

AUTOBRAKE 2000

MODEL: AB1014T2 & AB1014KT2

PARTS MANUAL

ROPER WHITNEY
2833 HUFFMAN BLVD
ROCKFORD, IL 61103
815-962-3011

www.roperwhitney.com

AB1014T2 AND AB1014KT2

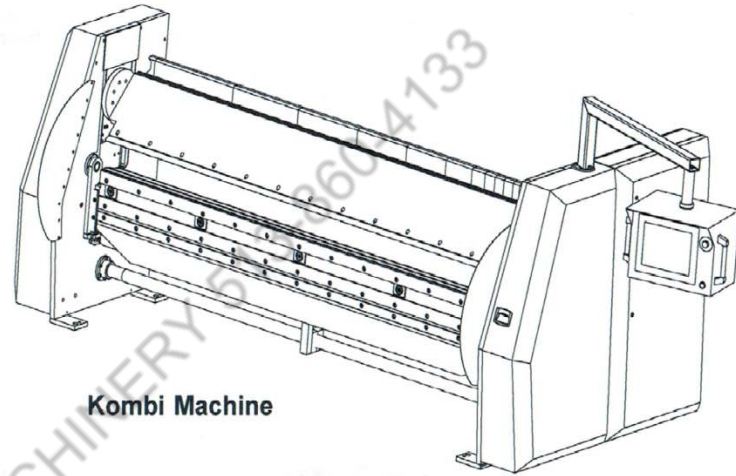
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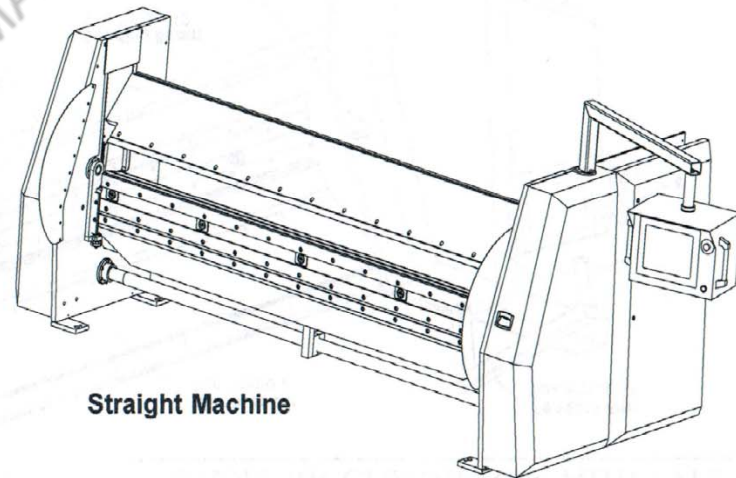
CINCINNATI PRECISION MACHINERY 513-860-4133

SECTION 1:

BASIC MECHANICAL



Kombi Machine



Straight Machine

CINCINNATI PRECISION MACHINERY 513-260-4133

BASIC MECHANICAL – AB1014T2

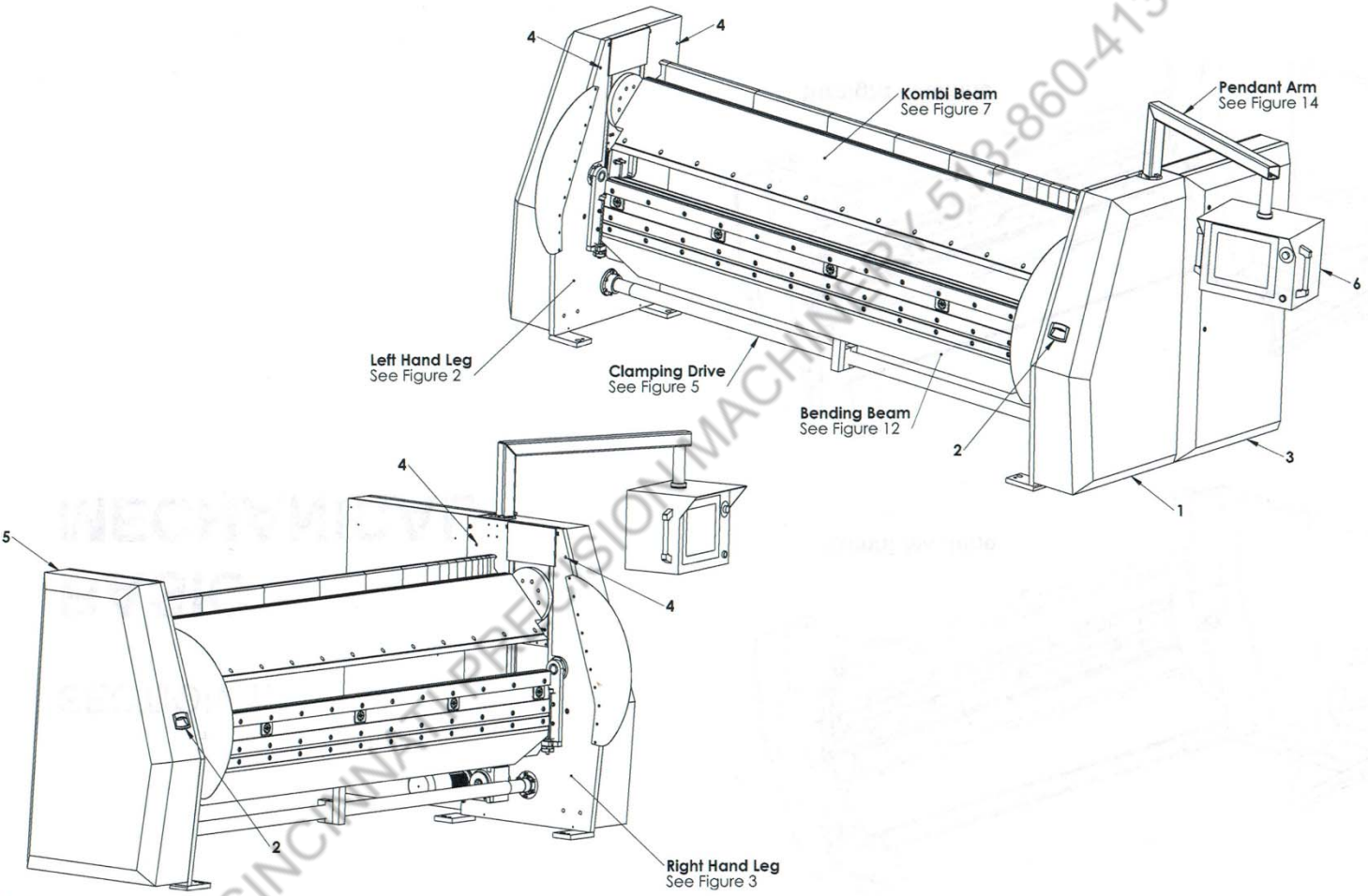


FIG. 1

COVERS AND MISCELLANY

ITEM	QTY	RW PART #	RW PART DESCRIPTION
1	1	786220701	Right Hand Leg Cover
2	4	683356359	Flush Pull Handle
3	1	786220700	Electrical Cabinet
4	4	686012828	Socket Head Cap Screw M8 x 30mm
5	1	786220702	Left Hand Leg Cover
6	1	260009716	Titan/Orion 15" Control Head (IEI)

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BASIC MECHANICAL – AB1014T2

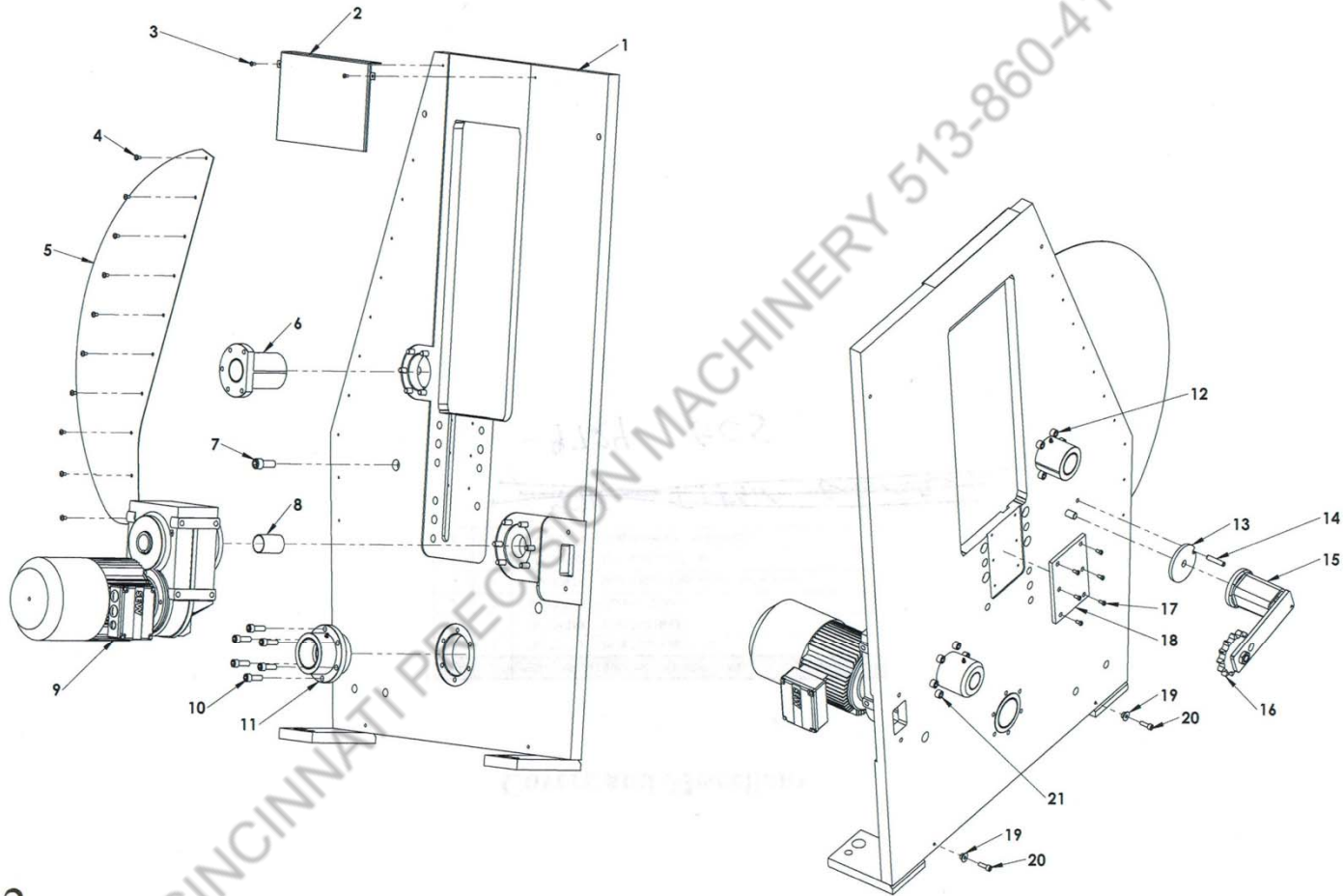


FIG. 2

LEFT HAND LEG

ITEM	QTY	RW PART #	RW PART DESCRIPTION
1	1	786140677	Left Hand Leg
2	1	786220703	Upper Gib Cover
3	2	686012880	Socket Button Head Screw M5 x 10mm
4	11	686012888	Socket Button Head Screw M6 x 10mm
5	1	786440698	Bending Beam Guard
6	1	286940064	Apron Shaft Support
7	1	686012739	Socket Head Cap Screw M16 x 40mm
8	1	686194707	Pocketed Bearing
9	1	660011312	Bending Motor
10	6	686012676	Socket Head Cap Screw M12 x 35mm
11	1	286940066	Clamp Shaft Support
12	5	686012676	Socket Head Cap Screw M12 x 35mm
13	1	596000613	Tensioner Spacer
14	1	683063515	Roll Pin M10 x 50mm
15	1	686000413	Chain Tensioner
16	1	686285519	Idler Sprocket
17	1	686012893	Socket Low Head Cap Screw M6 x 12mm
18	1	686000689	Leg Gib
19	2	783180076	Leg Cover Support
20	2	686012713	Socket Head Cap Screw M8 x 25mm
21	6	686012845	Socket Head Cap Screw M12 x 50mm

