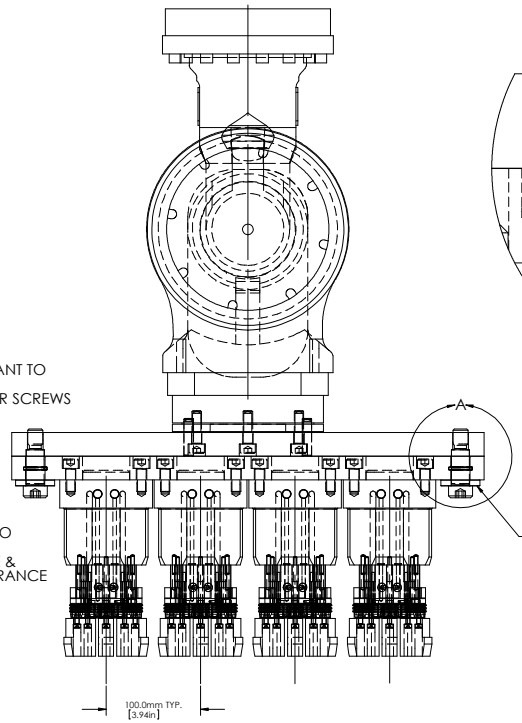
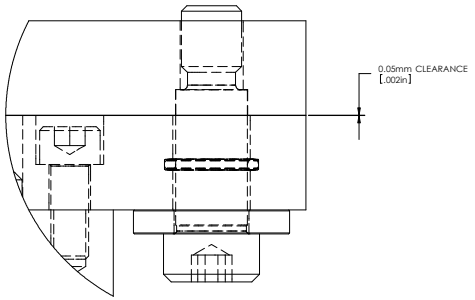


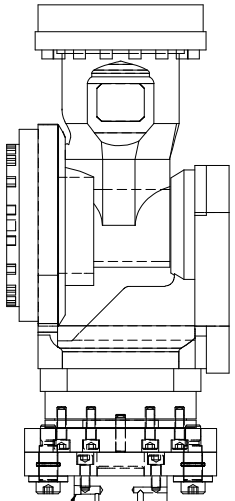
GRIPPER PLATE IS COMPLIANT TO BASE PLATE BY 1.5mm CLEARANCE ON SHOULDER SCREWS

NOTE: GRIND WASHER OR CONTROL C'BORE DEPTH TO ALLOW GRIPPER PLATE TO SLIDE BETWEEN BASE PLATE & WASHER - .001/.002" CLEARANCE

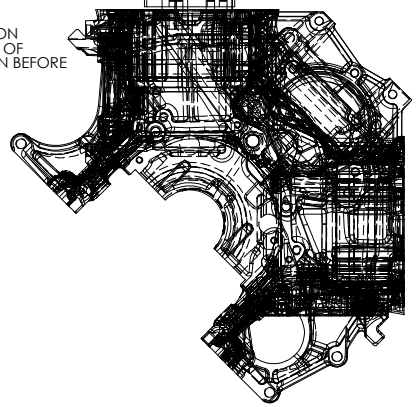
HARDENED WASHER



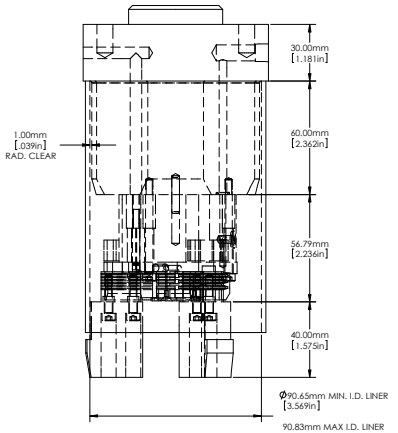
DETAIL A
SCALE 2 : 1



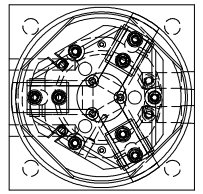
OPENING TO ACCOMODATE SWITCH CABLE



ROBOT TO POSITION LEAD ON GRIPPER FINGERS INTO TOP OF CYLINDER BORES AS SHOWN BEFORE RELEASING LINERS



6mm STROKE PER JAW
1mm TO GO AS SHOWN
5mm RETRACT AS SHOWN

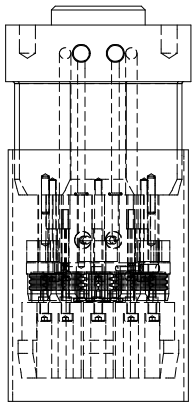


NOTE: COMPLIANCE CALCULATION

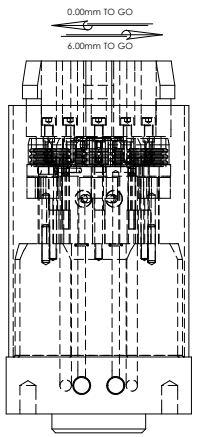
MAX OUT OF POSITION OF CYLINDER BLOCK IN CLAMP UP POS'N = .75mm
REPEATABILITY OF BARREL ROTATE = .25mm
REPEATABILITY OF ROBOT ARM = .30mm

TOTAL AMOUNT OF COMPLIANCE REQUIRED = 1.30mm
TOTAL AMOUNT OF COMPLIANCE ALLOWED IN END OF ARM TOOLING = 1.50mm
LEAD ON GRIPPER FINGERS WILL ACCOMODATE 3.5mm OUT OF POSITION

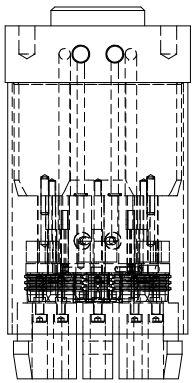
GRIPPER PICKING LINER FROM DUNNAGE



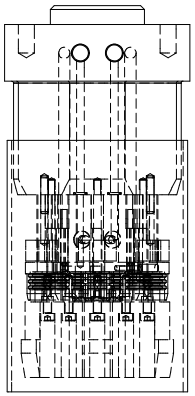
GRIPPERS ROTATED 180 DEGREES UP - JAWS RETRACTED ALLOWING LINER TO DROP AGAINST SHOULDER



JAWS ADVANCE TO HOLD LINER & ROTATE 180 DEGREES DOWN - ROBOT POSITIONS GRIPPER JAWS INTO CYLINDER. BORES



JAWS RETRACT ALLOWING LINER TO FALL INTO CYLINDER BORES



NOTE:
REMOVE ALL SHARP EDGES

NO.	DATE	BY	DESCRIPTION	MATL
			GENERAL REQUIREMENTS UNLESS OTHERWISE SPECIFIED	

CK MANUFACTURING/INDUSTRIAL CONCEPTS INC.

SIZE	DRAWING NO.	REV
E		
DRAWN	DATE	
MJ	03/2011	
CHECKED	SCALE	SHEET
LCG	1:1	1 OF 1

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