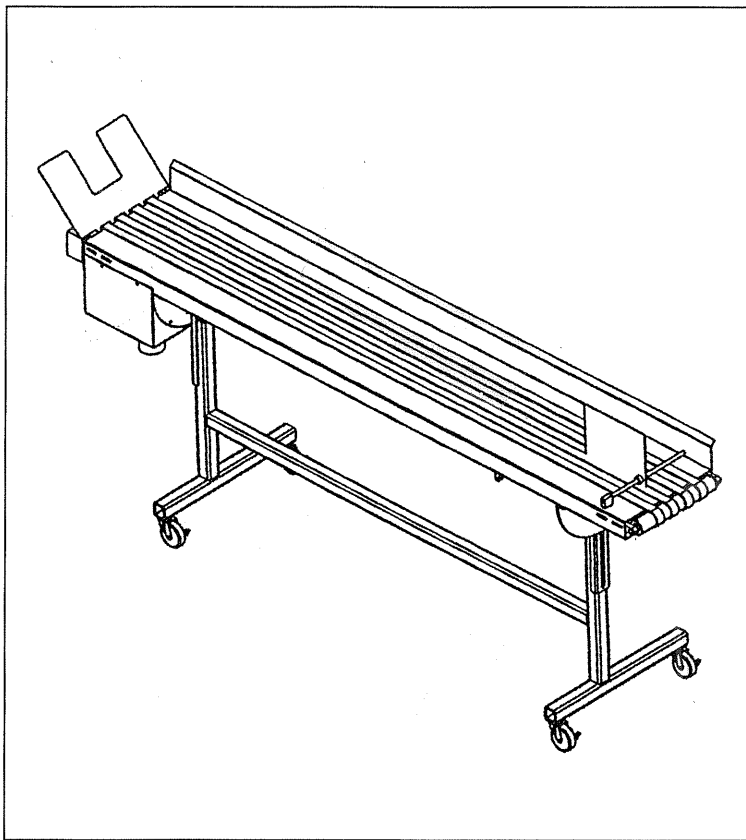


Kirk-Rudy, Inc.

Instruction and Parts Manual KR 618 Tilt Conveyor



Manufactured by Kirk-Rudy, Inc.

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

10000-618 REV. 1 05/23/00

Manual

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

1 Important Safety Instructions

Intended Use Statement: The Kirk-Rudy Inc. 618 Tilt Conveyor is intended to be used with a Philipsburg Insertter at 90° and tilted to desired angle. The KR 618 can also be right-hand or left-hand.

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



WARNING

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

2 SPECIFICATIONS

<u>PRODUCT SIZE RANGE</u>	<u>English</u>	<u>Metric</u>
Minimum Size:	3.5" W x 6" L	89 mm W x 152 mm L
Maximum Size:	6" W x 9" L	152 mm W x 229 mm L

<u>MACHINE DATA</u>	<u>English</u>	<u>Metric</u>
Length	75"	190.5 cm
Width	18"	45.7 cm
Height	28"-34.5"	71.1 cm - 87.6 cm
Tilt Angle from horizontal	approx. 60 degrees	

ELECTRICAL DATA

110 AC, 60 Hz, Single Phase, 1 amp MDL

3 INSTALLATION

3.1 UNCRATING AND UNPACKING



WARNING

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

1. Remove conveyor from crate.
2. Inspect for damage.
3. Locate and open spare parts box (usually shipped inside main machine).
4. Compare packing list with the enclosed items
5. Roll conveyor into place using the casters provided.

4 OPERATING INSTRUCTIONS

4.1 OPERATION



WARNING

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

1. Roll conveyor 90° to other machine and lock castors.
2. Adjust height with bolts on conveyor legs to desired height.
3. Adjust tilt with bolts on conveyor support bracket (part #527530).
4. Plug into wall socket.
5. Turn conveyor on at electrical box.

5 MAINTENANCE

5.1 GENERAL MAINTENANCE



WARNING

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

Keep conveyor and moving parts free of dirt, dust and trash. Periodically lubricate chain with chain lubrication. Lightly oil rollers to prevent rusting. Replace belts as necessary.

5.2 REPLACING AND ADJUSTING BELTS

1. Remove whale tail (part #531459-01).
2. Move the end roller in by loosening adjustment screws on both sides on conveyor.
3. Hold belts at joint and pull inward to provide slack.
4. Pull out wire in joint.
5. Reverse procedure to install new belt and remove slack from belts by tightening adjustment screws on end roller.

