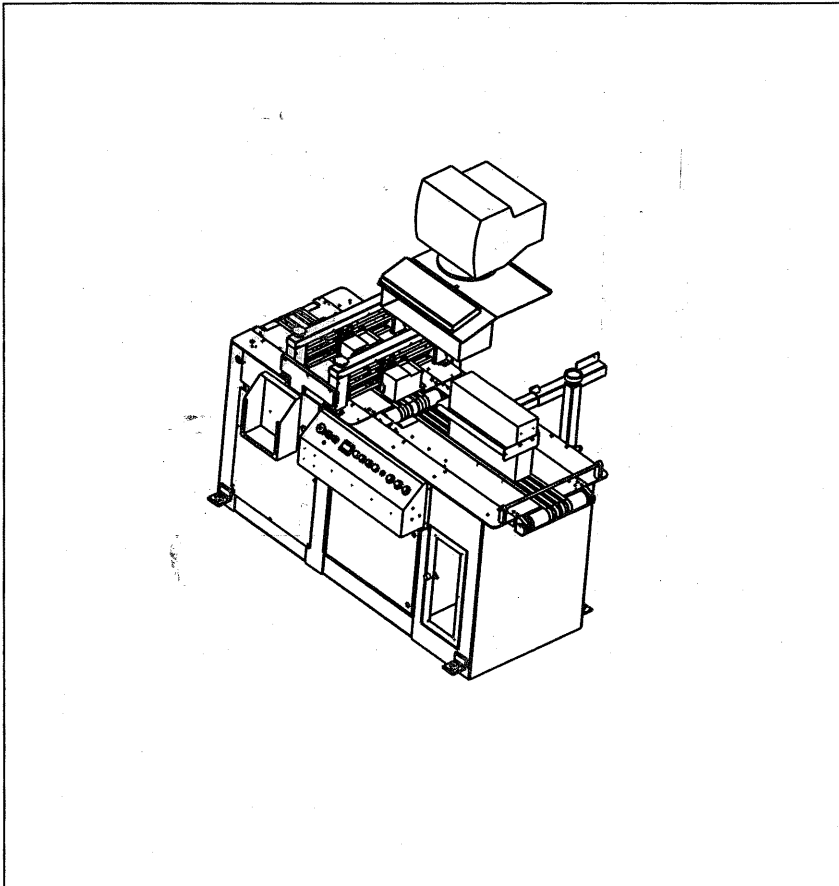


Kirk-Rudy, Inc.

Instruction and Parts Manual KR219B



Manufactured by Kirk-Rudy, Inc.

Before using this machine, all operators must study this manual to understand and follow the safety warnings and instructions. Keep these instructions with the machine for future reference. If you have any questions, contact your local Kirk-Rudy, Inc. Distributor.

10000-219B REV. 3 4/2/2003

Manual

TABLE OF CONTENTS

<u>SECTION</u>	<u>DESCRIPTION</u>	<u>PAGE</u>
1	IMPORTANT SAFETY INSTRUCTIONS	3
2	SPECIFICATIONS	4
3	INSTALLATION	
	3.1 UNCRATING	5
	3.2 ACCESSORIES AND SPARE PARTS	5
4	OPERATING INSTRUCTIONS	
	4.1 CONTROL PANEL	6
	4.2 STOP CIRCUIT	7
	4.3 SEQUENCE OF SET-UP	7
	4.4 SIDE GUIDES	7-9
	4.5 TABLETOP BELTS	9-10
	4.6 SKID BAR	11
	4.7 PRODUCT DETECTION	11
	4.8 DRYER ARM SETUP & USAGE	12
5	MAINTENANCE	
	5.1 DAILY MAINTENANCE	13
6	PARTS LIST AND DIAGRAMS	
	6.1 PARTS LIST	14
	6.2 DIAGRAMS	14
7	ELECTRICAL SCHEMATICS AND PARTS	
	7.1 WIRING DIAGRAMS LIST	15
8	APPENDIX	16
9	NOTES	17
10	WARRANTY AND SERVICE INFORMATION	18

NOTE: FIGURES AND DIAGRAMS ARE NOT INCLUDED IN PAGE NUMBERS.

1 Important Safety Instructions

Intended Use Statement: The KR219B SP85900 machine is design to convey product for inkjet printing and drying. A vacuum conveyor table will be used to transport the product under inkjet heads for printing. Next, product will be transferred to a heat belt section. The heat belt section will use a high temperature vacuum blower to the control the product as it is conveyed under an inkjet print dryer. Usage for other purposes may lead to an unsafe condition.

SAVE THESE INSTRUCTIONS. Read all instructions before using this product.



WARNING

- * NEVER OPERATE THE MACHINE WITHOUT ALL GUARDS OR SAFETY DEVICES IN PLACE.
- * ALWAYS TURN POWER OFF WHEN MAKING ADJUSTMENTS.
- * ALWAYS DISCONNECT THE POWER SUPPLY BEFORE ANY MAINTENANCE OR SERVICE WORK.
- * NEVER START THE MACHINE WITHOUT FIRST CHECKING ALL PERSONNEL ARE CLEAR OF MOVING PARTS.
- * KEEP FINGERS CLEAR OF ALL MOVING PARTS.
- * NEVER REMOVE THE PRODUCT FROM THE MACHINE WHILE MACHINE IS RUNNING.
- * SHOULD MISFED PRODUCT JAM THE MACHINE AND STOP IT FROM RUNNING, ALWAYS PRESS THE STOP BUTTON BEFORE CLEARING PRODUCT. IF THE STOP BUTTON IS NOT PRESSED AND THE JAM IS CLEARED, THE MACHINE WILL BEGIN RUNNING.
- * IT IS NOT RECOMMENDED THAT LOOSE CLOTHING, JEWELRY AND LONG HAIR BE WORN WHILE OPERATING THIS MACHINERY.
- * ALWAYS USE AN EXPERIENCED ELECTRICIAN WHEN TROUBLE-SHOOTING ELECTRICAL PROBLEMS.
- * CHANGES OR MODIFICATIONS TO THIS UNIT NOT EXPRESSLY APPROVED BY THE PARTY RESPONSIBLE FOR COMPLIANCE COULD VOID THE USER'S AUTHORITY TO OPERATE THE EQUIPMENT.

2 SPECIFICATIONS

<u>PRODUCT SIZE RANGE</u>	<u>English</u>	<u>Metric</u>
Minimum Size:	3" W x 5" L	7.6cm W x 12.7cm L
Maximum Size:	17" W x 16" L	43.2cm W x 40.6cm L
Minimum Thickness:	Card Stock (.007")	Card Stock (.10mm)
Maximum Thickness:	.625"	15.9 mm

PHYSICAL SIZE (STANDARD)

Length	69"	175.26 cm
Width	45"	114.3 cm
Height	50.25"	127.6 cm
Weight	lbs	kg
Shipping	lbs	kg

MAXIMUM SPEED

590 feet per minute

ELECTRICAL SPECIFICATIONS

Power Requirements: 120VAC/20A 60Hz.

3 INSTALLATION



WARNING

Read and follow all Safety Instructions in Section 1, Page 3 before proceeding.

3.1 UNCRATING

1. Position crate near installation site.
2. Remove crate top and sides.
3. Locate accessories box and verify all items are present.
4. Remove metal strapping and securing blocks.
5. Use forklift to lift machine off skid. Be sure to position the forks in a centrally located position.
6. Machine is on casters and can be rolled to desired location.
7. Adjust the height of the base with the four leveling legs.

Note: A forklift should be used to lift machine from pallet. The base is mounted on casters.

3.2 ACCESSORIES AND SPARE PARTS

The accessories and spare parts are packaged and located inside the base cabinet. The box should be opened and checked against the enclosed packing list.

4 OPERATING INSTRUCTIONS



WARNING

Read and follow all Safety Instructions in Section 1, Page 3 before proceeding.

4.1 CONTROL PANEL (Figure 1.0)

Main Power Off Switch: This switch cuts power to the entire machine. Twist to unlatch.

Main Power Switch: When this two-position switch is depressed, source voltage is supplied to the electrical panel. This will make all of the switches on the electrical control panel active. The switch will be light green when activated.

Blower Switch: Rotate this switch to actuate both vacuum blowers. One is for the inkjet table. One is for the dryer table.

Feeder Stop Switch: When this two-position switch is depressed the feeder portion of the machine will turn off. The rest of the machine past the feeder will continue to operate.

Stop Switch (red): Machine operation can be manually stopped by depressing the stop button on the operator panel or the button on the left panel of the conveyor.

Jog Switch (black): The machine can be inched or jogged by depressing and releasing this switch. The machine will continue to cycle if this button is held depressed.

Start Switch (green): Continuous machine operation is achieved by depressing this switch momentarily and releasing.

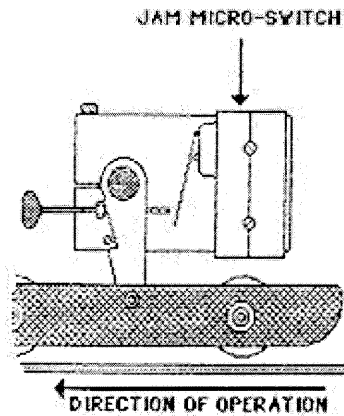
Speed Control, Table Conveyor: Machine speed can be varied by turning the first knob. Turn knob clockwise to increase conveyor speed, counterclockwise to decrease.

Speed Control, Conveyor: The second knob controls the speed of the belts on the shingle conveyor. When the main drive motor speed is set at a convenient range to continually replenish product in the feed hopper and for zip code sorting requirements, the conveyor speed should be adjusted for required product overlap. Turn knob clockwise to increase belt speed, counterclockwise to decrease.

Speed Control, Conveyor Speed Up: The third knob controls the speed up of the belts on the shingle conveyor. Turn knob clockwise to increase belt speed, counterclockwise to decrease.

4.2 STOP CIRCUIT

The stop circuit is wired in series, this means that if one of the stop switches or buttons is open, the machine will not run. There are two stop switches on the KR219B. They are the jam microswitch on the skid bar assembly, and the control panel emergency stop button.



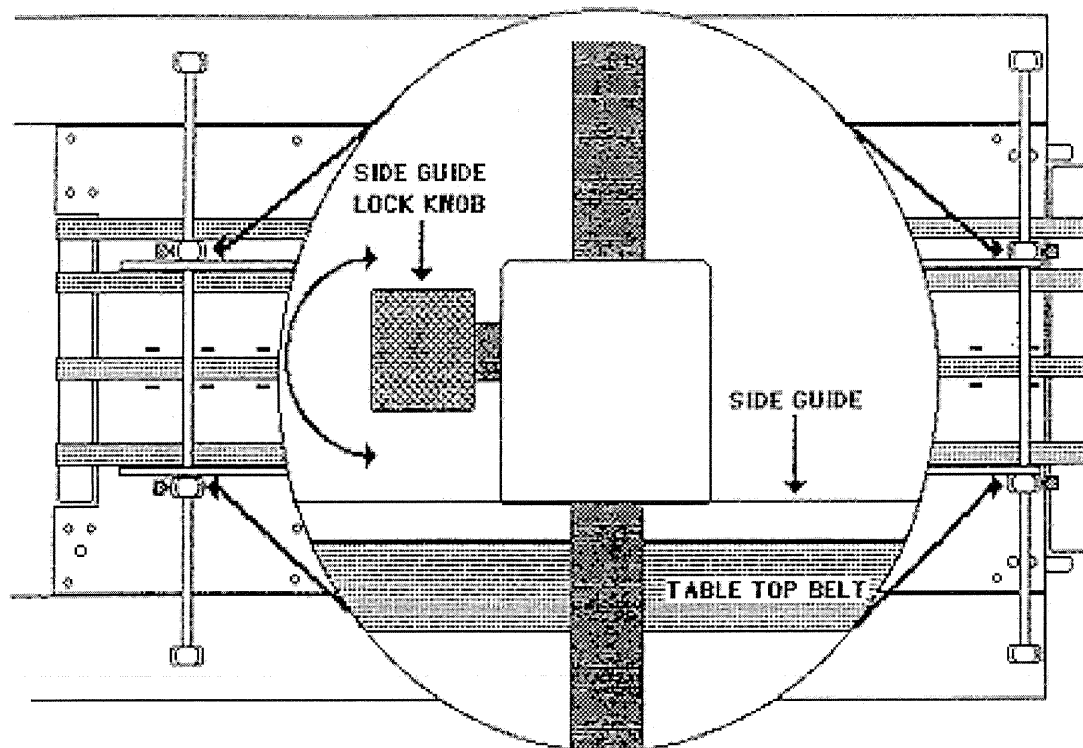
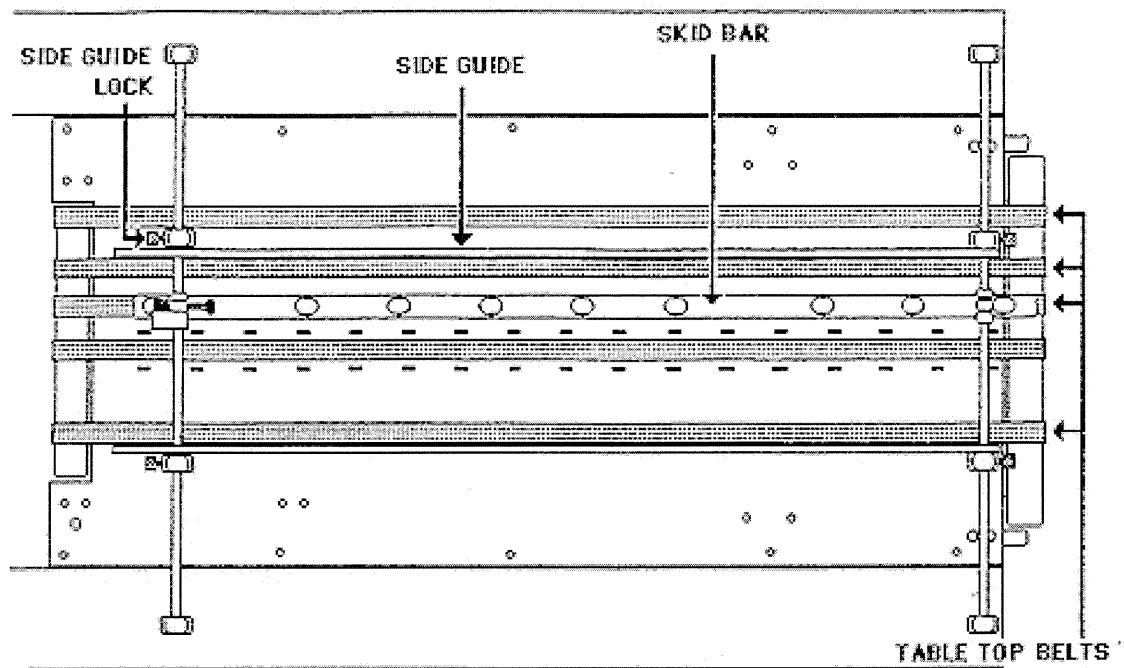
4.3 SEQUENCE OF SET-UP

1. Position tabletop side guides.
2. Set micro jam switch and adjust skid bar to product height.
3. Turn and pull the power off button and stop button.
4. Plug conveyor up or if no conveyor, use jumpers to complete circuit. Machine will not run with incomplete circuit.
5. Turn power on.
6. Press start button.
7. Adjust tabletop belts.

4.4 SIDE GUIDES

Side guides are used to keep the product feeding in one direction and in an orderly manner. It is an important part of the 219IJ and 219IJ+20. To adjust the side guides, place the product on the tabletop belts and unlock the side guide lock knobs. Slide side

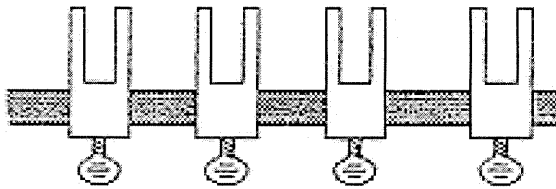
guides to 1/16" on both sides of the product. Lock side guides into place with lock knobs.



If the side guides are too tight, the mailing piece will not move across the tabletop. If they are too loose, the mailing piece may skew and the ink will be placed on crooked.

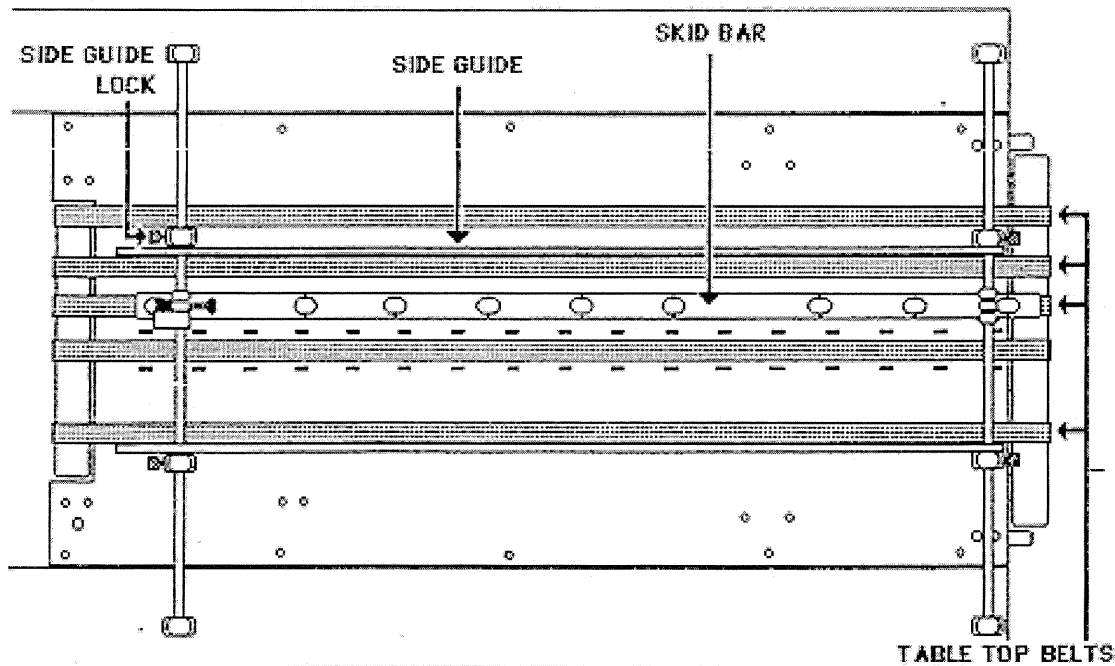
4.5 TABLETOP BELTS

The tabletop belts are designed to transport the product from the feed rollers, under the labeling head and onto the conveyor. There are five tabletop belts on the KR219B. However, not all of them are needed for every product. You may run the belts that are not needed outside of the side guides.



