



Automatic Turning Technology, LLC



Automa, Inc.

Friday, January 19, 2001

*Prepared Exclusively For:*

*Adams Wood Products L.T.D., L.P.  
P.O.Box 728  
Morristown, TN 37815-0728  
(423) 587 2942*

*Larry Swinson*

By:

Automatic Turning Technology LLC

Proposal # 010119

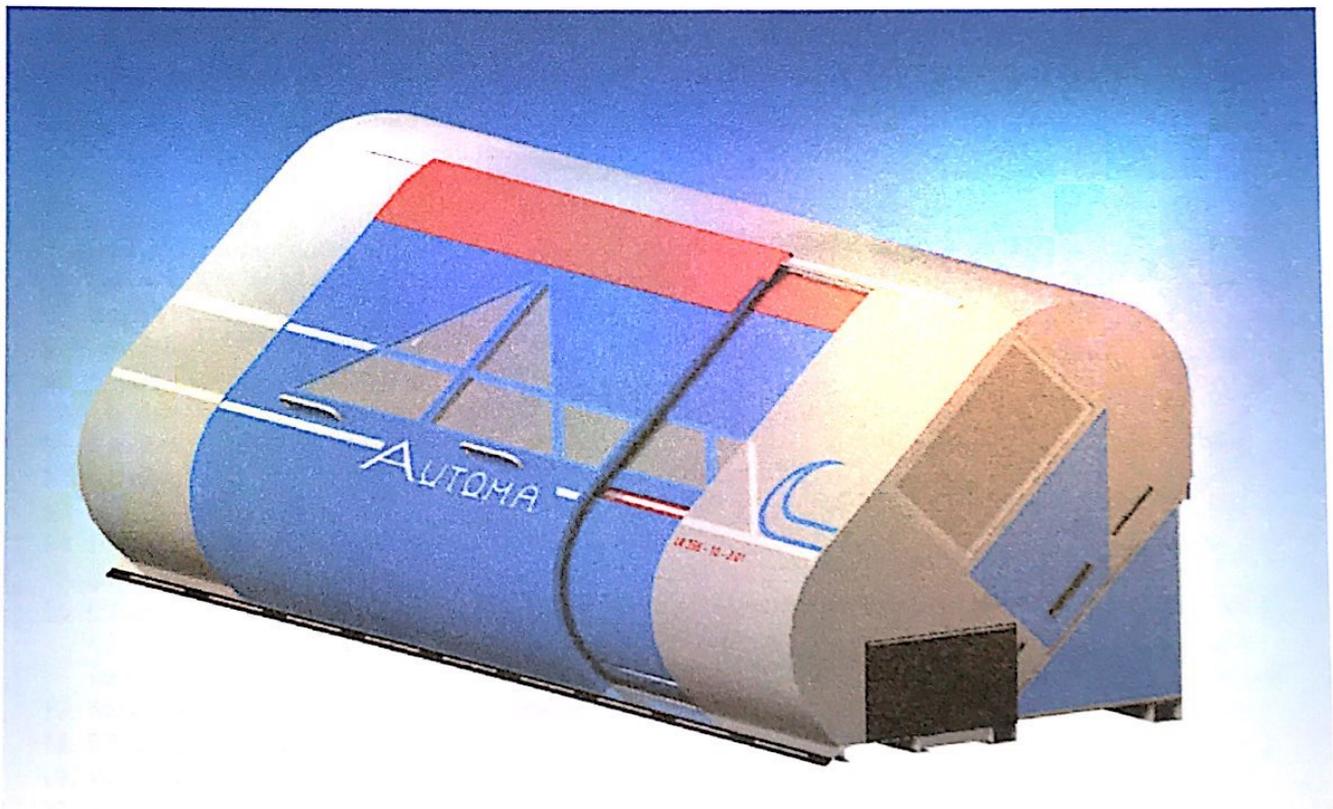
**Automa LR 355-10-3.01**

**Patent pending**

*Page#1*

8318 Pineville-Matthews Rd  
Suite 275  
Charlotte, NC 28226 USA  
Phone: 704-540-7121  
Fax: 704-540-7275  
Email: attllc@bellsouth.net

Proposal # 010119



**Automa LR 355-10-3.01**  
**Patent pending**



Friday, January 19, 2001  
Proposal # 010119

Dear Larry,

Following our phone conversation, Automatic Turning Technology is please to offer you the following:

One of new Automa LR 355-10-3.01 CNC combination lathe and router as specified below for maximum work-piece size of 3000 mm length and 355 mm diameter.

1. 10 controlled cnc axes as per picture # page 4.
2. 2 indexing tool turrets with 12 tool positions each.
3. Each turret may be outfitted with milling cutters or with lathe tools
4. Milling tool holders with up to 10 HP motors
5. 2 of self centering steady rests for up to 355 mm diameter work-piece
6. 2 of self centering and self locating work holding clamps for work-piece size up to 355 mm
7. Headstock with 19 KW C axis frameless motor, water cooled, for up to 6000 RPM and 260 Nm maximum torque.
8. Headstock RPM and indexing is automatically controlled by CNC
9. Linear axis movements by linear motors
10. Maximum linear axis positioning speed of 2000 mm/sec, maximum acceleration of 2 G
11. Linear axis positioning precision of 0.01 mm
12. Tailstock opening and setting automatically controlled by CNC
13. Steady rest and clamps setting is automatically controlled by CNC
14. Full machine enclosure with automatic door opening
15. Incorporated dust suction and chip removal conveyor
16. CNC control by Indramat with open architecture and: Human Machine Interface, PLC integrated with CNC, Intelligent digital drives, interactive on line and of line NC simulation, multi axis interpolation, integrated cycle speed programming, tools management, high resolution diagnostic, PLC logic analyzer.
17. Servo drives and power supply with regenerative power.
18. Fiber optic wiring
19. Peripherals wired by Fixture mount I/O
20. Flexible machine operator panel
21. Electrical cabinet with air conditioning unit.
22. Safeties as per UL and CE standards
23. Instruction manuals and part books.

