

**CHART 2
AUTOMATIC TOOL CHANGER**

10-18-95

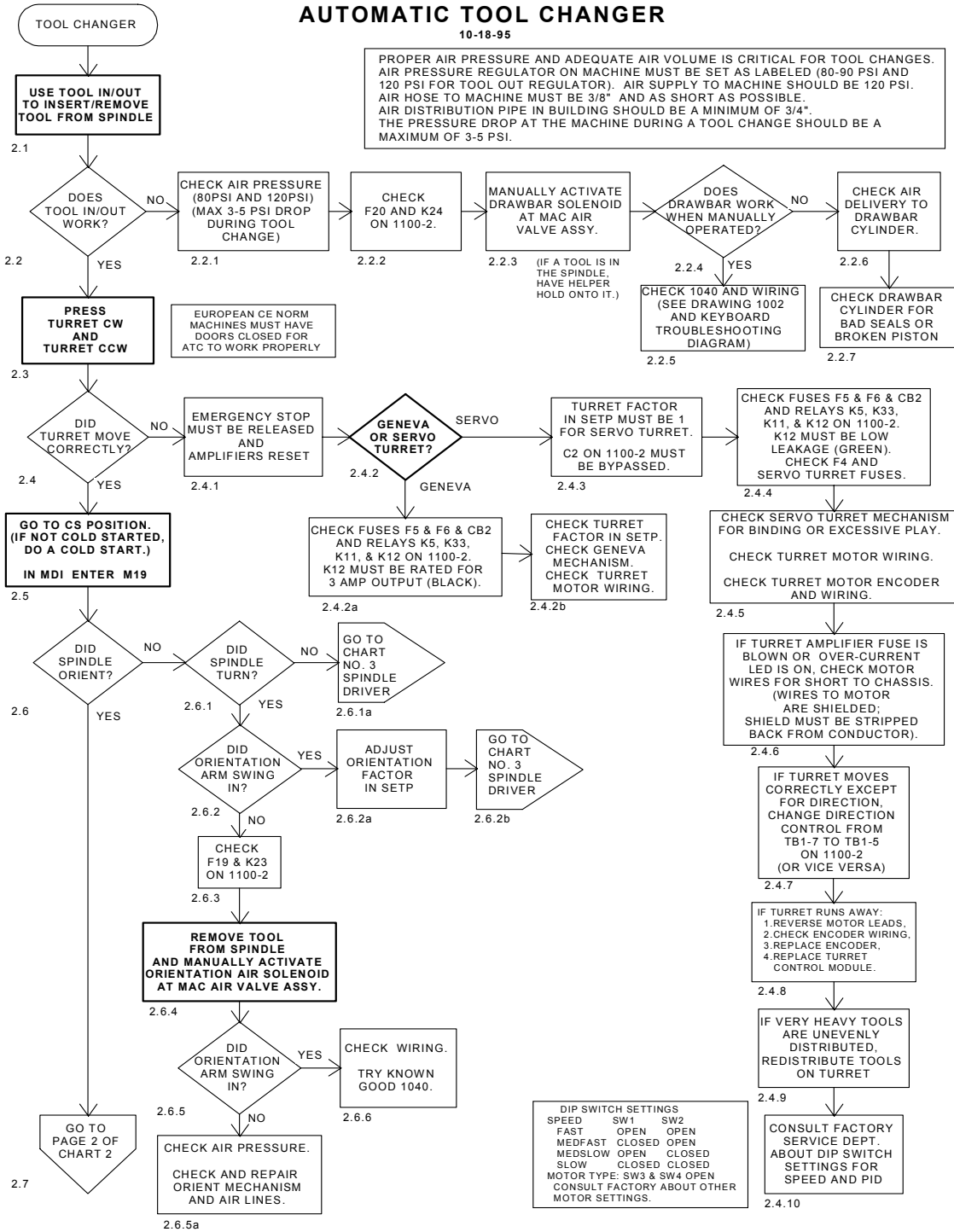


Figure 16-4 Automatic Tool Changer

CHART 2 continued (page 2)
AUTOMATIC TOOL CHANGER
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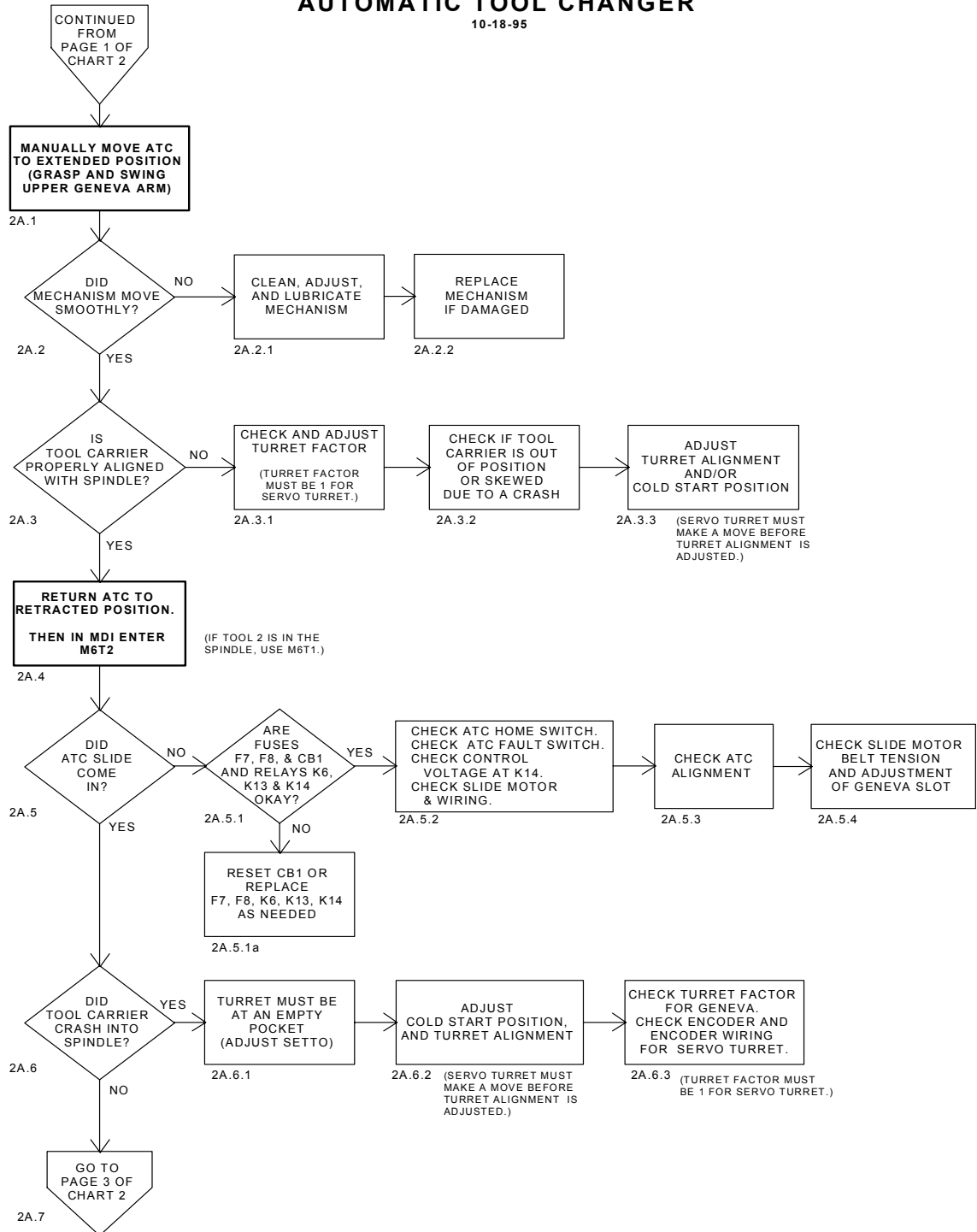


Figure 16-5 Automatic Tool Changer (Continued)

CHART 2 continued (page 3)
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PROPER AIR PRESSURE AND ADEQUATE AIR VOLUME IS CRITICAL FOR TOOL CHANGES. AIR PRESSURE REGULATOR ON MACHINE MUST BE SET AS LABELED (80-90 PSI AND 120 PSI FOR TOOL OUT REGULATOR). AIR SUPPLY TO MACHINE SHOULD BE 120 PSI. AIR HOSE TO MACHINE MUST BE 3/8" AND AS SHORT AS POSSIBLE. AIR DISTRIBUTION PIPE IN BUILDING SHOULD BE A MINIMUM OF 3/4". THE PRESSURE DROP AT THE MACHINE DURING A TOOL CHANGE SHOULD BE A MAXIMUM OF 3-5 PSI.

