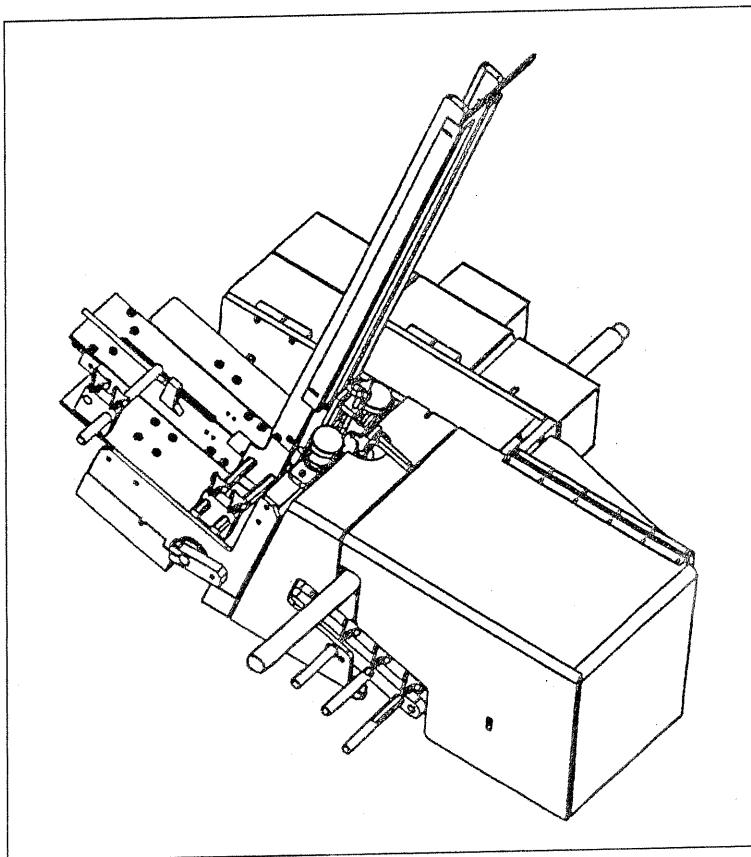


Kirk-Rudy, Inc.

Instruction and Parts Manual

486LR Credit Card Head



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.

10000-486 REV. E 28JAN2005

Instruction
and Parts Manual

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1 Important Safety Instructions

Intended Use Statement: The card feeder has been designed to individually feed and overlay a paper/plastic card onto another paper/plastic product. The card feeder is mounted on a base that uses a shuttle feeder to feed out product in time with a chain lug registration system on the base. The lugs push the product first under a hot melt applicator and then under the card feeder. The card feeder works similar to the base. A shuttle feeder delivers cards individually to a chain lug registration system that pushes the card down a ramp formed by the two lug side guides and onto the product. The combination is then transported onto a conveyor for ease in gathering. Adjustments can be made in the registration of the card on the product are made by adjusting the timing between the chain lug systems of the head and the base. 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.
- * READ ANY ADDITIONAL PRODUCT MANUALS THAT ARE SUPPLIED WITH KIRK-RUDY MACHINES FOR INSTRUCTIONS AND IMPORTANT SAFETY INSTRUCTIONS.

2 SPECIFICATIONS

<u>PRODUCT SIZE RANGE</u>	<u>English</u>	<u>Metric</u>
Minimum Size:	2" W x 2" L	51mm W x 51mm L
Maximum Size:	6.5" W x 7" L	165mm W x 178mm L
Minimum Thickness:	.005"	.13mm
Maximum Thickness:	0.094	2.4mm

SPEED

Maximum 15,000/hr (5.5" spacing)
 10,000/hr (22" spacing)

MACHINE DATA -BASE

Length:	9' 8"	~3 m
Width:	45"	114 cm
Height:	36"	91 cm
Weight: Net	1420 lbs.	645 kgs
Shipping Crate:	1670 lbs.	759 kgs

MACHINE DATA -HEAD

Length:	32.8"	83.3 cm
Width:	21.12"	53.6 cm
Height:	12"	30.5 cm
Weight: Net	65	29.5 kgs
Shipping Crate:	85	38.6 kgs

POWER REQUIREMENTS

Approximately 15 ft-lbs torque

VACUUM

25" Hg

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

Vacuum Pump Motor: Mounted on the inside of the electrical panel, are two 8MDL (@220V) or one 12MDL (@120V) fuses.

3 INSTALLATION



WARNING

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

3.1 MOUNTING THE HEAD (CARD FEEDER)

1. Uncrate the head and set on a flat surface.
2. Remove the head drive shaft on the base by removing the three bolts on the coupling and the two bolts and set screws on the support bearing (see drawing 533614-06 in the base manual).
3. Open the front cover and locate the head drive clamps on the head. Remove the bearing from the head drive shaft and insert the shaft into the sleeve on the side where the clamps are located stopping when the head gets midway on the shaft.
4. Slide the bearing back on the end of the shaft, flat side outward.
5. Using the head drive shaft, Lift the head with the head drive shaft and reinstall the shaft on the head support castings by first putting the end of the shaft through the hole in the casting.
6. Reinstall and tighten the bolts and setscrews for the bearing and the coupling and tighten the bolts on the head drive clamps.

CAUTION: RUNNING THE MACHINE WITHOUT TIGHTENING THE BOLTS ON THE HEAD DRIVE CLAMPS WILL CAUSE DAMAGE TO THE HEAD AND THE SHAFT.

7. Connect the clear tube from the forward vacuum pump to the nipple on the vacuum body underneath the shuttle table on the card feeder. (see drawing 535403-01)
8. Connect the three pin twist plugs together for the head solenoid power.
9. Connect the molex plugs (labeled #2) for the product gate beam switch. (see drawing 534034-01)
10. Connect the quick disconnect cable (labeled #3) to the card missfeed beam switch mounted on the bridge.
11. Open the back cover and connect the quick disconnect cable (labeled #4) to the card gate beam switch. (see drawing 534034-01)
12. Mount the safety interlock for the onto chain lug cover. (see drawing SP66600-3, sheet 1 of 5)

4 MACHINE DESCRIPTION

4.1 HEAD MECHANICAL COMPONENT DESCRIPTION

1. VACUUM BODY: Provides vacuum to hold the bottom card to the shuttle feeder table. A spring valve in the vacuum body opens and closes to provide vacuum in time with the movement of the shuttle table. A removable vacuum feeder plate, equipped with holes for the vacuum and a slot for the rear guide, is attached to the top of the vacuum body. Interchangeable vacuum feeder plates are available for feeding different products thru the feeder. (see drawing 535403-01)
2. SHUTTLE TABLE: Moves the bottom card under the feed gate and between a set of upper and lower feed rollers. The back and forth movement of the shuttle table (center plate) is controlled by a crank arm. The movement also causes a push rod to move in and out of the vacuum body to open and shut the spring valve. A pusher plate is mounted on top of the shuttle table to assist in feeding the bottom card out when the shuttle table moves forward. A rear guide suspended in a slot in the shuttle table (support credit card pusher) keeps the cards forward against the feed gate as the shuttle table moves back. (see drawing 534023-01)
3. BRIDGE ASSEMBLY: Provides an adjustable feed gate to prevent more than one card from being fed at one time. Provides a set of adjustable top feed rollers to help move the card from the shuttle table to the lug chain. Provides a quick release for raising the top feed rollers to clear a jam. (see drawing 534068-01)
4. LOWER FEED ROLLERS: As the shuttle feeder moves forward and the vacuum is turned off, the lower rollers work together with the top feed rollers to move a card from the shuttle table onto the chain lug system. The lower feed rollers are gear driven, the top feed rollers free wheel. (see drawing 534071-01)
5. CARD HOPPER GUIDE: Provides side guides for guiding the cards down to the shuttle table as the bottom card below feeds out. Provides angle side guides to guide the leading edge of the cards so that the cards can be stacked at the same angle of the shuttle table. Provides brushes to help support the weight of the stack of cards in the feeder making the bottom card easier to feed. Provides a side guide tie strap to stabilize the top of the side guides. (see drawing 536342-01)
6. CHAIN REGISTER ATTACHER SYSTEM: Provides a driven belt for transporting the cards from the shuttle feeder to the chain lugs. Provides lug side guides for guiding and supporting the cards from the shuttle feeder to the tabletop. Provides a set of lug chains for pushing the cards, in time with the product on the base, from the to belt to the tabletop. Provides a spring loaded chain take-up for each lug chain. Provides rail adjustment for moving the side guides in or out and locking the guide in position. (see drawing SP66600- 3, sheet 5 of 5)
7. SKIDBAR: Provides bearings, spring loaded by arms on the skid bar, to roll over the top of the cards adding friction while they are on the drive belt. Provides hold down straps with adjustable tension, for keeping the trailing edge of the cards against the chain lugs while they travel down the lug side guides. (see drawing 535807-01)
8. PINCH ROLLERS: Spring loaded pinch rollers provide pressure for transferring the cards from the side guides to the product. (see drawing 535356-03)

9. GEAR ASSEMBLY: Provides a way to time the card shuttle feeder to the chain register attachment system. (see drawing 535389-01 and SP66600-3, sheet 5 of 5)
10. THROW OUT ASSEMBLY: Provides a way to stop the card feeder from feeding a card when there is a missfeed of the base product feeder or if the feeder had ran out of product. (see three drawings labeled 534034-01)

4.2 HEAD ELECTRICAL COMPONENT DESCRIPTION

1. SOLENOID: Attached to the throw out assembly, provides a way to disconnect the card feeder shuttle table crankshaft when a product missfeed occurs on the base shuttle feeder or when the base feeder runs out of product. (see drawing 534034-01)
2. PRODUCT MISSFEED BEAM SWITCH: A 90 degree, retro-reflective beam switch located above the base tabletop and underneath the card feeder, provides product detection for the product missfeed circuit. The connecting cable for the beam switch is labeled #1 beam switch.
3. PRODUCT GATE BEAM SWITCH: A retro-reflective beam switch with an internal relay provides “gating” for the product missfeed circuit. It is mounted so as to sense the reflector on the inside prox ring on the side of the head. The connecting cable for the beam switch is labeled #2 beam switch. (see drawing 535034-01)
4. CARD MISSFEED BEAM SWITCH: A retro-reflective beam switch mounted on the head bridge provides card detection for the card missfeed circuit. The connecting cable for the beam switch is labeled #3 beam switch.
5. CARD GATE BEAM SWITCH: A retro-reflective beam switch mounted on the head provides “gating” for the card missfeed circuit. It is mounted so as to sense the reflector on the outside prox ring on the side of the head. The connecting cable for the beam switch is labeled #4 beam switch. (see drawing 535034-01)
6. SAFETY INTERLOCK: A safety interlock will open the stop circuit and stop the machine when the safety cover for the chain lugs is open.

5 SETUP AND OPERATION

5.1 CARD FEEDER SETUP (Abbreviated)

1. Perform routine maintenance.
2. Select and install proper vacuum plate.
3. Adjust and lock the upper feed rollers.
4. Adjust and lock the feed gate.
5. Set and lock pusher plate.
6. Set and lock rear guide.
7. Set and lock card hopper guide assembly.
8. Set Lug side guides.
9. Turn on feeder vacuum and adjust.
10. Time card shuttle feeder to chain lugs using gear assembly.

11. Adjust skid bar and hold down straps.
11. Test run and fine tune head till cards feed from the card feeder to the base with no problems.

5.2 CARD FEEDER SETUP (Expanded)

1. **PERFORM MAINTENANCE** – To prevent possible problems with setup and operation, clean and lubricate the card feeder as necessary before completing the rest of the set up. (see Section 7 - Maintenance)
2. **SELECT AND INSTALL PROPER VACUUM PLATE** – The machine is normally shipped with the vacuum plate for card feeding. Other vacuum plates are available if the vacuum plate provided is not compatible to what is being fed.
3. **ADJUST AND LOCK THE UPPER FEED ROLLERS** – Using the quick release lock to raise the upper rollers so that a portion of the card can be placed between an upper and lower roller. Using the knob on top of the roller adjust the height of the roller till the card is gripped by the rollers with the quick release locked. When adjusted properly, it takes a firm tug to pull the card out from between the rollers. Tighten the locking ring below the adjustment knob to hold the adjustment of the roller. Repeat the process for the other roller.
4. **ADJUST AND LOCK THE FEED GATE** – Use the knob on top of the feed gate assembly to adjust the height of the feed gate to the thickness of the card. Lock the feed gate in place by using the horizontally opposing screw at the top of the feed gate assembly.
5. **SET AND LOCK PUSHER PLATE** – Hand wheel the machine until the shuttle table on the card feeder is in the full back position. Loosen the button head screws holding the pusher plate and adjust the position of the pusher plate until a card can fit between the leading edge of the pusher plate and the gate. Lock the pusher plate down in place using the button head screws so that an even 1/16 inch gap is between the card and the plate. This adjustment should leave enough room for the trailing edge of the next card to drop down in front of the pusher plate when the shuttle table is in the full back position.
6. **SET AND LOCK REAR GUIDE** – Use the setscrew in the end of the $\frac{1}{2}$ inch support shaft to position and lock the rear guide. Leave a 1/16 inch gap between the rear guide and the cards so that the cards can drop downward to feed out.
7. **SET AND LOCK CARD HOPPER GUIDE ASSEMBLY** – Leaving a 1/32 inch gap between each guide and the cards, set the guides to center the cards in the feeder and use the knobs to lock the right guide in place and the cap screws to lock the left guide in place. It is possible to set the guides to feed the cards off center if the situation requires it. Shorter support shafts for the left side guide can be obtained if the card is larger than normal. Use the side guide tie strap to set and lock the width of the top of the side guides (a technique is to set the top of the side guides a little wider than the bottom). Use the slotted holes to adjust of the angle side guide that is mounted to each side guide plates so the leading edge of the cards is even with the feed gate. Use the slotted holes on the brush holder and the brush block to adjust of the brush pressure. The purpose of the brushes is to help hold the weight off the bottom cards to make it easier for the bottom card to feed out. The best technique is to use less brush pressure at the top of the stack of cards and more brush pressure towards the bottom of the stack.

8. SET LUG SIDE GUIDES – Four knob screws are used to lock the support shafts to hold the lug side guides in place. Loosen the two outside screws and push or pull on the support shafts till the left lug side guide is in alignment with the left feeder side guide. Then, use the knob screw to lock the adjustment in place. Repeat the procedure to align the right lug side guide with the right feeder side guide. When properly adjusted, a card will be able to slide down the lug side guides from the card feeder to the base tabletop when being pushed by the chain lugs.
9. TURN ON FEEDER VACUUM AND ADJUST – The right vacuum pump switch on the control panel turns on the vacuum pump to the card feeder. After turning on the pump, hand wheel the machine till the shuttle table in the card feeder is all the way forward. This will close the valve in the vacuum body. Open the doors under the control panel and check the amount of vacuum is on the gage of the right vacuum pump. The pump gage should read above 20 inches if the valve in the vacuum body is closed. If the vacuum is below 20 inches, loosen the locking nut on the pressure relief valve and increase the spring pressure on the valve by holding the bottom of the screw to keep it from turning and turning the upper nut to run it up the screw. As you increase the spring pressure the amount of vacuum showing on the gage will increase. Lock the adjustment in place by re-tightening the lock nut against the adjustment nut.
10. TIME CARD SHUTTLE FEEDER TO CHAIN LUGS USING GEAR ASSEMBLY – Check that the card feeder vacuum pump is on and check that the toggle switches for the beam switches are off. Hand wheel the machine till the chain lugs on the top rear sprocket of the head are 90 degrees from the upright position. If the chains in the head do not move, open the cover for the head drive clamps, tighten the clamps and try again. Load a card in the card feeder. Go to the left side of the machine and open the cover for the gear assembly. Pull out and hold the knob on the spring loaded gear assembly to disengage the card feeder from the drive gear. Keeping the handle pulled out. Rotate the knob counter clockwise till the trailing edge of the card feeds out beyond the chain lugs. Make sure the handle on the gear assembly goes back in when you release it. You might have to wiggle the knob on the gear assembly back and forth to get the teeth on the gears to line up for the handle to go completely back in and re-engage the gears. Load another card in the card feeder and jog the machine to check that the card makes a smooth transition from the card feeder, to the belts to the trailing edge being pushed by the lugs. Retry the procedure as necessary until the desired results are achieved.
11. ADJUST SKID BAR AND HOLD DOWN STRAPS – The skid bar assembly is clamped to a $\frac{1}{2}$ inch shaft. Check to see that the clamp is parallel to the lug side guides. If not, loosen the clamp and re-tighten it so that it is parallel. The skid bar is spring loaded so that it will swing upward and forward if a card jam should occur. The forward swing arm rests on a pin inserted in a clamp collar. Adjust the resting height of the skid bar to the top of the cards in the lug side guides by loosening the clamp collar and re-tighten the collar so that the bearings of the skid bar just touch the cards in the lug side guide. Use the brass finger screws to adjust the tension of the hold down straps. The straps should have enough tension to keep the trailing edge of the cards against the chain lugs.
12. TEST RUN AND FIND TUNE THE HEAD TILL CARDS FEED FROM THE CARD FEEDER TO THE BASE WITH NO PROBLEMS – With the missfeed

toggle switches off on the control panel, the card feeder will continuously feed cards, with or without product being fed, as long as the machine is running and cards are in the card feeder. When you are finished making any adjustments on the card feeder refer to the Machine Setup (Expanded) in the base manual for timing the head to the base and setting the missfeed systems.

6 PRODUCT SPACING CHANGE

To accommodate different size products, the KR215-486LR can be setup to run with 5.5, 11, or 22 inch spacing. The instructions for changing the base spacing are in the manual for the base. Two gears and two lug chains with the appropriate lug spacing must be obtained and changed in the head to change the spacing. The gears for all three spacing are listed in drawing SP66600-3, sheet 3 of 5 in this manual. For lug chains and gears for 5.5 inch spacing see drawing 535388-06. For lug chains and gears for 11 inch spacing see drawing 535388-01. For lug chains and gears for 22 inch spacing see drawing 535388-05.

7 MAINTENANCE

1. The upper and lower feed rollers can be cleaned with an alcohol and water solution.
2. Four grease fittings on the card shuttle table provide a way to add grease to the shuttle table bushings. Two of the grease fittings can be serviced easily from the back of the card feeder. The top plates on the right and left side of the shuttle table must be removed to service the other two grease fittings. (see drawing 534023-01) Check the shafts frequently and add grease as necessary to keep from running dry.
3. The vacuum body and spring valve should be checked and cleaned frequently.
4. To keep the head so it can be easily reposition for registering the product, wipe oil on the head drive shaft, loosen the head clamps and slide the head back and forth on the shaft a routine basis. This will keep a light film of oil on the head drive shaft and between the shaft and the sleeve of the head clamps.

8 DIAGRAM AND PARTS LIST

SP66600-3	TOP LEVEL
534073-01	ASSY, FRAME FRONT
534031-01	ASSY, FRAME PLATE
534030-01	ASSY, FEEDER
534023-01	ASSY, VACUUM FEEDER
534035A-01	ASSY, SIDE PLATE
534068-01	ASSY, BRIDGE
534071-01	ASSY, LOWER FEED ROLLER
500729-2A	ASSY, ARM CRADLE FEEDER
534025-01	ASSY, FEEDER LEVER
500751A	ASSY, BEARING BLOCK
535405-01	ASSY, GUIDE
535403-01	ASSY, VACUUM BODY
500735-A	ASSY, VACUUM ROD
533829-01	ASSY, PAPER GUIDE BLOCK
534043-01	ASSY, GATE
534069-01	ASSY, FEED ROLLER BAR
502261A	ASSY, FEED ROLLER
536342-01	ASSY, EMBOSSED CARD HOPPER
535398-01	ASSY, EXTENDED SIDE GUIDE
534046-01	ASSY, STUD AND IDLER SPROCKET
110108A	ASSY, IDLER SPROCKET
535385-01	ASSY, STUD AND IDLER SPROCKET
534064-01	ASSY, TAKEUP
534034-01	ASSY, THROWOUT
534060-01	ASSY, HUB DISCONNECT
501374-12	ASSY, PROX RING W/ REFLECTOR
533849-01	ASSY, BEARING HUB
533891A-01	ASSY, IDLER ROLLER
534275-01	ASSY, TAKEUP
109386A	ASSY, IDLER PULLEY
534834-01	ASSY, COVER
535397-01	ASSY, COVER
535351-01	ASSY, TAKEUP #25 CHAIN
535350A	ASSY, BUSHING BAR
535352A-01	ASSY, STUD
110157A	ASSY, 25B24 IDLER
534075-01	ASSY, #25 CHAIN TAKEUP
535388-01	ASSY, CHAIN 11" SPACING
535388-05	ASSY, CHAIN 22" SPACING
535388-06	ASSY, CHAIN 5.5" SPACING
535389-01	ASSY, GEAR
SP44701A	ASSY, SLEEVE
536056-01	ASSY, RAIL ADJUSTMENT
536053-01	ASSY, SIDEGUIDE LH
536053-02	ASSY, SIDEGUIDE RH

535807-01	ASSY, SKID BAR
102233A	ASSY, CLAMP COLLAR
500801A	ASSY, LINK
535356-03	ASSY, PINCH ROLLER
500801A	ASSY, LINK
501057-A	ASSY, ROLLER

REV NO	DATE	DESCRIPTION	ECN NO	BY

SCALE 0.120

X XXX
REF'D WHERE USED

KIRK - RUDY, INC.
KENNESEE SAW, GEORGIA

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KENNESEE, GA 3044 USA

THIRD ANGLE PROJECTION

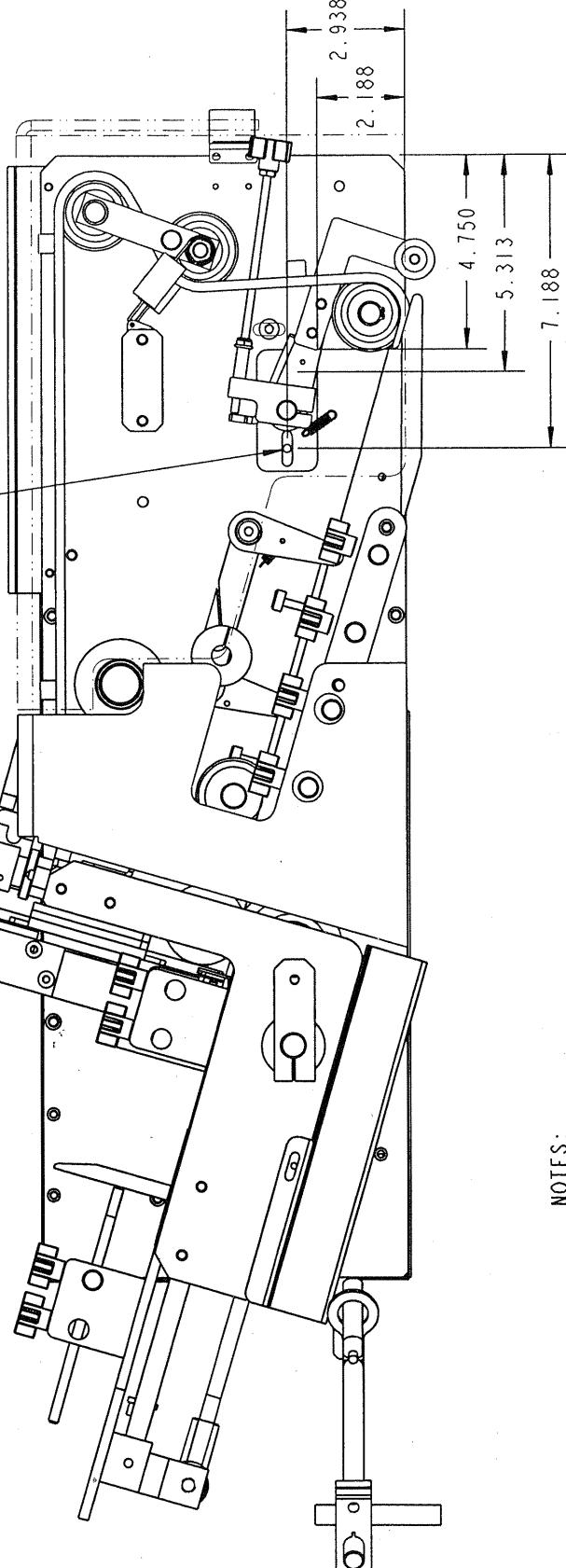
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CHECKED BY: FINISH: XXX

