

Community Playthings
Ernie Hofer
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New York, 12487 USA

Offer No.: 16171D
Project: Flow Coat

Rheda-Wiedenbrück: 03.09.2015
Your contact: Andrew Scott
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Dear Ernie,

as recently discussed and according to your mails from the last week. of August we are pleased to send the updated quotation for a staining line with a flowcoater. We have added 2 additional variants please refer to the drawing A-16171C as per your request.

Short or difficult pieces have to be loaded in a wire basket to pass the line.

Capacity calculation:

Overall production per week according last Excel sheet:	6.300 pieces
Total amount of meter per week:	3.650 m (12000 ft)
Average length:	590 mm (1 ft 11 inch)
Average width:	100 mm (4 inch)
Batch length:	max.4200 mm (14 ft)
Batch width:	305 mm (12 inch)
Pieces per batch:	ca. 10
Batches/min	0,4
Needed line speed:	2,0 m/min
Add.capacity 50%	3,0 m/min
Needed drying time (100°F=38°C):	2 min
Length of dryer	3 m
Available drying time	3 – 4 min

We hope this offer will find your attention and remain

with kind regards

VENJAKOB Maschinenbau

GmbH & Co. KG

Our offer is based on the following line parameters:

Operating width:	310 mm
Production speed:	7,5 m/min
Speed range:	2 - 10 m/min.
Operating level:	940+-20 mm
Components to be finished:	wood elements
Panel size	L x W x H
min.:	300 x 30 x 10 mm
max.:	1510 x 305 x 50 mm

small parts have to be transported in a wire basket
The wire baskets has to be made by the customer.

One sample of this basket will be delivered with the line.

coating material:	water based stain
Supply voltage:	110/460 V 60 Hz TNC
Voltage fluctuation max.:	+/- 5%
Control voltage:	24 V
Ambient air temperature:	18 - 35°C
Height over sea level max.:	1000 m
Machine colour:	
Spray Machine:	Grey RAL 7035
Conveyors:	Grey RAL 7035
Design details:	Black RAL 9005
Control cabinet:	Grey RAL 7035
Operating side of the line:	right hand side

Heating medium for the drying tunnels:hot water 90 / 70°C

Pos. 1 FEEDING BELT CONVEYOR

For feeding the batches into the flowcoater
Belt with marked area to built a gap for the angle transfer.

Technical Data:

length: 2300 mm

Price

USD

5,904.00

Pos. 2 1 IMPREGNATION MACHINE VEN FLOW

for flowcoating of windowprofiles in continious production with a waterbased impregnation (viscosity similar to water)

The material is is sprinkled on the surface and remains for appr. 10 seconds. After this time a high pressure air knife nozzles will blow the acess material from the surface.

The whole cabin is built with fall to the side to collect the rest of the material. It is reused after passing a filter system. The cabin is built of stainless steel.

The blowing off of the access material by air knife is effected by a high pressure fan.

The machine comprises:

1 conveyor system

with spray protected roller system.

length 3000 mm

1 sprinkling zone

with two nozzle systems adjusted to reach the whole surface of the workpiece.

length: 200 mm

1 penetration area

length ca. 1000 mm

time of residence ca. 10 sec

1 blowing zone

with adjustable knife nozzles

air supply with high pressure fan

air flow adjustable by frequency converter

length	ca. 1000 mm
air speed	ca. 40 m/sec

material supply

to supply the two sprinklers with fluid and collector for recovered material.

workpiece tolerances:

twist:	max. 1° on the whole length
straightness	max. 0,5mm deviation/m in horizontal and vertical
weight distribution:	evenly on whole length
coating material:	waterbased impregnation

Unstable components can not be repositioned when tilted.

Increased operating width

for components up to max. 305mm

Price	USD	50,527.00
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Pos. 3 MOULDING ANGLE TRANSFER VEN TRANS 90°

conveying from lengthwise direction to crosswise, comprising:

1 excenter-transfer arms integrated into the driven infeed roller conveyor.

The tacted transfer system allows a minimum distance between the single mouldings on the following cross transfer system.

Technical Data:

length of roller conveyor:	4500 mm
roller pitch:	185 mm
number of transfer arms:	22
spacing	185 mm
tacting cycle:	max. 30/min.

Price	USD	42,780.00
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Pos. 4 MOULDING CROSSWISE V-BELT CONVEYOR

for handling of mouldings following an angle transfer.

Mouldings are conveyed by means of various v-belts along the system. The unit is fitted with an insulation cover between the conveyor. A drying tunnel can be fitted on top of the unit.

Technical data:

length:	4000 mm
operating width:	4200 mm
number of belts:	22
distance of belts:	185 mm

outfeed prepared for an additional angletransfer:

position of driving shaft in the middle
gaps for passing of the carriers of the angle transfer

Price

USD

58,716.00

Pos. 5 JET DRYING TUNNEL 70 °C

made of sandwich elements with fire preventing insulation material.

