

BOELTER INDUSTRIES 122809-8 SERVO DRIVEN CANTILEVER PRESS LINE

eCantilever Press Line Specifications:

Maximum Web width:	34 inches
Maximum Printing Width:	32 inches
Colors:	Eight Colors in 4-frames
Configuration:	Cantilever Sleeve System
Print Station Power:	Servo Direct Drive
Rated Maximum Speed:	500 fpm (see note "a")
Rated Registration:	±0.005"
Paper Substrates:	12 to 24 Pt Board
Plate Cylinder Repeat Range:	12 to 28 inches Sleeve System
Anilox Roller Specifications:	Eight Sleeves Engraved Up To 400 Lines
Plate Cylinder Specifications:	Eight Sleeves Included, (Customer Specified)

Dryer Specifications:

Drying:	Tower One: Three Systems of IR, Air Knives, Exhaust
	Tower Two: Three Systems of IR, Air Knives, Exhaust
	Tower Three: Three Systems of IR, Air Knives, Exhaust
	Tower Four: Three Systems of IR, Air Knives, Exhaust

Note a: Printing speeds up to 500 fpm can be achieved on varied substrates depending on ink coverage, paper, printing plate layout, dryers, and type of ink.

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Press Specifications

1. All rollers are statically and dynamically balanced.
2. Idler rollers are mounted on dead shafts with pre-lubricated ball bearings.
3. Idlers are used in critical areas to reduce wrinkling of substrate.
4. The anilox roller is directly driven with a servo for accurate control.
5. The plate cylinder is directly driven with a servo for accurate register control.
6. The plate cylinder is cantilever in design to allow for quick printing sleeve change over.
7. Anilox rollers are ceramic coated and laser engraved to customer specification.
8. One base plate cylinder is supplied with each print station and designed to accept sleeve system.
9. Plate cylinder to anilox roller adjustment is through the touch screen.
10. Electronic side lay operating switches on the main control panel provide for lateral registration adjustment of the printing stations.
11. A pneumatically controlled and adjusted enclosed fountain/doctor blade system is included with each print station. The system pivots on three inch structural tubing mounted directly in the frames for stability at high speeds.
12. Impression cylinders are hard chrome plated and mounted on eccentric assemblies for on/off operation.
13. Each station is equipped with Register correction through 360-degree rotation of a plate cylinder. The cylinders are rotated electronically through the touch screen located in the main control panel.

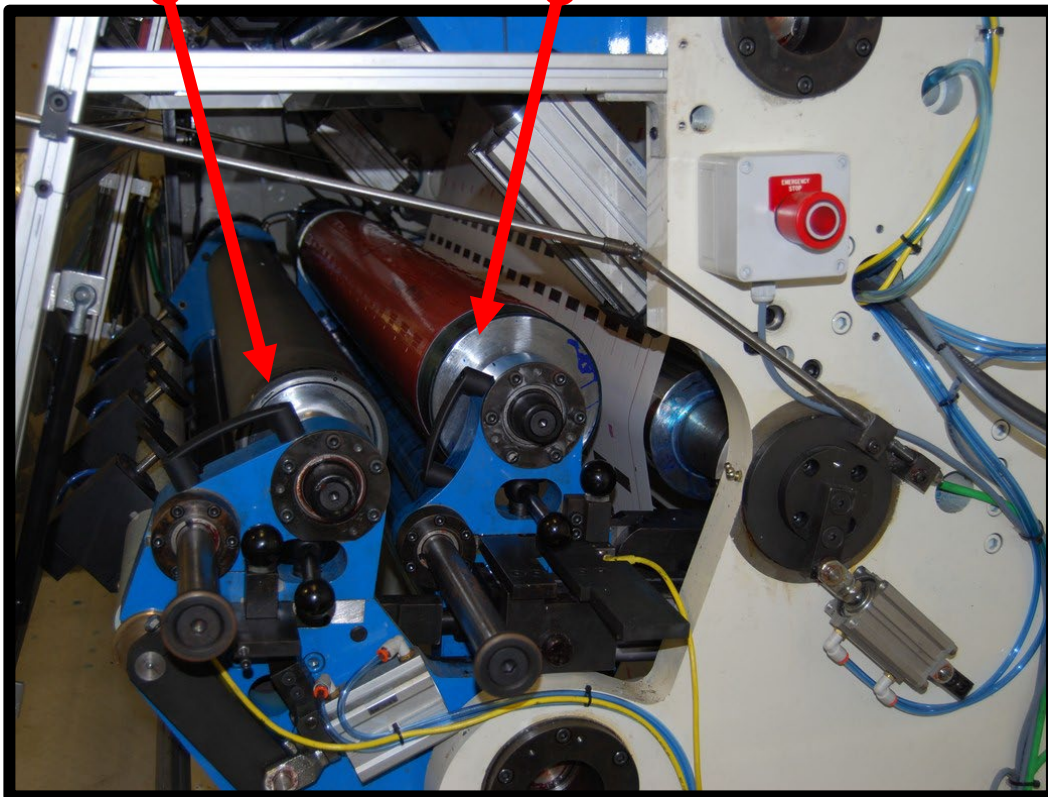


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Cantilever Anilox and Plate Cylinder

