



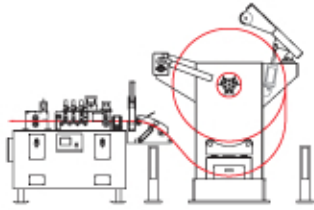
High Performance Coil Feeding Lines

ABOUT FEED LEASE

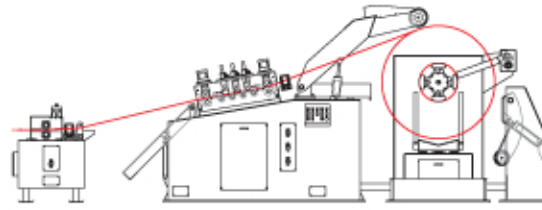
For over 40 years, Feed Lease Corporation (FLC) has been committed to designing and building premium quality, high performance press room automation equipment. Starting in 1969, FLC has been building air feeds, coil cradles, coil reels and powered straighteners. By the early 1980s, we had designed and manufactured our first electronic servo feed. During the 1980s, we also created a diverse and broad line of peripheral coil handling equipment. These include coil cars, coil elevators, coil storage racks, coil up enders, space saving coil handling systems, electronically controlled zig zag feed systems and much more.

FLC's in-house personnel have decades of experience in equipment design, precision machinery assembly, sales and service. An experienced parts department services any replacement part need — in most cases, on the same day. Our 24-hour-a-day technical support is as close as your telephone. Our dealer network provides convenient service and support to all of our customers. Our innovative engineering department provides the most up-to-date press feeding equipment on the market.

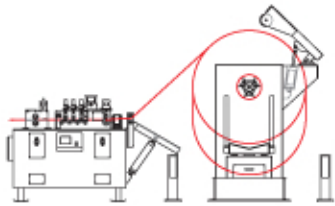
FLC is a modern designer and builder of a wide variety of feed lines and press room equipment. As shown on the following pages, we are experienced at building lines that conserve precious floor space, lines for very heavy gauge and/or high strength steel and versatile conventional lines that work with Class A and other surface-critical materials. We invite you to review this brochure and our website. We trust you will come to agree that Feed Lease is SMART. TOUGH. PROVEN.



