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Fig.1.

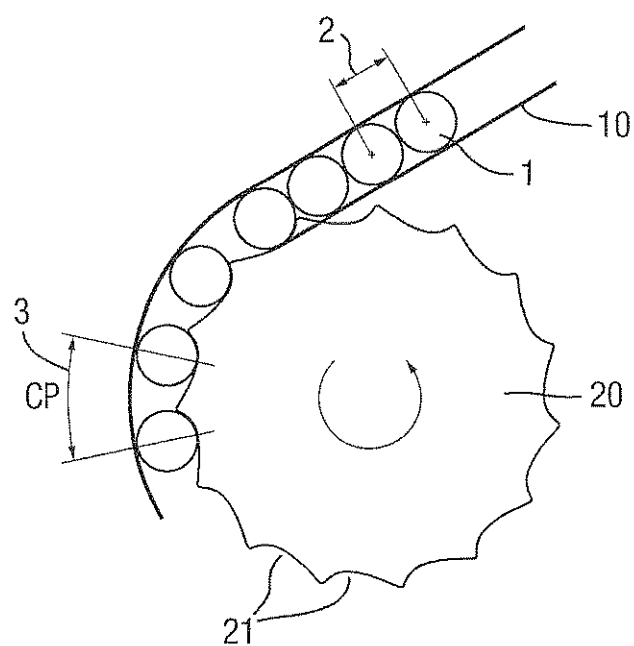
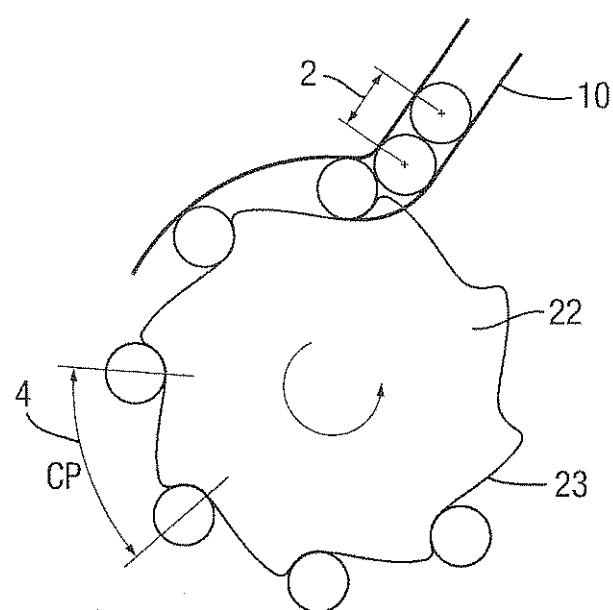


Fig.2.



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Fig.3a.

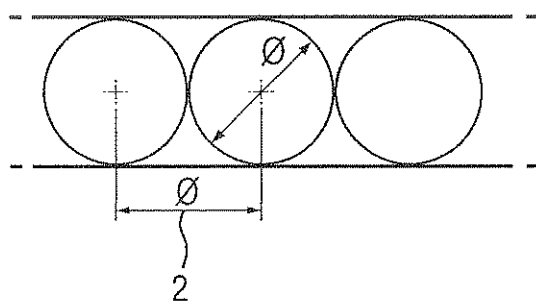


Fig.3b.

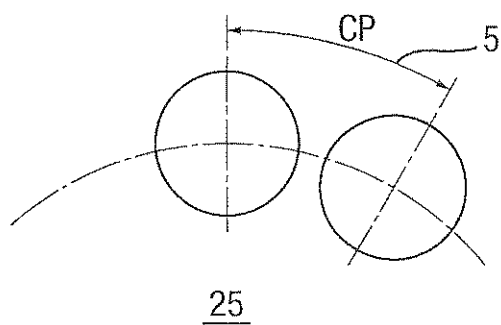


Fig.4a.

