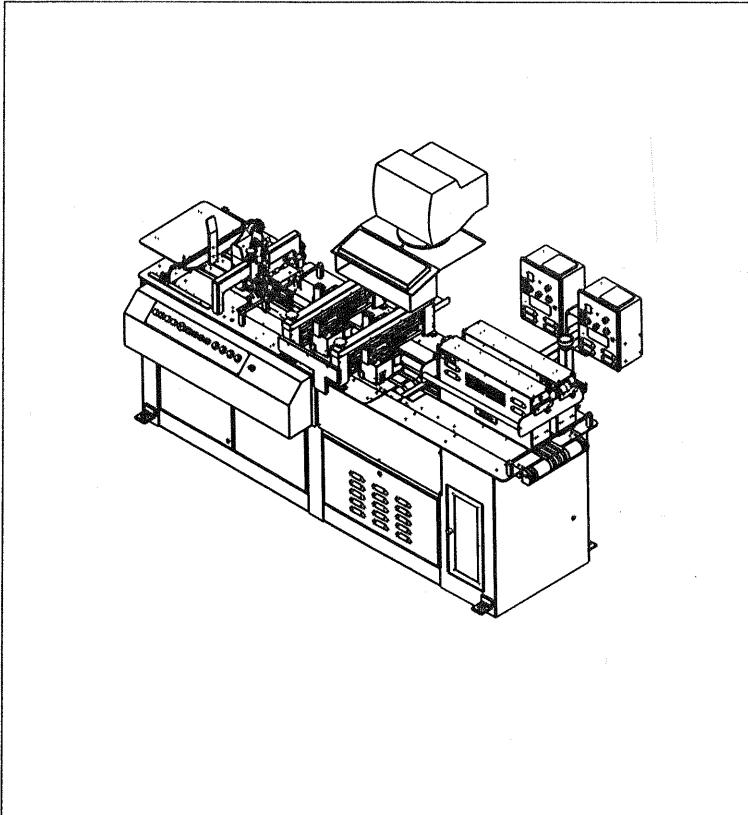


Kirk-Rudy, Inc.

Instruction and Parts Manual

KR215P RITE-JET

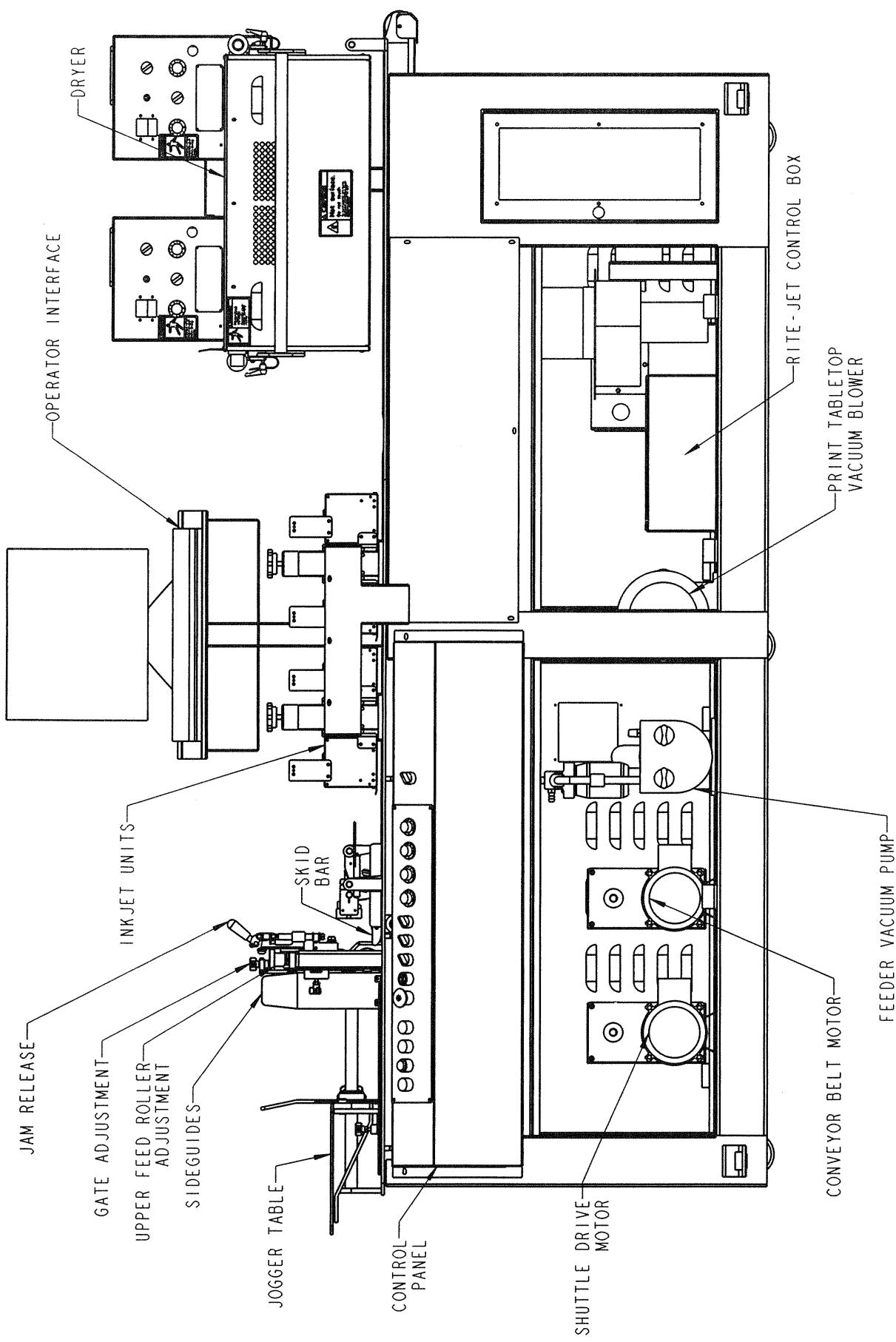


NOTE: Some items are for view reference only.
Manufactured by Kirk-Rudy, Inc.

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

10000-215P REV. 1 10/18/2001

Instruction
and Parts Manual



KR215P COMPONENTS DESCRIPTION
FIG. 2

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

1 Important Safety Instructions

Intended Use Statement: The KR215P is a top load, bottom feed transport designed to separate and feed product for inkjet printing and drying. Once product has left the shuttle feeder, a vacuum conveyor table will be used to transport the product under inkjet heads for printing. Next, product will be transferred to a heat belt section. The heat belt section will use a high temperature vacuum blower to control the product as it is conveyed under an inkjet print dryer. 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 MISFED PRODUCT JAM THE MACHINE AND STOP IT FROM RUNNING, ALWAYS PRESS THE STOP BUTTON BEFORE CLEARING PRODUCT. IF THE STOP BUTTON IS NOT PRESSED AND THE JAM IS CLEARED, THE MACHINE WILL BEGIN RUNNING.* IT IS NOT RECOMMENDED THAT LOOSE CLOTHING, JEWELRY AND LONG HAIR BE WORN WHILE OPERATING THIS MACHINERY.* ALWAYS USE AN EXPERIENCED ELECTRICIAN WHEN TROUBLE-SHOOTING ELECTRICAL PROBLEMS.* CHANGES OR MODIFICATIONS TO THIS UNIT NOT EXPRESSLY APPROVED BY THE PARTY RESPONSIBLE FOR COMPLIANCE COULD VOID THE USER'S AUTHORITY TO OPERATE THE EQUIPMENT.	

NOTE: THIS EQUIPMENT HAS BEEN TESTED AND FOUND TO COMPLY WITH THE LIMITS FOR A CLASS A DIGITAL DEVICE, PURSUANT TO PART 15 OF THE FCC RULES. THESE LIMITS ARE DESIGNED TO PROVIDE REASONABLE PROTECTION AGAINST HARMFUL INTERFERENCE WHEN RADIO FREQUENCY ENERGY AND, IF NOT INSTALLED AND USED IN ACCORDANCE WITH THE INSTRUCTION MANUAL, MAY CAUSE HARMFUL INTERFERENCE TO RADIO COMMUNICATIONS. OPERATION OF THIS EQUIPMENT IN A RESIDENTIAL AREA IS LIKELY TO CAUSE HARMFUL INTERFERENCE IN WHICH CASE THE USER WILL BE REQUIRED TO CORRECT THE INTERFERENCE AT HIS OWN EXPENSE. SHIELDED CABLES MUST BE USED WITH THIS UNIT TO ENSURE COMPLIANCE WITH THE FCC CLASS A LIMITS.

2 SPECIFICATIONS

PRODUCT SIZE RANGE	English	Metric
Minimum Size:	3" W x 5" L	7.6cm W x 12.7cm L
Maximum Size:	17" W x 17" L	43.1cm W x 43cm L
Minimum Thickness:	Card Stock (.007")	Card Stock (.10mm)
Maximum Thickness:	.625"	15.9 mm

MACHINE DATA BASE

Length	100"	254 cm
Width	44.75"	113.7 cm
Height (tabletop)	33.25"	84.5 cm
Weight	lbs	kg
Shipping	lbs	kg

ELECTRICAL

Base Main Power Input:	220 VAC, Single Phase,4-WIRE 60/50 Hz,30 A
Feeder Drive Motor:	½ H.P. DC
Vacuum Pump:	½ H.P. DC
Table Conveyor Motor:	½ H.P. DC
Vacuum Blower:	120 Volt, AC 60/50 Cycle, 1.4 A
Speed Up Conveyor Motor:	¼ H.P. DC

3 INSTALLATION



WARNING

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

3.1 UNCRATING

1. Position crate near installation site.
2. Remove crate top and sides.
3. Locate accessories box and verify all items are present.
4. Remove metal strapping and securing blocks.
5. Use forklift to lift machine off skid. Be sure to position the forks in a centrally located position.
6. Machine is on casters and can be rolled to desired location.
7. Adjust the height of the base with the four leveling legs
8. Locate and attach electrically the KR Conveyor (if purchased with KR215P). The electrical connections for the conveyor are located on the left side of the machine from the direction of product flow.
9. Locate and attach electrically the dryer. **Warning: Dryer must be externally powered. DO NOT USE ELECTRICAL OUTLETS INSIDE CABINET FOR DRYER.** The electrical connection (two pin twist) to enable the dryer is located on the left side of the machine from the direction of product flow.

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

3.2 ACCESSORIES AND SPARE PARTS

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

3.3 COMPONENT DESCRIPTION (see Figure 2)

1. JOGGER TABLE: Used to set the backstop for the product being fed. Can also be used to hold extra product.
2. FEEDER: Pushes product into gate and feed rollers.
3. GATE ADJUSTMENT: Prevents more than one piece of product from being fed at one time.
4. UPPER FEED ROLLER ADJUSTMENT: Along with the lower feed rollers, feeds product through the bridge.
5. JAM RELEASE: Raises top feed rollers, so a jam can be fixed.
6. SIDE GUIDES: Keeps product from skewing while traveling on the tabletop.
7. SKID BAR: Detects jam up and provides friction to drive product.

8. OILER: Used to lubricate shuttle bushings.
9. FEEDER VACUUM PUMP: Supplies vacuum to the feeder.
10. SHUTTLE DRIVE MOTOR: Drives the feeder shuttle table.
11. TABLETOP VACUUM BLOWER: Supplies vacuum to the tabletop.
12. HIGH TEMPERATURE VACUUM BLOWER: Supplies vacuum to the dryer tabletop.
13. CONTROL PANEL (for more detail, see Section 4.1 and Figure 2.0): Contains operator controls.
14. ENCODER: This device measures speed of belts and is driven off the front roller shaft. This is used to get the correct speed for printing.
15. INKJET UNITS: This is location of inkjet heads.
16. RITE-JET CONTROLLER: This controller interfaces with computer to control all inkjet functions.

4 OPERATING INSTRUCTIONS

4.1 BASE – ELECTRICAL OPERATION

OVERVIEW OPERATOR CONTROLS



WARNING

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

The following controls are located on the operator side of the feeder base. (**FIG. 1**)

Feeder Stop Switch: When this two-position switch is depressed the feeder portion of the machine will turn off. The feeder that is controlled is dependent on the position of the 215/496 mode switch. The rest of the machine past the feeder will continue to operate.

Stop Switch (red): Machine operation can be manually stopped by depressing the stop button on the operator panel or the button on the left panel of the conveyor. This will stop all conveyors and the feeder.

Jog Switch (black): The machine can be inched or jogged by depressing and releasing this switch. The machine will continue to cycle if this button is held depressed.

Start Switch (green): Continuous machine operation is achieved by depressing this switch momentarily and releasing.

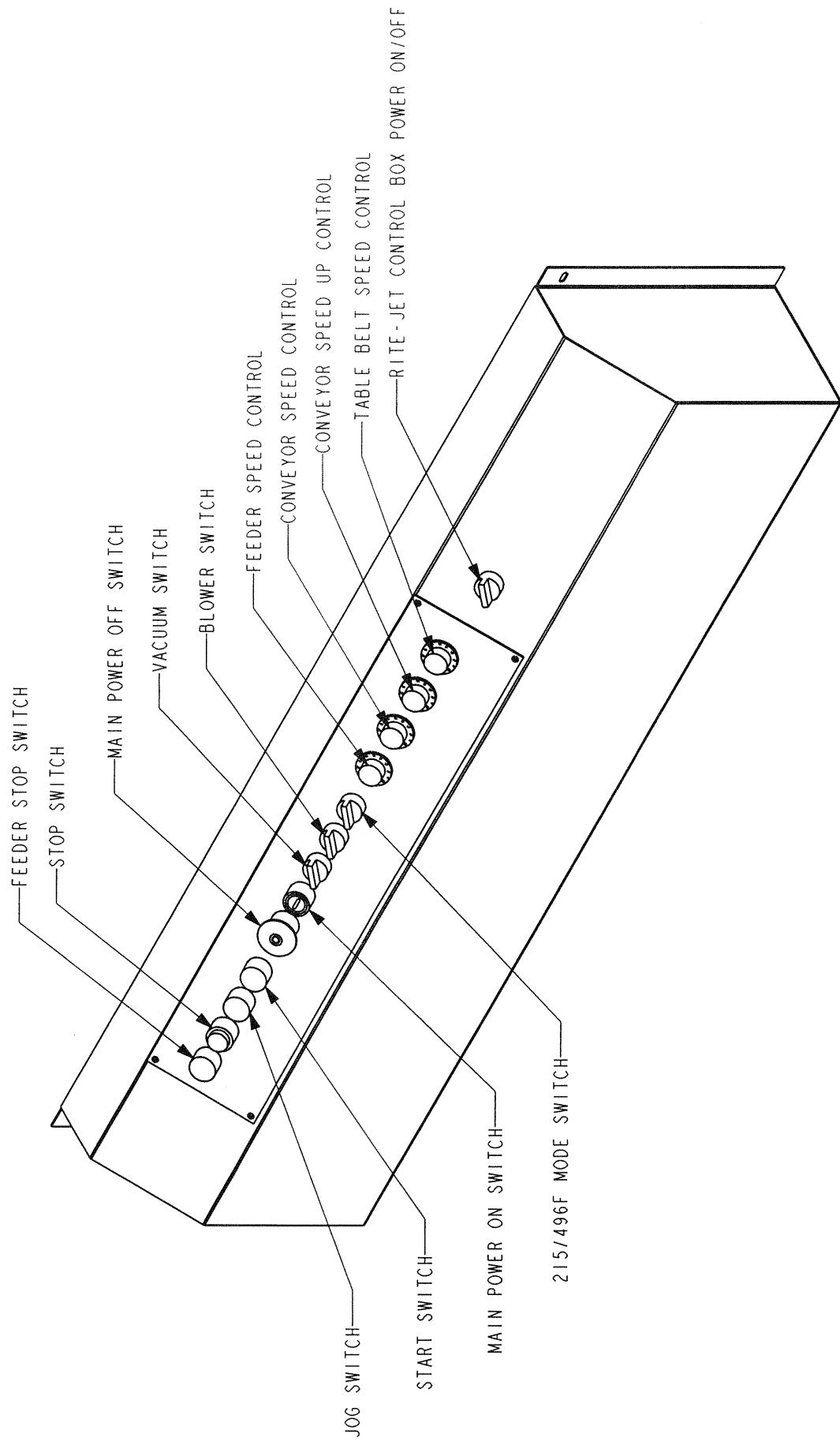
Main Power Off Switch: This switch cuts power to the entire machine. Twist to unlatch.

Main Power Switch: When this two-position switch is depressed, source voltage is supplied to the electrical panel. This will make all of the switches on the electrical control panel active. The switch will be light green when activated.

Vacuum Switch: Rotate this switch to actuate the feeder vacuum pump.

Blower Switch: Rotate this switch to actuate both vacuum blowers. One is for the inkjet table. One is for the dryer table.

215 or 496 Mode Switch: This (optional) switch enables a 496 friction feeder, which can be used on top of the existing shuttle feeder. The 496 feeder (optional) will plug (two pin twist) into the left side panel of the electrical control box.



KR215P CONTROL PANEL
FIGURE 1.0

Speed Control, Feeder: Machine speed can be varied by turning the first knob. Turn knob clockwise to increase shuttle speed, counterclockwise to decrease.

Speed Control, Conveyor: The second knob controls the speed of the belts on the shingle conveyor. When the main drive motor speed is set at a convenient range to continually replenish product in the feed hopper and for zip code sorting requirements, the conveyor speed should be adjusted for required product overlap. Turn knob clockwise to increase belt speed, counterclockwise to decrease.

Speed Control, Conveyor Speed Up: The third knob controls the speed up of the belts on the shingle conveyor. Turn knob clockwise to increase belt speed, counterclockwise to decrease.

Speed Control, Table Conveyor: The forth knob controls the speed of the belts on the dryer table. Turn knob clockwise to increase belt speed, counterclockwise to decrease.

ELECTRICAL COMPONENT DESCRIPTION

Stack Detection Beamswitch: Detects the presence of a stack in the hopper area. If no stack is detected the feeder drive motor will stop. This sensor is mounted to the bottom of the left side guide.

Dryer Product Detect Beamswitch: Detects the presence of product on the base. If no product is detected for a certain amount of time the dryer lamps are turned off. This feature is used to increase belt life and decrease power consumption.

Rite-Jet Product Detect Beamswitch: Detects the presence of product on the base for print placement.

Safety Features, Electrical: All devices are fully protected as follows:

- Main Drive Motor: The solid state component board mounted inside the electrical panel has a 12ABC input fuse and a 8AGC armature output fuse. The main drive motor will not operate with this fuse blown.
- Table Conveyor Drive Motor: The conveyor drive board has a 12ABC and 8AGC fuse.
- Vacuum Pump Motor: Mounted on the inside of the electrical panel, are two 8MDL fuses.
- Shingle Conveyor Drive Motor: The conveyor drive board has a 12ABC and 4AGC fuse.

- Inkjet Table Vacuum Blower Motor: Mounted on the inside of the electrical panel is a 3.2 MDL fuse.
- Dryer Table Vacuum Blower Motor: Mounted on the inside of the electrical panel is a 3.2 MDL fuse.
- AC Outlet Boxes: Each box is fused at 8 amps/120 VAC.

PLUG INTERFACES

Plug Description	Plug Type
Rite-Jet controller interface Plugs (see figure #1)	
Rite-Jet/215P	8-Pin
Encoder	9-Pin
Product Beamswitch	4-pin
Dryer Plugs:	
Dryer Enable: Contact Closure	Male 2-Pin Twist
Dryer Enable: +24 VAC	Female 3-Pin Twist
Dryer Drive Control	Female 4-pin Molex
Power Supply Plugs:	
220 Vac/I Phase/30 Amp	4-Pin/4-wire
120 Vac, 8 Amp	Standard 120VAC outlet
Stop Plug:	
Conveyor Stop: Contact Closure	Female 2-Pin Turck
Conveyor Plug:	
Conveyor Motor	Female 3-Pin Turck
Stacker Plug:	
Stacker cycle	Female 3-pin Molex
Stacker divert	Female 3-pin twist

RITE-JET CONTROLLER OUTPUT SIGNALS

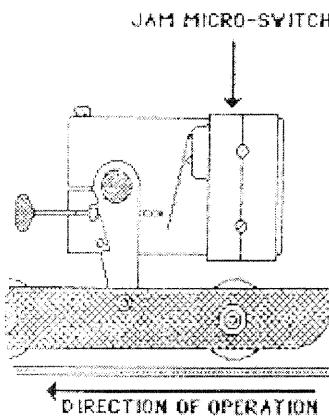
Conveyor Speed Up/ Stacker Cycle: The conveyor speed up/stacker cycle output signal is used for two different functions depending on which machine is placed inline with the 215. The conveyor speed up is used to control speed up on a shingle conveyor for address breaks. The amount of time for the speed up is determined by the Rite-Jet controller. The stacker cycle function (bundle break) uses the Rite-Jet controller to signal the KR630/703 stacker for bundle breaks. Note: Use optional KR938 Signal Tracking System when installing equipment between KR215P and KR630/703 stackers.

Feeder Stop: The feeder stop function is used to stop the shuttle motor at the end of a run.

Stacker Divert: The Rite-Jet controller divert function is used to signal the divert on the KR630/703 stacker.

4.2 STOP CIRCUIT

The stop circuit is wired in series, this means that if one of the stop switches or buttons is open, the machine will not run. There are six stop switches on the KR215P. They are the jam microswitch on the skid bar assembly, the Bryce stop out, the stop button, conveyor stop (E-box input), low hopper and the control panel emergency stop button.



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

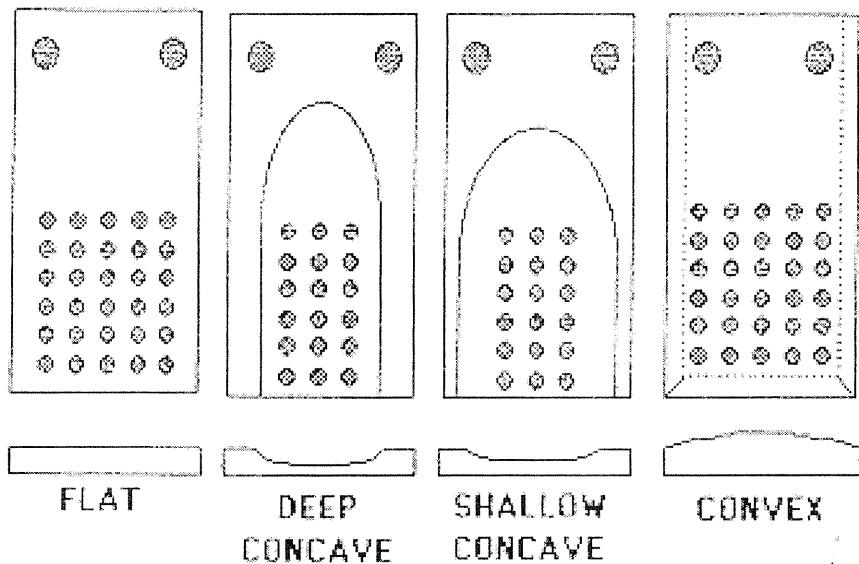
The second switch that is most often open is the conveyor stop button. This button is usually open because of improper seating of the plug that goes into the back of the machine. If neither the machine nor the conveyor will run (conveyor power switch in “automatic” position) when the start button is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

4.3 SEQUENCE OF SET-UP

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

4.4 VACUUM PLATES

Before setting up the feeder, the correct vacuum plate should be selected and installed. There are four vacuum plates available for the KR215P.



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

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

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

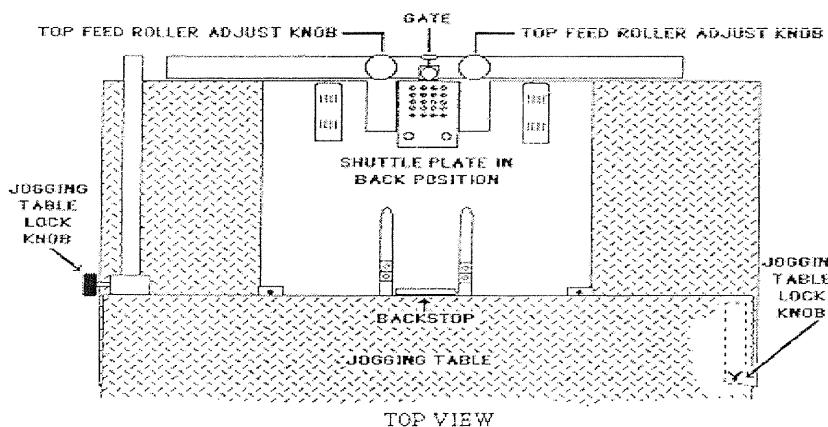
CONVEX PLATE: For tri-folded or self-mailers and can also be used for product that has a warp or bend.

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

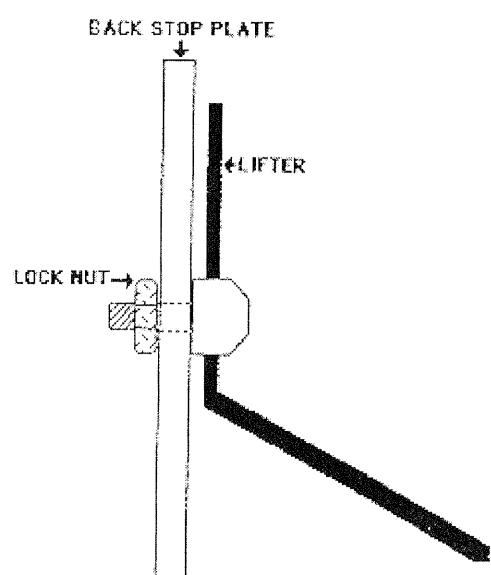
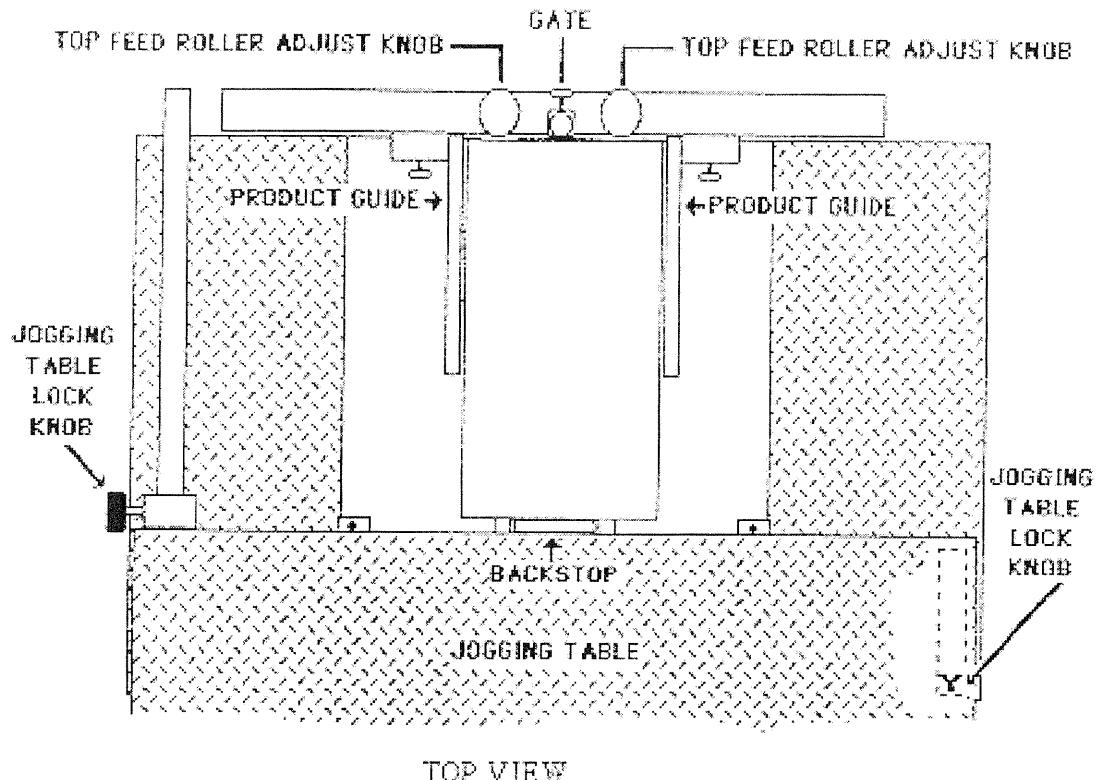
4.5 SHUTTLE/FEEDER SET-UP

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

Jog the machine until the shuttle plate is in the extreme back position.



