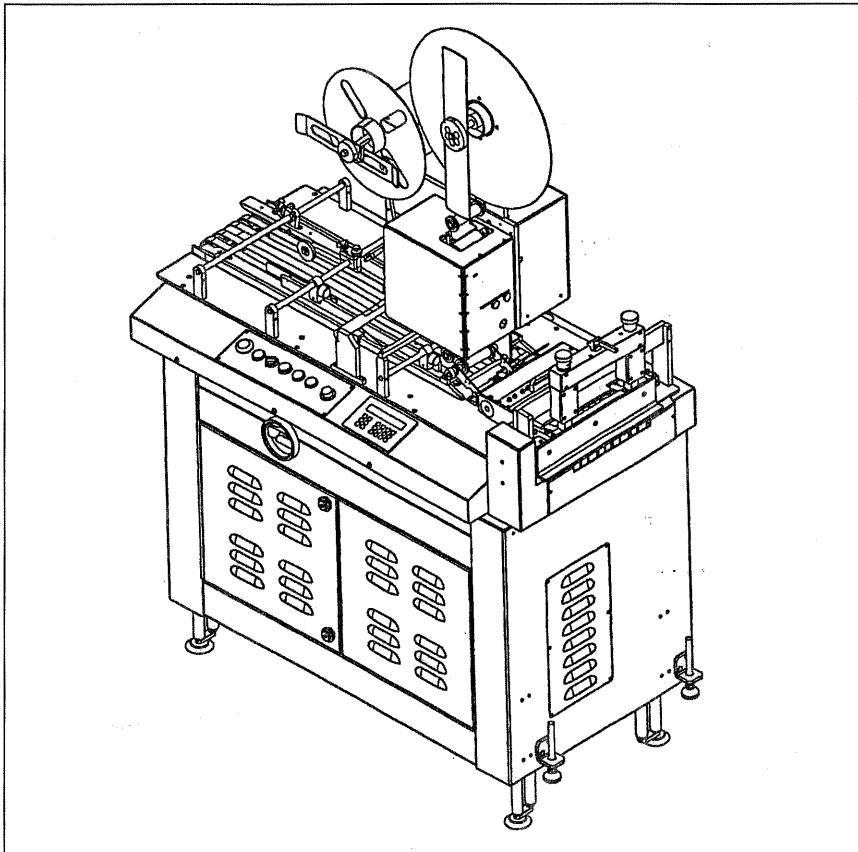


# *Kirk-Rudy Inc.*

## Instruction and Parts Manual

### KR535 Tabmaster



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

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## **1.0 Important Safety Instructions**

Intended Use Statement: The KR535 Tabbing System is designed to apply and fold a pressure sensitive tab or label around the edge of a product in order to seal the product along one edge. It can also be used for simply applying pressure sensitive labels. The system is made up of two major components - the base and head. The tabbing base carries the product underneath the head where a tab is peeled off and applied to the edge of the product. A mechanical plow folds the tab around the edge of the product as it moves through the machine. 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 MISFEED 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 A LICENSED 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.

## 2.0 SPECIFICATIONS

	<u>English</u>	<u>Metric</u>
<b><u>HEAD</u></b>		
Physical size:	28" X 24" X 8"	11.0 X 9.45 X 3.15cm
Weight	60 lbs	27.22 kg
Tabs:		
Material:	Paper, translucent and clear perforated and non-perforated labels.	
Size:	0.75" – 2.00" Diameter	19 – 51 mm
<b><u>Labels:</u></b>		
Minimum:	0.25" W x 1.5" L	6.4 X 38.1 mm
Maximum:	3" W x 2" L	76.2 x 51 mm
<b><u>BASE</u></b>		
Physical size LxWxH:	60" x 24" x 33"	23.62 x 9.45 x 13 cm
Weight:	750 lbs	340.2 kg
Crated Weight:	900 lbs	408.2 kg
<b><u>Substrate:</u></b>		
Minimum:	3.50" x 5.00"	89 x 127 mm
Other sizes available on request		
Maximum:	8.50" x 11.00"	216 x 279.4 mm
Other sizes available on request		
<b><u>Thickness:</u></b>		
Minimum:	Single sheet, 20 lb.	
Maximum:	0.19" thick booklet	4.8 mm

### **MAXIMUM OPERATING SPEEDS**

Single tabbing:	30,000 products / hour
Double tabbing:	30,000 products / hour
<u>Note:</u> Speeds are dependent on material being feed.	

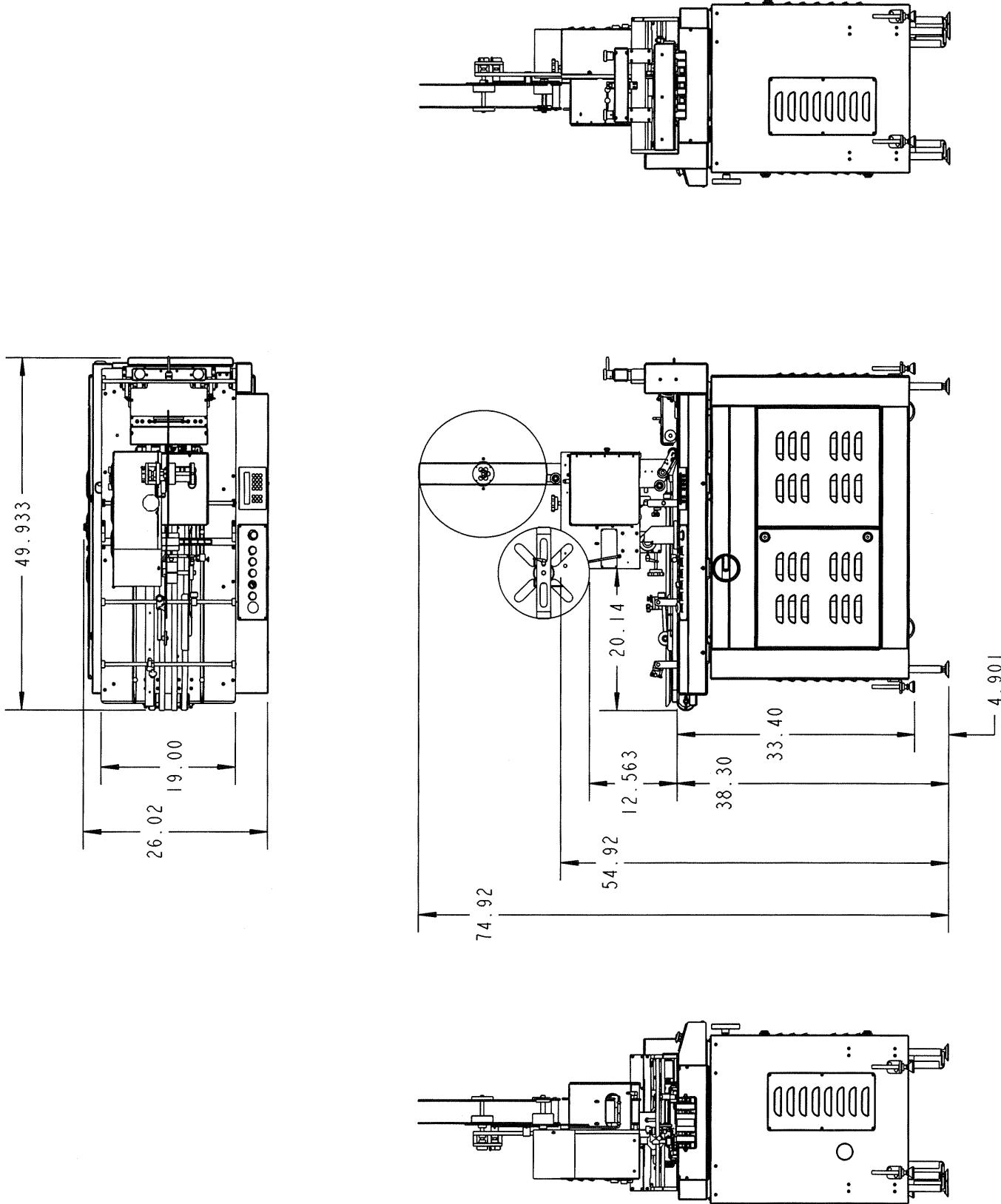
### **ELECTRICAL REQUIREMENTS**

System - Head & Base	120 VAC, 1 Phase, 50/60 Hz, 15 Amps
Head (when sold separately)	120 VAC, 1 Phase, 50/60 Hz, 10Amps
Electrical cord connection:	120V NEMA

### **OPTIONS:**

537341-01	Kit, Hydra-Lift 535
537503-01	Kit, Bump Turn 535
537877-01	Kit, Right-hand Spring Steel Mount 535
537877-02	Kit, Left-hand Spring Steel Mount 535

**Note:** Options are shown in various Figures and Parts Drawings. They do not come standard with the KR535 unless ordered.



KR535 TABMASTER  
VIEWS & DIMENSIONS  
FIGURE 1.0

## **3.0 INSTALLATION**



### **WARNING**

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

Note: Some boxes may be located inside the base cabinet.

#### **3.1 Uncrating and Unpacking**

**Position crates near installation site.**

1. Remove crate top and sides.
2. Remove metal strapping and securing blocks.
3. Locate accessories box and use checklist to verify all items were shipped.
4. Use a forklift to lift machine off skid. Be sure to position the forks in a centrally located position.
5. Machine is on casters and can be rolled inline with feeder base.
6. Adjust the height of the tabber base using the leveling legs.
7. Roll takeaway conveyor into place.

#### **3.2 Cable and Cord Connections**

1. Conveyor: Connect shingling conveyor plugs into the connectors on the outfeed bottom left panel of the tabbing base. Note: Applies to KR bases only.
2. Connect tabber plugs into the feeder base plugs. The tabber base is now connected into the stop circuitry of the feeder base. Note: Applies to KR bases only.

Note: For feeder bases other than Kirk-Rudy, connect the conveyor plug into the base as usual. Wire the tabber base into the stop circuitry of the feeder base by connecting the feeder base stop wires to the S-402-CCT socket provided.

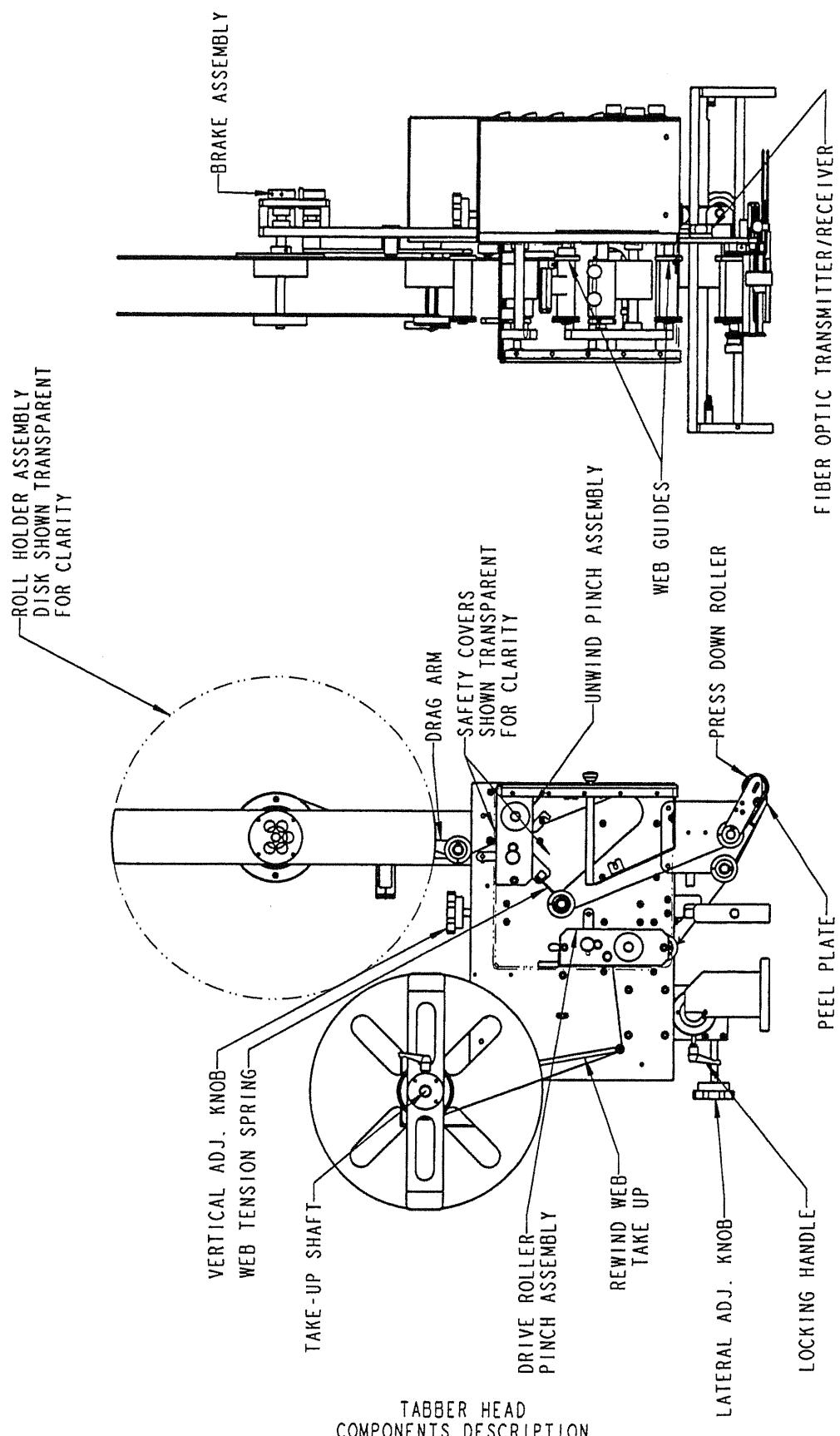
3. Power Cord: Plug the tabber base into an appropriate electrical outlet.

## **4.0 MACHINE DESCRIPTION**

### **4.1 MECHANICAL COMPONENT DESCRIPTION**

#### **4.1.1 Head Assembly (see Figure 2.0)**

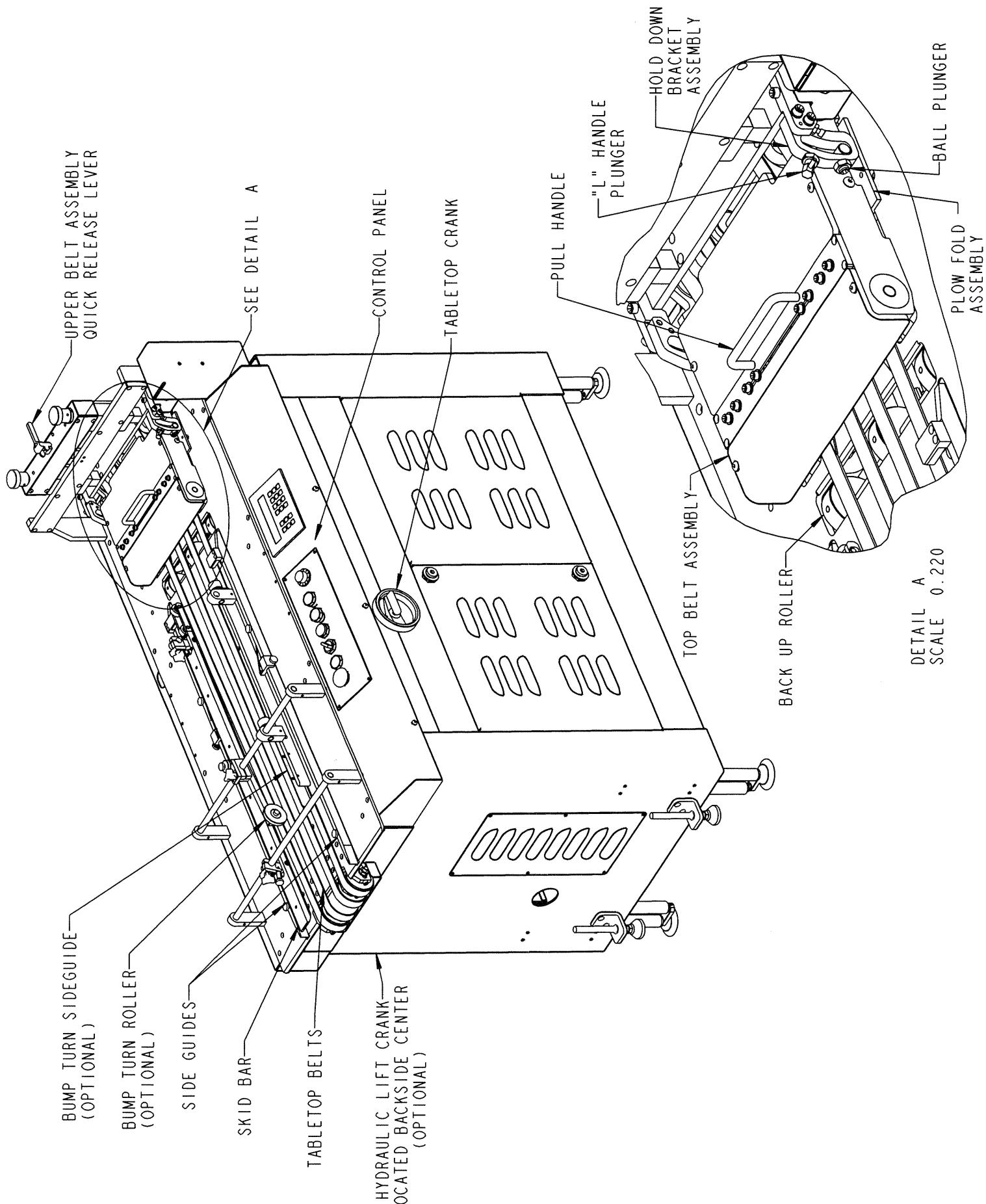
1. Roll Holder Assembly: Holds the roll of tabs or labels. Front and back guides stabilize the roll. The front guide is easily removed by rotating it until the setscrew hole in the guide hub aligns with the flat on the core hub shaft. The three screws attaching the guide plate to the hub do not have to be removed when adding new rolls of tabs.
2. Brake Assembly: Stops uncontrolled unwind of the tab roll.
3. Drag Arm: Controls the core hub break assembly. Web tension swings the arm and releases the break on the core hub shaft.



4. Unwind Pinch Assembly: This assembly unwinds the roll of labels into a loop inside the label tray. A deflector underneath the roller prevents the web from sticking to the urethane roller and wrapping around it. The unwind motor is controlled by an unwind loop sensor in the bottom of the label tray (Figure 5.0). The machine stops if the sensor is not covered within two seconds of the unwind motor starting. This function eliminates pulling the end of the roll through the head and allows splicing onto the old roll. Pull the spring-loaded knob on the face of the assembly and rotate the lever clockwise to separate the two unwind rollers.
5. Web Tension Spring: Maintains web tension over the peel plate. The spring is located near the top of the label tray and rests on a fixed guide roller.
6. Web Guides: Guide the web through the head. The guides closest to the head frame align with the edge of the roller.
7. Fiber Optic Transmitter and Receiver: This system detects the gap between tabs and controls when the drive roller stops.
8. Peel Plate: Tabs are peeled off the web when it is dragged over the peel plate.
9. Press Down Roller: Tabs are rolled onto the product by the press down roller.
10. Drive Roller Pinch Assembly: The drive roller pinch assembly pulls the web over the peel plate. Pull the spring-loaded knob on the face of the assembly and rotate the lever clockwise to separate the two rollers.
11. Take-up Shaft: The take-up shaft rewinds the backing paper after the tab is removed. Web tension around the take-up shaft is relieved when the u-shaped round bar is slid off the take-up shaft.
12. Locking Handle: Tightening this handle secures the head to the head support shaft.
13. Lateral Adjustment Knob: The head adjustment knob is used to slide the head across the base.
14. Vertical Adjustment Knob: Turning this knob pivots the tab head and changes the distance between the peel plate and the tabletop.
15. Safety Covers: Enclose nip points on the head. Never operate the machine without all safety covers in place.

#### **4.1.2 Base (see Figure 3.0)**

1. Tabletop Crank: – The crank on the front of the base is used for cross flow adjustment of the tabletop.
2. Skid Bar: Steel balls in the skid bar hold the product against the belt and prevent slippage.
3. Tabletop Belts: The two outside belts angle the product into the side guide ensuring edge registration.
4. Side Guide: The product is driven into the side guide by the tabletop belt ensuring edge registration.
5. Plow Fold Assembly: Knocks the tab down and folds it under the product.
6. Control Rollers, upper and lower: Prevent the product from slipping in the plow fold area.
7. Back up Roller: Provides backup support to the head press down roller.
8. Control Panel: The switches and operator interface located on the front of the machine.



BASE COMPONENTS DESCRIPTION  
FIGURE 3.0

DETAIL A  
SCALE 0.220

9. Top Belt Assembly: Helps prevent slippage in the plow fold area and helps squeeze the tab onto the product. Each assembly is adjusted vertically by rotating the knob on the bridge.
10. Upper Belt Assembly Quick Release: Use the quick release handle to raise the top belt assembly and clear jams or tabs from the plow fold area.
11. Hydraulic Lift Crank (optional): Quickly and easily adjusts table height plus or minus 6 inches.
12. Bump Turn Side Guide (optional): The end of the bump turn side guide forces the product to rotate 90 degrees and register against the inside wall of the guide.
13. Bump Turn Roller (optional): This spring loaded roller pinches the product onto the belts in order to drive the product around the end of the bump turn side guide.

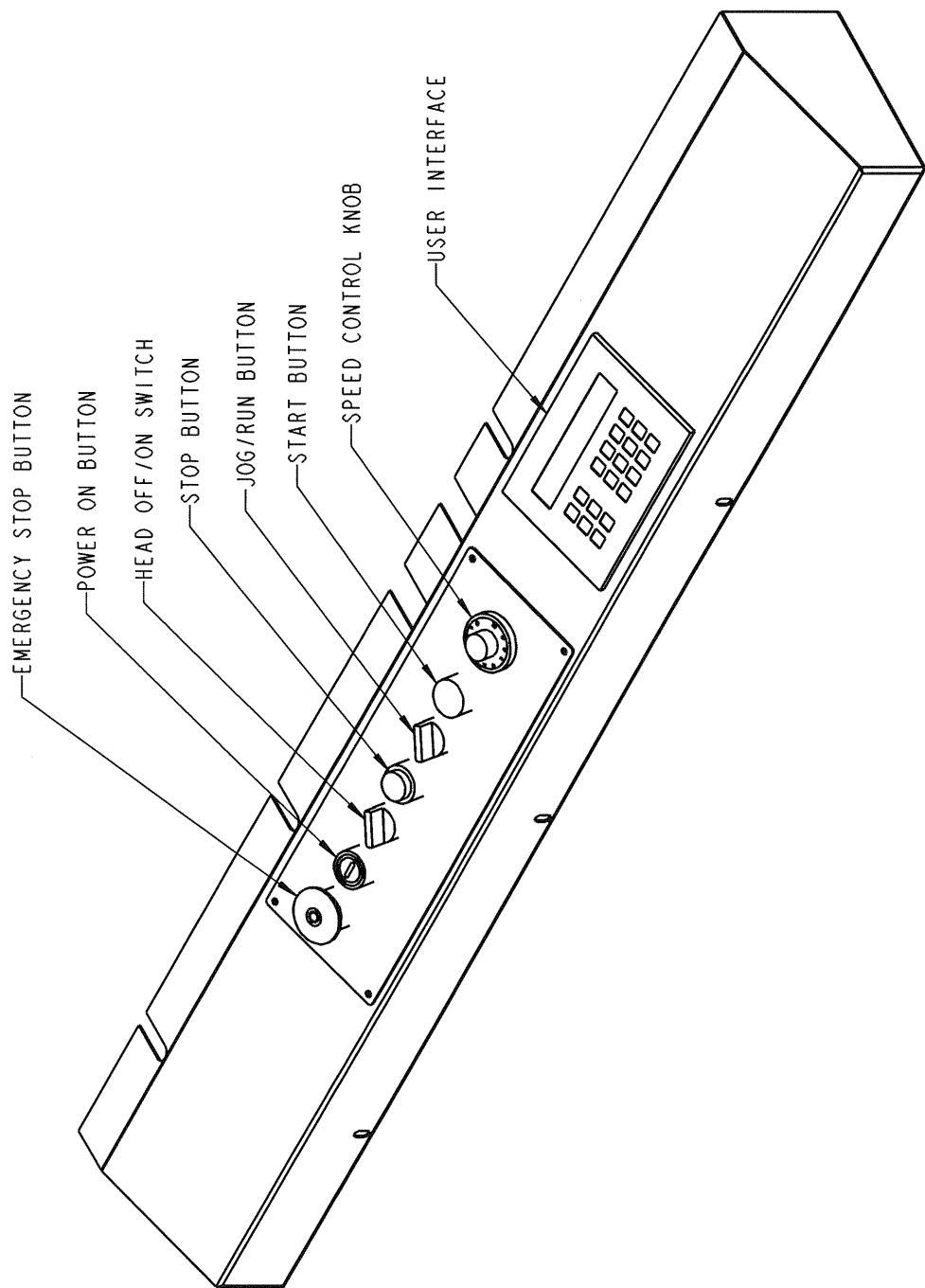
## 4.2 ELECTRICAL COMPONENT DESCRIPTION

### 4.2.1 Control Panel (Left to Right) (See Figure 4.0)

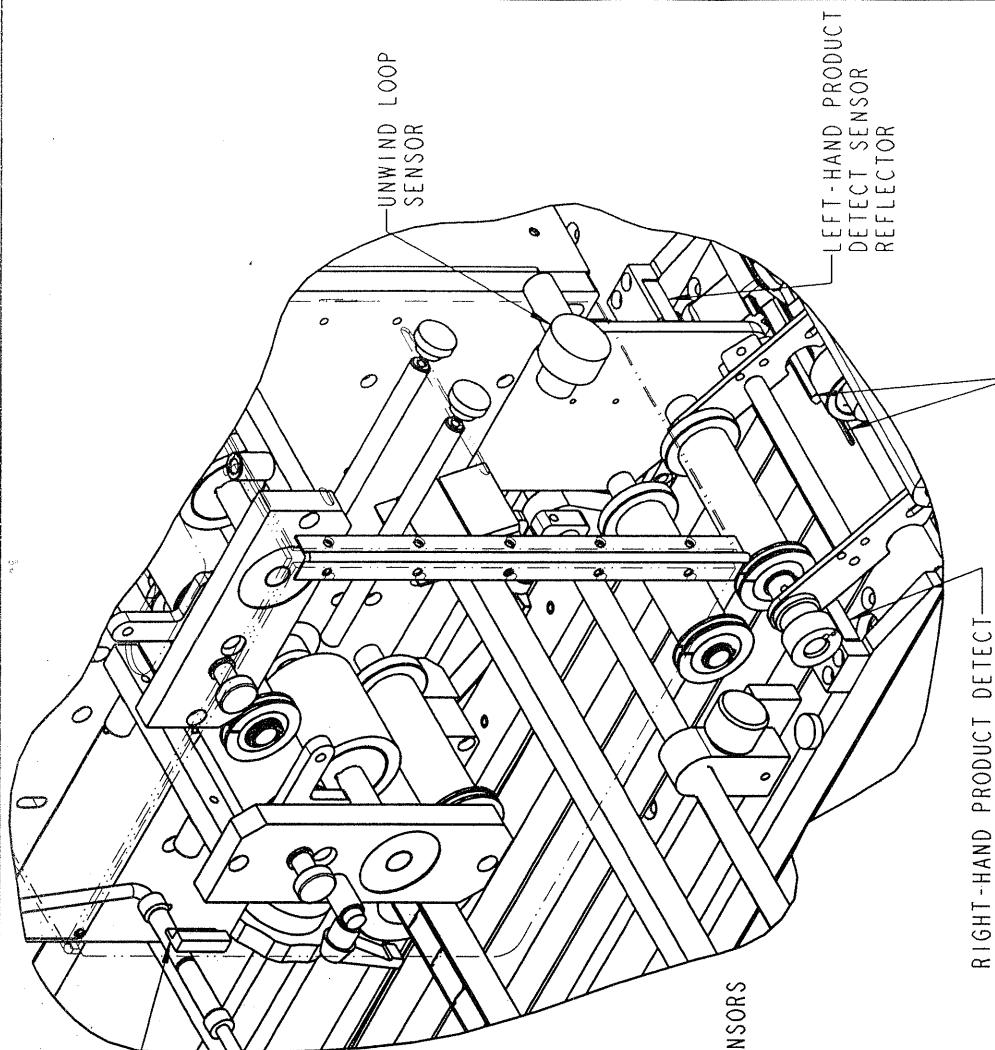
1. Emergency Stop Button: Press button to turn machine power off. To turn power on, unlatch this button. The green “power on” indicator light will turn off when power is off.
2. Power on Button: Press button to turn on machine power. Emergency stop button must be unlatched. Switch illuminates when activated.
3. Head On/Off Switch: This switch is used to disconnect electrical power to the head.
4. Stop Button: Stops the base unit’s drive motor.
5. Jog Button: When the main power is on, depressing the jog button will start the base unit drive motor. As soon as the jog button is released, the main drive motor will stop.
6. Start Button: When the main power is on, the start button will start the base unit drive motor. Always be sure personnel are clear of moving parts before starting the main drive motor.
7. Speed Control Knob: Sets the speed of the base unit’s drive motor.
8. User Interface: See section 4.3 User Interface for complete description.

### 4.2.2 Electrical Connections to Base

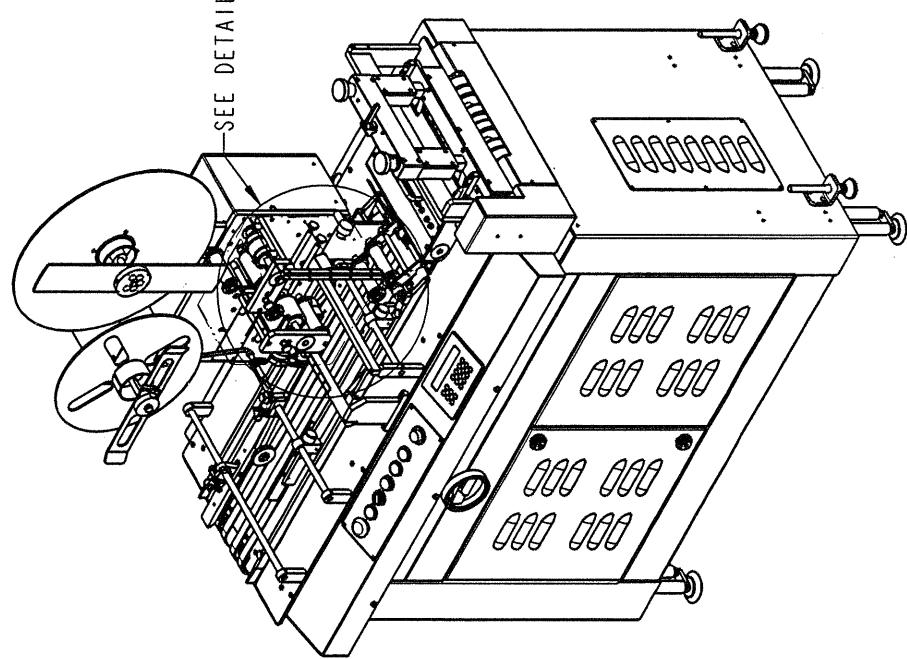
1. Main Power Cord – The main power cord, located on the panel at the rear of the base, has a built in disconnect which can be released by pushing the latch on the connector and twisting the connector off.
2. Conveyor Stop Plug – located on the panel at the rear of the base below main power, connects to the KR314 conveyor for a stop signal.
3. Conveyor Power Plug - located on the panel at the rear of the base below the main power, connects to the KR314 conveyor for power.
4. Conveyor Power Feed through Cable and Plug – located coiled up inside the base cabinet and accessible through the rear door feeds the power from the KR feeder through the KR535 to the Kr314 Conveyor. (3-Pin Cable/Plug # RSM 36D-6M)
5. Feeder Stop Cable and Plug – located coiled up inside the base cabinet and accessible through the rear door stops the feeder upstream. (2-Pin Cable/Plug # RSM 20-6M).



CONTROL PANEL  
FIGURE 4.0



DETAIL  
SENSORS  
SCALE 0.312



MACHINE SENSOR  
FIGURE 5.0

#### **4.2.3 Machine Sensors (Figure 5.0)**

1. Product Detect Beam Switch: Detects the product's leading edge. There are two product detect beam sensors on the machine - one for right hand tabbing and one for left hand tabbing. The beam switch is mounted underneath the tabletop and passes a beam up through a hole at a reflective disk mounted to the top of the side guide.
2. Tab-Label Sensor: Detects the gap between tabs or labels and is located on the peel plate. The change in the amount of light reaching the receiver as a tab passes through the beam activates a switch that stops the stepper motor. The beam can be seen as a red dot on the web between the transmitter and receiver. Fiber optic cables connect the label sensor to an amplifier unit mounted to the backside of the head. LED's on the end of the amplifier denote sensor mode. A red LED light means the sensor is in teach mode while a green LED light means run mode.
3. Unwind Loop Sensor: This sensor is attached to the bottom of the label tray and detects the presence of webbing in the tray.
4. Head Door Magnet Switch: When the head door is open, base and head operation is disabled. Must press start button to operate.

#### **4.3 USER INTERFACE (See Figure 6.0)**

**4.3.1 Overview:** The user interface provides a way to electronically change certain machine settings. This system eliminates most mechanical adjustments and makes the machine user-friendly. Machine speed, tabbing mode (single or dual), error messages and a product counter is presented on a display screen. Settings are modified using the keypad next to the screen. To change a setting, press the applicable button, type in a value and save the new value by pressing enter. Values associated with a particular job can be saved and recalled at a later time. A total of 10 different jobs can be saved. A multi-tasking controller permits changes to be made "on the fly."

#### **4.3.2 Function Keys (See Figure 6.0)**

1 or 2 Tabs: Provides a way to change the number of tabs (one or two) applied to the product. Pressing the key toggles the mode between one and two tabs.

Tab size: Enter the diameter of the tab or the label length. Note: when a new tab or product size is entered, the tab position(s) are automatically recalculated.

Load or Save: Press this button to load or save job data. Type in a 1 to load a job or type in a 2 to save the current settings for future use. To save a job, type in a number between 1-10 to identify this configuration. Use the back of the manual to record this number next to a job description. **Important note:** When the system is turned off, settings not saved to a job are discarded. If a job# had been loaded it will be reloaded when power is re-applied.

Machine Information: Press this button to scroll through the current settings.

Tab position: Provides a way to change the location of the tab on the product. Tab location is measured from the lead edge of the product to the tab edge. Single tab location defaults to the center of the product. Dual tab location defaults to .5" from each end of the product.

Tab type: Select either white or clear. When selecting white tab (opaque) the sensor operates by not being able to look through the tab and by being able to look through

the web between tab gaps. When selecting clear tab (translucent) the sensor operates by being able to look through the tab and not being able to look through the web gap due to black lines in the gap.

L/R Beam Switches: Activates the left or right product detect beam switch. When looking downstream the control panel is on the right side, the left beam switch is located on the backside of the machine. The right beam switch is located on the near side of the machine. Pressing the key toggles the mode from left to right and right to left.

Machine Setup: Use of this function key is limited to Kirk Rudy service technicians. A password is required to access speed compensation values, tab roll unwind parameters and other default settings.

Product size: Enter the size of the product. This value is used to calculate tab location on the product. Note: when a new tab or product size is entered, the tab position(s) are automatically recalculated.

Reset counter: Press this button and type “1” to reset the counter displayed on the screen.

Sensor Teach: When the tab type changes, recalibrate the tab sensor by pressing this button and running a single product through the machine. Belt speed must be less than 35 feet/minute for the sensor to correctly teach itself. The sensor amplifier unit will display a red light immediately after the label sensor button is pressed. The sensor amplifier unit is located on the rear of the peel plate support. The amplifier will display a green light when it is finished with its adjustments.

Clear: Press this button to clear the current numeric entry.

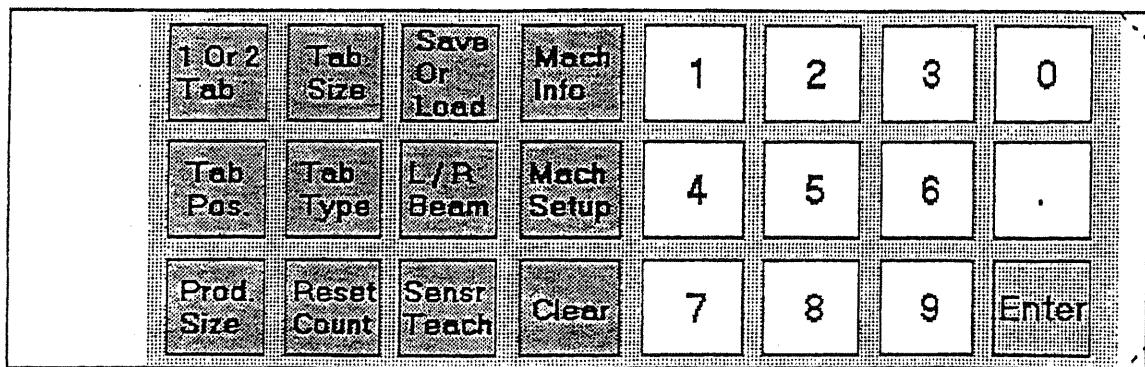


Figure 6.0 Interface Control Panel

#### **4.3.3 Error Messages**

1. Jam under product detect beam switch: A machine stop will occur if the product detect beam switch is covered for more than 1 second while the machine is running.
2. Tabber Door: A machine stop will occur when the door on the tabber head is opened while the machine is running.
3. Stop Circuit: A machine stop will occur if the stop circuit cords are unplugged.
4. Unwind beam switch: A machine stop will occur if the sensor is not covered within two seconds of the unwind motor starting.

## **5.0 OPERATING INSTRUCTIONS**



### **WARNING**

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

#### **5.1 System Overview**

The product enters the KR 535 and is pressed onto an angled belt by the skid bar rollers. The angled belt drives the product into a side guide registering the edge to be tabbed. The product detect beam switch detects the leading edge and sends a signal to the control unit. Tabs are applied to the product according to operator input parameters using the operator interface. The control unit starts the main drive roller peeling a tab off the webbing and onto the product. The main drive roller is stopped once the label sensor detects the gap between tabs. Speed sensing capabilities enable the control unit to apply tabs accurately as the base speed is changed. A plow folding system rolls the tab down and around the edge of the product as it moves through the folding section. A pinch roller then squeezes the tab securely onto the product.

#### **5.2 Base Setup**

1. Turn the main power on. Turn the head on/off switch to off for base setup.
2. Jog the feeder base until the product is delivered to the infeed of the tab base.
3. Using the tabletop crank position the appropriate side guide approximately 1/8" away from the edge that is to be tabbed. Check tabletop height.
4. Raise the head using the vertical adjustment knob enough to allow the product under the peel plate.
5. Jog the product up to the top belt assembly and adjust the gap between the top belt assembly and the lower control rollers. See 5.2.1 Upper Belt Adjustment.
6. Insure product runs through smoothly by running a few products through the unit.

**NOTE: During initial power-up only, the first product through does not receive a tab.**

##### **5.2.1 Upper Belt Adjustment**

1. Make sure quick release lever is down and in the locked position.
2. Pull the upper belt assembly up and lock into place with plunger.
3. Adjust the back rollers just above the thickness of the product to be run.

4. While moving the product back and forth between the upper and lower roller (adjust the roller to be used for applying pressure to the tab) adjust the back roller down until there is a slight drag on the product (just enough to drive the product through, not enough to mash the product). Set your adjustment knob by turning the lock collar tight against the bottom plate.