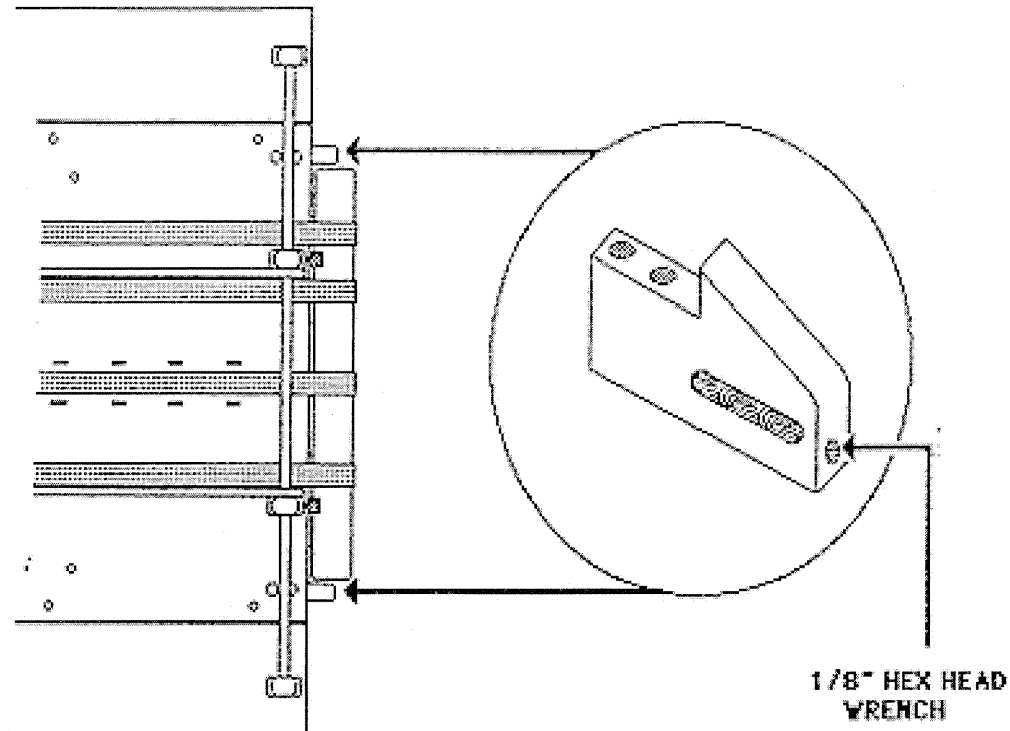
Underneath the tabletop is located guides for the tabletop belts. Each belt has its own guide. To move the belts, simply loosen the thumbscrew on the bottom of the guide and slide the guide on the shaft to the desired position and then tighten the thumbscrew.

The belts should be positioned so that there is a belt riding next to each side guide, one belt between the vacuum ports and, if used, one underneath the skid bar.



The fourth and additional belts are normally used when running large product such as newspapers or heavy product such as magazines.

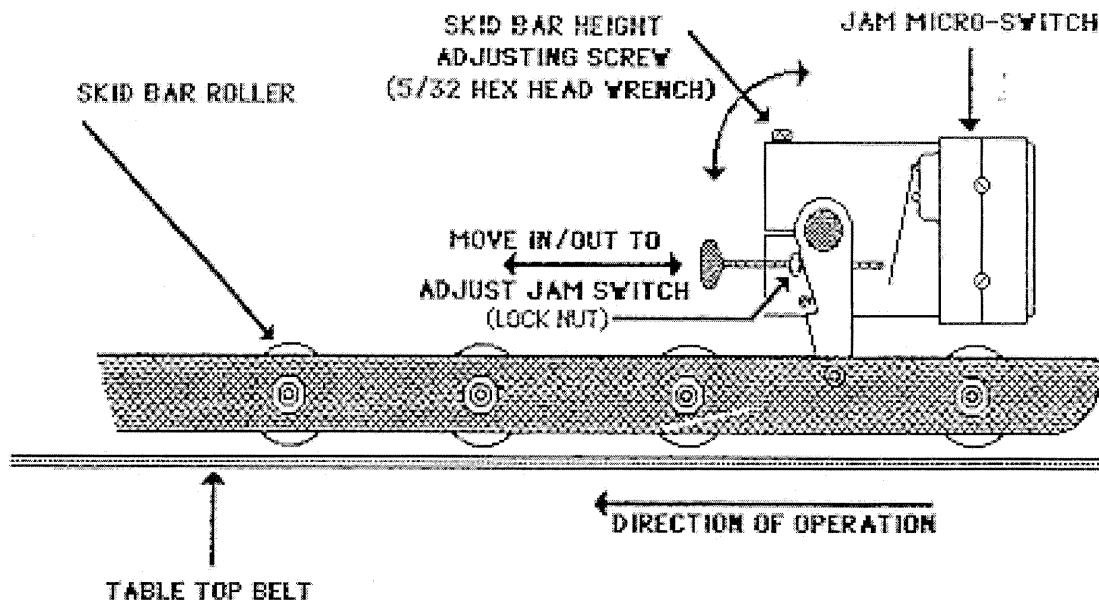
The tabletop belt tension can be adjusted. Caution should be taken not to over tighten. There should be just enough tension to prevent belt slippage.



4.6 SKID BAR

The skid bar rides on top of the product to help transport the mailing piece across the tabletop. The skid bar should be placed over one of the tabletop belts for best results. To move the skid bars locate and loosen the 1/8" hex head set screws in the lock collars on the right-hand side of the machine. The left-hand side of the machine has a lock collar and a skid bar block that is held in place with a 5/32" hex head screw. The KR219B are furnished with one skid bar. The skid bar is not needed when running small pieces such as cards or envelopes, but it can be installed when running large or heavy product.

Attached to one end of the skid bars is a "jam detector switch" on certain machines. This switch, when properly set, will stop the machine when a jam or double feed occurs.



To set the skid bar, rotate the machine until a mailing piece is under the skid bar. Loosen the 5/32" hex head screw on the skid bar block. Adjust until the skid bar is resting on the mailing piece and the skid bar rollers rotate as the product is transported. Lock in place with the 5/32" hex head screw.

The jam switch is adjusted by loosening the lock nut, moving the adjustment knob in or out and tightening the lock nut. The microswitch should disengage and stop the machine when a jam or double feed occurs.

NOTE: The machine will not run if the jam switch is not set properly (see Section 4.2).

4.7 PRODUCT DETECTION

The KR219B has a beamswitch located at the infeed for product detection. This beamswitch is used with a time delay relay to control the dryer lamps. The beamswitch is set up so if product is not detected for "x" amount of time the dryer lamp are turned off. The amount of time is adjustable. This circuit is designed to extend the life of the high heat belts on the outfeed section of the machine.

4.8 DRYER ARM SETUP & USAGE (FIG 4)



WARNING

Read and follow all Safety Instructions in Section 1, Page 3 before proceeding. Dryer surface maybe hot. Read and follow dryer manufactures manual before proceeding.

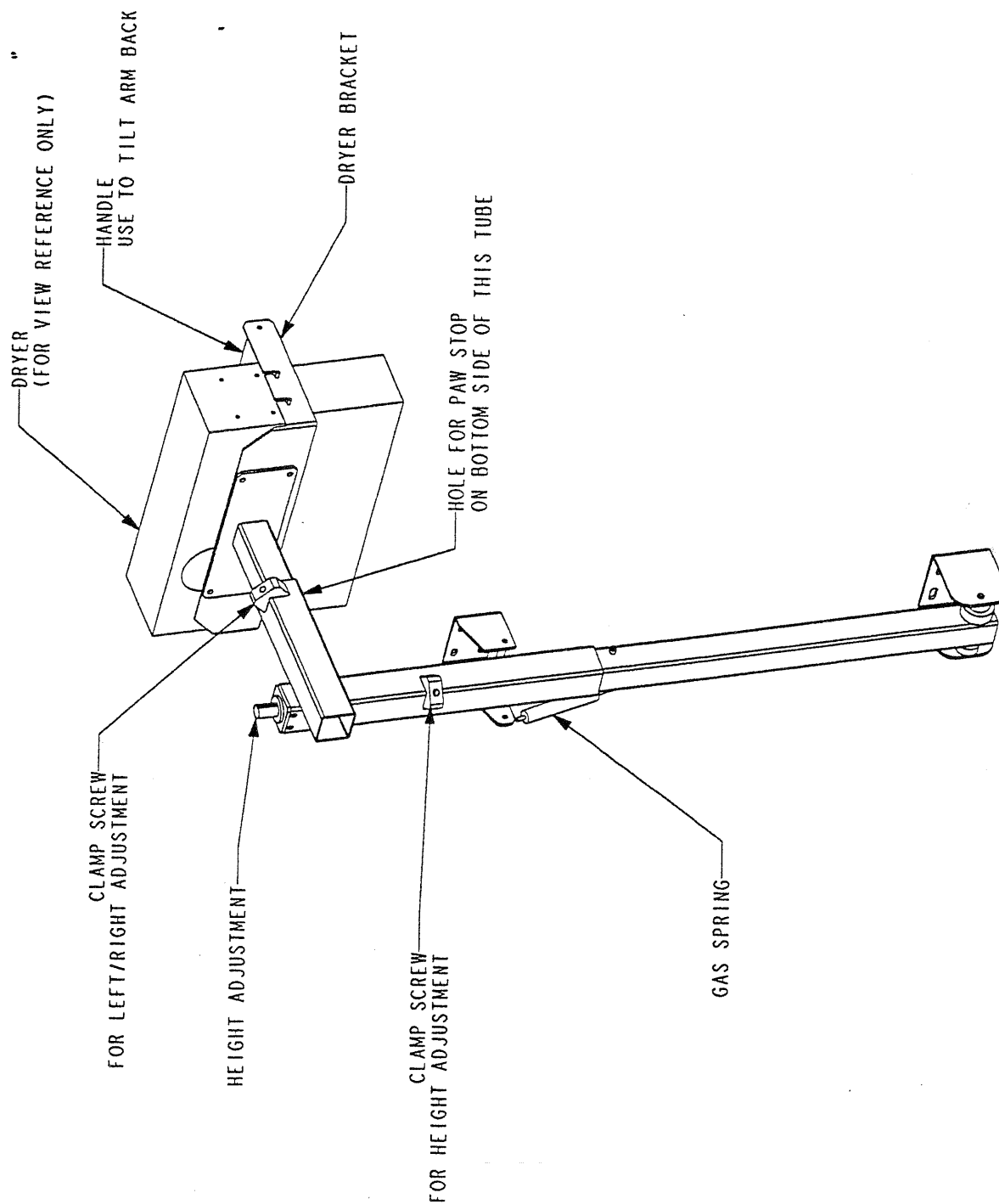
Height Adjustment: The height of the dryer can be adjusted using the wheel on the top of the dryer Arm. First loosen the clamp screw on the vertical tube of the dryer arm. Next, turn the crank clockwise to move the dryer down or counter clockwise to move the dryer up. Retighten clamp screw when dryer is at desired height.

Left/Right Adjustment: The left/right position of the dryer can be adjusted by loosening the clamp screw on the horizontal tube, continue to hold the clamp screw handle and slide the dryer in and out. Retighten clamp screw when dryer is at desired location.

Clearing Jam Under Dryer: Use handle to push dryer arm back approximately 15 degrees. Dryer arm will remain back so jam can be cleared. **Note: A microswitch at the bottom is used to turn dryer off in the back position.** Pull on handle to position the dryer back over the conveyor for normal operation.

Horizontal Tube Removal: The inside horizontal tube has a paw stop to prevent the dryer from being pulled out too far. The spring loaded paw will automatically stop the tube at the end of its stroke. The spring loaded paw automatically resets when the tubing is pushed in the opposite direction. To remove the horizontal tube follow these steps:

1. Remove dryer from dryer bracket.
2. Loosen horizontal clamp screw.
3. Slide tube out until the paw stops it.
4. Use allen wrench to push paw up and out of the hole located on the bottom of the larger horizontal tubing, at same time pull inside tubing out.



DRYER ARM SET UP/USAGE
FIGURE 4.0

5 MAINTENANCE



WARNING

Read and follow all Safety Instructions in Section 1, Page 3 before proceeding.

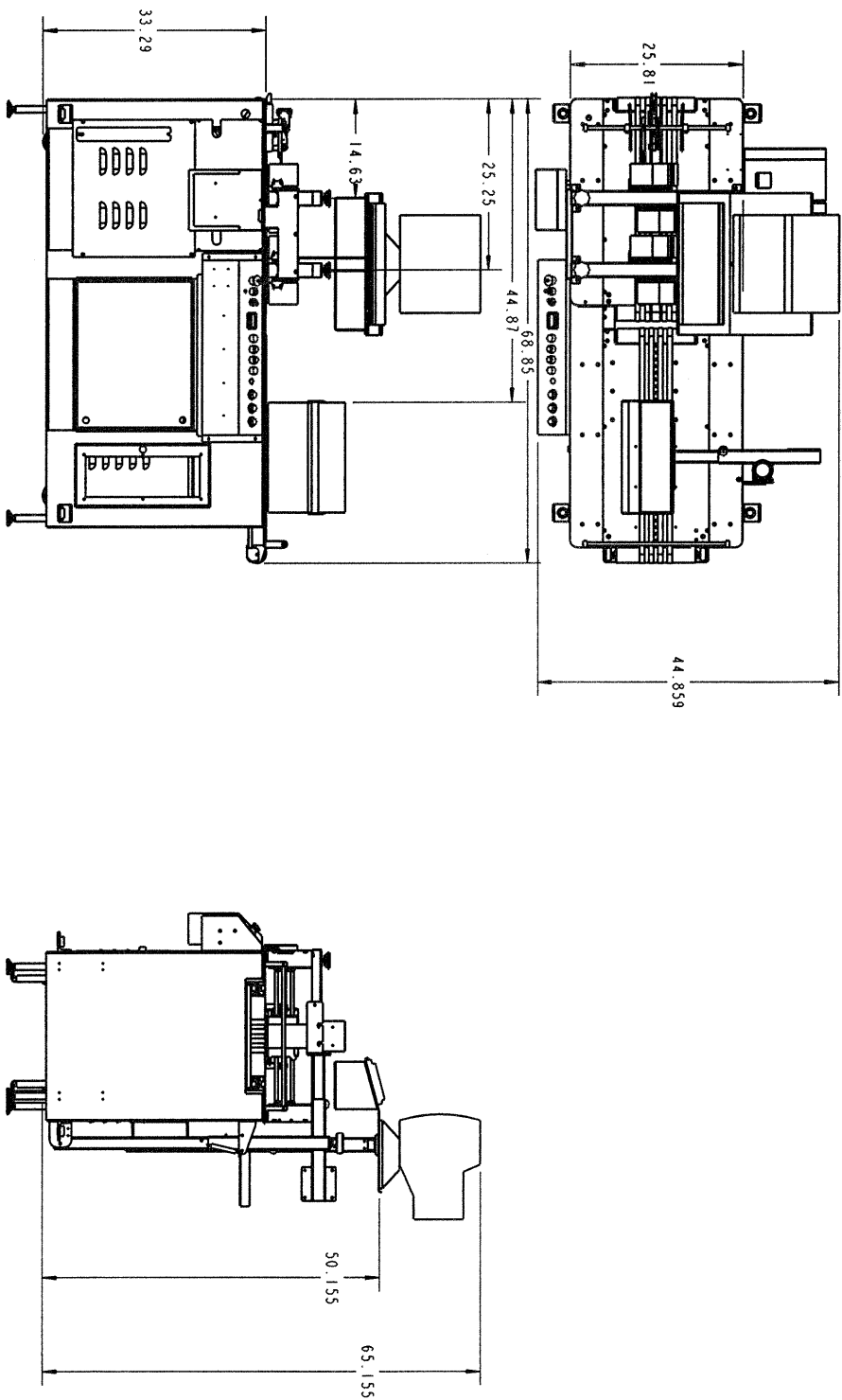
5.1 DAILY MAINTENANCE

Remove excessive paper dust, ink, glue, and all other foreign materials from the tabletop and inside the base. Use a clean soft rag. Dampen rag with water if necessary.

6 PARTS LISTS AND DIAGRAMS

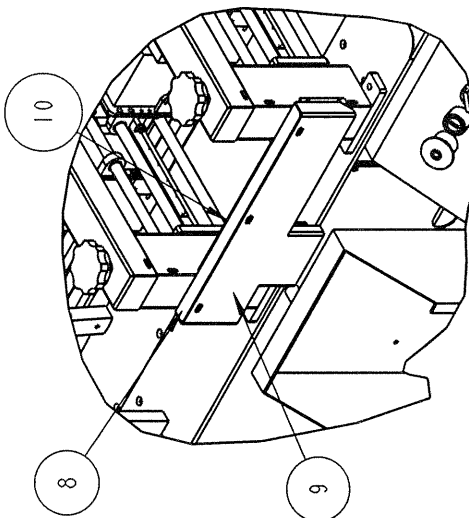
This section contains the entire mechanical bill of materials and assembly drawings.

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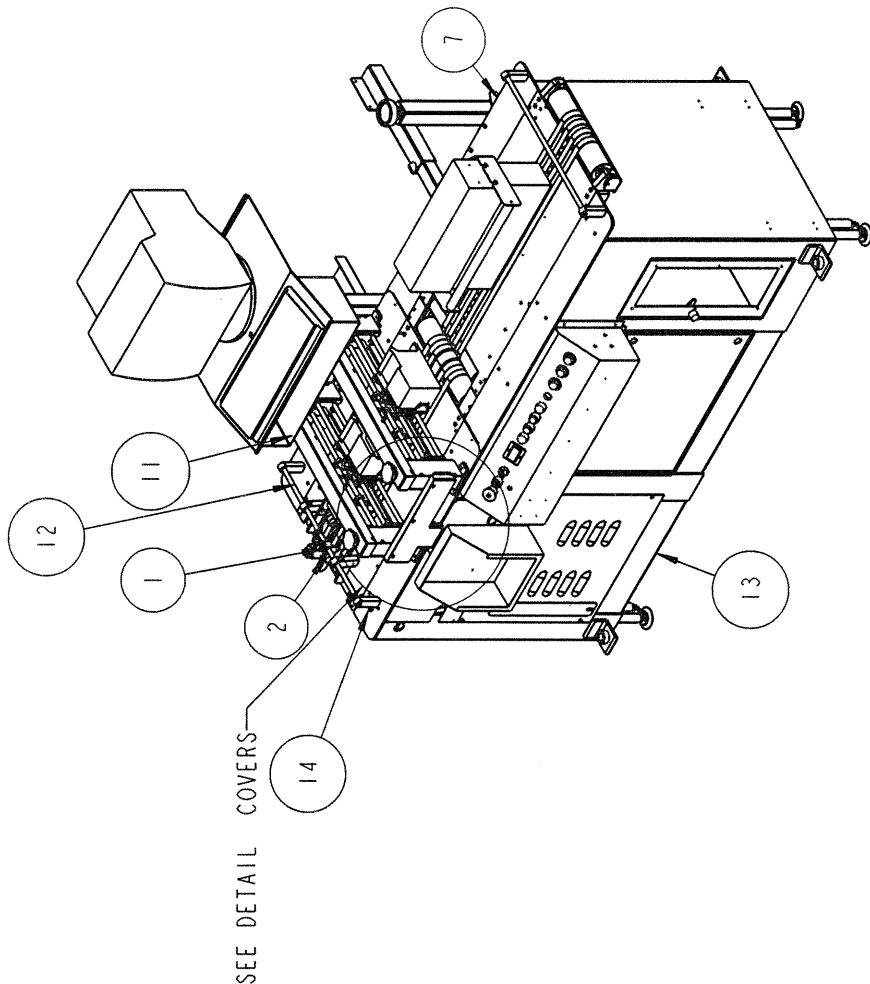


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DATE BY:	0.060	AS	MS	IN	MM	XXX	XXX	SP85900	20F 4	ASSY, 219B BRYCE INKJET	SP85900		
DATE BY:	14-Aug-00	REWORK ALL DIMENSIONS AND TOLERANCES UNLESS OTHERWISE NOTED				XXX	XXX	MAY BE COPIED OR REPRODUCED FOR INTERNAL USE ONLY					
DATE BY:	WALTER	DO NOT SCALE - WORK TO DIMENSIONS ONLY				XXX	XXX						

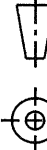

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2	1	106202-7	BELT, GREEN 1.25 X 68.75
3	1	108904-3	BELT, TIMING 390L075
4	1	108936-1	BELT, TIMING 345L075
5	1	108940-9	BELT, TIMING 420L075
6	1	109010-2	BELT, TIMING 190XL037
7	1	536479-02	ASSY, 36IN FRAME EXT
8	1	536497-01	BAR, CABLE COVER
9	1	536504-02	COVER, CABLE FRONT
10	1	536535-02	COVER, CABLE FRONT
11	2	538169-01	ASSY, BRYCE INKJET BRACKET
12	1	538188-01	ASSY, SKIDBAR/SENSOR
13	1	538288-04	ASSY, CABINET & COVERS
14	1	538441-01	ASSY, 219 SECTION



