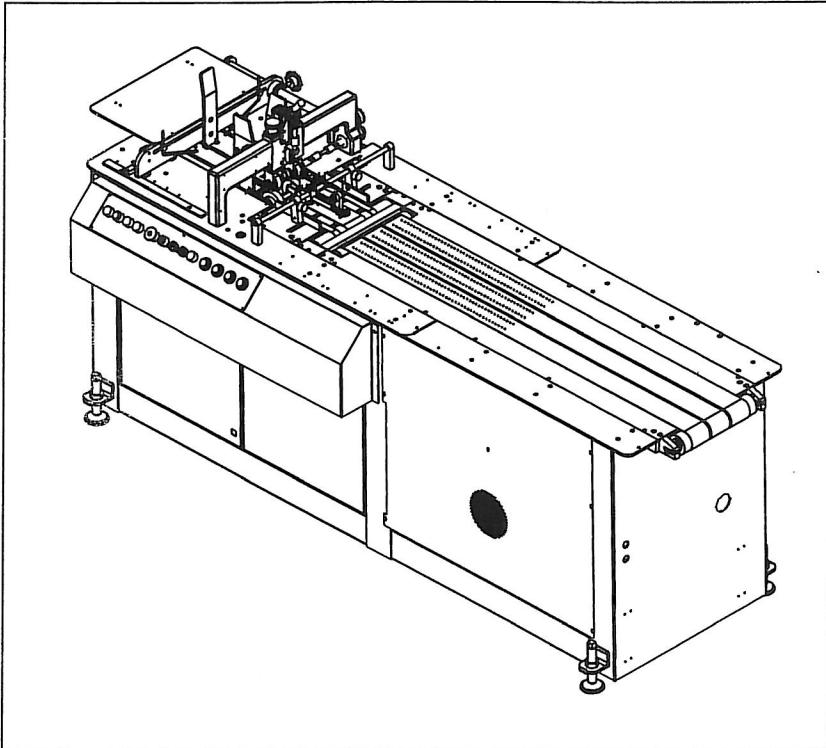


# *Kirk-Rudy, Inc.*

## Instruction and Parts Manual

### KR215W Ink Jet Base Dual Motor w/36" Ext.



**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.

Instruction  
and Parts Manual

# TABLE OF CONTENTS

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<u>SECTION</u>	<u>DESCRIPTION</u>	<u>PAGE</u>
1	IMPORTANT SAFETY INSTRUCTIONS	3
2	SPECIFICATIONS	4
3	INSTALLATION	5
3.1	UNCRATING	5
3.2	ACCESSORIES AND SPARE PARTS	5
3.3	COMPONENT DESCRIPTION	5
4	OPERATING INSTRUCTIONS	6-18
4.1	CONTROL PANEL	6
4.2	STOP CIRCUIT	6-7
4.3	SEQUENCE OF SET-UP	7
4.4	VACUUM PLATES	8
4.5	SHUTTLE/FEEDER SET UP	8-10
4.6	GATE SET UP	11
4.7	VACUUM TIMING & TOP ROLLER SET UP	11-14
4.8	JAM RELEASE	14
4.9	SPACING	15
4.10	SIDE GUIDES	15-16
4.11	TABLE TOP BELTS	16-17
4.12	SKID BAR	18
5	MAINTENANCE	19
5.1	LUBRICATION	19
5.2	DAILY MAINTENANCE	19
6	DIAGRAMS AND PARTS LIST	20-21
6.1	DIAGRAMS	20-21
6.2	PARTS LIST	21
7	ELECTRICAL SCHEMATICS AND PARTS	22
7.1	WIRING DIAGRAMS LIST	22
7.2	PARTS LIST	22
8	APPENDIX	23-24
8.1	POSSIBLE OPTIONS	23
8.2	22 IN SPACING OPTION	23
8.3	VIDEOJET ENCODER OPTION	24
9	NOTES	25
10	WARRANTY AND SERVICE INFORMATION	26

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

# **1    Important Safety Instructions**

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Intended Use Statement: The KR215IJ base is a top load bottom feed transport designed to separate and feed product one at a time in a consistent manner.

**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

Length	127"	322.6cm
Width	30.5"	77.5cm
Height	45"	114.3cm
Weight	1400 lbs	635 kg
Shipping	1575 lbs	715 kg

### MAXIMUM CYCLE SPEED

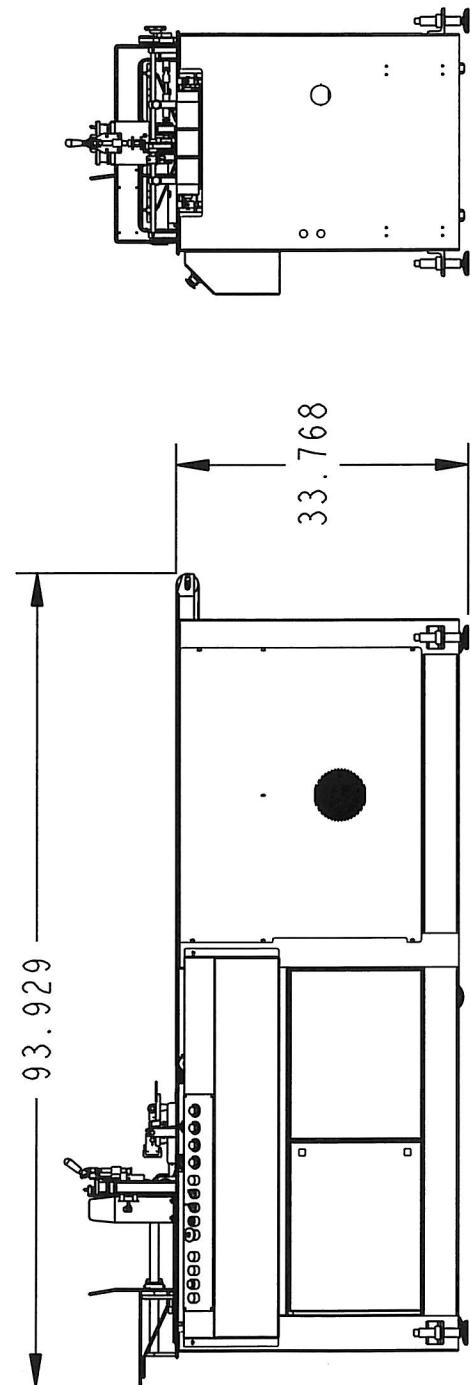
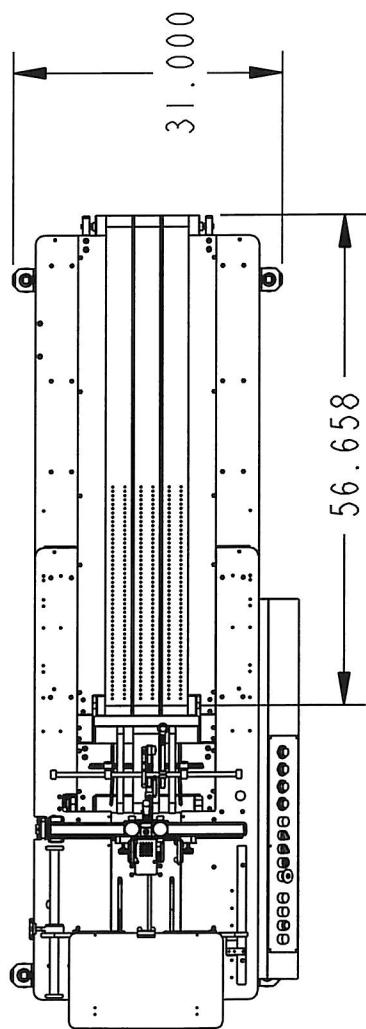
30,000 cycles per hour

### ELECTRICAL REQUIREMENTS

Main Power	220V, single phase, 60 cycle, AC 20 amps
Vacuum Pump	1/2 hp
Drive Motors	1/2 hp

## DRAWING # KR2 | 5W1 J36

REV NO	DATE	DESCRIPTION	ECN NO	BY
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DRAWN BY: JMW	SCALE 0 . 050	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED .005 .005 .005 .005	MATERIAL: N / A	THIRD ANGLE PROJECTION Elevation View	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. WOODSTOCK, GA 30188 USA
CHECKED BY:	DATE 22 - Nov - 04	ANG. .01 .005 .005 .005	HEAT TREAT.: N / A	MODEL: SA 304	TITLE: 2   5W + 36 DM
TRACED BY:	MASTER	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED	FINISH: N / A	SHEET NO: 20F2	DRAWING # KR2   5W1 J36
		ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY			

## **3 INSTALLATION**

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### **WARNING**

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

#### **3.1 UNCRATING**

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

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.

#### **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.

#### **3.3 COMPONENT DESCRIPTION (see Figure 1.0)**

1. JOGGER TABLE: Used to set the backstop for the product being fed. Can also be used to hold extra product.
2. FEEDER: Pushes product under gate and into feed rollers.
3. GATE: Prevents more than one piece of product from being fed at one time.
4. TOP FEED ROLLERS: Along with the lower feed rollers, feeds product through the bridge.
5. JAM RELEASE: Raises top feed rollers, so a jam can be cleared.
6. SIDE GUIDES: Keeps product from skewing while traveling on the tabletop.
7. HANDWHEEL: Used to move the feed shuttle by hand during setup.
8. OILER: Used to lubricate machine.
9. FEEDER VACUUM PUMP: Supplies vacuum to the feeder.
10. DRIVE MOTOR: Drives the feeder pushers and tabletop belts.
11. TABLETOP VACUUM PUMP: Supplies vacuum to the tabletop.
12. CONTROL PANEL (for more detail, see Section 4.1 and Figure 2.0): Contains operator controls.

## **4 OPERATING INSTRUCTIONS**

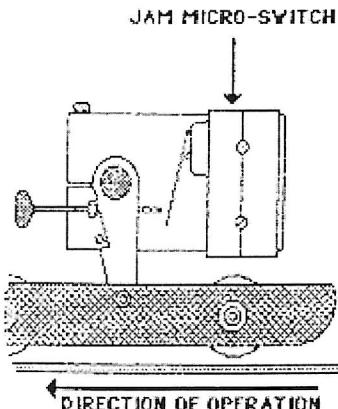
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### **4.1 CONTROL PANEL (see Fig. 2.0)**

1. STOP BUTTON: Stops the feeder when pressed and released.
2. JOG BUTTON: The machine will run as long as this switch is depressed. This switch is designed as an aid for set-up and will also stop the machine when pressed.
3. START BUTTON: Starts the machine.
4. POWER OFF / EMERGENCY STOP BUTTON: This is a latching switch. To turn power on, unlatch emergency stop. Press button to turn machine power off. The green light in the power button will turn off when power is off.
5. POWER BUTTON: Press button to turn machine power on. Emergency stop button must be unlatched. Button will glow green when machine is on.
6. VACUUM SELECTOR SWITCH: Turns on/off vacuum.
7. BLOWER SELECTOR SWITCH: Turns on/off blower.
8. COUNTER: Counts the product.
9. FEEDER SPEED CONTROL: Controls the speed of the feeder. “0” is minimum speed, “10” is maximum speed.
10. CONVEYOR SPEED CONTROL: Controls the speed of the conveyor. “0” is minimum speed, “10” is maximum speed.
11. CONVEYOR SPEED UP CONTROL: Controls how fast conveyor speeds up for zip code separation.

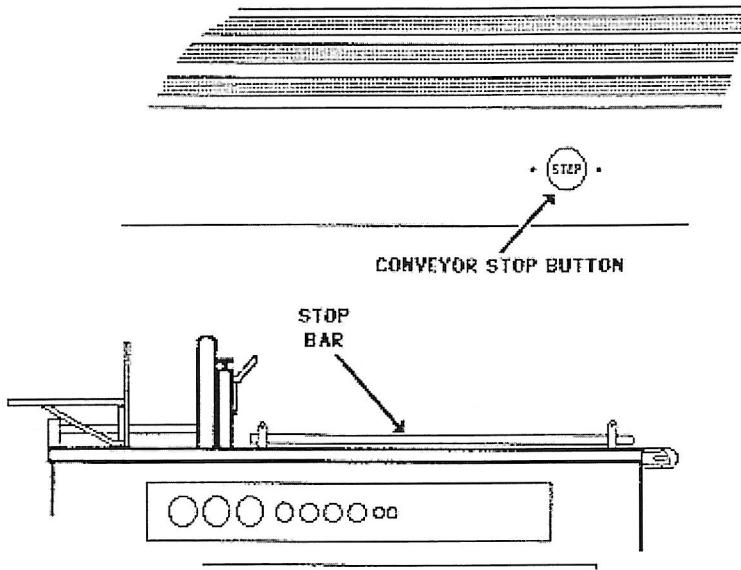
### **4.2 STOP CIRCUIT**

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 four stop switches on the KR215IJ. They are the jam microswitch on the skid bar assembly (533821-01), the panic stop bar (535275-01), the conveyor stop button, and the control panel emergency stop button (Figure 2.0).



The switch that is open most often is the “jam microswitch” located on the skid bar (see Section 4.12).

The second switch that is most often open is the conveyor stop button. This button is usually open because of improper seating of the plug that goes into the back of the machine. If neither the machine nor the conveyor will run (conveyor power switch in “automatic” position) when the start button is depressed, check all the stop switches. If the machine will still not run, the problem must be isolated with a volt/ohm meter using the schematics.



#### 4.3 SEQUENCE OF SET-UP

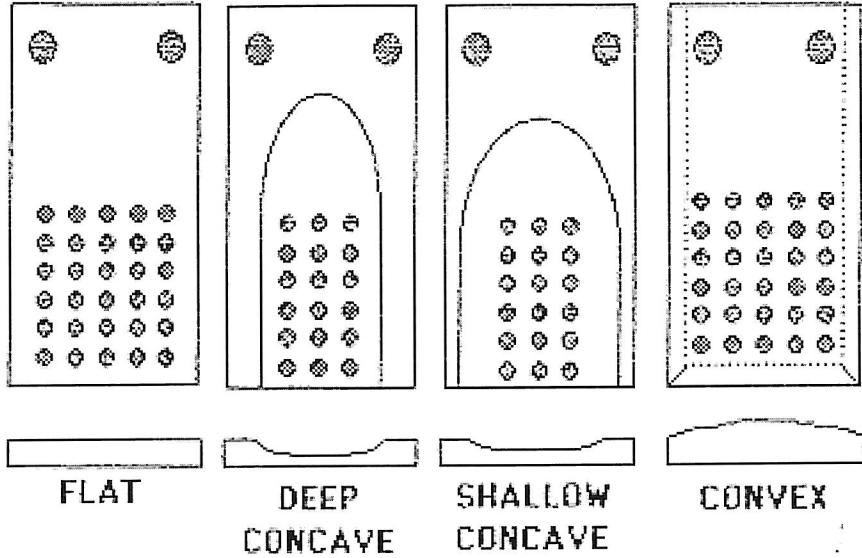
Note: Daily maintenance should be performed at the start of each day.

1. Select and install proper vacuum plate.
2. Set upper feed rollers.
3. Adjust gate.
4. Engage needle blocks, lifters and/or pusher blocks.
5. Adjust feed hopper product guides and backstop.
6. Adjust tabletop belts.
7. Position tabletop side guides.
8. Position skid bar(s).
9. Adjust vacuum.
10. Set shuttle feeder and tabletop speeds.

Insert KR215IJ09 & KR215IJ10

#### 4.4 VACUUM PLATES

Before setting up the feeder, the correct vacuum plate should be selected and installed. There are four vacuum plates available for the KR215IJ.



**FLAT PLATE:** For thick product such as magazines and newspapers, any product that does not give or have bend to it.

**DEEP CONCAVE PLATE:** For thin product such as single sheets or flimsy product.

**SHALLOW CONCAVE PLATE:** For thicker product that has some flexibility.

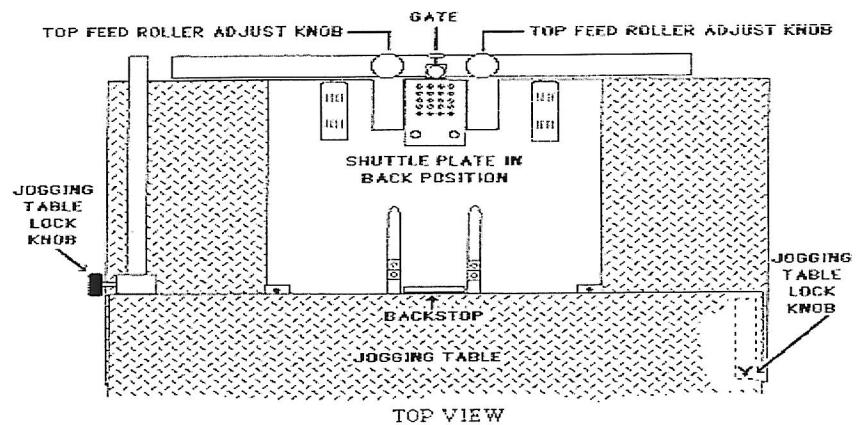
**CONVEX PLATE:** For tri-folded or self-mailers and can also be used for product that has a warp or bend. (Optional: not sent with machine.)

To change vacuum plates, remove the two 5/32" hex head screws in the rear of the plate and lift the plate out from the shuttle on the feeder. Insert the desired plate and re-install the two screws.

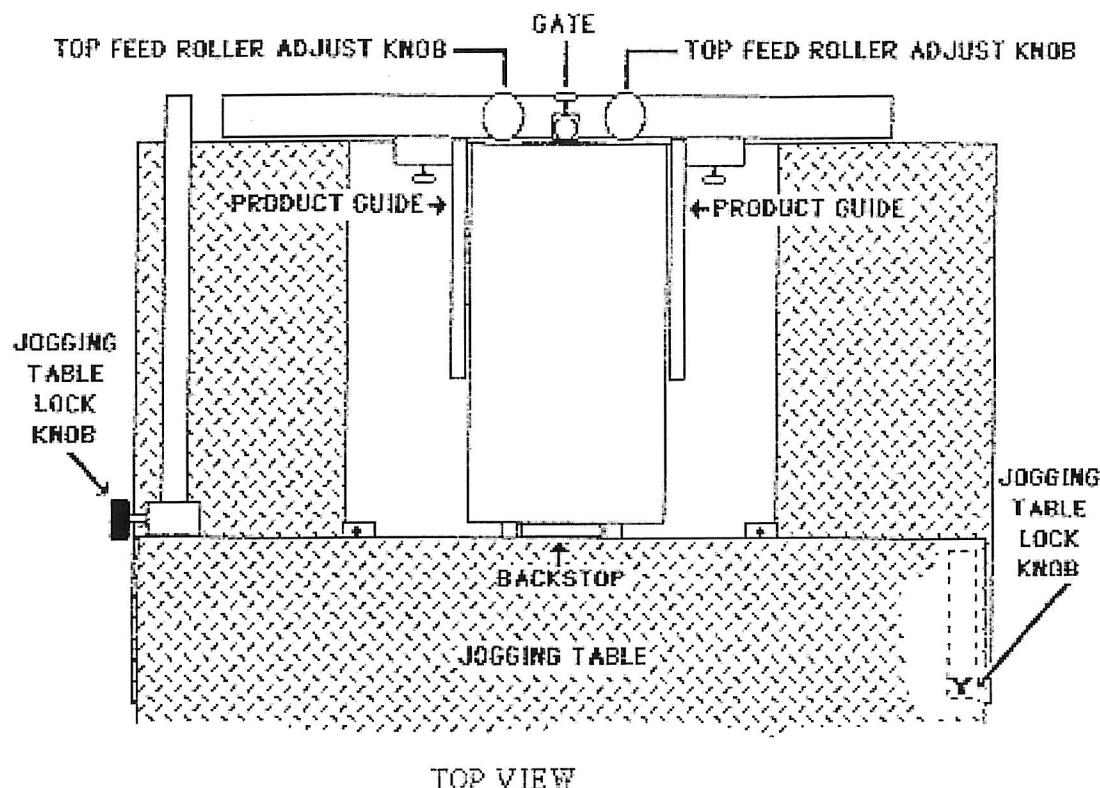
#### 4.5 SHUTTLE/FEEDER SET-UP

To set up the feeder, loosen the back stop/jogging table and slide back. Loosen the two product guides and slide out from the center of the feeder.

