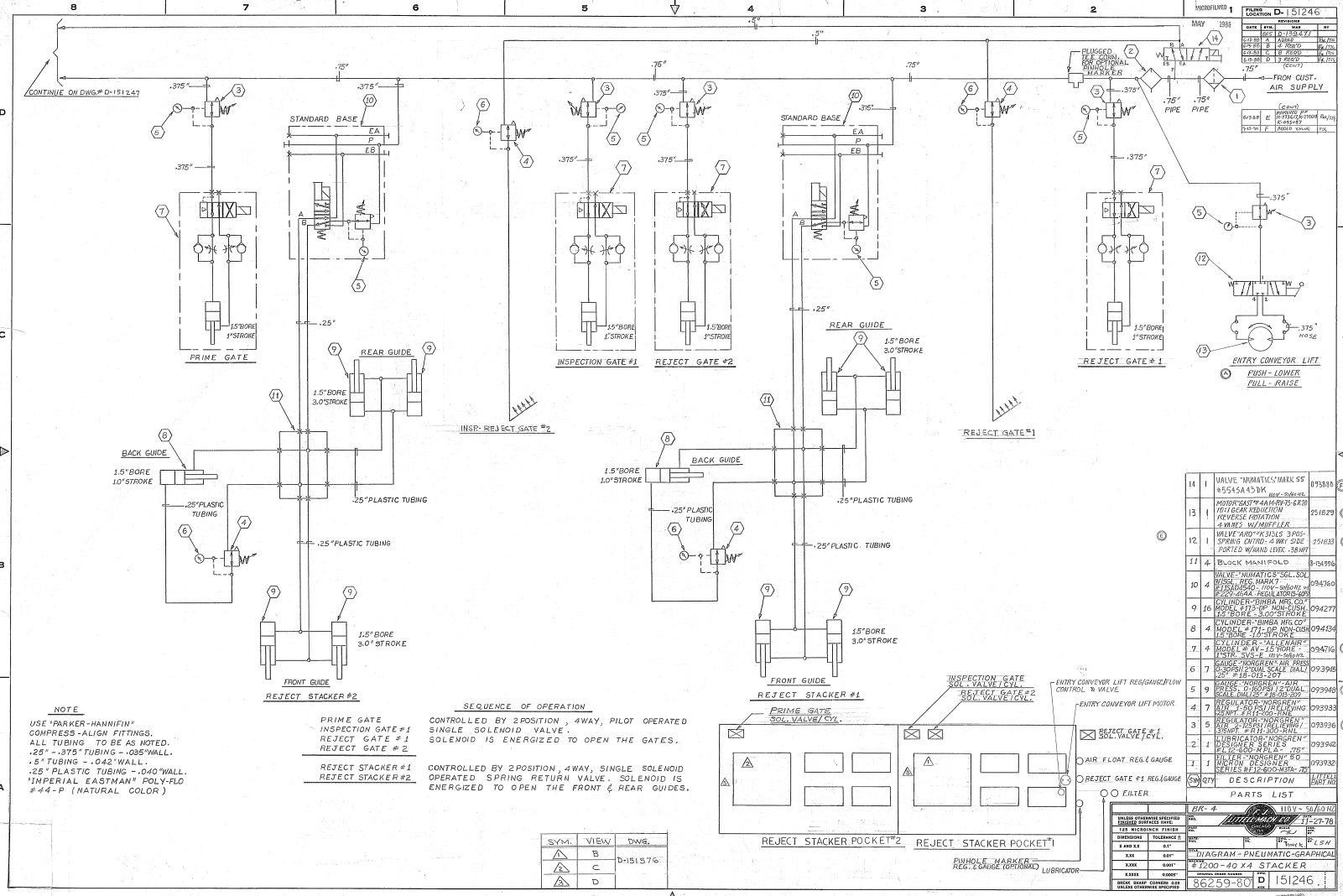

14	1	VALVE "NUMATICS" MARK 5S #5545A43DK (NOT SHOWN)	093880
13	1	MOTOR "EASTERN" 4AM-RY15-GR10 10:1 GEAR REDUCTION REVERSE ROTATION 4 WIRES W/MUFFLER	251629
12	1	VALVE "ARO" #K31SLS 3 POS. SPRING CNTRD. 4 WAY SIDE PORTED W/HAND LEVER - 3/8 NPT	251633
11	4	BLOCK MANIFOLD	3-134996
10	4	VALVE "NUMATICS" SOL. SOL. W/SEL. REG. MARK 7 #1 STANDARD - 110V - 50/60HZ #227-60AA - REGULATOR 5-60S	094760
9	16	CYLINDER - PIMBA MFG. CO. MODEL # 713-DP NON-PUSH 1.5" BORE - 3.00" STROKE	094277
8	4	CYLINDER - "BIMBA MFG. CO." MODEL # 171-DP NON-PUSH 1.5" BORE - 1.0" STROKE	094434
7	4	CYLINDER - "ALLEN AIR" MODEL # AV-1.5 "HOME" 1.5" STR. SVS-E (NOT SHOWN)	094716
6	7	GAUGE - "NORGREN" AIR PRESS. 0-160 PSI DUAL SCALE DIAL 2.25" #18-013-201	093945
5	9	GAUGE - "NORGREN" AIR PRESS. 0-160 PSI DUAL SCALE DIAL (NOT SHOWN) #18-013-239	093948
4	7	REGULATOR - "NORGREN" AIR 1/4" - 150 PSI RELIEVING W/NUT & KNOB #R11-200-RNL	093933
3	5	REGULATOR - "NORGREN" AIR 1/4" - 150 PSI RELIEVING W/SHUT #R11-300-RNL	093936
2	1	LUBRICATOR - "NORGREN" DESIGNER SERIES #LC-600-NPLA - .75"	093942
1	1	FILTER - "NORGREN" 80 MICRON DESIGNER SERIES #F12-600-M3TA-.75"	093932
