

# Configured Manufacturing Systems:

## Cultured Marble Manufacturing - Level 1

The “**LEVEL 1**” **Cultured Marble Manufacturing System** has been designed according to these

assumptions:

1. Production of **Cultured Marble, Cultured Granite and/or Cultured Onyx**
2. Production capacity per 8 hour shift of **1000 kg (approx. 2,200 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 560 m <sup>2</sup> as shown / ~ 750 m <sup>2</sup> with storage
Electrical Consumption ~ 100 Amps
Compressed Air Requirement ~ 125 – 150 CFPM (212 - 255 m <sup>3</sup> /h)
Manpower Requirement 8 persons
Shipping Volume 91.44 m x 6.1 m (3' x 20') 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).

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

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*(continued)*

10000 sq ft

30'-0" 14'-0" 24'-6" 13'-0"

1.07M 4.27M 4.27M 3.96M

9.14M 7.47M

50'-0" 15.24M

24'-0" 7.32M

1 2 3 4 5 6 7 8 9 10 11 12 13 14 15 16 17 18 19 20 21

MOBILE CART MOBILE CART MOBILE CART

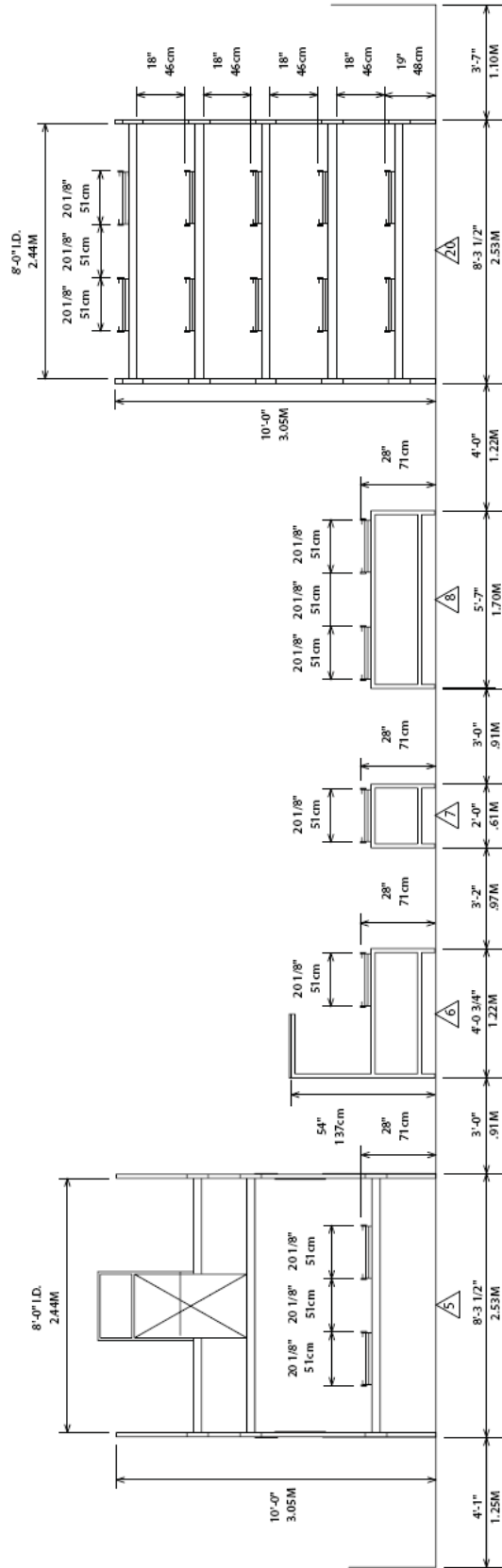
A B

120'-0"
36.57M

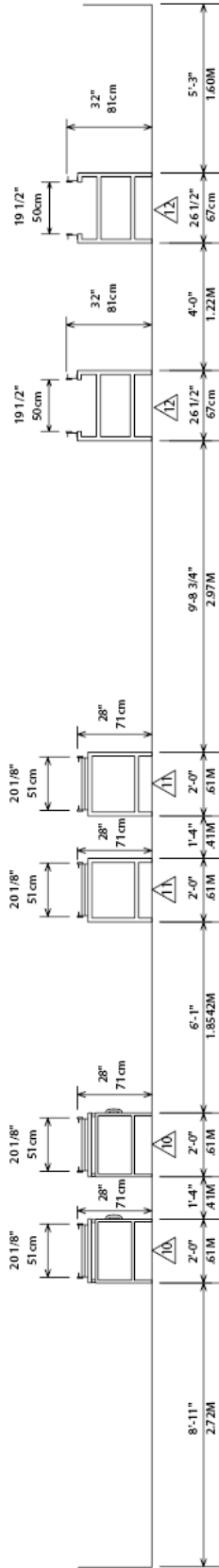
# **Configured Manufacturing Systems: Cultured Marble Manufacturing - Level 1**