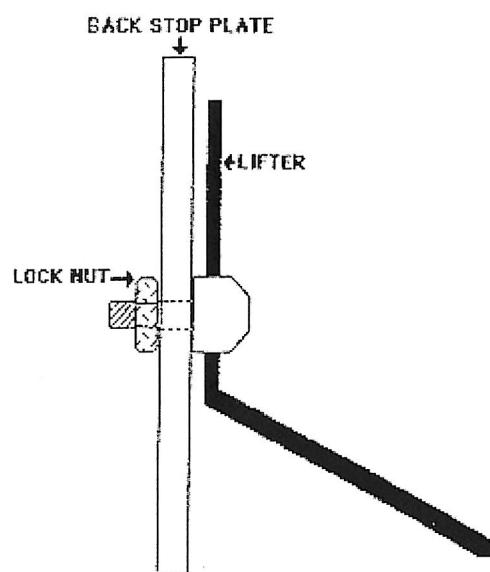
Rotate the machine by hand until the shuttle plate is in the extreme back position.



Place the product on the shuttle plate up against the gate. Bring the backstop up against the product and lock in place. Bring both product side guides in to the product. Allow approximately 1/8" play between guides and the product. Lock in place.



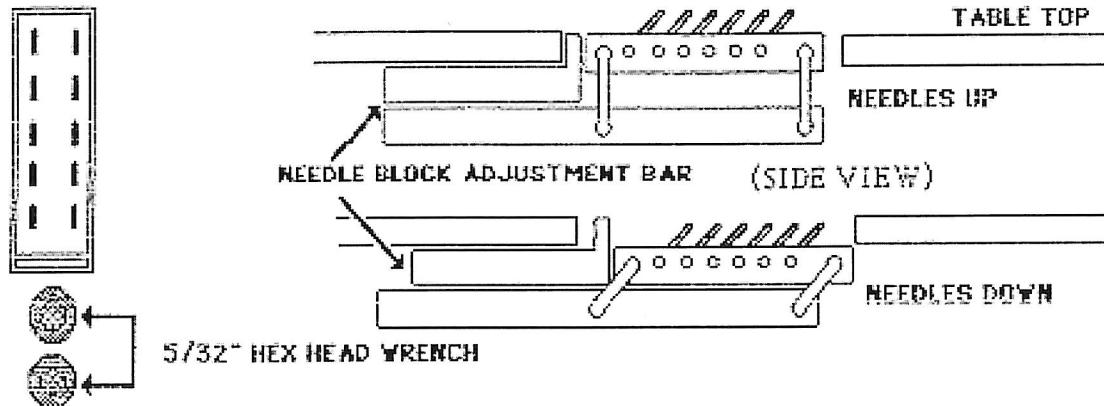
TOP VIEW



The feeder is equipped with lifters, needle blocks, and pushers to aid in the feeding of various products.

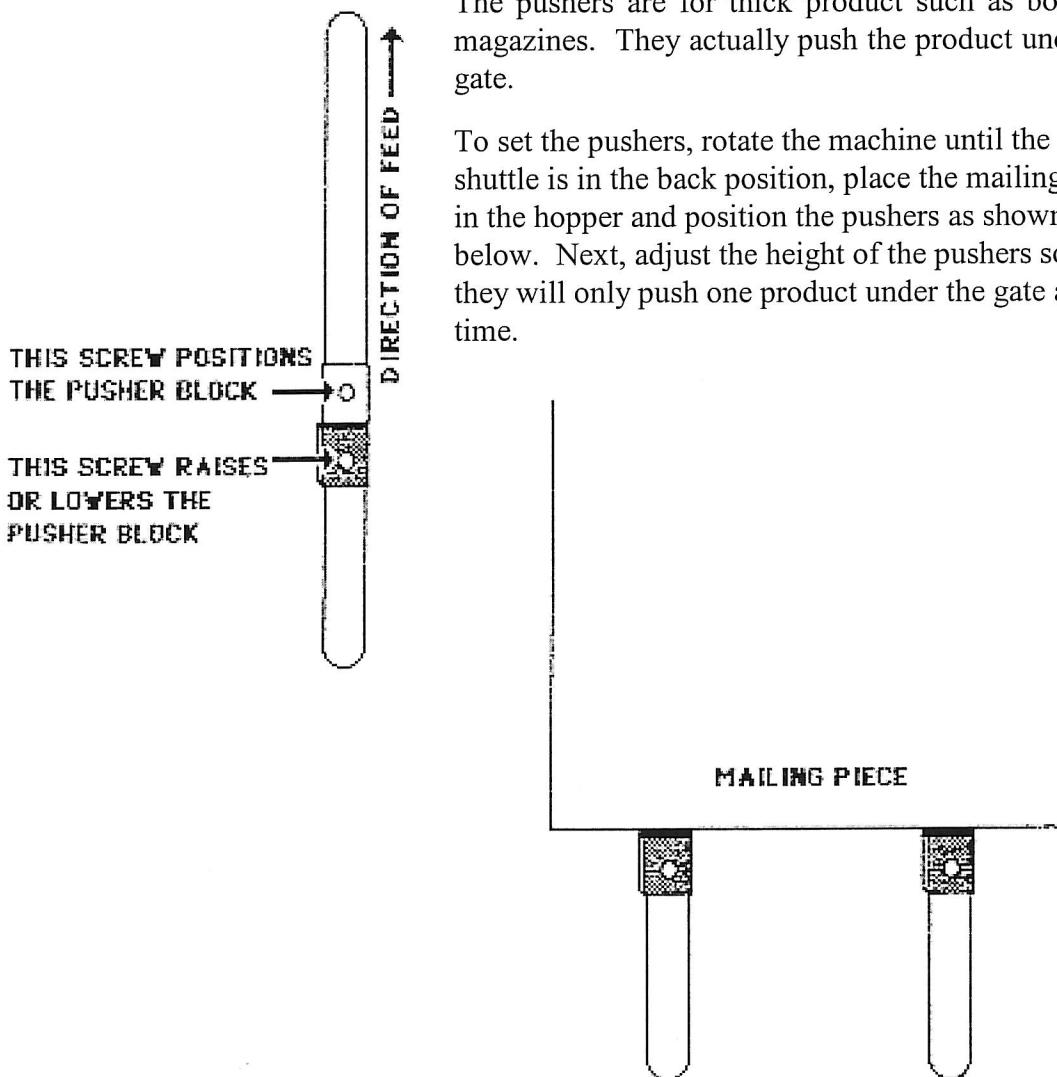
The lifters are designed to lift up the back of the product and angle the front edge toward the gate to aid in feeding. These are most commonly used for large products such as newspapers, magazines, and etc.

**Optional:** The needle blocks are designed to grab the product and help in the feed under the gate. The needle blocks can damage the product and are almost always used for newspapers. They are often used in conjunction with the lifters.



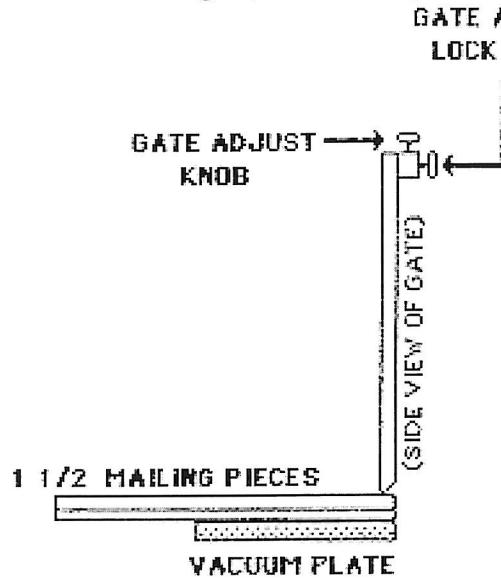
The pushers are for thick product such as books or magazines. They actually push the product under the gate.

To set the pushers, rotate the machine until the shuttle is in the back position, place the mailing piece in the hopper and position the pushers as shown below. Next, adjust the height of the pushers so that they will only push one product under the gate at a time.



#### 4.6 GATE SET-UP

To set the gate, loosen the gate lock knob and turn gate adjust knob counter clockwise to raise the gate. Turn the main power and the feeder vacuum pump switches on. To rotate the gate, adjust the knob clockwise until the gate is snug against the mailing piece. (When setting up on a mailing piece that is two or more pages, the gate should be set snug to  $1 \frac{1}{2}$  times the thickness of the mailing piece. Simply take  $1 \frac{1}{2}$  pieces and place underneath the gate). After the gate is set, lock in place with the gate lock knob.



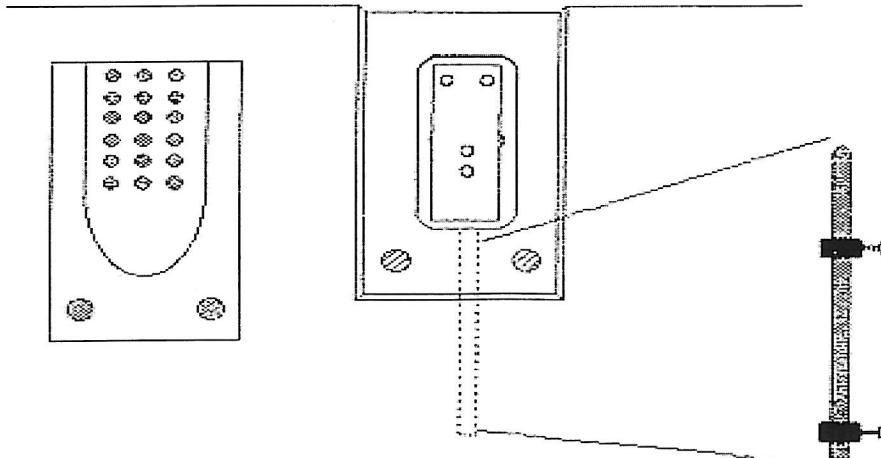
GATE ADJUST  
LOCK KNOB

This should allow one piece to feed smoothly but keep two pieces from going under the gate at the same time. If two pieces are fed and the gate is set properly, the piece on top will jam or tear. If this happens, the problem is either the mailing pieces are stuck together or too much vacuum is being applied to the vacuum plate. To adjust the amount of vacuum being applied to the plate, see Section 4.6.

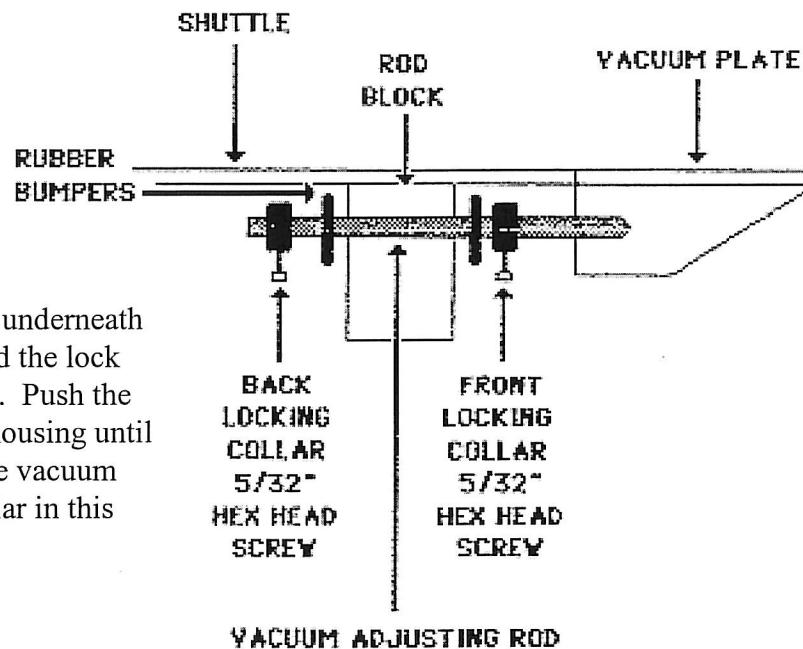
#### 4.7 VACUUM TIMING AND TOP FEED ROLLER SET-UP

The vacuum connected to the vacuum plate is designed to come on  $1/8"$  before the shuttle plate reaches the maximum backstroke. The vacuum connected to the vacuum plate should go off after the vacuum plate has transported the product underneath the gate and between the feed rollers. The lower feed rollers will come up.

The vacuum is turned on and off by two lock collars set-screwed to a rod that rides underneath the vacuum plate. When this rod is pushed in it turns the vacuum on and when it is pulled out the vacuum is turned off.

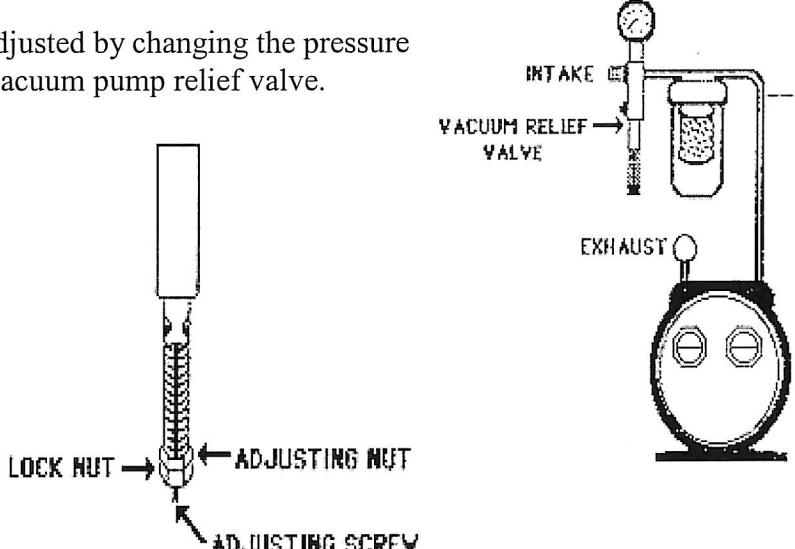


To adjust the vacuum on, turn the main power and feeder vacuum pump switches on and rotate the machine by hand until the shuttle plate is 1/8" from its maximum backstroke. Locate the front lock collar on the rod underneath the feeder and loosen. Hold the lock collar against the rod block. Push the rod into the vacuum plate housing until the vacuum comes on to the vacuum plate. Tighten the lock collar in this position.

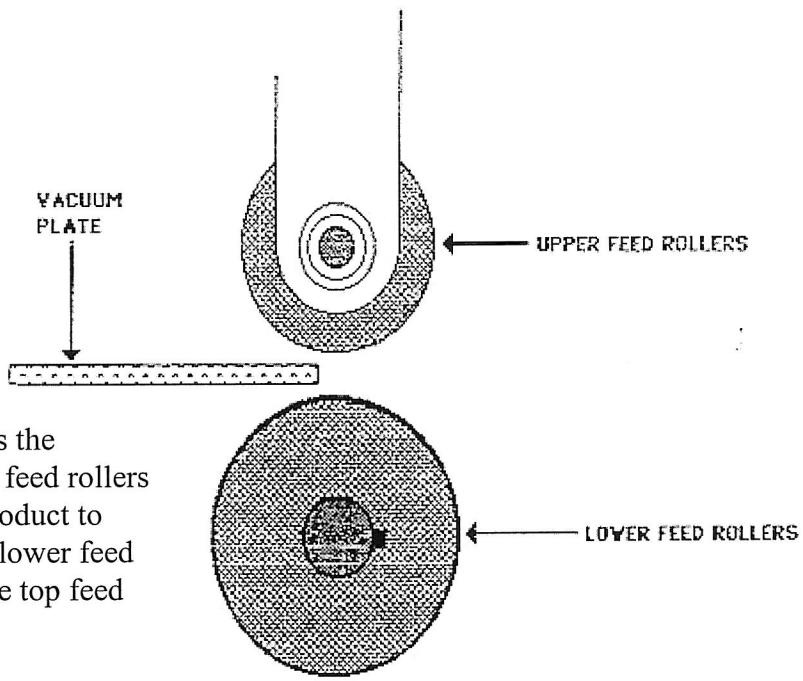


Vacuum to the plate can be adjusted by changing the pressure on the spring located on the vacuum pump relief valve.

Locate the vacuum relief valve on the feeder vacuum pump (located on the left of the machine) and loosen the lock nut. Now the vacuum can be adjusted by holding the adjustment screw and turning the adjustment nut. As the spring is compressed, the vacuum increases. Loosening the compression spring decreases vacuum.

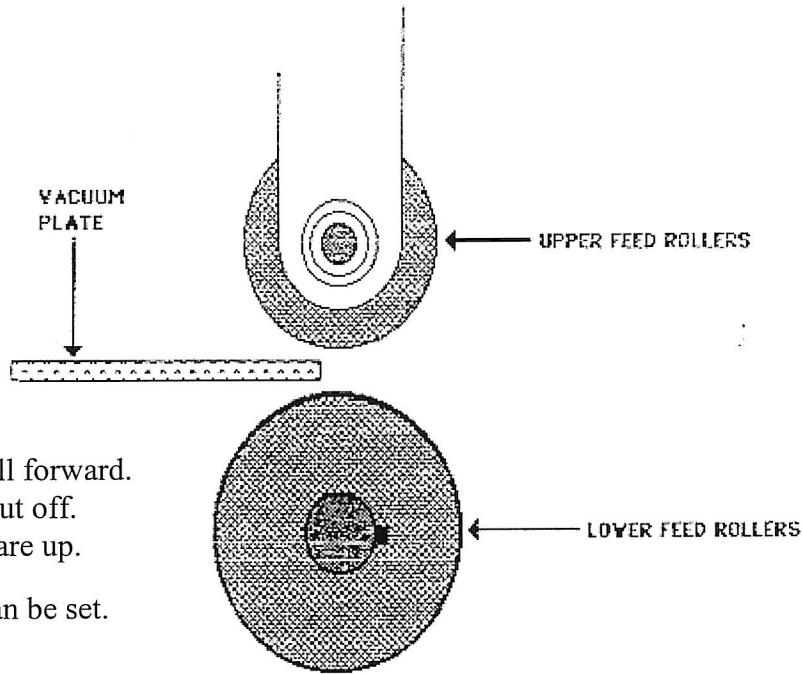


Rotate the machine with the handwheel and move the shuttle forward until the lower feed rollers come up. At this point the vacuum should go off. To adjust the vacuum off, loosen the back lock collar and hold against the rod block, pull the rod out of the vacuum plate housing until the vacuum goes off. Tighten in this position.



As the vacuum plate moves the product forward, the lower feed rollers move down to allow the product to move between the top and lower feed rollers. DO NOT adjust the top feed rollers at this point.

At this position the upper feed rollers can be set.



1. The vacuum plate is full forward.
2. The vacuum plate is shut off.
3. The lower feed rollers are up.

Now the top feed rollers can be set.

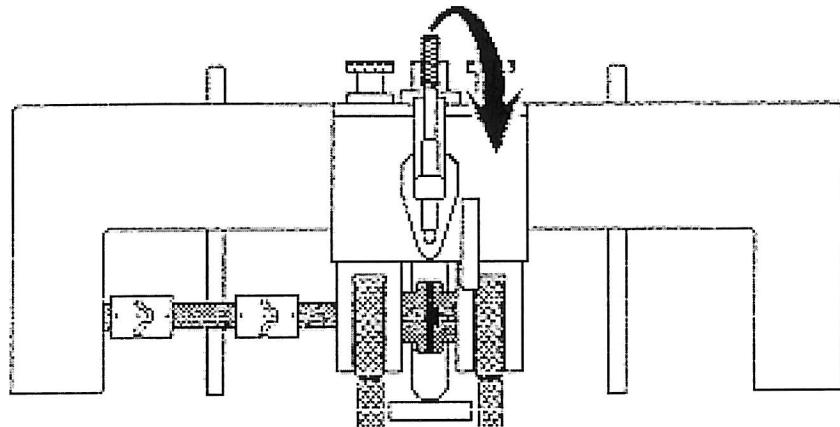
To set the top feed rollers, place a mailing piece in the shuttle feeder. Turn on the main power and feeder vacuum pump. Rotate the machine by hand until the piece is fed underneath the gate, between the top and lower feed rollers, and the lower feed rollers have come up. Adjust the top feed rollers up and down until there is enough pressure on the mailing piece to be able to pull the piece back out without tearing it.

After setting the top feed rollers, lock them in place with the locking nuts.

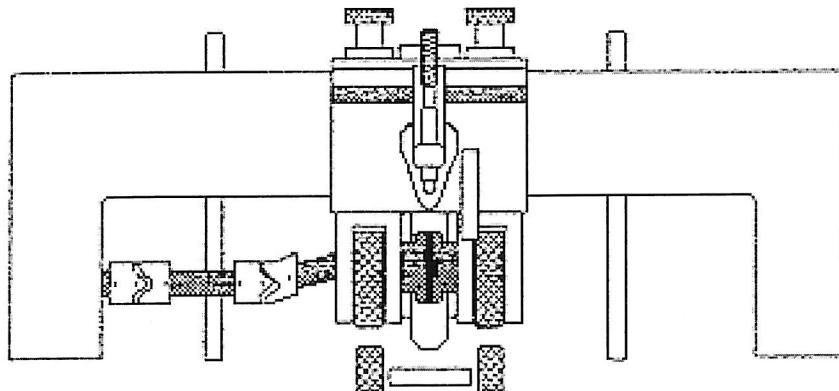
Place several pieces in the feeder and run the machine using the run or jog button. If the piece pulls to one side as it leaves the feed rollers, the top feed rollers are not set properly. Adjust until the mailing piece is fed smoothly by raising or lowering one of the top feed rollers.

