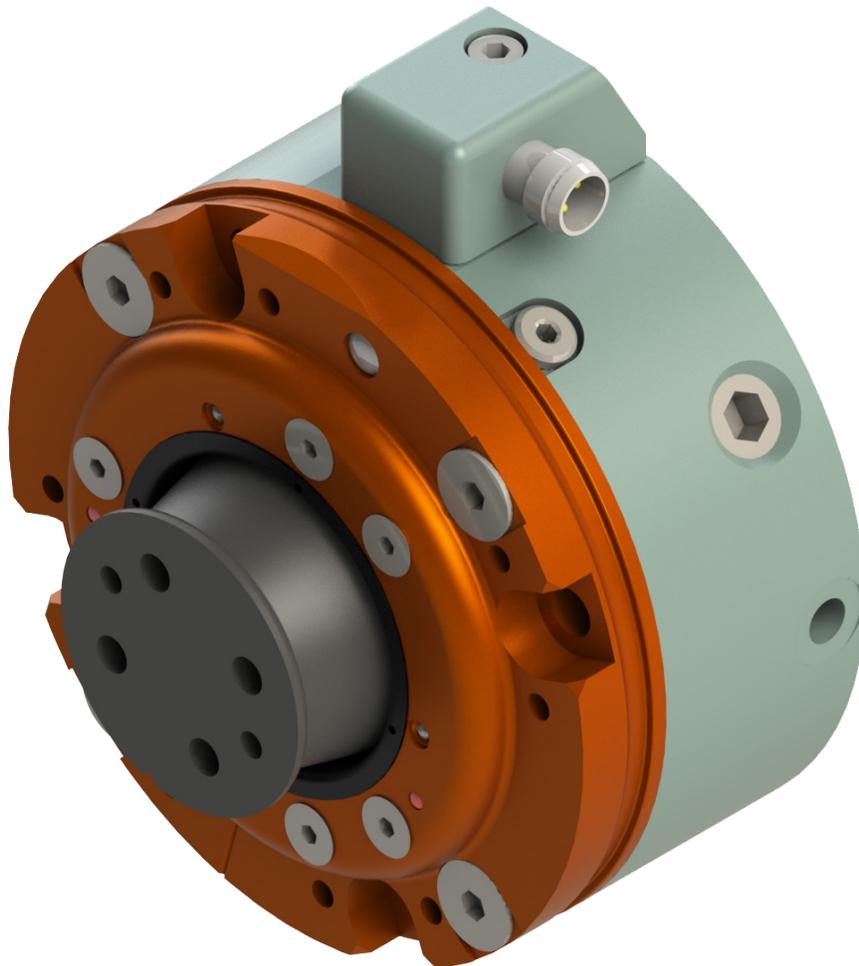




**Robotic Collision Sensor  
SR-81 and SR-101  
Switch Replacement and Adjustment  
Manual**

U.S. Patent Nos. 6069415 and 6690208



**Document #: 9610-60-1010**

***Engineered Products for Robotic Productivity***

*Pinnacle Park • 1031 Goodworth Drive • Apex, NC 27539 • Tel: +1-919.772.0115 • Fax: +1-919.772.8259 • www.ati-ia.com*

## Foreword

Please contact ATI Industrial Automation with any questions concerning your particular model.



**CAUTION:** This manual describes the function, application and safety considerations of this product. This manual must be read and understood before any attempt is made to install or operate the product. Failure to read and understand the information in this manual may result in damage to equipment or injury to personnel.

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## How to Reach Us

Sale, Service and Information about ATI products:

**ATI Industrial Automation**

1031 Goodworth Drive

Apex, NC 27539 USA

[www.ati-ia.com](http://www.ati-ia.com)

Tel: 919.772.0115

Fax: 919.772.8259

**Application Engineering**

Tel: 919.772.0115

Fax: 919.772.8259

E-mail: [applicationsengineers@ati-ia.com](mailto:applicationsengineers@ati-ia.com)

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## Glossary

Term	Definition
8 mm Connector	8 mm electrical connector mounted in block attached to the side of the body.
Body	Cylindrical aluminum housing and air pressure chamber. An interface plate to the user's robot is usually attached here.
Cam	A hardened steel ring mounted inside the cover on which the hardened steel ball segments mounted to the stem are nested.
Collision Sensing Switch	A mechanical switch that changes state to an open circuit when a crash is detected. It is mounted in the center of the body.
Collision	The accidental impact between the end of arm tooling and some obstruction in its path.
Cover Plate	Disk-shaped aluminum cover for Collision Sensor body.
Crash	The result of a disturbance that displaces the Collision Sensor components from their standard, working position.
Interface Plate	Optional component used to adapt the Collision Sensor body or stem to the user's robot or tooling.
Piston	The component which, together with the body, creates a pressure chamber. Varying the pressure in this chamber varies the load required to move the piston.
Reset	The ability of the Collision Sensor to return to its working position when a disturbing force or displacement is removed.
Stem	Round tapered post containing tapped holes and a dowel pin hole. An interface plate to the user's tooling is usually attached here.

## 1. Safety

The safety section describes general safety guidelines to be followed with this product, explanation of the notifications found in this manual, and safety precautions that apply to the product. More specific notifications are imbedded within the sections of the manual where they apply.

### 1.1 Explanation of Notifications

The notifications included here are specific to the product(s) covered by this manual. It is expected that the user heed all notifications from the robot manufacturer and/or the manufacturers of other components used in the installation.



**DANGER:** Notification of information or instructions that if not followed will result in death or serious injury. The notification provides information about the nature of the hazardous situation, the consequences of not avoiding the hazard, and the method for avoiding the situation.



**WARNING:** Notification of information or instructions that if not followed could result in death or serious injury. The notification provides information about the nature of the hazardous situation, the consequences of not avoiding the hazard, and the method for avoiding the situation.



**CAUTION:** Notification of information or instructions that if not followed could result in moderate injury or will cause damage to equipment. The notification provides information about the nature of the hazardous situation, the consequences of not avoiding the hazard, and the method for avoiding the situation.

**NOTICE:** Notification of specific information or instructions about maintenance, operation, installation, or setup of the product that if not followed could result in damage to equipment. The notification can emphasize specific grease types, good operating practices, or maintenance tips.

### 1.2 General Safety Guidelines

The Collision Sensor is not designed for, nor should it be used in, situations involving the safety of humans or animals. The Collision Sensor is designed as a safety device to protect industrial components and machinery from damage resulting from collisions and impacts. In all situations the user is responsible for insuring that applicable safety practices are followed as outlined by the manufacturer of the equipment on which the Collision Sensor is used.

The routing of electrical and pneumatic lines must minimize the possibility of stress, pullout, kinking, rupture, etc. Failure of critical electrical and/or pneumatic lines to function properly may result in injury to personnel and damage to equipment.



**CAUTION:** The customer should lock out and discharge all energy to the work cell prior to working on any Collision Sensor system. Failure to do so may result in damage to equipment or injury to personnel.

### 1.3 Safety Precautions



**WARNING:** Do not perform maintenance or repair on the Collision Sensor with air pressure applied, current supplied to the sensor, or the robot not in a safe condition. Injury or equipment damage can occur if this is not observed. Always ensure that air pressure has been vented from the unit, that electrical current is not supplied to the Collision Sensor's signal circuit, and that the robot is in a safe, locked-out condition consistent with local and national safety standards before performing maintenance or repair on the Collision Sensor.

