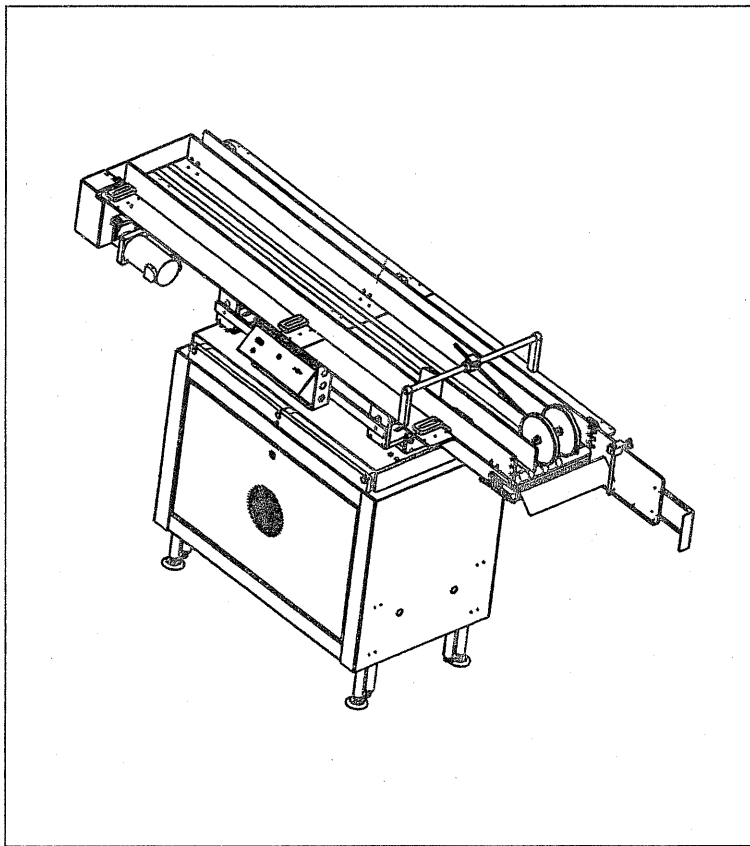


Kirk-Rudy, Inc.

Instruction and Parts Manual KR533 Autoloader



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-KR533 REV. 3 8/9/04

Manual

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

1 Important Safety Instructions

Intended Use Statement: The autoloader has three possible setups: right hand feed to a friction feeder, right hand feed to a shuttle table feeder or inline feed to a shuttle table feeder. Which setup is used is determined by the type feeder in use and characteristics of the product. In all three setups, a beam switch is used to detect a minimum level of product in the feeder hopper and activate a clutch to engage motor driven belts to convey more products into the hopper. To smooth out the autoloading process, a time delay relay is used to keep the clutch engaged momentarily after the product level is the minimum level. A knob on the control panel controls the speed of the autoloader belts. A motor driven jogger can be switched on for right hand feed. Usage for other purposes may lead to an unsafe condition.

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



WARNING

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

2 SPECIFICATIONS

ELECTRICAL REQUIREMENTS

110 VAC, 5 Amp., 60Hz Single Phase

MAXIMUM BELT SPEEDS (Autoloader)

100 FPM

PHYSICAL SIZE (Autoloader)

	<u>ENGLISH</u>	<u>METRIC</u>
Length:	70"	177.8 cm
Width:	20"	50.8 cm
Height: (tabletop)	36.5-42.5"	92.7-107.9 cm
Height Bottom Clearance:	33.38"- 39.38"	84.8-100 cm

PRODUCTS (Autoloader)

MAX: 15"W X 13"L

MIN: 3"W X 3.5"L

OPTIONAL ITEMS (see assembly prints)

544866-01 ASSY, KIT DRIVE ROLLER KR533

544870-01 ASSY, KIT PRODUCT SLIDE KR533

3 INSTALLATION



WARNING

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

3.1 Uncrating and Unpacking

1. Position the crate near the installation site.
2. Remove crate top and sides.
3. Remove plastic cover.
4. Remove metal strapping and securing blocks.
5. Use a forklift to lift machine off skid. Be sure to position the forks in a central location.
6. Machine is on casters and can be rolled into position with the feeder base.

3.2 Accessories and Spare Parts

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

4 MACHINE DESCRIPTION

4.1 Mechanical Component Description (see figure #1)

4.1.1 Hydralift: a storable crank handle is used to elevate or lower the unit. The crank handle activates a pump unit that hydraulically extends and re-tracks legs attached to each corner of the unit. Full extension of the legs lifts the unit approximately six inches. A footpad on the end of each leg can be screwed in or out if necessary for leveling. (see #544850-01)

4.1.2 Hand Crank: the hank crank is used to move the autoloader tabletop left or right. Full movement is approximately six inches. The handle on the hank crank is storable. (see assembly #544561-01)

4.1.3 Hand Wheel: the hand wheel is used to move the autoloader tabletop in and out. Full movement is approximately fifteen inches. Two levers type knobs are used to lock the fore and aft moment in place. (see assembly #537692-10)

4.1.4 Table Tilt: the tabletop can be tilted to 25 degrees. Two lever type knobs, one for each tilt assembly, are use to lock the angle in place. (see assembly #538182-02)

4.1.5 Jogger: a motor driven plate on the outfeed end of the tabletop moves in and out for jogging. Power to the jogger can turned on and off by a switch on the control box. (see diagram 544858-01)

4.1.6 Belts and Belt Takeups: the tabletop has four conveyor belts. A belt takeup is used to control the position and tightness of each belt. The belt takeups are located underneath the infeed end of the tabletop. (see assembly #539325-01)

4.1.7 Drive Roller Assembly: a driver roller assembly controls the shingle during autoloading. It is especially useful from keeping slick product from sliding uncontrollably as the shingle moves downward into the feeder. (see assembly #544866-01)

4.1.8 Product Slide: a plate held in place by two adjustable arms is used to autoloading flimsy product inline to the shuttle feeder. It is not used for a side delivery. Locked in place by two sets of lever knobs, the plate supports the product as the shingle slides into the feeder. The product slide is not used if the product is stiff enough so as not to sag as it shingles into the feeder. (see assembly #544870-01)

4.1.9 Long Side Guide: the long sideguide is used on the right side of the autoloader table top for autoloading the KR 496F friction feeder and the left side for autoloading the KR 215 shuttle feeder. When used in a right hand set up for a KR215 shuttle table feeder, a backstop is attached to provide the shuttle table feeder with a rear guide. A large product rear side guide is attached to the backstop to act as a rear side guide for large products. For smaller products, a small product rear sideguide assembly can be mounted to the backstop.

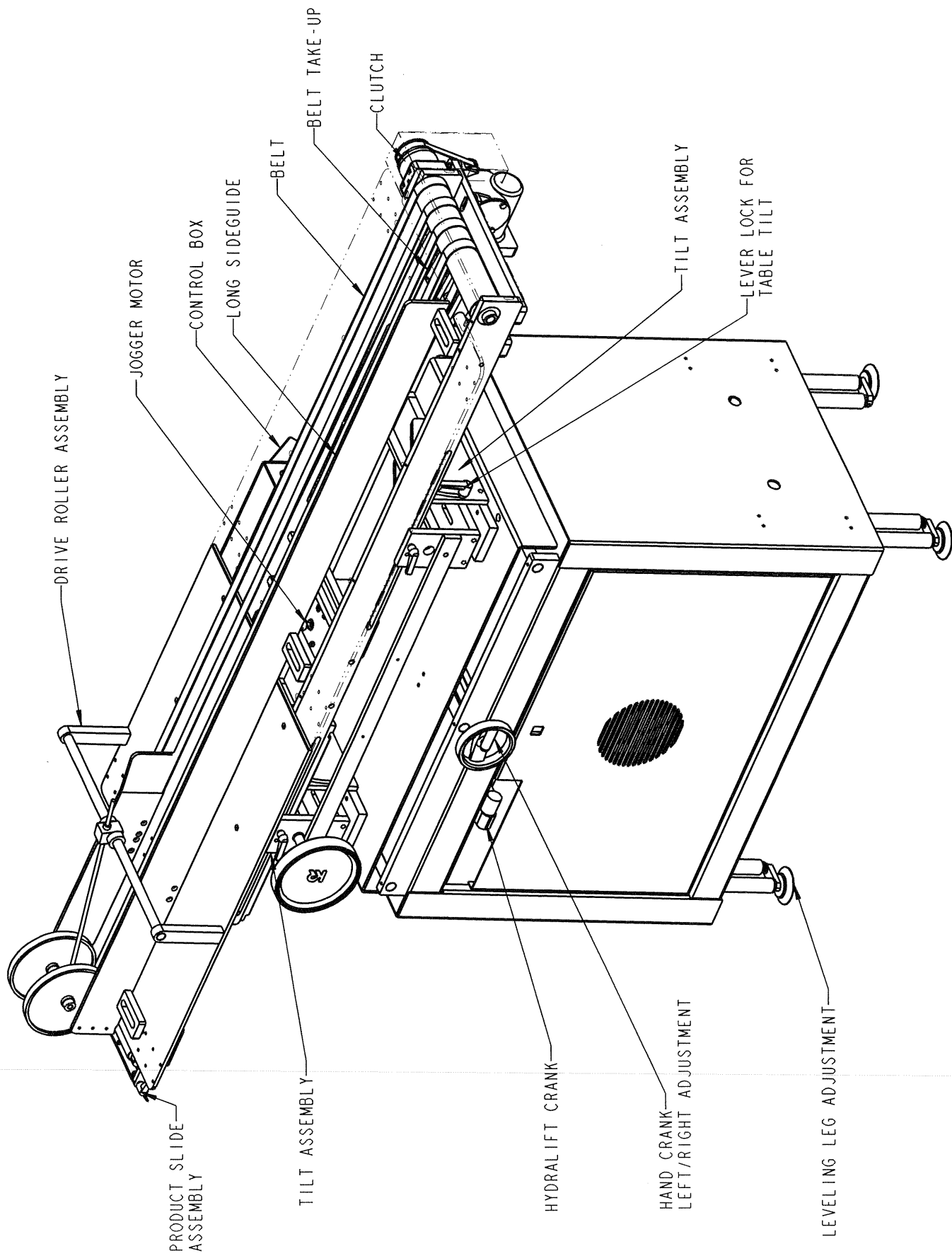
4.1.10 Short Side Guide: the short sideguide is used on the right side of the autoloader tabletop for inline autoloading the KR215 shuttle feeder.

4.2 Electrical Component Description (see figure #1)

4.2.1 Electrical Connection: the electrical cord has a standard 15 amp, 110 volt electrical plug.

4.2.2 Control Box: the control box has an on/off switch that lights up when the power is on, a locking speed control and an on/off switch for the jogger.

4.2.2 Beam Switch and Time Delay Relay: a beam switch is used to control the clutch. When product is not detected by the beam switch, the clutch is engaged to drive the belts. The clutch will stay engaged after the beam switch again detects product until the time set on the relay expires.

