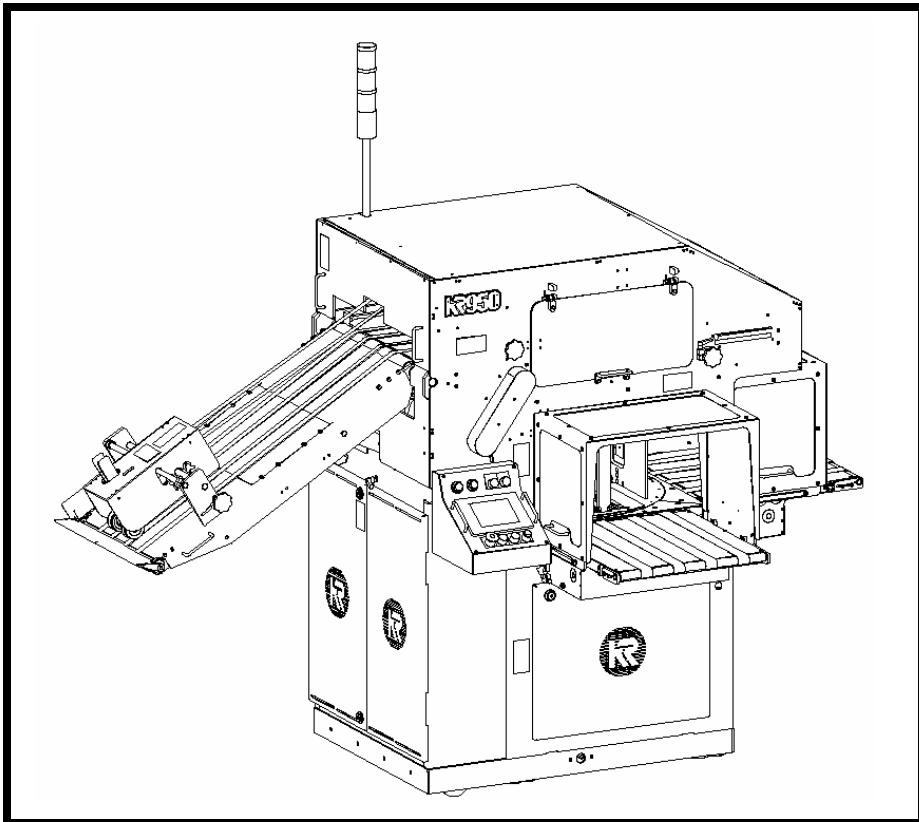


Kirk-Rudy, Inc.

**Instruction
and Parts Manual**

**KR950 Compensating
Stacker**



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.

TABLE OF CONTENTS

<u>SECTION</u>	<u>DESCRIPTION</u>	<u>PAGE</u>
1	IMPORTANT SAFETY INSTRUCTIONS	6
2	SPECIFICATIONS	7
3	INSTALLATION	8-10
3.1	UNCRATING	8
3.2	MACHINE INSTALLATION	8-9
3.3	ELECTRICAL CONNECTIONS	10-11
4	MACHINE DESCRIPTION	12-38
4.1	MECHANICAL COMPONENT DESCRIPTION	12
1.	Divert Gate	12
2.	Ramp/Infeed Conveyor	12
3.	Upper and Lower Static Bar Mounting	12
4.	Infeed Beam Switch (PE)	12
5.	Infeed Belt Rollers	12
6.	Disher	12-13
7.	Blow Down Nozzles	13
8.	Top Belt Idler	13
9.	Stack Beam Switch (PE)	13
10.	Side Joggers	13
11.	Front and Back Guides	13
12.	Fingers	13-14
13.	Tool Trays	14
14.	Turntable	14
15.	Drop Table	14
16.	Storage Area	14
17.	Turntable Side Guides	14
18.	Guide Rods	14-15
19.	Product Pusher	15
20.	Turntable Skid Bar	15
21.	Discharge Conveyor	15
22.	Safety Switches	15
23.	Air Regulator	15
24.	Leg Screws	15
25.	Hydra-lift Kit	15
26.	Horizontal Adjustment Assembly	16
4.2.	ELECTRICAL COMPONET DESCRIPTION	16
4.2.1	Main Control Panel and Push Button Station	16
1.	E-Stop Pushbutton	16
2.	Power Pushbutton	16
3.	Start Pushbutton	16
4.	Stop Pushbutton	16
5.	Open Fingers	16
6.	Cycle Machine	16

TABLE OF CONTENTS

<u>SECTION</u>	<u>DESCRIPTION</u>	<u>PAGE</u>
	7. Infeed Speed Pot	16
	8. Discharge Speed Pot	16
4.2.2	Remote Pushbutton Station	17
4.2.3	Discharge Congeyor	17
	1. Discharge Power	17
	2. Discharge Enable	17
	3. Discharge Conveyor Beam Switch (PE)	17
4.2.4	Machine Light Tower Description	17
4.3	TOUCH SCREEN INTERFACE	17-33
	4.3.1 Touch Screen Overview	17
	4.3.2 Touch Screen Data Entry Terminology	18
	4.3.3 Password and Non Password Screens	18
	TOUCH SCREEN MAP	19
	4.3.4 Main Screen	20
	4.3.5 Operator Screen	20-22
	4.3.6 Manual Screen	22-24
	4.3.7 Status Screen	24-25
	4.3.8 Password Screen	25
	4.3.9 General Setup	25-26
	4.3.10 Finger Setup Screen	27-28
	4.3.11 Table Setup Screen 1	28-29
	4.3.12 Table Setup Screen 2	29-30
	4.3.13 Discharge Setup Screen	30
	4.3.14 Diagnostic Screen	31-32
	4.3.15 I/O Screens	32-33
	4.3.16 Miscellaneous	33
	4.3.17 Clock Screen	33
4.4	COMPENSATING AND DISCHARGING	34-38
	4.4.1 Methods of Compensating Bundles and Discharging Stacks	34
	4.4.2 Minimum Stack Size	34
	4.4.3 Compensating Batches and Discharging Stacks by Count	34-35
	4.4.4 Remote Sort	35
	4.4.5 Over Stacking	35
	4.4.6 Compensating Batches and Discharging Stacks by Remote Sort	35-36
	4.4.7 Compensating Batches by Count and Discharging Stacks by Remote Sort	36-37
	4.4.8 Moving the Infeed Beam Switch to an Upstream Machine	37-38
	44.9 Reset Machine	38
44.10	Infeed Count Auto Reset	38

TABLE OF CONTENTS

<u>SECTION</u>	<u>DESCRIPTION</u>	<u>PAGE</u>
5	MAKE READY INSTRUCTIONS	39
	5.1 INTRODUCTION	39
	5.2 MAKE READY PROCEDURE	39-57
6	OPERATION	58
	6.1 INTRODUCTION	58
	6.2 CONTROLS	58
	6.3 PRESTART CHECKS	58
	6.4 START-UP	58-59
	6.5 FINE TUNING	59
	6.5.1 Infeed Belt Speed	59-60
	6.5.2 Product Dishing Rollers	60
	6.5.3 Blow-Down Air	60
	6.5.4 Pusher Speed	60-62
	6.5.5 Discharge Conveyor Belt Speed	63
	6.6 CLEARING A JAM	63
	6.7 TROUBLE SHOOTING	64
7	MAINTENANCE	65-66
8	PARTS LISTS AND DIAGRAMS	67
	8.1 PARTS LIST	67
	8.2 DIAGRAMS	67-69
9	ELECTRICAL SCHMATICS AND PARTS	71
	9.1 SCHEMATIC LIST	71
	9.2 ELECTRICAL PARTS LIST	71
10	APPENDIX	72
	Recommended Spare Parts List	
	Infeed Belt Path Diagram	
	Outfeed Belt Path Diagram	
	Outfeed Belt Path Diagram with Justifier	
	Turn Table Pneumatic Schematic	
	Electrical Box Pneumatic Schematic	
	KR950 Options	
	Supplied Side Guide Dimensions	
	Upper Belt Assembly Reference Dimensions	
	Infeed Belt Take Up Assembly Reference Dimensions	
	KR950 Brochure	
	KR950 Functional Description	

TABLE OF CONTENTS

<u>SECTION</u>	<u>DESCRIPTION</u>	<u>PAGE</u>
11	CROSS REFERENCE PART AND ASSEMBLY INDEX	75
11.1	PART DESCRIPTION AND NUMBER INDEX	75-96
11.2	ASSEMBLY INDEX LIST	96-114
12	NOTES	115
13	WARRANTY AND SERVICE INFORMATION	116

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

1 Important Safety Instructions

Intended Use Statement: The KR950 Compensating Stacker is designed to be used inline with other equipment. The machine stacks product being fed to it by an upstream machine and discharges the stacked product right, left or strait out. Stacks can be made up of self-initiated counts or slaved to a signal input from the upstream machine. While the machine is stacking, uneven products can be compensated 180 degrees into smaller batches to form a stable stack before discharging. Stacks can be broken up according to zip code with the KR Town Sort option. A divert gate is mounted on the infeed end of the stacker allowing products to be diverted as necessary before entering the stacker. 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.

KR950

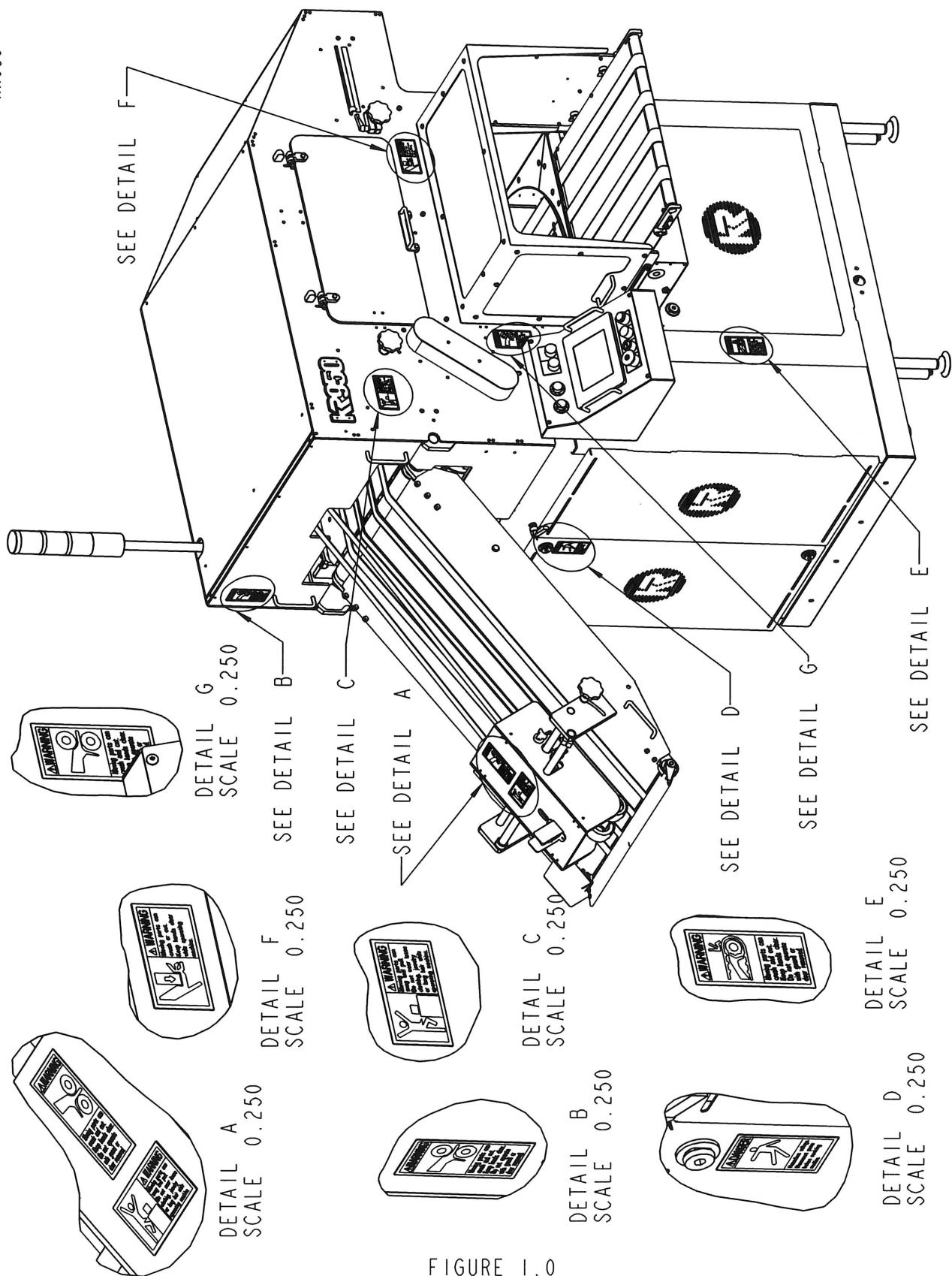


FIGURE 1.0

KR950

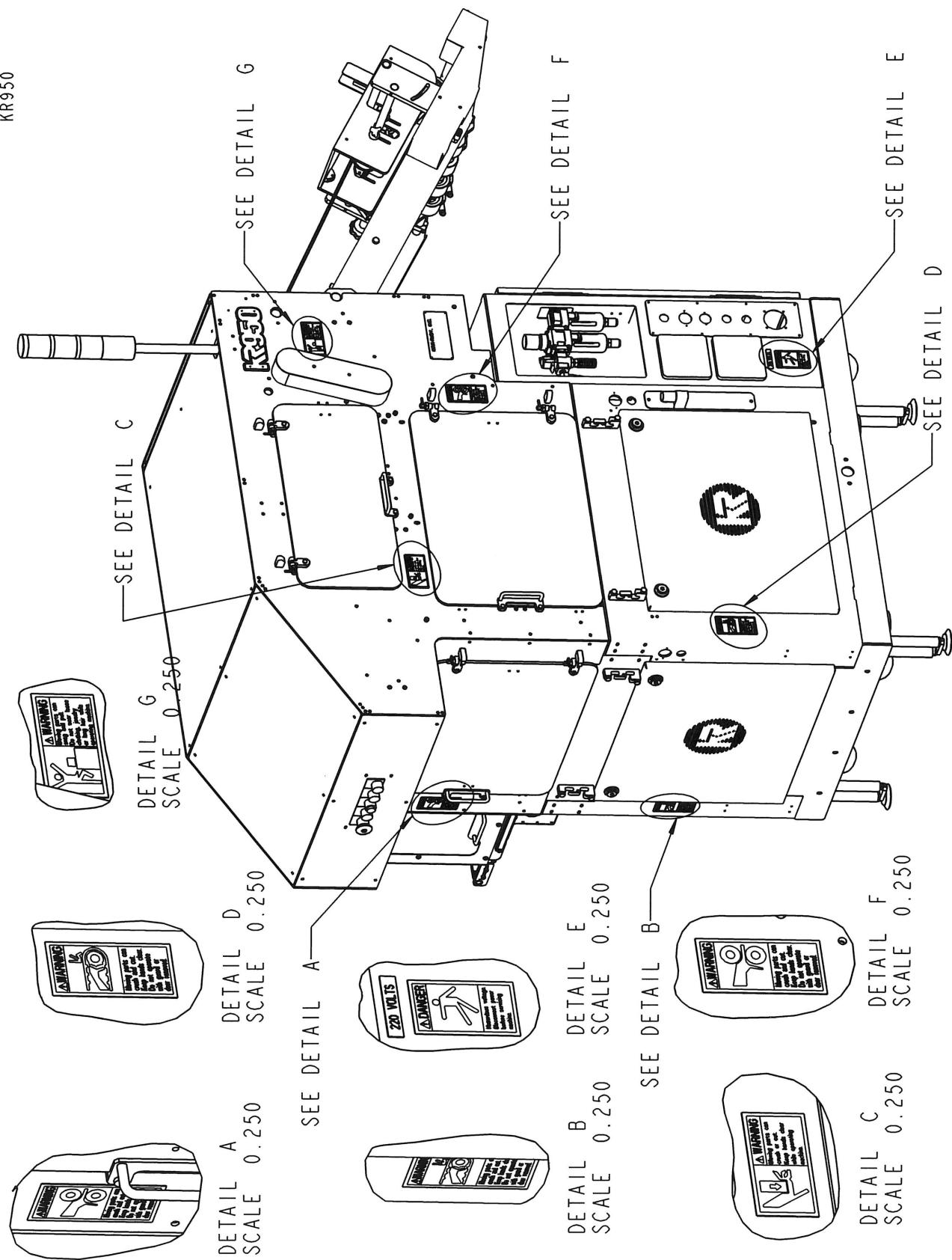
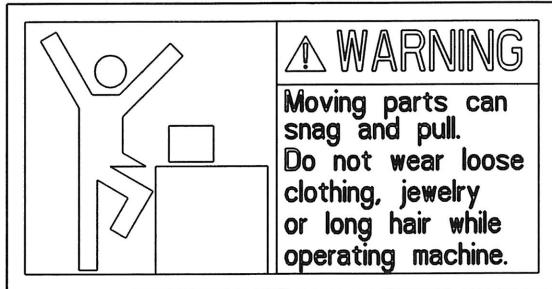
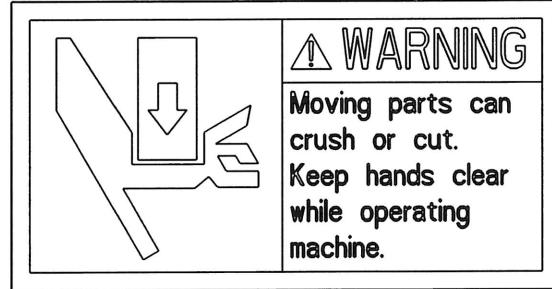
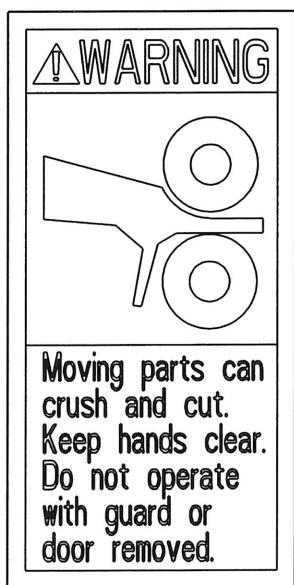
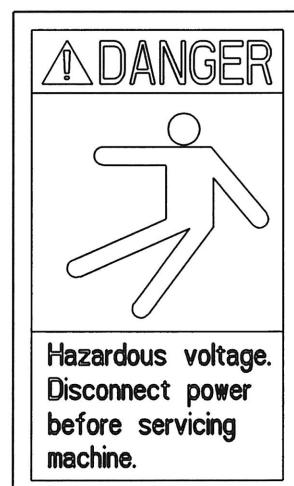
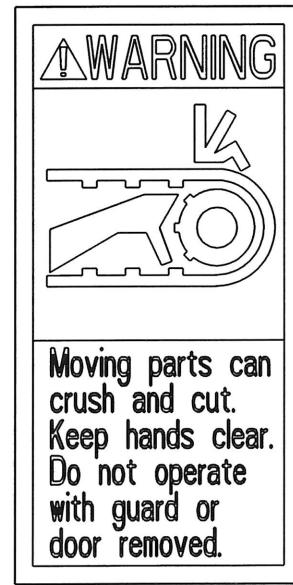
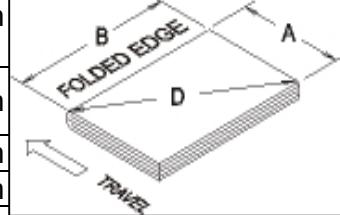


FIGURE 2.0

LOOSE CLOTHES
WARNING LABELCRUSH
WARNING LABELROLLER
WARNING LABELELECTRICAL SHOCK
WARNING LABELDRIVE TRAIN
WARNING LABEL

2 SPECIFICATIONS

Maximum Speed (Product Dependant) Speed tested using a 11" x 14" Newspaper	18,500+ copies/hour, 770+ bundles/hour (12 copies/batch, 24 pieces total, compensated once) 514'/minute @ 20" spacing		
Maximum/Minimum "A" Folded Edge Leading	18.0" / 6"	460mm/152mm	
Maximum/Minimum "B" Folded Edge Leading	18.0" / 4.5"	460mm/114mm	
Maximum/Minimum "A" Folded Edge w/Flow	18.0" / 4.5"	460mm/114mm	
Maximum/Minimum "B" Folded Edge w/Flow	18.0" / 6"	460mm/152mm	
Minimum "D"	Limited by "A" and "B"		
Maximum "D"	25.5"	648mm	
Minimum Product Thickness	.07"	1.8mm	
Maximum Product Thickness	2.5"	64mm	
Maximum Batch Height	14"	356mm	
Maximum Stack Height	14"	356mm	
Maximum Batch Count	150 batches/bundle		
Maximum Stack Count	999 copies/bundle		
Product Orientation	Direct, folded-edge leading / Folded edge with flow		
Product Alignment	Leading edge perpendicular to stream centerline (+ -) 5 degrees		
Stream Off-Center Condition	(+ -) .25"	(+ -) 6mm	
Discharge Direction	Left, Right, Straight, Alternating, 90 Degree Exit		
Infeed Belt Height	30.0" - 42.0"	762mm-1067mm	
Outfeed Belt Height	33.0" - 37.0"	838mm-940mm	
Electrical Requirements	220 VAC, 1 phase, 30 Amps, 50/60 Hz		
Air Requirements	3 cfm		
Operating Air Pressure	80-100 psi		
Physical Size	See Figure 4.0		
Weight	? Lbs.		
Options	Base Hydralift		
	Multiple Discharge Conveyors		
	Speed Following		
	Townsort Interface		
	Upper and Lower Static Bar Mounting		
	Inline Product Justification Adjustment		
	Inline Product Justification Hydralift		
	Discharge Conveyor Extender		
	Discharge Conveyor Photo Eye		

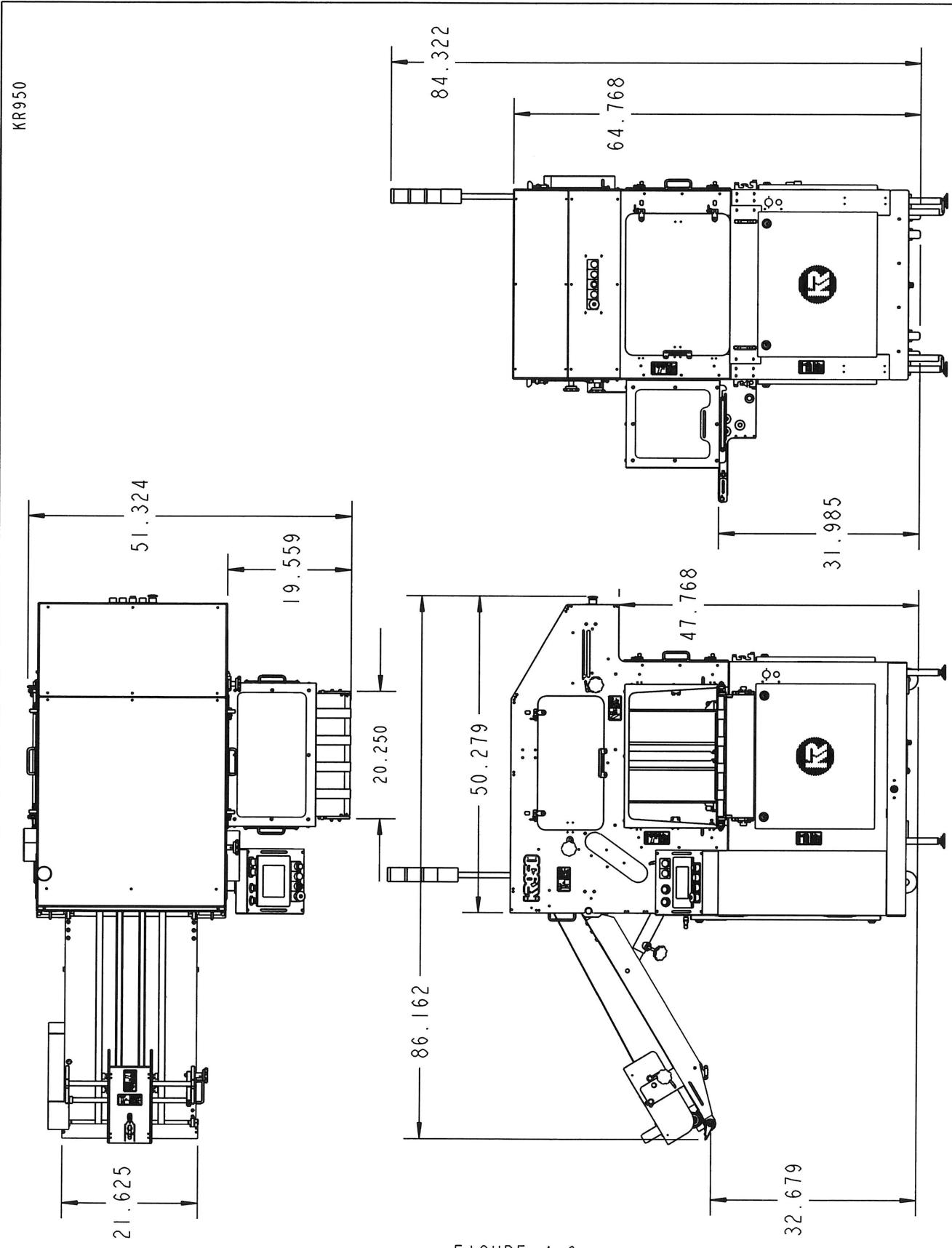


FIGURE 4.0

KR950

MAIN POWER AND AIR INPUT

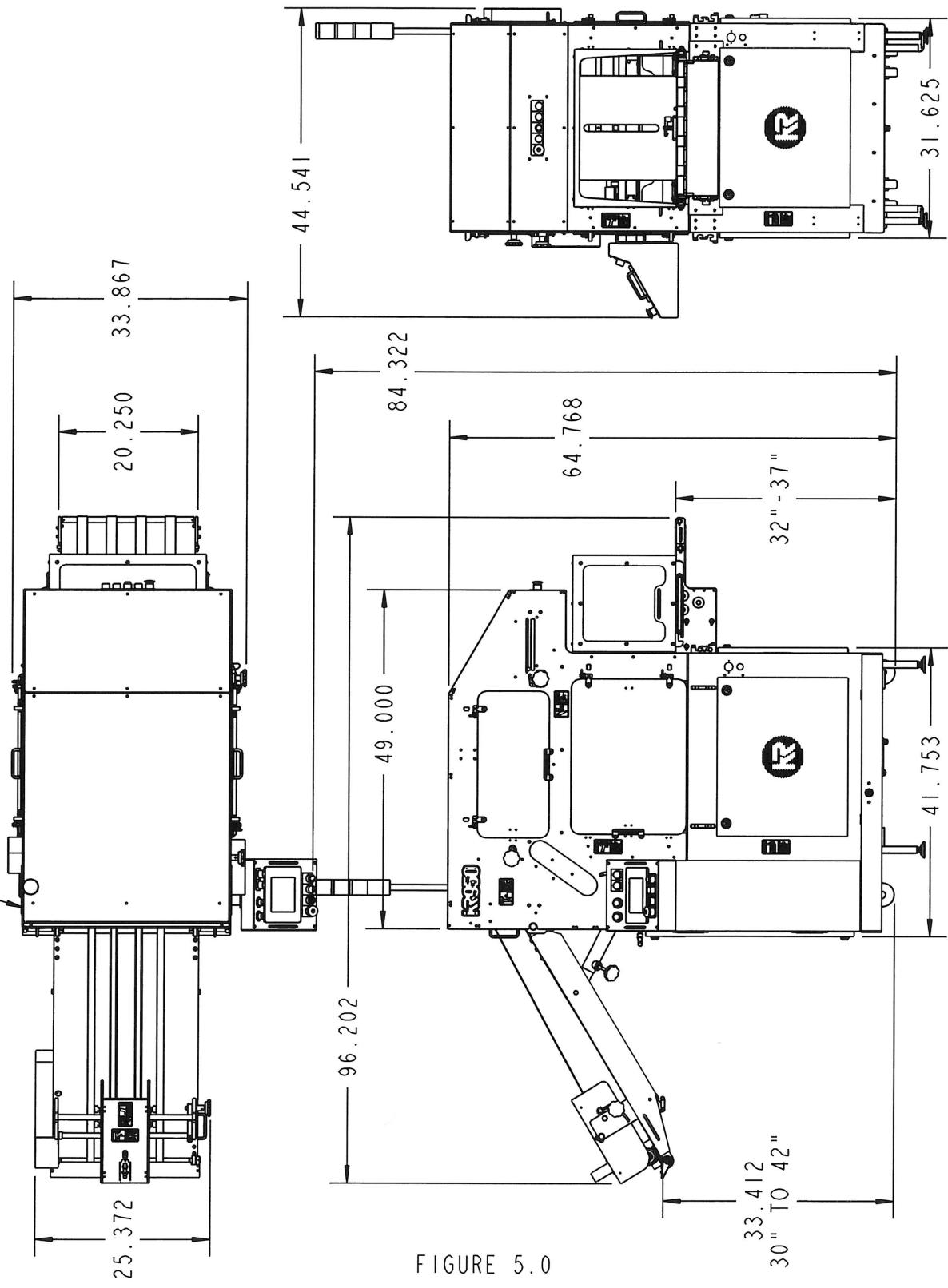


FIGURE 5.0

3 INSTALLATION



WARNING

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

3.1 UNCRATING

WARNING: To reduce the possibility of injury, all packing material should be properly disposed of or stored at the time of removal.

1. Position crate in a suitable open area.

NOTE: The machine is on casters and can be rolled in place if the installation site is on the same level.

2. Remove crate top and sides.
3. Remove metal strapping and securing blocks.
4. Locate accessories box and use checklist to verify all items were shipped.

NOTE: Some boxes may be located inside the base cabinet.

5. Use a forklift to lift machine off skid. Be sure to position the forks in a centrally located position.
6. Roll or forklift the machine to the installation site.

3.2 MACHINE INSTALLATION

1. Position the machine in line with the other machines that make up the process in an area that will allow ample room for working and a clear path for the flow of material to and from the machine area. Normally, the machines are lined up to center the flow of product on the equipment but can be offset as necessary.

CAUTION: Gaps between the machines should be kept to a minimal distance but care should be taken to ensure the moving parts of each machine have adequate clearance before starting up the machines.

2. Position the aluminum pads below the leveling legs, loosen the nuts and hand screw the leveling legs down to where the point of the leveling legs make contact with the dimple in the pads. After contact is made with all the pads, turn each leveling leg the exact same number of turns. This procedure will keep the weight distribution even on all the pads. Level the machine if necessary. Check to make sure all leveling legs are weight bearing.

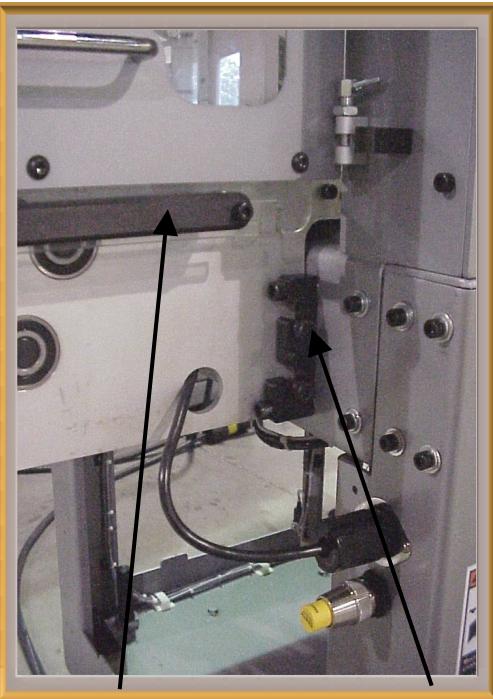
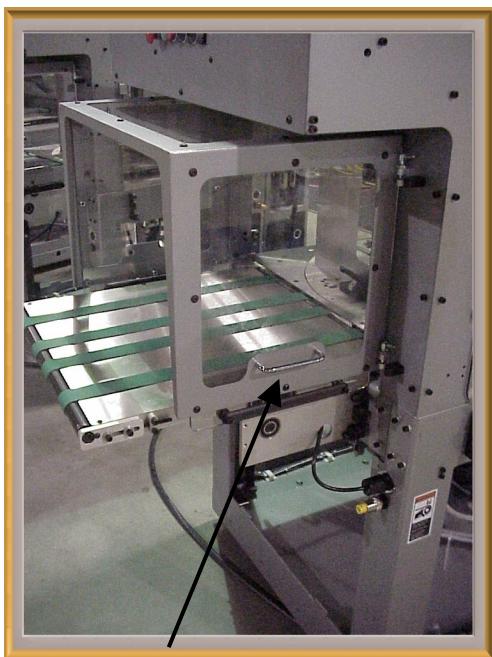
3. Adjust infeed conveyor height to upstream machine outfeed height.



Infeed Conveyor Height Adjustment Lock Knob

When loosening the conveyor height adjustment lock knob be sure to have the conveyor handle in your other hand to prevent the conveyor from falling unexpectedly. The conveyor top support has a gas spring to aid in lifting the conveyor top for quick and easy infeed height adjustments.

4. Mount discharge conveyor on the side desired to discharge the stacked product. A discharge conveyor can be mounted in either of three different locations – left, right or strait out. To make it easy to mount, two shoulder bolts on the side of the discharge conveyor hook into brackets. After mounting the discharge conveyor onto the brackets, screw a $\frac{1}{4}$ -20 bolt in the hole between the shoulder bolts to make sure the discharge conveyor stays in position. Up to three different discharge conveyors can be used in any configuration.



Slide the tunnel cover off and set aside to move the discharge conveyor from one location to another.

Use the cover mount as handles to easily move the conveyor.

One screw on each side of the conveyor is used to hold the conveyor in place.

3.3 ELECTRICAL CONNECTIONS (see Figure 6.0)



WARNING

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

CAUTION: Ensure cables and power cords are grouped and tied together neatly and properly secured or guarded. Check to see that all preventive measures are taken to prevent damage to the machine or personal harm from tripping over or getting entangled in the wires during operation or maintenance of the machines.

1. **Main Disconnect:** The power cord is plugged into the main disconnect which is located on e-box (electrical Box) on the left side of the machine. For locking the machine out, remove power cord and place a lock through the hole on the receptacle.
2. **Machine Stop In Receptacle:** A two-pin Turck female receptacle marked "Stop In" is located above the power receptacle on the e-box. The receptacles serve the purpose of providing a connection point to stop the machine remotely.
3. **Machine Stop Out:** A two pin male Turck male receptacle located on the e-box. This will deactivate when the machine is not in run mode.
4. **Discharge Power:** A three-pin twist female receptacle supplies DC power to the discharge conveyor motor for each discharge station. After mounting the discharge conveyor to a station, plug the power cord to the discharge conveyor motor into the applicable receptacle.

5. Discharge Enable: A two-pin Turck female receptacle allows interface with the machine PLC to allow product to be discharged onto that conveyor. Either an optional discharge beam switch (PE) or a shorting plug must be plugged into every discharge enable receptacle for the stacker to run.
6. Comp/Sort: A five-pin male beam switch type quick disconnect receptacle is provided for the comp/sort cable. A male three-pin molex connector is normally attached to other end of the comp/sort cable to provide a connector for remote sort purposes.

NOTE: In order to run the machine, the stop circuit must be a closed circuit. If the Stop In receptacle is left open, a jumper plug must be connected to the open stop receptacle in order to complete the stop circuit.

KR950

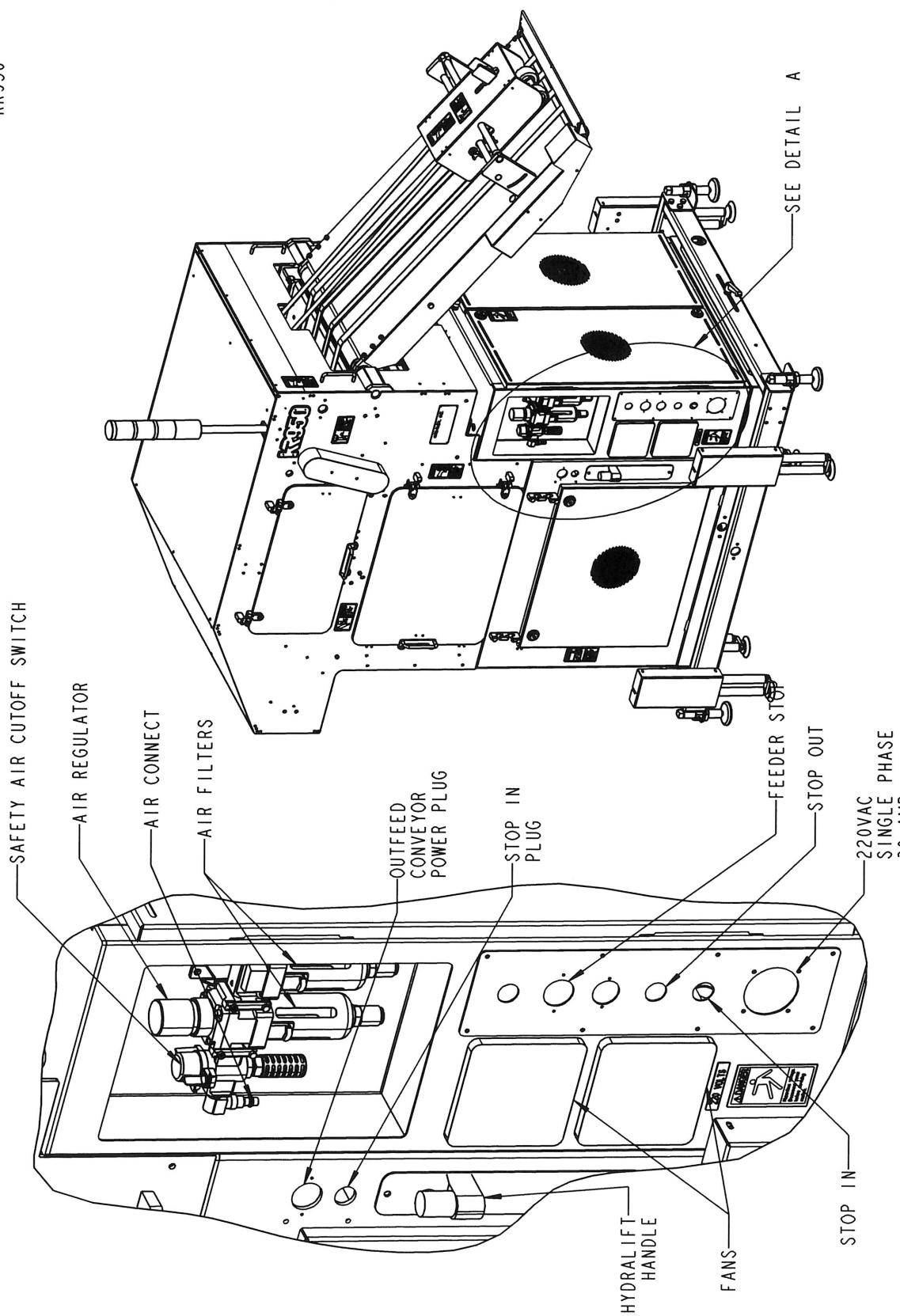


FIGURE 6.0

4 MACHINE DESCRIPTION



WARNING

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

4.1 MECHANICAL COMPONENT DESCRIPTION

4.1.1 Base Component Description (see Figures 7.0 through 14.0)

- 1. Divert Gate:** An electrically activated air cylinder controls the divert gate located on the infeed end of the ramp. A small air regular mounted under the ramp provides control of the air pressure to the divert air cylinder (normally set at 45 psi). The divert gate can be used to divert stacks that are undersized for normal continuous operation of the compensating stacker or products that do not complement a stack such as an inkjet purge. A slot is cut on the leading edge of the divert gate to mark the center of the machine for ease of alignment with upstream equipment. If the Infeed PE is relocated in front of the divert gate, the divert gate cannot be used when using the remote sort and remote batch functions.
- 2. Ramp/Infeed Conveyor:** Upper and lower belts transport product up an incline then over a flat tabletop and into the stacker. The incline tabletop is the ramp and the flat tabletop is the infeed conveyor. The ramp has a spring assisted telescoping arm with a locking knob to adjust and hold the height of the infeed end of the ramp. A single motor drives both upper and lower sets of belts used to convey the product. The speed control for the motor is on the control panel. As an option, the speed control for the ramp/infeed conveyor can be wired for speed following.
- 3. Upper and Lower Static Bar Mounting:** As an option, brackets used for mounting vendor supplied static bars can be mounted to the sides of the ramp to bridge over and under the ramp. When static bars are installed on the brackets, a plate is removed from the center of the ramp to provide a large hole in the ramp. This hole allows the charge to flow thru the product between the static charge bars as it travels up the ramp.
- 4. Infeed Beam Switch (PE):** The infeed beam switch is normally located at the beginning of the ramp and is used as a jam detector. The touch screen can be used to change the functions of the infeed beam switch. When remote sort is turned on using the touch screen, the infeed beam switch works in conjunction with the stack beam switch to track product on the ramp/infeed conveyor. In some remote sort operations, the beam switch is moved from the beginning of the ramp to a location on the upstream machine in which case the touch screen is used to turn off the jam detector feature.
- 5. Infeed Belt Rollers:** Located at the beginning of the ramp, the upper belt rollers are adjustable for the thickness of the product. An arm/knob assembly on the right side of the ramp is used to make and hold the adjustment.
- 6. Disher:** Located on the infeed conveyor, the disher consists of flat bearings mounted on two arms located just outside of the upper belts. The arms can be raised or lowered using an adjustment knob located on the right side of the infeed

conveyor. The disher is used with light and flimsy product. While the upper belts are holding down the center of the product, the arms of the disher can be raised to curl the sides of the product to form a U shape. The U shape stiffens the product laterally helping the product to fully enter the stacker without folding over.

7. **Blow Down Nozzles:** Two blow down nozzles can be used when necessary to help control product entering the stacker. They can be adjusted together or independently. The flex tube nozzles allow control of the direction and a valve allows for control of the amount of air being used. Opening the valve on the flex tube nozzles bleeds air that is used to operate the air cylinders on the machine. If too much air is bled off, the machine will stop operation. The air should be turned off when not needed.
8. **Top Belt Idler:** In addition to the infeed belt rollers, a second set of adjustable idler rollers for the upper belts are located above the infeed conveyor. An arm/knob assembly on the upper right side of the machine is used to make and hold the adjustment thickness of the product.
9. **Stack Beam Switch (PE):** Located above the infeed conveyor, the stack beam switch counts product entering the stacker. It is also used as a jam detector.
10. **Side Joggers:** Along with the front and back guides, the side joggers are used to guide the product as it enters the upper area of the stacker from the infeed conveyor and keep the product in the center of the stacker while it remains in the upper area of the stacker. The additional small in and out movement of the joggers while the machine is running help create a better stack alignment of the product. An adjustment wheel, marked in fraction of inches, and a locking handle are located just inside the upper door on the right side of the stacker. The adjustment wheel is used to set the width between the side joggers and the side joggers move in unison to stay equal distance from the center of the machine as the adjustment wheel is turned. Three different size sets of side jogger plates come with the machine.
11. **Front and Back Guides:** Along with the side joggers, the front and back guides are also used to guide the product as it enters the upper area of the stacker from the infeed conveyor and keep it in the center of the stacker while the product remains in the upper area of the stacker. An additional back and forth rocking movement of the front guides while the machine is running helps create a better stack alignment of the product. An adjust knob, with a locking lever, extends outside of the machine to the right of the upper right door for ease of adjustment for the guides. When you turn the knob, the guides will move in and out in unison to stay equal distance from the center of the stacking area. The front sensors are attached to the infeed conveyor table and the knob actually moves the infeed table in and out to position the front guides. A product length guide adjustment indicator to the right of the adjustment knob shows the distance between the guides in fractions of inches.
12. **Fingers:** Operated by an air cylinder, the fingers move in to catch and hold product in the upper section of stacker. They move out to release product to the drop table in the lower section of the stacker. A sensor located at each end of the air cylinder signals when the fingers are fully open or fully closed. During operation, the fingers never move out to the full open position. A sensor mounted on the side of the infeed conveyor near the rear guides is used to shorten the travel of the

fingers so that the fingers do not open to the full open position but only open to the extent that they clear the front and back guides. This sensor is mounted in such a way that it is automatically adjusted when the guides are repositioned. Another manually adjustable sensor can be used to stop the fingers at a staged stop position leaving them partially open when they are in the closed position. The staged closed position can be used when the product is stiff enough to bridge the gap left between the fingers. Using this sensor shortens the finger travel and thus the time required to cycle the fingers. Using the combination of sensors, the fingers can be programmed using the options provided on the touch screen to operate in several modes. Fingers can be unscrewed and removed as necessary when they interfere with the positioning of the longer side joggers.

- 13. Tool Trays:** Tool trays are provided inside the upper stacker area on both sides of the machine. The tool trays are used to store unused staging fingers and tools for adjustment of the machine.
- 14. Turntable:** A turntable is used to rotate the product for compensation and discharge and is the heart of the compensating stacker. The turntable is belt driven and precisely powered by a servomotor. Sensors mounted in the cabinet under the turntable provide for homing the turntable and confirming discharge positions during operation. The homing process provides for a known start point for turntable operation. The drop table, guide rods, product pusher and the air cylinders that drive these devices are mounted on the turntable to control stacking and discharging product. Large side guides are also mounted on the turntable to keep the product centered as it is rotated and lowered for compensation and discharge.
- 15. Drop Table:** An air cylinder powers a drop table that is used to control the height of the stack in the lower section of the stacker and lower a completed stack to the bottom for discharge. The air cylinder has sensors that signal when the drop table is fully up or fully down. Lowering the drop table other than fully down is accomplished through timing. Using the touch screen, it can be programmed to drop in several modes. Two different size sets of outer plates come with the machine and can be screwed on either side of the drop table to increase its width when necessary.
- 16. Storage Area:** There is a storage area located in the lower section of the stacker for storage of the spare outer plates for the drop table.
- 17. Turntable Side Guides:** Large side guides are mounted on the turntable to keep the product centered on the turntable as it is rotated and lowered for compensation and discharge. Bolts with leverage handles are used to secure the guides in place. The side guides are adjusted for the size of the product during setup. Each side guide has a scale to ensure quick and accurate placement of the guides.
- 18. Guide Rods:** The pneumatically powered guide rods extend upwards from the turntable from individual air cylinders. The air cylinder rod is actually the guide rod. They are controlled in unison. The guide rods help gather and hold the stack on the drop table. They are positioned and set to the size of the product during set up. A slot with an adjacent scale marked in fractions of an inch allows quick and precise adjustment. The rods drop below the turntable when the drop table lowers the stack for discharge; then, return to the up position to start the next cycle. A sensor on each end of the guide rod air cylinders signal when the guide rods are up

or down. The guide rods can be turned off using the touch screen. When off the guide rods will stay in the full down position during operation of the stacker.

19. **Product Pusher:** The product pusher is a vertical bar that pushes the product off of the turntable during the discharge cycle. The product pusher is driven by an air cylinder mounted on the bottom of the turntable. A sensor on each end of the air cylinder signals when the pusher is at the end of the air cylinder. Two additional sensors are mounted on the guide rod assemblies below the turntable. The sensors on the guide rod assemblies are automatically set to the size of the product when you set the guide rods. On cycles where the pushrod returns to a staged position after discharge, the sensor on the guide rod nearest the staging end of the turntable signals the end of the discharge cycle when the pushrod passes the guide rod. The speed of the air cylinder can be controlled by adjusting the air flow screws on the cylinder. A tuner function is provided on the touch screen for precise adjustment of the air flow screws.
20. **Turntable Skid Bar:** The turntable skid bar consists of flat bearings mounted on an angled metal bar. Two of these bearing mounted bars are screwed to the turntable to form a channel for the product pusher. The skid bar supports the center of the product laterally to allow the pusher to push the product off the turntable without damaging the product.
21. **Discharge Conveyor:** The discharge conveyor delivers the stacked product to down stream machines such as a strapper. The discharge conveyor is easily moved to one of three outfeed locations. As an option, additional discharge conveyors can be installed on two or all three outfeed stations at the same time. However, an additional motor board must be added for each additional discharge conveyor. Discharge conveyors with variable extensions are also available. An optional discharge conveyor beam switch (PE) can also be added. The beam switch can be used to either stop the compensating stacker or switch to another discharge when product downstream of the discharge blocks the beam switch. (See 4.1.2 Discharge Conveyor for more details)
22. **Safety Switches:** There are six safety switches mounted on the doors and discharge tunnels of the machine. These switches are to detect when the doors or tunnels are open or removed and stop operation of the machine.
23. **Air Regulator:** An air regulator unit is mounted on the left lower side of the machine cabinet. A quick disconnect is provided for supplying air to the machine. A valve is also provided to turn air off the machine when not in use. A sensor inside the machine cabined deactivates the machine when the air pressure drops below 75 PSI.
24. **Leg Screws:** Located inside the machine cabinet below the turntable are four leg screws. The leg screws, with the addition of aluminum pads, are used to lift the stacker off of the casters and level the base.
25. **Hydra-lift Kit:** An optional hydra lift kit can be added to the compensating stacker to reduce time in relocating or centering the machine. The kit provides pneumatic legs to be used in the place of the screw legs. After the machine is rolled into position, a storable handle is used to extend the legs and raise the machine off the wheels to a useful height. Reversing the turn of the handle will bring the machine back down on the wheels for relocation.

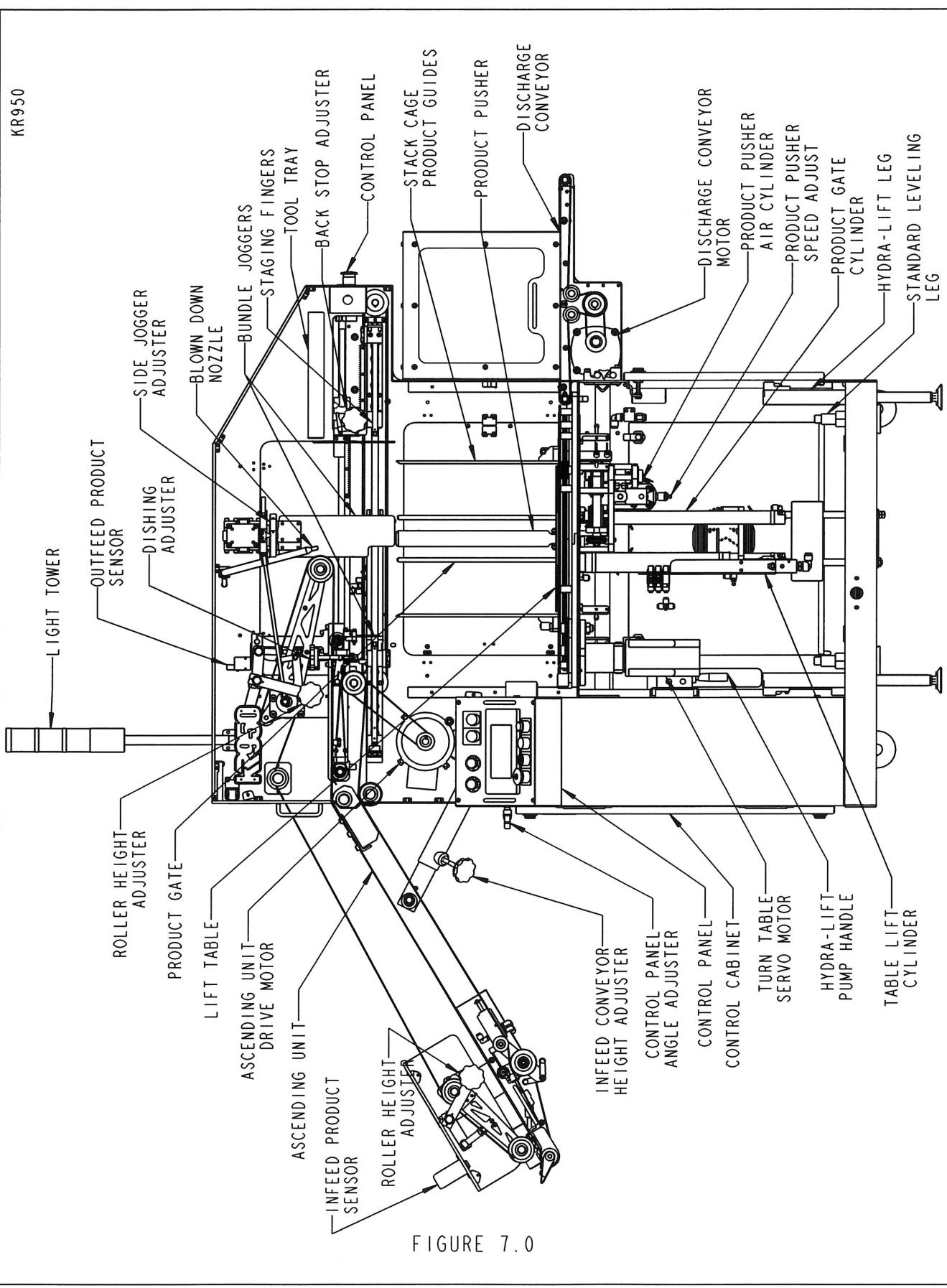


FIGURE 7.0

KR950

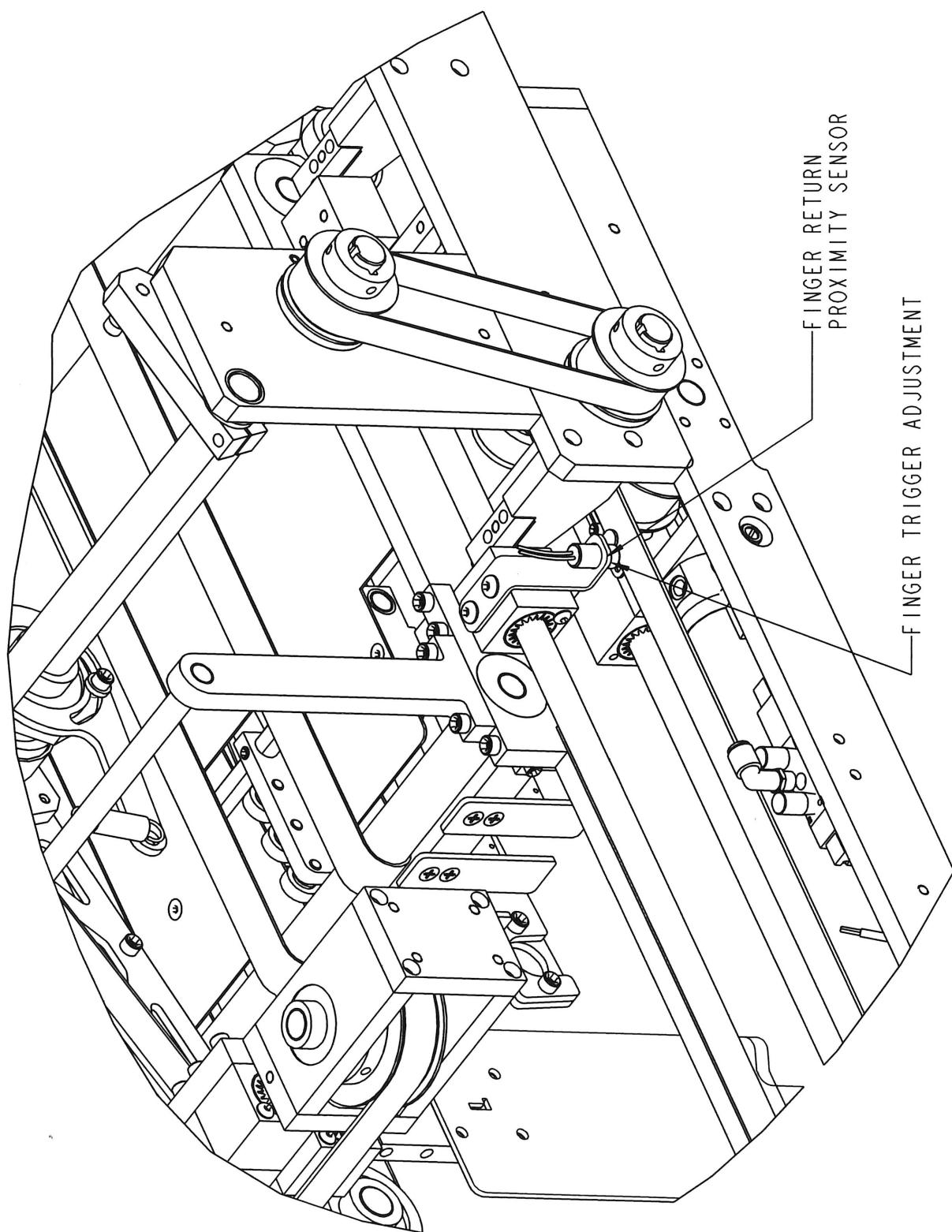


FIGURE 8.0

543985-01

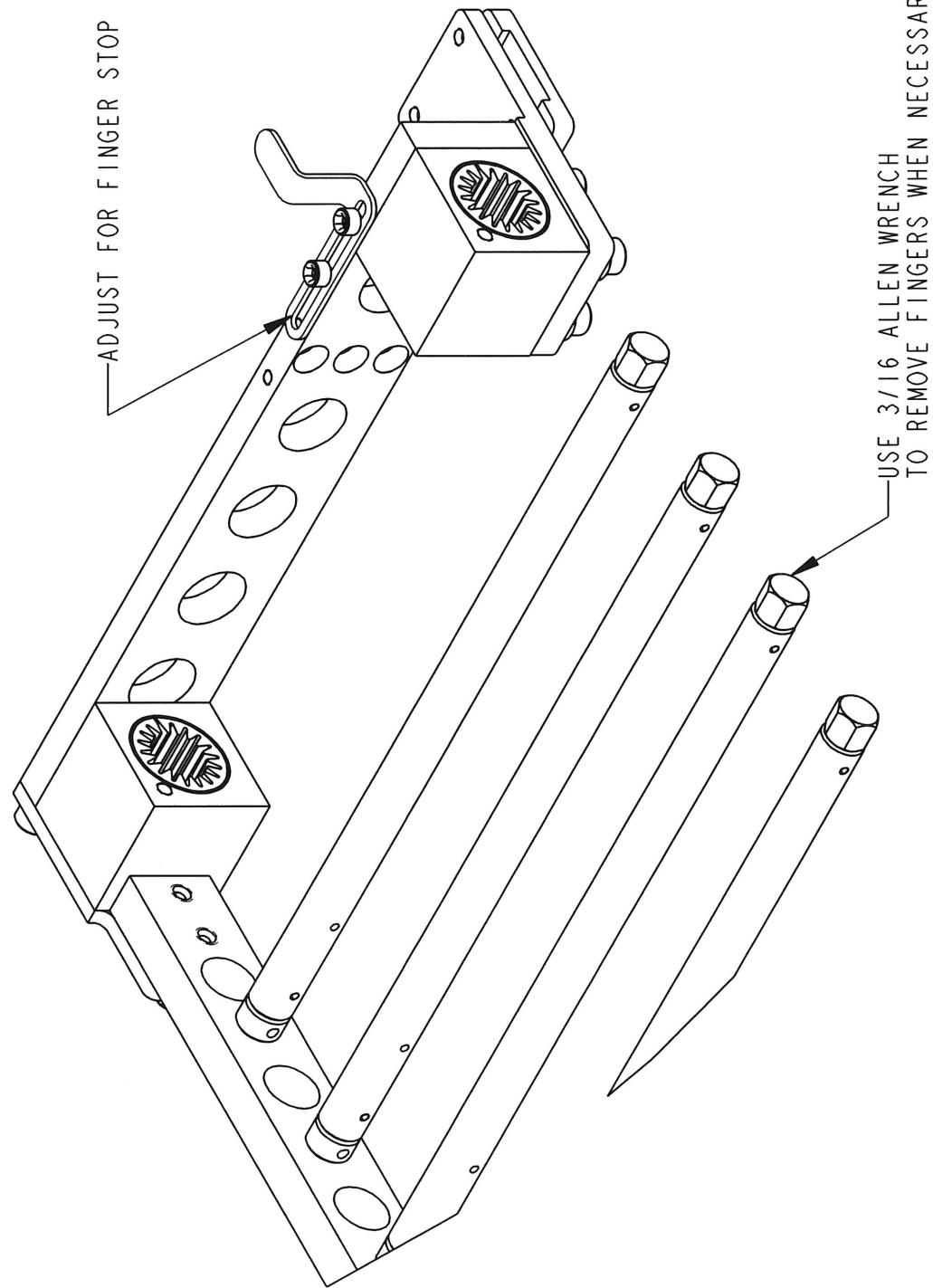


FIGURE 9.0

543896-01

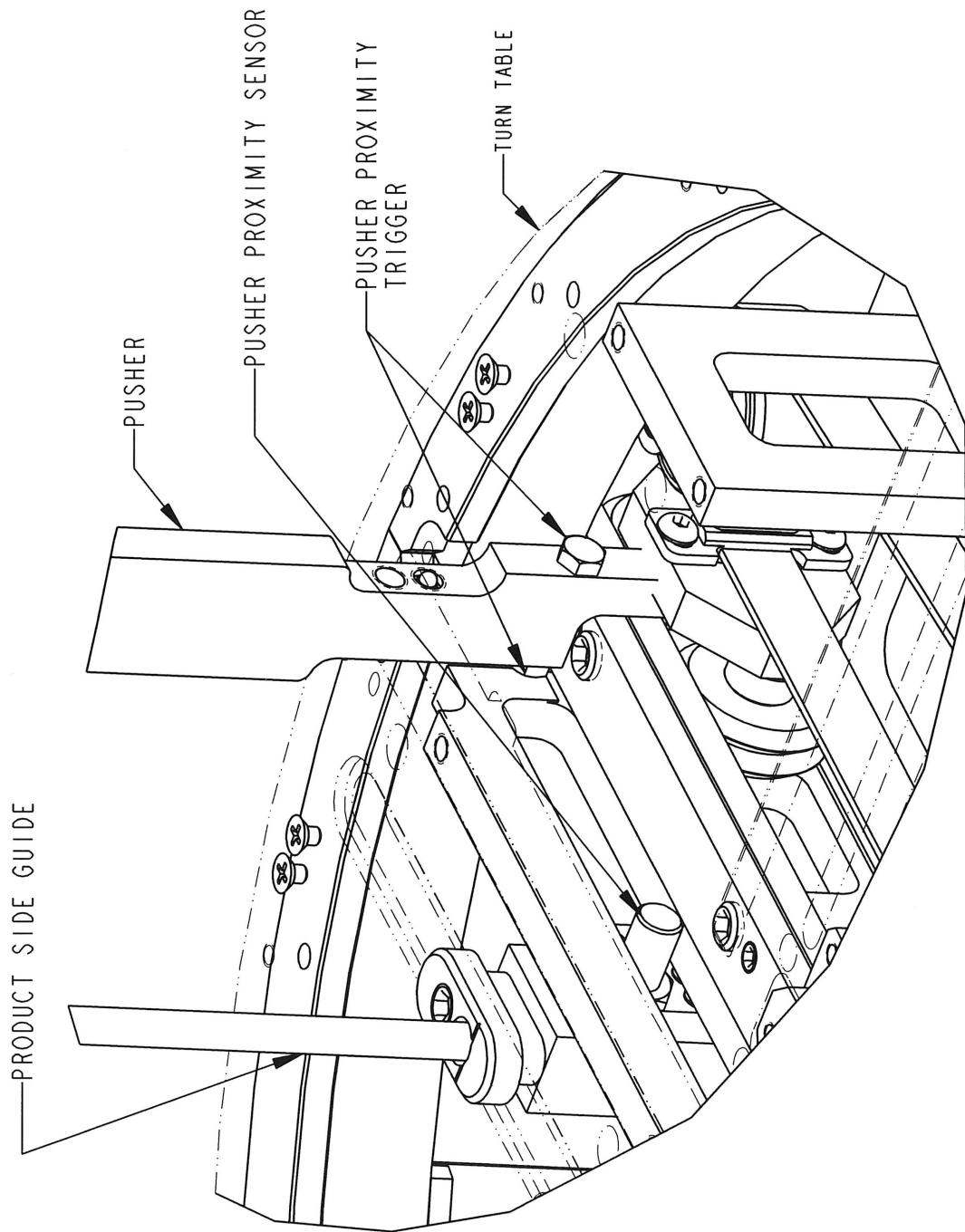


FIGURE 10.0

543896-01

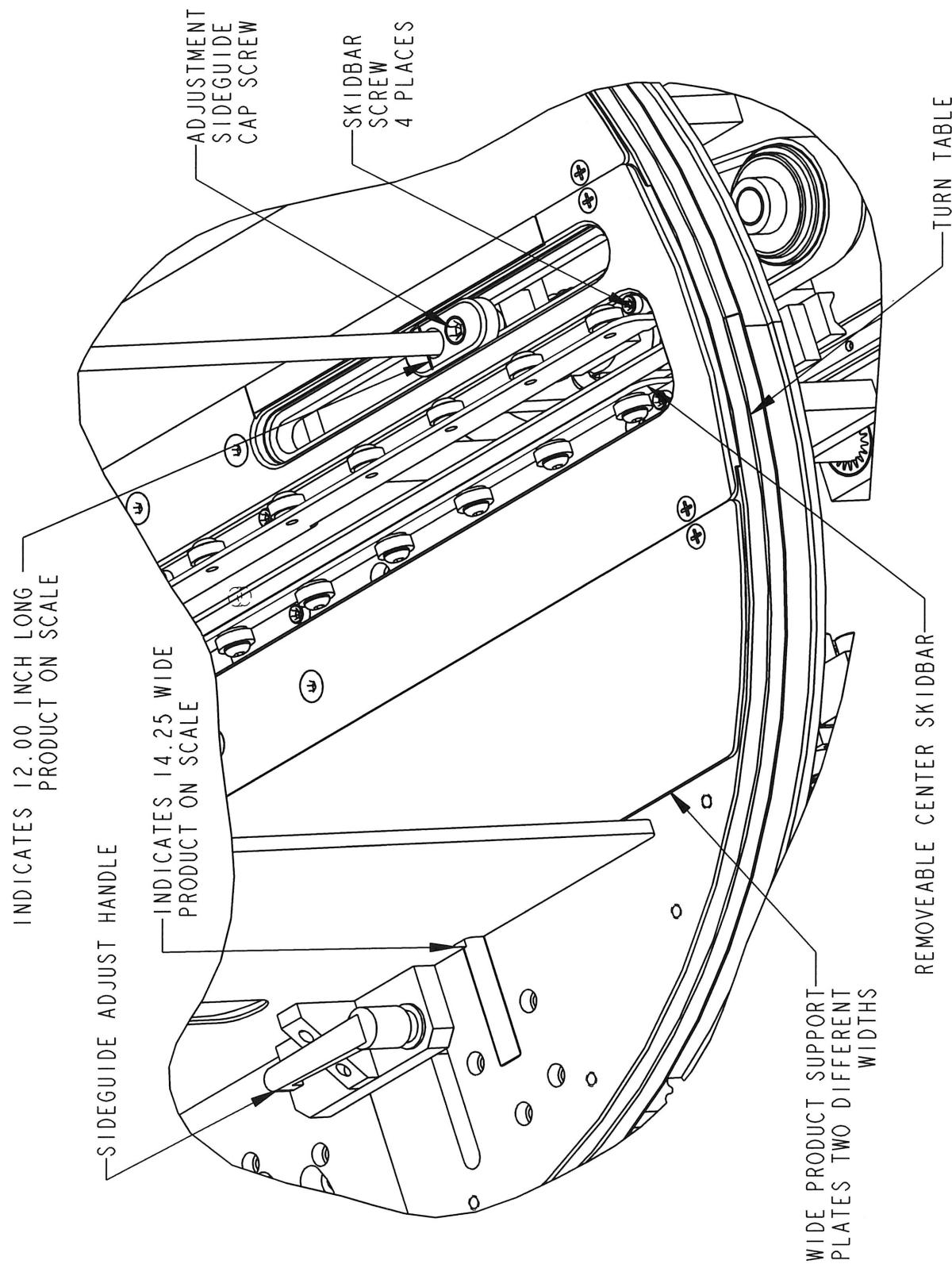


FIGURE 11.0

545632-01

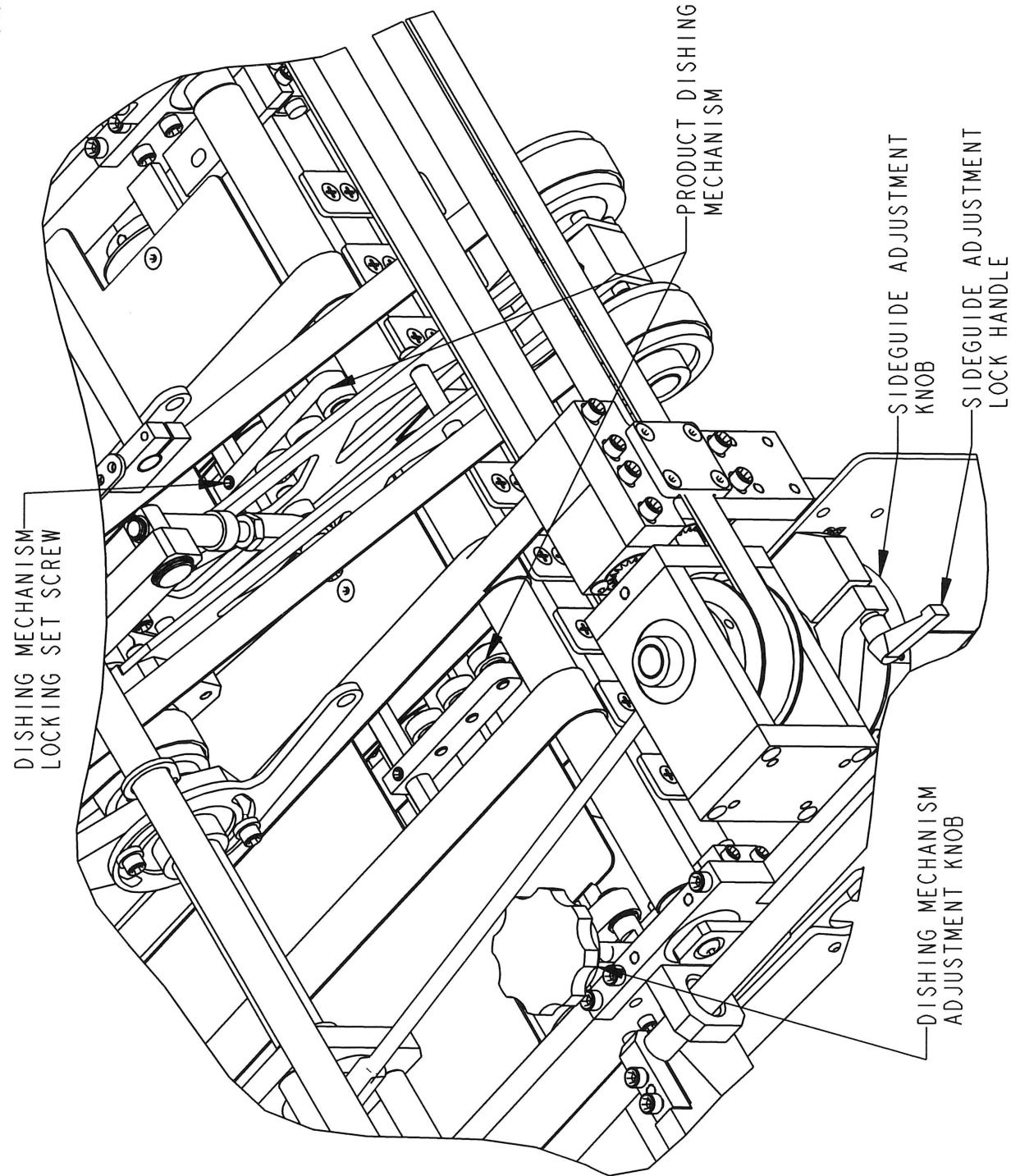


FIGURE 12.0

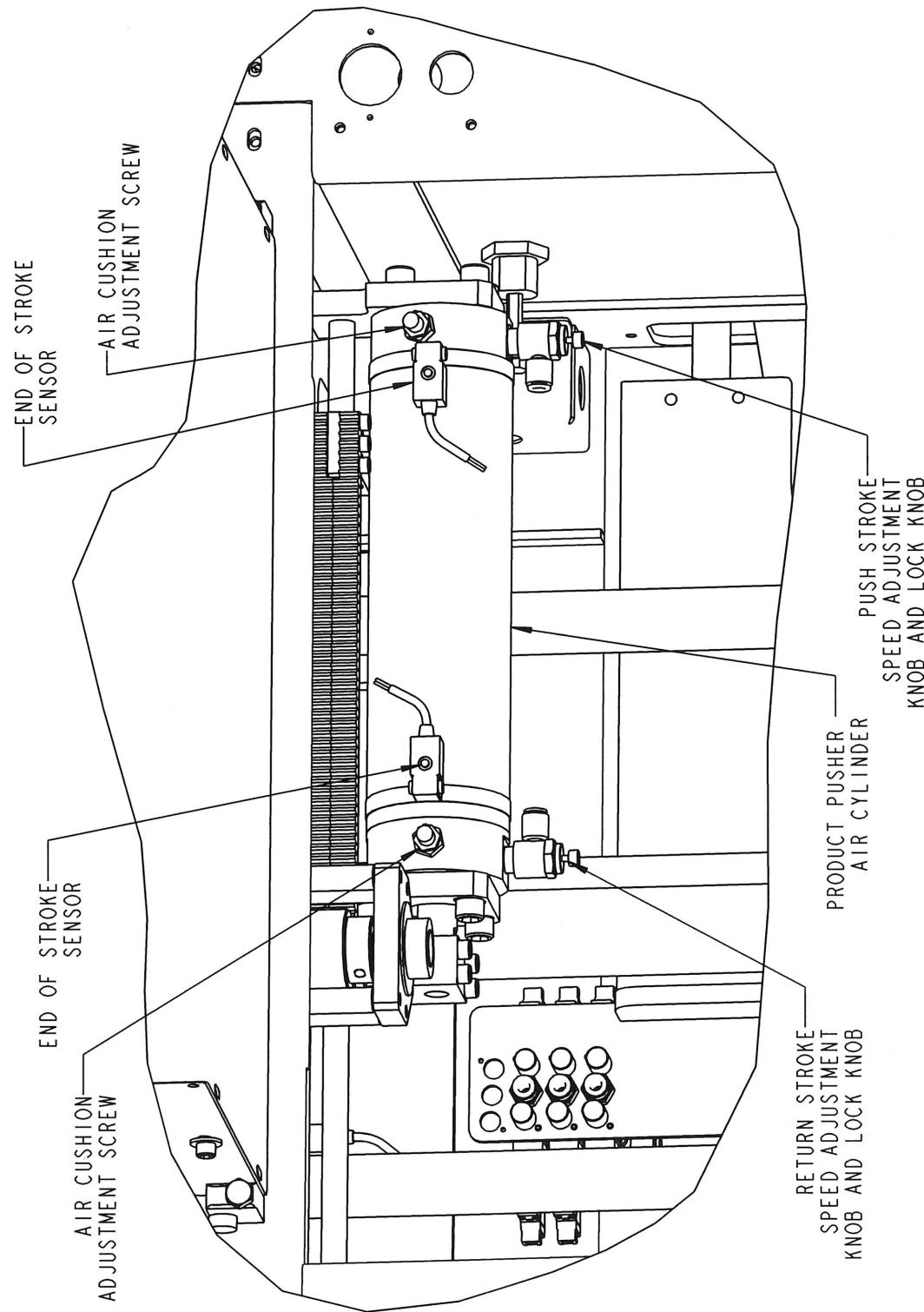


FIGURE 13.00

545684-01

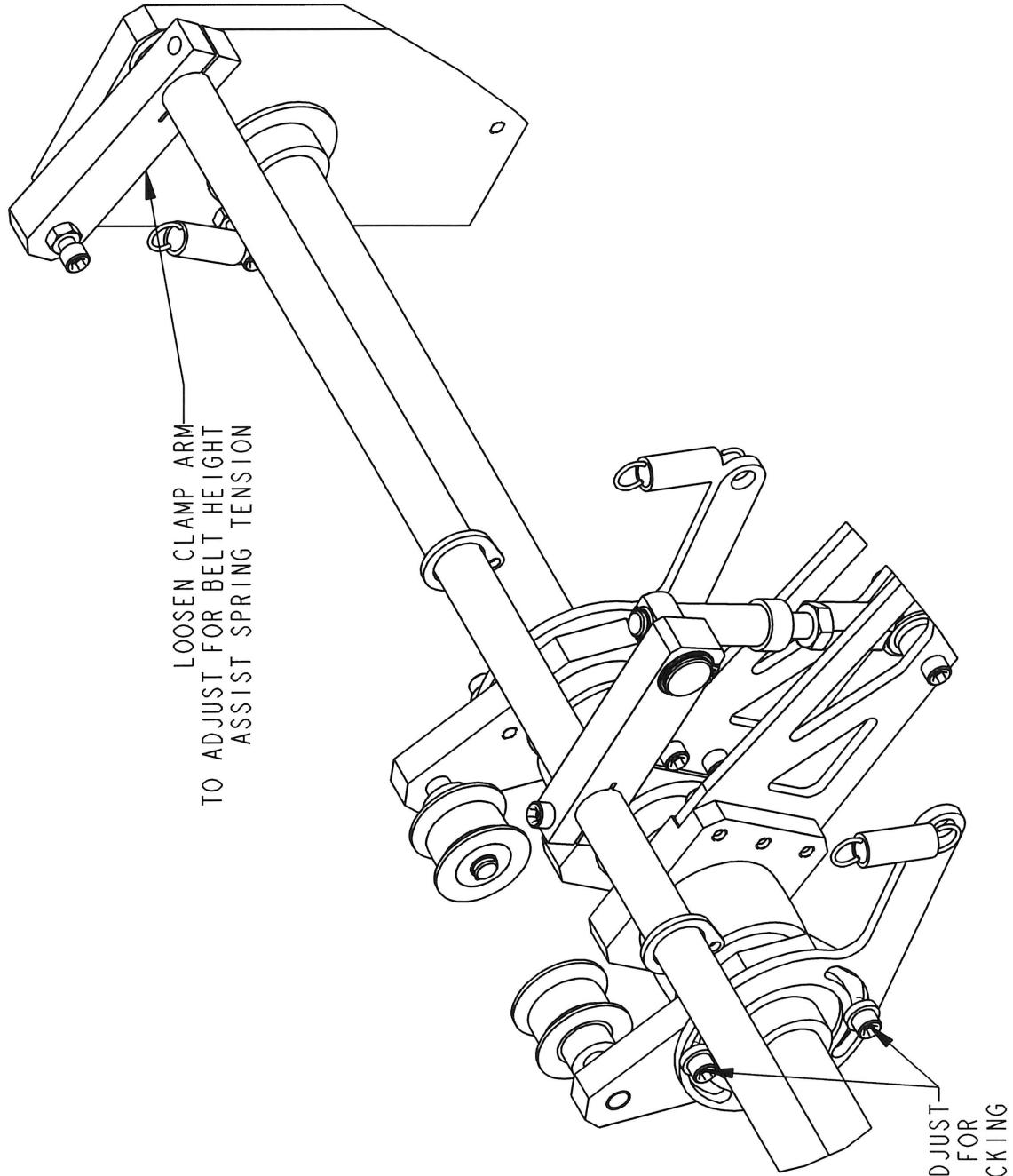


FIGURE 14.0

KR950

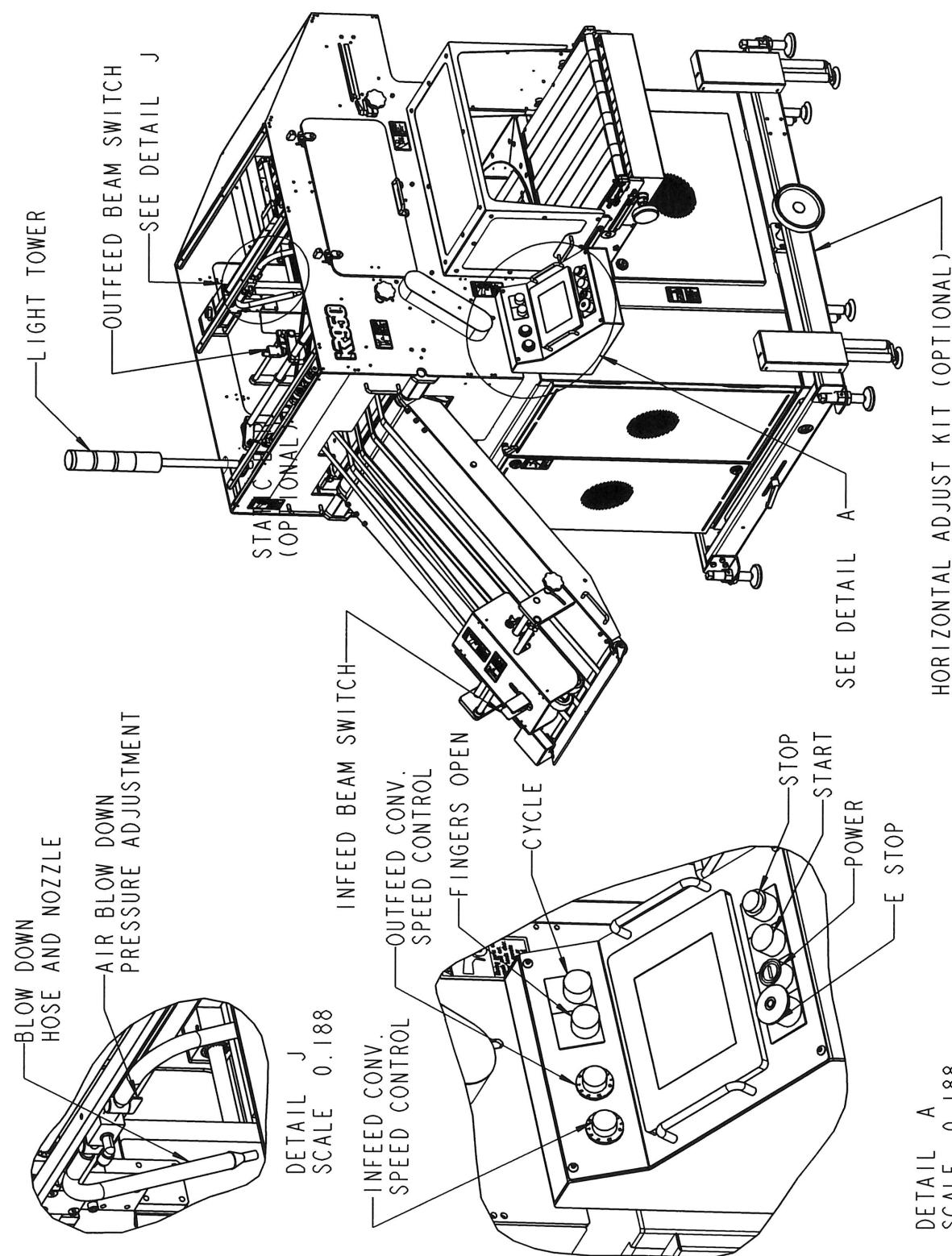


FIGURE 15.0

KR950

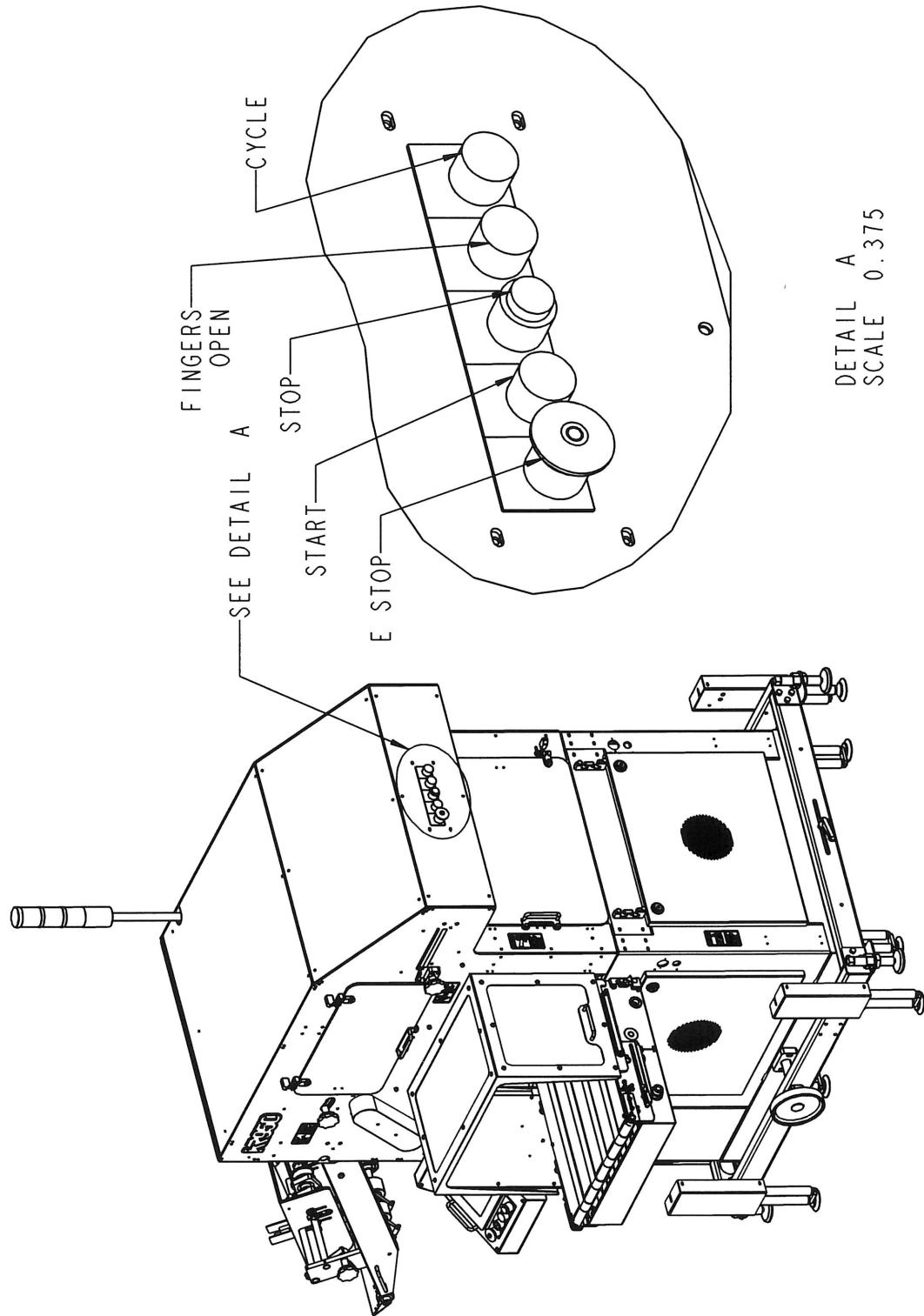


FIGURE 16.0

26. Horizontal Adjustment Assembly: An optional assembly that the machine sits on. If the machine feeding the compensating stacker has side registration the center of the product will move in relation to the compensating stacker. The horizontal adjustment assembly has a wheel that can be used to move the machine left or right to center different size products. A hydra-lift kit can also be added to the make it easy to relocate the machine.

4.2 ELECTRICAL COMPONENT DESCRIPTION

4.2.1 Main Control Panel and Push Button Station: (See Figure 15.0) The main control panel is where the operator controls the machine and is referred to as the OCP (Operator Control Panel). The control panel swivels to either side of the stacker and has a locking bolt with a handle to lock in position.. The control panel contains pushbuttons, speed controls, and a touch screen. Section 4.3 describes the functions of the touch screen. With the exception of the power pushbutton, the pushbuttons on the main control panel are repeated on the push button station located above the B discharge. The functions of the buttons and the speed controls are described below:

1. **E-Stop Pushbutton:** The e-stop pushbutton is a twist-lock push button that requires the operator to twist the button to release it. When pressed, all power to the solenoids, motors, and drives are disconnected. Power to the machine will not be restored when the button is released; the power is restored by the power pushbutton.
2. **Power Pushbutton:** The power pushbutton restores power to the output devices after the activation of an e-stop pushbutton or when power is restored to the machine after being unplugged. The e-stop pushbutton must be released for the power pushbutton to work. After the machine has been powered down, wait for a minimum of 15 seconds before pushing the power button and restoring power to the machine. This is to allow the servo drive to dissipate the energy stored inside it.
3. **Start Pushbutton:** This button serves two functions. If an e-stop was activated, pressing this button will activate the logic in the PLC to home the servo. When the servo is homed, pressing this button will put the machine in run mode and is ready for production. The start pushbutton on located on the push button station can not be used to home the machine.
4. **Stop Pushbutton:** The E-Stop Pushbutton is used in emergency situation because of a safety issue. To stop the machine for a jam or the end of production, press the stop button to turn off the infeed and the discharge conveyors. Power is still applied to the drives but the drives' stop circuits are activated.
5. **Open Fingers:** Pressing the open fingers button will stop the machine and open the fingers as wide as the front and back guides. Pressing the start button will reset the machine and close the fingers.
6. **Cycle Machine:** At the end of production or when there is a non-recoverable jam, this button will clear the machine of product and reset the batch and stack counters to zero.
7. **Infeed Speed Pot:** This $\frac{3}{4}$ turn knob is used to adjust the speed of the infeed conveyor.
8. **Discharge Speed Pot:** This $\frac{3}{4}$ turn knob is used to adjust the speed of all three-discharge conveyors.

4.2.1 Remote Pushbutton Station: An optional pushbutton station can allow the machine to start and stop remotely. The machine is pre-wired so that an optional remote

control panel can be added. The buttons on the control panel are repeated on the remote pushbutton station.

- 4.2.2 Discharge Conveyor:** The three locations to mount a discharge conveyor are marked clockwise A, B, and C starting with the left side of the machine. Each side has its own discharge power and discharge enable receptacle. In addition, each discharge cover has a magnetic safety switch.
1. **Discharge Power:** A three-pin twist female receptacle supplies DC power to the discharge conveyor motor.
 2. **Discharge Enable:** A two pin female Turck receptacle allows interface with the machine PLC to allow product to be discharged onto that conveyor. For the stacker to run, either a discharge beam switch (PE) or a jumper plug must be plugged into the discharge enable receptacle of a discharge in use.
 3. **Discharge Conveyor Beam Switch (PE):** Using the discharge enable, an optional discharge conveyor beam can be mounted on a downstream location and used to either stop the compensating stacker or switch to another discharge conveyor when the product blocks the beam switch at the downstream location.

4.2.3 Machine Light Tower Description

Red Flashing Light: Lights when the Emergency Stop button (E-stop) on the operator station or at a push button station is pressed. Will not stop flashing until the green power button is pressed.

Red Solid Light: Lights when machine is not in run mode. Pressing the start button will put the machine in run mode.

Yellow Light: Lights when a machine fault occurs.

Green Solid Light: Lights when the machine is in run mode and is ready to receive product.

4.3 TOUCH SCREEN INTERFACE

- 4.3.1 Touch Screen Overview:** The OIT (Operator Interface Terminal) is a touch screen terminal that interfaces with the PLC (Programmable Logic Computer) and it is mounted on the OCP (Operator Control Panel). The interface provides a way to change machine settings, monitor the status of the machine, display faults, and allow manual operations. This system eliminates most mechanical adjustments and makes the machine user-friendly. A touch screen map on page 18 shows an overview of all the touch screens.

4.3.2 Touch Screen Data Entry Terminology

This screen has four types of inputs: screen change, toggle, action, and numerical values.

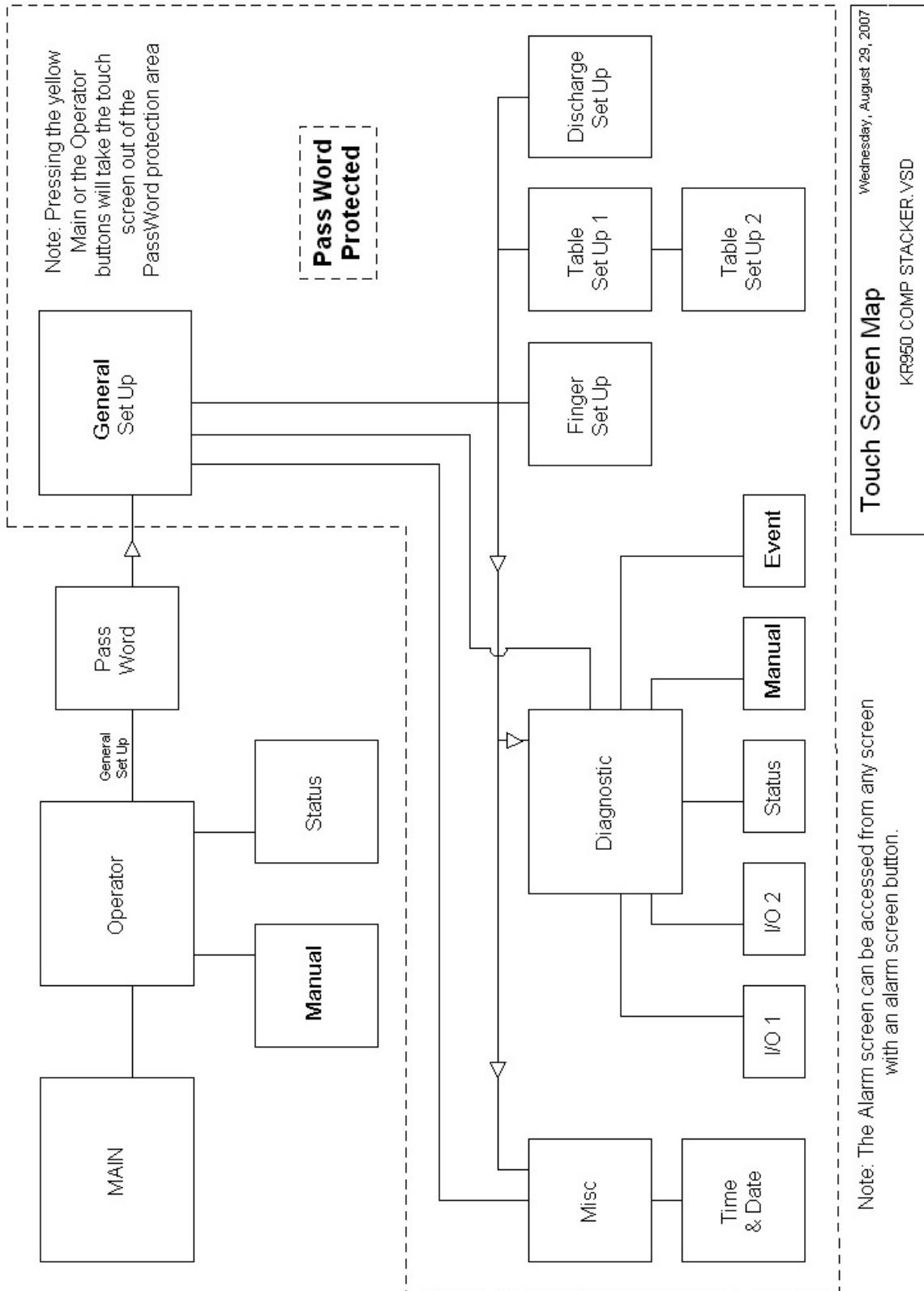
1. **Screen Change:** At power up, the Main Menu screen is displayed. Pressing the OPER. Screen change button will change the screen to the operator screen. All other non-password and password protected screens can be accessed from the operator screen through the use of the screen change buttons provided on the screens (see paragraph 4.3.3 Non Password and Password Protected Screens). A touch screen map provides a comprehensive picture of all the screens in the touch screen and the paths provided to bring up each screen.
2. **Toggle:** When pressed, a toggle input would switch back and forth between two choices (i.e. on/off). When an input is on, the button will either display green and will have the word on. Another example of a toggle input is 0/90 Degree Compensation.
3. **Action:** Pressing an action button (such as the control buttons on the Manual Screen) causes an action to happen.
4. **Numerical Values:** Configuration information (such as Stack Size) is given as numerical value. To change the numerical value, press the button that displays the numerical value. When pressed, a keypad will be displayed on the screen. Enter the value and press enter. This will load the new value in. If a value is out of range, the new value will be ignored.

IMPORTANT: If the Enter key is not pressed, the new value will not be accepted.

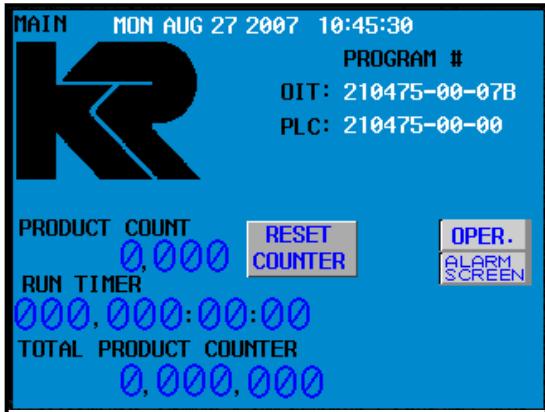
4.3.3 Non Password and Password Protected Screens

1. **Non-Password Protected Screens:** The main screen, operator screen, manual screen, and status screen are used by the operator for setting up and running normal production. These screens are non-password protected and can be accessed anytime there is power to the touch screen.
2. **Password Protected Screens:** Generally, password protected screens have values and options that affect critical operation of the machine. Because of this, password protected screens are only accessible by authorized personnel through the use of a password. Other password protective screens pertain to maintenance functions. The manual and status screens directly accessible from the operator screen have been repeated with the repeated screens made assessable from other password protective screens to keep from having to re-enter the password after using the screen. Password protected screens are only accessed through the general setup screen which is accessible only through a password screen. Once the password is entered, the general setup screen is brought up and all other password protective screens can be accessed. Pressing the yellow main or oper button will return you to either screen selected and will prevent access to password protected screens without returning to the general setup screen via the password screen.

NOTE: After entering the password protected screens, returning to the main or operate screen will prevent unauthorized changes to the operation of the machine.



4.3.4 Main Screen (see 8.1 Touch Screen Menus)



The main screen is displayed at power up.

1. **Date:** At the top of the machine is displayed the date and time. The date and time can be changed on a password-protected screen.
2. **Oper.:** When pressed, this button will change the screen to the operator screen. The operator screen is used during normal setup and operation of the machine for use in production.
3. **Alarm Screen:** When an alarm condition occurs, the alarm screen automatically pops up on the screen. When the alarm screen is closed, it will not reactivate until a new alarm condition occurs. This button brings up the Alarm Screen to display any alarm conditions that still exists.
4. **Product Count:** This counter displays the current production count. The product count appears on the main screen and the operator screen. The counter is incremented when product passes under the stack PE (photo eye). The counter can be cleared by pressing the reset counter button on the main screen or the operator screen.
5. **Reset Counter:** This button resets the production counter.
6. **Run Timer:** The run timer is used to track the run time of the machine. It is activated when the machine is in actual operation or simulated cycle (If the infeed belts are operating, the timer is running.). This timer cannot be cleared.
7. **Total Production Counter:** This counter counts the total pieces the machine processed. It only counts when something passes under the stack PE. It does not count in simulated cycle. It cannot be reset.