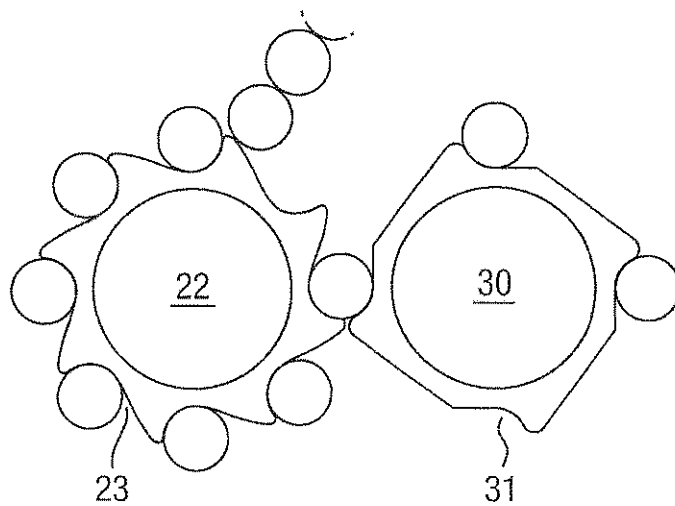
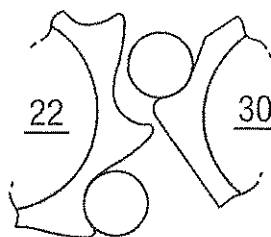
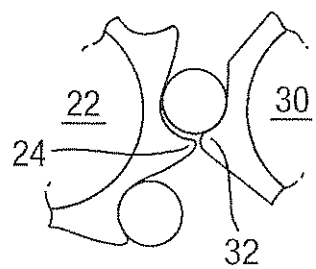
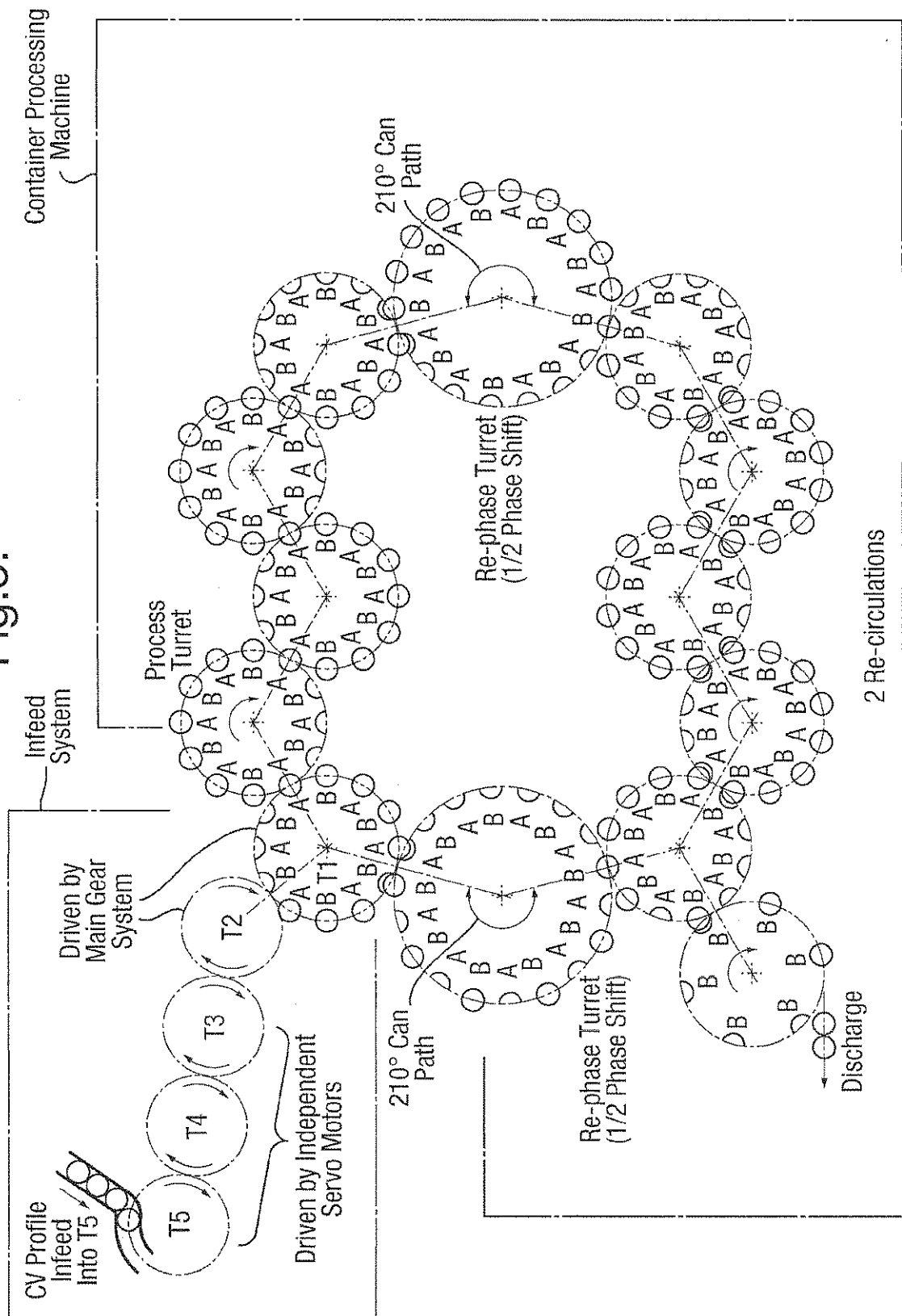


