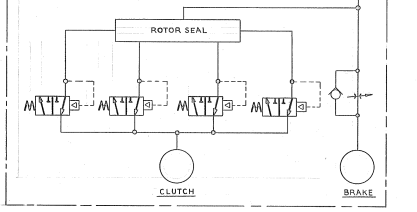


SEQUENCE OF OPERATION
 CATENARY ARM: CONTROLLED BY 5 WAY 2 POSITION MANUALLY OPERATED VALVE.
 LOWER ROLL LOCK: CONTROLLED BY 4 WAY 2 POSITION MANUALLY OPERATED VALVE.
 STOCK GUIDE LOCK: CONTROLLED BY 4 WAY 2 POSITION MANUALLY OPERATED VALVE.
 STOCK GUIDES: CONTROLLED BY 4 WAY 2 POSITION MANUALLY OPERATED VALVE.
 FEED ROLL: CONTROLLED BY 5 WAY 2 POSITION SINGLE SOLENOID OPERATED VALVE.
 EXIT ROLL: CONTROLLED BY 5 WAY 2 POSITION SINGLE SOLENOID OPERATED VALVE.
 CLUTCH BRAKE: CONTROLLED BY 3 WAY 2 POSITION SINGLE SOLENOID OPERATED VALVE.



QTY	DESCRIPTION	LITTELL PART NO.
20	1 PITCH SHIFTER UNIVERSAL 2.000	091513
19	CLUTCH AND BRAKE - PARKER	093467
18	1 CYLINDER - WARDEN - AIR	091078
17	2 CYLINDER - WARDEN - AIR	092434
16	1 CYLINDER - WARDEN - AIR	093378
15	1 CYLINDER - WARDEN - AIR	092467
14	1 CYLINDER - WARDEN - AIR	093378
13	1 CYLINDER - WARDEN - AIR	093378
12	1 CYLINDER - WARDEN - AIR	093378
11	1 CYLINDER - WARDEN - AIR	093378
10	1 CYLINDER - WARDEN - AIR	093378
9	1 CYLINDER - WARDEN - AIR	093378
8	1 CYLINDER - WARDEN - AIR	093378
7	1 CYLINDER - WARDEN - AIR	093378
6	1 CYLINDER - WARDEN - AIR	093378
5	1 CYLINDER - WARDEN - AIR	093378
4	1 CYLINDER - WARDEN - AIR	093378
3	1 CYLINDER - WARDEN - AIR	093378
2	1 CYLINDER - WARDEN - AIR	093378
1	1 CYLINDER - WARDEN - AIR	093378

NOTE: USE PARKER INTRALOK FITTINGS.
 ALL TUBING .375" UNLESS NOTED.
 .25" TO .5" TUBING X .035" WALL.

UNLESS OTHERWISE SPECIFIED	INCHES	MM
FRONT VIEW	1/2	12.7
TOP VIEW	1/4	6.35
SECTIONAL VIEW	1/8	3.175
SCALE	AS SHOWN	
DATE	9/87	
DESIGNER	XXX	
CHECKED	XXX	
APPROVED	XXX	
TITLE	DIAGRAM - PNEUMATIC - GRAPHICAL	
SCROLL SHEETING	SCROLL SHEETING - LINE	
8120	D 119876	