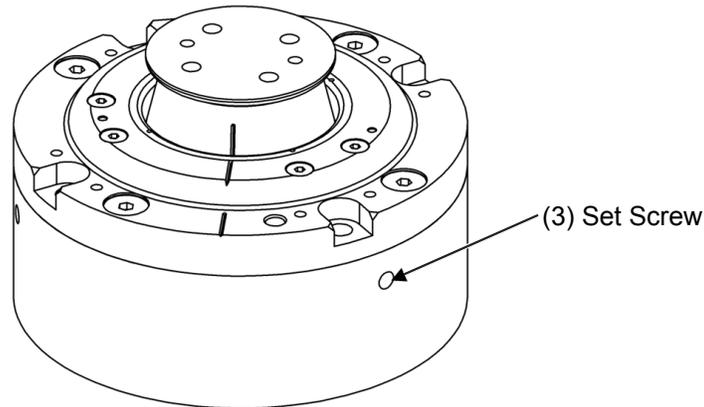


**WARNING:** The Collision Sensor is only to be used for intended applications and applications approved by the manufacturer. Using the Collision Sensor in applications other than intended will result in damage to Collision Sensor or end-of-arm tooling and could cause injury to personnel.



**CAUTION:** Do not adjust or remove either of the (3) set screws installed in the wall of the body. Doing so may result in damage to the unit or failure of the switch to operate. See [Figure 1.1](#).

Figure 1.1—Location of Set Screws



## 2. Switch Replacement

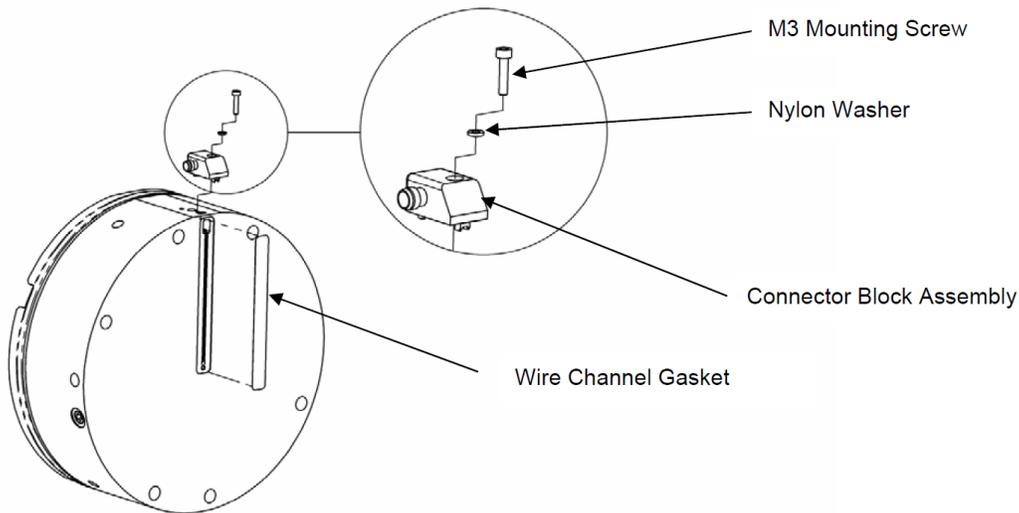
**Parts required:** ATI Tool (3810-60-1489), Switch kit (9160-SWITCHKIT-081 for the SR-81 or 9160-SWITCHKIT-101 for the SR-101)

**Tools required:** Allen wrenches (hex keys), Wire cutters, ATI Tool (3810-60-1489)

**Supplies required:** Loctite 222

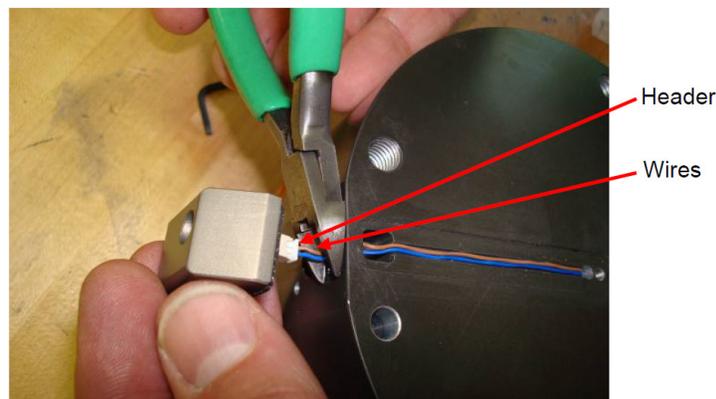
1. Remove the customer tooling from the Collision Sensor. Refer to 9610-60-1004 for procedure.
2. Remove the Collision Sensor from the robot. Refer to 9610-60-1004 for procedure.
3. Remove the M3 socket head cap screw and nylon washer that secure the connector block to the body using a 2.5 mm Allen wrench.
4. Remove the wire channel gasket.

**Figure 2.1—Removing the Connector Block**



5. Pull the connector block away from the Collision Sensor as shown in [Figure 2.1](#) and cut the wires as shown in [Figure 2.2](#).
6. Unplug the connector from PCB Header.
7. Remove the connector by cutting the wires and discard the connector.