TRACED BY: MASTER NOTES: XXX

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1/4-20 TAPPED HOLE
2-PLCS

NOTES:

1. USE FOR INSTALLING PINCH ROLLER ASSEMBLY 535356-04.
2. ADD TWO 1/4-20 TAPPED AS SHOWN.

X	XXX
RECD	WHERE USED

KIRK - RUDY, INC.
KENNESAW, GEORGIA

ASSY - CHAIN REGISTER ATTACHER

SP66600-3

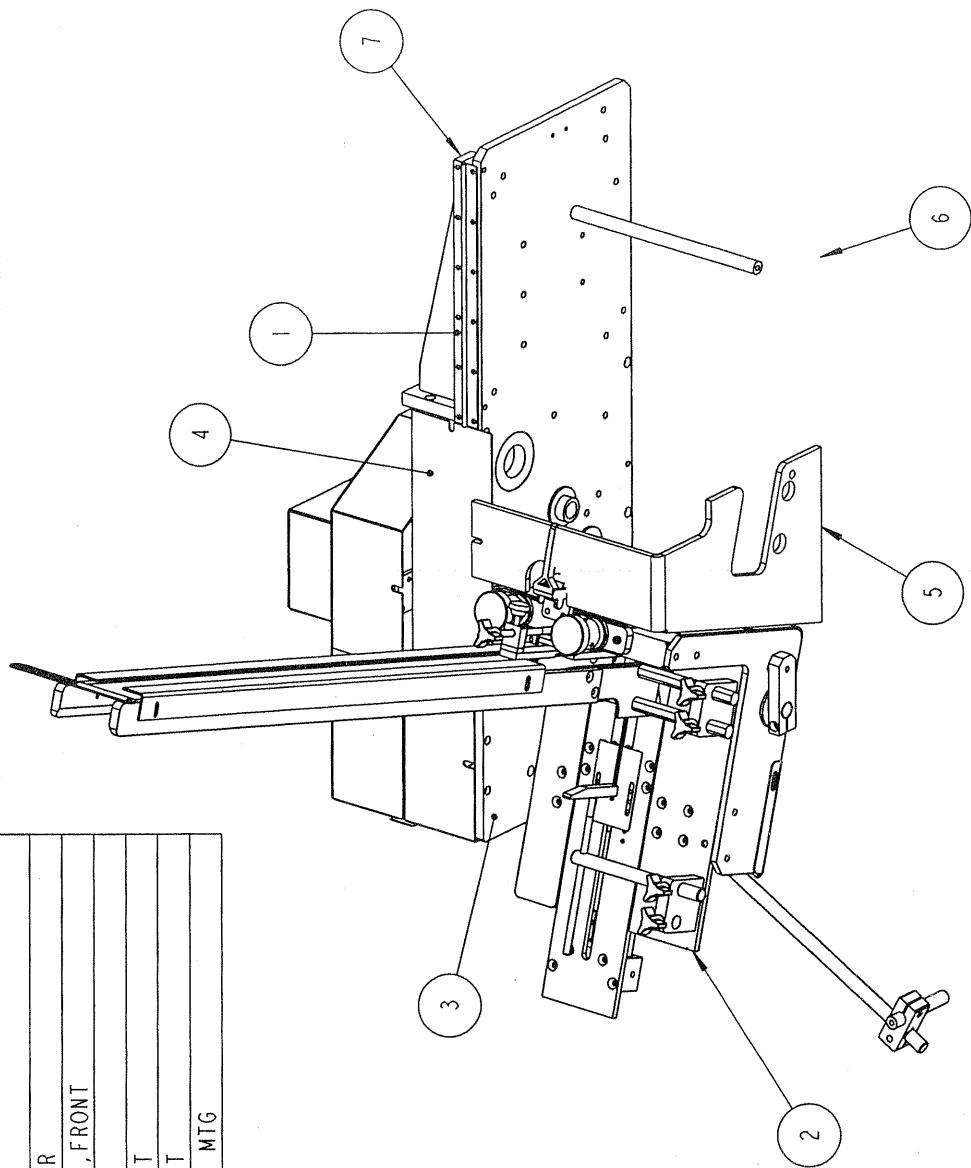
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TO DIMENSIONS ONLY

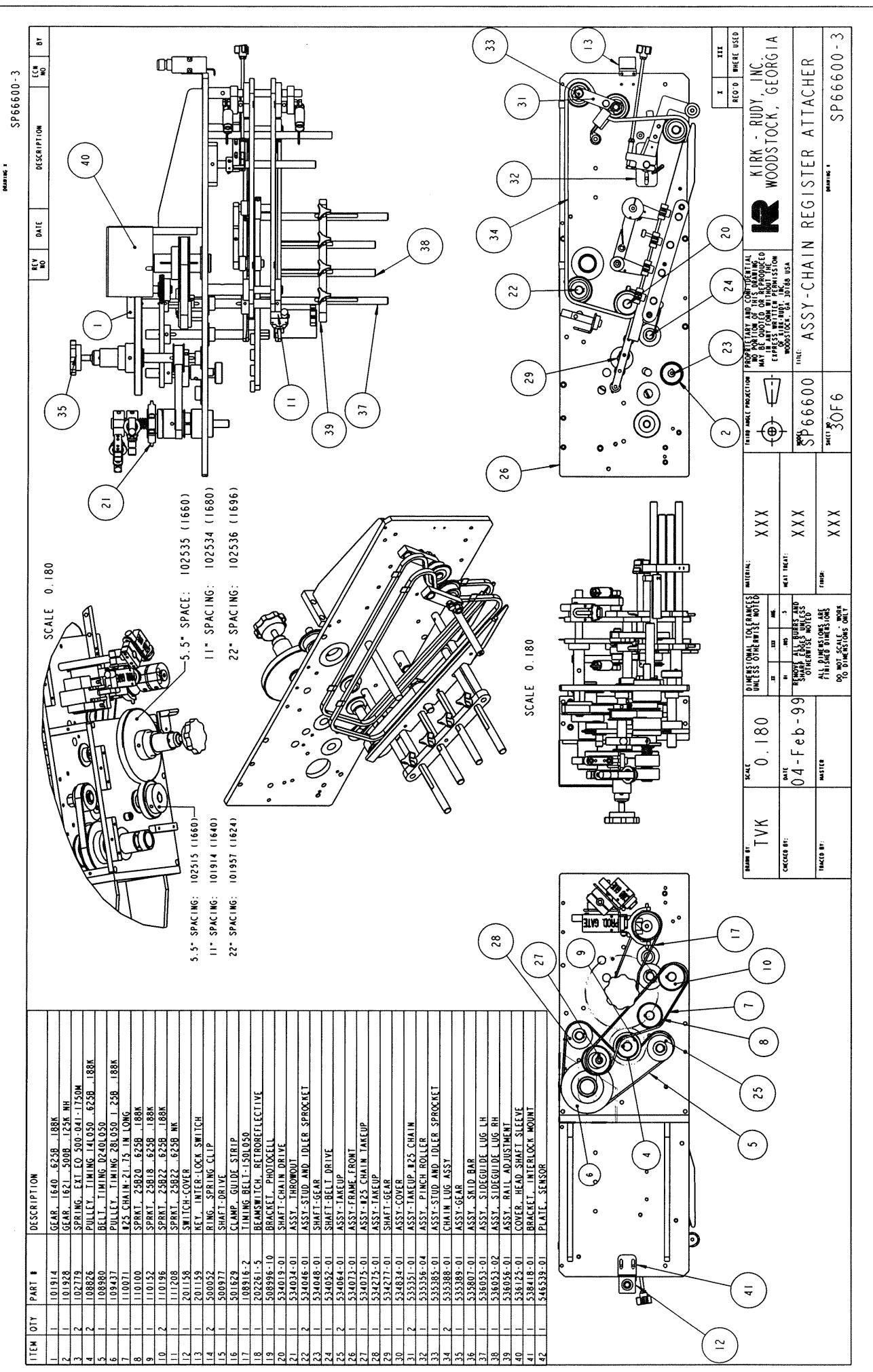
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SP66600-3

ITEM QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	1	190724-2 ALUM HINGE					
2	1	534030-01 ASSY - FEEDER					
3	1	534073-01 ASSY - FRAME, FRONT					
4	1	534834-01 ASSY - COVER					
5	1	534836-01 COVER - FRONT					
6	1	534837-01 COVER - FRONT					
7	1	534839-01 BAR - COVER MTG					



DRAWN BY:	SCALE	0 . 156	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED				X X X	THIRD ANGLE PROJECTION	PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE QUOTED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC. KENNESAW, GA 3044 USA
CHECKED BY:	DATE	23-Feb-99	.xx	.xxx	.005	.5	HEAT TREAT:	X X X	MODEL:
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									SP66600-3



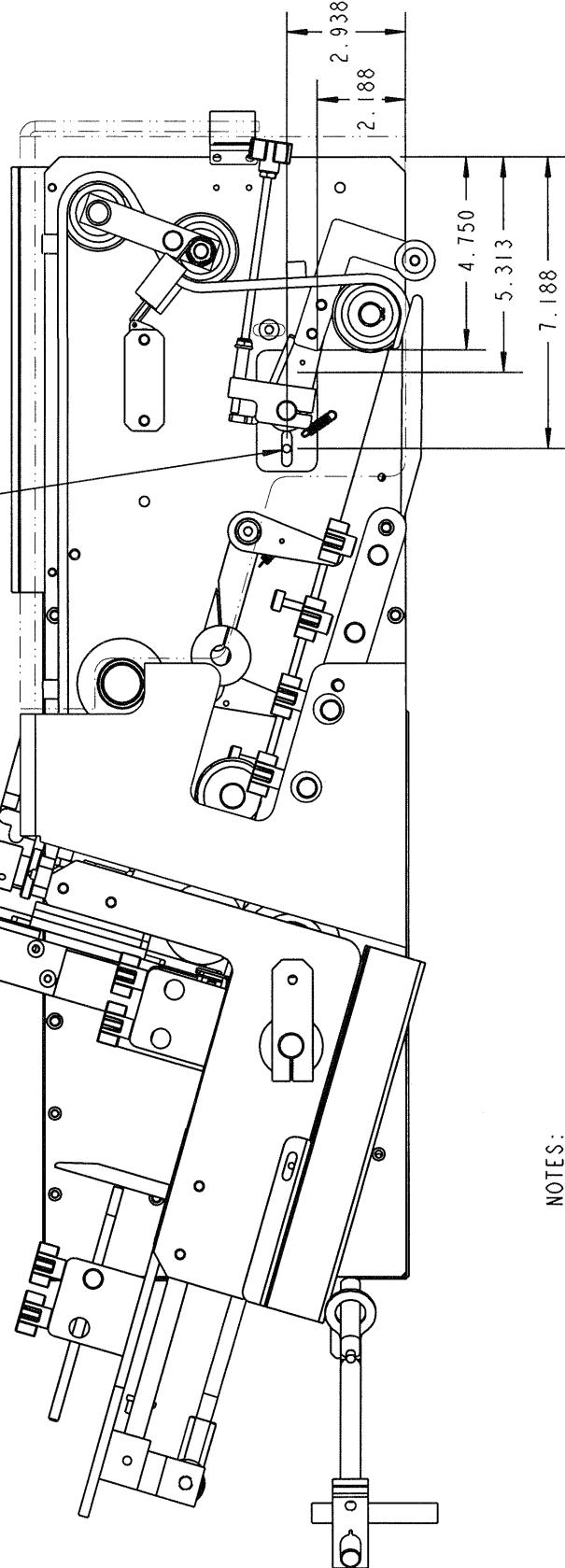
ITEM QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	2	102779	SPRING, EXT EO 500-041-1750M				
2	1	201158	SWITCH-COVER				
3	1	201159	KEY, INTER-LOCK SWITCH				
4	2	500052	RING, SPRING CLIP				
5	1	501629	CLAMP, GUIDE STRIP				
6	1	190724-2	ALUM HINGE				
7	1	202261-5	BEAMSWITCH, RETROREFLECTIVE				
8	1	508996-10	BRACKET, PHOTOCELL				
9	1	533891A-01	ASSY-IDLER ROLLER				
10	1	533919-01	BAR-SUPPORT				
11	4	533929-01	BAR-SPACER				
12	1	534031-01	ASSY-FRAME PLATE				
13	1	534034-01	ASSY, THROWOUT				
14	2	534054-01	BAR-COVER MTG				
15	1	534073-01	ASSY-FRAME, FRONT				
16	1	534839-01	BAR-COVER MTG				
17	1	534840-01	BAR-SPACER, FRAME				
18	2	535353-01	SHAFT, SPACER SPRING MNT.				
19	1	535354-01	BAR-SUPPORT				
20	1	535356-04	ASSY, PINCH ROLLER				
21	1	535807-01	ASSY, SKID BAR				
22	1	536053-01	ASSY, SIDEGUIDE LUG LH				
23	1	536053-02	ASSY, SIDEGUIDE LUG RH				
24	1	536056-01	ASSY, RAIL ADJUSTMENT				
25	1	536125-01	COVER, HEAD SHAFT SLEEVE				
26	1	538418-01	BRACKET, INTERLOCK MOUNT				
27	1	546539-01	PLATE, SENSOR				

X XXX
RECD WHERE USED

DRAWN BY:	SCALE	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED		MATERIAL:	THIRD ANGLE PROJECTION		PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE QUOTED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC. KENNESAW, GA 30144 USA
CHECKED BY:	DATE	.xx	.xxx	ANG.		MODEL:	KIRK - RUDY, INC. KENNESAW, GEORGIA
TRACED BY:	MASTER	.01 .005 .5		HEAT TREAT:	SP66600	SHEET NO:	DRAWING 1
		REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED		FINISH:	XXX	40F6	SP66600-3
		ALL DIMENSIONS ARE FINISHED DIMENSIONS		DO NOT SCALE - WORK TO DIMENSIONS ONLY			

REV NO	DATE	DESCRIPTION	ECN NO	BY
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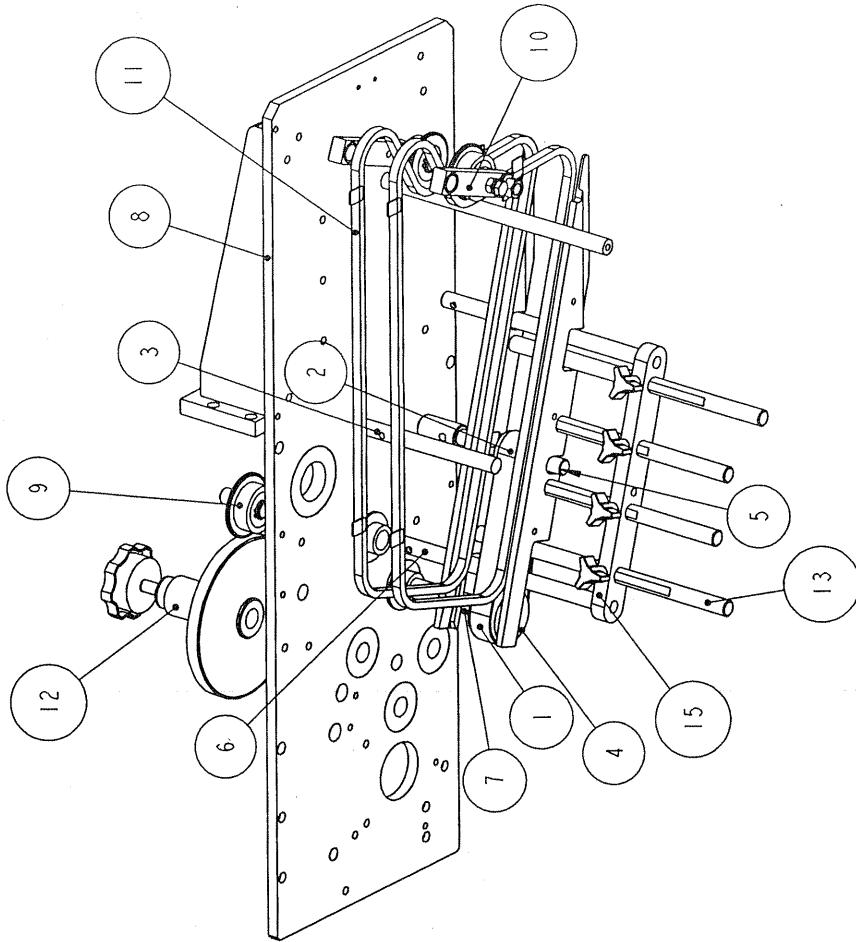
1/4-20 TAPPED HOLE
2-PLCS



NOTES:
1. USE FOR INSTALLING PINCH ROLLER ASSEMBLY 535356-04.
2. ADD TWO 1/4-20 TAPPED AS SHOWN.

DRAWN BY:	TVK	SCALE	0 .250	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED			MATERIAL:	X X X	THIRD ANGLE PROJECTION	KIRK - RUDY INC.
CHECKED BY:		DATE	19 - May - 05	.01	.005	.5	HEAT TREAT:	X X X		KENNESAW, GEORGIA
TRACED BY:		MASTER		REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED			FINISH:	X X X	SP 66600	ASSY - CHAIN REGISTER ATTACHER
				ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE WORK TO DIMENSIONS ONLY			SHEET NO:	20F7	DRAWING #	SP 66600-3
							REF'D:	X XXX	WHERE USED	

ITEM QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	106287	BELT-3/4 X 14					
2	533891A-01	ASSY-IDLER ROLLER					
3	533915-01	STUD-SKID BAR					
4	533958-01	ROLLER-BELT DRIVE					
5	534050-01	STUD-RAIL					
6	534051-01	STUD-RAIL					
7	534052-01	SHAFT-BELT DRIVE					
8	534073-01	ASSY-FRAME, FRONT					
9	534075-01	ASSY-#25 CHAIN TAKEUP					
10	535351-01	ASSY-TAKEUP, #25 CHAIN					
11	535388-01	CHAIN LUG ASSY					
12	535389-01	ASSY-GEAR					
13	536053-01	ASSY, SIDEGUIDE LUG LH					
14	536053-02	ASSY, SIDEGUIDE LUG RH					
15	536056-01	ASSY, RAIL ADJUSTMENT					



DRAWN BY:	TVK	SCALE	0 . 188	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	MATERIAL: XX - XXX ANG. .01 .005 .5	HEAT TREAT: XXX	THIRD ANGLE PROJECTION	KIRK - RUDY, INC. KENNESAW, GEORGIA
CHECKED BY:		DATE	23-Feb-99	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED	FINISH: XXXX	FINISH: XXXX	MODEL: SP66600	NAME: ASSY-CHAIN REGISTER ATTACHER
TRACED BY:		MASTER	M	ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY			SHEET NO: 50F 6	DRAWING #: SP 66600 - 3

ITEM	QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	1	103120	BEARING, FLAT 1.250					
2	4	103804	BEARING, HUB .625					
3	1	534032-01	PLATE-FRAME, BACK					
4	3	534054-01	BAR - COVER MITG					

4

2

3

1

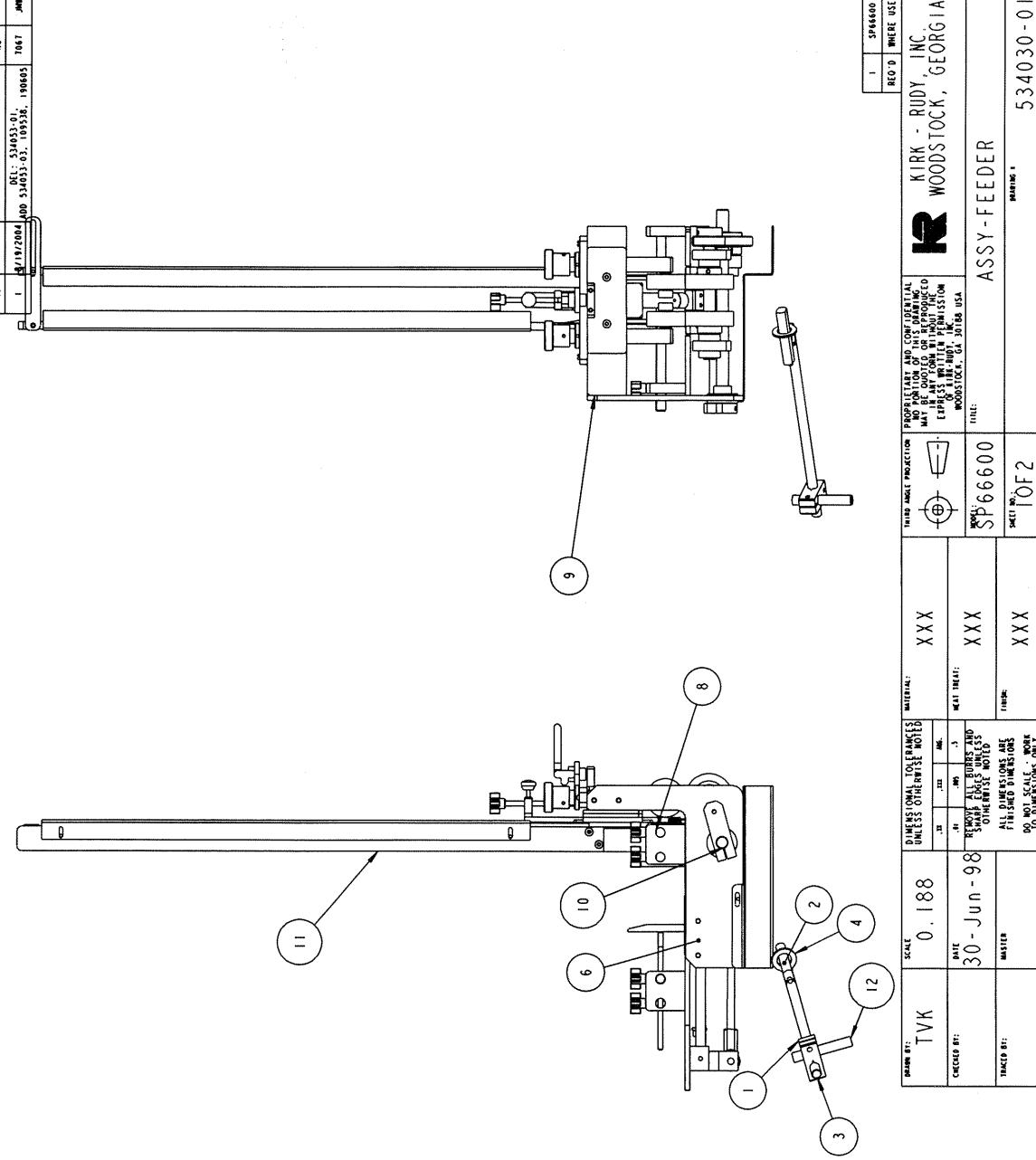
DRAWN BY:	TVK		
SCALE:	0 . 250		
DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	X X X		
.xx	.xxx	.005	.5
DATE:	24 - Feb - 99		
CHECKED BY:			
TRACED BY:	MASTER		

MATERIAL:	X X X
HEAT TREAT:	X X X
FINISH:	X X X
REMOVED ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED	ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY

THIRD ANGLE PROJECTION	PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE QUOTED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC. KENNESAW, GA 30144 USA
MODEL:	SP 66600
SHEET NO:	10F1
TITLE: ASSY - FRAME PLATE	
DRAWING # 534031-01	