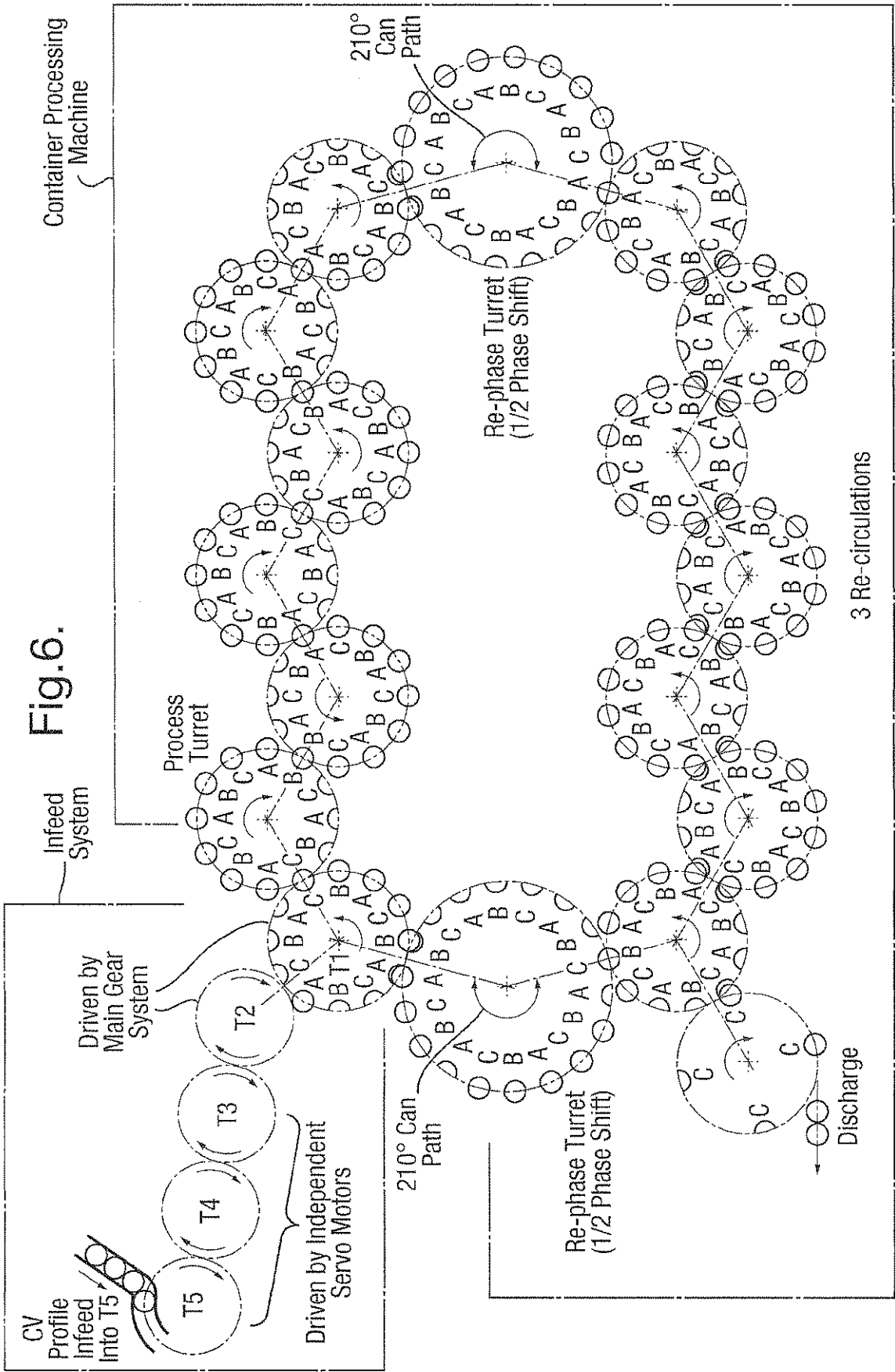
Fig.4b.



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Fig.5.





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Table 1

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

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Fig.7.