Anilox Roller

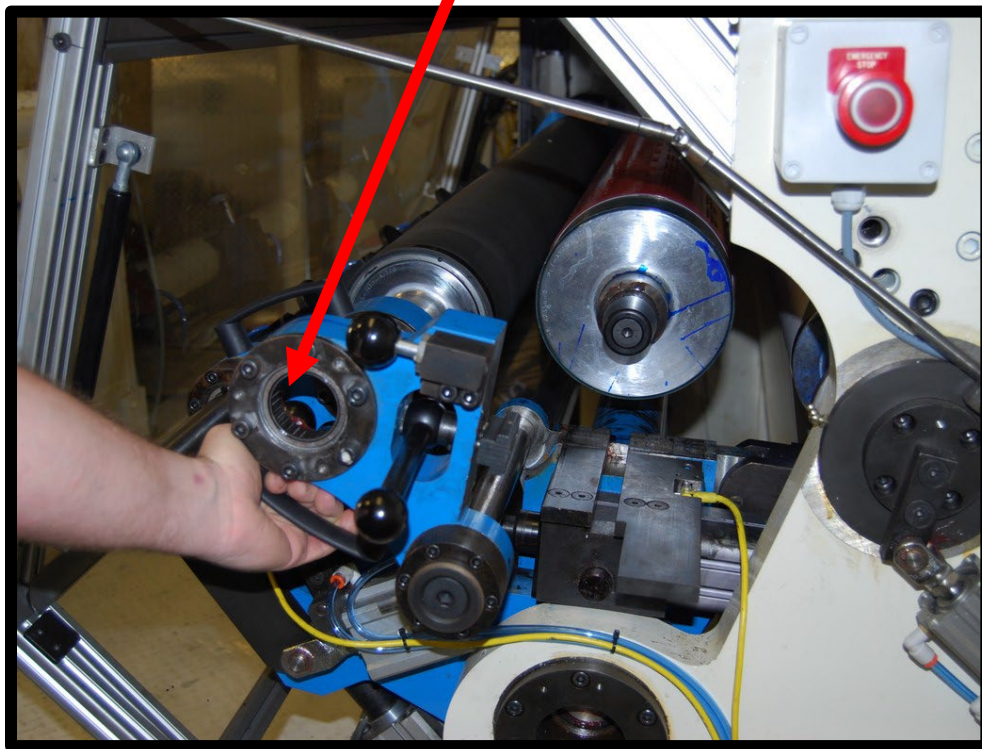
Plate Cylinder



Cantilever Plate and Anilox roller system allows for rapid changing of the respective sleeves. Above picture shows the anilox and plate sleeve installed and the deck in run position ready to print.

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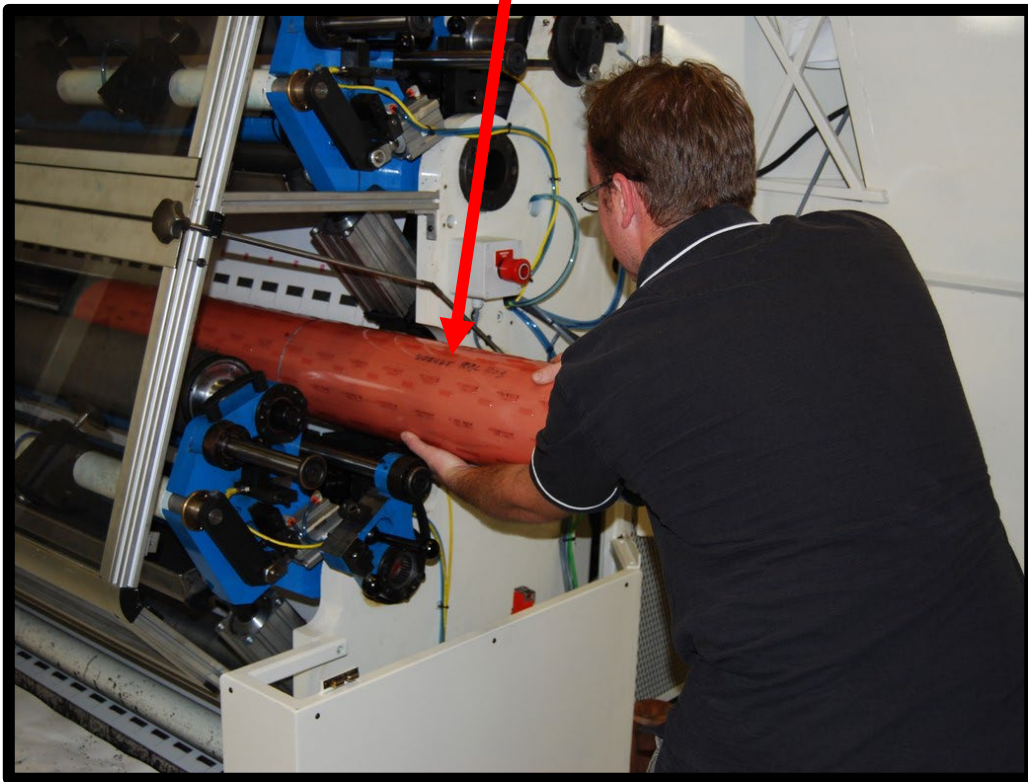
Quick Release Carriage



