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Fig.1.

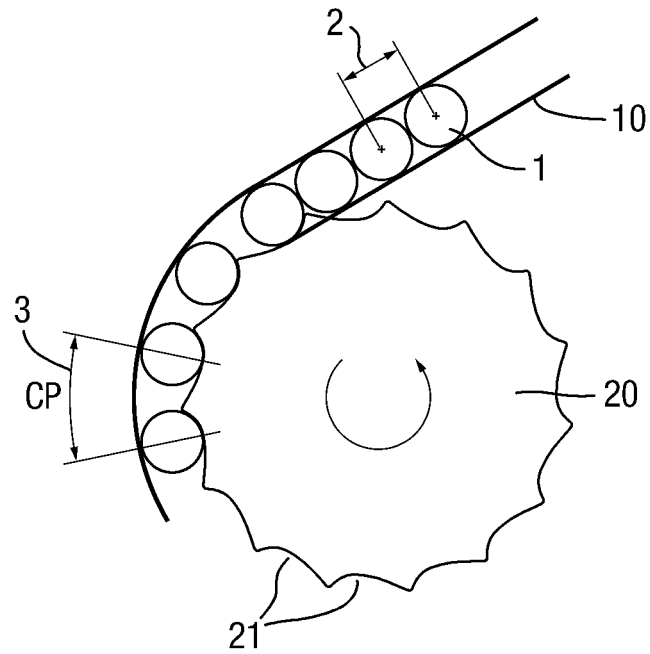
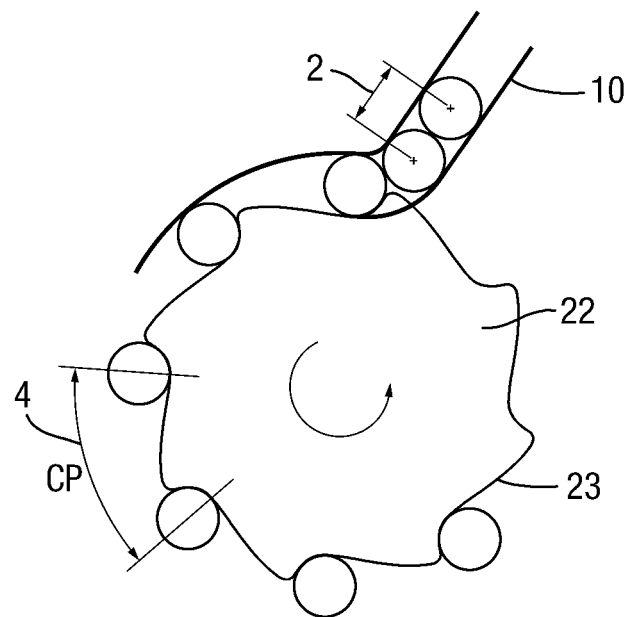


Fig.2.



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Fig.3a.

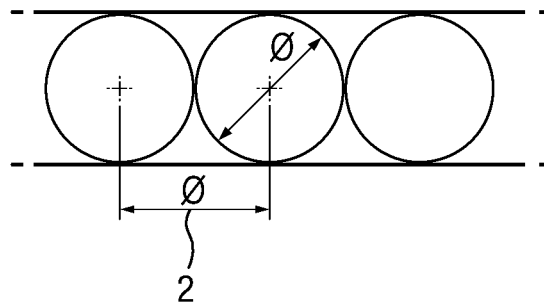
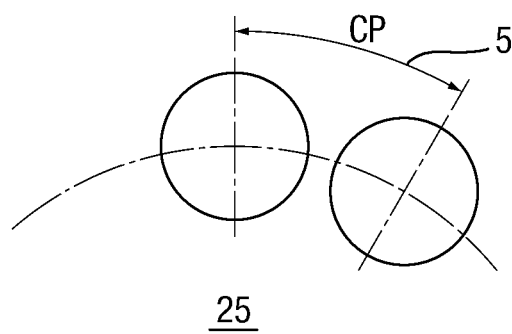


Fig.3b.



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Fig.4a.