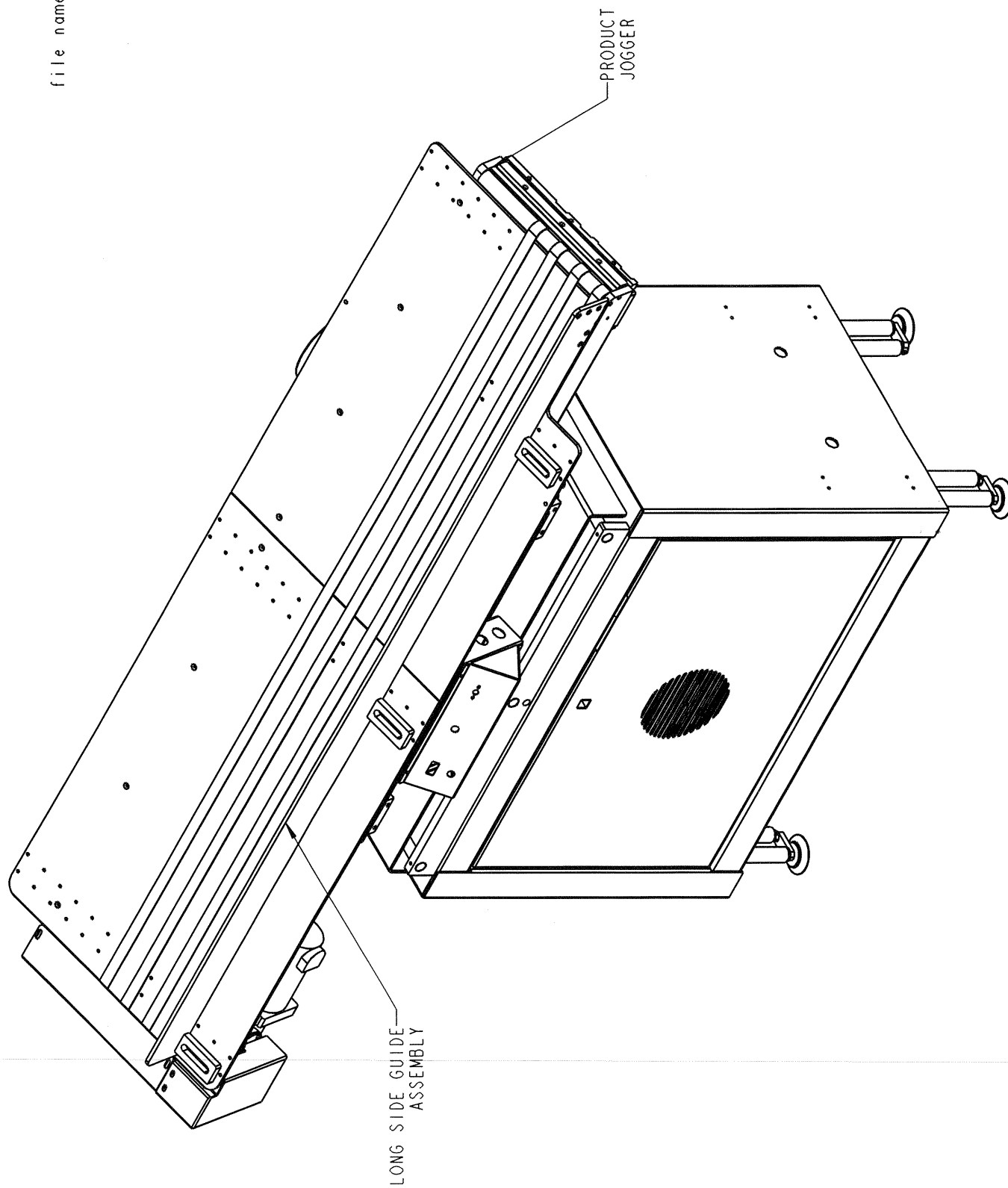


MECHANICAL COMPONENT DESCRIPTION
FIGURE #1

5 OPERATING INSTRUCTIONS

5.1 Set Up for Right Hand KR 496F Feeder (see figure #2)

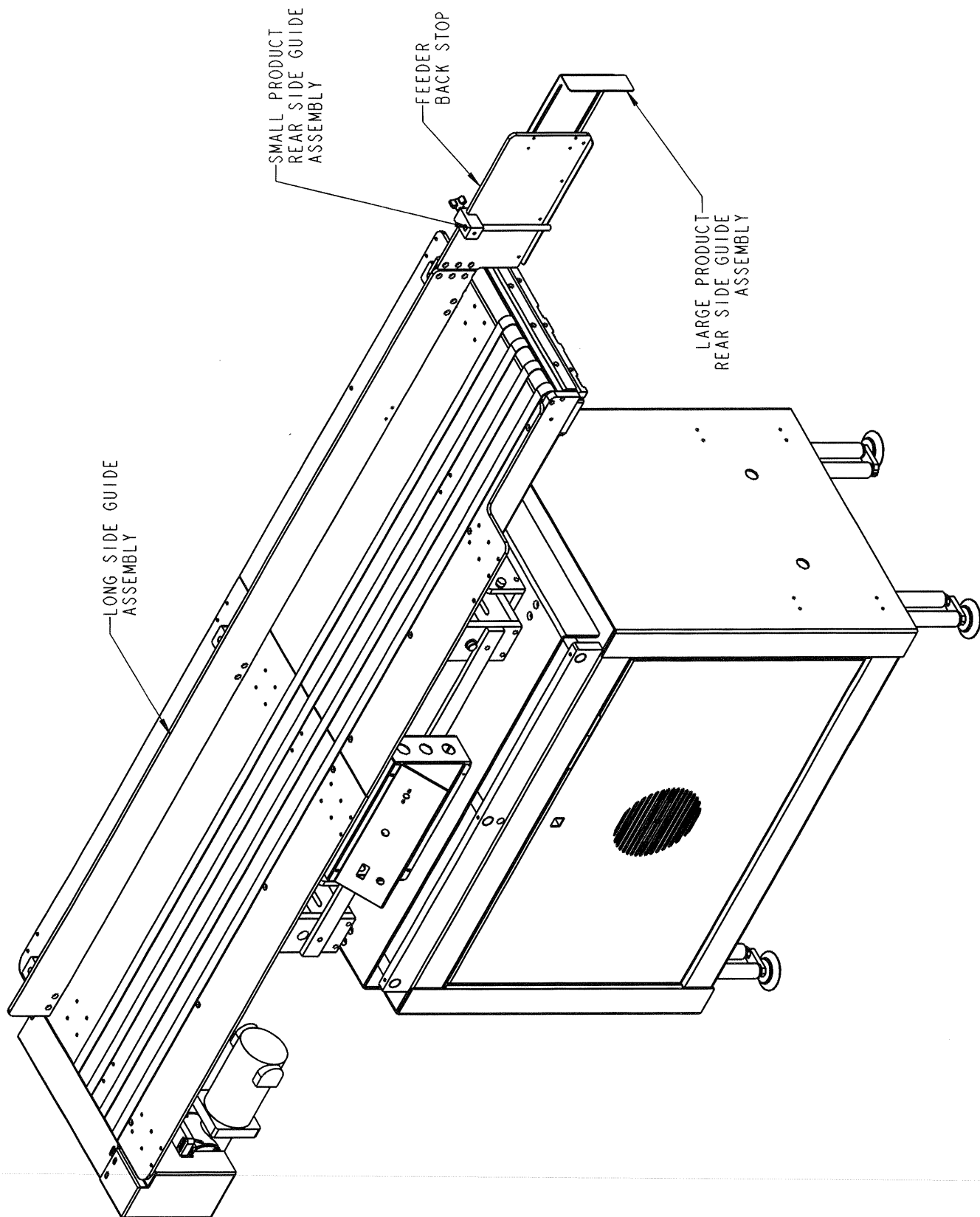
1. Setup and adjust the KR 496 friction feeder on the KR215 for feeding the product. Remove the rear side guides. Remove the left sideguide from the slide block and install the large left sideguide (part #530545-12) provided with the autoloader. Remove the right side guide and leave the product in place for positioning the autoloader.
2. Set the autoloader tabletop in the flat position and move the tabletop completely to the out position using the hand wheel. Crank the left/right hand crank so that the autoloader tabletop is set to mid travel (approximately five cranks from a left or right stop).
3. Roll the autoloader in alignment with the friction feeder and perpendicular to the base. **Important: to be able to adjust from minimum to maximum size product without repositioning the autoloader, the distance between the base of the autoloader and the base of the KR215 should be 14 inches.** The tabletop will move approximately three inches to the right when tilted. Aligning the outside edge of the autoloader tabletop (right side) with the friction feeder bridge will position the edge of the cutout portion of the autoloader tabletop to clear the friction feeder bridge when the tabletop is tilted.
4. Crank the hydalift crank handle clockwise till the unit is fully elevated.
5. Tilt the tabletop fully forward and lock in place using the lever type knobs.
6. Use the handwheel to move the autoloader up to the edge of the product leaving about an eighth of an inch for product to autoload and drop down to the belts during feeding. Lock the in and out movement in place using the two lever type knobs provided.
7. Fine-tune the elevation and angle of the autoloader to match the tabletop of the friction feeder. Lock the angle in place using the lever type knobs on the tilt assembly. Store the hydalift crank handle.
8. Using the clamp type belt guides under the tabletop, set the position and tension of the autoloader tabletop belts to convey the product.
9. Install the long side guide assembly (with out the back stop attachment) on the right side of the autoloader tabletop. **Important: the long side guide assembly should be lined up slightly in front of the front guide of the friction feeder (towards the product in the feeder) in order to keep product from catching on the edge of the front guide when autoloaded into the feeder.**
10. Fill the hopper of the shuttle feeder by hand to the minimum level. Plug in the autoloader. With the autoloader empty, attach the autoloader beamswitch, turn the autoloader on and set at the beamswitch to activate the autoloader at the minimum product level.
11. Turn off the autoloader and remove product from the feeder till the product is just below the minimum level. Load the autoloader with product and turn on. The autoloader should shingle product into the feeder till the beamswitch deactivates the autoloader clutch. Turn on the jogger and check operation.



12. Test feed and adjust the speed of the autoloader belts for smooth autoloading.

5.2 Set Up for Right Hand KR 215 Feeder (see figure #3)

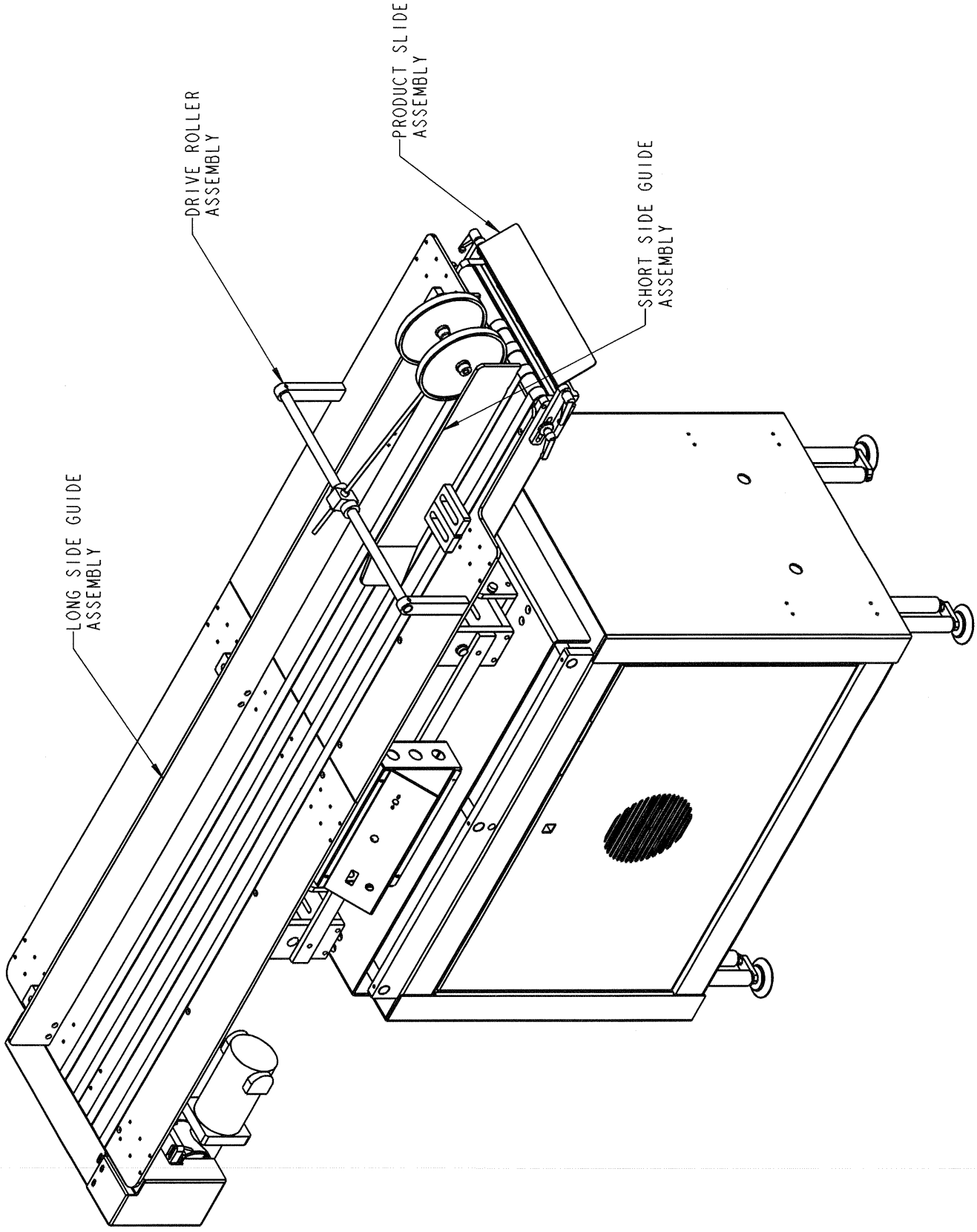
1. Set up and adjust the KR 215 shuttle feeder for feeding the product.
2. Remove the jogging table assembly. Remove the right sideguide assembly by sliding the block off. Remove the slide plates for the right sideguide. Install the bridge plate (part #544771-02) provided with the autoloader. Remove the left sideguide and replace with sideguide assembly #544748-02. Place the midpoint of the product at the midpoint of the feed gate and set the left sideguide to the edge of the product. Leave the product in position for alignment of the autoloader.
3. Set the autoloader tabletop in the flat position and move the tabletop completely to the out position using the hand wheel. Crank the left/right hand crank so that the autoloader tabletop is set to mid travel (approximately five cranks from a left or right stop).
4. Roll the autoloader in alignment with the KR215 feeder and perpendicular to the base. **Important: to be able to adjust from minimum to maximum size product without repositioning the autoloader, the distance between the base of the autoloader and the base of the KR215 should be 14 inches.** The edge of the cutout part of the autoloader table top should be aligned with the bridge plate leaving room for the autoloader to be moved in to the side of the product.
5. Crank the hydalift crank handle till the bottom of the autoloader tabletop clears the top of the KR215 tabletop.
6. Using the handwheel move the autoloader in to the edge of the product leaving about an eighth of an inch for the product to autoload and drop to the shuttle table as it feeds and lock in place. Lock the in and out movement in place using the two lever type knobs provided. Using the left/right hand crank, move the autoloader tabletop to where the cutout is against the bridge plate. Store the handcrank handle.
7. Using the hydalift crank handle, lower the autoloader till the spacers rest on the KR215 tabletop. Store the crank handle.
8. Using the clamp type belt guides under the tabletop, set the position and tension of the autoloader tabletop belts to convey the product.
9. Install the backstop assembly on the long sideguide (see assembly #544863-01). Using a product for spacing, install the long sideguide on the left side of the tabletop. Set either the large rear sideguide or the small rear sideguide assembly, depending on the size of the product, inline with the left sideguide.
10. Fill the hopper of the shuttle feeder by hand to the minimum level. Plug in the autoloader. With the autoloader empty, attach the autoloader beamswitch turn the autoloader on and set at the beamswitch to activate the autoloader at the minimum product level.
11. Turn off the autoloader and remove product from the feeder till the product is just below the minimum level. Load the autoloader with product and turn on. The autoloader should shingle product into the feeder till the beamswitch deactivates the autoloader clutch. Turn on the jogger and check operation.
12. Test feed and adjust the speed of the autoloader belts for smooth autoloading.



KR533 RIGHT HAND KR215 FEED

5.3 Set Up for Inline KR 215 Feeder (see figure #4)

1. Set up and adjust the KR 215 shuttle feeder for feeding the product.
2. Remove the jogging table assembly. Remove the left and right sideguides from the slide blocks and install the left sideguide (assembly #544748-02) and right-angled sideguide (part #500788-28r) provided with the autoloader. Place the midpoint of the product at the midpoint of the feed gate and set the left and right sideguides to the edges of the product. Leave the product in position for alignment of the autoloader.
3. Set the autoloader tabletop in the flat position and move the tabletop completely to the out position using the hand wheel. Crank the left/right hand crank so that the autoloader tabletop is set to mid travel (approximately five cranks from a left or right stop).
4. If the product is flimsy and will not shingle by itself into the feeder, install the product slide (assembly #544870-01) on the outfeed end of the autoloader. If not, rotate the clips outward on the bottom leading edge of the autoloader to act as a backstop for the shuttle feeder.
5. Using the clamp type belt guides under the tabletop, set the position and tension of the autoloader tabletop belts to convey the product.
6. Center a product on the autoloader belts and install the short sideguide on the right side and the long sideguide (see assembly #544772-01), without the backstop assembly on the left side.
7. Install the drive roller assembly.
13. Roll the autoloader in alignment with the KR215 feeder. **Important: to be able to adjust from minimum to maximum size product without repositioning the autoloader, the distance between the base of the autoloader and the base of the KR215 should be 12 1/8 inches.**
8. Crank the hydalift crank handle till the bottom of the autoloader tabletop clears the top of the KR215 tabletop.
9. If not using the product slide, use the handwheel to move the autoloader in to the back edge of the product leaving about an eighth of an inch for the product to autoload and drop to the shuttle table as it feeds and lock in place. Lock the in and out movement in place using the two lever type knobs provided.
10. If using the product slide, remove the product from the feeder and use the handwheel to move the autoloader in till the edge of the product slide is just aft of the feed plate when the plate is in its most rearward position.
11. Using the handcrank, fine-tune the alignment of the autoloader tabletop to the product. Store the hand crank handle.
12. Using the hydalift crank handle, lower the autoloader till the spacers rest on the KR215 tabletop. Store the crank handle.
13. Fill the hopper of the shuttle feeder by hand to the minimum level. Plug in the autoloader. With the autoloader empty, attach the autoloader beamswitch turn the autoloader on and set at the beamswitch to activate the autoloader at the minimum product level.



KR533 INLINE KR215 FEED
FIGURE #4

14. Turn off the autoloader and remove product from the feeder till the product is just below the minimum level. Load the autoloader with product and turn on. The autoloader should shingle product into the feeder till the beamswitch deactivates the autoloader clutch. Adjust the product drive wheel over the bow of the shingle to keep product from sliding into the feeder. Leave the jogger switch off.
15. Test feed and adjust the speed of the autoloader belts for smooth autoloading.

6 MAINTENANCE

1. Check belts for wear and proper tension. Replace belt if necessary.
2. Remove dust from sensor using a soft, clean cloth.
3. Clean the tabletop with a clean, damp cloth and a mild detergent or cleaner.

7 PARTS LIST AND DIAGRAMS

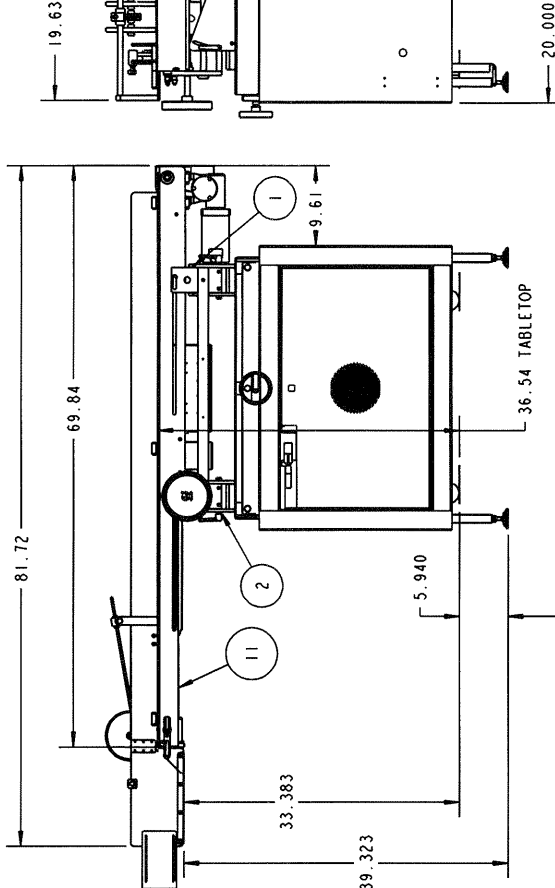
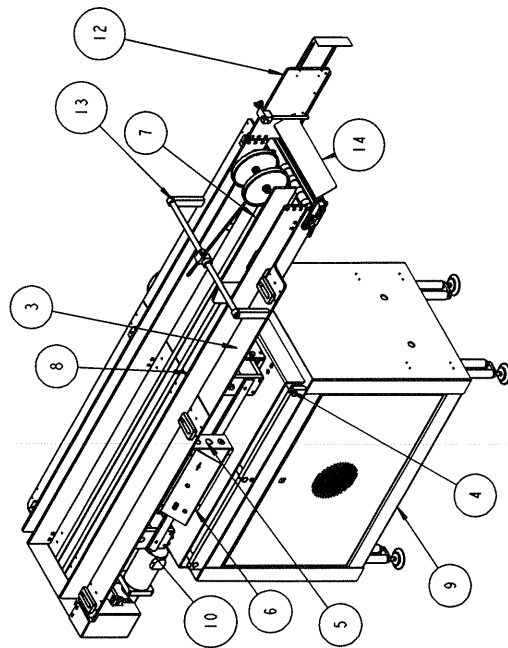
7.1 DIAGRAMS

ASSEMBLY #	DESCRIPTION	PAGES
544737-03	ASSY, KR533+KR215B	6
KR533-3	ASSY, KR533 AUTOLOADER	1
537692-09	ASSY, FRAME SLIDE	1
538182-02	ASSY, ANGLE ADJ. STAND	1
537692-10	ASSY, FRAME SLIDE	1
544561-01	ASSY, KR533 FRAME SLIDE	1
537280-01	ASSY, BUSHING BLOCK	1
544772-01	ASSY, SIDEGUIDES INLINE 215 FEED	1
544774-01	ASSY, SIDEGUIDES 496F FEED	1
544850-01	ASSY, KR533 AUTOLOADER CABINET	1
539424-01	ASSY, RH HYDRALIFT LEG	1
539425-01	ASSY, LH HYDRALIFT LEG	1
544854-03	ASSY, AUTOLOADER FRAMES	1
530676-04	ASSY, DRIVE ROLLER	1
535878-02	ASSY, OUTFD ROLLER	1
539325-01	ASSY, ¾ IN FLAT BELT TAKEUP	1
544858-01	ASSY, JOGGER AUTOLOADER	1
544863-01	ASSY, SIDEGUIDE RH 215 FEED	1
544866-01	ASSY, KIT DRIVE ROLLER KR533	1
544870-01	ASSY, KIT PRODUCT SLIDE KR533	1
SP58900-4	ASSY, 496F FEEDER AUTOLOADER	1
530549-04	ASSY, BACKSTOP 496F AUTOLOAD	1
530887-12	ASSY, BRIDGE 496F	1
544748-02	ASSY, SIDEGUIDE 215 AUTOLOAD	1