Patent pending

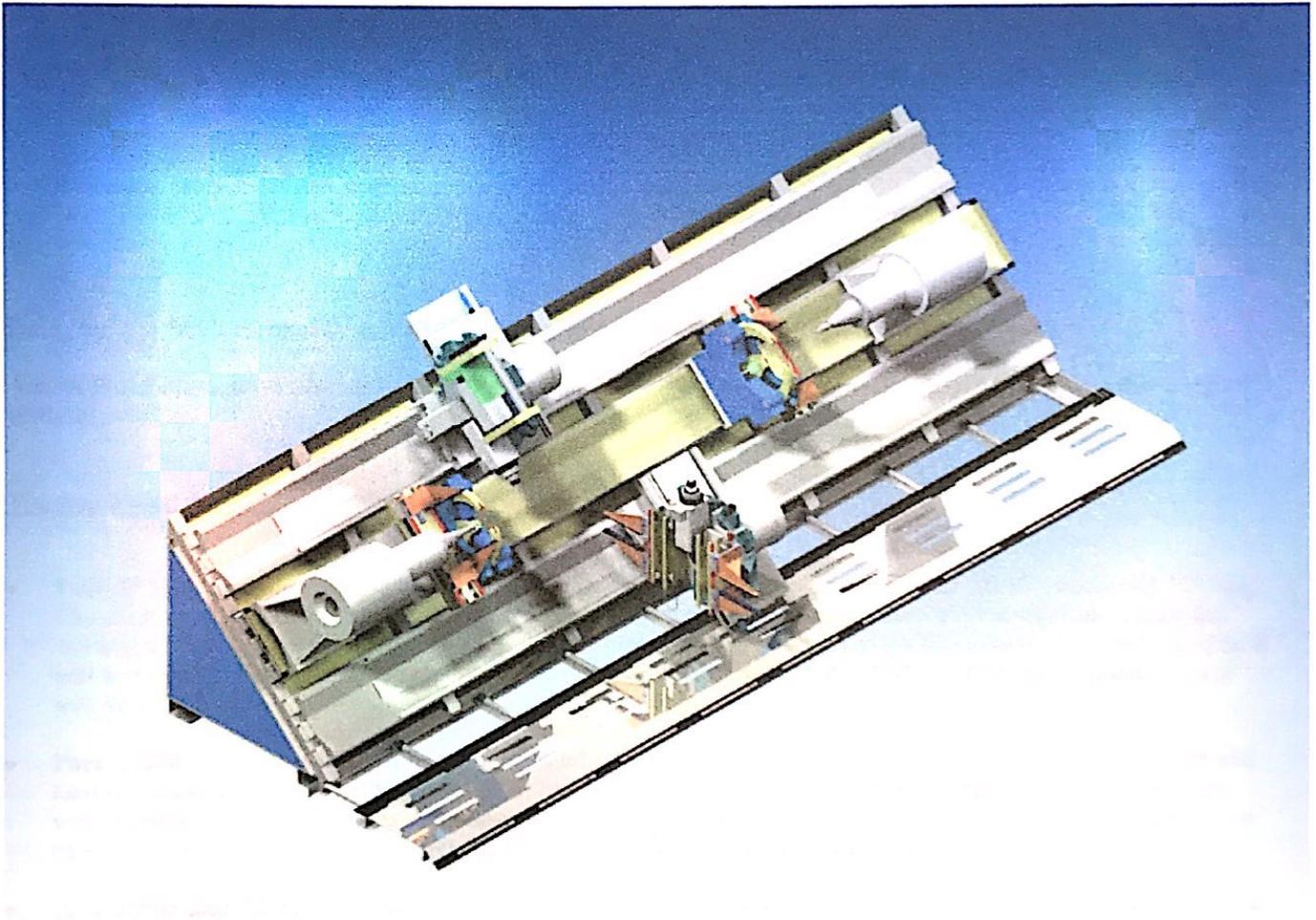


Automatic Turning Technology, LLC



Automa, Inc.

Proposal # 010119



Patent pending



## Proposal #010119

The machine will be outfitted with the proper tooling and fixtures to produce the following customer parts (per catalog Dated September 1, 2000):

1. # A0560
2. # A0570
3. # A0568
4. # A0565
5. # A0561
6. # A0113
7. # A0125
8. # A0122
9. Non catalog item, named "Bed post 84 inches long by 7, 1/8 inches diameter Henredon"
10. # AFR28

Part programs will be created by Automatic Turning Technology utilizing standard cad/cam software.

Adams Wood Products will be consulted by Automatic Turning Technology on the preferred tooling and software specifications.

### The machining process for the above parts will be as following:

- **Part A0560**, glued up wood stock will be supplied by customer. Stock size will be 6.25"x6.25" square and 17" long. The stock will be manually loaded onto the machine centering clamps. The machine will automatically chuck the work-piece than it will proceed to first rough cut the piece to shape , than finish cut the piece to shape and size than it will belt sand the piece and brush sand the piece to a 150 grit finish on Maple stocks. **Estimated production rate will be of 5 minutes.**
- **Part A0570**, Glued up stock will be supplied by customer, rough square 8.75" x 8.75" x 17" long. The operator will load the stock onto the centering clamps, than the machine will perform the turning operation , sanding operation with brushes, fluting operation with milling cutters, and final sanding operation with brushes, 4 grits of brushes may be utilized in sequence to obtain a 180 grit finish. **Cycle time is estimated to be of 3 minutes.**
- **Part A0565 and A0568**, glued up stocks will be supplied by customer, the A0565 will require a S4S stock or the machine will be able to machine the square end at an additional 1 minute of cycle time. Loading by operator on machine centering rests. Process as per A0570. Estimated cycle time for the turning, sanding , reeding and sanding again to 150 brush finish will be of **4 minutes.**
- **Part A0561**, Customer will supply glued up stock of 17" length and 7x7" rough square. Operator will load stock onto the machine centering rests, than the machine will perform the turning and the brush sanding operations terminating with a 150 grit brush finish. **Cycle time shall be estimated at 2 minutes.**