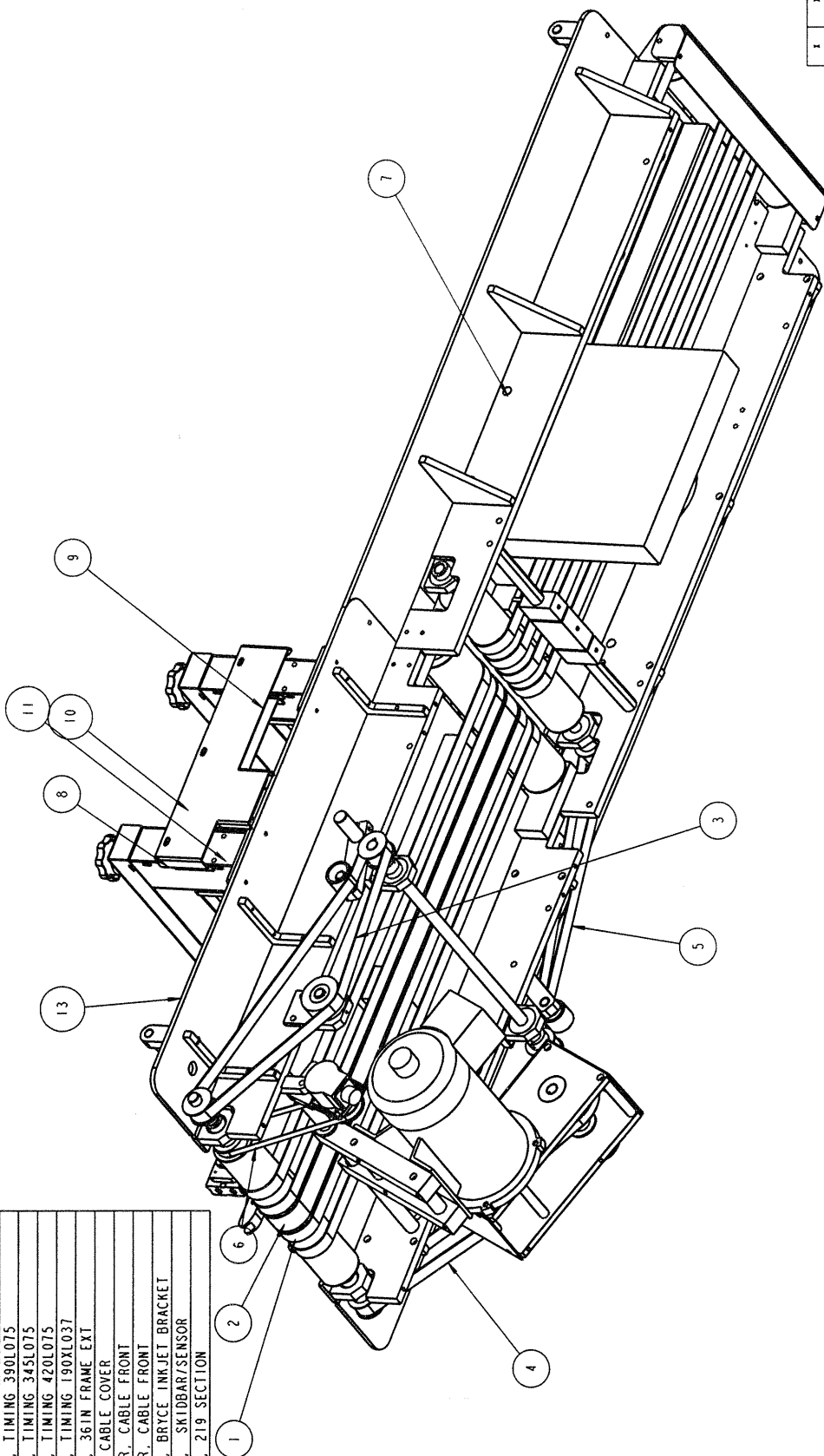
DETAIL COVERS
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SEE DETAIL COVERS-

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	CHECKED BY: DATE 14-Aug-00	REMOVE ALL BURS AND SHARP EDGES UNLESS OTHERWISE NOTED		HEAT TREAT: XXX						
		ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY		FINISH: XXX						
		TRACED BY:	MASTER							

ITEM	QTY	PART #	DESCRIPTION
1	4	105901-9	BELT, GREEN .75 X 68.75
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11	2	538169-01	ASSY, BRYCE INKJET BRACKET
12	1	538188-01	ASSY, SKIDBAR/SENSOR
13	1	538441-01	ASSY, 219 SECTION

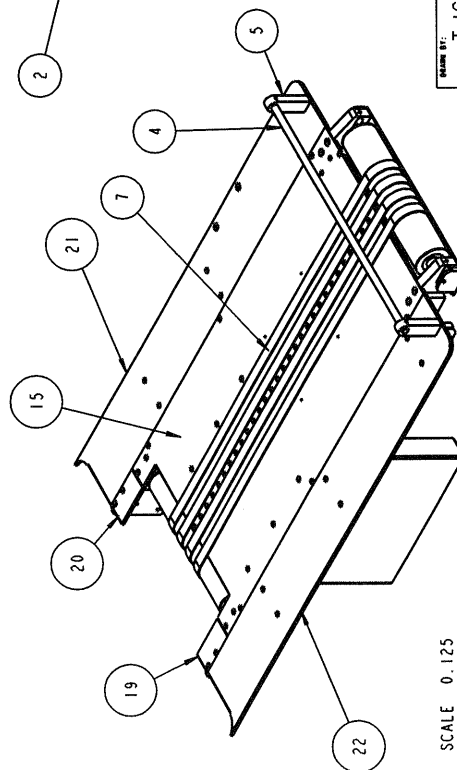
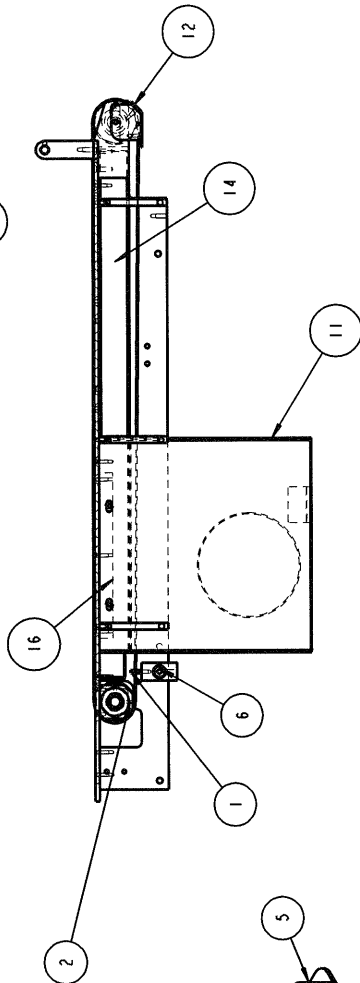
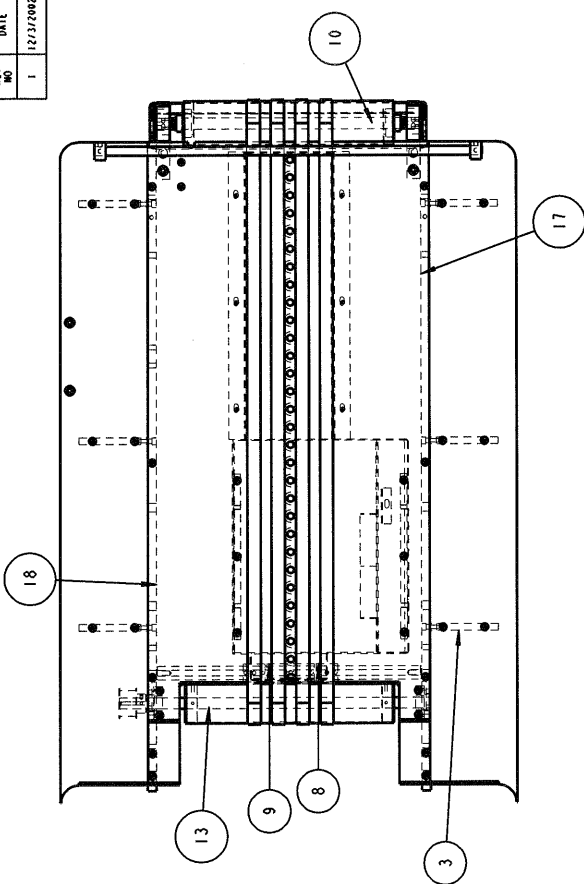


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	CHECKED BY: DATE 14-Aug-00	DATE 14-Aug-00	DATE 14-Aug-00					DATE 14-Aug-00	
TRACED BY:	MASTER	ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY		XXX	XXX	XXX	ASSY, 219B BRYCE INKJET		
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536479-02

REV	DATE	DESCRIPTION	ECR	BT
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ITEM	QTY	PART #	DESCRIPTION
1	8	105419	DOWEL, PIN .188X1.000
2	1	108809	PULLEY, TIMING 12L075 .625B .188K
3	6	500721	GUSSET - TABLET SUPPORT
4	1	500787	SHAFT-SIDE GUIDE ADJ.
5	2	500791	POST, SIDEGUIDE
6	1	500824	SHAFT-BELT GUIDE
7	4	108472-2	BELT, HIGH HEAT 3/4 X 72
8	2	500725-13	GUIDE, BELT 3/4
9	1	500725-17	GUIDE, BELT
10	1	530619-01	ASSY. IDLER ROLLER
11	1	532449-06	WLDMT, BOX VACUUM 215B
12	1	532712-01	ASSY. OUTFD SAFETY COVER
13	1	538467-01	ASSY. DRIVE ROLLER DRYER
14	1	536473-01	TRAY, VACUUM
15	1	536474-02	PLATE, TT DRYER
16	2	538282-01	BAR, BOX MOUNT
17	1	538286-01	FRAME, 36 IN. EXTENSION RH
18	1	538286-02	FRAME, 36 IN. EXTENSION LH
19	1	538287-01	PLATE, TABLET INSERT RH
20	1	538287-02	PLATE, TABLET INSERT LH
21	1	SP26803-5L	TABLETOP, LH 36 IN
22	1	SP26803-5R	TABLETOP, RH 36 IN



SCALE 0.125

NAME BY:	TJG	SCALE	0.150	DIMENSIONS OWN TO BE PRINTED UNLESS OTHERWISE NOTED	MATERIAL:	XXX	PROPERTY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS WITHOUT WRITTEN PERMISSION OF KIRK - RUDY, INC. KENNESAW, GA 30144 USA	REQ'D WHERE USED	1	536479-02
CHECKED BY:		DATE	25-Feb-00	REWORK ALL DIMENSIONS AND FINISHES UNLESS OTHERWISE NOTED	HEAT TREAT:	XXX				
TRACER BY:		MATERIAL		ALL DIMENSIONS ARE TO DIMENSIONS ONLY	FINISH:	XXX				

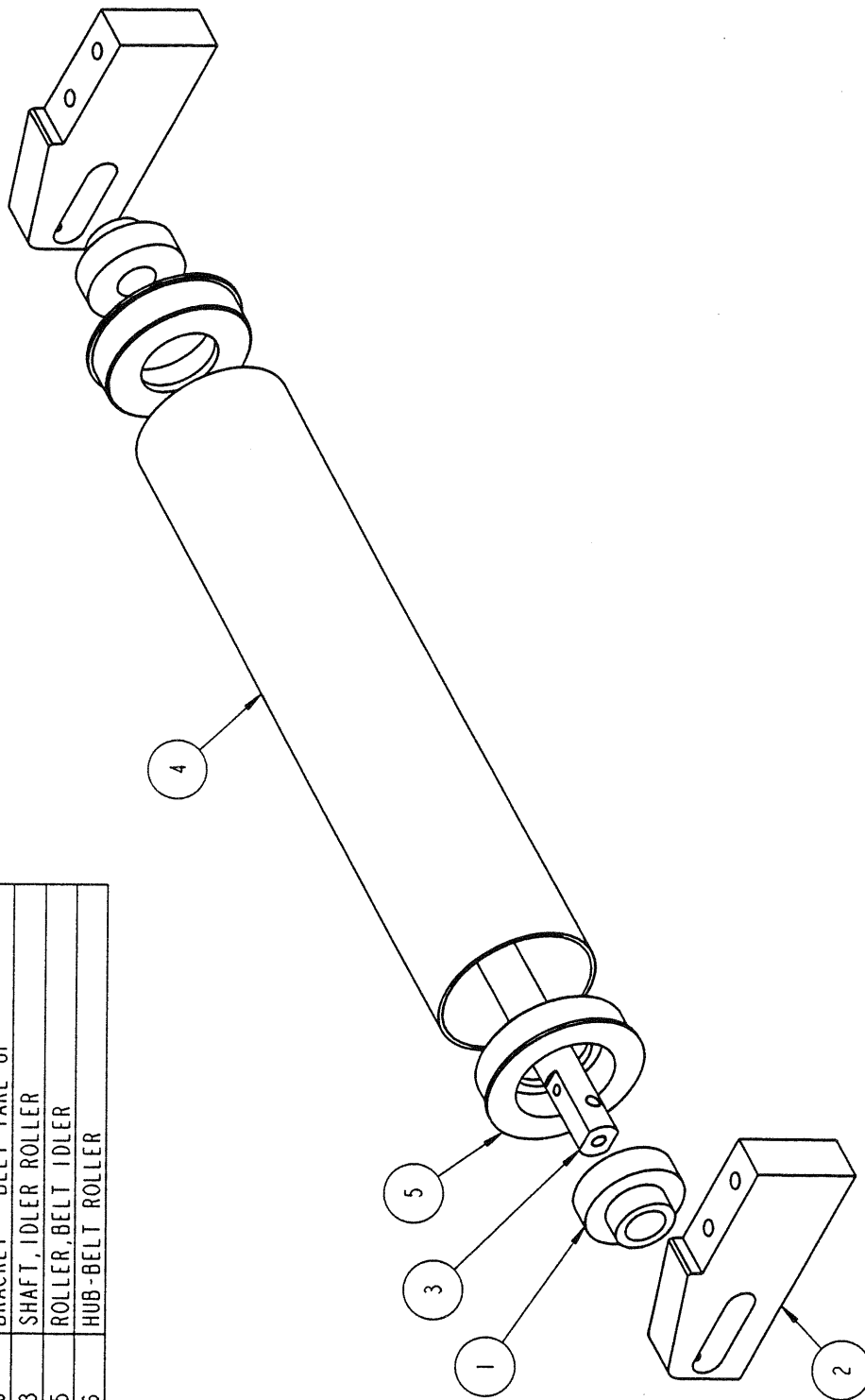
KIRK - RUDY, INC.
KENNESAW, GEORGIA

ASSY, 36 IN FRAME EXT

536479-02

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2	2	500716	BRACKET - BELT TAKE-UP
3	1	500823	SHAFT, IDLER ROLLER
4	1	500835	ROLLER, BELT IDLER
5	2	500836	HUB-BELT ROLLER

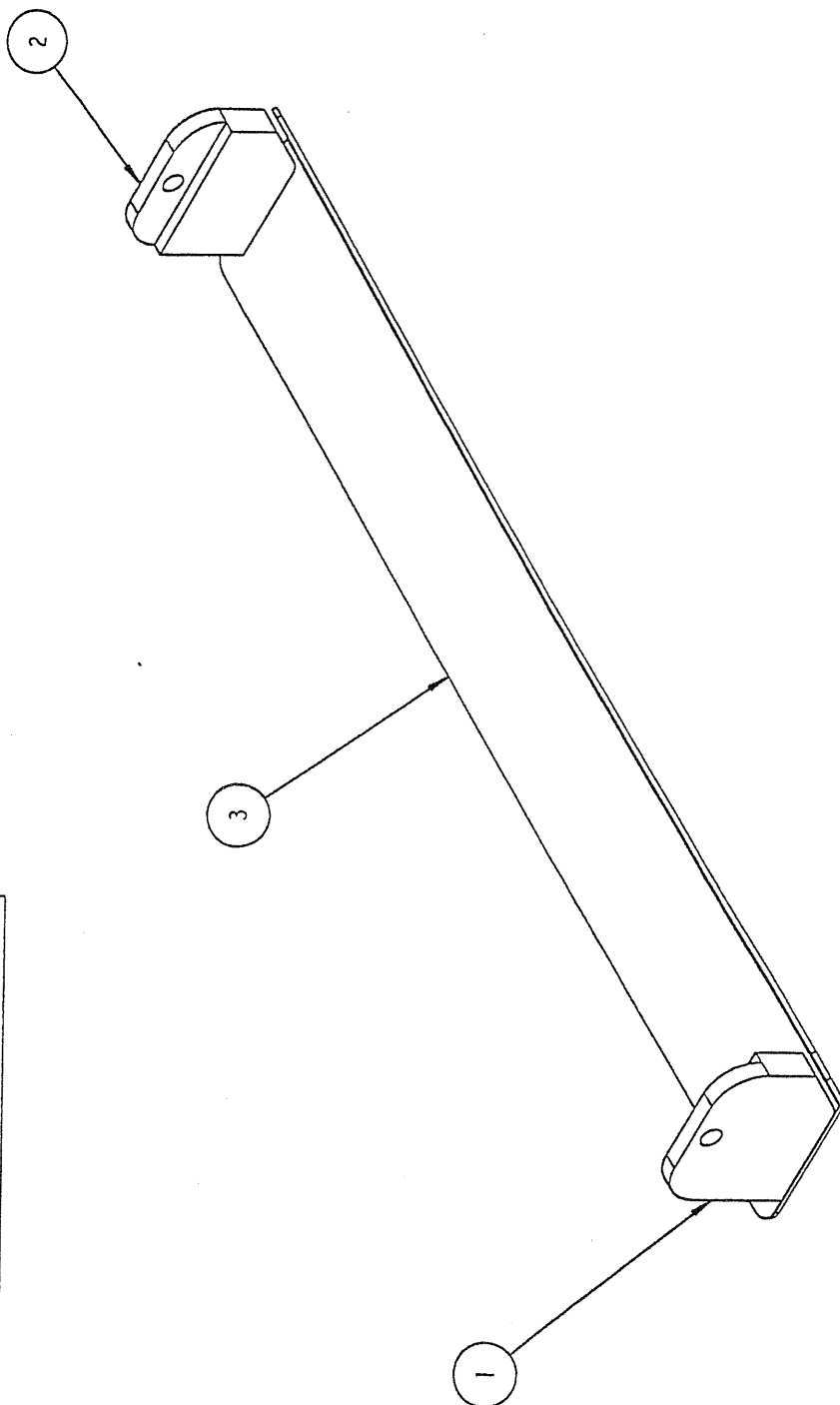


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THIRD ANGLE PROJECTION	THIRD ANGLE PROJECTION
MODEL SP71700	MODEL SP71700
SHEET NO 1 OF 1	SHEET NO 1 OF 1
TITLE ASSY, IDLER ROLLER	TITLE ASSY, IDLER ROLLER
DRAWING 1	DRAWING 1
530619-01	530619-01

DRAWN BY: A KEY	SCALE 0.410	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	MATERIAL: N/A	THIRD ANGLE PROJECTION	PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE QUOTED OR REPRODUCED WITHOUT THE WRITTEN PERMISSION OF KIRK-RUDY, INC. KENNESAW, GA 30144 USA	REQ'D	WHERE USED
CHECKED BY:	DATE 01-Mar-99	II .01	III .005	IV .5	ANG.	SP71700	SP71700
TRACED BY:	MASTER	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED		HEAT TREAT: N/A	FINISH: N/A	530619-01	530619-01

ITEM	QTY	PART #	DESCRIPTION
1	1	530816-01	BRKT, RH OUTFD RLLR GRD
2	1	530817-01	BRKT, LH OUTFD ROLLER GRD
3	1	530818-01	GUARD, OUTFEED ROLLER

