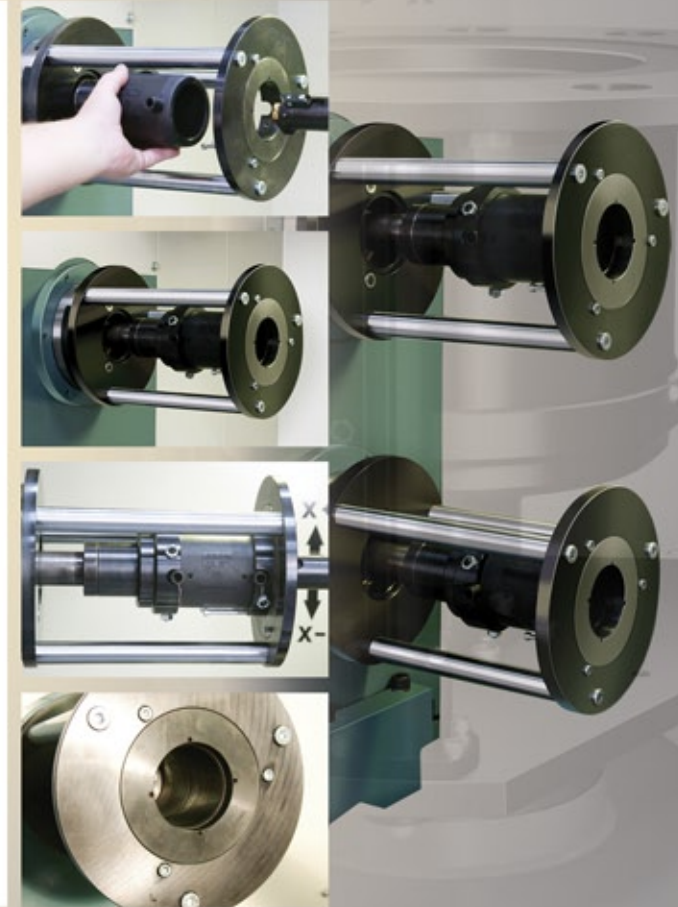


# TYPICAL OPERATING SEQUENCE



Described below is the **typical operating sequence** of a standard wire laying machine. This is based on single wire laying, but double wire laying is also available.

- ONE** The fitting is manually loaded into the machine fixture. Doors close and the part is clamped under high pressure.
- TWO** The boring cycle starts, moving the boring bar into the fitting at high speed to bore the inside diameter to size. Doors open and swarf is manually removed. Doors close and the machine is programmed to orientate the part and stop the wire laying tool at the first termination hole in the fitting.
- THREE** Doors open and the wire is manually hooked through the first terminal hole in the fittings. Doors close.
- FOUR** The wire laying part of the program is then run, typically laying the first fusion zone, cold zone and second fusion zone.
- FIVE** The wire laying tool positions next to the second termination hole in the fitting.
- SIX** Doors open, the wire is manually pulled through the second termination hole in the fitting and is trimmed. Doors close.
- SEVEN** The boring bar advances and finish bores the fitting at high speed to remove excess material.
- EIGHT** The tool moves to a pre-set waiting position. Machine doors open for manual removal of the fitting.
- NINE** The machine is ready for the next fitting to be loaded and the operating sequence repeated.



PROCESS & EQUIPMENT PROTECTED BY PATENTS: EP1042108 | E215874 | P19813732-8 | 2,312,374 | ZL98812630.3 | 215588 | 136,935 | 2000-526336 | 10-0616469 | 220759 | P341526 | E52173657T3 | 04/2320 | US 6,530,139 B1 | US 6,751,840 B2 | US 7,069,637 B2 | PCT/GB2008/050487 | 08290385 | 57411 | P4527278



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