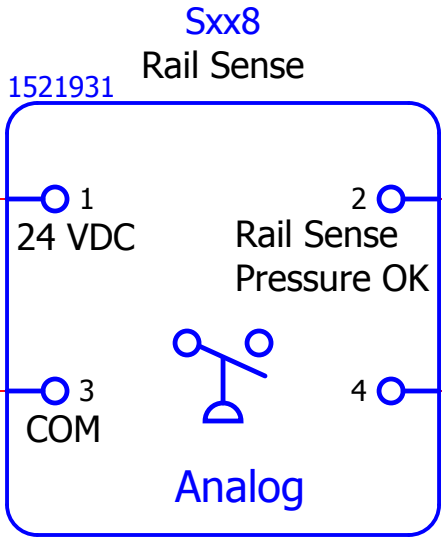
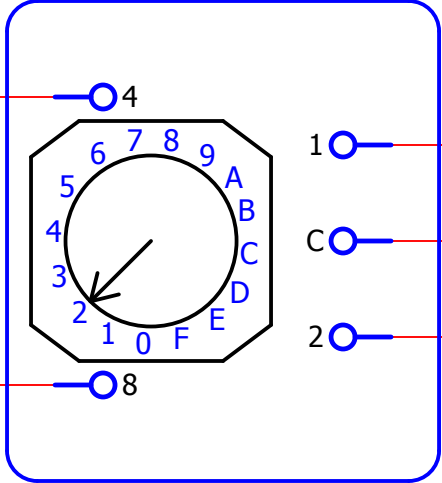


10000
10001
10002
10003
10004
10005
10006
10007
10008
10009
10010
10011
10012
10013
10014
10015
10016
10017
10018
10019
10020

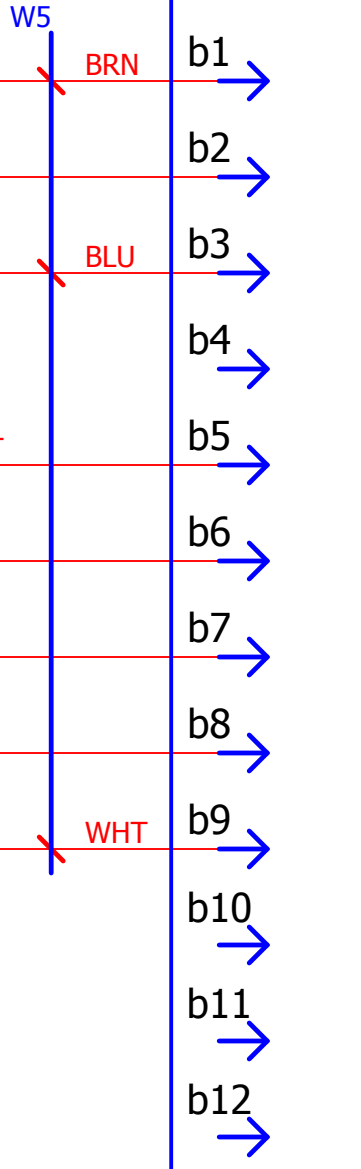
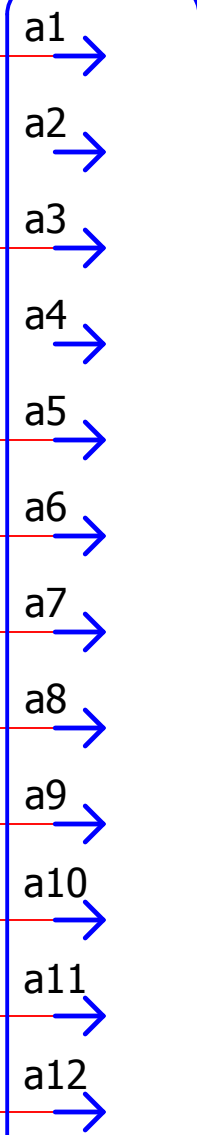
To Prox Block 10101 /

Belden 9593
Cut Length 19"
Strip Length @ Hex 1 1/2"
@ Harting 6"
Cut Out Spare Wires

AUTO-SWITCH-19
Hex Switch
Binary Select

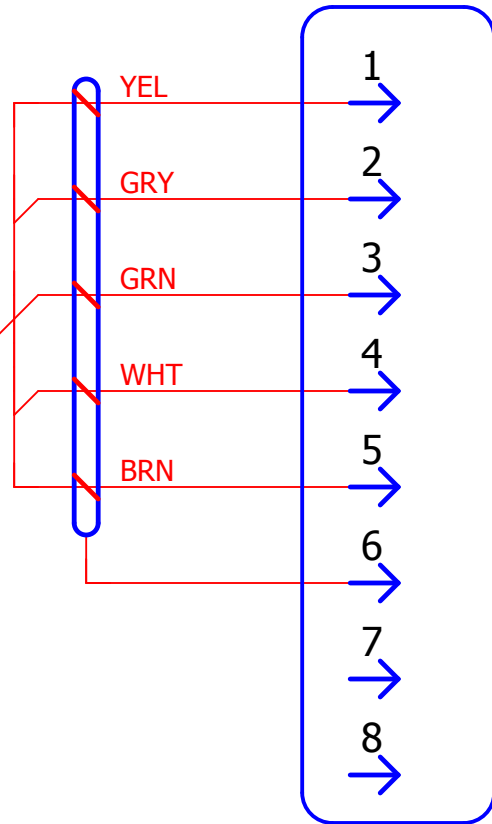


Standard Harting



PE

CPI Harting



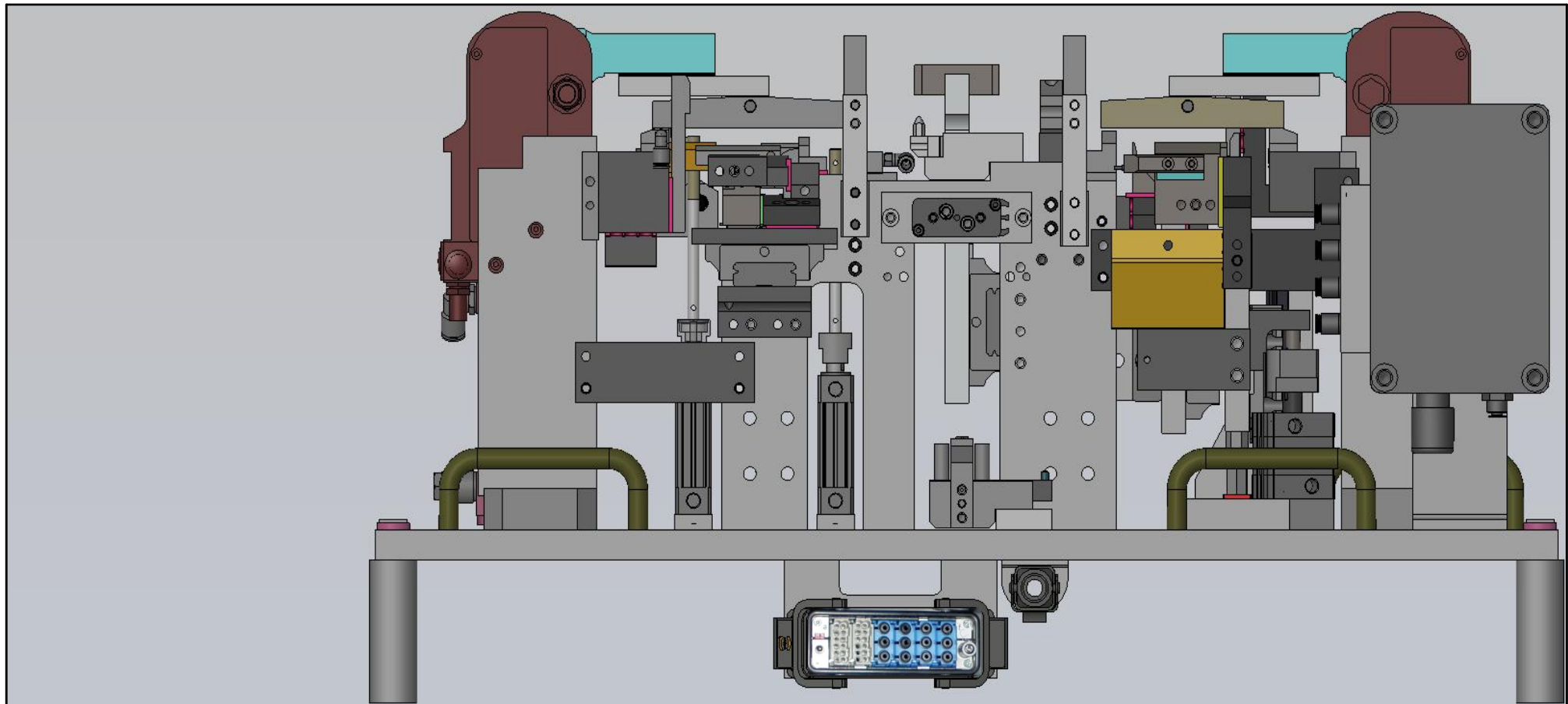
To 1st CPI
Input Block

10122 /

Note: Only Installed If Additional Inputs Are Required

Tooling Information

Serial #	18002-02
Variant	C483 UR LH IB S06EL
Assembly #	E04994
Machine #	PP2.12
Position	Frame 1 Place B
Tooling ID	2
Asset #	61100810



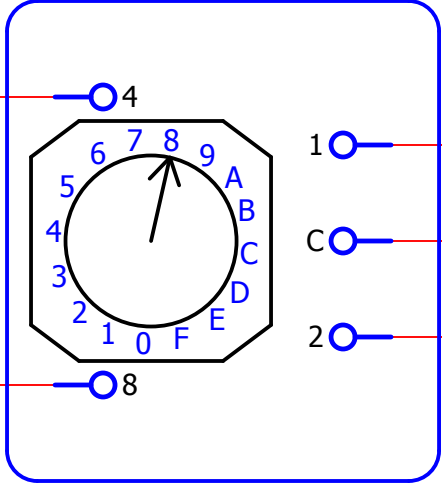
*Refer to Air Schematic for Detailed Pin Locations

10000
10001
10002
10003
10004
10005
10006
10007
10008
10009
10010
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10012
10013
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10015
10016
10017
10018
10019
10020

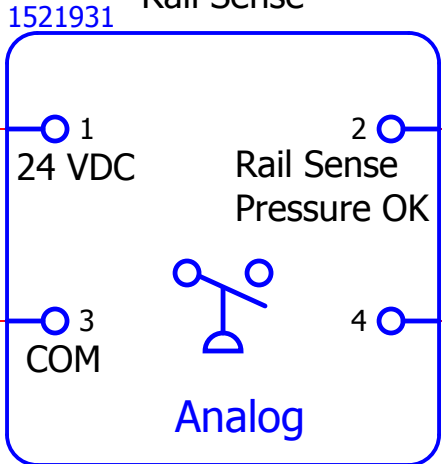
To Prox Block 10101 /

Belden 9593
Cut Length 19"
Strip Length @ Hex 1 1/2"
@ Harting 6"
Cut Out Spare Wires

AUTO-SWITCH-19
Hex Switch
Binary Select

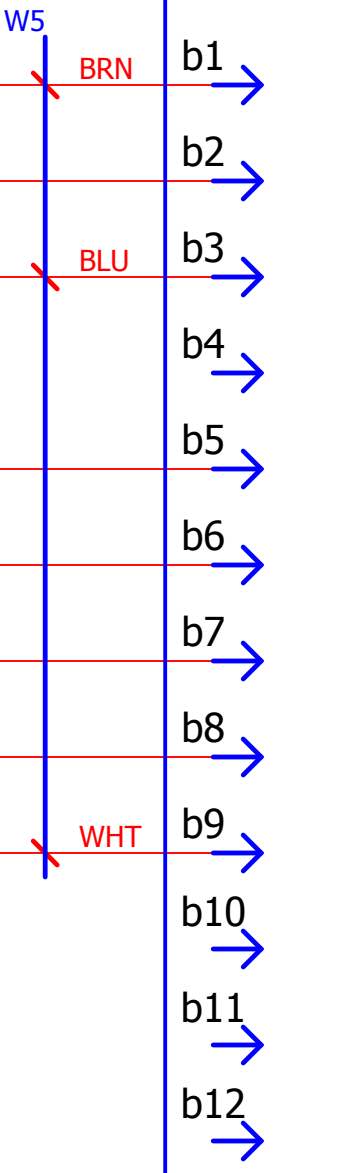
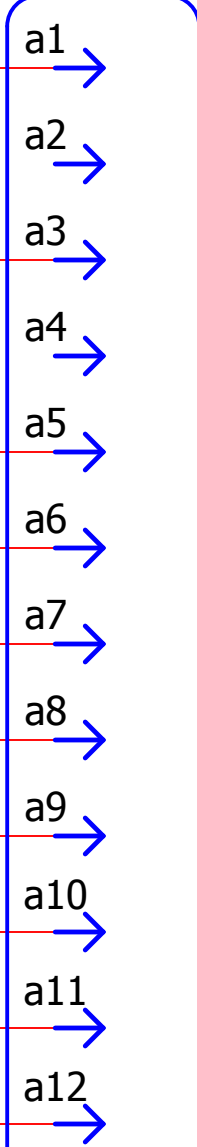


Sxx8
Rail Sense



Heat Shrink

Standard Harting



CPI Harting

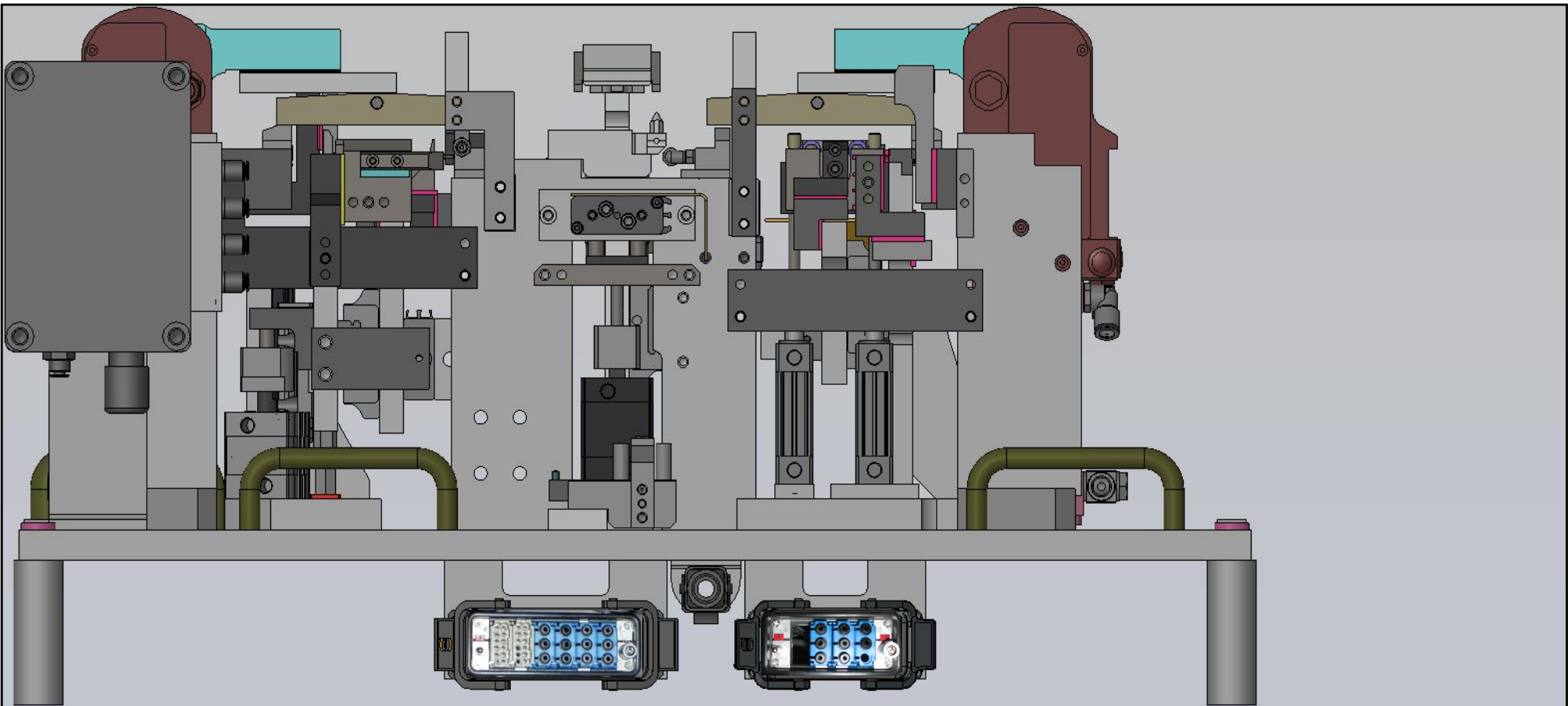
To 1st CPI
Input Block

10122 /

Note: Only Installed If Additional Inputs Are Required

Tooling Information

Serial #	18002-08
Variant	C482 UR LH OB S04/S06EL
Assembly #	E04895/E04997
Machine #	PP2.12
Position	Frame 2 Place D
Tooling ID	8
Asset #	61100816



