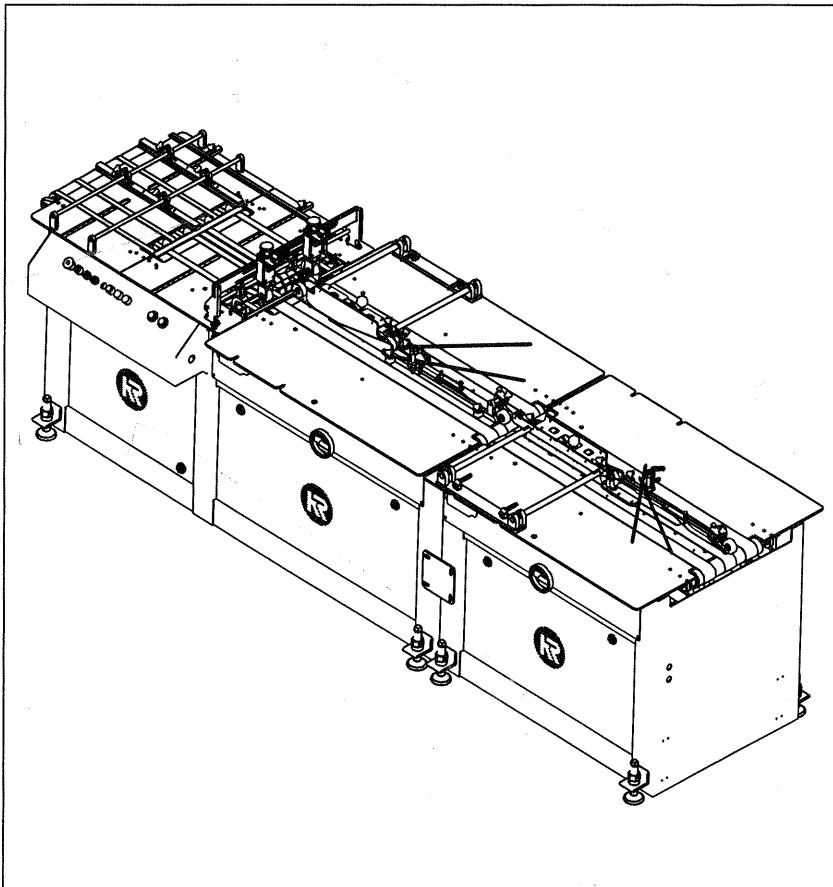


Kirk-Rudy, Inc.

Parts Manual

KR219RSDF

Inline Dual Plow Fold Base (KR219RSF+KR219FM)



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-KR219RSDF

REV. 2

8/8/03

Parts Manual

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1 Important Safety Instructions

Intended Use Statement: The KR219RSDF is a transport system designed to register, score and fold product one at a time. Product feeds out onto angled conveyor belts and is registered against a side guide. The product is then transported through a scoring device and onto the first plow fold table. The plow fold section folds the product and presses the crease. The product then enters the last plow fold section and finishes the fold. Usage for other purposes may lead to an unsafe condition.

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



WARNING

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

2 MACHINE SPECIFICATIONS

PHYISICAL SIZE

219RFS + 219FM Length	124"	315 cm
219RFS Length	82"	208 cm
Width	36"	91 cm
Over All Height	43"	109 cm
Table Top Height	33.25"	84.5 cm

Note: See Figures 1.0, 2.0 and 3.0

PRODUCT SPECIFICATIONS

See Section 3.0 Product Specifications Figure 3.0 and 4.0

SPEED

Motor with Gear Reduction (Standard)

For applications below 240 ft/min (60 cycles) and 200 ft/min (50 cycles)

Motor without Gear Reduction (Optional)

For applications above 240 ft/min max speed 600 ft/min (60 cycles) and 500 ft/min (50 cycles)

Note: Speed is dependent on type of product being used.

ELECTRICAL REQUIREMENTS

Main Power 220V, single phase, 50/60 cycle, AC 30 amps

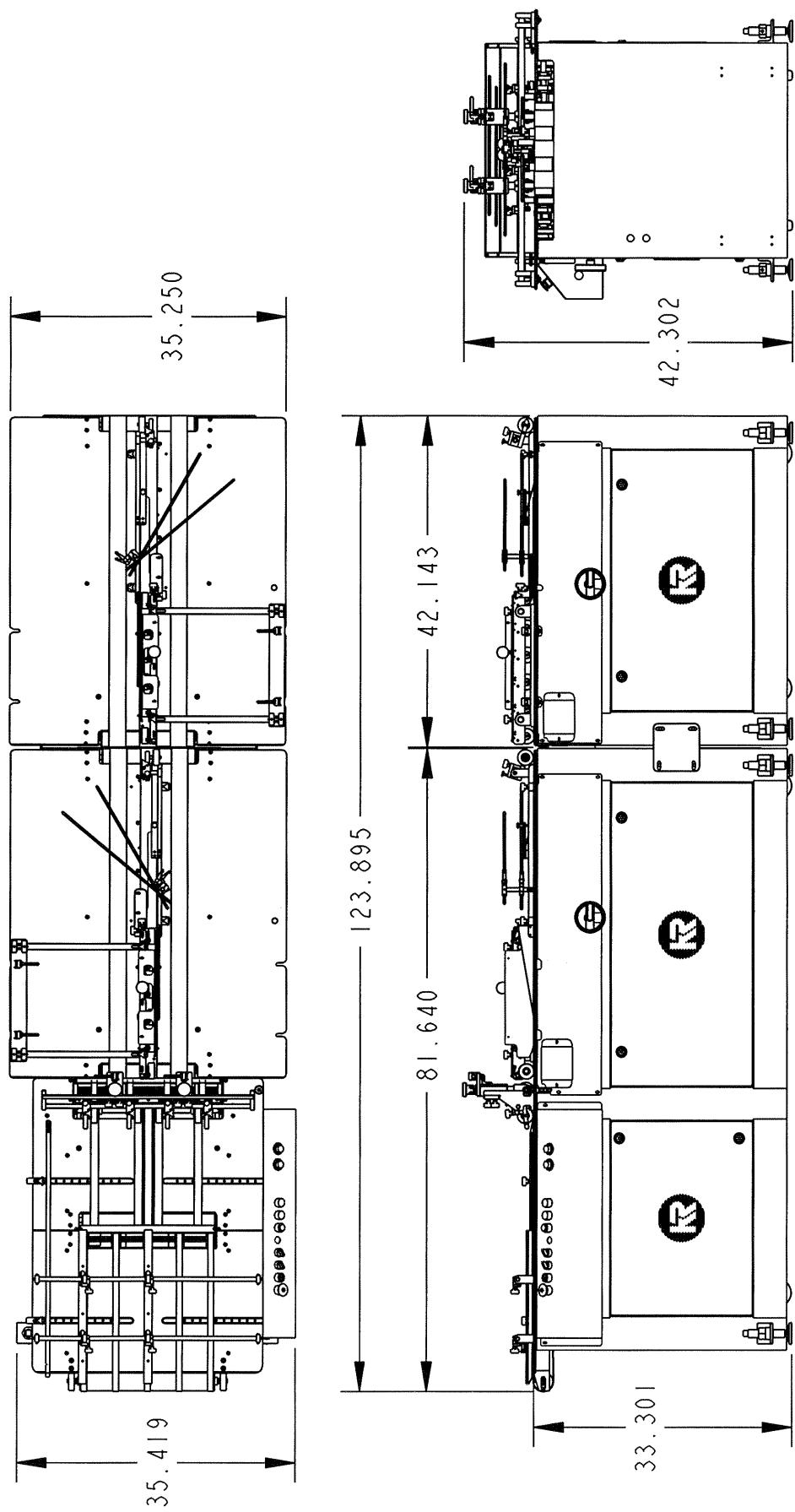


FIGURE 1.0

KR219RSF

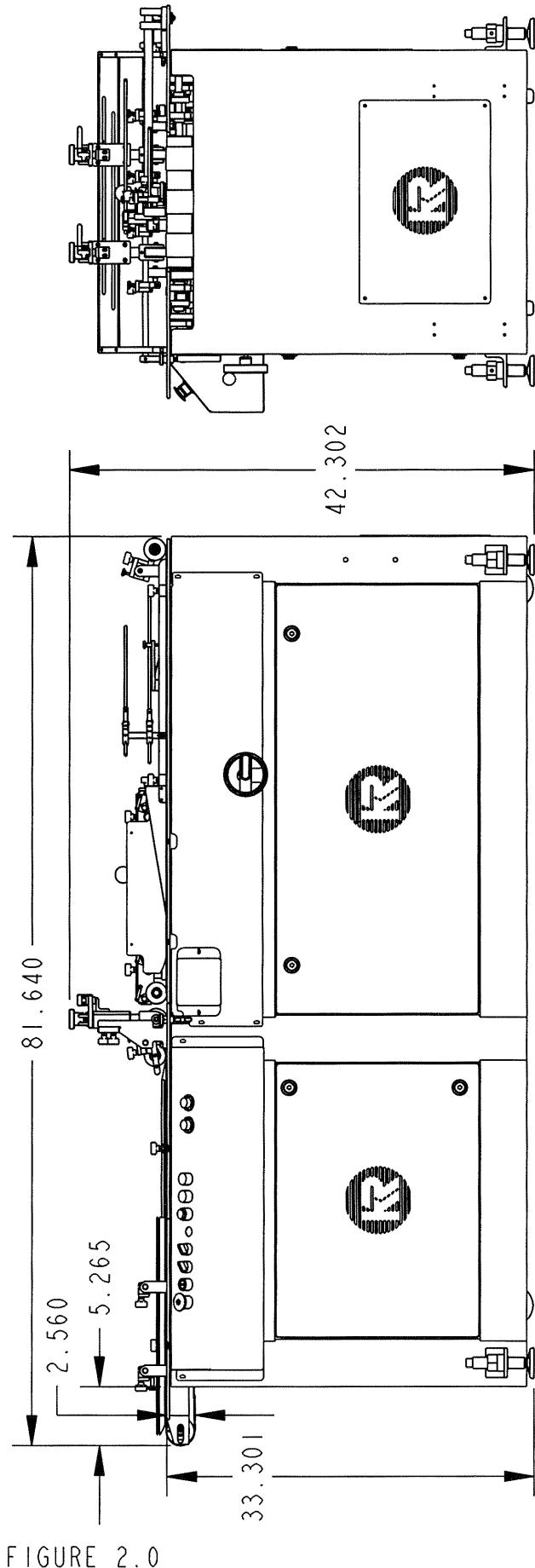
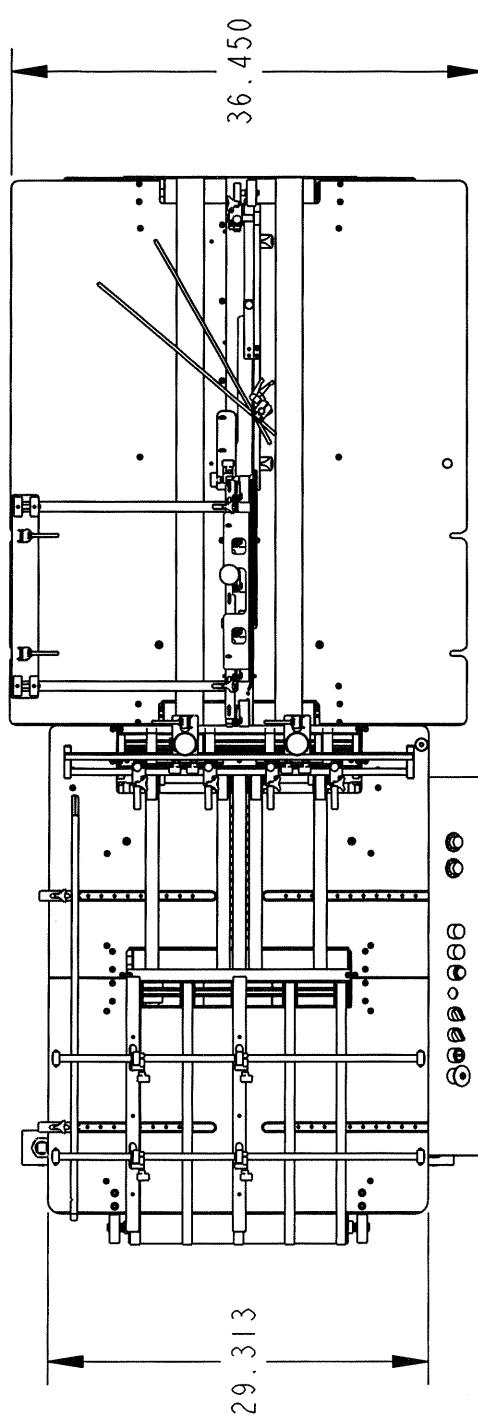


FIGURE 2.0

KR219FM

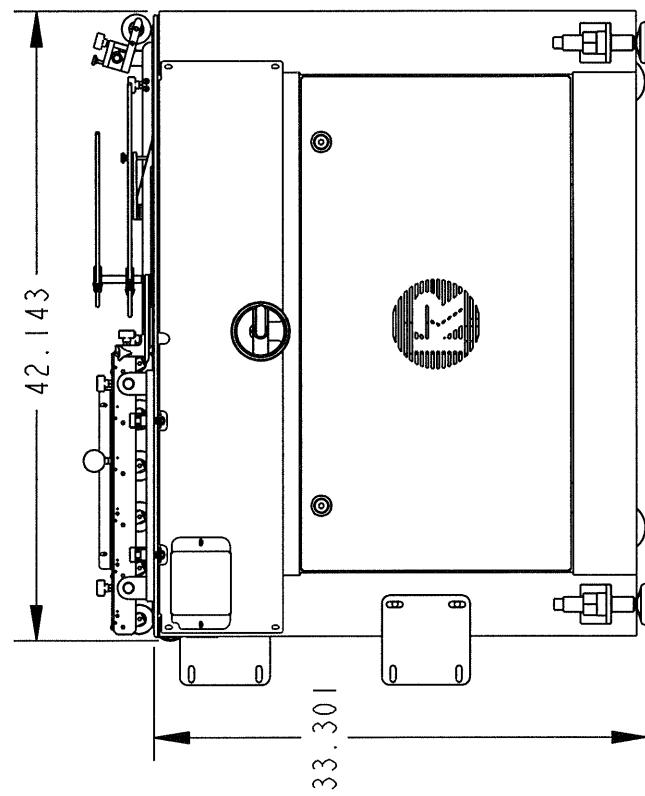
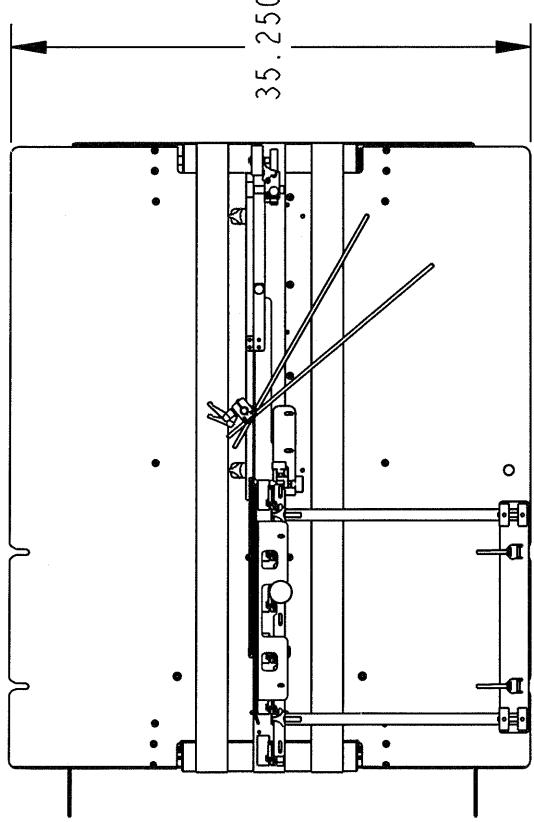


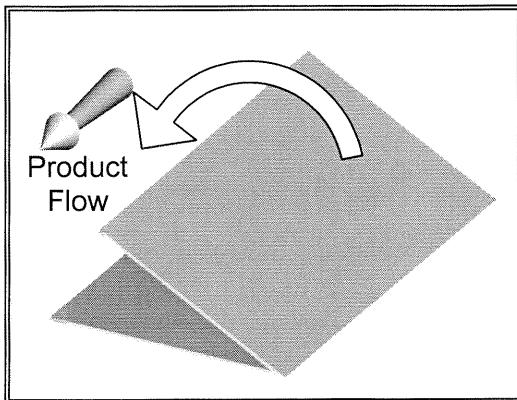
FIGURE 3.0

3 PRODUCT SPECIFICATIONS

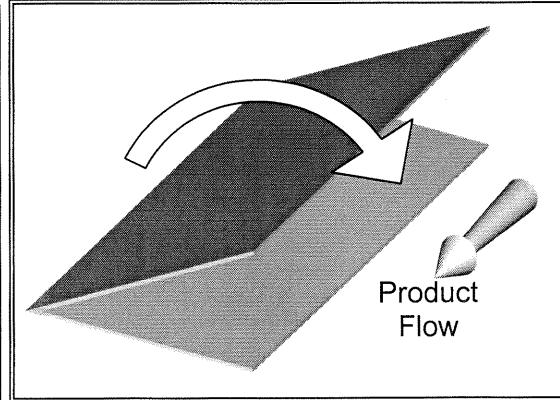
3.1 Product Size Specifications

See Figure 4.0 for product size specifications.

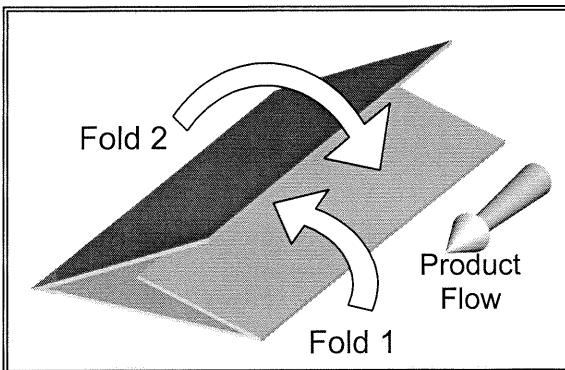
3.2 Product Fold Options



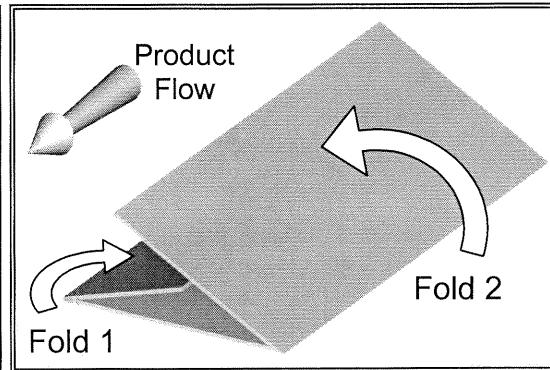
Left Hand Single Fold



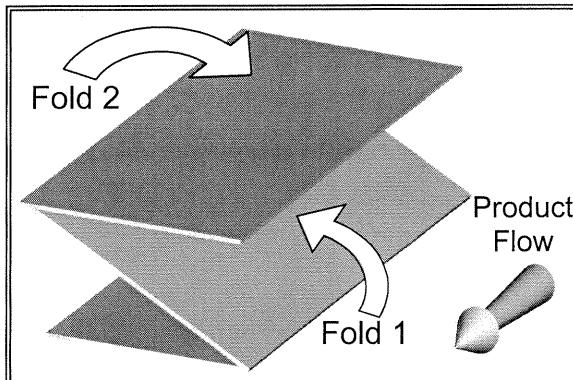
Right Hand Single Fold



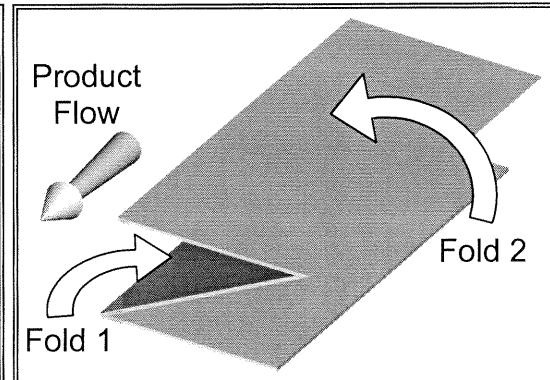
Left Hand/Right Hand Double Fold



Right Hand/Left Hand Double Fold



Left Hand/Right Hand Double "Z" Fold



Right Hand/Left Hand Double "Z" Fold

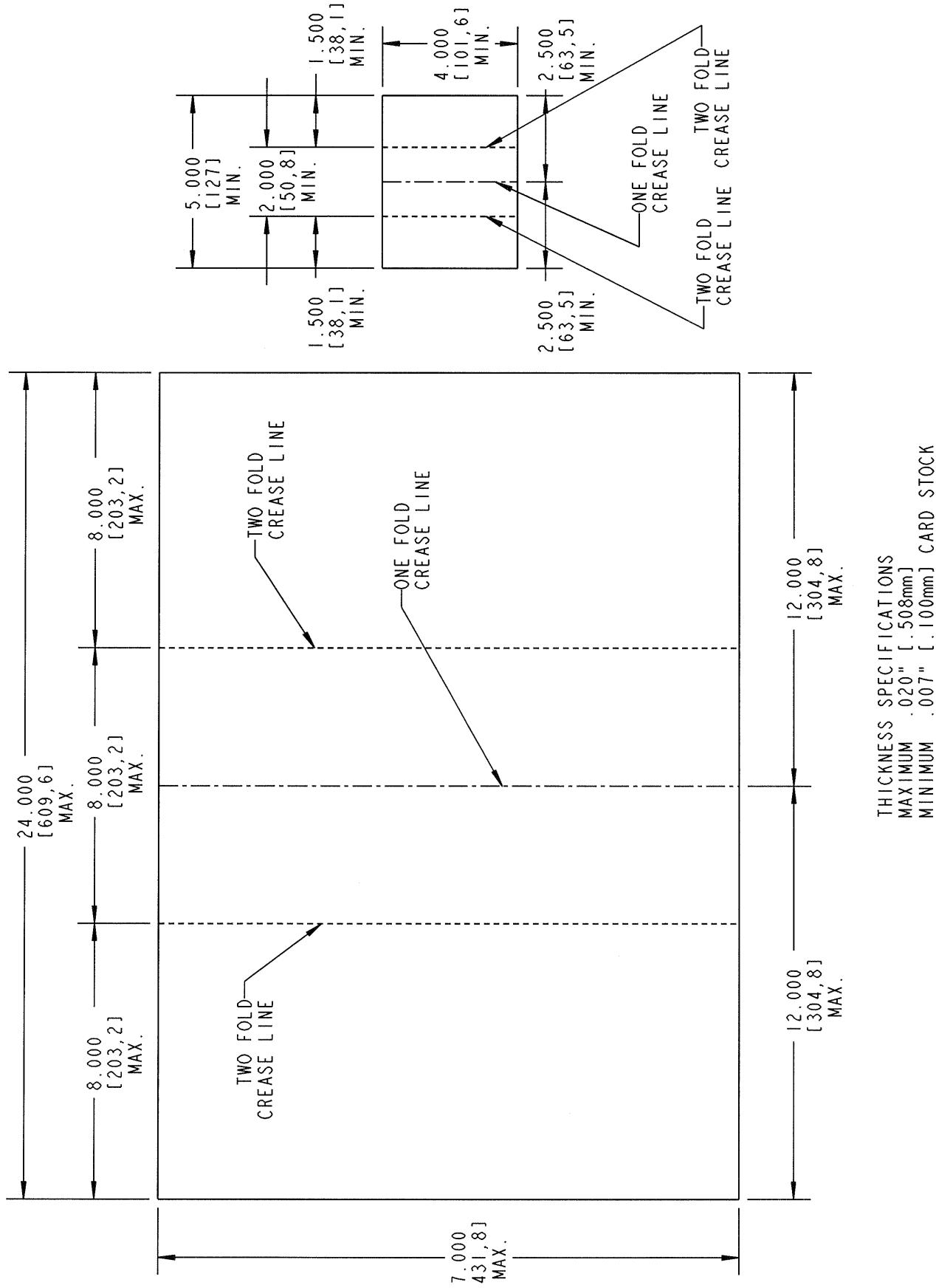


FIGURE 4.0

4 INSTALLATION



WARNING

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

4.1 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.

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

4.2 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.

5 COMPONENT DESCRIPTIONS



WARNING

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

5.1 Control Panel (See Figure 5.0)

1. POWER OFF / EMERGENCY STOP BUTTON: This is a latching switch. To turn power on, unlatch emergency stop. Press button to turn machine power off. The green light in the power button will turn off when power is off.
2. POWER BUTTON: Press button to turn machine power on. Emergency stop button must be unlatched. Button will glow green when machine is on.
3. BLOWER ON/OFF SWITCH: Turns on/off blowers that supply the vacuum to each section. The left hand blower switch operates the infeed tabletop belts and the right hand switch operates the last two tabletop belt sections.
4. STOP BUTTON: Pressing the stop button will stop the motors driving the belts. The button must be unlatched to restart the machine.
5. JOG BUTTON: The machine will run as long as this switch is depressed. This switch is designed as an aid for set-up and will also stop the machine when pressed and released.
6. START BUTTON: If no stop buttons are latched, pressing the start button starts the motor driving the tabletop belts.
7. MOTOR SPEED CONTROL: Controls the speed of the tabletop belts. “0” is minimum speed, “10” is maximum speed. The left hand speed knob controls the speed of the infeed belt section. The middle speed knob controls the second set of tabletop belts. The right hand speed knob controls the speed of the out feed tabletop belts.
8. CONVEYOR SPEED CONTROL: Controls the speed of the conveyor when an outfeed conveyor is used.
9. REMOTE JOG RECEPTACLE: A two pin twist jog cord plugs in here to remotely jog the machine for setup.

5.2 Base Component Descriptions (See Figure 6.0)

1. STEEL BALL SKID BAR: Used to hold product down onto the side register belts. A fine adjust screw is provided to use when product is driven too hard into the side register guide.
2. SIDE REGISTER GUIDE: Used to register the product against after the angled belts have driven product into the guide. The register guide is made to be self aligning. The mounting brackets use a wedge which fits into a wedged slot to make sure the guide is perpendicular to the creasing wheel assembly.

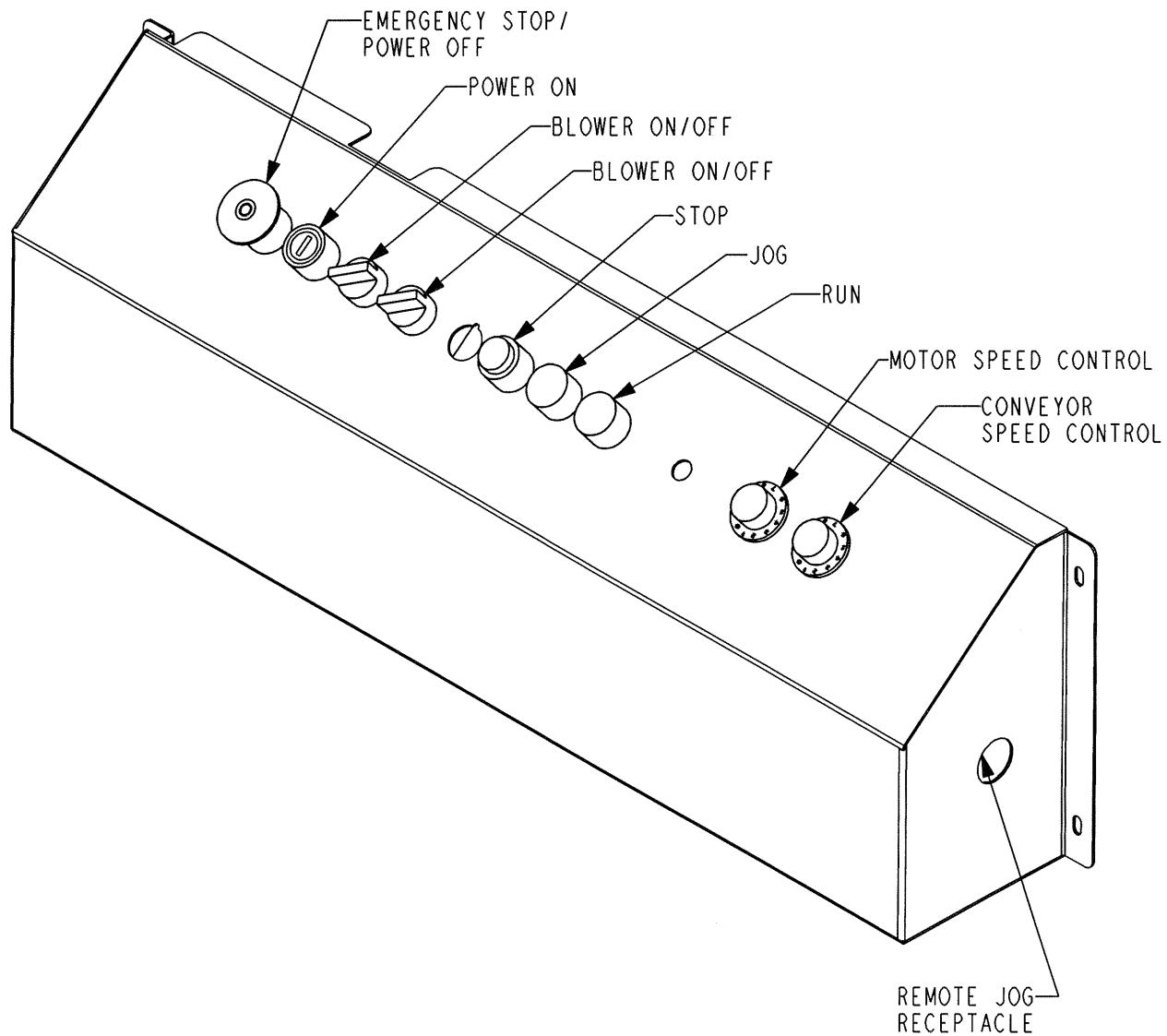


FIGURE 5.0

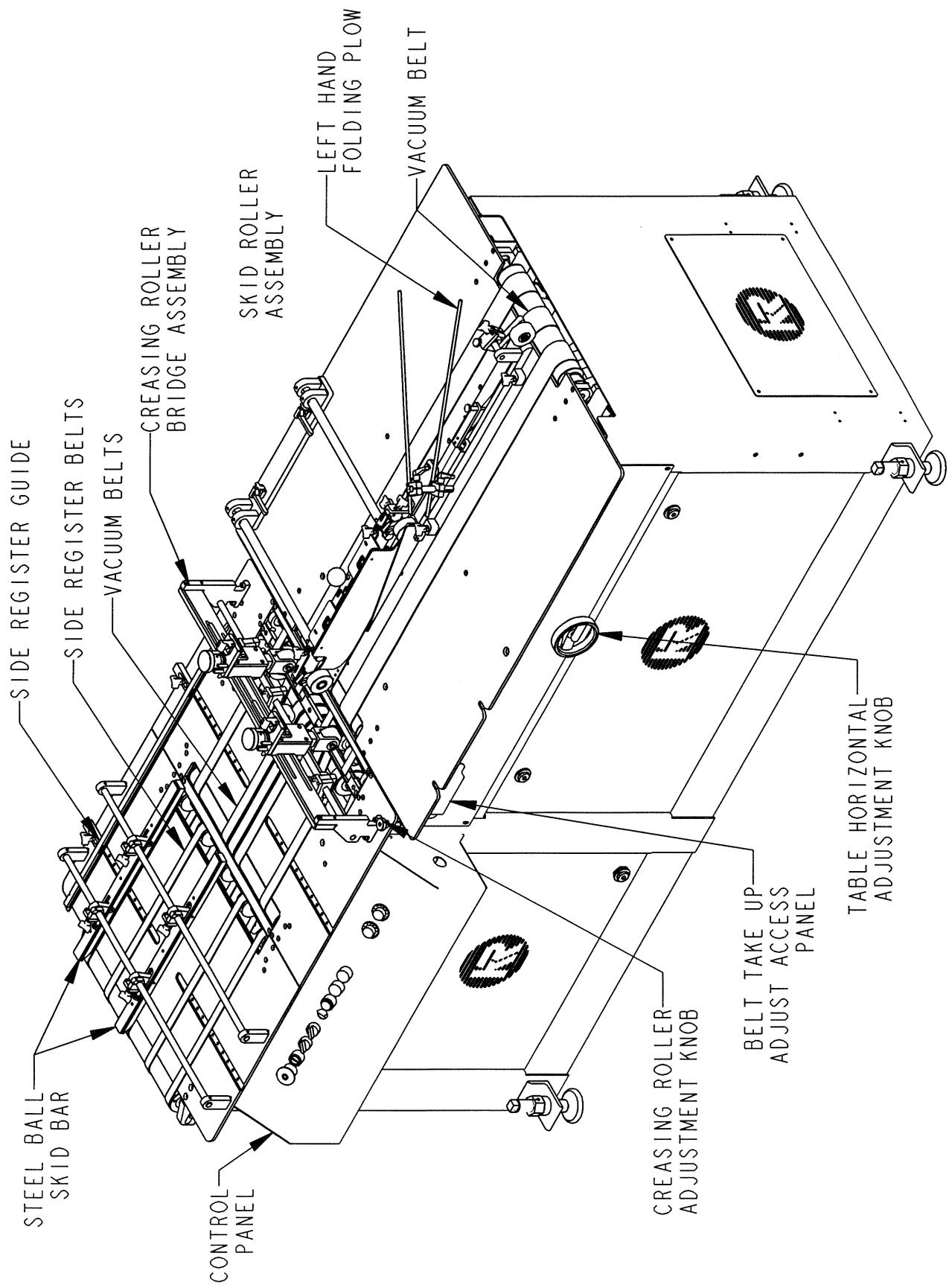


FIGURE 6.0

3. SIDE REGISTER BELTS: The side register belts are angled to drive the product up against the side register guides. The fine adjust on the steel ball skid bar assembly will adjust for the amount of drive into the side register guide.
4. VACUUM BELTS: The three center belts have vacuum holes between the belts to create a vacuum to hold product down onto the belts. The belts carry the product to the creasing assembly.
5. CREEASING ROLLER BRIDGE ASSEMBLY: Product is fed into the creasing roller assembly. The creasing rollers press the product into the urethane rollers creating a crease for folding.
6. SKID ROLLER ASSEMBLY: Every roller is individually spring loaded to provide maximum control to hold the product firmly onto the vacuum belts. The skid roller assembly is adjustable from left to right with the horizontal adjustment knobs.
7. VACUUM BELT: The vacuum belts have holes in the belts to better hold the product to the belt. The belts transport the product through the plow folding operation.
8. LEFT-HAND FOLDING PLOW: The plow folding assembly forces the product over and presses the creased edge shut.
9. RIGHT-HAND FOLDING PLOW: (not shown) The plow folding assembly forces the product over and presses the creased edge shut.
10. CONTROL PANEL: Contains the control knobs that control the machine. Refer to 5.1 Control Panel.
11. CREEASING ROLLER ADJUSTMENT KNOB: Used to adjust the height of the creasing rollers.
12. TABLE HORIZONTAL ADJUSTMENT KNOB: Used to adjust the table left to right to adjust for different product sizes.
13. BELT TAKE UP ADJUST ACCESS PANEL: The panel allows access to the spring loaded take up system for maintenance.

5.3 Creasing Roller Bridge Component Descriptions (See Figures 6.0 and 7.0)

1. ROLLER VERTICAL ADJUSTMENT KNOB: This knob adjusts the pressure of the urethane roller against the creasing roller. The locking ring must be loosened before an adjustment can be made.
2. ROLLER QUICK RELEASE HANDLE: The quick release handle is used to aid in clearing jams if one should occur. Make sure the handle is in its down and fully locked position before making adjustments.
3. LOCKING RING: The locking ring ensures the vertical adjustment knob isn't inadvertently knocked out of adjustment. The locking ring must be loosened before making adjustments.
4. ADJUSTABLE CREEASING ROLLER ASSEMBLY: The creasing roller assembly is used to provide a drive and creasing wheel support. The assembly can be adjusted from left to right with the horizontal adjustment knobs.
5. HORIZONTAL ADJUSTMENT KNOBS: The creasing roller assembly can be adjusted from left to right with these knobs.

