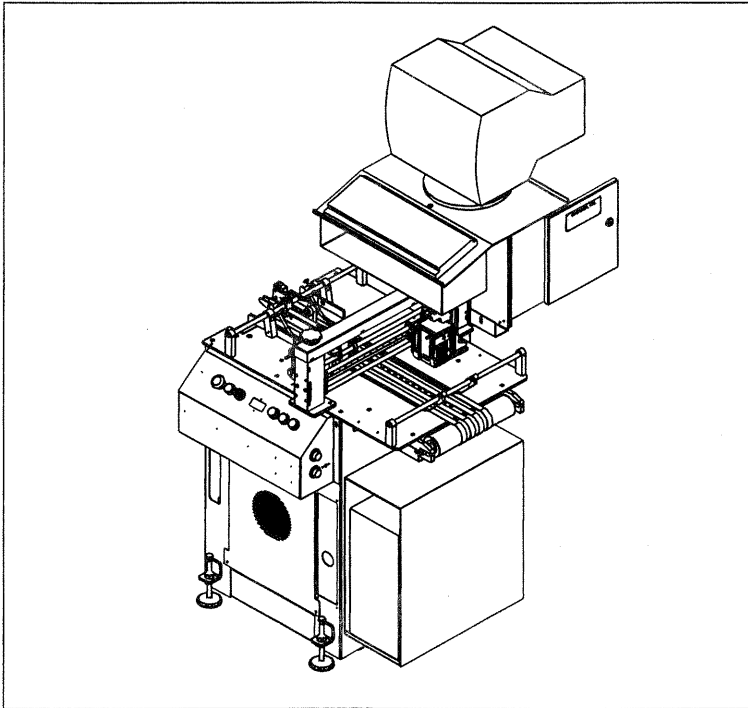


Kirk-Rudy, Inc.

Instruction and Parts Manual

KR319N NetJet



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.

10000-319N REV. 1 03/07/05

Manual

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

1 Important Safety Instructions

Usage for other purposes may lead to unsafe condition.

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



WARNING

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

2 SPECIFICATIONS

ELECTRICAL

110 VAC, 50/60Hz, Single Phase, 15 amp

PHYSICAL SIZE

	<u>ENGLISH</u>	<u>METRIC</u>
Length:	32.25"	82 cm
Width:	29.44"	75 cm
Height: (TABLETOP)	33.5"	85 cm
Weight:		

Shipping:

PRODUCTS

Minimum Size: 3"W X 5"L

Maximum Size 15" W X 9" L

*Limited print area

3 INSTALLATION

3.1 UNCRATING AND UNPACKING



WARNING

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

The machinery is crated. Remove machines and all packaging from crates. Note: Some boxes are located inside the base cabinet.

Note: A forklift should be used to lift machine from pallet.

The Base is mounted on rollers.

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 ASSEMBLY OF BASE

NOTE: Read all Safety and Operating Instructions contained in this manual before beginning operation and assembly.

1. Locate machine in final location and mount the (4) 4" leveling screws and pads on the corners of the machine.

4 OPERATING INSTRUCTIONS

4.1 BASE – ELECTRICAL OPERATION

4.1.1 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 & 2)**

Main Power Off Button (red, white circle, yellow plate): Pressing this button cuts the power to the entire machine. Twist to unlatch.

Main Power On Button: When this two-position switch is depressed, source voltage is supplied to the electrical panel and button will light up. This will make all of the switches on the electrical control panel active.

Stop Button (red plate): Machine operation can be manually stopped by depressing the stop button on the operator panel. Twist to unlatch.

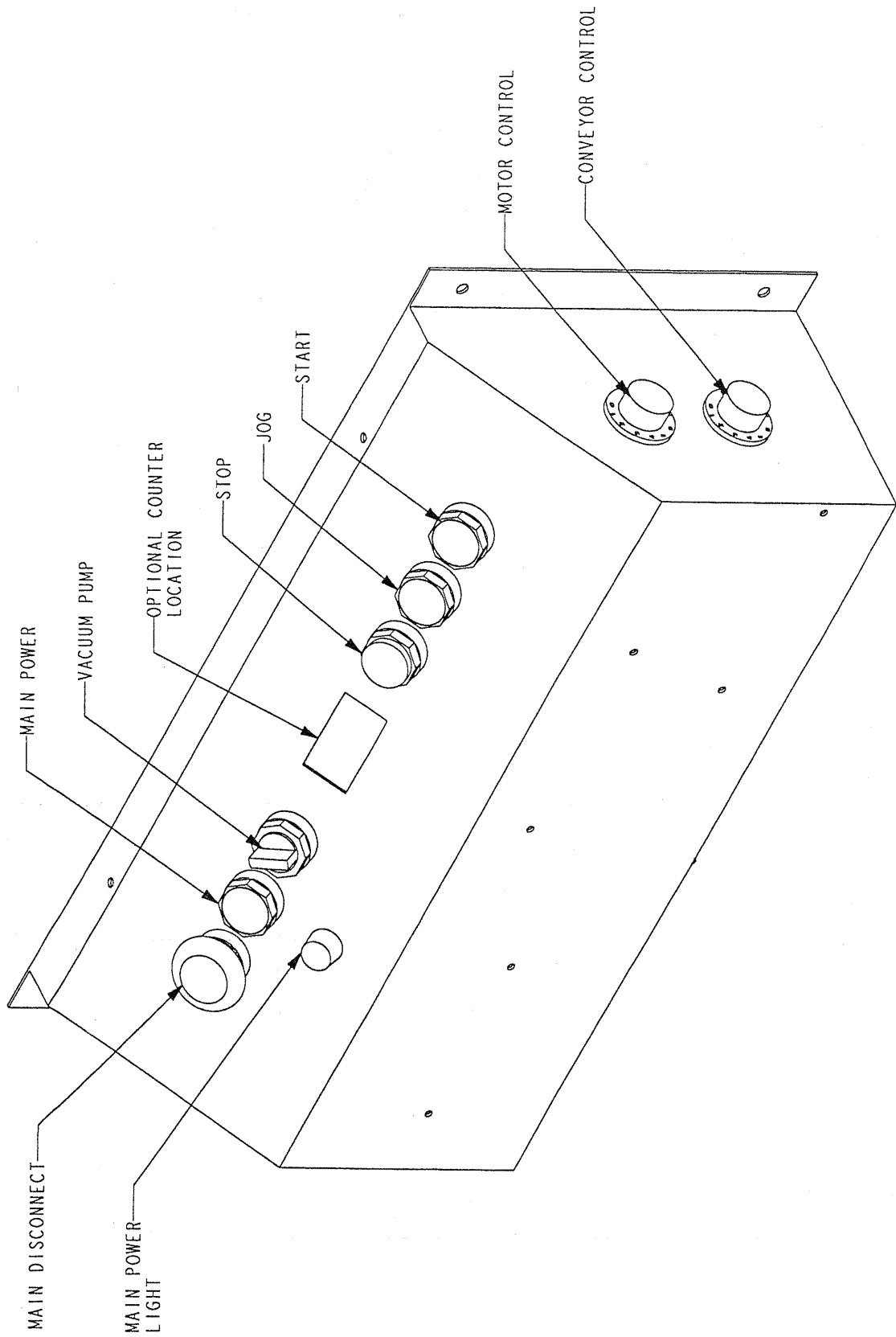
Jog Button (black): The machine can be inched or jogged by depressing and releasing this button. The machine will continue to cycle if this button is held depressed.

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

Speed Control, Table Conveyor: The knob controls the speed of the belts on the table. This speed should be set slightly greater than the feeder speed. Turn knob clockwise to increase belt speed, counterclockwise to decrease.

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 319N mode switch. The rest of the machine past the feeder will continue to operate.

Printer Switch: On/Off switch for NetJet Printer.



OPERATOR CONTROLS
FIGURE 2.0

4.1.2 PLUG INTERFACES

Plug Description	Plug Type
NetJet controller interface Plugs (see figure #1)	
NetJet/319N	8-Pin
Encoder	9-Pin
Product Beamswitch	4-pin
Stop In	2-pin Turck
Power Supply Plugs:	
120 Vac, 8 Amp	Standard 120VAC Outlet
Stop Plug:	
Conveyor Stop: Contact Closure	Male 3-Pin Twist Stop Out Socket

Netjet Controller Output Signals

Conveyor Speed Up: The conveyor speed up/stacker cycle output signal is used for two different functions depending on which machine is placed inline with the 319N. The conveyor speed up is used to control speed up on a shingle conveyor for address breaks. The NetJet controller determines the amount of time for the speed up.

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

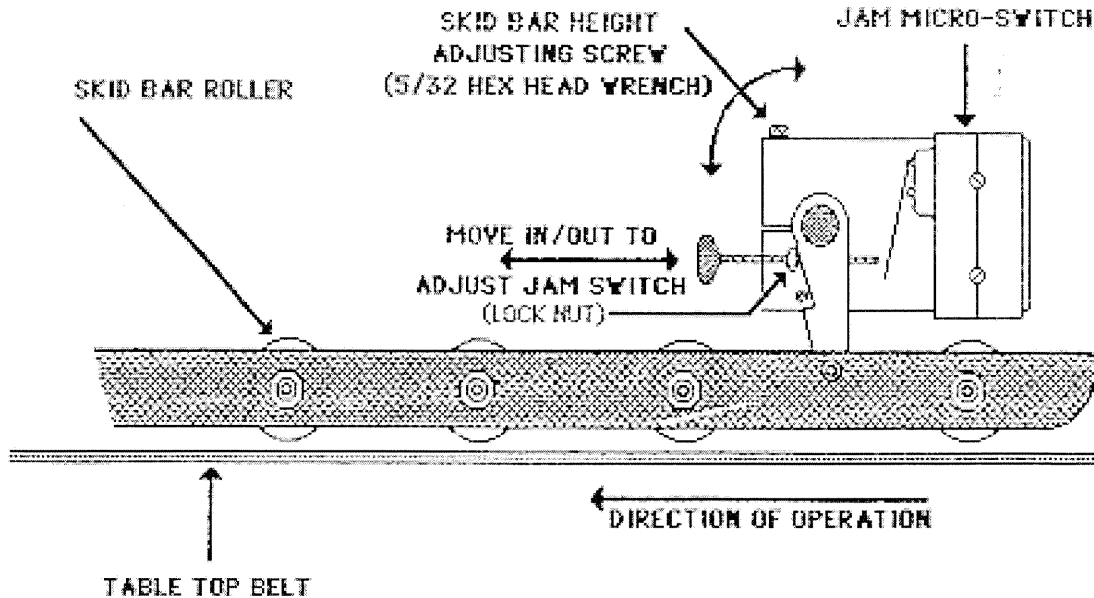
Side Guides:

Position side guides to within 1/8" of mailing piece as it is propelled across entire tabletop. Rotate the two knurled hand knobs at each end of the side guides and rotate ¼ turn counterclockwise to allow movement of guides--to lock, rotate knobs clockwise while twisting with slight pressure. Each side guide can be pivoted left to right by loosening the allen screws in side guide mounting blocks--when pivoted the guide will raise and allow clearance between table belts and label head pressure rollers. (Caution: Do not position guides directly over table belt(s) or label head pressure roller(s). The guide mounting screws can be left slightly loose for faster set-up when guide movement is required.