4.3.5 Operator Screen



The Operator screen is used for normal operation of the machine. Only non-password screens can be directly accessed from this screen

1. **Status, Manual, and Main:** Pressing any of these three buttons will bring up the named screen. All three screens are non-password protected screens.
2. **General Setup:** Pressing this button will bring up the password screen. The password screen is the gate to the password-protected screens. The password screens are for configuration and maintenance of the machine. Only authorized and trained personnel should use the password-protected screens.
3. **Alarm Screen:** When an alarm condition occurs, the alarm screen automatically pops up on the screen. When the alarm screen is closed, it will not reactivate until a new alarm condition occurs. This button brings up the Alarm Screen to display any alarm conditions that still exists.

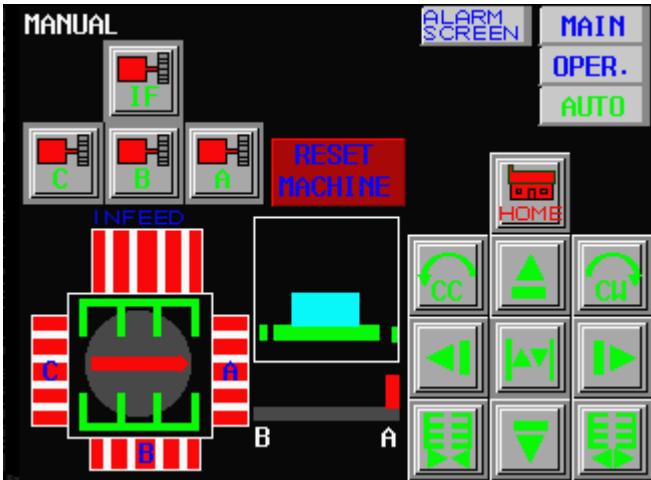
4. **Batch Size:** A batch is the number of product required before a compensation cycle occurs. There are two values shown on the screen for batch size - set value and current count. The operator sets the number in the set value. Pressing the set value window will bring up a keypad for entering the value. The value entered determines the number of product stacked before a compensation cycle occurs. . The machine will not let the set value for the batch size be set larger than the set value for the stack size. The machine will not let the set value for the batch size be less than what is set in the minimum stack size on the general setup touch screen. The current count is the number of product that have been stacked towards the completion of a batch. With the exception of over stacking, when the current count equals the set value, the machine will compensate the stack.
5. **Stack Size:** A stack is the number of product required before a discharge cycle is activated. There are two values shown on the screen for stack size – set value and current value. The operator sets the number in the set value. Pressing the set value window will bring up a keypad for entering the value. The machine will not let the set value for the stack size be less than what is set in the minimum stack size on the general setup touch screen. The value entered determines the number of product stacked before a discharge cycle occurs. The current count is the number of products that have been stacked towards the completion of a stack.

Note: During setup a minimum stack size is calculated and set on the general setup touch screen. This is the minimum number of product needed in a batch or stack to allow the stacker time to complete a discharge cycle before it can act on the next batch or stack.

6. **Cycle Timer:** This timer is used to measure the duration of the compensation cycle and the discharge cycle. The timer is useful in tuning the machine or determining the minimum stack size.
7. **Product Count:** This counter displays the current production count. The product count appears on the operator screen and the main screen. The counter is incremented when product passes under the stack PE. This counter is cleared by pressing the reset counter button on the operator screen or the main screen.
8. **Reset Counter:** This button resets the production counter. It does not clear the batch or stack counters.
9. **Simulate Cycle:** This toggle button, when active, will simulate product entering the machine. Each simulated piece is one second apart. This simulation will activate the compensation cycle and the discharge cycle.
10. **Reset Machine:** This button will clear all counters, timers, and reset the compensation cycle and discharge cycle. It will not clear the production counter. After the button is pressed, product in the machine will need to be removed by pressing the cycle machine button on the operator control panel.
11. **Sort Infeed Count:** When remote sort is turned off on the General Setup screen, this window will display a zero. When remote sort is turned on, this window will display the infeed count (see section 4.4.6 - Compensating Batches and Discharging Stacks by Remote Sort).

12. **Compensate Infeed Count:** When remote batch is turned off on the General Setup screen, this window will display zero. When remote batch is turned on, this window will display the compensate infeed count (see section 4.4.6 - Compensating Batches and Discharging Stacks by Remote Sort).
13. **Reset Inf Cnt:** Resets the sort and/or compensate infeed counts to zero.

4.3.6 Manual Screen

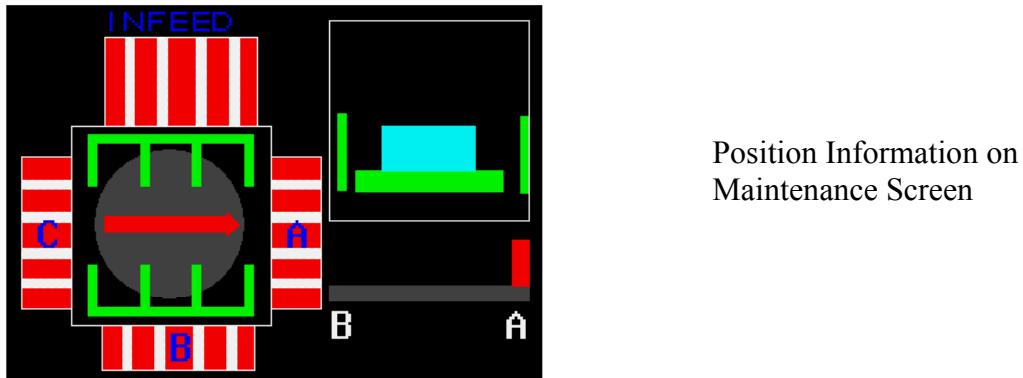


- manual mode to be able to use the action buttons to manually control the machine. If the machine is in the manual mode, pressing the start button to start up the machine will automatically put the machine back in the auto mode.
3. **Reset Machine:** If a fault or a jam occurs while the machine is in a compensation or discharge cycle, the machine may lock up. Pressing the reset machine button will reset the counters and timer to there initial settings for receiving product. After this button is pressed and the fault is cleared, the operator needs to cycle the machine after the start button is pressed.
 4. **Motor Buttons:** There are four motor buttons, the infeed (IF) and discharge A, B, and C. Pressing a motor button toggles the selected motor between on and off. When the motors are red and the words are green, the motors are manually turned off. When the motors are green and the letters are red, the motor is turned on.
 5. **Home:** Pressing the home button will instruct the servo to move to the home position. Homing the servo motor gives it a reference point for all movements.
 6. **CC & CW Buttons:** CC and CW mean counterclockwise and clockwise. If the machine has not reached the final position in that direction, pressing one these buttons will turn the base one position in the direction of the arrows.
 7. **Up & Down Arrows:** Pressing the up or down arrow will activate the table cylinder to move the drop table up or down until the limit point of the direction of movement is reached. The button can be pressed momentarily to move is small increments or held down to move the table all the way to the limit point for that direction of travel.
 8. **Right & Left Buttons:** Pushing the right arrow moves the pusher to side A of the table and the left arrow moves the pusher to side B of the table. The pusher can be moved in small increments by momentarily pushing an arrow or moved to the limit of travel in that direction by holding down the button.

1. **Alarm Screen:** When an alarm condition occurs, the alarm screen automatically pops up on the screen. When the alarm screen is closed, it will not reactivate until a new alarm condition occurs. The alarm screen button brings up the alarm screen to display any alarm conditions that still exists.

2. **Auto/Manual:** Pressing the auto/manual button toggles the machine between the auto and manual mode. The machine must be in the

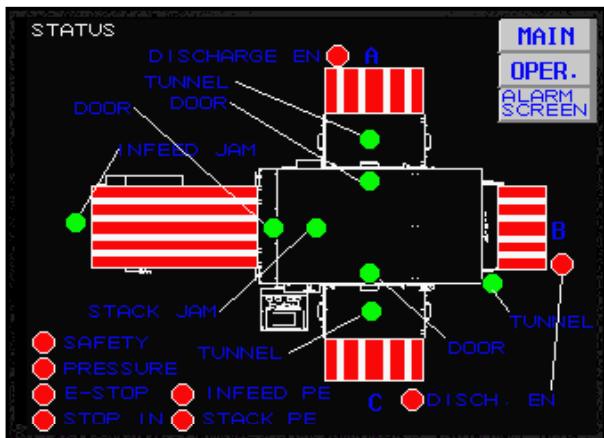
9. **Up/Down Button with Rods :** Pressing this button toggles the side guides to the full up or full down position.
10. **Fingers In & Out Buttons:** Pressing these buttons move the fingers in or out. Pressing the out button once moves the fingers to the first out position set by a moveable sensor. Pressing the out button a second time will move the fingers to the second out position set by the limit switch on the air cylinder.



11. **Turn Table Position Arrow:** The position arrow is used to determine the table position relative to the Home Position. The home position is when the arrow is pointing to discharge A. When the arrow is blue, the table is in the correct location and it is aligned with the position proximity sensor underneath the table. A red arrow means the table is in transition or it is not aligned with the proximity sensor.
12. **Staging Fingers:** Located above the table, the fingers catch the product while the turntable is compensating or discharging product. The fingers have three position, back, forward, and staging. The fingers are green when the fingers are on the position sensors. Note: Due to the nature of pneumatics, the fingers will overshoot the staging sensor before it will stop. For normal operations, the fingers in the staging area will be red.
13. **Infeed Conveyor:** The infeed conveyor is displayed in two colors, red and green. Red means the motor is off and green means the motor is running.
14. **Discharge Conveyor A, B, & C:** The discharge conveyor motor is displayed in three different colors, red, yellow, and green. When red, the discharge conveyor is off. Yellow means the motor is selected for discharge but the motor is not running because of an optional downstream enable. Green means the discharge conveyor is running.
15. **Pusher:** The pusher has four position, A side, A side staging, B side Staging, and B side. The A side is defined as the side when the table is in the home position. Use the table position indicator to determine the A and B side. Mounted on the Side Guides are proximity sensors. These sensors are used to stop the pusher when staging the pusher. Staging occurs after the product is discharged. This is to reduce the cycle time for discharging product. The pusher is displayed in two colors, red and green. Green indicates the pusher is on the sensor and red indicate the pusher is not on the sensor. Note: Due to the nature of pneumatics, the pusher will overshoot the staging sensor before it will stop. For normal operations, the fingers in the staging area will be red.
16. **Side Guides:** The side guides have two positions, up and down. When red, the side guides are in transition and green means they are in position.

- 17. Turn Table Lift:** The Turn Table has two indicating colors, red and green. Green indicates that the table is in the top or bottom position. Red indicates that it is somewhere in-between.

4.3.7 Status Screen

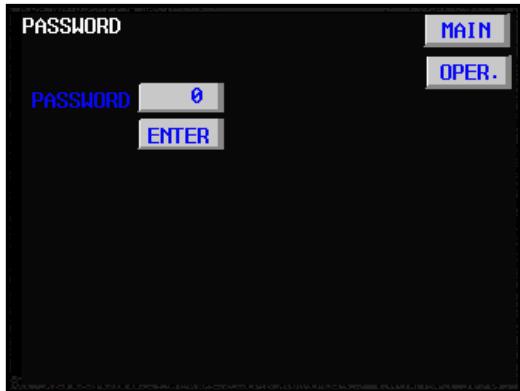


The Status Screen monitors the key inputs and outputs for the operations of the machine.

1. **Discharge En:** There are three Discharge Enable inputs. These inputs are two pins Turck connectors located on the base at each discharge. The discharge cannot be activated unless the down stream equipment is ready to receive product. If there is no Discharge Enable activated, the machine will go into standby mode until it receives an enable signal. If there is no downstream equipment to interface with, a Turck jumper is used. Note: Use jumper only when there is no discharge conveyor mounted at the discharge.
2. **Warning:** The loss of enable will not stop the machine. To stop the machine, use either a remote stop station or use the Stop In connector mounted on the e-box.**Door:** There are three doors mounted at the top of the machine to gain access to the fingers and the infeed conveyor. Two doors are over discharge A and B. The third door is at the infeed. Opening any of the doors activates a safety switch to stop the machine. The machine will not run again until all doors are closed.
3. **Discharge:** There are three-discharge locations. Each location will have either a tunnel or a door. The tunnel is mounted on top of the discharge conveyor. If a tunnel is removed or a door is opened, the machine will stop and will not restart until the tunnel is replace or the door is closed.
4. **Infeed Jam:** A jam alarm occurs when the infeed eye is blocked for a specific duration. Pressing the start button will reset the alarm if the infeed jam eye has been unblocked..
5. **Stack Jam:** A stack alarm occurs when the stack eye is blocked for a specific duration. Pressing the start button will reset the alarm is the stack eye has been unblocked.
6. **Safety:** All doors and tunnels are series to one input. This creates a double safety incase a failure occurs in the switch. If any doors or tunnels are open it will deactivate this input.
7. **Pressure:** Mounted inside the control cabinet is a pressure switch. When the pressure drops below a certain set point, the switch will deactivate and will stop the machine.
8. **E-Stop:** The Emergency Stop when pressed will remove power to all output devices. This input monitors the E-stop circuit.
9. **Stop In:** This is a two pin female Turck connector mounted on the e-box. This input is tied to a down stream device to stop the machine. The operator must press the Start Button to restart the machine. The signal must remain high to keep the machine in run mode. If no down stream interface is required, a Turck jumper must be installed. Note: This is different from the Discharge Enable signal. A loss of Discharge Enable will put the machine in standby and will start up as soon as the signal is received.

- 10. Conveyors:** The infeed and discharge conveyor outputs are displayed as the conveyors. If the output is on to activate the conveyor, the conveyor will be green else it will be red. Note: On the Maintenance Screen, the discharge conveyor shows the control status of the conveyor.

4.3.8 Password Screen



Pressing the general setup button on the operators screen brings up the password screen. On this screen, a valid password must be entered to move to the password protected screens.

1. **Password Numerical Button:** Pressing this button will activate a keypad to enter the password. The password is a four-digit number.
2. **Enter:** After entering the password number, press enter on the keypad then press the enter button below the password. This will bring up the general setup screen and allow access to all

password protected screens. Note: If the proper password does not gain entry to the general setup screen, return to the operator screen and press the reset machine button. Then, try entering the password again.

NOTE: After entering the password protected screens, returning to the main or operate screen will prevent unauthorized changes to the operation of the machine.

4.3.9 General Setup



1. **Misc., Diag, Fingers Setup, Table Setup, and Disch Setup:** Pressing these screen change buttons will bring up the screens and remain in the password-protected section of the touch screen.
2. **Main and Oper:** Pressing these screen change buttons will bring up the selected screen. The buttons are colored yellow because they will take you out of the password-protected section of the touch screen.
3. **Alarm Screen:** When an alarm condition occurs, the alarm screen automatically pops up on the screen. When the alarm screen is closed, it will not reactivate until a new alarm condition occurs. This button brings up the Alarm Screen to display any alarm conditions that still exists.

4. **Remote Sort:** Pressing the remote sort button toggles the remort sort on and off. When on, the remote sort allows an upstream machine to send a sort signal to the machine through the three pin molex connector. The sort signal begins a process that activates the stack complete for the machine when the last product drops onto the stack (see the remote sort section for complete details on remote sort). The stack complete signal will discharge the stack with the last product of the mail sort on top of the stack. With the remote sort on, the machine will still compensate and stack when the when the current count in the

batch size and stack size equals the set values. An exception for this occurs when the compensate is canceled for overstacking before a complete stack signal activates a discharge through the remote sort process (see the remote sort section for details on overstacking).

5. **Remote Batch:** Pressing the remote batch button toggles the remote batch on and off. When on, the remote batch allows an upstream machine to send a compensate signal to the machine through the three pin molex connector. The compensate signal begins a process that activates the batch complete for the machine when the last product in the batch drops onto the stack. The machine will compensate the stack with that product on top of the newly completed batch (see the remote sort section for complete details of remote sort). With the remote batch is on, the set value for the stack size should be set for largest stack of product the machine will hold. The set value for the batch size will automatically mirror the set value for the stack size. If the current count for the batch and stack size equals what is set in the set value, the machine will activate the discharge cycle and discharge the product. This is to keep from jamming the machine.
6. **Infeed Count Auto Reset:** When using remote sort with the infeed count auto reset turned on, the infeed count for sort will automatically reset back to zero after 15 seconds of run time if no product passes under the infeed beam switch or the stack beam switch. If the remote batch is also turned on, the infeed count for compensate will also zero out.
7. **Infeed Jam:** Pressing the infeed PE jam button will toggle it on and off. When the infeed PE is moved onto another machine, the infeed jam detection will need to be turned off. This will keep the stacker from faulting out when the upstream machine has stopped.
8. **PE Jam Timer:** This sets the time duration for product to be under the infeed PE or Stack PE before the machine will fault out due to a jam. The timer is in 100th of a second.
9. **Minimum Stack Size:** The minimum stack size value sets the minimum value for the for the batch and stack size set in the Operator Screen. This is also the minimum number of pieces that must be in the stack before the machine receives a compensate or a discharge command. This value is determined by the rate of product being stacked and the time it requires to complete a stack discharge. To determine this value, multiply the feed rate for the product by the cycle time for the discharge cycle or refer to the Minimum Stack Count Chart page 57 in this manual.
10. **Cycle Fault Timer:** The upper cycle fault timer display is activated when a discharge or compensation cycle is activated and stays on until the cycle is complete. It will continue to display the final value until it is activated again. The lower cycle fault timer is the set point. Touching the value shown will bring up a keypad for changing the set point value. If this timer reaches the set point, it will cause the machine to fault out. The timer preset value needs to be a minimum of a ¼ of a second longer than the longest cycle.

4.3.10 Fingers Setup



- Misc., Diag, General Setup, Table Setup, and Disch Setup:** Pressing these screen change buttons will bring up the screens and remain in the password-protected section of the touch screen.
- Oper and Main:** Pressing these screen change buttons will bring up the selected screen. The buttons are colored yellow because they will take you out of the password-protected section of the touch screen.
- Alarm Screen:** When an alarm condition occurs, the alarm screen automatically pops up on the screen. When the alarm screen is closed, it will not reactivate until a new alarm condition occurs. This button brings up the Alarm Screen to display any alarm conditions that still exists.
- Finger's Position:** Pressing the finger position button will toggle it close or open. In the close mode, product is accumulated on the fingers. The fingers will open when the stacker is ready to compensate or discharge. The fingers will open to drop the stack on to the drop table and then close again to accumulate product. In the open mode, the fingers start in an open position allowing the product to stack on the drop table; then, momentary close to stack the product on the closed fingers while stack is being compensated or discharged. When the compensation or discharge is completed, the fingers open again to drop the product that has accumulated on the fingers to the drop table and continue stacking the product on the drop table. This process allows larger stacks between compensation.
- Delay Fingers Opening:** This time delay allows the product activating the compensating cycle to settle on the stack before the fingers open and drop the stack onto the drop table. This delay is only used when using the fingers accumulate mode. To change the value in the delay, press the window and a keypad will appear on the lower right hand corner of the screen
- Delay Fingers Closing:** When the cycle starts, this delays the fingers from closing. This delay prevents the fingers from pinching the product that triggered the cycle. To change the value in the delay, press the window and a keypad will appear on the lower right hand corner of the screen.
- Count for Finger Delay Opening:** The finger delay opening can only be used when the fingers position is in the open mode. When it is on, the fingers will start a batch in the close position, stacking product on closed fingers; then, open the fingers and finish the batch in the open position when the count of product stacked on the fingers is equal to the value shown in the window. Count for fingers delay opening is activated when a value other than zero is entered for the set value. To deactivate it, a value of zero must be entered in the set value. The count for fingers delay is automatically turned off when the fingers position mode is set to close and is reactivated when the fingers position mode is set to open.

8. **Count for Oversize Batch:** The finger delay opening can only be used when the fingers position is in the close mode. When the count for oversize batch is on, the fingers will start a batch in the close position; then the fingers will momentarily open and close again dropping the stack accumulated on the fingers to the drop table each time the number of product stacked on the fingers is equal to the value in the window. The count for oversize batch is activated when a value other than zero is entered for the set value. To deactivate it, a value of zero must be entered in the set value. The count for oversize batch will automatically turn off when the fingers position mode is set to open and will reactivate when the fingers position mode is set to close.
9. **Finger Close Staging:** When the fingers close staging is toggled to the on position, the fingers close to an interim position instead of a full close position. This interim position is called close staging position. The close staging prox sensor determines the close staging position. The fingers close staging position shortens the cycle times when the product does not require the fingers to be fully closed to support it. The interim close position is adjustable.

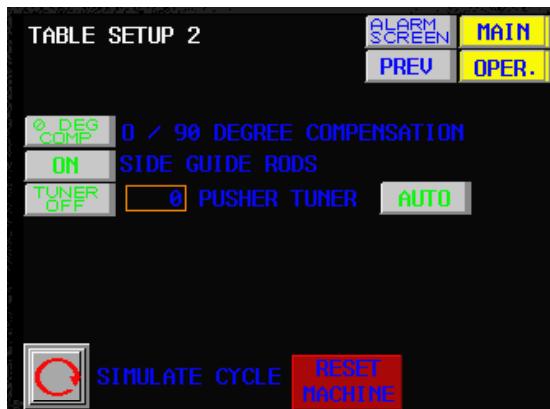
4.3.11 Table Setup 1

TABLE SETUP 1	MISC. GENERAL SETUP	DIAG FINGER SETUP	ALARM SCREEN DISCH SETUP	MAIN OPER.
0	/100	DELAY DROP & ROTATE		NEXT
0	/100	TABLE DROP TIMER		
0	/100	POST DROP TABLE DELAY		
0	/100	PUSHER DELAY		
0	/100	POST PUSH DELAY		
0	/100	POST POSITION DELAY		
ON		DROP TABLE		
COMP		DROP TABLE EVENT		
0		0	DROP TABLE PIECE COUNT	
0	/100		DROP TABLE PIECE TIMER	

1. **Misc., Diag, General Setup, Finger Setup and Disch Setup:** Pressing these screen change buttons will bring up the selected screen and remaining the password-protected section of the touch screen.
2. **Oper and Main:** Pressing these screen change buttons will bring up the selected screen. They are colored yellow because they will take you out of the password – protected section of the touch screen and you will have to re-enter the password to return to the setup screens.
3. **Alarm Screen:** When an alarm condition occurs, the alarm screen automatically pops up on the screen. When the alarm screen is closed, it will not reactivate until a new alarm condition occurs. This button brings up the Alarm Screen to display any alarm conditions that still exists.
4. **Delay Drop and Rotate:** This time delay is used to allow product to settle onto the table before the next step in the cycle to occur.
5. **Table Drop Timer:** The distance that the table moves down for each compensation cycle to allow more product to accumulate is done by a timer. The distance dropped is based on the air pressure, valve settings, and the drop time set value.
6. **Post Drop Table Delay:** This delay is used to allow the product after it is dropped and compensated to settle before the fingers open to allow new product to drop onto the table.
7. **Pusher Delay:** This time delay is to allow product to settle before the pusher discharges it.
8. **Post Push Delay:** This time delay occurs after the pusher push the product onto the discharge conveyor. This is used to allow product to clear the table area before it returns to the receiving position.

9. **Post Position Delay:** This time delay occurs when the table guides and pusher have returned to receiving position to receive product.
10. **Drop Table:** Pressing the drop table button will toggle the drop table on and off. When the drop table is on it will move to the full up position at the completion of a discharge cycle and drop as programmed on compensate and discharge cycles. When the drop table is off, it rests at the full down position during operation of the machine.
11. **Drop Table Event:** Pressing the drop table event button will toggle between comp and piece. When in the comp mode, the drop table will drop when the product is compensated for the amount of time set in the table drop timer on the compensate setup screen. In the piece mode, the drop table will drop when the drop table piece count is reached. The drop table piece timer is used for the distance the table drops.
12. **Drop Table Piece Count:** If the drop table event is in the piece mode, when the number of product set in the drop table piece count passes under the stack PE the drop table will drop the amount of time set in the drop table piece timer. Press the window on the left and a keypad will appear on the right hand bottom of the screen for setting the value in the window. The window on the right is the current count.
13. **Drop Table Piece Timer:** Press the window and a keypad will appear on the right hand bottom of the screen for setting the value in the window.

4.3.12 Table Setup 2



1. **Prev:** Pressing this screen change button will return to the Table Setup 1 screen and remain in the password-protected section of the touch screen.
2. **Oper and Main:** Pressing these buttons will bring up the screens. They are colored yellow because they will take you out of the password-protected section of the touch screen and you will have to re-enter the password to return to the setup screens.
3. **Alarm Screen:** When an alarm condition occurs, the alarm screen automatically pops up on the screen. When the alarm screen is closed, it will not reactivate until a new alarm condition occurs. The alarm screen button will bring up the alarm screen to display any alarm conditions that still exists.
4. **0/90 Degree Compensation:** Pressing the button to toggle to 90 degree will cause the table to start and compensate 90 degrees from the normal compensation position. It is used when the width and length of the product necessitates conforming the drop table to the orientation of the product. **Note:** Compensating in the 90 degree position may increase the cycle time.
5. **Side Guide Rods:** Pressing the side guide rod button toggles the rods on and off. When on, the side guide rods rise all the way up at the end of the discharge cycle and drop all the way down when the discharge cycle drops the drop table. When off, the side guide rods rest at the full down position during operation of the machine.
6. **Pusher Tuner:** When in manual mode, this button will activate the pusher to cycle back and forth. This will allow the maintenance personnel to adjust the pusher speed to

minimize the cycle time for the product being processed. The screen below displays the time for each stroke of the pusher.

7. **Simulate Cycle:** This toggle button, when active, will simulate product entering the machine. Each simulated piece is one second apart. This simulation will activate the compensation cycle and the discharge cycle.
8. **Reset Machine:** The reset machine button will clear all counters, timers, and reset the compensation cycle and discharge cycle. It will not clear the production counter. After the button is pressed, product in the machine will need to be removed by pressing the cycle machine button on the operator control panel.

4.3.13 Discharge Setup



1. **Misc., Diag, General Setup, Finger Setup and Table Setup:** Pressing these screen change buttons will bring up the screens and remain in the password-protected section of the touch screen.
2. **Oper and Main:** Pressing these buttons will bring up the screens. They are colored yellow because they will take you out of the password-protected section of the touch screen and you will have to re-enter the password to return to the setup screens.
3. **Alarm Screen:** When an alarm condition occurs, the alarm screen automatically pops up on the screen. When the alarm screen is closed, it will not reactivate until a new alarm condition occurs. This button brings up the Alarm Screen to display any alarm conditions that still exists.
4. **Activate Discharge A, B, & C:** There are three components for each discharge. These components are On/Off, Timer Activate, and Delay off.
 - a. **On/Off:** This toggle button will turn the discharge on or off. However, the discharge enable must be activated for the discharge to run.
 - b. **Time Activate:** With the discharge turned on and discharge enable activated, the discharges can be operated in two modes, always on and delay off after discharge. The always on will run continuously until the discharge enable for that side is deactivated. The delay off after discharge turns the conveyor on when the pusher is activated and runs until the delay off timer times out.
 - c. **Time On:** This timer sets the duration the discharge conveyor runs after the pusher completes its push. These timers work in 100th of a second.

4.3.14 Diagnostic



1. **I/O 1, I/O 2, Status, Event Screen Manual and General Setup:** Pressing these screen change buttons will bring up the screens and remain in the password-protected section of the touch screen.
2. **Main and Oper:** Pressing these screen change buttons will bring up the screens. They are colored yellow because they will take you out of the password-protected

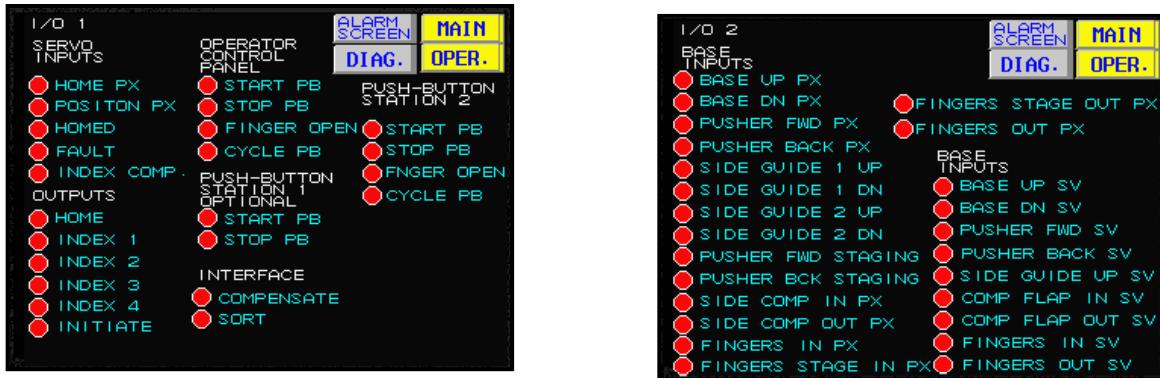
section of the touch screen and you will have to re-enter the password to return to the setup screens.

3. **Alarm Screen:** When an alarm condition occurs, the alarm screen automatically pops up on the screen. When the alarm screen is closed, it will not reactivate until a new alarm condition occurs. This button brings up the alarm screen to display any alarm conditions that still exists.
4. **Cycle Timer:** The cycle timer is used to measure the duration of either the compensation cycle or the discharge cycle. The timer is useful in tuning the machine or determining the minimum bundle size.
5. **Cycle Fault Timer:** The cycle fault timer is activated when a discharge or compensation cycle is activated and stays on until the cycle is complete. If this timer reaches the set point, it will cause the machine to fault out. The timer preset value needs to be a minimum of a $\frac{1}{4}$ second longer than the longest cycle.
6. **Batch Size:** A batch is the number of pieces required before a compensation cycle occurs. There are two values, set value and count value. The set value is the number of pieces before a compensation cycle occurs and the count value is the current number of pieces received to implement a compensation cycle. Note: If the difference between a batch size and a bundle size is less than the minimum bundle requirement, a compensation cycle will be ignored to allow the bundle to be completed for discharge.
7. **Stack Size:** A stack is the number of pieces required before a discharge cycle is activated. There are two values, set value and count value. The set value is the number of pieces required for a discharge cycle to occur and the count value is the current number of pieces received to implement a discharge cycle.
8. **Minimum Stack Size:** The minimum stack size sets the minimum number of pieces that the machine can receive to do compensation or discharge cycle. This value is determined by the feed rate of the product and time it requires to complete a stack discharge. To determine this value, multiply the feed rate for the product by the cycle time for the discharge cycle.
9. **Reset Machine:** The reset machine button will clear all counters, timers, and rest the compensation cycle and discharge cycle. It will not clear the production counter.

After the button is pressed, product in the machine will need to be removed by pressing the cycle machine button on the operator control panel.

10. **Simulate Cycle:** This toggle button, when active, will simulate product entering the machine. Each simulated piece is one second apart. This simulation will activate the compensation cycle and the discharge cycle.

4.3.15 I/O Screens



The I/O Screens displays the I/Os that are not displayed on the Status Screen. Not all I/Os will be described.

4.3.15.1 I/O Screen 1

Inputs

1. **Home Px:** Indicates the Turn Table is in the home position.
2. **Position Px:** Indicates the table is aligned with the discharge conveyor.
3. **Homed:** Activates when the servo finish its homing procedure.
4. **Fault:** The servo is currently faulted out.
5. **Index Comp:** Activates when the servo finish an Index move.

Output

1. **Home:** PLC instructing the servo to home itself.
2. **Index 1-4:** Outputs from the PLC to instruct the servo to move to a predefined position at a predefined speed. Movement does not occur until the Initiate is activated
3. **Initiate:** PLC telling the servo to initiate an index defined by the Index outputs.

Interface

1. **Compensate:** External signal to initiate a compensate cycle when the next piece of product crosses the Infeed Photo-Eye
2. **Sort:** External signal to initiate a discharge cycle when the next piece of product crosses the infeed Photo-Eye.

Push-Button

1. **Start, Fingers open, Cycle Pushbuttons:** These buttons uses a normally closed contact and the inputs are deactivated. When pressed, the inputs are activated.
2. **Stop Push-Button:** These buttons uses a normally closed contact to keep the signal high. When pressed, the signal is deactivated. The stacker will not go into run mode until the high signal is restored.

4.3.15.2 I/O Screen 2

These I/Os are used to control the movements of the pneumatic cylinders. The inputs are used for cylinder positions and the outputs are used to activate the cylinders. This screen is useful when trouble-shooting sensor positions valve controls.

4.3.16 Miscelaneous

The password is a four-digit number. A zero may be used in the first digit (0023). After changing the password, write the password down in a secured location. Do not depend on memory.

1. **New Password:** Enter the new password to be used. To get to this screen requires a password so old password is not required.
2. **Confirm Password:** Enter the password again to verify the password.



Enter: Pressing the enter button change the password. Exiting the screen before pressing enter will not change the password.

4.3.17 Clock Screen

1. **Seconds:** Numerical value range 0-59.
2. **Minutes:** Numerical value range 0-59.
3. **Hours:** Numerical value range 0-23.
4. **Date:** Numerical value range 0-31.
5. **Month:** Numerical Value range 1-12
6. **Year:** Numerical value defined as the 4 digits of the year.
7. **Local Day:** Numerical value range 0-6. Sunday is defined a 0.



4.4 COMPENSATING AND DISCHARGING

4.4.1 Methods of Compensating Bundles and Discharging Stacks

Compensating occurs when a batch is completed and the product in the stacker is rotated 180 degrees as the stacking process continues. Discharging occurs when a stack is completed and the product leaves the stacker in the completed stack while the stacking process on the next stack continues. There can be any number of batches in a stack from zero to whatever number is desired or possible depending on the size of the product.

Both compensating and discharging of the product is controlled using the following methods:

- Compensating batches and discharging stacks by count
- Compensating batches and discharging stacks by remote sort
- Compensating batches by count and discharging stacks by remote sort

Regardless of the method that is used, the minimum stack size must be calculated and set in the touch screen to prevent jams and allow for over stacking when necessary.

4.4.2 Minimum Stack Size

The maximum cycle time and the rate of the product being stacked (either in products per hour or products per minute) determine the minimum stack size set on the touch screen (see Minimum Stack Count Chart for the KR950 Compensating Stacker). The cycle time for the discharge cycle is used because the time it takes to discharge a stack will always be greater than the time it takes to compensate a batch. The number entered in the minimum stack size on the General Setup touch screen is the minimum number of product the stacker needs in the next batch or stack to ensure the stacker has time to complete the discharge cycle of the current stack being discharged before it can act to compensate or discharge the next batch or stack.

There are only two ways to decrease the minimum stack size needed, slow down the rate of product stacked or find a way to decrease the stack cycle time.

4.4.3 Compensating Batches and Discharging Stacks By Count

In compensating and discharging by count, a number is entered on the Operator touch screen in the set value for the desired batch size and a number is entered in the set value for the desired stack size.

The stack beam switch on the ramp/infeed conveyor (the second beam switch) counts the product right before it drops on the stack. As each product passes under the beam switch, a count of one is added to both the count value for the batch size and the count value for the stack size. When the count value for the batch size is equal to the batch size set value, the stacker compensates the stack and zeros out the count value in the batch size but not the count value in the stack size. This process continues until the number for the count value in the

stack size equals the number set in the set value for the stack size; then, the stacker discharges the stack and zeros out both the count values for the stack size and batch size.

To stack and discharge without compensating, enter the size of the stack size desired in the set values for the batch size and stack size (the same number) and the stacker will always discharge when this number is reached and zero out the count value for both the batch size and the stack size.

4.4.4 Remote Sort

Remote sort allows the compensation and stacking of the product using remote batch and remote stack signals. The word sort in remote sort comes from postal sorting. In postal sorting, the product is separated in trays and bundles for mailing and the stacks would accommodate the postal breaks in addition to any batching and stacking done to ease handling of the product. So, in essence, a sort signal is a stack signal. In remote sorting a system, such as an inkjet printing system, a camera system or a town sort system acts as a remote source to send a compensate signal to the stacker to designate the last product in a batch or a stack signal to the stacker to designate the last product in a stack.

NOTE: If an inkjet printing system is used for remote sort, it must be an intelligent printing system that can manipulate the database for compensate and sort signals. If it is an old inkjet printing system without an intelligent database, it won't work.

4.4.5 Over Stacking

The stacker automatically over stacks a batch or a stack if remote sort on the General Setup screen is turned on. Using the number entered in the minimum stack size, the stacker will cancel the compensate or discharge when a sort signal had been received and the number of product left to complete the stack for the signal is less than the number set in the minimum stack size. This will keep the stacker from shutting down because the stack resulting from the remote sort signal would be smaller than the minimum stack size and the stacker would not have time to complete a compensate or discharge of the canceled batch or stack before the stacker acted on the remote sort signal.

4.4.6 Compensating Batches and Discharging Stacks by Remote Sort

To compensate batches and discharge stacks by remote sort, access the General Setup touch screen and toggle on remote sort and remote batch. Then, set the stack size on the Operator screen to a number larger than the largest stack you will remote sort. This will keep the current count from reaching a value equal to the set value and discharging a stack in between remote stack signals. The batch size will automatically change to the stack size when remote sort and remote batch are both turned on so no compensation will occur from a batch count.

In addition to the stack beam switch, remote sorting requires use of the infeed beam switch to allow for tracking of the product from the time the remote sort signal is received from the remote source to the time it is stacked. Turning on the remote sort and remote batch changes the function of the infeed beam switch so that a count of one will be added to the sort and

compensate infeed count each time a product passes under the infeed beam switch. As product travel up the ramp and pass under the stack beam switch, a count of one is subtracted from the compensate and sort infeed count for each product that passes under the stack beam switch as the product drops on top of the stack in the stacker.

As products flow up the ramp and into the stacker, the sort and compensate infeed counts will increase to the number of product on the ramp/infeed conveyor. As the flow continues to come onto the ramp and go up and into the stacker the infeed beam switch will continue to add a count of one for each product into the stack and compensate infeed count and the stack beam switch will continue to subtract a count of one from the compensate infeed count and the sort infeed count. The result is that the sort and compensate infeed counts on the Operators screen will only increase to the maximum number of product that can fit on the ramp/infeed conveyor and oscillate from this number by one as the infeed and stack beam switches continue to add and subtract a count of one to the sort and compensate infeed counts.

To correctly track the last product in the batch or stack the appropriate signal must be sent when the last product in the batch or stack is to be the next product to pass under the infeed beam switch. If it is a compensate signal the compensate infeed count will increase by one for the designated product when the stacker receives the signal and will quit oscillating because no other products will be added to the compensate infeed count on the Operator screen. As the flow continues, the compensate infeed count will decrease by one for each product as it passes under the stack beam switch into the stacker till the last product in the batch is stacked. At that time the compensate infeed count will be zero and the stacker will compensate the stack. Also at that time, the compensate infeed count will increase to the number of product that passed under the infeed beam switch after the last product in the batch stopped the infeed count on the operators screen and began oscillating again plus or minus one to reflect the number of product on the ramp/infeed conveyor. The compensate infeed beam switch did not stop increasing the compensate infeed count by one when the compensate signal was received, it just went to memory for the next batch.

During all this time, the sort infeed count never quit oscillating plus or minus one because the compensate and sort counts are independent. When a sort signal is received, the sort infeed count will do the same as the compensate infeed count. The only difference is that the compensate infeed count will also zero out when the stack is discharged.

4.4.7 Compensating Batches by Count and Discharging Stacks by Remote Sort

To compensate batches by count and discharge by sort, turn the remote sort on and the remote batch off on the General Setup screen. Set the batch size desired and the maximum stack size desired on the Operator screen.

As product flow into the stacker and pass under the stack beam switch a count of one is added to the batch current count. With the exception of over stacking, the stacker will compensate the stack of product each time the current count for the batch size reaches the set value for the batch size.

In addition to the stack beam switch, remote sorting requires use of the infeed beam switch to allow for tracking of the product from the time the remote sort signal is received from the remote source to the time it is stacked. Turning on the remote sort changes the function of the infeed beam switch so that a count of one will be added to the sort infeed count each time a product passes under the infeed beam switch. As product travel up the ramp and pass under the stack beam switch, a count of one is subtracted from the sort infeed count for each product that passes under the stack beam switch as the product drops on top of the stack in the stacker.

As products flow up the ramp and into the stacker the sort infeed count will increase to the number of product on the ramp/infeed conveyor. As the flow continues to come onto the ramp and go up and into the stacker the infeed beam switch will continue to add a count of one for each product into the stack infeed count and the stack beam switch will continue to subtract a count of one. The result is that the sort infeed count on the Operators screen will only increase to the maximum number of product that can fit on the ramp/infeed conveyor and oscillate from this number by one as the beam switches continue to add and subtract a count of one to the sort infeed count.

To correctly track the last product in the stack the appropriate signal must be sent when the last product in the stack is to be the next product to pass under the infeed beam switch. When the remote sort signal is received by the stacker, stack infeed count will increase by one for the last product in the stack and will quit oscillating because no other products will be added to the current infeed count. As the flow continues, the stack infeed count will decrease by one as each product passes under the stack beam switch into the stacker till the last product in the stack is stacked. At that time the stack infeed count will be zero and the stacker will discharge the stack. The stacker will also zero out the batch size current count when it discharges. At the same time, the sort infeed count will increase to the number of product that passed under the infeed beam switch after the last product in the stack stopped the infeed count on the operators screen and began oscillating again plus or minus one to reflect the number of product on the ramp/infeed conveyor. The infeed beam switch did not stop increasing the infeed count by one when the signal was received, it just went to memory in the next stack.

To prevent the stacker from shutting down from a remote sort signal coming too soon after a compensate, it is recommended to move the infeed beam switch to an upstream machine to increase the number of products between the infeed and stack beam so that it is equal or greater than the number calculated and set in the minimum stack size so that the overstack feature in the program will be fully functional.

4.4.8 Moving the Infeed Beam Switch to an Upstream Machine

The distance between the infeed beam switch and the stack beam switch is approximately 36 inches. This distance is relatively short and depending on the size of the product could allow little as only three products at one time between the infeed and stack beam switches. In order for the oversize stack function to be fully functional the number of product at any given time between the infeed and stack beam switches must be equal or greater than the number set in the minimum stack size. To increase the number of product that can be overstacked, the

beam switch can be moved to an upstream machine to increase the distance between the infeed and stack beam switches and thus increase the number of product being tracked.

When the infeed beam switch is moved to an upstream machine, turn off the infeed jam on the General Setup screen and do not use the divert. To ensure tracking of every product, any time a product passes under the infeed beam switch, it is added to the infeed count whether or not the stacker is running.

4.4.9 Reset Machine

The reset machine button will zero out the current count for the batch and stack size as well as zero out the sort and compensate zero out.

4.4.10 Infeed Count Auto Reset

If on, the infeed count auto reset will automatically zero out the infeed count after the stacker has stop running for 15 seconds. It assumes a jam has occurred and clears the machine for restart. The infeed count auto reset can be turned off using the General Setup screen.

5 MAKE READY INSTRUCTIONS



WARNING

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

5.1 INTRODUCTION

The make ready instructions provided in this section describe the recommended procedures for preparing the stacker for a production run. Prior to beginning an actual make ready, the installation steps described in Section 4 of this manual should have already been completed. The following steps and adjustments should be made prior to the use of the stacker in production.

5.2 MAKE READY PROCEDURE

Before setting up the machine, it should be cleaned of any foreign material.

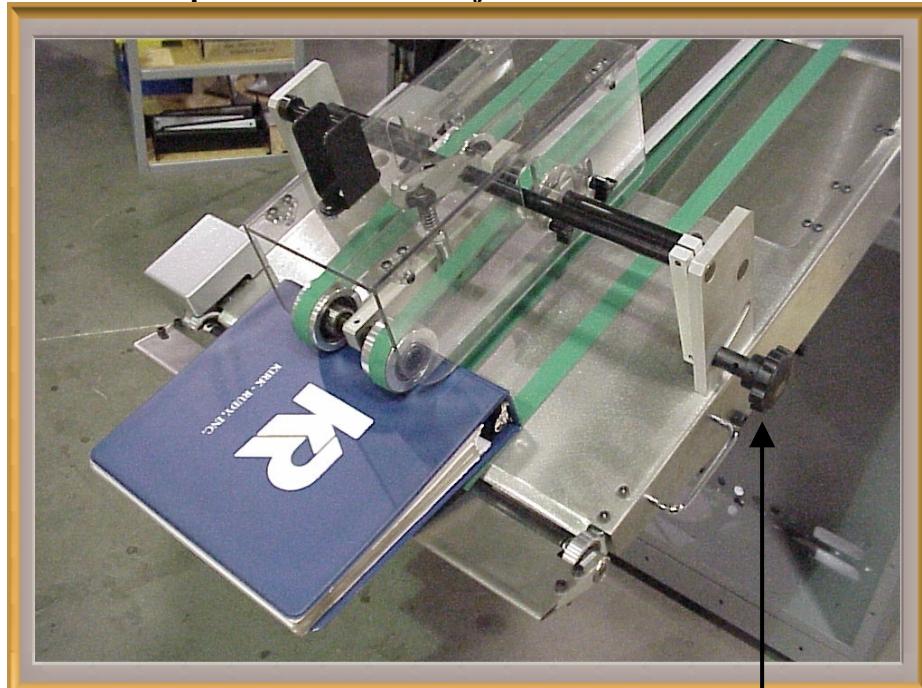
Paper debris is easily removed with low-pressure air. It is particularly important that the photocell sensors are free of any foreign material. When the machine is clean, proceed with the following make ready procedure.



WARNING

The power must be off and the power button locked in the “OFF” position before proceeding with the make ready procedure.

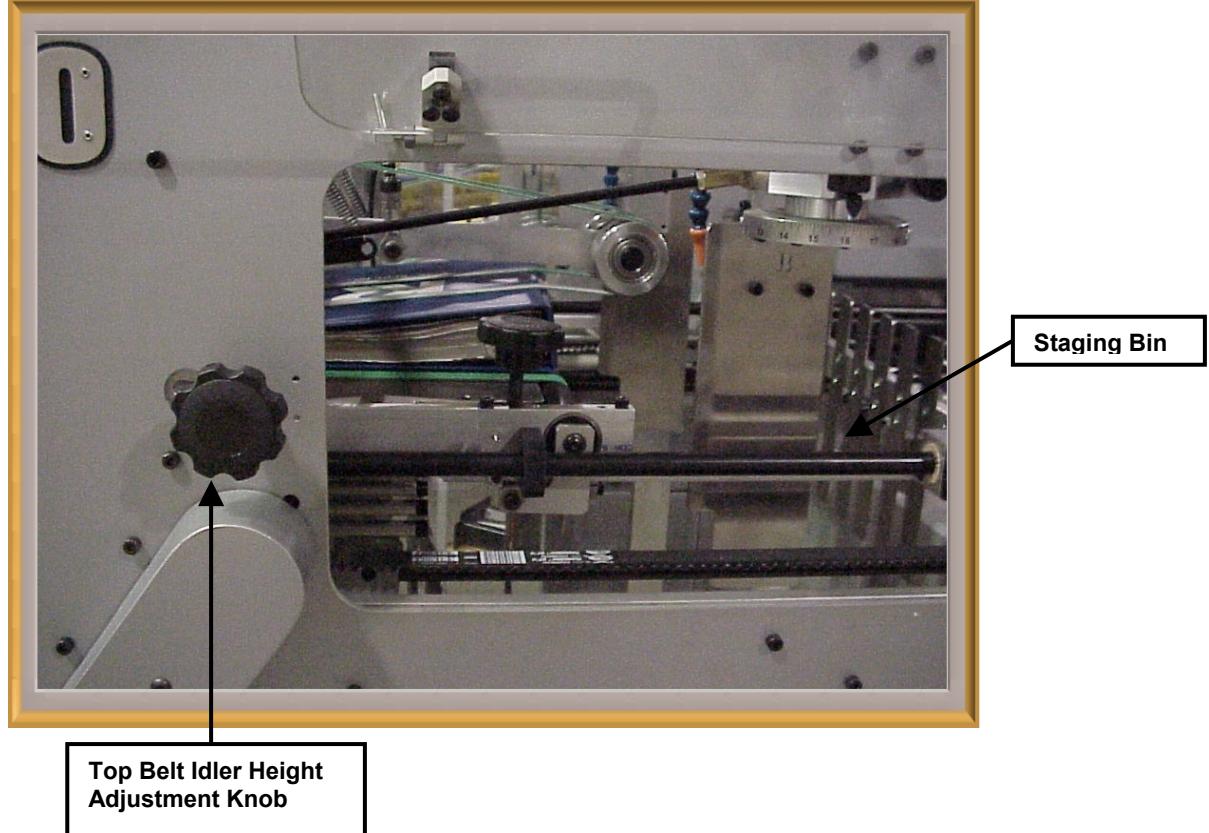
1. Set infeed product thickness adjustment.



**Infeed Product
Thickness Adjustment
Knob**

Loosen the infeed product thickness adjustment knob and pull the handle to the left. Place the product under the front rollers and rest the rollers on top of the product. Tighten the thickness adjustment knob and the roller height is set.

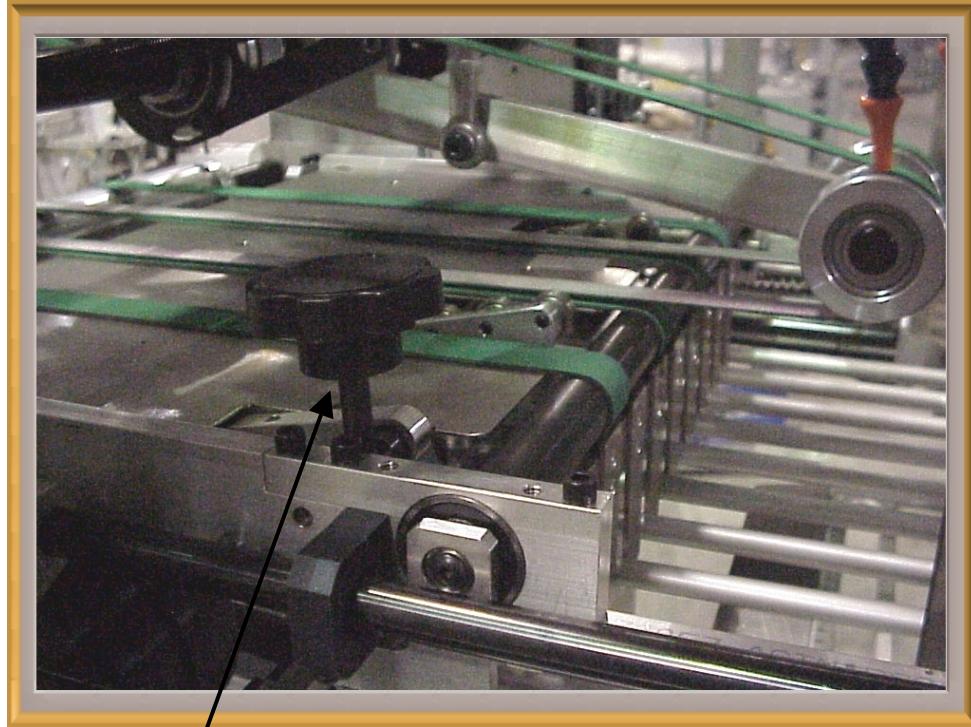
2. Set top belt idler height.



With the stop push-button in the “OFF” position and the staging bin safety door open, loosen the top belt idler height adjustment knob and pull the handle to the right. Place the product under the top rollers and rest the rollers on top of the product. Tighten the thickness adjustment knob and the roller height is set. Make sure the roller is parallel with the book. If the roller is set too low the product will be directed down and may not settle properly into the staging bin.

Note: The staging bin safety door has an interlock switch that prevents the machine from being operated when the guard is open.

3. Set the product dishing adjustment for product under $\frac{1}{4}$ " thick.

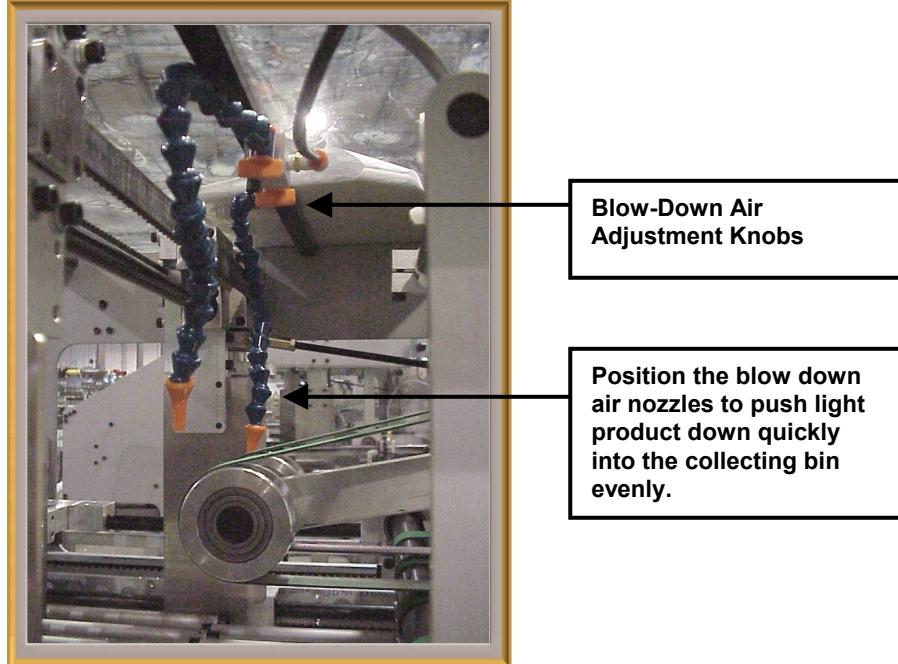


**Product Dishing Adjustment
Knob**

The product dishing rollers provide the ability to arch or bow the product as they are transferred from the infeed belts into the bin. Bowing the product provides stiffness and prevents the thinner products from “nose-diving” into the bin unit. With the stop push-button in the “OFF” position and the staging bin safety door open. Place the product between the upper and lower belts by lifting up on the upper belt idler roller. Rotate the product dishing adjustment knob to set the dishing rollers to the desired angle. The dishing rollers shouldn’t bow the product so much that a crease is formed. Just enough bow to provide proper stiffness works best. The width of the dishing rollers can be adjusted in and out if needed. Setscrews secure the roller arms on the flats of the mount shaft.

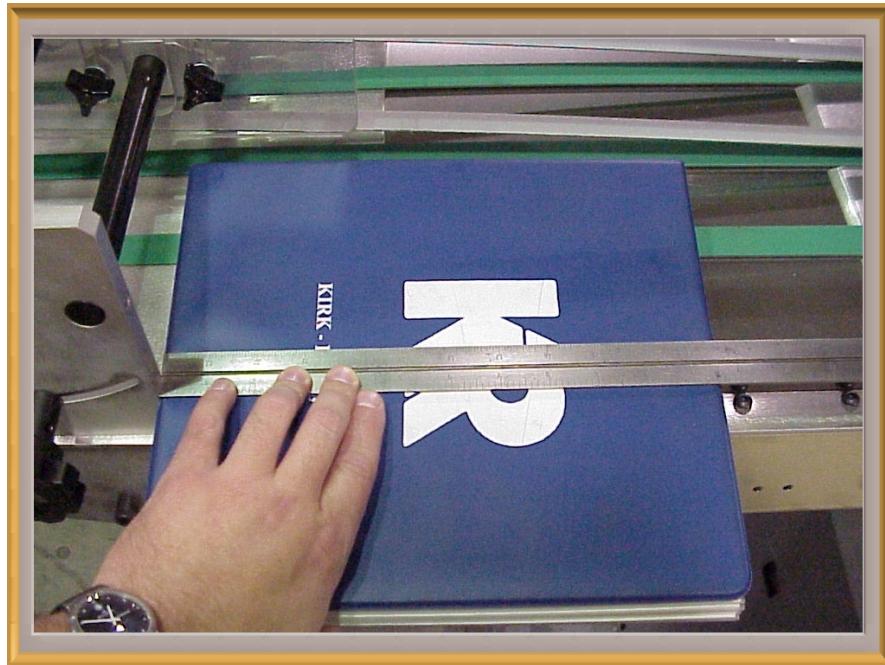
Note: The staging bin safety door has an interlock switch that prevents the machine from being operated when the guard is open.

4. Set and adjust the blow down air for product under 1/8" thick.

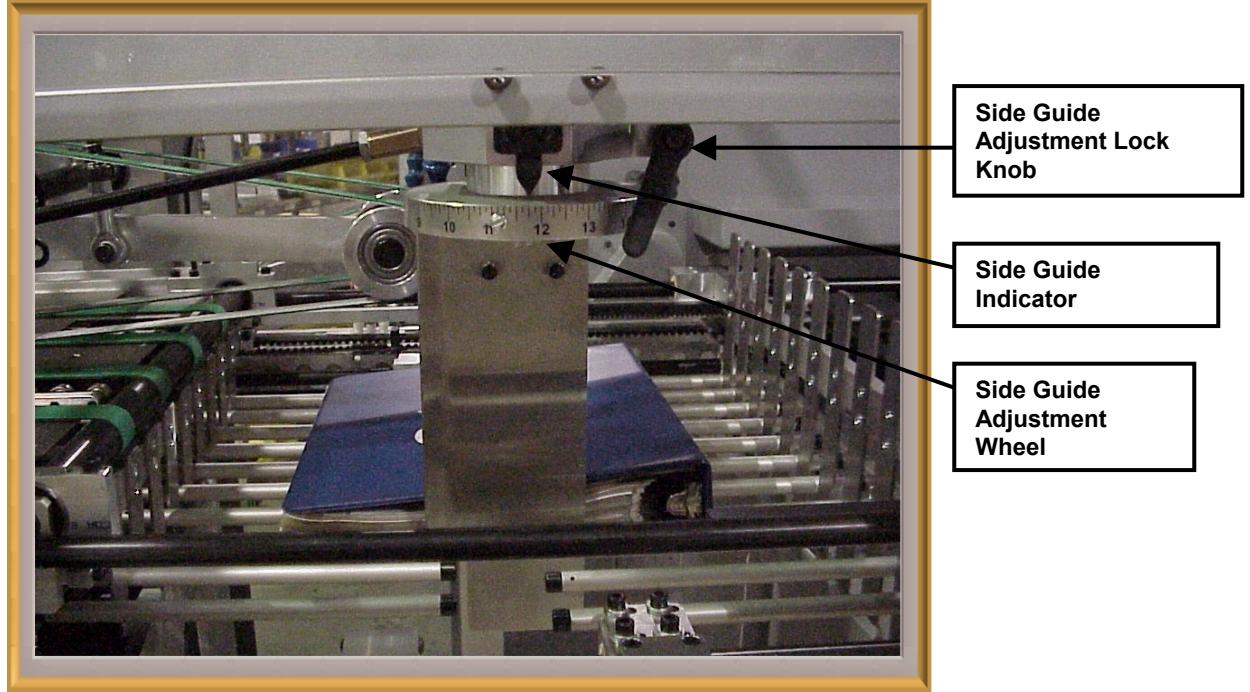


The blow-down air should be used to help light product drop properly in the staging bin. Light product tends to float down rather than drop. Any product thicker than $\frac{1}{4}$ " does not require blow-down air.

5. Measure the width of the product.



6. Set the product side guide adjustment to width of the product.



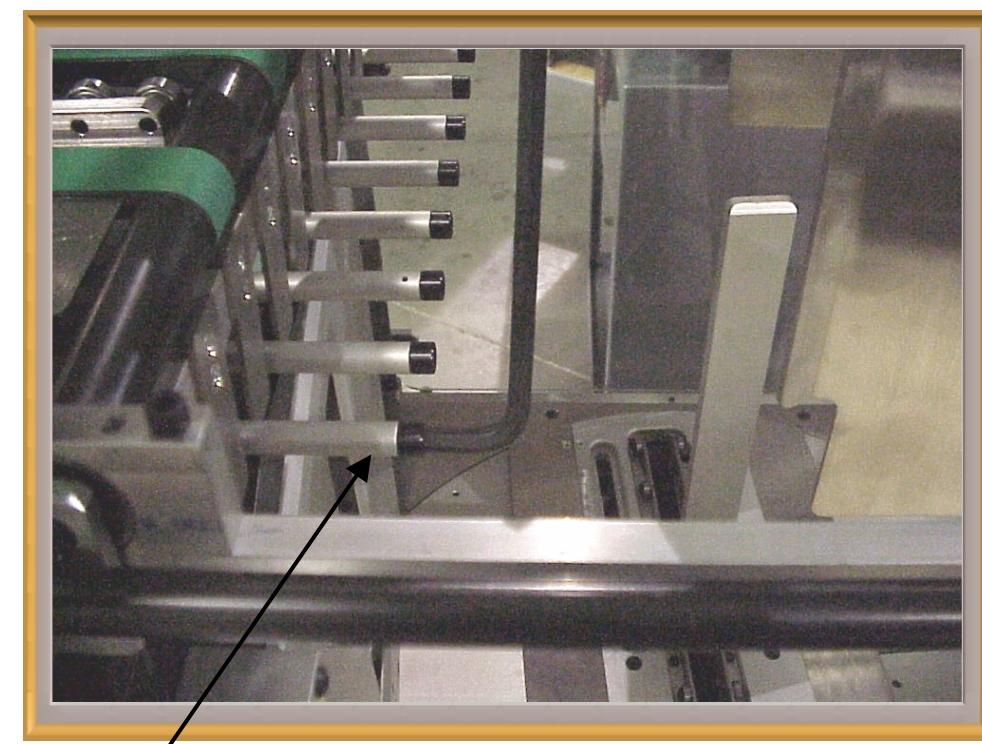
The side guides automatically keep the product centered. Loosen the side guide adjustment lock knob. Open the staging fingers to the width of the side guide. Product should be placed in the bin. Rotate the side guide adjustment wheel to move the guides with in 1/16" of the product edge. The side guides jog from side to side while in operation to form square stacks. Depending on where the side guides are in the jog cycle the guides could be set too tight for the product. Verify the scale indicates that the guides are set at least 1/16" wider than the product.

7. Make sure that the fingers clear the side guide and remove if needed.



Fingers are shown interfering with the side guide.

Remove the book and close the staging fingers by hand. If fingers hit the side guide they will have to be removed. Grab the infeed belt and pull the belt enough to see the side guide jog to make sure that the side guide doesn't hit the fingers.



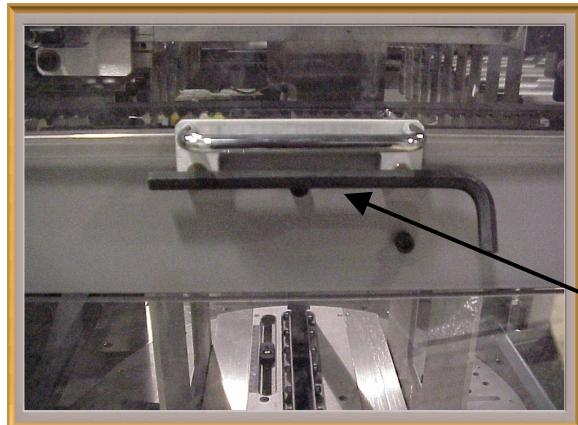
Remove the interfering finger with a 5/16 Allen wrench as shown.



**Showing Fingers removed
and clearing the side guide.**

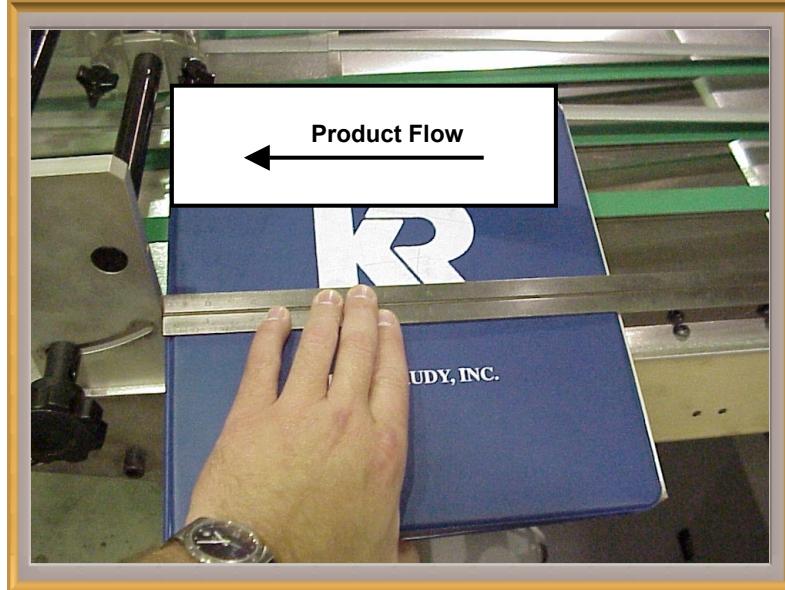


**Store the unused fingers
in this tray.**

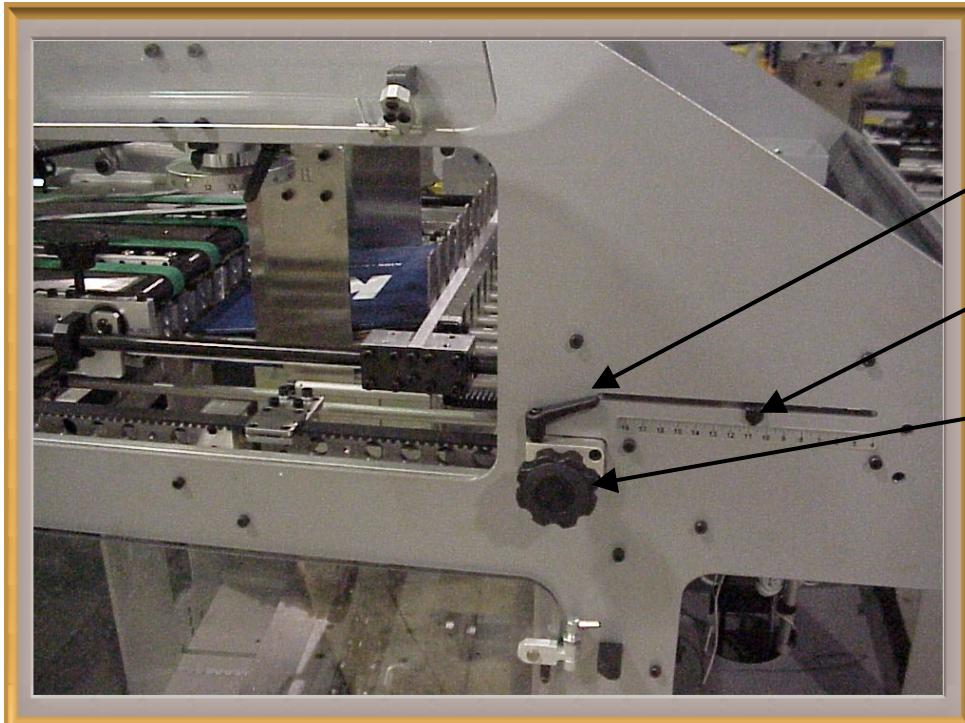


Store the 5/16" staging fingers Allen wrench on the magnet door latch as shown.

8. Measure the length of the book and record the measurement.



9. Set the front and back guides to the length of the product.



Product Length
Adjustment Lock
Knob

Product Length
Guide Adjustment
Indicator

Product Length
Adjustment Knob

Proper adjustment of the bin guides will ensure a neat uniform pile while letting the product drop freely into the bin. The front bin guide jogs to form tight stacks. The guides should be set to allow the front guide to jog the product. Loosen the product length adjustment lock knob. Place the product back into the staging bin. Rotate the product length adjustment knob until the front and back guides are $1/16"$ from the edge of the product. Lock the product length adjustment lock knob.

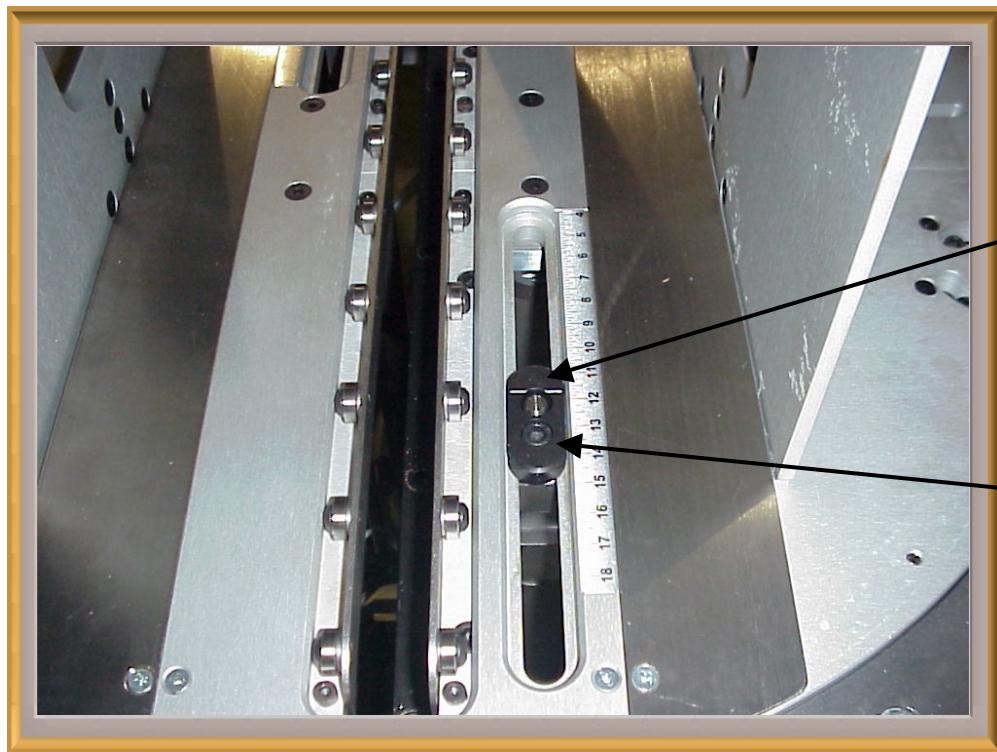
10. Set the turntable guide rods to the width of the product.



Use a $1/4"$ Allen
wrench to loosen
guide rod.



Store the $\frac{1}{4}$ " guide rod Allen wrench on the magnet door latch as shown.



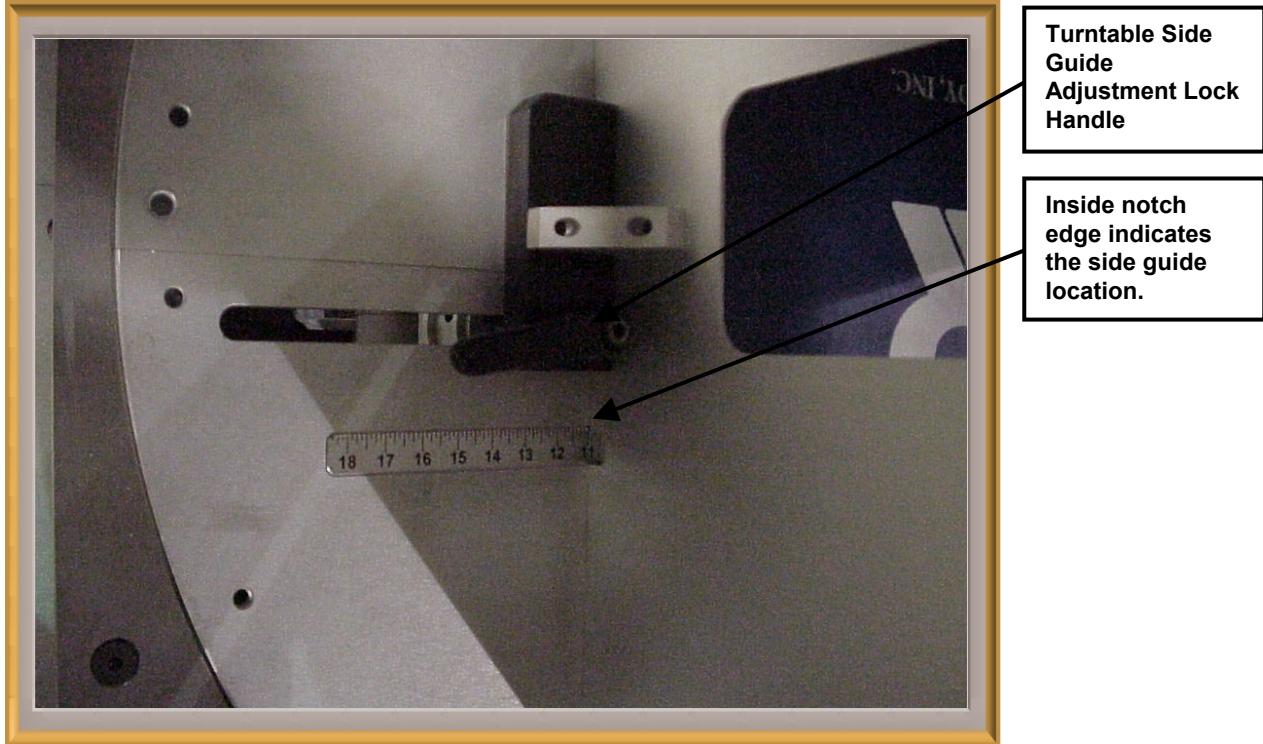
Line indicator up with the scale to the width of the product and tighten in place.

Guide Rod Locking Screw

With the stop push-button in the “OFF” position and the turntable safety door open loosen the guide rod locking screw. Using the line indicator slide the guide rod $\frac{1}{16}$ " wider than the product and tighten in place. Repeat this procedure for the other guide rod.

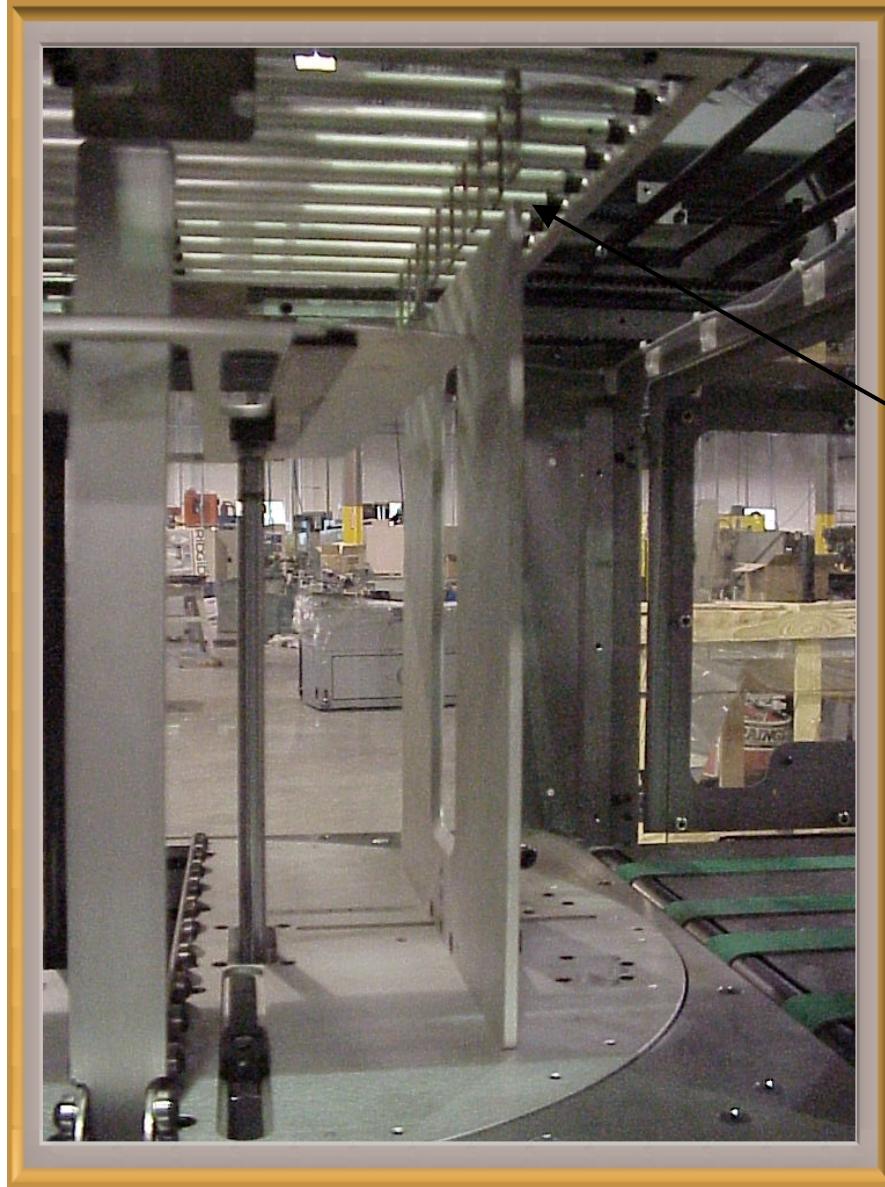
Note: The turntable safety door has an interlock switch that prevents the machine from being operated when the guard is open

11. Set the turntable side guides to the length of the product.



Loosen the turntable side guide adjustment lock handle. Slide the guide to 1/16" wider than the product using the inside notch edge on the scale and tighten in place. If the lift table wings are interfering with the side guide they will have to be removed. Refer to step number 13.

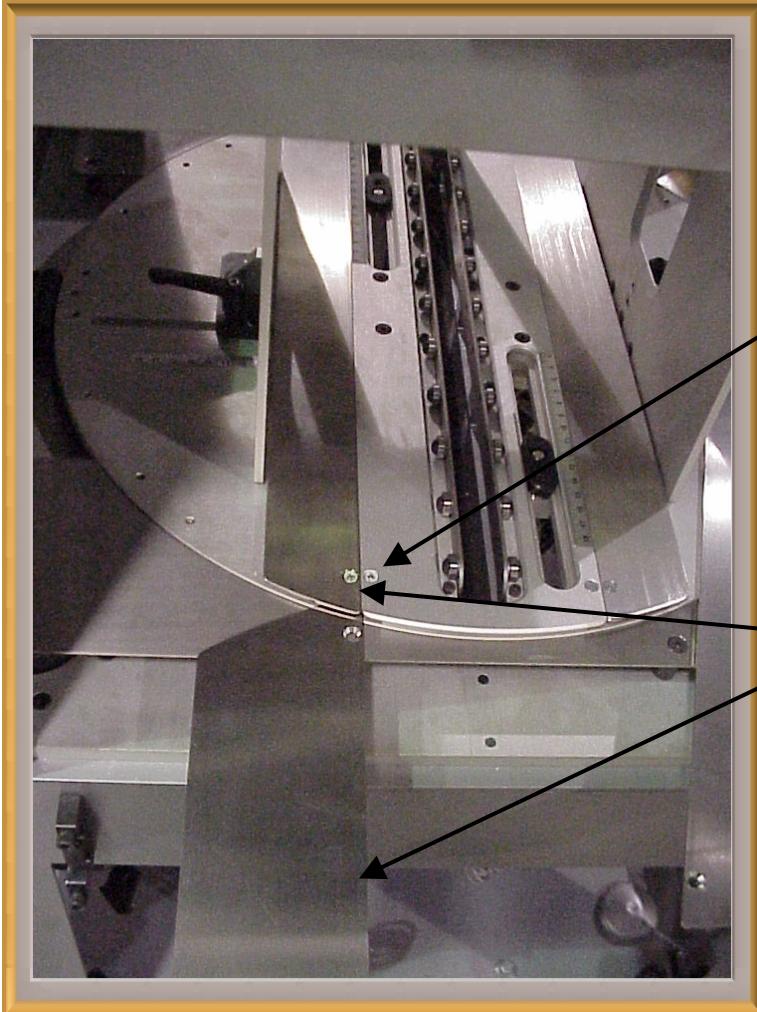
12. Verify that the turntable side guides are just outside the bin guides as shown.



Set top of side guide just outside the upper bin guides as shown here.

The upper guides can be used to set the lower guides as shown without having to use the scale to set the guides. Place the product in the turntable to make sure the guides have a 1/16" clearance on both sides.

13. Attach the appropriate lift table wing based on the product width.



Remove the screws from the aluminum when removing the wings. Remove the screws from the stainless when switching to a wider wing.

There are three different supported product widths. Use the widest lift table wing possible.

Thick product may not require the use of the lift table wings. The wings prevent thin product from curling down and provide support for the stack upon exiting.

14. Store the unused lift table wings in the tray provided.



Lift Table Wing Storage Tray

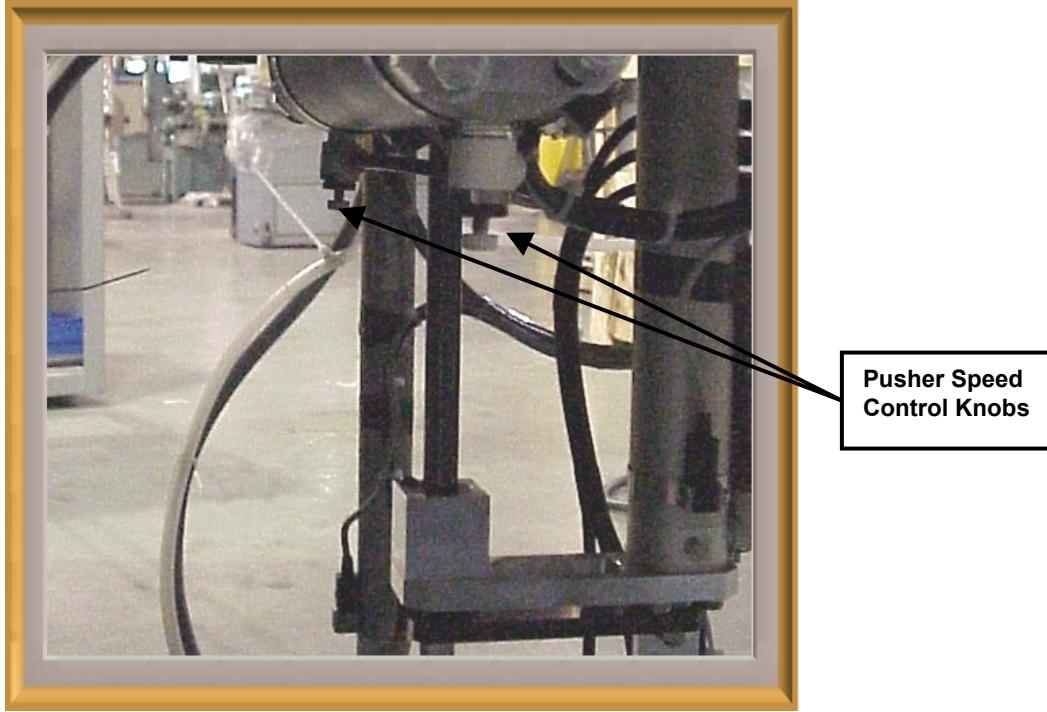
15. Set the infeed belt speed.



Infeed Conveyor Speed Control Knob

The belt speed of the infeed transfer belts is adjusted through the control knob located on the main control panel. The belt speed should be fast enough to ensure a gap of 2 to 6 inches between the books for the counter to function and for the books to drop in the bin (1" gap is the absolute minimum). If the books are too far apart resulting from the belt speed being too high, the books will hit the bin back guide at a higher velocity and may not drop into the bin properly. With the speed set to $\frac{3}{4}$ maximum setting hand feed a book and observe how hard the book hits the back bin guide. If the book drops well into the staging bin the speed is set to be fine-tuned in the start-up phase (see the Operation Section of this manual).

16. Set the pusher speed.



The push-out and return strokes must occur before the next “drop” of product occurs. A fast pusher speed is preferable to a slower one that causes the stacker to fault out because of a cycle overrun. The pusher speed can best be fine-tuned during the start-up phase (see the Operation Section of this manual). To make adjustments to the pusher speeds open the lower cabinet door opposite the discharge conveyor side. Locate the speed control valves on the pusher cylinder, as shown above. Press the “STOP” pushbutton and go to the configuration setup screen on the touch screen interface (*refer to Section 4.2.10*). With the pusher speed control knob accessible push the “AUTO” touch screen button and then the “TUNER OFF” button. The pusher should automatically cycle from one side of the turntable to the other. Screw the speed control knobs out to increase the speed and in to decrease the speed. The display on the touch screen interface shows the amount of time the pusher takes to go from one end of the turntable to the next. This gives you a reference point to record the pusher speed. Try to match the speed of both strokes using the speed reference on the touch screen. Once the speeds are set push the “MANUAL” touch screen button.

17. Set the discharge conveyor speed.



The purpose of the discharge conveyor is to deliver a completed stack to down stream equipment such as a strapper. The belt speed of the discharge conveyor belts is adjusted through the control knob located on the main control panel. The belt speed should be just fast enough to keep up with pusher speed. This will ensure that a completed stack will have a smooth transition from the turntable to the discharge conveyor. A speed set too slow will cause the stack to topple after the pusher has left the stack. A speed set too fast will cause the bottom of the stack to pull away from the pusher causing it to fall. The discharge conveyor speed can best be fine-tuned during the start-up phase (see the Operation Section of the manual).

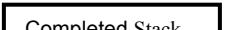
Note: The control panel swivel clamp lock handle is used to secure the control panel in place. The control panel can be swiveled and clamped in any position from 0 to 180 degrees out. A 45-degree setting is useful when the stacker is used in-line with a strapper.

18. Enter in the batch size and stack size into the touch screen interface.



A compensated stack is made up of batches. A batch is a group of product in the stack that is turned the same way. The “make-up” of a stack does not need to be uniform batches. The smallest batch will always be the last one on top of the bundle.

For example:

	<u>Touch Screen Setting</u>		<u>Stack Make-Up</u>
Example 1:	Batch Size: 5	Drop 2	 5
	Stack Size: 11	Drop 1	 6
Example 2:	Batch Size: 20	Drop 3	 10
	Stack Size: 50	Drop 2	 20
		Drop 1	 20
Example 3:	Batch Size: 25	Drop 2	 25
	Stack Size 50	Drop 1	 25
Example 4:	Batch Size: 25	Drop 2	 Completed Stack 25
	Stack Size 25	Drop 1	 Completed Stack 25

Note: In example 4 the batch and stack size are entered in as the same size. This causes the 25 books in the stack to be run without compensating. Each drop is a completed stack without the turntable turning.

Batch Size: There are two indicators for the Batch Size. The numeral button displays the current set value for the Batch Size. Pressing this button will bring up a popup keypad to change the set value. This value cannot be greater than the Stack Size. The second indicator displays the current batch count. Once the count reaches the set value, a compensation cycle will be activated and the counter will reset to zero.

Note: Even numbered batches eliminate an ejection cycle that result in a faster cycle time.

Stack Size: There are two indicators for the Stack Size. The numeral button displays the current set value for the Stack Size. Pressing this button will bring up a popup keypad to change the set value. The second indicator displays the current stack count. Once the count reaches the set value, a discharge cycle will be activated and the counter will reset to zero.

STACKER PARAMETERS

Now that the logic and stack make-up are understood, the four (4) key physical limitations of the stacker that affect the stack make-up will be explained.

- **Bin Capacity:** The depth of the bin in standard mode is 3-3/4". The depth of the bin in thick book mode (refer to Section 4.5.11) is 9". Books enter the stacker and are accumulated in the bin. Prior to the bin filling up, the books must be dropped to the turntable. *The depth of the bin thus defines the maximum number of books in a "drop".* For example, in standard mode $\frac{1}{4}$ " thick books are being stacked the maximum number of books in a batch is 15. Another example, in thick book mode ("Reverse Finger On" refer to Section 4.2.11) 1-1/2" thick books are being stacked the maximum number of books in a batch is 6.
- **Drop Table Cycle Time:** The drop table must reach the bottom before the ejection cycle can begin. *The greater amount of fall after each drop decreases the entire cycle time.* This is because the drop table has less distance to travel to the turntable after the last drop. The distance the drop table travels is set by a time value set in the "Compensation Setup" screen (see Section 4.2.13). The more time entered the further the drop table falls with each drop the faster the over-all cycle time.
- **Discharge Cycle Time:** The discharge cycle time is the time it takes the pusher to push-out the stack and then go back to its home position. While the discharge cycle is occurring, the books that are entering the stacker are collected in the bin. The discharge cycle time determines the minimum drop count. For example, if the cycle time is 2.6 seconds and 200 books per minute (12,000 books per hour) are being stacked, then the minimum drop count is:

$$\begin{aligned} 200 \text{ BPM} : 60 \text{ seconds per minute} &= 3.33 \text{ books per second} \\ (3.33 \text{ books per second enter the stacker}) \\ 3.33 \text{ books} \times 2.6 \text{ seconds} &= 8.7 \text{ books} \end{aligned}$$

Refer To the "Minimum Stack Count Chart Below"

Since the stacker cannot process parts of a book the minimum book drop is **9** books. A key point to understand is that during the discharge cycle, the "drop" that is being collected is the first drop of the next stack.

A stacker-overrun error will occur and stop the stacker when too few books are set in the batch size value. The more copies per hour the higher the minimum batch count must be. A minimum batch count value is set from the factory. The minimum batch count value can be changed in the general setup touch screen menu (see Section 4.2.11).

Note: Even numbered batches eliminate an ejection cycle that result in a faster cycle time.

- **Compensation Cycle Time:** As in the case of the discharge cycle time, the drop that is being collected while the compensation is occurring, must be of sufficient quantity of books to provide enough time for the compensate to be completed.
- *The minimum drop count will be limited by the discharge cycle time (2.6 seconds minimum) rather than by the compensation cycle time (1.0 seconds minimum).*

Minimum Stack Count Chart for the KR950 Compensating Stacker

Cycle time is product dependant and should be based on the required quality of stack produced.
The cycle time can be shortened by utilizing the fine-tuning procedures detailed in Section 6.5.
See note below on how to determine the cycle time.

No.	Books/Hour	Books/Min.	Cycle Time in Seconds										
			2.00	2.25	2.50	2.75	3.00	3.25	3.50	3.75	4.00	4.25	4.50
1	4000	67	2	3	3	3	3	4	4	4	4	5	5
2	4500	75	3	3	3	3	4	4	4	5	5	5	6
3	5000	83	3	3	3	4	4	5	5	5	6	6	6
4	5500	92	3	3	4	4	5	5	5	6	6	6	7
5	6000	100	3	4	4	5	5	5	6	6	7	7	8
6	6500	108	4	4	5	5	5	6	6	7	7	8	8
7	7000	117	4	4	5	5	6	6	7	7	8	8	9
8	7500	125	4	5	5	6	6	7	7	8	8	9	9
9	8000	133	4	5	6	6	7	7	8	8	9	9	10
10	8500	142	5	5	6	6	7	8	8	9	9	10	11
11	9000	150	5	6	6	7	8	8	9	9	10	11	11
12	9500	158	5	6	7	7	8	9	9	10	11	11	12
13	10000	167	6	6	7	8	8	9	10	10	11	12	13
14	10500	175	6	7	7	8	9	9	10	11	12	12	13
15	11000	183	6	7	8	8	9	10	11	11	12	13	14
16	11500	192	6	7	8	9	10	10	11	12	13	14	14
17	12000	200	7	8	8	9	10	11	12	13	13	14	15
18	12500	208	7	8	9	10	10	11	12	13	14	15	16
19	13000	217	7	8	9	10	11	12	13	14	14	15	16
20	13500	225	8	8	9	10	11	12	13	14	14	15	16
21	14000	233	8	9	10	11	12	13	14	15	16	17	18
22	14500	242	8	9	10	11	12	13	14	15	16	17	18
23	15000	250	8	9	10	11	13	14	15	16	17	18	19
24	15500	258	9	10	11	12	13	14	15	16	17	18	19
25	16000	267	9	10	11	12	13	14	16	17	18	19	20
26	16500	275	9	10	11	13	14	15	16	17	18	19	21
27	17000	283	9	11	12	13	14	15	17	18	19	20	21
28	17500	292	10	11	12	13	15	16	17	18	19	21	22
29	18000	300	10	11	13	14	15	16	18	19	20	21	23
30	18500	308	10	12	13	14	15	17	18	19	21	22	23
31	19000	317	11	12	13	15	16	17	18	20	21	22	24
32	19500	325	11	12	14	15	16	18	19	20	22	23	24
33	20000	333	11	13	14	15	17	18	19	21	22	24	25
34	20500	342	11	13	14	16	17	19	20	21	23	24	26
35	21000	350	12	13	15	16	18	19	20	22	23	25	26
36	21500	358	12	13	15	16	18	19	21	22	24	25	27

In order to read the actual cycle time press the "Stop" button. Press the "Start" button and then the "Cycle" button. The last number displayed in the "Cycle Timer" field on the "Maintenance" screen is the cycle time that is used for this chart. Refer to Section 4.2.7 for the "Maintenance" screen location.

6 OPERATION



WARNING

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

6.1 INTRODUCTION

The section of this manual deals with the running of the stacker to produce stacks of books. The stacker must first be prepared following the Make Ready instructions.

6.2 CONTROLS

“RUN” and “STOP” pushbuttons are located at convenient points on the stacker. Following international color codes, the “RUN” pushbuttons are green and the “STOP” pushbuttons are red “mushrooms”. Take a walk around the machine with the specific purpose of familiarizing yourself with the control pushbuttons. (See Figures 15.0 and 16.0)

The operator should also be aware of the Systems Interlock. If the interlock plug is connected and if the stacker stops because of either a “STOP” push button actuation or a jam switch actuation, the upstream system will also come to a halt. The upstream system cannot be started until the stacker is running.

The stacker however, is an independent unit from the upstream system in that a “stop” of the upstream system will not stop the stacker.

6.3 PRESTART CHECKS

Check to make certain that all tools, cleaning cloths and foreign materials have been removed from the stacker area.



WARNING

Make certain all safety and access covers have been installed before starting operation.

6.4 START-UP

The start-up of the stacker must be integrated with the start-up of the entire production system. This manual’s scope is limited to the stacker. Ensure operator understanding of the entire system before beginning its operation.

When stacker make ready procedures are complete, the start-up for a production is as follows:

- Ensure that make ready for the entire system has been completed.
- Check to ensure that all personnel are clear of the stacker and then press the “RUN” pushbutton.
- Produce six (6) to ten (10) books and monitor them as they drop into the bin.

- Produce enough books to make a stack and monitor how the stack is formed. If drops, compensates and total stack are acceptable, proceed into full production. If they are not acceptable, first check to ensure that the make ready procedure was followed; if difficulty still exists, proceed to the Operating Procedures.
- As the operating speed of the book production system is increased, monitor the performance of the stacker to ensure acceptable stack quality is still being maintained.

6.5 FINE TUNING

This phase of the manual deals with the adjustments that are more effectively done when the stacker is in operation. Some adjustments vary as a function of speed. In most cases, “starting points” are provided in the Make Ready Section. However, as the operator gains experience with the equipment and the products being run, revised Make Ready “starting points” appropriate for each set of conditions should be monitored and recorded in a log book.

The two key areas of the machine to observe during the operation are the “drops” being formed in the bin and the stacks being formed in the turntable basket. If the drops and stacks are not neat, uniform and the proper count, then the following areas may need to be fine-tuned.



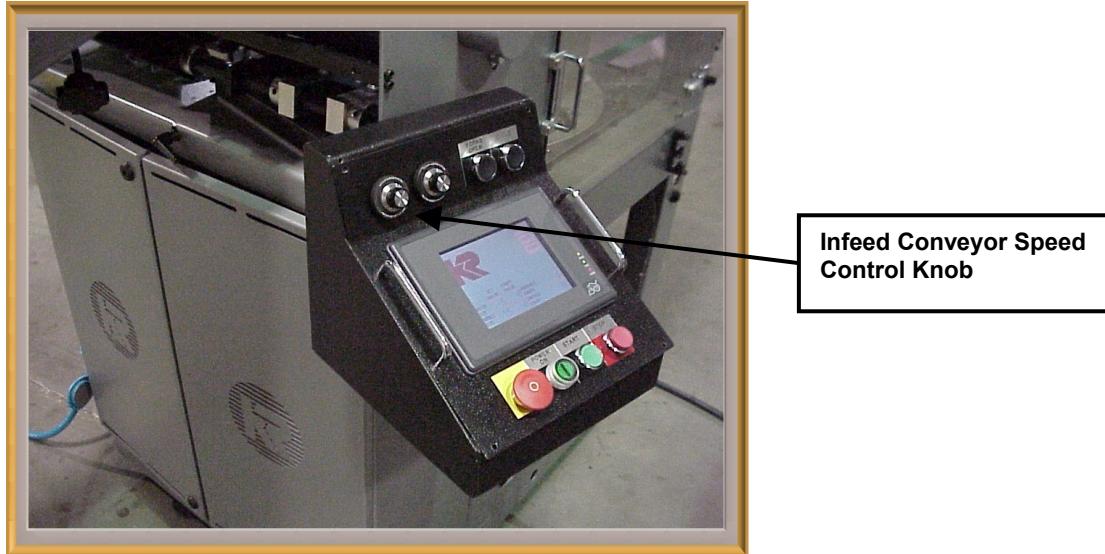
WARNING

Use extreme caution when making any adjustments while the machine is running.

6.5.1 INFEED BELT SPEED

The belt speed of the infeed transfer belts is adjusted through the control knob located on the main control panel. The belt speed should be fast enough to ensure a gap of 2 inches to 6 inches between the books for the counter to function and for the books to drop in the bin (1” gap is the absolute minimum). If the books are too far apart resulting from the belt speed being too high, the books will hit the bin back guide at a higher velocity and may not drop into the bin properly.

The optimum gap for normal operating speeds (12,000 CPH to 15,000 CPH) is 4 inches. If the product is large (bigger than A4 or 8-1/2” x 11”) and/or running at high speeds (18,500+ CPH) the gap should be reduced to 2 inches.



6.5.2 PRODUCT DISHING ROLLERS

The product dishing rollers should already be set and only require fine-tuning. The same criterion applies as for the original set-up. Raise the rollers to give more bow than thus more stiffness to the books as they enter the bin. Ensure that the books are not marked and will not jam because the guide rollers are set too high.

6.5.3 BLOW-DOWN AIR

The blow-down air attachment is located above the bin. The function of the blow-down air is to help light product drop into the bin. Light products tend to float down rather than drop. Any product thicker than $\frac{1}{4}$ " does not require blow-down air.

The three adjustable aspects of the blow-down air are: location of the tip, direction of the tip and air flow volume. It is recommended that the blow-down air be used as the final step in resolving a pile-forming problem in the bin. Adjustment of the blow-down air can best be accomplished through experimentation for each specific application.

6.5.4 PUSHER SPEED

The pusher speed should be adjusted from the Make Ready procedure and only require fine-tuning at this point. This is especially true when the speed of the book production system is increased or decreased.