6 PARTS LIST AND DIAGRAMS

This section contains the assembly diagrams.

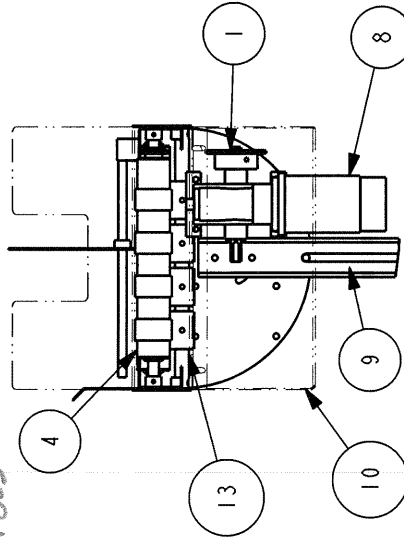
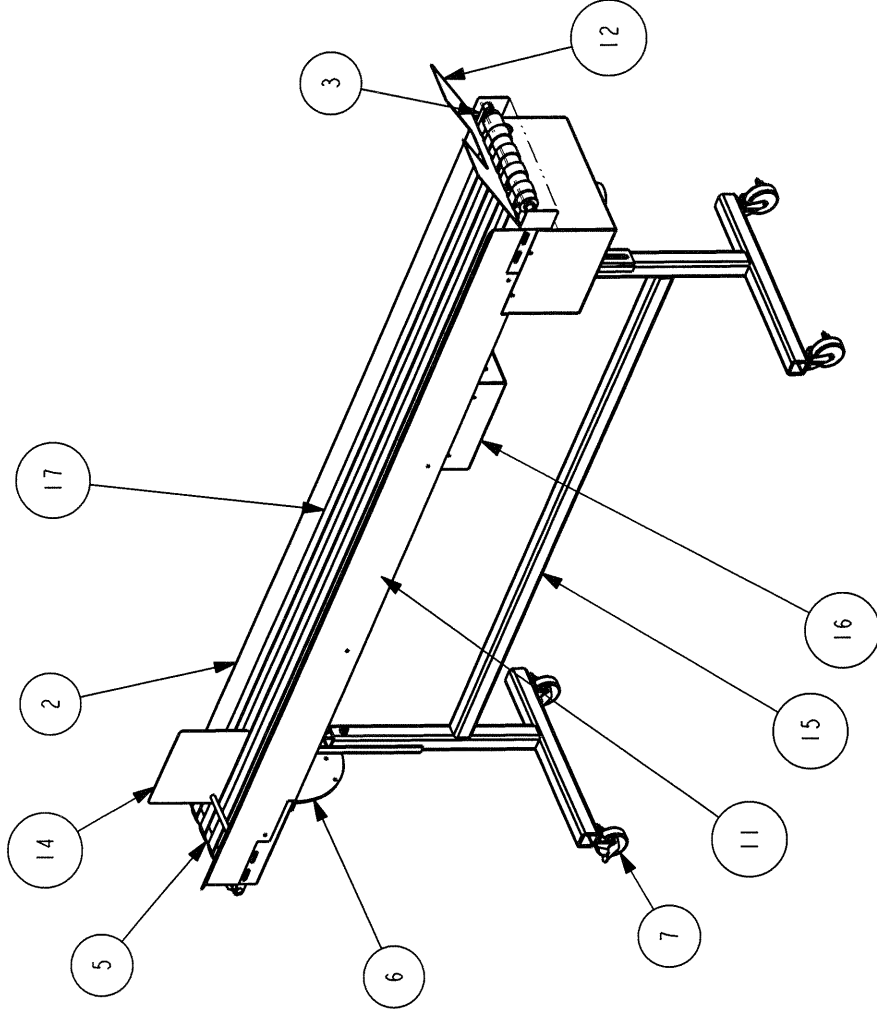
7 ELECTRICAL SCHEMATIC

The electrical schematic for the KR 618 conveyor is drawing #200 163 00 110.