**Figure 2.2—Remove the Connector**

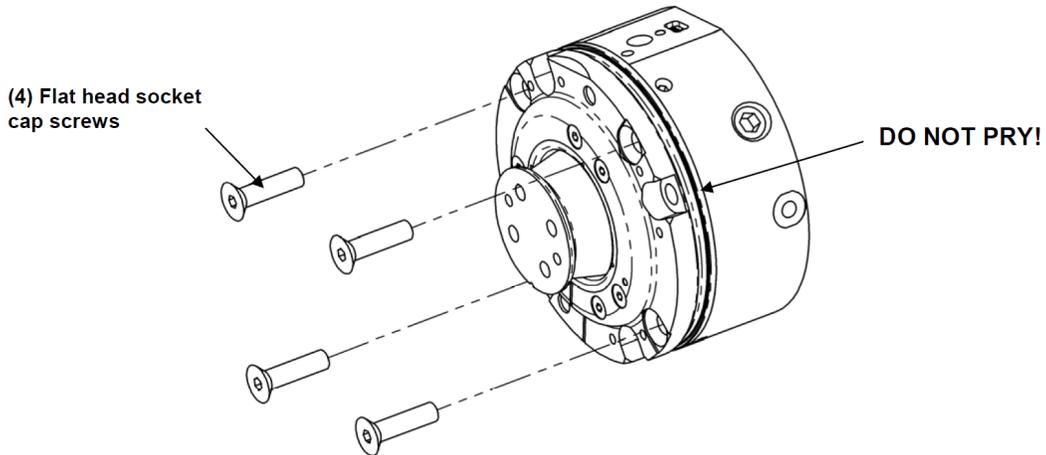


8. Remove the (4) screws that secure the cover plate assembly to the body.



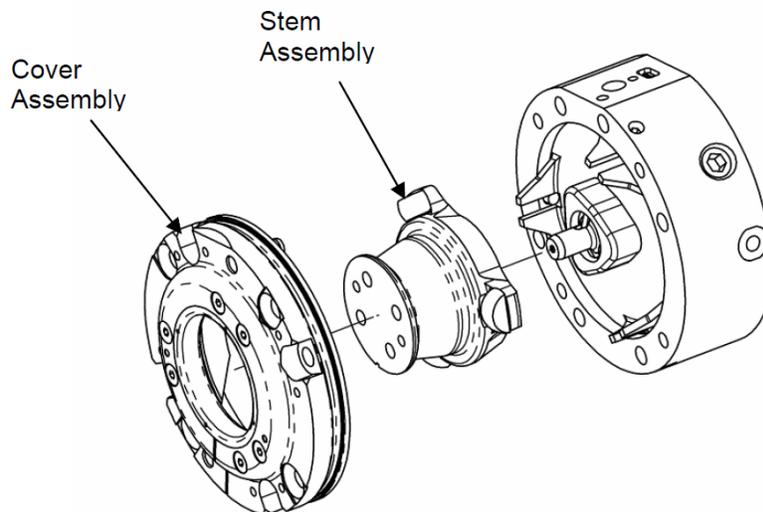
**CAUTION:** Do not attempt to pry or wedge the cover plate assembly and body apart. Doing so can damage the mating surfaces and may render the parts unusable.

**Figure 2.3—Removing the Cover Plate**



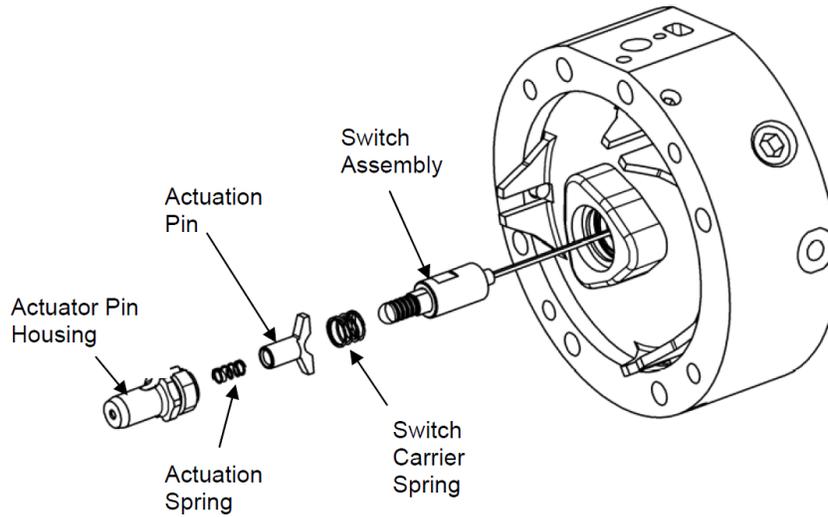
9. Remove the cover plate by carefully pulling it straight up and off of the body. This may be difficult due to the close fit of the dowel pins used to align the parts and the sealer used between the cover and body. It may be necessary to tap the cover with a rubber or plastic mallet.

**Figure 2.4— Removing the Cover and Stem Assembly**



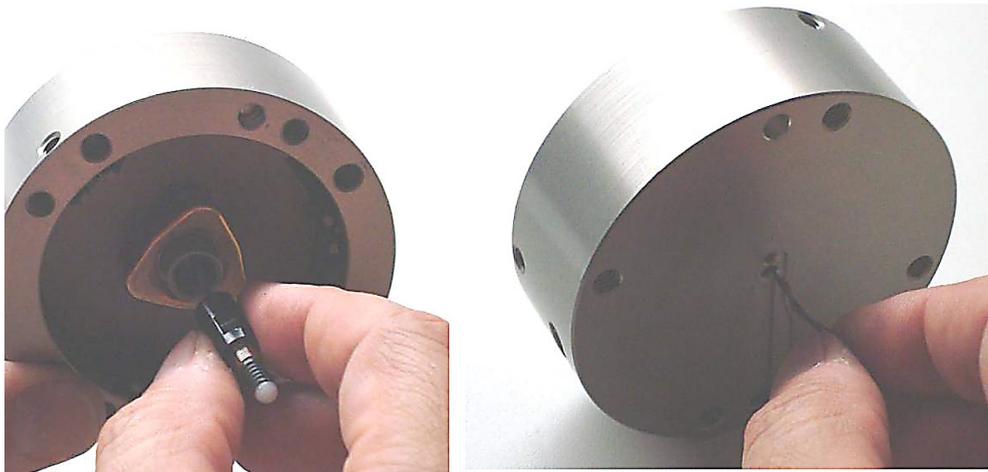
10. Remove actuator spring housing, actuation spring, actuation pin, switch carrier spring, and switch assembly. Discard parts.

**Figure 2.5—Removing the Switch**



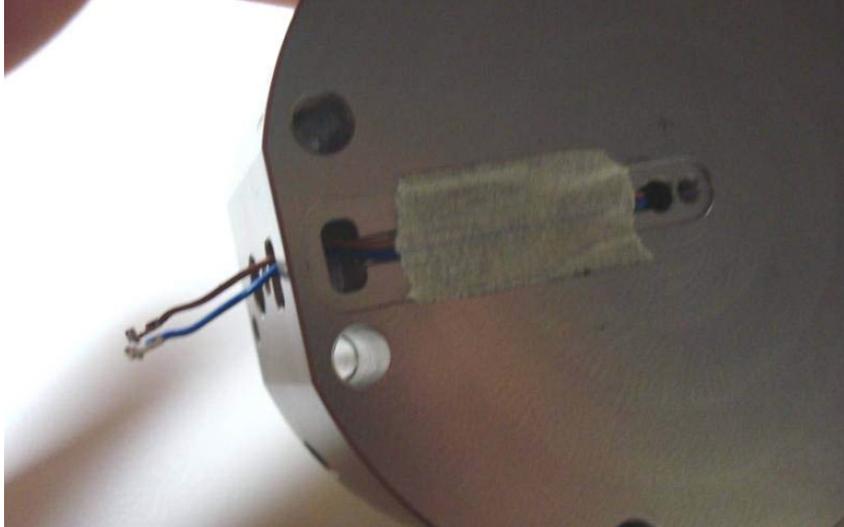
11. Insert the wires of the new switch assembly through the body post. Slide the switch assembly into position. Twisting the switch wires will simplify insertion of the wires into the body post.

**Figure 2.6—Installing the Switch**



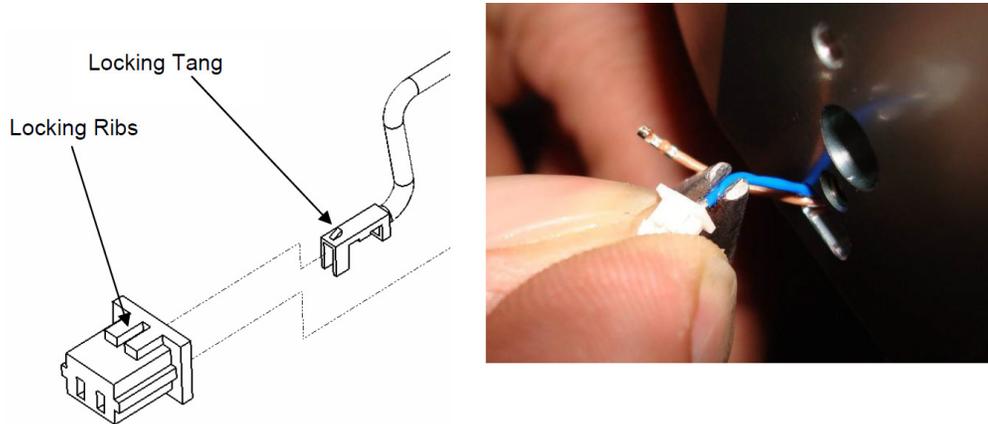
- Untwist the wires and feed them through the slot leading to the cavity on the side of the body.  
Ensure that the wires will lie side-by-side in the channel once the assembly has been completed.  
To prevent damage to the wires, temporarily apply masking tape to the channel once the wires are correctly positioned.