BASIC MECHANICAL – AB1014T2

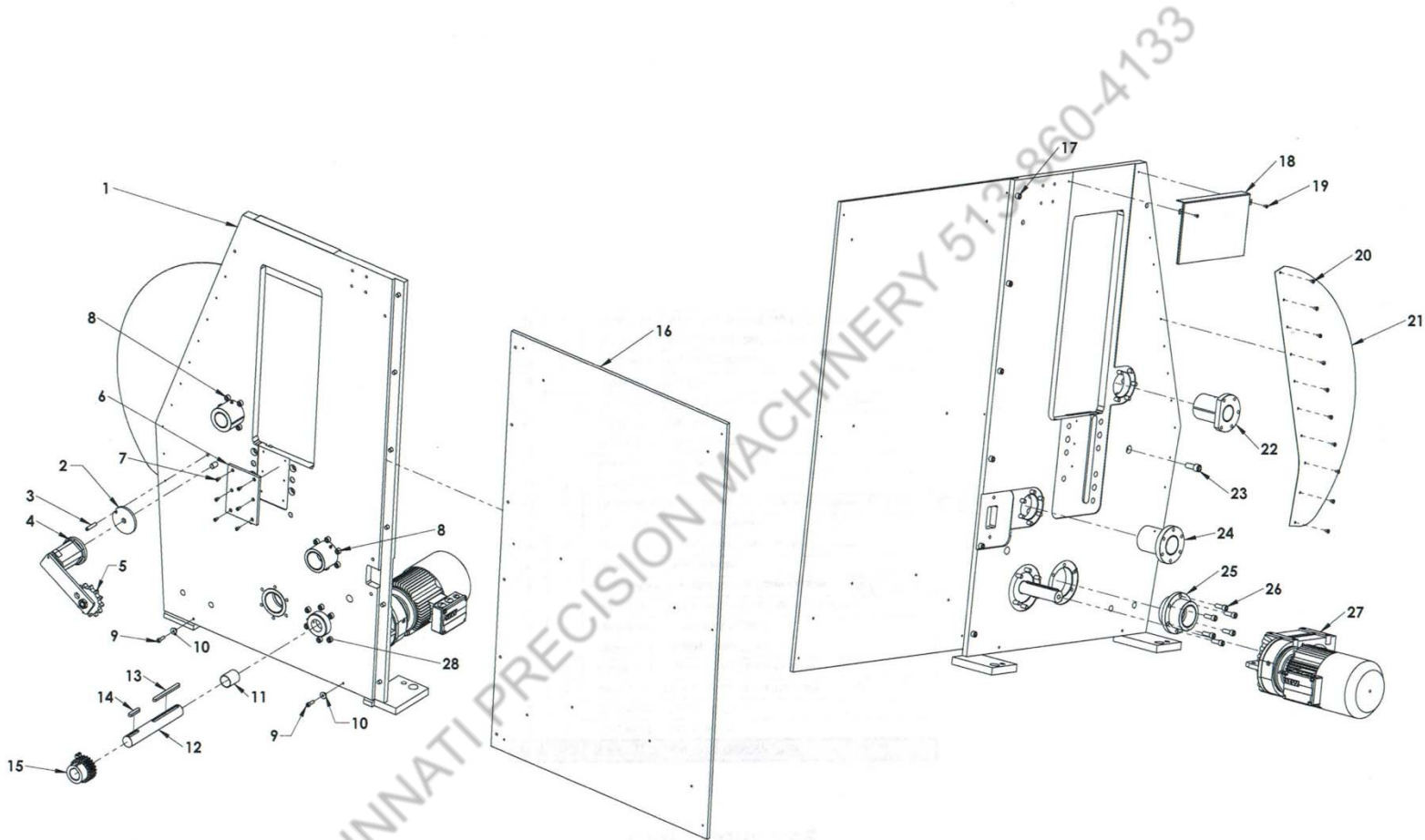


FIG. 3

RIGHT HAND LEG

ITEM	QTY	RW PART #	RW PART DESCRIPTION
1	1	786140678	Right Hand Leg
2	1	596000613	Tensioner Spacer
3	1	683063515	Roll Pin M10 x 50mm
4	1	686000413	Chain Tensioner
5	1	686285519	Idler Sprocket
6	1	686000689	Leg Gib
7	1	686012893	Socket Low Head Cap Screw M6 x 12mm
8	11	686012676	Socket Head Cap Screw M12 x 35mm
9	2	686012713	Socket Head Cap Screw M8 x 25mm
10	2	783180076	Leg Cover Support
11	1	686194807	Pocketed Bearing 40mm x 50mm
12	1	783680145	Clamping Pinion Shaft
13	1	683123938	Key 12mm x 8mm x 140mm
14	1	686123941	Key 12mm x 8mm x 56mm
15	1	786380707	Clamping Pinion Gear
16	1	786060705	Electrical Plate
17	6	686012674	Socket Head Cap Screw M12 x 30mm
18	1	786220703	Upper Gib Cover
19	2	686012880	Socket Button Head Screw M5 x 10mm
20	11	686012888	Socket Button Head Screw M6 x 10mm
21	1	786440698	Bending Beam Guard
22	1	286940064	Apron Shaft Support
23	1	686012739	Socket Head Cap Screw M16 x 40mm
24	1	286940065	Bending Shaft Support
25	1	286940066	Clamp Shaft Support
26	6	686012676	Socket Head Cap Screw M12 x 35mm
27	1	660011311	Clamping Motor
28	6	686012845	Socket Head Cap Screw M12 x 50mm

BASIC MECHANICAL – AB1014T2

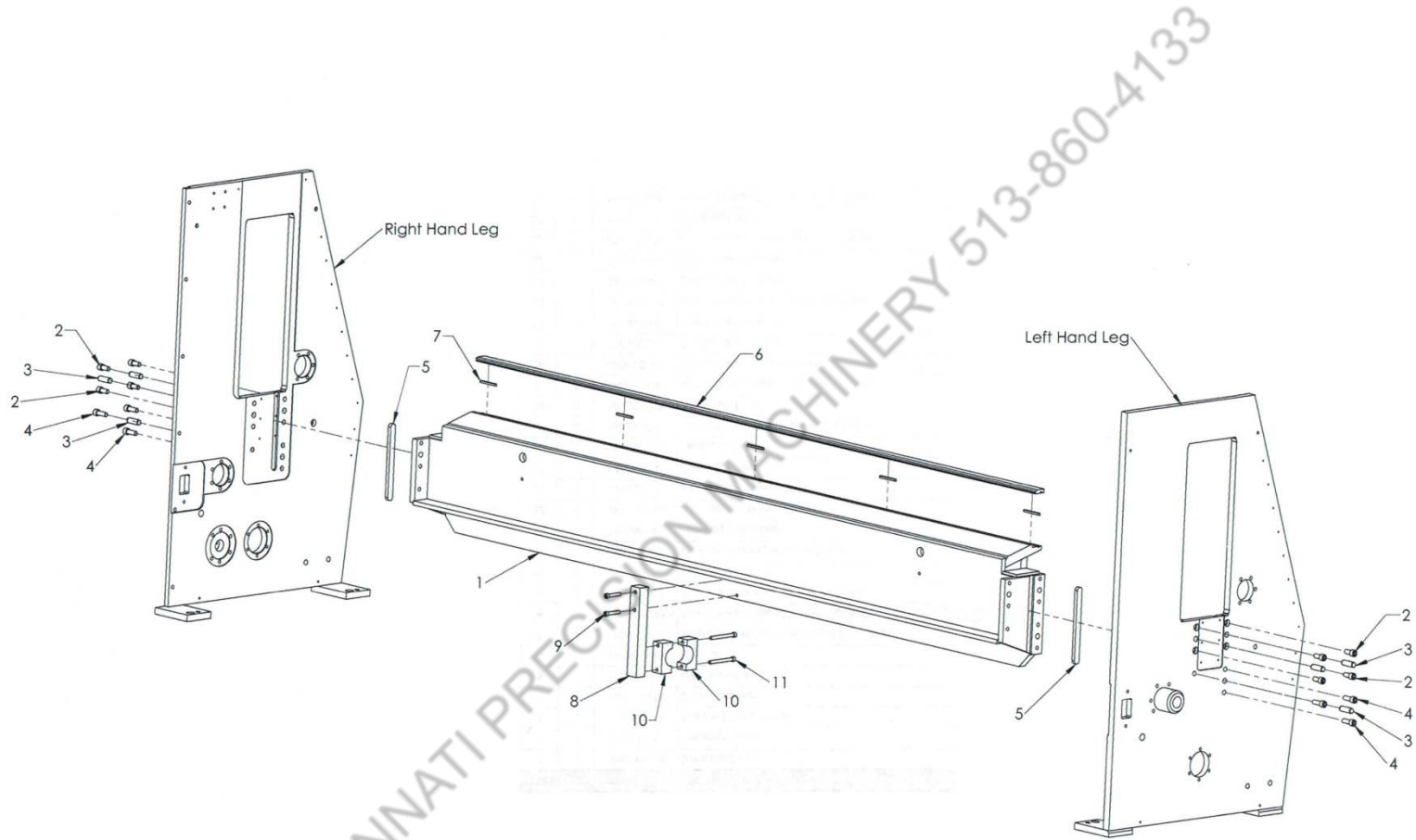


FIG. 4

LOWER BEAM

ITEM	QTY	RW PART #	RW PART DESCRIPTION
1	1	786020691	Lower Beam
2	8	686012889	Socket Head Cap Screw M16 x 35mm
3	6	686053402	Dowel Pin M20 x 60mm
4	6	686012890	Socket Head Cap Screw M16 x 45mm
5	2	786530683	Leg Key
6	1	786020816	Lower Jaw
7	5	686123942	Key – 8mm x 7mm x 90mm
8	1	786180681	Shaft Support
9	2	686012716	Socket Head Cap Screw M12 x 65mm
10	2	786130682	Support Bearing Block
11	2	686012891	Socket Head Cap Screw M12 x 120mm

BASIC MECHANICAL – AB1014T2

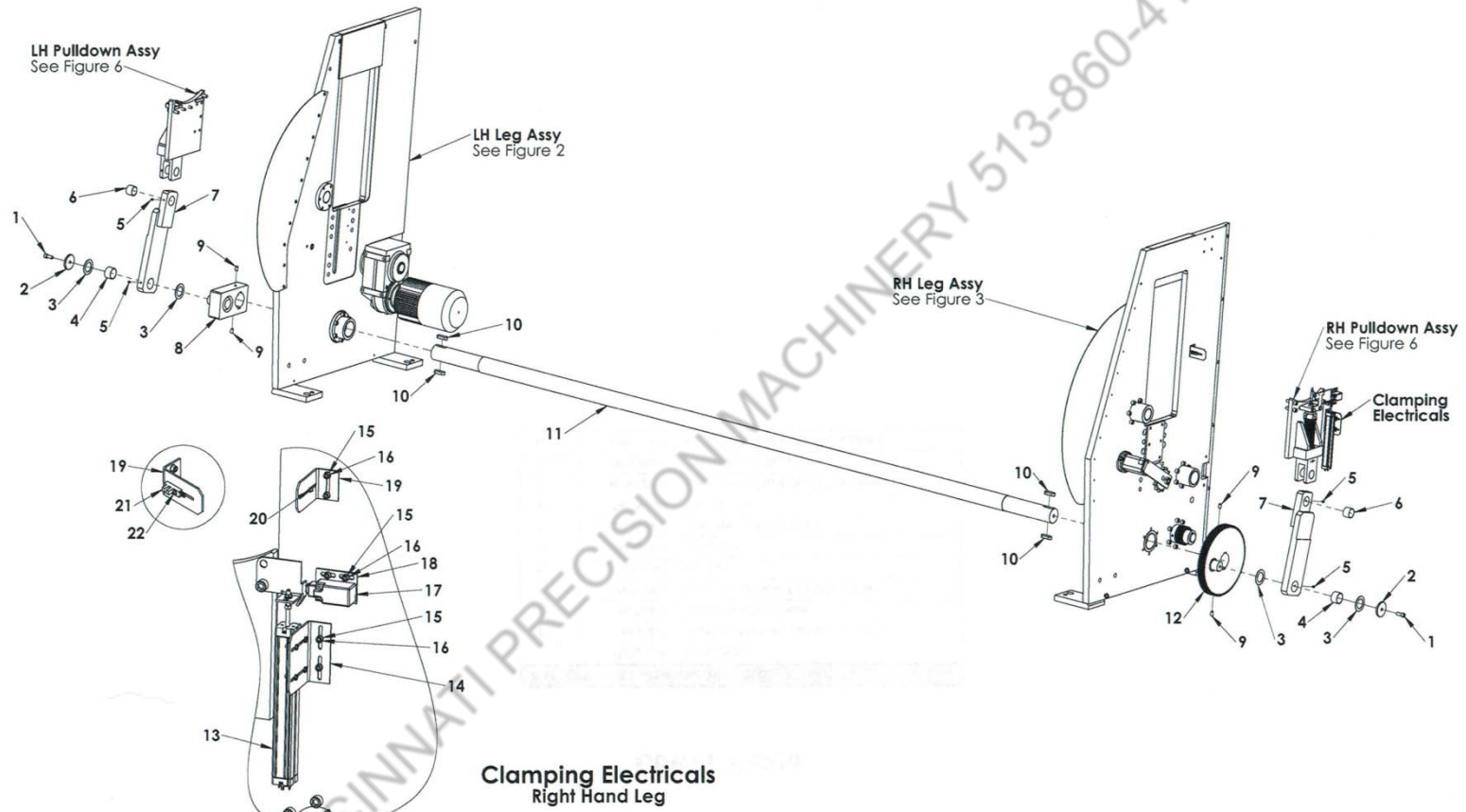
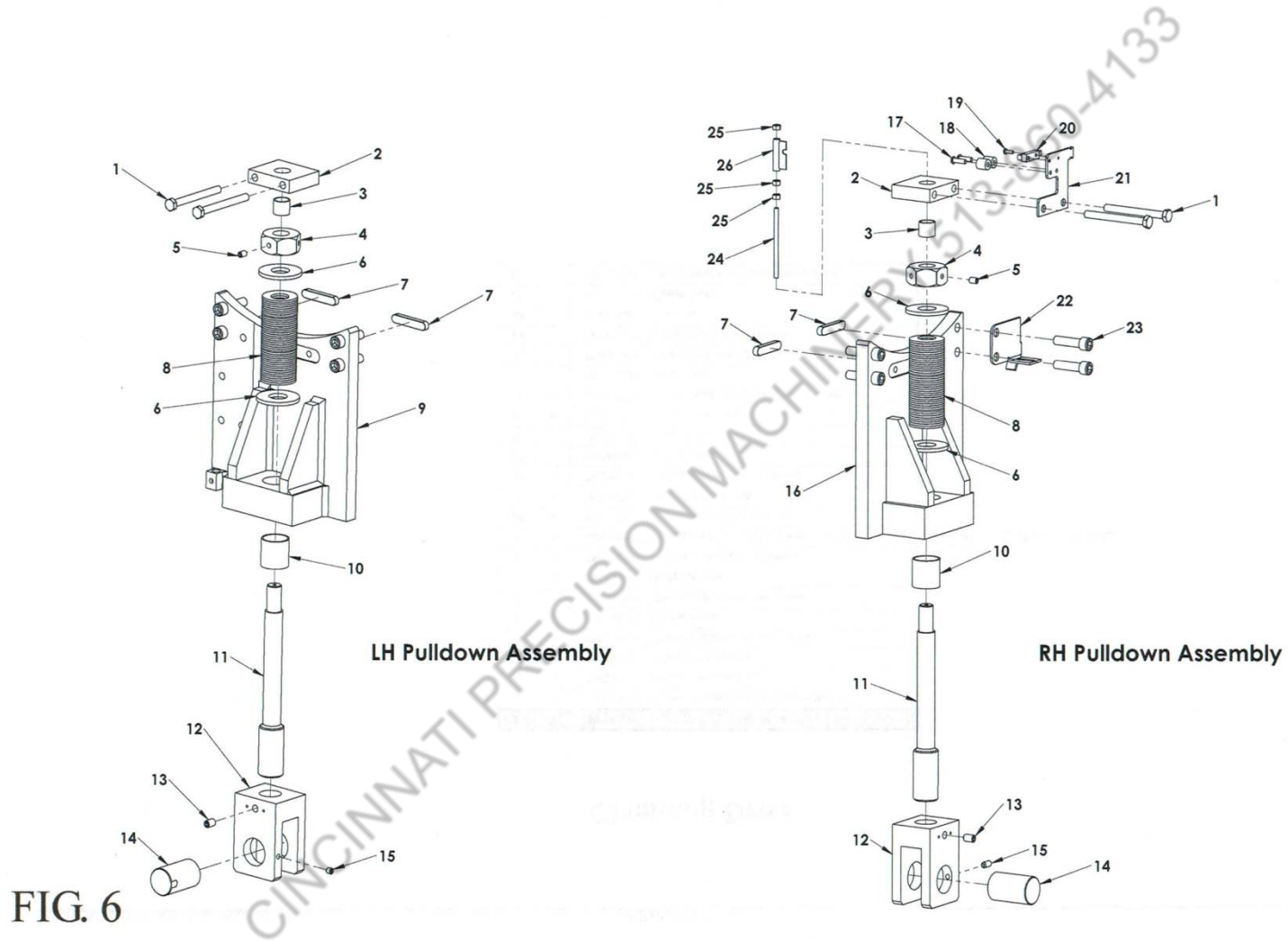