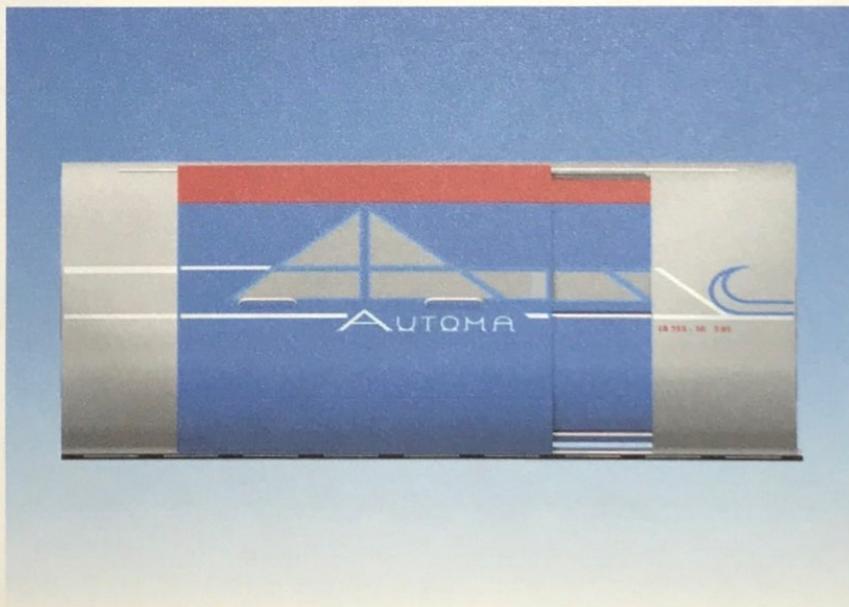
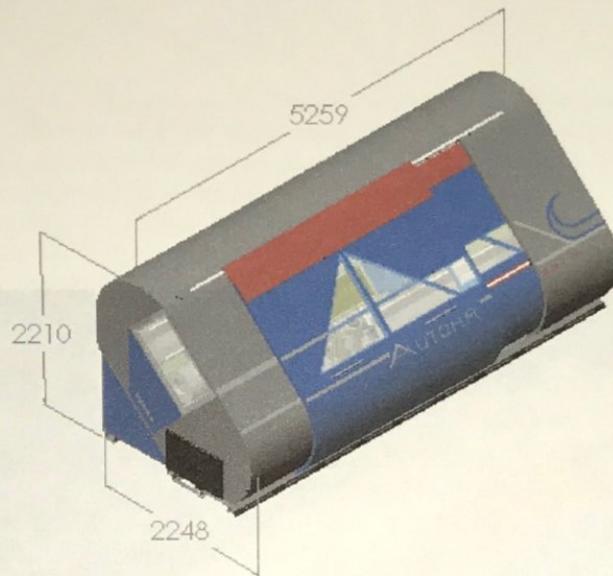


Automatic Turning Technology, LLC



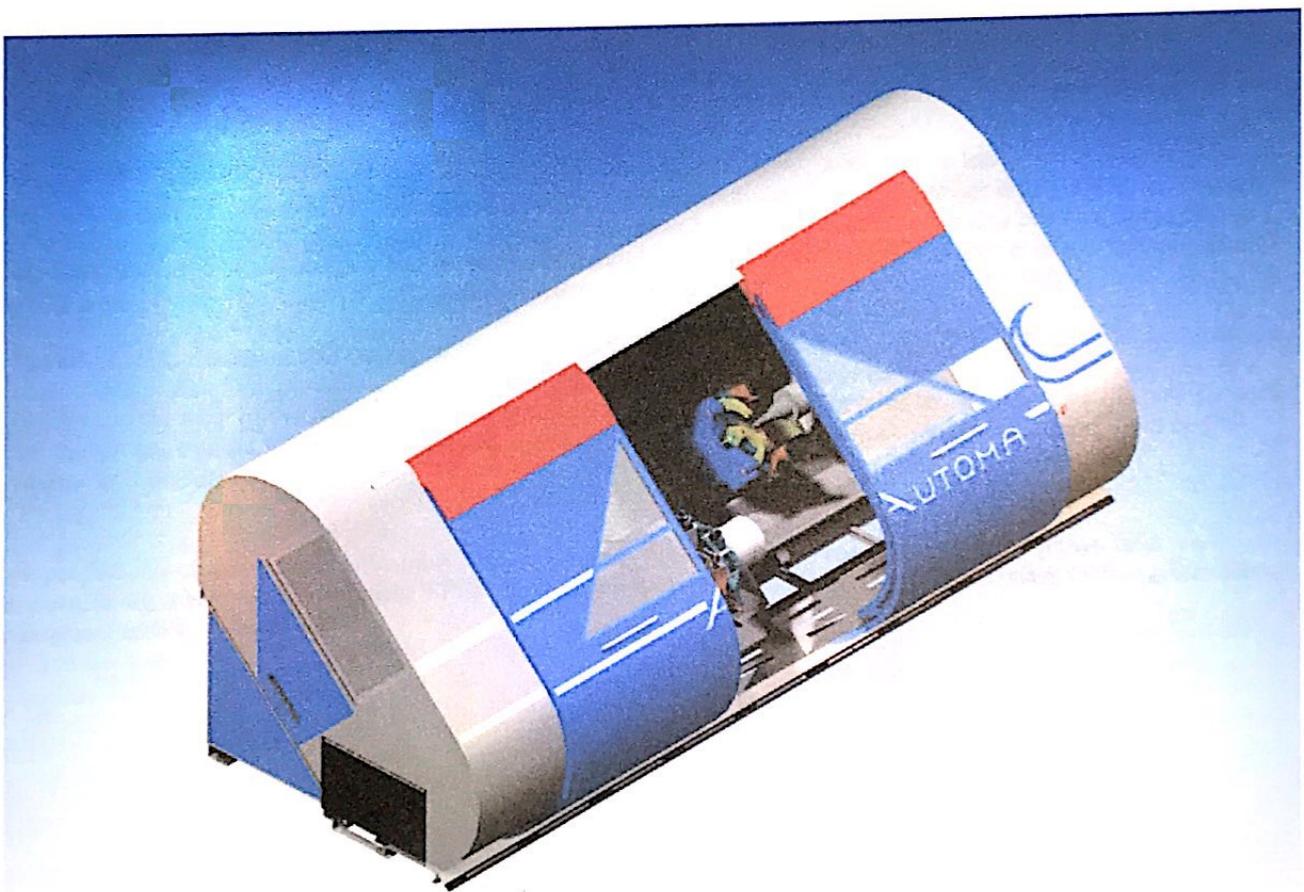
Automa, Inc.

