

# Configured Manufacturing Systems: Cultured Marble Manufacturing - Level 2

The “LEVEL 2” Cultured Marble Manufacturing System has been designed according to these assumptions:

1. Production of **Cultured Marble, Cultured Granite and Cultured Onyx**
2. Production capacity per 8 hour shift of **3000 kg (approx. 6613 lb)**

Three separate Cultured Marble/Onyx/Granite plant configurations are provided in this General Proposal, each assuming different capacity requirements:

**Level 1** - Production capacity per 8 hour shift of **1000 kg** (approx. 2,200 lb)

**Level 2** - Production capacity per 8 hour shift of **3000 kg** (approx. 6,613 lb)

**Level 3** - Production capacity per 8 hour shift of **8000 kg** (approx. 17,636 lb)

**Note:** Each of these plants can be modified or customized, or a completely customized plant can be designed for your needs. Contact your Globmarble sales representative to assist you with customization options.

A facility of this size requires approximately the following resources:

Manufacturing Area Required	1200 m <sup>2</sup> as shown / ~ 1600 m <sup>2</sup> with storage
Electrical Consumption	~ 250 Amps
Compressed Air Requirement	~ 225 CFPM (~382 m <sup>3</sup> /h)
Manpower Requirement	15 persons
Shipping Volume	91.44 cm x 12.192 m (3' x 40') container
Estimated Factory Ship Schedule	12-16 weeks

- The “as shown” number is the space requirements for what is shown on the drawings, but do NOT include space for Raw Materials Storage, Finished product movement (Finishing), or Finished Product Storage. Refer to the “with storage” number for estimated total space requirements including storage areas.

## Customer Services

The following services are likely required, but may vary according to the scope of the project.

For the purposes of developing a budgetary estimate, assume the following fees are likely.

The actual amount (if applicable) will be identified in the final design proposal.

- 1) Plant Design/Layout Services - To be determined and quoted in proposal.
- 2) Installation Supervision Services - To be determined and quoted in proposal.
- 3) On-Site Production Consultation - To be determined at a later date (if applicable).

