

SEQUENCE OF OPERATION

INSPECTION GATE  
 PRIME GATE #1  
 REJECT GATE #1  
 REJECT GATE #2

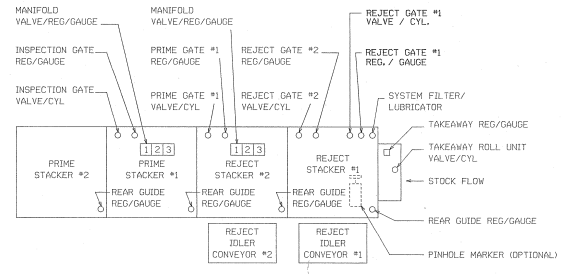
CONTROLLED BY 2 POSITION 4 WAY SINGLE SOLENOID OPERATED VALVE, SOLENOID IS ENERGIZED TO OPEN THE GATES.

PRIME STACKER 1 & 2  
 &  
 REJECT STACKER 1 & 2  
 &  
 REAR GUIDES

CONTROLLED BY 2 POSITION 4 WAY SINGLE SOLENOID OPERATED VALVE, SOLENOID IS ENERGIZED TO OPEN THE SIDE GUIDES AND REAR GUIDES.

TAKEAWAY ROLL  
 CONTROLLED BY 4 POSITION 6 WAY DOUBLE SOLENOID OPERATED VALVE, SOLENOIDS ARE ENERGIZED TO ACTUATE TAKEAWAY MECHANISM

NOTES:  
 USE 'PARKER-HANNIFIN' COMPRESS-A-LIGN FITTINGS  
 ALL TUBINGS TO BE AS NOTED  
 .25" - .375" TUBING - .263" WALL  
 .5" TUBING - .842" WALL  
 .25" PLASTIC TUBING - .044" WALL  
 \*ARTICIAL EASTMAN POLY-FLD #44-P (NATURAL COLOR)



QTY	DESCRIPTION	PART NO.
10	VALVE-NUMATICS-4 WAY SOL. SFG RETURN-NORM. 12-11520432 FC-120/80/60 .25" J.I.C.	893895
14	GAUGE-NORGREN-AIR PRESS. 18-813-288 8-800 PSI .25" BACK CONN.	893946
13	CYLINDER-BIMBY-NON CUSH. 1.5" BORE, 1.0" STROKE, #173-0P	894422
12	CYLINDER-BIMBY-CUSH. BOTH ENDS 1.5" BORE, 3" STROKE, #173-0P	894277
11	CYLINDER-DAWSON-AIR MODEL BN 2.0" BORE, 2.58" STROKE	893889
18	BLDCK - MANIFOLD - AIR	B-134996
10	VALVE-NUMATICS SOL. SOL. W/SINGLE REG. MARK. #11540415/1154042 W-220, 463A REGULATOR (3-38 PSI)	894760
8	VALVE-SOMMER 4 WAY SOL. OPER. #9035-08-2008 115 VOLT 50 / 60 HZ. AIR	893180
7	CYLINDER - BELLOW AIR MOTOR MODEL #8011-5827 1.5" BORE WITH 1" STROKE 115V. - 50 / 60 HZ. SING. SOL. OPERATED AIR - PILOT VALVE WITH PILOT HTG.	898854
6	GAUGE-NORGREN-AIR GAUG. SCALE #18-813-295 2" DUAL SCALE DIA. .25" BACK CONN	893945
5	GAUGE-NORGREN-AIR PRESS. 8-168 PSI #18-813-295 2" DUAL SCALE DIA. .25" BACK CONN	893948
4	REGULATOR-NORGREN-AIR RELIEVING TYPE B 1.5" PSI #11-288-ENE .200"PT	893933
3	REGULATOR -NORGREN - DESIGNER SERIES #11-380-INS. 2 TO 125 PSI-REL.-.375 NPT	893938
2	LUBRICATOR-NORGREN-DESIGNER SERIES #112-480-MPLA .58" NPT - 1/2 NPT	893941
1	FILTER-NORGREN-NORGREN DESIGNER SERIES #F12-480-H3TA-50 .58" NPT-1/2 NPT	893931

SIMTY	DESCRIPTION	PART NO.
1	REAR GUIDE REG/GAUGE	
1	TAKEAWAY ROLL UNIT VALVE/CYL	
1	SYSTEM FILTER/LUBRICATOR	
1	REJECT GATE #1 REG./GAUGE	
1	REJECT GATE #2 REG./GAUGE	
1	PRIME GATE #1 VALVE/CYL	
1	PRIME GATE #2 VALVE/CYL	
1	INSPECTION GATE VALVE/CYL	
1	MANIFOLD VALVE/REG/GAUGE	
1	REAR GUIDE REG/GAUGE	
1	REJECT STACKER #1	
1	REJECT STACKER #2	
1	PRIME STACKER #1	
1	PRIME STACKER #2	
1	REAR GUIDE REG/GAUGE	
1	REJECT IDLER CONVEYOR #1	
1	REJECT IDLER CONVEYOR #2	
1	PINHOLE MARKER (OPTIONAL)	