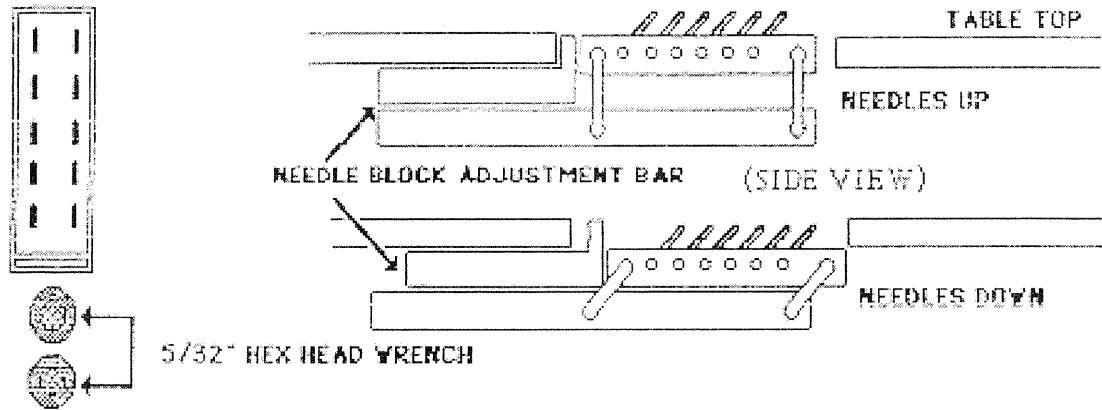
Place the product on the shuttle plate up against the gate. Bring the backstop up against the product and lock in place. Bring both product side guides in to the product. Allow approximately 1/8" play between guides and the product. Lock in place.



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

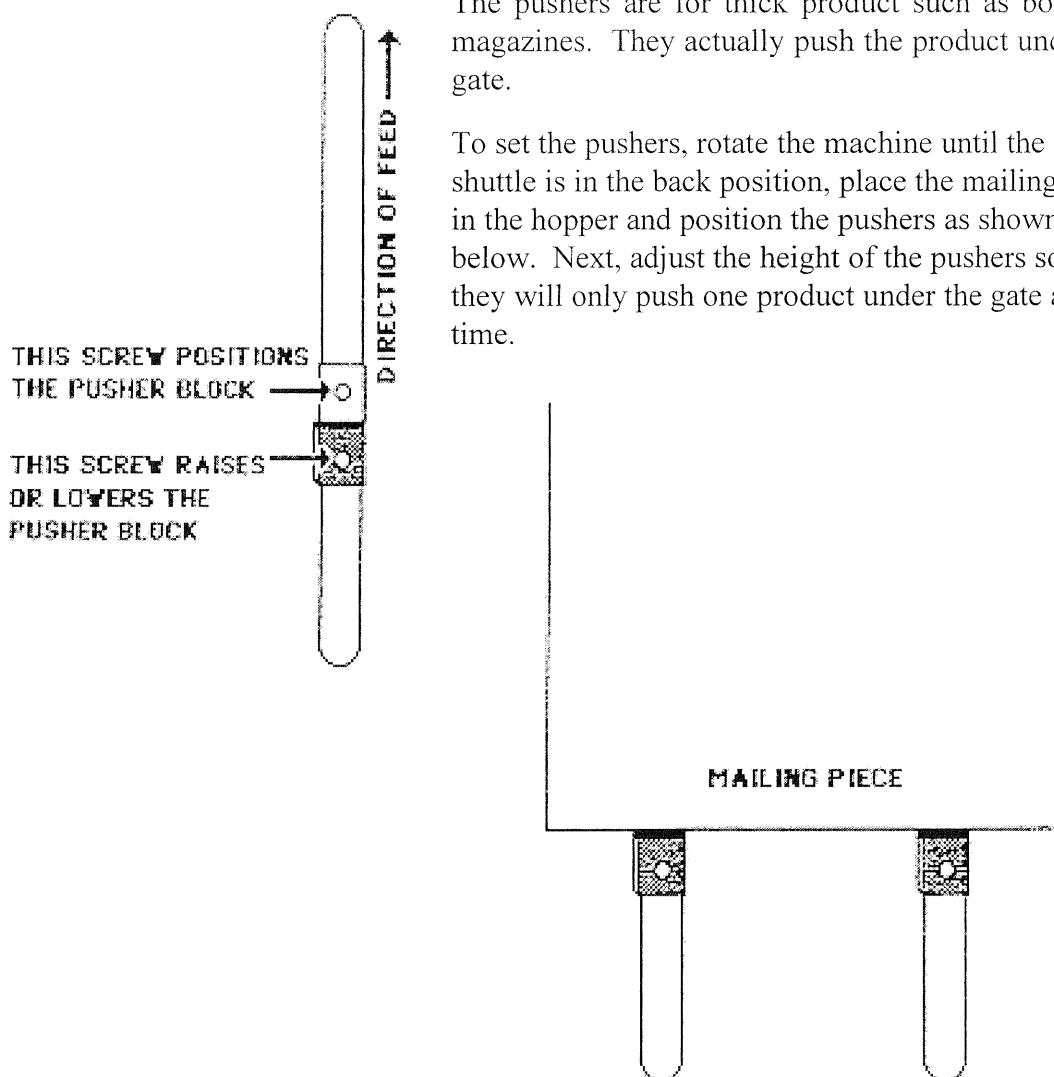
The lifters are designed to lift up the back of the product and angle the front edge toward the gate to aid in feeding. These are most commonly used for large products such as newspapers, magazines, and etc.

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



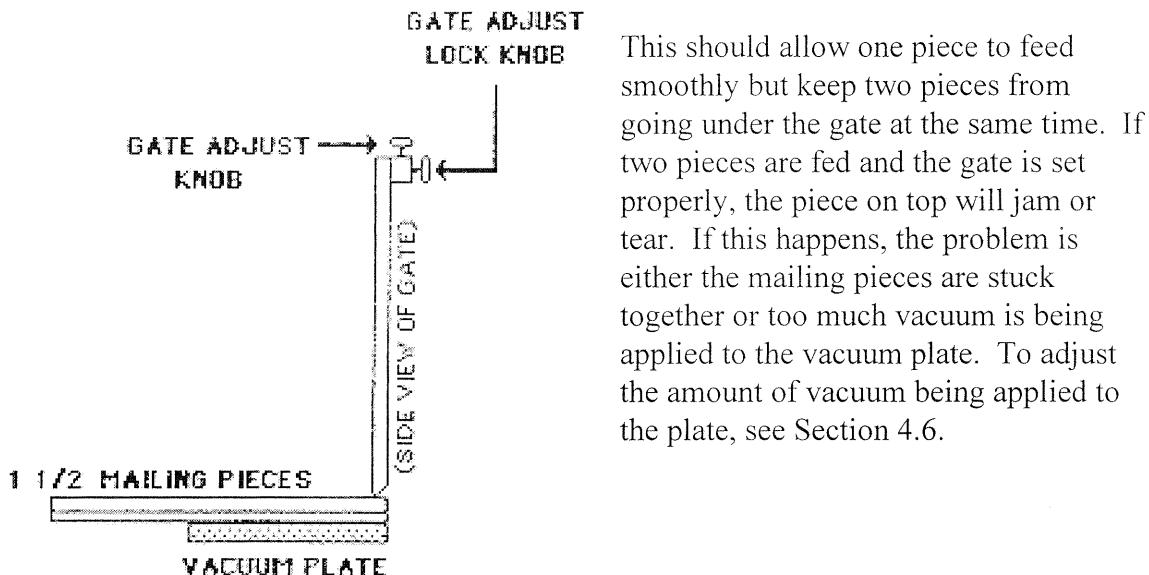
The pushers are for thick product such as books or magazines. They actually push the product under the gate.

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



4.6 GATE SET-UP

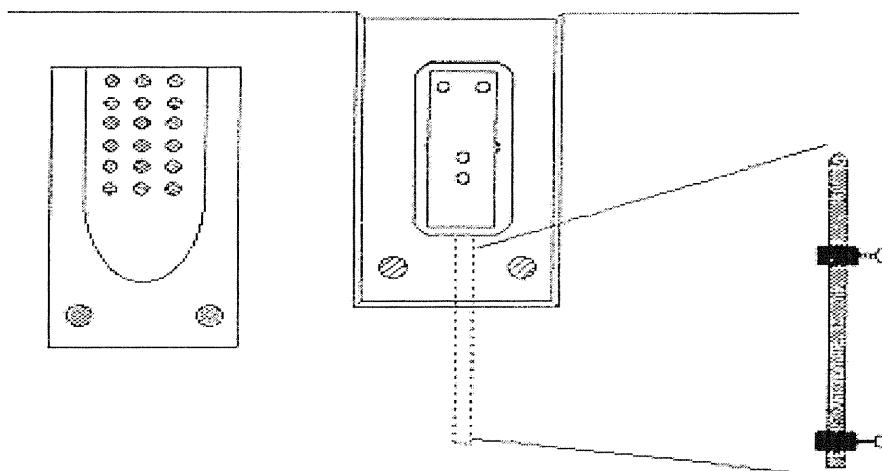
To set the gate, loosen the gate lock knob and turn gate adjusts knob counter clockwise to raise the gate. Turn the main power and the feeder vacuum pump switches on. To rotate the gate, adjust the knob clockwise until the gate is snug against the mailing piece. (When setting up on a mailing piece that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



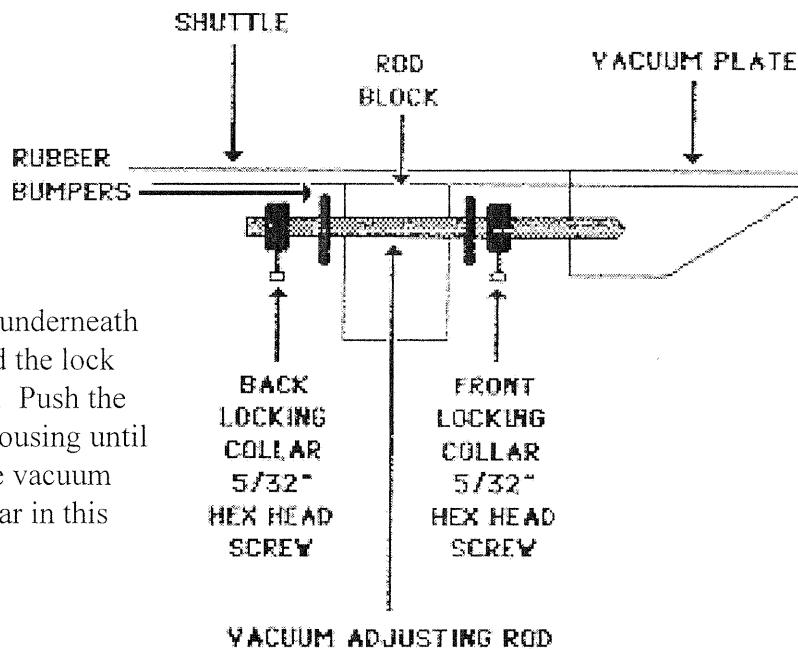
4.7 VACUUM TIMING AND TOP FEED ROLLER SET-UP

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

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

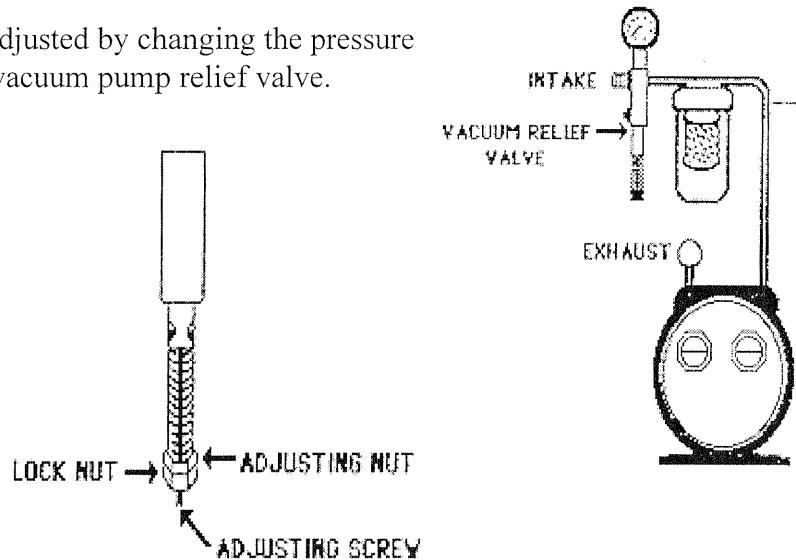


To adjust the vacuum on, turn the main power and feeder vacuum pump switches on and rotate the machine by hand until the shuttle plate is $1/8"$ from its maximum backstroke. Locate the front lock collar on the rod underneath the feeder and loosen. Hold the lock collar against the rod block. Push the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

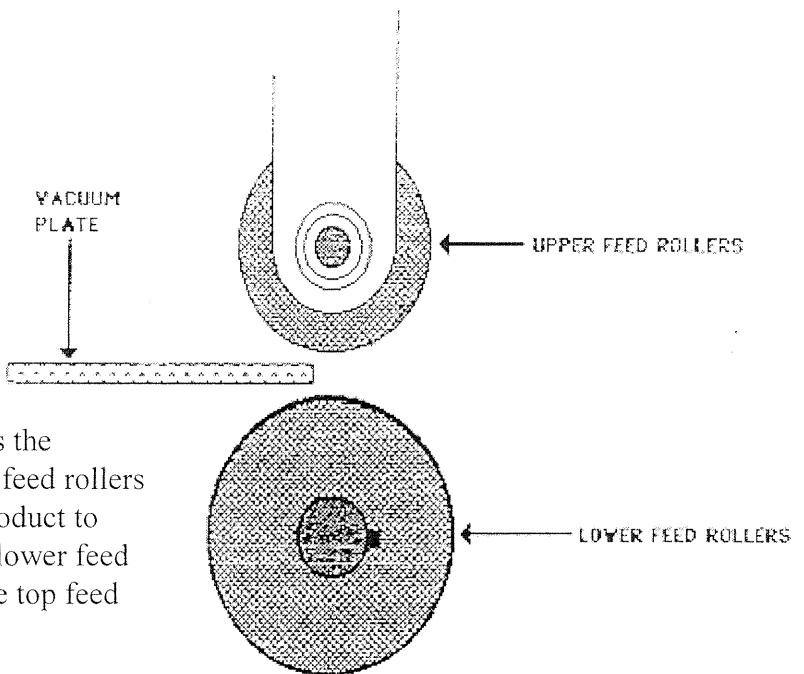


Vacuum to the plate can be adjusted by changing the pressure on the spring located on the vacuum pump relief valve.

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

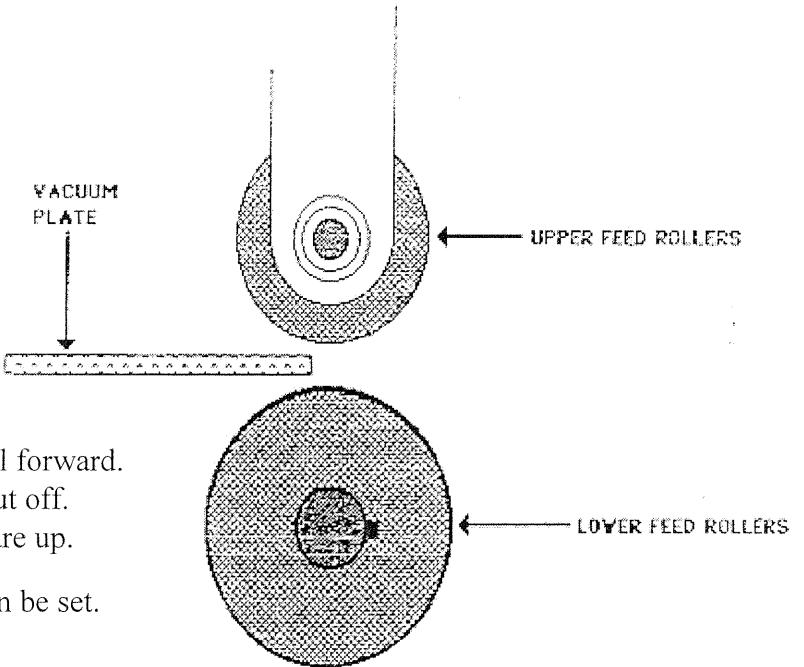


Rotate the machine with the handwheel and move the shuttle forward until the lower feed rollers come up. At this point the vacuum should go off. To adjust the vacuum off, loosen the back lock collar and hold against the rod block, pull the rod out of the vacuum plate housing until the vacuum goes off.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



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

At this position the upper feed rollers can be set.



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

Now the top feed rollers can be set.

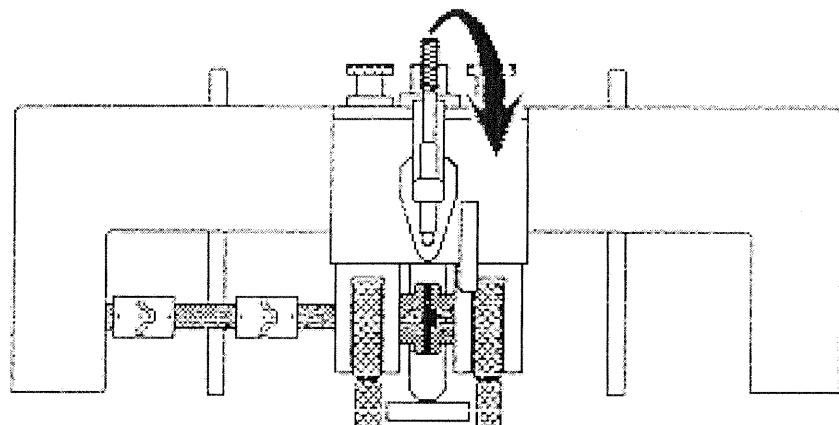
To set the top feed rollers, place a mailing piece in the shuttle feeder. Turn on the main power and feeder vacuum pump. Rotate the machine by hand until the piece is fed underneath the gate, between the top and lower feed rollers, and the lower feed rollers have come up. Adjust the top feed rollers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

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

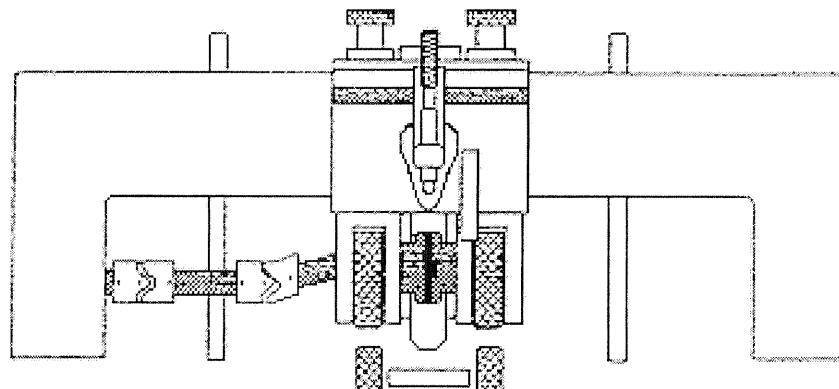
Place several pieces in the feeder and run the machine using the run or jog button. If the piece pulls to one side as it leaves the feed rollers, the top feed rollers are not set properly. Adjust until the mailing piece is fed smoothly by raising or lowering one of the top feed rollers.

4.8 JAM RELEASE

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



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



Jam release pulled down, raising gate and feed rollers.

4.9 SPACING

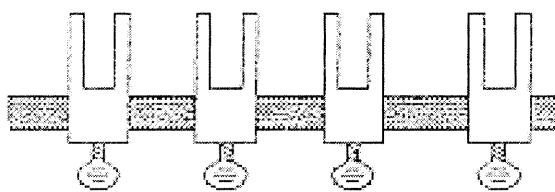
Varying the speed of both the shuttle feeder and tabletop belts controls spacing of product.

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

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

4.10 TABLETOP BELTS

The tabletop belts are designed to transport the product from the feed rollers, under the inkjet head and onto the dryer conveyor. There are seven tabletop belts on the KR215A. However, not all of them are needed for every product. You may run the belts that are not needed outside of the side guides.

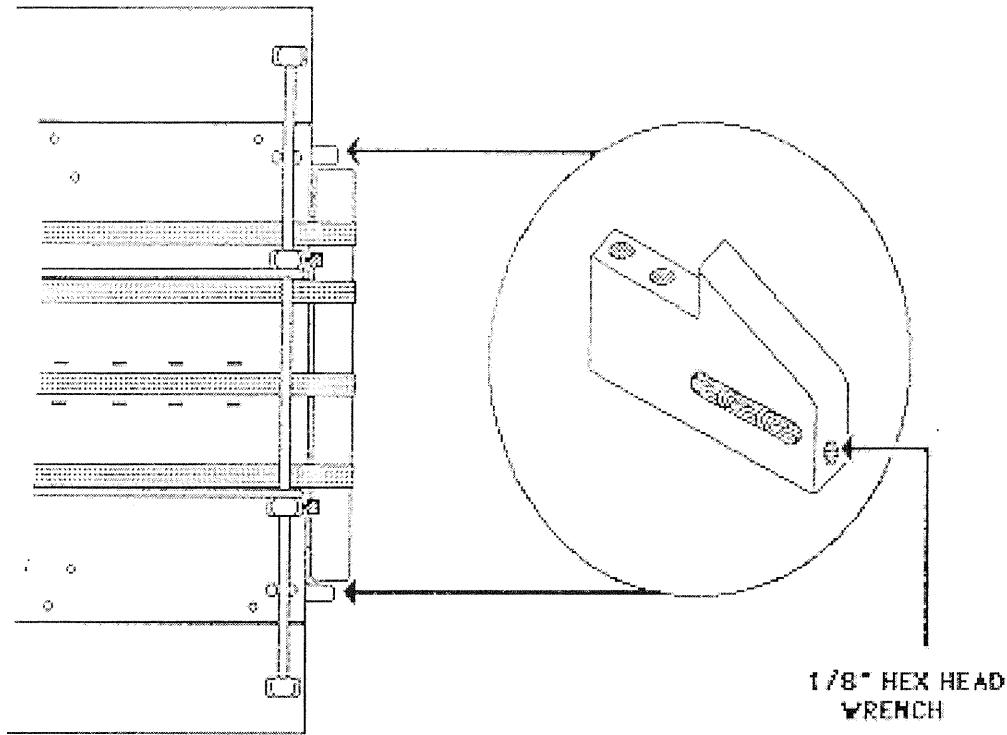


Underneath the tabletop is located guides for the tabletop belts. Each belt has its own guide. To move the belts, simply loosen the thumbscrew on the bottom of the guide and slide the guide on the shaft to the desired position and then tighten the thumbscrew.

The belts should be positioned so that there is a belt riding next to each side guide, one belt between the vacuum ports and, if used, one underneath the skid bar.

The fourth and additional belts are normally used when running large product such as newspapers or heavy product such as magazines.

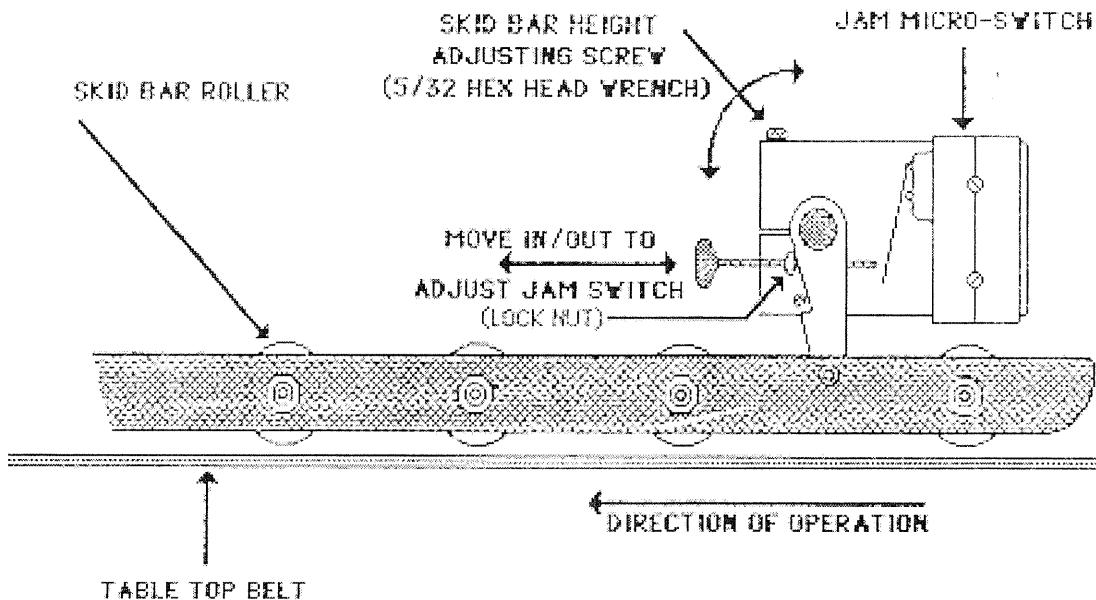
The tabletop belt tension can be adjusted. Caution should be taken not to over tighten. There should be just enough tension to prevent belt slippage.



4.11 SKID BAR

The skid bar rides on top of the product to help transport the mailing piece across the tabletop. The skid bar should be placed over one of the tabletop belts for best results. To move the skid bars locate and loosen the 1/8" hex head set screws in the lock collars on the right-hand side of the machine. The left-hand side of the machine has a lock collar and a skid bar block that is held in place with a 5/32" hex head screw. The KR215P is furnished with one skid bar, and is not needed when running small pieces such as cards or envelopes but can be installed when running large or heavy product.

Attached to one end of the skid bars is a "jam detector switch" on certain machines. This switch, when properly set, will stop the machine when a jam or double feed occurs.