**Cost (as configured) - excluding Customer Service fees if applicable.**

**Equipment: \$237,834.29 USD**

**Molds: \$69,809.74 USD**

**Supplies \$41,166.82 USD**

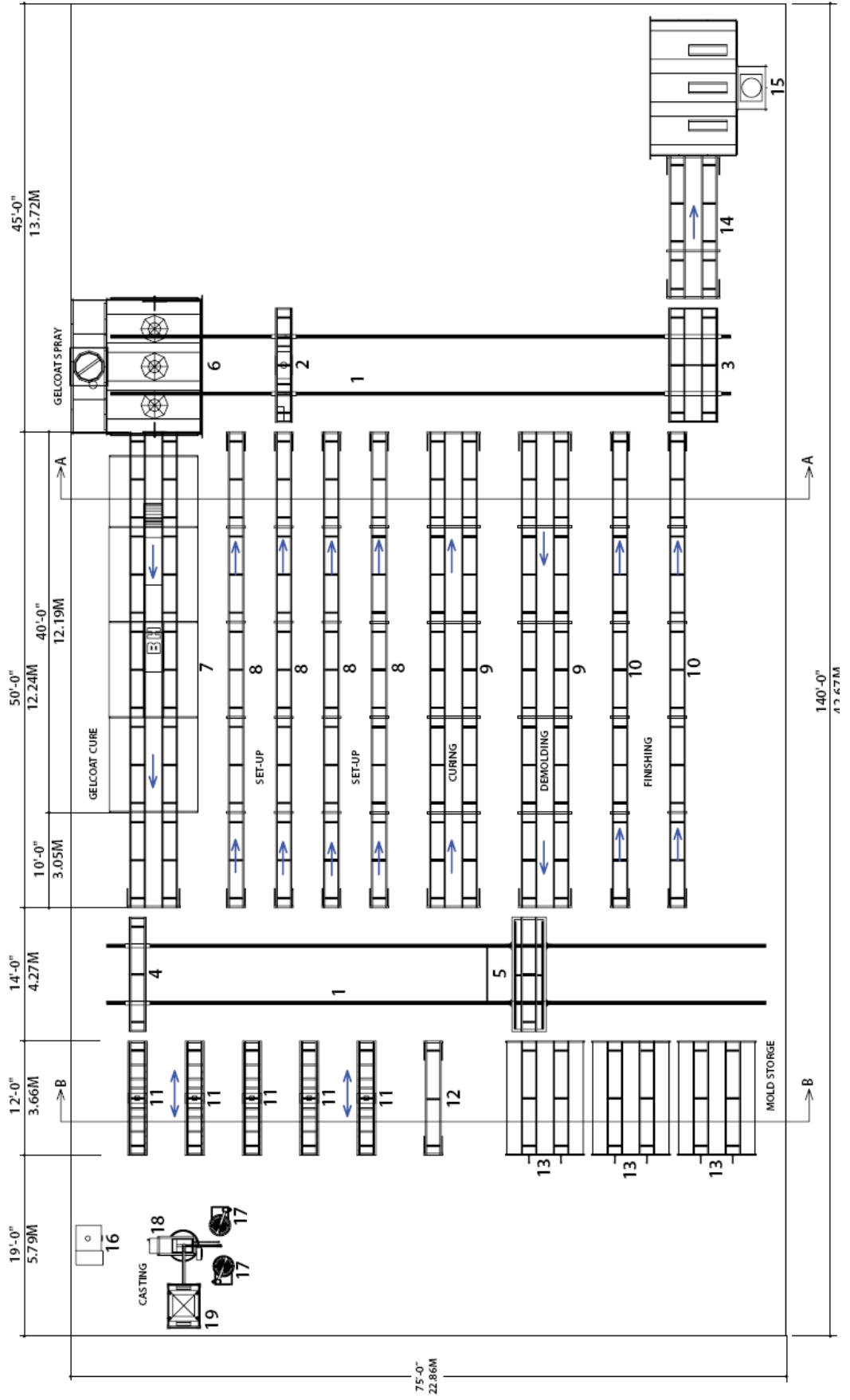
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**Total Ex factory: \$348,810.85 USD\***

*\* Excludes possible services identified in the Customer Services section above.*

# **Configured Manufacturing Systems: Cultured Marble Manufacturing - Level 2**

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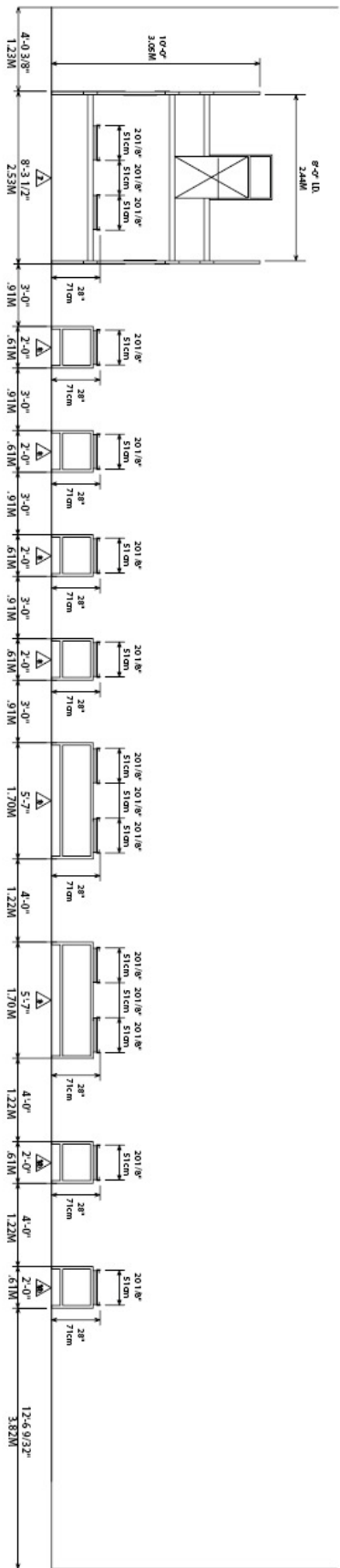
Note: Plan drawings do NOT provide any space for 1) Raw Materials Storage, 2) Finished product movement (Finishing), or 3) Finished Product Storage.