#### 4.8 JAM RELEASE

The feeder bridge contains a "jam release" that allows the gate and top feed rollers to be raised in case of a double feed or jam. To engage the jam release, simply pull down on the handle. Be sure and push up the handle and lower the gate and feed rollers after the jam has been cleared and before continuing operation.



Jam release in up position with gate and feed rollers down.



Jam release pulled down, raising gate and feed rollers.

## 4.9 SPACING

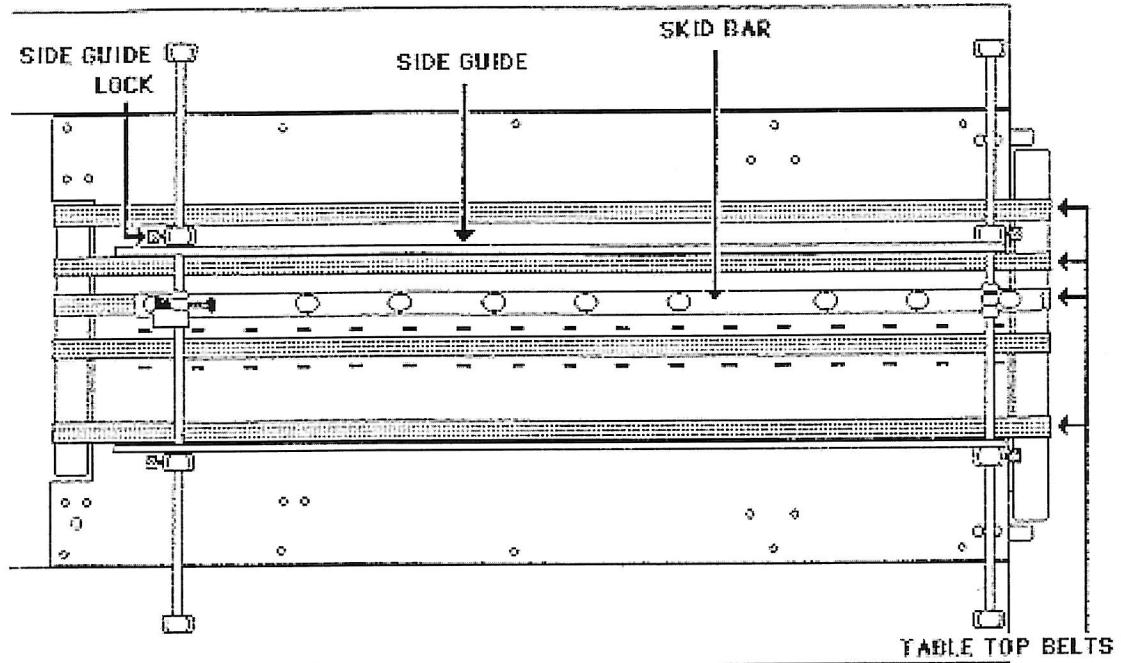
Varying the speed of both the shuttle feeder and tabletop belts controls spacing of product.

An optimum speed should be obtained on the tabletop belts by adjusting the speed control. This optimum speed should be determined by the quality of the ink jet. Once this speed has been determined and set, the shuttle feeder speed can be determined.

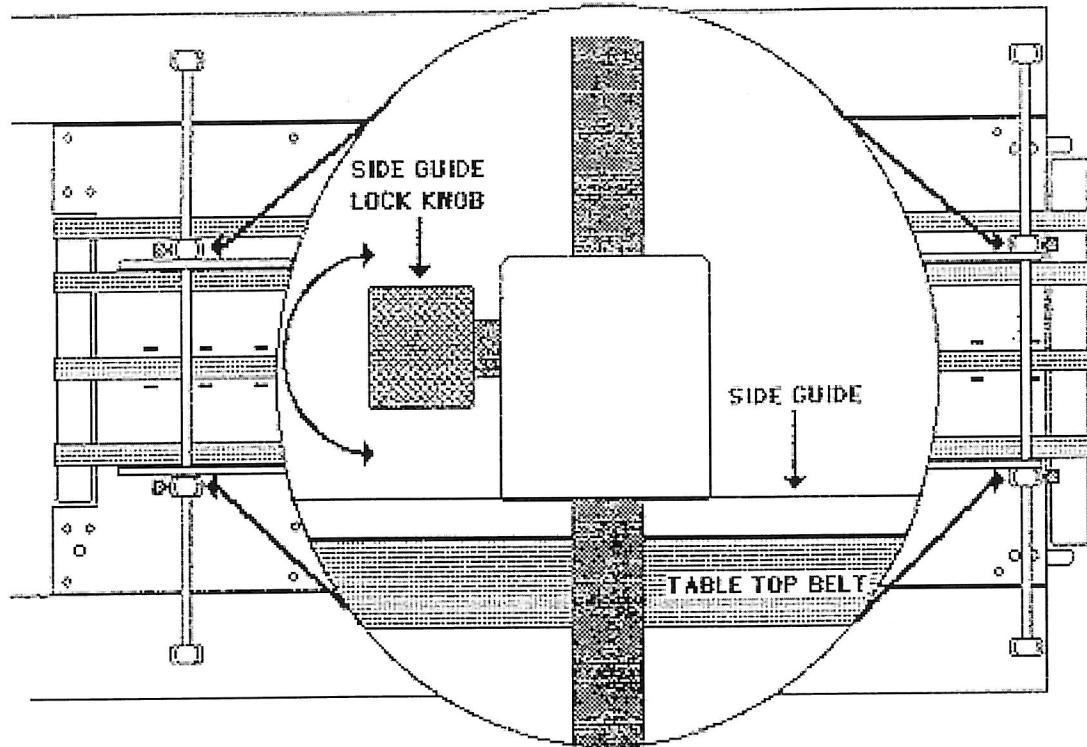
The shuttle feeder speed should be set to maintain a minimum spacing between the product being fed, allowing for maximum production. If the shuttle feeder speed is set too high, the products being fed will overlap and create problems with the ink jet.

For controls layout, see Figure 1.0.

## 4.10 SIDE GUIDES



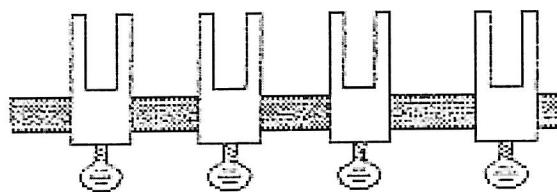
Once the product has been fed out through the feed rollers, the tabletop can be set. The first item to set up is the side guides. With the main power and feeder vacuum pump on, load the hopper and feed a piece out past the feed rollers. At this point, the two side guides can be brought in to either side of the piece with approximately 1/8" play on either side. The side guides are held in place with lock knobs that can be turned either way to lock the guides in place.



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.

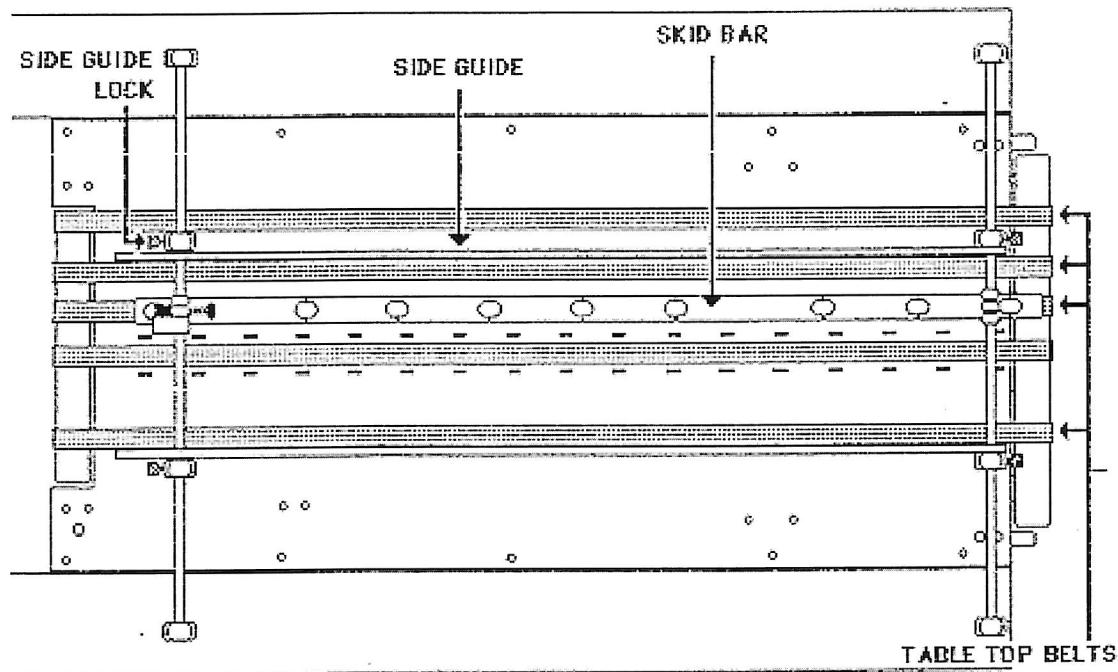
#### 4.11 TABLETOP BELTS

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 KR215IJ. However, not all of them are needed for every product. You may run the belts that are not needed outside of the side guides.



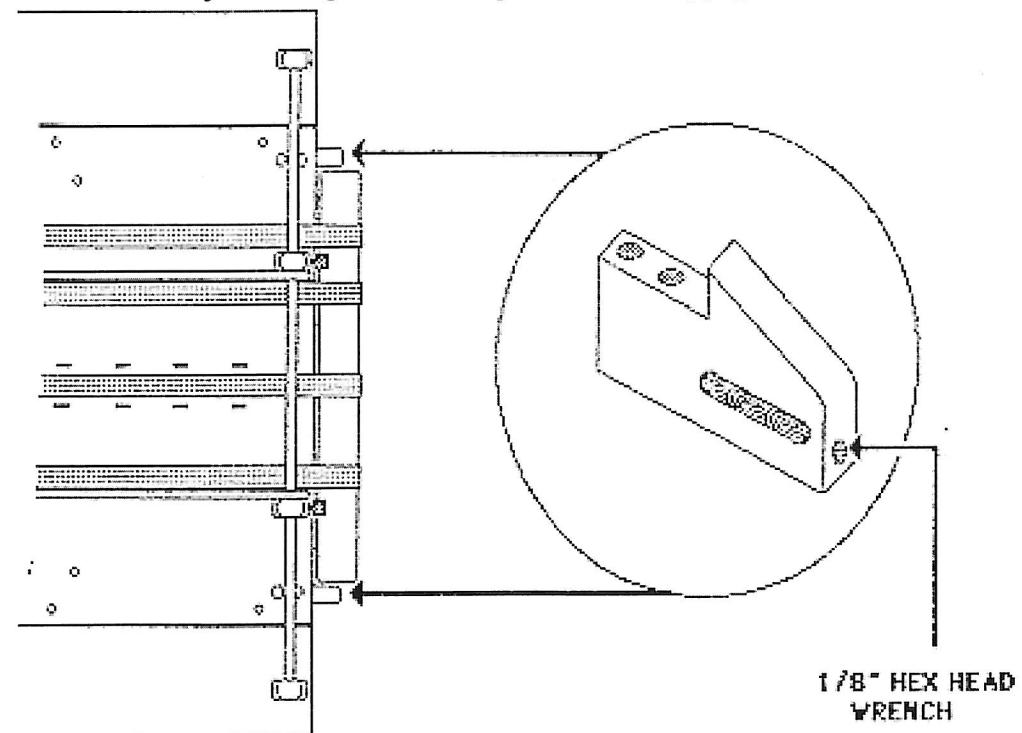
Underneath the tabletop is located guides for the tabletop belts. Each belt has its own guide. To move the belts, simply loosen the thumbscrew on the bottom of the guide and slide the guide on the shaft to the desired position and then tighten the thumbscrew.

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.

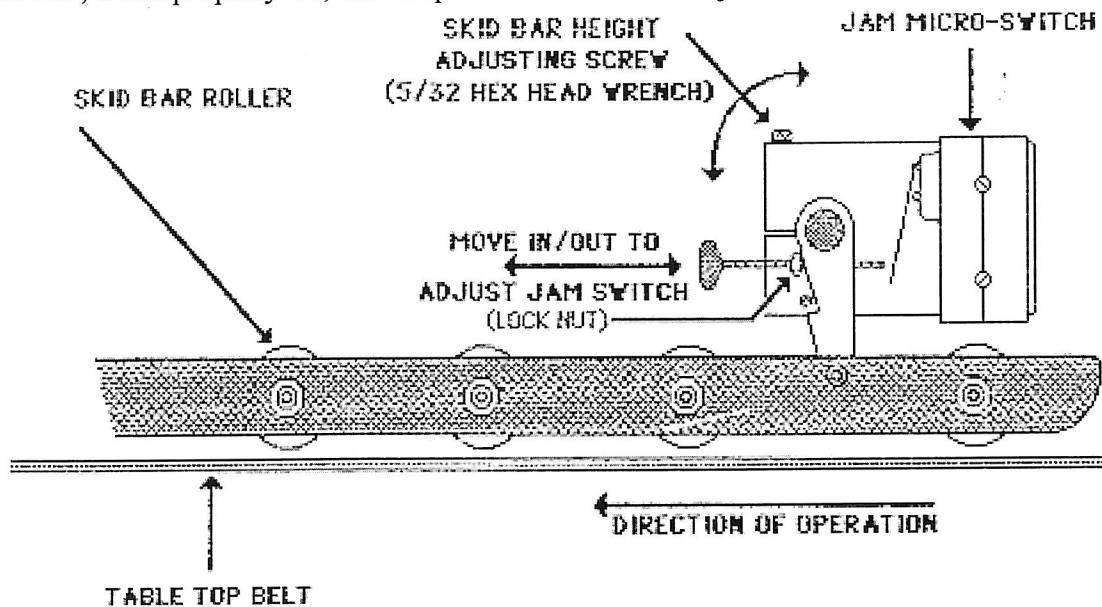
The tabletop belt tension can be adjusted. Caution should be taken not to over tighten. There should be just enough tension to prevent belt slippage.



#### 4.12 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 KR215IJ is furnished with one skid bar, and is not needed when running small pieces such as cards or envelopes but 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.



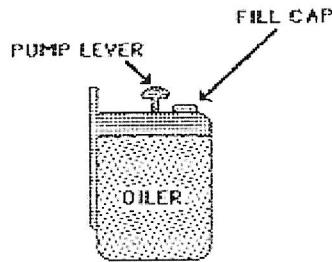
To set the skid bar, rotate the machine until a mailing piece is under the skid bar. Loosen the 5/32" hex head screw on the skid bar block. Adjust until the skid bar is resting on the mailing piece and the skid bar rollers rotate as the product is transported. Lock in place with the 5/32" hex head screw.

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).

# 5 MAINTENANCE

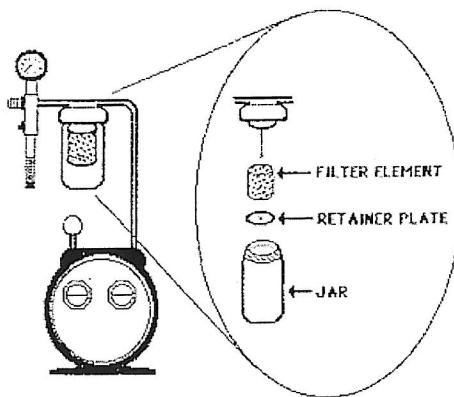
## 5.1 LUBRICATION



The operator should keep the KR215IJ clean and lubricated on a regular basis. The base has a central oiling system located on the left side near the jogger table, looking down stream. The oiler only requires the operator to pull the pump lever on the oiler. This should be done every two hours of operation. The oil recommended is 20-weight SAE machine oil.

## 5.2 DAILY MAINTENANCE

Item	Function	Remarks
Upper & Lower Feed Rollers	Remove glazing and all other foreign materials from feed surfaces.	Use alcohol.
Base (General)	Remove excessive paper dust, ink, glue, and all other foreign materials from the tabletop and inside of base.	Use clean soft rag. (Dampen with water if necessary.)
Vacuum Pump Filters	Remove paper dust.	Wrap edge of filter against a hard surface or vacuum. If unable to clean replace with new filter.
Vacuum Pump Filters Jars	Clean jars thoroughly.	Use warm water and dry thoroughly. CAUTION: Improper replacement of cracked rims of jars can result in a loss of vacuum. Insure jar is installed correctly and has a proper seal.
Vacuum Body	Remove paper dust.	Remove vacuum plate and valve to remove debris around valve.



## **6 DIAGRAMS AND PARTS LISTS**

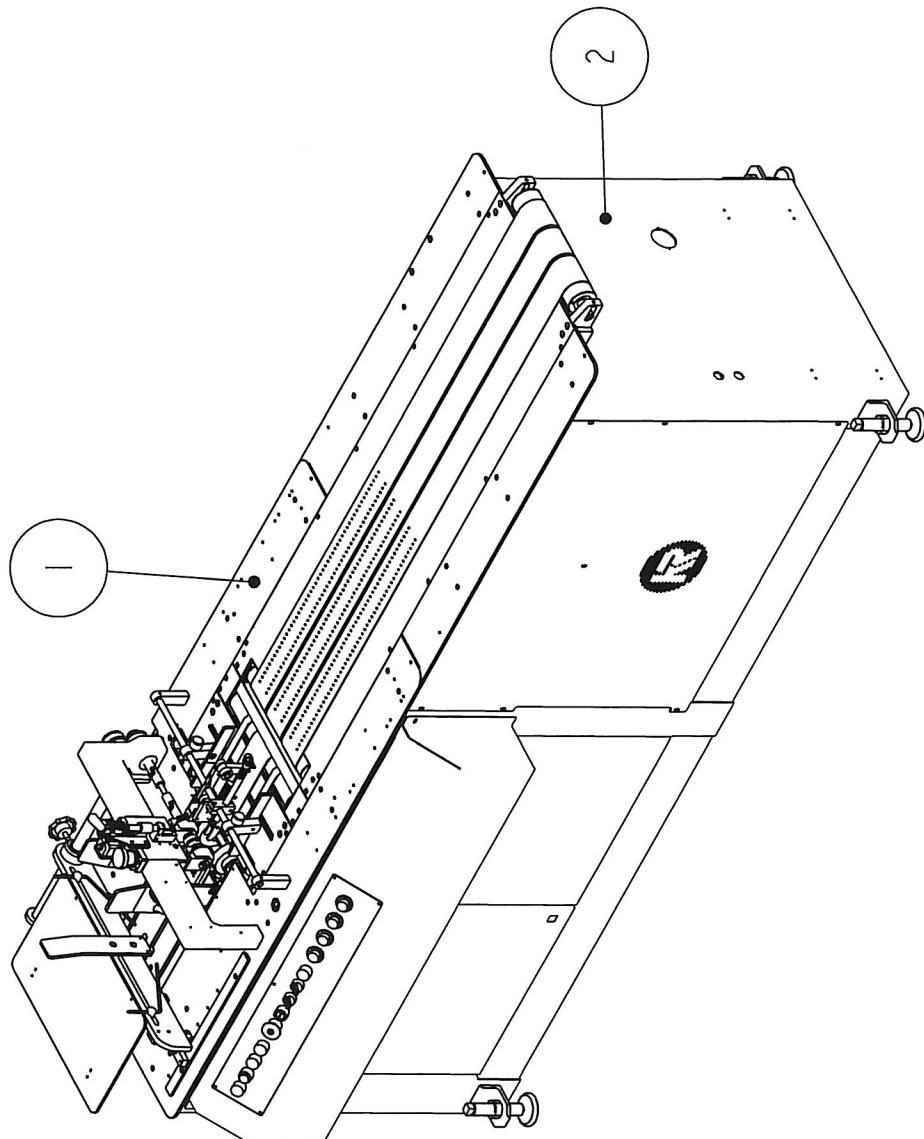
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### **6.1 DIAGRAMS**