Releasing the carriage blocks in open configuration allows access to the plate and anilox mandrel for sleeve insertion.

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Plate Cylinder Sleeve



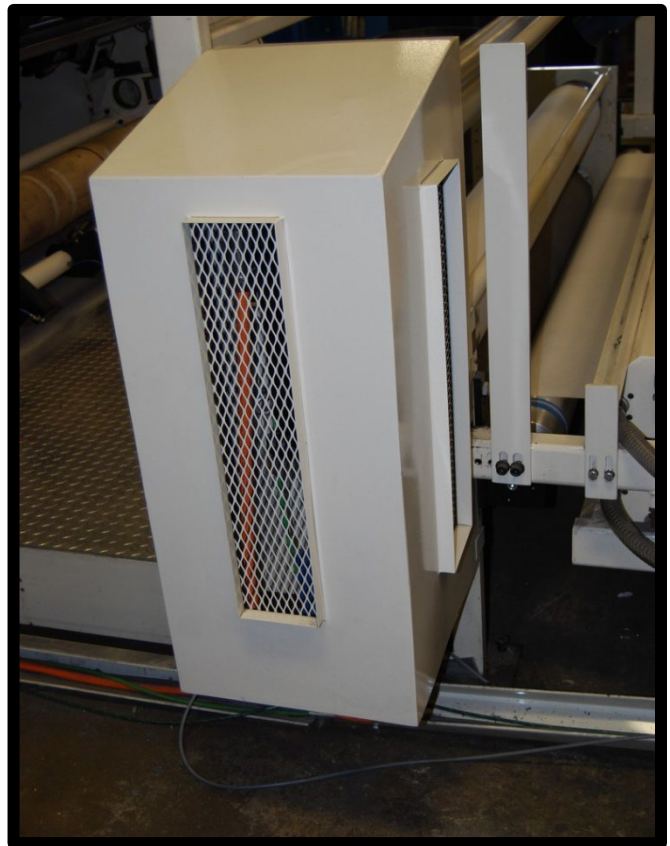
The plate cylinder repeat can be changed via the sleeve system. The customer can purchase different repeat sleeves for the job requirement. There is NO need for stocking expensive cylinders for different job requirements. Touch a button and remove the sleeve.

The same applies to the anilox roller. With a touch of a button the anilox roller sleeve can slide off for rapid changing.

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Infeed System

1. The in feed system isolates the web from undesirable fluctuations induced by stock roll deficiencies and the mechanical action of the dancer roll and other tension control mechanisms.
2. The web is fed into the press at optimum speed through a nip roller arrangement consisting of twin plasma coated roller and pneumatically operated rubber covered contact roller. A motor drives the system.



