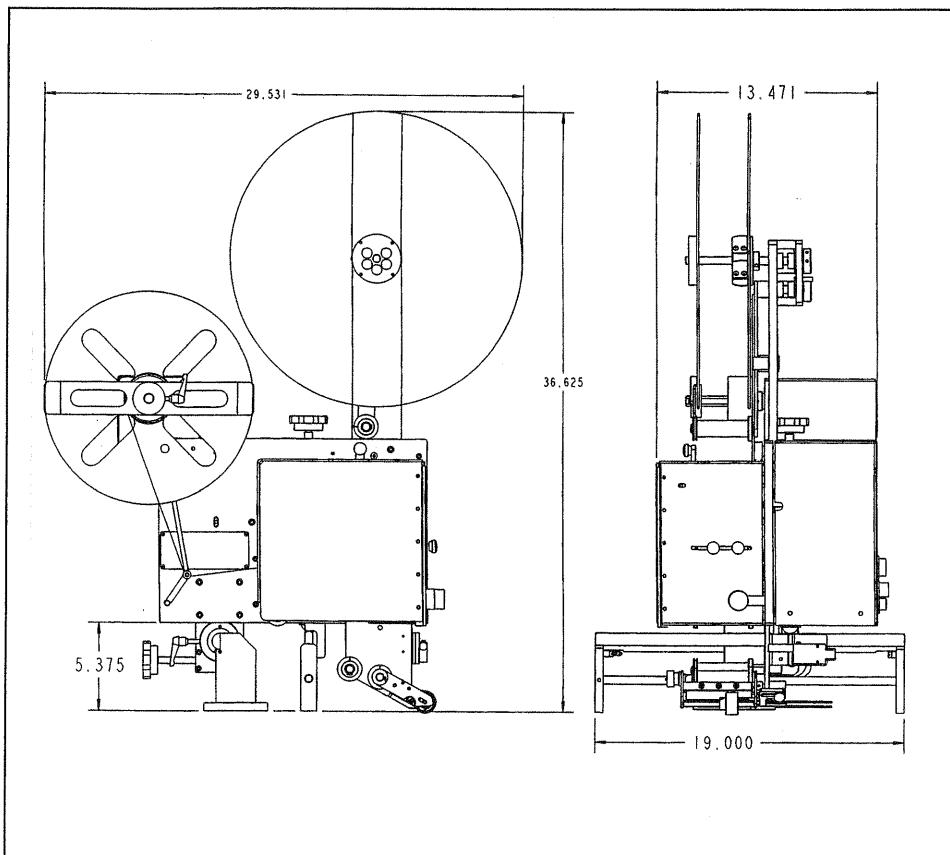


Kirk-Rudy Inc.

Instruction

and Parts Manual

KR535HD/KR535CSHD 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.

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1.0 Important Safety Instructions

Intended Use Statement: The KR535HD (stepper unwind) and KR535CSHD (clutched unwined) TabMaster are designed to apply pressure sensitive labels onto product. The KR535HD is just the head and standalone controls therefore, a base must be provided. Usage for other purposes may lead to an unsafe condition.

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

	WARNING
<ul style="list-style-type: none">* 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 LISCENSED 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>
<u>HEAD</u>		
Physical size:	29.5" X 36.63" X 19"	75 X 93 X 48.3cm
Weight	60 lbs	27.22 kg
<u>Labels:</u>		
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

MAXIMUM OPERATING SPEEDS

Single tabbing: 30,000 products / hour

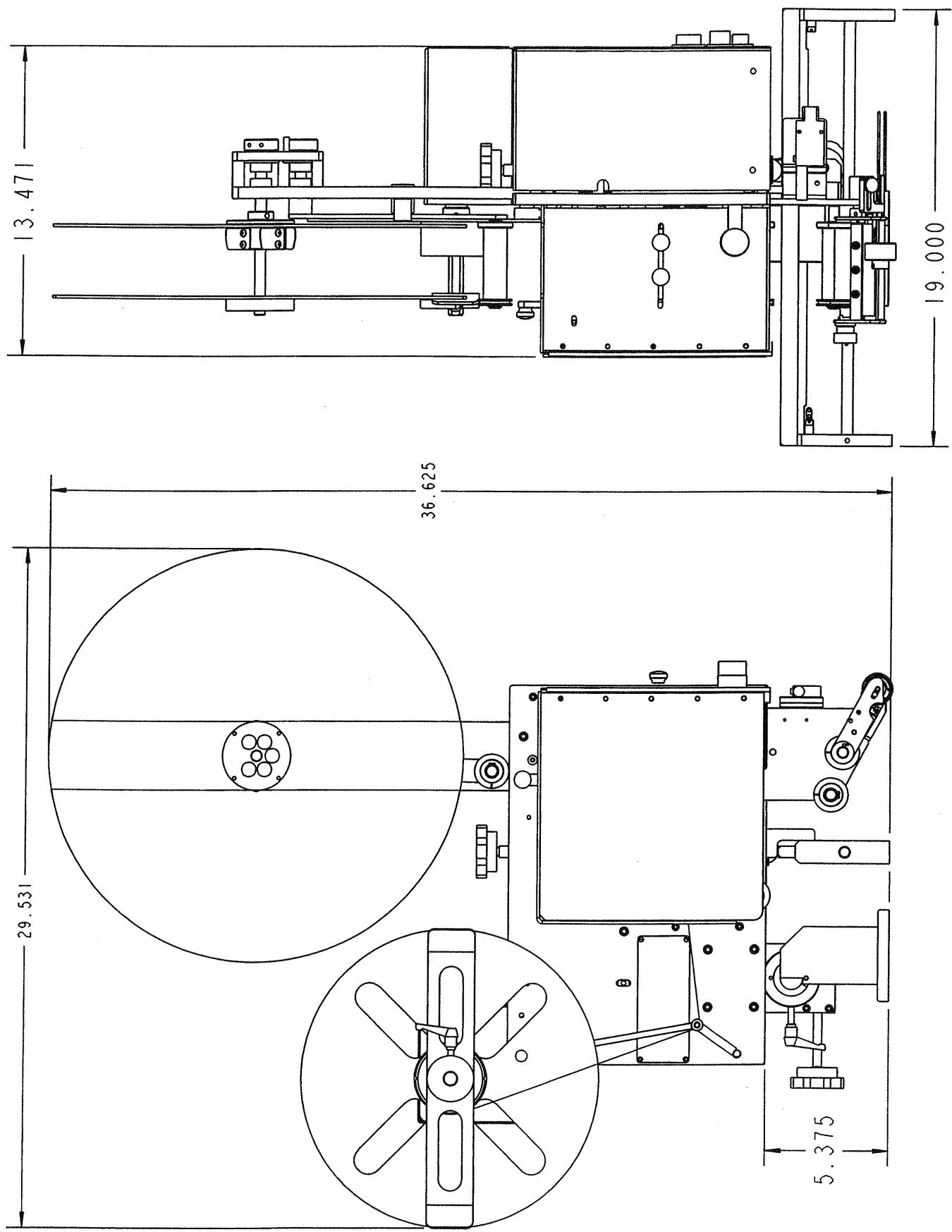
Double tabbing: 30,000 products / hour

Note: Speeds are dependent on material being feed.

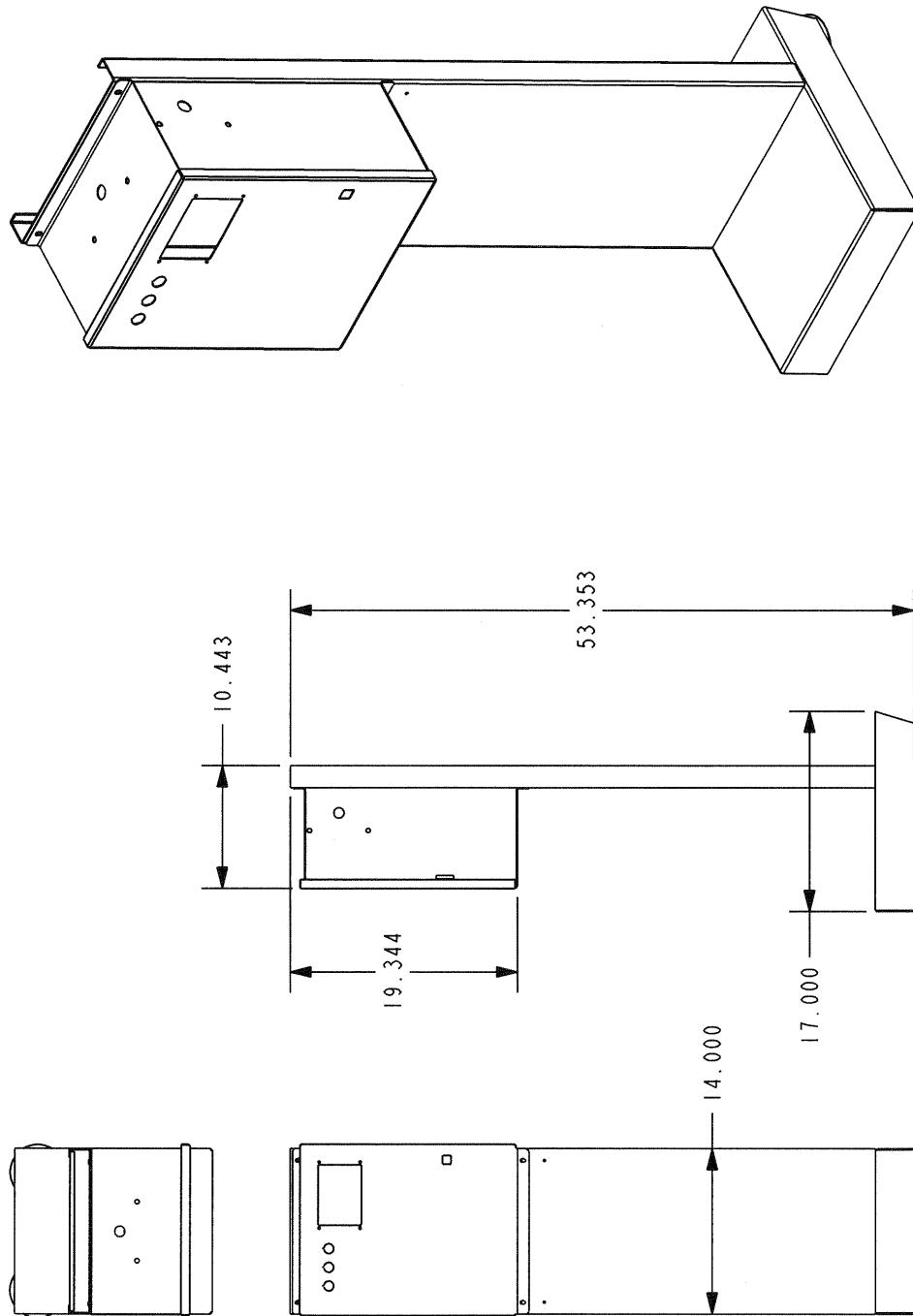
ELECTRICAL REQUIREMENTS

KR535HD 120 VAC, 1 Phase, 50/60 Hz, 10Amps

Electrical cord connection: 120V NEMA



REV NO	DATE	DESCRIPTION	ECN NO	BY
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SCALE 0.070

DRAWN BY:	JMW	SCALE	0 . 109	MATERIAL:	N / A	THIRD ANGLE PROJECTION	KIRK - RUDY, INC.	RECD WHERE USED
CHECKED BY:		DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	.01 .005 .5	ANG:			WOODSTOCK, GEORGIA	
DATE:	21-0c†-05	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED		HEAT TREAT:	N / A	MODEL:	ASSY, 535HD STAND	TITLE:
TRACED BY:	MASTER	ALL DIMENSIONS ARE FINISHED DIMENSIONS		FINISH:	N / A	SHEET NO:	20F2	DRAWING #
								535 80 - 02

3.0 INSTALLATION



WARNING

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

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. Mount head on existing base.

3.2 Cable and Cord Connections

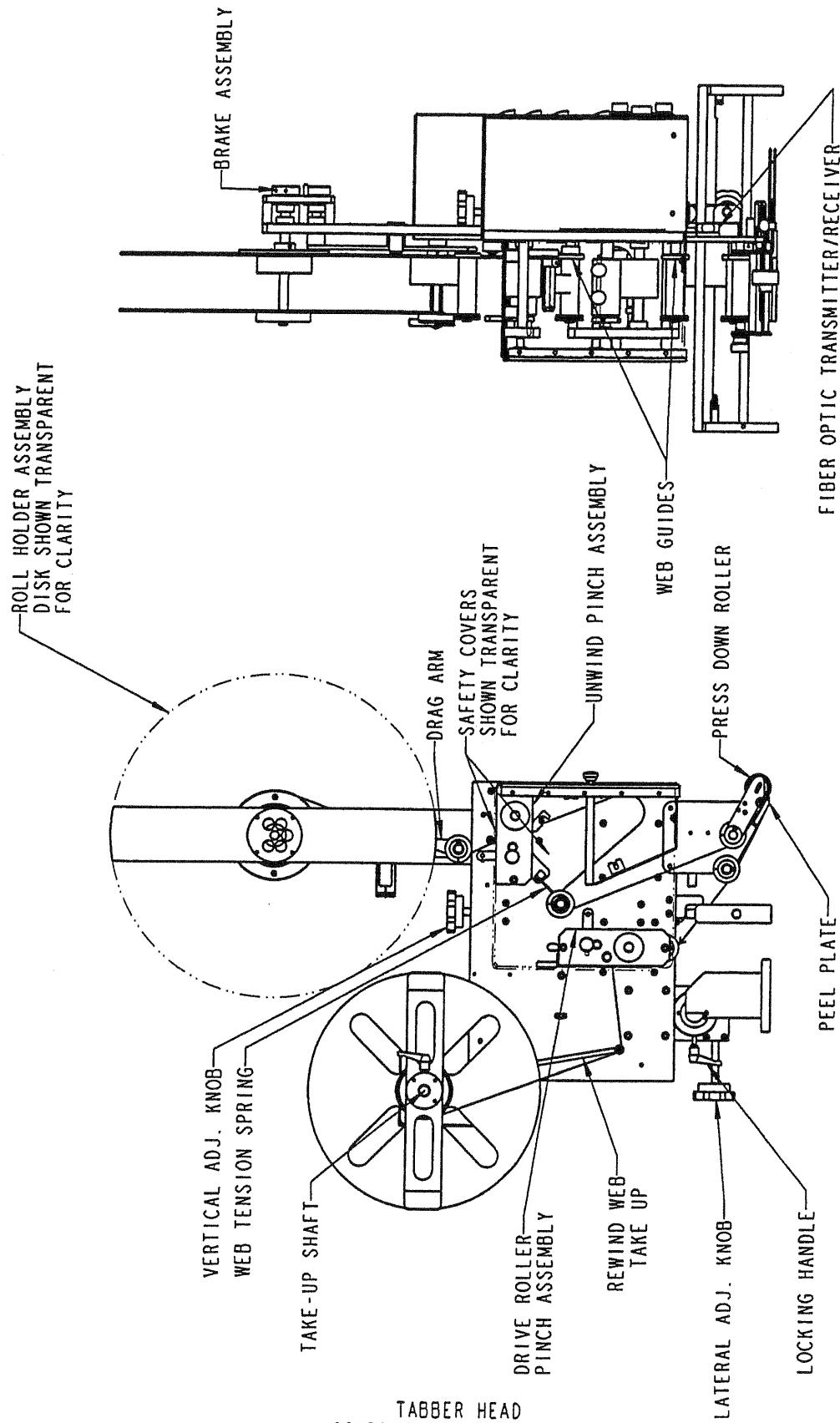
See Electrical Component Description

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.



TABBER HEAD
COMPONENTS DESCRIPTION
FIGURE 2.0

4.1.2 Base

The base that the KR535HD is to be mounted to should be a vacuum conveyor base. The vacuum base should have low profile sideguides for controlling the carrier product during the label application. The conveyor belts should be mechanically connected to an encoder to provide the controller with the necessary information to speed match and control label position.

4.2 ELECTRICAL COMPONENT DESCRIPTION

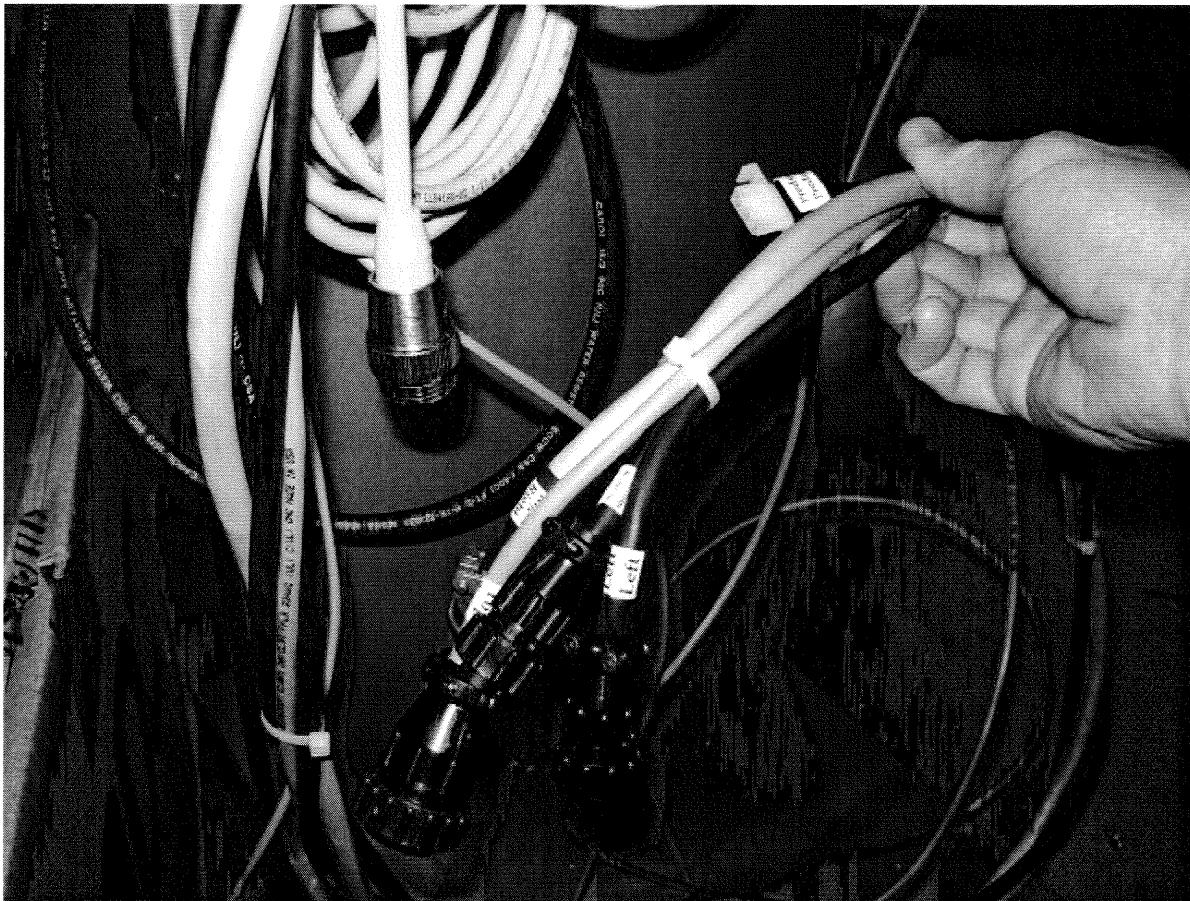
4.2.1 Control Panel (Left to Right)

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. Tabber Stop Button: Push to reset errors.
5. User Interface: See section 4.3 User Interface for complete description.



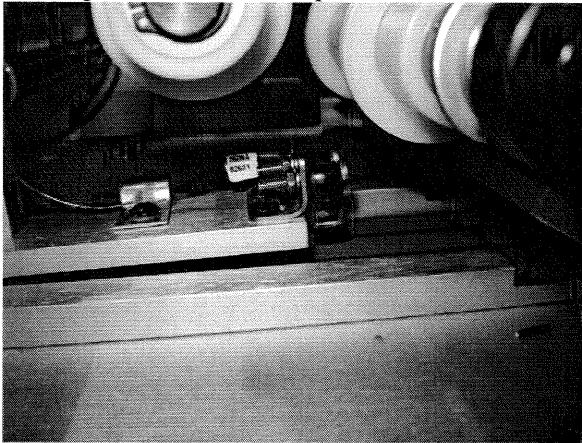
4.2.2 Electrical Connections Control Box and Head

1. Left: Connects to left plug on backside of the head.
2. Right: Connects to the right plug on backside of the head.
3. Top: Connects to top plug on backside of the head.
4. Bottom: Connects to bottom plug on backside of head.
5. Product Sensor: Connects to beamswitch to detect carrier product.
6. Encoder: Connects to base encoder for speed following.
7. Stop-Out: Yellow two-pin turk connects to base stop circuit.. The tabber head base is now connected into the stop circuitry of the base. Note: Applies to KR bases only.
8. Power Cord: Plug the 535HD into an appropriate electrical outlet.



4.2.3 Machine Sensors (Figure 5.0)

1. Product Detect Beam Switch: Detects the product's leading edge. This sensor required reflective tape.



2. Tab-Label Sensor: Detects the gap between 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)

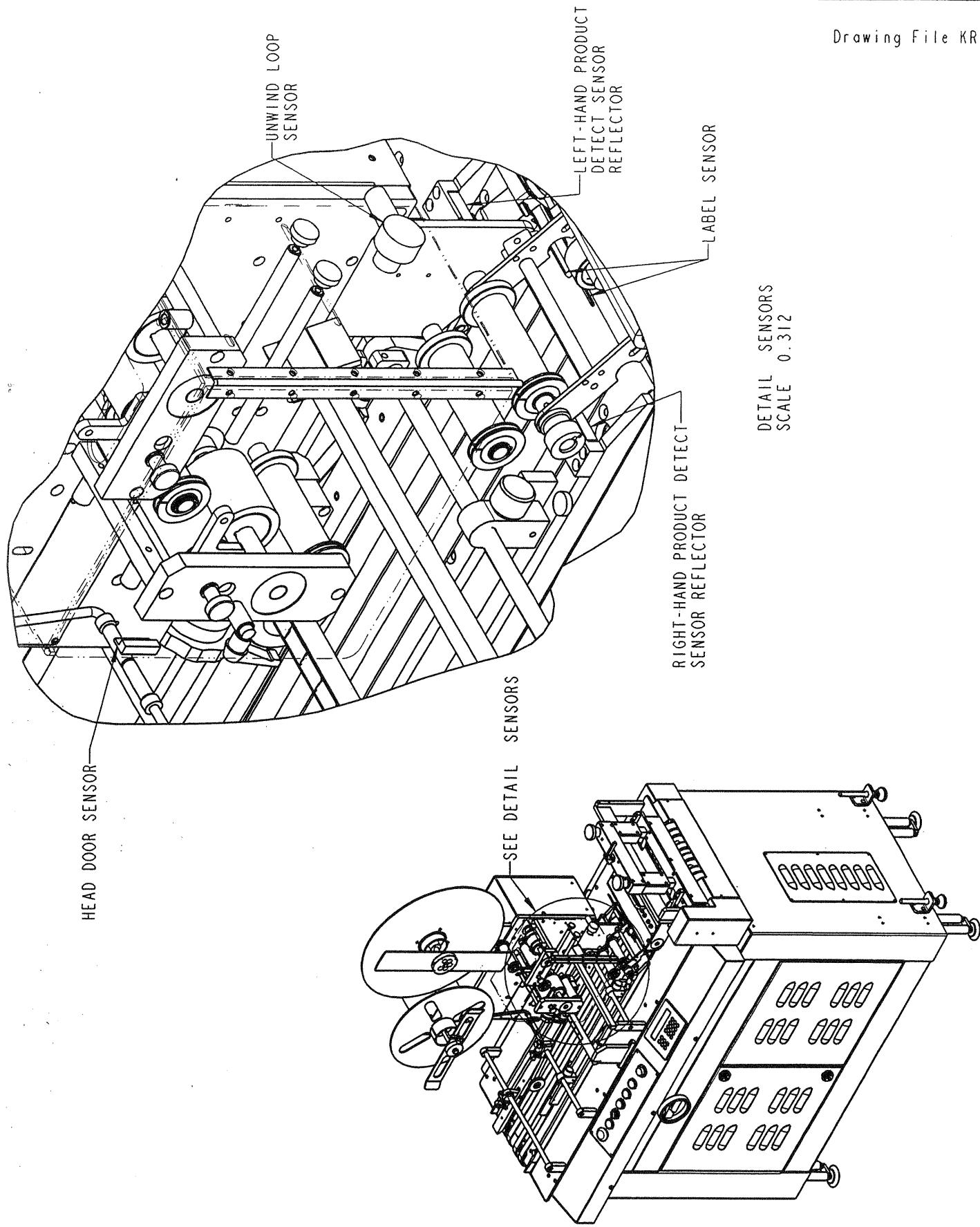
4.3.1 Overview: The user interface provides a way to electronically change certain machine settings and parameters. Settings and parameters are changed using the keypad next to the screen. To change a setting or a parameter, press the applicable button, press the clear button, type in the new setting or value and then press the enter button. Settings associated with a particular job can be saved and recalled at a later time. A total of 10 different jobs can be saved. During normal operation of the machine, machine speed, product count and error messages are displayed on the screen.

4.3.2 Function Keys (See Figure 6.0)

Tab/Stamp: Press this key to select tab or stamp mode. In the tab mode, the distance between tabs can be set. In the stamp mode, the stamps are applied in a continuous strip. In either mode, select 1 to 6 tabs/stamps to be applied to the each product.

NOTE: Labels are applied as tabs or stamps, depending on the desired spacing of the labels as they are applied to the product.

Tab Size: Press this key to enter the diameter of the tab or stamp. NOTE: When the number of tabs/stamps is changed, a new tab/stamp size is entered or a new product size is entered, the tab or stamp position(s) are automatically recalculated.



MACHINE SENSOR
FIGURE 5.0

Save to Job: Press this key to load a previously saved job or save the current settings to a job number for future use. Jobs are numbered from 1 to 10. Saving job settings to a job number will erase all settings previously saved to that job number.

Mach Info: Press this key to scroll through the current machine settings, logic inputs and logic outputs.

Tab Pos. Press this key to set the tab/stamp location. In the tab mode, this key provides a way to set the location of the leading edge of each tab from the leading edge of the product. In the stamp mode, this key provides a way to set the location of the leading edge of the first stamp from the leading edge of the product. NOTE: Compensation for machine speed changes only begins at approximately 200 feet per minute. Any change in machine speed below 200 feet per minute will vary the location of the tab/stamps. If the machine is to be operated at a speed less than 200 feet per minute, set the desired machine speed and make adjustments in tab/stamp position as necessary to obtain the desired placement. Speeds above 200 feet per minute are fully compensated and the tab/stamp position should not vary with changes in machine speed.

Tab Type: This key allows selection between two tab types, white and clear. Pressing the tab type key will toggle the setting to the other type. NOTE: At this time, there is no difference in operation of the machine in either type.

L/R Beam: This key allows selection of operation of the left or right product detect beam switch. (Left and right on a machine is determined by looking downstream) Pressing the key toggles the operation to the other beam switch. NOTE: This key does not function when the tabber head is mounted on a base with only one product detect beam switch.

Mach Setup: Press this key to view and change the machine parameters used to control the automatic operation of several functions of the machine. A password is required to access the machine setup screens.

Product Size: Press this key to enter the size of the product. The product size along with the tab or stamp length is used to automatically locate the position of the tab or stamp on the product. When the enable card jam function is activated, if the product detect beam switch is covered for belt travel longer than double the length entered in the product size the product jam stop will be activated. NOTE: When the number of tabs/stamps is changed, a new tab/stamp size is entered or a new product size is entered, the tab or stamp position(s) are automatically recalculated.

Reset Count: Press this key to reset the counter displayed on the screen.

Sensor Teach: Press this key to calibrate the tab sensor. For correct calibration of the tab sensor, the machine speed needs to be set at 30 feet per minute or less during calibration. The sensor amplifier unit is located on the rear of the peel plate support. The sensor amplifier unit will display a red light when the beam teach has been activated. After activation, a single product is run through the tabber and the tabber will apply tabs or stamps on the product as long as the product sensor is covered. The amplifier will display a green light when it is finished calibrating.

Clear: Press this key to clear the current setting or parameter on the display screen so that a new setting or parameter value can be entered.

Esc: Press this key to escape the current screen and return to the speed/count screen.

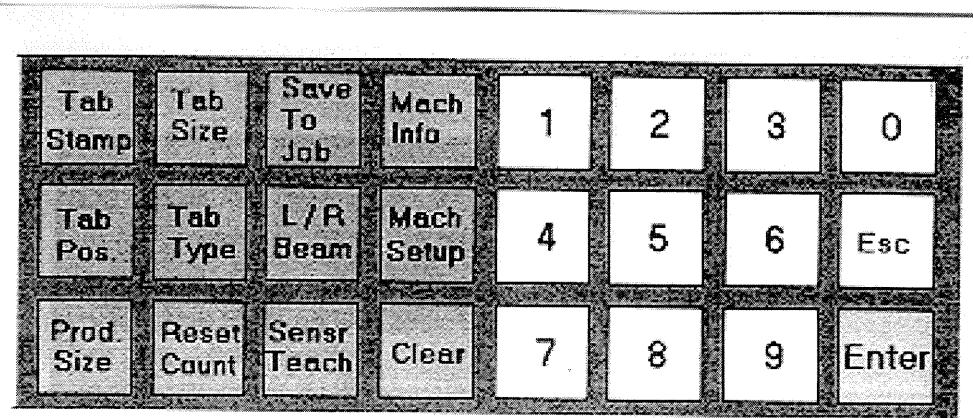


Figure 6.0 Interface Control Panel

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 the length of table belt travel equal to twice the product length set in the user interface.
2. Tabber Door: A machine stop will occur when the door on the tabber head is opened.
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 the time parameter set in the Machine Setup (normally 3 seconds).

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 KR535HD on a vacuum conveyor base. The product detect beam switch detects the leading edge and sends a signal to the control unit. Labels are applied to the product according to operator input parameters using the operator interface. The control unit starts the main drive roller peeling a label off the webbing and onto the product. The main drive roller is stopped once the label sensor detects the gap between labels. Speed sensing capabilities enable the control unit to apply labels accurately as the base speed is changed.