FIG. 5

CLAMPING DRIVE

ITEM	QTY	RW PART #	RW PART DESCRIPTION
1	2	686012674	Socket Head Cap Screw M12 x 30mm
2	2	786220727	Clamp Drive End Cap
3	4	786830712	Clamp Drive Washer
4	2	686194810	Pocketed Bearing 45mm x 30mm
5	4	686134017	Grease Fitting
6	2	686194707	Pocketed Bearing 40mm x 30mm
7	1	786030697	Pulldown Arm
8	1	786240711	Clamping Drive Link Weldment
9	4	686012672	Low Socket Head Cap Screw M12 x 20mm
10	4	686122894	Key 20mm x 12mm x 56mm
11	1	786680706	Clamping Drive Shaft
12	1	786380710	Main Clamping Gear Weldment
13	1	660000465	Linear Encoder
14	1	786200742	Linear Encoder Bracket
15	6	686033217	Lock Washer 6mm
16	6	686012733	Socket Head Cap Screw M6 x 10mm
17	1	660152656	Limit Switch
18	1	783010063	Limit Switch Bracket
19	1	783200065	Clamp Optical Switch Bracket
20	1	686023065	Nut 4mm
21	1	660233459	Optical Switch
22	1	686012636	Socket Head Cap Screw M4 x 16mm

BASIC MECHANICAL – AB1014T2



PULLDOWN ASSEMBLIES

ITEM	QTY	RW PART #	RW PART DESCRIPTION
1	4	686012902	Socket Head Cap Screw M10 x 100mm
2	2	786130690	Pulldown Shaft Block
3	2	686194809	Pocketed Bearing 20mm x 20mm Long
4	2	786560738	Clamp Spring Retaining Nut
5	2	686012896	Brass Tipped Socket Set Screw
6	4	786830737	Spring Stack Retaining Washer
7	4	686123944	Key 12mm x 8mm x 63mm
8	80	689790115	Clamp Disc Spring
9	1	786060685	Left Hand Pulldown Plate
10	2	683194798	Pocketed Bearing 35mm x 40mm Long
11	2	786680686	Pulldown Shaft
12	2	786500687	Pulldown Pivot Block
13	2	686012708	Socket Set Screw M10 x 16mm
14	2	786160692	Pulldown Pin
15	2	686012878	Socket Set Screw M8 x 16mm
16	1	786060684	Right Hand Pulldown Plate
17	2	686012871	Socket Head Button Screw M6 x 20mm
18	2	686000573	Plastic Cylinder Guide
19	1	686012724	Slotted Head Screw M4 x 12mm
20	1	660233459	Opto Switch
21	1	786010688	Upper Limit Switch Bracket
22	1	786010689	Pulldown Encoder Bracket
23	8	686012815	Socket Head Cap Screw M12 x 45mm
24	1	786000499	Threaded Rod M6 x 100mm
25	3	686023064	Hex Nut M6
26	1	783000111	Pulldown Sensor Flag

BASIC MECHANICAL – AB1014T2

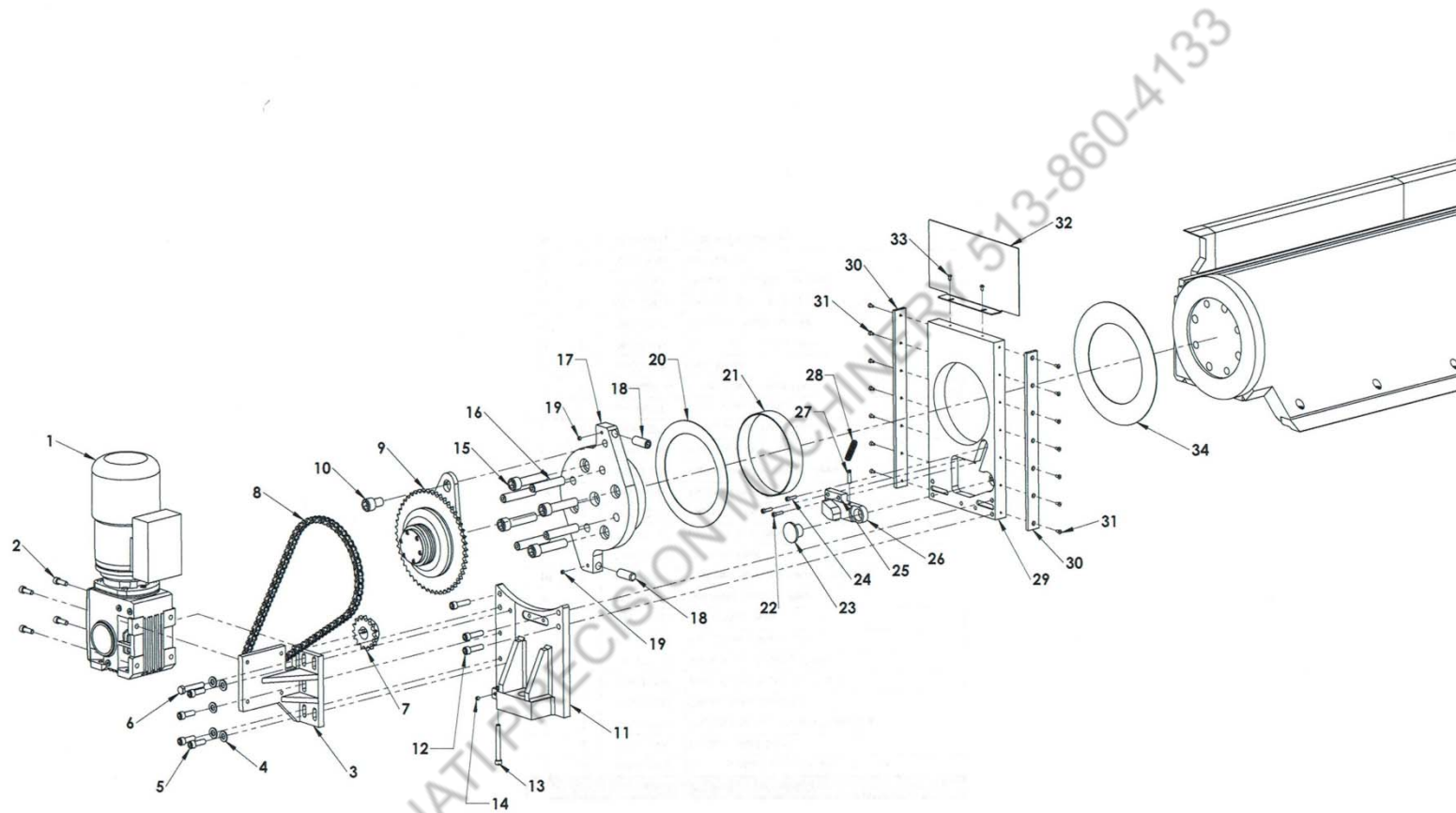


FIG. 7

KOMBI BEAM – LEFT HAND VIEW

ITEM	QTY	RW PART #	RW PART DESCRIPTION	ITEM	QTY	RW PART #	RW PART DESCRIPTION
1	1	660011313	Kombi Motor	18	2	686012898	Socket Set Screw M8 x 6mm
2	4	686012746	Socket Head Cap Screw M10 x 30mm	19	1	786830747	Outer Kombi Washer
3	1	786010743	Kombi Motor Mount	20	1	686194812	Bearing 200mm x 35mm
4	5	686033220	Flat Washer 12mm	21	2	686012725	Socket Head Cap Screw M6 x 25mm
5	4	686012676	Socket Head Cap Screw M12 x 35mm	22	1	786160754	Latch Rotation Pin
6	1	686012904	Hex Head Screw M12 x 65mm	23	1	686012725	Socket Head Cap Screw M6 x 25mm
7	1	786710755	Kombi Motor Sprocket	24	1	686000695	Latch Stop
8	1	786000757	Kombi Chain	25	1	786330753	Left Hand Kombi Latch
9	1	286940140	Torque Limiter	26	1	686184631	Latch Spring Anchor
10	1	786060685	Left Hand Pulldown Plate	27	1	686184630	Latch Extension Spring
11	3	686012815	Socket Head Cap Screw M12 x 45mm	28	1	786060751	Left Hand Kombi End Plate
12	1	686012901	Socket Head Cap Screw M10 x 90mm	29	2	683000690	Upper Beam Gib
13	1	695012808	Socket Set Screw M8 x 8mm	30	14	686012823	Socket Flat Head Screw M5 x 12mm
14	4	686012900	Socket Head Cap Screw M20 x 90mm	31	1	786220709	Upper Beam Gib Cover
15	4	686053407	Threaded Dowel Pin M20 x 100mm	32	2	686012880	Socket Head Button Screw M5 x 10mm
16	1	786060749	Left Hand Kombi Lock Plate	33	1	786830746	Inner Kombi Washer
17	2	686012899	Flat Point Socket Set Screw M20 x 50mm				

