OPERATING & MAINTENANCE INSTRUCTIONS

Rollmaster II™

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AeroGo©

1170 Andover Park West
Seattle, WA USA 98188-3909
Phone: (206) 575-3344
Fax: (206) 575-3505
www.aerogo.com
info@aerogo.com

AeroGo, Inc is a leading designer and manufacturer of Aero-Caster™ products (air casters or air bearings mounted on Standard or Custom products) that float from 500 lbs to 5000 tons on a virtually frictionless film of air.

AeroGo air caster product manufacturing practices are ISO certified by ABS Quality Evaluations, Inc and complies with SAE AS9003: 2001 and ISO 9001:2000 quality standards.

ISO 9001:2000 certified #34629
SAE AS9003 certified #40102

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Rollmaster Operating Specifications **Please record this information for your roll handling system – it will help during setup and operation**				
RC				
Rollmaster	Capacity (tons)	Target Roll Diameter	Aero-Caster® type	Fork Length (in)

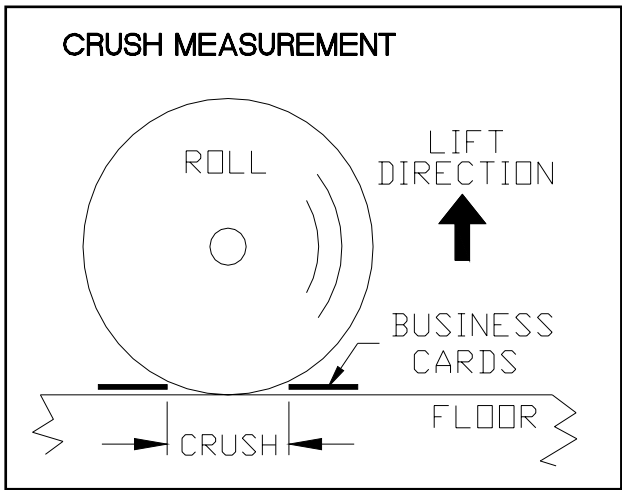
There is also a label on your roll-handling unit that specifies the roll dimensions that your AeroGo Rollmaster II will handle, i.e. RC4A46N42.

Rollmaster II™

HANDLING PAPER ROLLS – "CRUSH"

Since the Rollmaster II lifts a roll from its outside diameter, sizing the Rollmaster II is based on roll diameter and "crush". The Rollmaster II was built to a single Target Roll Diameter specified by you, the customer. It will handle a range of roll sizes beyond this target based on the roll "crush" (and floor conditions).

Crush Measurement: Place two business cards on the floor and move them in towards the roll until they are stopped between the roll and floor. Measure the distance between the business cards. This is the "Crush" dimension.



Model Example: For a 5,000–pound (2,270 kg) roll with a 46-inch (117 cm) diameter, a 37-inch (94 cm) roll web width, and a 2-inch (51 mm) crush, a correct Rollmaster model would have a 46-inch (117 cm) Target Diameter and a 42-inch (117 cm) Fork Length (Fork lengths begin at 24 inches (61 cm) and increase in 6-inch (15 cm) increments). The Rollmaster would handle roll diameters from 44-48 inches (117 cm – 122 cm) (46 +/-2) as long as the crush was 2 inches (51 mm) or less.

RC	4A	46	N	42
Rollmaster	Capacity (tons)	Target Roll Diameter	Aero-Caster® type	Fork Length (in)

ROLLMASTER ASSEMBLY

The AeroGo© Rollmaster II usually comes assembled, less the handle. To install the handle:

1. If you ordered a Rollmaster with throttle control then connect the two small hoses.
2. Connect colored hoses together (same color to each other) and insert into holes.
3. Bolt handle to the base of the Rollmaster. Caution: Do not pinch small colored hoses during this operation.

When complete, connect the Rollmaster unit to compressed shop air (see *Connecting Air*).

NOTE: BEFORE CONNECTING EQUIPMENT TO AIR OR OPERATING, READ ALL INSTRUCTIONS – INCLUDING SAFETY

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ROLLMASTER QUICK START GUIDE

1. Ensure that all hoses and fittings are clear of debris and are in good condition. Check for worn or missing parts. Ensure that the air supply hose length is
2. sufficient for its move to the desired destination or to the next air supply source.
3. For safety, first connect the ball valve and PT fitting to the end of the supply hose that will be attached to the Rollmaster.
4. Connect the air supply hose to the air supply source.
5. Connect ball valve, PT fitting and air supply hose to the Rollmaster, ensuring that the ball valve is in the off position (ball valve handle is perpendicular to the ball valve body).
6. Turn on the air supply at the source.
7. Slowly open the ball valve, applying air to the roll handling unit.
8. Push or pull the roll handling equipment on its no-load wheels towards the roll.
9. Straddle the roll with the forks.
10. Inflate the air casters to lift the roll off the floor – adjust as necessary.