**Figure 2.7—Routing the Wires**



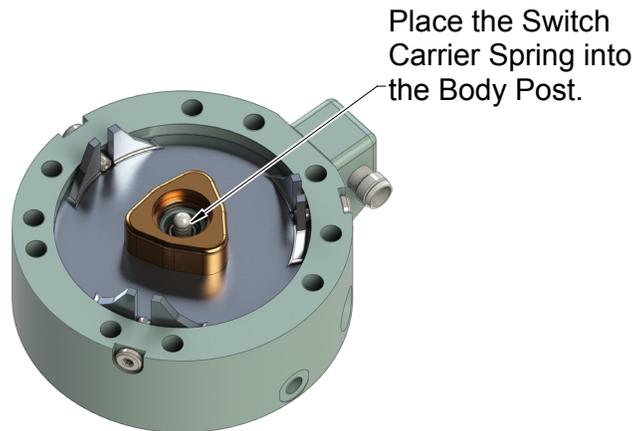
- Insert the wire connectors into the micro header socket with the locking tang of the wire connectors facing the locking ribs on the micro header socket. Grip each wire with needle-nose pliers just behind the wire connector and push it firmly into the micro header socket. Check to be sure that the wire connectors are locked into place and will not pull out accidentally.

**Figure 2.8—Inserting the Wire Connectors**



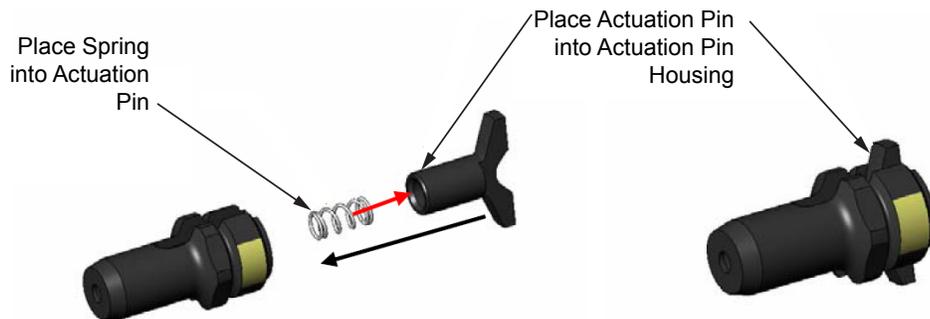
14. Place the switch carrier spring into the body post on top of the switch assembly.

**Figure 2.9—Installing the Switch Carrier Spring**



15. Place the spring into the actuation pin and then slide actuation pin into actuation pin housing.

**Figure 2.10—Inserting the Wire Connectors**



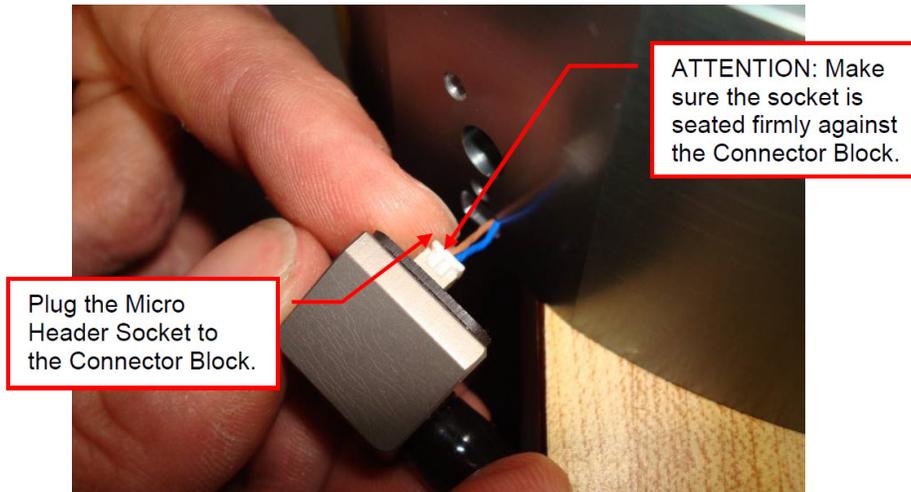
16. Screw the actuation pin housing into the body using tool 3810-60-1489 and tighten to 6 in-lbs (0.68 Nm).

**Figure 2.11—Installing the Switch Actuator**



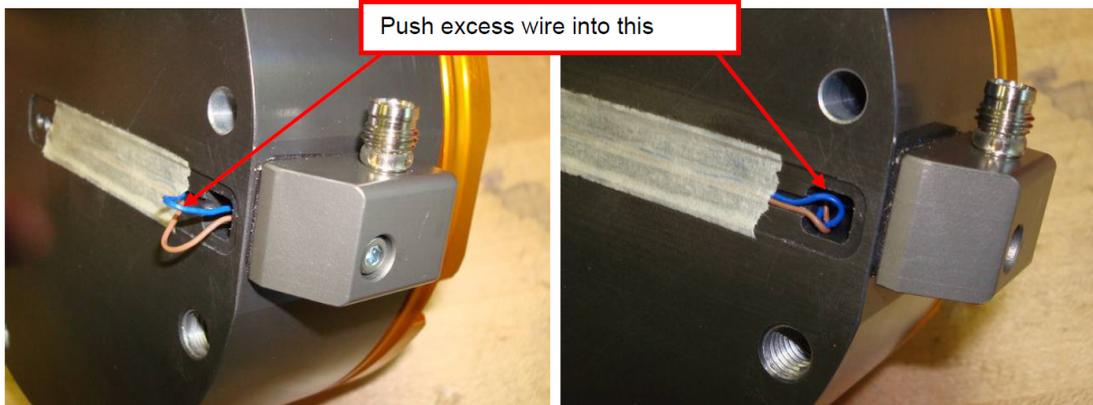
17. Plug the micro header socket into the pcb header in the connector block.