BASIC MECHANICAL – AB1014T2

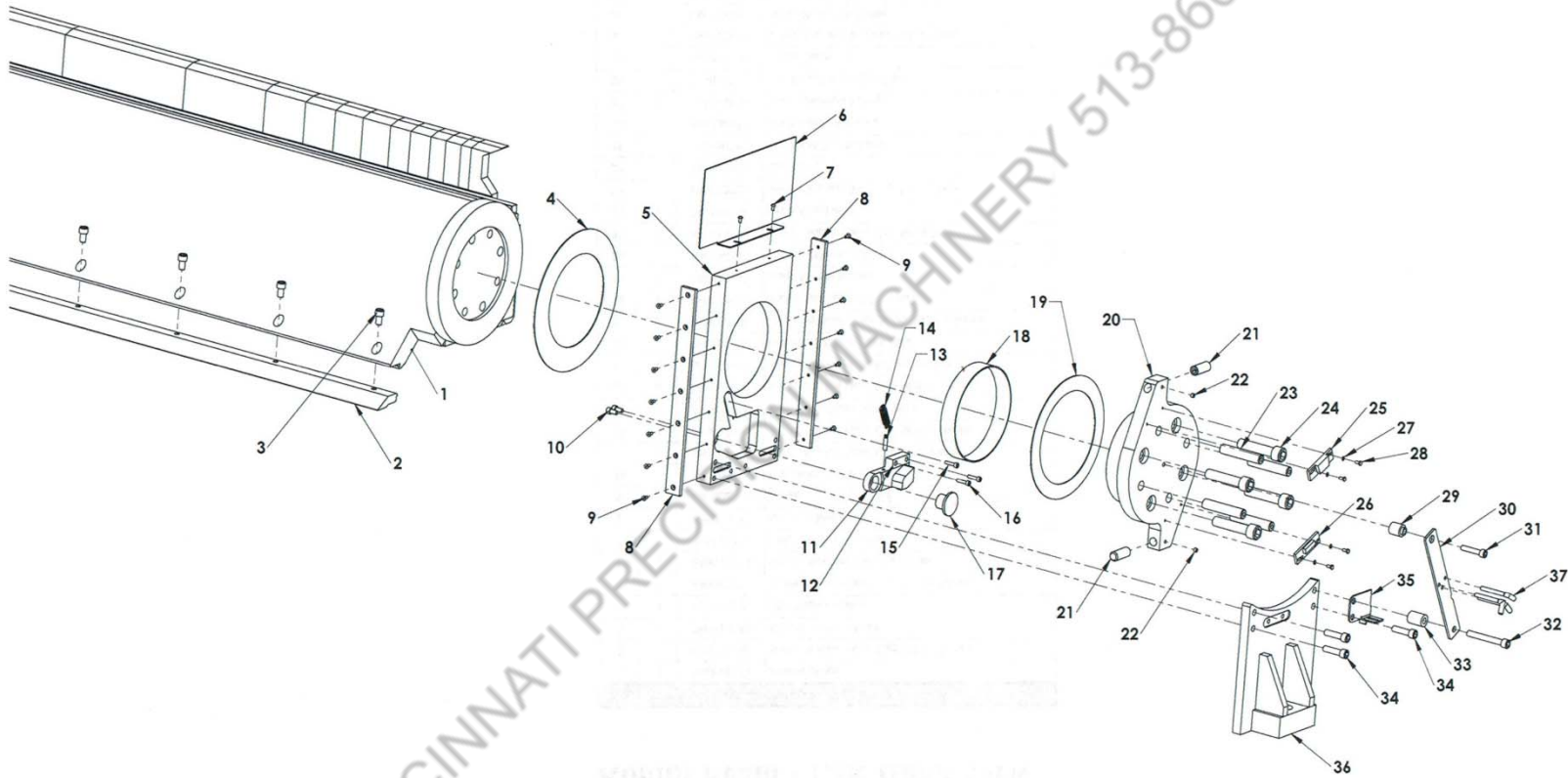


FIG. 8

KOMBI BEAM – RIGHT HAND VIEW

ITEM	QTY	RW PART #	RW PART DESCRIPTION	ITEM	QTY	RW PART #	RW PART DESCRIPTION
1	1	786020744	Kombi Beam	20	1	786060745	Right Hand Kombi Lock Plate
2	1	783020141	Upper Jaw	21	2	686012899	Flat Point Socket Set Screw M20 x 50mm
3	13	686012672	Low Socket Head Cap Screw M12 x 20mm	22	2	686012898	Socket Set Screw M8 x 6mm
4	1	786830746	Inner Kombi Washer	23	4	686053407	Threaded Dowel Pin M20 x 100mm
5	1	786060750	Right Hand Kombi End Plate	24	4	686012900	Socket Head Cap Screw M20 x 90mm
6	1	786220709	Upper Beam Gib Cover	25	1	786130780	Box Tool Flag
7	2	686012880	Socket Head Button Screw M5 x 10mm	26	1	786130781	Straight Tool Flag
8	2	683000690	Upper Beam Gib	27	4	686033180	Lock Washer
9	14	686012823	Socket Flat Head Screw M5 x 12mm	28	4	686012869	Low Head Hex Screw M5 x 8mm
10	2	686012765	Socket Head Cap Screw M8 x 16mm	29	1	786630756	Kombi Arm Spacer
11	1	786330753	Left Hand Kombi Latch	30	1	786060748	Kombi Sensor Arm
12	1	686000695	Latch Stop	31	1	686012857	Socket Head Cap Screw M10 x 50mm
13	1	686184631	Latch Spring Anchor	32	1	686012721	Socket Head Cap Screw M12 x 90mm
14	1	686184630	Latch Extension Spring	33	1	786630758	Pulldown Kombi Arm Spacer
15	1	686012725	Socket Head Cap Screw M6 x 25mm	34	3	686012815	Socket Head Cap Screw M12 x 45mm
16	2	686012725	Socket Head Cap Screw M6 x 25mm	35	1	786010689	Pulldown Encoder Bracket
17	1	786160754	Latch Rotation Pin	36	1	786060684	Right Hand Pulldown Plate
18	1	686194812	Bearing 200mm x 35mm	37	3	660152699	Proximity Switch
19	1	786830747	Outer Kombi Washer				

BASIC MECHANICAL – AB1014T2

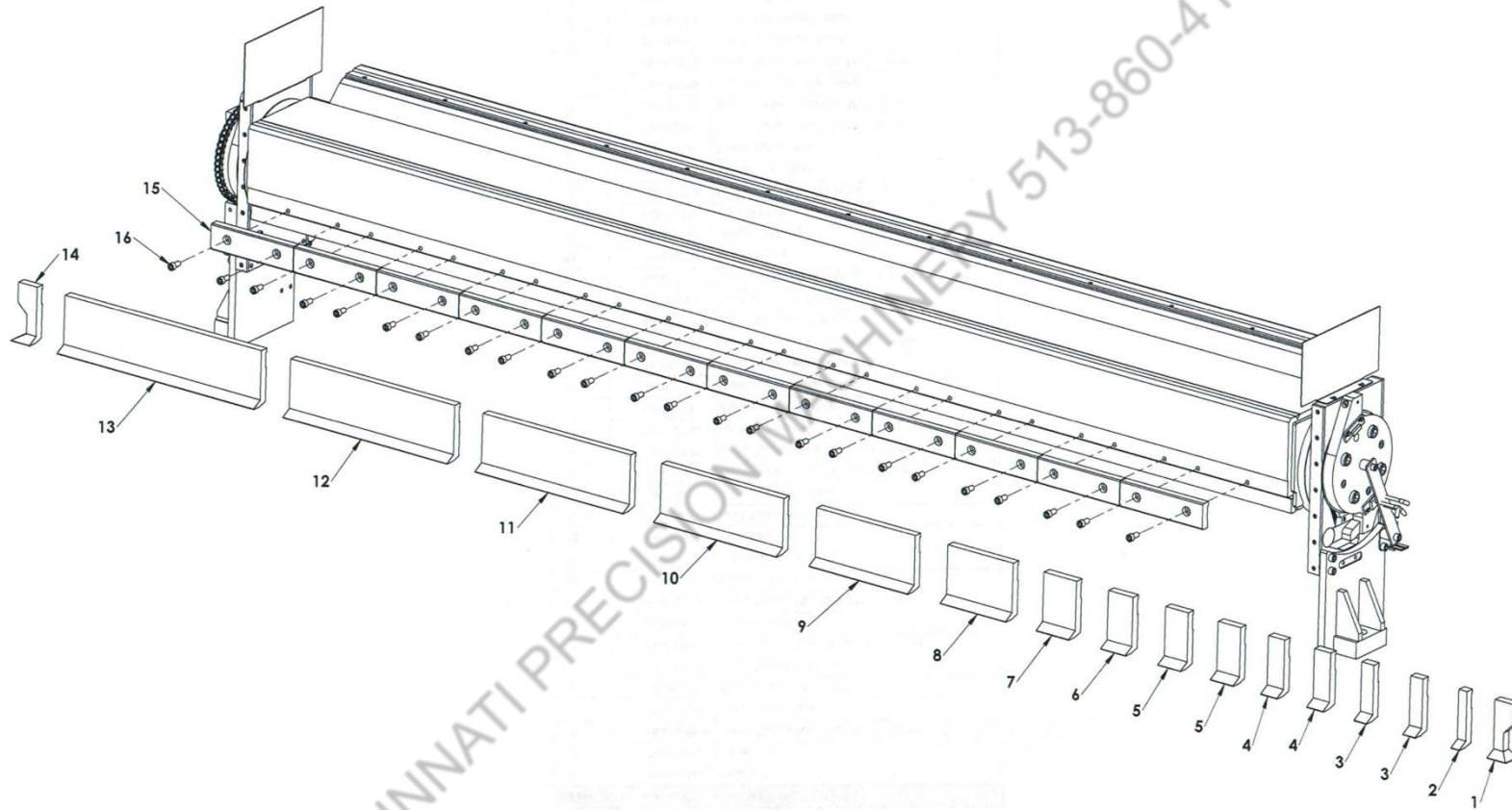


FIG. 9

KOMBI TOOLING

ITEM	QTY	RW PART #	RW PART DESCRIPTION
1	1	786360726	Right Finger
2	1	786360724	Finger – 1"
3	2	786360723	Finger – 1 ½"
4	2	786360722	Finger – 2"
5	2	786360721	Finger – 2 ¾"
6	1	786360720	Finger – 3"
7	1	786360719	Finger – 4"
8	1	786360718	Finger – 8"
9	1	786360717	Finger – 12"
10	1	786360716	Finger – 15"
11	1	786360715	Finger – 18"
12	1	786360714	Finger – 20"
13	1	786360713	Finger – 24"
14	1	786360725	Left Finger
15	12	786010632	Kombi Tool Clamp
16	24	686012827	Socket Head Cap Screw M12 x 25mm

BASIC MECHANICAL – AB1014T2

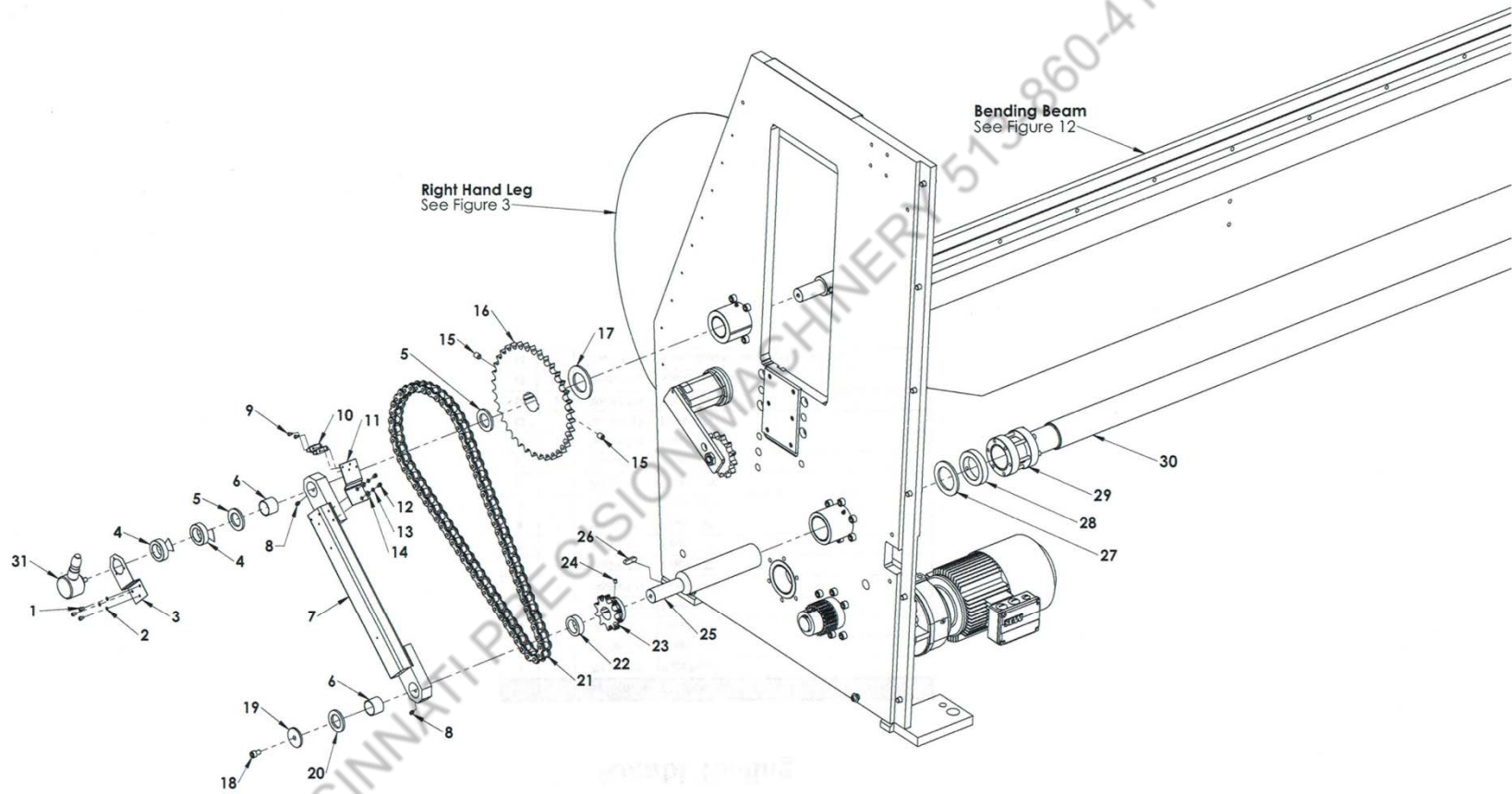


FIG. 10

BENDING DRIVE – RIGHT HAND VIEW

ITEM	QTY	RW PART #	RW PART DESCRIPTION	ITEM	QTY	RW PART #	RW PART DESCRIPTION
1	3	686012707	Socket Head Cap Screw M5 x 8mm	17	1	783830150	Thick Washer 5mm
2	3	686033180	Lock Washer M5	18	1	686012894	Socket Head Cap Screw M10 x 16mm
3	1	786200739	Encoder Mounting Bracket	19	1	786830729	Stop Washer
4	2	786130741	Bending Flag	20	1	786830730	Brass Bending Washer
5	2	786830730	Brass Bending Washer	21	1	786000734	Bending Chain
6	2	683194804	Pocket Bearing 35mm	22	1	786630731	Bending Spacer
7	1	786180693	Bending Shaft Weldment Support	23	1	783710021	Small Bending Sprocket
8	2	686134017	Spin/Drive Straight Grease Fitting	24	1	695012808	Socket Set Screw
9	2	686012724	Slotted Head Screw M4 x 12mm	25	1	786680733	Short Bending Shaft
10	2	660233459	Opto Switch	26	1	783530053	Key 10mm x 8mm x 36mm
11	1	786200740	Bending Opto Mounting Bracket	27	1	786830732	Large Bending Washer
12	2	686012707	Socket Head Cap Screw M5 x 8mm	28	1	686000694	Retaining Collar 40mm
13	2	686033180	Lock Washer M5	29	1	686000693	Taper Lock Connector
14	2	686033173	Flat Washer 6mm	30	1	786680728	Long Bending Shaft
15	2	686012886	Socket Head Cap Screw M12 x 55mm	31	1	660000404	Rotary Encoder
16	1	783710022	Large Bending Sprocket				