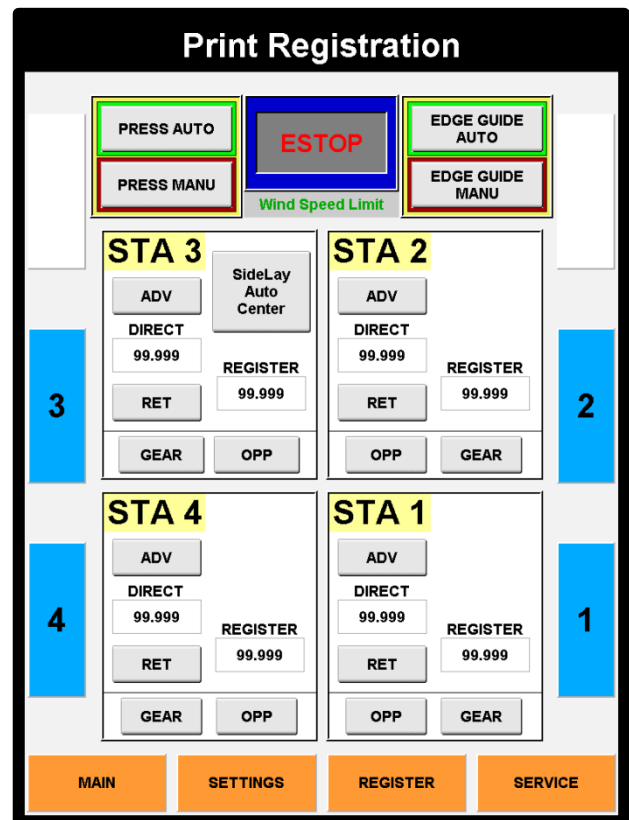
Chill Roller Exit Feed Section

1. Two 30 inch in circumference twin wall chill rollers will aid in normalizing the web temperature.
2. The rollers are hard chromes plated.
3. The two rollers are mounted in two inch thick frames for stability.
4. The rollers come supplied with one rotary union per roller.
5. One chill roller is driven by a motor through a gear box.

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Registration Adjustment System

1. The system allows for independent 360 degree circumferential adjustment of each print station.
2. Side lay movement is controlled from the registration screen on the touch panel.
3. Direct Register allows the operator to specific move amounts in inches or millimeters directly into the register control from the touch screen. This allows the press operator to move the press register in the same units he thinks in. He can take a sample and measure the error then enter the exact amount while the press is in idle mode. This equates to a reduction in wasted material.



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Touch Screen

Touch screen panels are located at the rewind and each tower to control the:

1. Plate to anilox roller adjustment with the ability to change each side independently or at the same time. A digital readout per station allows the operator to see the amount of linear squish he is applying.
2. Side lay position and control.
3. Line speed, acceleration settings, deceleration settings, roll stop and process counter settings.
4. Unwind tension settings and core size settings are controllable and settable from the panels. Core size settings, in 1/10 inch increments, relate to the auto roll stop system in the unwind stand.
5. Print station status. This includes is the station in print mode, clean up mode, and is the station turned off.
6. Dryer IR ramp (amount of time until maximum voltage is reached), IR ramp start point in FPM, IR maximum voltage.
7. All settings added to optional job memory.
8. Register control settings and status is added to the touch screen.
9. Manual 360 degree circumferential register can be performed from the control panel or the touch screen.



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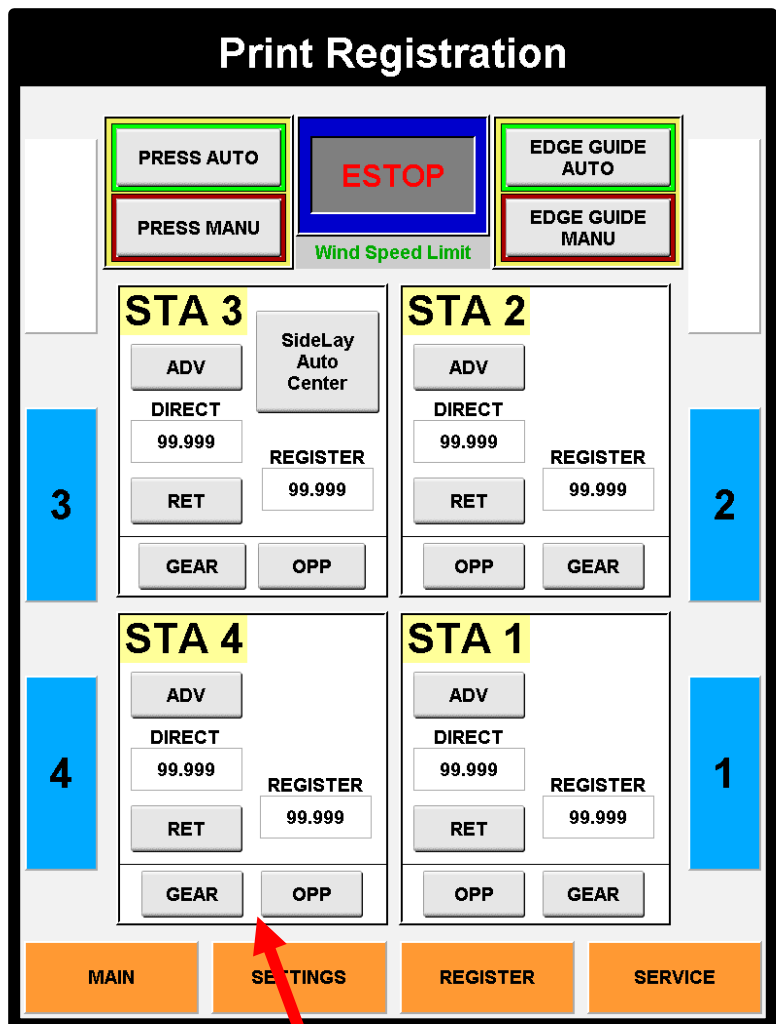
Press Line Pre-Setting System