Drawing #	Description
KR215WIJ36	KR215WIJ36 MACHINE
536470-05	ASSY, TABLETOPS
530619-01	ASSY, IDLER ROLLER
531021-01	ASSY, SHUTTLE TABLE
500708A	ASSY, VACUUM BODY
500728A	ASSY, BUSHING BLOCK
500751A	ASSY, BEARING BLOCK
531022-03	ASSY, LOWER FEED BELT DR.
531106-01	ASSY, HUB
531405-01	ASSY, JOGGER TABLE
536892-01	ASSY, REAR BRIDGE
536178-02	ASSY, BELT DRIVE PLATE
536467-01	ASSY, DRIVE ROLLER
530676-01	ASSY, FRONT ROLLER
537549-01	ASSY, BRIDGE TIMING BELT
100800	ASSY, UNIVERSAL JOINT
100800-1	ASSY, UNIVERSAL JOINT
500814-1A	ASSY, SIDE GUIDE RAIL
535412-01	ASSY, SIDE GUIDE
537550-01	ASSY, BRIDGE
538188-01	ASSY, SKIDBAR/SENSOR
538021-01	ASSY, SKIDBAR
546139-02	ASSY, INFEED
531274-02	ASSY, ROLLER BELT DRIVE
533876-02	ASSY, IDLER ROLLER
538288-12	ASSY, CABINET

ITEM QTY	PART #	DESCRIPTION
1	1	536470-05 ASSY, TABLETOPS SA304
2	1	538288-12 ASSY, CABINET 215+36 SA304

REV NO	DATE	DESCRIPTION	ECN NO	BY



DRAWN BY:	SCALE	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	MATERIAL:	REO'D WHERE USED
JMW	0 .070	.01 .005 .005 ANG.	N / A	I
CHECKED BY:	DATE	22 - Nov - 04	HEAT TREAT:	
		REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED	N / A	
TRACED BY:	MASTER	ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE WORK TO DIMENSIONS ONLY	N / A	
			SHEET NO. OF 2	DRAWING #
				KR215W1J36

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.  
WOODSTOCK, GA 30188 USA

KRK

MODEL: SA304

TITLE: 215W + 36 DM

DRAWING #

ITEM	QTY	PART #	DESCRIPTION	REF.	DATE	REVISION	REV.	SP.
1	2	103108	BEARING, FLAT .500					
2	5	103812	BEARING, HUB .625					
3	1	104105	SNAPPING, 500					
4	1	108869	PULLEY, TIMING 12L075 .625B .188K					
5	1	108820	PULLEY, TIMING 16L075 .750B .188K					
6	1	108961	BELT, TIMING D181L050					
7	1	1092723	PULLEY, TIMING 25MHS .750B .188K					
8	3	111911	BELT .3" X 118 125- MPH -SP (SEE DRAWING)					
9	1	500705	TABLETOP, MARION SHUTTLE					
10	9	500721	GUSSET - TABLETOP SUPPORT					
11	1	500751	PULLEY, REVERSING (TIMING)					
12	2	500824	SHAFT-BELT GUIDE					
13	1	525408	STUD, TAKEUP ARM					
14	1	105000-1	V-PULLEY					
15	1	108917-6	BELT, TIMING 25L015					
16	1	1089124-3	BELT, TIMING 50-5M-15					
17	2	1089125-4	BELT, TIMING 25S-5M-15					
18	1	500701-14L	FRAME, LH SA304					
19	1	500701-14R	FRAME, RH SA304					
20	1	500702-4R	TABLETOP, RH SIDE					
21	2	500702-9L	TABLETOP, LH SIDE					
22	1	500721-1	GUSSET, CUTOUT					
23	1	500725-29	GUIDE, BELT .3" BELT SA304					
24	1	500738-1	STUD, REVERSING PULLEY (TIMING)					
25	1	500825-4	SHAFT-SPROCKET DRIVE					
26	1	500983-1	STUD, IDLER SPROCKET					
27	1	5006584-2	ARM, TAKE UP					
28	1	516045-5	ROLLER, BELT TAKEUP					
29	1	530619-01	ASSY, IDLER ROLLER					
30	1	531021-01	ASSY, SHUTTLE TABLE					
31	1	531022-03	ASSY, LOWER FEED BELT DR.					
32	1	531105-01	ASSY, HUB					
33	1	531405-01	ASSY, JOGGER TABLE					
34	1	534181-05	SHAFT, FRONT ROLLER					
35	1	536478-02	ASSY, BELT DRIVE PLATE					
36	1	536461-01	ASSY, DRIVE ROLLER DRYER					
37	1	536474-06	TABLETOP, INLET SA304					
38	1	535759-01	ASSY, BRIDGE TIMING BELT					
39	1	538188-01	SKIDBAR SENSOR					
40	1	530226-01	FRAME, .36 IN. EXTENSION RH					
41	1	530236-02	FRAME, .36 IN EXTENSION LH					
42	1	530281-05	PLATE, TABLETOP INSERT RH					
43	1	530281-06	PLATE, TABLETOP INSERT LH					
44	1	546139-02	ASSY, INFED					
45	2	546534-01	INSERT, SA304 AIR BLOCK					
46	1	546541-01	WELDMENT, VACUUM CHAMBER 215W-35					
47	1	SP26803-5L	TABLETOP, LH 36 IN					
48	1	SP26803-5R	TABLETOP, RH 36 IN					

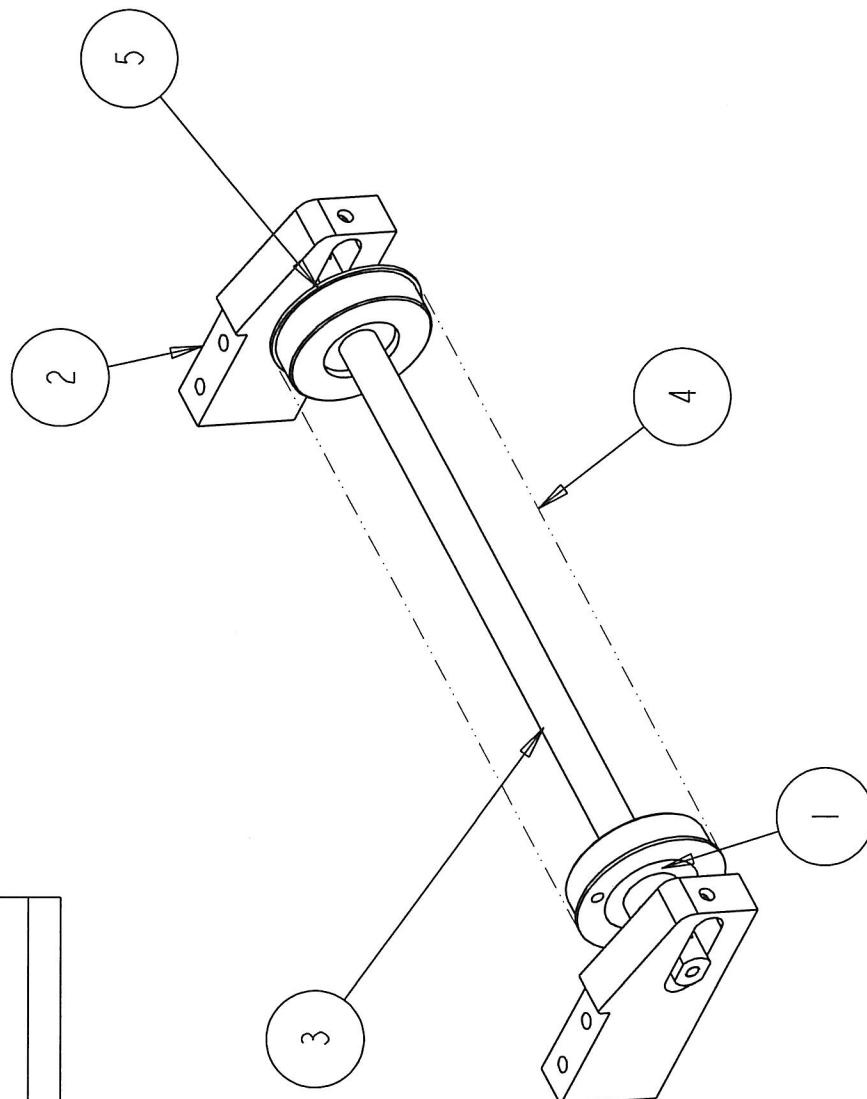
ITEM NO. 5		ITEM NO. 6		ITEM NO. 7		ITEM NO. 8		ITEM NO. 9	
1	108961	1	108961	KIRK RODDY INC.		KIRK RODDY INC.		WOODSTOCK, GEORGIA	
2	500702	2	500702	ITEM NO. 5	ITEM NO. 6	ITEM NO. 7	ITEM NO. 8	ITEM NO. 9	ITEM NO. 10

KIRK RODDY INC.  
WOODSTOCK, GEORGIA  
ASY, TABLETOPS SA304  
ITEM NO. 10

KIRK RODDY INC.  
WOODSTOCK, GEORGIA  
ASY, TABLETOPS SA304  
ITEM NO. 10

ITEM	QTY	PART #	DESCRIPTION
1	2	103804	BEARING, HUB .625
2	2	500716	BRACKET - BELT TAKE-UP
3	1	500823	SHAFT, IDLER ROLLER
4	1	500835	ROLLER, BELT IDLER
5	2	500836	HUB

REV NO	DATE	DESCRIPTION	ECN NO	BY



REQ'D	WHERE USED
1	215

KIRK - RUDY, INC.  
KIRK WOODSTOCK, GEORGIA

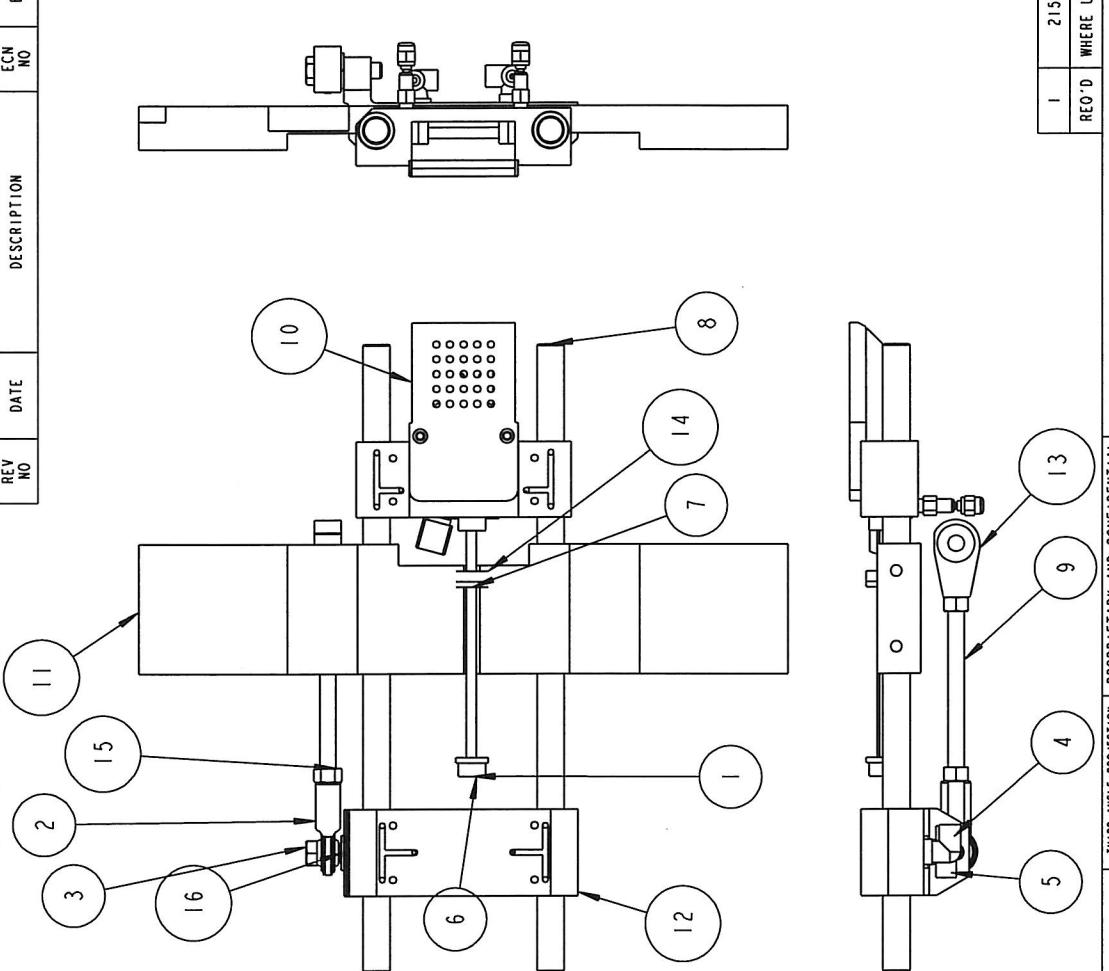
TITLE: ASSY, IDLER ROLLER  
DRAWING # 530619-01

DRAWING # 530619-01

DRAWN BY: TVK		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. WOODSTOCK, GA 30188 USA	
CHECKED BY:		DATE 02 - Mar - 99	.01	.005	ANG. 5			
TRACED BY:		MASTER	REMOVE ALL BURRS, AND SHARP EDGES, UNLESS OTHERWISE NOTED		HEAT TREAT: N / A	MODEL: SP71700	TITLE: ASSY, IDLER ROLLER	
			ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY		FINISH: N / A	SHEET NO: 0F1	DRAWING #	

ITEM QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	2	102225 COLLAR .250					
2	1	103500 BEARING - ROD END					
3	1	107302 BOLT, HEX HEAD 3/8-16X1.50					
4	1	109523 JUNCTION, 2-WAY					
5	1	109524 JUNCTION, 3-WAY					
6	1	500735 ROD - PUSH					
7	2	500737 WASHER - BUMPER					
8	2	500741 SHAFT - FEEDER					
9	1	500749 ROD - FEEDER SLIDE					
10	1	500708A ASSY, VACUUM BODY					
11	1	500710-1 BRACKET - FEEDER SUPPORT					
12	1	500728A ASSY, BUSHING BLOCK					
13	1	500751A ASSY, BEARING BLOCK					
14	1	530253-01 RING					
15	2	RHN012 NUT, HEX 3/8					
16	1	WA013 WASHER, FLAT 3/8					

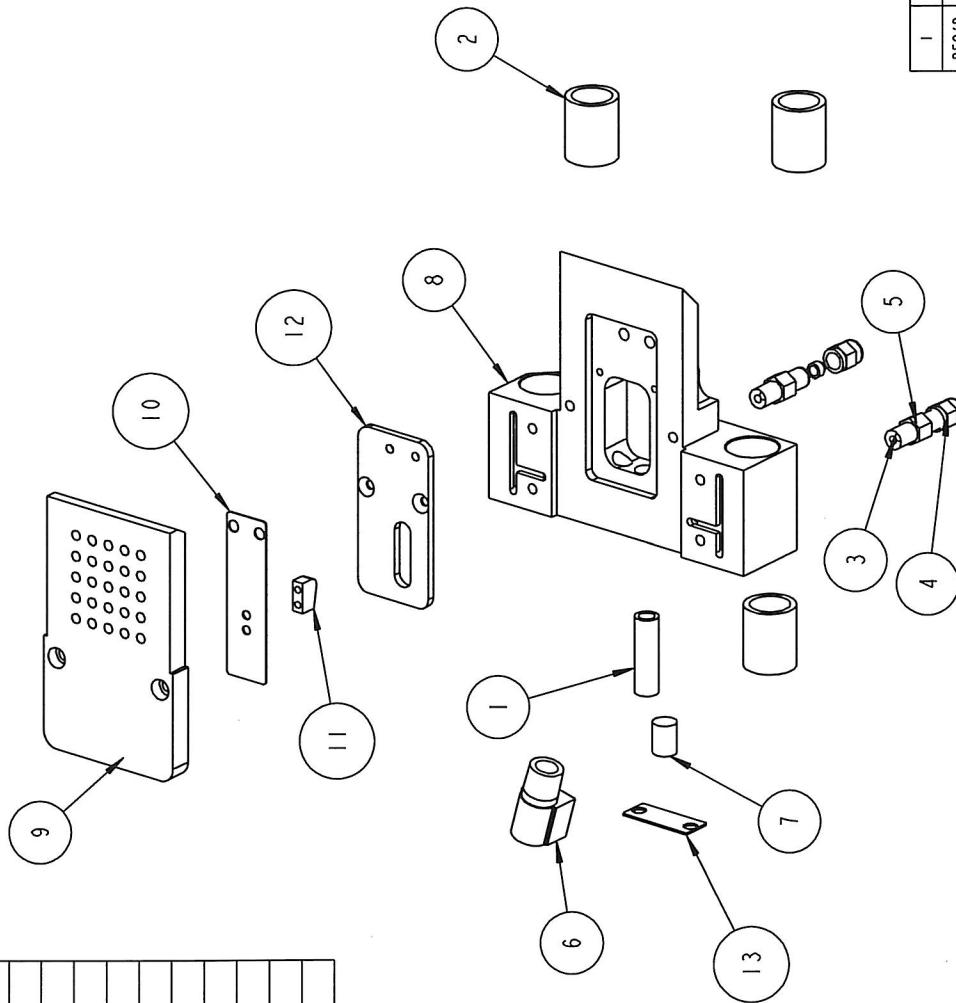
SCALE 0.180



1 215  
REO'D WHERE USED

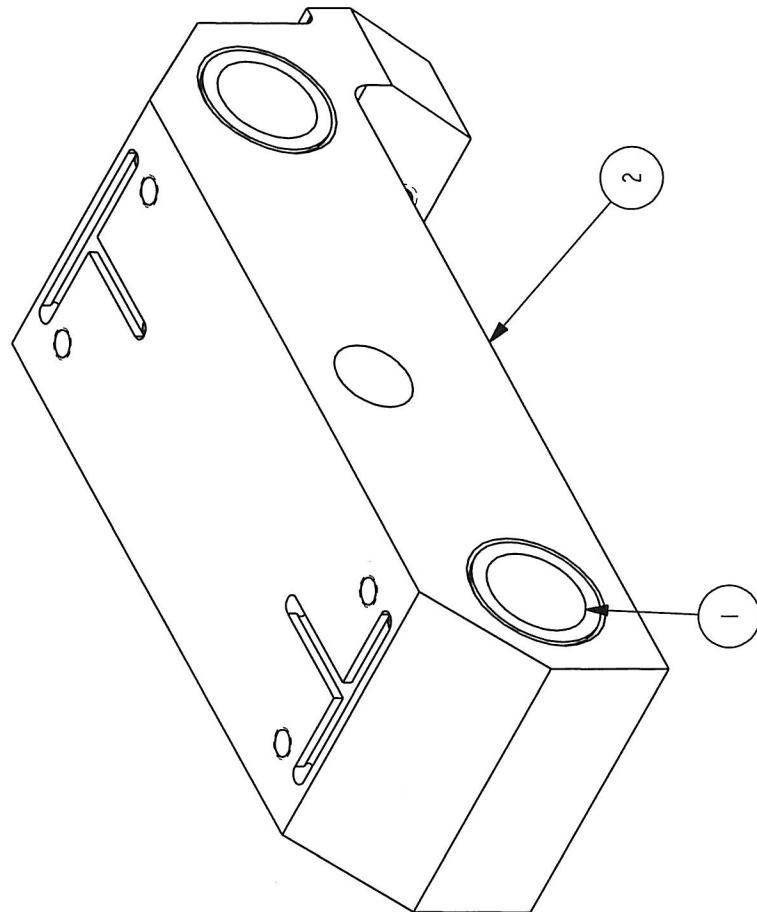
DRAWN BY: TVK	SCALE 0 . 250	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED			MATERIAL: N / A	PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE QUOTED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC. WOODSTOCK, GA 30188 USA	
CHECKED BY:	DATE 05 - May - 98	.xx	.01	.005	AMG.	THIRD ANGLE PROJECTION	KIRK - RUDY, INC. WOODSTOCK, GEORGIA
TRACED BY:	MASTER	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED			HEAT TREAT: N / A	MODEL: 215	TITLE: ASSY, SHUTTLE TABLE
		ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY			FINISH: N / A	SHEET NO. 0F1	DRAWING # 531021-01

ITEM QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	1	100131 BUSHING, SL.250 ID.375 OD.1.250 LG					
2	4	100145 BUSHING, SL.625 ID.813 OD.1.000 LG					
3	2	109521 OIL METER UNIT					
4	2	109528 NUT, COMPRESSION FEMALE					
5	2	109537 SLEEVE, COMPRESSION					
6	1	190606 FITTING - 90 DEG 1/4 NPT					
7	1	190769 MAGNET, BUNTING					
8	1	500708 BODY, VACUUM VALVE					
9	1	500709 PLATE - VACUUM FEEDER					
10	1	500738 SPRING - VALVE					
11	1	500739 BLOCK - PUSHER					
12	1	500740 PLATE - VACUUM					
13	1	531155-01 PLATE, MAGNETIC					