**WARNING: If excessive pressure is applied between the upper and lower back rollers the belt may not track and ride off the edge of the roller and break.**

5. After the height has been set release the plunger holding the upper belt assembly. Make sure that the hold down shaft has seated against the brackets and Delrin® ball plungers on both sides. See **Figure 3.0**.
6. Test run to make sure the tab is folded tight around the edge of the product.

### 5.2.2 Opening the Upper Belt Arms

The upper belt arms open to ease cleaning tabs from the plow fold area and to clear jams. The upper belt assembly is held down with spring loaded plungers. In case of a jam the spring plungers will give way and allow the upper belt assembly to disengage. If this happens stop the machine and clear the jam before resetting the upper belt assembly.

1. Open the quick release to raise the upper belt arms.
2. Lift the upper belt assembly by grabbing the pull handle and disengage the shaft from the Delrin® ball plungers. See **Figure 3.0**.
3. For maintenance the “L” handle plunger will lock the upper belt assembly in the up position. However, during run time the “L” handle plunger can be locked out to quickly clear jams without having to disengage the lock.
4. When the upper belt assembly is set back down into tabbing position make sure that the hold down shaft has seated against the bracket and Delrin® ball plungers on both sides.

Note: The upper belt assembly has a limit switch to stop the base from operating while the upper belt assembly is in the up position.

## 5.3 Head Setup

### 5.3.1 Roll Installation and Web Path (**Figure 7.0**)

1. Remove the front guide of the roll holder assembly and install a new roll of tabs onto the mounting hub. Install the roll so that as the free end is pulled, the roll rotates in the clockwise direction. Reinstall the front guide.
2. Disengage both pinch roller assemblies by pulling out each release pin. Unravel approximately 4 feet of webbing. The web guides closest to the frame are fixed. Adjust outer web guides as necessary. Use the vertical adjustment knob to raise the head if necessary to make threading around the peel plate easier. Thread the webbing as shown in **Figure 7.0** and re-engage both pinch roller assemblies
3. Position web guides against the web edge.
4. Check web tracking by rotating the main drive roller by hand.

- Turn power on and check the label sensor is positioned in the center of the web.

### 5.3.2 Head Position

- Jog a product through the machine and stop it as the lead edge passes the peel plate. Release the locking knob and use the lateral adjustment knob to align the center of the tab with the edge of the product. Read the scale at the bearing hub and record this measurement for future reference.
- Lower the head using the vertical adjusting knob until the bottom edge of the peel plate just clears the top of the product. Make sure the top of the product does not rub against the webbing along the bottom of the peel plate.
- Lower the press down roller onto the top of the product. Jog the product clear of the peel plate and check for clearance between the press down and lower control rollers. The press down roller should not contact the lower roller.

### 5.4 Operator Interface

**(NOTE: During initial power-up only, the first product through does not receive a tab.)**

- Turn power on and set base belt speed to ~ 35 feet/minute.
- Press **Product Size** function key and enter the product length or select a previously saved job by pressing the **Read from Job** function key.
- Press **Tab Type** function key and enter the tab label material.
- Press **Tab Size** function key and enter the tab size (inches) or the label length.
- Press **Label Sensor Teach** function key and verify red light on amplifier is illuminated.
- Run one product through the machine.
- A single tab will dispense passing the web under the label sensor. Verify the red light on the amplifier goes out and the green light illuminates. If the green light does not illuminate, repeat the procedure at a lower base belt speed.
- Press **Tab Mode** function key and select the number of tabs to apply.
- If necessary, adjust tab position using the **Tab Position** function key.
- Press **Reset Counter** function key.
- Press **Save or Load** function key and save to a Job #.

### 5.5 TROUBLE SHOOTING

Problem	Solution
Machine will not start	Unlatch stop button Close head door Check stop circuit cords are properly connected Check speed control is above zero Close the upper belt assembly
Tab head is not dispensing tabs	Check unwind and drive roller pinch levers are locked in place.

	Verify the correct product detect beam switch is active (left or right).
Tab is not rolled tight against edge	<p>Verify product is edge registered against side guide</p> <p>Verify center of tab is aligned with edge of product.</p> <p>Verify product is held firmly in the fold area.</p> <p>Verify web is properly guided and inline with roll.</p>
Tab pops open after product exits machine	<p>Lower top outfeed roller.</p> <p>Check tab shelf life</p>
Erratic tab placement	<p>Lower head until peel plate is slightly above the top of the product.</p> <p>Lower press down roller.</p> <p>Verify tab size matches the tab size parameter value in the user interface.</p> <p>Run label sensor teach program</p> <p>Clean product detect beam switch and its reflector.</p> <p>Clean loose tabs from the lower control rollers and plow fold</p> <p>Increase spring tension on press down roller</p> <p>Reduce machine speed</p>
Web breaks	<p>Inspect web for die cuts or edge nicks</p> <p>Ensure wear tape is attached to peel plate</p> <p>Remove adhesive buildup on web rollers.</p>
Web wraps around unwind roller	<p>Clean adhesive off of the unwind roller</p> <p>Center web deflector on the web and position it slightly away from the unwind roller.</p>
Second tab is placed off the end of the product	Check product size is correctly entered in the operator interface.
Upper belts do not track	Adjust upper roller to lighten the pressure between the upper and lower rollers. See <b>5.2.1 Upper Belt Adjustment</b>
Grooves in urethane unwind roller	Adjust position of web deflector

## **6.0 MAINTENANCE**



### **WARNING**

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

#### **6.1 Head**

1. Periodically clean adhesive from all web rollers
2. Check wear tape on peel plate
3. Check tab roll brake system operation and adjust if necessary.
4. Remove dust from loop sensor using a dry tissue.

#### **6.2 Base**

1. Check tabletop belts for wear and tension if necessary.
2. Clean loose tabs from the plow fold and lower control rollers.
3. Remove dust from product sensor and reflector using a dry tissue.

#### **6.3 Upper Belt Replacement Procedure**

Note: Machine is oriented looking down stream with the control panel being on the right-hand side.

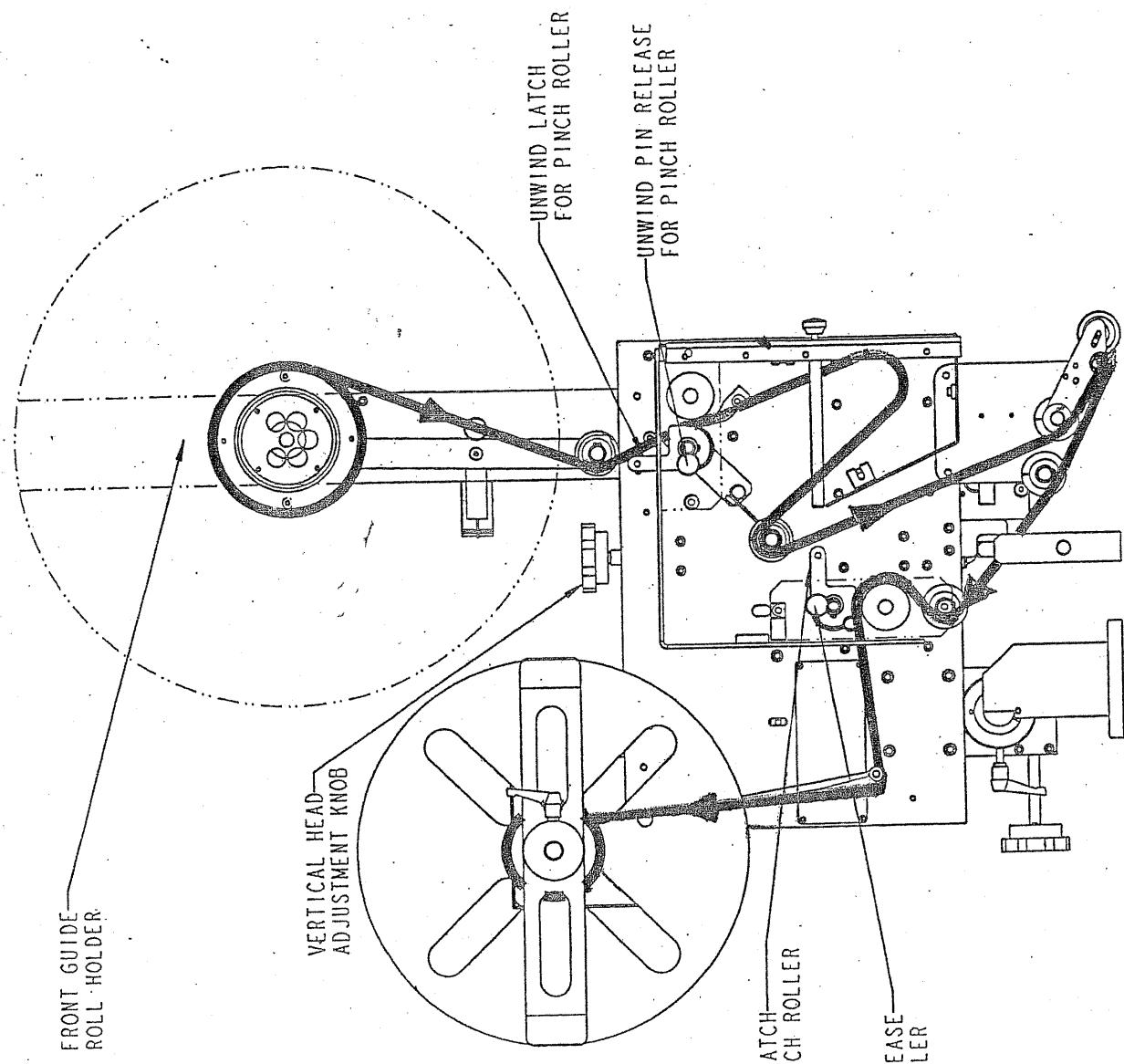
1. Unplug the machine.
2. Remove the outfeed clear belt cover by unscrewing the two 10-32 cap head screws.
3. Locate the upper belt cross support plate and unscrew the four ¼-20 cap head screws.
4. Remove the left-handed hold down bracket by unscrewing the two ¼-20 cap head screws that mount the bracket assembly to the cross support plate.
5. Slide the upper belt assembly off the universal drive taking care not to lose the key.
6. Remove the two Plexiglas® covers by removing the four 10-32 button head screws.
7. Remove the belt take-up bar by removing the four 10-32 cap head screws.
8. Slip the flat belts off the drive and idler rollers and replace with the new belt.
9. Reassemble in reverse order.

#### **6.4 Lower Belt Replacement Procedure**

Note: Machine is oriented looking down stream with the control panel being on the right-hand side.

1. Unplug the machine.
2. Adjust the tabletop to the right by rotating the crank clockwise until you reach the stop.
3. Remove the rear tabletop drive cover by unscrewing the four 10-32 flat head screws.
4. Locate and loosen the knob that secures the belt-changing tool.
5. Thread the belt-changing tool through the new belts and snap the tool on the table support slide shaft. This tool supports the table during the belt changing process.
6. Remove the five spacers that support the left-hand frame plate by unscrewing the ten ¼-20 cap head screws.

7. Unscrew the five  $\frac{1}{4}$ -20 cap head screws that fasten the support posts on the left-hand side of the tabletop.
8. Loosen the five  $\frac{1}{4}$ -20 cap head screws that fasten the support posts on the right-hand side of the tabletop.
9. Loosen the infeed idler rollers by loosening the two 9/16 hex nuts and turning the  $\frac{1}{4}$ -20 set screws counter-clockwise.
10. Remove the old belts and replace with the new belts taking care note to over tighten.
11. Reassemble in reverse order.



WEB PATH  
FIGURE 7.0

## **7.0 PARTS LISTS AND DIAGRAMS**

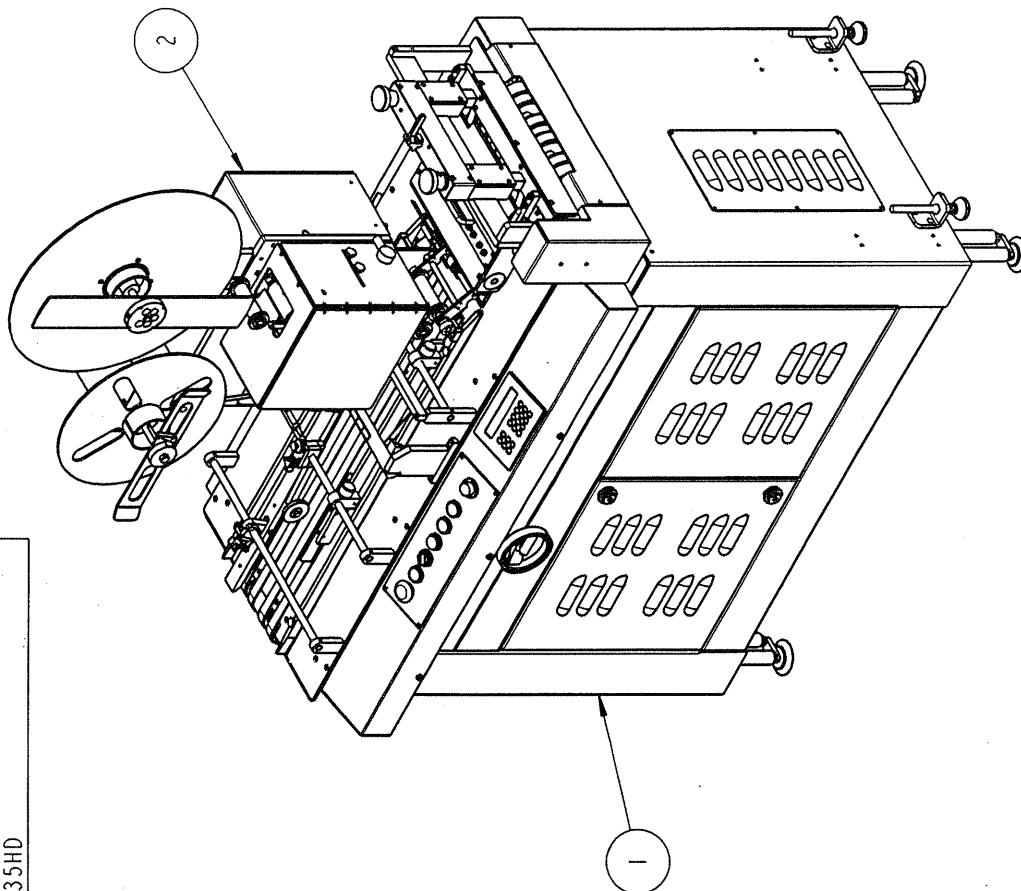
Diagrams are shown in order as indicated below. Sub-assemblies are indented under the main assembly.

### **7.1 DIAGRAMS**

DRAWING #	DESCRIPTION
KR535	KR535
537262-01	Assy, KR535 Base & Table
537263-01	Assy, Tabletop
537264-01	Slide Frame Assy
537280-01	Bushing Block Assy
537283-01	Assy, Motor Mount
537337-02	Assy, ¼ Single Red. Encoder Mnt
537284-02	Assy, Skid Bar
539816-01	Assy, Skid Bar Adjust
539817-01	Assy, Skid Bar Clamp
537293-03	Assy, Bridge
539966-01	Assy, Tabletop Belt
539967-01	Assy, Tabletop Belt
539964-01	Assy, Fork
539984-01	Assy, Upper Adjust
539950-01	Assy, Upper Belt
539965-01	Assy, Belt Take-up
539959-01	Assy, Take-up Roller
541134-01	Assy, RH Upper Belt Lock
541135-01	Assy, LH Upper Belt Lock
539973-01	Assy, Universal Upper Belt
541742-01	Kit, Floating Roller Skid Bar
537313-01	Assy, Tabletop
537503-01	Kit, Bump Turn
537517-01	Assy, Post
537516-01	Assy, Bump Turn Roller
537317-01	Assy, Infeed Takeup Belt
537320-01	Assy, Infeed Takeup Belt
537321-01	Assy, Center Infeed Belt Takeup
537324-01	Assy, Control Panel
537369-01	Assy, Tabber Cabinet
537341-01	Kit, Tabber Hydraulic Lift
537877-01	Assy, Spring Steel Mount RH
537877-02	Assy, Spring Steel Mount LH
KR535HD	KR535HD
536382-04	Assy, Frame Mount
536399-02	Assy, Pinch Roller, Drive

536320-02	Assy, Roller Drive
536400-01	Assy, Bearing Plate
537667-02	Assy, Nip Roller
537668-01	Assy, Eccentric Shaft w/Pin
536738-03	Assy, Pinch Roller, Unwind
536320-03	Assy, Drive Roller
536400-02	Assy, Bearing Plate, Unwind
536817-01	Assy, Web Drag
536746-01	Assy, Label Roll
536763-01	Assy, Unwind Wheel
537670-01	Assy, Unwind Support Bar
537671-01	Assy, Unwind Brg Plate
537674-01	Assy, Swing Arm Brake
536749-02	Assy, Rewind
536959-01	Assy, Slip Clutch
537673-01	Assy, Rewind Brg Support
536767-01	Assy, Vertical Adjustment
536769-02	Assy, Stripper Plate
536581-02	Assy, Sensor Slide
536806-01	Assy, Pinch Roller Arm
536832-01	Assy, Guide Roller
536832-03	Assy, Guide Roller
537672-01	Assy, Pinch Roller
536784-01	Assy, Electrical Connection Plate
536805-01	Assy, Motor Tab Drive
536805-02	Assy, Motor Unwind
536832-02	Assy, Guide Roller Drag
536951-01	Assy, Frame Cross Adjustment
536766-02	Assy, Cross Adjustment
536957-01	Assy, Label Tray Cover
537669-01	Assy, Frame w/ Bearings

ITEM	CITY	PART #	DESCRIPTION
1	1	537262-01	ASSY, TABBER
2	1	538869-01	ASSY, KR535HD

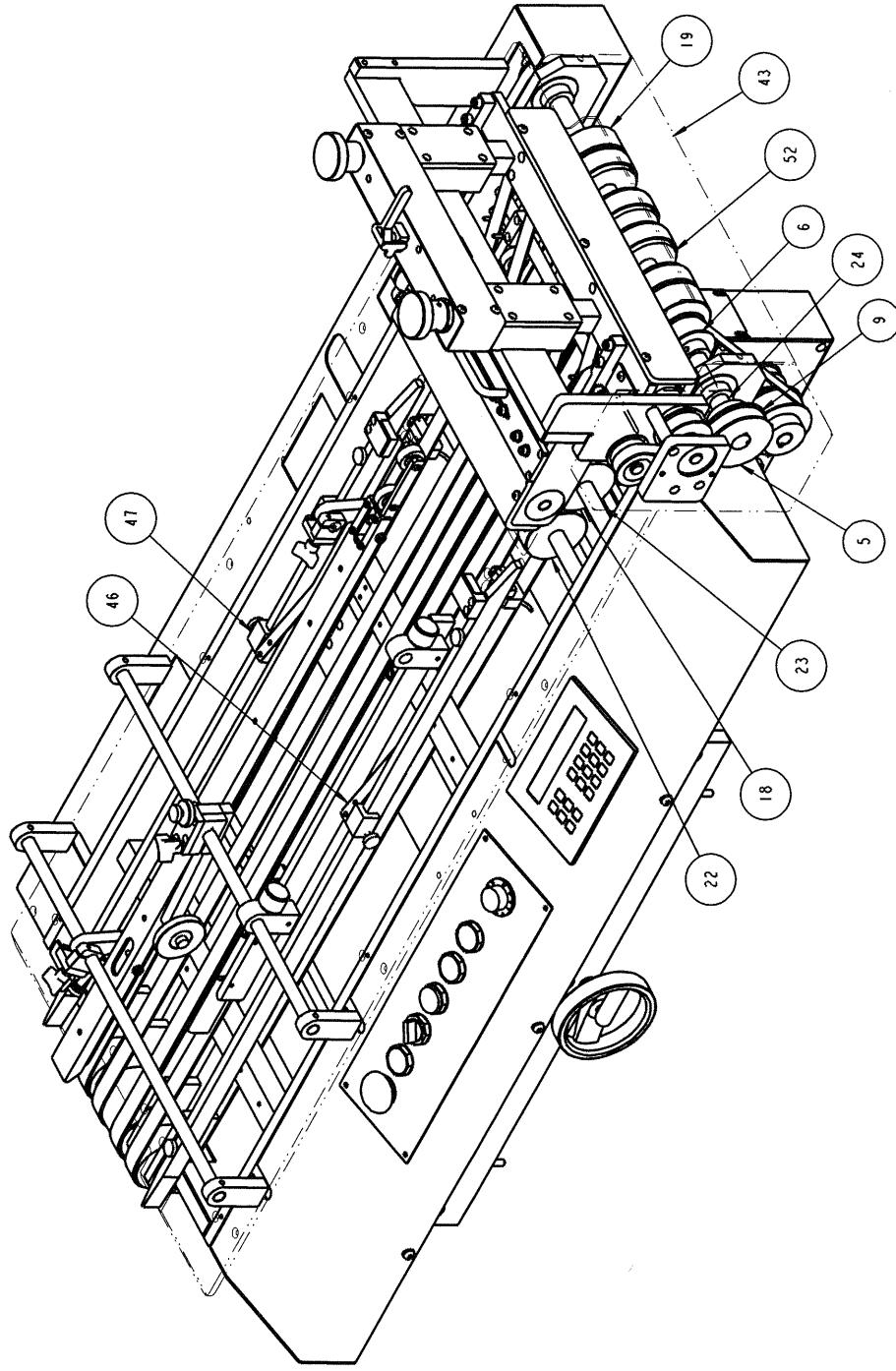


DRAWN BY: A KEY	SCALE 0 . 080	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED			MATERIAL: N / A	THIRD ANGLE PROJECTION NO PORTION OF THIS DRAWING MAY BE QUOTED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC. KENNESAW, GA 30144 USA	REQ'D REF'D WHERE USED
CHECKED BY:	DATE 04 - AUG - 00	.01	.005	.5	HEAT TREAT: N / A	MODEL: 535	1
TRACED BY: <i>m</i>	MASTER	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY			FINISH: N / A	SHEET NO. OF 5	DRAWING # KR535

ITEM QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	1	537263-01 ASSY, TABLETOP					
2	1	537369-01 ASSY, TABBER CABINET					

DRAWN BY: A KEY	SCALE 0 . 080	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
CHECKED BY:	DATE 04-Aug-00	.xx	.xxx	ANG. .01 -.005 .5	HEAT TREAT: N/A	REMOVED ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED	KIRK - RUDY - INC. KENNESAW, GEORGIA
TRACED BY:	MASTER			FINISH: N/A	SHEET NO. 20F3	TITLE: ASSY, TABBER	
						DRAWING # 537262-01	



ITEM#	PART #	DESCRIPTION
1	3	WASHER, FLAT 1/4ID BRASS
2	1	BELT, FLAT 99.25 X .75
3	1	BOLT, SHOULDER 3/8X1/2
4	1	PULLEY, TIMING 20L015 .625B .188K
5	1	PULLEY, TIMING 20L050 .750B .188K
6	1	PULLEY, TIMING 14L015 .750B .188K
7	1	PULLEY, TIMING 14L050 .750B .188K
8	1	TIMING BELT .225L050
9	1	109023 TIMING BELT .D150L050
10	1	209021 CLAMP, WIRE
11	3	521615 BAR, SPACER
12	2	106500-1 BELT, FLAT 99.25 X .75
13	1	106500-2 BELT, FLAT 99.25 X .75
14	2	108722-2 PULLEY, 2X10L037 .625B MK
15	1	108826-1 PULLEY, TIMING 14L050 .625B MK
16	1	108927-4 TIMING BELT .210L075
17	1	109018-3 TIMING BELT .100XL037
18	2	503565-2 ROLLER, BOTTOM FEED
19	2	527614-2 ROLLER, PRESS
20	1	527622-2LA FRAME ASY
21	1	527622-2RA FRAME ASY
22	3	527633-2 ROLLER, TAB PRESS DOWN
23	2	527637-2 SHAFT, PRESS DOWN ROLLER
24	1	528231-1 SHAFT, ROLLER DRIVE
25	1	531852-01 KNOB, ASY
26	1	532421-02 COVER, SIDE
27	1	537101-01 GUIDE, ANGLED BELT
28	1	537101-02 GUIDE, ANGLED BELT
29	1	537254-01 ASSY, FRAME SIDE
30	1	537283-01 ASSY, MOTOR MOUNT
31	1	537284-02 ASSY, SKID BAR
32	1	537293-03 ASSY, BRIDGE
33	1	537313-01 ASSY, TABLETOP
34	1	537317-01 ASSY, INFEED TAKEUP BELT
35	1	537320-01 ASSY, INFEED TAKEUP BELT
36	1	537321-01 ASSY, CENTER INFEED BELT TAKEUP
37	1	537324-01 ASSY, CONTROL PANEL
38	1	537328-01 WLDNNT, INFEED COVER
39	1	537334-01 SPACER, BELT CHANGE SUPPORT
40	1	537335-01 PLATE, BELT CHANGE SUPPORT
41	1	537336-01 SPACER, BELT CHANGE KNOB
42	1	537351-01 WLDNNT, UPPER DRIVE COVER
43	1	537353-01 COVER, OUTFEED LOWER BELT
44	1	537555-03 GUIDE, BOTTOM TAB
45	1	537595-05 GUIDE, BOTTOM TAB
46	1	537877-01 KIT, SPRING STEEL MOUNT RH
47	1	537877-02 KIT, SPRING STEEL MOUNT LH
48	3	537913-01 STUD, CONTROL PANEL MOUNT
49	1	539683-01 PLATE, TABLETOP GUSSET
50	6	539684-01 SPACER, TABLETOP
51	3	CSEFF65 SCREW, BUTTON HEAD 1/4X.500
52	4	SPI18325-4 ROLLER, DRIVE (CROWNED)

ITEM QTY	PART #	DESCRIPTION	REV NO	DATE	ECN NO	BT
1	3	100604 WASHER, FLAT 1/4ID BRASS				
2	1	106500 BELT, FLAT .99-.25 X .75				
3	1	107206 BOLT, SHOULDER 3/8X11/2				
4	1	108828 PULLEY, TIMING 201.075 .625B .188K				
5	1	108833 PULLEY, TIMING 201.050 .750B .188K				
6	1	108871 PULLEY, TIMING 141.075 .750B .188K				
7	1	108872 PULLEY, TIMING 141.050 .750B .188K				
8	1	108928 TIMING BELT, 225L050				
9	1	109033 TIMING BELT, D150L050				
10	1	209021 CLAMP, WIRE				
11	3	527615 BAR, SPACER				
12	2	106500-1 BELT, FLAT .99-.25 X .75				
13	1	106500-2 BELT, FLAT .99-.25 X .75				
14	2	108722-2 PULLEY, 24XL037 .625B NK				
15	1	108861-1 PULLEY, TIMING 141.050 .825B NK				
16	1	108927-4 TIMING BELT, 210L075				
17	1	109018-3 TIMING BELT, 100X1037				
18	2	503636-2 ROLLER, BOTTOM FEED				
19	2	527614-2 ROLLER, PRESS				
20	1	527612-2RA FRAME ASY				
21	1	527612-2RA FRAME ASY				
22	3	527633-2 ROLLER, TAB PRESS DOWN				
23	2	527637-2 SHAFT, PRESS DOWN ROLLER				
24	1	528231-1 SHAFT, ROLLER DRIVE				
25	1	531832-01 KNOB, ASY				
26	1	532421-02 COVER, SIDE				
27	1	537101-01 GUIDE, ANGLED BELT				
28	1	537101-02 GUIDE, ANGLED BELT				
29	1	537264-01 ASSY, FRAME SIDE				
30	1	537263-01 ASSY, MOTOR MOUNT				
31	1	537264-02 ASSY, SKID BAR				
32	1	537263-03 ASSY, BRIDGE				
33	1	537313-01 ASSY, TABLETOP				
34	1	537317-01 ASSY, INFED TAKEUP BELT				
35	1	537320-01 ASSY, INFED TAKEUP BELT				
36	1	537321-01 ASSY, CENTER INFED BELT TAKEUP				
37	1	537324-01 ASSY, CONTROL PANEL				
38	1	537328-01 WLDNNT, INFED COVER				
39	1	537334-01 SPACER, BELT CHANGE SUPPORT				
40	1	537335-01 PLATE, BELT CHANGE SUPPORT				
41	1	537336-01 SPACER, BELT CHANGE KNOB				
42	1	537351-01 WLDNNT, UPPER DRIVE COVER				
43	1	537353-01 COVER, OUTFEED LOWER BELT				
44	1	537555-03 GUIDE, BOTTOM TAB				
45	1	537555-05 GUIDE, BOTTOM TAB				
46	1	537817-01 KIT, SPRING STEEL MOUNT RH				
47	1	537817-02 KIT, SPRING STEEL MOUNT LH				
48	3	537913-01 STUD, CONTROL PANEL MOUNT				
49	1	539683-01 PLATE, TABLETOP GUSSET				
50	6	539684-01 SPACER, TABLETOP				
51	3	CSF165 SCREW, BUTTON HEAD 1/4X .500				
52	4	SP18325-4 ROLLER, DRIVE (CROWNED)				
DRAWING BY: A KEY DATE: 0.230 SCALE: 1:1 CHECKED BY: 09 - Mar - 01 MEET TOLERANCE: N/A TRACED BY: MASTER DATE: N/A REV'D WHERE USED: 1 SP16300 <b>KRK - RUDY, INC.</b> <b>192 KENNESAW, GEORGIA</b> <b>AIRPORT DR. KENNESAW, GA 30042 USA</b> <b>TEL: 404-922-0000 FAX: 404-922-0001</b>						

DRAWING # 537263-01

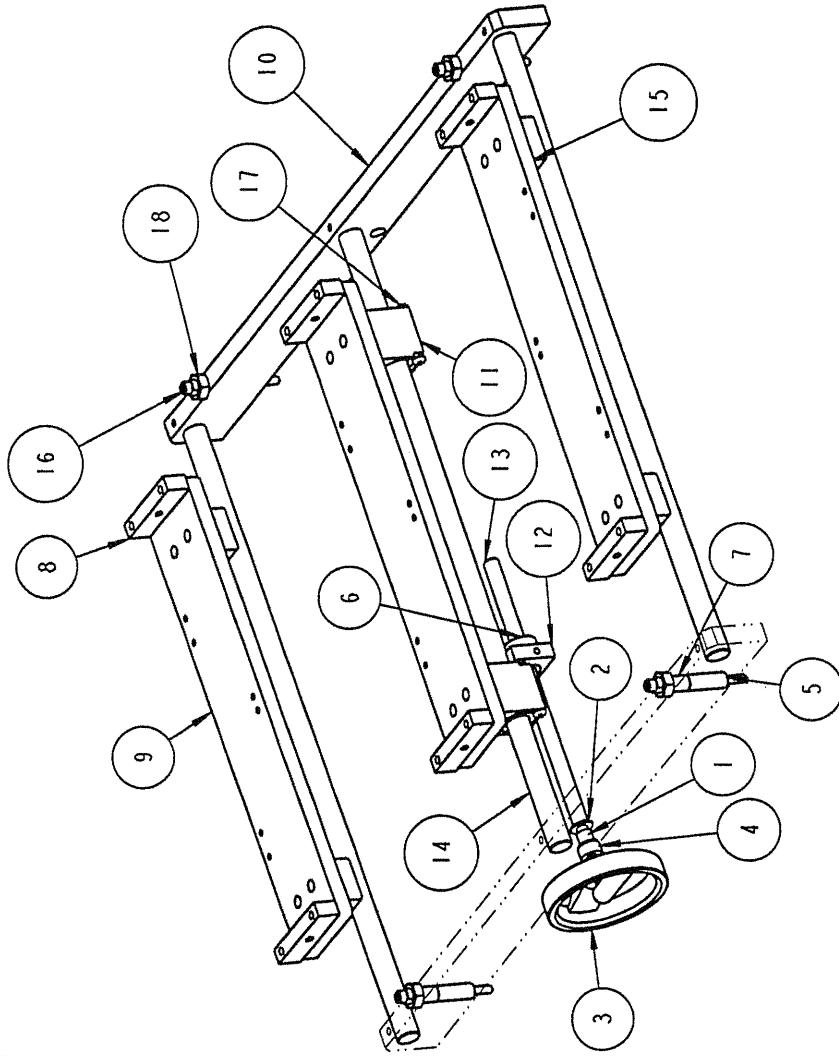
SCALE 0.230

ITEM QTY	PART #	DESCRIPTION	REV NO.	DATE	ECN NO.	BT
1	3	100604 WASHER, FLAT 1/4ID BRASS				
2	1	105500 BELT, FLAT 99.25 X .75				
3	1	101206 BOLT, SHOULDER 3/8X1 1/2				
4	1	108828 PULLEY, TIMING 20L0175 .6258 .188K				
5	1	108833 PULLEY, TIMING 14L0175 .7508 .188K				
6	1	108871 PULLEY, TIMING 14L0175 .7508 .188K				
7	1	108872 PULLEY, TIMING 14L0175 .7508 .188K				
8	1	108928 TIMING BELT, 225L050				
9	1	109023 TIMING BELT, D150L050				
10	1	203021 CLAMP, WIRE				
11	3	522675 BAR, SPACER				
12	2	106500-1 BELT, FLAT 99.25 X .75				
13	1	106500-2 BELT, FLAT 99.25 X .75				
14	2	108122-2 PULLEY 24KL037 .6258 NK				
15	1	108826-1 PULLEY, TIMING 14L050 .6258 NK				
16	1	108927-4 TIMING BELT, 210L075				
17	1	109018-3 TIMING BELT, 100L037				
18	2	503656-2 ROLLER, BOTTOM FEED				
19	2	521614-2 ROLLER, PRESS				
20	1	521622-2LA FRAME ASY				
21	1	527622-2BA FRAME ASY				
22	3	521633-2 ROLLER, TAB PRESS DOWN				
23	2	521637-2 SHAFT, PRESS DOWN ROLLER				
24	1	528823-1 SHAFT, ROLLER DRIVE				
25	1	531852-01 KNOB ASY				
26	1	532421-02 COVER, SIDE				
27	1	537101-01 GUIDE, ANGLED BELT				
28	1	537101-02 GUIDE, ANGLED BELT				
29	1	531264-01 ASSY, FRAME SIDE				
30	1	531283-01 ASSY, MOTOR MOUNT				
31	1	531284-02 ASSY, SKID BAR				
32	1	531293-03 ASSY, BRIDGE				
33	1	531313-01 ASSY, TABLETOP				
34	1	531317-01 ASSY, INFED TAKEUP BELT				
35	1	531320-01 ASSY, INFED TAKEUP BELT				
36	1	531321-01 ASSY, CENTER INFED BELT TAKEUP				
37	1	531324-01 ASSY, CONTROL PANEL				
38	1	531328-01 WLDNNT, INFED COVER				
39	1	531334-01 SPACER, BELT CHANGE SUPPORT				
40	1	531335-01 PLATE, BELT CHANGE SUPPORT				
41	1	531336-01 SPACER, BELT CHANGE KNOB				
42	1	531351-01 WLDNNT, UPPER DRIVE COVER				
43	1	531353-01 COVER, OUTFEED LOWER BELT				
44	1	531595-03 GUIDE, BOTTOM TAB				
45	1	531595-05 GUIDE, BOTTOM TAB				
46	1	531877-01 KIT, SPRING STEEL MOUNT RH				
47	1	531877-02 KIT, SPRING STEEL MOUNT LH				
48	3	531973-01 STUD, CONTROL PANEL MOUNT				
49	1	533683-01 PLATE, TABLETOP GUSSET				
50	6	533684-01 SPACER, TABLETOP				
51	3	CSF65 SCREW, BUTTON HEAD 1/4X.500				
52	4	SP18325-4 ROLLER, DRIVE (CROWNED)				

1	SP16300	WAVEONE 1
RECD 0	WAVEONE 1	
KIRK - RUDY INC.		
KENNESAW, GEORGIA		
PRINTED IN U.S.A.		
37	37	ASSY, TABLETOP
35	35	ASSY, TABLETOP



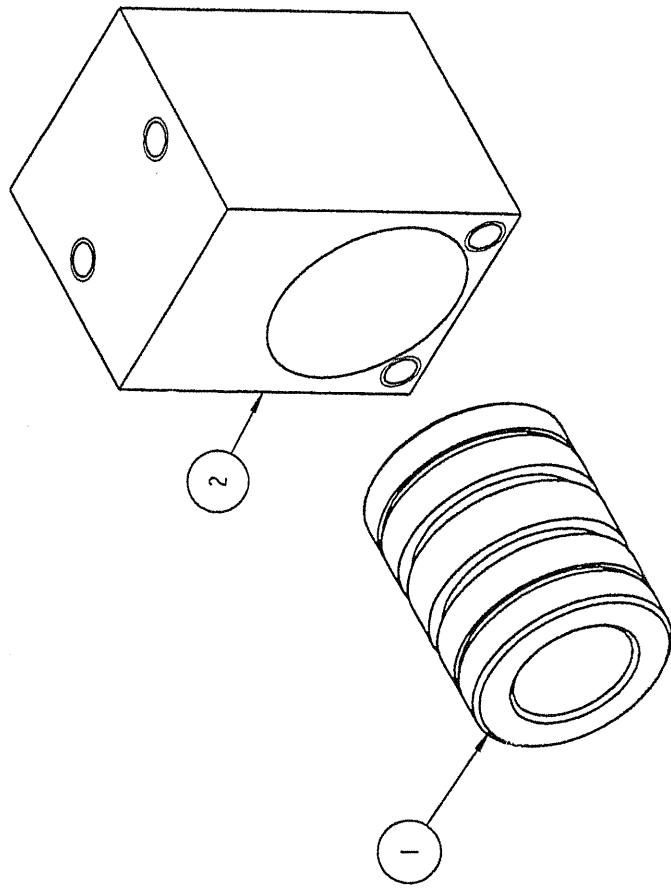
ITEM QTY	PART #	DESCRIPTION
1	100302	BUSHING, FL. 3751D.5000D.5001G
2	100402	WASHER, THRUST TB612
3	102139	HANDWHEEL, FOLD AWAY
4	102200	COLLAR .375
5	102670	SPACER
6	109836	ACME NUT, 1/2 - 2
7	510660	SCREW-ADJUSTING
8	6527639	SPACER, FRAME
9	3527620-2	BRACKET, TABBER MOUNT
10	2537277-01	PLATE, SLIDE SHAFT MOUNT
11	2537280-01	BUSHING BLOCK ASY
12	1537281-01	PLATE, NUT MOUNT
13	1537282-01	ROD, ACME THREADED SLIDE ADJ
14	3537309-01	SHAFT, SLIDE
15	4537311-01	BLOCK, SLIDE
16	4CSD305	
17	3CSFF63	BUTTON HEAD SCREW
18	4HJN014	



