December 2004

ORDER CONFIRMATION
No. 136/04

for

SHOPEX B.V.

SHOPEX B.V.
Zilverenberg 3
NL - 5234 GL 'S-Hertogenbosch

Sarego, December 2nd, 2004

For the kind attention of Mr. Rob Overgoor

Order confirmation No. 136/04

Dear Mr. Overgoor,

We thank you for your order and have pleasure in confirming the supply of the following:

P4-2516abt PANEL BENDER

TL30155C.RPR	Scissor table
PCR3015/ARH80.OPA16	Robotized loading/unloading
P4-2516abt.LS.LI.MMACHNT.RAD	Panel Bender
ABA30/400/130	Programmable blankholder
CLA	Auxiliary blade command
UC570-2	Set of CLA tools
P	Mover for auxiliary tool
ASR	Roller-surface + Belt conveyor for unloading area
R81	Water-air cooler
UPS	Uninterruptible power supply
JOBP4.MAINTMGR	Software for P4
P4OFFICE	Software application

TECHNICAL DESCRIPTION

P4-2516^{abt} PANEL BENDER

TL30155C.RPR - Scissor table

Motorized scissor table, equipped with a roller pack reference system (RPR), apt to feed sheet metal packs. It can automatically translate along its own long side to correctly position the pack of sheets against the fixed reference of the destacker.
An autonomous hydraulic power unit ensures the horizontal motion of the table and the automatic adjusting of the drawing height while the sheets are being destacked.

Max dimension of the sheets to be loaded	3048 x 1524	mm
Max height of the pack to be loaded, including pallet	460	mm
Carrying capacity	5000	kg
Vertical stroke	550	mm

PCR3015/ARH80.OPA16 - Robotized loading/unloading

Unit placed alongside the Panel Bender, which allows notched sheets to be automatically fed and panels to be automatically unloaded and stacked compatibly with the panel shape, the suction cups arrangement and their pick-up force. It enables the Panel Bender to work unattended until all the sheets to be bent have been used up or all the positions available in the unloading area have been occupied.
It is composed of a brush-conveyor (**PCR3015**), which facilitates the lifting of notched sheets, and of an articulated Kuka robot with six degrees of freedom (**ARH80**) which is equipped with a pick-up device (**OPA16**) with suction cups that can be automatically adjusted according to the dimensions of the sheet and panel to be handled.
During the loading cycle the sheet is separated from the pack placed on the table beneath the conveyor, "double-sheet" checked, pre-centered and sent to the feeding pincer of the panel bender. When the panel has been processed the robot picks it up and stacks it in a given area suitably arranged within its arm's radius of action.
The robot complete cycle with path calculation is automatically elaborated and is integrated in the panel bender programming with a simple instruction.
The panel bender can be fed and unloaded manually.
Special stacking strategies are not included but must be studied and quoted separately.
Operational characteristics:

height from the floor to beginning of stack in stacking area:	200	mm
height from the floor to the end of the stack in stacking area:	1500	mm
maximum weight of panel:	40	kg

P4-2516^{abt} - Panel Bender

Programmable and automatic Panel Bender for the production of sheet metal panels through the formation of an unlimited number of bends on each side. The system automatically centers and bends the sheet it is fed with and then unloads the bent part.
Its features are:

- sheet feeding and positioning pincer with sheet thickness measuring device;
- sheet centering references able to automatically position themselves in masked time and to check if the panel has been centered correctly;
- ability to produce the first bend on each side flattened at 180 degrees (positive and negative safe edge);

- capacity to program the stop of the descending blankholder from 0 to 165 mm in order to obtain, for example, an open safe edge;
- ability to make both up and down bends; the last bend on each side must be an upwards bend; only the last bend on the last side bent can be a down bend;
- ability to bend pre-painted sheets or silked stainless steel, protected by plastic film (however, the quality of the material must be verified according to the application);
- increased energy saving thanks to an electronically managed pump able to optimize the capacity of the hydraulic circuit according to system needs;
- interpolated movement of the blade during bending - to reduce possibility of sheet marking - calculated on the basis of characteristics of the metal sheet and obtained thanks to "Salvagnini bending formula";
- discontinuous rotator at 0°, 90°, 180° and 270°;
- an electrical coil fitted in the hydraulic power pack's oil tank can be programmed to come on and pre-heat the oil in the hydraulic circuit in order to bring it to the optimum working temperature at a set time;
- work surface equipped with plastic brushes for an easy handling of the panel without scratching the contact surface and to reduce the noise during the production cycle;
- hermetically insulated cabinet provided with an automatic device for the conditioning and the internal temperature control;

maximum length of incoming notched sheet:	2795	mm
maximum width of incoming notched sheet:	1500	mm
maximum diagonal of notched sheet:	2800	mm
maximum bending length:	2500	mm
maximum dimension of bends above work surface:	165	mm

LS.LI – Bending blades

Bending blades able to make positive and negative bends up to ±135° in a single step.