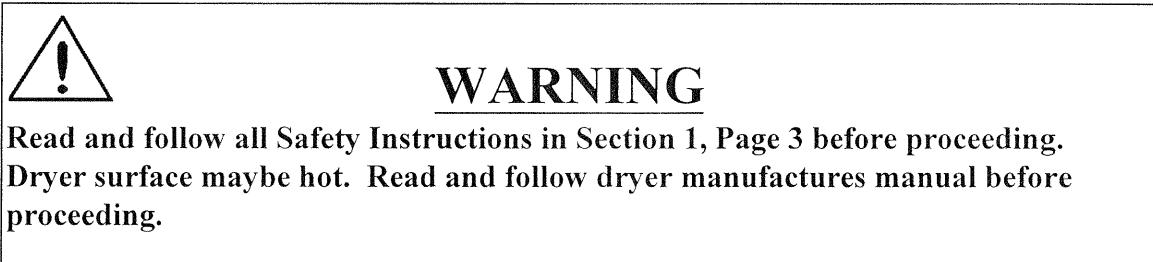


To set the skid bar, rotate the machine until a mailing piece is under the skid bar. Loosen the 5/32" hex head screw on the skid bar block. Adjust until the skid bar is resting on the mailing piece and the skid bar rollers rotate as the product is transported. Lock in place with the 5/32" hex head screw.

The jam switch is adjusted by loosening the lock nut, moving the adjustment knob in or out and tightening the lock nut. The microswitch should disengage and stop the machine when a jam or double feed occurs.

NOTE: The machine will not run if the jam switch is not set properly (see Section 4.2).

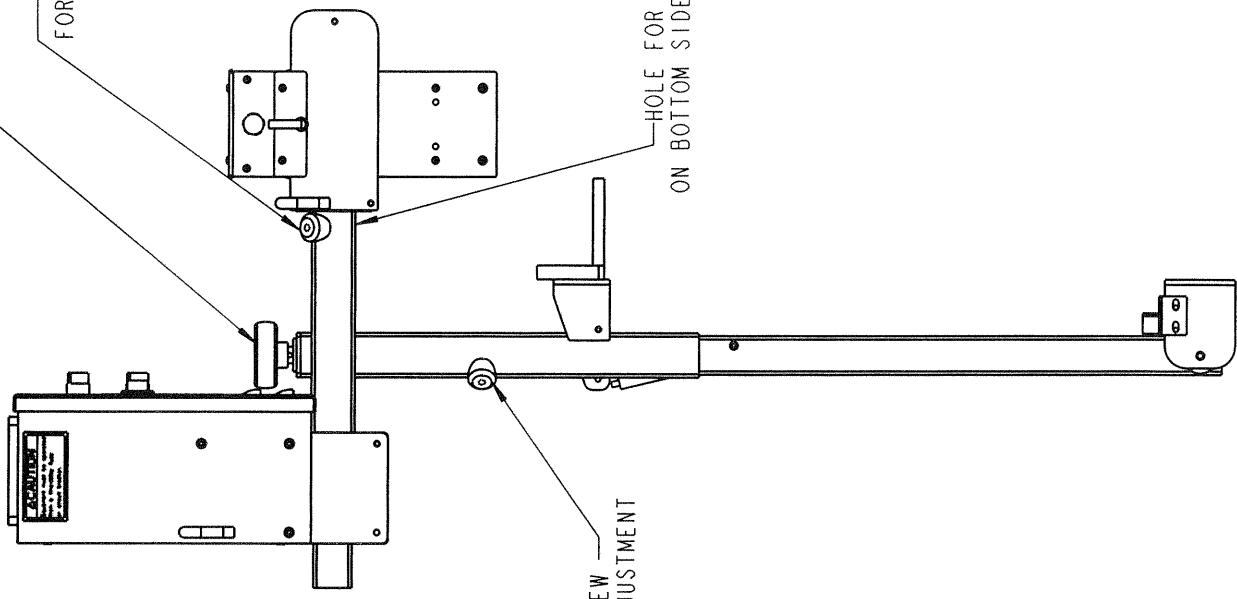
4.12 DRYER ARM SETUP & USAGE (FIG 4)



Height Adjustment: The height of the dryer can be adjusted using the wheel on the top of the dryer Arm. First loosen the clamp screw on the vertical tube of the dryer arm. Next, turn the crank clockwise to move the dryer down or counter clockwise to move the dryer up. Retighten clamp screw when dryer is at desired height.

HEIGHT ADJUSTMENT

CLAMP SCREW
FOR LEFT/RIGHT ADJUSTMENT



CLAMP SCREW
FOR HEIGHT ADJUSTMENT

HOLE FOR PAW STOP
ON BOTTOM SIDE OF THIS TUBE

DRYER ARM SET UP/USAGE
FIGURE 4.0

Left/Right Adjustment: The left/right position of the dryer can be adjusted by loosening the clamp screw on the horizontal tube, continue to hold the clamp screw handle and slide the dryer in and out. Retighten clamp screw when dryer is at desired location.

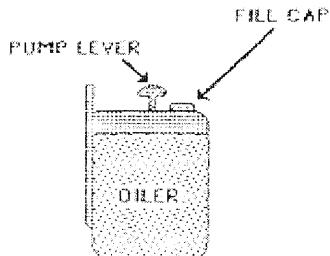
Clearing Jam Under Dryer: Use handle to push dryer arm back approximately 15 degrees. Dryer arm will remain back so jam can be cleared. **Note: On Research Dryers** (Dryer will automatically turn off in the back position.) Pull on handle to position the dryer back over the conveyor for normal operation.

Horizontal Tube Removal: The inside horizontal tube has a paw stop to prevent the dryer from being pulled out too far. The spring loaded paw will automatically stop the tube at the end of its stroke. The spring loaded paw automatically resets when the tubing is pushed in the opposite direction. To remove the horizontal tube follow these steps:

1. Remove dryer from dryer bracket.
2. Loosen horizontal clamp screw.
3. Slide tube out until the paw stops it.
4. Use allen wrench to push paw up and out of the hole located on the bottom of the larger horizontal tubing, at same time pull inside tubing out.

5 MAINTENANCE

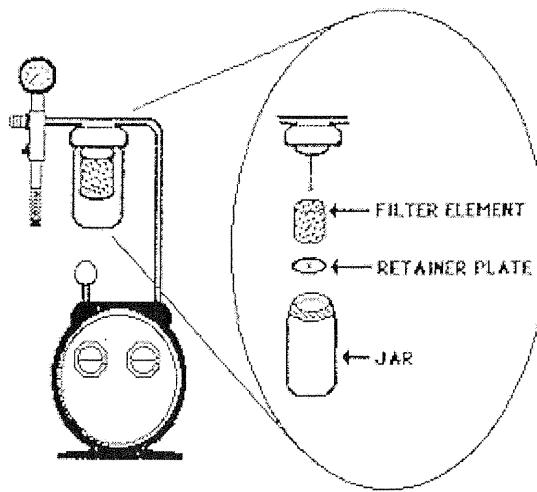
5.1 LUBRICATION



The operator should keep the KR215P clean and lubricated on a regular basis. The base has a central oiling system that only requires the operator to pull the pump lever on the oiler. This should be done every two hours of operation. The oil recommended is a 20 weight SAE machine oil.

5.2 DAILY MAINTENANCE

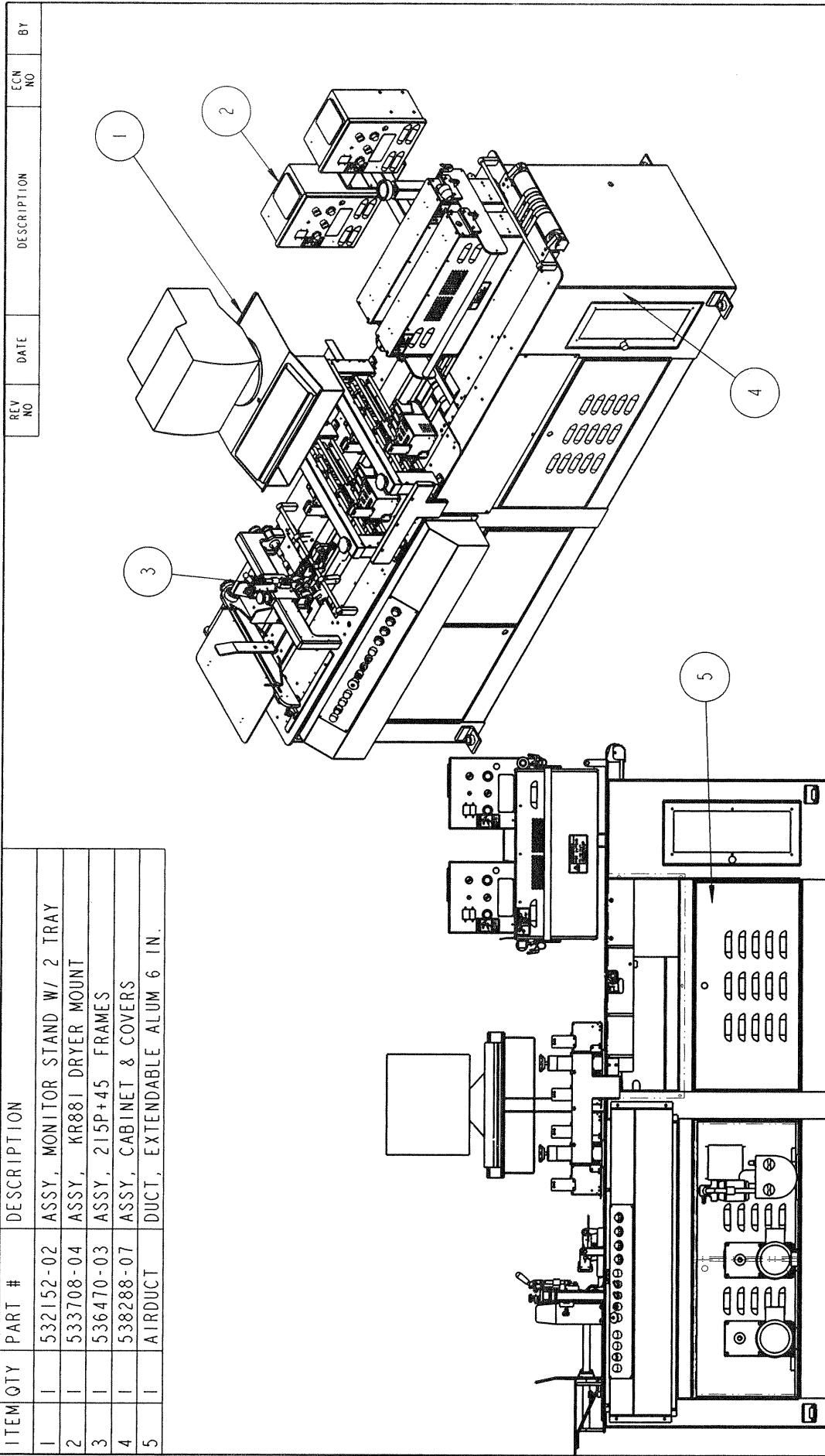
Item	Function	Remarks
Upper & Lower Feed	Remove glazing and all other foreign materials from feed	Use alcohol.
Base (General)	Remove excessive paper dust, ink, glue, and all other foreign materials from the tabletop and inside of base.	Use clean soft rag. (Dampen with water if necessary.)
Vacuum Pump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



6 DIAGRAMS AND PARTS LIST

This section contains the entire mechanical bill of materials and assembly drawings.

ITEM QTY	PART #	DESCRIPTION
1	1	532152-02 ASSY, MONITOR STAND W/ 2 TRAY
2	1	533708-04 ASSY, KR881 DRYER MOUNT
3	1	536470-03 ASSY, 215P+45 FRAMES
4	1	538288-07 ASSY, CABINET & COVERS
5	1	AIRDUCT DUCT, EXTENDABLE ALUM 6 IN.



DRAWN BY:	SCALE	0 . 050	MATERIAL:	XXX	THIRD ANGLE PROJECTION	KIRK - RUDY, INC.
CHECKED BY:	DATE	17-0c + 0	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	.xx .xxx .005 .005 .5	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	KENNESAW, GEORGIA
TRACED BY:	MASTER		MATERIAL:	XXX	MODEL:	ASSY , KR215P
			FINISH:	XXX	SP 94000	
			REMOVED ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED		SHEET NO.	10F2
			ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY		DRAWING I	215P
					X	XXX
					RED O	WHERE USED

REV NO	DATE	DESCRIPTION	ECN NO
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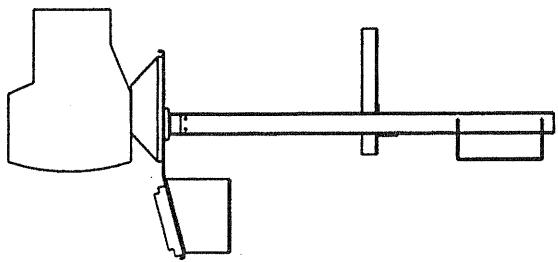
X XXX
REQ'D WHERE USED

DRAWN BY: T JG	SCALE: 0 . 050	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	
CHECKED BY:	DATE: 17 - 0 C + - 0	.XX	.XXX
TRACED BY:	MASTER	.01	.005 ANG.
		.5	HEAT TREAT:
REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED			
ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY			

PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE QUOTED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY INC. KENNESAW, GA 30046 USA	THIRD ANGLE PROJECTION
TITLE: ASSY, KR215P	
SHEET NO. 20F2	
DRAWING #	

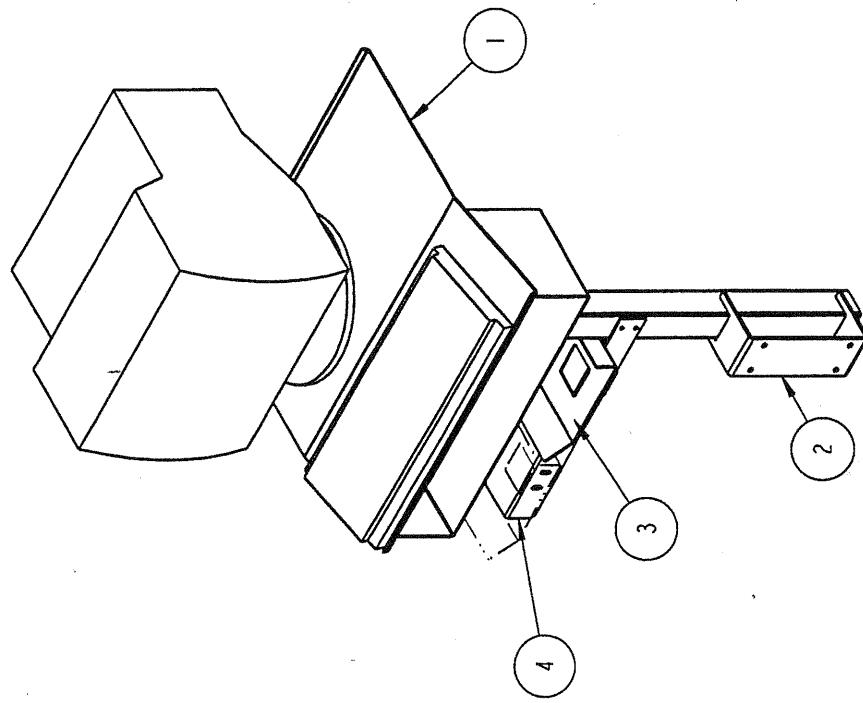
X XXX
REQ'D WHERE USED

ITEM	QTY	PART #	DESCRIPTION
1	1	532155-02	ASSY, MONITOR PIVOT
2	1	536586-01	WLDMT, MONITOR STAND
3	2	536932-01	SHELF, INKCARTRIDGE HP
4	1	538095-01	BRACKET, INK TRAY MTG SHORT



SCALE 0.060

REV NO	DATE	DESCRIPTION	ECN NO	BY
1	25-JUL-00	ADDED 536932-01 & 538095-01	6560	ATB



NOTES:
1. OPTIONAL FOUR (4) TRAY SYSTEM AVAILABLE.

DRAWN BY:	T JG	SCALE	0 . 100	MATERIAL:	NOTED	THIRD ANGLE PROJECTION	PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE OUTLINED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC. KENNESAW, GA 30144 USA
CHECKED BY:		DATE	27 - AUG - 99	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED		HEAT TREAT:	KIRK - RUDY, INC., KENNESEE SAW, GEORGIA
TRACED BY:	MASTER	ANG.	.01 .05 .5		NONE	SP 76500	ASSY, MONITOR STAND W/ 2 TRAY
		FINISH:				SHEET NO. 1 OF 1	DRAWING # 532152-02

ITEM QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
			1	9/3/2000	CHANGED STUD TO 500#83-7 ADDED INTERNAL SNAP RING	6577	TJG
1	100800	ASSY, UNIVERSAL JOINT	1				
2	102302	SHIM, .500X.750X.062					
3	103108	BEARING, FLAT .500					
4	104106	SNAPRING .500					
5	104205	SNAPRING, INTERNAL .125 BORE					
6	109386	PULLEY, TIMING 15L050 .1.125B NK					
7	109410	PULLEY, TIMING 14L050 .500B .125K					
8	500803	SHAFT-UNIVERSAL JOINT					
9	100800-1	ASSY, UNIVERSAL JOINT					
10	2	500814-1A ASSY, SIDE GUIDE RAIL					
11	1	500983-7 STUD, IDLER SPROCKET					
12	1	531582-01 EG ASSY, BRIDGE DRIVE AND GATE					
13	1	535412-01 ASSY, SIDE GUIDE					
14	1	537550-01 ASSY, BRIDGE					
15	1	HJNO14					
16	1	SP43307 SHAFT, UPPER FEED ROLLER					
17	1	WHS013 LOCK WASHER					

SEE DETAIL A

DETAIL A
SCALE 0.750

DRAWN BY:
A KEY

SCALE 0.250

DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED

.XX	.XXX	AMG.
.01	.005	.5

HEAT TREAT:

REMOVE ALL BURS AND SHARP EDGES UNLESS OTHERWISE NOTED

ALL DIMENSIONS ARE FINISHED DIMENSIONS

DO NOT SCALE - WORK TO DIMENSIONS ONLY

CHECKED BY:

TRACED BY:

MASTER M

RECD'D WHERE USED

I 215

KIRK - RUDY, INC.
KENNEBUNK, GEORGIA

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EXPRESS WRITTEN PERMISSION
OF KIRK-RUDY, INC.
KENNEBUNK, GA 30144 USA

MODEL: 215

SHEET NO. 1 OF 1

ASSY, BRIDGE TIMING BELT

DRAWING #

537549-01

ITEM QTY	PART #	DESCRIPTION
1	2	100338 BUSHING, FLI. 0001DI. 2500DI. 500LG
2	1	532128-02 TRAY, KEYBOARD
3	1	532154-01 HOUSING, PIVOT
4	1	532157-01 SPACER, PIVOT
5	1	532467-01 SHAFT, DRYER PIVOT
6	1	538343-01 TRAY, MOUSE PAD

REV NO	DATE	DESCRIPTION	ECN NO	BY

SCALE 0.125

DRAWN BY: T JG SCALE: 0 . 312 DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED

.01	.005	.5	NOTED
.xx	.xxx	ANG.	

HEAT TREAT: XXX

NOTED

REMOVED ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED

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

CHECKED BY: DATE: 26 - Aug - 99

FINISH:

MASTER: M

NOTED

SP76500

SHEET NO: 1 OF 1

ASSY, MONITOR PIVOT

DRAWING 9

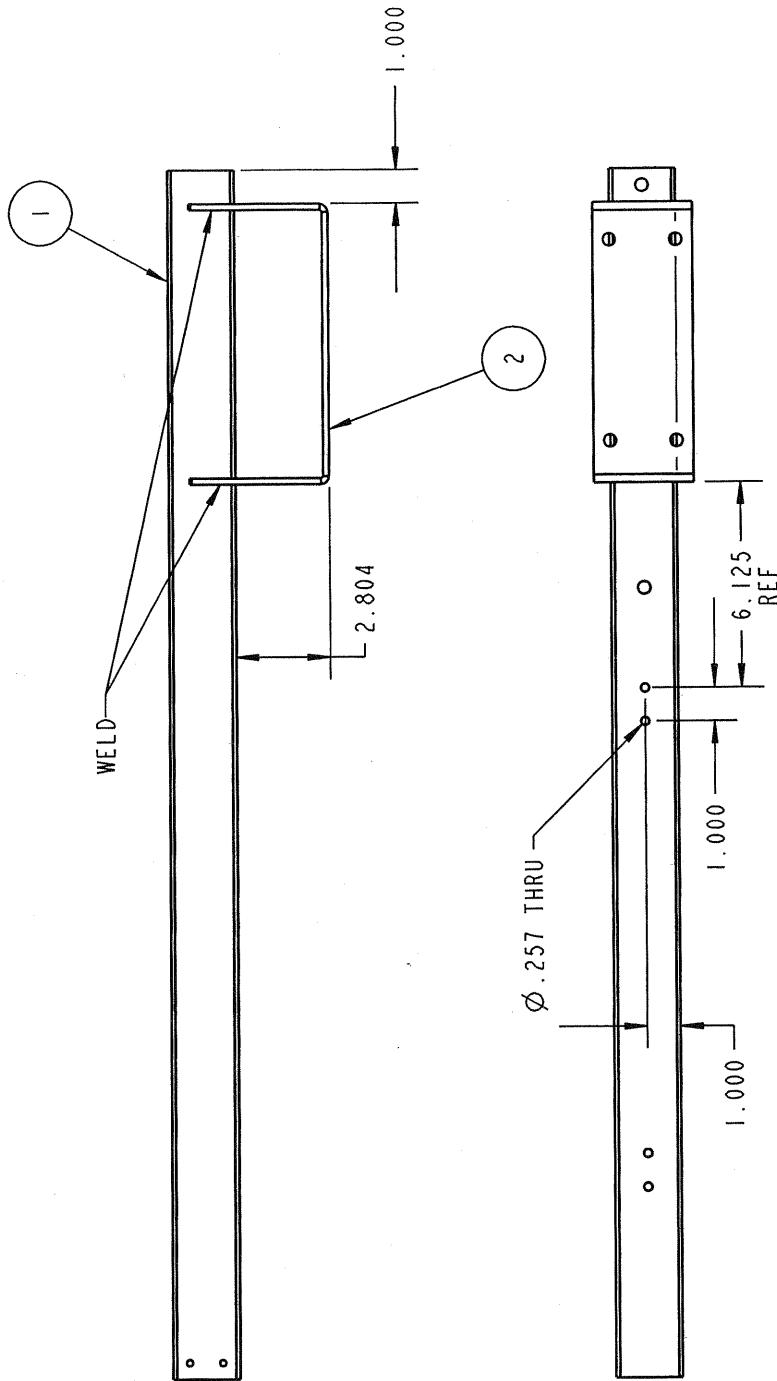
532155-02

1	532152-02
REQ'D	WHERE USED

KIRK - RUDY, INC.
KENNESAW, GEORGIA

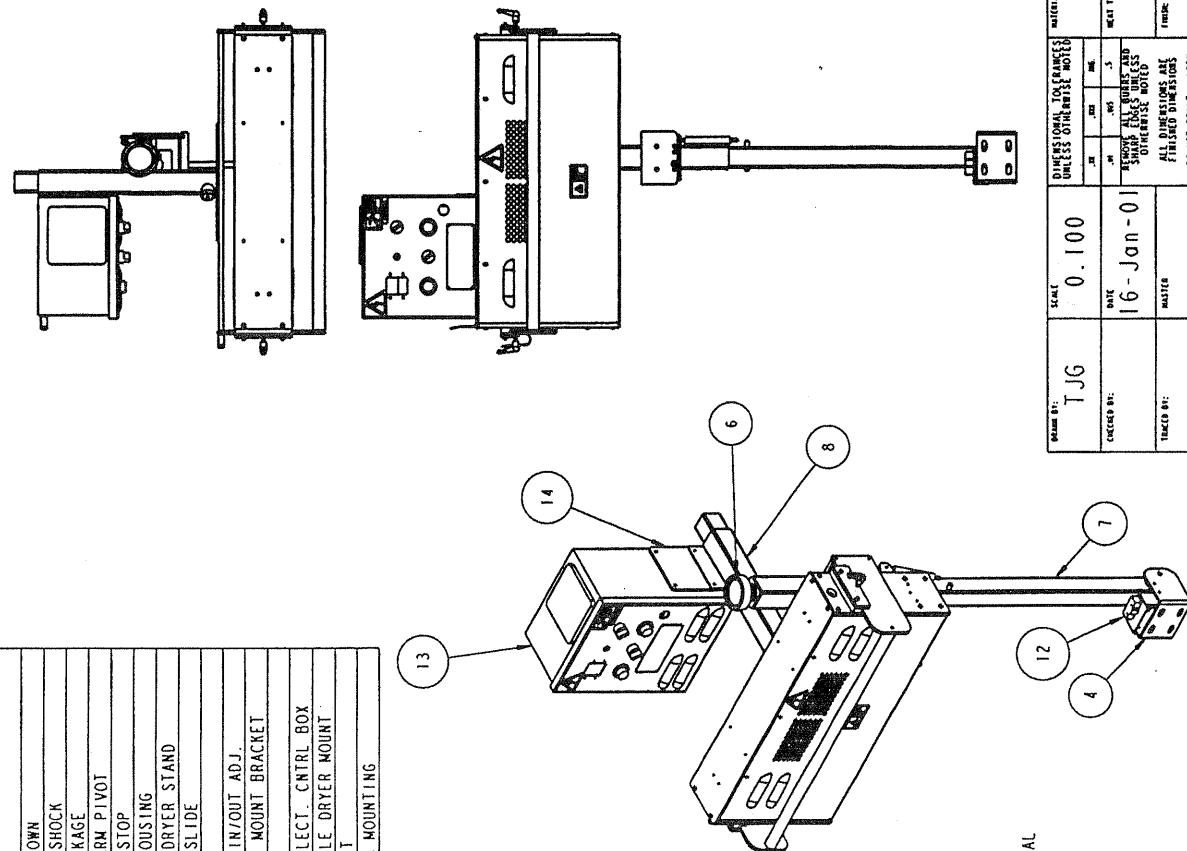
PROPRIETARY AND CONFIDENTIAL
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EXPRESS WRITTEN PERMISSION
OF KIRK-RUDY, INC.
KENNESAW, GA 30144 USA

ITEM	QTY	PART #	DESCRIPTION	REV NO	DATE	ECN NO	BY
1	1	532153-01	TUBING, VERTICAL				
2	1	532164-01	BRACKET, INTERFACE				



X	XXX
REQ'D	WHERE USED
 KIRK - RUDY, INC. KENNESAW, GEORGIA	
<small>PROPRIETARY AND CONFIDENTIAL NO PART OF THIS DRAWING MAY BE COPIED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC. KENNESAW, GA 30144 USA</small>	
REF:	
TITLE: WLDMT, MONITOR STAND	
DRAWING #: 536586-01	
SCALE: 0.188	
DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	
.XX	.XXX
.01	.065
.5	.5
MATERIAL: NOTED	
HEAT TREAT: NONE	
FINISH: NOTED	
NOTES: REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY	
DRAWN BY: T JG	DATE: 27 - Aug - 99
CHECKED BY:	
TRACED BY: MASTER	
SHEET NO: 10F1	

ITEM QTY	PART #	DESCRIPTION
1	532159-01	BLOCK, LOCK DOWN
2	532452-01	BRACKET, GAS SHOCK
3	532453-01	GAS SHOCK LINKAGE
4	532456-01	ASSY, DRYER ARM PIVOT
5	532458-01	SHAFT, DRYER STOP
6	532735-01	ASSY, SCREW HOUSING
7	532738-01	WELD. TUBING DRYER STAND
8	532739-02	WELD. TUBING SLIDE
9	532741-01	TUBING, BASE
10	532744-02	WELD. TUBING IN/OUT ADJ.
11	533190-01	ASSY, STOPPER MOUNT BRACKET
12	533714-01	ASSY, SWITCH
13	538722-01	ASSY, DRYER ELECT. CTL BOX
14	538734-01	BRACKET, SINGLE DRYER MOUNT
15	538791-01	CLAMP, CONDUIT
16	538792-01	ASSY, DRYER & MOUNTING



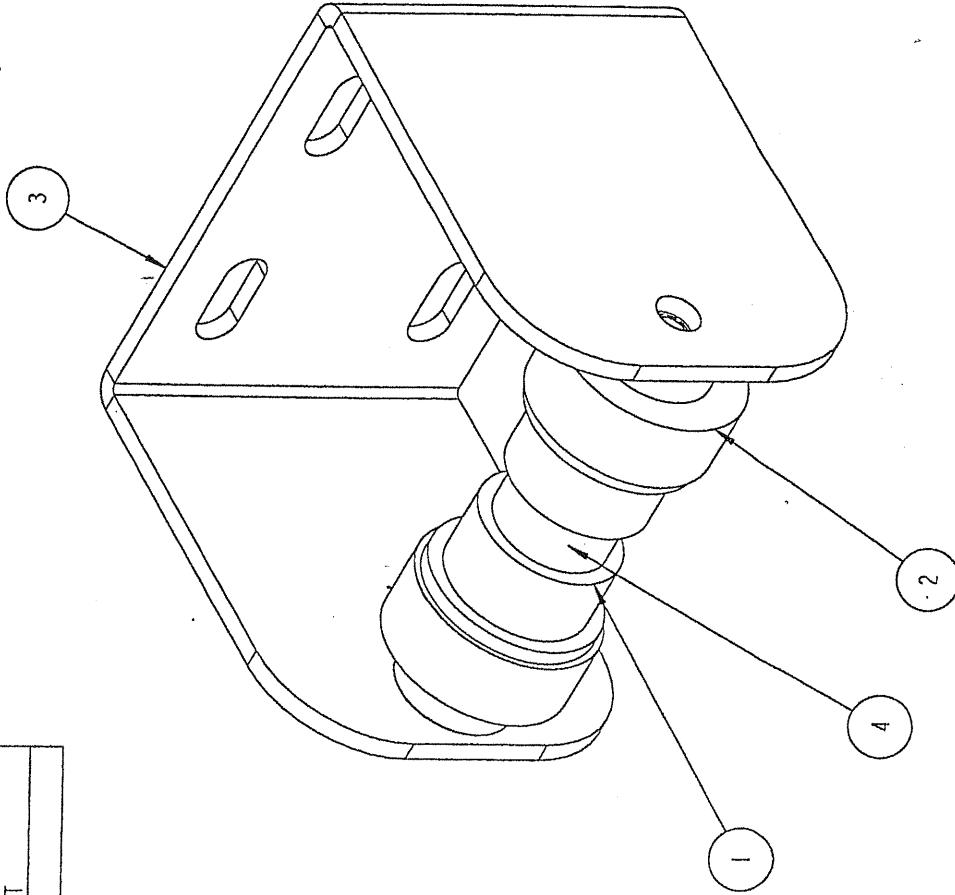
NOTE:
 1. DRYER ARM IS OPTIONAL
 2. SINGLE DRYER SHOWN

ITEM	REV NO	DATE	DESCRIPTION	CCW NO OR
1	2158			
2				RECD WHERE USED
3				
4				
5				
6				
7				
8				
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16				

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SUE FOR INFRINGEMENT.