The complete stacker cycle time (starting with the first book until the completed stack is discharged) is longer when compensating stacks with an odd number of batches and shorter with an even number of batches. For example, if the total number of books in a stack is 24 with stacks of 12 then the pusher return cycle is removed since the last discharge places the pusher in the location required to start the next cycle. If the total number of books in a stack is 24 with stacks of 8 the pusher has to include a return cycle after the last discharge to be in place for the next cycle. Always try to have an even number of batches to take advantage of eliminating a pusher return cycle motion. This allows the pusher speed to be reduced and will deliver stacks of product more gently. Removing the necessity for a return stroke reduces the entire cycle time allowing faster operation.

First observe the pusher speed while the stacker is in operation. Observe the length of time the pusher is in its home position before the first “drop” of books for the next stack is released. If the pusher doesn’t just make it to its home position just as the next stack is being dropped the speed of the pusher can be reduced. If the pusher doesn’t make it back to its home position before the next stack is to be dropped the stacker will stop with a “stack overrun” displayed on the touch screen control panel. The optimum speed of the pusher is one that allows the pusher to only rest for a moment before the staging fingers are opened.

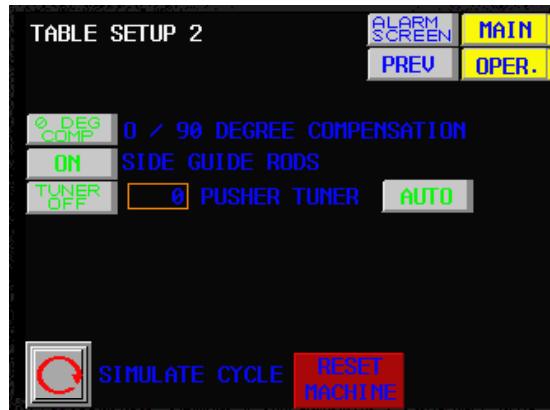


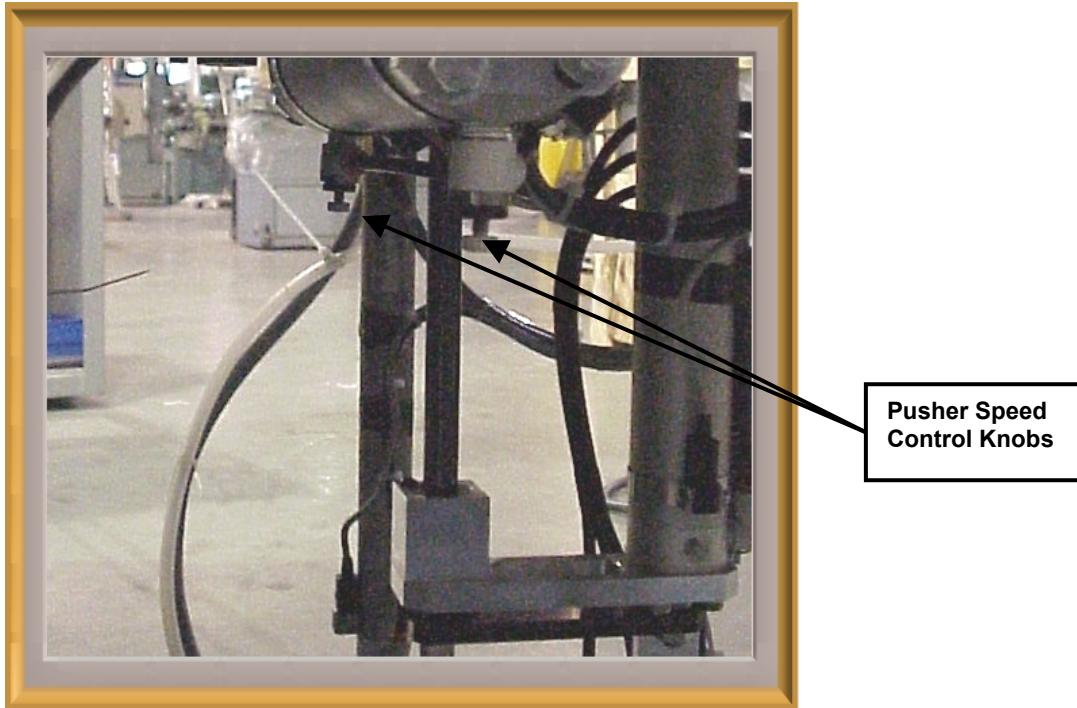
WARNING

Use extreme caution when making any adjustments while the machine is running.

To make adjustments to the pusher speed open the lower cabinet door opposite the discharge conveyor side. Locate the speed control valves on the pusher cylinder, as shown below. Press

the “STOP” pushbutton and go to the configuration setup screen on the touch screen interface (**refer to Section 4.2.12**). With the pusher speed control knob accessible push the “AUTO” touch screen button and then the “TUNER OFF” button. The pusher should automatically cycle from one side of the turntable to the other. Screw the speed control knobs out to increase the speed and in to decrease the speed. The display on the touch screen interface shows the amount of time the pusher takes to go from one end of the turntable to the next. This gives you a reference point to record the pusher speed. Try to match the speed of both strokes using the speed reference on the touch screen. Once the speeds are set push the “MANUAL” touch screen button.





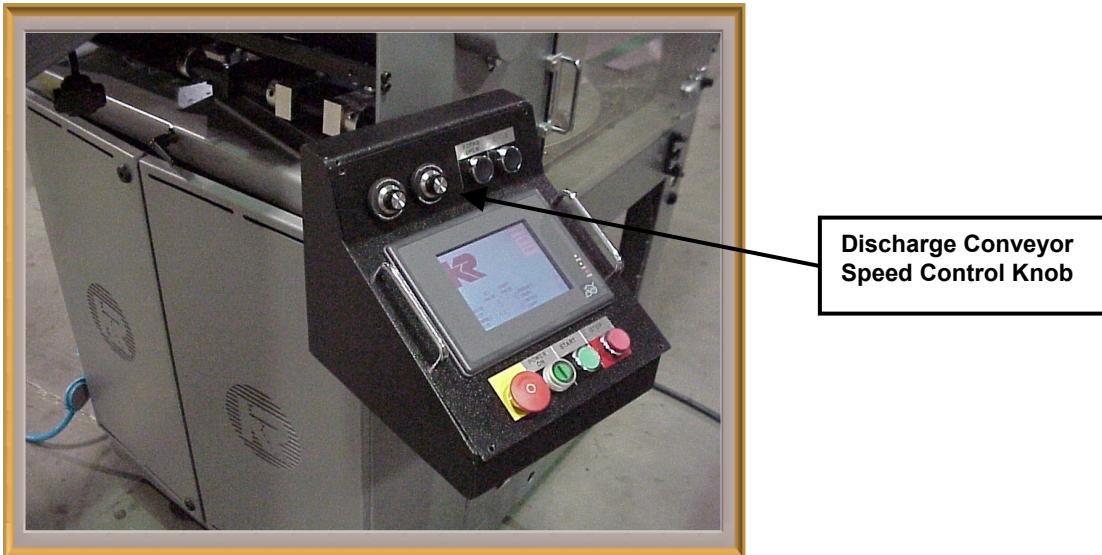
Refer to Section 4.2.10

If after adjusting the pusher speed it is found that pusher can't return to its home position before the staging fingers need to open, these are your options:

- Increase the number of product in the batches.
- Speed up the pusher eject.
- Use an even number of batchers to make up the stack.
- Reduce the operating speed of the book production system.

6.5.5 DISCHARGE CONVEYOR BELT SPEED

The purpose of the discharge conveyor is to deliver a completed stack to down stream equipment such as a strapper. The belt speed of the discharge conveyor belts is adjusted through the control knob located on the main control panel. The belt speed should be just fast enough to keep up with pusher speed. This will ensure that a completed stack will have a smooth transition from the turntable to the discharge conveyor. A speed set too slow will cause the stack to topple after the pusher has left the stack. A speed set too fast will cause the bottom of the stack to pull away from the pusher causing it to fall.



6.6 CLEARING A JAM

As with any automated high-speed paper handling equipment jams are expected from time to time. The procedure to clear a jam is as follows:

- Push a “STOP” pushbutton on any of the control panels.
- Press “OPEN FINGERS” pushbutton on one of the control panels (only required if the jam is involved with the staging bin).
- Open the appropriate guard door closest to the jam.
- Remove the jammed product.
- Close the guard door.
- Press the “RUN” pushbutton on any of the control panels.

Note: The guard-doors have interlock switches that prevent the machine from operating when the guard door is open.

The interrupted stack will resume with the proper number of books if the jam occurred before the outfeed photo-eye. If the jam occurred in the bin or turntable the stack will be short the amount of products that jammed. If necessary the operator can replace the number of books onto the stack.

6.7 TROUBLE SHOOTING

Problem	Solution
Machine will not start	Unlatch stop buttons (feeder control box, control panel, conveyor). 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 main disconnect. Check fuses.
Stack Over Run Alarm	Increase amount of books in batch. Refer to 5.2.18
Infeed Jam Alarm	A jam alarm occurs when the infeed eye is blocked for a specific duration. Clear the jammed product and press the start button to reset the alarm.
Stack Jam Alarm	A stack alarm occurs when the stack eye is blocked for a specific duration. Clear the jammed product and press the start button to reset the alarm.

7 MAINTENANCE



WARNING

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

Clean from paper dust See Figures A and B (Below)	Use clean soft rag soaked in water. Do not use solvents to clean
Clean or replace	Use clean soft rag soaked in water. Do not use solvents to clean belts.
Check tension of flat belts See Figures C and D (Below)	Add pressure to the spring loaded take up arms if the belts are loose.
Oil wick on the V-Guide Roller Cover See Figure E (Below)	Apply 30 weight oil to both sides of the roller cover wicks.
Check tension of drive belt See Figure F (Below)	Use take up from top side of turntable to tighten the drive belt.
Grease pusher track See Figure G (Below)	Apply grease to pusher track underneath the turntable.
Grease rack and pinon See Figure H (Below)	Apply grease to the pusher gear rack underneath the turntable.

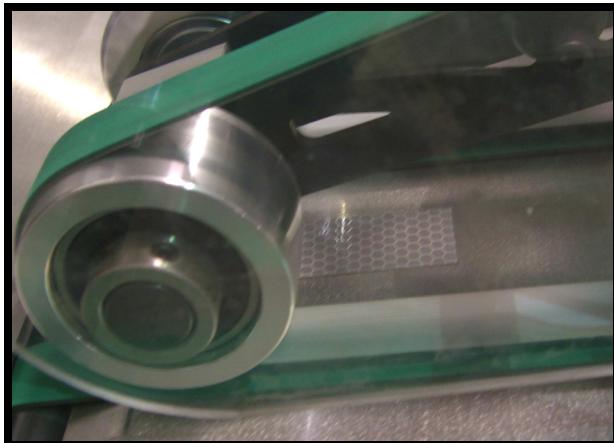


Figure A

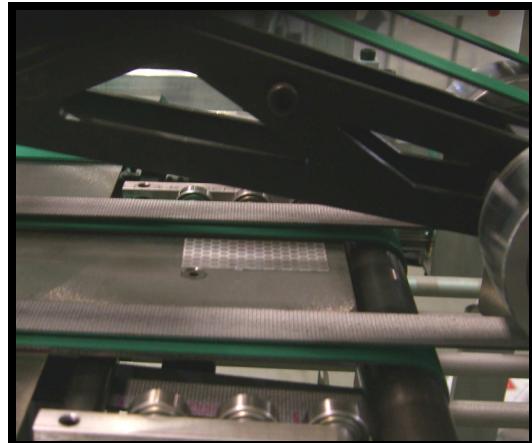


Figure B

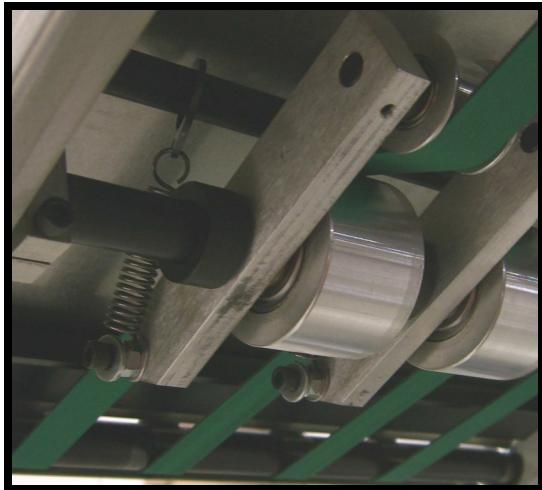


Figure C

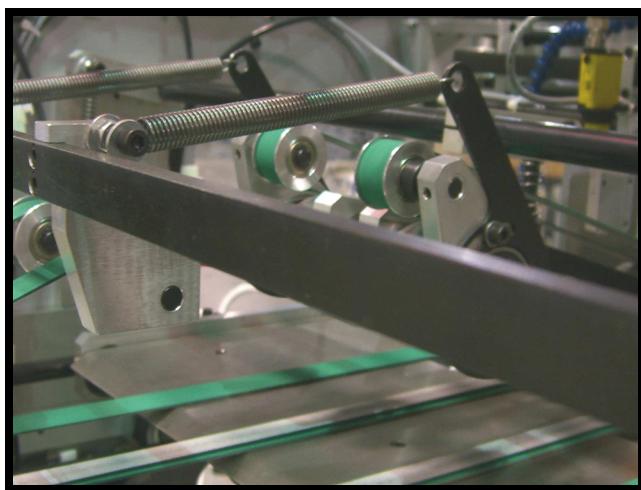


Figure D

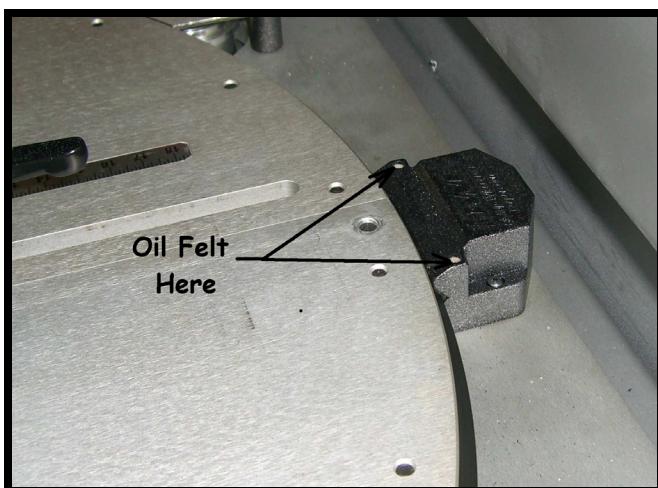


Figure E

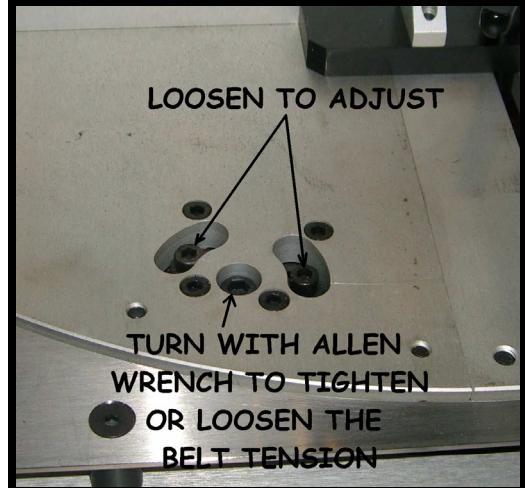


Figure F

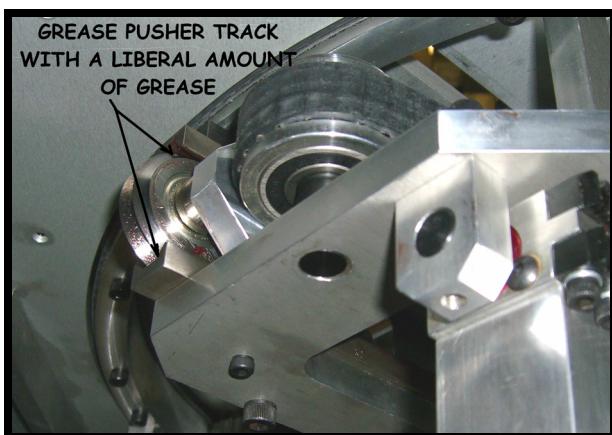


Figure G



Figure H

8 PARTS LISTS AND DIAGRAMS

8.1 PARTS LIST

See following pages for parts list.

8.2 DIAGRAMS

NO.	DRAWING #	DESCRIPTION
1	.KR950	ASSY, COMPENSATION STACKER
2	543899-01	ASSY, TURN TABLE AND MOUNT
3	543994-01	ASSY, TURN TABLE DRIVE
4	543902-01	ASSY, GUIDE WHEEL CONCENTRIC
5	543901-01	ASSY, GUIDE WHEEL ECCENTRIC
6	543919-02	ASSY, SERVO MOTOR
7	543923-01	ASSY, DIVERT ROLLER
8	547182-01	ASSY, TURN TABLE GUIDE
9	543896-01	ASSY, TURN TABLE
10	543972-01	ASSY, TURN TABLE
11	543926-01	ASSY, HTD BELT TAKE UP
12	543926-02	ASSY, HTD BELT TAKE UP
13	543962-01	ASSY, TABLE ROLLER
14	543910-01	ASSY, SIDE GUIDE
15	543915-01	ASSY, RETRACTABLE PRODUCT GUIDE
16	543915-02	ASSY, RETRACTABLE PRODUCT GUIDE
17	543933-01	ASSY, PUSHER
18	543923-02	ASSY, DIVERT ROLLER
19	543948-01	ASSY, PUSHER BAR
20	543902-01	ASSY, GUIDE WHEEL CONCENTRIC
21	543953-01	ASSY, PRODUCT LIFT
22	547235-01	ASSY, AIR VALVE
23	545602-01	ASSY, STACKER CABINET
24	538024-01	ASSY, 1 IN. LEVELING LEG
25	547463-02	ASSY, HORIZONTAL ADJUSTMENT
26	547507-01	ASSY, ADJUST ROLLER
27	547507-02	ASSY, ADJUST ROLLER
28	538024-01	ASSY, 1 IN. LEVELING LEG
29	547513-01	ASSY, HYDRALIFT LEG
30	539425-03	ASSY, HYDRALIFT LEG
31	547518-02	ASSY, HANDWHEEL
32	539425-02	ASSY, LH HYDRALIFT LEG
33	539424-02	ASSY, RH HYDRALIFT LEG
34	545621-01	ASSY, ELECTRICAL BOX
35	547187-01	ASSY, STACKER CONTROL PANEL
36	547201-02	ASSY, AIR REGULATOR
37	208504-1	ASSY, FILTER/FINGER GUARD

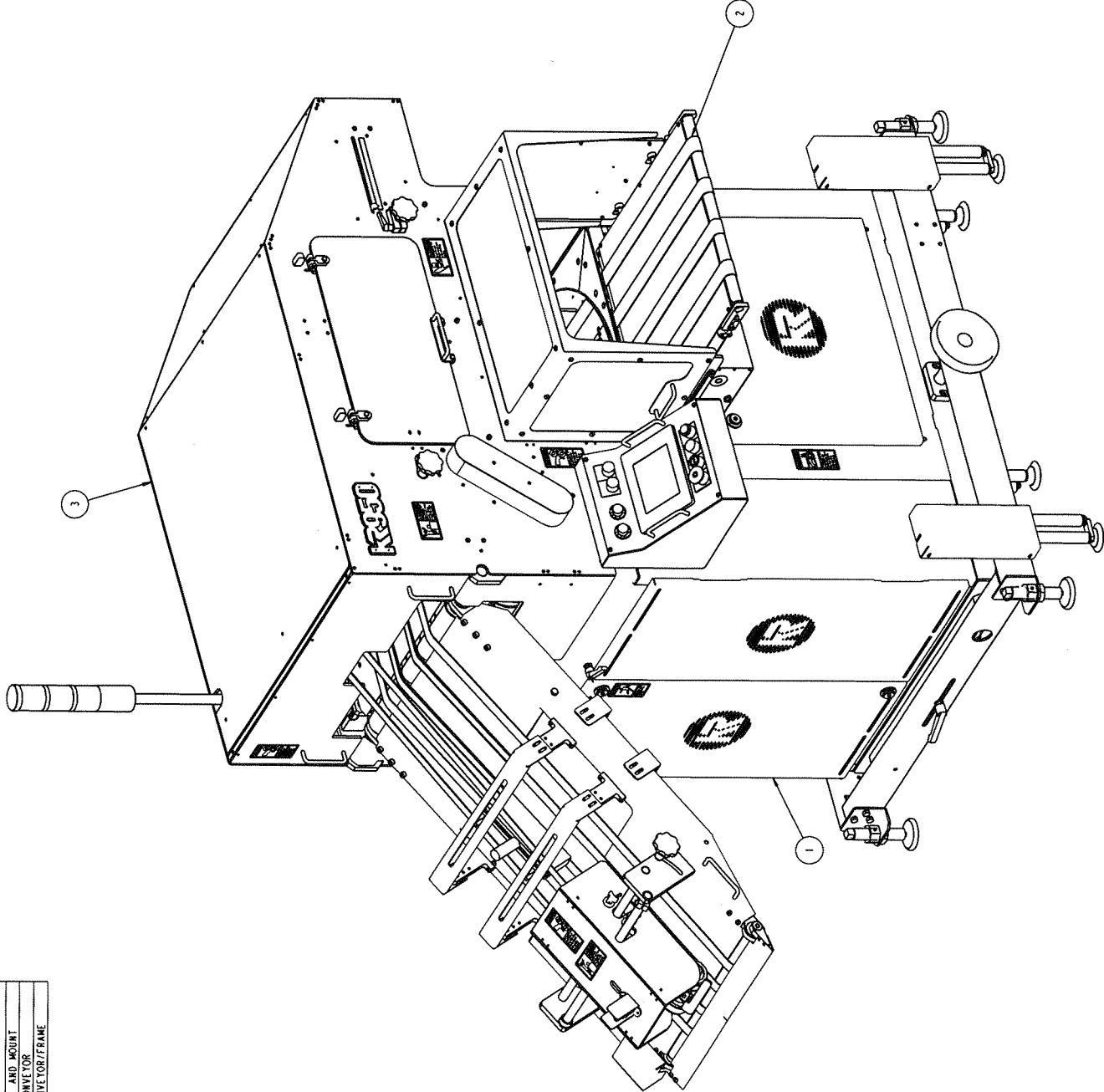
38	. 547236-01	ASSY, AIR MANIFOLD
39	. 545800-01	ASSY, INFEED CONVEYOR/FRAME
40	. 543980-01	ASSY, PRODUCT CATCH FINGER
41	. 543985-01	ASSY, INFEED FINGER
42	. 543989-01	ASSY, PRODUCT CATCH FINGER
43	. 543986-01	ASSY, OUTFEED FINGER
44	. 543989-01	ASSY, PRODUCT CATCH FINGER
45	. 545625-01	ASSY, BELT TAKEUP
46	. 547213-01	ASSY, FINGER VALVE
47	. 545632-01	ASSY, STACKER FLAT BELT
48	. 545738-01	ASSY, BELT DRIVE FRAME
49	. 545636-03	ASSY, CONVEYOR IDLER ROLLER
50	. 545636-01	ASSY, CONVEYOR DRIVE ROLLER
51	. 545637-01	ASSY, BELT ADJUST
52	. 545727-01	ASSY, PRODUCT DISHING
53	. 547208-01	ASSY, BEAM SWITCH MOUNT
54	. 545653-01	ASSY, BACK SIDE GUIDE
55	. 547215-01	ASSY, SIDEGUIDE ADJUST SHAFT
56	. 545657-01	ASSY, BACK SIDE GUIDE SLIDE
57	. 545666-01	ASSY, INFEED BELT RAMP
58	. 534814-07	ASSY, VALVE CYLINDER PLATE
59	. 545704-01	ASSY, UPPER BELT
60	. 547204-01	ASSY, OUTFEED CONVEYOR COVER
61	. 545673-01	ASSY, BELT TAKE UP
62	. 545674-02	ASSY, ROLLER
63	. 545678-01	ASSY, TAKEUP 1 IN BELT
64	. 510611A	ASSY-ROLLER
65	. 547533-01	ASSY, STATIC BAR
66	. 545684-01	ASSY, UPPER BELT
67	. 545696-01	ASSY, TAKEUP 1 IN BELT
68	. 510611-1A	ASSY-ROLLER
69	. 545696-02	ASSY, TAKEUP 1 IN BELT
70	. 510611-1A	ASSY-ROLLER
71	. 545699-01	ASSY, BELT DIVERT ROLLER
72	. 545707-01	ASSY, UPPER SIDEGUIDE
73	. 545718-01	ASSY, RH SIDEGUIDE
74	. 545719-01	ASSY, RH SIDEGUIDE
75	. 538022-06	ASSY, MOTOR MOUNT
76	. 530654-03	ASSY, MOTOR MTG BAR
77	. 545750-01	ASSY, INFEED LIFT
78	. 545748-01	ASSY, SIDE FRAME
79	. 545782-01	ASSY, LEXAN DOOR
80	. 545779-01	ASSY, DOOR HINGE
81	. 545789-01	ASSY, SIDE COVER DOOR
82	. 545779-01	ASSY, DOOR HINGE
83	. 545789-03	ASSY, SIDE COVER DOOR
84	. 545779-01	ASSY, DOOR HINGE

85	.	547186-01	ASSY, KR950 LOGO
86	.	547236-02	ASSY, AIR BLOW DOWN
87	.	547461-01	ASSY, STACK LIGHT
88	.	545754-01	ASSY, OUTFEED CONVEYOR
89	.	545636-02	ASSY, CONVEYOR DRIVE ROLLER
90	.	545786-02	ASSY, OUTFEED CONVEYOR COVER
91	.	547519-01	ASSY, OUTFEED BELT ADJUST

Sheet No. 1 KR950

Rev. No. DATE ISSUED ECO NO.

ITEM/QTY	PART #	DESCRIPTION
1	543990-01	ASSY, TURN TABLE AND MOUNT
2	545150-01	ASST. OUTFEED CONVEYOR
3	545300-01	ASST. INFEED CONVEYOR/FRAME



ITEM	REV.	ECO #	ISSUE DATE	DESCRIPTION	ECO NO.
A	KEY	0 . 033	DATE ISSUED 01/01/01	WELDING	N/A
CHASSIS PT.	REV.	001	000	000	000
MAKER PT.	REV.	000	000	000	000

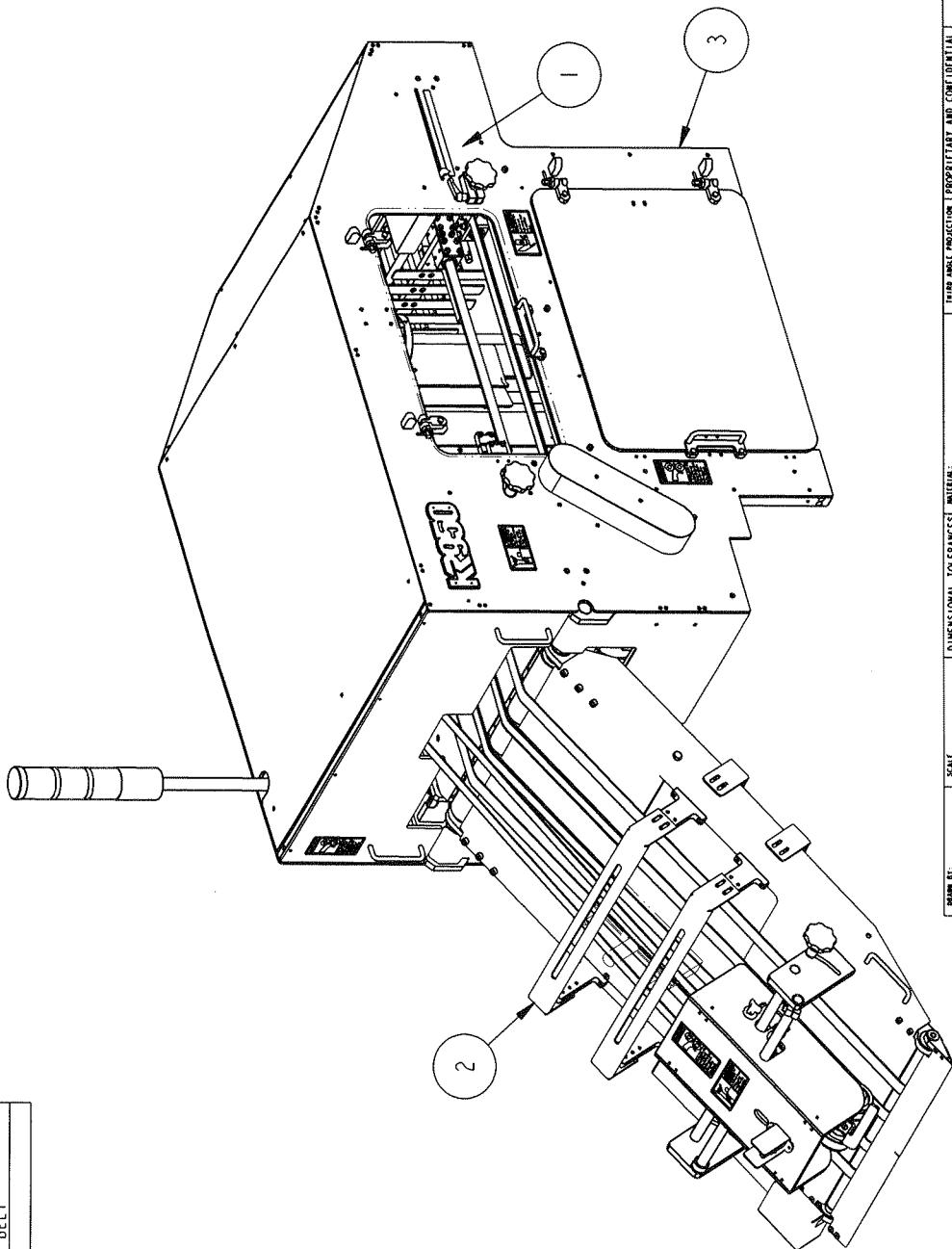
ITEM/QTY	PART #	DESCRIPTION	WELDING	DATE ISSUED	REV.	ECO #	ECO NO.
1	31 - Jan - 06	Turn Table Mount	Welded	31 - Jan - 06	000	000	000
2		Outfeed Conveyor	Welded				
3		Infeed Conveyor	Welded				

ITEM	REV.	ECO #	ISSUE DATE	DESCRIPTION	ECO NO.
A	KEY	0 . 033	DATE ISSUED 01/01/01	WELDING	N/A
CHASSIS PT.	REV.	001	000	000	000

ITEM/QTY	PART #	DESCRIPTION	WELDING	DATE ISSUED	REV.	ECO #	ECO NO.
1	31 - Jan - 06	Turn Table Mount	Welded	31 - Jan - 06	000	000	000
2		Outfeed Conveyor	Welded				
3		Infeed Conveyor	Welded				

545800-01

ITEM	QTY	PART #	DESCRIPTION	REV NO.	DATE	DESCRIPTION	ECN NO.	BT
1	1	543980-01	ASSY, PRODUCT CATCH FINGER					
2	1	545632-01	ASSY, STACKER FLAT BELT					
3	1	545748-01	ASSY, SIDE FRAME					



NAME BY:	A KEY	SCALE:	0.100	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	N/A	TRIM LINE PROJECTION	PROJECTION OF THIS DRAWING MAKES AN AUTOMATIC INDICATION OF EXPRESSED TOLERANCE WHEN USED IN DRAWINGS.
CHECKED BY:		DATE:	08 Sep - 03	INCHES	N/A	MODEL:	950
TRACED BY:				FEET		SCALE:	20F2
						UNIT:	ASSY, INFED CONVEYOR / FRAME
						REO'D WHERE USED	
						KIRK - RUDY, INC. WOODSTOCK, GEORGIA	
						5458000-01	

ITEM QTY	PART #	DESCRIPTION	KEY	DATE	DESCRIPTION	COS	SP
1	6	100217	BUSHING, SC. 250 ID .37500 6216				
2	6	108720	NUT, HEX 1/4-20				
3	6	107407	SCREW, SHCS 1/4-20X1.000				
4	2	190759	MAGNET, BUNTING				
5	2	190782	LABEL, LOOSE CLOTHES				
6	2	190784	LABEL, STAMPING WARNING				
7	4	190785	LABEL, ROLLER VERT WARNING				
8	2	190935	HANDLE				
9	1	201164	PLATE, YELLOW POWER OFF LABEL				
10	4	201169	PLATE, CUSTOM				
11	1	190119-1	PLATE, NAME				
12	1	201124-2	BUTTON, START				
13	1	201125-3	BUTTON, STOP				
14	1	201125-5	BUTTON, POWER OFF				
15	2	201126-1	BUTTON, JOG				
16	1	545749-01	FRAME, RH SIDE				
17	1	545749-02	FRAME, LH SIDE				
18	1	545764-01	COVER, OUTFIELD FRAME				
19	1	545765-01	COVER, INFIELD FRAME				
20	1	545765-02	COVER, INFIELD FRAME				
21	9	545766-01	BAR, FRAME SPACER				
22	1	545766-02	BAR, FRAME SPACER				
23	1	545767-01	COVER, FRAME END				
24	1	545768-01	COVER, OUTFIELD TOP LEYAN				
25	1	545769-01	COVER, TOP LEYAN				
26	1	545770-01	COVER, FRONT LEYAN				
27	2	545771-01	W/LANT, COVER TIMING BELT				
28	1	545774-01	BAR, INFIELD DOOR MOUNT				
29	4	545775-01	SPACER, COVER MOUNT				
30	4	545716-01	BAR, FRAME MOUNT				
31	3	545782-01	ASST., LEYAN DOOR				
32	1	545789-01	ASST., SIDE COVER DOOR				
33	1	545789-03	ASST., SIDE COVER DOOR				
34	2	545791-01	BAR, MAGNET MOUNT				
35	2	545792-01	BUCKET, DOOR STOP				
36	1	545798-01	BOX, BUTTON				
37	2	547186-01	ASSY, KB950 LOGO				
38	2	547217-01	BAR, TOP MOUNT				
39	2	547217-02	BAR, TOP MOUNT				
40	1	547227-01	BUCKET, SAFETY SWITCH MNT				
41	1	547236-02	ASSY, AIR BLOW DOWN				
42	2	547237-01	TRAY, TOOL				
43	1	547461-01	ASSY, STACK LIGHT				
44	2	CSEF55	SCREW, BUTTON HEAD 18-32X.750				
45	7		MAGNET SENSORS, MAGNET RECEIVER				

SEE DETAIL B

DETAIL B
SCALE 1:500

SEE DETAIL A—

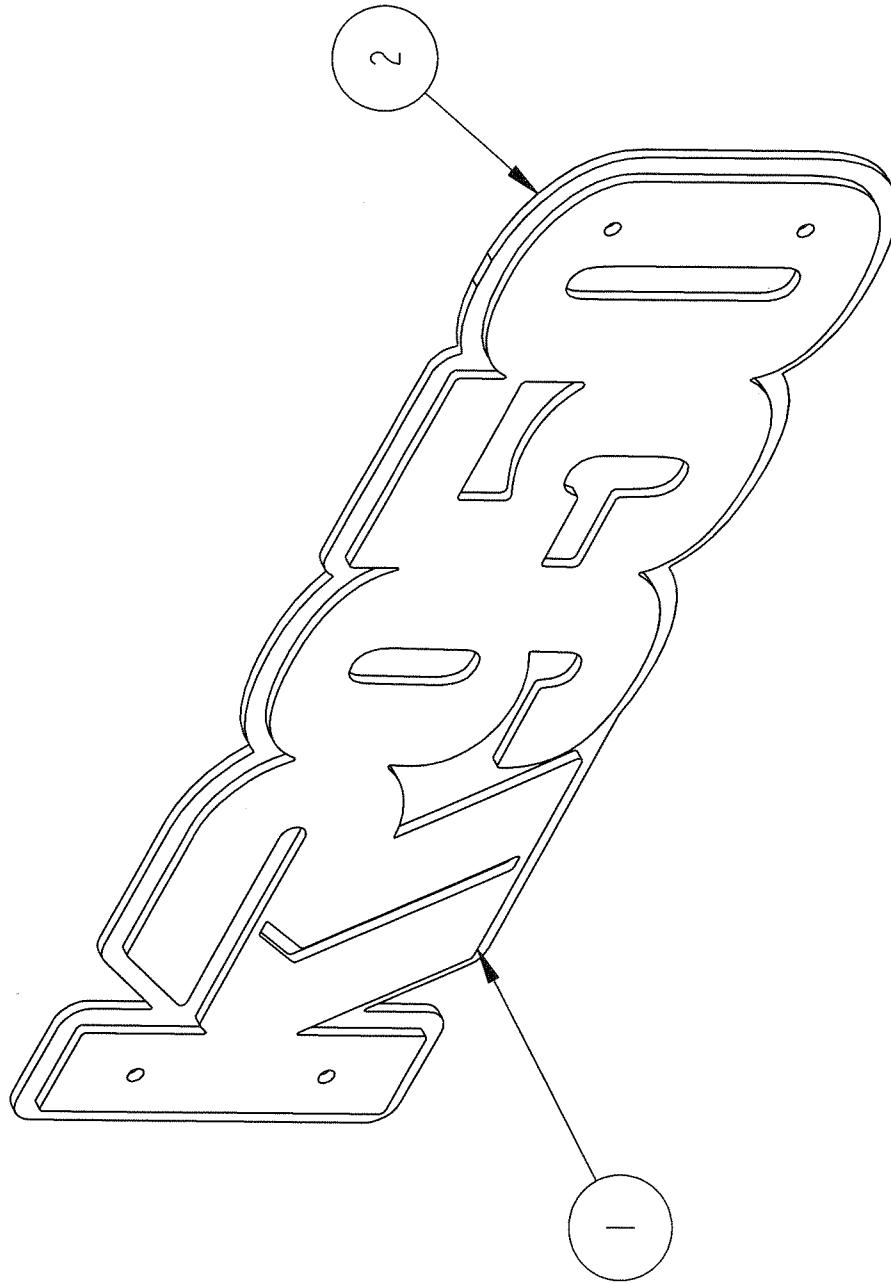
DETAIL A
SCALE 1:500

1	SEE
2	SEE
3	SEE
4	SEE
5	SEE

KIRK - RIDY, INC.
WOODSTOCK, GEORGIA
ASSY., SIDE FRAME

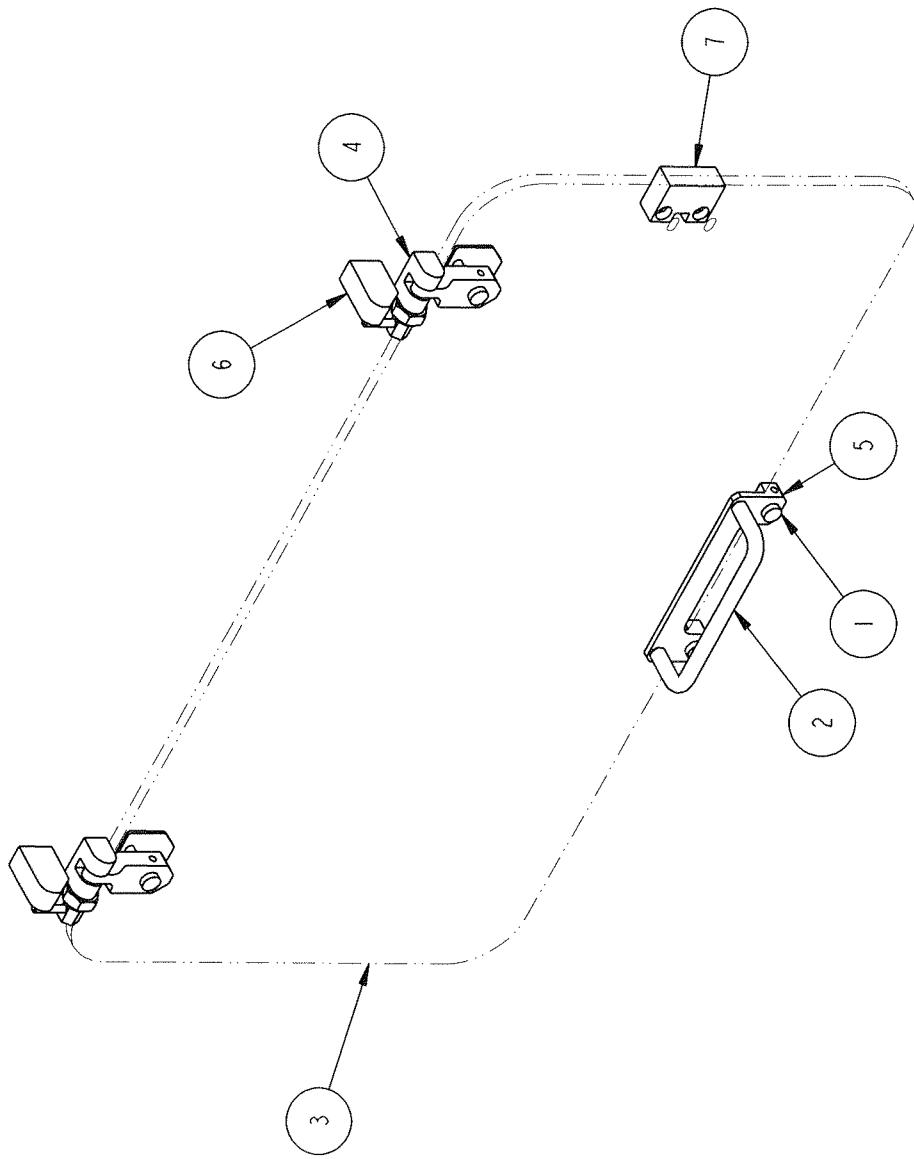
Drawing # 545748-01

ITEM	QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	1	547184-01	LOGO, KR950					
2	1	547185-01	PLATE, KR950 LOGO BACKING					



DRAWN BY: A KEY	SCALE 1 . 000	MATERIAL: N/A	THIRD ANGLE PROJECTION PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE OCULDED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC. KENNESAW, GA 30144 USA						
CHECKED BY: 	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED <table border="1"><tr><td>.xx</td><td>.xxx</td><td>ANG.</td></tr><tr><td>.01</td><td>.005</td><td>.5</td></tr></table>	.xx	.xxx	ANG.	.01	.005	.5	HEAT TREAT: N/A	MODEL: 950
.xx	.xxx	ANG.							
.01	.005	.5							
TRACED BY: MASTER	DATE 12-JUL-04	FINISH: N/A	SHEET NO. 1 OF 1						
REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED ALL DIMENSIONS ARE FINAL SHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY		TITLE: ASSY, KR950 LOGO DRAWING # 547186-01							

ITEM NO.	PART #	DESCRIPTION	REV NO.	DATE	DESCRIPTION	REV NO.	DATE
1	2	190169 MAGNET, BUNTING					
2	1	190955 HANDLE					
3	1	545777-01 COVER, UPPER SIDE LEXAN					
4	2	545779-01 ASSY. DOOR HINGE					
5	1	545783-01 PLATE, DOOR HANDLE MOUNT					
6	2	545790-01 BLOCK, DOOR KEEPER					
7	1	MAGNETSENSORSOL, MAGNET RECEIVER					

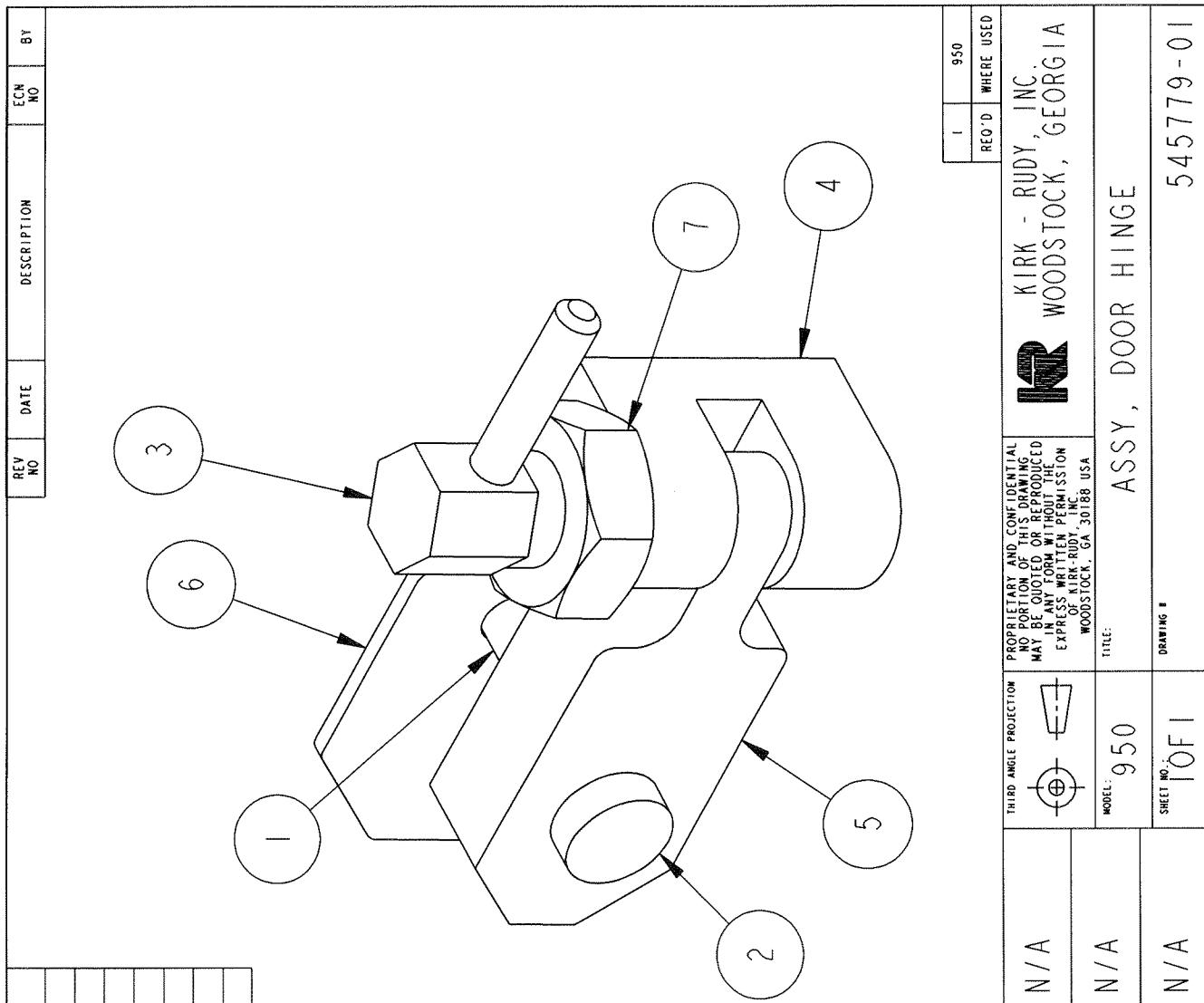


ITEM NO.		SCALE	0 . 438	DIMENSIONS OF PARTS		MATERIAL:		ITEM NO.		DIMENSIONS OF PARTS		MATERIAL:		ITEM NO.		DIMENSIONS OF PARTS		MATERIAL:	
CHECKED BY:				BASE	III	III	III	BASE	III	III	III	III	III	BASE	III	III	III	III	
TRACED BY:				12 - JU 1 - 04	12 - JU 1 - 04	12 - JU 1 - 04	12 - JU 1 - 04	12 - JU 1 - 04	12 - JU 1 - 04	12 - JU 1 - 04	12 - JU 1 - 04	12 - JU 1 - 04	12 - JU 1 - 04	12 - JU 1 - 04	12 - JU 1 - 04	12 - JU 1 - 04	12 - JU 1 - 04	12 - JU 1 - 04	
REMARKS:																			

PRINTED BY: KIRK - RUDY, INC
WOODSTOCK, GEORGIA

DRAWING #: ASSY, SIDE COVER DOOR
545789-03

ITEM	QTY	PART #	DESCRIPTION
1	3	106826	SCREW, BUTTON HEAD #10-32X.625
2	1	190769	MAGNET, BUNTING
3	1	190967	HAND PLUNGER, 3/8-16X1.13
4	1	545780-01	BLOCK, DOOR HINGE MOUNT
5	1	545781-01	BRACKET, DOOR HINGE MOUNT
6	1	547927-01	BRACKET, LEXAN MOUNT
7	1	HMSN14	NUT, HEX 3/8-16



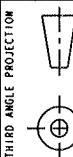
ITEM	QTY	REV NO	DATE	DESCRIPTION	ECN NO	BY

I	950
REF'D	WHERE USED

KIRK - RUDY, INC.
WOODSTOCK, GEORGIA



WOODSTOCK, GA 30188 USA



THIRD ANGLE PROJECTION

© KIRK-RUDY, INC.

WOODSTOCK, GA 30188 USA

PROPRIETARY AND CONFIDENTIAL

NO PORTION OF THIS DRAWING

MA Y BE QUOTED OR REPRODUCED

IN ANY FORM WITHOUT THE

EXPRESS WRITTEN PERMISSION

OF KIRK-RUDY, INC.

WOODSTOCK, GA 30188 USA

ALL DIMENSIONS ARE

FINISHED DIMENSIONS

DO NOT SCALE - WORK

TO DIMENSIONS ONLY

ASSY, DOOR HINGE

TITLE:

950

MASTER

SCALE

2.000

DATE

31- JAN - 06

REMOVED ALL BURRS AND

SHARP EDGES UNLESS

NOTED

ALL DIMENSIONS ARE

FINISHED DIMENSIONS

DO NOT SCALE - WORK

TO DIMENSIONS ONLY

0F1

SHEET NO:

DRAWING #:

545779-01

TRACED BY:

MASTER

SCALE

2.000

DATE

31- JAN - 06

REMOVED ALL BURRS AND

SHARP EDGES UNLESS

NOTED

ALL DIMENSIONS ARE

FINISHED DIMENSIONS

DO NOT SCALE - WORK

TO DIMENSIONS ONLY

0F1

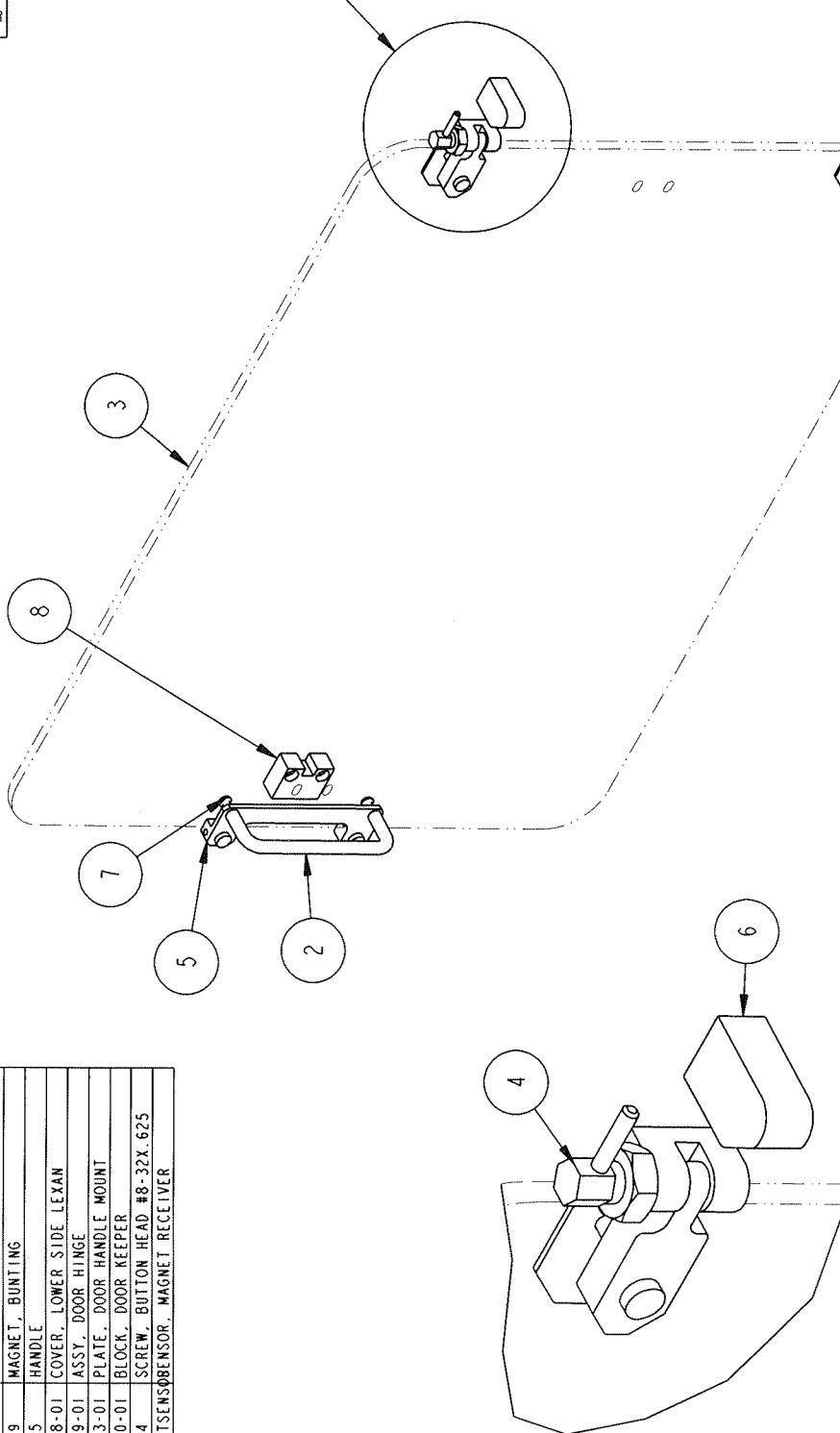
SHEET NO:

DRAWING #:

545779-01

ITEM #	PART #	DESCRIPTION	REV. NO.	DATE	DESCRIPTION	REV. NO.	DATE
1	2	190769 MAGNET BUNTING					
2	1	190955 HANDLE					
3	1	545718-01 COVER, LOWER SIDE LEXAN					
4	2	545719-01 ASSY. DOOR HINGE					
5	1	545733-01 PLATE, DOOR HANDLE MOUNT					
6	2	545780-01 BLOCK, DOOR KEEPER					
7	2	CSFF54 SCREW, BUTTON HEAD #8-32X.625					
8	1	MAGNET/SENSOR, MAGNET RECEIVER					

SEE DETAIL A

DETAIL A
SCALE .000

ITEM #:	A KEY	SCALE	0 .375	DIMENSIONS IN INCHES	INCHES									
CHECKED BY:	31 - Jan - 06	DATE		ALL DIMENSIONS	"	"	"	"	"	"	"	"	"	"
TRACED BY:	MASTER	MASTER		STATED UNLESS	N/A									
				OTHERWISE NOTED										

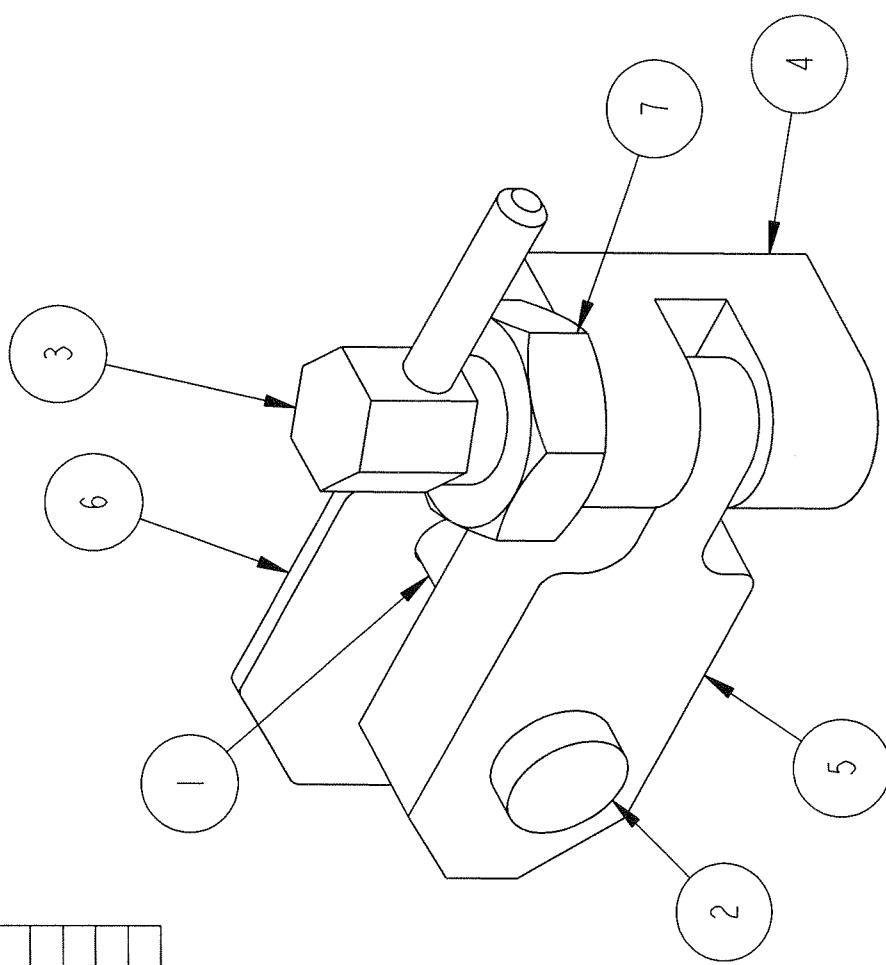
REVISIONS AND CHANGES:
000

PRINTED BY: KIRK - RUDY, INC.
WOODSTOCK, GEORGIA

PRINTED BY: ASSY, LEXAN DOOR

PRINTED BY: 545782-01

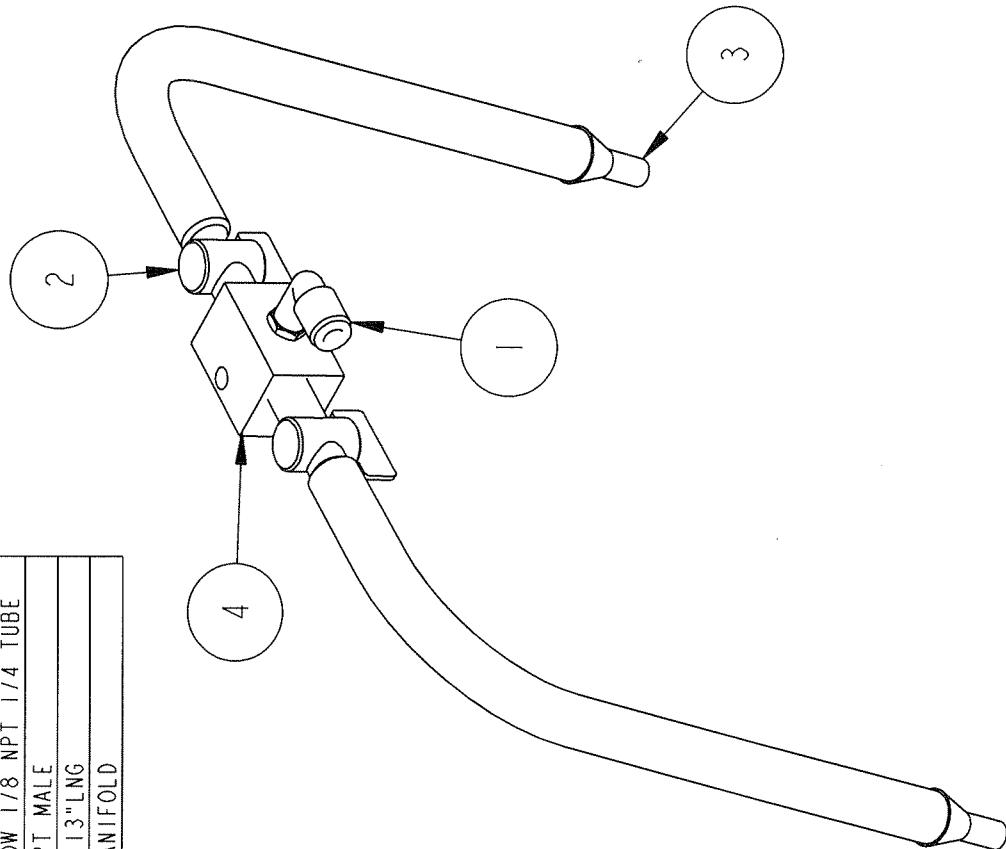
ITEM	QTY	PART #	DESCRIPTION
1	3	106826	SCREW, BUTTON HEAD #10-32X.625
2	1	190769	MAGNET, BUNTING
3	1	190967	HAND PLUNGER, 3/8-16X1.13
4	1	545780-01	BLOCK, DOOR HINGE MOUNT
5	1	545781-01	BRACKET, DOOR HINGE MOUNT
6	1	547927-01	BRACKET, LEXAN MOUNT
7	1	HMSN14	NUT, HEX 3/8-16



ITEM	QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	1	950						REF'D WHERE USED

DRAWN BY:	A KEY	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. WOODSTOCK, GA 30188 USA
CHECKED BY:		DATE	.01	.005	.5	HEAT TREAT:			KR	KIRK - RUDY, INC. WOODSTOCK, GEORGIA
TRACED BY:		31 - Jan - 06	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED			FINISH:	N / A	MODEL: 950	TITLE:	ASSY, DOOR HINGE
	MASTER		ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY				N / A	SHEET NO: 1 OF 1	DRAWING #	545779-01

ITEM	QTY	PART #	DESCRIPTION
1	1	191337	FITTING, ELBOW 1/8 NPT 1/4 TUBE
2	2	191349	VALVE, 1/4 NPT MALE
3	2	191350	HOSE, 1/4 ID 13" LG
4	1	543970-03	BLOCK, AIR MANIFOLD

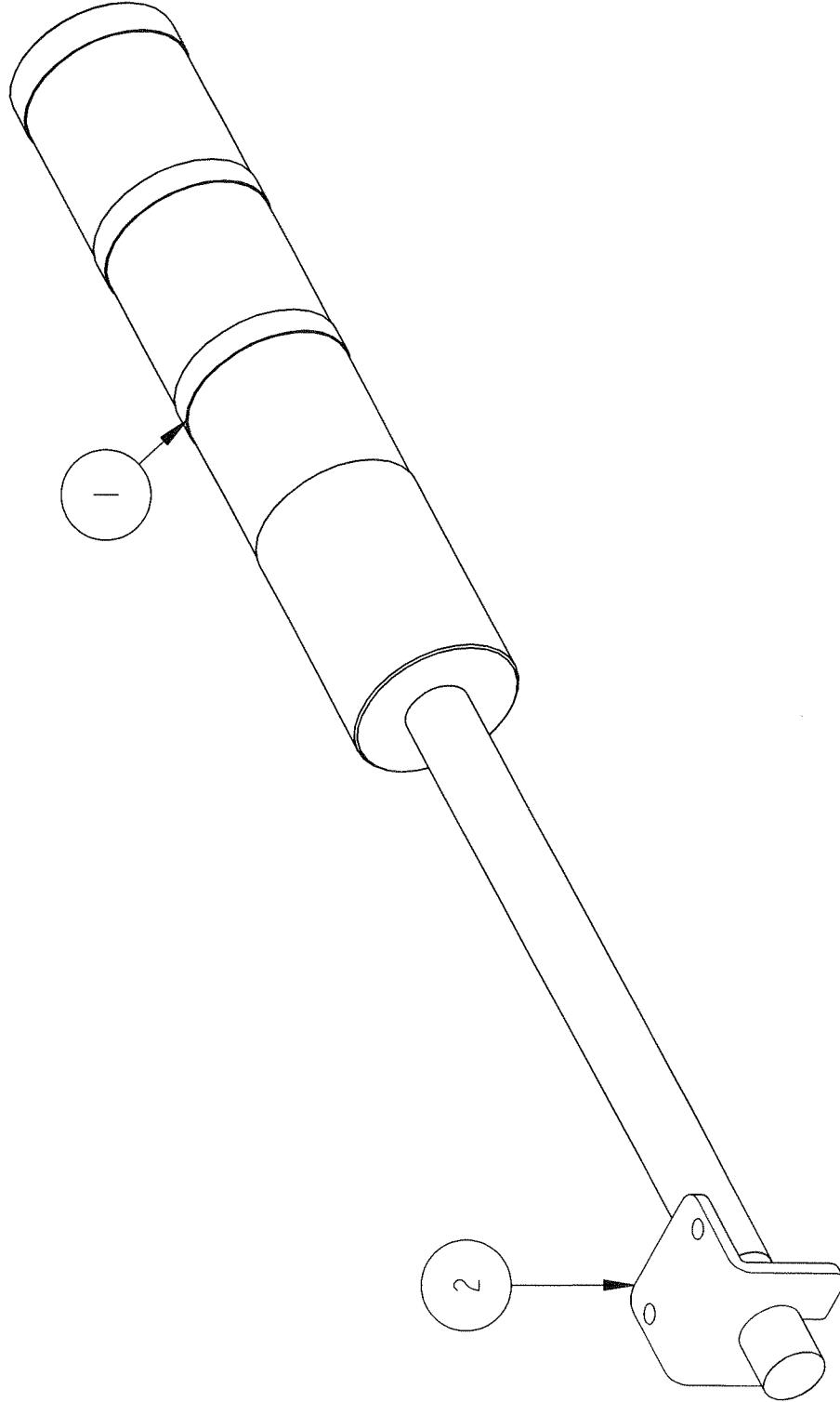


REV NO	DATE	DESCRIPTION	ECN NO	BY

I	950	REO'D WHERE USED
---	-----	------------------

DRAWN BY: A KEY	SCALE 0 . 500	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED		MATERIAL: N/A	THIRD ANGLE PROJECTION	KIRK - RUDY, INC. WOODSTOCK, GEORGIA
CHECKED BY:	DATE 01 - MAR - 05	.xx	.xxx	ANG. .01 .005 .5	HEAT TREAT: N/A	MODEL: 950
TRACED BY:	MASTER	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED		FINISH: N/A	SHEET NO.: OF 1	TITLE: ASSY, AIR BLOW DOWN
		ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY				DRAWING #: 547236-02

ITEM	QTY	PART #	DESCRIPTION
1	1	202284-8	LIGHT, THREE BULB
2	1	547462-01	BRACKET, STACK LIGHT MNT

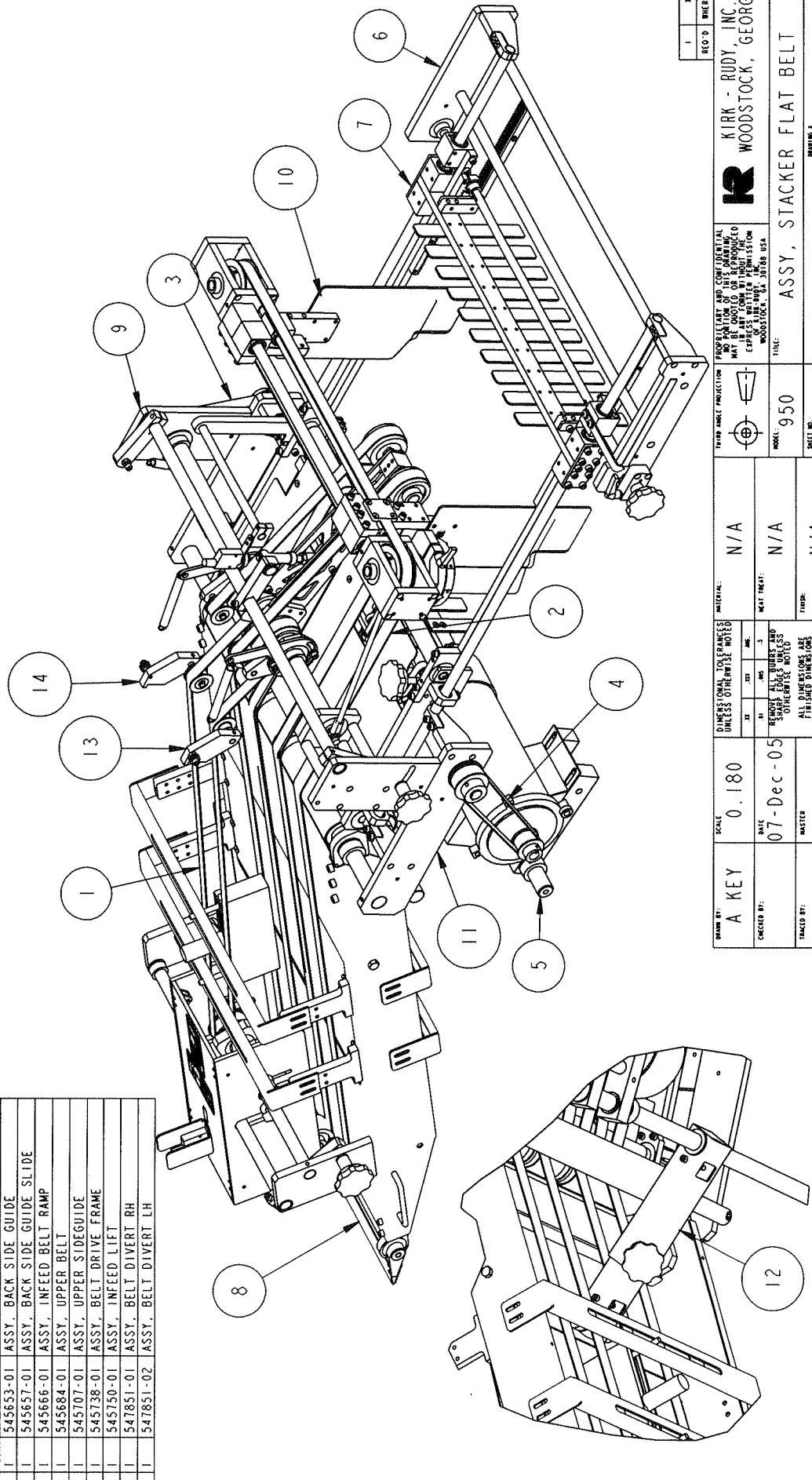


ITEM	QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	1	202284-8	LIGHT, THREE BULB					

I	XXX
REF'D	WHERE USED
KIRK - RUDY, INC.	
KR WOODSTOCK, GEORGIA	
PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE QUOTED OR REPRODUCED IN ANY FORM OR WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC. WOODSTOCK, GA 30188 USA	
SCALE:	.500
DRAWN BY:	A KEY
DATE:	31-JAN-06
CHECKED BY:	
TRACED BY:	MASTER
DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	N/A
.01 .005 .5	ANG. HEAT TREAT:
REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED	
ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY	
MODEL: 950	950
FINISH:	N/A
ASSY, STACK LIGHT	ASSY, STACK LIGHT
SHEET NO. 1 OF 1	DRAWING # 547461-01

Drawing # 545632-01

ITEM QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	REV NO	DATE
1	2	BELT, FLAT 138.25 X .75					
2	4	BELT, FLAT 133.25 X 1.000					
3	1	BELT, TIMING 187L075					
4	1	BELT, TIMING 225L075					
5	1	ASSY, MOTOR MOUNT					
6	1	ASSY, BACK SIDE GUIDE					
7	1	ASSY, BACK SIDE GUIDE SLIDE					
8	1	ASSY, INFEED BELT RAMP					
9	1	ASSY, UPPER BELT					
10	1	ASSY, UPPER SIDEGUIDE					
11	1	ASSY, BELT DRIVE FRAME					
12	1	ASSY, INFEED LIFT					
13	1	ASSY, BELT DIVERT RH					
14	1	ASSY, BELT DIVERT LH					



1	XXX
REV 0	WHERE ISSUED
KIRK - RUDY, INC.	
WOODSTOCK, GEORGIA	
PRINTED AND CONFIDENTIAL	
PROPRIETARY INFORMATION	
DO NOT COPY OR REPRODUCE	
IN WHOLE OR IN PART	
EXCEPT AS AUTHORIZED	
BY KIRK - RUDY, INC.	
WOODSTOCK, GA 30188 USA	
TRIM: ASSY, STACKER FLAT BELT	
Model: 950	
Sheet No: 0F4	

ITEM #	SCALE	SCALE	ITEM #				
A KEY	0 . 180	0 . 180	REMOVED	REMOVED	REMOVED	REMOVED	REMOVED

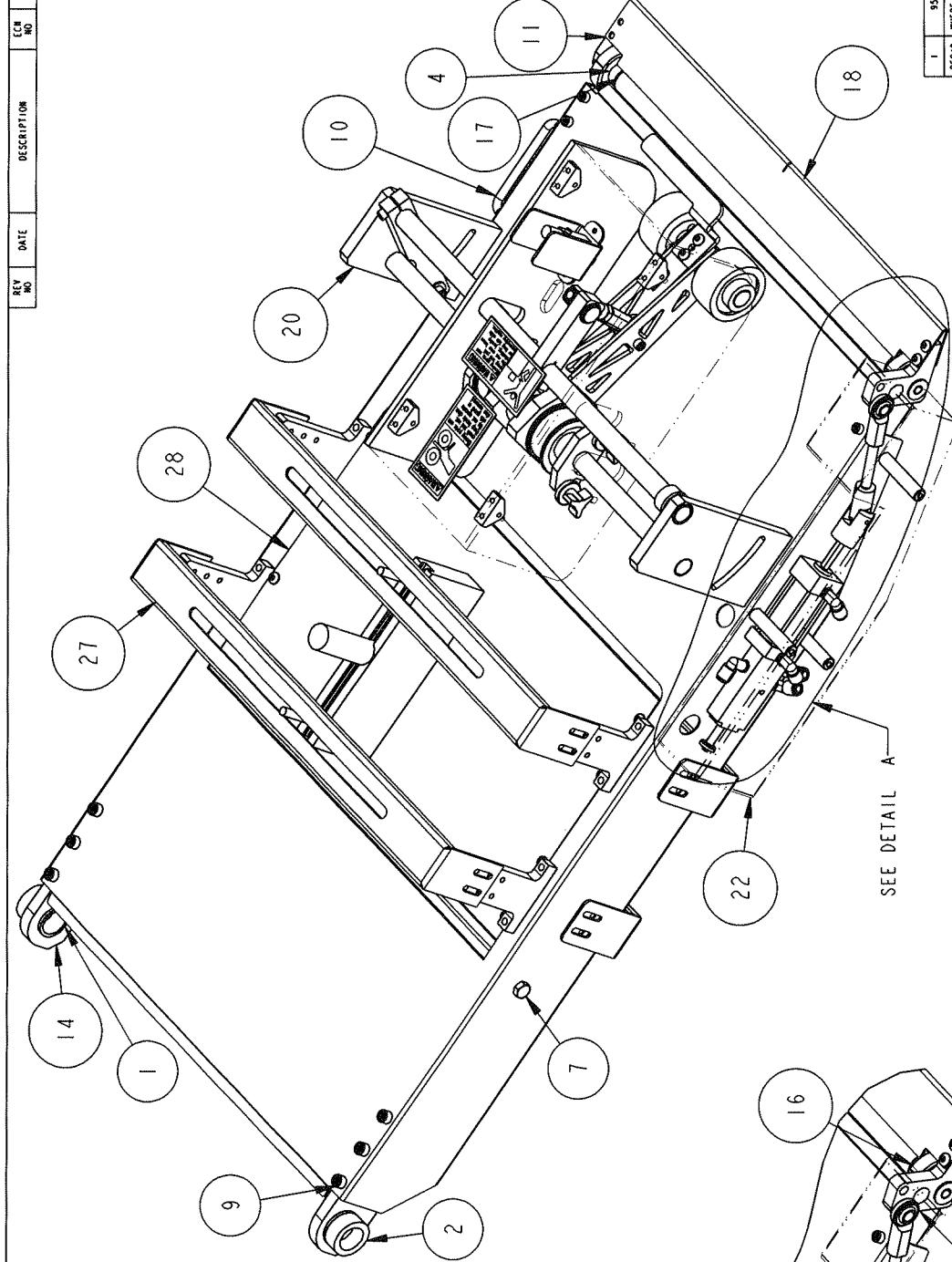
ITEM #	SCALE	SCALE	ITEM #				
CHECKED BY:	DATE	DATE	ITEM #				
07 - Dec - 05	07 - Dec - 05	07 - Dec - 05	N/A	N/A	N/A	N/A	N/A
MAILED BY:	MASTER	MASTER	ITEM #				

SCALE 0 . 188

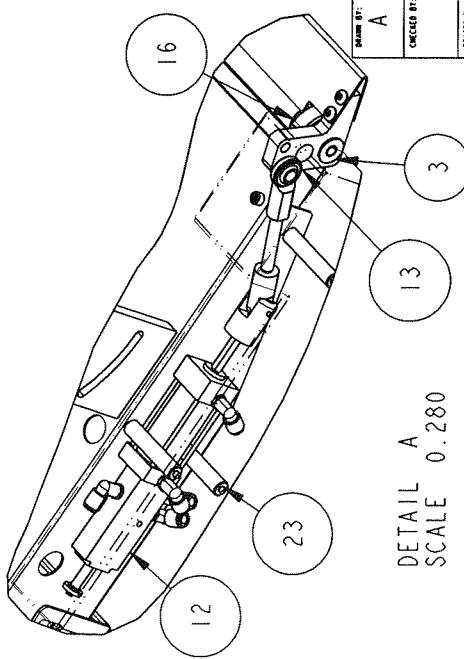
ITEM NO.	PART #	DESCRIPTION	REV. NO.	DATE	ECN NO.	BY
1	2	BUSHING, FL. 00000000000000000000				
2	2	COLLAR, I. 0000				
3	4	BEARING, FLAT .375				
4	2	BEARING, HUB 625				
5	8	SCREW, BUTTON HEAD 1/4X .500				
6	1	BOLT, HEX HEAD 3/8-16X1.25				
7	1	BOLT, HEX HEAD 3/8-16X2.00				
8	4	SCREW, SHCS 1/4-20X .500				
9	6	SCREW, SHCS 5/16-18X .500				
10	6	HANDLE				
11	1	ARM, REJECT CYLINDER				
12	1	ASSY, VALVE CYLINDER PLATE				
13	1	ARM, REJECT CYLINDER				
14	2	PLATE, INFED RAMP BEARING				
15	1	545669.02 TABLETOP, INFED RAMP				
16	2	545670.01 PLATE, HUB BEARING				
17	1	545671.01 SHAFT, INFED ROLLER				
18	1	GUIDE, INFED DIVERT				
19	1	545673.01 ASSY, BELT TAKE UP				
20	1	545704.01 ASSY, UPPER BELT				
21	1	545746.02 SPACER, FRAME				
22	1	545794.01 WDMNT, AIR CYLINDER COVER				
23	3	SPACER, BEARING PLATE				
24	1	547211.01 SPACER, CONVEYOR SUPPORT				
25	1	547223.01 BRACKET, INFED RAMP SUPP				
26	1	547223.02 BRACKET, INFED RAMP SUPP				
27	1	KIT, STATIC BAR				
28	1	TABLETOP, STATIC BAR FILLER				
29	4	547535.01 BRACKET, TABLETOP MOUNT				
30	2	SCREW, BUTTON HEAD 1/4X .250				

DRAWING #:		DIMENSIONAL TOLERANCES		MATERIAL:	
ITEM NO.	Part #	IN	MM	IN	MM
A	KEY	0 .250		N/A	
CHECKED BY:		IN	MM	IN	MM
MAILED BY:		IN	MM	IN	MM
TRACED BY:		IN	MM	IN	MM

DETAIL A
SCALE 0.280



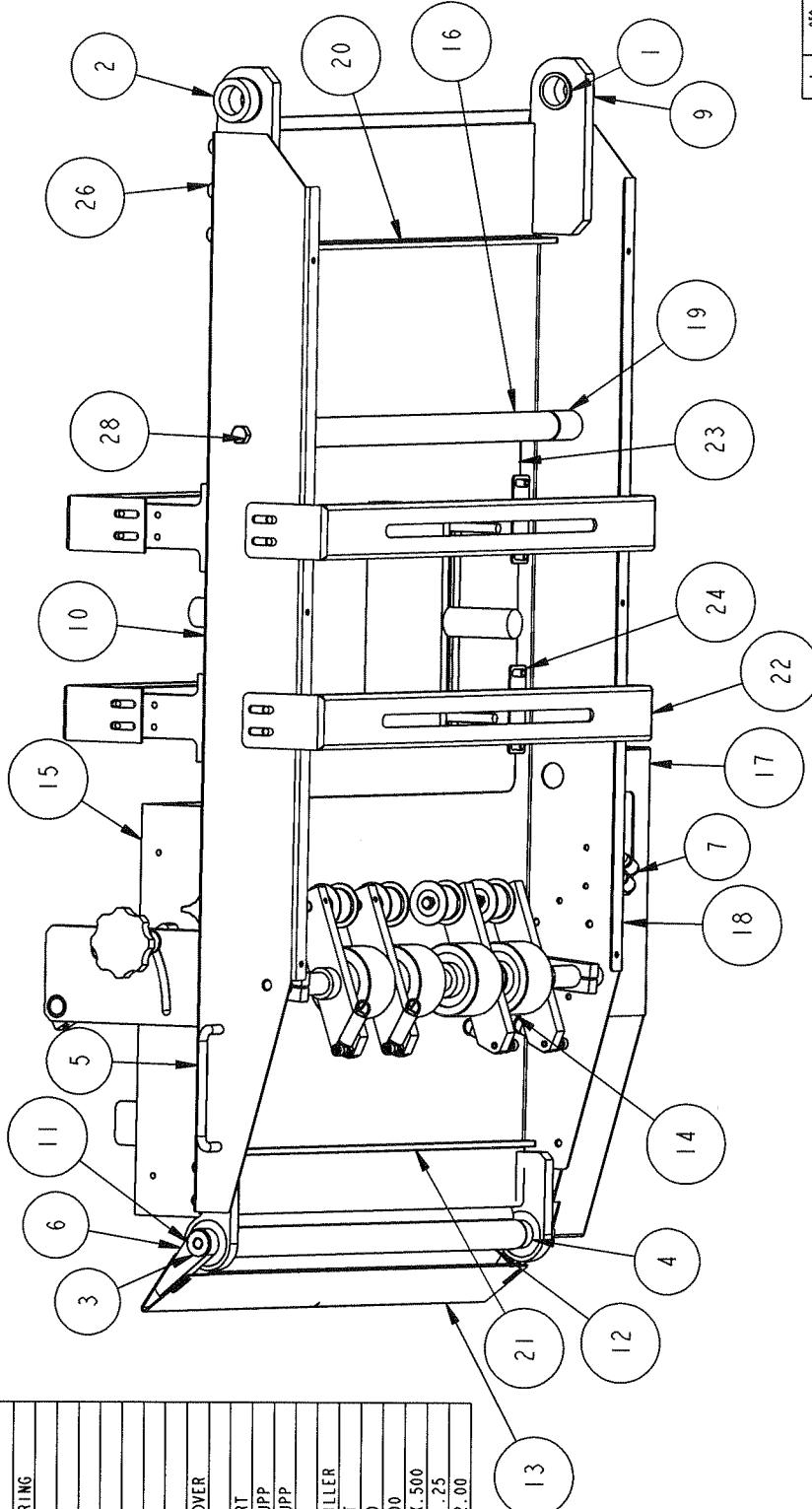
1	950	RECD WHERE USED
KRK KIRK - RUDY, INC		
WOODSTOCK, GEORGIA		
ITEM:		
MODEL:	950	ASSY, INFED BELT RAMP
SETUP:	OF 2	SEE DETAIL A



DRAWING #:

545666-01

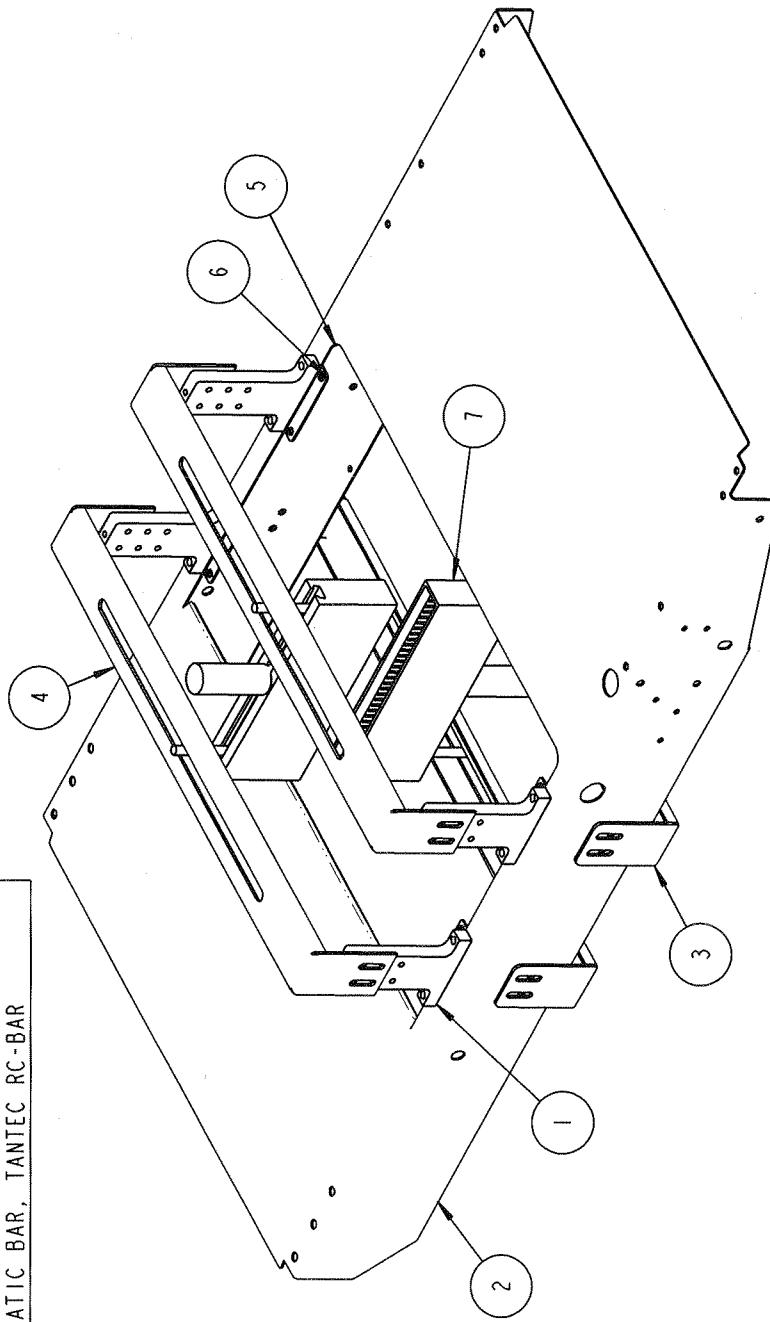
ITEM QTY	PART #	DESCRIPTION	REV NO	DATE	ECN NO	BY
1	2	100326 BUSHING, FLI .000101-.250000, .750L G				
2	2	102217 COLLAR 1.000				
3	4	103106 BEARING, FLAT .315				
4	2	103804 BEARING, HUB .625				
5	1	190955 HANDLE				
6	1	532226-02 ARM, REJECT CYLINDER				
7	1	534814-01 ASSY, VALVE CYLINDER PLATE				
8	1	541779-02 ARM, REJECT CYLINDER				
9	2	545668-01 PLATE, INFEED RAMP BEARING				
10	1	545669-01 TABLETOP, INFEED RAMP				
11	2	545670-01 PLATE, HUB BEARING				
12	1	545671-01 SHAFT, INFEED ROLLER				
13	1	545672-01 GUIDE, INFEED DIVERT				
14	1	545673-01 ASSY, BELT TAKE UP				
15	1	545701-01 ASSY, UPPER BELT				
16	1	545746-02 SPACER, FRAME				
17	1	545794-01 WDNTNT, AIR CYLINDER COVER				
18	3	545797-01 SPACER, BEARING PLATE				
19	1	547211-01 SPACER, CONVEYOR SUPPORT				
20	1	547223-01 BRACKET, INFEED AMP SUPP				
21	1	547223-02 BRACKET, INFEED RAMP SUPP				
22	1	547533-01 ASSY, STATIC BAR				
23	1	547535-01 TABLETOP, STATIC BAR FILLER				
24	4	547536-01 BRACKET, TABLETOP MOUNT				
25	4	CSD222 SCREW, SHCS 1/4-20X.500				
26	6	CSD2318 SCREW, SHCS 5/16-18X.500				
27	8	CSF65 SCREW, BUTTON HEAD 1/4X.500				
28	1	RHB081 BOLT, HEX HEAD 3/8-16X.25				
29	1	RHB084 BOLT, HEX HEAD 3/8-16X2.00				



1	950	RECD WHERE USED
KIRK - RUDY, INC.		
WOODSTOCK, GEORGIA		
TELE: ASSY, INFEED BELT RAMP		
DRAWING #: 545666-01		
20F2		

DRAWING #: A KEY		SCALE:	0 .250	DIMENSIONAL TOLERANCES		MATERIAL:	N/A	THREE ANGLE PROJECTION
CHECKED BY:	DATE:	.IN	.IN	.IN	.IN	WEAR TREAT:	N/A	PROPRIETARY AND CONFIDENTIAL
MASTER	01-Mar-05	REMOVED ALL SURFACES UNLESS OTHERWISE SPECIFIED	SHOT BLOWN SURFACES ARE	ALL SURFACES UNLESS	SHOT BLOWN SURFACES ARE	EXCEPT WHERE NOTED	N/A	NO DRAWING NUMBER
RECD:		TO BE USED FOR MANUFACTURE	TO BE USED FOR MANUFACTURE	TO BE USED FOR MANUFACTURE	TO BE USED FOR MANUFACTURE	TO BE USED FOR MANUFACTURE		PRINTED ON 01/05/05

ITEM	QTY	PART #	DESCRIPTION
1	4	508049-9	BAR, UPPER STATIC SUPPORT
2	1	545669-02	TABLETOP, INFEED RAMP
3	2	547534-01	BRACKET, STATIC BAR
4	2	547534-02	BRACKET, STATIC BAR
5	1	547535-01	TABLETOP, STATIC BAR FILLER
6	4	547536-01	BRACKET, TABLETOP MOUNT
7	2	STATIC-BAR	STATIC BAR, TANTEC RC-BAR

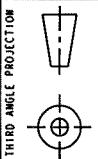


REV NO	DATE	DESCRIPTION	ECN NO	BY

I	950
REF'D	WHERE USED

KRK 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

MODEL: 950

TITLE: KIT, STATIC BAR

SHEET NO. 10F1

DRAWING # 547533-01

SCALE 0 . 180

MATERIAL: N/A

HEAT TREAT: N/A

FINISH: N/A

UNLESS OTHERWISE NOTED

.00 .005 .005 .005

REMOVE ALL BURRS AND
SHARP EDGES UNLESS
OTHERWISE NOTED

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

DATE 07-JUL-05

MAKER

DRAWN BY:

checked by:

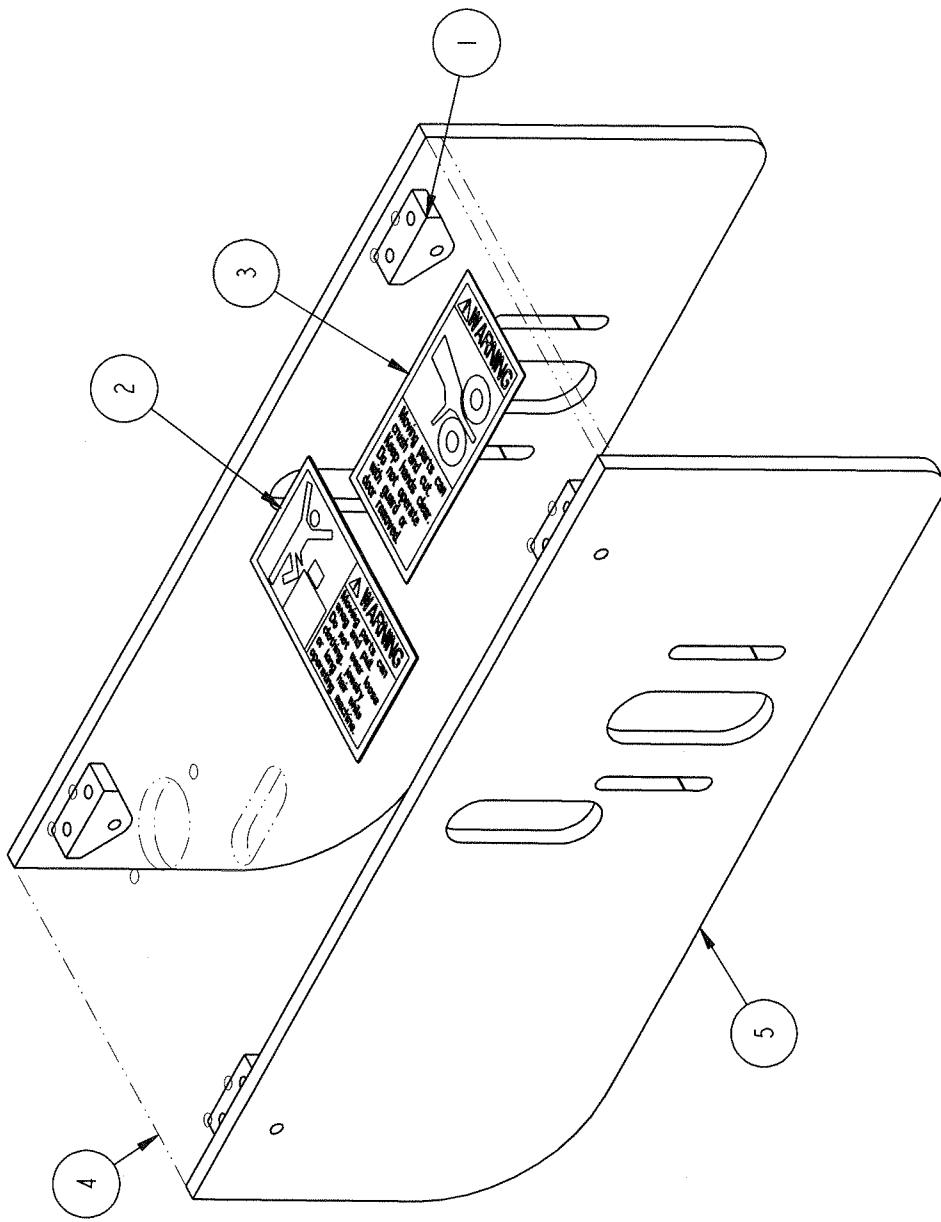
traced by:

ITEM NO.	PART #	DESCRIPTION	REV. NO.	DATE	DESCRIPTION	REV. NO.
1	1	100129			BUSHING, SL. 3751D 5000D 500LG	
2	1	100149			BUSHING, SL. 7501D 8750D 500LG	
3	1	100170			BUSHING, SL. 7501D 8750D 625LG	
4	1	100357			BUSHING, FL. 7501D 8750D 625G	
5	3	100602			WASHER, FLAT SJ161D	
6	1	102112			KNOB	
7	4	102119			KNOB	
8	1	102207			COLLAR .750	
9	2	102211			COLLAR .375	
10	1	102362			SPRING, COMPRESSION	
11	2	103112			BEARING, FLAT .750	
12	1	103300			BEARING - ROD END	
13	2	103805			BEARING, HUB .750	
14	1	104100			SNAPRING, .375	
15	2	104103			SNAPRING, .750	
16	4	107407			SCREW, SHCS 1/4-20X1.000	
17	1	107448			SCREW, SHCS 5/16-18X2.25	
18	1	20226-5			BEAMSWITCH, RETROREFLECTIVE	
19	1	543401-03			GUARD, BEAM SWITCH	
20	2	545685-03			ROLLER, DIVERT	
21	2	545685-02			PLATE, UPPER BELT SUPPORT	
22	1	545689-02			SHAFT, UPPER ARM ADJUST	
23	1	545690-01			ARM, UPPER BELT ADJUST	
24	1	545691-01			SHAFT, ARM PIVOT	
25	1	545692-02			SHAFT, VERTICAL ARM	
26	1	545693-02			ARM, UPPER BELT ADJUST	
27	1	545698-01			SHAFT, ARM LOCK	
28	1	545705-01			SHAFT, UPPER BELT DRIVE	
29	1	547204-01			ASSY, OUTFEED CONVEYOR COVER	
30	2	547207-01			BRACKET, INFD BELT COVER MNT	
31	1	547766-02			ASSY, UPPER BELT	
32	1	HWSN14			NUT, HEX 3/8-16	
33	4	SP6383-1			SPACER, GEAR COVER	

1	550	REV. D WHERE USED
K	KIRK - RUDY, INC.	WOODSTOCK, GEORGIA
950	950	DATE:
545704-01	545704-01	TIME:

DRAWING BY:	SCALE:	UNLESS OTHERWISE NOTED:	THIN SOLID PROJECTION	PROJECTION AND CENTER LINE
A KEY	0 .500	N/A	1	NOT TO SCALE
CHECKED BY:	05-0ct-05	2	1	NOT TO SCALE
TRACED BY:	MASTER	3	1	NOT TO SCALE
		4	1	NOT TO SCALE
		5	1	NOT TO SCALE
		6	1	NOT TO SCALE
		7	1	NOT TO SCALE
		8	1	NOT TO SCALE
		9	1	NOT TO SCALE
		10	1	NOT TO SCALE
		11	1	NOT TO SCALE
		12	1	NOT TO SCALE
		13	1	NOT TO SCALE
		14	1	NOT TO SCALE
		15	1	NOT TO SCALE
		16	1	NOT TO SCALE
		17	1	NOT TO SCALE
		18	1	NOT TO SCALE
		19	1	NOT TO SCALE
		20	1	NOT TO SCALE
		21	1	NOT TO SCALE
		22	1	NOT TO SCALE
		23	1	NOT TO SCALE
		24	1	NOT TO SCALE
		25	1	NOT TO SCALE
		26	1	NOT TO SCALE
		27	1	NOT TO SCALE
		28	1	NOT TO SCALE
		29	1	NOT TO SCALE
		30	1	NOT TO SCALE
		31	1	NOT TO SCALE

ITEM QTY	PART #	DESCRIPTION
1	4	190158 MOUNTING BLOCK
2	1	190182 LABEL, LOOSE CLOTHES
3	1	190185 LABEL, ROLLER VENT WARNING
4	1	547205-01 TOP, INFEED BELT COVER
5	2	547206-01 FRAME, OUTFEED CONVEYOR COVER

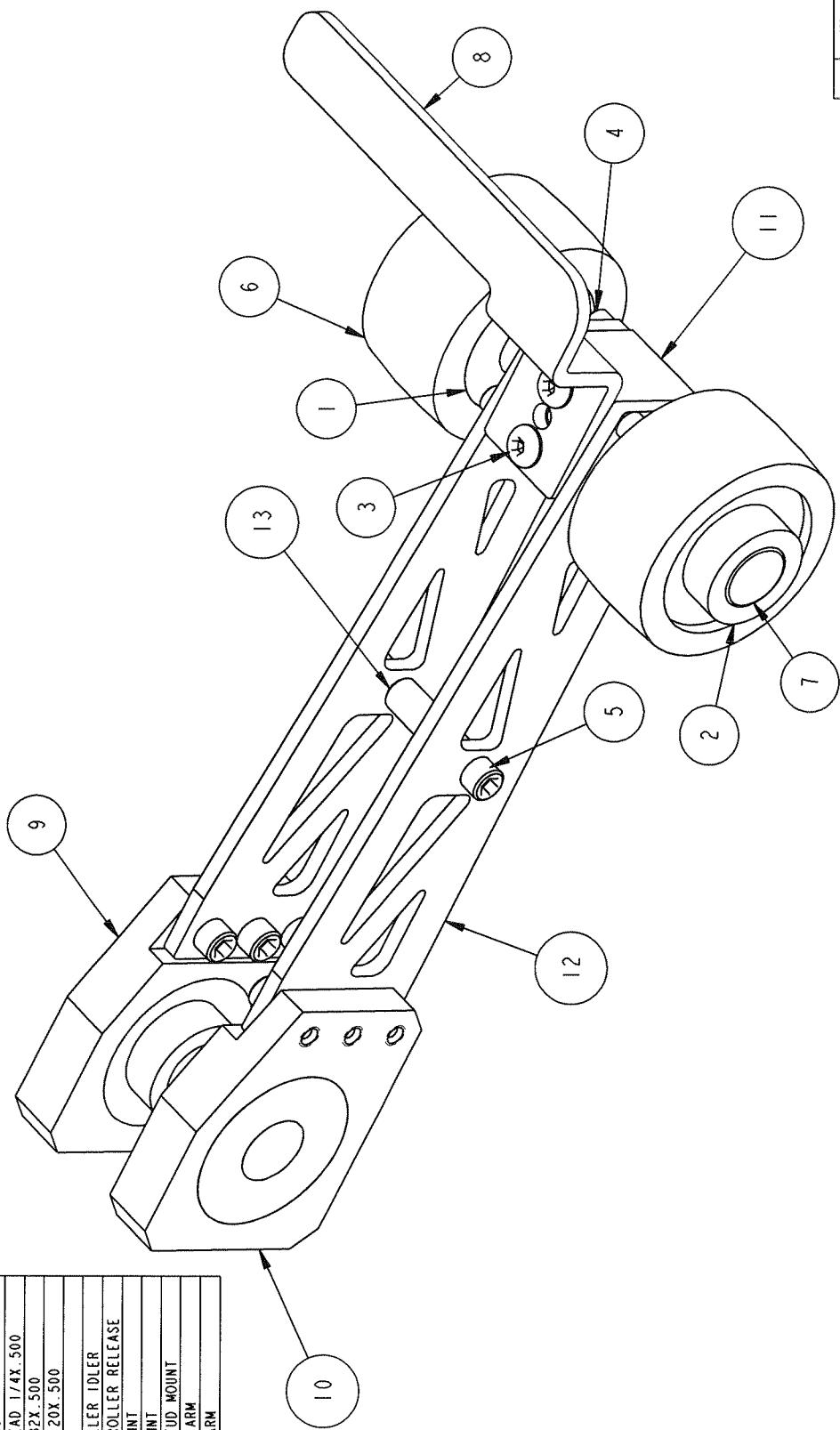


REV NO	DATE	DESCRIPTION	ECN NO	BT

I	\$50
REV 0	WHERE USED
KIRK - RUDY, INC.	
WOODSTOCK, GEORGIA	
THIS DRAWING PROTECTION PROPRIETARY AND CONFIDENTIAL	
REPRODUCTION OR DISSEMINATION	
IS PROHIBITED UNLESS AUTHORIZED IN WRITING BY THE	
ENGINEER IN CHARGE, KIRK - RUDY, INC.,	
WOODSTOCK, GA 30188 USA	
THIS: 950	
MATERIAL: N/A	
DIMENSIONAL TOLERANCES: N/A	
SCALE:	0.625
KEY:	A
DATE:	01-Mar-05
CHECKED BY:	
MAILED BY:	MASTER
ALL QUOTES, COSS, SPECS, & DESIGN ARE SUBJECT TO CHANGE WITHOUT NOTICE. PRINTED ON 100% RECYCLED PAPER. DO NOT SCALE - PRINT DIMENSIONS ONLY	
547204-01	

DRAWING NO. 547766-02

ITEM QTY	PART #	DESCRIPTION
1	2	103112 BEARING, FLAT .750
2	4	103815 BEARING, HUB .150
3	2	106818 SCREW, BUTTON HEAD 1/4X .500
4	8	107409 SCREW, SHCS 10-32X .500
5	8	107410 SCREW, SHCS 1/4-20X .500
6	2	545615-01 ROLLER, DIVERT
7	1	545614-01 SHAFT, UPPER ROLLER IDLER
8	1	547539-01 HANDLE, INFEED ROLLER RELEASE
9	1	547762-02 PLATE, BEARING MNT
10	1	547762-03 PLATE, BEARING MNT
11	1	547763-01 BLOCK, ROLLER STUD MOUNT
12	2	547764-02 BRACKET, ROLLER ARM
13	1	547765-01 SPACER, ROLLER ARM

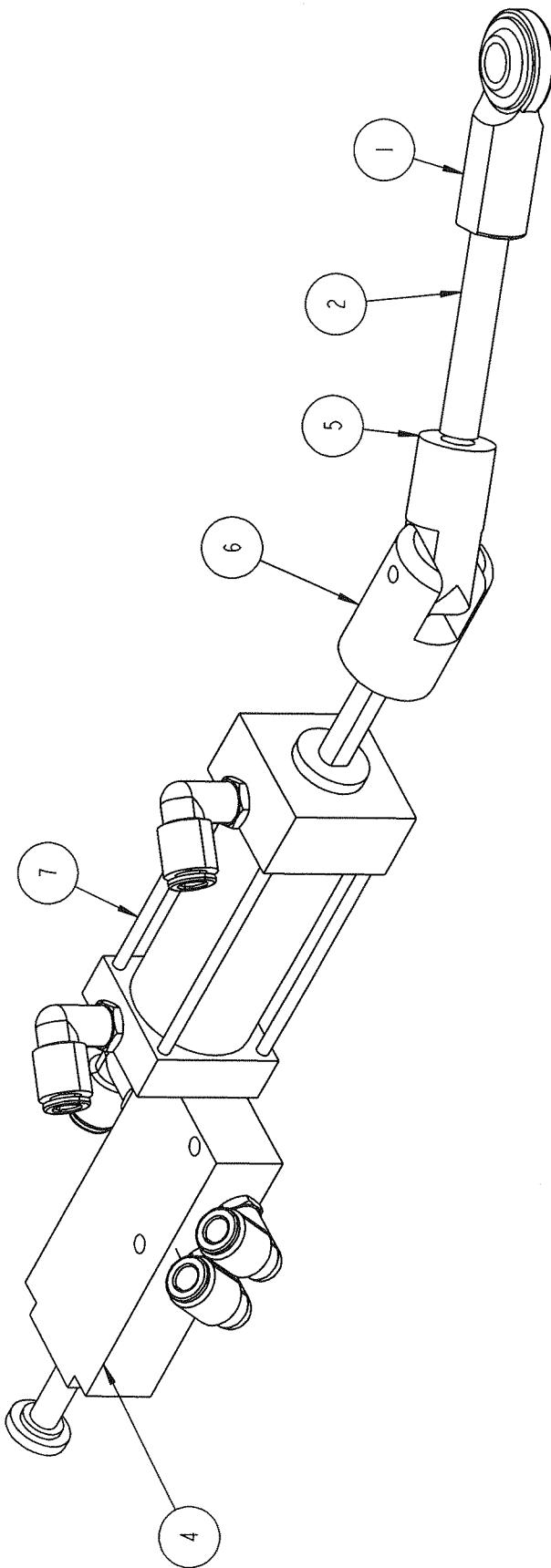


ITEM	REV NO.	DATE	SCW NO.	BY
1				
RECD WHERE USED				5/20
KIRK - RUDY, INC				
WOODSTOCK, GEORGIA				
ASSY, UPPER BELT				DRAWING NO. 547766-02
10F3				

NOTES:	SCALE	SCALE	NOTES ON THIS DRAWING
A KEY	0 .938	0 .938	NOTES ON THIS DRAWING
CHECKED BY:	MALE	MALE	NO FILED COPIES OF THIS DRAWING ARE TO BE MADE OR REPRODUCED
TRACED BY:	MALE	MALE	EXCEPT AS SPECIFIED IN THE DRAWING, PRACTICE IS AS FOLLOWS:
			ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
			ALL DIAMETERS ARE INCHES UNLESS OTHERWISE NOTED
			DO NOT SCALE; WORK TO DIMENSIONS ONLY

ITEM	REV NO.	DATE	SCW NO.	BY
1				

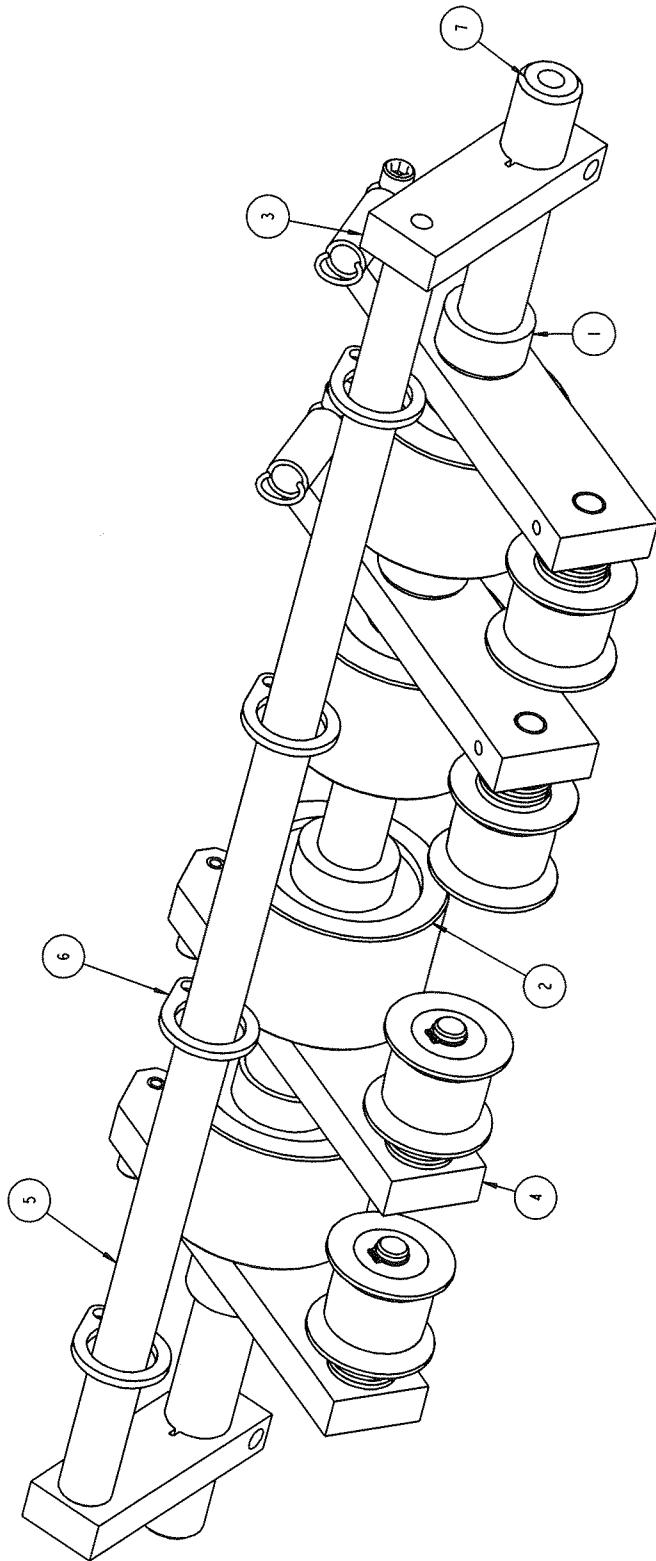
ITEM QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	1	103500			BEARING - ROD END		
2	1	105633			SHAFT, THREADED 3/8-24 X 2.375		
3	5	191337			FITTING, ELBOW 1/8 NPT 1/4 TUBE		
4	1	202708			VALVE, THREE WAY AIR		
5	1	508055			LINK, GATE		
6	1	508175			CLEVIS, AIR CYLINDER		
7	1	190803-1			CYLINDER, AVB1 X 1B W/SHOCK PADS		



NOTE:
 1) AVAILABLE IN COILS OF 24 VDC AND 110 VAC
 24 VDC 202708-1 (512 DIVERT, 215 DIVERT OPTIONAL)
 110 VAC 202708-2 (SP630-703 RAMP, 215 DIVERT OPT.)