DRAWN BY:	TVK	SCALE	0 . 380	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.
CHECKED BY:		DATE	05 - May - 98	.01 .005 .5	ANG. HEAT TREAT.	MODEL: 215	KIRK - RUDY, INC. WOODSTOCK, GEORGIA
TRACED BY:	MASTER			REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED	N / A	SHEET NO.: OF 1	DRAWING #: ASSY, VACUUM BODY 500708A
				ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY	N / A		

ITEM	QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	4	100145	BUSHING, SL. 6251D.8130D1.0001G					
2	1	500728	BRACKET - FEEDER					



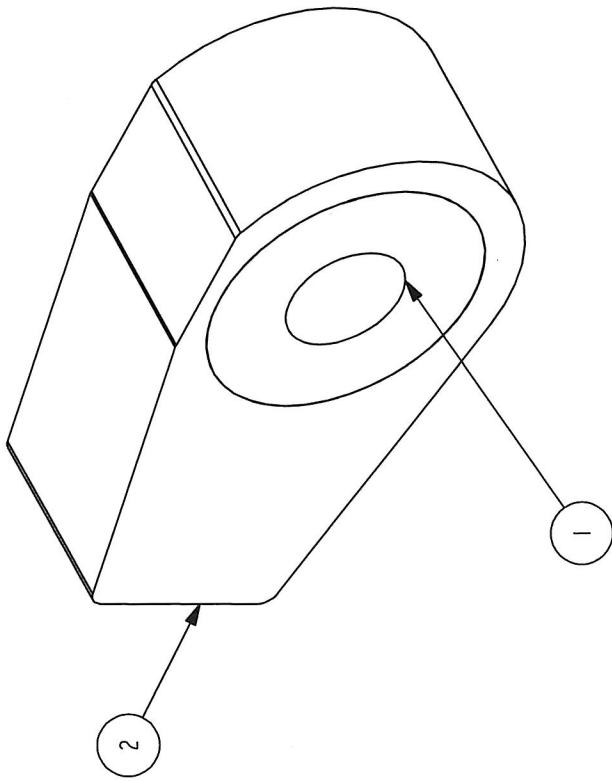
DRAWN BY:	SCALE	1 . 000	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED		MATERIAL:	N / A	THIRD ANGLE PROJECTION	PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE QUOTED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC. WOODSTOCK, GA 30188 USA
CHECKED BY:	DATE		.01 .005 .5 .01 .005 .5 ANG.		HEAT TREAT:	N / A		
TRACED BY:	MASTER	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED		MODEL: 215		TITLE: ASSY, BUSHING BLOCK	SHEET NO: 00F1	DRAWING #
		ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY						500728A

I	531021-01
REO'D	WHERE USED

DRAWING I

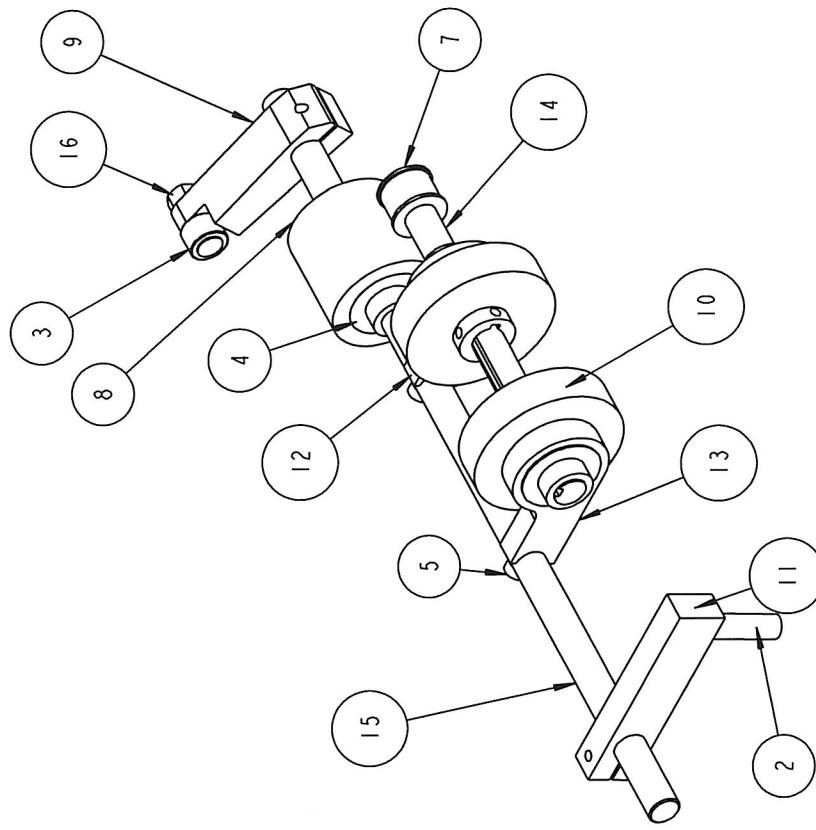
500751A

ITEM	QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	2	103106	BEARING, FLAT . 375					
2	1	500751	YOKE - FEEDER CRANK					



DRAWN BY:	SCALE	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED		MATERIAL:	THIRD ANGLE PROJECTION		PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE COPIED OR REPRODUCED IN WHOLE OR IN PART EXCEPT WITH WRITTEN PERMISSION OF KIRK-RUDY INC. WOODSTOCK, GA 30188 USA	REQ'D WHERE USED
MY	2.000	.01	.005	N/A			KIRK - RUDY, INC. WOODSTOCK, GEORGIA	
CHECKED BY:	DATE			HEAT TREAT:				
	09-Apr-99	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED		N/A				
TRACED BY:	MASTER			FINISH:				
		ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY		N/A				
SHEET NO.:			TITLE:	ASSY, BEARING BLOCK		DRAWING #:	500751A	

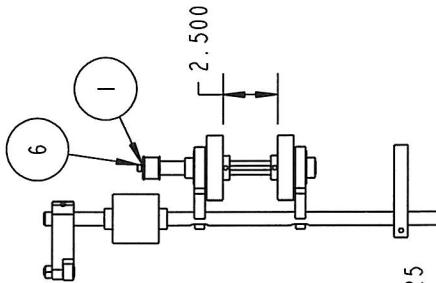
ITEM	QTY	PART #	DESCRIPTION
1	1	100619	WASHER, FLAT 10-32
2	1	102701	SPRING
3	1	103405	CAM FOLLOWER
4	4	103804	BEARING, HUB .625
5	2	107104	BOLT, SHOULDER 5/16X3/4
6	1	107409	SCREW, SHCS 10-32X .500
7	1	109719	PULLEY, TIMING 165M15 .375B .125K
8	1	109722	PULLEY, TIMING 365M15 1.574 DIA
9	1	500734	LEVER - CAM
10	2	500746	ROLLER - BOTTOM FEED
11	1	500786	LEVER, SPRING
12	1	500729-4L	ARM, FEEDER CRADLE HUBBRG LH
13	1	500729-4R	ARM, CRADLE FEEDER HUBBRG RH
14	1	500748-5	SHAFT - FEEDER ROLLER
15	1	500827-1	SHAFT, SPRING LEVER
16	1	RHNO12	NUT, HEX 3/8



SCANNING

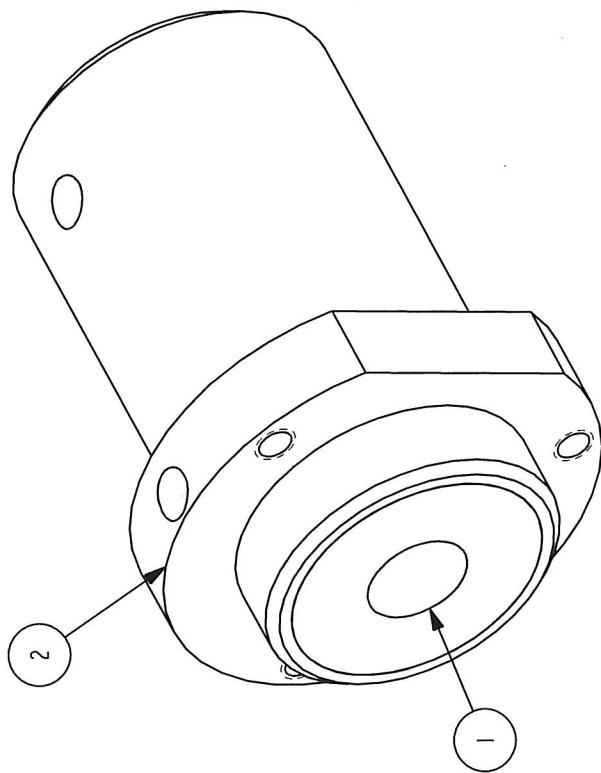
REV NO	DATE	DESCRIPTION	ECN NO	BY
1	11/27/2006	REPLACED 500729-2 W/ REPLACE FLAT BIG W/ HUB BIG	500729-4 6624	TJG
2	08/22/2005	REPLACED WASHER 53-7683-01 WITH 100619	7258	CNC

I	XXX	WHERE USED
REQ'D		



DRAWN BY:	T JG	SCALE	0 . 3   3	MATERIAL:	XXX	THIRD ANGLE PROJECTION	KIRK - RUDY, INC.
CHECKED BY:		DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	.XX - XXX .01 .005 .5	ANG.	XXX		R WOODSTOCK, GEORGIA
TRACED BY:		DATE	02 - NOV - 99	HEAT TREAT:	XXX	NOTE:	PROPRIETARY AND CONFIDENTIAL MADE FOR KIRK-RUDY INC. NO COPIES OR REPRODUCED EXPRESSED WRITTEN PERMISSION OF KIRK-RUDY INC. WOODSTOCK, GA 30188 USA
		FINISHES:			XXX	ASSY , LOWER FEED BELT DR.	TITLE:
						SHEET NO.: 1 OF 1	DRAWING #: 531022-03

ITEM QTY	PART #	DESCRIPTION
1	2	103804 BEARING, HUB .625
2	1	500718 HUB - SHAFT BEARING

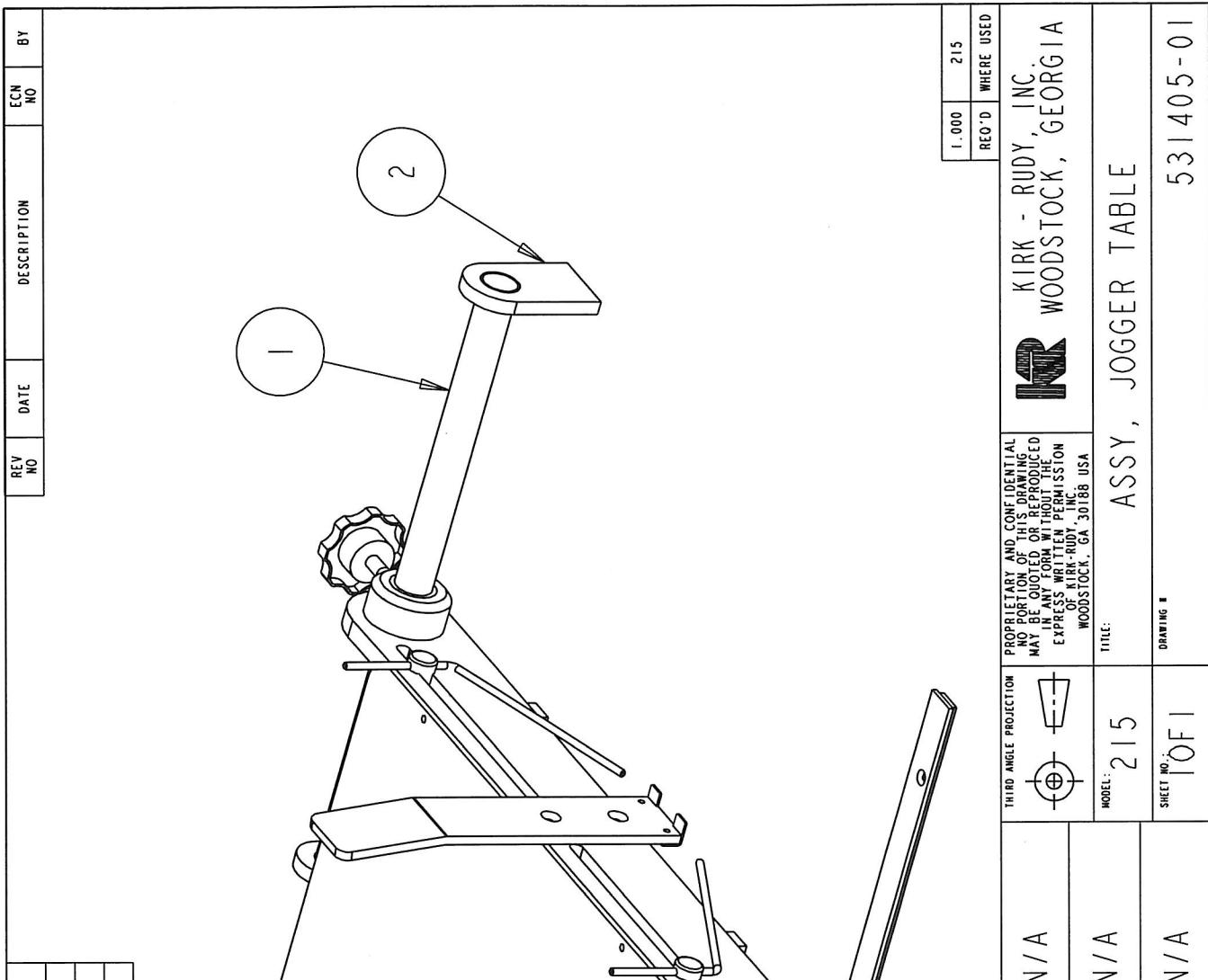


REV NO	DATE	DESCRIPTION	ECN NO	BY

1	536176-01	REO'D WHERE USED
2	15	MODEL:
3	ASSY, HUB	TITLE:
4	DRAWING #	SHEET NO. OF 1
5	531106-01	

DRAWN BY: MY	SCALE 1.000	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. WOODSTOCK, GA 30188 USA
CHECDED BY:	DATE 12-Apr-99	.XX .01 .005 .005 ANG.	RE-TREAT: N/A		
TRACED BY:	MASTER	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED ALL DIMENSIONS ARE IN INCHES DO NOT SCALE - WORK TO DIMENSIONS ONLY	FINISH: N/A		

ITEM QTY	PART #	DESCRIPTION
1	1	500769 SHAFT - REAR GUIDE
2	2	500832 BRACKET-REAR-GUIDE
3	1	536892-01 ASSY, REAR BRIDGE



ITEM QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	1	500769 SHAFT - REAR GUIDE					
2	2	500832 BRACKET-REAR-GUIDE					
3	1	536892-01 ASSY, REAR BRIDGE					

DRAWN BY: TVK	SCALE 0 .250	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. WOODSTOCK, GA 30188 USA
CHECKED BY:	DATE 02-Mar-99	.XX	.XXX	.01	HEAT TREAT: N/A	MODEL: 215	TITLE: ASSY, JOGGER TABLE
TRACED BY:	MASTER	.005	.5		FINISH: N/A	SHEET NO. OF 1	DRAWING ■
					ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY		531405-01

Drawing # 536892-01					
ITEM / QTY	PART #	DESCRIPTION	REV NO	DATE	ECN NO
1	1	BUSHING, SL1.0001D1.2500D1.500LG			BY
2	1	102112 KNOB			BY
3	1	105601 SHAFT, THREADED 3/8-16			BY
4	1	500714 BRIDGE - READ GUIDE			BY
5	1	500715 PLATE - REAR CENTER GUIDE			BY
6	1	500770 HUB - REAR GUIDE SHAFT			BY
7	2	500771 CLIP-SIDE GUIDE			BY
8	1	500845 TABLE, JOGGER			BY
9	2	500847 BRACE, COMPUTER FORM REST			BY
10	1	500764AL ASSY, LIFTER			BY
11	1	500764AR ASSY, LIFTER			BY
12	1	500880-2 BRACKET, JOG TABLE SUPPORT			BY
13	1	535813-01 BAR, SLIDE			BY
14	1	535813-02 BAR, SLIDE			BY
15	1	535814-01 BLOCK, SLIDE			BY
16	1	536191-01 BAR, LOCKING			BY
17	1	536405-01 ASSY, JOGGER TABLE SLIDE			BY

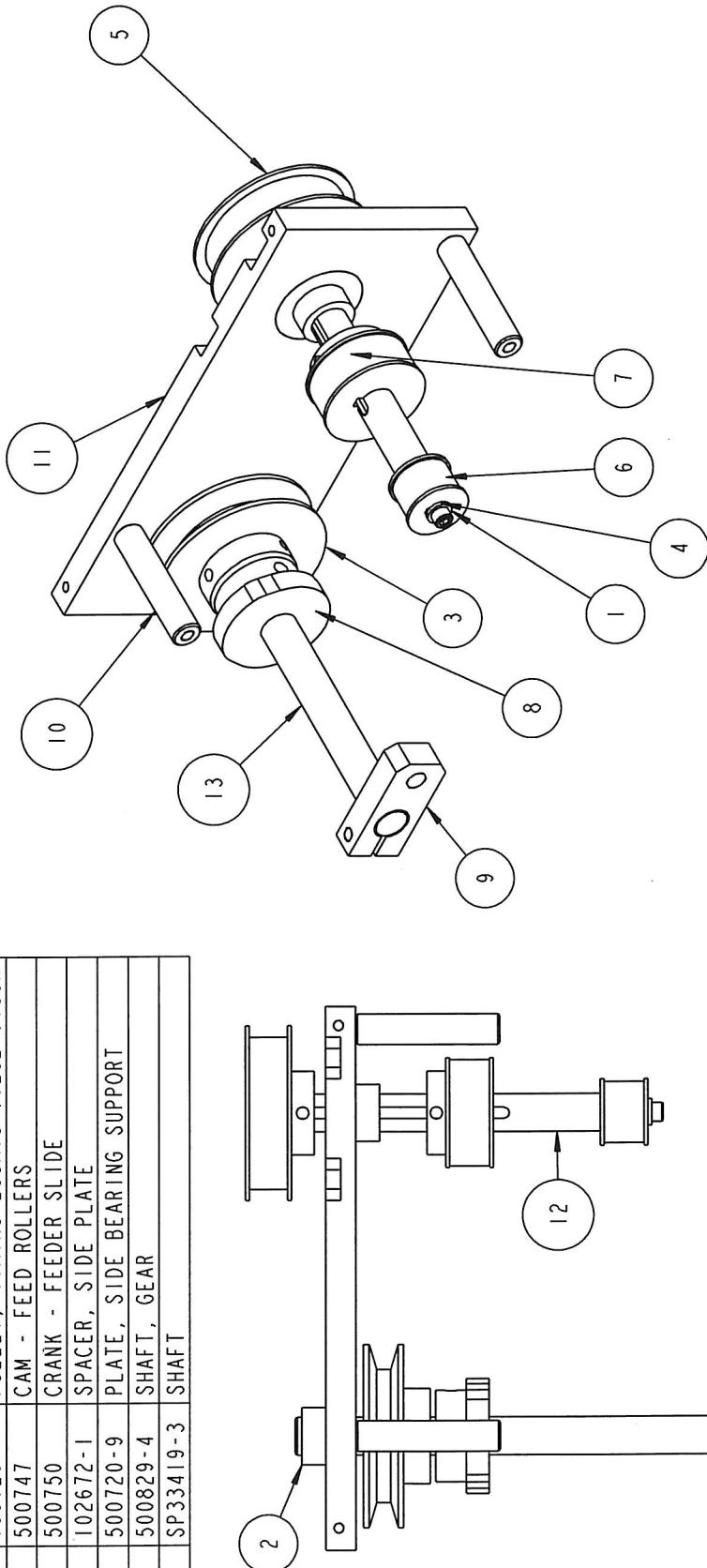
1	536892-01
REV D	WHERE USED
<b>KIRK-RUDY, INC.</b> <b>KR</b> WOODSTOCK, GEORGIA	

Drawing # RHM		SCALE 0 .250	DIMENSIONS OR TOLERANCES		Material: N/A	Finish Projector:
			IN	MM	Mat. IN: 1	Mat. MM: 1
CHECKED #: 21 - Mar - 02			REMOVED FROM PRINT		N/A	Model: 215
TRACED BY: MASTER			SHARPENED AND TRACED OTHERWISE NOTED		Finish: N/A	Sheet No: 10F1
			ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY			Serial No: 536892-01

ITEM	QTY	PART #	DESCRIPTION
1	1	100619	WASHER, FLAT 10-32
2	2	103804	BEARING, HUB 625
3	1	105021	V-PULLEY, AK30
4	1	107409	SCREW, SHCS 10-32X .500
5	1	10841	PULLEY, TIMING 21L050 .625B .188K
6	1	109719	PULLEY, TIMING 165M15 .375B .125K
7	1	109720	PULLEY, TIMING 285M15 .625B .188K
8	1	500747	CAM - FEED ROLLERS
9	1	500750	CRANK - FEEDER SLIDE
10	2	102672-1	SPACER, SIDE PLATE
11	1	500720-9	PLATE, SIDE BEARING SUPPORT
12	1	500829-4	SHAFT, GEAR
13	1	SP33419-3	SHAFT

REV NO	DATE	DESCRIPTION	ECN NO	BY
1	3/22/2000	REPLACED 500120 W/500720-9 REPLACE FLAT BKG W/HUB BKG.	6537	TJG
2	8/22/2005	REPLACED WASHER 537683-01 WITH 100619	7258	CNC

I	215IJ
REQ'D	WHERE USED



DRAWN BY:  
T JG

SCALE  
0 . 375

THIRD ANGLE PROJECTION



MATERIAL:  
N / A

DIMENSIONAL TOLERANCES  
UNLESS OTHERWISE NOTED

.01 .005 .005 .015

HEAT TREAT:  
N / A

FINISH:  
N / A

ALL DIMENSIONS ARE  
IN INCHES UNLESS  
NOTED  
TO DIMENSIONS ONLY

KIRK - RUDY, INC.  
WOODSTOCK, 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.