REV	NO	DATE	DESCRIPTION	ECN	NO	BY
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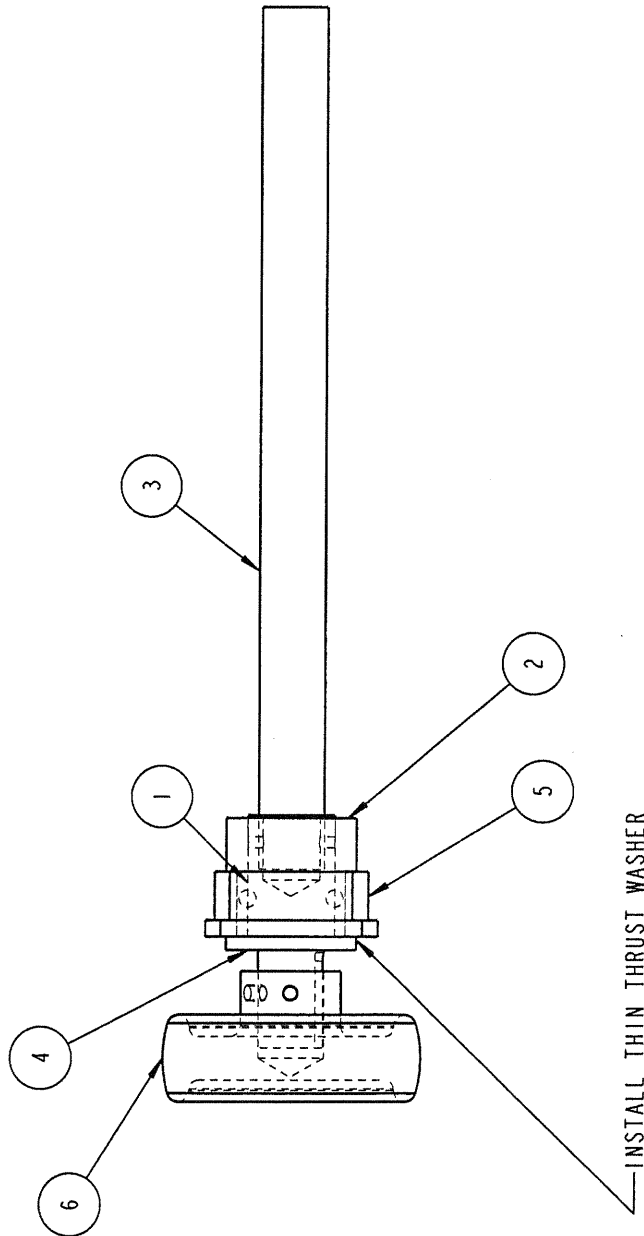


DRAWN BY: TJG	SCALE	0.500	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	.XX		.XX	ANG.	MATERIAL:	THIRD ANGLE PROJECTION		PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE QUOTED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC. KENNESAW, GA 30144 USA	KIRK - RUDY, INC. KENNESAW, GEORGIA	1	532078-01
	CHECKED BY:	DATE		6-Feb-98	REC'D	WHERE USED								
TRACED BY:	DATE	6-Feb-98	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED	.01		.005	.5	HEAT TREAT:	MODEL:	215	TITLE:	ASSY, OUTFD SAFETY COVER	532712-01	
MASTER			ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY		NOTED		FINISH:		10F1		DRAWING 9			

532736-01

ITEM	QTY	PART #	DESCRIPTION
1	1	100257	BUSHING, SLI.0001DI.2500D.750LG
2	1	102217	COLLAR 1.000
3	1	503734	THREADED ROD, 3/4-10
4	1	503736	HUB
5	1	532737-01	BLOCK, ROD MOUNT
6	1	533006-01	HANDWHEEL, W/ KR LOGO

REV NO	DATE	DESCRIPTION	ECN NO	BY
1	10-JUN-98	REPLACED 532127-01 WITH 503734	6349	MY
2	10-JAN-02	REPLACED 100326 WITH 100257	6780	RSH

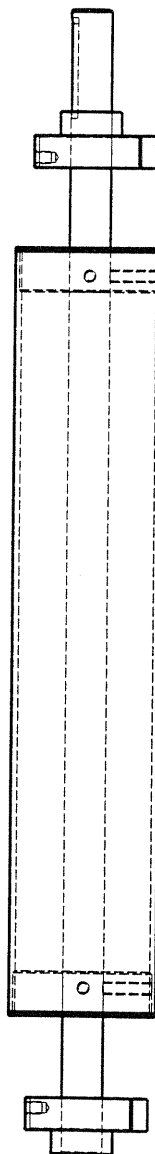
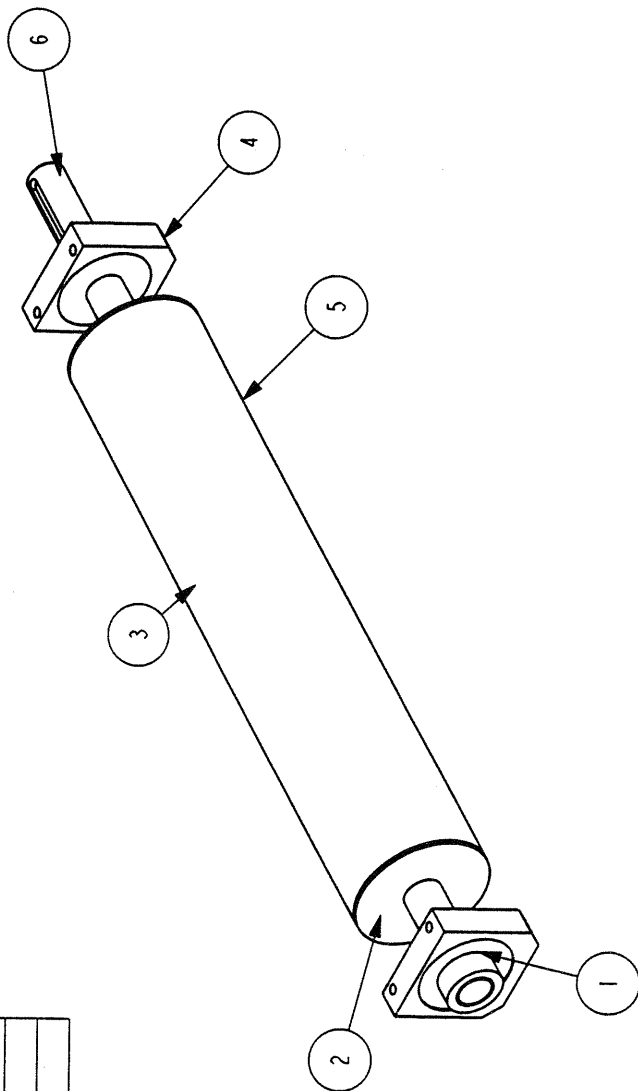


—INSTALL THIN THRUST WASHER


DRAWN BY: TJG	SCALE 0.500	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED .XX .XXX ANG. .01 .005 .5	MATERIAL: NOTED	THIRD ANGLE PROJECTION 	PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE QUOTED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK - RUDY, INC. KENNESAW, GA 30144 USA	KIRK - RUDY, INC. KENNESAW, GEORGIA	1 532734-01 REQ'D WHERE USED
CHECKED BY:	DATE 20-Feb-98	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY	HEAT TREAT: NONE	MODEL SP62500	TITLE: ASSY, SCREW HOUSING		
TRACED BY:	MASTER M		FINISH: NOTED	SHEET NO. 1 OF 1	DRAWING 1 532736-01		

ITEM	QTY	PART #	DESCRIPTION
1	2	103804	BEARING - HUB
2	2	500839	HUB-BELT DRIVE
3	1	500742-4	ROLLER - TUBE BELT DRIVE
4	2	500819-1	BLOCK-BEARING
5	1	530676-01	ROLLER ASY
6	1	534181-02	SHAFT, FRONT ROLLER

REV NO	DATE	DESCRIPTION	ECN NO	BY
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1	536471-01
REV'D	WHERE USED

 KIRK - RUDY, INC. KENNESAW, GEORGIA	PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE QUOTED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC. KENNESAW, GA 30144 USA
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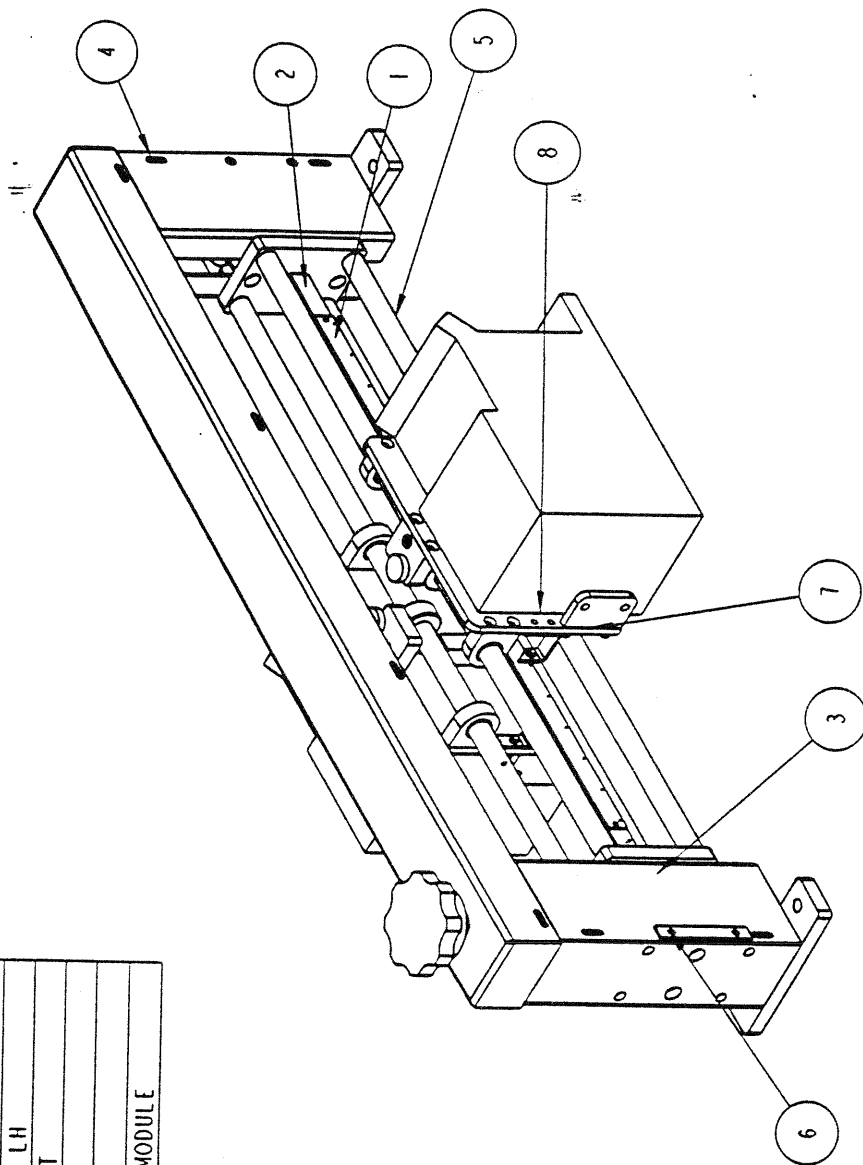
TITLE:	ASSY, DRIVE ROLLER DRYER
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DRAWING #	536467-01
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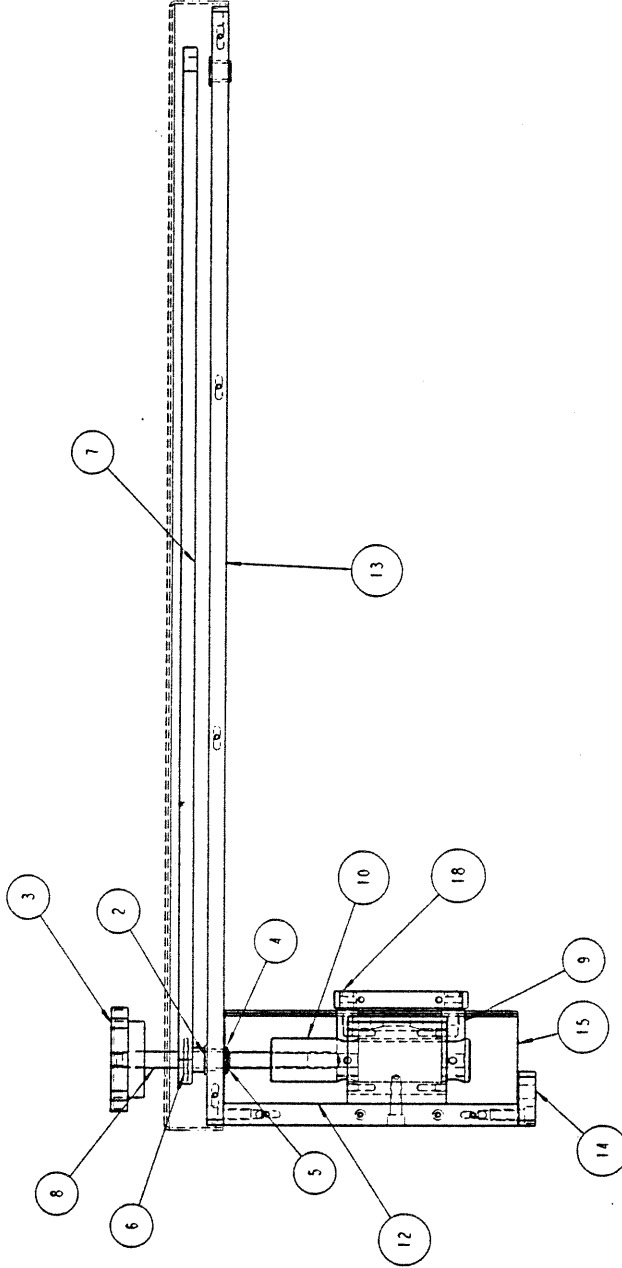
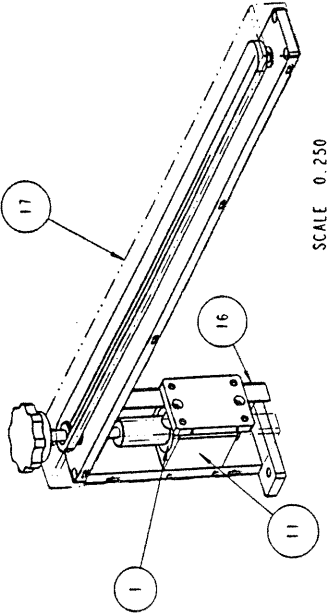
DRAWN BY: TJG	SCALE 0.375	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED			MATERIAL: N/A	THIRD ANGLE PROJECTION 
		.XX .01	.XX .005	ANG. .5		
CHECKED BY:	DATE 27-Aug-99	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED			HEAT TREAT: N/A	MODEL: SP76500
TRACED BY:	MASTER M	ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY			FINISH: N/A	SHEET NO: 10F1

ITEM	QTY	PART #	DESCRIPTION
1	2	190771	SCALE, CENTER ZERO
2	1	531678-02	BAR, SCALE SUPPORT
3	1	538153-01	ASSY, VERTICAL ADJ. RH
4	1	538153-02	ASSY, VERTICAL ADJ. LH
5	4	538168-01	SHAFT, HEAD SUPPORT
6	2	538178-01	STRAP, RIBBON CLAMP
7	2	538269-01	ASSY, INKJET MOUNT
8	2	BRYCE-INKJET	BRYCE, INKJET HEAD MODULE

REV NO	DATE	DESCRIPTION	ECN NO	BY
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[illegible]

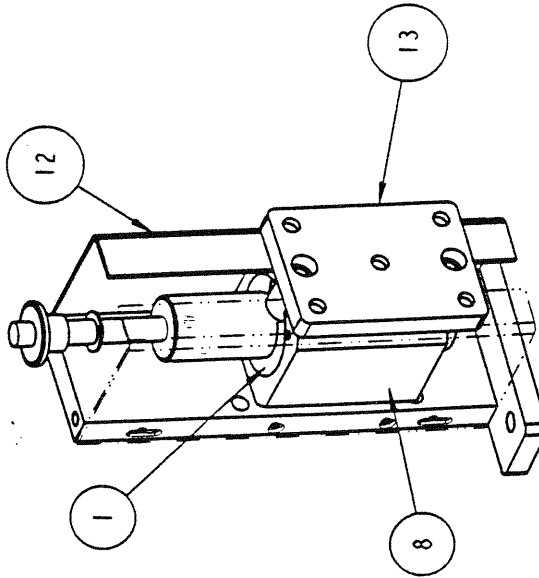
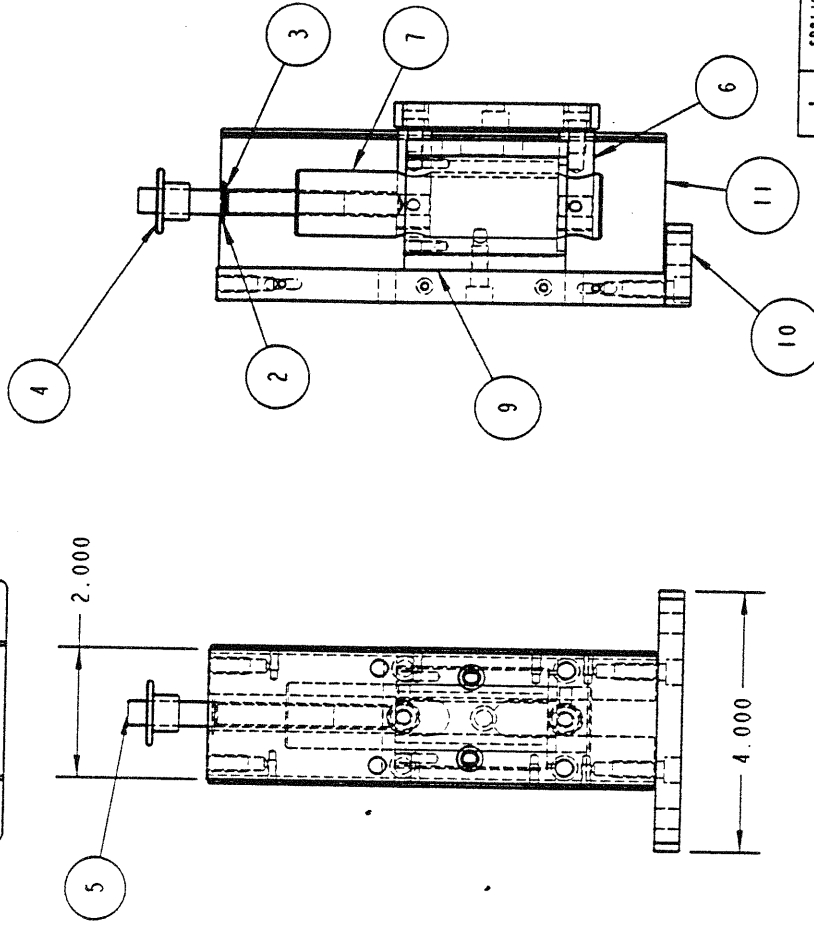
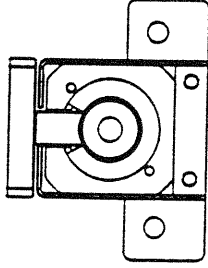
ITEM	QTY	PART #	DESCRIPTION
1	1	100251	BEARING, LINEAR SLEEVE OPEN
2	1	100306	BUSHING, FL 375ID. 500OD. 500LG
3	1	102112	KNOB, PURCHASED
4	1	102306	SHIM, .375X.625X.031
5	1	104100	SHAPRING, .375
6	1	110163	SPRKT, 25811 .375B MK
7	1	110021-17	CHAIN, NO. 25 X 47.5 IN.
8	1	500341-2	SHAFT, LIFT
9	2	538146-01	SHAFT, BRACKET SUPPORT
10	1	538147-01	SHAFT, VERTICAL SUPPORT
11	1	538149-01	HOUSING, LINEAR BEARING
12	1	538150-01	PLATE, VERTICAL MOUNT
13	1	538151-01	PLATE, SCREW SUPPORT
14	1	538152-01	PLATE, BOTTOM SUPPORT
15	1	538154-01	COVER, LINEAR SLIDE RH
16	1	538154-02	COVER, LINEAR SLIDE LH
17	1	538155-01	COVER, CHAIN
18	1	538167-01	PLATE, SHAFT SUPPORT