KR533-3

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1	1	537692-09	ASSY. FRAME SLIDE
2	1	537692-10	ASSY. FRAME SLIDE
3	2	537695-03	BAR. SLIDE SPACER
4	1	544561-01	ASSY. KR533 FRAME SIDE
5	1	544601-02	BOX. ELECTRICAL CONTROL
6	1	544602-01	COVER. ELECTRICAL CONTROL
7	1	544772-01	ASSY. SIDEGUIDES INLINE 215 FEED
8	1	544774-01	ASSY. SIDEGUIDES 496F FEED
9	1	544850-01	ASSY. KR533 AUTOLOADER CABINET 8"
10	2	544853-01	STRAP. FRAME SLIDE SUPPORT
11	1	544854-03	ASSY. AUTOLOADER FRAMES
12	1	544863-01	ASSY. SIDEGUIDES RH 215 FEED
13	1	544866-01	ASSY. KIT DRIVE ROLLER KR533
14	1	544870-01	ASSY. KIT PRODUCT SLIDE KR533



1	KR533
REV'D	WHERE USED

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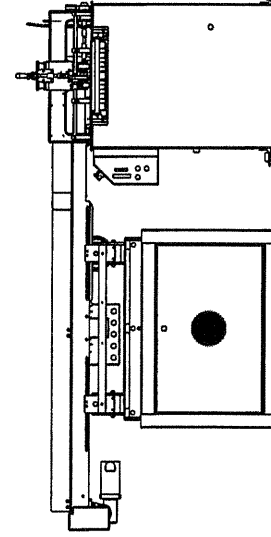
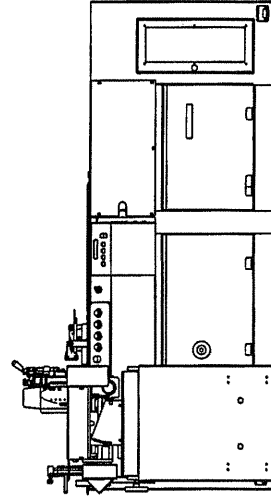
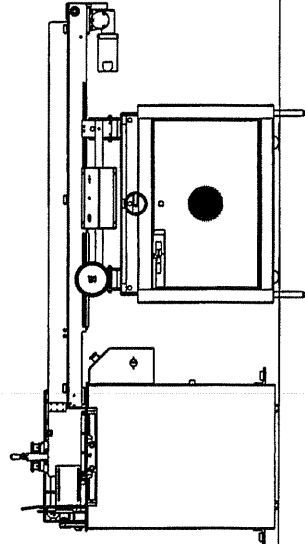
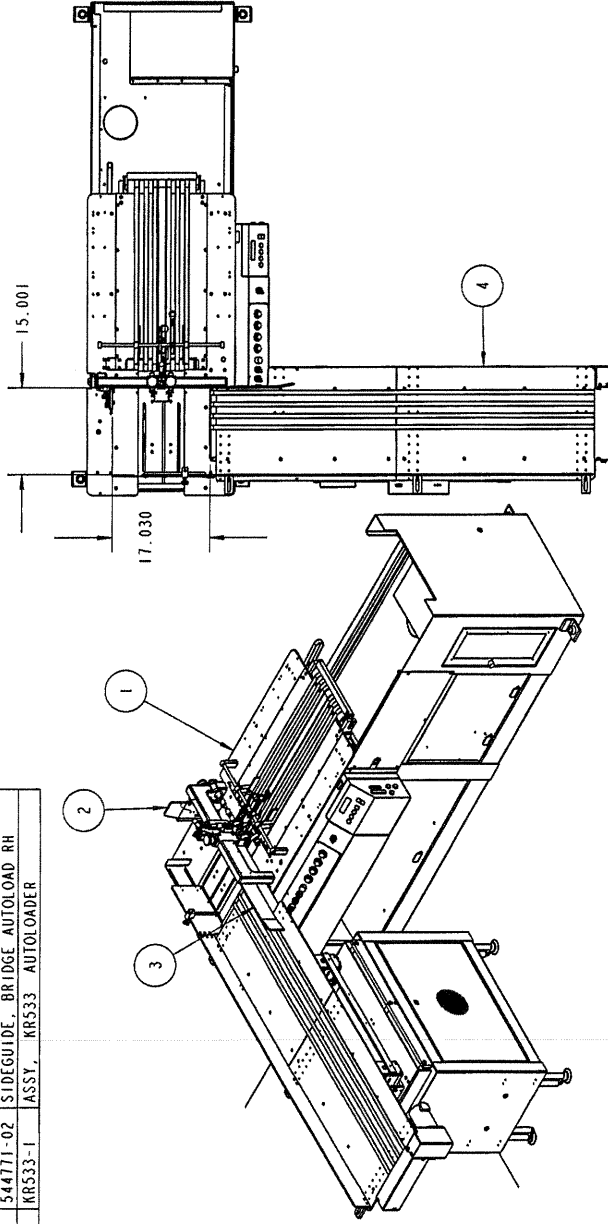
KR533-3

DRAWING 1

544737-03

ITEM QTY	PART #	DESCRIPTION
1	544736-01	ASSY, KR215B
2	544748-02	ASSY, SIDEGUIDE 215 AUTOLOAD
3	544771-02	SIDEGUIDE, BRIDGE AUTOLOAD RH
4	KR533-1	ASSY, KR533 AUTOLOADER

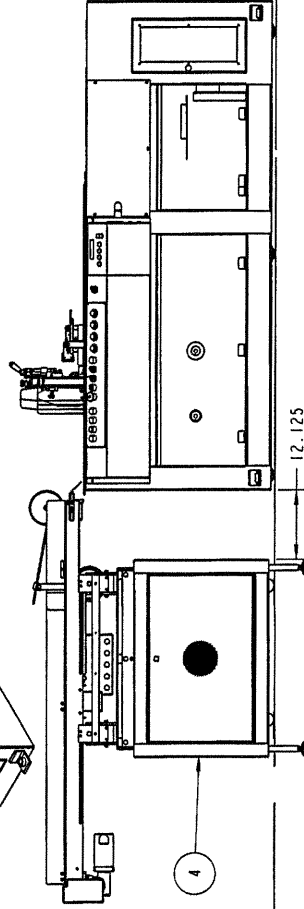
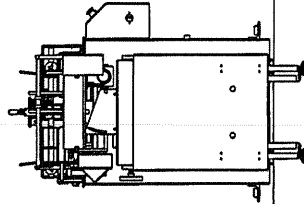
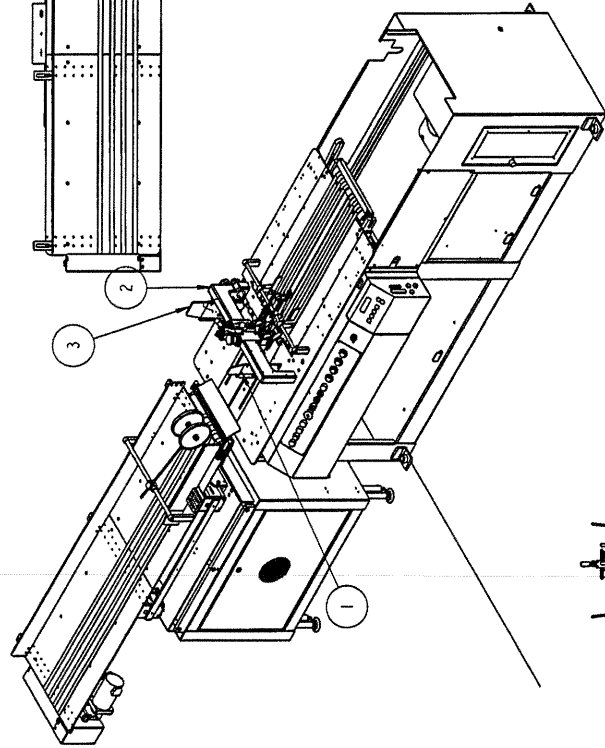
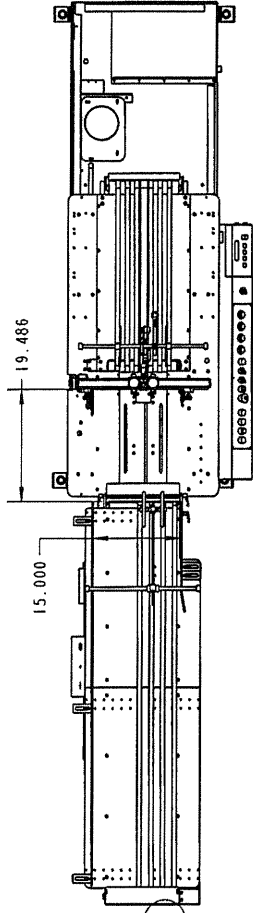
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CHECKED BY:		DATE	10-Oct-03	SCALE	10-Oct-03	SCALE	10-Oct-03	ASSY, KR533+KR215B
THICK BY:		DATE	10-Oct-03	SCALE	10-Oct-03	SCALE	10-Oct-03	544737-03

ITEM QTY	PART #	DESCRIPTION
1	500788-28R	SIDEGUIDE, FEEDER W/AUTO RH
2	544736-01	ASSY, KR215B
3	544748-02	ASSY, SIDEGUIDE 215 AUTOLOAD
4	KR533-1	ASSY, KR533 AUTOLOADER

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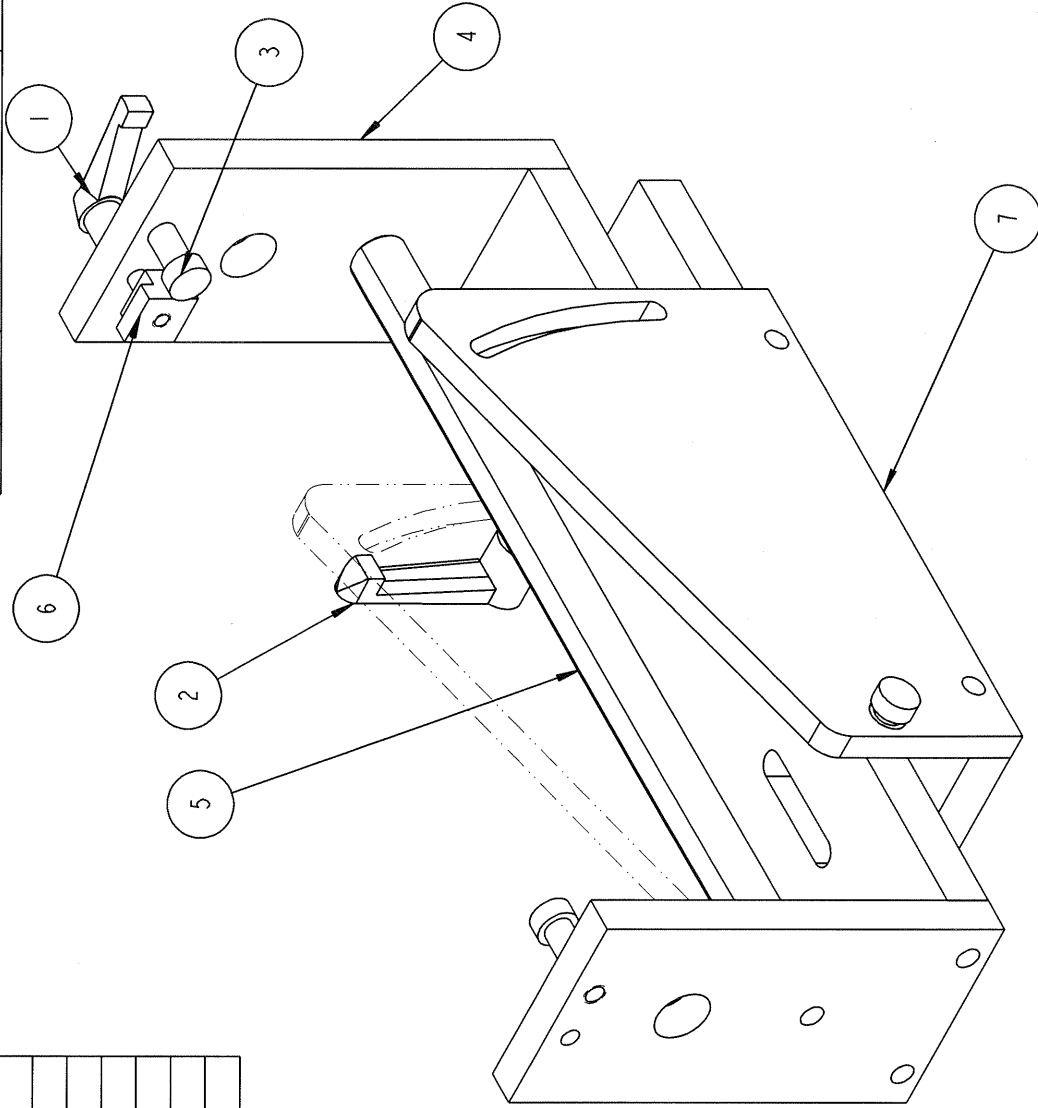


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KIRK - RUDY, INC. WOODSTOCK, GEORGIA	544737-03
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1	1	102140	HANDLE, RELEASE 1/4-20 X 1.0
2	1	102149	HANDLE, RELEASE 5/16-18 X 1.26
3	2	107204	BOLT, SHOULDER 3/8X5/8
4	2	537693-05	PLATE, FRAME UPRIGHT SA287-1
5	1	537694-01	SHAFT, SPACER AUTOL MNT.
6	1	537700-01	CLAMP, T-SLOT
7	1	538182-02	ASSY, ANGLE ADJ. STAND

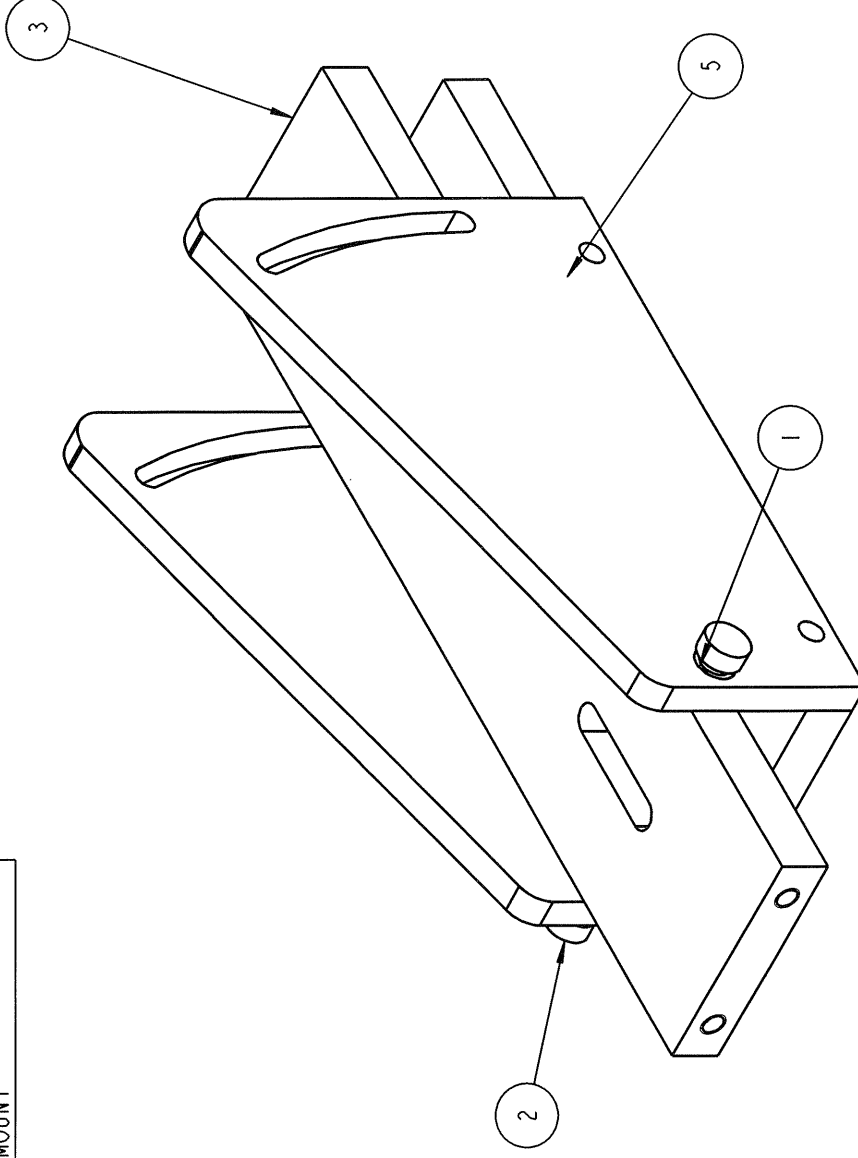
REV NO	DATE	DESCRIPTION	ECN NO	BY
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DRAWN BY: JMW	SCALE 0.438	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED			MATERIAL: XXX	THIRD ANGLE PROJECTION 	PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE QUOTED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC. WOODSTOCK, GA 30188 USA	 KIRK - RUDY, INC. WOODSTOCK, GEORGIA	I SA237	WHERE USED REQ'D
		.XX	.XXX	ANG.						
CHECKED BY:	DATE 06-Aug-04	.01	.005	.5	HEAT TREAT: XXX	MODEL: SA237-1	TITLE: ASSY, FRAME SLIDE			
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	DRAWING # 537692-09			