5.2 Head Setup

5.3.1 Roll Installation and Web Path (Figure 7.0)

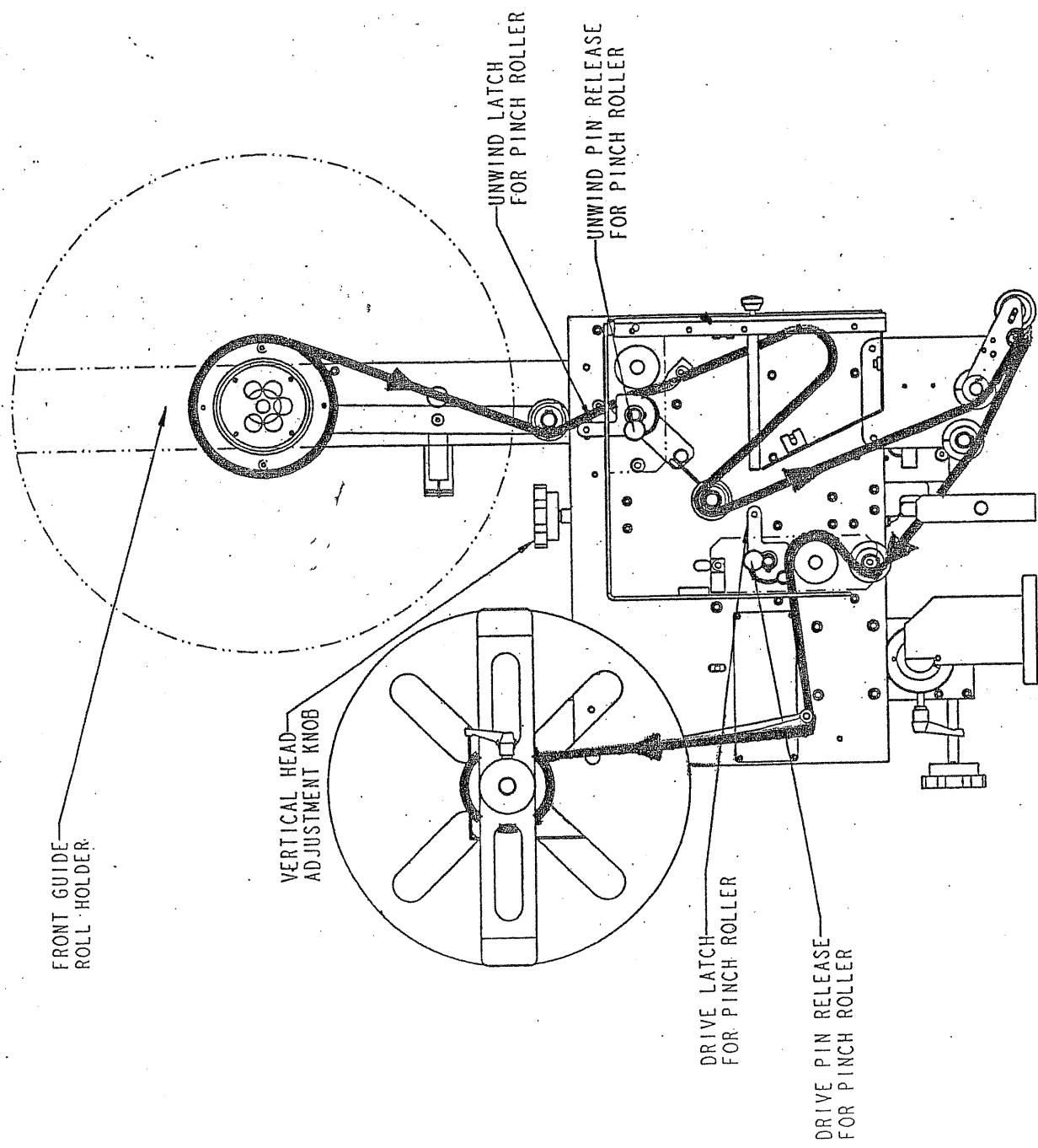
1. Remove the front guide of the roll holder assembly and install a new roll of labels onto the mounting hub. Install the roll so that as the free end is pulled, the roll rotates in the clockwise direction. Reinstall the front guide.
2. Disengage both pinch roller assemblies by pulling out each release 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.
5. Turn power on and check the label sensor is positioned in the center of the web.

5.3.2 Head Position

1. 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.
2. 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.
3. 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

1. Turn power on and set base belt speed to ~ 35 feet/minute.



WEB PATH
FIGURE 7.0

2. Press **Product Size** function key and enter the product length or select a previously saved job by pressing the **Read from Job** function key.
3. Press **Tab Type** function key and enter the tab or label material.
4. Press **Tab Size** function key and enter the tab size (inches) or the label length.
5. Press **Label Sensor Teach** function key and verify red light on amplifier is illuminated.
6. Run one product through the machine.
7. 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.
8. Press **Tab Mode** function key and select the number of tabs to apply.
9. If necessary, adjust tab position using the **Tab Position** function key.
10. Press **Reset Counter** function key.
11. 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 labels	Check unwind and drive roller pinch levers are locked in place. Verify the correct product detect beam switch is active (left or right).
Erratic label placement	Lower head until peel plate is slightly above the top of the product. Lower press down roller. Verify tab size matches the tab size parameter value in the user interface. Run label sensor teach program Clean product detect beam switch and its reflector. Clean loose tabs from the lower control rollers and plow fold Increase spring tension on press down roller Reduce machine speed
Web breaks	Inspect web for die cuts or edge nicks Ensure wear tape is attached to peel

	plate Remove adhesive buildup on web rollers.
Web wraps around unwind roller	Clean adhesive off of the unwind roller Center web deflector on the web and position it slightly away from the unwind roller.
Second label is placed off the end of the product	Check product size is correctly entered in the operator interface.
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. Remove dust from product sensor and reflector using a dry tissue.

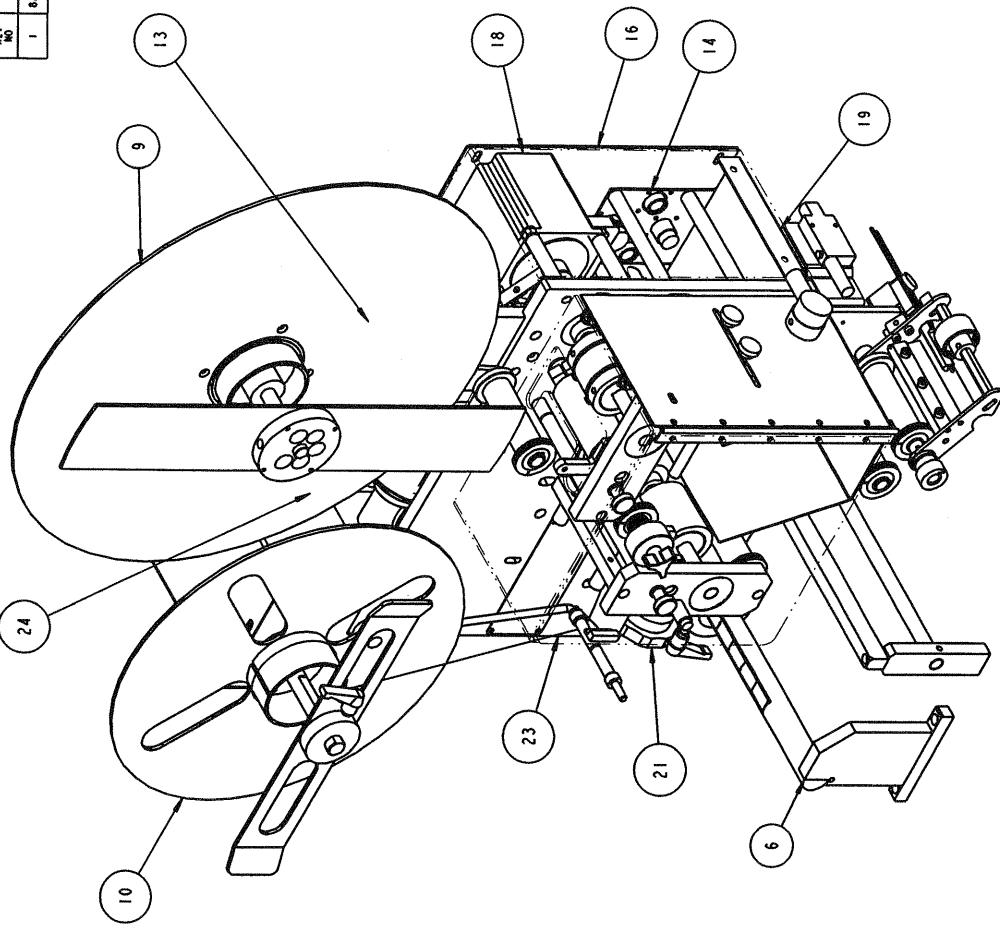
7.0 PARTS LISTS AND DIAGRAMS

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

7.1 KR535HD (stepper motor unwind) DIAGRAMS

538869-01	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
536832-19	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
536180-02	Assy, 535HD Stand & Controls

ITEM QTY	PART #	DESCRIPTION	REV A0	DATE	DESCRIPTION	ECN NO	BT
1	1	105014 BELT, TIMING 200X1037					
2	1	103857 PULLEY, 32XL037 .500B NK					
3	1	103990 PULLEY, TIMING 201D050 .500B NK					
4	1	200613 MOTOR, AC 1/20 HP					
5	1	108909-5 BELT, TIMING 32ZL050					
6	1	538382-04 ASSY-FRAME MOUNT					
7	1	536399-02 ASSY, PINCH ROLLER DRIVE					
8	1	536738-03 ASSY, PINCH ROLLER UNWIND					
9	1	536746-01 ASSY-LABEL ROLL					
10	1	536749-02 ASSY, REWIND					
11	1	53676-01 ASSY, VERTICAL ADJUSTMENT					
12	1	536769-02 ASSY-STRIPPER PLATE					
13	1	536780-02 COVER-IH					
14	1	536784-01 ASSY-ELECTRICAL CONNECTION PLAT					
15	1	53679-02 PLATE-TAKEUP MOTOR					
16	1	53679-02 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	536951-01 ASSY, FRAME CROSS ADJUSTMENT					
22	1	536957-01 ASSY, LABEL TRAY COVER					
23	1	531669-01 ASSY, FRAME W/ BEARINGS					
24	1	538164-02 COVER, REWIND SHAFT					
25	1	538829-01 ASSY, UNWIND CLUTCH					



ITEM	REV D WHERE USED	ITEM	REV D WHERE USED
TJG	SCALE: 0.300	MATERIAL: N/A	ITEM: 5335HD
CHECKED BY:	DATE: 26-Mar-01	REAR TREAT: N/A	ITEM: ASSY, KRS35HD
MAKER:	ALL DIMENSIONS ARE IN INCHES. NOT DRAWN TO SCALE. DRAWN TO SPECIFICATIONS ONLY.	MAKER: N/A	SCALE: 10F5
			ITEM: 538869-01

ITEM QTY	PART #	DESCRIPTION	REVISION	REV N/A	DATE	DESCRIPTION	ECN N/A	BY
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2	1	109857 PULLEY, 32XL037 .500B NK						
3	1	109990 PULLEY, TIMING 20L050 .500B NK						
4	1	200613 MOTOR, AC 1/20 HP						
5	1	108909-5 BELT, TIMING 322L030						
6	1	536382-04 ASSY-FRAME MOUNT						
7	1	536399-02 ASSY, PINCH ROLLER DRIVE						
8	1	536738-03 ASSY, PINCH ROLLER UNWIND						
9	1	536746-01 ASSY-LABEL ROLL						
10	1	536749-02 ASSY, REWIND						
11	1	536767-01 ASSY, VERTICAL ADJUSTMENT						
12	1	536769-02 ASSY-STRIPPER PLATE						
13	1	536780-02 COVER-LH						
14	1	536784-01 ASSY-ELECTRICAL CONNECTION PLAT						
15	1	536794-02 PLATE-TAKEUP MOTOR						
16	1	536797-02 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	536951-01 ASSY, FRAME CROSS ADJUSTMENT						
22	1	536957-01 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						

1 111
REV'D WHERE USED

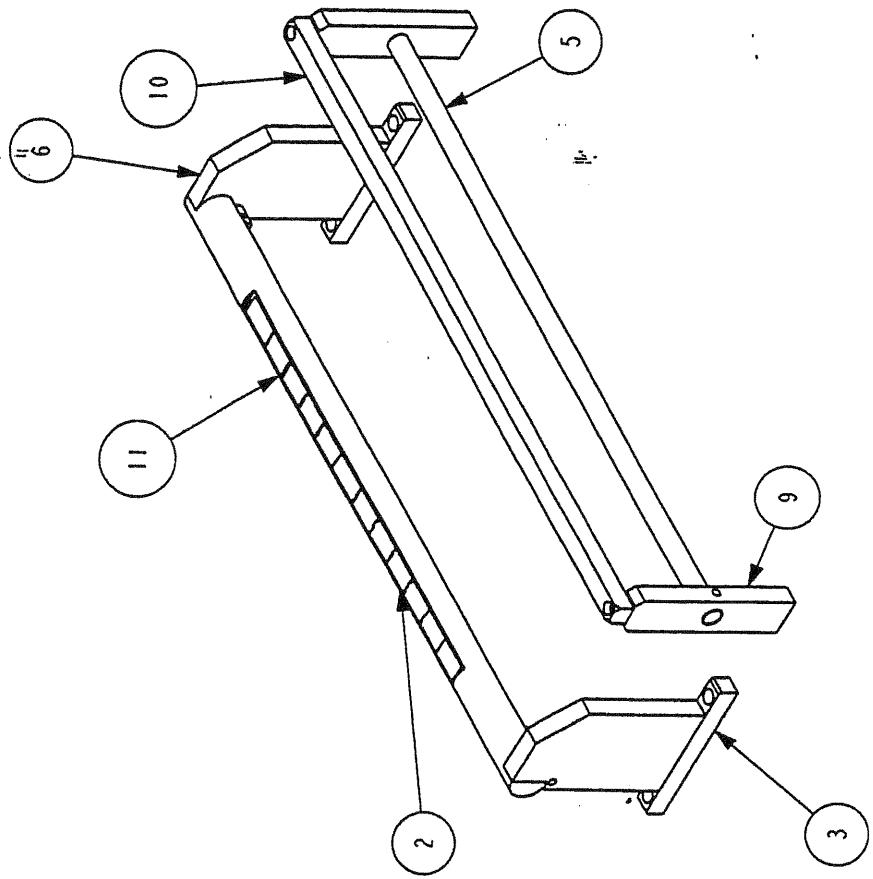
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SCALE:		0.200		PRINT DATE:	5/35HD
T.J.G				TIME:	40F5
				PRINTED IN U.S.A.	

KIRK - RUDY, INC.
KR WOODSTOCK, GEORGIA

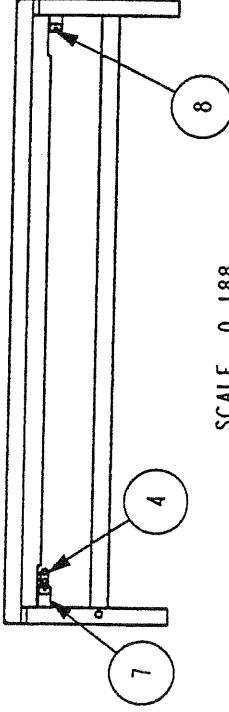
ASSY, KRS35HD

Reparte # 538869-01

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

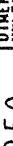


SCALE 0.188

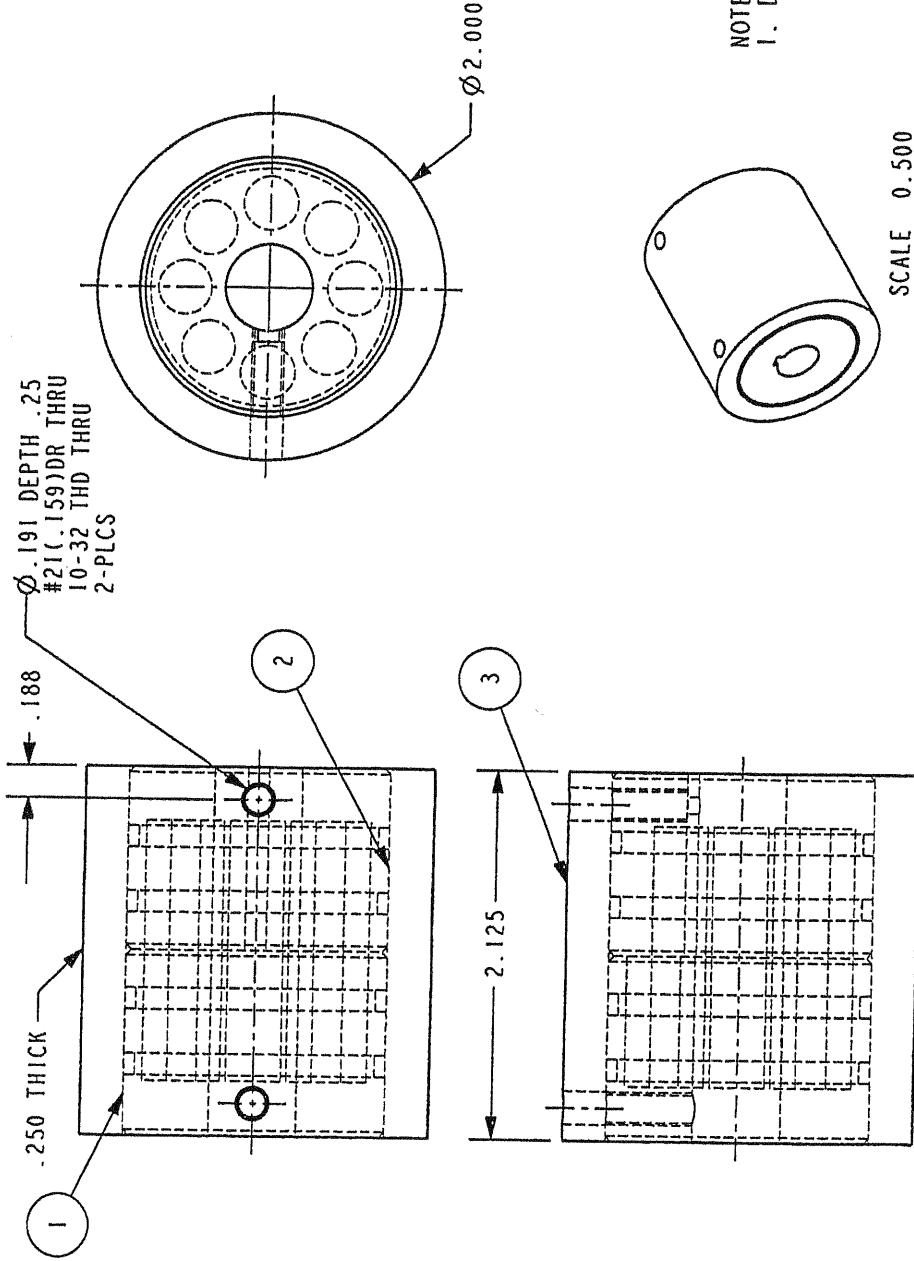


NOTE:

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

PRINTED BY:	TVK	SCALE:	0 . 250	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	MATERIAL:	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	KIRK - RUDY INC.	KIRK - RUDY INC.
CHECKED BY:		DATE:	22-0c†-99	.01 .005 .5	WEAT TREAT:			TIME:	KENNESAW, GEORGIA	KENNESAW, GEORGIA
HANDED BY:	MASICK	MATERIAL:		ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY		SP 76300		SHEET NO:	ASSY - FRAME MOUNT	ASSY - FRAME MOUNT
								DR. NO:	10F 1	10F 1
PRINTED ON 100% RECYCLED PAPER										PRINTED ON 100% RECYCLED PAPER

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



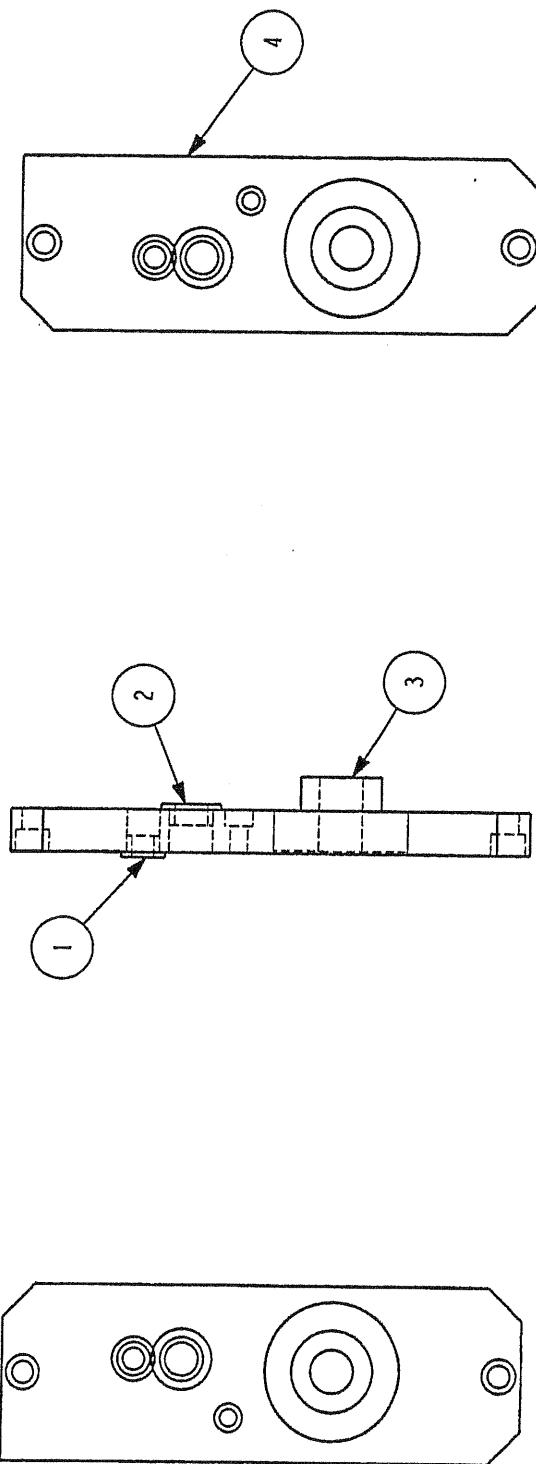
DRAWN BY:	T JG	SCALE	1 . 000	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	XXXX	MATERIAL:	XXXX	THIRD ANGLE PROJECTION	PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE QUOTED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC. KENNESAW, GEORGIA
CHECKED BY:		DATE	13-Dec-99	.xx	.005	ANG.	.5	HEAT TREAT:	XXXX
TRACED BY:				REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED				MODEL:	535
				ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY				SHEET NO.	10F1
								DRAWING #	536320-02
								REV'D	335
								WHERE USED	

KIRK - RUDY, INC.
KENNESAW, GEORGIA

ASSY, ROLLER DRIVE

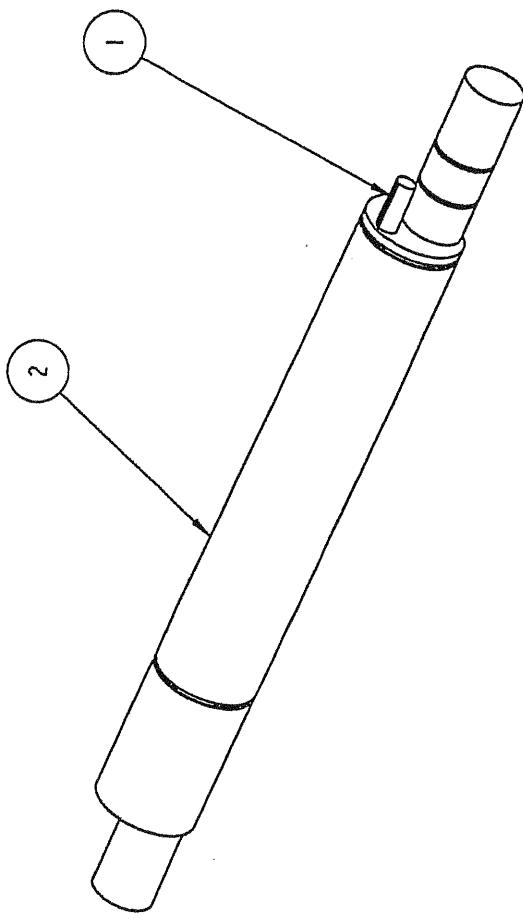
DRAWING # 536400-01

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



DRAWN BY: TVK	SCALE 0 .500	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED .xx -.005 .01 ANG.	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 13 - Aug - 99	BEAT TREAT: .5	MODEL: SP76300	TITLE: ASSY-BEARING PLATE	
TRACED BY:	MASTER M	FINISH: XXX	SHEET NO. OF 1	DRAWING # 536400-01	
REMOVED ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY					

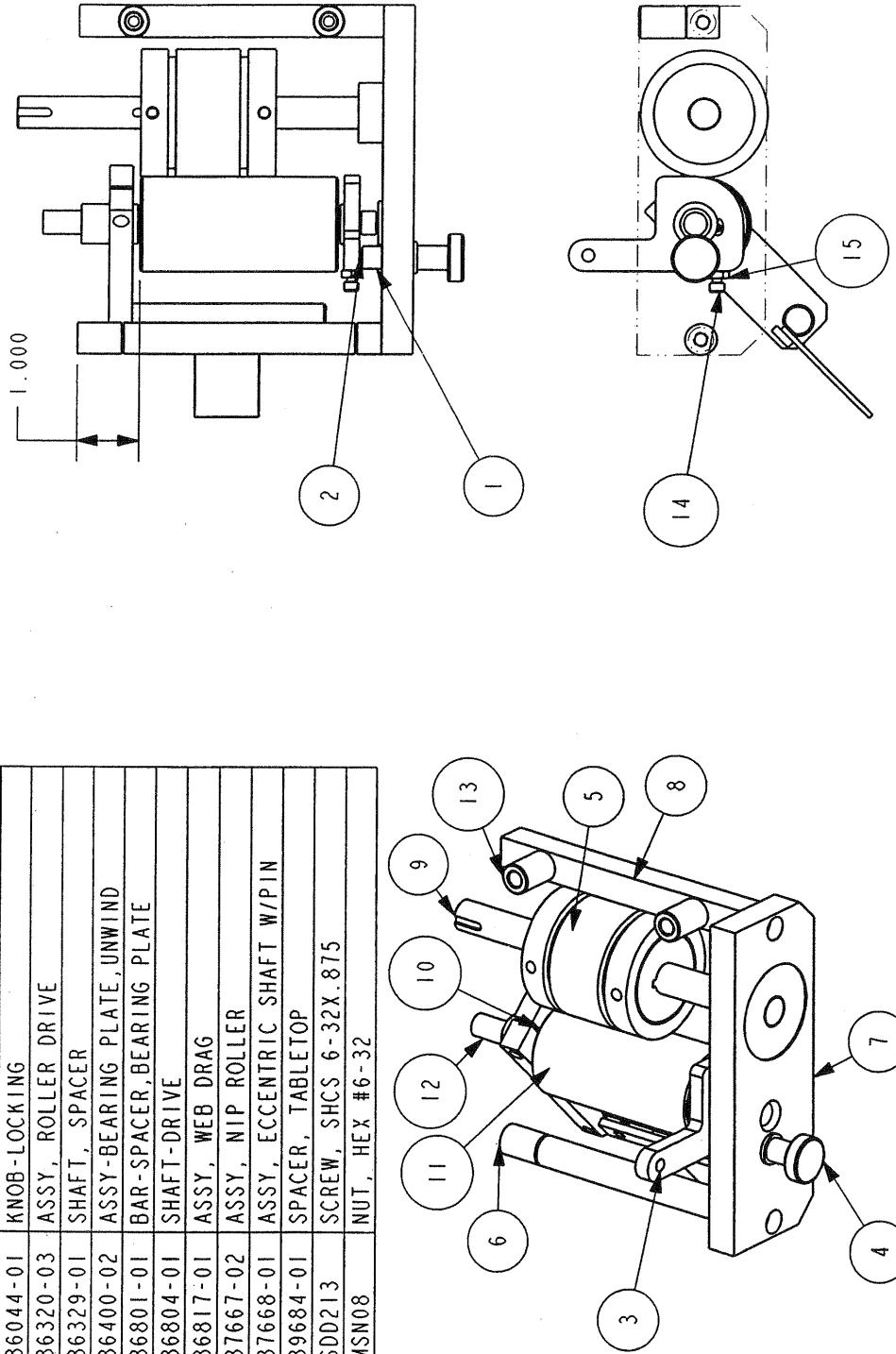
ITEM QTY	PART #	DESCRIPTION
1	1	05210 PIN, ROLL 125X.750
2	1	536328-01 SHAFT-ECCENTRIC



DRAWN BY:	T JG	SCALE	.000	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	XX	MATERIAL:	XXX	THIRD 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, GEORGIA	REF'D	KR335RD
CHECKED BY:		DATE	01 - NOV - 99	.01 .005 .5	ANG.	MEAT TREAT:	XXX	FIGURE	R	KIRK - RUDY, INC.	WHERE USED
TRACED BY:		MASTER	M	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY	FINISH:	MODEL:	535	SHEET NO.	10F1	DRAWING #	ASSY, ECCENTRIC SHAFT W/PIN

537668-01

ITEM	QTY	PART #	DESCRIPTION
1	1	102793	SPRING, COMP OD .36 W .03 L .75
2	1	104107	SNAFRING, .250
3	1	536037-01	PLATE-RELEASE
4	1	536044-01	KNOB-LOCKING
5	1	536320-03	ASSY, ROLLER DRIVE
6	1	536329-01	SHAFT, SPACER
7	1	536400-02	ASSY-BEARING PLATE UNWIND
8	1	536801-01	BAR-SPACER, BEARING PLATE
9	1	536804-01	SHAFT-DRIVE
10	1	536817-01	ASSY, WEB DRAG
11	1	537667-02	ASSY, NIP ROLLER
12	1	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



ITEM	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	1	10/10/2000	MODIFIED FOR WIRE STRIPPER ADDED WIRE GROOVES TO ROLLER	6596	TJS

1.000	RR535SHD
REQ'D	WHERE USED

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 30144 USA	
CHECKED BY:		DATE 22-0C 1 - 99	.01	.005	AMT. .5	HEAT TREAT:	XXX	KIRK - RUDY, INC. KENNESAW, GEORGIA
TRACED BY:		MASTER <i>m</i>	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED		FINISH: ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY	MODEL: 535	SHEET NO. OF 1	TITLE: ASSY, PINCH ROLLER UNWIND DRAWING #
								536738-03

ITEM QTY	PART #	DESCRIPTION
1	536312-02	ROLLER-CORE
2	536313-02	ROLLER-CORE, KEYED
3	5363397-02	COATING, URETHANE DUR60

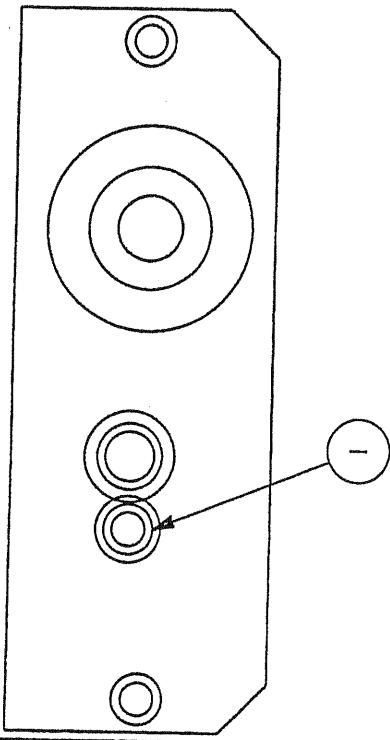
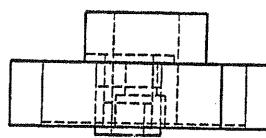
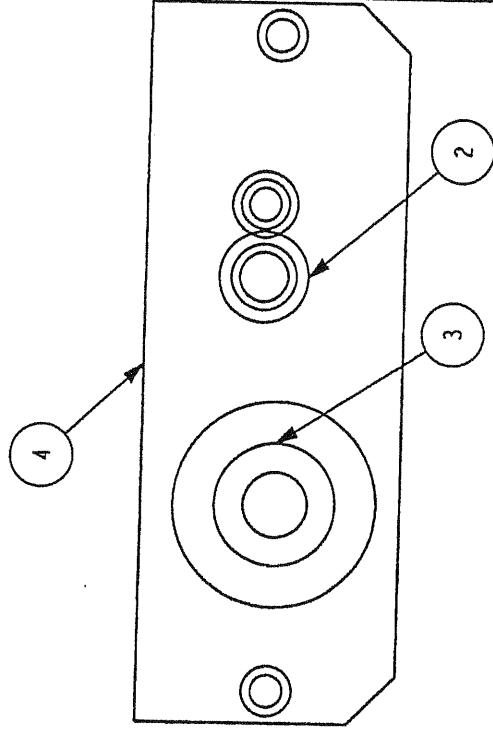
ITEM	QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	1	536312-02	ROLLER-CORE					
2	1	536313-02	ROLLER-CORE, KEYED					
3	1	536397-02	COATING, URETHANE DUR60					

