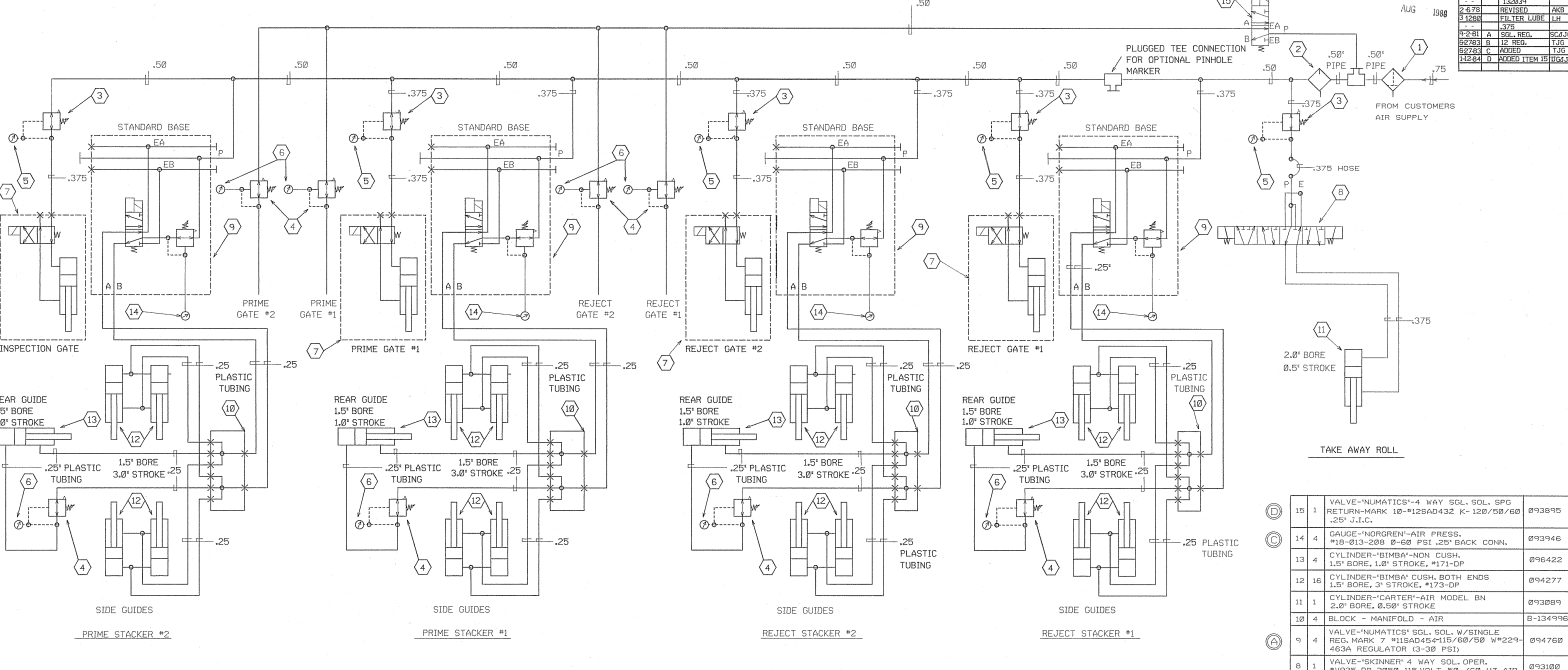


THIS DRAWING REPLACES DRAWING OF SAME NUMBER BY RRM DATED 9-27-77



**SEQUENCE OF OPERATION**

INSPECTION GATE  
 PRIME GATE #1  
 REJECT GATE #1  
 REJECT GATE #2

CONTROLLED BY 2 POSITION 4 WAY SINGLE SOLENOID OPERATED VALVE. SOLENOID IS ENERGIZED TO OPEN THE GATES.

