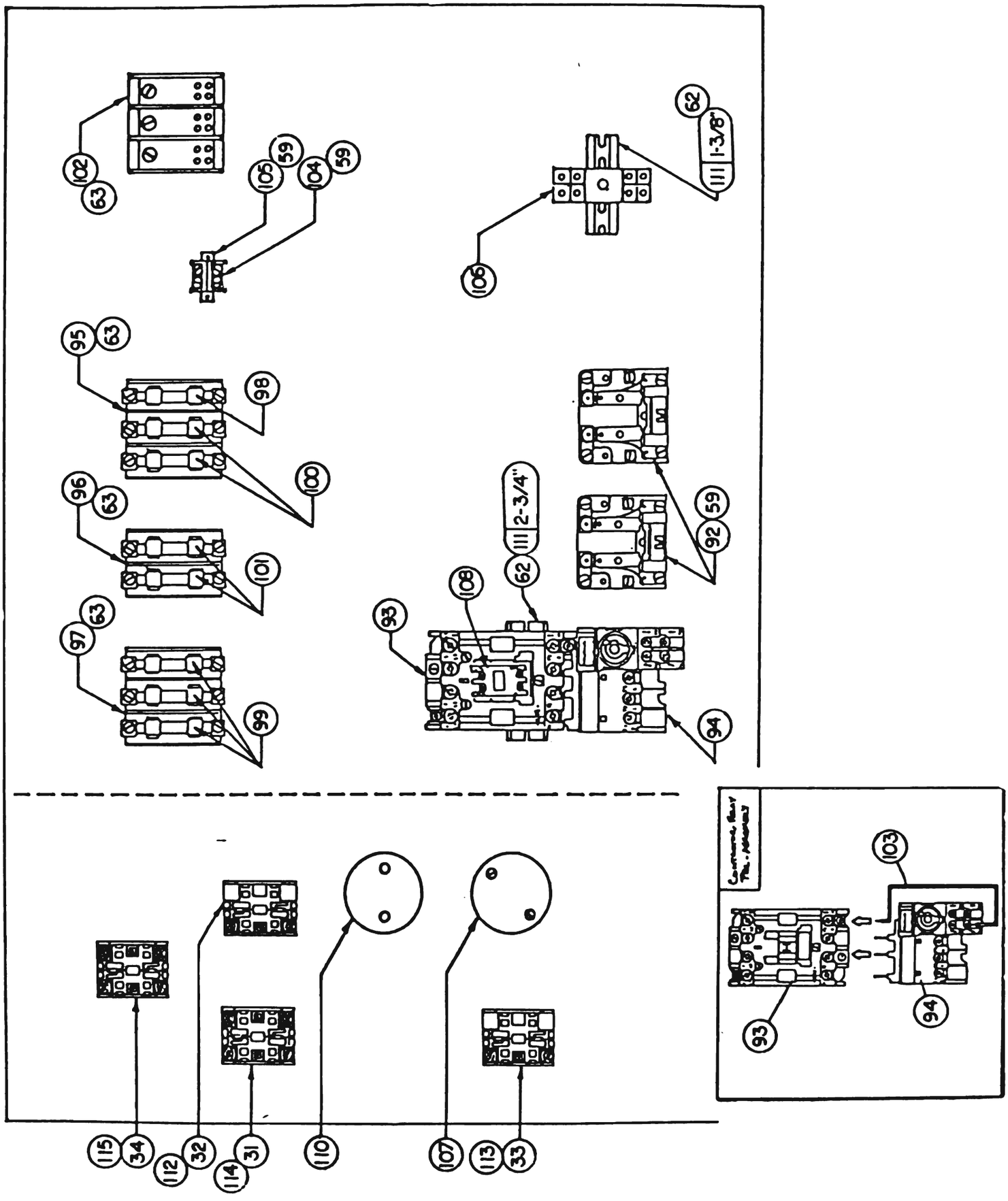
#22 BLOWER SUB ASS'Y



AB 604A
MACHINE ASS'Y



AB 604A
MACHINE ASS'Y
ELECTRICAL COMPONENTS



DC80A DRY FILTER CABINET

SET-UP INSTRUCTIONS

1. Remove the unit from the shipping skid and remove all packing material.

2. Remove the 4" I.D. flex hose and clamp from inside the cabinet.

3. Shake manual bag wrapper for free operation. Close inspection cover.

4. Check seal around bottom of dust collection tray for tight fit.

5. Clamp the 4" I.D. flex hose onto the input tube on the side of the filter cabinet.

6. Position the filter cabinet adjacent to the blower output, and clamp the flex hose onto the blower output.

7. Start the blower motor and check the unit for dust leaks.

MAINTENANCE INSTRUCTIONS

1. Slide the bag wrapper handle back and forth daily to shake accumulated dust off the filter sleeves. Frequency will depend upon cabinet usage. A high dust level inside the blasting cabinet is an indication that the bag wrapper needs to be operated.