SYM.	QTY.	DESCRIPTION	SUPPLIER PART NO.

PARTS LIST

NOTE

USE "PARKER-HANNIFIN" COMPRESS-ALIGN FITTINGS.
ALL TUBING TO BE AS NOTED.
.25" - .375" TUBING - .035" WALL.
.5" TUBING - .042" WALL.
.25" PLASTIC TUBING - .040" WALL.
"IMPERIAL EASTMAN" POLY-FLO #44-P (NATURAL COLOR)

PRIME GATE
INSPECTION GATE #1
REJECT GATE #2

REJECT STACKER #1
REJECT STACKER #2

SEQUENCE OF OPERATION

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

CONTROLLED BY 2 POSITION, 4 WAY, SINGLE SOLENOID OPERATED SPRING RETURN VALVE. SOLENOID IS ENERGIZED TO OPEN THE FRONT & REAR GUIDES.

SYM.	VIEW	DWG.
1	B	D-151576
2	C	
3	D	

MODEL	BR-4
	110V - 50/60HZ
DRAWN	11-21-78
SCALE	NONE
SIZE	D
DWG. NO.	151246
TITLE	DIAGRAM - PNEUMATIC-GRAPHICAL
MACHINE	#1200-40 X4 STACKER
ORIGINAL ORDER NUMBER	86259-80

UNLESS OTHERWISE SPECIFIED FINISHED SURFACES HAVE: 125 MICROINCH FINISH
DIMENSIONS TOLERANCE ±
2 AND 3 X 0.1"
X.XX 0.01"
X.XXX 0.001"
X.XXXX 0.0005"
BREAK SHARP CORNERS 0.03 UNLESS OTHERWISE SPECIFIED

FILING LOCATION D-151246
MICROFILMED MAY 1980

REVISIONS			
DATE	SYM.	WAS	BY
10/1/79	A	D-151247	
6-5-80	B	A 20870	RK
8-11-80	C	B 21000	RK
1-9-81	D	3 HOLES (CONT.)	RK
6-9-81	E	ADDED SYSTEM (CONT.)	RK
10-1-81	F	ADDED TANK	RK