WOODSTOCK, GA 30188 USA

MODEL: SP79000

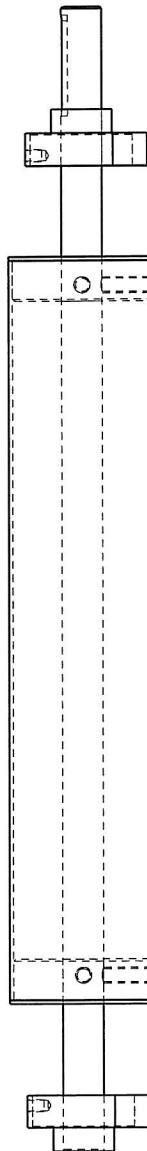
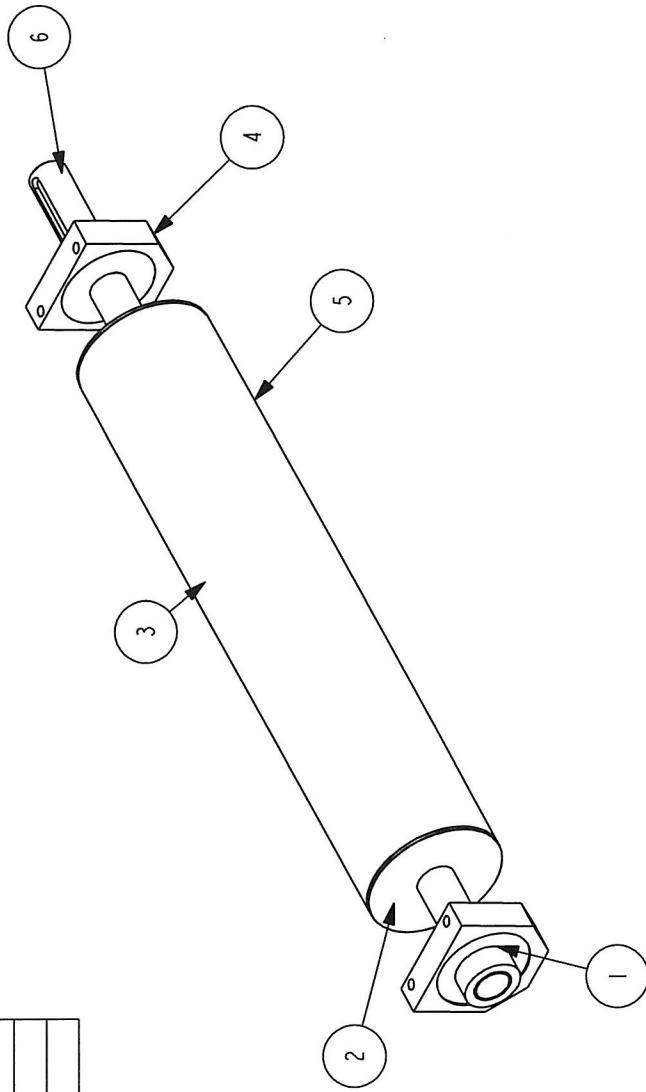
TITLE: ASSY, BELT DRIVE PLATE

SHEET NO: 10F1

DRAWING #

536178-02

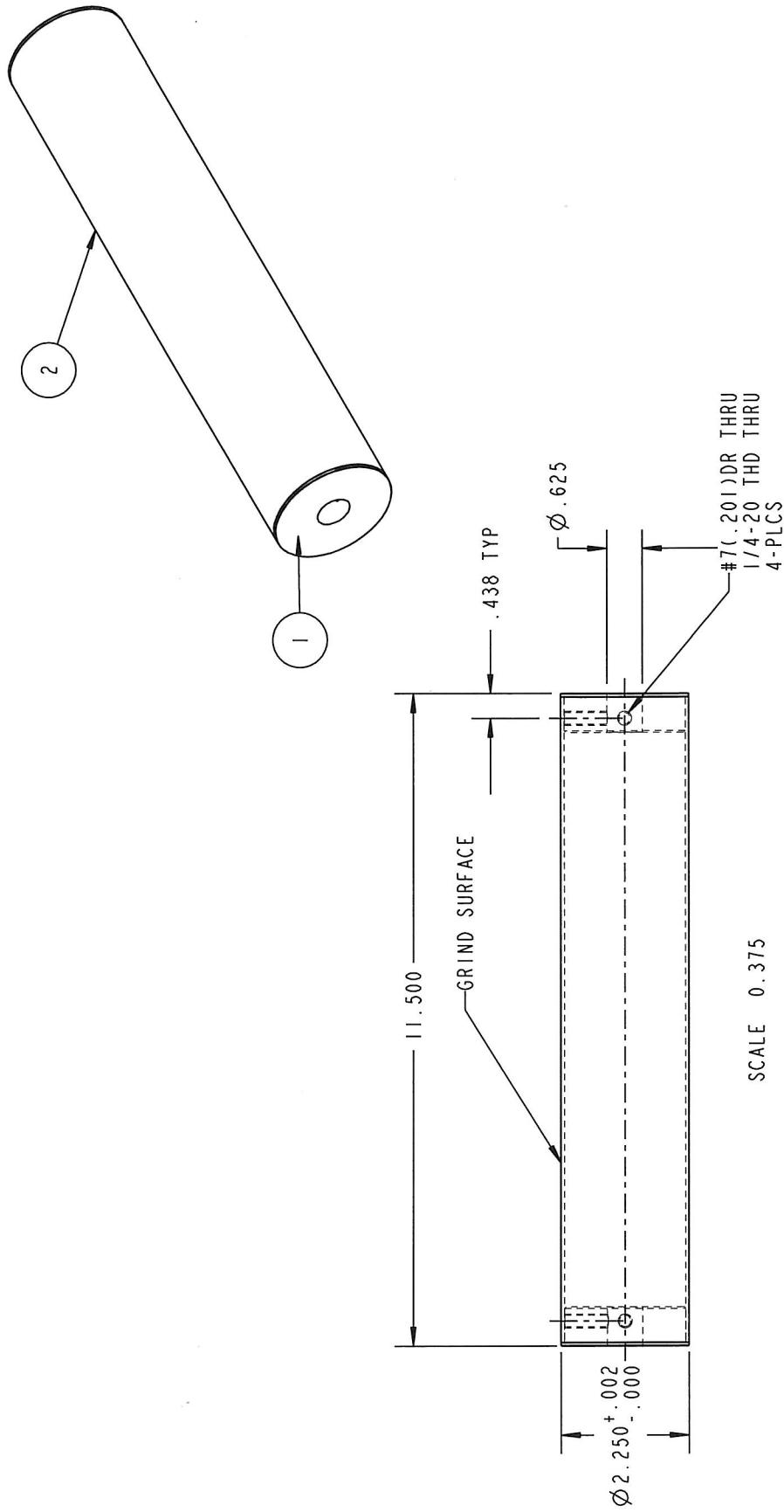
ITEM QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	2	103804 BEARING, HUB .625					
2	2	500839 HUB-BELT DRIVE					
3	1	500742-4 ROLLER, TUBE BELT DRIVE					
4	2	500819-1 BLOCK, BEARING					
5	1	530676-01 ASSY, ROLLER FRONT DRIVE					
6	1	534181-02 SHAFT, FRONT ROLLER					



DRAWN BY: T JG	SCALE 0 . 375	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED			MATERIAL: N / A	THIRD ANGLE PROJECTION - - -	REF'D WHERE USED 1 536471-01
CHECKED BY:	DATE 27-Aug-99	.01	.005	.5	HEAT TREAT: N / A	KIRK - RUDY, INC. WOODSTOCK, GEORGIA	
TRACED BY:	MASTER	REMOVE ALL BURS AND SHARP EDGES UNLESS OTHERWISE NOTED			FINISH: ALL DIMENSIONS ARE IN INCHES DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY	SP 76-500	SHEET NO: 1 OF 1
						ASSY, DRIVE ROLLER DRYER	DRAWING # 536467-01

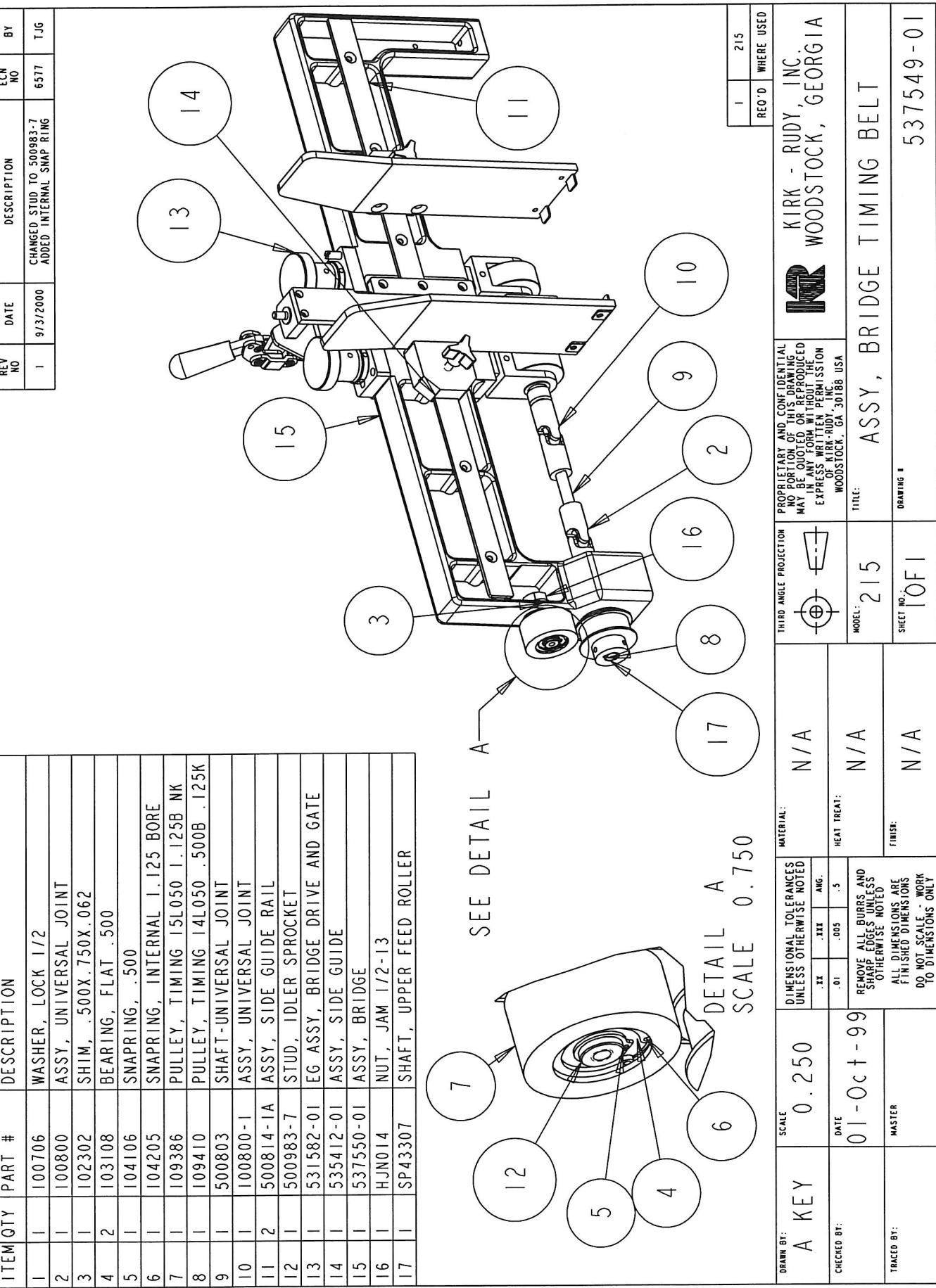
DRAWING # 530676-01

ITEM	QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	2	500839	HUB-BELT DRIVE	1	10/5/2004	ADDED GRIND SURFACE AND 00 TOLERANCE	7100	TJG
2	1	500742-4	ROLLER, TUBE BELT DRIVE					



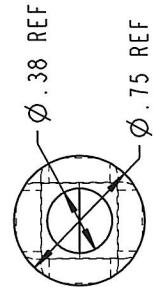
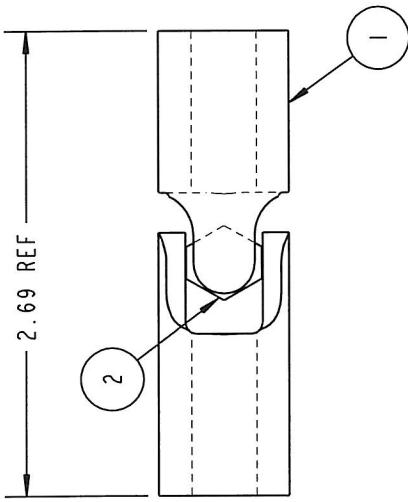
DRAWN BY:	SCALE	NOTES	THIRD ANGLE PROJECTION	PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE QUOTED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC.
TJG	0.375	MATERIAL: .01 .005 .5 .005 ANG. HEAT TREAT: N/A		KIRK - RUDY, INC. WOODSTOCK, GEORGIA
CHECKED BY:	DATE	REMOVE ALL BURS AND SHARP EDGES UNLESS OTHERWISE NOTED	MODEL: 215	WOODSTOCK, GA 30188 USA
TRACED BY:	MASTER	ALL DIMENSIONS ARE FINAL SHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY	SHEET NO: 10F1	TITLE: ASSY, ROLLER FRONT DRIVE DRAWING # 530676-01

ITEM QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	100706	WASHER, LOCK 1/2	1	9/3/2000	CHANGED STUD TO 500983-7 ADDED INTERNAL SNAP RING	6577	TJG
2	100800	ASSY, UNIVERSAL JOINT					
3	102302	SHIM, .500X.750X.062					
4	2	103108 BEARING, FLAT .500					
5	104106	SNAPRING, .500					
6	104205	SNAPRING, INTERNAL 1.125 BORE					
7	109386	PULLEY, TIMING 15L050 1.125B NK					
8	109410	PULLEY, TIMING 14L050 .500B .125K					
9	1 500803	SHAFT-UNIVERSAL JOINT					
10	1 100800-1	ASSY, UNIVERSAL JOINT					
11	2 500814-1A	ASSY, SIDE GUIDE RAIL					
12	1 500983-7	STUD, IDLER SPROCKET					
13	1 531582-01	EG ASSY, BRIDGE DRIVE AND GATE					
14	1 535412-01	ASSY, SIDE GUIDE					
15	1 537550-01	ASSY, BRIDGE					
16	1 HJN014	NUT, JAM 1/2-13					
17	1 SP43307	SHAFT, UPPER FEED ROLLER					



DRAWING # 100800

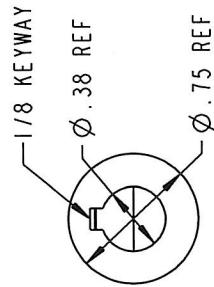
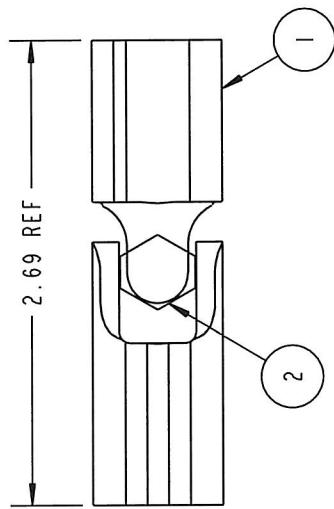
ITEM	QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	2	100800_1	UNIVERSAL	1	2-11-98	RE-DRAWN IN PRO-E	6254	MJG
2	1	100800_3	UNIVERSAL					



SCALE	1 .000	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED				PURCHASED		
		.XXI	.XXX	.005	.5	ANG.	HEAT TREAT:	
DRAWN BY:							N/A	
CHECKED BY:	30-MAY-90							
TRACED BY:	MASTER							

REO'D	WHERE USED
1	531679-01
1	500704-A
KIRK - RUDY INC. WOODSTOCK, GEORGIA WOODSTOCK, GA 30188 USA	
THIRD ANGLE PROJECTION	
MATERIAL:	
REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED	
ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY	
MODEL: 215	TITLE: ASSY , UNIVERSAL JOINT
SHEET NO. 1 OF 1	DRAWING #

ITEM	QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	2	100800-1-1	UNIVERSAL	1	2-11-98	RE-DRAWN IN PRO-E	6254	NJG
2	1	100800-3	UNIVERSAL					

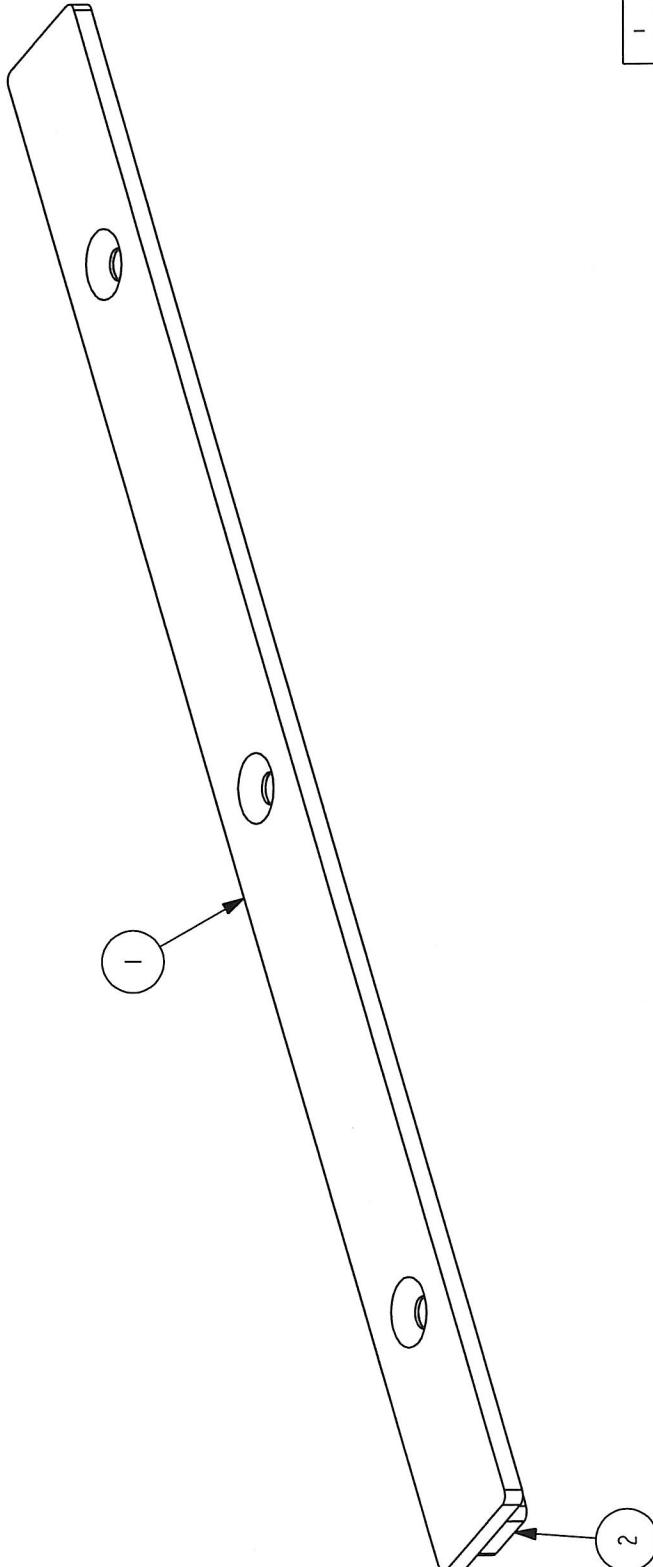


RECD WHERE USED	1	531679-01
	1	500704-A
DRAWN BY:	Y0	SCALE .000
CHECKED BY:	31 - JULL - 79	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED
TRACED BY:	MASTER	MATERIAL: PURCHASED DATE .01 .005 .5 .005 .005 .5 ANG. HEAT TREAT: N/A FINISH: ALL DIMENSIONS ARE IN INCHES DO NOT SCALE - WORK TO DIMENSIONS ONLY
		THIRD ANGLE PROJECTION
		NO PORTION OF THIS DRAWING MAY BE QUOTED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC. WOODSTOCK, GA 30188 USA
MODEL:	215	TITLE: ASSY, UNIVERSAL JOINT
SHEET NO:	OF 1	DRAWING # 100800-1

DRAWING I

5008 | 4 - I A

ITEM QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	500814-1	RAIL - SIDE GUIDE					
2	500814-2	RAIL - SIDE GUIDE					



**REQ'D WHERE USED**

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DY, INC.