2. Remove the dust collection tray and dump the accumulated dust as necessary.

3. This unit is designed to filter dry air only.

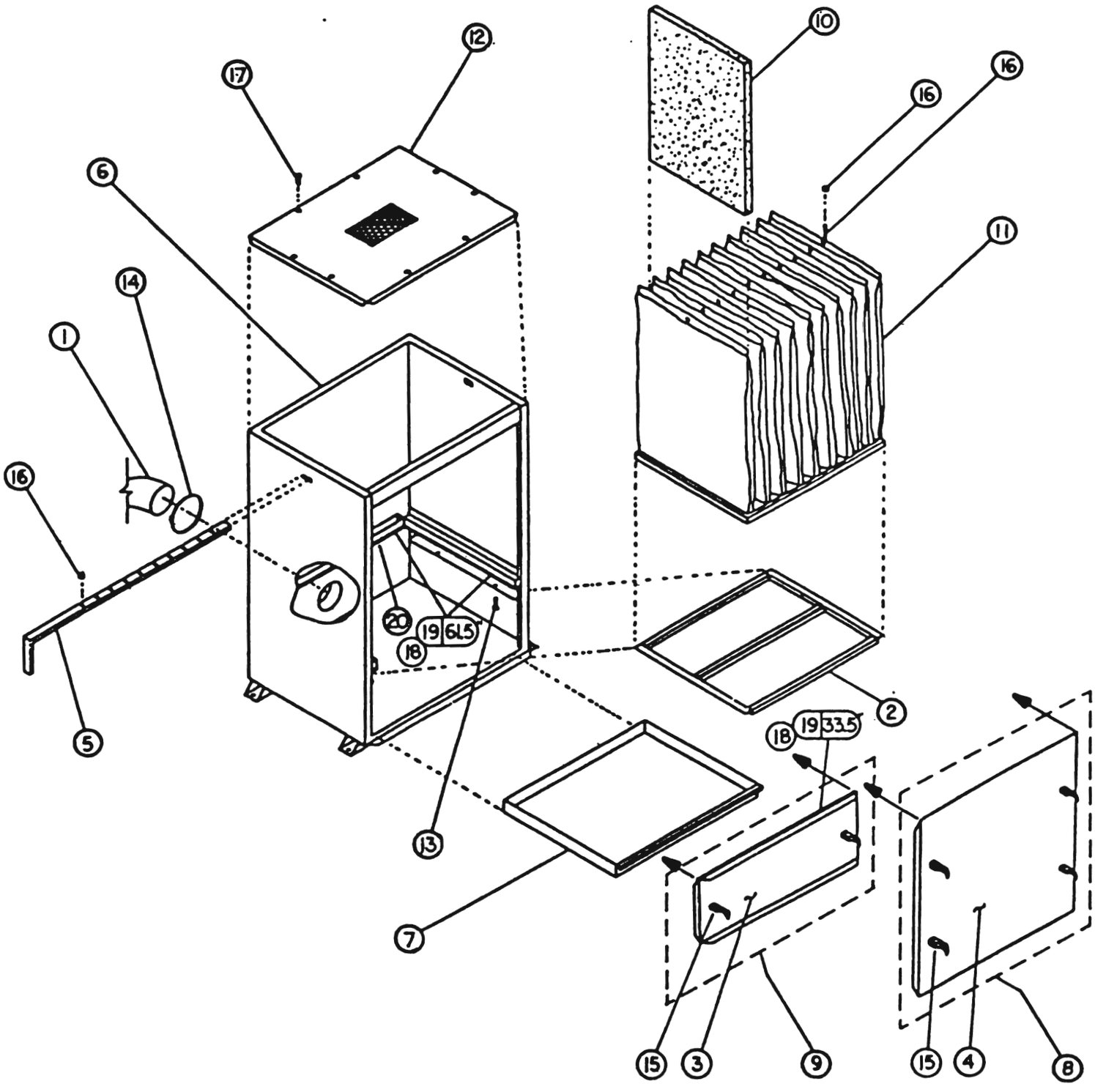
This dry filter cabinet may be used on any type of exhaust blower exhausting dust-laden air. It may be used to trap dust particles from grinders, sanders, saws, welders and wood-working machinery.