The even distribution of air over the full operating width is reached by using slot nozzles on the full width of the tunnel.

One combined heating-, fan- and filter unit in compact design produces the air required for the process. A high capacity fan circulates the air through the F5 filter and heat exchanger. The tunnel can be operated with two different air speeds in the first and second tunnel section. All areas of the dryer are easily accessible through inspection panels for maintenance and cleaning. At the tunnel sides every 2000 mm insulated openings are fitted for observing the operating level.

Circulating air and exhaust air speed and volumes are controlled by manually adjustable air flaps. The air flow is secured by air flow switches in the tunnel, to keep the set volumes of air.

Included in the delivery is one temperature control system.

technical data:

length:	3000 mm
operating width:	4200 mm
opening height:	80 mm
air temperature:	50 °C
air speed:	25 m/sec
heating medium:	hot water,
heat capacity (max)+15/70°C	50 kW
exhaust air volume	500 m3/h
electric consumption:	5,0 kW

Price	USD	39,840.00
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Pos. 6 MOULDING ANGLE TRANSFER VEN TRANS 90°

conveying from lengthwise direction to crosswise,
comprising:

1 excenter-transfer arms integrated into the driven infeed roller conveyor.

The tacted transfer system allows a minimum distance between the single mouldings on the following cross transfer system.

Technical Data:

length of roller conveyor:	4500 mm
roller pitch:	185 mm
number of transfer arms:	22
spacing	185 mm
tacting cycle:	max. 30/min.

Price	USD	42,780.00
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Pos. 7 BELT CONVEYOR

As a return conveyor

Technical Data:

length:	5300 mm
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Price	USD	10,20000
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Pos. 8 CONTROL CABINET

for all quoted items, with all necessary control and protection elements, motor relays indicators, displays and main switch. All elements are internally pre wired on marked series clamps.

The cabinet includes all free contacts for interlocking our and also machines of other suppliers.

(not explosion proof design)

Price	USD	34,56000
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Pos. 9 WIRING MATERIAL

for the complet wiring of the quoted items according to the agreed position of the control cabinet (distance to machinery max. 10m). The installation, and connecting of the wires and the fixing materials like cable trays, are not included.

Price	USD	5,040.00
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Total Price:	USD	290,347.00
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Options:

Subject to price change over extended time period

Light curtain and software for workpiece counter when driving in batches:

Price:	6,204.00 USD
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Extension of dryer "Variant 2"

Material for extension of the V-Belt conveyer by 3000mm

Price:	10,800.00 USD
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Additional oven with a length of 3000mm to increase the drying time

Price:	39,840.00 USD
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Extension of switch cabinet for the additional oven

Price:	5,400.00 USD
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Additional wiring material for the additional oven

Price:	840.00 USD
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Total Price variant 2:	USD	56,880.00
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Extension of dryer “Variant 3”

Removable roller conveyer

Price: 5,400.00 USD

Angle transfer

Price: 42,780.00 USD

V-belt conveyer

Price: 58,716.00 USD

Additional oven with a length of 3000mm to increase the drying time

Price: 39,840.00 USD

Angle transfer

Price: 42,780.00 USD

Removable roller conveyer

Price: 5,400.00 USD

Extension of switch cabinet for the additional oven and conveyer technology

Price: 22,200.00 USD

Additional wiring material for the additional oven and conveyer technology

Price: 3,360.00 USD

Total Price variant 3:**USD 220,476.00**

INSTALLATION COMMISSIONING

This includes the installation and commissioning of all quoted items by our technicians, including all working hours as well as instruction time at the machines. Excluded are tickets, hotel accommodation and local transport. If a training and production support is agreed this is based on a single shift operation. (There would be an additional charge for the variant 3)

USD 9,000.00

SALES CONDITIONS:

Execution of components:

The line / machine is produced respecting the harmonized European norms. Are harmonized European norms not available, the European norms or German safety standards are valid.
For complete machines /plants 2006/42/EG, Article 1 (a-f) a declaration of conformity will be executed.
For incomplete machines / plants 2006/42/EG, Article 1 (g) a Declaration of Incorporation will be made.

Not Explosion proof equipment

The quoted machinery is not executed with explosion proof equipment

American standards

The plant is executed with explosion proof equipment in the designated hazardous areas according to valid UL / CSA standards. The control cabinet is not explosion proof and has to be positioned outside any hazardous regarded area.

Supply Voltage: 1/110 V 3/480V - 60 Hz
Control Voltage: 24V

Wiring material:

Wiring material required between machines and control cabinet is not included in the supply . Not including any cable ways or supports to be supplied and constructed by customer.