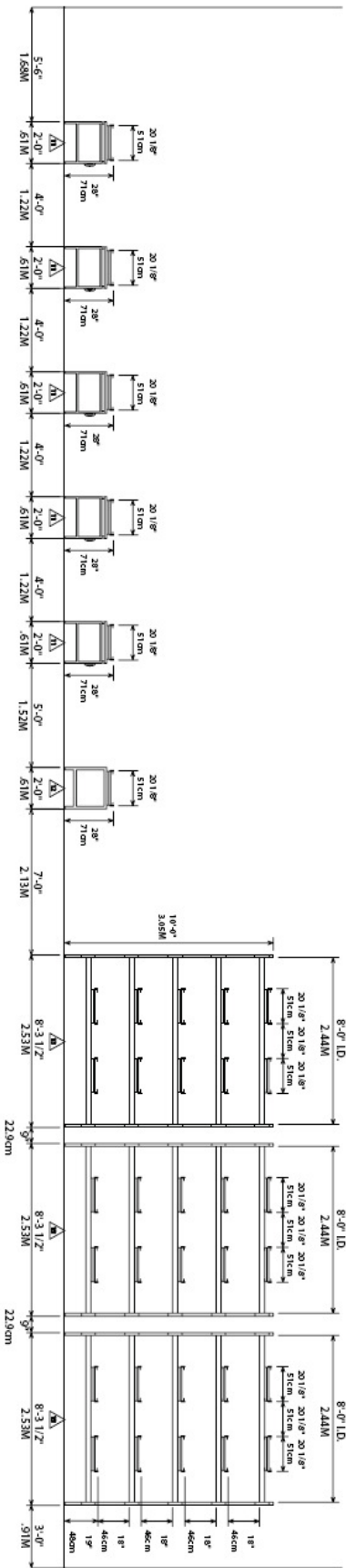
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*(continued)*

Note: Plan drawings do NOT provide any space for 1) Raw Materials Storage, 2) Finished product movement (Finishing), or 3) Finished Product Storage.