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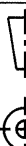


ITEM	QTY	PART #	DESCRIPTION
1	1	110758	SPRKT, 35B22 .500B NK
2	1	527510	TOP, CONVEYOR
3	4	527513	ARM, ROLLER
4	1	527515	ASSY, OUTFEED ROLLER
5	1	527517	ASSY, INFEED ROLLER
6	2	527530	BRACKET, CONVEYOR SUPPORT
7	4	190670-1	CASTER, 2 1/2 IN SWIVEL LOCKING
8	1	200174-2	MOTOR 1/15 HP DC BRUSH
9	2	527529-1	CHANNEL, CONVEYOR SLIDE
10	1	530702-01	COVER, MOTOR
11	1	531456-01	SIDE GUIDE, CONVEYOR
12	1	531459-01	WLDMNT, WHALE TAIL
13	1	538236-01	ASSY, BELT GUIDE SHAFT
14	1	538237-01	ASSY, STOP PLATE
15	1	538239-01	WLDMNT, TILT CONVEYOR LEGS
16	1	538240-01	ASSY, TILT ELEC. BOX
17	4	538244-01	BELT, FLAT 1 IN X 12 FT 8 IN

111825



SCALE 0.125

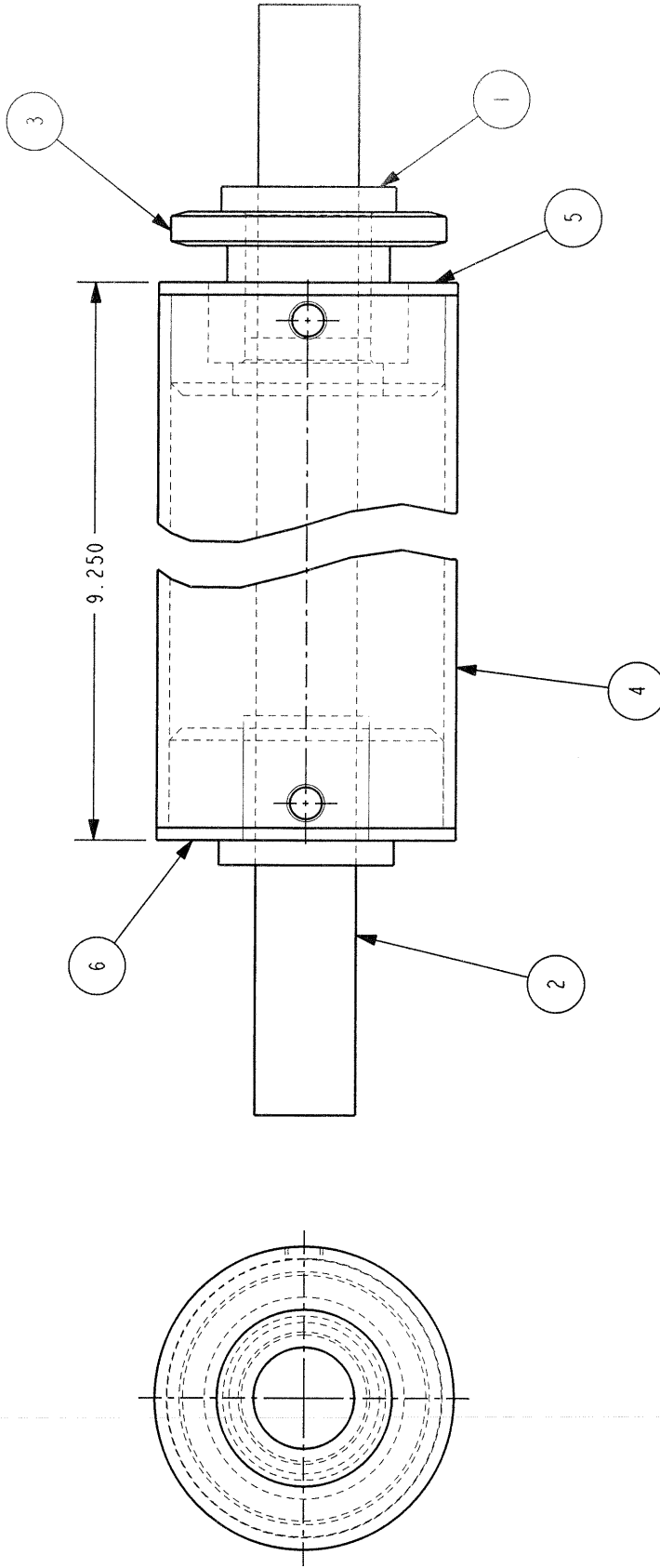
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	CHECKED BY:	DATE 13-Apr-00	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED							HEAT TREAT: NONE
		TRACED BY:	MASTER 	ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY						FINISH: XXX
					MODEL: XXX		TITLE: ASSY, TILT CONVEYOR			
					SHEET NO. 1 OF 1		DRAWING #	538241-01		

