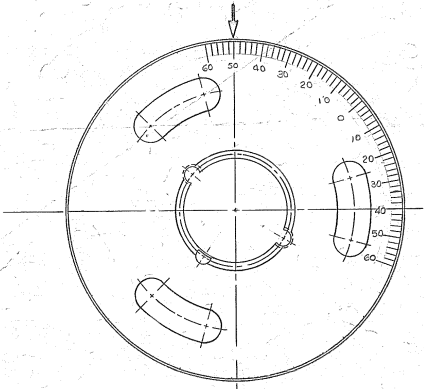


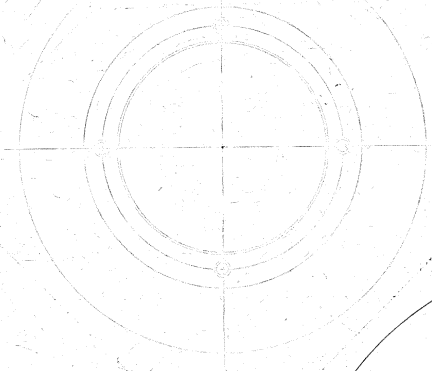
JUN 1987

REVISIONS			
DATE	BY	WAR	BY
1-28-83	A	208° START	5r/1p
		11.3° STOP	
9-2-76	DWG	UP-DATED - TIMING	MARKS
		DIAGRAM SET	TIME
10-8-76	B	110° D.D.	4p
10-8-76	C	330°	4p
6-8-76	D	190°	5 M 6P
6-8-76	E	205°	5 M 6P
6-8-76	F	320°	5 M 6P
6-8-76	G	100°	5 M 6P
6-8-76	H	RESERVED TIMING	5 M 6P

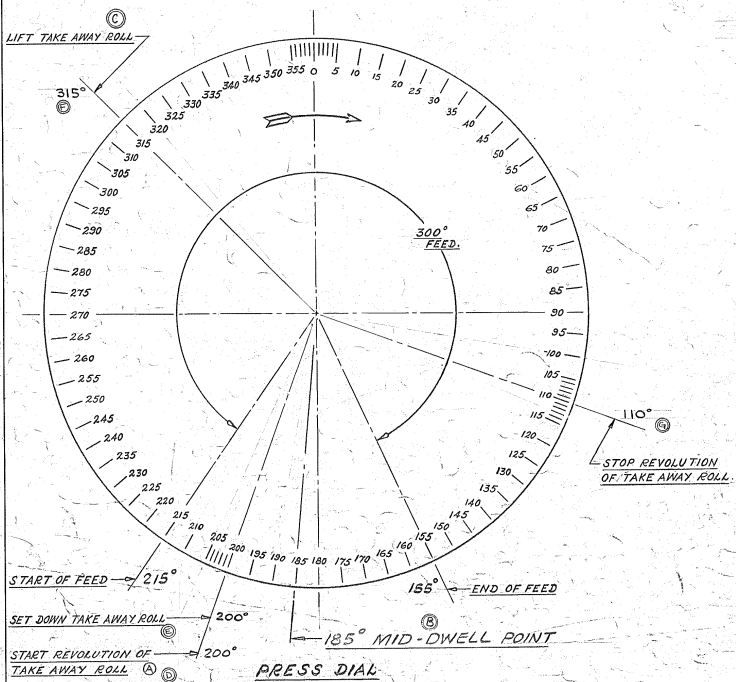
NOTE: FOR TIMING
INDEX PRESS TO 185° (MID-DWELL POINT)
AND SET FEED & TAKE AWAY ROLLS TO "0"



TIMING DISC.
TAKE-AWAY ROLLS



DIE INTERFERENCE CHART.



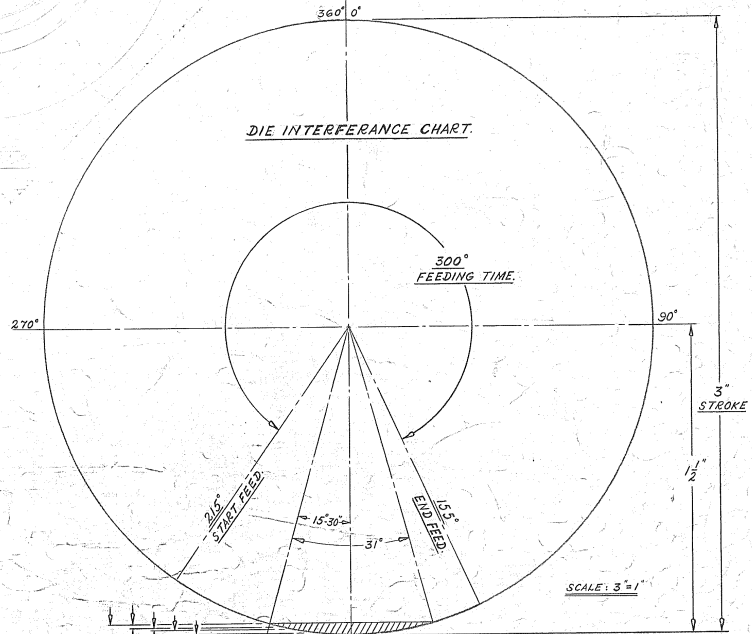
LIFT TAKE AWAY ROLL

START OF FEED

SET DOWN TAKE AWAY ROLL

START REVOLUTION OF TAKE AWAY ROLL

PRESS DIAL



3" STROKE

1/2"

SCALE: 3" = 1"

CUT PIECE LEAVES DIE HERE.

- .010" APPROX. DIE OVERTRAVEL.
- .015" MAX. STOCK THICKNESS.
- .010" APPROX. STRIPPER LEAD.
- .020" APPROX. SHEAR ON PUNCH.
- .055" APPROX. TOTAL DIE INTERFERENCE.

MOTTEL MACHINE CO. "A-1A-6A"

NO.	SCALE	REV.
PART NO.		
MATE. REQ.	BY	M.C.T.
		4p

TITLE: **DIAGRAM - TIMING.**

MACHINE NO. **538 CAM OPERATED ROLL FEED**

ORIGINAL ORDER NUMBER **71800-63**

DWG. NO. **51783**