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ÖSTERREICH

Valley, 05.09.2005
10042 / MF

Final Report

We hereby confirm that Mr. Santosh V. Subbaiah has hold the three days COPRA® RollForm training to Mr. Johnny G. Tadros and Mr. Ayman El Sayed for the software modules

COPRA® RollDesign Husk
COPRA® Tube Mill Roll Design Centre

at Tuborco S.A.E. Steel Tubes from June 27th to 29th, 2005 as specified in the Contract No. 2005/013, Project No. TF/EGY//03/002, Purchase Order No. 16000817.

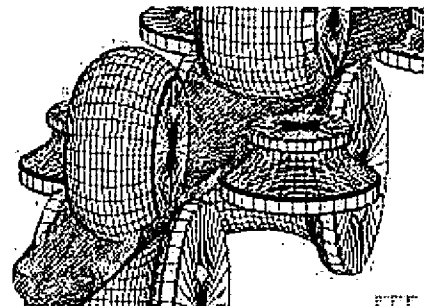
Please find following a comprehensive description of the software's performance and utilizations, content of the training activity and the appraisal of the trainees ability to operate the software:

Description of the COPRA® software

M3 COPRA® Professional Tube Mill Roll Design Center

The COPRA® Professional Tube Mill Roll Design Center is the advanced and worldwide leading software package for tube mill roll design. It includes features as...

- Project manager
- Data base archiving
- Machine data setup
- Setup for forming methods (circular, 2-radius, W-forming, 4-radius, oval welding shape or others...)
- Forming strategy setup
- Setup of forming parameters
- Roll design setup



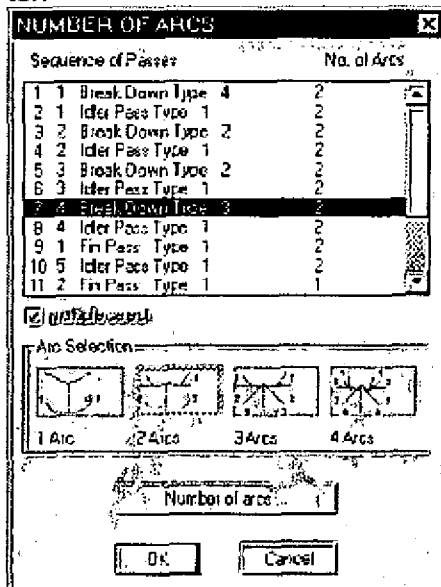
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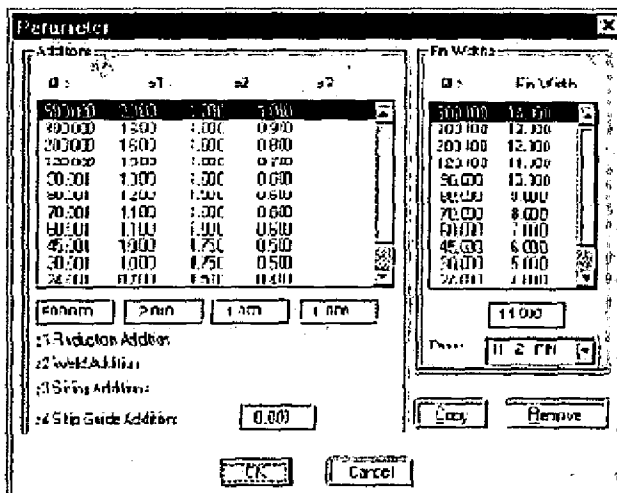
•The flower setup can be done in a very flexible way. One section may consist of as much as 8 different arcs. For every individual arc angle, radius and arc length can be defined separately.

•For the fin passes it is also possible to define the fin- width dependent on the tube diameter.



•Material additions such as profiling-, sizing-, welding- and strip guide additions can be entered depending on the tube diameters.

•The design of the rolls can also be done diameter-dependent. This guarantees highest flexibility for the setup of fillet radii and chamfers.



Easy and user friendly definition of material additions...

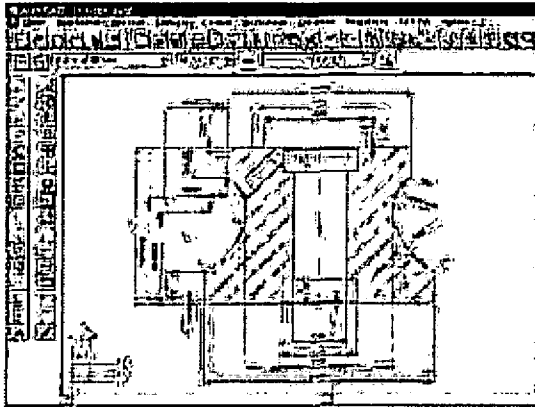
- COPRA® also includes a software program for the calculation of the optimum down-hill forming curve.
- It has been shown that the widespread opinion that a constant gravity point was the optimum forming method is wrong.
- A special purpose optimization program provides the possibility to minimize material strain. With this option the optimum forming curves for the individual passes (including cage forming) can be determined.
- Leading roll forming and tubing companies have been using this software all over the world

COPRA® Roll Design Husk (H1)

An accurate and sound design of roll tooling is - as well as the design of the flower pattern - decisive for the quality and manufacturing costs of a roll formed section. COPRA® is offering in its roll editor a variety of features for an effective roll tool design.

