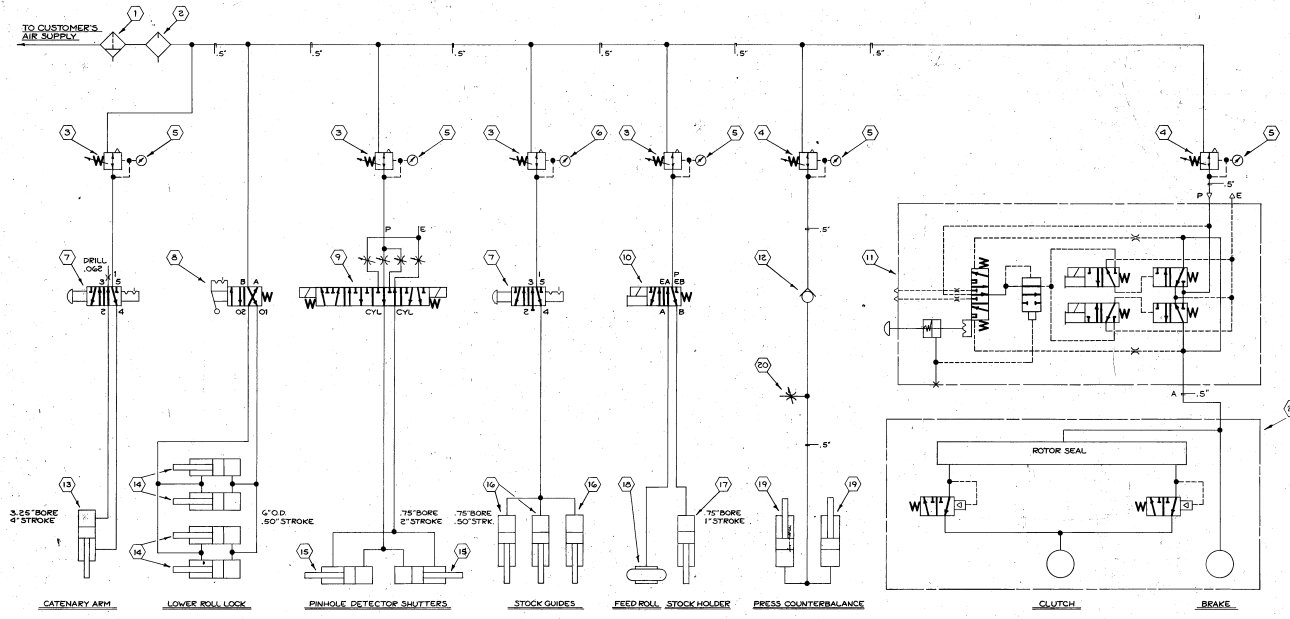


TO CUSTOMER'S AIR SUPPLY



**SEQUENCE OF OPERATION**

- CATENARY ARM : CONTROLLED BY 4 WAY 2 POSITION MANUALLY OPERATED DETENTED VALVE.
- LOWER ROLL LOCK : CONTROLLED BY 4 WAY 2 POSITION MANUALLY OPERATED DETENTED VALVE.
- PINHOLE DETECTOR : CONTROLLED BY 4 WAY NORMALLY CLOSED NORMALLY OPEN NO NEUTRAL SHUTTERS. POSITION DOUBLE SOLENOID OPERATED VALVE.
- STOCK GUIDES : CONTROLLED BY 4 WAY 2 POSITION MANUALLY OPERATED DETENTED VALVE.
- STOCK HOLDER : CONTROLLED BY 4 WAY 2 POSITION SINGLE SOLENOID OPERATED SPRING RETURN VALVE.
- FEED ROLL : RETURN VALVE.
- CLUTCH / BRAKE : CONTROLLED BY 3 WAY DOUBLE SOLENOID OPERATED VALVE.

**NOTE:**  
USE "PARKER-HANNIFIN" COMPRESS-A-LIGN FITTINGS.  
ALL TUBING TO BE .375" UNLESS NOTED.  
.25" 5" TUBING -.035" WALL

21	CLUTCH BRAKE LAYDOWN AIR/FLEX CLUTCH #HCB-400 BRAKE #HCB500 FLX VALVE SUB ASSY #02027C HUSSEY ROTOMAN #R20283C HERRIGAY FLOW CONTROL VALVE #E2223L QUICK RELEASE #R1058 #HCB400-BK-C-REG	
20	RETROCK SHUTOFF #HERRIGAY C3 #R1045	091515
19	CYLINDER "MILLER" AIR COUNTERBALANCE	#H2872E
18	ACTUATOR "HERRIGAY" AIRSTROKE #H	092671
17	CYLINDER "BIRBAIR" 3" BORE 2" STROKE AND RETURN #BFC 041	093370
16	CYLINDER "MILLER" AIR 7.5" BORE .50" STROKE	AH1098 AH1814
15	CYLINDER "BIRBAIR" DEL. ACTING 7.5" BORE 2" STROKE	093370
14	CYLINDER "HACK" DEL. ACTING 7.5" BORE 2" STROKE	093465
13	CYLINDER "MILLER" AIR 3.25" BORE 4" STROKE	092668
12	VALVE "BIRBAIR" SEAL #C-3-APP-500 3" FEMALE	092426
11	VALVE "BIRBAIR" 3 WAY DBL SOL. DBL. VALVE N.C. #E223400C POSITION	
10	VALVE "NUMATIC" 4 WAY SOL. SOL. AND RETURN #R20483C-C5 1/2" INCH	
9	SOLENOID OPER. 115V 50 Hz #V353 DEL. COIL	
8	VALVE "BIRBAIR" STRAIGHT HANDLE LOCK	091224
7	VALVE "BELLONS" PALM STRITON OPER #C3031 1/4" .50"	093140
6	GAUGE "NORGREN" AIR #H-03-207 C-30 PSI	093945
5	GAUGE "NORGREN" AIR #H-03-207 C-160 PSI	093940
4	REGULATOR "NORGREN" #R1E-400-RNLA-.5" C-1E5 PSI	093938
3	REGULATOR "NORGREN" #R1E-300-RNLA-.375" C-1E5 PSI	093936
2	LUBRICATOR "NORGREN" #LID-400-HPLA-5"	093941
1	FILTER "NORGREN" AIR #F1C-400-MSTA-.5"	093931

**PARTS LIST**

DATE	REV.	BY	APP.
11/23/69	1		
100% S. MOD.			
DIAGRAM-PNEUMATIC-CRAPHICAL			
SCROLL SHEETING LINE			
82730 D 13204			