NOTE:
1. DUROMETER 60

SCALE 0.500

DRAWN BY: T J G	SCALE 1 .000	MATERIAL: XXX	THIRD ANGLE PROJECTION E - - - - -	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
CHECKED BY: 	DATE 19 - MAY - 00	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED .00 .015 .005 .5 ANG.	FINISH: XXX	TIME: 5335
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 #: ASSY, ROLLER DRIVE 536320-03
			I	536320-03 REV'D WHERE USED

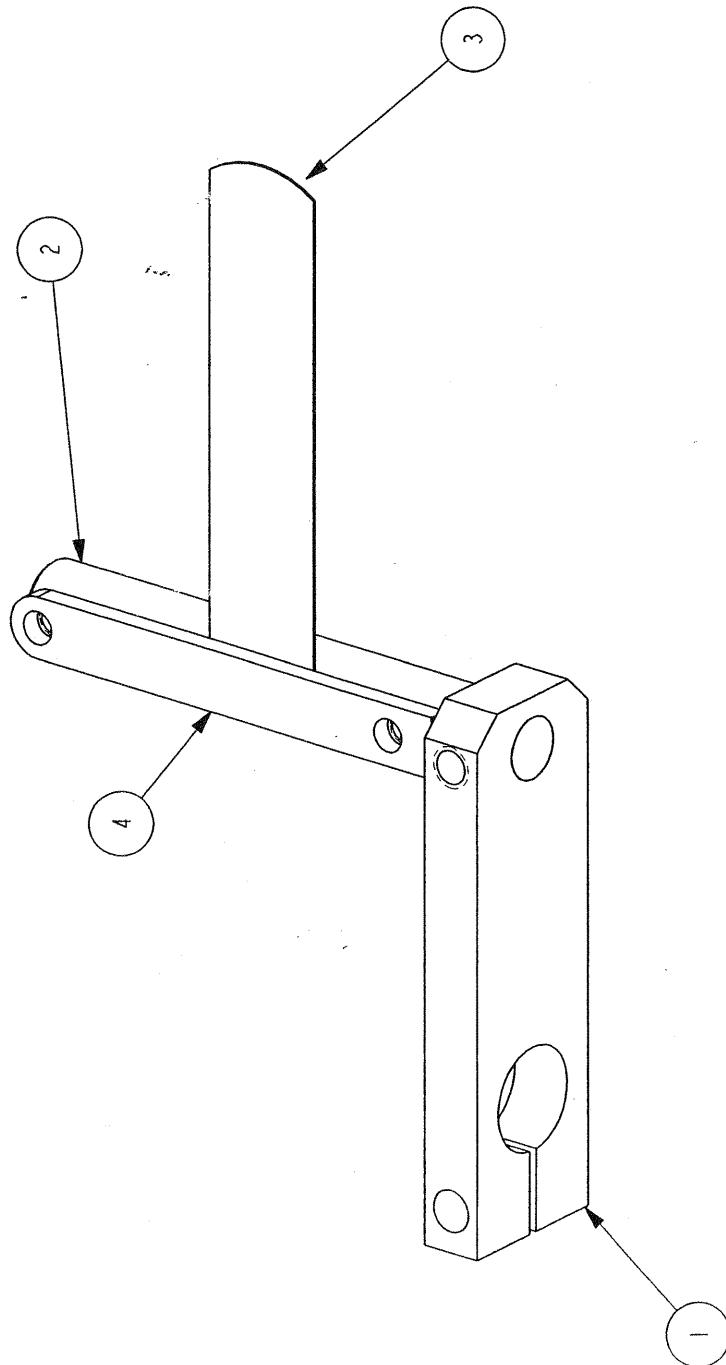
ITEM QTY	PART #	DESCRIPTION
1	100309	BUSHING, FL. 250ID. 375OD. 250LG
2	100330	BUSHING, FL. 375ID. 500OD. 250LG
3	103803	BEARING, HUB .500
4	536732-02	PLATE-BEARING, UNWIND



1	SP76300		
RECD	WHERE USED		
KRK KIRK - RUDY, INC. KENNESAW, GEORGIA			
ASSY - BEARING PLATE, UNWIND			
SCALE:	0 . 750		
DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED			
.01	.005	.005	.005
DATE:	13 - Aug - 99		
CHECKED BY:	REMOVED ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED		
TRACED BY:	ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY		
MATERIAL:	XXX		
THIRD ANGLE PROJECTION			
NOTE:	SP76300		
SHEET NO. OF 1	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		

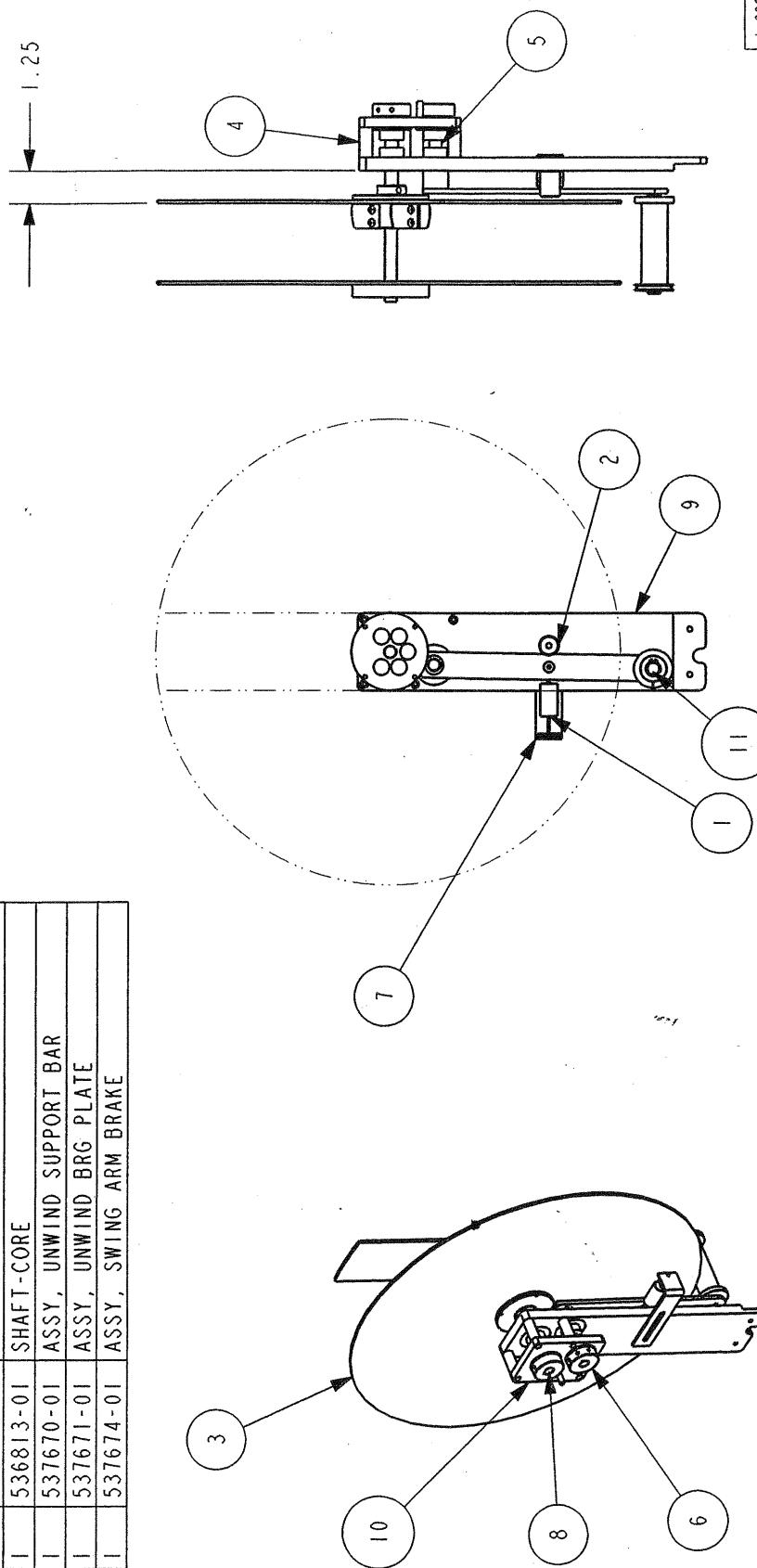


1	SP76300	REQ'D WHERE USED
	KIRK - RUDY, INC. KENNESAW, GEORGIA	
	SP76300	TITLE: ASSY, WEB DRAG
	SHEET NO. 0 OF 1	DRAWING # 536817-01

DRAWN BY: <i>TVK</i>	SCALE 1.000	MATERIAL: N/A	THIRD ANGLE PROJECTION	PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE QUOTED OR REPRODUCED IN WHOLE OR IN PART EXCEPT WITH WRITTEN PERMISSION OF KIRK RUDY, INC. KENNESAW, GA 30144 USA
CHECKED BY: <i>03-Nov-03</i>	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED .xx .xxx .005 .5 ANG.	HEAT TREAT: N/A		
TRACED BY: <i>M</i>	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: SP76300	
MASTER				

ITEM QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	102775	SPRING, EXT EO 500-055-1750M	1	11/8/2004	REPLACED 536352-02 W-10 REPLACED 527651-6 W-12 SEE ASSY#536763-01	7118	TJG
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					

ITEM QTY	PART #	DESCRIPTION	SCALE	SCALE	SCALE
1	102775	SPRING, EXT EO 500-055-1750M	0 . 156	N/A	0 . 125
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			



1.000	KRS35HD
REV'D	WHERE USED

KIRK - RUDY, INC.
KENNESAW, GEORGIA



KIRK - RUDY, INC.
KENNESAW, GEORGIA

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

TIME:
SP76300

MASTER M

SCALE 0 . 125

SCALE 0 . 156

SCALE 0 . 156

DATE 22-0C1-99

REMOVED ALL BURRS AND
SHARP EDGES UNLESS
OTHERWISE NOTED

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

MASTER M

REV'D

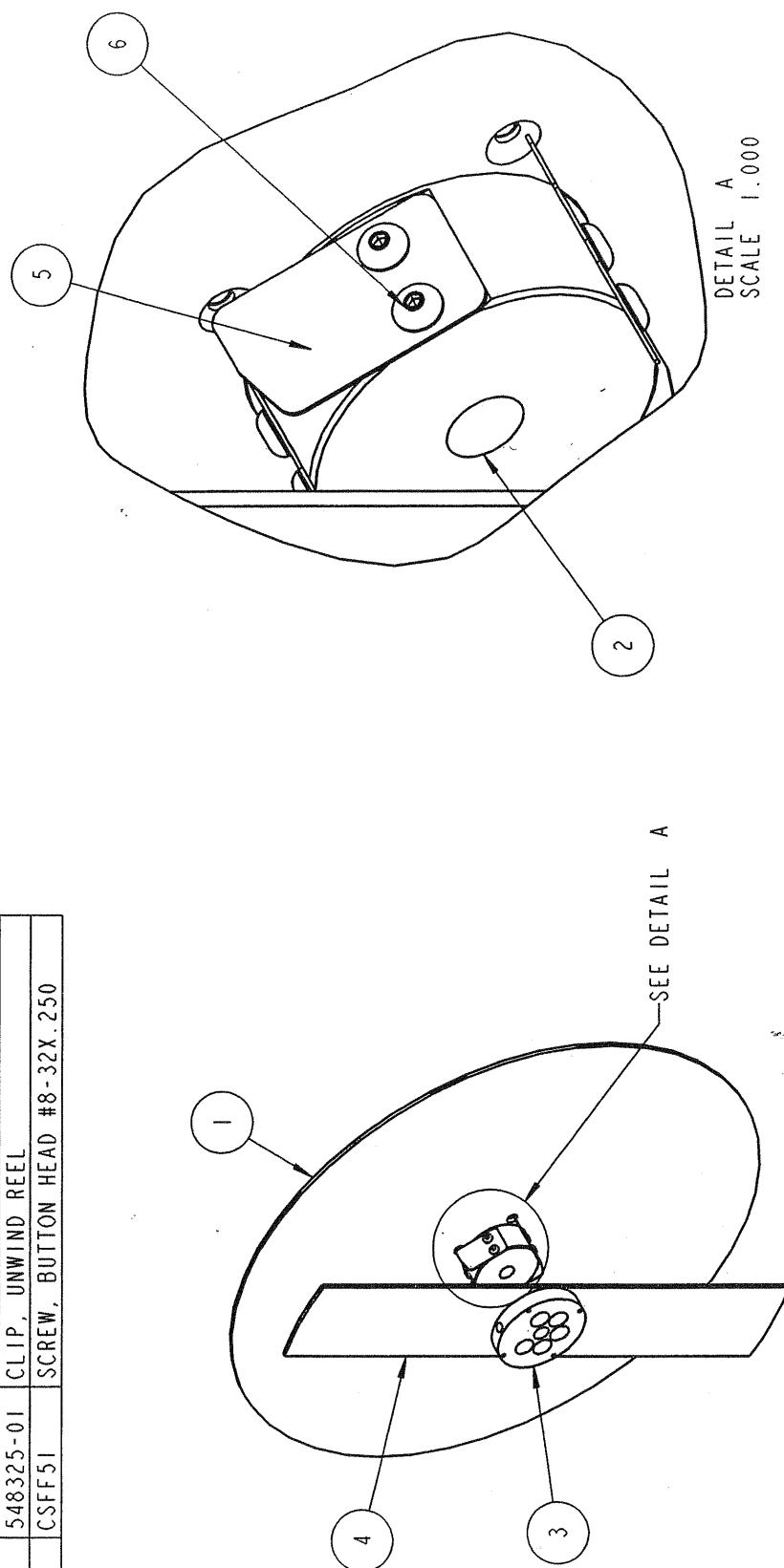
WHERE USED

1 OF 1

DRAWING #

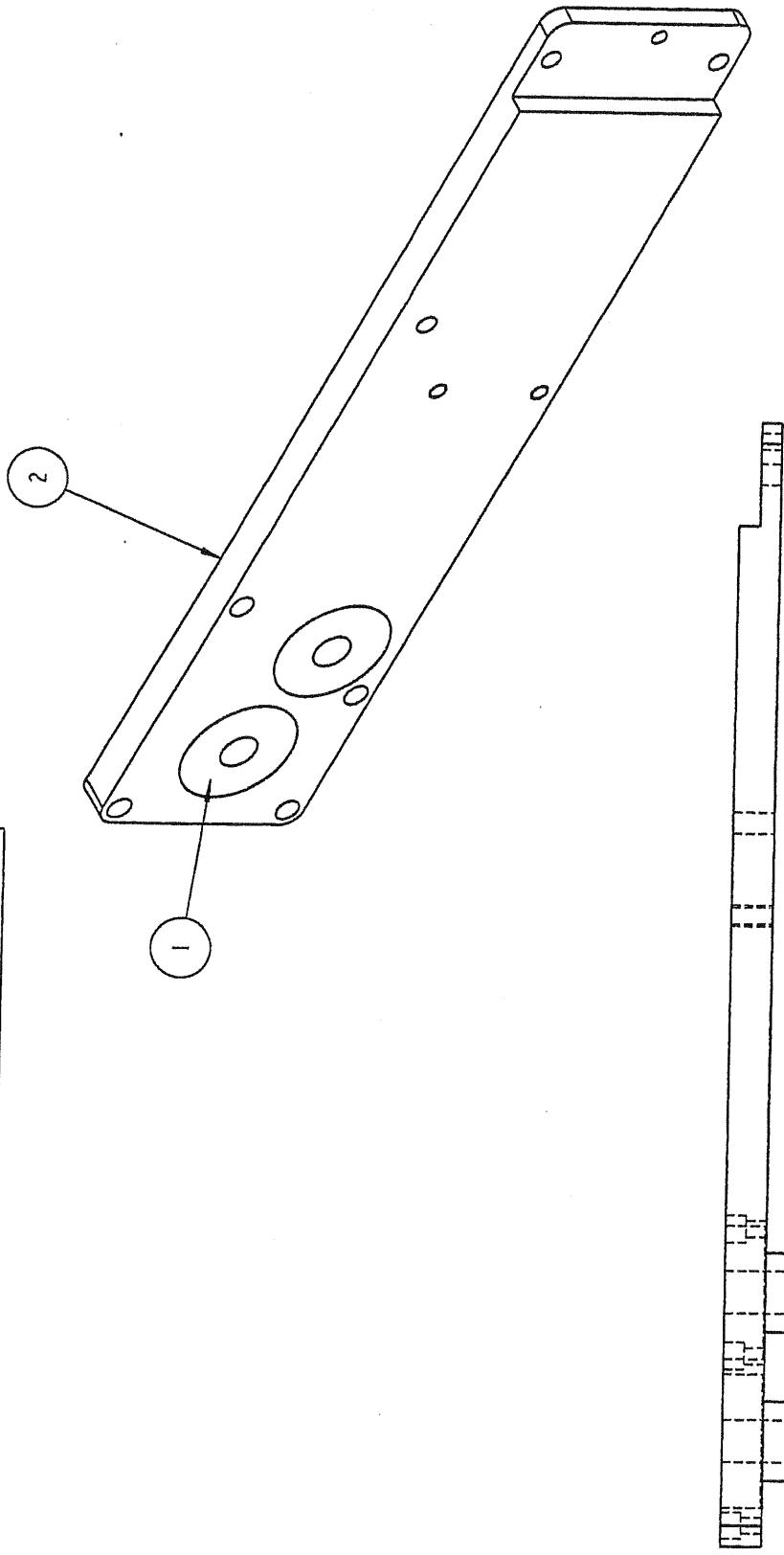
536746-01

ITEM	QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	1	527651-12	DISK, LABEL UNWIND					
2	1	536352-10	HUB, UNWIND REEL					
3	1	536353-01	HUB-REEL					
4	1	536354-01	PLATE-UNWIND					
5	4	548325-01	CLIP, UNWIND REEL					
6	8	CSFF51	SCREW, BUTTON HEAD #8-32X.250					



DRAWN BY:		SCALE	0 . 188	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	MATERIAL: N/A	THIRD ANGLE PROJECTION	PROPRIETARY AND CONFIDENTIAL MAY BE OBTAINED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC. KENNESAW, GA 30144 USA	RECD WHERE USED
CHECKED BY:		DATE	05-Nov-04	.01 .005 .5 ANG.	HEAT TREAT: N/A	MODEL: SAA317	TITLE: ASSY, UNWIND WHEEL	I
TRACED BY:	M	MASTER		REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED	FINISH: N/A	SHEET NO: 1 OF 1	DRAWING #:	536763-01
				ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY				

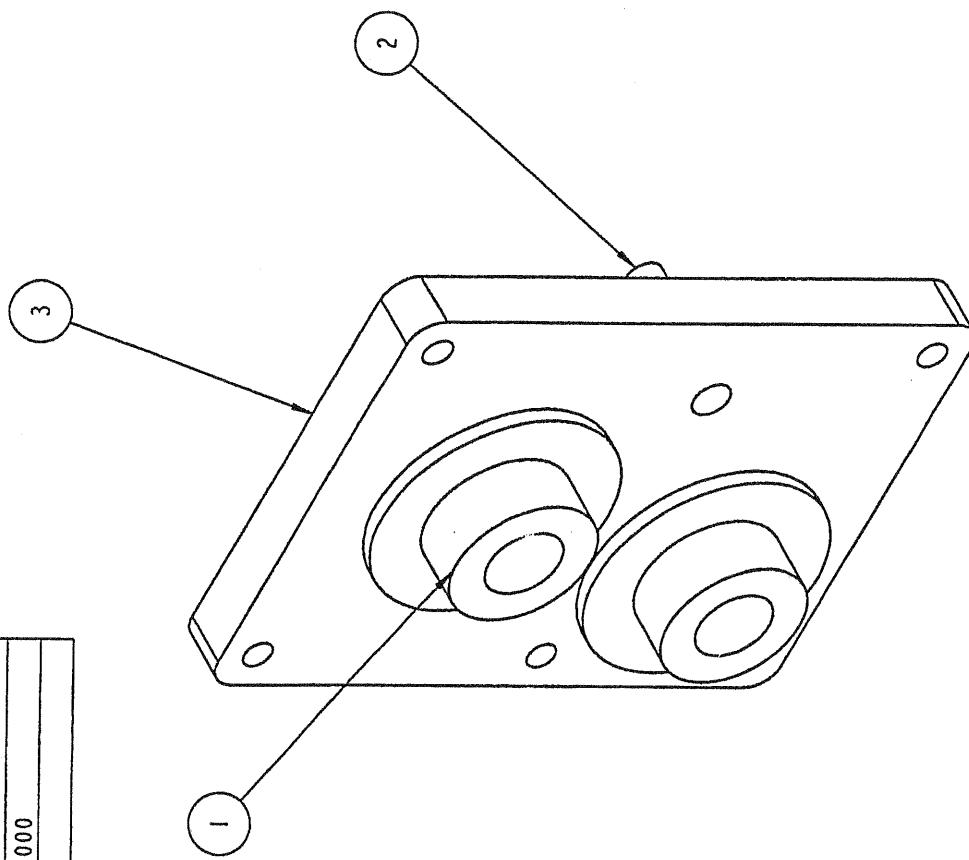
ITEM QTY	PART #	DESCRIPTION
1 2	103803	BEARING, HUB .500
2 1	536741-01	PLATE - REEL



REV NO.	DATE	DESCRIPTION	ECN NO	BY
1 KRS535HD RED'D WHERE USED				
KIRK - RUDY, INC. KENNESAW, GEORGIA  <small>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</small>				
TITLE:				
NOTE: 535				
ASSY, UNWIND SUPPORT BAR				
DRAFTING # 537670-01				
SHEET NO. 1 OF 1				

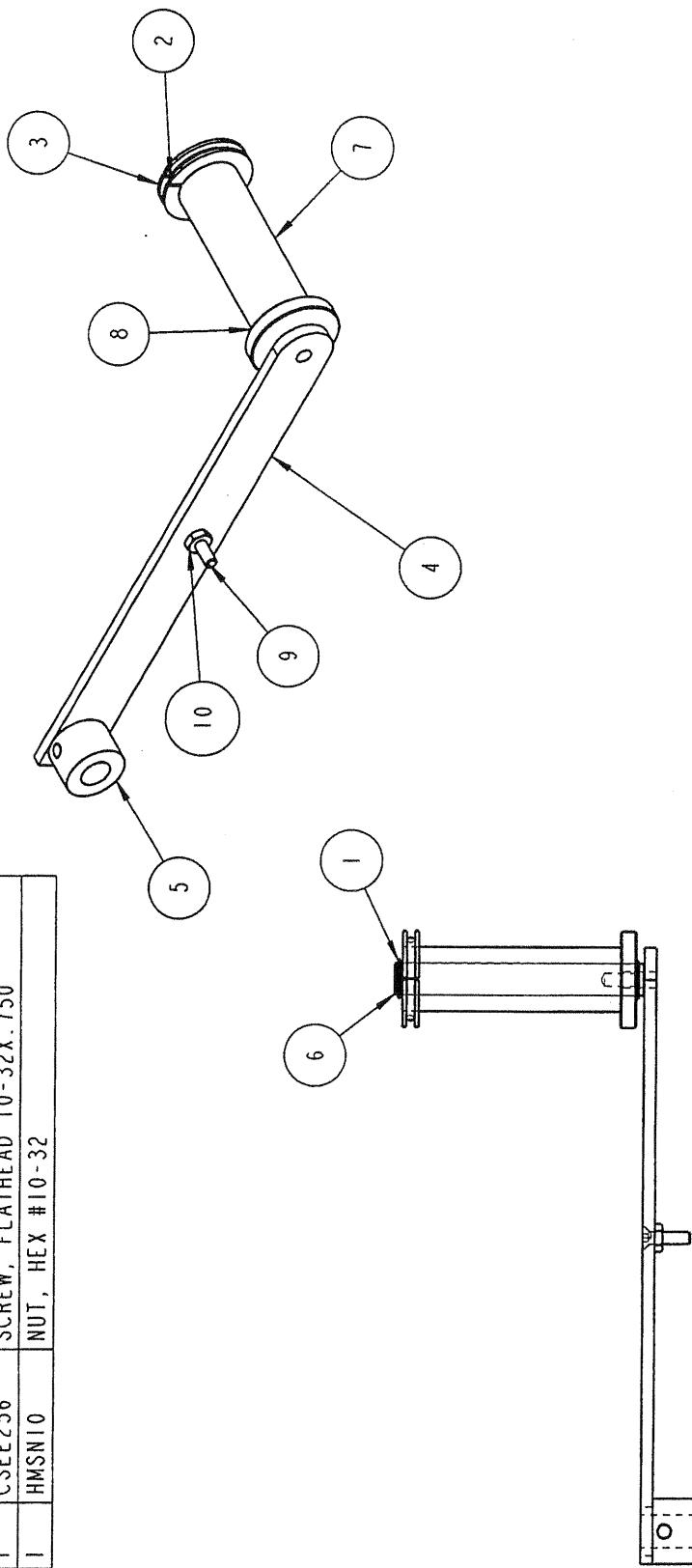
DRAWING # 537671-01

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



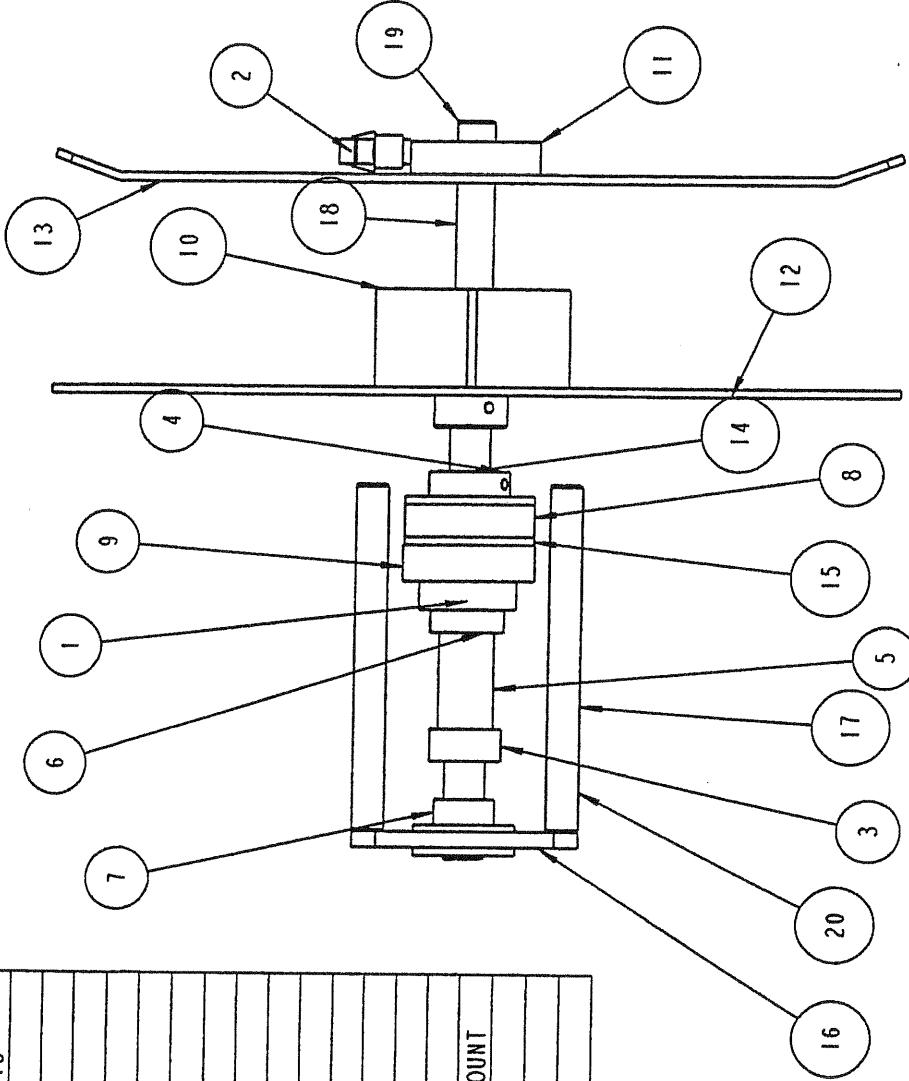
DRAWN BY:	SCALE:	1.000	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	X X X	THIRD ANGLE PROJECTION	PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE QUOTED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC. KENNESAW, GA 30144 USA
checked by:	DATE:	01-Nov-99	.005	.5	REAR TREAT:	X X X
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
					LINE:	ASSY, UNWIND BRG PLATE
					SHEET NO.:	10F1
					DRAWING #:	537671-01
					REV'D:	KR535HD
					WHERE USED:	

ITEM	TYPE	QTY	PART #	DESCRIPTION
1	PART	2	104106	SNAPRING, .500
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



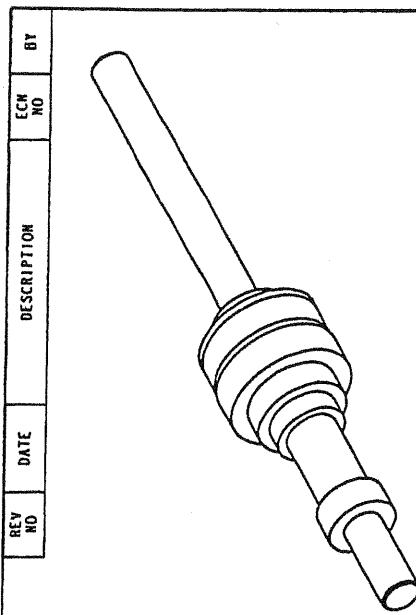
DRAWN BY:		SCALE	MATERIAL:	THIRD ANGLE PROJECTION	PROPRIETARY AND CONFIDENTIAL	RELD TO WHERE USED
T JG		0.375	XXX		NO PART OF THIS DRAWING MAY BE QUOTED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY INC.	KIRK - RUDY, INC. KENNESAW, GEORGIA
CHECKED BY:		0.01 .005 .005	AMG			
DATE		01 - Nov - 99	FLAT TREAT:	XXX	MODEL: 535	TITLE: ASSY, SWING ARM BRAKE
TRACED BY:		MASTER M	FINISH:	XXX	SHEET NO.: 10F1	DRAWING #
DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED		.01 .005 .005	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED	ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK ONLY TO DIMENSIONS		

ITEM / QTY	PART #	DESCRIPTION
1 1	100145	BUSHING, SL. 62510.813001.0000LG
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	190720	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