ELEVATION VIEW A-A

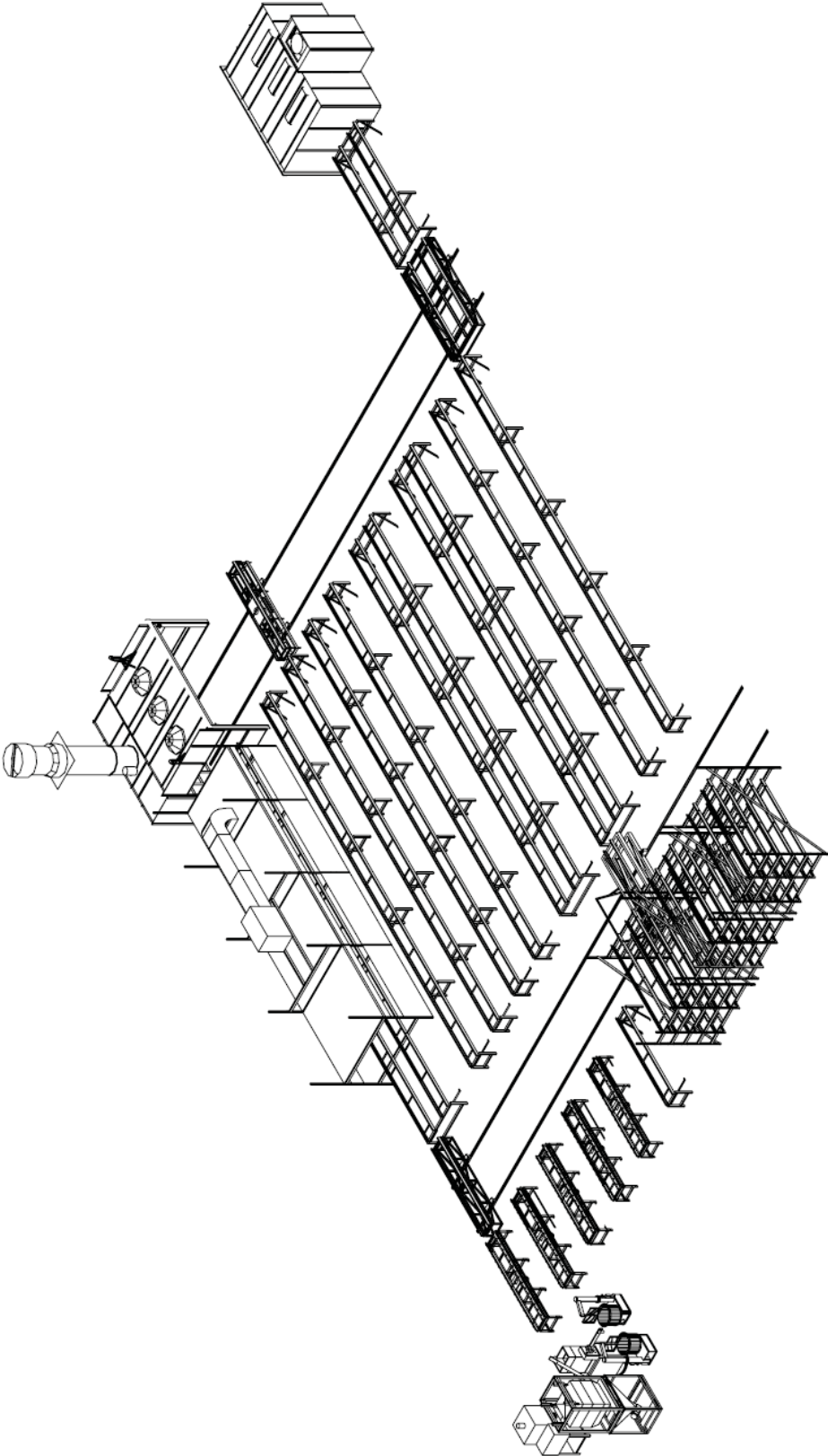


ELEVATION VIEW B-B

# **Configured Manufacturing Systems: Cultured Marble Manufacturing - Level 2**

*(continued)*

Note: Plan drawings do NOT provide any space for 1) Raw Materials Storage, 2) Finished product movement (Finishing), or 3) Finished Product Storage.



# Configured Manufacturing Systems: Cultured Marble Manufacturing - Level 2

(continued)

## Manufacturing Equipment Package

The following equipment products are recommended. Each is shown on the attached sample floorplan and equipment price list.

Dwg#	Part Number	Product Description	Qty
1	083087	Cart Track 10*	27
2	083161	Tilt/Rotate Gelcoat Cart, 12'	1
3	083079D	Double Wide Standard Exchange Cart, 12'	1
4	083079	Standard Exchange Cart 12'	1
5	110071	Hi-Boy Cart 12' with Battery Power	1
6	163847C	GF-14-7-9-1 Spray Booth Complete	1
7	GCEL9630S	Gelcoat Conveyor, ( _EL), 1L, 2W, 96" x 30' C	1
	GC9610	Gelcoat Conveyor, 1L, 2W, 96" x 10' Addition	1
	A1110	A-11 Conveyor 10' Addition	1
8	A510S	A-5 Conveyor 10' Complete	4
	A510	A-5 Conveyor 10' Addition	16
9	A1110S	A-11 Conveyor 10' Complete	2
	A1110	A-11 Conveyor 10' Addition	8
10	A510S	A-5 Conveyor 10' Complete	2
	A510	A-5 Conveyor 10' Addition	8
11	O831019	Vibration Table 12' with 3 Phase Tenv Electric Vibrator	5
12	A512S	A-5 Conveyor 12' Complete	1
13	MD5L9612	Conveyor, 5L, 2W, 96" ID x 12' Complete	3
14	A1110S A-11	Conveyor 10' Complete	1
	A115 A-11	Conveyor 5' Addition	1
15	164004CMB	CMB-14-7-8 Grind Booth	1
16	111469	Pot Washer, Marbleclean Machine with 4 Drums	1
17	190026	GS1350, Mixer, 3PH Sgl with Dolly	2
18	150131	Batchmaster III Batching Machine	1
30	BMCA	Batchmaster Catalyst System	1
	163770	Base Color System with Stand	1
	CMBCS-1C	Base Color System A/C - 1 Color	1
	180389	Scale Option Assembly, Weight Loss System, Batchmaster	1
19	150445B	Ground Hopper - Batchmaster	1
	150160	Frame, Standard Bulk Bag Suspender (Groundhopper)	1