ITEM	QTY	PART #	DESCRIPTION
1	2	100101	BUSHING, SL.375ID.500OD.375LG
2	2	107206	BOLT, SHOULDER 3/8X1 1/2
3	1	537695-01	BAR, SLIDE BASE
4	1	538180-02	PLATE, BOTTOM MOUNT
5	2	538181-02	BAR, BEARING MOUNT

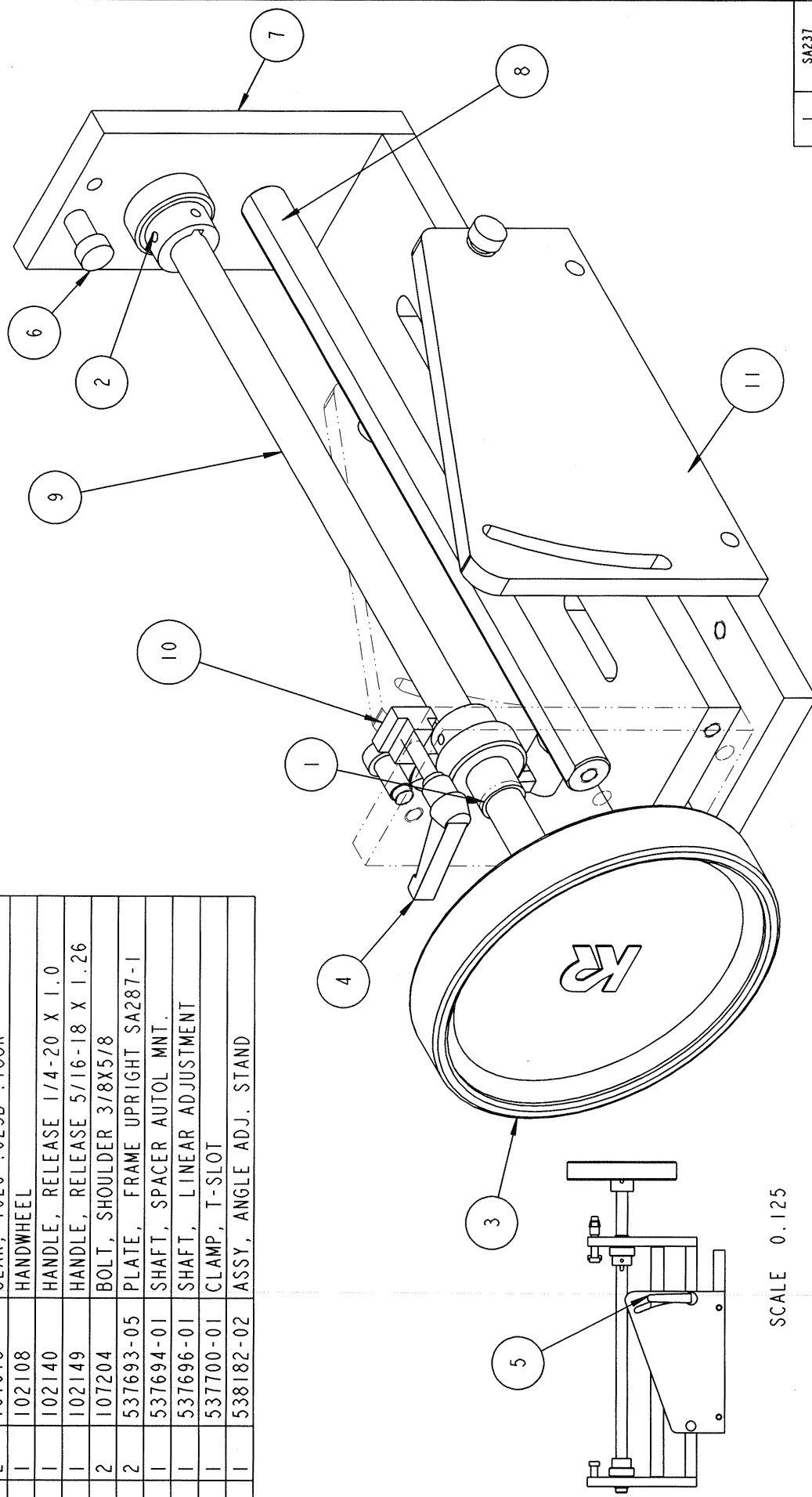
REV NO	DATE	DESCRIPTION	ECN NO	BY
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DRAWN BY: PEB	SCALE 0.500	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED		MATERIAL: XXX	THIRD ANGLE PROJECTION 	PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE QUOTED OR REPRODUCED WITHOUT THE WRITTEN PERMISSION OF KIRK-RUDY, INC. WOODSTOCK, GA 30188 USA	KIRK - RUDY, INC. WOODSTOCK, GEORGIA	2	SA237	REQ'D	WHERE USED
		.XX	.XXX								
CHECKED BY:	DATE 02-Sep-03	.01	.005	HEAT TREAT: XXX	MODEL: SA237	TITLE: ASSY, ANGLE ADJ. STAND					
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. 10F1	DRAWING # 538182-02					

ITEM	QTY	PART #	DESCRIPTION
1	2	100144	BUSHING, SL.625ID.7500D.625LG
2	2	101913	GEAR, 1620 .625B .188K
3	1	102108	HANDWHEEL
4	1	102140	HANDLE, RELEASE 1/4-20 X 1.0
5	1	102149	HANDLE, RELEASE 5/16-18 X 1.26
6	2	107204	BOLT, SHOULDER 3/8X5/8
7	2	537693-05	PLATE, FRAME UPRIGHT SA287-1
8	1	537694-01	SHAFT, SPACER AUTOL MNT.
9	1	537696-01	SHAFT, LINEAR ADJUSTMENT
10	1	537700-01	CLAMP, T-SLOT
11	1	538182-02	ASSY, ANGLE ADJ. STAND

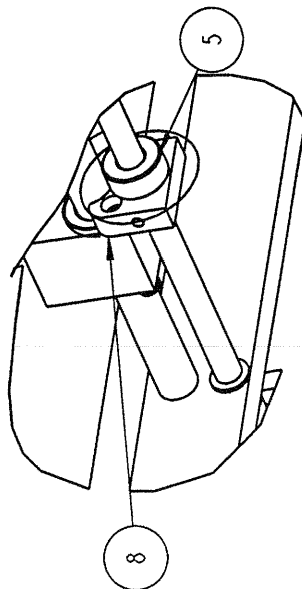
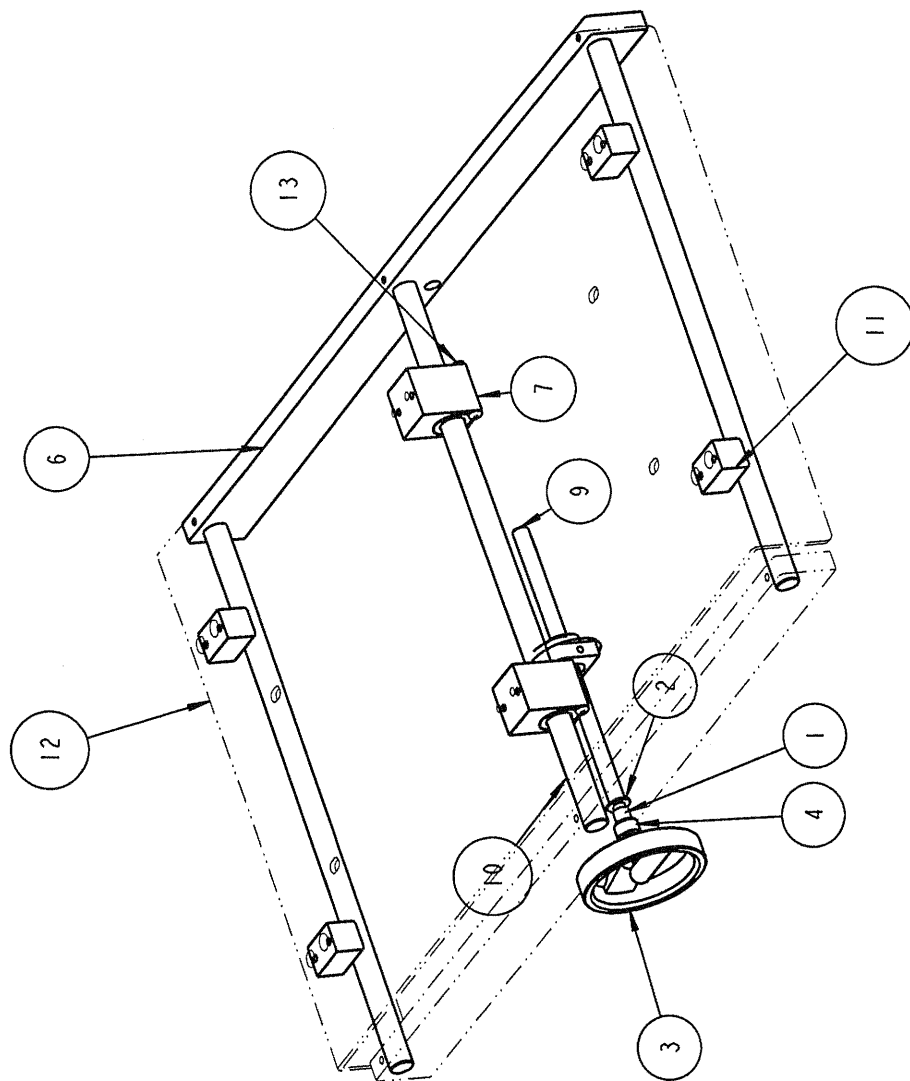
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SCALE 0.125

DRAWN BY: JMW	SCALE 0.438	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED			MATERIAL: XXX	THIRD ANGLE PROJECTION 	 KIRK - RUDY, INC. WOODSTOCK, GEORGIA	I SA237	WHERE USED		
	CHECKED BY: DATE 27-Aug-03	.XX .01	.XXX .005	ANG. .5							
		TRACED BY: MASTER	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED			HEAT TREAT: XXX				MODEL: SA237-1	TITLE: ASSY, FRAME SLIDE
			ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY								
								537692-10			

ITEM	QTY	PART #	DESCRIPTION
1	1	100302	BUSHING, FL. 375ID. 5000D. 500LG
2	1	100402	WASHER, THRUST TB612
3	1	102139	HANDWHEEL, FOLD AWAY
4	1	102200	COLLAR .375
5	1	109836	ACME NUT, 1/2 - 2
6	2	537277-03	PLATE, SLIDE SHAFT MOUNT
7	2	537280-01	BUSHING BLOCK ASY
8	1	537281-01	PLATE, NUT MOUNT
9	1	537282-01	ROD, ACME THREADED SLIDE ADJ
10	3	537309-04	SHAFT, SLIDE
11	4	537311-01	BLOCK, SLIDE
12	1	544562-01	PLATE, AUTOLOADER SLIDE
13	3	CSFF63	SCREW, BUTTON HEAD 1/4X.250

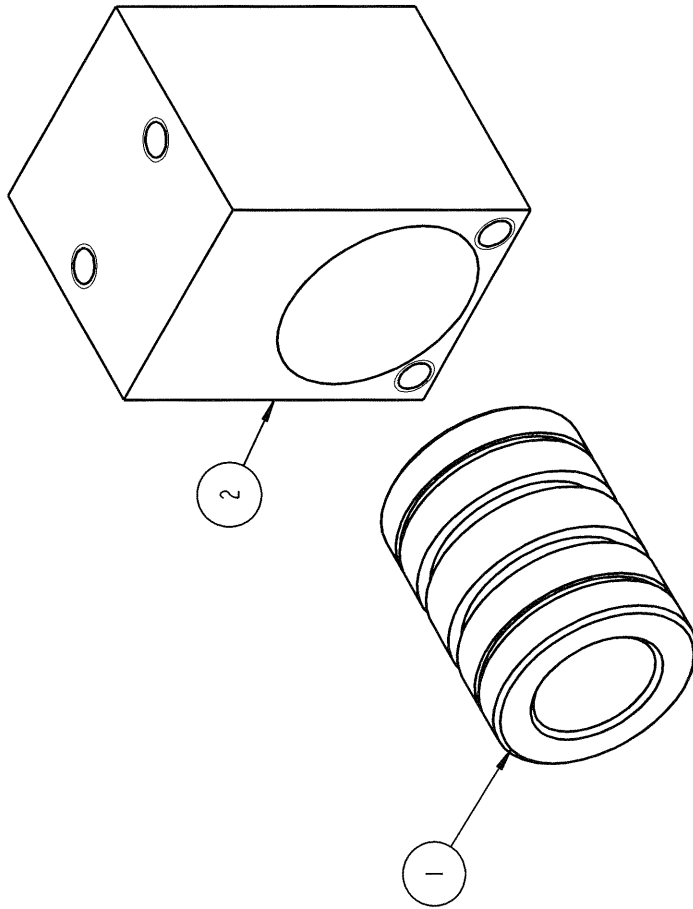




1	SA237
REQ'D	WHERE USED

DRAWN BY: TJG	SCALE 0.185	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED		MATERIAL: N/A	THIRD ANGLE PROJECTION 	PROPRIETARY AND CONFIDENTIAL NO PART OF THIS DOCUMENT MAY BE COPIED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC. WOODSTOCK, GA 30188 USA	 KIRK - RUDY, INC. WOODSTOCK, GEORGIA
CHECKED BY:	DATE 09-Sep-03	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED		HEAT TREAT: N/A	MODEL: SA237	TITLE: ASSY, KR533 FRAME SIDE	
TRACED BY:	MASTER 	ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY		FINISH: N/A	SHEET NO.: 1 OF 1	DRAWING # 544561-01	

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

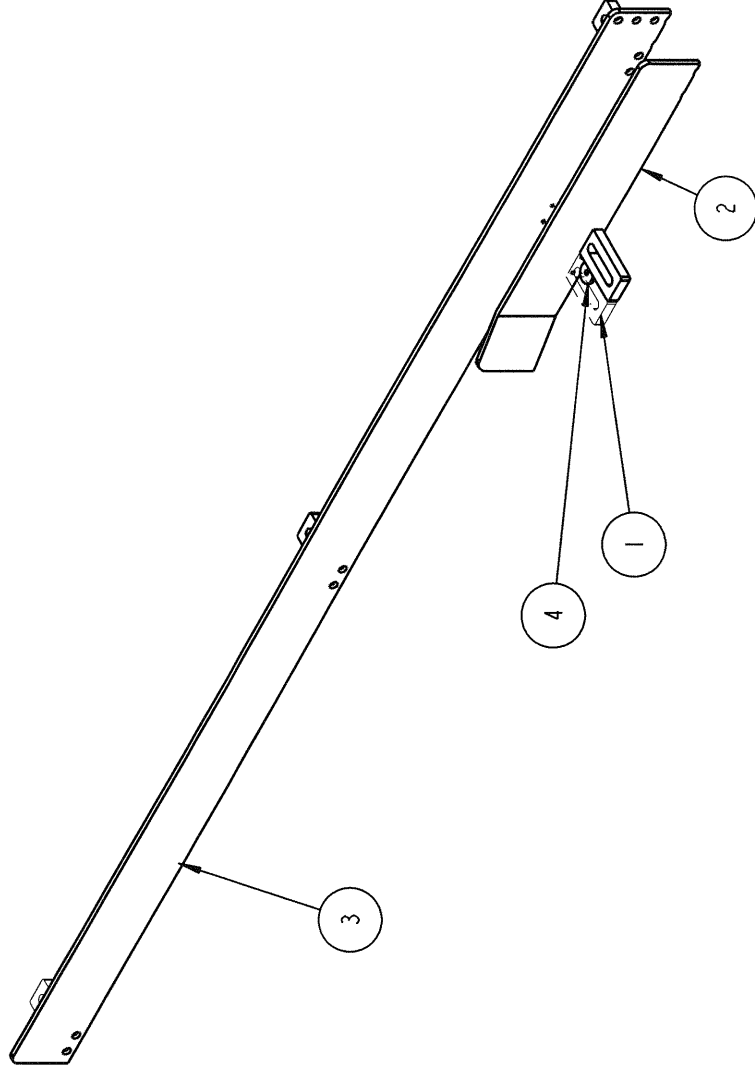
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DRAWN BY: A KEY	SCALE 1.000	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED		MATERIAL: N/A	THIRD ANGLE PROJECTION 	PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE QUOTED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC. WOODSTOCK, GA 30188 USA	 KIRK - RUDY, INC. WOODSTOCK, GEORGIA	2	SP76300
	CHECKED BY: 08-0c+-99	DATE	DATE					REQ'D	WHERE USED
TRACED BY:	MASTER	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY		HEAT TREAT: N/A	MODEL: 535	TITLE: BUSHING BLOCK ASY			
				FINISH: N/A	SHEET NO. 1 OF 1	DRAWING # 537280-01			