527515

ITEM	QTY	PART #	DESCRIPTION
1	2	100304	BUSHING, FL.500ID.6250D.750LG
2	1	527514	SHAFT, CONVEYOR ROLLER
3	1	527516	SPRKT, 35B10 .625B NK
4	1	527515-1	ROLLER
5	1	527515-2	HUB, SPROCKET MOUNT
6	1	527515-3	HUB, BUSHING MOUNT

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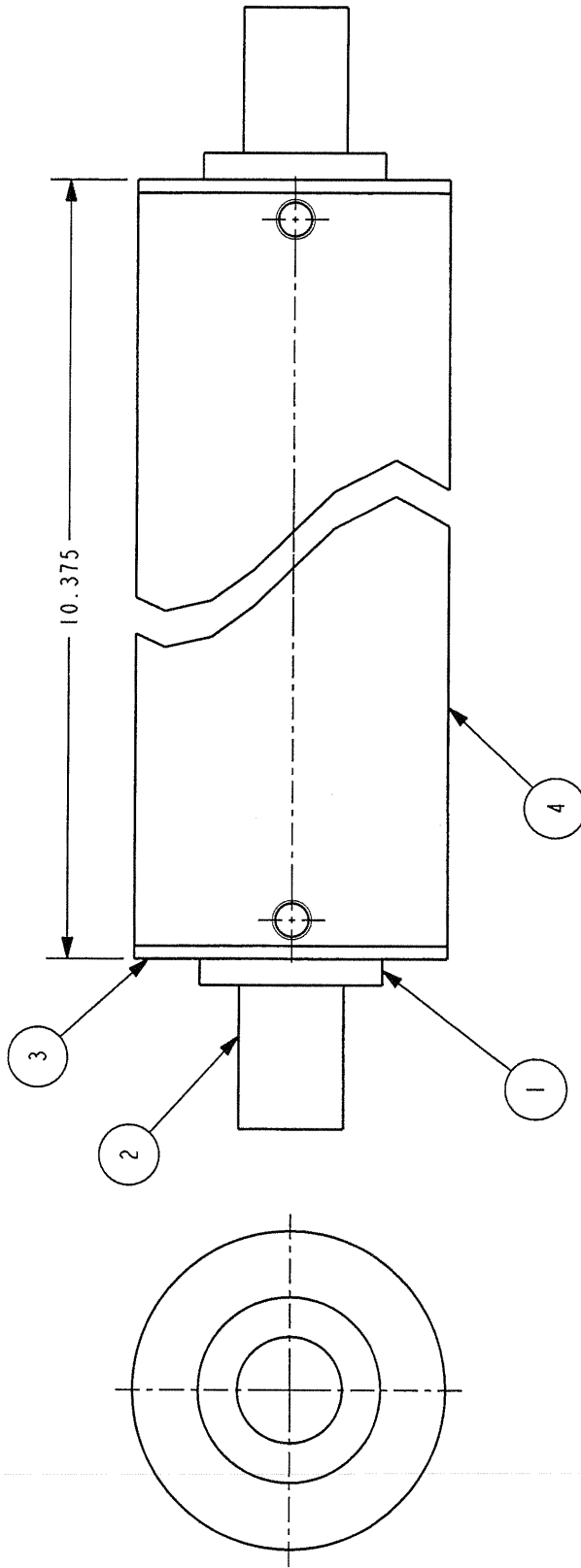
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TRACED BY:	MASTER	FINISH: BLACK OXIDE	SHEET NO: 10F1	DRAWING # 527515		