REQ'D WHERE USED	I SP 66600
------------------	------------

ITEM QTY	PART #	DESCRIPTION
1	1	508953 CLAMP
2	1	202253-1 SENSOR, EATON CUTLER-HAMMER 1410280003
3	1	508955-3 SHAFT, PHOTOCELL MOUNT
4	1	508956-6 PHOTOCELL BRACKET, 90 DEG
5	1	534023-01 ASSY, VACUUM FEEDER
6	1	534035A-01 ASSY, SIDE PLATE
7	1	534053-03 GUARD, FEEDER UNDERSIDE
8	1	534067-01 BLOCK, PAPER GUIDE
9	1	534068-01 ASSY, BRIDGE
10	1	534071-01 LOWER FEED ROLLER ASSY
11	1	535338-01 ASSY, EXTENDED SIDE GUIDE
12	1	SP52707 SHAFT, SPACER



Sheet No. 1

534030-01

REV. NO. DATE DESCRIPTION ECR NO. BY

1 3/19/2001 000 534030-01, 109538, 109605 7067 JMW

REF. NO. WHERE USED
1 SP46600KIRK-RUDY INC.
WOODSTOCK, GEORGIAASSY - FEEDER
MATERIALS:

DRAWING NO. OR REFERENCE		MATERIAL		REVISIONS	
SCALE:	0.188	INCHES OR MILLIMETERS	XXX	DATE:	SP 66600
CHECKED BY:	30-Jun-98	INCHES	XXX	MAILED:	SP 66600
TRACED BY:	MASTER	MILLIMETERS	XXX	TIME:	10F2

534030-01

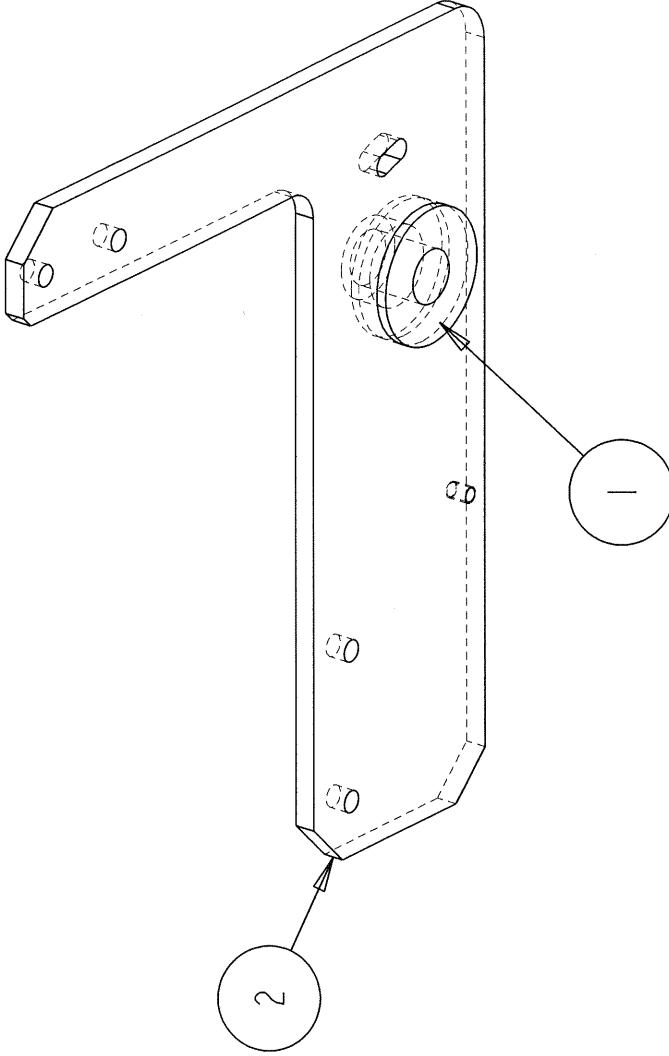
ITEM	QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	1	502229	LEVER, FEEDER CRANK	1	17 JAN 2005	502281-2 WAS 502230, 502236 WAS 502296-1, ADDED 544628-01		JMW
2	1	502231	SHAFT					
3	1	502249	SHAFT					
4	2	502296	SHAFT, FEEDER					
5	1	500735-A	ASSY, VACUUM ROD					
6	1	502217-1	PLATE, TOP CENTER 6 & 9 IN. DES.					
7	1	502881-2	PUSHER, SUPPORT CREDIT CARD					
8	2	533829-01	ASSY, PAPER GUIDE BLOCK					
9	1	534024-01	PLATE - TOP					
10	1	534025-01	ASSY, FEEDER LEVER					
11	1	534026-01	PLATE - TOP					
12	1	534097-01	BAR-SHUTTLE MOUNT					
13	1	535403-01	ASSY - VACUUM BODY, LIN					
14	1	535405-01	ASSY, GUIDE					
15	1	544628-01	PLATE, PUSHER					

1 SP66600
REO'D WHERE USED

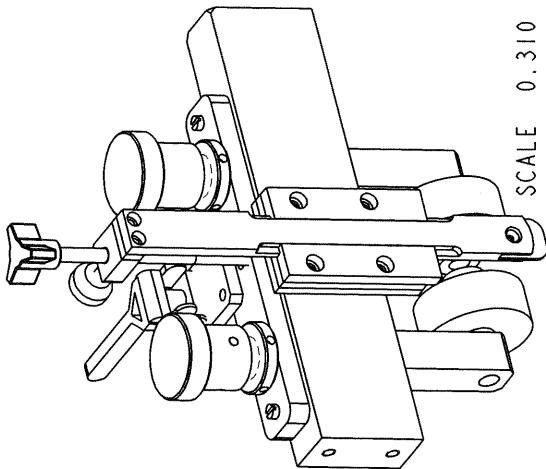
DRAWN BY: TVK	SCALE: 0 . 350	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED			MATERIAL: N / A	THIRD ANGLE PROJECTION [Diagram]	PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE COPIED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC. KENNESAW, GA 3044 USA	
CHECKED BY:	DATE: 13-JUL-98	.xx	.xxx	.005	HEAT TREAT: N / A	MODEL: SP 66600	TITLE: ASSY, VACUUM FEEDER	
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: 10F	DRAWING #: 534023-01		

ITEM QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	103804	BEARING, HUB .625					
2	534035-01	PLATE - SIDE BEARING					

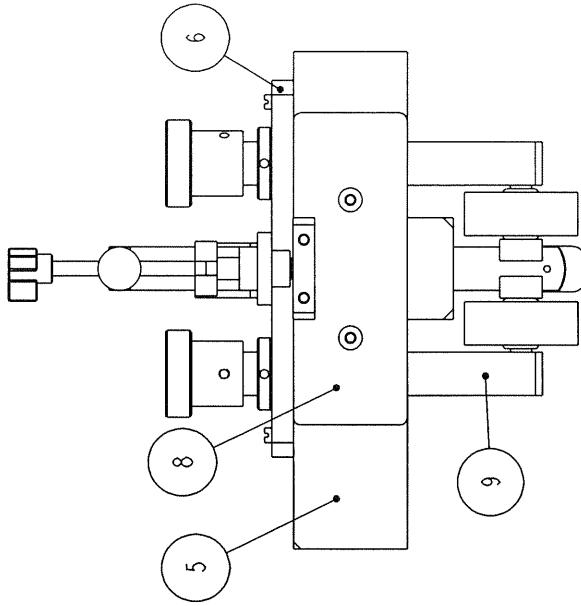
DRAWN BY: TVK	SCALE 0 . 500	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED		MATERIAL: XXX		THIRD ANGLE PROJECTION	PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE QUOTED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY INC. KENNESAW, GA 30144 USA
CHECKED BY:	DATE 24-Feb-99	.xx	.xxx	.005	.5	HEAT TREAT: XXX	KR KIRK - RUDY, INC. KENNESAW, GEORGIA
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		MODEL: SP 66600	TITLE: ASSY - SIDE PLATE
						SHEET NO: 10F1	DRAWING #: 534035A-01



ITEM	QTY	PART #	DESCRIPTION
1	1	190733	CLAMP, QUICK RELEASE
2	2	500799-6	STUD, BRIDGE (LONG)
3	1	530888-01	BLOCK, QUICK RELEASE
4	1	530889-01	PLATE, QUICK RELEASE
5	1	534039-01	BAR, BRIDGE
6	1	534040-01	PLATE, QUICK RELEASE
7	1	534043-01	ASSY-GATE
8	1	534045-01	PLATE-FRONT BRIDGE
9	2	534069-01	ASSY-FEED ROLLER, BAR
10	1	534279-01	PLATE-SPACER

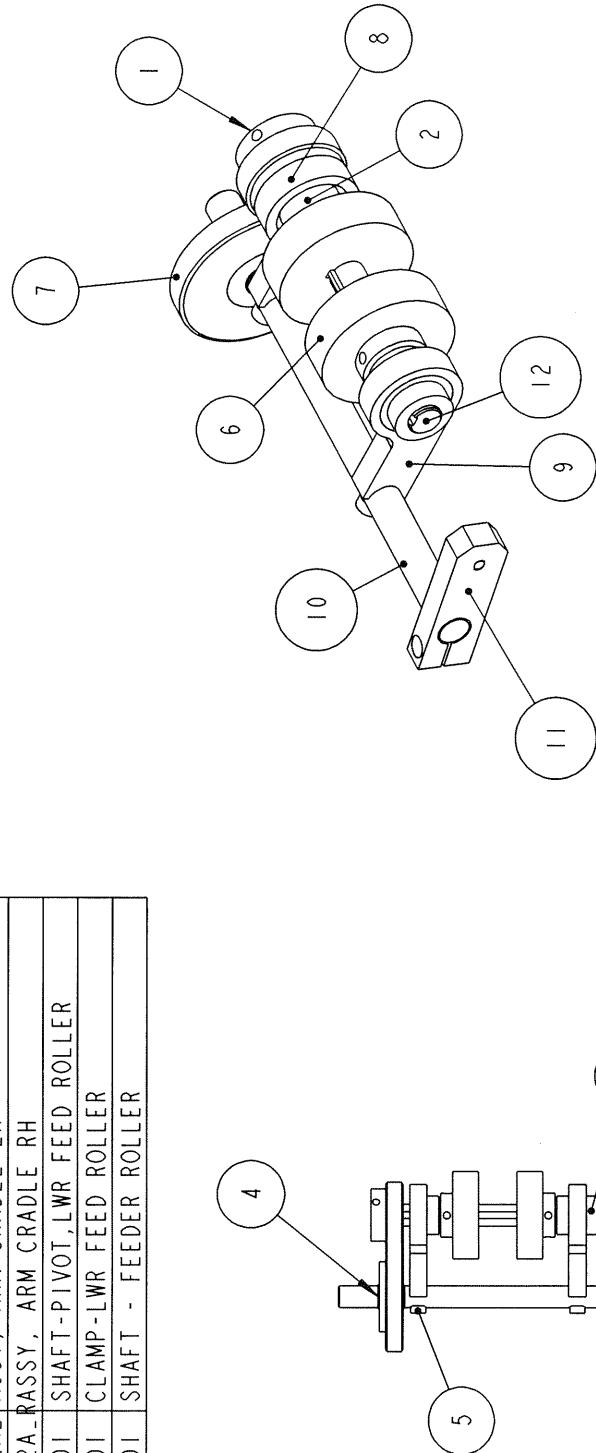


SCALE 0.310



DRAWN BY:	SCALE	MATERIAL:	THIRD ANGLE PROJECTION	PROPRIETARY AND CONFIDENTIAL
TVK	0 . 310	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	X X X	NO PORTION OF THIS DRAWING MAY BE COPIED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC. KENNESAW, GA 3044 USA
CHECKED BY:	DATE	.XX .XXX ANG.	X X X	KIRK - RUDY, INC. KENNESAW, GEORGIA
TRACED BY:	MASTER	.01 .005 .5	FINISH:	ASSY-BRIDGE
	30 - JUN - 98	REMOVE ALL BURS AND SHARP EDGES UNLESS OTHERWISE NOTED ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY	SHEET NO.: 0F1	DRAWING # 534068-01
			MODEL: SP 66600	TITLE:
			REO'D WHERE USED	SP 66600
			I	SP 66600

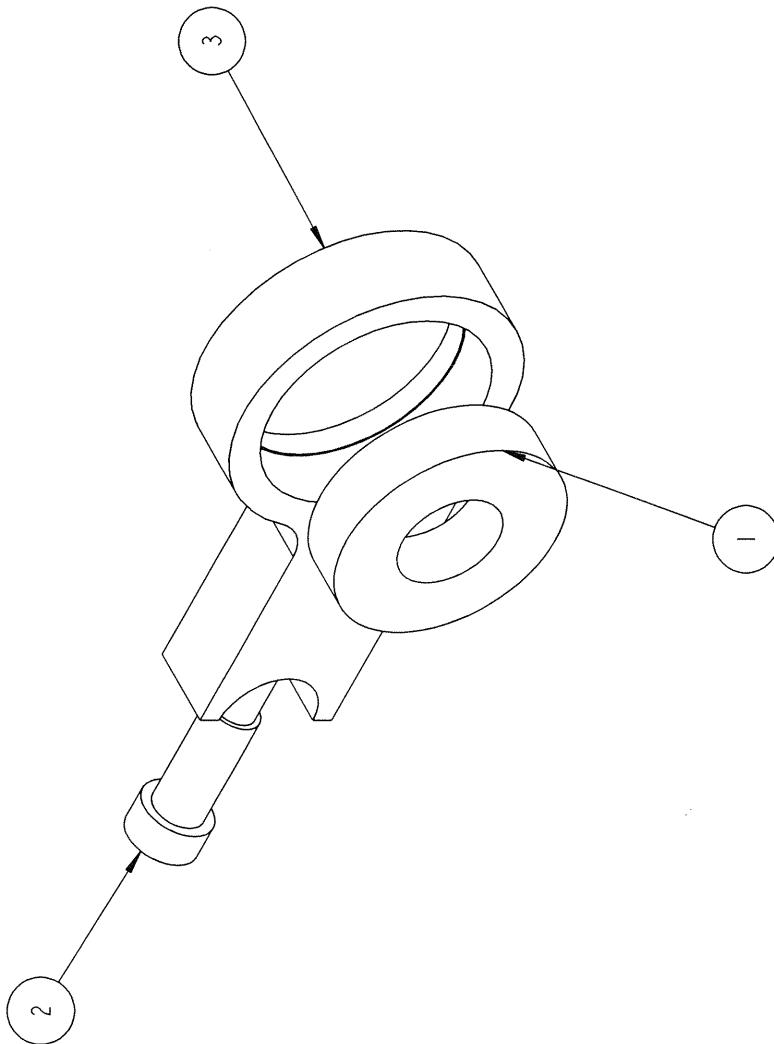
ITEM	QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	1	101916	GEAR, 1628 .625B .188K					
2	2	102201	COLLAR .625					
3	1	102221	COLLAR .625					
4	2	104104	SNAPRING, .625					
5	2	107102	BOLT, SHOULDER 5/16X1/2					
6	2	503656	ROLLER, BOTTOM FEED					
7	1	101944A	ASSY - IDLER GEAR					
8	1	500729-2AL	ASSY, ARM CRADLE LH					
9	1	500729-2A-RASSY	ARM CRADLE RH					
10	1	534029-01	SHAFT-PIVOT,LWR FEED ROLLER					
11	1	534056-01	CLAMP-LWR FEED ROLLER					
12	1	534072-01	SHAFT - FEEDER ROLLER					



SCALE 0.188

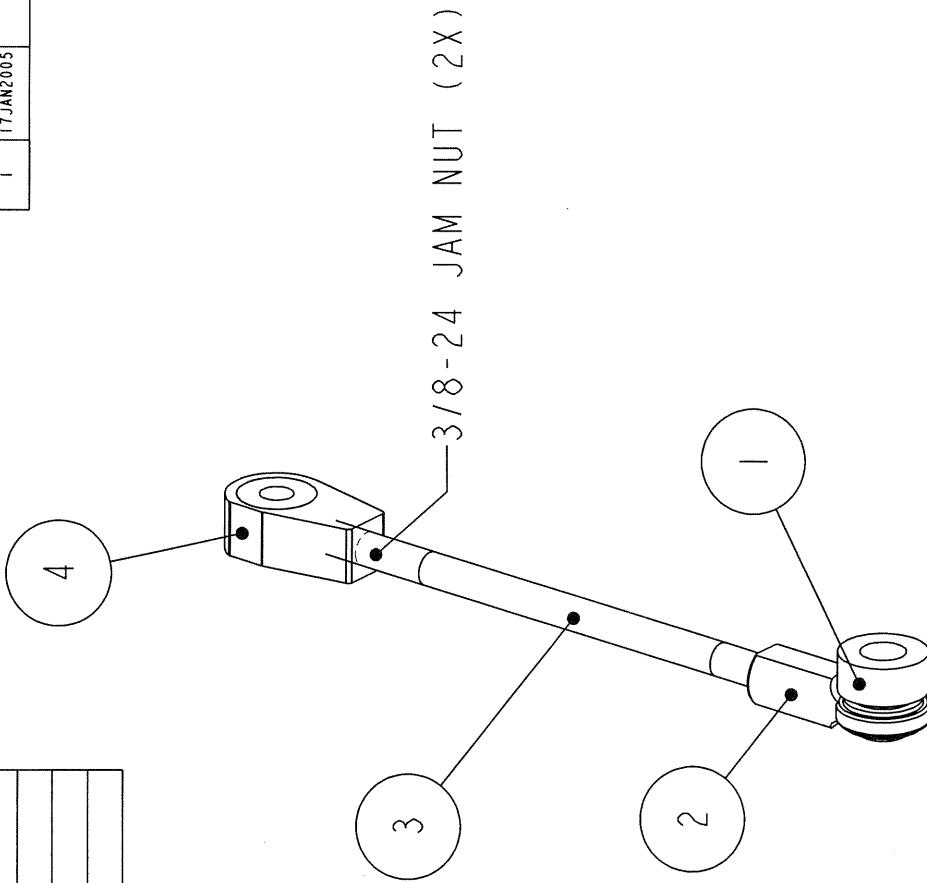
DRAWN BY: TVK	SCALE 0 . 3 3	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED		MATERIAL: XX	THIRD ANGLE PROJECTION		PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE COPIED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY INC. KENNESAW, GA 30144, USA	
CHECKED BY:	DATE 16 - Sep - 98	.xx	.005	.01	.005	.5	HEAT TREAT: XX	MODEL: XXX
TRACED BY:	MASTER	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED		ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY		SHEET NO. 10F	TITLE: LOWER FEED ROLLER ASY	
							DRAWING #	
							534071-01	
							SP66600	
							REQ'D WHERE USED	
							1	

ITEM	QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	1	103110	BEARING, FLAT .625					
2	1	107104	BOLT, SHOULDER 5/16X3/4					
3	1	500729-2	ARM, CRADLE FEEDER					



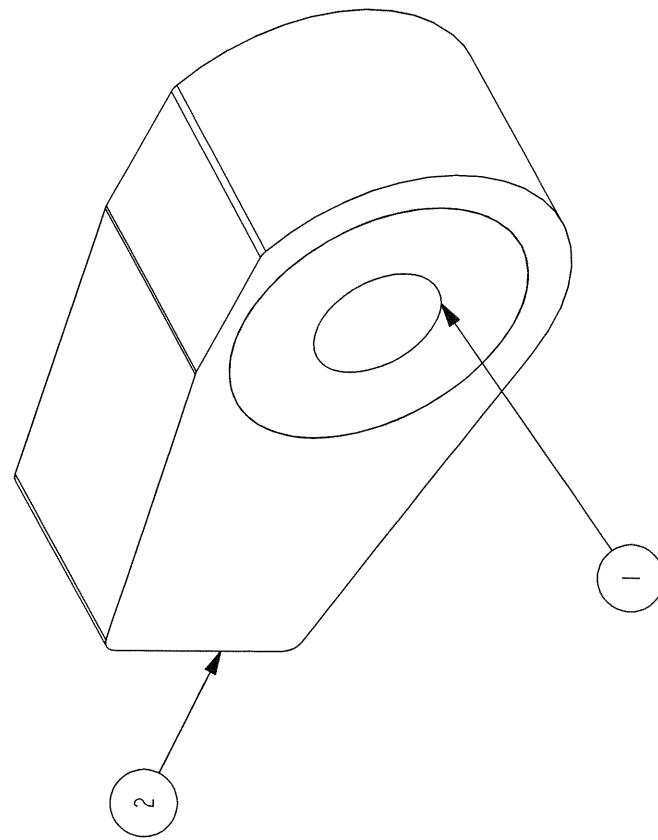
DRAWN BY: TJG	SCALE 1 . 000	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED		MATERIAL: NOTED	THIRD ANGLE PROJECTION		PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE QUOTED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC. KENNESAW, GA 30144 USA	
CHECKED BY:	DATE 21 - Jan - 98	.xx	.xxx	HEAT TREAT: NONE			KIRK - RUDY, INC. KENNESAW, GEORGIA	
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	MODEL: 324	SHEET NO: OF 1	TITLE: ASSY, ARM CRADLE FEEDER	
							DRAWING # 500729-2A	

ITEM	QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	1	102205	COLLAR .500	1	17JAN2005	500749-2 WAS 500749	7145	JMW
2	1	103500	BEARING - ROD END					
3	1	500749-2	ROD - FEEDER SLIDE					
4	1	500751A	ASSY, BEARING BLOCK					



1	SP66600
REV'D	WHERE USED
1	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	
THIRD ANGLE PROJECTION	486LR
MATERIAL: N/A	MODEL: 486LR
DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	TITLE: ASSY, FEEDER LEVER
.XX .XXX .005 .5 ANG.	DRAWING #
DATE 24-FEB-99	SHEET NO: 0F1
CHECKED BY:	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED
TRACED BY:	ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY

ITEM QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	2	103106 BEARING, FLAT .375					
2	1	500751 YOKE - FEEDER CRANK					

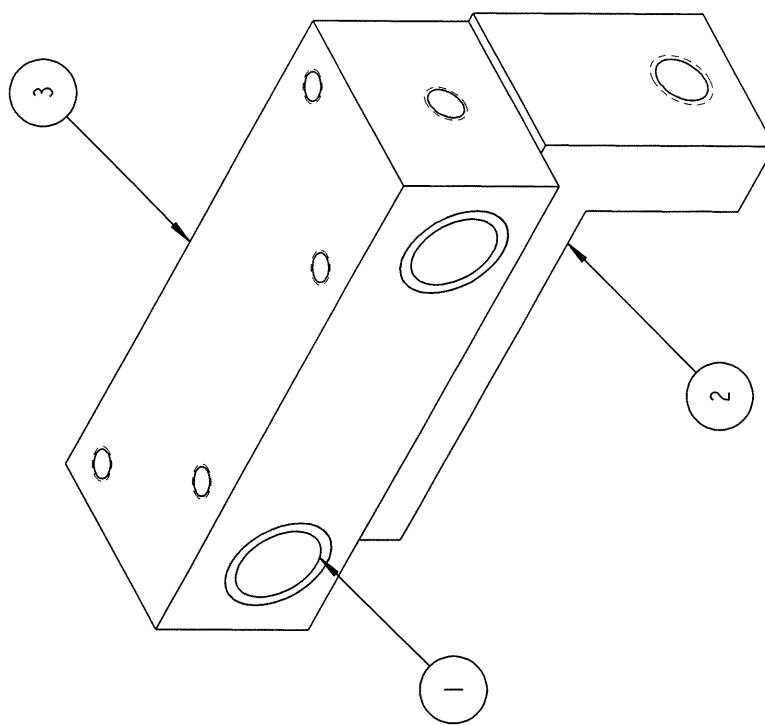


DRAWN BY:	MY	SCALE:	2 . 000	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	MATERIAL: N / A	THIRD ANGLE PROJECTION	PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE QUOTED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC. KENNESAW, GA 30144, USA
DATE:	09-Apr-99	.xx	.xxx	ANG.	.01	.005	HEAT TREAT: N / A
CHECKED BY:		REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED				MODEL: 215	TITLE: ASSY, BEARING BLOCK
TRACED BY:	MASTER	ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY				SHEET NO: OF 1	DRAWING # 500751A