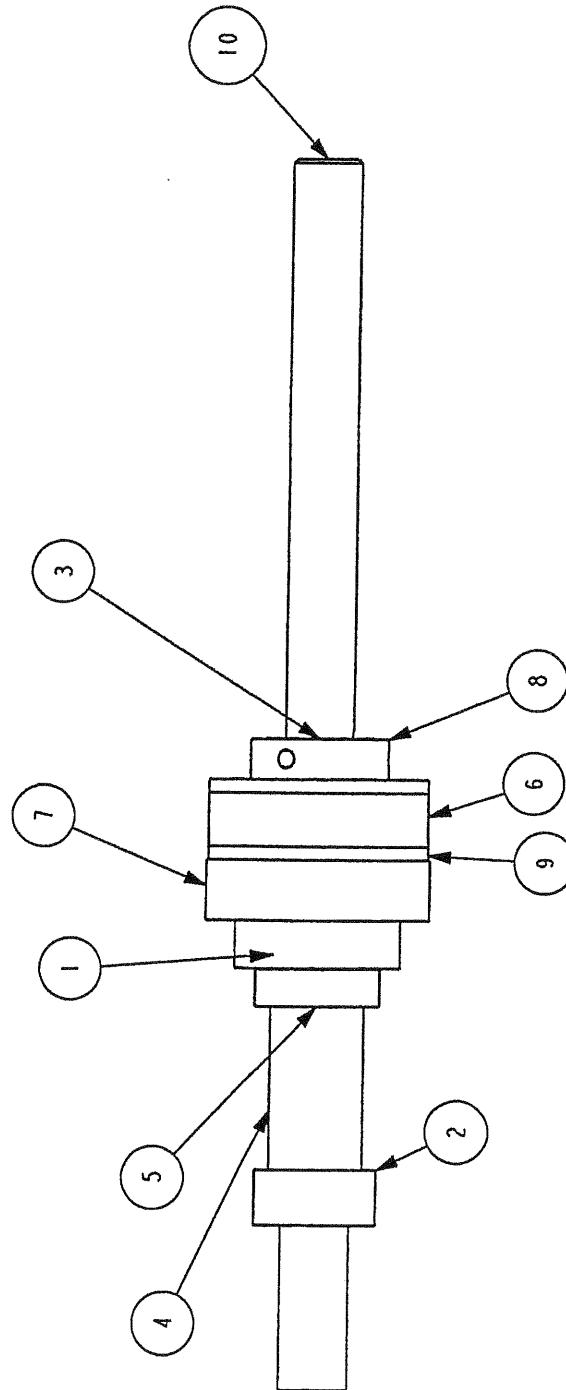


DRAWN BY:	SCALE	1	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	MATERIAL:	THIRD ANGLE PROJECTION	PROPRIETARY AND CONFIDENTIAL
T JG	0.	125	N/A	N/A	+	NO PORTION OF THIS DRAWING MAY BE OBTAINED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC. KENNESAW, GA 30044 USA
CHECKED BY:	DATE	.01	.005	WEAR TREAT:	535	MODEL:
	22-0ct-99	.01	.005	N/A		535
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
	M					DRAWING #
						ASSY, REWIND
						536749-02
						I KRS3350 REQ'D WHERE USED

ITEM QTY	PART #	DESCRIPTION
1	1 00145	BUSHING. SL.625ID.8130DI.000LG
2	1 02203	COLLAR .625
3	2 102564	SHIM. .625X1.000X.010
4	1 102722	SPRING, COMPRESSION
5	1 103211	BEARING, BALL THRUST .625
6	1 190720	DISC, F3 FELT
7	1 108772-1	PULLEY, 32XL037
8	1 527695-1	HUB, TAKEUP
9	1 527697-1	DISC, TAKEUP
10	1 536803-01	SHAFT, TAKE-UP



SCALE 0.375



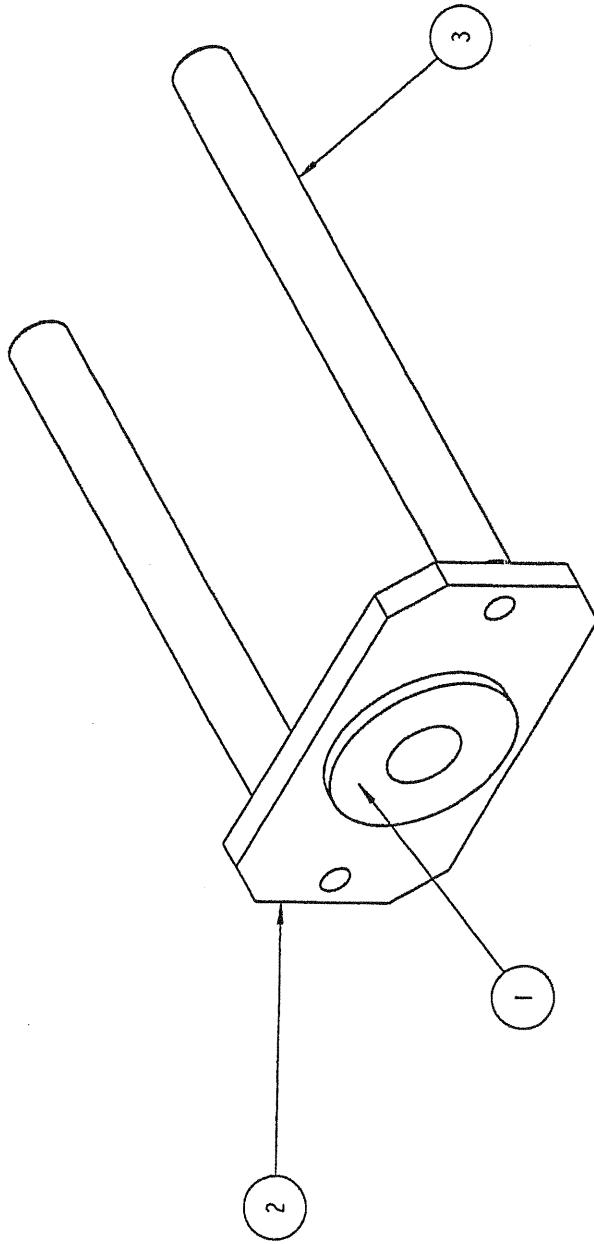
DRAWN BY:	SCALE	MATERIAL:	THIRD ANGLE PROJECTION	PROPRIETARY AND CONFIDENTIAL
TVK	0 . 625	N / A		NO PORTION OF THIS DRAWING MAY BE QUOTED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC. KENNESAW, GA 3044 USA
CHECKED BY:	DATE	UNLESS OTHERWISE NOTED		TIME:
	24 - Sep - 99	.01 .005 .5		
TRACED BY:	MASTER	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY		DRAWING #
	M	N / A	TOP	536959-01

REC'D	RECD'D	WHERE USED
1	SP76300	

ASSY - SLIP CLUTCH

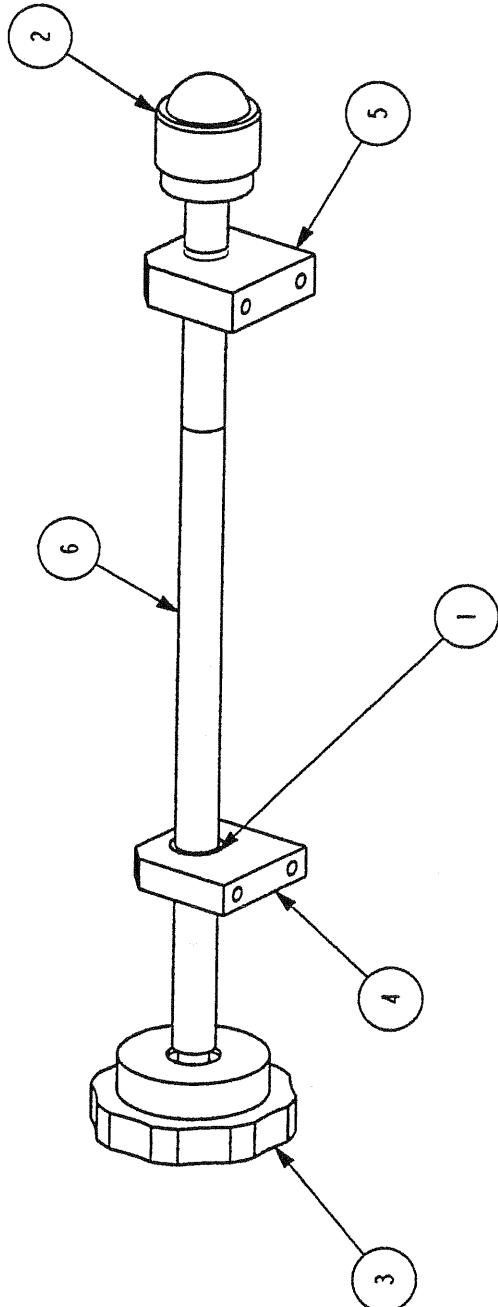
536959-01

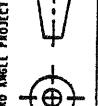
ITEM QTY	PART #	DESCRIPTION
1	1 03804	BEARING, HUB .625
2	1 536795-01	PLATE-BEARING
3	2 536802-01	BAR-ROUND, BEARING PLATE MOUNT



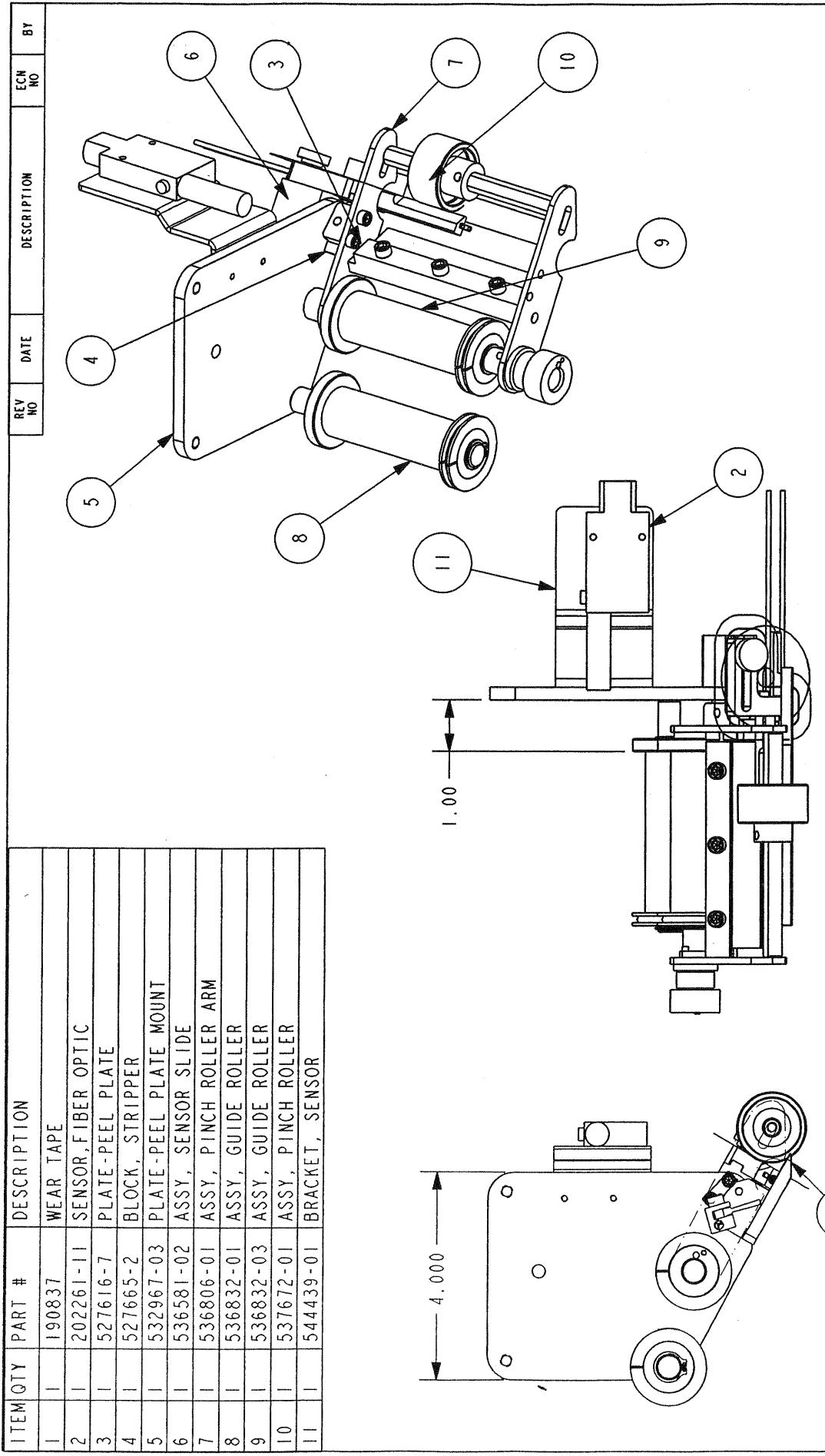
1	KRS3SHD	
REV D	WHERE USED	
 KIRK - RUDY, INC. KENNESAW, GEORGIA		
<small>NO PORTION OF THIS DRAWING MAY BE QUOTED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC. KENNESAW, GA 30144 USA</small>		
DRAWN BY: T JG	SCALE: 0 . 750	
DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED		
.01	.005	.5
DATE: 01 - Nov - 99	MATERIAL: XXX	
MEAT TREAT:		
REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED		
ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY		
CHECKED BY: MASTER	535	MODEL:
TRACED BY:	XXX	FINISH:
SHEET NO. 1 OF 1		TITLE: ASSY, REWIND BRG SUPPORT
		DRAWING #: 537673-01

ITEM QTY	PART #	DESCRIPTION
1	100133	BUSHING, SL. 50010.6250D.375LG
2	103955	BALL TRANSER
3	500712	KNOB
4	1	536796-01 PLATE-BUSHING
5	1	536796-02 PLATE-THREADED ADJUSTMENT
6	1	536822-01 SHAFT-VERT. ADJ



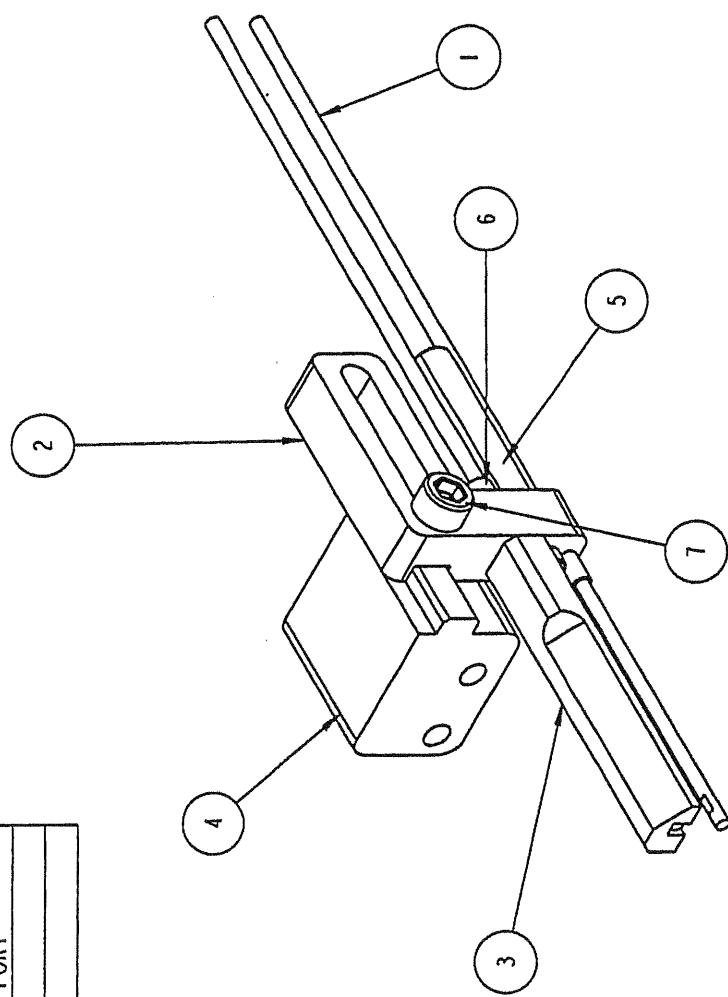
1.000	KRASSHD																								
REV'D	WHERE USED																								
 KIRK - RUDY, INC. KENNEBUNK, GEORGIA																									
Title:																									
SHEET NO. 1 OF 1																									
DRAWING # 536767-01																									
DRAWN BY: VK SCALE: 0 . 500 MATERIAL: N / A DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED <table border="1" style="margin-left: auto; margin-right: auto;"> <tr> <td>.01</td> <td>.005</td> <td>.005</td> <td>.01</td> <td>.005</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>MM</td> </tr> </table> HEAT TREAT: N / A THIRD ANGLE PROJECTION: 		.01	.005	.005	.01	.005	.005	.005	.005	.005	.005	.005	.005	MM											
.01	.005	.005	.01	.005	.005	.005	.005	.005	.005	.005	.005														
MM	MM	MM	MM	MM	MM	MM	MM	MM	MM	MM	MM														
CHECKED BY: 25-0c† - 99 PROPRIETARY AND CONFIDENTIAL REMOVAL OR DISMANTLING OF THIS DRAWING IS PROHIBITED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC. KENNEBUNK, GA 30144, USA																									
TRACED BY: M WORKS: SP76300 DATE: 25-0c† - 99																									
ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY																									

ITEM QTY	PART #	DESCRIPTION
1	190837	WEAR TAPE
2	202261-11	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



DRAWN BY:	SCALE	DATE	REMOVED ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED	MATERIAL:	THIRD ANGLE PROJECTION	PROPRIETARY AND CONFIDENTIAL
T JG	0 . 375	.xx	.01 .005 .5	N / A	-	NO PORTION OF THIS DRAWING MAY BE COPIED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC.
CHECKED BY:		12 - NOV - 03		N / A		WOODSTOCK, GEORGIA
TRACED BY:	MASTER		REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED	MODEL: 535	SHEET NO: 10F2	TITLE: ASSY - STRIPPER PLATE
			ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY	FINISH: N / A		DRAWING #: 536769-02

ITEM QTY	PART #	DESCRIPTION
1	202261-12	FIBER, PLASTIC PIPSM26U
2	538157-01	BLOCK, FIBER OPTIC MOUNT
3	538158-01	GUARD, FIBER OPTIC
4	538159-01	BLOCK, SENSOR SLIDE
5	538163-01	SHAFT, FIBER OPTIC SUPPORT
6	CSDDI53	
7	CSDD266	



ITEM QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	2	202261-12 FIBER, 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	CSD0153					
7	1	CSD0266					

DRAWN BY: T JG SCALE: 1 . 000 DIMENSIONAL TOLERANCES MATERIAL: XXX UNLESS OTHERWISE NOTED .01 .015 .065 .5 MEAN TREAT: XXX DATE: 29 - Dec - 99 REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED FINISH: XXX ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY

CHECKED BY: TRACED BY: M

1 536769-02
REV'D WHERE USED

KIRK - RUDY, INC.
KENNESAW, GEORGIA

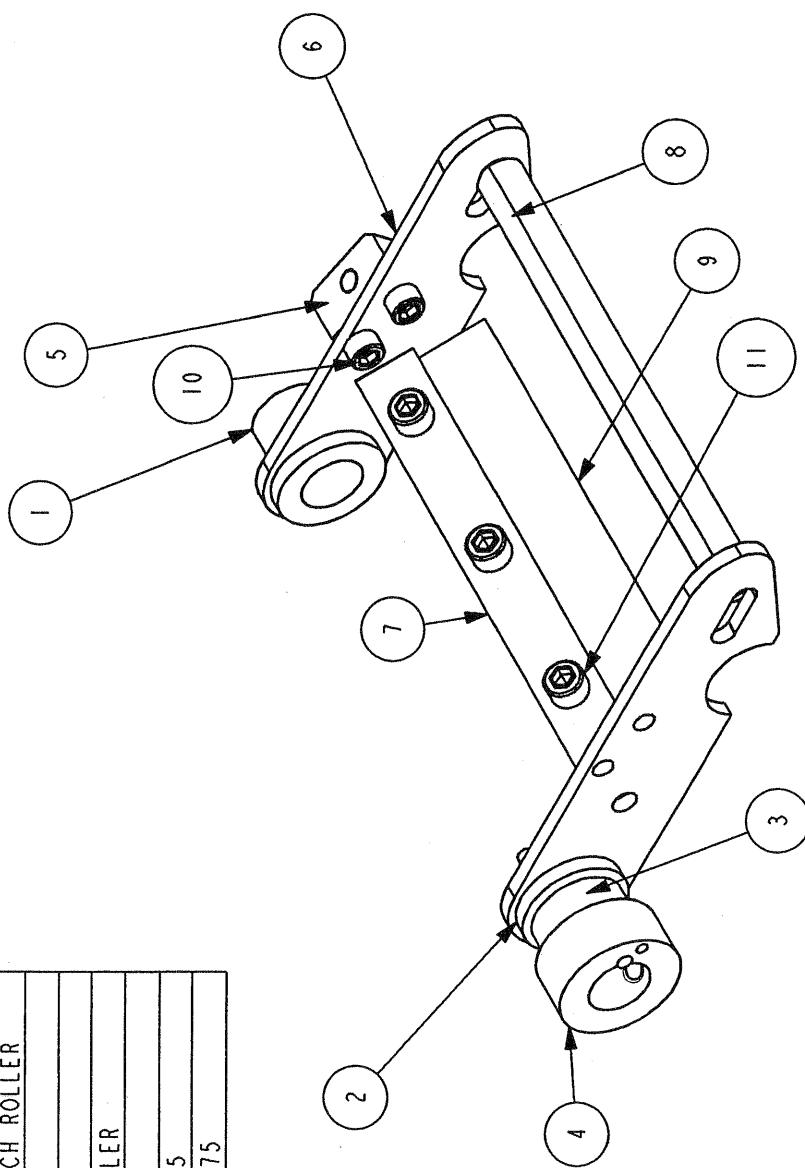
ASSY, SENSOR SLIDE

535

1 OF 1

536581 - 02

ITEM QTY	PART #	DESCRIPTION
1	100304	BUSHING, FL. 500ID. 6250D. 750LG
2	100323	BUSHING, FL. 500ID. 6250D. 375LG
3	102785	SPRING, TORSION
4	102205-2	COLLAR
5	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



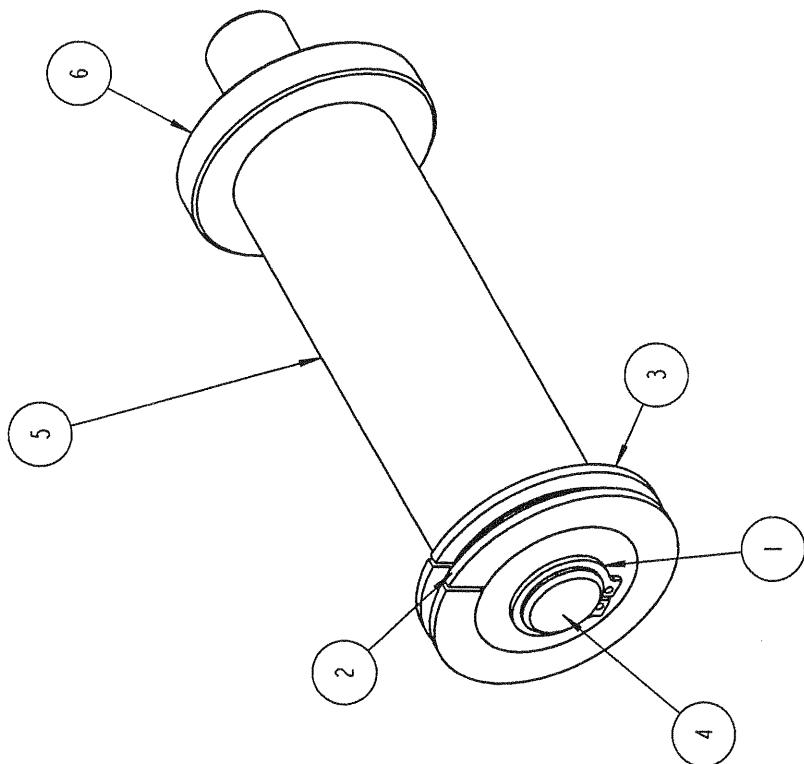
REV NO	DATE	DESCRIPTION	ECN NO	BY
1	8/11/2002	ADDED 543367-01 AND 536773-04 DELETED 536773-01	6865	TJS

REC'D	WHERE USED
1	SP76300

DRAWN BY: TVK	SCALE: 0 .750	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED		MATERIAL: XXX	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 30044 USA	
CHECKED BY:	DATE: 10 - Sep - 99	.XX	.XXX	ANG. .01 .005 .5	HEAT TREAT: XXX	MODEL: SP76300	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 #: ASSY , PINCH ROLLER ARM

536806-01

ITEM	QTY	PART #	DESCRIPTION
1	2	104106	SNAPRING, .500
2	1	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

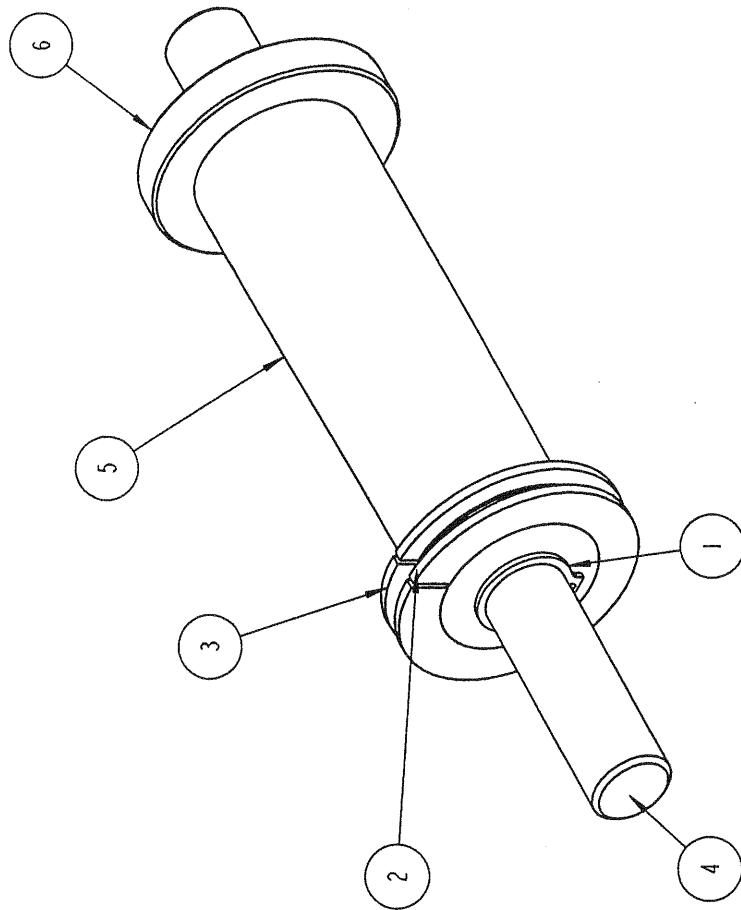


ITEM	QTY	PART #	DESCRIPTION	REV NO	DATE	ECN NO	BY
				1	7/2/2001	REPLACED EXL SPRING WITH O-RING	6713 T.G

1	KR535HD
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 30044 USA	THIRD ANGLE PROJECTION	KIRK - RUDY, INC. KENNESAW, GEORGIA
	ORTHOGRAPHIC	ASSY, GUIDE ROLLER
	MODEL: SP76300	DRAWING #
	SHEET NO. 1 OF 1	536832 - 01
DRAWN BY: T.J.G.	SCALE: 1.000	MATERIAL: N/A
CHECKED BY:	DATE: 25-0c1-99	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED .01 -.005 .5 .01 -.005 .5 HEAT TREAT: N/A
TRACED BY:	MASTER M	FINISH: N/A REMOVE ALL BURS AND SHARP EDGES UNLESS OTHERWISE NOTED ALL DIMENSIONS ARE IN INCHES DO NOT SCALE - WORK TO DIMENSIONS ONLY

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

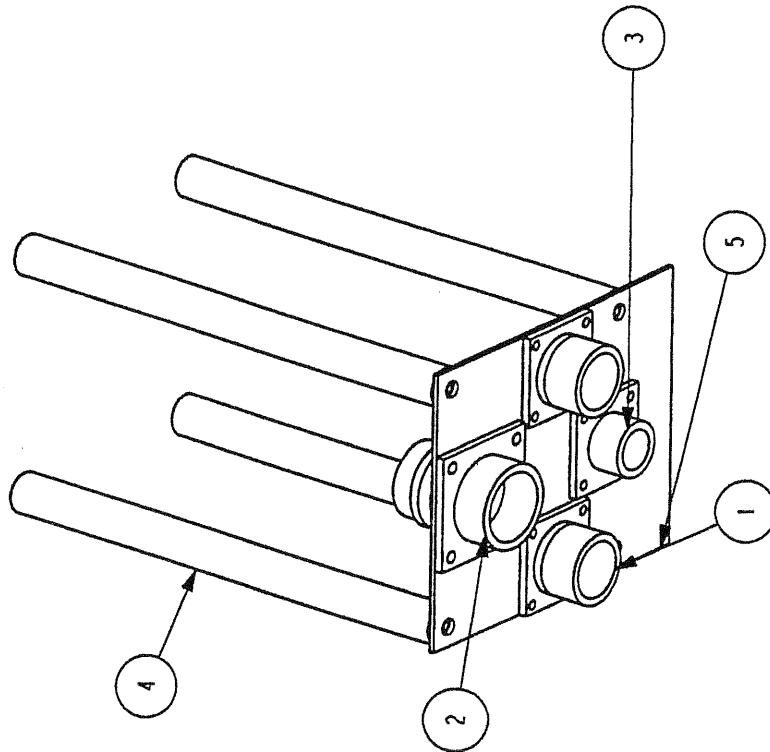


REV NO	DATE	DESCRIPTION	ECN NO	ON	REPLACED BY
1	1/12/2001	REPLACEMENT SPRING WITH O-RINGS	6	9111	9111

1000

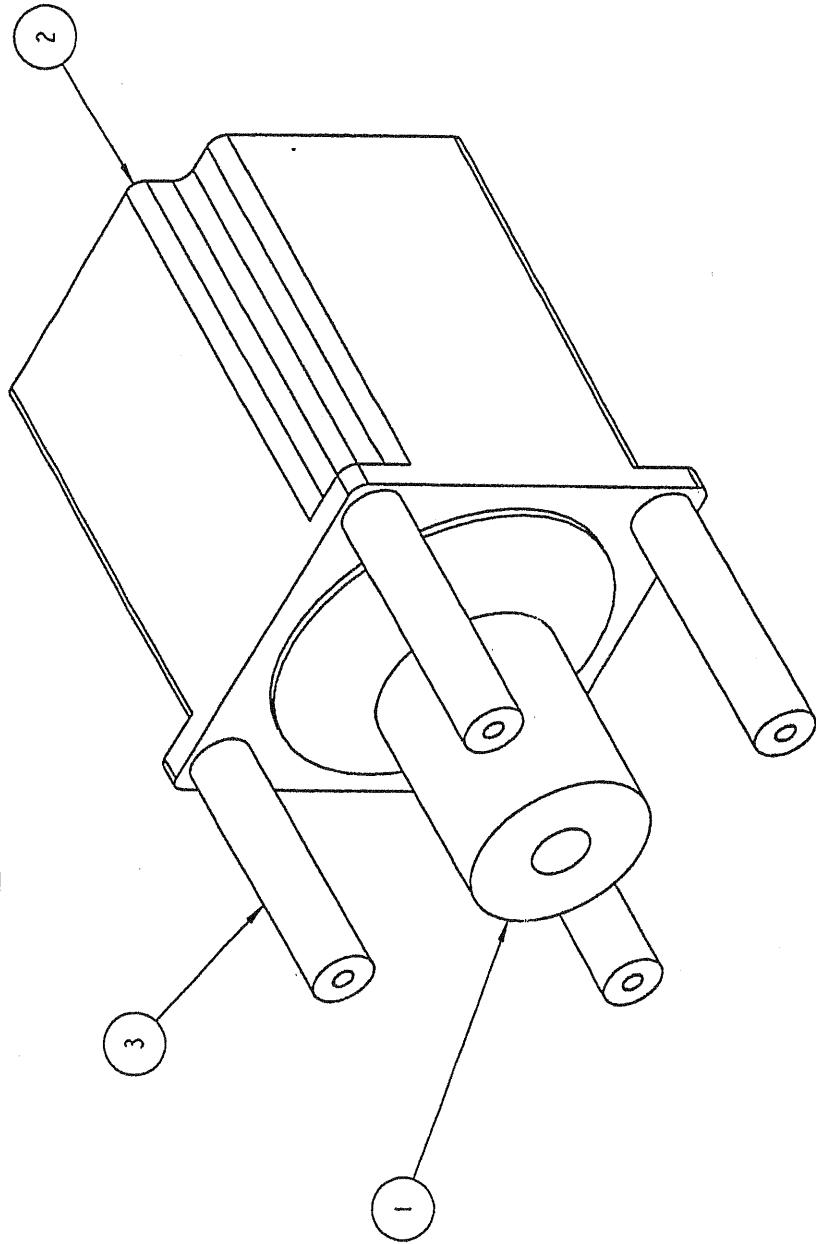
DRAWN BY:	T JG	SCALE	1 . 000	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	MATERIAL: N / A	THIRD ANGLE PROJECTION	PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE QUOTED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC. KENNESAW, GEORGIA
CHECKED BY:		DATE	25-0ct-99	.01 .005 .5	HEAT TREAT:	N / A	KIRK - RUDY, INC. KENNESAW, GEORGIA
TRACED BY:		MASTER		REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED	FINISH:	N / A	ASSY , GUIDE ROLLER
				ALL DIMENSIONS ARE DO NOT SCALE - WORK TO DIMENSIONS ONLY	MODEL:	SP76300	REO'D WHERE USED
					SHEET NO.	10F1	DRAWING #