4.2 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 KR215B 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).

5 PARTS LISTS AND DIAGRAMS

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

Item #	Qty	Part #	Description
1	4	100133	BUSHING, SL.500ID.625OD.375LG
2	2	100162	BUSHING, SL.500ID.625OD.625LG
3	2	100306	BUSHING, FL.375ID.500OD.500LG
4	2	100338	BUSHING, FL1.000ID1.250OD1.500LG
5	1	102112	KNOB
6	1	102114	KNOB
7	2	102132	KNOB, 10-32 CAP SCREW
8	1	102205	COLLAR .500
9	2	102210	COLLAR .188
10	2	102306	SHIM, .375X.625X.031
11	4	102792	SPRING, EXTENSION
12	2	102906	BEARING, LINEAR SLEEVE OPEN
13	2	103107	BEARING, FLAT .312
14	4	103804	BEARING, HUB .625
15	2	104100	SNAPRING, .375
16	1	105201	PIN, ROLL .125X 1.000
17	8	105419	DOWEL, PIN .188X1.000
18	1	105602	SHAFT, THREADED 10-32
19	1	109319	PULLEY, TIMING 32L050 .625B .188K
20	1	109847	PULLEY, 28XL037 .625B NK
21	1	109848	PULLEY, 26XL037 .375B NK
22	1	109953	TIMING PULLEY, 12L050, NO HUB
23	2	110163	SPRKT, 25B11 .375B NK
24	1	190101	MICROSWITCH, LEVER
25	1	190203	COVER, MICROSWITCH
26	1	190234	LIGHT INDICATOR
27	4	190634	FOOT, MOUNTING
28	2	190669	CASTER, 3.500 RIGID
29	2	190670	CASTER, 3.500 SWIVEL
30	2	190771	SCALE, CENTER ZERO
31	4	191002	ANGLE, LEVELING LEG SUPPORT
32	4	191004	LEG, BASE ASSEMBLY
33	4	191214	BOARD, INTERFACE TERMINAL
34	1	191227	ETHERNET HUB SWITCH
35	1	200129	BLOWER, FAN
36	1	200501	RECEPTACLE, AMPHENOL 4 PIN
37	1	201121	BUTTON, START
38	1	201122	BUTTON, STOP
39	1	201123	BUTTON, JOG
40	1	201145	SELECTOR, 2 POSITIONS
41	1	202492	ENCODER, ACCU-CODER 1000PPR
42	1	202531	POWER SUPPLY
43	1	202532	BOARD I/O 110V
44	4	208517	SPACER, .17ID .37OD .63LG

45	2	209016	KNOB, POT
46	2	209286	RELAY, ODC15
47	4	500791	POST, SIDEGUIDE
48	2	500792	POST, SIDE GUIDE
49	1	500800	LINK-SKID-FRONT
50	1	500801	LINK-SKID-REAR
51	1	500802	HOLDER-SKID SWITCH
52	1	500823	SHAFT, IDLER ROLLER
53	2	500834	SHAFT, SKID ROLLER
54	1	500835	ROLLER, BELT IDLER
55	2	500836	HUB
56	2	500839	HUB-BELT DRIVE
57	4	501629	CLAMP, GUIDE STRIP
58	1	503794	CLAMP
59	1	508593	CLAMP
60	4	102131-5	KNOB
61	4	105901-19	BELT, GREEN 3/4 X 68.75
62	1	108988-1	BELT, TIMING 540L050
63	1	109006-1	BELT, TIMING 150XL037
64	1	110021-17	CHAIN, NO. 25 X 47.5 IN.
65	1	190619-1	PLATE, NAME
66	1	190689-1	DOOR LATCH
67	1	191029-1	PUMP, MOVOTEC PB4612FC
68	4	191029-2	CYLINDER, LIFT CB415
69	4	191029-3	GLIDE, SUSPA
70	2	191195-1	HEAD, NETJET 1.5IN
71	2	191195-2	HEAD, NETJET 1.5IN
72	2	191195-3	HEAD, NETJET 1.5IN
73	2	191195-4	HEAD, NETJET 1.5IN
74	1	200170-2	MOTOR, 1/8HP DC GEAR
75	5	200503-3	RECEPTACLE, 8 PIN MALE
76	1	200512-1	RECEPTACLE, 9 PIN MALE
77	1	201124-1	BUTTON, POWER
78	1	201125-2	BUTTON, MUSHROOM STOP
79	1	201563-1	SWITCH, POWER
80	1	202734-1	BASE FLKM-2I/O
81	1	208503-5	FAN, CONTROL BOX 115V 3.1" SQUARE
82	1	208504-2	GUARD, FINGER
83	1	208505-1	FAN GUARD, 3.125"
84	1	500341-1	SHAFT, LIFT
85	1	500341-2	SHAFT, LIFT
86	1	500722-24	L RAIL, GUIDE LH
87	1	500722-24	R RAIL, GUIDE RH
88	1	500723-8	CHANNEL, SKID
89	2	500725-13	GUIDE, BELT 3/4
90	1	500725-17	GUIDE, BELT
91	1	500742-4	ROLLER, TUBE BELT DRIVE
92	2	500787-6	SHAFT, SIDE GUIDE ADJ
93	1	500824-7	SHAFT-BELT GUIDE
94	4	501812-1	LEG, LEVELING

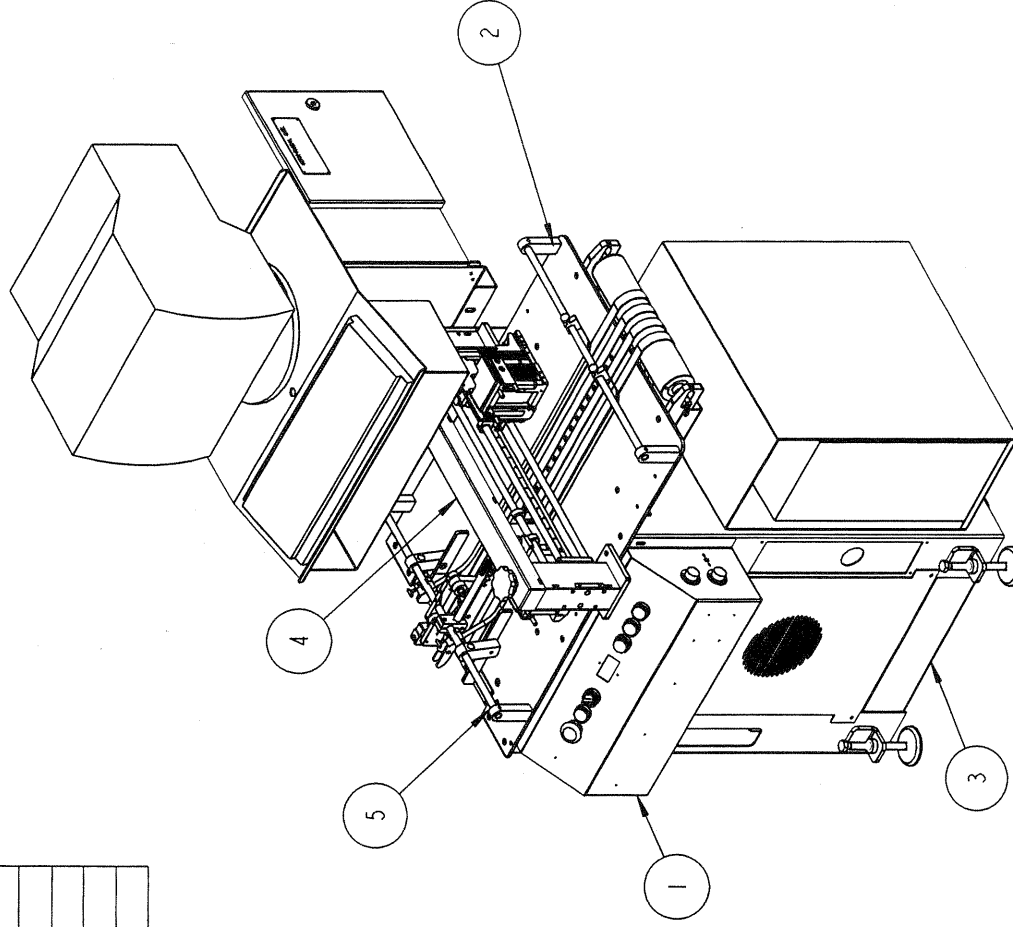
95	1	508995-7	SHAFT, BEAMSWITCH MOUNT
96	1	508996-2	PHOTOCELL BRACKET
97	1	528247-2	BOX, CONTROL
98	1	530441-01	BOX, ELECTRICAL INLET 20A
99	1	531024-03	PANEL, INFEED END
100	1	531025-03	PANEL, OUTFEED END
101	2	531026-03	ANGLE, CROSS SUPPORT
102	1	531027-02	BASE, CABINET
103	1	531028-11	PANEL, ELECTRICAL
104	1	531028-13	PNL, BACK R/H
105	1	531033-07	TABLETOP, VACUUM CONVEYOR
106	1	531034-04	SHAFT, ROLLER DRIVE
107	1	531678-02	BAR, SCALE SUPPORT
108	1	531987-02	PNL, ELECT. OUTLET CVR.
109	1	532115-04	UP-RIGHT, CENTER
110	1	532128-02	TRAY, KEYBOARD
111	1	532153-01	TUBING, VERTICAL
112	1	532154-01	HOUSING, PIVOT
113	1	532157-01	SPACER, PIVOT
114	2	532163-01	STAND, BELT GUIDE
115	1	532164-01	BRACKET, INTERFACE
116	1	532467-01	SHAFT, DRYER PIVOT
117	1	532475-01	MOUNT, MOTOR
118	4	537371-01	BRACKET, SPRING RETURN MOUNT
119	4	537596-01	BLOCK, HYDRAULIC LIFT LH
120	4	537596-02	BLOCK, HYDRAULIC LIFT RH
121	2	537597-01	BRACKET, HYDRAULIC LIFT SPRING
122	2	537597-02	BRACKET, HYDRAULIC LIFT SPRING
123	4	538146-01	SHAFT, BRACKET SUPPORT
124	2	538147-01	SHAFT, VERTICAL SUPPORT
125	2	538149-01	HOUSING, LINEAR BEARING
126	2	538150-01	PLATE, VERTICAL MOUNT
127	1	538151-01	PLATE, SCREW SUPPORT
128	2	538152-04	PLATE, INKJET STAND MOUNT
129	2	538154-01	COVER, LINEAR SLIDE RH
130	2	538154-02	COVER, LINEAR SLIDE LH
131	1	538155-01	COVER, CHAIN
132	2	538167-01	PLATE, SHAFT SUPPORT
133	4	538168-01	SHAFT, HEAD SUPPORT
134	2	538178-01	STRAP, RIBBON CLAMP
135	2	538270-01	PLATE, VERTICAL INKJET MNT.
136	4	538271-01	BLOCK, BUSHING MOUNT
137	2	538273-01	CAM, INKJET LEVEL
138	2	538280-01	BLOCK, SLIDE LOCK
139	2	538300-01	COLLAR, SLED LOCK
140	2	538305-01	INDICATOR, SCALE RH
141	2	538305-02	INDICATOR, SCALE LH
142	1	538343-01	TRAY, MOUSE PAD
143	1	538502-01	BOX, COMPUTER TOWER
144	1	538502-02	FLAT PANEL, COMPUTER TOWER