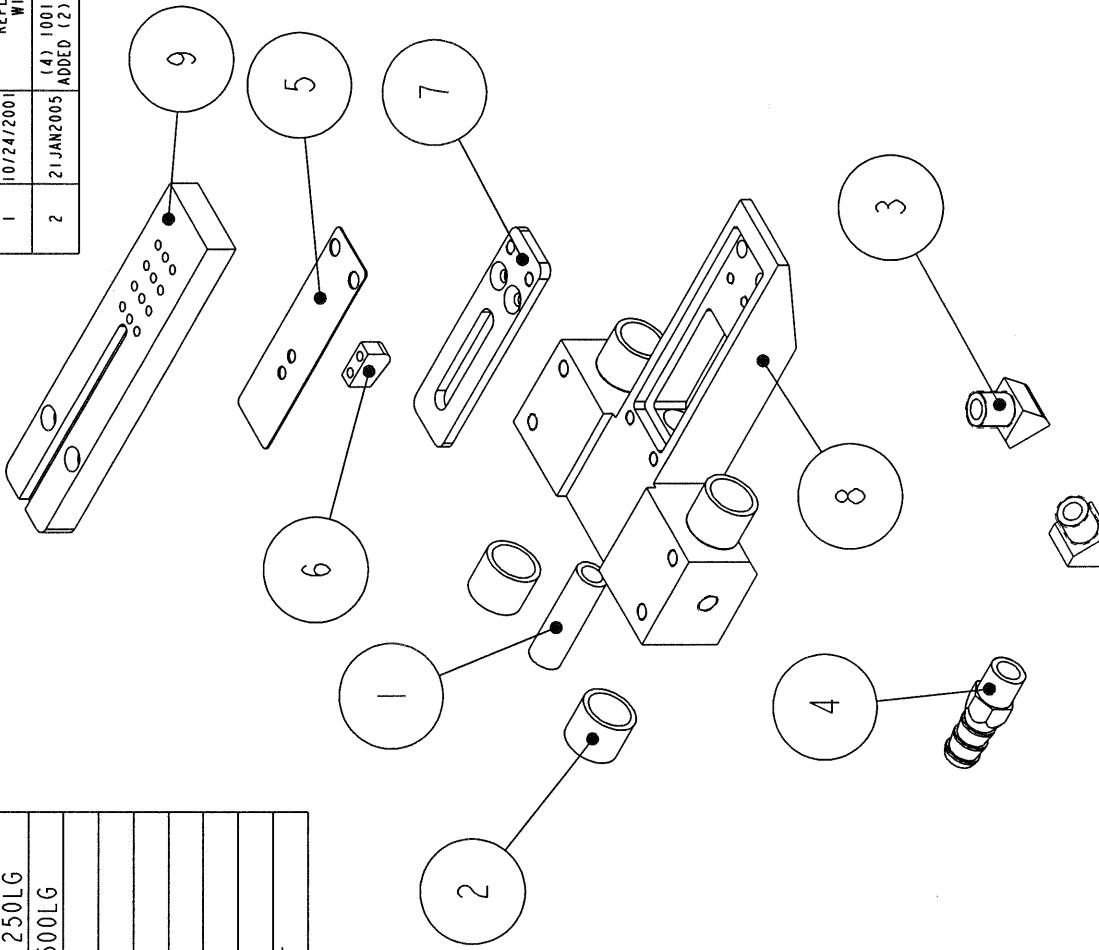
ITEM	QTY	PART #	DESCRIPTION
1	4	100135	BUSHING, SL.500 ID.625 OD.500 LG
2	1	502171	BRACKET, FEEDER
3	1	502227-1	BLOCK-BUSHING

REV NO	DATE	DESCRIPTION	ECN NO	BY
1	1/21/05	110135 WAS 190639	7154	JNW

1	SP66600
REQ'D	WHERE USED
 KIRK - RUDY, INC.  KENNESAW, GEORGIA	
PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE COPIED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC. KENNESAW, GA 30144 USA	
THIRD ANGLE PROJECTION	
	
MATERIAL:	N/A
DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	
.XX	.XXX
DATE	HEAT TREAT:
24-Feb-99	N/A
CHECKED BY:	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED
MASTER	ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY
TRACED BY:	FINISH:
	N/A
SHEET NO:	OF 1
TITLE: ASSY, GUIDE	
DRAWING #: 535405-01	



ITEM	QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	1	100131	BUSHING, SL.250ID.375OD.1.250LG	1	10/24/2001	REPLACED 502211-1 WITH 502211-12		TJG
2	4	100135	BUSHING, SL.500ID.625OD.500LG	2	21 JAN 2005	(4) 100135 WAS (2) 100147, ADDED (2) 109338. (11) 190605		JMW
3	2	109538	45 DEGREE FITTING					
4	1	190605	NIPPLE, VACUUM LINE					
5	1	500738	SPRING - VALVE					
6	1	500739	BLOCK - PUSHER					
7	1	502298	PLATE, VACUUM (1 INCH)					
8	1	502210-3	BLOCK-VACUUM VALVE, 1 IN					
9	1	502211-12	PLATE, VACUUM FEEDER FLAT					

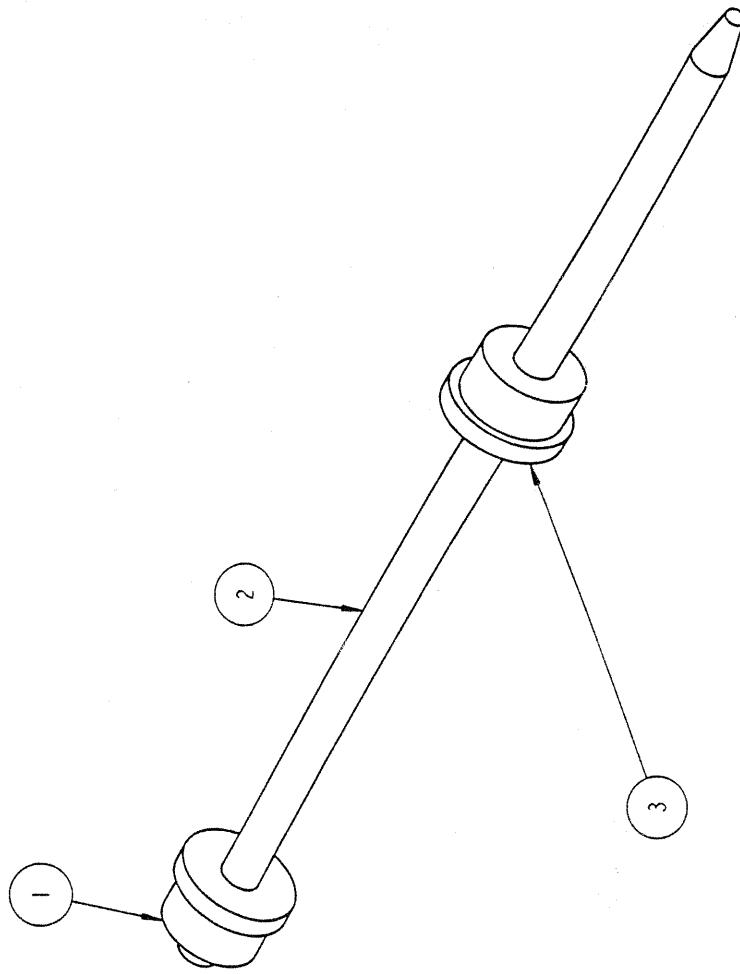


1	SP66600
REQ'D	WHERE USED

DRAWN BY: TVK	SCALE: 0 . 500	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED		MATERIAL: XXX	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
CHECKED BY:	DATE: 24-Feb-99	.01	.005	HEAT TREAT: XXX	MODEL: SP66600
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	SHEET NO: OF 1
					DRAWING #: ASSY - VACUUM BODY, IN

535403-01

ITEM	QTY	PART #	DESCRIPTION
1	2	102225	COLLAR .250
2	1	500735	ROD - PUSH
3	2	500737	WASHER - BUMPER



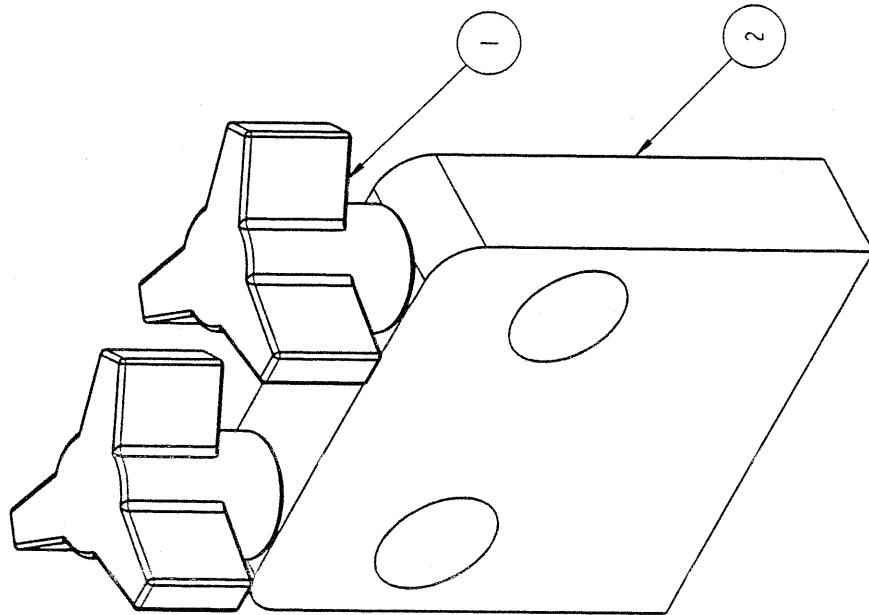
REV NO	DATE	DESCRIPTION	ECN NO	BY

1	532689-01
REF'D	WHERE USED
KR	KIRK - RUDY, INC. KENNESAW, GEORGIA
324	ASSY, VACUUM ROD
OF 1	DRAWING # 500735-A

DRAWN BY:	SCALE	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	MATERIAL: NOTED	THIRD ANGLE PROJECTION	PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE QUOTED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC. KENNESAW, GA. 30144 USA		
					.01	.005	.5
CHECKED BY:	DATE	AMG.	HEAT TREAT:	Model:	324	Title:	
	19-Jan-98		NONE			ASSY, VACUUM ROD	
TRACED BY:	MASTER		FINISH.	SHEET NO.	1	DRAWING #	
			REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED			500735-A	
			ALL DIMENSIONS ARE FINISHED DIMENSIONS				
			DO NOT SCALE - WORK TO DIMENSIONS ONLY				

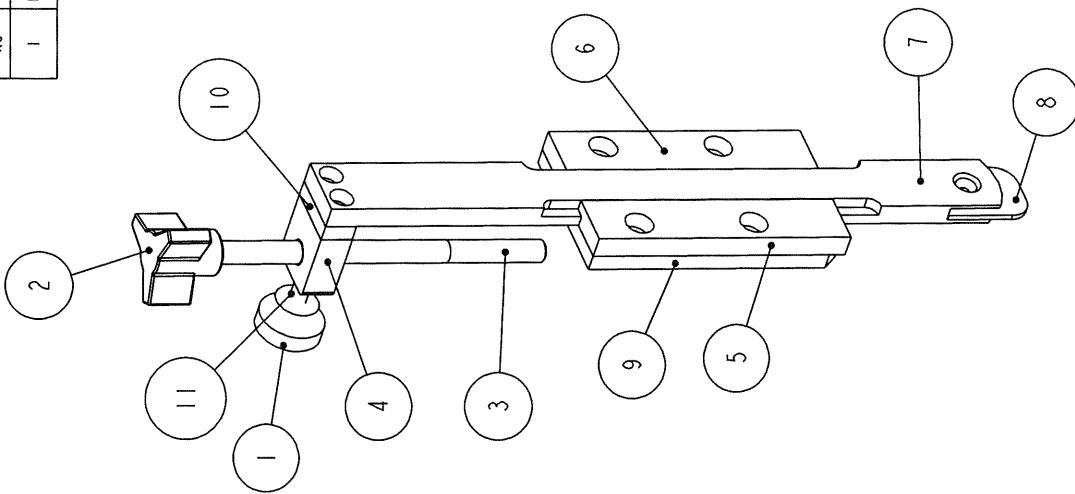
ITEM	QTY	PART #	DESCRIPTION
1	2	102117	KNOB
2	1	502172	BLOCK, PAPER GUIDE

REV NO	DATE	DESCRIPTION	ECN NO	BY
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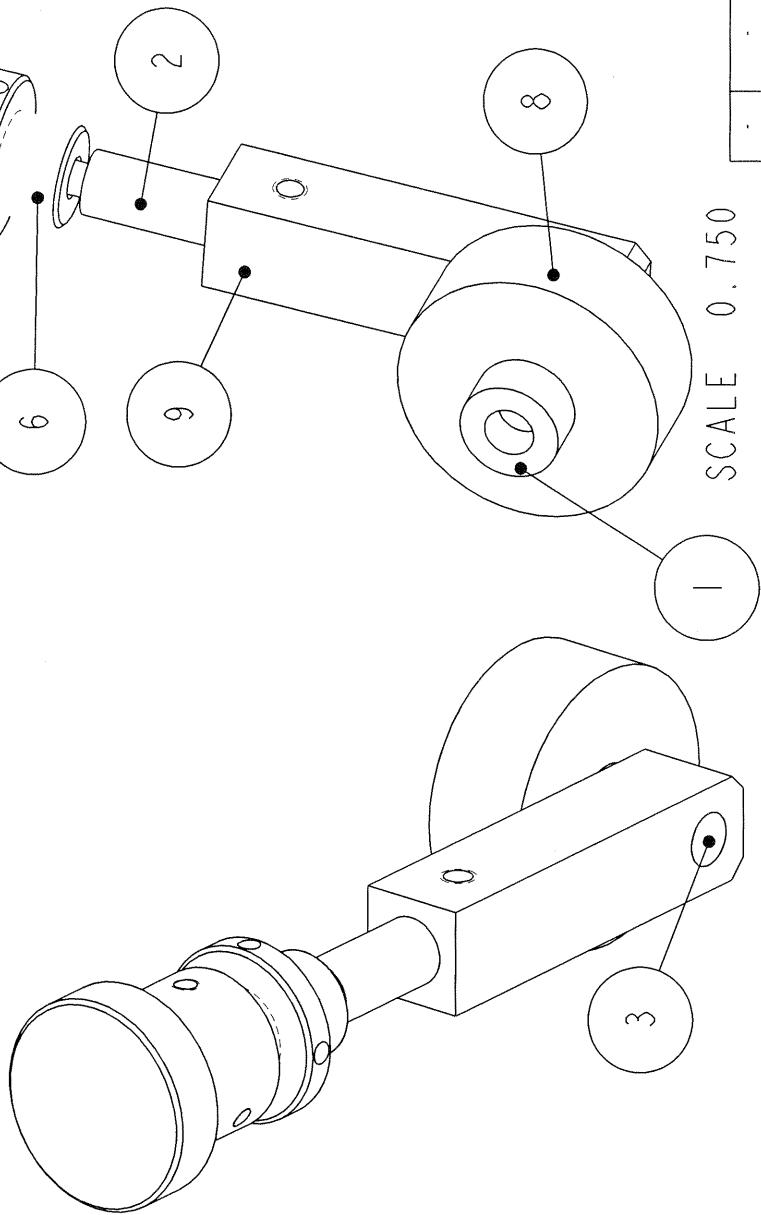
DRAWN BY:	SCALE	MATERIAL:	PROPRIETARY AND CONFIDENTIAL NO PARTITION OF THIS DRAWING MAY BE COPIED OR REPRODUCED IN ANY FORM, WHETHER EXPRESSED OR IMPLIED, WITHOUT PERMISSION OF KIRK-RUDY INC. KENNESAW, GA 3044 USA.
MY	.500	N/A	
CHECKED BY:	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	HEAT TREAT:	ASSY, PAPER GUIDE BLOCK
	.005 .01 .005 .005	N/A	DRAWING #
DATE	26 - May - 98	MODEL:	203
TRACED BY:	MASTER	FINISH:	SHEET NO.
		ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY	

ITEM	QTY	PART #	DESCRIPTION
1	1	02114	KNOB
2	1	02119	KNOB
3	1	502170	SHAFT, GATE ADJUSTING
4	1	502232	BLOCK, GATE BLADE
5	1	502233-L	GIB
6	1	502233-R	GIB
7	1	502234-1	BLADE, GATE
8	1	502234-T	RUBBER TIP
9	1	534279-01	PLATE SPACER
10	1	534280-01	PLATE-SPACER
11	1	SYA094	SCREW, SET 10-32X.750



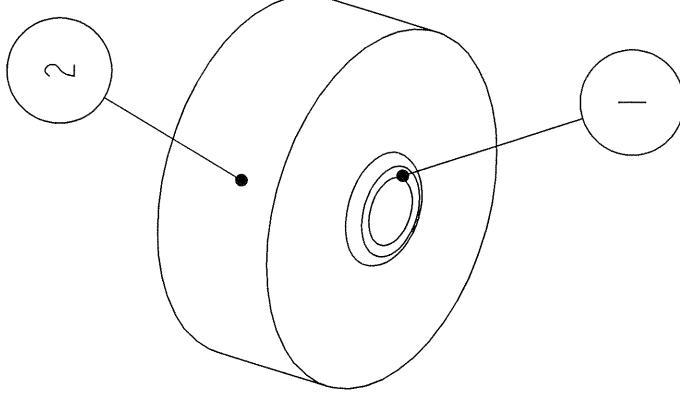
REV NO	DATE	DESCRIPTION	ECN NO	BY															
1	18JAN2005	SET SCREW WAS.05611 .502234-1 WAS 502234-1 ADDED 502234-1	7147	JMW															
SCALE 0.500																			
X	XXX	REQ'D WHERE USED	X	XXX															
<p>DRAWN BY: CMC SCALE 0 . 500 DIMENSIONAL TOLERANCES MATERIAL: XXX</p> <table border="1"> <tr> <td>DATE 13-0C+04</td> <td>.01</td> <td>.005</td> <td>.5 ANG.</td> <td>HEAT TREAT: XXX</td> </tr> <tr> <td colspan="4">REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED</td> <td>FINISH: XXX</td> </tr> <tr> <td colspan="5">ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY</td> </tr> </table> <p>CHECKED BY: TRACED BY: MASTER</p> <p>MODEL: SP 66600</p> <p>SHEET NO.: OF 1</p> <p>PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE QUOTED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC. KENNESAW, GA 30144 USA</p> <p>KIRK - RUDY, INC. KENNESAW, GEORGIA</p> <p>TITLE: ASSY - GATE</p> <p>DRAWING # 534043-01</p>					DATE 13-0C+04	.01	.005	.5 ANG.	HEAT TREAT: XXX	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED				FINISH: XXX	ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY				
DATE 13-0C+04	.01	.005	.5 ANG.	HEAT TREAT: XXX															
REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED				FINISH: XXX															
ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY																			

ITEM	QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	1	102200	COLLAR .375					
2	1	102787	SPRING					
3	1	105442	DOWEL, PIN .375X1.750					
4	1	107334	BOLT, HEX HO MACH					
5	1	500807	NUT - LOCK					
6	1	500809	SLEEVE - THREADED					
7	1	500812-2	KNOB, ROLLER ADJUSTMENT					
8	1	502261A	ASSY-FEED ROLLER					
9	1	534070-01	BAR-UPPER FEED ROLLER					



DRAWN BY:	JMW	SCALE	0 . 800	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	X X X	THIRD ANGLE PROJECTION	PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE QUOTED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC. KENNEDY, GA 30444 USA
CHECKED BY:	-	DATE	25-Jan-05	.XX .XXX .005 .5 ANG.	HEAT TREAT:	X X X	NOTE: KIRK-RUDY, INC. KENNEDY, GA 30444 USA
TRACED BY:	MASTER	MATERIAL	ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED	FINISH:	SP 66600	NAME: ASSY-FEED ROLLER, BAR SHEET NO.: 10F1 DRAWING #: 534069-01
	-						

ITEM QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	101100	BEARING, ONEWAY .375					
2	502261	UPPER FEED ROLLER					
				-		REQ'D	WHERE USED



DRAWN BY: JMW	SCALE 1 . 000	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED			MATERIAL: XXX	THIRD ANGLE PROJECTION - - -	PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE QUOTED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY INC. KENNESAW, GA 30144 USA
CHECKED BY: 0 , 000	DATE 25 - Jan - 05	.xx	.xxx	.005	HEAT TREAT: XXX	MODEL: 203	KIRK - RUDY - INC. KENNESAW, GEORGIA
TRACED BY: -	MASTER	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED			FINISH: XXX	SHEET NO: OF 1	TITLE: ASSY - FEED ROLLER DRAWING # 502261A
ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY							

ITEM	QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	4	502295	SHAFT, PAPER GUIDE	1	1/24/2004	ADDED (2) 502295, DELETED (2) 535527-01	7158	JWW
2	1	536339-01	PLATE, SIDE GUIDE RH					
3	1	536340-01	PLATE, SIDE GUIDE LH					
4	2	536347-01	BRUSH-BACKSTOP					
5	1	536348-01	ANGLE-SIDE GUIDE					
6	1	536349-01	ANGLE-SIDE GUIDE, RH					
7	2	536350-01	BLOCK-BRUSH MOUNTING					
8	1	CARD, EMBOSSED						

1.000 SP66600
REQ'D WHERE USED

SCALE 0.156

DRAWN BY: TVK	SCALE 0 . 250	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED			MATERIAL: N / A	THIRD ANGLE PROJECTION 	PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE COPIED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC. KENNESAW, GA 30144 USA	
DATE 23 - May - 99	.01	.005	.5	HEAT TREAT: N / A	MODEL: SP66600	TITLE: ASSY - EMBOSSED CARD HOPPER GUIDE	SHEET NO.: 10F1	DRAWING #: 536342-01
CHECKED BY: MASTER	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED			FINISH: N / A				
TRACED BY:	ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE WORK TO DIMENSIONS ONLY							

ITEM	QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	2	502295	SHAFT, PAPER GUIDE					
2	1	535393-01	ANGLE-SIDE GUIDE					
3	1	535393-01R	ANGLE-SIDE GUIDE					
4	1	535399-01	PLATE, GUIDE					
5	1	535400-01	SIDEGUIDE, PRODUCT EASY LOAD					
6	1	535401-01	SIDEGUIDE, TOP EASY LOAD					
7	1	535402-01	SIDEGUIDE, LH TOP EASY LOAD					
8	2	535527-01	SHAFT, PAPER GUIDE					
9	1	536128-01	STRAP, SIDEGUIDE TIE					