Proposal # 118119



Patent pending

Proposal # 010119



Patent pending



#### Proposal #010119

- **Part #A0113, 125, 122**, Customer will supply stock obtained by gluing molded strips of wood of the correct size and shape to create an octagonal hollow wood drum. The individual strips of wood will not need to be accurately trimmed to length, a standard length variation between wood strips could be of as much as 0.175". The operator will load the octagonal glued up drum onto the machine centering rests. The machine than will index the chuck so to be aligned with the interior octagonal section of the wood drum, will clamp the stock between heads-stock and tail-stock plates than it will perform the turning and rough brush sanding operation followed by the reeding operation and the finish brush sanding operation. Subsequently the machine will perform the longitudinal end boring every 90 degrees of the 360 and the 4 pear of radial boring at every 90 degrees of the 360. At operation completed a radial saw blade will trim both end of the work piece to the correct length and square ness . **Estimated production cycle time of 5 minutes.**
- **Item #9 "Henredon post"**, Customer will supply glued up hollow stock , stock will be loaded by operator on the centering rests, than the machine will chuck it and first will perform the turning and rough brush or belt sanding operation than it will perform the fluting or reeding operation and a final brush sanding , also a bed lock could be machined on the side of the bed post and an end-longitudinal boring for the finial application can be performed. Considering a total machining length of 84" a **total production rate of 12 minutes could be estimated.**
- **Part #AFR28**, Customer will supply stock with wing blocks glued on it, operator will load the stock on the centering rests. The machine will perform a rough and a finish shaping , than it will mill the square shank, the top of the wing blocks and the back of the wing blocks, subsequent belt sanding and brush sanding to 180 grit finish. Optional a hole for the stretcher and 4 holes for the lug-bolts can be machined. **Total production rate including the holes is estimated at 6 minutes.**

Above production rates and times have been computed based on cutting tool speed, chip load and section, feed speed rates, positioning speed rates, work piece RPM and acceleration rates. Final accurate production rates will be given only after physical testing of the process.

**Patent pending**

# UNFINISHED BILLIARD TABLE LEGS

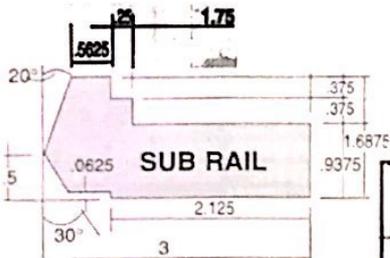


A0573CK  
THE BEAST



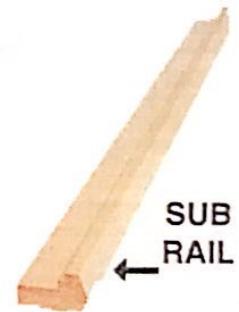
PRICES DO NOT INCLUDE SHIPPING CHARGES. ALL PRICES SUBJECT TO CHANGE WITHOUT NOTICE.  
PRICE PER PIECE CAN MIX WOODS, "BUT NOT" STYLES FOR 16-48 PIECE PRICE

PART #	STYLE	MAPLE-1			RED OAK-4			MAHOGANY-5			WTS. LBS. EA.	LENGTH	DIA.
		1-15 pc	16-47	48 & up	1-15 pc	16-47	48 & up	1-15pc	16-47	48 & up			
A0560	QUEEN ANNE	46.40	43.90	41.40	46.40	43.90	41.40	47.85	45.35	42.85	9.6	17"	6.25"
A0561	STYLE FOUR	47.95	45.45	42.95	47.95	45.45	42.95	49.25	46.75	44.25	12.1	17"	6.75"
A0562	RAMS HEAD	54.95	52.45	49.95	54.95	52.45	49.95	56.60	54.10	51.60	9.0	17"	6.25"
A0562CK	RAMS HEAD (CARVED KNEE)	-	-	-	66.05	63.55	61.05	-	-	-	9.0	17"	6.25"
A0564	CLAW/BALL	54.95	52.45	49.95	54.95	52.45	49.95	56.60	54.10	51.60	9.0	17"	6.25"
A0564CK	CLAW/BALL (CARVED KNEE)	-	-	-	68.40	65.90	63.40	70.85	68.35	65.85	9.0	17"	6.25"
A0565	REEDED	-	-	-	55.05	52.55	50.05	56.35	53.85	51.35	12.1	17"	6.75"
A0568	GRECIAN	55.05	52.55	50.05	55.05	52.55	50.05	56.40	53.90	51.40	12.1	17"	7.00"
A0570	TRUMPET	62.80	60.30	57.80	62.80	60.30	57.80	64.95	62.45	59.95	13.1	17"	8.50"
A0572	POOLPIT	-	-	-	46.35	43.85	41.35	-	-	-	11.5	17"	8.50"
A0573CK	THE BEAST	79.50	77.00	74.50	79.50	77.00	74.50	84.50	82.00	79.50	13.2	17"	7.25"



Sub Rails will be made from laminated poplar to help prevent warpage. No voids will be allowed.