GENERAL DESCRIPTION

The Rollmaster II is designed to easily load the paper roll, lift a roll of paper off of the floor, float the roll on a thin film of air for transfer to a new location, set the roll down, and then easily unload the paper roll.

Structure The Rollmaster II consists of two forks, a tie bar linking the two forks together, and a handle. The fork structure supports the roll and contains the air casters and wheels. The standard style has a manual regulator control, or the optional handle-mounted throttle control that is located on the handle. The regulator is contained in the tie bar. The standard Rollmaster II, that utilizes a throttle control, will operate the inflation of the air casters. The more the operator presses the handle of the throttle, the higher the air casters will inflate. The adjustment for air caster pressure will be done through mini-regulators located inside the compartment and through the pilot operator regulator. The air caster pressure is monitored by the pressure gauge.

Aero-Casters® There are four (4) 12-inch (30.5cm) diameter air casters attached to the bottom of the forks. The air casters will float the Rollmaster II (loaded or unloaded) on a thin film of air. When floating, the load will have omni-directional capability, with very little frictional constraint as compared to conventional material handling methods. The air casters can be inspected by tipping or lifting the whole structure onto its' side. (Make sure the air flow is turned off prior to inspection.)

No-Load Wheels There are three (3) wheels (1 swivel, 2 rigid) mounted in the base. They are designed to carry the weight of the Rollmaster only - the primary function is to move the unloaded roll handling equipment from one location to another while no air is being supplied to the air casters (air casters are turned off).

Pneumatic Controls The pneumatic control system distributes air from the air inlet to the various lift and float functions. The controls allow the operator to control, lift and float the rolls once

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loaded on the Rollmaster. There are two styles of controls: 1) Handle-mounted throttle control, or 2) Manual-operated regulator control.

BEFORE YOU BEGIN

ROLLMASTER SAFETY AND SETUP

The operation and maintenance of any equipment requires that the operating personnel be safety conscious at all times, not only for their own protection, but also for the protection of other workers, of the equipment and the load. Experience clearly indicates that following a few sensible safety practices could prevent most accidents. Some of the safety practices pertaining specifically to this roll handling equipment are outlined below.

1. Always inspect each component before use. Check for damaged or missing parts.
2. Operators should familiarize themselves with the roll handling equipment before attempting to operate.
3. Compressed air is a great tool but does require care in operation. Escaping air can create hazards if not controlled.
4. **Never disconnect a pressurized airline** – the line can whip and cause injury. Use caution when releasing air to minimize blowing dust and debris, which could cause eye injury. **Wear safety glasses.**
5. All air lines should be disconnected from the Rollmaster before performing any maintenance.
6. Only authorized personnel should be allowed around the roll handling equipment when making a move.
7. A roll should not be raised, lowered, or moved until the operator has verified that all of the personnel are clear of potential hazards.
8. The operating surface within the travel path should be visually checked for the removal of all obstructions before making a move.
9. Ensure that the operating surface is free of any puddles of any abrasive chemicals, cutting oils or fire-resistant hydraulic fluid. Should the air casters come in contact with any of these substances, clean the air caster fabric as soon as possible with warm, soapy solution, rinse and wipe dry.
10. Check air supply lines and the main air supply line. Blow the air lines clear of dirt or debris first before each hookup to your system. The status of the air supply lines should be monitored at all times to prevent them from becoming fouled during a roll move.
11. Do not prepare rolls while the unit is floating. The roll may shift during preparation, resulting in injury to the operator.
12. Establish your path for the move ahead of time. Consider floor condition, air supply location and sufficient clearance for your roll-handling move.
13. Do not leave the floating Rollmaster unattended. It may begin to drift downhill.