DRAWN BY: A KEY		SCALE 0 . 625	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 09 - JUL - 04	.01 .005 .005 ANG.	HEAT TREAT: N / A	MODEL: 950		TITLE: ASSY, VALVE CYLINDER PLATE
TRACED BY:	MASTER	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY		SHEET NO.: 10F		DRAWING # 5348 4 - 07

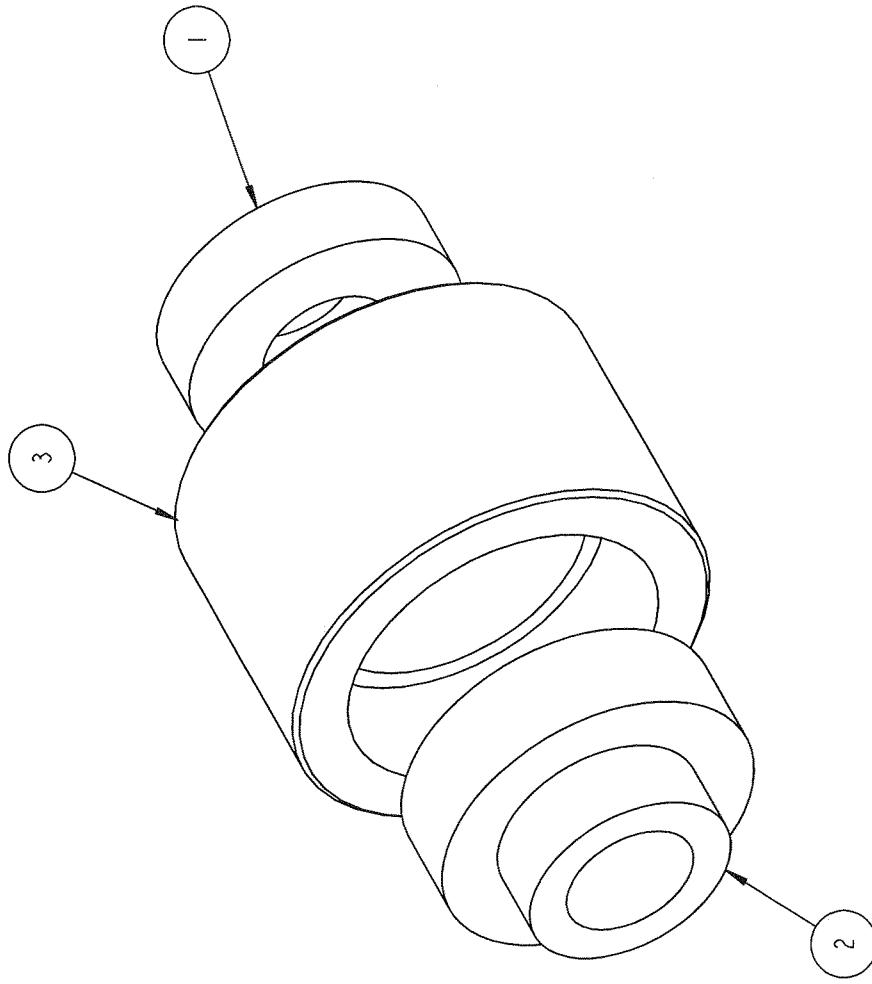
ITEM #	PART #	DESCRIPTION	REV NO.	DATE	ECN NO.	BT
1	4	102207 COLLAR .750				
2	4	545674-02 ASSY. ROLLER				
3	2	545677-01 ARM. SPRING MOUNT				
4	4	545678-01 ASSY. TAKEUP I IN BELT				
5	1	545681-01 SHAFT SPRING MOUNT				
6	4	545682-01 BRACKET, SPRING ANCHOR				
7	1	545746-03 SPACER, FRAME				



DRAWING #:	SCALE	DIMENSIONAL TOLERANCES			NOTES:	TRIM & ASSEMBLY	PROPRIETARY AND CONFIDENTIAL	REO'D WHERE USED
A KEY	0 .750	UNLESS OTHERWISE NOTED	N/A					
CHECKED BY:	DATE	IN	MM	IN	MM			
	01 - Mar - 05	.45	.445	.5	.500			
MAILED BY:	MASTER	REMOVED FROM SHEET	STUDS AND SCREWS NOT TO BE TIGHTENED	NOT TO BE TIGHTENED	NOT TO BE TIGHTENED			
			ALL OTHER DIMENSIONS ARE FINISHED DIMENSIONS NOT SCALLED - WORK TO DIMENSIONS ONLY					
				N/A				
						SET NO. 1 OF 2		

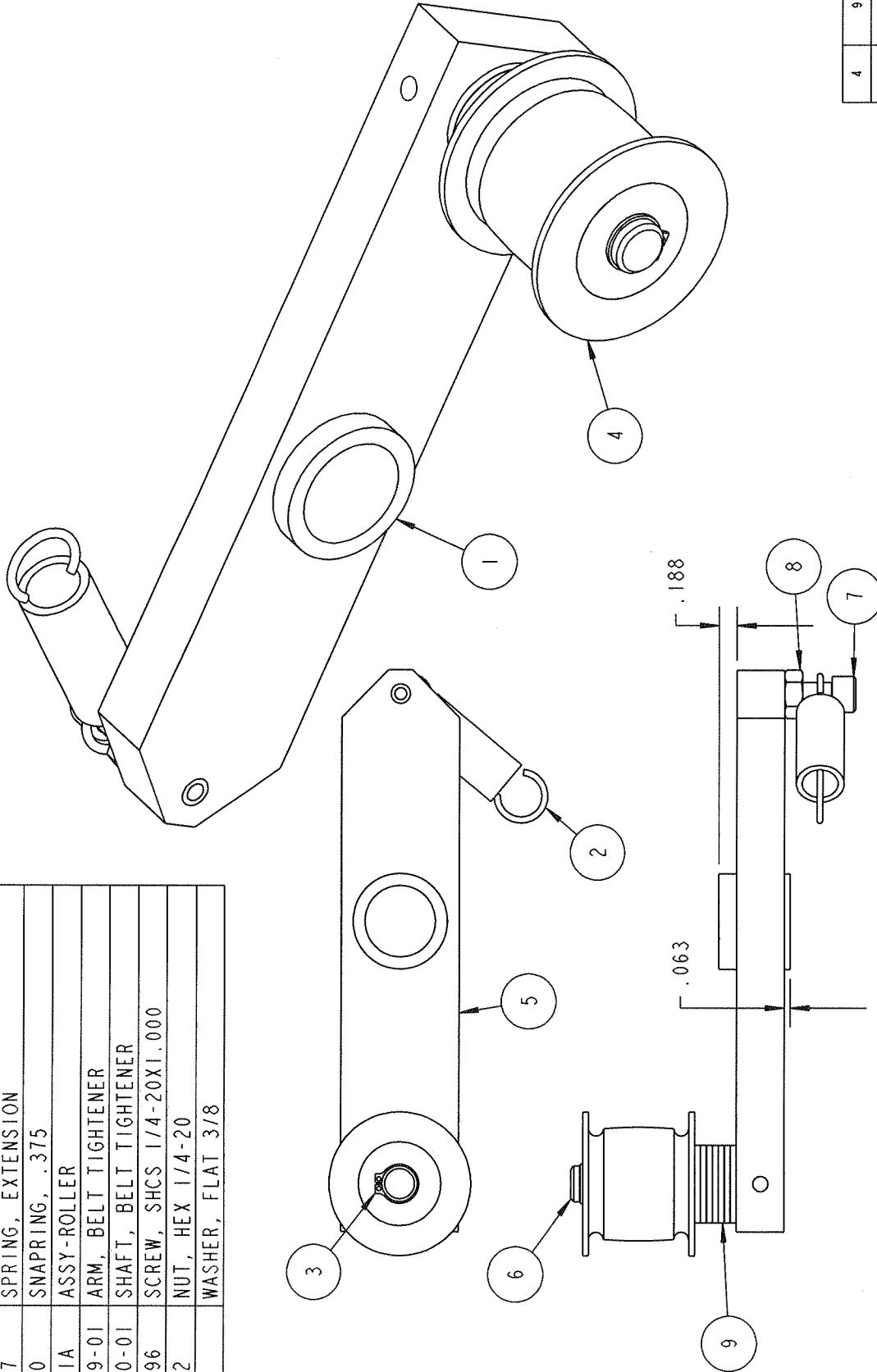
I	950
REO'D	WHERE USED
KRK	KIRK - RIDY, INC.
	WOODSTOCK, GEORGIA
	30166 USA
INITIAL:	ASSY, BELT TAKE UP
DRAWING #:	545673-01

ITEM QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	1	103112 BEARING, FLAT .750					
2	1	103805 BEARING, HUB .750					
3	1	545675-02 ROLLER, DIVERT					



4	950	REF'D	WHERE USED						
<p align="center">KR KIRK - RUDY, INC. KENNESAW, GEORGIA</p> <p align="center">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</p>									
<p align="center">THIRD ANGLE PROJECTION</p> <p align="center"> </p>		<p align="center">TITLE:</p> <p align="center">ASSY, ROLLER</p>							
<p align="center">DRAWN BY: A KEV</p> <p align="center">SCALE: 1 .000</p>		<p align="center">DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED</p> <table border="1"> <tr> <td>.xx</td> <td>.xxx</td> <td>ANG.</td> </tr> <tr> <td>.01</td> <td>.005</td> <td>.5</td> </tr> </table> <p align="center">HEAT TREAT: N/A</p>	.xx	.xxx	ANG.	.01	.005	.5	<p align="center">MATERIAL: N/A</p> <p align="center"> </p>
.xx	.xxx	ANG.							
.01	.005	.5							
<p align="center">CHECKED BY: 21-Sep-04</p>		<p align="center">REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED</p>	<p align="center">MODEL: 950</p>						
<p align="center">TRACED BY: MASTER</p>		<p align="center">ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY</p>	<p align="center">SHEET NO.: 10F1</p> <p align="center">DRAWING #</p>						

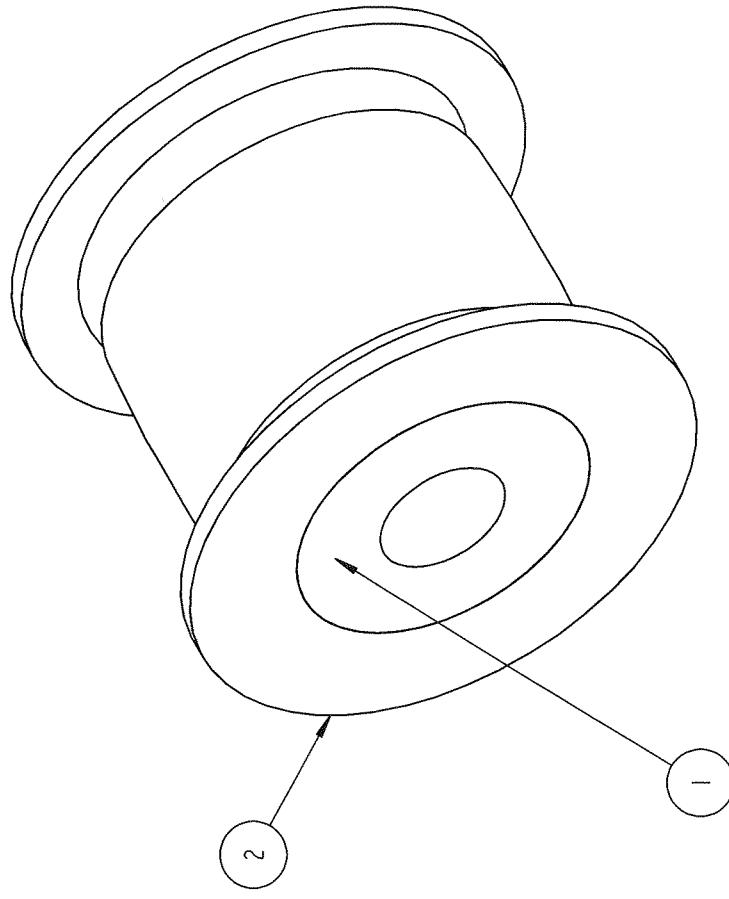
ITEM QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	100141	BUSHING, SL.7501DI.0000D.750LG					
2	102607	SPRING, EXTENSION					
3	104100	SNAPRING, .375					
4	510611A	ASSY-ROLLER					
5	1545679-01	ARM, BELT TIGHTENER					
6	1545680-01	SHAFT, BELT TIGHTENER					
7	CSDD296	SCREW, SHCS 1/4-20X1.000					
8	1HMSN12	NUT, HEX 1/4-20					
9	7WA013	WASHER, FLAT 3/8					



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	REO'D WHERE USED
CHECKED BY:		DATE	.xx .xxx ANG.	.01 .005 .5	HEAT TREAT:	N / A			
TRACED BY:	01 - Mar - 05	MASTER	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED	ALL DIMENSIONS ARE FINISHED DIMENSIONS	FINISH:	N / A	MODEL: 950	TITLE: ASSY, TAKEUP IN BELT	DRAWING #
								10F2	SHEET NO.:

510611A

ITEM	QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	2	103106	BEARING, FLAT .375					
2	1	510611	ROLLER, IDLER					

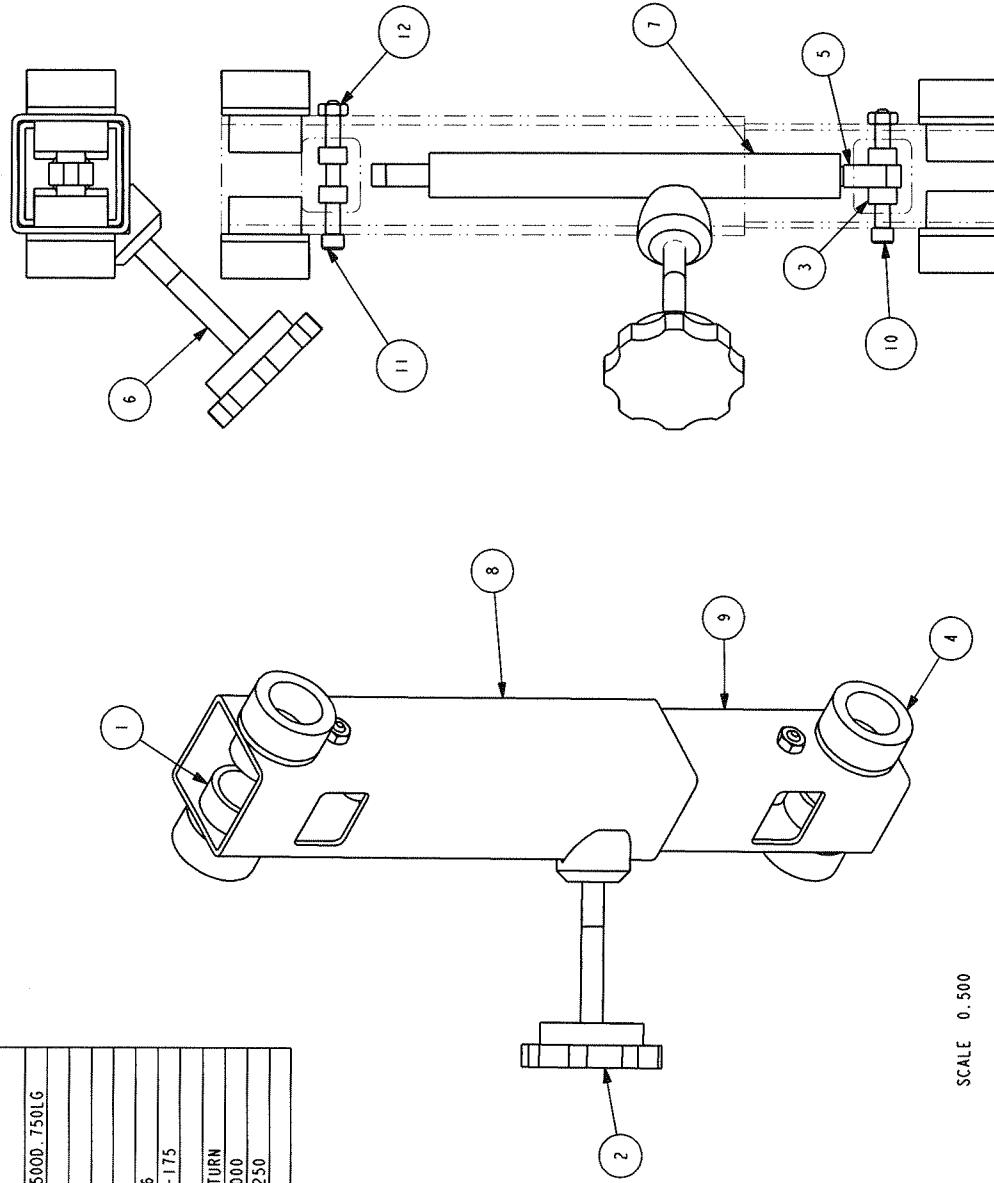


		<input checked="" type="checkbox"/> XXX		REO'D	WHERE USED
DRAWN BY:	T JG	SCALE	2.000	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	
CHECKED BY:		DATE	10 - Sep - 98	.xx	.xxx
TRACED BY:	MASTER	MATERIAL	X X X	.01	.005
		THIRD ANGLE PROJECTION		.5	HEAT TREAT:
					N / A
				REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED	
				ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY	
		MODEL:	X X X	TITLE: ASSY - ROLLER	
		FINISHES:	N / A	SHEET NO. 10 OF 1	DRAWING # 510611A

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

DRAWING #: 545750-01

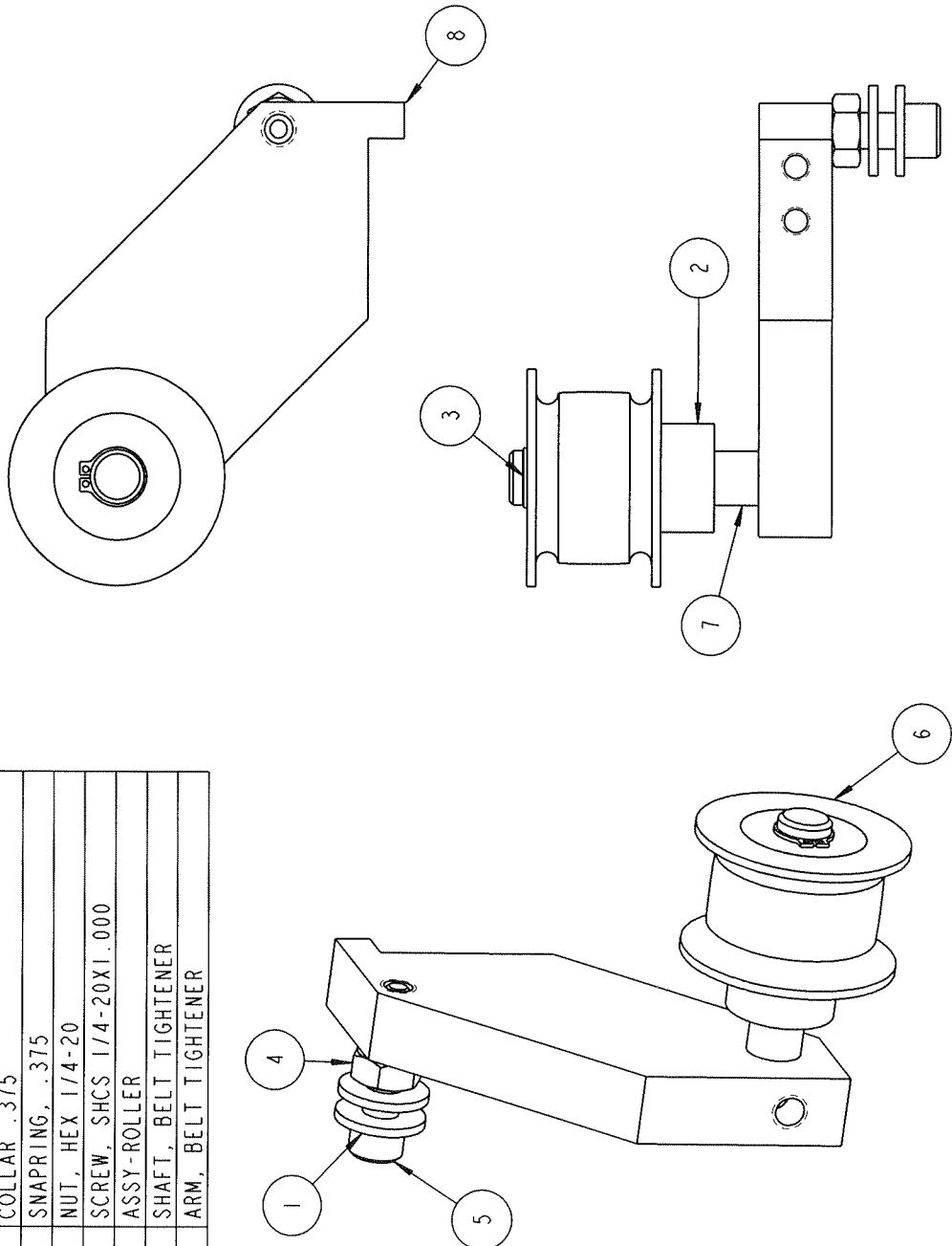
ITEM QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BT
1	4	100326 BUSHING, FLI 0001D, 250OD, 750LG					
2	1	102112 KNOB					
3	4	102206 COLLAR .250					
4	4	102217 COLLAR 1.000					
5	2	150841 BLOCK, CYLINDER MOUNT					
6	1	105601-1 SHAFT, THREADED 3/8-16					
7	1	150823-1 GAS SPRING, 100LB GAS-175					
8	1	545751-01 WLDNT, TUBING CLAMP					
9	1	545753-01 TUBING, VERTICAL BUMPTURN					
10	1	CSD300 SCREW, SHCS 1/4-20x2.000					
11	1	CSD301 SCREW, SHCS 1/4-20x2.250					
12	2	HMSN12 NUT, HEX 1/4-20					



SCALE 0.500

1	950	REVISION WHERE USED
KIRK - RUDY, INC. WOODSTOCK, GEORGIA		
TITLE: ASSY, INFEED LIFT		
DRAWING #: 545750-01		
SCALE: 0.500		
DIMS ON DRAWING UNLESS OTHERWISE NOTED		
IN MM. IN. MM. MM.		
ALL SURFACES AND EDGES ARE FINISHED UNLESS OTHERWISE NOTED		
ALL DIMENSIONS ARE IN MM. WORK TO DIMENSIONS ONLY		
MASTER		

ITEM	QTY	PART #	DESCRIPTION
1	2	100401	WASHER, THRUST TB410
2	1	102200	COLLAR .375
3	1	104100	SNAPRING, .375
4	1	106720	NUT, HEX 1/4-20
5	1	107407	SCREW, SHCS 1/4-20X1.000
6	1	510611-1A	ASSY-ROLLER
7	1	545680-01	SHAFT, BELT TIGHTENER
8	1	547852-01	ARM, BELT TIGHTENER

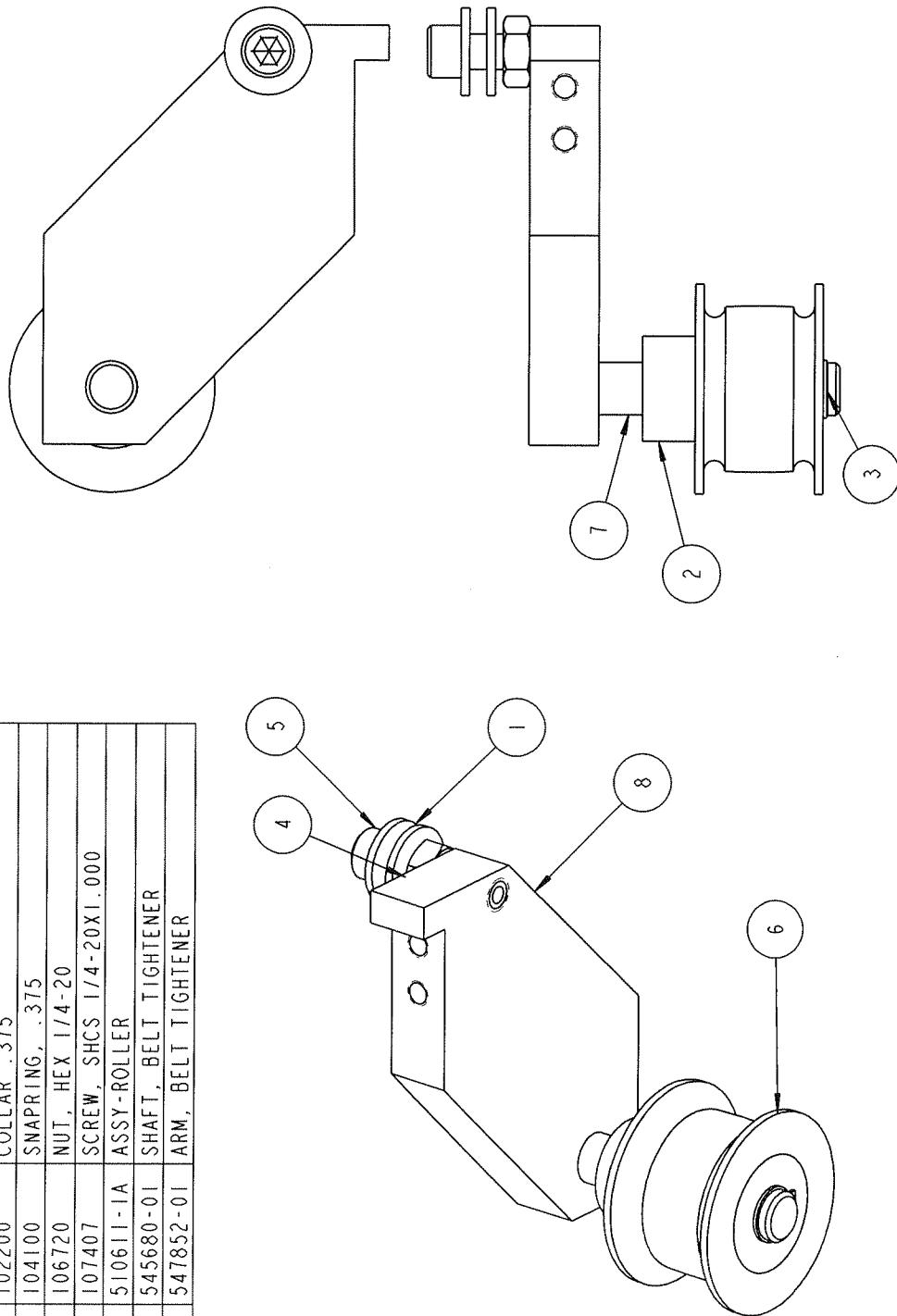


REV NO	DATE	DESCRIPTION	ECN NO	BY

1	950
REV'D	WHERE USED

DRAWN BY:	SCALE	0 .875	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	.xx	.xxx	ANG.	HEAT TREAT:	N/A	KIRK - RUDY, INC.	KIRK-RUDY, INC. WOODSTOCK, GEORGIA
TRACED BY:	MASTER	.01	.005	.5	FINISH:	N/A	MODEL: 950	TITLE: ASSY, BELT DIVERT RH
		REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED		ALL DIMENSIONS ARE IN INCHES DO NOT SCALE - WORK TO DIMENSIONS ONLY	SHEET NO.: 0F1		DRAWING #	547851-01

ITEM	QTY	PART #	DESCRIPTION
1	2	100401	WASHER, THRUST TB410
2	1	102200	COLLAR .375
3	1	104100	SNAPRING .375
4	1	106720	NUT, HEX 1/4-20
5	1	107407	SCREW, SHCS 1/4-20X1.000
6	1	510611-1A	ASSY-ROLLER
7	1	545680-01	SHAFT, BELT TIGHTENER
8	1	547852-01	ARM, BELT TIGHTENER



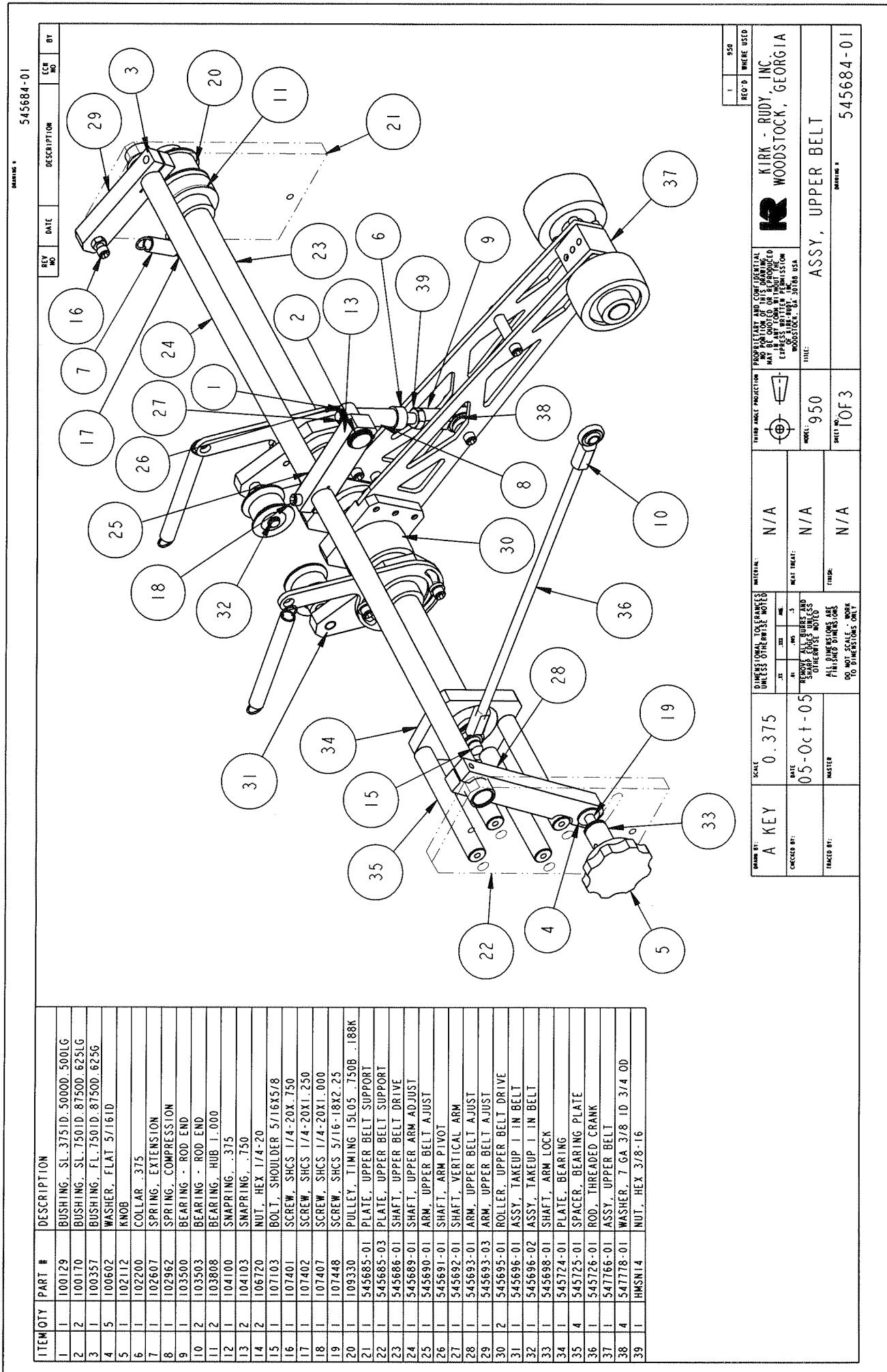
DRAWN BY:	SCALE	KEY	DATE	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	MATERIAL:	THIRD ANGLE PROJECTION	PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE COPIED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY INC. WOODSTOCK, GEORGIA
MASTER	0 .875	.01 .005 .5	07-Dec-05	.01 .005 .5	N/A		KIRK - RUDY, INC. WOODSTOCK, GEORGIA
TRACED BY:					HEAT TREAT:		TITLE: ASSY, BELT DIVERT LH MODEL: 950 SHEET NO. 0F1 DRAWING #: 547851-02
					FINS:		
					ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY		

1	950
REQ'D	WHERE USED

ITEM	QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	2	103106	BEARING, FLAT .375					
2	1	510611	ROLLER, IDLER					

XXX
RECD WHERE USED

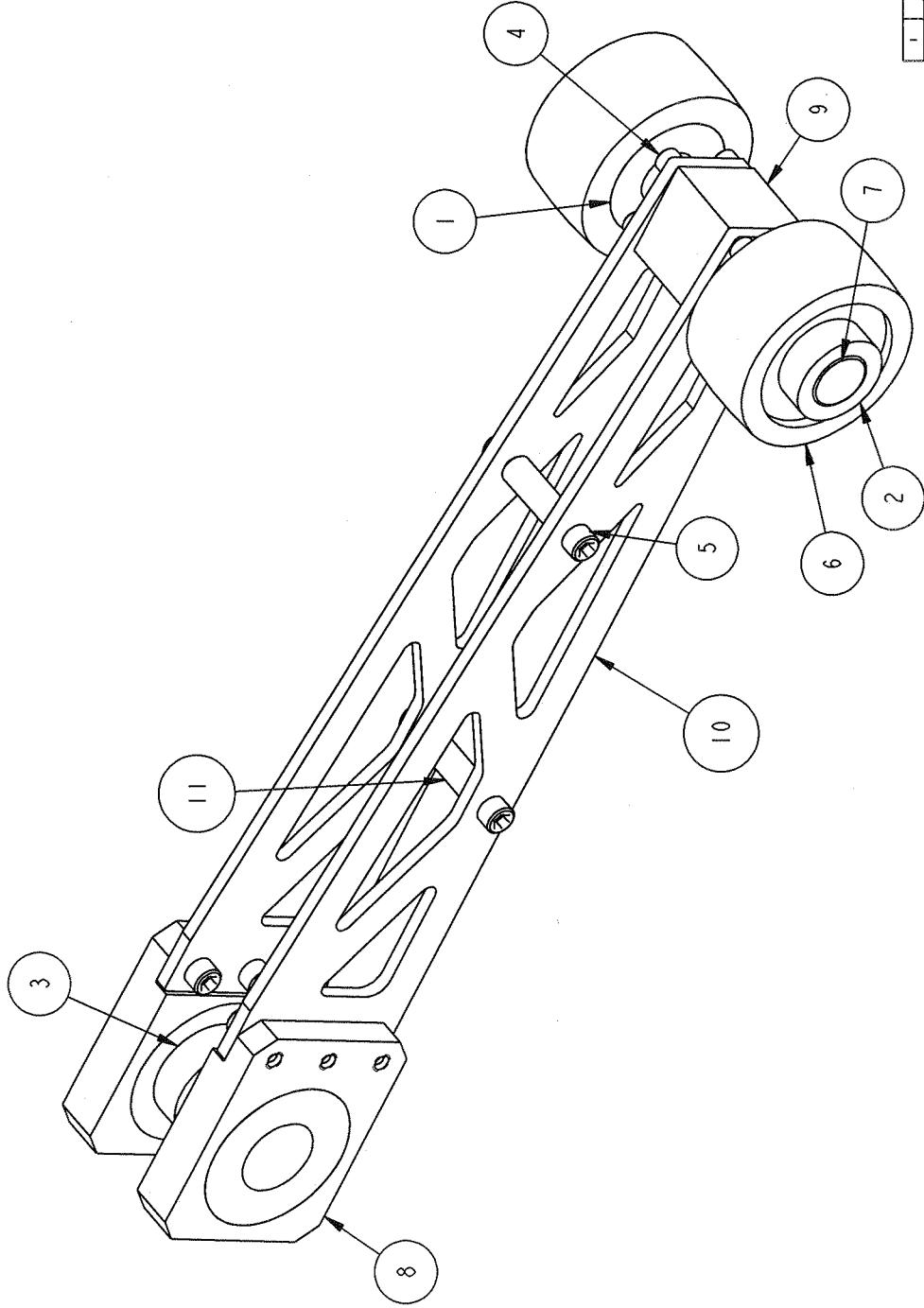
DRAWN BY: T J G	SCALE 2 . 000	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED			MATERIAL: X X X	THIRD ANGLE PROJECTION 	PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE QUOTED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC. KENNESAW, GA 30144 USA	
CHECHED BY:	DATE 10 - Sep - 98	.xx	.xxx	ANG. .01 .005 .5	HEAT TREAT: N / A	MODEL: X X X	TITLE: ASSY - 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 10 OF 1	DRAWING # 510611A	



DRAWING #

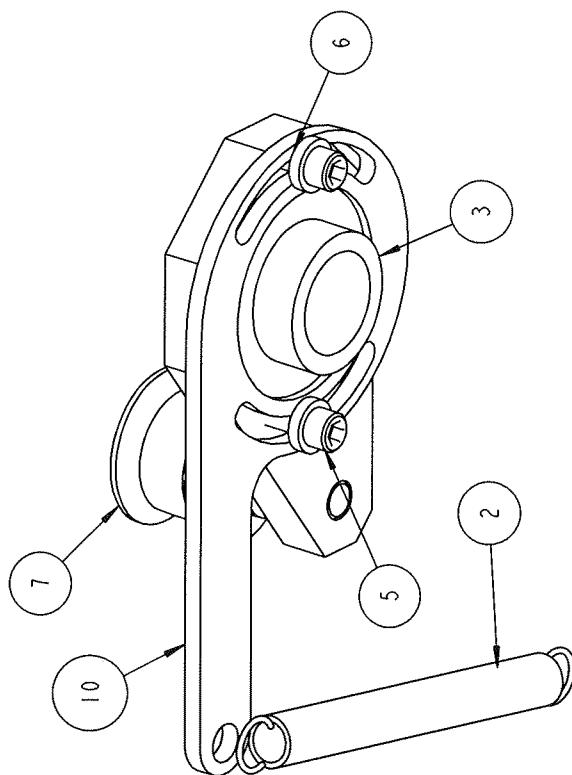
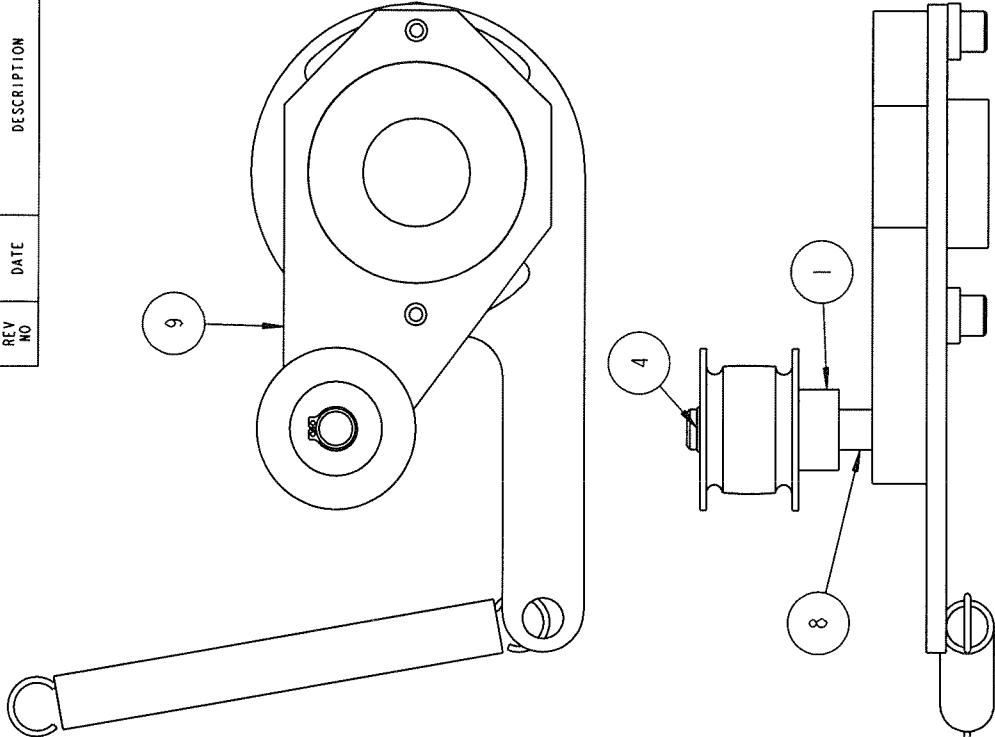
547766-01

ITEM #	PART #	DESCRIPTION	REV NO	DATE	ECN NO	BY
1	2	103112 BEARING, FLAT .750				
2	2	103805 BEARING HUB .750				
3	2	103808 BEARING, HUB 1.000				
4	8	101409 SCREW, SHCS 10-32X .500				
5	10	101410 SCREW, SHCS 1/4-20X .500				
6	2	545675-01 ROLLER, DIVERT				
7	1	545694-01 SHAFT, UPPER ROLLER IDLER				
8	2	547762-01 PLATE, BEARING MNT				
9	1	547763-01 BLOCK, ROLLER STUD MOUNT				
10	2	547764-01 BRACKET, ROLLER ARM				
11	2	547765-01 SPACER, ROLLER ARM				



REO'D	WHERE USED
KIRK - RUDY, INC.	
WOODSTOCK, GEORGIA	
TITLE: ASSY, UPPER BELT	
SCALE: 0.750	
DIMENSIONAL TOLERANCES: N/A	
UNLESS OTHERWISE NOTED	
IN INCHES	
INCH	MM
0.1 - Mar - 05	
PRINTED, CHECKED, APPROVED AND SIGNED BY: N/A	
ALL DIMENSIONS ARE FINISHED DIMENSIONS	
DO NOT SCALE - DRAW TO DIMENSIONS ONLY	
SHEET NO:	1 OF 3
DRAWING #: 547766-01	

ITEM	QTY	PART #	DESCRIPTION
1	1	102200	COLLAR .375
2	1	102964	SPRING, EXTENSION
3	1	103808	BEARING, HUB 1.000
4	1	104100	SNAPRING .375
5	2	107428	SCREW, SHCS 1/4-20X .625
6	2	111509	WASHER, FLAT .25710 .51500 .120TH
7	1	510611-1A	ASSY-ROLLER
8	1	545680-01	SHAFT, BELT TIGHTENER
9	1	545697-01	ARM, BELT TIGHTENER
10	1	547231-01	BRACKET, SPRING ADJUST



ITEM	QTY	PART #	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	1	102200					

1	950	REF'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, GEORGIA

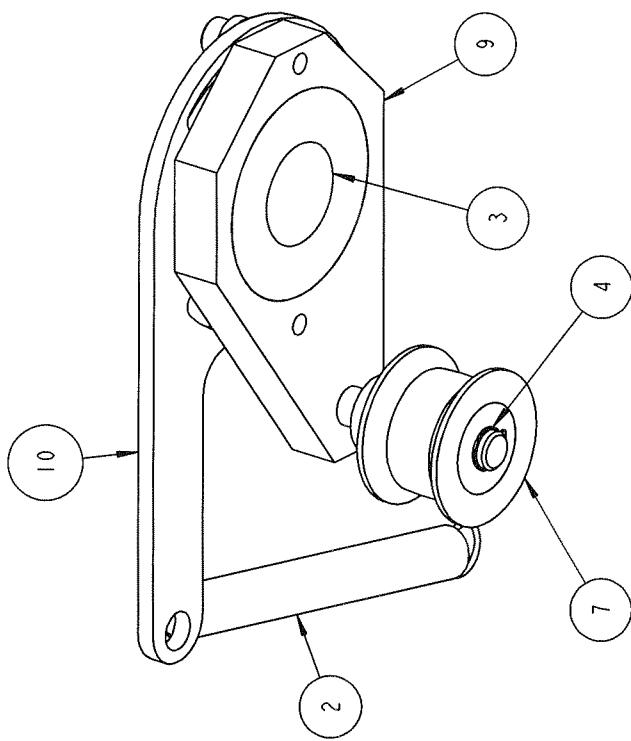
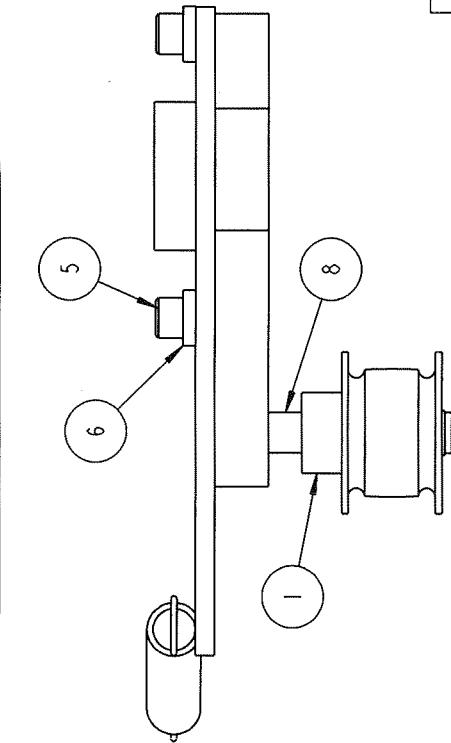
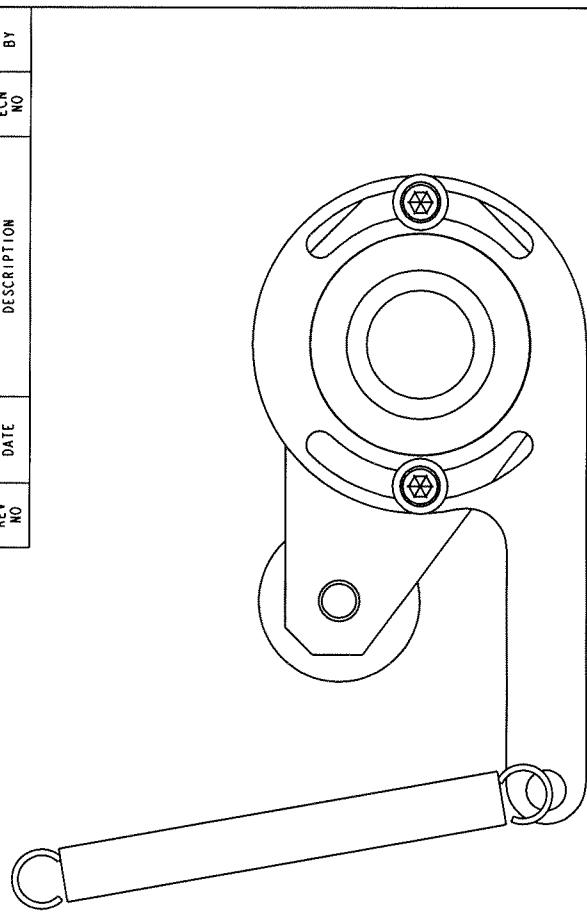
TITLE:

ASSY, TAKEUP IN BELT

545696-01

DRAWN BY:	SCALE	MATERIAL:	THIRD ANGLE PROJECTION
A KEY	0 .625	N/A	
		DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	
CHECKED BY:	DATE	.01 .005 .5	HEAT TREAT:
	12-0C+05		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. 0F1
			DRAWING #

ITEM	QTY	PART #	DESCRIPTION
1	1	102200	COLLAR .375
2	1	102964	SPRING, EXTENSION
3	1	103808	BEARING, HUB 1.000
4	1	104100	SNAPRING, .375
5	2	107428	SCREW, SHCS 1/4-20X.625
6	2	111509	WASHER, FLAT .2571D .5150D .120TH
7	1	510611-1A	ASSY-ROLLER
8	1	545680-01	SHAFT, BELT TIGHTENER
9	1	545697-01	ARM, BELT TIGHTENER
10	1	547231-01	BRACKET, SPRING ADJUST



DRAWN BY: A KEY SCALE 0 .625 DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED

MATERIAL: N/A

HEAT TREAT: N/A

FINISH: 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, GEORGIA

WOODSTOCK, GA 30188 USA

CHECKED BY:

DATE: 12-0C+ -05

ANG.: .01 .005 .5

REMOVE ALL BURRS AND

SHARP EDGES UNLESS

OTHERWISE NOTED

ALL DIMENSIONS ARE

FINISHED DIMENSIONS

DO NOT SCALE, WORK

TO DIMENSIONS ONLY

TRACED BY:

MASTER

ECN NO.

BY

REV NO.

DATE

DESCRIPTION

ECN NO.

REO D

WHERE USED

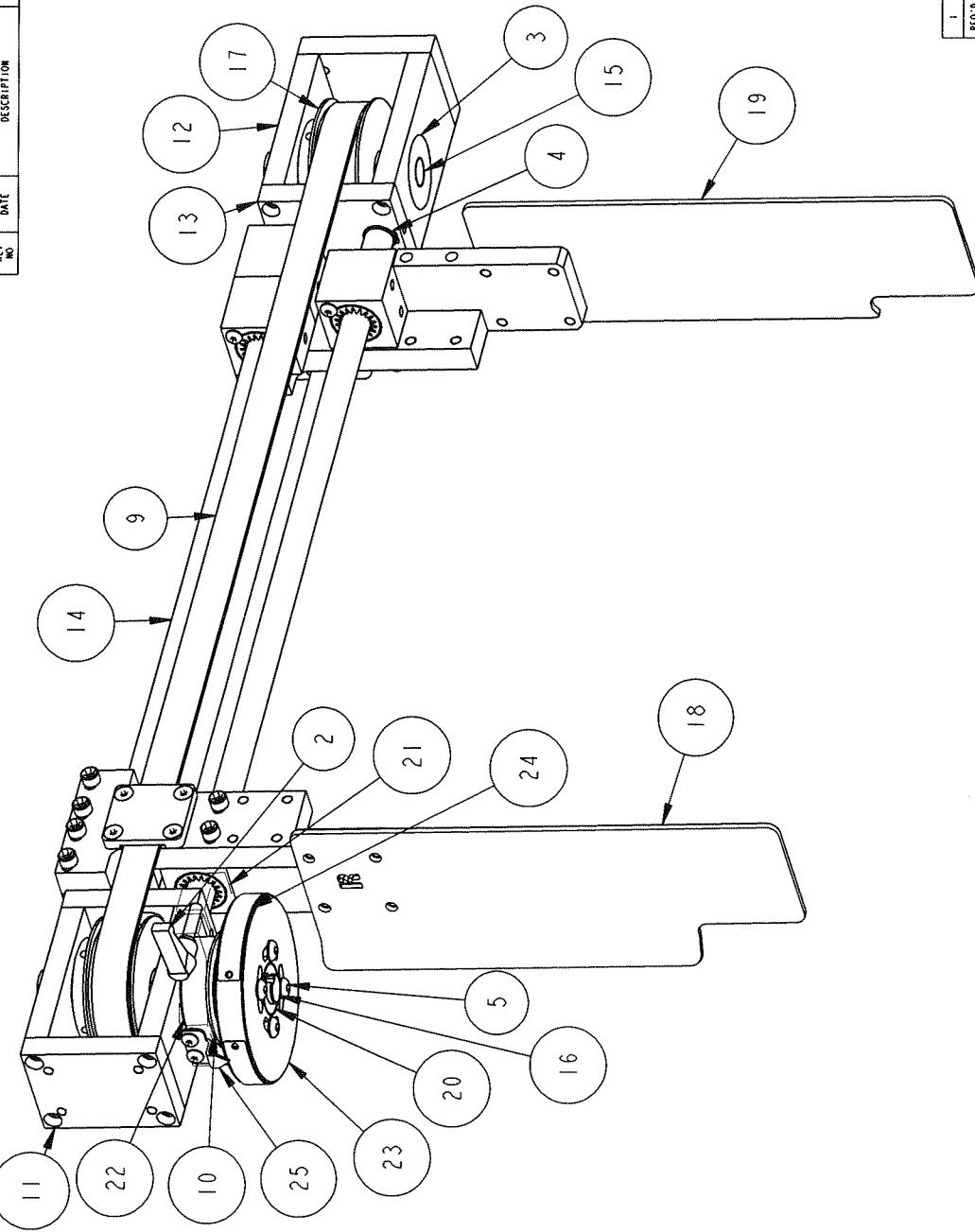
1

950

545696-02

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

1	4	100400			WASHER, THRUST TWS31	
2	1	102140			HANDLE, RELEASE 1/4-20 X 1.0	
3	4	103804			BEARING, HUB .625	
4	4	104104			SNAPRING, .625	
5	4	106800			SCREW, BUTTON HEAD 1/4X .750	
6	2	106811			SCREW, BUSHING .10-.32X .250	
7	1	101103			BOLT, SHOULDER 5/16X5/8	
8	4	1071428			SCREW, SHCS 1/4-20X .625	
9	1	109138-1			BELT, HTD TIMING 1440-8M-20	
10	1	543995-01			GUIDE, UPPER BELT ADJUST	
11	2	545709-01			PLATE, LH SIDE GUIDE MOUNT	
12	4	545710-01			PLATE, SIDEGUIDE BEARING	
13	2	545711-01			PLATE, SIDEGUIDE SHAFT MOUNT	
14	2	545712-01			SHAFT, SIDEGUIDE MOUNT	
15	1	545713-01			SHAFT, PULLEY IDEAL	
16	1	545714-01			SHAFT, SIDEGUIDE JOGGER	
17	2	545715-01			PULLEY, TIMING 288H20 .625B .188KEY	
18	1	545718-01			ASSY, RH SIDEGUIDE	
19	1	545719-01			ASSY, RH SIDEGUIDE	
20	1	545722-01			WHEEL, SIDEGUIDE ADJUST	
21	1	545723-01			PLATE, SIDEGUIDE CLAMP	
22	1	545730-01			HUB, SIDEGUIDE CLAMP	
23	1	545743-01			WHEEL, SIDEGUIDE ADJUST	
24	1	545744-01			RULE, FLAT SIDEGUIDE PLACEMENT	
25	1	545745-01			INDICATOR, SIDEGUIDE	

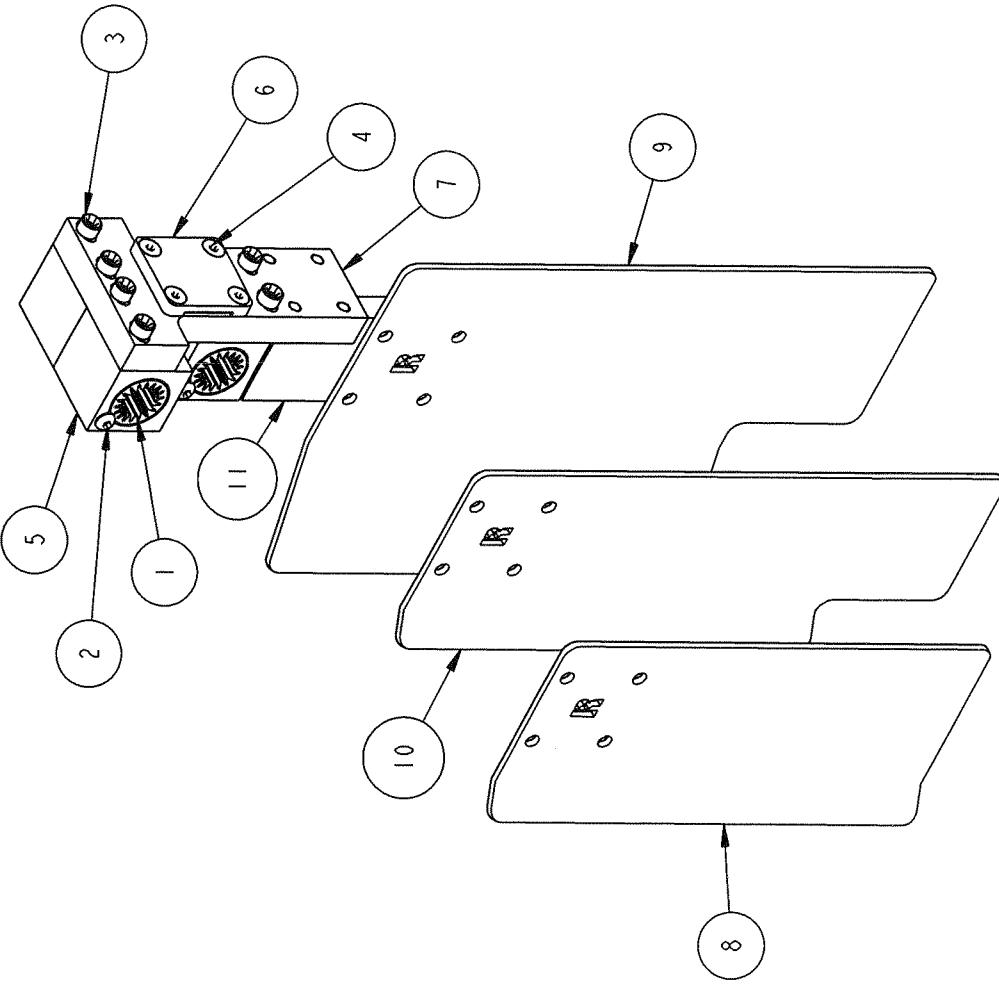


1	xxx	FIELD WHERE USED
KRK KIRK-RUDY, INC		
WOODSTOCK, GEORGIA		
ASSY, UPPER SIDEGUIDE		
DRAWING # 545707-01		

ITEM #:	A KEY	SCALE	0 .420	DIMENSIONAL TOLERANCES	MATERIAL:	N/A	TRADITIONAL PROJECTION	PROJECTION AND CONVENTIONAL
CHECKED BY:		DATE	31 - Jan - 06	IN INCHES .000 .005 .010 .000 .005 .010 .000 .005 .010	WEAR TREAT:	N/A	TOP	TOP
TRACED BY:		MASTER		REGENTS ALL ALUMINUM AND SOLID STATE ROTORS SOLID STATE ROTORS SOLID STATE ROTORS	TIME:	N/A	TOP	TOP
				ALL DIMENSIONS ARE IN INCHES. DASHED LINES DO NOT SCALE. WORK TO DIMENSIONS ONLY				

DRAWING #: 545718-01

ITEM #	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	3	100263 BUSHING .62510 1.12500 CROWNED					
2	4	106811 SCREW, BUTTON HEAD #10-32X.250					
3	6	107411 SCREW, SHCS 1/4-20X.875					
4	4	107526 SCREW, FLATHEAD 10-32X.325					
5	4	543987-01 BLOCK, FINGER SLIDE					
6	1	545631-01 PLATE, FINGER BELT CLAMP					
7	1	545716-01 PLATE, SIDEGUIDE MOUNT					
8	1	545717-01 GUIDE, UPPER SIDE					
9	1	545717-05 GUIDE, UPPER SIDE					
10	1	545717-09 GUIDE, UPPER SIDE					
11	1	547240-01 PLATE, SIDEGUIDE MOUNT					



I	545	RECD D DATE 04/09
KRK - RUDY, INC.		
KR WOODSTOCK, GEORGIA		
ITEM:	950	RECD:
GUIDE, UPPER SIDE	TOF 2	DRAWING #: 545718-01

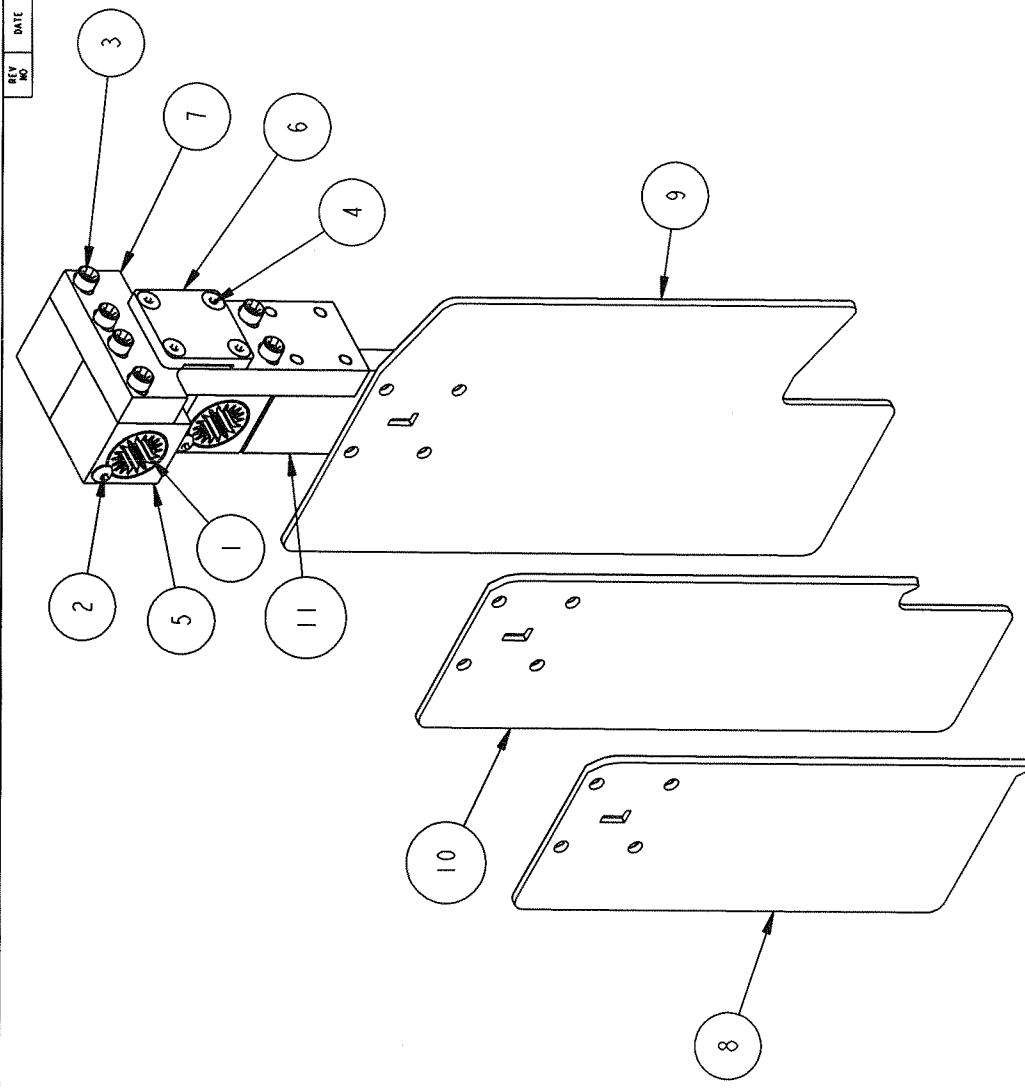
THIS DRAWING IS THE PROPERTY OF KRK - RUDY, INC. AND IS TO BE USED FOR INTERNAL PURPOSES ONLY. IT IS NOT TO BE COPIED OR DISCLOSED TO ANYONE OUTSIDE THE COMPANY. IT IS THE PROPERTY OF KRK - RUDY, INC. AND IS TO BE RETURNED UPON REQUEST. THIS DRAWING IS THE PROPERTY OF KRK - RUDY, INC. AND IS TO BE USED FOR INTERNAL PURPOSES ONLY. IT IS NOT TO BE COPIED OR DISCLOSED TO ANYONE OUTSIDE THE COMPANY. IT IS THE PROPERTY OF KRK - RUDY, INC. AND IS TO BE RETURNED UPON REQUEST.

ITEM #:	KEY	SCALE	MATERIAL:	ITEM #:	ITEM #:	ITEM #:	ITEM #:
CHECKED BY:		0 .200	22 GA STAINLESS STEEL	ITEM #:	ITEM #:	ITEM #:	ITEM #:
MAKER:	22 - Sep - 05	IN	N/A	ITEM #:	ITEM #:	ITEM #:	ITEM #:
INCHES:		MM	ITEM #:	ITEM #:	ITEM #:	ITEM #:	ITEM #:

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

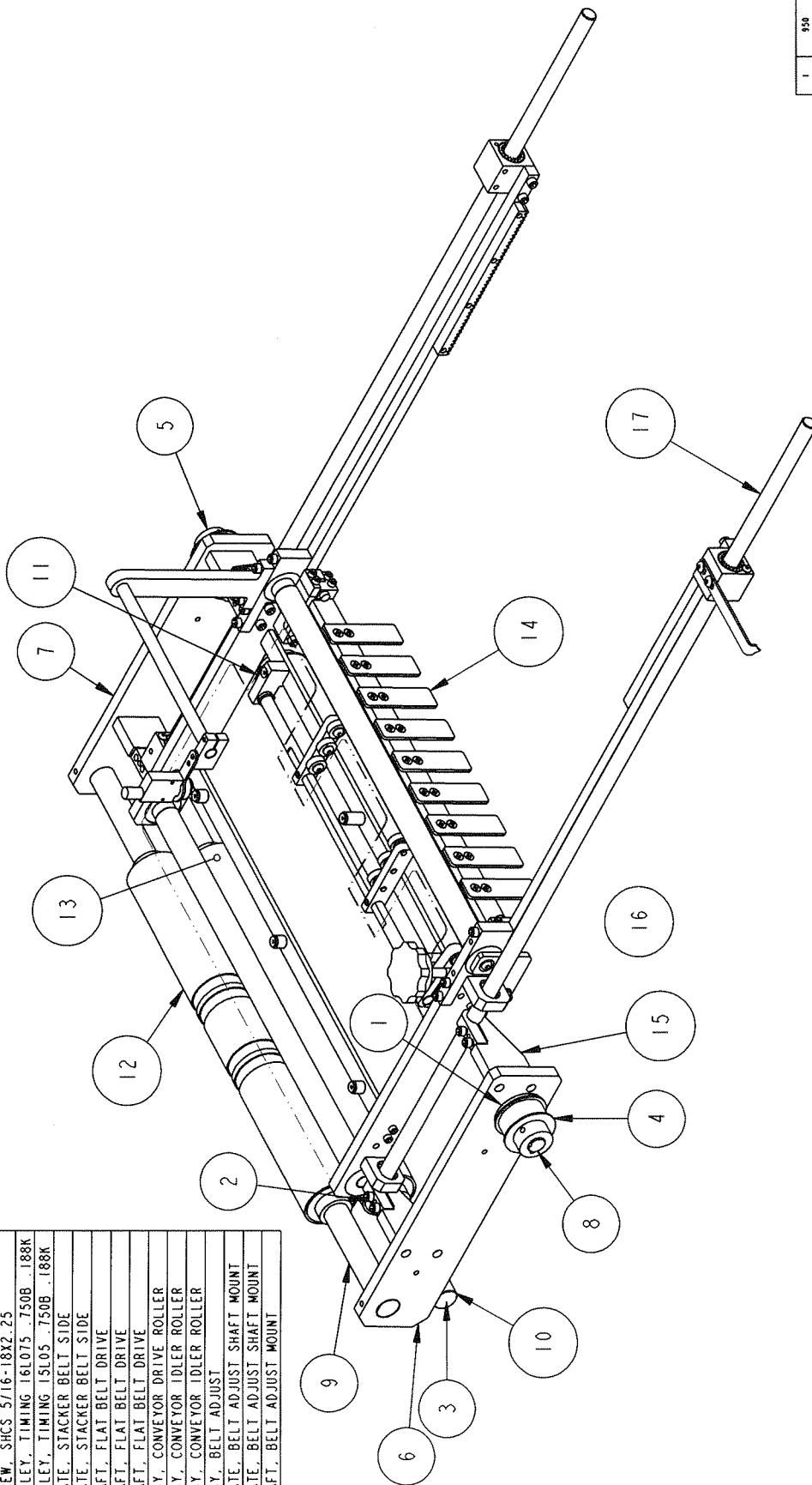
DRAWING # 545719-01

ITEM #	PART #	DESCRIPTION
1	3	1002-83 BUSHING .625ID X .1125OD CROWNED
2	4	106811 SCREW, BUTTON HEAD #10-32X.250
3	6	107411 SCREW, SHKS 1/4-20X.875
4	4	101526 SCREW, FLATHEAD #0-32X.625
5	4	543987-01 BLOCK, FINGER SLIDE
6	1	545631-01 PLATE, FINGER BELT CLAMP
7	1	545116-01 PLATE, SIDEGUIDE MOUNT
8	1	545117-02 GUIDE, UPPER SIDE
9	1	545117-06 GUIDE, UPPER SIDE
10	1	545117-08 GUIDE, UPPER SIDE
11	1	547240-01 PLATE, SIDEGUIDE MOUNT



REV NO.	DATE	DESCRIPTION	FCN NO.
I			950
RECD BY:			WHERE USED
22-Sep-05			KIRK-RUDY, INC WOODSTOCK, GEORGIA
MAKER:			TITLE:
MASTER			ASSY, RH SIDEGUIDE
TAKED BY:			545719-01

ITEM NO.	PART #	DESCRIPTION	REV. NO.	DATE	REV. NO.
1	2	103808 BEARING, HUB 1.000			
2	4	107407 SCREW, SHCS 1/4-20X1.000			
3	2	107448 SCREW, SHCS 5/16-18X2.25			
4	1	108820 PULLEY, TIMING 16L075 .750B .188K			
5	1	109330 PULLEY, TIMING 15L05 .750B .188K			
6	1	545633-01 PLATE, STACKER BELT SIDE			
7	1	545633-02 PLATE, STACKER BELT SIDE			
8	1	545634-01 SHAFT, FLAT BELT DRIVE			
9	1	545634-02 SHAFT, FLAT BELT DRIVE			
10	1	545634-03 SHAFT, FLAT BELT DRIVE			
11	1	545636-01 ASSY, CONVEYOR DRIVE ROLLER			
12	1	545636-03 ASSY, CONVEYOR IDLER ROLLER			
13	1	545636-04 ASSY, CONVEYOR IDLER ROLLER			
14	1	545637-01 ASSY, BELT ADJUST			
15	4	545640-02 PLATE, BELT ADJUST SHAFT MOUNT			
16	4	545640-03 PLATE, BELT ADJUST SHAFT MOUNT			
17	2	545641-01 SHAFT, BELT ADJUST MOUNT			



ITEM NO.	SCALE	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED		REV. NO.	REVISIONS
A	KEY	0 .250	N/A		
CHECKED BY:	DATE	.000	.000		
07-Dec-05					
TRACTED BY:	MASTER	N/A	N/A		
		ALL DIMENSIONS ARE IN INCHES. OVERSIZE AND UNDERSIZE TOLERANCES ARE .005 UNLESS OTHERWISE NOTED. DASHED LINES INDICATE NO SCALE. WORK TO DRAWINGS ONLY			

KIRK - RUDY, INC.
WOODSTOCK, GEORGIA

ASSY, BELT DRIVE FRAME

DRAWING # 545738-01

ITEM	QTY	PART #	DESCRIPTION	KEY NO.	DATE	DESCRIPTION	LEN NO.	BY
1	2	100132	BUSHING, SL. 250 ID. 3750D. 500 LG					
2	2	100283	BUSHING, 62510 I. 1250D					
3	1	100314	BUSHING, FL. 3131D. 4380D. 250 LG					
4	1	100604	WASHER, FLAT 1/4ID BRASS					
5	2	103104	BEARING, FLAT .230					
6	4	103804	BEARING, HUB .625					
7	1	106720	NUT, HEX 1/4-20					
8	2	106736	NUT, HEX #10-32					
9	1	106801	SCREW, BUTTON HEAD 1/4X.875					
10	6	106811	SCREW, BUTTON HEAD 10-32X.250					
11	2	106818	SCREW, BUTTON HEAD 1/4X.500					
12	2	107000	BOLT, SHOULDER 1/4X1 1/2					
13	1	107101	BOLT, SHOULDER 5/16X1 3/8					
14	4	107406	SCREW, SHCS 10-32X.1 250					
15	4	107407	SCREW, SHCS 1/4-20X1.000					
16	12	107411	SCREW, SHCS 1/4-20X.875					
17	4	107425	SCREW, SHCS 1/4-20X1.750					
18	4	107429	SCREW, SHCS 10-32X.625					
19	8	107430	SCREW, SHCS 10-32X.750					
20	2	107447	SCREW, SHCS 1/4-20X2.000					
21	6	107521	BLOCK, FLATHEAD 10-32X.250					
22	18	107546	SCREW, FLAT UNDERCUT 10-32X.250					
23	2	201055-1	PROXIMITY					
24	3	542987-01	BLOCK, FINGER SLIDE					
25	1	542987-02	BLOCK, FINGER SLIDE					
26	1	543987-03	BLOCK, FINGER SLIDE					
27	1	543987-04	BLOCK, FINGER SLIDE					
28	2	545641-01	PLATE, BELT ADJUST					
29	1	545639-01	ROLLER, BELT ADJUST					
30	1	545639-02	ROLLER, BELT ADJUST					
31	1	545643-01	PLATE, SIDEGUIDE JOGGER					
32	2	545644-01	PLATE, SIDE GUIDE MOUNT					
33	1	545645-01	PLATE, SIDEGUIDE MOUNT					
34	6	545650-01	GUIDE, FRONT SIDE					
35	3	544650-03	GUIDE, FRONT SIDE					
36	2	545651-01	BAR, UPPER BELT ADJUST SPACER					
37	2	545652-01	BLOCK, BEARING					
38	2	545656-01	PLATE, RACK GEAR MOUNT					
39	2	545662-01	GEAR, SIDEGUIDE ADJUST RACK					
40	1	545665-01	TOP, HORZ. TABLETOP					
41	3	545683-01	SPACER, TABLETOP					
42	1	545683-02	SPACER, TABLETOP					
43	1	545721-01	ASSY, PRODUCT DISHING					
44	2	545731-01	BRACKET, PROX MOUNT					
45	1	545740-01	INDICATOR, SIDEGUIDE					
46	1	547208-01	ASSY, ELEM SWITCH MOUNT					
47	1	547225-01	BRACKET, SIDEGUIDE JOGGER					
48	2	547233-01	BLOCK, GUIDE PIVOT					
49	2	547234-01	BLOCK, GUIDE PIVOT					
50	2	547532-01	BUSHING, 62510 I. 1250D CROWNED					
51	4	CSTF63	SCREW, BUTTON HEAD 1/4X.250					

DIMENSIONAL TOLERANCES		MATERIAL		DIMENSIONAL TOLERANCES		MATERIAL	
UNLESS OTHERWISE NOTED		IN		IN		IN	
A KEY	0.270	IN	.000	IN	.000	IN	.000
CHECKED BY:	DATE: 12 - JULY - 04	REMOVED	ALL BURRS & CO.	MADE BY:	DATE: 12 - JULY - 04	REMOVED	ALL BURRS & CO.
TRACTED BY:	MASTER	INCHES	INCHES	TRACTED BY:	MASTER	INCHES	INCHES
47							
48							
49							
50							
51							

REO WHERE ISSUED
KRK KIRK - RUDY, INC.
 WOODSTOCK, GEORGIA

MATING :
 545637-01

DETAIL B
 SCALE 0.500

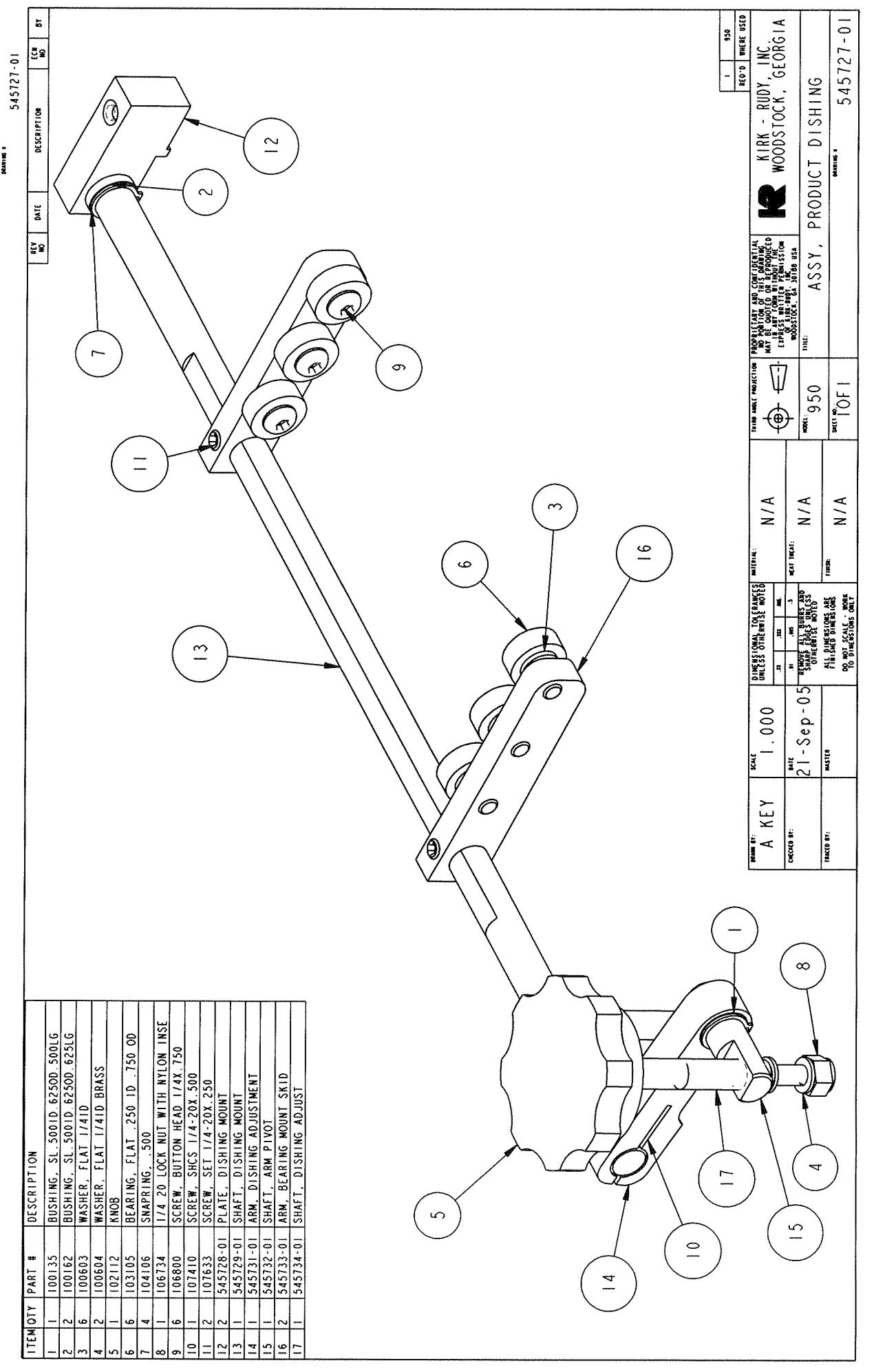
DETAIL A
 SCALE 0.500

47

ASSY, BELT ADJUST
 MATING :
 545637-01

Drawing # 545727-01

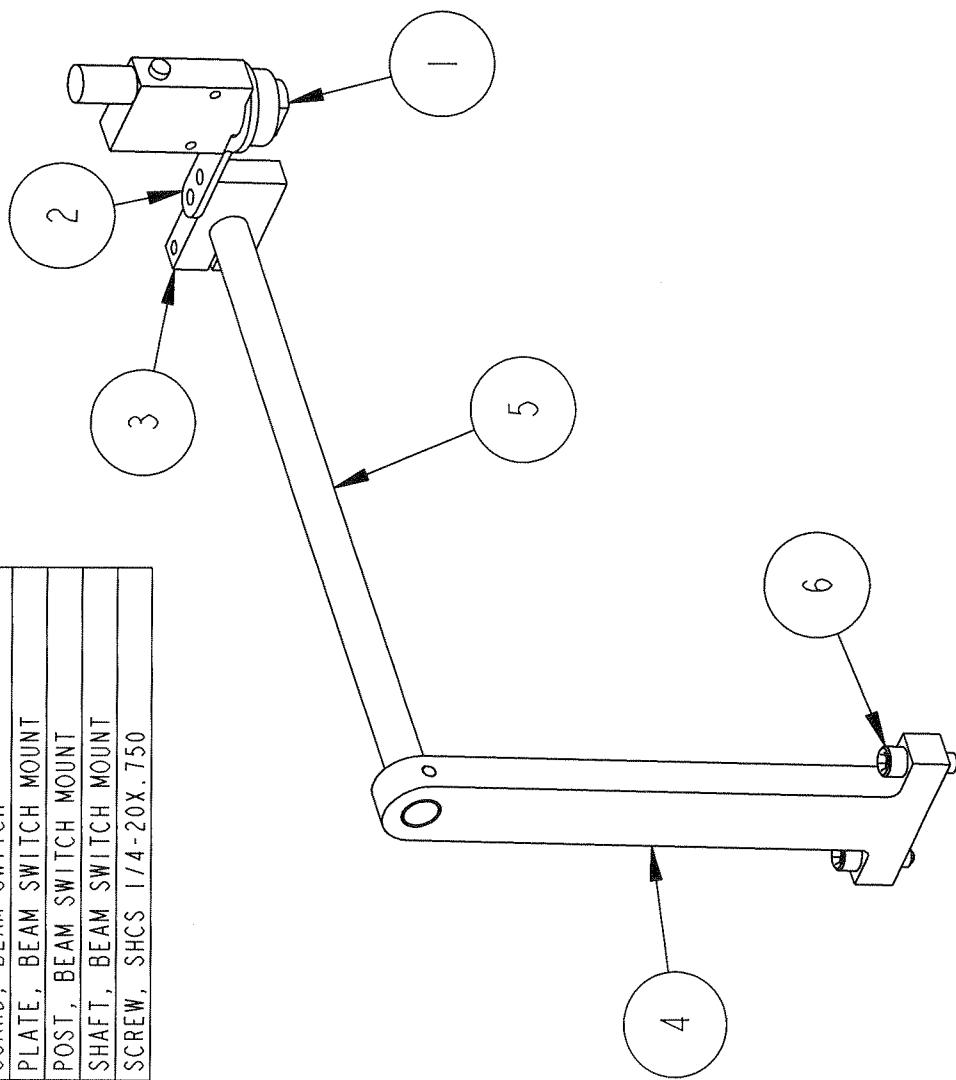
ITEM #	PART #	DESCRIPTION
1	1 100135	BUSHING, SL. 500 ID. 62500 500 LG
2	2 100162	BUSHING, SL. 500 ID. 62500 625LG
3	6 100603	WASHER, FLAT 1/4ID
4	2 100604	WASHER, FLAT 1/4ID BRASS
5	1 102112	KNOB
6	6 103105	BEARING, FLAT .250 ID .750 OD
7	4 104106	SNAFFING, .500
8	1 106734	1/4 20 LOCK NUT WITH NYLON INSE
9	6 106800	SCREW, BUTTON HEAD 1/4X.750
10	1 107110	SCREW, SHCS 1/4-20X.500
11	2 107633	SCREW, SET 1/4-20X.250
12	2 545728-01	PLATE, DISHING MOUNT
13	1 545729-01	SHAFT, DISHING MOUNT
14	1 545731-01	ARM, DISHING ADJUSTMENT
15	1 545732-01	SHAFT, ARM PIVOT
16	2 545733-01	ARM, BEARING MOUNT SKID
17	1 545734-01	SHAFT, DISHING ADJUST



ITEM #	SCALE	DESCRIPTION	REV NO	DATE	ECN NO	BY
A KEY	1.000	DIMENSION TO FRAME	N/A			
		UNLESS OTHERWISE NOTED				
		IN MM	IN MM	IN MM	IN MM	
CHECKED BY:	MAF	21 - Sep - 05				
TRACED BY:	MASTER					

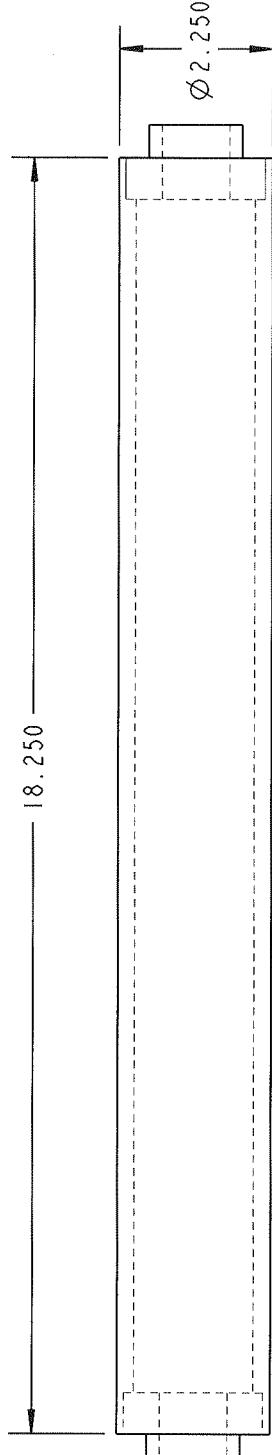
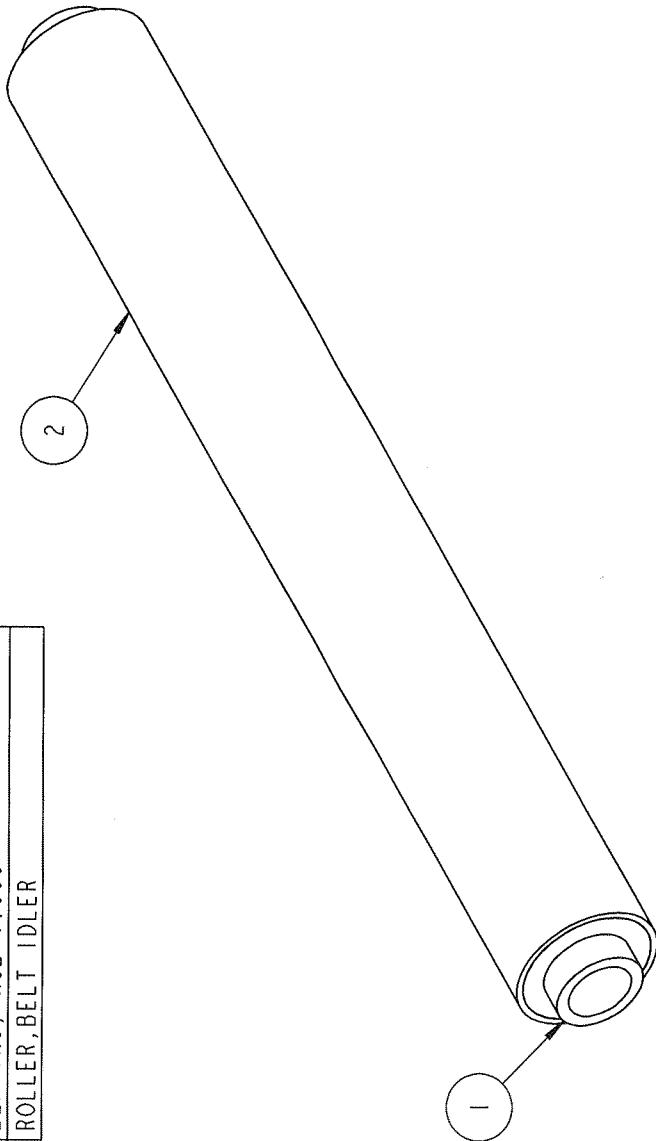
TECHNICAL DRAWING AND CONSTRUCTION PROBLEMS AND QUESTIONS MAY BE QUERIED OR REFERRED TO THE ENGINEERING DEPARTMENT, KIRK-RUDY INC., 1000 WOODSTOCK, GA 30388 USA
TITLE: ASSY, PRODUCT DISHING
MATERIAL: N/A
PART NO.: 950
SHEET NO.: 1 OF 1
DRAWING NO.: 545727-01

ITEM	QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	1	202261-5	BEAMSWITCH, RETROREFLECTIVE					
2	1	543401-04	GUARD, BEAM SWITCH					
3	1	545201-02	PLATE, BEAM SWITCH MOUNT					
4	1	547209-01	POST, BEAM SWITCH MOUNT					
5	1	547210-01	SHAFT, BEAM SWITCH MOUNT					
6	2	CSD294	SCREW, SHCS 1/4-20X.750					



1	950	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: A KEY	SCALE 0 . 438	THIRD ANGLE PROJECTION
DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	N / A	MATERIAL:
.xx .xxx .ANG.	.01 .005 .5	HEAT TREAT:
REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED		
CHECKED BY: DATE 01 - Mar - 05	N / A	FINISH:
TRACED BY: MASTER	N / A	MODEL: 950
		SHEET NO: 1 OF 1
		TITLE: ASSY, BEAM SWITCH MOUNT
		DRAWING # 5472008-01

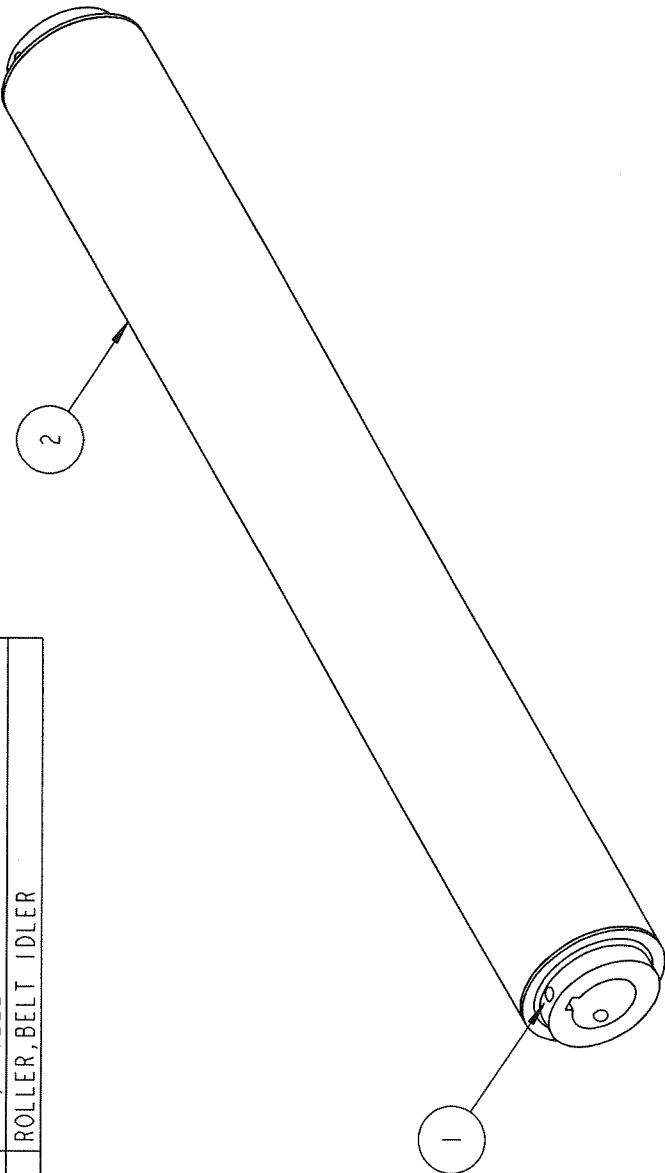
ITEM	QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	2	103808	BEARING, HUB 1.000					
2	1	545635-03	ROLLER,BELT IDLER					



SCALE 0.375

DRAWN BY: A KEY	SCALE 0 . 375	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED .xx .xxx ANG. .01 .005 .5	MATERIAL: NOTED	THIRD ANGLE PROJECTION ICON	PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE COPIED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC., USA KENNESAW, GA 30144 USA
CHECKED BY:	DATE 14-0C+ -04	HEAT TREAT: NONE	FINISH: ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY	MODEL: 950	TITLE: ASSY, CONVEYOR IDLER ROLLER DRAWING #
TRACED BY:	MASTER	NOTED	SHEET NO: 1 OF 1		545636-03

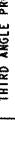
ITEM	QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	2	500330-9	HUB, ROLLER					
2	1	545635-01	ROLLER, BELT IDLER					



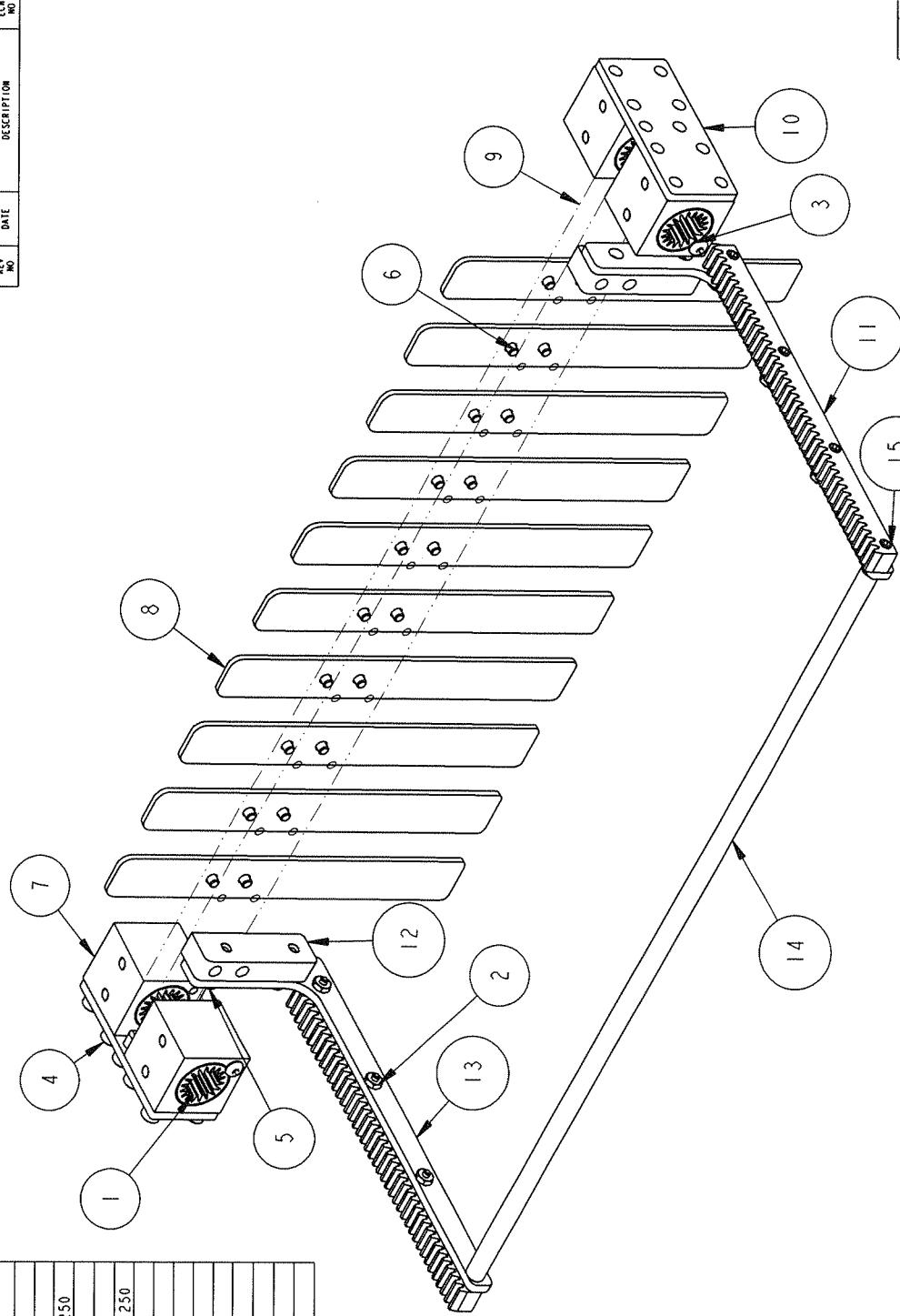
3.500 -

A technical drawing of a rectangular plate. The overall width is indicated as 18.500 on the left side. At the top center, there is a circular hole with a diameter of ϕ 2.250. A small dimension of 1.00 is shown near the bottom edge of the plate.

