

# Drilling

April 2014

The information below reflects the standards for this equipment. Please contact department manager for questions on projects that may fall outside of the standard. If you are unsure about any of the information, please check with manager or estimating.

**Flat Minimum N/A**

**Flat Maximum 20" Width  
MAY BE ABLE TO DO WIDER, BUT  
CHECK WITH PRODUCTION**

## Equipment Notes

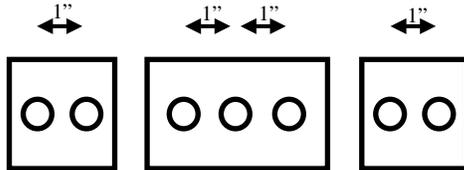
### St.Paul :

3 Heads (7 total Drill bits) 1" Center to Center

2 Heads (Outer) Can do up to 2 holes 1" Center to Center

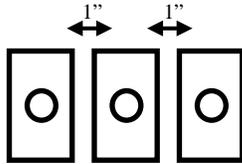
1 Head (Inner) Can do up to 3 holes 1" Center to Center

\*\* Drills Bits on each head CANNOT move, 3 Heads are moveable



### BP:

3 Heads (3 total Drill bits) minimum 1" Center to Center



### Caliper

2" Thickness

Remember to change your run speed if your total thickness doesn't divide evenly into 2"

### Modifiers

Name	MR Time	MR Waste	Run Speed	Run Waste
Additional Helper	N/A	N/A	N/A	N/A
Additional MR Minutes	Enter Additional Minutes	N/A	N/A	N/A
Additional MR Sheets	N/A	Enter Additional Sheets	N/A	N/A
Oblong Book	N/A	N/A	Reduce 10%	N/A

**Calculation:**

30 lifts/hour with 2" lift height

Examples:

16pg SC on 80# Gloss Text – Caliper of Text .0035 x 8 sheets = .014

2"/.014 = 142 x 30 = 4,260\*

352pg Book on 80# Gloss Text .0035 x 175 sheets = .6125

2"/.6285 = 4/hr **NOT 5**...x 30 = 120\*

\*Designated as “Minutes/Lift” in Section Finishing

Designated as “Run Speed” in Bound Components

Document owner to approve spec sheet. After approval, deliver to Estimating Manager for final review. Approval by document owner and Estimating Manager is needed for update of controlled form.