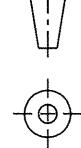
1 SP66600
REV D WHERE USED

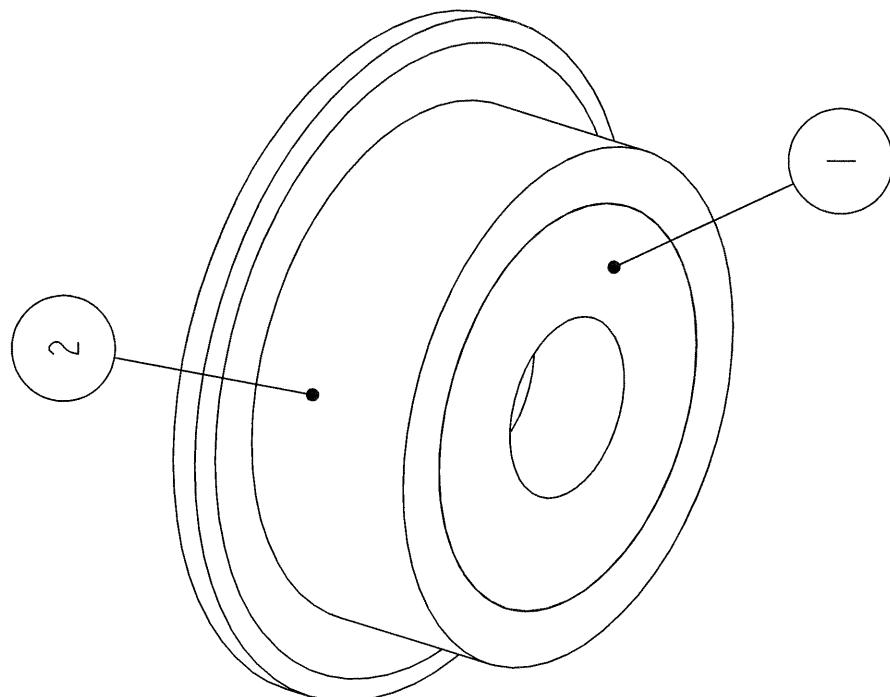
KIRK - RUDY, INC.
KENNESAW, GEORGIA

DRAWN BY: TVK	SCALE: 0 . 250	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED			MATERIAL: N/A	THIRD ANGLE PROJECTION [Diagram: Top view of a circle with a cross inside, indicating Third Angle Projection.]	PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE COPIED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC. KENNESAW, GA 30144 USA		
CHECKED BY:	DATE: 23-Feb-99	.xx	.xxx	.ANG.	HEAT TREAT: 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	MODEL: SP66600	TITLE: ASSY, EXTENDED SIDE GUIDE	DRAWING # 535398-01	
						SHEET NO. 0F1			

110108A

ITEM	QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	2	103108	BEARING, FLAT .500					
2	1	110108	SPRKIT, 25B22 1.125B NK					

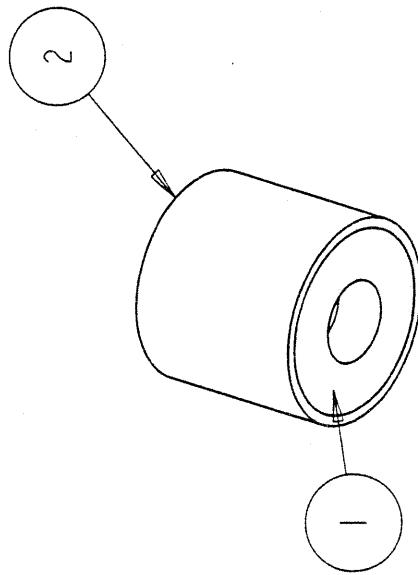
-	-	REO'D	WHERE USED
<p>PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE QUOTED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY INC. KR KIRK - RUDY, INC. KENNESAW, GEORGIA</p> <p>THIRD ANGLE PROJECTION</p>  <p>MODEL: SP 66600</p> <p>TITLE: ASSY - IDLER SPROCKET</p> <p>DRAWING #</p> <p>SHEET NO: 0F </p>			
DRAWN BY: JMW	SCALE 2 . 000	MATERIAL: XXX	
CHECKED BY: -	DATE 19 - Jan - 05	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED .xx .xxx .01 .005 .5	HEAT TREAT: XXX
TRACED BY: -	MASTER	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY	FINISH:



DRAWING 5
533891A-01

533891A-01

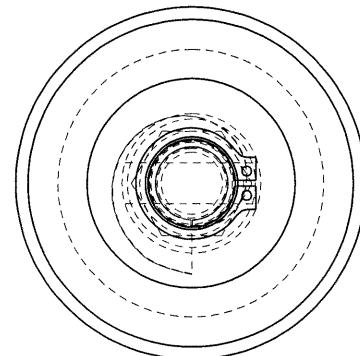
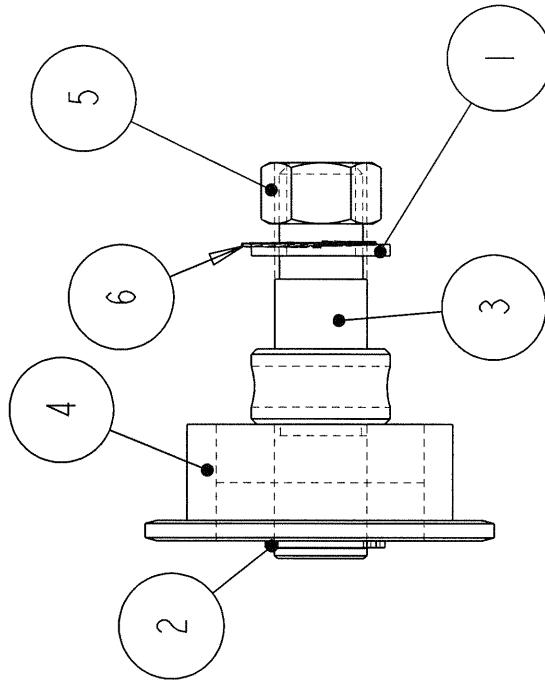
ITEM QTY	PART #	DESCRIPTION
1	2	103108 BEARING, FLAT .500
2	1	533891-01 ROLLER-IDLER, I. 1.2500



ITEM	QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	2	103108	BEARING, FLAT	.500				
2	1	533891-01	ROLLER-IDLER, I. 250D					

DRAWN BY: TVK	SCALE: 1 . 000	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED			MATERIAL: XXX	THIRD ANGLE PROJECTION			PROPRIETARY AND CONFIDENTIAL NO COPIES OF THIS DRAWING MAY BE COPIED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, KENNESAW, GA 3044 USA
CHECKED BY:	DATE: 24-Feb-99	.01	.005	.5	HEAT TREAT:	XXX			KIRK - RUDY, INC. KENNESAW, GEORGIA
TRACED BY:	MASTER	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED			FINISH:	XXX	SP66600	REF ID: SP66600	ASSY-IDLER ROLLER
ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY			SHEET NO: 10F 1	DRAWING #: 533891A-01					

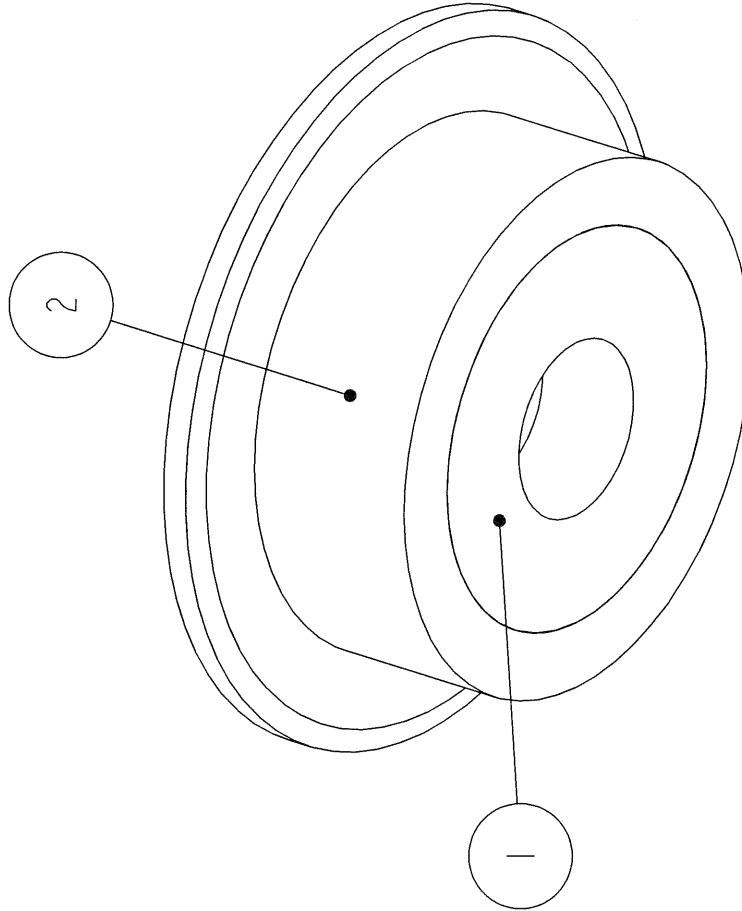
ITEM	QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	1	100402	WASHER, THRUST TB612					
2	1	104106	SNAPRING, .500					
3	1	500817	SHAFT-GEAR SPUR					
4	1	110108A	ASSY-IDLER SPROCKET					
5	1	RHN012	NUT, HEX 3/8					
6	1	WHS011	WASHER, LOCK 3/8					



DRAWN BY:	JMW	SCALE	.000	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED			THIRD ANGLE PROJECTION	PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE QUOTED OR REPRODUCED IN ANY FORM, WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC. KENNESAW, GA 30144 USA
CHECKED BY:	-	DATE	19-JAN-05	.xx	.xxx	ANG.		
TRACED BY:	-	MASTER		.01 .005 .5 REMOVE ALL BURS AND SHARP EDGES UNLESS OTHERWISE NOTED			HEAT TREAT:	KIRK - RUDY - INC. KENNESAW, GEORGIA
				ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY			MODEL: 215	STUD ASY
							SHEET NO: 0F1	DRAWING # 535352A-01

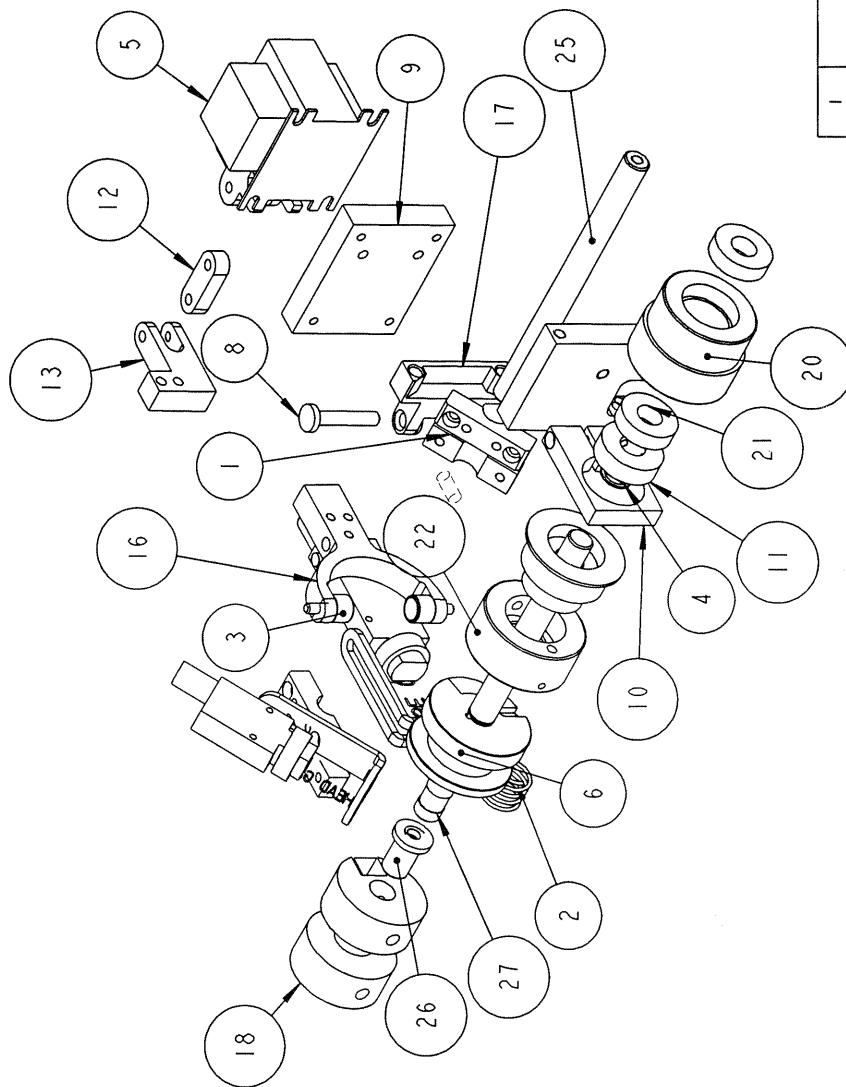
110157A

ITEM	QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	2	103108	BEARING, FLAT .500					
2	1	110157	SPRKIT, 25B24 1.125B NK					



								-	-		
								REQ'D	WHERE USED		
DRAWN BY: JMW		SCALE 2 . 000		DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED .xx .xxx ANG.		MATERIAL: X X X		THIRD ANGLE PROJECTION 		PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE QUOTED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY INC. KENNESAW, GA 30144 USA	
CHECKED BY: -		DATE 25 - Jan - 05		HEAT TREAT: NONE		MODEL: 215		TITLE: ASSY , 25B24 IDLER			
TRACED BY: -		MASTER		FINISH: N / A		SHEET NO.: 0F 1		DRAWING #		110157A	

ITEM	QTY	PART #	DESCRIPTION	REV NO	DATE	ECN NO	BY
1	2	100309	BUSHING, FL. 250ID. 375OD. 250LG	1	2/13/2004		
2	1	102707	SPRING, COIL	2	8/19/2004	DELETED: 501037, 535394-01, ADD 501374-12 50896-2, 535209-02	TJS
3	2	103408	CAM FOLLOWER				JMW
4	1	104106	SNAPRING, .500				
5	1	190002	SOLENOID				
6	1	500936	COLLAR, THROW-OUT				
7	2	501093	WASHER				
8	1	501336	PIN-YOKE PIVOT				
9	1	502000	SOLENOID PLATE				
10	1	502874	BRAKE-ONE UP HEAD				
11	1	502875	COLLAR-BAKE ONE UP HEAD				
12	1	503250	LINK, THROW OUT				
13	1	503255	LEVER, THROW OUT (EXT)				
14	1	202261-5	BEAMSWITCH, RETROREFLECTIVE				
15	1	202261-33	SENSOR, RELAY				
16	1	500941-1	YOKE, THROWOUT TIP-ON				
17	1	500957-1	BRACKET, YOKE THROWOUT				
18	2	501374-12	ASSY, PROX RING W/ REFLECTOR				
19	2	508996-9	BRACKET, PHOTOCELL 90DEG				
20	1	533849-01	ASSY, BEARING HUB				
21	1	534058-01	SPACER, YOKE THROWOUT				
22	1	534060-01	HUB, DISCONNECT				
23	2	535209-01	BLOCK, CLAMP BOTTOM				
24	2	535209-02	BLOCK, CLAMP TOP				
25	1	535395-01	STUD, BEAM SWITCH				
26	1	539684-01	SPACER, TABLETOP				
27	1	SP48607-1	SHAFT, THROWOUT				
28	1	WHS009	WASHER, LOCK 1/4				



ITEM	QTY	PART #	DESCRIPTION	REV NO	DATE	ECN NO	BY
1	2	100309	BUSHING, FL. 250ID. 375OD. 250LG	1	2/13/2004		
2	1	102707	SPRING, COIL	2	8/19/2004	DELETED: 501037, 535394-01, ADD 501374-12 50896-2, 535209-02	TJS
3	2	103408	CAM FOLLOWER				JMW
4	1	104106	SNAPRING, .500				
5	1	190002	SOLENOID				
6	1	500936	COLLAR, THROW-OUT				
7	2	501093	WASHER				
8	1	501336	PIN-YOKE PIVOT				
9	1	502000	SOLENOID PLATE				
10	1	502874	BRAKE-ONE UP HEAD				
11	1	502875	COLLAR-BAKE ONE UP HEAD				
12	1	503250	LINK, THROW OUT				
13	1	503255	LEVER, THROW OUT (EXT)				
14	1	202261-5	BEAMSWITCH, RETROREFLECTIVE				
15	1	202261-33	SENSOR, RELAY				
16	1	500941-1	YOKE, THROWOUT TIP-ON				
17	1	500957-1	BRACKET, YOKE THROWOUT				
18	2	501374-12	ASSY, PROX RING W/ REFLECTOR				
19	2	508996-9	BRACKET, PHOTOCELL 90DEG				
20	1	533849-01	ASSY, BEARING HUB				
21	1	534058-01	SPACER, YOKE THROWOUT				
22	1	534060-01	HUB, DISCONNECT				
23	2	535209-01	BLOCK, CLAMP BOTTOM				
24	2	535209-02	BLOCK, CLAMP TOP				
25	1	535395-01	STUD, BEAM SWITCH				
26	1	539684-01	SPACER, TABLETOP				
27	1	SP48607-1	SHAFT, THROWOUT				
28	1	WHS009	WASHER, LOCK 1/4				

DRAWN BY:	MY	SCALE	0 . 300	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	MATERIAL: N/A	THIRD ANGLE PROJECTION	PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE COPIED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC. KENNESAW, GA 30144 USA
CHECKED BY:		DATE	03 - JUN - 98	.XX .XXX .ANG.	HEAT TREAT: N/A	MODEL: 486LR	TITLE: ASSY , THROWOUT
TRACED BY:	MASTER			.01 .005 .5	FINISH: N/A	SHEET NO: 0F3	DRAWING #
				REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED	ALL DIMENSIONS ARE IN INCHES. WORK TO DIMENSIONS ONLY		534034-01

ITEM QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	2	100309			BUSHING, FL. 250ID.375OD.250LG		
2	1	102707			SPRING, COIL		
3	2	103408			CAM FOLLOWER		
4	1	104106			SNAPPING, .500		
5	1	190002			SOLENOID		
6	1	500936			COLLAR, THROW-OUT		
7	2	501093			WASHER		
8	1	501336			PIN-YOKE PIVOT		
9	1	502000			SOLENOID PLATE		
10	1	502874			BRAKE-ONE UP HEAD		
11	1	502875			COLLAR-BAKE ONE UP HEAD		
12	1	503250			LINK, THROW OUT		
13	1	503255			LEVER, THROW OUT (EXT)		
14	1	202261-5			BEAMSWITCH, RETROREFLECTIVE		
15	1	202261-33			SENSOR, RELAY		
16	1	500941-1			YOKE, THROWOUT TIP-ON		
17	1	500957-1			BRACKET, YOKE THROWOUT		
18	2	501374-12			ASSY, PROX RING W/ REFLECTOR		
19	2	508996-9			BRACKET, PHOTOCELL 90DEG		
20	1	533849-01			ASSY, BEARING HUB		
21	1	534058-01			SPACER, YOKE THROWOUT		
22	1	534060-01			HUB, DISCONNECT		
23	2	535209-01			BLOCK, CLAMP BOTTOM		
24	2	535209-02			BLOCK, CLAMP TOP		
25	1	535395-01			STUD, BEAM SWITCH		
26	1	539684-01			SPACER, TABLETOP		
27	1	SP48607-1			SHAFT, THROWOUT		
28	1	WHS009			WASHER, LOCK 1/4		

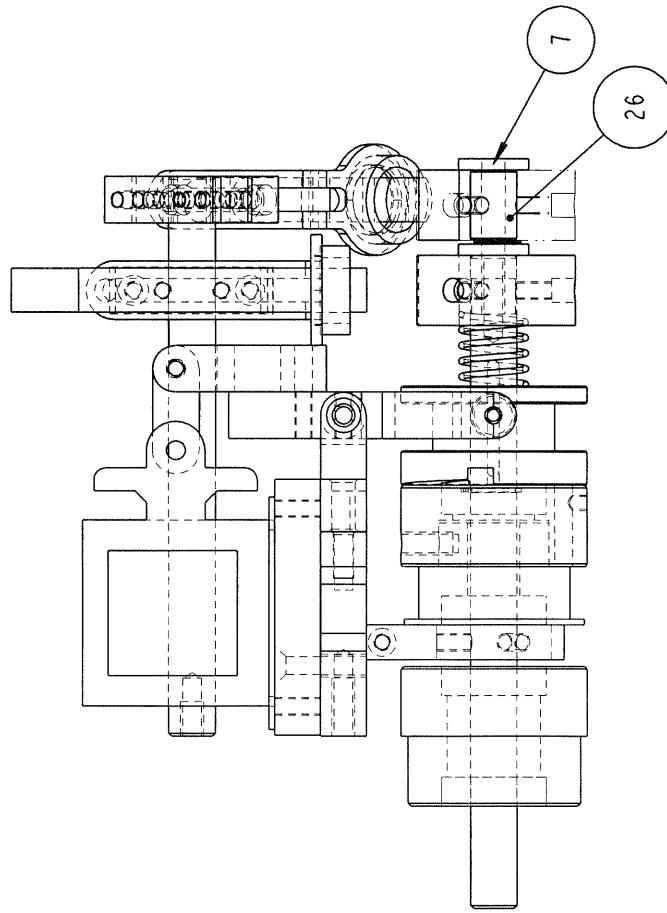
SCALE 0.750

DRAWN BY: MY
CHECKED BY:
TRACED BY:

19-Aug-04
MASTER

DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED		MATERIAL: N/A		THIRD ANGLE PROJECTION NO PORTION OF THIS DRAWING MAY BE DUPLICATED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY INC.	
.01	.005	.005	.005	KIRK - RUDY, INC. KENNESAW, GEORGIA	
.005 .005		HEAT TREAT: N/A		TITLE: ASSY, THROWOUT	
REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED		FINISH: N/A		DRAWING # 534034-01	
ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY		SHEET NO 20F3			

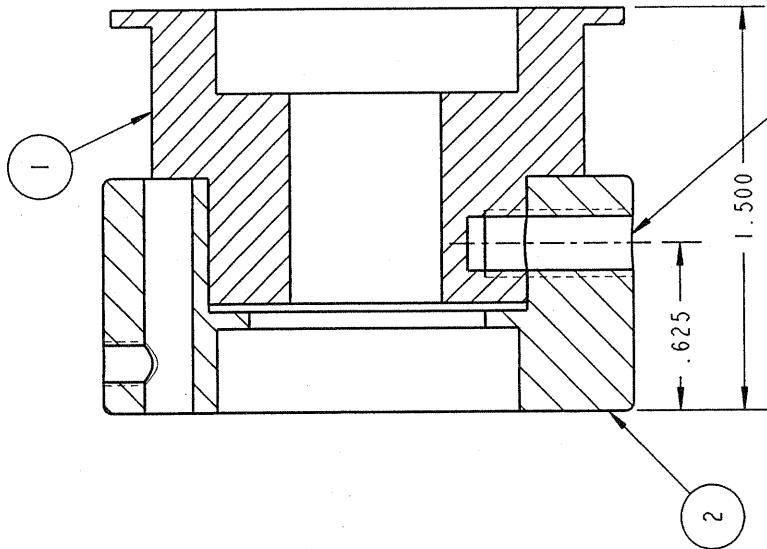
ITEM QTY	PART #	DESCRIPTION	REV NO	DATE	ECN NO	BY
1	2	100309				
2	1	102707				
3	2	103408				
4	1	104106				
5	1	190002				
6	1	500936				
7	2	501093				
8	1	501336				
9	1	502000				
10	1	502874				
11	1	502875				
12	1	503250				
13	1	503255				
14	1	202261-5				
15	1	202261-33				
16	1	500941-1				
17	1	500957-1				
18	2	501374-12				
19	2	508996-9				
20	1	533849-01				
21	1	534058-01				
22	1	534060-01				
23	2	535209-01				
24	2	535209-02				
25	1	535395-01				
26	1	539684-01				
27	1	SP48607-1				
28	1	WHS009				