ITEM:	SP88100	DATE:	16-Jan-01	SCALE:	T JG	NOTES:	NOTED
ITEM:		DATE:		SCALE:		NOTES:	NOTED
ITEM:		DATE:		SCALE:		NOTES:	NOTED

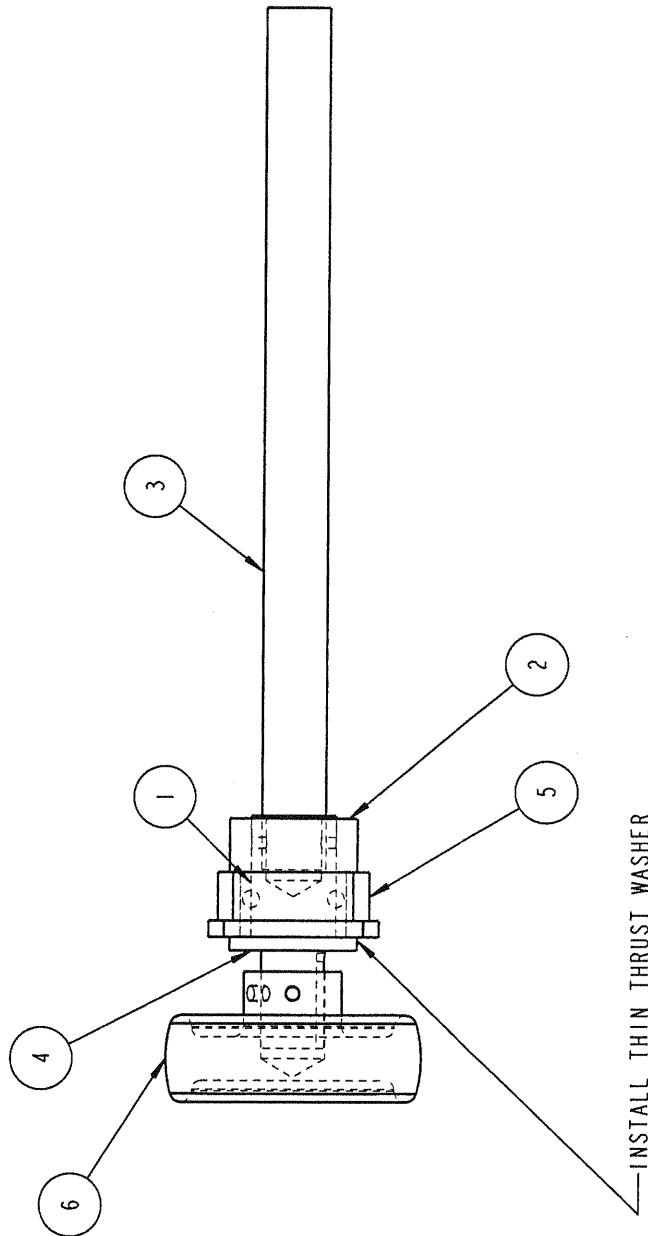
ITEM QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	2	100326 BUSHING, FLANGE 1.000					
2	2	102212 COLLAR 1.000					
3	1	532465-01 BRACKET, DRYER ARM PIVOT					
4	1	532467-01 SHAFT, DRYER PIVOT					



1	532734-01 REV'D WHERE USED
<p>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</p> <p>KR KIRK - RUDY, INC. KENNESAW, GEORGIA</p>	
Title: ASSY, DRYER ARM PIVOT	
SHEET NO.: 10F1	DRAWING #
<p>DRAWN BY: T JG SCALE: 0 . 750 DATE: 20 - Feb - 98</p> <p>CHECKED BY: TRACED BY: MASTER</p> <p>NOTED MATERIAL: REMOVE ALL BURRS AND SHARP EDGES AND OTHERWISE NOTED</p> <p>HEAT TREAT: NONE</p> <p>FINISH: NONE</p> <p>ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY</p>	
SPEC: 62500	

ITEM	QTY	PART #	DESCRIPTION
1	1	100257	BUSHING, SL 1.000 IDI .25000D .750 LG
2	1	102217	COLLAR 1.000
3	1	503734	THREADED ROD, 3/4-10
4	1	503736	HUB
5	1	532737-01	BLOCK, ROD MOUNT
6	1	533006-01	HANDWHEEL, W/ KR LOGO

REV NO	DATE	DESCRIPTION	ECN NO	BY
1	10-JUN-98	REPLACED 532737-01 WITH 503734	6349	NY
2	10-JAN-02	REPLACED 100326 WITH 100257	6780	RSH

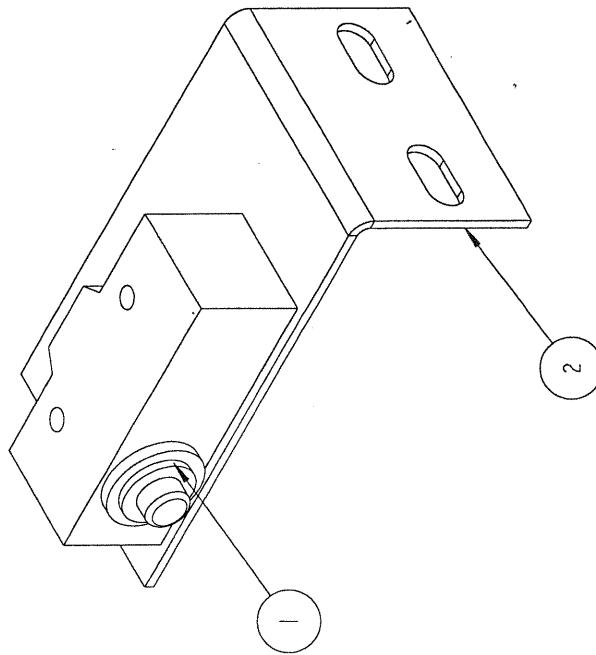


DRAWN BY: T JG	SCALE 0 . 500	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	MATERIAL: NOTED	THIRD ANGLE PROJECTION Elevation View	PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE QUOTED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY INC. KENNESAW, GA 30044 USA
CHECKED BY:	DATE 20 - Feb - 98	.01 .005 .5	HEAT TREAT: NONE	MODEL: SP 62500	TIME: ASSY, SCREW HOUSING
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: NOTED	SHEET NO. OF 1	DRAWING # 532736 - 01
I 532734-01 REQ'D WHERE USED					

ITEM QTY	PART #	DESCRIPTION
1	201049-2	MICRO SWITCH
2	533713-01	BRACKET, SENSOR

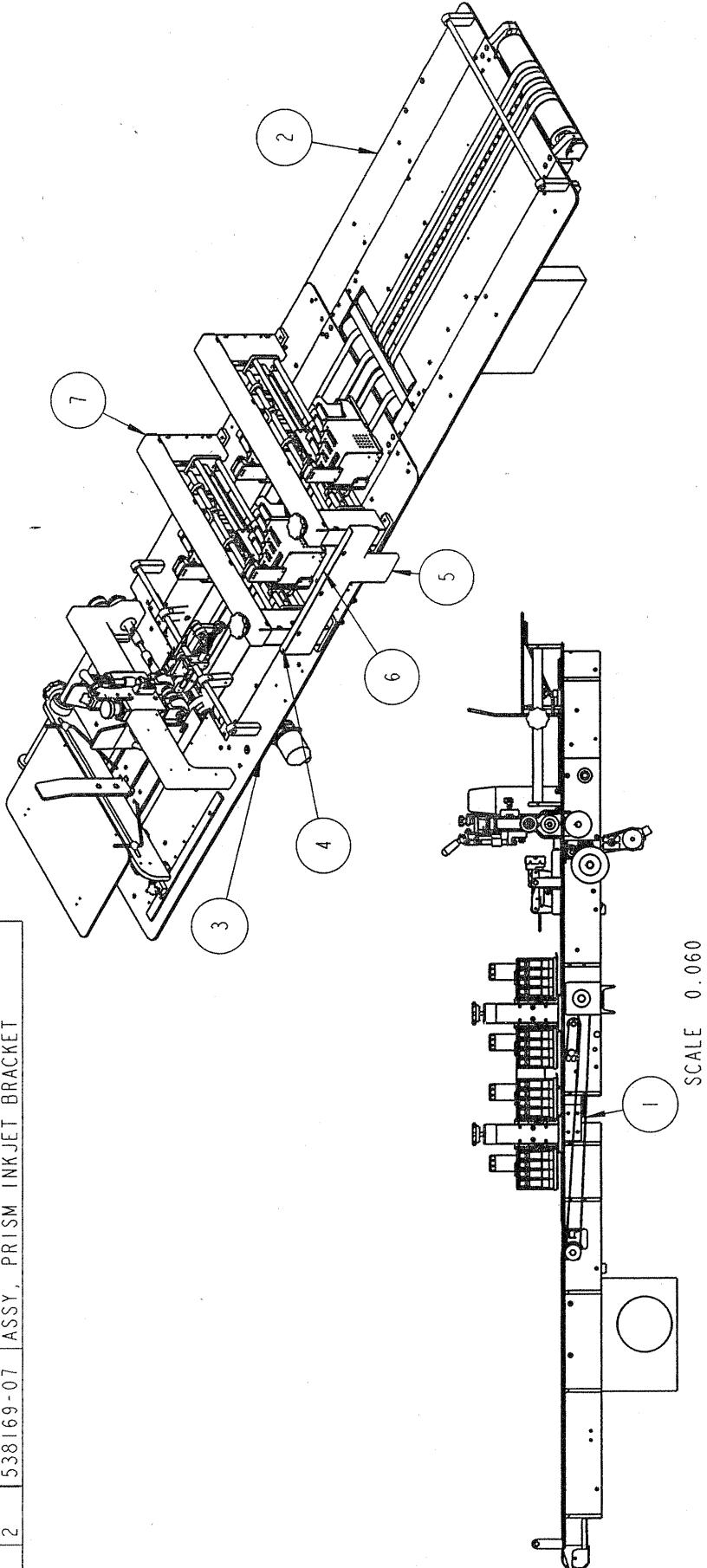
REV NO	DATE	DESCRIPTION	ECN NO	BY
1	9/10/98	NEW MICROSWITCH	6370	RHM

1	533708-01
REQ'D	WHERE USED



DRAWN BY: T JG	SCALE 1.000	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED			NOTE D	THIRD ANGLE PROJECTION	PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE QUOTED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC. KENNESAW, GA, 30144 USA		
DATE 4 - May - 98	.XX	.XXX	ANG.	.01			.005	.5	HEAT TREAT:
CHECKED BY: MASTER	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED			NONE			FINISH:	SHEET NO.: 10F1	DRAWING #: 533714-01
TRACED BY: W	ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE, WORK TO DIMENSIONS ONLY			NOTED					

ITEM QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	1	108922-2 BELT, TIMING 600L075					
2	1	536479-03 ASSY, 45 IN. FRAME EXT					
3	1	536491-03 ASSY, FEEDER & FRAMES					
4	1	536497-04 BAR, CABLE COVER					
5	1	536504-06 COVER, CABLE FRONT					
6	1	536535-06 COVER, CABLE REAR					
7	2	538169-07 ASSY, PRISM INKJET BRACKET					



1	21SP
REQ'D	WHERE USED
<p align="center">KR KIRK - RUDY, INC. KENNESAW, GEORGIA</p>	
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IN ANY FORM WITHOUT THE	
EXPRESS WRITTEN PERMISSION	
OF KIRK-RUDY INC.	
KENNESAW, GA 30144 USA	
THIRD ANGLE PROJECTION	
MATERIAL:	N/A
DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	
xx	xxx
.01	.005
ANG.	S
HEAT TREAT:	N/A
DATE	SP 94000
17-0C+0	TITLE: ASSY, 215P + 45 FRAMES
CHECKED BY:	SHEET NO.: 1 OF 2
TRACED BY:	DRAWING #:
MASTER	536470-03
REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED	
ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY	

ITEM #	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	8	103419 DOWEL, PIN .188X1.000	1	12/13/2002	REPLACE 532469-05 WITH 532468-06	6908	.06
2	1	108809 PULLEY, TIMING 12L075 .625B .188X					
3	8	500721 GUSSET - TABLETOP SUPPORT					
4	1	500787 SHAFT SIDE GUIDE ADJ.					
5	2	500791 POST SIDEGUIDE					
6	1	500824 SHAFT-BELT GUIDE					
7	4	106472-3 BELT, HIGH HEAT 3/4 X 72					
8	2	500721-1 GUSSET CUTOUT					
9	2	500725-13 GUIDE, BELT 3/4					
10	1	500725-17 GUIDE, BELT					
11	1	530619-01 ASSY, IDLER ROLLER					
12	1	532449-06 WLDNT, BOX VACUUM 215B					
13	1	532712-01 ASSY, OUTED SAFETY COVER					
14	1	536467-01 ASSY, DRIVE ROLLER DRYER					
15	1	536473-01 TRAY VACUUM					
16	1	536474-02 PLATE, TT DRYER					
17	2	538282-01 BAR, BOX MOUNT					
18	1	538286-05 FRAME, 45 IN. EXTENSION RH					
19	1	538286-06 FRAME, 45 IN. EXTENSION LH					
20	1	538287-01 PLATE, TABLETOP INSERT RH					
21	1	538287-02 PLATE, TABLETOP INSERT LH					
22	1	538870-01 TABLETOP, SIDE 9 IN RH					
23	1	538870-02 TABLETOP, SIDE 9 IN LH					
24	2	SP18606 PLATE, SCAB					
25	1	SP26803-5L TABLETOP, LH 36 IN					
26	1	SP26803-5R TABLETOP, RH 36 IN					
SCALE 0.125							
DRAWING #: T JG SCALE 0 .150 DIMENSIONAL TOLERANCES UNLESS OTHERWISE SPECIFIED							
CIRCLE #: DATE .17-0c + - 01 MATERIAL: XXX							
CIRCLE #: .5 MAX THICK: XXX							
ALL SHARP EDGES UNLESS OTHERWISE NOTED							
ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NO SCALE WORK TO DIMENSIONS ONLY							
SHEET #: 1 OF 1 DRAWING #: ASSY, 45 IN. FRAME EXT							
SCALE: 536479-03							

1	536479-03
RED 0	WHERE USED
KIRK - RUDY, INC. KENNESEE, GEORGIA	
SP 94000	
LINE:	
SHEET #: 1 OF 1	

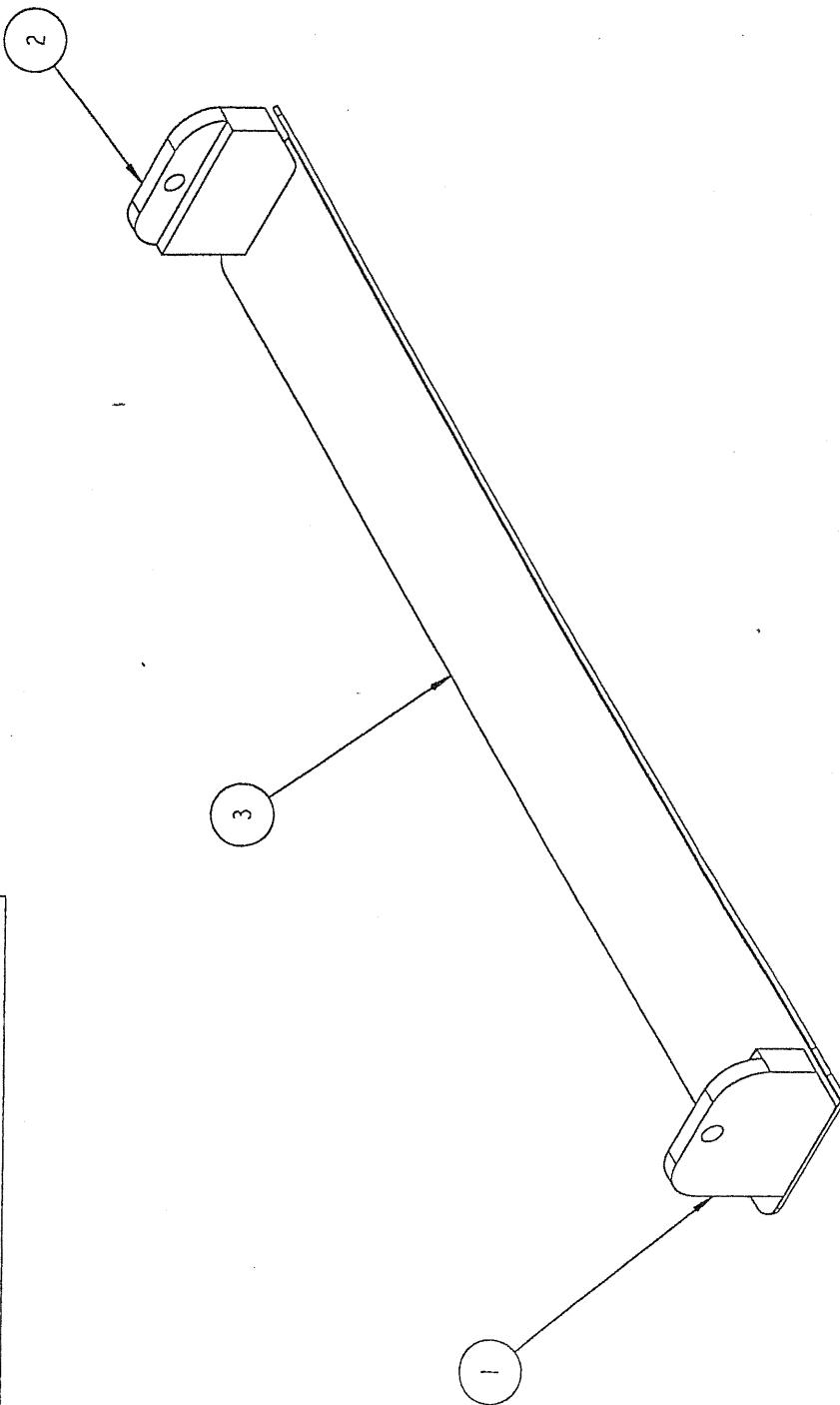
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OR REPRODUCED OR USED FOR ANY PURPOSE
EXCEPT AS AUTHORIZED IN THE CONTRACT
EXPRESSION LINE, KIRK & RUDY, INC.,
KENNESEE, GEORGIA USA

ITEM QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	2	103804 BEARING, HUB .625					
2	2	500716 BRACKET - BELT TAKE-UP					
3	1	500823 SHAFT, IDLER ROLLER					
4	1	500835 ROLLER, BELT IDLER					
5	2	500836 HUB-BELT ROLLER					

I SPR71700
REC'D WHERE USED

DRAWN BY: A KEY	SCALE: 0 .410	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED			MATERIAL: N/A	THREADED ANGLE PROJECTION	PROPRIETARY AND CONFIDENTIAL NO PART OF THIS DRAWING MAY BE COPIED OR REPRODUCED IN WHOLE OR IN PART EXCEPT WRITTEN PERMISSION OF KIRK-RUDY INC. KENNESAW, GA. 30144 USA
ENCLDED BY:	DATE: 01 - Mar - 99	.01	.005	.5	HEAT TREAT:		KIRK - RUDY, INC.
TRACED BY:	MASTER	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED			FINISH:		KENNESAW, GEORGIA
		ALL DIMENSIONS ARE FURNISHED DIMENSIONS DO NOT SCALE WORK TO DIMENSIONS ONLY			SHEET NO: 0F1	DRAFTING #	ASSY, IDLER ROLLER
							530619-01

ITEM	QTY	PART #	DESCRIPTION
1	1	530816-01	BRKT, RH OUTFD RLLR GRD
2	1	530817-01	BRKT, LH OUTFD ROLLR GRD
3	1	530818-01	GUARD, OUTFEED ROLLER



1	532018-01								
REV'D WHERE USED									
 KIRK - RUDY, INC.  KENNESAW, GEORGIA KENNESAW, GA 30144 USA									
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.									
DRAWN BY: T JG	SCALE: 0 .500								
DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED									
<table border="1"> <tr> <td>DATE:</td> <td>.xx</td> <td>.xx</td> <td>ANG.</td> </tr> <tr> <td>6 - Feb - 98</td> <td>.01</td> <td>.05</td> <td>.5</td> </tr> </table>		DATE:	.xx	.xx	ANG.	6 - Feb - 98	.01	.05	.5
DATE:	.xx	.xx	ANG.						
6 - Feb - 98	.01	.05	.5						
NOTED									
HEAT TREAT:									
NONE									
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								
MASTER:	NOTED								
SHEET NO:	10F1								
TITLE: ASSY, OUTFD SAFETY COVER									
DRAWING #:									
532712-01									

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

1 536461-01
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

3 536461-01
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

4 536461-01
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

5 536461-01
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

6 536461-01
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

ITEM QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	2	102225 COLLAR .250					
2	1	103500 BEARING - ROD END					
3	1	109523 JUNCTION, 2-WAY					
4	1	109524 JUNCTION, 3-WAY					
5	1	500735 ROD - PUSH					
6	2	500737 WASHER - BUMPER					
7	2	500741 SHAFT - FEEDER					
8	1	500749 ROD - FEEDER SLIDE					
9	1	500708A ASSY, VACUUM BODY					
10	1	500710-1 BRACKET - FEEDER SUPPORT					
11	1	500728A ASSY, BUSHING BLOCK					
12	1	500751A ASSY, BEARING BLOCK					
13	1	530253-01 RING					
14	1	RHB082 HEX HEAD BOLT					
15	2	RHN012 HEX NUT					
16	1	WA013 WASHER					

SCALE 0.180

DRAWN BY: TVK CHECKED BY: TRACED BY:

SCALE 0.250 DATE 05-May-98 FINISH: N/A

DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED

.01	.005	.005
MM	AMG.	S

HEAT TREAT: N/A

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

MATERIAL: N/A

MODEL: 215

SHEET NO.: 1 OF 1 DRAWING I

ASSY, SHUTTLE TABLE

215 WHERE USED

ITEM	QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	2	102700	SPRING, COIL					
2	1	500705	TABLETOP - NARROW SHUTTLE					
3	2	500760	LIFTER - FEEDER PUSHER					
4	2	500762	PLATE - FEEDER PUSHER BOTTOM					
5	2	500775	PLATE - FEEDER PUSHER TOP					
6	2	531117-01	ASSY, PUSHER					

1 215
REV'D WHERE USED

DRAWN BY: TVK **STAMP:** 0 . 375

CHECKED BY: 01 - Mar - 99 **DATE:** 01 - Mar - 99

TRACED BY: MASTER **MASTER:** N/A

REMOVED ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED

FINISH: N/A **FINISH:** N/A

MATERIAL: N/A **MATERIAL:** N/A

DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED

.01	.005	.5	ANG.
xx	xxx		

HEAT TREAT: 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

KRK KIRK - RUDY, INC.
KENNESAW, GEORGIA

TITLE: ASSY, SHUTTLE TABLE

MODEL: 215 **SHEET NO.:** 0F1 **DRAWING #:** 5000705A

ITEM QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	100131	BUSHING, SL. 250 ID. 37500I .250 LG					
2	4 100145	BUSHING, SL. 625 ID. 81300L .000 LG					
3	2 109521	OIL METER UNIT					
4	2 109528	NUT, COMPRESSION FEMALE					
5	2 109537	SLEEVE, COMPRESSION					
6	1 190606	FITTING - 90 DEG 1/4 NPT					
7	1 190769	MAGNET, BUNTING					
8	1 500708	BODY, VACUUM VALVE					
9	1 500709	PLATE - VACUUM FEEDER					
10	1 500738	SPRING - VALVE					
11	1 500739	BLOCK - PUSHER					
12	1 500740	PLATE - VACUUM					
13	1 531155-01	PLATE, MAGNETIC					