SCALE 0.375

DRAWN BY:	A KEY	SCALE	0 . 375	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	KIRK - RUDY, INC. KENNESAW, GEORGIA	REQ'D WHERE USED
CHECKED BY:		DATE	12 - JUL - 04	.xx	.XXX	ANG.				
TRACED BY:		MASTER		.01	.005	.5	HEAT TREAT: NONE	MODEL: 950	TITLE: ASSY, CONVEYOR DRIVE ROLLER	
REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED							FINISH: NOTED	SHEET NO.: 10F1	DRAWING #	

ITEM #	PART #	DESCRIPTION	REV #	DATE	DESCRIPTION	REV #
1	4	BUSHING .625 ID 1.12500				
2	6	NUT, HEX #6-32				
3	4	SCREW, BUTTON HEAD #10-32X.250				
4	10	SCREW, SHCS 1/4-20X.500				
5	2	SCREW, SHCS 1/4-20X.325				
6	20	SCREW FLHD UNDERCUT 10-32X.250				
7	4	BLOCK, FINGER SLIDE				
8	10	GUIDE, FRONT SIDE				
9	1	PLATE, BACK SIDE GUIDE				
10	2	PLATE, VERTICAL SIDE GUIDE				
11	2	GEAR, SIDEGUIDE ADJUST RACK				
12	2	BLOCK, RACK MOUNT				
13	2	BRACKET, RACK MOUNT				
14	1	SHAFT, RACK GEAR SPACER				
15	8	SCREW, SHCS 6-32X.750				
		CS00212				



DRAWING #:		SCALE:		DIMENSIONAL TOLERANCES		MATERIAL:		REMARKS:		WHERE USED	
A	KEY	0 .500		IN.	MM.	IN.	MM.	IN.	MM.	IN.	MM.
CHECKED BY:		DATE:	31 - Jan - 06	REMOVED ALL BURRS AND SHARP EDGES. BOLTS AND SCREWS ARE ALL PLATED. SURFACES TO MACHINING ARE WORK FINISHES ONLY. DRAWINGS ARE FOR INFORMATION ONLY.	REMOVED ALL BURRS AND SHARP EDGES. BOLTS AND SCREWS ARE ALL PLATED. SURFACES TO MACHINING ARE WORK FINISHES ONLY. DRAWINGS ARE FOR INFORMATION ONLY.	REMOVED ALL BURRS AND SHARP EDGES. BOLTS AND SCREWS ARE ALL PLATED. SURFACES TO MACHINING ARE WORK FINISHES ONLY. DRAWINGS ARE FOR INFORMATION ONLY.	REMOVED ALL BURRS AND SHARP EDGES. BOLTS AND SCREWS ARE ALL PLATED. SURFACES TO MACHINING ARE WORK FINISHES ONLY. DRAWINGS ARE FOR INFORMATION ONLY.	REMOVED ALL BURRS AND SHARP EDGES. BOLTS AND SCREWS ARE ALL PLATED. SURFACES TO MACHINING ARE WORK FINISHES ONLY. DRAWINGS ARE FOR INFORMATION ONLY.	REMOVED ALL BURRS AND SHARP EDGES. BOLTS AND SCREWS ARE ALL PLATED. SURFACES TO MACHINING ARE WORK FINISHES ONLY. DRAWINGS ARE FOR INFORMATION ONLY.	REMOVED ALL BURRS AND SHARP EDGES. BOLTS AND SCREWS ARE ALL PLATED. SURFACES TO MACHINING ARE WORK FINISHES ONLY. DRAWINGS ARE FOR INFORMATION ONLY.	REMOVED ALL BURRS AND SHARP EDGES. BOLTS AND SCREWS ARE ALL PLATED. SURFACES TO MACHINING ARE WORK FINISHES ONLY. DRAWINGS ARE FOR INFORMATION ONLY.
TRACED BY:		MASTER		SHEET #	OF	1					

KIRK - RODY, INC.
K WOODSTOCK, GEORGIA
ASSY, BACK SIDE GUIDE SLIDE
545657-01

PRINTED ON 10/10/2006 BY KIRK - RODY, INC.

ALL DRAWINGS ARE

FOR INFORMATION ONLY.

DRAWINGS ARE

FOR INFORMATION ONLY.

DO NOT USE.

PRINTED ON 10/10/2006 BY KIRK - RODY, INC.

ALL DRAWINGS ARE

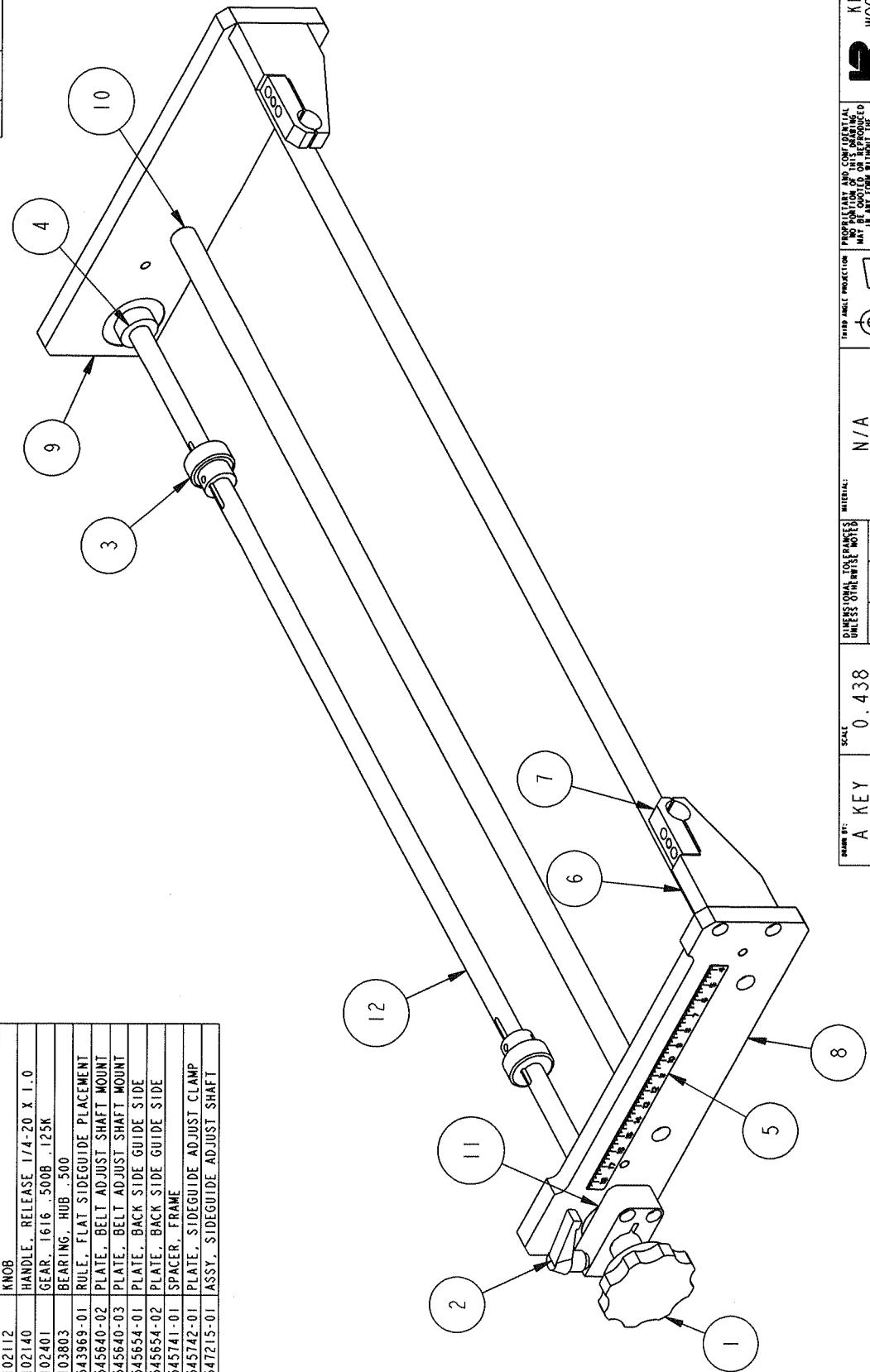
FOR INFORMATION ONLY.

DRAWINGS ARE

FOR INFORMATION ONLY.

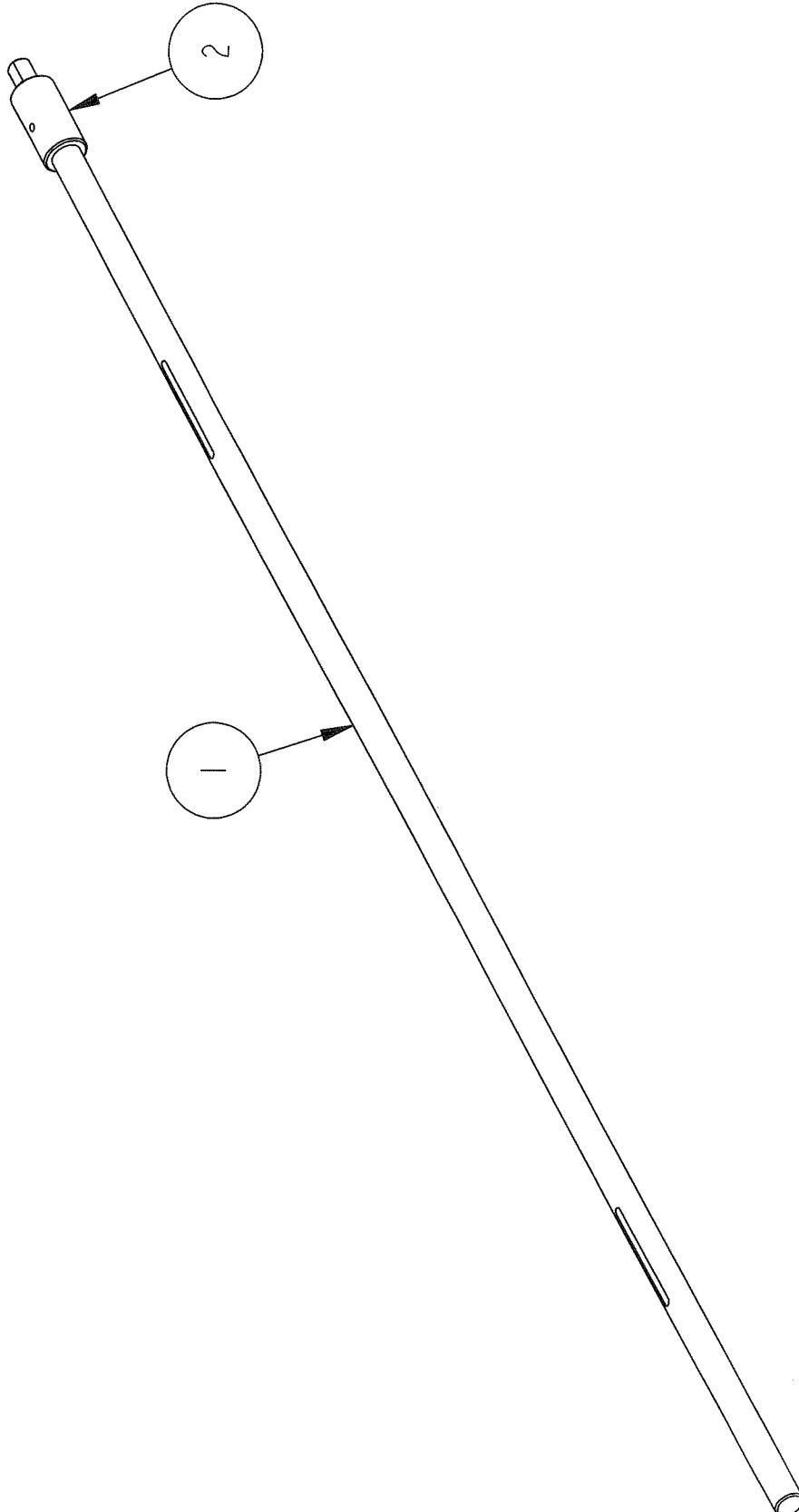
DO NOT USE.

ITEM NO.	PART #	DESCRIPTION	REV NO.	DATE	ECN NO.	BY
1	102112	KNOB				
2	102140	HANDLE, RELEASE 1/4-20 X 1.0				
3	2 102401	GEAR, 1616 .5008 .125K				
4	2 103803	BEARING, HUB .500				
5	1 543969-01	RULE, FLAT SIDEGUIDE PLACEMENT				
6	2 545640-02	PLATE, BELT ADJUST SHAFT MOUNT				
7	2 545640-03	PLATE, BELT ADJUST SHAFT MOUNT				
8	1 545634-01	PLATE, BACK SIDE GUIDE SIDE				
9	1 545634-02	PLATE, BACK SIDE GUIDE SIDE				
10	2 545741-01	SPACER, FRAME				
11	1 545742-01	PLATE, SIDEGUIDE ADJUST CLAMP				
12	1 547215-01	ASSY, SIDEGUIDE ADJUST SHAFT				



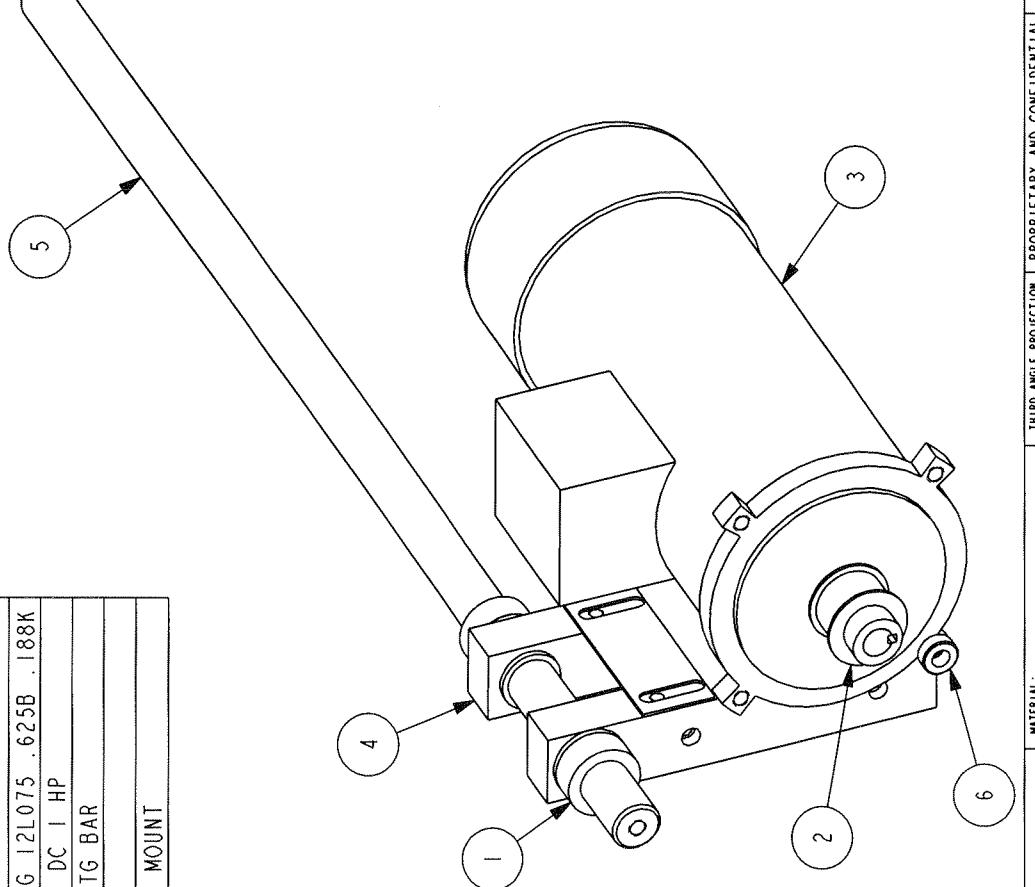
1	950	RE-D	WHERE USED
A KEY	SCALE 0 .438	DIMENSIONS IN INCHES UNLESS OTHERWISE SPECIFIED	MANUFACTURER N/A
CHECKED BY:	DATE 01 - Mar - 05	IN MM. .000 .000 .000 .000 .000 .000	WEIGHT: N/A
TRACED BY:	MASTER	TELETYPE: N/A ALL DIMENSIONS ARE FINISHED DIMENSIONS NO SCALE, WORK TO DIMENSIONS ONLY	TIME: N/A SHEET NO. 1 OF 1
			DRAWING #: 545653-01

ITEM	QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	1	545661-01	SHAFT, SIDE GUIDE ADJUST					
2	1	545698-02	SHAFT, ARM LOCK					



1	950			
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. <small>KENNESAW, GA 30144 USA</small>				
THIRD ANGLE PROJECTION				
MATERIAL:	N/A			
DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED				
.XX	.XXX	ANG.		
.01	.005	.5		
HEAT TREAT:	N/A			
<small>REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED</small>				
<small>ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY</small>				
DATE:	01 - Mar - 05	MODEL: 950	TITLE: ASSY, SIDE GUIDE ADJUST SHAFT	
CHECKED BY:		SHEET NO. 1 OF 1	DRAWING # 547215-01	
TRACED BY:	MASTER			

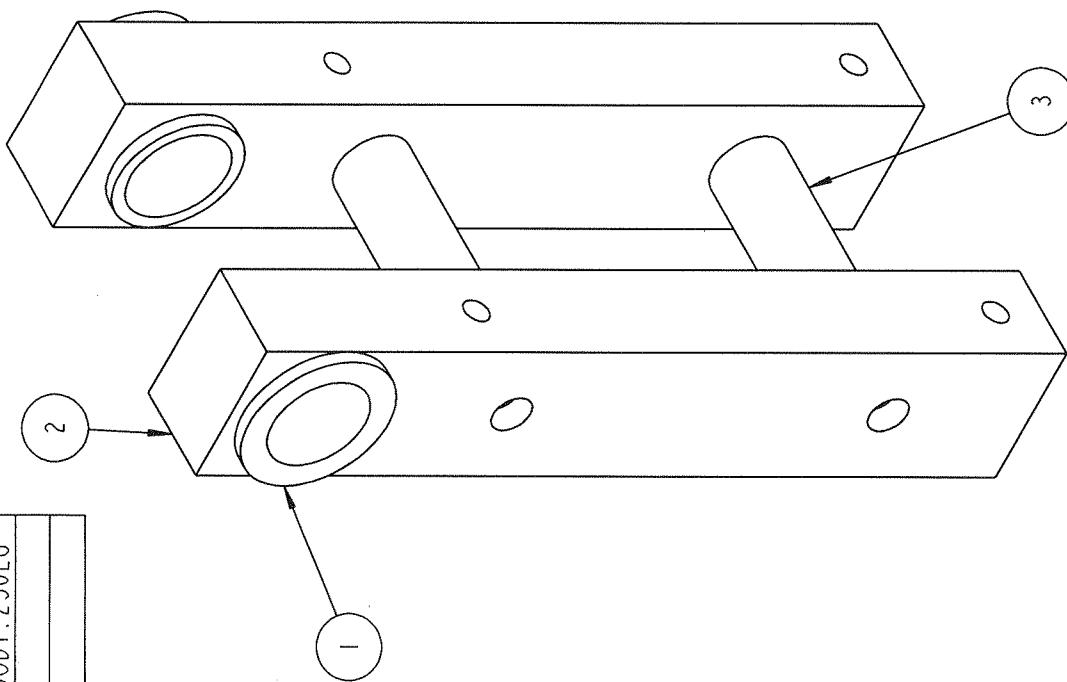
ITEM QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1 2	102217	COLLAR 1.000					
2 1	108809	PULLEY, TIMING 12L075 .625B .188K					
3 1	200151-2	MOTOR, LEESON DC 1 HP					
4 1	530654-03	ASSY, MOTOR MTG BAR					
5 1	545746-01	SPACER, FRAME					
6 1	545747-01	SPACER, MOTOR MOUNT					



DRAWN BY:	SCALE	0 .300	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED			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, GEORGIA	
A KEY			.XX	.XXX	AMG.	THIRD ANGLE PROJECTION	KIRK-RUDY, INC. WOODSTOCK, GEORGIA
CHECKED BY:	DATE	01 - MAR - 05	.01	.005	.5	MODEL:	950
			REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED			TITLE:	ASSY, MOTOR MOUNT
TRACED BY:	MASTER		ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE. WORK TO DIMENSIONS ONLY			SHEET NO.:	OF 1
						DRAWING #	538022-06

ITEM QTY	PART #	DESCRIPTION
1	2	100331 BUSHING, FLI. 0001DI.2500DI.250LG
2	2	530510-03 BAR, MOTOR MOUNT PIVOT
3	2	530511-01 SPACER, 3/4OD X 2L

REV NO	DATE	DESCRIPTION	ECN NO	BY
1	950			



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	REQ'D WHERE USED
A KE Y	0 . 625	.XX .XXX .065 .5	N / A	- - -	KIRK - RUDY, INC. KENNESAW, GEORGIA	
CHECDED BY:	DATE		HEAT TREAT:			
	09 - JU 1 - 04		N / A			
TRACED BY:	MASTER		FINISH:			
			N / A			
				SHEET NO. 10F1	DRAWING 1	
						530654-03

ITEM NO.	PART #	DESCRIPTION	REV. NO.	DATE	DESCRIPTION	REV. NO.
1	2	103804 BEARING, HUB 625				
2	2	109141 BELT, HD 20008M20				
3	2	109132 PULLEY, TIMING 238M20 .625B .88KEY				
4	1	191294 CYLINDER, AIR 1.25 D 10IN STROKE				
5	1	191339 FITTING, 1/8 NPT 1/4 TUBE ELBOW SP				
6	1	191395 FITTING, FLOW CONTROL METER OUT				
7	2	543981-01 PLATE, FINGER MOUNT				
8	1	543982-01 PLATE, FINGER MOUNT END				
9	1	543983-01 PLATE, FINGER SHAFT MOUNT				
10	2	543984-01 SHAFT, FINGER SLIDE				
11	1	543985-01 ASSY, INFEED FINGER				
12	1	543986-01 ASSY, OUTFEED FINGER				
13	1	545624-01 SHAFT, FINGER DRIVE				
14	2	545625-01 ASSY, BELT TAKEUP				
15	2	545628-01 PLATE, AIR CYLINDER MOUNT				
16	1	547213-01 ASSY, FINGER VALVE				

1	950	REV-D WHERE USED
KIRK - RUDY, INC		
WOODSTOCK, GEORGIA		
KR PRODUCT CATCH FINGER		
REVISION #:	ASSY, PRODUCT CATCH FINGER	
SCALE:	0 .250	
SHEET #:	06	
DIMENSIONS ON THIS DRAWING ARE IN INCHES		
ALL DIMENSIONS ARE IN INCHES DO NOT SCALE: WORK TO DIMENSIONS ONLY		
PRINTED BY:	MASTER	950
TRACED BY:		N/A
REVIEWED BY:		N/A
APPROVED BY:		N/A
THIS DRAWING IS THE PROPERTY OF KIRK - RUDY, INC. IT MAY NOT BE COPIED OR REPRODUCED EXCEPT AS AUTHORIZED IN THE AGREEMENT FOR THE PURCHASE OF THIS DRAWING. NO PARTS OF THIS DRAWING MAY BE REPRODUCED, COPIED, OR USED WITHOUT THE WRITTEN CONSENT OF KIRK - RUDY, INC. WOODSTOCK, GA 30083 USA		

ITEM QTY	PART #	DESCRIPTION	REV NO.	DATE	ECN NO.	BT
1	4	BUSHING .625ID 1.125OD				
2	8	WASHER, FLAT 1/4ID				
3	8	SCREW, SHCS 1/4-20X .375				
4	16	SCREW, SHCS 1/4-20X .625				
5	8	SCREW, FLATHEAD 10-32X .500				
6	4	543981-01 BLOCK, FINGER SLIDE				
7	1	543988-01 PLATE, INFEED FINGER MOUNT				
8	10	543989-01 ASSY, PRODUCT CATCH FINGER				
9	2	545623-01 BAR, FINGER SLIDE MOUNT				
10	2	545630-01 PLATE, FINGER BELT CLAMP				
11	2	545631-01 PLATE, FINGER BELT CLAMP				
12	2	545735-01 BRACKET, FINGER MOUNT BAR				
13	1	545737-02 BRACKET, PROX TRIGGER				
14	2	CSD0236 SCREW, SHCS 8-32X .250				

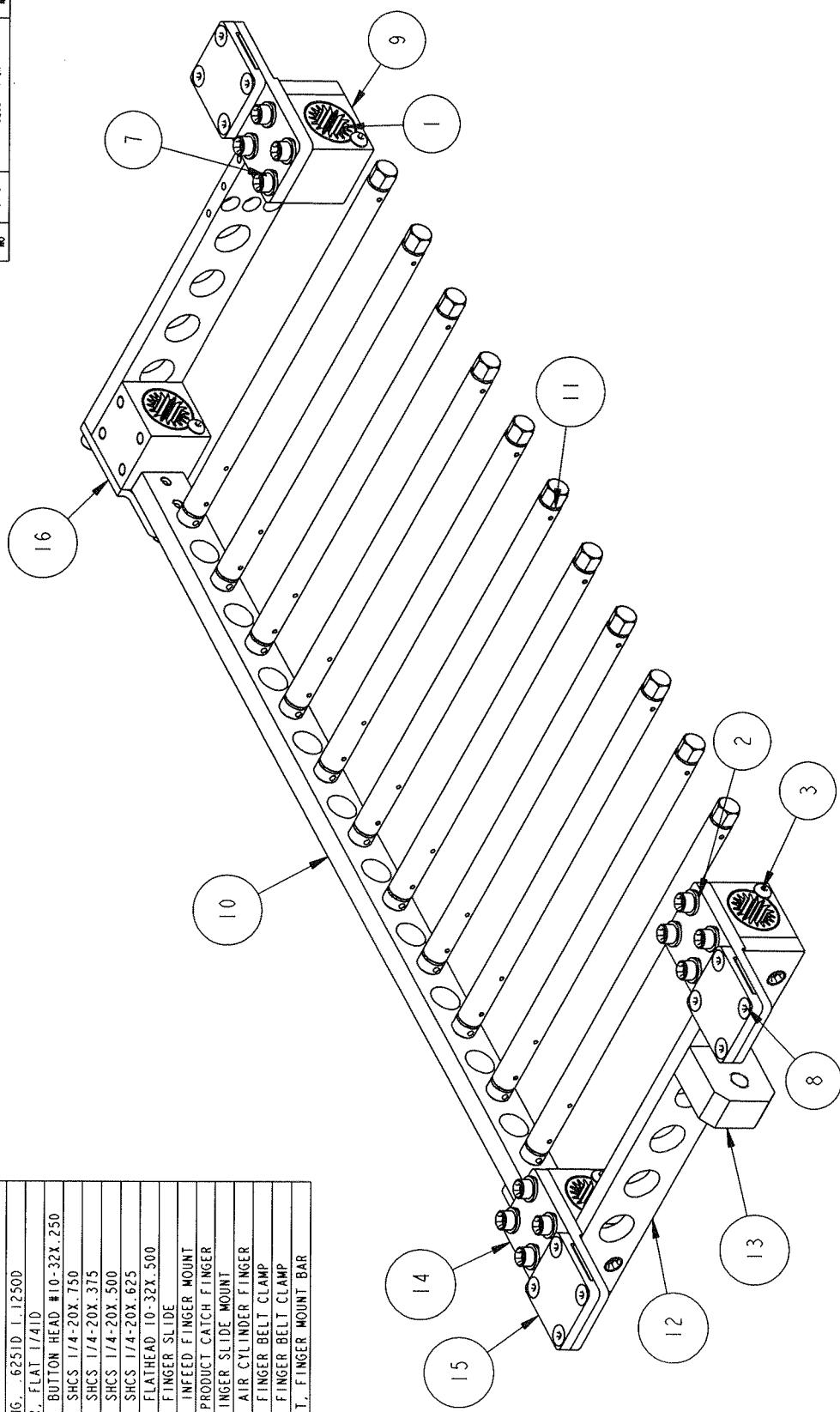
REVISIONS: 1 543985-01

RED D WHERE USED

DRAWING BY:		DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED		PROPRIETARY AND CONFIDENTIAL	
		INCHES		NO REPRODUCTION OR DISSEMINATION OF THIS DRAWING IS AUTHORIZED	
		MM		EXCEPT AS EXPRESSLY APPROVED IN WRITING BY THE CONTRACTOR	
		.000		THE INFORMATION CONTAINED HEREIN IS UNCLASSIFIED	
		.005		DATE 10/10/00 BY 30088 USA	
		.010		TIME 10:00	
CHECKED BY:		REPROD. ALL FIGURES AND		ASSY, INFEED FINGER	
		SPECIFICATIONS WHICH		DRAWING NO. 543985-01	
MADE BY:		ALL DIMENSIONS ARE		DATE 10/10/00	
MASTER		INCHES		TIME 10:00	
		NO. 0.500		TO INFEED ONLY	
A KEY		SCALE		REVISIONS: 1 543985-01	

KRK - RUDY INC.
KR WOODSTOCK, GEORGIA

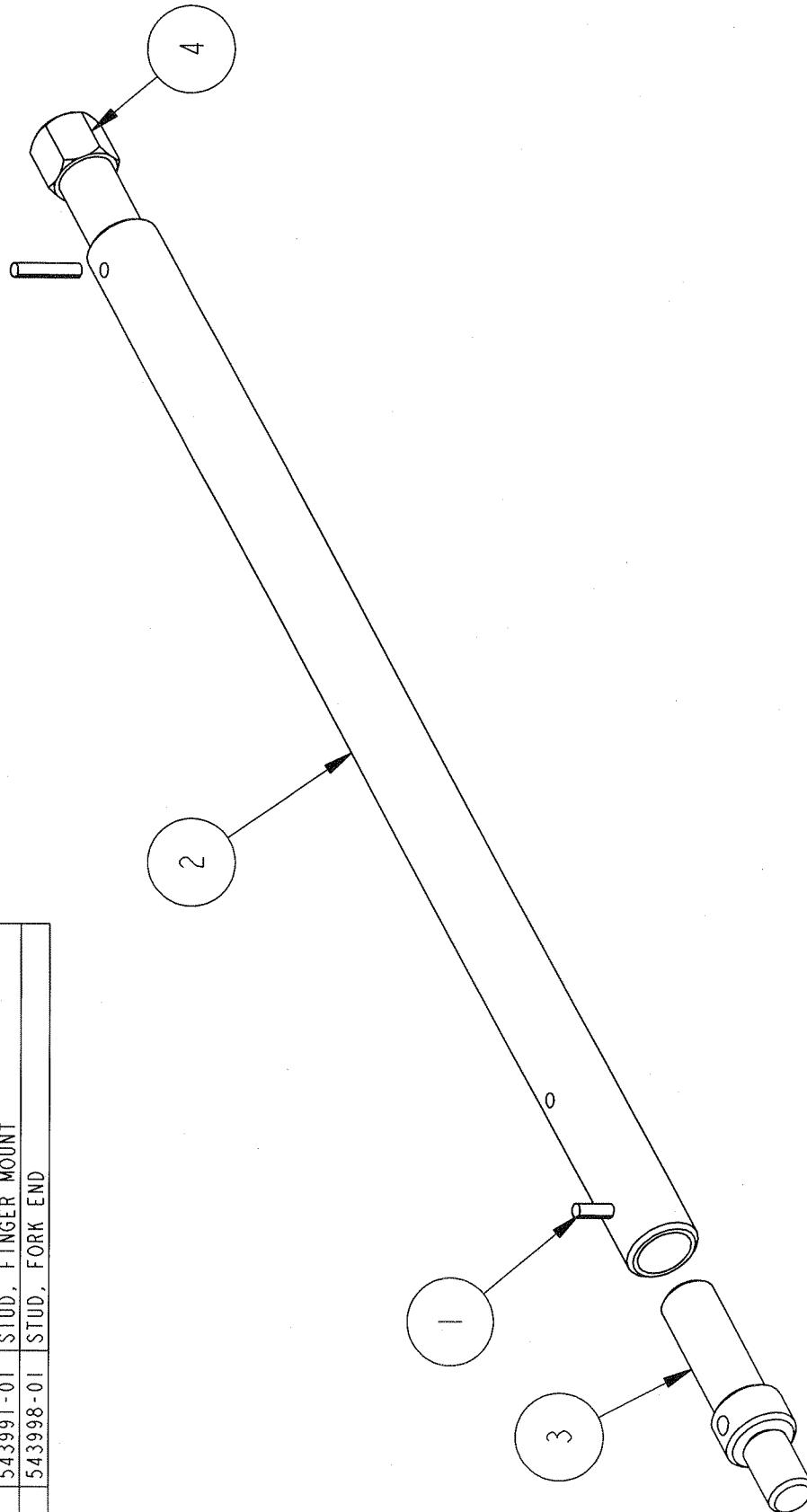
ITEM NO.	PART #	DESCRIPTION	KEY NO.	DATE	DESCRIPTION	LOC NO.	BY
1	4	BUSHING .625ID 1.125OD					
2	12	WASHER, FLAT 1/4ID					
3	6	SCREW, BUTTON HEAD #10-32X .250					
4	4	SCREW, SHCS 1/4-20X .750					
5	8	SCREW, SHCS 1/4-20X .375					
6	3	SCREW, SHCS 1/4-20X .500					
7	16	SCREW, SHCS 1/4-20X .625					
8	12	SCREW, FLATHEAD 10-32X .500					
9	4	543987-01 BLOCK, FINGER SLIDE					
10	1	543988-02 PLATE, INFEED FINGER MOUNT					
11	11	543989-01 ASSY, PRODUCT CATCH FINGER					
12	2	545623-01 BAR, FINGER SLIDE MOUNT					
13	1	545629-01 BLOCK, AIR CYLINDER FINGER					
14	3	545630-01 PLATE, FINGER BELT CLAMP					
15	3	545631-01 PLATE, FINGER BELT CLAMP					
16	2	545735-01 BRACKET, FINGER MOUNT BAR					



1	950	RED O WHERE USED
KR	KIRK - RUDY, INC.	
	WOODSTOCK, GEORGIA	
	ASSY, OUTFEED FINGER	
543986-01		

DRAWING #: A KEY		SCALE 0 .500		DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED		FINISH AND CONVENTIONAL		THESE ANGLES PROJECTION	
DATE	31 - Jan - 06	IN	MM	IN	MM	IN	MM	IN	MM
REMOVED				RIGHT	ALL BURRS AND OTHER DEFECTS			TOP	ALL BURRS AND OTHER DEFECTS
ALL DIMENSIONS ARE				INCHES	INCHES	INCHES	INCHES	INCHES	INCHES
IN THE DRAWINGS				DO NOT SCALE - WORK	TO DIMENSIONS ONLY				
MADE BY:	MASTER			N/A	N/A			OF 2	

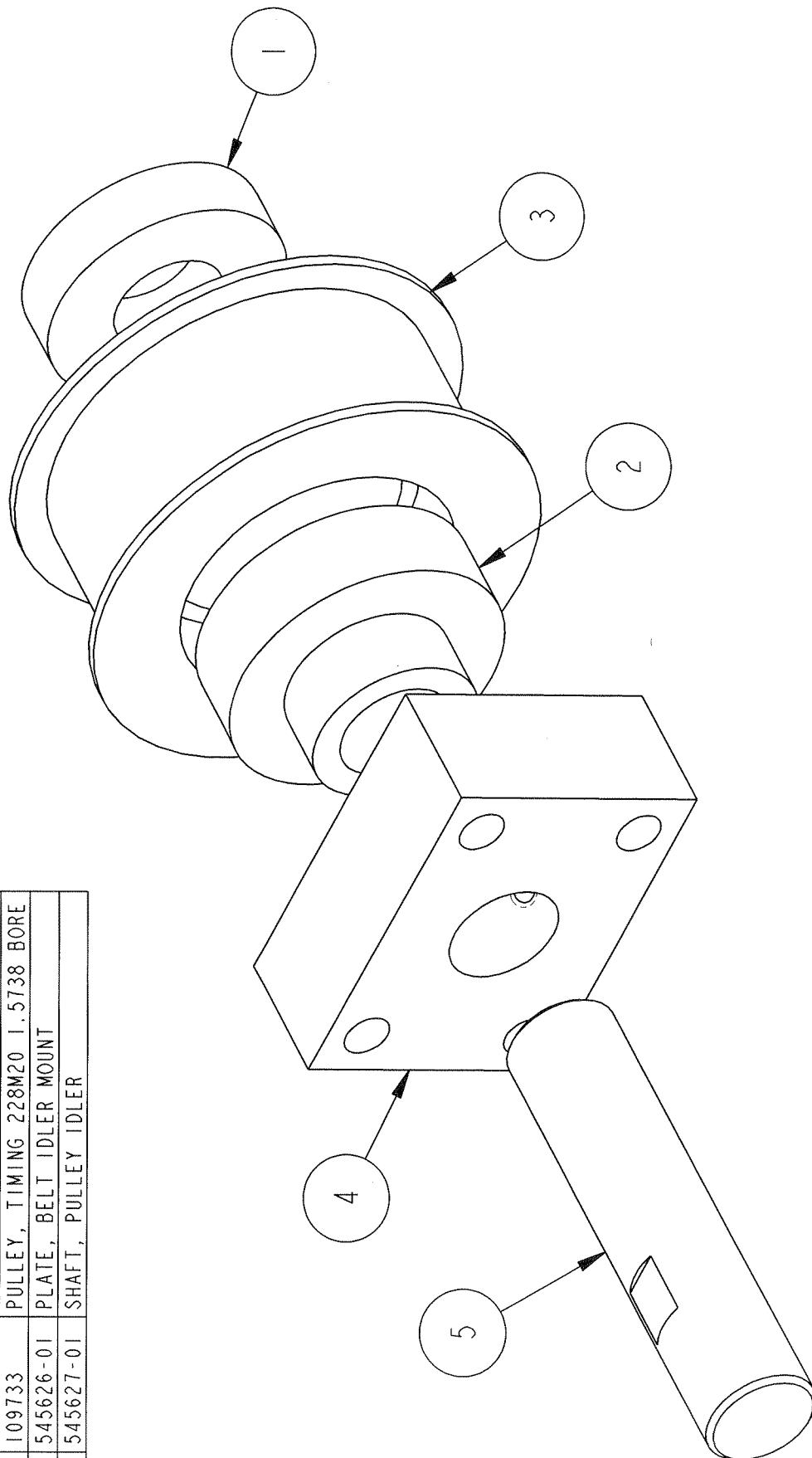
ITEM	QTY	PART #	DESCRIPTION
1	2	105221	PIN, ROLL .094X.500
2	1	543990-01	FINGER, PRODUCT CATCH
3	1	543991-01	STUD, FINGER MOUNT
4	1	543998-01	STUD, FORK END



ITEM	REV NO	DATE	DESCRIPTION	ECN NO	BY

21	950	
REF'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		
ASSY, PRODUCT CATCH FINGER	950	TITLE:
DRAWING #	OF 1	SHEET NO:
A KEY	SCALE .000	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED
03-AUG-05	DATE	.XX .XXX ANG. .01 .005 .5
MASTER	TRACED BY:	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY

ITEM	QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	1	103110	BEARING, FLAT .625					
2	1	103804	BEARING, HUB .625					
3	1	109733	PULLEY, TIMING 228M20 1.5738 BORE					
4	1	545626-01	PLATE, BELT IDLER MOUNT					
5	1	545627-01	SHAFT, PULLEY IDLER					

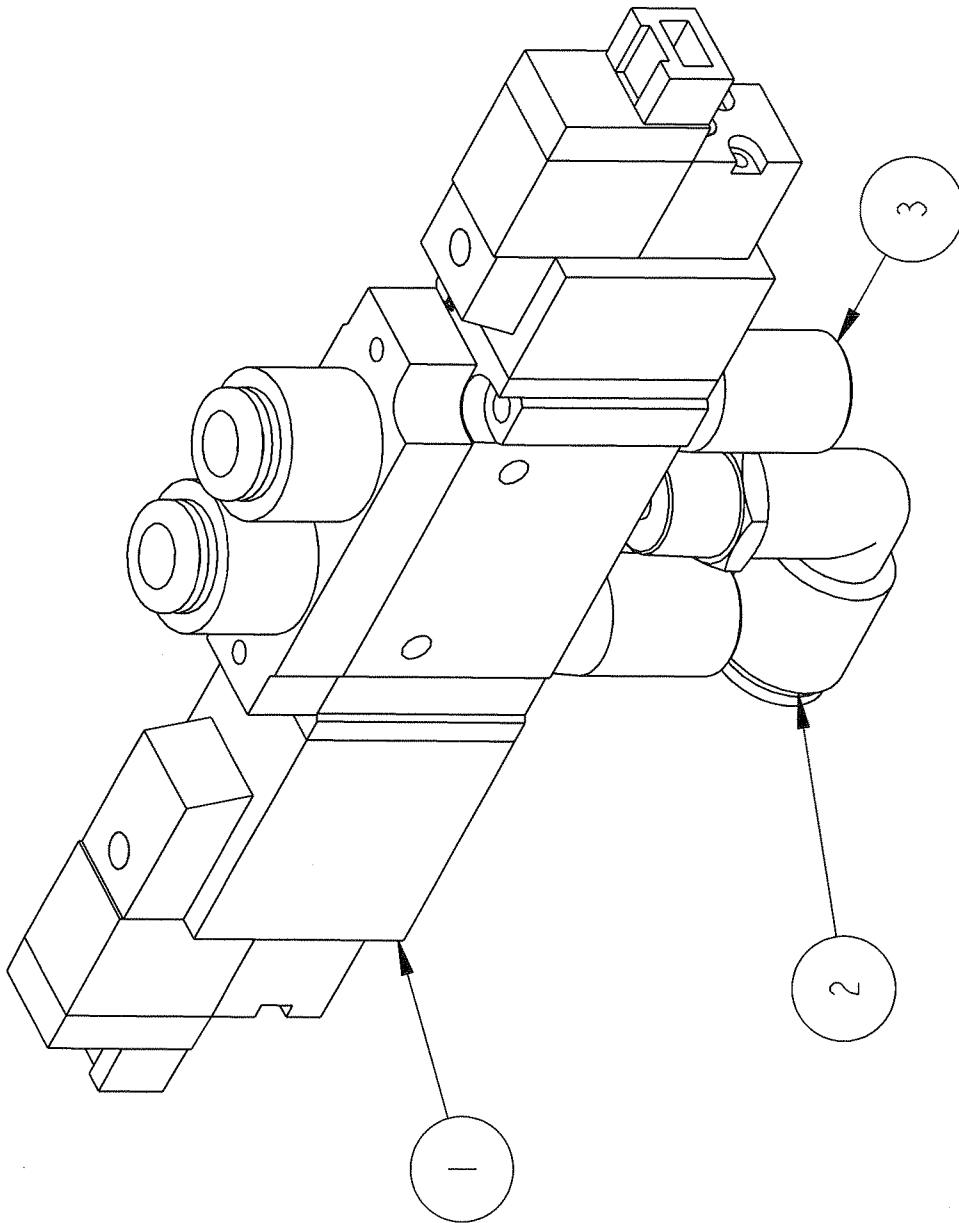


REF'D	WHERE USED
2	950
KR	KIRK - RUDY, INC. KENNESAW, GEORGIA
ASSY,	BELT TAKEUP
DRAWN BY: A KEY	SCALE: 1 .250
CHECKED BY:	DATE: 09-JUL-04
TRACED BY:	MASTER
MATERIAL: N/A	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED .005 .005 .01 .005 .005 .005 .005 .005 .005
FINISH: N/A	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY
SHEET NO: 1 OF 1	TITLE: MODEL: 950 DRAWING #: 545625-01

ITEM	QTY	PART #	DESCRIPTION
1	1	191309	VALVE, 5 WAY CENTER CLOSED
2	1	191337	FITTING, ELBOW 1/8 NPT 1/4 TUBE
3	2	191340	MUFFLER, 1/8 NPT AIR

REV NO	DATE	DESCRIPTION	ECN NO	BY

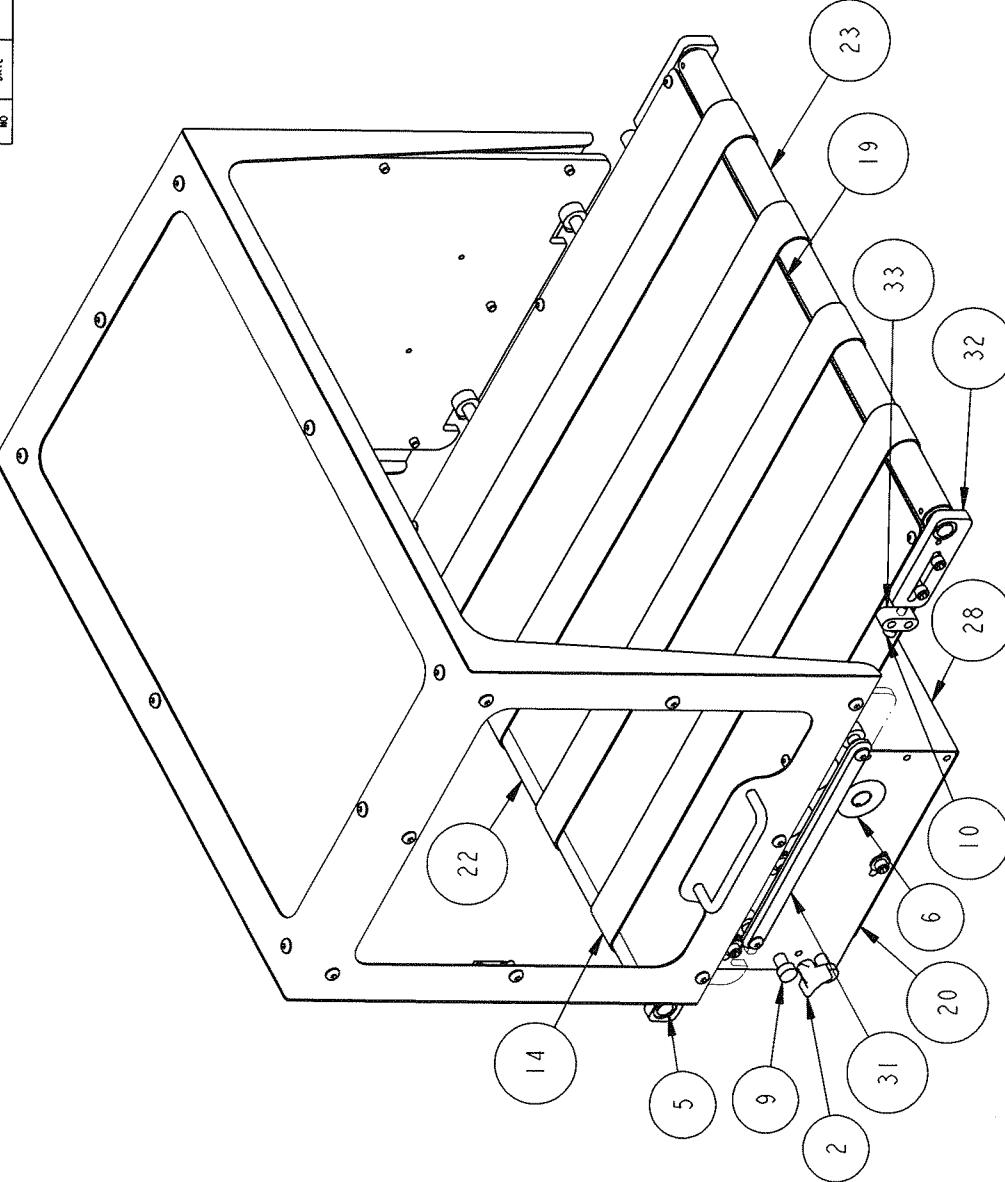
REV D	WHERE USED
I	XXX



DRAWN BY: A KEY	SCALE 1 . 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: 01 - Mar - 05	DATE 01 - Mar - 05	.xx .005 ANG. .5	HEAT TREAT: N/A	MODEL: 950	TITLE: ASSY, FINGER VALVE
TRACED BY: MASTER	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. 10 OF 1	DRAWING #
					547213-01

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

1	3	100401	WASHER, THRUST TB10					
2	2	102119	KNOB					
3	4	102200	COLLAR .375					
4	16	102201	COLLAR .625					
5	4	103405	CAM FOLLOWER					
6	6	103804	BEARING HUB 625					
7	8	106811	SCREW, BUTTON HEAD #10-32X .250					
8	4	106815	SCREW, BUTTON HEAD #4X .625					
9	4	107206	BOLT, SHOULDER 3/8X1/2					
10	2	107407	SCREW, SHCS 1/4-20X1.000					
11	7	107411	SCREW, SHCS 1/4-20X .875					
12	1	108871	PULLEY, TIMING 14L075 .7506 .88K					
13	1	109968	PULLEY, TIMING 14L075 .6258 .88K					
14	4	111871	BELT, FLAT 52.000 X 1.5					
15	1	108314-17	BELT, TIMING 124L075					
16	1	200169-3	MOTOR, BODINE 4179					
17	1	200513-5	GROMMET, RUBBER .75IDX.375OD.56TH					
18	1	545636-02	ASSY, CONVEYOR DRIVE ROLLER					
19	1	545155-01	TABLETOP, OUTFEED CONVEYOR					
20	1	545156-01	PLATE, OUTFEED CONVEYOR					
21	1	545156-02	PLATE, OUTFEED CONVEYOR					
22	1	545157-01	ROLLER, FLAT BELT					
23	1	545157-02	ROLLER, FLAT BELT					
24	2	545159-01	ROLLER, FLAT BELT					
25	1	545160-01	SHAFT, FLAT BELT DRIVE					
26	3	545161-01	SHAFT, MOTOR MOUNT SPACER					
27	3	545162-01	SHAFT, CONVEYOR SPACER					
28	1	545163-01	COVER, CONVEYOR BOTTOM					
29	1	545186-02	ASSY, OUTFEED CONVEYOR COVER					
30	4	545187-01	SPACER, COVER MOUNT					
31	2	545188-01	HANDLE, COVER MOUNT					
32	2	547457-01	PLATE, OUTFEED ROLLER TAKEUP					
33	2	547458-01	BLOCK, OUTFEED TAKEUP					



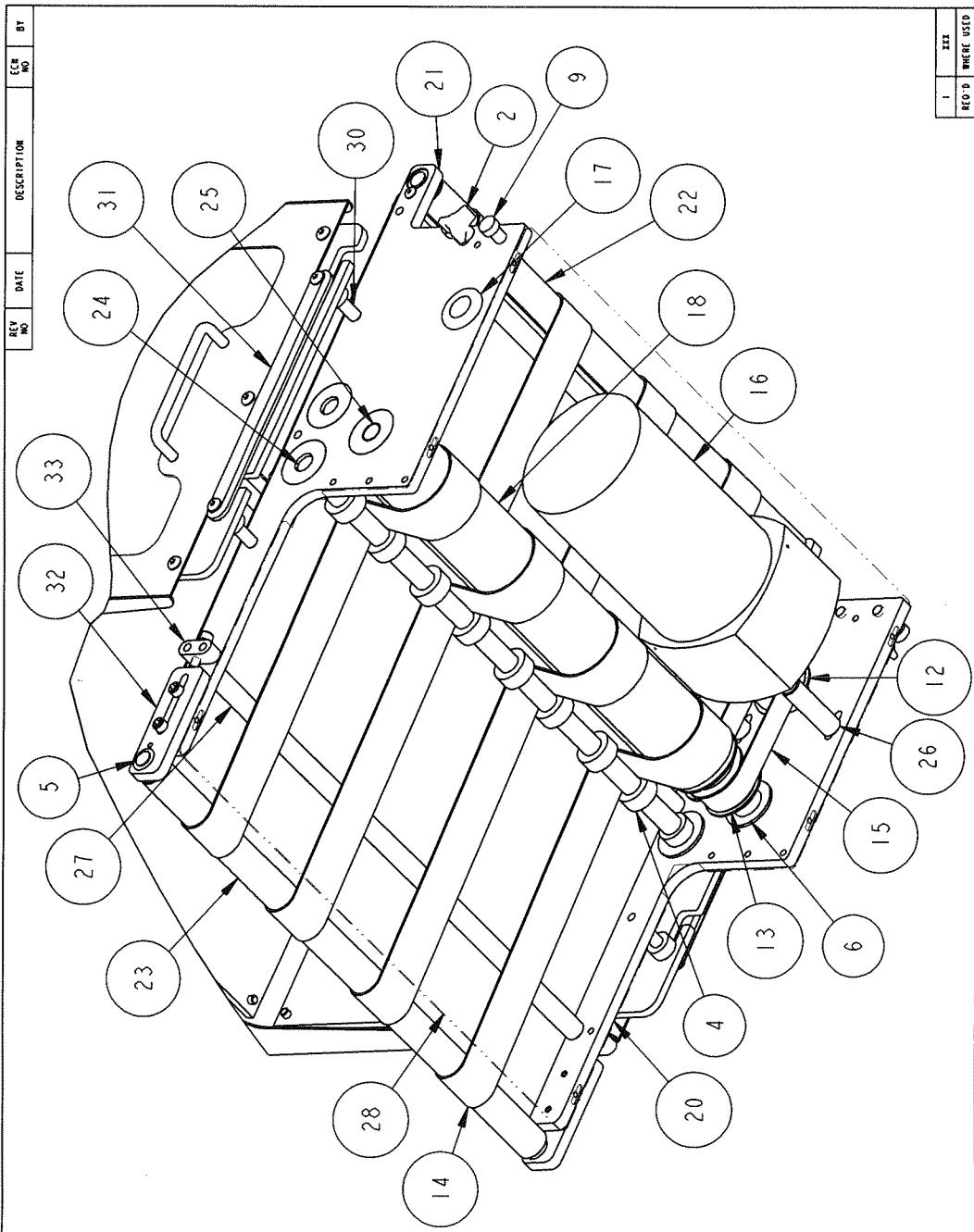
1	KEY	SCALE	0 .28	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED			N/A	
CHECKED BY:		DATE	09 - JULY - 04	REMOVED ALL BURRS AND SHARP EDGES UNLESS SPECIFIED	WEAR TOLERANCE:	N/A	REMOVED ALL BURRS AND SHARP EDGES UNLESS SPECIFIED	
TRADED BY:		MASTER		ALL PARTS TO BE FLUSH WITH SURFACES DO NOT SCALE WORK TO DIMENSIONS ONLY	FINISH:	N/A	ALL PARTS TO BE FLUSH WITH SURFACES DO NOT SCALE WORK TO DIMENSIONS ONLY	

1 XXX
REG'D WHERE USED

KRK KIRK-RUDY, INC.
WOODSTOCK, GEORGIA

DRAWING # 545754-01

ITEM #	CITY	PART #	DESCRIPTION
1	3	100401	WASHER, THRUST TB410
2	2	102119	KNOB
3	4	102200	COLLAR .375
4	16	102201	COLLAR .625
5	4	103405	CAM FOLLOWER
6	6	103804	BEARING, HUB 625
7	8	106811	SCREW, BUTTON HEAD #10-32X.250
8	4	106815	SCREW, BUTTON HEAD 1/4X.625
9	4	107206	BOLT, SHOULDER 3.8X1/2
10	2	107407	SCREW, SHCS 1/4-20X1.000
11	7	107411	SCREW, SHCS 1/4-20X.875
12	1	108871	PULLEY, TIMING 14L015 .750B .888K
13	1	109968	PULLEY, TIMING 14L015 .625B .888K
14	4	111871	BELT, FLAT 52.000 X 1.5
15	1	108314-17	BELT, TIMING 124C075
16	1	200169-3	MOTOR, BODINE 4179
17	1	200513-5	GROMMET, RUBBER .751DX.375OD.56TH
18	1	5453636-02	ASSY, CONVEYOR DRIVE ROLLER
19	1	545155-01	TABLETOP, OUTFEED CONVEYOR
20	1	545756-01	PLATE, OUTFEED CONVEYOR
21	1	545756-02	PLATE, OUTFEED CONVEYOR
22	1	545757-01	ROLLER, FLAT BELT
23	1	545757-02	ROLLER, FLAT BELT
24	2	545759-01	ROLLER, FLAT BELT
25	1	545760-01	SHAFT, FLAT BELT DRIVE
26	3	54576-01	SHAFT, MOTOR MOUNT SPACER
27	3	545762-01	SHAFT, CONVEYOR SPACER
28	1	545763-01	COVER, CONVEYOR BOTTOM
29	1	545785-02	ASSY, OUTFEED CONVEYOR COVER
30	4	545787-01	SPACER, COVER MOUNT
31	2	545788-01	HANDLE, COVER MOUNT
32	2	547457-01	PLATE, OUTFEED ROLLER TAKEUP
33	2	547458-01	BLOCK, OUTFEED TAKEUP



PRINTING :		SCALE	KEY	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED			PRINTING AND CONFIDENTIAL INFORMATION CONTAINED HEREIN ARE THE PROPERTY OF KIRK-RUDY, INC. AND ARE PROVIDED IN RESPONSE TO A REQUEST FOR INFORMATION FROM THE U.S. GOVERNMENT. THE INFORMATION CONTAINED HEREIN IS UNCLASSIFIED DATE 10/18/08 BY 1088 USA			PRINTING :	SCALE	KEY	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED			PRINTING :	SCALE	KEY	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED			PRINTING AND CONFIDENTIAL INFORMATION CONTAINED HEREIN ARE THE PROPERTY OF KIRK-RUDY, INC. AND ARE PROVIDED IN RESPONSE TO A REQUEST FOR INFORMATION FROM THE U.S. GOVERNMENT. THE INFORMATION CONTAINED HEREIN IS UNCLASSIFIED DATE 10/18/08 BY 1088 USA
PRINTING #:	DATE:	09- JUL - 04	KEY:	.000	.000	.000	PRINTING #:	DATE:	950	KEY:	.000	.000	.000	PRINTING #:	DATE:	20F6	KEY:					
CHECKED BY:	NAME:		REMOVED ALL BURRS AND OTHER SURFACE IRREGULARITIES TO FINISHED DIMENSIONS.	ALL DIMENSIONS ARE FINISHED DIMENSIONS NO SCALE WORK TO DIMENSIONS ONLY			PRINTED BY:	NAME:		PRINTED BY:	NAME:			PRINTED BY:	NAME:							
TRACED BY:	NAME:						PRINTED BY:	NAME:		PRINTED BY:	NAME:			PRINTED BY:	NAME:							

PRINTING # : 545754-01

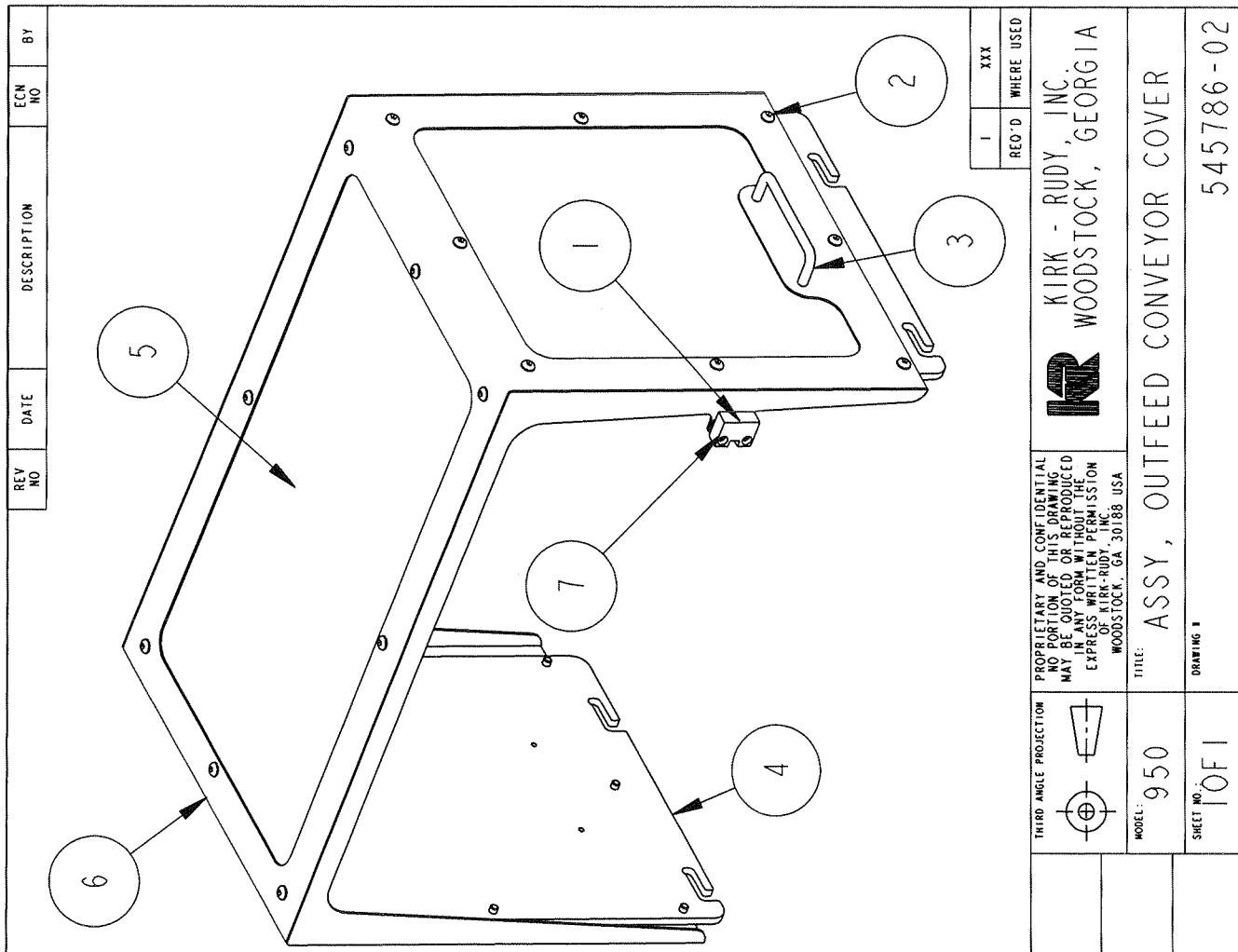
ITEM	QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	2	500330-4	HUB, ROLLER					
2	1	545635-02	ROLLER, BELT IDLER					

SCALE 0.375

1	950
REQ'D	WHERE USED

DRAWN BY: A KEY		SCALE 0 . 375	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED		MATERIAL: NOTED	THIRD ANGLE PROJECTION	PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE COPIED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC. KENNESAW, GA 30144 USA	
			.xx	.xxx	ANG.			
CHECKED BY:		DATE 23-JUL-98	.01	.005	.5	HEAT TREAT:		
TRACED BY:		MASTER	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED			NONE		
			ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY			FINISH:		
						NOTED	SHEET NO. 1 OF 1	DRAWING #
							545636-02	

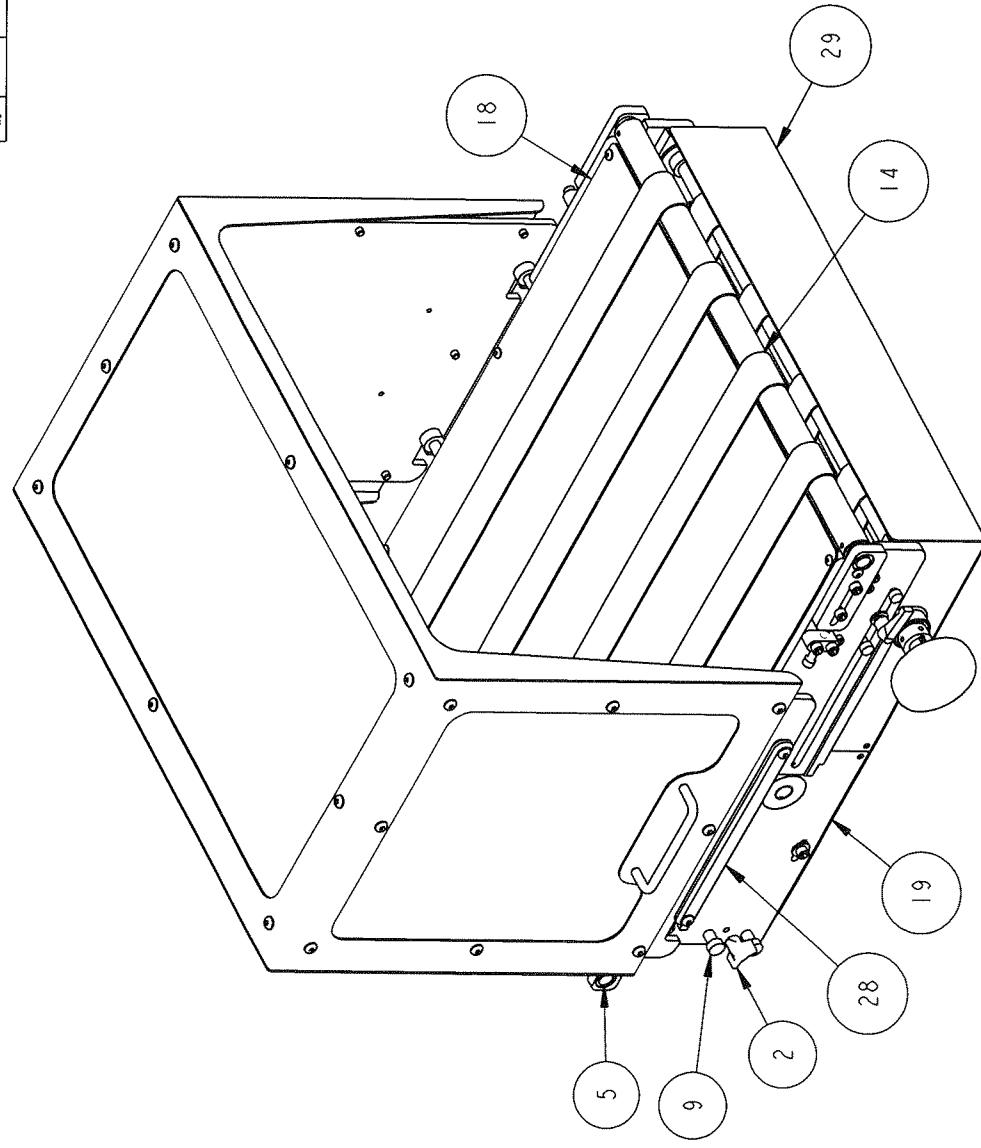
ITEM QTY	PART #	DESCRIPTION
1	6 100603	WASHER, FLAT 1/4ID
2	24 106818	SCREW, BUTTON HEAD 1/4X.500
3	2 190955	HANDLE
4	2 545784-02	FRAME, OUTFEED CONVEYOR COVER
5	1 545785-03	COVER, OUTFEED CONV. TOP
6	1 547531-01	WLDMNT, OUTFEED CONV. COVER
7	1	MAGNET SENSOR, MAGNET RECEIVER



ITEM QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	6 100603	WASHER, FLAT 1/4ID					
2	24 106818	SCREW, BUTTON HEAD 1/4X.500					
3	2 190955	HANDLE					
4	2 545784-02	FRAME, OUTFEED CONVEYOR COVER					
5	1 545785-03	COVER, OUTFEED CONV. TOP					
6	1 547531-01	WLDMNT, OUTFEED CONV. COVER					
7	1	MAGNET SENSOR, MAGNET RECEIVER					

DRAWN BY:	KEY	SCALE:	0 . 200	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-Feb-05	.01 .005 .5 XX XXX ANG.	HEAT TREAT:	KIRK-RUDY - INC. WOODSTOCK, GEORGIA	
TRACED BY:	MASTER			REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED	MODEL: 950	SHEET NO: 10 OF 1	TITLE: ASSY, OUTFEED CONVEYOR COVER
				ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY	DRAWING #		545786-02

ITEM QTY	PART #	DESCRIPTION	REF NO	DATE	DESCRIPTION	REF NO	DATE
1	3	100401 WASHER, THRUST TB110					
2	2	102119 KNOB					
3	4	102200 COLLAR .375					
4	8	102218 COLLAR .625					
5	2	103405 CAM FOLLOWER					
6	6	103804 BEARING HUB 625					
7	8	106811 SCREW, BUTTON HEAD 10-32X .250					
8	4	106815 SCREW, BUTTON HEAD 1/4X .625					
9	4	107206 BOLT, SHOULDER 3/8X 1/2					
10	3	107411 SCREW, SHCS 1/4-20X .875					
11	1	108811 PULLEY, TIMING 14.075 .750B .188K					
12	1	109968 PULLEY, TIMING 14.075 .625B .188K					
13	1	108914-20 BELT, TIMING 124.075					
14	4	111895-1 BELT, FLAT 70.750 X 1.500					
15	1	200169-3 MOTOR, BODINE 4179					
16	1	200513-5 GROMMET, RUBBER .75IDX .375ODX .56TH					
17	1	545636-02 ASSY, CONVEYOR DRIVE ROLLER					
18	1	545155-01 TABLETOP, OUTFEED CONVEYOR					
19	1	545156-01 PLATE, OUTFEED CONVEYOR					
20	1	545156-02 PLATE, OUTFEED CONVEYOR					
21	1	545157-01 ROLLER, FLAT BELT					
22	2	545159-01 ROLLER, FLAT BELT					
23	1	545160-01 SHAFT, CONVEYOR SPACER					
24	3	545161-01 SHAFT, MOTOR MOUNT SPACER					
25	2	545162-01 SHAFT, CONVEYOR SPACER					
26	1	545186-02 ASSY, OUTFEED CONVEYOR COVER					
27	4	545187-01 SPACER, COVER MOUNT					
28	2	545188-01 HANDLE, COVER MOUNT					
29	1	547519-01 ASSY, OUTFEED BELT ADJUST					



ITEM #	KEY	SCALE	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	MATERIAL:	FINISH:	WEIGHT:	QUANTITY:	DRAWING REFERENCE:
CHECKED BY:		0.250	.000 .000	N/A				
MAKER:	08 - Feb - 05							
INSPECTOR:								
REVISIONS:								
PRINTED BY:								
DATE:								

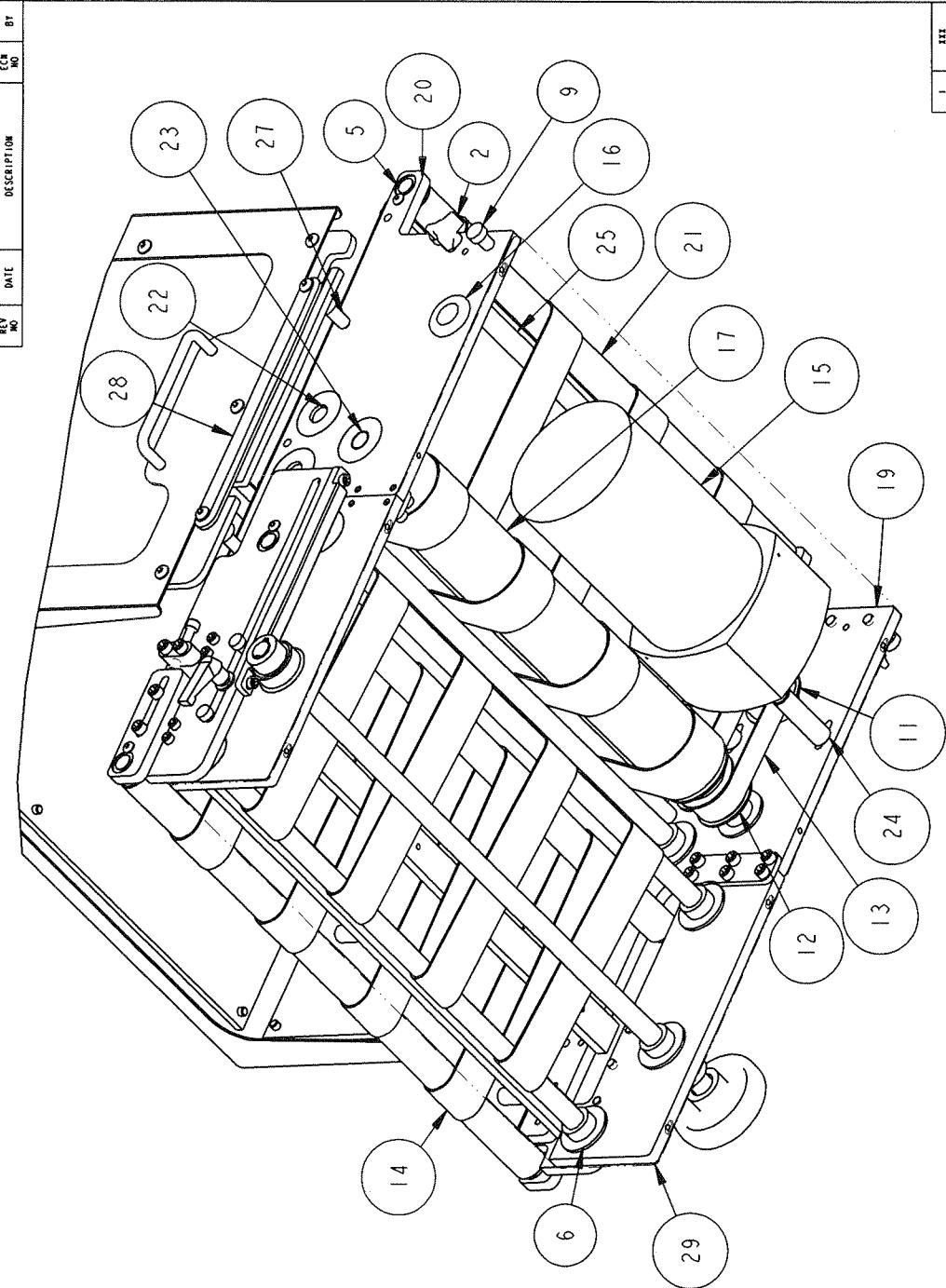
KIRK - RUDY, INC.
WOODSTOCK, GEORGIA

PRINTED IN U.S.A.
MAY 1986
WOODSTOCK, GA 30188 U.S.A.

950 ASSY, ADJUSTABLE OUTFEED CONVEYOR

545754-02

ITEM #	COUNT	PART #	DESCRIPTION
1	3	100401	WASHER, THRUST 1B410
2	2	102119	KNOB
3	4	102200	COLLAR .375
4	8	102218	COLLAR .625
5	2	103405	CAM FOLLOWER
6	6	103804	BEARING, HUB .625
7	8	105811	SCREW, BUTTON HEAD #10-32X.250
8	4	105815	SCREW, BUTTON HEAD 1/4X.625
9	4	107206	BOLT, SHOULDER 3.8X1/2
10	3	107411	SCREW, SHCS 1/4-20X.875
11	1	108871	PULLEY, TIMING 14L015 .750B .188K
12	1	109968	PULLEY, TIMING 14L015 .625B .188K
13	1	108914-20	BELT, TIMING 124L075
14	4	111895-1	BELT, FLAT 70 750 X 1 .500
15	1	200169-3	MOTOR, BODINE 4179
16	1	200513-5	GROMMET, RUBBER .75IDX.375ODX.56TH
17	1	545636-02	ASSY, CONVEYOR DRIVE ROLLER
18	1	545755-01	TABLETOP, OUTFEED CONVEYOR
19	1	545756-01	PLATE, OUTFEED CONVEYOR
20	1	545756-02	PLATE, OUTFEED CONVEYOR
21	1	545751-01	ROLLER, FLAT BELT
22	2	545759-01	ROLLER, FLAT BELT
23	1	545760-01	SHAFT, FLAT BELT DRIVE
24	3	545761-01	SHAFT, MOTOR MOUNT SPACER
25	2	545762-01	SHAFT, CONVEYOR SPACER
26	1	545786-02	ASSY, OUTFEED CONVEYOR COVER
27	4	545787-01	SPACER, COVER MOUNT
28	2	545788-01	HANDLE, COVER MOUNT
29	1	545719-01	ASSY, OUTFEED BELT ADJUST



ITEM #		SCALE	DIMENSIONAL TOLERANCES NOTES:		NOTES:	
A	KEY	0 .313	IN	.005	IN	.005
CHECKED BY:	SALT	08-Feb-05	REMOTE ALL SURFACES OTHER THAN MOUNTS	N/A	WEAR TEST:	N/A
PACKED BY:	MASTER		ALL SURFACES ARE FLAT SURFACES ONLY DO NOT SCALE - WORK TO DIMENSIONS ONLY	N/A	SHIPPING:	N/A
					REF ID:	545754-02

PRINTED AND PROTECTED PROPERTY OF KIRK-RUDY, INC.
AND IS THE EXCLUSIVE PROPERTY OF KIRK-RUDY,
INC. IT IS TO BE USED IN THE PERFORMANCE OF
EXPRESSLY AGREED SERVICES FOR KIRK-RUDY,
INC. NO COPIES MAY BE MADE WITHOUT THE
WRITTEN CONSENT OF KIRK-RUDY, INC.
WOODSTOCK, GA 30088 USA

KR KIRK-RUDY, INC.
WOODSTOCK, GEORGIA

ASSY, ADJUSTABLE OUTFEED CONVEYOR

545754-02

ITEM NO	PART #	DESCRIPTION	KEY NO	DATE	DESCRIPTION	ITEM NO
1	2	100401			WASHER, THRUST BA410	
2	2	101913			GEAR, 1620 .6238-.188K	
3	2	102140			HANDLE, RELEASE 1/4-20 X 1.0	
4	4	103005			CAM FOLLOWER	
5	6	03804			BEARING, HUB 625	
6	4	107402			BOLT, SHOULDER 5/16X1/2	
7	1	533006-01			HANDWHEEL	
8	1	545757-02			ROLLER, FLAT BELT	
9	1	545757-03			ROLLER, FLAT BELT	
10	2	545759-01			ROLLER, FLAT BELT	
11	2	547457-01			PLATE, OUTFEED ROLLER TAKEUP	
12	2	547458-01			BLOCK, OUTFEED TAKEUP	
13	2	547520-01			PLATE, OUTFEED ADJUST MOUNT	
14	2	547521-01			PLATE, ROLLER MOUNT	
15	2	547522-01			RACK, ROLLER ADJUST	
16	1	547523-01			SHAFT, AUTOLOADER ADJUSTMENT	
17	1	547525-01			TOP, ROLLER ADJUST TABLE	
18	2	547526-01			BAR, FRAME SPACER	
19	6	547527-01			SPACER, TABLETOP	
20	2	547528-01			PLATE, BELT ADJUST SPLICE	
21	1	547529-01			COVER, CONVEYOR BOTTOM	
22	4	CSD0265			SCREW, SHCS 10-32X.500	
23	8	CSD0266			SCREW, SHCS 10-32X.625	
24	12	CSD0292			SCREW, SHCS 1/4-20X.500	
25	4	CSD0294			SCREW, SHCS 1/4-20X.750	
26	4	CSD0295			SCREW, SHCS 1/4-20X.875	
27	2	CSD0298			SCREW, SHCS 1/4-20X1.500	
28	6	CSE2252			SCREW, FLATHEAD 10-32X.250	
29	4	CSFF56			SCREW, BUTTON HEAD 10-32X.250	

WIRING 1
REO WHERE USED

WIRING 2
ASSY, OUTFEED BELT ADJUST

NAME BY:	SCALE	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	MATERIAL
A KEY	0 .375	.005 .005	N/A
CHECKED BY:	DATE 04 - Feb - 05	MEET DRAWINGS AND SPECIFICATIONS WHICH ARE SUBJECT TO CHANGE BY ENGINEERS AND MANAGERS	N/A
TRACED BY:	MASTER	ALL DIMENSIONS ARE IN INCHES. EXCEPT WHERE OTHERWISE SPECIFIED. NO. 1 SCALE WORK TO DRAWINGS ONLY	N/A

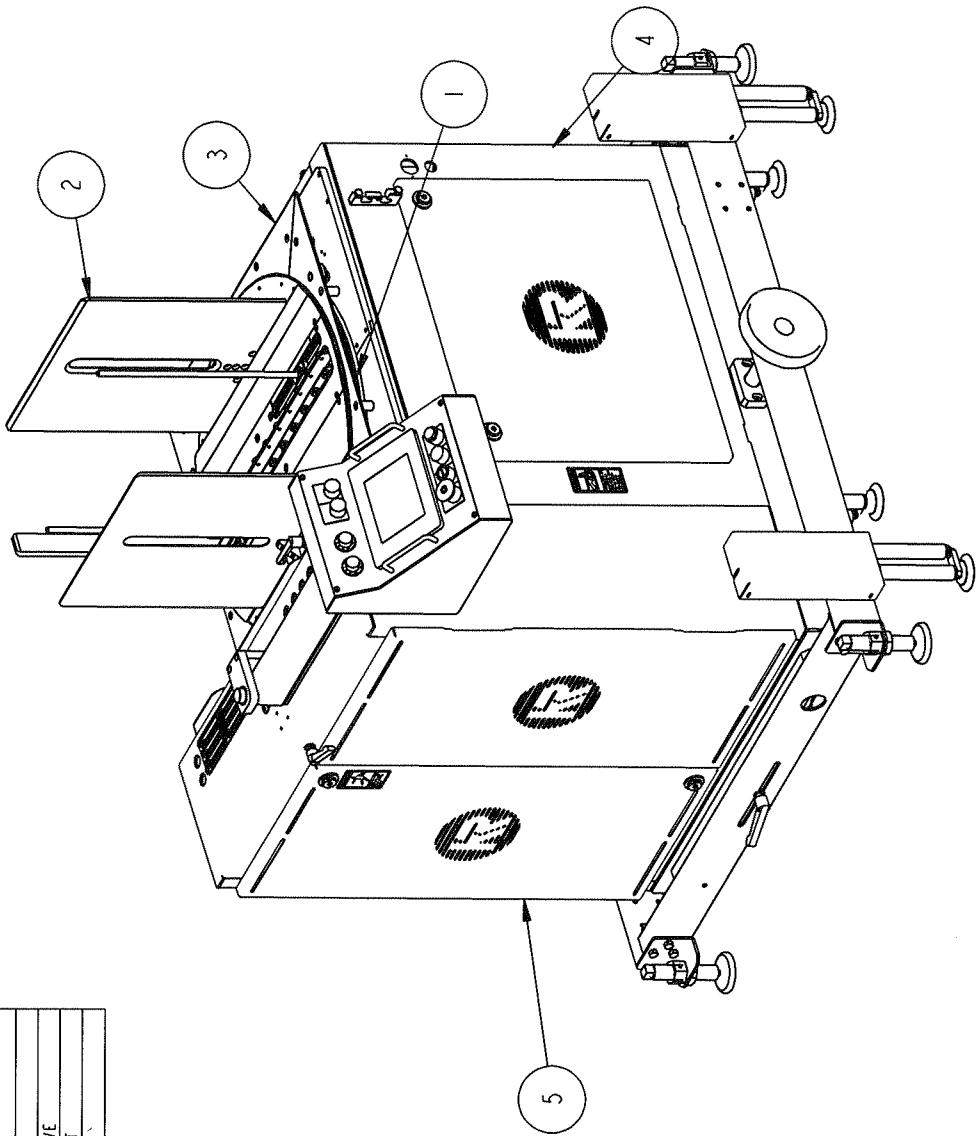
WIRING 3
ASSY, OUTFEED BELT ADJUST

NAME BY:	SCALE	DRAWING NUMBER	DATE	REVISION
KIRK - RUDI, INC.				
WOODSTOCK, GEORGIA				
PRINT DATE: 3/16/06 USA				
ITEM NO: 950				
SET UP: OF 2				

Drawing #

543899-01

ITEM NO.	PART #	DESCRIPTION	REV NO.	DATE	DESCRIPTION	REV NO.	DATE
1	1	109134-1 BELT, HD 2400-8M-20					
2	1	543896-01 ASSY, TURN TABLE					
3	1	543894-01 ASSY, TURN TABLE DRIVE					
4	1	545602-01 ASSY, STACKER CABINET					
5	1	545621-01 ASSY, ELECTRICAL BOX					



1	950	REO-D WHERE ISSUED
KIRK - RUDY INC		
KR WOODSTOCK, GEORGIA		
NAME:	ASSY, TURN TABLE AND MOUNT	REO-D
SCALE:	0.125	PRINTING #:
DATE:	15-Aug-05	INCHES OR MILLIMETERS:
CHECKED BY:		INCHES
MAKER:	MASTER	MILLIMETERS
TRACED BY:		SHARP EDGES UNLESS OTHERWISE NOTED
		ALL HOLE LOCATIONS ARE FINISHED UNLESS NOTED. WORK TO DIMENSIONS ONLY
		NOT SCALE. WORK TO DIMENSIONS ONLY
		SET OF 3
		543899-01

DRAWING #

543896-01

ITEM NO.	PART #	DESCRIPTION	REV. NO.	DATE	ECN NO.	BY
1	2	ASSY, SIDE GUIDE				
2	1	ASSY, RETRACTABLE PRODUCT GUIDE				
3	1	ASSY, RETRACTABLE PRODUCT GUIDE				
4	1	ASSY, PUSHER				
5	1	ASSY, PRODUCT LIFT				
6	1	ASSY, TURN TABLE				

1	950
REV. D	WHERE ISSUED

KRK KIRK - RUDY INC.
WOODSTOCK, GEORGIA

PRINTING AND CONFIDENTIAL INFORMATION CONTAINED HEREIN MAY BE PROPRIETARY TRADE SECRET OF KIRK-RUDY INC. IT MAY NOT BE REPRODUCED OR DISCLOSED TO UNAUTHORIZED PERSONNEL EXCEPT AS NECESSARY IN THE PERFORMANCE OF THE DUTIES OF THE EMPLOYEE OR CONTRACTOR.		PRINTING AND PRODUCTION METHOD:	DATE:
		N/A	950
REMOVED ALL BURRS, CAVES, SHARP EDGES, AND OTHER DEFECTS AS FURNISHED BY THE BUYER.	REMOVED ALL BURRS, CAVES, SHARP EDGES, AND OTHER DEFECTS AS FURNISHED BY THE BUYER.	REMOVED ALL BURRS, CAVES, SHARP EDGES, AND OTHER DEFECTS AS FURNISHED BY THE BUYER.	DATE:
MADE BY:	MASTER	SCALE NO.	543896-01
TRACTED BY:		SET NO.	10F5

SCALE 0.250

DRAWING #

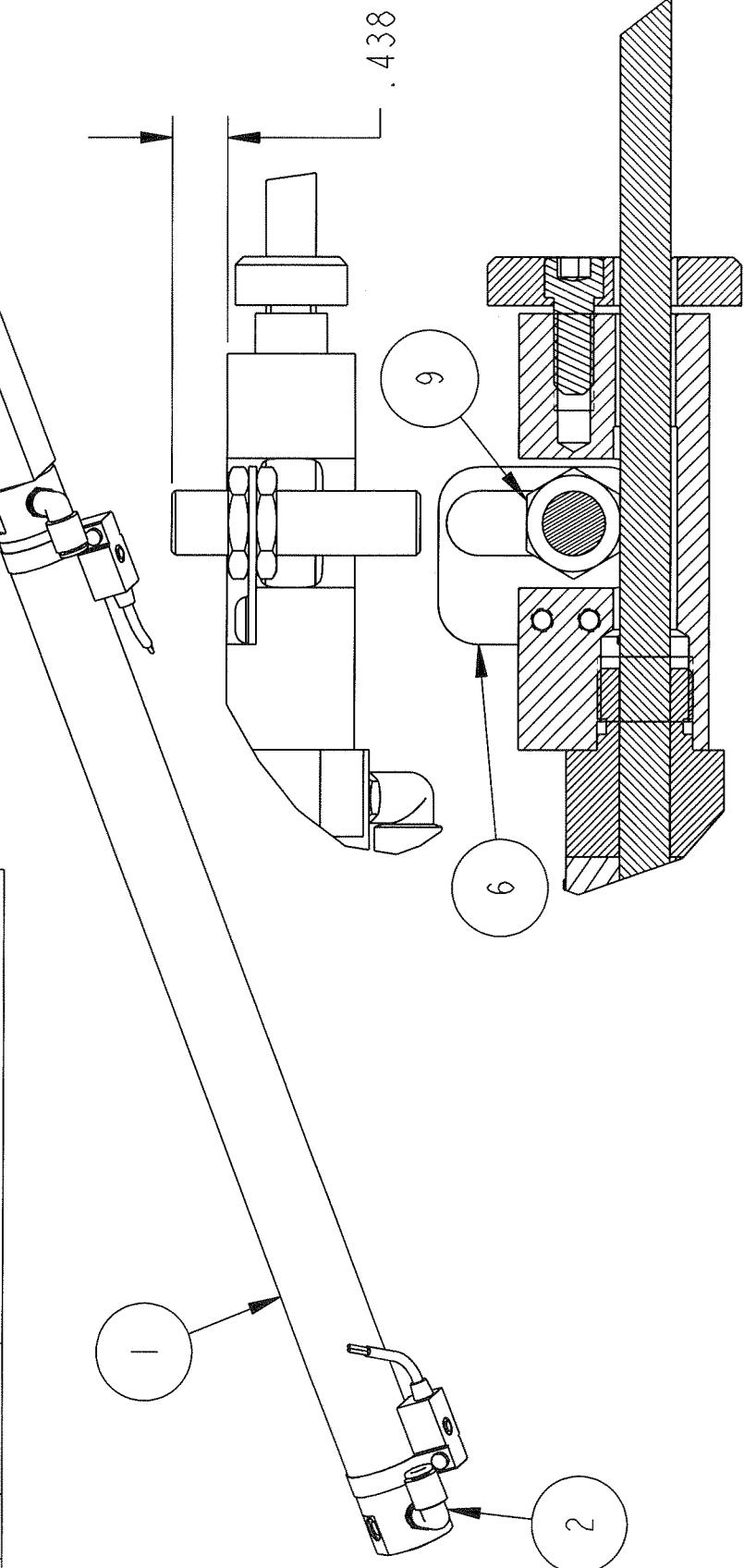
543910-01

ITEM / QTY	PART #	DESCRIPTION	REF NO	DATE	DESCRIPTION	REV NO
1	1	WASHER, FLAT 5/16"ID				
2	1	HANDLE, RELEASE 5/16-18 X 1-26				
3	1	BLOCK, SIDE GUIDE ADJUST CLAMP				
4	1	PLATE, PRODUCT GUIDE				
5	1	BLOCK, PRODUCT GUIDE MOUNT				
6	1	PLATE, SIDEGUIDE SUPPORT				