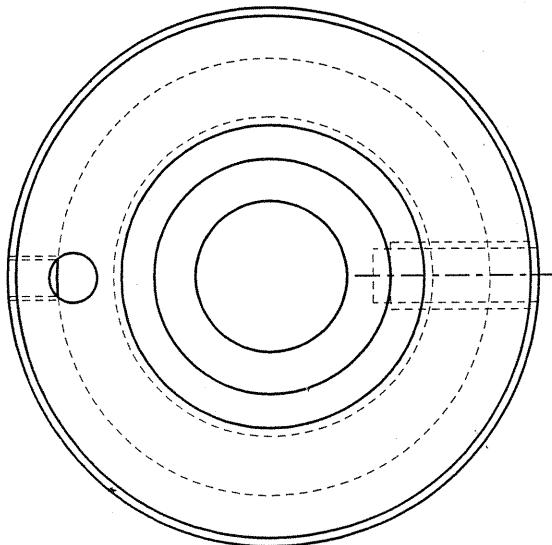
DRAWN BY:	SCALE	0 . 500	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED		MATERIAL:	N/A	THIRD ANGLE PROJECTION	PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE QUOTED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC., KENNESAW, GA 30144 USA
CHECKED BY:	DATE	.xx	.xxx	.5	HEAT TREAT:	N/A	MODEL:	486LR
TRACED BY:	MASTER	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED				FINISH:	SHEET NO:	30F3
		ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY					DRAWING #:	534034-01
				1	REF'D WHERE USED			

ITEM QTY	PART #	DESCRIPTION
1	533844-01	PULLEY, #4L050
2	534061-01	HUB

	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	05-JUN-98		REDRAWN IN PROJ E	6254	HY
2	9/18/2000		MODIFIED FOR MANUFACTURING	3580	TJG
3	2/13/2004		WIDTH WAS 1.875"	7031	TJG



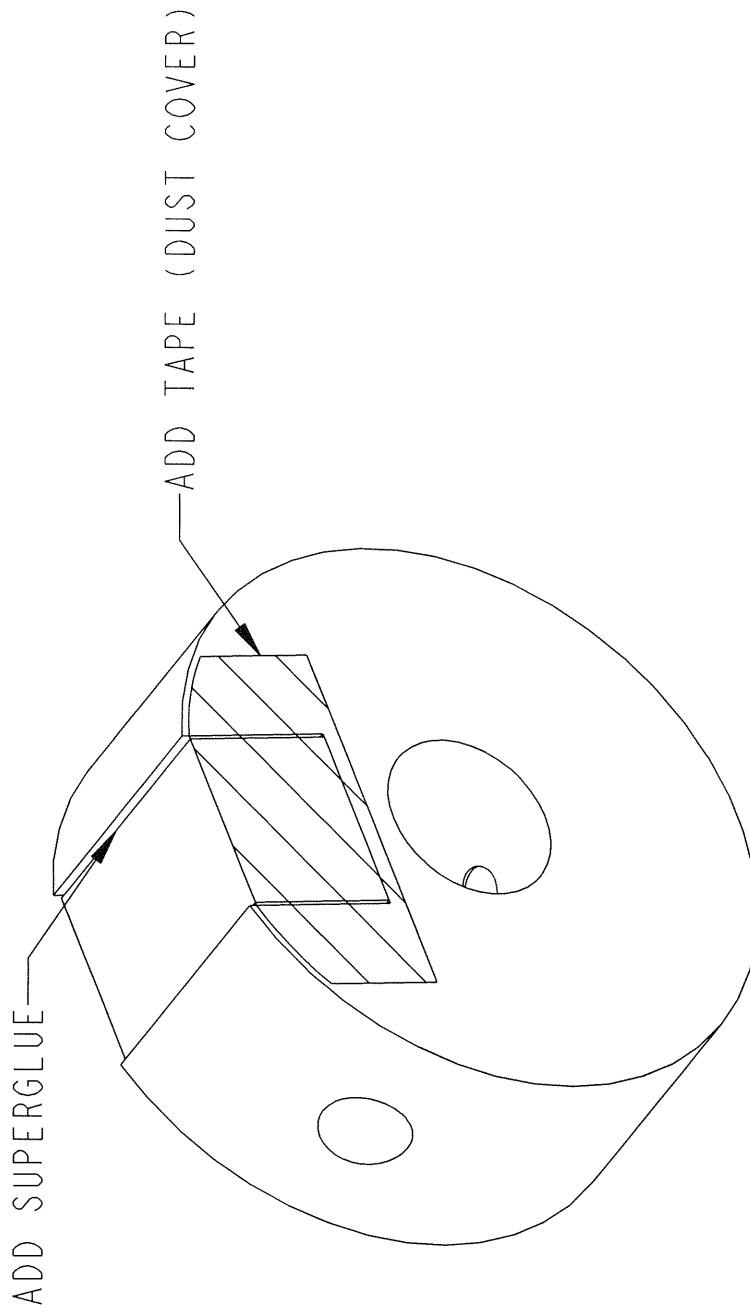
NOTES:
 1. PRESS FIT PULLEY INTO HUB
 2. INSTALL SET SCREW TO BOTTOM OUT INTO ALUM. PULLEY



DRAWN BY:	SCALE	DATE	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	MATERIAL:	THIRD ANGLE PROJECTION	PROPRIETARY AND CONFIDENTIAL
TVK	1 .500		.XX .XXX .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:		05-JUN-98	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED	HEAT TREAT: N/A	MODEL: SP66600	TITLE: HUB, DISCONNECT
TRACED BY:	MASTER		ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY	FINISH: N/A	SHEET NO. 1 OF 1	DRAWING I
						534060-01

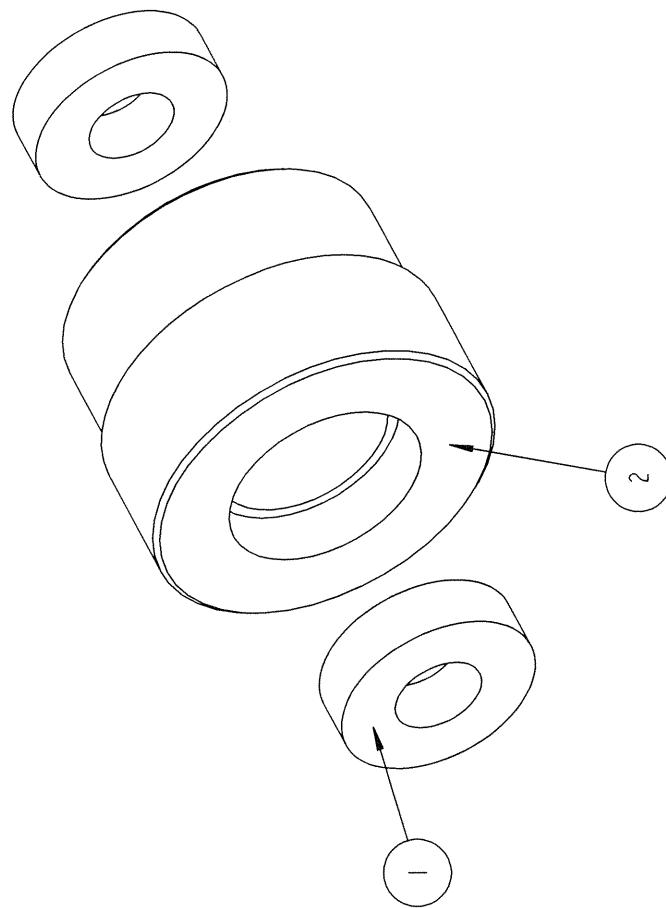
REV NO	DATE	DESCRIPTION	ECN NO	BY
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ITEM QTY	PART #	DESCRIPTION
1	202246-3	REFLECTOR, SENSOR (REF 501374-12)
2	501374-11	RING-BEAM SWITCH



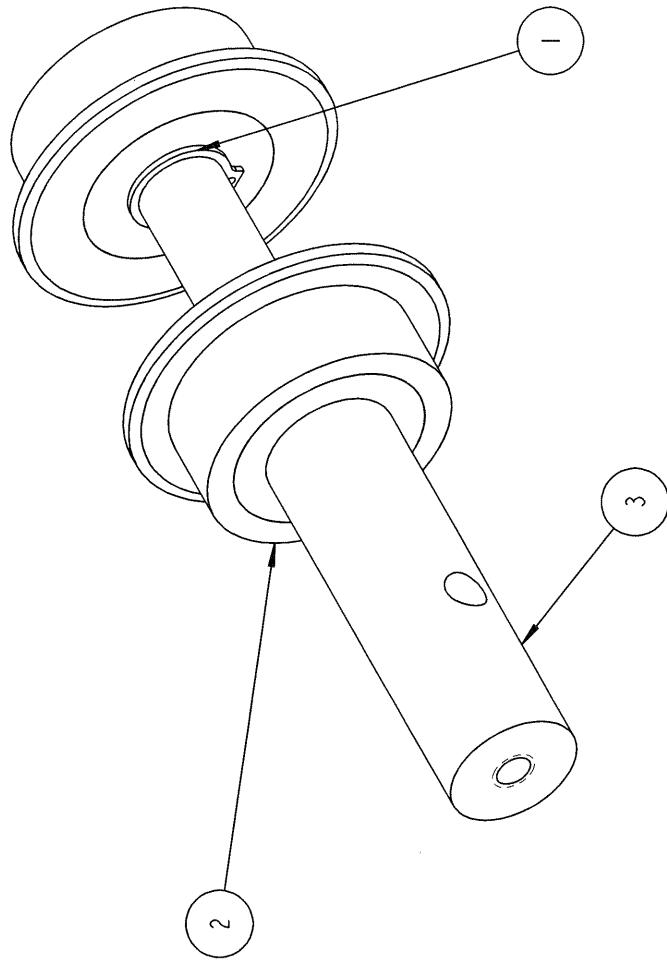
DRAWN BY:	JMW	SCALE	2.000	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	MATERIAL:	N/A	THIRD ANGLE PROJECTION	PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE QUOTED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC. KENNESAW, GA 30144 USA	
CHECKED BY:		.xx	.xxx	ANG.					
TRACED BY:		DATE	17-Aug-04	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED	HEAT TREAT:	N/A	MODE:	486LR	TITLE: ASSY, PROX RING W/ REFLECTOR
					FINISH:	N/A	SHEET NO.:	OF 1	DRAWING #:
									501374-12
REO'D WHERE USED XXX									

ITEM QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	2	103108 BEARING, FLAT .500					
2	1	533848-01 HUB, BEARING					



DRAWN BY:	MY	SCALE	.000	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	N/A	THIRD ANGLE PROJECTION	KIRK - RUDY, INC.
CHECKED BY:		DATE	05 - Jun - 98	.xx	.xxx	HEAT TREAT:	KENNESAW, GEORGIA
TRACED BY:	MASTER			ANG.	.01	.005	
				REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED			TITLE: ASSY, BEARING HUB
				ALL DIMENSIONS ARE IN INCHES DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY			DRAWING # 533849-01
				FINISH:	N/A	SHEET NO. OF 1	

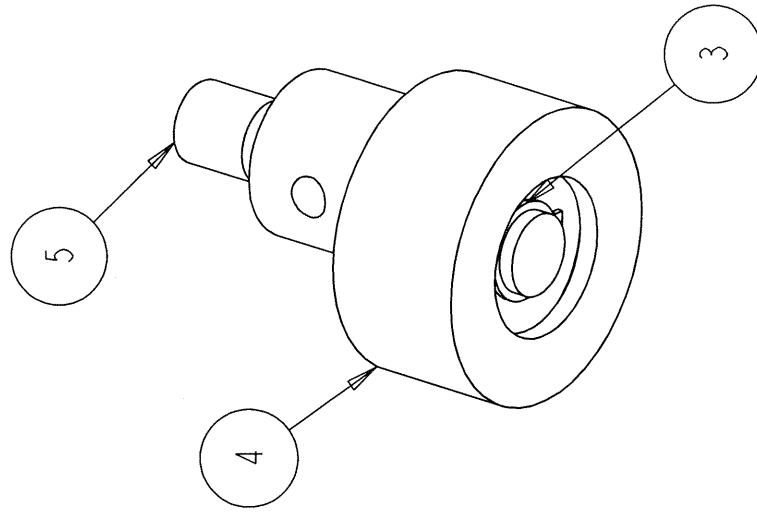
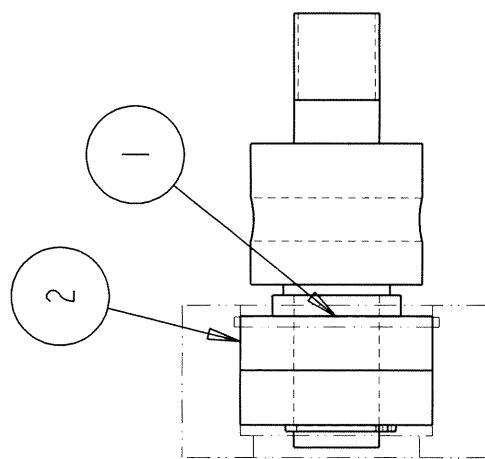
ITEM	QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	3	104106	SNAPRING, .500					
2	2	110108A	ASSY - IDLER SPROCKET					
3	1	534047-01	STUD - IDLER					



DRAWN BY: T JG	SCALE 1 . 000	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED		MATERIAL: XXX	THIRD ANGLE PROJECTION	PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE QUOTED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY INC., KENNESAW, GA 30144, USA		KIRK - RUDY, INC. KENNESAW, GEORGIA
CHECKED BY:	DATE 01-0C+ -01	.XX	.XXX	ANG. .01	HEAT TREAT: XXX	MODEL: SP 66600	TITLE: ASSY - STUD AND IDLER SPROCKET	DRAWING # 534046-01
TRACED BY:	MASTER	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED		ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY		SHEET NO. 10F1	DRAWING # 534046-01	

ITEM QTY	PART #	DESCRIPTION
1	1	102301 SHIM, .500X.750X.125
2	2	103108 BEARING, FLAT .500
3	1	104106 SNAPPING, .500
4	1	109386 PULLEY, TIMING 15L050 1.125B NK
5	1	534065-01 STUD

REV NO	DATE	DESCRIPTION	ECN NO	BY
2	SP66600			RECD WHERE USED



DRAWN BY:	SCALE	0.000	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED		MATERIAL:	N/A	THIRD ANGLE PROJECTION	PROPRIETARY AND CONFIDENTIAL NO kopieren OR TRAVERSE MAY BE DUPLICATED IN ANY FORM EXPRESS WRITTEN PERMISSION TO KIRK-RUDY INC. KENNESAW, GA 30144 USA	
CHECKED BY:	DATE	01-Feb-00	.01 .005 .5 XXX XXX ANG		HEAT TREAT:	N/A	TITLE:	ASSY - TAKE UP	
TRACED BY:	MASTER	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED		ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY		1115:	SP66600	SHEET NO.	DRAWING #
		N/A		N/A				10F1	534064-01

ITEM QTY	PART #	DESCRIPTION
1	103120	BEARING, FLAT 1.250
2	5 103804	BEARING, HUB .625
3	1 533942-01	PLATE-FRAME
4	1 534838-01	BAR - COVER MTG
5	2 536123-01	GUSSET, MAIN FRAME
6	1 536124-01	PLATE, GUSSET SUPPORT

REV NO	DATE	DESCRIPTION	ECN NO	BY
1	SP66600			REO'D WHERE USED

DRAWN BY: TVK SCALE 0 .250 DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED MATERIAL: XXX THIRD ANGLE PROJECTION

.xx	.xxx	.01	HEAT TREAT: XXX
ANG.		.005	

CHECKED BY: DATE 23-Feb-99 REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED

MASTER	ALL DIMENSIONS ARE FINISHED
--------	-----------------------------

TRACED BY:

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

KIRK - RUDY, INC.
KENNESAW, GEORGIA

ASSY - FRAME, FRONT

SP66600

SHEET NO. 1 OF 1

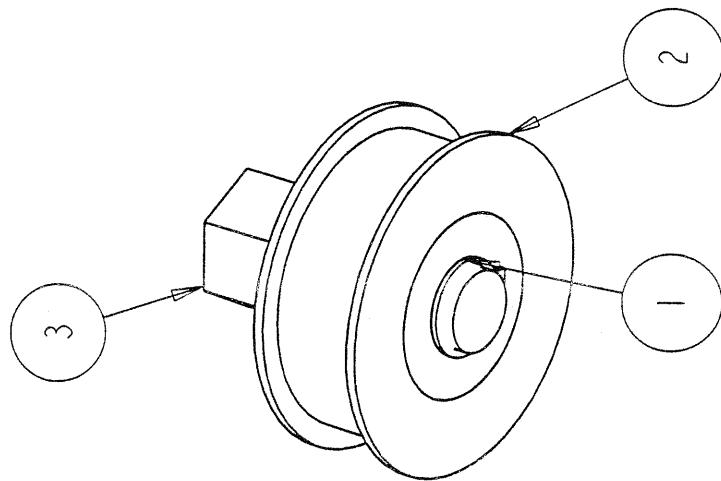
DRAWING 1

534073-01

ITEM QTY	PART #	DESCRIPTION
1	1 04106	SNAPRING, .500
2	1 10108A	ASSY-IDLER SPROCKET
3	500983-1	STUD, IDLER SPROCKET

REV NO	DATE	DESCRIPTION	ECN NO	BY	RECD WHERE USED

DRAWN BY: TVK	SCALE: 1 . 000	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED			THIRD ANGLE PROJECTION	PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE QUOTED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY INC. KENNESAW, GA 30144 USA
CHECKED BY:	DATE: 05 - Feb - 99	X	X	ANG.		
TRACED BY:	MASTER	.01	.005	.5	HEAT TREAT:	KIRK - RUDY - INC, KENNESAW, GEORGIA
		REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED			MODEL: XXX	ASSY - # 25 CHAIN TAKEUP
		ALL DIMENSIONS ARE FINISHED DIMENSIONS			SIZE: XXX	DRAWING #: 534075-01
		DO NOT SCALE - WORK TO DIMENSIONS ONLY			SHEET NO: 1 OF 1	



ITEM QTY	PART #	DESCRIPTION
1	104106	SNAPRING, .500
2	109386A	ASSY-IDLER PULLEY
3	534276-01	HEX STUD

REV NO	DATE	DESCRIPTION	ECN NO	BY

I	SP66600	REO-D WHERE USED
KR	KIRK - RUDY, INC.	KENNE SAW, GEORGIA
SP66600	TIME:	ASSY - TAKE UP
SHEET NO. 1 OF 1	DRAWING #	534275-01

DRAWN BY:	SCALE	MATERIAL:	THIRD ANGLE PROJECTION	PROPRIETARY AND CONFIDENTIAL
TVK	1 . 000	X X X	-	NO PORTION OF THIS DRAWING MAY BE COPIED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC. KENNE SAW, GA 30144 USA
CHECKED BY:	DATE	XX	XX	XX
	23-Feb-99	.01 .005 .5	HEAT TREAT:	
TRACED BY:	MASTER		MODEL:	
			SP66600	
			SHEET NO.	
			1 OF 1	
				DO NOT SCALE - WORK TO DIMENSIONS ONLY

I SP66600

REO-D WHERE USED

KR KIRK - RUDY, INC.

KENNE SAW, GEORGIA

SP66600

TIME:

ASSY - TAKE UP

DRAWING #

534275-01

ITEM QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	1	534055-01 COVER - BACK	1	5/10/99	MODIFIED 534055-01 COVER	6466	TJG
2	1	534063-01 STUD - COVER					
3	1	534833-01 COVER - GEAR					
4	1	535390A-01 ASSY-HINGED BOX					
5	1	535391-01 BAR - COVER					
6	1	535392-01 BAR - COVER					
7	1	535396-01 BAR - COVER					
8	1	535397-01 ASSY - COVER					

SCALE 0.200

1	SP66600	REO'D WHERE USED
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DRAWN BY: TVK		SCALE 0.150	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED		THIRD ANGLE PROJECTION		PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE QUOTED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC. KENNESAW, GA 30144 USA	
			.xx	.xxx	ANG.			
			.01	.005	.5	HEAT TREAT:	XXX	
CHECKED BY:		DATE 19-Feb-99	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED		MODEL SP66600		TITLE:	
TRACED BY:		MASTER	ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY		SHEET NO. 10 OF 1		DRAWING #	
ASSY - COVER								
534834-01								

ITEM QTY	PART #	DESCRIPTION
1	190724-6	SHEET METAL HINGE
2	534062-01	COVER, CLUTCH
3	534835-01	

REV NO	DATE	DESCRIPTION	ECN NO	BY
1	SP66600	WELD STEEL HINGE TO BOTH COVERS		REO'D WHERE USED

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

xx	.xxx	ANG.
.01	.005	.5

HEAT TREAT: X X X

DATE: 19 - Feb - 99

CHECKED BY:

TRACED BY: MASTER

REMOVED ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED

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

MATERIAL: X X X

FINISH: X X X

MODEL: SP66600

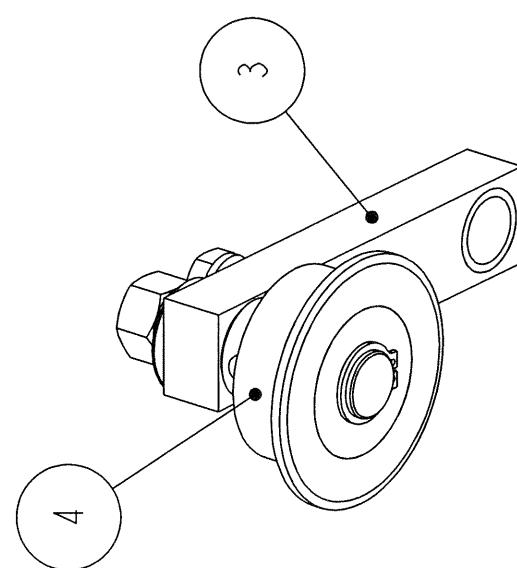
TITLE: ASSY - COVER

SHEET NO: 1 OF 1

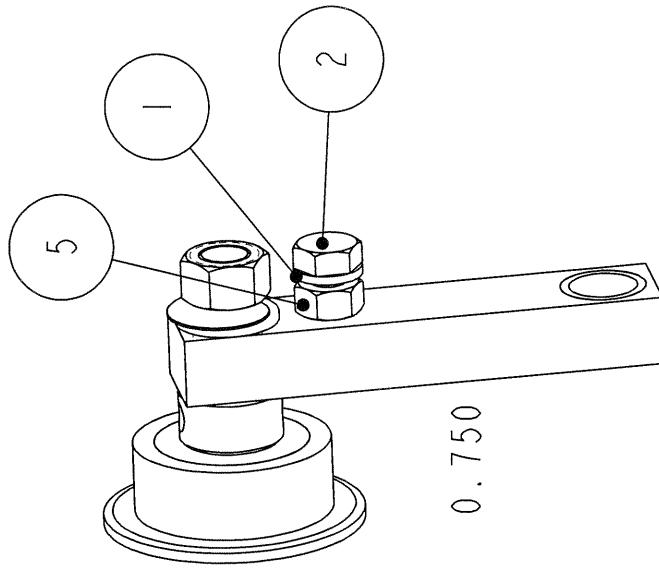
DRAWING #: 535397-01

ITEM QTY	PART #	DESCRIPTION
1	100603	WASHER, FLAT 1/4ID
2	25020HS500	BOLT, 1/4-20 X .500
3	535350A-01	ASSY-BUSHING BAR
4	535352A-01	STUD ASY
5	RHN010	NUT, HEX 1/4

