

NEWS RELEASE

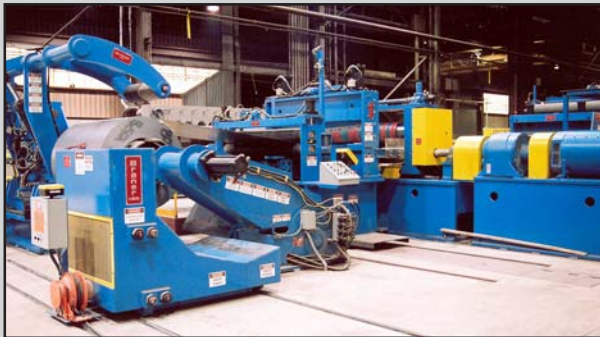
Marino/Ware Installs 72" Slitting & Automatic Packing Line

East Chicago, IN – Marino/Ware, a major manufacturer of metal framing components, has installed a Single-Loop Turret Head™ Slitting Line with an Automatic Slit Coil Packaging Line in its new manufacturing plant in East Chicago, IN. The new slitting line manufactured by Braner/Loopco, Schiller Park, IL, is designed to process 60,000# x 72" wide coated and non-coated carbon steel coil in gauges from .012" through .250" at line speeds to 1,500 FPM. The Packaging Line automatically handles slit coils up to 10,000# x 24" wide.



Single-Loop Turret Head™ Slitting Line

Wireless Coil Car Control: Entry and Exit Coil Cars are equipped with lightweight "wireless" operator controls that improve coil loading-unloading operations and improves safety. Elimination of the control cable gives attendants the freedom to select the best viewing positions while maintaining a safe distance from the Car and coil. Elimination of control cable maintenance is an added benefit.



Slitting Line Entry Section w/Wireless Car Control

Ultra-Precision Turret Head™ Slitter: The slitting line is equipped with a triple-head Turret Head™ Slitter equipped with three 9.000" quick-change ultra-precision slitter heads that allows Marino/Ware to quickly change heads and consistently produce slit coil with minimal slit edge burr to width tolerances of ± 0.002 ". The Braner/Loopco exclusive Turret Head™ Slitter design features unobstructed access to the slitter arbors, which makes tooling loading and unloading easier and faster than with any other multi-head slitter design. Re-tooled slitter heads are exchanged in less than 2-minutes with no cylinders, chains, or shuttle carts that require maintenance and consume floor space.



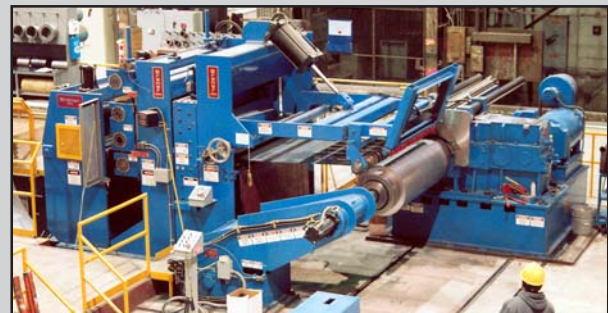
Three-Head 200 HP Quick-Change Turret Head™ Slitter

Scrap Handling: A unique scrap system allows Marino/Ware to automatically discharge edge trim scrap into a below-the-floor scrap container. A scrap elevator lifts the scrap container to floor level for quick removal by fork truck. Removing the overhead crane from scrap handling duties saves time and improves productivity. The roof of the elevator becomes a floor level platform while the line is running.



Hyd Scrap Elevator Allows Fast Fork Truck Dumpster Handling

"Loop-Control Tensioner": A patented Tension Stand with the ability to make adjustments to individual slit strip loops is an integral element of the Marino/Ware Turret Head™ Slitting Line. The "Loop-Control Tensioner" generates the strip tension necessary to wind tight straight-wall coils while adjusting the depths of individual strip loops, a feature that reduces looping pit depth requirements. In addition, a patented "Duplex" Roll Tensioner with two independent sets of tension rolls designed for processing "oiled" and "dry" surface critical materials is included. The two sets of tension rolls are mounted in a "quick-change" frame that allows pushbutton tension roll



Patented Loop-Control Tensioning System

changes in 2-minutes without the aid pushers, chains, cylinders, or indexing tables.

Automatic Coil Packaging: Slit coils produced by the Turret Head™ Slitting Line are automatically sorted and packaged. The Packaging Line has the capacity to handle slit coils weighing up to 10,000# in widths from 1" through 24".



Automatic Slit Coil Packaging System

A Wireless Coil Car transfers groups of slit coils from the Recoiler to a 4-Arm Horn at the entrance to the Packing Line. An automatic Downender separates and removes individual slit coils from the 4-Arm and downends the coils 90-degrees onto a conveyor rolls.



Automatic Slit Coil Downender

Multiple drive electric eye controlled power conveyor automatically stage and present coils to a Coiltech Semi-Automatic Strapping Machine where multiple radial straps are applied to the coil. The Coiltech Strapping Machine positions coils for 2, 3, or 4-radial straps on powered conical rolls. Semi-automatic coil strapping is accomplished at a production rate of 60-coils per hour.

The Coiltech Strapping Machine operator places coil package "spacer sticks" onto the strapped coil after completing the strapping process. The coil with the spacer sticks is conveyed into the Automatic Coil Stacker where the coil is automatically centered under a set of hydraulic "coil grippers". The coil grippers safely secure the coil from ID and OD, and the coil is lifted from the conveyor rolls and transported to a 6-station Coil Sorting Turntable. Color-coded stacking stations are operator selected and automatically positioned to receive coils from



Coiltech Coil Strapping Machine

the Stacker. Individual slit coils are sorted onto appropriate coil packages by indexing the Turntable. A "multi-coil" stacking program allows the Stacker to accumulate multiple narrow coils on the coil grab before the coils are transported to the stacking station. The multi-coil stacking program improves coil packaging efficiency by allowing the Stacker to transport multiple coils per trip to the stacking station.



Heavy-Duty Automatic Coil Stacker

Completed coil packages are rotated to an unloading station where the packages are transferred from the Turntable to a weigh station. The coil packages weights are recorded, and appropriate shipping tags are attached. The completed coil packages are transferred to a runout conveyor to await removal and shipping.



Coil Stacker, Turntable, Weigh Station, & Pack Runout

Heavy mill-duty construction, *bullet-proof reliability*, experience from building 560+ Slitting Lines, plus outstanding support make the choice of Braner/Loopco Slitting & Packing Lines a "no-brainer".



Braner USA, Inc., 9301 W. Bernice St., Schiller Park, IL 60176
Phone (847) 671-6210 Fax: (847) 671-0537
www.braner.com



4245 Railroad Avenue
East Chicago, IN 43612

Fax: 219-378-7105
Phone: 219-378-7100
www.marinoware.com