145	4	540185-01	PLATE, NETJET HEAD MOUNT
146	1	541023-01	PLATE, ENCODER MOUNT
147	1	541024-01	BRACKET, ENCODER MOUNT
148	1	542188-01	PANEL, BLOWER BOX MOUNT
149	1	542190-01	BRACKET, BLOWER MOUNT
150	1	542191-01	DOOR, BLOWER BOX
151	2	542192-01	BRACKET, L DOOR STOP
152	2	542194-01	FRAME, 319W
153	1	542195-01	TRAY, VACUUM
154	1	542196-01	COVER, BELTS OUTFEED
155	1	542198-04	BRACKET, NETJET BOX
156	2	542871-01	STRAP, 319B 3/8 X 29 IN.
157	2	544426-01	BAR, INFEED SKIDPLATE MOUNT
158	8	544431-01	RAISER, PIN
159	4	544432-01	RAISER, CLIP
160	2	544433-02	SKIDPLATE, WIDE
161	1	546002-01	BOX, ELECTRICAL
162	1	546003-01	DOOR, HINGED ELECTRICAL BOX
163	1	546004-01	PANEL, WIRING
164	1	546005-01	HINGE, 11IN LG
165	2	546006-01	PANEL, FLANGE
166	2	546009-01	MOUNT, I/O BOARDS
167	1	546010-01	SHAFT, .25 DIA
168	1	546012-01	PLATE, CONNECTORS
169	1	546013-01	PLATE, POWER SUPPLY
170	1	COMPUTER	CPUCOMPUTER, CPU TOWER
171	1	DINRAIL-0	1 DIN RAIL, 2.5" LG
172	1	KEYBOARD	KEYBOARD
173	1	MONITOR	15 IN. MONITOR
174	2	SP37359	SHAFT, SKID BAR SPACER

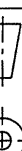

KR319N

ITEM	QTY	PART #	DESCRIPTION
1	1	533132-01	ASSY, 324M CONTROL BOX
2	1	533195-04	ASSY, 319 WINKJET CONVEYOR
3	1	533196-07	ASSY, CABINET & COVERS
4	1	538169-21	ASSY, NETJET PRINT MOD W/AB
5	1	538188-04	ASSY, SKIDBAR/SENSOR

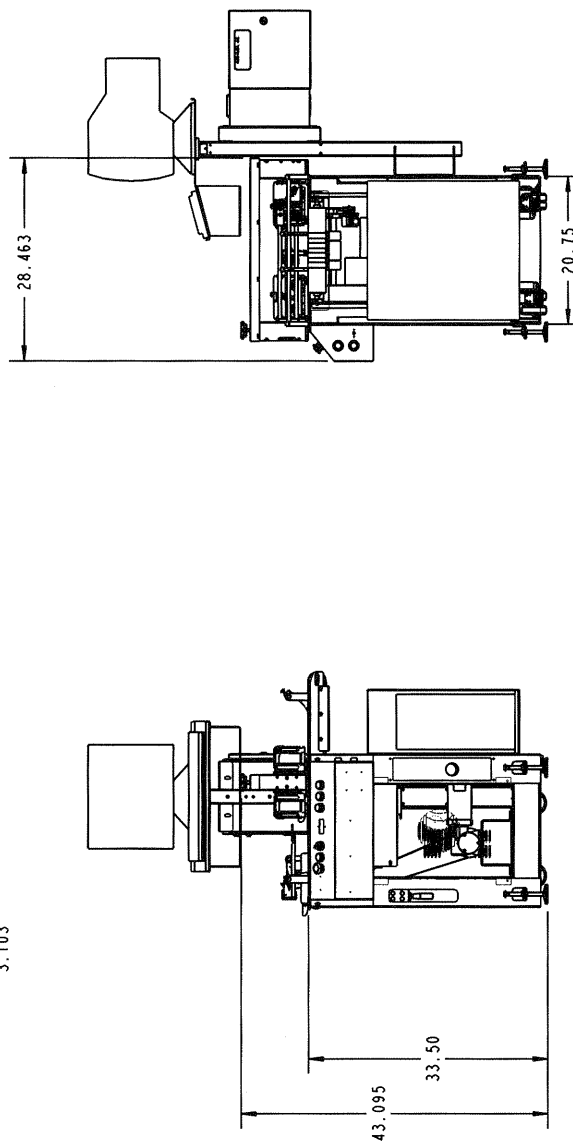
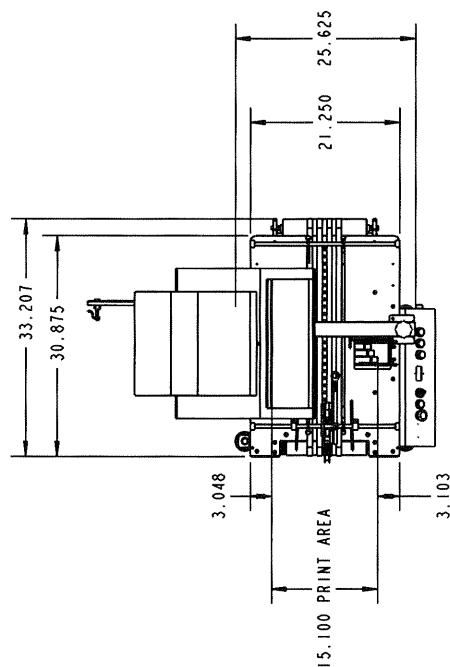
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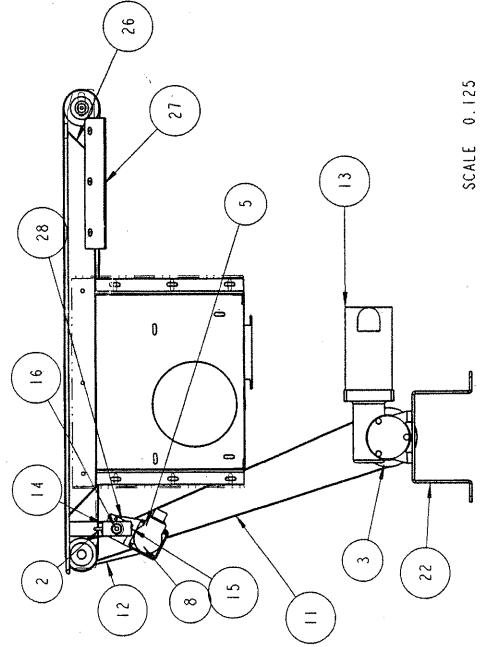
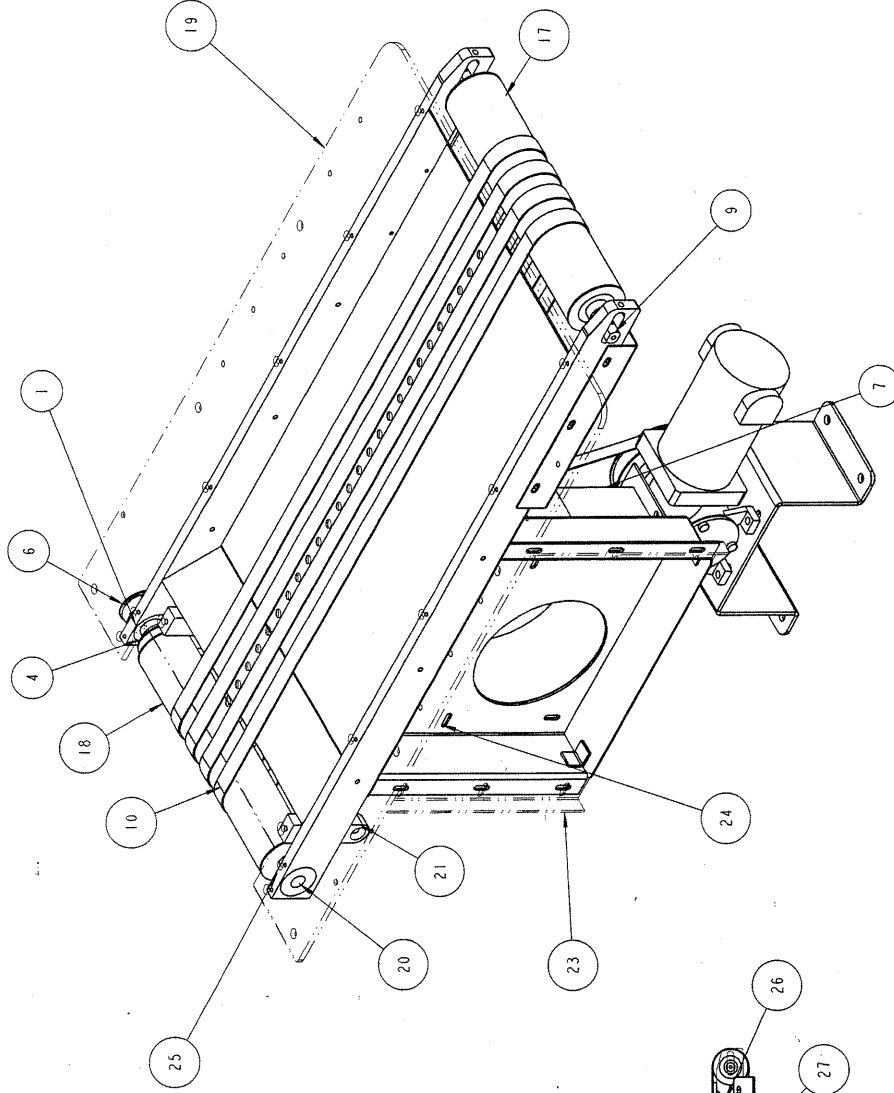
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DRAWING 1