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



DRAWN BY:	SCALE	0 . 500	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	MATERIAL: XXX	THIRD ANGULAR 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 30444 USA
CRICKETED BY:	DATE	10 - Sep - 99	.01 .005 .5 MEAT TREAT:	XXX	MODEL: SP76300	ASSY-ELECTRICAL CONNECTION PLATE
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	XXX	STOCK NO: 10F1	DRAWING # 536784-01

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



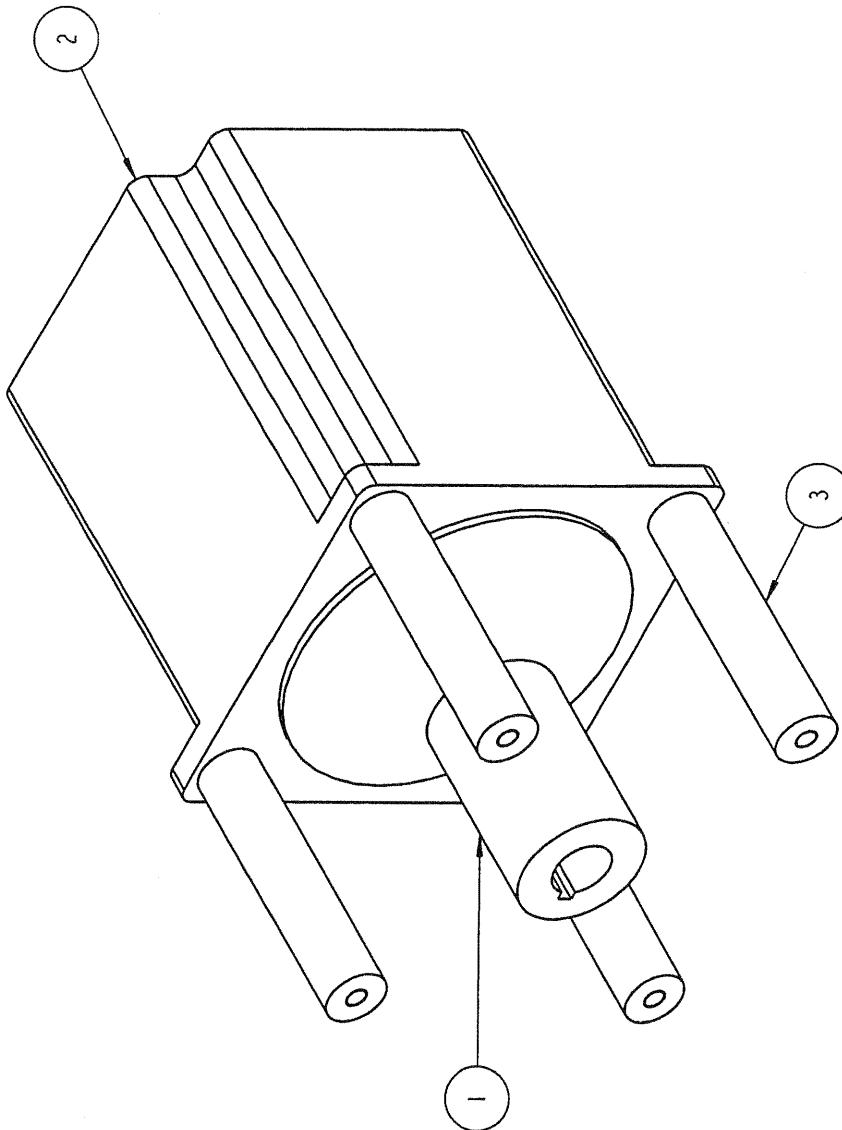
ITEM	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	101222	COUPLING, SHAFT SC035					
2	200159-4	MOTOR, STEPPER KML092-F07					
3	536950-01	SHAFT, MOTOR MOUNT					

2	KR5353RD
RECD	WHERE USED

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 OBTAINED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY KENNESAW, GA 30144 USA	
CHECKED BY:		DATE: 25 - 0 C + - 9 9	.01	.005	ANG.: .5	NOTE: SP76300	TITLE: ASSY, MOTOR TAB DRIVE	
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	SHEET NO. 1 OF 1	DRAWING #: 536805-01	

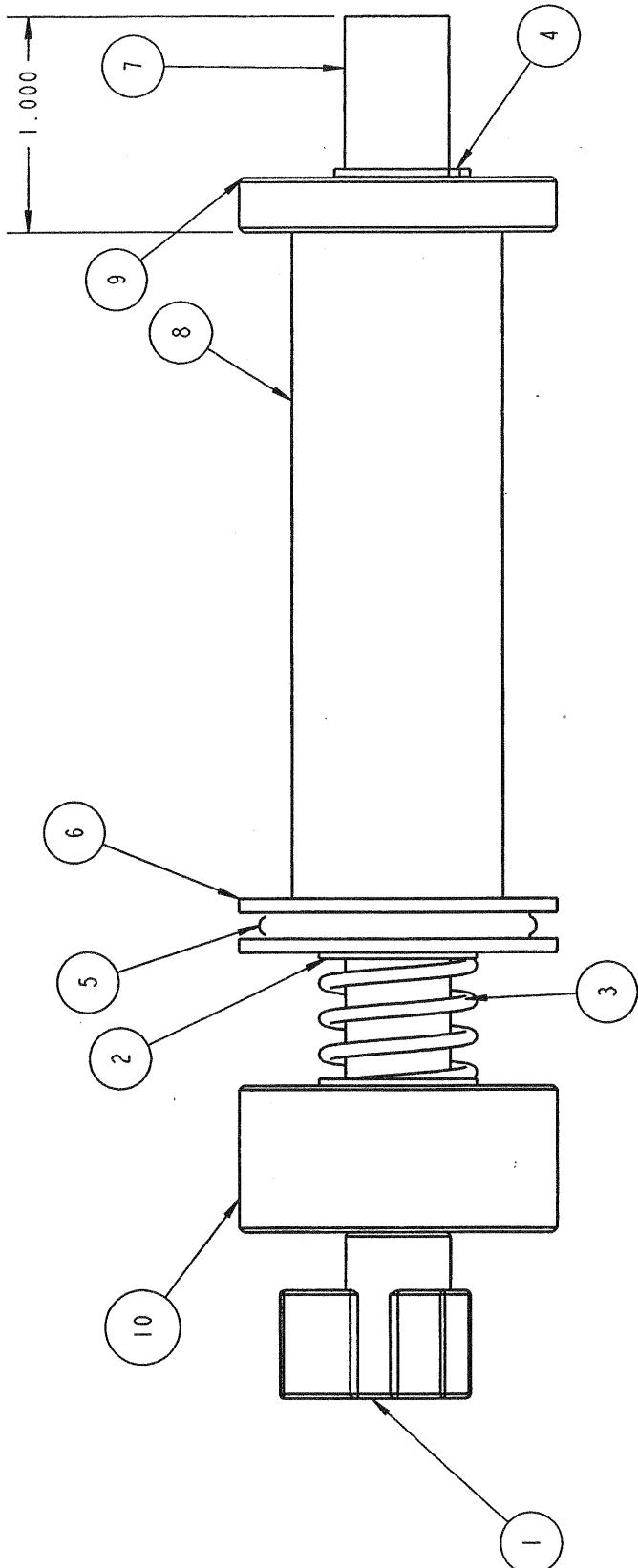
ITEM QTY	PART #	DESCRIPTION
1	101223	COUPLING, SHAFT .500B .125K
2	200159-4	MOTOR, STEPPER KML092-F07
3	4 536950-01	SHAFT, MOTOR MOUNT

REV NO	DATE	DESCRIPTION	ECN NO	BY
1	7/22/2001	ELIMINATED PART 536805-02	6114	TJG



DRAWN BY:	SCALE:	0 . 750	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	MATERIAL:	X X X	THIRD ANGLE PROJECTION	KIRK - RUDY, INC.
			.01 .005 .5	ANG.			KENNESAW, GEORGIA
CHECKED BY:	DATE:	17 - Dec - 99	REMOVE ALL BURS AND SHARP EDGES UNLESS OTHERWISE NOTED	HEAT TREAT:	X X X	MODEL:	ASSY, MOTOR UNWIND
TRACED BY:	MASTER:	M	ALL DIMENSIONS ARE FINISHED DIMENSIONS	FINISH:	X X X	SHEET NO.:	1 OF 1
			DO NOT SCALE - WORK TO DIMENSIONS ONLY			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:	SCALE	1 .250	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	MATERIAL:	N/A	THIRD ANGLE PROJECTION	PROPRIETARY AND CONFIDENTIAL NO DUPLICATION OR REPRODUCTION MADE OUT OF OR REPORTED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC. KENNESAW, GA 30144 USA
CHECKED BY:	DATE	15-JUL-03	.XX .XXX .005 .005 .5	ANG.	HEAT TREAT:	N/A	TITLE:
TRACED BY:	MASTER	M	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED	FINISH:	N/A	MODE:	KR535
			ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY			SHEET NO.	1 OF 1

I KR535
REQ'D WHERE USED

I
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	BAR, BRG HOUSING MOUNT

ITEM	QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY

I KIRK-RUDY INC.
REO'D WHERE USED

DRAWN BY: T JG SCALE: 0 .500 MATERIAL: XXX THIRD ANGLE PROJECTION

UNLESS OTHERWISE NOTED .005 .01 .5

CHECKED BY: DATE: 01 - Nov - 99 MEAT TREAT: XXX

REMOVED ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED

ALL DIMENSIONS ARE FINISHED DIMENSIONS

DO NOT SCALE " WORK TO DIMENSIONS ONLY"

MASTERED BY: M

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 TITLE: ASSY, FRAME CROSS ADJUSTMENT

SHEET NO: 10F1 DRAWN BY: DR

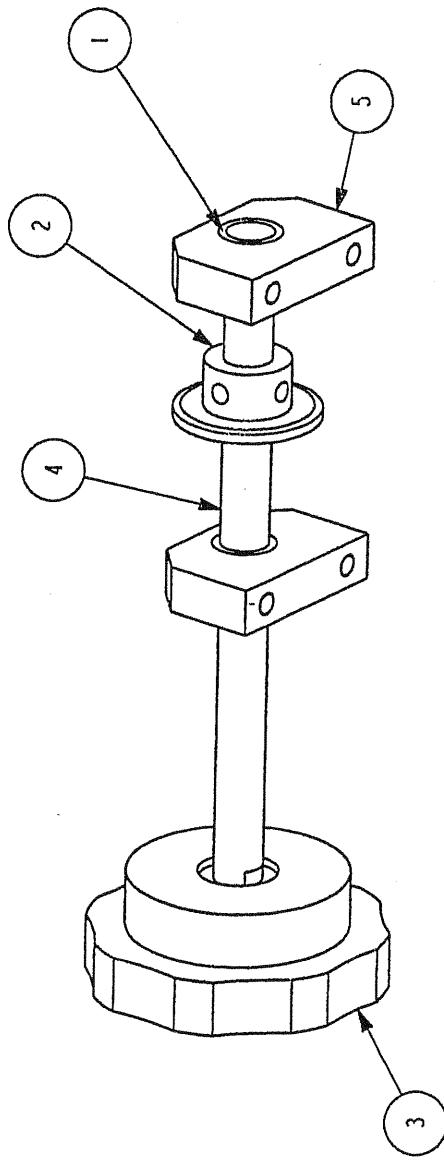
KIRK-RUDY INC.
KENNESAW, GEORGIA

536951-01

DRAWING 8

536766-02

ITEM	QTY	PART #	DESCRIPTION
1	2	100101	BUSHING, SL. 375ID .5000OD. 375LG
2	1	111207	SPRKLT. 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:	N/A	THIRD ANGLE PROJECTION	PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE QUOTED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC. KENNESAW, GA 30144 USA	KIRK - RUDY, INC. KENNESAW, GEORGIA	1,000 REQ'D	SP76300 WHERE USED
CHECKED BY:	DATE	.01	.005	ANG.	.5	REAR TREAT:	N/A	SP76300	TIME:	DRAWING #:
TRACED BY:	MASTER	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED		FINISH:	N/A	ASSY - CROSS ADJUSTMENT		10F1	SHEET NO.:	
		ALL DIMENSIONS ARE FINISHED DIMENSIONS		DO NOT SCALE - WORK TO DIMENSIONS ONLY						

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

REV NO	DATE	DESCRIPTION	ECN NO	BY
1	7/2/2001	REPLACED UNWIND SENSOR	6715	TJG
RECD WHERE USED				
1	KR555HD			

DRAWN BY:	SCALE	MATERIAL:	THIRD ANGLE PROJECTION
TVK	0 . 310	X X X	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
CHECKED BY:	DATE	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	+
	25-0c1-99	.01 .005 .005	-
TRACED BY:	MASTER	HEAT TREAT:	MODEL: 535
	M	X X X	SHEET NO: 1 OF 1
		FINISH:	NAME: DRAWING #
		REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED	ASSY, LABEL TRAY COVER
		ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE WORK TO DIMENSIONS ONLY	536957-01

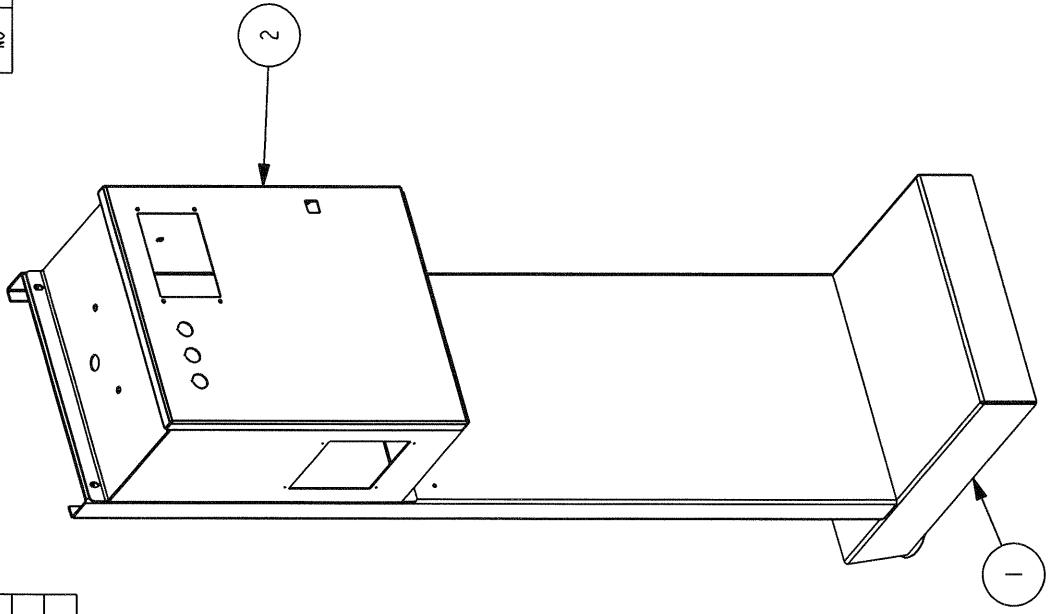
ITEM QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	CEN NO	BY
1	2 100131	BUSHING, SL. 250ID. 375OD. 250LG					
2	1 100162	BUSHING, SL. 500ID. 625OD. 625LG					
3	2 100302	BUSHING, FL. 375ID. 500OD. 500LG					
4	2 102206	COLLAR .250	1	10/10/2000	ADDED WIRE STRIPPER	6596	TJG
5	1 102623	SPRING, EXT. 360D 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: TJG SCALE 0.250 DIMENSIONAL TOLERANCES
 UNLESS OTHERWISE NOTED
 .01 .005 .005 .005
 ANG.
 CHECKED BY:
 DATE 22-0C+ - 99
 TRACED BY:
 MASTER M

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			
				TITLE: ASSY, FRAME W/ BEARINGS			
				SHEET NO. 1 OF 1			
				DRAWING # 537669-01			

ITEM QTY	PART #	DESCRIPTION
1	1	300029 WLDMNT, INDEXER BOX STAND
2	1	531724-02 WLDMNT, KRS535CS CONTROLS BOX



REV NO	DATE	DESCRIPTION	ECN NO	BY

RECD WHERE USED

KIRK - RUDY, INC.
WOODSTOCK, GEORGIA

PROPRIETARY AND CONFIDENTIAL
NO PORTION OF THIS DRAWING
MAY BE QUOTED OR REPRODUCED
IN WHOLE OR IN PART
WITHOUT THE
EXPRESS WRITTEN PERMISSION
OF KIRK - RUDY, INC.
WOODSTOCK, GA 30888 USA

THIRD ANGLE PROJECTION

ASSY, 535HD STAND - CONTROL BOX

DRAWING # 536180-02

DRAWN BY: JMW SCALE: 0.109 MATERIAL: N/A

Dimensional tolerances unless otherwise noted:

.XX	.XXX	.ANG.
.01	.005	.5

HEAT TREAT: N/A

FINISH: N/A

REMOVED ALL BURRS AND
SHARP EDGES UNLESS
OTHERWISE NOTED

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

DATE: 21-0C1-05 MODEL: 535HD SHEET NO.: OF 2

MASTER

7.2 KR535CSHD (clutch unwind) DIAGRAMS

DRAWING #	DESCRIPTION
538869-02	Assy, KR535HD Clutch
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
536738-07	Assy, Roller Unwind Clutch
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
536832-19	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
538829-01	Assy, Unwind Clutch
542625-01	Assy, Arm Belt Tensioner
536180-02	Assy, 535HD Stand & Controls

ITEM QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BT
1	109857	PULLEY 32XL037 .500B MK					
2	109990	PULLEY, TIMING 20L050 .500B MK					
3	2006.3	MOTOR, AC 1/20 HP					
4	108904-6	BELT, TIMING 322L050					
5	109014-2	BELT, TIMING 200XL037					
6	536382-04	ASSY-FRAME MOUNT					
7	1	536399-02 ASSY, PINCH ROLLER DRIVE					
8	1	536738-07 ASSY, ROLLER UNWIND CLUTCH					
9	1	536746-01 ASSY-LABEL ROLL					
10	1	536749-02 ASSY, REWIND					
11	1	536761-01 ASSY, VERTICAL ADJUSTMENT					
12	1	536769-02 ASSY-STRIpper PLATE					
13	1	536780-02 COVER-H					
14	1	536784-01 ASSY-ELECTRICAL CONNECTION PLAT					
15	1	536791-02 PLATE-TAKEUP MOTOR					
16	1	536791-02 PLATE-COVER					
17	1	536805-01 ASSY, MOTOR TAB DRIVE					
18	1	536836-01 COVER-BOTTOM					
19	1	536832-19 ASSY, GUIDE ROLLER DRAG					
20	1	536951-01 ASSY, FRAME CROSS ADJUSTMENT					
21	1	536951-01 ASSY, LABEL TRAY COVER					
22	1	537669-01 ASSY, FRAME W/ BEARINGS					
23	1	538164-02 COVER, REWIND SHAFT					
24	1	538829-01 ASSY, UNWIND CLUTCH					

I	III
REV'D	WHERE USED
<p align="center">KRK - RUDY, INC. WOODSTOCK, GEORGIA</p>	
TIME:	535CS
SCALE:	0 .300
CHECKED BY:	09-Apr-02
MAKER:	N/A
TRACED BY:	N/A
DRAWN BY:	N/A
DESIGN BY:	N/A
APPROVED BY:	N/A
REVIEWED BY:	N/A
INITIALS:	10F4

Drawing # 538869-02

ITEM #	PART #	DESCRIPTION	REV A	DATE	DESCRIPTION	REV A	DATE
1	109857	PULLEY 32X1037 .500B NK					
2	109990	PULLEY TIMING 201050 .500B NK					
3	200613	MOTOR, AC 1/20 HP					
4	108905-6	BELT, TIMING 322L050					
5	109014-2	BELT, TIMING 200XL037					
6	536382-04	ASSY, FRAME MOUNT					
7	1	536395-02 ASSY, PINCH ROLLER DRIVE					
8	1	536738-07 ASSY, ROLLER UNWIND CLUTCH					
9	1	536746-01 ASSY-LABEL ROLL					
10	1	536749-02 ASSY, REWIND					
11	1	536761-01 ASSY, VERTICAL ADJUSTMENT					
12	1	536765-02 ASSY-STRIPPER PLATE					
13	1	536780-02 COVER-H					
14	1	536784-01 ASSY-ELECTRICAL CONNECTION PLAT					
15	1	536794-02 PLATE-TAKEUP MOTOR					
16	1	536791-02 PLATE-COVER					
17	1	536805-01 ASSY, MOTOR TAB DRIVE					
18	1	536826-01 COVER-BOTTOM					
19	1	536832-19 ASSY, GUIDE ROLLER DRAG					
20	1	536951-01 ASSY, FRAME CROSS ADJUSTMENT					
21	1	536951-01 ASSY, LABEL TRAY COVER					
22	1	537669-01 ASSY, FRAME W/ BEARINGS					
23	1	538164-02 COVER-REWIND SHAFT					
24	1	538829-01 ASSY, UNWIND CLUTCH					

1	REV A
REV D	WHERE USED
KIRK - RUDY, INC.	
WOODSTOCK, GEORGIA	
TIME:	
535CS	
40F4	

1 REV A

REV D WHERE USED

KIRK - RUDY, INC.

WOODSTOCK, GEORGIA

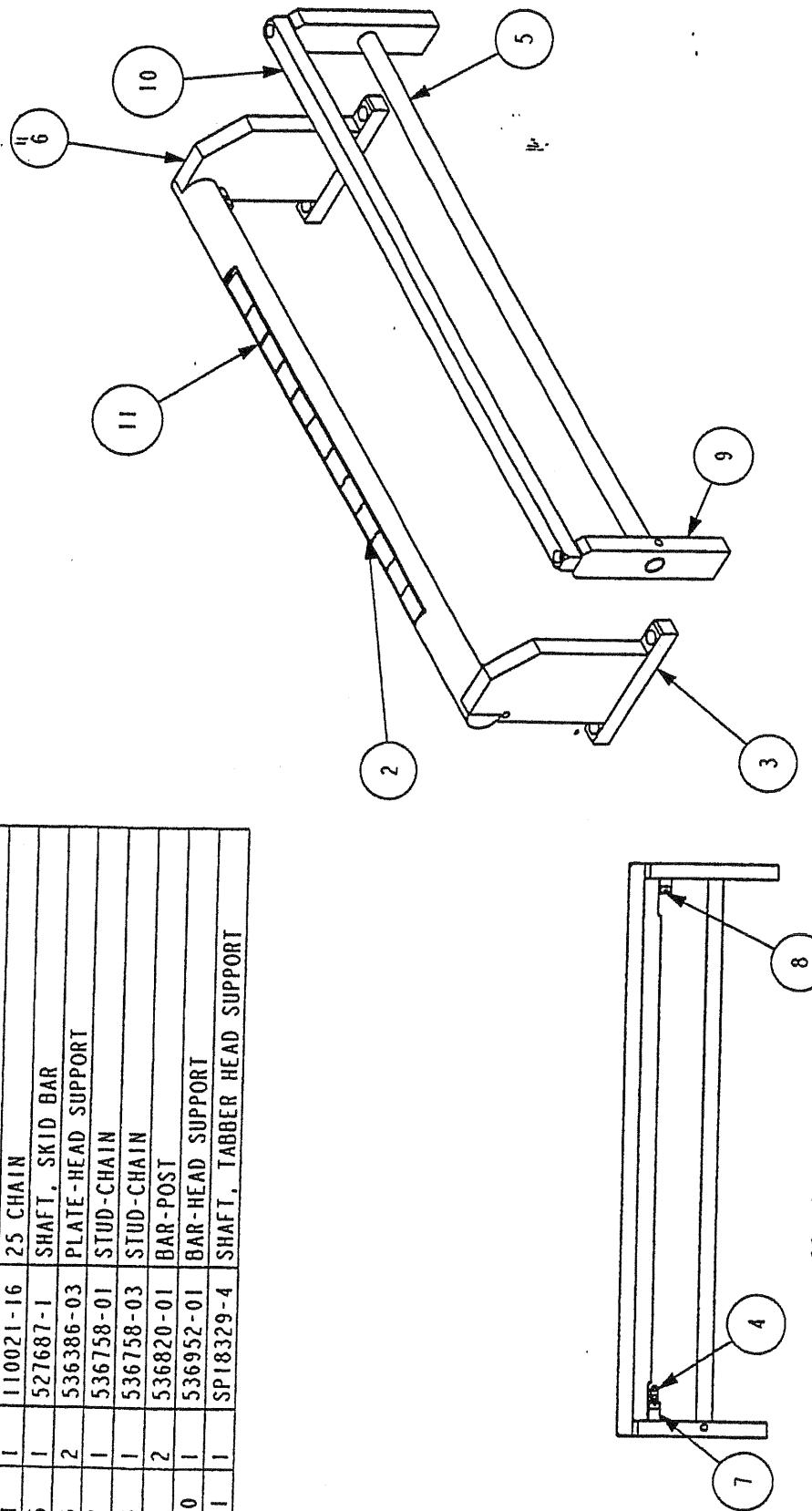
TIME:

535CS

40F4

NAME #:		SCALE	DIMENSIONAL CHANGES UNLESS OTHERWISE NOTED		MATERIAL	DRAWING PROJECTION	
ITEM #:	DATE	IN	MM	IN	MM	IN	MM
CHECKED BY:	09-Apr-02	N/A	N/A	N/A	N/A	N/A	N/A
MAILED BY:							
TRACED BY:							

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



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

DRAWN BY:	SCALE	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	MATERIAL:	PROJECTION	REF'D	WHERE USED
TVK	0 . 250	.005 .005 .005	AM.	FRONT	KRK	KIRK - RUDY, INC.
CHECKED BY:	DATE	.01 .005 .005	MEAT TREAT:	TOP	KENNESAW, GEORGIA	630144 USA
TRACED BY:	MASTER	22-0c† - 99	REMOVED ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED	RIGHT	SP76300	ASSY - FRAME MOUNT
	M		ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY	TOP	10F1	DRAWING #

536382-04

ITEM	QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	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

DRAWING BY: TVK SCALE 0 .375 DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED

DATE	.XX	.XXX	XX	THIRD ANGLE PROJECTION	PROPRIETARY AND CONFIDENTIAL
22-0c† - 99	.01	.005	.5		NO PORTION OF THIS DRAWING MAY BE QUOTED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC. KENNEDY SAW, GEORGIA
MASTERS	MASTER	HEAT TREAT:			†
		REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED			
		FINISH:			
		XXX			

CHECKED BY: DATE: 22-0c† - 99 HEAT TREAT: XXX

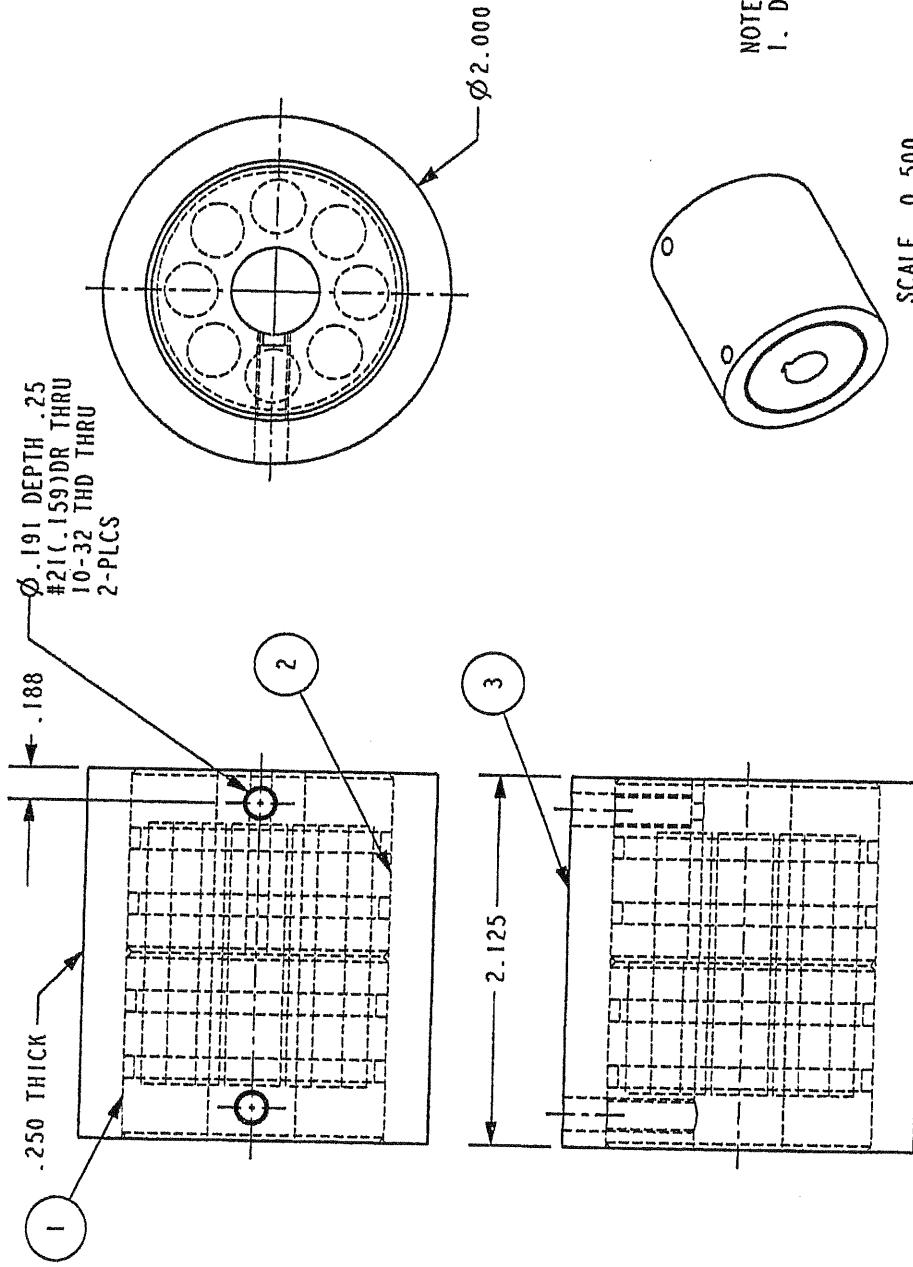
TRACED BY: DRAWING NO: 10F1

1.000 KRS35HD REC'D WHERE USED

ASSY, PINCH ROLLER DRIVE

536399-02

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



DRAWN BY:	SCALE	REV'D	535
T JG	1.000		
DATE			
13-Dec-99			
CHECKED BY:	.005	.3	
	.01		
MASTER			
M			
ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY			
DRAWING #: 536320-02	535	ASSY, ROLLER DRIVE	

