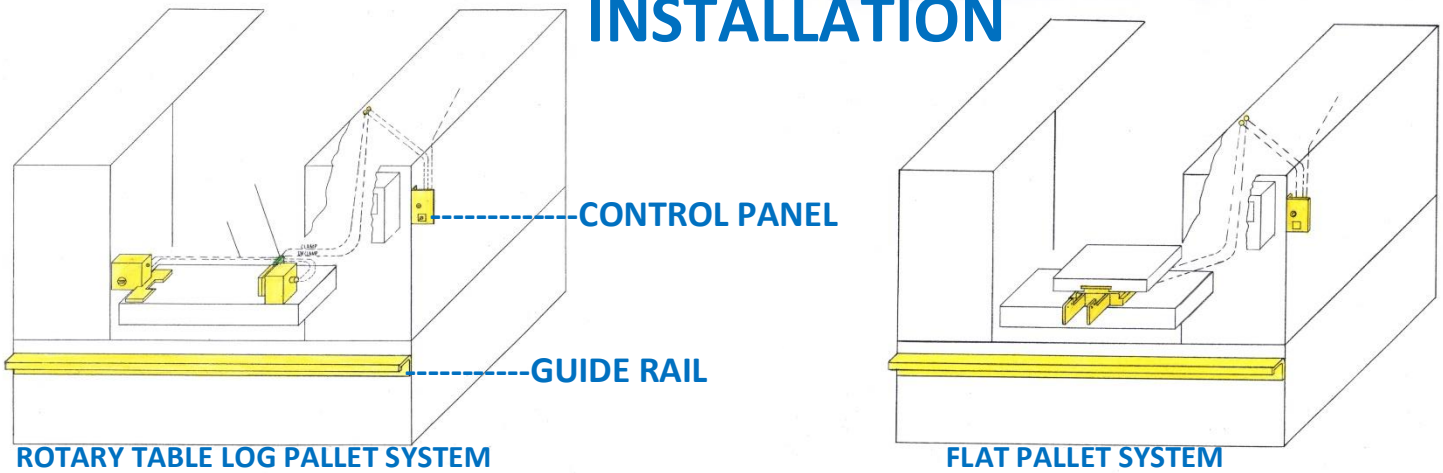


INSTALLATION



Installation of the Rotary Log Pallet System or the Flat Pallet System requires the mounting of a Guide Rail and a control panel. The guide rail locates the carts and enables them to position for pallet transfer.

The control panel contains a valve to clamp and unclamp the pallets and logs. It contains a device to indicate proper clamping of the Pallet Adaptor, Tale Stock and the Flat Pallet Clamp.

The Pallet Adaptor can be mounted on any rotary table with a turn table diameter of 12.2" or more. A spacer is used to increase the rotary table centerline height.

The Tale Stock provides air pressure through the engagement taper to remove chips and sense proper clamping.

The Pallet Adaptor and Flat Pallet Clamp provide air pressure thru the locating seats to remove chips and sense proper clamping.

The Rotary Table Pallet Adaptor will not unclamp the pallet unless it is in position for pallet transfer. The Index Station will not allow pallet transfer unless rotated to the pallet transfer position and a lock pin is retracted. The Index Station can rotate the log to three 90 deg. positions (270 deg.) for work handling.

Some machining centers used with the Pallet Rotary Table System may require relocation of a large machining center pendent or wider carts to clear the Index Station.

Powered doors and carts will be available soon.