533195-04

REV NO	DATE	DESCRIPTION	ECN NO	BY
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ITEM QTY	PART #	DESCRIPTION
1	2	103804 BEARING, HUB, 625
2	8	105419 DOWEL, PIN, 188X1.000
3	1	109319 PULLEY, TIMING 32L050 625B 188K
4	1	109847 PULLEY, 28X1037 625B MK
5	1	109848 PULLEY, 26X1037 375B MK
6	1	109953 TIMING PULLEY, 12L050, NO HUB
7	1	200129 BLOWER, FAN
8	1	202492 ENCODER, DYNAPAR 1000PPR
9	1	500823 SHAFT, IDLER ROLLER
10	4	105901-19 BELT, GREEN 3/4 X 68.75
11	1	108988-1 BELT, TIMING 540L050
12	1	109006-1 BELT, TIMING 150X1037
13	1	200170-2 MOTOR, 1/8HP DC GEAR
14	2	500725-13 GUIDE, BELT 3/4
15	1	500725-17 GUIDE, BELT
16	1	500824-7 SHAFT-BELT GUIDE
17	1	500835-A ASSY, TUBE ROLLER
18	1	530676-06 ASSY, DRIVE ROLLER
19	1	531033-07 TABLETOP, VACUUM CONVEYOR
20	1	531034-04 SHAFT, ROLLER DRIVE
21	2	532163-01 STAND, BELT GUIDE
22	1	532475-01 MOUNT, MOTOR
23	1	542188-01 PANEL, BLOWER BOX MOUNT
24	1	542189-01 WDMT, BLOWER BOX W/DOOR
25	2	542194-01 FRAME, 319W
26	1	542195-01 TRAY, VACUUM
27	1	542196-01 COVER, BELTS OUTFEED
28	1	SP45241-10 PLATE, ENCODER MOUNT



SCALE 0.125

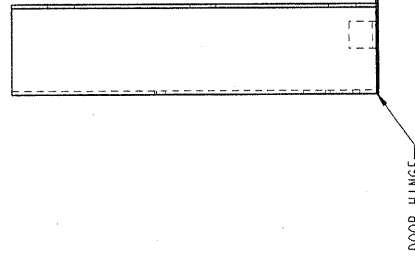
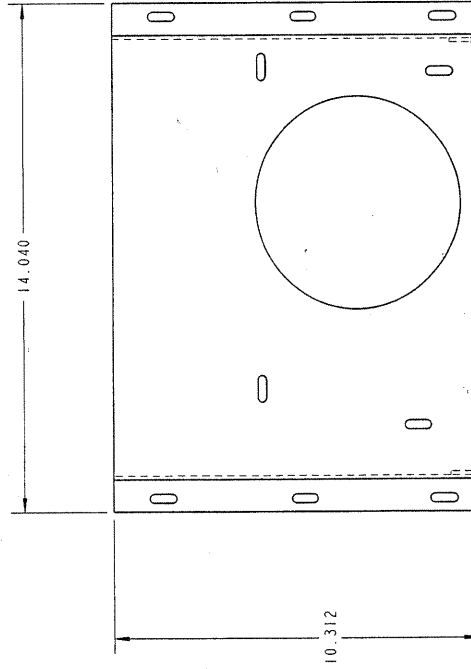
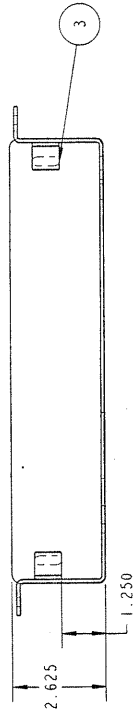
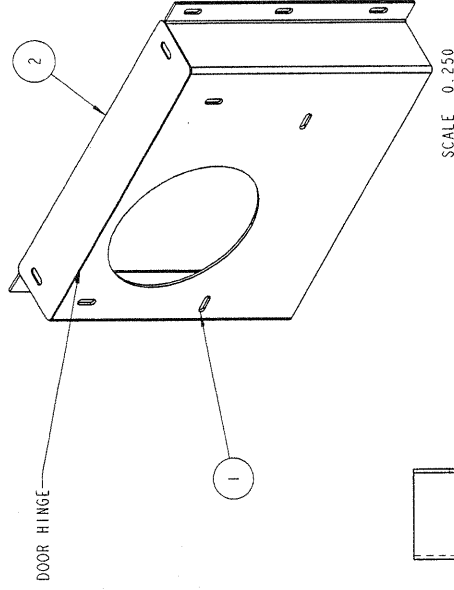
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TRACED BY:	MASTER: M	FINISH: NOTED	SHEET NO: 1 OF 2	DRAWING NO: 533195-04

DRAWING 1

542189-01

ITEM	QTY	PART #	DESCRIPTION
1	1	542190-01	BRACKET, BLOWER MOUNT
2	1	542191-01	DOOR, BLOWER BOX
3	2	542192-01	BRACKET, L DOOR STOP

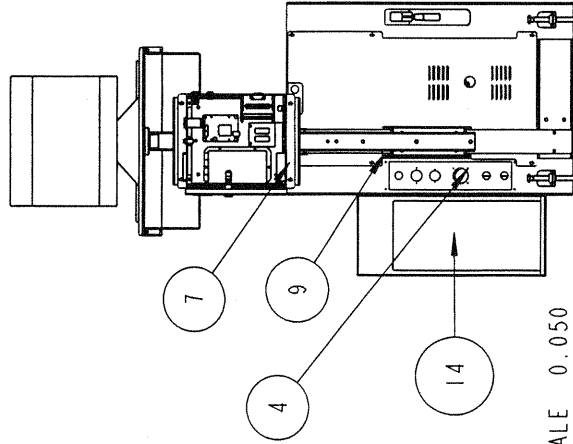
REV	NO	DATE	DESCRIPTION	CON	BY
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DATE BY: T JG	SCALE: 0.312	DIMENSIONAL TOLERANCES: UNLESS OTHERWISE NOTED	MATERIAL: XXX	THIRD ANGLE PROJECTION	PROPERTY: THIS CONFIDENTIAL PROPERTY MAY BE LOANED OR REPRODUCED FOR ANY PURPOSE WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK - RUDY, INC. KENNESAW, GA 30144 USA	REV'D: WHERE USED
CHECKED BY:	DATE: 18-Dec-01	REWORK: ALL DIMENSIONS ARE FINISHED DIMENSIONS UNLESS OTHERWISE NOTED	HEAT TREAT: XXX	MODEL: SP91900	TITLE: WIDMT, BLOWER BOX W/DOOR	533195-04
TRACED BY:	MASTER: M	ALL DIMENSIONS ARE FINISHED DIMENSIONS UNLESS OTHERWISE NOTED	FINISH: PAINT	SHEET NO: 1 OF 1		

DRAWING 1
542189-01

ITEM	QTY	PART #	DESCRIPTION
1	4	190634	FOOT, MOUNTING
2	1	191029-1	PUMP, MOVOTEC PB4612FC
3	4	501812-1	LEG, LEVELING
4	1	530441-01	BOX, ELECTRICAL INLET 20A
5	1	531023-05	WLDMT, 319B BASE CABINET
6	1	531028-11	PANEL, ELECTRICAL
7	1	531028-13	PNL, BACK R/H
8	1	531987-02	PNL, ELECT. OUTLET CVR.
9	1	532115-04	UP-RIGHT, CENTER
10	1	532152-20	ASSY, MONITOR STAND NETJET
11	1	538502-03	WLDMT, COMPUTER BOX
12	2	539424-01	ASSY, RH HYDRALIFT LEG
13	2	539425-01	ASSY, LH HYDRALIFT LEG
14	1	COMPUTER_C	COMPUTER, CPU TOWER