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

ITEM	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	100309	BUSHING, FL. 250ID. 375OD. 250LG					
2	100330	BUSHING, FL. 375ID. 500OD. 250LG					
3	103803	BEARING, HUB .500					
4	536732-01	BAR-BEARING, DRIVE					

DRAWN BY: TVK SCALE: 0 . 500 DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED

0.01	.005	.005
.01	.005	.005

CHECKED BY: 13 - Aug - 99 DATE: 13 - Aug - 99 MATERIAL: XXX FINISH: XXX

TRACED BY: M MASTER: M FINISH: XXX

REMOVED ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED
ALL DIMENSIONS ARE IN MILLIMETERS
FINISHED SURFACES
DO NOT SCALE - WORK TO DIMENSIONS ONLY

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

TITLE: ASSY-BEARING PLATE

MODEL: SP76300 SHEET NO. 10F1 DRAWING #

I SP76300 RED'D WHERE USED

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

REV NO.	DATE	DESCRIPTION	ECN NO	BY

2 KAS354D

REV'D WHERE USED

DRAWN BY: T JG SCALE 1 . 000 MATERIAL: XXX DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED

.01	.018	.016
.01	.015	.01

REAR TREAT: .01

DATE 28-Dec-99 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

REAR

REAR ALL BURRS AND
SHARP EDGES UNLESS
OTHERWISE NOTED

ALL DIMENSIONS ARE
FINISHED DIMENSIONS

DO NOT SCALE - WORK
TO DIMENSIONS ONLY

MODEL: 535

ASSY, NIP ROLLER

TRACED BY: MASTER M

STYLUS PROOF OF I

WORKSHEET

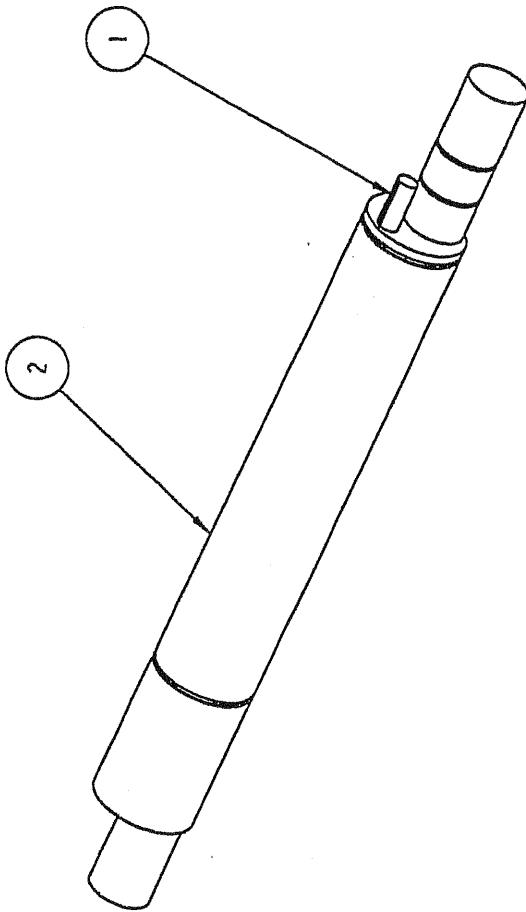
537667-02

DRAWING 2

537668-01

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

DRAWN BY:	SCALE:	1.000	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	MATERIAL: XXX	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	REV'D:	2	KR535HD	
TRACED BY:	01-NOV-99	.000 .005 .01	.000 .005 .01	AN6. .5	MEAT TREAT: XXX	MODEL: 535	WHERE USED:	KIRK - RUDY, INC. KENNESAW, GEORGIA		
MASTED BY:	M	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED ALL DIMENSIONS ARE FINISHED DIRECTIONS 				SHEET NO.: 10F1	DRAWING NO.:	ASSY, ECCENTRIC SHAFT W/PIN 537668-01		



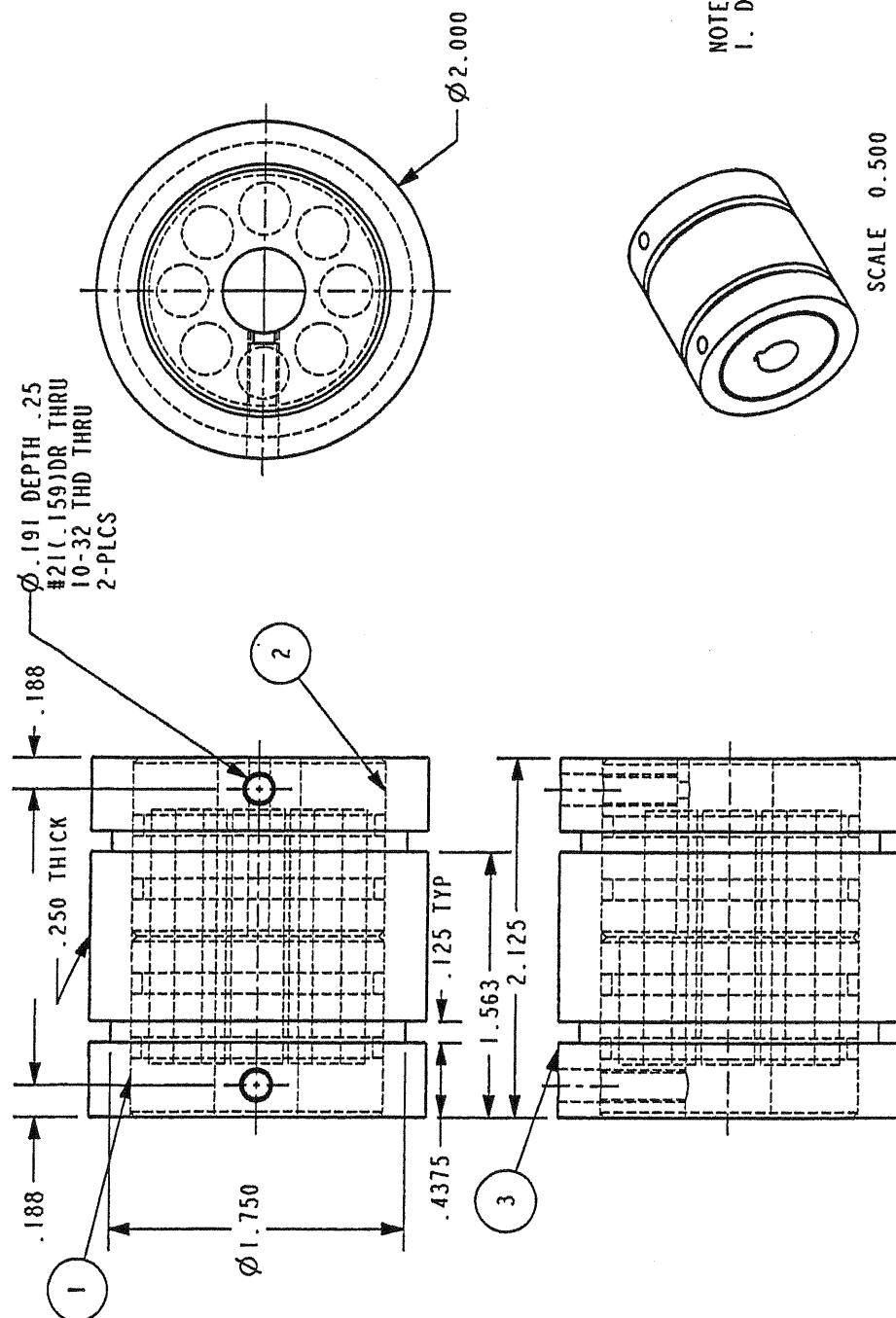
ITEM	QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	1	102793	SPRING, COMP OD .36 W .03 L .75					
2	1	104107	SNAPRING, .250					
3	1	536037-01	PLATE-RELEASE					
4	1	536044-01	KNOB-LOCKING					
5	1	536320-03	ASSY, ROLLER DRIVE					
6	1	536329-01	SHAFT, SPACER					
7	1	536400-02	ASSY-BEARING PLATE, UNWIND					
8	1	536801-01	BAR-SPACER, BEARING PLATE					
9	1	536817-01	ASSY, WEB DRAG					
10	1	537667-02	ASSY, NIP ROLLER					
11	1	537668-01	ASSY, ECCENTRIC SHAFT W/PIN					
12	2	539684-01	SPACER, TABLETOP					
13	1	CSD213	SCREW, SHCS 6-32X .875					
14	1	HMSN08	NUT, HEX #6-32					

1.000 538869-02
REQ'D WHERE USED

1.000 536738-07
DRAWING #

DRAWN BY: T JG	SCALE: 0 .375	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED			MATERIAL: XXX	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 3044 USA	
CHECKED BY:	DATE: 09-Apr-02	.XX	.XXX	ANG. .01 .005 .5	HEAT TREAT: XXX		MODEL: 535CS	TITLE: ASSY, ROLLER UNWIND CLUTCH
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 # 536738-07	

ITEM QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BT
1	1	536312-02 ROLLER-CORE					
2	1	536313-02 ROLLER-CORE, KEYED					
3	1	536397-02 COATING, URETHANE DUR60					



DRAWN BY: T JG	SCALE: 1 . 000	MATERIAL: XXX	THIRD ANGLE PROJECTION	PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE COPIED OR REPRODUCED IN WHOLE OR IN PART WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, KENNESAW, GA 30446 USA
CHECHED BY:	DATE: 19 - MAY - 00	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	.XX .XXX ANG. .01 .005 .5	NOTE: 5335
TRACED BY:	MASTER: M	FINISH: XXX	REMOVED ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY	SCALE: 10F1 DRAWING #: 536320-03

I 536320-03

REV'D WHERE USED

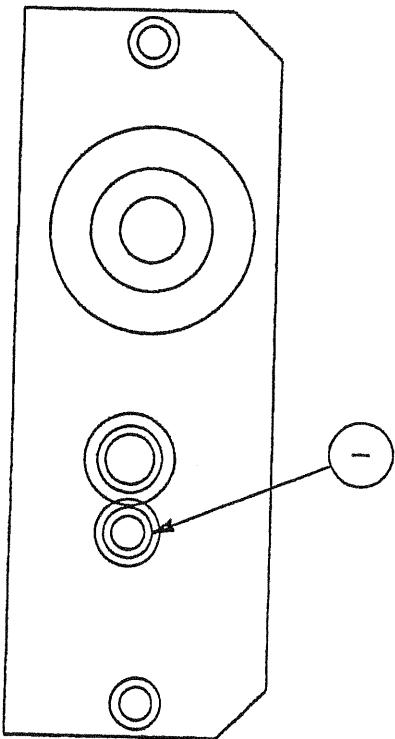
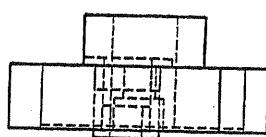
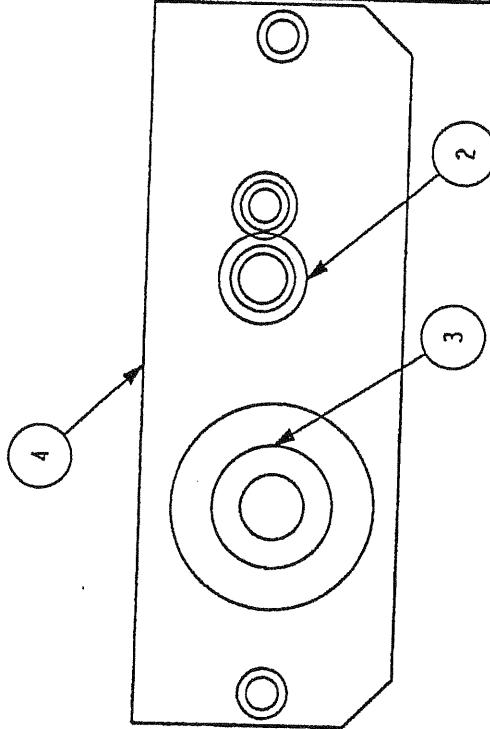
KIRK - RUDY INC

KENNESAW, GEORGIA

ASSY, ROLLER DRIVE

536320-03

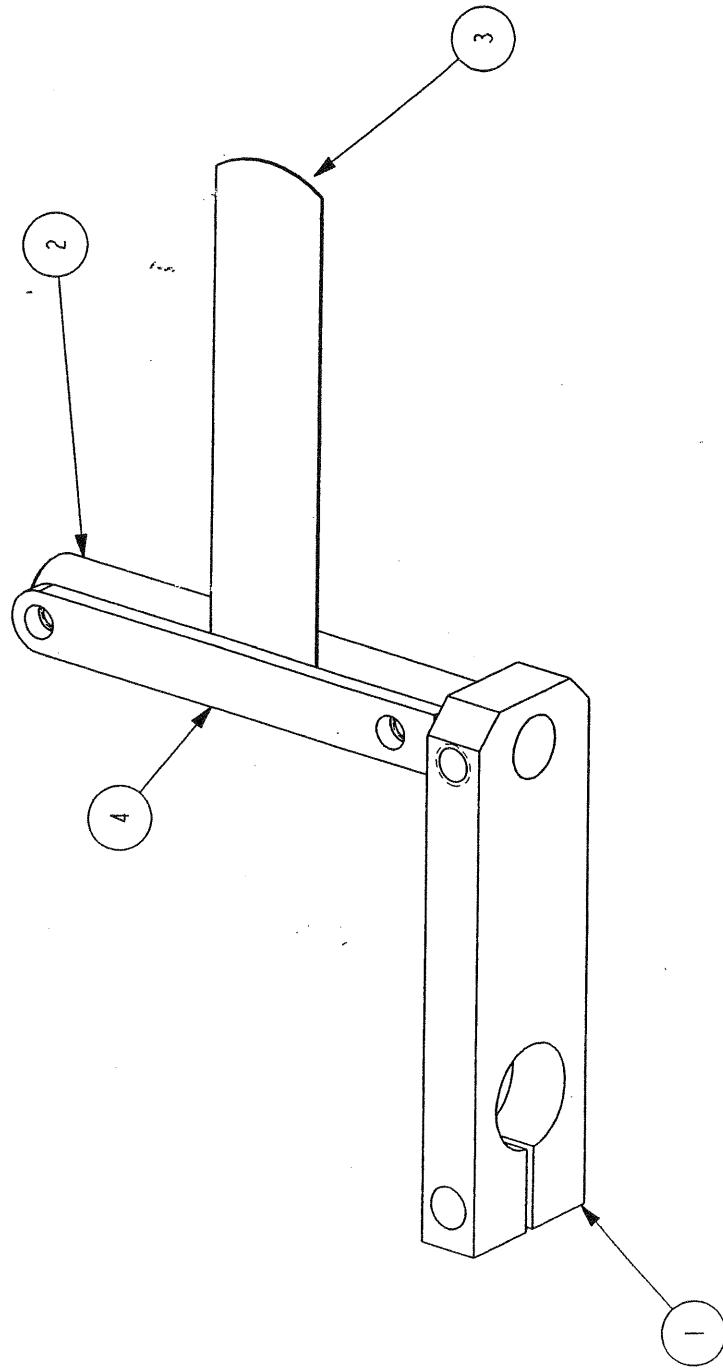
ITEM QTY	PART #	DESCRIPTION
1	100309	BUSHING, FL. 250ID. 375OD. 250LG
2	100330	BUSHING, FL. 375ID. 500OD. 250LG
3	103803	BEARING, HUB .500
4	536732-02	PLATE-BEARING, UNWIND



DRAWN BY:	SCALE	0 . 750	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	MATERIAL: XXX	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.
CHECKED BY:	DATE	.01	.005	AMG. .5	WEAR FACES:	TIME:
TRACED BY:	MASTER	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY				SP76300
					SHEET NO. 1 OF 1	DRAWING # 536400-02

KRK KIRK - RUDY, INC.
KENNESAW, GEORGIA

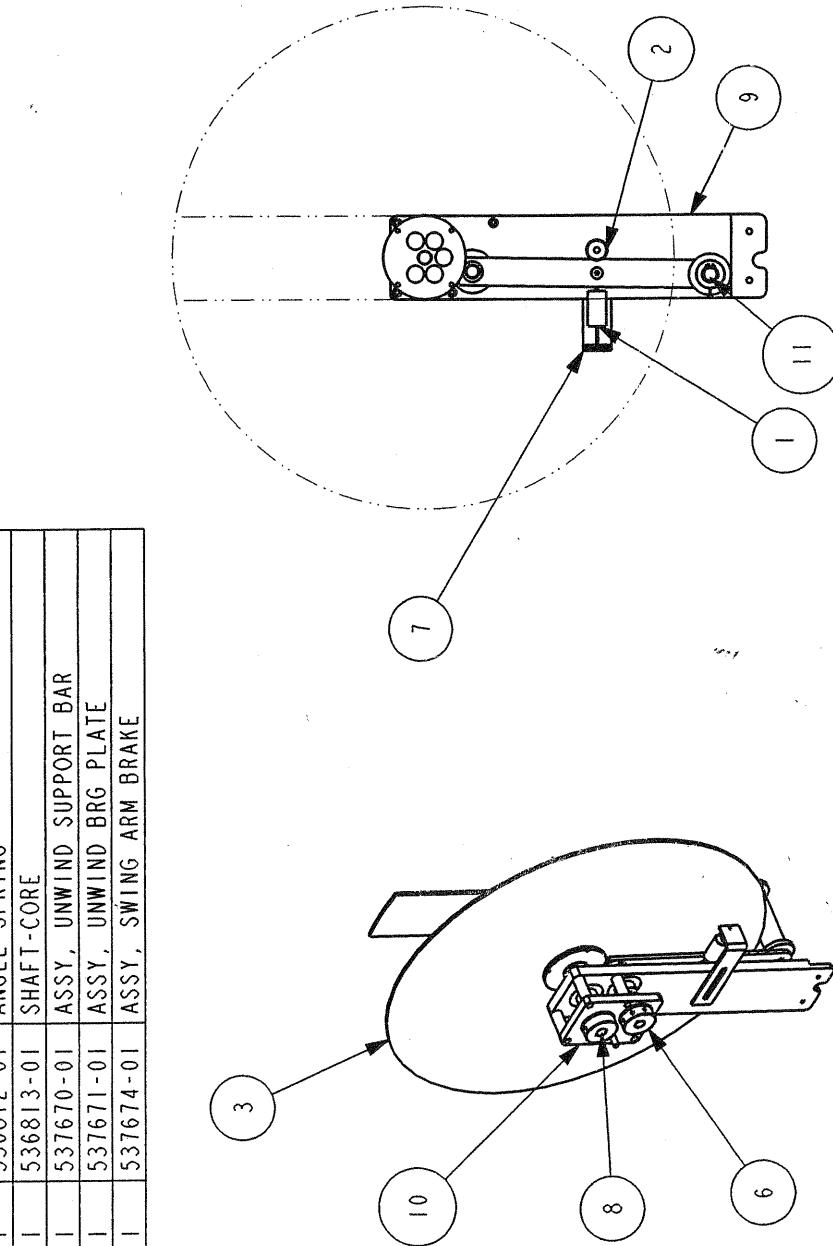
ITEM QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	1	536814-01			CLAMP-BELT MOUNT		
2	1	536815-01			BAR, BRUSH MOUNT		
3	1	536818-01			DRAG, SPRING STEEL		
4	1	536824-01			BAR-CLAMP, BRUSH		



1	SP76300	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 30044 USA		KIRK - RUDY, INC. KENNESAW, GEORGIA
THIRD ANGLE PROJECTION		
MATERIAL:	N / A	
DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	.005 .005 .005	HEAT TREAT:
DATE	03-Nov-03	FINISH:
CHECKED BY:		ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY
TRACED BY:	MASTER	SHEET NO. 1 OF 1
		TITLE: ASSY, WEB DRAG
		DRAWING #: 536817-01

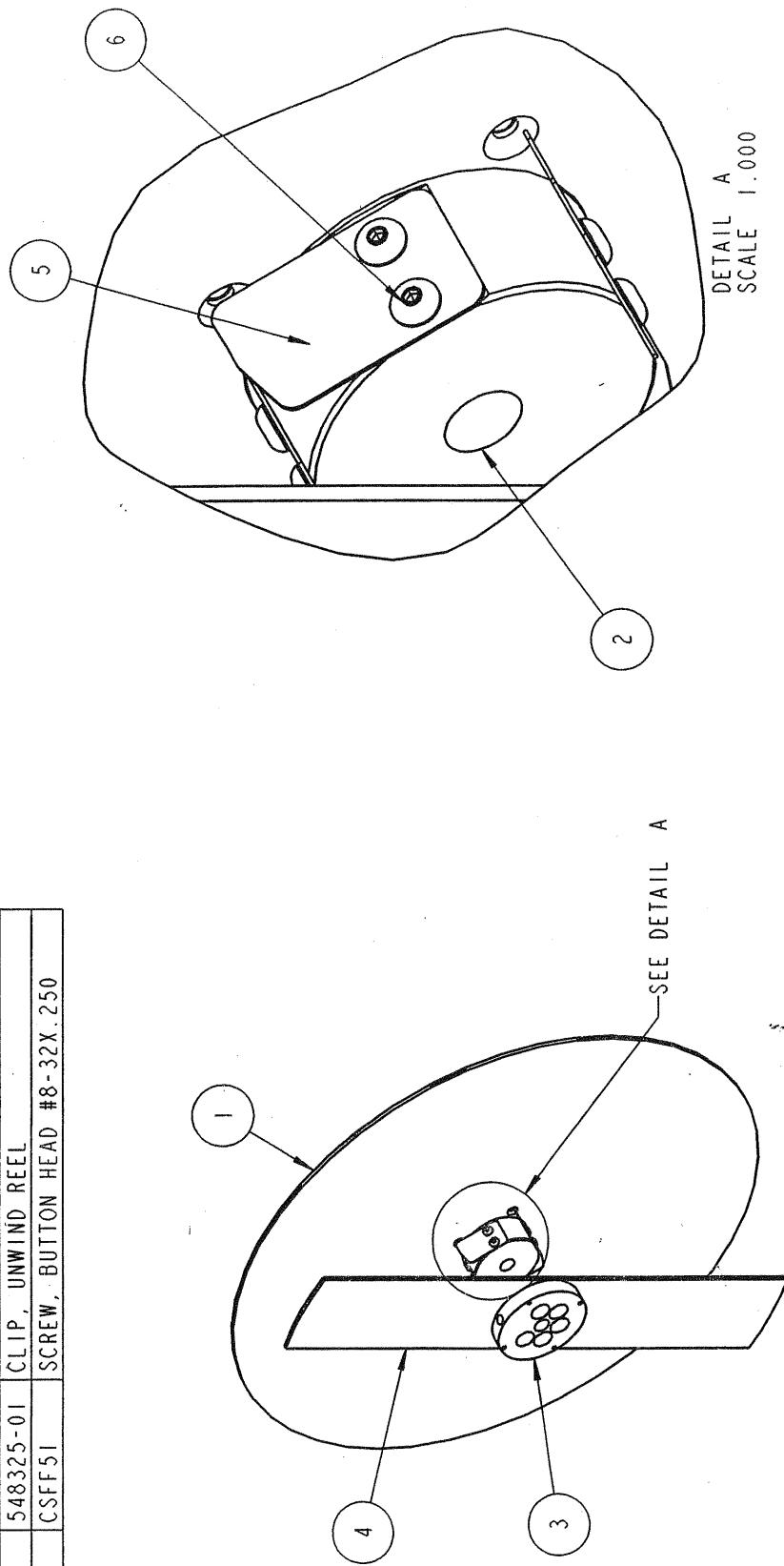
ITEM	QTY	PART #	DESCRIPTION	REV NO	DATE	ECN NO	BY
1	1	102775	SPRING, EXT EO 500-055-1750M	1	11/8/2004	REPLACED 536352-02 W/10 REPLACED 521651-6 W/12 SEE ASSY#536763-01	TJG
2	1	527653	SHAFT, ARM SUPPORT				
3	1	536763-01	ASSY, UNWIND WHEEL				
4	4	536764-01	STUD-SPACER, BRAKE PLATE				
5	1	536809-01	SHAFT-BRAKE				
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



DRAWN BY: TVK	SCALE 0.156	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 3044 USA
CHECKED BY:	DATE 22-0ct-99	HEAT TREAT: N/A	+---+	MODEL: SP76300
TRACED BY:	MASTER <i>m</i>	FINISH: N/A	SHEET NO. 10F1	DRAWING # ASSY-LABEL ROLL
		DO NOT SCALE - WORK ONLY TO DIMENSIONS		536746-01

ITEM QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	1	527651-12			DISK, LABEL UNWIND		
2	1	536352-10			HUB, UNWIND REEL		
3	1	536353-01			HUB-REEL		
4	1	536354-01			PLATE-UNWIND		
5	4	548325-01			CLIP, UNWIND REEL		
6	8	CSFF51			SCREW, BUTTON HEAD #8-32X.250		



1	KR535
REQ'D	WHERE USED
DETAIL A	SCALE 1.000
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	
TITLE: ASSY, UNWIND WHEEL	
DRAWN BY: T JG	SCALE 0.188
DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	
.01	.005
.005	.005
.005	.005
HEAT TREAT:	
MODEL: SA317	
DATE: 05-Nov-04	SHEET NO. 0F1
CHECKED BY:	
MASTER M	
TRACED BY:	
ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY	

DRAWING # 537670-01

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

ITEM	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECR NO	BY
1	JG	0 . 500					

SCALE 0 . 500

1 KRS35HD
REV'D WHERE USED

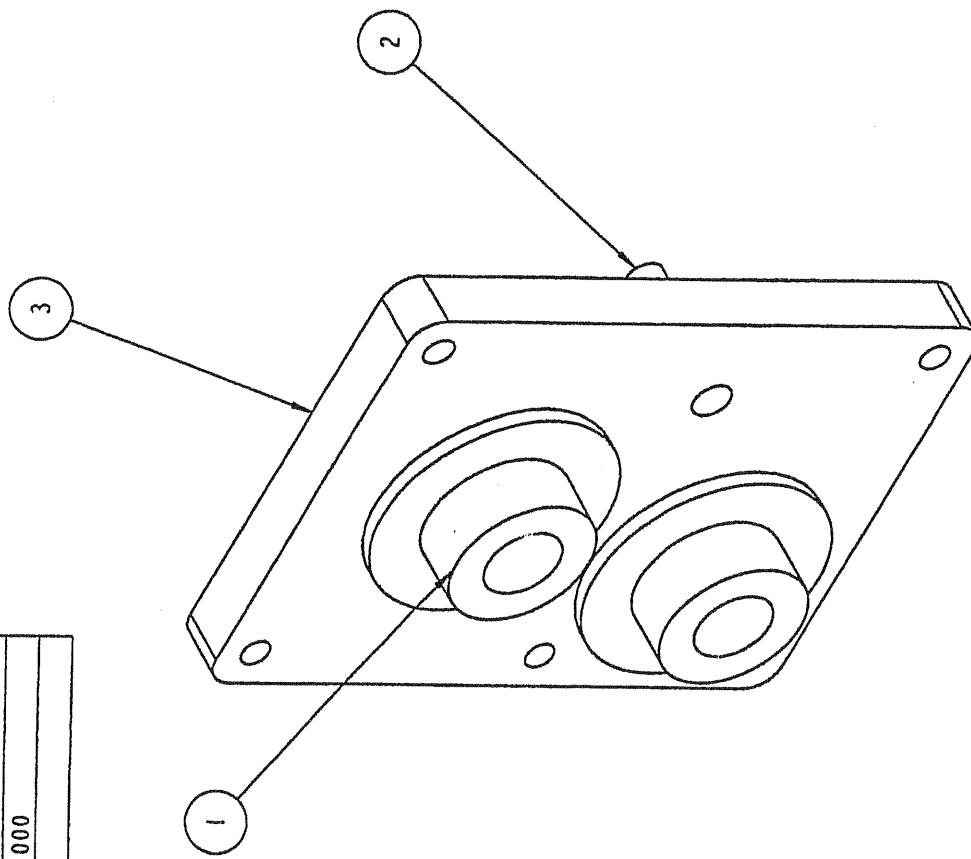
PROPRIETARY AND CONFIDENTIAL
NO PORTION OF THIS DRAWING
MAY BE QUOTED OR REPRODUCED
IN ANY FORM WITHOUT THE
EXPRESS WRITTEN PERMISSION
OF KIRK-RUDY, INC.,
KENNESAW, GA 30144 USA