Exhaust air tubing:

The exhaust tubes are not included in the supply. The exhaust tubes need to be sealed. Also the compressed air and heating supplies are not included in the offer.

Standard elements used:

To ensure the function of the line all components of the line are selected by us. If different component fabricates are requested, this needs to be confirmed by us.

The test of the insulation and balance of potential needs to be done by customer.

Shipment requirement:

Approx 1 x 40 ft High Cube Container per large item from Germany. Charged at cost.

Packing material:

packing material will be charged as used.

Price basis:

Ex Works according to INCOTERMS 2010, excluding installation and commissioning charges. Local taxes have to be added. If necessary any permits/costs needing to be obtained are the responsibility of the customer. Installation additional.

Payment conditions:

30% deposit payable with order.

60% on confirmation that machines are ready for delivery.

10% after commissioning but not later than 30 days after delivery.

Delivery conditions:

according to ORGALIME S 2000.

Warranty:

On the machinery supplied we grant a warranty time of 12 months or 1760 operational hours from the date of production start. Excluded from warranty are wear parts (i.e. Nozzles, seals membranes,.....)

Possible warranty cases are depending on regular daily maintenance as well as every half year maintenance by our technicians.

Warranty claims exceeding the given times are possible if maintenance contracts are made with us.

The warranty is valid only for cases of normal use of the equipment. It excludes cases which are caused by modifications which have not expressly agreed by us.

Property regulation:

All delivered goods remain in the possession of Venjakob Maschinenbau GmbH & Co KG until we have received full payment. An extended ownership claim is expressly valid until the line is paid completely.

Delivery time ex works:

Approximately 6 months with written order and clearing of all technical details.

Validity of offer:

The prices given are held valid for a period of 1 month, and are subject to exchange fluctuations. 1.2 USD to Euro

Remote service module:

The control cabinet of the Machine can be equipped with a service router which can build up a connection to the service server by UMTS or Ethernet.

The customer has to supply:

- a) One DHCP-compatible network connection / **or**
- b) One SIM-Card (unlocked) for UMTS-data transfer released

If a visit needs to be made, and a not correctly executed connection of the remote system is diagnosed, this visit will be charged by us.

Operating instructions at machine:

by symbols or in English language.

Technical specification:

The technical details given in the order confirmation are preliminary.
The final details will be sent to you approx. 4 weeks prior to delivery.

Transport of the equipment on site:

The components we supply can be unloaded from the truck by forklift or crane.
Details you will receive prior to delivery from us.
The max. Kilo weight is approx. 4.000 Kg
The max. Kilo size is (L x W x H) 2,5 x 5,8 x 2,6 m
Please check the transport way in your factory.

Insurance:

The machinery needs to be insured by the customer from the point of taking over from us according to orgalime conditions (i.e. EX works /FOB/CIF /DAP).

Non Disclosure Clause:

The above described Machinery, as well as additionally presented documents, cannot be given to a third party without permission of Venjakob. This rule is not limited in time, and not bound to a business relation. If the clause is not respected we keep us the right of claims of damages.

INSPECTION AGREEMENT (Suggestion)

For an optimized operation of the quoted line we advise to have an inspection agreement made with our service department.
The inspection agreement is a long-term pre-planned, expert examination of the supplied Equipment at fixed time intervals and at fixed prices secure.

Through timely maintenance and inspection of the machine can reduce the cost of maintenance, so the total get-usability of and extensive repair work will be avoided. In addition, components of the machine according to undertake the safety regulations for maintenance.

According to EN 12 621 - (conveying under pressure) must be checked in the system under pressure hoses by the operator or an authorized service company.

Our inspection agreement includes:

- Reviewing and where necessary improve the control and function parameters.
- Adjustment.
- Visual inspection for wear, leaks and damage to the machine components
- Review of all security functions.
- Discussion required by or necessary changes to the machine with the customer.
- Advice on necessary repairs discovered during the inspection required repairs.
- The customer receives a written report on these Inspection opportunities with a recommendation regarding the work to be undertaken.

Customer Benefits

- Minimization of machine downtime.
- Spare parts can be offered based on the actual needs and are available in case of service.
- Increases productivity.
- Planned repairs instead of unplanned production stoppages-the- Venjakob original spare parts.
- The status of the machines is transparent and the security aspects are fulfilled.

Visit intervals

The intervals of the inspection agreement set by the customer and Venjakob. Typically, a planned bi-annual working rhythm. The presence on site for inspection is 6 hours. During this time, even minor repairs are carried out. The material required for any repair is not included.

An inspection agreement can include:

The working time, travel costs, travel expenses and accommodation

With kind regards

Andrew Scott Taggart

VENJAKOB NORTH AMERICA

This quote contains confidential information and is intended solely for the use by the addressee.