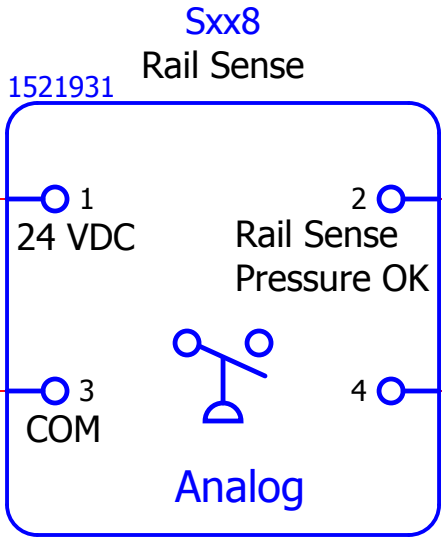
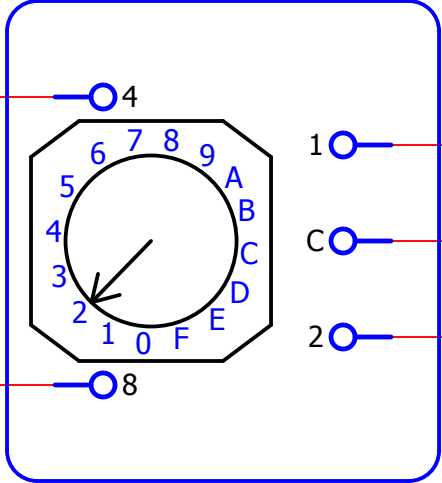
*Refer to Air Schematic for Detailed Pin Locations

10000
10001
10002
10003
10004
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10006
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10008
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10010
10011
10012
10013
10014
10015
10016
10017
10018
10019
10020

To Prox Block 10101 /

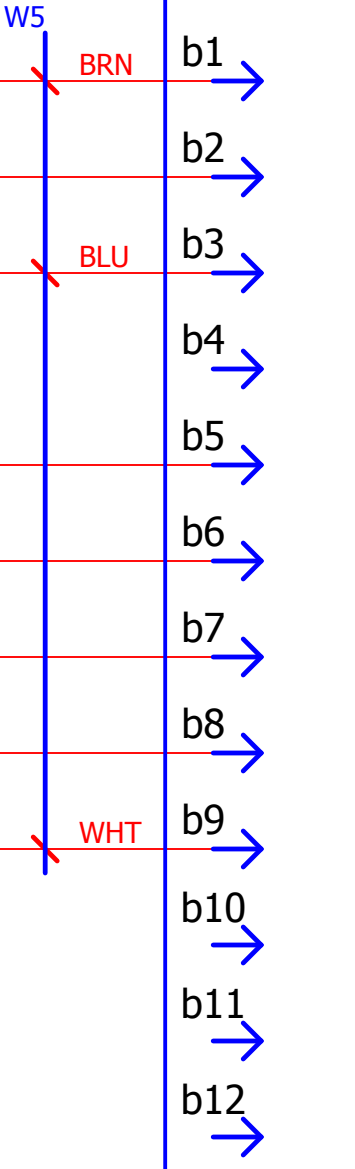
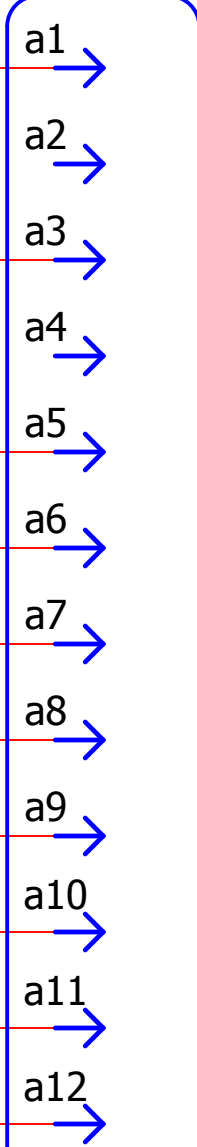
Belden 9593
Cut Length 19"
Strip Length @ Hex 1 1/2"
@ Harting 6"
Cut Out Spare Wires

AUTO-SWITCH-19
Hex Switch
Binary Select

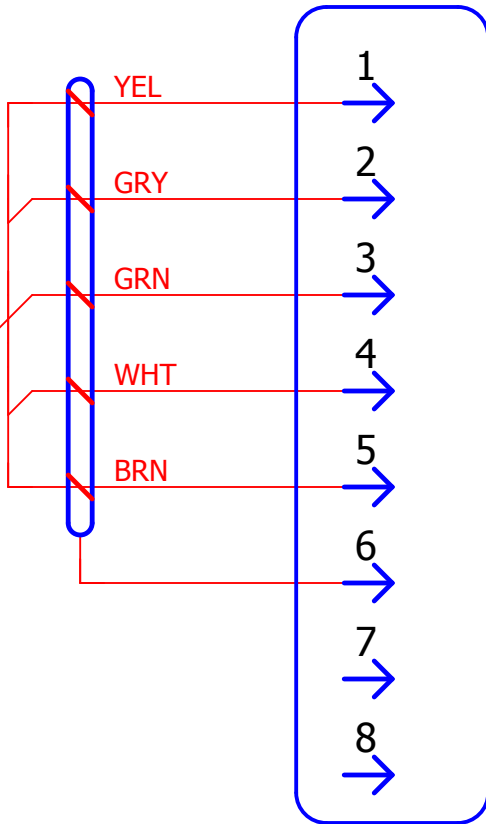


Heat Shrink

Standard Harting



CPI Harting



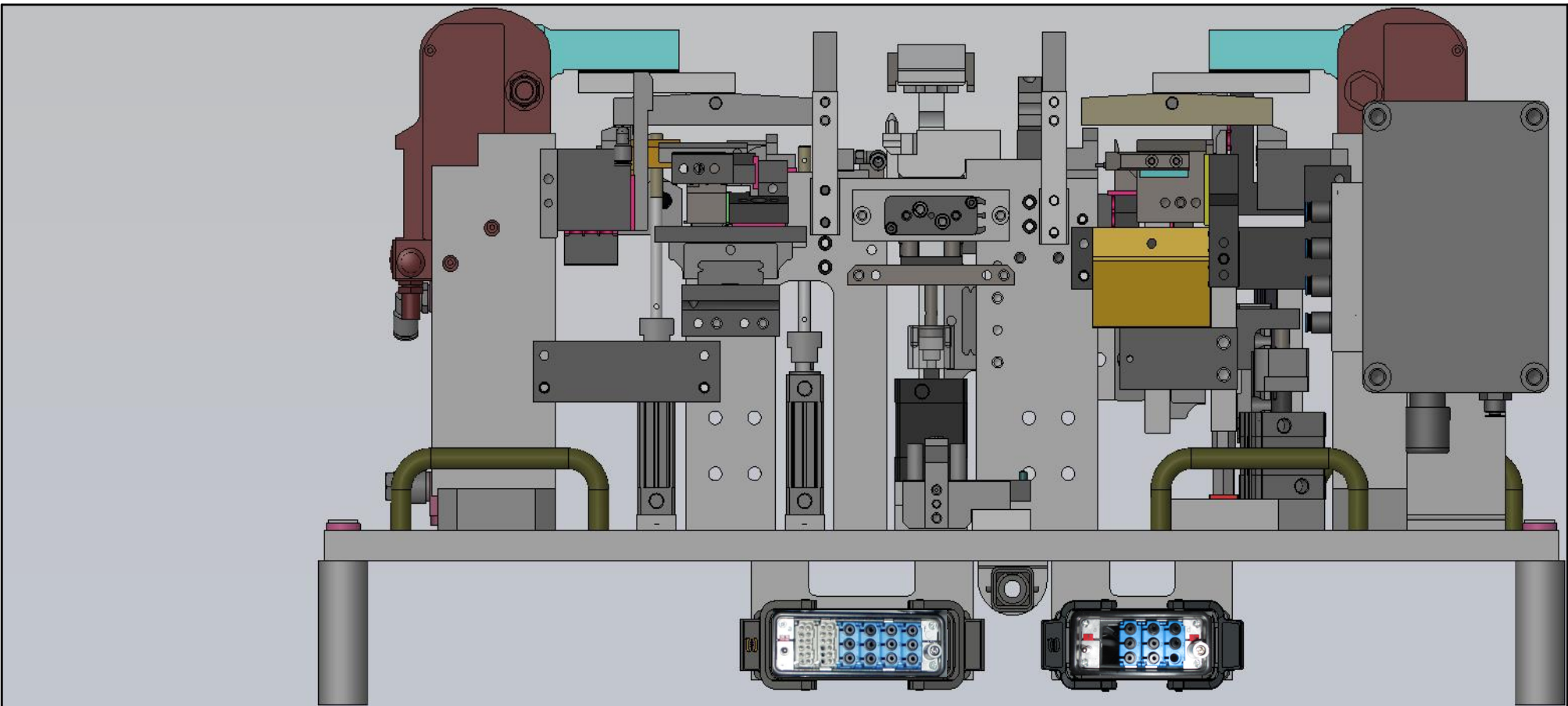
To 1st CPI
Input Block

10122 /

Note: Only Installed If Additional Inputs Are Required

Tooling Information

Serial #	18002-14
Variant	C482 UR LH IB S04/S06EL
Assembly #	E04897/E04994
Machine #	PP2.14
Position	Frame 1 Place B
Tooling ID	2
Asset #	61100800



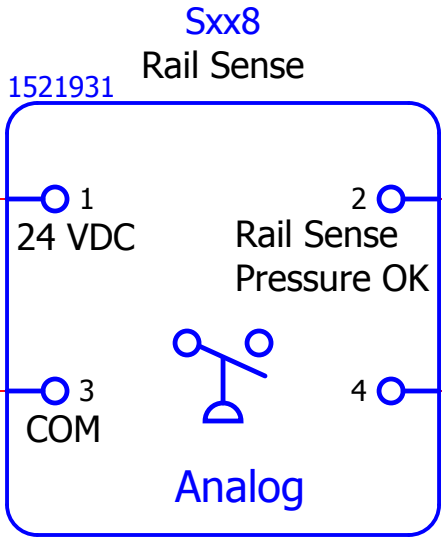
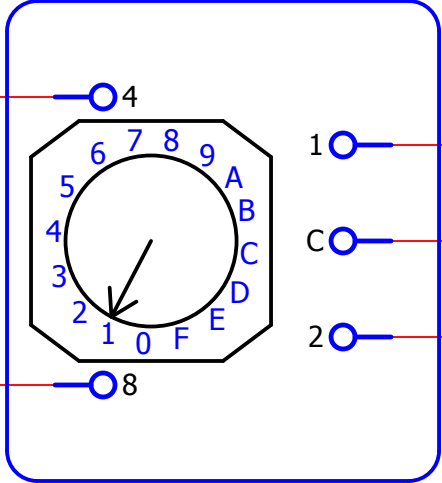
*Refer to Air Schematic for Detailed Pin Locations

10000
10001
10002
10003
10004
10005
10006
10007
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10009
10010
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10012
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10015
10016
10017
10018
10019
10020

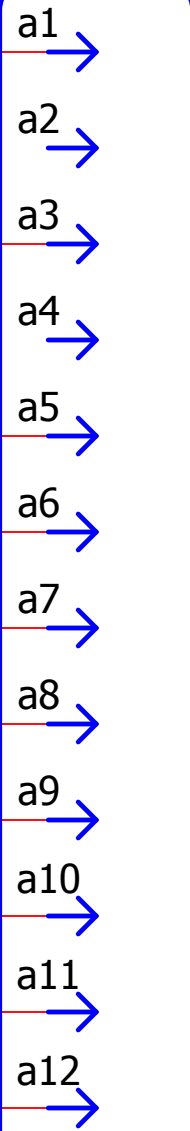
To Prox Block 10101 /

Belden 9593
Cut Length 19"
Strip Length @ Hex 1 1/2"
@ Harting 6"
Cut Out Spare Wires