KRK KIRK - RUDY, INC.
KENNE SAW, GEORGIA

ASSY, UNWIND SUPPORT BAR

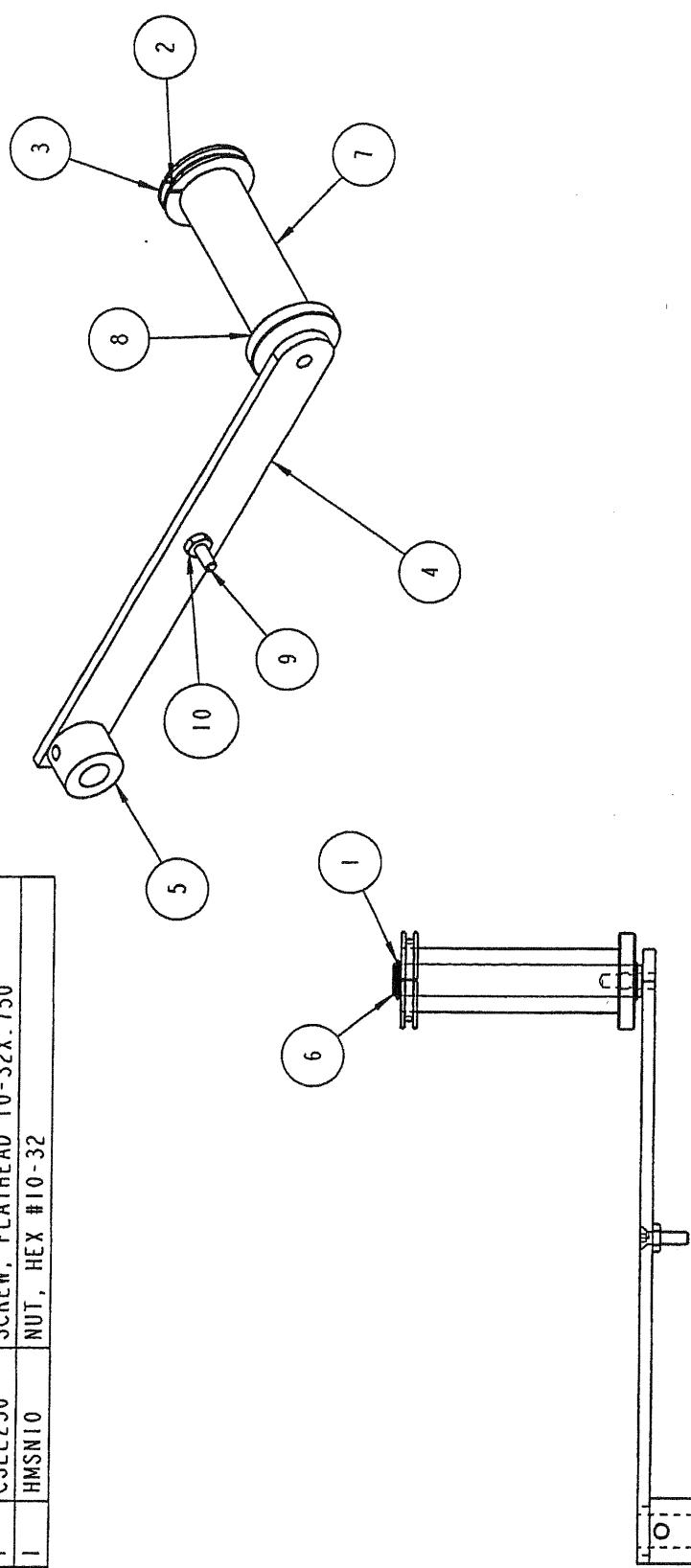
537670-01

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	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
T JG	1 . 000	.000 -XXX ANG.	XXX		
CHECKED BY:	DATE	.005 .5	HEAT TREAT: XXX	MODEL: 535	NAME: ASSY, UNWIND BRG PLATE
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. 10F1 DRAWING # 537671-01
01 - Nov - 99					

ITEM	TYPE	QTY	PART #	DESCRIPTION
1	PART	2	104106	SNAPRING, .500
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



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	
CHECKED BY:	TRACED BY:	DATE	.XX	.XXX	AMT.	HEAT TREAT:	VIEW:	MODEL:	NAME:
T J G	MASTER	01-Nov-99	.01	.005	.5	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED	XXX	535	ASSY, SWING ARM BRAKE
						ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY	XXX	10F1	DRAWING #

1	KR535RD
RED'D	WHERE USED

537674-01

ITEM QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	100145	BUSHING, SI. 6251D-.8130DI.000LG					
2	102140	HANDLE, RELEASE 1/4-20 X .75					
3	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 190720	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, TAKE UP					
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					

DRAWING B

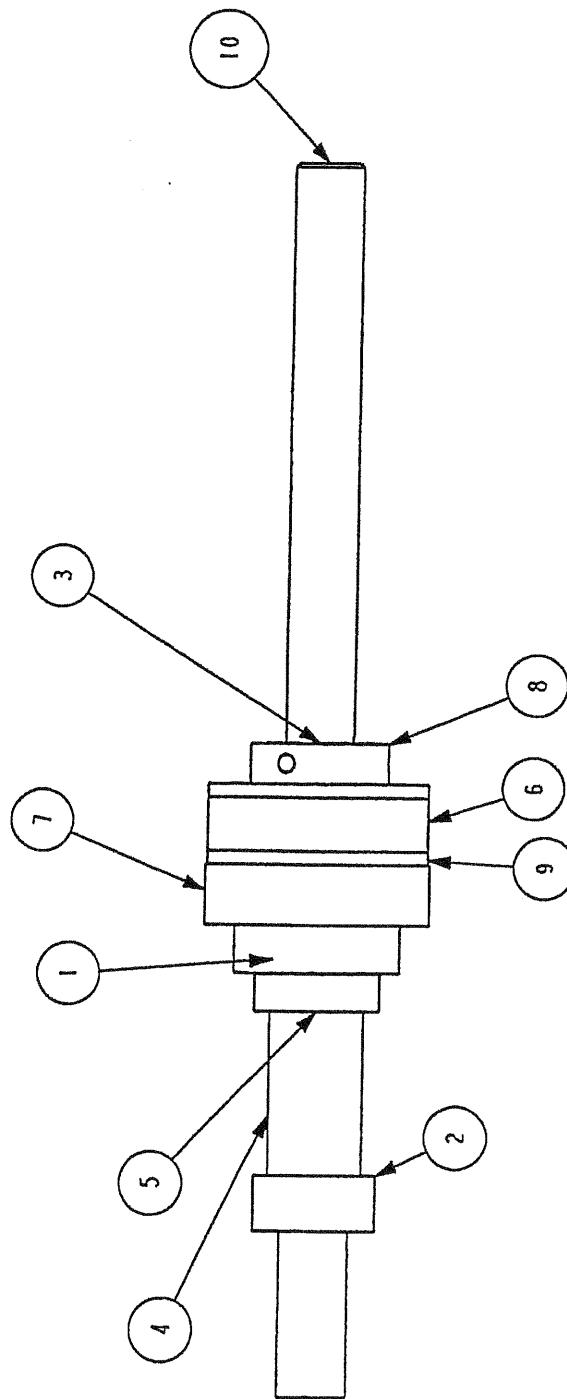
ASSY, REWIND

DRAWING B

1	KRS5510D
REO'D	WHERE USED
	KIRK - RUDY, INC. KENNESAW, GEORGIA
NOTE:	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
SHEET NO.	535
DRAWING NO.	10F1
MASTER BY:	M
TRACED BY:	
DATE:	22-0c 1 - 99
SCALE:	0 . 1 25
DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	
IN	.000 .005 .005
ANG.	.5
HEAT TREAT:	
REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED	
ALL DIMENSIONS ARE IN INCHES UNLESS NOTED DO NOT SCALE - WORK TO DIMENSIONS ONLY	

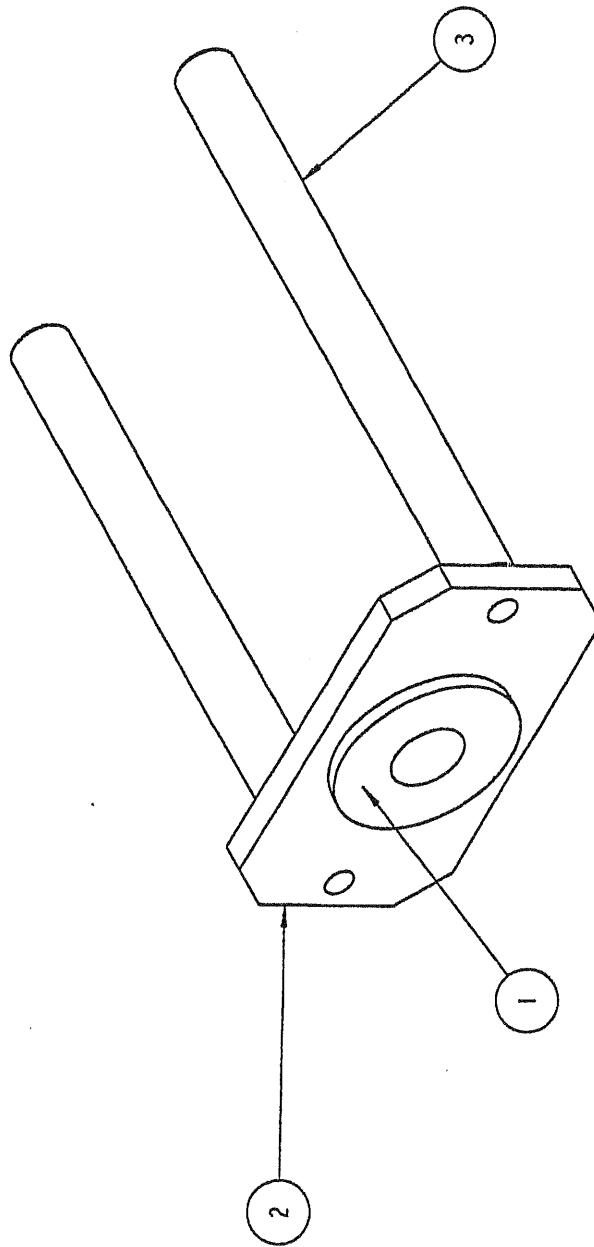
ITEM QTY	PART #	DESCRIPTION
1	100145	BUSHING. SL. 625ID.8130D1.0001LG
2	102203	COLLAR .625
3	2 102564	SHIM, .625X1.000X.010
4	1 102722	SPRING, COMPRESSION
5	1 103211	BEARING, BALL THRUST .625
6	1 190720	DISC, F3 FELT
7	1 108772-1	PULLEY. 32XL037
8	1 527695-1	HUB, TAKEUP
9	1 527697-1	DISC, TAKEUP
10	1 536803-01	SHAFT, TAKE-UP

SCALE 0.375



DRAWN BY:	SCALE	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	MATERIAL:	THIRD ANGLE PROJECTION	PROPRIETARY AND CONFIDENTIAL
TVK	0 . 625	.01 .005 .005	N / A		NO POSITION OF THE DIAMETERS MAY BE QUOTED OR SPECIFIED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC. KENNESAW, GA 30144 USA
CHECKED BY:	DATE 24-Sep-99	.01 .005 .005	MEAT TREAT:	MODEL: 535	DATE:
TRACED BY:	MASTER	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED	FINISH:	SHEET NO: 10F1	DRAWING #
		ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY			ASSY - SLIP CLUTCH
					536959-01
					I SP716300 REC'D WHERE USED

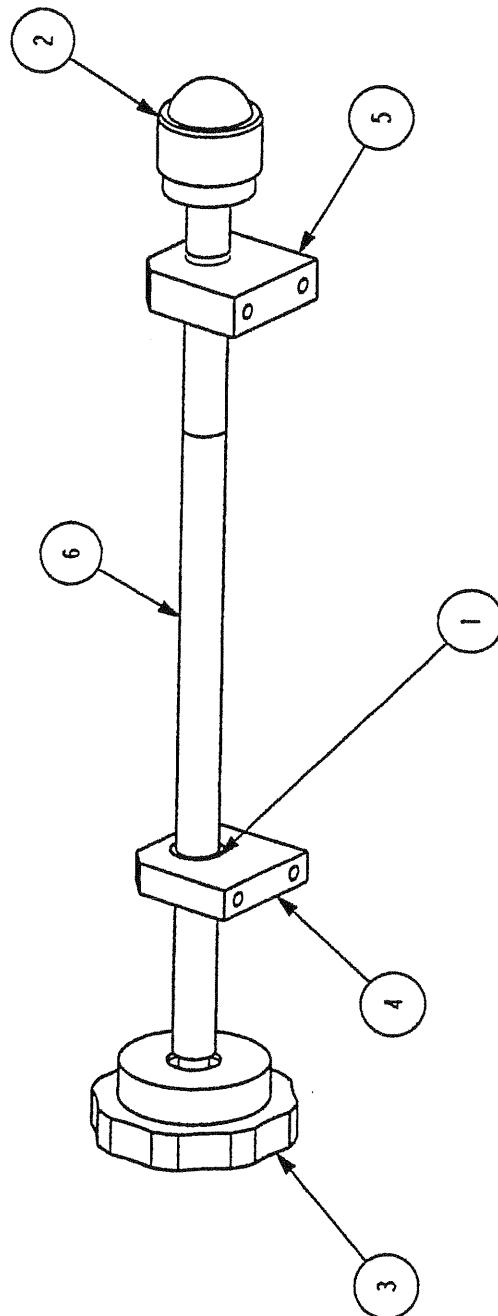
ITEM	QTY	PART #	DESCRIPTION
1	1	103804	BEARING, HUB .625
2	1	536795-01	PLATE-BEARING
3	2	536802-01	BAR-ROUND, BEARING PLATE MOUNT



ITEM	KR33540
REV NO	RED-0
DATE	WHERE USED
DESCRIPTION	
ECN NO	
8Y	
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	
KRK	
KENNESAW, GA 30144 USA	
DRAWN BY: TJC	
SCALE	0 .750
DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	
.00	.000
.01	.005
.06	
.5	
MATERIAL: XXX	
FINISH: XXX	
MEAT TREAT: XXX	
REMOVED ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED	
ALL DIMENSIONS ARE FINISHED DIMENSIONS	
DO NOT SCALE - WORK TO DIMENSIONS ONLY	
CHECKED BY:	DATE: 01 - Nov - 99
TRACED BY:	MASTER: M
SHEET NO. 10F1	DRAWING # 537673-01

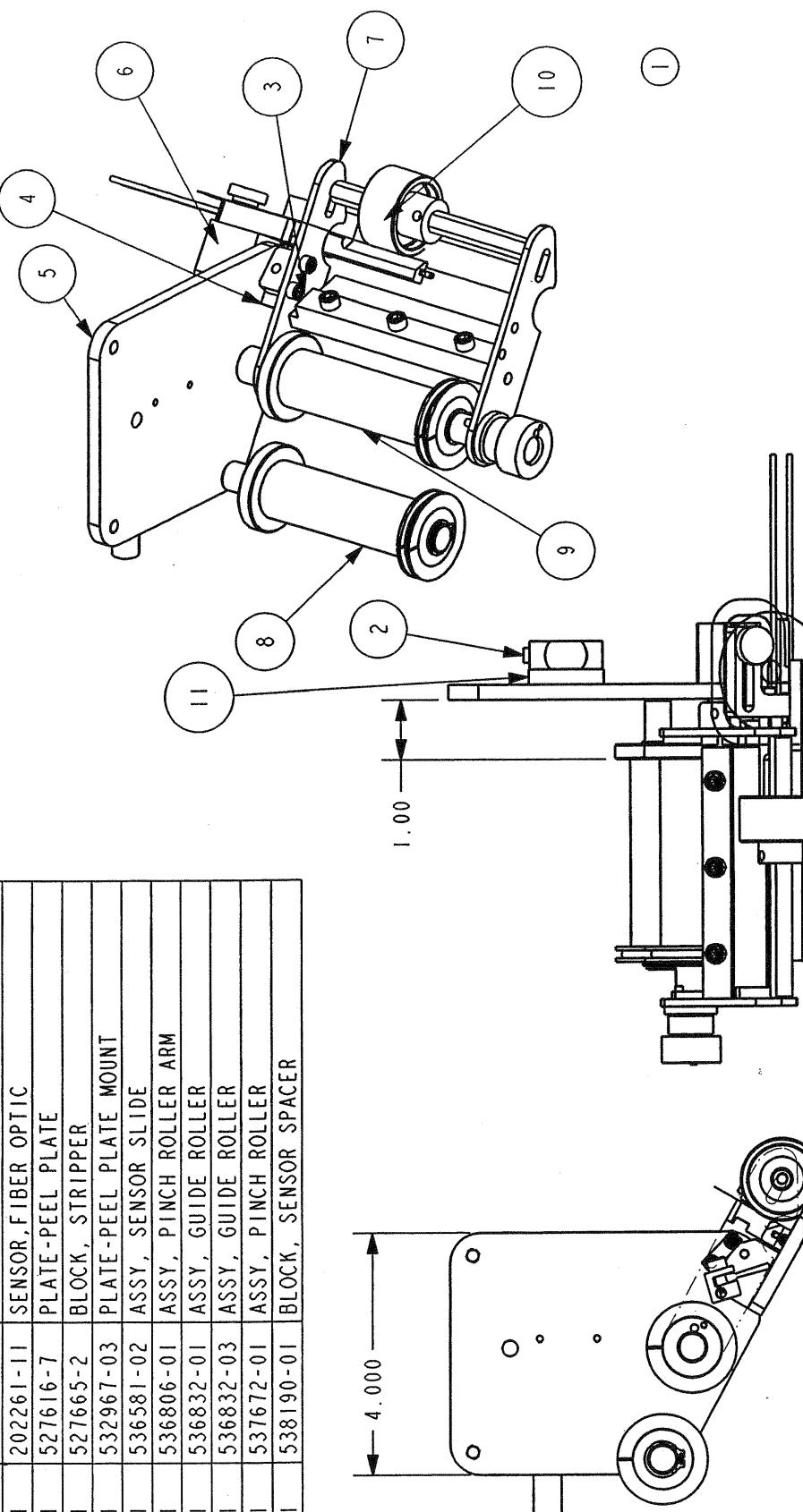
ITEM QTY	PART #	DESCRIPTION
1	100133	BUSHING, SL. 5001D. 375LG
2	103955	BALL TRANSER
3	500772	KNOB
4	536796-01	PLATE-BUSHING
5	536796-02	PLATE-THREADED ADJUSTMENT
6	536822-01	SHAFT-VERT. ADJ

REV NO	DATE	DESCRIPTION	ECN NO	BY
1	21-JUN-00	REPLACED 537675-01 WITH REVISED 536822-01		AIB



1.000	WIRESSWD
RE'D'D	WHERE USED
KR	KIRK - RUDY INC.
	KENNESAW, GEORGIA
WORK:	SP76300
TIME:	ASSY, VERTICAL ADJUSTMENT
SHEET NO.:	10F1
DRAWING #:	536767-01
SCALE:	0 . 500
DRAWN BY:	TVK
CHECKED BY:	DATE: 25-0ct-99
TRACED BY:	MASTER: W1
DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	
.000	.000
.04	.005
.5	
MATERIAL: N/A	
FINISH: N/A	
NOTE: 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 NO	DATE	DESCRIPTION	ECN NO	BY
1	1 190837	WEAR TAPE.					
2	1 202261-11	SENSOR, FIBER OPTIC					
3	1 527616-7	PLATE-PEEL PLATE					
4	1 527665-2	BLOCK, STRIPPER					
5	1 532967-03	PLATE-PEEL PLATE MOUNT					
6	1 536581-02	ASSY, SENSOR SLIDE					
7	1 536806-01	ASSY, PINCH ROLLER ARM					
8	1 536832-01	ASSY, GUIDE ROLLER					
9	1 536832-03	ASSY, GUIDE ROLLER					
10	1 537672-01	ASSY, PINCH ROLLER					
11	1 538190-01	BLOCK, SENSOR SPACER					

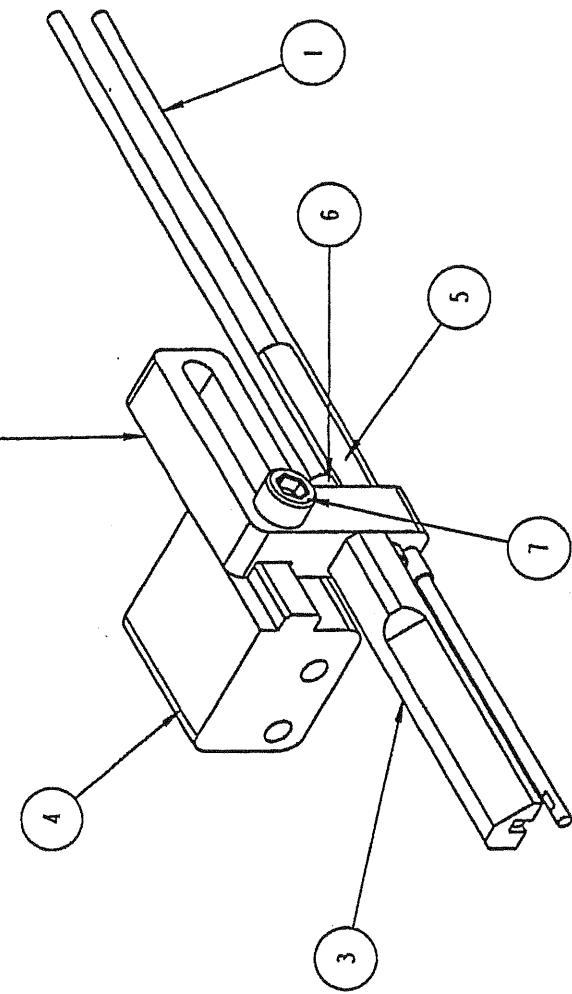


NOTES:
1. SENSOR NOT INCLUDED IN ASSEMBLY. FOR REFERENCE ONLY.

1.000	KR535HD
REQ'D	WHERE USED

SCALE	0.375	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
DRAWN BY:	T JG	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED			
CHECKED BY:		.XX .XXX .005 .01 .005 .01	HEAT TREAT:	N/A	
TRACED BY:		REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED	FINISH:	N/A	
MASTER	M	ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY	MODEL:	535	SHEET NO. OF 2
			TITLE:	ASSY-STRIPPER PLATE	DRAWING #
					536769-02

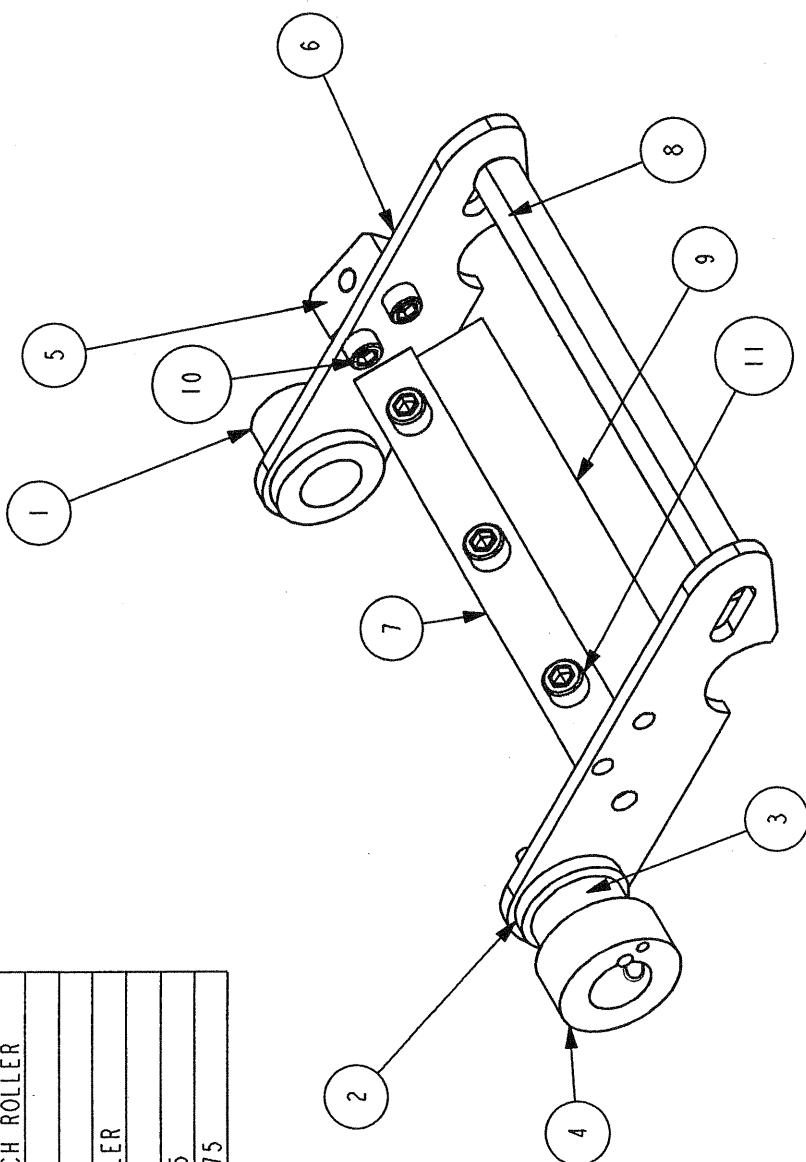
ITEM QTY	PART #	DESCRIPTION
1	202261-12	FIBER, PLASTIC PIPSN26U
2	1	BLOCK, FIBER OPTIC MOUNT
3	1	538157-01 GUARD, FIBER OPTIC
4	1	538159-01 BLOCK, SENSOR SLIDE
5	1	538163-01 SHAFT, FIBER OPTIC SUPPORT
6	3	CSD0153
7	1	CSD0266



REV NO	DATE	DESCRIPTION	ECN NO	BY
I	536769-02			RECD WHERE USED

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, GA 30144 USA
CHECKED BY:	DATE 29-Dec-99	.01 .005	.005 .005	WEAR TREAT: XXX	MODEL: 535
TRACED BY: MASTER		REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED	FINISH: XXX	SHEET NO. 10F1	PRINT: DRAWING #
		ALL DIMENSIONS ARE FINISHED DIMENSIONS			536581-02
		DO NOT SCALE - WORK TO DIMENSIONS ONLY			

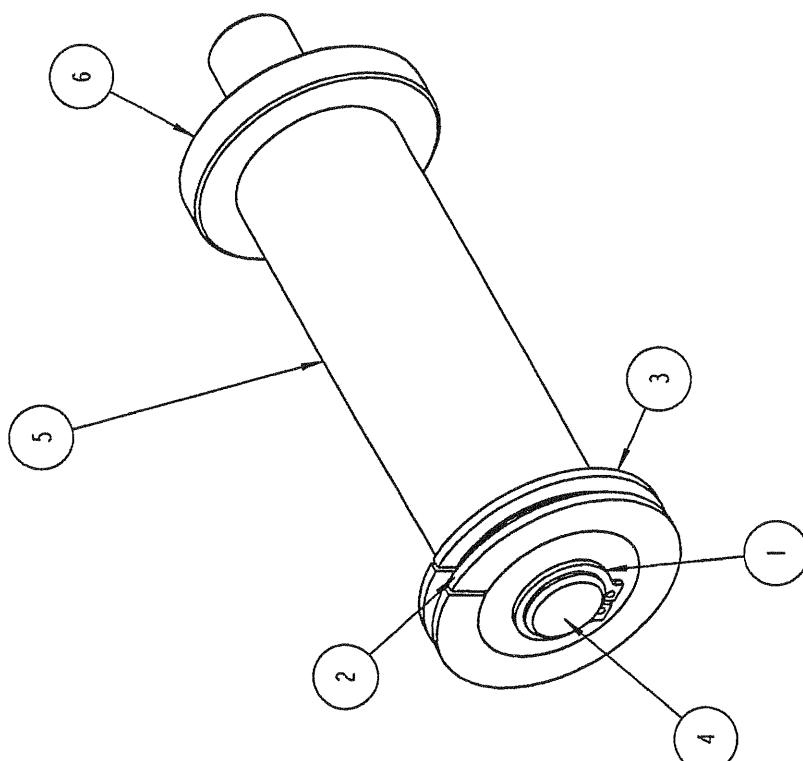
ITEM QTY	PART #	DESCRIPTION
1	100304	BUSHING, FL. 500ID. 62500D. 750LG
2	100323	BUSHING, FL. 500ID. 62500D. 375LG
3	102785	SPRING, TORSION
4	102205-2	COLLAR
5	536770-01	BLOCK-ADJUSTMENT, PINCH ROLLER
6	536772-01	PLATE, BUSHING
7	536773-04	BAR, BRUSH MOUNT
8	536774-01	BAR-ROUND, PINCH ROLLER
9	543367-01	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	6865	JG

1	SPT16300
REQ'D	WHERE USED
KIRK - RUDY, INC. KENNESAW, GEORGIA	
PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE COPIED OR REPRODUCED IN WHOLE OR IN PART EXPRESS WRITTEN PERMISSION OF KIRK - RUDY, KENNESAW, GA 30444 USA	
THIRD ANGLE PROJECTION	VIEW
MATERIAL: XXX	FINISH: OF 1
DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	HEAT TREAT: XXX
.XX -.XXX .005 .5	FINISH: XXX
REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED	
ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY	
DRAWN BY: TVK	SCALE: 0 .750
CHECKED BY:	DATE: 10 - Sep - 99
TRACED BY:	MASTER: M
MODEL: SP76300	
SHEET NO. 1 OF 1	
TITLE: ASSY, PINCH ROLLER ARM	
DRAWING # 536806-01	

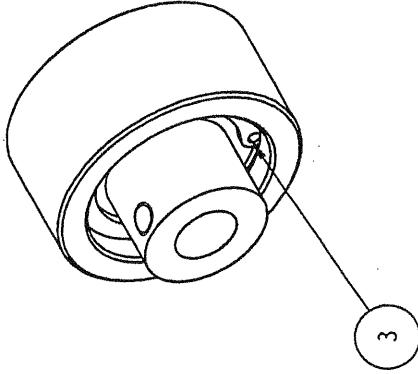
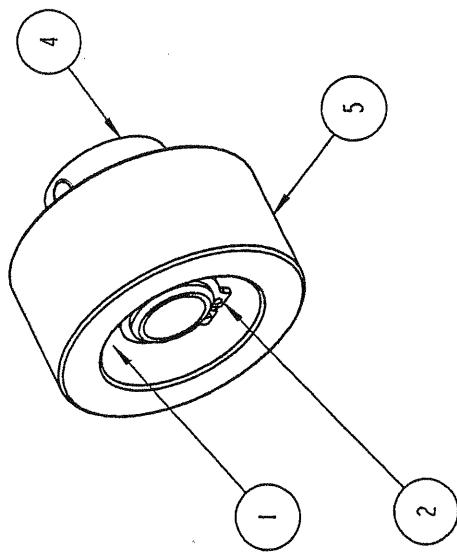
ITEM	QTY	PART #	DESCRIPTION
1	2	104106	SNAPRING, .500
2	1	190895	O-RING, 1.125 X 1.312 X .093
3	1	525205	GUIDE, RING
4	1	536777-01	SHAFT WEB
5	1	536833-01	ROLLER, WEB
6	1	538101-01	DISK, TAB GUIDE



REV NO	DATE	DESCRIPTION	ECN NO	BT
1	7/2/2001	REPLACED EXT. SPRING W/ O-RING	6713	TJG

1	KRK53540
REC'D	WHERE USED
KRK 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 30444 USA	
THIRD ANGLE PROJECTION	
MODEL: SP76300	
TITLE: ASSY, GUIDE ROLLER	
SHEET NO: 10F1	
DRAWING #: 536832-01	
DRAWN BY:	SCALE
TJG	1.000
DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	
.01	.005
DATE:	25-0ct-99
CHECKED BY:	MASTER M
TRACED BY:	
REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED	
ALL DIMENSIONS ARE FURNISHED IN INCHES DO NOT SCALE - WORK TO DIMENSIONS ONLY	