I	SP76300
REQ'D	WHERE USED

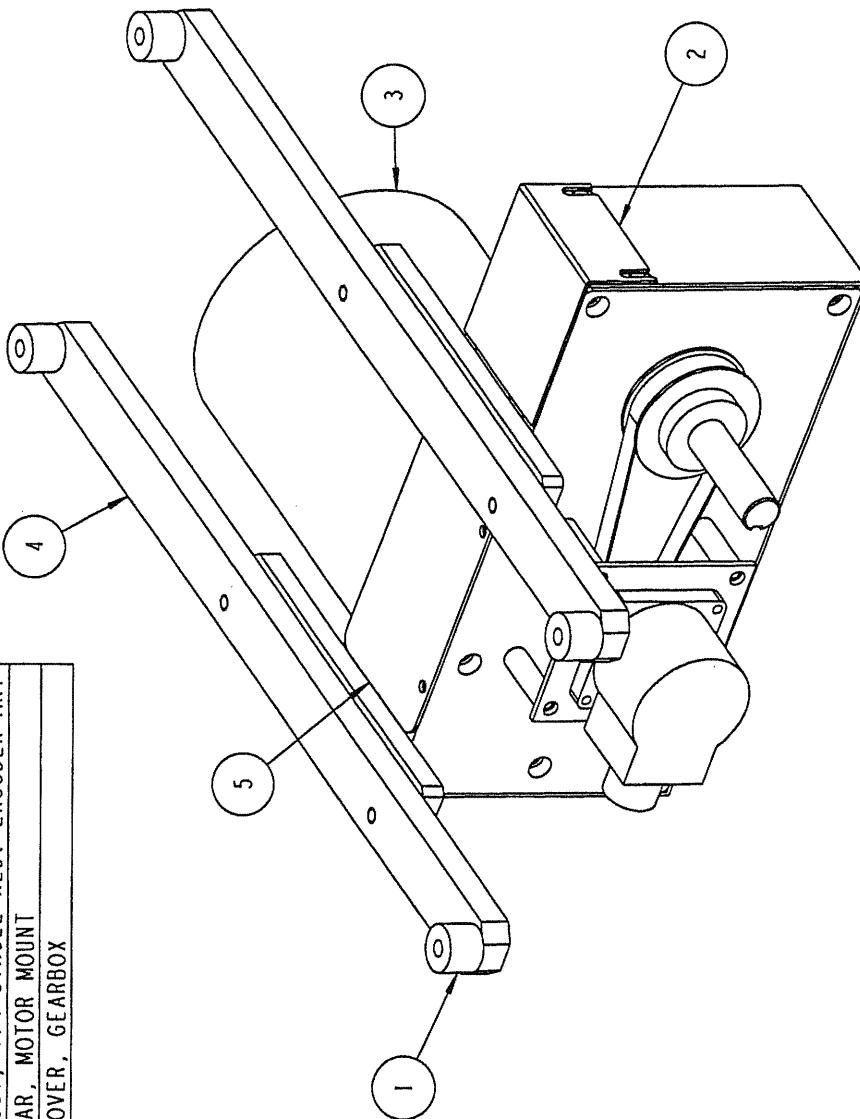
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CHECKED BY:	DATE 01 - Aug - 00	ANG. .01 .005 .005	HEAT TREAT: N / A	MODE: 535 Title: ASSY, FRAME SIDE
TRACED BY:	MASTER	FINISH: N / A	SHEET NO.: 1 OF 1	DRAWING # 537264-01

ITEM QTY	PART #	DESCRIPTION
1	1	102905 LINEAR BUSHING, THOMSON
2	1	537279-01 BLOCK, SLIDE



DRAWN BY: A KEY	SCALE 1 . 000	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED .01 .005 .5	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
CHECKED BY:  08 - 0C + - 99	DATE 08-0C+ - 99	HEAT TREAT: N / A	MODEL: KR535	INTL:	KIRK - RUDY, INC. KENNESAW, GEORGIA
TRACED BY:  MASTER	MASTER	FINISHES: N / A	SHEET NO. 1 OF 1	DRAWING # 537280-01	BUSHING BLOCK ASY 537280-01

ITEM	QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	B/R
1	4	102381	SPACER, GUIDE BOTTOM					
2	1	528257-1	COVER, TABBER DRIVE MOTOR					
3	1	537337-02	ASSY, 1/4 SINGLE RED. ENCODER MNT					
4	2	537882-01	BAR, MOTOR MOUNT					
5	1	539686-01	COVER, GEARBOX					



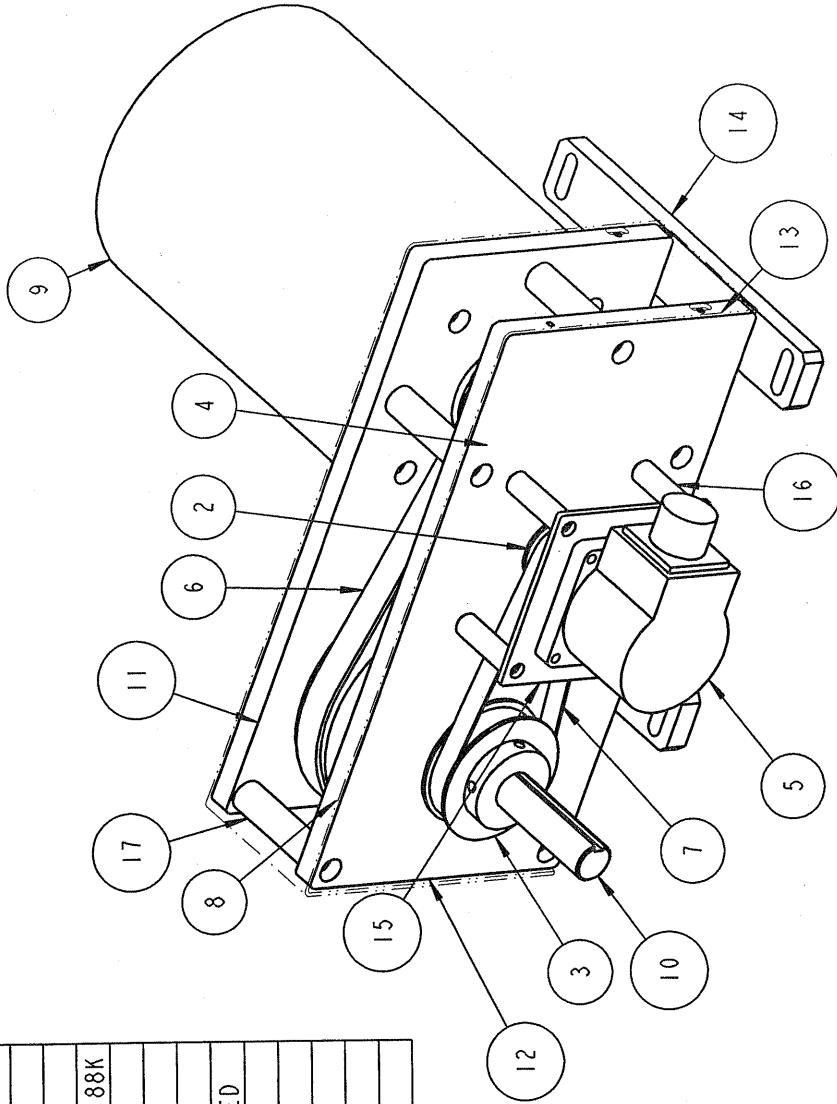
DRAWN BY:	SCALE	0 . 375	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	MATERIAL: N / A	THIRD ANGLE PROJECTION	PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE QUOTED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC. KENNESAW, GA 30144, USA
CHECKED BY:	DATE	.xx	.xx	ANG. .01 .005 .5	HEAT TREAT:	
TRACED BY:	MASTER	22 - Sep - 00	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED	N / A	MODEL:	535
			ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE WORK TO DIMENSIONS ONLY	N / A	STREET NO:	10F 1
					DRAWING #:	537283-01

I	SP76300
RED'D	WHERE USED

KIRK - RUDY, INC.  
KENNESAW, GEORGIA

ASSY, MOTOR MOUNT  
TITLE:  
DRAWING #

ITEM	QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	2	103804	BEARING, HUB .625					
2	1	108700	PULLEY, 15XL037 .375B NK					
3	1	108708	PULLEY, 30XL037 .625B NK					
4	1	108821	PULLEY, TIMING 12L050 .500B NK					
5	*	202458	ENCODER, DYNAPAR					
6	1	108912-1	BELT, TIMING 187L050					
7	1	109007-2	TIMING BELT, 120XL037					
8	1	109319-1	PULLEY, TIMING 32L050 .625B .188K					
9	1	200165-4	MOTOR, LEESON DC					
10	1	500748-4	SHAFT - FEEDER ROLLER					
11	1	509006-1	PLATE, REAR SIDE					
12	1	509007-1	PLATE-GEARBOX 1/2 HP SINGLE RED					
13	1	509037-4	COVER, REDUCER					
14	2	530138-02	BAR, MOUNTING					
15	1	537338-01	BRACKET, DYNAPAR ENCODER MNT					
16	4	537339-01	SPACER, ENCODER MOUNT					
17	5	SPI6208-1	SPACER, REDUCER					



## \*ENCODERS:

KR535 KR#202388-2  
KR535CS KR#202492  
KR435 KR#202492  
KR550MX 202388-2  
KR550CS 202492

DRAWN BY: A KEY	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 WHOLE OR IN PART EXPRESSLY WRITTEN PERMISSION OF KIRK RUDY, INC. WOODSTOCK, GEORGIA
CHECKED BY:	DATE 08-0C†-99	.XX	.XXX	HEAT TREAT: NONE		
TRACED BY:	MASTER 	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY		FINISH: N / A	SHEET NO. 10F1	DRAWING # 5373337-02

ITEM QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	2	100603 WASHER, FLAT 1/4x10					
2	4	100608 WASHER, FLAT 1/4x10 3/32TK BRASS					
3	4	104107 SNARING, .250					
4	1	105210 PIN, ROLL .125X.150					
5	12	190864 BALL, 1/2 DIA STEEL					
6	12	190869 DISC, 1/2 DIA FELT					
7	1	500801-11A ASSY, LINK					
8	2	501051-A ASSY, ROLLER					
9	1	529107-7 BAR, SILENT SKID					
10	1	529148-7 RETAINER PLATE-SKID PLATE					
11	1	531506-01 ASSY, SKIDBAR POST					
12	2	531852-01 PLATE, SKID BAR ROLLER SUPPORT					
13	2	531853-01 SHAFT, SKID BAR ROLLER					
14	1	539816-01 ASSY, SKID BAR ADJUST					
15	1	539817-01 ASSY, SKID BAR CLAMP					
16	4	CSD0299					
17	2	CSD0271					
18	6	CSD0232					
19	2	HNSN10 HEX NUT					

1	SPRING
RECD	WHEN USED
<b>KRK - RUDY, INC.</b>	
<b>KR KENNESEW, GEORGIA</b>	
PROPRIETARY AND CONFIDENTIAL NO COPIES OF THIS DRAWING MAY BE MADE EXCEPT AS AUTHORIZED IN WRITING FROM THE ENGINEER HAVING PERMISSION TO RELEASE DRAWINGS. KRK - RUDY, INC. KENNESAW, GA, USA	
NAME:	5335
SKETCH:	TOP 3
DATE:	7-Jan-00
CHECKED BY:	MASTER
TRACED BY:	MASTER
ALL DIMENSIONS ARE FAIRING DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY	
DRAWING # 537284-02	

ITEM QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	100619	WASHER, FLAT 10-32					
2	102117	KNOB					
3	102132	KNOB, 10-32 CAP SCREW					
4	102714	SPRING					
5	105613	SHAFT, 10-32 X 2.00 LNG					
6	537879-01	BLOCK, SKID BAR ADJUST CLAMP					
7	537884-01	CAP, SKID BAR ADUST					
8	537886-01	ASSY, TRIKNOB 10-32 X 2.000 LNG					
9	539816-01	ASSY, SKID BAR ADJUST					
10	CSD0264						
11	CSD0270						
12	HMSN10	HEX NUT					

DRAWN BY: A KEY      SCALE: 2 . 000      DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED

.01	.005	.5
xx	xx	ANG.

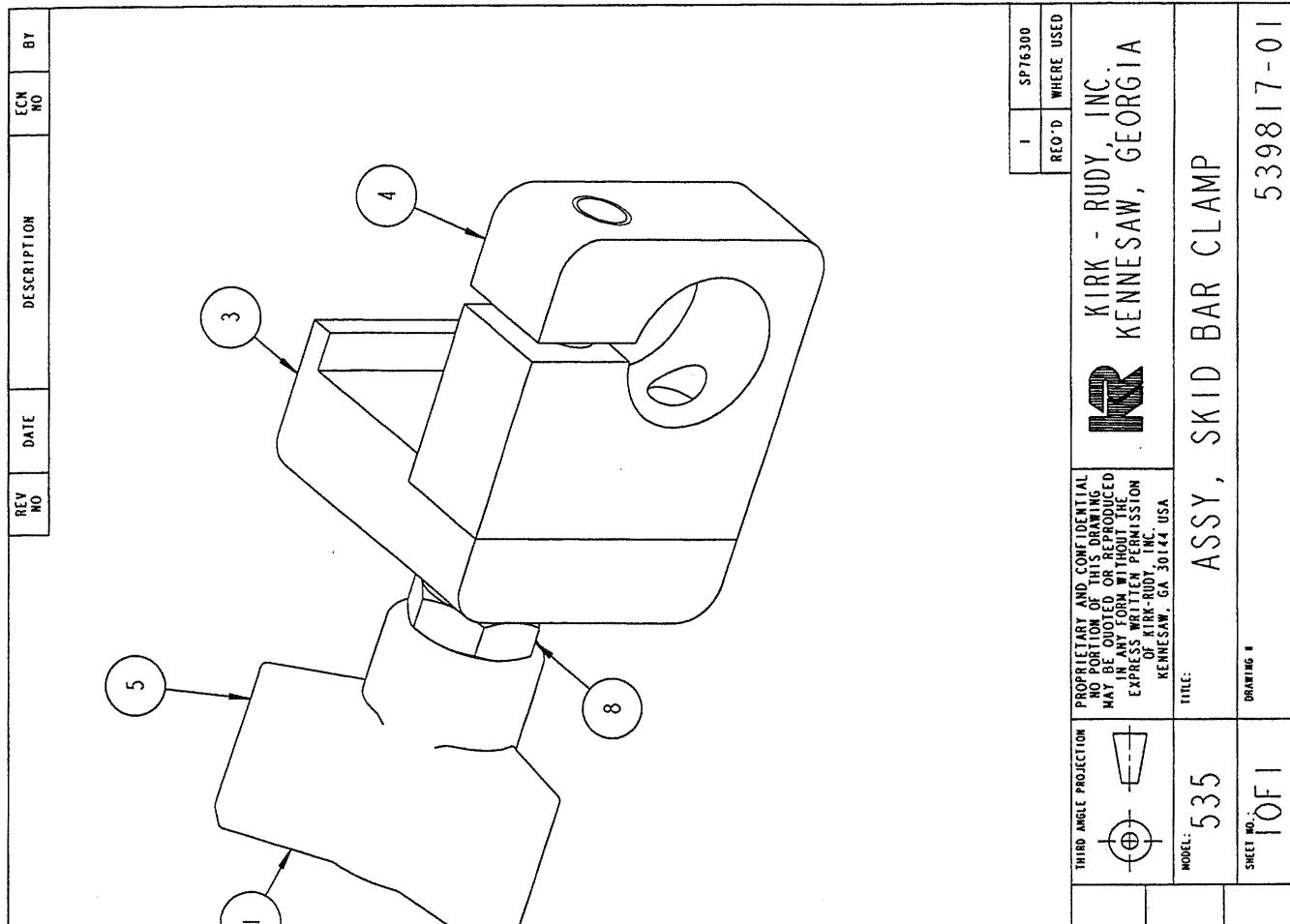
DATE: 05 - DEC - 00      MATERIAL: N / A      HEAT TREAT: N / A

CHECKED BY:      DRAWING: 5335      PROPRIETARY AND CONFIDENTIAL  
NO PORTION OF THIS DRAWING  
MAY BE DUPLICATED OR REPRODUCED  
IN WHOLE OR IN PART, WITHOUT THE  
EXPRESS WRITTEN PERMISSION  
OF KIRK-RUDY, INC.,  
KENNESAW, GA 30144 USA

TRACED BY: MASTER      FINISH: N / A      SHEET NO: 10F 1      TITLE: ASSY, SKID BAR ADJUST

RECD'D: SP76300      WHERE USED: 1 SP76300

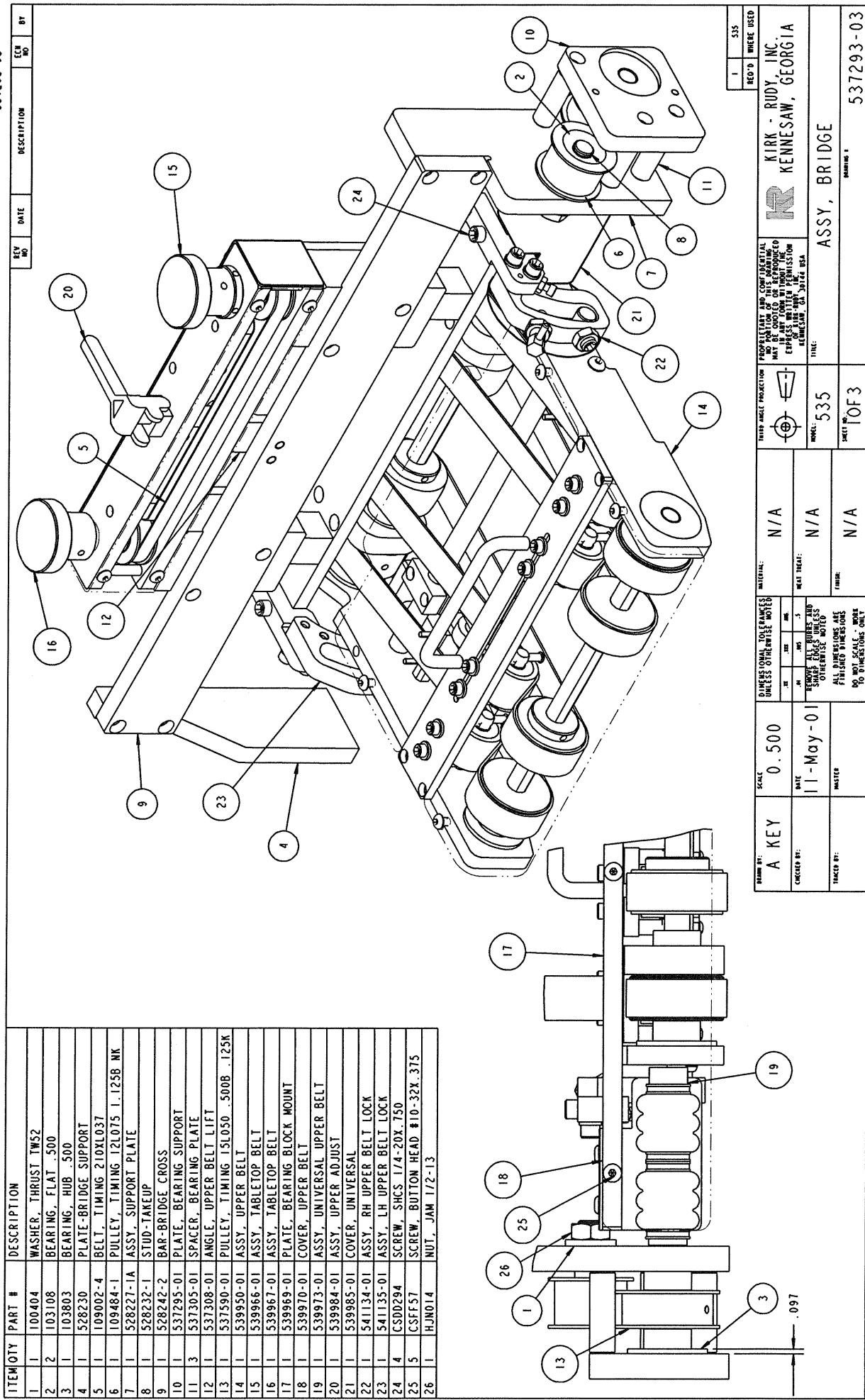
ITEM QTY	PART #	DESCRIPTION
1	102117	KNOB
2	105613	SHAFT, 10-32 X 2.00 LNG
3	537884-01	CAP, SKID BAR ADJUST
4	537885-01	BLOCK, SKID BAR ADJUST CLAMP
5	537886-01	ASSY, TRIKNOB 10-32 X 2.000 LNG
6	539817-01	ASSY, SKID BAR CLAMP
7	CSDD264	
8	HMSN10	HEX NUT



I	SP76300
RECD	WHERE USED

DRAWN BY:	A KEY	SCALE	2 . 000	MATERIAL:	N / A	THIRD ANGLE PROJECTION	PROPRIETARY AND CONFIDENTIAL NO POSITION OR DRAWING MAY BE COPIED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY INC. KENNE SAW, GA 30144 USA
CHECKED BY:		DATE	05 - Dec - 00	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:	5335
				ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY		SHEET NO.:	10F1

539817-01

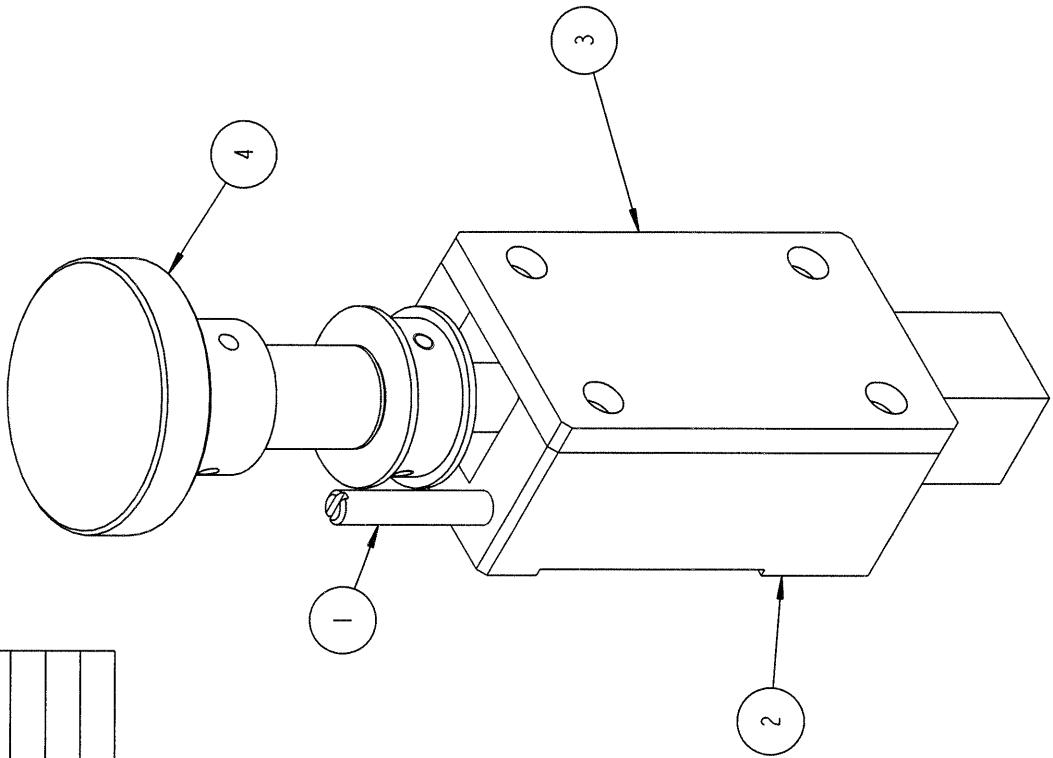


ITEM #	REV #	DATE	DESCRIPTION	ECN #
				535

ITEM #		RED O WHERE USED	
KIRK - RUDY, INC. KENNESAW, GEORGIA			

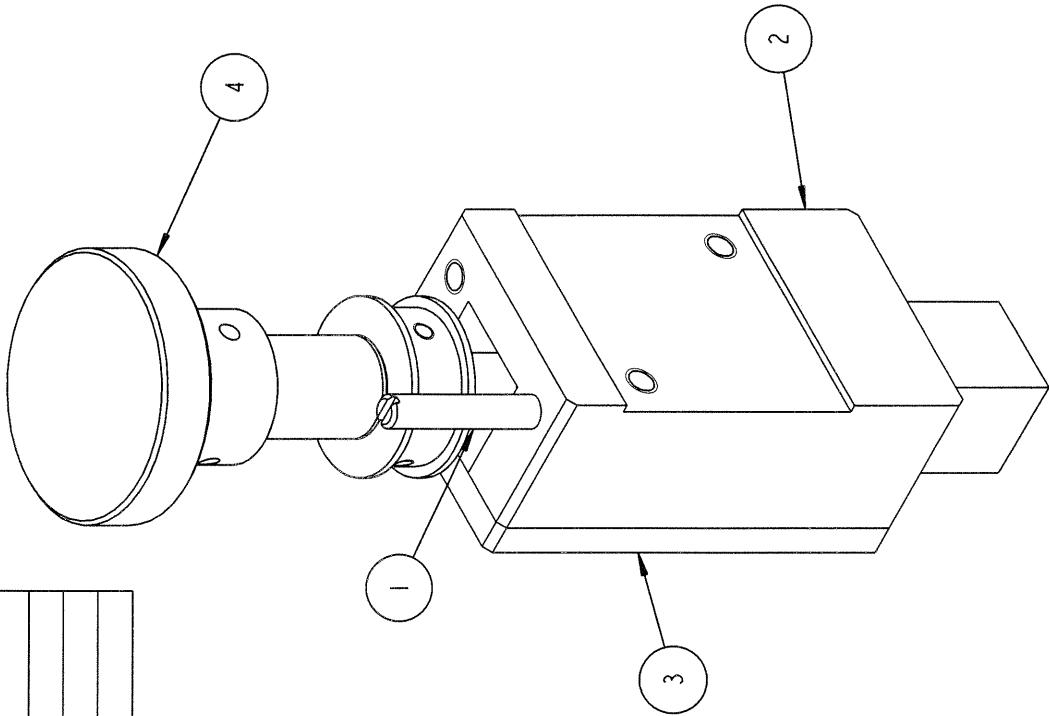
ITEM #:		SCALE:	DIMENSIONAL TOLERANCES MATERIAL:	
			IN	MM
KEY	A	0 .500	N/A	
CREATED BY:		DATE:	.005	.005
			-	-
			WEAR TOLERANCE:	
			REMOVED ALL SURFACES AND SHAPES, WHETHER OR NOT SPECIFIED, TO THE TOLERANCE OF THE SURFACE, SHAPE, POSITION, OR OTHER DIMENSION.	
			ALL DIMENSIONS ARE FINISHED UNLESS OTHERWISE NOTED. USE SCALES TO SIZE. USE ONLY DIMENSIONS.	
MASTER	TRACED BY:	RELEASER:	N/A	

ITEM	QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	1	500799-10	STUD, BRIDGE (LONG)					
2	1	537294-01	BAR, BRIDGE					
3	1	537306-01	PLATE, UPPER BELT SUPP					
4	1	539964-01	ASSY, FORK					



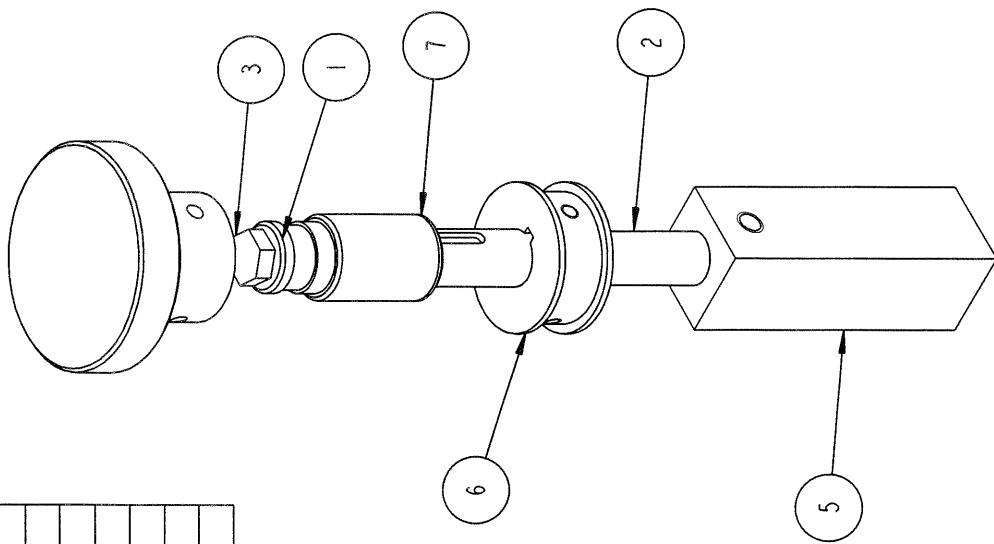
1	535			
REF'D	WHERE USED			
<p align="center"><b>KR</b> KIRK - RUDY, INC. KENNESAW, GEORGIA</p>				
<p align="center">PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE QUOTED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC., USA</p>				
<p align="center">THIRD ANGLE PROJECTION</p>				
MATERIAL:	N/A			
DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED				
.01	.005	.5	HEAT TREAT:	N/A
.xx	.xxx	ANG.		
CHECKED BY:		DATE: 29-May-01		
TRACED BY:		MASTER		
SCALE: A KEY		DIMENSION: 0 .750		
REMOVED ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED		ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY		
SHEET NO:	1 OF 1			TITLE: ASSY, TABLETOP BELT
DRAWING #:				DRAWING #:
539966-01				

ITEM	QTY	PART #	DESCRIPTION
1	1	500799-10	STUD, BRIDGE (LONG)
2	1	537294-01	BAR, BRIDGE
3	1	537306-01	PLATE, UPPER BELT SUPP
4	1	539964-01	ASSY, FORK



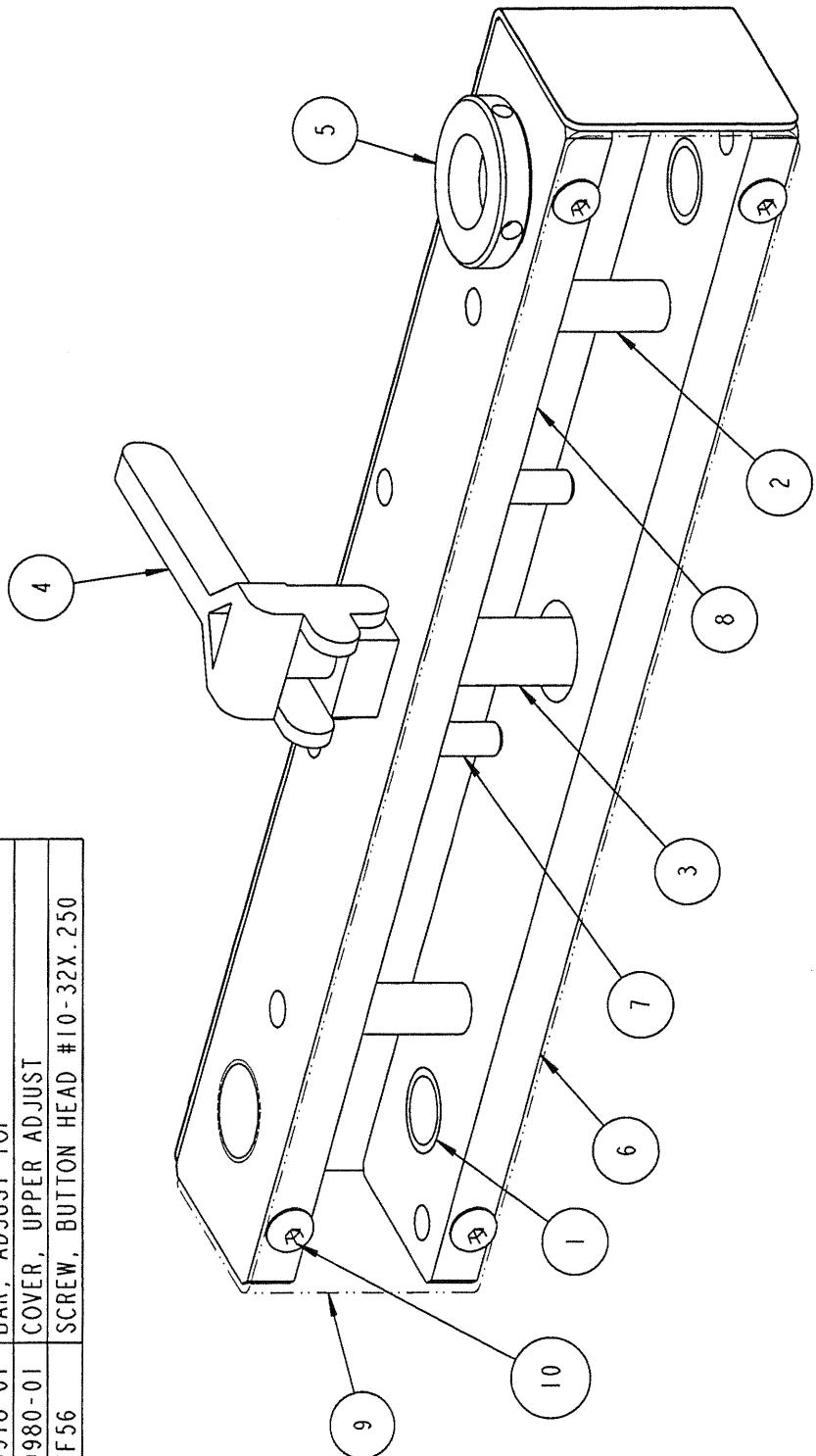
RECD	535		
WHERE USED			
<b>KRK KIRK - RUDY, INC. KENNESAW, GEORGIA</b>			
PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE QUOTED OR REPRODUCED IN ANY FORM, WITHOUT THE EXPRESS WRITTEN PERMISSION OF KRK-RUDY INC. KENNESAW, GA 30144 USA			
THIRD ANGLE PROJECTION			
MATERIAL:	N/A		
DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED			
.XX	.XXX	ANG.	
.01	.005	.5	HEAT TREAT:
REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED			
ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY			
DRAWN BY: A KEY	SCALE: 0 . 750	DATE: 29-May-01	MODEL: 535
CHECKED BY:			TITLE: ASSY, TABLETOP BELT
TRACED BY:	MASTER	FINISH:	SHEET NO. 1 OF 2
		DRAWING #	539967-01

ITEM	QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	1	100604	WASHER, FLAT 1/4ID BRASS					
2	1	102701	SPRING					
3	1	107342	BOLT - HEX HEAD 1/4-20 X 5.500					
4	1	500812	KNOB, ROLLER ADJUSTMENT					
5	1	539968-01	BAR - FORK					
6	1	539981-01	PULLEY, 18XL037 .625B NO HUB					
7	1	539982-01	SLEEVE - THREADED					



DRAWN BY: <b>A KEY</b>	SCALE: <b>0 .625</b>	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED -.xx .xxx ANG. .01 .005 .5	MATERIAL: <b>N/A</b>	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. KENNESAW, GA 30144 USA	REF ID: <b>2</b>	WHERE USED <b>535</b>
CHECKED BY:	DATE <b>03-Apr-01</b>	HEAT TREAT: <b>N/A</b>	MODEL: <b>535</b>	TITLE: <b>ASSY , FORK</b>		
TRACED BY:	MASTER	FINISH: <b>N/A</b>	SHEET NO. <b>1 OF 1</b>	DRAWING # <b>539964-01</b>		

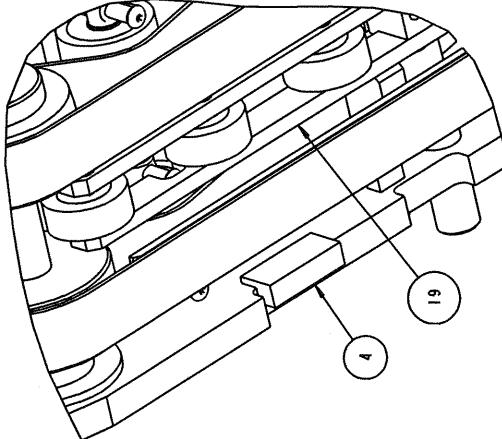
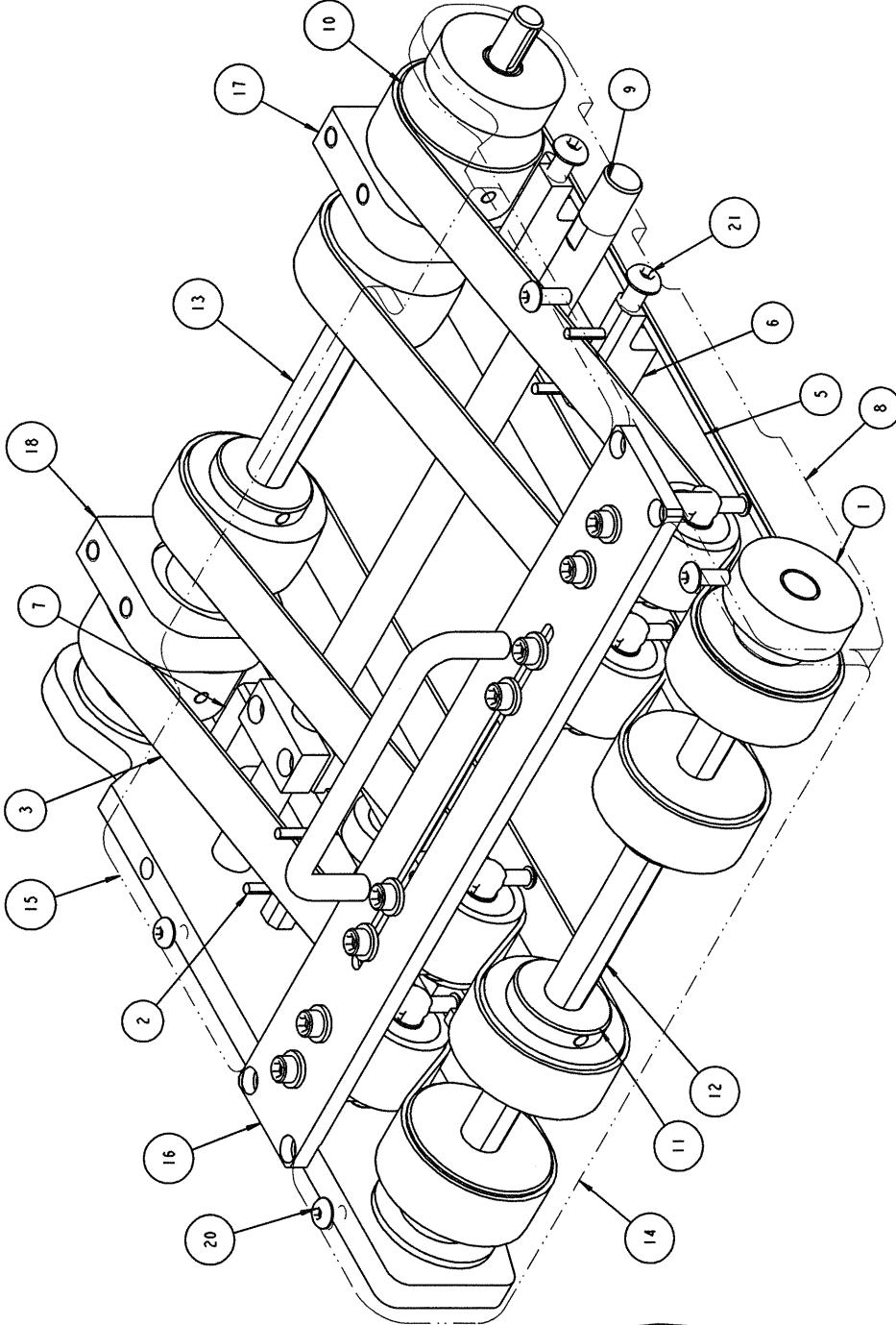
ITEM QTY	PART #	DESCRIPTION
1 2	100135	BUSHING, SL. 5001D. 6250D. 5001LG
2 2	100160	BUSHING, SL. 2501D. 3750D1. 0001LG
3 1	102670	SPACER
4 1	190733	CLAMP, QUICK RELEASE
5 1	500807	NUT - LOCK
6 1	539976-01	BAR, UPPER BELT LIFT
7 4	539977-01	SHAFT, UPPER BELT ADJUST
8 1	539978-01	BAR, ADJUST TOP
9 2	539980-01	COVER, UPPER ADJUST
10 8	CSFF56	SCREW, BUTTON HEAD #10-32X.250