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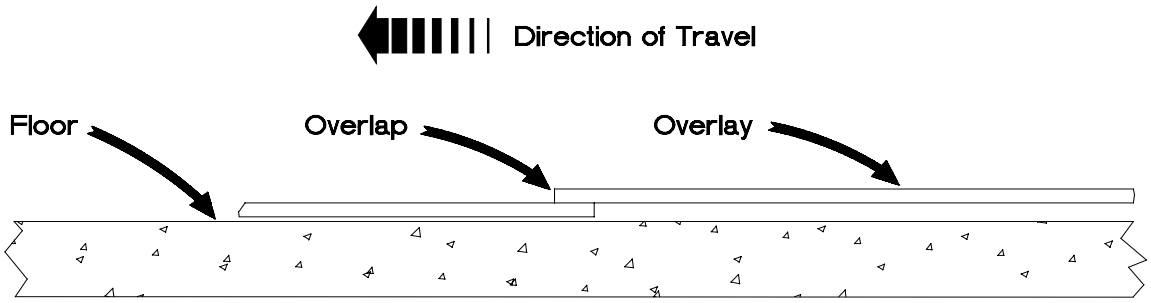
OPERATING SURFACE

The operating surface is critical to the efficient operation of air film products. Surfaces with porosity rob your load moving system of air, either destroying the air film, or causing you to operate with air volumes much more than the air supply you would normally require. A smooth, non-porous surface such as sealed, hand-trowelled concrete or vinyl tile is ideal. Unsealed concrete may be permanently upgraded for air film handling use by sealing (either over the entire surface or just the travel path) with many kinds of commercial penetrating sealers. Fill cracks with a sealistic compound filler. For information on achieving sealed concrete floors, consult AeroGo Engineering Instructions EI-16 *"Concrete Surface Treatments"* (available upon request).

To move rolls over cracks that cannot be permanently filled, such as door moldings, floor joints or elevator gaps, inexpensive overlay materials such as thin-gage sheet metal or non-embossed linoleum can be used. See AeroGo EI-15 *"Temporary and Permanent Surface Overlays"* (available upon request) for recommended overlay solutions.

For a straight path move, overlay tracks (over which your Rollmaster can float) can be formed by shingling so that the Aero-Casters are always moving from the higher to the lower overlay. (See drawing below for example).



SURFACE GRADES

The flexible air caster is constructed to contour and conform to out-of-plane surface undulations. A normal factory floor with a deviation of ¼-inch (6mm) in any 10-foot (3m) circle is satisfactory.

Friction is so low that a floating load will float downhill on a slight grade. A restraining force equal to the downhill component of the load weight (140 lbs. (64 kg) for a 14,000 lb (6356 kg) load on a 1% grade) must be applied. If drifting is not permissible, restrain loads with common rigging methods such as tether lines, winches and guide rails

AIR SUPPLY

VOLUME:

The volume of air required by a Rollmaster depends on the size and quantity of air casters. See AeroGo Rollmaster Literature included with your product - or contact your Local Factory Authorized Dealer/AeroGo Factory to find the volume your roll handling system requires.

To check if your compressor will provide the air volume needed, multiply the horsepower rating of your compressor by four to give you its approximate SCFM output.

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COMPRESSOR OUTPUT
FORMULA
Example: A 25 hp electric motor multiplied x 4 = 100SCFM*

**This is only a guideline. For true compressor output, when in doubt, use a flow meter with the appropriate pressure gage to check the output of a vintage compressor.*

To minimize the loss of air pressure at needed air volume, keep supply lines as short and as large as feasible. Keep air pressure high in the hose and regulate it down at or near the main inlet into your roll handling system.

Use only flow-through hose fittings, couplings and pressure regulators as supplied or specified by AeroGo.

PRESSURE:

Supply air at a pressure sufficient to float your roll. Allow for pressure loss through hose, fittings and components. 100 psi (7.03 kg/cm2) is recommended plant air supply pressure. This will allow for pressure drops in the system, and leave enough for the required operating pressure at your Rollmaster. This is 25 psig (1.76 kg/cm2) for Standard Neoprene (N) and Urethane (U) Aero-Casters.

AIR HOSES:

Check with an AeroGo Authorized Dealer or the Factory for recommended minimum hose sizes for your Rollmaster.

CONNECTING AIR

1. Ensure all hoses and fittings are clear of debris and are in good condition. Check for worn or missing parts. Ensure supply hose length is sufficient for its move to destination or to next air supply source.
2. For safety, first connect the ball valve and PT fitting to the end of the supply hose that will be attached to the Rollmaster.
3. Connect the air supply hose to the air supply source.
4. Connect the ball valve, PT fitting and supply hose to the Rollmaster, ensuring that the ball valve is in the off position (ball valve handle is perpendicular to ball valve body).
5. Turn on the air supply at the source.
6. Slowly open the ball valve, applying air to the Rollmaster unit.