NOTES:
1. HYDRALIFT OPTIONAL

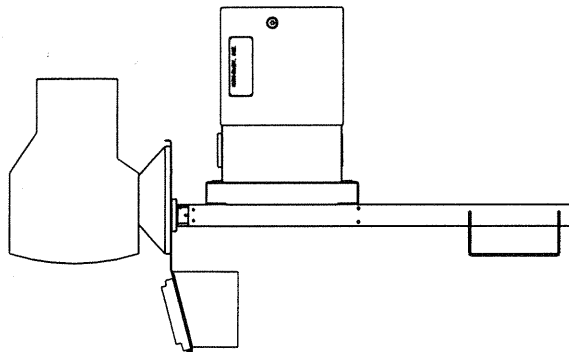
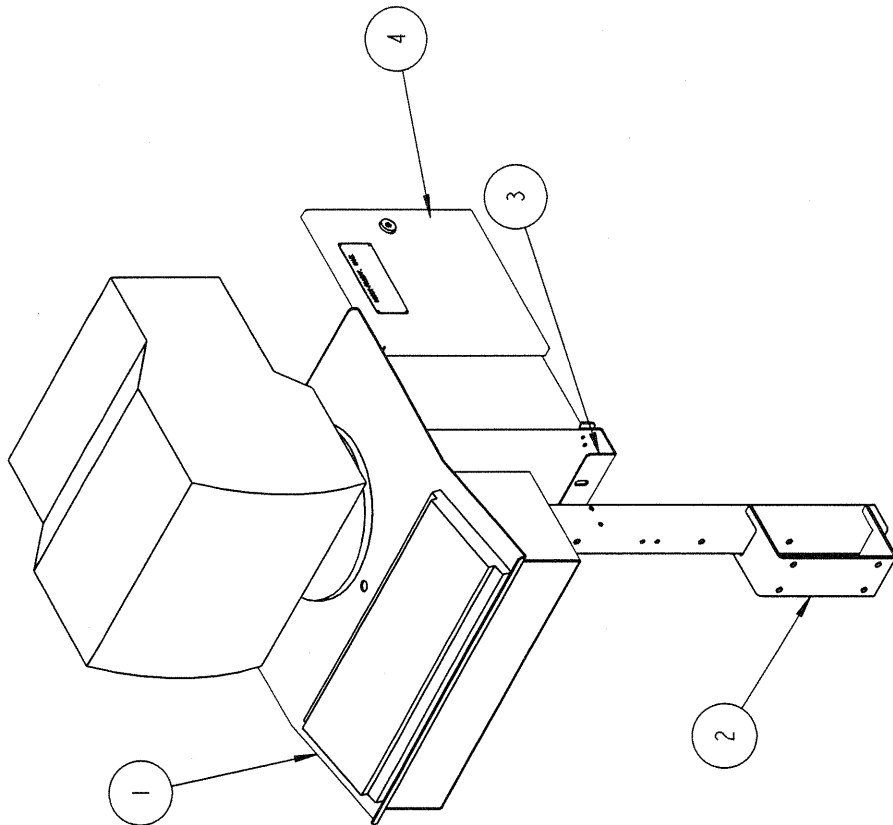
SCALE 0.050

1	319N
REC'D	WHERE USED

DRAWN BY: CMC	SCALE 0.060	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED .XX .XXX ANG. .01 .005 .5	MATERIAL: N/A	THIRD ANGLE PROJECTION	PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE QUOTED OR REPRODUCED WITHOUT THE WRITTEN PERMISSION OF KIRK-RUDY, INC. KENNESAW, GA 30144 USA	KIRK - RUDY, INC. KENNESAW, GEORGIA
CHECKED BY:	DATE 07-Mar-05	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY	HEAT TREAT: N/A	MODEL: 319N	TITLE: ASSY, CABINET & COVERS	
TRACED BY:	MASTER m		FINISH: N/A	SHEET NO: 10F1	DRAWING # 533196-07	

ITEM	QTY	PART #	DESCRIPTION
1	1	532155-02	ASSY, MONITOR PIVOT
2	1	536586-02	WLDMT, MONITOR STAND
3	1	542198-04	BRACKET, NETJET BOX
4	1	546008-01	PRINT CONTROL MODULE NETJET 110V

REV NO	DATE	DESCRIPTION	ECN NO	BY
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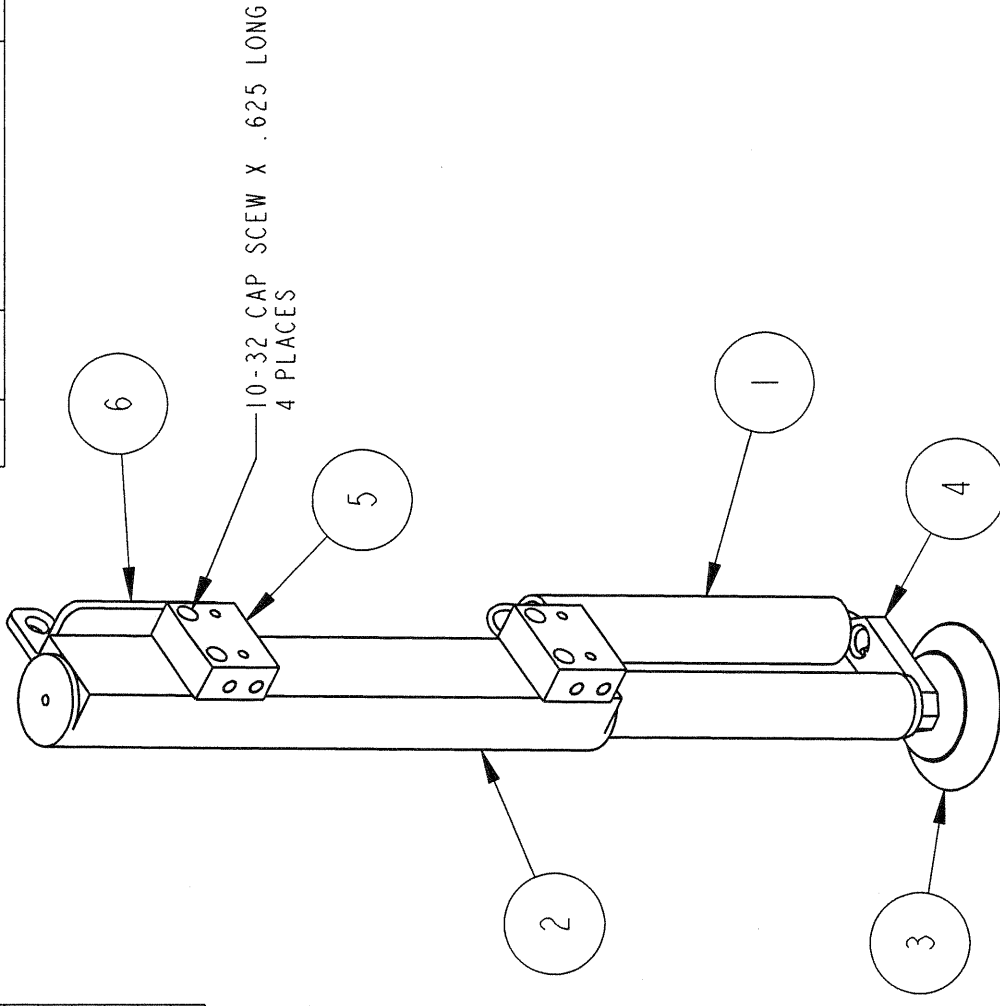
SCALE 0.060

1	533196-07
REV'D	WHERE USED



DRAWN BY: CMC	SCALE 0.100	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED		MATERIAL: N/A		THIRD ANGLE PROJECTION 		PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE QUOTED OR REPRODUCED WITHOUT THE WRITTEN PERMISSION OF KIRK-RUDY, INC. KENNESAW, GA 30144 USA		KIRK - RUDY, INC. KENNESAW, GEORGIA	
CHECKED BY:	DATE 07-Mar-05	.XX .01	.XXX .005	ANG. .5	HEAT TREAT: N/A	MODEL: 319N	319N	TITLE: ASSY, MONITOR STAND NETJET			
TRACED BY:	MASTER 	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED			FINISH: N/A	SHEET NO. 1 OF 1	1 OF 1	DRAWING 1		532152-20	

ITEM	QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
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1	1	102792	SPRING, EXTENSION
2	1	191029-2	CYLINDER, LIFT CB415
3	1	191029-3	GLIDE, SUSPA
4	1	537371-01	BRACKET, SPRING RETURN MOUNT
5	2	537596-01	BLOCK, HYDRAULIC LIFT LH
6	1	537597-01	BRACKET, HYDRAULIC LIFT SPRING



2	SP84700
REQ'D	WHERE USED

DRAWN BY: A KEY	SCALE 0.375	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED			MATERIAL: N/A		THIRD ANGLE PROJECTION	PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE QUOTED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC. KENNESAW, GA 30144 USA		KIRK - RUDY, INC. KENNESAW, GEORGIA
	CHECKED BY:	DATE 26-Jul-00	.XX .XXX ANG. .01 .005 .5							
TRACED BY:	MASTER	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY			FINISH: N/A	MODEL: SP84700	TITLE: ASSY, RH HYDRA LIFT LEG	DRAWING # 539424-01		

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

REV NO	DATE	DESCRIPTION	ECN NO	BY
1				
2				

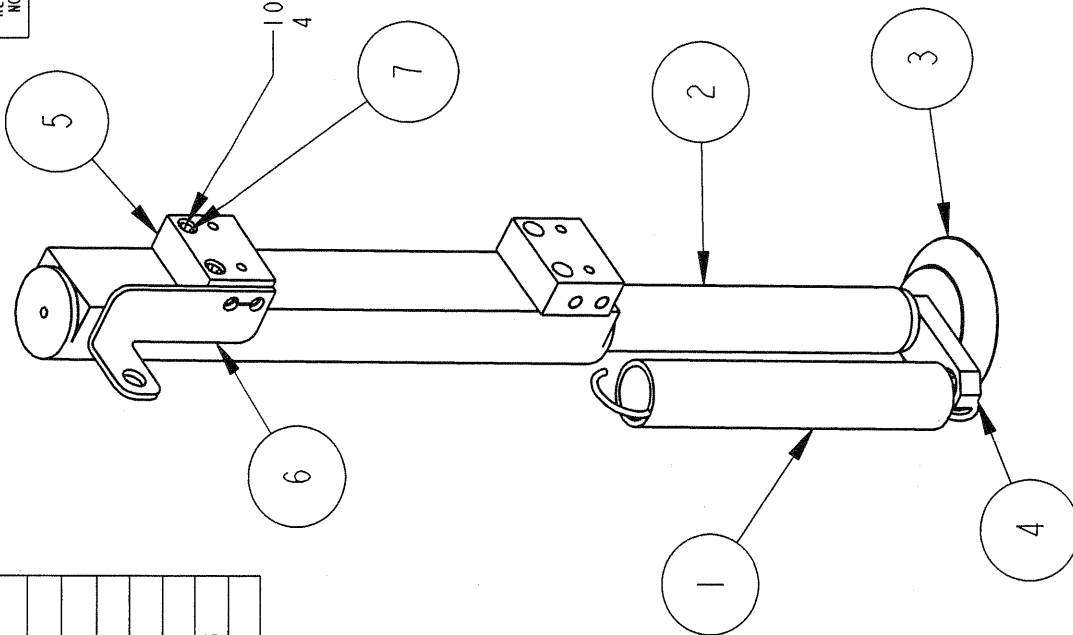
10-32 CAP SCEW X .625 LONG
4 PLACES

1 2 3 4 5 6 7

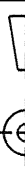

PROPRIETARY AND CONFIDENTIAL
THIS DRAWING IS THE PROPERTY OF KIRK-RUDY, INC.
AND IS NOT TO BE REPRODUCED OR COPIED
IN ANY FORM WITHOUT THE EXPRESS WRITTEN
PERMISSION OF KIRK-RUDY, INC.
KENNESAW, GA 30144 USA