2	950
REV'D	WHEN USED

DRAWING #: A KEY		SCALE: 0 .438	DIMENSIONS & TOLERANCES: UNLESS OTHERWISE NOTED	MATERIAL: N/A	TECHNICAL PROTECTION: PROTECT THIS DRAWING AND COPYRIGHT MATERIAL FROM UNAUTHORIZED REPRODUCTION OR EXAMINATION. IT IS THE PROPERTY OF KIRK-RUDY INC., WOODSTOCK, GEORGIA.	
CHECKED BY: 25-Jul-05		IN MM	IN INCHES	WEIGHT: N/A	EXPLANATION: MAY BE COPIED ON REQUEST TO KIRK-RUDY INC., WOODSTOCK, GA 30188 USA.	
TRACED BY: MASTER		IN MM	IN INCHES	TIME: N/A	TITLE: MODEL: 950	
					SHEET NO: 10F1	ASSY, SIDE GUIDE

ITEM	QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	1	109694	CYLINDER, PRODUCT GUIDE AIR					
2	2	191337	FITTING, ELBOW 1/8 NPT 1/4 TUBE					
3	1	202718-3	SENSOR, PROXIMITY INDUCTIVE					
4	1	543916-01	BLOCK, AIR CYLINDER MOUNT					
5	1	543917-01	PLATE, AIR CYLINDER CLAMP					
6	1	547460-01	BRACKET, PROX MOUNT					
7	1	CSDD320	SCREW, SHCS 5/16-18X.750					
8	2	CSFF56	SCREW, BUTTON HEAD #10-32X.250					
9	2	PROXNUT	NUT, PROX					



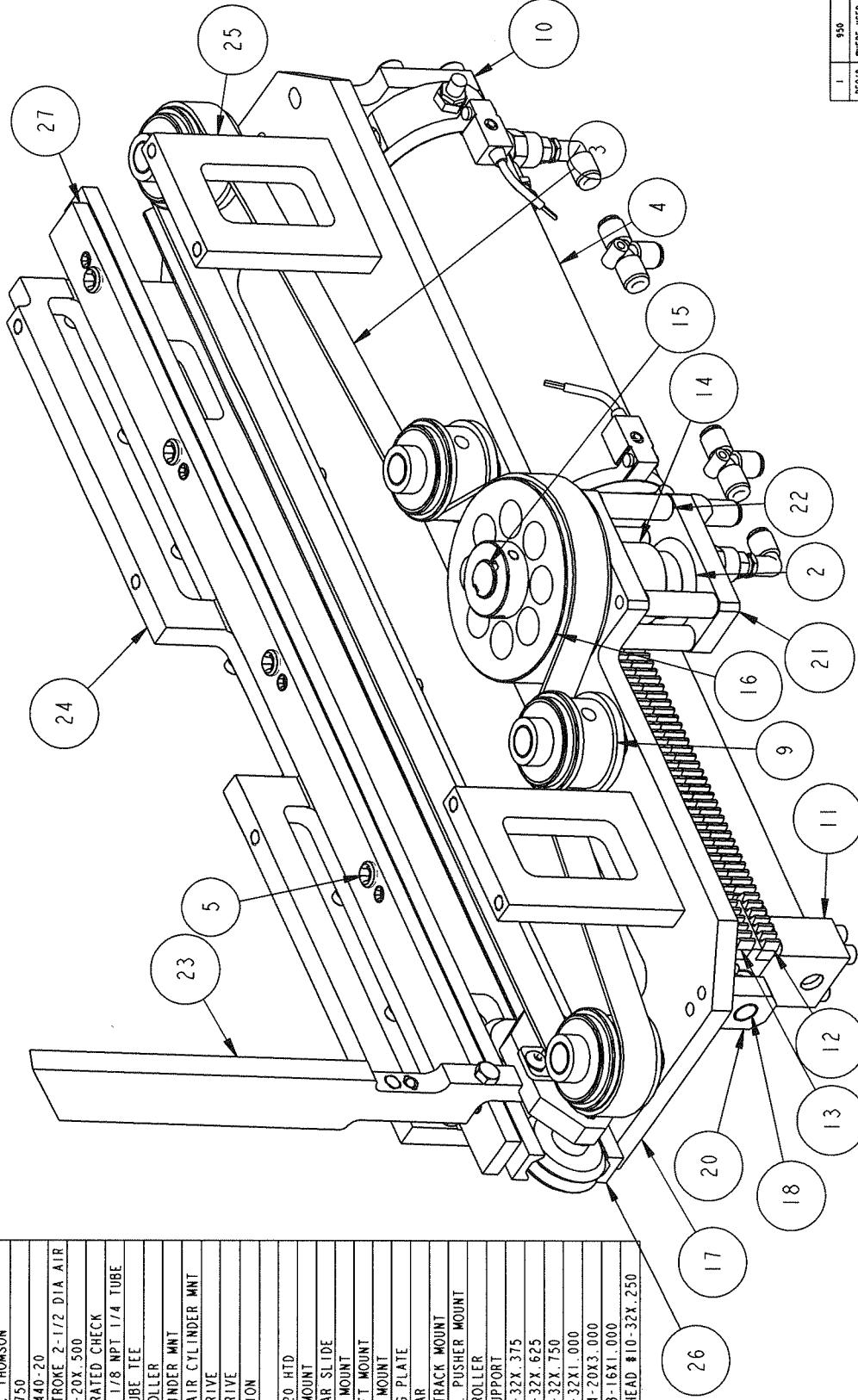
DRAWN BY: A KEY	SCALE 0 .375	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED		MATERIAL: N/A	THIRD ANGLE PROJECTION --- +---	PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE QUOTED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY INC. KENNESAW, GA 30044 USA	RECD 2	WHERE USED 950
CHECKED BY: 	DATE 28-Feb-05	.xx	.005	ANG. .5	HEAT TREAT: N/A	MODEL: 950	TITLE: ASSY, RETRACTABLE PRODUCT GUIDE	DRAWING # 543915-01
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. 1 OF 1		
		N/A		N/A				

ITEM QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	1	109694 CYLINDER, PRODUCT GUIDE AIR					
2	2	191337 FITTING, ELBOW 1/8 NPT 1/4 TUBE					
3	1	202718-3 SENSOR, PROXIMITY INDUCTIVE					
4	1	543916-01 BLOCK, AIR CYLINDER MOUNT					
5	1	543917-01 PLATE, AIR CYLINDER CLAMP					
6	1	547460-01 BRACKET, PROX MOUNT					
7	1	CSDD320 SCREW, SHCS 5/16-18X.750					
8	2	CSFF56 SCREW, BUTTON HEAD #10-32X.250					
9	2	PROXNUT NUT, PROX					

.78 |

DRAWN BY: A KEY	SCALE 0 . 375	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED			MATERIAL: N/A	THIRD ANGLE PROJECTION	
CHECKED BY:	DATE 28-Feb-05	.xx	.xxx	ANG. .01 -.005 .5	HEAT TREAT: N/A	KR KIRK - RUDY, INC. KENNESAW, GEORGIA	
TRACED BY:	MASTER	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED			FINISH: N/A	MODEL: 950 TITLE: ASSY, RETRACTABLE PRODUCT GUIDE SHEET NO.: OF 1 DRAWING #	

2	950	REO'D	WHERE USED
2	950		



ITEM #	PART #	DESCRIPTION	REV NO	DATE	TECH	BY

DRAWN BY:	A KEY	SCALE	0 . 500	DIMENSIONAL TOLERANCES			MATERIAL:	N/A	REAR TRAIL:	N/A	MORE:	INITIAL:	ASSY ,	PUSHER
				IN.	MM.									
CHECKED BY:		DATE	17 - Sep - 04	REAR ALL SURFS AND SHARP EDGES UNLESS OTHERWISE NOTED										
MADE BY:		MASTER		ALL DIMENSIONS ARE FINISHED IN INCHES			LINER	N/A						
PROPRIETARY AND CONFIDENTIAL NO PART OF THIS DRAWING IS TO BE COPIED OR REPRODUCED, IN WHOLE OR IN PART, EXCEPT WITH PERMISSION W.R. GRAY INC., 3016 USA														
														
PRINTED ON 10-2000														

KIRK ROGGIN, INC.
WOODSTOCK, GEORGIA

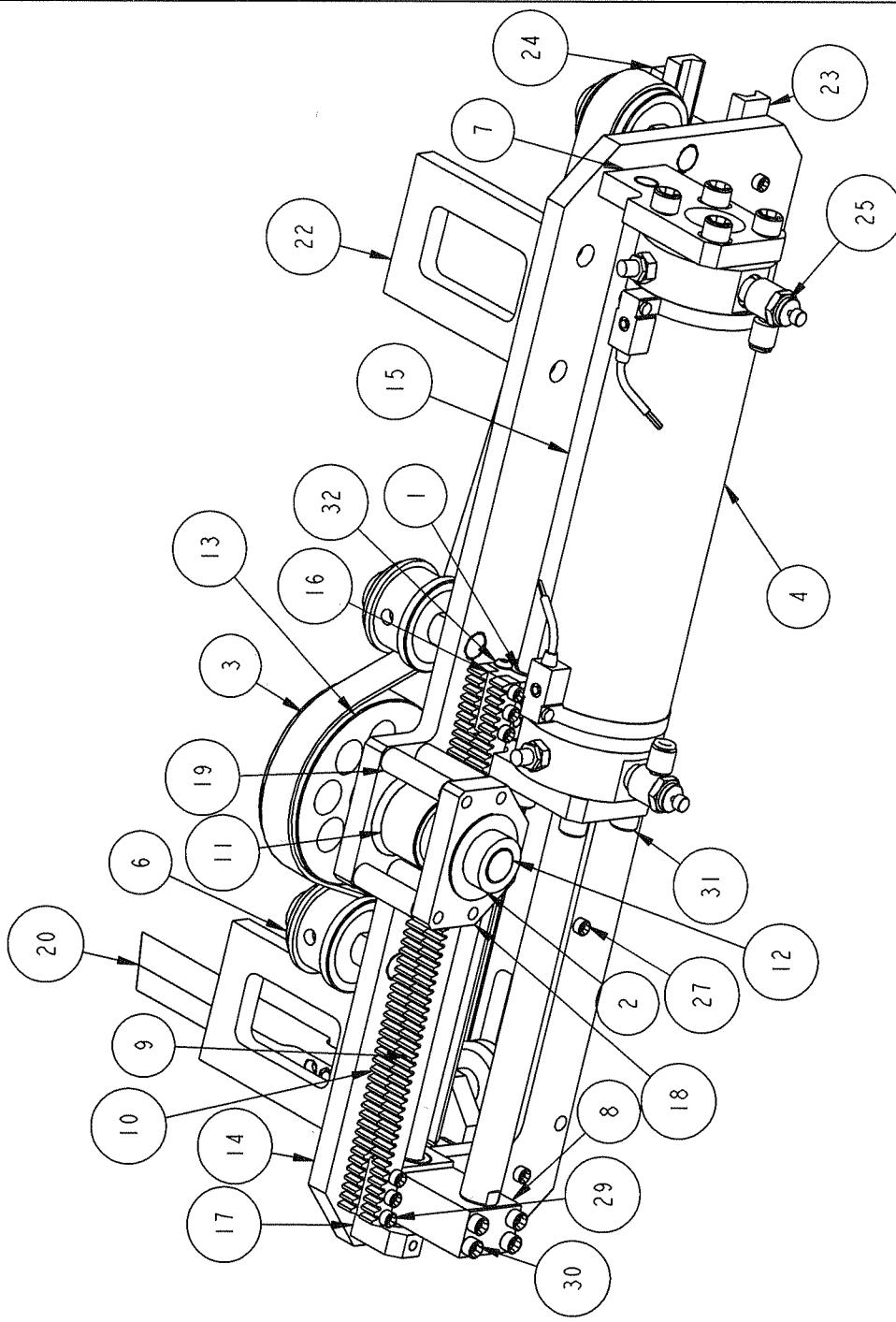
ASSY PUBLISHER

卷之三

543933-01

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

1	2	102912	LINER BUSHING, THOMSON			
2	2	103805	BEARING, HUB .750			
3	1	109138	BELT, HD 8M-1440-20			
4	1	109692	CYLINDER, 8" STROKE 2-1/2 DIA AIR			
5	5	191319	SCREW, SET 1/2-20X .500			
6	4	543923-02	ASSY, DIVERT ROLLER			
7	2	543934-01	PLATE, AIR CYLINDER MNT			
8	1	543935-01	BLOCK, PUSHER AIR CYLINDER MNT			
9	1	543936-01	RACK, PUSHER DRIVE			
10	1	543936-02	RACK, PUSHER DRIVE			
11	1	543938-01	GEAR, 1624 PINION			
12	1	543939-01	SHAFT, PINION			
13	1	543940-01	PULLEY, 40-8M-20 HD			
14	1	543941-01	PLATE, PUSHER MOUNT			
15	1	543942-01	SHAFT, RACK GEAR SLIDE			
16	2	543943-01	BLOCK, BUSHING MOUNT			
17	1	543944-01	POST, RACK SHAFT MOUNT			
18	1	543945-01	PLATE, BEARING MOUNT			
19	4	543946-01	SPACER, BEARING PLATE			
20	1	543948-01	ASSY, PUSHER BAR			
21	1	543951-01	PLATE, PUSHER TRACK MOUNT			
22	2	543952-01	PLATE, VERTICAL PUSHER MOUNT			
23	2	543964-02	TRACK, PUSHER ROLLER			
24	1	543966-02	PLATE, TRACK SUPPORT			
25	2	AS2211F-02	.075			
26	5	CSD0264	SCREW, SHCS 10-32X .375			
27	5	CSD0266	SCREW, SHCS 10-32X .625			
28	8	CSD0267	SCREW, SHCS 10-32X .750			
29	6	CSD0259	SCREW, SHCS 10-32X .000			
30	4	CSD0304	SCREW, SHCS 1/4-20X3.000			
31	8	CSD0348	SCREW, SHCS 3/8-16X1.000			
32	4	CSFF556	SCREW, BUTTON HEAD #10-32X.250			

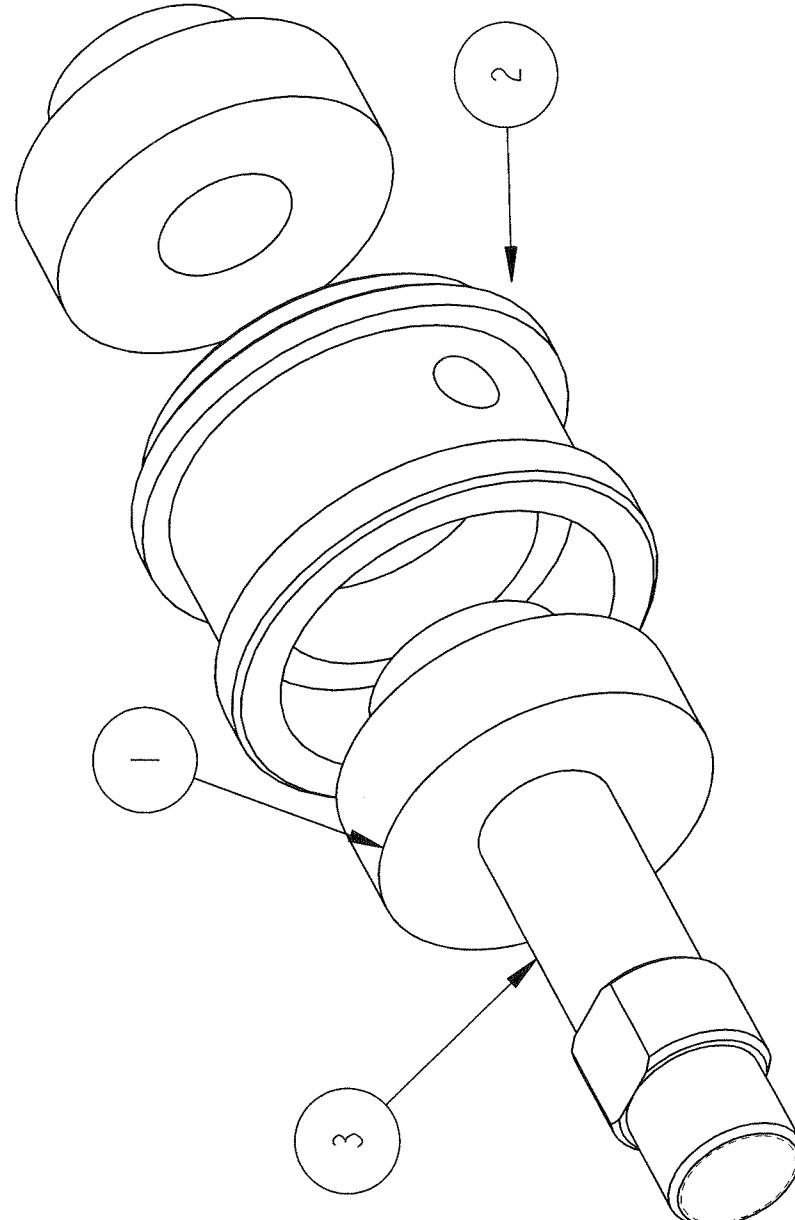


DRAWING #:		SCALE:		DIMENSIONAL TOLERANCES:		MATERIAL:		THREE-DIMENSIONAL PROJECTION	
A	KEY	0 .450		.000	.000	N/A	N/A	PROPRIETARY AND CONFIDENTIAL	
CHECKED BY:		DATE:	28-Feb-05	.000	.000			NO COPIES OR DERIVATIVES ARE TO	
INITIALS:		REMOVED:						BE MADE FROM THIS DRAWING.	
TELECO:		ALL DIMENSIONS ARE IN INCHES.						THIS DRAWING IS THE PROPERTY OF	
MASTER:		SPRING WIRE SIZE .010						KIRK-RUDY, INC.	
		SHIPS IN BOXES ONLY						WOODSTOCK, GEORGIA	
I		1						PRINTED ON 2/28/05	
RECD BY:		REC'D DATE:						950	
		REC'D BY:						200	
		REC'D DATE:						FEB 2005	

DRAWING #

543933-01

ITEM	QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	2	103804	BEARING, HUB .625					
2	1	543922-01	ROLLER, HTD DIVERT BELT					
3	1	543924-02	STUD, BELT DIVERT IDLER					



		2	950
REO D	WHERE USED		
 KIRK - RUDY, INC. KENNESAW, GEORGIA			
DRAWN BY: A KEY		SCALE 1 . 250	MATERIAL: N/A
CHECKED BY: 02 - May - 03		DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED .xx .xxx .005 .5 ANG.	THIRD ANGLE PROJECTION 
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	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: 950	TITLE: ASSY, DIVERT ROLLER
		SHEET NO. 1 OF 1	DRAWING # 543923-02

ITEM	QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	1	100603	WASHER, FLAT 1/4ID					
2	2	190965	BALL PLUNGER, DELRIN NOSE 3/8-16					
3	2	25020HS500	BOLT, 1/4-20 X .500					
4	2	543902-01	ASSY, GUIDE WHEEL CONCENTRIC					
5	1	543949-01	PLATE, PUSHER BAR SLIDE					
6	1	543950-01	BAR, PUSHER					
7	1	543965-02	BRACKET, PUSHER BELT MNT					
8	2	CSEE309	SCREW, FLATHEAD 5/16-18X.750					
9	2	CSFF65	SCREW, BUTTON HEAD 1/4X.500					

1 950
REV D WHERE USED

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

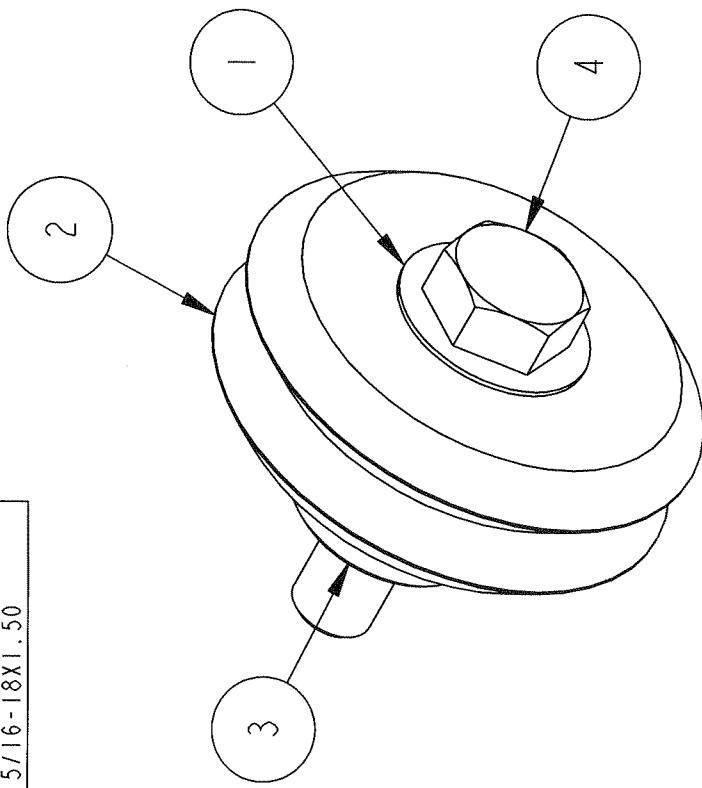
KR KIRK - RUDY, INC.
KENNESAW, GEORGIA

TITLE: ASSY, PUSHER BAR
DRAWING #:

543948-01

DRAWN BY: A KEY	SCALE 1 . 000	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED			MATERIAL: N / A	THIRD ANGLE PROJECTION		
CHECKED BY:	DATE 01 - Sep - 04	.xx	.xxx	.005	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			FINISH: N / A	MODEL: 950	SHEET NO.: 1 OF 1	DRAWING #:

ITEM	QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	1	100616	WASHER, FLAT 5/16 ID .020 TK					
2	1	102908	WHEEL, GUIDE W3X					
3	1	102909	BUSHING, ADAPTER STRAIGHT B3					
4	1	RHB052	BOLT, HEX HEAD 5/16-18X1.50					



DRAWN BY: A K E Y	SCALE 1 . 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 05 - Mar - 03	.xx	.xxx	.005	ANG. .5	HEAT TREAT: N / A	MODEL: 950	TITLE: ASSY, GUIDE WHEEL CONCENTRIC
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 10 OF 1	DRAWING # 543902-01
							2	950
							RECD BY	WHERE USED

Drawing 1					
ITEM #	PART #	DESCRIPTION	Qty	DATE	DESCRIPTION
1	2	WASHER, THRUST TB612	2		ECN NO
2	2	SCREW, BUTTON HEAD #10-32X .250			BY
3	4	SCREW, FLATHEAD 1/4-20X .815			
4	12	SCREW, FLHD UNDERCUT 10-32X .250			
5	1	CYLINDER, 1/2 INCH LIFT			
6	1	191337 FITTING, ELBOW 1/8 NPT 1/4 TUBE			
7	1	191394 FITTING, FLOW CONTROL METER OUT			
8	1	543947-01 TABLETOP, PRODUCT LIFT			
9	1	543954-01 BLOCK, LIFT CYLINDER MOUNT			
10	2	543955-01 BAR, LIFT MOUNT SPACER			
11	1	543956-01 BLOCK, LIFT TABLE MOUNT			
12	1	543956-02 BLOCK, LIFT TABLE MOUNT			
13	1	543957-01 BAR, LIFT SHAFT MOUNT			
14	1	543958-01 SHAFT, PRODUCT LIFT SUPPORT			
15	2	543959-01 BLOCK, LIFT SHAFT BUSHING			
16	1	543960-01 BLOCK, LIFT CYLINDER MOUNT			
17	1	543961-01 BLOCK, LIFT CYLINDER MOUNT			
18	2	543969-01 RULE, FLAT SIDEGUIDE PLACEMENT			
19	2	543973-01 TABLETOP, PRODUCT LIFT SUPPORT			
20	2	543973-02 TABLETOP, PRODUCT LIFT SUPPORT			
21	2	543613-01 PLATE, PRODUCT LIFT SCAB			
22	1	547235-01 ASSY, AIR VALVE			
23	2	547532-01 BUSHING, 6251D 1.125OD CROWDED			
24	1	547923-03 ASSY, FLEX CABLE STRAIN RELIEF			
25	2	HIN013 NUT, JAM 7/16-14			
26	2	HMSN14 NUT, HEX 3/8-16			

REF ID: WHERE ISSUED

Drawing 2		DRAWING AND CONFIDENTIALITY INFORMATION		DRAWING AND CONFIDENTIALITY INFORMATION	
A	KEY	SCALE	0 .340	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	MATERIAL:
				N/A	
CHECKED BY:		SATE	02-Feb-06	REMOVED BY:	N/A
TRACED BY:		MASTER		REMOVED BY:	N/A
ALL DIMENSIONS ARE IN INCHES. UNLESS NOTED, DIMENSIONS DO NOT SCALE. WORK TO DIMENSIONS ONLY.					

REF ID: WHERE ISSUED

ITEM	QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	6	107468	SCREW, SHCS 4-40X1.000					
2	4	191296	FITTING, STRAIGHT 1/4 T 1/8 NPT					
3	1	191298	FITTING, STRAIGHT 3/8 T 1/4 NPT					
4	2	191337	FITTING, ELBOW 1/8 NPT 1/4 TUBE					
5	2	191338	FITTING, 1/4 TUBE TEE					
6	6	191340	MUFFLER, 1/8 NPT AIR					
7	1	191341	VALVE, TWO POSITION SINGLE					
8	1	191342	VALVE, THREE POSITION CLOSED CENTER					
9	1	191343	VALVE, THREE POSITION EXHAUST CTR					
10	1	191352	FITTING, 1/4NPT 3/8TUBE ROTARY					
11	1	543967-01	PLATE, PNEUMATIC HARNESS					
12	1	543970-01	BLOCK, AIR MANIFOLD					
13	1	545622-01	BRACKET, TERMINAL MOUNT					
14	1	547238-01	GUIDE, AIR HOSE					

I XXX
 REO'D WHERE USED

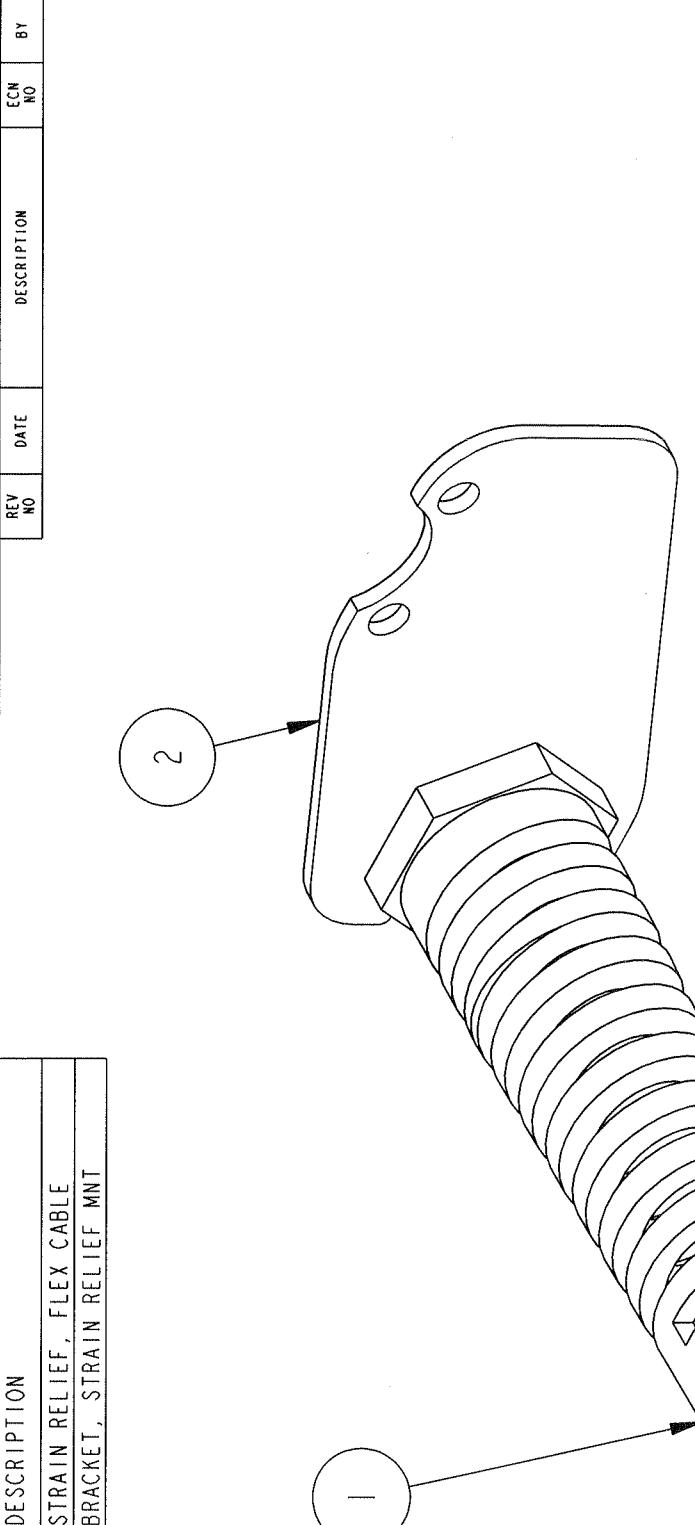
547235-01

DRAWN BY:
 A KEY
 SCALE: 0 .300
 DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED
 .XX .XXX .01 .005 .5 ANG.
 REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED
 ALL DIMENSIONS ARE FINISHED DIMENSIONS
 DO NOT SCALE - WORK TO DIMENSIONS ONLY

THIRD ANGLE PROJECTION
 NO PORTION OF THIS DRAWING
 MAY BE COPIED OR REPRODUCED
 IN ANY FORM IN WHOLE OR IN PART
 EXPRESSLY AGREED WITH KIRK-RUDY,
 KIRK-RUDY INC.,
 KIRK-RUDY,
 WOODSTOCK, GEORGIA
 USA

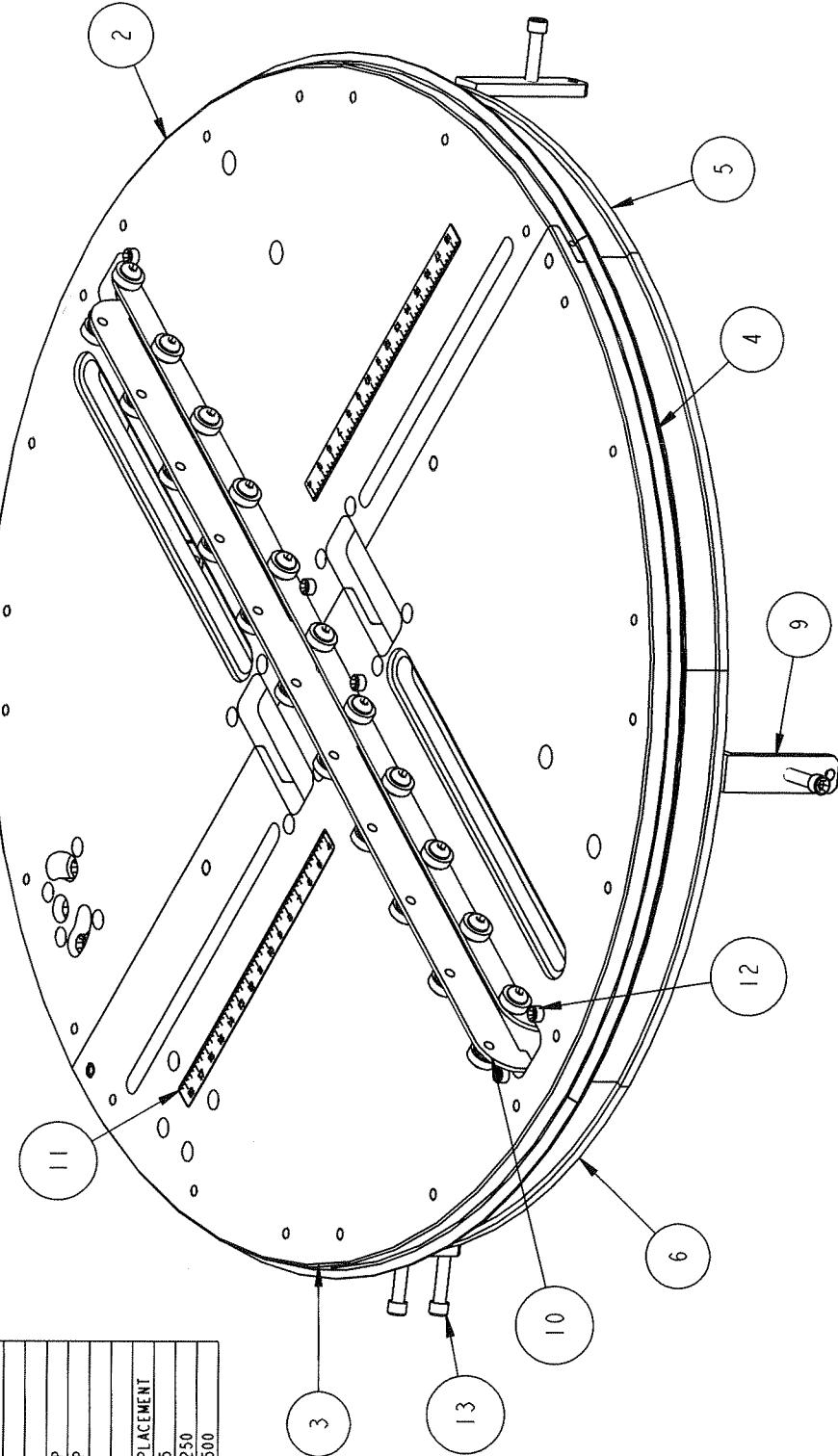
PROPRIETARY AND CONFIDENTIAL
 DRAWING NO. 547235-01
 DRAWN AND OWNED BY KIRK-RUDY,
 INC., WOODSTOCK, GEORGIA
 DRAWN BY: DATE: 02-Feb-06
 CHECKED BY: TRACED BY: MASTER
 MODEL: 950
 FINISH: N/A
 SHEET NO. OF 1
 DRAWING #: ASSY, AIR VALVE
 TITLE: DRAWING #:

ITEM	QTY	PART #	DESCRIPTION
1	1	191433	STRAIN RELIEF, FLEX CABLE
2	1	547924-03	BRACKET, STRAIN RELIEF MNT



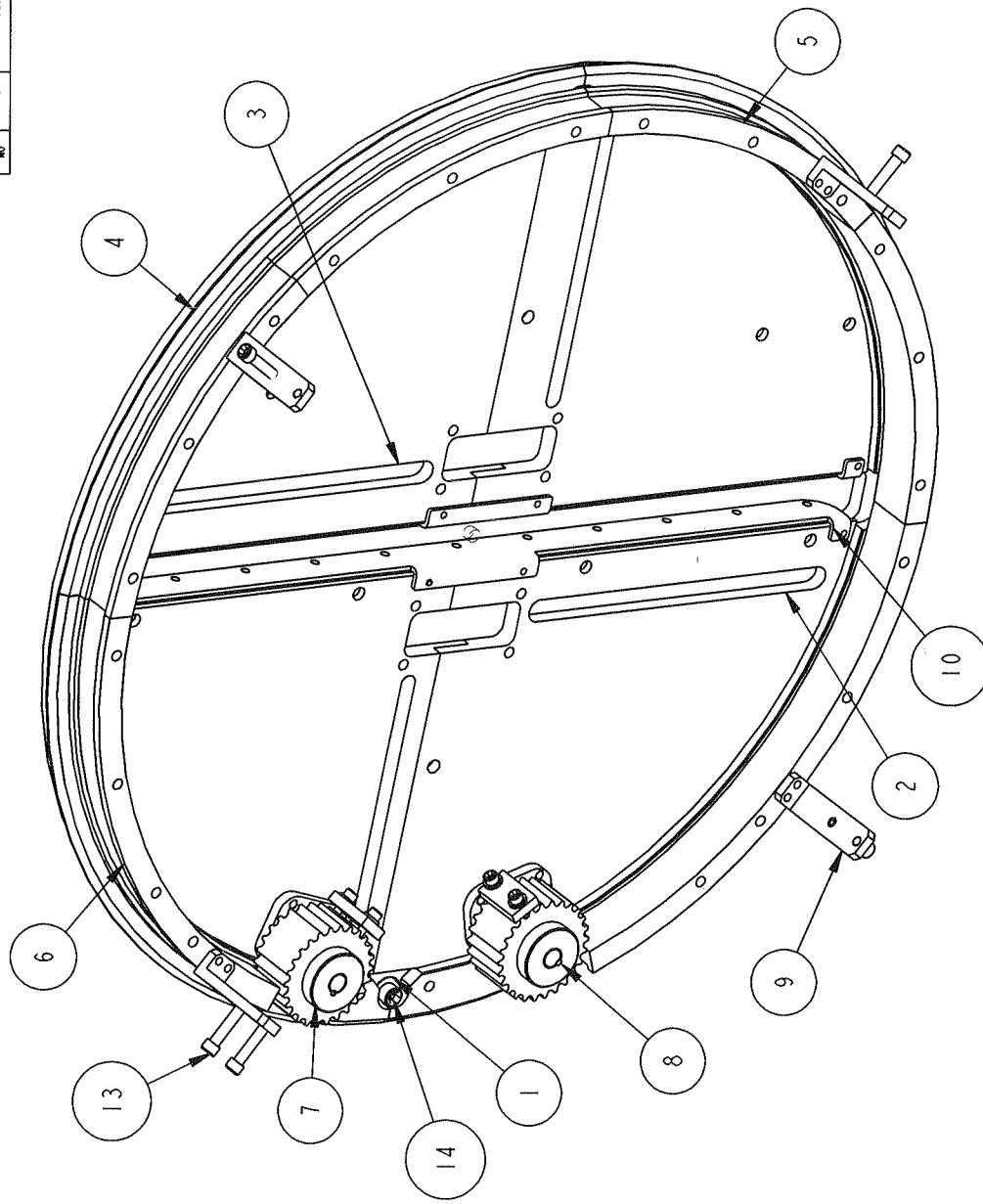
DRAWN BY:	SCALE	KEY	DATE	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED			MATERIAL:	THIRD ANGLE PROJECTION	PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE QUOTED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC. WOODSTOCK, GEORGIA
A	.000		02-Fe b - 06	.01	.005	.5	N/A		
CHECKED BY:				REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED			HEAT TREAT:		KIRK - RUDY, INC. WOODSTOCK, GEORGIA
TRACED BY:	MASTER			ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY			FINISH:	950	TITLE: ASSY, FLEX CABLE STRAIN RELIEF
							SHEET NO. 1 OF 1	DRAWING #	547923-03

ITEM NO.	PART #	DESCRIPTION	REV. NO.	DATE	DESCRIPTION	ECN NO.	BY
1	1	100616 WASHER, FLAT 5/16 D .020TK					
2	1	543897-01 PLATE, RH TURN TABLE					
3	1	543897-02 PLATE, RH TURN TABLE					
4	4	543898-01 TRACK, V ROLLER GUIDE					
5	4	543918-01 RING, HHD BELT GUIDE					
6	2	543918-02 RING, HHD BELT GUIDE					
7	1	543926-01 ASSY, HHD BELT TAKE UP					
8	1	543926-02 ASSY, HHD BELT TAKE UP					
9	4	543922-01 BRACKET, PROX SCREW					
10	2	543962-01 ASSY, TABLE ROLLER					
11	2	543969-01 RULE, FLAT SIDEGUIDE PLACEMENT					
12	8	CSD026 SCREW, SHCS 10-32X .625					
13	5	CSDD97 SCREW, SHCS 1/4-20X1.250					
14	1	CSDD318 SCREW, SHCS 5/16-1.8X .500					



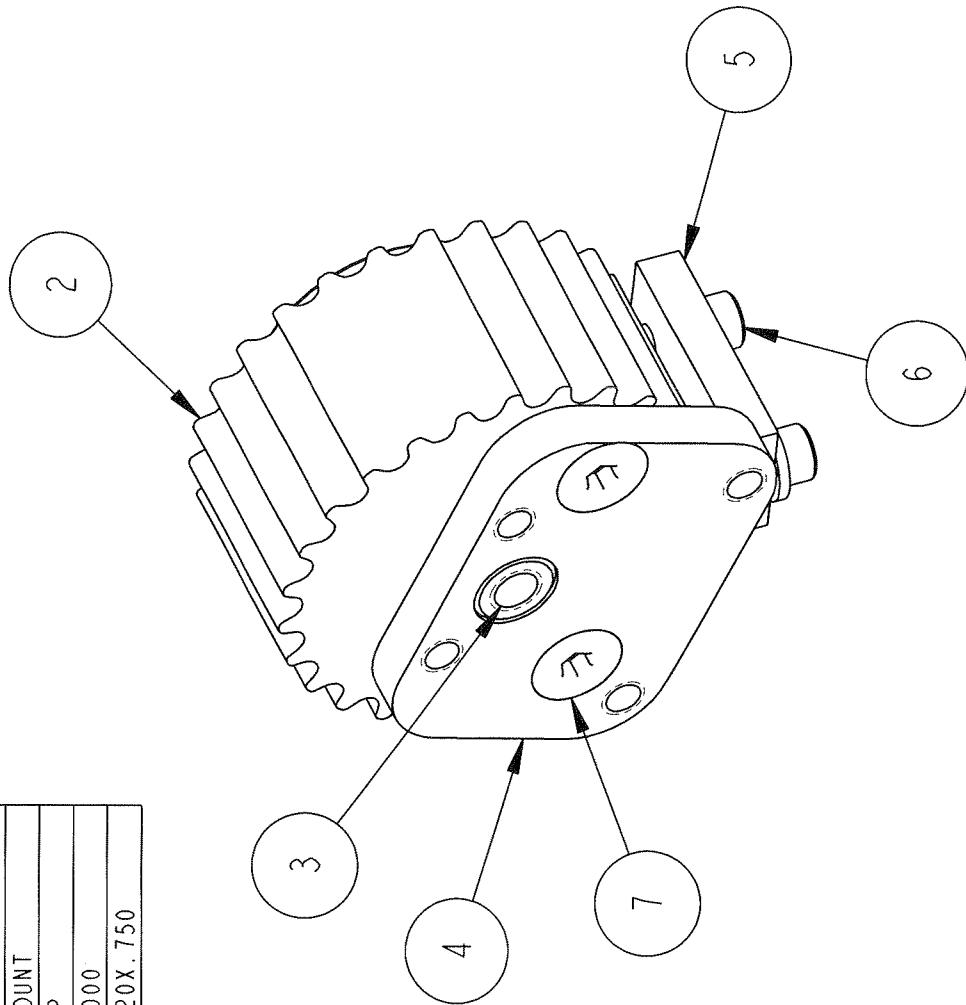
1	950	REF'D WHERE USED
KRK KIRK - RUDY, INC. WOODSTOCK, GEORGIA		
ASSY, TURN TABLE		
DRAWING #: A KEY	SCALE: 0.438	THIRD ANGLE PROJECTION
DATE: 28-Feb-05	UNLESS OTHERWISE NOTED	MATERIAL: N/A
CHECKED BY:	.000 .000 .000	WEIGHT: N/A
TRACED BY:	.000 .000 .000	INCHES: N/A
		MM: 950
		NET WT: 10F2

ITEM NO.	PART #	DESCRIPTION	REV NO.	DATE	DESCRIPTION	ECN NO.	BY
1	1	100616 WASHER, FLAT 5/16ID .020TK					
2	1	543897-01 PLATE, RH TURN TABLE					
3	1	543897-02 PLATE, RH TURN TABLE					
4	4	543898-01 TRACK, Y ROLLER GUIDE					
5	4	543818-01 RING, HID BELT GUIDE					
6	2	543918-02 RING, HID BELT GUIDE					
7	1	543926-01 ASSY, HID BELT TAKE UP					
8	1	543926-02 ASSY, HID BELT TAKE UP					
9	4	543932-01 BRACKET, PROX SCREW					
10	2	543962-01 ASSY, TABLE ROLLER					
11	2	543969-01 RULE, FLAT SIDEGUIDE PLACEMENT					
12	8	CSD0266 SCREW, SHCS 10-32X .625					
13	5	CSD0297 SCREW, SHCS 1/4-20X1.250					
14	1	CSDD318 SCREW, SHCS 5/16-18X .500					



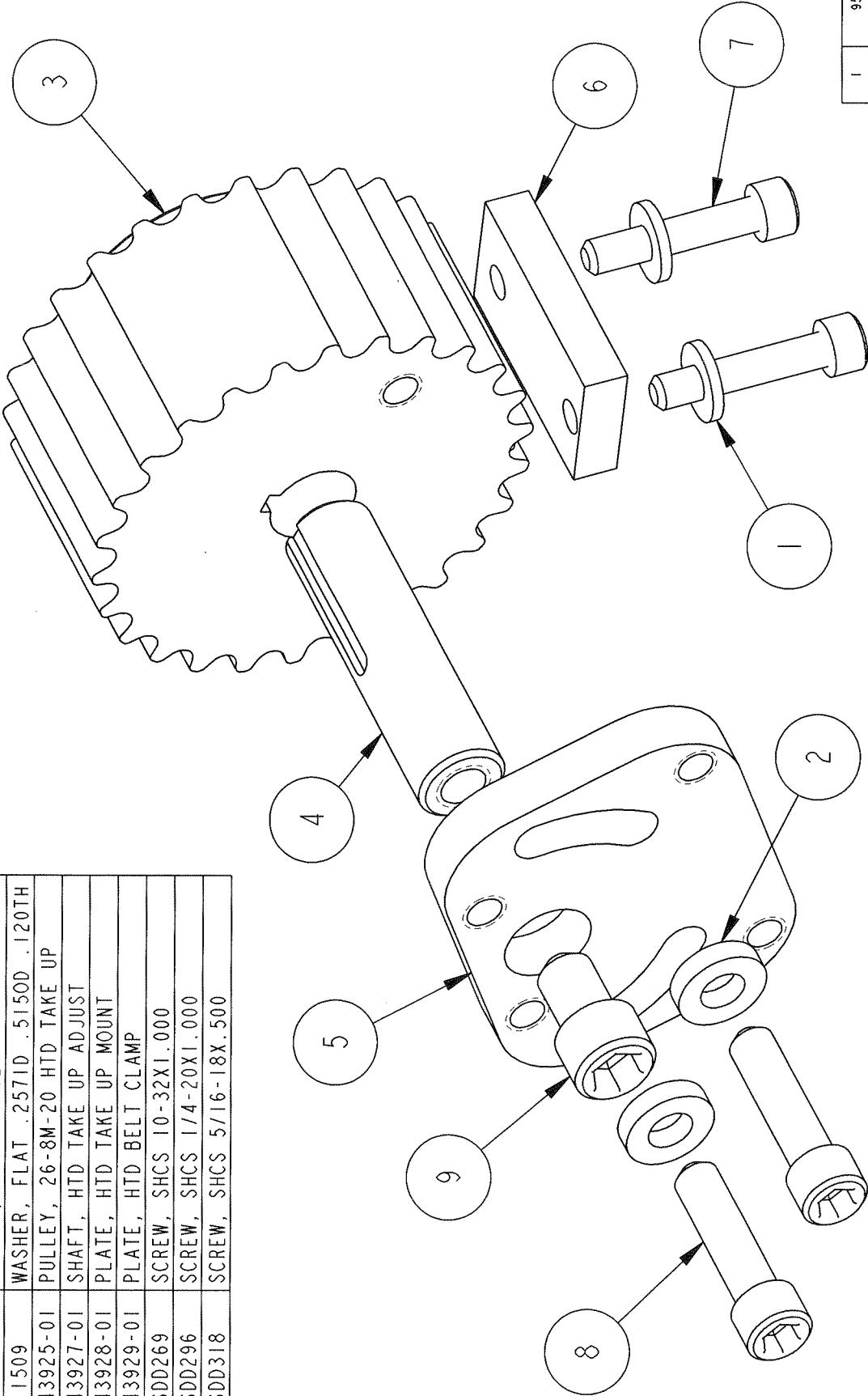
PRINTING 1	543972-01	1	950
REO'D	WHERE USED		
KIRK - RUDY, INC.	KIRK - RUDY, INC.		
WOODSTOCK, GEORGIA	WOODSTOCK, GEORGIA		
PROPRIETARY AND CONFIDENTIAL AND IS THE PROPERTY OF KIRK-RUDY, INC. IT IS TO BE KEPT SECRET AND NOT DISCLOSED OR COPIED IN WHOLE OR IN PART. EXCEPT AS AUTHORIZED IN WRITING BY KIRK-RUDY, INC., WOODSTOCK, GA. 30188 USA	PROPRIETARY AND CONFIDENTIAL AND IS THE PROPERTY OF KIRK-RUDY, INC. IT IS TO BE KEPT SECRET AND NOT DISCLOSED OR COPIED IN WHOLE OR IN PART. EXCEPT AS AUTHORIZED IN WRITING BY KIRK-RUDY, INC., WOODSTOCK, GA. 30188 USA		
PRINTING 1	ASSY, TURN TABLE	950	SCALE 1:10
PRINTING 1	543972-01	20F2	SCALE 1:10

ITEM	QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	2	100619	WASHER, FLAT 10-32					
2	1	543925-01	PULLEY, 26-8M-20 HTD TAKE UP					
3	1	543927-01	SHAFT, HTD TAKE UP ADJUST					
4	1	543928-02	PLATE, HTD TAKE UP MOUNT					
5	1	543929-01	PLATE, HTD BELT CLAMP					
6	2	CSD269	SCREW, SHCS 10-32X1.000					
7	2	CSEE283	SCREW, FLATHEAD 1/4-20X.750					



DRAWN BY: A K E Y	SCALE . 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. KR KIRK - RUDY, INC., KENNESAW, GEORGIA	
CHECDED BY:	DATE 02 - May - 03	.xx	.xxx	ANG. .01 .005 .5	FINISH TREAT: N / A		MODEL: 950	TITLE: ASSY, HTD BELT 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			N / A	SHEET NO. 10F1	DRAWING # 543926-01	
						I	950	
						RECD WHERE USED		

ITEM	QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	2	100619	WASHER, FLAT 10-32					
2	2	111509	WASHER, FLAT .25710 .51500 .120TH					
3	1	543925-01	PULLEY, 26-8M 20 HTD TAKE UP					
4	1	543927-01	SHAFT, HTD TAKE UP ADJUST					
5	1	543928-01	PLATE, HTD TAKE UP MOUNT					
6	1	543929-01	PLATE, HTD BELT CLAMP					
7	2	CSDD269	SCREW, SHCS 10-32X1.000					
8	2	CSDD296	SCREW, SHCS 1/4-20X1.000					
9	1	CSDD318	SCREW, SHCS 5/16-18X.500					



DRAWN BY: A KEY	SCALE 1 . 250	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 13-May-03	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED .01 .005 .5 .000 ANG.	HEAT TREAT: N / A	MODEL: 950 TITLE: ASSY, HTD BELT 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	FINISH: N / A	SHEET NO. 1 OF 1 DRAWING #
				543926-02

ITEM QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	11	100603 WASHER, FLAT 1/4ID					
2	11	103104 BEARING, FLAT .250					
3	1	543963-01 BRACKET, PULLEY ROLLER					
4	11	CSFF64 SCREW, BUTTON HEAD 1/4X.375					

2 950
 REQ'D WHERE USED

DRAWN BY: A KEY	SCALE 0 . 500	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 09 - JUL - 04	.XX	.XXX	ANG. .01 .005 .5	HEAT TREAT: N / A		
TRACED BY:	MASTER	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED			FINISH: N / A	SHEET NO: 10 OF 1	TITLE: ASSY, TABLE ROLLER DRAWING #: 543962-01

ITEM QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	102911	COVER, V ROLLER W/CIA					
2	201055-1	PROXIMITY					
3	543900-01	PLATE, TURN TABLE MOUNT					
4	543900-02	PLATE, TURN TABLE MOUNT					
5	543901-01	ASSY, GUIDE WHEEL ECCENTRIC					
6	543902-01	ASSY, GUIDE WHEEL CONCENTRIC					
7	543914-01	PLATE, TURN TABLE MOUNT SUPPORT					
8	543919-02	ASSY, STEPPER MOTOR					
9	543931-01	BRACKET, PROX MOUNT					
10	547182-01	ASSY, TURN TABLE GUIDE					

1 \$50
REV B WHERE USED

NAME #: A KEY	SCALE 0 .320	DIMENSIONAL TOLERANCES		MATERIAL: N/A	TRIM ANGLE PROJECTION		PROPRIETARY AND CONFIDENTIAL
CHECKED BY:	DATE 08 - Sep - 03	.01	.005	.005	.01	.005	PRINTED ON 08-08-03
TRACED BY:	MASTER	REMOVED ALL LAYERS AND SURFACE FINISHES	ALL LAYERS AND SURFACE FINISHES	HEAT TREAT:	N/A	N/A	MADE IN U.S.A.
		FILE SURFACES AS SHOWN	FILE SURFACES AS SHOWN	TEMP:	N/A	N/A	PRINTED IN U.S.A.

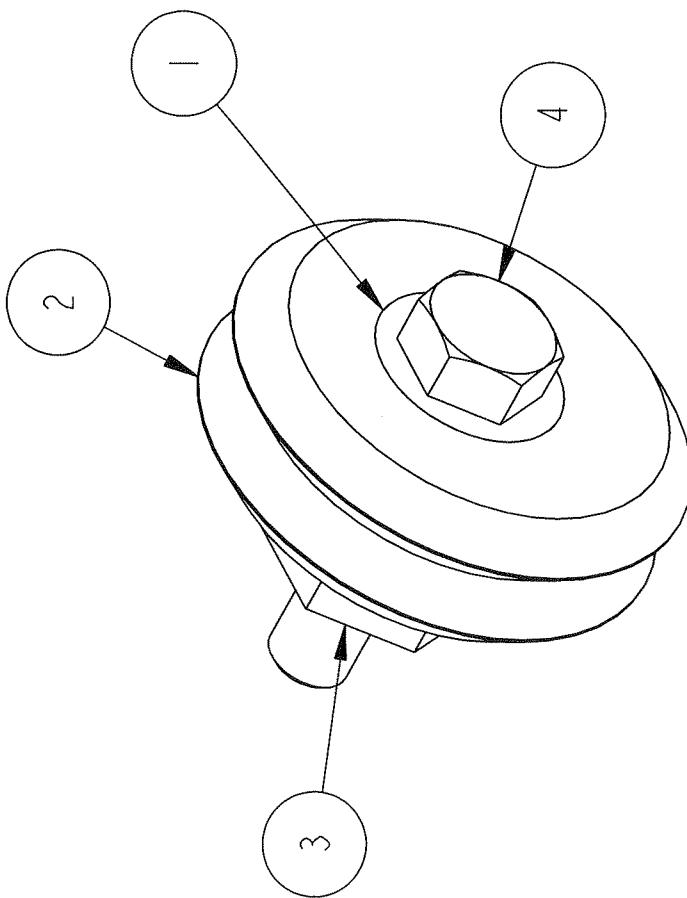
KIRK - RUDY, INC.
WOODSTOCK, GEORGIA

DRAWING #: 543994-01

ITEM QTY	PART #	DESCRIPTION	REV A6	DATE	DESCRIPTION	ECN A6	BT
1	102911	COVER, V ROLLER W/CA					
2	201055-1	PROXIMITY PLATE, TURN TABLE MOUNT					
3	543900-01	PLATE, TURN TABLE MOUNT					
4	543900-02	PLATE, TURN TABLE MOUNT					
5	1	543901-01 ASSY, GUIDE WHEEL ECCENTRIC					
6	2	543901-01 ASSY, GUIDE WHEEL CONCENTRIC					
7	1	543914-01 PLATE, TURN TABLE MOUNT SUPPORT					
8	1	543919-02 ASSY, STEPPER MOTOR					
9	1	543931-01 BRACKET, PROX. MOUNT					
10	1	547182-01 ASSY, TURN TABLE GUIDE					

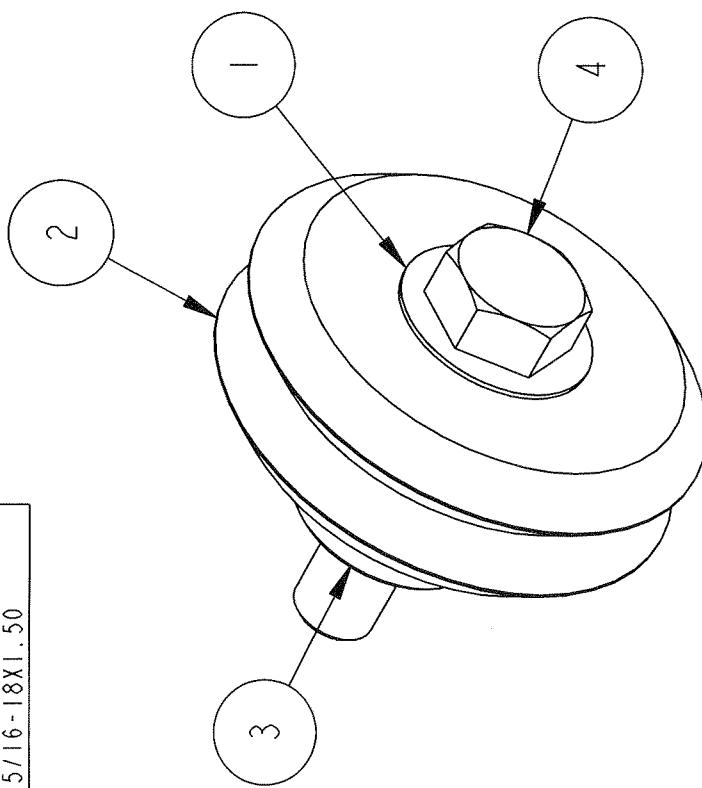
I	950	REVISION	WHERE USED
KRK	WOODSTOCK, GEORGIA		
950	ASSY, TURN TABLE DRIVE	DRAWING #	543994-01
950	MASTER	SCALE	0 .250
950	MASTER	DATE	09-Jul-04
950	MASTER	REVISION	N/A
950	MASTER	REMARKS	ALL DIMENSIONS ARE IN INCHES. FILE SHEET DRAWS ON DO NOT SCALE - MORE TO DIMENSIONS ONLY

ITEM QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	100616	WASHER, FLAT 5/16 ID .020 TK					
2	102908	WHEEL, GUIDE W3X					
3	102910	BUSHING, ADAPTER ADJ. BX3					
4	RHB052	BOLT, HEX HEAD 5/16-18X1.50					



DRAWN BY: A KEY	SCALE 1 . 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	REO'D WHERE USED I 950
CHECKED BY:	DATE 05 - Mar - 03	.xx .01 ANG. .005 .5	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	FINISH: N/A	MODEL: 950	TITLE: ASSY, GUIDE WHEEL ECCENTRIC	SHEET NO. 1 OF 1 DRAWING # 543901-01

ITEM	QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	1	100616	WASHER, FLAT 5/16 ID .020 TK					
2	1	102908	WHEEL, GUIDE W3X					
3	1	102909	BUSHING, ADAPTER STRAIGHT B3					
4	1	RHB052	BOLT, HEX HEAD 5/16-18X1.50					



DRAWN BY: A KEY	SCALE 1 . 500	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED .xx .xxx .005 .5 ANG.	MATERIAL: N/A	THIRD ANGLE PROJECTION E- -	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 05-Mar-03	HEAT TREAT: N/A	MODEL: 950	TITLE: ASSY, GUIDE WHEEL CONCENTRIC	DRAWING # 543902-01	
TRACED BY:	MASTER	FINISH: N/A	SHEET NO: 10F1			

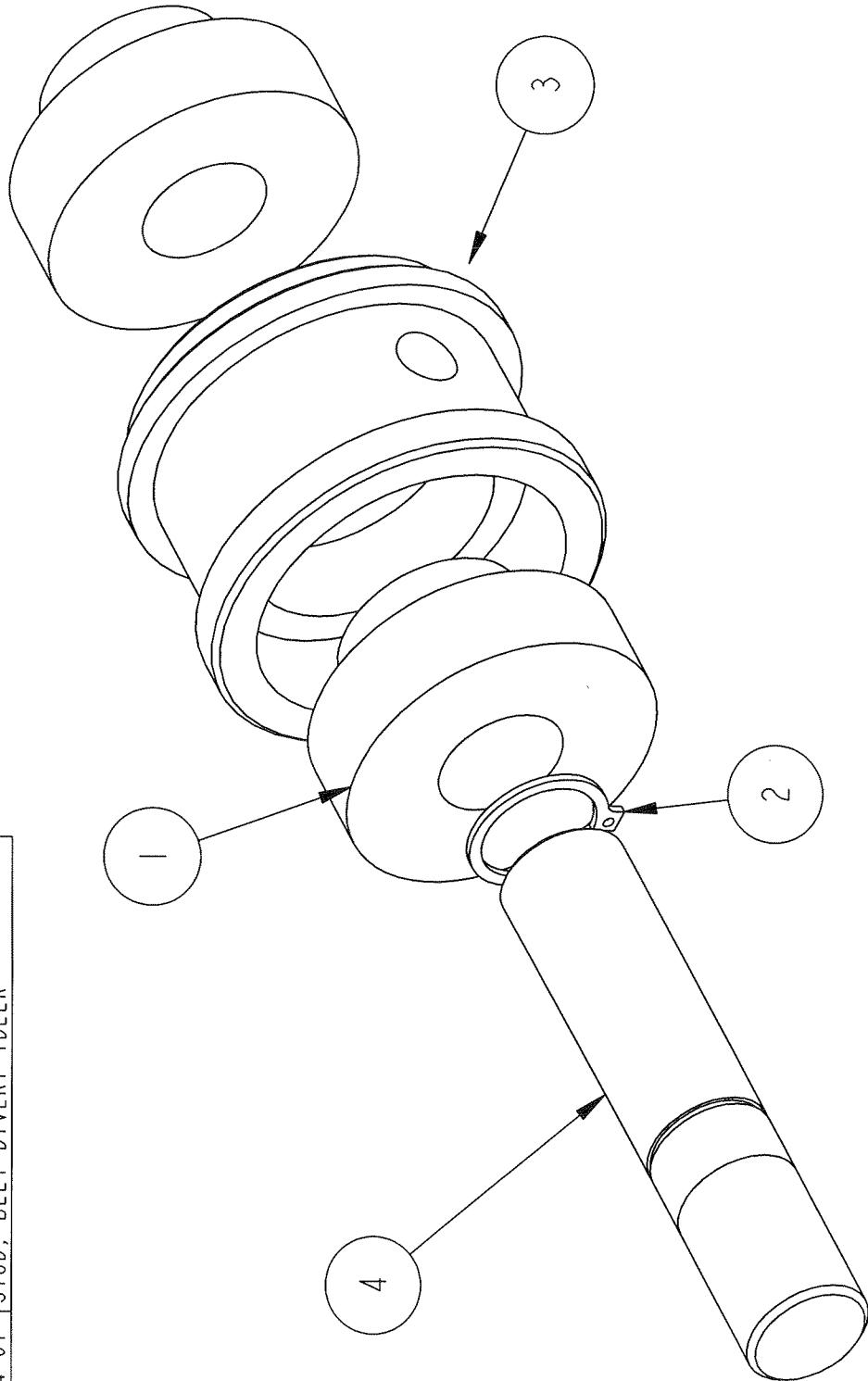
DRAWING #

543919-02

ITEM #	PART #	DESCRIPTION	REV #	DATE	ECN #	BT
1	2	100407 WASHER, THRUST TWO				
2	1	191237 REDUCER, SERVO MOTOR				
3	1	200615 MOTOR, SERVO				
4	1	543920-01 PLATE, STEPPER MOTOR MOUNT				
5	1	543921-01 PULLEY, 26-8M-20 H/D 1 1/2 BORE				
6	2	543923-01 ASSY, DIVERT ROLLER				
7	4	543930-01 SPACER, MOTOR MOUNT				
8	2	HJN016 NUT, JAM 5/8-12				

1	\$50	RECD WHERE USED
KRK KARK - RUDY, INC WOODSTOCK, GEORGIA		
ASSY, SERVO MOTOR		
DRAWING # 543919-02		
SCALE: 0 .625		
DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED		
IN IN IN IN IN IN IN		
09 - JUL - 04		
PRINTED ON 09-04-2009 BY KARK-RUDY, INC.		
ALL DIMENSIONS ARE IN INCHES. EXCEPT WHERE NOTED		
NOT SCALE DRAWINGS. WORK TO DIMENSIONS ONLY		

ITEM	QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	2	103804	BEARING, HUB .625					
2	1	104104	SNAPRING, .625					
3	1	543922-01	ROLLER, HTD DIVERT BELT					
4	1	543924-01	STUD, BELT DIVERT IDLER					



DRAWN BY: A K E Y	SCALE 1 . 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. KENNESAW, GA 30144 USA	
CHECKED BY:	DATE 02 - May - 03	.xx	.xxx	.5 ANG.	HEAT TREAT: N / A		MODEL: 950	TITLE: ASSY, DIVERT ROLLER
TRACED BY:	MASTER	REMOVE ALL BURRS, UNDERS AND EDGES, UNLESS OTHERWISE NOTED			FINISH: N / A	SHEET NO.: 10F 1	DRAWING #: 543923-01	
		ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY						

Drawing 1 547182-01

ITEM #	PART #	DESCRIPTION	REV NO.	DATE	DESCRIPTION	ECN NO.	BY
1	1	545759-01 GUIDE, PRODUCT TRANSFER					
2	1	545759-02 GUIDE, PRODUCT TRANSFER					
3	1	545759-03 GUIDE, PRODUCT TRANSFER					
4	12	541183-01 SPACER, TURN TABLE GUIDE					

REF-D WHERE USED
1 950

DRAWING #: A KEY		SCALE 0 . 375	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED		TYPICAL PROJECTION		PROPRIETARY AND CONFIDENTIAL NO FORUMS OR DISCUSSIONS MAILED TO: KIRK-RUDY INC. FROM: KIRK-RUDY INC. EX-1000, 10TH ST. WOODSTOCK, GA 30188 USA	
CHECKED #: 09 - Jul 1 - 04	DATE	.060	.060	.030	N/A	WEIGHT: 1	KIRK - RUDY INC. WOODSTOCK, GEORGIA	
TRACED BY: MASTER	TRACED BY:	REMOVED ALL BURRS, TACK OIL, FELTS, WOOL, ALL DIMENSIONS ARE FINISHED DIMENSIONS NO. NO. HALF : NONE TO DIMENSIONS ONLY		N/A	950	UNIT: ASSY , TURN TABLE GUIDE	547182-01	
				N/A	SET NO: 10F1			

ITEM #	PART #	DESCRIPTION	REV NO	DATE	QC NO	BY
1	6 107339	BOLT, HEX HEAD 5/16-18X1.25				
2	6 107348	BOLT, HEX HEAD 5/16-18X1.75				
3	3 190180	LABEL, TIMING BELT WARNING				
4	1 191298	FITTING, STRAIGHT 3/8 T 1/4 NPT				
5	1 191351	FITTING, ELBOW .315T .250NPT				
6	6 190689-1	DOOR LATCH				
7	4 538024-02	ASSY, 1 IN. LEVELING LEG 8.00 LNG				
8	1 545603-01	WIDMANT, STACKER CABINET				
9	3 545608-01	DOOR, DROPOUT CABINET				
10	1 545610-01	CHANNEL, REMOVABLE END				
11	6 545158-01	BRACKET, CONVEYOR MOUNT				
12	1 547220-01	COVER, HYDRAULIFT				
13	3 547228-01	COVER, CONVEYOR PLUG				
14	1 547229-01	BLOCK, AIR MANIFOLD				
15	1 547456-01	WIDMANT, CONVEYOR MOUNT				
16	1 547463-02	ASSY, HORIZONTAL ADJUSTMENT				
17	1 547537-01	KIT, 950 1000LB HYDRAULIFT				
18	1 547923-02	ASSY, FLEX CABLE STRAIN RELIEF				

RED D WHERE USED

3 550

PRINTED ON: 01-FEB-06

PRINTED BY: MASTER

SCALE: 0.071

KEY: A

REVISIONS:

1. DIMENSION OR OTHERWISE NOTED

IN	MM
.065	1.65
.5	12.7

2. REAR TRAIL: N/A

3. REMOVE ALL BURRS AND SHOTBLAST ALL METAL SURFACES

4. ALL ASSEMBLIES ARE TO BE PAINTED OR OILED

5. DO NOT SCALE, WORK TO DIMENSIONS ONLY

6. KIRK - RUDY, INC.
WOODSTOCK, GEORGIA
30188 USA

7. 950 ASSY, ADJUSTABLE OUTFEED CONVEYOR

8. 545602-01

ITEM	CITY	PART #	DESCRIPTION	REV	NO	DATE	DESCRIPTION	ECN	BY
1	2	190188	LABEL, VOLTAGE WARNING LARGE						
2	1	190195	LABEL, 220 VOLTS						
3	1	191337	FITTING, ELBOW 1/8 NPT 1/4 TUBE						
4	2	208503	FAN, SUION SP100A						
5	2	190589-1	DOOR LATCH						
6	6	200491-2	CONNECTOR, PHOENIX						
7	2	208504-1	ASSY FILTER/FINGER GUARD						
8	1	530441-06	BOX, ELECTRICAL INLET 30A						
9	1	545614-01	W/DNNT, CONTROL BOX						
10	1	547187-01	ASSY, STACKER CONTROL PANEL						
11	1	547200-01	PANEL, ELECTRICAL						
12	1	547201-02	ASSY, AIR REGULATOR						
13	1	547236-01	ASSY, AIR MANIFOLD						
14	1	547239-01	BRACKET, PHOENIX CONNECTOR						
15	1	547453-01	W/DNNT, LH ELECTRICAL DOOR						
16	1	547454-01	W/DNNT, RH ELECTRICAL DOOR						
17	4	CSFF56	SCREW, BUTTON HEAD #10-32X.250						

I	XXX	RECD	WHERE ISSUED
K	KIRK - RUDY, INC.	WOODSTOCK, GEORGIA	
950	950	950	950
MASTER	N/A	N/A	N/A

SCALE:	0	1	5	6	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	MATERIAL:	N/A	TECHNICAL PROJECTION PROPRIETARY AND CONFIDENTIAL AND IS THE PROPERTY OF KIRK-RUDY, INC. IT IS TO BE KEPT SECURELY MAINTAINED AND IS NOT TO BE COPIED IN ANY FORM WITHOUT THE EXPRESS WRITTEN CONSENT OF KIRK-RUDY, INC. WOODSTOCK, GA 30088 USA
CHECKED BY:	DATE:	09	-	JUL	-	04	N/A	PRINTED, ALL BURNS AND OTHER DEFECTS ARE HIGHLIGHTED. FINISHES, DIMENSIONS AND TOLERANCES ARE TO SCALE. WORK TO DIMENSIONS ONLY
TRACED BY:	MASTER							

1	XXX	RECD	WHERE ISSUED
K	KIRK - RUDY, INC.	WOODSTOCK, GEORGIA	

DRAWING #

547187-01

ITEM #	PART #	DESCRIPTION	REV. NO.	DATE	DESCRIPTION	REV. NO.	DATE
1	1	BUSHING. FL1.000101.25000.75016					
2	2	SHIM. 5/16 X 5/8 X 1/16					
3	4	SCREW. BUTTON HEAD 10-32X .250					
4	4	SCREW. BUTTON HEAD 1/4X .625					
5	4	SCREW. SHCS 1/4-20X .750					
6	2	HANDLE					
7	6	PLATE, CUSTOM LABEL					
8	1	CONSOLE. TOUCH SCREEN					
9	2	KNOB. POT					
10	1	HANDLE - RELEASE					
11	1	201124-2 BUTTON. START					
12	1	201124-4 BUTTON. POWER ON					
13	1	201125-3 BUTTON. STOP					
14	1	201125-5 BUTTON. POWER OFF					
15	2	201126-1 BUTTON. JOG					
16	1	547189-01 PANEL. STACKER CONTROL					
17	1	547191-01 GLIDE. CONTROL ARM					
18	1	WLDNNT. CONTROL PANEL TUBE					
19	2	547194-01 SHAFT. CONTROL ARM PIVOT					
20	1	547195-01 PLATE. BOTTOM PIVOT CLAMP					
21	1	547196-01 PLATE. TOP PIVOT					
22	1	547197-01 PLATE. TOP PIVOT MOUNT					
23	1	547198-01 SHAFT. KNOB SPACER					
24	1	547202-01 WLDNNT. CONTROL PANEL					
25	2	547222-04 BAR. FRAME SUPPORT					
26	2	CS00320 SCREW. SHCS 5/16-8X .750					

REF'D. WHERE USED	1	950
KIRK - RUDY, INC		
WOODSTOCK, GEORGIA		
ASSY. STACKER CONTROL PANEL		
DRAWING # 547187-01		

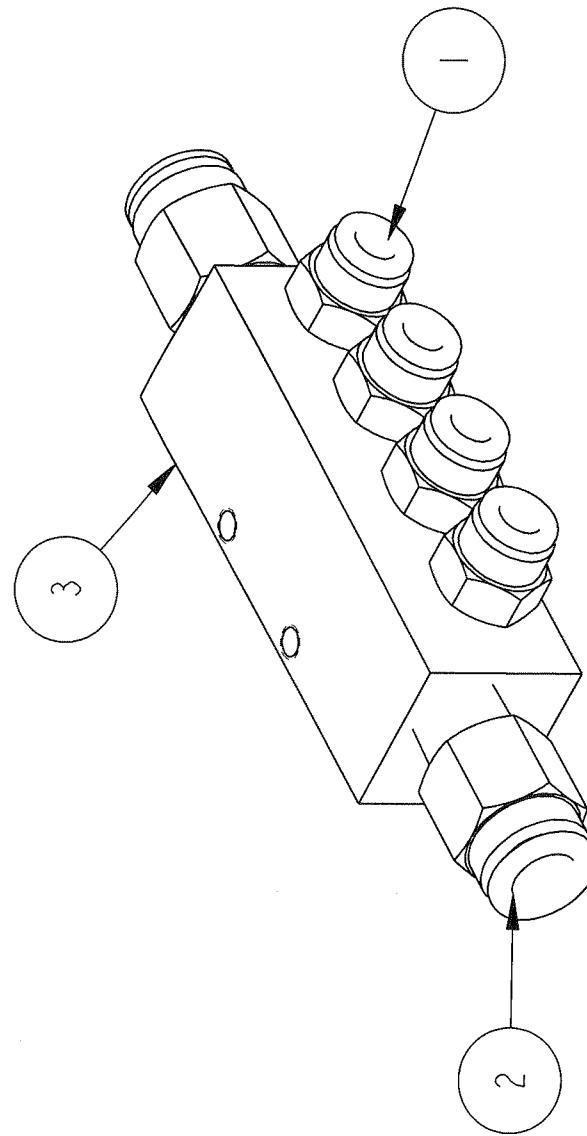
SCALE:	A KEY	0 .400	DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED	N/A	THIS DRAWING IS FOR INFORMATIONAL PURPOSES ONLY AND MAY BE QUOTED OR REFERENCED FOR THE DESIGN OF THIS PART. IT IS NOT A DRAWING FOR MANUFACTURE. IT IS THE PROPERTY OF KIRK-RUDY, INC., WOODSTOCK, GA 30188 U.S.A.
CHECKED BY:			REVIEWED FOR CORRECTNESS AND UNLESS OTHERWISE NOTED	N/A	
TRACED BY:		05 - 0 c t - 0 5	ALL DIMENSIONS ARE INCHES UNLESS OTHERWISE NOTED	N/A	SCALE: 1 OF 1

ITEM QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	109544	NIPPLE, 1/4 NPT AIR GUN					
2	190606	FITTING - 90 DEG 1/4 NPT					
3	191344	FITTING, 1/4 NPT 3/8 TUBE ELBOW					
4	2 191353	BRACKET, AIR REGULATOR MOUNT					
5	1 191393	MUFFLER, 1/4 NPT					
6	1 191299-1	FILTER, AIR					
7	1 191300-1	REGULATOR, AIR					
8	1 191303-1	VALVE, AIR SAFETY					

1 950
REO 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. WOODSTOCK, GA 30188 USA
CHECKED BY:	DATE 07-JUL-05	.XX	.XXX	ANG. .01 .005 .5	HEAT TREAT:	N/A	KIRK - RUDY, INC. WOODSTOCK, GEORGIA
TRACED BY:	MASTER	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED		FINISH:	N/A	SHEET NO. 1 OF 1	TITLE: ASSY, AIR REGULATOR DRAWING # 547201-02

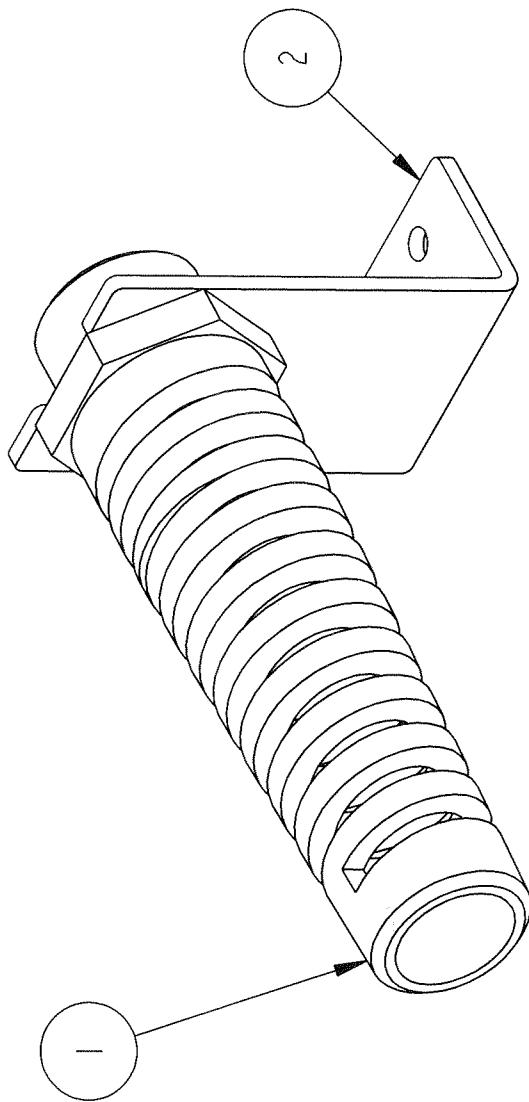
ITEM QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	4	191296 FITTING, STRAIGHT 1/4 T 1/8 NPT					
2	2	191298 FITTING, STRAIGHT 3/8 T 1/4 NPT					
3	1	543970-02 BLOCK, AIR MANIFOLD					



DRAWN BY: A KEY	SCALE 1 . 000	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED			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
CHECKED BY:	DATE 28 - Feb - 05	.xx	.xxx	ANG.	HEAT TREAT: N / A	KIRK - RUDY, INC., KENNESAW, GEORGIA
TRACED BY:	MASTER	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY			MODEL: 950	TITLE: ASSY, AIR MANIFOLD
					SHEET NO.: 1 OF 1	DRAWING #: 547236-01

ITEM QTY	PART #	DESCRIPTION
1	191433	STRAIN RELIEF, FLEX CABLE
2	547924-02	BRACKET, STRAIN RELIEF MNT

REV NO	DATE	DESCRIPTION	ECN NO	BY

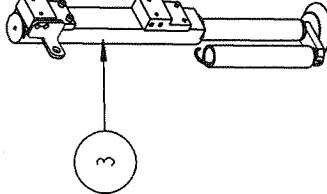
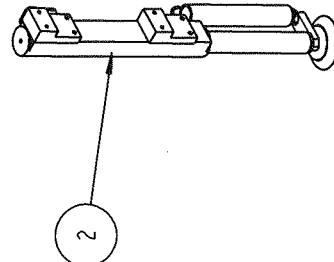
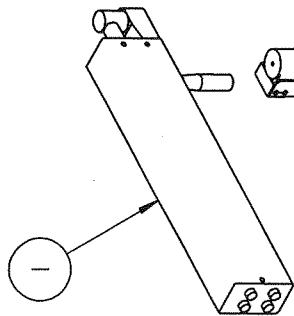


1	950	
RECD	WHERE USED	
<p>PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE QUOTED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC. WOODSTOCK, GEORGIA</p> <p>KR KIRK - RUDY, INC. WOODSTOCK, GEORGIA</p>		
<p>THIRD ANGLE PROJECTION</p> <p>(+)</p>		
MATERIAL:	N/A	
DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED		
XX	.005	ANG.
.01		
HEAT TREAT:		
N/A		
DATE:	23-Jan-06	
REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED		
ALL DIMENSIONS ARE IN INCHES UNLESS NOTED		
FINISH:	N/A	
MASTER:	OF 1	
DO NOT SCALE - WORK TO DIMENSIONS ONLY		
TITLE: ASSY, FLEX CABLE STRAIN RELIEF		
SHEET NO.	DRAWING #	
547923-02		

DRAWING 8

547537-01

ITEM	QTY	PART #	DESCRIPTION
1	1	191032-01	PUMP, MOVOTEC PB4615FC
2	2	541179-02	ASSY, RH HYDRAULIFT LEG 1000LB
3	2	541180-02	ASSY, LH HYDRAULIFT LEG



REV NO	DATE	DESCRIPTION	ECN NO	BY
SINGLE PROJECTION				
REF'D WHERE USED				
1		KIRK - RUDY, INC. WOODSTOCK, GEORGIA	950	
TITLE:				
KIT, 950 1000LB HYDRAULIFT				
DRAWING #				
OF 3				

4475337-0 |
LIFT

1

.EQD WHE

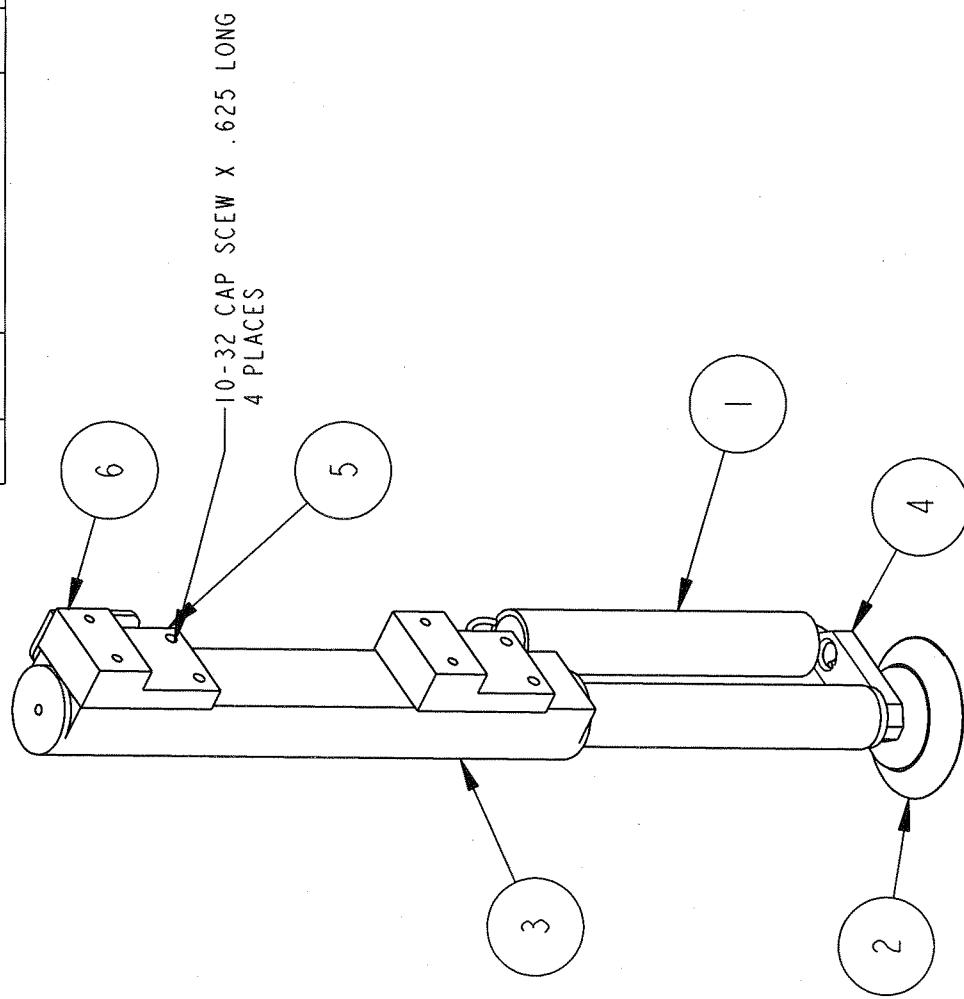
KIRK-RUDY INC.
WOODSTOCK, GEORGIA

KIT: 950 1000L B HYDRAULIC

547537-01

DRAWN BY: A KEY	SCALE 0 . 125	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 9 - Aug - 05	.01	.005	ANG. HEAT TREAT.	MODEL: 950	TITLE: KIT, 950
TRACED BY:	MASTER	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED		FINISH: N/A	SHEET NO.: 1 OF 3	DRAWING #: E

ITEM QTY	PART #	DESCRIPTION
1	102792	SPRING, EXTENSION
2	191029-3	GLIDE, SUSPA
3	191032-02	CYLINDER, LIFT CB615 1000LB
4	1	537371-01 BRACKET, SPRING RETURN MOUNT
5	2	537596-04 BLOCK, HYDRAULIC LIFT LH
6	1	537597-04 BRACKET, HYDRAULIC LIFT SPRING



REV NO	DATE	DESCRIPTION	ECN NO	BY

REF ID	WHERE USED
2	950



KIRK - RUDY, INC.
WOODSTOCK, GEORGIA

541179-02

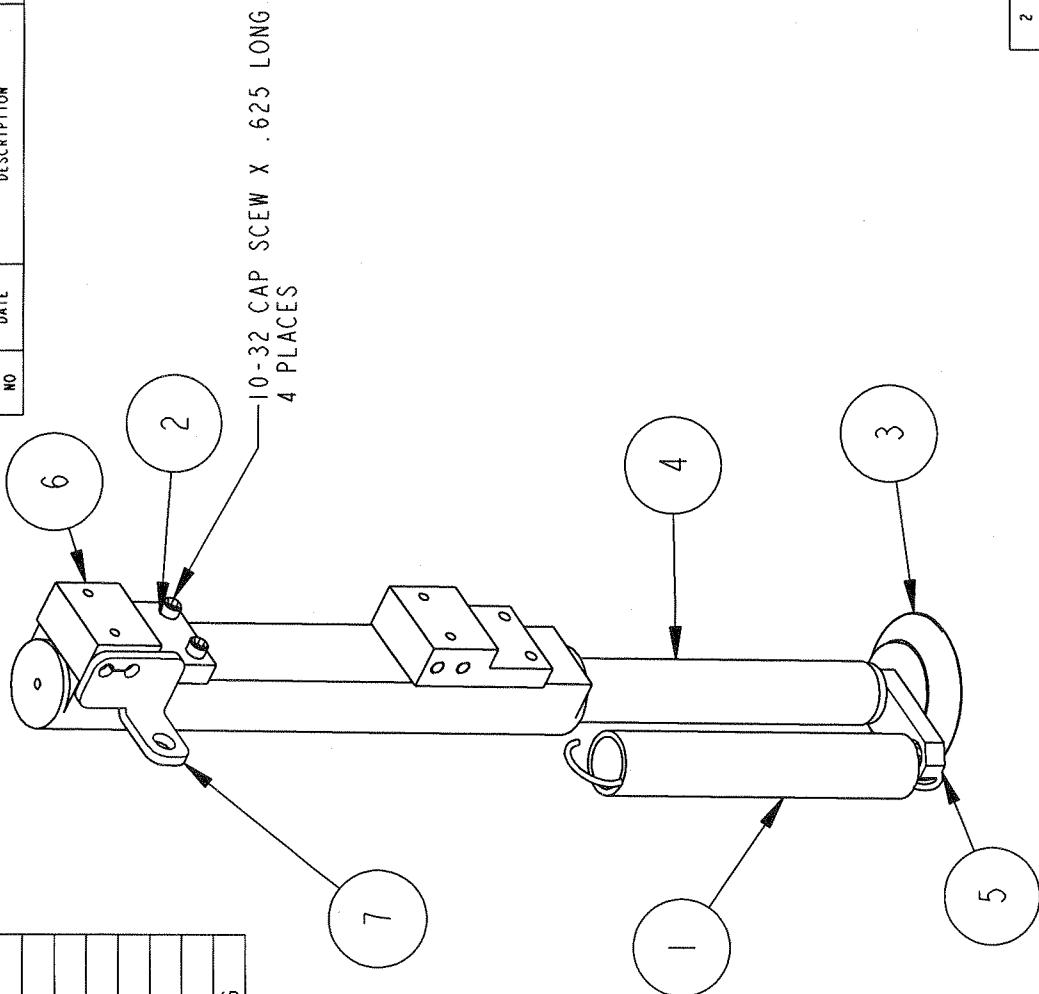


PROPRIETARY AND CONFIDENTIAL
NO PORTION OF THIS DRAWING
MAY BE QUOTED OR REPRODUCED
IN ANY FORM WITHOUT THE
EXPRESS WRITTEN PERMISSION
OF KIRK-RUDY, INC.
WOODSTOCK, GA 30188 USA

title:
ASSY, RH HYDRAULIFT LEG 1000LB
DRAWING #:
541179-02

DRAWN BY:	SCALE	0 . 375	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	MATERIAL:		
				.01	.005	.5
CHECKED BY:	DATE	19 - Aug - 05	REMOVE ALL BURS AND SHARP EDGES UNLESS OTHERWISE NOTED	N / A	HEAT TREAT:	
TRACED BY:	MASTER		ALL DIMENSIONS ARE IN INCHES	N / A	TIME:	
			DO NOT SCALE - WORK TO DIMENSIONS ONLY	N / A	SHEET NO:	10F1

ITEM QTY	PART #	DESCRIPTION
1	102792	SPRING, EXTENSION
2	107429	SCREW, SHCS 10-32X .625
3	191029-3	GLIDE, SUSPA
4	191032-02	CYLINDER, LIFT CB615 1000LB
5	537371-01	BRACKET, SPRING RETURN MOUNT
6	537596-03	BLOCK, HYDRAULIC LIFT LH
7	537597-03	BRACKET, HYDRAULIC LIFT SPRING



REV NO	DATE	DESCRIPTION	ECN NO	BY

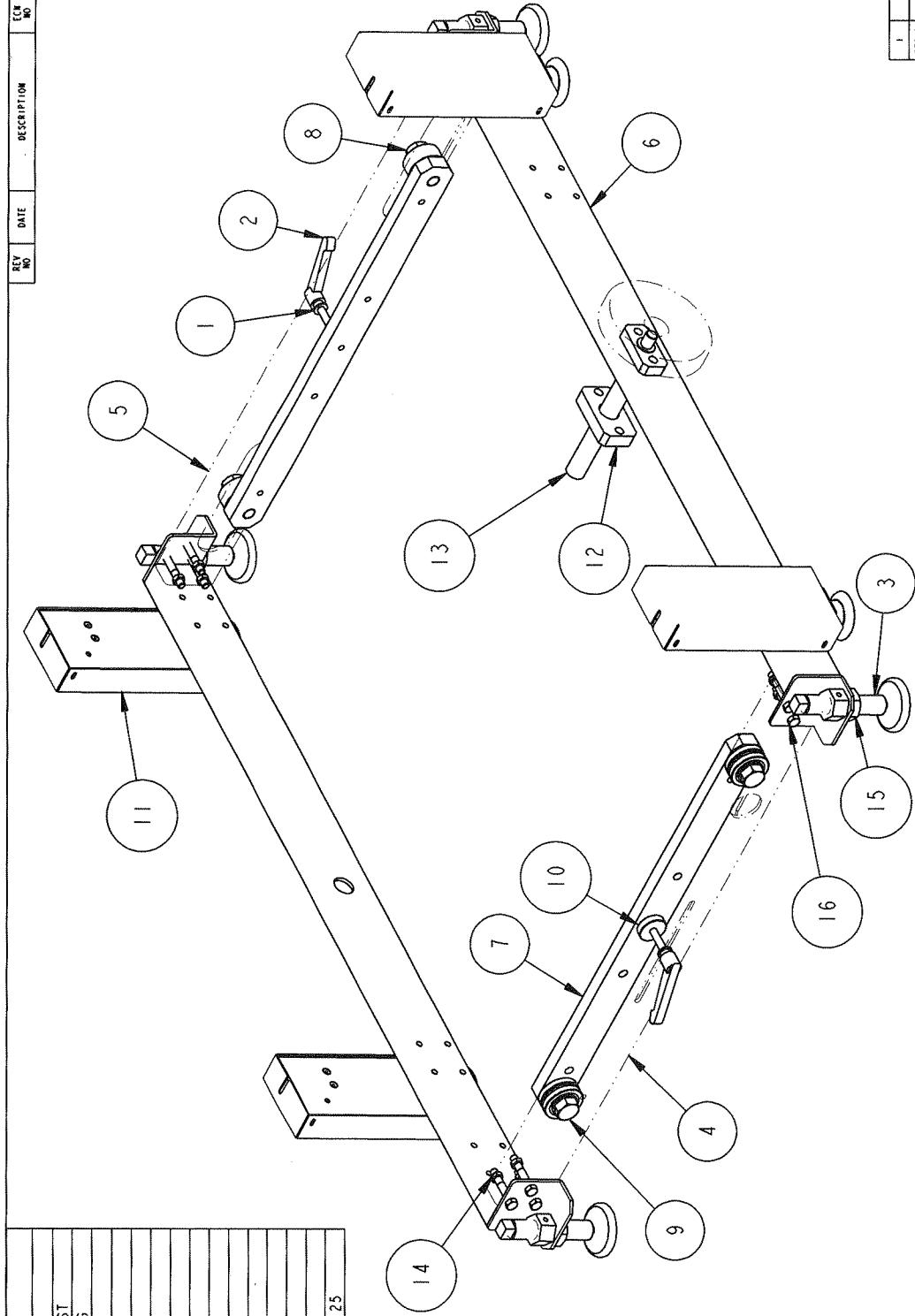
2	950
REF'D	WHERE USED

DRAWN BY: A KEY	SCALE 0 .375	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	MATERIAL: N/A	THIRD ANGLE PROJECTION 	PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE QUOTED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC. WOODSTOCK, GA 30188 USA	
					DATE 19-AUG-05	ANG. .01 .005 .5 HEAT TREAT: N/A
CHECKED BY:		REMOVE ALL BURS AND SHARP EDGES UNLESS OTHERWISE NOTED		MODEL: 950	TITLE: ASSY, LH HYDRAULIFT LEG	SHEET NO. OF 1
TRACED BY:		ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE WORK TO DIMENSIONS ONLY				
MASTER						

2	950
REF'D	WHERE USED

2	950
REF'D	WHERE USED

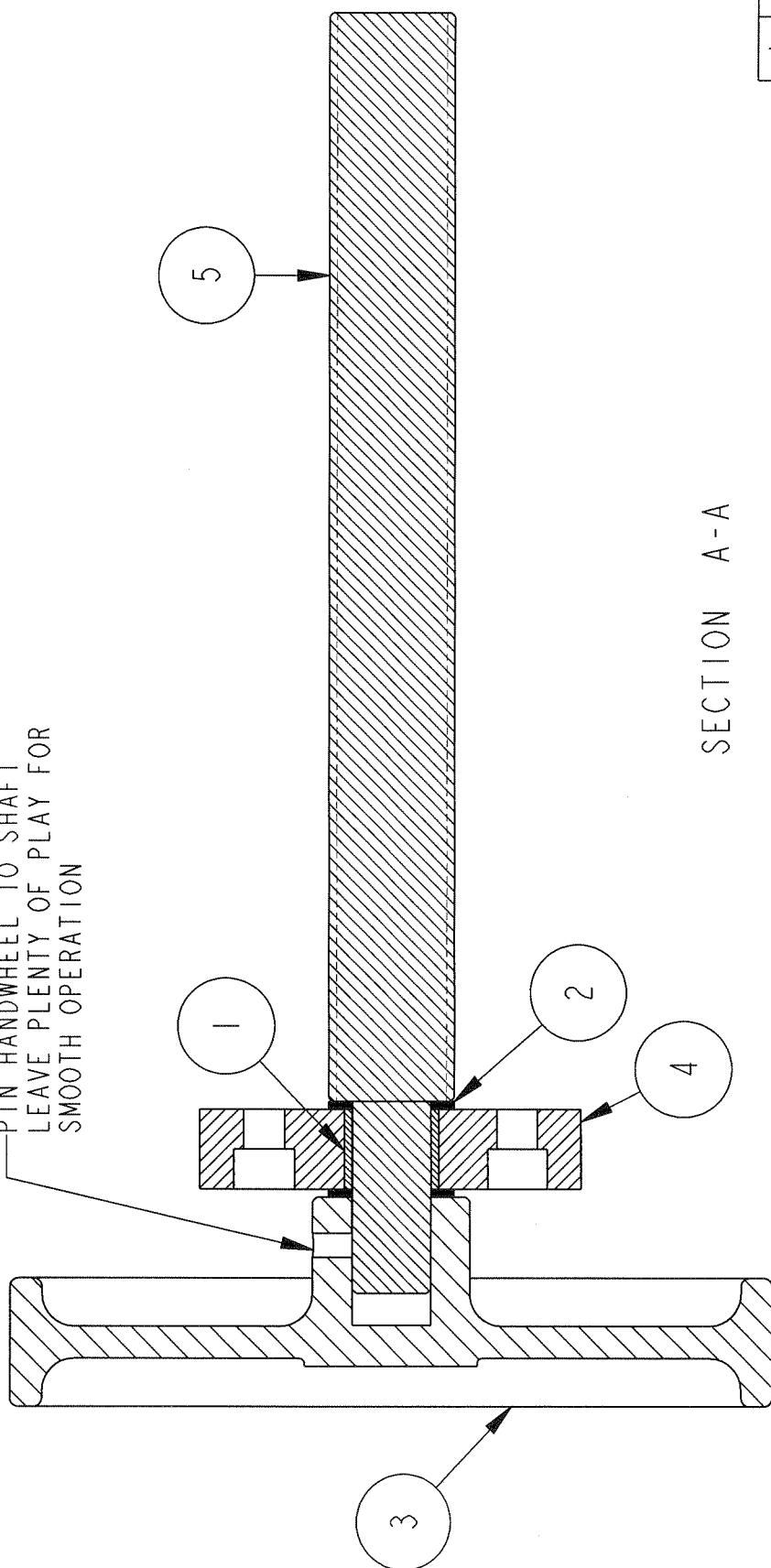
ITEM / QTY	PART #	DESCRIPTION
1	2	100402 WASHER, THRUST BB612
2	2	191361 KNOB, 3/8-.16 QUICK ADJUST
3	4	538024-01 ASSY, 1 IN. LEVELING LEG
4	1	547464-01 TUBE, FRONT MOUNT
5	1	547464-02 TUBE, SIDE MOUNT
6	2	547466-02 WDMMT, SIDE TUBE MOUNT
7	2	547468-01 PLATE, ADJUSTMENT MOUNT
8	2	547507-01 ASSY, ADJUST ROLLER
9	2	547507-02 ASSY, ADJUST ROLLER
10	1	547510-01 SPACER, HANDLE ADJUST
11	4	547513-01 ASSY, HYDRAULIC LEG
12	1	547517-02 BLOCK, SCREW CAPTURE
13	1	547518-02 ASSY, HANDWHEEL
14	12	HJN012 NUT, JAM 3/8-16
15	1	HJN019 NUT, JAM 1-8
16	12	RHB85 BOLT, HEX HEAD 3/8-16X2.25