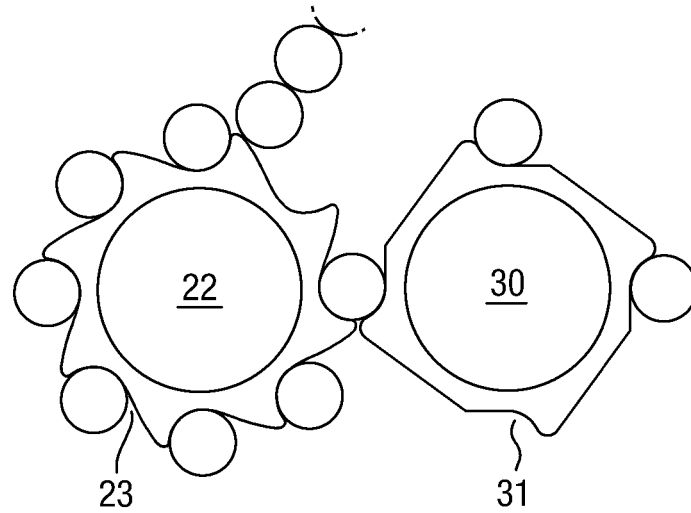


Fig.4b.

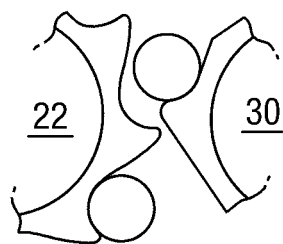
