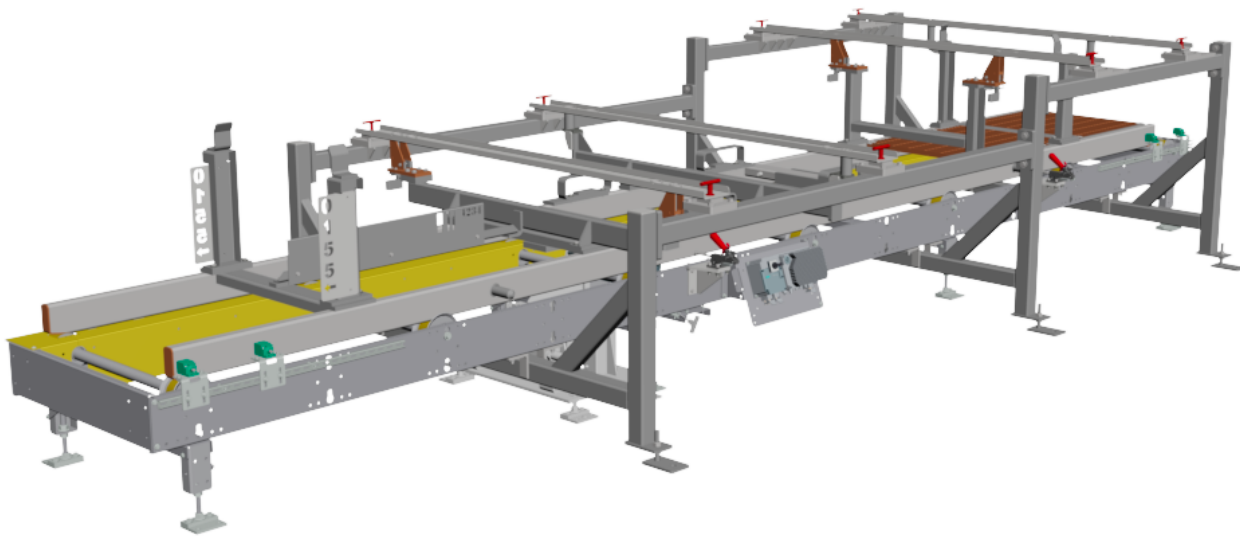
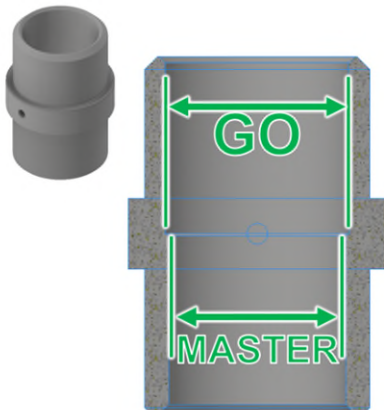


PTED SKID MASTERING



▲ Checking Station with Skid and Power Roll Bed



▲ GO/MASTERING Gauge



▲ T-Pin

A GO/MASTERING gauge is a type of inspection and alignment tool used to both verify and set critical dimensions or locations for PTED skids in a checking station.

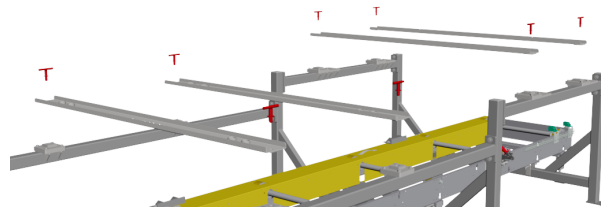
GO Gauge:

- Larger opening
- Used during initial check
- Confirms if the pin location is within acceptable limits
- If it “goes” (passes the check), then no mastering is needed

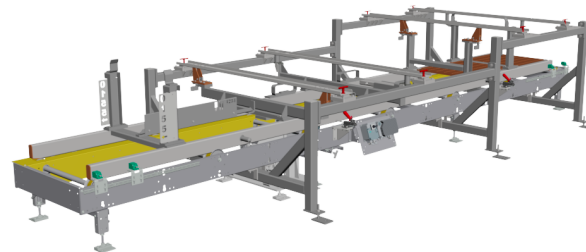
MASTERING Gauge:

- Smaller opening
- Used when adjustments are needed
- Holds the piece in a precise position for tack welding

- 1 Remove the T-Pins (x8) and the Drop cross-members (x4) from the checking station.