DRAWN BY: TVK SCALE: 0 . 380 MATERIAL: N/A DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED

CHECKED BY:	DATE:	.xx	.xxx	ANG.	THIRD ANGLE PROJECTION
	05 - May - 98	.01	.005	.5	
TRACED BY:	MASTER	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED			HEAT TREAT: N/A
	M	ALL DIMENSIONS ARE FINISHED DIMENSIONS			FINISH: N/A
		DO NOT SCALE - WORK TO DIMENSIONS ONLY			

RECD WHERE USED

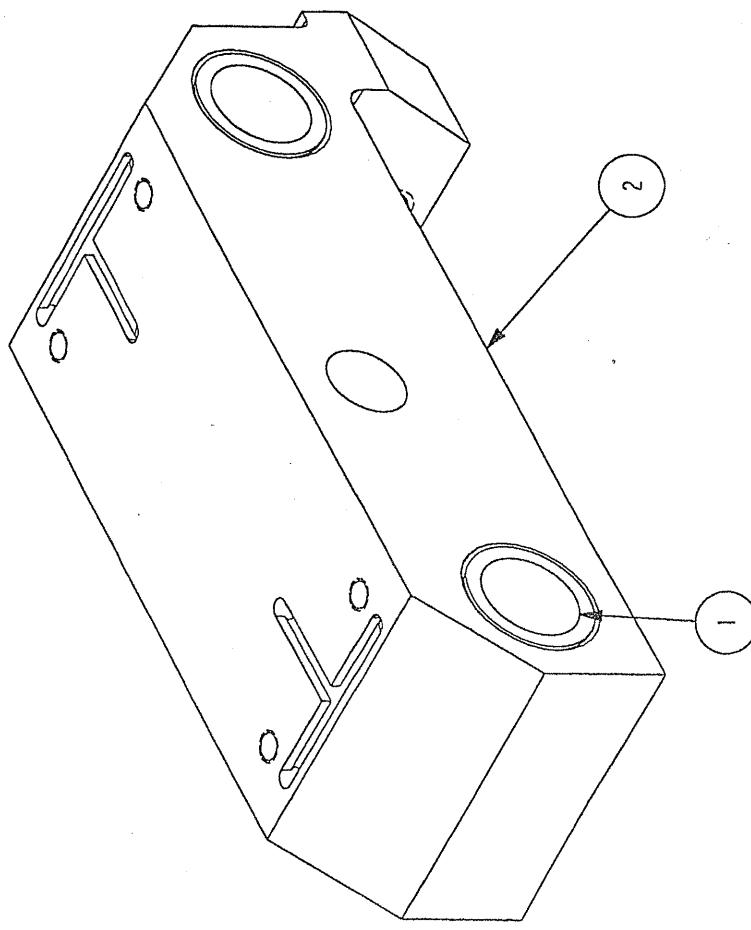
1	531021-01
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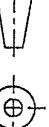
KIRK - RUDY, INC.
KENNESAW, GEORGIA

ASSY, VACUUM BODY

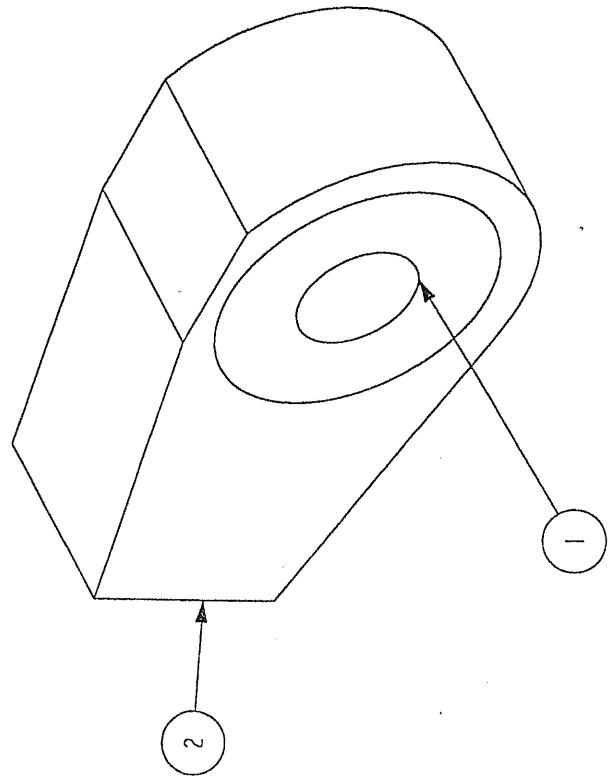
500708A

ITEM QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	4	100145 BUSHING, SL.625 ID.8130D1.000LG					
2	1	500728 BRACKET - FEEDER					



DRAWN BY:	MY	SCALE:	1 . 000	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED			MATERIAL:	N/A	THIRD ANGLE PROJECTION	KIRK - RUDY, INC.
CHECKED BY:		DATE:	09 - Apr - 99	.01	.005	.005	ANG.			KENNESAW, GEORGIA
TRACED BY:	MASTER	FINISH:	"M"	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED			HEAT TREAT:	N/A	NOTE:	ASSY, BUSHING BLOCK
				ALL DIMENSIONS ARE FINISHED DIMENSIONS					SHEET NO:	OF 1
				DO NOT SCALE - WORK TO DIMENSIONS ONLY					DRAWING NO:	500728A

ITEM QTY	PART #	DESCRIPTION
1	2	103106 BEARING, FLAT .375
2	1	500751 YOKE - FEEDER CRANK



REV NO	DATE	DESCRIPTION	ECN NO	BY
I 531021-01 REQ'D WHERE USED				
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				
DRAWN BY:	SCALE	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	THIRD ANGLE PROJECTION	TIME:
M.Y	2.000	.005 .005 .5		
CHECKED BY:	DATE	HEAT TREAT:	MODEL:	
	09-Apr-99	N/A	215	
TRACED BY:	MASTER	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY	FINISH:	SHEET NO.: 10F1 DRAWING # 500751A

ITEM QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	102701	SPRING	1	11/21/2000	REPLACED 500729-2 W/ 500729-4 REPLACE FLAT BRG W/ HUB BRG	6624	TJG
2	103405	CAM FOLLOWER					
3	103804	BEARING, HUB .625					
4	109719	PULLEY, TIMING 165M15 .375B .125K					
5	109722	PULLEY, TIMING 365M15 1.574 DIA					
6	500734	LEVER - CAM					
7	500746	ROLLER - BOTTOM FEED					
8	500786	LEVER SPRING					
9	500729-41	ARM, FEEDER CRADLE HUBBRG LH					
10	500729-4R	ARM, CRADLE FEEDER HUBBRG RH					
11	500748-5	SHAFT - FEEDER ROLLER					
12	500827-1	SHAFT, SPRING LEVER					
13	537683-01	WASHER, NO. 10 .63 00 .125TH					
14	CSDD265						
15	RHN012	HEX NUT					

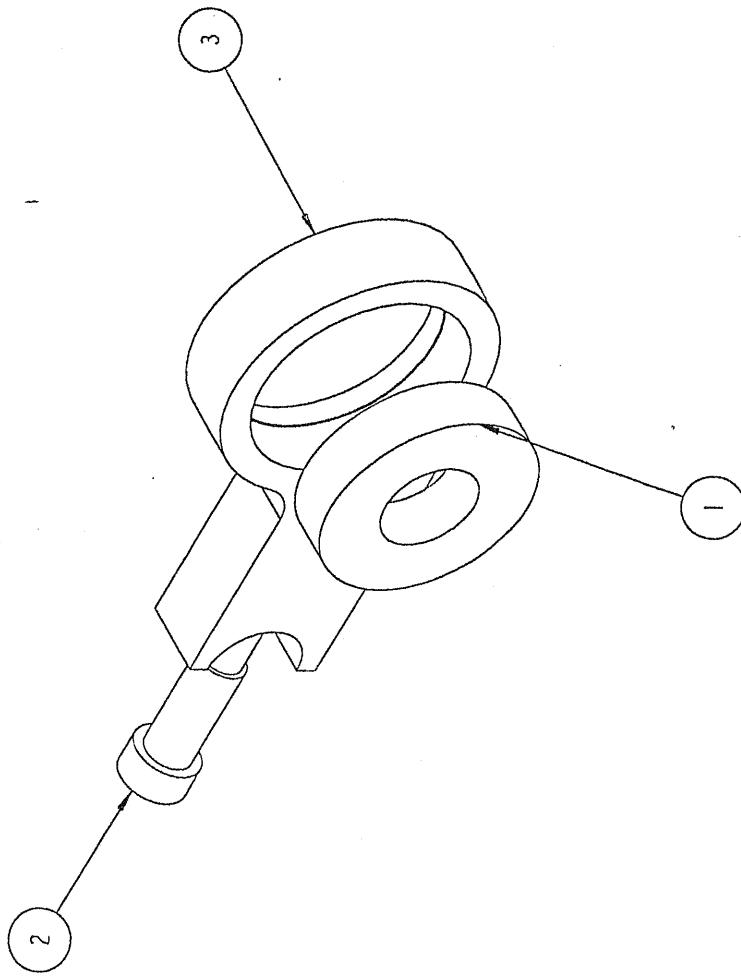
SCALE 0.125

I	XXX
RECD	WHERE USED

1	ASSY, LOWER FEED BELT DR.
2	531022-03

DRAWN BY: TJG	SCALE 0 .313	MATERIAL: DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	THIRD ANGLE PROJECTION	PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE QUOTED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC. KENNESAW, GA 30144 USA
CHECKED BY:	DATE 02-Nov-99	.XX .XXX .005 .5 ANG.	NOTE: SHEET NO. 10F1	KIRK - RUDY, INC. KENNESAW, GEORGIA
TRACED BY:	MASTER	HEAT TREAT: REMOVE ALL RUGGS AND SHARP EDGES UNLESS OTHERWISE NOTED	FINISH: ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY	DRAWING #

ITEM	QTY	PART #	DESCRIPTION
1	1	103110	BEARING, FLAT .625
2	1	107104	BOLT, SHOULDER 5/16X3/4
3	1	500729-2	ARM, CRADLE FEEDER



DRAWN BY:	SCALE	DATE	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	MATERIAL: NOTED	THIRD ANGLE PROJECTION NO DRAWING OF THIS DRAWING MAY BE OBTAINED ON REQUEST IN ANY FORM AT THE EXCESS WRITTEN PERMISSION OF KIRK-RUDY INC. KENNESAW, GA 3044 USA	REF'D WHERE USED
CHECKED BY:	.01	.005	.01	HEAT TREAT: NONE	TIME:	532059-01
TRACED BY:	MASTER	21 - Jan - 98	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED	FINISH: NOTED	SHEET NO. OF 1	DRAWING #
	M		ALL DIMENSIONS ARE FINISHED DIMENSIONS	DO NOT SCALE - WORK TO DIMENSIONS ONLY		500729-2A

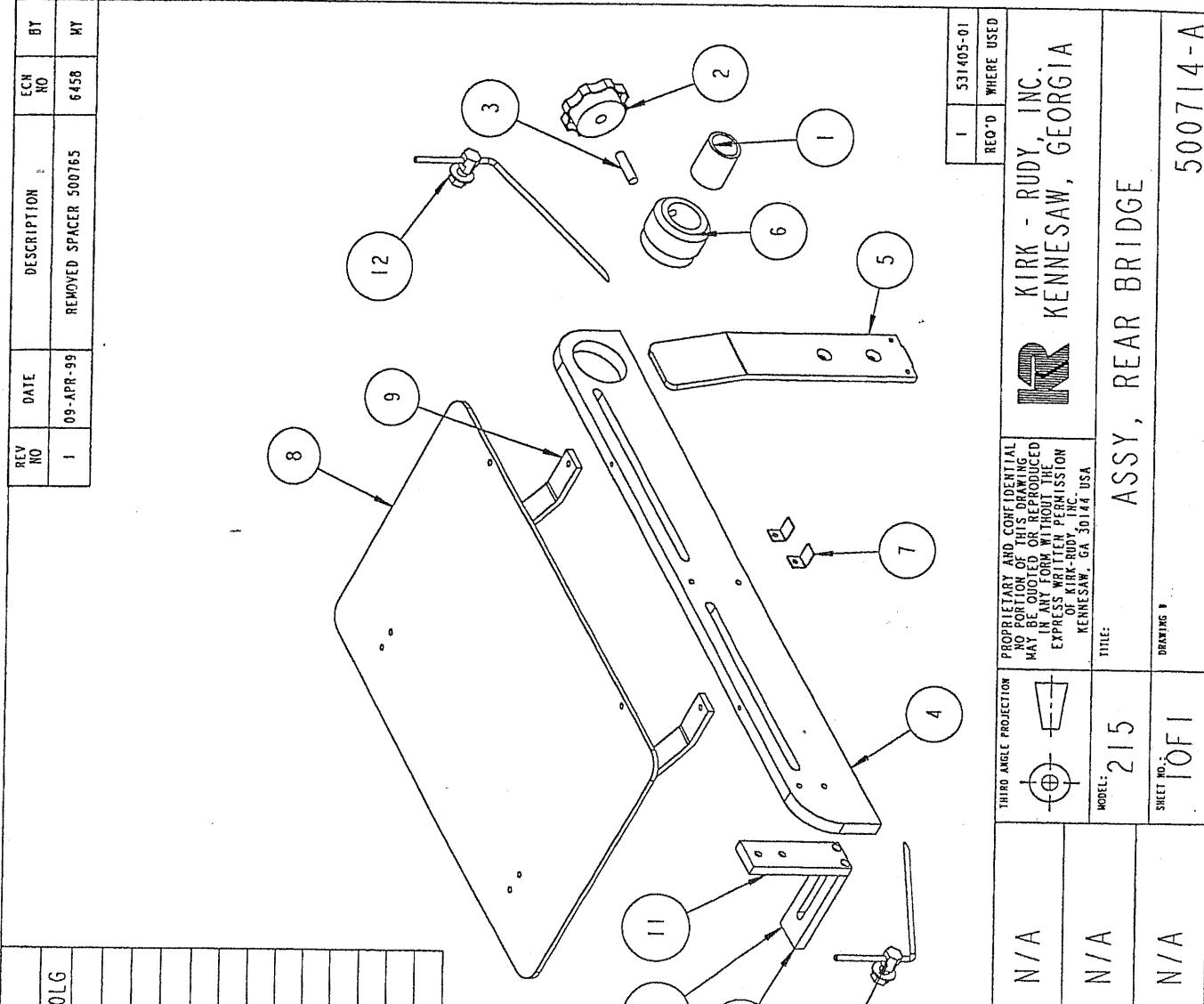
ITEM QTY	PART #	DESCRIPTION
1	1	500769 SHAFT - REAR GUIDE
2	2	500832 BRACKET - REAR-GUIDE
3	1	500714-A ASSY, REAR BRIDGE

DRAWN BY:	SCALE	0 . 250	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	MATERIAL: N/A	THIN END ANGLE PROJECTION	PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MA BE COPIED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY INC., KENNESAW, GA 30144 USA
CHECKED BY:	DATE	02 - Mar - 99	.01 .005 .5	HEAT TREAT: N/A	MODEL: 215	TIME: 00:00
TRACED BY:	MASTER	N	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY	FINISH: N/A	SHEET NO: 10F1	DRAWING #: ASSY, JOGGER TABLE
					1.000	215
					REV'D	WHERE USED

1.000	215
REV'D	WHERE USED

531405-01

ITEM QTY	PART #	DESCRIPTION
1	100109	BUSHING, S11.0001D1.2500DI.5000LG
2	102112	KNOB, PURCHASED
3	105601	SHAFT, THREADED 5/16-18
4	500714	BRIDGE - READ GUIDE
5	500715	PLATE - REAR CENTER GUIDE
6	500770	HUB - REAR GUIDE SHAFT
7	500771	CLIP-SIDE GUIDE
8	500845	TABLE, JOGGER
9	2 500847	BRACE, COMPUTER FORM REST
10	1 500878	SUPPORT - JOGGER TABLE
11	1 500880	BRACKET - JOG TABLE SUPP
12	1 500764AL	ASSY, LIFTER
13	1 500764AR	ASSY, LIFTER
14	1 500880A	ASSY, BRACKET



REV NO	DATE	DESCRIPTION	ECN NO	BT
1	09-APR-99	REMOVED SPACER 500765	6458	WY

I	531405-01
REQ'D	WHERE USED

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	DRAWING NO:	TITLE:	THIRD ANGLE PROJECTION	
	MATERIAL:	N/A		
DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	.01	.005	.5	HEAT TREAT:
DATA:	XII	XIX	ANG.	
CHECKED BY:				REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED
TRACED BY:				ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY
MASTER:	M			

DRAWN BY:	N JG	SCALE:	0.188	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. KENNESAW, GA 30144 USA
DATA:				.01 .005 .5	HEAT TREAT:	N/A		
CHECKED BY:								
TRACED BY:								

12 - Apr - 99

215

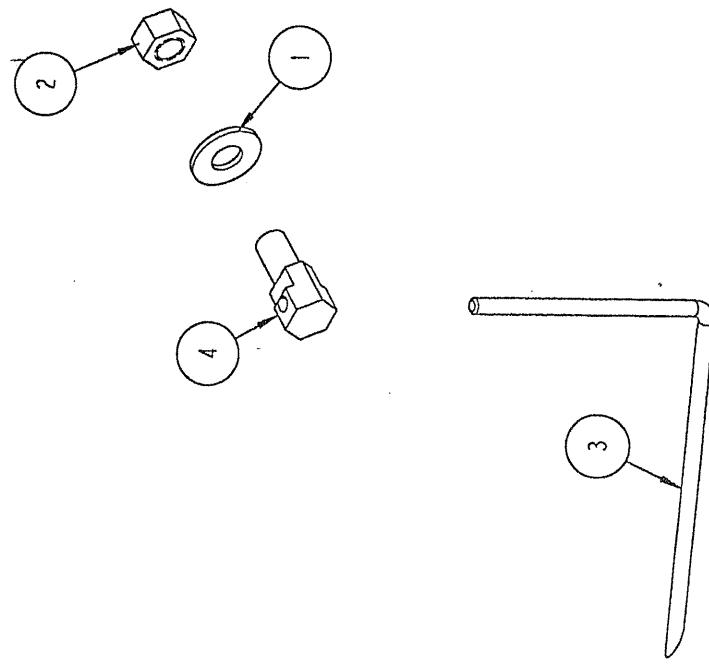
10F1

DRAWING #

ASSY, REAR BRIDGE

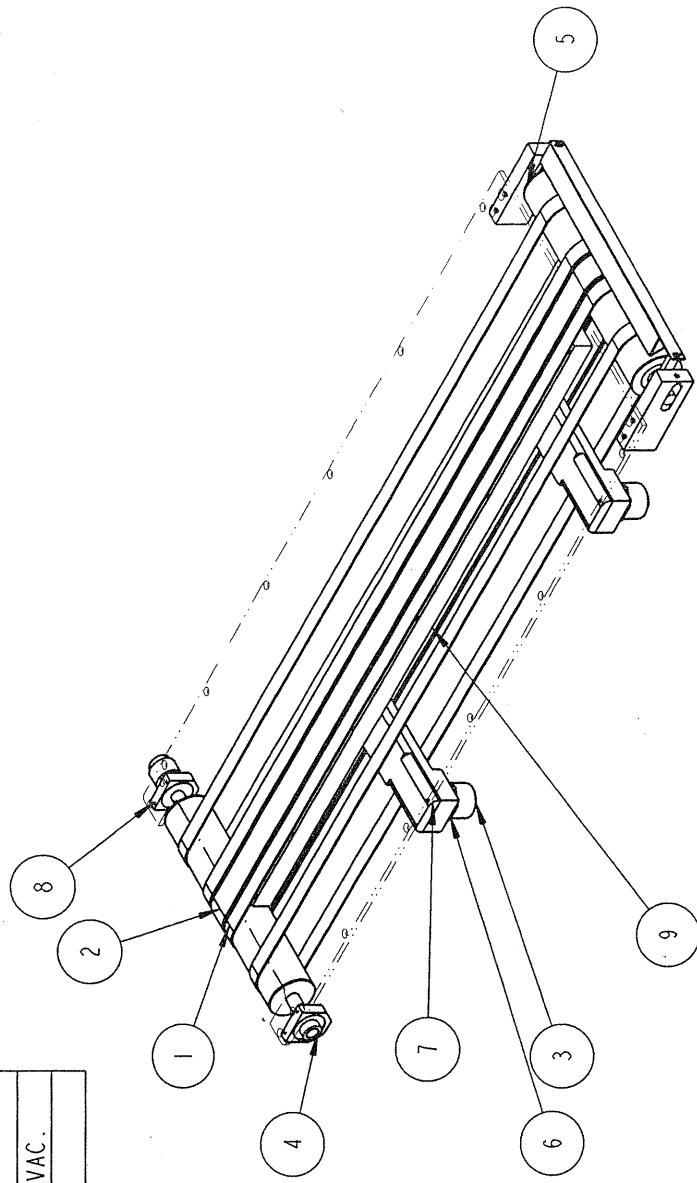
500714-A

ITEM QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	1	100601			THRUST WASHER		
2	1	106702			NUT, 3/8-16		
3	1	500764			LIFTER - REAR BRIDGE		
4	1	500766			SCREW - MACHINE REAR GUIDE		



DRAWN BY:	N J G	SCALE:	0 . 500	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	MATERIAL:	N / A	THIRD ANGLE PROJECTION	KIRK - RUDY, INC.
CHECKED BY:		DATE:	23 - JUL - 97	.05	AMT.	.01	-	KENNEBUNK, GEORGIA
TRACED BY:	MASTER	FINISH:		REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED	HEAT TREAT:	N / A	NOTE:	215
				ALL DIMENSIONS ARE FINISHED DIMENSIONS			SHEET NO.	10F1
				DO NOT SCALE - WORK TO DIMENSIONS ONLY			DRAWING #	500764A
								RE'D WHERE USED

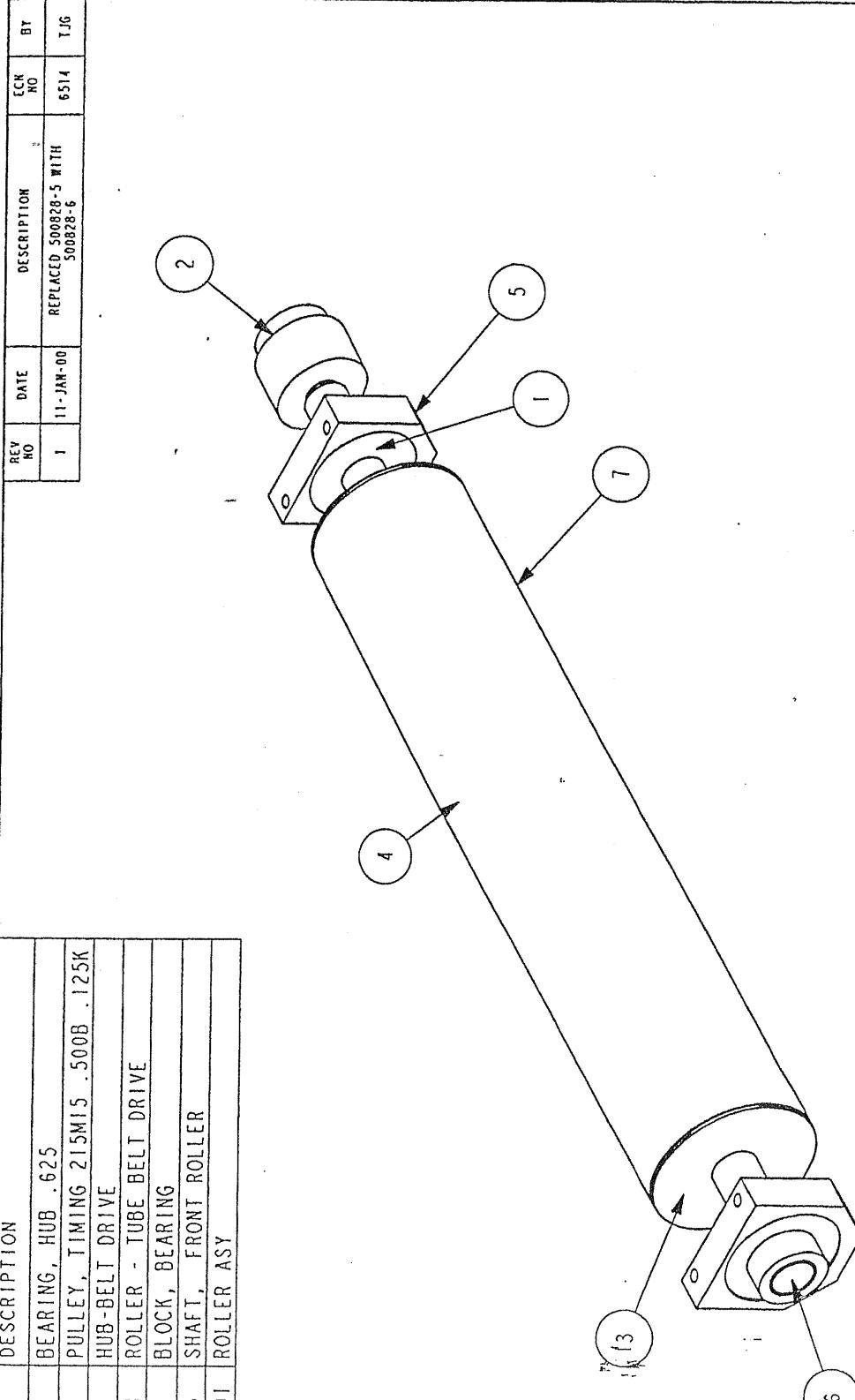
ITEM QTY	PART #	DESCRIPTION	REV NO	DATE	ECN NO	BY
1	4	106567 BELT, GREEN 3/4 X 86.75 IN.				
2	1	106568 BELT, GREEN 1.25 X 86.75				
3	2	190715 PVC COUPLING				
4	1	531274-02 ASSY, ROLLER BELT DRIVE				
5	1	533876-02 ASSY, IDLER ROLLER				
6	2	SP28217-1 BLOCK, LOWER VACUUM				
7	2	SP28218-1 BLOCK, UPPER VACUUM				
8	1	SP30201-19 TABLETOP, CENTER INFED W/VAC.				
9	1	SP30202-10 BLOCK, VACUUM				



I	536491-03
RCO'D	WHERE USED

DRAWN BY:	SCALE	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED		MATERIAL:	THIRD ANGLE PROJECTION		PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE COPIED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC. KENNESAW, GA 30144 USA	
CHECKED BY:	DATE	.XX	.XXX	AMG.	N/A			
TRACED BY:	DATE	.01	.005	.5	HEAT TREAT:	N/A		
		REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED		FINISH:	N/A	SP94000	SHEET NO.	1 OF 1
		ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY					DRAWING I	536468-03

ITEM	QTY	PART #	DESCRIPTION
1	2	103804	BEARING, HUB .625
2	1	109721	PULLEY, TIMING 215M15 .5000B .125K
3	2	500839	HUB-BELT DRIVE
4	1	500742-4	ROLLER - TUBE BELT DRIVE
5	2	500819-1	BLOCK, BEARING
6	1	500828-6	SHAFT, FRONT ROLLER
7	1	530676-01	ROLLER ASSY

