



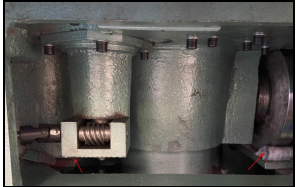


HSTP Lubrication Schedule

Part	Location	Image	Frequency	Type of Lubricant
Tooling Heads	The heads of Upper Punches and Lower Punches		Visually inspect and apply when dry	NLGI Grade 1
Tooling after cleaning	Air-tight container		After cleaning	Mineral oil
Tooling Barrels	The main shaft of the Tooling		Everytime Tooling is installed in press	SAE 10
Gearbox	On top of Gearbox through the shaft's bore		Visually inspect and top off when needed	460 Grade Worm Gear Oil



Part	Location	Image	Frequency	Type of Lubricant
Turret Drive Shaft Oil Wells	On top of machine		Visually inspect and apply when dry	SAE 10
Upper Roller Cams	Grease nipples on Upper Roller Cams in front and back of machine		Every 100 hours/once per week	NLGI Grade 2

Part	Location	Image	Frequency	Type of Lubricant
Lower Roller Cams	Felt pads underneath the Lower Roller Cams		Visually inspect and apply when dry	SAE 10