

**INSTRUCTION
MANUAL**

**ASR1-A
AIR SOLENOID**

Spring Gaging Systems
from
LARSON SYSTEMS

Installing an Air Solenoid for Sorting

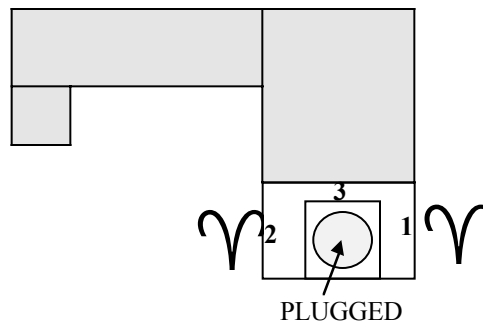
The ASR1-A is available in two versions: P/N B014-0520 for standard 115VAC and B014-0521 for 24VAC (European). The 24VAC version has a tag by the connector marking it as 24VAC.

The ASR1-A blows out all bad springs, short or long, in the same direction. This is the most common method of sorting by air.

Air solenoids can be configured to blow only on reject or to blow continuously and stop only on reject.

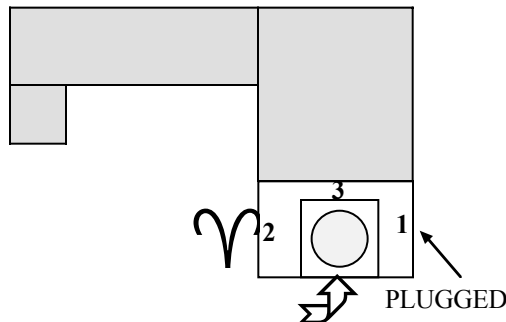
To Blow on Reject Only

1. Input air supply to inlet '1'.
2. Place plug in inlet '3'.
3. Position a line from outlet '2' to blow out bad springs.
4. Adjust Sort Time on the gage.



To Blow Continuously Except on Reject

1. Input air supply to inlet '3'.
2. Place plug in inlet '1'.
3. Position a line from outlet '2' to blow out good springs.
4. Adjust Sort Time on the gage.



The air solenoid can be mounted to blow right at the tooling or at another location where the spring will be passing as it falls after cutoff. Forming a nozzle that spreads the air blast over an area will decrease the possibility of missing a spring.

Caution must be used when blowing at the tooling. If the air continues to blow well into the coiling process *some* springs can be deformed. Blowing on the spring when the gage is reading the length can give an inaccurate reading if the spring end is pushed away from the probe tip. These considerations depend on the air pressure in the solenoids and wire type.