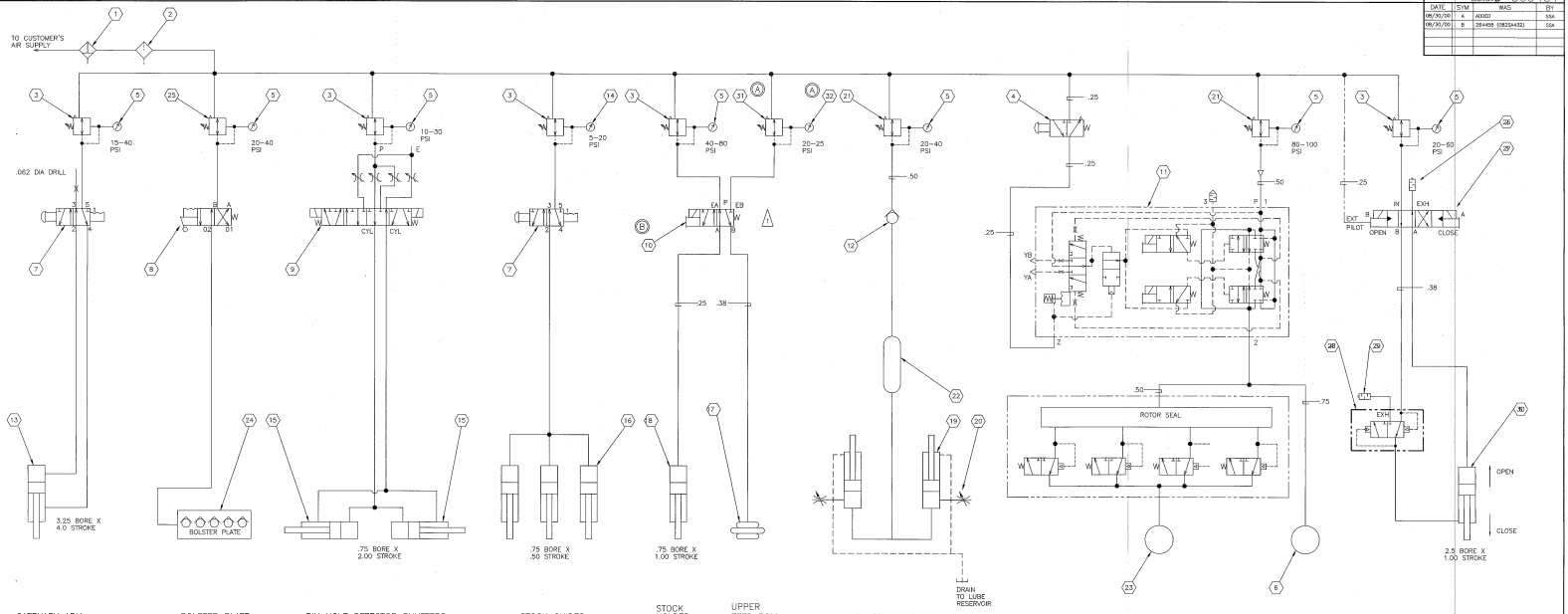
FILING LOCATION D-309431			
DATE	SYM	WAS	BY
08/30/00	A	ADDED	SSA
08/30/00	B	284458 (08SSA432)	SSA



SEQUENCE OF OPERATION:

CATENARY ARM.....	CONTROLLED BY 4 WAY, 2 POSITION, MANUALLY OPERATED, DETENTED VALVE.
PINHOLE DETECTOR SHUTTERS.....	CONTROLLED BY 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.
EXIT ROLL.....	CONTROLLED BY 4 WAY, 2 POSITION, DOUBLE SOLENOID OPERATED VALVE. SOLENOID A IS ENERGIZED TO CLOSE THE FEED ROLLS. SOLENOID B IS ENERGIZED TO OPEN THE FEED ROLLS.

NOTE:
USE "PARKER-HANNFIN" COMPRESS-ALIGN FITTINGS.
ALL TUBING TO BE .38 UNLESS NOTED.
.25 – .50 TUBING – .035 WALL

	NEW	OLD
1	EB	1
	B	2
	P	3
	A	4
	EA	5

SYM	QTY	DESCRIPTION	LITTELL PT NO
A	32	1	GAUGE – AIR "NORGREN" #18-013-208 W/PULSE DAMPER, 0-60 PSI, .25 NPT, BACK CONNECTION, 2" DIAL	093946
A	31	1	REGULATOR "PARKER" #07R31AC COMPLETE WITH #PS737P TAMPERPROOF KIT AND #PS807P MTG. BRACKET INCLUDING PANEL MTG. NUT	297288
	30	1	CYLINDER – AIR "PARKER" #2.5"D-2AU34A1" 2.50 BORE x1.00 STROKE .38 NPT PORTS	309070
	29	1	MUFFLER – "QUIETAIRE" #M900SA .38 NPT	008073
	28	1	VALVE – QUICK EXHAUST "DELTROL" #EV-25A-.375 .38 NPT	213223
	27	1	VALVE – DIRECTIONAL "MAC" #82A-BA-CAD-TM-DDAA-1DA 4 WAY, 2 POSITION, DOUBLE SOLENOID, 24 VDC	309432
	26	1	MUFFLER – "QUIETAIRE" #M500SA .38 NPT	287087
	SYM	QTY	DESCRIPTION	LITTELL PT NO