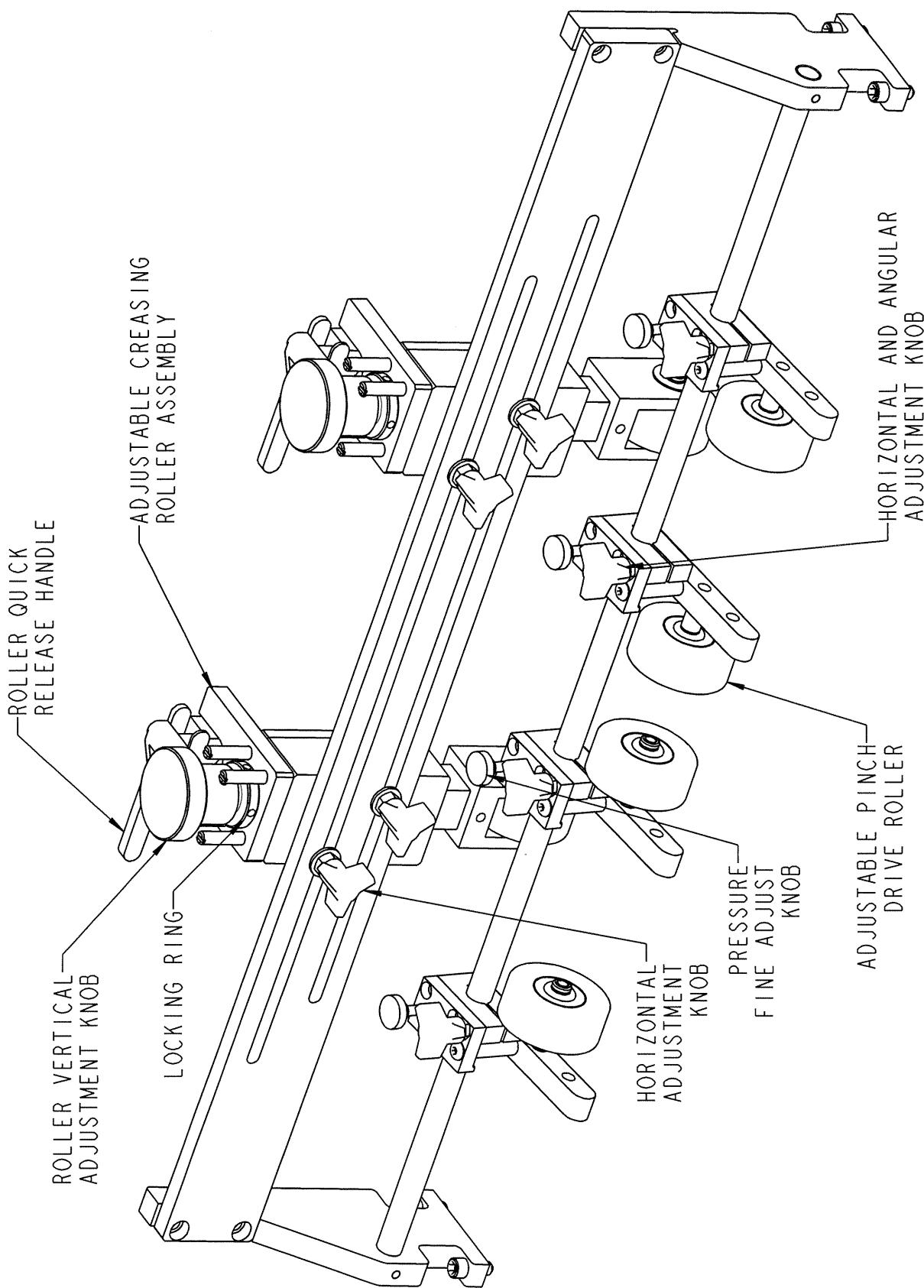


FIGURE 7.0

6. ADJUSTABLE PINCH DRIVE ROLLER: This assembly drives the product through the creasing roller. The angle, pressure and left to right adjustment can be easily be made with the adjustment knobs provided.
7. PRESSURE FINE ADJUST KNOB: Once the pinch drive roller has been adjusted a fine adjust knob will allow a closer setting. Once the pinch roller has been fine adjusted a locking ring is provided to secure the adjustment knob.
8. HORIZONTAL AND ANGULAR ADJUSTMENT KNOB: The horizontal and angular adjustment knobs are used to position the assembly from left to right and to roughly set the roller pressure. A fine adjust knob is provides for easily pressure setting.

5.4 Creasing Wheel Component Descriptions (See Figure 8.0)

1. CREASING WHEEL COARSE ADJUST SET SCREW: Used to unlock the creaser wheel assembly from the driving shaft and move to another location.
2. CREASING WHEEL FINE ADJUST RING: Used to fine adjust creasing wheel location.
3. CREASING WHEEL LOCKING RING: Used to lock the fine adjust creasing wheel into place.
4. THREADED SLEEVE: Used for fine adjusting the creasing wheel.
5. CREASE FINE ADJUST LOCK WASHER: Secures the fine adjustment of the creasing wheel.
6. DRIVE ROLLER: Used to help drive product through that doesn't need to be creased.

5.5 Skid Bar Component Descriptions (see Figure 9.0)

1. SKID ROLLER: Individual spring loaded press down rollers hold product to the vacuum belts to prevent slippage while making the first fold.
2. PRODUCT HOLD DOWN GUIDE: The hold down guide is used to help the product stay on the vacuum belt while the last part of the fold over occurs. The guide is adjustable up and down as well as left and right by means of the skid bar.
3. HORIZONTAL ADJUSTMENT KNOB: The skid bars can easily be adjusted from left to right on the support shafts by means of the horizontal adjustment knobs. The product hold down guide is adjusted left and right with this adjustment.
4. SKID ROLLER JAM RELEASE KNOB: This knob is pushed toward the infeed of the machine in order to lift all of the spring loaded skid rollers. This is done for adjusting the skid roller assembly from side to side or for product jam release.
5. PRODUCT HOLD DOWN GUIDE VERTICAL ADJUSTMENT KNOBS: The product hold down guide is adjusted up and down with these adjustment knobs.

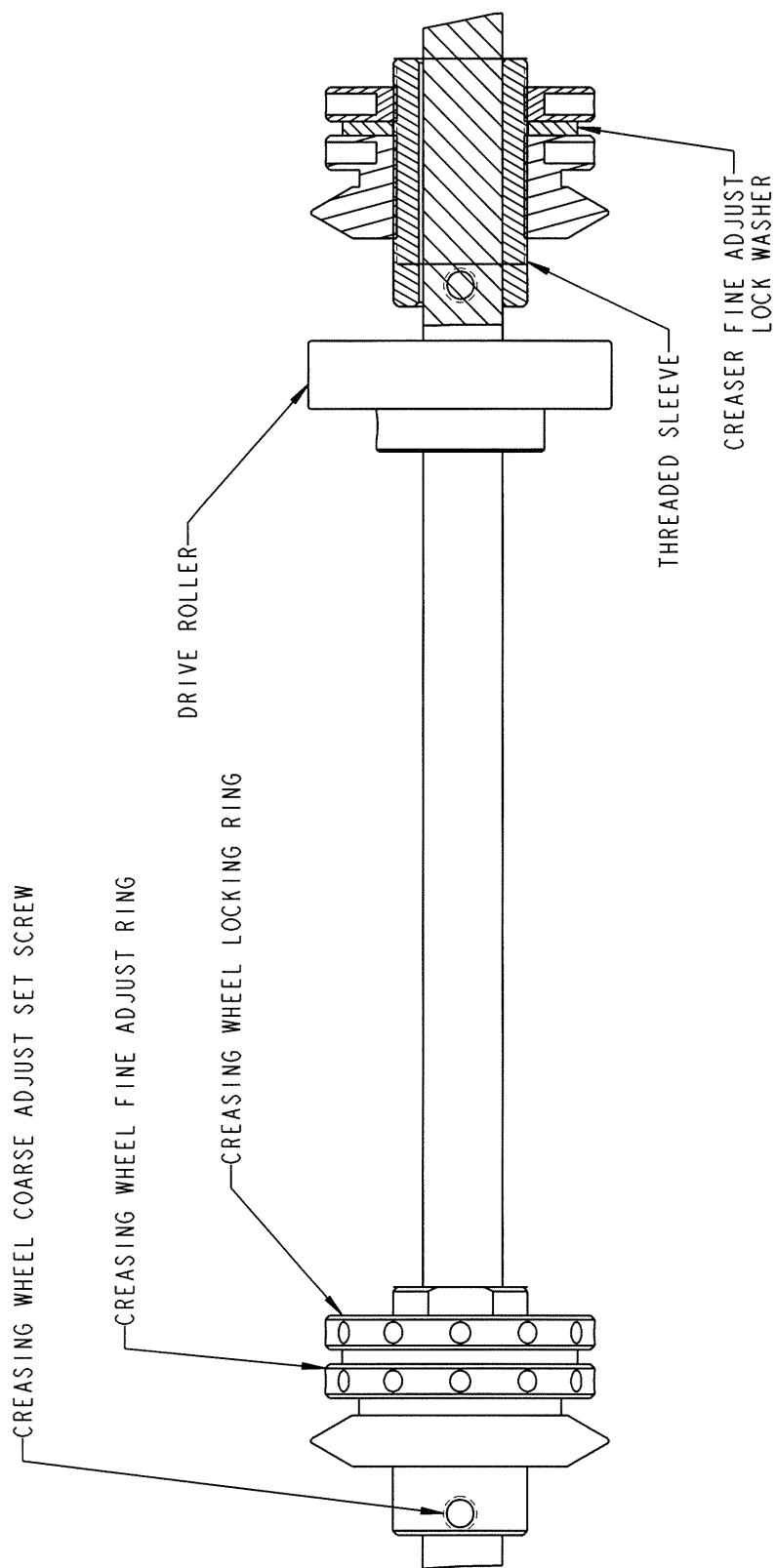


FIGURE 8.0

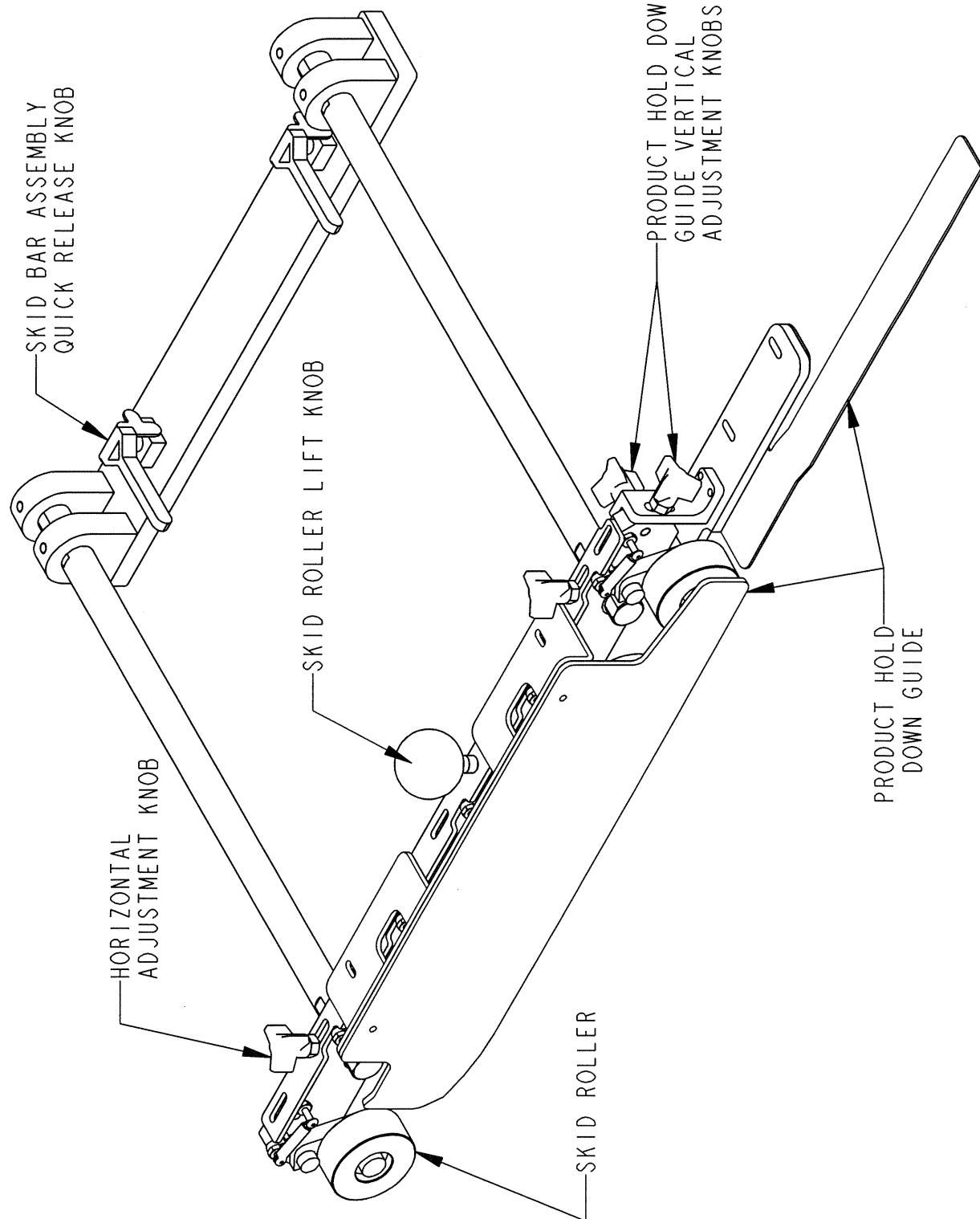


FIGURE 9.0

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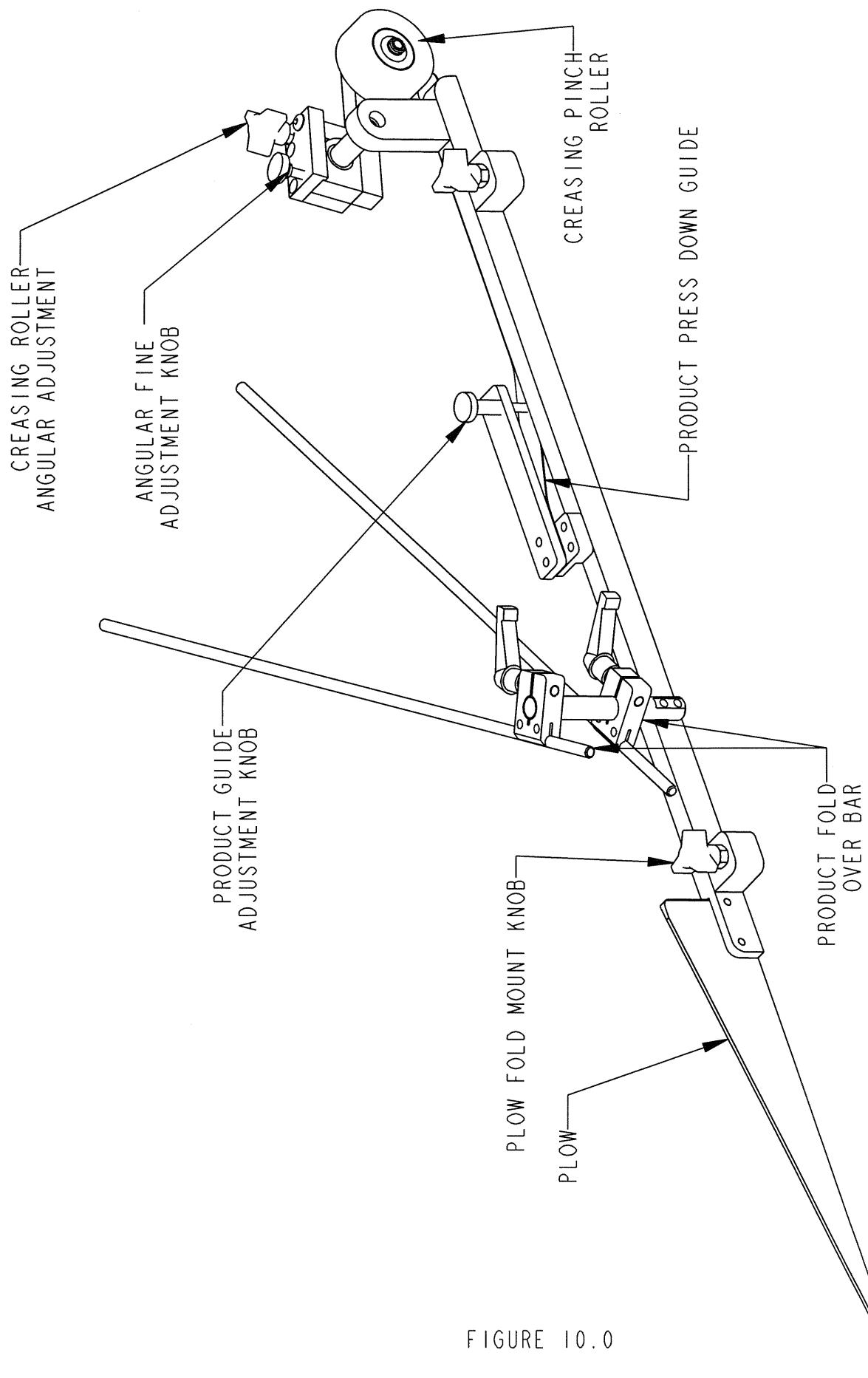


FIGURE 10.0

5.6 Plow Fold Component Descriptions (see Figure 10.0)

1. PLOW: The plow lifts the product to a vertical position as it is driven through the skid bar assembly.
2. PRODUCT FOLD OVER BAR: The product fold over bar forces the product to fold by guiding the product over and down. The bar can be adjusted at different heights and angles with the clamp provided.
3. PRODUCT PRESS DOWN GUIDE: This guide bar completes the fold and presses the edge flat. This guide also ensures that the product is folded straight along the creased edge.
4. PRODUCT GUIDE ADJUSTMENT KNOB: The adjustment knobs controls how fast the product is pressed and ensures that the product is flat before reaching the creasing pinch roller.
5. CREASING PINCH ROLLER: This roller is used to press the folded product down at the crease. The pinch roller should be set to press the crease to make a tight fold but not so tight that the product skews as it is driven through.
6. CREASING ROLLER ANGULAR ADJUSTMENT: The angular adjustment knob is a coarse setting and allows different product thickness' to be run.
7. ANGULAR FINE ADJUSTMENT KNOB: Once the creasing roller has been adjusted a fine adjust knob will allow the pressure to be fine tuned. Once the creasing roller has been fine adjusted a locking ring is provided to secure the adjustment knob.

6 OPERATING INSTRUCTIONS



WARNING

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

6.1 Sequence Of Setup

1. Perform daily maintenance.
2. Adjust register side guide to product.
3. Adjust register belts and skid bars if necessary.
4. Adjust press down rollers.
5. Adjust creasing rollers.
6. Adjust creasing press down rollers.
7. Adjust first plow fold table.
8. Set first product guide height.
9. Adjust first crease press down roller tension.
10. Adjust second plow fold table.
11. Set second product guide height.
12. Adjust second crease press down roller tension.
13. Turn tabletop vacuum pumps on.
14. Test run product by jogging product through.

6.2 Product Side Register Setup (Reference Set Up Sequence 2,3 and **Figure 6.0**)

1. Align side guide with product. The register guide is made to be self aligning. The mounting brackets use a wedge which fits into a wedged slot to make sure the guide is perpendicular to the creasing wheel assembly. Tighten one adjustment knob at a time to allow the guide to align itself.
2. If the guide has to be placed where a side register belt is then the drive roller will have to be moved to make room. Loosen the set screw securing the roller to the shaft and slide over. If the belts need more side registration then the infeed tube roller can be adjusted to a greater angle. The drive roller is crowned so that the belt will track without a belt guide.
3. Slide the skid bar over the belt making sure the skid bar is over the angled belt.
4. Test run the product to make sure that the product is registered against the side guide before going under the spring loaded pinch rollers.

6.3 Creasing Roller Setup (Reference Set Up Sequence 4, 5 and 6)

1. Adjust the press down rollers so that two are on the two outside vacuum belts by loosening the horizontal and angular adjustment knob and sliding the press down rollers into place. **See Figure 7.0**
2. Adjust the two outside press down rollers one inch from each edge of the product and over the outside drive belts. The lower belts will have to also be adjusted by loosening the set screws securing the idler rollers in place and sliding over. Adjust the pressure fine adjust knob to apply an even amount of pressure on each roller. The pressure should be set strong enough to drive the product but still be able to rotate with one finger while the machine is not running. **See Figure 7.0**
3. The creasing rollers should be adjusted so that the edge of the creasing roller is above the tabletop approximately 1/16 to 1/8 of an inch by adjusting the creasing roller adjustment knob. **See Figure 7.0**
4. The creasing rollers should be adjusted to line up with the desired fold line. Loosen the creasing wheel coarse adjust set screw with a 1/8 inch allen wrench and slide the creasing wheel close to where the fold line will be. Tighten the assembly in place. To use the fine adjust loosen the creasing wheel locking ring and rotate the creasing wheel fine adjust ring to move the wheel. Retighten the creasing wheel locking ring to secure the creasing wheel in place. **See Figure 8.0**
5. The adjustable creasing roller assembly should then be slid into place by loosening the horizontal adjustment knobs and centering the urethane roller directly over the creasing wheel. Loosen the locking ring and lower the urethane rollers down against the creasing wheel using the roller vertical adjustment knobs. Adjust the tension on each roller to be even and test run product to verify the score is as desired. The roller should be easy to turn with your finger to test for even pressure. Test run product through by jogging material through. If the score is too deep or not deep enough adjust

the creasing roller adjustment knob (see **Figure 7.0**) clock wise to increase the scored depth or counter-clockwise to decrease the scored depth.

6.4 Pre-Creased Product Setup

1. The drive roller (see **Figure 8.0**) next to the creasing wheel is used to drive product through that doesn't need to be creased. Loosen the set screw securing the drive roller to the shaft a move to a location to drive the product through. Locate the adjustable creasing roller assembly (see **Figure 7.0**) directly over the drive using the horizontal adjustment knobs. Adjust the tension by using the roller vertical adjustment knob. Make sure that the roller quick release handle is in the down and locked position before making the adjustment.

6.5 Plow Fold Table Setup (Reference Set Up Sequence 7 thru 14)

1. Adjust the plow fold table horizontally by turning the table horizontal adjustment knob. Adjust the table so the center vacuum belt edge that lines up with the plow is in line with the first fold creasing wheel. **See Figure 6.0**
2. Loosen the horizontal product hold down guide height by using the product hold down guide vertical adjustment knobs. Fold two pieces of product in two and place one after another under the horizontal product hold down guides and tighten the vertical adjustment knobs to lock into place. **See Figure 9.0**
3. Jog product through to test the product fold over bar placement and stop the product before going under the product guide bar. If the product doesn't fold over quickly enough the angle of the bar can be adjusted by loosening the clamp screw and rotating the bar assembly. The height of the bar can also be changed to help product fold over. **See Figure 10.0**
4. Jog the product under the product press down guide and adjust the product guide knobs to press the product together right before going under the creasing pinch roller. The guide bar also aligns the folded product edges up before the edge is pressed to form a tight crease. Adjustment of the product press down guide determines the straightness of product fold. Different guide bar settings may be required for different products. **See Figure 10.0**
5. Jog the product under the creasing pinch roller and adjust the creasing roller pressure by loosening the creasing roller angular adjustment knob and placing the roller on top of the folded product. Press down on the assembly to apply pressure to the product with the spring loaded roller and lock into place. Use the angular fine adjustment knob to achieve the desired amount of pressure and lock into place by using the locking knob. The pressure should be set to just press the product enough to obtain a tight fold. **See Figure 10.0**
6. The last plow fold table should be adjusted using steps 1 through 5.
7. Turn the vacuum tabletop blower pumps on. **See Figure 5.0**
8. Jog product through the entire machine and review the results.
9. Test run the product at machine speed. If the product skews on the plow fold table then the speeds should be reduced to decrease the gap between products.

This allows more vacuum to be used. If the tabletop belts slip first check the spring loaded take up arm tension and then the blower bleeder valves. If the belt tension is adequate then adjustment of the bleeder valves is necessary. The bleeder valves allows vacuum to escape reducing the amount of drag on the tabletop belts. See **Figure 6.0**

7 MAINTENANCE



WARNING

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

Item	Function	Remarks
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.)
Pinch Rollers	Remove glazing and all other foreign materials from roller surfaces.	Use alcohol.
Tabletop Belts	Check tension of flat belts	Add pressure to the spring loaded take up arms

8 TROUBLE SHOOTING



WARNING

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

Problem	Solution
Machine will not start	Unlatch stop button Check stop circuit cords are properly connected. Check speed control is above zero. Check circuit breaker.
Machine will not power up	Check circuit breaker. Check fuses.
Creasing assembly doesn't crease properly	Check for worn press down rollers. Check for proper pressure adjustment on the press creasing press down rollers. Check the drive pinch roller tensions are even. Check quick release clamp.
Product skews during or after folding	Check pinch roller adjustment. Check to make sure vacuum is on. Make sure all guides are set. Reduce machine speed to increase vacuum control of product.
Tabletop belts slip	Check the tension on the spring loaded vacuum belt take up arms. Adjust vacuum bleed valve to reduce the amount of vacuum. Speed belts up to increase spacing between product.

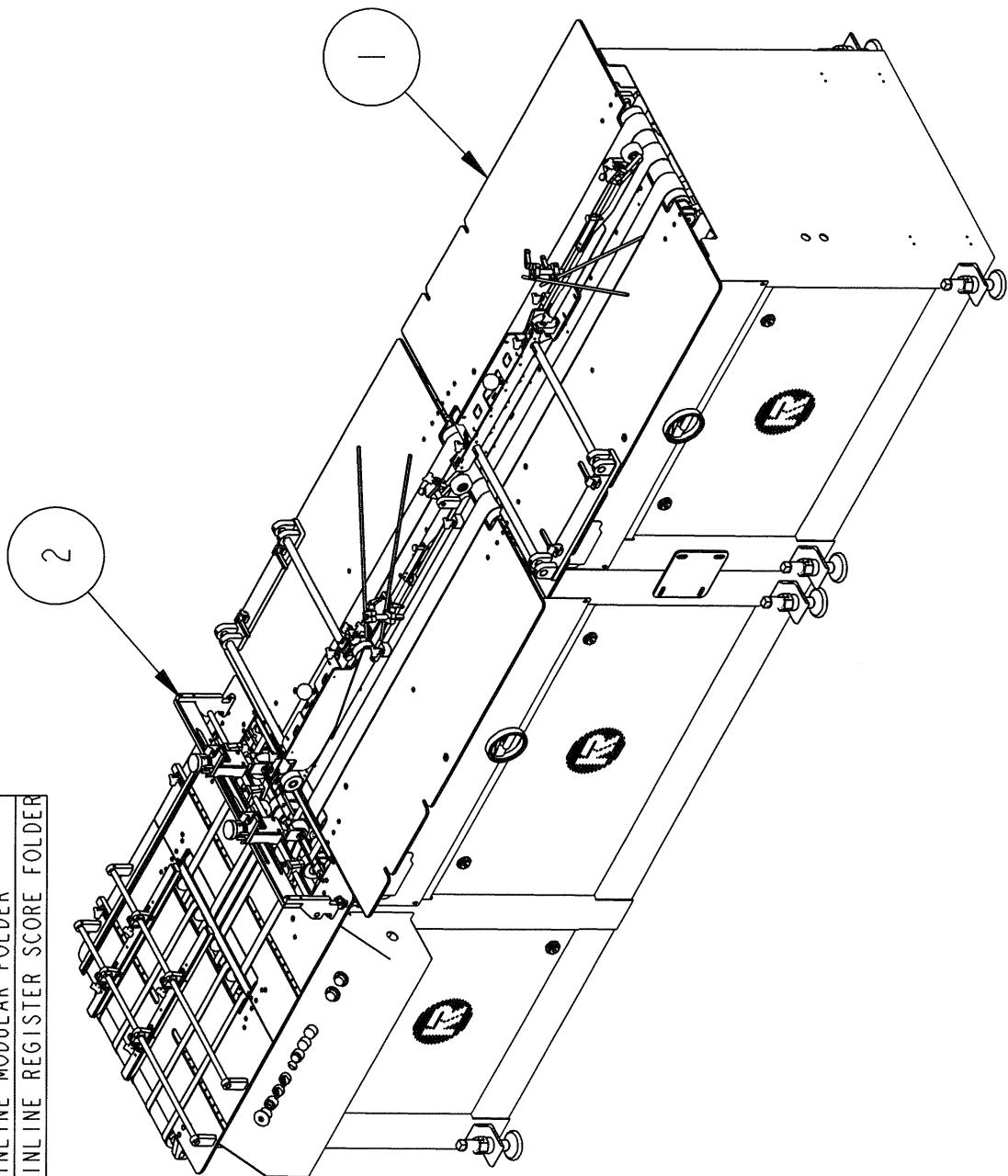
9 PARTS LISTS AND DIAGRAMS

See following pages for parts list and diagrams.

1	.KR219RSDF	ASSY, REGISTER SCORE DUAL FOLD
2	. KR219RSF	ASSY, INLINE REGISTER SCORE FOLDER
3	. 545008-03	ASSY, ANGLED BELTS/SCORING
4	. 530619-02	ASSY, IDLER ROLLER
5	. 545012-02	ASSY, DRIVE ANGLE BELTS
6	. 545139-01	ASSY, LH REGISTER SIDEGUIDE
7	. 545009-02	ASSY, SKID BARS
8	. 538022-04	ASSY, 1/2 HP AC MOTOR MOUNT
9	. 530654-01	ASSY, MOTOR MTG BAR
10	. 545013-03	ASSY, CREEASING TABLETOP
11	. 545015-02	ASSY, FRONT ROLLER
12	. 545018-03	ASSY, OUTFEED BELT/CREEASER
13	. 545025-01	ASSY, FLAT BELT IDLER ROLLER
14	. 545025-02	ASSY, FLAT BELT IDLER ROLLER
15	. 508759-3A	ASSY, ADJUST KNOB
16	. 545150-01	ASSY, CREEASER
17	. 539358-02	ASSY, BELT DIVERT
18	. 545029-02	ASSY, BRIDGE
19	. 545031-01	ASSY, CREEASER PLATEN IDLER ROLLER
20	. 545036-01	ASSY, SPRING ROLLER
21	. 500745A	ASSY, UPPER FEED ROLLER
22	. 545036-02	ASSY, SPRING ROLLER
23	. 536627-01	ASSY, TAKE-UP ECCENTRIC
24	. 545028-03	ASSY, SPRING BELT TAKE-UP
25	. 534220-01	ASSY, ECCENTRIC IDLER STUD
26	. 516045A	ASSY, IDLER 1.376 DIA. X 1.00
27	. 545040-03	ASSY, LH FOLDING TABLETOP
28	. 545041-01	ASSY, FRAME
29	. 545048-02	ASSY, TABLETOP
30	. 539016-02	ASSY, DRIVE ROLLER
31	. 539014-01	ASSY, OUTFEED ROLLER
32	. 500819-2A	ASSY, BEARING LOCK
33	. 539358-01	ASSY, BELT DIVERT
34	. 545046-01	ASSY, OUTFEED VACUUM CHANNEL
35	. 530656-01	ASSY, VACUUM MANIFOLD
36	. 545028-02	ASSY, SPRING BELT TAKE-UP
37	. 538022-03	ASSY, 1/2 HP AC MOTOR MOUNT
38	. 530654-01	ASSY, MOTOR MTG BAR
39	. 545053-03	ASSY, FRAME SLIDE
40	. 545060-03	ASSY, SKID BAR
41	. 545058-03	ASSY, SKID BAR ROLLER
42	. 537760-03	ASSY, SKID BAR ROLLER
43	. 545058-01	ASSY, SKID BAR ROLLER
44	. 537760-01	ASSY, SKID BAR ROLLER

45	.	545064-01	ASSY, PLOW FOLD
46	.	545036-03	ASSY, SPRING ROLLER
47	.	500745A	ASSY, UPPER FEED ROLLER
48	.	545079-03	ASSY, CABINET & COVERS
49	.	545087-03	ASSY, CONTROL PANEL
50	.	538024-01	ASSY, 1 IN. LEVELING LEG
51	.	KR219FM	ASSY, INLINE MODULAR FOLDER
52	.	545040-04	ASSY, FOLDER TABLETOP
53	.	545041-01	ASSY, FRAME
54	.	545048-02	ASSY, TABLETOP
55	.	539016-02	ASSY, DRIVE ROLLER
56	.	500819-2A	ASSY, BEARING LOCK
57	.	539014-01	ASSY, OUTFEED ROLLER
58	.	500819-2A	ASSY, BEARING LOCK
59	.	539358-01	ASSY, BELT DIVERT
60	.	545046-01	ASSY, OUTFEED VACUUM CHANNEL
61	.	530656-01	ASSY, VACUUM MANIFOLD
62	.	545028-02	ASSY, SPRING BELT TAKE-UP
63	.	538022-03	ASSY, 1/2 HP AC MOTOR MOUNT
64	.	530654-01	ASSY, MOTOR MTG BAR
65	.	545053-04	ASSY, FRAME SLIDE
66	.	545060-04	ASSY, SKIDBAR
67	.	545058-02	ASSY, SKID BAR ROLLER
68	.	537760-02	ASSY, SKID BAR ROLLER
69	.	545058-04	ASSY, SKID BAR ROLLER
70	.	537760-04	ASSY, SKID BAR ROLLER
71	.	545064-02	ASSY, PLOW FOLD
72	.	545036-04	ASSY, SPRING ROLLER
73	.	545111-03	ASSY, CABINET & COVERS
74	.	538024-01	ASSY, 1 IN. LEVELING LEG

ITEM QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	KR219FM	ASSY, INLINE MODULAR FOLDER					
2	KR219RSF	ASSY, INLINE REGISTER SCORE FOLDER					



DRAWN BY: A K E Y	SCALE 0 . 063	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. WOODSTOCK, GA 30188 USA
CHECKED BY:	DATE 28 - Jul - 03	.xx	.xxx	AMG.	.5	HEAT TREAT:	KIRK - RUDY, INC WOODSTOCK, GEORGIA
TRACED BY:	MASTER	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED		ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY		MODEL: 219RSDF	title: ASSY, REGISTER SCORE DUAL FOLD
						SHEET NO: 1 OF 3	DRAWING #: KR219RSDF

ITEM QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	1	545008-03 ASSY, ANGLED BELTS/SCORING					
2	1	545040-03 ASSY, LH FOLDING TABLETOP					
3	1	545079-03 ASSY, CABINET & COVERS					

1 219RSF
 REV D WHERE USED

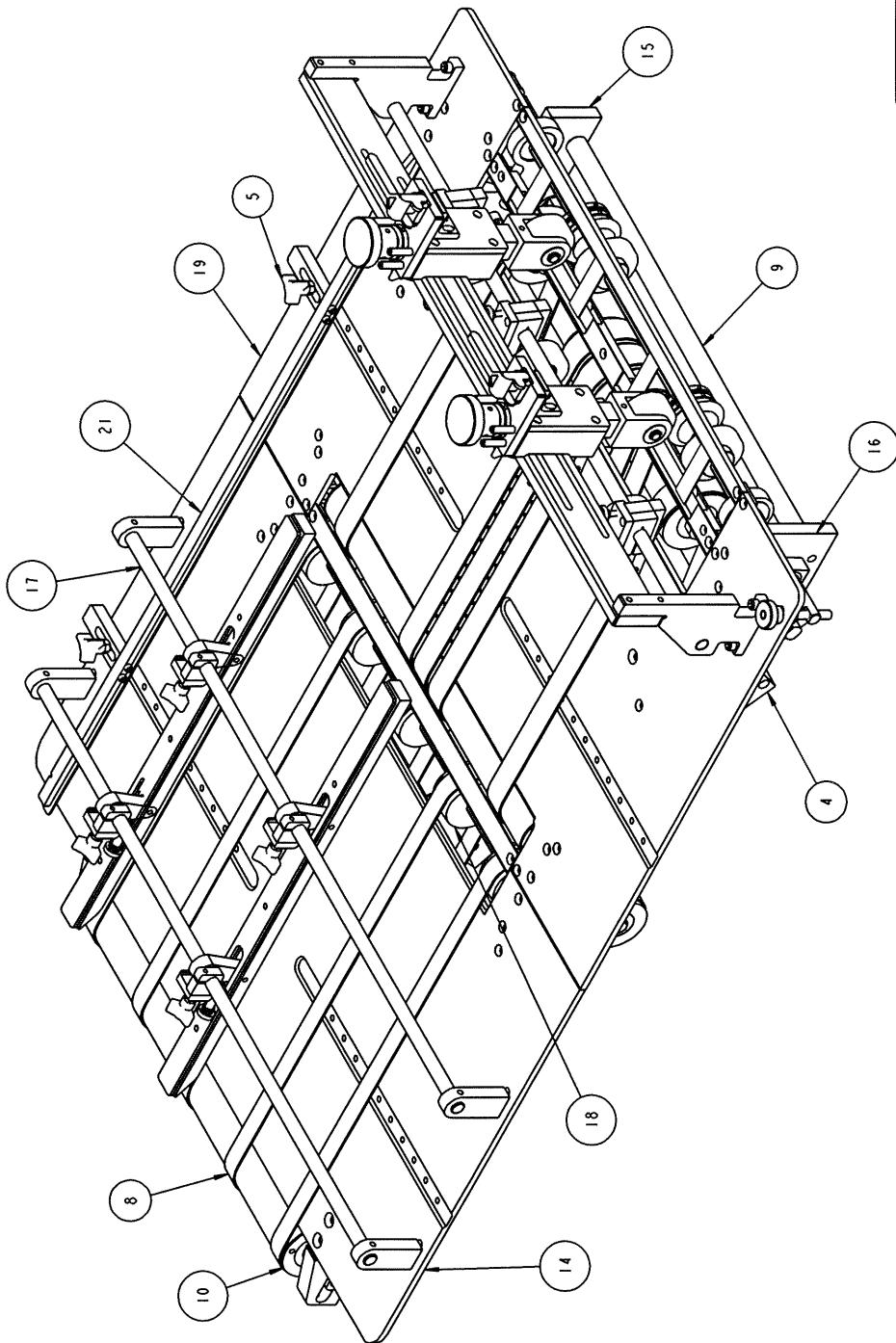
1 219RSF
 REV D WHERE USED

DRAWN BY: A KEY	SCALE 0 . 080	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED		MATERIAL: N / A	THIRD ANGLE PROJECTION	PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE QUOTED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC. WOODSTOCK, GA 30188 USA	
checked by:	DATE 28 - Jul 1 - 03	.xx	.xxx	ANG. .01 .005 .5	HEAT TREAT:	N / A	ASSY, INLINE REGISTER SCORE FOLDER
TRACED BY:	MASTER	FINISH: REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY				N / A	SHEET NO. 1 OF 4