D & I: 500CPM - 1500CPM Tangential Infeed

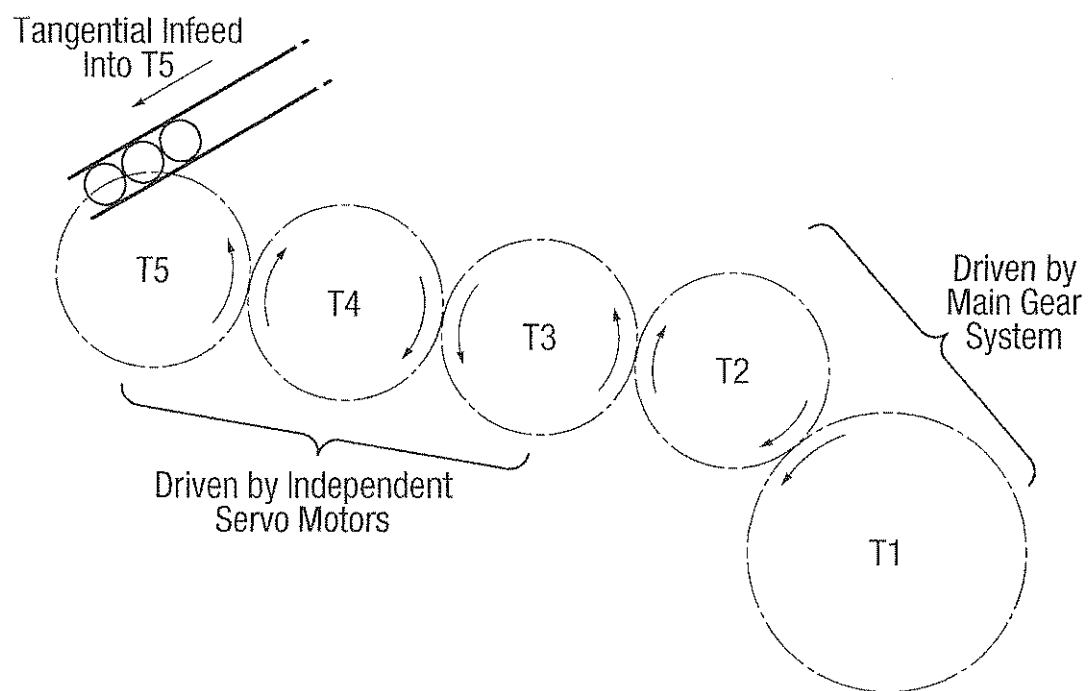


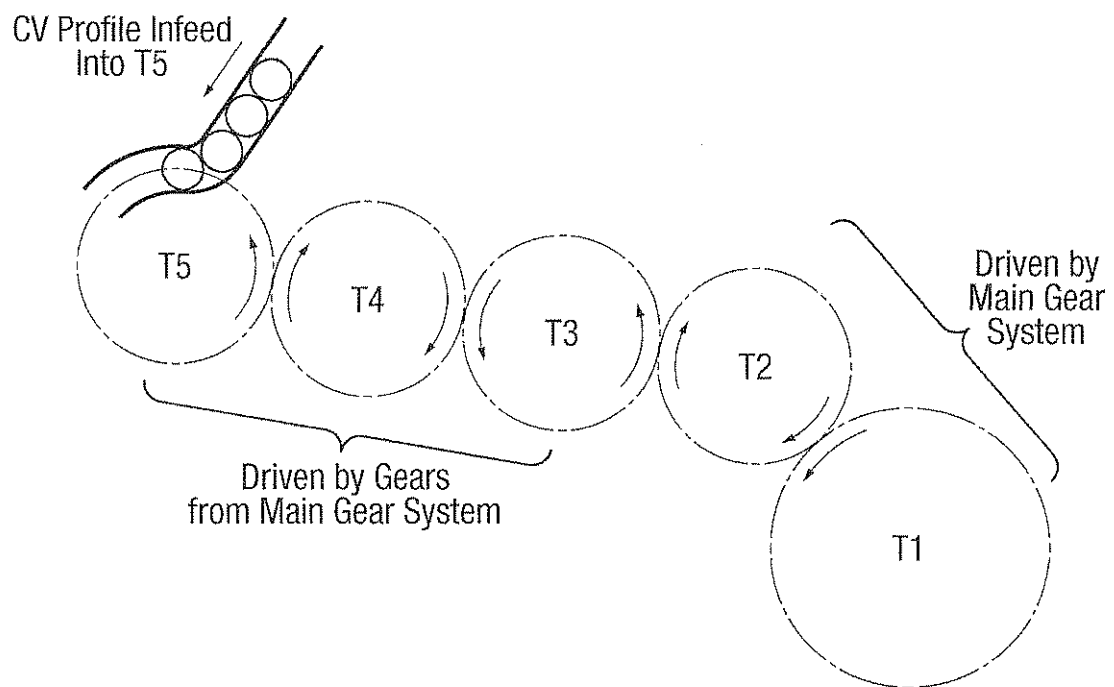
Table 2

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

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Fig.8.

Extruded and D & I: 250CPM CV Infeed



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Table 3

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