



**NEW BRITAIN MACHINE**

South Street, New Britain, Connecticut 06050 203 229-1641

May 2, 1977  
Ref. #4177-1

*Mod 40SH*

*Set 38964*

Gentlemen:

As an alternate to our Proposal Ref. #4177 dated April 18, 1977, we wish to offer our quotation covering a Model 40SH Friction Welding Machine.

We quote as follows:

One - Model 40SH Sliding Head, Hand Loaded, Single End Friction Welding Machine including fabricated steel base, welding head, self-centering clamp assembly and carriage, adjustable back-stop, automatic lubrication, machine sequence monitor, electrical controls

*new 1977*

PRICE

*(Capacity 5 square inches)*

\$ 72,620.00

Electrical Equipment

1	40 HP, DC Main drive, TEFC-BB Motor	\$ 2,265.00
1	20 HP Hydraulic drive, TEFC-BB Motor	1,025.00
1	Three-jaw hydraulically operated chuck	2,430.00
1	Hydraulic chucking cylinder	1,160.00
	Reduced pressure system	1,500.00
		<u>\$ 8,380.00</u>

Extra Machine Equipment

Additional clamp assembly mechanism to grip long tubes in place of using standard back-stop.

Price----- \$ 4,000.00

Tooling

Clamp jaws (1 set)  
Chuck jaws (1 set) Included in basic machine price

TOTAL PRICE \$ 85,000.00

Optional Machine Equipment

1 Infeed type flash removal slide \$ 10,500.00

The electrical control equipment offered and quoted above will comply with 1967 J. I. C. General Purpose (N.M.T.B.A.) electrical standards. If other deviations are required we will be pleased to advise the cost for your particular specifications when you are ready to place your order for this equipment.

Components supplied or specified by your company are to have dBA levels during full load operation that are 3dBA under their maximum permissible noise level.

This machine is shipped on a returnable aluminum skid. If this skid and the associated hardware is not returned to us within thirty (30) days, we will issue a debit memorandum for \$700.

If you wish to furnish your own motors, there will be a \$190 charge for each 20 HP motor and a \$270 charge for each 40 HP motor to cover handling and wiring.

The prices in this quotation are subject to an upward percentage adjustment at the time of shipment to reflect, on a one for one basis, the percentage increase in the Wholesale Industrial Price Index which is compiled monthly by the U. S. Department of Labor. The interval to be used in determining such adjustment will begin with the onset of the fourth (4th) month following the month of receipt of order and extend to the end of the second (2nd) month prior to the scheduled shipment month of the machine. Any upward adjustment will be limited to a maximum of one (1) percent per month of current purchase price. The machine invoice will contain only the percentage increase of the INDEX during the specified interval or the one (1) percent per month maximum, whichever is lower.

If you are interested in leasing, we are in a position to discuss such a plan with you.

The Terms and Conditions shown on the attached form, Pages 1 - 4, are a part of this proposal.

We undertake to provide a full metal to metal connection across the weld face within the confines of the minimum component diameter with the exception of any nonmetallic inclusions present in the parent material. Any particular physical properties required at the weld must be established and agreed to at an early stage by production of samples and testing. Acceptance properties might only be obtained by post weld treatment.

The customer shall supply all weldment materials for testing purposes. Materials for testing the machine must be at our works at least ten (10) weeks before the delivery date of the machine. Friction welding "burn-off" and forge allowances after welding tolerances and weld quality are to be confirmed after friction welded samples have been produced by us using the customer's weldment materials.

While the important friction welding parameters are monitored in order to alert the operator of machine malfunction, it is the customer's responsibility to ensure, by quality control procedures, that welds are produced within the accepted standards.

Metallographic examination of the weld will be used to assess weld quality.

Please note the attached comments regarding the Occupational Safety and Health Act of 1970. We request you review them and permit us to prepare a supplement as may be required to meet your requirements and specifications.

New Britain will provide a chart (N.M.T.B.A. form) with the sound pressure levels noted (dBA - slow response). If an octave band spectral analysis (time - frequency - decibel) is required, it will be provided at a cost of \$750 per machine.

If you require that the machine be painted to OSHA specifications, there will be an additional cost of \$200.

After a purchase order number has been placed, an order may not be canceled without our written consent. A minimum charge of \$2,000 will apply to any cancellation. With regard to additional costs incurred in the form of engineering, etc., please see paragraph under "Terms and Conditions".

Due to severe shortages and our inability to obtain certain brand items, we request your permission to substitute any preference you may have regarding fittings, valves, switches, etc. We will do our best to comply with your specifications, but your agreement in advance to substitution, if necessary, will be appreciated.

If we are favored with an order and new or revised part print drawings are submitted after engineering has started, all completed engineering work that cannot be used will be charged at the rate of \$16 an hour.

Thank you for this opportunity to quote on your machinery requirements.

Very truly yours,

NEW BRITAIN MACHINE DIVISION  
Litton Industrial Products, Inc.



C. G. Haughton  
Product Manager  
Friction Welding

/e  
Quoted in triplicate  
cc: Dayton Office  
cc: North Point Mchy.