AUTO-SWITCH-19
Hex Switch
Binary Select



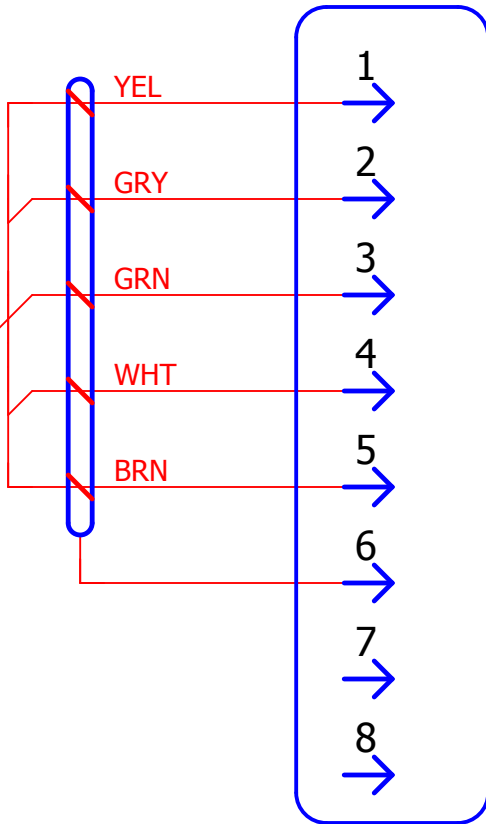
Standard Harting



CPI Harting

To 1st CPI
Input Block

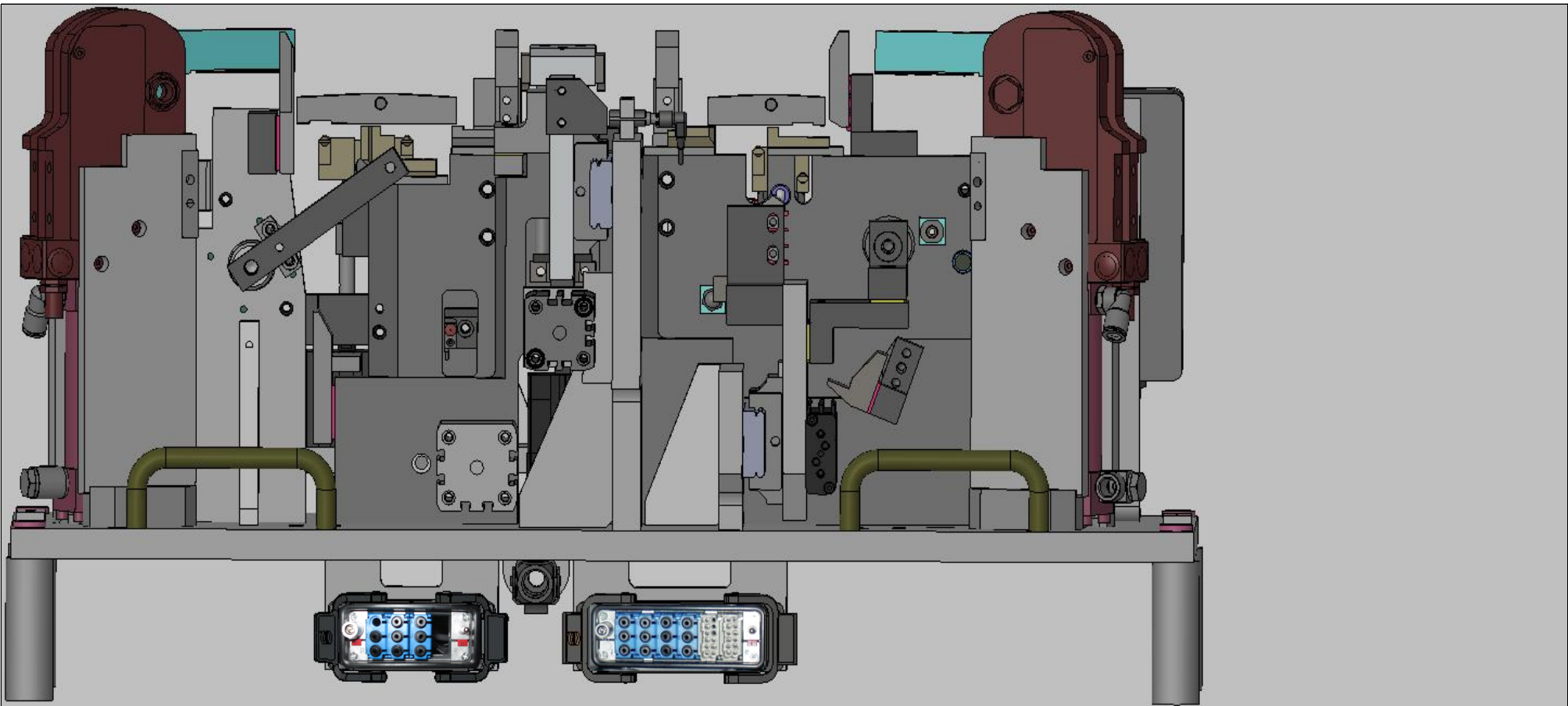
10122 /



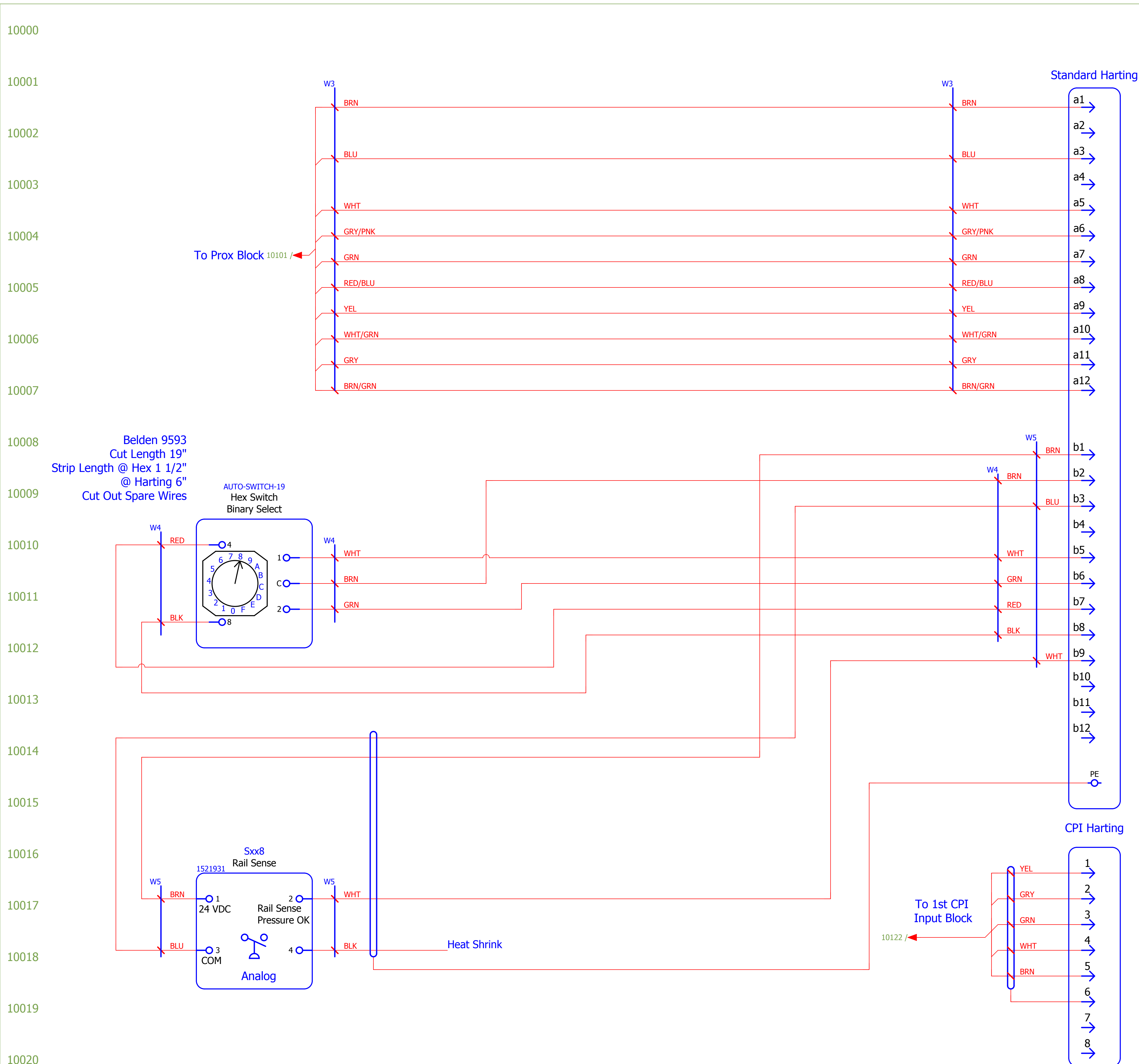
Note: Only Installed If Additional Inputs Are Required

Tooling Information

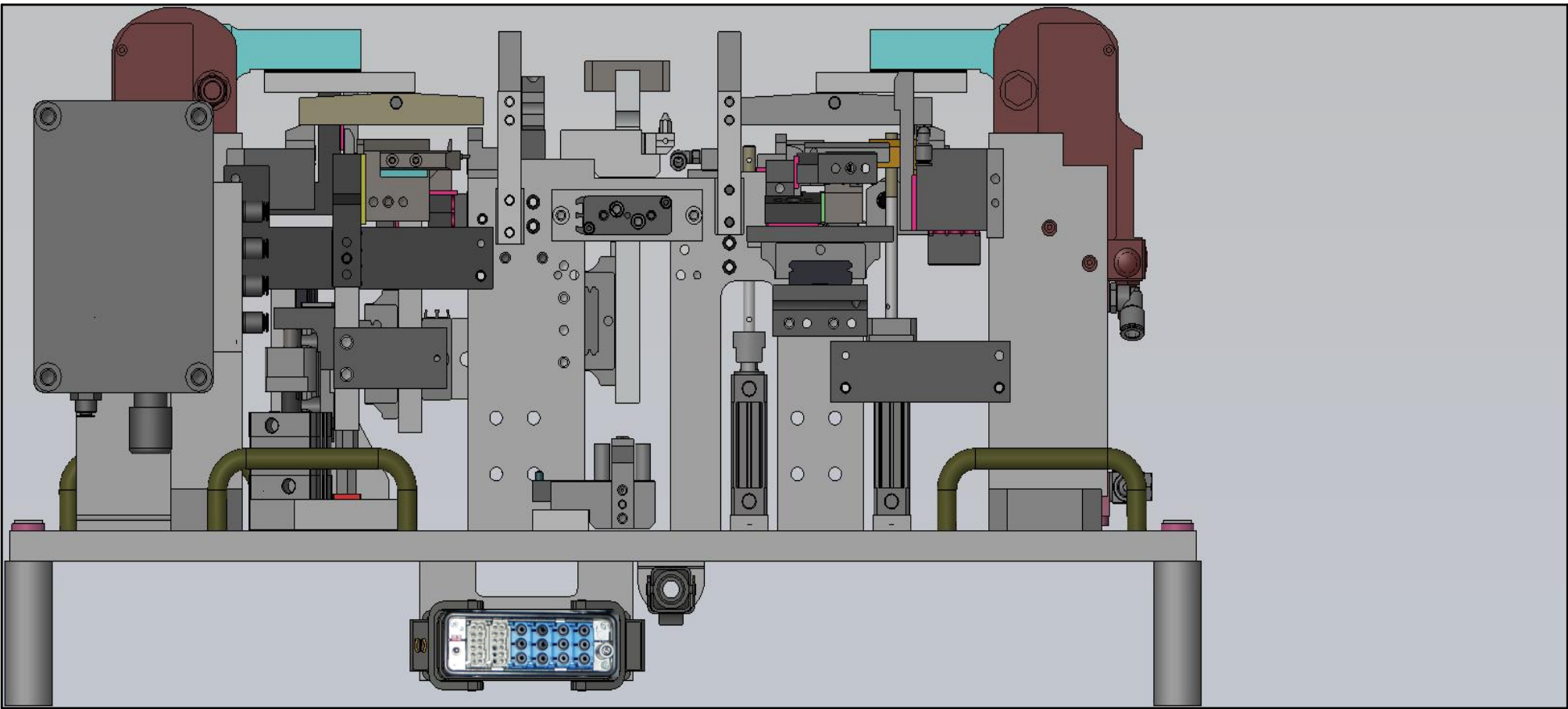
Serial #	18002-17
Variant	S02MA UR RH HIGH OB
Assembly #	E04904
Machine #	PP2.15
Position	Frame 1 Place A
Tooling ID	1
Asset #	61100820



*Refer to Air Schematic for Detailed Pin Locations



Tooling Information	
Serial #	18002-24
Variant	C483 UR RH IB S06EL
Assembly #	E05511
Machine #	PP2.16
Position	Frame 2 Place D
Tooling ID	8
Asset #	61100818



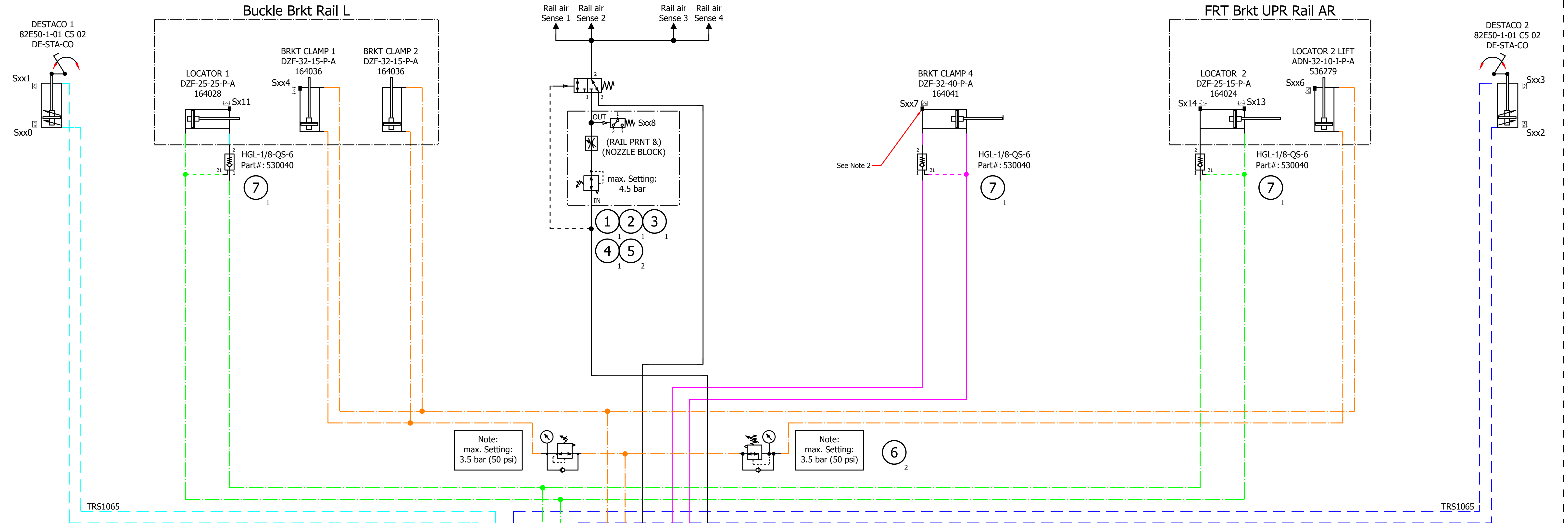
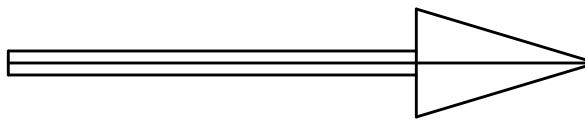
*Refer to Air Schematic for Detailed Pin Locations

Note: Only Installed If Additional Inputs Are Required

on tooling plate

Laser Cell
Tooling for Ass'y #E04994 (Mech. Layout#18002-02)
PP2.12 Tooling frame 1 - Place B

Driving Direction



Operator Side

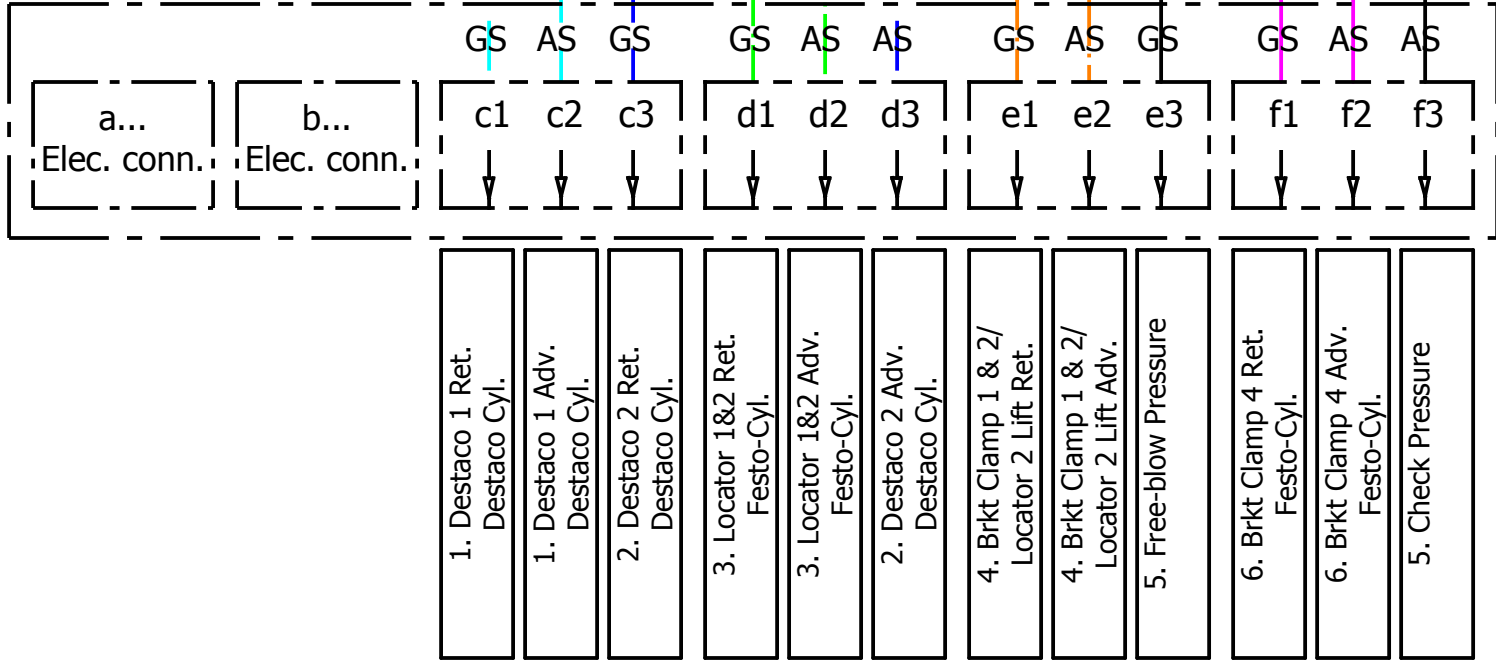
TOOLING FIXTURE OPERATING SEQUENCE (E04994)

Insert all assy brackets (#934430 & #C55600)
Insert Rail (#E04995)

Start cycle

Step #1, Locator 1 & 2 advanced (V3),
Bracket Clamp 4 advanced (V6)
Step #2, Destaco 1 & 2 advanced (V1 & V2)
Step #3, Bracket Clamp 1 & 2/Locator 2 Lift advanced (V4),
Energize Check Pressure/Rail present (V5)
Step #4, De-energize Check Pressure (V5)

Harting - Surface Mount
Hanmodular-6 Module Frame
at device



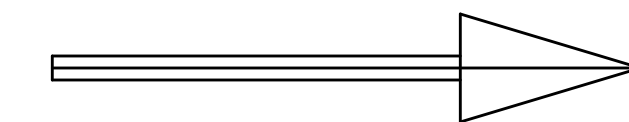
see page 202 to page 209 of
"pneumatics sch. for Tooling frame"

Note 1:
Hose line between valve terminals and Harting plugs: Outer DM. 6mm
Hose line between Destaco Cyl. and Harting plugs: Outer DM. 10mm (99118-1006)
Hose line between Cyl. and Harting plugs: Outer DM. 6mm (99118-0604)
AS - Cylinder Advance, GS - Cylinder Return
Note 2:
Install memory stone to all the hall switches on the cylinders
Install memory stone to all the hall switches on the rotary cylinders

[illegible]

