

- (一) Machine origin : A vibrating pay-off machine switch on , B shift piston at rear position , D vacuum sucker not work , C swing vat let vacuum sucker D stop at vertical position 。 E inject vat at top position , F vat of return material at low position , G conveyer stop , H 、 I straight in rotating vat at low position 。
- (二) Manual function : to make sure the capability of control panel can activate each actuator A~I 。

(三) Automatic function :

1. To put round parts in vibrating pay-off machine arbitrarily , vibrating pay-off machine pushing round parts up in whirls , the one with gap toward top will pass examination to be moved to slop , the others will drop back vibrating pay-off machine .
2. C swing vat turning clockwise to slop , D vacuum sucker sucking part , C swing vat turning counterclockwise to inspecting seat , D vacuum sucker putting down part , C swing vat turning clockwise back to vertical position .
3. E inspect vat moving to push part downward , sensor reporting suitable pressure then stop , using photoelectric sensor to get stop position , to judge if the outer diameter qualified or not , F vat of return material moving up , potential meter measuring voltage at the top of round part , via A/D convertor , to check the height of round part qualified or not , E inspect vat moving up .
4. C swing vat turning counterclockwise to inspecting seat , vacuum sucker sucking part , C swing vat turning clockwise back to vertical position , F vat of return material moving down , B shift piston moving at front position , C swing vat turning clockwise to conveyer , vacuum sucker putting down part , C swing vat turning clockwise back to vertical position , B shift piston at rear position .
5. As S12 on, conveyer turning , moving part to the front of H straight in rotating vat , if outer diameter not qualify , H straight in rotating vat will reject part at first outlet slop , then moving part to the front of I straight in rotating vat , if height not qualify , I straight in rotating vat will reject part at second outlet slop , qualify parts moving to the end of conveyer .