

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

INPUT
REGULATOR 1
SET TO 55-60 PSI

VAC SWITCH

ONLY CONNECT
FOR PLACEMENT
VERSION

SOL 6
VACUUM

INPUT
REGULATOR 3
SET TO 25 PSI

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

LEFT WELD CYL

RIGHT WELD CYL

PICK UP HEAD CYL

SOL 7
ROTARY
STAGE

ROTARY
STAGE CYL

TRANSDUCER

FLOW
REG 1

INPUT
REGULATOR 2
SET TO 25 PSI

SOL 1
ARMS DOWN

SOL 3
HEAD DOWN

SOL 2
HEAD UP

ACC 1

ACC 2

ACC 3

FLOW
REG 4

FLOW
REG 3

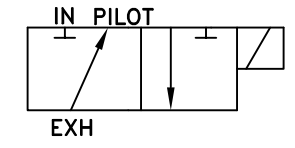
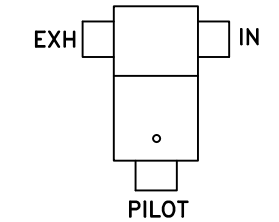
ONLY CONNECT
FOR PICK & PLACE
VERSION

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



PART NO	NEXT ASSY NO	QTY
APPLICATION		
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES		
XX= ±		
XXX= ±		
XXXX= ±		
ANGLE= ±		

AMADA
AMADA WELD TECH
1820 S. MYRTLE AVE.
MONROVIA, CA 91017-7133
626-303-5676

DRAWN	DATE	CHECKED	DATE
APPV	DATE	APPV	DATE

FINISHED PARTS TO BE
DEBURRED, DEGREASED
CLEANED, AND ALL SHARP
EDGES REMOVED

DO NOT SCALE PRINT

F	UPDATED DWG EO 45916	D.A.V.	10JUN20
E	UPDATED DWG EO 45360	M.A.C	20FEB19
D	UPDATED DWG EO 40659	VW	19NOV10
REV	DESCRIPTION	APPV	DATE
PNEUMATIC SCHEMATIC			
Autoflow AF-8500A			
MATERIALS HANDLING SYSTEM			
CODE IDENT	DWG NO	105-00244-213	
FILE NO	DWG SIZE	SCALE	SHEET
	B	NONE	1 OF 1