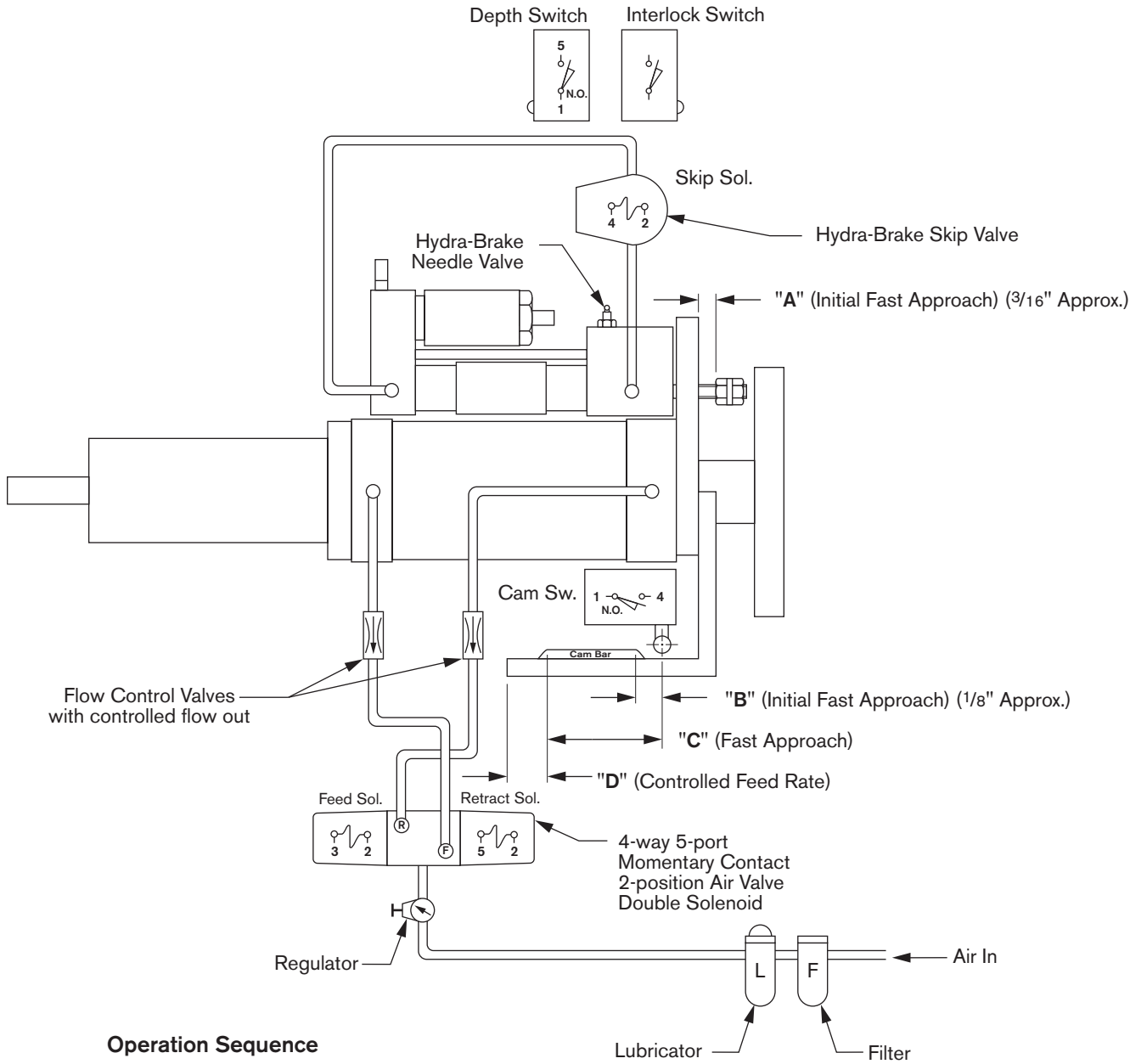


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AUTOMATIC DRILLING & TAPPING UNITS

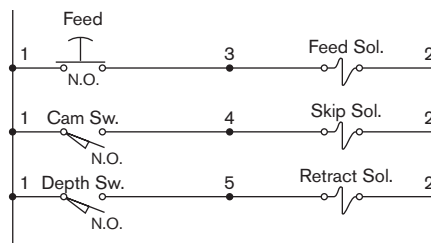
FAST APPROACH-SKIP HYDRA BRAKE OPERATION