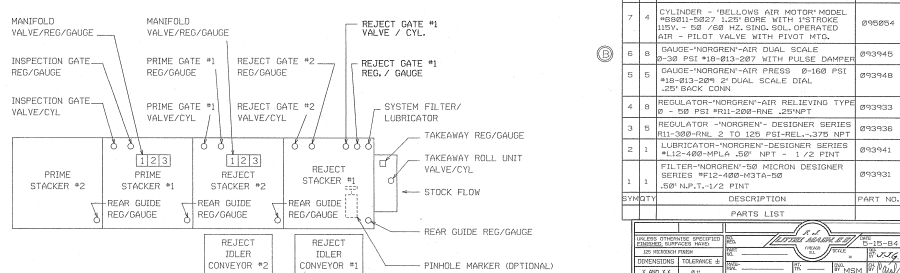
PRIME STACKER 1 & 2  
 &  
 REJECT STACKER 1 & 2  
 SIDE & REAR GUIDES

CONTROLLED BY 2 POSITION 4 WAY SINGLE SOLENOID OPERATED VALVE. SOLENOID IS ENERGIZED TO OPEN THE SIDE GUIDES AND REAR GUIDES.

TAKEAWAY ROLL

CONTROLLED BY 4 POSITION 6 WAY DOUBLE SOLENOID OPERATED VALVE. SOLENOIDS ARE ENERGIZED TO ACTUATE TAKEAWAY MECHANISM

**NOTES:**  
 USE 'PARKER-HANNIFIN'  
 COMPRESS-A-LON FITTINGS  
 ALL TUBINGS TO BE AS NOTED  
 .25" - .375" TUBING - .035" WALL  
 .5" TUBING - .042" WALL  
 .25" PLASTIC TUBING - .040" WALL  
 'IMPERIAL EASTMAN' POLY-FLD  
 #44-P (NATURAL COLOR)



NO.	DESCRIPTION	PART NO.
15	VALVE-NUMATICS-4 WAY SOL. SOL. SPD. RETURN-MARK 10-1125X432 KC-128/59/68 .25" J.I.C.	893970
14	GAUGE-NORGREN-AIR PRESS.	893946
13	CYLINDER-BIMBA-NON CUSH. 1.5" BORE, 1.0" STROKE, #171-OP	896422
12	CYLINDER-BIMBA-NON CUSH. BOTH ENDS 1.5" BORE, 3" STROKE, #173-OP	894277
11	CYLINDER-CARTER-AIR MODEL BN 2.0" BORE, 0.59" STROKE	893289
10	BLOCK - MANIFOLD - AIR	8-134976
9	VALVE-NUMATICS SOL. SOL. W/SINGLE REG. MARK 9 #1154X44115/88/58 W#224-463A REGULATOR (3-38 PSI)	894758
8	VALVE-ROSKNERN 4 WAY SOL. OPER. #1935-05-205M 1/8" VOLT. 50 / 68 H2 AIR	893180
7	CYLINDER - WELLSONG AIR MOTOR MODEL #8811-5827 1.25" BORE WITH 1" STROKE DIA. X .50 / 68 H2 SINGLE SOLENOID OPERATED AIR - PILOT VALVE WITH PIVOT MTD.	898854
6	GAUGE-NORGREN-AIR DUAL SCALE 0-30 PSI #18-813-287 WITH PLUSE DAMPER	893945
5	GAUGE-NORGREN-AIR PRESS 0-160 PSI #18-813-289 2" DUAL SCALE DIAL .25" GAGE COIL	893946
4	REGULATOR-NORGREN-AIR 20V TYPE 8 - 50 PSI #41-200-FINE-20VNF	893933
3	REGULATOR-NORGREN-DESIGNER SERIES R11-388-FNL 2 TO 125 PSI-RELL-.375 NPT LUBRICATOR-NORGREN-DESIGNER SERIES #115-485-M1-A .50" NPT - 1/2" PHT	893941
2	FILTER-NORGREN-50 MICRON DESIGNER SERIES #12-488-837A-50 .50" NPT, 1-1/2" PNT	893931
1		

**PARTS LIST**

REGULATOR-NORGREN-DESIGNER SERIES R11-388-FNL 2 TO 125 PSI-RELL-.375 NPT LUBRICATOR-NORGREN-DESIGNER SERIES #115-485-M1-A .50" NPT - 1/2" PHT	QTY	1
FILTER-NORGREN-50 MICRON DESIGNER SERIES #12-488-837A-50 .50" NPT, 1-1/2" PNT	QTY	1

82520-77

132077

82520-77