Maximum thickness of sheet metal with a

UTS of 410 N/mm² (± 90°)	2.50	mm
UTS of 410 N/mm² (± 135°)	2.00	mm
UTS of 600 N/mm² (± 90°)	2.00	mm
UTS of 600 N/mm² (± 125°)	1.50	mm
UTS of 265 N/mm² (± 90°)	3.00	mm
UTS of 265 N/mm² (± 135°)	2.00	mm
Minimum thickness of sheet metal	0.50	mm

MMACHNT - MICROMach, Management and control system

High performance control system distributed on 3 levels.

- Elaboration unit for managing and supervising the machine. The unit is composed of a COMPAQ workstation with Windows 2000 operation system equipped with an UltraSCSI hard disk and two ETHERNET TCP/IP RJ45 network cards: one for the connection to the "real-time" control and the other for the connection to any programming office workstation.
- Proprietary real-time control unit which communicates with the interface section through a high-performance VME bus.
- Interface section towards peripheral devices such as hydraulic motors, solenoid valves, sensors .etc.

The MMACHNT control system allows the operator to use the main functions for managing the system swiftly and intuitively by means of a specially created graphic interface.

The MMACHNT system includes the following applications:

- machine diary which records the number of movements made by machine parts;
- graphic diagnostic on monitor which indicates operation anomalies and indications on the solution of the problem;
- the post-processor (PDE) which analyses the syntax and the geometry of the programming macroinstructions, transforming them in data useful to the working cycle of the P4. The PDE also manages the movements of the manipulator, bearing in mind the form and dimensions of the blank and automatically calculates the gripping points and bending force according to the quality of the material.
- Analog modem that permits a fast information exchange between the machine and various Salvagnini depts. such as Service, Automation, Studies & Applications.

RAD - Software package

Software package for the automatic programming of radius bends. Length, angle, radius, number of steps and the angle correction factor are stated in the bending program. From this data, RAD automatically creates the bending sequence of the radius bend. As with normal bends, angle correction, length correction, etc. can be programmed. The radius is between 5 mm and 50 mm programmable. The tolerances for the dimension and angle of radius bends must be verified by Salvagnini beforehand and depends on customer production.

ABA30/400/130 - Programmable blankholder

It is composed of:

- device for automatically setting the length of the blankholder tool in accordance with the instructions contained in the bending program. The blankholder is able to modify its length in masked time while the panel is being unloaded.
- a series of segments for the blankholder tool with front and side grooves to allow inward bends to be made.

The length of the blankholder tool can be composed in 4 mm steps.

Characteristics:

Maximum length of the blankholder:	2500	mm
Maximum length of the inward bend on the short side of the blankholder:	30	mm
Maximum length of the inward bend on the long side of the blankholder:	45	mm
Minimum width of the panel without inward bends:	about 130	mm
Minimum length of the panel:	about 400	mm

CLA - Auxiliary blade command

Option for the P4 panel bender composed of a numerical control device which is able to position one or two auxiliary blades along the lower blade in order to modify the bending profile during a phase of the bending cycle.

The bending blades are supplied as option.

Characteristics:

Maximum thickness of metal with a UTS of 410 N/mm^2:	2.00	mm
Maximum thickness of metal with a UTS of 600 N/mm^2:	1.50	mm
Maximum length of auxiliary blade:	1000	mm
Minimum length of auxiliary blade:	50	mm
Maximum bend angle:		90°

UC570-2 - Set of CLA tools

Set composed of 10 pairs of CLA tools for a total length of 670 mm.
Their various combinations allow you to compose tools starting from a length of 100 mm up to a length of 570 mm in 2 mm steps.
The set is composed of the following:

1 pair of 25 mm CLA tools
1 pair of 26 mm CLA tools
1 pair of 27 mm CLA tools
1 pair of 28 mm CLA tools
1 pair of 29 mm CLA tools
1 pair of 30 mm CLA tools
1 pair of 35 mm CLA tools
1 pair of 40 mm CLA tools
1 pair of 45 mm CLA tools
1 pair of 50 mm CLA tools

P - Mover for auxiliary tool

Option composed of a device for the automatic insertion of a fixed special tool between the blankholder and the counter-blade, which occurs in accordance with the instructions contained in the bending program. (e.g. grooves for embossing, tubular bend and special negative bend). The tool is not included.