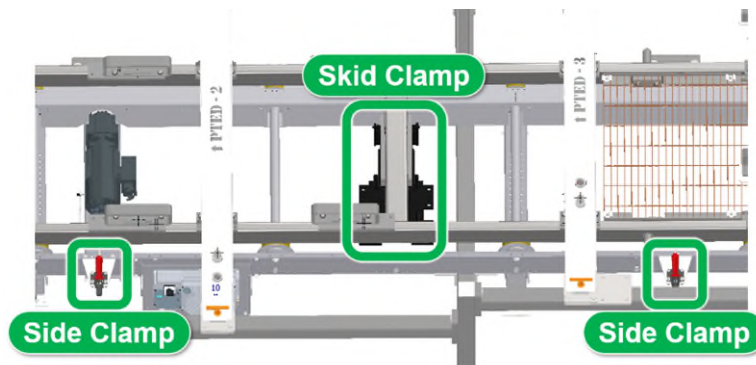


- 2 Move the Skid onto the checking station's Power Roll Bed.

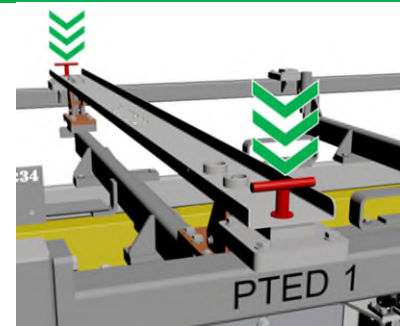


Engage the Skid Positioning Clamp (x1), then the Side Positioning Clamps (x2).

- 3

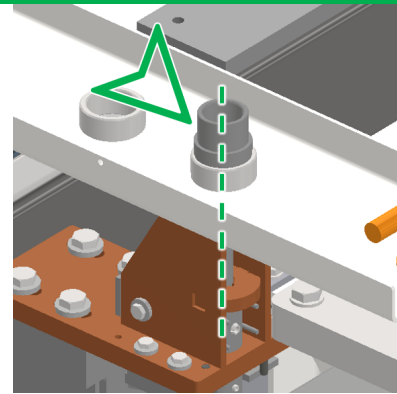


- 4 Position the Drop cross-member on location **PTED 1** and insert two T- Pins to secure it to the checking station.



Insert the GO GAUGE into the Drop's alignment hole to check pin location.

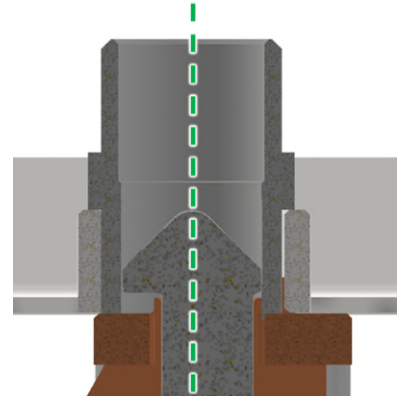
- 5** If pin passes Go Gauge: skip to **Step 8**.
 If pin does not pass Go Gauge: continue to **Step 6**.



Loosen Skid details and adjust as required.

- 6** Insert MASTERING GAUGE into Drop's alignment hole to hold pin in new position.

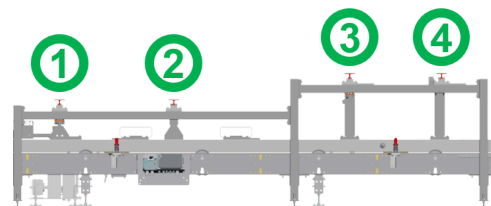
Note: Do NOT use GO GAUGE for step 6, be sure to only use the MASTERING GAUGE.



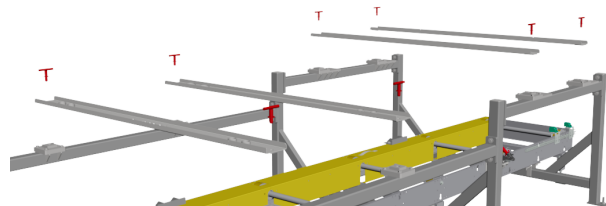
- 7** Once positioned using the MASTERING GAUGE, tack weld the skid details in place.
 Return the GO/MASTERING GAUGE to its storage location.



- 8** Repeat steps 4-7 using locations **PTED 2, 3, & 4**.



- 9** Remove the T-Pins (x8) and the Drop cross-members (x4) from the checking station before removing the skid.



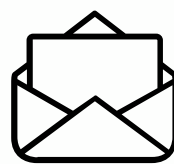
FATA

AUTOMATION

***Do You Have Service Questions
or Need Spare Parts?***



(248) 724-7660



**service@fatainc.com
spareparts@fatainc.com**

**2333 E Walton Blvd. Auburn Hills, MI 48326
www.fataautomation.com**