Operator Side

Driving Direction

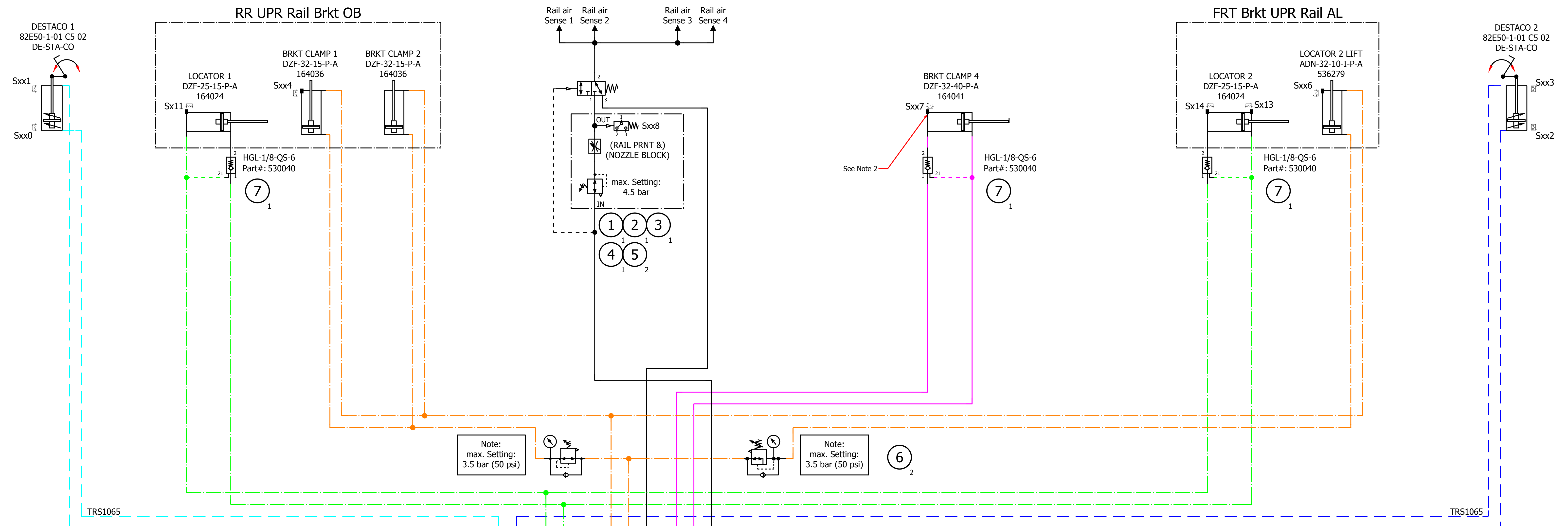


Sx10 RR Upper Rail Bracket OB (935264) Present

Sx15 Front Bracket Upper Rail AL (C55599) Present

on tooling plate

Laser Cell
Tooling for Ass'y #E04997 (Mech. Layout#18002-04)
PP2.12 Tooling frame 2 - Place B



under tooling plate

TOOLING FIXTURE OPERATING SEQUENCE (E04997)

Insert all assy brackets (#935264 & #C55599)
Insert Rail (#E04998)

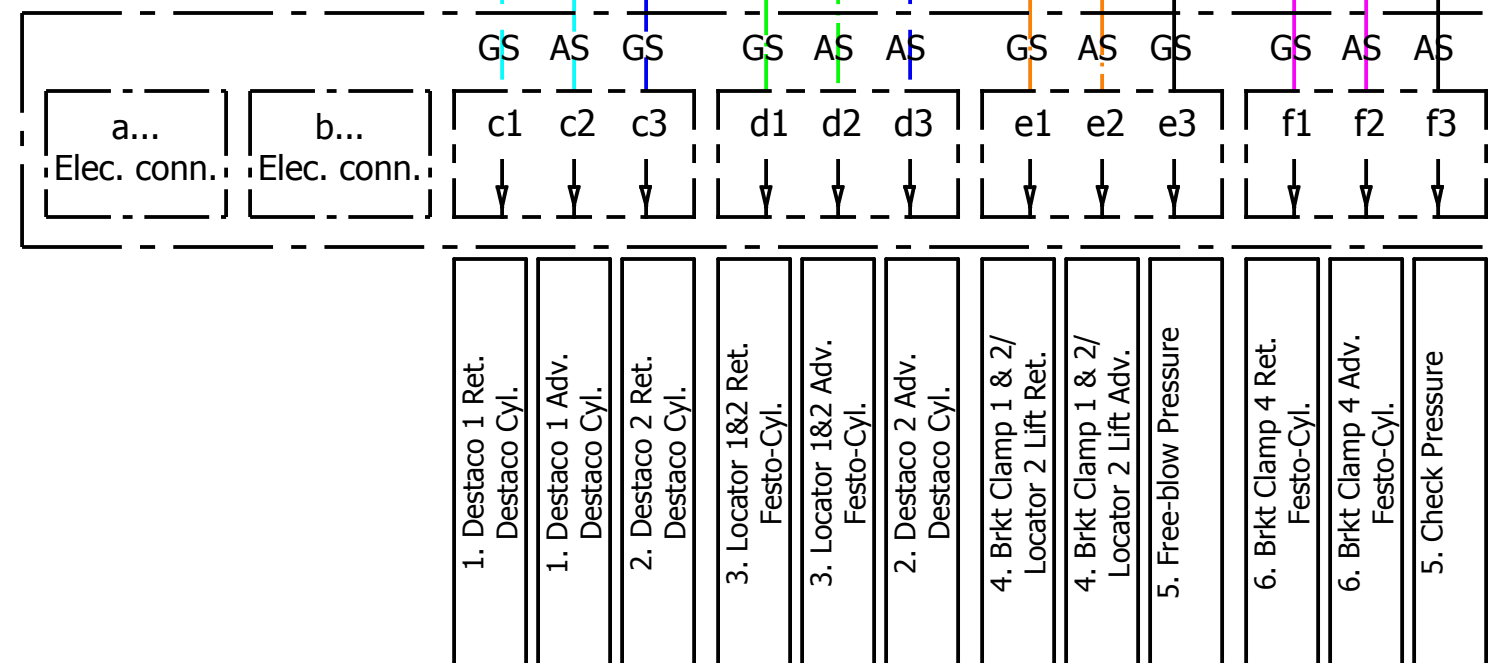
Start cycle

Step #1, Locator 1 & 2 advanced (V3),
Bracket Clamp 4 advanced (V6)
Step #2, Destaco 1 & 2 advanced (V1 & V2)
Step #3, Bracket Clamp 1 & 2/Locator 2 Lift advanced (V4),
Energize Check Pressure/Rail present (V5)
Step #4, De-energize Check Pressure (V5)

After welding:

Step #1, De-energize Bracket Clamp 1 & 2/Locator 2 Lift advance (V4),
Step #2, Locator 1 & 2 returned (V3),
Bracket Clamp 4 returned (V6)
Step #3, Bracket Clamp 1 & 2/Locator 2 Lift returned (V4)
Step #4, Destaco 1 & 2 returned (V1 & V2)
Step #5, Bracket Clamp 1 & 2/Locator 2 Lift advanced for part eject (V4),
Energize Free-Blow Pressure for nozzle clean (V5)
Step #6, Bracket Clamp 1 & 2/Locator 2 Lift returned (V4),
De-energize Free-Blow Pressure (V5)
Welded part unloaded

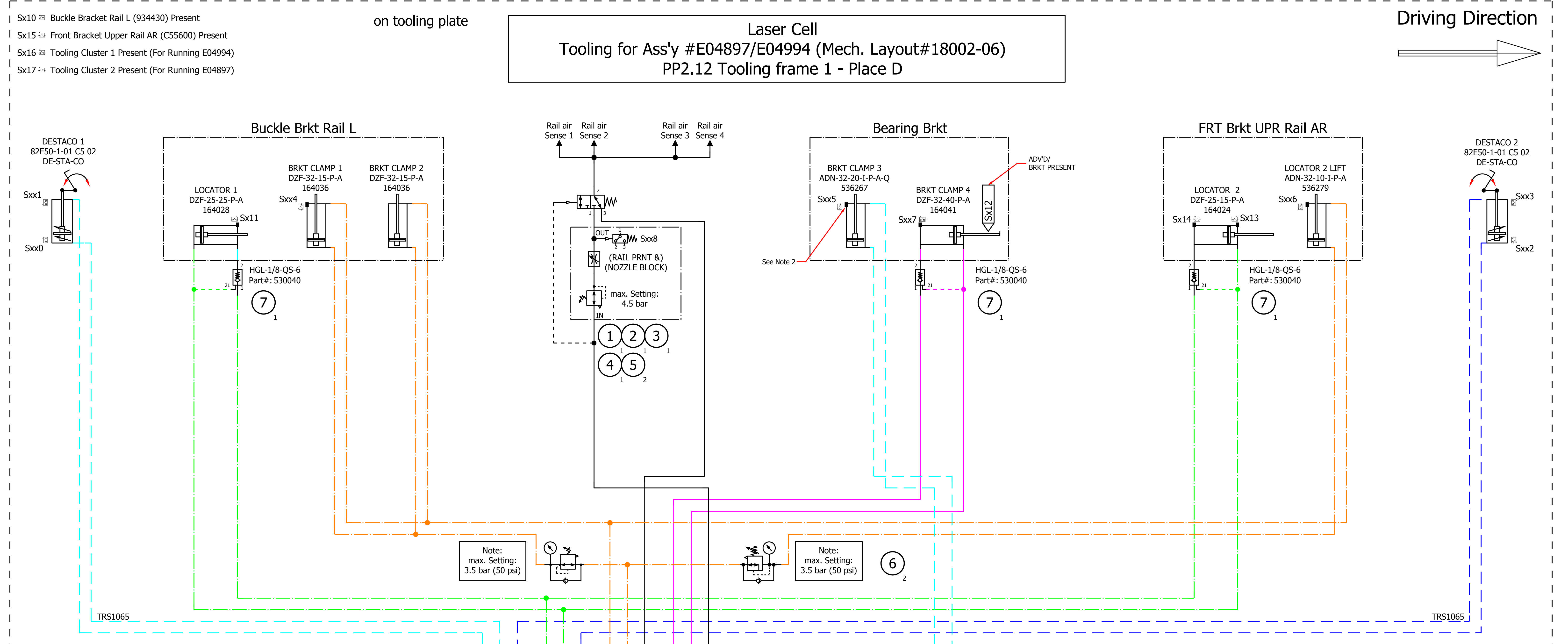
Harting - Surface Mount
Hanmodular-6 Module Frame
at device



see page 202 to page 209 of
"pneumatics sch. for Tooling frame"

Note 1:
Hose line between valve terminals and Harting plugs: Outer DM. 6mm
Hose line between Destaco Cyl. and Harting plugs: Outer DM. 10mm (99118-1006)
Hose line between Cyl. and Harting plugs: Outer DM. 6mm (99118-0604)
AS - Cylinder Advance, GS - Cylinder Return
Note 2:
Install memory stone to all the hall switches on the cylinders
Install memory stone to all the hall switches on the rotary cylinders

[illegible]



TOOLING FIXTURE OPERATING SEQUENCE (E04897/E04994)

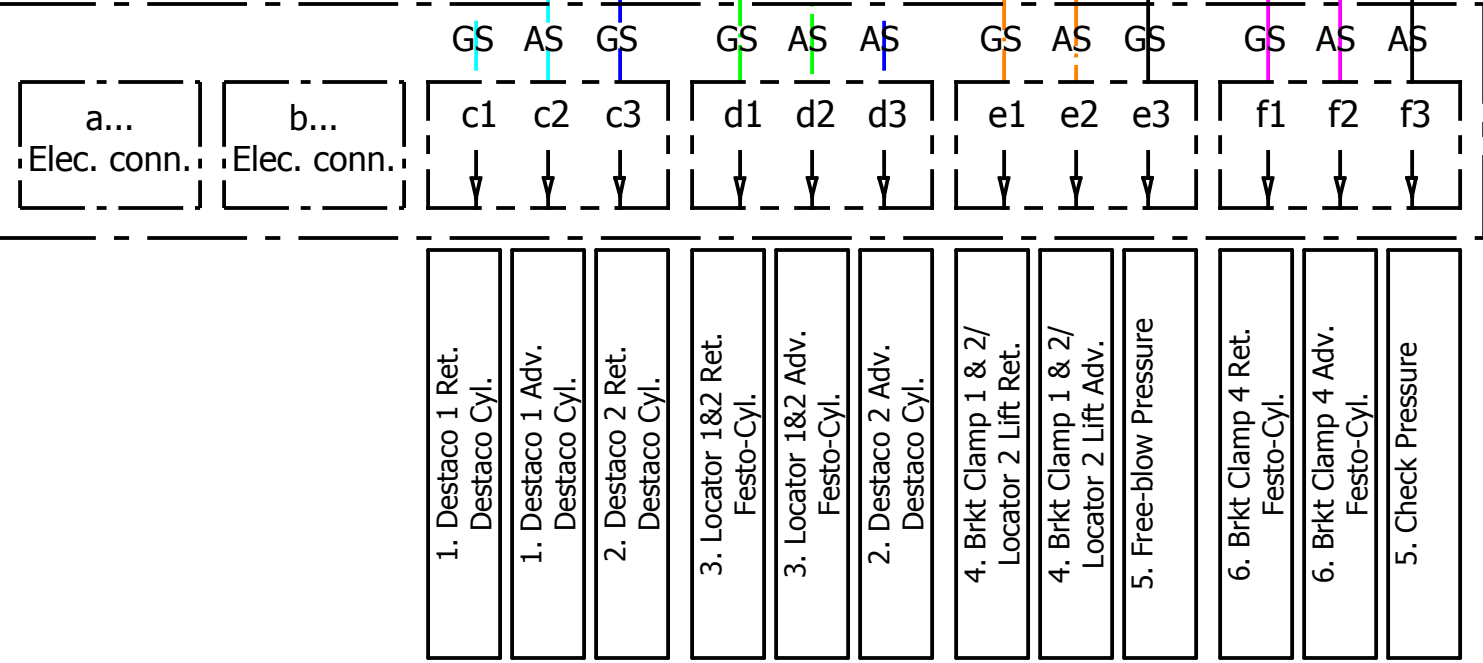
Insert all assy brackets (#934430, #984908 & #C55600) for E04897 or (#934430 & #C55600) for E04994
Insert Rail (#E04891) for E04897 or (#E04995) for E04994

- Start cycle
Step #1, Locator 1 & 2 advanced (V3),
Bracket Clamp 4 advanced/Bearing Brkt (#984908) Present (V6)
Step #2, Destaco 1 & 2 advanced (V1 & V2)
Step #3, Bracket Clamp 1 & 2/Locator 2 Lift advanced (V4),
Bracket clamp 3 advanced (V7),
Energize Check Pressure/Rail present (V5)
Step #4, De-energize Check Pressure (V5)

- After welding:
Step #1, De-energize Bracket Clamp 1 & 2/Locator 2 Lift advance (V4),
Bracket Clamp 3 returned (V7)
Step #2, Locator 1 & 2 returned (V3),
Bracket Clamp 4 returned (V6)
Step #3, Bracket Clamp 1 & 2/Locator 2 Lift returned (V4)
Step #4, Destaco 1 & 2 returned (V1 & V2)
Step #5, Bracket Clamp 1 & 2/Locator 2 Lift advanced for part eject (V4),
Energize Free-Blow Pressure for nozzle clean (V5)
Step #6, Bracket Clamp 1 & 2/Locator 2 Lift returned (V4),
De-energize Free-Blow Pressure (V5)
Welded part unloaded

under tooling plate

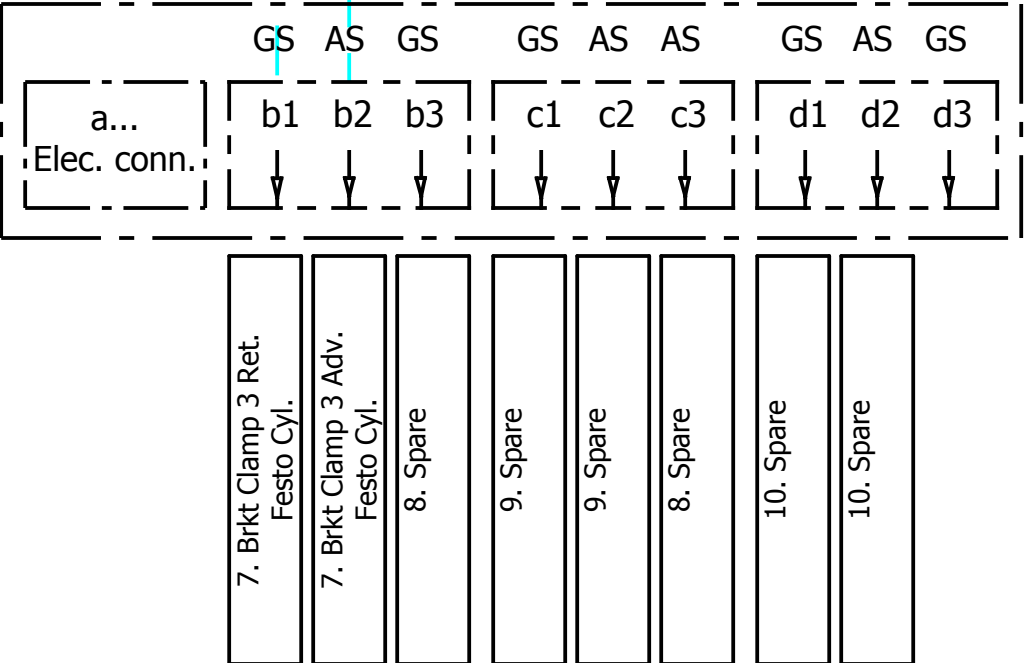
Harting - Surface Mount
Hanmodular-6 Module Frame
at device



see page 202 to page 209 of
"pneumatics sch. for Tooling frame"

