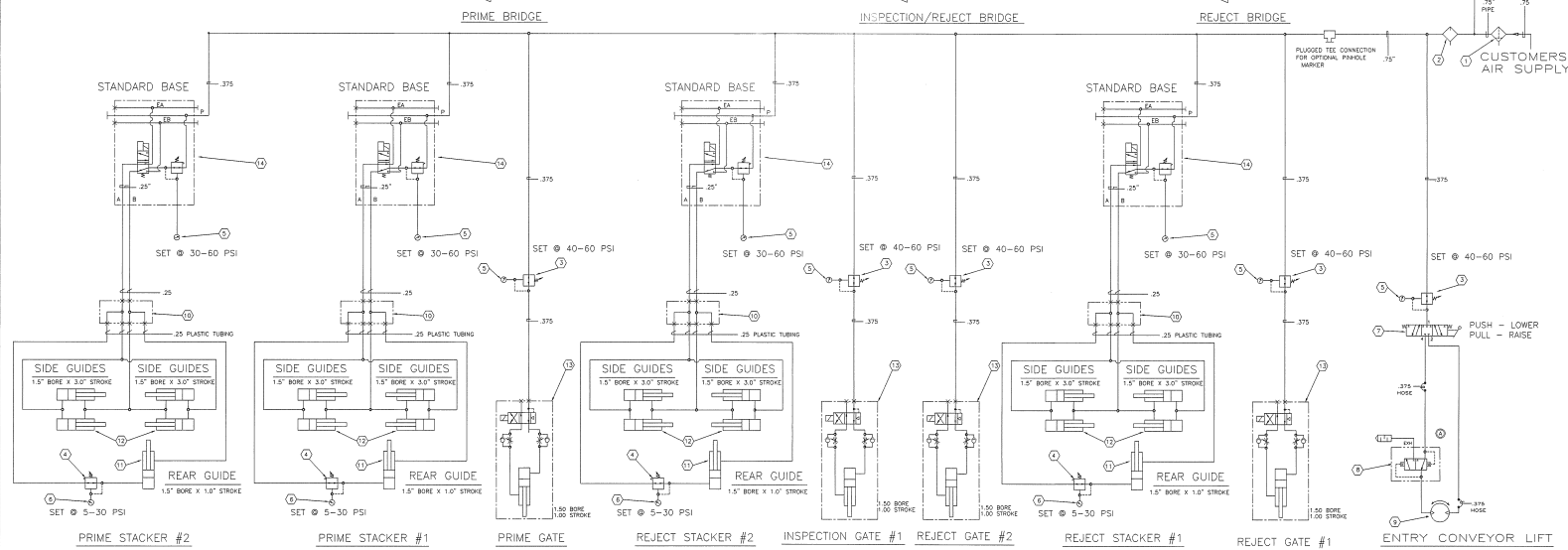
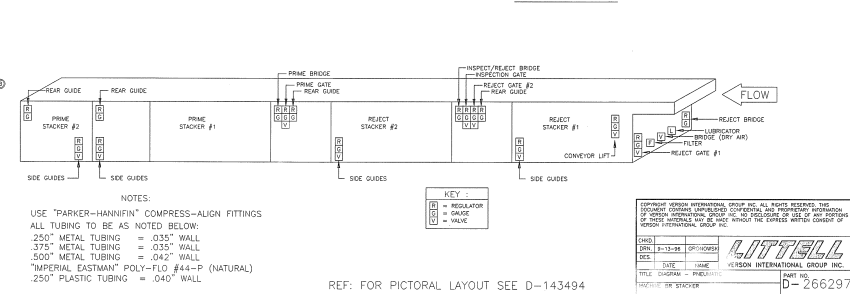


