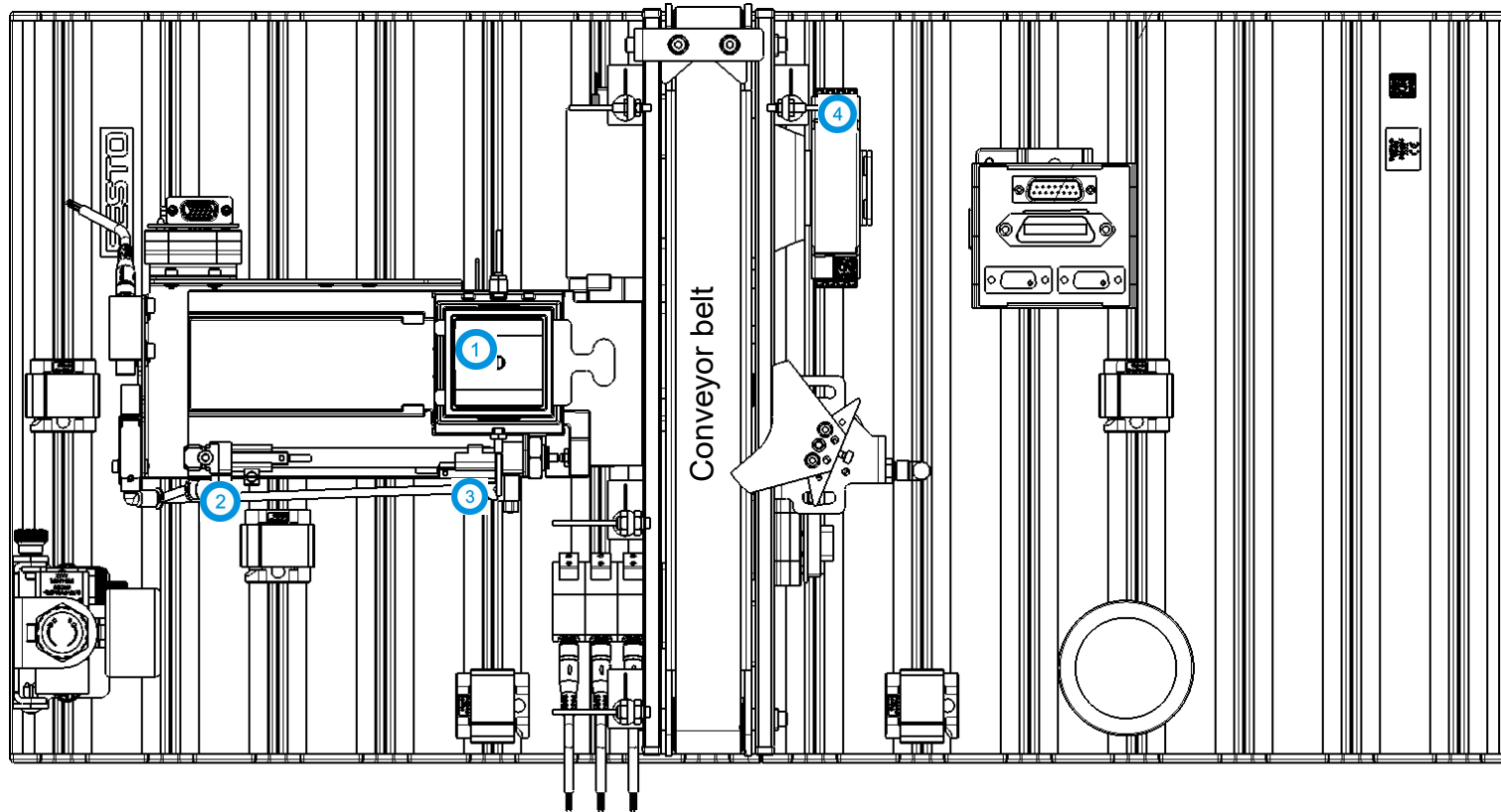


Distributing Station Layout



- 1 Workpiece is placed inside the magazine stack which get detected by the through-beam sensor.
- 2 The double-acting cylinder's -reed magnetic switch must be in retracted position for the cylinder to push workpiece to the conveyor.
- 3 The double-acting cylinder will retract as it detect by another reed magnetic switch that is in advanced position. Then, the conveyor motor will turns on to move workpiece to the end to another station.
- 4 As the workpiece gets to the end, it will break the through-beam sensor which enable a timer of 2 seconds to continue conveyor motor to run for an additional 2 seconds.