REV NO	DATE	DESCRIPTION	ECN NO	BY
538153-01				
KIRK - RUDY, INC. KENNESAW, GEORGIA				
PROPERTIES AND CONFIDENTIALITY MAY BE OBTAINED BY REQUESTING INFORMATION FROM THE OFFICE OF THE ATTORNEY GENERAL OF THE STATE OF GEORGIA			REC'D WHERE USED 1 538153-01	
THIRD ANGLE PROJECTION 			TYPE SP81400	
DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED .0005 .001 .002 .003 .005 .010 .015 .020 .030 .040 .050 .060 .070 .080 .090 .100 .125 .150 .175 .200 .250 .300 .375 .500 .625 .750 .875 1.000 1.250 1.500 1.750 2.000 2.500 3.000 3.750 4.000 5.000 6.000 7.000 8.000 10.000 12.000 15.000 20.000 25.000 30.000 37.500 40.000 50.000 60.000 75.000 100.000 125.000 150.000 200.000 250.000 300.000 375.000 500.000 600.000 750.000 1000.000			DATE 10-Jan-00	
SCALE 0.375			WORKING XXX	
CHECKED BY T.J.G.			DATE 10-Jan-00	
DRAWN BY T.J.G.			DATE 10-Jan-00	
MASTER M			TYPE XXX	
ALL DIMENSIONS ARE FINISHED DIMENSIONS UNLESS OTHERWISE NOTED			TYPE XXX	
DO NOT SCALE - WORK TO DIMENSIONS ONLY			TYPE XXX	
SHEET NO. 1 OF 1			538153-01	

538153-02

ITEM	QTY	PART #	DESCRIPTION
1	1	100251	BEARING, LINEAR SLEEVE OPEN
2	1	102306	SHIM, .375X.625X.031
3	1	104100	SNAPRING, .375
4	1	110163	SPRKT, 25B11 .375B NK
5	1	500341-1	SHAFT, LIFT
6	2	538146-01	SHAFT, BRACKET SUPPORT
7	1	538147-01	SHAFT, VERTICAL SUPPORT
8	1	538149-01	HOUSING, LINEAR BEARING
9	1	538150-01	PLATE, VERTICAL MOUNT
10	1	538152-01	PLATE, BOTTOM SUPPORT
11	1	538154-01	COVER, LINEAR SLIDE RH
12	1	538154-02	COVER, LINEAR SLIDE LH
13	1	538167-01	PLATE, SHAFT SUPPORT



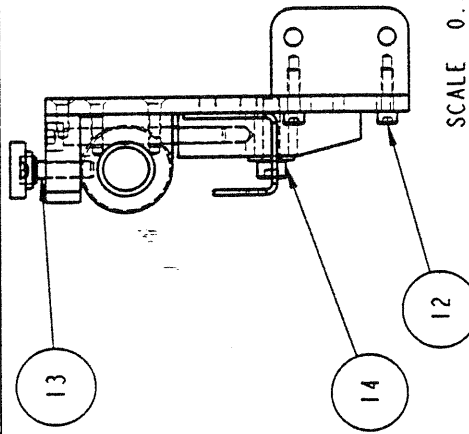
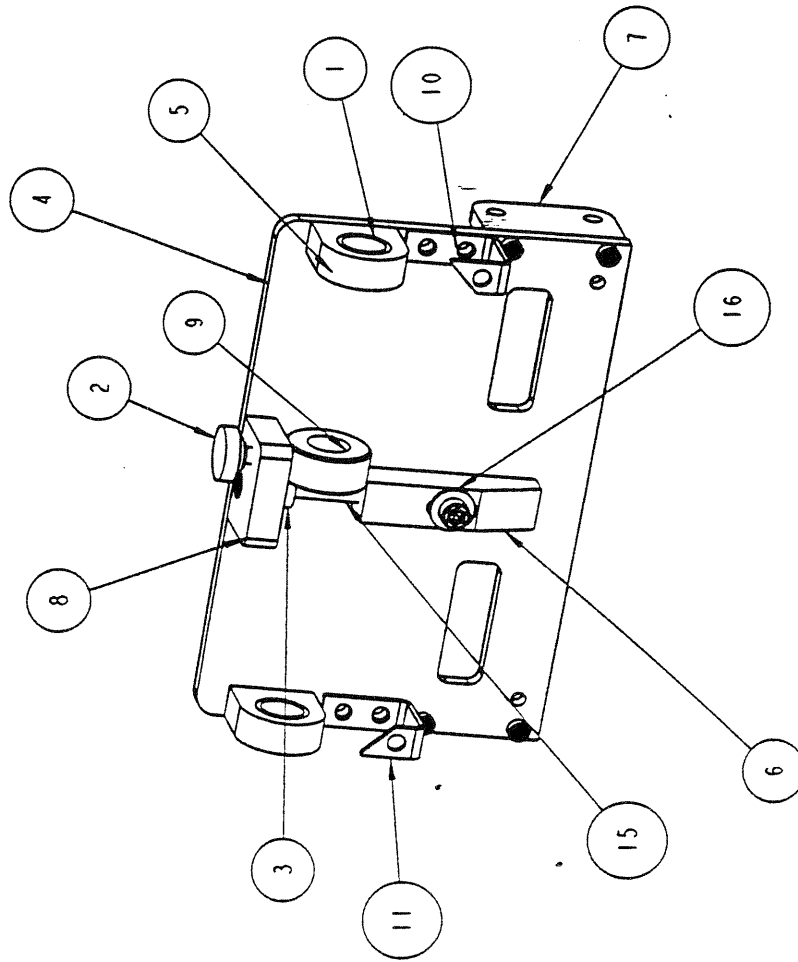
SCALE 0.375

DATE BY: TJG	SCALE: 0.375	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	MATERIAL: XXX	THIRD ANGLE PROJECTION	PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE QUOTED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC. KENNESAW, GA 30144 USA	REC'D: 1	WHERE USED: SP81400
CHECKED BY:	DATE: 10-Jan-00	.XX .01 .005 .003 .5	HEAT TREAT: XXX				
TRACED BY: M		REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED	FINISH: XXX				
ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY				TITLE: ASSY, VERTICAL ADJ. LH		DRAWING 1	
				SHEET NO: 10F1		538153-02	

KIRK - RUDY, INC.
KENNESAW, GEORGIA

ITEM	QTY	PART #	DESCRIPTION	REV NO	DATE	ECN NO	BY
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1	2	100133	BUSHING, SL 500ID.625OD.375LG
2	1	102132	KNOB, 10-32 CAP SCREW
3	1	102210	COLLAR .188
4	1	538270-01	PLATE, VERTICAL INKJET MNT.
5	2	538271-01	BLOCK, BUSHING MOUNT
6	1	538273-01	CAM, INKJET LEVEL
7	2	538277-01	PLATE, INKJET HEAD MOUNT
8	1	538280-01	BLOCK, SLIDE LOCK
9	1	538300-01	COLLAR, SLED LOCK
10	1	538305-01	INDICATOR, SCALE RH
11	1	538305-02	INDICATOR, SCALE LH
12	4	CSDD210	
13	1	CSDD266	
14	1	CSDD267	
15	1	CSDD272	
16	1	WA006	WASHER



SCALE 0.500

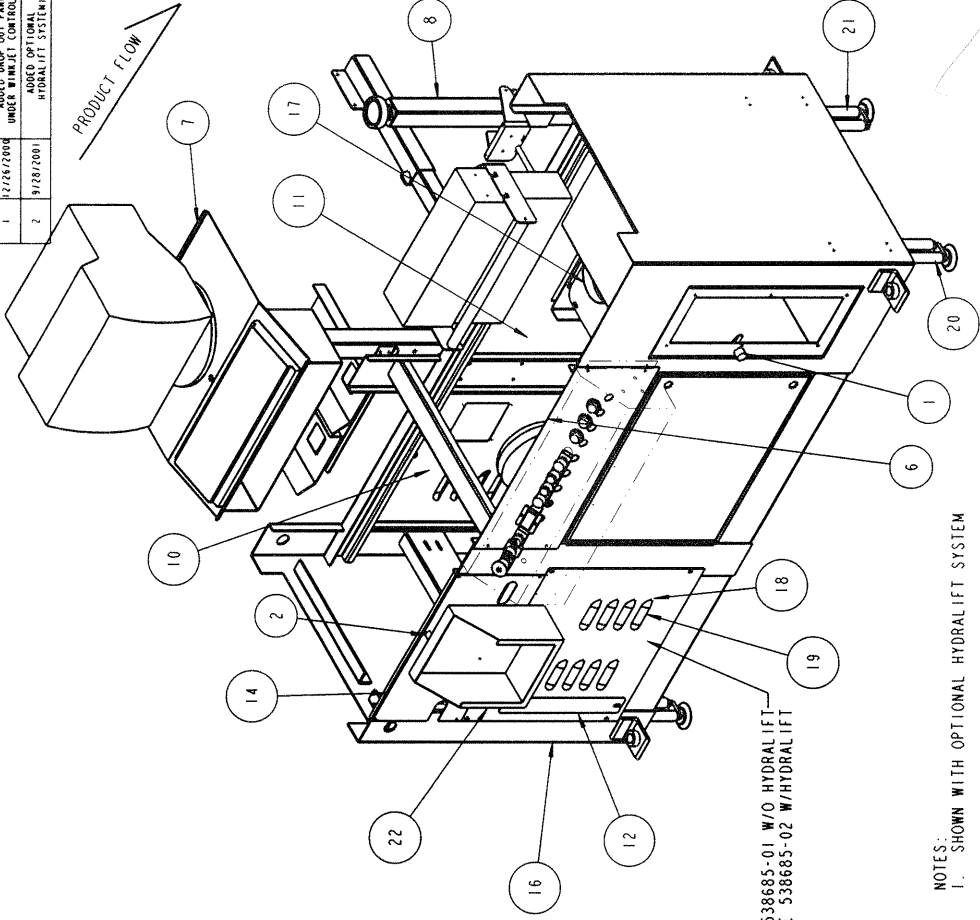
2	538169-01
REV'D	WHERE USED

DATE BY: TJG	SCALE 0.500	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	MATERIAL:	THIRD ANGLE PROJECTION	PROPRIETARY AND CONFIDENTIAL NO PART OF THIS DOCUMENT MAY BE COPIED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC. KENNESAW, GA 30144 USA	KIRK - RUDY, INC. KENNESAW, GEORGIA	538169-01
CHECKED BY:	DATE 18-Feb-00	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED	HEAT TREAT:	MODEL SP81400	TITLE: ASSY, INKJET MOUNT		
TRACED BY:	MASTER M	ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY	FINISH:	SHEET NO. 10F2	DRAWING 8	538269-01	

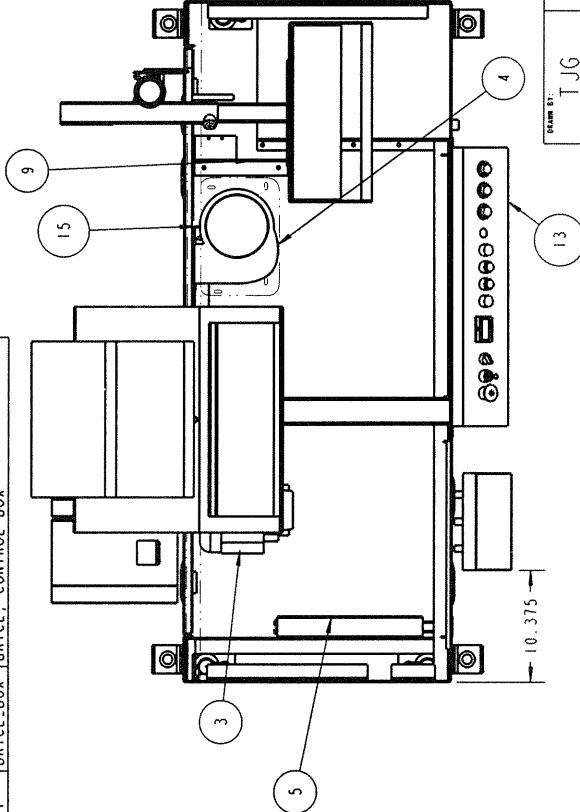
ITEM QTY	PART #	DESCRIPTION
1	102143	KNOB, CABINET LATCH
2	102359	SPACER, .250X.625X.750
3	100120	BLOWER, FAN
4	200129	BLOWER, FAN
5	191029-1	PUMP, MOVOTEC PB4612FC
6	530865-02	PANEL, ELECTRICAL
7	532152-02	ASSY. MONITOR STAND W/ 2 TRAY
8	533331-01	ASSY. DRYER MOUNT
9	533823-01	WELDMENT, ELECTRICAL BOX
10	536445-07	DOOR, REAR DROP OUT
11	536492-05	DOOR, DRYER REAR
12	537344-02	COVER, LIFT KIT HOLE
13	538038-01	ASSY. 2191J CONTROL PANEL
14	538274-04	PANEL, FRONT CENTER
15	538284-01	BRACKET, BLOWER MOUNT
16	538285-04	WLDMNT, 2198 CABINET
17	538291-01	WLDMNT, AIR HOSE MNT.
18	538685-01	PANEL, FRONT INFEED 2198
19	538685-02	PANEL, FRONT 2198 W/HYDRA LIFT
20	539424-01	ASSY. RH HYDRA LIFT LEG
21	539425-01	ASSY. LH HYDRA LIFT LEG
22	1	BRYCE, BOX

REV NO	DATE	DESCRIPTION	ECN NO	BT
1	12/26/2008	ADDED DROP OUT PANEL UNDER WINDJET CONTROL BOX	5642	TJG
2	9/28/2001	ADDED OPTIONAL HYDRA LIFT SYSTEM	6738	TJG

PRODUCT FLOW



USE 538685-01 W/O HYDRA LIFT
USE 538685-02 W/HYDRA LIFT



SCALE 0.090

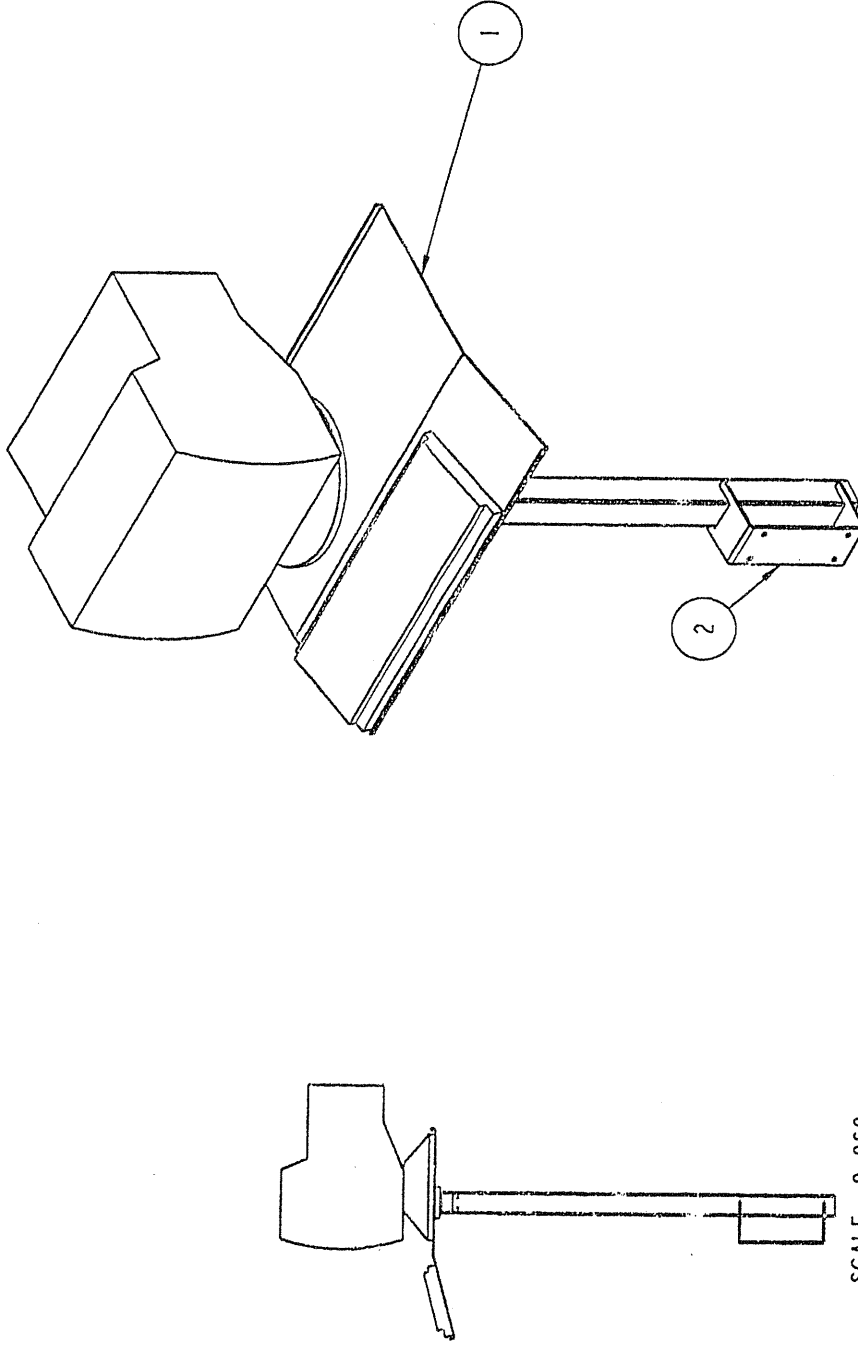
NOTES:
1. SHOWN WITH OPTIONAL HYDRA LIFT SYSTEM

NAME BY: TJG	SCALE: 0.090	DATE: 15-Aug-00	CHECKED BY:	TRACED BY:
<p>UNLESS OTHERWISE SPECIFIED, DIMENSIONS ARE IN INCHES. DECIMAL DIMENSIONS ARE TO NEAREST 0.001. FRACTIONAL DIMENSIONS ARE TO NEAREST 1/16. ALL DIMENSIONS ARE FINISHED DIMENSIONS. DO NOT SCALE. WORK TO DIMENSIONS ONLY.</p>				
<p>THIRD ANGLE PROJECTION</p>		<p>WINDJET PRODUCTION</p>		
<p>RESPONSE LIST AND COST ESTIMATE MAY BE QUOTED OR REPRODUCED WITHOUT THE WRITTEN PERMISSION OF KIRK - RUDY, INC. KENNESAW, GA 30144 USA</p>		<p>KIRK - RUDY, INC. KENNESAW, GEORGIA</p>		
<p>SP85900</p>		<p>ASSY, CABINET & COVERS</p>		
<p>10F3</p>		<p>538288-04</p>		