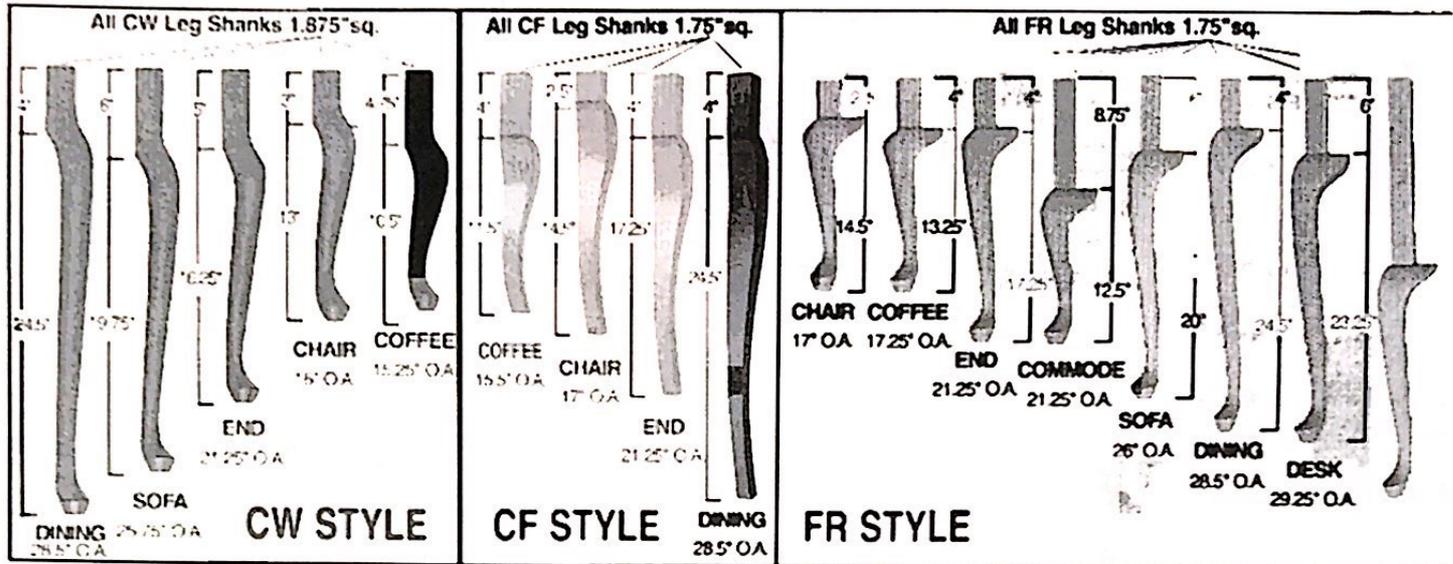
PART#	STYLE	POPLAR-10			WTS. LBS. EA.	length
		1-143	144-299	300 & up		
A0700	SUB RAIL	15.95	11.95	10.95	4.0	50"



Adams Wood Products™ To Order Phone 423-587-2942 Fax 423-586-2188

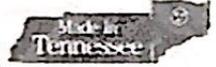
September 1, 2000

# UNFINISHED QUEEN ANNE LEGS



## NO MINIMUM QUANTITY REQUIRED

PRICES DO NOT INCLUDE SHIPPING CHARGES. ALL PRICES SUBJECT TO CHANGE WITHOUT NOTICE.  
 NOTE: CAN MIX WOODS BUT NOT STYLES OR SIZES TO RECEIVE QUANTITY PRICING.



## PRICE PER LEG

PART #	STYLE	MAPLE-1			CHERRY-3			RED OAK-4			MAHOGANY-5			WALNUT-6			PAINT GRADE-10 WHEN AVAILABLE		
		1-11pc	12-99	100&up	1-11pc	12-99	100&up	1-11pc	12-99	100&up	1-11pc	12-99	100&up	1-11pc	12-99	100&up	1-11pc	12-99	100&up
ACW15	COFFEE	15.95	11.95	8.45	19.45	15.45	11.95	19.25	15.25	11.75	17.30	13.30	9.80	19.95	15.95	12.45	12.20	9.20	6.70
ACW16	CHAIR	16.60	12.60	9.10	20.45	16.45	12.95	20.25	16.25	12.75	17.90	13.90	10.40	20.45	16.45	12.95	12.85	9.85	7.35
ACW21	END	18.55	14.55	11.05	23.30	19.30	15.80	23.10	19.10	15.60	20.00	16.00	12.50	24.70	20.70	17.20	14.25	11.25	8.75
ACW25	SOFA	21.65	17.65	14.15	27.95	23.95	20.45	27.10	23.10	19.60	23.35	19.35	15.85	29.30	25.30	21.80	17.00	14.00	11.50
ACW28	DINING	26.40	22.40	18.90	33.45	29.45	25.95	32.50	28.50	25.00	28.70	24.70	21.20	33.45	29.45	25.95	21.00	18.00	15.50

### CF STYLE-COUNTRY FRENCH (SQUARE TAPER)

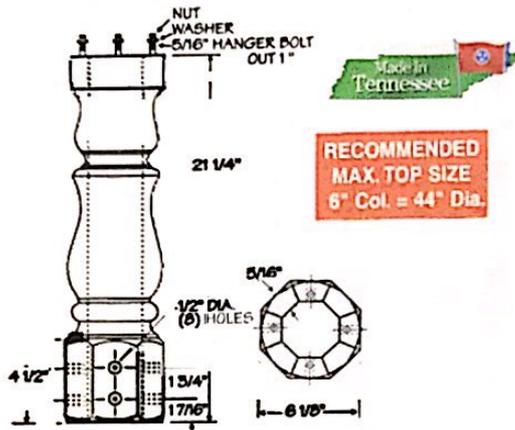
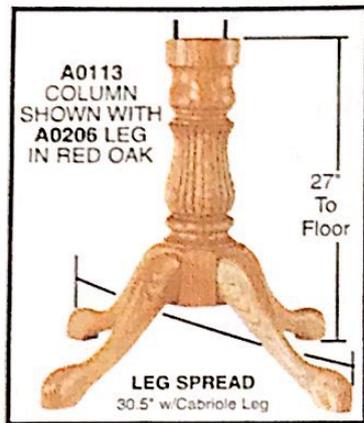
ACF15	COFFEE	18.30	14.30	10.80	21.70	17.70	14.20	21.60	17.60	14.10	-	-	-	-	-	-	14.60	11.60	9.10	1.5
ACF17	CHAIR	18.70	14.70	11.20	22.35	18.35	14.85	-	-	-	-	-	-	-	-	-	14.95	11.95	9.45	1.6
ACF21	END	20.35	16.35	12.85	24.85	20.85	17.35	24.75	20.75	17.25	-	-	-	-	-	-	16.15	13.15	10.65	2.0
ACF28	DINING	25.65	21.65	18.15	32.45	28.45	24.95	31.75	27.75	24.25	-	-	-	-	-	-	20.45	17.45	14.95	2.6