1 219RSF
 REV D WHERE USED

1 219RSF
 REV D WHERE USED

ITEM NO.	PART #	DESCRIPTION	REV NO.	DATE	ECN NO.	BY
1	2	BUSHING, FL. 75010 .87500 .6256				
2	1	102701 SPRING				
3	1	108809 PULLEY, TIMING 121075 .625B .188K				
4	1	500185 BLOCK, SPRING				
5	2	500190 ASSY, KNOB				
6	1	108914-3 BELT, TIMING 124L075				
7	1	108952-15 BELT, TIMING 255L075				
8	5	111838-1 BELT, STRETCH 3/4 X 40 .750				
9	1	500824-12 SHAFT, MOTOR PIVOT				
10	1	530619-02 ASSY, IDLER ROLLER				
11	1	534220-01 ASSY, ECCENTRIC IDLER STUD				
12	1	536687-01 ASSY, TAKEUP ECCENTRIC				
13	1	538022-04 ASSY, 1/2 HP AC MOTOR MOUNT				
14	1	545003-02 TABLETOP, CENTER OUTFEED				
15	1	545006-01 FRAME, RH				
16	1	545007-01 FRAME, LH INFEED				
17	1	545009-02 ASSY, SKIDBAR				
18	1	545012-02 ASSY, DRIVE ANGLE BELTS				
19	1	545013-03 ASSY, CREEASING TABLETOP				
20	1	545028-03 ASSY, SPRING BELT TAKEUP				
21	1	54539-01 ASSY, LH REGISTER SIDEGUIDE				



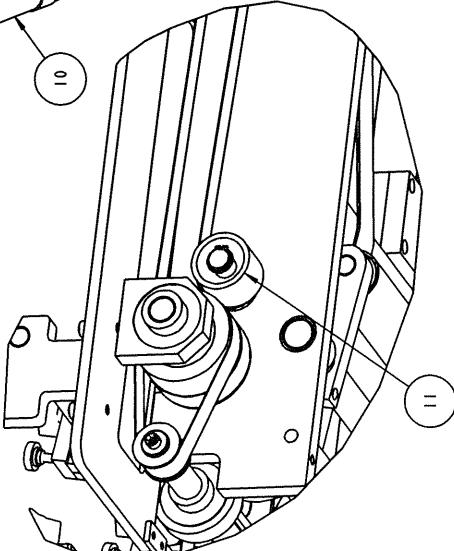
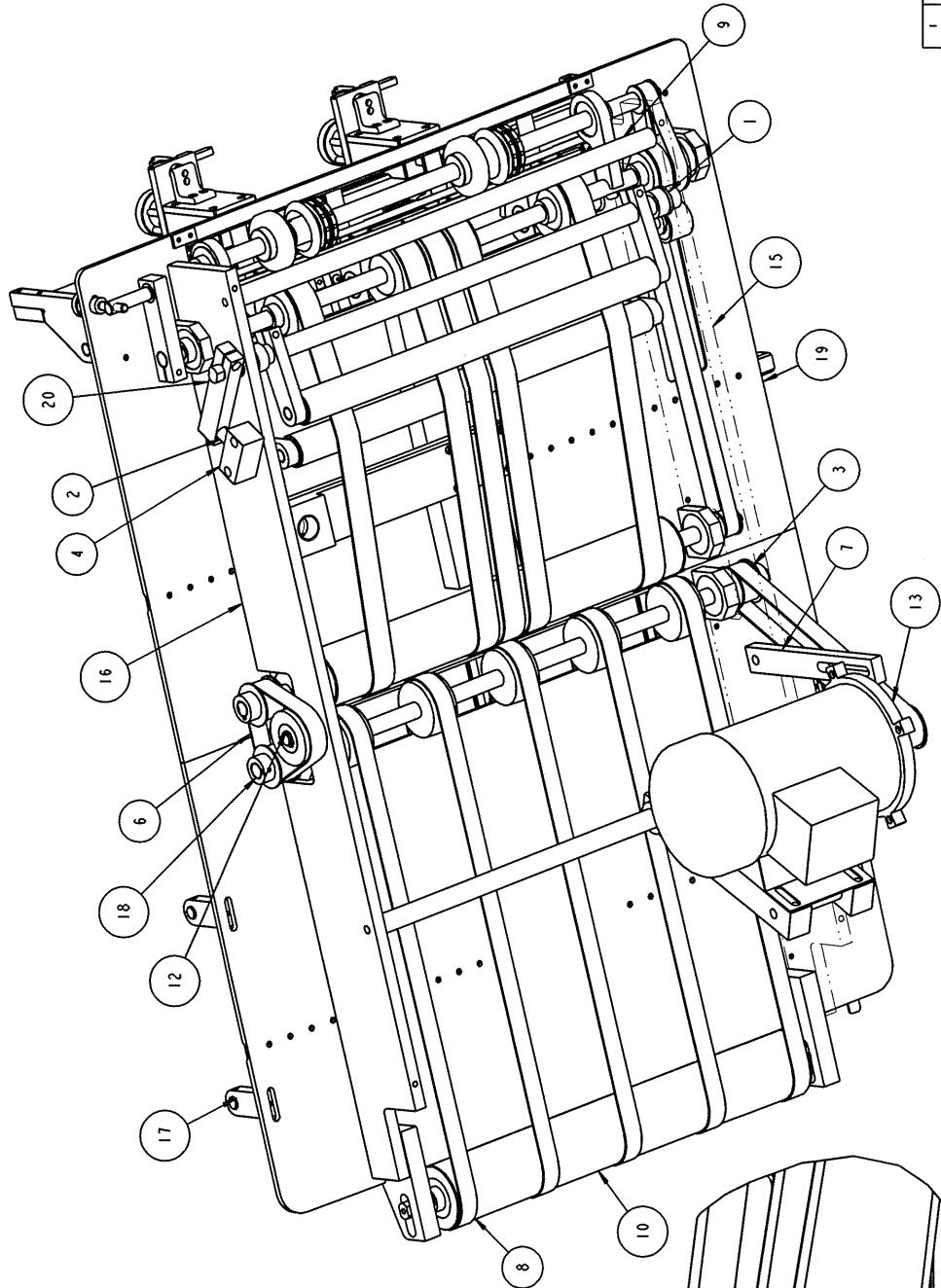
DRAWING BY:		SCALE	0 .250	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED		MATERIAL:	N/A	TELETYPE PROJECTOR PROPRIETARY AND CONFIDENTIAL PRINTED ON 100% RECYCLED PAPER. COPIES ON 100% RECYCLED PAPER ARE NOT ALLOWED. PRINTED ON 100% RECYCLED PAPER. COPIES ON 100% RECYCLED PAPER ARE NOT ALLOWED. PRINTED ON 100% RECYCLED PAPER. COPIES ON 100% RECYCLED PAPER ARE NOT ALLOWED.		REVISIONS:
CHECKED BY:		DATE	08 - Aug - 03	IN	.005	WEIGHT:	N/A	PRINTED ON 100% RECYCLED PAPER. COPIES ON 100% RECYCLED PAPER ARE NOT ALLOWED.	PRINTED ON 100% RECYCLED PAPER. COPIES ON 100% RECYCLED PAPER ARE NOT ALLOWED.	PRINTED ON 100% RECYCLED PAPER. COPIES ON 100% RECYCLED PAPER ARE NOT ALLOWED.
MAILED BY:		MASTER		IN	.005	FINISHED DIMENSIONS FROM THIS DRAWING ARE TO BE USED. ALL OTHER DIMENSIONS SHOWN ON THIS DRAWING ARE FOR INFORMATION ONLY.	N/A	PRINTED ON 100% RECYCLED PAPER. COPIES ON 100% RECYCLED PAPER ARE NOT ALLOWED.	PRINTED ON 100% RECYCLED PAPER. COPIES ON 100% RECYCLED PAPER ARE NOT ALLOWED.	PRINTED ON 100% RECYCLED PAPER. COPIES ON 100% RECYCLED PAPER ARE NOT ALLOWED.
RECORDED BY:				IN	.005	NO. OF COPIES:	100	PRINTED ON 100% RECYCLED PAPER. COPIES ON 100% RECYCLED PAPER ARE NOT ALLOWED.	PRINTED ON 100% RECYCLED PAPER. COPIES ON 100% RECYCLED PAPER ARE NOT ALLOWED.	PRINTED ON 100% RECYCLED PAPER. COPIES ON 100% RECYCLED PAPER ARE NOT ALLOWED.

1	S A M P L E
RECD BY	WHERE USED

ASSY , ANGLED BELTS/SCORING

545008-03

REV NO	DATE	DESCRIPTION	ITEM NO	BY
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NAME BY:		SCALE		DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED		MATERIAL:		TEST ARTICLE PRODUCTION		PROPRIETARY AND CONFIDENTIAL DO NOT COPY OR DISTRIBUTE. THIS DRAWING IS THE PROPERTY OF MAY & BROWN CO., INC. IT IS TO BE MAINTAINED IN CONFIDENTIALITY AND NOT COPIED OR DATED. EXCEPT AS MAY BE AUTHORIZED IN WRITING BY THE PUBLISHER, NO PART OF THIS DRAWING MAY BE COPIED, USED, REPRODUCED OR TRANSMITTED, IN WHOLE OR IN PART, BY TELETYPE, TELEGRAPH, FACSIMILE, ELECTRONIC MAIL, OR ANY OTHER MEANS.		I- RECD SA112 WHERE USED	
A KEY		0 . 230		.11 .005 .005		N/A		DATE 28 - JUL - 03		WEAT TEST N/A		MATERIAL: ASSY, ANGLED BELTS/SCORING BELT 3	
CHECKED BY:												MATERIAL: RUBBER N/A	
TRACK #::		MASTER										MATERIAL: RUBBER N/A	
PRINTED ON : 5450008-03													

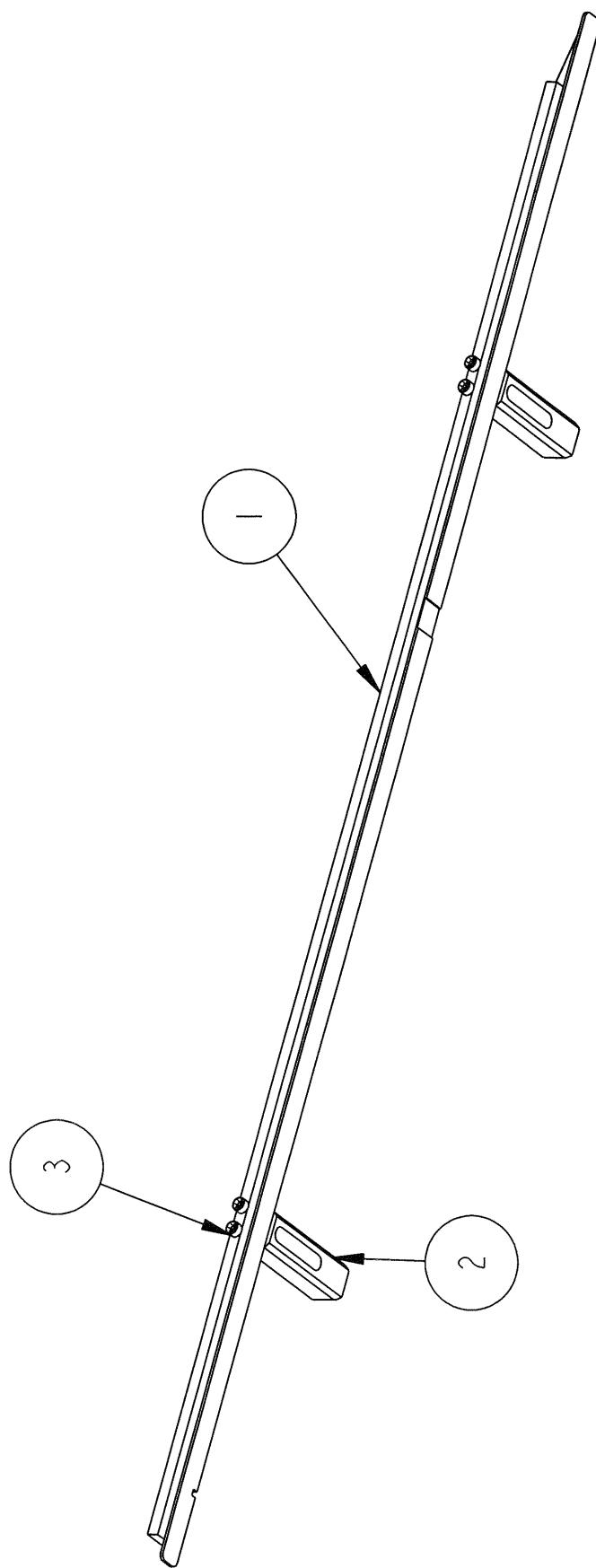
KIRK - RUDY, INC.
WOODSTOCK, GEORGIA

ITEM QTY	PART #	DESCRIPTION	REV NO	DATE	ECN NO	BY
1	4	100162 BUSHING, SL. 50010 .2500 .325LG				
2	2	100619 WASHER, FLAT 10-32				
3	2	102132 KNOB, 10-32 CAP SCREW				
4	2	102714 SPRING, COMPRESSION				
5	2	105220 PIN, ROLL .125X .750				
6	21	190770 STEEL BALL				
7	21	190889 DISC, 1/2 DIA FELT				
8	4	503556 POST, SIDEGUIDE				
9	2	500781-18 SHAFT, SIDE GUIDE ADJ				
10	4	500801-11 LINK, SKID-REAR				
11	4	500801-11A ASSY, LINK				
12	2	537879-01 BLOCK, SKID BAR ADJUST CLAMP				
13	4	537884-01 CAP, SKID BAR ADJUST				
14	2	537885-01 BLOCK, SKID BAR ADJUST CLAMP				
15	4	537886-01 ASSY, TRIKNOB 10-32 X 2.000 LNG				
16	2	545000-01 SKID BAR, BALL				
17	2	545001-01 RETAINER PLATE, SKID BAR				
18	1	545009-02 ASSY, SKIDBAR				
19	3	CSD064 SCREW, SHCS 10-32X .375				
20	2	CSD0210 SCREW, SHCS 10-32X1.250				

1	SAB12
2	WRENCH SET
3	KIRK - RUDY, INC WOODSTOCK, GEORGIA
4	PROFESSIONAL AND COMMERCIAL MANUFACTURING & ASSEMBLY OF EQUIPMENT FOR THE INDUSTRIAL, CONSTRUCTION, EXPLOSIVE, MILITARY, AIRPORT AND AUTOMOTIVE INDUSTRIES WOODSTOCK, GA 30188 USA
5	TEL:
6	219RSF
7	10F 1

DRAWING # 545009-02

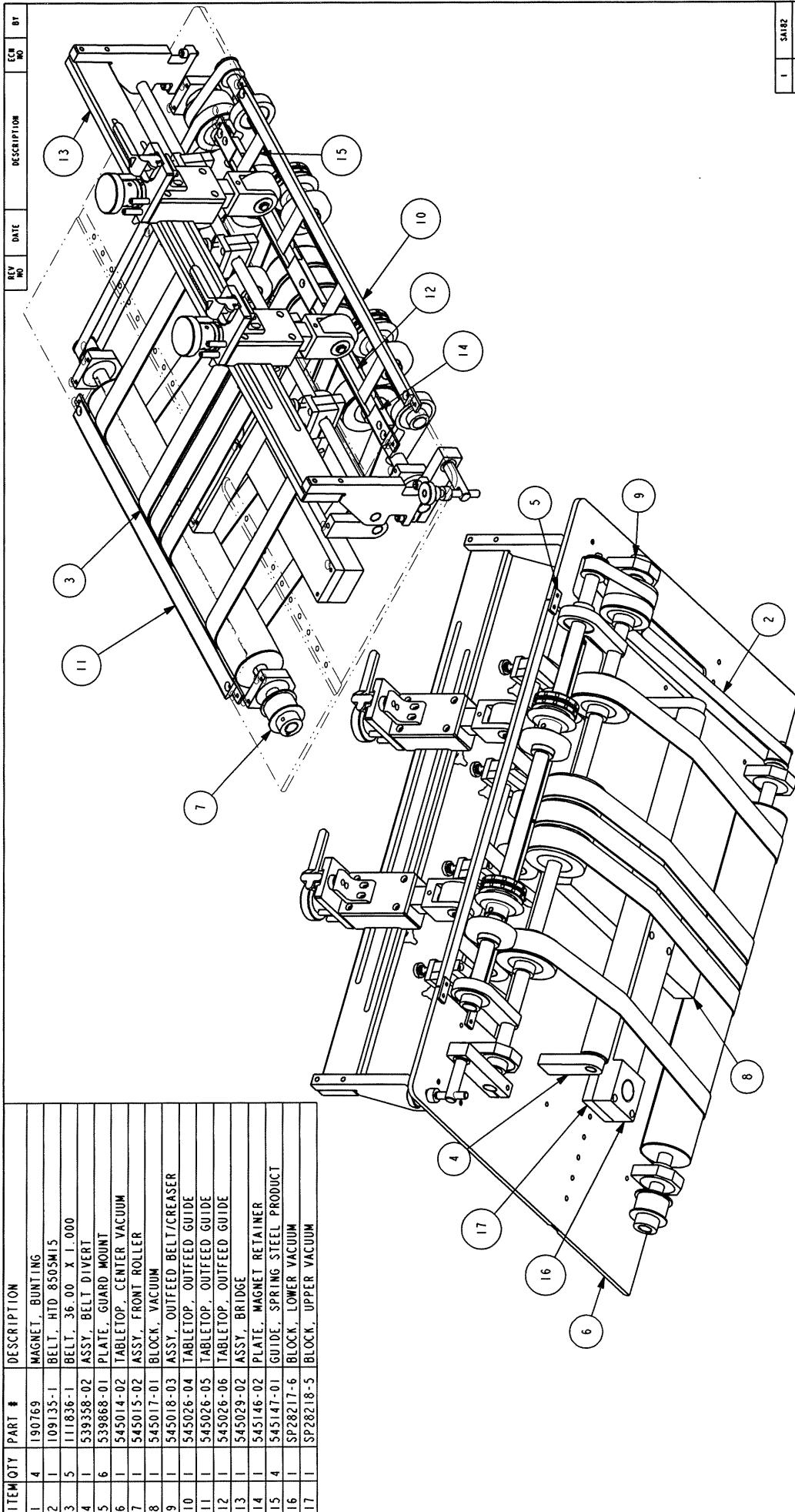
ITEM	QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	1	545140-01	SIDEGUIDE, REGISTER					
2	2	545149-01	BAR, SIDEGUIDE MOUNT					
3	4	CSDD240	SCREW, SHCS 8-32X.750					



5	SP80500
REQ'D	WHERE USED
<p>DRAWN BY: A KEY SCALE 0 . 313 DIMENSIONAL TOLERANCES MATERIAL: N/A THIRD ANGLE PROJECTION PROPRIETARY AND CONFIDENTIAL CHECKED BY: DATE 28 - JU 1 - 03 UNLESS NOTED NO PORTION OF THIS DRAWING TRACED BY: MASTER FINISH N/A HEAT TREAT: N/A MAY BE QUOTED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC. WOODSTOCK, GA 30188 USA</p>	
<p>MODEL: 219RSF TITLE: ASSY, LH REGISTER SIDEGUIDE SHEET NO. 10F1 DRAWING # 545139-01</p>	

Drawing #

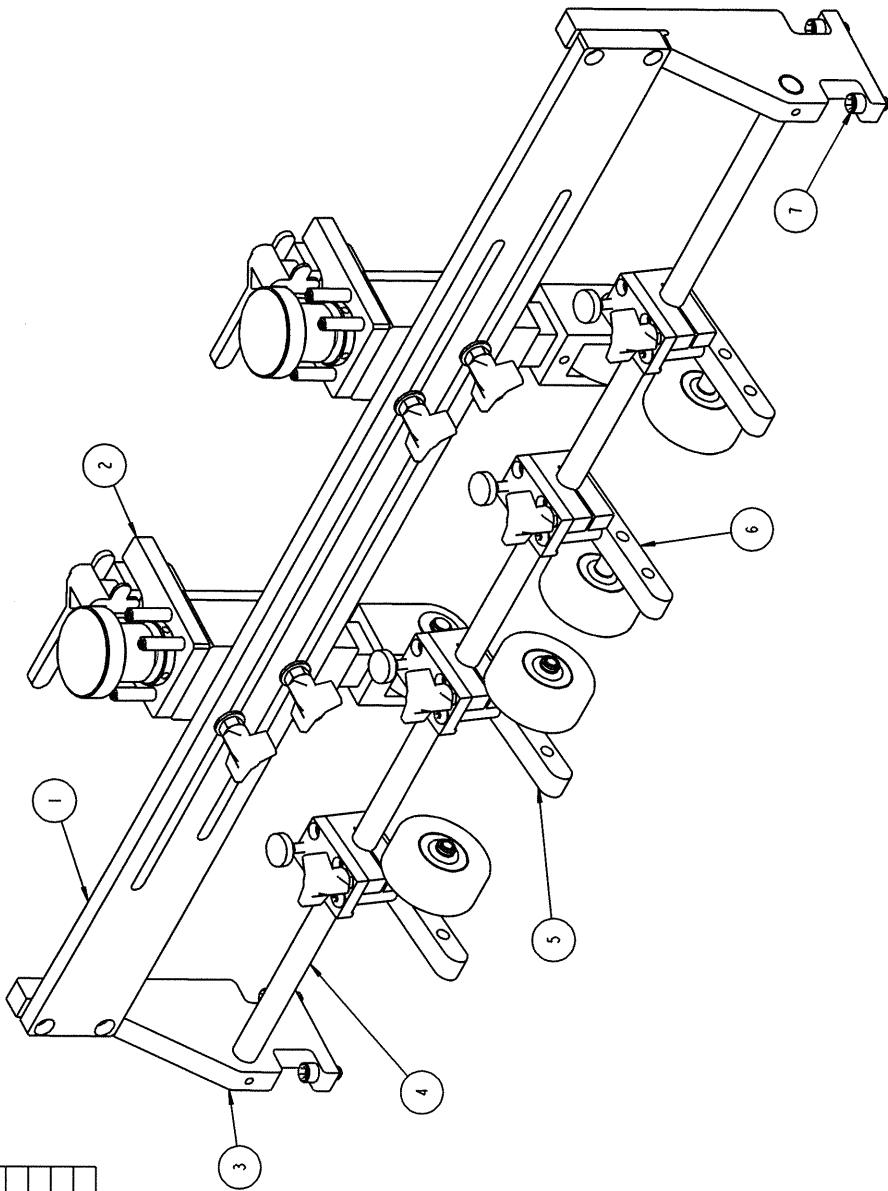
545013-03



1	SA182
RECO'D	WHEN USED
KIRK - RUDY, INC.	
WOODSTOCK, GEORGIA	
1	ASSY, CREEASING TABLETOP
Drawing #	
545013-03	

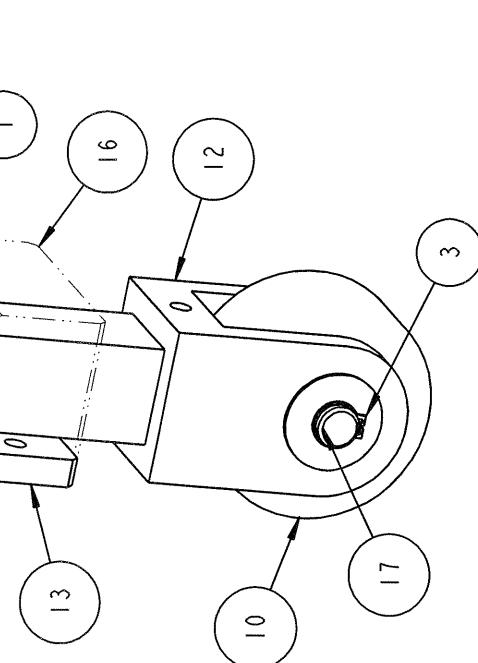
DRAWING #: A KEY		SCALE: 0 .250		DIMENSION, TOLERANCES UNLESS OTHERWISE SPECIFIED		MATERIAL: N/A		DRAWING AND CONSTRUCTION NOTES: N/A		PRODUCTION AND CONSTRUCTION NOTES: N/A	
CHANGED BY:	DATE: 26-Mar-03	IN:	MM:	IN:	MM:	IN:	MM:	IN:	MM:	IN:	MM:
MASTER				N/A		N/A		N/A		N/A	
TRACED BY:				1 OF 1				1 OF 1			

ITEM	QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	1	545030-02	BAR, BRIDGE CROSS					
2	2	545031-01	ASSY, CREEPER PLATEN IDLER ROLLER					
3	2	545034-01	PLATE, BRIDGE SUPPORT					
4	1	545035-02	SHAFT, PINCH ROLLER SUPPORT					
5	2	545036-01	ASSY, SPRING ROLLER					
6	2	545036-02	ASSY, SPRING ROLLER					
7	4	CSD293	SCREW, SHCS 1/4-20X .625					



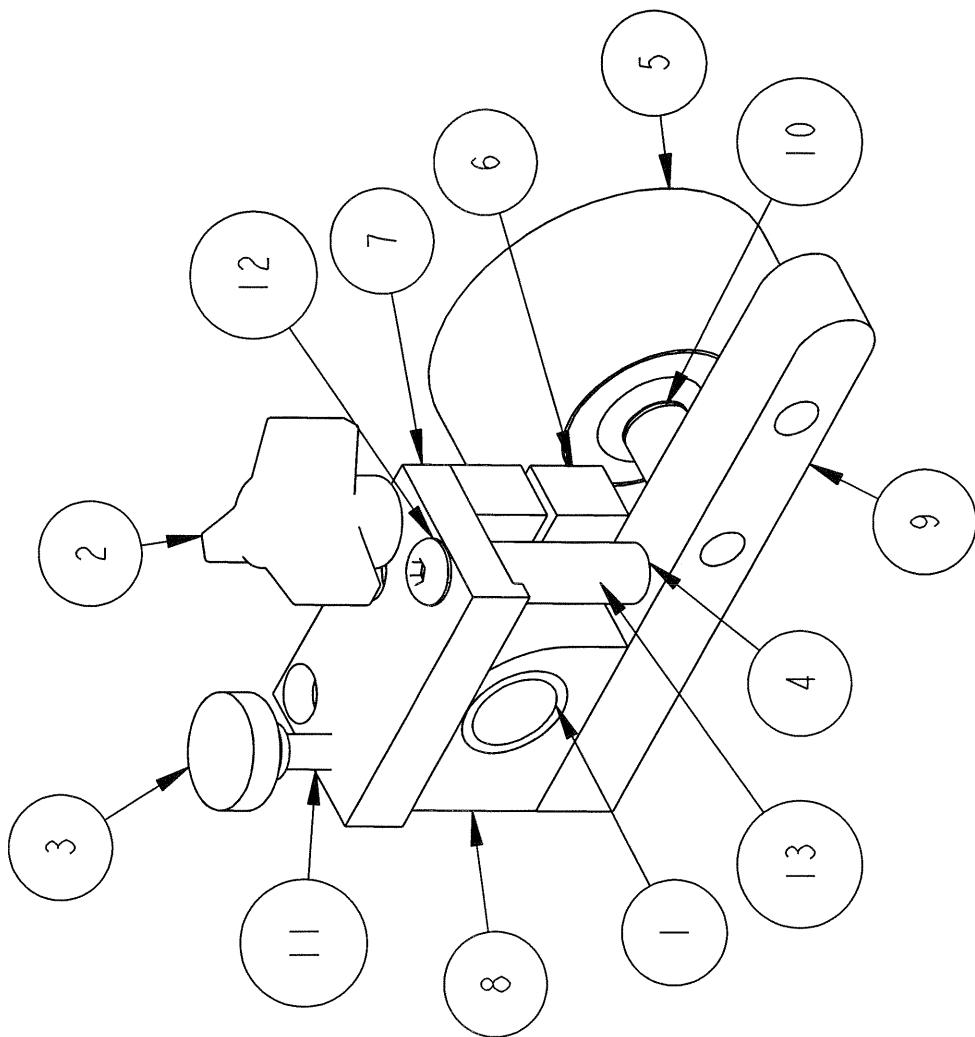
1	S4182
REV'D	WHERE USED
PROPRIETARY AND CONFIDENTIAL	
NO PART OF THIS DRAWING MAY BE COPIED OR REPRODUCED	
EXCEPT WITH WRITTEN PERMISSION	
KIRK-RIDY, INC.	
WOODSTOCK, GEORGIA	
PRINTED ON 2/19/96	
TIME:	21:49:56
ASSY, BRIDGE	DRAWING NO. 545029-02
SCALE: 0.438	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED
IN. MM.	IN. MM.
XX	XX
IN. MM.	IN. MM.
MASTER	ALL SURFACES UNLESS OTHERWISE NOTED
IN. MM.	ALL SURFACES ARE TO BE FINISHED
IN. MM.	DO NOT SCALE - DRAW TO ONE SET OF DIMENSIONS

ITEM	QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	2	100401	WASHER, THRUST TB410					
2	1	102701	SPRING					
3	2	104100	SNAPRING, .375					
4	1	104400	BOLT - HEX HEAD					
5	1	190733	CLAMP, QUICK RELEASE					
6	2	500790	ASSY, KNOB					
7	1	500807	NUT - LOCK					
8	1	500809	SLEEVE - THREADED					
9	1	500812	KNOB, ROLLER ADJUSTMENT					
10	1	500745A	ASSY, UPPER FEED ROLLER					
11	4	500799-10	STUD, BRIDGE (LONG)					
12	1	500811A	ASSY, FORK WITH BEARINGS					
13	1	537306-03	PLATE, UPPER BELT SUPP					
14	1	537308-02	ANGLE, UPPER BELT LIFT					
15	1	539976-02	BAR, UPPER BELT LIFT					
16	1	545032-01	BAR, BRIDGE					
17	1	545039-01	SHAFT, IDLER ROLLER					



DRAWN BY: A KEY	SCALE 0 . 625	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED			MATERIAL: N/A	THIRD ANGLE PROJECTION	PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE QUOTED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC. WOODSTOCK, GA 30188 USA
CHECKED BY:	DATE 26-Mar-03	.xx	.xxx	.005	HEAT TREAT: N/A	MODEL: SA182	KIRK - RUDY, INC WOODSTOCK, GEORGIA
TRACED BY:	MASTER	REMOVE ALL BURRS, SHARP EDGES UNLESS OTHERWISE NOTED ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY			FINISH: N/A	SHEET NO.: 1 OF 1	DRAWING #: 545031-01
						I	535 RECD WHERE USED

ITEM	QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	1	100135	BUSHING, SL. 500ID. 625OD. 500LG					
2	1	102119	KNOB					
3	1	102132	KNOB, 10-32 CAP SCREW					
4	1	102704	SPRING, COIL					
5	1	500745A	ASSY, UPPER FEED ROLLER					
6	1	537512-01	BLOCK, BUMP TURN ROLLER MNT					
7	1	537513-01	PLATE, BUMP TURN CAP					
8	1	537514-01	BLOCK, BUMP TURN PIVOT					
9	1	545037-01	ARM, PINCH ROLLER MOUNT					
10	1	545038-01	STUD, IDLER ROLLER					
11	1	CSDD267	SCREW, SHCS 10-32X.750					
12	1	CSFF58	SCREW, BUTTON HEAD #10-32X.500					
13	1	CSFF60	SCREW, BUTTON HEAD #10-32X.750					
14	1	HMSN10	NUT, HEX #10-32					



DRAWN BY: A K E Y	SCALE 1 . 000	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED			MATERIAL: N / A	THIRD ANGLE PROJECTION - - -	PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE QUOTED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC. WOODSTOCK, GA 30188 USA	
CHECKED BY:	DATE 26-Mar-03	.xx	.xxx	.005	HEAT TREAT: N / A		MODEL: SA 182	TITLE: ASSY, SPRING ROLLER
TRACED BY:	MASTER	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED			FINISH: N / A	SHEET NO.: 10F1	DRAWING #: 545036-01	
		ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY						

2	SA164-2
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ITEM	QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	1	100135	BUSHING, SL. 500 ID. 625 OD. 500 LG					
2	1	102119	KNOB					
3	1	102132	KNOB, 10-32 CAP SCREW					
4	1	102704	SPRING, COIL					
5	1	500745A	ASSY, UPPER FEED ROLLER					
6	1	537512-01	BLOCK, BUMP TURN ROLLER MNT					
7	1	537513-01	PLATE, BUMP TURN CAP					
8	1	537514-01	BLOCK, BUMP TURN PIVOT					
9	1	545037-01	ARM, PINCH ROLLER MOUNT					
10	1	545038-01	STUD, IDLER ROLLER					
11	1	CSDD267	SCREW, SHCS 10-32X.750					
12	1	CSFF58	SCREW, BUTTON HEAD #10-32X.500					
13	1	CSFF60	SCREW, BUTTON HEAD #10-32X.750					
14	1	HMSN10	NUT, HEX #10-32					

2	SA164-2
REQ'D	WHERE USED

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

THIRD ANGLE PROJECTION	
MODEL:	SA182
TITLE:	ASSY, SPRING ROLLER
DRAWING #	10F1

DRAWN BY:	A KEY	SCALE	1 . 000	MATERIAL:	N / A
				DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	
				.XX	.XXX
				.01	.005
				.5	.5
				HEAT TREAT:	N / A
				FINISH:	N / A

CHECKED BY:	26 - Mar - 03	REMOVED ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED
TRACED BY:	MASTER	ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY

DRAWING #

545018-03

ITEM QTY	PART #	DESCRIPTION	REV A6	DATE	ECN NO	BY
1	100256	BUSHING, SL .500ID 750OD 625LG				
2	102204	COLLAR .313				
3	103804	BEARING, HUB .625				
4	2	101104	BOLT, SHOULDER S/16X3/4			
5	1	109719	PULLEY, TIMING 165M15 .375B .125K BELT, HD 2705W20			
6	1	109138 .1 PULLEY, TIMING 365M15 1.574 DIA				
7	1	109722 .1 ASSY, BEARING LOCK				
8	2	500819 .3A ASSY, BEARING ADJUST KNOB				
9	1	508759 .3A				
10	1	531683 .01 WASHER, NO. 10 .63 OD .125TH				
11	1	545019 .02 SHAFT, SPRING LEVER				
12	1	545020 .02 SHAFT, CREAISING ROLLER				
13	1	545021 .01 ARM, CREAISING ROLLER ADJUST				
14	1	545022 .01 ARM, CRADLE FEEDER HUBRG RH				
15	1	545022 .02 ARM, FEEDER CRADLE HUBRG LH				
16	2	545025 .01 ASSY, FLAT BELT IDLER ROLLER				
17	1	545025 .02 ASSY, FLAT BELT IDLER ROLLER				
18	1	545026 .02 SHAFT, CREAISING WHEEL ADJUSTMENT				
19	2	545150 .01 ASSY, CREASER				
20	2	545394 .01 ROLLER, LOWER DRIVE				
21	1	CSD0255 SCREW, SHCS 10-32X .500				

1	SA182
RECD	WHERE USED
PROPLANT AND CONFIDENTIAL INFORMATION CONTAINED HEREIN IS UNCLASSIFIED AND MAY BE COPIED OR DISCLOSED EXCEPT AS PROVIDED IN THE INFORMATION REPORTING AND HANDLING OF PROPRIETARY AND CONFIDENTIAL INFORMATION REPORT. THIS INFORMATION IS THE PROPERTY OF KIRK - RUDY, INC., WOODSTOCK, GA 30088 USA.	
PRINT	ASSY, OUTFEED BELT/CREASER
545018-03	

DRAWING #:

A KEY

SCALE

0 .625

DIMENSIONAL TOLERANCES

UNLESS OTHERWISE NOTED

N/A

MATERIAL:

N/A

PART NUMBER:

N/A

MANUFACTURER:

N/A

DATE:

28-Jul-03

CHECKED BY:

MASTER

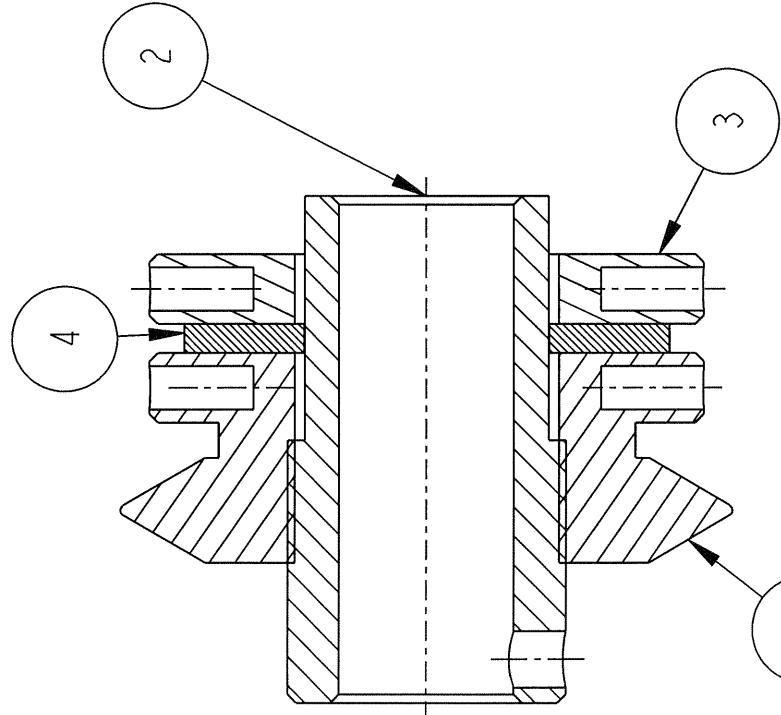
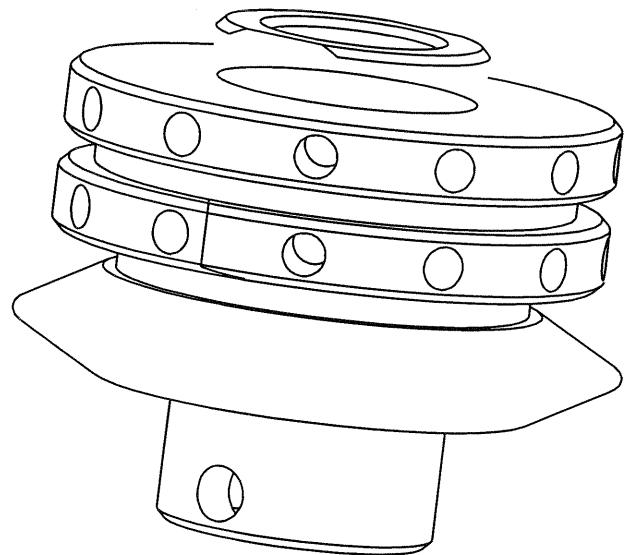
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NOTES:

NOT CALCULATED. NO DIMENSIONS ONLY

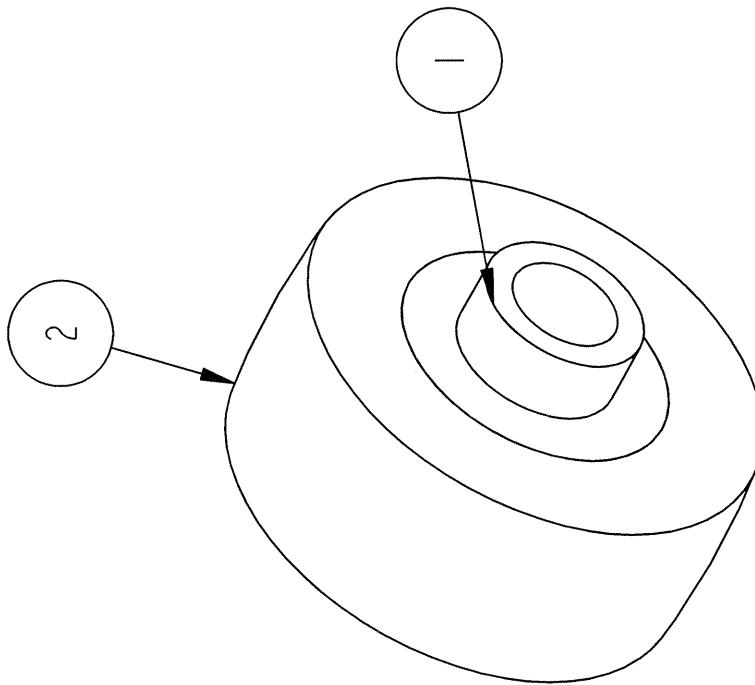
ITEM	QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	1	545023-03	WHEEL, CREASE					
2	1	545151-01	SLEEVE, CREASER WHEEL					
3	1	545152-01	RING, CREASER LOCKING					
4	1	545174-01	WASHER, CREASER LOCK					



SECTION A - A

DRAWN BY: A KEY	SCALE 1 . 500	MATERIAL: N / A	THIRD ANGLE PROJECTION NO PORTION OF THIS DRAWING MAY BE QUOTED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC. WOODSTOCK, GA 30188 USA
CHECKED BY:	DATE 01 - May - 03	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED .01 -.005 .5 XXX ANG.	HEAT TREAT: N / A
TRACED BY:	MASTER	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY	MODEL: SA182
			Sheet No.: 10F1
			DRAWING #: 545150-01
			REV'D SA182
			WHERE USED

ITEM	QTY	PART #	DESCRIPTION
1	2	103804	BEARING, HUB .625
2	1	545024-01	ROLLER, CROWNED IDLER

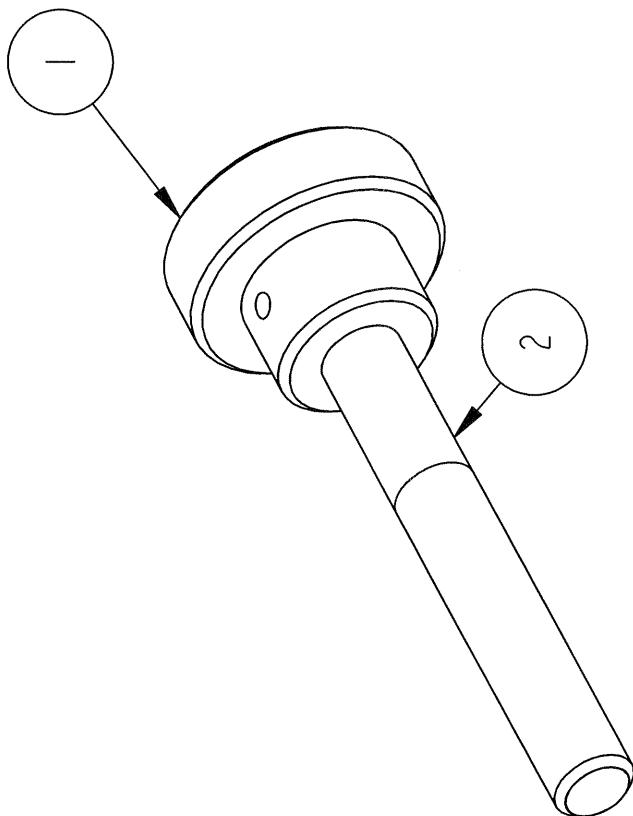


DRAWN BY: A KEY	SCALE 1 . 000	MATERIAL: N/A	THIRD ANGLE PROJECTION NO PORTION OF THIS DRAWING MAY BE QUOTED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC. WOODSTOCK, GA 30188 USA
CHECKED BY:	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED .xx .xxx .05 .5 ANG.	HEAT TREAT: N/A	MODEL: SA182
TRACED BY:	DATE 26-Mar-03 REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY	FINISH: N/A	TITLE: ASSY , FLAT BELT IDLER ROLLER
		SHEET NO.: 10F1	DRAWING #: 545025-01

ITEM	QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	2	103804	BEARING, HUB .625					
2	1	545024-02	ROLLER, CROWNED IDLER					

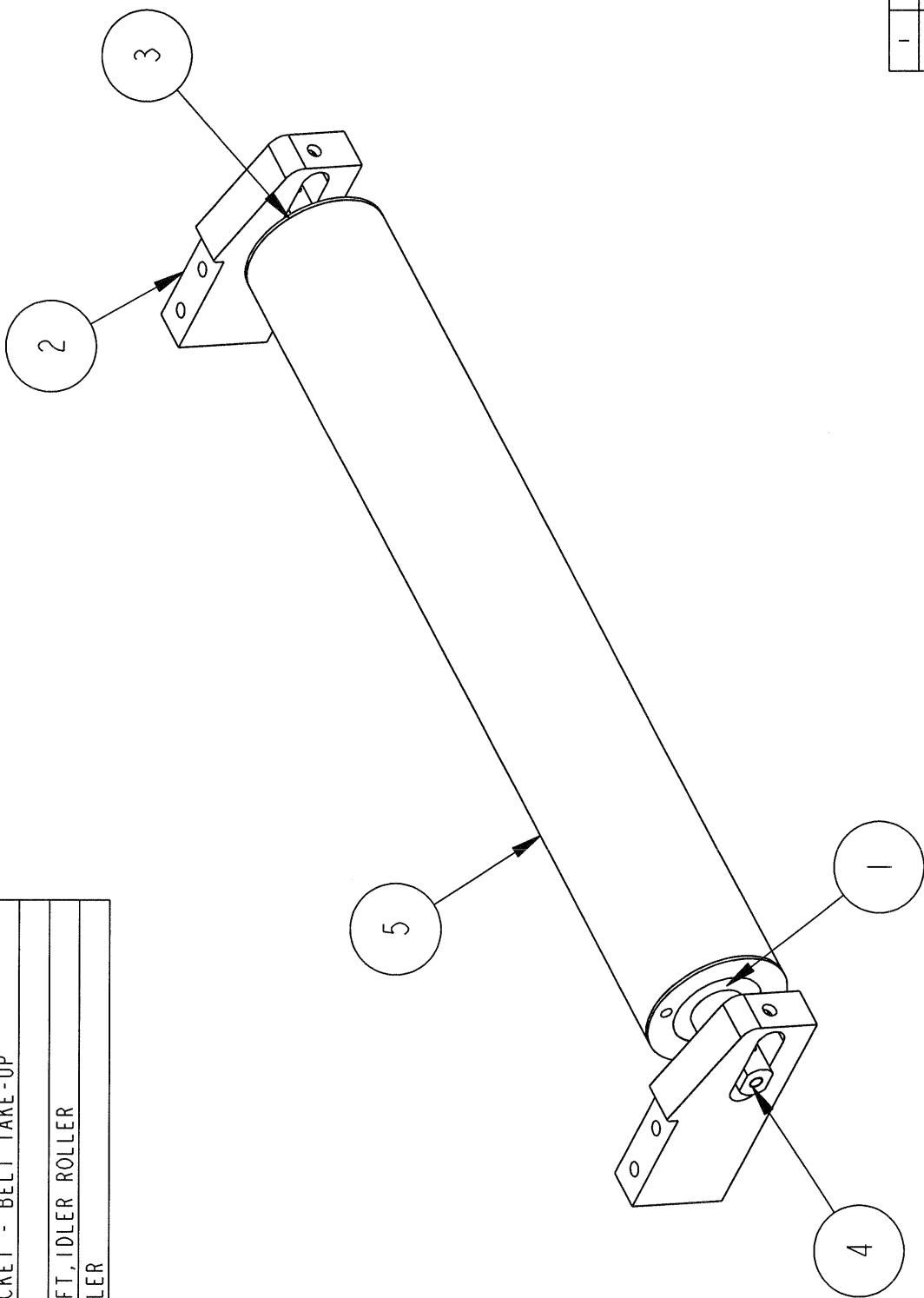
DRAWN BY: A KEV	SCALE 1 . 000	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED			MATERIAL: N / A	THIRD ANGLE PROJECTION - - -	PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE QUOTED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC. WOODSTOCK, GA 30188 USA	
CHECKED BY:	DATE 26-Mar-03	.xx	.005	.5	HEAT TREAT: N / A	MODEL: SA182	TITLE: ASSY, FLAT BELT IDLER ROLLER	
TRACED BY:	MASTER	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY			N / A	SHEET NO.: 10F1	DRAWING #: 545025-02	

ITEM	QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	1	508759-1	KNOB, ADJUSTMENT					
2	1	508759-3	SCREW					



4	S A 164-2
REO'D	WHERE USED
 KIRK - RUDY, INC. WOODSTOCK, GEORGIA	
<small>PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE QUOTED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC. WOODSTOCK, GA 30188 USA</small>	
DRAWN BY: A KEY SCALE: 1 . 500 DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED .xx .xxx .005 .5 ANG.	THIRD ANGLE PROJECTION  MATERIAL: N / A HEAT TREAT: N / A
CHECKED BY: DATE: 26 - Mar - 03 TRACED BY: MASTER	MODEL: S A 182 REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY
	SHEET NO.: 1 OF 1 DRAWING #: 508759-3A

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	2	500836	HUB					
4	1	500823-14	SHAFT, IDLER ROLLER					
5	1	500835-17	ROLLER					



DRAWN BY:	A KE Y	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. WOODSTOCK, GA 30188 USA
CHECKED BY:		DATE	28 - JUL - 03	.XX .XXX .005 .5 ANG.	HEAT TREAT: N / A	MODEL: 219RSF	TITLE: ASSY, IDLER ROLLER
TRACED BY:	MASTER			REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY	FINISH: N / A	SHEET NO. OF 1	DRAWING # 530619-02

ITEM	QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	2	103804	BEARING, HUB .625					
2	1	108809	PULLEY, TIMING 12L075 .625B .188K					
3	2	500819-2	BLOCK, BEARING					
4	5	536898-01	ROLLER, DRIVE CROWNED 2.25DIA					
5	1	545002-02	SHAFT, FRONT ROLLER					

1 219RSF

REQ'D WHERE USED

DRAWN BY:
A KEY

SCALE: 0 .500

DATE: 28 - JUL - 03

CHECKED BY:

TRACED BY: MASTER

MATERIAL: N / A

DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED

.xx	.xxx	.005	.5
.01	.005	.005	.005

HEAT TREAT: N / A

FINISH: N / A

REMOVED ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED

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

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

KR KIRK - RUDY, INC.
WOODSTOCK, GEORGIA

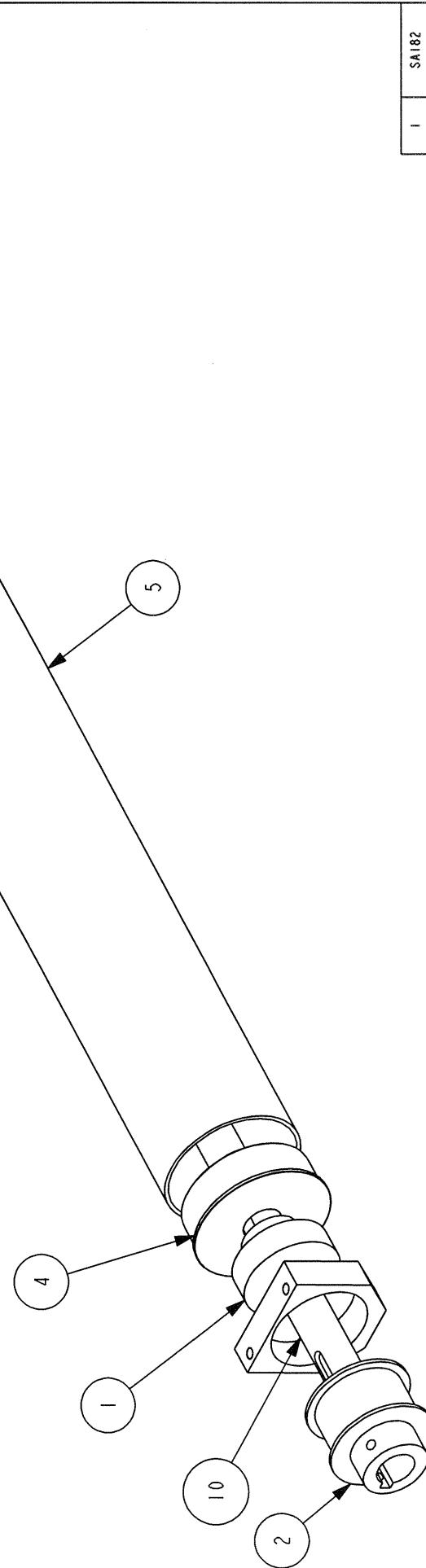
MODEL: 219RSF

TITLE: ASSY, DRIVE ANGLE BELTS

SHEET NO: 1 OF 1

DRAWING #: 545012-02

ITEM QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	2	103804 BEARING, HUB .625					
2	1	108809 PULLEY, TIMING 12L075 .625B .188K					
3	1	109719 PULLEY, TIMING 165M15 .375B .125K					
4	2	500838 HUB-BELT DRIVE					
5	1	500742-15 ROLLER, TUBE BELT DRIVE					
6	2	500819-1 BLOCK, BEARING					
7	2	500819-1A ASSY, BEARING LOCK					
8	1	537683-01 WASHER, NO. 10 .63 OD .125TH					
9	1	545015-02 ASSY, FRONT ROLLER					
10	1	545016-02 SHAFT, FRONT ROLLER					
11	1	CSDD265 SCREW, SHCS 10-32X .500					



1	SA182
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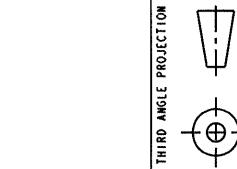
DRAWN BY:	SCALE	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED			MATERIAL:	THIRD ANGLE PROJECTION	PROPRIETARY AND CONFIDENTIAL
A KEY	0 .438	.01	.005	.5	N / A		NO PORTION OF THIS DRAWING MAY BE QUOTED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY INC. WOODSTOCK, GA 30188 USA
CHECKED BY:	DATE	.xx	.xxx	.ANG.	HEAT TREAT:		
	28 - Jul 1 - 03				N / A		
TRACED BY:	MASTER	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED			FINISH:		
		ALL DIMENSIONS ARE FINISHED. DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY			N / A		
					SHEET NO. 1 OF 1	DRAWING #	

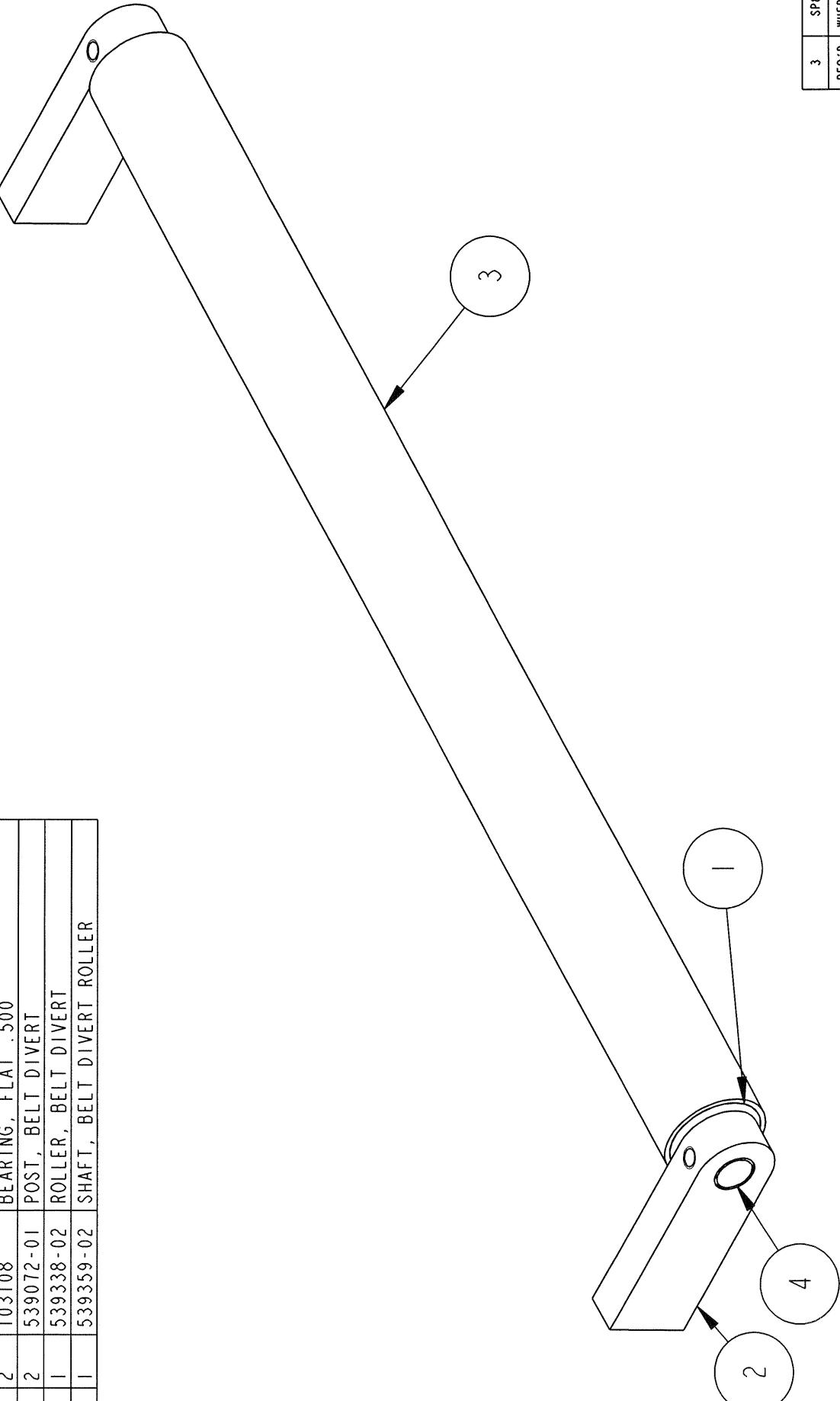
KR KIRK - RUDY, INC.
WOODSTOCK, GEORGIA

ASSY, FRONT ROLLER

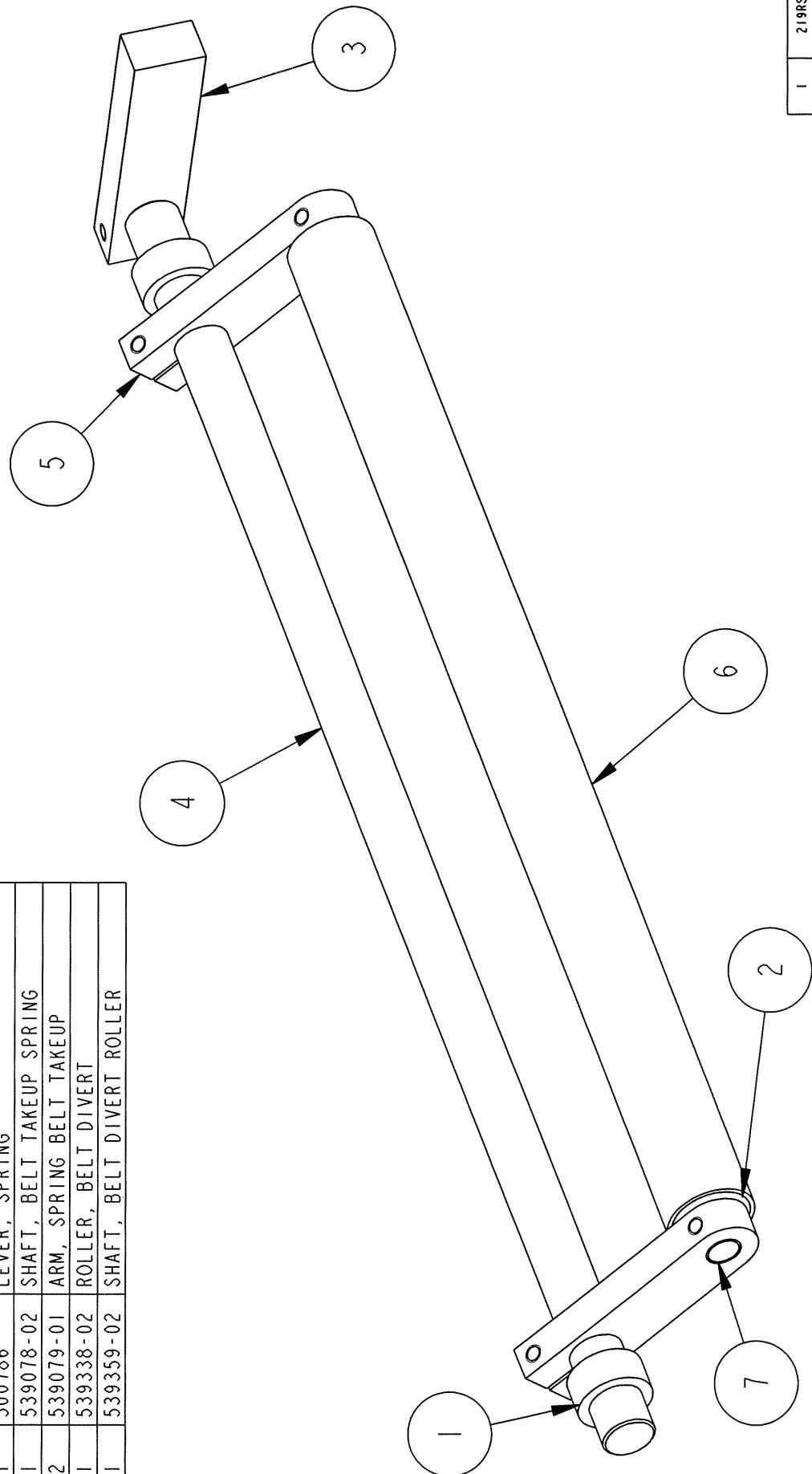
545015-02

ITEM	QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	2	103108	BEARING, FLAT .500					
2	2	539072-01	POST, BELT DIVERT					
3	1	539338-02	ROLLER, BELT DIVERT					
4	1	539359-02	SHAFT, BELT DIVERT ROLLER					

DRAWN BY: A KEY	SCALE 0 . 625	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED			MATERIAL: N / A	THIRD ANGLE PROJECTION 	PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE QUOTED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC. WOODSTOCK, GA 30188 USA	
CHECKED BY:	DATE 24 - May - 00	.xx	.xxx	.ANG.	HEAT TREAT: N / A	MODEL: SP 84000	TITLE: ASSY, BELT DIVERT	
TRACED BY:	MASTER	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY			N / A	SHEET NO.: 10F1	DRAWING #: 539358-02	



ITEM QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	2	102207 COLLAR .750					
2	2	103108 BEARING, FLAT .500					
3	1	500786 LEVER, SPRING					
4	1	539078-02 SHAFT, BELT TAKEUP SPRING					
5	2	539079-01 ARM, SPRING BELT TAKEUP					
6	1	539338-02 ROLLER, BELT DIVERT					
7	1	539359-02 SHAFT, BELT DIVERT ROLLER					



DRAWN BY:	A KEY	SCALE	0 . 500	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	N / A	MATERIAL:	PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE QUOTED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC. WOODSTOCK, GA 30188 USA	
CHECKED BY:		xx	.xxx	ANG.		HEAT TREAT:		THIRD ANGLE PROJECTION
TRACED BY:		.01	.005	.5		FINISH:	9RSF	MODEL:
RECD WHERE USED		DATE		28 - Jul - 03	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED		ASSY , SPRING BELT TAKE UP	TITLE:
		MASTER			ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY	N / A	10F	SHEET NO.:
								DRAWING #:

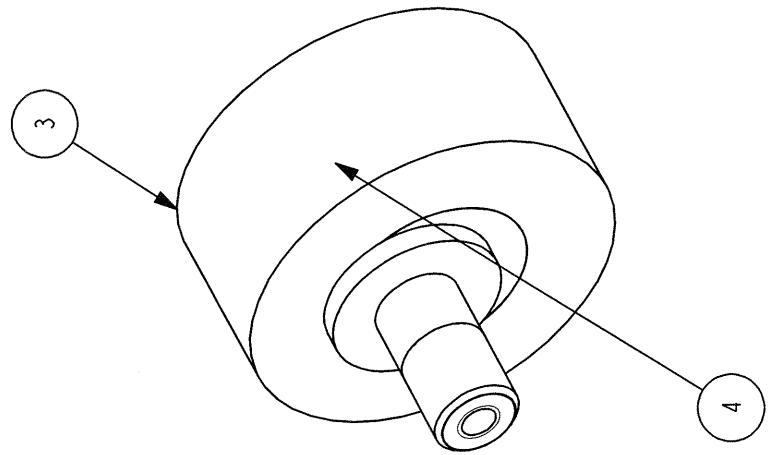
ITEM	QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	2	103108	BEARING, FLAT .500					
2	1	104106	SNAPRING, .500					
3	1	516045	ROLLER, BELT TAKEUP					
4	1	500983-3	STUD, IDLER SPROCKET					
5	1	516045A	ASSY, IDLER 1.376 DIA. X 1.00					
6	1	534220-01	ASSY, ECCENTRIC IDLER STUD					

2	SP72800
REV'D	WHERE USED

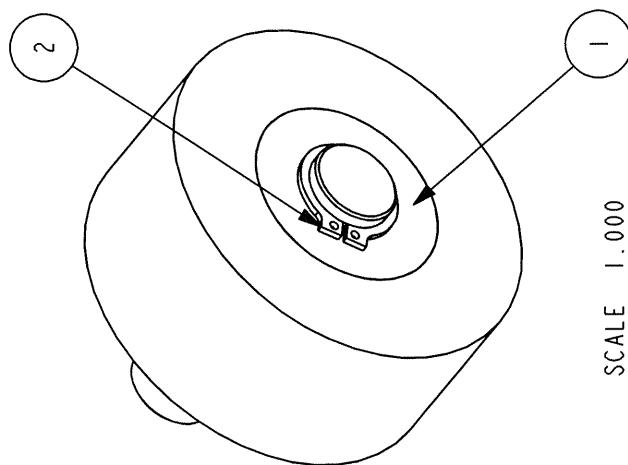
KIRK - RUDY, INC. WOODSTOCK, GEORGIA	
NO PORTION OF THIS DRAWING MAY BE QUOTED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY INC. WOODSTOCK, GA 30188 USA	

SCALE: A KEY	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	MATERIAL: N/A	THIRD ANGLE PROJECTION
	.xx .xxx .5 .01 .005 .5		
DATE: 08-JUL-99	HEAT TREAT:	N/A	
CHECKED BY: MASTER	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED		MODEL: 445
TRACED BY: 	ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY		TITLE: ASSY, ECCENTRIC IDLER STUD
	N/A	SHEET NO.: 10F1	DRAWING #: 534220-01

ITEM	QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	2	103108	BEARING, FLAT .500					
2	1	104106	SNAPRING, .500					
3	1	108862-1	PULLEY, TIMING 18L075 1.125B NK					
4	1	500983-3	STUD, IDLER SPROCKET					



SCALE 1.000



DRAWN BY: A Y B	SCALE 1.000	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED			MATERIAL:		THIRD ANGLE PROJECTION NO PORTION OF THIS DRAWING MAY BE QUOTED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC. KIRK RUDY - WOODSTOCK, GEORGIA	
CHECKED BY:	DATE 30-May-00	.xx	.xxx	.05	.5	ANG.		HEAT TREAT:
TRACED BY:	MASTER	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED					MODEL: 703R	
		ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY					SHEET NO.: 10F1	DRAWING #: 536627-01

ITEM	QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	1	108809	PULLEY, TIMING 12L075 .625B .188K					
2	1	200614	MOTOR, LEESON AC 1/2HP C56C					
3	1	500824-12	SHAFT, MOTOR PIVOT					
4	1	530512-01	ARM, MOTOR SUPPORT					
5	1	530654-01	ASSY, MOTOR MTG BAR					

1	219RSF
REQ'D	WHERE USED

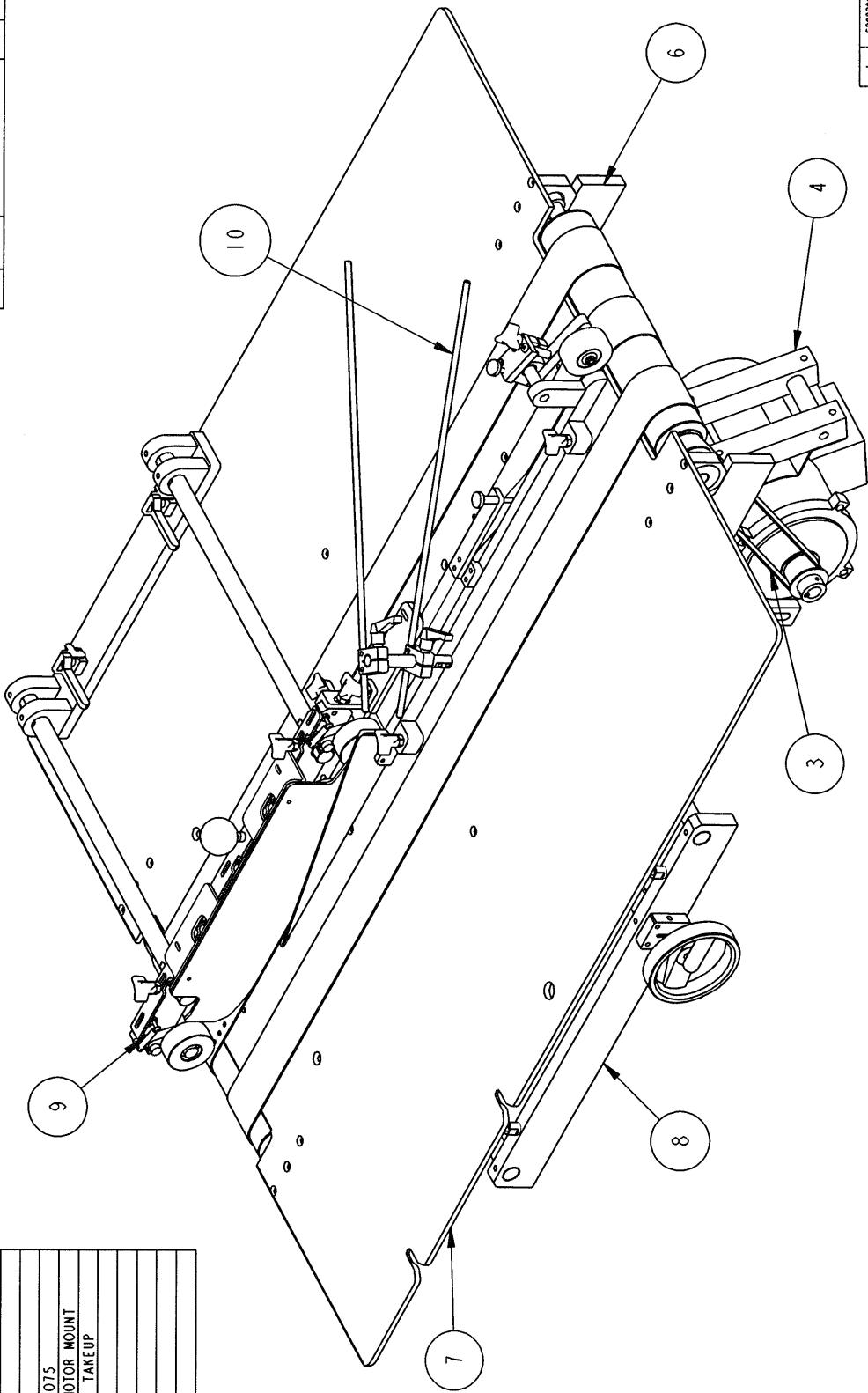
DRAWN BY: A KEY	SCALE 0 . 250	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED				MATERIAL: N/A	THIRD ANGLE PROJECTION		PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE QUOTED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC. WOODSTOCK, GA 30188 USA
CHECKED BY:	DATE 10 - JUN - 03	.xx	.xxx	.01	.005	HEAT TREAT: N/A			KIRK - RUDY, INC. WOODSTOCK, GEORGIA
TRACED BY:	MASTER	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED				FINISH: N/A	MODEL: 219RSF		TITLE: ASSY, 1/2 HP AC MOTOR MOUNT
		ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY				SHEET NO.: 10F1	DRAWING #: 538022-04		

ITEM	QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	2	100320	BUSHING, FL.7501D1.0000D1.000LG					
2	2	530510-01	PIVOT BAR					
3	2	530511-01	SPACER, 3/400 X 2L					

DRAWN BY: T JG	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. WOODSTOCK, GA 30188 USA	
CHECKED BY:	DATE: 27 - Jul - 01	.xx	.xxx	.05	FINISH TREAT: N / A			
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			
					SHEET NO. 10F1	DRAWING # ASSY , MOTOR MTG BAR		
						530654-01		

1	GENERAL
REO'D	WHERE USED

ITEM NO.	PART #	DESCRIPTION
1	102101	SPRING
2	500185	BLOCK, SPRING
3	108907-9	BELT, TIMING 2700075
4	1	538022-03 ASSY, 1/2 HP AC MOTOR MOUNT
5	1	545028-02 ASSY, SPRING BELT TAKEUP
6	1	545041-01 ASSY, FRAME
7	1	545048-02 ASSY, TABLETOP
8	1	545053-03 ASSY, FRAME SLIDE
9	1	545060-03 ASSY, SKID BAR
10	1	545064-01 ASSY, PLOW FOLD