532152-02

ITEM	QTY	PART #	DESCRIPTION
1	1	532155-02	ASSY, MONITOR PIVOT
2	1	536586-01	WLDMT, MONITOR STAND

REV NO	DATE	DESCRIPTION	ECN NO	BY
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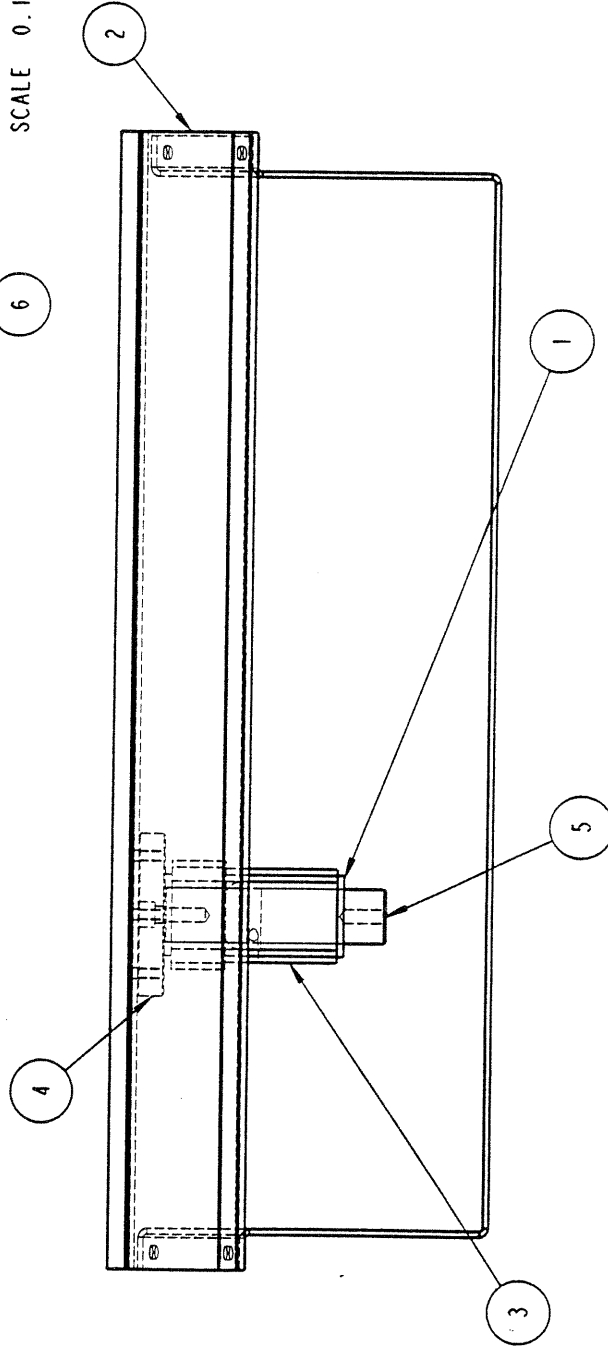
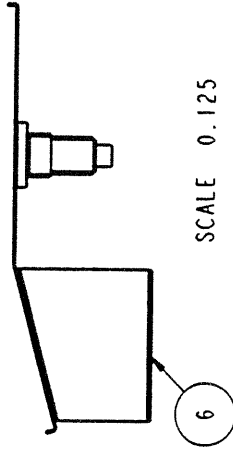
SCALE 0.060

DATE BY: TJG	SCALE: 0.100	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	MATERIAL: NOTED	TRITD ANGLE PROJECTION	PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE COPIED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC. KENNESAW, GA 30144 USA	1 SP76500
CHECKED BY:	DATE: 27-Aug-99	.XX .01 .XX .005 .XX .5	HEAT TREAT: NONE		KIRK - RUDY, INC. KENNESAW, GEORGIA	REC'D WHERE USED
TRACED BY:	MASTER: M	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED				
		ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY			ASSY, OPERATOR INTERFACE	
						532152-02

532155-02

ITEM	QTY	PART #	DESCRIPTION
1	2	100338	BUSHING, FLI .0001DI .2500DI .500LG
2	1	532128-02	TRAY, KEYBOARD
3	1	532154-01	HOUSING, PIVOT
4	1	532157-01	SPACER, PIVOT
5	1	532467-01	SHAFT, DRYER PIVOT
6	1	538343-01	TRAY, MOUSE PAD

REV NO	DATE	DESCRIPTION	ECN NO	BY
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1	532152-02
REV'D	WHERE USED

KIRK - RUDY, INC.
KENNESAW, GEORGIA

PROPRIETARY AND CONFIDENTIAL
NO PORTION OF THIS DRAWING
MAY BE QUOTED OR REPRODUCED
IN ANY FORM WITHOUT THE
EXPRESS WRITTEN PERMISSION
OF KIRK-RUDY, INC.
KENNESAW, GA 30144 USA

THIRD ANGLE PROJECTION

 MODEL: SP76500
 SHEET NO: 1 OF 1

NOTED
XXX
NOTED

MATERIAL:
HEAT TREAT:
FINISH:

DIMENSIONAL TOLERANCES
UNLESS OTHERWISE NOTED

XX	.XX	ANG.
.01	.005	.5

 REMOVE ALL BURRS AND
SHARP EDGES UNLESS
OTHERWISE NOTED
 ALL DIMENSIONS ARE
FINISHED DIMENSIONS
DO NOT SCALE - WORK
TO DIMENSIONS ONLY

SCALE: 0.312
DATE: 26-Aug-99
MASTER: M

DRAWN BY: TJG
CHECKED BY:
TRACED BY:

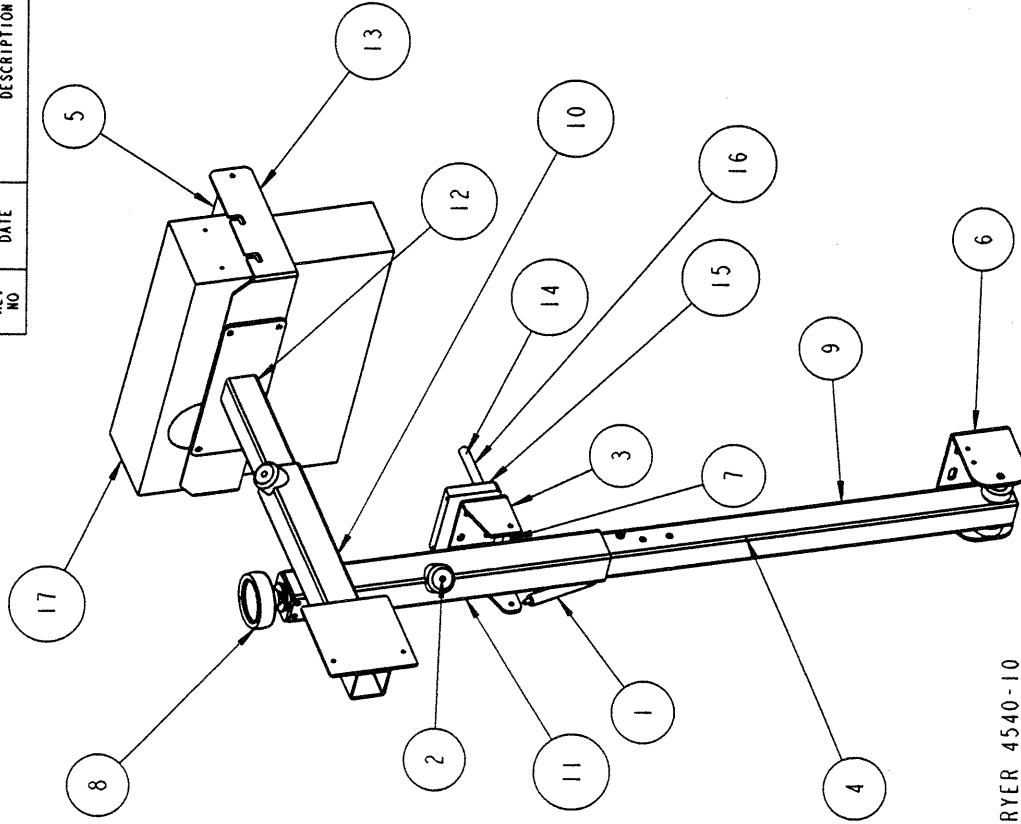
ASSY, MONITOR PIVOT
DRAWING 3

532155-02

533331-01

ITEM	QTY	PART #	DESCRIPTION
1	1	190804	GAS SPRING
2	1	532129-01	BLOCK, LOCK DOWN
3	1	532452-01	BRACKET, GAS SHOCK
4	1	532453-01	GAS SHOCK LINKAGE
5	1	532464-01	SHAFT, DRYER HANDLE
6	1	532466-01	ASSY, DRYER ARM PIVOT
7	1	532468-01	SHAFT, DRYER STOP
8	1	532736-01	ASSY, SCREW HOUSING
9	1	532738-01	WELD, TUBING DRYER STAND
10	1	532739-02	WELD, TUBING SLIDE
11	1	532741-01	TUBING, BASE
12	1	532744-02	WELD, TUBING IN/OUT ADJ.
13	1	533189-01	BRACKET, DRYER MOUNT
14	1	533190-01	ASSY, STOPPER MOUNT BRACKET
15	1	533191-01	PLATE, STOPPER MOUNT
16	1	533192-01	SHAFT, SPACER
17	1	RES4540-2	DRYER, RES. 4540-10

NOTE: DRYER BRACKET AND HANDLE SHOWN ARE FOR RESEARCH DRYER 4540-10
FOR 4540-05 DRYER USE BRACKET (532456-02) AND HANDLE (532464-02)

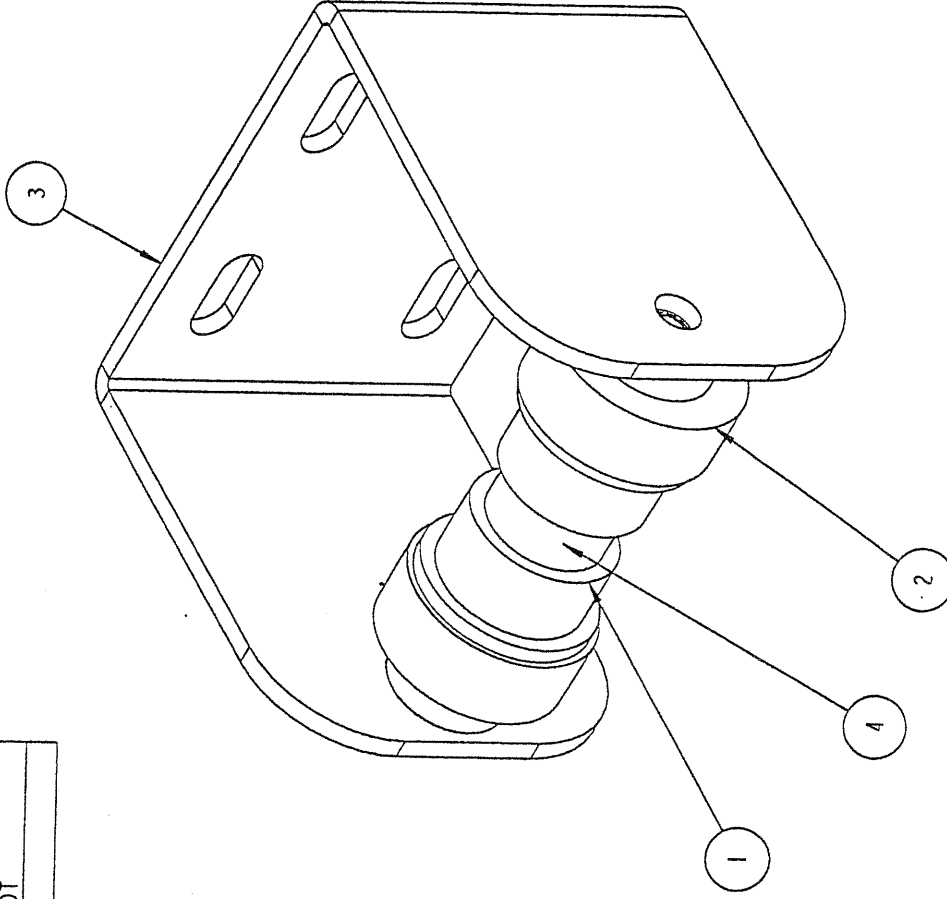


1	2191J
REC'D	WHERE USED

DRAWN BY: TJG	SCALE 0.110	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED XX .01 XX .005 ANG. .5	MATERIAL: NOTED	THIRD ANGLE PROJECTION 	PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC. KENNESAW, GA 30144 USA	KIRK - RUDY, INC. KENNESAW, GEORGIA	REC'D	WHERE USED
	CHECKED BY: DATE 20-Mar-98							
TRACED BY: MASTER M	DATE 20-Mar-98	HEAT TREAT: NONE		MODEL: 2191J	TITLE: ASSY, DRYER MOUNT	533331-01	DRAWING #	
DO NOT SCALE - WORK TO DIMENSIONS ONLY								

ITEM	QTY	PART #	DESCRIPTION
1	2	100326	BUSHING, FLANGE 1.000
2	2	102212	COLLAR 1.000
3	1	532465-01	BRACKET, DRYER ARM PIVOT
4	1	532467-01	SHAFT, DRYER PIVOT

REV	NO	DATE	DESCRIPTION	ECN	BY
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1	532134-01
REV'D	WHERE USED

THIRD ANGLE PROJECTION	PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE QUOTED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC. KENNESAW, GA 30144 USA	KIRK - RUDY, INC. KENNESAW, GEORGIA
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MODEL:	SP62500	TITLE:	ASSY, DRYER ARM PIVOT
SHEET NO.:	1 OF 1	DRAWING #	532466-01

DRAWN BY:	TJG	SCALE:	0.750	MATERIAL:	NOTED
CHECKED BY:		DATE:	20-Feb-98	HEAT TREAT:	NONE
TRACED BY:		MASTER:	M	FITISH:	NONE

DIMENSIONAL TOLERANCES
UNLESS OTHERWISE NOTED

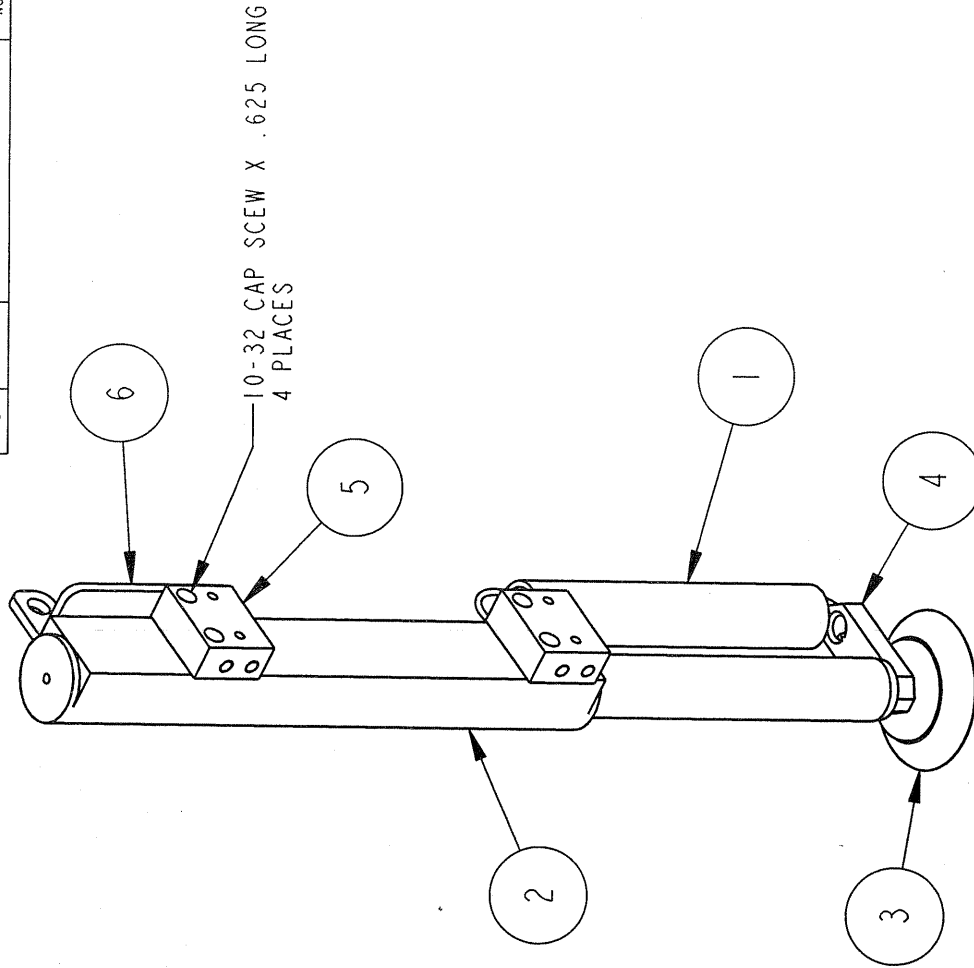
.2X	.1XX	ANG.
.01	.005	.5

REMOVE ALL BURRS AND
SHARP EDGES UNLESS
OTHERWISE NOTED


ALL DIMENSIONS ARE
FINISHED DIMENSIONS
DO NOT SCALE - WORK
TO DIMENSIONS ONLY


ITEM	QTY	PART #	DESCRIPTION
1	1	102792	SPRING, EXTENSION
2	1	191029-2	CYLINDER, LIFT CB415
3	1	191029-3	GLIDE, SUSPA
4	1	537371-01	BRACKET, SPRING RETURN MOUNT
5	2	537596-01	BLOCK, HYDRAULIC LIFT
6	1	537597-01	BRACKET, HYDRAULIC LIFT SPRING MNT

REV NO	DATE	DESCRIPTION	ECN NO	BY
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2	SP84700
REC'D	WHERE USED

PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE QUOTED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC. KENNESAW, GA 30144 USA	 KIRK - RUDY, INC. KENNESAW, GEORGIA
--	---

THIRD ANGLE PROJECTION	
MODEL:	SP84700
SHEET NO.:	1 OF 1

MATERIAL:	N/A
HEAT TREAT:	N/A
FINISH:	N/A

DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED		
.XX	.XX	ANG.
.01	.005	.5

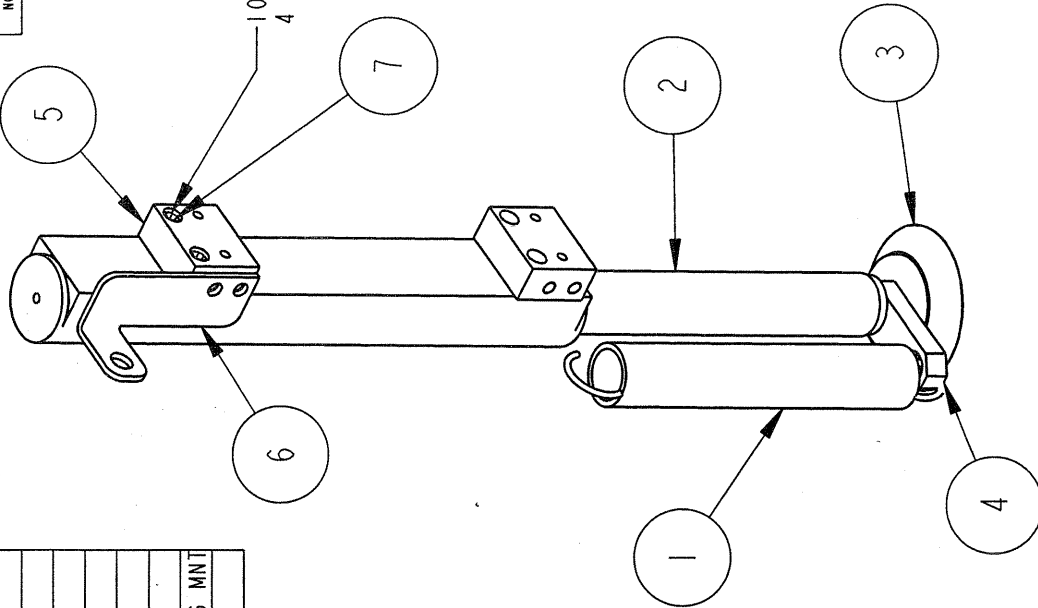
SCALE	0.375
DATE	26-Jul-00
MASTER	

DRAWN BY:	A KEY
CHECKED BY:	
TRACED BY:	

TITLE:	ASSY, RH HYDRAULIC LEG
DRAWING #	539424-01

ITEM	QTY	PART #	DESCRIPTION
1	1	102792	SPRING, EXTENSION
2	1	191029-2	CYLINDER, LIFT CB415
3	1	191029-3	GLIDE, SUSPA
4	1	537371-01	BRACKET, SPRING RETURN MOUNT
5	2	537596-01	BLOCK, HYDRAULIC LIFT
6	1	537597-02	BRACKET, HYDRAULIC LIFT SPRING MNT
7	2	CSDD266	