DRAWN BY:	SCALE	0 .750	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.
CHECKED BY:	DATE	02-May-01	.XX .XXX ANG.	HEAT TREAT:	N/A		
TRACED BY:	MASTER			FINISH:	N/A	SHEET NO. 1 OF 3	TITLE: ASSY, UPPER ADJUST
							DRAWING # 539984-01

1	535
REQ'D	WHERE USED

ITEM NO.	PART #	DESCRIPTION
1	6 103803	BEARING, HUB .500
2	4 105210	PIN, ROLL .125X .750
3	4 106550	PLATE, FLAT 23.812 X .750
4	1 201170	SWITCH, SAFETY DOOR
5	2 539951-01	PLATE, BELT GUIDE
6	2 539952-01	PLATE, BELT SUPPORT MOUNT
7	2 539952-02	PLATE, BELT SUPPORT MOUNT
8	2 539953-01	ARM, UPPER BELT SUPPORT
9	1 539954-01	SHAFT, UPPER BELT ADJUST
10	4 539958-01	ROLLER, BELT DRIVE
11	4 539958-02	ROLLER, BELT DRIVE
12	1 539960-01	SHAFT, INFEED IDLER ROLLER
13	1 539961-01	SHAFT, OUTFEED DRIVE ROLLER
14	1 539962-01	COVER, INFEED
15	1 539963-01	COVER, OUTFEED
16	1 539963-01	ASSY, BELT TAKE UP
17	1 539972-01	PLATE, RH BEARING
18	1 539972-02	PLATE, LH BEARING
19	1 541742-01	KIT, FLOATING ROLLER SKID BAR
20	4 CSFF58	SCREW, BUTTON HEAD #10-32X.500
21	4 CSFF65	SCREW, BUTTON HEAD 1/4X.500



ITEM NO.	REV NO.	DATE	ECN NO.	BY

1	535	RED O WHERE USED		
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THIS DRAWING PROTECTS PROPRIETARY AND CONFIDENTIAL INFORMATION OF KIRK-RUDY, INC. IT IS THE PROPERTY OF KIRK-RUDY, INC. AND IS TO BE KEPT FROM PUBLIC VIEWING OR DISCLOSURE. IT IS THE PROPERTY OF KIRK-RUDY, INC. AND IS TO BE KEPT FROM PUBLIC VIEWING OR DISCLOSURE. IT IS THE PROPERTY OF KIRK-RUDY, INC. AND IS TO BE KEPT FROM PUBLIC VIEWING OR DISCLOSURE.				
KIRK-RUDY, INC. KENNESAW, GEORGIA				
TIME:				
ITEM:	5335	MODEL:	5335	SET

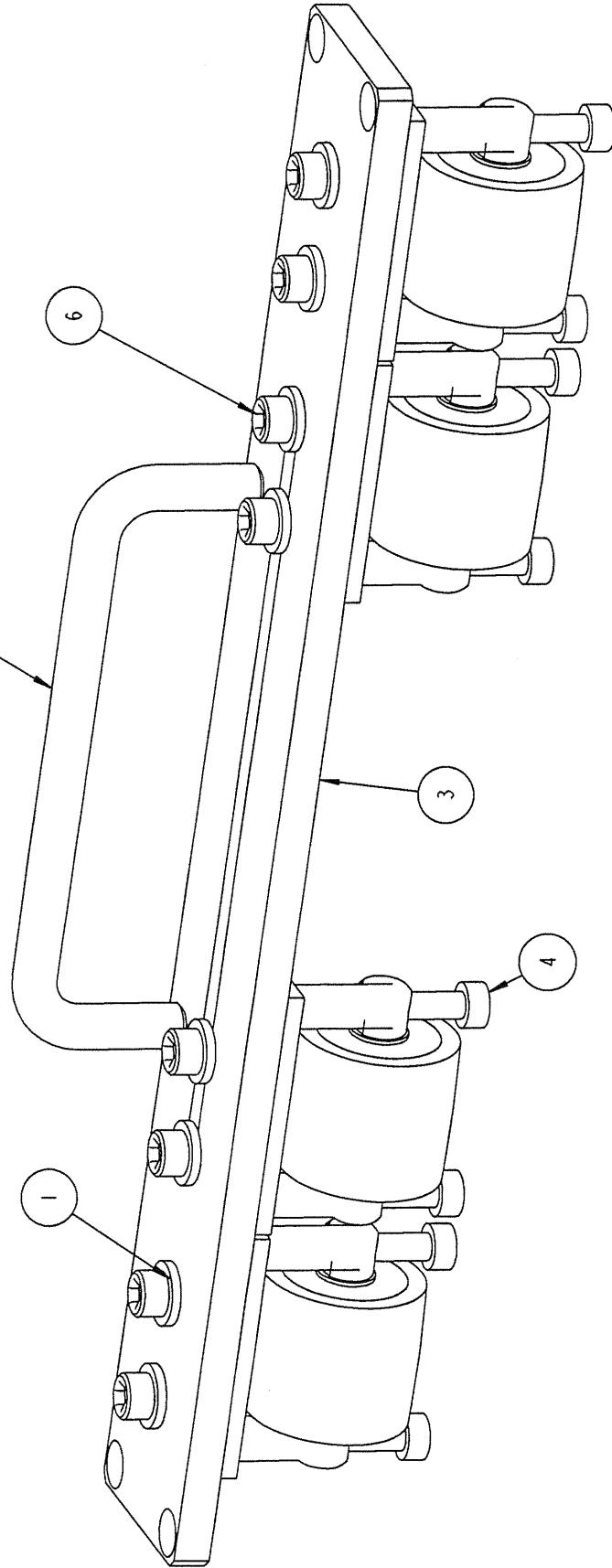
  

ITEM NO.	SCALE	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED
	"	"
CHECKED BY:	DATE	INCH MM
		" .005 .005
TRACED BY:	MASTER	INCHES ALL SURFACES AND OTHER FEATURES ARE UNLESS OTHERWISE SPECIFIED
		ALL DIMENSIONS ARE INCHES UNLESS OTHERWISE SPECIFIED
		NO. NO. SCALE - WHERE DIMENSIONS ARE INCHES ONLY

DRAWING # 539950-01  
ASSY, UPPER BELT

TOF 2

ITEM	QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	10	100619	WASHER, FLAT 10-32					
2	1	190955	HANDLE					
3	1	539955-01	BAR, SPRING MOUNT					
4	4	539959-01	ASSY, TAKEUP ROLLER					
5	2	CSD238	SCREW, SHCS 8-32X.500					
6	8	CSD265	SCREW, SHCS 10-32X.500					



1	535										
RECD	WHERE USED										
<p align="center"><b>KRK KIRK - RUDY, INC.</b> <b>KENNE SAW, GEORGIA</b></p>											
<p align="center">PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE QUOTED OR REPRODUCED IN WHOLE OR IN PART WITHOUT THE WRITTEN PERMISSION OF KIRK-RUDY, INC. KENNESAW, GA 30144 USA</p>											
TITLE:											
MODEL: 535											
DRAWING #:											
SHEET NO.: 10F1	DRAWING #:										
ASSY, BELT TAKE UP											
<p align="center">DRAWN BY: A KEY      SCALE: 0 . 938      MATERIAL: N/A      THIRD ANGLE PROJECTION</p>											
<p align="center">DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED</p>											
<table border="1"> <tr> <td>.01</td> <td>.005</td> <td>.5</td> <td>HEAT TREAT:</td> <td>N/A</td> </tr> <tr> <td>.01</td> <td>.005</td> <td>.5</td> <td>FINISH:</td> <td>N/A</td> </tr> </table>		.01	.005	.5	HEAT TREAT:	N/A	.01	.005	.5	FINISH:	N/A
.01	.005	.5	HEAT TREAT:	N/A							
.01	.005	.5	FINISH:	N/A							
<p align="center">REMOVE ALL BURRS, AND SHARP EDGES UNLESS OTHERWISE NOTED</p>											
<p align="center">ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY</p>											
MASTER	M										

ITEM	QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	2	102714	SPRING, COMPRESSION					
2	2	103106	BEARING, FLAT .375					
3	2	104100	SNAPRING, .375					
4	1	508761-2	ROLLER, TAKE UP					
5	1	508761-2A	ASSY, ROLLER					
6	1	539956-01	BLOCK, TAKEUP MOUNT					
7	1	539957-01	SHAFT, TAKEUP ROLLER					
8	1	539959-01	ASSY, TAKEUP ROLLER					
9	2	541058-01	SLEEVE, SPRING ROLLER					
10	2	CSFF45	SCREW, BUTTON HEAD #6-32X.188					

4 535  
REG'D WHERE USED

ASSY, TAKEUP ROLLER  
 539959-01

DRAWN BY:  
**A KEY**  
 SCALE: 2.000  
 DATE: 04-Dec-01  
 CHECKED BY:  
 TRACED BY:  
 MASTER

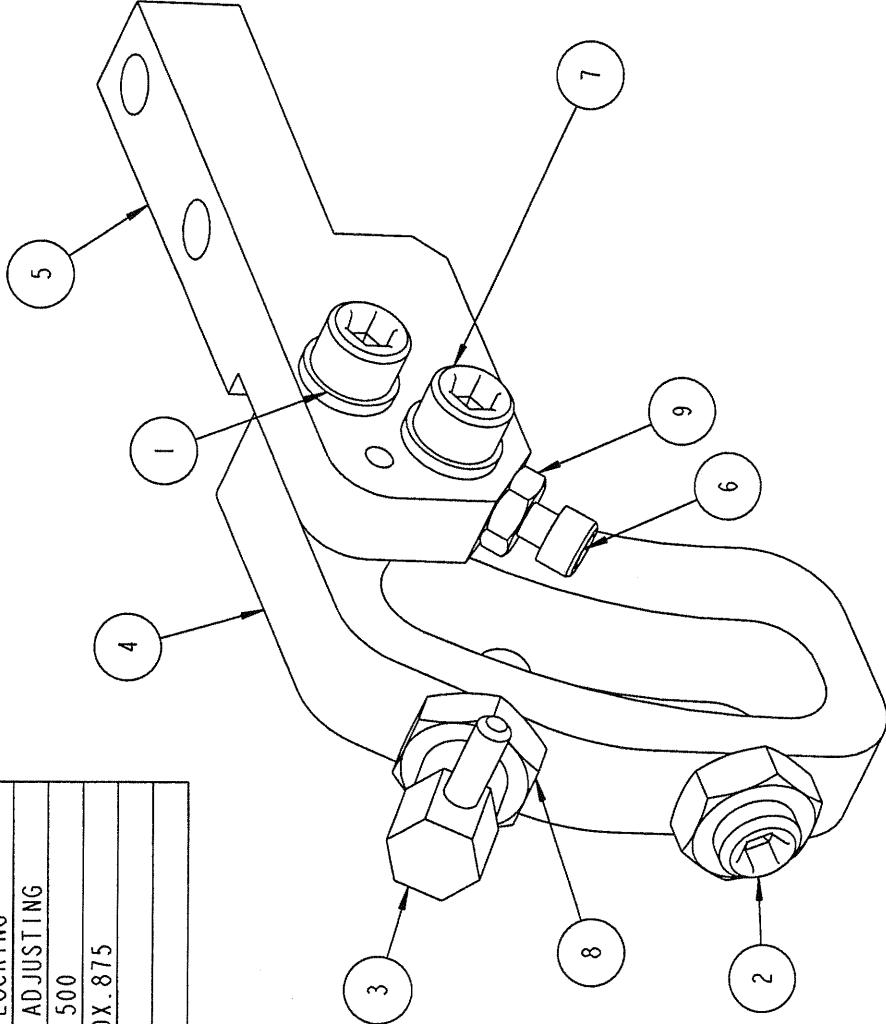
DIMENSIONAL TOLERANCES  
 UNLESS OTHERWISE NOTED  
 .XX .XXX .5  
 .01 .005 ANG.  
 REMOVE ALL BURRS AND  
 SHARP EDGES UNLESS  
 OTHERWISE NOTED  
 ALL DIMENSIONS ARE  
 FINISHED DIMENSIONS  
 DO NOT SCALE - WORK  
 TO DIMENSIONS ONLY

MATERIAL: N/A  
 HEAT TREAT: N/A  
 FINISH: N/A  
 SHEET NO. 1 OF 1  
 TITLE: 535  
 DRAWING #: 4

PROPRIETARY AND CONFIDENTIAL  
 NO PORTION OF THIS DRAWING  
 MAY BE OCULATED OR REPRODUCED  
 IN ANY FORM WITHOUT THE  
 EXPRESS WRITTEN PERMISSION  
 OF KIRK-RUDY, INC.  
 KENNESAW, GA 3044 USA

**KR** KIRK-RUDY, INC.  
 KENNESAW, GEORGIA

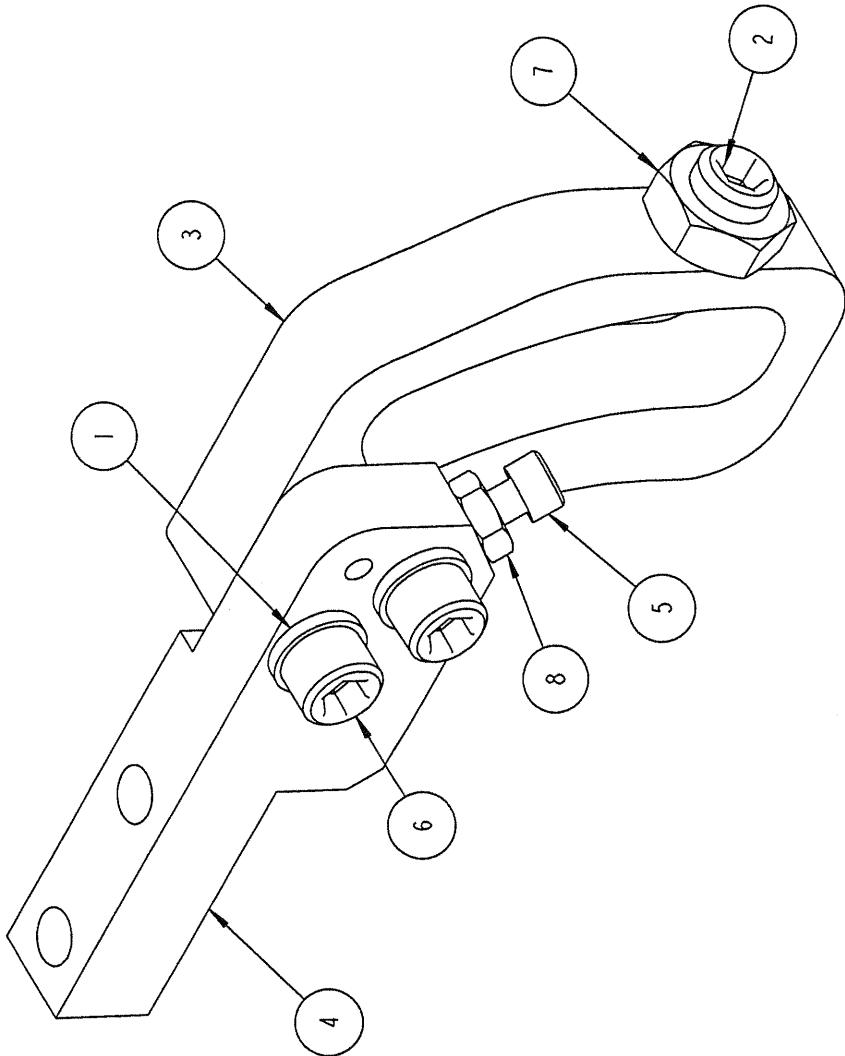
ITEM QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	2	100603 WASHER, FLAT 1/4ID					
2	1	190965 BALL PLUNGER, DELRIN NOSE	3	/8-16			
3	1	190967 HAND PLUNGER, 3/8-16X1.13					
4	1	541136-01 PLATE, UPPER BELT LOCKING					
5	1	541137-01 PLATE, UPPER BELT ADJUSTING					
6	1	CSDD238 SCREW, SHCS 8-32X .500					
7	2	CSD295 SCREW, SHCS 1/4-20X .875					
8	2	HJN012 NUT, JAM 3/8-16					
9	1	HMSN09 NUT, HEX #8-32					



1	535	REF'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
MATERIAL:	N/A		
DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED			
DATE	02-May-01	ANG.	
CHECKED BY:		.01	.005
TRACED BY:	MASTER	.005	.5
		REMOVE ALL BURRS AND STRAIGHTEN EDGES UNLESS OTHERWISE NOTED	
		ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY	
		SHEET NO. 1 OF 1	DRAWING #

541134-01

ITEM	QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	2	100603	WASHER, FLAT 1/4ID					
2	1	190965	BALL PLUNGER, DELRIN NOSE 3/8-16					
3	1	541136-03	PLATE, UPPER BELT LOCKING					
4	1	541137-02	PLATE, UPPER BELT ADJUSTING					
5	1	CSDD238	SCREW, SHCS 8-32X .500					
6	2	CSDD295	SCREW, SHCS 1/4-20X .875					
7	1	HJN012	NUT, JAM 3/8-16					
8	1	HMSN09	NUT, HEX #8-32					



1	535
REQ'D	WHERE USED

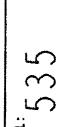
PROPRIETARY AND CONFIDENTIAL  
NO PORTION OF THIS DRAWING  
MAY BE QUOTED OR REPRODUCED  
IN ANY FORM WITHOUT THE  
EXPRESS WRITTEN PERMISSION  
OF KIRK-RUDY, INC.  
KENNESAW, GA 30144 USA



KIRK - RUDY, INC.  
KENNESAW, GEORGIA

ASSY, LH UPPER BELT LOCK

DRAWING #



541135-01

DRAWN BY: A KEY	SCALE 1 . 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. KENNESAW, GA 30144 USA	
CHECKED BY:	DATE 11-May-01	.01 .005	.005 .5	HEAT TREAT: N/A		MODEL: 535	TITLE: ASSY, LH UPPER BELT LOCK
TRACED BY:	MASTER 	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED		FINISH: N/A	SHEET #10 TOP F 1	DRAWING #	541135-01
		ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY					

ITEM QTY	PART #	DESCRIPTION
1 2	190835	BELLOWS, UNIVERSAL
2 1	528225-1	SHAFT-UPPER FEED ROLLER
3 1	539974-01	JOINT, UNIVERSAL

ITEM QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1 2	190835	BELLOWS, UNIVERSAL					
2 1	528225-1	SHAFT-UPPER FEED ROLLER					
3 1	539974-01	JOINT, UNIVERSAL					

1 535  
REV'D WHERE USED

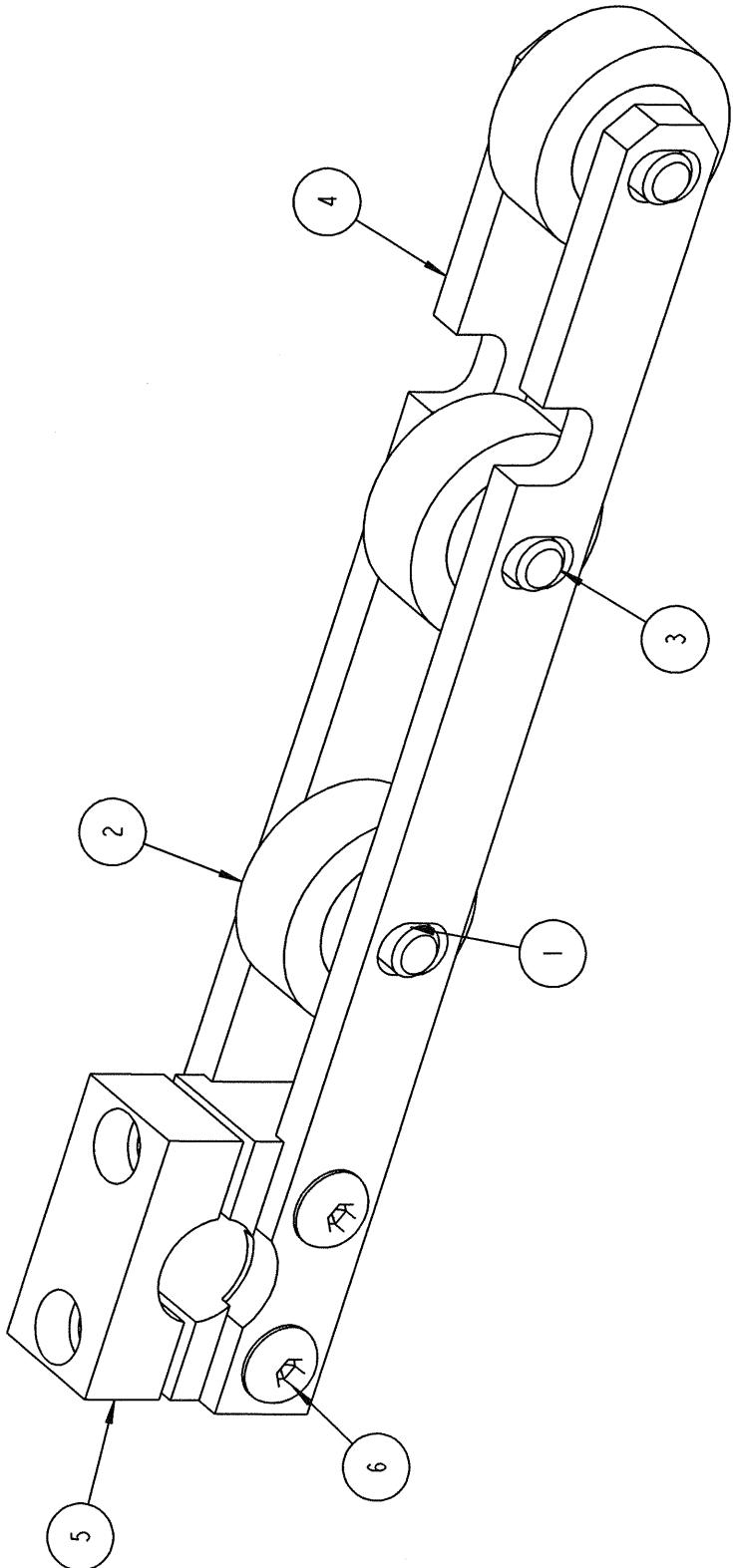
PIN SHAFT TO  
UNIVERSAL

SECTION A-A  
SCALE 1.250

ASSY, UNIVERSAL UPPER BELT  
DRAWING # 539973-01

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. KENNESAW, GA 30144 USA
A KEY	1 .250	.XX .XXX .01 .005 .5	N / A		KIRK - RUDY, INC. KENNESAW, GEORGIA
CHECKED BY:	DATE	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED	HEAT TREAT:	MODEL:	TITLE:
	20 - Feb - 01		N / A	535	ASSY, UNIVERSAL UPPER BELT
TRACED BY:	MASTER	ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE WORK TO DIMENSIONS ONLY	FINISH:	SHEET NO.	DRAWING #
	m	N / A	N / A	QF 1	539973-01

ITEM QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO
1	6	104107			SNAPRING, .250	
2	3	501057-A			ASSY, ROLLER	
3	3	537853-01			SHAFT, SKID BAR ROLLER	
4	2	541743-01			PLATE, SKID BAR ROLLER SUPPORT	
5	1	541744-01			BRACKET, SKID BAR MOUNT	
6	4	CSFF57			SCREW, BUTTON HEAD #10-32X.375	



DRAWN BY:	A KEY	SCALE	.250		DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED		MATERIAL:	N/A	THIRD ANGLE PROJECTION		KIRK - RUDY, INC.
CHECKED BY:		DATE	.xx	.xxx	ANG.					REPRODUCED IN ANY FORM OR PART WITHOUT THE WRITTEN PERMISSION OF KIRK-RUDY, INC., KENNESAW, GA. 30444 USA	KENNESAW, GEORGIA
TRACED BY:		04-DeC-01			HEAT TREAT:	N/A	MODEL:	535	TITLE: KIT, FLOATING ROLLER SKID BAR		
MASTER					FINISH:	N/A	SHEET NO.:	OF 3	DRAWING #:		

REV NO	DATE	DESCRIPTION	ECN NO	BY

**SWITCH LOCATION**

**ITEM QTY PART # DESCRIPTION**

1	4	102132	KNOB, 10-32 CAP SCREW
2	1	201170	SWITCH, SAFETY DOOR
3	2	202261-13	BANNER SWITCH, SENSOR
4	1	528205-7	CHANNEL, FOLDER
5	1	528205-8	CHANNEL, FOLDER
6	1	531923-02	TABLETOP, TABBER
7	2	537314-01	SIDEGUIDE, TABBER
8	1	537503-01	KIT, BUMP TURN
9	2	537589-01	BRACKET, REFLECTOR MOUNT
10	1	537595-03	GUIDE, BOTTOM TAB
11	1	537595-04	GUIDE, BOTTOM TAB
12	2	537730-01	REFLECTOR, RECTANGLE
13	2	537880-02	BLOCK, BEAM SWITCH MOUNT
14	4	CSDD268	SCREW, SHCS 10-32X.875

DRAWN BY: A KEY SCALE 0 . 188 DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED

DATE	.xx	.xxx	ANG.	.5	HEAT TREAT:
30-Apr-01	.01	.005			N / A

REMOVED ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED

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

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.  
WOODSTOCK, GA 30188 USA

REO'D WHERE USED

1 SP76300

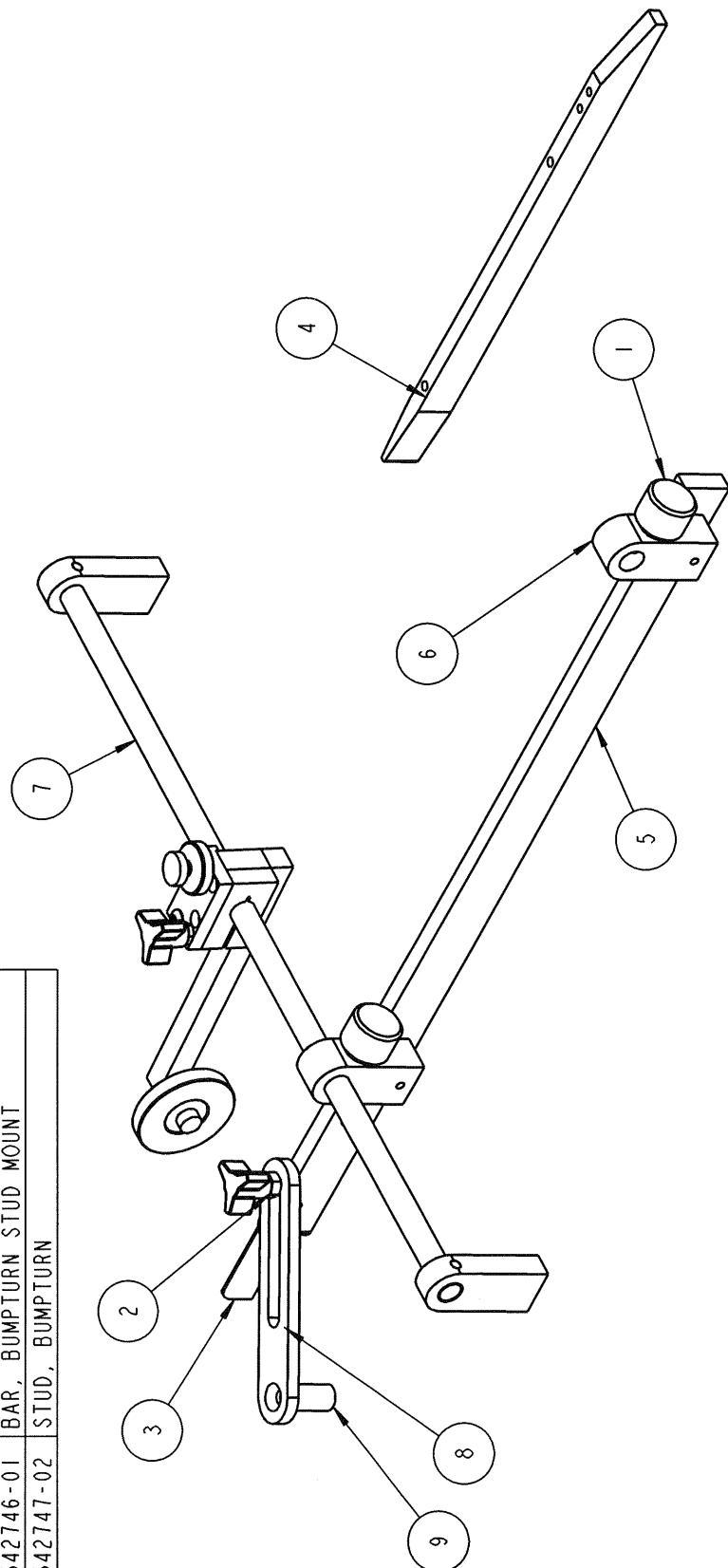
ASSY, TABLETOP

MASTER

DRAWING # 537313-01

ITEM QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1 2	500793	LOCK, SIDE GUIDE CAM	1	5/22/03	ADD ITEMS 2, 8 AND 9	6974	P&B
2 1	500790-2	ASSY, TRI-KNOB 1/4-20 STUD					

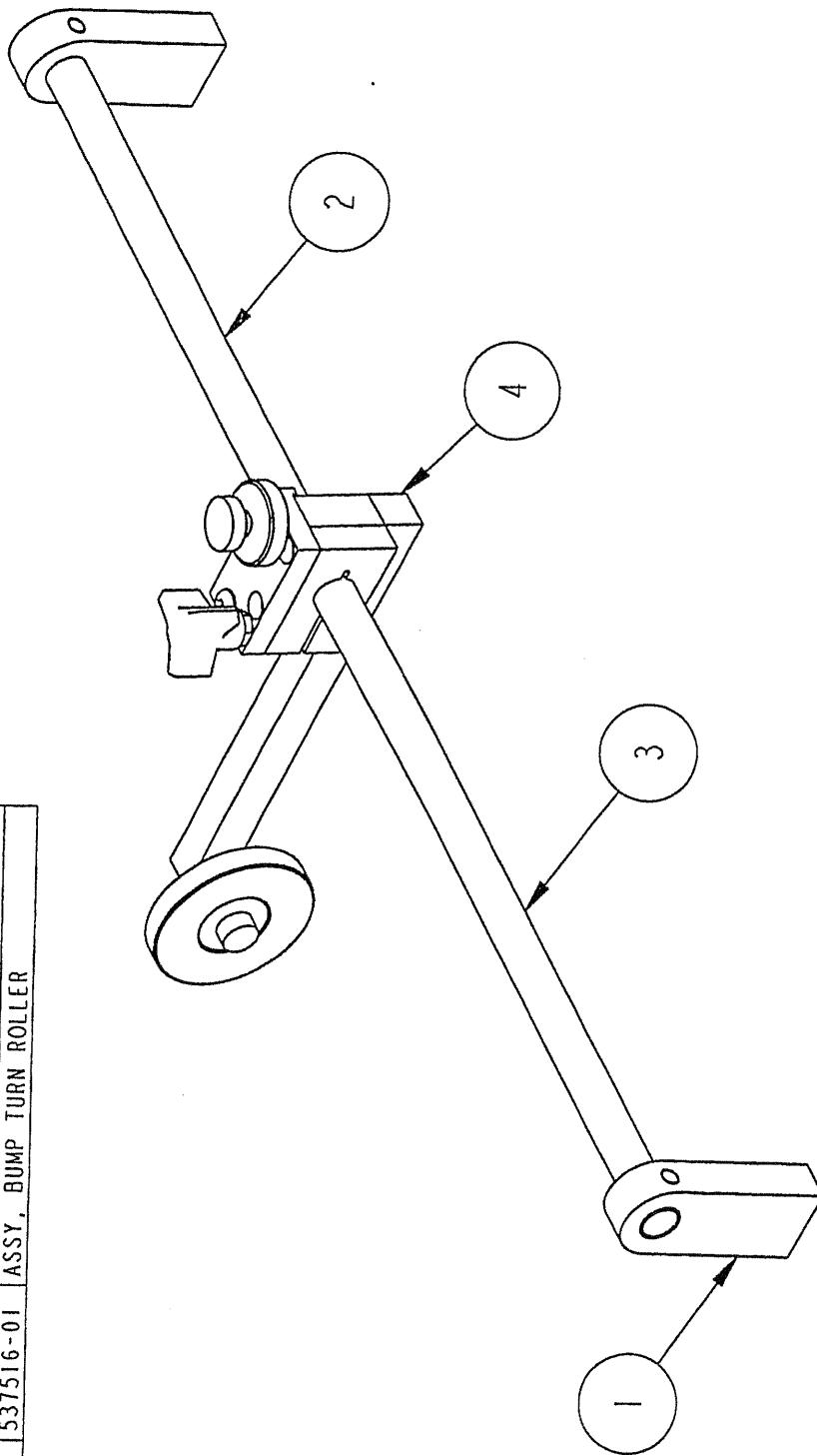
A KEY	SCALE	0 .3   3	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	MATERIAL:	N/A	THIRD ANGLE PROJECTION	PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE QUOTED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC. KENNESAW, GA 30444 USA
CHECKED BY:	DATE	.XX .XXX	.005 .01 .05 ANG.	HEAT TREAT:	N/A	MODEL:	KIRK - RUDY, INC. KENNESAW, GEORGIA
TRACED BY:	DATE	08-0C1 - 99	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED	FINISH:	N/A	SHEET NO:	KIT, BUMP TURN
MASTER			ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE. WORK TO DIMENSIONS ONLY			1 OF 2	DRAWING #: 537503-01



I	SP76300
REO'D WHERE USED	

A KEY	SCALE	0 .3   3	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 30444 USA
CHECKED BY:	DATE	.XX .XXX	.005 .01 .05 ANG.	HEAT TREAT:	N/A	MODEL:	KIRK - RUDY, INC. KENNESAW, GEORGIA
TRACED BY:	DATE	08-0C1 - 99	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED	FINISH:	N/A	SHEET NO:	KIT, BUMP TURN
MASTER			ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE. WORK TO DIMENSIONS ONLY			1 OF 2	DRAWING #: 537503-01

ITEM QTY	PART #	DESCRIPTION
1	2	503556 POST, SIDEGUIDE
2	1	527687-1 SHAFT, SKID BAR
3	1	537508-01 ASSY, SIDEGUIDE POST
4	1	537516-01 ASSY, BUMP TURN ROLLER



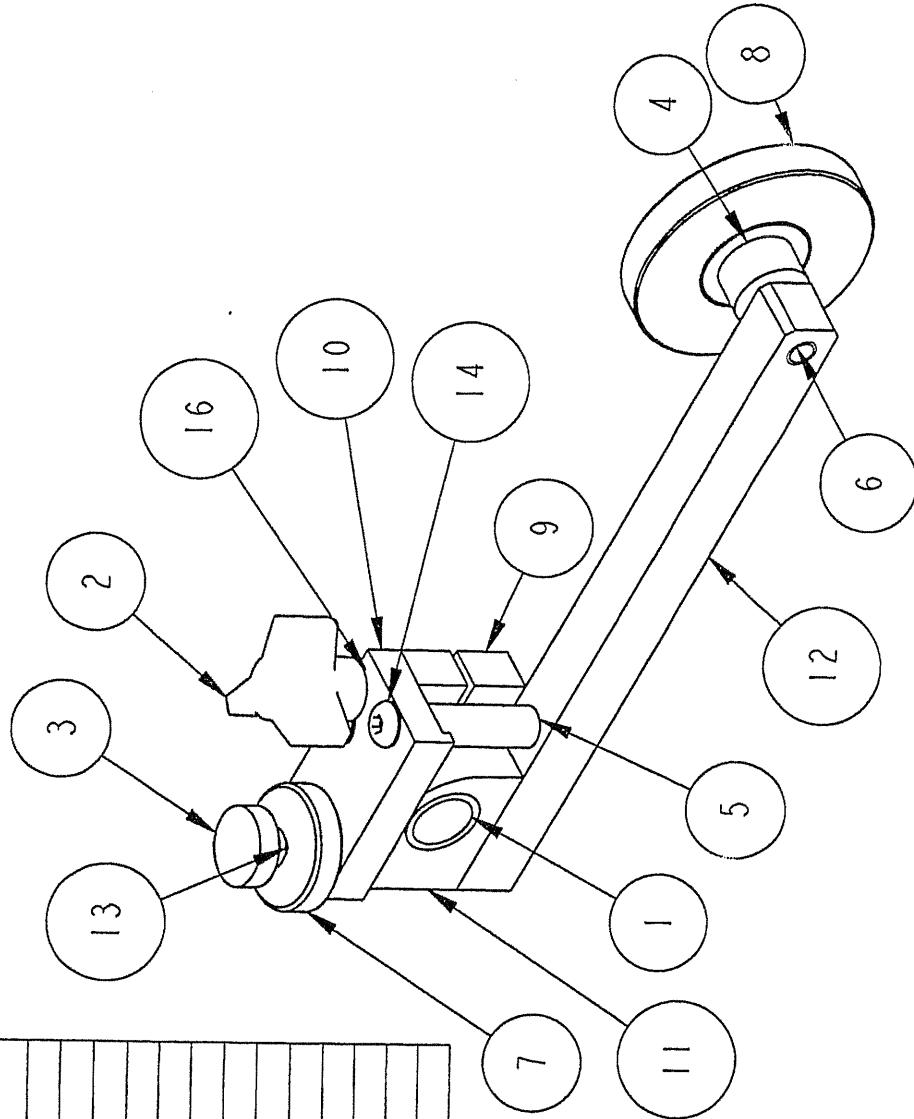
DRAWN BY:	SCALE	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	MATERIAL:	THIRD ANGLE PROJECTION	PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE QUOTED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, KENNESAW, GEORGIA	RECORD #:	WHERE USED
A KEY	0 .500	.01 .005 .5	N/A			SP76300	KIRK - RUDY, INC.
CHECKED BY:	DATE	X .XX ANG.	HEAT TREAT:				KENNESAW, GEORGIA
TRACED BY:	MASTER	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED	FINISH:			10F1	ASSY, POST