ITEM NO.	REV NO.	DATE	DESCRIPTION	ECN NO.	BT
1					
2					
3					
4					
5					
6					
7					
8					
9					
10					

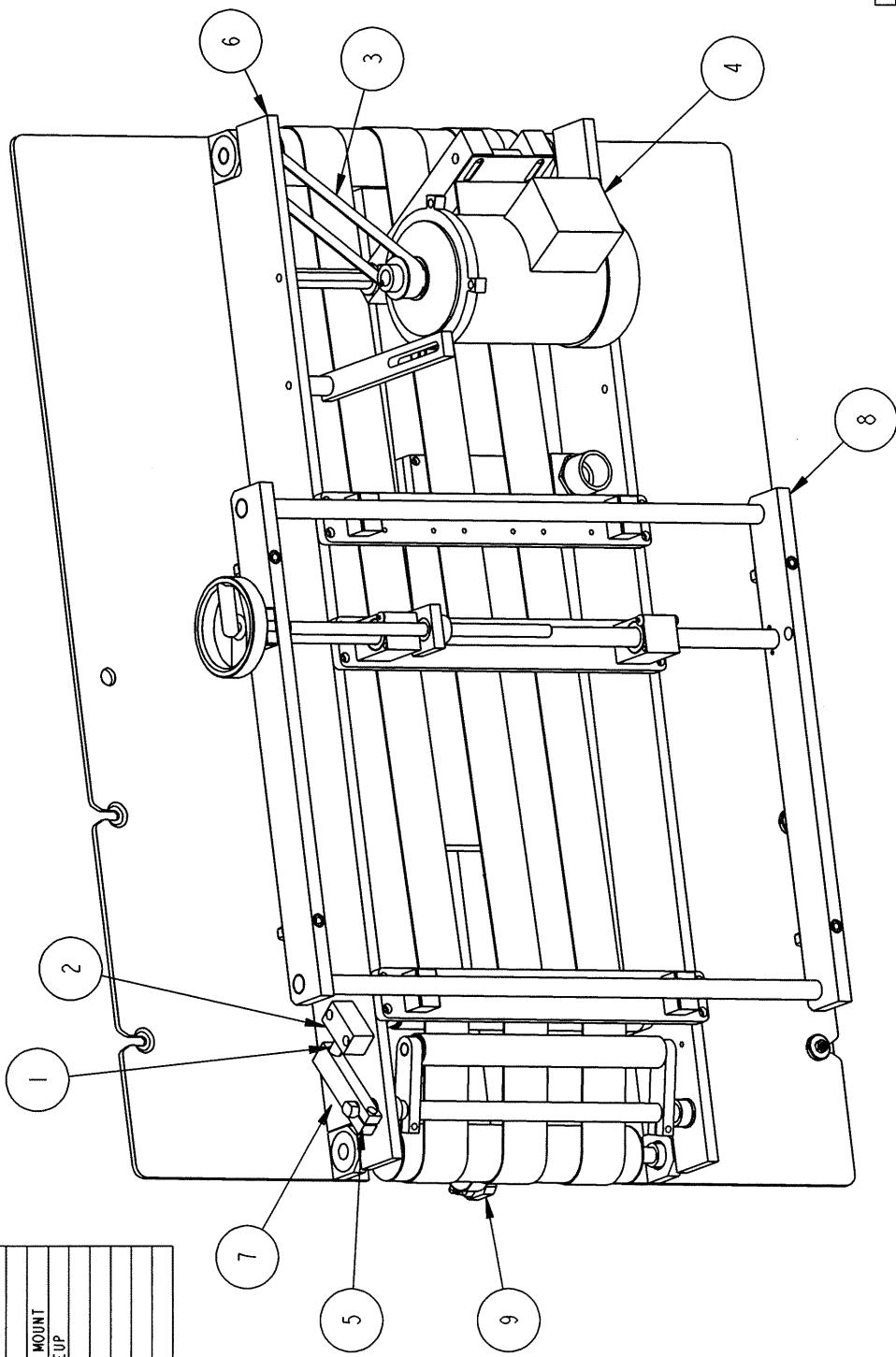
ITEM NO.	SCALE	DIMENSIONAL TOLERANCES	MATERIAL:
A	KEY	0 . 240	N/A
CHECKED BY:	DATE	IN	IN
	28 - Jul 1 - 03	.065	.065
REMOVED ALL SURFACES AND SLOTS ON THIS DRAWING		.5	.5
MASTER		N/A	N/A
TECHNICAL DRAWINGS OF THIS ITEM ARE LOCATED IN THE FILE NUMBER 545040-03		N/A	N/A
		PRINTED ON 08/03/03	PRINTED ON 08/03/03

ITEM NO.	REV NO.	WHERE USED
1		KIRK - RUDY, INC. WOODSTOCK, GEORGIA

ITEM NO.	REV NO.	WHERE USED
1		KIRK - RUDY, INC. WOODSTOCK, GEORGIA

ITEM NO.	REV NO.	WHERE USED
1		KIRK - RUDY, INC. WOODSTOCK, GEORGIA

ITEM #	QTY	PART #	DESCRIPTION
1	1	102701	SPRING
2	1	500785	BLOCK, SPRING
3	1	108907-9	BELT, TIMING 270L075
4	1	538022-03	ASSY, 1/2 HP AC MOTOR MOUNT
5	1	545028-02	ASSY, SPRING BELT TAKEUP
6	1	545041-01	ASSY, FRAME
7	1	545048-02	ASSY, TABLETOP
8	1	545053-03	ASSY, FRAME SLIDE
9	1	545060-03	ASSY, SKID BAR
10	1	545064-01	ASSY, PLOW FOLD

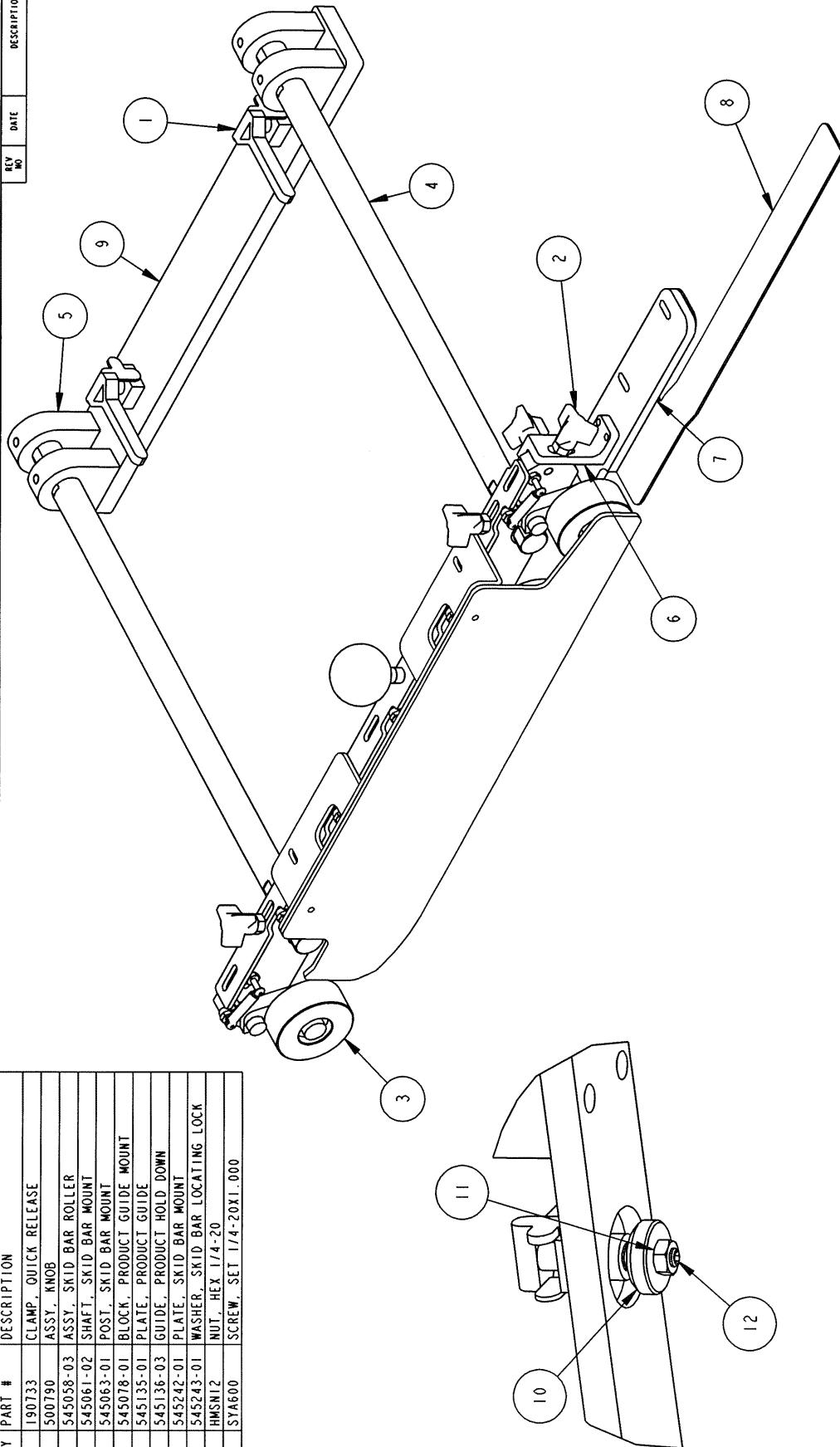


ITEM #	REV #	DATE	DESCRIPTION	ECN #	BT	RECD WHERE USED
1			219SF			KIRK - RUDY, INC. WOODSTOCK, GEORGIA

DRAWN BY:		DIMENSIONAL TOLERANCES		MATERIAL:		PRINTED BY:
A KEY		SCALE	UNLESS OTHERWISE NOTED	IN.	MM	
		0 . 230		N / A	N / A	PRINTED ON 08-08-2013
CHECKED BY:		DATE	ALL SURFACES AND SHAPES ARE MADE TO THIS DIMENSION EXCEPT WHERE NOTED	IN.	MM	PRINTED BY:
		08 - Aug - 03		N / A	N / A	PRINTED ON 08-08-2013
TRACED BY:		MASTER		N / A	N / A	PRINTED BY:

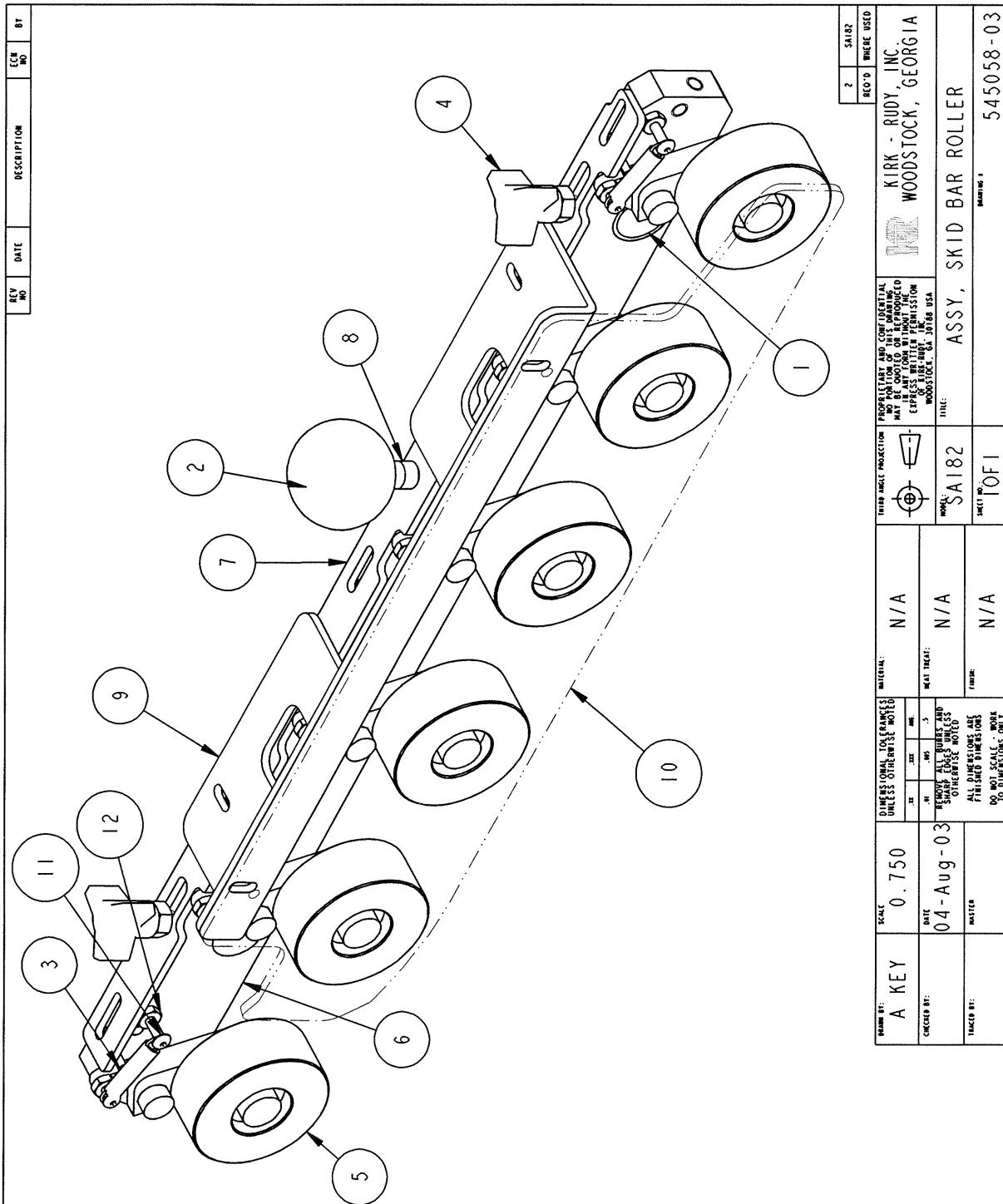
Drawing # 545040-03

ITEM QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	2	190733 CLAMP, QUICK RELEASE					
2	2	500790 ASSY, KNOB					
3	1	545058-03 ASSY, SKID BAR ROLLER					
4	2	545061-02 SHAFT, SKID BAR MOUNT					
5	4	545063-01 POST, SKID BAR MOUNT					
6	1	545078-01 BLOCK, PRODUCT GUIDE MOUNT					
7	1	545135-01 PLATE, PRODUCT GUIDE					
8	1	545136-03 GUIDE, PRODUCT HOLD DOWN					
9	1	545242-01 PLATE, SKID BAR MOUNT					
10	2	545243-01 WASHER, SKID BAR LOCATING LOCK					
11	2	NMSN 12 NUT, HEX 1/4-20					
12	2	SYA600 SCREW, SET 1/4-20X1.000					



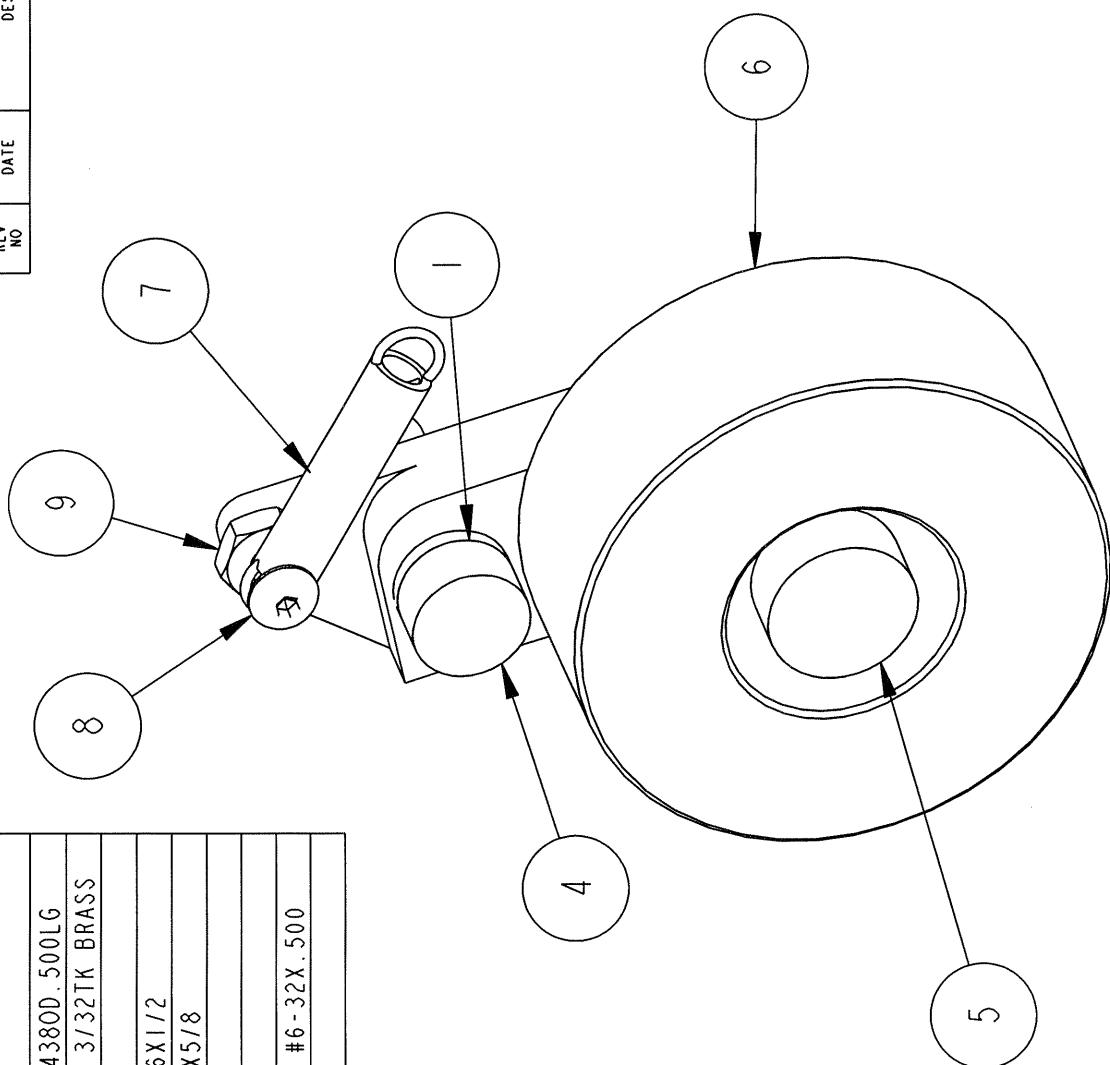
I	219RSF	RECD WHERE SET
KIRK - RUDY, INC		WOODSTOCK, GEORGIA
219RSF	INIT:	ASSY, SKID BAR
A KEY	SCALE 0 .420	DIMENSIONAL TOLERANCES: N/A
08-Aug-03	IN MM	IN MM
MASTER	MADE BY:	PRINTED DATE: 08-AUG-03
10F2	10F3	ALL DIMENSIONS ARE IN INCHES. FOR DIMENSIONS ONLY

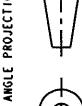
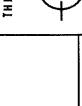
ITEM #	PART #	DESCRIPTION
1	100149	BUSHING, SL .750 ID .875 OD .500 LG
2	102123	KNOB, ROUND
3	105210	PIN, ROLL .125X .750
4	2	500790 ASSY, KNOB
5	6	537760-03 ASSY, SKID BAR ROLLER
6	1	545059-01 PLATE, SKID BAR ROLLER MOUNT
7	1	545119-01 BAR, SPRING ROLLER ADJUSTMENT
8	1	545130-01 SHAFT, SPRING ROLLER KNOB
9	1	545137-01 BRACKET, VERTICAL HOLD DOWN MOUNT
10	1	545138-01 GUIDE, VERTICAL HOLD DOWN
11	6	CSF49 SCREW, BUTTON HEAD #6-.32X .625
12	6	HWSN08 NUT, HEX #6-32



A KEY		SCALE	DIMENSIONAL TOLERANCES		NOTES:
		0 .750	.005	.005	N/A
CHECKED BY:	DATE	04 - Aug - 03	.005	.005	WEAR TOLERANCE
					REMOVES ALL GROVES AND SHARP EDGES UNLESS OTHERWISE SPECIFIED
TRACED BY:	MASTER				ALL DIMENSIONS ARE IN INCHES. USE SCALES ON DRAWINGS FOR DIMENSIONAL TOLERANCES.
					PRINTED ON 10/01/03
					REV 0 DATE 03/03/03
					2 SA182 WHERE USED
					KIRK - RUDY, INC. WOODSTOCK, GEORGIA
					PRINTED ON 10/01/03
					SA182
					ASSY, SKID BAR ROLLER
					PRINTED 1
					545058-03

ITEM	QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	1	100318	BUSHING, FL. 3131D.4380D.500LG					
2	1	100608	WASHER, FLAT 1/4ID 3/32TK BRASS					
3	1	102762	SPRING, EXTENSION					
4	1	107102	BOLT, SHOULDER 5/16X1/2					
5	1	107204	BOLT, SHOULDER 3/8X5/8					
6	1	500339-2A	ASSY, ROLLER					
7	1	537761-01	ARM, ROLLER MOUNT					
8	1	CSFF48	SCREW, BUTTON HEAD #6-32X.500					
9	1	HMSN08	NUT, HEX #6-32					

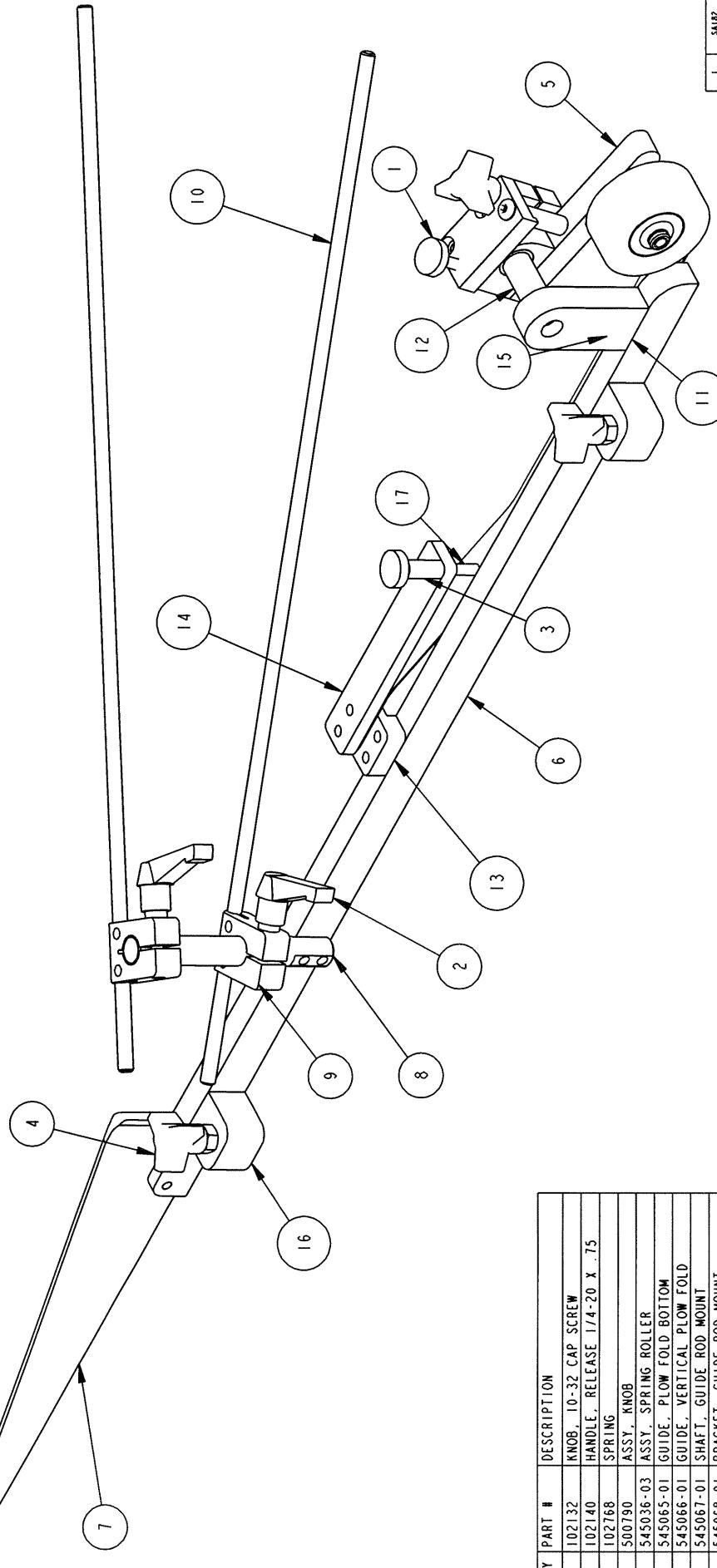


44	SP72800
REQ'D	WHERE USED
KRK KIRK - RUDY, INC. WOODSTOCK, GEORGIA	
THIRD ANGLE PROJECTION	PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE QUOTED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KRK-RUDY, INC. WOODSTOCK, GA 30188 USA
	
MODEL: SAI 82	TITLE: ASSY, SKID BAR ROLLER
SHEET NO. 10F1	DRAWING # 537760-03

DRAWN BY: A KEV	SCALE 1 . 500	MATERIAL: N / A	HEAT TREAT: N / A
CHECKED BY:	DATE 04-Apr-03	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED .xx .xxx .01 .005 .5 ANG.	
TRACED BY: MASTER		REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY	FINISHES N / A

Drawing # 545064-01

REV NO	DATE	ECN NO	B1
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ITEM #	PART #	DESCRIPTION	SCALE	SCREW	NOTES
1	1	102132 KNOB, 10-32 CAP SCREW	0 . 600	N/A	
2	2	102140 HANDLE, RELEASE 1/4-20 X .75			
3	1	102768 SPRING			
4	2	500790 ASSY, KNOB			
5	1	545064-03 ASSY, SPRING ROLLER			
6	1	545065-01 GUIDE, PLOW FOLD BOTTOM			
7	1	545066-01 GUIDE, VERTICAL PLOW FOLD			
8	1	545067-01 SHAFT, GUIDE ROD MOUNT			
9	2	545068-01 BRACKET, GUIDE ROD MOUNT			
10	2	545069-01 ROD, PLOW FOLD OVER			
11	1	545071-01 POST, PINCH ROLLER MOUNT			
12	1	545072-01 STUD, PINCH ROLLER MOUNT			
13	1	545132-01 BRACKET, GUIDE ROD MOUNT			
14	1	545133-01 BAR, SPRING STEEL MOUNT			
15	1	545134-01 GUIDE, SPRING STEEL			
16	2	545244-01 BRACKET, PLOW FOLD MOUNT			
17	1	CSD271 SCREW, SHCS 10-32X1.500			

ITEM #	PART #	DESCRIPTION	SCALE	SCREW	NOTES
1					

ITEM #	PART #	DESCRIPTION	SCALE	SCREW	NOTES
1					

ITEM #	PART #	DESCRIPTION	SCALE	SCREW	NOTES
1					

ITEM #	PART #	DESCRIPTION	SCALE	SCREW	NOTES
1					

ITEM #	PART #	DESCRIPTION	SCALE	SCREW	NOTES
1					

ITEM #	PART #	DESCRIPTION	SCALE	SCREW	NOTES
1					

ITEM #	PART #	DESCRIPTION	SCALE	SCREW	NOTES
1					

ITEM #	PART #	DESCRIPTION	SCALE	SCREW	NOTES
1					

ITEM #	PART #	DESCRIPTION	SCALE	SCREW	NOTES
1					

ITEM #	PART #	DESCRIPTION	SCALE	SCREW	NOTES
1					

ITEM #	PART #	DESCRIPTION	SCALE	SCREW	NOTES
1					

ITEM #	PART #	DESCRIPTION	SCALE	SCREW	NOTES
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ITEM #	PART #	DESCRIPTION	SCALE	SCREW	NOTES
1					

ITEM #	PART #	DESCRIPTION	SCALE	SCREW	NOTES
1					

ITEM #	PART #	DESCRIPTION	SCALE	SCREW	NOTES
1					

ITEM #	PART #	DESCRIPTION	SCALE	SCREW	NOTES
1					

ITEM #	PART #	DESCRIPTION	SCALE	SCREW	NOTES
1					

ITEM #	PART #	DESCRIPTION	SCALE	SCREW	NOTES
1					

ITEM #	PART #	DESCRIPTION	SCALE	SCREW	NOTES
1					

ITEM	QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	1	100135	BUSHING, SL. 5001D. 6250D. 5001L6					
2	1	102119	KNOB					
3	1	102132	KNOB, 10-32 CAP SCREW					
4	1	102704	SPRING, COIL					
5	1	500745A	ASSY, UPPER FEED ROLLER					
6	1	537512-01	BLOCK, BUMP TURN ROLLER MNT					
7	1	537513-01	PLATE, BUMP TURN CAP					
8	1	537514-01	BLOCK, BUMP TURN PIVOT					
9	1	545037-01	ARM, PINCH ROLLER MOUNT					
10	1	545038-01	STUD, IDLER ROLLER					
11	1	CSD267	SCREW, SHCS 10-32X.750					
12	1	CSFF58	SCREW, BUTTON HEAD #10-32X.500					
13	1	CSFF60	SCREW, BUTTON HEAD #10-32X.750					
14	1	HMSN10	NUT, HEX #10-32					

1 SA182
REO'D WHERE USED

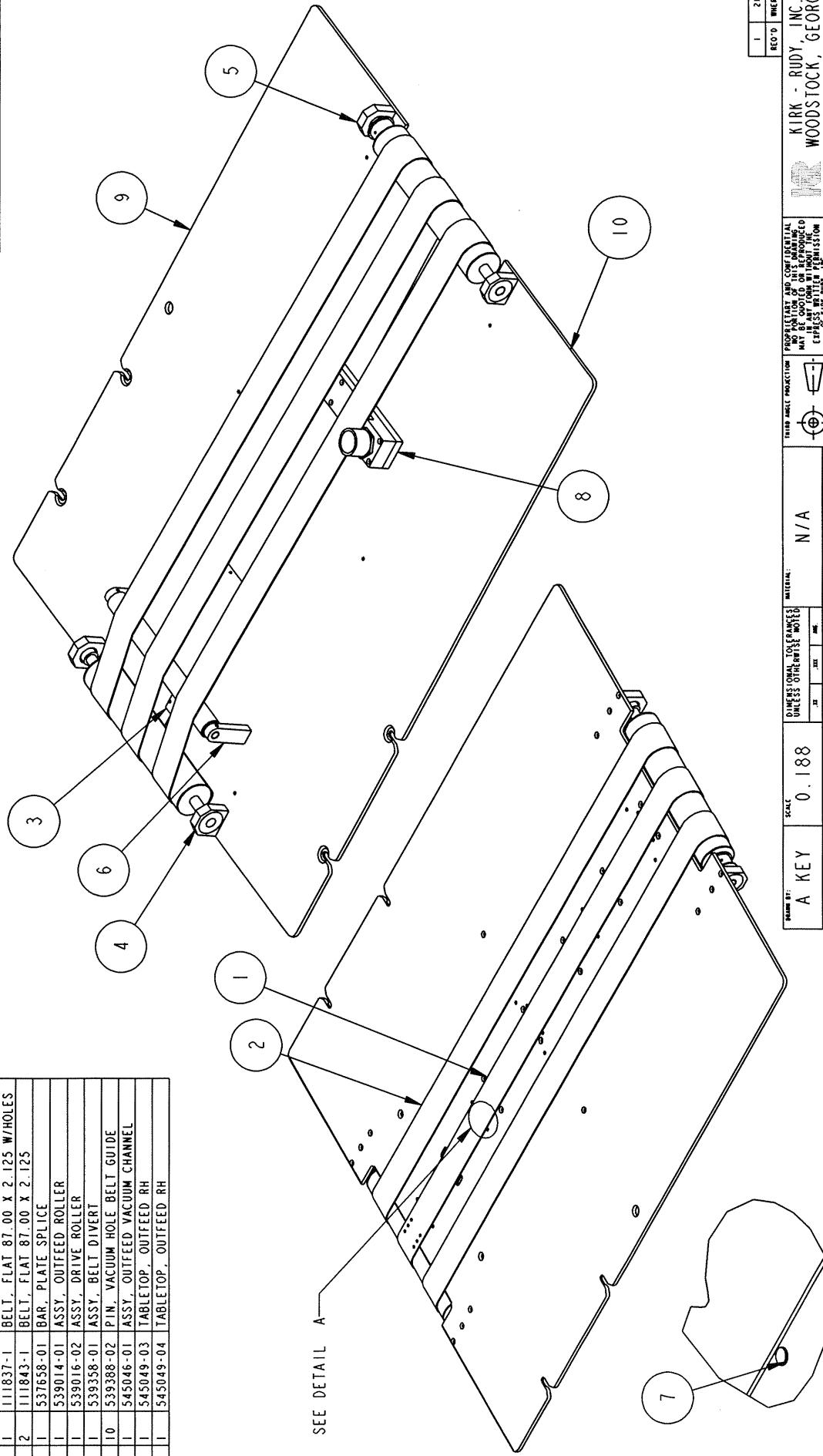
DRAWN BY: A KEY	SCALE 1 . 000	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED			MATERIAL: N/A	THIRD ANGLE PROJECTION 	PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE QUOTED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC. WOODSTOCK, GA 30188 USA	
CHECKED BY:	DATE 26-Mar-03	.01	.005	.5	HEAT TREAT: N/A	MODEL: SA182	TITLE: ASSY, SPRING ROLLER	
TRACED BY:	MASTER	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED			FINISH: N/A	SHEET NO.: 10F1	DRAWING #: 545036-03	

DRAWING #

545048-02

ITEM QTY	PART #	DESCRIPTION	REV NO	DATE	ECN NO
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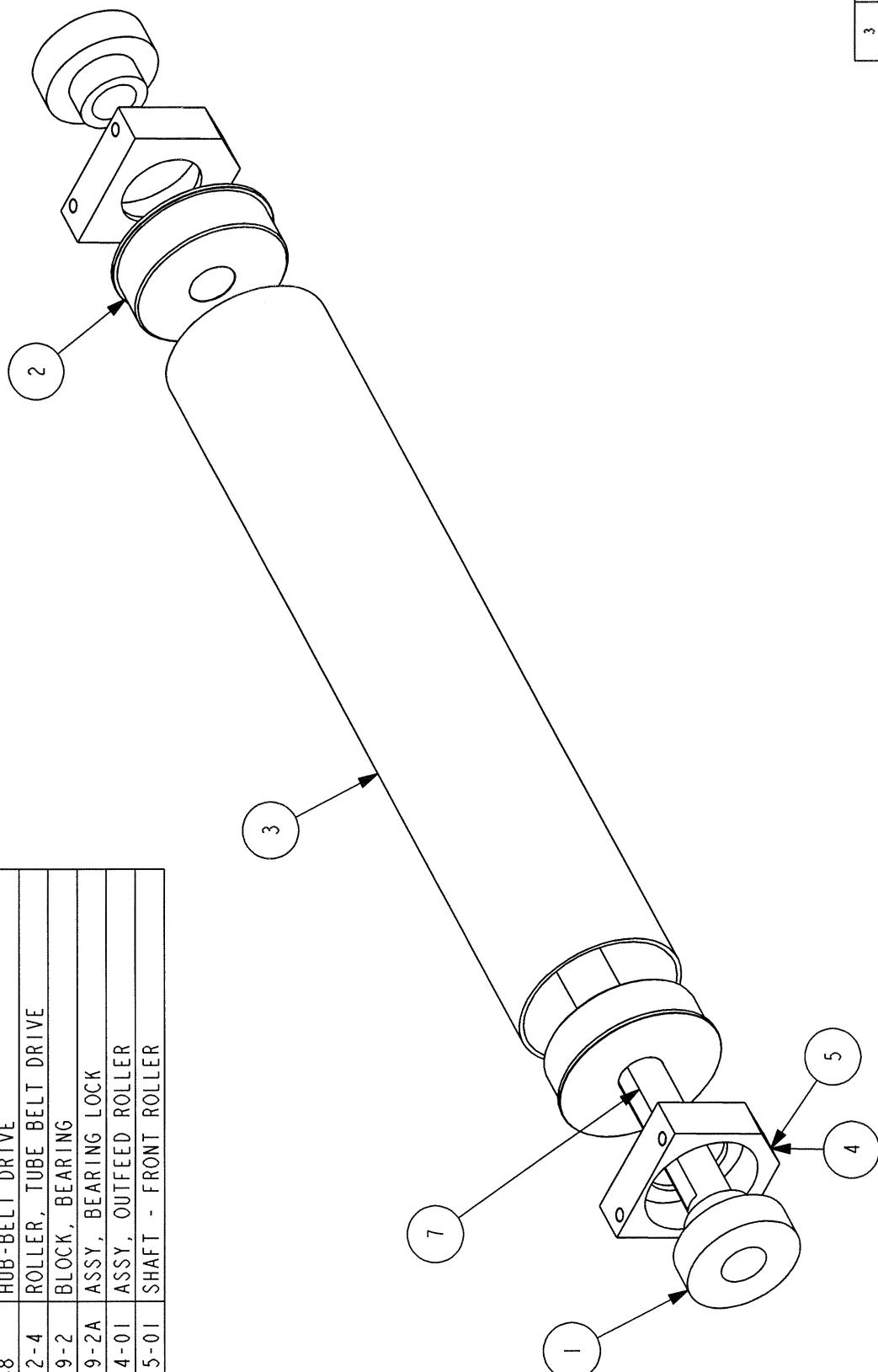
1	111831-1	BELT, FLAT 87.00 X 2.125 W/HOLES			
2	111843-1	BELT, FLAT 87.00 X 2.125			
3	531638-01	BAR, PLATE SPLICE			
4	539014-01	ASSY, OUTFEED ROLLER			
5	538016-02	ASSY, DRIVE ROLLER			
6	539358-01	ASSY, BELT DIVERT			
7	10 539358-02	PIN, VACUUM HOLE BELT GUIDE			
8	1 545046-01	ASSY, OUTFEED VACUUM CHANNEL			
9	1 545049-03	TABLETOP, OUTFEED RH			
10	1 545049-04	TABLETOP, OUTFEED RH			



