



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 SHUTTERS : CONTROLLED BY 4 WAY NORMALLY CLOSED NORMALLY OPEN NO NEUTRAL POSITION DOUBLE SOLENOID OPERATED VALVE.
- STOCK GUIDES : CONTROLLED BY 4 WAY 2 POSITION MANUALLY OPERATED DETENTED VALVE.
- STOCK HOLDER 1 : 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.
- EXIT ROLL : CONTROLLED BY 3 WAY 2 POSITION SINGLE SOLENOID OPERATED SPRING RETURN VALVE.

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

NEW	OLD
ES	1
B	2
A	3
A	4
CA	5

ITEM	DESCRIPTION	QUANTITY	LITTELL PART NO.
23	CLUTCH FAUCET	1	093379
22	VALVE-NUMERIC 3WAY SOLENOID SPRING RETURN	1	093462
21	REGULATOR-NORGEN 2-125 PSI	1	093938
20	FILTER-NORGEN 50 MICRON 2" O.D.	1	091515
19	CYLINDER-ALTRAIR AIR STROKE #16	1	042871
18	CYLINDER-BIRBAIR 1" BORE 3" STROKE 5/8" RETURN #8	1	043378
17	CYLINDER-LITTELL AIR 7/8 BORE 50" STROKE	1	440034
16	CYLINDER-FIRESTONE ACTING 7/8 BORE 2" STROKE #18-24	1	448314
14	GAUGE-AIR 14000002	1	093045
13	CYLINDER-VALVE AIR 3.25 BORE 4" STROKE 1000 # 810	1	092668
12	VALVE-CIRCLE SEAL 1.000 4-SPIR 1000-25 FEMALE	1	090423
11	VALVE-ROSS 3WAY DR. 1.000 4-SPIR 1000-25 FEMALE	1	093704
10	VALVE-NUMERIC 3WAY SOLENOID SPRING RETURN	1	093896
9	VALVE-SUNNER 4WAY 1.000 SOLENOID 15/16" HP #V33-DE-2050	1	091254
8	VALVE-HANNIFIN AIR STRAIGHT HANDLE LOCK TYPE K5200	1	091240
7	VALVE-HURT - PALM RETURN OPER.	1	093340
6	ROTOR FAUCET	1	093360
5	GAUGE-NORGEN AIR #18-005-010 #1875	1	093940
4	VALVE-ROSS MAN OPER #1121005-15 NP	1	091173
3	REGULATOR-NORGEN #811-000-RNU-375 2-125 PSI	1	093936
2	FILTER-NORGEN AIR #F12-400-MSTA-5"	1	093941
1	FILTER-NORGEN AIR #F12-400-MSTA-5"	1	093941

PARTS LIST

ITEM	DESCRIPTION	QUANTITY	LITTELL PART NO.
1	CLUTCH	1	04400

BR-4 PRESS

84400 D 14514