TITLE: KR 535

SHEET NO. 1 OF 1

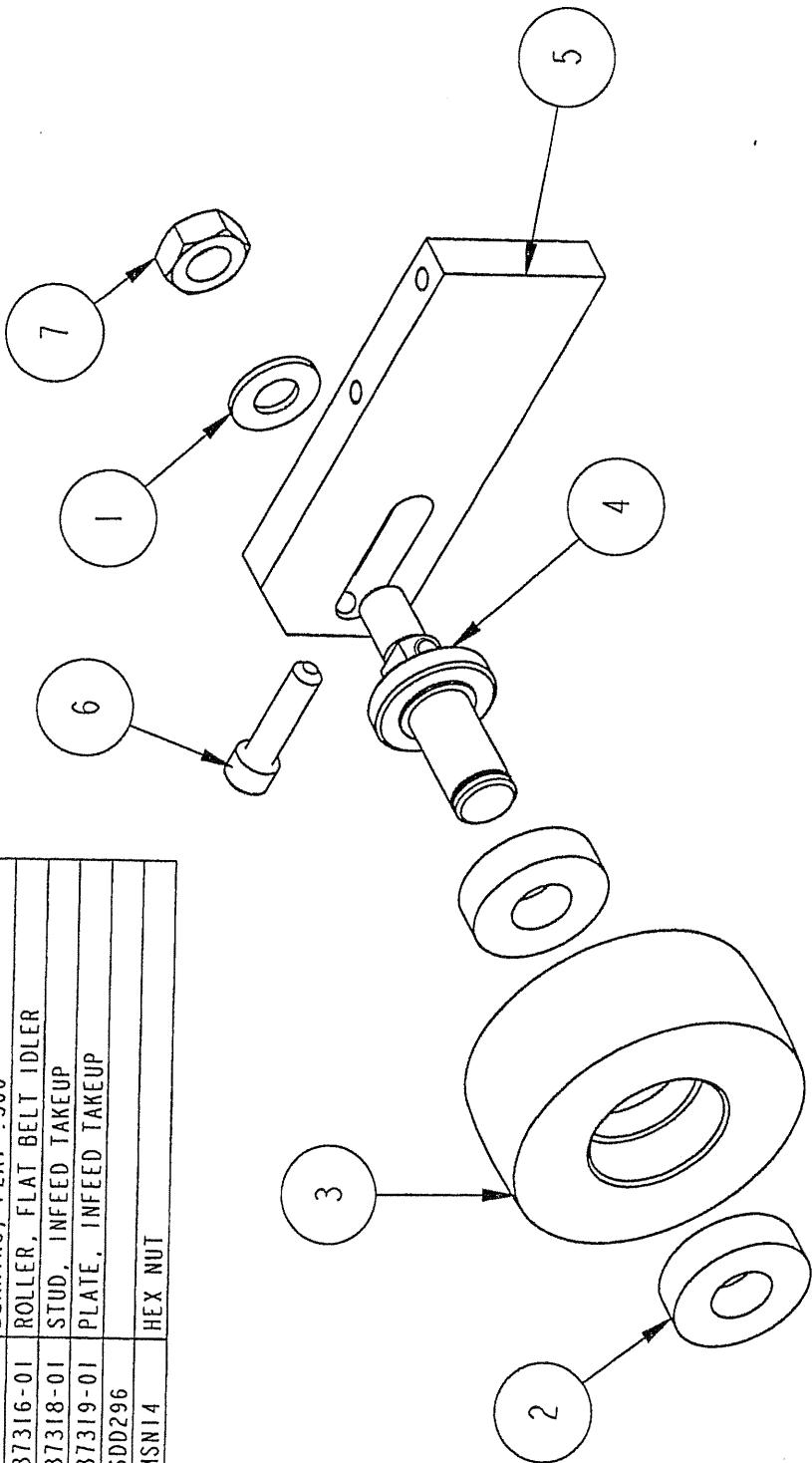
DRAWING # 537517-01

ITEM QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ETCH NO	BY
1	1 100135	BUSHING, SL.5001D.6250D.500LG					
2	1 102119	KNOB					
3	1 102132	KNOB, 10-32 CAP SCREW					
4	1 102204	COLLAR .313					
5	1 102704	SPRING, COIL					
6	1 107104	BOLT, SHOULDER 5/16X3/4					
7	1 502268	KNOB - JAM NUT					
8	1 500339A	ASSY, ROLLER					
9	1 537512-01	BLOCK, BUMP TURN ROLLER MNT					
10	1 537513-01	PLATE, BUMP TURN CAP					
11	1 537514-01	BLOCK, BUMP TURN PIVOT					
12	1 537515-01	ARM, BUMP TURN ROLLER MNT					
13	1 CSDD267						
14	1 CSFF58	BUTTON HEAD SCREW					
15	1 CSFF60	BUTTON HEAD SCREW					
16	1 HMSN10	HEX NUT					



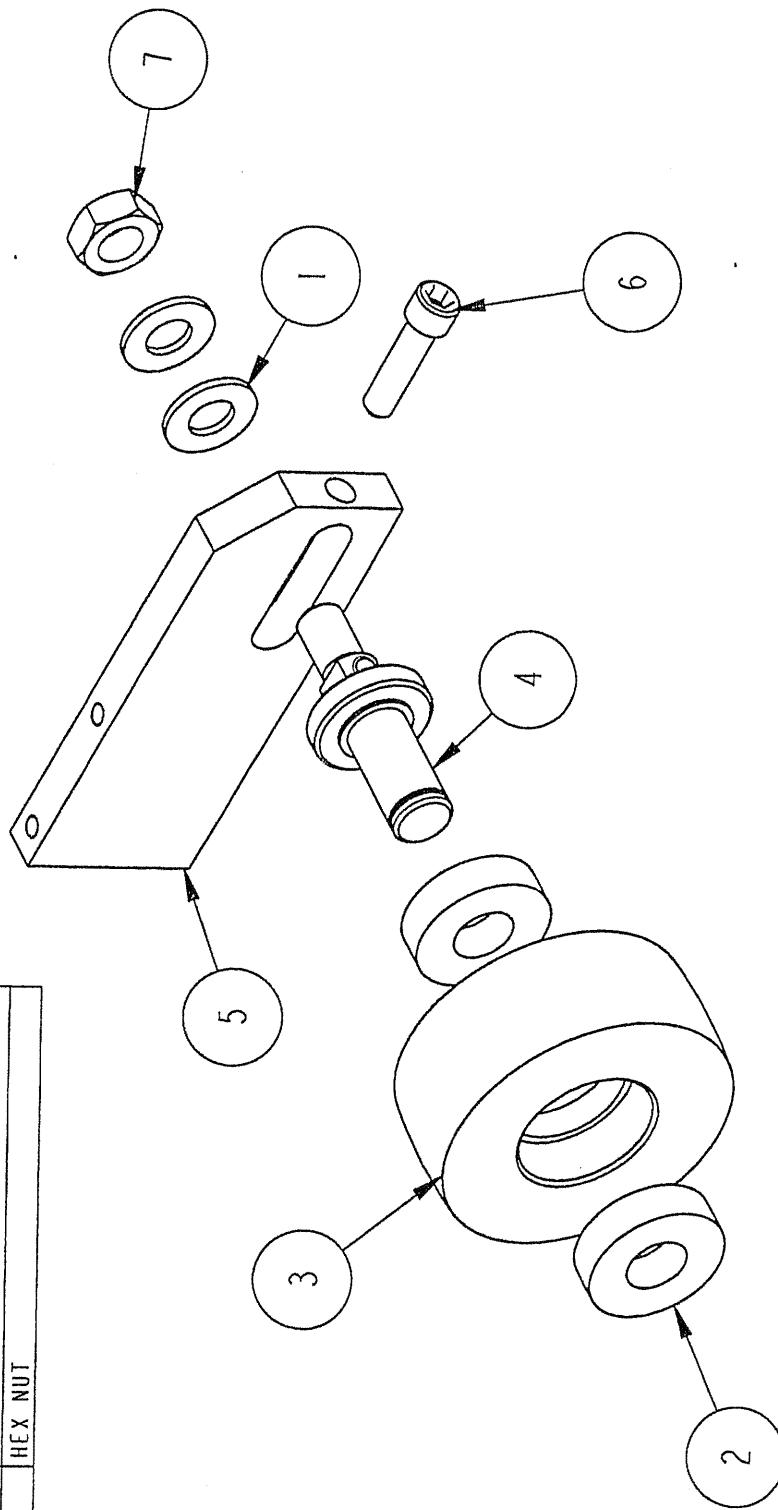
DRAWN BY: A KEY	SCALE 0 .750	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED		MATERIAL: N/A	THIRD ANGLE PROJECTION	PROPRIETARY AND CONFIDENTIAL NO PART OF THIS DRAWING MAY BE COPIED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC. KENNESAW, GA 30144 USA
CHECKED BY:	DATE 08-08-99	.01	.015	ANF.	REAR TREAT:	N/A
TRACED BY:	MASTER	.01 REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED		ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY	MODEL: KR535	SHEET <sup>10</sup> OF 1
					TITLE: ASSY, BUMP TURN ROLLER	DRAWING #: 537516-01

ITEM	QTY	PART #	DESCRIPTION
1	1	100402	WASHER, THRUST TB612
2	2	103108	BEARING, FLAT .500
3	1	537316-01	ROLLER, FLAT BELT IDLER
4	1	537318-01	STUD, INFEED TAKEUP
5	1	537319-01	PLATE, INFEED TAKEUP
6	1	CSD296	
7	1	HMSN14	HEX NUT



DRAWN BY:	A KEY	SCALE	0 . 750	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 30444 USA
CHECKED BY:	DATE	.xx	.xx	ANG.	HEAT TREAT:	N / A	KIRK - RUDY, INC. KENNESAW, GEORGIA
TRACED BY:	MASTER	.01	.005	.5	REMOVED ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED	N / A	MODEL: KR535
					ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY	SHEET NO.: 10F1	TITLE: ASSY, INFED TAKEUP BELT
							DRAWING #: 537317-01

ITEM QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	2	100402 WASHER, THRUST TB612					
2	2	103108 BEARING, FLAT .500					
3	1	537316-01 ROLLER, FLAT BELT IDLER					
4	1	537318-01 STUD, INFEED TAKEUP					
5	1	537319-01 PLATE, INFEED TAKEUP					
6	1	C SDD296					
7	1	HMSN14 HEX NUT					



1	SP716300
RECD	WHERE USED
KR	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	
Model:	KR535
Date:	08-00C + - 99
Traced by:	MASTER
Scale:	0 .750
Drawn by:	A KEY
DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	
.01	.005
.005	.005
.5	.5
HEAT TREAT:	
REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED	
ALL DIMENSIONS ARE FINISHED DIMENSIONS	
DO NOT SCALE - WORK TO DIMENSIONS ONLY	
SHEET NO:	1 OF 1
DRAWING #:	537320-01

ITEM QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	2	100611 WASHER, FLAT 1/2ID 1/16TK					
2	2	103108 BEARING, FLAT .500					
3	2	537319-01 PLATE, INFEED TAKEUP					
4	1	537322-01 ROLLER, CENTER INFEED FLAT BELT					
5	1	537323-01 SHAFT, INFEED TAKEUP					
6	2	CSDD296					

DRAWN BY:  
A KEY  
SCALE  
0 .625

CHECKED BY:  
DATE  
08-0c†-99

TRACED BY:  
MASTER

DIMENSIONAL TOLERANCES  
UNLESS OTHERWISE NOTED

.01	.005	.5	HEAT TREAT:	N/A
-----	------	----	-------------	-----

REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED

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

MATERIAL:  
N/A

THIRD ANGLE PROJECTION

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

KR535

ASSY, CENTER INFEED BELT TAKEUP

DRAWING #  
537321-01

	REV NO	DATE	DESCRIPTION	ECON NO	BY

ITEM	QTY	PART #	DESCRIPTION
1	1	202488	DISPLAY, MAPLE
2	1	201124-2	BUTTON, START
3	1	201124-4	BUTTON, POWER ON
4	1	201125-3	BUTTON, STOP
5	1	201125-7	BUTTON, POWER OFF
6	2	201145-1	SELECTOR, 2 POSITIONS
7	1	209016-2	LOCK, POT
8	1	209016-3	KNOB, POT
9	1	537327-01	WELDMENT, CONTROL PANEL
10	1	537588-01	PANEL, CONTROL

DRAWN BY: <b>A KEY</b>	SCALE: <b>0 .250</b>	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED		MATERIAL: <b>N/A</b>	THRO ANGLE PROJECTION	PROPRIETARY AND CONFIDENTIAL NO PARTS OF THIS DRAWING MAY BE COPIED OR REPRODUCED IN WHOLE OR IN PART WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY INC. WOODSTOCK, GA 30188 USA	
CHECKED BY:	DATE: <b>08-0ct-99</b>	.xx	.xxx	ANG. <b>.01</b>	HEAT TREAT: <b>N/A</b>	<b>535</b>	TITLE: <b>KIRK - RUDY, INC.</b> <b>WOODSTOCK, GEORGIA</b>
TRACED BY:	MASTER <b>M</b>	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED		FINISH: <b>N/A</b>	SHEET NO.: <b>0F2</b>	DRAWING #: <b>537324-01</b>	
		ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY					

ITEM QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	1 02132	KNOB, 10-32 CAP SCREW					
2	4 191030	PAD, LEVELING 1.57 DIA #38059					
3	3 190689-1	DOOR LATCH					
4	1 527657-1	DOOR, TABBER					
5	1 530441-01	BOX, ELECTRICAL INLET 20A					
6	1 535294-01	BRACKET, CONTROL BOARD MOUNT					
7	1 535295-01	COVER, CONTROL BOARD					
8	1 536926-01	BRACKET, BOARD SUPPORT					
9	1 537340-01	WLDMNT, TABBER CABINET W/LIFT LEGS					
10	1 537341-01	KIT, TABBER HYDRAULIC LIFT					
11	1 537344-02	COVER, LIFT KIT HOLE					
12	1 537345-01	WLDMNT, ELECTRICAL BOX					
13	1 537348-01	COVER, RH BOTTOM					
14	1 537349-01	COVER, LH BOTTOM					
15	2 537367-01	COVER, CABINET FAN					
16	1 537368-01	PANEL, ELECTRICAL					
17	1 CSFF63	BUTTON HEAD SCREW					

DRWNG NO:	A KEY	SCALE	0 .083	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	N / A	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
CHEC'D BY:		DATE	15 - Dec - 99	.01	.005	WEAT TREAT:	N / A		KIRK - RUDY, INC. KENNESAW, GEORGIA
TRACED BY:		MASTER				FINISH:	N / A	SHEET NO.	1 OF 1
						NOTE:	535	DRAWING #	ASSY, TABBER CABINET
									537369-01
								REC'D	SP76300 WHERE USED

ITEM	QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	4	102792	SPRING, EXTENSION					
2	1	191029-1	PUMP, MOVOTEC PB4612FC					
3	4	191029-2	CYLINDER, LIFT CB415					
4	4	191029-3	GLIDE, SUSPA					
5	3	537343-01	SPACER, LIFT KIT MOUNT					
6	4	537371-01	BRACKET, SPRING RETURN MOUNT					
7	4	537596-01	BLOCK, HYDRAULIC LIFT LH					
8	4	537596-02	BLOCK, HYDRAULIC LIFT RH					
9	2	537597-01	BRACKET, HYDRAULIC LIFT SPRING					
10	2	537597-02	BRACKET, HYDRAULIC LIFT SPRING					
11	2	CSDD266	SCREW, SHCS 10-32X .625					

1	SPT6300
RECD	WHERE USED

1	537341-01
---	-----------

**KR** KIRK - RUDY, INC.  
KENNESSAW, GEORGIA

PROPRIETARY AND CONFIDENTIAL  
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IN ANY FORM, WITHOUT THE  
EXPRESS WRITTEN PERMISSION  
OF KIRK RUDY, INC.  
KENNESSAW, GA 3044 USA

THIRD ANGLE PROJECTION

MATERIAL: N/A

HEAT TREAT: N/A

MODEL: 535

TITLE: KIT, TABBER HYDRAULIC LIFT

DRAWING #

SHEET NO: 10F1

FINISH: N/A

ALL DIMENSIONS ARE  
FURNISHED IN INCHES.  
DO NOT SCALE - WORK  
TO DIMENSIONS ONLY

REMOVE ALL BURRS AND  
SHARP EDGES UNLESS  
OTHERWISE NOTED

DIMENSIONAL TOLERANCES  
UNLESS OTHERWISE NOTED

.01 .005 .5

.XX .XXX ANG.

SCALE 0.130

KEY A

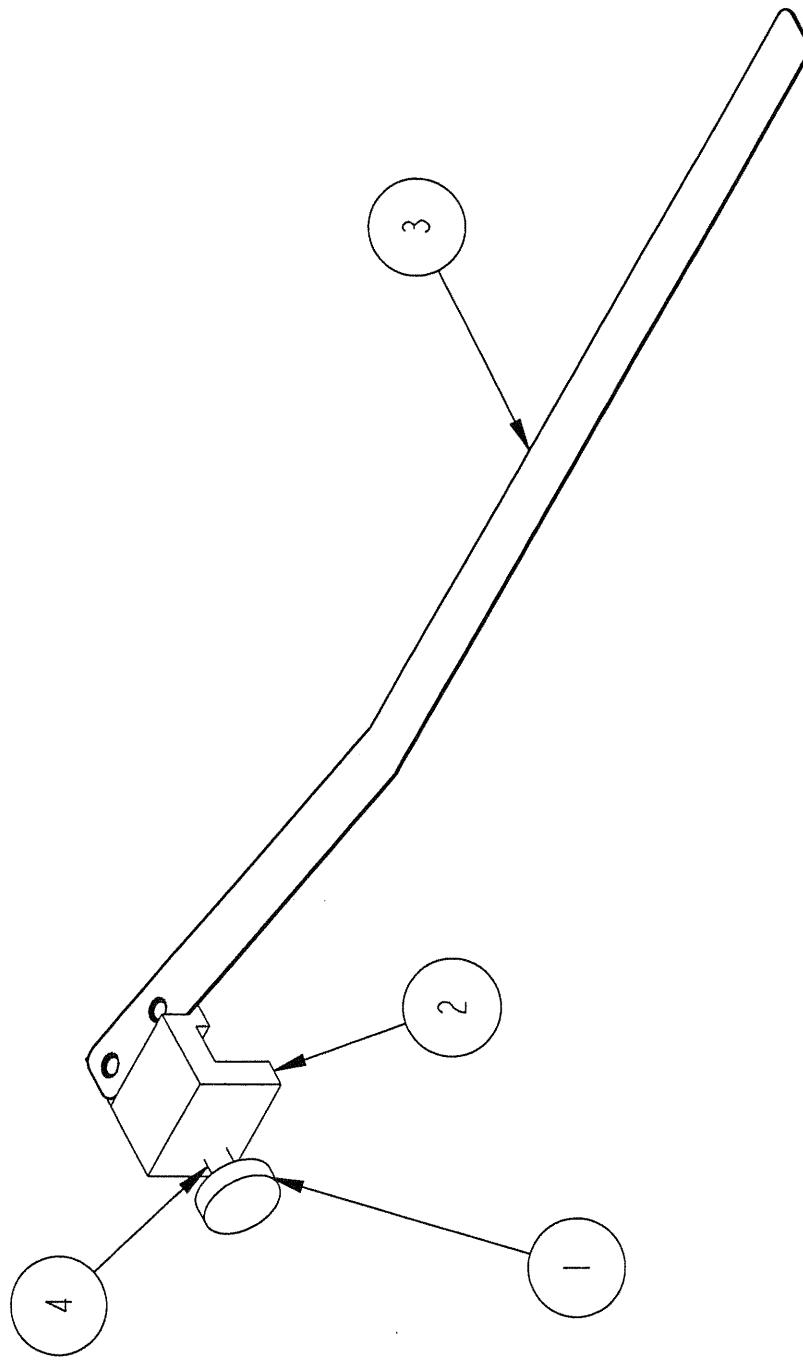
DATE 10-DEC-02

DRAWN BY:

CHECKED BY:

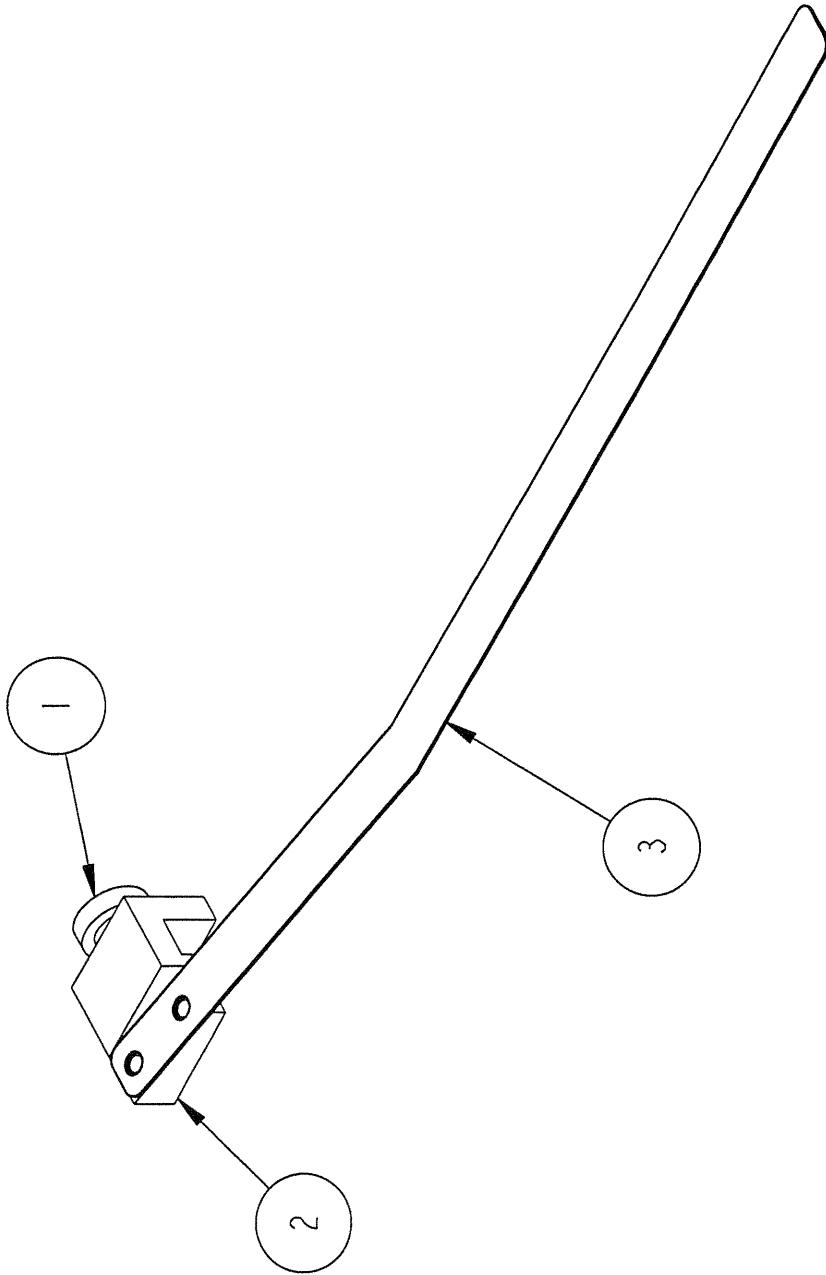
TRACED BY:

ITEM	QTY	PART #	DESCRIPTION
1	1	102132	KNOB, 10-32 CAP SCREW
2	1	537878-01	BLOCK, SPRING STEEL MOUNT
3	1	537883-01	GUIDE, SPRING STEEL PRODUCT
4	1	CSDD265	SCREW, SHCS 10-32X .500



1	535																								
REV'D	WHERE USED																								
<p>DRAWN BY: A KEY SCALE 0 .750 MATERIAL: N / A DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED</p> <table border="1"> <tr> <td>.01</td> <td>.005</td> <td>.005</td> <td>.005</td> <td>.005</td> <td>.005</td> <td>.005</td> <td>.005</td> </tr> <tr> <td>XII</td> <td>XIX</td> <td>XIX</td> <td>XIX</td> <td>XIX</td> <td>XIX</td> <td>XIX</td> <td>XIX</td> </tr> <tr> <td>ANG.</td> <td>ANG.</td> <td>ANG.</td> <td>ANG.</td> <td>ANG.</td> <td>ANG.</td> <td>ANG.</td> <td>ANG.</td> </tr> </table> <p>HEAT TREAT: N / A</p> <p>DATE 23 - Mar - 01</p> <p>CHECKED BY:</p> <p>TRACED BY:</p> <p>MASTER</p> <p>REMOVED ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED</p> <p>ALL DIMENSIONS ARE FINISHED DIMENSIONS</p> <p>DO NOT SCALE - WORK TO DIMENSIONS ONLY</p>		.01	.005	.005	.005	.005	.005	.005	.005	XII	XIX	ANG.													
.01	.005	.005	.005	.005	.005	.005	.005																		
XII	XIX	XIX	XIX	XIX	XIX	XIX	XIX																		
ANG.	ANG.	ANG.	ANG.	ANG.	ANG.	ANG.	ANG.																		
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																								
KIRK - RUDY, INC. KENNESAW, GEORGIA	MODEL: 535																								
TITLE: KIT, SPRING STEEL MOUNT RH	SHEET NO: 10F 1																								
DRAWING #: 537877-01	DRWING #: 8																								

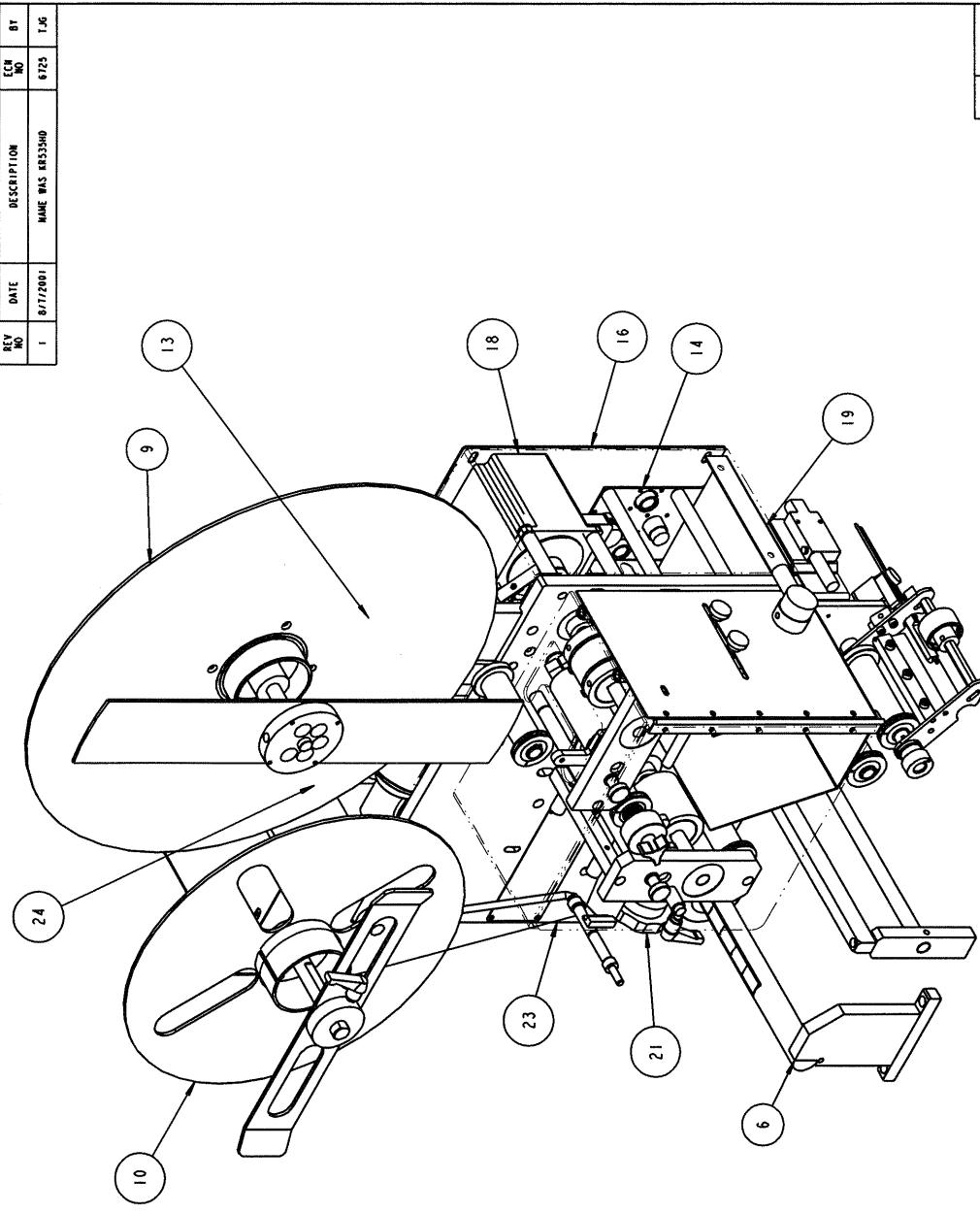
ITEM QTY	PART #	DESCRIPTION
1	102132	KNOB, 10-32 CAP SCREW
2	537878-02	BLOCK, SPRING STEEL MOUNT
3	537883-01	GUIDE, SPRING STEEL PRODUCT
4	CSDD265	SCREW, SHCS 10-32X .500



1	535						
REV NO	RED WHERE USED						
DRAFTING #							
537877-02							
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							
TITLE: KIT, SPRING STEEL MOUNT LH							
SHEET NO:	10F1						
DRAWING #							
537877-02							
DRAWN BY: A KEY	SCALE 0 .750	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED		MATERIAL: N/A	THIRD ANGLE PROJECTION	PROPRIETARY AND CONFIDENTIAL	
DATE 23-Mar-01	.01	.005	.5	HEAT TREAT: N/A	-	NO PORTION OF THIS DRAWING	
CHECKED BY: MASTER	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED		FINISH: N/A		MAY BE QUOTED OR REPRODUCED		
TRACED BY: MASTER	ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE. WORK TO DIMENSIONS ONLY				IN ANY FORM WITHOUT THE		
					EXPRESS WRITTEN PERMISSION		
					OF KIRK-RUDY, INC.		
					KENNESAW, GA 30144 USA		

ITEM	QTY	PART #	DESCRIPTION
1	1	109014	BELT, TIMING 200XL037
2	1	109857	PULLEY, 32XL037 .500B NW
3	1	109990	PULLEY, TIMING 201050 .500B NW
4	1	200613	MOTOR, AC 1/120 HP
5	1	108909-5	BELT, TIMING 322L050
6	1	536382-04	ASSY-FRAME MOUNT
7	1	536199-02	ASSY, PINCH ROLLER DRIVE
8	1	536138-03	ASSY, PINCH ROLLER UNWIND
9	1	536746-01	ASSY-LABEL ROLL
10	1	536149-02	ASSY, REWIND
11	1	536167-01	ASSY, VERTICAL ADJUSTMENT
12	1	536169-02	ASSY-STRIpper PLATE
13	1	536180-02	COVER-LH
14	1	536184-01	ASSY ELECTRICAL CONNECTION PLAT
15	1	536194-02	PLATE-TAKEUP MOTOR
16	1	536197-02	PLATE-COVER
17	1	536805-01	ASSY MOTOR TAB DRIVE
18	1	536805-02	ASSY, MOTOR UNWIND
19	1	536826-01	COVER-BOTTOM
20	1	536832-19	ASSY, GUIDE ROLLER DRAG
21	1	536851-01	ASSY, FRAME CROSS ADJUSTMENT
22	1	536857-01	ASSY, LABEL TRAY COVER
23	1	537669-01	ASSY, FRAME W/ BEARINGS
24	1	538164-02	COVER, REWIND SHAFT
25	1	538829-01	ASSY, UNWIND CLUTCH

ITEM	QTY	PART #	SCALE	DESCRIPTION
1	1	T JG	0 . 300	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED
			IN.	MM.
			.000	.000
			.005	.005
			.010	.010
			N/A	N/A
			N/A	N/A
			N/A	N/A



ITEM	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	1	6/17/2001	NAME WAS KR535HD	6125	T.G.

I	III
RECD	WHERE USED

<b>KRK</b>		KIRK - RUDY, INC., WOODSTOCK, GEORGIA
		PRINTED IN U.S.A.
		538869-01
		ASSY, KR535HD
		PRINTED IN U.S.A.
		538869-01

ITEM #	PART #	DESCRIPTION	REV NO	DATE	ECN NO	BT
1	109014	BELT, TIMING 200X037				
2	109857	PULLEY, 32XL037 .500B NK				
3	109990	PULLEY, TIMING 201050 .500B NK				
4	1-200613	MOTOR, AC 1/120 HP				
5	1-108309-5	BELT, TIMING 322L050				
6	1-536382-04	ASSY FRAME MOUNT				
7	1-536389-02	ASSY PINCH ROLLER DRIVE				
8	1-536138-03	ASSY PINCH ROLLER UNWIND				
9	1-536746-01	ASSY-LABEL ROLL				
10	1-536149-02	ASSY REWIND				
11	1-536167-01	ASSY VERTICAL ADJUSTMENT				
12	1-536169-02	ASSY-STRIPPER PLATE				
13	1-536180-02	COVER-LH				
14	1-536784-01	ASSY-ELECTRICAL CONNECTION PLAT				
15	1-536194-02	PLATE-TAKEUP MOTOR				
16	1-536679-02	PLATE-COVER				
17	1-536805-01	ASSY MOTOR TAB DRIVE				
18	1-536805-02	ASSY MOTOR UNWIND				
19	1-536822-01	COVER-BOTTOM				
20	1-536832-19	ASSY GUIDE ROLLER DRAG				
21	1-536851-01	ASSY FRAME CROSS ADJUSTMENT				
22	1-536857-01	ASSY LABEL TRAY COVER				
23	1-537669-01	ASSY FRAME W/ BEARINGS				
24	1-538164-02	COVER, REWIND SHAFT				
25	1-538829-01	ASSY UNWIND CLUTCH				

I III  
REC'D WHERE USED

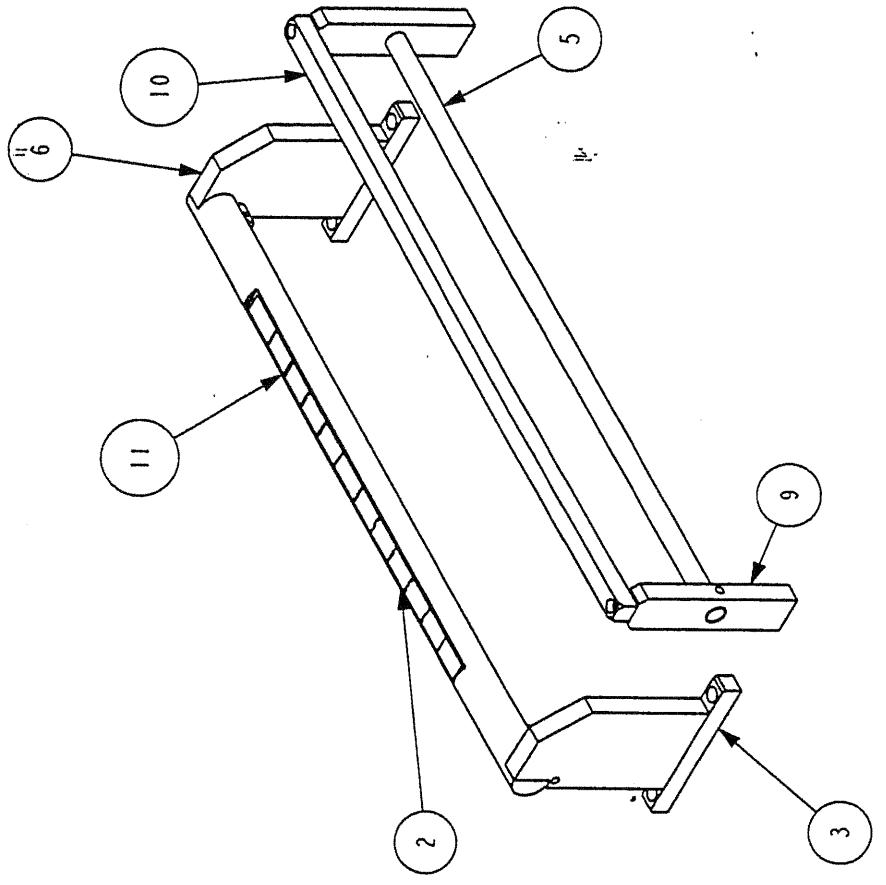
**KR** KIRK-RUDY, INC.  
WOODSTOCK, GEORGIA

ASSY, KR535HD

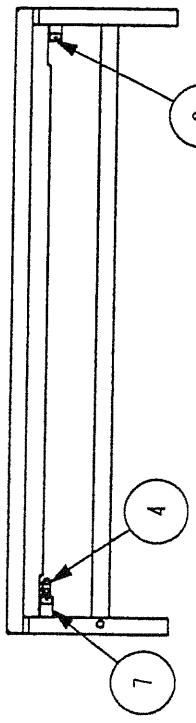
DRAWING 1 538869-01

DRAWING BY:		SCALE	SCALE	DIMENSIONAL TOLERANCES		
				IN.	MM.	UNIT:
T JG		0.200		N/A	N/A	
CHECKED BY:		DATE		.5	.060	IN. MM.
		26-Mar-01		LEWDY, ALL BURRS AND SHARP EDGES UNLESS OTHERWISE SPECIFIED ALL SURFACES ARE FINISHED TO SIZE AND TO NINETEEN HUNDRED THOUSANDS OF AN INCH	N/A	
TRACED BY:		MASTER		N/A	N/A	

ITEM QTY	PART #	DESCRIPTION
1	2	110010 LINK, #25 MASTER
2	1	190838 SCALE
3	2	500794 PLATE-MOUNTING
4	1	110021-16 25 CHAIN
5	1	527687-1 SHAFT, SKID BAR
6	2	536386-03 PLATE-HEAD SUPPORT
7	1	536758-01 STUD-CHAIN
8	1	536758-03 STUD-CHAIN
9	2	536820-01 BAR-POST
10	1	536952-01 BAR-HEAD SUPPORT
11	1	SP18329-4 SHAFT, TABBER HEAD SUPPORT



SCALE 0.188



NOTE:  
1. USE #25 CHAIN X 16.25" LONG

1	KR335HD
REO'D	WHERE USED

**KR** KIRK - RUDY, INC.  
KENNEDY SAW, GEORGIA

DRAWN BY:	SCALE	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. KENNEDY SAW, GA 30144 USA
CHECKED BY:	DATE	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	NOTES:	LINE:
TRACED BY:	MASTER	.01 .015 .005 .005 .005 REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY	NOTED	SP 76300 SHEET NO. 1 OF 1 DRAWING #

536382-04

ITEM QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	102793	SPRING, COMP OD .36 W.03 L.75					
2	2 104100	SNAPRING, .375					
3	4 104106	SNAPRING, .500					
4	1 104107	SNAPRING, .250					
5	1 190839	MAGNET, BUNTING					
6	1 532785-01	ASSY, SPRING CLIP					
7	1 536037-01	PLATE-RELEASE					
8	1 536044-01	KNOB-LOCKING					
9	1 536320-02	ASSY, ROLLER DRIVE					
10	1 536329-01	SHAFT, SPACER					
11	1 536400-01	ASSY-BEARING PLATE					
12	1 536801-01	BAR-SPACER,BEARING PLATE					
13	1 536804-01	SHAFT-DRIVE					
14	1 536833-01	ROLLER, WEB					
15	1 536958-01	SPACER-MAGNET					
16	1 537667-01	ASSY, NIP ROLLER					
17	1 537668-01	ASSY, ECCENTRIC SHAFT W/PIN					
18	1 538101-01	DISK, TAB GUIDE					
19	2 539684-01	SPACER, TABLETOP					
20	1 CSDD213	SCREW, SHCS 6-32X.875					
21	1 HMSN08	NUT, HEX #6-32					

SCALE 0.250

SCALE 0.250

SCALE 0.250

1.000 KRS35HD  
REO'D WHERE USED

1.000 KRS35HD  
REO'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 3044 USA

KRK KIRK - RUDY INC.  
KENNESAW, GEORGIA

5355 5355  
SHEET NO. 10F1 DRAWING I

536399-02

DRAWN BY: TVK	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 3044 USA
DATE 22-0C+99	.xx .01 .005 .5	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED			HEAT TREAT: XXX		
CHECKED BY:				FINISH:	XXX	MODEL: 5355	TITLE: ASSY, PINCH ROLLER DRIVE
TRACED BY:	MASTER	ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY					