1	219SF
ECN#	WEEK 1550
KIRK - RUDY, INC.	
WOODSTOCK, GEORGIA	
TIME:	
ASSY, TABLETOP	
DETAIL #	545048-02

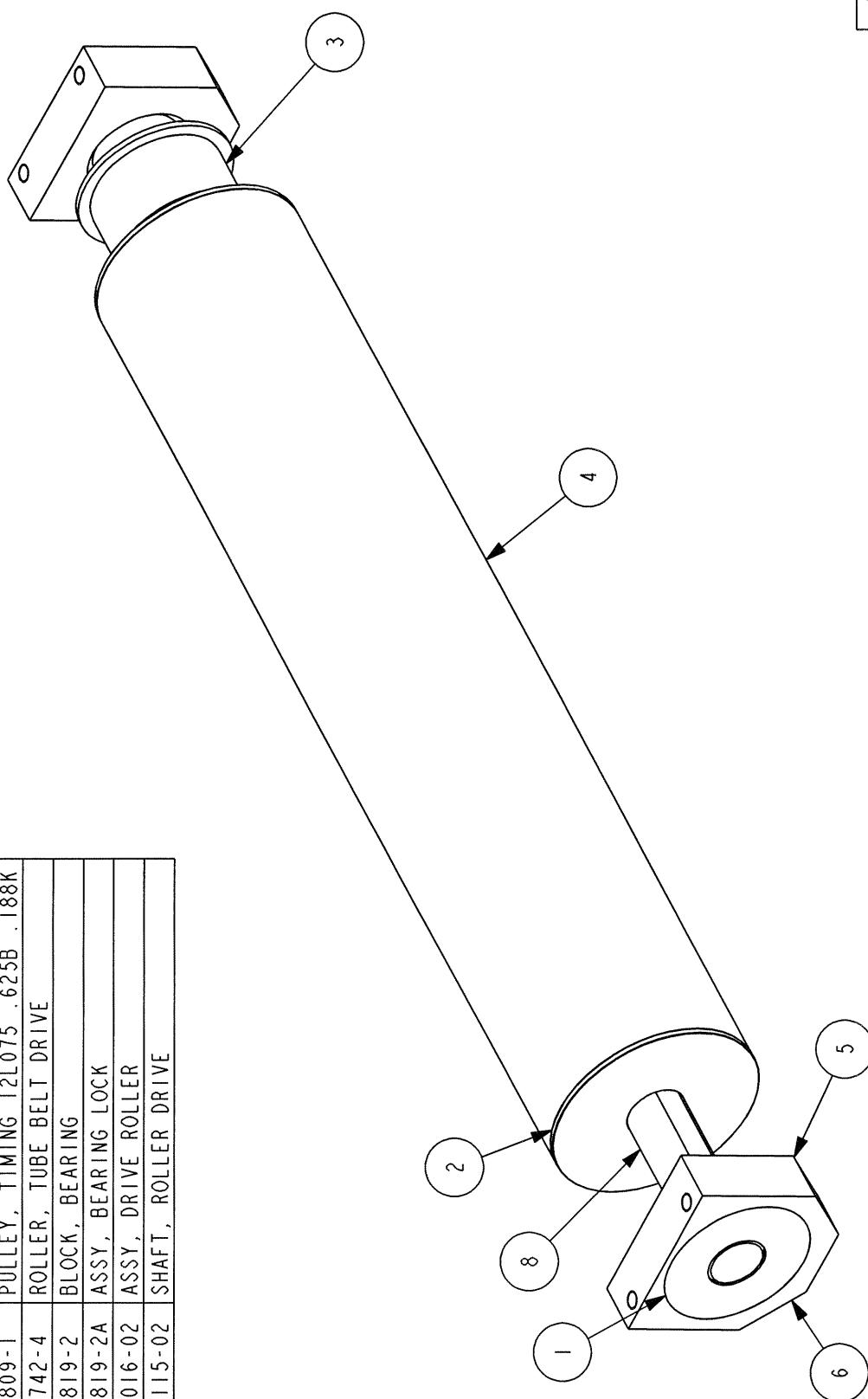
ITEM #:	SCALC	DIMENSIONAL TOLERANCES			MANUFACTURER:
		INCHES UNLESS OTHERWISE NOTED			
CHECKED BY:	A KEY	INCH	MM	INCH	N/A
DATE:	08 - Aug - 03				
REMARKS:	ALL DIMENSIONS ARE INCHES. TAKE BOTTOM AND TOP SURFACES AS REFERENCE. NOT TO SCALE. WORK TO DIMENSIONS ONLY.			N/A	
STAMP #:	MAILED	INCH	MM	INCH	N/A

ITEM	QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	2	103804	BEARING, HUB	.625				
2	2	500838	HUB-BELT DRIVE					
3	1	500742-4	ROLLER, TUBE BELT DRIVE					
4	2	500819-2	BLOCK, BEARING					
5	2	500819-2A	ASSY, BEARING LOCK					
6	1	539014-01	ASSY, OUTFEED ROLLER					
7	1	539015-01	SHAFT - FRONT ROLLER					



DRAWN BY:	A KEY	SCALE	0 . 500	MATERIAL:	N / A	THIRD ANGLE PROJECTION		KIRK - RUDY, INC.	
DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED				.01	.005	.005	HEAT TREAT:	N / A	
CHECKED BY:		DATE	08 - Mar - 00	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED				FINISH:	N / A
TRACED BY:		MASTER		ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY				SHEET NO.:	OF 1
				MODEL:	SP 800500	TITLE:		ASSY, OUTFEED ROLLER	
				REO'D	WHERE USED			DRAFTING 1	
				3	SP 800500			539014-01	

ITEM	QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	2	103804	BEARING, HUB . 625					
2	2	500838	HUB-BELT DRIVE					
3	1	108809-1	PULLEY, TIMING 12L075 . 625B . 188K					
4	1	500742-4	ROLLER, TUBE BELT DRIVE					
5	2	500819-2	BLOCK, BEARING					
6	2	500819-2A	ASSY, BEARING LOCK					
7	1	539016-02	ASSY, DRIVE ROLLER					
8	1	539115-02	SHAFT, ROLLER DRIVE					



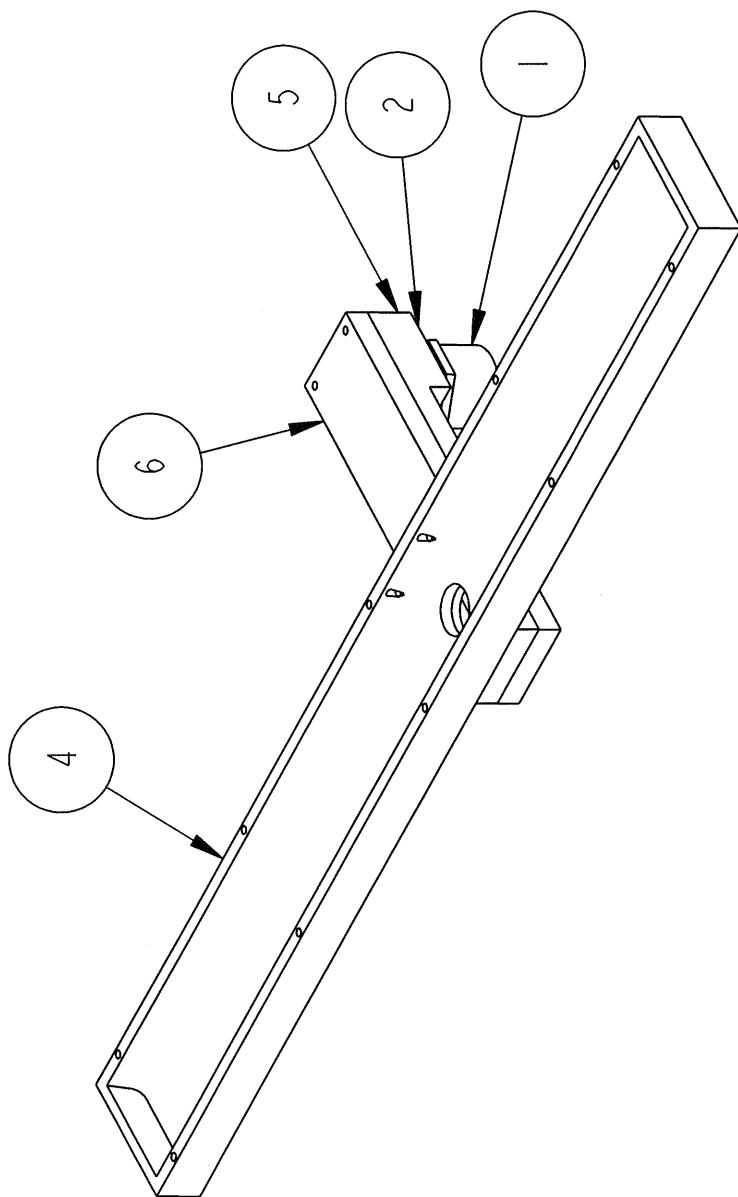
DRAWN BY: A KEY	SCALE 0 . 625	MATERIAL: N / A	THIRD ANGLE PROJECTION NO PORTION OF THIS DRAWING MAY BE QUOTED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC.  WOODSTOCK, GA 30188 USA
CHECKED BY:	DATE 26-Mar-03	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED .01 .005 .005 .005 .005 .005 ANG.	HEAT TREAT: N / A
TRACED BY:	MASTER	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY	MODEL: SA 182 TITLE: ASSY, DRIVE ROLLER SHEET NO.: 10F 1 DRAWING #: 539016-02

ITEM QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	2	103108 BEARING, FLAT .500					
2	2	539072-01 POST, BELT DIVERT					
3	1	539338-01 ROLLER, BELT DIVERT					
4	1	539359-01 SHAFT, BELT DIVERT ROLLER					

3	SP84000	REQ'D WHERE USED
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DRAWN BY: A KEY	SCALE 0 . 625	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	MATERIAL: N/A	THIRD ANGLE PROJECTION	PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE QUOTED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC. WOODSTOCK, GA 30188 USA
CHECKED BY:	DATE 24-May-00	.005 .005 .005	HEAT TREAT: N/A	MODEL: SP84000	TITLE: ASSY, BELT DIVERT
TRACED BY:	MASTER	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY		SHEET NO.: OF 1	DRAWING #: 539358-01

ITEM	QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	1	190715	PVC COUPLING					
2	1	530656-01	ASSY, VACUUM MANIFOLD					
3	1	545046-01	ASSY, OUTFEED VACUUM CHANNEL					
4	1	545047-01	CHANNEL, OUTFEED VACUUM					
5	1	SP28217-1	BLOCK, LOWER VACUUM					
6	1	SP28218-1	BLOCK, UPPER VACUUM					



1	SA182	REF'D TO WHERE USED
KR	KIRK - RUDY, INC. WOODSTOCK, GEORGIA	
PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE QUOTED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC. WOODSTOCK, GA 30188 USA		
THIRD ANGLE PROJECTION		
MATERIAL: N / A		
DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED		
.xx .xxx .005 .5		
ANG.		
.01 .005		
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		
DATE: 08 - Aug - 03	MODEL: 219RSF	TITLE: ASSY, OUTFEED VACUUM CHANNEL
CHECKED BY:		
MASTER	SHEET NO.: 1 OF 1	DRAWING #: ■
TRACED BY:		
		545046-01

ITEM	QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	1	108809	PULLEY, TIMING 12L075 .625B .188K					
2	1	200614	MOTOR, LEESON AC 1/2HP C56C					
3	1	500824	SHAFT-BELT GUIDE					
4	1	530512-01	ARM, MOTOR SUPPORT					
5	1	530654-01	ASSY, MOTOR MTG BAR					
6	1	545103-01	SPACER, MOTOR MOUNT					

1 219RSF
 REQ'D WHERE USED

1 219RSF
 REQ'D WHERE USED

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

KRK KIRK - RUDY, INC.
WOODSTOCK, GEORGIA

THIRD ANGLE PROJECTION

MODEL: 219RSF

TITLE: ASSY, 1/2 HP AC MOTOR MOUNT

DRAWN BY: A KEY

SCALE: 0 .375

MATERIAL: N/A

DIMENSIONAL TOLERANCES
UNLESS OTHERWISE NOTED

.xx	.xxx	.5
.01	.005	

HEAT TREAT:

DATE: 10 - JUN - 03

REMOVED ALL BURS AND
SHARP EDGES UNLESS
OTHERWISE NOTED

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

MASTER

TRACED BY:

SHEET NO. 0F1

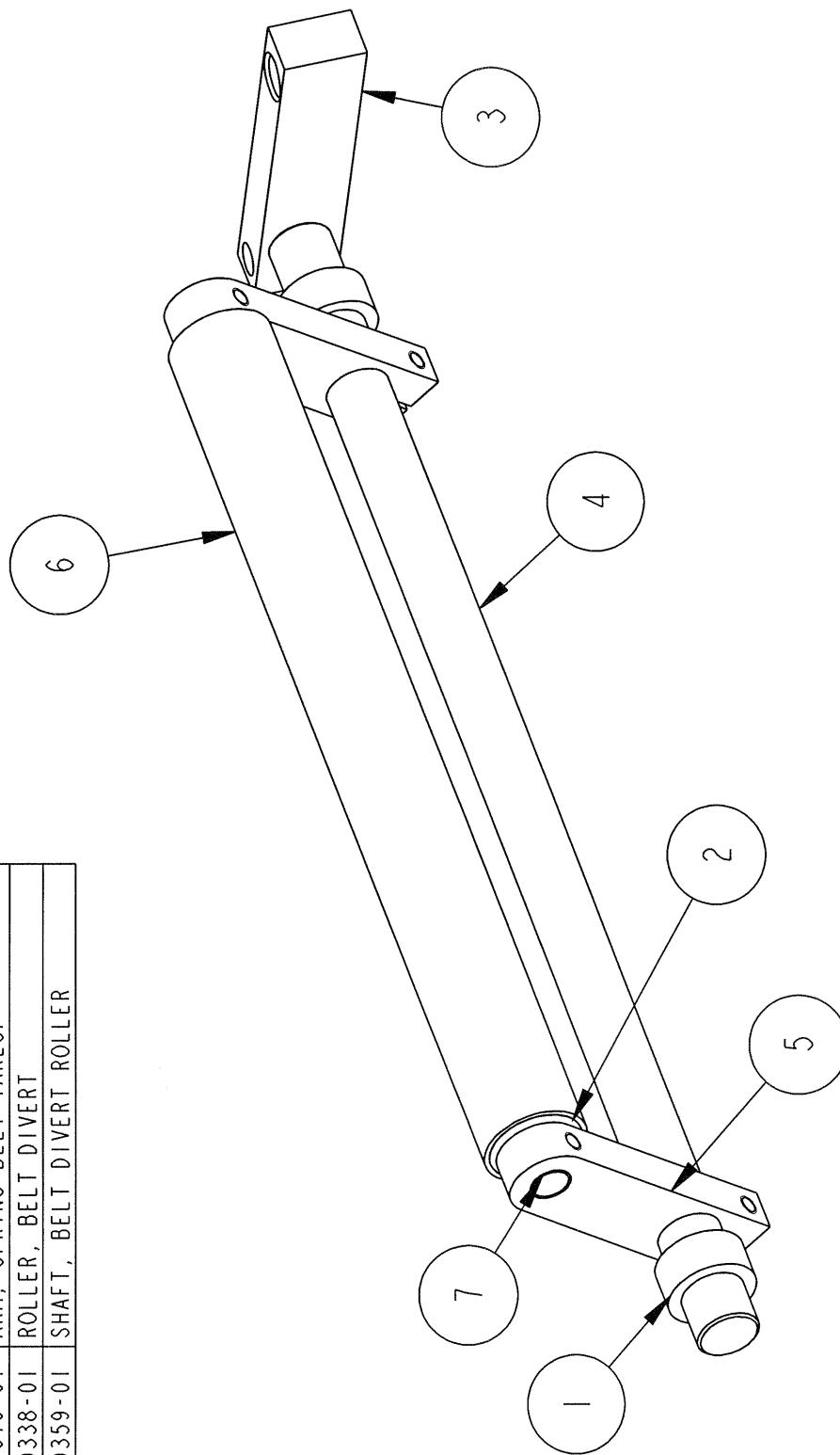
DRAWING #

538022-03

ITEM	QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	2	100320	BUSHING, FL. 7501DI.0000DI.000LG					
2	2	530510-01	PIVOT BAR					
3	2	530511-01	SPACER, 3/4OD X 2L					

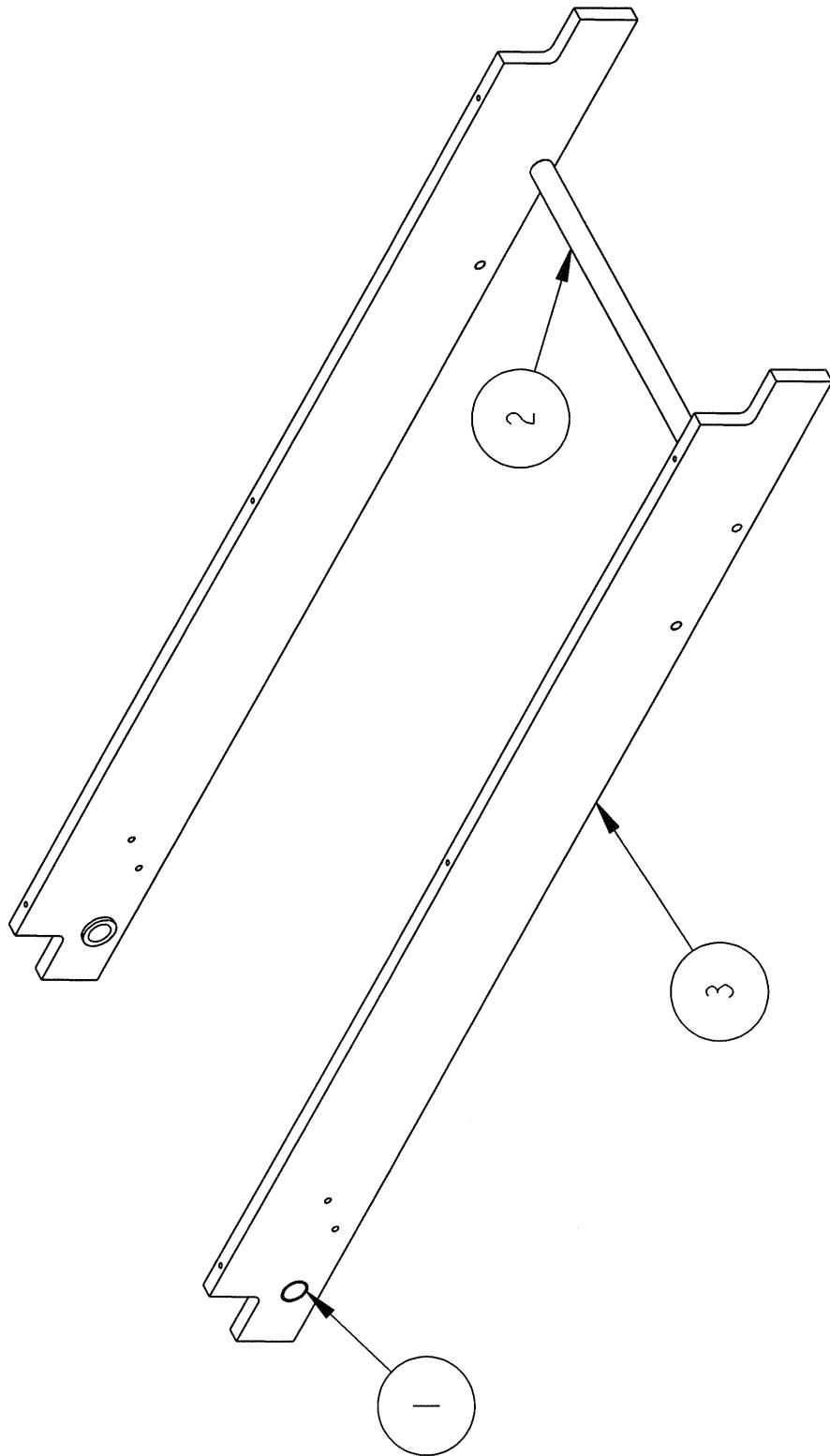
DRAWN BY: TJG	SCALE 0 . 500	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED			MATERIAL: N / A	THIRD ANGLE PROJECTION 	PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE QUOTED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC. WOODSTOCK, GA 30188 USA	
CHECKED BY:	DATE 27 - JU 1 - 01	.xx	.xxx	.05	ANG. N / A	HEAT TREAT: N / A		KRK KIRK - RUDY, INC. WOODSTOCK, GEORGIA
TRACED BY:	MASTER	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED			FINISH: N / A	MODEL: GENERAL		TITLE: ASSY , MOTOR MTG BAR
		ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY			SHEET NO.: 10F1	DRAWING #: 530654-01		

ITEM	QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	2	102207	COLLAR .750					
2	2	103108	BEARING, FLAT .500					
3	1	500786	LEVER, SPRING					
4	1	539078-01	SHAFT, BELT TAKEUP SPRING					
5	2	539079-01	ARM, SPRING BELT TAKEUP					
6	1	539338-01	ROLLER, BELT DIVERT					
7	1	539359-01	SHAFT, BELT DIVERT ROLLER					



DRAWN BY: A KEV	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. WOODSTOCK, GA 30188 USA
CHECKED BY:	DATE 26 - Mar - 03	.xx .xxx .5 .01 -.005 ANG.	HEAT TREAT: N / A	MODEL: SAI 82	KIRK - RUDY, INC. WOODSTOCK, GEORGIA
TRACED BY: MASTER	ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED	FINISH: N / A	SHEET NO. 10F 1	TITLE: ASSY , SPRING BELT TAKEUP DRAWING # 545028-02

ITEM	QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	2	100357	BUSHING, FL. 750 ID. 8750 OD. 625G					
2	1	500824	SHAFT-BELT GUIDE					
3	2	545042-01	PLATE, FRAME					



1	219RSF	REQ'D WHERE USED
KIRK - RUDY, INC	KR	WOODSTOCK, GEORGIA
NO PORTION OF THIS DRAWING MAY BE QUOTED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC.		WOODSTOCK, GA 30188 USA
28-JUL-03	219RSF	TITLE: ASSY, FRAME
MASTER	N/A	SHEET NO: 0F1
		DRAWING B

DRAWN BY:

A KEY

SCALE

0 . 188

DIMENSIONAL TOLERANCES

UNLESS OTHERWISE NOTED

N/A

MATERIAL:

N/A

THIRD ANGLE PROJECTION

E-

+ -

N/A

HEAT TREAT:

N/A

FINISH:

N/A

MODEL:

219RSF

TITLE:

ASSY, FRAME

SHEET NO: 0F1

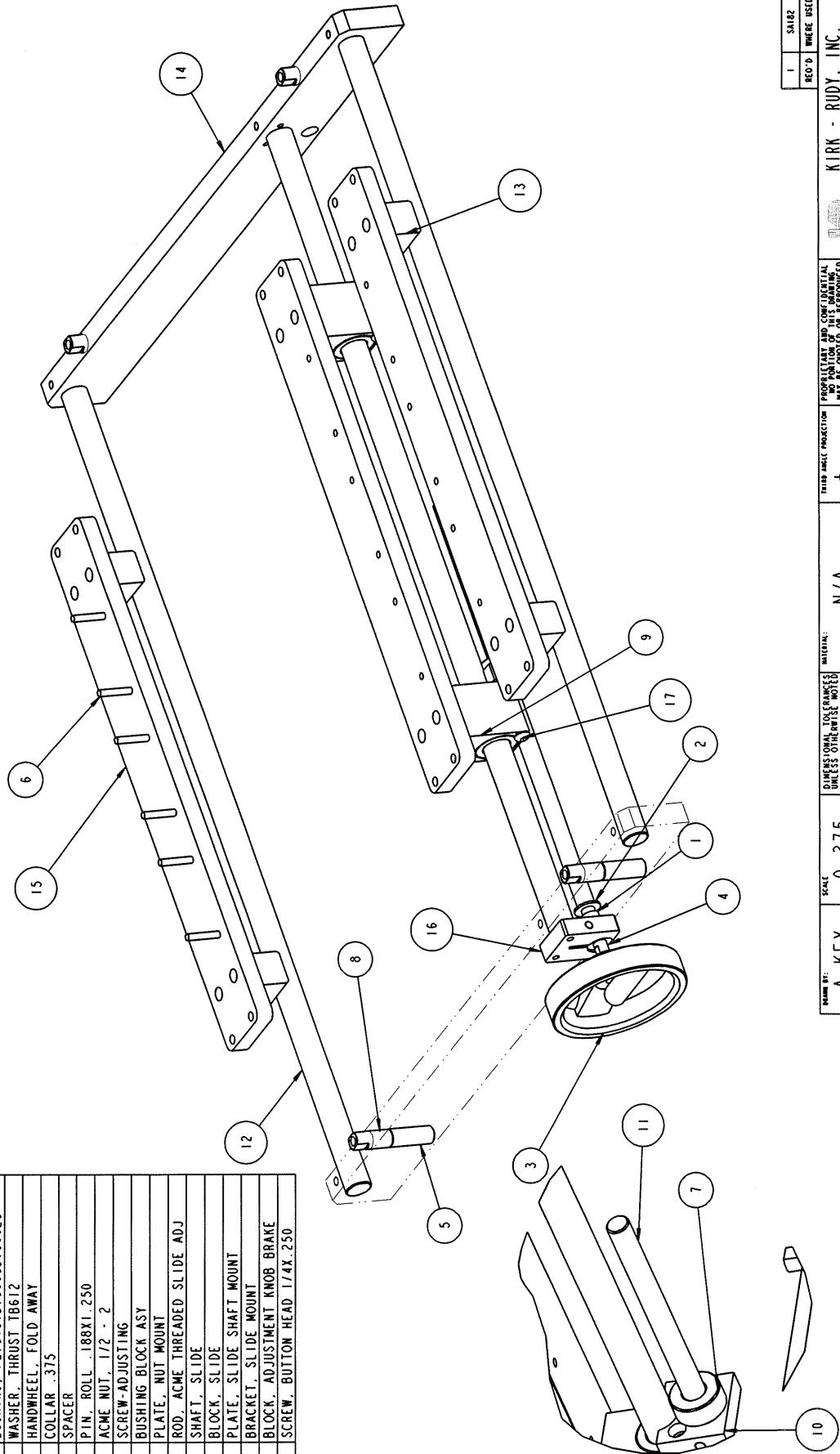
DRAWING B

545041-01

WHEELING ■

545053-03

ITEM	QTY	PART #	DESCRIPTION
1	1	100302	BUSHING, FL. 375ID. 500OD. 500LG
2	1	100402	WASHER, THRUST TB612
3	1	102139	HANDWHEEL, FOLD AWAY
4	1	102200	COLLAR .375
5	4	102670	SPACER
6	6	105209	PIN, ROLL .188X1.250
7	1	109836	ACME NUT, 1/2 - 2
8	4	510660	SCREW, ADJUSTING
9	2	537280-01	BUSHING BLOCK ASY
10	1	537281-01	PLATE, NUT MOUNT
11	1	537282-05	ROD, ACME THREADED SLIDE ADJ
12	3	537309-03	SHAFT, SLIDE
13	4	537311-01	BLOCK, SLIDE
14	2	545054-01	SLIDE SHAFT MOUNT
15	3	545055-01	BRACKET, SLIDE MOUNT
16	1	545131-01	BLOCK, ADJUSTMENT KNOB BRAKE
17	3	CSFF63	SCREW, BUTTON HEAD 1/4X.250

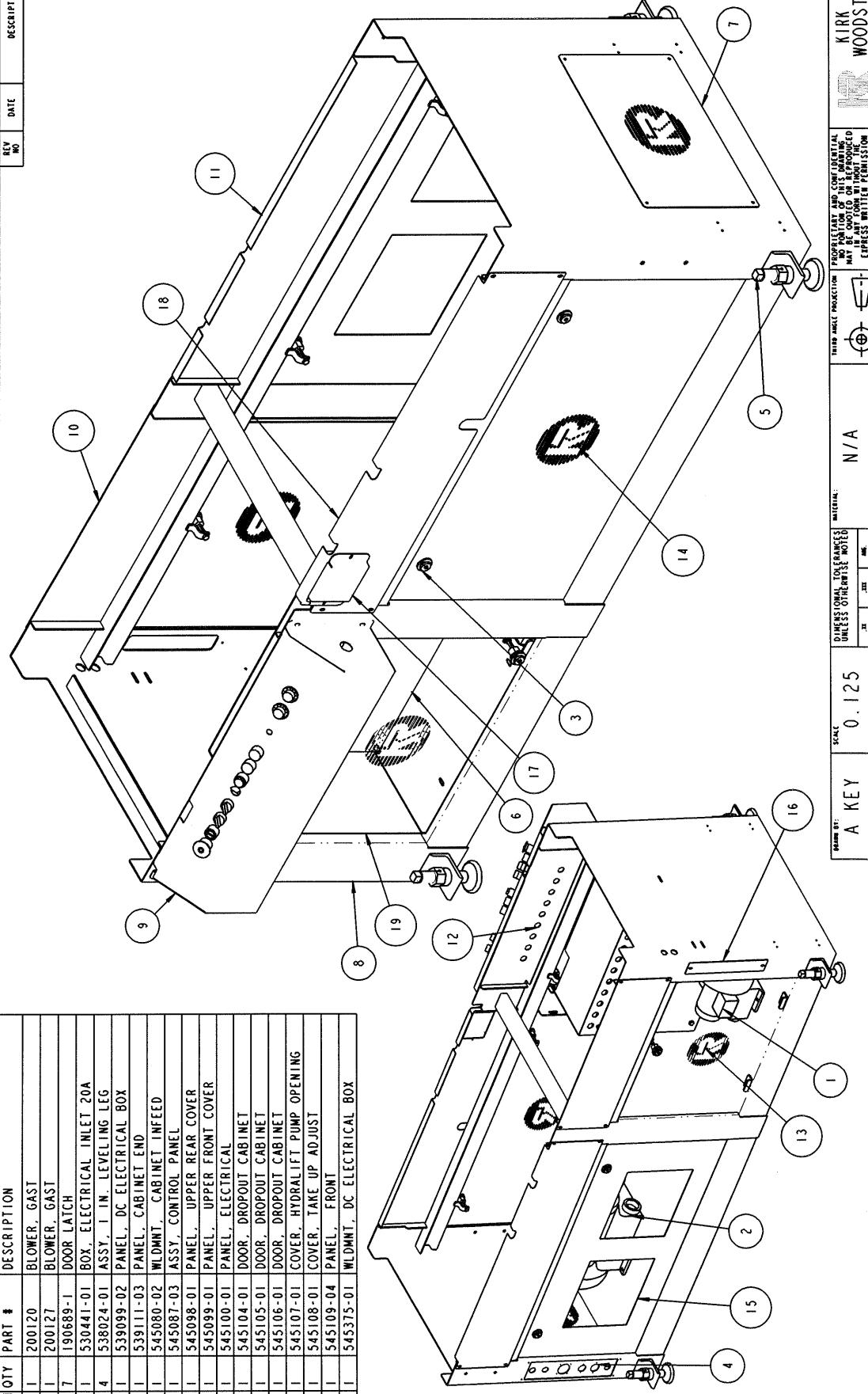


ITEM	KEY	SCALE	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	MATERIAL	THREE ANGLE PROJECTION	PROPRIETARY AND CONFIDENTIAL ALL INFORMATION CONTAINED HEREIN IS UNPUBLISHED PROPRIETARY INFORMATION OF KIRK-RUDY, INC. EXCEPT AS EXPRESSLY AGREED IN WRITING BY THE PARTIES, IT IS A TRADE SECRET OF KIRK-RUDY, INC., 39186 USA	RECD BY	WERE USED
	A	KEY	0 .375	N/A		KIRK - RUDY, INC. WOODSTOCK, GEORGIA	S A 182	
CHECKED BY:		DATE:	29-Apr-03	IN IN. MM.	INCHES MM. SCALES REMOVE ALL BURRS AND SHARP EDGES FROM ALL PARTS AND FILL ALL HOLE DOWNS AND PODS. SURFACE FINISH TO 0.015 MAX. ONLY	INCHES MM. SCALES REMOVE ALL BURRS AND SHARP EDGES FROM ALL PARTS AND FILL ALL HOLE DOWNS AND PODS. SURFACE FINISH TO 0.015 MAX. ONLY		
TRACED BY:		MASTER		N/A			(OF 1)	545053-03

REV NO	DATE	ECN NO	BY
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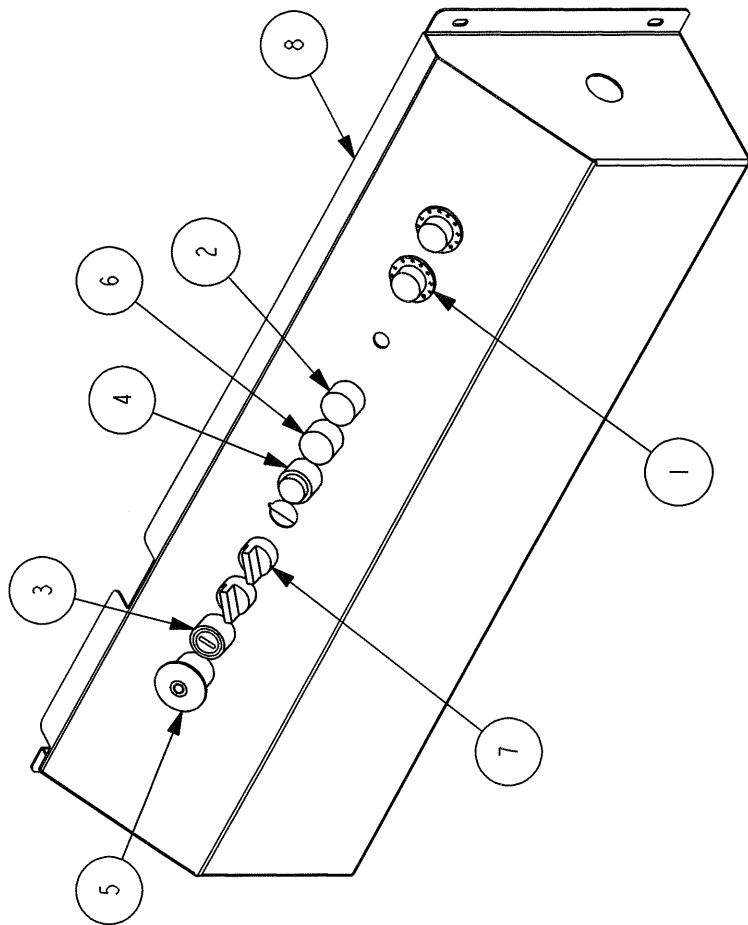
ITEM QTY	PART #	DESCRIPTION
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ITEM QTY	PART #	DESCRIPTION
1	200120	BLOWER, GAST
2	200127	BLOWER, GAST
3	190689-1	DOOR LATCH
4	530441-01	BOI. ELECTRICAL INLET 20A
5	538024-01	ASSY. I IN. LEVELING LEG
6	539099-02	PANEL. DC ELECTRICAL BOX
7	539111-03	PANEL. CABINET END
8	545080-02	WLDMNT. CABINET INFED
9	545081-03	ASSY. CONTROL PANEL
10	545088-01	PANEL. UPPER REAR COVER
11	545099-01	PANEL. UPPER FRONT COVER
12	545100-01	PANEL. ELECTRICAL
13	545104-01	DOOR. DROPOUT CAB INET
14	545105-01	DOOR. DROPOUT CAB INET
15	545106-01	DOOR. DROPOUT CAB INET
16	545107-01	COVER. HYDRAULIFT PUMP OPENING
17	545108-01	COVER. TAKE UP ADJUST
18	545109-04	PANEL. FRONT
19	545315-01	WLDMNT. DC ELECTRICAL BOX



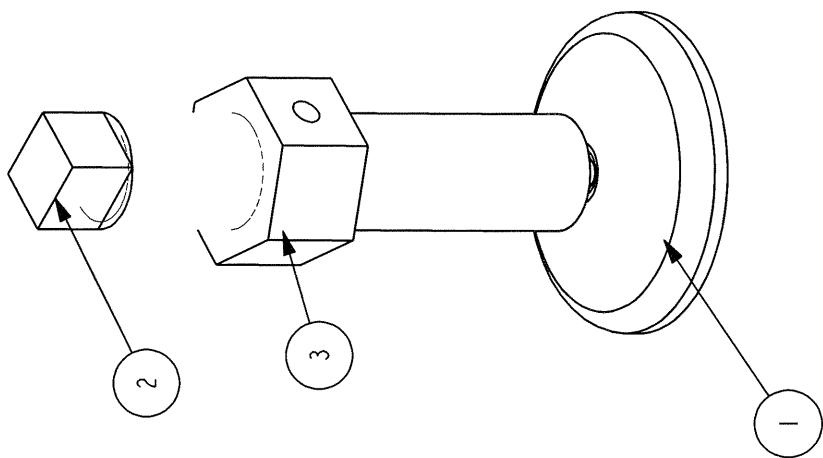
1	219RSF
REV O	WHERE USED
A KEY	SCALE 0 .125
CHECKED BY:	DATE 28 - Jul 1 - 03
MASTER	MEASUREMENTS IN. MM. .100 .000 .000 .000 .000 .000
TRACED BY:	MEAS TOLERANCE: N/A N/A N/A
	NOTES: REMOVE ALL SURGES AND SHARP EDGES UNLESS OTHERWISE ADVISED. ALL DRILL Holes AND PUNCH HOLES MUST BE DIA. 1/4" OR SMALLER. DO NOT EXCISE METAL OR DIMENSIONS ON PART.
	PRINTED BY: KIRK - RUDY INC. WOODSTOCK, GEORGIA 1986 USA
	TITLE: ASSY, CABINET & COVERS
	DRAWING #: 545079-03

ITEM	QTY	PART #	DESCRIPTION	REV NO	DATE	ECN NO	BY
1	2	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	1	201126-1	BUTTON, JOG				
7	2	201145-1	SELECTOR, 2 POSITIONS				
8	1	545088-02	BOX, 219 CONTROL				



I	SA182	REO'D	WHERE USED
KIRK - RUDY, INC. WOODSTOCK, GEORGIA			
PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE QUOTED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC. WOODSTOCK, GA 30188 USA			
SCALE: 0 . 188	MATERIAL: N / A	THIRD ANGLE PROJECTION	
DATE: 10 - Jun - 03	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED .01 .005 .5 .xx .xxx .ANG.		
CHECKED BY:	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED	HEAT TREAT: N / A	MODEL: SA182
TRACED BY:	ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY	FINISH: N / A	TITLE: ASSY, CONTROL PANEL
MASTER	SHEET NO. 10 OF 2	DRAWING #	545087-03

