

Advancing Your Productivity? Here it comes! Your IEMCA BarFeeder.

Your IEMCA BarFeeder will arrive soon. Proper Shipping and Unloading Practices should be observed.

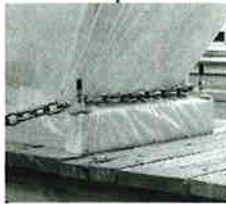
At Hydromat Inc. we take great care in ensuring your new IEMCA BarFeeder is transported in a safe and professional manner. Unfortunately, things can happen between the shipment and delivery day. The right time to discover any shipping damage is *before* signing for the machine. Your help with the receipt and inspection of the equipment, and prompt notification of any damage to IEMCA's Service Department, is critical to our ability to provide any assistance necessary. Please take a few minutes to acquaint yourself with the shipment and handling of our machines and ensure the personnel responsible for the receipt, handling, placement and initial preparation of the bar feeder are familiar with the contents of this package.

HOW YOUR BARFEEDER SHOULD ARRIVE.

UNWRAP THE BARFEEDER FOR A CLOSER LOOK



Your IEMCA Bar Feeder will arrive tarped and either strapped or chained on a flat bed air-ride truck. All drivers are instructed not to place any straps or chains across the top of the machine. In the event this has occurred, leave the load on the truck and do not allow the machine to be untarped until pictures can be obtained. To properly remove the machine from the trailer we recommend either an overhead crane or a medium to heavy duty fork truck. In the event that neither of these are available we strongly recommend the use of a rigging company to safely off load and position your machine. Please note these machines are very top heavy and extreme care should be exercised whenever they are being moved.



SELECT THE PROPER FORK LIFT FOR YOUR MACHINE.

BARFEEDER WEIGHTS

BOSS 332.....	3,000 lbs	TS-560.....	4,750 lbs
BOSS 547.....	3,000 lbs	VIP-70s/80.....	1,500 lbs
MICRO BOSS.....	1,700 lbs	MASTER 880.....	4,500 lbs
GENIUS 112/120...	3,000 lbs	PRA-40/52/100.....	4,000 lbs
TAL-65.....	4,500 lbs	SIR-25/32.....	5,000 lbs
		VacXtract.....	400 lbs

HOW YOUR IEMCA BARFEEDER IS WRAPPED.



Your bar feeder will be skidded (secured in 4 positions) and wrapped in layers of foam, bubble wrap and plastic. A separate accessories box will be located on the skid with the machine. Shipping documentation will be attached to the outside of the machines packaging.



Please read and follow these steps to insure a safe and trouble free IEMCA BarFeeder installation.

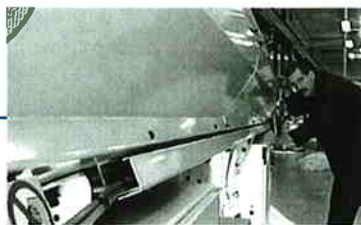
Unwrapping and inspecting the unit while it is still on the truck is the best way to identify any damage before unloading the machine and signing the bill of lading. It is very important that any damage is noted on the bill of lading and initialed by both you the receiver and the driver.

INSPECTION OF YOUR IEMCA BARFEEDER

UNWRAP THE BARFEEDER FOR A CLOSER LOOK



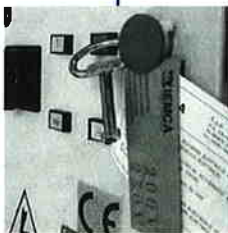
The safe transportation of your bar feeder is the responsibility of the carrier from our dock to yours. Unwrap the unit. Inspect the outside of the machine for cosmetic damage to the sheet metal and finish. Inspect the exterior services for physical integrity (i.e. all hoses and wires still attached).



INSPECT FOR INTERNAL DAMAGE



Your machine should arrive with the initial guide channel and bar pusher installed. Open the hood and visually inspect the interior of the magazine compartment. The key for the electrical and oil cabinets will be tie-wrapped to the front stand. Open both the electrical and oil cabinets and visually inspect for shipping damage.



UNLOADING

HOW TO UNLOAD YOUR BARFEEDER

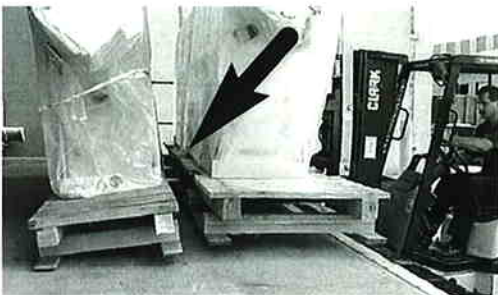
HOW TO UNLOAD USING A FORKLIFT.



When using a forklift be aware that most IEMCA Bar feeders are top heavy. Once removed from the truck they should be transported as far back on the forks and as low to the ground as possible. We always recommend the use of a spotter to assist the forklift operator. Position the truck forks as far apart as possible. Center the forklift on the machine skid and utilize the skids 4" x 4" beams to lift the machine.