**Figure 2.12—Connecting the Connector Block**



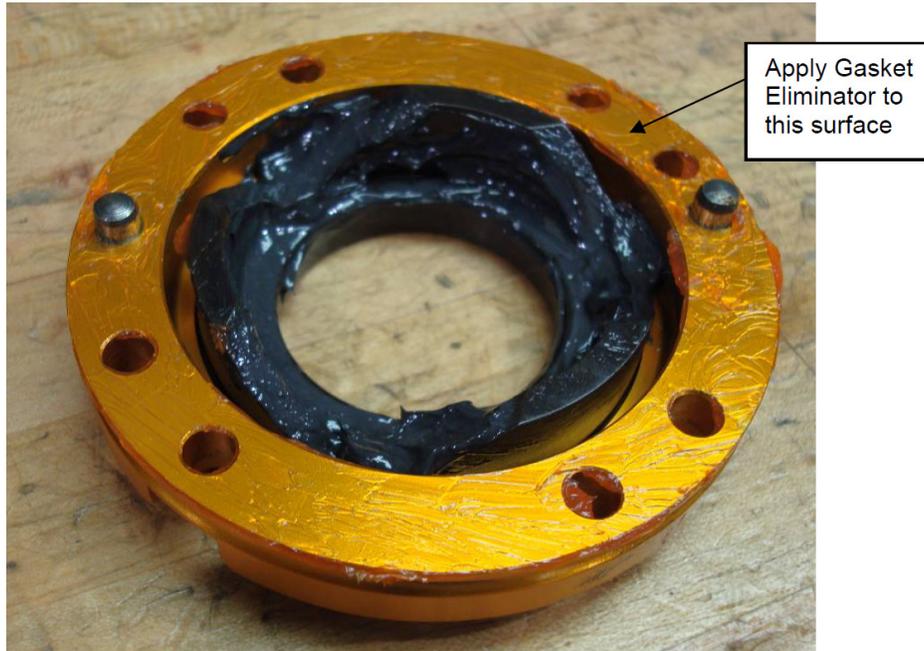
18. Place the nylon washer on M3. Apply Loctite 222 to the connector block's M3 mounting screw and thread it into the body and torque to 64 in-ozs (0.45 Nm). To avoid bunching of the wires in the channel, work any slack in the wires into the slot leading to the cavity on the side of the body.
19. To avoid bunching of the wires in the channel, work any slack in the wires into the body cavity indicated above.

**Figure 2.13—Stowing of Excess Wire**



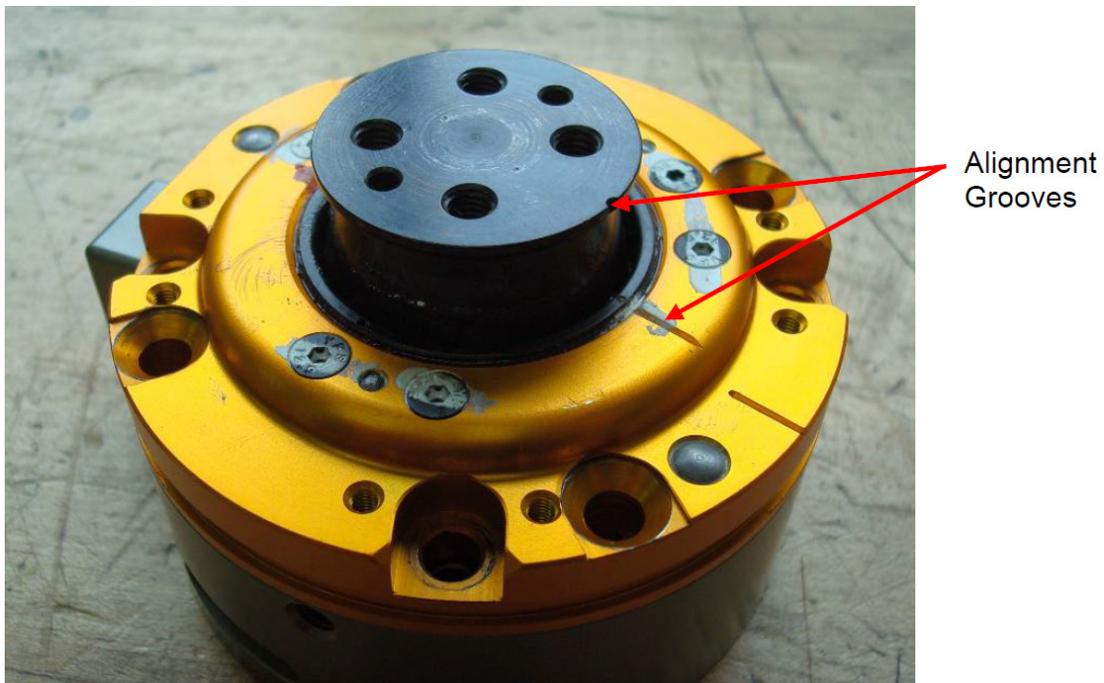
20. If the unit was equipped with a C1 or C5 style IP-65 sealing boot apply Loctite 548 Gasket Eliminator to the underside of the cover.

**Figure 2.14—Applying Gasket Eliminator**



21. With the stem assembly upright, set the cover plate assembly onto it. Make certain that the alignment grooves are properly aligned.