GEORGIA

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008 | 4 = | A

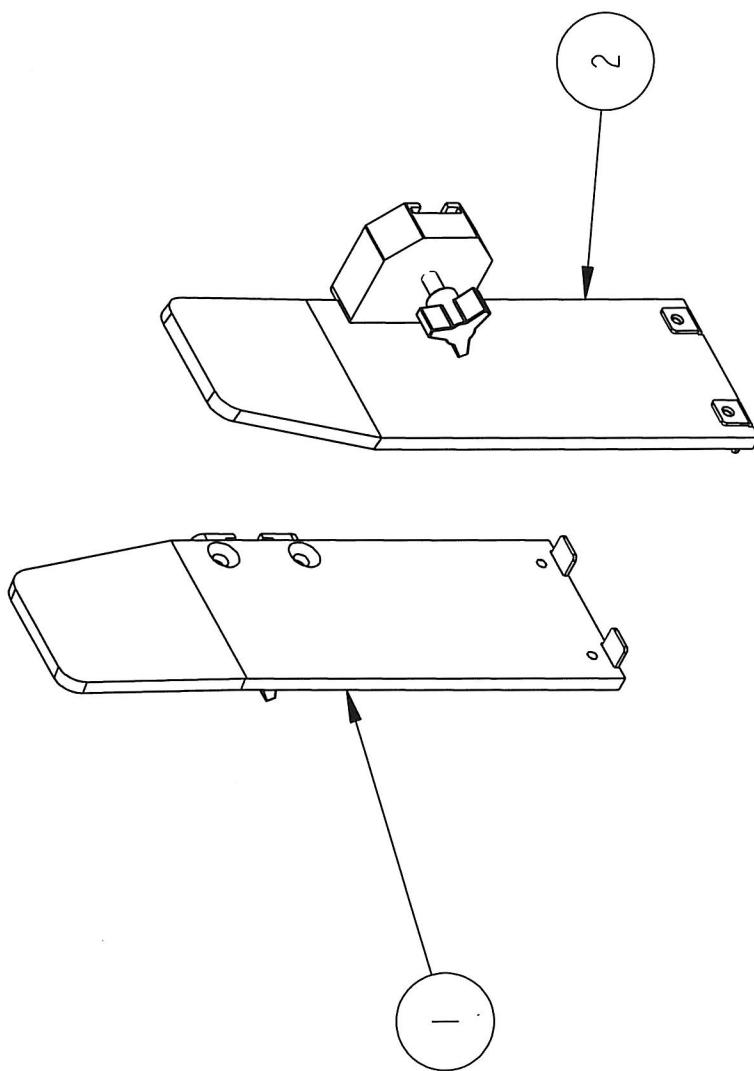
DRAWN BY:	MY	SCALE	1 . 000	MATERIAL:	N / A	THIRD ANGLE PROJECTION	PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE QUOTED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC. WOODSTOCK, GA 30188 USA
CHECKED BY:		DATE	12 - Apr - 99	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	.01 .005 .5	HEAT TREAT:	N / A
TRACED BY:	MASTER			REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED	MODEL: 215 TITLE: ASSY , SHEET NO: 1 OF 1 DRAWING #		
				ALL DIMENSIONS ARE FINISHED DIMENSIONS 0.0 NOT SCALE, WORK TO DIMENSIONS ONLY		FINISH: N / A	

ITEM #	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	REV NO	DATE
1	1	WASHER, THRUST TW31					
2	2	WASHER, THRUST					
3	2	BEARING, ONEWAY .375					
4	1	COLLAR .250					
5	1	SHIM .375X.625X.125					
6	2	SPRING					
7	4	BEARING, FLAT .375					
8	2	BOLT - HEX HEAD					
9	1	SPIDER - ROLLER DRIVE					
10	1	LEVER - QUICK RELEASE					
11	1	PLATE, GATE FEEDER					
12	1	SHAFT - TOP ROLLER DRIVE					
13	1	SHAFT - TOP ROLLER ASSY					
14	2	ROLLER, UPPER					
15	2	PLATE - HOLD DOWN					
16	1	PLATE - GATE END					
17	2	NUT - LOCK					
18	2	SLEEVE - THREADED					
19	1	SHAFT - SCREW ADJ					
20	2	FORK ASSY					
21	2	KNOB, ROLLER ADJUSTMENT					
22	2	SPACER					
23	1	COLLAR .102000-2					
24	1	SHAFT - TOP ROLLER					
25	2	COLLAR - TOP ROLLER SHAFT					
26	1	SHAFT - TOP ROLLER					
27	2	ASSY, UPPER FEED ROLLER					
28	1	PLATE - BACK					
29	1	CLAMP - MOUNTING PLATE					
30	1	BLOCK, CLAMP SUPPORT					
31	1	STUD, BRIDGE (LONG)					
32	1	BLOCK - CONNECTOR					
33	1	PLATE, TOP BRIDGE					
34	2	ASSY, FORK WITH BEARINGS					
35	1	531582-01 EG ASSY, BRIDGE DRIVE AND GATE					
36	2	531584-01 EG ASSY, FORK					
37	2	531672-01 BAR, FORK					
38	2	531673-01 YOKE					

1	53341-01	RECD WHERE USED
PROPRIETARY AND CONFIDENTIAL INFORMATION OF KIRK-RUDY, INC. NO PART OF THIS DRAWING MAY BE COPIED OR REPRODUCED EXCEPT WITH WRITTEN PERMISSION OF THE OWNER. KIRK-RUDY, INC., WOODSTOCK, GEORGIA USA		
KR	KIRK - RUDY, INC. WOODSTOCK, GEORGIA	
215	EG ASSY, BRIDGE DRIVE AND GATE	
10F1	531582-01	

SCALE	DIFFERENCE IN TOTAL LENGTH'S	MATERIAL:	NOTES
0 .281		N/A	
IN.	MM.	WEIGHT:	
23 - Sep - 97		N/A	
CHECKED BY:	REPROD. BY:	MAKER:	215
MASTER			10F1

ITEM QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	1	500755AL ASSY, SIDE GUIDE LH					
2	1	500755AR ASSY, SIDE GUIDE RH					

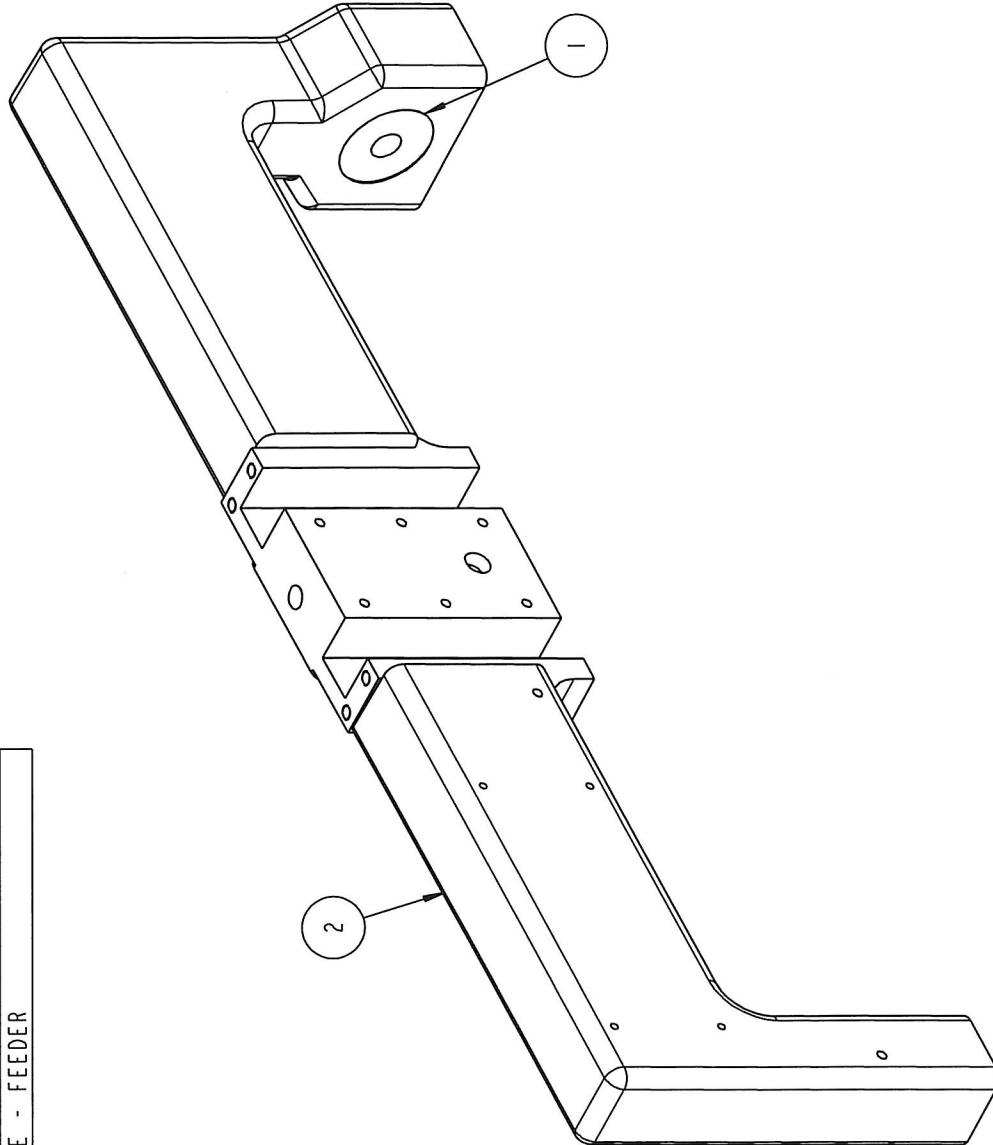


1	535411-01						
REQ'D	WHERE USED						
PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE QUOTED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC. WOODSTOCK, GA 30188 USA							
 <b>KIRK - RUDY, INC.</b> <b>WOODSTOCK, GEORGIA</b>							
MODEL:	215						
TITLE:	ASSY, SIDE GUIDE						
DRAWING #:	535412-01						
SCALE:	0 . 375						
MADE BY:	TVK						
DATE:	06-06-00						
DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	<table border="1"> <tr> <td>.01</td> <td>.005</td> <td>.5</td> </tr> <tr> <td>IN</td> <td>MM</td> <td>ANG.</td> </tr> </table>	.01	.005	.5	IN	MM	ANG.
.01	.005	.5					
IN	MM	ANG.					
HEAT TREAT:	N/A						
FINISH:	N/A						
REMOVED ALL BURS AND SHARP EDGES UNLESS OTHERWISE NOTED	ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY						
MASTER	OF 1						

ITEM	QTY	PART #	DESCRIPTION
1	2	103803	BEARING, HUB .500
2	1	530182-02	BRIDGE - FEEDER

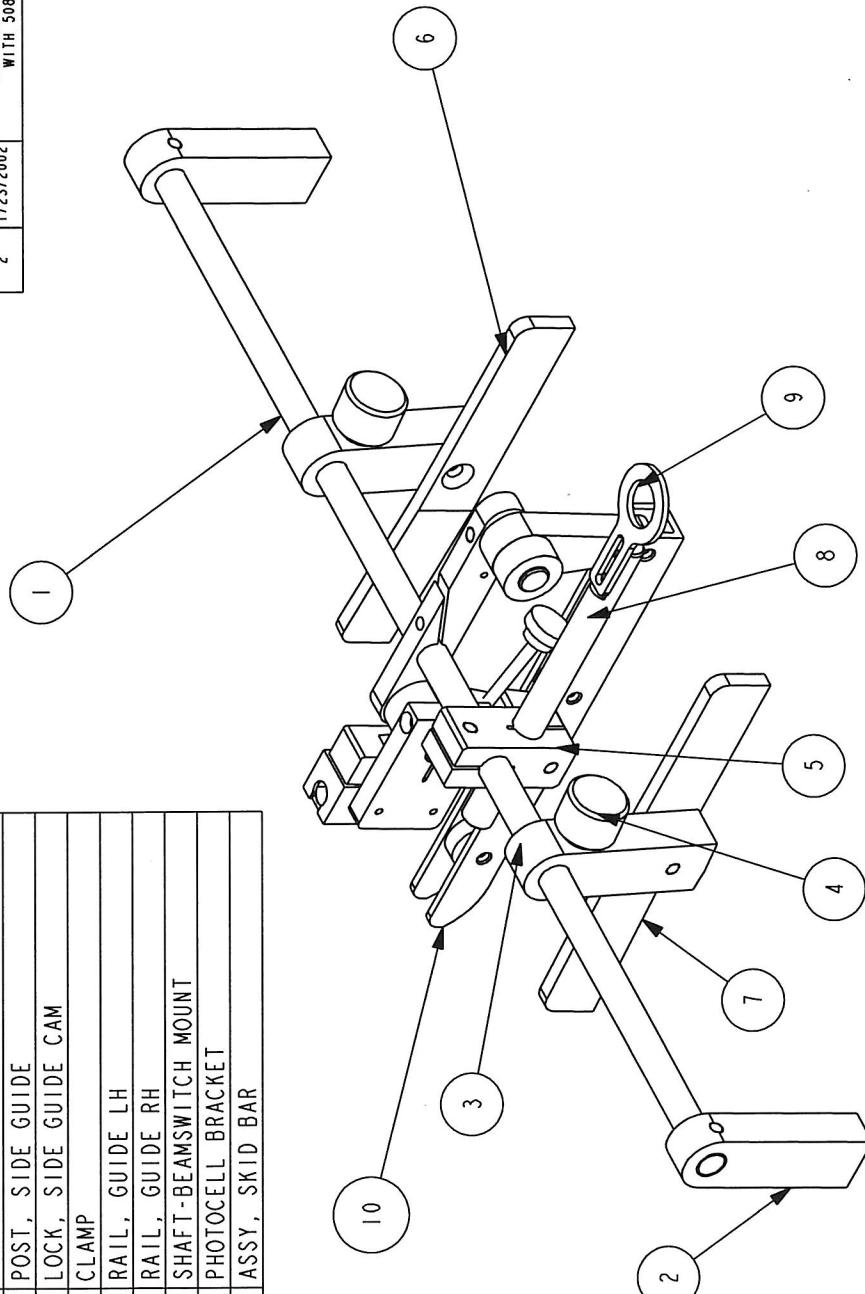
REV NO	DATE	DESCRIPTION	ECN NO	BY
-				

1	SP86900
REQ'D	WHERE USED
<b>KIRK - RUDY, INC. WOODSTOCK, GEORGIA</b>	
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. WOODSTOCK, GA 3088 USA	
THIRD ANGLE PROJECTION	
MATERIAL:	N/A
DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	
.01    .005    .5	HEAT TREAT:
DATE	N/A
06-06-00	FINISH:
REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED	
MASTER	N/A
SHEET NO.	OF 1
ASSY, BRIDGE	
DRAWING #	
537550-01	



DRAWING # 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	2	500793 LOCK, SIDE GUIDE CAM
5	1	508593 CLAMP
6	1	500722-24L RAIL, GUIDE LH
7	1	500722-24R RAIL, GUIDE RH
8	1	508995-4 SHAFT-BEAMSWITCH MOUNT
9	1	508996-2 PHOTOCELL BRACKET
10	1	538021-01 ASSY, SKID BAR



DRAWN BY:	SCALE	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	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.
T JG	0 . 375	.01 .005 .005 .5	N / A		KIRK - RUDY ' INC WOODSTOCK, GEORGIA
CHECKED BY:	DATE	17 - Jan - 00	HEAT TREAT:		WOODSTOCK, GA 30188 USA
TRACED BY:	MASTER	REMOVE ALL BURS AND SHARP EDGES UNLESS OTHERWISE NOTED ALL DIMENSIONS ARE IN INCHES DO NOT SCALE - WORK TO DIMENSIONS ONLY	FINISH:		ASSY, SKIDBAR / SENSOR
				SHEET NO. 10F	DRAWING # 538188-01
				I	REF'D WHERE USED
				1	536491-02

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		

1	KR2191J20
1	KR2191J

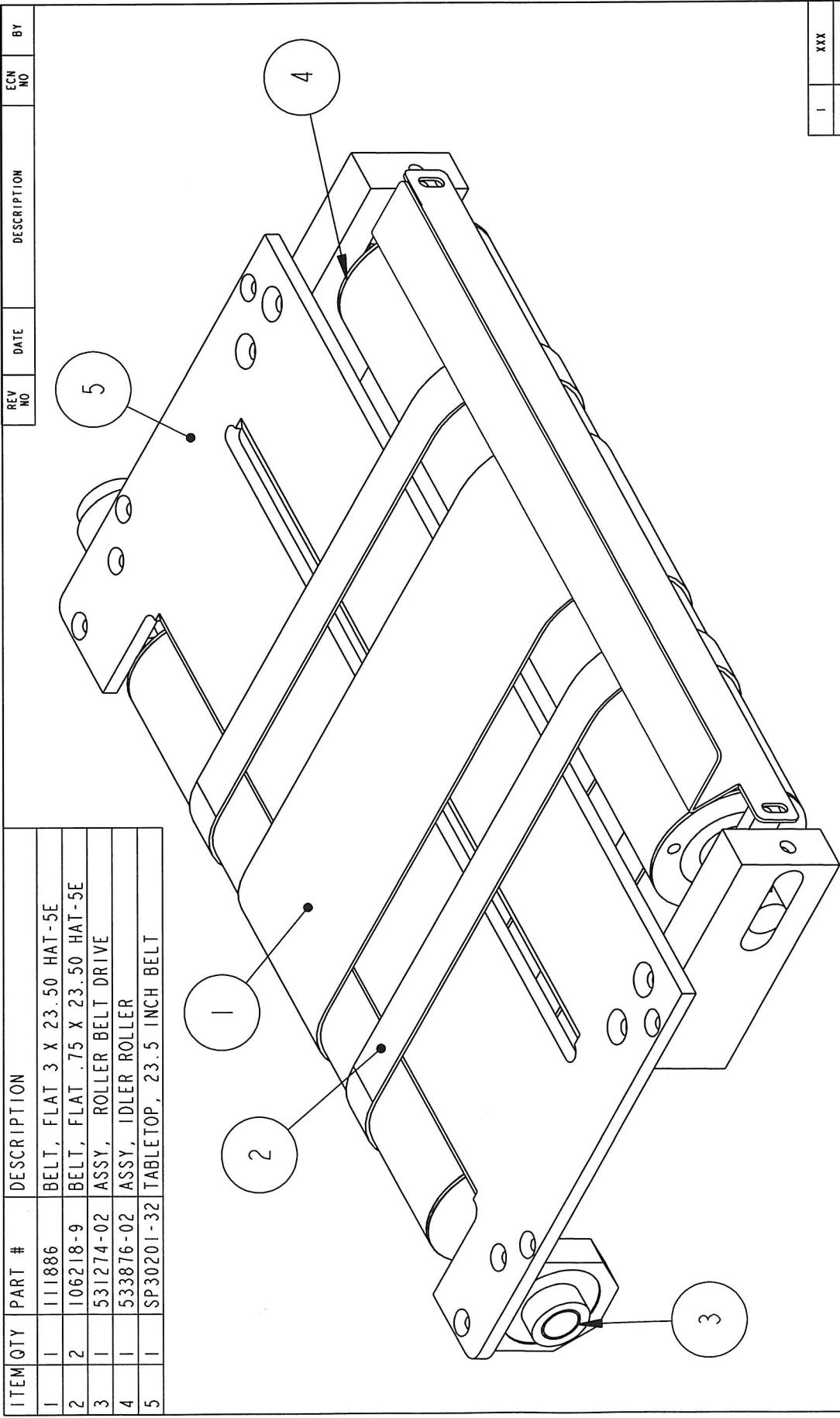
REQ'D WHERE USED

ASSY, SKID BAR

538021-01

DRAWN BY:	SCALE	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	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. WOODSTOCK, GA 30188 USA
A Y B	0 . 750	.01 .005 .5	N / A		KIRK - RUDY ' INC. WOODSTOCK , GEORGIA
CHECHED BY:	DATE	REMOVE ALL BURS AND SHARP EDGES UNLESS OTHERWISE NOTED	HEAT TREAT:		MODEL: 2191J TITLE: ASSY, SKID BAR
TRACED BY:	MASTER	ALL DIMENSIONS ARE FINAL SHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY	FINISH:	SHEET NO: 10F1	DRAWING #