REV NO	DATE	DESCRIPTION	ECN NO	BY
1	21 JAN 2005	ADDED NUT, SCREW, WASHER FOR SPRING LOADED APP.	7155	JWW



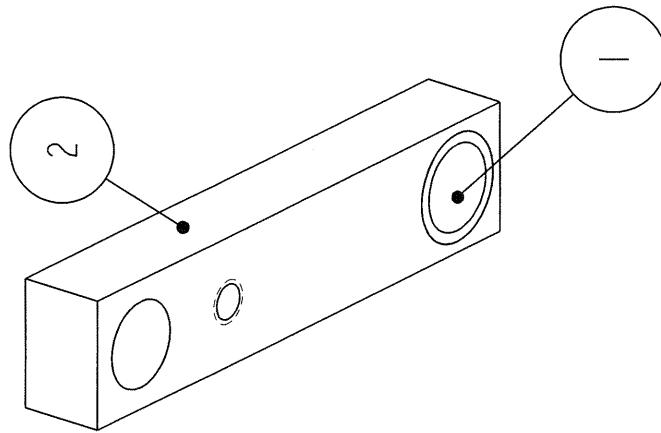
SCALE 0.750



2	SP66600
REQ'D	WHERE USED

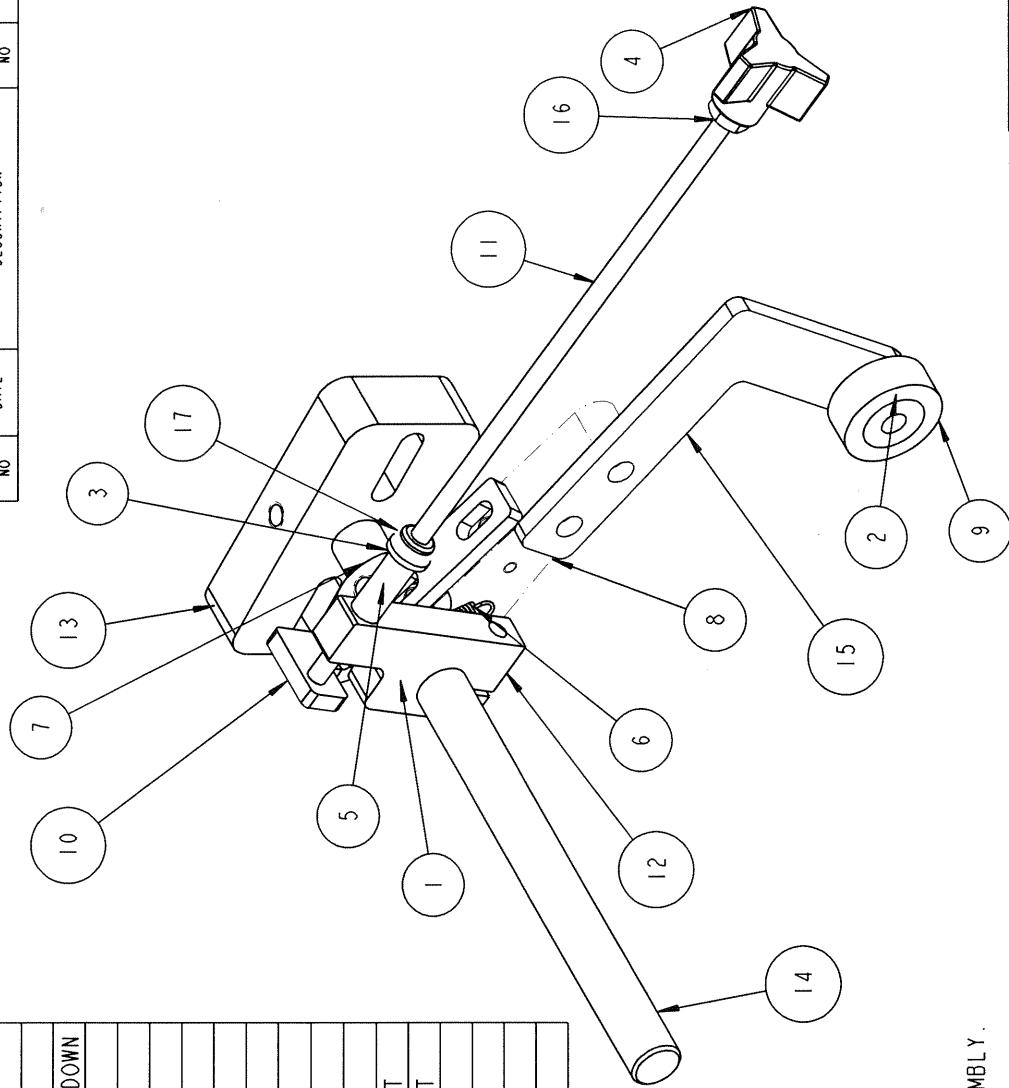
DRAWN BY: TVK	SCALE 0.750	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED		MATERIAL: XXX	THIRD ANGLE PROJECTION - - -	PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE COPIED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC. KENNESAW, GA 3044 USA	
DATE 12-Feb-99	.01	.005	.5	HEAT TREAT: XXX	MODEL: SP66600	TITLE: ASSY-TAKEUP, #25 CHAIN	DRAWING #
CHECKED BY:				FINISH: XXX	SHEET NO.: 10F1		
TRACED BY:	MASTER						535351-01

ITEM QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	1	100135	BUSHING, SL. 5001D. 6250D. 5000LG				
2	1	535350-01	ARM-TAKEUP				



req	MACH
RECD	WHERE USED
 KIRK - RUDY, INC.  KENNE SAW, 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. KENNE SAW, GA 30144 USA	
ASSY - BUSHING BAR	
TITLE: SP 66600	
SHEET NO: 10F1	
DRAWN BY: d r a w n - b y	
SCALE: 1 . 000	
DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	
.xx	.xxx
.01	.005
.5	.5
HEAT TREAT: X X X	
DATE: 19 - Jan - 05	
CHECKED BY: checked - b y	
TRACED BY: traced - b y	
MATERIAL: X X X	
REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED	
FINISH: ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY	

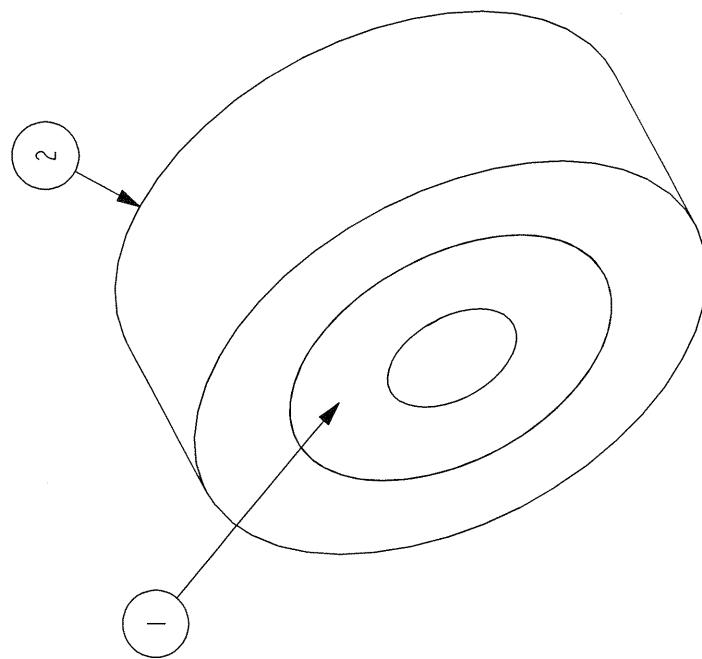
ITEM QTY	PART #	DESCRIPTION
1	100 62	BUSHING, SL. 500ID. 625OD. 625LG
2	100605	WASHER, FLAT 1/4ID BRASS CUT DOWN
3	100619	WASHER, FLAT 10-32
4	102117	KNOB
5	102714	SPRING, COMPRESSION
6	102716	SPRING, COIL EO 240-026-1000M
7	102205-3	COLLAR
8	500801-24	LINK, PINCH ROLLER
9	501057-A	ASSY, ROLLER
10	548500-01	BRACKET, PINCH ROLLER
11	548501-01	ROD, THREADED #10-32
12	548504-01	BLOCK, PINCH ROLLER ADJUSTMENT
13	548506-01	BLOCK, PINCH ROLLER ADJUSTMENT
14	548507-01	SHAFT, PINCH ROLLER PIVOT
15	548508-01	LEVER, PINCH ROLLER
16	HMSN10	NUT, HEX #10-32
17	LOCKNUT-101	LOCKNUT, 10-32



NOTE:
1. REPLACES 535356-03 PINCH ROLLER ASSEMBLY.

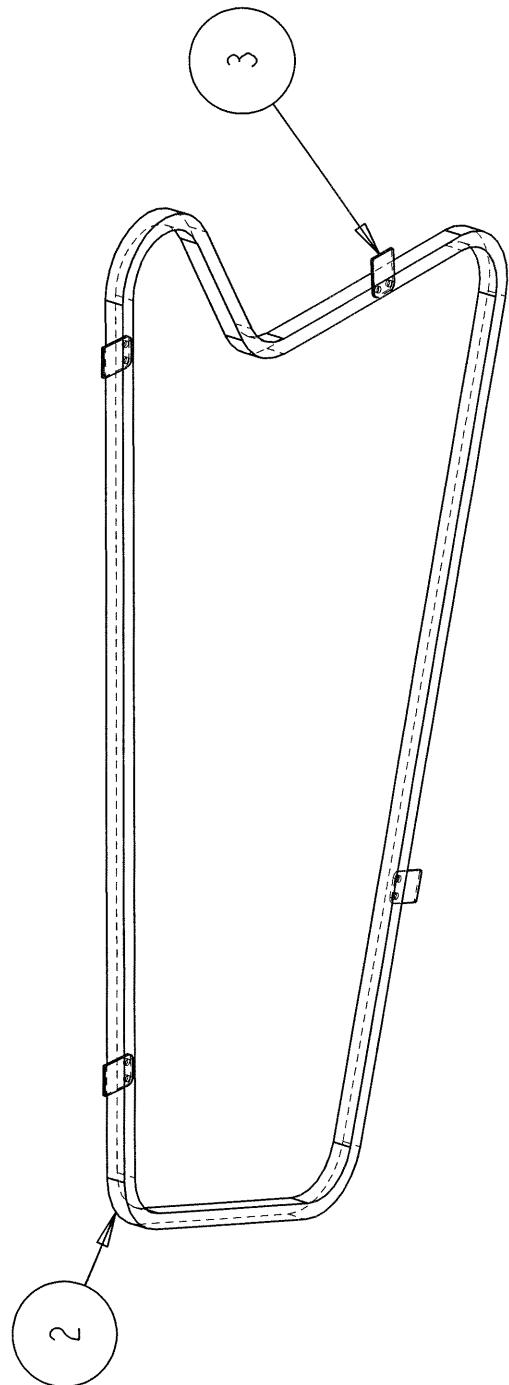
DRAWN BY:	SCALE	MATERIAL:	THIRD ANGLE PROJECTION	RECD WHERE USED
T JG	0 . 625	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	N / A	
CHEKED BY:	DATE	XX XXX .005 .5	HEAT TREAT:	
TRACED BY:	DATE	25 - Mar - 05	FINISH:	
	MASTER	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY	SHEET # OF 1	DRAWING #
			486LR	535356-04

ITEM QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	2	103104 BEARING, FLAT .250					
2	1	501057 ROLLER					



4	535208-01
REQ'D	WHERE USED
 KIRK - RUDY INC. KENNESAW, GEORGIA	
PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE QUOTED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY INC. KENNESAW, GA 30144 USA	
SCALE: M/Y	3.000
DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	
.xx	.xxx
.01	.005
ANG.	.5
HEAT TREAT:	
N/A	
DRAWN BY:	5 - Dec - 98
DATE	MASTER
REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED	
ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY	
CHECKED BY:	
TRACED BY:	
MODEL:	X
SHEET NO:	10F1
ASSY, ROLLER	
DRAWING # 501057-A	

ITEM QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	1	110010 LINK, #25 MASTER					
2	10TY 4	110021-5 #25 CHAIN - 1 1/2" LG					
3	4	500815-1 CLIP-CHAIN-ATTACHMENT					

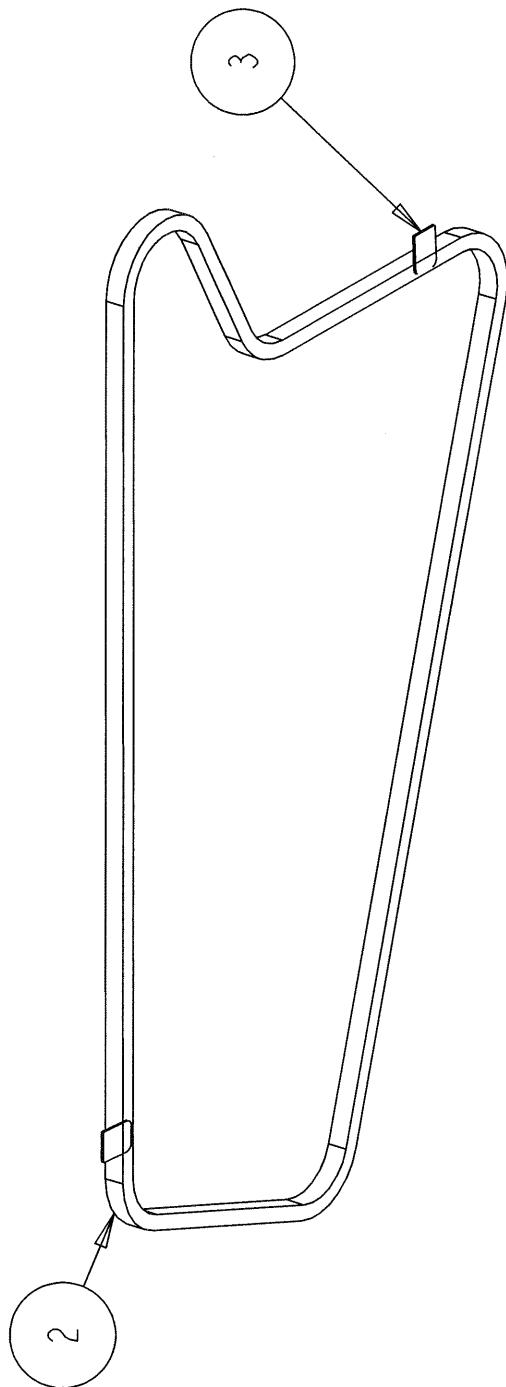


NOTES:

1. CHAIN LENGTH 44"
2. SETUP FOR 1 1/2" SPACING
3. USE FOR 486LR
4. REQUIRES 2 ASY PER MACHINE
5. USE WITH GEARS 101914 (1640) / 102534 (1680)

DRAWN BY: TVK	SCALE 0 . 380	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED		X X X	THIRD ANGLE PROJECTION	PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE QUOTED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY INC. KENNESAW, GA 30144 USA	
CHECKED BY:	DATE 23-FEB-99	.01	.005	ANG. .005	HEAT TREAT:	X X X	MODEL: SP 66600
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	SHEET NO: 10F1	TITLE: CHAIN LUG ASSY	DRAWING #: 535388-01

ITEM	QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	2	110010	LINK, #25 MASTER					
2	1 or 2	110021-45	CHAIN, #25 X 22 IN.					
3	2	500815-1	CLIP-CHAIN-ATTACHMENT					

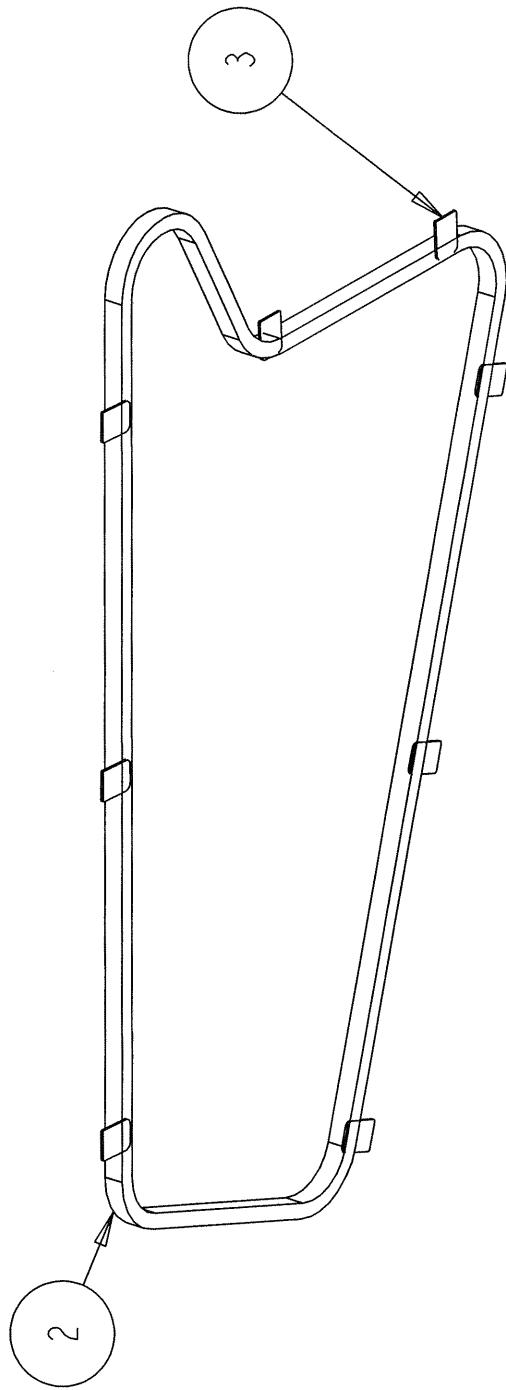


NOTES:

1. CHAIN LENGTH 44"
2. SET UP FOR 22" SPACING
3. USE FOR KR486LR
4. REQUIRES 2 ASSY PER HEAD
5. USE WITH GEARS | 01957 (1624) / 102536 (1696)

DRAWN BY: T J G	SCALE 0 . 380	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED			MATERIAL: XXX	THIRD ANGLE PROJECTION	PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE QUOTED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY INC. KENNESAW, GA 30144 USA	
CHECKED BY: 	DATE 17 - Feb - 03	.01	.005	.5	HEAT TREAT: XXX	MODEL: 486LR	TITLE: ASSY, #25 & LUGS 22 IN. SPACE	DRAWING #
TRACED BY: MASTER		REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED			FINISH: XXX	SHEET NO.: 10F1		
		ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY						535388-05

ITEM QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	2	110010 LINK, #25 MASTER					
2	10Y 8	110021-46 CHAIN, #25 X 5.5 IN.					
3	8	500815-1 CLIP-CHAIN-ATTACHMENT					

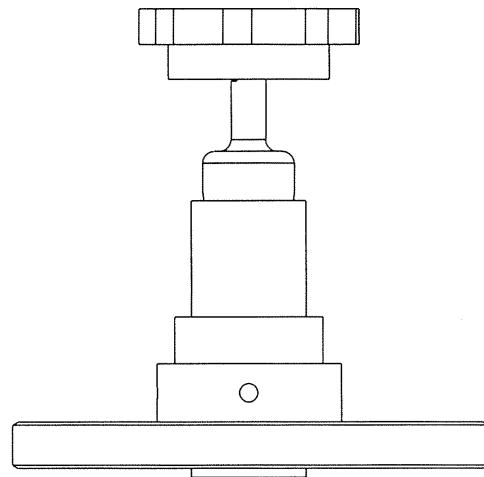
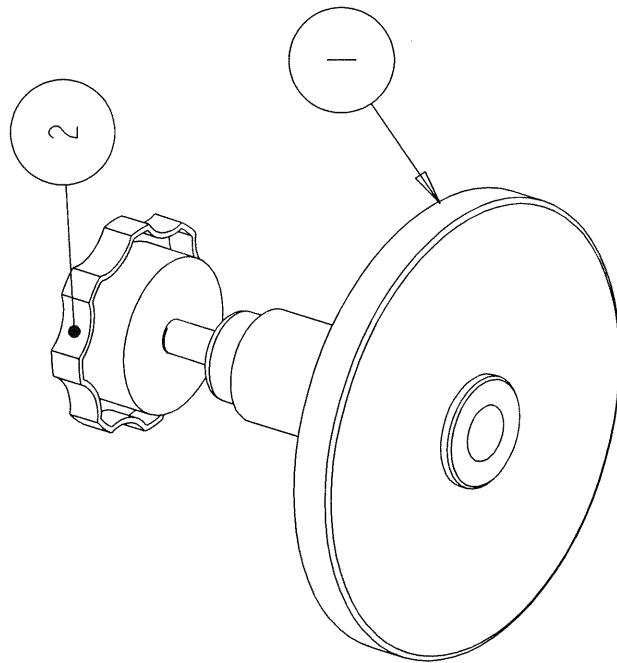


NOTES:

1. CHAIN LENGTH 44"
2. SET UP FOR 5.5" SPACING
3. USE FOR KR486LR
4. REQUIRES 2 ASSY PER HEAD
5. USE WITH GEARS 102515 (1660) / 102535 (1660)

DRAWN BY: T JG	SCALE 0 . 380	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED .xx .xxx ANG. .01 .005 .5	MATERIAL: XXX	THIRD ANGLE PROJECTION HEAT TREAT: XXX	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	REO'D 2	SP66600-4 WHERE USED
CHECKED BY: 7 - F eb - 03	DATE MASTER	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED	MODEL: 486LR	ASSY, #25 & LUGS 5.5 IN. SPACE	TITLE: DRAWING #		
TRACED BY: MASTER		ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY	SHEET NO.: 10F 1				

ITEM QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	102534	GEAR, 1680 1.000B .188K					
2	SP44701A	ASSY-SLEEVE					

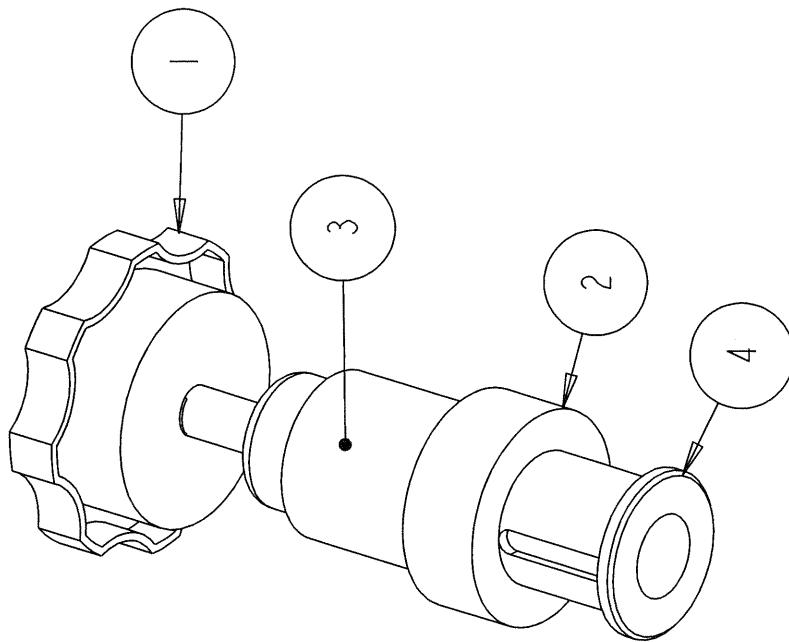


1	SP66600	REO'D WHERE USED
 KIRK - RUDY, INC. KENNESAW, GEORGIA		
<small>PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE QUOTED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC. KENNESAW, GA 30144 USA</small>		
DRAWN BY: TVK	SCALE 0 . 500	THIRD ANGLE PROJECTION
CHECKED BY:	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED .xx .xxx ANG.	MATERIAL: XXX
TRACED BY: MASTER	DATE 23-Feb-99	HEAT TREAT: XXX
	.01 .005 .5	MODEL: SP66600
	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED	TITLE: ASSY-GEAR
	ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY	SHEET NO. 0F1
		DRAWING 1
		535389-01