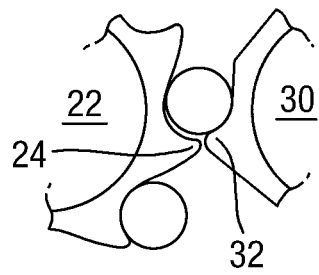
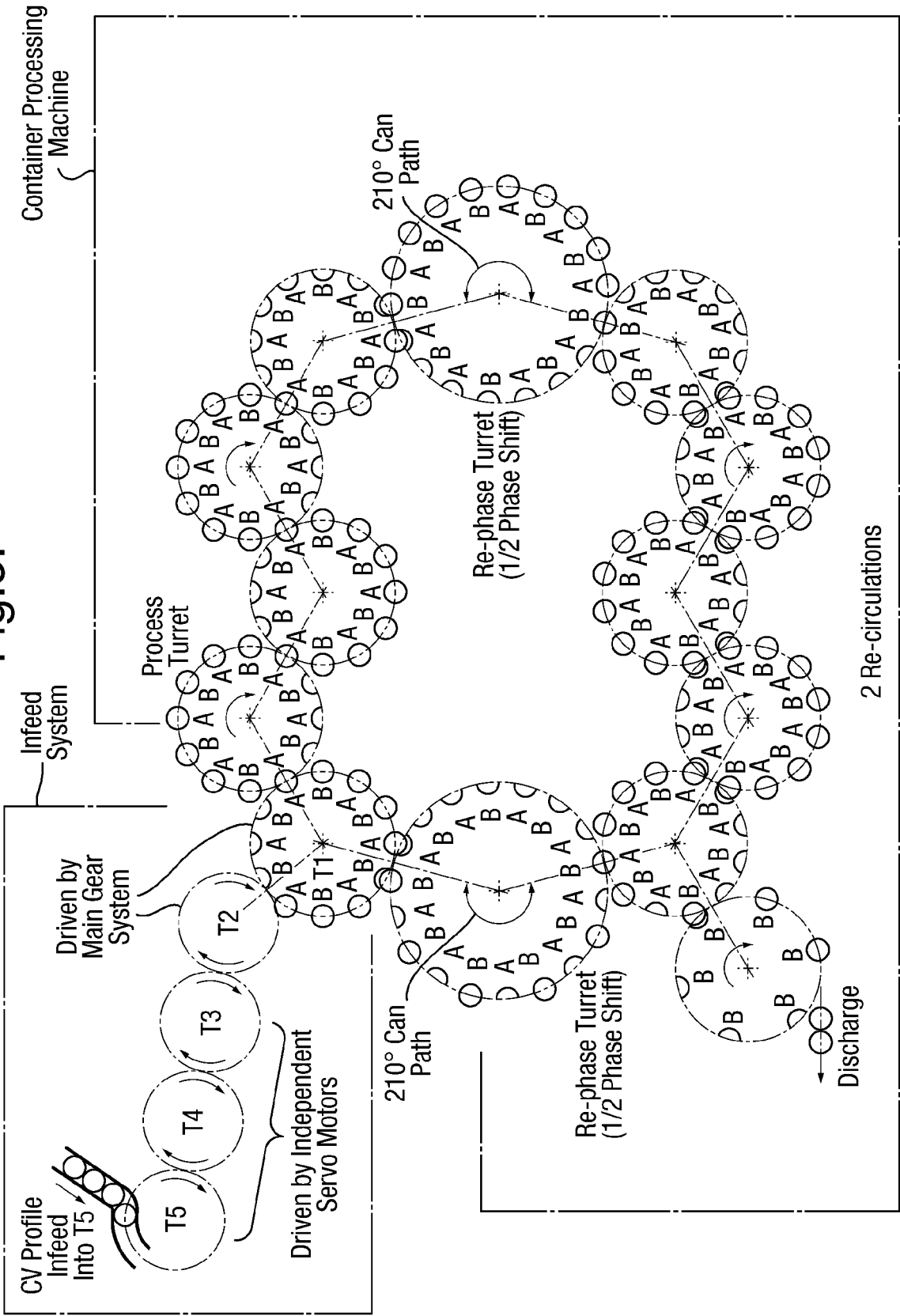
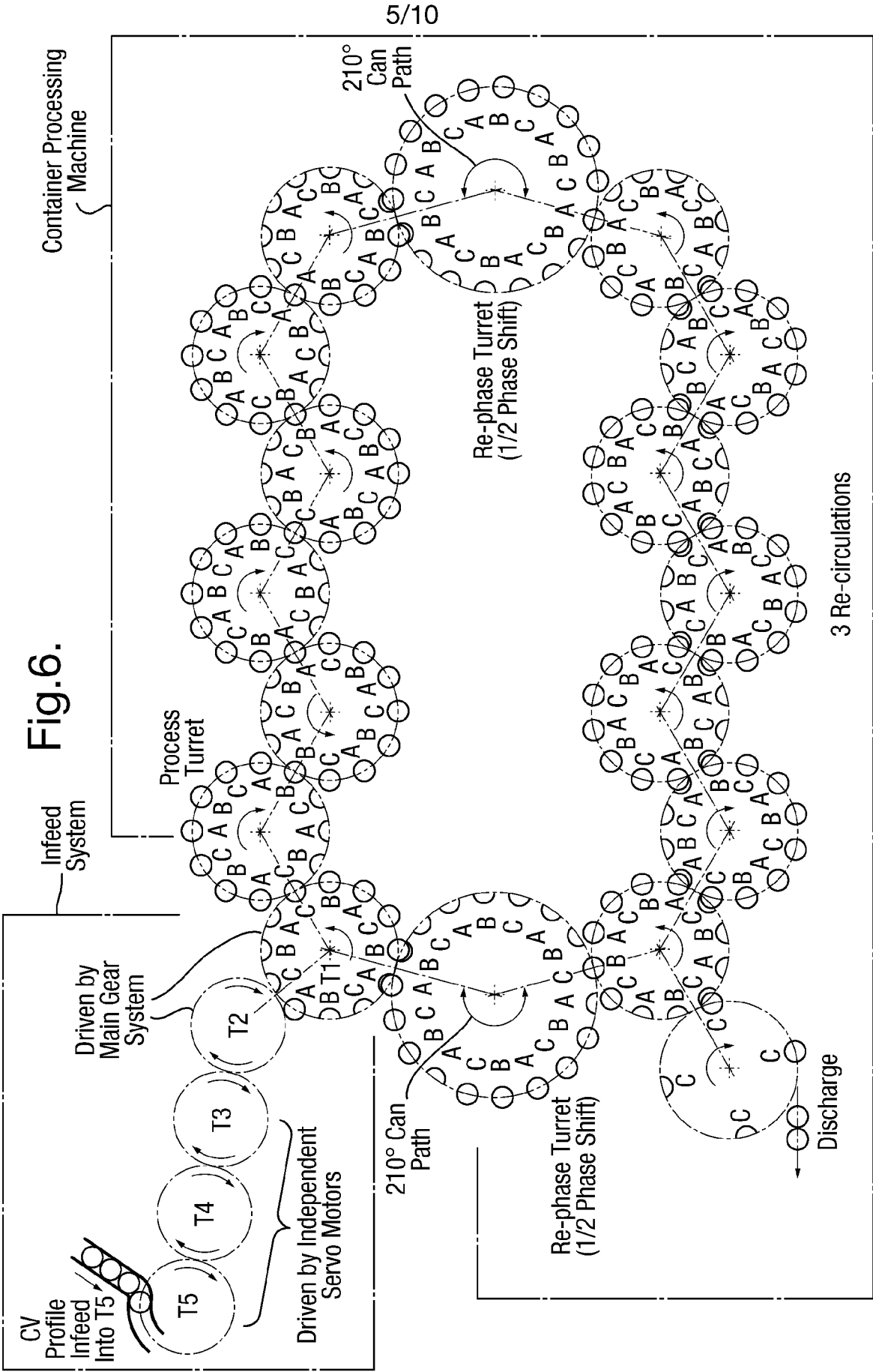


Fig.5.