\* Optional Mold Track included

**Total Manufacturing Equipment Package - \$237,834.29 USD**



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(continued)

## Production Mold Package

Part Number	Description	Qty	Um
<b>OVAL COLLECTION</b>			
29044M	Mark 44 Corner Tub 60"x 60" (Male)*	1	Each
490448M	F-Mark 44 Female	1	Each
22760M	170-9 Wall Panel 60"x 60" (Male)*	2	Each
20515M	110-NB-146 Countertop Deck (Male)*	2	Each
20074M	108-OL Opal Floating Bowl (Male)*	2	Each
400747M	FFF-OL Opal Bowl Female	2	Each
22855M	180-55 Opal Shampoo Holder (Male)	1	Each
428554M	FFL-180-55 Opal Shampoo Female	1	Each
22853M	180-53 Opal Paper Holder (Male)	1	Each
428544M	FFL 180-53 Paper Female	1	Each
<b>STANDARD PACKAGE</b>			
64104M	4104 Bathtub 1900mm x 720mm (Male)	2	Each
841048M	F-4104 1900mm Tub Female	2	Each
22790M	170-10 Wall Panel 32" x 60" (Male)*	2	Each
22777M	170-15 Tub Skirt 20" x 120" (Male)*	2	Each
22757M	170-6 Wall Panel 60" x 72" (Male)*	2	Each
20028M	108-N Laguna Floating Bowl (Male)**	4	Each
400287M	FFF-N Laguna Female	4	Each
22817M	180-17 Soap/Shampoo Holder	2	Each
428178M	FFO-180-17 Soap/Shampoo Holder Female	2	Each
22807M	108-7 Paper Holder (Male)	2	Each
428078M	FFO-180-7 Paper Female	2	Each
<b>MISCELLANEOUS MOLDS</b>			
22814M	Combination Trim (Male)*	2	Each
28101M	Oval Sample Mold 24 Cavity (Male)*	1	Each
22350M	4430-NB 146 Kitchen Deck (Male)*	2	Each

\* *Optional Mold Track included*

\*\* *Optional Overflow included*

**Total Production Mold Package - \$69,809.74 USD**

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(continued)

## Production Supplies Package

This comprehensive package of consumable supplies and fabrication tools is required in the daily manufacturing process. The quantity of supplies in this package is estimated to be sufficient to serve the initial start-up and commissioning period as well as the first 90 days production.