1. The system will upgrade the servo motors and drive controls to allow for the accuracy required to control the individual print stations.
2. When incorporated with pin mount sleeves or a manual pointing device the pre-setting system monitors each print stations relationship to each other and presets the stations to proper registration based on web path and cylinder size.
3. Automatic presetting will restore a station that has been turned off for cleaning to register once turned back on. This feature can be used without stopping the press line.
4. The presetting system will automatically re-register a job that was previously running even after the press is powered off. No operator input is required.
5. Many types of RG stations can be included in the presetting system including numbering, sheeting, window patching machines, and external encoder outputs for third party equipment like video systems.
6. If the job memory option is purchased the press can be set by the repeat size or a specific stored job number.

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Electronic Sidelay

1. Electronic side lay operating switches on the main control panel provide for lateral registration adjustment of the printing stations.
2. Left to right movement of $\pm 1/4"$ is possible.
3. Stations can be moved individually.
4. Each switch will illuminate when the limit of travel for that printing station has been reached.
5. All stations are returned to the center position through a single push button control.



Side Lay Controls

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Electronic Plate to Anilox Automation

1. Motors control the plate to anilox adjustment.
2. Two control panels allow the operator to adjust print quality.
3. The system will allow for quick plate cylinder changing.
4. The operator can adjust both sides of either cylinder simultaneously or choose to skew the cylinder to obtain the desired print quality.

Electronic Impression to Plate Automation

1. Motors control the plate to impression adjustment.
2. Two control panels allow the operator to adjust print quality.
3. The operator can adjust both sides of either cylinder simultaneously or choose to skew the cylinder to obtain the desired print quality.

Plate Automation - Station 1

PLATE SETUP OPEN CLOSE Opp Pres: 299 psi Gear Pres: 299 psi Auto Support Leveling		PLATE SETUP IN OUT Position: -2000
ANILOX SETUP		
OPP SIDE IN OUT Position: -2999999	DUAL IN OUT Position: -1999999	GEAR SIDE IN OUT Position: -1999999
DISABLE MOTORS	Plate Air	Anilox Air
MAIN SETTINGS REGISTER SERVICE		

1, 2, 3, 4

Touch Screen Controlled

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Automatic Cleaning Peristaltic Supply Pump



1. The automatic cleaning pump utilizes two peristaltic pumping units.
2. Each pump has a function, one feeds glue while the other creates suction returning the glue to the pale or drum.
3. The pump/cleaning system is controlled by a computer allowing timed events to take place.



Engineering Inc.

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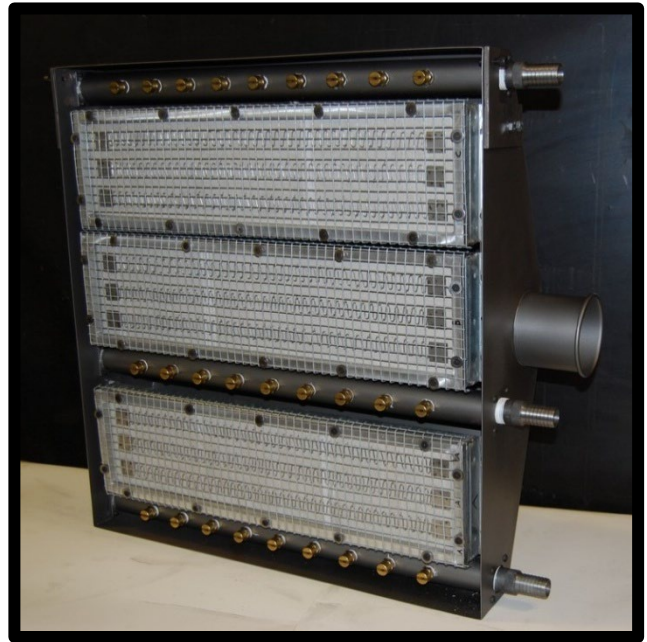
Automatic Cleaning Peristaltic Supply Pump Cont.

4. The pumping/cleaning system goes through a sequence of events to accomplish supplying or clean up. Below is the list of timed events:
5. At the start up of the day the operator will engage the cavity, start the anilox roller rotating, and then press the start button on the pump stand.
6. The pump will start pumping glue thru the feed lines into the cavity. During this process there can be residual cleaning fluid left in the lines so the initial fluid feed through the lines will be sent to the drain. Minimal amount of glue will be lost.
7. The pump stand will change the flow arrangement and pump the ink to the storage container.
8. At the end of the day the operator places the press into idle mode and presses the clean button.
9. The glue pumping system changes the feed line into a return and sucks all the ink left in the cavity out returning it to the storage container. This eliminates wasting your valuable glue left in the system. This can save up to five gallons of glue from being wasted.
10. The glue pumping system changes over to clean mode and pumps water from the built in storage tank through the return lines (highest point on the cavity) into the cavity while sucking the fluid out of the feed line (lowest point on the cavity). This waste fluid is pumped to a drain or storage tank.
11. If the operator requires an extended clean cycle he holds the clean button for a count of five and the clean cycle is doubled.