Operator Side

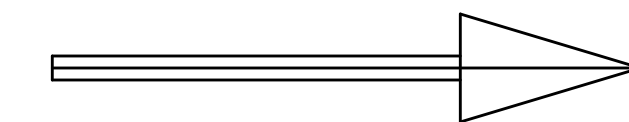
Harting - Surface Mount
Hanmodular-4 Module Frame
at device





- Note 1:
Hose line between valve terminals and Harting plugs: Outer DM. 6mm
Hose line between Destaco Cyl. and Harting plugs: Outer DM. 10mm (99118-1006)
Hose line between Cyl. and Harting plugs: Outer DM. 6mm (99118-0604)
AS - Cylinder Advance, GS - Cylinder Return
Note 2:
Install memory stone to all the hall switches on the cylinders
Install memory stone to all the hall switches on the rotary cylinders


Operator Side


Driving Direction



Sx10  RR Upper Rail Bracket OB (935264) Present

Sx15  Front Bracket Upper Rail AL (C55599) Present

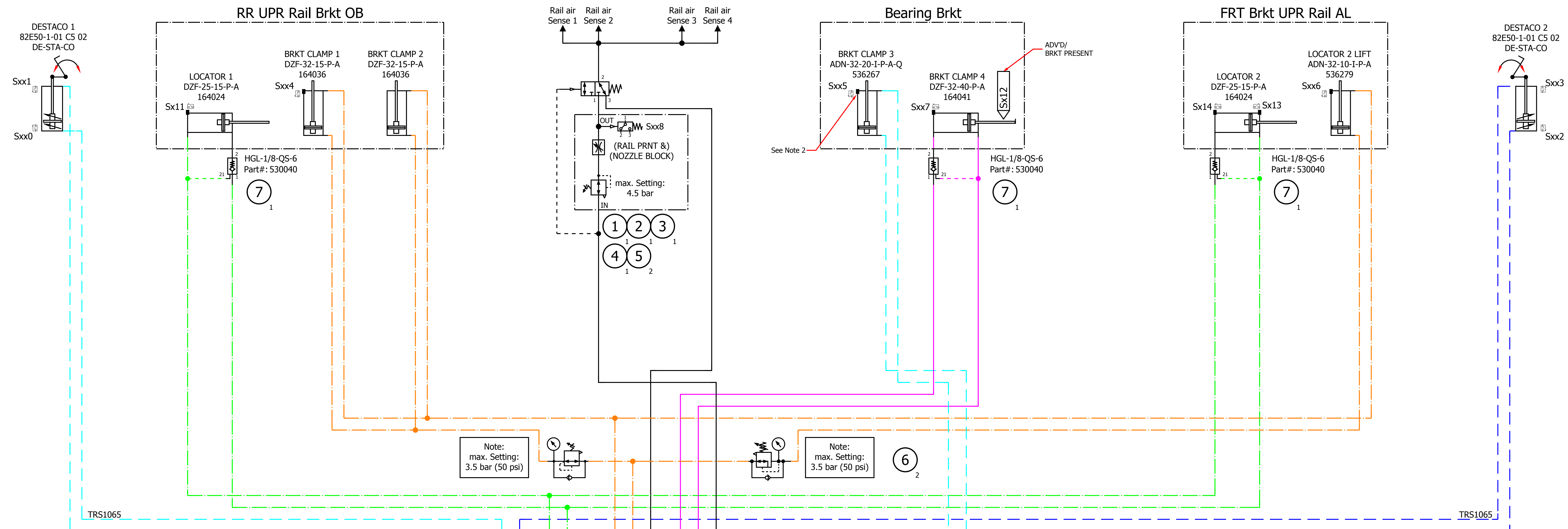
Sx16  Tooling Cluster 1 Present (For Running E04997)

Sx17  Tooling Cluster 2 Present (For Running E04895)

on tooling plate

Laser Cell

Tooling for Ass'y #E04895/#E04997 (Mech. Layout#18002-08)
PP2.12 Tooling frame 2 - Place D



under tooling plate

TOOLING FIXTURE OPERATING SEQUENCE (E04895/E04997)

Insert all assy brackets (#935264, #984908 & #C55599) for E04895 or (#935264 & #C55599) for E04997
Insert Rail (#E04887) for E04895 or (#E04998) for E04997

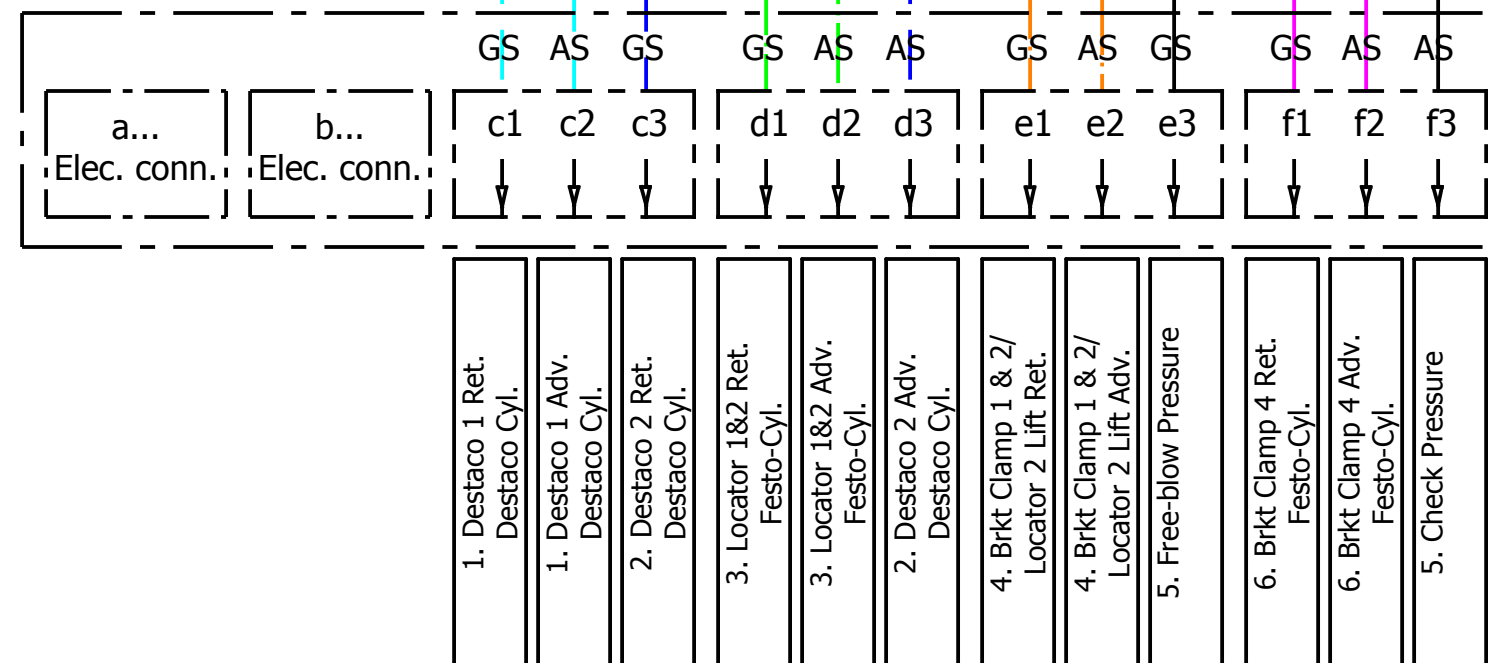
Start cycle

Step #1, Locator 1 & 2 advanced (V3),
Bracket Clamp 4 advanced/Bearing Brkt (#984908) Present (V6)
Step #2, Destaco 1 & 2 advanced (V1 & V2)
Step #3, Bracket Clamp 1 & 2/Locator 2 Lift advanced (V4),
Bracket clamp 3 advanced (V7),
Energize Check Pressure/Rail present (V5)
Step #4, De-energize Check Pressure (V8)

After welding:

Step #1, De-energize Bracket Clamp 1 & 2/Locator 2 Lift advance (V4),
Bracket Clamp 3 returned (V7)
Step #2, Locator 1 & 2 returned (V3),
Bracket Clamp 4 returned (V6)
Step #3, Bracket Clamp 1 & 2/Locator 2 Lift returned (V4)
Step #4, Destaco 1 & 2 returned (V1 & V2)
Step #5, Bracket Clamp 1 & 2/Locator 2 Lift advanced for part eject (V4),
Energize Free-Blow Pressure for nozzle clean (V5)
Step #6, Bracket Clamp 1 & 2/Locator 2 Lift returned (V4),
De-energize Free-Blow Pressure (V5)
Welded part unloaded

Harting - Surface Mount
Hanmodular-6 Module Frame
at device

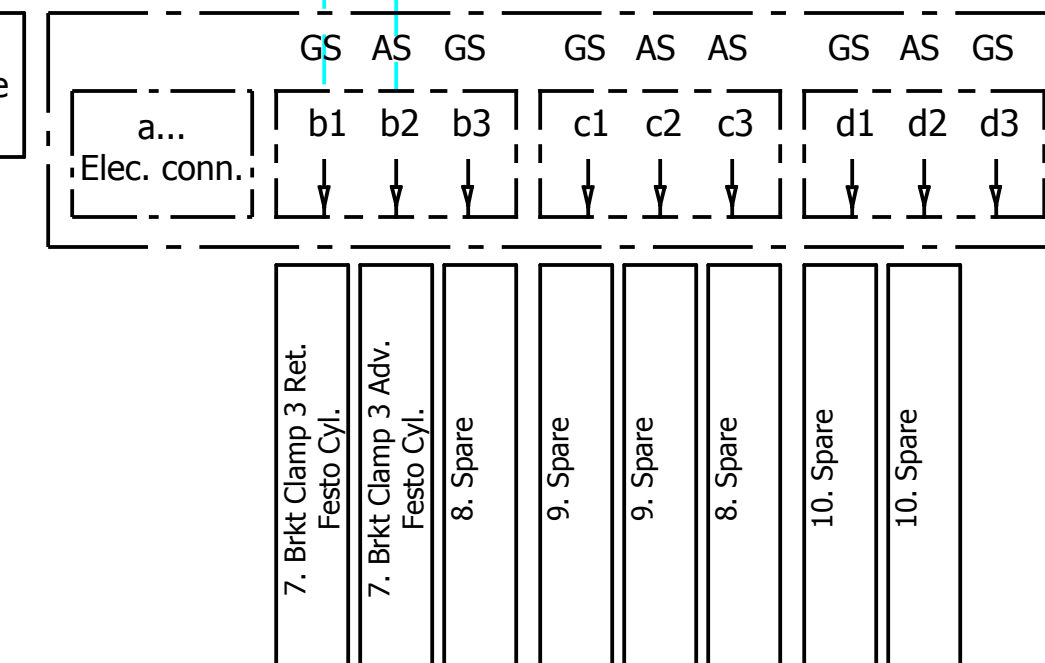


see page 202 to page 209 of
"pneumatics sch. for Tooling frame"

Note 1:
Hose line between valve terminals and Harting plugs: Outer DM. 6mm
Hose line between Destaco Cyl. and Harting plugs: Outer DM. 10mm (99118-1006)
Hose line between Cyl. and Harting plugs: Outer DM. 6mm (99118-0604)
AS - Cylinder Advance, GS - Cylinder Return

Note 2:
Install memory stone to all the hall switches on the cylinders
Install memory stone to all the hall switches on the rotary cylinders

Harting - Surface Mount
Hanmodular-4 Module Fram
at device

[illegible]

Brose
18002
Brose Ford C482 & C483 Tooling

Autodyne Machinery Inc.
375 Harwood Ave. N.

18002-08

Designed by: M.C.
Drawn by: M.C.
Checked by:

18002-08

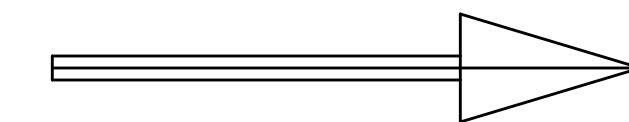
Page	201
Next	+09/1


AUTODYNE


AUTODYNE


Operator_Side


Driving Direction



Sx10  Buckle Bracket Rail R (934431) Present

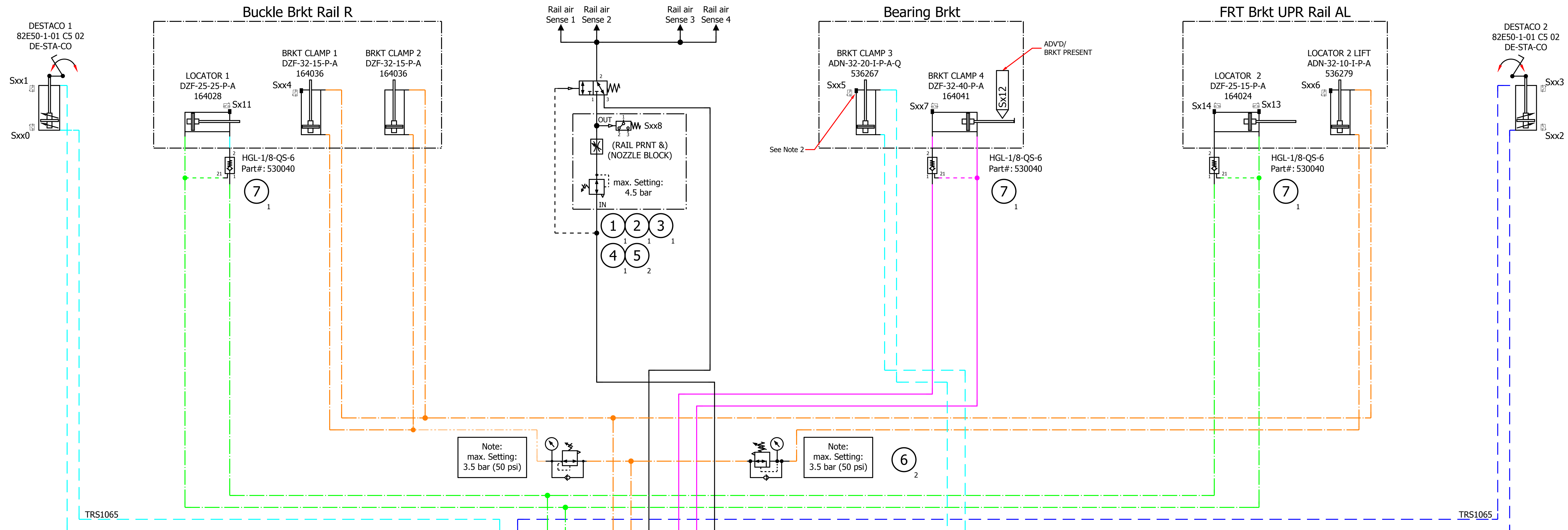
Sx15  Front Bracket Upper Rail AL (C55599) Present

Sx16  Tooling Cluster 1 Present (For Running E05511)

Sx17  Tooling Cluster 2 Present (For Running E04888)

on tooling plate

Laser Cell
Tooling for Ass'y #E04888/E05511 (Mech. Layout#18002-12)
PP2.13 Tooling frame 2 - Place D



under tooling plate

TOOLING FIXTURE OPERATING SEQUENCE (E04888/E05511)

Insert all assy brackets (#934431, #984908 & #C55599) for E04888 or (#934431 & #C55599) for E05511
Insert Rail (#E04887) for E04888 or (#E04998) for E05511

Start cycle
Step #1, Locator 1 & 2 advanced (V3),
Bracket Clamp 4 advanced/Bearing Brkt (#984908) Present (V6)
Step #2, Destaco 1 & 2 advanced (V1 & V2)
Step #3, Bracket Clamp 1 & 2/Locator 2 Lift advanced (V4),
Bracket clamp 3 advanced (V7),
Energize Check Pressure/Rail present (V5)
Step #4, De-energize Check Pressure (V5)

After welding:
 Step #1, De-energize Bracket Clamp 1 & 2/Locator 2 Lift advance (V4),
 Bracket Clamp 3 returned (V7)
 Step #2, Locator 1 & 2 returned (V3),
 Bracket Clamp 4 returned (V6)
 Step #3, Bracket Clamp 1 & 2/Locator 2 Lift returned (V4)
 Step #4, Destaco 1 & 2 returned (V1 & V2)
 Step #5, Bracket Clamp 1 & 2/Locator 2 Lift advanced for part eject (V4),
 Energize Free-Blow Pressure for nozzle clean (V5)
 Step #6, Bracket Clamp 1 & 2/Locator 2 Lift returned (V4),
 De-energize Free-Blow Pressure (V5)
 Welded part unloaded

see sheet 2 to sheet 5 of
"pneumatics sch. for Tooling frame"

Note 1:
Hose line between valve terminals and Harting plugs: Outer DM. 6mm
Hose line between Destaco Cyl. and Harting plugs: Outer DM. 10mm (99118-1006)
Hose line between Cyl. and Harting plugs: Outer DM. 6mm (99118-0604)
AS - Cylinder Advance, GS - Cylinder Return

Note 2:
Install memory stone to all the hall switches on the cylinders
Install memory stone to all the hall switches on the rotary cylinders

Brose
18002
Brose Ford C482 & C483 Tooling

Autodyne Machinery Inc.
375 Harwood Ave. N.