ITEM	QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	1	190634	FOOT, MOUNTING					
2	1	191010	LEVELING BOLT, CABINET					
3	1	191011	NUT, CABINET LEVELING					

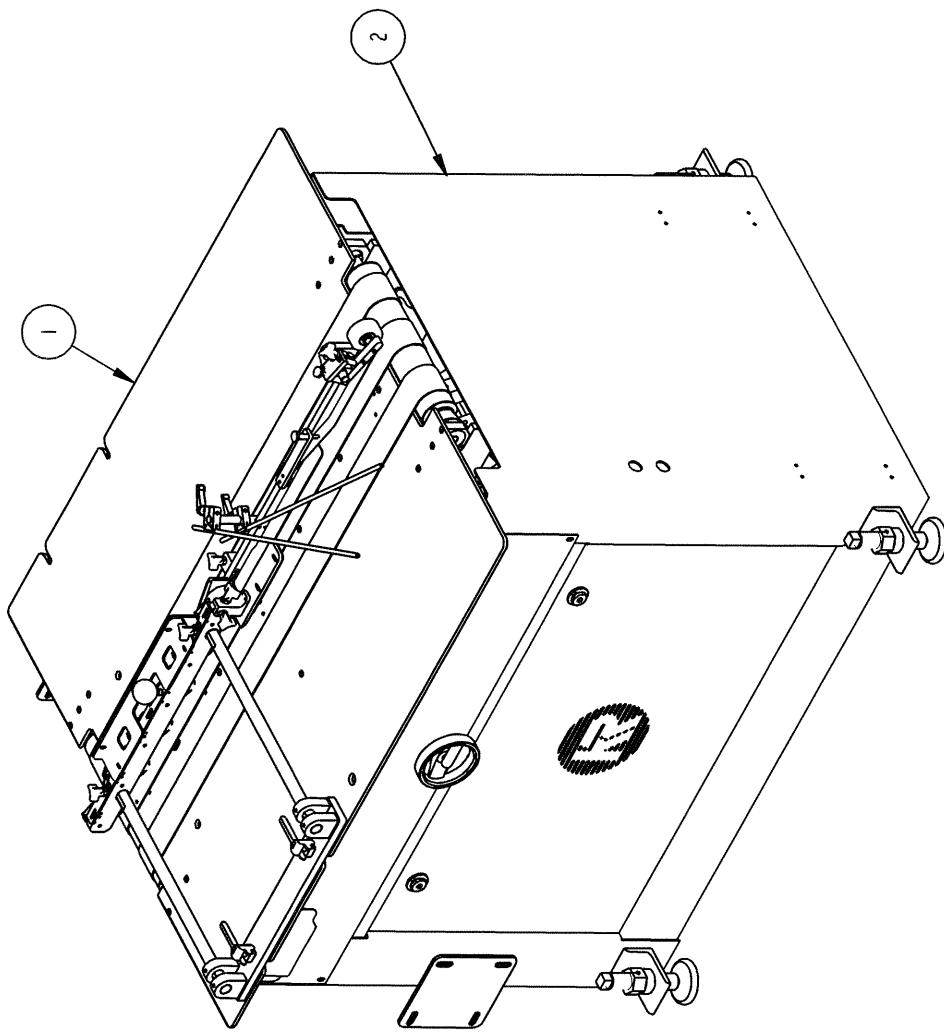


X	GENERAL	
REQ'D	WHERE USED	
<p align="center">KRK KIRK - RUDY, INC. WOODSTOCK, GEORGIA</p>		
<p align="center">PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE QUOTED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC. WOODSTOCK, GA 30188 USA</p>		
DRAWN BY: A YB	SCALE: 0 . 625	
DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED		
.xx	.xxx	.ANG.
.01	.005	.5
HEAT TREAT:		
DATE: 16 - NOV - 99		
CHECKED BY:		
TRACED BY:		
<p align="center">REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED</p>		FINISH:
ALL DIMENSIONS ARE FINISHED DIMENSIONS		N / A
DO NOT SCALE - WORK TO DIMENSIONS ONLY		N / A
SHEET NO. 0F 1		DRAWING #
TITLE: ASSY, 1 IN. LEVELING LEG		
538024-01		

DRAWING 1

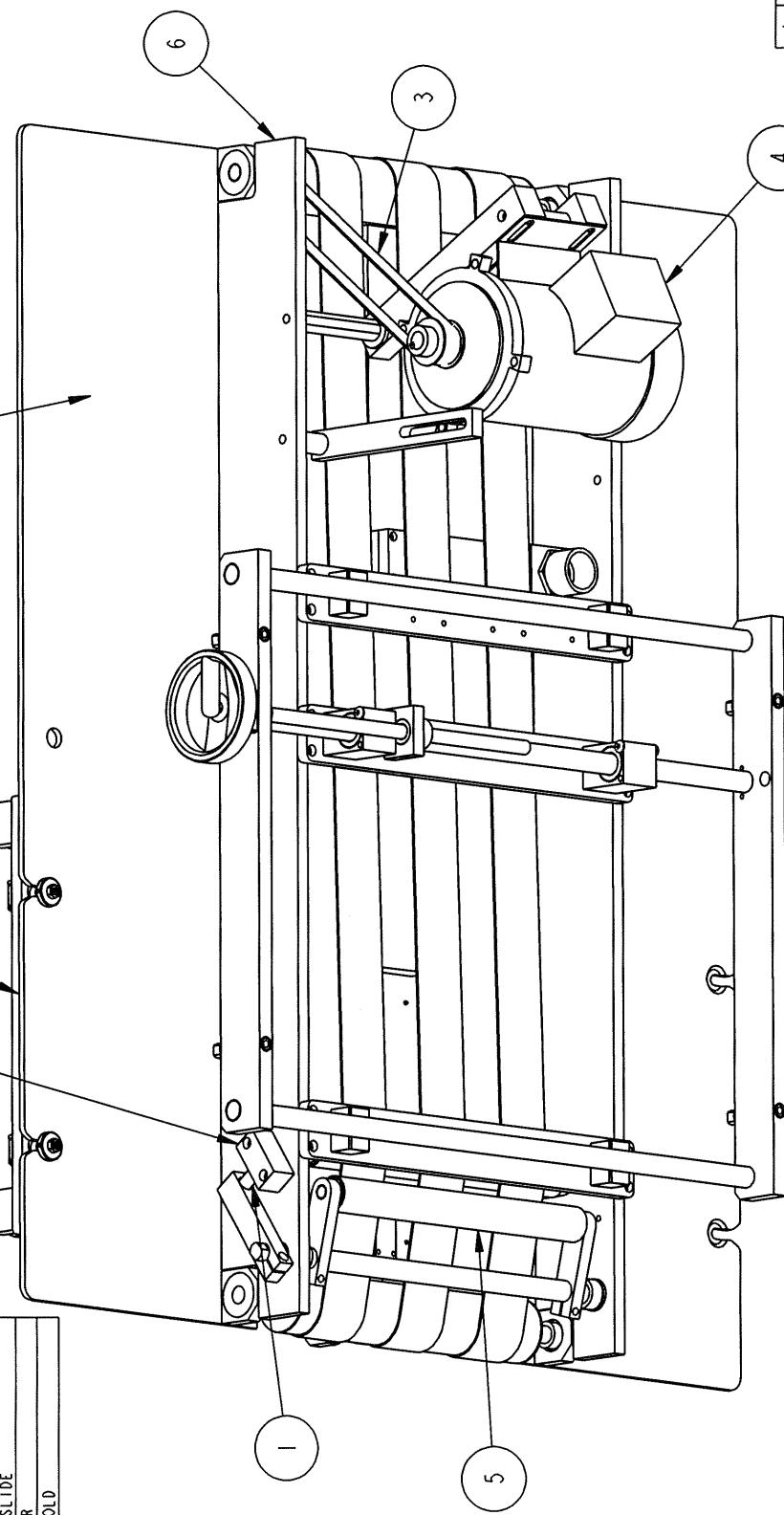
KR219FM

ITEM QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO
1	1	545040-04 ASSY, FOLDER TABLETOP				
2	1	545111-03 ASSY, CABINET & COVERS				



DRAWING #: A KEY	SCALE: 0 . 140	DIMENSIONAL TOLERANCES:			MATERIAL: N/A	MANUFACTURED AND CONFIDENTIAL INFORMATION PRINTED ON THIS DRAWING MAY BE QUOTED OR REPRODUCED BY CONTRACTOR, SUBCONTRACTOR, EQUIPMENT MANUFACTURER, TRANSMITTER, RECEIVER, WOODSTOCK, GA 30188 USA	RECD BY: KIRK - RUDY, INC. WOODSTOCK, GEORGIA
		.IN.	.MM.	.IN.			
CREATED BY:	DATE: 23-Apr-03	INCHES	MM	INCHES	MATERIAL: N/A	TIME: 219FM	RECD BY: ASSY, INLINE MODULAR FOLDER
MADE BY:	MAKER:	INCHES	MM	INCHES	MATERIAL: N/A	TIME: 10F2	RECD BY: KR219FM

ITEM #	PART #	DESCRIPTION	REV. NO.	DATE	ECN NO.	BY
1	102701	SPRING				
2	500185	BLOCK SPRING				
3	108907-9	BELT, TIMING 270LOTS				
4	1	538022-03 ASSY. 1/2 HP AC MOTOR MOUNT				
5	1	545028-02 ASSY. SPRING BELT TAKEUP				
6	1	545041-01 ASSY. FRAME				
7	1	545048-02 ASSY. TABLETOP				
8	1	545053-04 ASSY. FRAME SLIDE				
9	1	545060-04 ASSY. SKIDBAR				
10	1	545064-02 ASSY. PLOW FOLD				



ITEM #	SCALE	DATE	TIME	REMARKS
A KEY	0 .250		N/A	UNLESS OTHERWISE NOTED
CHECKED BY:		10 - Jun - 03		
MASTER				REMOVED ALL PLATES AND SCREWS FROM THIS ASSEMBLY FOR PICTURES AND THE PLATES AND SCREWS ARE TO BE RESTORED ONCE PICTURES ARE TAKEN.
TRACED BY:				

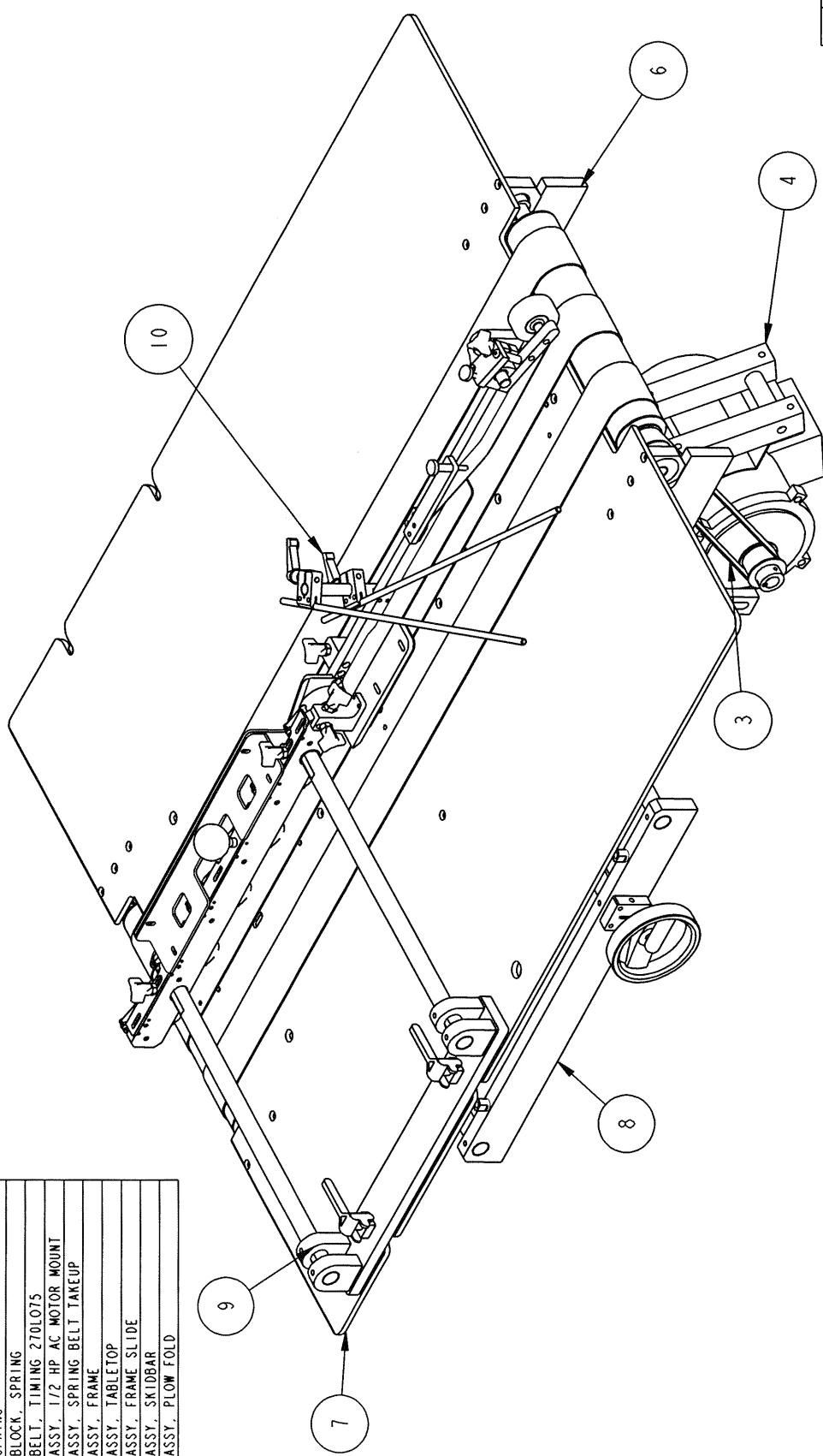
1 219RSF
RECD DATE USED

KIRK - RUDY, INC.
WOODSTOCK, GEORGIA

219RSF TIME:
20F2

DRAWING #: 545040-04

ITEM #	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BT
1	1	102011 SPRING					
2	1	500785 BLOCK, SPRING					
3	1	108907-9 BELT, TIMING 2701075					
4	1	538022-03 ASSY, 1/2 HP AC MOTOR MOUNT					
5	1	545028-02 ASSY, SPRING BELT TAKEUP					
6	1	545041-01 ASSY, FRAME					
7	1	545048-02 ASSY, TABLETOP					
8	1	545053-04 ASSY, FRAME SLIDE					
9	1	545060-04 ASSY, SKIDBAR					
10	1	545064-02 ASSY, PLOW FOLD					



REF ID:	A KEY	SCALE	0 . 240	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED			REMARKS
CHECKED BY:		DATE	08 - Aug - 03	.005	.005	.005	REMOVAL ALL BURRS AND SHARP EDGES AND WELD SPOTS
TRACED BY:				N/A	N/A	N/A	FLUSH WELD SPOTS AND PLATE SURFACES TO PLOW FOLD ASSEMBLY
				N/A	N/A	N/A	DO NOT SCALE, WORK TO DIMENSIONS ONLY
							PRINTED ON 08-08-2003

1 2 3 4 5 6 7 8 9 10

REF ID: 19RSF DATE: 08-08-2003

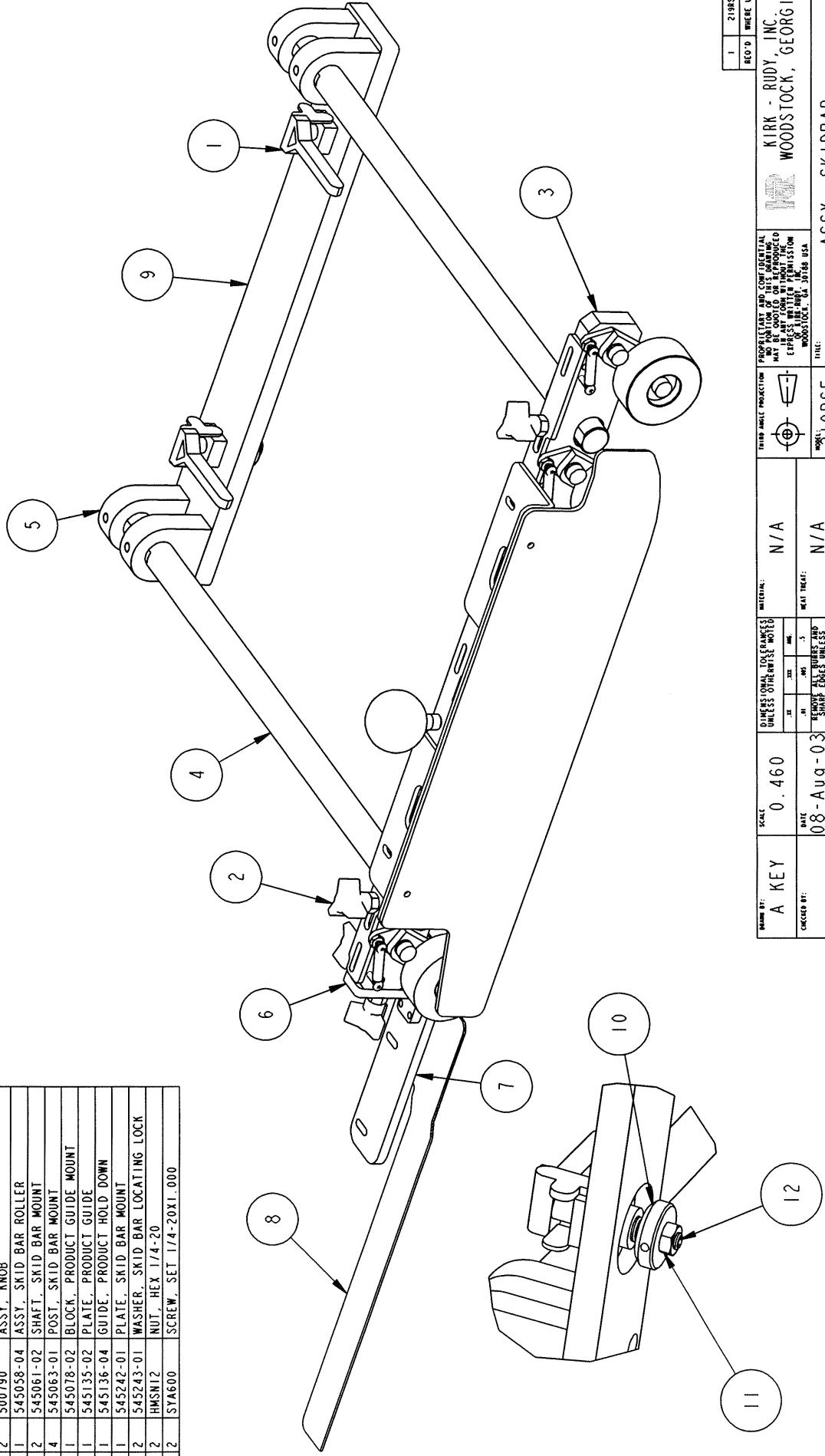
REF ID: 10F2 DATE: 08-08-2003

REF ID:	1	2 3 4 5 6 7 8 9 10	WHEN USED
REF ID:	19RSF	KIRK - RUDY, INC. WOODSTOCK, GEORGIA	PRINTED ON 08-08-2003

MATERIALS

545040-04

ITEM	QTY	PART #	DESCRIPTION
1	2	190133	CLAMP, QUICK RELEASE
2	2	500190	ASSY., KNOB
3	1	545058-04	ASSY, SKID BAR ROLLER
4	2	545061-02	SHAFT, SKID BAR MOUNT
5	4	545063-01	POST, SKID BAR MOUNT
6	1	545018-02	BLOCK, PRODUCT GUIDE MOUNT
7	1	545135-02	PLATE, PRODUCT GUIDE
8	1	545136-04	GUIDE, PRODUCT HOLD DOWN
9	1	545242-01	PLATE, SKID BAR MOUNT
10	2	IHSN12	WASHER, SKID BAR LOCATING LOCK
11	2	NUT, HEX 1/4-20	
12	2	SYA600	SCREW, SET 1/4-20X1.000



ITEM	QTY	RECD	WHERE USED
1	2	219RSF	

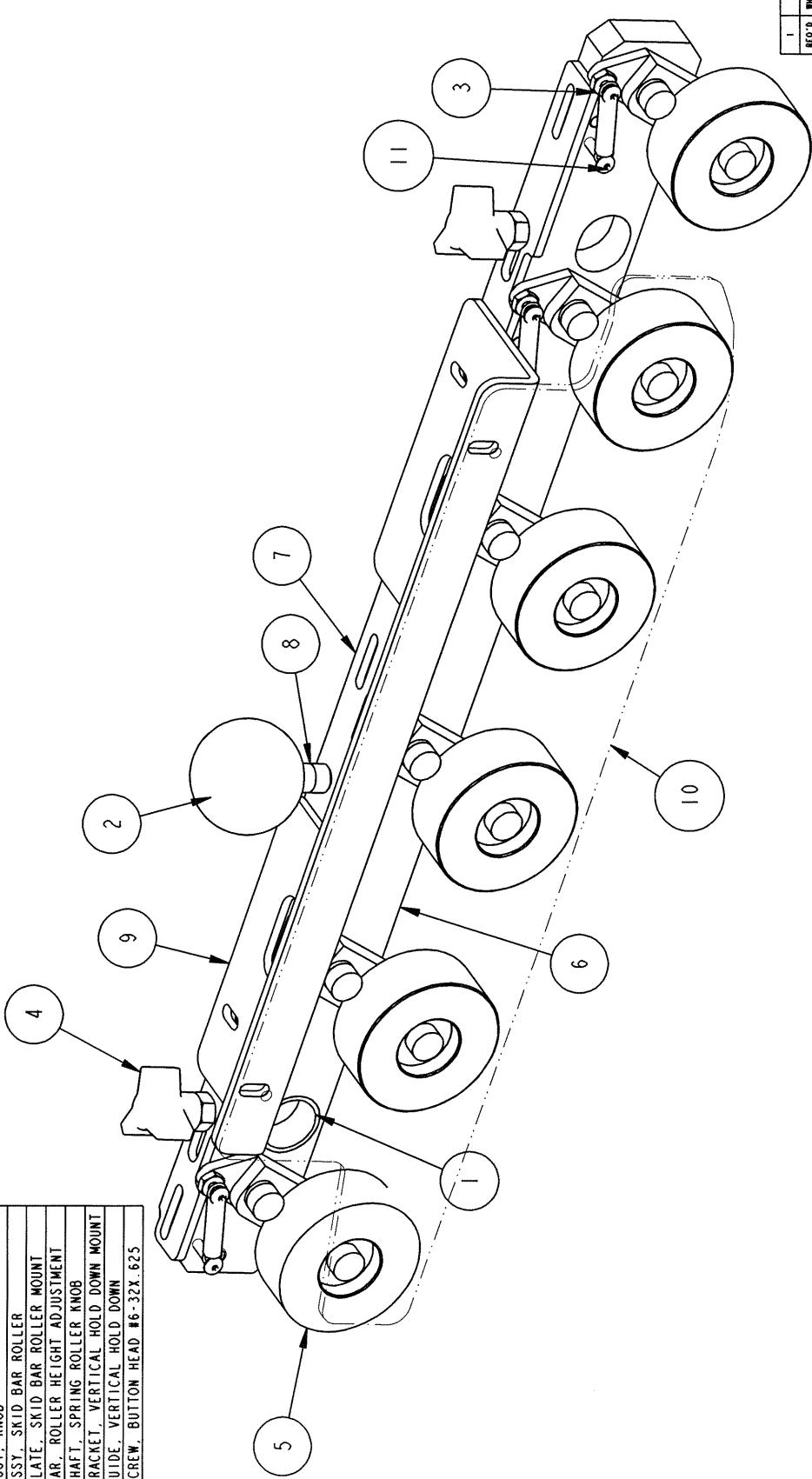
DRAWN BY:		SCALE:		DIMENSIONAL TOLERANCES		NOTES:	
A	KEY	0	.460	N/A	N/A		
CHCKED BY:		IN	MM	IN	MM	IN	MM
DATE:	08-Aug-03	INCHES	MILLIMETERS	INCHES	MILLIMETERS	INCHES	MILLIMETERS
TRACED BY:							

ALL DIMENSIONS ARE
FINISHED DIMENSIONS
TO NO SCALE - WORK
TO DIMENSIONS ONLY

DRAWN BY:		SCALE:		DIMENSIONAL TOLERANCES		NOTES:	
KIRK - RUDY, INC.							
WOODSTOCK, GEORGIA							
DATE:	219RSF	INCHES	MILLIMETERS	INCHES	MILLIMETERS	INCHES	MILLIMETERS
TRACED BY:							

ASSY, SKIDBAR

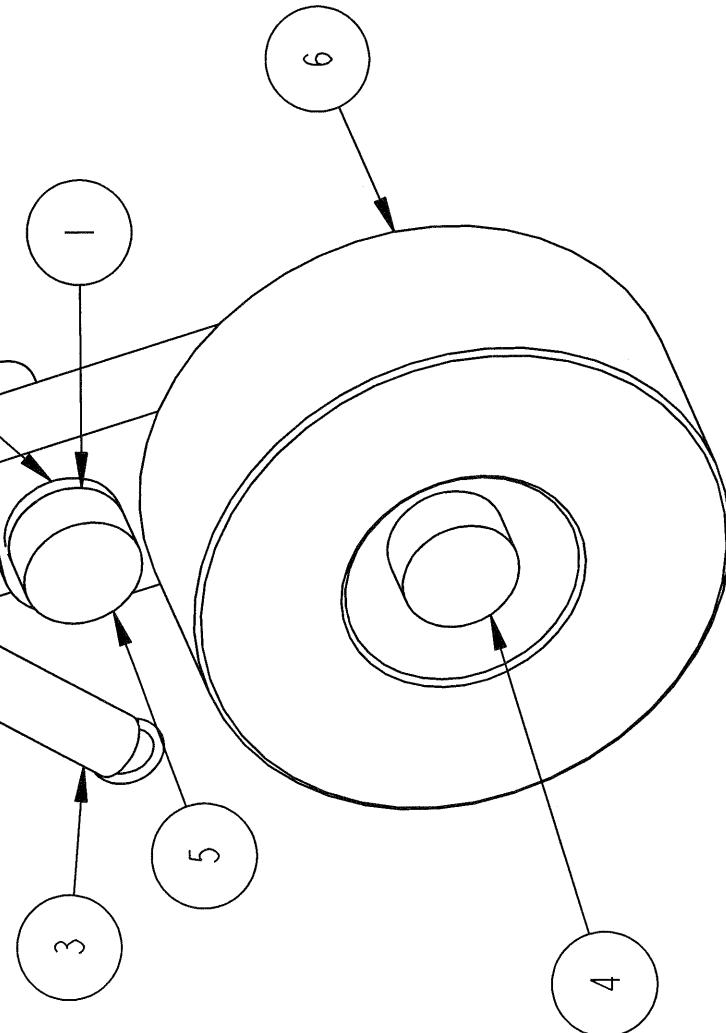
ITEM NO.	PART #	DESCRIPTION
1	100149	BUSHING, SL. 750ID 875OD .500LG
2	102123	KNOB, ROUND
3	105210	PIN, ROLL, .125X .750
4	2	ASSY, KNOB
5	6	ASSY, SKID BAR ROLLER
6	1	PLATE, SKID BAR ROLLER MOUNT
7	1	545119-02 BAR, ROLLER HEIGHT ADJUSTMENT
8	1	545130-01 SHAFT, SPRING ROLLER KNOB
9	1	545137-01 BRACKET, VERTICAL HOLD DOWN MOUNT
10	1	545138-02 GUIDE, VERTICAL HOLD DOWN
11	6	SCREW, BUTTON HEAD #6-32X.625



ITEM NO.	REV NO.	DATE	DESCRIPTION	ECN NO.	BT
1	SAB2				
RECD	WHERE USED				
SAB182	WOODSTOCK, GEORGIA				
PROPRIETARY AND CONFIDENTIAL NO COPIES OR DERIVATIVES MAY BE MADE OR DISCLOSED EXCEPT WITH THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC. WOODSTOCK, GA 30188 USA					
DRAWING PROJECTION					
SAB182					
ASSY, SKID BAR ROLLER					
DRAWING 1					
545058-04					

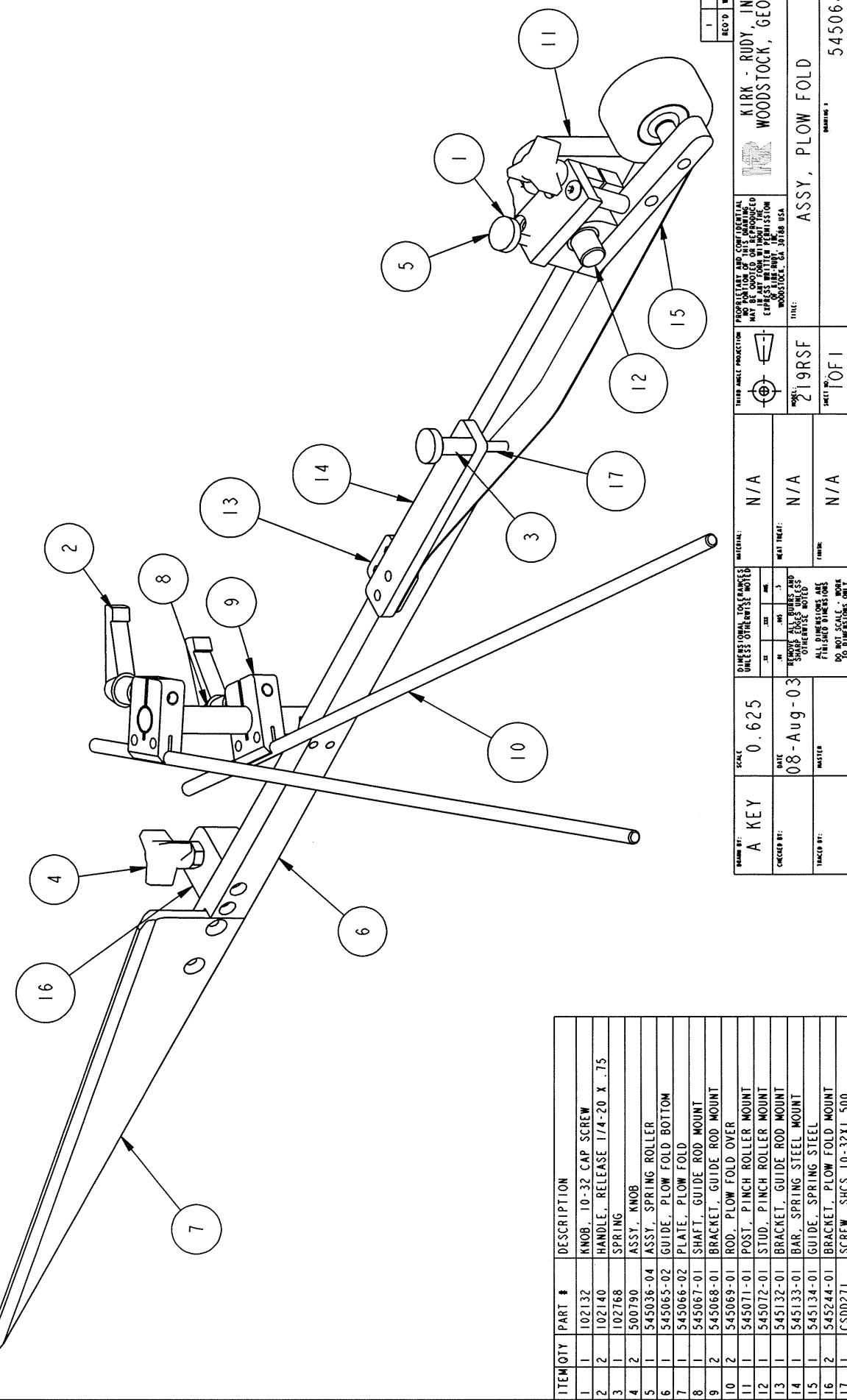
NAME BY:	SCALE	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	MATERIAL	THREE DIMENSION
A KEY	0 .750		N/A	
CHECKED BY:	DATE	IN	IN	
	04 - Aug - 03	.005	.005	
TRACED BY:	MASTER	WT	WT	
		N/A	N/A	
				NOT TO SCALE, WORK TO DIMENSIONS ONLY
				1 OF 1

ITEM	QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	1	100318	BUSHING, FL. 3131D.4380D.500LG					
2	1	100608	WASHER, FLAT 1/4ID 3/32TK BRASS					
3	1	102762	SPRING, EXTENSION					
4	1	107101	BOLT, SHOULDER 5/16X3/8					
5	1	107102	BOLT, SHOULDER 5/16X1/2					
6	1	500339-2A	ASSY, ROLLER					
7	1	537761-03	ARM, ROLLER MOUNT					
8	1	CSFF48	SCREW, BUTTON HEAD #6-32X.500					
9	1	HMSN08	NUT, HEX #6-32					



DRAWN BY: A KEY	SCALE 1 . 500	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED .01 .005 .005 .5	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. KENNESSAW, GA 30144 USA
DATE 04-Apr-03		HEAT TREAT: N/A		MODEL: SAL 82	TITLE: ASSY, SKID BAR ROLLER
CHECKED BY:		FINISH: N/A		SHEET NO.: 10F1	DRAWING #: 537760-04
TRACED BY:	MASTER				

REV NO	DATE	DESCRIPTION	ECN NO	BT



ITEM #	PART #	DESCRIPTION	SCALE	SCALE	MATERIAL:
1	1	KNOB, 10-32 CAP SCREW	IN	MM	N/A
2	2	HANDLE, RELEASE 1/4-20 X .75 SPRING	IN	MM	N/A
3	1	102768 ASST. KNOB	IN	MM	N/A
4	2	500790 ASSY, SPRING ROLLER	IN	MM	N/A
5	1	545065-04 ASSY, SPRING ROLLER	IN	MM	N/A
6	1	545065-02 GUIDE, PLOW FOLD BOTTOM	IN	MM	N/A
7	1	545066-02 PLATE, PLOW FOLD	IN	MM	N/A
8	1	545067-01 SHAFT, GUIDE ROD MOUNT	IN	MM	N/A
9	2	545068-01 BRACKET, GUIDE ROD MOUNT	IN	MM	N/A
10	2	545069-01 ROD, PLOW FOLD OVER	IN	MM	N/A
11	1	545071-01 POST, PINCH ROLLER MOUNT	IN	MM	N/A
12	1	545072-01 STUD, PINCH ROLLER MOUNT	IN	MM	N/A
13	1	545132-01 BRACKET, GUIDE ROD MOUNT	IN	MM	N/A
14	1	545133-01 BAR, SPRING STEEL MOUNT	IN	MM	N/A
15	1	545134-01 GUIDE, SPRING STEEL	IN	MM	N/A
16	2	545244-01 BRACKET, PLOW FOLD MOUNT	IN	MM	N/A
17	1	CSD0271 SCREW, SHCS 10-32X 1.500	IN	MM	N/A

ITEM QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	1 00135	BUSHING, SL 500 ID. 625 OD. 500 LG					
2	1 02119	KNOB					
3	1 02132	KNOB, 10-32 CAP SCREW					
4	1 102704	SPRING, COIL					
5	1 500745A	ASSY, UPPER FEED ROLLER					
6	1 537512-01	BLOCK, BUMP TURN ROLLER MNT					
7	1 537513-01	PLATE, BUMP TURN CAP					
8	1 537514-01	BLOCK, BUMP TURN PIVOT					
9	1 545037-01	ARM, PINCH ROLLER MOUNT					
10	1 545038-01	STUD, IDLER ROLLER					
11	1 CSDD267	SCREW, SHCS 10-32X .750					
12	1 CSFF58	SCREW, BUTTON HEAD #10-32X .500					
13	1 CSFF60	SCREW, BUTTON HEAD #10-32X .750					
14	1 HMSN10	NUT, HEX # 0-32					