SAFETY NOTE: If two (2) supply hoses are joined together, the cam locks on hose ends should be secured, i.e. cable tied or taped down, to ensure that they don't get caught and disconnect during your roll move.

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INFLATING:

Depending on your style of Rollmaster there are differing methods for accomplishing inflation:

1) Handle mounted throttle control style Rollmasters have an air lift lever which can be squeezed to inflate the air casters and lift the roll "off" the floor. Releasing the air-lift lever will deflate the air casters.

2) Manual operated regulator control style Rollmasters have regulator knobs that can be rotated clockwise to increase pressure to the air casters and lift the roll "off" the floor and vice versa.

When the air casters are properly inflated, air will just begin escaping from between the air caster and floor. This can be visually and audibly detected by looking for wisps or hearing the start of air escaping. The light escaping air can also be felt – but use caution and never put fingers or hands below or between loads that could shift or drop. See chart below for more information.

Observe	Cause	Remedy
Below rated Lift Height, no air escaping, air caster squeals/rubs	Too little pressure/ flow	Increase air flow; See *Adjustments*
Near rated Lift Height; Friction reduced and load can begin drifting; wisps starting to show escaping air	Ideal air pressure/ flow	-
Excess air escaping; Load bouncing or hopping	Too much pressure/ flow	Reduce air flow; See *Adjustments*

Note: Verify proper inflation before moving load. Indication of proper inflation is that the load may "drift" slightly to find the lowest section of floor.

ADJUSTMENTS:

All adjustments are factory set and should not need to be changed during roll moves and operation. A possible exception is the air caster pressure, which may need adjustment to compensate for your specific floor conditions or for a range of load weights. Call Factory for information.

Air Caster Inflation Rate - Regulator Adjustment: To increase pressure to the air casters, the regulator mounted on the crossbeam can be adjusted accordingly.

1. On Rollmaster systems with a manual regulator only, the large primary regulator is all that needs adjusting. Turning the knob clockwise will increase the air caster pressure. Turning the knob counter clockwise will decrease the air caster pressure.
2. On systems with a throttle control lever, a mini-regulator controls the amount of the air to the pilot regulator, which ultimately controls how much air can pass through the pilot regulator to the air casters. To increase or decrease the amount of air to the air casters, simply turn the mini-regulator knob (located on the crossbar) clockwise or counter clockwise respectively. The pressure that goes to the air casters can be monitored with the gauge mounted near the mini-regulator.

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ROLLMASTER OPERATION

Before Operation:

1. Read the *Safety and Set Up* section of this manual.
2. All adjustments should be properly set at startup and should not need to be changed during operation. A possible exception is air caster pressure, which may need adjustment to compensate for your specific floor conditions or a range of load weights. See *Adjustments* or call the factory for information.

General Operations

LOADING A PAPER ROLL

1. Push or pull equipment on its no-load wheels towards the roll.
2. Straddle the roll with the forks.
3. Inflate the air casters to lift the roll off the floor – adjust as necessary.

Warning: Keep hands, feet, hoses and other objects from under the roll and roll handling equipment at all times. Sudden pressure loss can result in severe injury to personnel or damage to equipment. Never leave a Rollmaster system unattended while inflated or floating.

Note: Occasionally, it may be necessary to move paper rolls that are smaller than the diameter the Rollmaster can carry. Pushing the Rollmaster under the paper roll and adding spacers or wedges (preferably on both sides to equalize the load) to make up the clearance between the paper roll and the Rollmaster forks will allow smaller diameters to be moved.

MOVING A ROLL

1. Push the Rollmaster on its inflated air casters to the desired destination. For handle-mounted throttle control style, do not release the air-lift lever until the Rollmaster has come to a complete stop or damage to your roll could occur.

LOWERING AND UNLOADING A ROLL

1. Release the air-lift lever (or on manually operated models, use the ball valve provided to turn off the air to the unit or rotate the regulator knob to the off position) to turn off the air to the air casters.
2. Once the air casters have deflated, pull the Rollmaster out from under the roll on its No-Load Wheels to complete your move.

DISCONNECT

1. Shut off the main air supply line ball valve.
2. Open the Rollmaster ball valve.
3. Inflate air casters and allow the air to escape completely out of the air casters.
4. When the air supply hose is soft, close the ball valve on the Rollmaster.
5. After the air supply line has fully discharged, disconnect from source.
6. Inspect all components for damage prior to storage.

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ROLLMASTER MAINTENANCE - Preventive/Periodic

Periodic maintenance will significantly increase the life of your Rollmaster II. The following is a list of maintenance points.