REV NO	DATE	DESCRIPTION	ECN NO	BY
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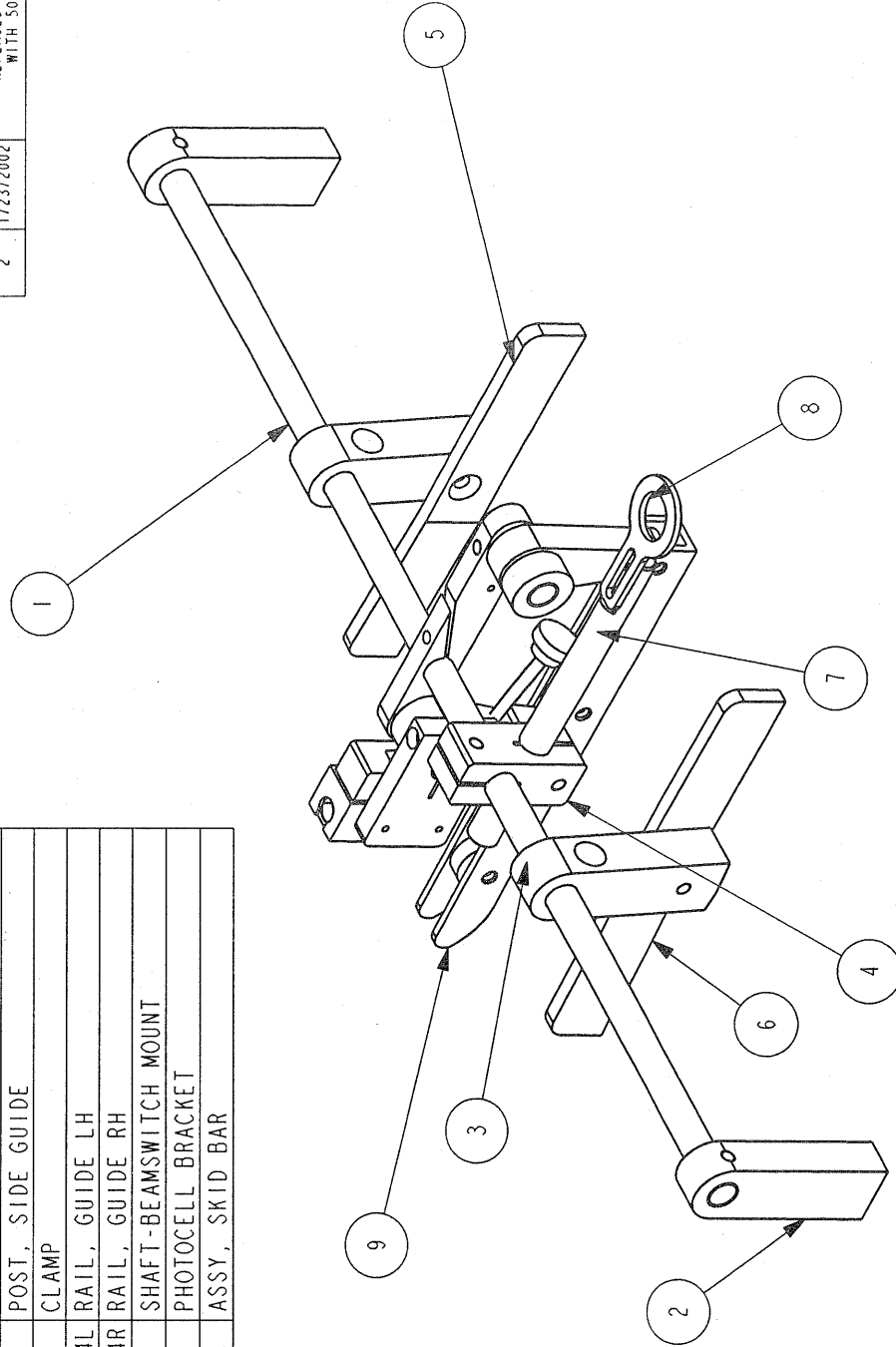


DRAWN BY: A KEY	SCALE 0.375	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED			MATERIAL: N/A	THIRD ANGLE PROJECTION 	 KIRK - RUDY, INC. KENNESAW, GEORGIA	PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE QUOTED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC. KENNESAW, GA 30144 USA	TITLE: ASSY, LH HYDRA LIFT LEG	DRAWING # 539425-01
		.XX .01	.XXX .005	ANG. .5						
CHECKED BY:	DATE 26-Jul-00	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED			HEAT TREAT: N/A	MODEL: SP84700				
TRACED BY:	MASTER 	ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY			FINISH: N/A	SHEET NO: 10F1				

538188-01

ITEM	QTY	PART #	DESCRIPTION
1	1	500787	SHAFT-SIDE GUIDE ADJ.
2	2	500791	POST, SIDE GUIDE
3	2	500792	POST, SIDE GUIDE
4	1	508593	CLAMP
5	1	500722-24L	RAIL, GUIDE LH
6	1	500722-24R	RAIL, GUIDE RH
7	1	508995-4	SHAFT-BEAMSWITCH MOUNT
8	1	508996-2	PHOTOCELL BRACKET
9	1	538021-01	ASSY, SKID BAR

REV NO	DATE	DESCRIPTION	ECN NO	BY
1	11/2/2001	REPLACED 508995-1 WITH 508995-4		TJG
2	1/23/2002	REPLACED 508996-4 WITH 508996-2		TJG



DRAWN BY: TJG	SCALE 0.375	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED		MATERIAL: N/A	THIRD ANGLE PROJECTION 	PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE QUOTED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC. KENNESAW, GA 30144 USA	KIRK - RUDY, INC. KENNESAW, GEORGIA	REQ'D I	WHERE USED 536491-02
	CHECKED BY: DATE 17-Jan-00	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED							
TRACED BY: MASTER	DATE 17-Jan-00		HEAT TREAT: N/A		TITLE: ASSY, SKIDBAR/SENSOR		SHEET NO.: 10F1		
538188-01			FINISH: N/A		MODEL: SP81400		DRAWING 1		

ITEM	QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	2	100162	BUSHING, SL.500ID.625OD.625LG					
2	1	102114	KNOB					
3	1	102205	COLLAR .500					
4	2	103107	BEARING, FLAT .312					
5	1	105201	PIN, ROLL .125X 1.000					
6	1	105602	SHAFT, THREADED 10-32					
7	1	190101	MICROSWITCH, LEVER					
8	1	190203	COVER, MICROSWITCH					
9	1	500800	LINK-SKID-FRONT					
10	1	500801	LINK-SKID-REAR					
11	1	500802	HOLDER-SKID SWITCH					
12	2	500834	SHAFT, SKID ROLLER					
13	1	503794	CLAMP					
14	1	190101A	ASSY-SWITCH WITH COVER					
15	1	500723-8	CHANNEL, SKID					
16	1	500800-A	ASSY, LINK					
17	1	500801A	ASSY, LINK					
18	1	500802A	ASSY, CLAMP					
19	2	500834A	ASSY, STUD WITH BEARING					
20	2	SP37359	SHAFT, SKID BAR SPACER					

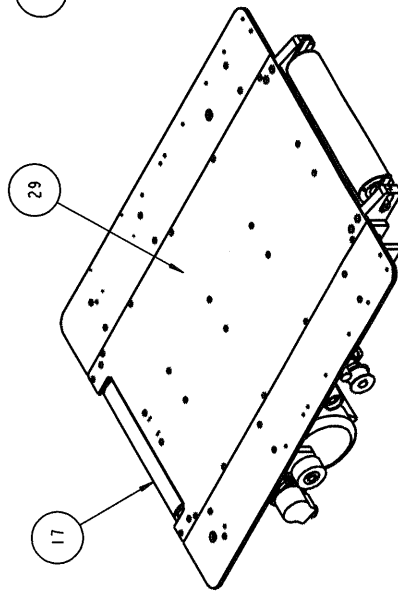
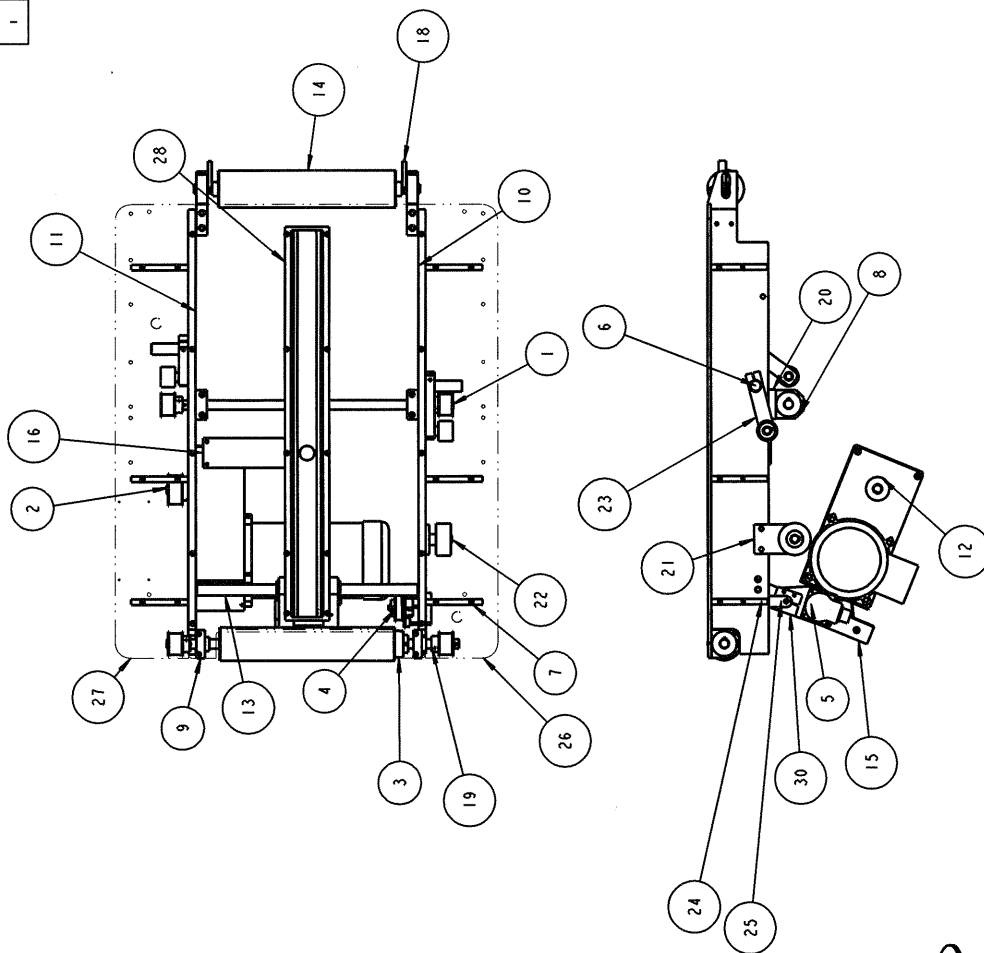
SCALE 0.500

REV NO	DATE	DESCRIPTION	ECN NO	BY
1	KR2191J20			
1	KR2191J			
REQ'D	WHERE USED			

KIRK - RUDY, INC. KENNESAW, GEORGIA	PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE QUOTED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC. KENNESAW, GA 30144 USA	THIRD ANGLE PROJECTION 	MODEL: 2191J	SHEET NO. 10FI	ASSY, SKID BAR	538021-01
	TITLE: DRAWING #					

REV NO	DATE	DESCRIPTION	ECN NO	BY
1	1/4/2002	REPLACED ENCODER MOUNT WITH SP45241-10	6774	TJG

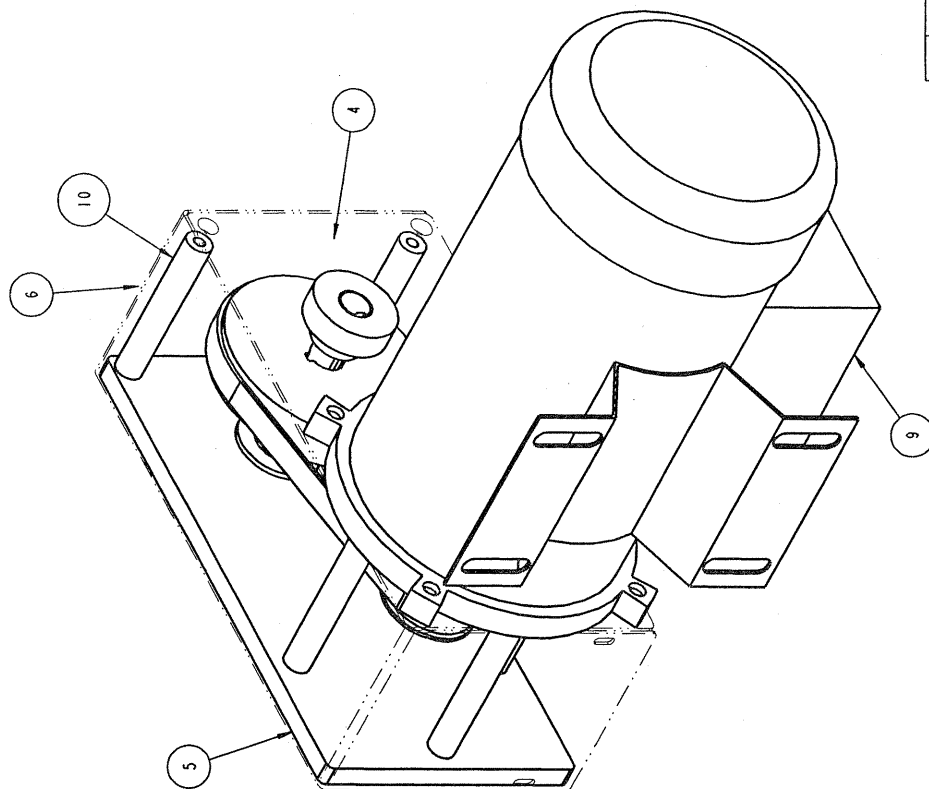
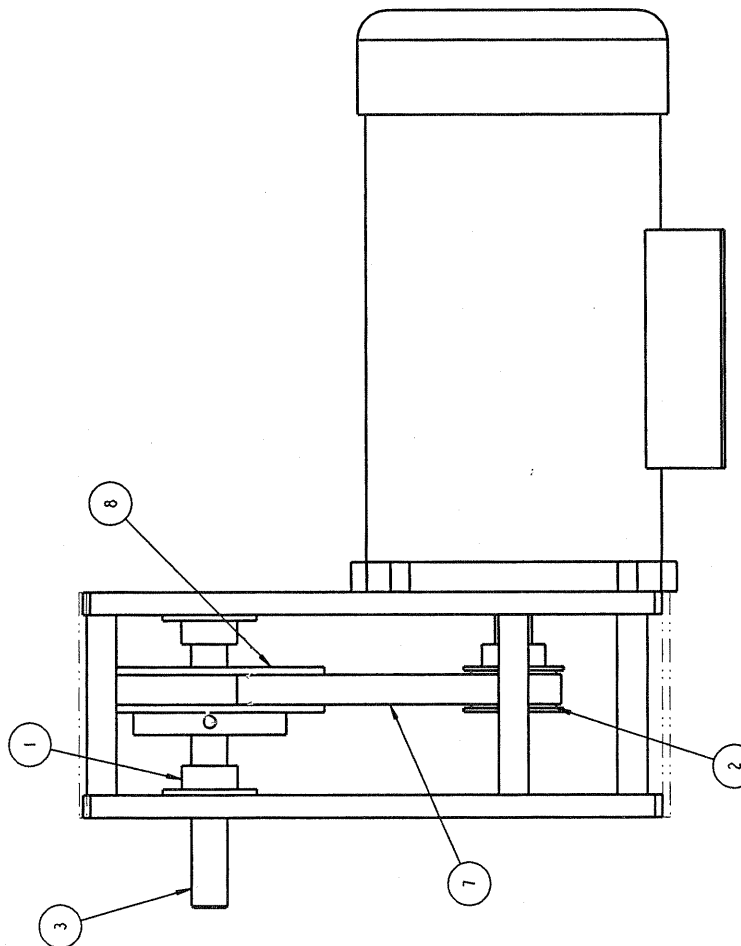
ITEM	QTY	PART #	DESCRIPTION
1	4	108809	PULLEY, TIMING 12L075 .625B .188K
2	1	108818	PULLEY, TIMING 16L075 .625B .188K
3	1	109847	PULLEY, 28X1037 .625B NK
4	1	109848	PULLEY, 26X1037 .375B NK
5	1	202492	ENCODER, DYNAPAR 1000PPR
6	2	525408	STUD, TAKEUP ARM
7	6	500721-1	GUSSET,CUTOUT
8	2	500819-1A	ASSY, BEARING LOCK
9	2	500819-2A	ASSY, BEARING LOCK
10	1	501201-3	FRAME, 219B RH
11	1	501202-3	FRAME, 219B LH
12	1	509000-8A	ASSY, MTR/REDUCER SR 1/2HP VERT
13	1	530519-01	SHAFT, MOTOR PIVOT
14	1	530619-01	ASSY, IDLER ROLLER
15	1	530654-01	ASSY, MOTOR MTG BAR
16	1	530656-01	ASSY, VACUUM MANIFOLD
17	1	530676-01	ROLLER ASY
18	2	533669-01	BLOCK, DEFLECTOR MOUNT
19	2	534181-01	SHAFT, FRONT ROLLER
20	2	534182-01	BLOCK, BEARING MOUNT
21	1	534184-01	PLATE, IDLER PULLEY
22	1	535077-01	ASSY, IDLER 18L075
23	2	536477-01	ASSY, TAKE UP TIMING BELT
24	1	537691-01	BAR, ENCODER STUD MNT.
25	1	538341-01	STUD, ENCODER MOUNT
26	2	538576-01	TABLETOP, SIDE 219B RH
27	2	538576-02	TABLETOP, SIDE 219B LH
28	1	SP30202	BLOCK, VACUUM
29	1	SP30201-1	TABLETOP 30.5 IN EXT. CANTER VA
30	1	SP45241-10	PLATE, ENCODER MOUNT



SCALE 0.125

NAME BY:	TJG	SCALE	0.125	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED				MATERIAL:	NOTED	THIRD ANGLE PROJECTION	PROFILES LAST AND LOW IDENTICAL MAY BE COPIED OR REPRODUCED WITHOUT PERMISSION OF KIRK - RUDY, INC. KIRK - RUDY, INC. KENSINGTON, VA 22044 USA	PROPERTY OF KIRK - RUDY, INC. KENNESAW, GEORGIA	I	SP85900	REC'D	WHERE USED
CHECKED BY:		DATE	15-Aug-00	BY	ALL DIMES	AND	5	WEAR TEAT:	NONE							
DRAWN BY:		MATTER		REMOVE ALL DIMES AND SHARP EDGES UNLESS NOTED OTHERWISE				FINISH:	NOTED	WALL SP85200	FINISH	ASSY, 219 SECTION				
<div style="display: flex; justify-content: space-between;"> SHEET NO. 538441-01 </div>																