*(continued)*

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



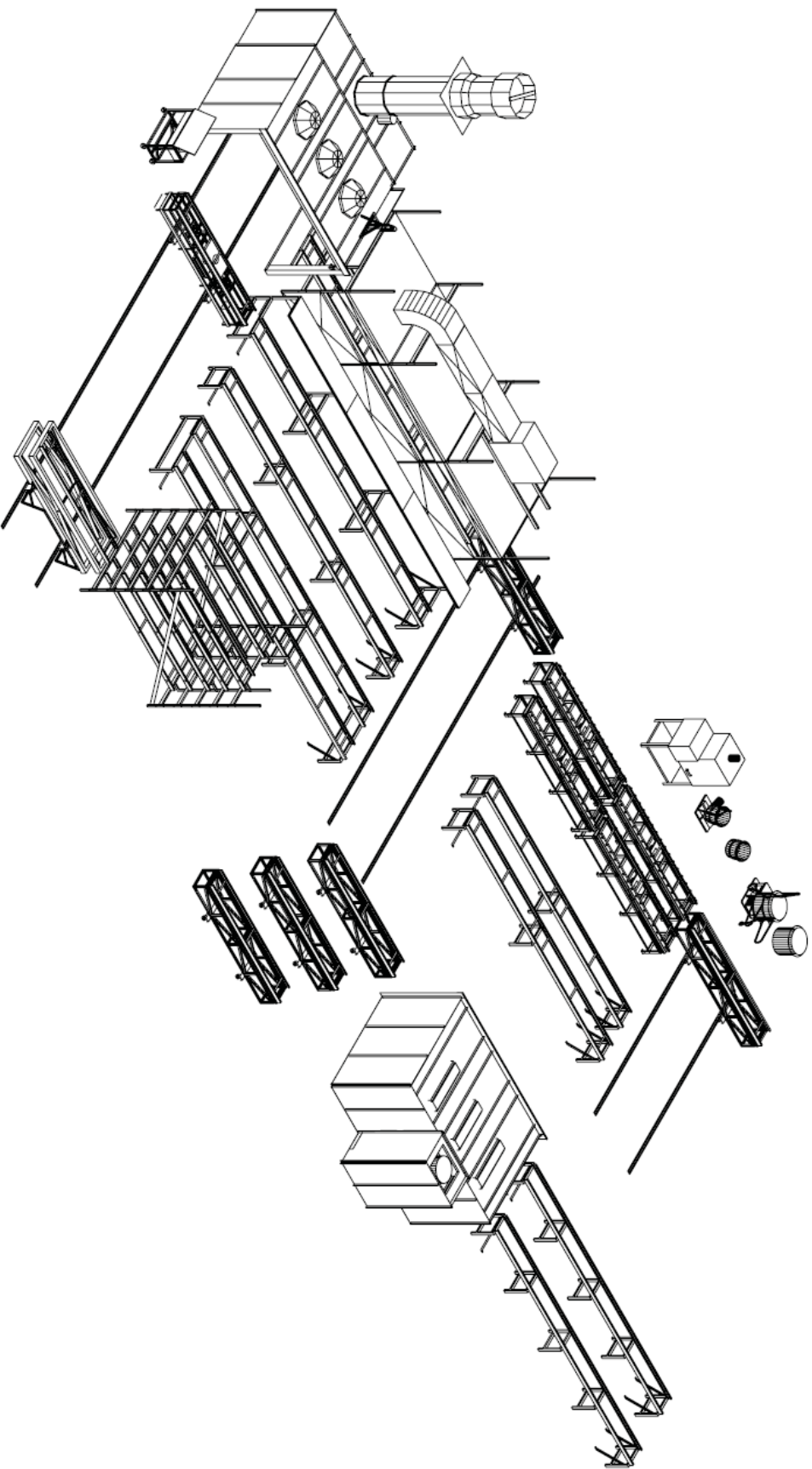
ELEVATION VIEW A-A



# **Configured Manufacturing Systems: Cultured Marble Manufacturing - Level 1**

*(continued)*

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# Configured Manufacturing Systems: Cultured Marble Manufacturing - Level 1

(continued)

## Manufacturing Equipment Package

The value in the Dwg# column indicates that designated item in the floorplan drawing.