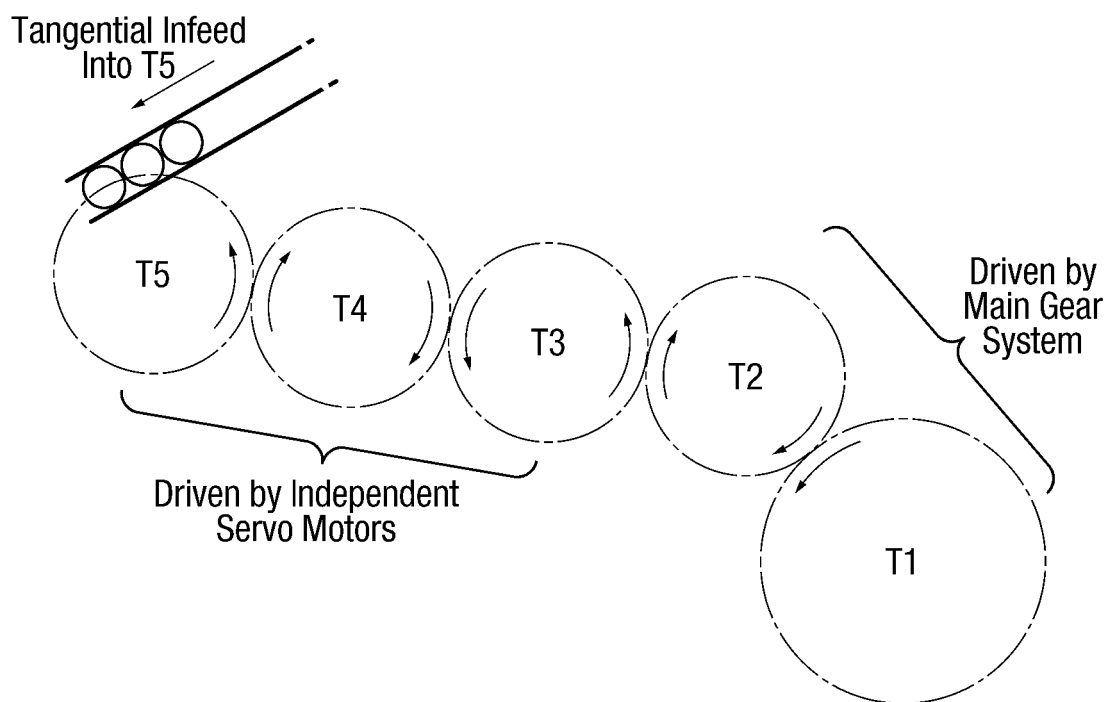




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Fig.7.