18002-12

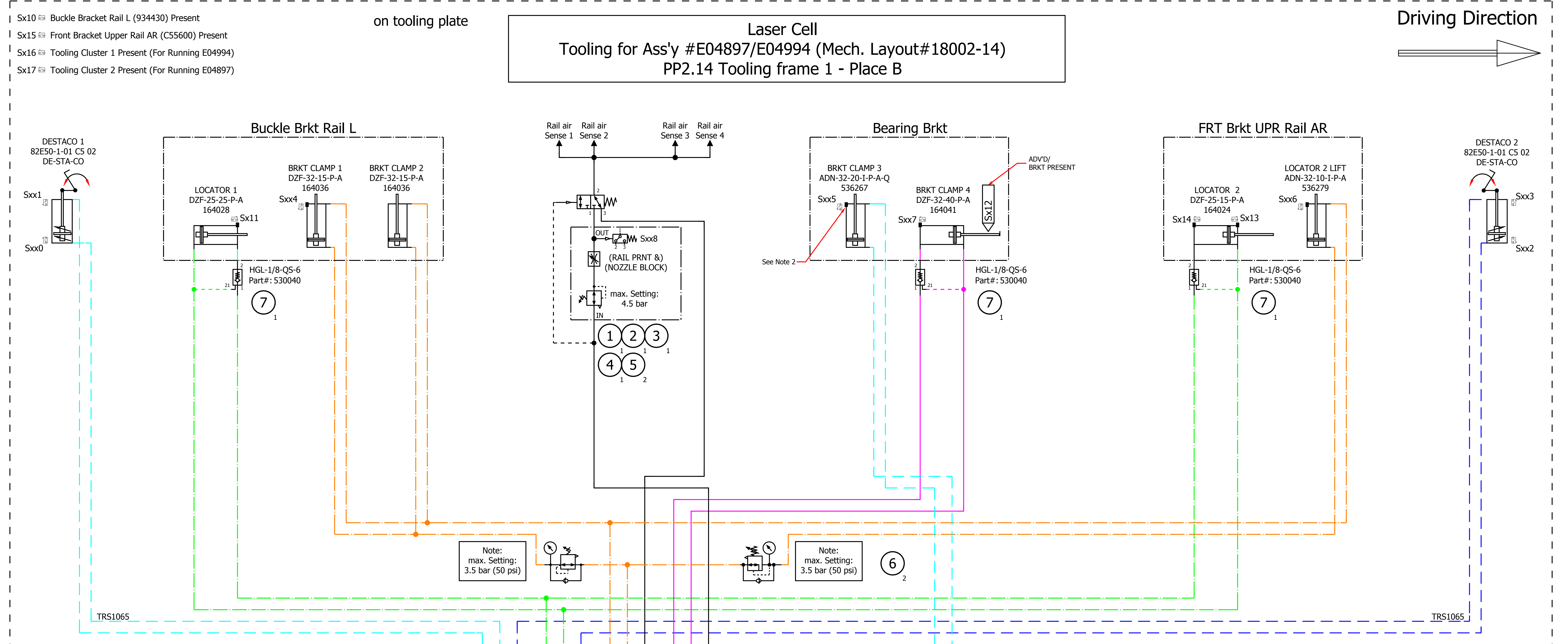
Designed by: M.C.
Drawn by: M.C.
Checked by:

18002-12

Page	201
Next	+13/1

AUTODYNE

[illegible]



TOOLING FIXTURE OPERATING SEQUENCE (E04897/E04994)

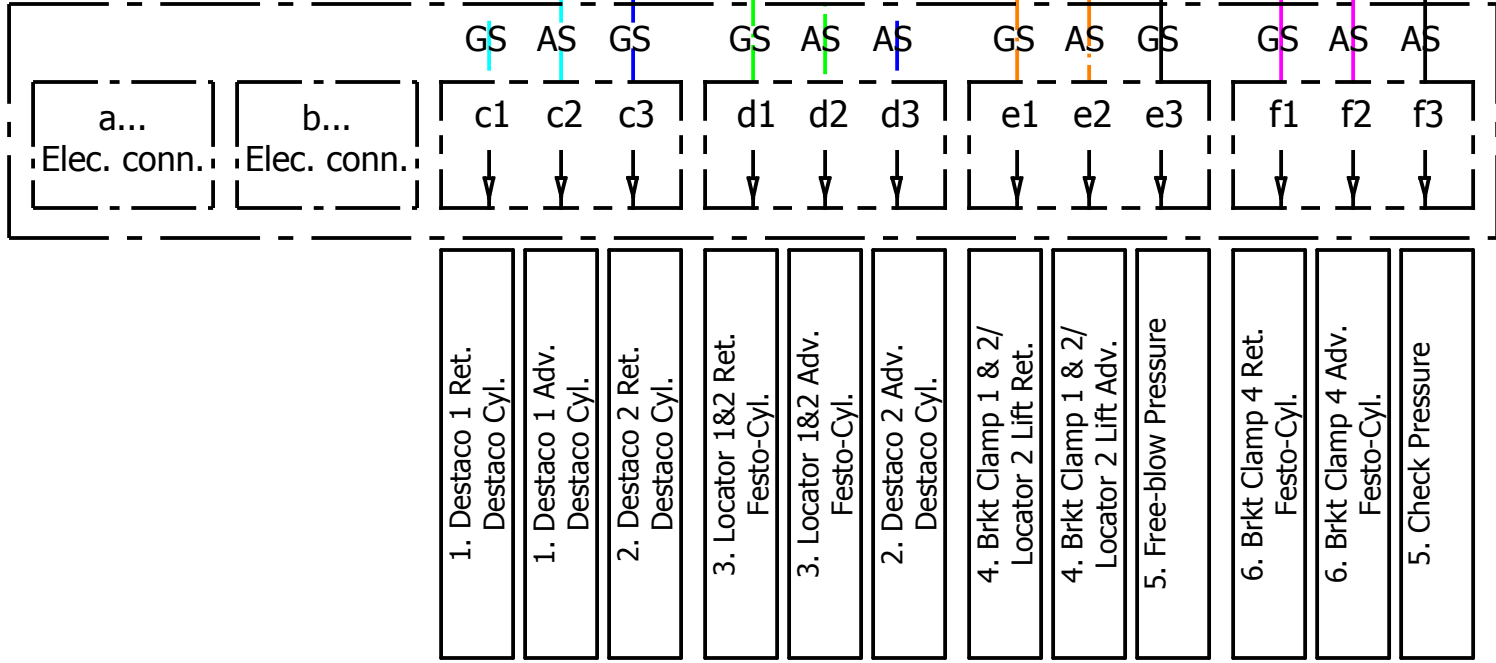
Insert all assy brackets (#934430, #984908 & #C55600) for E04897 or (#934430 & #C55600) for E04994
Insert Rail (#E04891) for E04897 or (#E04995) for E04994

- Start cycle
Step #1, Locator 1 & 2 advanced (V3),
Bracket Clamp 4 advanced/Bearing Brkt (#984908) Present (V6)
Step #2, Destaco 1 & 2 advanced (V1 & V2)
Step #3, Bracket Clamp 1 & 2/Locator 2 Lift advanced (V4),
Bracket clamp 3 advanced (V7),
Energize Check Pressure/Rail present (V5)
Step #4, De-energize Check Pressure (V5)

- After welding:
Step #1, De-energize Bracket Clamp 1 & 2/Locator 2 Lift advance (V4),
Bracket Clamp 3 returned (V7)
Step #2, Locator 1 & 2 returned (V3),
Bracket Clamp 4 returned (V6)
Step #3, Bracket Clamp 1 & 2/Locator 2 Lift returned (V4)
Step #4, Destaco 1 & 2 returned (V1 & V2)
Step #5, Bracket Clamp 1 & 2/Locator 2 Lift advanced for part eject (V4),
Energize Free-Blow Pressure for nozzle clean (V5)
Step #6, Bracket Clamp 1 & 2/Locator 2 Lift returned (V4),
De-energize Free-Blow Pressure (V5)
Welded part unloaded

under tooling plate

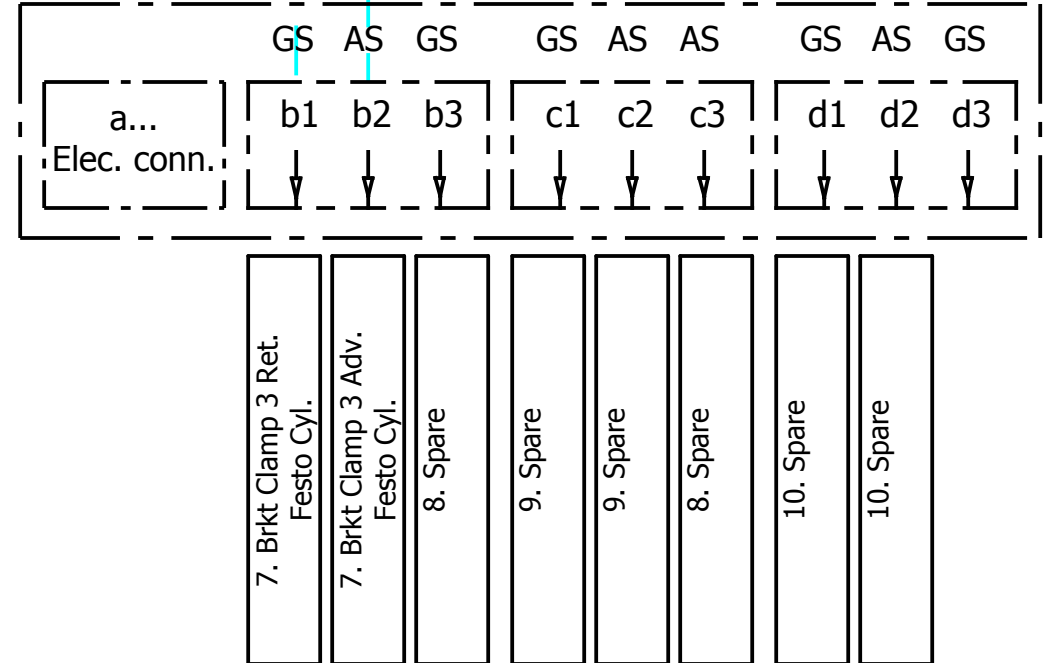
Harting - Surface Mount
Hanmodular-6 Module Frame
at device



see sheet 2 to sheet 5 of
"pneumatics sch. for Tooling frame"

Operator Side

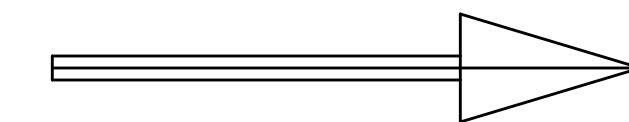
Harting - Surface Mount
Hanmodular-4 Module Frame
at device





- Note 1:
Hose line between valve terminals and Harting plugs: Outer DM. 6mm
Hose line between Destaco Cyl. and Harting plugs: Outer DM. 10mm (99118-1006)
Hose line between Cyl. and Harting plugs: Outer DM. 6mm (99118-0604)
AS - Cylinder Advance, GS - Cylinder Return
- Note 2:
Install memory stone to all the hall switches on the cylinders
Install memory stone to all the hall switches on the rotary cylinders


Operator_Side


Driving Direction



Sx10  RR Upper Rail Bracket OB (935264) Present

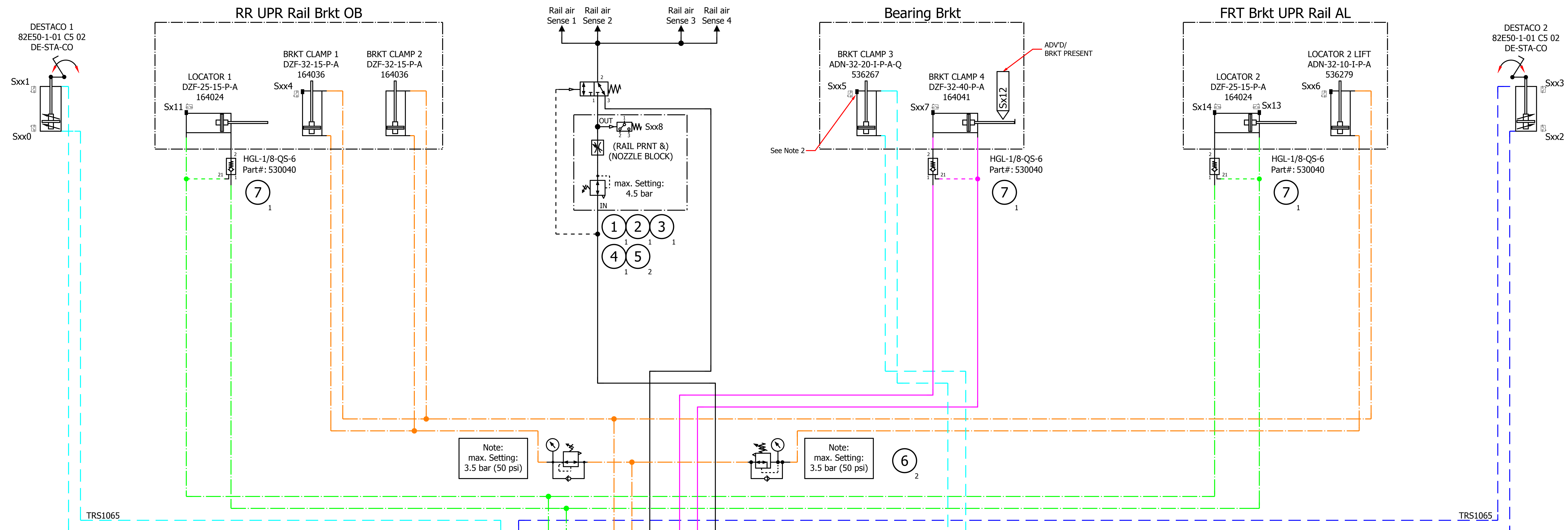
Sx15  Front Bracket Upper Rail AL (C55599) Present

Sx16  Tooling Cluster 1 Present (For Running E04997)

Sx17  Tooling Cluster 2 Present (For Running E04895)

on tooling plate

Laser Cell
Tooling for Ass'y #E04895/#E04997 (Mech. Layout#18002-16)
PP2.14 Tooling frame 2 - Place B



under tooling plate

TOOLING FIXTURE OPERATING SEQUENCE (E04895/E04997)

Insert all assy brackets (#935264, #984908 & #C55599) for E04895 or (#935264 & #C55599) for E04997
Insert Rail (#E04887) for E04895 or (#E04998) for E04997

Start cycle

Step #1, Locator 1 & 2 advanced (V3),
Bracket Clamp 4 advanced/Bearing Brkt (#984908) Present (V6)
Step #2, Destaco 1 & 2 advanced (V1 & V2)
Step #3, Bracket Clamp 1 & 2/Locator 2 Lift advanced (V4),
Bracket clamp 3 advanced (V7),
Energize Check Pressure/Rail present (V5)
Step #4, De-energize Check Pressure (V8)

After welding:

Step #1, De-energize Bracket Clamp 1 & 2/Locator 2 Lift advance (V4),
 Bracket Clamp 3 returned (V7)
 Step #2, Locator 1 & 2 returned (V3),
 Bracket Clamp 4 returned (V6)
 Step #3, Bracket Clamp 1 & 2/Locator 2 Lift returned (V4)
 Step #4, Destaco 1 & 2 returned (V1 & V2)
 Step #5, Bracket Clamp 1 & 2/Locator 2 Lift advanced for part eject (V4),
 Energize Free-Blow Pressure for nozzle clean (V5)
 Step #6, Bracket Clamp 1 & 2/Locator 2 Lift returned (V4),
 De-energize Free-Blow Pressure (V5)
 Welded part unloaded

see sheet 2 to sheet 5 of
"pneumatics sch. for Tooling frame"

Note 1:
Hose line between valve terminals and Harting plugs: Outer DM. 6mm
Hose line between Destaco Cyl. and Harting plugs: Outer DM. 10mm (99118-1006)
Hose line between Cyl. and Harting plugs: Outer DM. 6mm (99118-0604)
AS - Cylinder Advance, GS - Cylinder Return

Note 2:
Install memory stone to all the hall switches on the cylinders
Install memory stone to all the hall switches on the rotary cylinders

Brose
18002
Brose Ford C482 & C483 Tooling

Autodyne Machinery Inc.
375 Harwood Ave. N.