### FR STYLE

AFR17	CHAIR	22.30	18.30	14.80	27.10	23.10	19.60	26.90	22.90	19.40	24.75	20.75	17.25	27.65	23.65	20.15	17.75	14.75	12.25	2.1
AFR18	COFFEE	22.30	18.30	14.80	27.10	23.10	19.60	26.90	22.90	18.40	24.75	20.75	17.25	27.65	23.65	20.15	17.75	14.75	12.25	2.1
AFR21	END	24.25	20.25	16.75	29.80	25.80	22.30	29.60	25.60	22.10	27.00	23.00	19.50	30.45	26.45	22.95	19.35	16.35	13.85	2.7
AFR22	COMMODE	26.60	22.60	19.10	32.45	28.45	24.95	32.25	28.25	24.75	29.40	25.40	21.90	33.35	29.35	25.85	21.70	18.70	16.20	2.7
AFR26	SOFA	27.05	23.05	19.55	34.75	30.75	27.25	33.60	29.60	26.30	30.60	26.60	23.10	34.70	30.70	27.20	22.15	19.15	16.65	3.2
AFR28	DINING	29.65	25.65	22.15	37.75	33.75	30.25	36.75	32.75	29.25	33.40	29.40	25.90	38.00	34.00	30.50	23.75	20.75	18.25	3.2
AFR29	DESK	29.65	25.65	22.15	37.75	33.75	30.25	36.75	32.75	29.25	33.40	29.40	25.90	38.00	34.00	30.50	23.75	20.75	18.25	3.3
AFR34	LOWBOY	36.55	32.55	29.05	47.00	43.00	39.50	45.75	41.75	38.25	41.45	37.45	33.95	47.30	43.30	39.80	30.05	27.05	24.55	3.8

September 1, 2000

## #A0113 UNFINISHED REEDED TULIP BASES

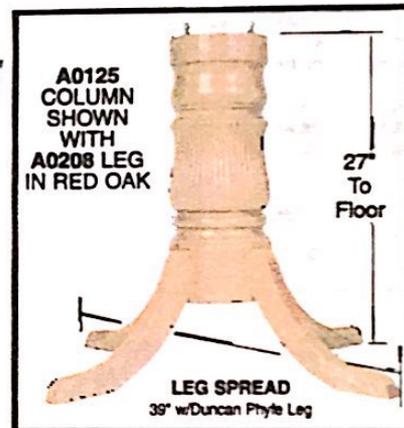
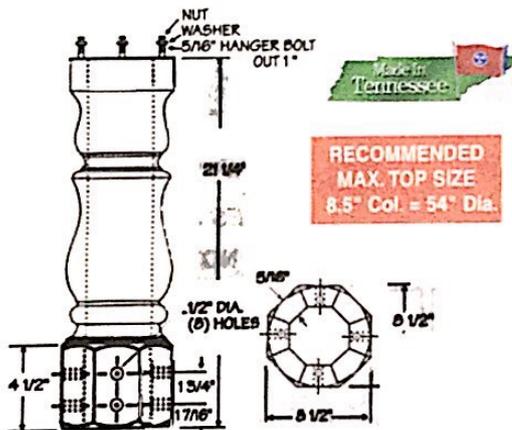
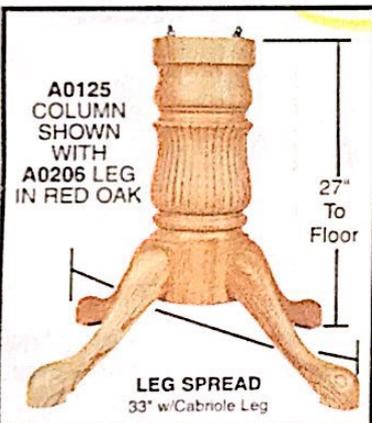


LEG PICTURES & PRICING ON NEXT PAGE

RECOMMENDED  
MAX. TOP SIZE  
6" Col. = 44" Dia.

STYLE	MAPLE-1		CHERRY-3		RED OAK-4		MAHOGANY-5		WTS. LBS. EA.
QUANTITY	1-24 Pcs.	25 Pcs. & Up	1-24 Pcs.	25 Pcs. & Up	1-24 Pcs.	25 Pcs. & Up	1-24 Pcs.	25 Pcs. & Up	
A0113 6" COL. Price Each	57.00	42.00	72.25	57.25	59.25	44.25	67.00	52.00	10.5

## #A0125 UNFINISHED REEDED TULIP BASES

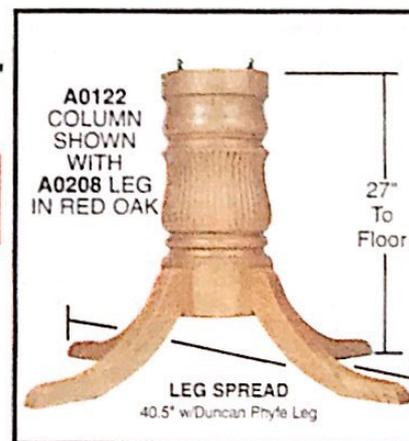
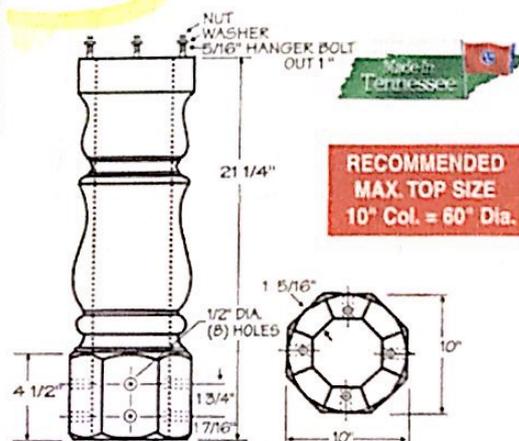
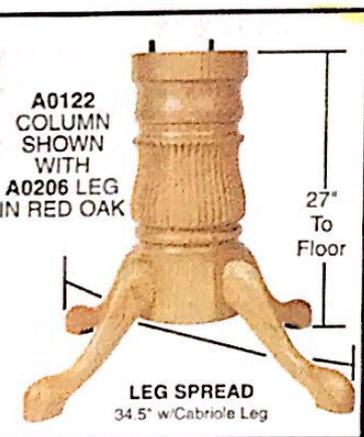


LEG PICTURES & PRICING ON NEXT PAGE

RECOMMENDED  
MAX. TOP SIZE  
8.5" Col. = 54" Dia.