SERVICE PARTS LISTING
MODEL DC80A

No.	Part#	Description	Qty.
1.	KI 2557	Suction Hose	1
2.	KI 5140	Filter Lock W.A.	1
3.	KI 5903	Box Front	1
4.	KI 5904	Door	1
5.	KI 5908	Shaker Bar	1
6.	KI 5909	Cabinet W.A.	1
7.	KI 5911	Dust Pan W.A.	1
8.	KI 5912	Door Sub-Assembly	1
9.	KI 5913	Box Front Sub-Assembly	1
10.	KI 5914	Filter Bag Spacer	9
11.	KI 5915	Bag Frame Sub-Assembly	1
12.	KI 5916	Cabinet Top W.A.	1
13.	KI 101-005	1/4" x 1-1/2" Hex Bolt	4
14.	KI 105-011	Worm Gear Clamp 4-3/32" x 6"	1
15.	KI 109-001	Hornet Latch	6
16.	KI 109-062	Hook Bolt	10
17.	KI 112-086	#8 x 5/8" Self Drilling Screw	8
18.	KI 658-021	Adhesive	1
19.	KI 659-014	1/4" x 1" Felt Sealing Strip	*97"
20.	KI 659-012	1/2" x 1" Foam Sealing Strip	24"

* Order KI 658-021 to install.

DC 80A



FIELD SERVICE:

All Peterson products are backed by a network of field representatives who are capable of providing "first line" machine service, as well as any training that may be required. All rates quoted herein are rates in affect at the time of this printing and are subject to change at any time.

Peterson field representatives will instruct on the use of all purchased units as soon as possible after delivery. Further instruction needed due to changes in personnel can also be arranged at the current rate of $37.50 per hour, plus expenses.

Peterson field representatives can also be contacted for out-of-warranty service at the same rate of $37.50 per hour, plus applicable expenses. All charges made for training and service are to be paid directly to the servicing Peterson field representative and not to Peterson Machine Tool, Inc.

In addition to this network of field representatives, Peterson maintains a staff of qualified factory service specialists who are available for telephone consultation and may be scheduled for in-the-field service as deemed necessary.

Out-of-warranty service and/or machine reconditioning, done by factory personnel, will be charged the current rate of $37.50 per hour, plus actual travel and living expenses. (Daily labor charge not to exceed $300.00 per day). "Travel time" is considered "work time" for billing purposes.

VIOLATION OF SAFETY RULES AFFIXED TO THE MACHINES CAN LEAD TO INJURY.

REPAIR WORK AND OPERATING INSTRUCTIONS:

ALWAYS GIVE SERIAL NUMBER OF MACHINE WHEN ORDERING PARTS.

Each Peterson salesman is experienced in the servicing of Peterson equipment. On each call to your establishment, he will inspect the Peterson equipment being used in your shop. If at any time during his absence from your establishment, a Peterson machine should fail to function properly, advise us at the factory and we will have our representative call as soon as possible. If it is necessary to return equipment to us for repairs, we will so advise you. See "Returned Merchandise" below.

No charge will be made for service or parts when installed either at the factory or in the field if the machine is in the warranty period and upon inspection we find defective materials or workmanship. Likewise, no charge will be made for operating instructions provided the machine is in warranty period and operating instructions have not previously been provided on this particular machine.

Do not fail to contact us before returning any equipment as we may be able to help you either by mail or having our representative call.

RETURNED MERCHANDISE:

No merchandise is to be returned without the express written authorization of Peterson. If Peterson grants permission to return merchandise, it must be shipped transportation prepaid with machine parts properly oiled or greased to prevent rust and equipment properly crated. Peterson has the option of deducting up to 10% handling charge for any items returned. When returning equipment for repairs, always oil or grease machine parts to prevent rust, see that machines are properly crated and protected and prepay transportation. Any Cleaning Chemical and sludge has to be removed before shipment or the machine will be refused upon arrival at any Peterson facility.

TERMS:

Machines: For those customers who want to pay cash, terms are 2% 10, Net 30.
Low cost financing is available if credit is approved.
Parts: Terms are 1% 10, Net 30.
If credit is not established, please include payment with order or authorize C.O.D. terms. All payments must be in U.S. dollars. Finance charges up to 18% per annum may be charged for late payment.

GOVERNMENT BIDS:

Additional charges will be made for special packaging and marking if required by government contracts. Bidders are urged to review carefully the specifications supplied in invitations to bid, as well as all additional specifications referred to in the invitation.

Peterson
MACHINE TOOL INC.
ASK A PETERSON USER.

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