RECD BY:	DATE:	DESCRIPTION:	QTY:	FCN NO:
I	XIX			
REC'D WHERE USED				
KR	KIRK-RUDY, INC.			
	WOODSTOCK, GEORGIA			
TOP HALF PROJECTION PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE COPIED OR REPRODUCED EXCEPT WITH PRIOR WRITTEN PERMISSION KIRK-RUDY, INC. WOODSTOCK, GA 30092 USA				
REF ID: A KEY	SCALE: 0.188	UNLESS OTHERWISE NOTED: INCHES OR MILLIMETERS INCHES	N/A	
CHECKED BY:	DATE: 08-Feb-05	ALL BODIES AND SPRING COILS UNLESS OTHERWISE NOTED	N/A	
TRACED BY:	MASTER	ALL DIMENSIONS ARE FLAT SURFACES STATED NO. NO. SCALLOP WORK TO DIMENSIONS ON	N/A	
		SAY IN INCHES	TOP 1	547463-02

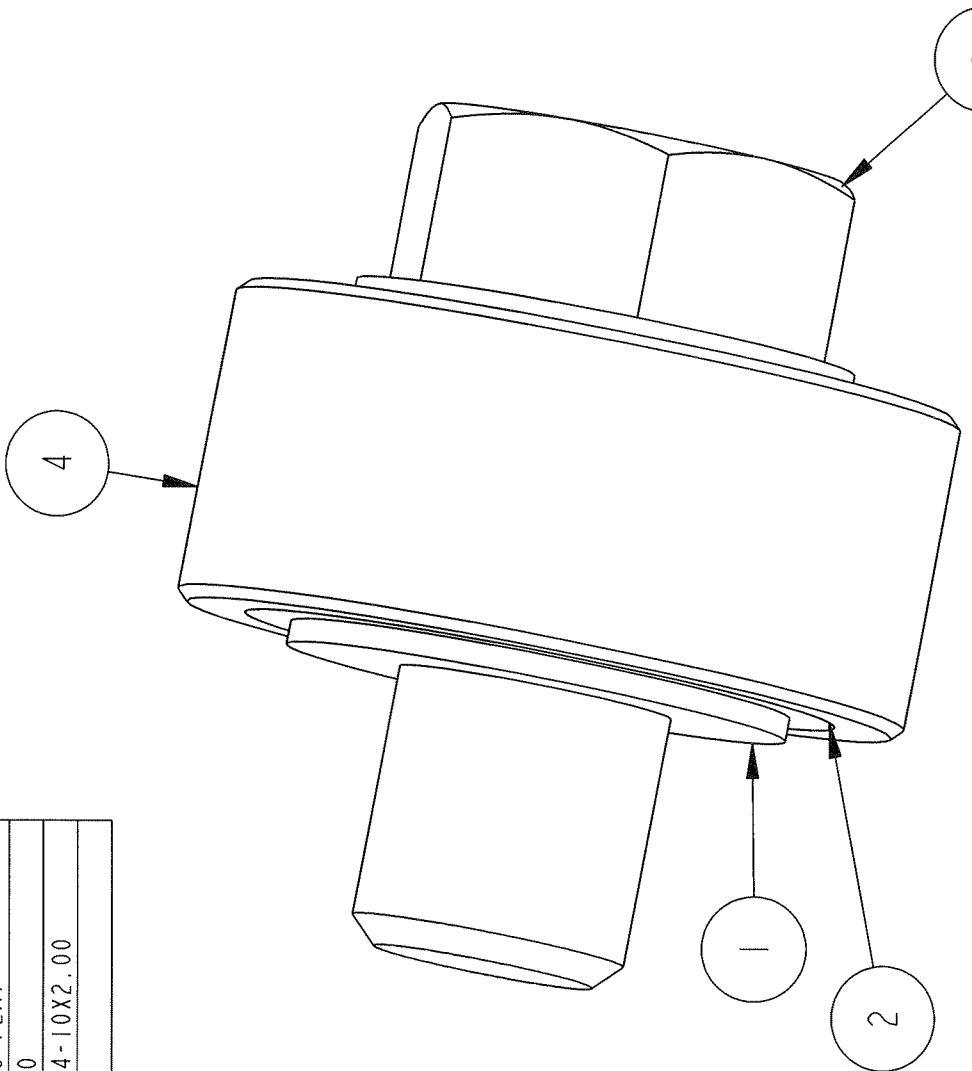
ITEM QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	100144	BUSHING, SL. 6251D.7500D.6251G					
2	2	100407 WASHER, THRUST TW62					
3	1	102108-4 HANDWHEEL, CLUTCH BEARING					
4	1	547511-02 BLOCK, THREADED ROD MOUNT					
5	1	547512-02 SHAFT, THREADED ADJUSTMENT					

PIN HANDWHEEL TO SHAFT
LEAVE PLENTY OF PLAY FOR
SMOOTH OPERATION



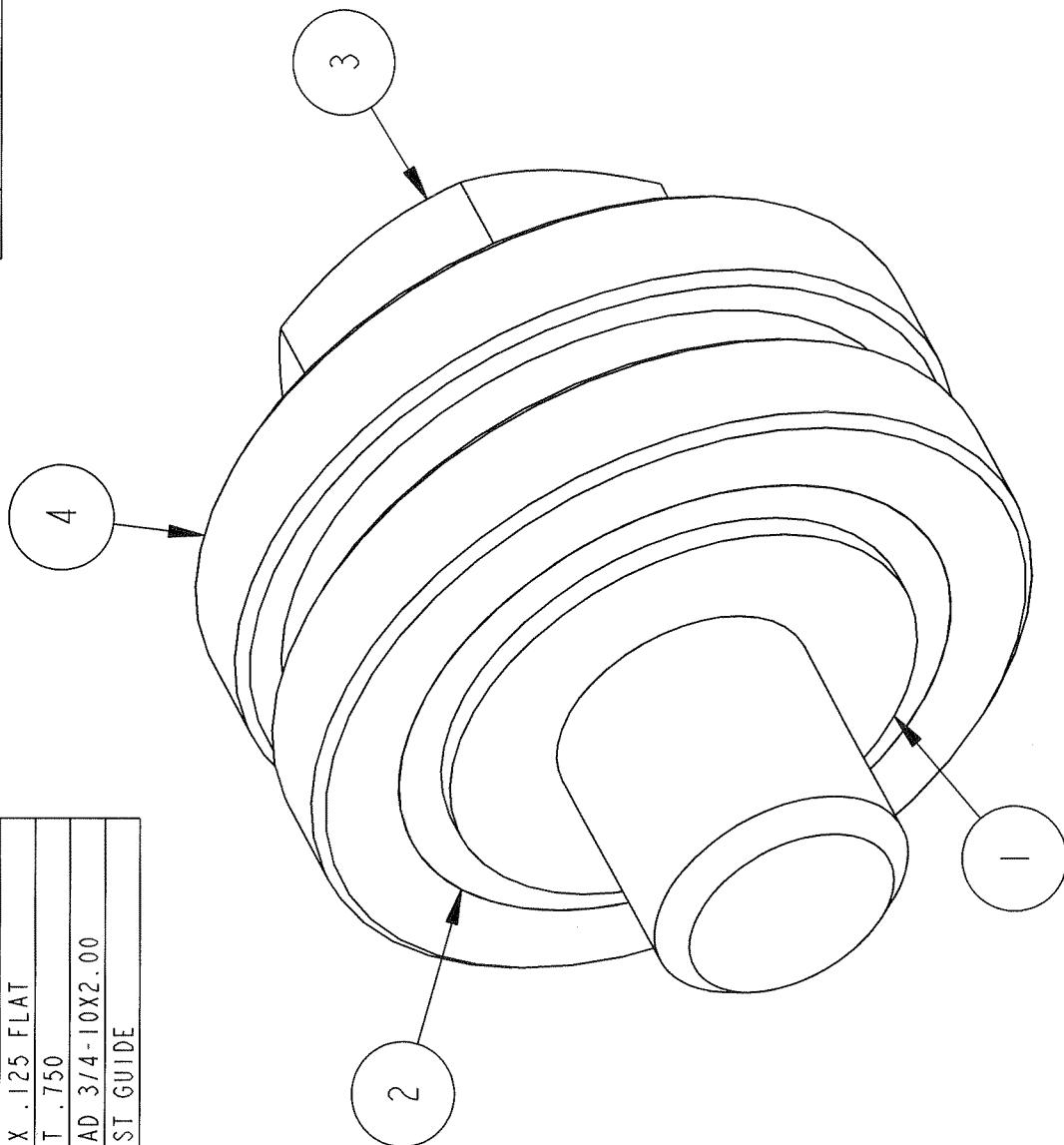
DRAWN BY:	A KE Y	SCALE	0 . 750	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	MATERIAL: N/A	THIRD ANGLE PROJECTION	PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE QUOTED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC.
CHECKED BY:		DATE	08-Feb-05	.xx .xxx .005 .5	ANG. HEAT TREAT: N/A		KIRK - RUDY, INC. KENNESAW, GEORGIA
TRACED BY:	MASTER			REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED	FINISH: N/A	MODEL: 950	KENNESAW, GA 30144 USA
				ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY		SHEET NO: 10F1	TITLE: ASSY, HANDWHEEL DRAWING #: 547518-02

ITEM	QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	2	100633	WASHER, 750 X .125 FLAT					
2	2	103112	BEARING, FLAT .750					
3	1	104415	BOLT, HEX HEAD 3/4-10X2.00					
4	1	547509-01	ROLLER, ADJUST					



DRAWN BY: A KEY	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. KR KIRK - RUDY, INC. KENNESAW, GEORGIA
CHECKED BY:	DATE 08-Feb-05	.xx .xxx .005 .5 ANG.	HEAT TREAT: N/A	MODEL: 950	TITLE: ASSY, ADJUST ROLLER
TRACED BY:	MASTER	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE TO DIMENSIONS ONLY	FINISH: N/A	SHEET NO.: 1 OF 1	DRAWING #: 547507-01
				2	950 REOD WHERE USED

ITEM QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1 2	100633	WASHER, 750 X .125 FLAT					
2 2	103112	BEARING, FLAT .750					
3 1	104415	BOLT, HEX HEAD 3/4-10X2.00					
4 1	547509-02	ROLLER, ADJUST GUIDE					



DRAWN BY:	A KEY	SCALE	2.000	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	MATERIAL:	N/A	THIRD ANGLE PROJECTION	KIRK - RUDY - NC. KENNESAW, GEORGIA	2	950
CHECKED BY:		DATE	08-Feb-05	.xx .xxx ANG.	HEAT TREAT:	N/A			RECD WHERE USED	
TRACED BY:	MASTER	FINISH:	N/A	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED	ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY	MODEL: 950	TITLE: ASSY, ADJUST ROLLER	DRAWING #	547507-02	
							SHEET NO: 10F			

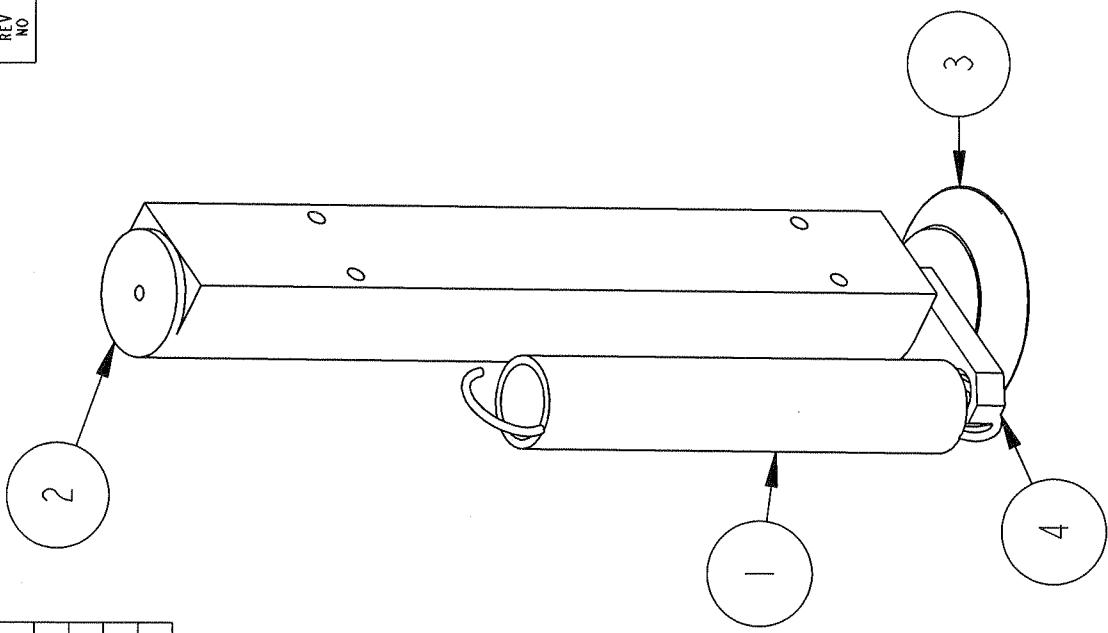
ITEM QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	1	539425-03 ASSY, HYDRALIFT LEG					
2	1	547514-01 PLATE, HYDRALIFT LEG MOUNT					
3	1	547515-01 COVER, HYDRALIFT LEG					
4	1	CSDD322 SCREW, SHCS 5/16-18X1.000					
5	4	CSEE253 SCREW, FLATHEAD 10-32X.375					
6	1	HMSN13 NUT, HEX 5/16-18					

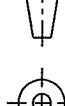
1 XXX
REV D WHERE USED

1 ASSY, HYDRALIFT LEG
DRAWING # 547513-01

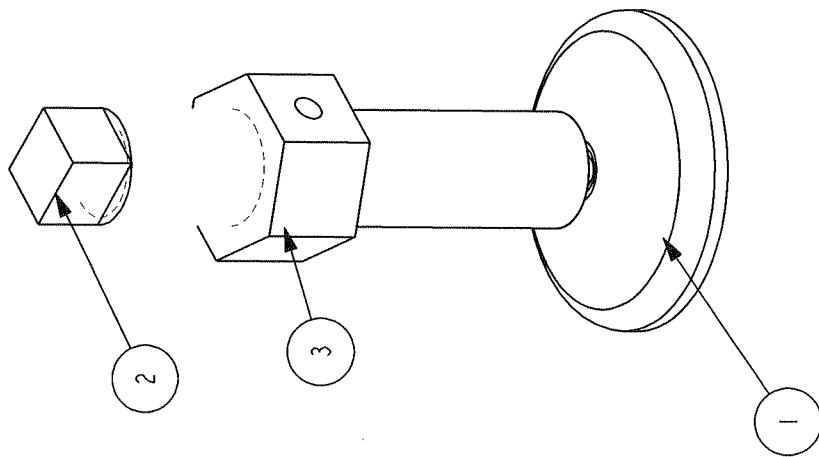
DRAWN BY: A KEY		SCALE 0 . 500	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED		MATERIAL: N/A	THIRD ANGLE PROJECTION		PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE QUOTED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC. KENNESAW, GA 30144 USA		
CHECKED BY: 08-Feb-05		DATE	.xx	.xxx	ANG. .01 .005 .5	HEAT TREAT: N/A			MODEL: 950 TITLE: ASSY, HYDRALIFT LEG	
TRACED BY: MASTER		MATERIAL	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED		FINISH: N/A		SHEET NO: 10 OF 1	DRAWING #		

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



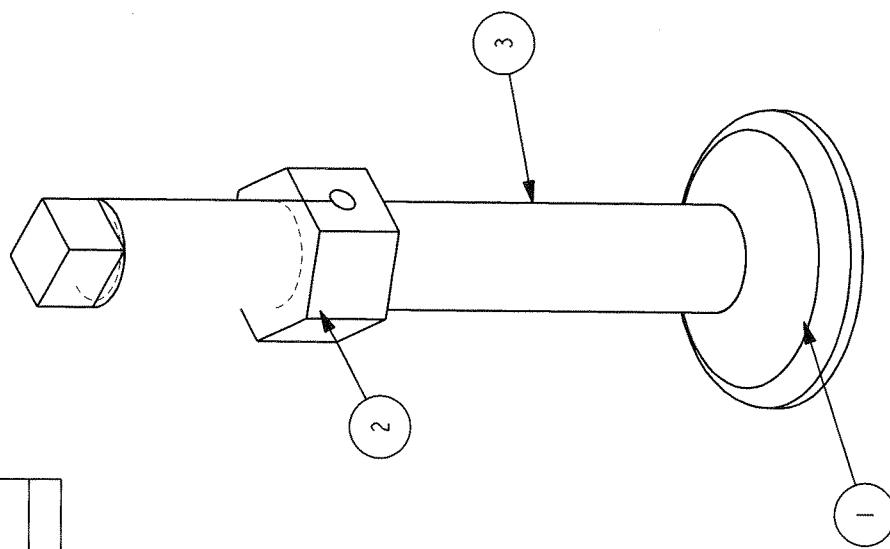
2	SP84700
RECD	WHERE USED
 KIRK - RUDY, INC. KENNESAW, GEORGIA	
PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE QUOTED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC. KENNESAW, GA 30144 USA	
THIRD ANGLE PROJECTION	
MATERIAL:	N / A
DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	
.XX .XXX .005 .5	ANG.
HEAT TREAT:	N / A
 REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED	
FINISHES:	N / A
MASTER	SHEET NO. 1 OF 1
TRACED BY:	DRAWING #
CHECKED BY:	TITLE: ASSY, HYDRAULIFT LEG
DRAWN BY:	539425-03
SCALE: 0 .500	DATE: 08-FEB-05

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



						<input checked="" type="checkbox"/> GENERAL <small>REO D WHERE USED</small>	
DRAWN BY: A Y B	SCALE 0 . 625	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED		MATERIAL: N / A	THRO 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. KIRK-RUDY, INC. KENNESAW, GEORGIA	
CHECKED BY: 	DATE 16 - NOV - 99	.01	.005	HEAT TREAT: N / A		KENNESAW, GA 3044 USA	
TRACED BY: MASTER		.005 ANG.		FINISH: ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY	MODEL: GENERAL	TITLE: ASSY, 1 IN. LEVELLING LEG	
				SHEET NO.: 10 OF 1	DRAWING #: 538024-01		

ITEM QTY	PART #	DESCRIPTION
1	190634	FOOT, MOUNTING
2	190111	NUT, CABINET LEVELING
3	191010-3	LEVELING BOLT, CABINET



REV NO	DATE	DESCRIPTION	ECN NO	BY

4	950	
RECD	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
THIRD ANGLE PROJECTION		
MATERIAL:	N / A	
DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED		
XX - XXX	ANG.	
.01	.05	.5
HEAT TREAT:	N / A	
DATE	05-00-05	
SCALE	0 . 6 2 5	
DRAWN BY: A KEY		
CHECKED BY:		
TRACED BY:		
SHEET NO:	1 OF 1	DRAWING #
		538024-02

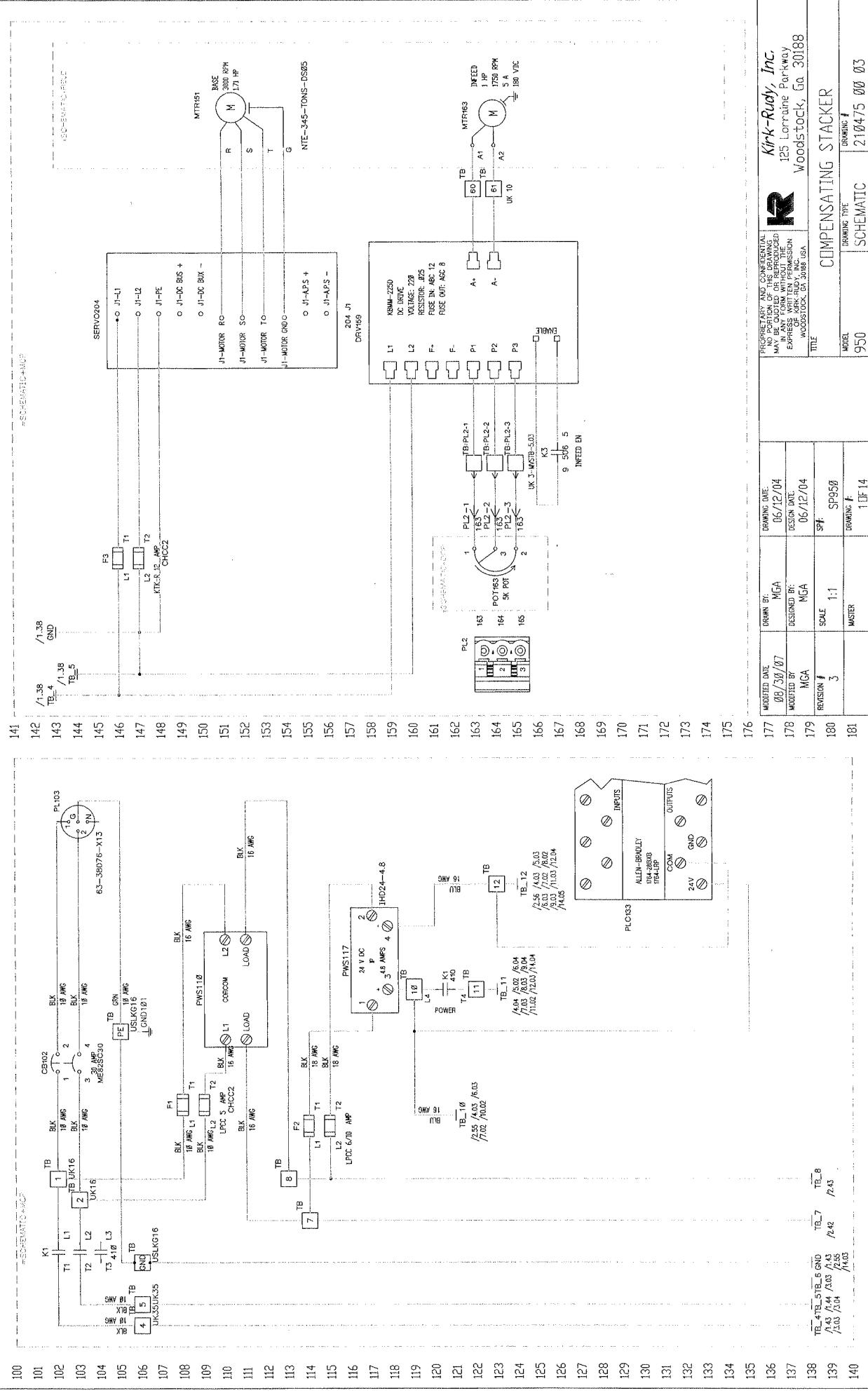
9 ELECTRICAL SCHEMATICS AND PARTS

9.1 SCHEMATIC LIST

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

Reference schematic number: 210475 00 01

9.2 ELECTRICAL PARTS LIST



Kirk-Rudy, Inc.
125 Lorraine Parkway
Woodstock, Ga. 30188

KR

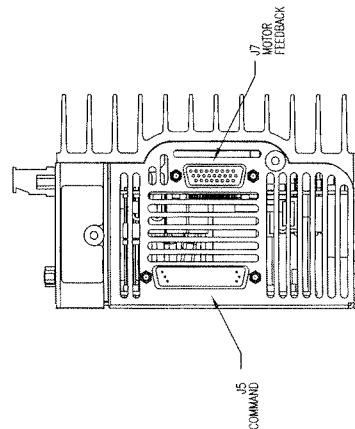
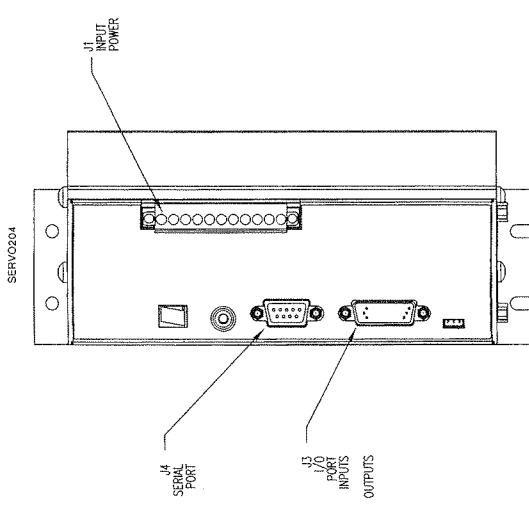
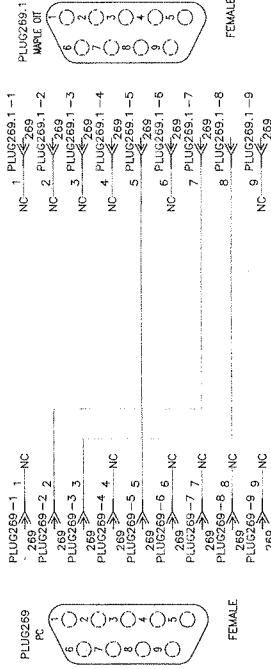
COMPENSATING STACKER

Model:	950	Drawing No.:	11F14
Drawing Date:	06/12/04	Design Date:	06/12/04
Modified By:	MGA	Revised By:	MGA
Scale:	1:1	SP950	
Master:			

PROPRIETARY AND CONFIDENTIAL
NO COPIES OR PARTS OF THIS DRAWING
MAY BE MADE IN WHOLE OR IN PART
BY ANY FORM WITHOUT THE
EXPRESS WRITTEN PERMISSION
OF KIRK-RUDY INC.
WOODSTOCK, GA 30188 USA

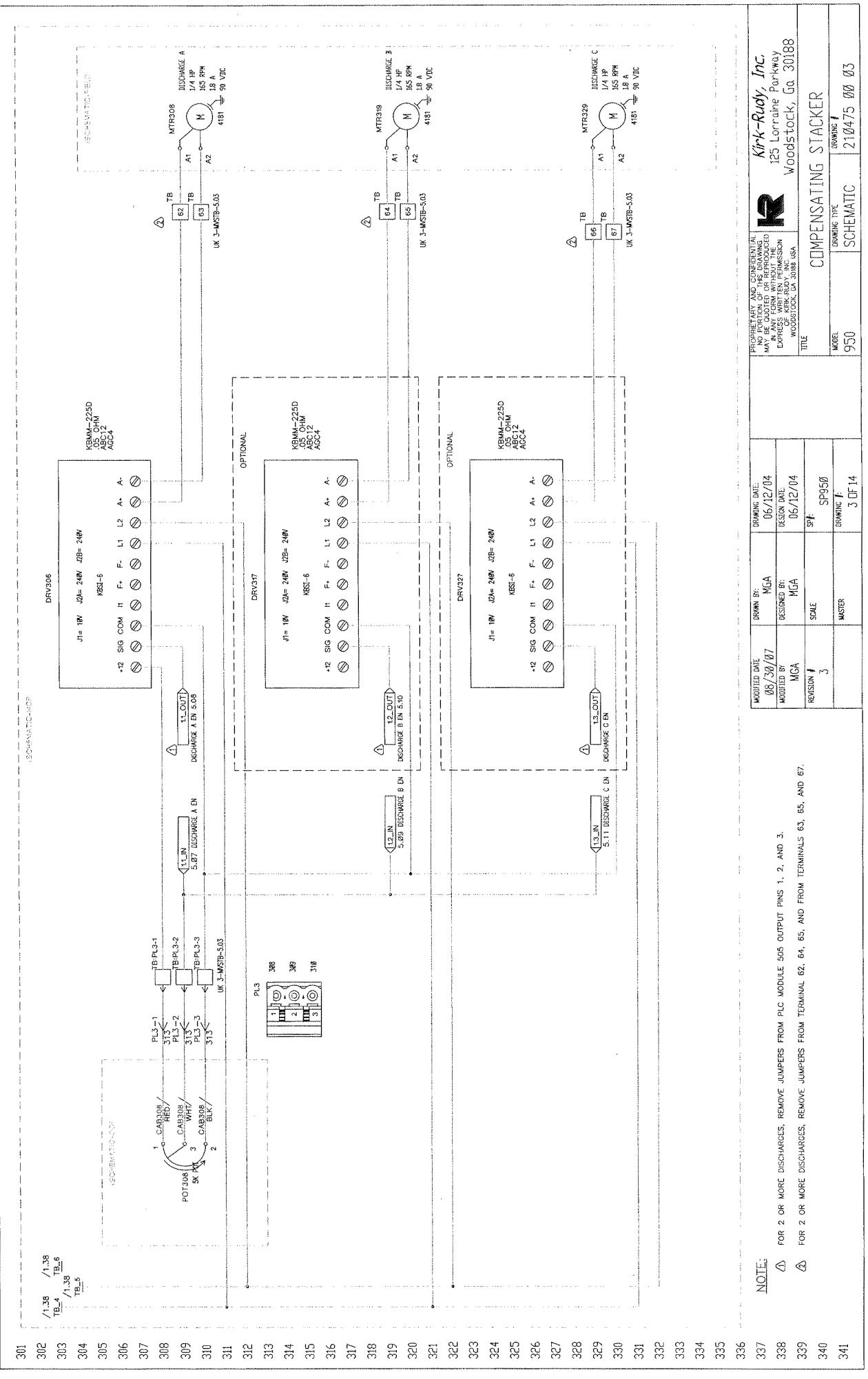
TIME:

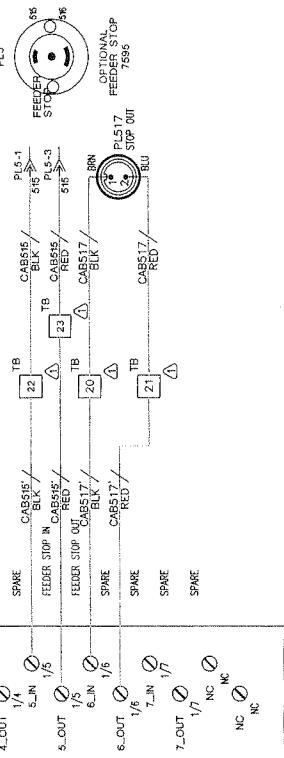
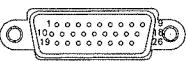
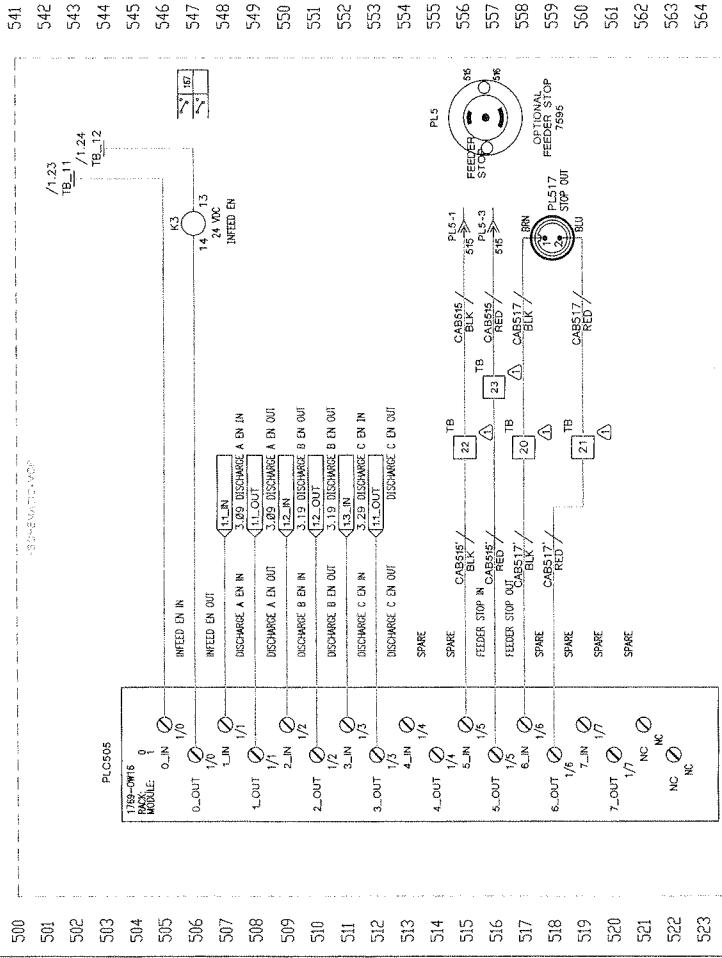
200	
201	
202	
203	
204	
205	
206	
207	
208	
209	
210	
211	
212	
213	
214	
215	
216	
217	
218	
219	
220	
221	
222	
223	
224	
225	
226	
227	
228	
229	
230	
231	
232	
233	
234	
235	
236	
237	
238	
239	
240	
241	TB7 /1.38
242	TB7 /1.38
243	TB8
244	
245	FAN245
246	FAN249
247	
248	
249	
250	DP200A-322X8T
251	
252	
253	
254	/1.21 /1.38
255	TB10 /1.24
256	TB12
257	
258	
259	
260	
261	
262	
263	
264	
265	
266	
267	PLUG269-1-1-NC
268	PLUG269-2-2
269	PLUG269-3-3
270	PLUG269-4-4
271	PLUG269-5-NC
272	PLUG269-6-NC
273	PLUG269-7-NC
274	PLUG269-8-NC
275	PLUG269-9-NC
276	
277	MANUFACTURED DATE: 08/30/07
278	MANUFACTURED BY: MCA
279	DESIGNED BY: MCA
280	REVISION #: 3
281	SP950

CONNECT GROUND WIRE
TO OCP ENCLOSURE

SERVO204

Kirk-Rudy, Inc.	
125 Lorraine Parkway	Woodstock, Ga 30188
COMPENSATING STACKER	
DRAWING TYPE: SCHEMATIC	
DRAWING NUMBER: 950	
DRAWING DATE: 06/12/04	
DESIGN DATE: 06/12/04	
TITLE: COMPENSATING STACKER	
MODEL: 950	





CONNECT SHIELD TO GOUND D-SUB FRAME

REF ID	DESCRIPTION	DRAWING TYPE	SCHEMATIC
541		INPUT LINE 1	BLACK
542		INPUT LINE 3	BROWN
543		INPUT LINE 5	RED
544		INPUT LINE 7	ORANGE
545		INPUT LINE 9	YELLOW
546		INPUT LINE 11	GREEN
547		OUTPUT LINE 1	BLUE
548		OUTPUT LINE 3	VIOLET
549		OUTPUT LINE 5	GREY
550		ENABLE	WHITE
551		INPUT LINE 2	PINK
552		INPUT LINE 4	TAN
553		INPUT LINE 6	RED/BLACK
554		INPUT LINE 8	RED/YELLOW
555		INPUT LINE 10	RED/GREEN
556		INPUT LINE 12	WHITE/BLACK
557		OUTPUT LINE 2	WHITE/BROWN
558		OUTPUT LINE 4	WHITE/RED
559		I/O +V	WHITE/ORANG
560		I/O COM	WHITE/YELLOW
561		N/C	
562		N/C	
563		N/C	
564		N/C	
565		N/C	
566		N/C	
567		N/C	
568		OUTPUT LINE 6	WHITE/GREEN
569		OUTPUT LINE 7	WHITE/BLUE
570			
571			
572			
573			
574			
575			
576			
577	WORKED DATE	DRAWN BY:	DRAWING DATE:
578	08/30/07	MCA	06/12/04
579	MODIFIED BY:	DESIGNED BY:	DESIGN DATE:
	MCA	MCA	06/12/04
580	REVISION #	SCALE	SP95W
581	3	MASTER	DRAWING #
		5 OF 14	210475 00 03

NOTE
Δ UK 3-MSTB-5.63 TERMINALS

Proprietary and Confidential.
May not be copied or reproduced
in any form without the
express written permission
of Kirk-Rudy, Inc.
Woodstock, GA 30288 USA

KR Kirk-Rudy, Inc.
125 Lorraine Parkway
Woodstock, Ga. 30288

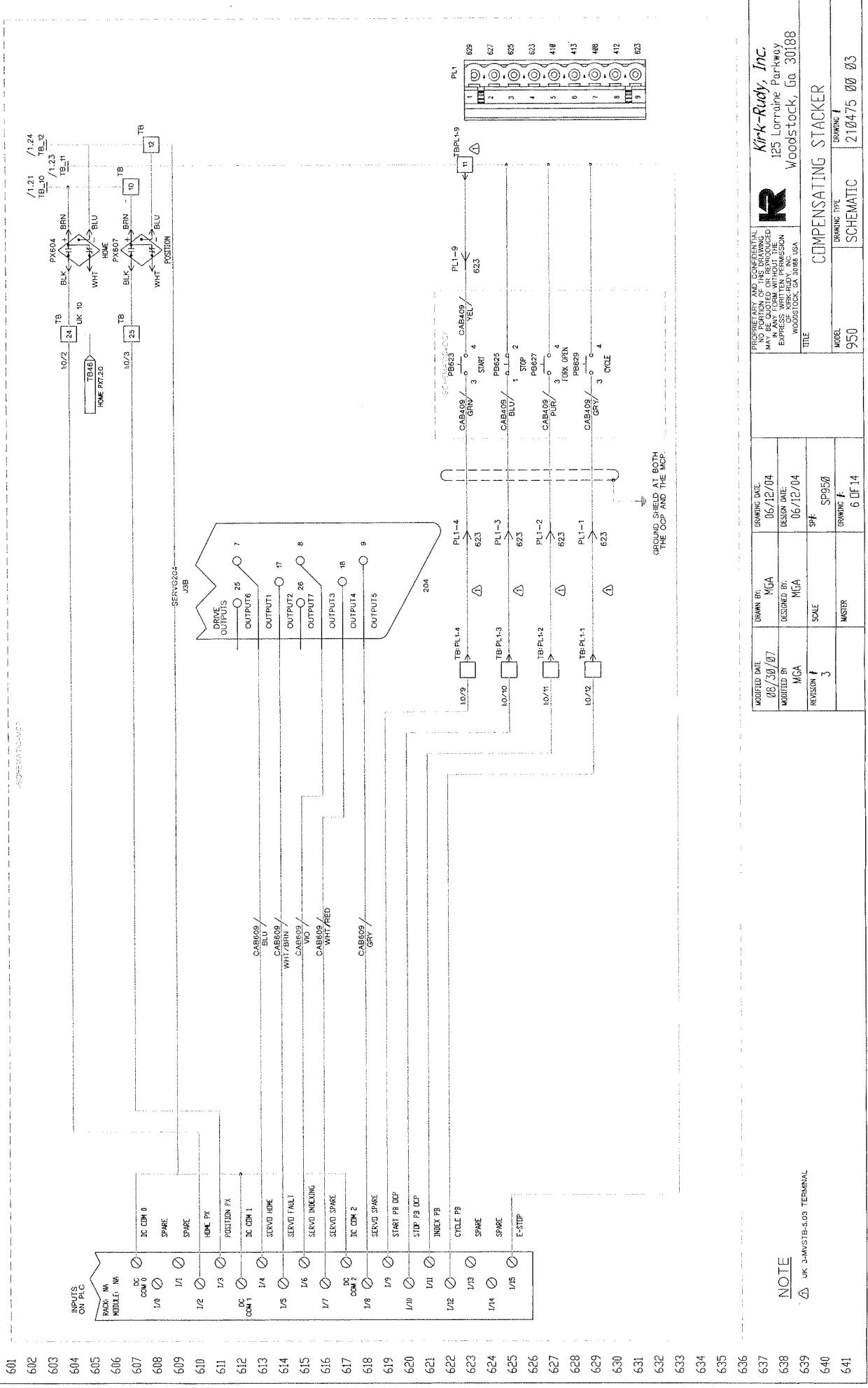
COMPENSATING STACKER

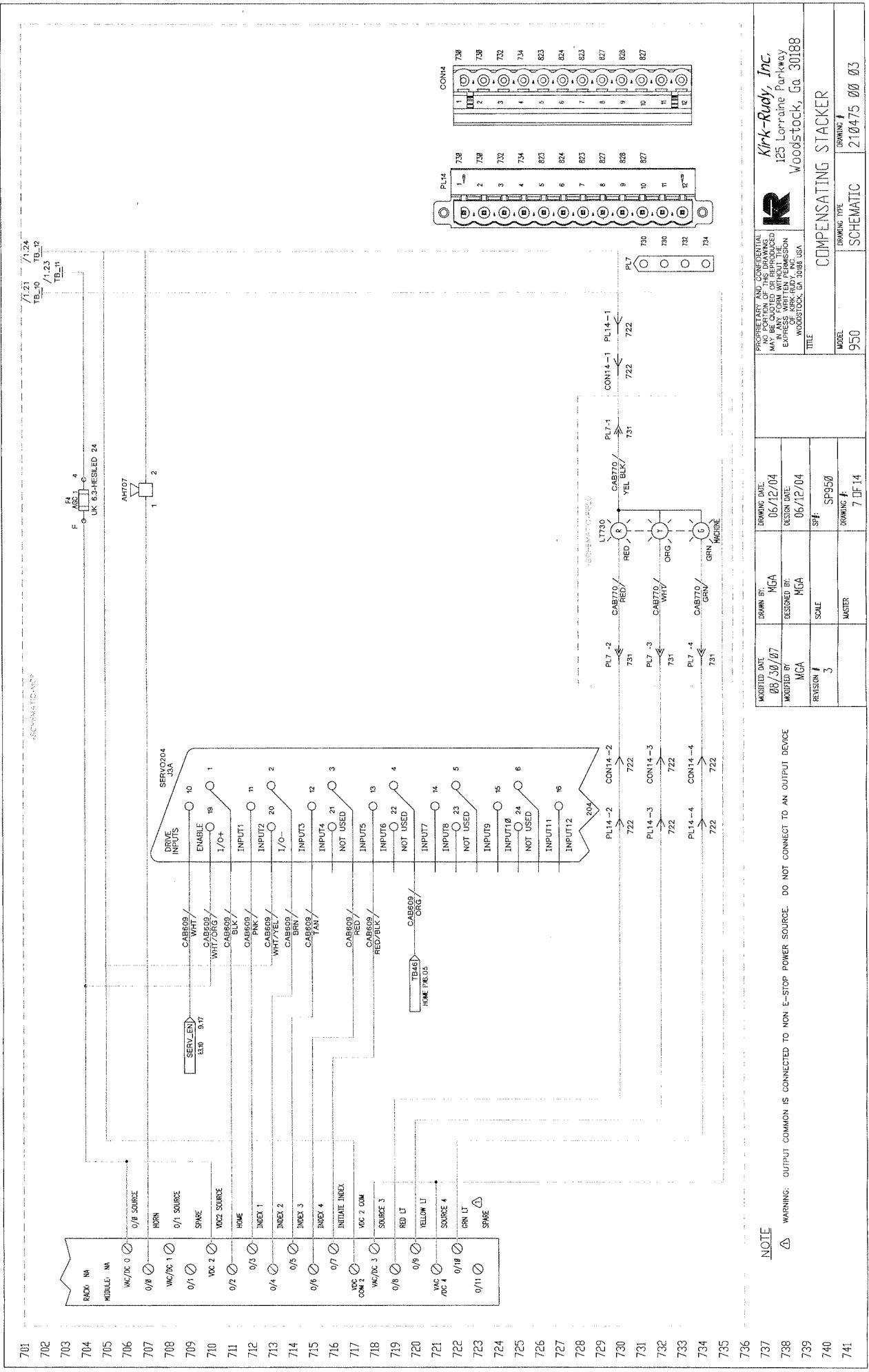
DRAWING #

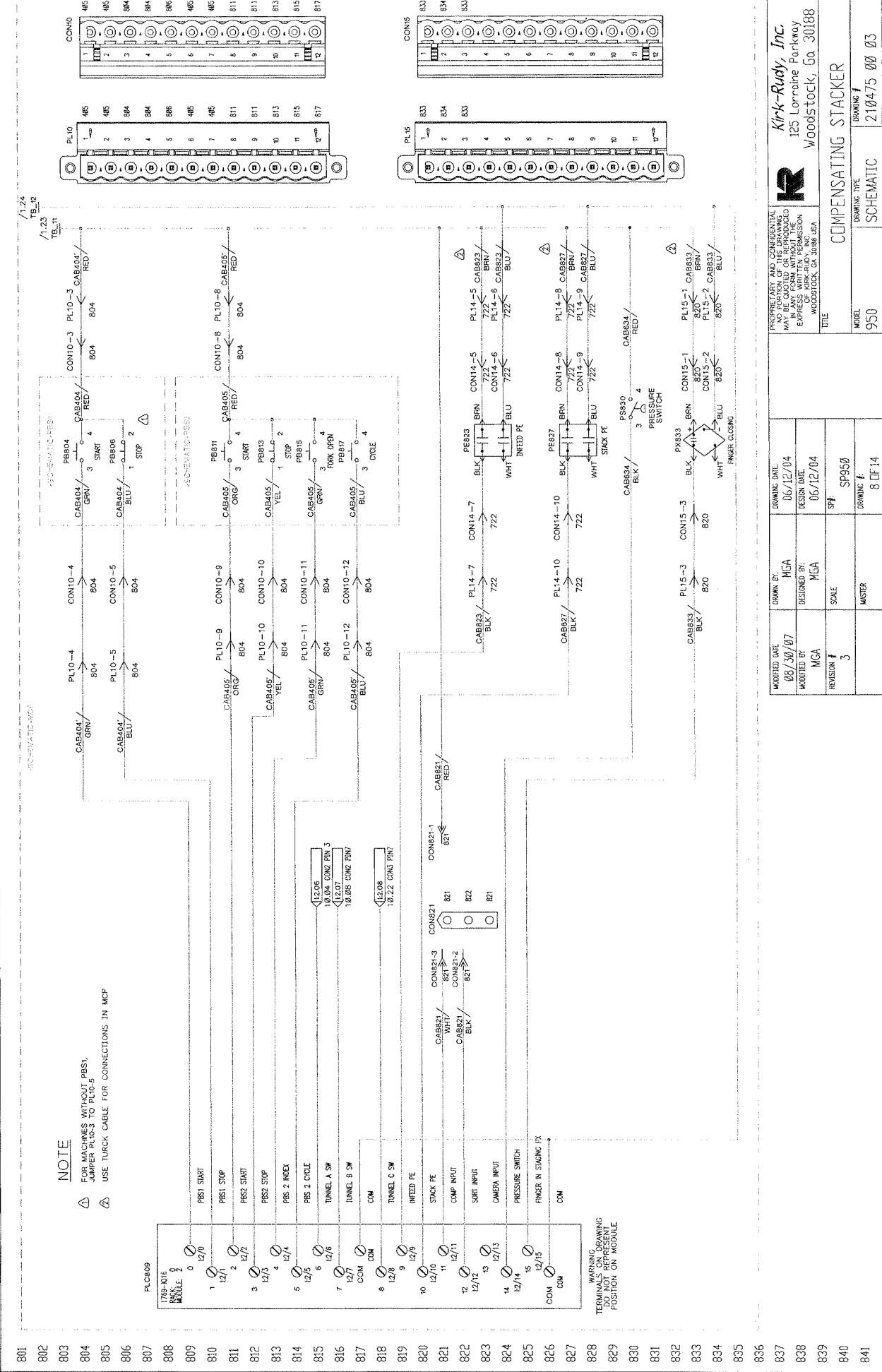
210475

SCHEMATIC

920

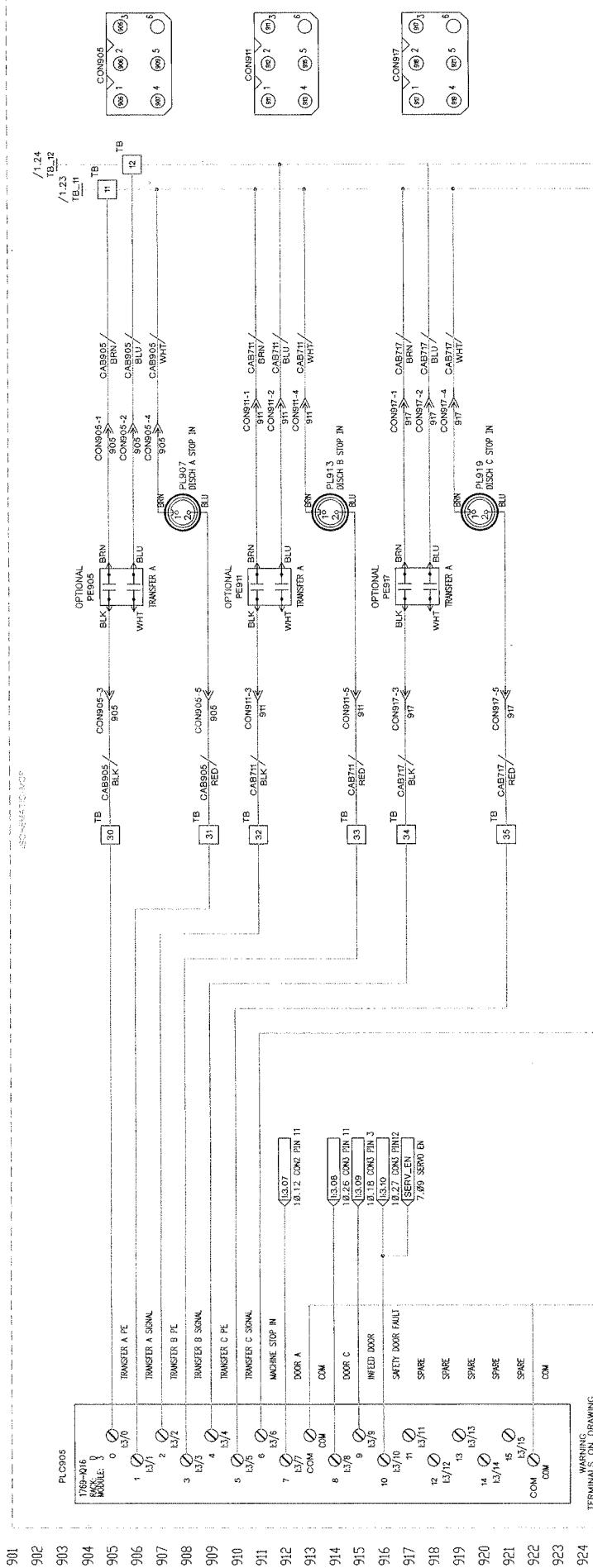




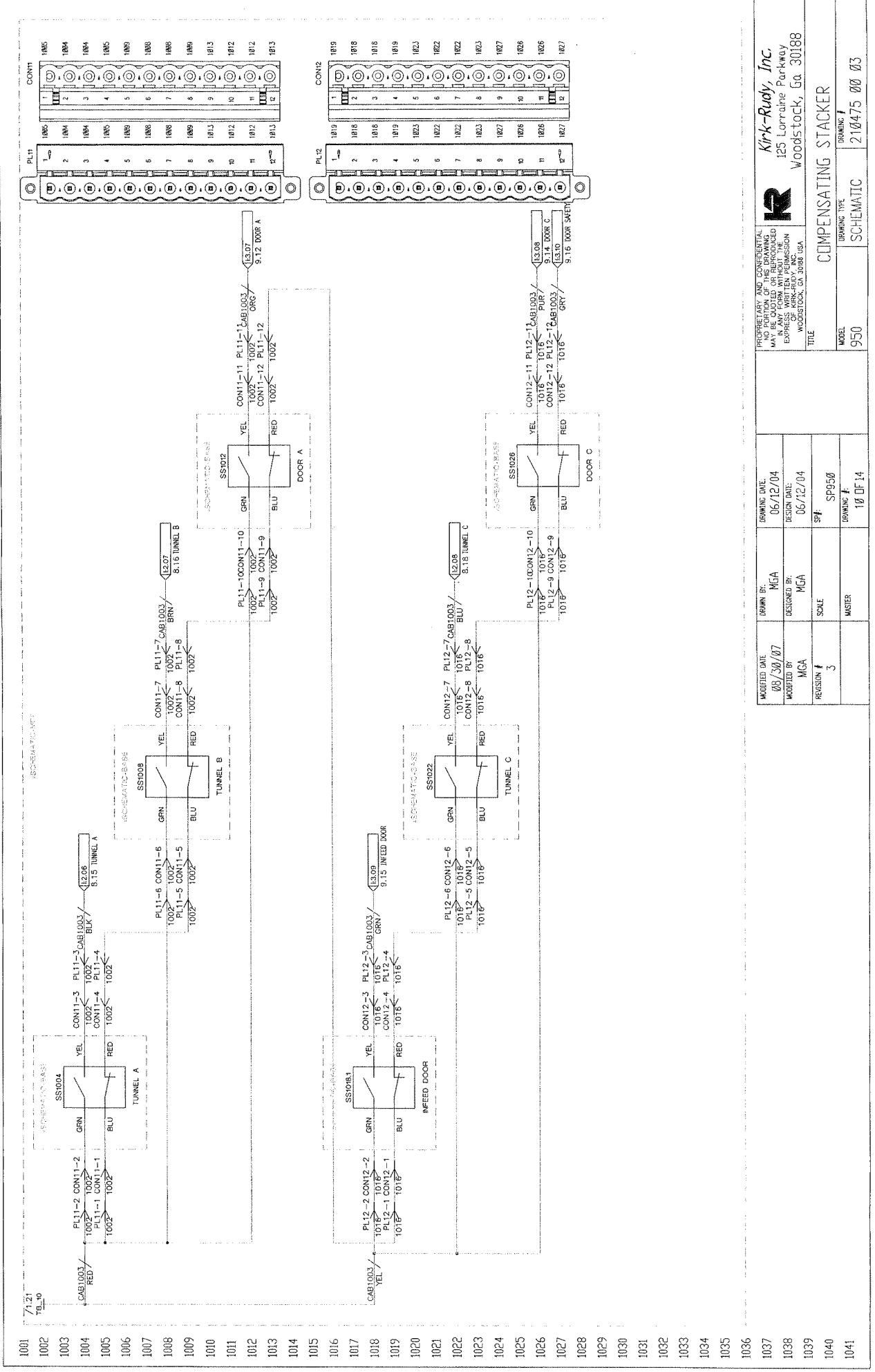


MODIFIED DATE	DRAWN BY	DRAWING DATE	DESIGNER BY	DESIGN DATE	TITLE
06/30/07	MGA	06/12/04	MGA	06/12/04	Kirk-Rudy, Inc.
					125 Lorraine Parkway Woodstock, GA 30188

COMPENSATING STACKER

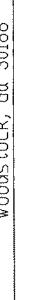


MODIFIED DATE 08/30/07	DRAWN BY MGA	DRAWING DATE 06/12/04
MODIFIED BY MGA	DESIGNED BY MGA	DESIGN DATE 06/12/04
REVISION # 3	SCALE SP500	DRAWING # 9
MODEL 950	SCHEMATIC	DRAWING TYPE 9/14
TITLE COMPENSATING STACKER		
DRAWN BY Kirk-Rudy, Inc.		
125 Lorraine Parkway Woodstock, Ga. 30188		



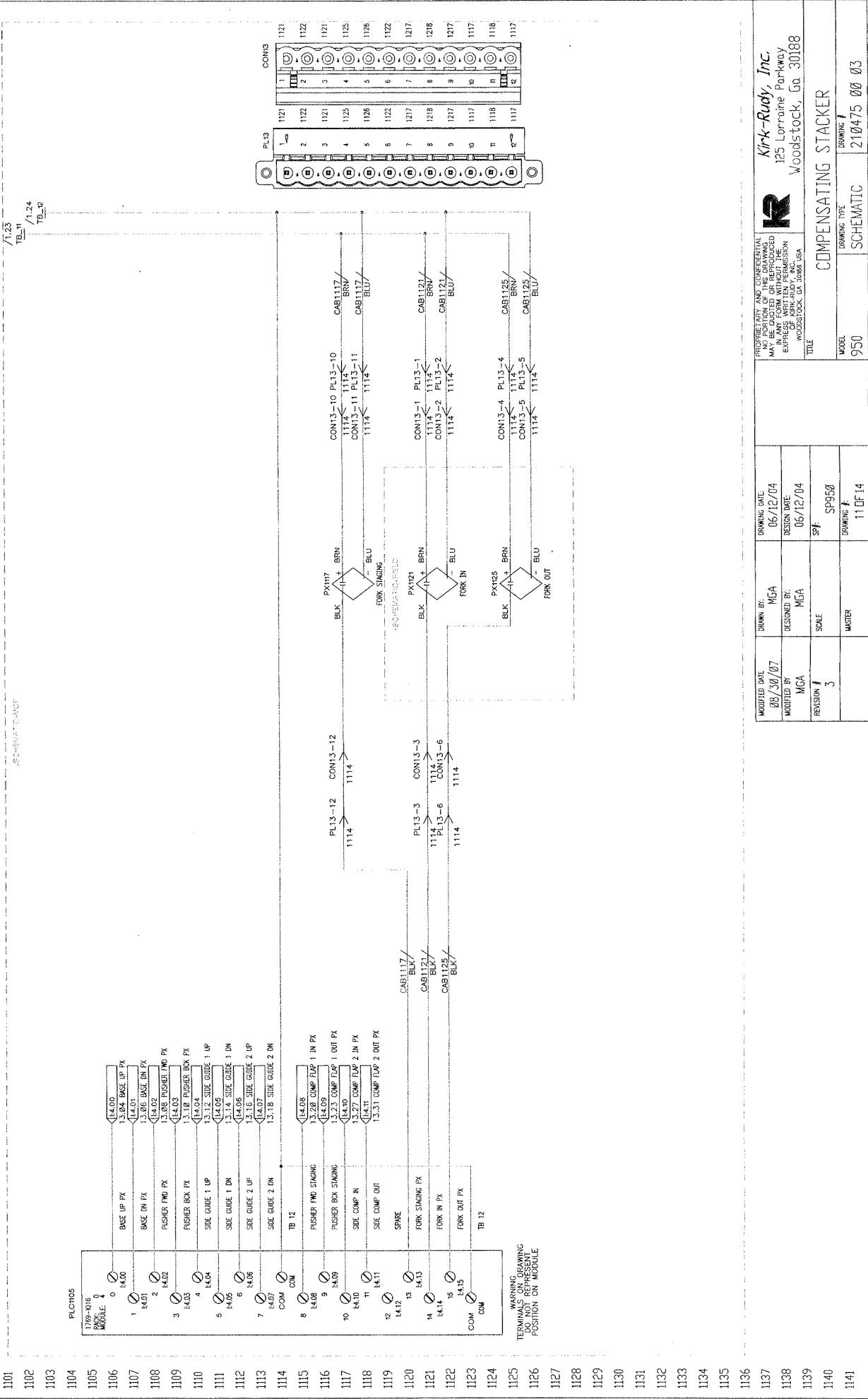
MODIFIED DATE 05/30/07	DRAWN BY MGA	DRAWING DATE 06/12/04
MODIFIED BY MGA	DESIGNED BY MGA	DESIGN DATE 06/12/04
REVISION # 3	SCALE SP950	DRAWING TYPE MASTER
Model 950	DRAWING F	DRAWING ID 210475 00 03

PROPRIETARY AND CONFIDENTIAL
NOT TO BE COPIED OR REPRODUCED
IN ANY FORM WITHOUT THE
EXPRESS WRITTEN PERMISSION
OF KIRK-RUDY, INC.
WOODSTOCK, GA 30888 USA
TITLE
COMPENSATING STACKER
DRAWING STAMP
DATE
210475 00 03



Kirk-Rudy, Inc.
125 Lorraine Parkway
Woodstock, Ga 30188

SHEET 2 OF 2

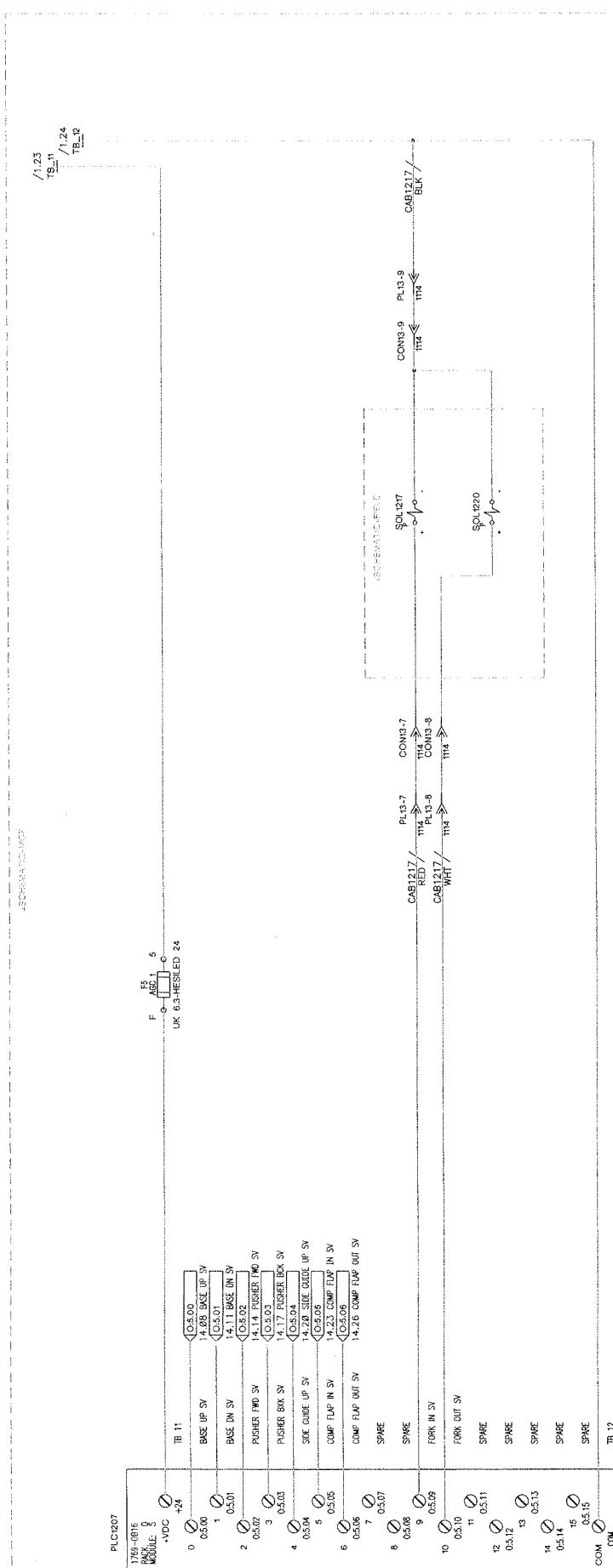


PROPRIETARY AND CONFIDENTIAL
NO PART OF THIS DRAWING OR SPECIFICATION
MANUFACTURED OR USED WITHOUT THE
EXPRESSED WRITTEN PERMISSION
OF KIRK-RUDY, INC.
WOODSTOCK, GA 30188
TITLE

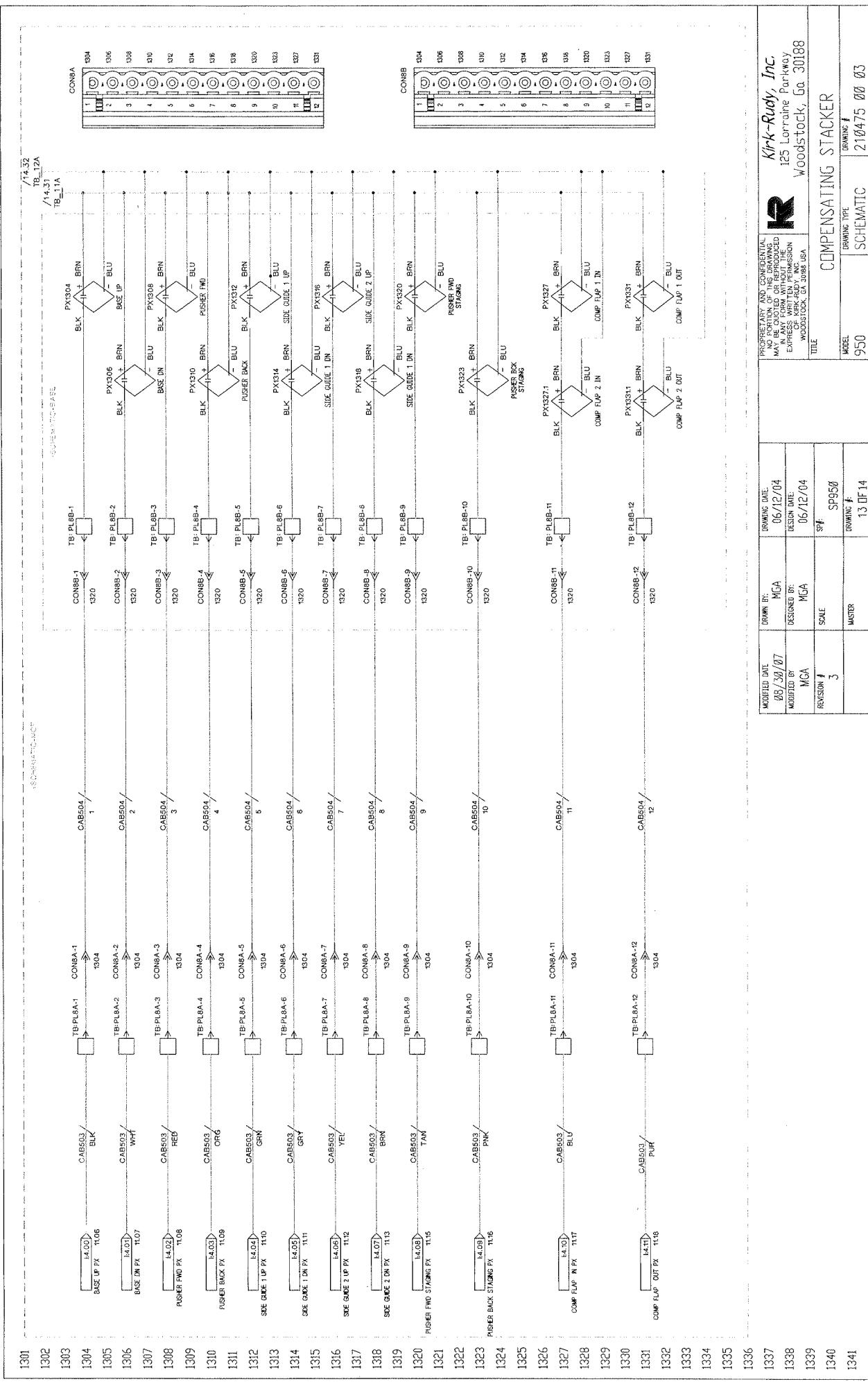


COMPENSATING STACKER

MODEL: SP950
DRAWING TYPE: F
SCHEMATIC
DRAWING NUMBER: 210475 00 03



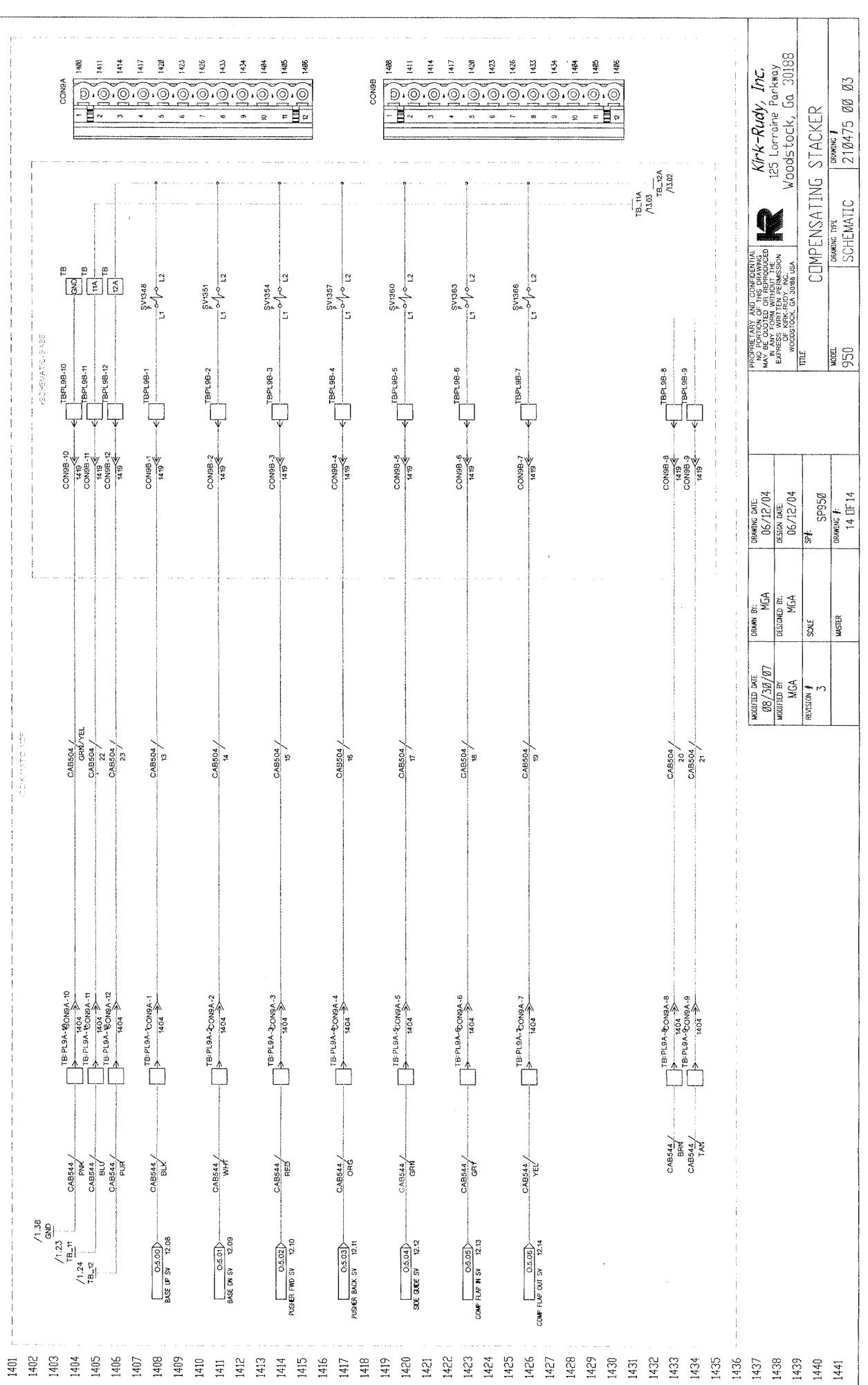
06/12/04	DRAWN BY: MCA	MODIFIED DATE: 06/12/04	DESIGNED BY: MCA	PROPRIETARY AND CONFIDENTIAL NO REPRODUCTION OR DERIVATION IN ANY FORM WITHOUT THE EXPRESS WRITTEN CONSENT OF KIRK-RADY, INC. WOODSTOCK, GA 30188
SP950	SCALE: 3	SP950	DRAWING #: F	Kirk-Rady, Inc. 125 Lorraine Parkway Woodstock, Ga. 30188
950	MASTER	12 OF 14	DRAWING #: F	COMPENSATING STACKER
950	SCHEMATIC	12 OF 14	DRAWING #: F	21047500003_03



PROPRIETARY AND CONFIDENTIAL NOT TO BE COPIED OR REPRODUCED IN ANY FORM WITHOUT THE EXPLICIT WRITTEN PERMISSION OF KIRK-RUDY, INC. WOODSTOCK, GA 30888 USA	DRAWING DATE: 06/12/04
MODIFIED BY: MGA	DESIGNED BY: MGA
MODIFIED DATE: 08/30/07	DESIGN DATE: 06/12/04
REVISION #: 3	SCALE: SP950
MASTER	DRAWING #: 13 IF 14
950	DRAWING TYPE: SCHEMATIC
13	DRAWING #: 2104750003_03

Kirk-Rudy, Inc.
125 Lorraine Parkway
Woodstock, Ga. 30188

COMPENSATING STACKER



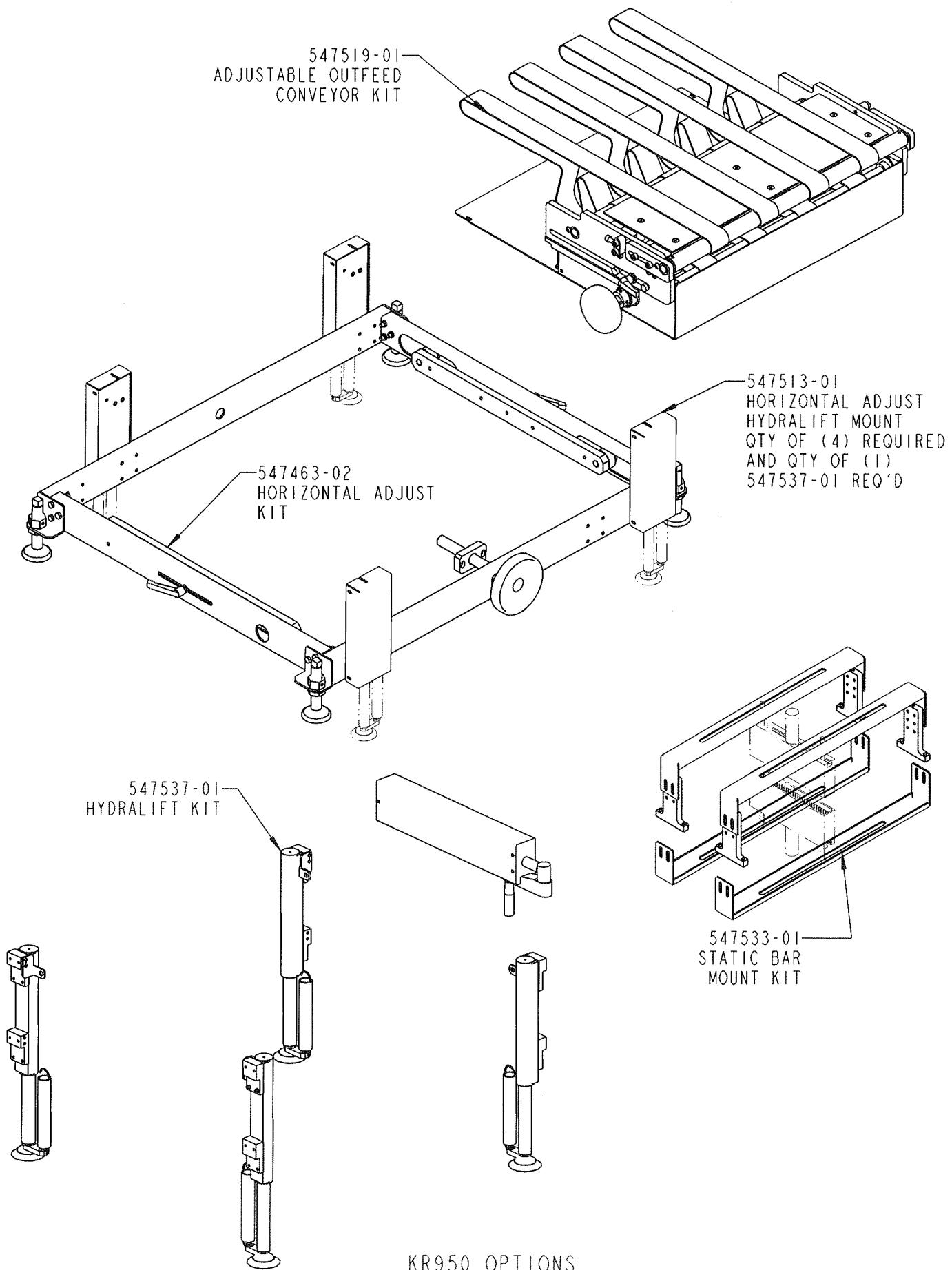
Kirk-Rudy, Inc.	
125 Lorraine Parkway Woodstock, Ga. 30188	
COMPENSATING STACKER	DRAWING TYPE: 1
NOVEL	DRAWING #: 950
SCHEMATIC	DRAWING #: 210475 000 03

MODIFIED DATE	DRAWN BY	DRAWING DATE
08/30/07	MCA	06/12/04
MODIFIED BY	DESIGNED BY	DESIGN DATE
MCA	MCA	06/12/04
REVISION #	SCALE	SP950
3	MASTER	DRAWING #: 14-114

10 APPENDIX

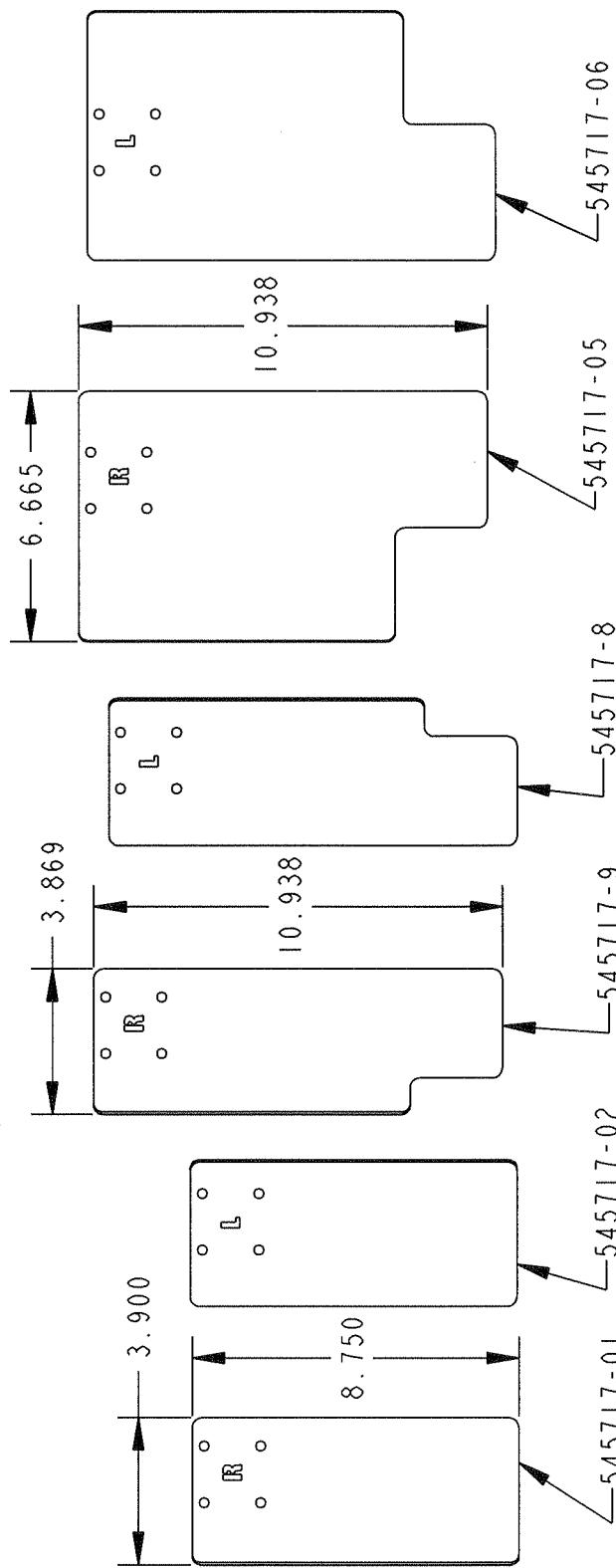
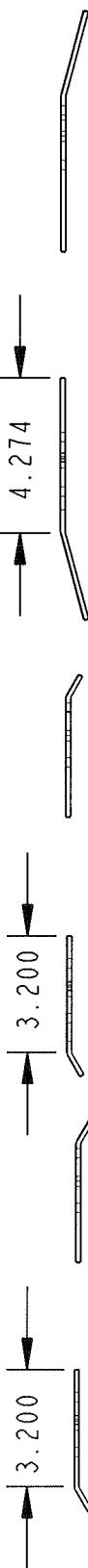
- 1 Recommended Spare Parts List
- 2 KR950 Options
- 3 Side Guide Options
- 4 Infeed Conveyor Belt Path Diagram
- 5 Outfeed Conveyor Belt Path Diagram
- 6 Outfeed Conveyor Belt Path Diagram with Justifier
- 7 Turntable Pneumatic Schematic
- 8 Electrical Box Pneumatic Schematic
- 9 Upper Belt Assembly Reference Dimensions
- 10 Infeed Conveyor Belt Take Up Reference Dimensions
- 11 KR950 Brochure
- 12 KR950 Functional Description

KR950 RECOMMENDED SPARE PARTS			
NO.	PART NO.	DESCRIPTION	QTY
1	100283	BUSHING, .625ID 1.125OD	4
2	108905	BELT, TIMING 187L075	1
3	108914	BELT, TIMING 124L075	1
4	108952	BELT, TIMING 225L075	1
5	109134	BELT, HTD 2400-8M-20	1
6	109138	BELT, HTD 8M-1440-20	1
7	109138	BELT, HTD TIMING 1440-8M-20	1
8	109141	BELT, HTD 20008M20	2
9	111871	BELT, FLAT 52.000 X 1.5	4
10	111872	BELT, FLAT 138.25 X .75	2
11	111873	BELT, FLAT 133.25 X 1.000	4
12	208022	FUSE [KB BOARD MOTOR] 8 AGC OUT	2
13	208023	FUSE [KB BOARD MOTOR] INFEED 12 ABC IN	2
14	208023	FUSE [KB BOARD MOTOR] 12 ABC	2
15	208024	FUSE [PANEL] PLC F4 1 AGC	2
16	208024	FUSE [PANEL] PLC F5 1 AGC	2
17	208044	FUSE [KB BOARD MOTOR] 4 AGC	2
18	201055-1	PROXIMITY	1
19	201176-2	SWITCH, MAGNET SAFETY	2
20	202261-5	BEAMSWITCH, RETROREFLECTIVE	1
21	202718-3	SENSOR, PROXIMITY INDUCTIVE	1
22	208056-0	FUSE [PANEL] PS F2 LP-CC 6/10	2
23	208056-5	FUSE [PANEL] PS110 LP-CC 5	2
24	208057-2	FUSE [PANEL] SERVO F3 KTK- R12	2



KR950 OPTIONS

545718-01



SIDE GUIDE OPTIONS

UPPER SIDE GUIDE OPTIONS

545717-06

545717-05

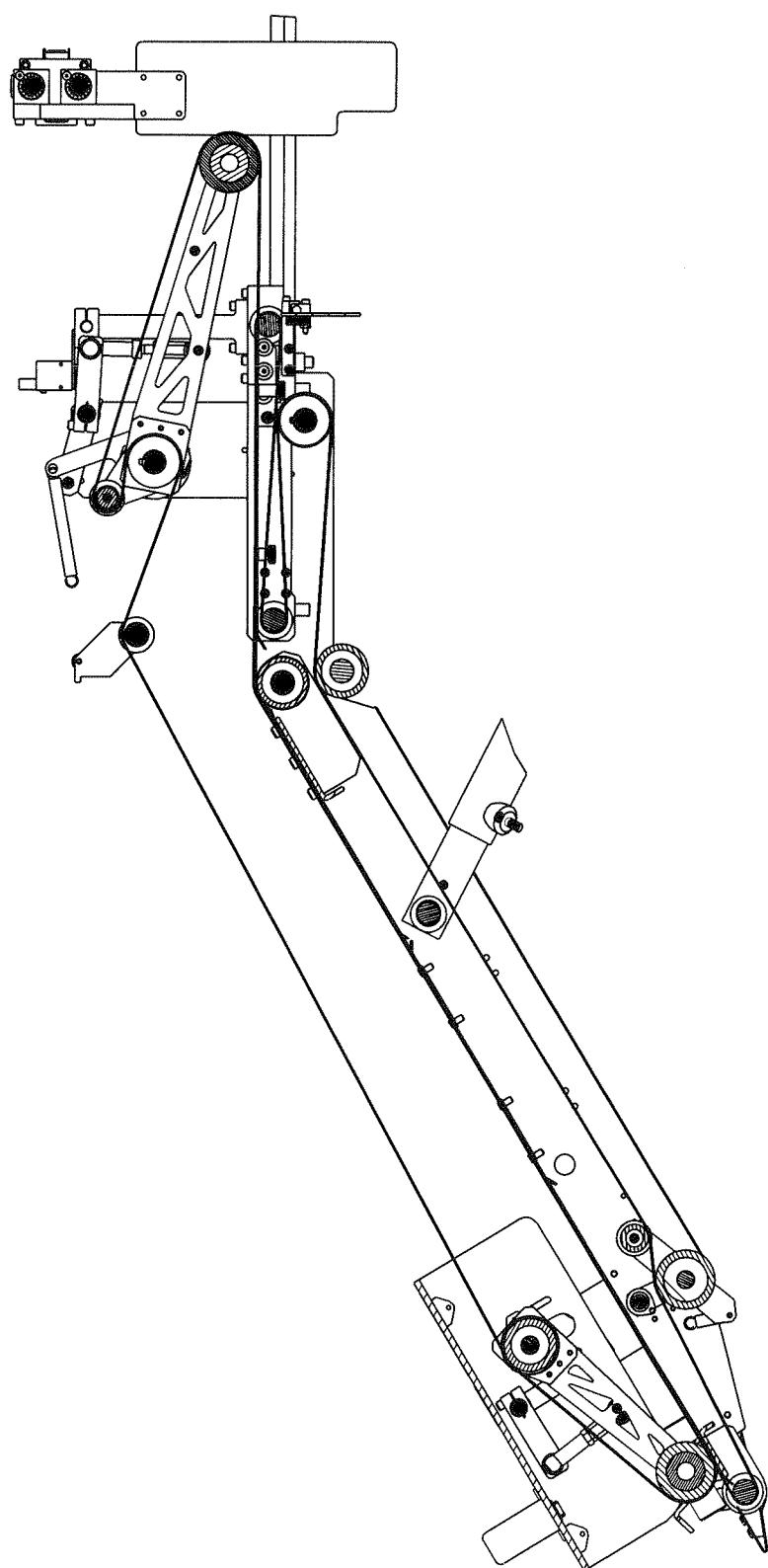
545717-08

545717-09

545717-02

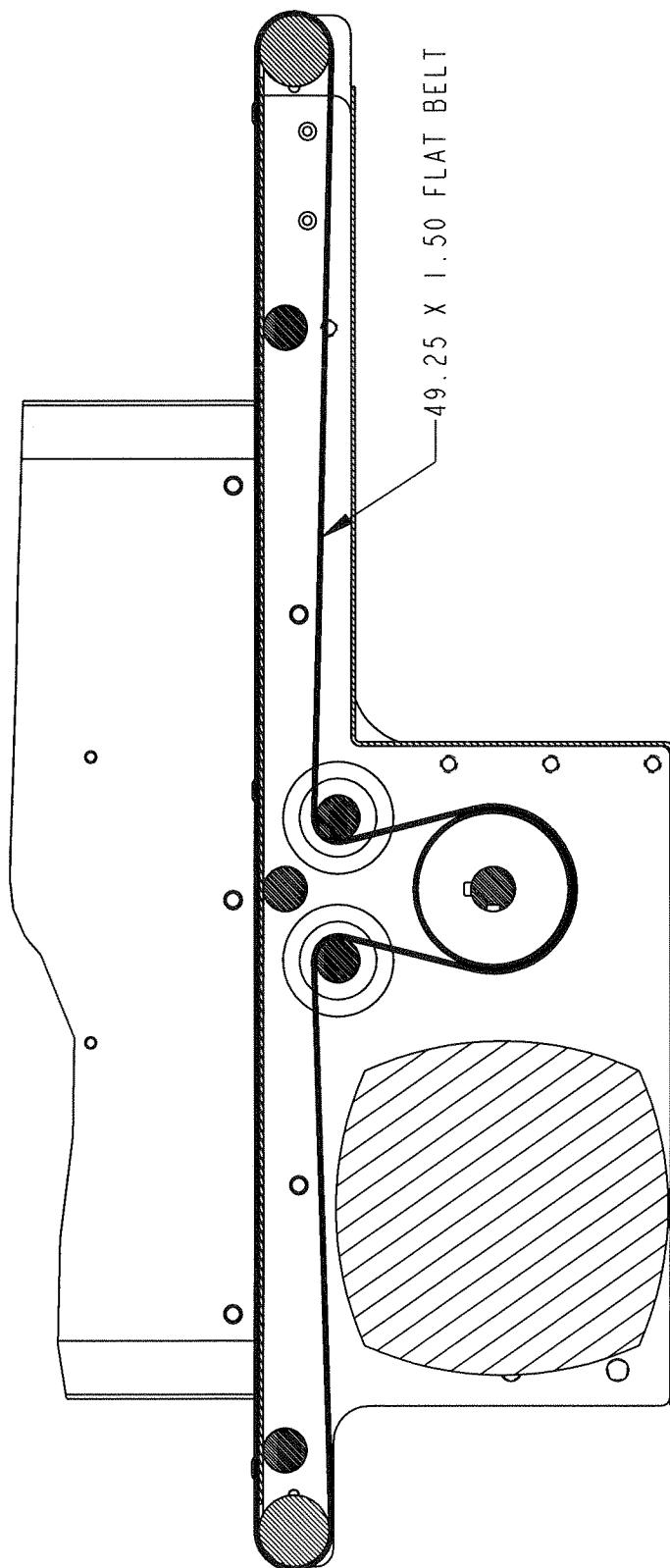
545717-01

545632-01



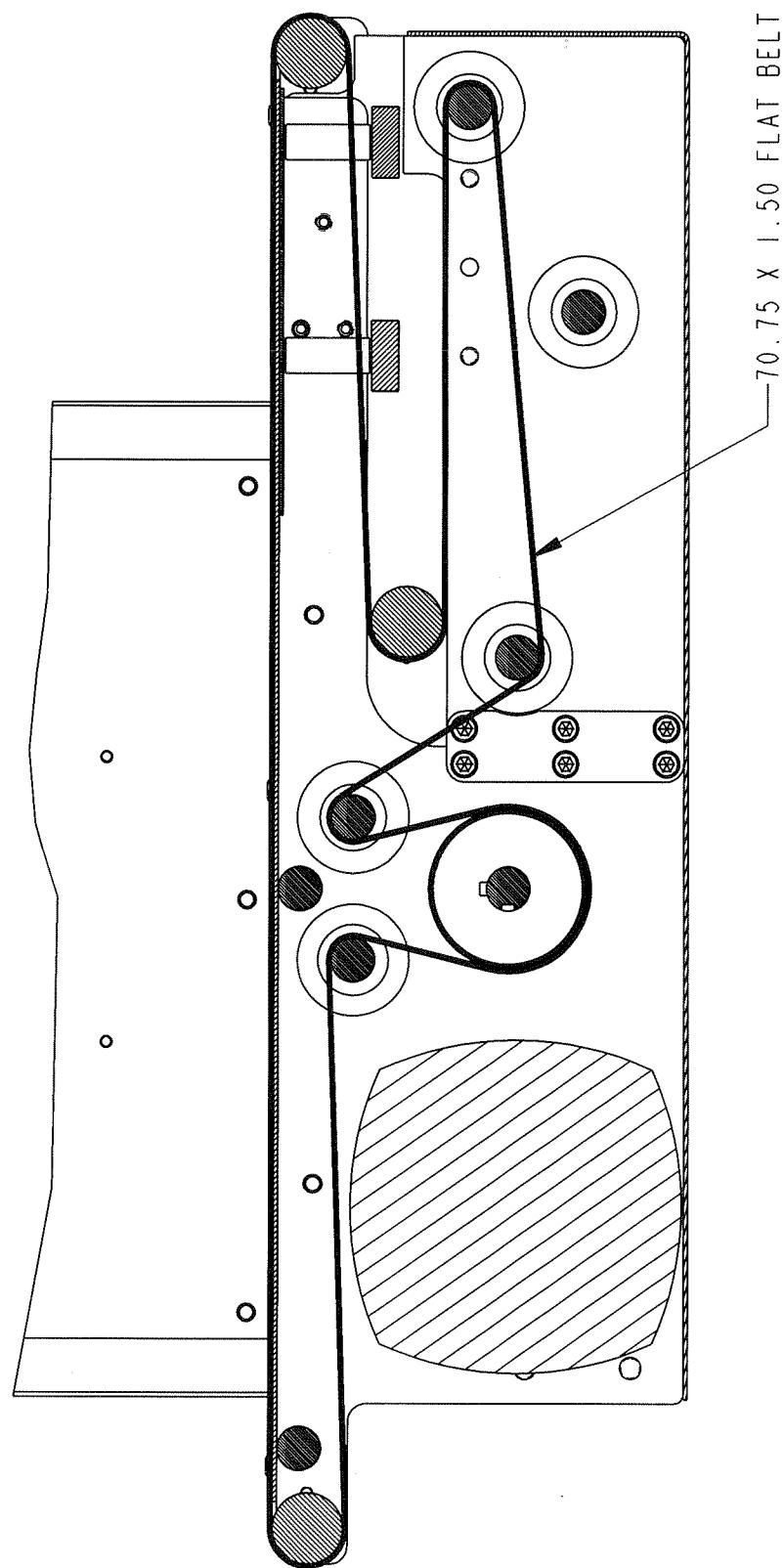
INFEED CONVEYOR BELT PATH DIAGRAM

545754-01



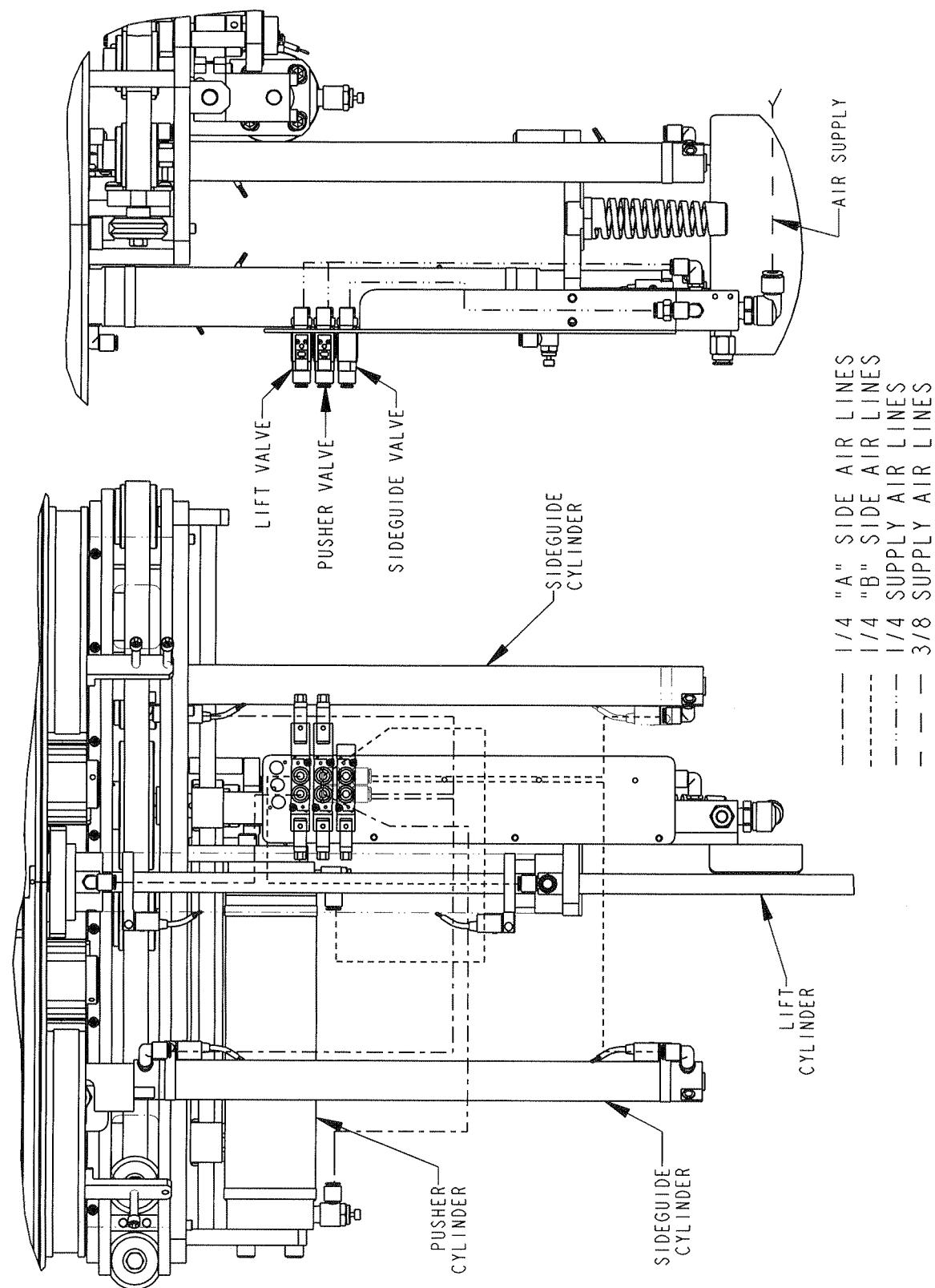
OUTFEED CONVEYOR BELT PATH DIAGRAM

545754-02



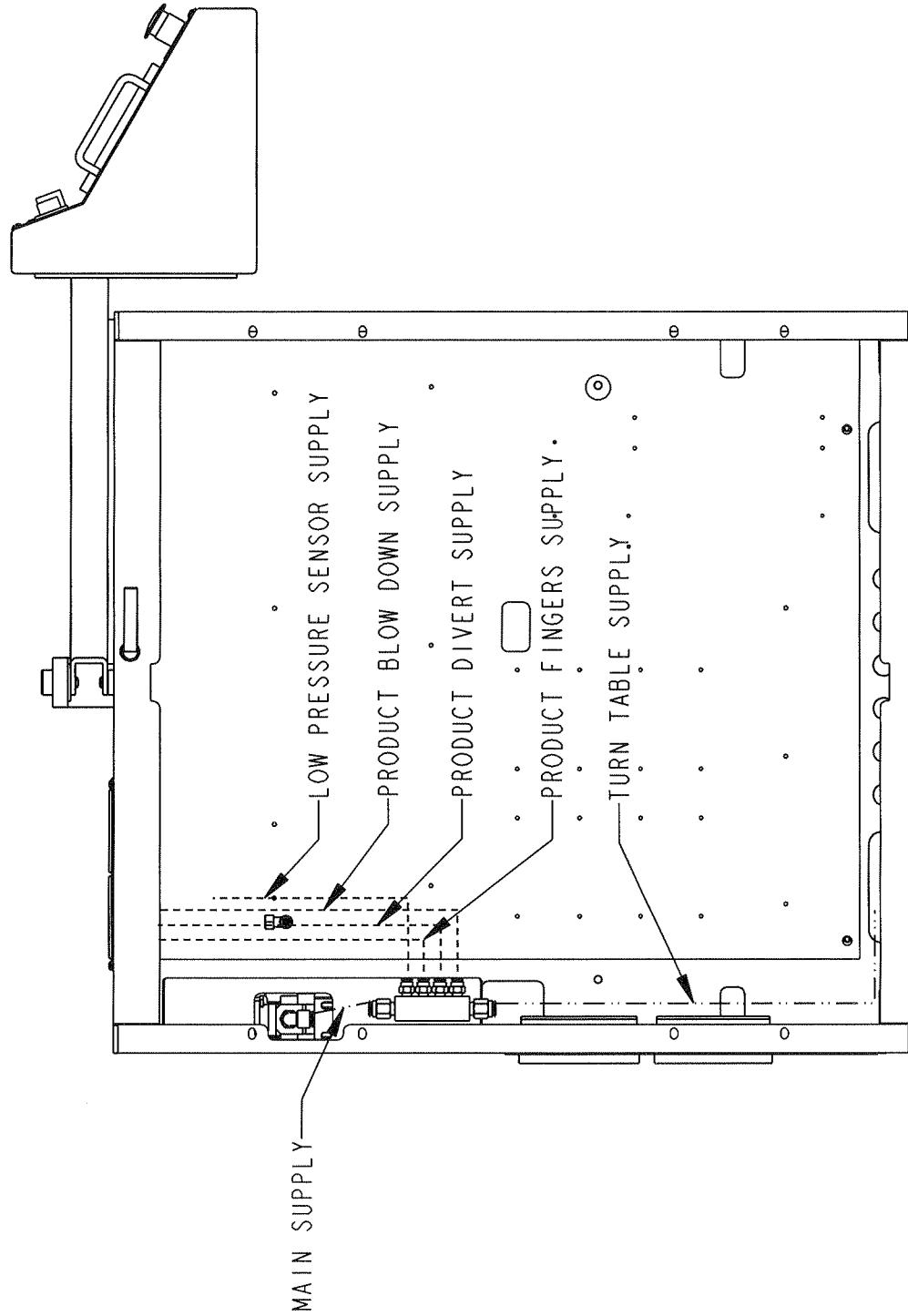
OUTFEED CONVEYOR BELT PATH DIAGRAM WITH JUSTIFIER

543896-01



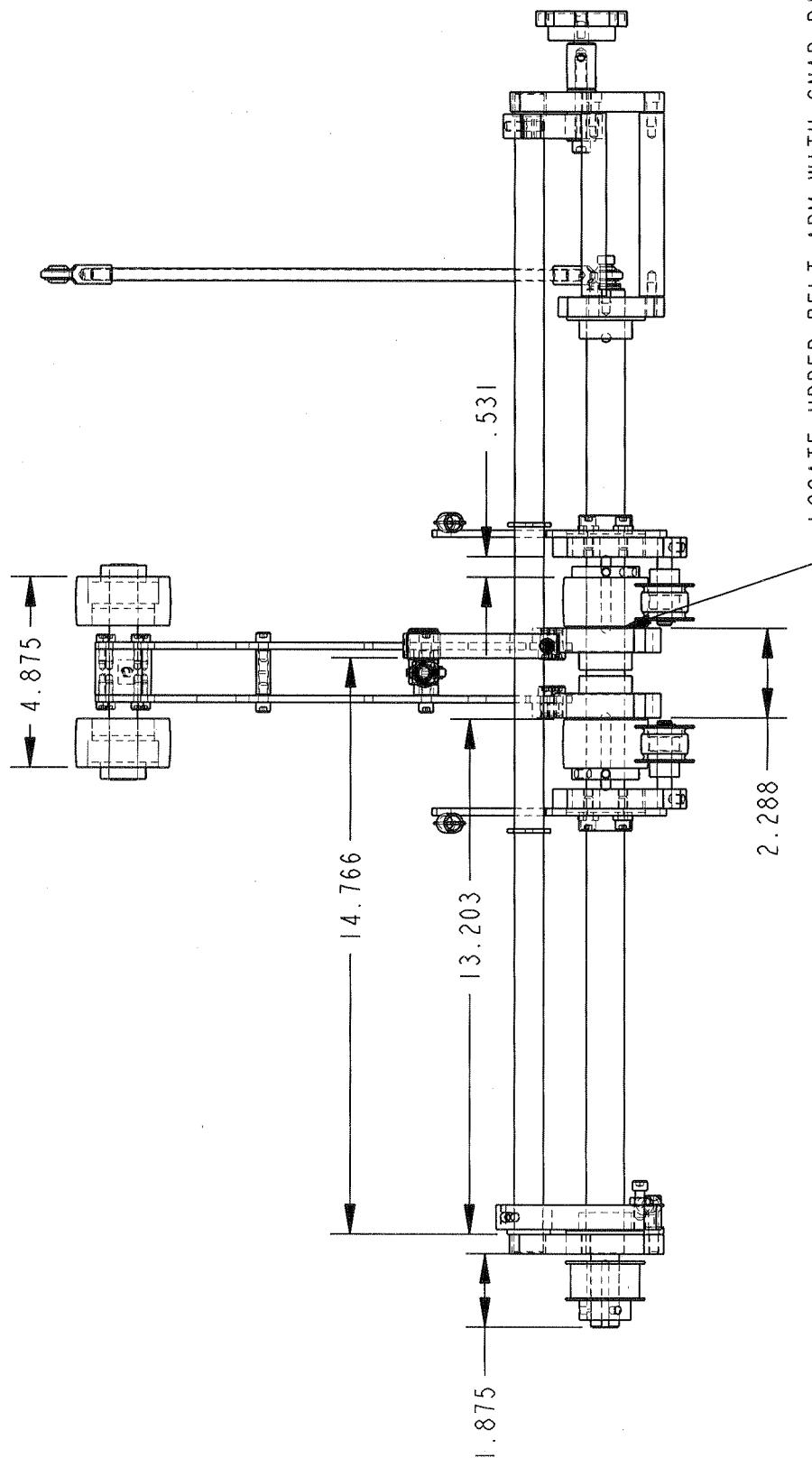
TURNTABLE PNEUMATIC SCHEMATIC

545621-01

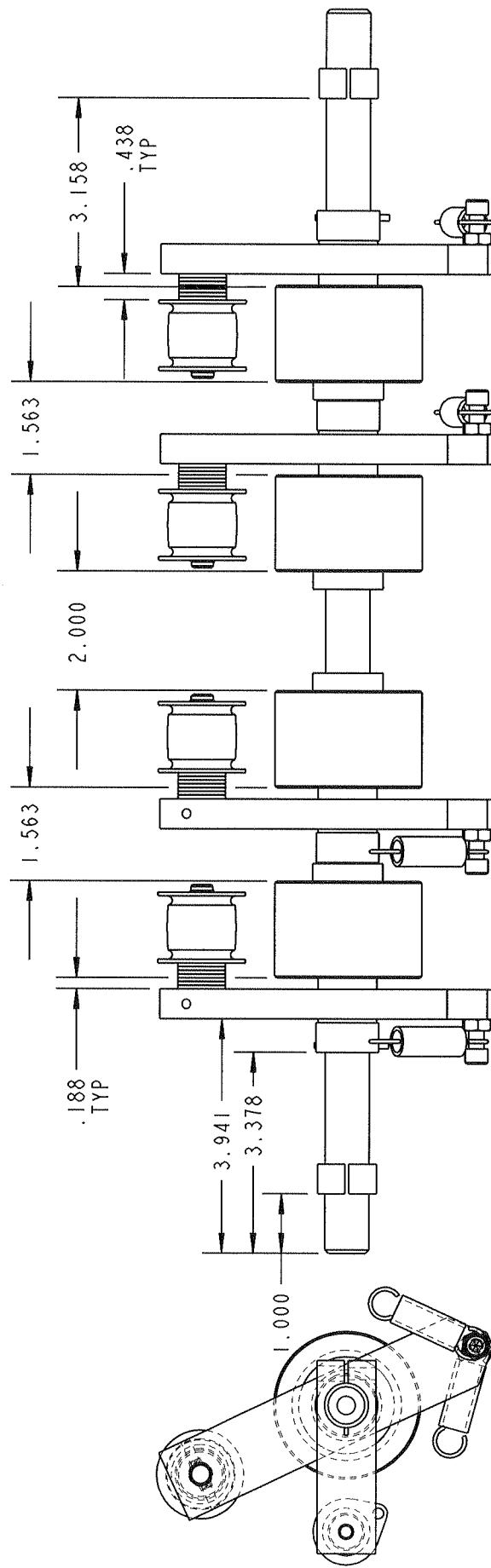


ELECTIRCAL BOX PNEUMATIC SCHEMATIC

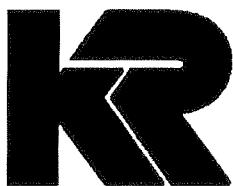
545684-01



UPPER BELT DRIVE REFERENCE DIMENSIONS



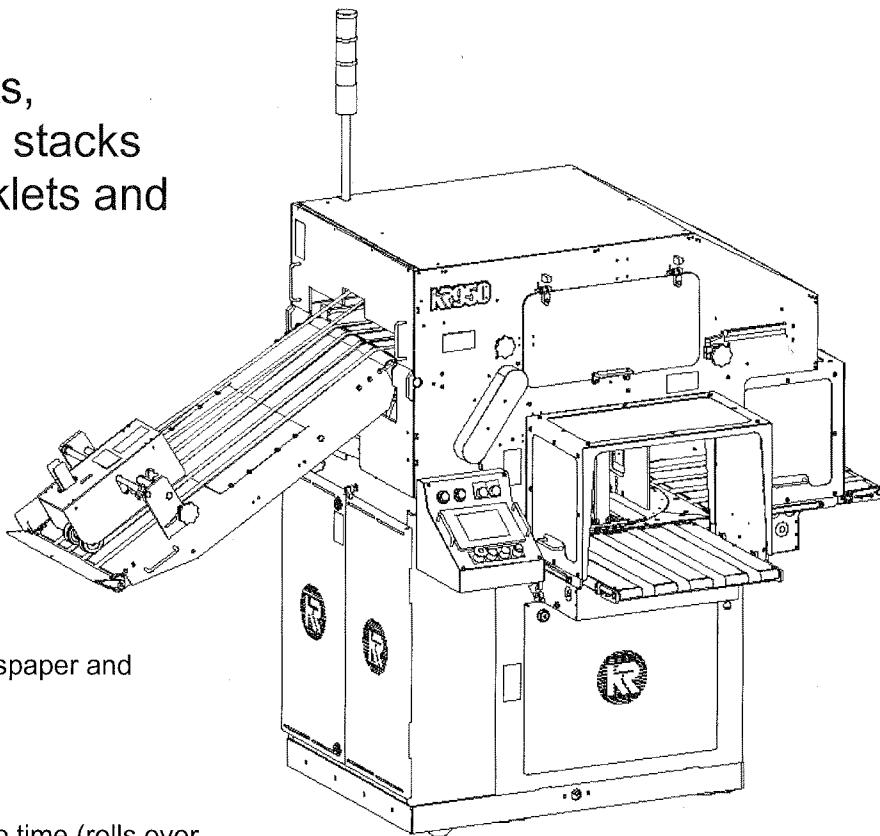
INFEED CONVEYOR BELT TAKE UP REFERENCE DIMENSIONS