STYLE	MAPLE-1		CHERRY-3		RED OAK-4		MAHOGANY-5		WTS. LBS. EA.
QUANTITY	1-24 Pcs.	25 Pcs. & Up	1-24 Pcs.	25 Pcs. & Up	1-24 Pcs.	25 Pcs. & Up	1-24 Pcs.	25 Pcs. & Up	
A0125 8 1/2" COL. Price Each	71.50	56.50	87.95	72.95	74.40	59.40	61.50	66.50	16.6

## #A0122 UNFINISHED REEDED TULIP BASES



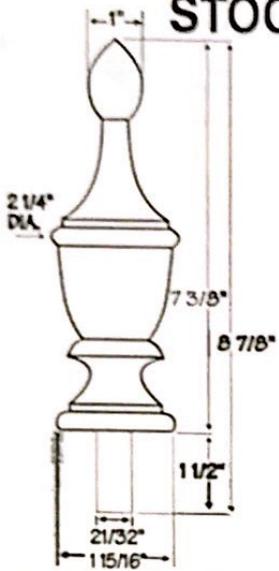
LEG PICTURES & PRICING ON NEXT PAGE

RECOMMENDED  
MAX. TOP SIZE  
10" Col. = 60" Dia.

STYLE	MAPLE-1		CHERRY-3		RED OAK-4		MAHOGANY-5		WTS. LBS. EA.
QUANTITY	1-15 Pcs.	16 Pcs. & Up	1-15 Pcs.	16 Pcs. & Up	1-15 Pcs.	16 Pcs. & Up	1-15 Pcs.	16 Pcs. & Up	
A0122 10" COL. Price Each	75.95	60.95	94.50	79.50	78.25	63.25	68.50	73.50	22.0

# POSTS & ROBE RAILS

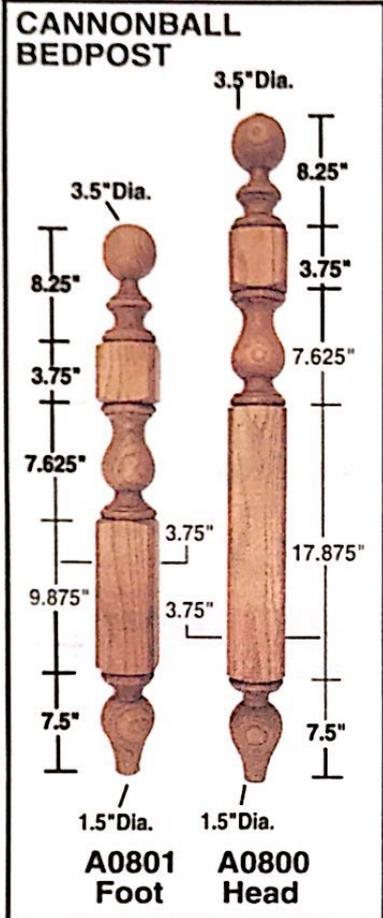
STOCK ITEMS VARIOUS WOODS



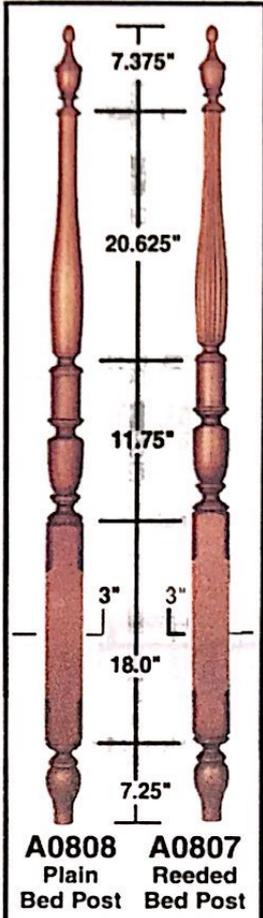
**A0803-220 Finial**  
CAN BE PURCHASED SEPARATELY



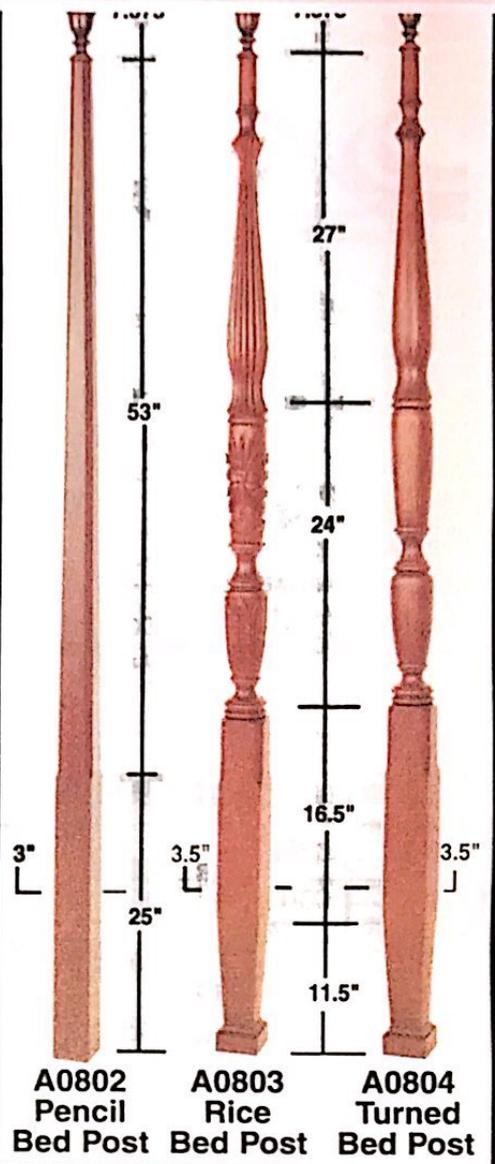
Two Brass Plated Bolt Covers & nails included with each post.