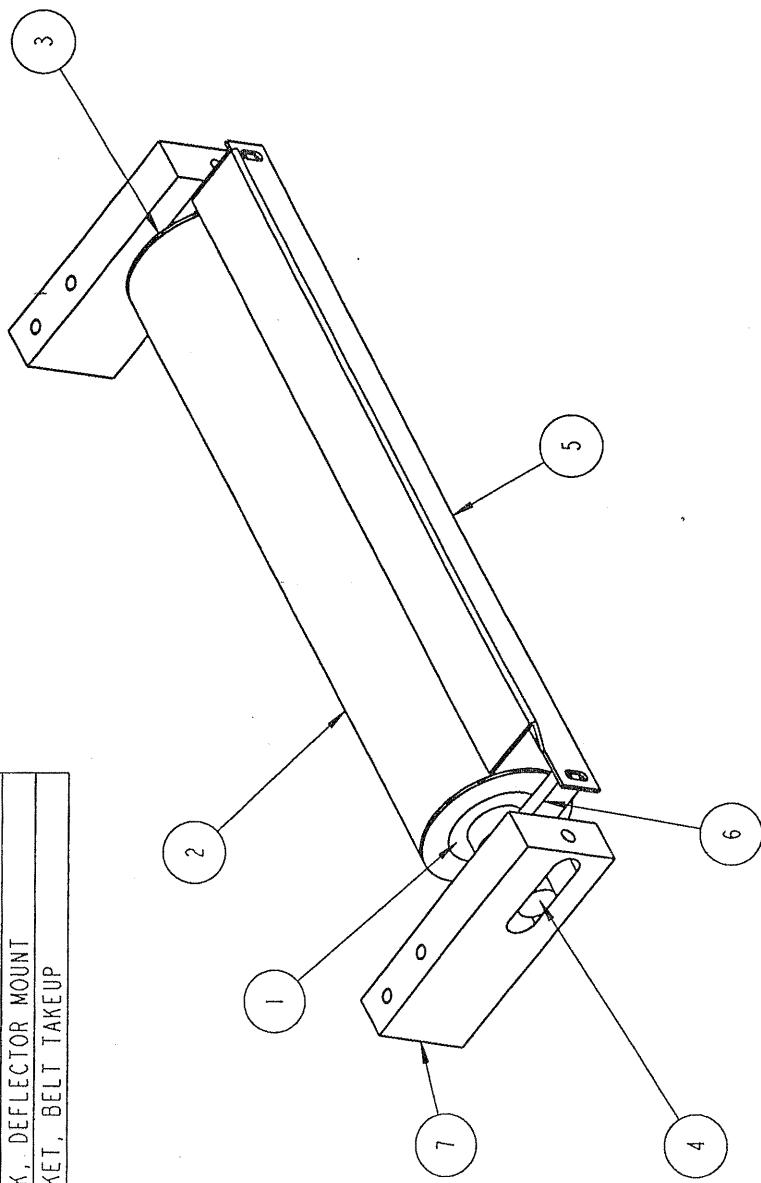


DRAWN BY:	SCALE:	DATE:	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	MATERIAL:	THIRD ANGLE PROJECTION	PROPRIETARY AND CONFIDENTIAL NO PORION OF THIS DRAWING MAY BE COPIED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY INC. KENNESAW, GA 30044 USA
J T JG	0 . 500	.01 .005 .5	X1 .005 ANG.	N/A		REMOVED SHARP EDGES UNLESS OTHERWISE NOTED
CHECKED BY:	DATE:	04 - NOV - 99	MEAT TREAT:	N/A		ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY
TRACED BY:	MASTERS:	M	MISS:	N/A	sheet 1 of 1	DRAWING #: ASSY, ROLLER BELT DRIVE 531274-02

1	2151J
REO'D	WHERE USED

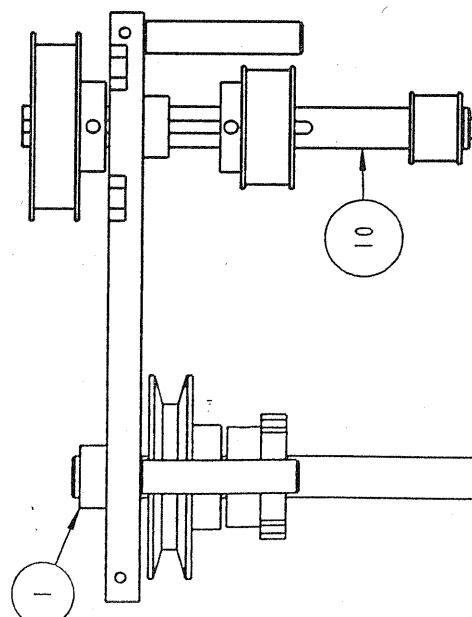
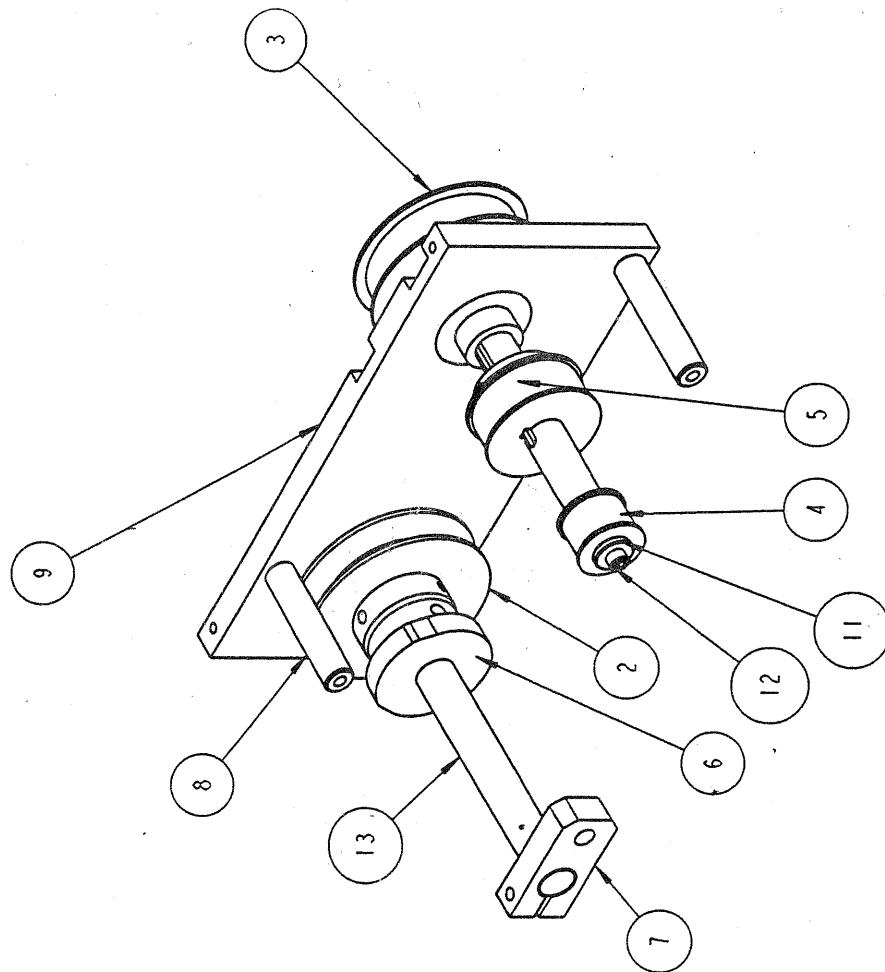
KIRK - RUDY INC. KENNESAW, GEORGIA

ITEM QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1 2	103804	BEARING - HUB					
2 1	500835	ROLLER					
3 2	500836	HUB					
4 1	500823-10	SHAFT, IDLER ROLLER					
5 1	533623-01	DEFLECTOR					
6 2	533669-01	BLOCK, DEFLECTOR MOUNT					
7 2	533975-01	BRACKET, BELT TAKEUP					



DRAWN BY:	T J G	SCALE	0 . 375	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	MATERIAL: NOTED	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. KENNESAW, GEORGIA	RECD WHERE USED
CHECKED BY:		.xx	.xxx	ANG.	.005	.5			
DATE:	28 - Feb - 00	DATE		HEAT TREAT:	NONE	NOTE:	SP 81400	TITLE:	
TRACED BY:	M	MASTER		FINISH:	NONE	SHEET NO.:	1 OF 1	DRAWING #:	

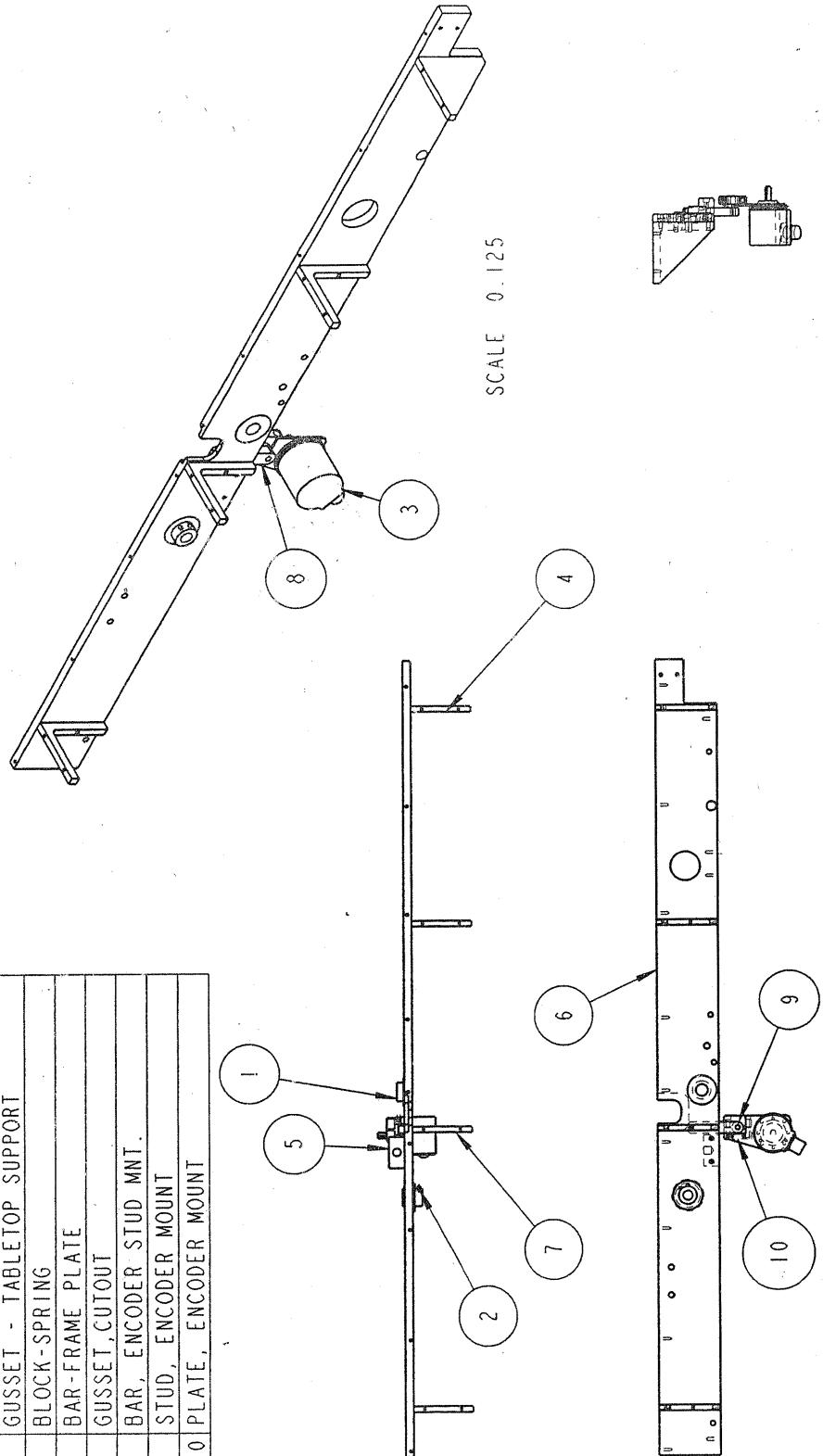
ITEM	QTY	PART #	DESCRIPTION
1	2	103804	BEARING - HUB
2	1	105021	V-PULLEY, AK30
3	1	108841	PULLEY, TIMING 21L050 .625B .188K
4	1	109719	PULLEY, TIMING 16M15 .375B .125K
5	1	109720	PULLEY, TIMING 28M15 .625B .188K
6	1	500747	CAM - FEED ROLLERS
7	1	500750	CRANK - FEEDER SLIDE
8	2	102672-1	SPACER, SIDE PLATE
9	1	500720-9	PLATE, SIDE BEARING SUPPORT
10	1	500829-4	SHAFT, GEAR
11	1	537683-01	WASHER, NO. 10 .63 OD .125TH
12	1	CSDD265	
13	1	SP333419-3	SHAFT



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 30444 USA
T JG	0 .375	.01 .005 .005	N / A		
DATE:	04-Nov-99	ANG.	HEAT TREAT:		KIRK - RUDY, INC. KENNESAW, GEORGIA
CHECKED BY:			N / A		SP 79000
TRACED BY:	M		FINISH:		SHEET NO. 1 OF 1
		REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED	ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY		ASSY, BELT DRIVE PLATE

536178-02

ITEM QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	RY
1	1	103805 BEARING, HUB .750					
2	1	103817 HUBBEARING 5/8 ID					
3	1	202507 ENCODER, DYNAPAR 3600PPR					
4	1	500721 GUSSET - TABLETOP SUPPORT					
5	1	500785 BLOCK-SPRING					
6	1	500701-R BAR-FRAME PLATE					
7	3	500721-1 GUSSET, CUTOUT					
8	1	537691-01 BAR, ENCODER STUD MNT.					
9	1	538341-01 STUD, ENCODER MOUNT					
10	1	SP45241-10 PLATE, ENCODER MOUNT					



DRAWN BY:	T JG	SCALE	0 . 094	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		xx . xxx	AMT:	xx	KIRK - RUDY - INC KENNESAW, GEORGIA
TRACED BY:		xx - 0 c + - 0	.01 .005 .5	HEAT TREAT:	XXX	MODEL: SP94000	ASSY, 215 FRAME RH
MASTER				FINISH:	XXX	SHEET NO: 10F1	DRAWING #: 536475-02
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	2	103108 BEARING, FLAT .500					
2	2	103805 BEARING, HUB .750					
3	2	103812 BEARING, HUB .625					
4	1	104106 SNAPRING, .500					
5	1	104205 SNAPRING, INTERNAL 1.125 BORE					
6	1	500721 GUSSET - TABLETOP SUPPORT					
7	1	508540 STUD					
8	1	525408 STUD, TAKEUP ARM					
9	2	500721-1 GUSSET, CUTOUT					
10	1	500983-7 STUD, IDLER SPROCKET					
11	1	508684-1 ARM, TAKE UP					
12	1	516045-5 ROLLER, BELT TAKEUP					
13	1	516045A ASSY, IDLER 1.376 DIA. X 1.00					
14	1	531106-01 ASSY, HUB					
15	1	536469-01 FRAME, 215A LH					
16	1	536477-01 ASSY, TAKE UP TIMING BELT					
17	1	538996-01 ASSY, ECCENTRIC BELT IDLER					

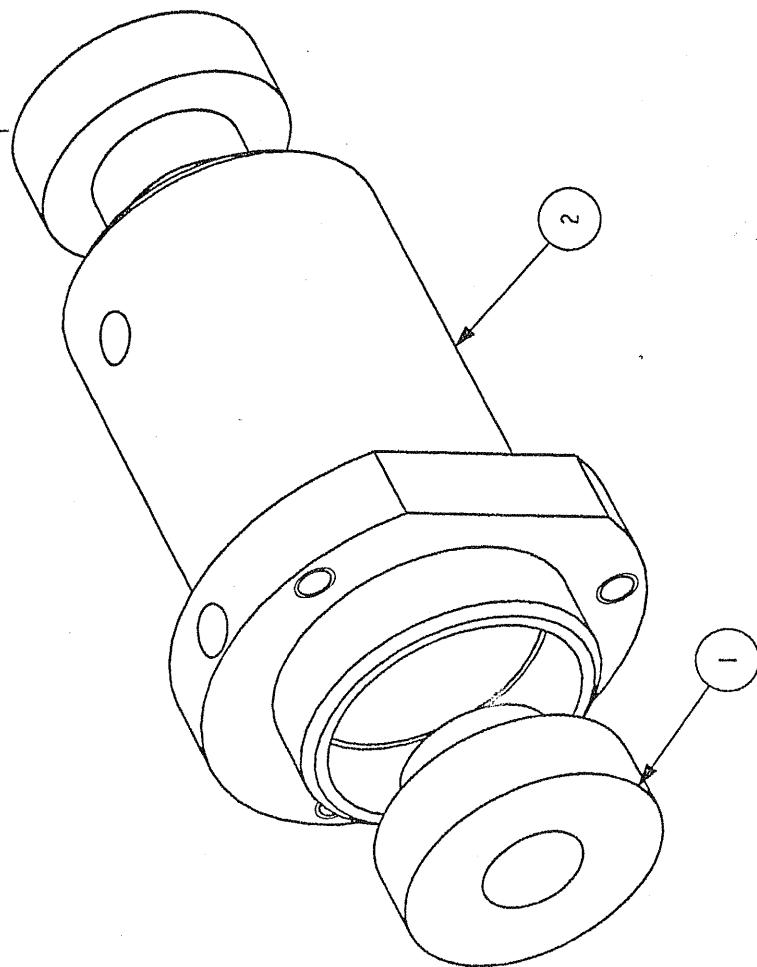
SCALE 0.125

REF D WHERE USED
1 536491-03

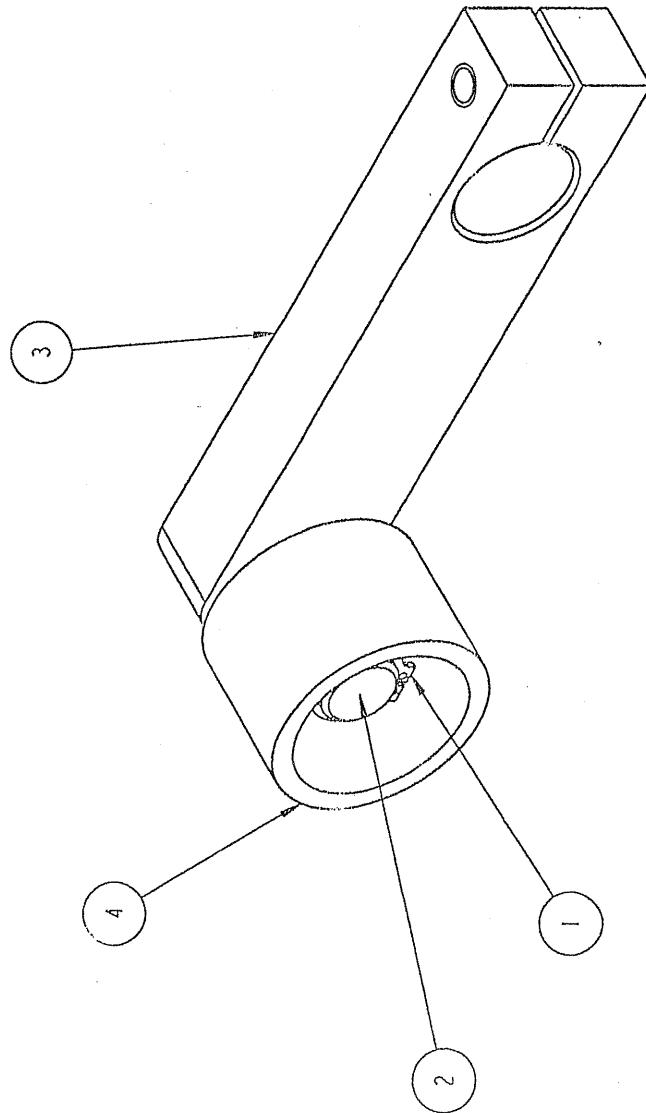
DRAWN BY: T JG	SCALE 0 . 0 9 4	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED		MATERIAL: XXX	THIRD ANGLE PROJECTION	PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE QUOTED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC. KENNESAW, GA 30144 USA	
CHECKED BY:	DATE 17-0c + -0	.01	.005	HEAT TREAT: XXX	NOTE: SPP 94000	TITLE: ASSY, 215 FRAME LH	
TRACED BY:	MASTER	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED		FINISH: XXX	SHEET NO. 10F1	DRAWING # 536476-02	

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

DRAWN BY:	SCALE	REV NO	DATE	DESCRIPTION	ECN NO	BY
JLG	1.000					
DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED						
	.01	.005	.5	HEAT TREAT:	N/A	
CHECKED BY:	DATE					
	28-JUL-99					
TRACED BY:	MASTER					
	M					
REMOVED ALL BURRS AND SHARP CORNERS UNLESS OTHERWISE NOTED						
ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY						
PROPRIETARY AND CONFIDENTIAL NO koppy or copy of this drawing MAY BE QUOTED OR REPRODUCED EXCEPT WITH WRITTEN PERMISSION OF KIRK-RUDY INC. KENNESAW, GA 30144 USA						
KIRK - RUDY, INC. KENNESAW, GEORGIA						
TITLE: ASSY, HUB						
SHEET NO. 1 OF 1 DRAWING #						
531106-01						

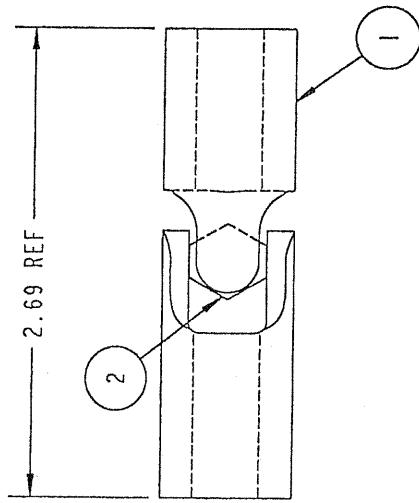


ITEM QTY	PART #	DESCRIPTION
1	104106	SNAPRING, .500
2	508540	STUD
3	508684-2	ARM, TAKE UP
4	516045A	ASSY, IDLER 1.376 DIA. X 1.00 IN



ITEM	REV NO	DATE	DESCRIPTION	ECN NO	B7
1				536476-01	
REQ'D WHERE USED					
KR KIRK-RUDY, INC.					
KR 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					
THIRD ANGLE PROJECTION					
DRAWN BY: TJG	SCALE .000	MATERIAL: XXX	DATE: 01 - Sep - 99	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	
CHECKED BY:	DATE	REMAINS:	DATE	.01 .005 .5 %	
TRACED BY:	MASTER	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED	MASTER	ALL DIMENSIONS ARE FIRMED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY	
				NOTE: SP 76500	PRINTED: 1 OF 1
				SHEET NO: 1	DRAWING #: 536477-01

ITEM QTY	PART #	DESCRIPTION
1	2	100800_1 UNIVERSAL
2	1	100800_3 BLOCK, PIN



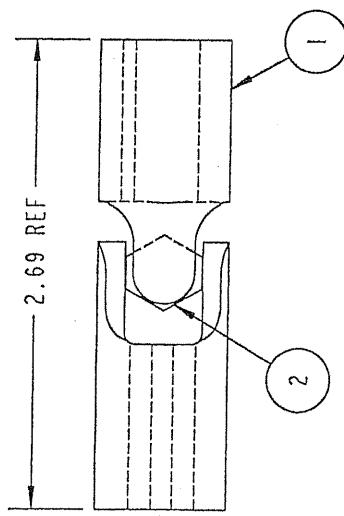
REV NO	DATE	DESCRIPTION	ECN NO	B/T
I	2-11-98	RE-DRAWN IN PRO-E	6254	NJG

REF'D	WHERE USED
I	531679-01
I	500704-A

DRAWN BY:	SCALE	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	PURCHASED	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	THIRD ANGLE PROJECTION	PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE COPIED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC. KENNESAW, GA 30144 USA	
						MODEL:	TITLE:
CHECKED BY:	DATE	.01 .005 .5	HEAT TREAT:	N/A	215	ASSY, UNIVERSAL JOINT	DRAWING #
TRACED BY:	MASTER	30-MAY-90	FINISH:	N/A	SHEET NO.:	10F1	100800

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

DRAWN BY:	SCALE	1.000	MATERIAL:	PURCHASED	THIRD ANGLE PROJECTION	PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE QUOTED OR REPRODUCED IN WHOLE OR IN PART WITHOUT EXPRESS WRITTEN PERMISSION OF KIRK-RUDY INC. KENNESAW, GA 30442 USA
CHECKED BY:	DATE	.xx .xx .xx	AMG.	.01 -.005 .005	HEAT TREAT:	N/A
TRACED BY:	MASTER	31 - JUL - 79			REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED	
					ALL DIMENSIONS ARE FINISHED DIMENSIONS	
					DO NOT SCALE - WORK TO DIMENSIONS ONLY	

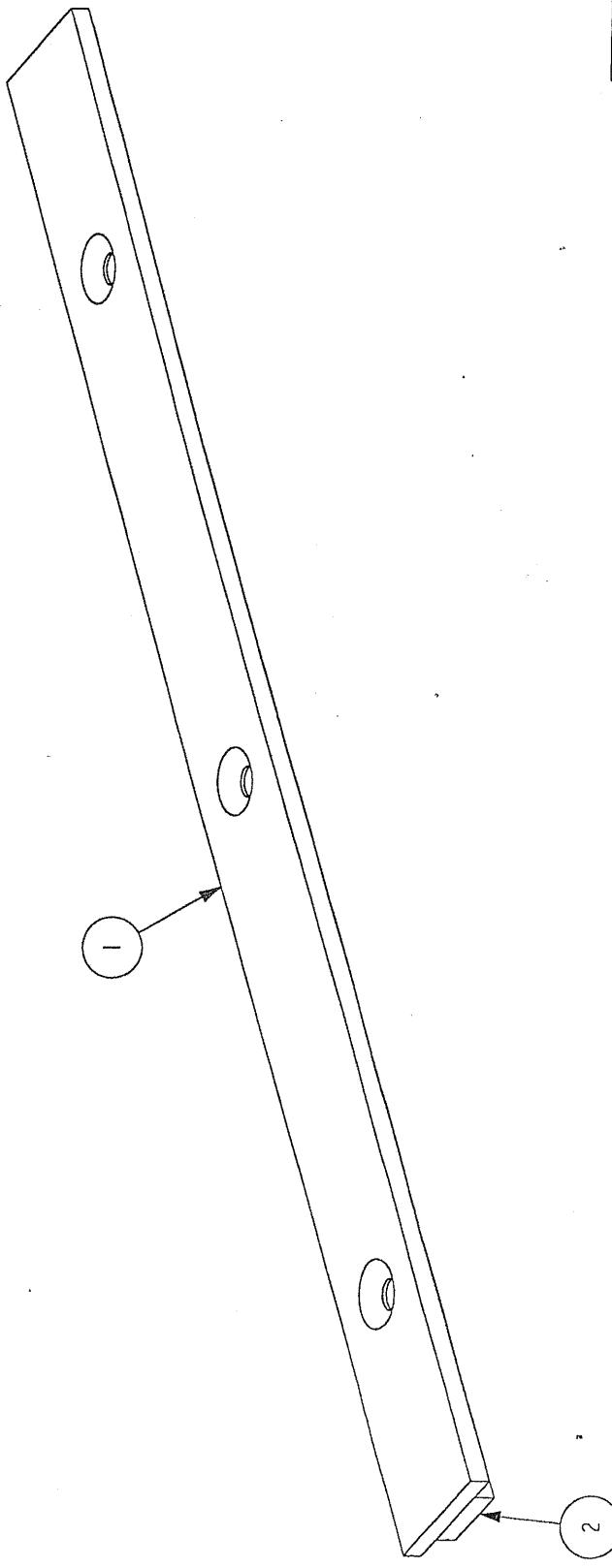


1	531679-01
1	500704-A
REQ'D	WHERE USED
KRK	KIRK - RUDY, INC.
KRK	KENNESAW, GEORGIA
MODE:	215
TITLE:	ASSY, UNIVERSAL JOINT
SHEET NO.:	100800-1
DRAWING #:	100800-1