ITEM	QTY	PART #	DESCRIPTION
1	1	536312-02	ROLLER-CORE
2	1	536313-02	ROLLER-CORE, KEYED
3	1	536397-02	COATING, URETHANE DUR60

REV NO	DATE	DESCRIPTION	ECN NO	BY

NOTE:  
1. DUROMETER 60

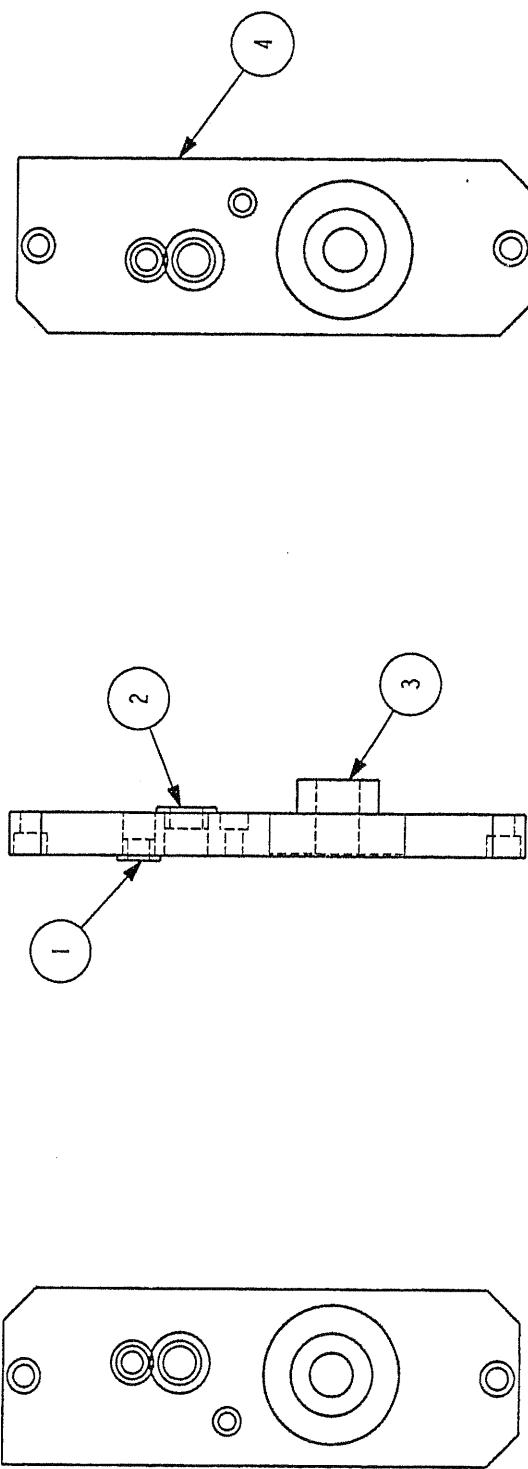
SCALE 0.500

2	535
REQ'D	WHERE USED

ITEM QTY	PART #	DESCRIPTION
1	100309	BUSHING, FL. 250ID.375OD.250LG
2	100330	BUSHING, FL. 375ID.500OD.250LG
3	103803	BEARING, HUB .500
4	1 536732-01	BAR-BEARING, DRIVE

REV NO	DATE	DESCRIPTION	ECN NO	BY

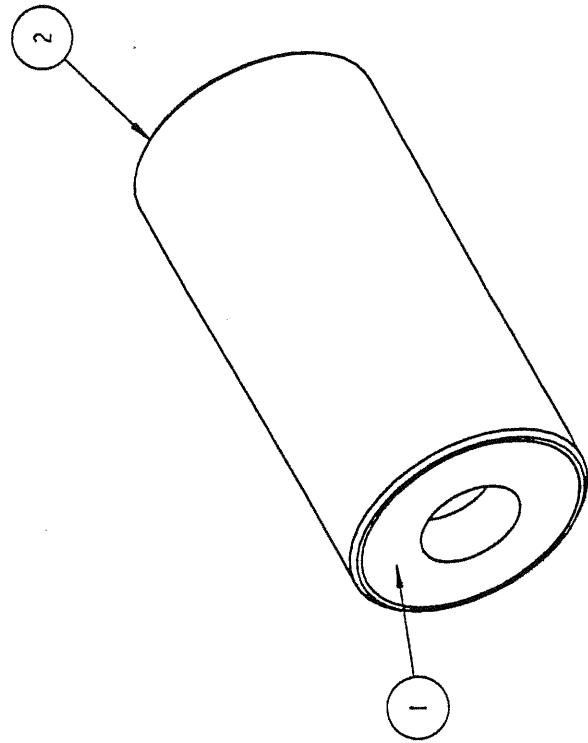
1	SP16300
REO'D	WHERE USED
KRK	KRK - RUDY, INC.
	KENNESSAW, GEORGIA
	ASSY-BEARING PLATE
	DRAWING ■
SHEET NO. 1 OF 1	DRAWING ■
	536400-01



DRAWN BY:	TVK	SCALE:	0 . 500	MATERIAL:	X X X	THIRD ANGLE PROJECTION:	NO	PROPRIETARY AND CONFIDENTIAL
DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	.01	.005	.005	HEAT TREAT:	X X X			NO PORTION OF THIS DRAWING MAY BE COPIED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KRK-RUDY, INC. KENNESAW, GA 30044 USA
DATE:	3 - Aug - 99	REMOVED ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED		FINISH:	X X X	NOTE:	SP76300	TIME:
TRACED BY:	MASTER M	ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE WORK TO DIMENSIONS ONLY		FINISH:	X X X			

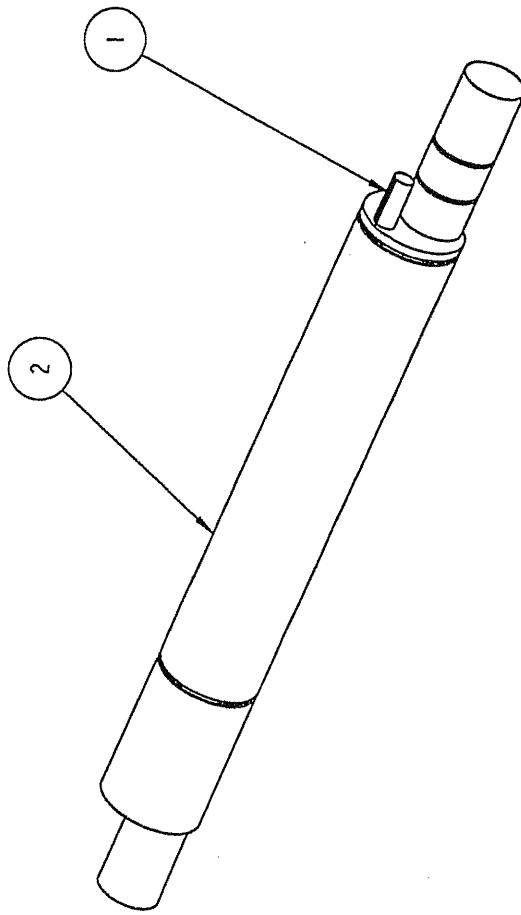
ITEM / QTY	PART #	DESCRIPTION
1	2	103110 BEARING, FLAT .625
2	1	536040-02 ROLLER, UNWIND PINCH

REV NO	DATE	DESCRIPTION	ECN NO	BT



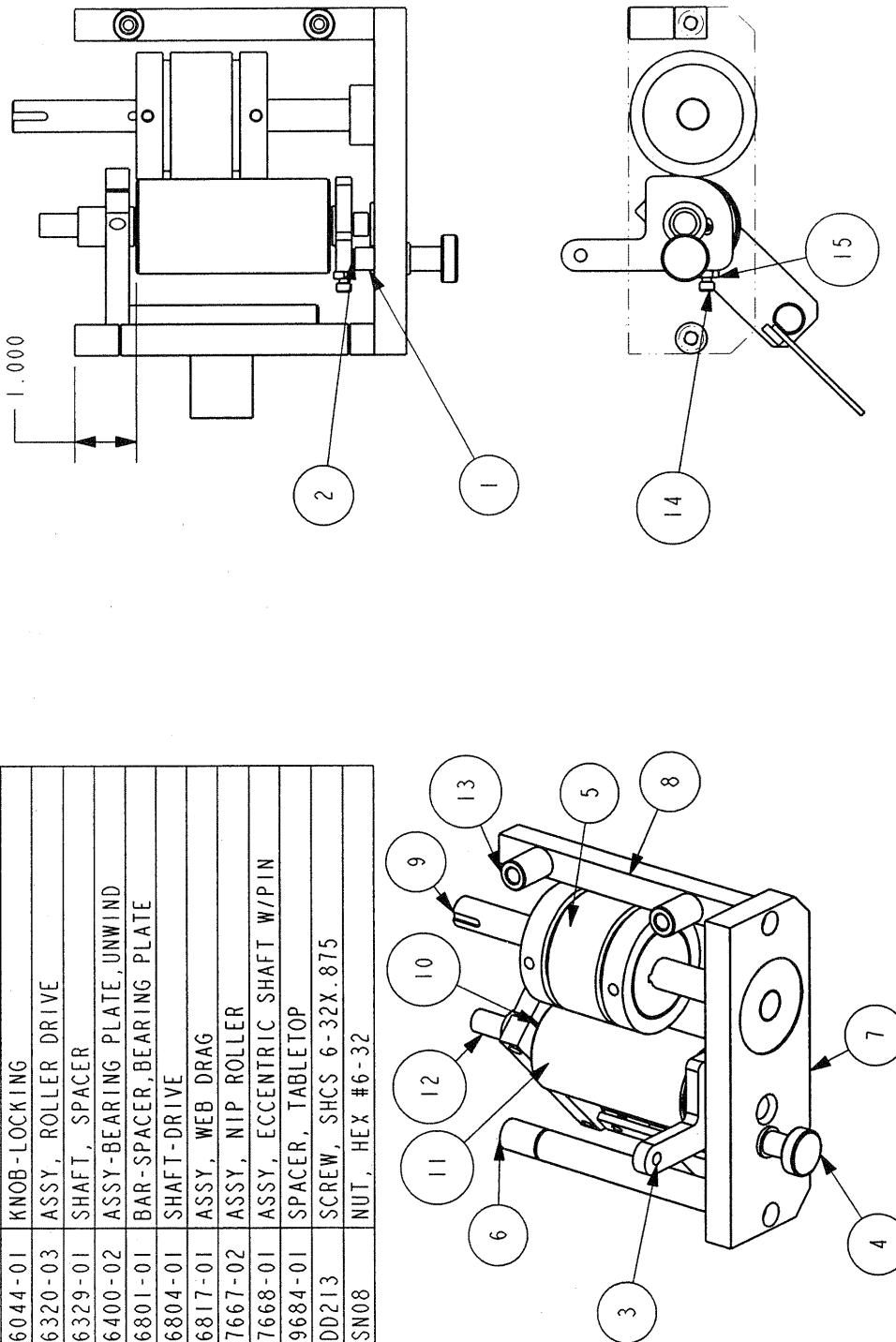
2	MRS5550D
RECD	WHERE USED
<b>KR</b>	KIRK - RUDY, INC. KENNESAW, GEORGIA
NOTE:	ASSY, NIP ROLLER
DATE:	28-Dec-99
MASTER:	M
SCALE:	.000
DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	
.01	.005
ANG.	.5
MATERIAL: XXX	
FINISH: REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED	
ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE WORK TO DIMENSIONS ONLY	
SHEET #:	1 OF 1
DRAWING #:	537667-02

ITEM QTY	PART #	DESCRIPTION
1	105210	PIN, ROLL - 125X.750
2	536328-01	SHAFT-ECCENTRIC



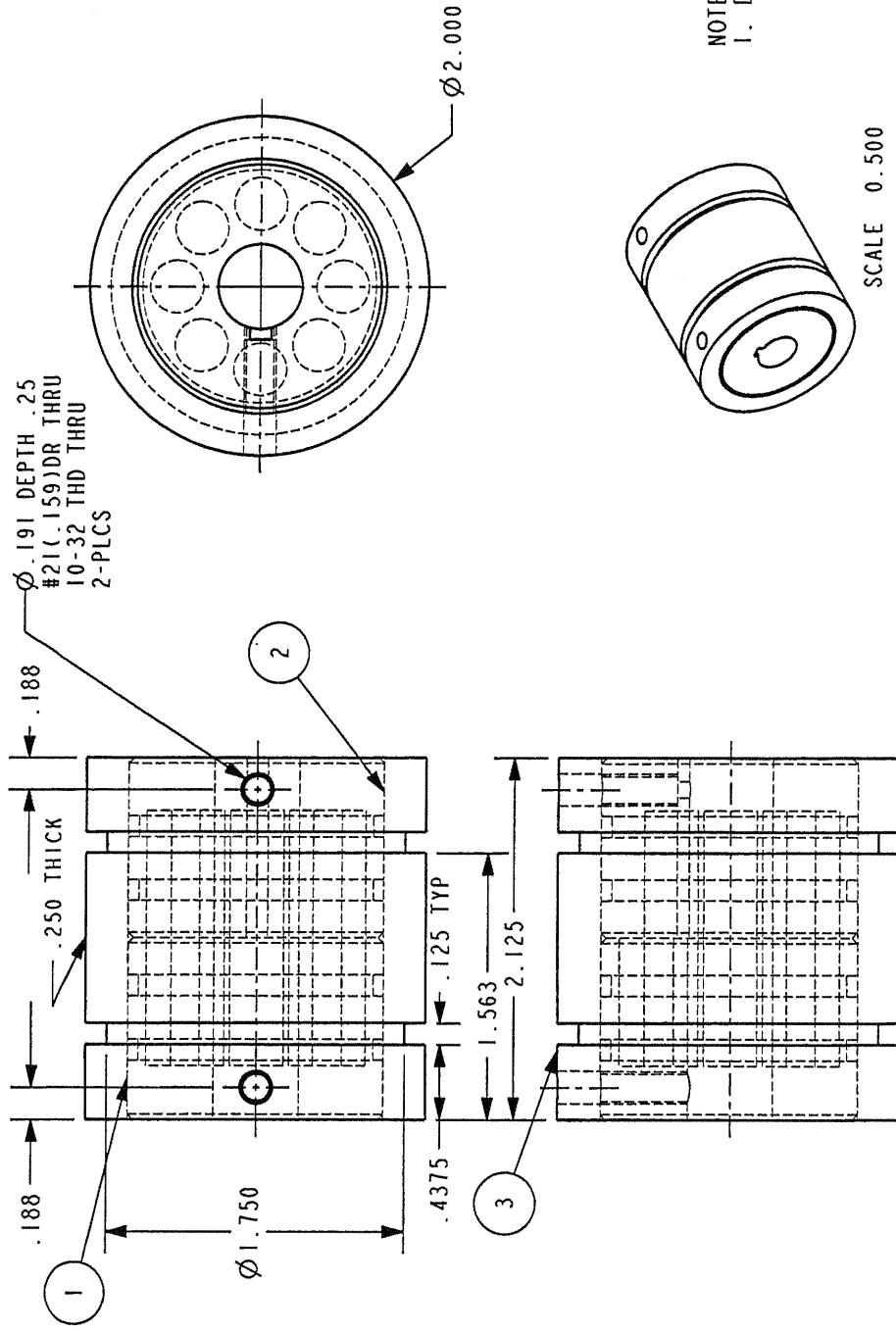
DRAWN BY:	T JG	SCALE	1 . 000	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED		MATERIAL:	XXX	THIRD ANGLE PROJECTION	PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE QUOTED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC. KENNESAW, GEORGIA	
CHECKED BY:	DATE	.XX	.XX	AMT.	.01	HEAT TREAT:	XXX	MODEL:	535	FILE NO.:
TRACED BY:	MASTERED	01 - Nov - 99	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED		ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY		SHEET NO.:	10F1	DRAVING NO.:	537668-01
KIRK - RUDY, INC. KENNESAW, GEORGIA										2 KRS35HD REV'D WHERE USED

ITEM QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	102793	SPRING, COMP OD. 36 W.03 L.75	1	10/10/2000	MODIFIED FOR WIRE STRIPPER ADDED WIRE GROOVES TO ROLLER	6596	TJG
2	104107	SNAPRING, .250					
3	536037-01	PLATE-RELEASE					
4	536044-01	KNOB-LOCKING					
5	536320-03	ASSY, ROLLER DRIVE					
6	536329-01	SHAFT, SPACER					
7	536400-02	ASSY-BEARING PLATE, UNWIND					
8	536801-01	BAR-SPACER, BEARING PLATE					
9	536804-01	SHAFT-DRIVE					
10	536817-01	ASSY, WEB DRAG					
11	537667-02	ASSY, NIP ROLLER					
12	537668-01	ASSY, ECCENTRIC SHAFT W/PIN					
13	2	539684-01	SPACER, TABLETOP				
14	1	CSDD213	SCREW, SHCS 6-32X.875				
15	1	HMSN08	NUT, HEX #6-32				



DRAWN BY: TVK	SCALE 0 . 375	MATERIAL: DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	X X X	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
CHECKED BY:	DATE 22-0C1-99	.XX .XXX .01 .005 .5	X X X	HEAT TREAT:
TRACED BY:	MASTER M	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED	X X X	MODEL: 535
		ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY		SHEET NO.: 1 OF 1
				DRAWING I 536738-03

ITEM	QTY	PART #	DESCRIPTION
1	1	536312-02	ROLLER-CORE
2	1	536313-02	ROLLER-CORE, KEYED
3	1	536397-02	COATING, URETHANE DURGO



NOTE:  
1. DUROMETER 60

SCALE 0.500

REQ'D	WHERE USED
I	536738-03

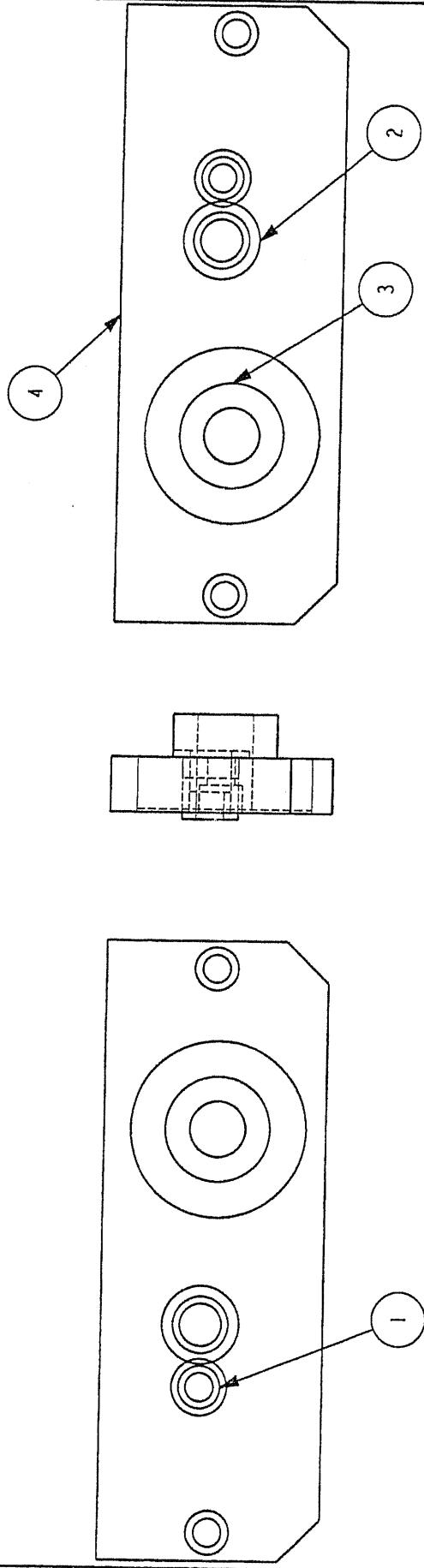


KIRK - RUDY INC.  
KENNEDY SAW, GEORGIA

PROPRIETARY AND CONFIDENTIAL		THIRD ANGLE PROJECTION	PROPRIETARY AND CONFIDENTIAL MAY BE QUOTED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC. KENNEDY, GA 30144 USA
DATE	REV.		
19-MAY-00	.000	MATERIAL: XXX	
		DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	
		.01 .005 .5	AMG.
		REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED	HEAT TREAT: XXX
		ALL DIMENSIONS ARE FINISHED DIMENSIONS	FINISH: XXX
		DO NOT SCALE - WORK TO DIMENSIONS ONLY	

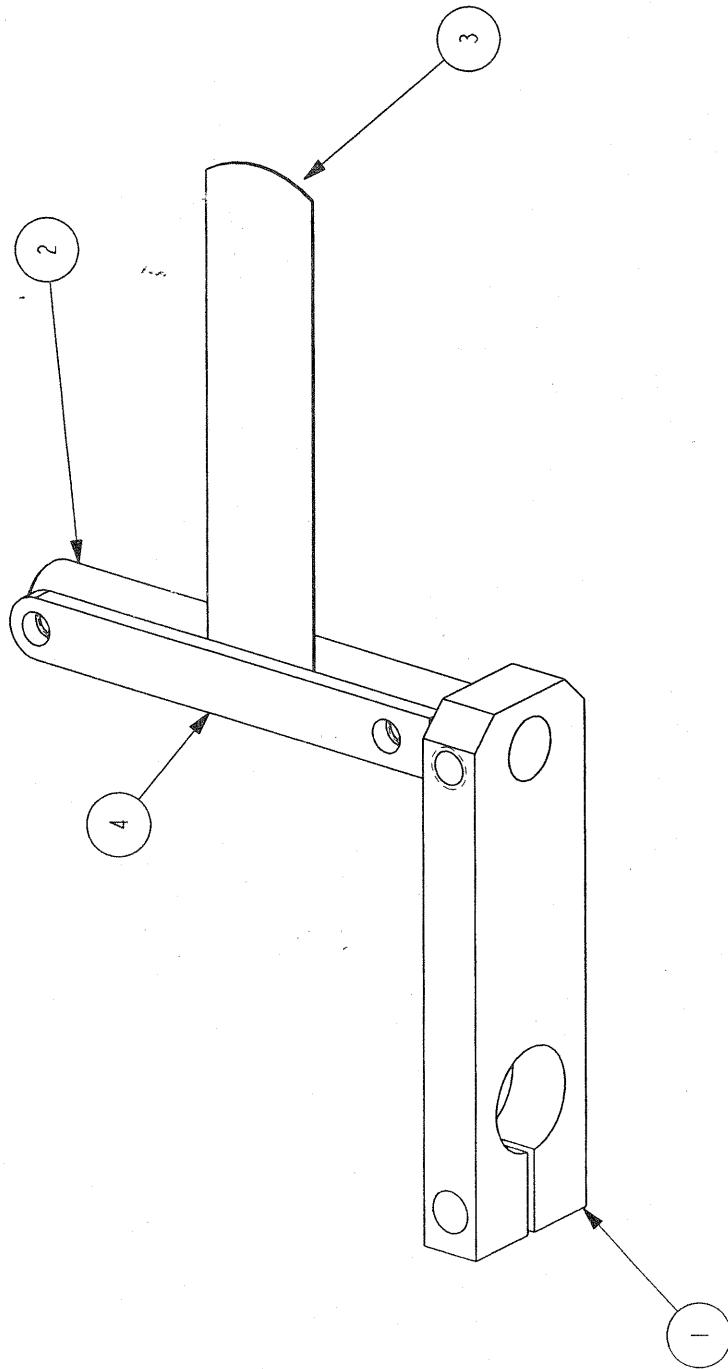
DRAWN BY:	SCALE	DATE	CHECKED BY:	TRACED BY:	NOTE:
T JG	1 .000	19-MAY-00			

ITEM QTY	PART #	DESCRIPTION
1	100309	BUSHING, FL. 250ID. 375OD. 250LG
2	100330	BUSHING, FL. 375ID. 500OD. 250LG
3	103803	BEARING, HUB .500
4	536732-02	PLATE-BEARING, UNWIND



1	SP76300
RECD	WHERE USED
 KIRK - RUDY, INC. KENNESAW, GEORGIA	
<small>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</small>	
DATE:	THIRD ANGLE PROJECTION
13 - Aug - 99	
CHECKED BY:	MATERIAL:
	XXX
	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED
	.XX .XXX .005 .5
	HEAT TREAT:
MASTER:	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED
TRACED BY:	ALL DIMENSIONS ARE FINISHED DIMENSIONS
	DO NOT SCALE - WORK TO DIMENSIONS ONLY
NOTE: SP76300	
SHEET NO.	10F1
DRAWING # 536400-02	

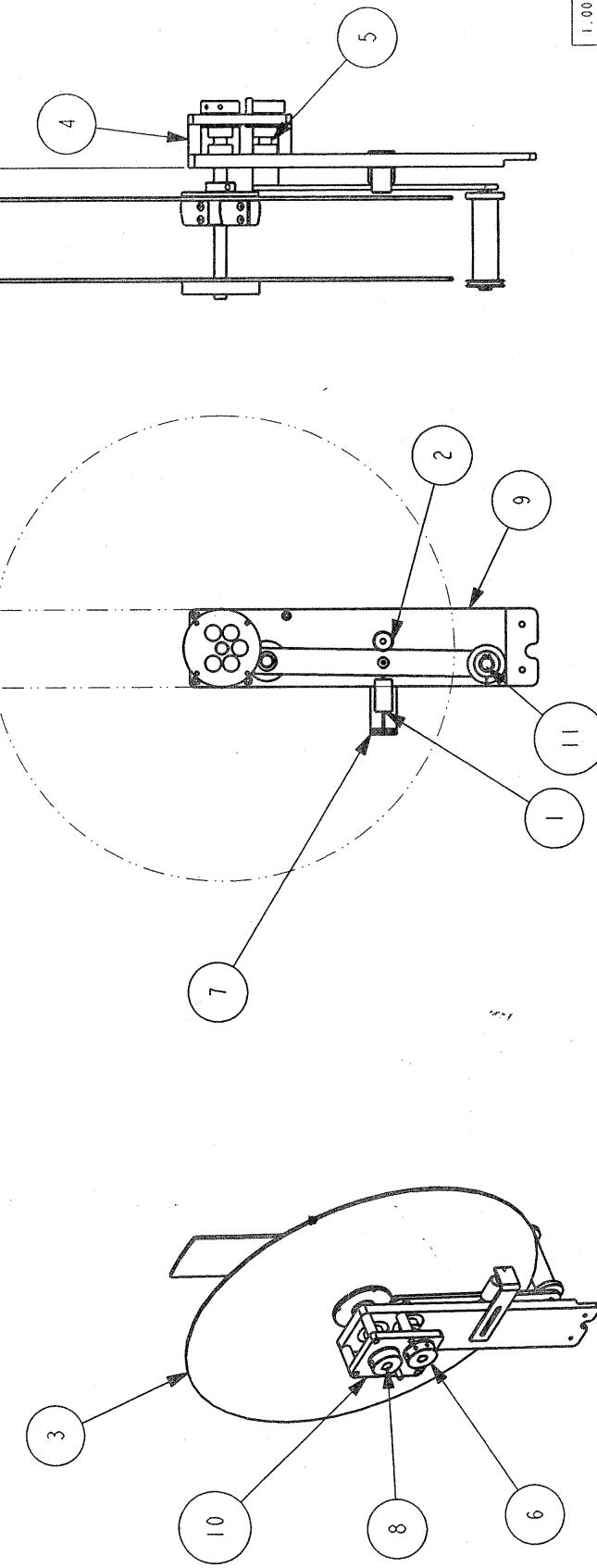
ITEM QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	1	536814-01 CLAMP-BELT MOUNT					
2	1	536815-01 BAR, BRUSH MOUNT					
3	1	536818-01 DRAG, SPRING STEEL					
4	1	536824-01 BAR-CLAMP, BRUSH					



DRAWN BY: TVK	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. KENNESAW, GA 30144 USA
DATE 03-NOV-03	.xx	.xxx	.005	.5	HEAT TREAT: N / A	MODEL: SP76300	KIRK - RUDY, INC. KENNESAW, GEORGIA
CHECKED BY:	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED			FINISH: N / A	TITLE: ASSY , WEB DRAG		
TRACED BY: MASTER 	ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY			SHEET NO.: 10F1	DRAWING #: 536817-01		

ITEM QTY	PART #	DESCRIPTION
1	1 02775	SPRING, EXT EO 500-055-1750M
2	527653	SHAFT, ARM SUPPORT
3	536763-01	ASSY, UNWIND WHEEL
4	4 536764-01	STUD-SPACER, BRAKE PLATE
5	1 536809-01	SHAFT-BRAKE
6	2 536811-01	HUB-BRAKE
7	1 536812-01	ANGLE-SPRING
8	1 536813-01	SHAFT-CORE
9	1 537670-01	ASSY, UNWIND SUPPORT BAR
10	1 537671-01	ASSY, UNWIND BRG PLATE
11	1 537674-01	ASSY, SWING ARM BRAKE

1.25



1.000 KRS35HD  
REOD WHERE USED

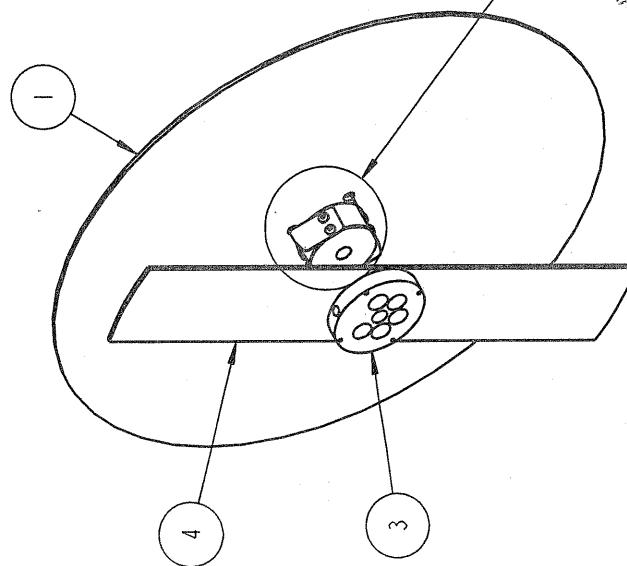
KIRK - RUDY INC.  
KENNEDY, GEORGIA

SP76300  
DRAFTING #

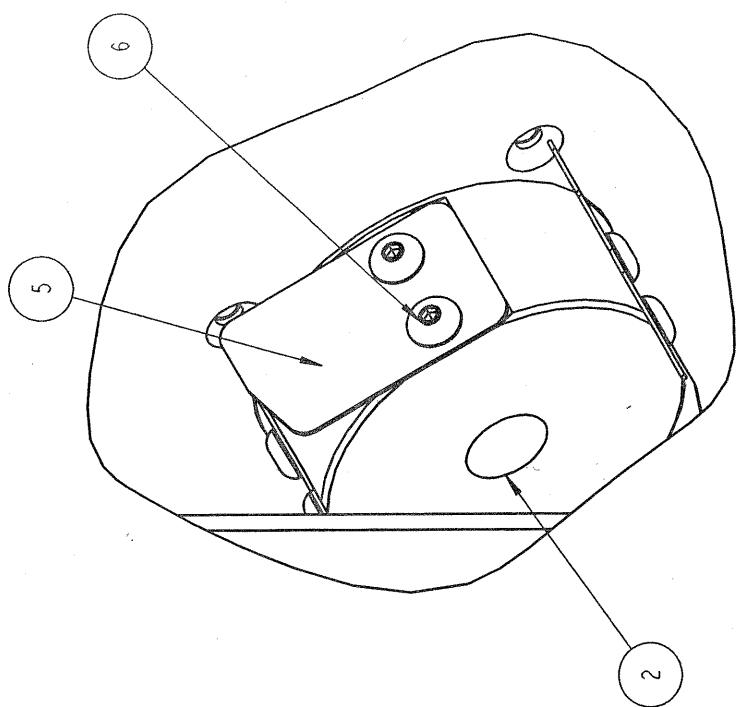
SCALE 0.125

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.	
CHECKED BY:		DATE	.XX	.XXX	ANG.				
		22-0ct-99	.01	.005	.5	HEAT TREAT:	N/A		
TRACED BY:		MASTER	REMOVE ALL BOARS AND SHARP EDGES UNLESS OTHERWISE NOTED			FINISH:	N/A		
			ALL DIMENSIONS ARE FLUSHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY						
			M			SHEET NO. 1 OF 1			
			ASSY-LABEL ROLL						
			536746-01						

ITEM QTY	PART #	DESCRIPTION
1	527651-12	DISK, LABEL UNWIND
2	536352-10	HUB, UNWIND REEL
3	536353-01	HUB-REEL
4	536354-01	PLATE-UNWIND
5	548325-01	CLIP, UNWIND REEL
6	CSFF51	SCREW, BUTTON HEAD #8-32X.250



SEE DETAIL A

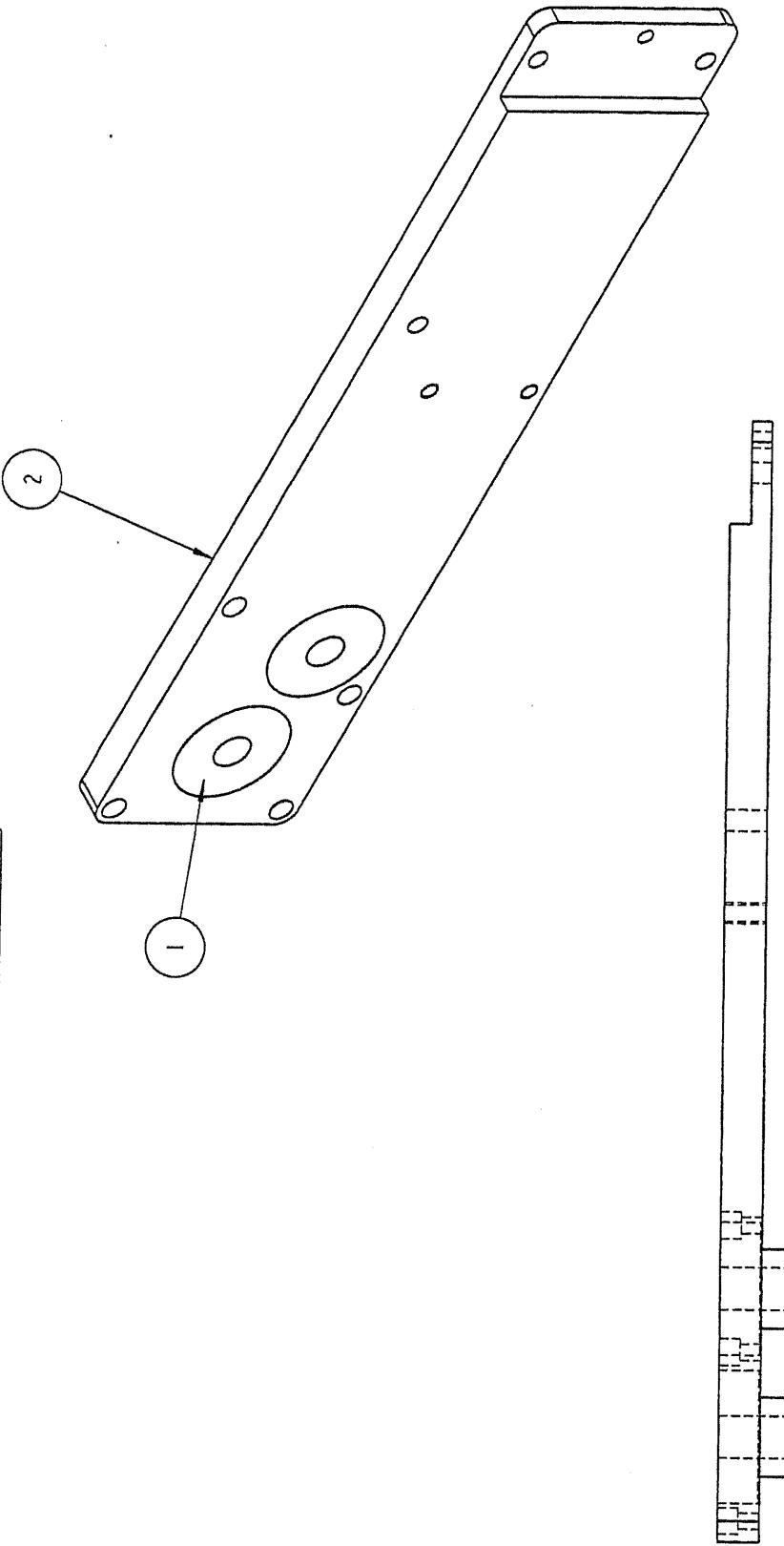
DETAIL  
SCALE 1.000

REV NO	DATE	DESCRIPTION	ECN NO	BY

1	KR535
RECD	WHERE USED

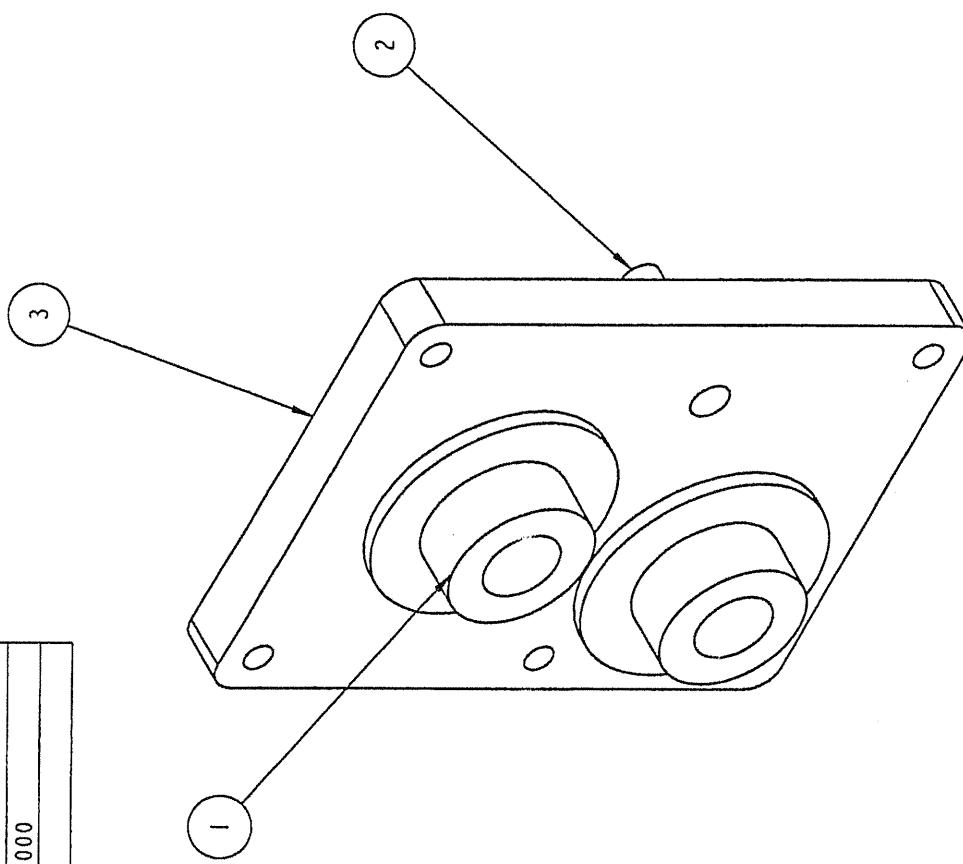
DRAWN BY: T JG	SCALE: 0.188	MATERIAL: N/A	THIRD ANGLE PROJECTION	PROPRIETARY AND CONFIDENTIAL
CHECKED BY:	DATE: 05-Nov-04	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED .01 .005 .5	HEAT TREAT: N/A	NO PORTION OF THIS DRAWING MAY BE QUOTED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC. KENNESAW, GA 30144 USA
TRACED BY: <i>M</i>	MASTER:	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY	FINISH: N/A	MODEL: SA317
			SHEET NO. 1 OF 1	TITLE: ASSY, UNWIND WHEEL
				DRAWING #: 536763-01