BASIC MECHANICAL – AB1014T2

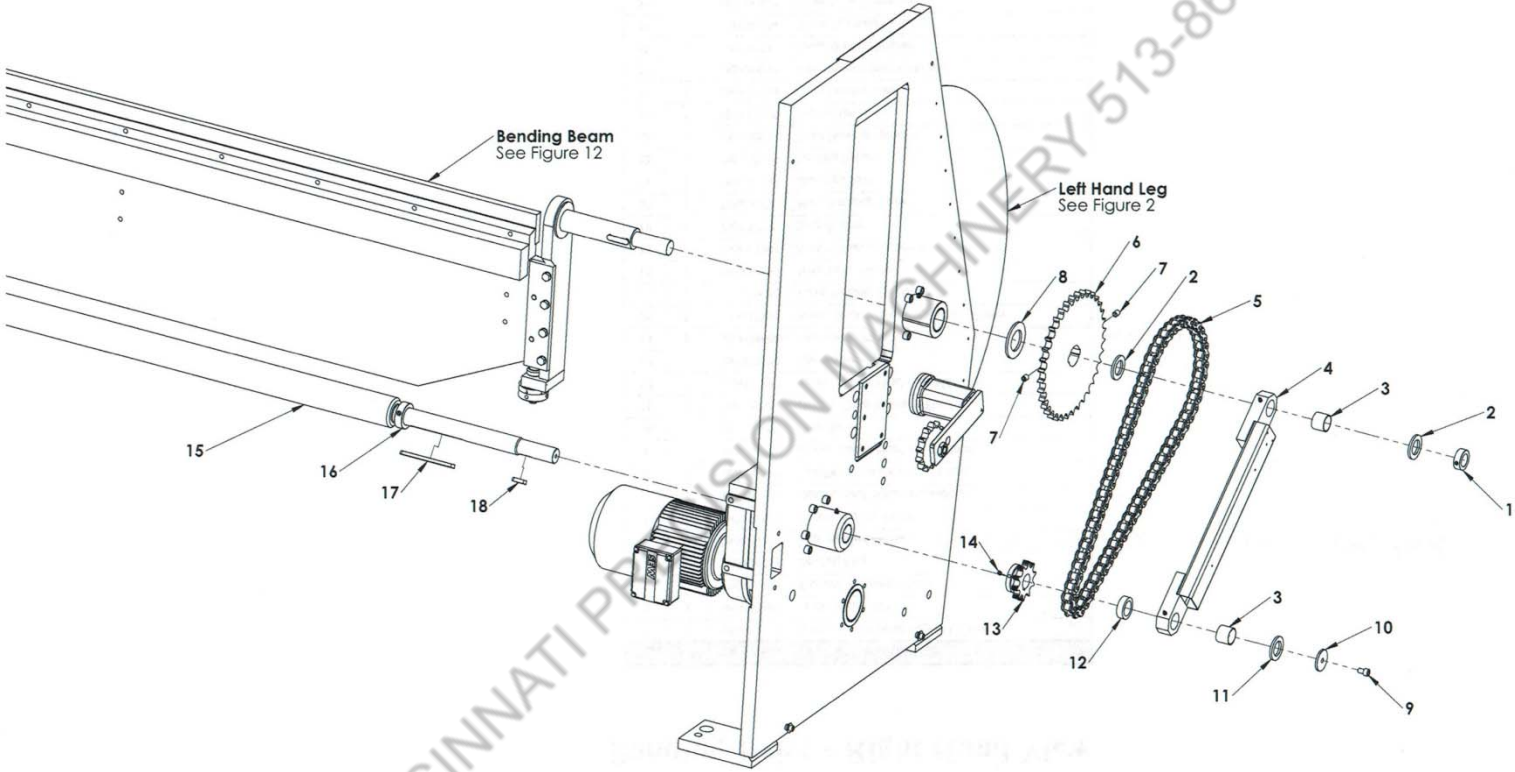


FIG. 11

BENDING DRIVE – LEFT HAND VIEW

ITEM	QTY	RW PART #	RW PART DESCRIPTION
1	1	683000684	Retaining Collar 30mm
2	2	786830730	Brass Bending Washer
3	2	683194804	Pocket Bearing 35mm
4	1	786180693	Bending Shaft Weldment Support
5	1	786000734	Bending Chain
6	1	783710022	Large Bending Sprocket
7	2	686012886	Socket Head Cap Screw M12 x 55mm
8	1	783830150	Thick Washer 5mm
9	1	686012894	Socket Head Cap Screw M10 x 16mm
10	1	786830729	Stop Washer
11	1	786830730	Brass Bending Washer
12	1	786630731	Bending Spacer
13	1	783710021	Small Bending Sprocket
14	1	695012808	Socket Set Screw
15	1	786680728	Long Bending Shaft
16	1	686000694	Retaining Collar 40mm
17	1	683123938	Key 12mm x 8mm x 140mm
18	1	783530053	Key 10mm x 8mm x 36mm

BASIC MECHANICAL – AB1014T2

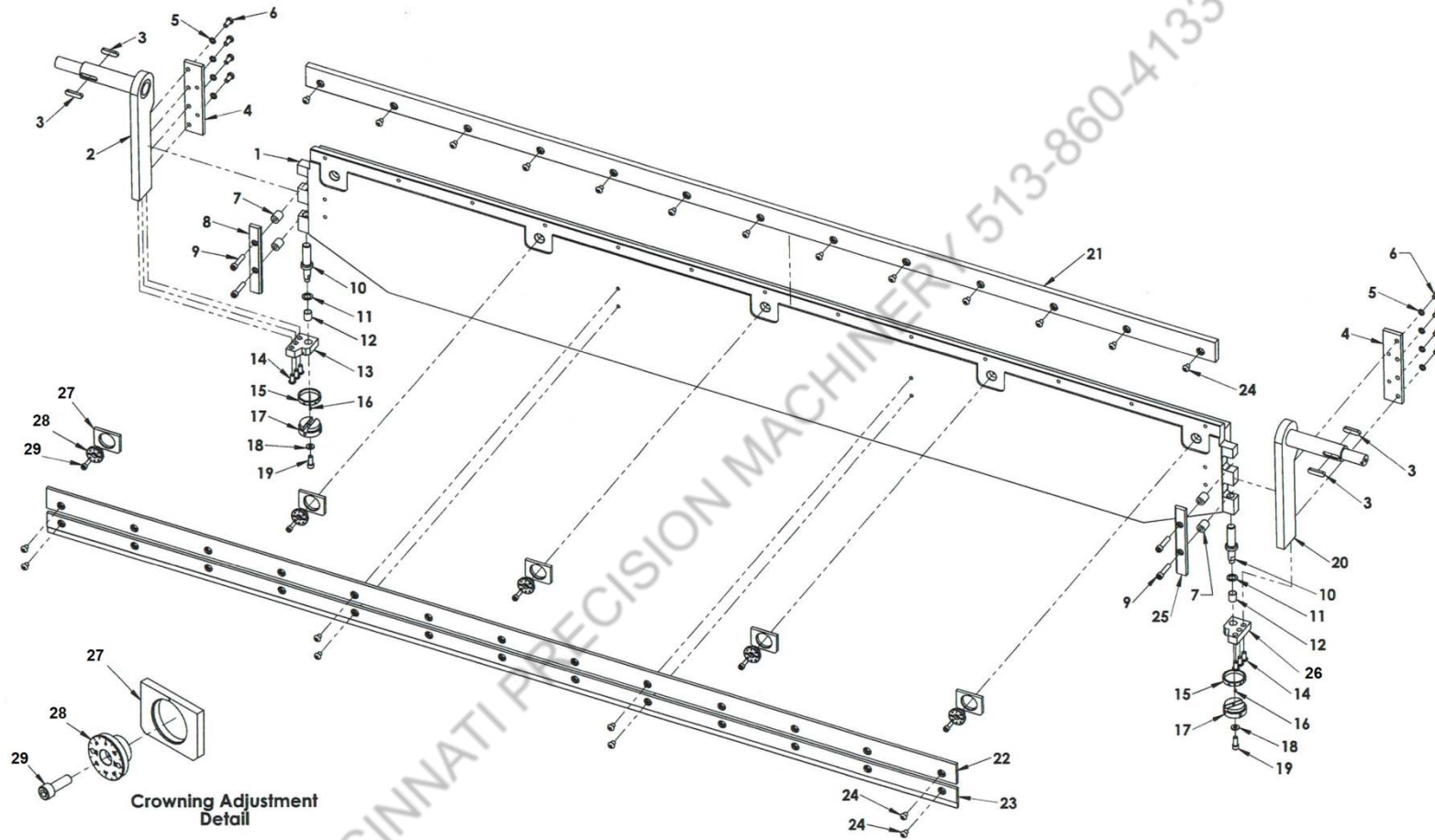
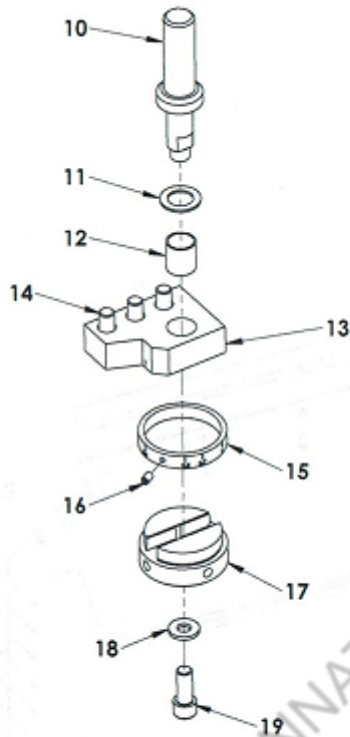


FIG. 12

BENDING BEAM



Apron Adjustment Detail

ITEM	QTY	RW PART #	RW PART DESCRIPTION
1	1	783020136	Bending Beam
2	1	783500130	Bending Beam Left Hand Hinge
3	4	783530052	Key 9mm x 14mm x 56mm
4	2	783030126	Bending Beam Support Plate
5	8	686033185	Lock Washer 12mm
6	8	686012873	Hex Head Bolt M12 x 25mm
7	4	783630133	Bending Beam Gib Spacer
8	1	783400135	Left Hand Bending Beam Gib
9	4	686012886	Socket Head Cap Screw M12 x 55mm
10	2	783160127	Bending Beam Set Screw
11	2	783830110	Apron Thrust Bearing
12	2	683194794	Pocketed Bearing 20mm x 30mm Long
13	1	783500131	Left Hand Set Screw Plate
14	6	686012903	Socket Button Head Screw M14 x 25mm
15	2	786300591	Apron Ring Scale
16	2	695012811	Socket Set Screw M6 x 10mm
17	2	783300013	Bending Beam Dial
18	2	686033220	Flat Washer M12
19	2	686012674	Socket Head Cap Screw M12 x 30mm
20	1	783500129	Bending Beam Right Hand Hinge
21	1	786120694	Thick Bending Bar 20mm
22	1	786120695	Thin Bending Bar 10mm
23	1	786120696	Thin Bending Bar 7mm
24	21	686012673	Socket Button Head Screw M12 x 30mm
25	1	783400128	Right Hand Bending Beam Gib
26	1	783500132	Right Hand Set Screw Plate
27	5	783060114	Crowning Plate
28	5	783210113	Crowning Eccentric
29	5	686012746	Socket Head Cap Screw M10 x 30mm