ITEM QTY	PART #	DESCRIPTION
1 1	500814-1	RAIL - SIDE GUIDE
2 1	500814-2	RAIL - SIDE GUIDE

DRAWING # 500814-1A

REV NO	DATE	DESCRIPTION	ETCH NO	BY



DRAWN BY:	MY	SCALE	1 . 000	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	MATERIAL:	N / A	THIRD ANGLE PROJECTION	PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE QUOTED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC.  KENNESAW, GEORGIA
CHECKED BY:		DATE	12 - Apr - 99	.xx .xxx ANG.	.01 .005 .5	HEAT TREAT:	N / A	
TRACED BY:	MASTER	MASTER	M	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: 215	TITLE: ASSY, SIDE GUIDE RAIL
							SHEET NO: 10F1	DRAWING #: 500814-1A

PARTS LIST						
ITEM #	PART #	DESCRIPTION	KEY NO	DATE	DESCRIPTION	ECN NO
1	2	100400 THRUST WASHER				
2	1	100402 THRUST WASHER				
3	2	100409 THRUST WASHER				
4	2	101100 ONE WAY BEARING				
5	1	102114 KNOB				
6	1	102117 KNOB				
7	1	102225 COLLAR				
8	1	102345 SHIM				
9	2	102701 SPRING	26			
10	4	103106 BEARING - FLAT				
11	2	104400 BOLT - HEX HEAD				
12	1	190600 SPIDER - ROLLER DRIVE				
13	1	190885 LEVER - QUICK RELEASE				
14	1	500730 PLATE, GATE FEEDER				
15	1	500743 SHAFT - TOP ROLLER DRIVE				
16	1	500744 SHAFT - TOP ROLLER ASSY				
17	2	500745 ROLLER - IDLER				
18	1	500195 PLATE - BACK				
19	2	500805 PLATE - HOLD DOWN				
20	1	500806 PLATE - GATE END				
21	2	500807 NUT - LOCK				
22	1	500808 PLATE - TOP BRIDGE				
23	2	500809 SLEEVE - THREADED				
24	1	500810 SHAFT - SCREW ADJ				
25	2	500811 FORK ASY				
26	2	500812 KNOB, ROLLER ADJUSTMENT				
27	2	500859 SPACER				
28	1	102114A ROUND KNOB ASY				
29	1	102200-2 COLLAR				
30	1	500743.2 SHAFT - TOP ROLLER				
31	2	500744.5 COLLAR - TOP ROLLER SHAFT				
32	1	500744.6 SHAFT - TOP ROLLER				
33	2	500745A UPPER FEED ROLLER ASY				
34	1	500749.5 FLOCK, CLAMP SUPPORT				
35	2	500799.6 STUD, BRIDGE (LONG)				
36	2	500799.7 STUD, BRIDGE (SHORT)				
37	1	500799.2 BLOCK - CONNECTOR				
38	1	500799.3 CLAMP - MOUNTING PLATE				
39	2	500811A FORK ASY WITH BEARINGS				
40	1	531582-01 EG BRIDGE DRIVE AND GATE ASY				
41	2	531584-01 EG FORK ASY				
42	2	531672-01 BAR, FORK				
43	2	531673-01 YOKE				
44	1	RHB051				
45	1	RHB081				
46	1	SX5390				
47	1	WH5010				
48	1	WH5011				

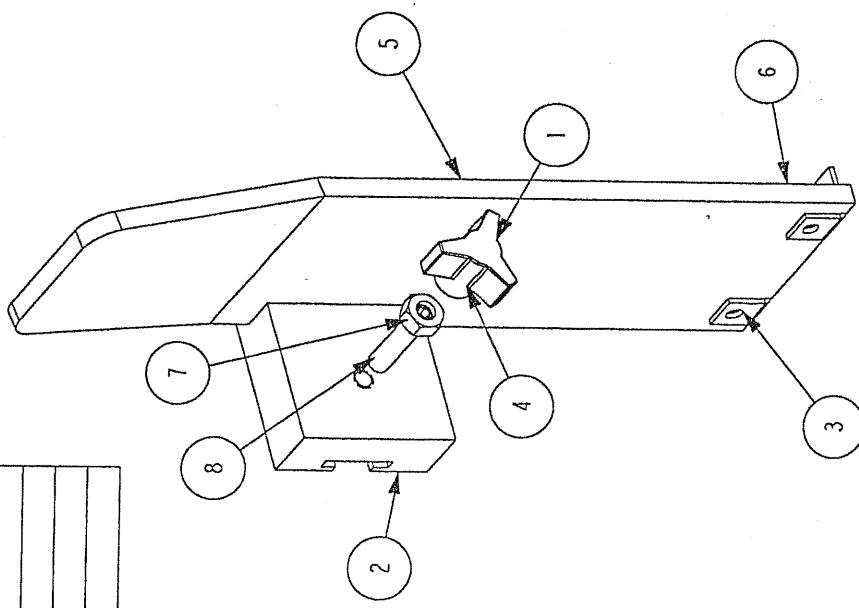
DRAWING NO.		SCALE	DIMENSIONS IN INCHES UNLESS OTHERWISE SPECIFIED		THREE ANGLE PROJECTION		PROPRIETARY AND CONFIDENTIAL INFORMATION CONTAINED HEREIN IS THE PROPERTY OF KIRK-RUDY INC. AND IS RESTRICTED FROM DIVULGATION EXCEPT AS PROVIDED BY APPLICABLE CONTRACTUAL AGREEMENTS.	
NAME	NUMBER	DATE	IN	MM	IN	MM	IN	MM
TVK	0 . 250	23 - Sep - 97	XXX	XXX	XXX	XXX	KIRK - RUDY INC.	
CHECKED BY:			WEIGHT:	WEIGHT:	WEIGHT:	WEIGHT:	KENNESAW, GEORGIA	
MAKER:	<i>M</i>		SPRING:	SPRING:	SPRING:	SPRING:	EG BRIDGE DRIVE AND GATE ASY	
REMOVED BY:			STUFFED:	STUFFED:	STUFFED:	STUFFED:	531582-01	

ITEM QTY	PART #	DESCRIPTION
1	1	500755AL ASSY, SIDE GUIDE LH
2	1	500755AR ASSY, SIDE GUIDE RH

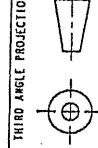
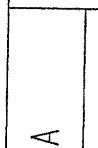
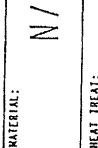
REV NO	DATE	DESCRIPTION	ECN NO	BY
1	535411-01			REO'D WHERE USED

DRAWN BY: TVK	SCALE: 0 . 500	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED		MATERIAL: N / A	THIRD ANGLE PROJECTION	PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE QUOTED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC. KENNESAW, GA 30144 USA		
CHECKED BY:	DATE: 02 - Mar - 99	.XX	.XXX	ANG. .01	.05	.5	HEAT TREAT:	N / A
TRACED BY:	MASTER	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED		ALL DIMENSIONS ARE FINISHED DIMENSIONS		TITLE: 215		
	"	M		N / A		SHEET NO: 10F1	DRAWING #: 535412-01	

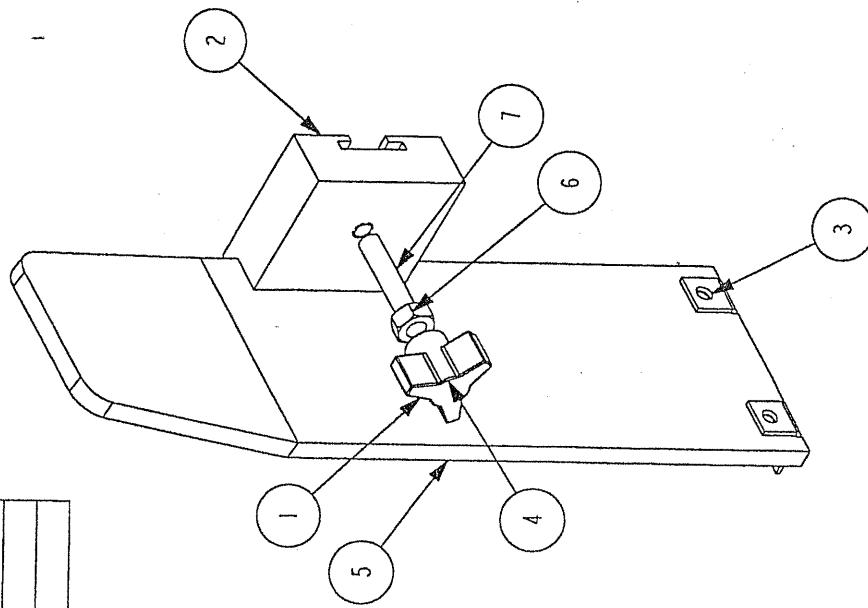
ITEM QTY	PART #	DESCRIPTION
1	1	102119 KNOB
2	1	500755 CLAMP - SIDE GUIDE
3	2	500771 CLIP-SIDE GUIDE
4	1	102119-A ASSY, KNOB
5	1	500788L PLATE - RH SIDEGUIDE
6	1	500788LA ASSY-SIDE GUIDE PLATE
7	1	RHN010 HEX NUT
8	1	SYA601



ITEM NO	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	1	535412-01			
REQ'D WHERE USED					
 KIRK - RUDY, INC.					
KENNESEAW, GEORGIA					
KIRK RUDY, INC., 36144 USA					
TITLE: ASSY, SIDE GUIDE LH					
DRAFTING # 10F1					
500755AL					

DRAWN BY:	SCALE	MATERIAL:	THIRD ANGLE PROJECTION	PROPRIETARY AND CONFIDENTIAL
MY	0 . 500	N/A		NO FOR ICON OF THIS DRAWING MAY BE QUOTED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK RUDY, INC. KENNESEAW, GA 36144 USA
CHECKED BY:	DATE : 12-Apr-99	MATERIAL: N/A		HEAT TREAT: N/A
TRACED BY:	MASTER	DIMENSIONS: REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED FINISH: ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY		MODEL: 215
				SHEET NO.: 1 OF 1

ITEM QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECH NO	BY
1	1	102119			KNOB		
2	1	500755			CLAMP - SIDE GUIDE		
3	2	500771			CLIP-SIDE GUIDE		
4	1	102119-A			ASSY, KNOB		
5	1	500788R			PLATE, SIDEGUIDE RH		
6	1	RHN010			HEX NUT		
7	1	SYA601					



1	535412-01	REO'D WHERE USED
3	KIRK - RUDY, INC.	KENNESAW, GEORGIA
4	215	TITLE:
5	N/A	DRAWING #:
6	N/A	SCALE:
7	N/A	MADE BY:
8	N/A	CHECKED BY:
9	N/A	TRACED BY:

THIRD ANGLE PROJECTION

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

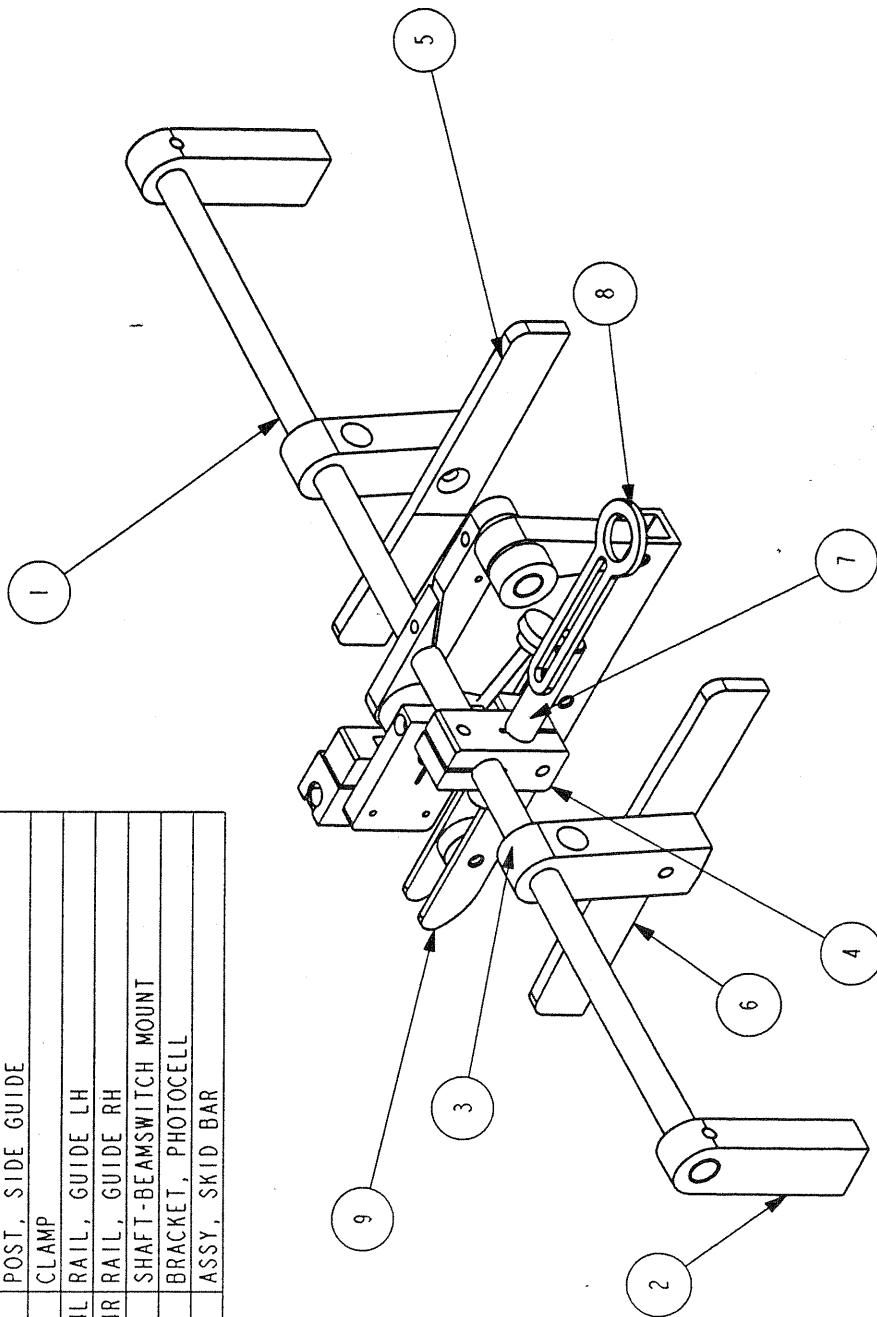
MATERIAL: N/A
DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED
.015 .005 .005 .005
.01 .005 .005 .005
ANG. ANG. ANG. ANG.

HEAT TREAT: N/A
REMOVE ALL BURRS AND
SHARP EDGES UNLESS
OTHERWISE NOTED
ALL DIMENSIONS ARE
FINISHED DIMENSIONS
DO NOT SCALE - WORK
TO DIMENSIONS ONLY

MASTER " M "

12 - Apr - 99

ITEM QTY	PART #	DESCRIPTION
1	500787	SHAFT-SIDE GUIDE ADJ.
2	500791	POST, SIDEGUIDE
3	500792	POST, SIDE GUIDE
4	508593	CLAMP
5	500722-24L	RAIL, GUIDE LH
6	500722-24R	RAIL, GUIDE RH
7	508995-1	SHAFT-BEAMSWITCH MOUNT
8	508996-4	BRACKET, PHOTOCELL
9	538021-01	ASSY, SKID BAR



ITEM	REV NO	DATE	DESCRIPTION	ECN NO	BY
1					
2					
3					
4					
5					
6					
7					
8					
9					

DRAWN BY:	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. KENNESAW, GA 30144 USA
CHECKED AT:	DATE	.xx	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	N / A	HEAT TREAT:	
TRACED BY:	MASTER	17-Jan-00	.01	.005	.5	SP 81400
			REMOVE ALL BURS, AND SHARP EDGES UNLESS OTHERWISE NOTED	N / A	FINISH:	SHEET NO. 1 OF 1
			ALL DIMENSIONS ARE FINISHED DIMENSIONS	N / A		DRAWING #
			DO NOT SCALE - WORK TO DIMENSIONS ONLY			538188-01

ITEM	QTY	PART #	DESCRIPTION	REV NO	DATE	ECN NO	BY
1	2	100162	BUSHING, SL. 500 ID. 625 OD. 625 LG				
2	1	102114	KNOB				
3	1	102205	COLLAR .500				
4	2	103107	BEARING, FLAT .312				
5	1	105201	PIN, ROLL .125X 1.000				
6	1	105602	SHAFT, THREADED 10-32				
7	1	190101	MICROSWITCH, LEVER				
8	1	190203	COVER, MICROSWITCH				
9	1	500800	LINK-SKID-FRONT				
10	1	500801	LINK-SKID-REAR				
11	1	500802	HOLDER-SKID SWITCH				
12	2	500834	SHAFT, SKID ROLLER				
13	1	503794	CLAMP				
14	1	190101A	ASSY-SWITCH WITH COVER				
15	1	500723-8	CHANNEL, SKID				
16	1	500800-A	ASSY, LINK				
17	1	500801A	ASSY, LINK				
18	1	500802A	ASSY, CLAMP				
19	2	500834A	ASSY, STUD WITH BEARING				
20	2	SP37359	SHAFT, SKID BAR SPACER				

SCALE 0.500

REQ'D	WHERE USED
1	KR2191J20
1	KR2191J

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

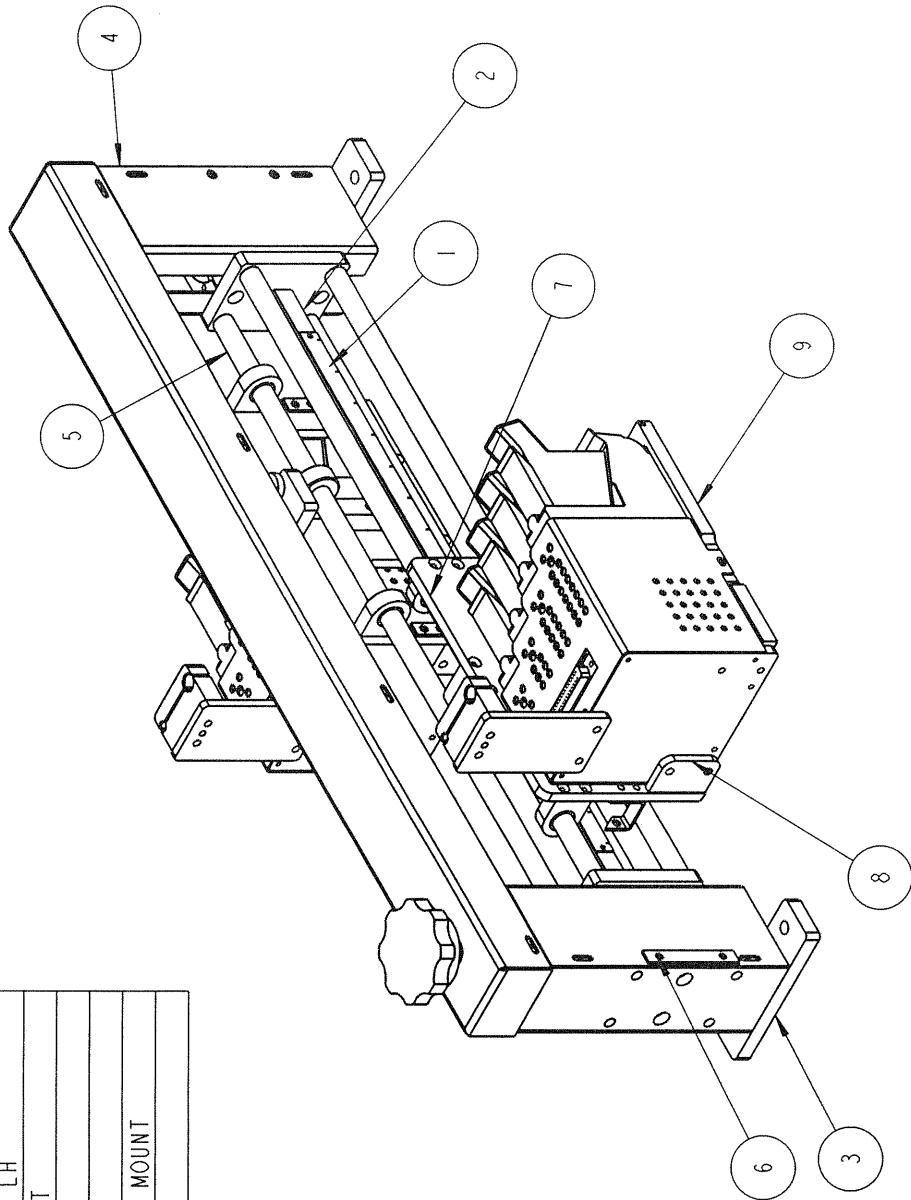
THIRD ANGLE PROJECTION	PROJECTION
MODEL:	191J
SHEET NO.:	10F1

DRAWN BY:	SCALE	0.750	MATERIAL:	N/A
DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED				
.01	.005	.5	HEAT TREAT:	N/A
.01 -.005 ANG.				
REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED				
ALL DIMENSIONS ARE FINISHED DIMENSIONS				
DO NOT SCALE - WORK TO DIMENSIONS ONLY				

CHECKED BY:	DATE	15 - NOV - 99		
TRACED BY:	MASTER	M		

ASSY, SKID BAR	
538021-01	

ITEM QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	2	190771 SCALE, CENTER ZERO					
2	1	531678-02 BAR, SCALE SUPPORT					
3	1	538153-01 ASSY, VERTICAL ADJ. RH					
4	1	538153-02 ASSY, VERTICAL ADJ. LH					
5	4	538168-01 SHAFT, HEAD SUPPORT					
6	2	538178-01 STRAP, RIBBON CLAMP					
7	2	538269-04 ASSY, INKJET MOUNT					
8	2	538277-01 PLATE, INKJET HEAD MOUNT					
9	2	538863-01 ASSY, 4 HEAD MOUNT					



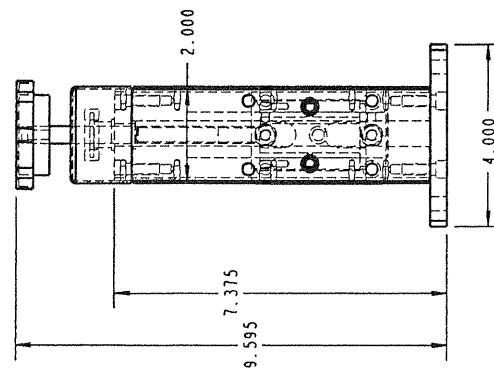
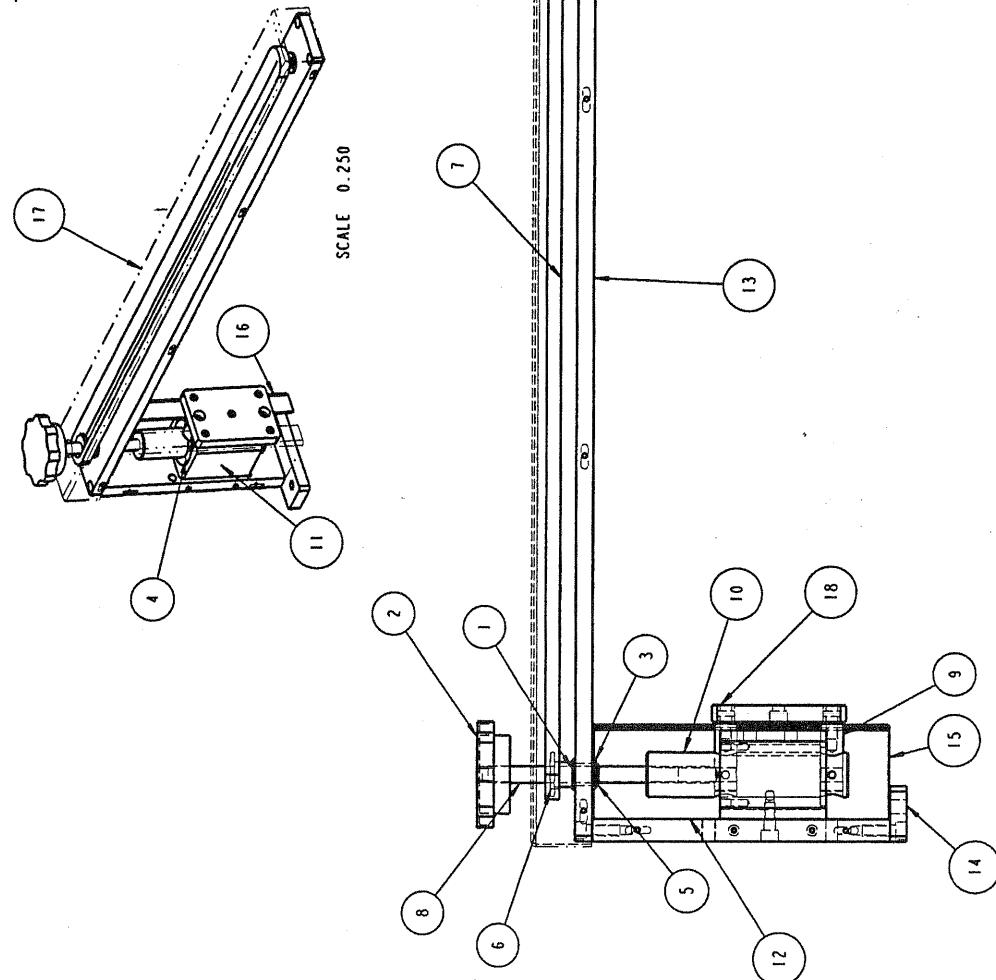
DRAWN BY: T JG	SCALE 0 .250	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED		MATERIAL: XXX		REO'D WHERE USED
CHECKED BY:	DATE 16 - JUL - 01	.xx	.xxx	ANG. .01	.005	.5
TRACED BY:	MASTER	HEAT TREAT:		XXX		
		REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED		XXX		
		ALL DIMENSIONS ARE FINISHED DIMENSIONS		XXX		
		DO NOT SCALE - WORK TO DIMENSIONS ONLY		XXX		
		THIRD ANGLE PROJECTION		TITLE: SHEET NO. 1 OF 4		
		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		DRAWING #: 538169-07		
		KIRK - RUDY, INC.		KIRK-RUDY, INC. KENNESAW, GEORGIA		

Drawing #

538153-01

ITEM NO	PART #	DESCRIPTION	REV NO	DATE	ECN NO	BY
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ITEM NO	PART #	DESCRIPTION
1	2	100306 BUSHING, FL.375 ID.500 OD.500 LG
2	1	102112 KNOB, PURCHASED
3	1	102306 SHIM, .375X .625X .031
4	1	102906 BEARING, LINEAR SLEEVE OPEN
5	1	104100 SNAP RING, .375
6	1	110163 SPRKT, 25611 .375B NK
7	1	110021-17 CHAIN, NO. 25 X 47.5 IN.
8	1	500341-2 SHAFT, LIFT
9	2	538146-01 BRACKET, SUPPORT
10	1	538147-01 SHAFT, VERTICAL SUPPORT
11	1	538149-01 HOUSING, LINEAR BEARING
12	1	538150-01 PLATE, VERTICAL MOUNT
13	1	538151-01 PLATE, SCREW SUPPORT
14	1	538152-01 PLATE, BOTTOM SUPPORT
15	1	538154-01 COVER, LINEAR SLIDE RH
16	1	538154-02 COVER, LINEAR SLIDE LH
17	1	538155-01 COVER, CHAIN
18	1	538167-01 PLATE, SHAFT SUPPORT



ITEM NO:	T JG	SCALE:	0.375	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	MATERIAL:	XXX	INCHES	MM	WEIGHT:	1.5	REMOVED FILE QUARTEERS AND SQUARES CAVITIES ON THIS SIDE OF THE MATERIAL	SP 81400	PRINT DATE:	10-JAN-00	PRINTED BY:	KIRK - RUDY, INC. KENNE SAW, GEORGIA
ITEM NO:																
ITEM NO:																

ITEM NO:	T	SCALE:	1.000	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	MATERIAL:	XXX	INCHES	MM	WEIGHT:	1.5	REMOVED FILE QUARTEERS AND SQUARES CAVITIES ON THIS SIDE OF THE MATERIAL	SP 81400	PRINT DATE:	10-JAN-00	PRINTED BY:	KIRK - RUDY, INC. KENNE SAW, GEORGIA
ITEM NO:																
ITEM NO:																

Drawing #

538153-01

ITEM QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECM NO	BY
1	1 02306	SHIM, .375X.625X.031					
2	1 02906	BEARING, LINEAR SLEEVE OPEN					
3	1 104100	SNAPRING, .375					
4	1 110163	SPRK, 25011 .375B NK					
5	1 500341-1	SHAFT, LIFT					
6	2 538 46-01	SHAFT, BRACKET SUPPORT					
7	1 538 47-01	SHAFT, VERTICAL SUPPORT					
8	1 538 49-01	HOUSING, LINEAR BEARING					
9	1 538 50-01	PLATE, VERTICAL MOUNT					
10	1 538 52-01	PLATE, BOTTOM SUPPORT					
11	1 538 54-01	COVER, LINEAR SLIDE RH					
12	1 538 54-02	COVER, LINEAR SLIDE LH					
13	1 538 67-01	PLATE, SHAFT SUPPORT					

SCALE 0.375

DRAWN BY: T J G SCALE 0.375

DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED

.00	.005	.005	.005
.01	.015	.015	.015
	ANG.	ANG.	ANG.