ITEM QTY	PART #	DESCRIPTION
1 2	103803	BEARING, HUB .500
2 1	536741-01	PLATE-REEL



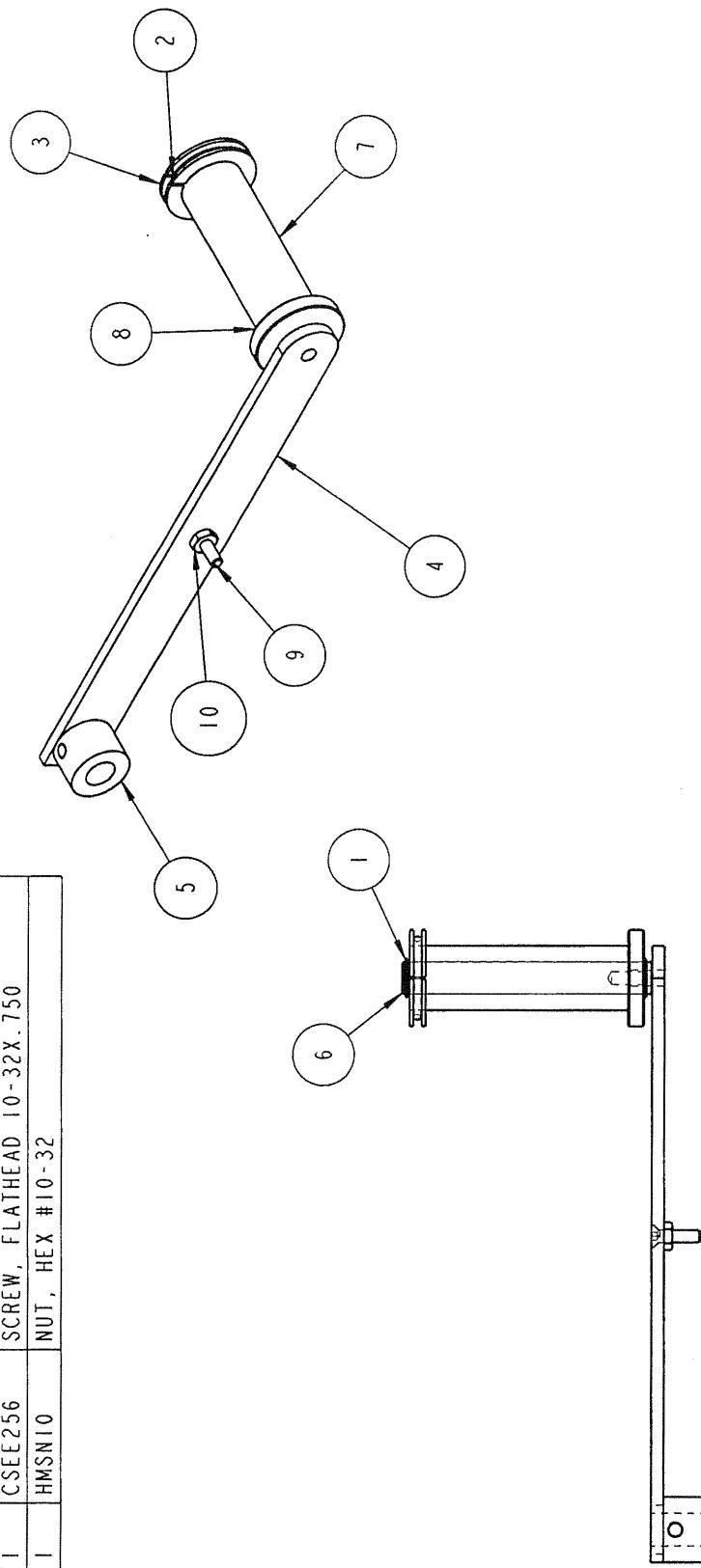
DRAWN BY:	T JG	SCALE	0 . 500	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	MATERIAL: XXX	THIRD ANGLE PROJECTION	PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE QUOTED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC. KENNESAW, GA 30141 USA
CHECKED BY:	DATE	.xx	.xx	.01 .005 .5	HEAT TREAT: XXX	MODEL: 535	NAME: 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				SHEET NO. 1 OF 1	DRAWING # 537670-01

ITEM	QTY	PART #	DESCRIPTION
1	2	103803	BEARING, HUB .500
2	1	105401	DOWEL, PIN .250X1.000
3	1	536762-01	PLATE-REEL



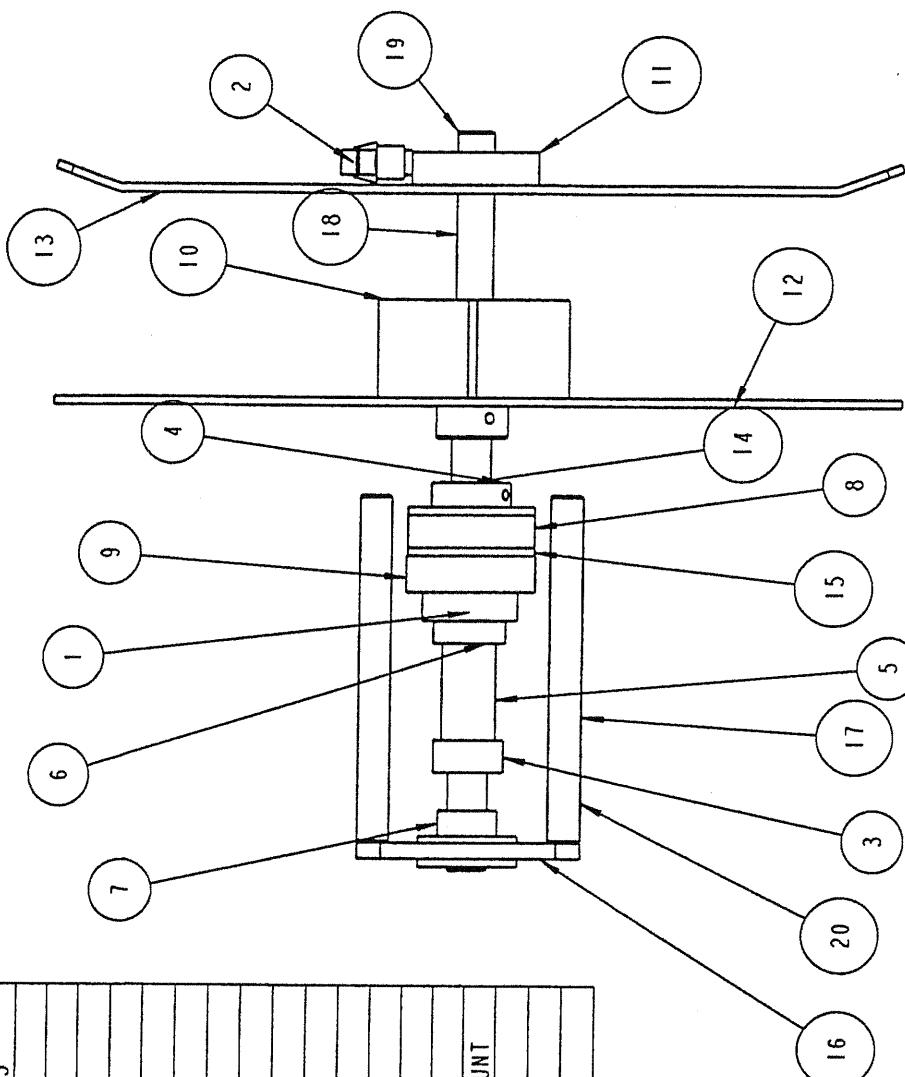
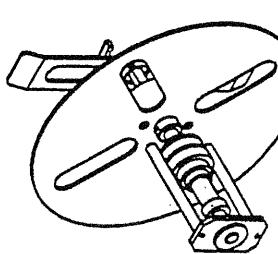
DRAWN BY:	SCALE	1 . 000	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED		MATERIAL:	XXX	THIRD ANGLE PROJECTION	PROPRIETARY AND CONFIDENTIAL NO DUPLICATION OR REPRODUCTION MADE IN ANY FORM WITHOUT EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, KENNESAW, GEORGIA	
CHECKED BY:	DATE	01 - Nov - 99	.01	.005	ANG.	.5	HEAT TREAT:	XXX	KIRK - RUDY, INC. KENNESAW, GA 30144 USA
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					MODEL:	535
								TITLE:	ASSY, UNWIND BRG PLATE
								SHEET NO.	OF 1
								DRAWING #	537671-01

ITEM	TYPE	QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECON NO	BY
1	PART	2	104106	SNAPRING, .500	1	7/21/2001	REPLACED EXT. SPRING WITH O-RING	6713	TJG
2	PART	1	190895	O-RING, 1.125 X 1.312 X .093					
3	PART	1	525205	GUIDE, RING					
4	PART	1	536807-01	BAR-SWING					
5	PART	1	536808-01	HUB-SWING ARM					
6	PART	1	536831-01	SHAFT, WEB UNWIND					
7	PART	1	536833-01	ROLLER, WEB					
8	PART	1	538101-01	DISK, TAB GUIDE					
9	PART	1	CSEE256	SCREW, FLATHEAD 10-32X.750					
10	PART	1	HMSN10	NUT, HEX #10-32					



I	KR535HD						
REQ'D	WHERE USED						
 KIRK - RUDY, INC. KENNESAW, GEORGIA							
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							
TITLE: ASSY, SWING ARM BRAKE							
DRAWING # 537674-01							
THIRD ANGLE PROJECTION							
							
MATERIAL: XXX							
DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED							
<table border="1" style="margin-left: auto; margin-right: auto;"> <tr> <td>.XX</td> <td>.XXX</td> <td>ANG.</td> </tr> <tr> <td>.01</td> <td>.005</td> <td>.5</td> </tr> </table>		.XX	.XXX	ANG.	.01	.005	.5
.XX	.XXX	ANG.					
.01	.005	.5					
HEAT TREAT:							
FINISH:							
REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED							
ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY							
DRAWN BY: <b>TJG</b>	SCALE: 0 .375						
CHECKED BY:	DATE: 01 - Nov - 99						
TRACED BY:	MASTER: <b>M</b>						
SHEET NO: 10F1	MODEL: 535						

ITEM QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	1 100145	BUSHING, SL. 6251D.813001.000LG					
2	1 102140	HANDLE, RELEASE 1/4-20 X .75					
3	1 102203	COLLAR .625					
4	2 102564	SHIM, .625X1.000X.010					
5	1 102722	SPRING, COMPRESSION					
6	1 103211	BEARING, BALL THRUST .625					
7	1 103804	BEARING, HUB .625					
8	1 190120	DISC, F3 FELT					
9	1 108772-1	PULLEY, 32XL037					
10	1 527610-2	ROLLER, TAKE UP					
11	1 527625-3	HUB, ROLL					
12	1 527651-4	RING, RETAINING					
13	1 527651-5	RING, RETAINING					
14	1 527695-1	HUB, TAKEUP					
15	1 527697-1	DISC, TAKEUP					
16	1 536795-01	PLATE-BEARING					
17	2 536802-01	BAR-ROUND, BEARING PLATE MOUNT					
18	1 536803-01	SHAFT, TAKE-UP					
19	1 536959-01	ASSY-SLIP CLUTCH					
20	1 537673-01	ASSY, REWIND BRG SUPPORT					

DRAWN BY:	JG	SCALE:	0 .125	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
CHECKED BY:		DATE:	22-0c†-99	.01 .005 .5	HEAT TREAT:	N/A		
TRACED BY:		MASTER:	<b>M</b>	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED	FINISH:	N/A	535	DRWING #:
				ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY				10F 1

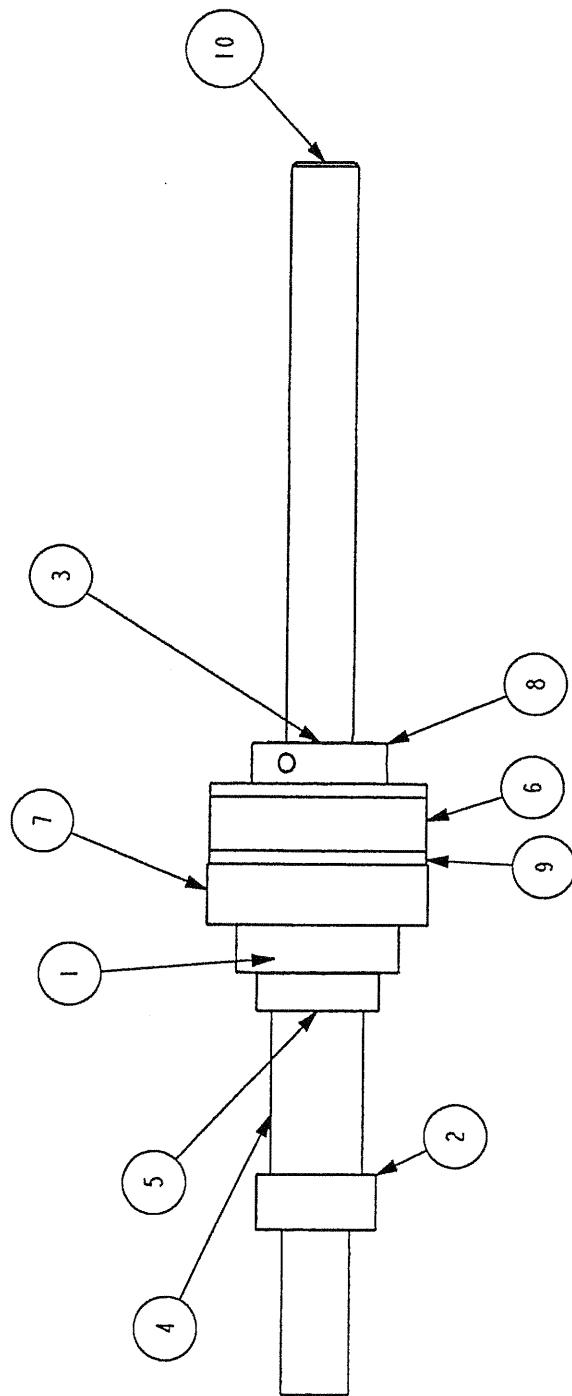
1	KR535RD
REQ'D	WHERE USED

ASSY, REWIND

536749-02

ITEM	QTY	PART #	DESCRIPTION
1	1	100145	BUSHING, SL. 62510D1.000LG
2	1	102203	COLLAR .625
3	2	102564	SHIM, .625X1.000X.010
4	1	102722	SPRING, COMPRESSION
5	1	103211	BEARING, BALL THRUST .625
6	1	190120	DISC, F3 FELT
7	1	108772-1	PULLEY, 32XL0371
8	1	521695-1	HUB, TAKEUP
9	1	521697-1	DISC, TAKEUP
10	1	536803-01	SHAFT, TAKE-UP

SCALE 0.375



DRAWN BY:	SCALE	DATE	MASTER	RECD	WHERE USED
TVK	0 .625	24 - Sep - 99	M	SP16300	KIRK - RUDY, INC.
CHECKED BY:					KENNESAW, GEORGIA
TRACED BY:					

DIMENSIONAL TOLERANCES  
UNLESS OTHERWISE NOTED

.00	.015	.005	.005	.005
-----	------	------	------	------

REMOVE ALL BURRS AND  
SHARP EDGES UNLESS  
OTHERWISE NOTED

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

PROPRIETARY AND CONFIDENTIAL  
NO PORTION OF THIS DRAWING  
MAY BE COPIED OR REPRODUCED  
IN WHOLE OR IN PART  
EXCEPT WRITTEN PERMISSION  
OF KIRK RUDY, INC.  
KENNESAW, GA 30141 USA

3RD ANGLE PROJECTION

HEAT TREAT:

MODEL: 535

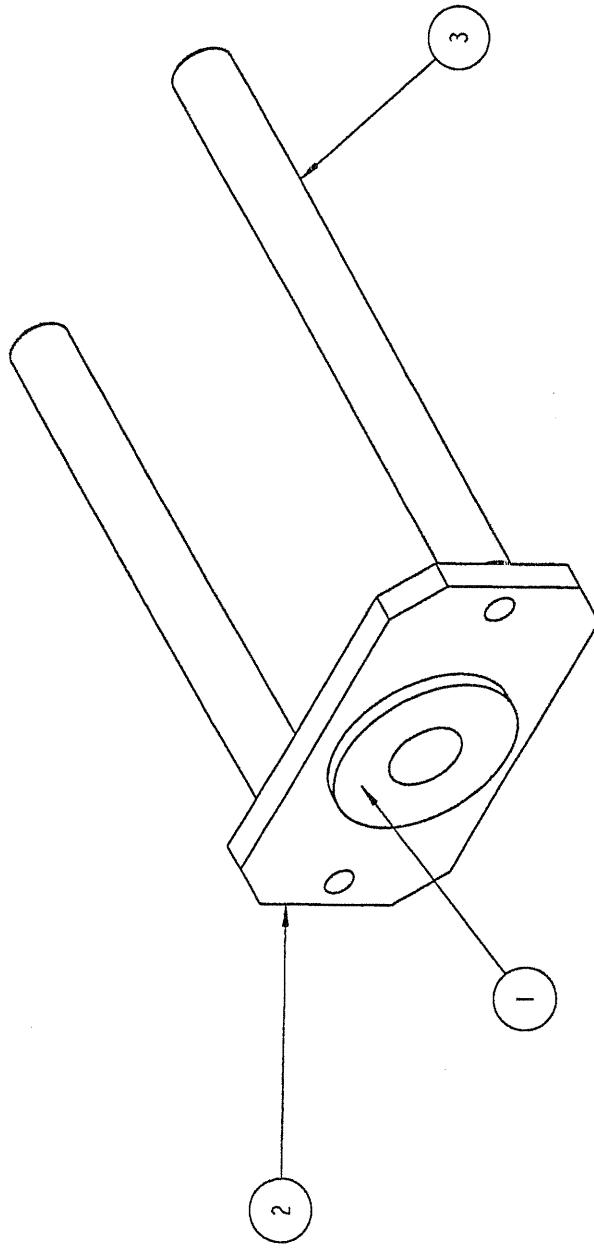
DATE:

ASSY - SLIP CLUTCH

SHEET NO: 1 OF 1

DRAWING #: 536959-01

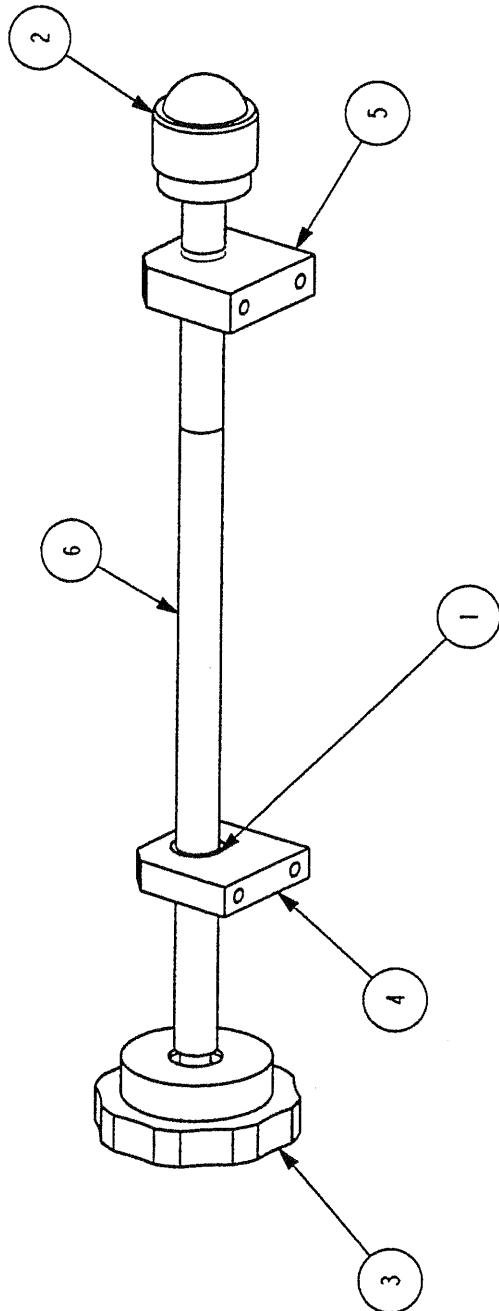
ITEM	QTY	PART #	DESCRIPTION
1	1	103804	BEARING, HUB .625
2	1	536795-01	PLATE-BEARING
3	2	536802-01	BAR-ROUND, BEARING PLATE MOUNT



DRAWN BY:	T JG	SCALE	0 .750	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. KENNEDY SAW, GA 30144, USA	
CHECKED BY:	DATE	.xx	.xx	ANG.	.01	.005	.5	MEAT TREAT: XXX
TRACED BY:	MASTER	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED				NOTE: 535		
		ALL DIMENSIONS ARE FINISHED DIMENSIONS				SHEET NO.: 10F1	DRAWING #: 537673-01	
		DO NOT SCALE - WORK TO DIMENSIONS ONLY						

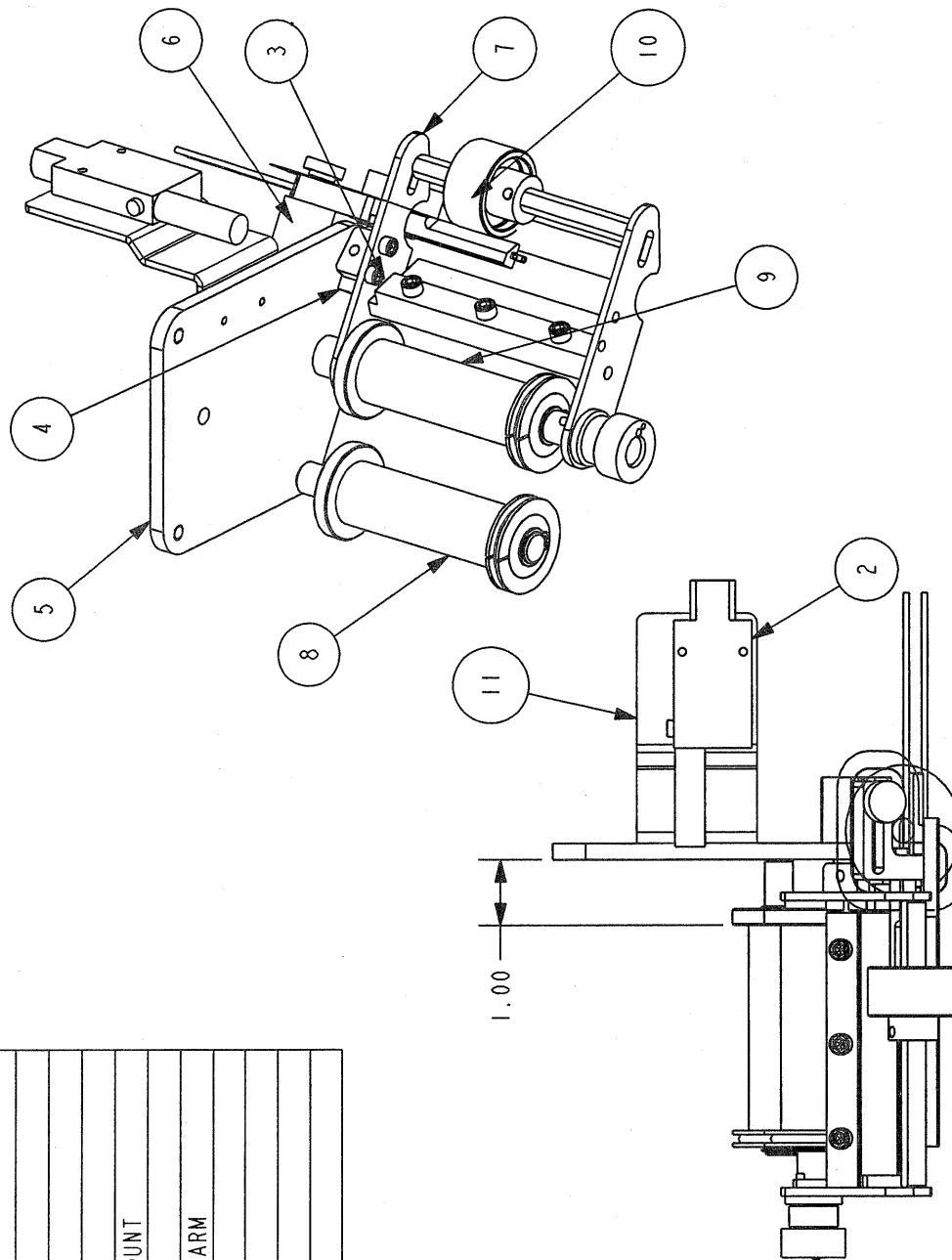
KIRK - RUDY, INC.  
KENNEDY SAW, GEORGIA

ITEM QTY	PART #	DESCRIPTION
1	1	100133 BUSHING, SL.5001D.6250D.375LG
2	1	103955 BALL TRANSFER
3	1	500772 KNOB
4	1	536796-01 PLATE-BUSHING
5	1	536796-02 PLATE-THREADED ADJUSTMENT
6	1	536822-01 SHAFT-VERT. ADJ



1. 000	KRS35SHD		
REC'D	WHERE USED		
<b>KRK KIRK - RUDY, INC. KENNESAW, GEORGIA</b>			
PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE QUOTED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KRK - RUDY, INC. KENNESAW, GA 30044 USA			
NOTE:	ASSY, VERTICAL ADJUSTMENT		
DATE:	SP76300		
SERIALIZED	10F1		
DRAWN BY:	MASTER		
SCALE:	0 . 500		
DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED			
.01	.005	.005	.005
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	REV N	DATE	DESCRIPTION	ECN NO	BY
1	190837	WEAR TAPE					
2	202261-111	SENSOR, FIBER OPTIC					
3	527616-7	PLATE - PEEL PLATE					
4	527665-2	BLOCK, STRIPPER					
5	532967-03	PLATE - PEEL PLATE MOUNT					
6	536581-02	ASSY, SENSOR SLIDE					
7	536806-01	ASSY, PINCH ROLLER ARM					
8	536832-01	ASSY, GUIDE ROLLER					
9	536832-03	ASSY, GUIDE ROLLER					
10	537672-01	ASSY, PINCH ROLLER					
11	544439-01	BRACKET, SENSOR					



NOTES:  
1. SENSOR NOT INCLUDED IN ASSEMBLY. FOR REFERENCE ONLY.



1.000  
REF'D WHERE USED

KIRK - RUDY, INC.  
WOODSTOCK, GEORGIA

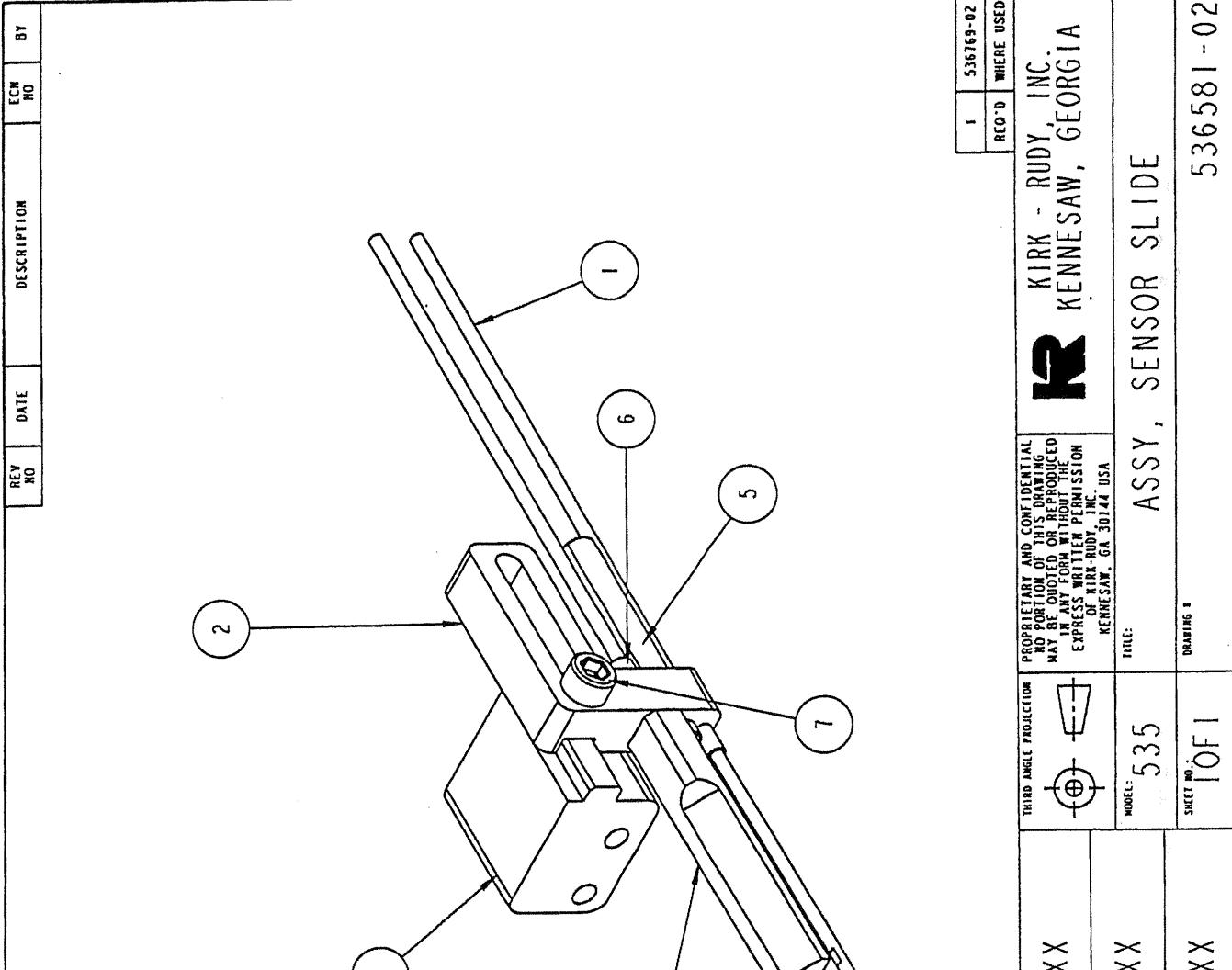
ASSY - STRIPPER PLATE

DRAWING #

536769-02

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.	
TRACED BY:		DATE	.xx	.xxx	ANG.				WOODSTOCK, GA 30188 USA
		12-NOV-03	.01	.005	.5	HEAT TREAT:	N / A	MODEL:	535
MASTER	M		REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED		ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY		FINISH:	SHEET NO.:	10 OF 2

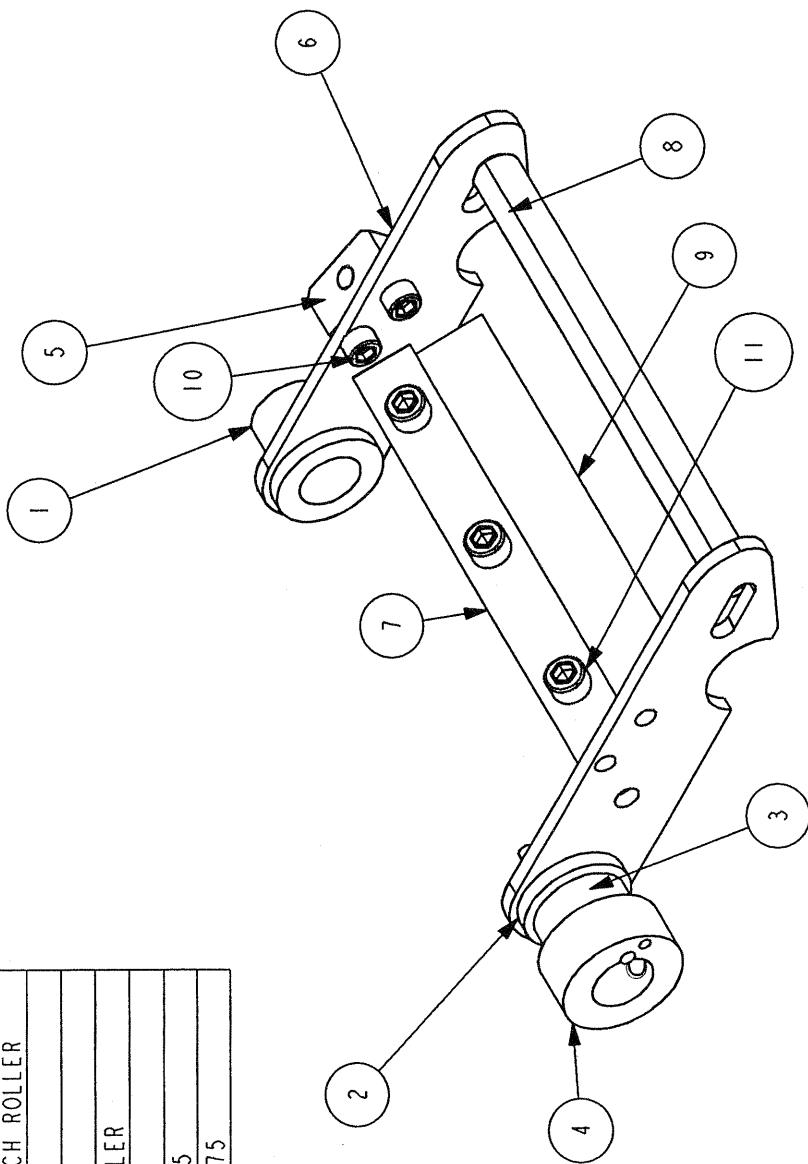
ITEM	QTY	PART #	DESCRIPTION
1	2	202261-12	PLASTIC PIPSM26U
2	1	538157-01	BLOCK, FIBER OPTIC MOUNT
3	1	538158-01	GUARD, FIBER OPTIC
4	1	538159-01	BLOCK, SENSOR SLIDE
5	1	538163-01	SHAFT, FIBER OPTIC SUPPORT
6	3	CSDD153	
7	1	CSDD266	



1	536769-02
REV'D	WHERE USED
KR	KIRK - RUDY, INC.
	KENNESAW, GEORGIA
NAME:	ASSY, SENSOR SLIDE
DATE:	535
SHEET NO.:	OF 1
DRAWING #:	536581-02

DRAWN BY:	T JG	SCALE	1.000	MATERIAL:	X X X	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
CHECKED BY:		DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	.XX .XXX .005 .5	HEAT TREAT:	X X X		
DATE:	29-Dec-99	REMOVAL ALL RIBS AND SHARP EDGES UNLESS OTHERWISE NOTED		FINISH:	X X X		
TRACED BY:	M	MASTER					ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY

ITEM	QTY	PART #	DESCRIPTION
1	1	100304	BUSHING, FL. 500ID. 625OD. 750LG
2	1	100323	BUSHING, FL. 500ID. 625OD. 375LG
3	1	102785	SPRING, TORSION
4	1	102205-2	COLLAR
5	1	536770-01	BLOCK-ADJUSTMENT, PINCH ROLLER
6	2	536772-01	PLATE, BUSHING
7	1	536773-04	BAR, BRUSH MOUNT
8	1	536774-01	BAR-ROUND, PINCH ROLLER
9	1	543367-01	BRUSH, HOLD DOWN
10	2	CSDD237	SCREW, SHCS 8-32X .375
11	3	CSDD264	SCREW, SHCS 10-32X .375



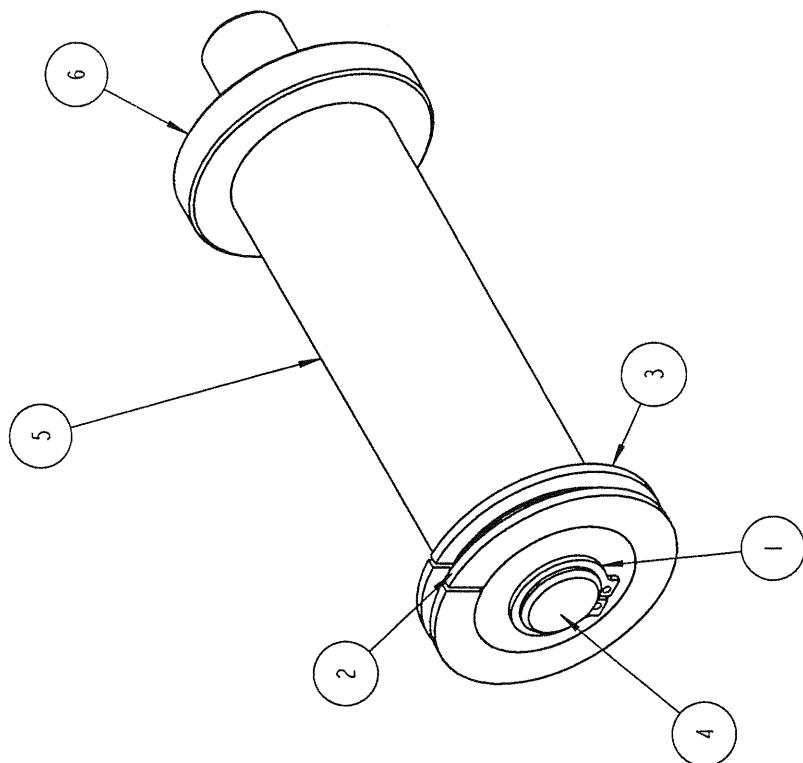
REV NO	DATE	DESCRIPTION	ECN NO	BY
1	8/11/2002	ADDED 543367-01 AND 536773-04 DELETED 536773-01	536773-04	TG

REC'D	WHERE USED
1	SP76300

DRAWN BY:		SCALE	0 . 750	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	MATERIAL:	X X X	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.
TVK		.xx	.xxx	.065	.5	HEAT TREAT.		
DATE		10 - Sep - 99						KIRK-RUDY INC. KENNESAW, GA 30144 USA
CHECKED BY:								SP76300
TRACED BY:		MASTER	M	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED	X X X			TITLE: ASSY, PINCH ROLLER ARM
				ALL DIMENSIONS ARE FINISHED IN INCHES DO NOT SCALE - WORK TO DIMENSIONS ONLY	X X X			SHEET NO. 1 OF 1
								DRAWING #

536806-01

ITEM QTY	PART #	DESCRIPTION
1	104106	SNAPRING .500
2	190895	O-RING, 1.125 X 1.312 X .093
3	1 525205	GUIDE, RING
4	1 536777-01	SHAFT WEB
5	1 536833-01	ROLLER, WEB
6	1 538101-01	DISK, TAB GUIDE

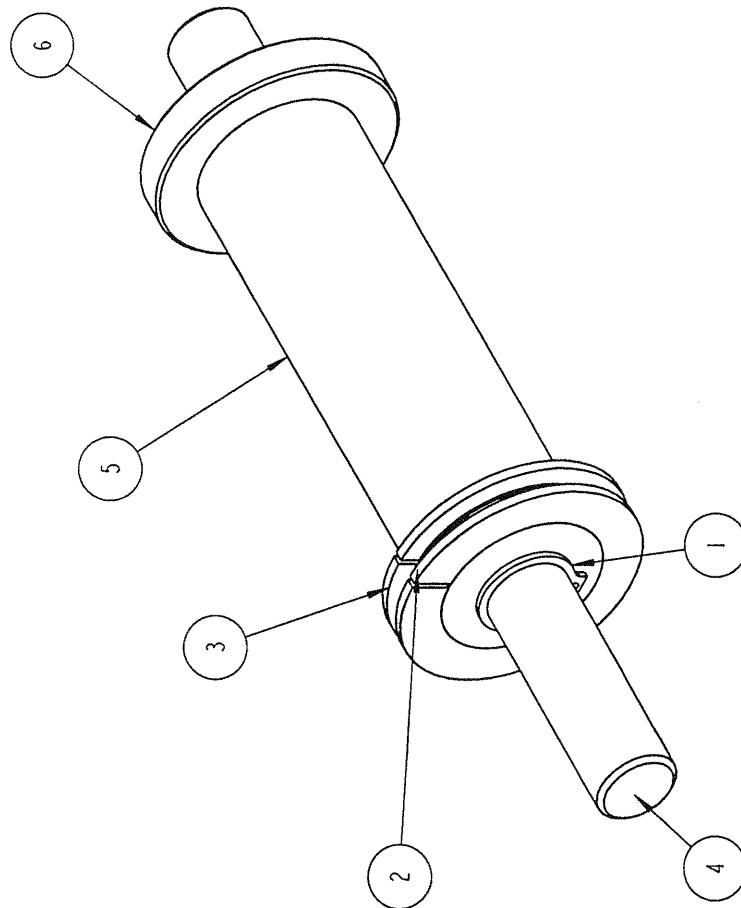


REV NO	DATE	DESCRIPTION	ECN NO	BY
1	7/22/2001	REPLACED EXT. SPRING WITH O-RING	6713	TJG

REO'D	WHERE USED
1	KRS35HD

DRAWN BY: TJG	SCALE 1.000	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED		
CHECKED BY:	DATE 25-0ct-99	.xx	.xxx	ANG. .01 .005 .5
TRACED BY:	MASTER <i>M</i>	HEAT TREAT: N/A		
FINISH: REMOVE ALL BURS AND SHARP EDGES UNLESS OTHERWISE NOTED ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY				
MATERIAL: N/A		THIRD 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	
MODEL: SP76300		TITLE: ASSY, GUIDE ROLLER		SHEET NO. 10F1
DRAWING #				DRAWING #
				536832-01

ITEM QTY	PART #	DESCRIPTION
1	104106	SNAPRING .500
2	190895	O-RING, 1.125 X 1.312 X .093
3	525205	GUIDE, RING
4	536777-03	SHAFT WEB
5	536833-01	ROLLER, WEB
6	538101-01	DISK, TAB GUIDE



REV NO	DATE	DESCRIPTION	CCN NO	BY
1	7/2/2001	REPLACED EXT. SPRING WITH O-RING	6713	TJG

I	KRS55HID
REQ'D	WHERE USED



KIRK - RUDY, INC.  
KENNESAW, GEORGIA

ASSY, GUIDE ROLLER

SP76300

DRAWING #:  
1 OF 1

DATE:  
25-0C1-99

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 30044 USA

HEAT TREAT:

N/A

FINISH:

N/A

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

MASTER M

SHEET NO. 1

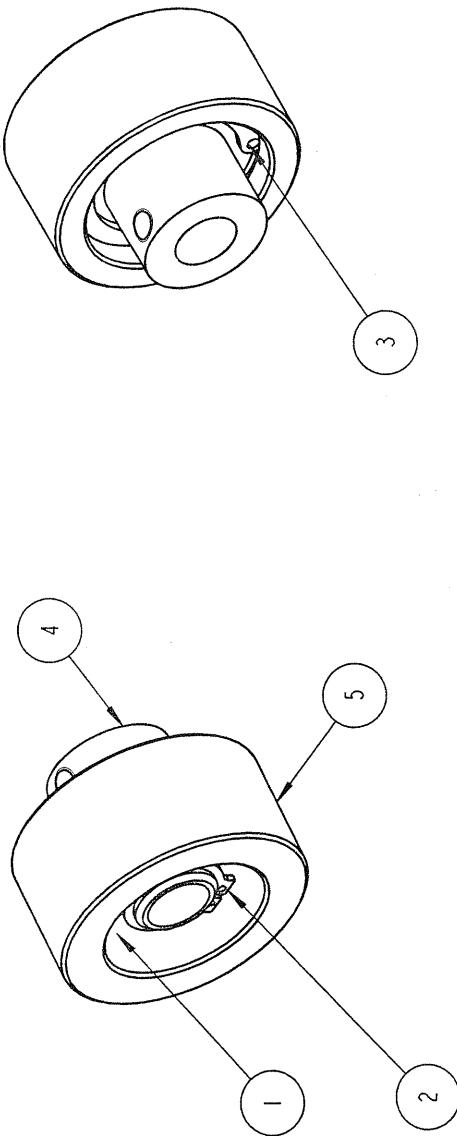
DRAWING NO.