Qty	Part No.	Description	Qty	Part No.	Description
<b>TOOLS</b>			1	023040	FS-801DT Gram Beam Balance
1	GCG2H	Gelcoat Spray System	1	023051	FS-14-648-1 Stop Watch
1	100017	Pneumatic Clay Extruder	2	023052	FS-14-990c O-300 Thermometer
20	020400	Mil Gauge	2	023049	FS-13-700 Dropper - 144/pkg
10	01032	Waxing Tool #2	1	023042	FS-15 47416 Water Bath
10	01031	Waxing Tool #1	2		Stir Sticks - 1000/box
1	02007	Catalyst Dispenser	1	105-1117	2 Quart Spray System
4	02010	Grabber (Double)	1	105-1131	1 Quart Siphon System
8	102050	Air Polisher/Grinder	1	54-3918	Gun Wrench
4		Rubber Backing Pad	<b>CONSUMABLE SUPPLIES</b>		
4	102062	Grinding Disc Backing Plate	125	102061	7"x 7/8" 24-Grit Grinding Disc
4	100004	Buffing Brick Holder	100	020280	3" Buffing Pad
4	01017	Buffing Pad Cleaning Tool	100	02027	3" Grinding Disc
2	02008	Pneumatic Air Thing	50	010066	Wooden Wedges - Box/100
2	102080	Die Grinder/right Angle Head	25	010629	Gr Release 15 Oz - Case/12
4	020281	1/4" Collet	1	010633	Gr PVA Cnt 32 Oz - Case/6
4	020282	1/8" Collet Adaptor	1	010627	Gr Sealer 32 Oz - Case/10
4	020283	1/8" Grinding Tip Ball	2	010623	Gr Interphase Wax 32 Oz # Case/12
4	020284	1/8" Grinding Tip Cone			
4	020285	1/8" Grinding Tip Cylinder	1	010615	Gr Stripper 32 Oz - Case/12
4	020300	Rubber Mallet	8	01002	Plastic Dividers - 3/8"
2	02028	3" Backplate For Pad	3	001045	Oval Polycollar - Box/500
50	010063	Plastic Wedges	15	00026	Overflow Pipe - Box/100
			15	00108C	Beauty Rings Oval Chrome - Box/100
4	020430	Hole Saw, 7/8"	2	00005	Floating Unit Assembly - Box/1000
4	020461	Hole Saw, 1 1/8" & 1 1/4"	10	010138	Cotton Wipes/25 ct.
4	020465	Hole Saw, 1 3/8"	8	010164	Buffing Pads - 36/Case (50/50 Blend)
4	020439	Hole Saw, 2 3/8"	2	010152	Buffing Bricks/Barrel
4	020451	Hole Saw Shank, Small	10	010188	Masking Tape 2" - 24/Case
8	020452	Hole Saw Shank, Large	20	010184	Masking Tape 3/4" - 48/Case
150	103615	Gee Mold Clamp	5	010193	Spl. Dbl Act Mask Tape Case/48
20	01130	Standard Polydome	2	02210	Permoplast Tooling Clay Case/50 Lb
20	01124	Overflow Stem	2	02214	Ex-Wax Soft Case 24/lb
20	01127111	1/2" Stem Assembly	144	191088	Silicone Tube
10	020260	Pot Scraper	1	023011	Sandpaper - 600 Grit - Wet/Dry - 50 ct
2	191089	Caulking Guns	1	023012	Sandpaper - 400 Grit - Wet/Dry - 50 ct
25	023030	Pinch Clamps			

6	023033	3" Putty Knife	1	023013	Sandpaper - 320 Grit - Wet/Dry - 50 ct		
4	112097	2" Drum Gate Valve	1	023014	Sandpaper - 220 Grit - Wet/Dry - 50 ct		
20	102096	Pipe Clamp	1	023015	Sandpaper - 100 Grit - Garnet - 100 ct		
1	023036	Binks 31-295 Agitator	1	023016	Sandpaper - 80 Grit - Garnet - 50 ct		
2	023043	FS-08570-21E 250mil Cylinder - 8/pkg	1	023017	Sandpaper - 36 Grit - Garnet - 50 ct		
2	023044	FS-08570-21G 1000mil Cylinder - 4/pkg	(Note: this list does not include raw materials)				
2	023048	FS-02593-50C 250 Mil Beaker - 100/Case	Total Production Supplies Package - \$41,166.82				
2	023058	FS-02593-50F 1000 Mil Beaker - 100/Case	USD				
1	023038	FS-02-117 Platform Scale					