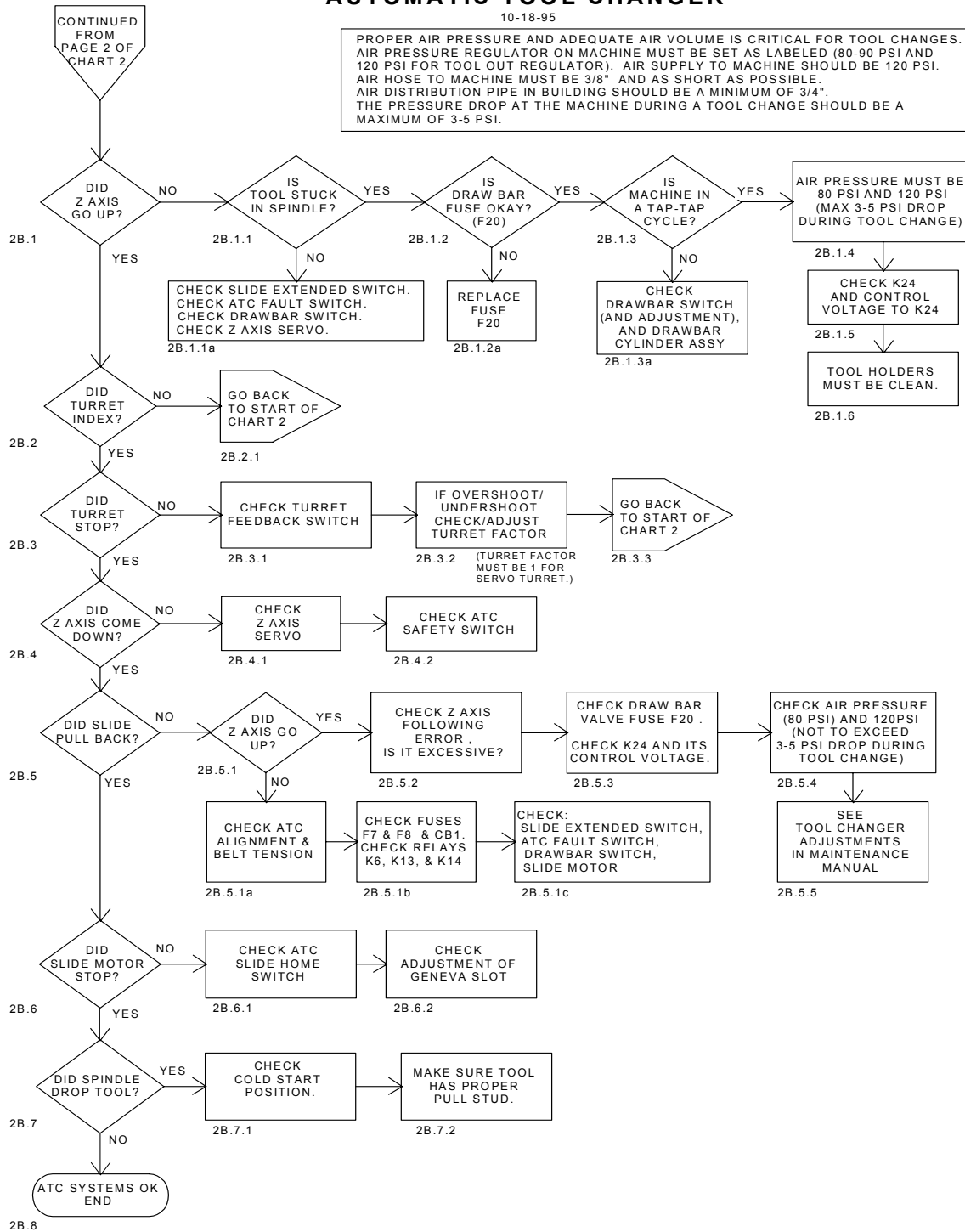


Figure 16-6 Automatic Tool Changer (Continued)