ITEM QTY	PART #	DESCRIPTION
1	111886	BELT, FLAT 3 X 23.50 HAT-5E
2	106218-9	BELT, FLAT .75 X 23.50 HAT-5E
3	531274-02	ASSY, ROLLER BELT DRIVE
4	533876-02	ASSY, IDLER ROLLER
5	SP30201-32	TABLETOP, 23.5 INCH BELT



REV NO	DATE	DESCRIPTION	ECN NO	BY
1	XXX			

REO'D WHERE USED

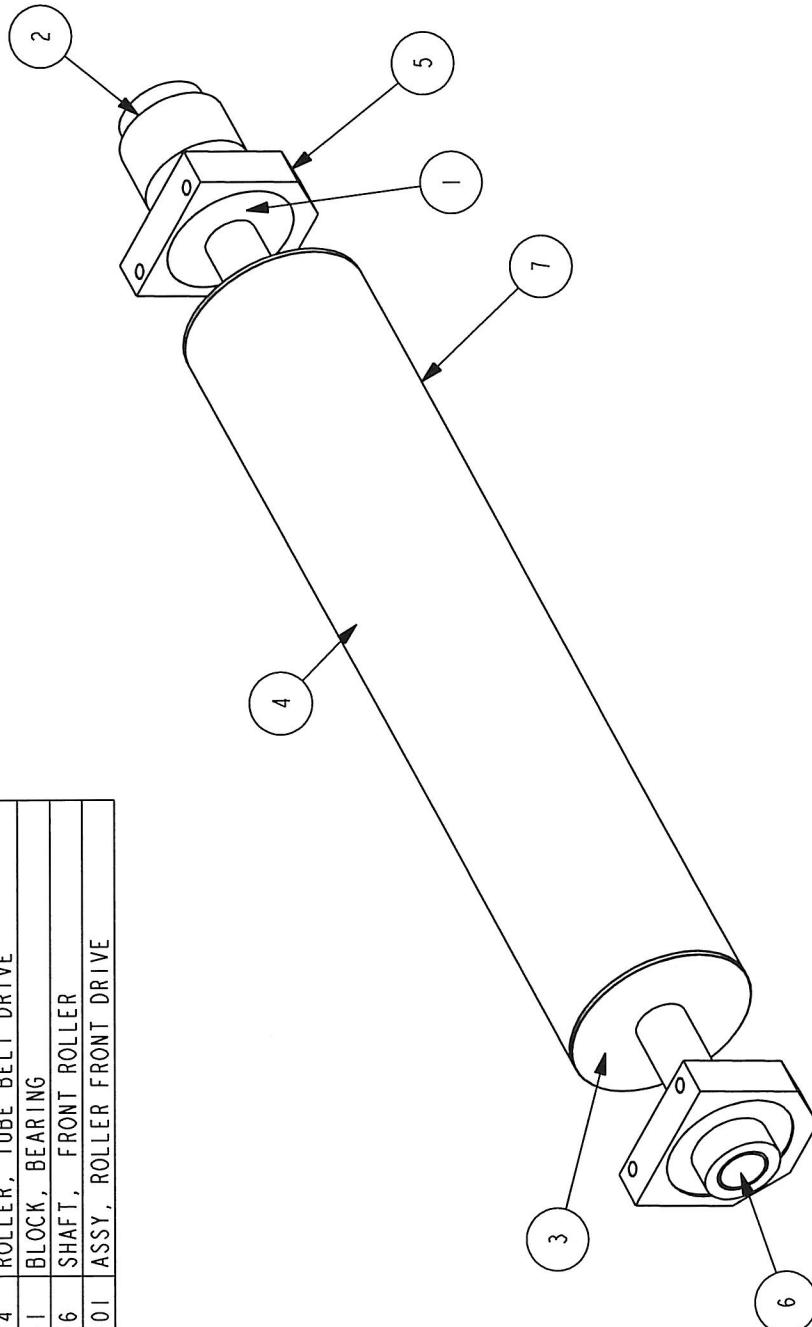
KIRK - RUDY, INC.  
WOODSTOCK, GEORGIA

ASSY, INF EED  
TITLE:  
DRAFTING #

DRAWN BY:	SCALE	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	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.
JMW	0 . 500	.01 .005 .5 .005 .005 .005 ANG.	N / A	-	KIRK - RUDY, INC. WOODSTOCK, GEORGIA
CHECKED BY:	DATE	12 - Nov - 04	HEAT TREAT:	-	TITLE: SA 309
TRACED BY:	MASTER	REMOVE ALL BURS AND SHARP EDGES UNLESS OTHERWISE NOTED	FINISH:	SHEET NO.: 10F	DRAWING #
		ALL DIMENSIONS ARE IN INCHES DO NOT SCALE - WORK TO DIMENSIONS ONLY			546139-02

## ITEM QTY PART # DESCRIPTION

ITEM QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	2	103804 BEARING, HUB .625	1	11-JAN-00	REPLACED 500828-5 WITH 500828-6	6514	TJG
2	1	109721 PULLEY, TIMING 215M15 .500B .125K					
3	2	500839 HUB-BELT DRIVE					
4	1	500742-4 ROLLER, TUBE BELT DRIVE					
5	2	500819-1 BLOCK, BEARING					
6	1	500828-6 SHAFT, FRONT ROLLER					
7	1	530676-01 ASSY, ROLLER FRONT DRIVE					

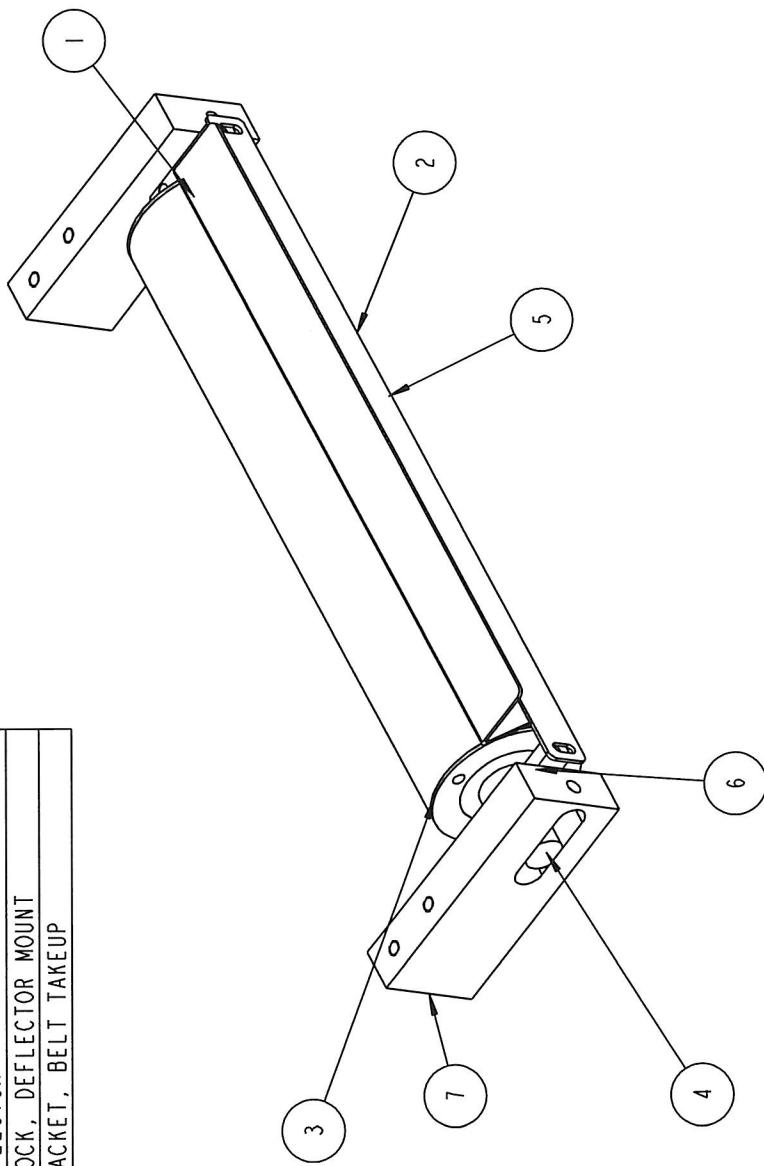


1	215J
REO'D	WHERE USED

REV NO	DATE	DESCRIPTION	ECN NO	BY
1	11-JAN-00	REPLACED 500828-5 WITH 500828-6	6514	TJG

DRAWN BY: TJG	SCALE 0 . 500	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. WOODSTOCK, GA 30188 USA
CHECKED BY:	DATE 04 - Nov - 99	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED .01 .005 .5 .01 .005 .5 ANG.	HEAT TREAT: N / A	MODEL: SP79000
TRACED BY:	MASTER	FINISH: ALL DIMENSIONS ARE FINISHED IN INCHES DO NOT SCALE - WORK TO DIMENSIONS ONLY	N / A	SHEET NO.: 10F1
				DRAWING #: 531274-02

ITEM QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO.	BY
1	2	103804 BEARING, HUB .625					
2	1	500835 ROLLER, BELT IDLER					
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					

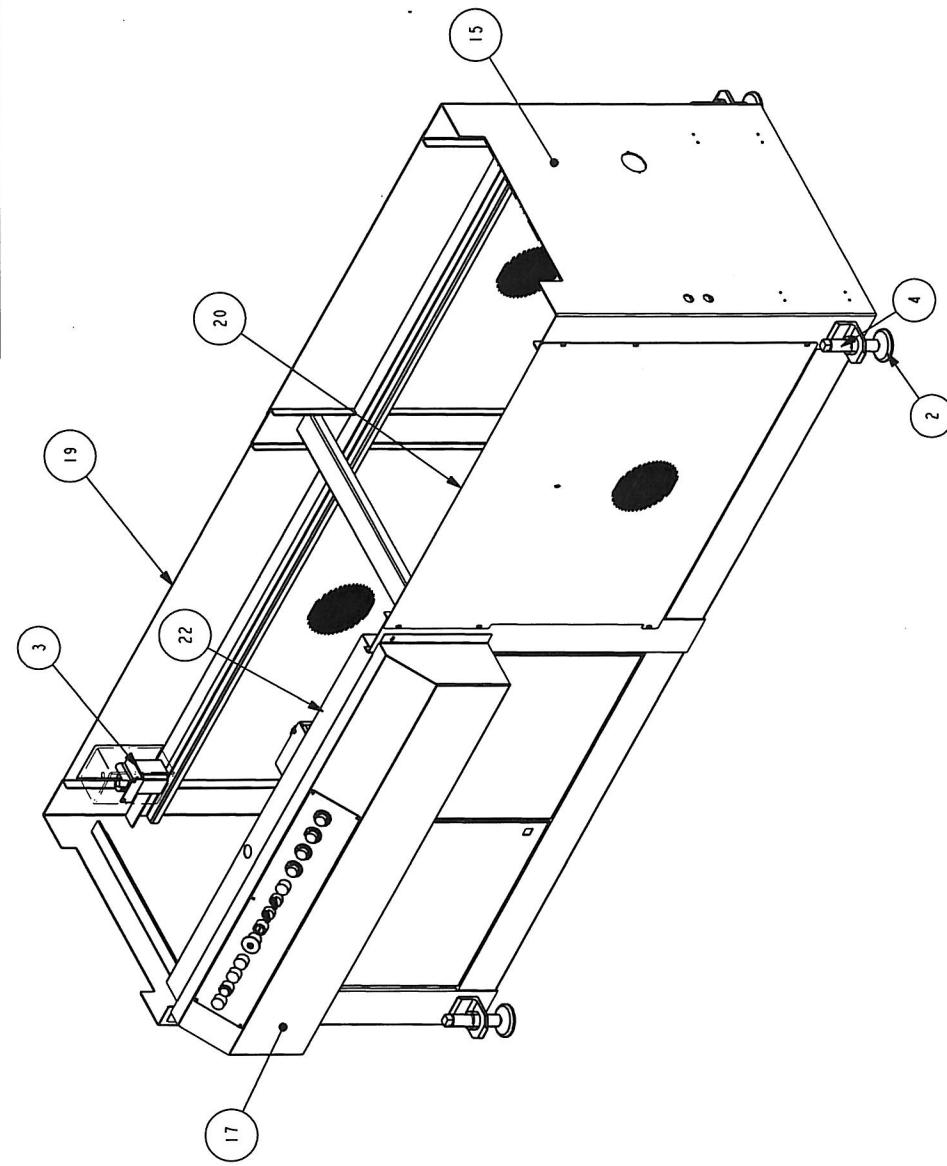


DRAWN BY: T JG	SCALE 0 . 375	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED			MATERIAL: XXX .01 .005 .5 ANG. .01 .005 .5	NOTED NONE	REAR TREAT: NONE	THIRD ANGLE PROJECTION - - -	PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE QUOTED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC. WOODSTOCK, GA 30188 USA	KIRK - RUDY, INC. WOODSTOCK, GEORGIA
CHECKED BY:	DATE 28 - Feb - 00	REMOVE ALL BURS AND SHARP EDGES UNLESS OTHERWISE NOTED			MODEL: SP81400	TITLE: ASSY, IDLER ROLLER				
TRACED BY:	MASTER	ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY			FINISH: NONE	SHEET NO.: 10F1	DRAWING #: 533876-02			

1	536468-02
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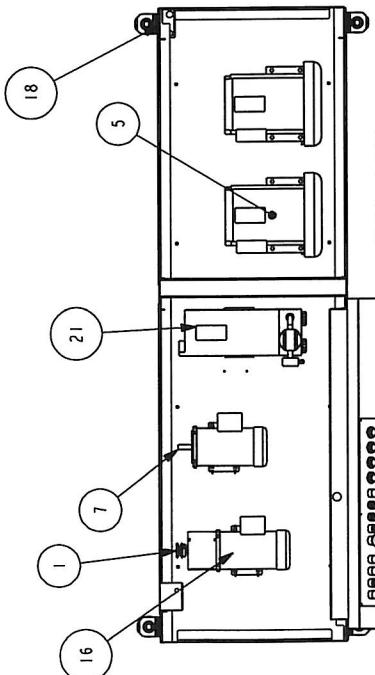


ITEM QTY	PART #	DESCRIPTION	REV	DATE	DESCRIPTION	REV	DATE
1	105026	V-PULLEY, MAVR. 2200					
2	4 190634	FOOT, MOUNTING					
3	1 190637	OIL PUMP					
4	4 191010	LEVELLING BOLT, CABINET					
5	2 200127	BLOWER, GAST					
6	4 209016	KNOB, POT					
7	1 200152-2	MOTOR, LEESON DC 1/2HP					
8	2 201124-2	BUTTON, START					
9	1 201124-4	BUTTON, POWER ON					
10	1 201125-3	BUTTON, STOP					
11	1 201125-5	BUTTON, POWER OFF					
12	2 201126-1	BUTTON, JOG					
13	2 201145-1	SELECTOR, 2 POSITIONS					
14	1 500421-1	PNL. CONTROL					
15	1 500830-4	WLDUNIT, 215x36 INKJET BASE CABL					
16	1 509000-8A	ASSY, MIT/REDUCER SR 1/2HP VERT					
17	1 530068-05	BOX, CONTROL					
18	1 530441-01	BOX, ELECTRICAL INLET 20A					
19	1 530637-01	PANEL, INKJET BASE BACK					
20	2 530638-01	PANEL, 36IN EXT.					
21	1 531168-01	ASSY, 3/4 HP VACUUM PUMP					
22	1 538299-01	INSERT, 215B ELECTRICAL					



DRAWN BY:		SCALE:		MATERIALS:		TEST AND PRODUCTION		PROPRIETARY AND CONFIDENTIAL	
JMW		0 . 100		N / A		N / A		NO COPIES OR DERIVATIVES	
CHECKED BY:		06 - Apr 1 - 06		N / A		N / A		MAY BE COPIED OR REPRODUCED EXCEPT AS PERMITTED BY THE DRAWING CONTRACT, INC. WOODSTOCK, GA, USA	
TRACED BY:		MASTER		N / A		N / A		ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE. WORK TO DIMENSIONS ONLY	
RECD WHERE USED		1 538288-12							

SCALE 0.063



## **6.2 PARTS LIST**

See following pages for parts list.

## **7 ELECTRICAL SCHEMATICS AND PARTS**

---

### **7.1 SCHEMATIC LIST**

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

109500 38 02 215 Dual Motor Inkjet

### **7.2 PARTS LIST**

KR Part #	Qty	Manufacturer	Description
202277	11	IDec	Socket, Relay 700HN116/SH2B-05
202291	11	IDec	Relay, 24VAC 700-HF32A24-4RH28-ULC
202426-2	3	KB	Board, 90VDC Motor KBMM 225D 240VAC
202427-1	1	KB	Resistor, 0.05 Ohm 9839 1/4hp 90VDC Motor
202427-2	2	KB	Resistor, 0.025 Ohm 9841 1/2hp 90V, 1hp 180V
203022-2	1	Micron	Transformer, B050-0021-GA 240VAC
205700	1	Dale	Resistor, RH-50 50W 20Ohm
208021	2	Buss	Fuse, 8 MDL
208022	2	Buss	Fuse, 8A AGC/GGC
208023	6	Buss	Fuse, 12A AGC/GGC
208029	2	Buss	Fuse, 3 2/10 MDL
208030	2	Buss	Fuse, 1 6/10A MDL/GDL
208043	2	Buss	Fuse, 10A MDA/GDL
208044	1	Buss	Fuse, 4A AGC/GGC
208047	1	Buss	Fuse, 4A MDL/GDL
209163	3.188	Phoenix	Din Rail, NS35/7.5 Per Foot
209234	11	Phoenix	Block, Terminal UK16
209236	54	Phoenix	Block, Terminal UK3MVSTB-5.08
209237	3	Phoenix	Terminal, Ground USLKG16
209238	3	Phoenix	End, Block E-UK
209241	9	Phoenix	Cover, End DUK3-MVSTB
209245	1	Phoenix	Holder, Fuse 24V UK6.3-HEILED24
209247	8	Phoenix	Holder, Fuse 250V UK10-Drehsila

## **8 APPENDIX**

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### **8.1 POSSIBLE OPTIONS**

The KR215IJ base can be modified to handle a variety of applications, contact your Kirk-Rudy dealer or call Kirk-Rudy direct to discuss you specific application.

Here is a list of some of the options offered for the KR215IJ base:

- Rubber Tip Feeder Gate
- Inline Label Base for second application head
- Modifications to increase thickness limits
- Auto Load Conveyor. Designed for ease of loading of thick product, automatically maintains pre-determined level in feeder.
- Shuttle “Low Product” Detector (stops machine).

### **8.2 22 IN. SPACING OPTION**

For 22 in. spacing between product, Change Gear Plate 22 in Assembly (535810-01) is used in place of Change Gear Plate 11 in Assembly (535812-01). See following page for 535810-01.

## 9 NOTES

## **10 WARRANTY AND SERVICE**

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### **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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