18002-16

Designed by: M.C.
Drawn by: M.C.
Checked by:

18002-16

Page	201
Next	+17/1

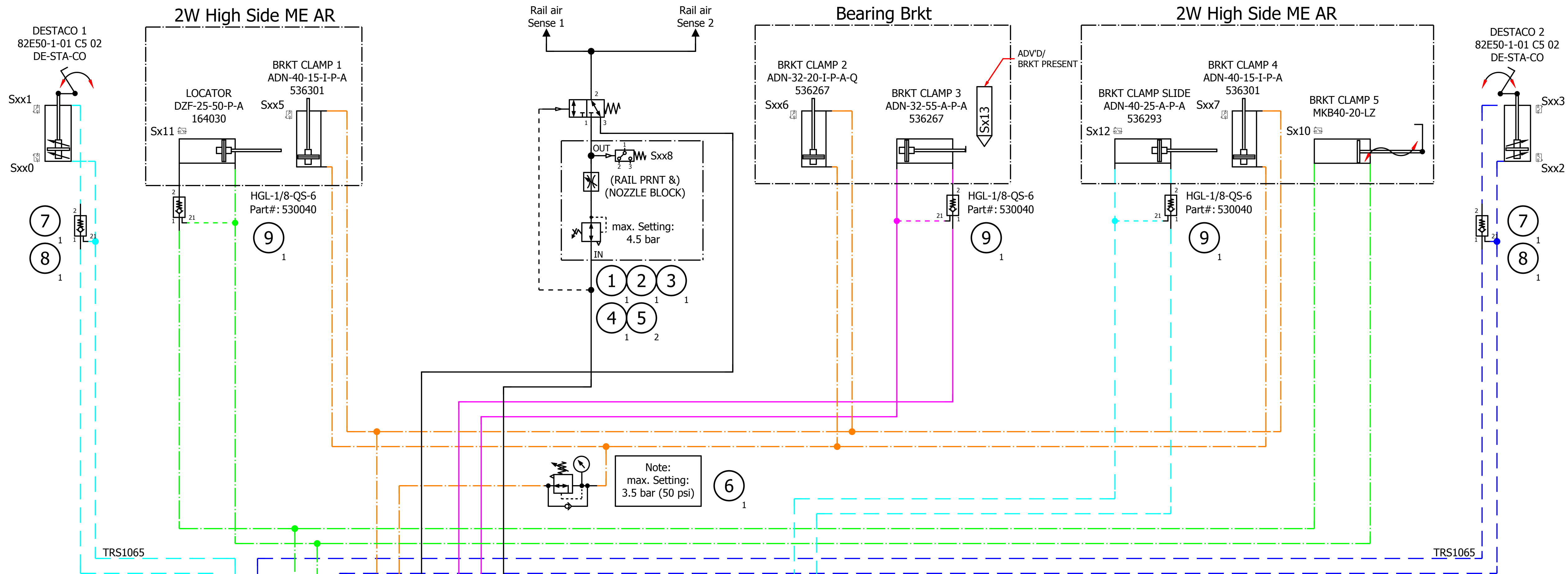
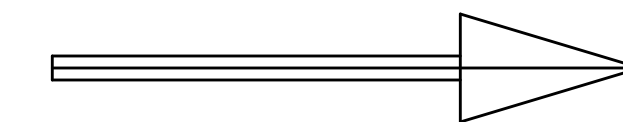
AUTODYNE

[illegible]

on tooling plate

Laser Cell
Tooling for Ass'y #E04904 (Mech. Layout#18002-17)
PP2.15 Tooling frame 1 - Place A

Driving Direction



under tooling plate

Operator Side

TOOLING FIXTURE OPERATING SEQUENCE (E04904)

Insert all assy brackets (#984908 & #C95210)
Insert Rail (#E04891)

Start cycle
Step #1, Locator/Bracket Clamp 5 advanced (V3),
Bracket Clamp 3 advanced (V6)
Step #2, Destaco 1 & 2 advanced (V1 & V2)
Step #3, Bracket Clamp Slide advanced (V7)
Step #4, Bracket Clamp 1, 2 & 4 advanced (V4),
Energize Check Pressure/Rail present (V5)
Step #5, De-energize Check Pressure (V5)

After welding:
Step #1, Locator/Bracket Clamp 5 returned (V3),
Bracket Clamp 1, 2 & 4 returned (V4)
Step #2, Bracket Clamp 3 returned (V6),
Bracket Clamp Slide returned (V7)
Step #3, Destaco 1 & 2 returned (V1 & V2)
Step #4, Energize Free-Blow Pressure for nozzle clean (V5),
De-energize Free-Blow Pressure (V5)
Welded part unloaded

see page 202 to page 209 of
"pneumatics sch. for Tooling frame"

Note:
Hose line between valve terminals and Harting plugs: Outer DM. 6mm
Hose line between Destaco Cyl. and Harting plugs: Outer DM. 10mm (TRS1065)
Hose line between Cyl. and Harting plugs: Outer DM. 6mm (TRS0603)
AS - Cylinder Advance, GS - Cylinder Return


[illegible]


AUTODYNE


Operator Side


Driving Direction



Sx15  Manual Upper Rail Sub Stg 1 (E04906-Sub) Present 1

Sx16  Manual Upper Rail Sub Stg 1 (E04906-Sub) Present 2

Sxx4  2W High Side ME AL (C95209) Present 1

Sx14  2W High Side ME AL (C95209) Present 2

on tooling plate

Laser Cell
Tooling for Ass'y #E04906 (Mech. Layout#18002-19)
PP2.15 Tooling frame 2 - Place A

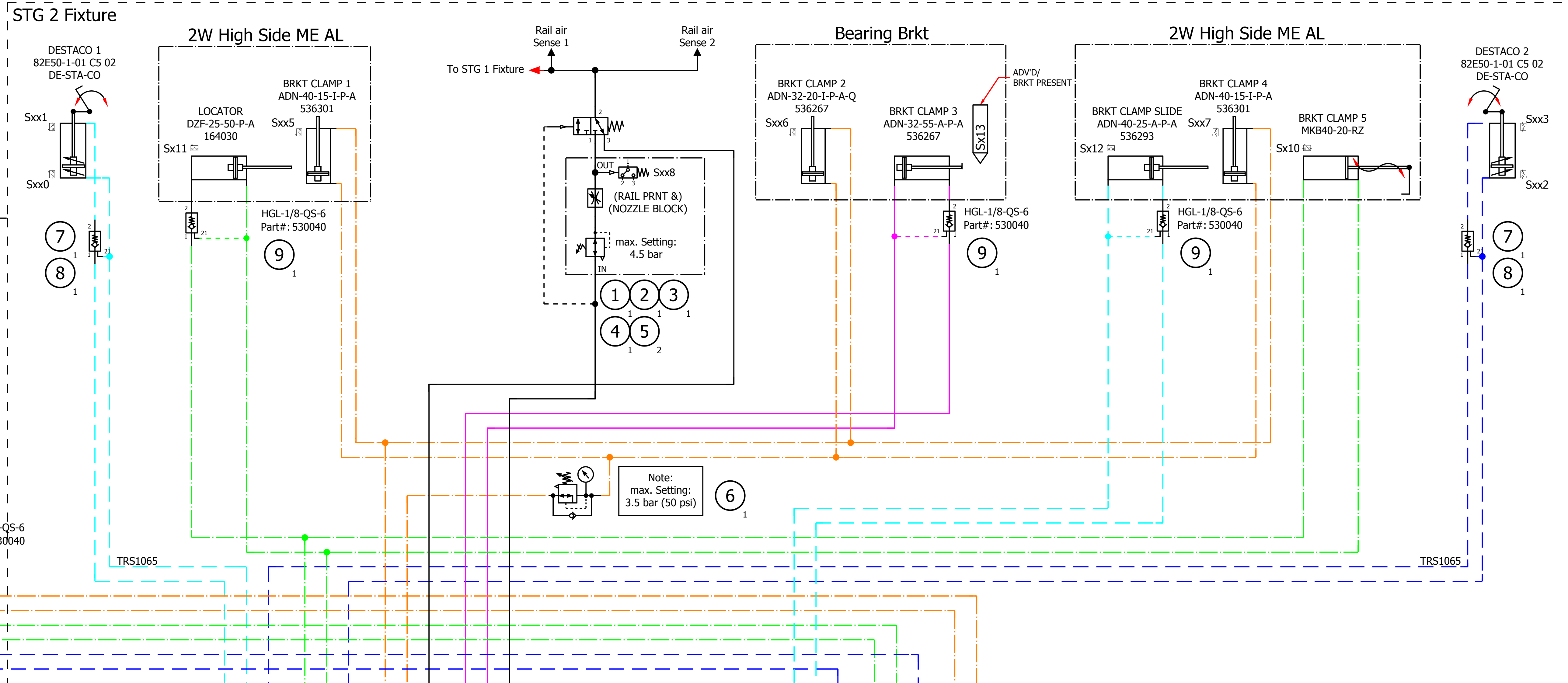


FIG 1 TOOLING FIXTURE OPERATING SEQUENCE (E04906-Sub)

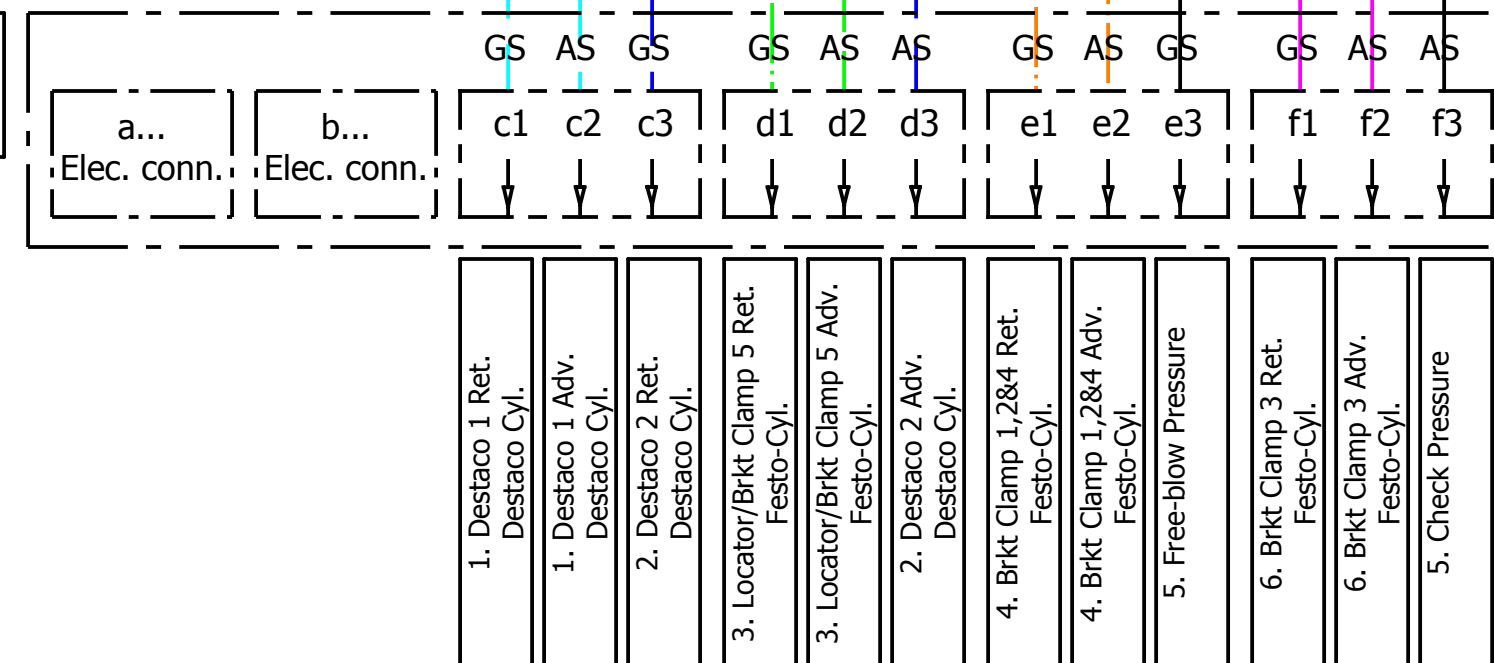
Insert all assy brackets (#936037)
Insert Rail (#E04887)

Step #1, Rail clamp advanced (V10)
 Step #2, Brkt clamp 6 advanced (V8)
 Step #3, Brkt clamp 7 advanced (V9)
 Step #4, Energize Check Pressure/Rail present (V5)
 Step #5, De-energize Check Pressure (V5)

Step #1, Bracket Clamp 6 returned (V8)
 Step #2, Bracket Clamp 7 returned (V9)
 Step #3, Rail Clamp returned (V10)
 Welded part unloaded

under tooling plate

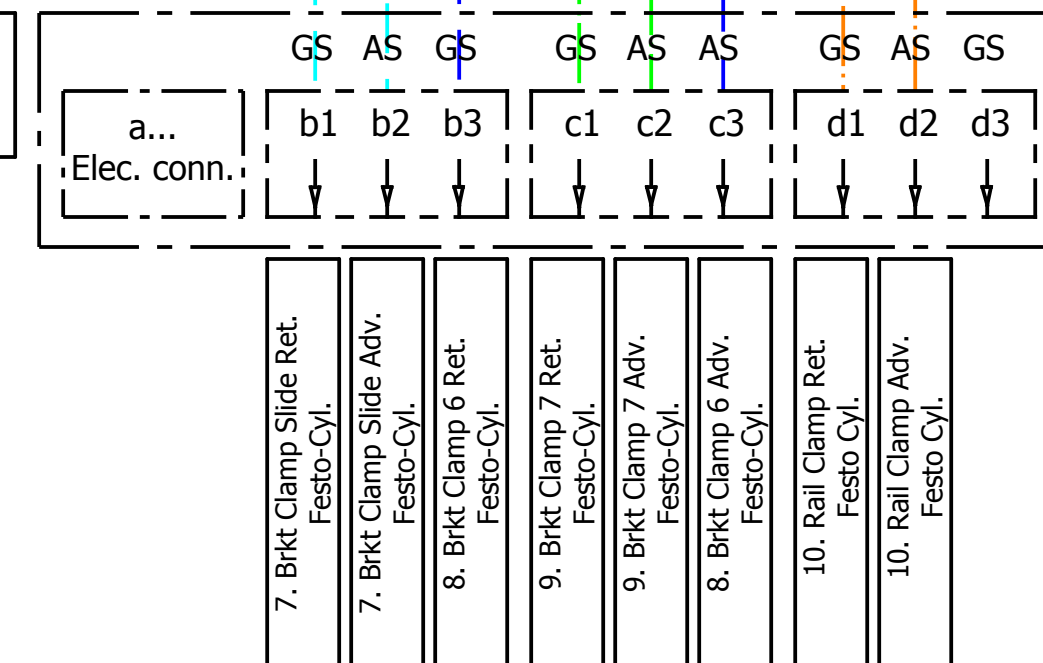
Harting - Surface Mount
Hanmodular-6 Module Frame
at device



see page 202 to page 209 of
"pneumatics sch. for Tooling frame"

Note:
Hose line between valve terminals and Harting plugs: Outer DM. 6mm
Hose line between Destaco Cyl. and Harting plugs: Outer DM. 10mm (TRS1065)
Hose line between Cyl. and Harting plugs: Outer DM. 6mm (TRS0603)
AS - Cylinder Advance, GS - Cylinder Return