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High Output IR Dryer

1. The dryer system employs air knives powered by a dedicated blower. The air knives are positioned to provide an air curtain upon entering the dryer cabinet to shear the ink vapor ahead of the infrared unit and upon exiting the cabinet to facilitate final cure.
2. An electronic control card ramps the infrared units up and down based on web speed. The control card provides an adjustment range adequate to provide drying of medium to heavy print formats without damaging substrate.
3. An exhaust blower is used to rapidly evacuate ink vapors and latent heat within the system.
4. The installation of multiple systems permits drying of any print combination.
5. The main controls are designed to allow for system expansion.
6. Air supply is an integral part of the unit and no additional source is required. The volumetric flow and velocity within the plenum and from the air knife assemblies is engineered according to the specific application.



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Press Line Pricing

ITEM	QTY	Cantilever Line	UNIT	TOTAL
1	1	Infeed System	\$60,000.00	\$60,000.00
2	8	Print Stations	\$60,000.00	\$480,000.00
3	8	Cantilever Anilox Roller	\$10,000.00	\$80,000.00
4	8	Cantilever Plate Cylinder	\$10,000.00	\$80,000.00
5	8	Plate To Anilox	\$7,500.00	\$60,000.00
6	8	Servo Sidelay	\$12,500.00	\$100,000.00
7	8	Automated Peristaltic Pump	\$9,500.00	\$76,000.00
8	8	Pre-Setting	\$6,000.00	\$48,000.00
9	1	Job Memory	\$4,000.00	\$4,000.00
10	1	Third Party Video Output	\$4,000.00	\$4,000.00
11	4	Print Tower Dryer	\$28,000.00	\$112,000.00
12	8	Bridge Dryer	\$20,000.00	\$160,000.00
13	1	Exit Feed	\$60,000.00	\$60,000.00
14	2	Metering Station Drive	\$25,000.00	\$50,000.00
15	1	Engineering For 12" Repeat	\$45,000.00	N.C.
16	1	Locked in Installation	\$55,000.00	N.C.
17	1	Press Lighting	\$8,000.00	\$8,000.00
			TOTAL	\$1,382,000.00
			Discount 5%	(\$69,100.00)
				\$1,312,900.00



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DELIVERY:	Seven Months Based On Deposit
FOB:	Virginia Beach
INSTALLATION:	Two men Three weeks
RECOMMENDED TRAINING:	One, eight-hour day per work shift.
TERMS:	30% down with purchase order
	30% 60 days from down payment
	30% 120 days from down payment
	5% prior to shipment
	5% net 30 days from shipment

Service Rates

REGULAR TIME -----	\$105.00/hr.
WEEKENDS/HOLIDAYS -----	\$130.00/hr.
MODEM HOURLY RATE (one hour minimum) -----	\$ 65.00/hr.
TRAVEL TIME -----	\$ 50.00/hr.
PER DIEM -----	\$ 60.00/day
COMPANY VEHICLE USAGE -----	\$ 60.00/day
GAS AND TOLLS , HOTELS, TRANSPORTATION, RENTAL CAR AND ALL OTHER EXPENSES-----	A Service Fee Will Be Added To The Cost



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Shipping: RG Engineering is not responsible for shipping or shippers insurance. We will recommend trucking companies that we have used in the past that pass our requirements or we can review recommended trucking firms.

Fork Trucks and Loading Equipment: Customer is responsible for supplying the required fork trucks and any loading equipment. RG Engineering will recommend the fork truck size.

Equipment unloading and placement: RG Engineering cannot operate fork trucks or heavy equipment at the customer site.

Anchoring of Equipment: Customer is responsible for anchoring of the complete line. RG Engineering technicians will align and level the Line and relay to Customer the size and where the anchors are needed.

Air Supply: The Line has several air drop locations that will be defined in the layout drawings. RG Engineering will detail the amount and CFM of the supplied air. Customer is responsible the running of air line to the supplied interface points on the equipment.

Main Power Supply: The Line has several power drop locations that will be defined in the layout drawings. RG Engineering will detail the amount and voltage and amperage of the supplied power. Customer is responsible the running of main power lines to the supplied interface points on the equipment. The Line may require 240 and 480 volt supply. Internal 110 and 24 volt power will be supplied by RG Engineering.