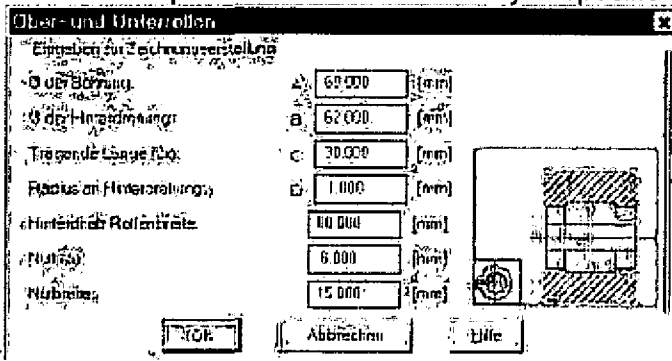
Following some examples of features implemented:

- ▣ automatic or interactive definition of machine axes
 - ▣ automatic definition of tool contour layout (not just for open shapes but for even complex contours as well as side rolls etc.)
 - ▣ both - interactive or automatic
 - ▣ large number of editing functions
 - ▣ COPRA® offers you several methods to generate roll tools for a specific profile shape.
 - ▣ as COPRA® is completely integrated in AutoCAD the user can choose from both - COPRA® internal or AutoCAD editing commands (best of both worlds...)
 - ▣ For designer who used to work with DOS programs:
COPRA® does also have a list editor
 - ▣ Lines are not just drawn as a contour in the CAD system (as usual in CAD systems) but each roll is stored in the COPRA data base - as a separate object
 - ▣ automatic single roll dimensioning
 - ▣ automatic assembly plan dimensioning
 - ▣ design of combination tool sets (in module roller technology)
 - ▣ fully automatic roll design and detailing for hat, U-type or C-Channels
 - ▣ you will hardly find a similar number of roll form specific feature in any other software
 - ▣ COPRA® has got a (optional) data base management system which allows for a company wide management of roll tool and profile data - including QM data. data M Software has got a long experience in roll data management - starting from PCs up to midrange server technology. We have got the solution for your needs. Just contact us.
- Automatic dimensioning of roll drawings
- ▣ both - single roll drawings as well as assembly plans
 - ▣ dimensioning strategies can be set by the user



fully automatic dimensioned roll drawing

The parameters required can be defined easily in specific dialogue



boxes:
Side roll Parameters

Content of the COPRA® Rollform Software training

Conducted at Company:

Tuborco S.A.E. Steel Tubes,
New borg el Arab City,
Second Industrial Zone Block no. 9,
Alexandria, EGYPT

Software Modules:

COPRA® Roll Design Husk,
COPRA® Tube Mill Roll Design Centre.

Trainees:

Mr. Johnny G. Tadros
Mr. Ayman El Sayed.

Training dates:

28th – 30th June, 2005.

Place of Training:

At company address as mentioned above.

Contents of the Training:

1. Initialise COPRA® - Toolbar "COPRA®"
2. COPRA® Basic Settings
 - 2.1. Pass- and Roll numbering
 - 2.2. COPRA® - Technology for data export
 - 2.3. COPRA® - Options
3. The COPRA® CAD-Finder
 - 3.1. Create a new project
 - 3.2. Roll attribute File
4. Design a New Tube Mill
 - 4.1. Define sequence of forming steps
 - 4.2. Machine Layout
 - 4.2.1. Tubemill Layout
5. Forming strategy
 - 5.1. List of Additions
 - 5.2. Explanation of Additions

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- 5.2.1. Sizing Additons
- 5.2.2. Reduction Addition
- 6. Strip Width Calculation
 - 6.1. Define the Forming Strategy
 - 6.2. Number of Arcs
 - 6.3. Calculations
 - 6.3.1. Calculations for station 1 to 8
 - 6.3.2. Calculations for station number 9 to 13
 - 6.4. Idler passes between Fin Passes
 - 6.5. Enter the forming angles Flower design
 - 6.6. Fin Width
 - 6.6.1. Adapt parameters for fin width 26
 - 6.6.2. Adapt parameters for fin width 15
 - 6.6.3. Adapt parameters for fin width 8
 - 6.7. Calculate the flower
 - 6.8. Optimize Flower
- 7. Simulation
 - 7.1. How to get a simulation diagram
- 8. Optimize with Downhill forming
 - 8.1. Save an Archive File
- 9. Roll Design
- 10. Modify Rolls
 - 10.1. Optimize station number 1
 - 10.2. COPRA® Explorer
 - 10.3. Modify station number
 - 10.4. Station number 3
 - 10.5. Station number 4
 - 10.6. Station number 5
 - 10.7. Modify station number 6
 - 10.8. Modify Station number 7
 - 10.9. Station number 8 and 9
 - 10.10. Station number 10
 - 10.11. Station number 11
 - 10.12. Modify station number 12
 - 10.13. Station number 13
 - 10.14. Modify station number 14
 - 10.15. Modify station number 15
 - 10.16. Station number 16
 - 10.17. Modify station number 17
 - 10.18. Station 18