HEAT TREAT: XXX

MASTER M

REMOVED ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED

ALL DIMENSIONS ARE FINISHED

DO NOT SCALE WORK TO DIMENSIONS ONLY

DRAWING # 10F1

TITLE: ASSY, VERTICAL ADJ. LH

CHECKED BY:

TRACED BY:

DATE: 10 - Jan - 00

MODEL: SP81400

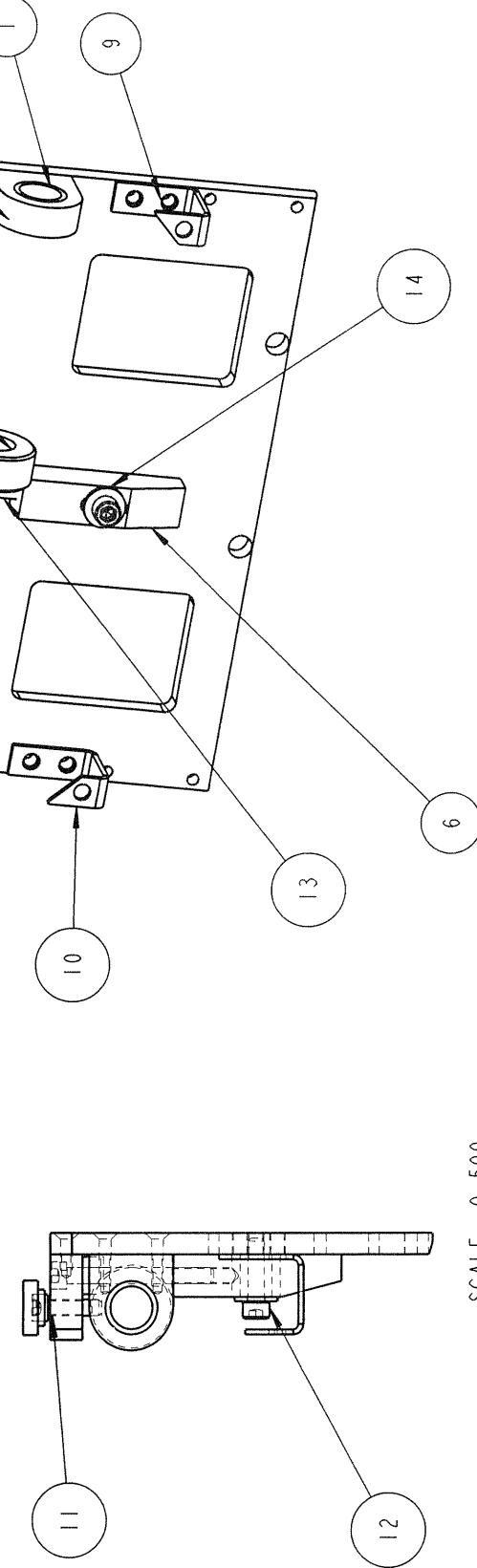
SHEET # 1 OF 1

WHERE USED: 1 SP81400

RECD WHERE USED: 1

KIRK - RUDY, INC.
KENNESAW, GEORGIA
KR

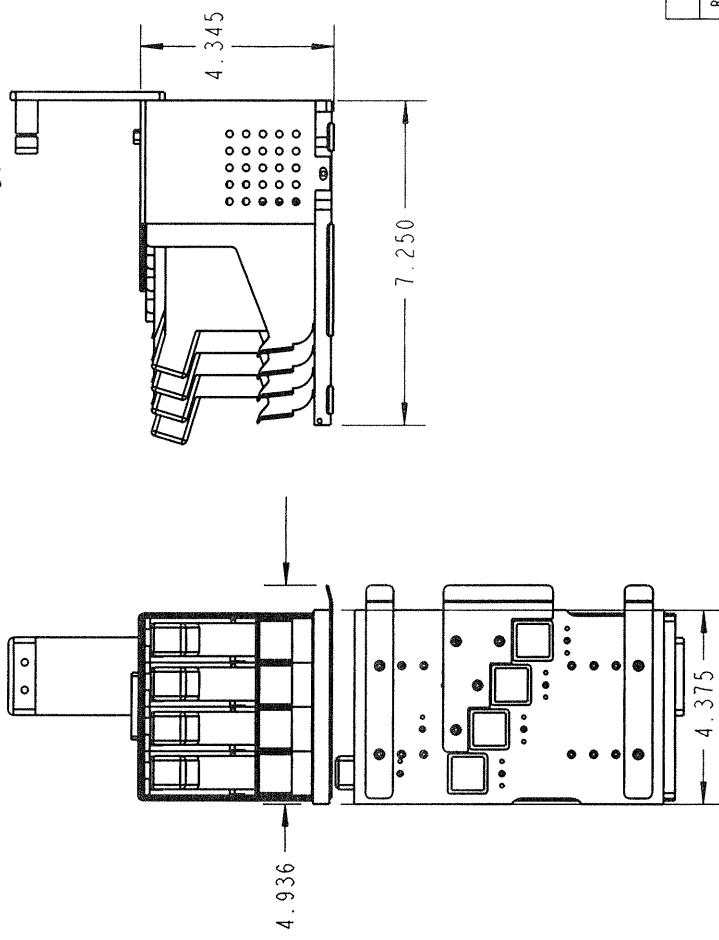
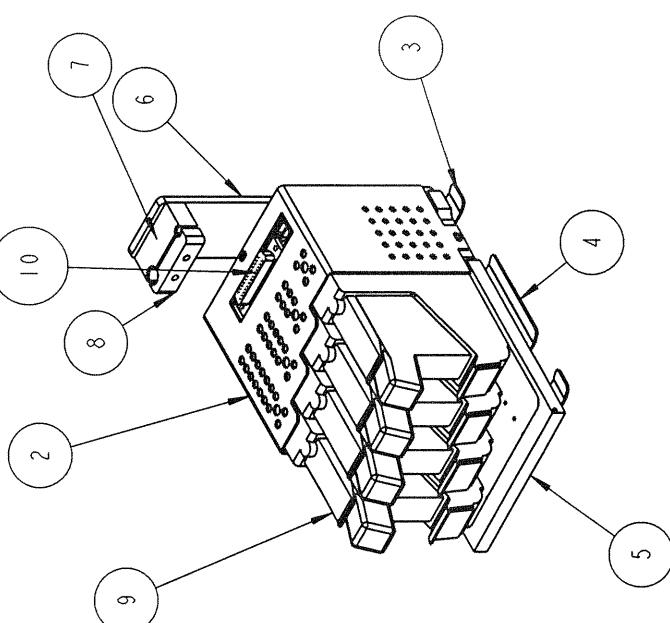
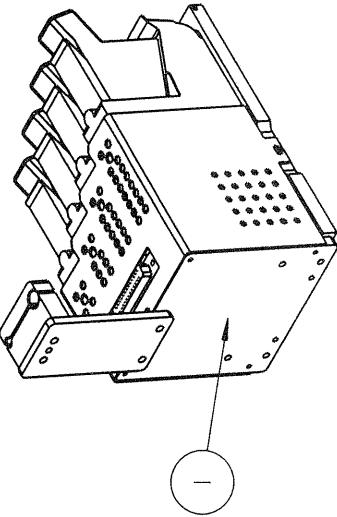
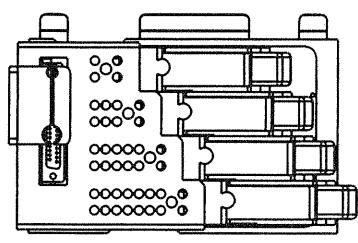
ITEM	QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	2	100133	BUSHING, SL. 500ID. 625OD. 375LG					
2	1	102132	KNOB, 10-32 CAP SCREW					
3	1	102210	COLLAR .188					
4	1	538270-04	PLATE, VERTICAL INKJET MNT.					
5	2	538271-01	BLOCK, BUSHING MOUNT					
6	1	538273-01	CAM, INKJET LEVEL					
7	1	538280-01	BLOCK, SLIDE LOCK					
8	1	538300-01	COLLAR, SLED LOCK					
9	1	538305-01	INDICATOR, SCALE RH					
10	1	538305-02	INDICATOR, SCALE LH					
11	1	CSDD266	SCREW, SHCS 10-32X.625					
12	1	CSDD267	SCREW, SHCS 10-32X.750					
13	1	CSDD272	SCREW, SHCS 10-32X1.750					
14	1	WA006	WASHER, FLAT #10					



DRAWN BY:	SCALE	0.500	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	.09-0C†-01	.xx .xxx .005 .005	HEAT TREAT: XXX	VIEW NO. SP93500	TITLE: ASSY, INKJET MOUNT
TRACED BY:	MASTER		REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED	FINISH: XXX	SHEET NO. 10F2	DRAWING # 538269-04
			ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY			

2	538169-07
REQ'D	WHERE USED

ITEM QTY	PART #	DESCRIPTION
1	1	538860-01 PLATE, CIRCUIT BOARD MOUNT
2	1	538861-01 COVER, CIRCUIT BOARD
3	2	538862-01 SKIDBAR, INKJET CARTRIDGE
4	1	538864-01 SKIDBAR, INKJET CARTRIDGE
5	1	538865-01 PLATE, INK CARTRIDGE MOUNT
6	1	538933-01 PLATE, WIRE CLAMP MOUNT
7	1	538934-01 CLAMP, WIRE
8	1	538934-02 CLAMP, WIRE
9	1	HP-CARTRIDGE
10	1	PRISM_BOARD - ALL



REV NO	DATE	DESCRIPTION	ECN NO	BY
2	538169-07	REO'D WHERE USED		

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KENNE SAW, GEORGIA
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KENNE SAW, GA
30144, USA

THIRD ANGLE PROJECTION
TITLE:
MODEL:
SHEET NO.:
10F2
DRAWING ■

ASSY, 4 HEAD MOUNT
538863-01

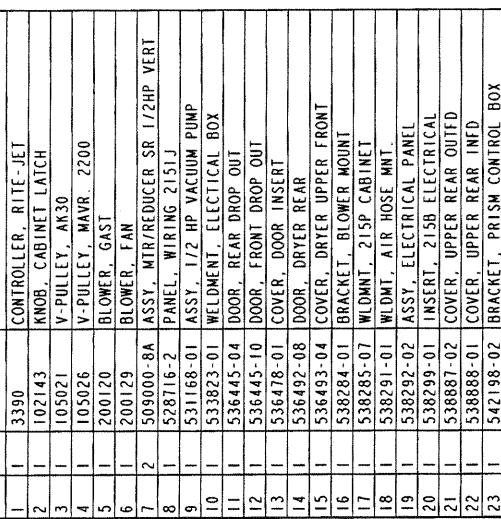
DRAWN BY:	SCALE	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	MATERIAL:	HEAT TREAT:	REMOVED ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED
T JG	0 .250	.xx .xxx .01 .005 .5	XXX	XXX	ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY
CHECKED BY:	DATE				
	16-JUL-01				

TRACED BY:	MASTER	SHEET NO.	OF	NUMBER
		10	2	538863-01

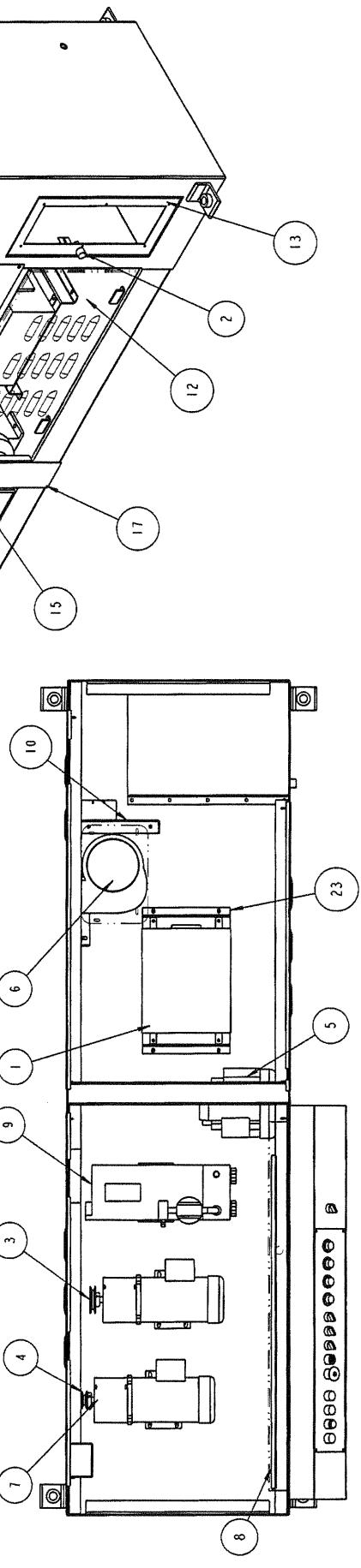
SHEET # 538288-07

ITEM #	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	REV NO	BY
--------	--------	-------------	--------	------	-------------	--------	----

1	1	3390			CONTROLLER, RITE-JET		
2	1	102143			KNOB, CABINET LATCH		
3	1	105021			V-PULLEY, AK30		
4	1	105026			V-PULLEY, MAVR. 2200		
5	1	200120			BLOWER, GAST		
6	1	200129			BLOWER, FAN		
7	2	509000-8A			ASSY, MTR/REDUCER SR 1/2HP VERT		
8	1	528716-2			PANEL, WIRING 2151J		
9	1	531168-01			ASSY, 1/2 HP VACUUM PUMP		
10	1	533823-01			WELDMENT, ELECTRICAL BOX		
11	1	536445-04			DOOR, REAR DROP OUT		
12	1	536445-10			DOOR, FRONT DROP OUT		
13	1	536478-01			COVER, DOOR INSERT		
14	1	536492-08			DOOR DRYER REAR		
15	1	536493-04			COVER, DRYER UPPER FRONT		
16	1	538284-01			BRACKET, BLOWER MOUNT		
17	1	538285-07			WLMNT, 215P CABINET		
18	1	538291-01			WLDMT, AIR HOSE MNT		
19	1	538292-02			ASSY, ELECTRICAL PANEL		
20	1	538299-01			INSERT, 215B ELECTRICAL		
21	1	538887-02			COVER, UPPER REAR OUTD		
22	1	538888-01			COVER, UPPER REAR INF		
23	1	542198-02			BRACKET, PRISM CONTROL BOX		



SCALE 0.090



SCALE 0.090

1	215P	RED WHERE USED
2	215P	RED WHERE USED
3	215P	RED WHERE USED
4	215P	RED WHERE USED
5	215P	RED WHERE USED
6	215P	RED WHERE USED
7	215P	RED WHERE USED
8	215P	RED WHERE USED
9	215P	RED WHERE USED
10	215P	RED WHERE USED
11	215P	RED WHERE USED
12	215P	RED WHERE USED
13	215P	RED WHERE USED
14	215P	RED WHERE USED
15	215P	RED WHERE USED
16	215P	RED WHERE USED
17	215P	RED WHERE USED
18	215P	RED WHERE USED
19	215P	RED WHERE USED
20	215P	RED WHERE USED
21	215P	RED WHERE USED
22	215P	RED WHERE USED
23	215P	RED WHERE USED

ITEM:	PRISM CONTROL BOX	TYPE & ANGLE PROJECTION
MADE IN:	UNITED STATES OF AMERICA	MATERIAL:
DATE:	18-0c 1 - 01	XX X
MAKER:	KIRK-RUDY, INC.	XX X
ADDRESS:	KENNESAW, GEORGIA	XX X
TIME:	10:14	XX X
SPCS:	SP-94000	XX X
SETUP:	10F1	XX X

DRAWN BY:	JG	SCALE	0 . 090	DIMENSIONS ARE IN INCHES
CHECKED BY:		DATE	XX	XX
MASTERS:	M	IN.	XX	XX
TRACED BY:		MM	XX	XX
		MM	XX	XX

SHEET # 538288-07

ITEM NO.	PART #	DESCRIPTION	REV AS	DATE	DESCRIPTION	ECN AS	BT
2	103804	BEARING, HUB .625					
2	108888	PULLEY, TIMING 12L050 .625B .188K					
3	1	503619					
4	1	509006	SHAFT				
4	1	509006	PLATE, REAR SIDE				
5	1	509007	PLATE, GEARBOX 1/2 HP SINGLE RED				
6	1	509037	COVER, REDUCER				
7	1	108912-1	BELT, TIMING 18L050				
8	1	109319-1	PULLEY, TIMING 32L050 .625B .188K				
9	1	200152-2	MOTOR, LEESON DC 1/2HP				
10	5	SPI6208	SPACER, REDUCER				

1 111
REV'D PREVIOUS

DRAWING 1 OF 1

1	111
REV'D PREVIOUS	
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OF KIRK-RUDY, INC.,	
WOODSTOCK, GEORGIA	
WOODSTOCK, GA 30088 USA	

KIRK-RUDY, INC.
WOODSTOCK, GEORGIA

DRAWING NUMBER:	
JG	
SCALE:	0 .500
DIMENSIONS IN INCHES	
IN	MM
.5	12.7
MATERIAL:	
N/A	
MANUFACTURER:	
NONE	
TIME:	
GENERAL	

DRAWING NO.: 3 - Nov - 98

ISSUED BY:	MASTER
CHECKED BY:	M
TRACED BY:	
SAFETY:	1 OF 1

PRINTED ON 3-NOV-98

ALL DIMENSIONS ARE
IN INCHES UNLESS
OTHERWISE NOTED

NOT SCALE - WORK
TO DIMENSIONS ONLY

ITEM QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECH NO	BY
1	190660	NIPPLE, 1/2 IN TUBING					
2	200102	VALVE, RELIEF GAST 822/823					
3	200108	STEM GAST 822/823					
4	200109	PLATE GAST 822/823					
5	200124	PUMP, VACUUM GAST					
6	501645	BLOCK, CONNECTOR (VACUUM PUMP)					
7	200100-1	GAUGE, VACUUM GAST 822/823					
8	200100-2	FILTER, VACUUM GAST 822/823					
9	200100-3	JAR, GLASS GAST 822/823					
10	200100-13	NIPPLE, STEEL					
11	200100-14	ELBOW, PIPE GAST 822/823					
12	200100-16	COUPLING GAST 822/823					
13	200100-21	NIPPLE, STEEL					
14	200100-22	COUPLING, STEEL					
15	200100-23	PLUG, SQUARE HEAD GAST 822/823					
16	200100-26	COVER FOR AB992 GAST 822/823					
17	200124-2	FILTER, FELT GAST 823					
18	200124-4	END CAP, AK510 GAST 823					
19	200124-5	MUFFLER, SINTERED GAST 823					
20	200124-6	O-RING, GASKET GAST 823					

REO'D	WHERE USED
1	215
REO'D	WHERE USED
1	KIRK - RUDY, INC. KIRK KENNESSAW, GEORGIA KENNESSAW, GA 30144 USA
1	ASSY, 1/2 HP VACUUM PUMP DRAFTING #
1	531168-01

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OF KIRK-RUDY, INC.
KENNESSAW, GA 30144 USA

THIRD ANGLE PROJECTION

NOTED	MATERIAL:	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED
		.XX .XXX .005 .5
		HEAT TREAT:
	NONE	
		REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED
		ALL DIMENSIONS ARE FINISHED DIMENSIONS
		DO NOT SCALE - WORK TO DIMENSIONS ONLY

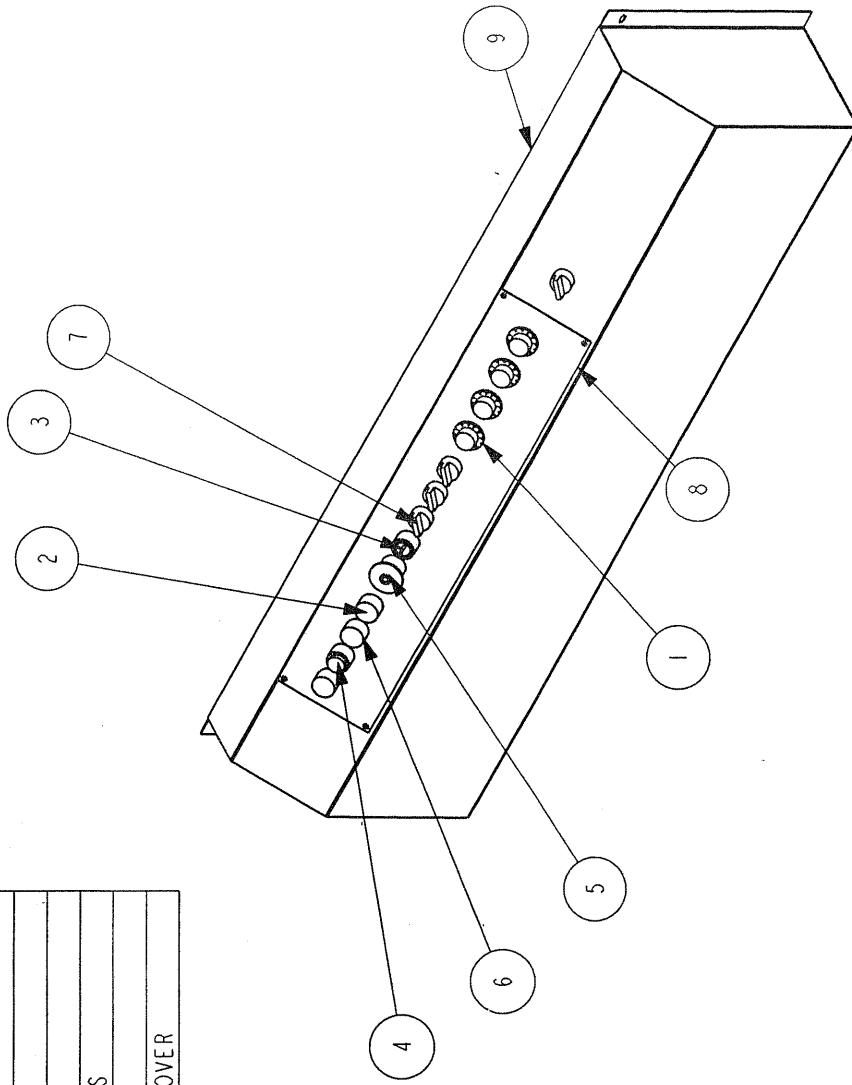
DRAWN BY: MY DATE: 20 - Jun - 97

CHECKED BY: TRACED BY: M

SHEET NO. 10F1

MASTER

ITEM QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	4	209016 KNOB, POT					
2	1	201124-2 BUTTON, START					
3	1	201124-4 BUTTON, POWER ON					
4	1	201125-3 BUTTON, STOP					
5	1	201125-5 BUTTON, POWER OFF					
6	2	201126-1 BUTTON, JOG					
7	4	201145-1 SELECTOR, 2 POSITIONS					
8	1	500421-1 PNL, CONTROL					
9	1	538293-02 WLDMT, CONTROL BOX COVER					



I	538288-07
REO D WHERE USED	
 KIRK - RUDY INC. KENNEDY SAW, GEORGIA	
DRAWN BY: T JG SCALE: 0 . 125 DIMENSIONAL TOLERANCES: UNLESS OTHERWISE NOTED .01 .005 .5	
CHECKED BY: DATE: 18-0C1-01 MATERIAL: N/A THIRD ANGLE PROJECTION: NO PART AND THIS DRAWING MAY BE QUOTED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY INC. REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED	
TRACED BY: MASTER: M FINISH: N/A MODEL: 215P TITLE: ASSY, ELECTRICAL PANEL ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY	
SHEET NO: 10F1 DRAWING #: 538292-02	

7 ELECTRICAL SCHEMATICS AND PARTS

7.1 SCHEMATIC LIST

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

109 500 33-00

7.2 PARTS LIST

8 APPENDIX

8.1 POSSIBLE OPTIONS

The KR215P base can be modified to handle a variety of applications, contact your Kirk-Rudy dealer or call Kirk-Rudy direct to discuss your specific application.

Here is a list of some of the options offered for the KR215P base:

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

9 NOTES

10 WARRANTY AND SERVICE

WARRANTY

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

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

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

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

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

USE ONLY GENUINE KIRK-RUDY REPLACEMENT PARTS

KIRK-RUDY, INC.
125 LORRAINE PARKWAY
WOODSTOCK, GA. 301448844
770-427-4203
FAX 770-427-4036
WWW.KIRKRUDY.COM