BASIC MECHANICAL – AB1014T2

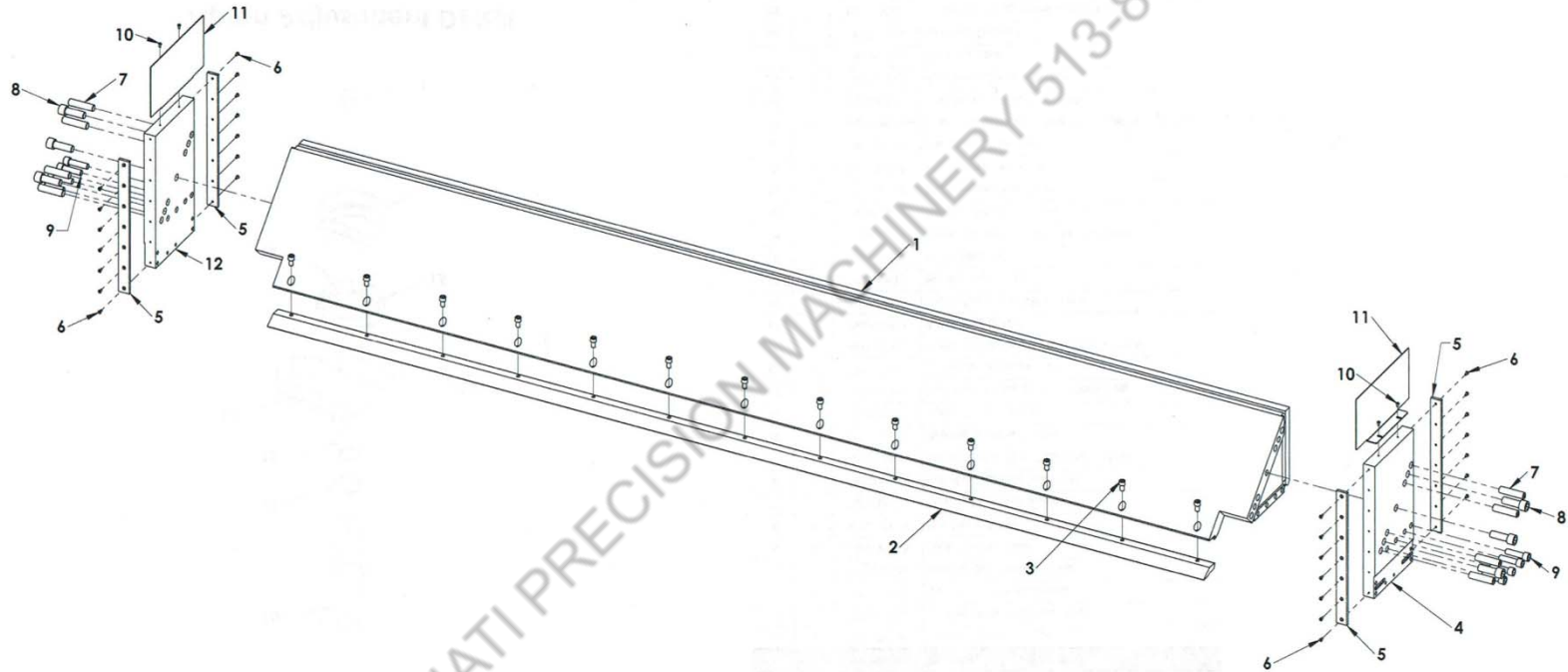


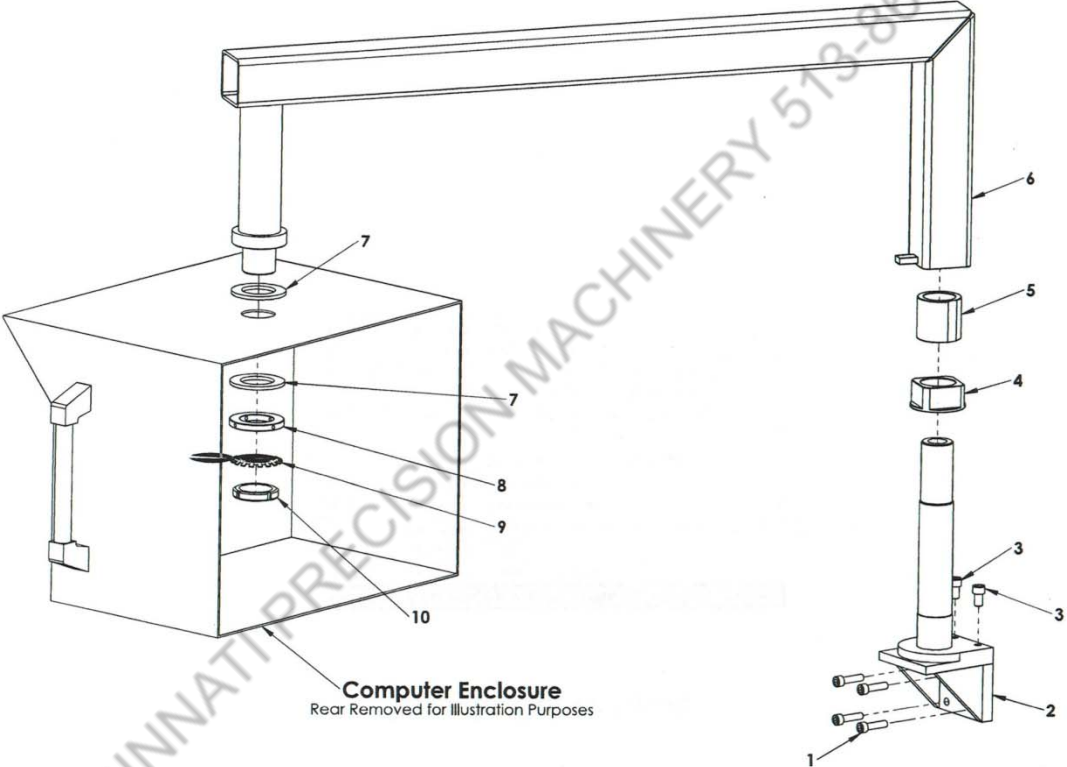
FIG. 13

CINCINNATI PRECISION MACHINERY 513-860-4133

STRAIGHT UPPER BEAM

ITEM	QTY	RW PART #	RW PART DESCRIPTION
1	1	783020140	Straight Upper Beam
2	1	783020141	Upper Jaw
3	13	686012672	Low Socket Head Cap Screw M12 x 20mm
4	1	783060143	Right Hand End Plate
5	4	683000690	Upper Beam Gib
6	28	686012823	Socket Flat Head Screw M5 x 12mm
7	8	686053403	Dowel Pin M20 x 80mm
8	6	689650720	Socket Head Cap Screw M20 x 60mm
9	8	683012892	Socket Head Cap Screw M16 x 60mm
10	4	686012880	Socket Head Button Screw M5 x 10mm
11	2	786220709	Upper Beam Gib Cover
12	1	783060142	Left Hand End Plate

BASIC MECHANICAL – AB1014T2



Computer Enclosure
Rear Removed for Illustration Purposes

FIG. 14

PENDANT ARM**286940061**

ITEM	QTY	RW PART #	RW PART DESCRIPTION
1	4	686012882	Socket Head Cap Screw M10 x 40mm
2	1	783010048	Pendant Arm Swivel Mount
3	2	686012747	Socket Head Cap Screw M12 x 20mm
4	1	786080612	Lower Pivot Bushing
5	1	786080611	Upper Pivot Bushing
6	1	786030699	Pendant Arm Weldment
7	2	786830605	Nylon Washer
8	1	786830606	Steel Washer
9	1	689000310	Star Lock Washer
10	1	689000310	Spanner Nut

SECTION 2:

**ELECTRICAL
AND CONTROLS**

CINCINNATI PRECISION MACHINERY 513-860-4133

CINCINNATI PRECISION MACHINERY 513-860-4133

ELECTRICAL AND CONTROLS – AB1014

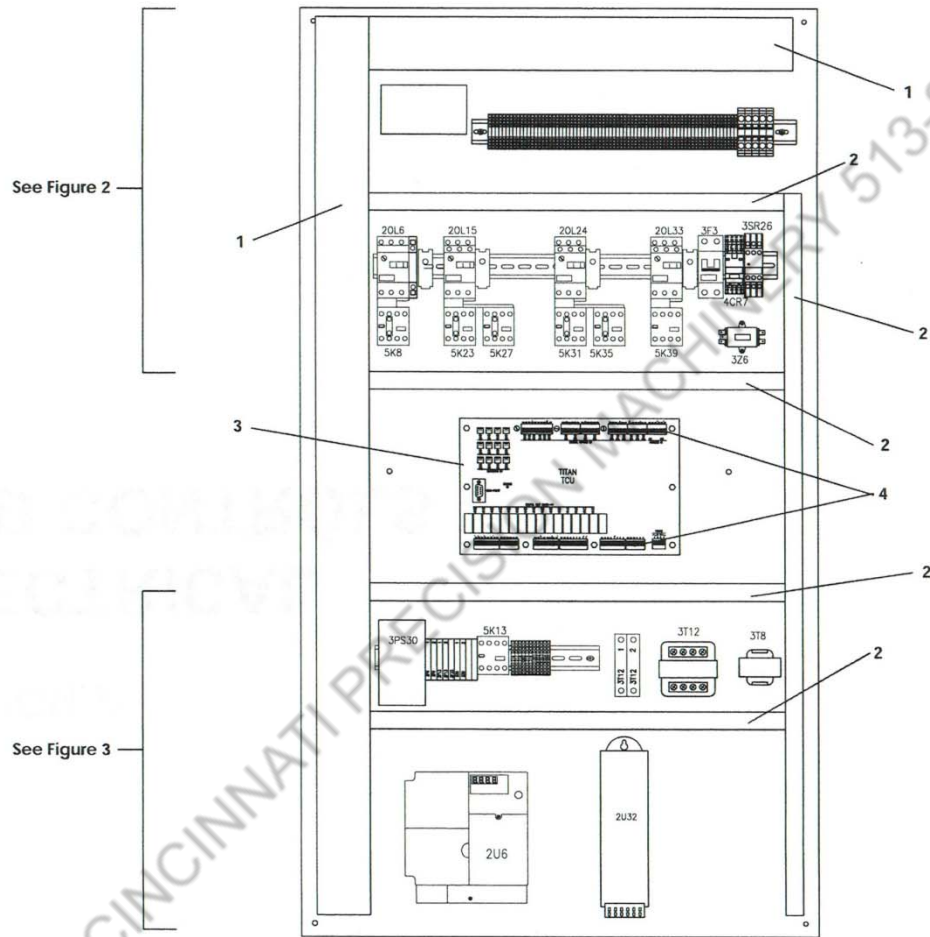


FIG. 1

ELECTRICAL PANEL TABLE 1

ITEM	QTY	RW PART #	RW PART DESCRIPTION
1	6 ft.	660182998	Wireway with Cover 3" x 3"
2	11 ft.	660182957	Wireway with Cover 1" x 3"
3	1	660233520	Titan Control Unit
4	1 set	660000544	Titan Control Unit Terminal Blocks

CINCINNATI PRECISION MACHINERY 513-860-4133

ELECTRICAL AND CONTROLS – AB1014

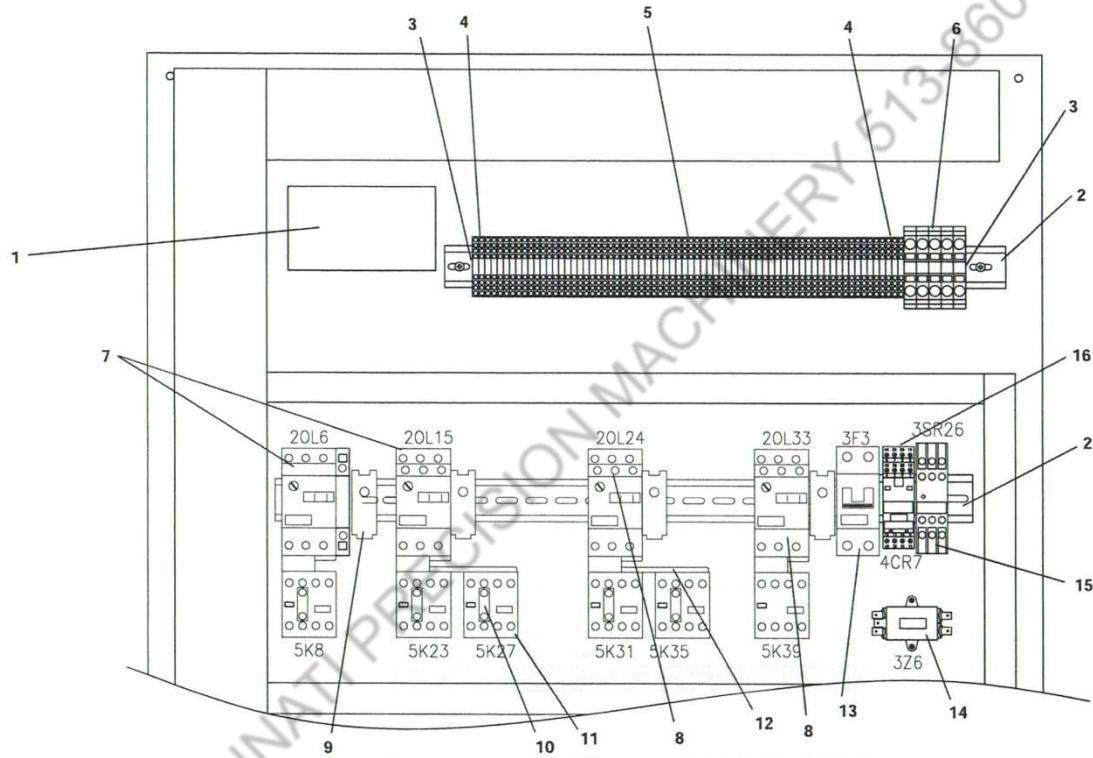


FIG. 2

ELECTRICAL PANEL TABLE 2

ITEM	QTY	RW PART #	RW PART DESCRIPTION
1	1	660051769	Power Distribution Block
1A	1	660051770	Power Distribution Block Cover
2	2	660000347	Din Rail
3	8	660000561	End Cover
4	9	660000562	Ground Blocks
5	49	660000559	Terminal Block M2.5/5
5A	49	660000563	Terminal Label
6	3	660000560	Terminal Block M4/6
6A	3	660000564	Terminal Label RC610
7	2	660041603	Overload
8	2	660041604	Overload
9	4	660000478	RC Filter
10	5	660021356	Aux Contactors NC
11	6	660021292	Contactors
12	2	660021354	Reverse Wire Kit
13	1	660041606	Circuit Breaker 10A DP
14	1	660000396	Filter
15	1	660142628	Safety Relay
16	1	660142563	Relay DPDT