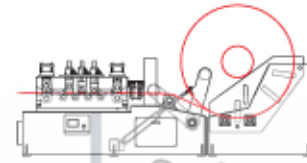
SMARTSAVER



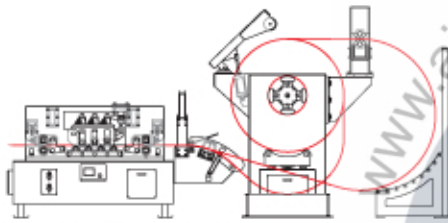
3 AXIS SYNCHRONIZED LINE



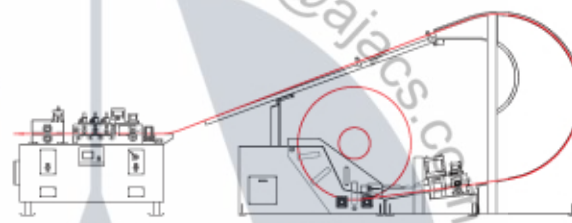
PADDLE LOOP LINE



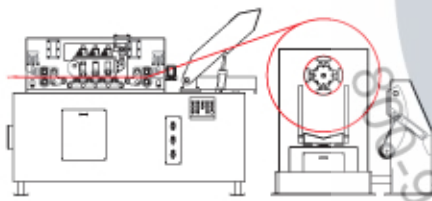
CRADLE/STRAIGHTENER/FEEDER



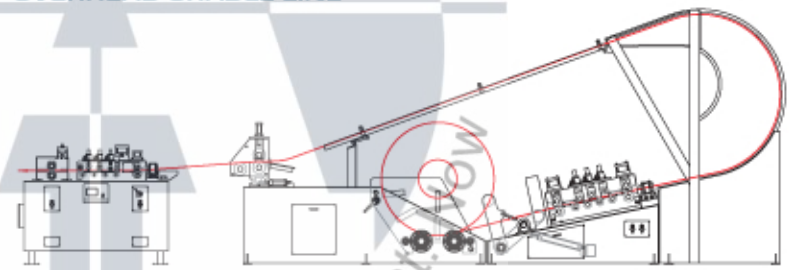
SMARTSAVER HD



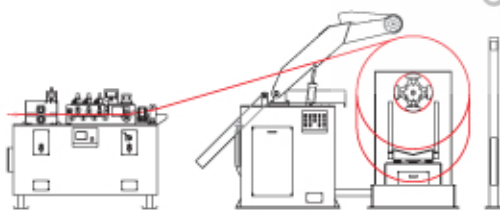
OVERHEAD CRADLE LINE



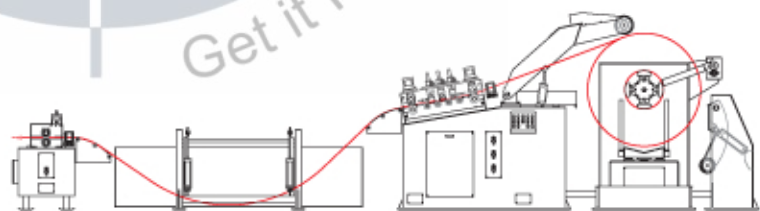
2 AXIS SYNCHRONIZED LINE



OVERHEAD CRADLE/STRAIGHTENER LINE



PADDLE LOOP LINE



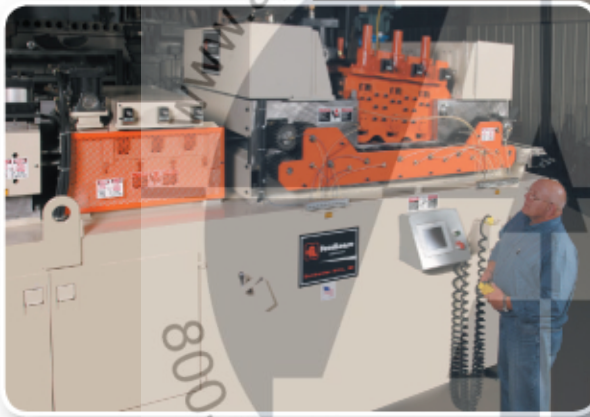
CONVENTIONAL LINE

SPACE-SAVER LINES

Synchronized Line

A synchronized line is a conventional feed line, but with one significant difference – no loop. Thus, a line that may normally require 45-50 feet of floor space and the expense of a looping pit instead requires only about 30 feet with no pit. A highly sophisticated control package communicates press speed, feed speed and required straightener speed automatically. The straightener and feed provide material to the press simultaneously, thus eliminating the need for the slack loop.

This synchronized line concept employs a feeder/straightener instead of a separate feed and straightener. This reduces the floor space significantly. This line (see right) is capable of running .394" thick high strength material in only 23 feet.



Paddle Loop Line

This spacesaver design combines a feeder/straightener with a powered reel. Slack loop is developed below the spindle, reducing floor space significantly compared to conventional slack loops. For thicker materials, an optional hold down arm/peeler/threader/debender assembly is used. Optional pilot release for the straightener is available.

SmartSaver Line

Another Space-Saver design is our innovative SmartSaver. For many applications, SmartSaver can save as much as 50% of the floor space required by a conventional feed line without making sacrifices in performance.

SmartSaver comes in two primary designs as shown here. Lines can be designed to handle material up to 72" wide, high strength steel and coil weights up to 60,000 Lb. The list of standard features is long, yet you can also select from several options to tailor the SmartSaver to solve your application's unique challenges. All of this for a price that is often LESS than a comparable conventional feed line. So why waste valuable floor space? SmartSaver provides maximum performance with minimum space.



The SmartSaver HD builds on many of the strengths of the SmartSaver. The addition of the heavy-duty pull-off roll enhances the versatility of the system by forcing material into a larger slack loop space. The SmartSaver HD is ideal for thicker materials and/or longer feed lengths, making it a great choice for blanking, progressive die and transfer press applications.



SmartSaver develops the loop below the spindle, saving considerable floor space. By combining this space-saving loop design with a feeder/straightener combo, the total footprint of the feed line is often only 15-18 feet. Pilot release for both feed and straightener rolls is available, making this design ideal for progressive die applications.