Dwg#	Part Number	Description	Qty	UM
1	110311	Solvent Wash Tank	1	EA
2	083087	Cart Track 10'	19	EA
3	083161	Tilt/Rotate Gelcoat Cart - 12'	1	EA
4	163847C	GF-14-7-9 Spraybooth -1 Door	1	EA
5	GCEL9630S	Gelcoat Conveyor, EL, 1L, 2W, 96" x 30' C	1	EA
6	A810S	A-8 Conveyor 10' Complete	1	EA
6	A810	A-8 Conveyor 10' Addition	2	EA
7	A510S	A-5 Conveyor 10' Complete	1	EA
7	A510	A-5 Conveyor 10' Addition	2	EA
8	A1110S	A-11 Conveyor 10' Complete	1	EA
8	A1110	A-11 Conveyor 10' Addition	2	EA
9	083079	Standard Exchange Cart 12'	2	EA
10	083081	Vibration Table 12' with Pneumatic Vibrator	4	EA
11	A510S	A-5 Conveyor - 10' Complete	2	EA
11	A510	A-5 Conveyor 10' Addition	2	EA
11	A55	A-5 Conveyor 5' Addition	2	EA
12	F510S	F-5 Conveyor 10' Complete	2	EA
12	F510	F-5 Conveyor 10' Addition	2	EA
12	F55	F-5 Conveyor 5' Addition	2	EA
13	110237	Blender, 100 lb, 1PH/60HZ	1	EA
14	110244	Pot, 100 lb Stainless Steel Mixing Vessel	1	EA
15	103503	Mixer, 350 lb, 240/3PH/60 W/Dolly	1	EA
16	103504	Pot, 350 lb Stainless Steel Mixing Vessel	1	EA
17	111680	GS1500 Marbleclean Machine w/4 Drums	1	EA
18	164004CMB	CMB-14-7-8 Grind Booth	1	EA
19	110071	Hi-Boy Cart 12' with Battery Power	1	EA
20	MD5L9612	Conveyor, 5L, 2W, 96" ID x 12' Complete	1	EA
21	0831162	Mobile Mold Cart	3	EA

\* Price quoted includes required crating for selected equipment

**Total Manufacturing Equipment Package - \$118,989.86 USD**



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## Production Mold Package

Part Number	Description	Quantity	UM
29044M	Mark 44 Oval 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
20074M	108-OL Opal Floating Bowl With Optional Oval Overflow (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
64104M	4104 Bathtub 1900mm x 720mm (Male)	1	Each
841048M	F-4104 1900mm Tub Female	1	Each
22790M	170-10 Wall Panel 32" x 60" (Male)	1	Each
22777M	175 Tub Skirt 20" x 120" (Male)	1	Each
22757M	170-6 Wall Panel 60" x 72" (Male)	1	Each
20028M	108-N Laguna Floating Bowl With Optional Oval Overflow (Male)	2	Each
400287M	FFF-N Laguna Female	2	Each
22817M	180-17 Soap/Shampoo Holder (Male)	1	Each
428178M	FFO-180-17 Soap/Shampoo Holder Female	1	Each
22807M	108-7 Paper Holder (Male)	1	Each
428078M	FFO-180-7 Paper Female	1	Each
20515M	110-NB-146 Lavatory Countertop (Male)	1	Each
22814M	Combination Trim (Male)	1	Each
28101M	Oval Sample Mold 24 Cavity (Male)	1	Each
23134M	Table Top 54" Round (Male)	1	Each
23108M	Table Top 36" Round (Male)	1	Each
23104M	Table Top 20" Round (Male)	1	Each

\* Optional Mold Track included.

\*\* Optional Overflow included.

Crating is included as required.

**Total Production Mold Package - \$44,442.20 USD**

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## 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.