**Figure 2.15—Orientation of the Stem and Cover Plate**

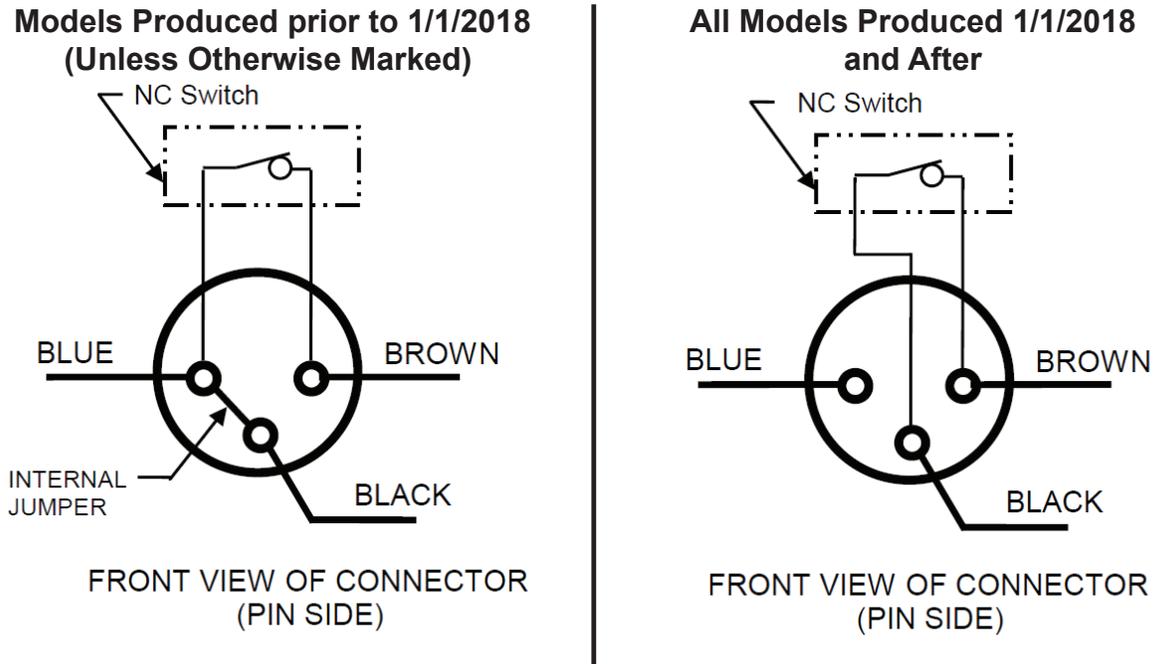


## 2.1 Switch Adjustment

**Tools required:** Allen wrenches (hex keys), Arbor press, Dial indicator

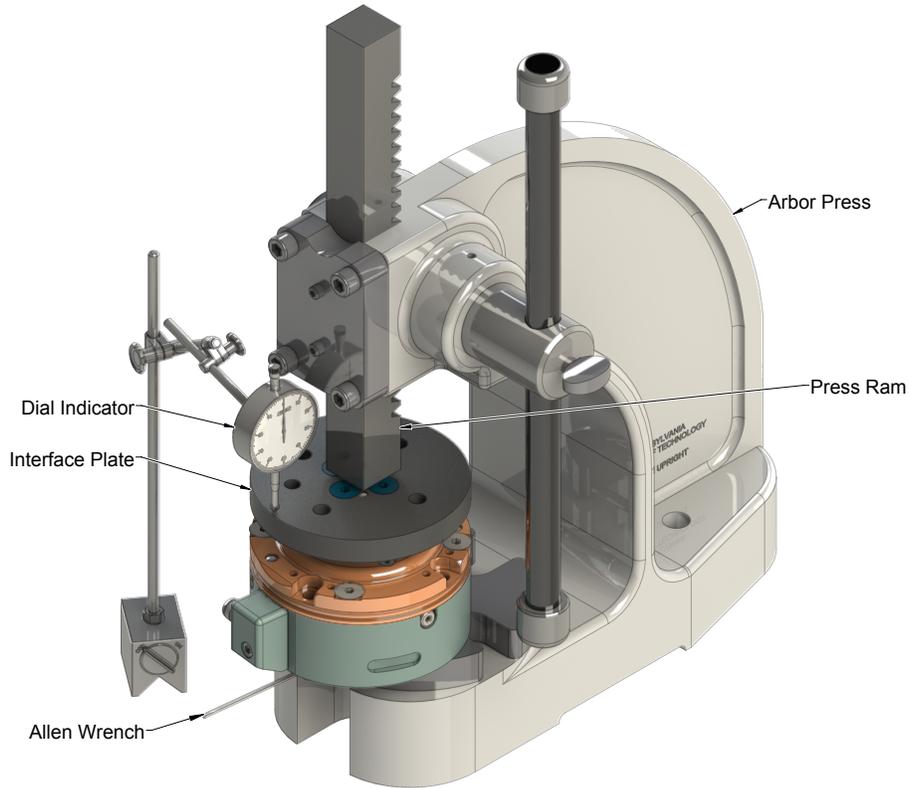
1. Provide 20 psi to the air supply port (not required if equipped with preload springs) and insure that the Collision Sensor returns to its reset or working position with the stem fully extended and the alignment mark on the stem in line with the alignment mark on the cover plate.
2. Set a volt-ohm meter to ohms or continuity and connect it between the black and brown wires of the cord (see [Figure 2.16](#)) connected to the 8 mm connector on the switch housing.

**Figure 2.16—Switch Wiring**



3. Attach an interface plate to the stem of the Collision Sensor.
4. Center the Collision Sensor under the press ram of an arbor press (see [Figure 2.17](#)).

**Figure 2.17—Checking the Switch Height Adjustment**



5. Set a dial indicator in contact with the interface plate and adjust it so that the probe is vertical. Set the dial indicator height so that it can read at least 0.10" (2.5 mm) stroke. Set the dial ring to zero. The factory default switch setting is 0.025" (0.64 mm).
6. Push on the press handle until the switch circuit opens and check the distance traveled on the dial indicator.

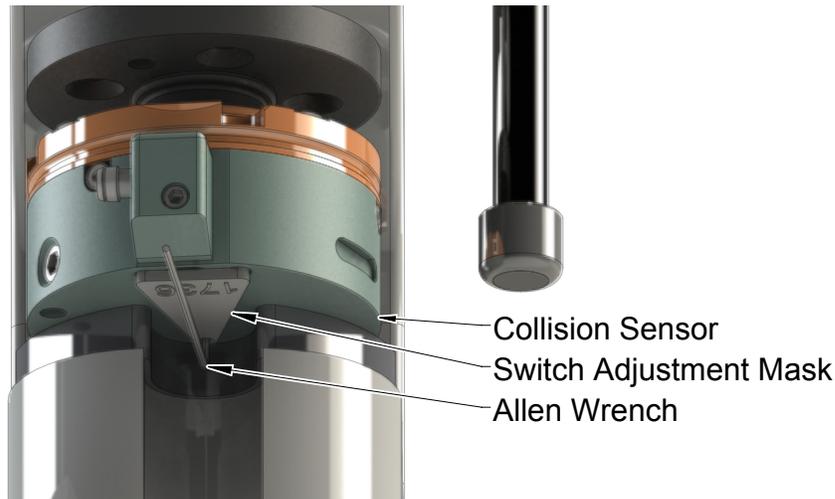
7. If the distance traveled before the switch turns off is greater than desired, turn the adjusting screw clockwise. If the distance traveled is less, turn the adjusting screw counterclockwise (use a 1.5 mm hex key).



**CAUTION:** The switch can be adjusted to open between 0.01" and 0.05" (0.3 mm and 1.3 mm) of axial stem displacement. Setting the switch to open beyond the maximum value of 0.05" (1.3 mm) may result in failure of the switch to detect a crash condition. Setting the switch to open under the minimum value of 0.01" (0.3 mm) may result in damage to the switch and eventual failure of the switch to detect a crash condition.

8. Place the switch adjustment mask onto the bottom of the Collision Sensor. Use the (2) fastener holes closest to connector block to locate the mask on the Collision Sensor.
9. Insert the Allen wrench through the hole in the mask to adjust the switch.

**Figure 2.18—Locating of Adjusting Screw with Mask**



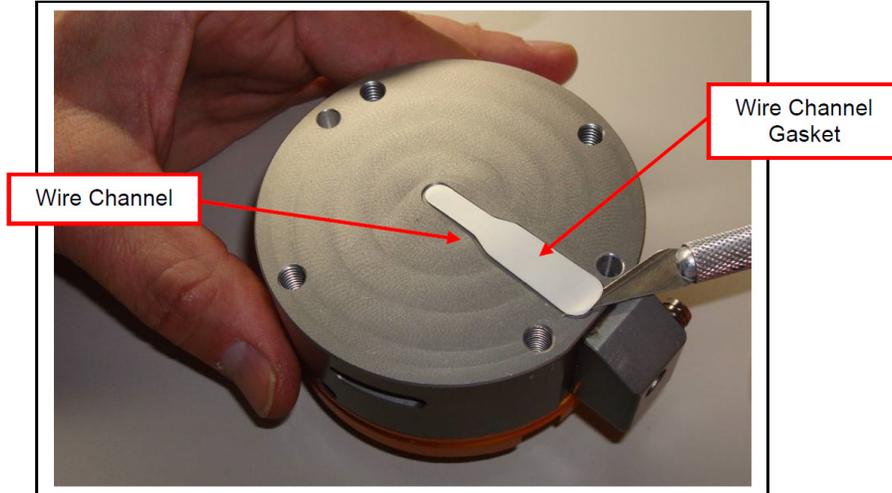
10. After turning the adjusting screw, confirm that the switch is functioning properly by pushing down on the interface plate until the switch circuit opens. Verify that the switch setting is within the adjustment range of 0.01" to 0.05" (0.3 mm to 1.3 mm).



**CAUTION:** Before putting the Collision Sensor back into operation, confirm that the switch is functioning properly and is set within the adjustment range of 0.01" to 0.05" (0.3 mm to 1.3 mm).