ELECTRICAL AND CONTROLS – AB1014

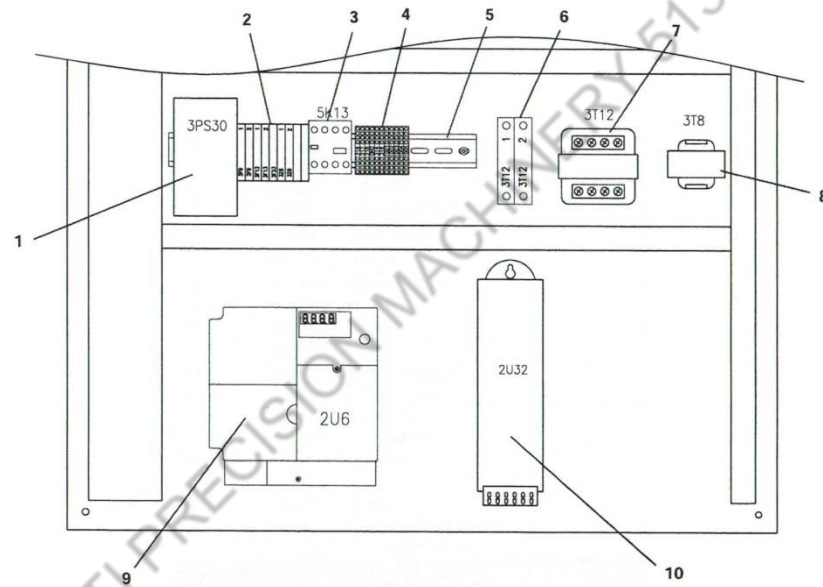


FIG. 3

CINCINNATI PRECISION MACHINERY 513-860-4133

ELECTRICAL PANEL TABLE 3

ITEM	QTY	RW PART #	RW PART DESCRIPTION
1	1	660132506	Power Supply 24VDC
2A	7	660000567	Fuse Holders
2B	1	660000568	Fuse Block Cover
2C	2	660051765	Fuse 3.15A
3	1	660021292	Contactator
4	10	660000559	Terminal Block M2.5/5
5	1	660000347	Din Rail
6A	1	660051766	Fuse Holder 2 Pole
6B	2	660051760	Fuse 1 Amp
7	1	660132503	Transformer 24VAC
8	1	660132504	Transformer 10VAC
9	1	660011234	VSD 5HP
10	1	660011296	Servostar 300 Backgauge Drive

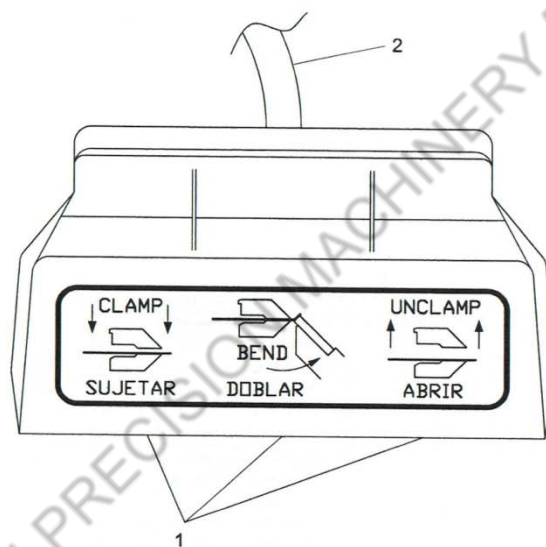


FIG. 4

CINCINNATI PRECISION MACHINERY 513-860-4133

3-PEDAL FOOT SWITCH**P/N: 660092123**

ITEM	QTY	RW PART #	RW PART DESCRIPTION
1	3	660092127	Replacement Switch
2	1	660000329	Foot Switch Cable Note: Always machine length plus 6 ft.

CINCINNATI PRECISION MACHINERY 513-860-4133

CINCINNATI PRECISION MACHINERY 513-860-4133

SECTION 3:

BACKGAUGE

CINCINNATI PRECISION MACHINERY 513-860-4133

BACKGAUGE – AB1014T2

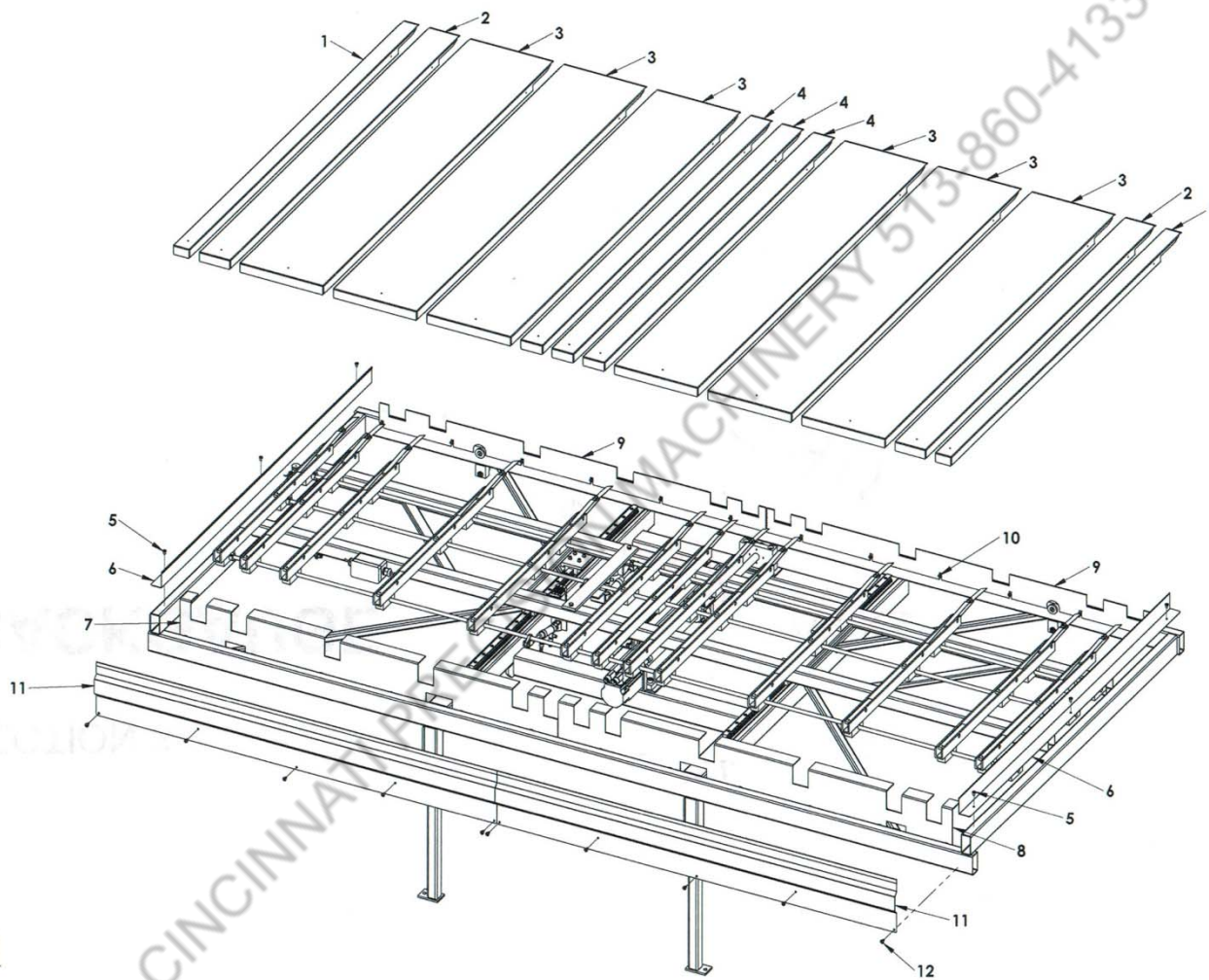


FIG. 1

COVERS AND GUARDS

ITEM	QTY	RW PART #	RW PART DESCRIPTION
1	2	786220566	B.G. Cover – 2 ½" Wide
2	2	786220563	B.G. Cover – 4 ¾" Wide
3	6	786220565	B.G. Cover – 12 ¾" Wide
4	3	786220564	B.G. Cover – 3 3/8" Wide
5	6	686012732	Phillips Head Pan Screw M6 x 10mm
6	2	786220572	Carriage Shield
7	1	786220567	Left Rear Backgauge Cover Support
8	1	786220568	Right Rear Backgauge Cover Support
9	2	786220571	Front Backgauge Cover Support
10	12	686012732	Phillips Head Pan Screw M6 x 10mm
11	2	786220656	Rear Backgauge Guard Half
12	10	686012732	Phillips Head Pan Screw M6 x 10mm

BACKGAUGE – AB1014T2

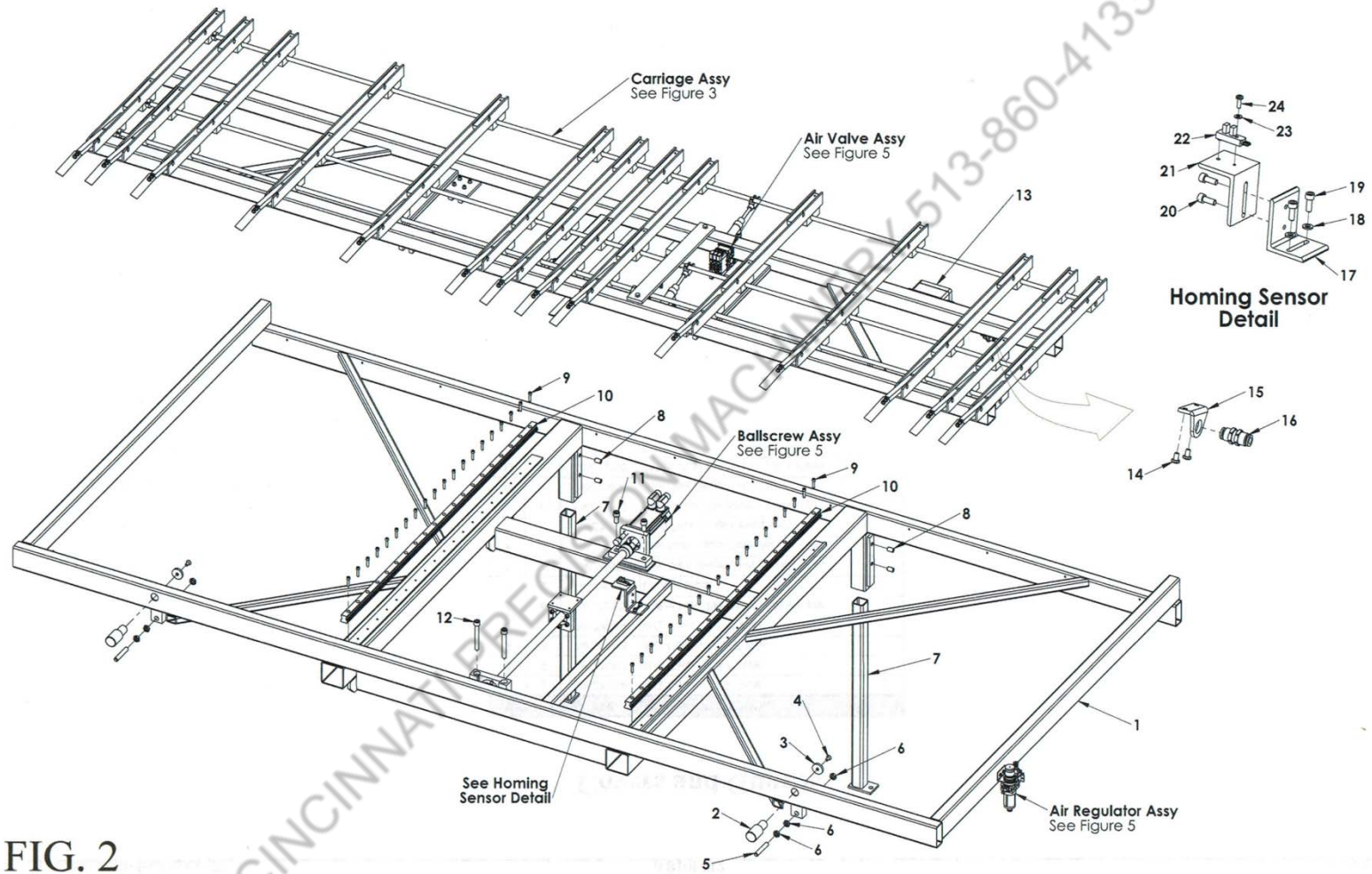


FIG. 2

BACKGAUGE ASSEMBLY

ITEM	QTY	RW PART #	RW PART DESCRIPTION
1	1	786140551	Backgauge Frame
2	2	786160586	Backgauge Alignment Pin
3	2	786160587	Backgauge Alignment Pin Washer
4	2	686012767	Flat Head Socket Screw M8 x 16mm
5	2	686212885	Socket Set Cup Point Screw M12 x 100mm
6	6	686023072	Jam Nut M12
7	2	786940586	Backgauge Leg
8	4	686012672	Low Socket Head Cap Screw M12 x 20mm
9	40	686012725	Socket Head Cap Screw M6 x 25mm
10	2	689450285	Linear Way (with plugs)
11	2	686012827	Socket Head Cap Screw M12 x 25mm
12	2	686012720	Socket Head Cap Screw M12 x 90mm
13	1	660102209	Terminal Box
14	2	686012732	Phillips Head Screw M6 x 10mm
15	1	669203813	Straight Coupler Mount
16	1	669224138	Bulkhead Coupling with Hex Nuts
17	1	786200561	Lower Homing Switch Bracket
18	2	686033173	Flat Washer 6mm
19	2	686012847	Hex Head Cap Screw M6 x 20mm
20	2	686012847	Hex Head Cap Screw M6 x 20mm
21	1	786200562	Upper Homing Switch Bracket
22	1	660233459	Optical Sensor
23	1	686033177	Flat Washer 4mm
24	1	686012724	Slotted Pan Head Screw M4 x 12mm