KR KIRK - RUDY, INC.
KENNESAW, GEORGIA

527517

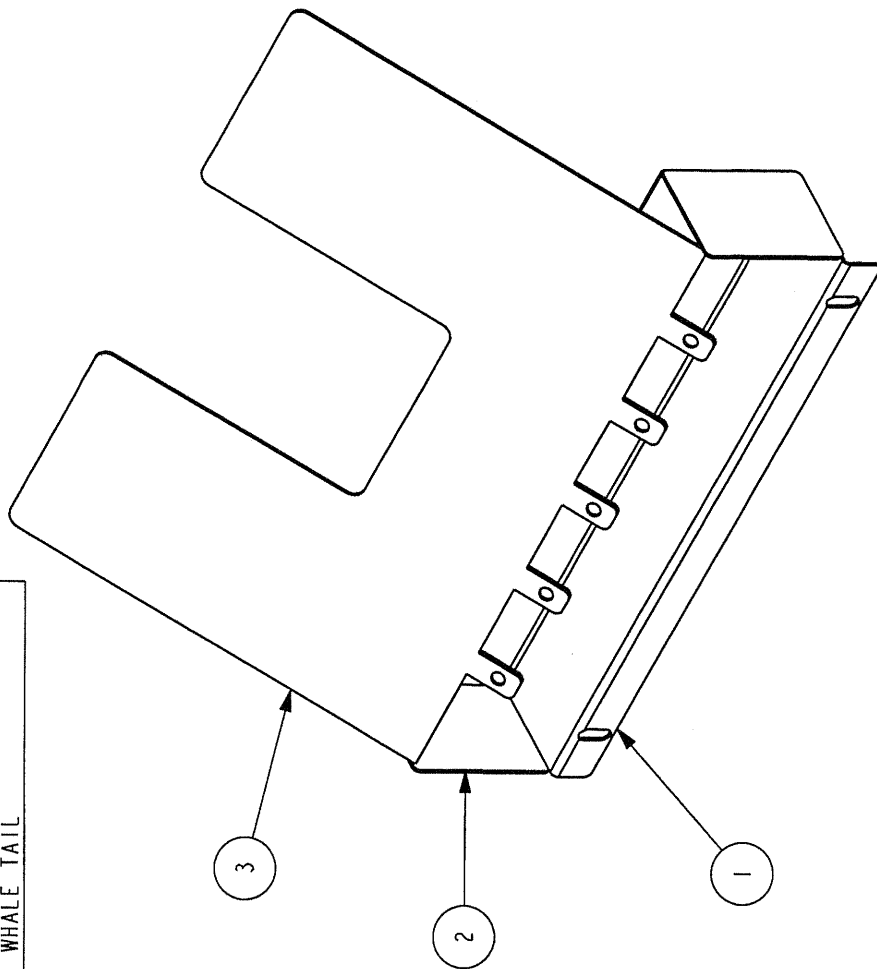
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2	1	527514	SHAFT, CONVEYOR ROLLER
3	2	527515-3	HUB, BUSHING MOUNT
4	1	527517-1	ROLLER





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	CHECKED BY:	DATE 18-APR-91	.XX .01	.XXX .005	ANG. .5					
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						SHEET NO. 1 OF 1	DRAWING 8	527517		

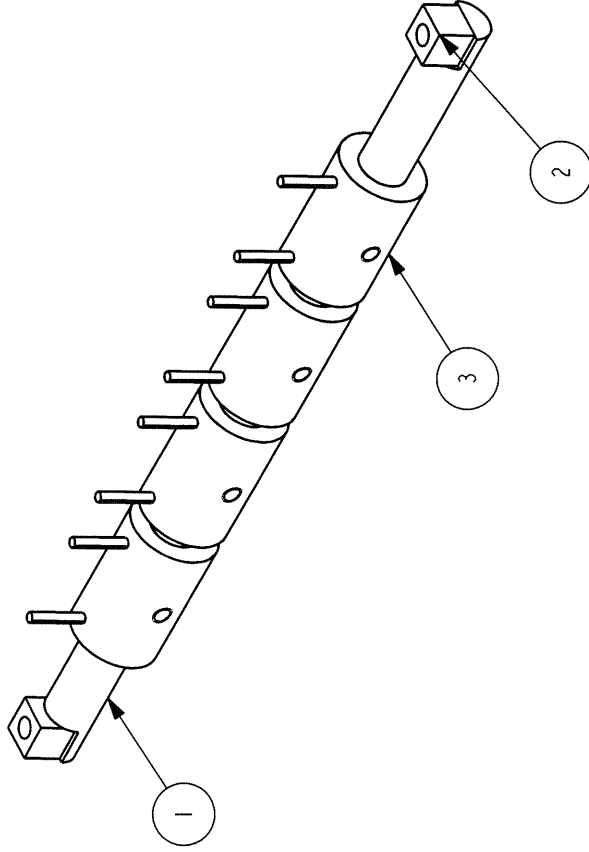
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