ITEM	QTY	PART #	DESCRIPTION
1	5	508737-7	BRACKET
2	1	537603-09	SIDEGUIDE, PRODUCT RH
3	1	537603-10	SIDEGUIDE, PRODUCT LH
4	5	SP6383-1	SPACER, GEAR COVER

REV NO	DATE	DESCRIPTION	ECN NO	BY
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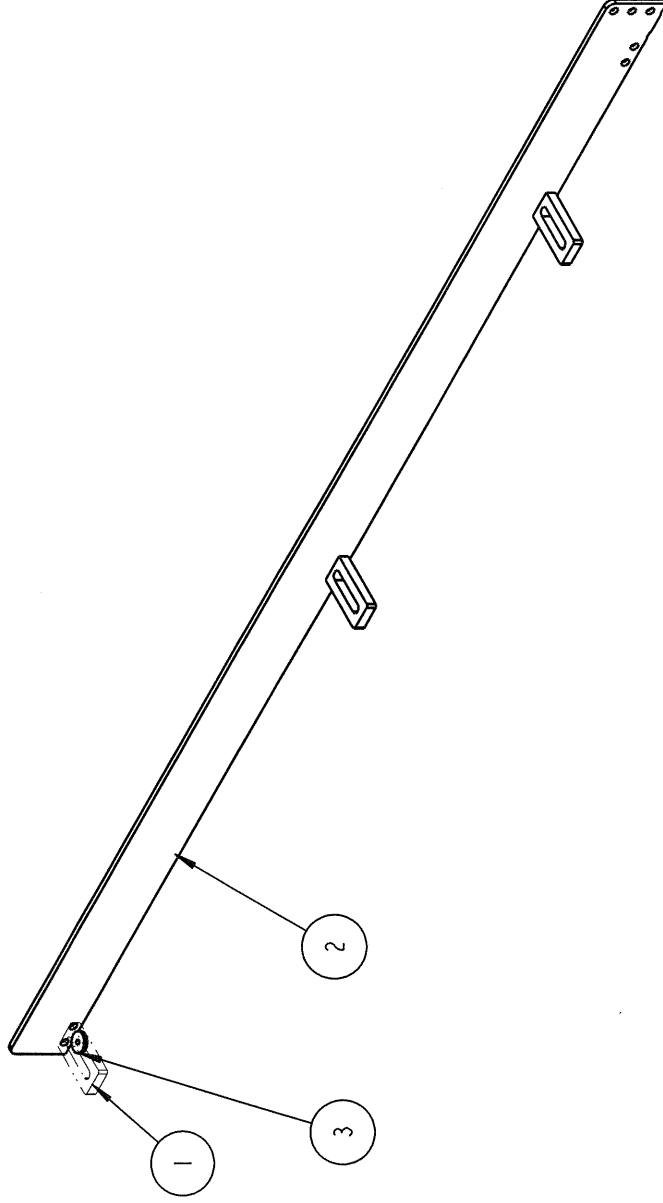


NOTES:
1. USE FOR INLINE AUTOLOADING KR215.

DRAWN BY: TJG		SCALE 0.125		DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED			MATERIAL: XXX	THIRD ANGLE PROJECTION 	 KIRK - RUDY, INC. WOODSTOCK, GEORGIA	I KR533	REQ'D WHERE USED	
				.XX .01								.XX .005
CHECKED BY:		DATE 24-Oct-03		REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED			HEAT TREAT: XXX	MODEL: KR533	TITLE: ASSY, SIDEGUIDES INLINE 215 FEED	PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE QUOTED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC. WOODSTOCK, GA 30188 USA		
TRACED BY:		MASTER		ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY			FINISH: XXX					SHEET NO.: 1 OF 1



ITEM	QTY	PART #	DESCRIPTION
1	3	508737-7	BRACKET
2	1	537603-10	SIDEGUIDE, PRODUCT LH
3	3	SP6383-1	SPACER, GEAR COVER

REV NO	DATE	DESCRIPTION	ECN NO	BY
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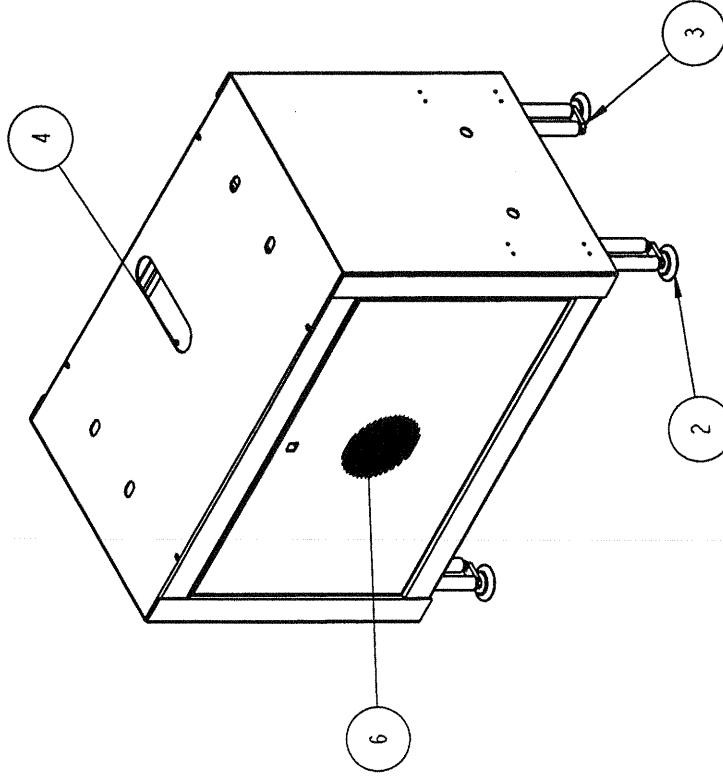
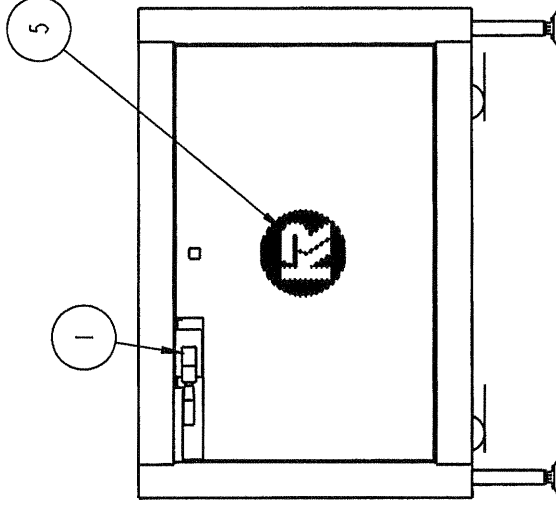
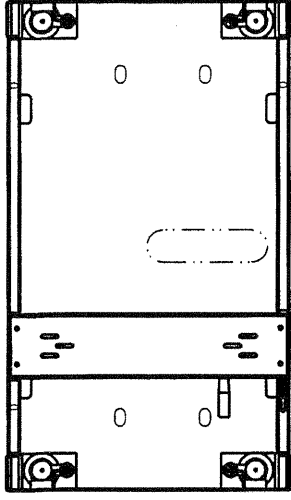
NOTES:

1. USE FOR RIGHT HAND 496F ON KR215 AUTOLOADING.

DRAWN BY: TJG	SCALE 0.125	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. WOODSTOCK, GA 30188 USA	 KIRK - RUDY, INC. WOODSTOCK, GEORGIA	I KR533	REQ'D WHERE USED
	CHECKED BY:	DATE 24-Oct-03	FINISH: XXX						
TRACED BY:	MASTER	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY		HEAT TREAT: XXX	SHEET NO. 1 OF 1	DRAWING 1	544774-01		

ITEM	QTY	PART #	DESCRIPTION
1	1	191029-1	PUMP, MOVOTEC PB4612FC
2	2	539424-01	ASSY, RH HYDRALIFT LEG
3	2	539425-01	ASSY, LH HYDRALIFT LEG
4	1	544851-01	WDMNT, KR533 AUTOLOADER CABINET
5	1	544873-01	DOOR, DROPOUT KR533
6	1	544874-01	DOOR, DROPOUT KR533

REV NO	DATE	DESCRIPTION	ECN NO	BY
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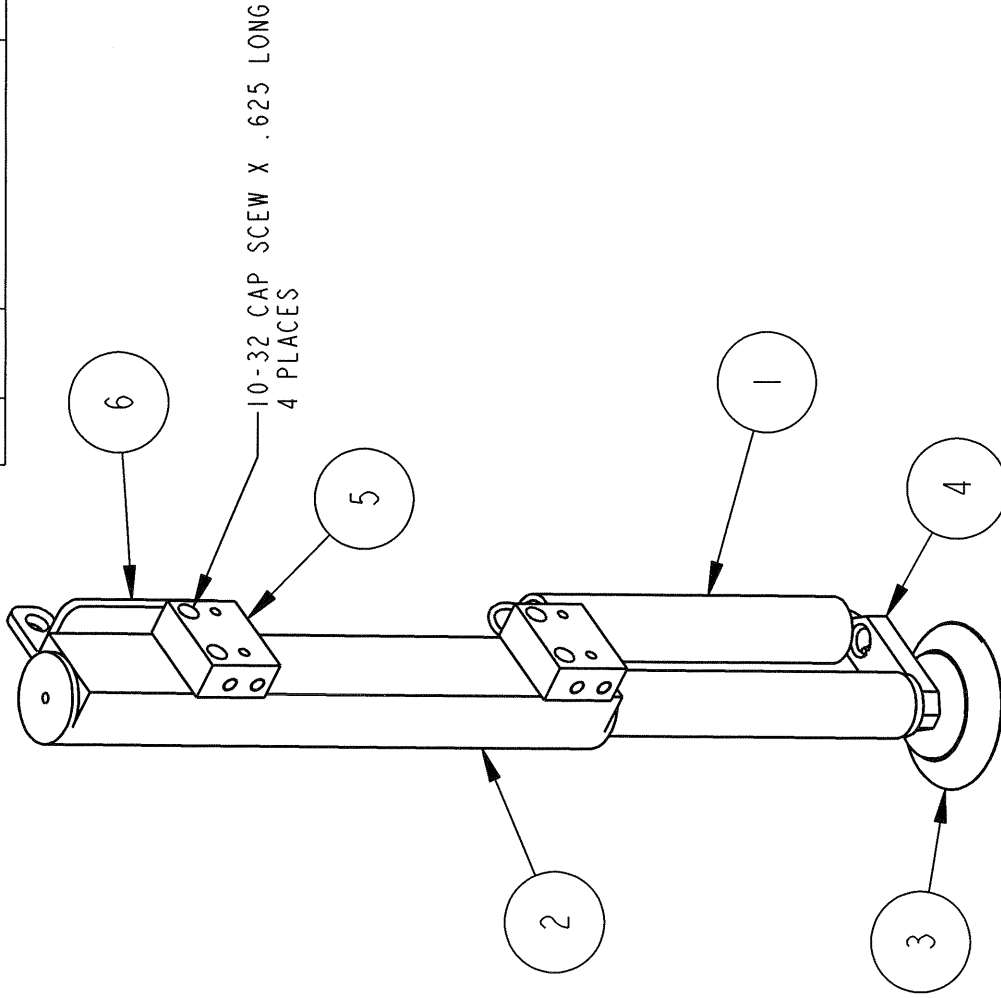


1	SA237
REQ'D	WHERE USED



DRAWN BY: TJG	SCALE 0.080	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED		MATERIAL: XXX	THIRD ANGLE PROJECTION 	PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE LOANED, REPRODUCED OR COPIED IN ANY MANNER WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC. WOODSTOCK, GA 30188 USA	 KIRK - RUDY, INC. WOODSTOCK, GEORGIA
CHECKED BY:	DATE 11-Nov-03	.XX -01	.XXX -005	ANG. -5			
TRACED BY:	MASTER 	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED		HEAT TREAT: XXX	MODEL: KR533	TITLE: ASSY, KR533 AUTOLOADER CABINET	DRAWING # 544850-01
		ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY		FINISH: XXX			

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

REV NO	DATE	DESCRIPTION	ECN NO	BY
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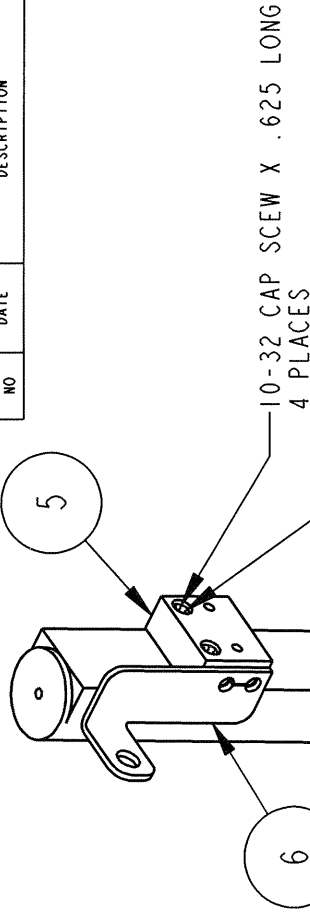


2	SP84700	WHERE USED
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DRAWN BY: A KEY	SCALE 0.375	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED			MATERIAL: N/A	 THIRD ANGLE PROJECTION	 KIRK - RUDY, INC. WOODSTOCK, GEORGIA	PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE QUOTED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC. WOODSTOCK, GA 30188 USA		
		.XX .01	.XXX .005	ANG. -5						
CHECKED BY:	DATE 26-Jul-00	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED			HEAT TREAT: N/A	MODEL: SP84700	TITLE: ASSY, RH HYDRA LIFT LEG			
TRACED BY:	MASTER	ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY			FINISH: N/A					

ITEM	QTY	PART #	DESCRIPTION
1	1	102792	SPRING, EXTENSION
2	1	191029-2	CYLINDER, LIFT CB415
3	1	191029-3	GLIDE, SUSPA
4	1	537371-01	BRACKET, SPRING RETURN MOUNT
5	2	537596-01	BLOCK, HYDRAULIC LIFT LH
6	1	537597-02	BRACKET, HYDRAULIC LIFT SPRING
7	2	CSDD266	SCREW, SHCS 10-32X.625

REV NO	DATE	DESCRIPTION	ECN NO	BY
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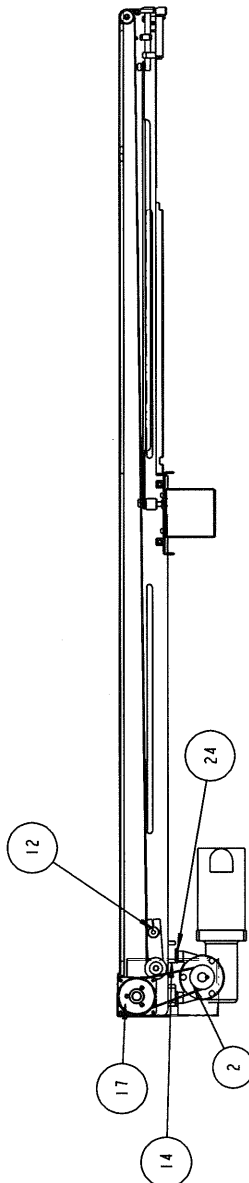
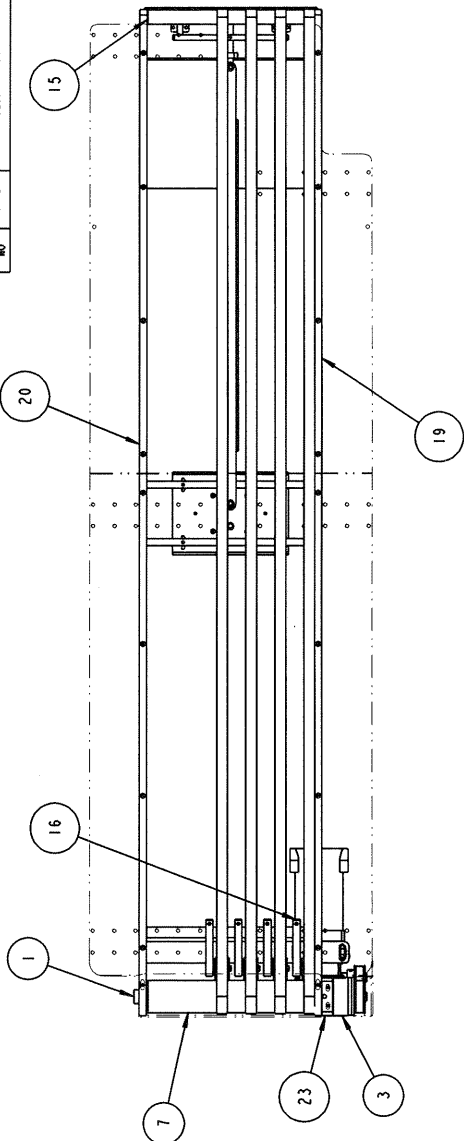