Operation Sequence

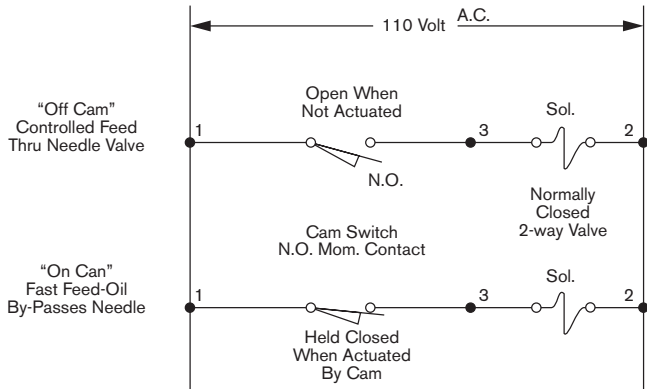
- “A” – Dimension “A” is set as an initial fast approach prior to cam switch actuation (This prevents skip valve solenoid from being electrically held in retract position.)
- “B”– Dimension “B” is set to actuate cam switch just before Dimension “A” is reached.
- “C”– Dimension “C” is total length of rapid approach. Cam bar is cut to suit.
- “D”– Dimension “D” is controlled feed rate thru Hydra-Brake needle valve after switch drops off cam bar

Basic Circuitry

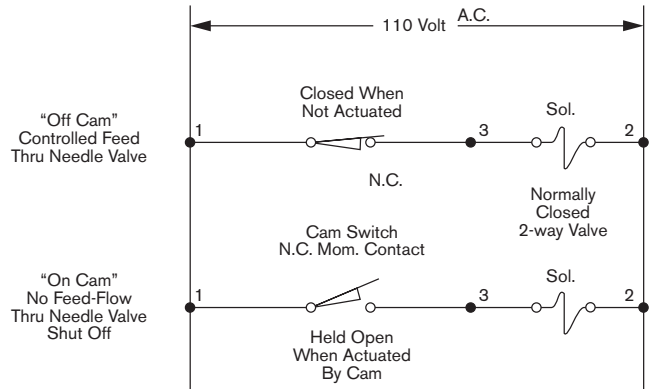


BASIC SKIP-STOP ELECTRICAL CIRCUIT

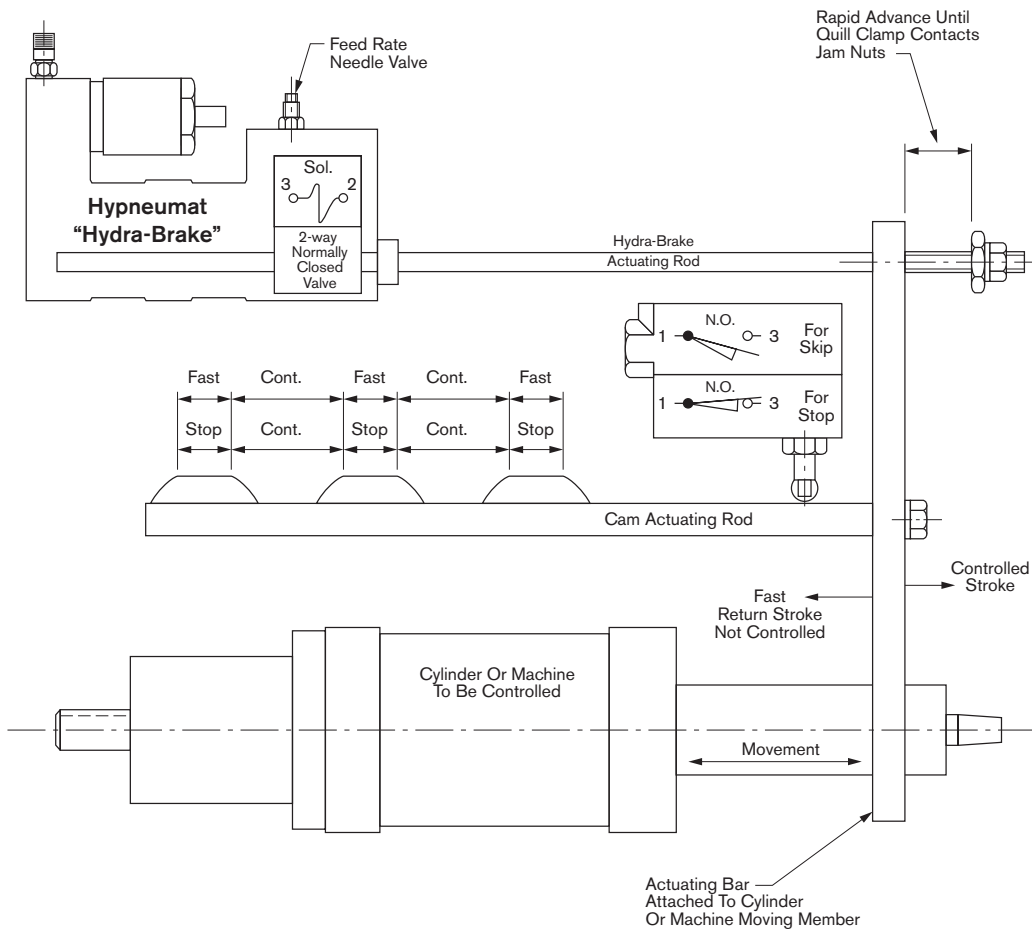
"Skip" Hydra-Brake Electrical Circuit



"Stop" Hydra-Brake Electrical Circuit



Mechanical Installation



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