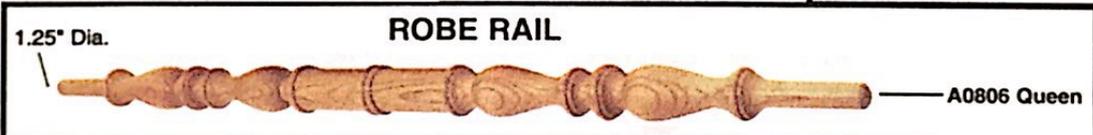
**A0801 Foot**      **A0800 Head**



**A0808 Plain Bed Post**      **A0807 Reeded Bed Post**



**A0802 Pencil Bed Post**      **A0803 Rice Bed Post**      **A0804 Turned Bed Post**



**ROBE RAIL**

**A0806 Queen**

PRICES FOR POSTS  
A0802, A0803, A0804  
A0807 & A0808  
INCLUDES FINIAL

PRICES DO NOT INCLUDE SHIPPING CHARGES • ALL PRICES SUBJECT TO CHANGE WITHOUT NOTICE.

**PRICE PER PIECE**

**NO MINIMUM QUANTITY**

ITEM #	ITEM	SIZE	MAPLE-1	CHERRY-3	RED OAK-4	MAHOGANY-5	Packed Wts. Lbs.
A0800	CANNONBALL HEAD POST	3.75"x3.75"x45"	60.50 ea.	91.50 ea.	64.50 ea.	N/A	13.5 ea.
A0801	CANNONBALL FOOT POST	3.75"x3.75"x37"	50.50 ea.	78.95 ea.	53.75 ea.	N/A	10.5 ea.
A0802	* PENCIL BED POST	3"x3"x85.375"	82.00 ea.	118.95 ea.	84.95 ea.	110.75 ea.	16.5 ea.
A0803	RICE BED POST	3.5"x3.5"x86.375"	N/A	122.95 ea.	119.25 ea.	131.95 ea.	18.5 ea.
A0804	TURNED BED POST	3.5"x3.5"x86.375"	N/A	90.95 ea.	87.95 ea.	101.95 ea.	18.5 ea.
A0806	QUEEN SIZE ROBE RAIL	3" dia. x61.5"	50.25 ea.	77.50 ea.	51.50 ea.	N/A	8.6 ea.
A0807	REEDED BED POST	3"x3"x65"	54.50 ea.	67.25 ea.	59.50 ea.	N/A	10.5 ea.
A0808	PLAIN BED POST	3"x3"x65"	50.50 ea.	63.25 ea.	55.50 ea.	N/A	10.5 ea.
A0803-220	FINIAL ONLY	2.25" dia w/ .625"x1.5" dowel	10.25 ea.	10.25 ea.	10.25 ea.	12.25 ea.	.55 ea.

\* 2 posts per box. Add \$5.00 per box for UPS special handling charge.

Adams Wood Products™ To Order Phone 423-587-2942 Fax 423-586-2188

September 1, 2000 7



Automatic Turning Technology, LLC



Proposal #010119

**Machine requirements:**

- **Power supply 480 V , 200 A . ( regenerative power! Voltage will be fed back to the line supply by the machine during all of the deceleration stages)**
- **Compressed air hose section 0.5 “**
- **Dust suction 4 of 10” diameter pipes**
- **Floor space see picture #**
- **Tot machine mass 11,000.00 Kg**

**Condition of delivery:**

- **Estimated delivery time will be 4 months from date of confirmed order**
- **Initial testing and approval by customer will be performed at the Automa manufacturing site in Charlotte, N.C.**
- **Shipping installation and training of customer personnel at customer site in Morristown TN is included in the supply.**
- **Adequate training time at customer facility for 2 operators is estimated at 2 weeks and it is included in the supply.**
- **Optional CNC operator training is supplied by Indramat and is not included.**
- **Warranty on installed components is of 2 years from date of installation and it is supplied directly to the end user by the components original manufacturer.**
- **Warranty on the Automa designed and manufactured parts is of 2 years from date of installation and it is supplied directly by Automa to the end user.**
- **All warranties expressly do not cover abuse and misuse.**
- **Customer has the responsibility to cover the equipment of this supply under his own property/fire and casualty insurance starting from delivery time.**

**Patent Pending**



Proposal # 010119

**Price:**

One of Automa Mod. LR 355-10-3.01 , 480v 3ph 60Hz.....\$ 350,000.00  
Including tooling, freight and training as above specified .

**Terms:**

Payment 100% following signed customer approval of the above machine and not later than 60 days from completed installation and operator training.

Adams Wood Product will have the right to approve or reject the above supply, approval or rejection must be submitted to Automatic Turning Technology in writing and signed not later than 60 days from date of completed installation and training. An eventual request for a time extension will have to be approved in writing by Automatic Turning Technology.

In the event of a rejection of the supply than Automatic Turning Technology will arrange for shipping of the machine back to Charlotte N.C. at no charge to the Customer and all obligations between Automatic Turning Technology and Adams Wood Products will be terminated.

Automatic Turning Technology will retain the title of the above machine till final payment has been received.

By check or transfer to Automatic Turning Technology LLC.

Payment to be guarantied by bank Letter of Credit and approved by our bank at the time of order confirmation

The above proposal has a validity of 30 days from proposal date..

Paolo Colle  
Automatic Turning Technology

Larry Swinson  
Adams Wood Products  
Date:

Patent pending