DRAWN BY: A KEY	SCALE 0.375	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	MATERIAL: N/A			THIRD ANGLE PROJECTION 	PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE REPRODUCED OR TRANSMITTED IN ANY FORM WITHOUT THE WRITTEN PERMISSION OF KIRK-RUDY, INC. WOODSTOCK, GA 30188 USA	 KIRK - RUDY, INC. WOODSTOCK, GEORGIA	2 SP84700 REQ'D WHERE USED
	DATE 26-Jul-00		HEAT TREAT: N/A	FINISH: N/A	MODEL: SP84700				
CHECKED 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 # 539425-01			

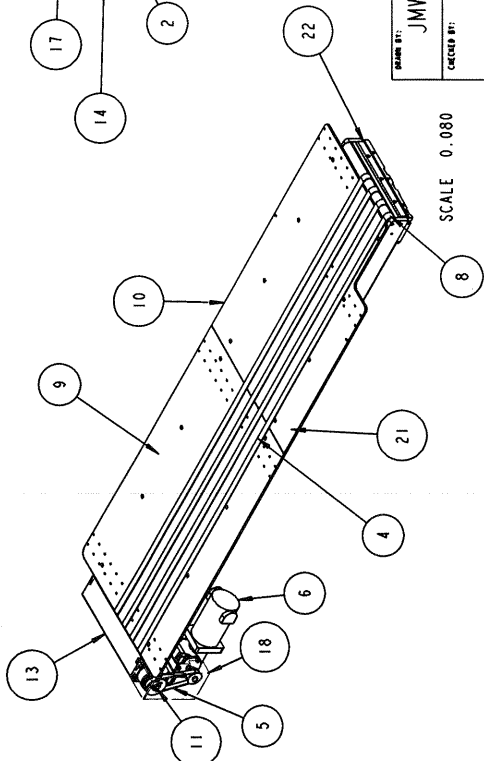
544854-03

REV	DATE	DESCRIPTION	ECN	BY

ITEM	QTY	PART #	DESCRIPTION
1	2	103804	BEARING, HUB .625
2	1	108873	PULLEY, TIMING 12L050 .625B .188K
3	1	202217	ELECTROID CLUTCH 201-467-8100
4	4	105987-9	BELT, FLAT 140.75 X 3/4
5	1	108916-29	BELT, TIMING 150L050
6	1	200170-2	MOTOR, 1/8HP DC GEAR
7	1	530676-04	ASSY, DRIVE ROLLER
8	1	535878-02	ASSY, OUTFD ROLLER
9	1	536591-05	TABLETOP, AUTOLOADER
10	1	536594-06	TABLETOP, AUTOLOADER
11	1	536595-02	SHAFT, CONVEYOR DRIVE
12	1	536599-01	SHAFT, SPACER CONVEYOR
13	1	537607-02	COVER, REAR ROLLER DRIVE
14	2	537697-02	PLATE, MOTOR MOUNT
15	1	538104-01	SHAFT, ROLLER OUTFD
16	4	539325-01	ASSY, 3/4 IN FLAT BELT TAKEUP
17	1	541061-01	PULLEY, TIMING 18L050 CLUTCH
18	1	544768-01	WLDMT, COVER BELT CLUTCH
19	1	544856-05	FRAME, CONVEYOR RH - RACK UP
20	1	544856-06	FRAME, CONVEYOR LH RACK UP
21	2	544857-02	RACK, RA16 GEAR SAZ87-1 AUTOLOADER
22	1	544858-01	ASSY, JOGGER AUTOLOADER
23	1	SP49715-1	PLATE CLUTCH
24	4	SP6383-1	SPACER, GEAR COVER



SCALE 0.125



SCALE 0.080

NAME BY: JMW	SCALE: 0.060	DATE: 06-Aug-04	MASTER
CHECKED BY:			
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TRACED BY:			

DATE: 06-Aug-04	SCALE: 0.060	DATE: 06-Aug-04	MASTER
CHECKED BY:			
TRACED BY:			

DATE: 06-Aug-04	SCALE: 0.060	DATE: 06-Aug-04	MASTER
CHECKED BY:			
TRACED BY:			

DATE: 06-Aug-04	SCALE: 0.060	DATE: 06-Aug-04	MASTER
CHECKED BY:			
TRACED BY:			

DATE: 06-Aug-04	SCALE: 0.060	DATE: 06-Aug-04	MASTER
CHECKED BY:			
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DATE: 06-Aug-04	SCALE: 0.060	DATE: 06-Aug-04	MASTER
CHECKED BY:			
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DATE: 06-Aug-04	SCALE: 0.060	DATE: 06-Aug-04	MASTER
CHECKED BY:			
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DATE: 06-Aug-04	SCALE: 0.060	DATE: 06-Aug-04	MASTER
CHECKED BY:			
TRACED BY:			

DATE: 06-Aug-04	SCALE: 0.060	DATE: 06-Aug-04	MASTER
CHECKED BY:			
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DATE: 06-Aug-04	SCALE: 0.060	DATE: 06-Aug-04	MASTER
CHECKED BY:			
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DATE: 06-Aug-04	SCALE: 0.060	DATE: 06-Aug-04	MASTER
CHECKED BY:			
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DATE: 06-Aug-04	SCALE: 0.060	DATE: 06-Aug-04	MASTER
CHECKED BY:			
TRACED BY:			

DATE: 06-Aug-04	SCALE: 0.060	DATE: 06-Aug-04	MASTER
CHECKED BY:			
TRACED BY:			

DATE: 06-Aug-04	SCALE: 0.060	DATE: 06-Aug-04	MASTER
CHECKED BY:			
TRACED BY:			

DATE: 06-Aug-04	SCALE: 0.060	DATE: 06-Aug-04	MASTER
CHECKED BY:			
TRACED BY:			

DATE: 06-Aug-04	SCALE: 0.060	DATE: 06-Aug-04	MASTER
CHECKED BY:			
TRACED BY:			

DATE: 06-Aug-04	SCALE: 0.060	DATE: 06-Aug-04	MASTER
CHECKED BY:			
TRACED BY:			

DATE: 06-Aug-04	SCALE: 0.060	DATE: 06-Aug-04	MASTER
CHECKED BY:			
TRACED BY:			

DATE: 06-Aug-04	SCALE: 0.060	DATE: 06-Aug-04	MASTER
CHECKED BY:			
TRACED BY:			

DATE: 06-Aug-04	SCALE: 0.060	DATE: 06-Aug-04	MASTER
CHECKED BY:			
TRACED BY:			

DATE: 06-Aug-04	SCALE: 0.060	DATE: 06-Aug-04	MASTER
CHECKED BY:			
TRACED BY:			

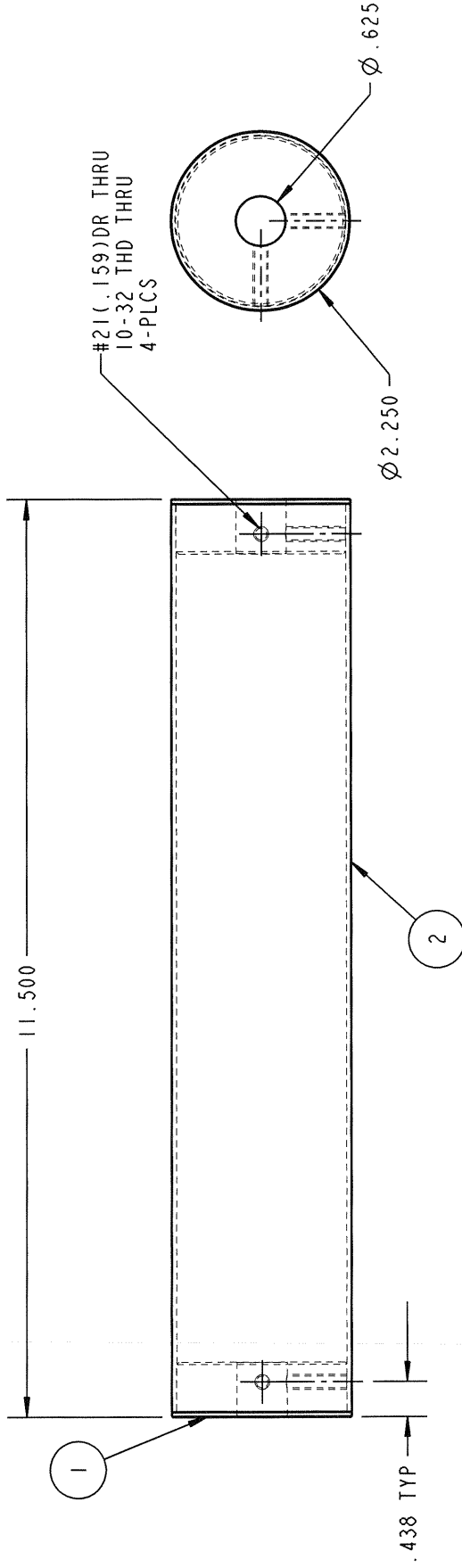
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CHECKED BY:			
TRACED BY:			

DATE: 06-Aug-04	SCALE: 0.060	DATE: 06-Aug-04	MASTER
CHECKED BY:			
TRACED BY:			

DATE: 06-Aug-04	SCALE: 0.060	DATE: 06-Aug-04	MASTER
CHECKED BY:			
TRACED BY:			

DATE: 06-Aug-04	SCALE: 0.060	DATE: 06-Aug-04	MASTER
CHECKED BY:			
TRACED BY:		</	

ITEM	QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	2	500839	HUB-BELT DRIVE					
2	1	500742-12	ROLLER - TUBE BELT DRIVE					

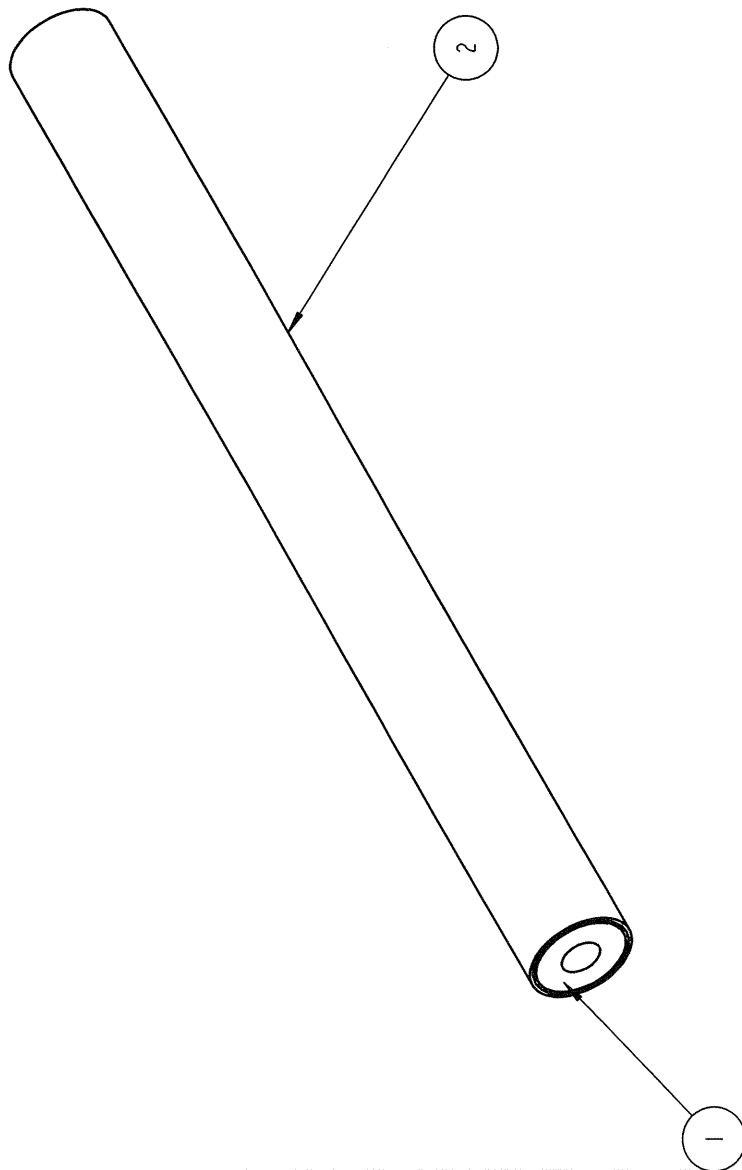


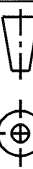

NOTES:
1. PRESS FIT HUBS INTO TUBING
2. DRILL AND TAP

DRAWN BY: TJG	SCALE: 0.500	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	MATERIAL: NOTED	THIRD ANGLE PROJECTION	PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE COPIED OR REPRODUCED WITHOUT THE WRITTEN PERMISSION OF KIRK-RUDY, INC. WOODSTOCK, GA 30188 USA	KIRK - RUDY, INC. WOODSTOCK, GEORGIA	REQ'D I	WHERE USED 536592-02
CHECKED BY:	DATE: 12-Nov-99	HEAT TREAT: N/A	FINISH: N/A	MODEL: SP79800	TITLE: ASSY, DRIVE ROLLER			
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 # 530676-04			

ITEM	QTY	PART #	DESCRIPTION
1	2	103106	BEARING, FLAT .375
2	1	508763-5	ROLLER, IDLER

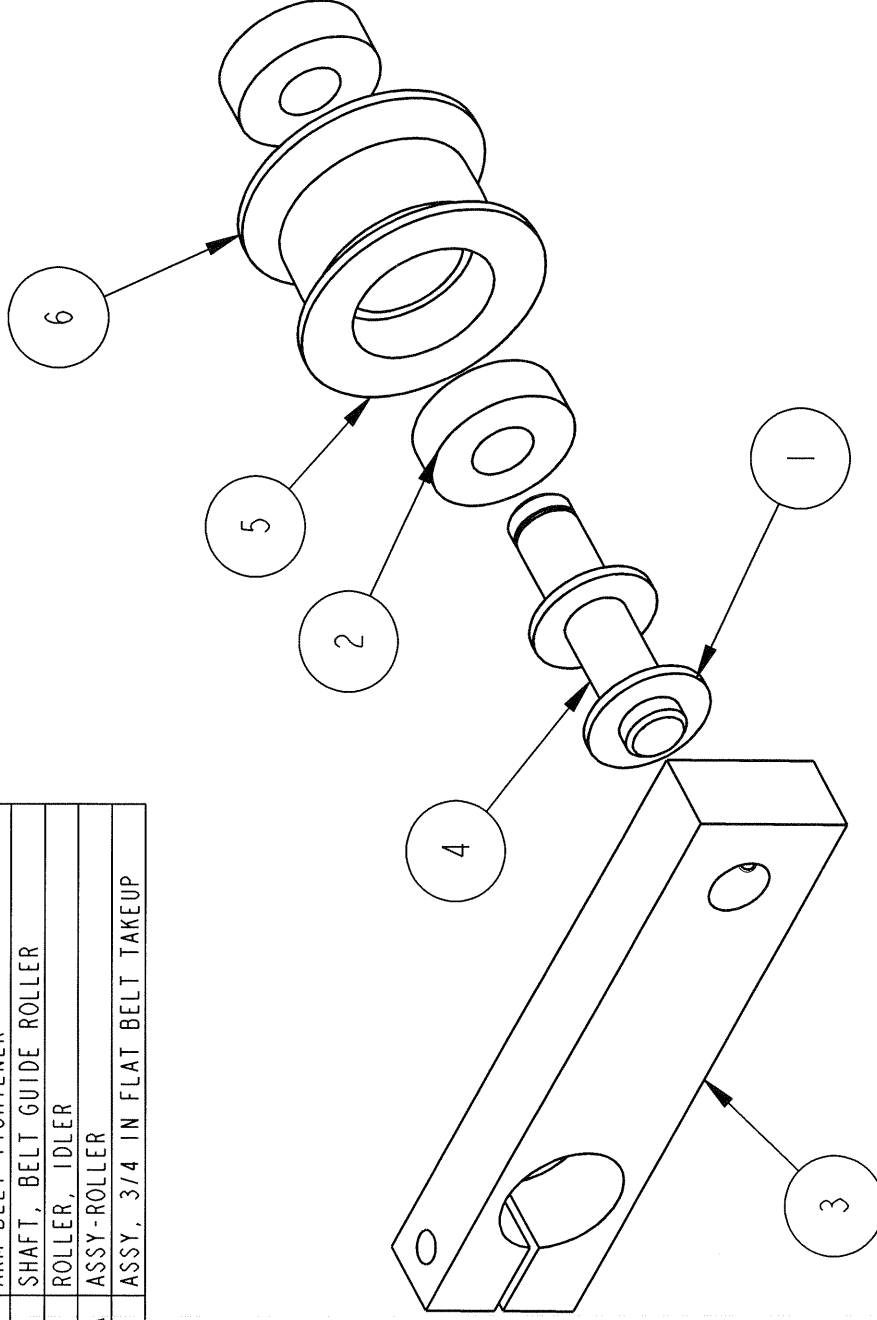
REV NO	DATE	DESCRIPTION	ECN NO	BY
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DRAWN BY: TJG	SCALE 0.625	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED		MATERIAL: XXX	THIRD ANGLE PROJECTION 	PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE QUOTED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC. WOODSTOCK, GA 30188 USA	 KIRK - RUDY, INC. WOODSTOCK, GEORGIA	536592-02	
			.XX					.XXX	ANG.
CHECKED BY:	DATE 12-Nov-99	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED		HEAT TREAT: XXX					
TRACED BY:	MASTER	ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY		FINISH: XXX	MODEL: SP79800	TITLE: ASSY, OUTFD ROLLER			
					SHEET NO: 1 OF 1	DRAWING #			535878-02