Aero-Casters

1. Periodically inspect for damage or wear - this can be done by tipping the unit on its side.
2. Wash with warm, soapy water if necessary. Use no solvents.
3. While the roll handling unit is on its side, apply a small amount of air to the unit and slightly inflate the air casters to ensure proper inflation. All air casters should inflate similarly. **Wear safety glasses.**
4. Check the air casters for damage, missing attachment bolts, cuts, tears or wear.
5. Replacement is required if the air casters are cut, torn, or excessively worn to threads (see below for replacement instructions).

Inspect Base

1. Tip the Rollmaster on its side to inspect the bottom of the forks.
2. Check wheels for damage, cracks, no rotation, etc.
3. Check the bottom of the forks for damage – scratches in the paint that would indicate unit has been moved over high spots on the floor when the unit is moved unloaded, or the No-Load wheels are not properly shimmed, or are potentially damaged.
4. Check No-Load wheel brackets for damage or missing attachment bolts.

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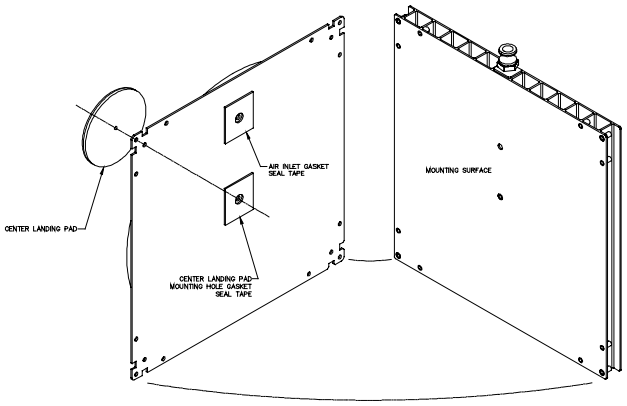
MAINTENANCE – Air Caster Repair/Replacement

REPLACEMENT INSTRUCTIONS - Standard Aero-Caster®(Model number found on Aero-Caster label or call for your model)



1. Remove all the screws and save from the air caster that you are removing from your Rollmaster.
2. Clean the mounting structure and remove any old double-backed foam sealing tape with scraper (utility knife or other) to provide a smooth surface (clean and dry) to which the new seal tape from the new replacement air caster will adhere.
3. Temporarily position the new air caster against the fork-mounting surface. Be sure that the air inlet hole on the air caster lines up with the air outlet hole in the bottom of the forks, or the Rollmaster's air casters will not inflate.
4. Remove the protective clear plastic (Mylar) from all the foam tape on the new air caster. Carefully locate the air caster on the mounting structure and press firmly to seal.
5. Replace the screws to secure the air caster on the mounting structure.

WHEELS

Remove the four attachment bolts and install new wheel.

THROTTLE CONTROL

1. Remove the two attachment screws that are holding the handle in position (1 on top 8-32 flathead, 1 on bottom 10-24 socket head).
2. Slowly remove the throttle assembly and verify the hoses (2 ea) are connected to the round throttle valve.
3. Record hose color and location installed on the round valve, i.e. side of valve (air out) and bottom of valve (air in).
4. Remove valve from the throttle handle and install the new valve. Note if the old valve has a nut and/or washer. You must use the same type of configuration on the new valve.
5. Connect the air-line to the valve.
6. Install the throttle assembly into handle – being careful not to pinch the air lines with the throttle assembly.

Note: After replacing the valve, if the Rollmaster does not inflate, check to be sure you have not pinched the hoses.

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TROUBLESHOOTING

The majority of component malfunctions are immediately evident by the failure of an individual component to function. The repair is usually straightforward and should involve generally accepted shop practice. Call the factory or your AeroGo certified dealer for additional information.

