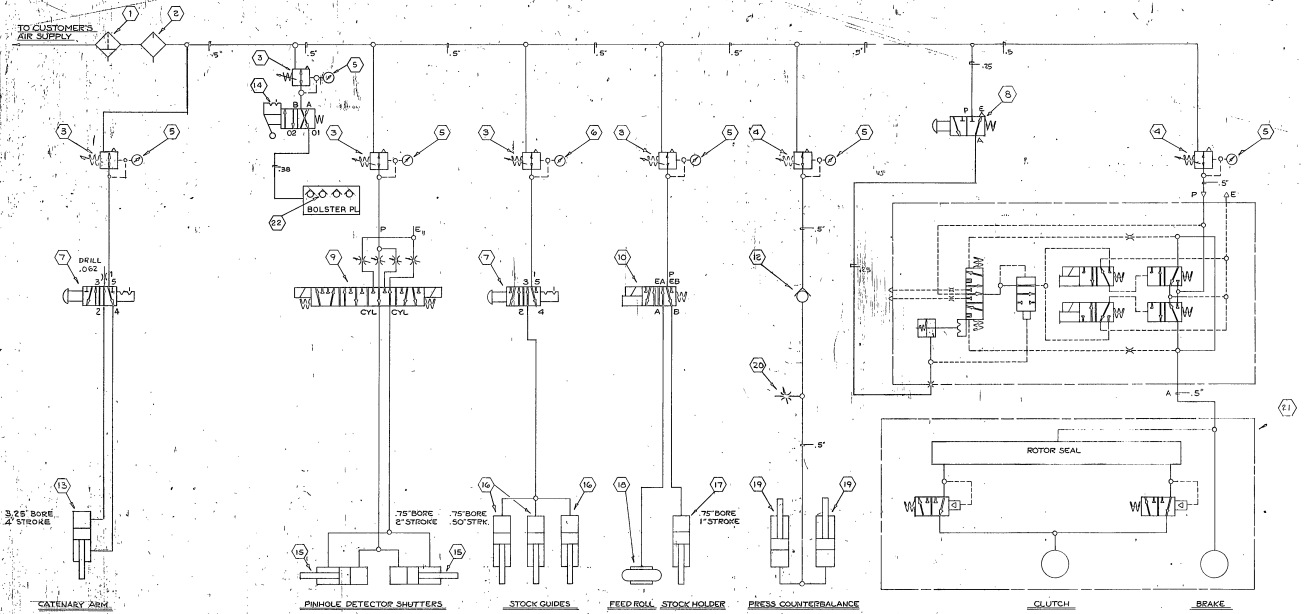

FILING LOCATION D-161177

REVISIONS			
DATE	SYM.	WAS	NOW
		129858	143199
		160310	

SEQUENCE OF OPERATION

CATENARY ARM : 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 & FEED ROLL : CONTROLLED BY 4 WAY 2 POSITION SINGLE SOLENOID OPERATED SPRING RETURN VALVE.

CLUTCH & BRAKE : CONTROLLED BY 3 WAY DOUBLE SOLENOID OPERATED VALVE. & MANUALLY OPERATED 2 POSITION 4-WAY DETENTED VALVE.

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

SYM	QTY	DESCRIPTION	LITTELL PART NO.
22	14	VALVE-BALL-"GITS" STYLE "S"-P6P99J-.125-27 NPT	097023
21	1	CLUTCH/BRAKE-"EATON" AIRFLEX CLUTCH #14CB+ 400 BRAKE #9C5200 FLY WHEEL SUB ASSY #3054715 MODIFIED DWG/APPD. D08896-MOD#1 AT FLOW CONTROL VALVE-#2 #2100 QUICK EXH. VALVE-N/A #1900 4-14048G-D12-.625"Q.	
20	1	REGULATOR-"NORGREN" #11-800-RNL-.5"	093134
19	2	CYLINDER-"MILLER" AIR COUNTERBALANCE.	B-127122
18	1	ACTUATOR-"PNEUSTONE" AIRSTRONG #16	092071
17	1	CYLINDER-"BIMBA" AIR .75"BORE 1"STROKE SPG RETURN 093-DXI	093378
16	3	CYLINDER-"LITTELL" AIR .75"BORE - .50"STROKE	A116098 A116314
15	2	CYLINDER-"BIMBA" DBL ACTING .75"BORE 2"STRK #BR-042-D	
14	1	VALVE-"HANNIFIN" AIR STRAIGHT HANDLE LOCK TYPE "S" S-4A4-A4-S	091224
13	1	CYLINDER-"MILLER" AIR 3.25 BORE 4" STROKE MOD #81B	092668
12	1	VALVE-"CIRCLE SEAL" #2491-S-4PP-200-.5" FEMALE	092826
11	1	VALVE-"ROSS" 3 WAY DBL SOL-DBL VALVE N.C. #S573A5004-.75"	093704
10	1	VALVE-"NUMATICS" 4 WAY SOL SOL SPG RETURN #1ESAD13C1-GES	093395
9	1	VALVE-"SCHRADER" 4 WAY DBL SOL-OPER 115V-60 HZ #V934-DEF2080	
8	1	VALVE-"ROSS" MANUOPER PUSH BUTTON SPR RETURN #1723A2005A-.25 NPT	096173
7	2	VALVE-"BELLOWS" PALM BUTTON OPER. #02231-144-.25"	093140
6	1	GAUGE-"NORGREN" AIR #18-013-207 0-30 PSI	093135
5	6	GAUGE-"NORGREN" AIR #18-013-209 0-160 PSI	093136
4	2	REGULATOR-"NORGREN" #R12-400-RNLA-.5" 2-125 PSI	093138
3	5	REGULATOR-"NORGREN" #R11-300-RNL-.375" 2-125 PSI	093134
2	1	LUBRICATOR-"NORGREN" #L12-400-MPLA-.5"	093141
1	1	FILTER-"NORGREN" AIR #F12-400-M3TA-.5"	093131

PARTS LIST

UNLESS OTHERWISE SPECIFIED FINISHES REMOVED HAVE:					
125 MICROINCH FINISH					
DIMENSIONS	TOLERANCE ±				
X AND XX	0.1"				
.XX	0.01"				
.XXX	0.01"				
.XXXX	0.0005"				
BREAK SHARP EDGES AND REMOVE BURRS					

DRAWN		DATE	6-10-83
CHECKED			
ENGR. APPR.			
MFG APPR.			
MATL			
FINISH			
NEXT ASSY	MSM	USED ON	LN-IE

Littell International, Inc.

TITLE	DIAGRAM: PNEUMATIC-GRAPHICAL
SIZE	D
DRAWING NO.	161177
SCALE	
WEIGHT	
SHEET	

LN-IE SCROLL SHEETING LINE

87270-83