ITEM	QTY	PART #	DESCRIPTION
1	2	100402	WASHER, THRUST TB612
2	2	103106	BEARING, FLAT .375
3	1	504949	ARM BELT TIGHTENER
4	1	504988	SHAFT, BELT GUIDE ROLLER
5	1	510611-1	ROLLER, IDLER
6	1	510611-1A	ASSY-ROLLER
7	1	539325-01	ASSY, 3/4 IN FLAT BELT TAKEUP

REV NO	DATE	DESCRIPTION	ECN NO	BY
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6	SP84000
REQ'D	WHERE USED

PROPRIETARY AND CONFIDENTIAL
NO PORTION OF THIS DRAWING
MAY BE QUOTED OR REPRODUCED
IN ANY FORM WITHOUT THE
EXPRESS WRITTEN PERMISSION
OF KIRK-RUDY, INC.
WOODSTOCK, GA 30188 USA

THIRD ANGLE PROJECTION

MATERIAL:	N/A
HEAT TREAT:	

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

DRAWN BY:	A KEY	SCALE	1.000
CHECKED BY:		DATE	

TITLE: ASSY, 3/4 IN FLAT BELT TAKEUP
 DRAWING ■ 539325-01

MODEL:	SP84000
SHEET NO.:	1 OF 1

finish:	N/A
	N/A

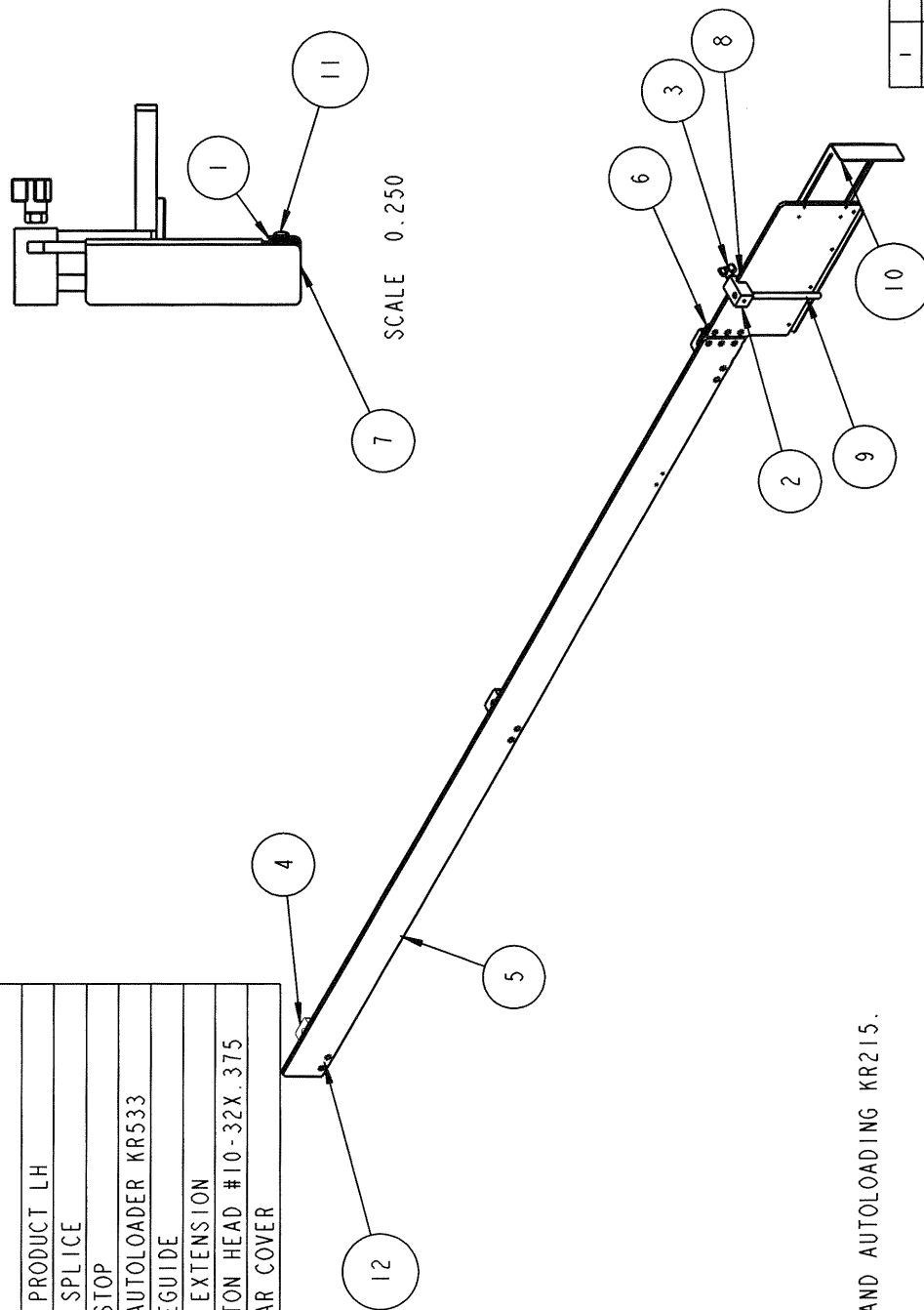
REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED

ALL DIMENSIONS ARE FINISHED DIMENSIONS

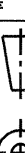
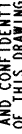
DO NOT SCALE - WORK TO DIMENSIONS ONLY

23-May-00	
TRACED BY:	MASTER

ITEM	QTY	PART #	DESCRIPTION
1	4	102562	SHIM, .25X.500X.062
2	1	501913	BLOCK, ROD ADJUSTMENT
3	1	102119-A	ASSY, KNOB
4	3	508737-7	BRACKET
5	1	537603-10	SIDEGUIDE, PRODUCT LH
6	1	537658-02	BAR, PLATE SPLICE
7	1	544776-01	CLIP, BACKSTOP
8	1	544864-01	BACKSTOP, AUTOLOADER KR533
9	1	544875-01	SHAFT, SIDEGUIDE
10	1	544876-01	SIDEGUIDE, EXTENSION
11	4	CSFF57	SCREW, BUTTON HEAD #10-32X.375
12	3	SP6383-1	SPACER, GEAR COVER



NOTES:
1. USE FOR RIGHT HAND AUTOLOADING KR215.

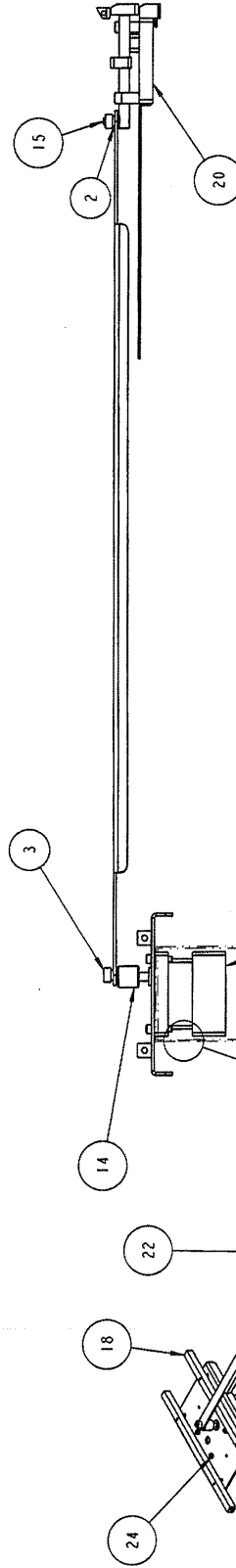
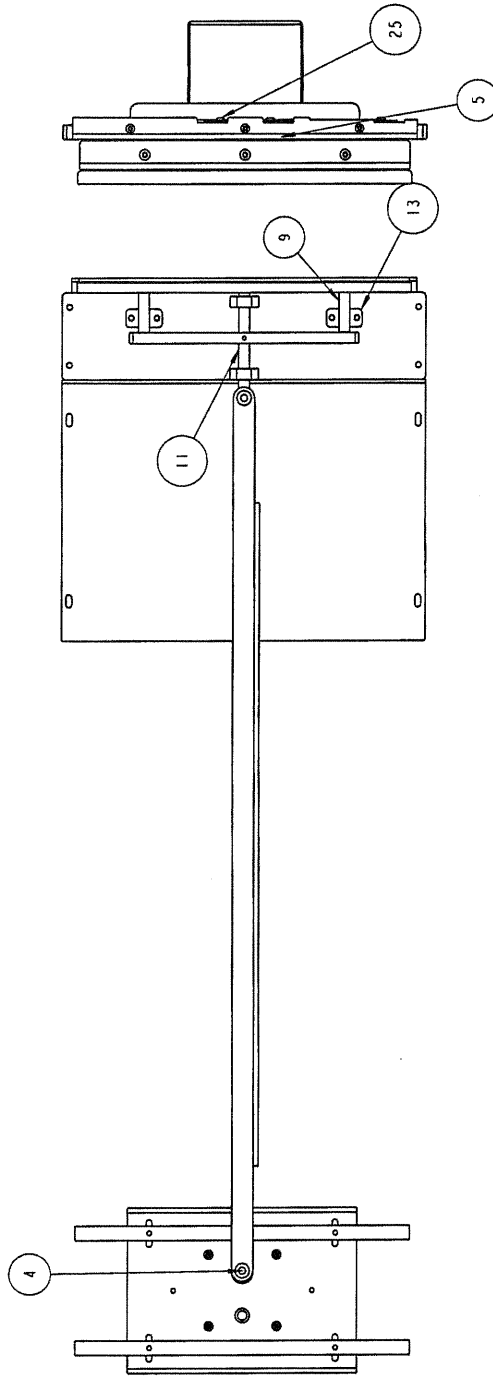
DRAWN BY: TJG	SCALE 0.090	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED			MATERIAL: XXX	THIRD ANGLE PROJECTION 	PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE QUOTED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC. WOODSTOCK, GA 30188 USA	 KIRK - RUDY, INC. WOODSTOCK, GEORGIA	REQ'D		WHERE USED			
	CHECKED BY:	DATE 24-Oct-03	.XX	.XXX					ANG.	HEAT TREAT: XXX	MODEL: KR533	TITLE: ASSY, SIDEGUIDES RH 215 FEED	1	KR533
		TRACED BY:	MASTER	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED					FINISH: XXX					

MARKING 1

544858-01

REV	NO	DATE	DESCRIPTION	CM	BY
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ITEM	QTY	PART #	DESCRIPTION
1	2	100101	BUSHING, SL. 3751D. 5000D. 375LG
2	2	100309	BUSHING, FL. 2501D. 3750D. 250LG
3	2	102223	COLLAR, 250
4	1	105413	DOWEL, PIN, 250X. 750
5	3	107904	BALL PLUNGER, 10-32
6	1	206600	MOTOR, 41RPM 120V
7	1	537699-03	BACKSTOP, AUTOLOADER
8	2	544544-01	BLOCK, BUSHING MOUNT
9	2	544545-01	SHAFT, JOGGER GUIDE
10	1	544546-01	BAR, JOGGER
11	1	544547-01	SHAFT, JOGGER GUIDE
12	1	544548-01	BAR, JOGGER
13	2	544549-01	BLOCK, POLY GUIDE
14	1	544553-01	SHAFT, ECCENTRIC JOGGER
15	1	544558-01	PIN, JOGGER
16	1	544569-01	COVER, JOGGER MOTOR
17	1	544741-01	CHANNEL, JOGGER MOTOR MOUNT
18	2	544744-01	BAR, JOGGER MOTOR MOUNT
19	3	544747-01	CLIP, PRODUCT BACKSTOP
20	1	544859-01	PLATE, JOGGER SUPPORT
21	1	544860-01	BAR, BACKSTOP AUTOLOADER
22	1	544861-01	LINK, JOGGER DRIVE
23	1	544862-01	COVER, JOGGER LINKAGE
24	4	CSDD267	SCREW, SHCS 10-32X. 750
25	3	CSFF57	SCREW, BUTTON HEAD #10-32X. 375



REV	NO	DATE	DESCRIPTION	CM	BY
1	1				
2	1				
3	1				
4	1				
5	1				
6	1				
7	1				
8	1				
9	1				
10	1				
11	1				
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15	1				
16	1				
17	1				
18	1				
19	1				
20	1				
21	1				
22	1				
23	1				
24	1				
25	1				

SCALE	0.250	MATERIAL	XXX
DATE	13-Oct-03	NEAT TREAT	XXX
SCALE	M	FINISH	XXX

BRAND BY:	TJG	PROPRIETARY AND CONFIDENTIAL	KIRK - RUDY, INC.
CHECKED BY:		NO REPRODUCTION OR REUSE OF ANY PARTS OR COMPONENTS WITHOUT THE WRITTEN PERMISSION OF KIRK - RUDY, INC.	WOODSTOCK, GEORGIA
TRACED BY:		MODEL	ASSY, JOGGER AUTOLOADER
		SHEET NO.	10F1
		SHEET NO.	544858-01

SCALE 0.125

544866-01

ITEM	QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	6	102200	COLLAR .375					
2	2	102201	COLLAR .625					
3	4	102206	COLLAR .250					
4	2	501809	WHEEL					
5	1	501818	BLOCK, PIVOT					
6	1	501819	BLOCK					
7	1	501824	WHEEL BAR					
8	2	500791-17	POST, DRIVE WHEEL MOUNT					
9	1	544867-01	SHAFT, ROLLER					
10	1	544868-01	SPACER, TOP REST					

THIRD ANGLE PROJECTION	MODEL: KR533	SHEET NO. 10F1	DRIVING 1
	N/A	N/A	N/A
PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE QUOTED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC. WOODSTOCK, GA 30188 USA	TITLE: ASSY, KIT DRIVE ROLLER KR533		
DRAWING 1			

SCALE	0.125	DATE	10-Nov-03	MASTER	
DRAWN BY:	TJG	CHECKED BY:		TRACED BY:	

REO'D	WHERE USED
X	XXX

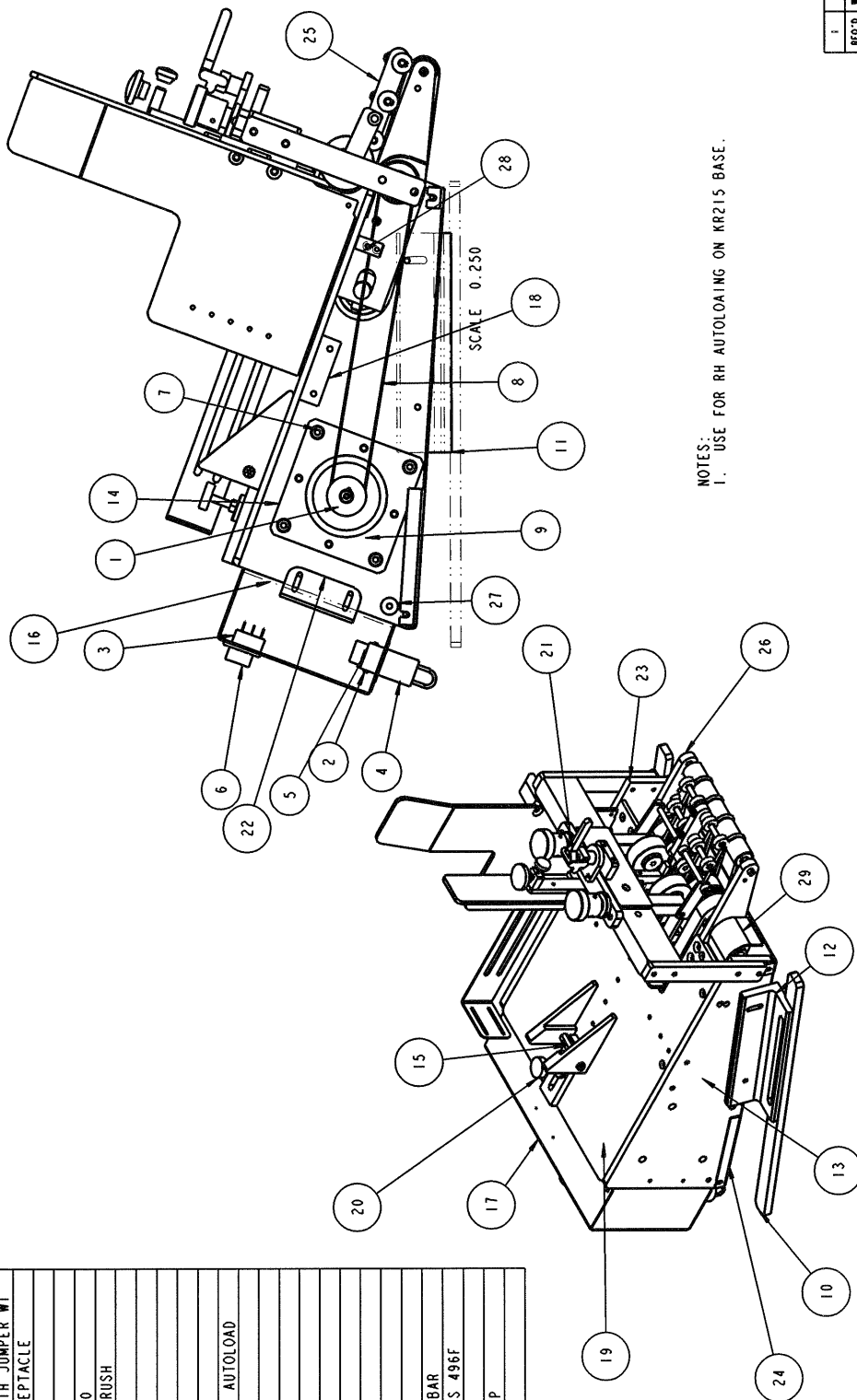
ITEM	QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	2	102140	HANDLE, RELEASE 1/4-20 X .75					
2	2	102148	HANDLE, RELEASE 1/4-20 X .78					
3	2	544869-01	BAR, PRODUCT SLIDE MOUNT					
4	1	544871-01	BAR, PRODUCT SLIDE MOUNT					
5	1	544872-01	GUIDE, PRODUCT SLIDE					
6	5	CSFF58	SCREW, BUTTON HEAD #10-32X.500					
7	2	SP6383-1	SPACER, GEAR COVER					