ASR - Roller-surface + Belt conveyor for unloading area

Automation of the unloading area composed of:

- three roller surfaces one after the other for a total length of about 9 mm: the robot can pick up the pallets (Europallet format), equipped with a metallic cover, from a stack on the ground inside the unloading area and places them on the roller surface. Pallets covering with appropriate sheet metal is at customer charge. The bent panels are stacked by the robot on the pallet placed on the roller surface. When the maximum stacking height allowed (depending on the panel geometry) is reached, the pallet is moved by one step in order to leave room for the next pallet.
- a moveable belt conveyor which unloads the single panels in continuous mode.

R81 - Water-air cooler

Autonomous, independent closed circuit cooling unit for maintaining a constant temperature in the liquid inside the cooling circuit of the system. Refrigerating yield: 20.1 kW using R407C ecological gas.

UPS - Uninterruptible power supply

Continuous electronic power supply capable of maintaining the voltage at 220V - as required by the computer – to allow exiting from all the applications and the consequent shutting-down and automatic turning off of the UPS itself.
The shut-down of the NT system is activated one minute after a blackout.
Then, a minute after activation of the shut-down, the UPS turns itself off and automatically turns on when the power to the system's electric cabinet is restored.

JOBP4.MAINTMGR - Software for the automatic management of batch sequences and for saving system data.

Software packages, installed on every Salvagnini system, which allow the automatic management of the production of sequence of batches (JOBP4), if equipped with a sheet automatic feeding system, and the saving of the data and movements of the system components .

The sequence of batches is contained in a list manually prepared by the operator. It must be possible to produce the batches - that differ from one another for the program, the type and the thickness of material - with the same arrangement of the special tooling; otherwise, separated lists must be prepared. The final destinations of the single parts produced are automatically assigned according to the configuration of the connections placed downstream of the system. These destinations can be modified by the operator before starting production. It is possible to interrupt the input sequence and then to re-start it from where it was interrupted, even if in the meantime other parts have been produced.

All the movements or actions performed by any active object present on the system can be counted both to facilitate the maintenance and test operations and to obtain information on the wear condition of some components. The operator must manually select the desired objects among the lists that are at disposal in the system.

P4OFFICE - Software application

Software application for classifying, filing and transferring bending programs, in the office auxiliary workstation. Based on a window graphic interface, it makes the remote maintenance activity of the panel bender programs easier and more efficient.

PRICES

P4-2516^{abt} Panel Bender	**€**	**690.000,00**
Transport	€	10.440,00
Installation & Commissioning	€	29.620,00
Training	€	3.870,00
TOTAL PRICE OF SUPPLY	**€**	**733.930,00**

(Seven Hundred Thirty Three Thousand Nine Hundred and Thirty Euro)

CONDITIONS OF SALE

Date of despatch
August 2005.

Delivery
DDU 'S-Hertogenbosch (Netherlands), on lorry. The insurance during transport is at our charge and also covers unloading the system and moving it to its definitive position, provided that the appropriate mechanical equipment is used (fraud or gross negligence excepted).

Payment

40% with the order against bank guarantee.
The expenses for issuing the bank guarantee are at our charge.

40% on delivery of the system to your works;

20% upon signature of the final acceptance test report at customer's site.
The payment of the above instalment shall be guaranteed by a bank guarantee issued in our favour, to be received by us at least one month before despatch of the system from our works. This bank guarantee shall expire six (6) weeks after the expected date of the final acceptance test.
The expenses for issuing the bank guarantee are at your charge.

All payments should be made by SWIFT credit transfer.
All payments will be credited without cost.
You will not be entitled to make any complaints about any eventual dissatisfaction, if you are not up-to-date with your payments.

Penalty
Penalty for late final acceptance tests in your works, except for causes due to Shopex or force majeure, is payable for each full week after the agreed date of the final acceptance test, after a 2-week period of grace.
The penalty is 0.5% for each week calculated on the total amount of the supply. The maximum amount is 3%.
The Buyer, in any case, can neither demand nor claim for damages in no way, nor request the cancellation of the contract, declaring himself already compensated for all with the payment of the penalty insofar as it has been explained above.