THIRD ANGLE PROJECTION	MODEL	TITLE	PROPRIETARY AND CONFIDENTIAL THIS DRAWING IS THE PROPERTY OF KIRK-RUDY, INC. AND IS NOT TO BE REPRODUCED OR COPIED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC. KENNESAW, GA 30144 USA	REV NO	DATE	DESCRIPTION	ECN NO	BY
100%	SP84700	ASSY, LH HYDRA LIFT LEG	KIRK - RUDY, INC. KENNESAW, GEORGIA	2				
100%	SP84700	ASSY, LH HYDRA LIFT LEG	KIRK - RUDY, INC. KENNESAW, GEORGIA	2				
100%	SP84700	ASSY, LH HYDRA LIFT LEG	KIRK - RUDY, INC. KENNESAW, GEORGIA	2				

SHEET NO.	TOTAL SHEETS	DRAWING #
100%	100%	539425-01

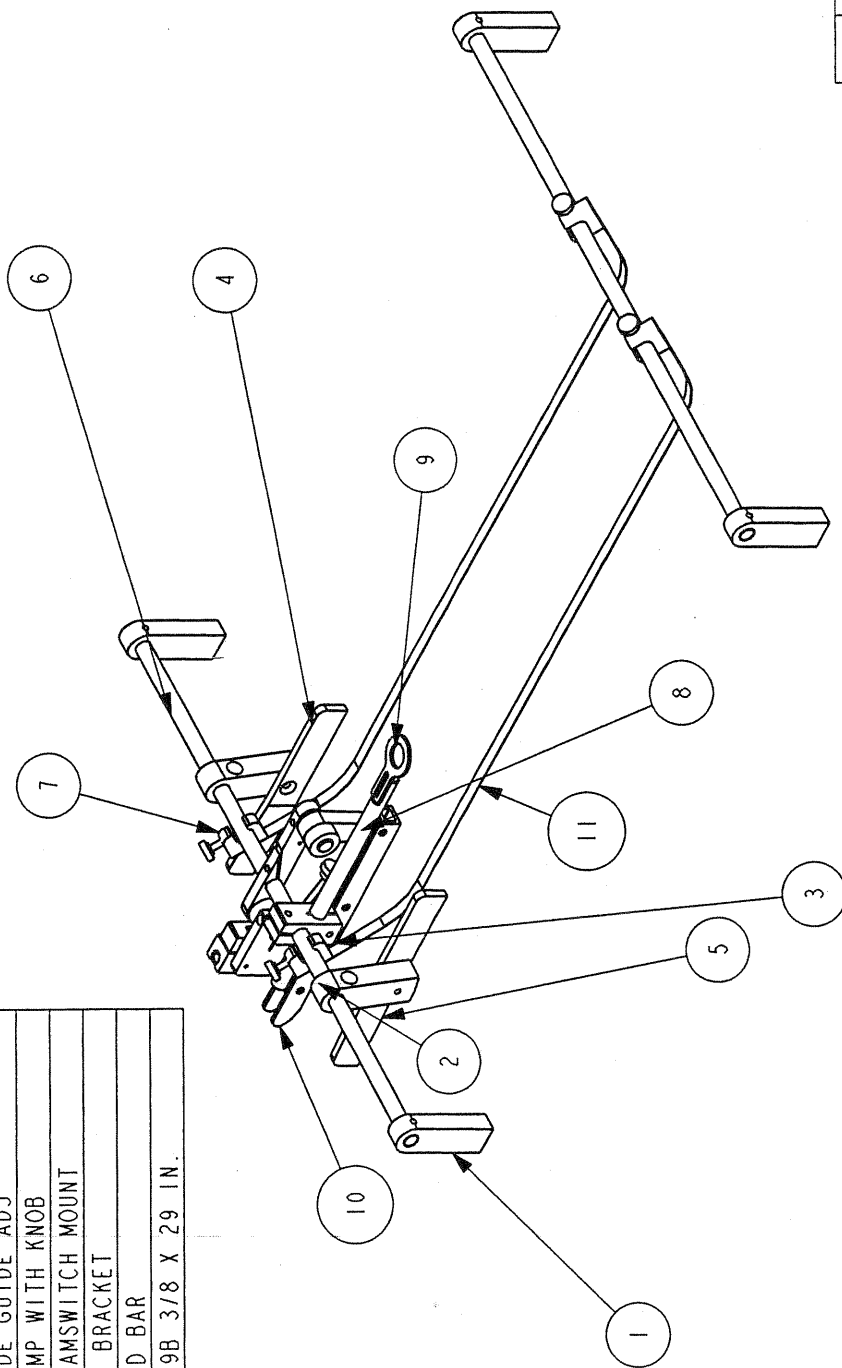


2	SP84700
REQ'D	WHERE USED

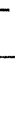



DRAWN BY: A KEY	SCALE 0.375		DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED		MATERIAL: N/A		 KIRK - RUDY, INC. KENNESAW, GEORGIA	PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE QUOTED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC. KENNESAW, GA 30144 USA
	DATE 26 - Jul - 00			HEAT TREAT: N/A				
CHECKED BY:	MASTER		REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED		FINISH: N/A	MODEL: SP84700	TITLE: ASSY, LH HYDRALIFT LEG	DRAWING # 539425-01
TRACED BY:			ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY					

ITEM	QTY	PART #	DESCRIPTION
1	4	500791	POST, SIDE GUIDE
2	2	500792	POST, SIDE GUIDE
3	1	508593	CLAMP
4	1	500722-24L	RAIL, GUIDE LH
5	1	500722-24R	RAIL, GUIDE RH
6	2	500787-6	SHAFT, SIDE GUIDE ADJ
7	4	501629-A	ASSY, CLAMP WITH KNOB
8	1	508995-7	SHAFT, BEAMSWITCH MOUNT
9	1	508996-2	PHOTOCELL BRACKET
10	1	538021-01	ASSY, SKID BAR
11	2	542871-01	STRAP, 319B 3/8 X 29 IN.

REV NO	DATE	DESCRIPTION	ECN NO	BY
1	1/27/2003	ADDED SPRING STEEL STRAPS	6917	TJG



1	SP91900-2
REQ'D	WHERE USED

DRAWN BY: TJG	SCALE 0.188	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED			MATERIAL: N/A			PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE QUOTED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC. KENNESAW, GA 30144 USA	 KIRK - RUDY, INC. KENNESAW, GEORGIA
CHECKED BY:	DATE 23-Jan-02	.XX .01	.XX .005	ANG. .5					
TRACED BY:	MASTER 	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED			HEAT TREAT: N/A	MODEL: SP91900	TITLE: ASSY, SKIDBAR/SENSOR		
					FINISH: N/A	SHEET NO. 1 OF 1	DRAWING 1	538188-04	

538021-01

ITEM	QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	2	100162	BUSHING, SL. 5001D. 6250D. 625LG					
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					

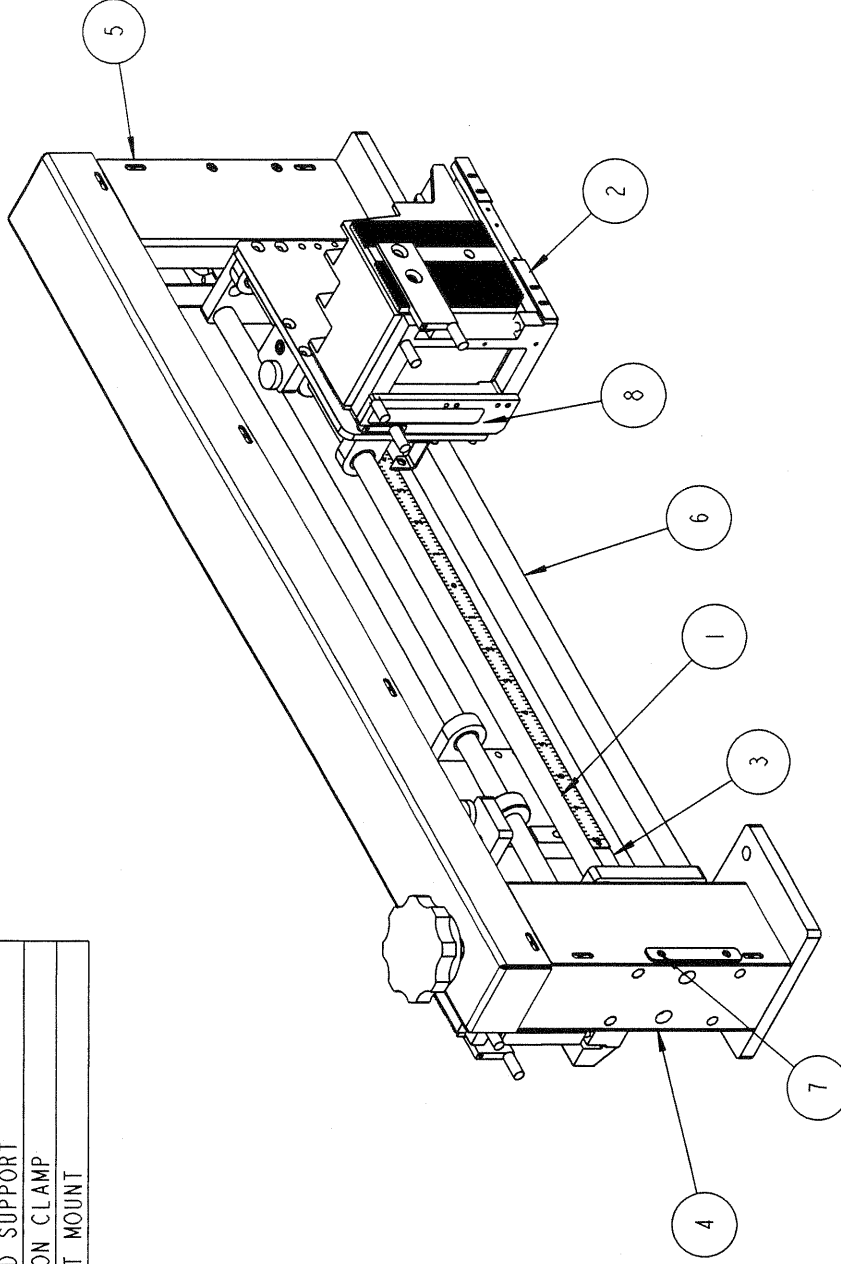
SCALE 0.500

1	KR2191J20
1	KR2191J
REQ'D	WHERE USED

DRAWN BY: AYB	SCALE 0.750	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED		MATERIAL: N/A	THIRD ANGLE PROJECTION	PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE QUOTED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC. KENNESAW, GA 30144 USA	KIRK - RUDY, INC. KENNESAW, GEORGIA
	CHECKED BY:	DATE 15-NOV-99	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY	HEAT TREAT: N/A	MODEL: 2191J	TITLE: ASSY, SKID BAR	
TRACED BY:	MASTER <i>m</i>			FINISH: N/A	SHEET NO.: 10F1	DRAWING 8	538021-01