THIRD ANGLE PROJECTION	MODEL: KR533	HEAT TREAT: XXX	MATERIAL: XXX	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	SCALE	DATE	MASTER	WHERE USED
	TOFI	XXX	XXX	.XX .01 .XXX .5 ANG.	0.375	11-Nov-03		KIRK - RUDY, INC. WOODSTOCK, GEORGIA
TITLE: ASSY, KIT PRODUCT SLIDE KR533								544870-01
DRAWING #								

PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE QUOTED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK - RUDY, INC. WOODSTOCK, GA 30188 USA	XXX	WHERE USED
	X	

REV	DATE	DESCRIPTION	BY
1			

ITEM	PART #	DESCRIPTION
1	109433	PULLEY, TIMING 10L050 .500B .125K
2	200323	STRAIN RELIEF
3	201132	SWITCH, LIGHTED
4	201514	3 PIN TWIST PLUG WITH JUMPER WI
5	201534	THREE PIN TWIST RECEPTACLE
6	209016	KNOB, POT
7	502255	SPACER, GEAR COVER
8	108945-10	BELT, TIMING 270L050
9	200165-5	MOTOR, 1/4 HP DC BRUSH
10	530498-01	BAR
11	530528-01	ANGLE
12	530528-02	ANGLE
13	530529-01	PLATE, RH FRAME
14	530534-01	PLATE, MOTOR MTG
15	530549-04	ASSY, BACKSTOP 496F AUTOLOAD
16	530710-01	ELECTRICAL BOX
17	530711-01	PANEL, CONTROL
18	530728-01	BAR-SPACER
19	530730-01	TABLETOP
20	530789-01	ONBOB ASSY, ROUND CAP
21	530887-12	ASSY, BRIDGE 496F
22	530910-01	ANGLE
23	530911-01	PLATE, LH FRAME
24	530912-01	COVER, BOTTOM
25	535051-05	ASSY, OUTFEED SKID BAR
26	535746-01	ASSY, FRICTION BELTS 496F
27	SP49620	SPACER
28	SP49631	BLOCK, TABLETOP SUPP
29	SP49625-1	COVER, PULLEY 496F



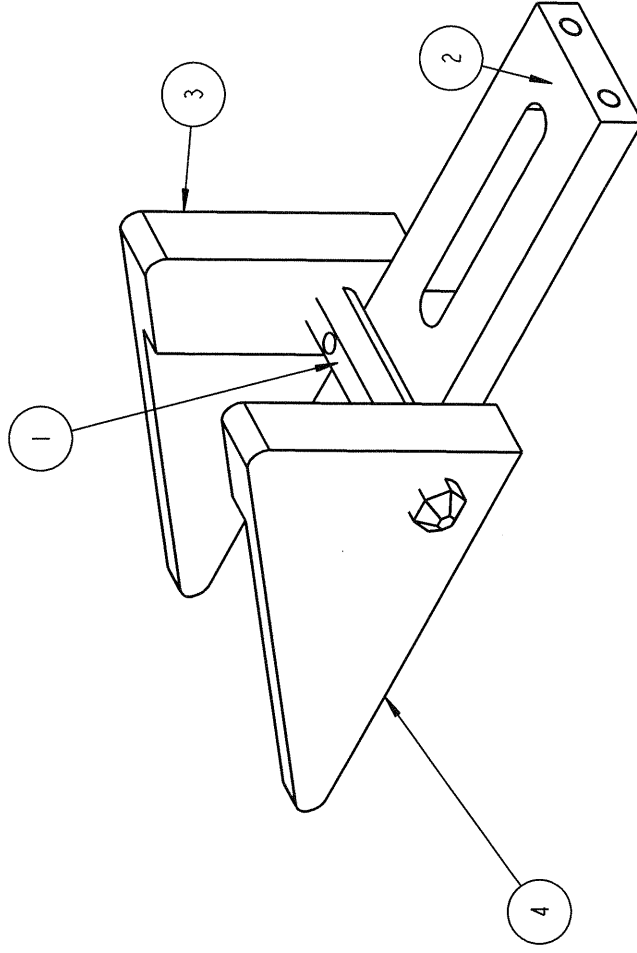
NOTES:
1. USE FOR RH AUTOLOADING ON KR215 BASE.

KIRK - RUDY, INC. WOODSTOCK, GEORGIA		1		496F	
PROPERTY AND CONFIDENTIALITY NOTICE: NO PORTION OF THIS DRAWING MAY BE REPRODUCED OR TRANSMITTED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK - RUDY, INC. WOODSTOCK, GA 30189 USA		THIS DRAWING PRODUCTION		REO'D, WHERE USED	
TITLE: ASSY, 496F FEEDER AUTOLOAD		DRAWN: SA237		CHECKED: TOF3	
SCALE: 0.188		DATE: 12-Nov-03		MATERIAL: XXX	
CHECKED BY: T JG		DATE: 12-Nov-03		MATERIAL: XXX	
TRACED BY: MATTER		DATE: 12-Nov-03		MATERIAL: XXX	
ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY		DIMENSIONS ON TO DIMENSIONS UNLESS OTHERWISE NOTED		DIMENSIONS ON TO DIMENSIONS UNLESS OTHERWISE NOTED	
TOLERANCES UNLESS OTHERWISE NOTED		TOLERANCES UNLESS OTHERWISE NOTED		TOLERANCES UNLESS OTHERWISE NOTED	
FRACTIONS		FRACTIONS		FRACTIONS	
DECIMALS		DECIMALS		DECIMALS	
ANGLES		ANGLES		ANGLES	
HOLE DIA		HOLE DIA		HOLE DIA	
TAP DIA		TAP DIA		TAP DIA	
THREAD DIA		THREAD DIA		THREAD DIA	
HOLE DIA		HOLE DIA		HOLE DIA	
TAP DIA		TAP DIA		TAP DIA	
THREAD DIA		THREAD DIA		THREAD DIA	

530549-04

ITEM	QTY	PART #	DESCRIPTION
1	1	530548-08	CROSS BAR
2	1	530675-01	BAR
3	1	530731-04	WEDGE, LH EXTENDED
4	1	530731-05	WEDGE, RH EXTENDED

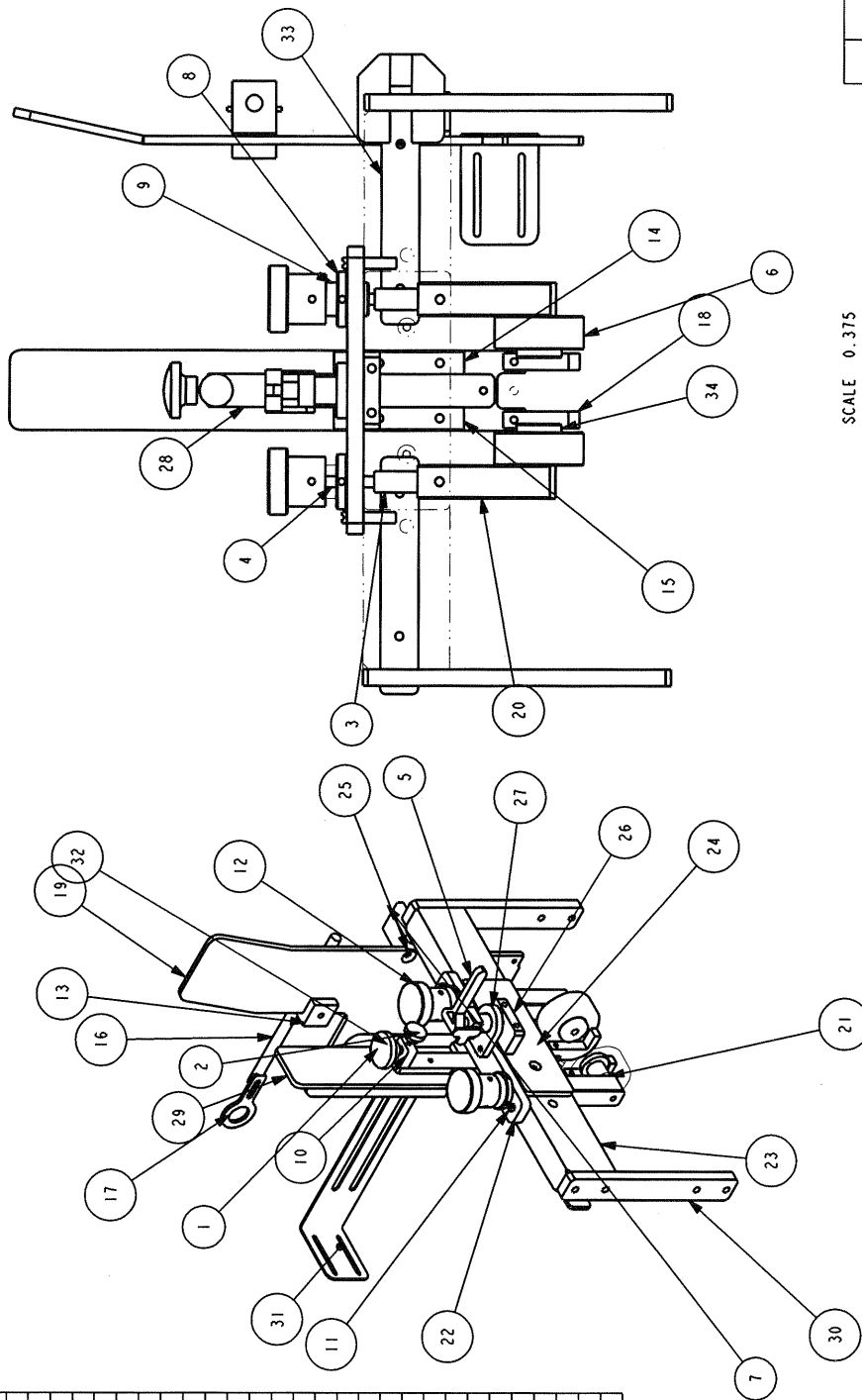
REV NO	DATE	DESCRIPTION	ECN NO	BY
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DRAWN BY: TJG	SCALE 0.750	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED <table border="1"> <tr> <td>.XX</td> <td>.XXX</td> <td>ANG.</td> </tr> <tr> <td>.01</td> <td>.005</td> <td>.5</td> </tr> </table>	.XX	.XXX	ANG.	.01	.005	.5	MATERIAL: NOTED	THIRD ANGLE PROJECTION 	PROPRIETARY AND CONFIDENTIAL FOR KIRK-RUDY, INC. THIS DRAWING MAY BE USED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC. WOODSTOCK, GA 30188 USA	KIRK - RUDY, INC. WOODSTOCK, GEORGIA	<table border="1"> <tr> <td>X</td> <td>XXX</td> </tr> <tr> <td>REQ'D</td> <td>WHERE USED</td> </tr> </table>	X	XXX	REQ'D	WHERE USED
	.XX		.XXX	ANG.													
.01	.005	.5															
X	XXX																
REQ'D	WHERE USED																
CHECKED BY:	DATE 06-Nov-03	HEAT TREAT: XXX	MODEL: SA237	TITLE: ASSY, BACKSTOP 496F AUTOLOAD													
TRACED BY:	MASTER	FINISH: XXX	SHEET NO: 1 OF 1	DRAWING 1	530549-04												

530887-12

ITEM QTY	PART #	DESCRIPTION
1	102113	KNOB, PLASTIC
2	102114	KNOB
3	102787	SPRING
4	107334	BOLT, HEX HO MACH
5	190733	CLAMP, QUICK RELEASE
6	500745	ROLLER, UPPER
7	500755	CLAMP - SIDE GUIDE
8	500807	NUT - LOCK
9	500809	SLEEVE - THREADED
10	502232	BLOCK, GATE BLADE
11	500799-6	STUD, BRIDGE (LONG)
12	500812-2	KNOB, ROLLER ADJUSTMENT
13	501913-1	BLOCK, ROD ADJUSTMENT
14	502233-R	GIB
15	502233LH	GIB
16	502824-1	SHAFT, SENSOR MOUNTING
17	508996-1	BRACKET, PHOTOCCELL
18	530478-01	DEFLECTOR PLATE
19	530545-12	SIDE GUIDE, LH
20	530753-01	BAR, RETARD ROLLER MOUNT
21	530754-01	STUD
22	530756-01	PLATE, QUICK RELEASE
23	530757-01	BAR, BRIDGE
24	530758-01	PLATE
25	530787-01	KNOB, ASY
26	530888-01	BLOCK, QUICK RELEASE
27	530889-01	PLATE, QUICK RELEASE
28	530890-01	GATE, CENTER ROLLER
29	530893-01	FRONT GUIDE
30	530908-01	BRIDGE MTG BAR
31	544399-01	BRACKET, SENSOR MOUNTING
32	544775-01	BRACKET, SENSOR MOUNTING
33	SP49675	BAR, TOP SLIDE
34	SP6383-1	SPACER, GEAR COVER

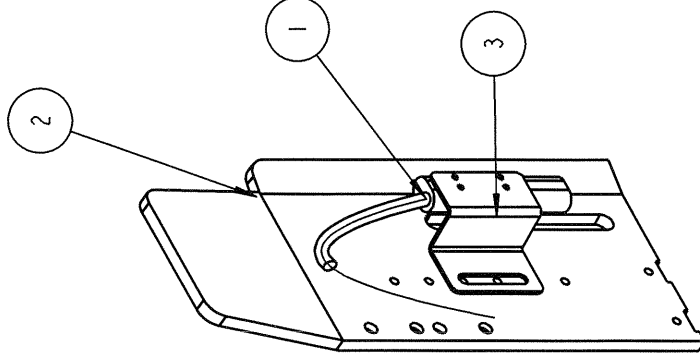


SCALE 0.375

NAME BY: T JG	SCALE: 0.250	DIMENSIONS: ALL DIMENSIONS ARE UNLESS OTHERWISE NOTED	MATERIAL: XXX	PROPERTY AND CONTROL: KIRK - RUDY, INC. WOODSTOCK, GEORGIA
CHECKED BY: 06-NOV-03	DATE: 06-NOV-03	REWORK: ALL DIMENSIONS ARE UNLESS OTHERWISE NOTED	WELD TREAT: NONE	FIGURE: SA237
TRACED BY:	MASTER	ALL DIMENSIONS ARE UNLESS OTHERWISE NOTED	FINISH: XXX	SHEET NO: 10F1
				530887-12

ITEM	QTY	PART #	DESCRIPTION
1	1	202263-5	BEAMSWITCH, LOW HOPPER
2	1	500788-34L	SIDEGUIDE, FEEDER W/AUTO LH
3	1	544775-01	BRACKET, SENSOR MOUNTING

REV NO	DATE	DESCRIPTION	ECN NO	BY
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NOTES:

1. USE ON KR215 BRIDGE.
2. USE FOR INLINE AND RIGHT HAND KR215 AUTOLOADING.

DRAWN BY: TJG	SCALE 0.312	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. WOODSTOCK, GA 30188 USA	KIRK - RUDY, INC. WOODSTOCK, GEORGIA	X XXX	REC'D WHERE USED
CHECKED BY:	DATE 24-Oct-03	.XX .01 XXX .005 ANG. .5	HEAT TREAT: XXX	MODEL KR533	TITLE ASSY, SIDEGUIDE 215 AUTOLOAD			
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	DRAWING # 544748-02			

8 ELECTRICAL SCHEMATICS AND PARTS

8.1 WIRING DIAGRAMS LIST

SCHEMATIC # 210212-06-00

8.2 PARTS LIST

9 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.

11 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.
125 LORRAINE PARKWAY
WOODSTOCK, GA. 30188
770-427-4203
FAX 770-427-4036
www.kirkrudy.com