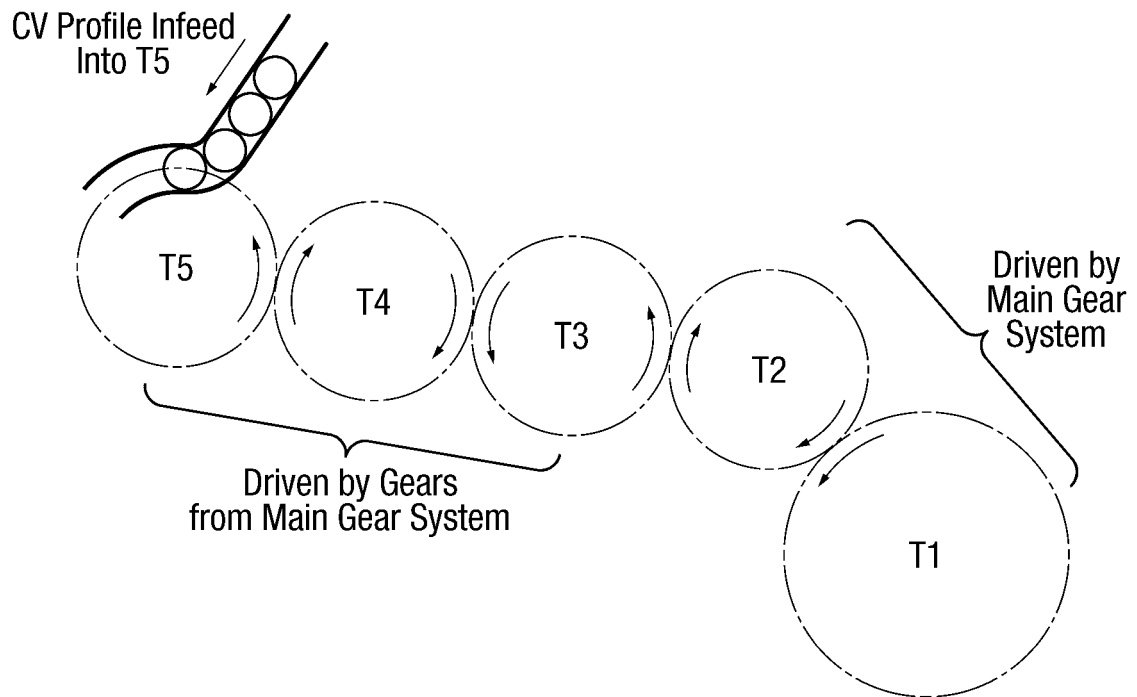
D &amp; I: 500CPM - 1500CPM Tangential Infeed



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Fig.8.

Extruded and D &amp; I: 250CPM CV Infeed



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Table 1

| D & I and extruded: 250CPM - 1500CPM CV infeed 5-turret<br>(Gear and servo motor drive) |                         |                            |                              |                            |                              |  |
|-----------------------------------------------------------------------------------------|-------------------------|----------------------------|------------------------------|----------------------------|------------------------------|--|
|                                                                                         |                         |                            |                              |                            |                              |  |
| T1<br>1Pocket<br>250RPM                                                                 | T2<br>1Pocket<br>250RPM | T3<br>2Pockets<br>125RPM   | T4<br>4Pockets<br>62.5RPM    | T5<br>8Pockets<br>31.25RPM | 250 CPM<br>12 Recirculations |  |
| 1.44:1                                                                                  | 2:1                     | 2:1                        | 2:1                          |                            |                              |  |
|                                                                                         |                         |                            |                              |                            |                              |  |
| T1<br>2Pocket<br>250RPM                                                                 | T2<br>2Pocket<br>250RPM | T3<br>4Pockets<br>125RPM   | T4<br>6Pockets<br>83-1/3RPM  | T5<br>8Pockets<br>62.5RPM  | 500 CPM<br>6 Recirculations  |  |
| 1.44:1                                                                                  | 2:1                     | 1.5:1                      | 1-1/3:1                      |                            |                              |  |
|                                                                                         |                         |                            |                              |                            |                              |  |
| T1<br>3Pocket<br>250RPM                                                                 | T2<br>3Pocket<br>250RPM | T3<br>4Pockets<br>187.5RPM | T4<br>6Pockets<br>125RPM     | T5<br>8Pockets<br>93.75RPM | 750 CPM<br>4 Recirculations  |  |
| 1.44:1                                                                                  | 1-1/3:1                 | 1.5:1                      | 1-1/3:1                      |                            |                              |  |
|                                                                                         |                         |                            |                              |                            |                              |  |
| T1<br>4Pocket<br>250RPM                                                                 | T2<br>4Pocket<br>250RPM | T3<br>4Pockets<br>250RPM   | T4<br>6Pockets<br>166-2/3RPM | T5<br>8Pockets<br>125RPM   | 1000 CPM<br>3 Recirculations |  |
| 1.44:1                                                                                  | 1:1                     | 1.5:1                      | 1-1/3:1                      |                            |                              |  |
|                                                                                         |                         |                            |                              |                            |                              |  |
| T1<br>6Pocket<br>250RPM                                                                 | T2<br>6Pocket<br>250RPM | T3<br>6Pockets<br>250RPM   | T4<br>6Pockets<br>250RPM     | T5<br>8Pockets<br>187.5RPM | 1500 CPM<br>2 Recirculations |  |
| 1.44:1                                                                                  | 1:1                     | 1:1                        | 1-1/3:1                      |                            |                              |  |