ITEM	QTY	PART #	DESCRIPTION
1	2	190771	SCALE, CENTER ZERO
2	2	191195	HEAD, NETJET 1.5IN
3	1	531678-02	BAR, SCALE SUPPORT
4	1	538153-06	ASSY, VERTICAL ADJ. RH
5	1	538153-07	ASSY, VERTICAL ADJ. LH
6	4	538168-01	SHAFT, HEAD SUPPORT
7	2	538178-01	STRAP, RIBBON CLAMP
8	2	538269-11	ASSY, NETJET MOUNT

REV NO	DATE	DESCRIPTION	ECN NO	BY
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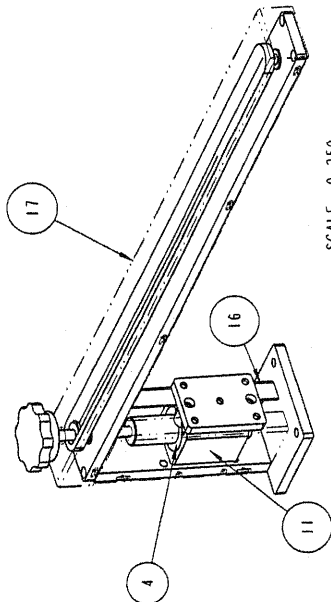
DRAWN BY: CMC	SCALE 0.250	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	MATERIAL: XXX	THIRD ANGLE PROJECTION 	PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE QUOTED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC. KENNESAW, GA 30144 USA	KIRK - RUDY, INC. KENNESAW, GEORGIA	I KR319N
CHECKED BY:	DATE 07-Mar-05	.XX .01 -XXX .005 ANG. .5	HEAT TREAT: XXX	MODEL 319N	TITLE ASSY, NETJET PRINT MOD W/AB		REQ'D WHERE USED
TRACED BY:	MASTER 	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY	FINISH: XXX	SHEET NO. 10F3	DRAWING # 538169-21		

WORKING 1

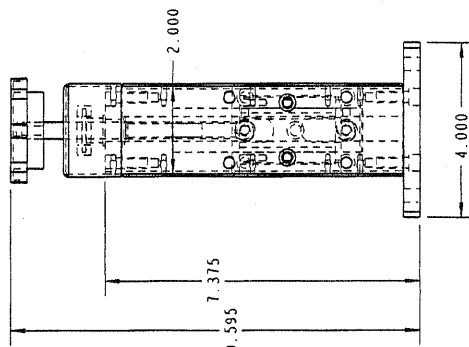
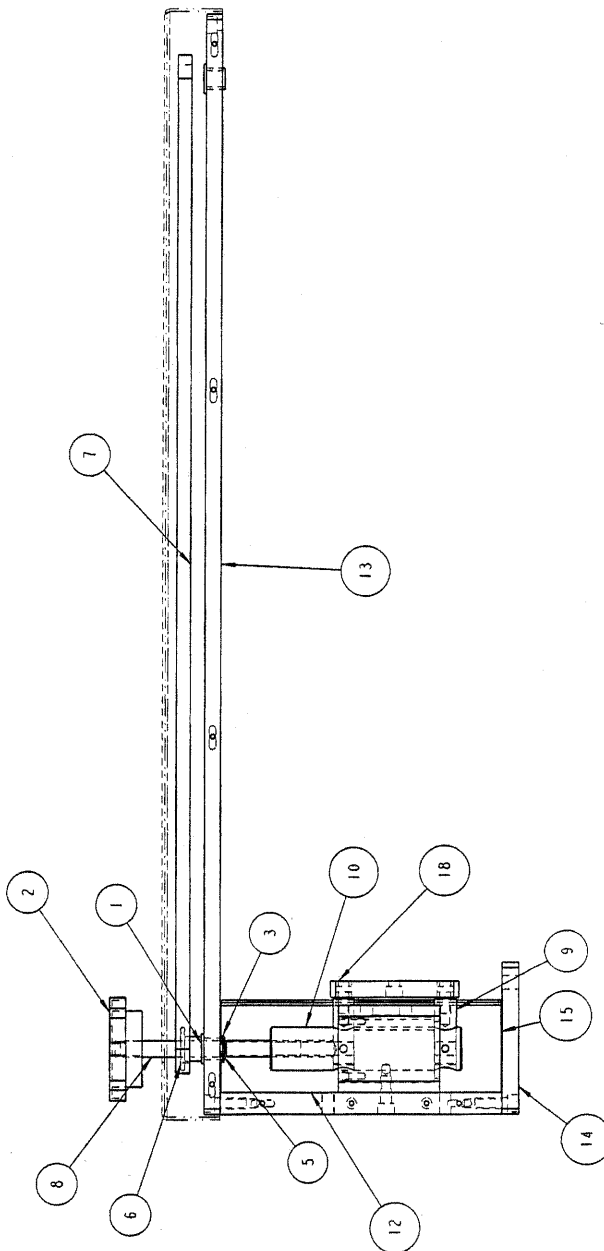
538153-06

REV	NO	DATE	DESCRIPTION	ECN	BY
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ITEMQTY	PART #	DESCRIPTION
1	2	100306 BUSHING, FL. 375ID. 5000D. 500LG
2	1	102112 KNOB, PURCHASED
3	1	102306 SHIM, .375X.625X.031
4	1	102906 BEARING, LINEAR SLEEVE OPEN
5	1	104100 SNAPRING, .375
6	1	110163 SPRKT, 25811 .375B NK
7	1	110021-17 CHAIN, NO. 25 X 47.5 IN.
8	1	500341-2 SHAFT, LIFT
9	2	538146-01 SHAFT, 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	538152-04 PLATE, BOTTOM SUPPORT 319
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



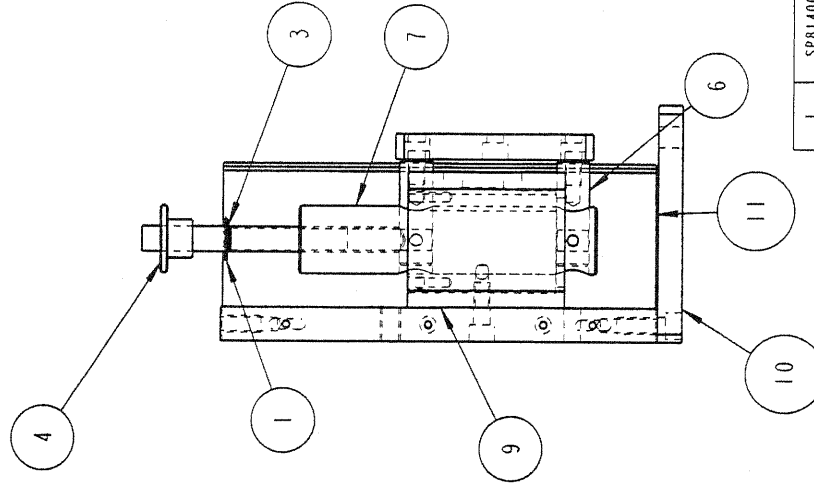
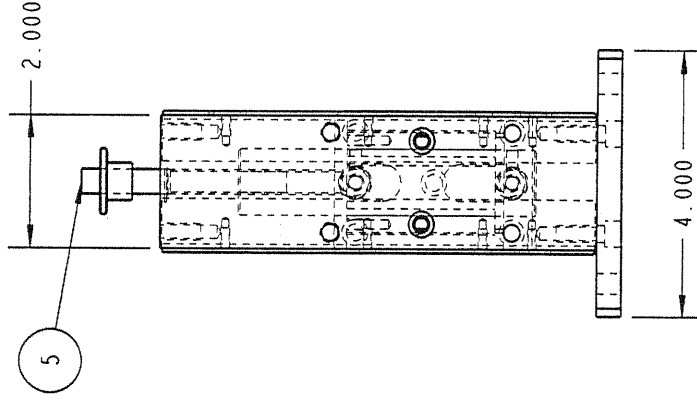
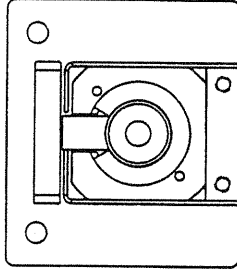
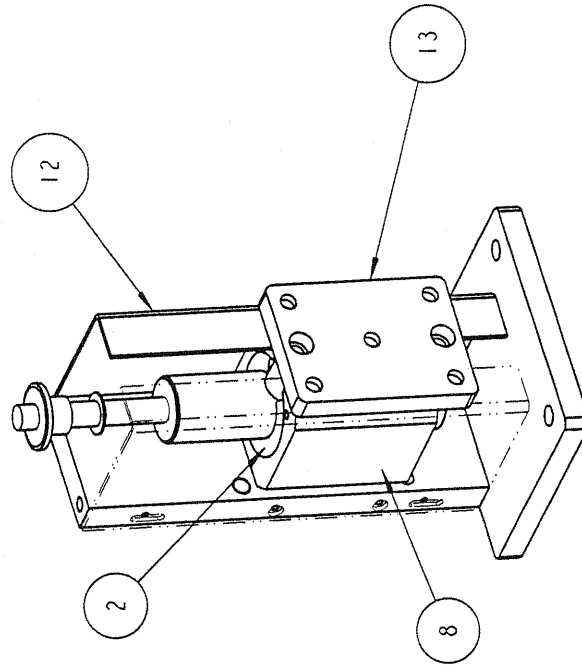
SCALE 0.250