11. Remove the masking tape covering the wire channel. Peel the paper backing off of the wire channel gasket and apply the gasket to the shallow recess straddling the wire channel. Be sure that the wires are laying side-by-side in the channel before smoothing the gasket into place. Also, be sure that the gasket resides completely within the shallow recess and that the wires are not twisted or bunched up under the gasket.

**Figure 2.19—Applying the Wire Channel Gasket**



### 3. Drawings

#### 3.1 SR-81

ITEM NO.	QTY.	PART NO.	DESCRIPTION
1	4	3500-1264020-15	M5 x 20mm SFHCS
2	1	9160-STEMCOVKIT-2.081*	Cover Plate Sub-assembly
3	1	(Includes Item 1)	Stem Sub-assembly
4	1	9160-SWITCHKIT-081	Actuation Pin Housing
5	1	(Includes Item 10)	Actuation Spring
6	1		Actuation Pin
7	1		Switch Carrier Spring
8	1		Switch Assembly
9	1	3500-1956005-12A	M2.5 x 5MM Flat Point Set Screw, N.D. Microspheres
10	1	3700-60-1745	Wire Channel Gasket
11	1	3700-60-1758	Molded Wire Channel Gasket (Use with C1, C4 and C5 Boots)
11	1	9160-CON-2	Connector Block Assembly

\* For units with grey covers add "-S" to end of part number.

**Notes:**

- See sheet 2 for optional boots and shields.
- Apply the specified grade of Loctite / tighten fasteners to the specified torque.
- Special linked Tool required.

**222MS / 64 in-ozs**

**222MS / 55 in-lbs**

**Pre-applied Thread Locker / 6 in-lbs**  
See note 3.

Rev.	Description	Initiator	Date
03	ECO 16274: Replaced 9160-CON-1 with 9160-CON-2. Removed ** Units with grey covers use 9160-CON-2. note. Removed 38 10-60-1489 Tool Kit sent to Tooling Lab. Removed Revision Block from Sheet 2.	T8C	12/19/2017

**ATI INDUSTRIAL AUTOMATION**

1031 Goodworth Drive, Apex, NC 27539, USA  
 Tel: +1 919 772.0115 Email: info@ati-ia.com  
 Fax: +1 919 772.8259 www.ati-ia.com  
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NOTES: UNLESS OTHERWISE SPECIFIED, ALL DIMENSIONS ARE IN MILLIMETERS.

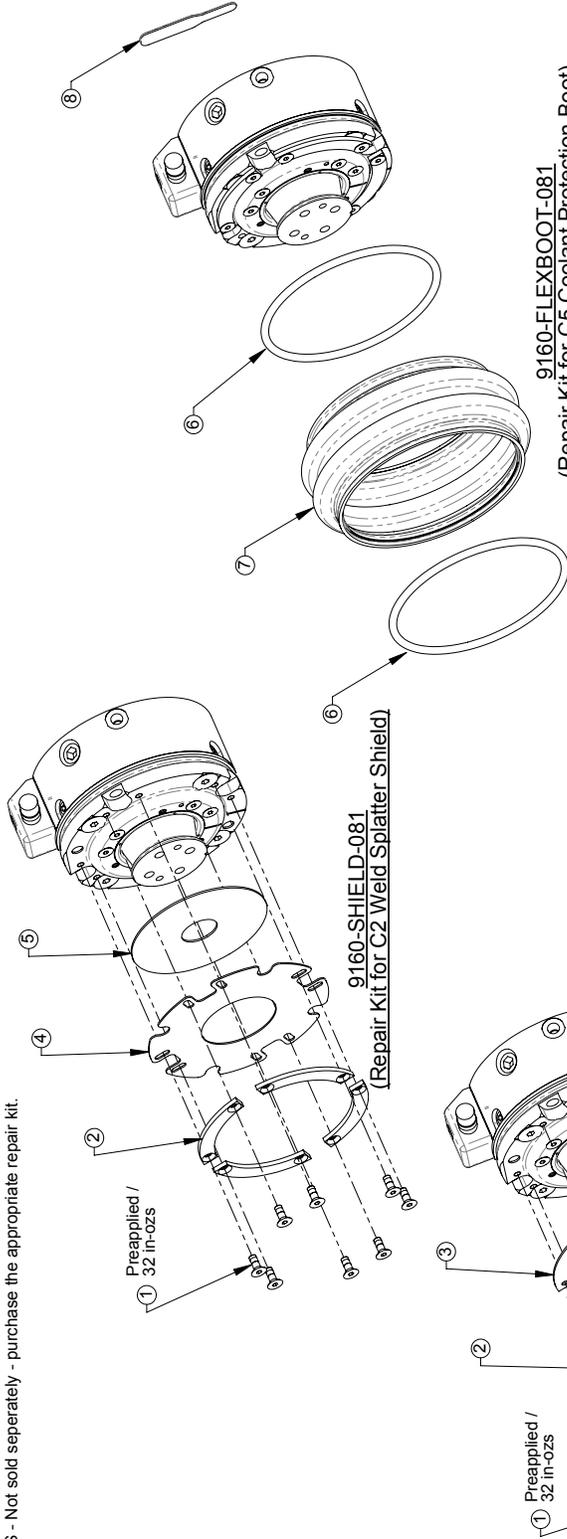
DO NOT SCALE DRAWING.

30° ANGLE PROJECTION

DRAWN BY: D. Wagner 6/4/08	CHECKED BY: W.B. 6/16/08	SCALE: 7:8	SHEET 1 OF 2	PROJECT #: 070517-2	DRAWING NUMBER: 9230-60-1136	REVISION: 03
TITLE: SR-81 Collision Sensor Assembly						

ITEM NO.	QTY.	PART NO.	DESCRIPTION
1	8	NSS	M3 x 8 SFHCS, Metric Blue, Microspheres Epoxy
2	4	NSS	Boot Retainer
3	1	3700-60-1099	Boot
4	1	NSS	Weld Splatter Shield
5	1	NSS	EDPD Rubber Seal
6	2	NSS	Garter Spring
7	1	3700-60-1548	Flexible Boot
8	1	3700-60-1758	Molded Wire Channel Gasket

NSS - Not sold separately - purchase the appropriate repair kit.



NOTES: UNLESS OTHERWISE SPECIFIED, ALL DIMENSIONS ARE IN MILLIMETERS.