BACKGAUGE – AB1014T2

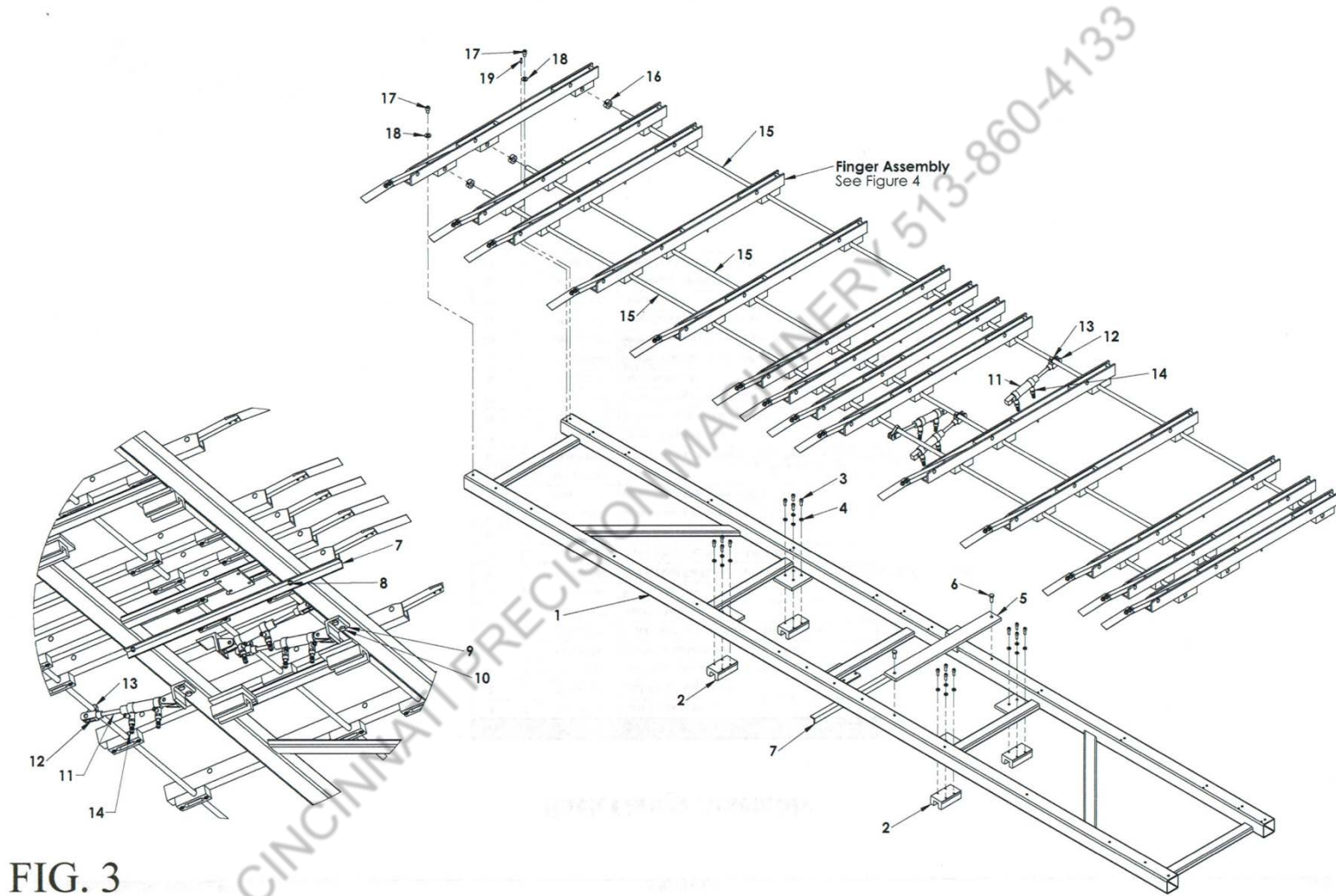


FIG. 3

CARRIAGE ASSEMBLY

ITEM	QTY	RW PART #	RW PART DESCRIPTION
1	1	786140550	Carriage Frame
2	4	689080286	Linear Way Slide
3	16	686012847	Hex Head Cap Screw M6 x 20mm
4	16	686033173	Flat Washer 6mm
5	1	786200577	Cylinder Mount Bracket
6	2	686012770	Hex Head Screw M8 x 20mm
7	1	786130574	Backgauge Home Switch Flag
8	2	686012711	Socket Head Cap Screw M5 x 10mm
9	2	786200651	Cylinder Mounting Bracket
10	4	686012770	Hex Head Screw M8 x 20mm
11	3	669214016	Air Cylinder
12	3	669203823	Short Clevis
13	3	786210579	Linkage Cam
14	6	669224143	Elbow Coupling 4mm
15	3	786030631	Backgauge Finger Guide Rod
16	6	686164344	Locking Collar ½”
17	28	686012669	Socket Head Cap Screw M8 x 12mm
18	28	686033175	Flat Washer 8mm
19	14	664063508	Roll Pin M5 x 28mm

BACKGAUGE – AB1014T2

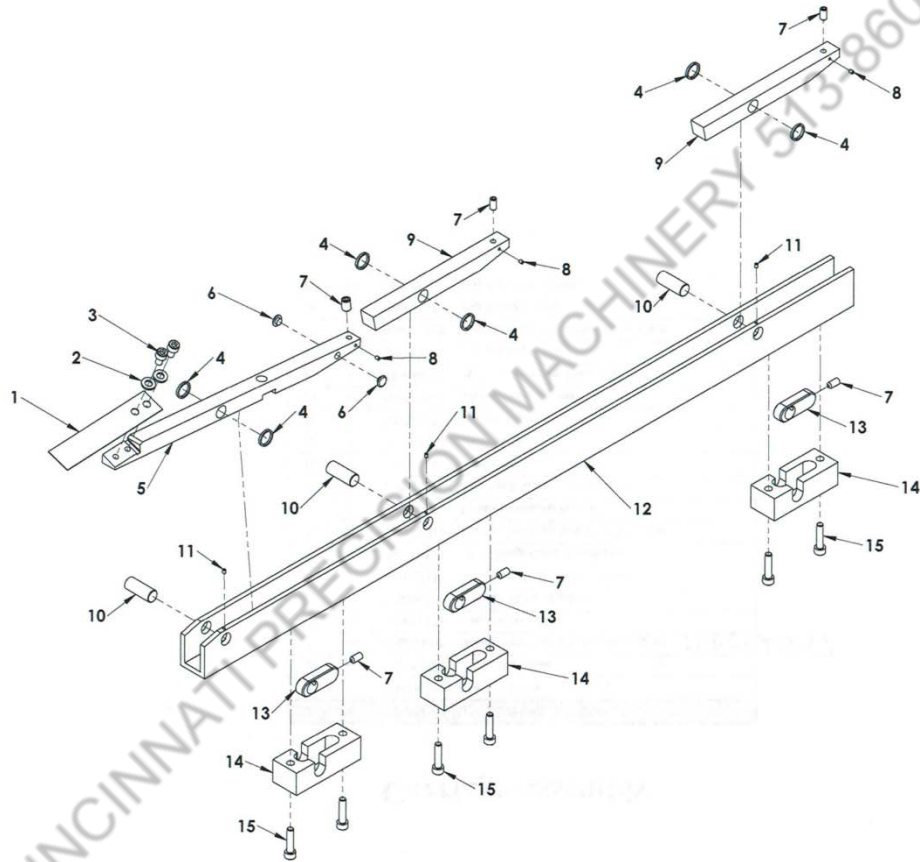
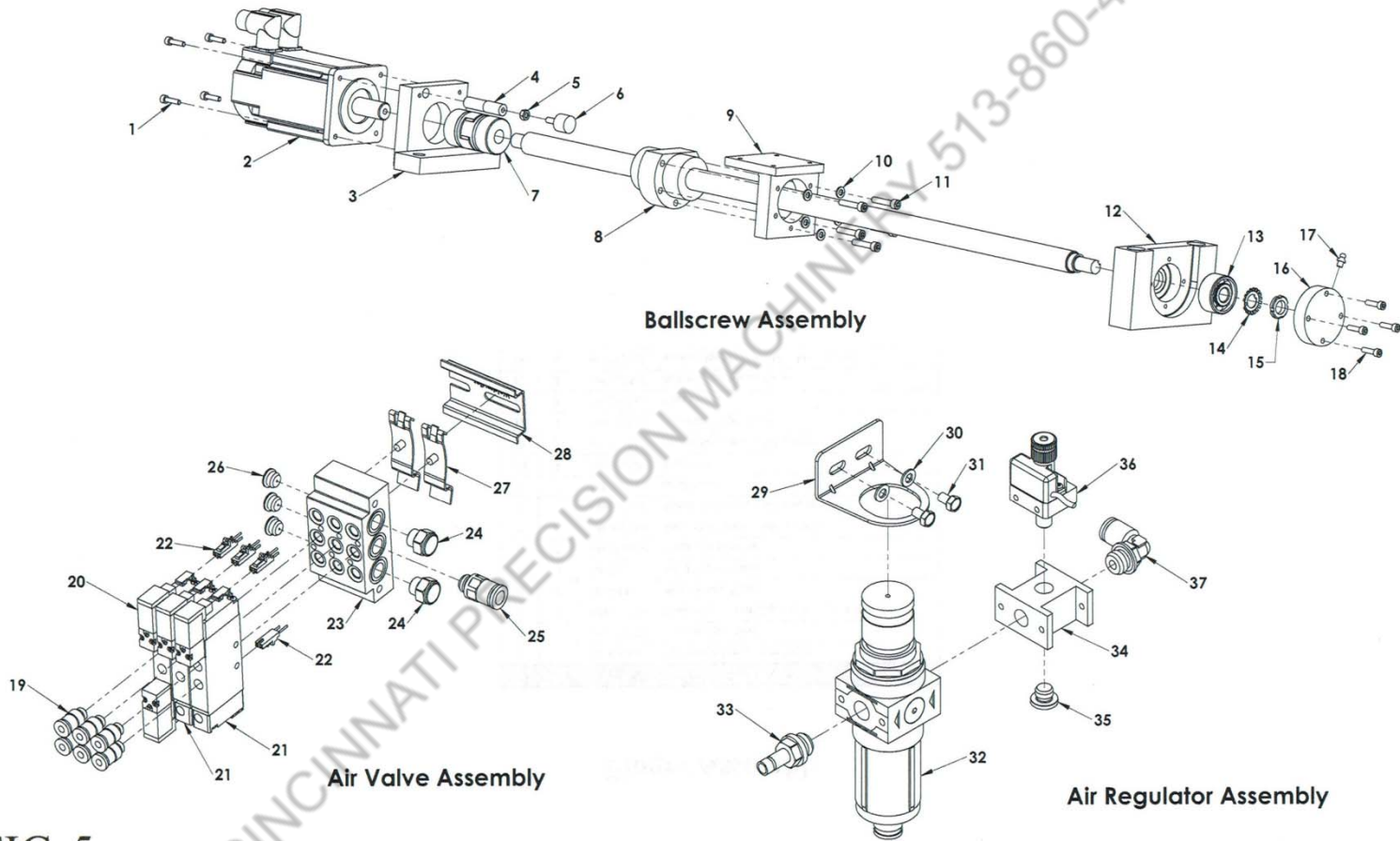


FIG. 4

FINGER ASSEMBLY

ITEM	QTY	RW PART #	RW PART DESCRIPTION
1	1	686000665	Backgauge Spring Steel Finger
2	2	686033173	Flat Washer 6mm
3	2	686012725	Socket Low Head Cap Screw M6 x 10mm
4	6	686033211	Block Plastic Washer
5	1	786360833	Front Finger Holder
6	2	686000674	Nylon Snap-In Plug
7	6	686012761	Socket Set Screw M6 x 12mm
8	3	686012759	Socket Set Screw M3 x 4mm
9	2	786360545	Solid Finger
10	3	786160549	Finger Pin
11	3	686012759	Socket Set Screw M3 x 4mm
12	1	786010547	Aluminum Finger Guide
13	3	786210548	Finger Cam
14	3	686133511	Nylon Finger Mount Block
15	6	686012725	Socket Head Cap Screw M6 x 25mm

BACKGAUGE – AB1014T2



MISC. COMPONENTS

ITEM	QTY	RW PART #	RW PART DESCRIPTION	ITEM	QTY	RW PART #	RW PART DESCRIPTION
1	4	686012719	Socket Head Cap Screw M5 x 20mm	19	6	669224139	Coupling 4mm
2	1	660011297	Backgauge Servo Motor	20	1	669274820	Valve 5/2 E-E
3	1	786200645	Servo Motor Mount	21	2	669274819	Valve 5/2 E-S
4	1	786630652	Backgauge Travel Stop Spacer	22	4	669203826	Plug In Connector
5	1	686023064	Hex Jam Nut M6	23	1	669203825	Manifold Base
6	1	686000661	Bumper	24	2	669224141	Silencer
7	1	686386631	Coupler	25	1	669224142	Coupler 8mm
8	1	686396665	Ball Screw and Nut	26	3	669224140	Plug
9	1	786200553	Backgauge Drive Bracket	27	2	669203827	Din Rail Clip
10	5	686033175	Flat Washer M6	28	1	660000346	Din Rail
11	5	686012721	Socket Head Cap Screw M6 x 30mm	29	1	669203824	Air Regulator Mount with Hex Nut
12	1	786200582	Front Ball Screw Mount	30	2	686033173	Flat Washer 6mm
13	1	686204744	Bearing	31	2	686012707	Hex Head Cap Screw M5 x 8mm
14	1	686033208	Lock Washer 15mm	32	1	669234412	Air Regulator
15	1	686023084	Lock Nut M15	33	1	N/A	Air Line Connector (Not Supplied by R.W.)
16	1	786260583	Bearing Retainer	34	1	669102733	Mount Kit
17	1	686000657	Straight Grease Zerk 6mm	35	1	669224140	Plug
18	4	686012719	Socket Head Cap Screw M5 x 20mm	36	1	669102732	Pressure Switch
				37	1	669224137	90 Degree Elbow
				N/A	1	669254605	Pressure Gauge 0-10 Bar, 0-160 PSI