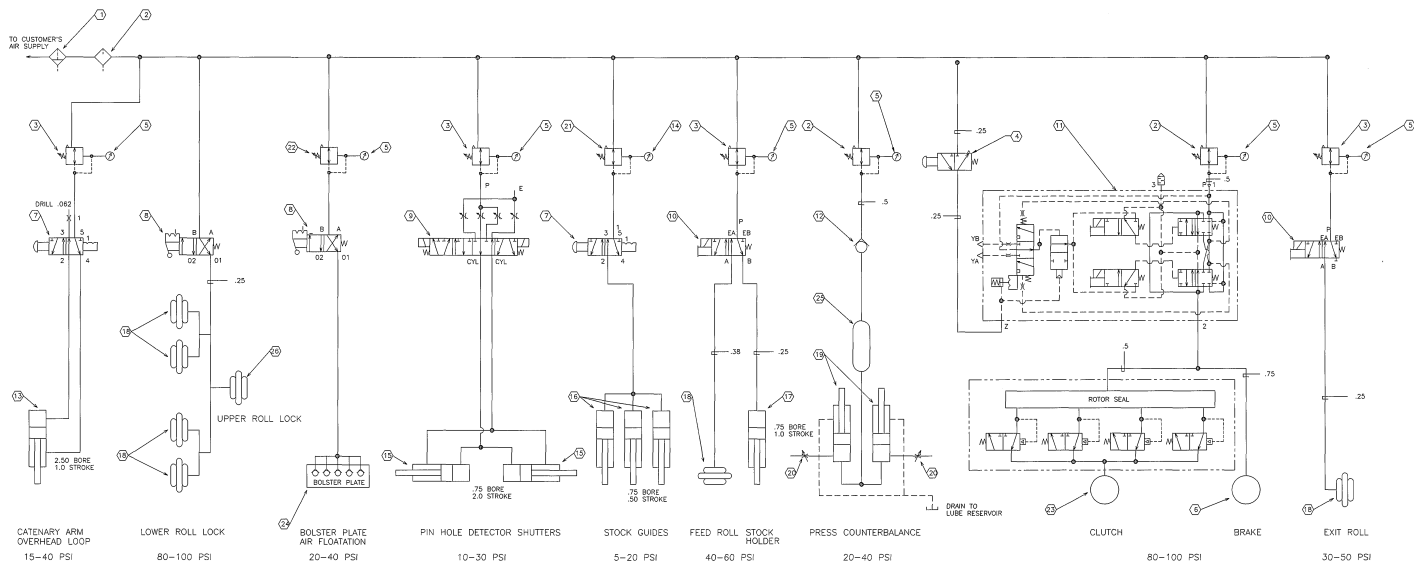


DATE	SYM	ISS	BY
02/27/61	A	BRACE, 264450	J.R.
02/02/61	B	CLUTCH, 092329	J.R.
04/09/61	C	092095	J.R.
04/08/61	D	27, 2150	J.R.
02/02/61	E	40600	J.R.
12/29/59	F	119608, 114314	J.R.
12-28-59	G	11, 950	J.R.
5-5-58	H	40600, CHART	J.R.



NOTE:
USE "PARKER-HANNIFIN" COMPRESS-A-LIGN FITTINGS.
ALL TUBING TO BE .375 UNLESS NOTED.
26-5 TUBING = .035 WALL.

NEW
REV
BY
EA

OLD
1
1
5

SEQUENCE OF OPERATION:

CATEGORY ARM: CONTROLLED BY 4 WAY, 2 POSITION, MANUALLY OPERATED, DETENTED VALVE.
LOWER ROLL LOCK: CONTROLLED BY 4 WAY, 2 POSITION, MANUALLY OPERATED, DETENTED VALVE.
PIN-HOLE 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.
EXIT ROLL: CONTROLLED BY 3 WAY, 2 POSITION, SINGLE SOLENOID OPERATED, SPRING RETURN VALVE.

28	1	ACTUATOR - "FIRESTONE" AIR STROKE	230963
25	1	TANK - SURGE "LITTELL" COUNTERBALANCE	219907
24	14	VALVE - BALL "GEE" STYLE #8 00033 125 NPT	092223
23	1	CLUTCH "FANUC" #16C8500	251760
22	1	REGULATOR "NORGREN" #108-2000-RMA 25 NPT 2-125 PSI	093934
21	2	REGULATOR "NORGREN" #112-400-RMA 50 NPT 0-125 PSI	093935
20	2	RETLOCK - SHUTTER "MORSE" 25 NPT BRASS #146	501515
19	2	CYINDER - AIR "PARKER" COUNTERBALANCE	B-232520
18	6	ACTUATOR -AIR "FIRESTONE" AIR STROKE #16	092871
17	1	CYINDER "BRACK" AIR 75 BORE X 1.00 STROKE, SPRING RETURN, 25 NPT	093379
16	3	CYINDER "LITTELL" AIR 75 BORE X 50 STROKE	A-133182
15	2	CYINDER "BRACK" AIR ACTING, 75 BORE X 2.0 STROKE #BR-042-0	
14	1	GAGE - HP "NORGREN" #18-013-297 0-30 PSI	093945
13	1	CYINDER "MILLER" AIR 2.50 BORE X 1.0 STROKE #810	098169
QTY		DESCRIPTION	LITTELL PT NO
			PARTS LIST

12	1	VALVE "ORCLE SEAL" #248-S-4PP-200 5 NPT FEMALE	092423
11	1	VALVE "ROSS" 3 MM, 2 POS, DBL SOL OPER, DBLE VALVE CROSS FROM 90-1/2 INCH, PIPE FLANGES	
10	2	VALVE "MORSE" 4 WAY, SING SOLENOID, SPRING RET. MARK # #26254320 25 NPT	SEE VOLTAGE CHART
9	1	#V235-DEF250	
8	2	VALVE "NORGREN" AIR 4 WAY, DBL SOLENOID	091224
7	2	25 NPT	093140
6	1	BRAKE "FANUC" #1212327 (SUPPLIED ON ITEM 23)	
5	7	GAGE "NORGREN" AIR #18-013-200 0-60 PSI	093948
4	1	VALVE "ROSS" MAN OPERATED, PALM BUTTON, GREEN	094173
3	5	REGULATOR "NORGREN" #111-300-RNL 375 NPT 2-125 PSI	093936
2	1	LUBRICATOR "NORGREN" #12-100-07A 5 NPT	093941
1	1	FILTER "NORGREN" AIR #F12-100-07A 5 NPT	093931
QTY		DESCRIPTION	LITTELL PT NO
			PARTS LIST

QTY	VOLTAGE CHART
11	110V/50/60HZ 24VDC
11	240454 279118
10	271854 264458
8	090530 264452

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DATE: 02/26/61
 DRAWN BY: J.R.
 CHECKED BY: J.R.
 TITLE: SCHEMATIC - PNEUMATIC - GRAPHICAL
 PART NO: D-240809
 SCALE: 1" = 1"

FORM NO. 240809