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 Tel: +1 919.772.0115 Email: info@ati-ia.com  
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DRAWN BY: D. Wagner 6/4/08	TITLE: SR-81 Collision Sensor Assembly	SCALE: 5:8	REVISION: 03
CHECKED BY: W.B. 6/16/08	PROJECT #: 070517-2	DRAWING NUMBER: 9230-60-1136	
SHEET 2 OF 2			

### 3.2 SR-101

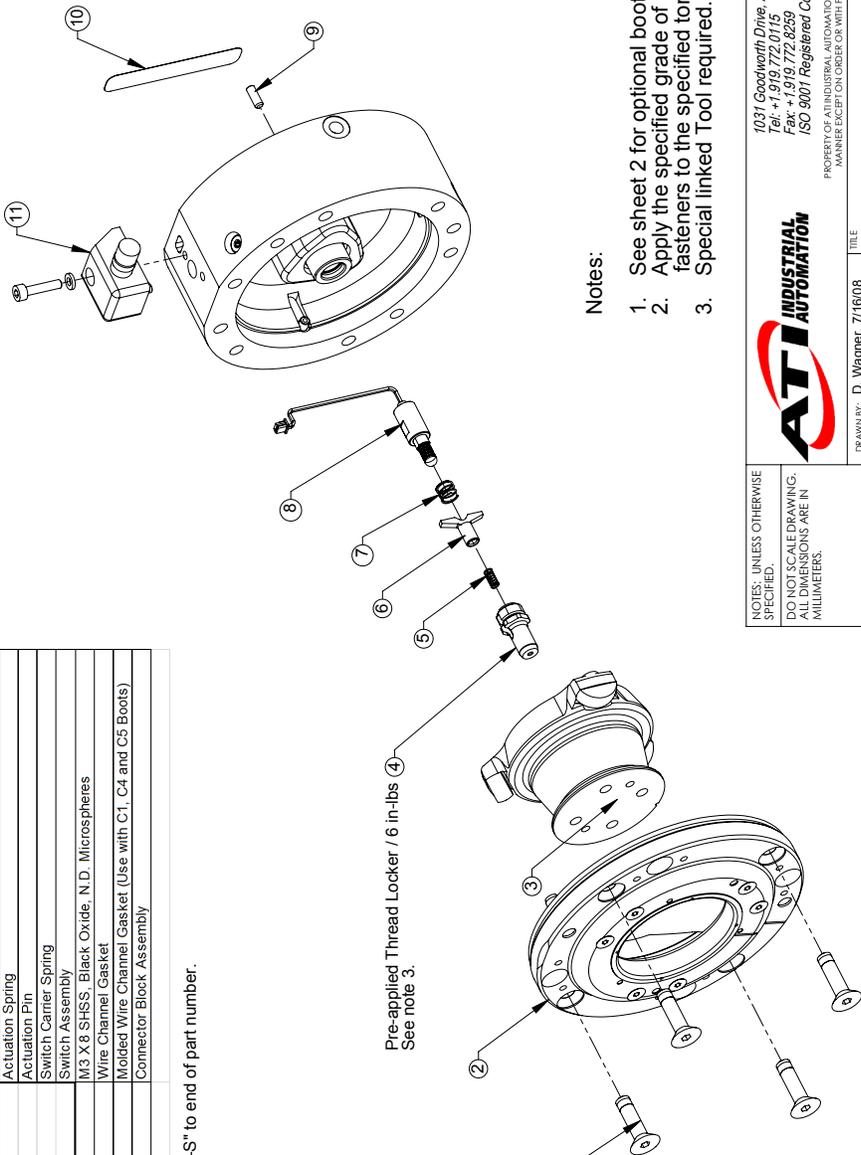
Rev.	Description	Initiator	Date
05	ECO 14939; Change part 3500-1244020-15 to 3700-60-1023 in assembly model; Removed revision block from sheet 2.	TBC	2/19/2018

ITEM NO.	QTY.	PART NO.	DESCRIPTION
1	4	3500-1244020-15	M4 x 20mm SFHCS
2	1	9160-STEMCOVKIT-2-101*	Cover Plate Sub-assembly
3	1	(Includes Item 1)	Stem Sub-assembly
4	1	9160-SWITCHKIT-101	Actuation Pin Housing
5	1	(Includes Item 10)	Actuation Spring
6	1		Actuation Pin
7	1		Switch Camer Spring
8	1		Switch Assembly
9	1	3500-1958008-12A	M3 X 8 SHSS; Black Oxide; N.D. Microspheres
10	1	3700-60-1113	Wire Channel Gasket
11	1	3700-60-1607	Molded Wire Channel Gasket (Use with C1, C4 and C5 Boots)
	1	9160-CONJ-2	Connector Block Assembly

\* For units with grey covers add ".S" to end of part number.

**Notes:**

1. See sheet 2 for optional boots and shields.
2. Apply the specified grade of Loctite / tighten fasteners to the specified torque.
3. Special linked Tool required.

<p>NOTES: UNLESS OTHERWISE SPECIFIED:                  DO NOT SCALE DRAWING.                  ALL DIMENSIONS ARE IN MILLIMETERS.</p>	<p>1031 Goodworth Drive, Apex, NC 27539, USA                  Tel: +1 919 772 0115 Fax: +1 919 772 8259                  Email: info@ati-ia.com www.ati-ia.com                  ISO 9001 Registered Company</p> <p>PROPERTY OF AT INDUSTRIAL AUTOMATION, INC. NOT TO BE REPRODUCED IN ANY MANNER EXCEPT ON ORDER OR WITH PRIOR WRITTEN AUTHORIZATION OF ATII.</p>	<p><b>ATI INDUSTRIAL AUTOMATION</b></p> <p>PROJECT # 070517-2 SHEET 1 OF 2</p> <p>SCALE 3:4</p> <p>DRAWING NUMBER 9230-60-1139</p> <p>REVISION 05</p>
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ITEM NO.	QTY.	PART NO.	DESCRIPTION
1	8	NSS	M3 x 8 SFHCS, Metric Blue, Microspheres Epoxy
2	4	NSS	Boot Retainer
3	1	3700-60-1263	Boot
4	1	NSS	Weld Splatter Shield
5	1	NSS	EDPD Rubber Seal
6	2	NSS	Garter Spring
7	1	3700-60-1558	Flexible Boot
8	1	3700-60-1607	Molded Wire Channel Gasket

NSS - Not sold separately - purchase the appropriate repair kit.

**9160-SHIELD-101**  
(Repair Kit for C2 Weld Splatter Shield)

Preapplied /  
32 In-ozs

**9160-BOOT-101**  
(Repair Kit for C1 - IP65 Boot)

Preapplied /  
32 In-ozs

**9160-FLEXBOOT-101**  
(Repair Kit for C5 Coolant Protection Boot)

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 Tel: +1 919.772.0115 Email: info@ati-ia.com  
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DRAWN BY: D. Wagner, 7/16/08  
 CHECKED BY: W. Berrocal, 7/16/08

TITLE: SR-101 Collision Sensor Assembly

SCALE: 1:2  
 SHEET 2 of 2

PROJECT #: 070517-2  
 DRAWING NUMBER: 9230-60-1139  
 REVISION: 05

## 4. Terms and Conditions of Sale

The following Terms and Conditions are a supplement to and include a portion of ATI's Standard Terms and Conditions, which are on file at ATI and available upon request.

ATI warrants to Purchaser that Collision Sensor products purchased hereunder will be free from defects in material and workmanship under normal use for a period of one (1) year from the date of shipment. The warranty period for repairs made under a RMA shall be for the duration of the original warranty, or ninety (90) days from the date of repaired product shipment, whichever is longer. ATI will have no liability under this warranty unless: (a) ATI is given written notice of the claimed defect and a description thereof within thirty (30) days after Purchaser discovers the defect and in any event not later than the last day of the warranty period; and (b) the defective item is received by ATI not later ten (10) days after the last day of the warranty period. ATI's entire liability and Purchaser's sole remedy under this warranty is limited to repair or replacement, at ATI's election, of the defective part or item or, at ATI's election, refund of the price paid for the item. The foregoing warranty does not apply to any defect or failure resulting from improper installation, operation, maintenance or repair by anyone other than ATI.

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No action against ATI, regardless of form, arising out of or in any way connected with products or services supplied hereunder may be brought more than one (1) year after the cause of action occurred.

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