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	TRACED BY:	MASTER 	ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY								FINISH: PAINT		

ITEM	QTY	PART #	DESCRIPTION
1	1	527533	SHAFT, BELT GUIDE
2	2	527534	SPACER, BELT GUIDE
3	4	527522-A	ASSY, BELT GUIDE

REV NO	DATE	DESCRIPTION	ECN NO	BY
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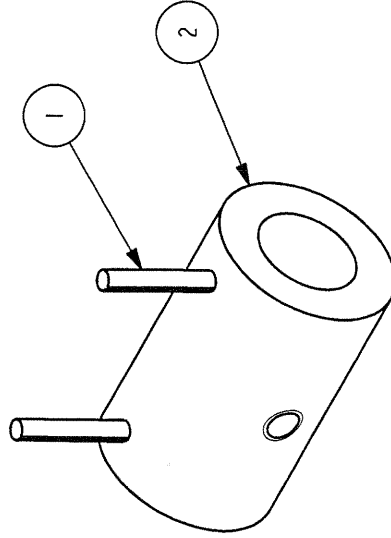


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		TRACED BY:	MASTER			ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY								FINISH:
						TILT			TITLE: ASSY, BELT GUIDE SHAFT					
						1001			SHEET NO.: DRAWING #	538236-01				

527522-A

ITEM	QTY	PART #	DESCRIPTION
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2	1	527522	BELT GUIDE

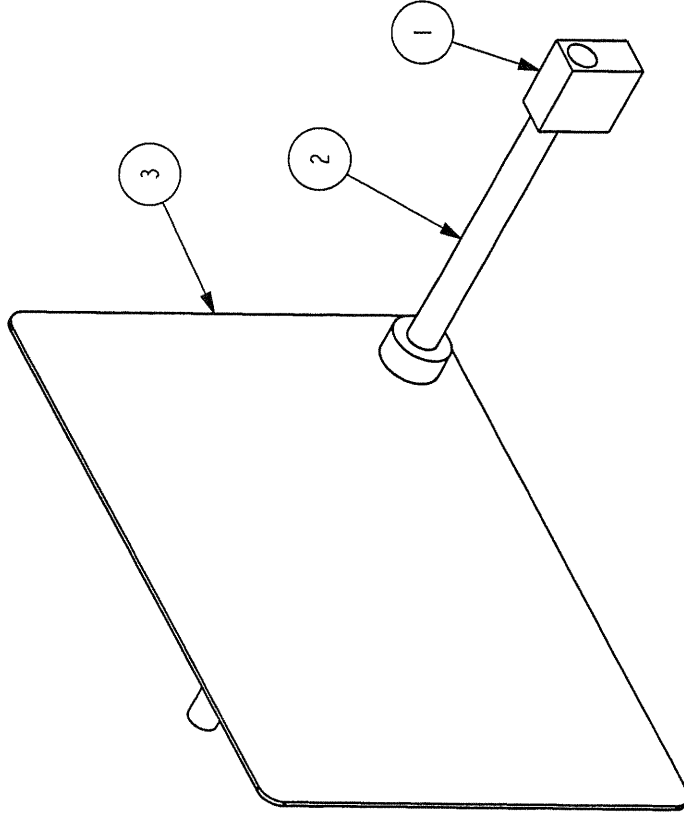
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CHECKED BY:	DATE 01-May-00	.XX .01 XXX .005 ANG. .5			HEAT TREAT: XXX	MODEL: XXX	TITLE: ASSY, BELT GUIDE	
TRACED BY:	MASTER M	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY			FINISH: XXX	SHEET NO. 1 OF 1	DRAWING # 527522-A	