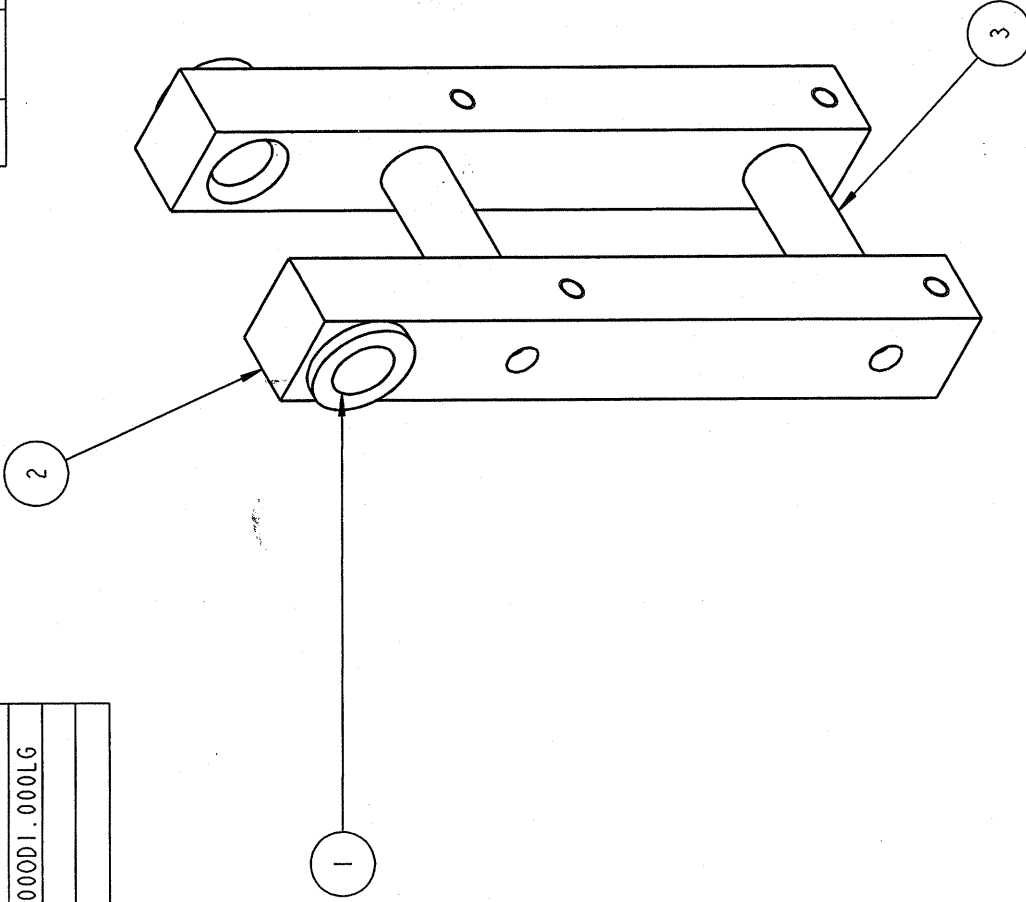
ITEM QTY	PART #	DESCRIPTION
1	2	103804 BEARING, HUB .625
2	1	108888 PULLEY, TIMING 12L050 .625B .188K
3	1	503619 SHAFT
4	1	509006 PLATE-REAR SIDE
5	1	509007 PLATE-GEARBOX 1/2 HP SINGLE RED
6	1	509037 COVER, REDUCER
7	1	108912-1 BELT, TIMING 187L050
8	1	109319-1 PULLEY, TIMING 32L050 .625B .188K
9	1	200152-2 MOTOR, LEESON DC 1/2HP
10	5	SP16208 SPACER, REDUCER



NAME BY: TJG	SCALE: 0.500	MATERIAL: N/A	THIRD ANGLE PROJECTION	FOR LIST AND FOR MATERIAL MAY BE QUOTED OR REPRODUCED WITHOUT PERMISSION OF THE COMPANY. EXPRESS WRITTEN PERMISSION REQUIRED. WOODSTOCK, GA 30188 USA	KIRK - RUDY, INC. WOODSTOCK, GEORGIA	REV NO	DATE	DESCRIPTION	ECR NO	BY
CHECKED BY:	DATE: 3-Nov-98	WALL THICK: NONE	GENERAL	100%	100%					
TRACED BY:	WATER: M	FINISH: N/A	100%	100%	100%					

ITEM	QTY	PART #	DESCRIPTION
1	2	100320	BUSHING, FL.7501D1.0000D1.000LG
2	2	530510-01	PIVOT BAR
3	2	530511-01	SPACER 3/4OD X 2L

REV NO	DATE	DESCRIPTION	ECN NO	BY
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I	GENERAL
REQ'D	WHERE USED

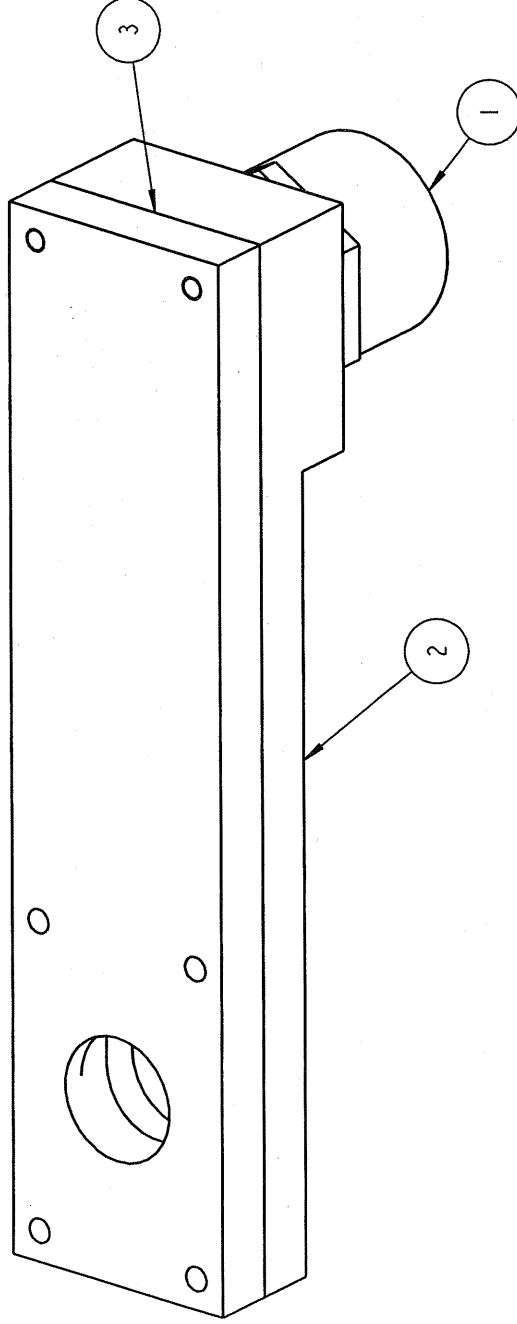
KIRK - RUDY, INC.
KENNESAW, GEORGIA

KR

PROPRIETARY AND CONFIDENTIAL
NO PORTION OF THIS DRAWING
MAY BE QUOTED OR REPRODUCED
IN ANY FORM WITHOUT THE
EXPRESS WRITTEN PERMISSION
OF KIRK-RUDY, INC.
KENNESAW, GA 30144, USA

27-Jul-01	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED	N/A	MODEL: GENERAL	TITLE: ASSY, MOTOR MTG BAR
MASTER	ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY	N/A	SHEET NO. 1 OF 1	DRAWING # 530654-01

ITEM	QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	1	190715	PVC COUPLING					
2	1	SP28217-1	BLOCK, LOWER VACUUM					
3	1	SP28218-1	BLOCK, UPPER VACUUM					

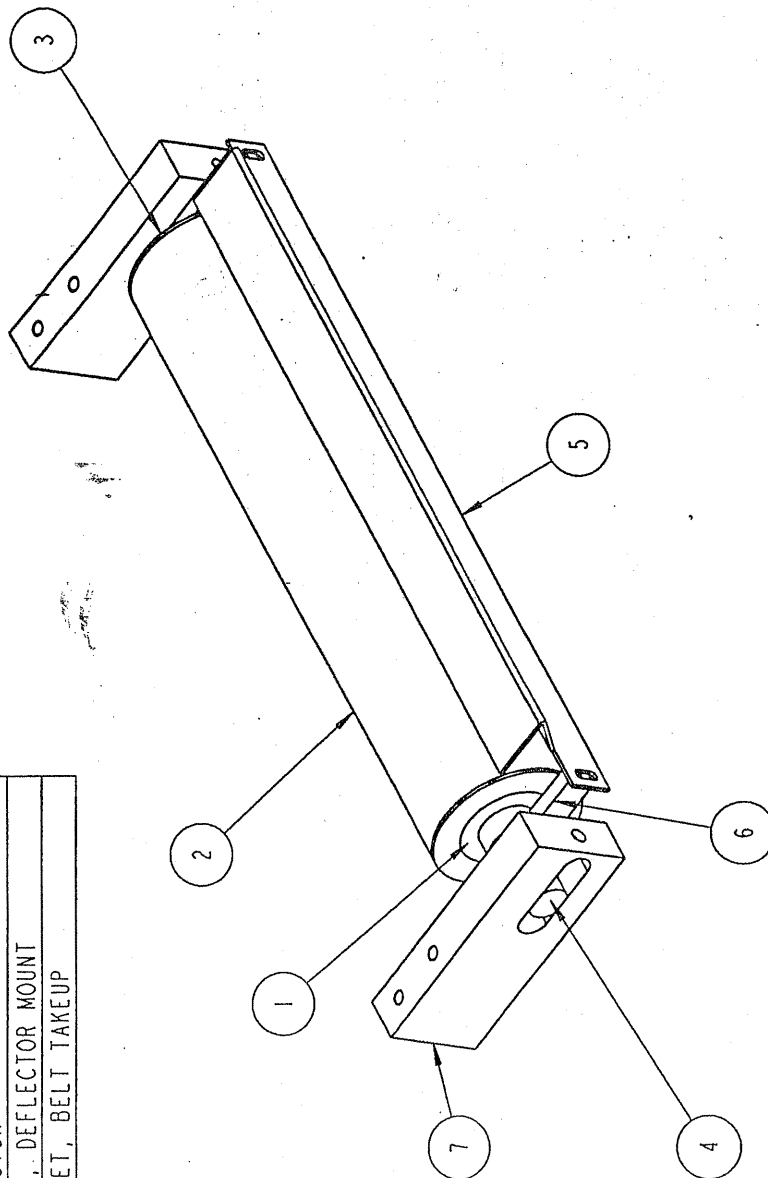


X	ALL
REQ'D	WHERE USED

DRAWN BY: RHM	SCALE 0.750	MATERIAL: NOTED	THIRD ANGLE PROJECTION 	PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE QUOTED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC. KENNESAW, GA 30144 USA	KIRK - RUDY, INC. KENNESAW, GEORGIA
CHECKED BY:	DATE 28-Jul-98	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED XX .01 .005 .5 ANG.	MODEL: 215	TITLE: ASSY, VACUUM MANIFOLD	
TRACED BY:	MASTER	HEAT TREAT: NONE	SHEET NO.: 10F1	DRAWING # 530656-01	

ITEM	QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECR NO	BY
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1	2	103804	BEARING - HUB					
2	1	500835	ROLLER					
3	2	500836	HUB					
4	1	500823-10	SHAFT, IDLER ROLLER					
5	1	533623-01	DEFLECTOR					
6	2	533669-01	BLOCK, DEFLECTOR MOUNT					
7	2	533975-01	BRACKET, BELT TAKEUP					

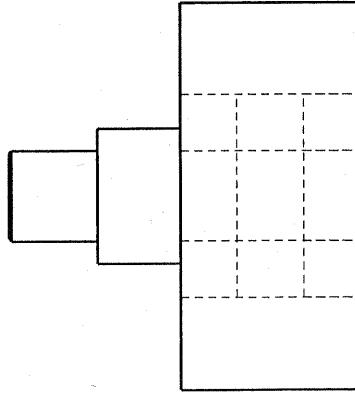
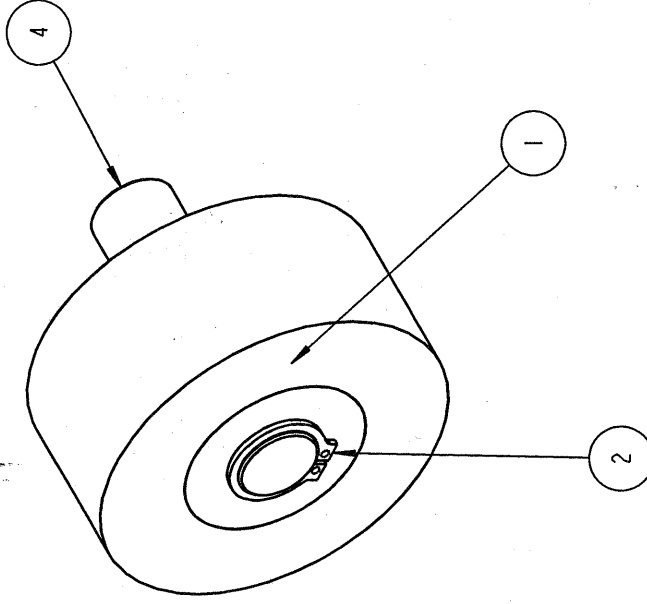


1	536468-02
REV'D	WHERE USED

DRAWN BY: TJG	SCALE 0.375	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	MATERIAL:	THIRD ANGLE PROJECTION	PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC. KENNESAW, GA 30144 USA	KIRK - RUDY, INC. KENNESAW, GEORGIA
	CHECKED BY:	DATE 28-Feb-00	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY	HEAT TREAT:	TITLE: ASSY, IDLER ROLLER	
TRACED BY:	MASTER M		FINISH:	SHEET NO. 1 OF 1	DRAWING # 533876-02	

ITEM	QTY	PART #	DESCRIPTION
1	2	103108	BEARING, FLAT .500
2	1	104106	SNAPRING, .500
3	1	108862-1	PULLEY, TIMING 18L075 1.125B NK
4	1	500939-1	STUD-IDLER GEAR BR'KT

REV NO	DATE	DESCRIPTION	ECN NO	BY
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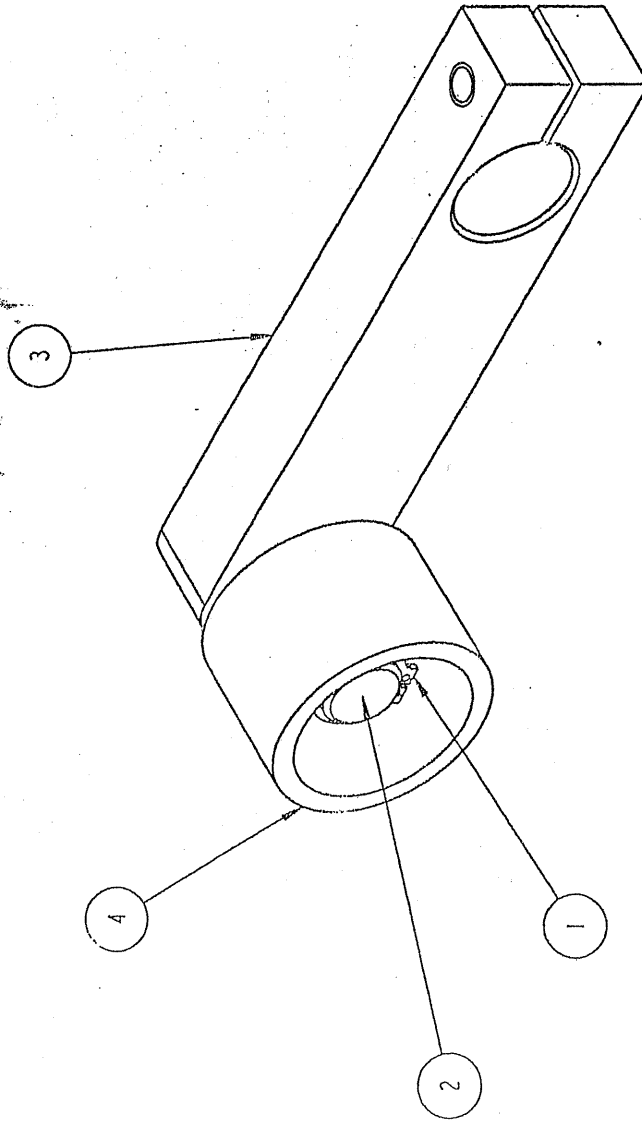


2	535069-01
REC'D	WHERE USED

DRAWN BY: TJG	SCALE 1.000	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED <table border="1"> <tr> <td>.XX</td> <td>.XX</td> <td>ANG.</td> </tr> <tr> <td>.01</td> <td>.005</td> <td>.5</td> </tr> </table>	.XX	.XX	ANG.	.01	.005	.5	MATERIAL: NOTED	THIRD ANGLE PROJECTION 	PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE QUOTED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK - RUDY, INC. KENNESAW, GA 30144 USA	KIRK - RUDY, INC. KENNESAW, GEORGIA
	.XX		.XX	ANG.								
.01	.005	.5										
CHECKED BY: 28-Sep-98	DATE 28-Sep-98	HEAT TREAT: NONE	MODEL: SP69400	TITLE: ASSY, IDLER 18L075								
TRACED BY:	MASTER	FINISH: NOTED		SHEET NO.: 1 OF 1	DRAWING 1 535077-01							

536477-01

ITEM	QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	1	104106	SNAPRING, .500					
2	1	508540	STUD					
3	1	508684-2	ARM, TAKE UP					
4	1	516045A	ASSY, IDLER 1.376 DIA. X 1.00 IN					



DRAWN BY: TJG		SCALE: 1.000	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED		MATERIAL: XXX		THIRD ANGLE PROJECTION		PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE QUOTED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC. KIRK-RUDY, INC. KENNESAW, GA 30144 USA		1 536476-01 REQ'D WHERE USED	
CHECKED BY:	DATE: 01-Sep-99		.XX .XX .XX .01 .005 .5		HEAT TREAT: XXX				KIRK - RUDY, INC. KENNESAW, GEORGIA			
TRACED BY:	MASTER:		REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY		FILED: XXX		MODEL: SP76500 SHEET NO. 1 OF 1		TITLE: ASSY, TAKE UP TIMING BELT DRAWING NO. 536477-01			

7 ELECTRICAL SCHEMATICS AND PARTS

7.1 SCHEMATIC LIST

The following wiring diagrams are included in the manual packet for your reference.

200 125 06 110.

8 APPENDIX

This image shows a single sheet of white paper with horizontal ruling lines. The lines are evenly spaced and run across the width of the page. There are no margins, text, or other markings on the paper.

10 WARRANTY AND SERVICE

WARRANTY

Warranty: Kirk-Rudy, Inc., warrants to the original retail purchaser that this product is free from defects in the material and workmanship, and agrees to repair or replace, at Kirk-Rudy's option, any defective product within (90) days from the date of purchase. This warranty is not transferable. It covers damage resulting from defects in material or workmanship, and it does not cover conditions or malfunctions resulting from normal wear, neglect, abuse or accident.

THIS WARRANTY IS IN LIEU OF ALL OTHER EXPRESSED WARRANTIES ANY IMPLIED WARRANTY OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE OR ANY IMPLIED WARRANTY ARISING OUT OF A COURSE OF DEALING, CUSTOM, OR USAGE OF TRADE.

Limitation of Remedies: If product is proven to be defective within the warranty period stated above, THE EXCLUSIVE REMEDY, AT KIRK-RUDY'S OPTION, SHALL BE TO REFUND THE PURCHASE PRICE OF OR TO REPAIR OR REPLACE THE DEFECTIVE PRODUCT, provided that the defective product is, at Kirk-Rudy's choice, returned immediately to Kirk-Rudy or authorized service representative designated by Kirk-Rudy, or made available at user's premises in a location suitable for servicing.

Limitation of Liability: Kirk-Rudy shall not otherwise be liable for any losses or damages, whether direct, indirect, special, incidental, or consequential, regardless of the legal or equitable theory asserted, including contract, negligence, warranty, or strict liability.

To obtain replacement parts and service, contact an Authorized Kirk-Rudy Dealer. Use Kirk-Rudy part numbers when ordering.

USE ONLY GENUINE KIRK-RUDY REPLACEMENT PARTS

For Service or Replacement Parts Please Call:
Kirk-Rudy @ 770-427-4203

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Woodstock, GA 30188
www.kirkrudy.com