DESIGNED BY: TJG	SCALE: 0.375	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED: FRACTIONS DECIMALS 1/16 1/32 1/64 .005 .010 .015 .020 .030 .040 .050 .060 .070 .080 .090 .100 .125 .150 .175 .200 .250 .300 .375 .500 .625 .750 .875 1.000 1.250 1.500 1.750 2.000 2.500 3.000 3.750 4.000 5.000 6.000 7.000 8.000 9.000 10.000	INITIALS: XXX	DATE: 17-Jul-01	REVISIONS: 1 2 3 4 5 6 7 8 9 10 11 12 13 14 15 16 17 18 19 20 21 22 23 24 25 26 27 28 29 30 31 32 33 34 35 36 37 38 39 40 41 42 43 44 45 46 47 48 49 50 51 52 53 54 55 56 57 58 59 60 61 62 63 64 65 66 67 68 69 70 71 72 73 74 75 76 77 78 79 80 81 82 83 84 85 86 87 88 89 90 91 92 93 94 95 96 97 98 99 100	TRACED BY: M	MASTER: M	DATE: 17-Jul-01	SCALE: 0.375	DESIGNED BY: TJG
PROPERTY AND CONFIDENTIALITY NOTICE: THIS DRAWING IS THE PROPERTY OF KIRK - RUDY, INC. AND IS NOT TO BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, WITHOUT THE WRITTEN PERMISSION OF KIRK - RUDY, INC. KIRK - RUDY, INC. KENNESAW, GEORGIA										
TITLE: ASSY, VERTICAL ADJ. RH										
SHEET NO: 10F1										
538153-06										

538153-07

ITEM	QTY	PART #	DESCRIPTION
1	1	102306	SHIM, .375X.625X.031
2	1	102906	BEARING, LINEAR SLEEVE OPEN
3	1	104100	SNAPRING, .375
4	1	110163	SPRKT, 25B11 .375B NK
5	1	500341-1	SHAFT, LIFT
6	2	538146-01	SHAFT, BRACKET SUPPORT
7	1	538147-01	SHAFT, VERTICAL SUPPORT
8	1	538149-01	HOUSING, LINEAR BEARING
9	1	538150-01	PLATE, VERTICAL MOUNT
10	1	538152-04	PLATE, BOTTOM SUPPORT 319
11	1	538154-01	COVER, LINEAR SLIDE RH
12	1	538154-02	COVER, LINEAR SLIDE LH
13	1	538167-01	PLATE, SHAFT SUPPORT



REV	NO	DATE	DESCRIPTION	ECN	BY
1	SP81400				

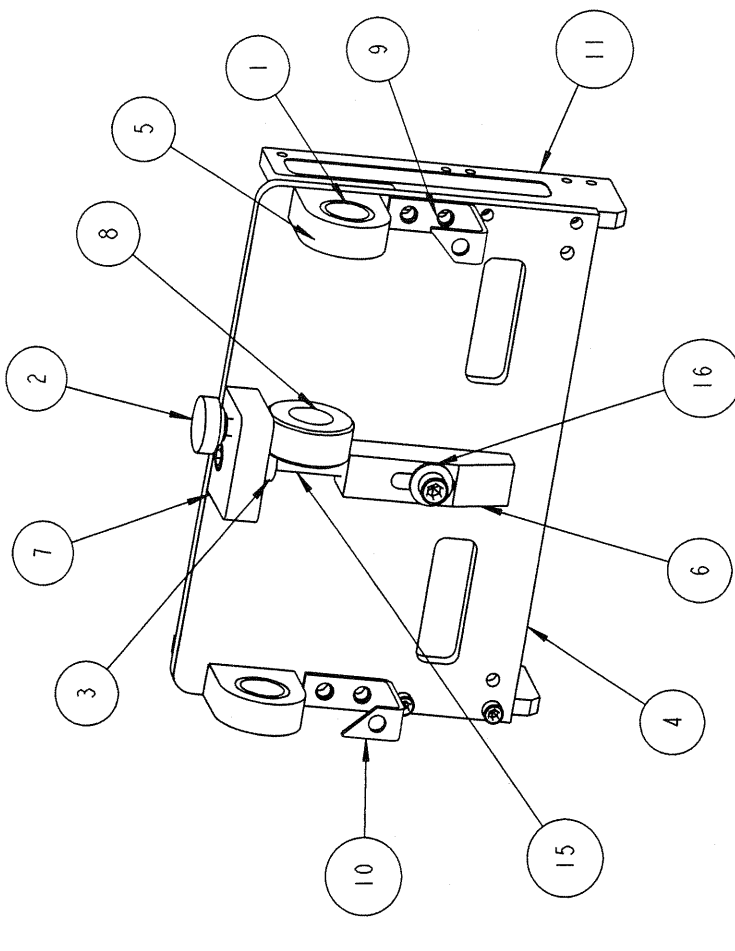
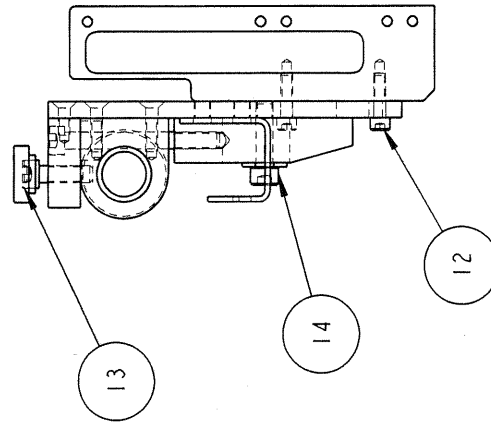
SCALE 0.375


DRAWN BY: TJG	SCALE: 0.375	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	MATERIAL: XXX	THIRD ANGLE PROJECTION	PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE QUOTED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK - RUDY, INC. KENNESAW, GA 30144 USA
CHECKED BY:	DATE: 17-Jul-01	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED	HEAT TREAT: XXX	MODEL: SP81400	TITLE: ASSY, VERTICAL ADJ. LH
TRACED BY:	MASTER: M	ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY	FINISH: XXX	SHEET NO: 10F1	DRAWING #
					538153-07

KR KIRK - RUDY, INC.
KENNESAW, GEORGIA

ITEM QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	2	100133					
2	1	102132					
3	1	102210					
4	1	538270-01					
5	2	538271-01					
6	1	538273-01					
7	1	538280-01					
8	1	538300-01					
9	1	538305-01					
10	1	538305-02					
11	2	540185-01					
12	2	CSDD210					
13	1	CSDD266					
14	1	CSDD267					
15	1	CSDD272					
16	1	WA006					

ITEM QTY	PART #	DESCRIPTION
1	2	BUSHING, SL.500ID.625OD.375LG
2	1	KNOB, 10-32 CAP SCREW
3	1	COLLAR .188
4	1	PLATE, VERTICAL INKJET MNT.
5	2	BLOCK, BUSHING MOUNT
6	1	CAM, INKJET LEVEL
7	1	BLOCK, SLIDE LOCK
8	1	COLLAR, SLED LOCK
9	1	INDICATOR, SCALE RH
10	1	INDICATOR, SCALE LH
11	2	PLATE, NETJET HEAD MOUNT
12	2	SCREW, SHCS 6-32X.500
13	1	SCREW, SHCS 10-32X.625
14	1	SCREW, SHCS 10-32X.750
15	1	SCREW, SHCS 10-32X1.750
16	1	WASHER, FLAT #10

THIRD ANGLE PROJECTION	MODEL	PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE COPIED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC. KENNESAW, GA 30144 USA	TITLE	REO'D	WHERE USED
	SP81400		ASSY, NETJET MOUNT	2	538169-01
	10FI				

DRAWN BY:	SCALE	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	MATERIAL:	HEAT TREAT:	FINISH:						
CMC	0.500	<table border="1"><thead><tr><th>.XX</th><th>.XXX</th><th>ANG.</th></tr></thead><tbody><tr><td>.01</td><td>.005</td><td>.5</td></tr></tbody></table>	.XX	.XXX	ANG.	.01	.005	.5	XXX	XXX	XXX
.XX	.XXX	ANG.									
.01	.005	.5									
CHECKED BY:	DATE	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED									
	04-Feb-04	ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY									
TRACED BY:	MASTER										
	M										

6 ELECTRICAL SCHEMATICS AND PARTS

6.1 WIRING DIAGRAMS LIST

200-178-03-04

6.2 PARTS LIST

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

DRAWING #	DESCRIPTION
KR319N	ASSY, 319N
533196-07	ASSY, CABINET & COVERS
531023-05	WLDMNT, 319B BASE CABINET
532152-20	ASSY, MONITOR STAND NETJET
536586-02	WLDMT, MONITOR STAND
532155-02	ASSY, MONITOR PIVOT
546008-01	PRINT CONTROL MODULE NETJET 110V
546007-01	ASSY,WELDMENT BOX
538502-03	WLDMT, COMPUTER BOX
539424-01	ASSY, RH HYDRALIFT LEG
539425-01	ASSY, LH HYDRALIFT LEG
533195-04	ASSY, 319 WINKJET CONVEYOR
530676-06	ASSY, DRIVE ROLLER
SP45241-10	PLATE, ENCODER MOUNT
500835-A	ASSY, TUBE ROLLER
542189-01	WLDMT, BLOWER BOX W/DOOR
538169-21	ASSY, NETJET PRINT MOD W/AB
538153-06	ASSY, VERTICAL ADJ. RH
538153-07	ASSY, VERTICAL ADJ. LH
538269-11	ASSY, NETJET MOUNT
191195	HEAD, NETJET 1.5IN
538188-04	ASSY, SKIDBAR/SENSOR
538021-01	ASSY, SKID BAR
500801A	ASSY, LINK
500800-A	ASSY, LINK
500802A	ASSY, CLAMP
190101A	ASSY-SWITCH WITH COVER
500834A	ASSY, STUD WITH BEARING
501629-A	ASSY, CLAMP WITH KNOB
102131-5A	KNOB ASY
533132-01	ASSY, 324M CONTROL BOX

7 APPENDIX

[illegible]

9 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

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