



NOTE:
 1. ALL DIMENSIONS ARE APPROXIMATE
 2. A CLEARANCE OF 3 FEET AROUND ALL MACHINERY IS RECOMMENDED
 3. MACHINE LINE DIRECTION: LH - LH CONTROLS
 4. TOTAL AIR REQUIRED: 22 CFM @ 90 PSI
 5. FULL LOAD AMPS REQUIRED: 119 AMPS @ 440/3/60

SUGGESTED TOOL LIST FOR INSTALLATION
 To facilitate installation, it would be most helpful if some, if not all, of the following items listed below could be available during setup of the machine line.

- 100 feet of heavy string or 20 ga. wire or equivalent (for alignment purposes)
- Two 8-foot 4 x 4s and two 6-foot 2x4s and smaller wooden blocks
- Two or three good quality measuring tapes
- Proper amount of hydraulic fluid and pump (electric if possible). Not necessary if customer has already filled tanks on appropriate machine
- Large pry bar (4-foot)
- Trouble light or flashlight (both if possible)
- Electrical extension cords
- Large push broom -- Heavy duty masonry drill -- Electrical insulation strippers
- Hydraulic bottle jack -- Spray lubricant -- Hammers -- Heavy chain -- Carpenter's Level
- Two-foot square -- Fork lift or roll dollies (to help in final alignment)

IPI INSTALLATION POLICY
 The customer is responsible for the following installation procedures prior to arrival of IPI serviceman for final adjustments, testing, and training.

1. All equipment set in place and properly spaced and connected in accordance with appropriate Layout Drawing.
2. All necessary external power lines connected to the machine(s).
3. All air and/or hydraulic connections made, including air compressor.
4. All interconnecting wires connected in accordance with the appropriate electrical (CD) drawing shipped with machinery.
5. All hydraulic reservoirs filled with correct hydraulic fluid type.
6. Sufficient material on hand such as metal coil, and insulation, glue, and pins if purchasing a fabricated line.
7. A prepared job-list on hand incorporating the full range of sizes, gauges of metal, etc., to thoroughly test machinery.
8. Operator(s) must be available to the Service technician during his entire stay.

DRAWN BY T COON		DATE Aug 18-98	SCALE N/A	CHECKED BY	REVISION	NAME-DATE
IPI WO- WORK ORDER NO.		CUSTOMER OMNI DUCT SYSTEMS			TITLE LHU DUCT LINE FLOOR LAYOUT	
IOWA PRECISION COILED METAL PROCESSING SYSTEMS, WORLDWIDE		Cedar Rapids, Iowa 52404			L-3191	
CUSTOMER No.					1 OF 1	