One working cycle follows this conditions: after indicating of the right clamping of the piece (block) via a sensor the processing of one couple begins. The sectional die on the pneumatic motor A presses the cylinder in - the two pieces in the couple together - via one slow and then one quick stroke. Then the motor A must stay in the extracted position and clamp the piece until the pneumatic motor B will have pressed the securing bolt from the side. Pressing in of the securing bolt is done by one slow and two quick strokes. Then the pneumatic motor C throws away the completed couple and the next couple of the pieces can be brought in.

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|  |  |  |  |
| --- | --- | --- | --- |
| cylinder | position | securing | slow |
| securing | slow | cylinder | position |
| cylinder | position | securing | slow |
| securing | slow | cylinder | position |
| cylinder | position | cylinder | position |