538237-01

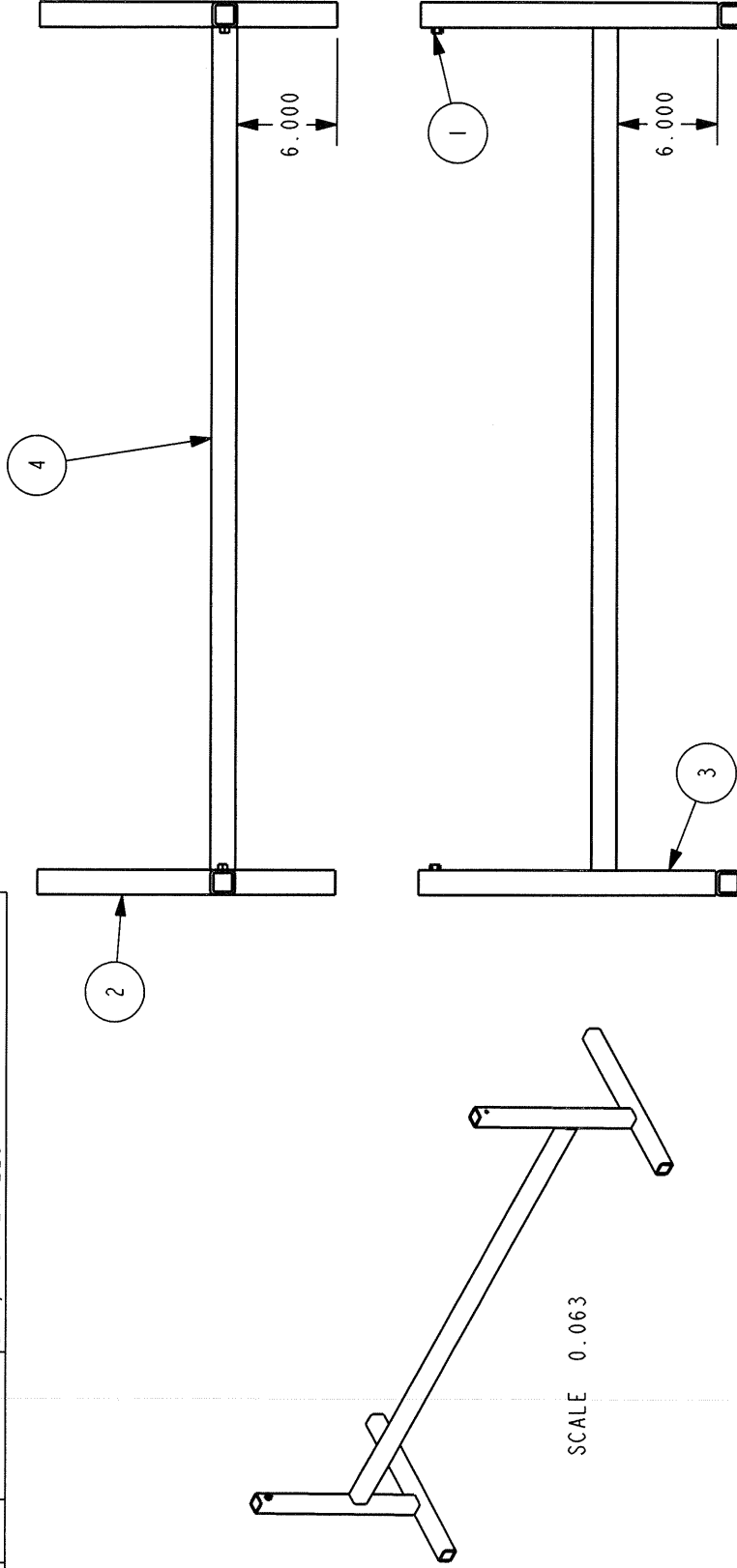
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1	1	527518	MOUNT, STOP PLATE					
2	1	527519	SHAFT, STOP PLATE MOUNT					
3	1	527520A	WLDMNT, STOP PLATE					






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	CHECKED BY: DATE 25-Apr-00	MATERIAL: XXX HEAT TREAT: XXX FINISH: XXX	TILT MODEL: TILT SHEET NO. 1 OF 1	TITLE: ASSY, STOP PLATE				
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ITEM	QTY	PART #	DESCRIPTION
1	2	106702	NUT, 3/8-16
2	2	527527	BAR, FOOT
3	2	527528	LEG, LOWER TELESCOPE
4	1	527532	BAR, HORIZ. LEG