Harting - Surface Mount
Hanmodular-4 Module Frame
at device



STG 2 TOOLING FIXTURE OPERATING SEQUENCE (E04906)

Insert all assy brackets (#984908 & #C95209)
Insert Rail (#E04906-Sub)

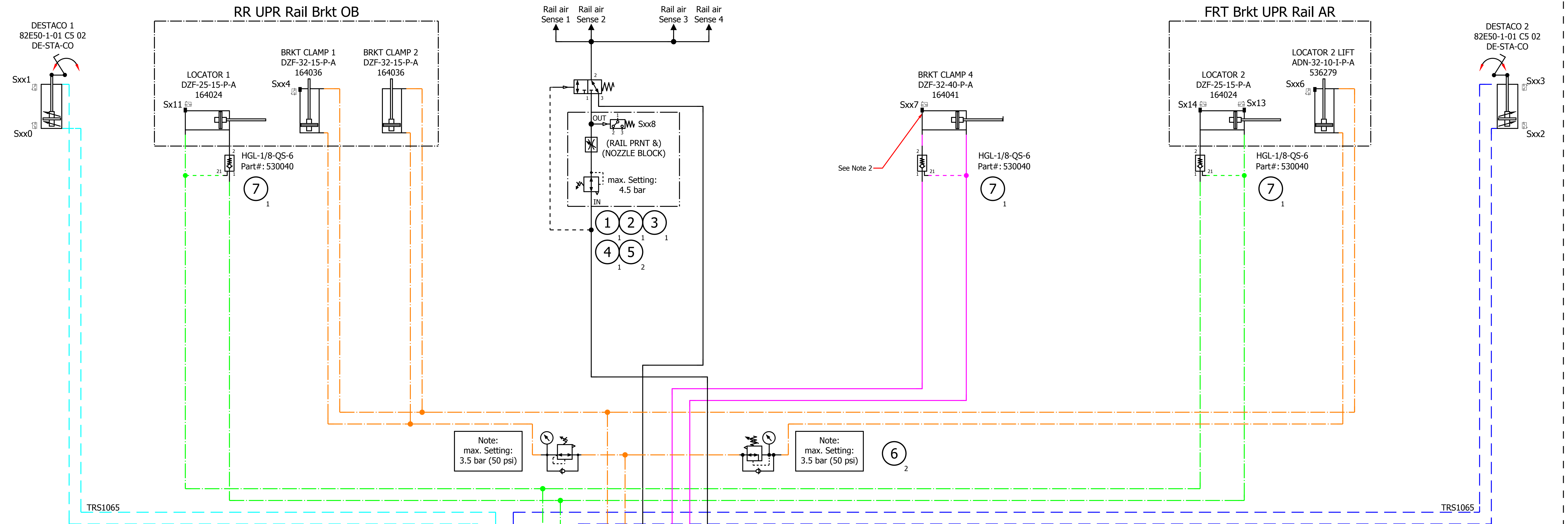
Start cycle
Step #1, Locator/Bracket Clamp 5 advanced (V3),
Bracket Clamp 3 advanced (V6)
Step #2, Destaco 1 & 2 advanced (V1 & V2)
Step #3, Bracket Clamp Slide advanced (V7)
Step #4, Bracket Clamp 1, 2 & 4 advanced (V4),
Energize Check Pressure/Rail present (V5)
Step #5, De-energize Check Pressure (V5)

After welding:
 Step #1, Locator/Bracket Clamp 5 returned (V3),
 Bracket Clamp 1, 2 & 4 returned (V4)
 Step #2, Bracket Clamp 3 returned (V6),
 Bracket Clamp Slide returned (V7)
 Step #3, Destaco 1 & 2 returned (V1 & V2)
 Step #4, Energize Free-Blow Pressure for nozzle clean (V5),
 De-energize Free-Blow Pressure (V5)
 Welded part unloaded

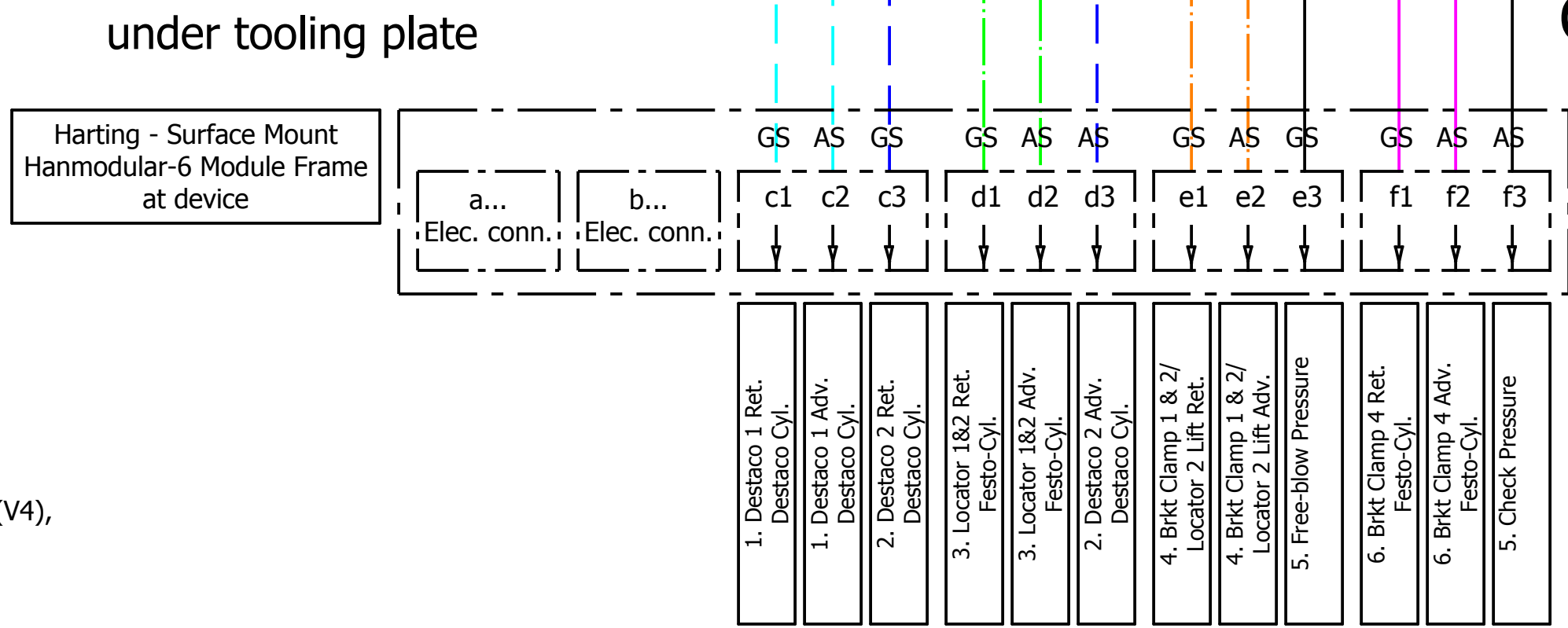
[illegible]

Sx15  Front Bracket Upper Rail AR (C55600) Present

Laser Cell
Tooling for Ass'y #E05509 (Mech. Layout#18002-22)
PP2.16 Tooling frame 1 - Place D



After welding:
 Step #1, De-energize Bracket Clamp 1 & 2/Locator 2 Lift advance (V4),
 Step #2, Locator 1 & 2 returned (V3),
 Bracket Clamp 4 returned (V6)
 Step #3, Bracket Clamp 1 & 2/Locator 2 Lift returned (V4)
 Step #4, Destaco 1 & 2 returned (V1 & V2)
 Step #5, Bracket Clamp 1 & 2/Locator 2 Lift advanced for part eject (V4),
 Energize Free-Blow Pressure for nozzle clean (V5)
 Step #6, Bracket Clamp 1 & 2/Locator 2 Lift returned (V4),
 De-energize Free-Blow Pressure (V5)
 Welded part unloaded



see page 202 to page 209 of
"pneumatics sch. for Tooling frame"

Note 1:
Hose line between valve terminals and Harting plugs: Outer DM. 6mm
Hose line between Destaco Cyl. and Harting plugs: Outer DM. 10mm (99118-1006)
Hose line between Cyl. and Harting plugs: Outer DM. 6mm (99118-0604)
AS - Cylinder Advance, GS - Cylinder Return
Note 2:
Install memory stone to all the hall switches on the cylinders
Install memory stone to all the hall switches on the rotary cylinders

[illegible]

Operator Side

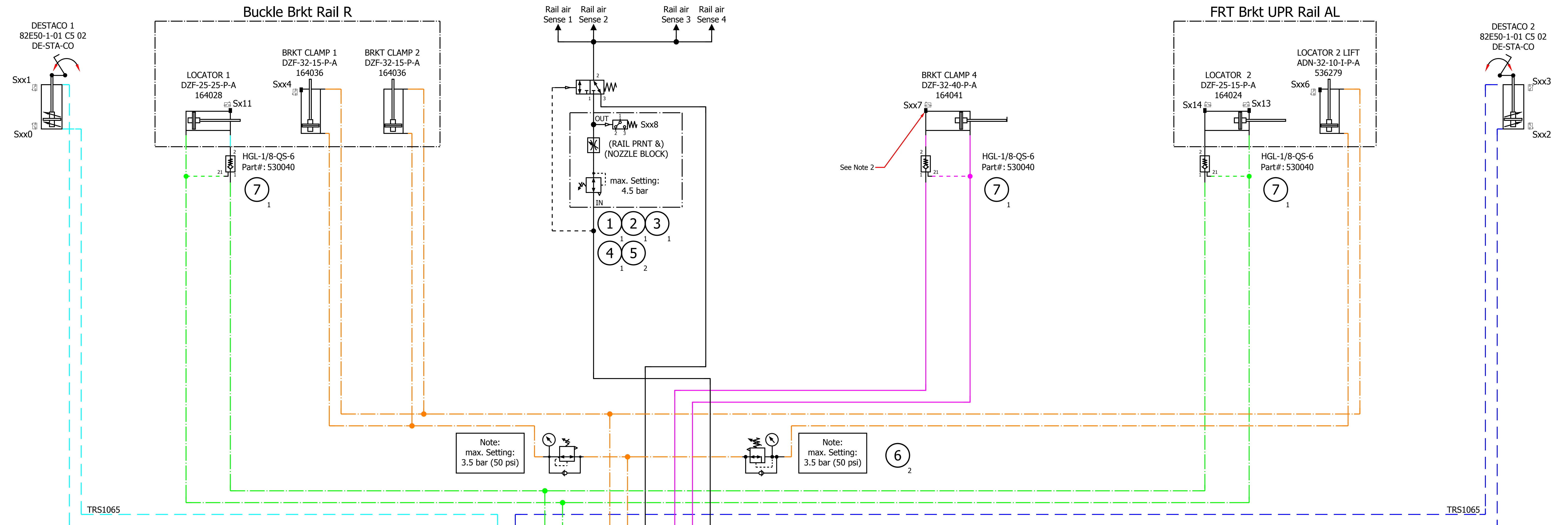
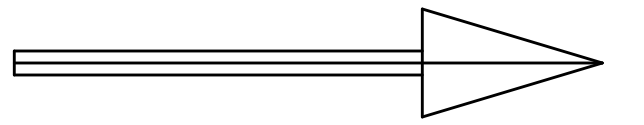
Sx10 Buckle Bracket Rail R (934431) Present

Sx15 Front Bracket Upper Rail AL (C55599) Present

on tooling plate

Laser Cell
Tooling for Ass'y #E05511 (Mech. Layout#18002-24)
PP2.16 Tooling frame 2 - Place D

Driving Direction



under tooling plate

OLING FIXTURE OPERATING SEQUENCE (E05511)

Insert all assy brackets (#934431 & #C55599)
Insert Rail (#E04998)

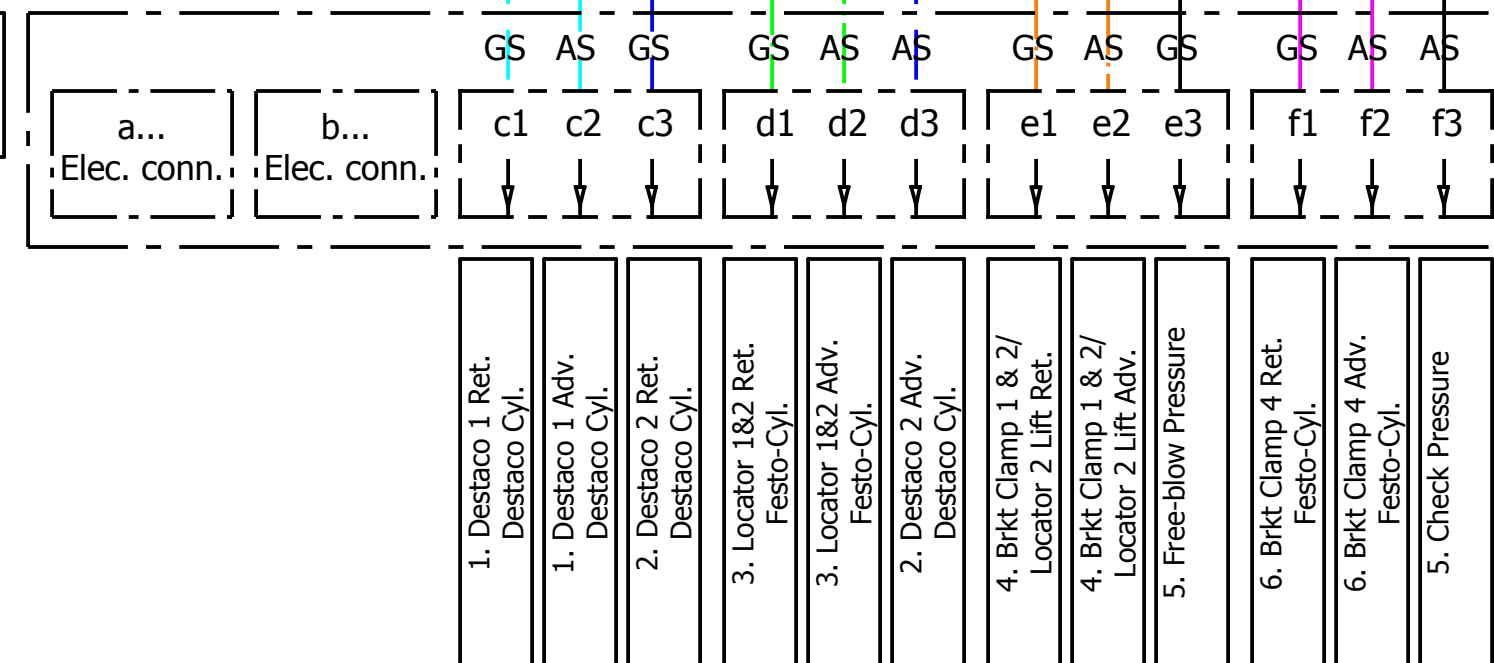
art cycle

- Step #1, Locator 1 & 2 advanced (V3),
Bracket Clamp 4 advanced (V6)
- Step #2, Destaco 1 & 2 advanced (V1 & V2)
- Step #3, Bracket Clamp 1 & 2/Locator 2 Lift advanced (V4),
Energize Check Pressure/Rail present (V5)
- Step #4, De-energize Check Pressure (V4)

er welding:

Step #1, De-energize Bracket Clamp 1 & 2/Locator 2 Lift advance (V4)
 Step #2, Locator 1 & 2 returned (V3),
 Bracket Clamp 4 returned (V6)
 Step #3, Bracket Clamp 1 & 2/Locator 2 Lift returned (V4)
 Step #4, Destaco 1 & 2 returned (V1 & V2)
 Step #5, Bracket Clamp 1 & 2/Locator 2 Lift advanced for part eject (V4),
 Energize Free-Blow Pressure for nozzle clean (V5)
 Step #6, Bracket Clamp 1 & 2/Locator 2 Lift returned (V4),
 De-energize Free-Blow Pressure (V5)
 Molded part unloaded

Harting - Surface Mount
Hanmodular-6 Module Frame
at device



see page 202 to page 209 of
"pneumatics sch. for Tooling frame"

Note 1:
Hose line between valve terminals and Harting plugs: Outer DM. 6mm
Hose line between Destaco Cyl. and Harting plugs: Outer DM. 10mm (99118-1006)
Hose line between Cyl. and Harting plugs: Outer DM. 6mm (99118-0604)
AS - Cylinder Advance, GS - Cylinder Return
Note 2:
Install memory stone to all the hall switches on the cylinders
Install memory stone to all the hall switches on the rotary cylinders

[illegible]