Load will not float properly

1. Review Operating Procedures
   A. Is there a minimum of 90-psi (6.3 kg/cm^2) system pressure at the inlet gauge? If not, check air supply line for restrictions.
   B. Are all of the controls in the proper state for the operation you wish to perform? Are they adjusted properly?
2. Look for cracks, holes or other irregularities in the floor.
   A. Is there an irregularity that is bleeding air from an air caster? If so, try increasing the pressure setting for that set of air casters. For instructions on how to correct or create a suitable operating surface, see AeroGo EI-13 *"Cracks, Joints and Holes in Concrete".* For larger surface areas that are damaged or cannot be sealed, consult AeroGo EI-15 *"Temporary and Permanent Surface Overlays".*
3. Inspect the Air Casters.
   A. Are they damaged or excessively dirty? Clean or replace as necessary – see *Maintenance* section.
4. Follow the air supply lines from the malfunctioning air caster(s) back to the main air supply line. Look for loose fittings, kinked hoses, etc.
5. Inspect all pilot lines, fittings and pneumatic components.
   A. Are there any loose fittings, hose kinks or holes, damaged or missing parts, or disconnected hoses?
   B. Is the fault in the component itself or is it in the pilot lines to the component? Replace faulty components when isolated.
   C. Did you recently replace an air caster? If an air caster's inlet hole is incorrectly positioned, the air casters will not inflate.
7. Air caster inlet seals are damaged or installed incorrectly.

Throttle Control Does Not Operate (no airflow is heard)

1) Check that the 1/16-inch (1.6mm) pilot lines are connected to the fitting on the regulator. On some units, a cover will need to be removed to view the fitting.
2) Check 1/16-inch (1.6mm) lines to the throttle handle. Remove the two attachment screws that are holding the handle in position. Slowly remove the throttle assembly and verify that the hoses (2 ea) are connected to the round throttle valve. Note: If 1/16-inch hose has oil, water or other contamination, replace the hose. This is easier than trying to remove contamination.

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3) With the throttle control lever out of the handle, verify the plunger operation on the valve. Hold the valve body and pull down slightly on the handle – pushing the plunger into the valve and releasing. The plunger should push the handle away from the valve. If not – replace the valve, as the spring inside the valve may be damaged.

Throttle Seems to Work but Aero-Casters® do not Inflate (airflow is heard)

1) Check installation of air caster(s). If an air caster's inlet hole is incorrectly positioned, the air casters will not inflate.
2) Check the mini-regulator. Turning the knob clockwise will increase the pressure and turning the knob counterclockwise will decrease the pressure. Pay attention on the pressure gauge. If there is no pressure reading, it is possible that there is a malfunction on the mini-regulator, line or in the pressure gauge. Check each one of them and replace or clean them if there is damage that causes malfunction.
3) Check the pilot-operated regulator: Check that the 1/16-inch line to the regulator is supplying proper air, i.e. should be minimum 90 psi when the throttle is completely depressed with supply air connected to the unit and the air supply is on. If the 1/16-inch line is supplying proper pressure, the pilot-operated regulator may be dirty or damaged and not operating properly.
    a. Order and install a regulator rebuild kit (see assembly instructions included with kit once it arrives), or
    b. Check the air source for contamination, i.e. oil or water in the air supply. If found, install filter downstream of unit.

Note: Some units have a secondary operating throttle control with additional plumbing, i.e. units with two handle and throttle controls. Contact the factory for assistance.

For replacement Aero-Casters or other parts,

Call AeroGo +1 206-575-3344 or 800-426-4757

or your Local Factory Certified Dealer.

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PLANNING ANOTHER MOVE?

Aero-Caster load handling equipment is rapidly gaining a wide variety of uses in diverse load handling applications. AeroGo products are available – or may be Custom Engineered – for different load sizes and shapes from 500 lbs (227kg) to 5000 tons. When planning to use your equipment in another location or under different load conditions, check with your factory-trained representative for recommendations

AEROGO WARRANTY

AeroGo warrants the Products and Product components manufactured by AeroGo ("Manufactured Products") shall substantially conform to AeroGo's product specifications, and shall be free from material defects in materials and workmanship for a period of twelve (12) months from the date of shipment by AeroGo ("AeroGo Warranty"). AeroGo shall not be liable for any breach of the AeroGo Warranty due to (i) acts or omissions of Customer or any third party after delivery; (ii) any abuse, damage beyond normal wear and tear or failure, (iii) operation or use of Manufactured Products other than in accordance with manufacturer's instructions and product specifications; or (iv) modification or alteration of the Manufactured Products by any party other than AeroGo. In the event any Manufactured Product is determined by AeroGo to be in breach of the aforementioned AeroGo Warranty, the sole remedy of complaining party and AeroGo's sole obligation shall be, at AeroGo's discretion and cost, to either repair or replace the allegedly defective Product, F.O.B. AeroGo's facility. AeroGo reserves the right to void its warranty where final destination and specific application information are withheld.

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AeroGo©

AeroGo, Inc.
1170 Andover Park West
Tukwila WA 98188
+1 (800) 426-4757 +1 206-575-3344
Fax: +1 206-575-3505 info@aerogo.com
www.aerogo.com

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