

GAS INPUT
55-60 PSIG
.25 O.D.
TUBE FITTING

INPUT
REGULATOR 1
SET TO 55-60 PSI

S1
VAC SWITCH

ONLY CONNECT
FOR PICK & PLACE
VERSION

SOL 6
PICK VACUUM

ORANGE

GREEN

P/U

INPUT
REGULATOR 2
SET TO 25 PSI

SOL 8
WELD
ARMS UP

SOL 1
WELD
ARMS DOWN

SOL 7
TABLE
ROTATE

SOL 4
FILL

SOL 5
EXHAUST

TRANSDUCER

ROTARY
STAGE

INPUT
REGULATOR 3
SET TO 25 PSI

VACUUM
SOURCE
27"-30" Hg
.25 O.D.
TUBE FITTING

ACC

ACC

ACC

SOL 3
PICK
HEAD DOWN

SOL 2
PICK
HEAD UP

RED

YELLOW

ONLY CONNECT
FOR PICK & PLACE
VERSION

P/U CYL

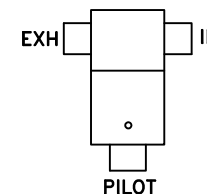
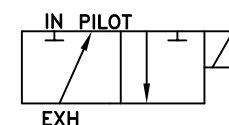
PICK UP SEQUENCE

ENERGIZE SOL. 2, 3, AND 4
P/U CYL EXTENDS
XDUCER REACHES SET PRESSURE
DE-ENERGIZE SOL. 4
SET PRESSURE HOLDING
TACK LID
DE-ENERGIZE SOL. 2 AND 3
ENERGIZE SOL. 5
P/U CYL RETRACTS
CYCLE REPEATS

ARMS SEQUENCE

ENERGIZE SOL. 1, 4 AND 8
ARMS CYL EXTENDS
XDUCER REACHES SET PRESSURE
DE-ENERGIZE SOL. 4
SET PRESSURE HOLDING
WELD PACKAGE
DE-ENERGIZE SOL. 1 AND 8
ENERGIZE SOL. 5
ARMS CYL RETRACTS
CYCLE REPEATS

PORTS FOR SOL 1-5
AND SOL 8



VACUUM
SOURCE
27"-30" Hg
.25 O.D.
TUBE FITTING

SOL 12
VACUUM
CHUCK

S2
VAC SWITCH

VACUUM CHUCK (PART SPECIFIC)

NOTE:
SEPARATE VACUUM INPUTS ARE REQUIRED FOR
THE PICK VACUUM AND VACUUM CHUCK AS SHOWN

USE VACUUM CHUCK
ON SMART NEST ONLY

SOL 13
TABLE SHOT PIN

ONLY CONNECT FOR SYSTEM
WITH AUER BOAT HANDLER

AMADA
AMADA WELD TECH
1820 S. MYRTLE AVE.
MONROVIA, CA 91017-7133
626-303-6676

TOLERANCES
(EXCEPT AS NOTED)

DECIMAL

.XX=±.010

.XXX=±.005

.XXXX=±.0005

FRACTIONAL

±1/64

ANGULAR

±30°

DRAWN BY DATE CHECKED BY DATE
APPV DATE APPV DATE
FINISHED PARTS TO BE
DEBURRED, DECREASED
CLEANED, AND ALL SHARP
EDGES REMOVED

SHEET NO.

1 OF 1

C	UPDATED DWG PER EO#45916	DV	06/10/20
B	UPDATED DWG PER EO#40957	DV	06/19/08
A	INITIAL RELEASE PER EO#21709	VW	06/19/08
REV	DESCRIPTION	APPV	DATE

TITLE		AF-1250A	
SEAMSEALER SYSTEM		PNEUMATIC SCHEMATICS	
SIZE	D	DRAWING NUMBER	105-00244-125