536832-03

REVISIONS:

0

ITEM QTY	PART #	DESCRIPTION
1	103108	BEARING, FLAT .500
2	104106	SNAPRING, .500
3	104205	SNAPRING, INTERNAL 1.125 BORE
4	536771-01	STUD-ROLLER
5	536775-01	ROLLER, ARM

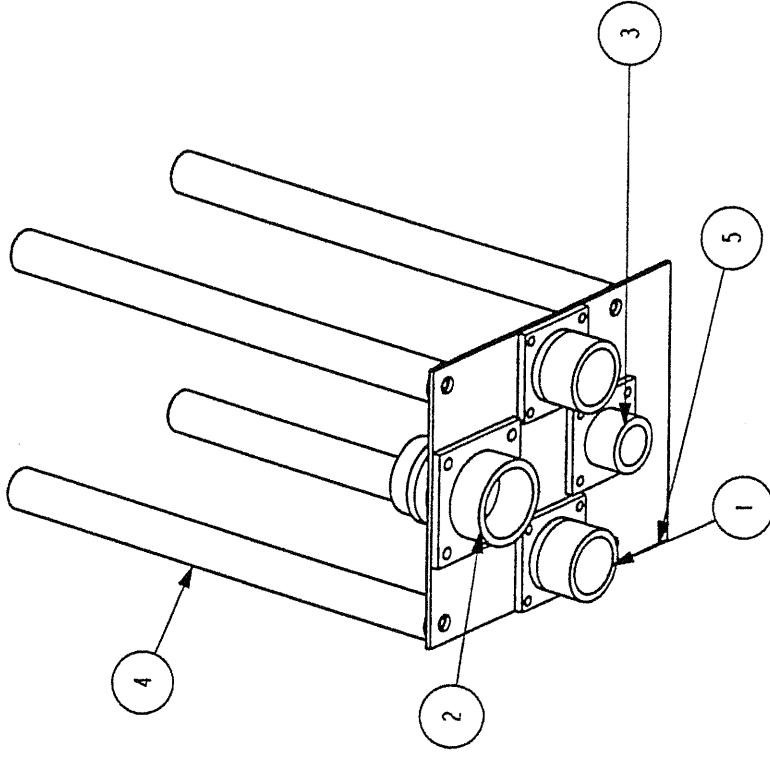


REV NO	DATE	DESCRIPTION	ECN NO	BY
1	10/30/2001	ADDED INTERNAL SNAPPING	6756	TJG

X	XXX
REQ'D	WHERE USED

DRAWN BY: TJG	SCALE 1 .000	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED: xx .xxx .005 .01 ANG.	MATERIAL: XXX	THRO ANGLE PROJECTION - - - - -	PROPRIETARY AND CONFIDENTIAL NO FORGING OF THIS DRAWING MAY BE DONE OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC. KENNESAW, GA 30144 USA
CHECKED BY:	DATE 01 - Nov - 99	HEAT TREAT: XXX	MODEL: 535	TITLE: ASSY, PINCH ROLLER	DRAWING #: 537672-01
TRACED BY:	MASTER <i>m</i>	FINISH: XXX	SHEET NO. OF 1	REMOVAL 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	2	200499 RECEPTACLE, AMPHENOL 4 PIN
2	1	200500 RECEPTACLE, AMPHENOL 16 PIN
3	1	200501 RECEPTACLE, AMPHENOL 4 PIN
4	4	536783-01 BAR-ROUND, ELECTRICAL PLATE
5	1	536785-01 PLATE-ELECTRICAL CONNECTION

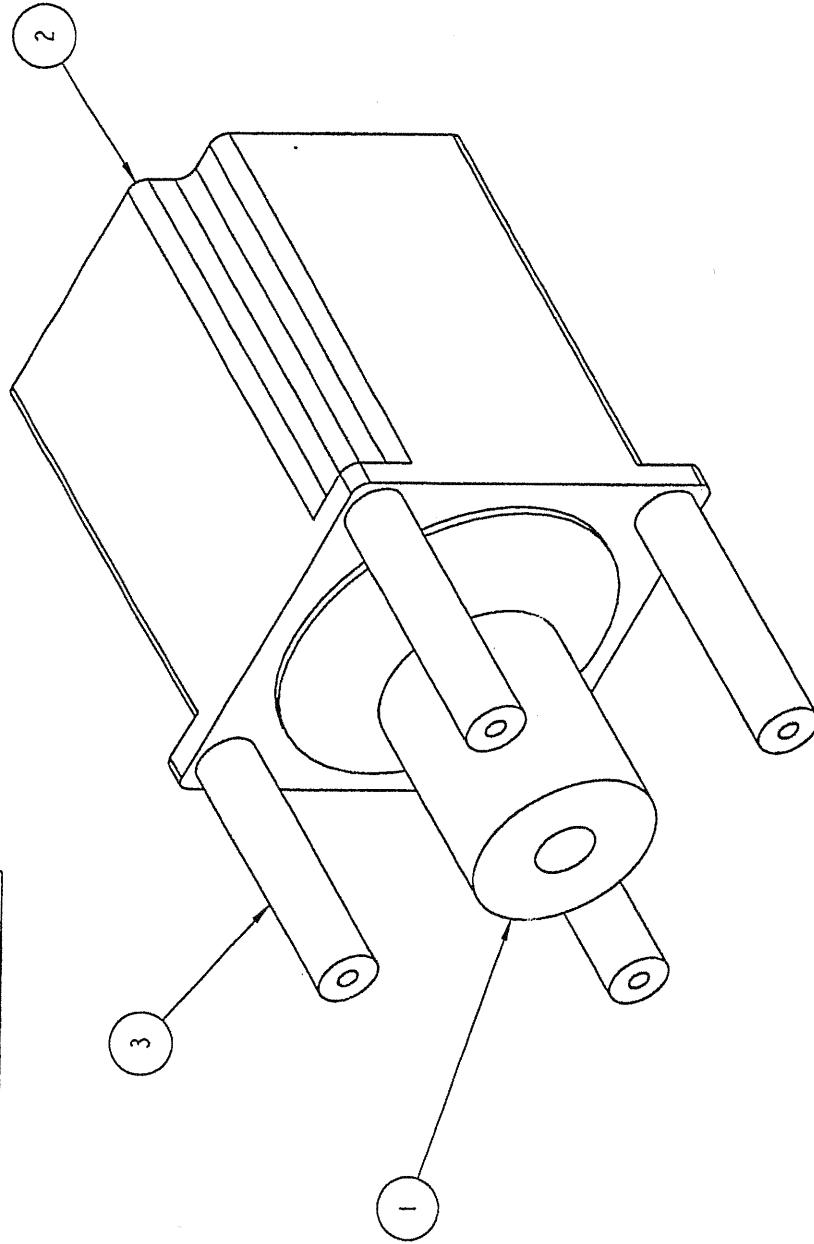


ITEM	REV NO	DATE	DESCRIPTION	ECN NO	B/T
1					
2					
3					
4					
5					

1	KRS350
RECO'D WHERE USED	
<b>KRK</b>	<b>KIRK - RUDY, INC.</b>
	<b>KENNESAW, GEORGIA</b>
NOTE:	ASSY-ELECTRICAL CONNECTION PLATE
DRAWING #	536784-01
SCREEN NO.	10F1

DRAWN BY: TVK	SCALE 0 . 500	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
CHECKED BY:	DATE 10 - Sep - 99	.01 .005 .5	HEAT TREAT: XXX		
TRACED BY:	MASTER <b>M</b>	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED	FINISH: XXX	NOTE: SP76300	NAME: ASSY-ELECTRICAL CONNECTION PLATE
		ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY			DRAWING #

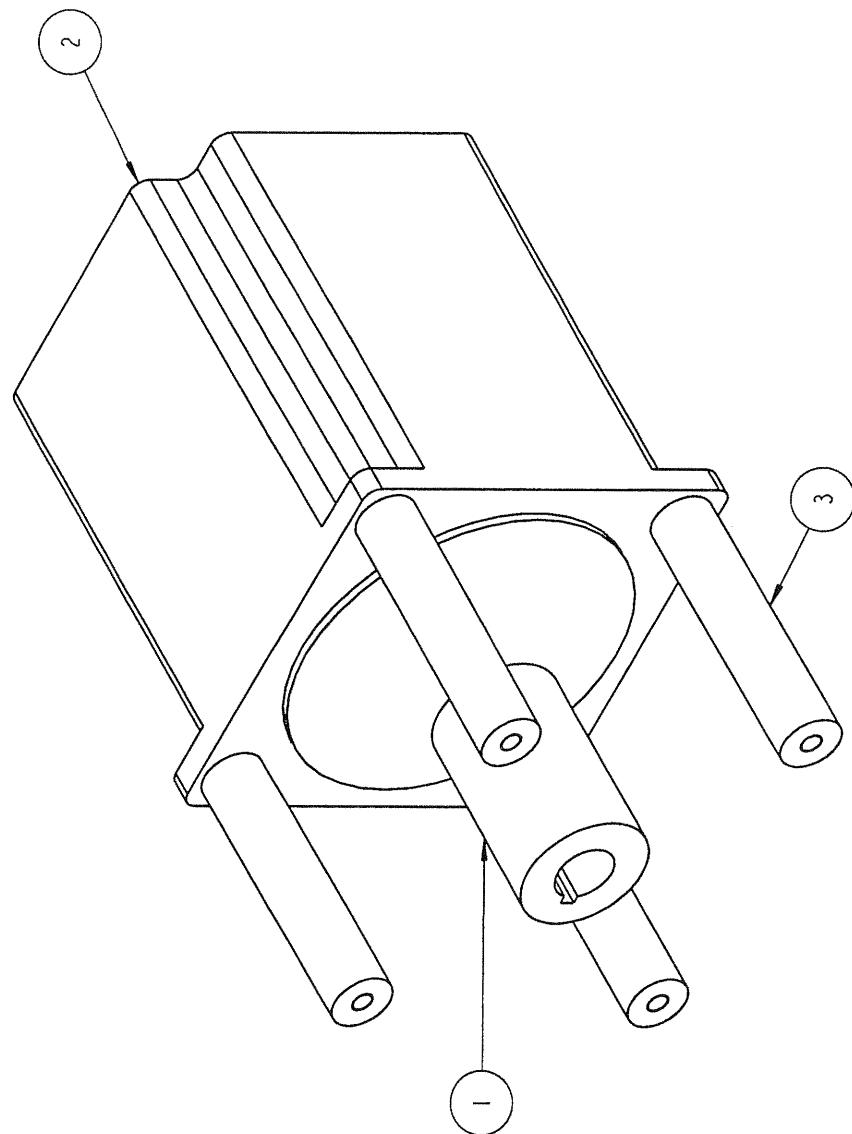
ITEM	QTY	PART #	DESCRIPTION
1	1	101222	COUPLING, SHAFT SC035
2	1	200159-4	MOTOR, STEPPER KML092-F07
3	4	536950-01	SHAFT, MOTOR MOUNT



ITEM NO.	SCALE	DATE	REMOVED ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED	MATERIAL:	HARD ANGLE PROJECTION	PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE DUPLICATED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC. KENNESAW, GA 30144 USA	REO'D WHERE USED
T JG	0 . 750		.01 .005 .5	XXX	⊕	SP76300	KIRK - RUDY, INC. KENNESAW, GEORGIA
CHECKED BY:		25-0c† - 99		HEAT TREAT:			DRAWING #
TRACED BY:	MASTER		REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY	XXX	1 OF 1		536805-01

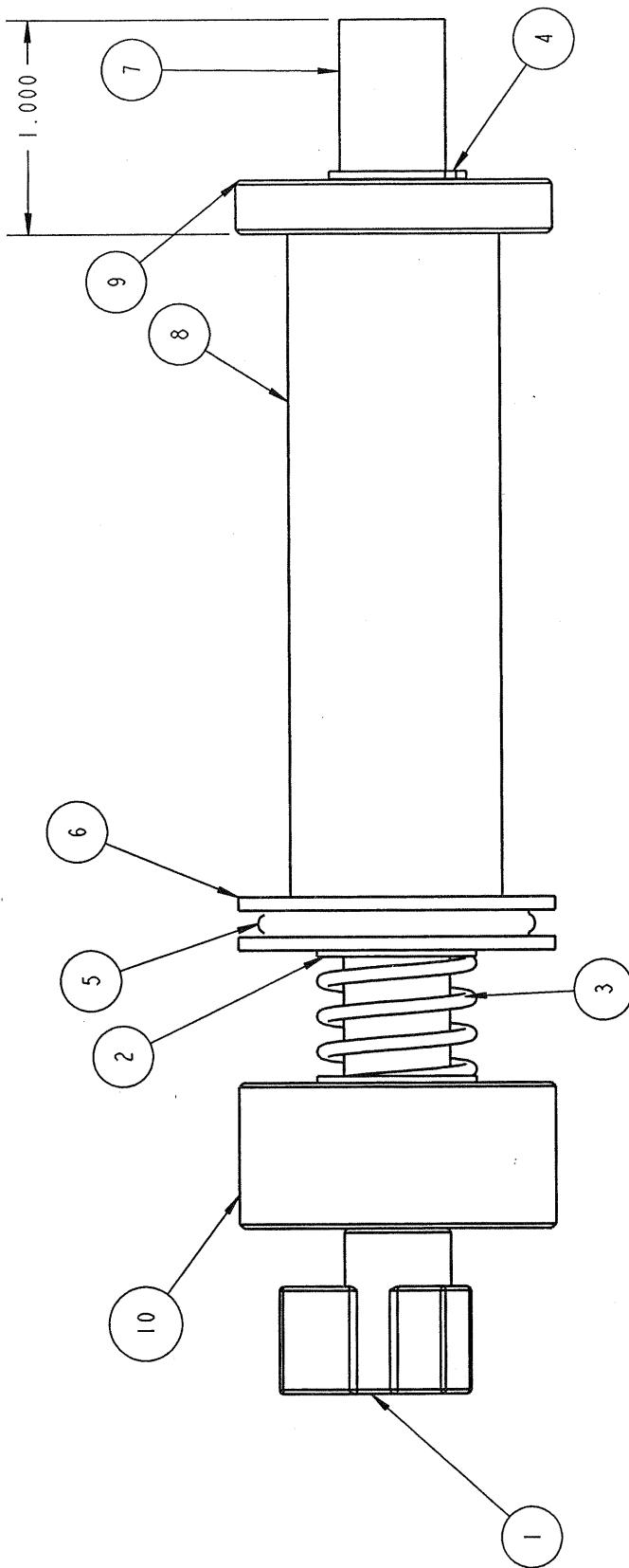
ITEM QTY	PART #	DESCRIPTION
1	101223	COUPLING, SHAFT .500B .125K
2	200159-4	MOTOR, STEPPER KML092-F07
3	536950-01	SHAFT, MOTOR MOUNT

ITEM NO	REV NO	DATE	DESCRIPTION	ECN NO	BY
1		7/22/2001	ELIMINATED PART 536905-02	6714	TJG



DRAWN BY:	SCALE	0 . 750	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED		HEAT TREAT:	XXX	THIRD ANGLE PROJECTION	KIRK - RUDY, INC.
CHECKED BY:	DATE	.xx	.xxx	ANG. .01	.005	.5	REMOVED ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED	KIRK - RUDY, INC.
TRACED BY:	MASTER	17-Dec-99	ALL DIMENSIONS ARE IN INCHES		FINISH:	XXX	DO NOT SCALE - WORK TO DIMENSIONS ONLY	KENNESAW, GEORGIA
	M							30144 USA
							SHEET NO. 1 OF 1	ASSY, MOTOR UNWIND
								DRAWING # 536805-02

ITEM QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	1	102117 KNOB					
2	2	102303 SPACER, .500X.750X.312					
3	1	102707 SPRING, COIL					
4	1	104106 SNAPRING, .500					
5	1	190895 O-RING, 1.125 X 1.312 X .093					
6	1	525205 GUIDE, RING					
7	1	536777-08 SHAFT, WEB BRAKE					
8	1	536833-01 ROLLER, WEB					
9	1	538101-01 DISK, TAB GUIDE					
10	1	542329-01 COLLAR, THREADED BRAKE					



DRAWN BY:	T JG	SCALE	.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. KENNESAW, GA 30144 USA
CHECKED BY:		DATE	5 - JUL - 03	.XX .XXX ANG.	.01 -.005 .5	HEAT TREAT:	
TRACED BY:		MASTER	M	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED	N/A	FINISH:	
				ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY	N/A	SHEET NO.: 10F1	DRAWING #: KR535

I	KR535
REQ'D	WHERE USED

KIRK - RUDY, INC.  
KENNESAW, GEORGIA



DISK, TAB GUIDE

ASSY, GUIDE ROLLER DRAG

536832-19

ITEM	QTY	PART #	DESCRIPTION
1	1	102140	HANDLE, RELEASE 1/4-20 X .75
2	2	102906	BEARING, LINEAR SLEEVE OPEN
3	1	536351-03	HUB-LINEAR BEARING MOUNT
4	1	536766-02	ASSY-CROSS ADJUSTMENT
5	1	536819-02	BRG HOUSING MOUNT

REV NO	DATE	DESCRIPTION	ECN NO	BY

I KR55SHD  
REO'D WHERE USED

DRAWN BY: T JG      SCALE: 0 . 500      DIMENSIONAL TOLERANCES: MATERIAL: XXX  
UNLESS OTHERWISE NOTED      .11 .005 .5 ANG.

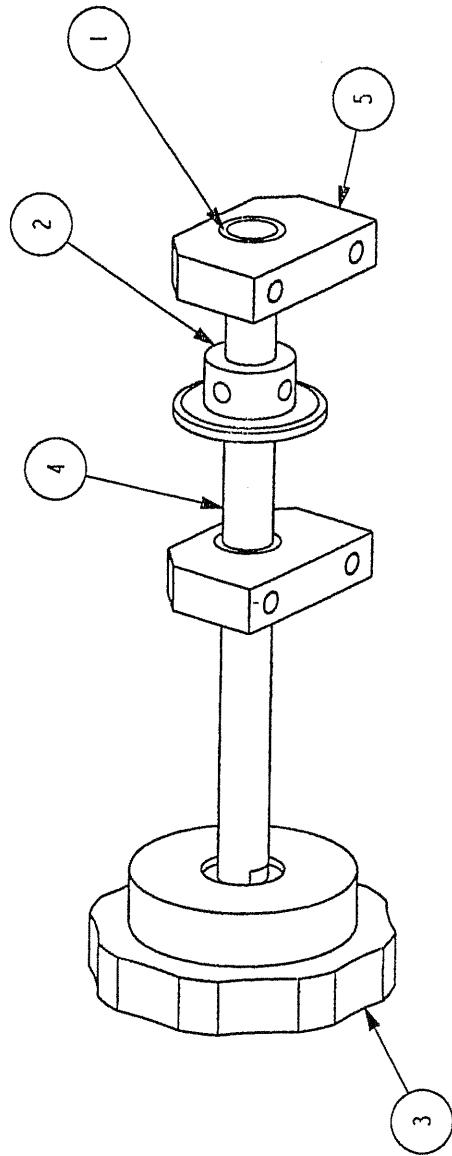
CHECKED BY: 01 - Nov - 99      DATE: .01 .005 .5 HEAT TREAT: XXX  
MASTER: m      FINISH: REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED  
ALL DIMENSIONS ARE FINISHED DIMENSIONS  
DO NOT SCALE - WORK TO DIMENSIONS ONLY

TRACED BY:

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

MODEL: 535      NAME: ASSY, FRAME CROSS ADJUSTMENT  
SHEET NO: 0F 1      DRAWING #: 536951-01

ITEM	QTY	PART #	DESCRIPTION
1	2	100101	BUSHING, SL. 375ID.5000OD.375LG
2	1	111207	SPRKT. 25B13 .375B NK
3	1	500772	KNOB
4	1	536757-02	STUD-DRIVE SPROCKET
5	2	536796-04	PLATE-BUSHING



DRAWN BY:	SCALE:	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED		MATERIAL:	THIRD ANGLE PROJECTION		PROPRIETARY AND CONFIDENTIAL	REF'D TO:	1.000	SP716100
CHECKED BY:	DATE:	.XX	.XXX	AMT.	.01	.005	.5	WHERE USED	RECD'D	
TVK	0 .750			N / A						
	03 - Sep - 99									
TRACED BY:	MASTER									

ASSY-CROSS ADJUSTMENT

DRAWING # 536766-02

TITLE: KIRK - RUDY, INC.  
KENNESAW, GEORGIA

MATERIAL: N/A

FINISH: N/A

SPEC NO: 76300

DRAWING #: 10F1

DRAWN BY: TVK

CHECKED BY: DATE: 03 - Sep - 99

TRACED BY: MASTER

REF'D TO: 1.000 SP716100

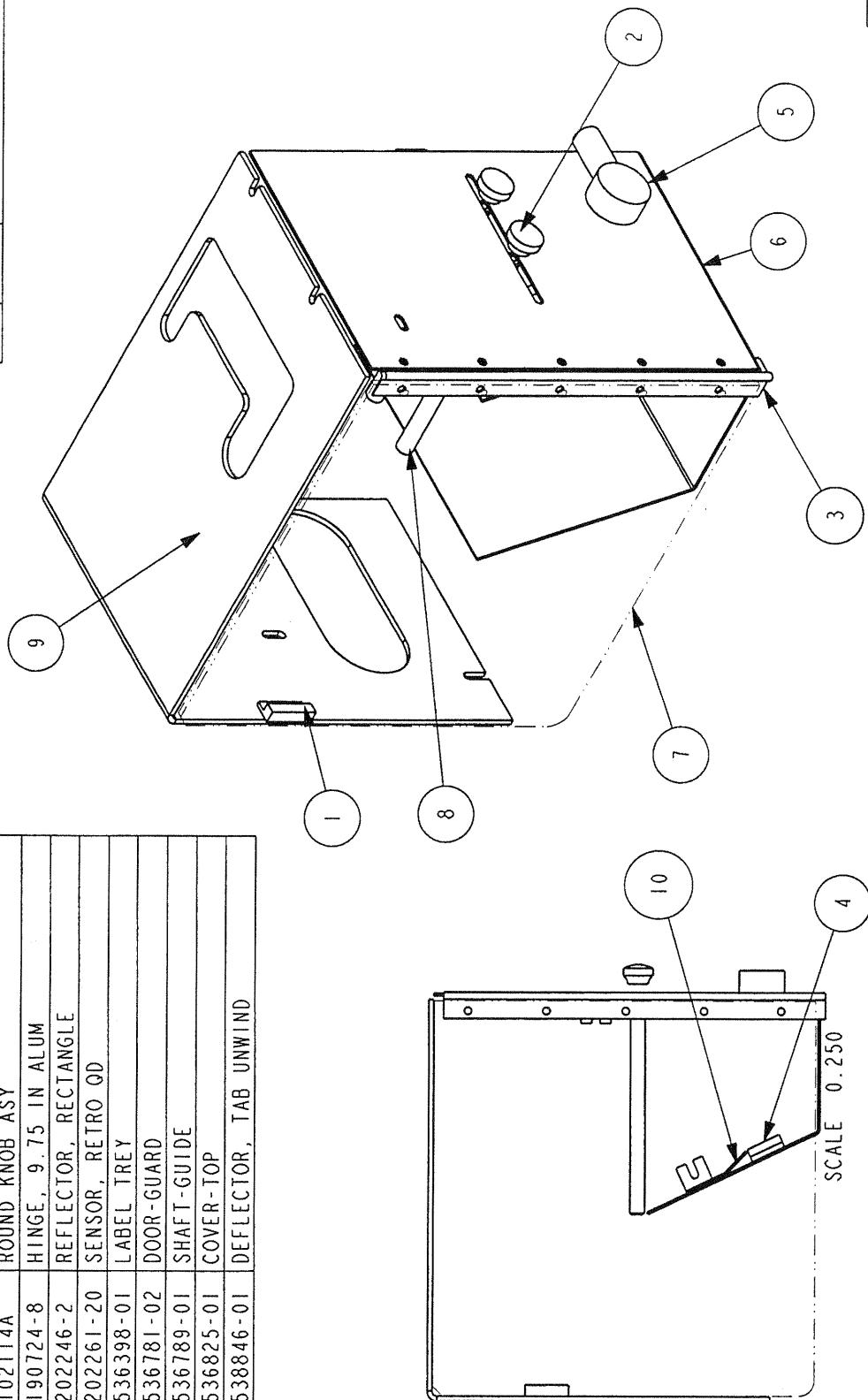
WHERE USED: RECD'D:

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

ITEM QTY	PART #	DESCRIPTION
1	201170	SWITCH, SAFETY DOOR
2	102114A	ROUND KNOB ASY
3	190724-8	HINGE, 9.75 IN ALUM
4	202246-2	REFLECTOR, RECTANGLE
5	202261-20	SENSOR, RETRO QD
6	536398-01	LABEL TREY
7	536781-02	DOOR-GUARD
8	536789-01	SHAFT-GUIDE
9	536825-01	COVER-TOP
10	538846-01	DEFLECTOR, TAB UNWIND

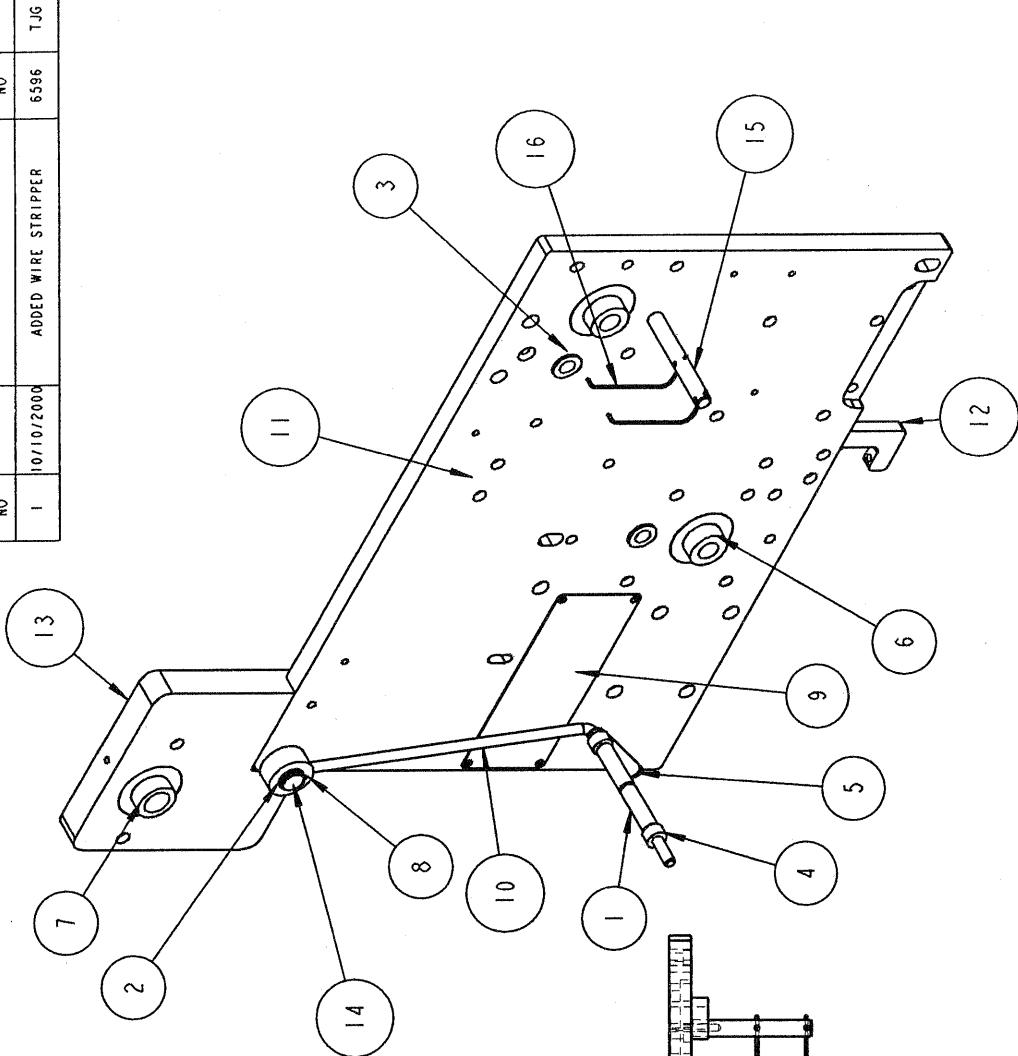
REV NO	DATE	DESCRIPTION	ECN NO	BY
I	7/22/2001	REPLACED UNWIND SENSOR	6715	JG

I	KR535HD
REQ'D	WHERE USED



DRAWN BY: TVK		SCALE 0 .310	MATERIAL XXX	THREE 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	
CHECKED BY:		DATE 25-0C1-99	DIMENSIONAL TOLERANCES .01 -.015 .005 .005	HEAT TREAT: XXX	MODEL: 535	TITLE: ASSY, LABEL TRAY COVER
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		SHEET NO. 10F1	DRAWING I
536957-01						

ITEM	QTY	PART #	DESCRIPTION
1	2	100131	BUSHING, SL. 250ID .375OD 1.250LG
2	1	100162	BUSHING, SL. 500ID .625OD .625LG
3	2	100302	BUSHING, FL. 375ID .500OD .500LG
4	2	102206	COLLAR .250
5	1	102623	SPRING, EXT. 3600 X .298ID X 2.5LG
6	2	103803	BEARING, HUB .500
7	1	103804	BEARING, HUB .625
8	1	104106	SNAPRING .500
9	1	190619	PLATE, NAME
10	1	532788-02	WLDMNT, TAKE-UP ROD
11	1	536374-03	PLATE, TABBER FRAME
12	1	538124-01	BAR, VERTICAL STOP
13	1	538137-02	PLATE, TAKE-UP ROLL EXT.
14	1	538195-01	SHAFT, REWIND ARM PIVOT
15	1	538373-01	SHAFT, TAB STRIPPER
16	2	538374-01	STRIPPER, TAB UNWIND



SCALE 0.250

DRAWN BY:	SCALE	0 . 250	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 30444 USA
CHECKED BY:	DATE	22-0c+ - 99	.01	.005	.005	HEAT TREAT: XXX	MODEL: 535	KIRK - RUDY, INC. KENNESAW, GA 30444 USA
TRACED BY:	MASTER	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY			FINISH: XXX	SHEET NO. 1 OF 1	TITLE: ASSY, FRAME W/ BEARINGS	
						DRAWING # 537669-01		
						REQ'D WHERE USED		
						1 KR535HD		

## **8.0 ELECTRICAL SCHEMATICS AND PARTS**



### **WARNING**

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

#### **8.1 SCHEMATIC NUMBER LIST**

The following wiring diagrams are supplied in a separate package and enlarged with your manual for your reference. A reference of drawing symbols is also provided.

200 111 01 110      Schematic, 535 Tabmaster  
SYMBOLS.ORC      Schematic Symbols Reference

#### **8.2 PARTS LIST**

<b>KR Part #</b>	<b>Qty</b>	<b>Manufacturer</b>	<b>Manufacture Part #</b>	<b>Description</b>
200338	1	Thomas & Betts	LT38P	Strain Relief - 3/8"
200339	1	Thomas & Betts	LT938P	Strain Relief - 90 Degree
201514	10	Hubbell	7594-VBLK	Plug - Twist, 3 Pin, Male
201541	1	Turck	RKF36-1M	Receptacle - 3 Pin, 1 Meter
201540	1	Turck	RKF20	Receptacle - 2 Pin
208503	2	Sunon	SP100A	Fan - 120 Vac
200323-1	7	Mencom	PCG-1/2R	Connector - Strain Relief
208043	1	Bussman		Fuse - 10 MDA
200159-1	1	Superior	M093 FD8208	Motor - 200 Steps/Rev
208023	1	Bussman		Fuse - 12 AGC
208044	1	Bussman		Fuse - 4 AGC
201542	1	Turck	RSM 20-6M	Plug - 2 Pin w/ Cable
202426	1	Penta Power	KBMM-225D	Board, Motor, DC, 120 Vac - For 90 Vdc Motor
209163	1	Phoenix	NS35/7.5	DIN Rail Strip - Length is application specific
202277	6	Idec	SH2B05	Socket, Relay - For 202 275, 202 276
204318	1	Clarostat	RV4NAYSD502A	Potentiometer - 5k Ohm
209237	3	Phoenix	USLKG16	Terminal, Ground
208015	3	Bussman		Fuse - 1 MDL
208022	2	Bussman		Fuse - 8 AGC
202427-1	1	Penta Power	9839	Resistor, .05 ohm
200341	1	Thomas & Betts	LT950P	Strain relief - 90 Degree
200340	1	Thomas & Betts	LT950P	Strain Relief - 1/2"
201515	1	Hubbell	7593-VBLK	Receptacle - Twist, 3pin, female
201546	1	Turck	RSM 20-6M	Plug with WIRENUT
201516	1	P/S	5266X	Plug, 15A 120V Power
201543	1	Turck	RSM 36C-6M	Plug, Conveyor Power
201160-3	1	Metric	63-18075-X13	Inlet, 20A 110V
201161-3	1	Metric	63-13075-180-X13	Connector, 20A 110V
201161-3A	1	Metric	CABLE W/PLUG	Connector, Assembly

KR Part #	Qty	Manufacturer	Manufacture Part #	Description
208504-1	1	Sunon	25726	Grill Fan Filter
200165-5	1	Leeson	M1130331.00	Motor, 1/4HP DC
209270	2	Leeson	M1900010.22	Brush, For 200165-5
209271	2	Leeson	M1900008.01	Brush, Cap for 200165-5
200608	1	Baldor	GP231001	Motor, Rewind
209272	2	Baldor		Brush for 200608
209092-1	2	Baldor		Brush Cap for 200608
200159-4	2	Warner	KML092F07	Motor, Stepping
202486	1	Warner	MX2000-1C	Board, Logic
209016-1	1	EHO	EH71-3N2S	Knob, Speed Pot
209016-2	1	EHO	KL1251G	Lock, Knob
201130-1	5	GE	P9B10VN	Contact, NO
201131-1	3	GE	P9B01VN	Contact, NC
201124-2	1	GE	P9CPNVG	Operator, Green Pushbutton
201124-4	1	GE	P9CPLVGD	Operator, Green Light
201124-5	1	GE	P9PDNVO	Socket, LED
201124-6	1	GE	080BA9S24LB	Bulb, 24VDC
201125-3	1	GE	P9CPNRS	Operator, Red Pushbutton

## 9.0 APPENDIX



### **WARNING**

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

The following component's brochures are supplied in a separate package with your manual for your reference.

<u>COMPONENT</u>	<u>MANUFACTURER</u>
DC Supply	International Power
Stepper Drives	Warner Electric
DC Motor Board	Penta-KB
Beamswitch	Banner
Tab Detector	Banner
Interface	Maple Systems

## **10.0 NOTES**

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## **11.0 WARRANTY AND SERVICE**

### **WARRANTY**

**Warranty:** Kirk-Rudy 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 OR 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 REPLACEMENT PARTS**

For Service or Replacement Parts Please Call:

In the USA: Kirk-Rudy @PH 770-427-4203, FX 770-427-4036

In Europe: Grafibind @ PH 011-31-5553-41610