ITEM QTY	PART #	DESCRIPTION
1	102112	KNOB
2	102212	COLLAR 1.000
3	102612	SPRING.COMPRESSION
4	SP44701	SLEEVE DISCONNECT

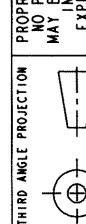
REV NO	DATE	DESCRIPTION	ECN NO	BY
1	17JAN2005	102112 WAS 102133	7146	JMW

1	SP66600
REO'D	WHERE USED



KRK KIRK - RUDY, INC.
KENNE SAW, GEORGIA

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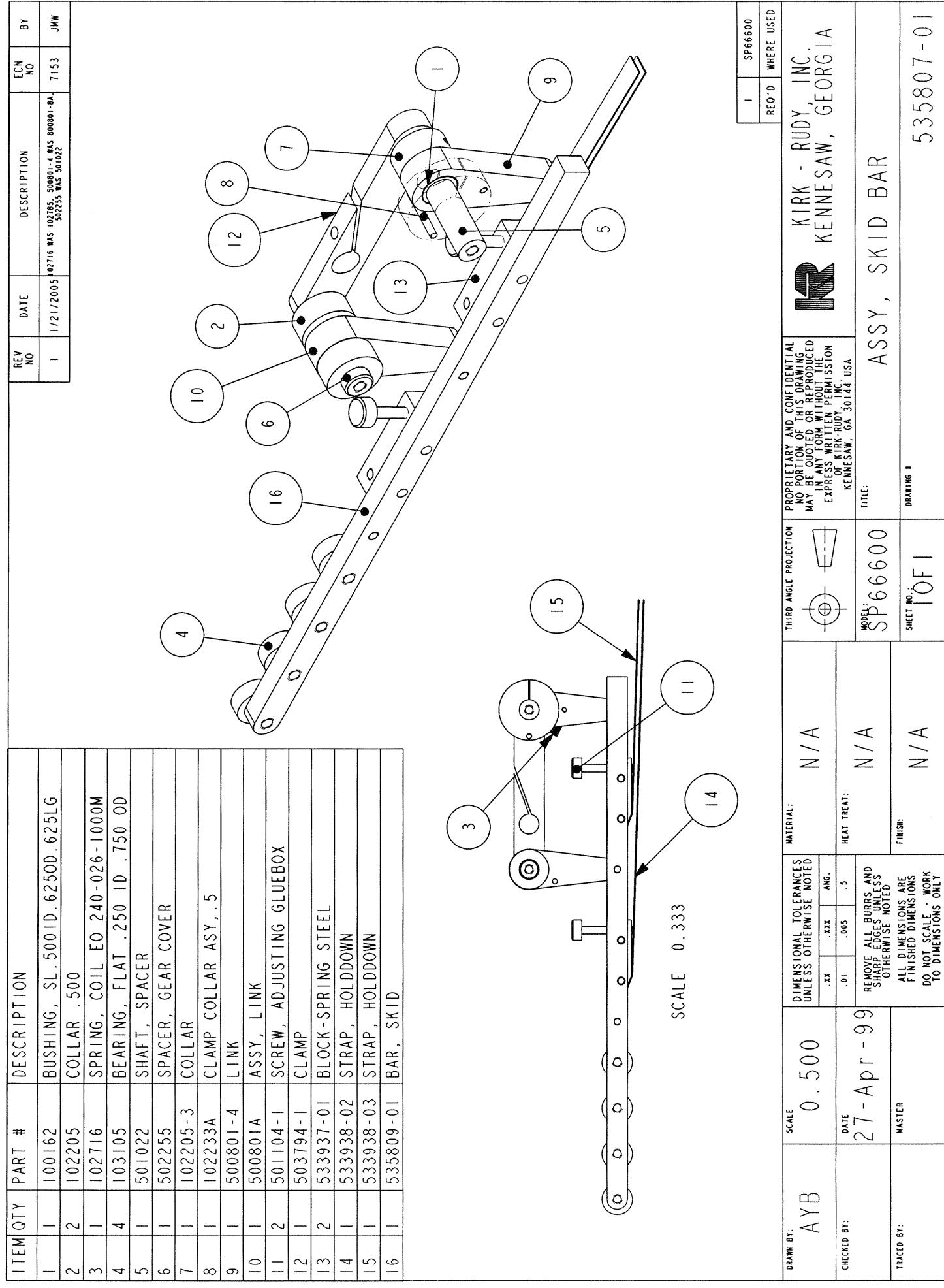


ASSY - SLEEVE

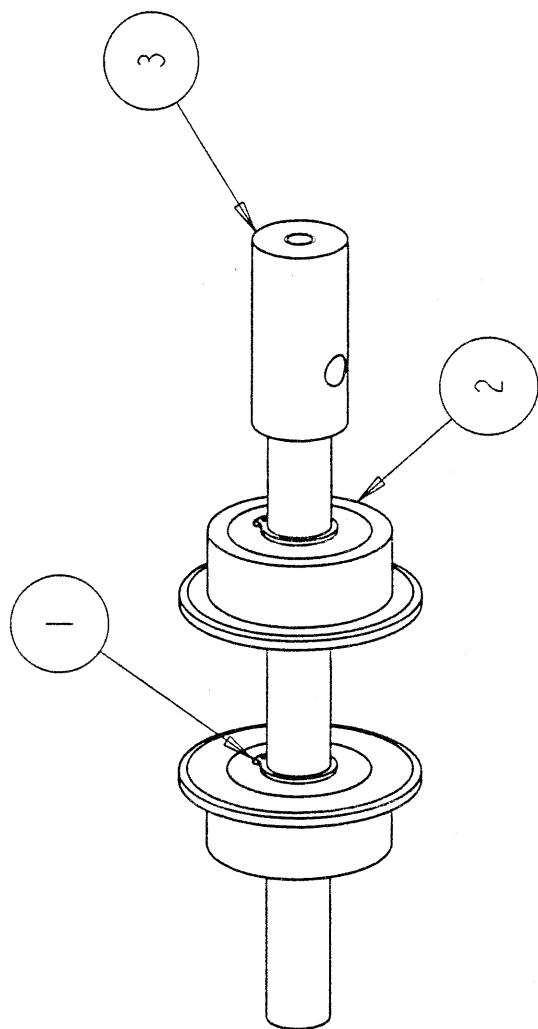
SP44701A

DRAWN BY: TVK	SCALE 0 . 750	MATERIAL: XXX	THIRD ANGLE PROJECTION
CHECKED BY: 23 - Feb - 99	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED .xx .xxx .005 .5	HEAT TREAT: XXX	NO. 1 TITLE:
TRACED BY: MASTER	REMOVE ALL BURRS AND SHARP EDGES UNLESS NOTED	FINISH: XXX	215 DRAWING #
	ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY	10F 1 SHEET NO.	

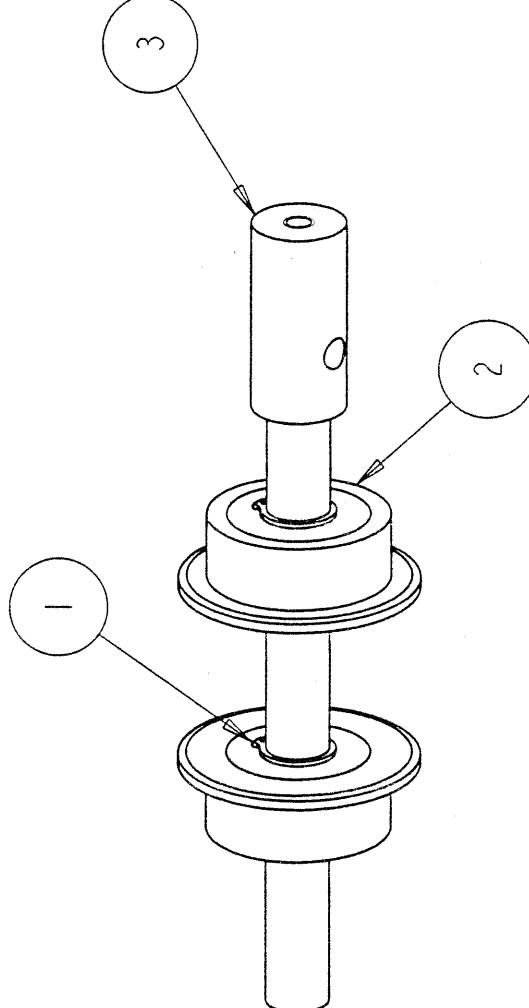
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1	100162	BUSHING, SL. 500 ID. 625 OD. 625 LG
2	102205	COLLAR .500
3	1	102716 SPRING, COIL EO 240-026-1000M
4	4	103105 BEARING, FLAT .250 ID .750 OD
5	1	501022 SHAFT, SPACER
6	1	502255 SPACER, GEAR COVER
7	1	102205-3 COLLAR
8	1	102233A CLAMP COLLAR ASY, .5
9	1	500801-4 LINK
10	1	500801A ASSY, LINK
11	2	501104-1 SCREW, ADJUSTING GLUEBOX
12	1	503794-1 CLAMP
13	2	533937-01 BLOCK- SPRING STEEL
14	1	533938-02 STRAP, HOLDDOWN
15	1	533938-03 STRAP, HOLDDOWN
16	1	5335809-01 BAR, SKID



ITEM	QTY	PART #	DESCRIPTION
1	4	104106	SNAPRING, .500
2	2	110108A	ASSY-IDLER SPROCKET
3	1	5353886-01	STUD IDLER



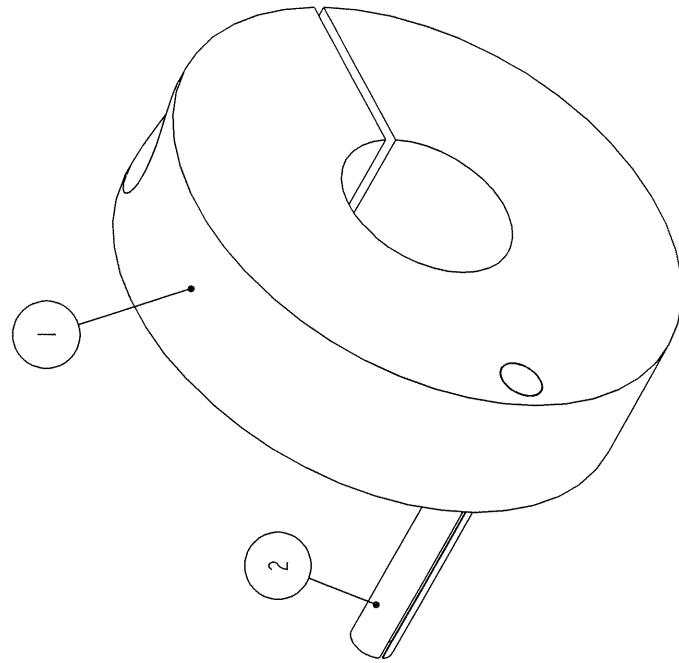
ITEM	QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	4	104106	SNAPRING, .500					
2	2	110108A	ASSY-IDLER SPROCKET					
3	1	535386-01	STUD-IDLER					



DRAWN BY:	TVK	SCALE	0 . 750	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED		MATERIAL:	XXX	THIRD ANGLE PROJECTION	PROPRIETARY AND CONFIDENTIAL NO POSITION ON THIS DRAWING MAY BE QUOTED OR REPRODUCED IN WHOLE OR IN PART EXCEPT WRITTEN PERMISSION OF KIRK-RUDY INC. KENNESAW, GA 30144 USA
CHECKED BY:		DATE	23 - Feb - 99	.01	.005	ANG.	.5	HEAT TREAT:	XXX
TRACED BY:		MASTER						NOTE:	SP 66600
								TIME:	ASSY-STUD AND IDLER SPROCKET
								SHEET NO:	1 OF 1
								DRAWING #:	535385-01

102233A

ITEM	QTY	PART #	DESCRIPTION
1	1	102233	CLAMP COLLAR, .5
2	1	105201	PIN, ROLL .125X 1.000

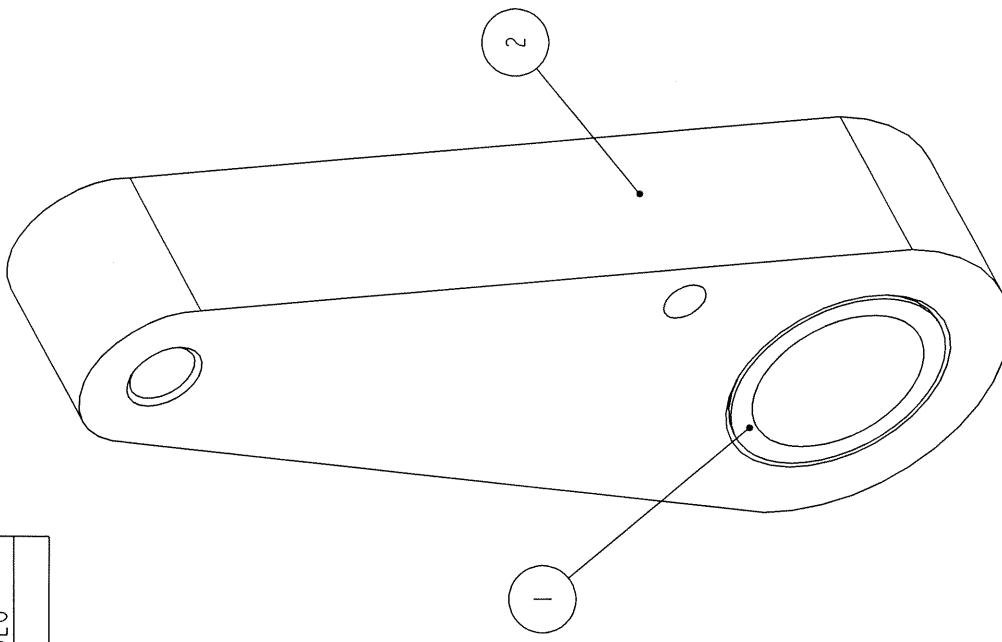


REV NO	DATE	DESCRIPTION	ECN NO	BY

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REQ'D	WHERE USED

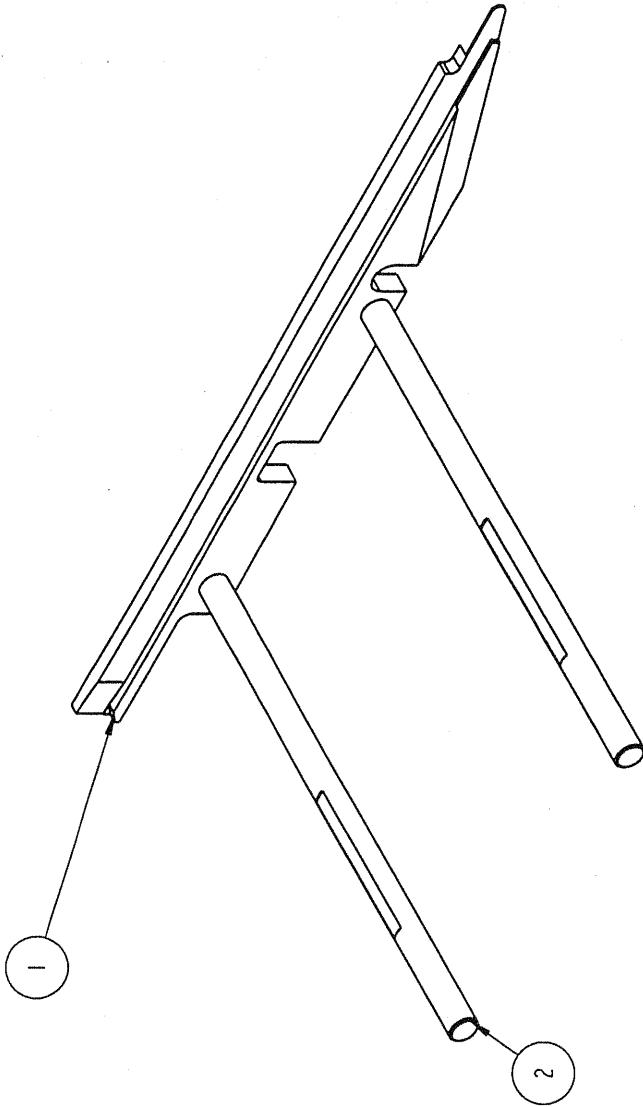
DRAWN BY:	SCALE	2 . 000	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	MATERIAL: XXX	THIRD ANGLE PROJECTION	PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE QUOTED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC. KENNESAW, GA 30144 USA
CHICKED BY:	DATE	.xx	.xxx	ANG.		
	18-May-98	.01	.005	.5	HEAT TREAT:	XXX
TRACED BY:	MASTER	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED		TINISH:	MODEL: 527	TITLE: CLAMP COLLAR ASY , 5
		ALL DIMENSIONS ARE FINISHED DIMENSIONS ARE DO NOT SCALE - WORK TO DIMENSIONS ONLY			SHEET NO. 0F1	DRAWING # 102233A

ITEM	QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	1	100162	BUSHING, SL. 500 ID. 625 OD. 625 LG					
2	1	500801	LINK-SKID-REAR					



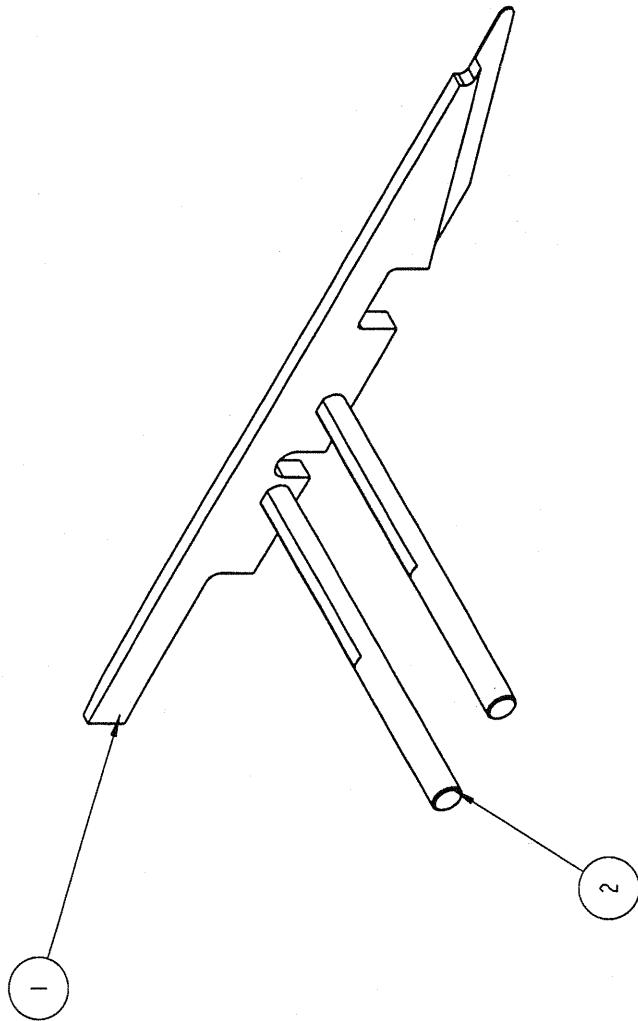
DRAWN BY:	SCALE	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED		MATERIAL:	THIRD ANGLE PROJECTION		PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE QUOTED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC. KENNESAW, GA 30144 USA	
MY	2 . 0 0 0	.xx	.xxx	N / A	HEAT TREAT:	N / A	KR	KIRK - RUDY, INC. KENNESAW, GEORGIA
CHECKED BY:	DATE	.01	.005	.5	MODEL:	215	TITLE:	
	18-May-98	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED					ASSY, LINK	
TRACED BY:	MASTER	ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY			SHEET NO:	10F	DRAWING #	500801A
REO'D WHERE USED								

ITEM QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	1	536052-01 BAR, PRODUCT GUIDE LH					
2	2	536055-01 SHAFT, SIDE RAIL MOUNT					



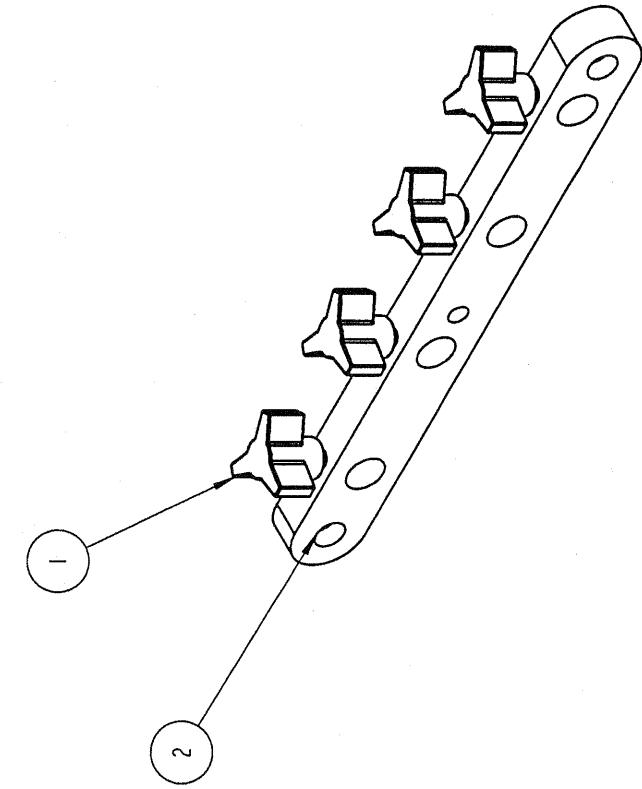
1	SP66600
REQ'D	WHERE USED
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PROPRIETARY AND CONFIDENTIAL THIS DRAWING MAY NOT BE COPIED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, KENNE-SAW, USA 30444 USA	
SCALE: 0 . 375	THIRD ANGLE PROJECTION
DRAWN BY: T JG	MATERIAL: XXX
DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	
.01 .005 .5	HEAT TREAT: XXX
DATE: 10 - May - 99	FINISH: XXX
CHECKED BY:	REMOVED ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED
MASTER	ALL DIMENSIONS ARE IN INCHES
TRACED BY: m	DO NOT SCALE - WORK TO DIMENSIONS ONLY
SHEET NO. 1 OF 1	DRAWINGS #
ASSY, SIDE GUIDE LUG LH	
536053-01	

ITEM	QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	1	536052-02	BAR, PRODUCT GUIDE RH					
2	2	536055-02	SHAFT, SIDE RAIL MOUNT					



DRAWN BY:		SCALE	0 . 375	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED			MATERIAL:	THIRD ANGLE PROJECTION	PROPRIETARY AND CONFIDENTIAL DRAWING OF THE DESIGNER 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 - May - 99	.xx	.01	.005	ANG.		KIRK - RUDY, INC. KENNESAW, GEORGIA
TRACED BY:		MASTER	m	HEAT TREAT:			XXX		ASSY , SIDE GUIDE LUG RH
REMOVED ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED		FINISH:	XXX			FINISH:	XXX	SHEET NO. 1 OF 1	DRAWING # 536053-02
ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY									

ITEM	QTY	PART #	DESCRIPTION
1	4	102117	KNOB
2	1	536054-01	BAR, GUIDE MOUNT



ITEM	QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	4	102117	KNOB					
2	1	536054-01	BAR, GUIDE MOUNT					

DRAWN BY:	T JG	SCALE:	0 . 500	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED		MATERIAL:	X X X	THIRD ANGLE PROJECTION	PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE COPIED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY INC. KENNESAW, GA 30144 USA	
CHECKED BY:		DATE:	10 - May - 99	.01	.005	ANG.	.5	HEAT TREAT:	X X X	TITLE:
TRACED BY:		MASTER:	M	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED		FINISH:		NOTE:	SP 66600	DRAWING #
				ALL DIMENSIONS ARE IN INCHES		DO NOT SCALE - WORK TO DIMENSIONS ONLY		SHEET NO:	OF 1	536056-01

9 APPENDIX

- 7.1 Electrical schematics
KR 486 head
- 7.2 Hot melt operation and maintenance manual
- 7.3 Vacuum pump operation and maintenance manual
- 7.4 Motor control board technical manual

10 NOTES

11 WARRANTY AND SERVICE

WARRANTY

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

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

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

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

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