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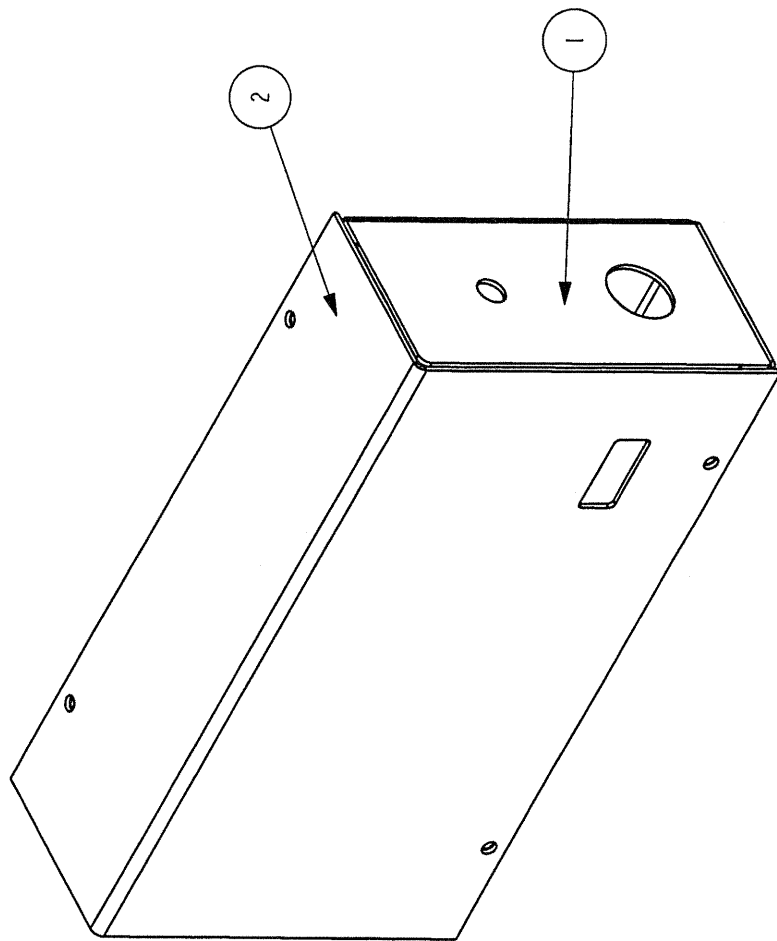
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	.XX		.XXX	ANG.										
	.01		.005	.5										
CHECKED BY:	DATE 25-Apr-00													
TRACED BY:	MASTER 													

TITLE: WLDMNT, TILT CONVEYOR LEGS	DRAWING # 538239-01
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538240-01

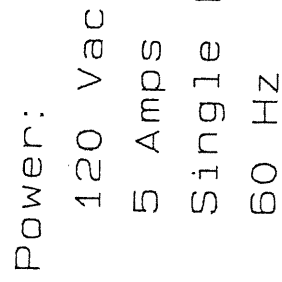
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2	1	536647-01	COVER, ELECTRICAL BOX

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I	TILT
REQ'D	WHERE USED

DRAWN BY: JLG	SCALE 0.500	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED -XX .01 -XX .005 -XX .5	MATERIAL: XXX	THIRD ANGLE PROJECTION 	PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE QUOTED OR REPRODUCED WITHOUT THE WRITTEN PERMISSION OF KIRK-RUDY, INC. KENNESAW, GA 30144 USA	 KIRK - RUDY, INC. KENNESAW, GEORGIA	TILT WHERE USED
	CHECKED BY: DATE 25-Apr-00						
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		FINISH: PAINT	SHEET NO. 10FI	DRAWING # 538240-01	



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Date:	April 25, 1996	Sheet 1 of 1
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16 Bit

Motor:	1/4 H. P.	Motor:	1/2 H. P.
Fuse:	4 AGC	Fuse:	8 AGC
Resistor:	0.05	Resistor:	0.025

Motor: 1/4 H.P.
Fuse: 4 AGC
Resistor: 0.05

8 APPENDIX

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

10 WARRANTY AND SERVICE

WARRANTY

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

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

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

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

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

USE ONLY GENUINE KIRK-RUDY REPLACEMENT PARTS

KIRK-RUDY, INC.

2700 KENNESAW DUE WEST ROAD

KENNESAW, GA. 30144

770-427-4203

FAX 770-427-4036