Isolation Transformer: The press line will require an isolation transformer. RG Engineering will size the transformer and can add the transformer purchase price to the final Line price. Customer or its contractors will be responsible for installation and interface to the line.

Fresh Water Supply: Customer is responsible for supplying the fresh water and a drain line from the automated pumping systems. RG Engineering is responsible for feed and return lines from RG Engineering manufactured pumping systems.

Concrete or Factory Floor Modifications: Customer is responsible.

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Terms and Conditions of Sale

1. Price Quotation. The price quotation is F.O.B. Virginia Beach, Virginia. It does not include the cost of insurance and freight to Buyer's destination, and does not include any local, state, or federal taxes. Buyer shall pay such taxes when billed by seller.

2. Confidentiality. Buyer shall not disclose to third parties any drawing, specifications, estimates, price quotations, or any other documentation regarding the goods. These materials are Copyrighted in the year of issuance by Seller.

3. Goods. The goods to be sold by Seller to Buyer are described in Boelter Industries 122809-8, which is expressly made a part of these Terms and Conditions.

4. Acceptance. Seller shall notify Buyer, in good time, of the readiness of the goods for testing at Seller's premises. At a mutually convenient time, which shall, in any event, be not later than seven (7) business days from the date of such notification, Buyer shall send its representative(s) to Seller's facilities in Virginia Beach, Virginia, to conduct and perform all desired and appropriate tests on the goods. Buyer shall, at its sole expense, supply and provide all necessary materials for conducting such tests, including, but not limited to, plates, paper stock and ink. The goods shall be deemed accepted upon the successful completion of such tests and Buyer shall execute an acknowledgement of acceptance at such time.

5. Delivery. Upon receipt of Buyer's order, a copy of these terms and conditions signed by an authorized representative of Buyer acknowledging Buyer's acceptance hereof and the down payment called for in Seller's Confirmation of Order, Seller will quote an estimated shipment date.

Seller's delivery period commences upon issuance of its Confirmation of Order. The delivery period shall be extended if Buyer makes any change in its order after issuance of Seller's Confirmation of Order and no change order shall be accepted unless it expressly authorizes an extension of the time in which delivery may be made.

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Delivery shall be deemed to occur when Seller places the goods in the possession of a carrier for shipment to Buyer or when Seller notifies Buyer of Seller's readiness to ship, whichever occurs first. Delivery of the goods shall be F.O.B. Virginia Beach, Virginia. Buyer shall select the carrier to be used and bear all costs of shipment from Virginia Beach, Virginia, to Buyer's chosen destination. Buyer shall indemnify and hold Seller harmless for all costs and expenses incurred in connection with the delivery of goods hereunder. Partial delivery is permissible.

Seller shall not be obligated to deliver goods to Buyer, incident to this transaction, unless and until all payments required to be made by Buyer prior to delivery have been made, or if Buyer is or is about to become insolvent, files, or has filed against it, a petition in bankruptcy, makes an assignment for the benefit of creditors, ceases payment to creditors, or proposes to creditors a moratorium or rescheduling of debts.

6. Risk of Loss. Risk of Loss shall pass to Buyer upon delivery as set forth in Section 5.

7. Payment. Payment shall be made in accordance with the terms of Seller's Confirmation of Order, which is expressly made a part of these terms and conditions. Buyer shall not set off against the purchase price any disputed claim against Seller which has not been established by a court of competent jurisdiction.

8. Warranty. Seller warrants that all goods, except those parts manufactured by others, shall be free from defects for a period of 12 months from the date of delivery. Seller warrants that any replacement part(s), except those manufactured by others, shall be free from defects for a period of 3 months from the date of its(their) installation or the expiration of the original twelve-month warranty period, whichever is greater. Seller's liability hereunder is limited solely to the cost of the replacement parts. Buyer shall pay for any labor or transportation charges incurred in connection with repairing or replacing defective parts. Notwithstanding anything contained herein to the contrary, this warranty shall not be honored unless Seller receives written notification of a warranty claim from Buyer within the warranty period. THE FOREGOING IS IN LIEU OF ALL OTHER WARRANTIES AND LIABILITIES, WHETHER STATUTORY OR ARISING UNDER COMMON LAW, EXPRESS OR IMPLIED, INCLUDING, BUT

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NOT LIMITED TO, WARRANTIES OF MERCHANTABILITY, FITNESS FOR A PARTICULAR PURPOSE, AND WORKMANLIKE SERVICE. SELLER DOES NOT MAKE ANY WARRANTY, OR ACCEPT ANY LIABILITY, REGARDING ANY PARTS MANUFACTURED BY OTHERS. However, Buyer shall have the benefit of any warranty made or offered by such other manufacturers; to the extent that Seller may transfer them to Buyer.