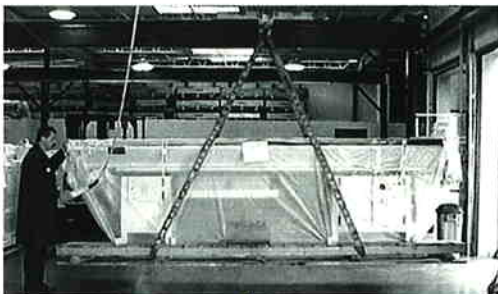


ALWAYS USE A SPOTTER.



There may be more than one machine on the truck bed. In some cases these machines may be located side by side on the truck bed. The bar feeder skids are narrow and it is easy to extend the forks too far through the machine you are lifting. This could cause the machine behind it to tip over. If possible when machines are located side by side on the truck bed, move the machine skid with a pallet mule to create space between the skids.

HOW TO UNLOAD USING A CRANE.



There are two ways the machine may be unloaded utilizing a crane. The first method is by using straps through the machine pallet. When using straps ensure that the straps are fed through the pallet below the machines oil and electrical cabinets. The second method utilizes the machines installed eyebolts. To access the eyebolts the machine must be unwrapped and the magazine hood opened. In either case when lifted with a crane the machine will tilt slightly towards its backside, this is normal.

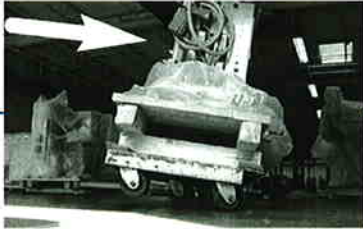
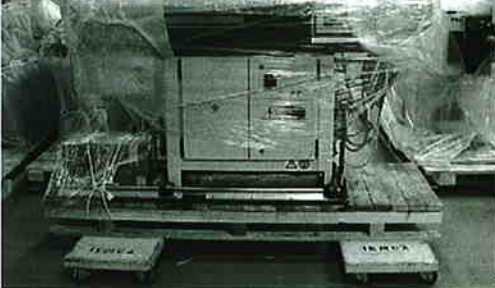


POSITIONING

HOW TO POSITION YOUR BARFEEDER

MOVING THE BARFEEDER INTO POSITION

The bar feeder may be transported through your facility utilizing an overhead crane or forklift as discussed earlier or by using industrial grade 3000 lb capacity dollies. Dollies of inadequate size may cause barfeeder to tip over.



LIFT PROCEDURES FOR FORKLIFTS AND CRANES.

To remove the bar feeder from its skid and if not previously accomplished, completely unwrap the machine and open the magazine hood. The eyebolts located in the magazine must be accessed to lift the machine from the skid. Attach lifting straps securely to the eyebolts. Using either an overhead crane or forklift put tension on the lifting straps but do not lift. Remove the skid - machine tie bolts then remove the machine from the skid and place the bar feeder on the load side of the machine tool. Once the bar feeder is in place, remove the eyebolts and keep for later use. If possible, place the bar feeder on four 4" x 4" blocks of wood. This will assist the service technician with the set-up and installation of your bar feeder. (Note: Machines that come installed with an Axial Track are to be placed directly on the floor.)



THE ACCESSORIES BOX SHOULD REMAIN CLOSED.

The accessories box(s) should be removed from the machine skid and placed with the bar feeder. The accessory box is sealed at the factory and we kindly request that it remains so until the service technician arrives to install your bar feeder. The service technician on arrival will open and inventory the contents of the box in accordance with the bill of materials for your machine.



PRE-INSTALLATION CHECKLIST

Below we have enclosed a list of items necessary for the successful and complete installation of your bar feeder.

FINAL PREPARATION BEFORE ARRANGING INSTALL

These items are necessary to install the bar feeder, run-off your stock at machining RPM and provide adequate and thorough training for your associates. Please take the time to complete the checklist provided.

- Electrical power and air supply to the machine tool complete.
- Machine tool (lathe) leveled.
- Bar feeder located at the lathe and removed from the shipping skid.
- Bar stock available for run-off. Bar straightness within .007" per foot.
- Machine tool cutting tools available for run-off.
- Interface for the bar feeder included with the machine tool.
- Test program for bar feeder run-off installed in the machine tool.
- Hydraulic oil available for the bar feeder.

OIL REQUIREMENTS

MULTI-SPINDLE

MODEL	LUBE OIL	QUANTITY	HYDRAULIC OIL	QUANTITY
SIR 32	CB-100	50 Gallons	HG-32	20 Gallons

SINGLE-SPINDLE

MODEL	LUBE OIL	QUANTITY
Genius 112	CB-32	15 Gallons
Genius 120	CB-64	15 Gallons
MINI BOSS 332	CB-100	20 Gallons
BOSS 545/547	CB-150	20 Gallons
MICRO BOSS	CB-150	5 Gallons
Master 880 P/F	CB-150	25 Gallons
Master 880 MP	CB-150	25 Gallons
TAL 65	CB-150	25 Gallons
TS 560	CB-150	15 Gallons

Your bar feeder will require ISO specification hydraulic oil for its lubrication system. This table lists the requirements for your machine.

We will be contacting you in the next few days to coordinate the specifics of your installation.

If you have any questions or concerns, Please call our service department at

763-476-4191

Customer Signature

Date