Part No.	Description	Qty	Um				
<b>TOOLS</b>							
GCG2H	Gelcoat Spray System	1	Each	023038	FS-02-117 Platform Scale	1	Each
100017	Pneumatic Clay Extruder	1	Each	023040	FS-801DT Gram Beam Balance	1	Each
020400	Mil Gauge	20	Each	023051	FS-14-648-1 Stop Watch	1	Each
01032	Waxing Tool #2	5	Each	023052	FS-14-990C O-300 Thermometer	1	Each
01031	Waxing Tool #1	5	Each	023049	FS-13-700 Dropper - 144/pkg	1	Pack
02007	Catalyst Dispenser	1	Each	023042	FS-15 47416 Water Bath	1	Each
02010	Grabber (Double)	4	Each	020261	Stir Sticks – 1000/box	1	Each
102050	Air Polisher/Grinder	4	Each	G100	Spray Cup Gun W/ #6 Nozzle	1	Each
	Rubber Backing Pad	5	Each	G200	32oz Paper Cups 25/sleeve	1	Each
102062	Grinding Disc Backing Plate	5	Each	<b>CONSUMABLE SUPPLIES</b>			
100004	Buffing Brick Holder	2	Each	102061	7"x 7/8" 24-grit Grinding Disc	25	Each
01017	Buffing Pad Cleaning Tool	2	Each	020280	3" Buffing Pad	25	Each
02008	Pneumatic Air Thing	1	Each	02027	3" Grinding Disc	50	Each
102080	Die Grinder - Right Angle Head	1	Each	010066	Wooden Wedges/100	20	Each
020281	1/4" Collet	2	Each	010629	Gr Release Wax 15 oz	5	Each
020282	1/8" Collet Adaptor	2	Each	010633	Gr PVA Cnt 32 oz - Case/6	1	Each
020283	1/8" Grinding Tip Ball	2	Each	010627	Gr Sealer 32 oz - Case/10	4	Each
020284	1/8" Grinding Tip Cone	2	Each	010623	Gr Interphase Wax 32 oz		
020285	1/8" Grinding Tip Cylinder	2	Each		- Case/12	1	Each
020300	Rubber Mallet	2	Each	010615	Gr Stripper 32 oz - Case/12	1	Each
02028	3" Backplate For Pad	1	Each	01002	Plastic Dividers 3/8"	2	Each
010063	Plastic Wedges	15	Each	00104-5G	Oval Polycollar - Box/500	1	Each
020430	Hole Saw, 7/8"	2	Each	00026	Overflow Pipe - Box/100	10	Each
020461	Hole Saw, 1-1/8" & 1-1/4"	2	Each	00108C	Beauty Rings Oval - Chrome/100	5	Each
020465	Hole Saw, 1 3/8"	2	Each	00005	Floating Unit Assembly/1000	1	Each
020439	Hole Saw, 2 3/8"	2	Each	010138	Cotton Wipes - 25/lb Box	5	Each
020451	Hole Saw Shank, Small	2	Each	0101652	Buffing Pads - 36/case	4	Case
020452	Hole Saw Shank, Large	4	Each	010152	Buffing Bricks - 1 Barrel (____ pcs)	1	Each
103615	Gee Mold Clamp	25	Each	AM010188	Masking Tape 2" - 24/case	5	Each
01130	Standard Polydome	20	Each	AM010184	Masking Tape 3/4" - 48/case	10	Each
01124	Overflow Stem	10	Each	X010193	Spl. Double Act Masking Tape - Case/48	2	Each
011271	11-1/2" Stem Assembly	10	Each	02210	Permoplast Tooling Clay Case/50 Lb	5	Each
020260	Pot Scraper	10	Each	02214	Ex-Wax Soft Case - 24/lbs	1	Each
191089	Caulking Guns	1	Each	191088	Silicone Tube	20	Each
191894	Pinch Clamps	50	Each	023011	Sandpaper - 600 Grit Wet/Dry - 50 ct	1	Each
023033	3" Putty Knife	6	Each	023012	Sandpaper - 400 Grit Wet/Dry - 50 ct	1	Each
112097	2" Drum Gate Valve	2	Each	023013	Sandpaper - 320 Grit Wet/Dry - 50 ct	1	Each
102096	Pipe Clamp	10	Each	023014	Sandpaper - 220 Grit Wet/Dry - 50 ct	1	Each
111816	Binks 31-295 Agitator	1	Each	023015	Sandpaper - 100 Garnet - 100 ct	1	Each
				023016	Sandpaper – 80 Garnet - 50 ct	1	Each
				023017	Sandpaper – 36 Garnet - 50 ct	1	Each
023043	FS-08570-21E 250 Mil Cylinder 8/pkg	1	Pack	<b>Total Production Supplies</b>			
023044	FS-08570-21G 1000 Mil Cylinder 4/pkg	1	Pack	<b>Package -</b>			
023048	FS-02593-50C 250 Mil Beaker 100/case	1	Case	<b>\$24,330.68 USD</b>			
023058	FS-02593-50F 1000 Mil Beaker 100/cs	1	Case				