SEQUENCE OF OPERATION

- INSPECTION GATE } CONTROLLED BY 2 POSITION 4 WAY SINGLE SOLENOID OPERATED VALVE. SOLENOID IS ENERGIZED TO OPEN THE GATES.
- PRIME GATE #1 }  
 REJECT GATE #1 }  
 REJECT GATE #2 }
- PRIME STACKER 1 & 2 } CONTROLLED BY 2 POSITION 4 WAY SINGLE SOLENOID OPERATED VALVE. SOLENOID IS ENERGIZED TO OPEN THE SIDE GUIDES AND REAR GUIDES.
- REJECT STACKER 1 & 2 }  
 SIDE\* & REAR GUIDES }
- ENTRY CONVEYOR LIFT } CONTROLLED BY 3 POSITION, 4 WAY, SPRING CENTERED HAND LEVER VALVE. LIFT & DESCENT OF ENTRY CONVEYOR THROUGH HAND LEVER POSITION.



SYM	QTY	DESCRIPTION	PART NO.	SYM	QTY	DESCRIPTION	PART NO.
B	1	VALVE - AIR CUSH EXHAUST "PNEUTROL" MODEL REV-25B	093735	15	1	VALVE-"NUMATICS"-4 WAY SGL. SOL. RETURN - SP40 50" J.I.C.	24VDC 115V-50/60HZ 093888
7	1	VALVE - "ARO" #K313LS 3 POSITION SPRING CENTERED, 4 WAY SIDE PORTED W/HAND LEVER	251833	14	4	VALVE-"NUMATICS" SGL. SOL. W/SINGLE REG. MARK 7 #154544	24VDC 115V-50/60HZ 094760
6	7	GAUGE-"NORGEN"-AIR DUAL SCALE 0-30 PSI #18-013-207 WITH PULSE DAMPER	093945	13	4	CYLINDER - "ALLEN AIR" MODEL - 8 W/ 1.5" x 1.0" SVS-E-AA-J 1.50 BORE x 1.00 STROKE 4 WAY-SINGLE SOLENOID PILOT VALVE-ROD NORMALLY EXTENDED	24VDC 115V-50/60HZ 094716
5	9	GAUGE-"NORGEN"-AIR PRESS 0-160 PSI #18-013-209 2" DUAL SCALE DIAL 23" BACK COUPL	093948	12	16	CYLINDER-"BIMBA" CUSH. BOTH ENDS 1.5" BORE, 3" STROKE, #D-21361-A	094277
4	7	REGULATOR-"NORGEN"-AIR RELIEVING TYPE 0 - 50 PSI #R11-200-RE-25"NOT	093933	11	4	CYLINDER-"BIMBA"-NON CUSH. 1.5" BORE, 1.0" STROKE, #D-10622-A-1	094134
3	5	REGULATOR-"NORGEN"-DESIGNER SERIES R11-300-RNL 2 TO 126 PSI-REL.-.375 NPT	093936	10	4	BLOCK - MANIFOLD - AIR	B-134996
2	1	LUBRICATOR-"NORGEN"-DESIGNER SERIES #L12-600-MPLA .75" N.P.T. - 1/2 PINT	093942	9	1	MOTOR - "GAST" #44M-RV-75-ER20 10:1 GEAR REDUCTION REVERSIBLE ROTATION 4 VANS W/HUFFLER	251829
1	1	FILTER-"NORGEN"-50 MICRON DESIGNER SERIES #F12-600-MTA-50 .75" N.P.T.-1/2 PINT	093932				



NOTES:  
 USE "PARVER-HANNIN" COMPRESS-ALIGN FITTINGS  
 ALL TUBING TO BE AS NOTED BELOW:  
 250" METAL TUBING = .035" WALL  
 375" METAL TUBING = .035" WALL  
 500" METAL TUBING = .042" WALL  
 "IMPERIAL EASTMAN" POLY-FLO #44-P (NATURAL)  
 250" PLASTIC TUBING = .040" WALL

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DATE: 12-11-81  
 BY: TJC  
 CHECKED BY: TJC  
 DRAWING NO.: D-266297  
 PROJECT NO.: 222-453A-3-20P/AN/AL/US  
 SCALE: 1" = 1'-0"