- 10.19. Modify station number 19
- 11. Define Roll attributes
 - 11.1. Default attributes
 - 11.2. Single roll attributes for turk head
 - 11.3. Display of roll accessories
- 12. Individual RollNumbering
 - 12.1. Disable COPRA® Station Numbering
 - 12.2. Start Individual Roll Numbering
 - 12.2.1. Shortcuts
 - 12.2.2. Set for Project
- 13. Station Attributes
 - 13.1. Station number 0 = Entry Guide
 - 13.2. Station Subtype
- 14. Roller weight – automatically saved to CADFinder
 - 14.1. Sawing List – automatically saved to CADFinder
- 15. Single roll dimensioning
 - 15.1. Attributes in Template
 - 15.2. Start Single Roll Dimensioning
 - 15.3. Enable Attributes from Template in COPRA®
 - 15.3.1. Project Info
 - 15.3.2. Machine Info
 - 15.3.3. Roll Info
 - 15.3.4. Paper Info
 - 15.4. CADFinder
 - 15.5. Roll drawings in CADFinder

Appraisal of the trainees:

After the training program on Second day, the trainees were able to input the actual details of their machines and do the designs of rolls as per the desired specifications. The trainees are familiar with the functionality available in the software modules they have purchased and have understood that they would need to practice with more real time design to make the best use of the software.

data M Software GmbH



Albert Sedlmaier
Managing Director

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Software Maintenance and Support Agreement

between

Tuborco S.A.E. Steel Tubes, Egypt

&

data M Software GmbH, Germany

This agreement is between Tuborco S.A.E. Steel Tubes, New borg el Arab City, Second Industrial Zone Block no. 9, Alexandria, Egypt hereinafter called TUBORCO and data M Software GmbH, Am Marschallfeld 17, D-83626 Valley/Oberlaindern, Germany hereinafter called data M.

The following stipulations apply to the maintenance and support of data M-Software.

data M has supplied to TUBORCO following COPRA[®] Roll Forming software modules

- M3 COPRA[®] Tube Mill Roll Design Centre
H1 COPRA[®] Roll Design Husk
Dongle No. 3364, 1 licence to use; OS- and CAD-Software used: MS Windows; AutoCAD software (MS Windows and AutoCAD are not part of this agreement)
- based on Contract No. 2005/013, Purchase Order No. 16000817, undersigned on June 8, 2005
- Yearly price for maintenance and support of above modules: EUR 3,440.00
- The Maintenance and Support Contract is starting with July 1st, July 2005 and ends on June 30th, 2006.

The term of the maintenance and support agreement is one year.

This maintenance and support fee shall be paid yearly in advance at the beginning of the contract.

TUBORCO will be entitled to free update of the above-mentioned modules of COPRA[®] Roll Forming software.

data M will use all its available resources, to answer TUBORCO's questions within its means. Support is limited to the programs resp. those parts that are required to work with COPRA[®] Software. Further problems with operating system, data base or Hardware, being independent of COPRA[®], are not covered by the maintenance and support agreement. data M's support department may be contacted via Telefax, Post or E-Mail (preferred). In case of emergency also by phone.

Tuborco Factory

The place of legal settlement for any disputes between the parties to this agreement shall be Miesbach. This agreement shall be subject to the law of the Federal Republic of Germany.


This agreement is signed by TUBORCO and data M in confirmation of the points mentioned above.

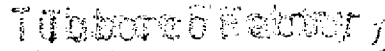
Valley/Oberlindern, 11/07/05
(location, date)

Alexandria, 29/06/2005
(location, date)

data M Software GmbH

Tuborco S.A.E. Steel Tubes


Am Marschallfeld 17
D-83626 Valley
Germany
Tel. (08004) 640-0
Fax (08004) 640-300
data M Software GmbH
(stamp/signature)


Johns
(stamp/signature)

TUBORCO FACTORY
Steel Pipes & Green House



مصنع تيوبوركو
“ واسير المعدنية والصوبات الزراعية ”

Certificate of Receipt

We hereby confirm the receipt of the documentation and the unlimited code for software

COPRA® Roll Design Husk
COPRA® Tube Mill Roll Design Centre

in compliance with Contract No. 2005/013, Purchase Order No. 16000817, undersigned on June 8, 2005.

Alexandria, June 27th, 2005

Tuborco S.A.E. Steel Tubes

Tuborco Factory

Johanne

مدينة برج العرب الجديدة - المنطقة الصناعية الثانية - جزء من بلوك ٩ مصنع ، ٠٣ / ٤٥٩٣٦١٨ - ٠٣ / ٤٥٩٢٢٧٨ - فاكس : ٠٣ / ٤٥٩٣٨٧٤
سجل تجارى : ١١٨٨٧٩ - بطاقة ضريبية : ١٦٠٧ مأمورية ضرائب الشركات المساهمة أول

Factory : New Borg El-Arab City - Second Industrial Zone - Blok No. 9 Tel. Fac : 03/4593618 - 03/4592278 - Fax : 03/4593874



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