Right of ownership
The machinery will belong to Salvagnini Italia until it has been fully paid for.

Competent Court
In case of controversy the law to be applied is that of Italy and the competent court is that of Vicenza.

CONDITIONS OF SUPPLY

Installation and commissioning (P4-2516^{abt} Panel Bender)
We will send you our own specialised personnel to do this.
It remains understood total price that you will put at our disposal, even over week-ends, and free of charge:
- auxiliary manpower
- suitable lifting facilities
- normal work tools
- electricity, compressed air and water
- telephone and telefax lines

as necessary for carrying out the work in the best possible manner.

Installation (P4OFFICE)
Excluded.
We will send you a CD containing the software and the installation procedure. Hereunder are the minimum requirements of the computer on which our software has to be installed:

COMPONENT	MINIMUM REQUIREMENTS	RECOMMENDED REQUIREMENTS
Computer (CPU)	PENTIUM INTEL II (450 Mhz)	PENTIUM INTEL IV (2.6 GHz)
Operating system	Windows 2000	Windows 2000
Video Graphic card	Graphics accelerator with 4 Mb	Graphics accelerator with 64 Mb
RAM	SDRAM 128 Mbyte	DDRAM 512 Mbyte
Hard disk capacity	UltraSCSI 4.3 Gbyte	UltraSCSI 36 Gbyte
Drive	CDROM	DVD; CDROM
Floppy disk Drive	3 ½ inch, 1.44 Mbyte	3 ½ inch, 1.44 Mbyte
2 network cards	ETHERNET TCP/IP (RJ 45).	ETHERNET TCP/IP (RJ 45 and BNC).

Furthermore we inform you that:
- the operating system must be Windows 2000 (Service Pack 2 or subsequent); access to the TCP/IP and NetBEUI network protocols; access to the network services: NetBIOS interface.
- Our Windows 2000 software packages have been developed for a 1024x768 pixel video resolution.
- Our Windows 2000 software packages need an IP fix address, the DHCP must be disabled.

It is understood that Salvagnini does not guarantee that its software is compatible with the hardware you supplied.

Instruction of your personnel
We will provide for instruction at our works or at our subsidiaries (travel, meals and accommodation expenses are not included) for two of your programmers for the time period stated below. The dates on which the courses will be carried out must be agreed upon, bearing in mind that some of these courses are held according to a previously established calendar. Your programmers must be familiar with the Windows operating system.
The course for maintenance and use of the machine will be held at your works by one of our technicians in charge of the installation of the machine, after the starting up of the system, for the time period stated below.

These courses will be held in English. If another language is requested, the use of an interpreter will be valued and will constitute a separate cost.

Duration of programming course:		*Duration of use and maintenance courses:*	
P4-2516^{abt}:	2 days	P4-2516^{abt}:	3 days

Technical documentation

The system will be supplied with a set of technical documentation in two copies: one on CD-ROM and one on paper. The set of documentation includes:

- "Instructions for use and maintenance", translated into the user's language and containing all the information necessary to carry out, in safe work conditions, the operations pertaining to the machine operator and the person in charge of ordinary maintenance.
- "Programming instructions", available in English and including the machine programming manual and the manual for using the optional software packages which help programming.
- "Technical documentation", available in English and including the drawings, diagrams, procedures, licences and certificates, necessary to complete the technical information relative to the system.
- "Electric, hydraulic and pneumatic diagrams" available in English.

Tests

Tests will be carried out in our works in the presence of your representatives. They will sign a test report stating that the equipment's construction and functions are as specified. This signature will function as acceptance of the equipment, for the shipment and for invoicing.
These tests will consist of producing a maximum of three different parts from your range. The parts shall be defined by the parties at least three months before the despatch of the system.
You will be responsible for sending us, at your expense and in accordance with our instructions, an appropriate number of blanks for setting up the system and carrying out the tests.

Final acceptance tests

The final acceptance tests will be carried out in your works by October 31st, 2005 in the presence of our representatives. A final acceptance test report will be drawn up stating that the equipment's construction and functions are as specified. This final acceptance test report will function as acceptance of the respective payment.
These tests will consist of producing the same three parts manufactured in our works. In order to produce these parts you will put at our disposal, in accordance with our instructions, an appropriate number of blanks for setting up the system and carrying out the tests.