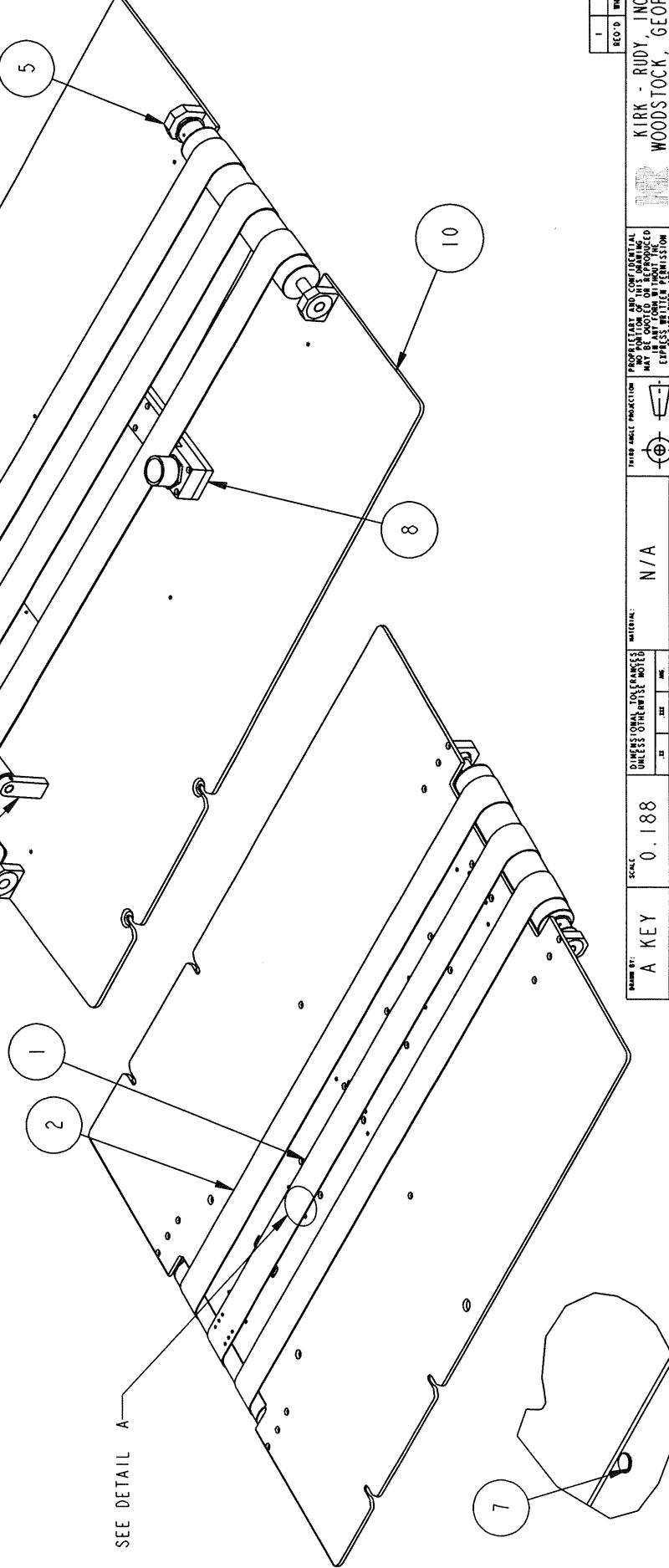
1	SA182
REQ'D	WHERE USED

PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE QUOTED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC. KENNESAW, GA 3044 USA	THIRD ANGLE PROJECTION
KR	KIRK - RUDY, INC. KENNESAW, GEORGIA
MODEL: SA182	TITLE: ASSY, SPRING ROLLER
SHEET NO: 10F1	DRAWING #

DRAWN BY: A KEY	SCALE 1 .000	MATERIAL: N/A
CHECKED BY:	DATE 26-Mar-03	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED .01 .005 .5 .xx .xxx .ang.
TRACED BY: MASTER		HEAT TREAT: N/A
		FINISH: N/A

ITEM QTY	PART #	DESCRIPTION	REV NO	DATE	ECN NO	BT
1	1111831-1	BELT, FLAT 87.00 X 2.125 W/HOLES				
2	1111843-1	BELT, FLAT 87.00 X 2.125				
3	5371638-01	BAR, PLATE SPLICE				
4	539014-01	ASSY, OUTFEED ROLLER				
5	538016-02	ASSY, DRIVE ROLLER				
6	539358-01	ASSY, BELT DIVERT				
7	10 529388-02	PIN, VACUUM HOLE BELT GUIDE				
8	1 545046-01	ASSY, OUTFEED VACUUM CHANNEL				
9	1 545049-03	TABLETOP, OUTFEED RH				
10	1 545049-04	TABLETOP, OUTFEED RH				

SEE DETAIL A



DETAIL A
SCALE 1.000

ITEM #:	A KEY	SCALE:	0 . 188	DIMENSIONAL TOLERANCES: UNLESS OTHERWISE NOTED	N/A	THREE ANGLE PROJECTION	PROPRIETARY AND CONFIDENTIAL
CHECKED BY:				IN INCHES	IN INCHES	IN INCHES	PRINTED ON 08/08/2003 BY KIRK-RUDY INC.
DATE:	08 - Aug - 03			MM	MM	MM	WOODSTOCK, GEORGIA
REMOVED ALL SURFACES AND OTHER SURFACES				INCHES	INCHES	INCHES	
SHOWN AS ONE SURFACE				INCHES	INCHES	INCHES	
ALL DIMENSIONS ARE				INCHES	INCHES	INCHES	
INCHES OR MILLIMETERS. (MM)				INCHES	INCHES	INCHES	
NO SCALE: WORK				INCHES	INCHES	INCHES	
TO DIMENSIONS ONLY				INCHES	INCHES	INCHES	

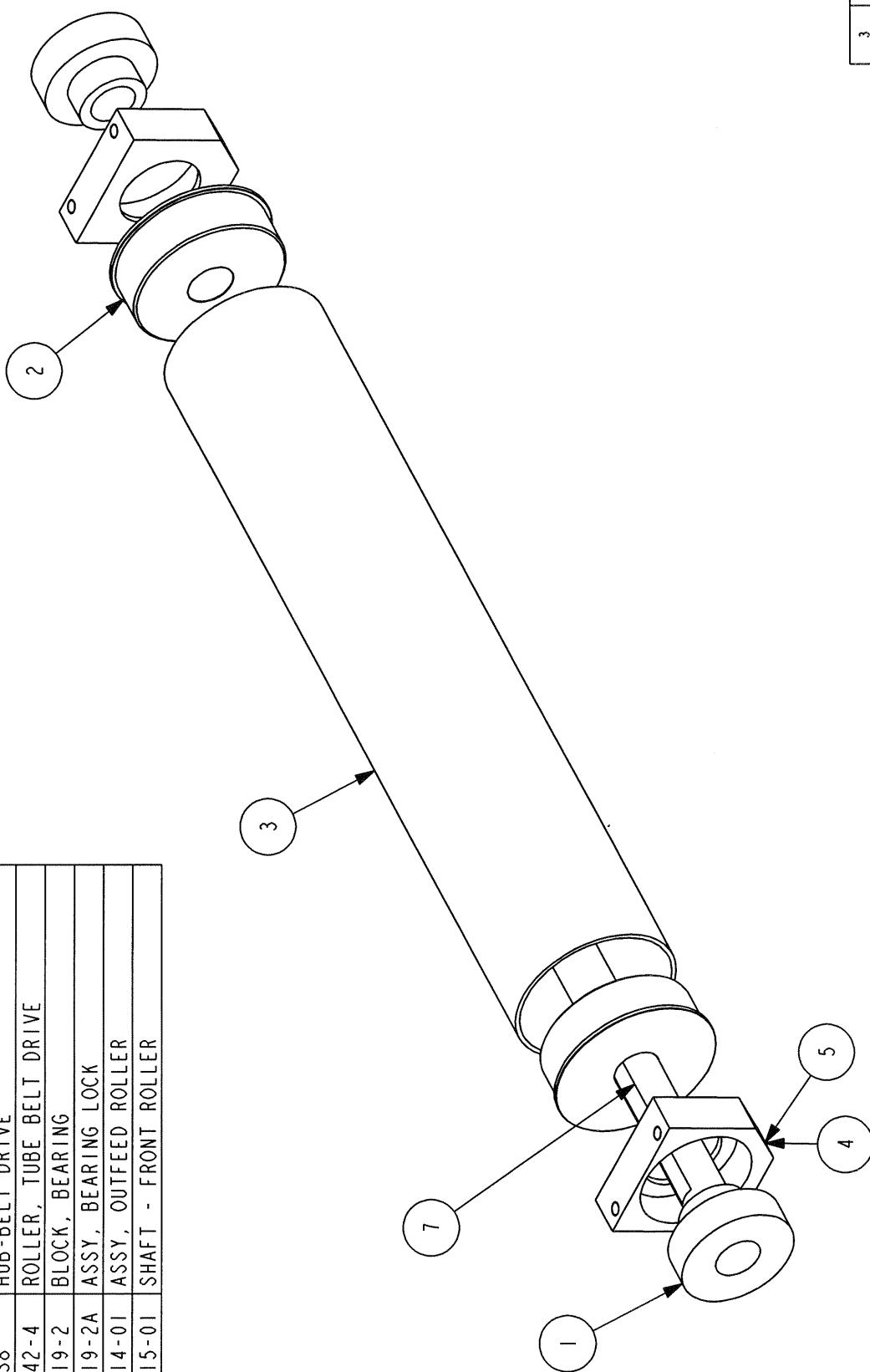
ITEM #:	1	219SF
ECN #:	WEEKLY ISD	

ASSY, TABLETOP

DRAWING #

545048-02

ITEM	QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	2	103804	BEARING, HUB .625					
2	2	500838	HUB-BELT DRIVE					
3	1	500742-4	ROLLER, TUBE BELT DRIVE					
4	2	500819-2	BLOCK, BEARING					
5	2	500819-2A	ASSY, BEARING LOCK					
6	1	539014-01	ASSY, OUTFEED ROLLER					
7	1	539015-01	SHAFT - FRONT ROLLER					



DRAWN BY: A KEY	SCALE 0 . 500	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED .xx .xxx .005 .5	MATERIAL: N / A	THIRD ANGLE PROJECTION 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 08 - Mar - 00	HEAT TREAT: N / A	MODEL: SP 80500	TITLE: ASSY, OUTFEED ROLLER	RECD WHERE USED 3 SP80500
TRACED BY: MASTER	MASTER	FINISH: N / A	SHEET NO.: 1 OF 1	DRAWING #: 539014-01	

ITEM	QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	2	103804	BEARING, HUB .625					
2	2	500838	HUB-BELT DRIVE					
3	1	108809-1	PULLEY, TIMING 12L075 .625B .188K					
4	1	500742-4	ROLLER, TUBE BELT DRIVE					
5	2	500819-2	BLOCK, BEARING					
6	2	500819-2A	ASSY, BEARING LOCK					
7	1	539016-02	ASSY, DRIVE ROLLER					
8	1	539115-02	SHAFT, ROLLER DRIVE					

I SA182
 REV 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

KR

ASSY , DRIVE ROLLER
 DRAWING #

SHEET NO OF 1

539016-02

DRAWN BY: A KEY	SCALE 0 . 625	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	
DATE: 26 - Mar - 03	.xx	.005	.5	ANG.	HEAT TREAT:	N / A	MODEL: SA182	TITLE: ASSY , DRIVE ROLLER
CHECKED BY:	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED				FINISH:	N / A	SHEET NO OF 1	DRAWING #
TRACED BY:	ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY					N / A		

ITEM	QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	2	103108	BEARING, FLAT .500					
2	2	539072-01	POST, BELT DIVERT					
3	1	539338-01	ROLLER, BELT DIVERT					
4	1	539359-01	SHAFT, BELT DIVERT ROLLER					

3	SP84000
REQ'D WHERE USED	

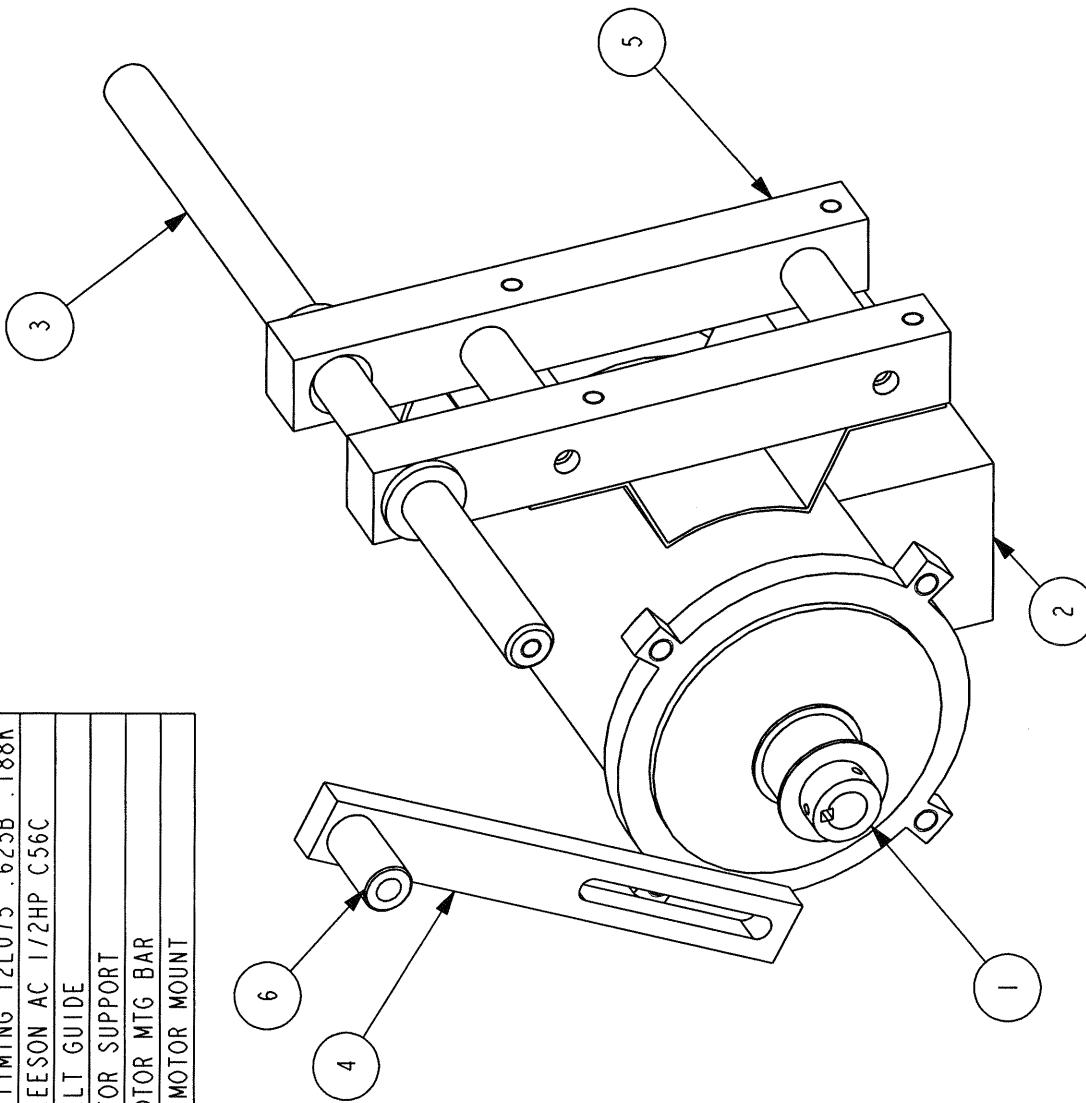
DRAWN BY: A KEY	SCALE 0 . 625	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED				MATERIAL: N / A	THIRD ANGLE PROJECTION		PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE QUOTED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY INC. KENNESAW, GA 30144 USA
CHECKED BY:	DATE 24 - May - 00	.xx	.xxx	.005	.5	HEAT TREAT: N / A			
TRACED BY:	MASTER	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED				FINISH: N / A	MODEL: SP84000	TITLE: ASSY , BELT DIVERT	
		ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY				SHEET NO. OF 1	DRAWING #	539358-01	

ITEM QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	190715	PVC COUPLING					
2	530656-01	ASSY, VACUUM MANIFOLD					
3	545046-01	ASSY, OUTFEED VACUUM CHANNEL					
4	545047-01	CHANNEL, OUTFEED VACUUM					
5	SP28217-1	BLOCK, LOWER VACUUM					
6	SP28218-1	BLOCK, UPPER VACUUM					

-	SA182
REQ'D	WHERE USED

DRAWN BY: A KEY	SCALE 0 . 28	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED			MATERIAL: N / A	THIRD ANGLE PROJECTION - - -	PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE QUOTED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC. WOODSTOCK, GA 30188 USA
CHECKED BY:	DATE 08 - Aug - 03	.xx	.xxx	.5	HEAT TREAT: N / A		KIRK - RUDY, INC. WOODSTOCK, GEORGIA
TRACED BY:	MASTER	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY			FINISH: N / A	MODEL: 219RSF	TITLE: ASSY, OUTFEED VACUUM CHANNEL
					SHEET NO: 1 OF 1	DRAWING #: 545046-01	

ITEM	QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	1	108809	PULLEY, TIMING 12L075 .625B .188K					
2	1	200614	MOTOR, LEESON AC 1/2HP C56C					
3	1	500824	SHAFT-BELT GUIDE					
4	1	530512-01	ARM, MOTOR SUPPORT					
5	1	530654-01	ASSY, MOTOR MTG BAR					
6	1	545103-01	SPACER, MOTOR MOUNT					



1	219RSF
REQ'D	WHERE USED

DRAWN BY: A KEY	SCALE 0 . 375	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED			MATERIAL: N / A	THIRD ANGLE PROJECTION [Diagram: Top view of a rectangular part with a central hole and two side features.]	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 10 - JUN - 03	.01	.005	.5	HEAT TREAT: N / A	MODEL: 219RSF	TITLE: ASSY , 1 / 2 HP AC MOTOR MOUNT	DRAWING #
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	SHEET NO. 1 OF 1	538022-03	

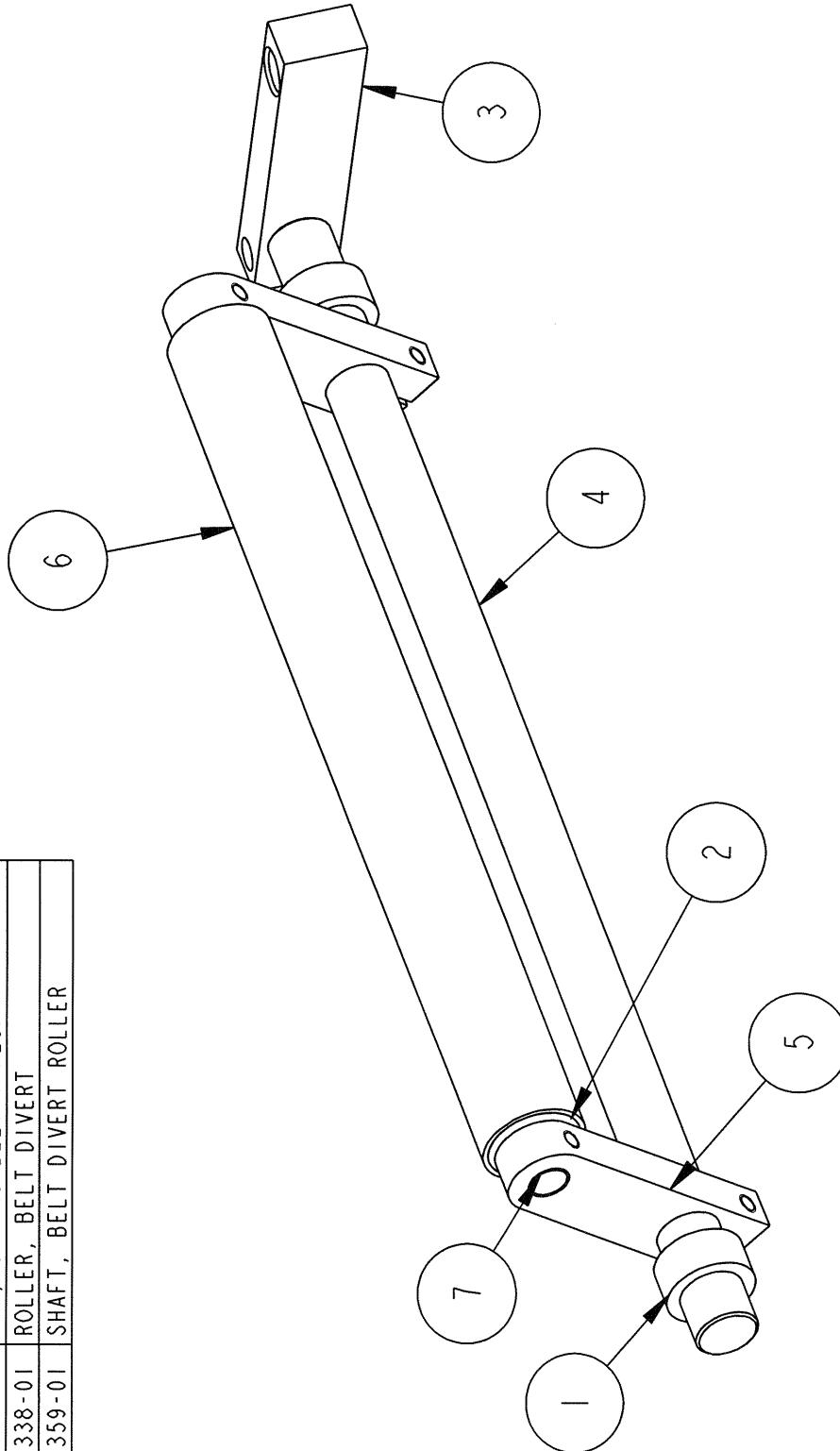
KR KIRK - RUDY, INC.
KENNESAW, GEORGIA

ITEM	QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	2	100320	BUSHING, FL. 7501DI.0000DI.000LG					
2	2	530510-01	PIVOT BAR					
3	2	530511-01	SPACER, 3/4OD X 2L					

-	GENERAL
REQ'D	WHERE USED

DRAWN BY: T JG	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. KENNEBUNK, ME 04045 USA	
CHECKED BY:	DATE 27-JUL-01	.XX	.XXX	AMG.	.01	.005	.5	HEAT TREAT: N / A
TRACED BY:	MASTER	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED			MODEL: GENERAL			TITLE: ASSY, MOTOR MTG BAR
		ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY			SHEET NO. OF 1			DRAWING # 530654-01

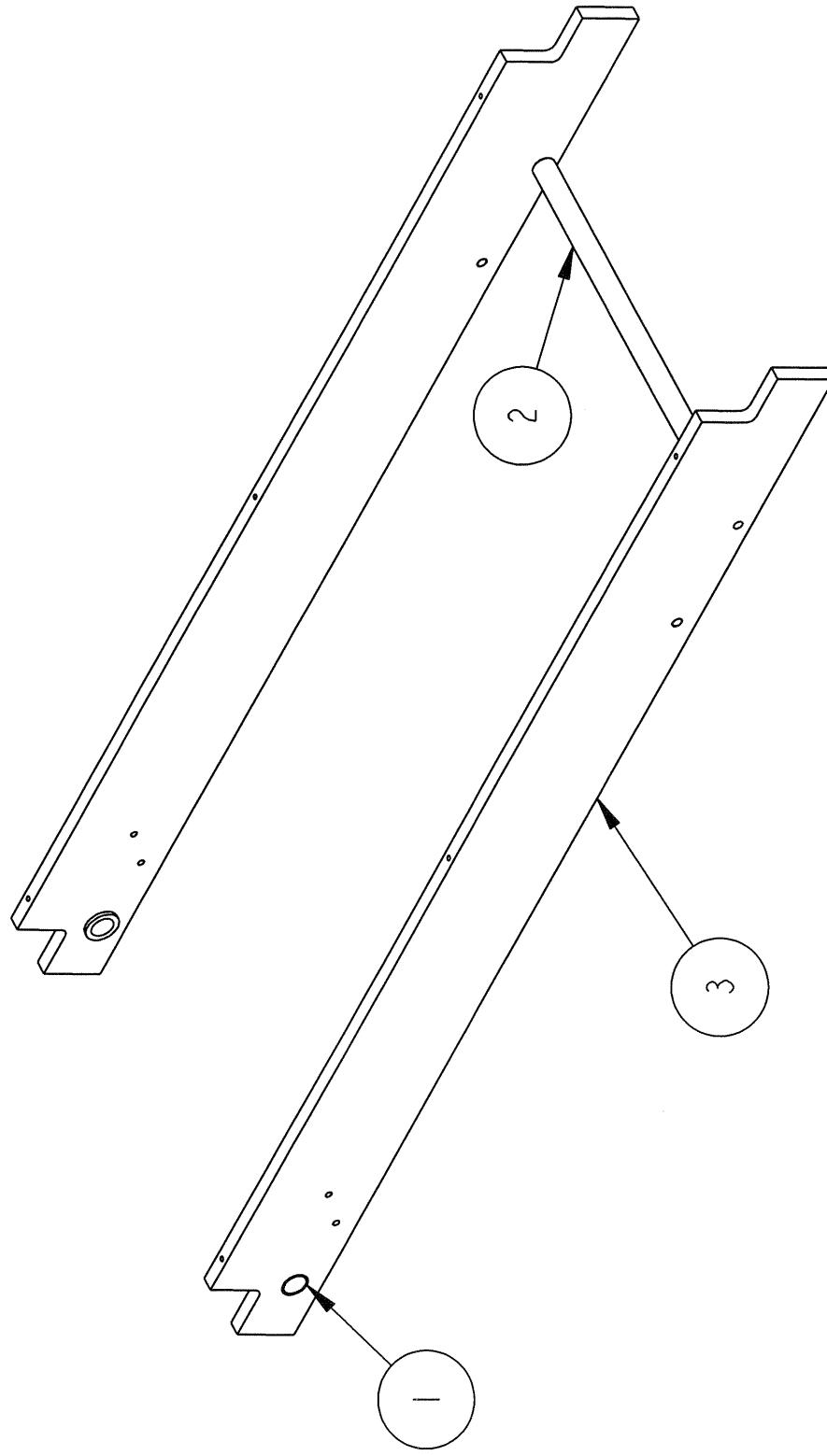
ITEM	QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	2	102207	COLLAR .750					
2	2	103108	BEARING, FLAT .500					
3	1	500786	LEVER, SPRING					
4	1	539078-01	SHAFT, BELT TAKEUP SPRING					
5	2	539079-01	ARM, SPRING BELT TAKEUP					
6	1	539338-01	ROLLER, BELT DIVERT					
7	1	539359-01	SHAFT, BELT DIVERT ROLLER					



DRAWN BY: A KEY	SCALE 0 . 500	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED			MATERIAL: N / A	HEAT TREAT: 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	
CHECKED BY:	DATE 26 - Mar - 03	.xx	.xxx	.5 ANG.	.01 .005		MODEL: SAI82	TITLE: ASSY , SPRING BELT TAKEUP
TRACED BY: MASTER		REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED			FINISH: N / A	SHEET NO.: 10F	DRAWING #: 545028-02	
		ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY						

1	SAI82
REQ'D	WHERE USED

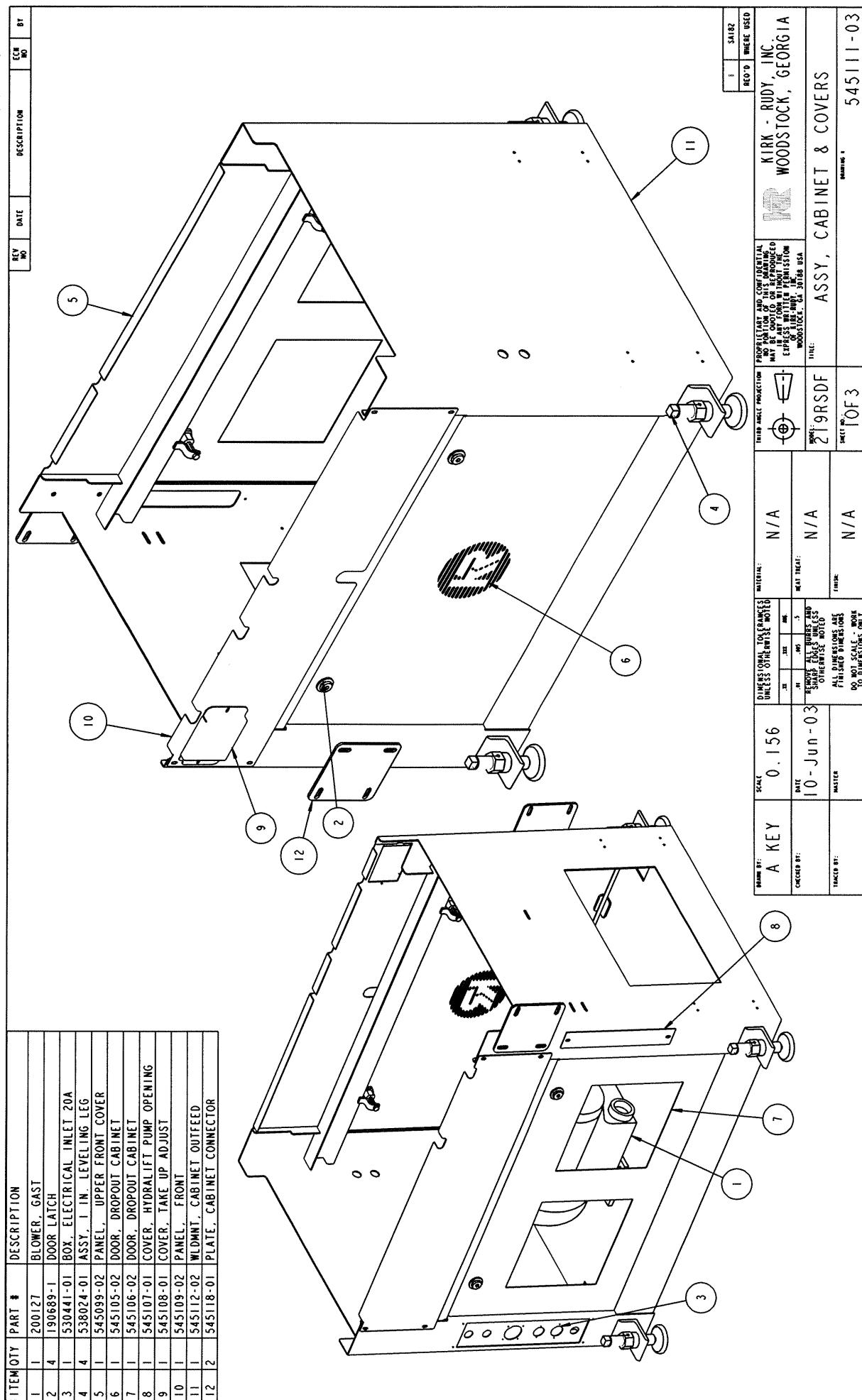
ITEM	QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	2	100357	BUSHING, FL. 750ID. 875OD. 625G					
2	1	500824	SHAFT-BELT GUIDE					
3	2	545042-01	PLATE, FRAME					



DRAWN BY: A KEY	SCALE: 0 . 188	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: 29-Apr-03	.xx	.xxx	.005	ANG. .5	HEAT TREAT: N / A	MODEL: SA182	TITLE: ASSY, FRAME
TRACED BY:	MASTER	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED			FINISH: N / A	SHEET NO.: 10F1	DRAWING #: 545041-01	

ITEM #	PART #	DESCRIPTION
1	20017	BLOWER, GAST
2	4 190689-1	DOOR LATCH
3	1 530441-01	BOX, ELECTRICAL INLET 20A
4	4 538024-01	ASSY. 1 IN. LEVELING LEG
5	1 545099-02	PANEL, UPPER FRONT COVER
6	1 545105-02	DOOR, DROPOUT CABINET
7	1 545106-02	DOOR, DROPOUT CABINET
8	1 545107-01	COVER, HYDRAULIC PUMP OPENING
9	1 545108-01	COVER, TAKE UP ADJUST
10	1 545109-02	PANEL, FRONT
11	1 545112-02	W/DOOR, CABINET OUTFEED
12	2 545118-01	PLATE, CABINET CONNECTOR

ITEM #	REV NO	DATE	DESCRIPTION	CCN NO	BT

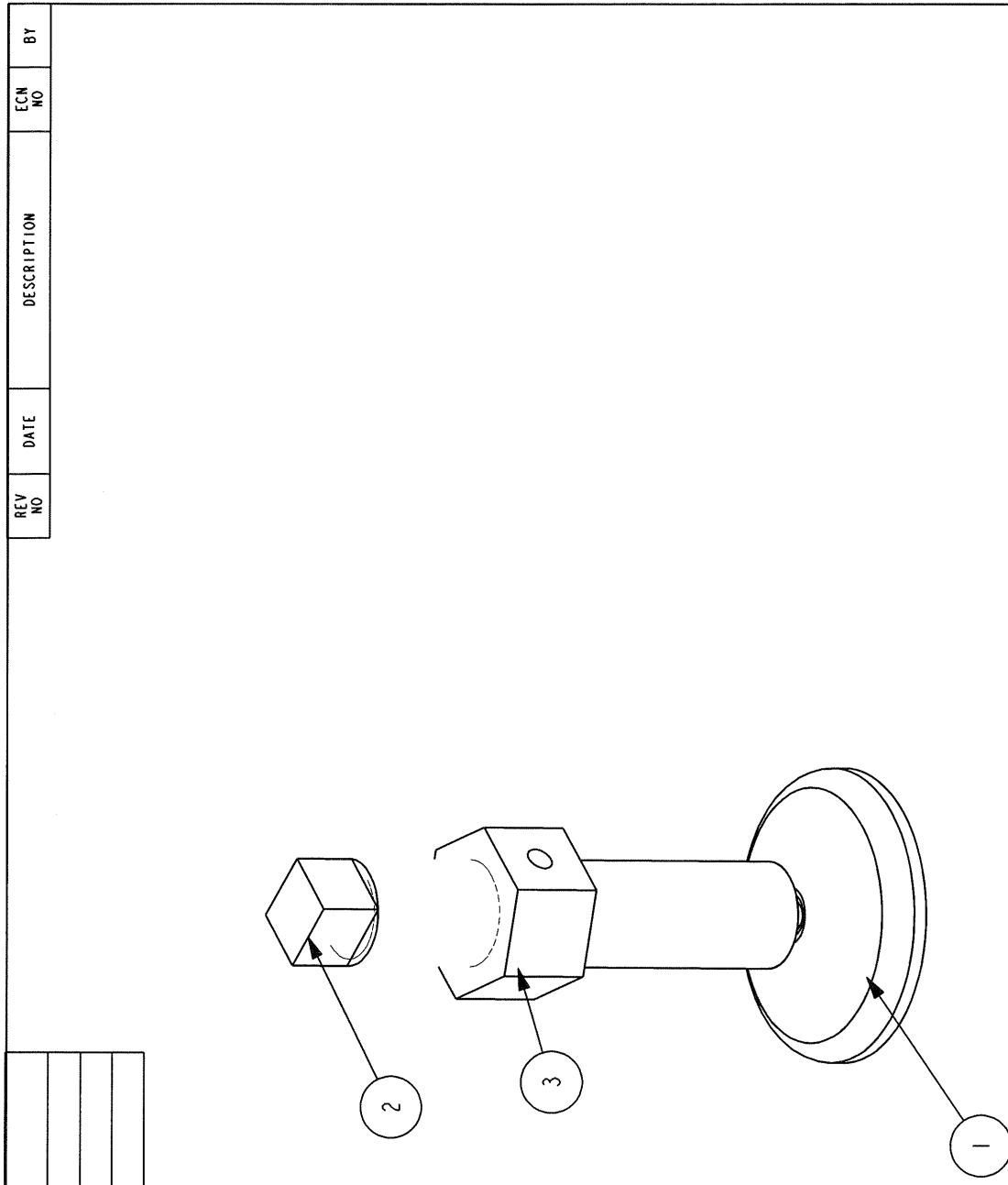


1	SAC182	RECD WHERE USED
KIRK-RUDY, INC.		
WOODSTOCK, GEORGIA		
ASSY, CABINET & COVERS		
Drawing 1 545111-03		

DRAWING BY:		SCALE	SCALE	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED		material	DRAWING PROJECTION NO DIMENSION OF THIS DRAWING IMPLIES ANY SIZE OR POSITION NOT SPECIFIED. THIS DRAWING IS THE PROPERTY OF KIRK-RUDY, INC. AND IS TO BE KEPT CONFIDENTIAL UNLESS WRITTEN PERMISSION IS GRANTED BY KIRK-RUDY, INC., WOODSTOCK, GA 30188 USA		TIME:
KEY	A	0	.156	.005	.005	N/A	.005	.005	
DATE	10 - Jun - 03								
CHECKED BY:									
TRACED BY:	MASTER								

1	SAK182	RECD WHERE USED
KIRK-RUDY, INC.		
WOODSTOCK, GEORGIA		
ASSY, CABINET & COVERS		
Drawing 1 545111-03		

ITEM QTY	PART #	DESCRIPTION
1	190634	FOOT, MOUNTING
2	191010	LEVELING BOLT, CABINET
3	191011	NUT, CABINET LEVELING



REV NO	DATE	DESCRIPTION	ECN NO	BY

X	GENERAL
REO'D	WHERE USED
KR KIRK - RUDY, INC.	
WOODSTOCK, GEORGIA	
PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE QUOTED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC.	
WOODSTOCK, GA 30188 USA	
THIRD ANGLE PROJECTION	
MATERIAL:	
DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	
SCALE:	0 . 625
DRAWN BY:	A Y B
CHECKED BY:	16 - Nov - 99
TRACED BY:	MASTER
DATE:	.01
xx	.065
ANG.	.5
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	
MODEL:	ASSY , 1 IN. LEVELING LEG
SHEET NO.:	10F1
DRAWING #	538024-01

10 ELECTRICAL SCHEMATICS AND PARTS

10.1 SCHEMATIC LIST

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

Schematic number: 200125 10 00

11 APPENDIX

11.1 POSSIBLE OPTIONS

The KR219RSDF In-Line Plow Fold 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 KR219RSDF base:

- Hydra-Lift Kit – Allows quick and easy setup when moving the base around as well as lifting the base from 0" to 5".
- KR219FL/KR219FR - The same base as a KR219FM included in this manual but with stand alone controls. This is used when registering or scoring the product is not required.

12 NOTES

13 WARRANTY AND SERVICE

WARRANTY

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

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

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

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

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

USE ONLY GENUINE KIRK-RUDY REPLACEMENT PARTS

KIRK-RUDY, INC
125 LORRAINE PARKWAY
WOODSTOCK, GA 30188
PH 770-427-4203
FX 770-427-4036