HEAVY-DUTY LINES FOR HIGH-STRENGTH STEEL

High strength steel requires special consideration when building a feed line. The photo below shows a line rated to run 36" wide x .500" thick material with a yield strength of up to 120 KSI. It employs two straighteners - one in the base of the cradle having 8" diameter rolls, one at the feed with 5" diameter rolls - for maximum versatility. The addition of the dual roll hold-down arm and hydraulic peeler device increases safety and ease of threading.



This reel-based system for high strength steel demonstrates optimum safety as well as optimum production. By including both top and bottom coil containment arms, safety is assured when the bands are cut on high strength, heavy gauge coils. The addition of the extreme-duty coil keeper rolls keeps the operator from having to load slide-on keeper arms onto the mandrel. These powered, self-centering rolls are built extremely tough and make coil changeovers a snap.

CONVENTIONAL LINES

A conventional line's versatility is a huge advantage. Special speed controls can ensure the straightener keeps running to avoid damaging surface-critical material. Safety devices for containing thick material and one-button automated setup are available. Adding a pull-thru straightener to the feed can further enhance versatility.



This line is rated for 40,000 lb. by 60" wide material. The versatility of this line is enhanced by the use of two straighteners. The large powered straightener handles the bulk of the material while the auxiliary pull-thru straightener mounted at the feed is used for lighter gauge materials.

This line is rated for 30" wide material and up to .312" thick material. It has a scissor-lift threading table that seats in the looping pit and allows for a simple and effective "tail out" mode. It also incorporates a crop shear on the exit side of the servo feed.



This 40,000 lb. x 60" wide line is CE certified and installed in Europe. Feed Lease can CE certify any of our feed line products.

PHOTO COURTESY OF PRIDGEON & CLAY KFT, APOSTAG, HUNGARY.

INDIVIDUAL PRESS ROOM EQUIPMENT



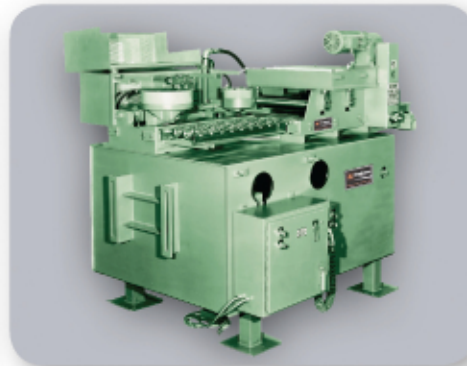
Servo Feeds:

- Roll widths from 12" to 84"
- Available for thicknesses up to .750"
- Roll diameters from 2.5" to 8"
- Servo feeds with pull-thru straighteners and powered feeder/straighteners are also available



Powered Straighteners:

- Straightener roll sizes from 2.25" to 8"
- Widths to 84"; thickness from .010-.750"
- Precision ground side plates
- Many safety and automation options



Air Feeds:

- From 2" to 6" bore main push cylinders
- Adjustable air check valve
- May be press or cabinet base mounted
- Optional pull-thru straighteners
- Double, dual-grip and zig-zag styles available



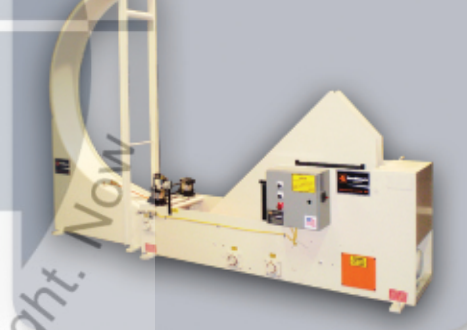
Upenders:

- Capacities from 10,000 lb. to 40,000 lb.
- 180 degree rotation optional
- Electro-mechanical drive for long-term usage
- Optional integration with coil feeding lines



Coil Reels and Load Cars:

- Capacities from 1,500 lb. to 60,000 lb.
- Width ranges from 12" to 84"
- Pull-off & powered models
- Single or double arm styles



Coil Cradles:

- Capacities from 4,000 lb. to 60,000 lb.
- Widths to 96"
- Available with pinch rolls or powered straighteners
- Many sizes of optional deflectors and chutes
- Rugged construction for dependable performance



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