Product warranty

Salvagnini expressly warrants that the system shall be free from defects in materials and workmanship for a period (the "Warranty Period) of twelve (12) months or fourthousand (4,000) hours of service, whichever shall be earlier completed, commencing on the date upon which the system has been commissioned, as defined below, but which is in any event not later than thirty (30) days after the arrival of the system at the place of delivery according to the contract terms. The system shall be considered to have been commissioned on the date the first manufactured part is produced by it and certified at customer's works by Salvagnini

in the presence of customer's representatives, who shall sign the system commissioning report. This warranty shall be valid only if all the use and maintenance instructions, contained in the manuals supplied with the system, are carefully carried out and the system has been used in normal operating conditions.

The warranty provides for the free supply, DDU 'S-Hertogenbosch (Netherlands) with our usual forwarding agent, of parts which are found to be defective together with the related labour. Labour will not be provided for the parts to be installed by the customer, such as hydraulic and pneumatic solenoid valves, pressure-switches, electrical and electronic switches, overload relays, all other electric material, hoses, pipes, software packages and modifications, circuit boards. Should you require any express delivery, the transport costs will be at your charge.

Salvagnini reserves the right to determine whether to repair or replace parts found to be defective. In any case, parts under warranty must be kept at Salvagnini's disposal: in case of non-fulfillment the parts shall be regularly invoiced.

If the repair of the defective part requires more than two days compared with the time needed for its replacement, the part will be in any case replaced.

Customer shall provide all requirements of Salvagnini at the system site, as requested by Salvagnini, without cost to Salvagnini, in connection with Salvagnini's inspection of and fulfillment of its warranty hereunder for the system, including (without limitation) customer personnel, suitable lifting facilities, work tools, electricity, compressed air and water, as well as telephone and telefax lines.

Salvagnini's warranty as to parts replaced or repaired hereunder shall not extend beyond the expiration of the original Warranty Period applied to the system. Salvagnini shall not be responsible for normal wear and tear, neglect or accident, abuse or improper use of the system or any part thereof, or malfunction due to unauthorized repairs or use of tools not supplied by Salvagnini or unauthorized replacement parts or supplies.

The warranty does not cover the following items:

- expendable materials such as oils, filter cartridges, lubrication grease and mechanical safety devices whose function is to break in certain circumstances;
- work tools such as punches, dies, cutting or bending blades, blankholder segments and counterblade;
- parts damaged by abuse, improper use, operator error, unauthorized repair or intervention by customer or third parties, or by the use of tools not supplied by Salvagnini.

Salvagnini guarantees the software only as far as the basic functions of the system are concerned, as described in the above technical description. The warranty does not cover all the functions and characteristics of the software.

The software of the system must not be modified; in particular the workstation configuration files must not be modified.

Certification of the product

The Salvagnini product is supplied with an EC conformity declaration issued in accordance with the following guidelines currently in force in the European Union:

- 98/37/CE Machine Directive (safety devices);
- 89/336/CEE Electromagnetic Compatibility Directive and relative amendments;
- 73/23/CEE Low-Tension Directive and relative amendments.

Machine color
The colors of our systems are:
- light gray RAL 7004 for the machine structure, the feeding and unloading connections;
- light gray RAL 7035 for the power cabinet;
- metallic gray for the outside safety covering;
- sea green for the connection elements of the safety covering;
- sea green for the anthropomorphic robot;
- metallic gray and sea green for the control pulpit.

Voltage
Our standard voltage is 400 Volts - 50 Hz.

Absorbed power:	P4-2516^{abt}	=	40 kW
	R81	=	11 kW

Packing
Our standard preparation for transport by truck is included in the price.
If a specific packing is requested this will be invoiced at cost price.

Exclusions
The above price does not include:
- oil for filling up of the hydraulic system;
- connection to your electric and compressed air supply systems (and the cooling water circuit if necessary);
- pipe for the connection between the machine and the self-contained cooling unit, if present;
- the foundations plates, the laying of these plates and any floor adaptation in the area of installation of the machines;
- special machining and modifications to the machine; in the case that during the feasibility study of the panels these modifications come out as necessary, they will be quoted separately;
- any other additional goods, work or services not explicitly mentioned in the description of the goods to be supplied.

We thank you again for placing your order with us.

Yours sincerely,

SALVAGNINI ITALIA s.p.a.

Francesco Scarpari
Managing Director

C.C.: Mac-Kenzie Plaatbewerkingsmachines BV

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