PARTS LIST

SYM	QTY	DESCRIPTION	LITTELL PT NO
25	1	REGULATOR – "NORGREN" #R08-200-RNMA 2-125 PSI .25 NPT	093934
24	14	VALVE – BALL "GITS" STYLE # "S"00553 .12 NPT	097023
23	1	CLUTCH – "FAWICK" #16CB500	251780
22	1	TANK – SURGE "LITTELL" COUNTERBALANCE	C-211907
21	2	REGULATOR – "NORGREN" #R12-400-RNLA .50 NPT	093938
20	2	PETCOCK – SHUTOFF "IMPERIAL" .25 NPT BRASS #49E	091515
19	2	CYLINDER – "PARKER" AIR COUNTER BALANCE	B-239250
18	1	CYLINDER – "BIMBA" AIR .75 BORE X 1.00 STROKE SPRING RETURN #BF041	093378
17	1	ACTUATOR – AIR "FIRESTONE" AIR STROKE #16	092871
16	3	CYLINDER – "LITTELL" AIR .75 BORE X .50 STROKE	A-135182 A-135183
15	2	CYLINDER – "BIMBA" AIR DBL ACTING .75BORE X 2.0 STR #BR-042-D	
14	1	GAUGE – "NORGREN" AIR #18-013-207 W/PULSE DAMPER, 0-30 PSI, .25 NPT, BACK CONNECTION, 2" DIAL	093945
13	1	CYLINDER – "MILLER" AIR 3.25 BORE X 4.0 STROKE #AR81B	092668
12	1	VALVE – "CIRCLE SEAL" #249-S-4PP-200 .50 NPT FEMALE	092423
11	1	VALVE – "ROSS" 3 WAY, 2 POS, DBL SOL OPER, DBL VALVE CROSS FLOW W/LC MONITOR, PIPE FLANGES, SILENCER, & EL JUNCTION BOX #3573A5142 NC .75, 24 VDC	279118
10	1	VALVE – "NUMATICS" 4 WAY, 5 SOL, SPRING RET #082SA43A, BASE WITH .25 NPTF SIDE PORTS, INDIVIDUAL EXHAUSTS	311863 B
9	1	VALVE – "SKINNER" AIR 4 WAY,DBL SOL #V935-LET2050 .24VDC	264452
8	1	VALVE – "HANNIFIN" AIR STRAIGHT HANDLE LOCK #CC3M3-25-S	091224
7	2	VALVE – "HUNT" PALM BUTTON OPERATED #02531-H4 .25 NPT	093140
6	1	BRAKE – "FAWICK" #12CTE237 SUPPLIED ON ITEM #23	
5	7	GAUGE – "NORGREN" AIR #18-013-208 W/PULSE DAMPER, 0-160 PSI, .25 NPT, BACK CONNECTION, 2" DIAL	093948
4	1	VALVE – "ROSS" RAIN PLATOON OPERATED, GREEN BUTTON #12223A2005 .25 NPT	094173
3	5	REGULATOR – "NORGREN" #R11-300-RNL 2-125 PSI	093936
2	1	LUBRICATOR – "NORGREN" #L12-400-MPLA50 NPT	093941
1	1	FILTER – AIR "NORGREN" #F12-400-M3TA .50 NPT	093931
SYM	QTY	DESCRIPTION	LITTELL PT NO

PARTS LIST

UNLESS OTHERWISE SPECIFIED FINISHED SURFACES HAVE: 125 MICRO INCH FINISH					
DIMENSIONS	TOLERANCE ±				
X AND X.X	0.1"	CHKD.	12.18.99	JJO	
X.XX	0.01"	DRN.	12.09.99	M.S.	
X.XXX	0.001"	DES.	–	–	
X.XXXX	0.0005"		DATE	NAME	
ANGLES ± 0° 30'		TITLE	DIAGRAM – PNEUMATIC – GRAPHICAL		PART NO. D-309431
BREAK SHARP CORNERS 0.03 UNLESS OTHERWISE SPECIFIED		MACHINE TAKE AWAY ROLLS	BR-4E SHEAR WITH ELECTRIC DRIVEN		
		ORIG. NO. 94020-99		SCALE: NONE	SHT 1 OF 1

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PLOTTED: 08/30/00 AT 11:54