9. Special Disclaimer. Seller includes, in all goods it manufactures, numerous safety features and devices and offers and provides training on the safe operation of such goods. Seller shall not be liable for any damages or claims whatsoever, including liability for personal injury or property damage arising out of the operation, storage or transportation of the goods if Buyer (i) removes or in any way modifies safety devices or warning labels supplied with or as part of the goods; or (ii) fails to operate the goods in accordance with the instructions and training offered and provided by Seller.

10. Incidental and Consequential Damages. Seller shall not be liable to Buyer, directly or indirectly, for incidental or consequential damages of any kind or description, including, but not limited to, for delay, down time, loss of use, loss of revenue or profit, personal injury, death or property damage.

11. Additional Parts. Orders placed by Buyer with Seller, subsequent to the date of acceptance of these Terms and Conditions, for additional or replacement parts or components shall be subject to these Terms and Conditions. Additional parts and components will be manufactured as accurately as possible; however, SELLER CANNOT AND DOES NOT MAKE ANY WARRANTY OR GUARANTEE THAT THE ADDITIONAL PARTS OR COMPONENTS WILL FIT WITHOUT ADDITIONAL WORK. Unless the entire machine is returned to Seller for fitting of the additional parts or components, any expense incurred in fitting the parts shall be borne by Buyer.

12. Default. The goods which are the subject of this transaction are to be specially manufactured by Seller for Buyer. Should Buyer breach any of these Terms and Conditions or fail to make any payment in accordance with the terms of the Seller's Confirmation of Order, it shall be deemed to be in default. In such event, Seller may, at its sole option and discretion, identify the goods to this

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contract and declare immediately due and payable any unpaid balance of the purchase price for the goods, even if not then completed or ready for delivery. If Buyer becomes insolvent, files, or has filed against it, a petition in bankruptcy, makes an assignment for the benefit of creditors, ceases payment to creditors, or proposes to creditors a moratorium or rescheduling of debts, the unpaid balance of the purchase price shall automatically become immediately due and payable without resort to any action on the part of the Seller and notwithstanding any notice requirements of these Terms and Conditions or Seller's Confirmation of Order. All payments which are made when due shall be subject to a service charge of 1.5% per month (18% APR). Buyer shall pay all court cost of collection, including a reasonable attorney's fee, if incurred.

13. Applicable Law and Selection of Forum. These Terms and Conditions shall be construed according to the laws of the Commonwealth of Virginia, without regard to conflicts of laws principles. Jurisdiction to hear and decide any action at law or suit in equity arising out of or pertaining to this transaction shall be proper only in the Circuit Court for the City of Virginia Beach, Virginia, or the United States District Court for the Eastern District of Virginia, Norfolk Division. In the event of any litigation filed in connection with or arising out of the sale of goods by Seller to Buyer, the party substantially prevailing shall be entitled to recover from the other party all of its reasonable attorneys' fees and expenses.

14. Excuse For Nonperformance or Delay. Seller shall not be responsible for any delay or failure to make delivery of all or any part of the goods due to federal, state, or local actions, regulations or laws; strikes or other labor troubles; fire, storms or Acts of God; inability to obtain parts or components manufactured by third parties, raw materials, labor, or supplies; or any other circumstance beyond Seller's control which prevents, hinders or makes commercially impracticable Seller's performance under these Terms and Conditions and Seller's Confirmation of Order.

15. Security Agreement. Buyer grants and conveys unto Seller a Security Interest in the goods until the purchase price has been fully paid and authorizes Seller to make and execute all documents and instruments necessary to perfect the same. If requested by Seller, Buyer shall execute all documents necessary to timely perfect said Interest. Buyer shall, at the time of execution of



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these Terms and Conditions, and simultaneously with the delivery hereof to Seller, inform Seller of the state under the laws of which it was organized and the organization or identification number assigned to it by that state.

16. Notices. Any notices required or desired to be given in connection herewith shall be sent as follows:

If to Seller:

Robert Galyon, President
RG Engineering, Inc.
505 London Bridge Road, Unit 101
Virginia Beach, VA 23454
Fax Number: 757-463-5507

If to Buyer:



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17. Entire Agreement. These Terms and Conditions and Seller's Confirmation of Order represent the entire agreement between the parties and control over any inconsistencies with Buyer's Purchase Order. Buyer's Terms and Conditions are not a part of this contract.

No modification of these Terms and Conditions or Seller's Confirmation of Order shall be valid and effective unless in writing and signed by all parties to this transaction. The invalidity of one provision shall not affect the validity of the remaining provisions.

Made and executed this ____ day of _____, 20__.

SELLER:	BUYER:
R G Engineering, Inc.	
By: _____ Robert Galyon, President	By: _____