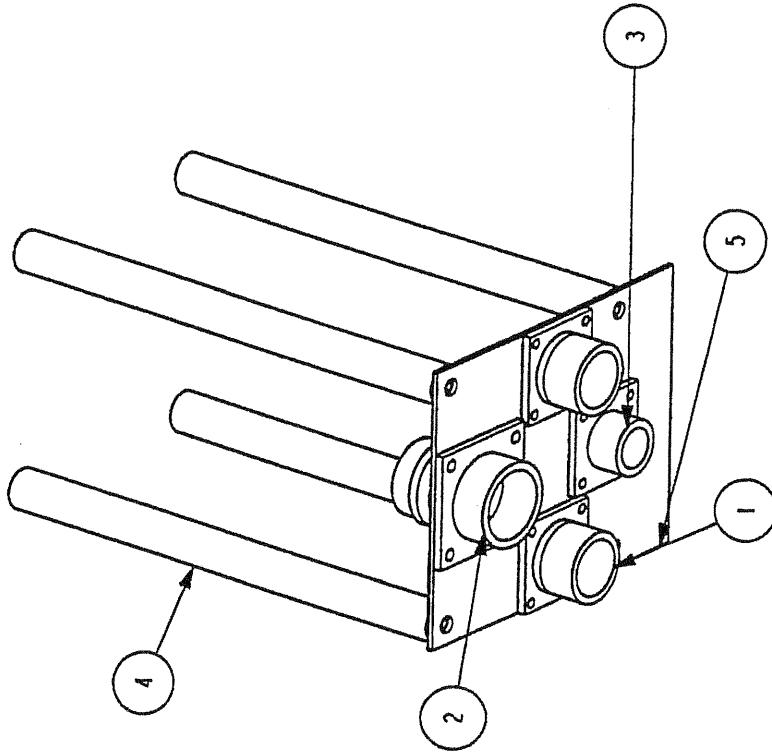
ITEM QTY	PART #	DESCRIPTION
1	103108	BEARING, FLAT .500
2	104106	SNAPRING, .500
3	104205	SNAPRING, INTERNAL 1.125 BORE
4	536771-01	STUD ROLLER
5	536775-01	ROLLER, ARM



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

X	XXX
RECD'D	WHERE USED
KR	KIRK - RUDY INC.
KR	KENNE SAW, GEORGIA
ASSY,	PINCH ROLLER
DRAWING #	537672-01
SCALE	1.000
DRAWN BY:	T JG
DATE	01 - Nov - 99
CHECKED BY:	
TRACED BY:	M
MASTER	
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.	
KENNE SAW, GA 30144 USA	
MODEL: 535	TITLE:
FINISH: XXX	SHEET NO. 10F1
ALL DIMENSIONS ARE	
SHARP EDGES UNLESS	
OTHERWISE NOTED	
ALL DIMENSIONS ARE	
FINISHED DIMENSIONS	
DO NOT SCALE WORK	
TO DIMENSIONS ONLY	

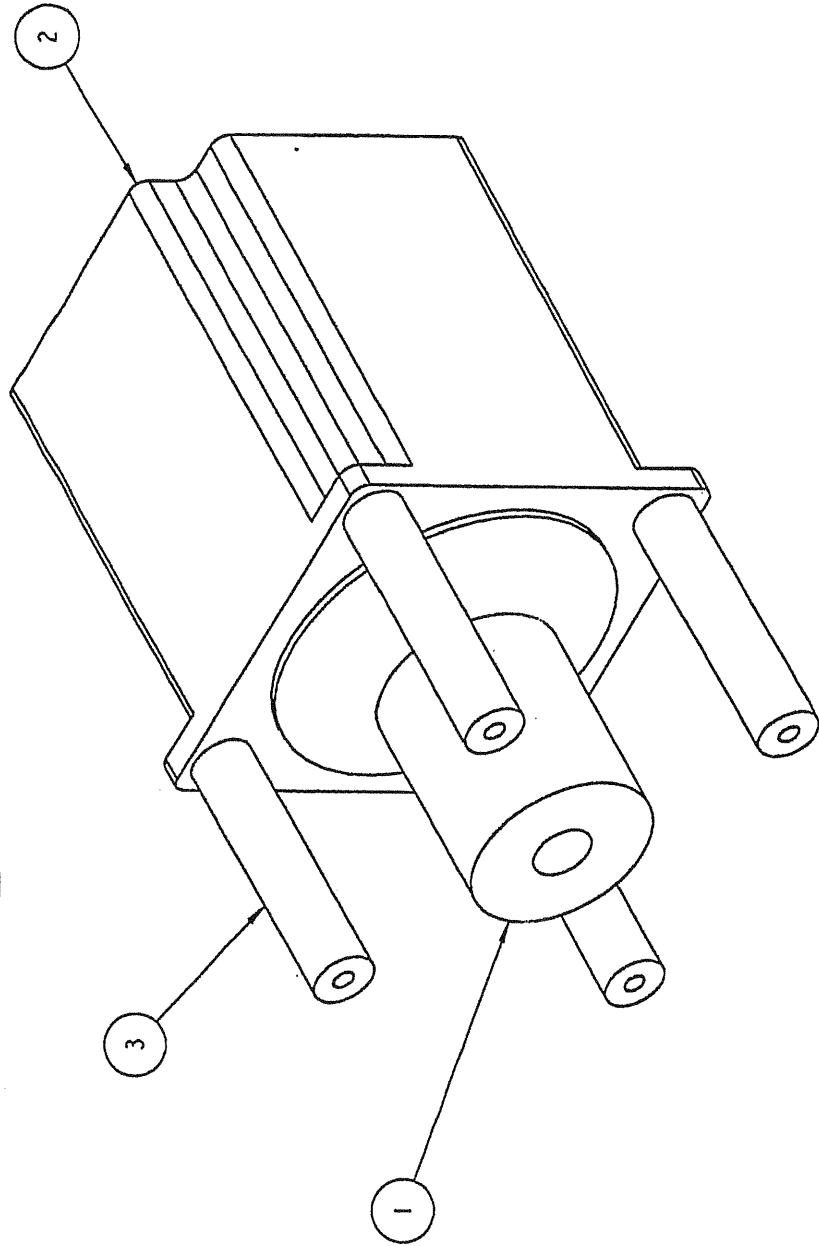
ITEM	QTY	PART #	DESCRIPTION
1	2	200499	RECEPTACLE, AMPHENOL 4 PIN
2	1	200500	RECEPTACLE, AMPHENOL 16 PIN
3	1	200501	RECEPTACLE, AMPHENOL 4 PIN
4	4	536783-01	BAR ROUND, ELECTRICAL PLATE
5	1	536785-01	PLATE-ELECTRICAL CONNECTION



ITEM	REV NO	DATE	DESCRIPTION	ECN NO	BT
1					
2					
3					
4					
5					

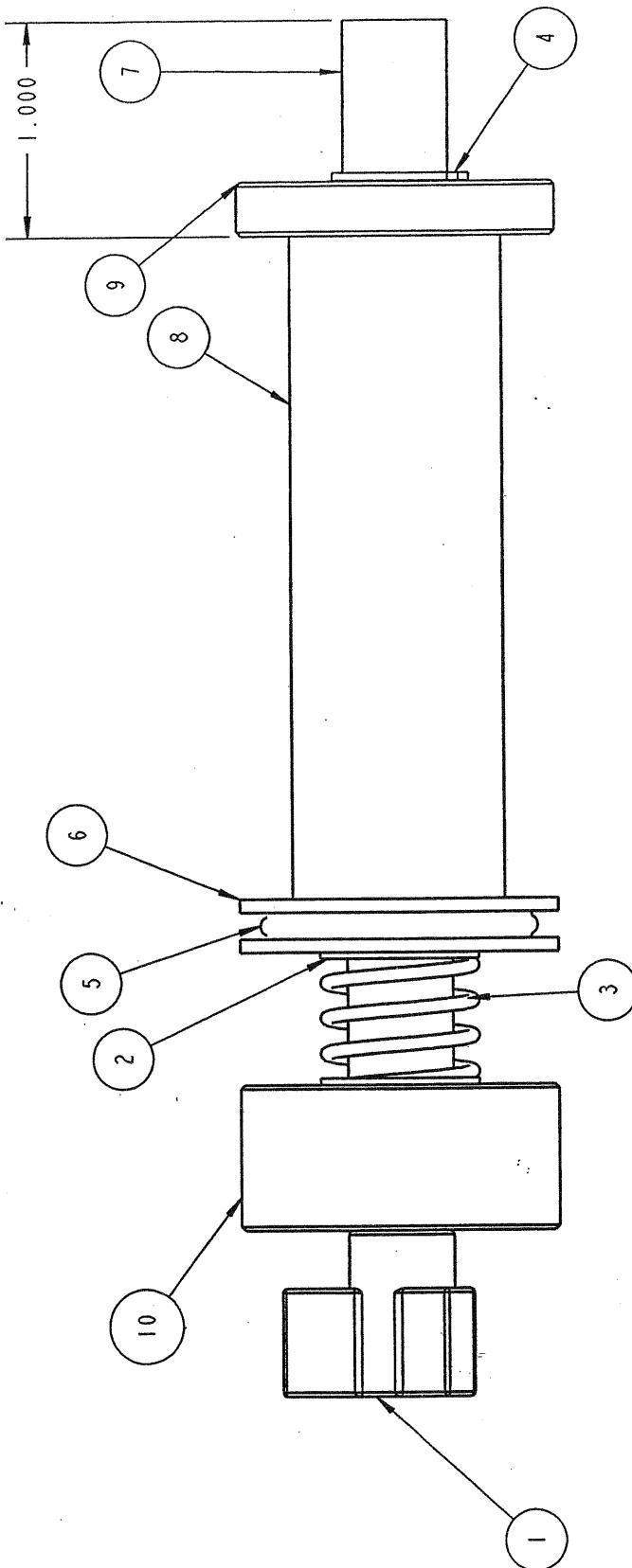
1	KRS35HD	
REC'D	WHERE USED	
KRK	KIRK - RUDY, INC.	
	KENNESAW, GEORGIA	
NAME:	SP76300 ASSY-ELECTRICAL CONNECTION PLATE	
SCALE:	1 OF 1	
DRAWN BY:	TVK	
SCALE:	0 . 500	
DATE:	10-Sep-99	
CHECKED BY:	M	
MASTERS:	M	
FINISHED:	XXX	
ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED	UNIT: INCH.	
.13	.111	.066
.01	.005	.005
HEAT TREAT:	XXX	
REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED	FINISH: XXX	
ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED	FINISH: XXX	
DO NOT SCALE - WORK TO DIMENSIONS ONLY		

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



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 COPIED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC. KENNESAW, GA 30144 USA
CHECKED BY:		DATE:	25-0ct-99	.01 .005 .005	M6. .5	REAR VIEW:	
TRACED BY:				REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED	XXX	NOTE:	
				ALL DIMENSIONS ARE FINISHED DIMENSIONS	XXX	REF.:	SP76300
				DO NOT SCALE - WORK TO DIMENSIONS ONLY	XXX	SHEET NO.:	OF 1
						DRAWING #:	ASSY , MOTOR TAB DRIVE
							536805-01

ITEM	QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECH 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:	SCALE	1 : 250	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	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., USA KIRKSBURG, GA 30144 USA
CHECKED BY:	DATE	15-JUL-03	.005 .005 .005	HEAT TREAT:	N/A	MODEL:	KR535
TRACED BY:	MASTERED	M	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED ALL DIMENSIONS ARE FINISHED UNLESS NOTED DO NOT SCALE - WORK TO DIMENSIONS ONLY	FINISH:	N/A	SHEET NO.	0F1
						DRAWING #	
						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	BAR, BRG HOUSING MOUNT

ITEM	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	B/T

1 KRS355HD
RC'D WHERE USED

3

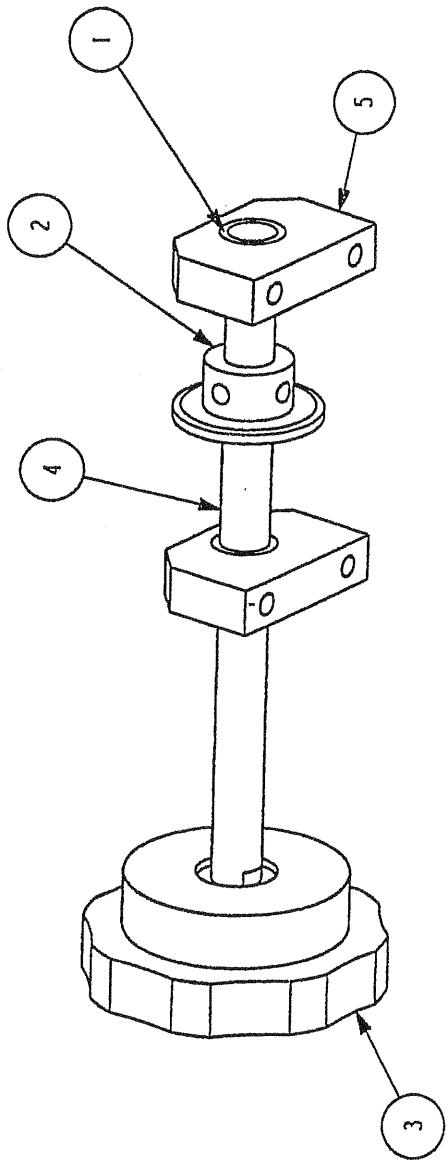
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5

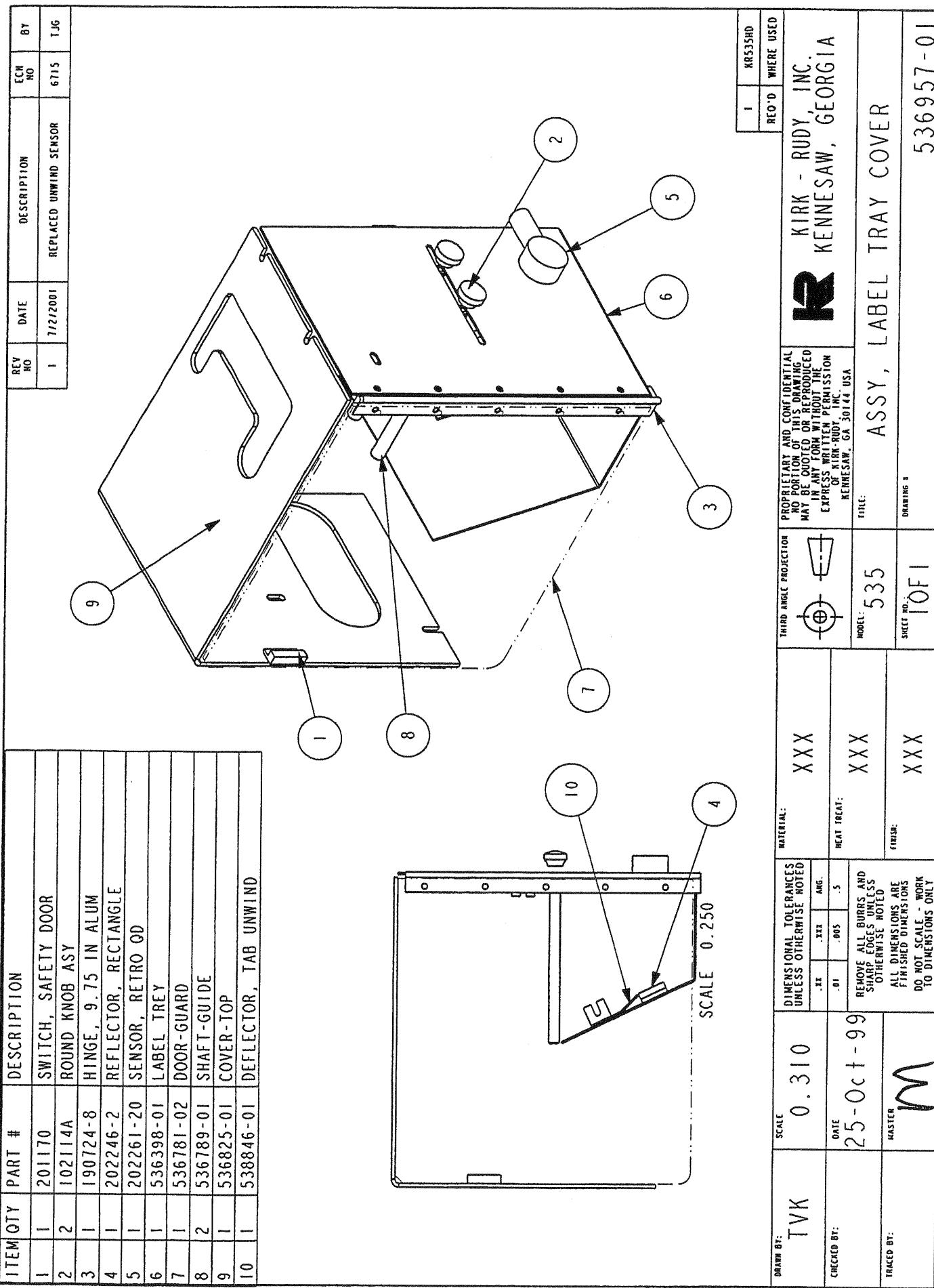
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DRAWN BY:	SCALE	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	MATERIAL:	THIRD ANGLE PROJECTION	PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE QUOTED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC. KENNESAW, GA 30144 USA
T JG	0 . 500	.01 .005 .5	XXX	XXX	535
ENCHED BY:	DATE	REMOVED ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED	HEAT TREAT:	535	535
TRACED BY:	MASTER	ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO OTHER STANDARDS ONLY	FINISH:	XXX	XXX
			SHEET NO.	10F1	DRAWING #
					536951-01

ITEM	QTY	PART #	DESCRIPTION
1	2	100101	BUSHING, SL.3751D.50000D.375L6
2	1	111207	SPRKT. 25813 .375B NK
3	1	500772	KNOB
4	1	536757-02	STUD-DRIVE SPROCKET
5	2	536796-04	PLATE-BUSHING



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 EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC., KENNESAW, GEORGIA
CHECKED BY:	DATE	.01 .005	.005 .005	FINISH:	SP76300	REF'D:
TRACED BY:	MASTER	M	REMOVE ALL CHURRS AND SHARP EDGES UNLESS OTHERWISE NOTED ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY	N / A	SHEET NO. 10F1	WHERE USED
						SP76300
						ASSY-CROSS ADJUSTMENT
						536766-02



ITEM	QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	2	100131	BUSHING, SL.250ID.375OD.250LG	1	10/10/2000	ADDED WIRE STRIPPER	6596	TJG
2	1	100162	BUSHING, SL.500ID.625OD.625LG	2	10/22/2004	REPLACE 538373-01 SHAFT WITH 536774-01 AND ADDED COLLAR	102216-1	CNC
3	2	100302	BUSHING, FL.375ID.500OD.500LG					
4	2	102206	COLLAR .250					
5	1	102623	SPRING, EXT.360D X .298ID X 2.5LG					
6	2	103803	BEARING, HUB .500					
7	1	103804	BEARING, HUB .625					
8	1	104106	SNAPPING, .500					
9	1	190619	PLATE, NAME					
10	1	102114A	ROUND KNOB ASSY					
11	1	102216-1	COLLAR .375					
12	1	5332788-02	WLDMNT, TAKE-UP ROD					
13	1	536374-03	PLATE, TABBER FRAME					
14	1	536774-01	BAR-ROUND, PINCH ROLLER					
15	1	538124-01	BAR, VERTICAL STOP					
16	1	538137-02	PLATE, TAKE-UP ROLL EXT.					
17	1	538195-01	SHAFT, REWIND ARM PIVOT					
18	2	538374-01	STRIPPER, TAB UNWIND					

SCALE 0.250

REF'D WHERE USED

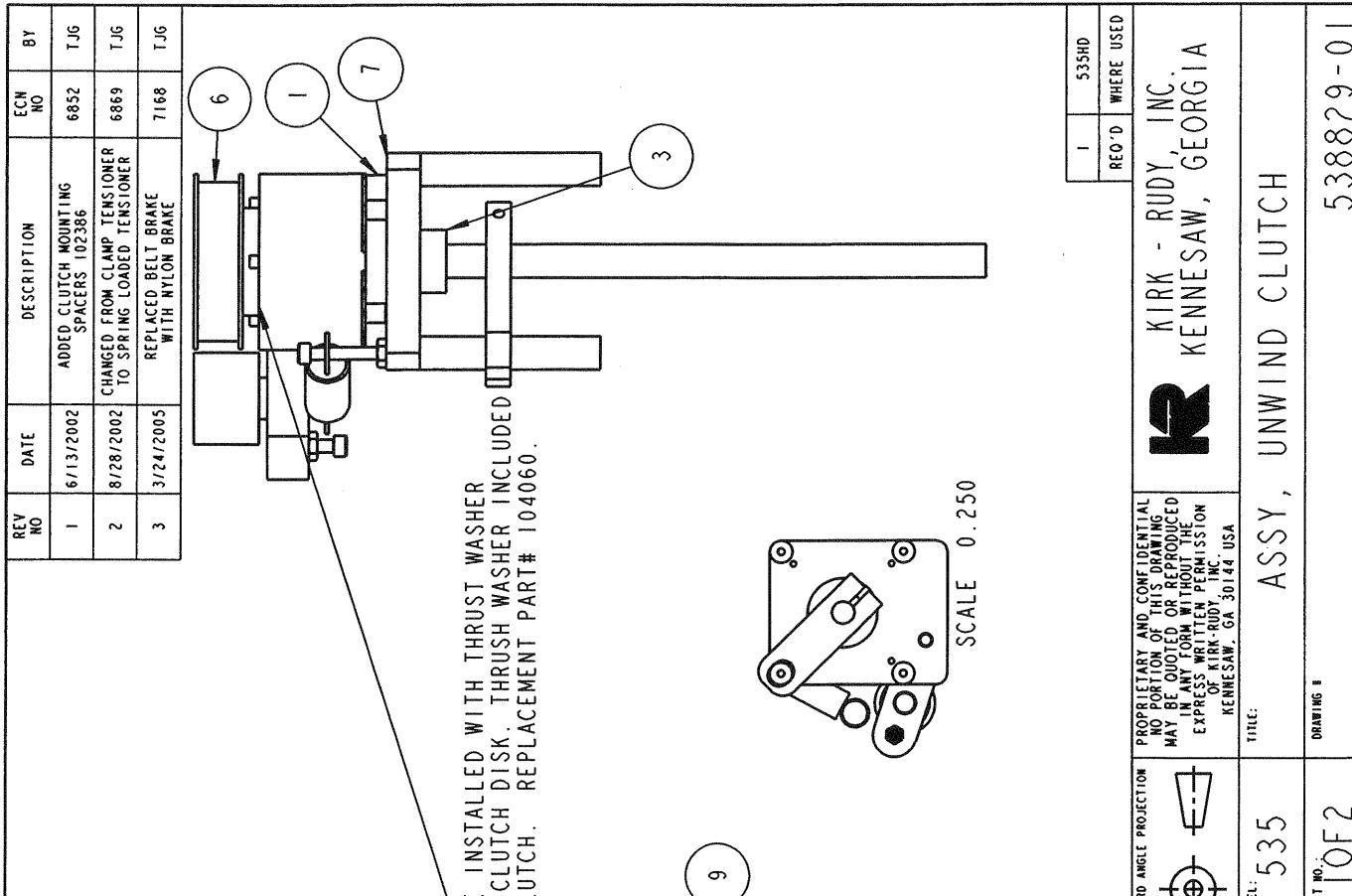
1 KRS33HD

REF'D WHERE USED

1 KRS33HD

DRAWN BY:	T JG	SCALE	0 . 250	MATERIAL:	X X X	THIRD ANGLE PROJECTION	PROPRIETARY AND CONFIDENTIAL INFORMATION OF THIS DRAWING MAY NOT BE COPIED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY INC.
CHECSED BY:		DATE	22-0c†-99	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	.XX .XXX ANG.		KIRK - RUDY, INC. KENNESAW, GEORGIA
TRACED BY:		MASTER		REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED	.01 .005 .5	MODEL: 5355	ASSY, FRAME W/ BEARINGS
				ALL DIMENSIONS ARE FINISHED DIMENSIONS		SHEET NO. 1 OF 1	DRAWING #
				DO NOT SCALE - WORK TO DIMENSIONS ONLY			537669-01

ITEM QTY	PART #	DESCRIPTION
1	4	102386 SPACER, .189X.375X.312
2	1	102775 SPRING, EXT EO 500-055-1750M
3	1	103803 BEARING, HUB .500
4	1	104059 CLUTCH, SIZE 26 .500B 90VDC
5	2	104104 SNAPPING, .625
6	1	109498 20L050 TIMING PULLEY W/C'BORES
7	1	531387-02 PLATE, CLUTCH MOUNT
8	4	536950-03 SHAFT, CLUTCH PLATE MOUNT
9	1	538830-01 SHAFT, UNWIND CLUTCH
10	1	542624-01 SHAFT, TENSION PIVOT
11	1	542625-01 ASSY, ARM BELT TENSIONER
12	1	548441-01 BRAKE, UNWIND CLUTCH SHAFT
13	1	CSDD269 SCREW, SHCS 10-32X1.000
14	1	CSDD273 SCREW, SHCS 10-32X2.000
15	2	HMSN10 NUT, HEX #10-32



DRAWN BY:	SCALE	MATERIAL:	THIRD ANGLE PROJECTION	PROPRIETARY AND CONFIDENTIAL
T JG	0 .375	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	X X X	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 .xxx .005 .005 .005	HEAT TREAT:	-
TRACED BY:	MASTER	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED	FINISH:	MODEL: 535

REV NO	DATE	DESCRIPTION	ECN NO	BY
1	6/13/2002	ADDED CLUTCH MOUNTING SPACERS 10386	6832	TJG
2	8/28/2002	CHANGED FROM CLAMP TENSIONER TO SPRING LOADED TENSIONER	6869	TJG
3	3/24/2005	REPLACED BELT BRAKE WITH NYLON BRAKE	7168	TJG

I	535HD
REQ'D WHERE USED	

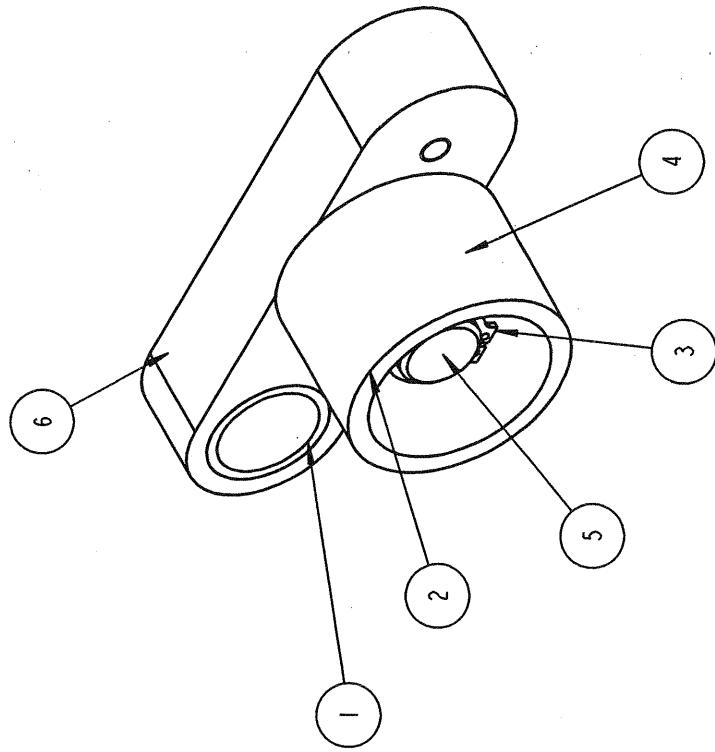
I	535HD
REQ'D WHERE USED	

ASSY, UNWIND CLUTCH

DRAWING #

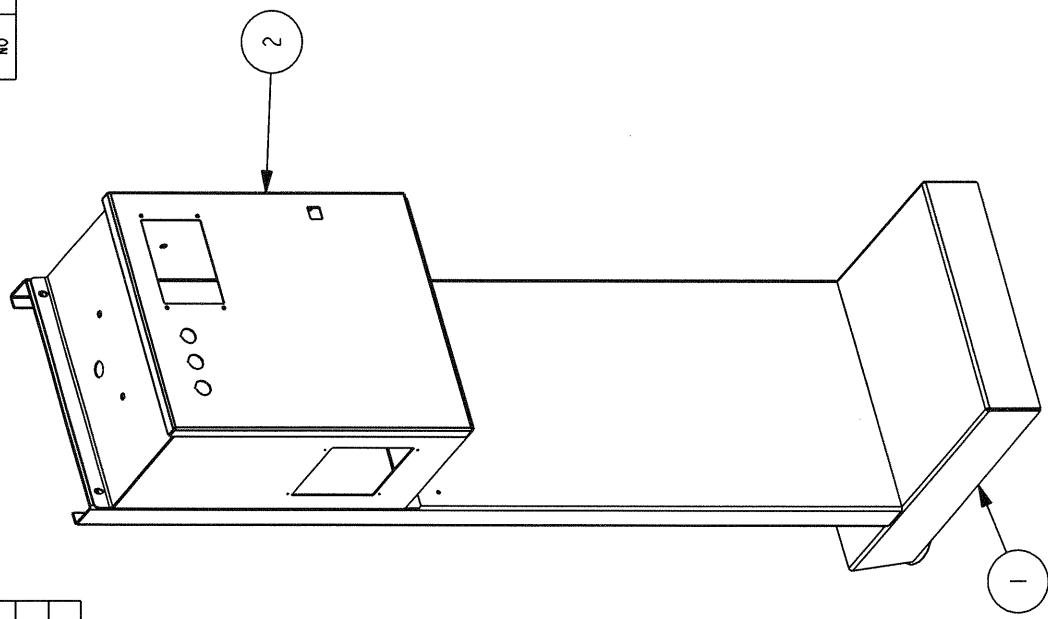
538829-01

ITEM QTY	PART #	DESCRIPTION
1	100144	BUSHING, SL. 6251D. 7500D. 625LG
2	103108	BEARING, FLAT .500
3	104106	SNAPRING, .500
4	516045	ROLLER, BELT TAKEUP
5	508682-1	STUD, IDLER GEAR
6	542623-01	ARM, BELT TENSIONER



DRAWN BY:	SCALE	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	MATERIAL:	THIRD ANGLE PROJECTION	PROPRIETARY AND CONFIDENTIAL NO PART OF THIS DRAWING MAY BE QUOTED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC. KENNESAW, GA 30144 USA	RECD-D WHERE USED
T JG	1 .000	.XX .XXX ANG.	XXX			KIRK - RUDY, INC. KENNESAW, GEORGIA
CHECKED BY:	DATE	.01 .005 .5	HEAT TREAT:		MODEL: 535CS	ASSY, ARM BELT TENSIONER
TRACED BY:	MASTER	2 - AUG - 02	FINISH:		SHEET NO. 10F1	DRAWING #
		REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY	XXX			542625-01

ITEM	QTY	PART #	DESCRIPTION
1	1	300029	WLDMNT, INDEXER BOX STAND
2	1	531724-02	WLDMNT, KR535CS CONTROLS BOX



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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 04 00	Schematic, KR535HD Tabmaster Schematic, KR535CSHD Tabmaster
SYMBOLS.ORC	Schematic Symbols Reference

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
Beamswitch	Banner
Tab Detector	Banner
Interface	Maple Systems

10.0 NOTES

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

Kirk-Rudy, Inc.
125 Lorraine Parkway
Woodstock, GA 30188
www.kirkrudy.com