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Table 2

| D & I: 500CPM - 1500CPM tangential infeed 5-turret |                         |                              |                           |                              |                              |
|----------------------------------------------------|-------------------------|------------------------------|---------------------------|------------------------------|------------------------------|
| T1<br>2Pocket<br>250RPM                            | T2<br>2Pocket<br>250RPM | T3<br>4Pockets<br>125RPM     | T4<br>8Pockets<br>62.5RPM | T5<br>12Pockets<br>41-2/3RPM | 500 CPM<br>6 Recirculations  |
| 1.44:1                                             | 2:1                     | 2:1                          | 1.5:1                     | T5<br>15Pockets<br>33-1/3RPM |                              |
|                                                    |                         |                              | 1.875:1                   |                              |                              |
| T1<br>3Pocket<br>250RPM                            | T2<br>3Pocket<br>250RPM | T3<br>6Pockets<br>125RPM     | T4<br>10Pockets<br>75RPM  | T5<br>12Pockets<br>62.5RPM   | 750 CPM<br>4 Recirculations  |
| 1.44:1                                             | 2:1                     | 1-2/3:1                      | 1.2:1                     | T5<br>15Pockets<br>50RPM     |                              |
|                                                    |                         |                              | 1.5:1                     |                              |                              |
| T1<br>4Pocket<br>250RPM                            | T2<br>4Pocket<br>250RPM | T3<br>6Pockets<br>166-2/3RPM | T4<br>10Pockets<br>100RPM | T5<br>12Pockets<br>83-1/3RPM | 1000 CPM<br>3 Recirculations |
| 1.44:1                                             | 1.5:1                   | 1-2/3:1                      | 1.2:1                     | T5<br>15Pockets<br>66-2/3RPM |                              |
|                                                    |                         |                              | 1.5:1                     |                              |                              |
| T1<br>6Pocket<br>250RPM                            | T2<br>6Pocket<br>250RPM | T3<br>8Pockets<br>187-1/2RPM | T4<br>10Pockets<br>150RPM | T5<br>12Pockets<br>125RPM    | 1500 CPM<br>2 Recirculations |
| 1.44:1                                             | 1-1/3:1                 | 1-1/4:1                      | 1.2:1                     | T5<br>15Pockets<br>100RPM    |                              |
|                                                    |                         |                              | 1.5:1                     |                              |                              |

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Table 3

| D & I and extruded: 250CPM - 1500CPM CV infeed 5-turret (Gear driven) |                         |                          |                           |                           |                              |
|-----------------------------------------------------------------------|-------------------------|--------------------------|---------------------------|---------------------------|------------------------------|
| T1<br>1Pocket<br>250RPM                                               | T2<br>1Pocket<br>250RPM | T3<br>1Pockets<br>250RPM | T4<br>2Pockets<br>125RPM  | T5<br>2Pockets<br>125RPM  | 250 CPM<br>12 Recirculations |
| 1.44:1                                                                | 1:1                     | 2:1                      | 1:1                       |                           |                              |
| T1<br>2Pocket<br>250RPM                                               | T2<br>2Pocket<br>250RPM | T3<br>2Pockets<br>250RPM | T4<br>4Pockets<br>125RPM  | T5<br>4Pockets<br>125RPM  | 500 CPM<br>6 Recirculations  |
| 1.44:1                                                                | 1:1                     | 2:1                      | 1:1                       |                           |                              |
| T1<br>3Pocket<br>250RPM                                               | T2<br>3Pocket<br>250RPM | T3<br>3Pockets<br>250RPM | T4<br>6Pockets<br>125RPM  | T5<br>6Pockets<br>125RPM  | 750 CPM<br>4 Recirculations  |
| 1.44:1                                                                | 1:1                     | 2:1                      | 1:1                       |                           |                              |
| T1<br>4Pocket<br>250RPM                                               | T2<br>4Pocket<br>250RPM | T3<br>4Pockets<br>250RPM | T4<br>8Pockets<br>125RPM  | T5<br>8Pockets<br>125RPM  | 1000 CPM<br>3 Recirculations |
| 1.44:1                                                                | 1:1                     | 2:1                      | 1:1                       |                           |                              |
| T1<br>6Pocket<br>250RPM                                               | T2<br>6Pocket<br>250RPM | T3<br>6Pockets<br>250RPM | T4<br>12Pockets<br>125RPM | T5<br>12Pockets<br>125RPM | 1500 CPM<br>2 Recirculations |
| 1.44:1                                                                | 1:1                     | 2:1                      | 1:1                       |                           |                              |