KR950 COMPENSATING STACKER

Kirk-Rudy, Inc. • 125 Lorraine Parkway • Woodstock, GA 30188
Phone: (770) 427-4203 • Fax: (770) 427-4036

Automatically sorts,
compensates and stacks
newspapers, booklets and
magazines



Features:

- ◆ Runs in-line with most newspaper and bindery systems
- ◆ In-line divert system
- ◆ PLC control system
- ◆ Large color touch screen
- ◆ Designed for minimal set-up time (rolls over top existing shingle conveyor)
- ◆ Handles difficult product smoothly with full, infeed tabletop support and lift table to protect product from damage at all speeds
- ◆ Easily changes configurations from right, left or straight product delivery with the option to deliver product 90 degrees from compensate with a touch of a button
- ◆ Servo driven turntable allows for fastest compensating times with smooth ramp up and ramp down motions
- ◆ Control panel quickly swivels to four operating positions
- ◆ Product drop fingers only open to product size to increase cycle time and extend component life
- ◆ The turntable side guides use the full width of the product instead of the corners so product isn't damaged by quick turns
- ◆ Town sort signal interface

Options:

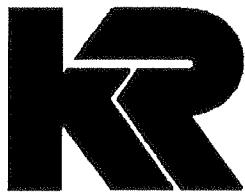
- ◆ 547519-01 Adjustable Outfeed Conveyor
- ◆ 547537-01 Hydra-Lift Kit
- ◆ 547533-01 Upper and Lower Static Bars
- ◆ 547463-02 Product Alignment Adjustment

Specifications:

- ◆ Electrical Requirements: 220V, 1PH, 30A, 60Hz
- ◆ Air Requirements: Min. 80 psi at 3 cfm
- ◆ Physical Dimensions:
 - Length: 8' Straight Delivery
 - 7'-3" Side Delivery
 - Width: 3'-8" Straight Delivery
 - 4'-4" Side Delivery
 - Height: 7'-2"
 - Infeed Height: 30" - 42"
 - Stack Delivery Height: 32" - 35"
- ◆ Stack Height:
 - Minimum: **1 piece**
 - Maximum: **14"**
- ◆ Belt Speed: **600'/min**
- ◆ Product Specifications:
 - Minimum: **4.5" x 6"**
 - Maximum: **18" x 18"**
 - Minimum Thickness: **.07"**
 - Maximum Thickness: **2.5"**
- ◆ Maximum Speed: **18,500+ copies/hour**
(Product Permitting)

**Specifications subject to change without notification

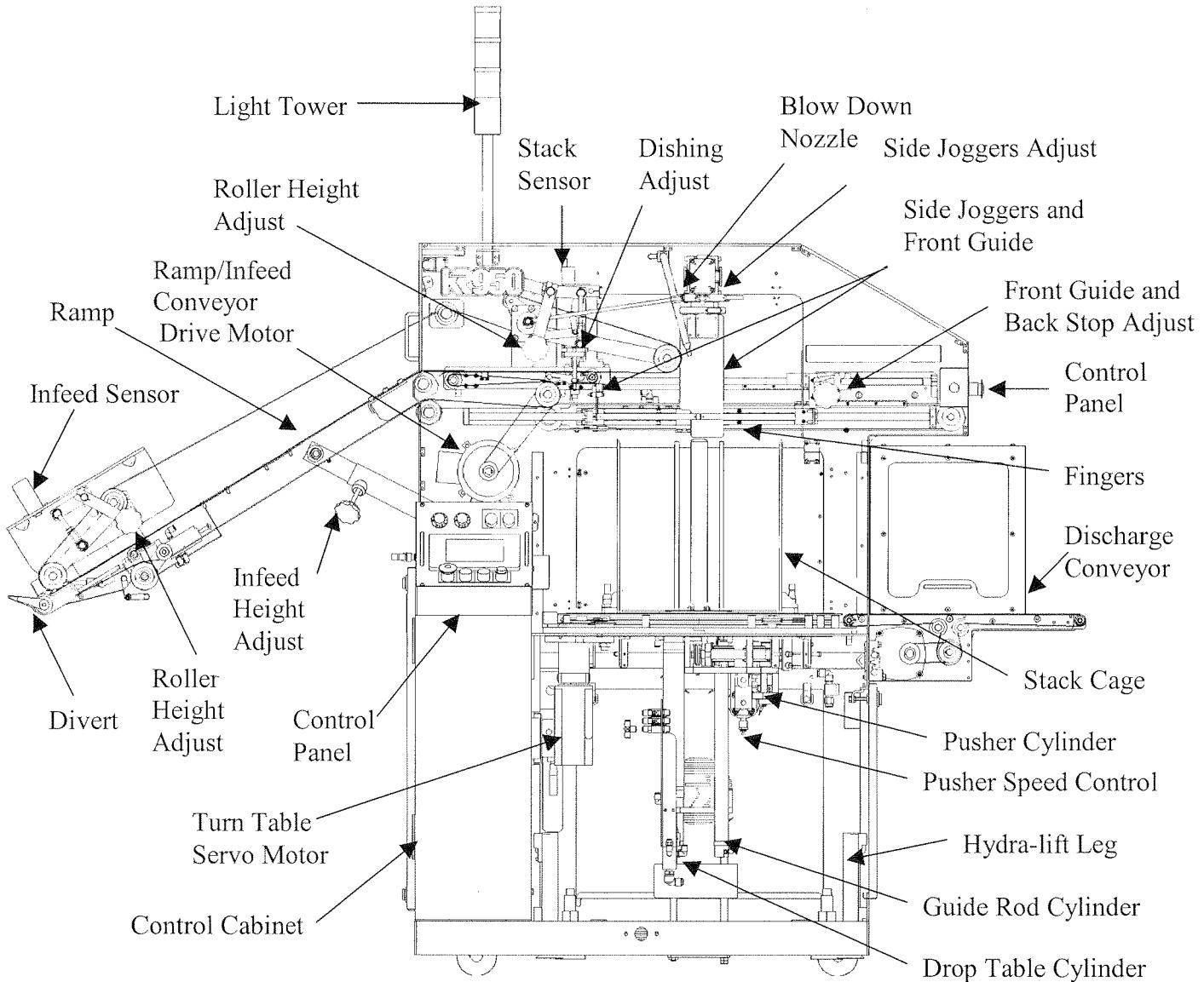
**Guards have been removed for clarity; do not operate machine without guards in place



KR950 COMPENSATING STACKER

Kirk-Rudy, Inc. • 125 Lorraine Parkway • Woodstock, GA 30188

Phone: (770) 427-4203 • Fax: (770) 427-4036



Functional Description

Evenly spaced product enters the stacker at the infeed. A divert at the infeed can be activated as necessary by receiving a signal from up-stream equipment such as an inkjet system to divert product that does not complement the stack and keep it from entering the stacker. The product is fully supported by the ramp and infeed conveyor and transported by upper and lower belts. When necessary, dishers on the infeed conveyor bend up the outer edges to curve the product. The curving of the product adds rigidity so the product enters the staging area properly. Blow down nozzles ensure product is quickly pushed down and settled into the fingers. The front guide and side joggers oscillate against the edges of the product to help form a square stack. After the desired batch count has been reached, the staging fingers open to drop the first batch onto the raised lift table and close to catch the next product in line. The table smoothly descends the batch downward a set distance while the turntable turns 180 degrees. When the next batch count is reached, another batch drops and so on until the stack is complete. When the stack is completed, the table drops completely down and the stack is rotated to the selected discharge side and the pusher pushes the stack out onto the discharge conveyor. The discharge conveyor delivers the product to downstream equipment. The turntable, lift and pusher resets at the same time to start another cycle. Up to three discharge conveyors can be selectively used at any time. NOTE: The action of the fingers can be programmed to several different modes to change stacking methods and decrease the cycle times of the stacker.

11 CROSS REFERENCE PART AND ASSEMBLY INDEX

Find the Index number and KR part number that corresponds to your part description or part number using the Part Description Index or Part Number Index list below. Using the Assembly Index list (located after the part description list) go to the index number. The part and assembly descriptions are indented below the containing assembly indicating the subassembly structure of the machine. Once the assembly KR number is found find the assembly diagram in the manual using the assembly number in the lower right hand corner of the diagram. Look at the bill of materials on the assembly diagram and find the balloon number that corresponds with the part number. That balloon number will point to the part location in the assembly.

PART DESCRIPTION INDEX				PART NUMBER INDEX			
Index	KR Part	Description	Qty.	Index	KR Part	Description	Qty.
481	106734	1/4 20 LOCK NUT WITH NYLON INSE	1	586	100129	BUSHING, SL.375ID.500OD.500LG	1
288	547199-01	ANGLE, CABINET SUPPORT	2	685	100129	BUSHING, SL.375ID.500OD.500LG	1
197	547199-02	ANGLE, CABINET SUPPORT	2	499	100132	BUSHING, SL.250ID.375OD.500LG	2
208	547199-03	ANGLE, CABINET SUPPORT	1	476	100135	BUSHING, SL.500ID.625OD.500LG	1
222	547467-02	ANGLE, SIDE TUBE MOUNT	1	630	100141	BUSHING, SL.750ID.1000OD.750LG	1
223	547467-01	ANGLE, TUBE SIDE MOUNT	1	261	100144	BUSHING, SL.625ID.750OD.625LG	1
469	545733-01	ARM, BEARING MOUNT SKID	2	592	100149	BUSHING, SL.750ID.875OD.500LG	1
626	545679-01	ARM, BELT TIGHTENER	1	477	100162	BUSHING, SL.500ID.625OD.625LG	2
692	545697-01	ARM, BELT TIGHTENER	1	584	100170	BUSHING, SL.750ID.875OD.625LG	1
705	545697-01	ARM, BELT TIGHTENER	1	683	100170	BUSHING, SL.750ID.875OD.625LG	2
467	545731-01	ARM, DISHING ADJUSTMENT	1	877	100247	BUSHING, SL.250ID.375OD.625LG	6
562	532226-02	ARM, REJECT CYLINDER	1	761	100283	BUSHING, .625ID 1.125OD	3
561	541779-02	ARM, REJECT CYLINDER	1	772	100283	BUSHING, .625ID 1.125OD	3
624	545677-01	ARM, SPRING MOUNT	2	504	100314	BUSHING, FL.313ID.438OD.250LG	1
583	545690-01	ARM, UPPER BELT AJUST	1	313	100326	BUSHING, FL.1000ID.1250OD.750LG	1
682	545690-01	ARM, UPPER BELT AJUST	1	652	100326	BUSHING, FL.1000ID.1250OD.750LG	2
689	545693-01	ARM, UPPER BELT AJUST	1	813	100326	BUSHING, FL.1000ID.1250OD.750LG	4
590	545693-02	ARM, UPPER BELT AJUST	1	798	100331	BUSHING, FL.1000ID.1250OD.1250LG	2
729	545693-03	ARM, UPPER BELT AJUST	1	612	100357	BUSHING, FL.750ID.875OD.625G	1
236	538024-01	ASSY, 1 IN. LEVELING LEG	4	666	100357	BUSHING, FL.750ID.875OD.625G	1
200	538024-02	ASSY, 1 IN. LEVELING LEG 8.00 LNG	4	783	100400	WASHER, THRUST TW31	4
226	547507-01	ASSY, ADJUST ROLLER	2	933	100401	WASHER, THRUST TB410	3
231	547507-02	ASSY, ADJUST ROLLER	2	966	100401	WASHER, THRUST TB410	2
895	547236-02	ASSY, AIR BLOW DOWN	1	155	100402	WASHER, THRUST TB612	2
345	547236-01	ASSY, AIR MANIFOLD	1	241	100402	WASHER, THRUST TB612	2
323	547201-02	ASSY, AIR REGULATOR	1	27	100407	WASHER, THRUST TW62	2
163	547235-01	ASSY, AIR VALVE	1	259	100407	WASHER, THRUST TW62	2
516	545653-01	ASSY, BACK SIDE GUIDE	1	75	100602	WASHER, FLAT 5/16ID	1
531	545657-01	ASSY, BACK SIDE GUIDE SLIDE	1	614	100602	WASHER, FLAT 5/16ID	3
489	547208-01	ASSY, BEAM SWITCH MOUNT	1	723	100602	WASHER, FLAT 5/16ID	5
435	545637-01	ASSY, BELT ADJUST	1	68	100603	WASHER, FLAT 1/4ID	11
739	545699-01	ASSY, BELT DIVERT ROLLER	1	128	100603	WASHER, FLAT 1/4ID	1
423	545738-01	ASSY, BELT DRIVE FRAME	1	378	100603	WASHER, FLAT 1/4ID	8
618	545673-01	ASSY, BELT TAKE UP	1	397	100603	WASHER, FLAT 1/4ID	12
409	545625-01	ASSY, BELT TAKEUP	2	475	100603	WASHER, FLAT 1/4ID	6

1	KR950	ASSY, COMPENSATION STACKER	1	944	100603	WASHER, FLAT 1/4ID	6
432	545636-01	ASSY, CONVEYOR DRIVE ROLLER	1	446	100604	WASHER, FLAT 1/4ID BRASS	1
917	545636-02	ASSY, CONVEYOR DRIVE ROLLER	1	479	100604	WASHER, FLAT 1/4ID BRASS	2
429	545636-03	ASSY, CONVEYOR IDLER ROLLER	2	9	100616	WASHER, FLAT 5/16ID .020TK	1
22	543923-01	ASSY, DIVERT ROLLER	2	14	100616	WASHER, FLAT 5/16ID .020TK	1
113	543923-02	ASSY, DIVERT ROLLER	4	42	100616	WASHER, FLAT 5/16ID .020TK	1
836	545779-01	ASSY, DOOR HINGE	2	123	100616	WASHER, FLAT 5/16ID .020TK	1
851	545779-01	ASSY, DOOR HINGE	2	50	100619	WASHER, FLAT 10-32	2
863	545779-01	ASSY, DOOR HINGE	2	61	100619	WASHER, FLAT 10-32	2
282	545621-01	ASSY, ELECTRICAL BOX	1	320	100629	SHIM, 5/16 X 5/8 X 1/16	2
333	208504-1	ASSY, FILTER/FINGER GUARD	2	230	100633	WASHER, 750 X .125 FLAT	2
416	547213-01	ASSY, FINGER VALVE	1	235	100633	WASHER, 750 X .125 FLAT	2
6	543902-01	ASSY, GUIDE WHEEL CONCENTRIC	2	965	101913	GEAR, 1620 .625B .188K	2
120	543902-01	ASSY, GUIDE WHEEL CONCENTRIC	2	472	102112	KNOB	1
11	543901-01	ASSY, GUIDE WHEEL ECCENTRIC	1	530	102112	KNOB	1
256	547518-02	ASSY, HANDWHEEL	1	595	102112	KNOB	1
217	547463-02	ASSY, HORIZONTAL ADJUSTMENT	1	718	102112	KNOB	1
46	543926-01	ASSY, HTD BELT TAKE UP	1	812	102112	KNOB	1
53	543926-02	ASSY, HTD BELT TAKE UP	1	610	102119	KNOB	4
247	539425-03	ASSY, HYDRALIFT LEG	1	948	102119	KNOB	2
245	547513-01	ASSY, HYDRALIFT LEG	4	529	102140	HANDLE, RELEASE 1/4-20 X 1.0	1
547	545666-01	ASSY, INFEED BELT RAMP	1	781	102140	HANDLE, RELEASE 1/4-20 X 1.0	1
358	545800-01	ASSY, INFEED CONVEYOR/FRAME	1	967	102140	HANDLE, RELEASE 1/4-20 X 1.0	2
364	543985-01	ASSY, INFEED FINGER	1	76	102149	HANDLE, RELEASE 5/16-18 X 1.26	1
804	545750-01	ASSY, INFEED LIFT	1	701	102200	COLLAR .375	1
887	547186-01	ASSY, KR950 LOGO	2	714	102200	COLLAR .375	1
835	545782-01	ASSY, LEXAN DOOR	2	735	102200	COLLAR .375	1
266	541180-02	ASSY, LH HYDRALIFT LEG	2	949	102200	COLLAR .375	4
793	538022-06	ASSY, MOTOR MOUNT	1	924	102201	COLLAR .625	16
795	530654-03	ASSY, MOTOR MTG BAR	1	817	102206	COLLAR .250	4
954	547519-01	ASSY, OUTFEED BELT ADJUST	1	593	102207	COLLAR .750	1
909	545754-01	ASSY, OUTFEED CONVEYOR	1	638	102207	COLLAR .750	4
935	545786-02	ASSY, OUTFEED CONVEYOR COVER	1	653	102217	COLLAR 1.000	2
601	547204-01	ASSY, OUTFEED CONVEYOR COVER	1	743	102217	COLLAR 1.000	4
383	543986-01	ASSY, OUTFEED FINGER	1	801	102217	COLLAR 1.000	2
359	543980-01	ASSY, PRODUCT CATCH FINGER	1	814	102217	COLLAR 1.000	2
368	543989-01	ASSY, PRODUCT CATCH FINGER	10	524	102401	GEAR, 1616 .500B .125K	2
387	543989-01	ASSY, PRODUCT CATCH FINGER	11	632	102607	SPRING, EXTENSION	1
464	545727-01	ASSY, PRODUCT DISHING	1	733	102607	SPRING, EXTENSION	1
146	543953-01	ASSY, PRODUCT LIFT	1	251	102792	SPRING, EXTENSION	1
97	543933-01	ASSY, PUSHER	1	270	102792	SPRING, EXTENSION	1
118	543948-01	ASSY, PUSHER BAR	1	278	102792	SPRING, EXTENSION	1
79	543915-01	ASSY, RETRACTABLE PRODUCT GUIDE	1	8	102908	WHEEL, GUIDE W3X	1
88	543915-02	ASSY, RETRACTABLE PRODUCT GUIDE	1	13	102908	WHEEL, GUIDE W3X	1
274	541179-02	ASSY, RH HYDRALIFT LEG 1000LB	2	122	102908	WHEEL, GUIDE W3X	1
755	545718-01	ASSY, RH SIDEGUIDE	1	7	102909	BUSHING, ADAPTER STRAIGHT B3	1
767	545719-01	ASSY, RH SIDEGUIDE	1	121	102909	BUSHING, ADAPTER STRAIGHT B3	1

619	545674-02	ASSY, ROLLER	4	12	102910	BUSHING, ADAPTER ADJ. BX3	1
17	543919-02	ASSY, SERVO MOTOR	1	16	102911	COVER, V ROLLER WC3A	1
849	545789-01	ASSY, SIDE COVER DOOR	1	109	102912	LINEAR BUSHING, THOMSON	2
861	545789-03	ASSY, SIDE COVER DOOR	1	615	102962	SPRING, COMPRESSION	1
819	545748-01	ASSY, SIDE FRAME	1	736	102962	SPRING, COMPRESSION	1
72	543910-01	ASSY, SIDE GUIDE	2	699	102964	SPRING, EXTENSION	1
520	547215-01	ASSY, SIDEGUIDE ADJUST SHAFT	1	712	102964	SPRING, EXTENSION	1
900	547461-01	ASSY, STACK LIGHT	1	66	103104	BEARING, FLAT .250	11
186	545602-01	ASSY, STACKER CABINET	1	447	103104	BEARING, FLAT .250	2
291	547187-01	ASSY, STACKER CONTROL PANEL	1	470	103105	BEARING, FLAT .250 ID .750 OD	6
422	545632-01	ASSY, STACKER FLAT BELT	1	563	103106	BEARING, FLAT .375	4
64	543962-01	ASSY, TABLE ROLLER	2	636	103106	BEARING, FLAT .375	2
625	545678-01	ASSY, TAKEUP 1 IN BELT	4	697	103106	BEARING, FLAT .375	2
691	545696-01	ASSY, TAKEUP 1 IN BELT	1	710	103106	BEARING, FLAT .375	2
704	545696-02	ASSY, TAKEUP 1 IN BELT	1	414	103110	BEARING, FLAT .625	1
37	543896-01	ASSY, TURN TABLE	1	229	103112	BEARING, FLAT .750	2
38	543972-01	ASSY, TURN TABLE	1	234	103112	BEARING, FLAT .750	2
2	543899-01	ASSY, TURN TABLE AND MOUNT	1	576	103112	BEARING, FLAT .750	2
3	543994-01	ASSY, TURN TABLE DRIVE	1	597	103112	BEARING, FLAT .750	2
32	547182-01	ASSY, TURN TABLE GUIDE	1	622	103112	BEARING, FLAT .750	1
663	545684-01	ASSY, UPPER BELT	1	676	103112	BEARING, FLAT .750	2
565	545704-01	ASSY, UPPER BELT	1	913	103405	CAM FOLLOWER	3
670	547766-01	ASSY, UPPER BELT	1	959	103405	CAM FOLLOWER	4
569	547766-02	ASSY, UPPER BELT	1	557	103500	BEARING - ROD END	1
745	545707-01	ASSY, UPPER SIDEGUIDE	1	588	103500	BEARING - ROD END	1
553	534814-07	ASSY, VALVE CYLINDER PLATE	1	687	103500	BEARING - ROD END	1
695	510611-1A	ASSY-ROLLER	1	721	103503	BEARING - ROD END	2
708	510611-1A	ASSY-ROLLER	1	523	103803	BEARING, HUB .500	2
634	510611A	ASSY-ROLLER	1	24	103804	BEARING, HUB .625	2
129	190965	BALL PLUNGER, DELRIN NOSE 3/8-16	2	115	103804	BEARING, HUB .625	2
373	545623-01	BAR, FINGER SLIDE MOUNT	2	406	103804	BEARING, HUB .625	2
392	545623-01	BAR, FINGER SLIDE MOUNT	2	413	103804	BEARING, HUB .625	1
834	545776-01	BAR, FRAME MOUNT	4	440	103804	BEARING, HUB .625	4
824	545766-01	BAR, FRAME SPACER	10	552	103804	BEARING, HUB .625	2
972	547526-01	BAR, FRAME SPACER	2	753	103804	BEARING, HUB .625	4
319	547222-04	BAR, FRAME SUPPORT	2	920	103804	BEARING, HUB .625	6
828	545774-01	BAR, INFED DOOR MOUNT	1	960	103804	BEARING, HUB .625	6
150	543955-01	BAR, LIFT MOUNT SPACER	2	104	103805	BEARING, HUB .750	2
152	543957-01	BAR, LIFT SHAFT MOUNT	1	577	103805	BEARING, HUB .750	4
874	545791-01	BAR, MAGNET MOUNT	2	596	103805	BEARING, HUB .750	2
796	530510-03	BAR, MOTOR MOUNT PIVOT	2	621	103805	BEARING, HUB .750	1
125	543950-01	BAR, PUSHER	1	677	103805	BEARING, HUB .750	2
890	547217-01	BAR, TOP MOUNT	2	428	103808	BEARING, HUB 1.000	2
891	547217-02	BAR, TOP MOUNT	2	431	103808	BEARING, HUB 1.000	2
453	545651-01	BAR, UPPER BELT ADJUST SPACER	2	678	103808	BEARING, HUB 1.000	2
656	508049-9	BAR, UPPER STATIC SUPPORT	4	700	103808	BEARING, HUB 1.000	1
188	545604-01	BASE, CABINET	1	713	103808	BEARING, HUB 1.000	1

494	202261-5	BEAMSWITCH, RETROREFLECTIVE	1	734	103808	BEARING, HUB 1.000	2
607	202261-5	BEAMSWITCH, RETROREFLECTIVE	1	742	103808	BEARING, HUB 1.000	2
557	103500	BEARING - ROD END	1	599	104100	SNAPRING, .375	1
588	103500	BEARING - ROD END	1	629	104100	SNAPRING, .375	1
687	103500	BEARING - ROD END	1	694	104100	SNAPRING, .375	1
721	103503	BEARING - ROD END	2	707	104100	SNAPRING, .375	1
66	103104	BEARING, FLAT .250	11	726	104100	SNAPRING, .375	1
447	103104	BEARING, FLAT .250	2	598	104103	SNAPRING, .750	2
470	103105	BEARING, FLAT .250 ID .750 OD	6	725	104103	SNAPRING, .750	2
563	103106	BEARING, FLAT .375	4	26	104104	SNAPRING, .625	1
636	103106	BEARING, FLAT .375	2	791	104104	SNAPRING, .625	4
697	103106	BEARING, FLAT .375	2	478	104106	SNAPRING, .500	4
710	103106	BEARING, FLAT .375	2	227	104415	BOLT, HEX HEAD 3/4-10X2.00	1
414	103110	BEARING, FLAT .625	1	232	104415	BOLT, HEX HEAD 3/4-10X2.00	1
229	103112	BEARING, FLAT .750	2	371	105221	PIN, ROLL .094X.500	2
234	103112	BEARING, FLAT .750	2	390	105221	PIN, ROLL .094X.500	2
576	103112	BEARING, FLAT .750	2	559	105633	SHAFT, THREADED 3/8-24 X 2.375	1
597	103112	BEARING, FLAT .750	2	545	106711	NUT, HEX #6-32	6
622	103112	BEARING, FLAT .750	1	254	106712	NUT, HEX 5/16-18	1
676	103112	BEARING, FLAT .750	2	507	106720	NUT, HEX 1/4-20	1
523	103803	BEARING, HUB .500	2	633	106720	NUT, HEX 1/4-20	1
24	103804	BEARING, HUB .625	2	731	106720	NUT, HEX 1/4-20	2
115	103804	BEARING, HUB .625	2	816	106720	NUT, HEX 1/4-20	2
406	103804	BEARING, HUB .625	2	879	106720	NUT, HEX 1/4-20	6
413	103804	BEARING, HUB .625	1	481	106734	1/4 20 LOCK NUT WITH NYLON INSE	1
440	103804	BEARING, HUB .625	4	503	106736	NUT, HEX #10-32	2
552	103804	BEARING, HUB .625	2	474	106800	SCREW, BUTTON HEAD 1/4X.750	6
753	103804	BEARING, HUB .625	4	787	106800	SCREW, BUTTON HEAD 1/4X.750	4
920	103804	BEARING, HUB .625	6	482	106801	SCREW, BUTTON HEAD 1/4X.875	1
960	103804	BEARING, HUB .625	6	846	106810	SCREW, BUTTON HEAD #10-32X.500	6
104	103805	BEARING, HUB .750	2	87	106811	SCREW, BUTTON HEAD #10-32X.250	2
577	103805	BEARING, HUB .750	4	96	106811	SCREW, BUTTON HEAD #10-32X.250	2
596	103805	BEARING, HUB .750	2	139	106811	SCREW, BUTTON HEAD #10-32X.250	4
621	103805	BEARING, HUB .750	1	161	106811	SCREW, BUTTON HEAD #10-32X.250	2
677	103805	BEARING, HUB .750	2	317	106811	SCREW, BUTTON HEAD #10-32X.250	4
428	103808	BEARING, HUB 1.000	2	353	106811	SCREW, BUTTON HEAD #10-32X.250	4
431	103808	BEARING, HUB 1.000	2	403	106811	SCREW, BUTTON HEAD #10-32X.250	6
678	103808	BEARING, HUB 1.000	2	462	106811	SCREW, BUTTON HEAD #10-32X.250	6
700	103808	BEARING, HUB 1.000	1	541	106811	SCREW, BUTTON HEAD #10-32X.250	4
713	103808	BEARING, HUB 1.000	1	762	106811	SCREW, BUTTON HEAD #10-32X.250	4
734	103808	BEARING, HUB 1.000	2	773	106811	SCREW, BUTTON HEAD #10-32X.250	4
742	103808	BEARING, HUB 1.000	2	790	106811	SCREW, BUTTON HEAD #10-32X.250	2
662	111873	BELT, FLAT 133.25 X 1.000	4	932	106811	SCREW, BUTTON HEAD #10-32X.250	8
744	111872	BELT, FLAT 138.25 X .75	2	979	106811	SCREW, BUTTON HEAD #10-32X.250	4
923	111871	BELT, FLAT 52.000 X 1.5	4	318	106815	SCREW, BUTTON HEAD 1/4X.625	4
983	111895	BELT, FLAT 70.750 X 1.500	4	947	106815	SCREW, BUTTON HEAD 1/4X.625	4
415	109141	BELT, HTD 20008M20	2	67	106816	SCREW, BUTTON HEAD 1/4X.375	11

357	109134-1	BELT, HTD 2400-8M-20	1	131	106818	SCREW, BUTTON HEAD 1/4X.500	2
117	109138	BELT, HTD 8M-1440-20	1	448	106818	SCREW, BUTTON HEAD 1/4X.500	2
754	109138-1	BELT, HTD TIMING 1440-8M-20	1	582	106818	SCREW, BUTTON HEAD 1/4X.500	2
928	108914-17	BELT, TIMING 124L075	1	660	106818	SCREW, BUTTON HEAD 1/4X.500	8
738	108905-12	BELT, TIMING 187L075	1	943	106818	SCREW, BUTTON HEAD 1/4X.500	24
803	108952-17	BELT, TIMING 225L075	1	500	107000	BOLT, SHOULDER 1/4X1/2	2
393	545629-01	BLOCK, AIR CYLINDER FINGER	1	505	107101	BOLT, SHOULDER 5/16X3/8	1
81	543916-01	BLOCK, AIR CYLINDER MOUNT	1	964	107102	BOLT, SHOULDER 5/16X1/2	4
90	543916-01	BLOCK, AIR CYLINDER MOUNT	1	722	107103	BOLT, SHOULDER 5/16X5/8	1
166	543970-01	BLOCK, AIR MANIFOLD	1	782	107103	BOLT, SHOULDER 5/16X5/8	1
346	543970-02	BLOCK, AIR MANIFOLD	1	915	107206	BOLT, SHOULDER 3/8X1/2	4
896	543970-03	BLOCK, AIR MANIFOLD	1	648	107307	BOLT, HEX HEAD 3/8-16X1.25	1
214	547229-01	BLOCK, AIR MANIFOLD	1	286	107325	HEX HEAD BOLT 1/4-20 X 1.50"	4
437	545652-01	BLOCK, BEARING	2	127	107327	BOLT, 1/4-20 X .500	2
108	543943-01	BLOCK, BUSHING MOUNT	2	10	107330	BOLT, HEX HEAD 5/16-18X1.50	1
809	190841	BLOCK, CYLINDER MOUNT	2	15	107330	BOLT, HEX HEAD 5/16-18X1.50	1
837	545780-01	BLOCK, DOOR HINGE MOUNT	1	124	107330	BOLT, HEX HEAD 5/16-18X1.50	1
852	545780-01	BLOCK, DOOR HINGE MOUNT	1	647	107332	BOLT, HEX HEAD 3/8-16X2.00	1
864	545780-01	BLOCK, DOOR HINGE MOUNT	1	210	107339	BOLT, HEX HEAD 5/16-18X1.25	6
848	545790-01	BLOCK, DOOR KEEPER	2	211	107348	BOLT, HEX HEAD 5/16-18X1.75	6
860	545790-01	BLOCK, DOOR KEEPER	2	316	107401	SCREW, SHCS 1/4-20X.750	4
872	545790-01	BLOCK, DOOR KEEPER	2	396	107401	SCREW, SHCS 1/4-20X.750	4
365	543987-01	BLOCK, FINGER SLIDE	4	495	107401	SCREW, SHCS 1/4-20X.750	2
384	543987-01	BLOCK, FINGER SLIDE	4	732	107401	SCREW, SHCS 1/4-20X.750	1
442	543987-01	BLOCK, FINGER SLIDE	3	971	107401	SCREW, SHCS 1/4-20X.750	4
534	543987-01	BLOCK, FINGER SLIDE	4	70	107402	SCREW, SHCS 1/4-20X1.250	5
756	543987-01	BLOCK, FINGER SLIDE	4	730	107402	SCREW, SHCS 1/4-20X1.250	1
768	543987-01	BLOCK, FINGER SLIDE	4	382	107403	SCREW, SHCS 1/4-20X.375	8
441	543987-02	BLOCK, FINGER SLIDE	1	401	107403	SCREW, SHCS 1/4-20X.375	8
444	543987-03	BLOCK, FINGER SLIDE	1	970	107404	SCREW, SHCS 1/4-20X1.500	2
445	543987-04	BLOCK, FINGER SLIDE	1	502	107406	SCREW, SHCS 10-32X1.250	4
497	547233-01	BLOCK, GUIDE PIVOT	2	59	107407	SCREW, SHCS 1/4-20X1.000	2
498	547234-01	BLOCK, GUIDE PIVOT	2	456	107407	SCREW, SHCS 1/4-20X1.000	4
271	537596-03	BLOCK, HYDRAULIC LIFT LH	2	512	107407	SCREW, SHCS 1/4-20X1.000	4
279	537596-04	BLOCK, HYDRAULIC LIFT LH	2	600	107407	SCREW, SHCS 1/4-20X1.000	4
740	545700-01	BLOCK, IDLER ROLLER BEARING	2	631	107407	SCREW, SHCS 1/4-20X1.000	1
149	543954-01	BLOCK, LIFT CYLINDER MOUNT	1	727	107407	SCREW, SHCS 1/4-20X1.000	1
159	543960-01	BLOCK, LIFT CYLINDER MOUNT	1	878	107407	SCREW, SHCS 1/4-20X1.000	6
160	543961-01	BLOCK, LIFT CYLINDER MOUNT	1	953	107407	SCREW, SHCS 1/4-20X1.000	2
156	543959-01	BLOCK, LIFT SHAFT BUSHING	2	51	107408	SCREW, SHCS 10-32X1.000	2
154	543956-01	BLOCK, LIFT TABLE MOUNT	1	62	107408	SCREW, SHCS 10-32X1.000	2
151	543956-02	BLOCK, LIFT TABLE MOUNT	1	137	107408	SCREW, SHCS 10-32X1.000	6
807	532129-01	BLOCK, LOCK DOWN	1	579	107409	SCREW, SHCS 10-32X.500	8
952	547458-01	BLOCK, OUTFEED TAKEUP	2	680	107409	SCREW, SHCS 10-32X.500	8
74	543912-01	BLOCK, PRODUCT GUIDE MOUNT	1	977	107409	SCREW, SHCS 10-32X.500	4
100	543935-01	BLOCK, PUSHER AIR CYLINDER MNT	1	402	107410	SCREW, SHCS 1/4-20X.500	3
538	545663-01	BLOCK, RACK MOUNT	2	480	107410	SCREW, SHCS 1/4-20X.500	1

572	547763-01	BLOCK, ROLLER STUD MOUNT	1	542	107410	SCREW, SHCS 1/4-20X.500	10
673	547763-01	BLOCK, ROLLER STUD MOUNT	1	580	107410	SCREW, SHCS 1/4-20X.500	8
262	547517-02	BLOCK, SCREW CAPTURE	1	643	107410	SCREW, SHCS 1/4-20X.500	4
73	543907-01	BLOCK, SIDE GUIDE ADJUST CLAMP	1	681	107410	SCREW, SHCS 1/4-20X.500	10
260	547511-02	BLOCK, THREADED ROD MOUNT	1	981	107410	SCREW, SHCS 1/4-20X.500	12
356	547239-02	BLOCKOFF, PHOENIX CONNECTOR	1	455	107411	SCREW, SHCS 1/4-20X.875	12
127	107327	BOLT, 1/4-20 X .500	2	763	107411	SCREW, SHCS 1/4-20X.875	6
227	104415	BOLT, HEX HEAD 3/4-10X2.00	1	774	107411	SCREW, SHCS 1/4-20X.875	6
232	104415	BOLT, HEX HEAD 3/4-10X2.00	1	934	107411	SCREW, SHCS 1/4-20X.875	7
648	107307	BOLT, HEX HEAD 3/8-16X1.25	1	974	107411	SCREW, SHCS 1/4-20X.875	4
647	107332	BOLT, HEX HEAD 3/8-16X2.00	1	142	107417	SCREW, SHCS 10-32X.375	5
243	RHB085	BOLT, HEX HEAD 3/8-16X2.25	12	253	107422	SCREW, SHCS 5/16-18X1.000	1
210	107339	BOLT, HEX HEAD 5/16-18X1.25	6	454	107425	SCREW, SHCS 1/4-20X1.750	4
10	107330	BOLT, HEX HEAD 5/16-18X1.50	1	43	107427	SCREW, SHCS 5/16-18X.500	1
15	107330	BOLT, HEX HEAD 5/16-18X1.50	1	56	107427	SCREW, SHCS 5/16-18X.500	1
124	107330	BOLT, HEX HEAD 5/16-18X1.50	1	649	107427	SCREW, SHCS 5/16-18X.500	6
211	107348	BOLT, HEX HEAD 5/16-18X1.75	6	377	107428	SCREW, SHCS 1/4-20X.625	16
500	107000	BOLT, SHOULDER 1/4X1/2	2	399	107428	SCREW, SHCS 1/4-20X.625	16
915	107206	BOLT, SHOULDER 3/8X1/2	4	540	107428	SCREW, SHCS 1/4-20X.625	2
964	107102	BOLT, SHOULDER 5/16X1/2	4	703	107428	SCREW, SHCS 1/4-20X.625	2
505	107101	BOLT, SHOULDER 5/16X3/8	1	716	107428	SCREW, SHCS 1/4-20X.625	2
722	107103	BOLT, SHOULDER 5/16X5/8	1	785	107428	SCREW, SHCS 1/4-20X.625	4
782	107103	BOLT, SHOULDER 5/16X5/8	1	69	107429	SCREW, SHCS 10-32X.625	8
886	545798-01	BOX, BUTTON	1	141	107429	SCREW, SHCS 10-32X.625	5
336	530441-06	BOX, ELECTRICAL INLET 30A	1	273	107429	SCREW, SHCS 10-32X.625	2
289	547202-01	BOX, REGULATOR MOUNT	1	501	107429	SCREW, SHCS 10-32X.625	4
299	547188-01	BOX, STACKER CONTROL PANEL	1	976	107429	SCREW, SHCS 10-32X.625	8
300	547188-02	BOX, STACKER CONTROL PANEL	2	145	107430	SCREW, SHCS 10-32X.750	8
655	547534-01	BRACKET, STATIC BAR	2	461	107430	SCREW, SHCS 10-32X.750	8
657	547534-02	BRACKET, STATIC BAR	2	140	107440	SCREW, SHCS 3/8-16X1.000	8
330	191353	BRACKET, AIR REGULATOR MOUNT	2	818	107443	SCREW, SHCS 1/4-20X2.250	1
209	545758-01	BRACKET, CONVEYOR MOUNT	6	459	107447	SCREW, SHCS 1/4-20X2.000	2
840	545781-01	BRACKET, DOOR HINGE MOUNT	1	815	107447	SCREW, SHCS 1/4-20X2.000	1
855	545781-01	BRACKET, DOOR HINGE MOUNT	1	515	107448	SCREW, SHCS 5/16-18X2.25	2
867	545781-01	BRACKET, DOOR HINGE MOUNT	1	613	107448	SCREW, SHCS 5/16-18X2.25	1
876	545792-01	BRACKET, DOOR STOP	2	728	107448	SCREW, SHCS 5/16-18X2.25	1
207	545611-01	BRACKET, END CHANNEL MOUNT	1	170	107468	SCREW, SHCS 4-40X1.000	6
379	545735-01	BRACKET, FINGER MOUNT BAR	2	376	107500	SCREW, FLATHEAD 10-32X.500	8
400	545735-01	BRACKET, FINGER MOUNT BAR	2	398	107500	SCREW, FLATHEAD 10-32X.500	12
272	537597-03	BRACKET, HYDRAULIC LIFT SPRING	1	255	107502	SCREW, FLATHEAD 10-32X.375	4
280	537597-04	BRACKET, HYDRAULIC LIFT SPRING	1	52	107506	SCREW, FLATHEAD 1/4-20X.750	2
609	547207-01	BRACKET, INFID BELT COVER MNT	2	483	107521	SCREW, FLATHEAD 10-32X.250	6
650	547223-01	BRACKET, INFEED RAMP SUPP	1	980	107521	SCREW, FLATHEAD 10-32X.250	6
651	547223-02	BRACKET, INFEED RAMP SUPP	1	764	107526	SCREW, FLATHEAD 10-32X.625	4
351	547239-01	BRACKET, PHOENIX CONNECTOR	1	775	107526	SCREW, FLATHEAD 10-32X.625	4
30	543931-01	BRACKET, PROX MOUNT	1	178	107537	SCREW, FLATHEAD 1/4-20X.875	4
485	545736-01	BRACKET, PROX MOUNT	1	130	107541	SCREW, FLATHEAD 5/16-18X.750	2

82	547460-01	BRACKET, PROX MOUNT	1	183	107546	SCREW, FLHD UNDERCUT 10-32X.250	12
95	547460-01	BRACKET, PROX MOUNT	1	484	107546	SCREW, FLHD UNDERCUT 10-32X.250	18
63	543932-01	BRACKET, PROX SCREW	4	546	107546	SCREW, FLHD UNDERCUT 10-32X.250	20
380	545737-01	BRACKET, PROX TRIGGER	1	473	107633	SCREW, SET 1/4-20X.250	2
65	543963-01	BRACKET, PULLEY ROLLER	1	800	108809	PULLEY, TIMING 12L075 .625B .188K	1
126	543965-02	BRACKET, PUSHER BELT MNT	1	511	108820	PULLEY, TIMING 16L075 .750B .188K	1
539	545664-01	BRACKET, RACK MOUNT	2	926	108871	PULLEY, TIMING 14L075 .750B .188K	1
672	547764-01	BRACKET, ROLLER ARM	2	117	109138	BELT, HTD 8M-1440-20	1
571	547764-02	BRACKET, ROLLER ARM	2	415	109141	BELT, HTD 20008M20	2
892	547227-01	BRACKET, SAFETY SWITCH MNT	1	510	109330	PULLEY, TIMING 15L05 .750B .188K	1
496	547226-01	BRACKET, SIDEGUIDE JOGGER	1	668	109330	PULLEY, TIMING 15L05 .750B .188K	1
698	547231-01	BRACKET, SPRING ADJUST	1	329	109544	NIPPLE, 1/4 NPT AIR GUN	1
711	547231-01	BRACKET, SPRING ADJUST	1	98	109692	CYLINDER, 8" STROKE 2-1/2 DIA AIR	1
639	545682-01	BRACKET, SPRING ANCHOR	4	147	109693	CYLINDER, 12 INCH LIFT	1
908	547779-01	BRACKET, SPRING MOUNT	1	80	109694	CYLINDER, PRODUCT GUIDE AIR	1
250	537371-01	BRACKET, SPRING RETURN MOUNT	1	89	109694	CYLINDER, PRODUCT GUIDE AIR	1
269	537371-01	BRACKET, SPRING RETURN MOUNT	1	408	109732	PULLEY, TIMING 228M20 .625B .188KEY	2
277	537371-01	BRACKET, SPRING RETURN MOUNT	1	412	109733	PULLEY, TIMING 228M20 1.5738 BORE	1
902	547462-01	BRACKET, STACK LIGHT MNT	1	927	109968	PULLEY, TIMING 14L075 .625B .188K	1
658	547536-01	BRACKET, TABLETOP MOUNT	4	58	111509	WASHER, FLAT .257ID .515OD .120TH	2
165	545622-01	BRACKET, TERMINAL MOUNT	1	702	111509	WASHER, FLAT .257ID .515OD .120TH	2
761	100283	BUSHING, .625ID 1.125OD	3	715	111509	WASHER, FLAT .257ID .515OD .120TH	2
772	100283	BUSHING, .625ID 1.125OD	3	923	111871	BELT, FLAT 52.000 X 1.5	4
157	547532-01	BUSHING, .625ID 1.125OD CROWNED	2	744	111872	BELT, FLAT 138.25 X .75	2
366	547532-01	BUSHING, .625ID 1.125OD CROWNED	4	662	111873	BELT, FLAT 133.25 X 1.000	4
385	547532-01	BUSHING, .625ID 1.125OD CROWNED	4	983	111895	BELT, FLAT 70.750 X 1.500	4
443	547532-01	BUSHING, .625ID 1.125OD CROWNED	4	328	190606	FITTING - 90 DEG 1/4 NPT	1
535	547532-01	BUSHING, .625ID 1.125OD CROWNED	4	202	190634	FOOT, MOUNTING	1
12	102910	BUSHING, ADAPTER ADJ. BX3	1	238	190634	FOOT, MOUNTING	1
7	102909	BUSHING, ADAPTER STRAIGHT B3	1	192	190670	CASTER, 3.500 SWIVEL	4
121	102909	BUSHING, ADAPTER STRAIGHT B3	1	604	190758	MOUNTING BLOCK	4
504	100314	BUSHING, FL.313ID.438OD.250LG	1	841	190769	MAGNET, BUNTING	1
612	100357	BUSHING, FL.750ID.875OD.625G	1	845	190769	MAGNET, BUNTING	2
666	100357	BUSHING, FL.750ID.875OD.625G	1	856	190769	MAGNET, BUNTING	1
313	100326	BUSHING, FL.1000ID1.250OD.750LG	1	859	190769	MAGNET, BUNTING	2
652	100326	BUSHING, FL.1000ID1.250OD.750LG	2	868	190769	MAGNET, BUNTING	1
813	100326	BUSHING, FL.1000ID1.250OD.750LG	4	871	190769	MAGNET, BUNTING	2
798	100331	BUSHING, FL.1000ID1.250OD1.250LG	2	875	190769	MAGNET, BUNTING	2
499	100132	BUSHING, SL.250ID.375OD.500LG	2	264	190780	LABEL, TIMING BELT WARNING	3
877	100247	BUSHING, SL.250ID.375OD.625LG	6	606	190782	LABEL, LOOSE CLOTHES	1
586	100129	BUSHING, SL.375ID.500OD.500LG	1	905	190782	LABEL, LOOSE CLOTHES	2
685	100129	BUSHING, SL.375ID.500OD.500LG	1	904	190784	LABEL, STAMPING WARNING	2
476	100135	BUSHING, SL.500ID.625OD.500LG	1	605	190785	LABEL, ROLLER VERT WARNING	1
477	100162	BUSHING, SL.500ID.625OD.625LG	2	903	190785	LABEL, ROLLER VERT WARNING	4
261	100144	BUSHING, SL.625ID.750OD.625LG	1	355	190788	LABEL, VOLTAGE WARNING LARGE	2
592	100149	BUSHING, SL.750ID.875OD.500LG	1	354	190795	LABEL, 220 VOLTS	1
584	100170	BUSHING, SL.750ID.875OD.625LG	1	809	190841	BLOCK, CYLINDER MOUNT	2

683	100170	BUSHING, SL.750ID.875OD.625LG	2	308	190955	HANDLE	2
630	100141	BUSHING, SL.750ID1.000OD.750LG	1	645	190955	HANDLE	1
309	201126-1	BUTTON, JOG	2	844	190955	HANDLE	1
881	201126-1	BUTTON, JOG	2	858	190955	HANDLE	1
304	201125-5	BUTTON, POWER OFF	1	870	190955	HANDLE	1
880	201125-5	BUTTON, POWER OFF	1	873	190955	HANDLE	2
305	201124-4	BUTTON, POWER ON	1	940	190955	HANDLE	2
306	201124-2	BUTTON, START	1	129	190965	BALL PLUNGER, DELRIN NOSE 3/8-16	2
882	201124-2	BUTTON, START	1	838	190967	HAND PLUNGER, 3/8-16X1.13	1
307	201125-3	BUTTON, STOP	1	853	190967	HAND PLUNGER, 3/8-16X1.13	1
883	201125-3	BUTTON, STOP	1	865	190967	HAND PLUNGER, 3/8-16X1.13	1
913	103405	CAM FOLLOWER	3	237	191010	LEVELING BOLT, CABINET	1
959	103405	CAM FOLLOWER	4	203	191011	NUT, CABINET LEVELING	1
192	190670	CASTER, 3.500 SWIVEL	4	239	191011	NUT, CABINET LEVELING	1
196	539527-06	CHANNEL, PUMP MOUNT	1	339	191223	HINGE, CONCEALED REMOVABLE	2
205	545610-01	CHANNEL, REMOVABLE END	1	343	191223	HINGE, CONCEALED REMOVABLE	2
555	508175	CLEVIS, AIR CYLINDER	1	19	191237	REDUCER, SERVO MOTOR	1
817	102206	COLLAR .250	4	405	191294	CYLINDER, AIR 1.25 D 10IN STROKE	1
701	102200	COLLAR .375	1	171	191296	FITTING, STRAIGHT 1/4 T 1/8 NPT	4
714	102200	COLLAR .375	1	172	191296	FITTING, STRAIGHT 1/4 T 1/8 NPT	1
735	102200	COLLAR .375	1	348	191296	FITTING, STRAIGHT 1/4 T 1/8 NPT	4
949	102200	COLLAR .375	4	349	191296	FITTING, STRAIGHT 1/4 T 1/8 NPT	1
924	102201	COLLAR .625	16	215	191298	FITTING, STRAIGHT 3/8 T 1/4 NPT	1
593	102207	COLLAR .750	1	347	191298	FITTING, STRAIGHT 3/8 T 1/4 NPT	2
638	102207	COLLAR .750	4	143	191319	SCREW, SET 1/2-20X.500	5
653	102217	COLLAR 1.000	2	144	191336	FITTING, 1/4T 1/4NPT SPEED CONTROL	2
743	102217	COLLAR 1.000	4	86	191337	FITTING, ELBOW 1/8 NPT 1/4 TUBE	2
801	102217	COLLAR 1.000	2	94	191337	FITTING, ELBOW 1/8 NPT 1/4 TUBE	2
814	102217	COLLAR 1.000	2	182	191337	FITTING, ELBOW 1/8 NPT 1/4 TUBE	1
352	200491-2	CONNECTOR, PHOENIX	6	419	191337	FITTING, ELBOW 1/8 NPT 1/4 TUBE	1
302	202537	CONSOLE, TOUCH SCREEN	1	560	191337	FITTING, ELBOW 1/8 NPT 1/4 TUBE	5
931	545763-01	COVER, CONVEYOR BOTTOM	1	897	191337	FITTING, ELBOW 1/8 NPT 1/4 TUBE	1
982	547529-01	COVER, CONVEYOR BOTTOM	1	176	191338	FITTING, 1/4 TUBE TEE	2
213	547228-01	COVER, CONVEYOR PLUG	3	420	191339	FITTING, 1/8 NPT 1/4 TUBE ELBOW SP	1
825	545767-01	COVER, FRAME END	1	173	191340	MUFFLER, 1/8 NPT AIR	6
829	545770-01	COVER, FRONT LEXAN	1	418	191340	MUFFLER, 1/8 NPT AIR	2
212	547220-01	COVER, HYDRALIFT	1	169	191341	VALVE, TWO POSITION SINGLE	1
252	547515-01	COVER, HYDRALIFT LEG	1	167	191342	VALVE, THREE POSTION CLOSED CENTER	1
823	545765-01	COVER, INFEED FRAME	1	417	191342	VALVE, THREE POSTION CLOSED CENTER	1
894	545765-02	COVER, INFEED FRAME	1	168	191343	VALVE, THREE POSITION EXHAUST CTR	1
842	545778-01	COVER, LOWER SIDE LEXAN	1	327	191344	FITTING, 1/4 NPT 3/8 TUBE ELBOW	1
942	545785-03	COVER, OUTFEED CONV. TOP	1	898	191349	VALVE, 1/4 NPT MALE	2
822	545764-01	COVER, OUTFEED FRAME	1	899	191350	HOSE, 1/4 ID 13"LNG	2
826	545768-01	COVER, OUTFEED TOP LEXAN	1	216	191351	FITTING, ELBOW .375T .250NPT	1
641	545795-01	COVER, REJECT AIR CYLINDER	1	174	191352	FITTING, 1/4NPT 3/8TUBE ROTARY	1
642	545796-01	COVER, REJECT AIR CYLINDER	1	330	191353	BRACKET, AIR REGULATOR MOUNT	2
831	545772-01	COVER, TIMING BELT	1	240	191361	KNOB, 375-16 QUICK ADJUST	2

827	545769-01	COVER, TOP LEXAN	1	350	191381	ELBOW, FEMALE 1/4 TUBE	1
937	545785-02	COVER, TUNNEL OUTFEED	1	331	191393	MUFFLER, 1/4 NPT	1
850	545777-01	COVER, UPPER SIDE LEXAN	1	184	191394	FITTING, FLOW CONTROL METER OUT	1
862	545777-01	COVER, UPPER SIDE LEXAN	1	185	191394	FITTING, FLOW CONTROL METER OUT	1
16	102911	COVER, V ROLLER WC3A	1	421	191395	FITTING, FLOW CONTROL METER OUT	1
147	109693	CYLINDER, 12 INCH LIFT	1	20	200615	MOTOR, SERVO	1
98	109692	CYLINDER, 8" STROKE 2-1/2 DIA AIR	1	884	201164	PLATE, YELLOW POWER OFF LABEL	1
405	191294	CYLINDER, AIR 1.25 D 10IN STROKE	1	303	201169	PLATE, CUSTOM LABEL	6
554	190803-1	CYLINDER, AVB1 X 1B W/SHOCK PADS	1	885	201169	PLATE, CUSTOM LABEL	4
249	191029-2	CYLINDER, LIFT CB415	1	302	202537	CONSOLE, TOUCH SCREEN	1
268	191032-02	CYLINDER, LIFT CB615 1000LB	1	558	202708	VALVE, THREE WAY AIR	1
276	191032-02	CYLINDER, LIFT CB615 1000LB	1	332	208503	FAN, SUNON SP100A	2
80	109694	CYLINDER, PRODUCT GUIDE AIR	1	335	208504	FILTER, FAN	1
89	109694	CYLINDER, PRODUCT GUIDE AIR	1	334	208505	GUARD, FINGER	1
204	190689-1	DOOR LATCH	6	310	209016	KNOB, POT	2
344	190689-1	DOOR LATCH	2	556	508055	LINK, GATE	1
338	545617-01	DOOR, CONTROL BOX	1	555	508175	CLEVIS, AIR CYLINDER	1
342	545619-01	DOOR, CONTROL BOX	1	635	510611	ROLLER, IDLER	1
199	545608-01	DOOR, DROPOUT CABINET	3	258	102108-4	HANDWHEEL, CLUTCH BEARING	1
350	191381	ELBOW, FEMALE 1/4 TUBE	1	315	102134-1	HANDLE - RELEASE	1
938	547530-01	END, TUNNEL COVER	1	811	105601-1	SHAFT, THREADED 3/8-16	1
939	547530-02	END, TUNNEL COVER	1	738	108905-12	BELT, TIMING 187L075	1
332	208503	FAN, SUNON SP100A	2	928	108914-17	BELT, TIMING 124L075	1
325	191299-1	FILTER, AIR	1	803	108952-17	BELT, TIMING 225L075	1
335	208504	FILTER, FAN	1	357	109134-1	BELT, HTD 2400-8M-20	1
369	543990-01	FINGER, PRODUCT CATCH	1	754	109138-1	BELT, HTD TIMING 1440-8M-20	1
388	543990-01	FINGER, PRODUCT CATCH	1	907	190619-1	PLATE, NAME	1
328	190606	FITTING - 90 DEG 1/4 NPT	1	204	190689-1	DOOR LATCH	6
327	191344	FITTING, 1/4 NPT 3/8 TUBE ELBOW	1	344	190689-1	DOOR LATCH	2
176	191338	FITTING, 1/4 TUBE TEE	2	554	190803-1	CYLINDER, AVB1 X 1B W/SHOCK PADS	1
174	191352	FITTING, 1/4NPT 3/8TUBE ROTARY	1	810	190823-1	GAS SPRING, 100LB GAS-175	1
144	191336	FITTING, 1/4T 1/4NPT SPEED CONTROL	2	201	191010-3	LEVELING BOLT, CABINET	1
420	191339	FITTING, 1/8 NPT 1/4 TUBE ELBOW SP	1	249	191029-2	CYLINDER, LIFT CB415	1
216	191351	FITTING, ELBOW .375T .250NPT	1	248	191029-3	GLIDE, SUSPA	1
86	191337	FITTING, ELBOW 1/8 NPT 1/4 TUBE	2	267	191029-3	GLIDE, SUSPA	1
94	191337	FITTING, ELBOW 1/8 NPT 1/4 TUBE	2	275	191029-3	GLIDE, SUSPA	1
182	191337	FITTING, ELBOW 1/8 NPT 1/4 TUBE	1	281	191032-01	PUMP, MOVOTEC PB4615FC	1
419	191337	FITTING, ELBOW 1/8 NPT 1/4 TUBE	1	268	191032-02	CYLINDER, LIFT CB615 1000LB	1
560	191337	FITTING, ELBOW 1/8 NPT 1/4 TUBE	5	276	191032-02	CYLINDER, LIFT CB615 1000LB	1
897	191337	FITTING, ELBOW 1/8 NPT 1/4 TUBE	1	325	191299-1	FILTER, AIR	1
184	191394	FITTING, FLOW CONTROL METER OUT	1	324	191300-1	REGULATOR, AIR	1
185	191394	FITTING, FLOW CONTROL METER OUT	1	326	191303-1	VALVE, AIR SAFETY	1
421	191395	FITTING, FLOW CONTROL METER OUT	1	799	200151-2	MOTOR, LEESON DC 1 HP	1
171	191296	FITTING, STRAIGHT 1/4 T 1/8 NPT	4	925	200169-3	MOTOR, BODINE 4179	1
172	191296	FITTING, STRAIGHT 1/4 T 1/8 NPT	1	352	200491-2	CONNECTOR, PHOENIX	6
348	191296	FITTING, STRAIGHT 1/4 T 1/8 NPT	4	950	200513-5	GROMMET, RUBBER .75IDX1.375ODX.56TH	1
349	191296	FITTING, STRAIGHT 1/4 T 1/8 NPT	1	31	201055-1	PROXIMITY	2

215	191298	FITTING, STRAIGHT 3/8 T 1/4 NPT	1	486	201055-1	PROXIMITY	1
347	191298	FITTING, STRAIGHT 3/8 T 1/4 NPT	2	306	201124-2	BUTTON, START	1
295	547193-01	FLANGE, WIRE TUBE	1	882	201124-2	BUTTON, START	1
202	190634	FOOT, MOUNTING	1	305	201124-4	BUTTON, POWER ON	1
238	190634	FOOT, MOUNTING	1	307	201125-3	BUTTON, STOP	1
821	545749-02	FRAME, LH SIDE	1	883	201125-3	BUTTON, STOP	1
941	545784-02	FRAME, OUTFEED CONVEYOR COVER	2	304	201125-5	BUTTON, POWER OFF	1
602	547206-01	FRAME, OUTFEED CONVEYOR COVER	2	880	201125-5	BUTTON, POWER OFF	1
820	545749-01	FRAME, RH SIDE	1	309	201126-1	BUTTON, JOG	2
810	190823-1	GAS SPRING, 100LB GAS-175	1	881	201126-1	BUTTON, JOG	2
524	102401	GEAR, 1616 .500B .125K	2	494	202261-5	BEAMSWITCH, RETROREFLECTIVE	1
965	101913	GEAR, 1620 .625B .188K	2	607	202261-5	BEAMSWITCH, RETROREFLECTIVE	1
102	543938-01	GEAR, 1624 PINION	1	901	202284-8	LIGHT, THREE BULB	1
458	545662-01	GEAR, SIDEGUIDE ADJUCT RACK	2	84	202718-3	SENSOR, PROXIMITY INDUCTIVE	1
537	545662-01	GEAR, SIDEGUIDE ADJUCT RACK	2	92	202718-3	SENSOR, PROXIMITY INDUCTIVE	1
296	547191-01	GLIDE, CONTROL ARM	1	333	208504-1	ASSY, FILTER/FINGER GUARD	2
248	191029-3	GLIDE, SUSPA	1	919	500330-4	HUB, ROLLER	2
267	191029-3	GLIDE, SUSPA	1	434	500330-9	HUB, ROLLER	2
275	191029-3	GLIDE, SUSPA	1	656	508049-9	BAR, UPPER STATIC SUPPORT	4
950	200513-5	GROMMET, RUBBER .75IDX1.375ODX.56TH	1	696	510611-1	ROLLER, IDLER	1
608	543401-03	GUARD, BEAM SWITCH	1	709	510611-1	ROLLER, IDLER	1
493	543401-04	GUARD, BEAM SWITCH	1	695	510611-1A	ASSY-ROLLER	1
334	208505	GUARD, FINGER	1	708	510611-1A	ASSY-ROLLER	1
175	547238-01	GUIDE, AIR HOSE	1	634	510611A	ASSY-ROLLER	1
452	545650-01	GUIDE, FRONT SIDE	9	336	530441-06	BOX, ELECTRICAL INLET 30A	1
536	545650-02	GUIDE, FRONT SIDE	10	796	530510-03	BAR, MOTOR MOUNT PIVOT	2
564	545672-01	GUIDE, INFEED DIVERT	1	797	530511-01	SPACER, 3/4OD X 2L	2
33	545799-01	GUIDE, PRODUCT TRANSFER	1	795	530654-03	ASSY, MOTOR MTG BAR	1
34	545799-02	GUIDE, PRODUCT TRANSFER	1	807	532129-01	BLOCK, LOCK DOWN	1
35	545799-03	GUIDE, PRODUCT TRANSFER	1	562	532226-02	ARM, REJECT CYLINDER	1
792	543995-01	GUIDE, UPPER BELT ADJUSTMENT	1	969	533006-01	HANDWHEEL	1
760	545717-01	GUIDE, UPPER SIDE	1	553	534814-07	ASSY, VALVE CYLINDER PLATE	1
771	545717-02	GUIDE, UPPER SIDE	1	250	537371-01	BRACKET, SPRING RETURN MOUNT	1
765	545717-05	GUIDE, UPPER SIDE	1	269	537371-01	BRACKET, SPRING RETURN MOUNT	1
776	545717-06	GUIDE, UPPER SIDE	1	277	537371-01	BRACKET, SPRING RETURN MOUNT	1
778	545717-08	GUIDE, UPPER SIDE	1	271	537596-03	BLOCK, HYDRAULIC LIFT LH	2
766	545717-09	GUIDE, UPPER SIDE	1	279	537596-04	BLOCK, HYDRAULIC LIFT LH	2
838	190967	HAND PLUNGER, 3/8-16X1.13	1	272	537597-03	BRACKET, HYDRAULIC LIFT SPRING	1
853	190967	HAND PLUNGER, 3/8-16X1.13	1	280	537597-04	BRACKET, HYDRAULIC LIFT SPRING	1
865	190967	HAND PLUNGER, 3/8-16X1.13	1	793	538022-06	ASSY, MOTOR MOUNT	1
308	190955	HANDLE	2	236	538024-01	ASSY, 1 IN. LEVELING LEG	4
645	190955	HANDLE	1	200	538024-02	ASSY, 1 IN. LEVELING LEG 8.00 LNG	4
844	190955	HANDLE	1	247	539425-03	ASSY, HYDRALIFT LEG	1
858	190955	HANDLE	1	196	539527-06	CHANNEL, PUMP MOUNT	1
870	190955	HANDLE	1	274	541179-02	ASSY, RH HYDRALIFT LEG 1000LB	2
873	190955	HANDLE	2	266	541180-02	ASSY, LH HYDRALIFT LEG	2
940	190955	HANDLE	2	561	541779-02	ARM, REJECT CYLINDER	1

315	102134-1	HANDLE - RELEASE	1	608	543401-03	GUARD, BEAM SWITCH	1
946	545788-01	HANDLE, COVER MOUNT	2	493	543401-04	GUARD, BEAM SWITCH	1
581	547539-01	HANDLE, INFEED ROLLER RELEASE	1	37	543896-01	ASSY, TURN TABLE	1
529	102140	HANDLE, RELEASE 1/4-20 X 1.0	1	39	543897-01	PLATE, RH TURN TABLE	1
781	102140	HANDLE, RELEASE 1/4-20 X 1.0	1	40	543897-02	PLATE, RH TURN TABLE	1
967	102140	HANDLE, RELEASE 1/4-20 X 1.0	2	41	543898-01	TRACK, V ROLLER GUIDE	4
76	102149	HANDLE, RELEASE 5/16-18 X 1.26	1	2	543899-01	ASSY, TURN TABLE AND MOUNT	1
969	533006-01	HANDWHEEL	1	4	543900-01	PLATE, TURN TABLE MOUNT	1
258	102108-4	HANDWHEEL, CLUTCH BEARING	1	5	543900-02	PLATE, TURN TABLE MOUNT	1
286	107325	HEX HEAD BOLT 1/4-20 X 1.50"	4	11	543901-01	ASSY, GUIDE WHEEL ECCENTRIC	1
339	191223	HINGE, CONCEALED REMOVABLE	2	6	543902-01	ASSY, GUIDE WHEEL CONCENTRIC	2
343	191223	HINGE, CONCEALED REMOVABLE	2	120	543902-01	ASSY, GUIDE WHEEL CONCENTRIC	2
340	547203-01	HOLDER, MANUAL	1	73	543907-01	BLOCK, SIDE GUIDE ADJUST CLAMP	1
290	547459-01	HOLDER, TABLE LIFT WING	1	72	543910-01	ASSY, SIDE GUIDE	2
899	191350	HOSE, 1/4 ID 13"LNG	2	77	543911-01	PLATE, PRODUCT GUIDE	1
919	500330-4	HUB, ROLLER	2	74	543912-01	BLOCK, PRODUCT GUIDE MOUNT	1
434	500330-9	HUB, ROLLER	2	79	543915-01	ASSY, RETRACTABLE PRODUCT GUIDE	1
784	545730-01	HUB, SIDEGUIDE CLAMP	1	88	543915-02	ASSY, RETRACTABLE PRODUCT GUIDE	1
488	545740-01	INDICATOR, SIDEGUIDE	1	81	543916-01	BLOCK, AIR CYLINDER MOUNT	1
789	545745-01	INDICATOR, SIDEGUIDE	1	90	543916-01	BLOCK, AIR CYLINDER MOUNT	1
265	547537-01	KIT, 950 1000LB HYDRALIFT	1	83	543917-01	PLATE, AIR CYLINDER CLAMP	1
654	547533-01	KIT, STATIC BAR	1	91	543917-01	PLATE, AIR CYLINDER CLAMP	1
472	102112	KNOB	1	45	543918-01	RING, HTD BELT GUIDE	4
530	102112	KNOB	1	44	543918-02	RING, HTD BELT GUIDE	2
595	102112	KNOB	1	17	543919-02	ASSY, SERVO MOTOR	1
718	102112	KNOB	1	18	543920-01	PLATE, STEPPER MOTOR MOUNT	1
812	102112	KNOB	1	21	543921-01	PULLEY, 26-8M-20 HTD 16mm BORE	1
610	102119	KNOB	4	23	543922-01	ROLLER, HTD DIVERT BELT	1
948	102119	KNOB	2	114	543922-01	ROLLER, HTD DIVERT BELT	1
240	191361	KNOB, 375-16 QUICK ADJUST	2	22	543923-01	ASSY, DIVERT ROLLER	2
310	209016	KNOB, POT	2	113	543923-02	ASSY, DIVERT ROLLER	4
354	190795	LABEL, 220 VOLTS	1	25	543924-01	STUD, BELT DIVERT IDLER	1
606	190782	LABEL, LOOSE CLOTHES	1	116	543924-02	STUD, BELT DIVERT IDLER	1
905	190782	LABEL, LOOSE CLOTHES	2	47	543925-01	PULLEY, 26-8M-20 HTD TAKE UP	1
605	190785	LABEL, ROLLER VERT WARNING	1	54	543925-01	PULLEY, 26-8M-20 HTD TAKE UP	1
903	190785	LABEL, ROLLER VERT WARNING	4	46	543926-01	ASSY, HTD BELT TAKE UP	1
904	190784	LABEL, STAMPING WARNING	2	53	543926-02	ASSY, HTD BELT TAKE UP	1
264	190780	LABEL, TIMING BELT WARNING	3	55	543927-01	SHAFT, HTD TAKE UP ADJUST	1
355	190788	LABEL, VOLTAGE WARNING LARGE	2	57	543928-01	PLATE, HTD TAKE UP MOUNT	1
237	191010	LEVELING BOLT, CABINET	1	48	543928-02	PLATE, HTD TAKE UP MOUNT	1
201	191010-3	LEVELING BOLT, CABINET	1	49	543929-01	PLATE, HTD BELT CLAMP	1
901	202284-8	LIGHT, THREE BULB	1	60	543929-01	PLATE, HTD BELT CLAMP	1
109	102912	LINEAR BUSHING, THOMSON	2	29	543930-01	SPACER, MOTOR MOUNT	4
556	508055	LINK, GATE	1	30	543931-01	BRACKET, PROX MOUNT	1
888	547184-01	LOGO, KR950	1	63	543932-01	BRACKET, PROX SCREW	4
841	190769	MAGNET, BUNTING	1	97	543933-01	ASSY, PUSHER	1
845	190769	MAGNET, BUNTING	2	99	543934-01	PLATE, AIR CYLINDER MNT	2

856	190769	MAGNET, BUNTING	1	100	543935-01	BLOCK, PUSHER AIR CYLINDER MNT	1
859	190769	MAGNET, BUNTING	2	101	543936-01	RACK, PUSHER DRIVE	1
868	190769	MAGNET, BUNTING	1	136	543936-02	RACK, PUSHER DRIVE	1
871	190769	MAGNET, BUNTING	2	102	543938-01	GEAR, 1624 PINION	1
875	190769	MAGNET, BUNTING	2	103	543939-01	SHAFT, PINION	1
925	200169-3	MOTOR, BODINE 4179	1	105	543940-01	PULLEY, 40-8M-20 HTD	1
799	200151-2	MOTOR, LEESON DC 1 HP	1	106	543941-01	PLATE, PUSHER MOUNT	1
20	200615	MOTOR, SERVO	1	107	543942-01	SHAFT, RACK GEAR SLIDE	1
604	190758	MOUNTING BLOCK	4	108	543943-01	BLOCK, BUSHING MOUNT	2
331	191393	MUFFLER, 1/4 NPT	1	110	543944-01	POST, RACK SHAFT MOUNT	1
173	191340	MUFFLER, 1/8 NPT AIR	6	111	543945-01	PLATE, BEARING MOUNT	1
418	191340	MUFFLER, 1/8 NPT AIR	2	112	543946-01	SPACER, BEARING PLATE	4
329	109544	NIPPLE, 1/4 NPT AIR GUN	1	148	543947-01	TABLETOP, PRODUCT LIFT	1
203	191011	NUT, CABINET LEVELING	1	118	543948-01	ASSY, PUSHER BAR	1
239	191011	NUT, CABINET LEVELING	1	119	543949-01	PLATE, PUSHER BAR SLIDE	1
503	106736	NUT, HEX #10-32	2	125	543950-01	BAR, PUSHER	1
545	106711	NUT, HEX #6-32	6	132	543951-01	PLATE, PUSHER TRACK MOUNT	1
507	106720	NUT, HEX 1/4-20	1	133	543952-01	PLATE, VERTICAL PUSHER MOUNT	2
633	106720	NUT, HEX 1/4-20	1	146	543953-01	ASSY, PRODUCT LIFT	1
731	106720	NUT, HEX 1/4-20	2	149	543954-01	BLOCK, LIFT CYLINDER MOUNT	1
816	106720	NUT, HEX 1/4-20	2	150	543955-01	BAR, LIFT MOUNT SPACER	2
879	106720	NUT, HEX 1/4-20	6	154	543956-01	BLOCK, LIFT TABLE MOUNT	1
158	HMSN14	NUT, HEX 3/8-16	2	151	543956-02	BLOCK, LIFT TABLE MOUNT	1
589	HMSN14	NUT, HEX 3/8-16	1	152	543957-01	BAR, LIFT SHAFT MOUNT	1
688	HMSN14	NUT, HEX 3/8-16	1	153	543958-01	SHAFT, PRODUCT LIFT SUPPORT	1
839	HMSN14	NUT, HEX 3/8-16	1	156	543959-01	BLOCK, LIFT SHAFT BUSHING	2
854	HMSN14	NUT, HEX 3/8-16	1	159	543960-01	BLOCK, LIFT CYLINDER MOUNT	1
866	HMSN14	NUT, HEX 3/8-16	1	160	543961-01	BLOCK, LIFT CYLINDER MOUNT	1
254	106712	NUT, HEX 5/16-18	1	64	543962-01	ASSY, TABLE ROLLER	2
193	HJN019	NUT, JAM 1-8	4	65	543963-01	BRACKET, PULLEY ROLLER	1
224	HJN019	NUT, JAM 1-8	2	134	543964-02	TRACK, PUSHER ROLLER	2
263	HJN019	NUT, JAM 1-8	1	126	543965-02	BRACKET, PUSHER BELT MNT	1
244	HJN012	NUT, JAM 3/8-16	12	135	543966-02	PLATE, TRACK SUPPORT	1
28	HJN016	NUT, JAM 5/8-12	2	164	543967-01	PLATE, PNEUMATIC HARNESS	1
162	HJN013	NUT, JAM 7/16-14	2	71	543969-01	RULE, FLAT SIDEGUIDE PLACEMENT	2
746	545709-01	PALTE, LH SIDE GUIDE MOUNT	2	177	543969-01	RULE, FLAT SIDEGUIDE PLACEMENT	2
194	545609-01	PANEL, BASE END	1	527	543969-01	RULE, FLAT SIDEGUIDE PLACEMENT	1
195	545609-02	PANEL, BASE END	1	166	543970-01	BLOCK, AIR MANIFOLD	1
285	545616-01	PANEL, CONTROL BOX BOTTOM	1	346	543970-02	BLOCK, AIR MANIFOLD	1
287	545618-01	PANEL, CONTROL BOX TOP	1	896	543970-03	BLOCK, AIR MANIFOLD	1
322	547200-01	PANEL, ELECTRICAL	1	38	543972-01	ASSY, TURN TABLE	1
189	545605-01	PANEL, INFEED END	1	179	543973-01	TABLETOP, PRODUCT LIFT SUPPORT	2
190	545606-01	PANEL, OUTFEED END SPEC.	1	180	543973-02	TABLETOP, PRODUCT LIFT SUPPORT	2
284	545620-01	PANEL, REAR ELECTRICAL	1	78	543974-01	PLATE, SIDEGUIDE SUPPORT	1
301	547189-01	PANEL, STACKER CONTROL	1	359	543980-01	ASSY, PRODUCT CATCH FINGER	1
191	545607-01	PANEL, TOP	1	360	543981-01	PLATE, FINGER MOUNT	2
371	105221	PIN, ROLL .094X.500	2	361	543982-01	PLATE, FINGER MOUNT END	1

390	105221	PIN, ROLL .094X.500	2	362	543983-01	PLATE, FINGER SHAFT MOUNT	1
225	547468-01	PLATE, ADJUSTMENT MOUNT	2	363	543984-01	SHAFT, FINGER SLIDE	2
83	543917-01	PLATE, AIR CYLINDER CLAMP	1	364	543985-01	ASSY, INFEED FINGER	1
91	543917-01	PLATE, AIR CYLINDER CLAMP	1	383	543986-01	ASSY, OUTFEED FINGER	1
99	543934-01	PLATE, AIR CYLINDER MNT	2	365	543987-01	BLOCK, FINGER SLIDE	4
404	545628-01	PLATE, AIR CYLINDER MOUNT	2	384	543987-01	BLOCK, FINGER SLIDE	4
532	545658-01	PLATE, BACK SIDE GUIDE	1	442	543987-01	BLOCK, FINGER SLIDE	3
517	545654-01	PLATE, BACK SIDE GUIDE SIDE	1	534	543987-01	BLOCK, FINGER SLIDE	4
518	545654-02	PLATE, BACK SIDE GUIDE SIDE	1	756	543987-01	BLOCK, FINGER SLIDE	4
492	545201-02	PLATE, BEAM SWITCH MOUNT	1	768	543987-01	BLOCK, FINGER SLIDE	4
719	545724-01	PLATE, BEARING	1	441	543987-02	BLOCK, FINGER SLIDE	1
671	547762-01	PLATE, BEARING MNT	2	444	543987-03	BLOCK, FINGER SLIDE	1
574	547762-02	PLATE, BEARING MNT	1	445	543987-04	BLOCK, FINGER SLIDE	1
570	547762-03	PLATE, BEARING MNT	1	367	543988-01	PLATE, INFEED FINGER MOUNT	1
111	543945-01	PLATE, BEARING MOUNT	1	386	543988-02	PLATE, INFEED FINGER MOUNT	1
436	545638-01	PLATE, BELT ADJUST	2	368	543989-01	ASSY, PRODUCT CATCH FINGER	10
508	545640-02	PLATE, BELT ADJUST SHAFT MOUNT	4	387	543989-01	ASSY, PRODUCT CATCH FINGER	11
519	545640-02	PLATE, BELT ADJUST SHAFT MOUNT	2	369	543990-01	FINGER, PRODUCT CATCH	1
513	545640-03	PLATE, BELT ADJUST SHAFT MOUNT	4	388	543990-01	FINGER, PRODUCT CATCH	1
525	545640-03	PLATE, BELT ADJUST SHAFT MOUNT	2	370	543991-01	STUD, FINGER MOUNT	1
978	547528-01	PLATE, BELT ADJUST SPLICE	2	389	543991-01	STUD, FINGER MOUNT	1
410	545626-01	PLATE, BELT IDLER MOUNT	1	3	543994-01	ASSY, TURN TABLE DRIVE	1
292	547195-01	PLATE, BOTTOM PIVOT CLAMP	1	792	543995-01	GUIDE, UPPER BELT ADJUSTMENT	1
198	545612-01	PLATE, CABINET WEIGHT	10	372	543998-01	STUD, FORK END	1
303	201169	PLATE, CUSTOM LABEL	6	391	543998-01	STUD, FORK END	1
885	201169	PLATE, CUSTOM LABEL	4	492	545201-02	PLATE, BEAM SWITCH MOUNT	1
465	545728-01	PLATE, DISHING MOUNT	2	186	545602-01	ASSY, STACKER CABINET	1
843	545783-01	PLATE, DOOR HANDLE MOUNT	1	187	545603-01	WLDMNT, STACKER CABINET	1
857	545783-01	PLATE, DOOR HANDLE MOUNT	1	188	545604-01	BASE, CABINET	1
869	545783-01	PLATE, DOOR HANDLE MOUNT	1	189	545605-01	PANEL, INFEED END	1
374	545630-01	PLATE, FINGER BELT CLAMP	2	190	545606-01	PANEL, OUTFEED END SPEC.	1
394	545630-01	PLATE, FINGER BELT CLAMP	3	191	545607-01	PANEL, TOP	1
375	545631-01	PLATE, FINGER BELT CLAMP	2	199	545608-01	DOOR, DROPOUT CABINET	3
395	545631-01	PLATE, FINGER BELT CLAMP	3	194	545609-01	PANEL, BASE END	1
759	545631-01	PLATE, FINGER BELT CLAMP	1	195	545609-02	PANEL, BASE END	1
770	545631-01	PLATE, FINGER BELT CLAMP	1	205	545610-01	CHANNEL, REMOVABLE END	1
360	543981-01	PLATE, FINGER MOUNT	2	207	545611-01	BRACKET, END CHANNEL MOUNT	1
361	543982-01	PLATE, FINGER MOUNT END	1	198	545612-01	PLATE, CABINET WEIGHT	10
362	543983-01	PLATE, FINGER SHAFT MOUNT	1	181	545613-01	PLATE, PRODUCT LIFT SCAB	2
49	543929-01	PLATE, HTD BELT CLAMP	1	283	545614-01	WLDMNT, CONTROL BOX	1
60	543929-01	PLATE, HTD BELT CLAMP	1	285	545616-01	PANEL, CONTROL BOX BOTTOM	1
57	543928-01	PLATE, HTD TAKE UP MOUNT	1	338	545617-01	DOOR, CONTROL BOX	1
48	543928-02	PLATE, HTD TAKE UP MOUNT	1	287	545618-01	PANEL, CONTROL BOX TOP	1
550	545670-01	PLATE, HUB BEARING	2	342	545619-01	DOOR, CONTROL BOX	1
246	547514-01	PLATE, HYDRALIFT LEG MOUNT	1	284	545620-01	PANEL, REAR ELECTRICAL	1
367	543988-01	PLATE, INFEED FINGER MOUNT	1	282	545621-01	ASSY, ELECTRICAL BOX	1
386	543988-02	PLATE, INFEED FINGER MOUNT	1	165	545622-01	BRACKET, TERMINAL MOUNT	1

548	545668-01	PLATE, INFEED RAMP BEARING	2	373	545623-01	BAR, FINGER SLIDE MOUNT	2
889	547185-01	PLATE, KR950 LOGO BACKING	1	392	545623-01	BAR, FINGER SLIDE MOUNT	2
907	190619-1	PLATE, NAME	1	407	545624-01	SHAFT, FINGER DRIVE	1
955	547520-01	PLATE, OUTFEED ADJUST MOUNT	2	409	545625-01	ASSY, BELT TAKEUP	2
911	545756-01	PLATE, OUTFEED CONVEYOR	1	410	545626-01	PLATE, BELT IDLER MOUNT	1
912	545756-02	PLATE, OUTFEED CONVEYOR	1	411	545627-01	SHAFT, PULLEY IDLER	1
951	547457-01	PLATE, OUTFEED ROLLER TAKEUP	2	404	545628-01	PLATE, AIR CYLINDER MOUNT	2
957	547457-01	PLATE, OUTFEED ROLLER TAKEUP	2	393	545629-01	BLOCK, AIR CYLINDER FINGER	1
164	543967-01	PLATE, PNEUMATIC HARNESS	1	374	545630-01	PLATE, FINGER BELT CLAMP	2
77	543911-01	PLATE, PRODUCT GUIDE	1	394	545630-01	PLATE, FINGER BELT CLAMP	3
181	545613-01	PLATE, PRODUCT LIFT SCAB	2	375	545631-01	PLATE, FINGER BELT CLAMP	2
119	543949-01	PLATE, PUSHER BAR SLIDE	1	395	545631-01	PLATE, FINGER BELT CLAMP	3
106	543941-01	PLATE, PUSHER MOUNT	1	759	545631-01	PLATE, FINGER BELT CLAMP	1
132	543951-01	PLATE, PUSHER TRACK MOUNT	1	770	545631-01	PLATE, FINGER BELT CLAMP	1
457	545656-01	PLATE, RACK GEAR MOUNT	2	422	545632-01	ASSY, STACKER FLAT BELT	1
39	543897-01	PLATE, RH TURN TABLE	1	424	545633-01	PLATE, STACKER BELT SIDE	1
40	543897-02	PLATE, RH TURN TABLE	1	425	545633-02	PLATE, STACKER BELT SIDE	1
956	547521-01	PLATE, ROLLER MOUNT	2	427	545634-01	SHAFT, FLAT BELT DRIVE	1
450	545644-01	PLATE, SIDE GUIDE MOUNT	2	426	545634-02	SHAFT, FLAT BELT DRIVE	1
528	545742-01	PLATE, SIDEGUIDE ADJUST CLAMP	1	514	545634-03	SHAFT, FLAT BELT DRIVE	1
747	545710-01	PLATE, SIDEGUIDE BEARING	4	433	545635-01	ROLLER,BELT IDLER	1
780	545723-01	PLATE, SIDEGUIDE CLAMP	1	918	545635-02	ROLLER,BELT IDLER	1
449	545643-01	PLATE, SIDEGUIDE JOGGER	1	430	545635-03	ROLLER,BELT IDLER	1
451	545645-01	PLATE, SIDEGUIDE MOUNT	1	432	545636-01	ASSY, CONVEYOR DRIVE ROLLER	1
757	545716-01	PLATE, SIDEGUIDE MOUNT	1	917	545636-02	ASSY, CONVEYOR DRIVE ROLLER	1
769	545716-01	PLATE, SIDEGUIDE MOUNT	1	429	545636-03	ASSY, CONVEYOR IDLER ROLLER	2
758	547240-01	PLATE, SIDEGUIDE MOUNT	1	435	545637-01	ASSY, BELT ADJUST	1
777	547240-01	PLATE, SIDEGUIDE MOUNT	1	436	545638-01	PLATE, BELT ADJUST	2
748	545711-01	PLATE, SIDEGUIDE SHAFT MOUNT	2	438	545639-01	ROLLER, BELT ADJUST	1
78	543974-01	PLATE, SIDEGUIDE SUPPORT	1	439	545639-02	ROLLER, BELT ADJUST	1
424	545633-01	PLATE, STACKER BELT SIDE	1	508	545640-02	PLATE, BELT ADJUST SHAFT MOUNT	4
425	545633-02	PLATE, STACKER BELT SIDE	1	519	545640-02	PLATE, BELT ADJUST SHAFT MOUNT	2
18	543920-01	PLATE, STEPPER MOTOR MOUNT	1	513	545640-03	PLATE, BELT ADJUST SHAFT MOUNT	4
311	547196-01	PLATE, TOP PIVOT	1	525	545640-03	PLATE, BELT ADJUST SHAFT MOUNT	2
312	547197-01	PLATE, TOP PIVOT MOUNT	1	509	545641-01	SHAFT, BELT ADJUST MOUNT	2
135	543966-02	PLATE, TRACK SUPPORT	1	449	545643-01	PLATE, SIDEGUIDE JOGGER	1
4	543900-01	PLATE, TURN TABLE MOUNT	1	450	545644-01	PLATE, SIDE GUIDE MOUNT	2
5	543900-02	PLATE, TURN TABLE MOUNT	1	451	545645-01	PLATE, SIDEGUIDE MOUNT	1
665	545685-01	PLATE, UPPER BELT SUPPORT	1	452	545650-01	GUIDE, FRONT SIDE	9
566	545685-02	PLATE, UPPER BELT SUPPORT	2	536	545650-02	GUIDE, FRONT SIDE	10
664	545685-03	PLATE, UPPER BELT SUPPORT	1	453	545651-01	BAR, UPPER BELT ADJUST SPACER	2
133	543952-01	PLATE, VERTICAL PUSHER MOUNT	2	437	545652-01	BLOCK, BEARING	2
533	545659-01	PLATE, VERTICAL SIDE GUIDE	2	516	545653-01	ASSY, BACK SIDE GUIDE	1
884	201164	PLATE, YELLOW POWER OFF LABEL	1	517	545654-01	PLATE, BACK SIDE GUIDE SIDE	1
490	547209-01	POST, BEAM SWITCH MOUNT	1	518	545654-02	PLATE, BACK SIDE GUIDE SIDE	1
110	543944-01	POST, RACK SHAFT MOUNT	1	457	545656-01	PLATE, RACK GEAR MOUNT	2
31	201055-1	PROXIMITY	2	531	545657-01	ASSY, BACK SIDE GUIDE SLIDE	1

486	201055-1	PROXIMITY	1	532	545658-01	PLATE, BACK SIDE GUIDE	1
21	543921-01	PULLEY, 26-8M-20 HTD 16mm BORE	1	533	545659-01	PLATE, VERTICAL SIDE GUIDE	2
47	543925-01	PULLEY, 26-8M-20 HTD TAKE UP	1	521	545661-01	SHAFT, SIDE GUIDE ADJUST	1
54	543925-01	PULLEY, 26-8M-20 HTD TAKE UP	1	458	545662-01	GEAR, SIDEGUIDE ADJUCT RACK	2
105	543940-01	PULLEY, 40-8M-20 HTD	1	537	545662-01	GEAR, SIDEGUIDE ADJUCT RACK	2
800	108809	PULLEY, TIMING 12L075 .625B .188K	1	538	545663-01	BLOCK, RACK MOUNT	2
927	109968	PULLEY, TIMING 14L075 .625B .188K	1	539	545664-01	BRACKET, RACK MOUNT	2
926	108871	PULLEY, TIMING 14L075 .750B .188K	1	460	545665-01	TOP, HORZ. TABLETOP	1
510	109330	PULLEY, TIMING 15L05 .750B .188K	1	547	545666-01	ASSY, INFEED BELT RAMP	1
668	109330	PULLEY, TIMING 15L05 .750B .188K	1	543	545667-01	SHAFT, RACK GEAR SPACER	1
511	108820	PULLEY, TIMING 16L075 .750B .188K	1	548	545668-01	PLATE, INFEED RAMP BEARING	2
408	109732	PULLEY, TIMING 228M20 .625B .188KEY	2	549	545669-02	TABLETOP, INFEED RAMP	1
412	109733	PULLEY, TIMING 228M20 1.5738 BORE	1	550	545670-01	PLATE, HUB BEARING	2
752	545715-01	PULLEY, TIMING 288M20 .625B .188KEY	2	551	545671-01	SHAFT, INFEED ROLLER	1
281	191032-01	PUMP, MOVOTEC PB4615FC	1	564	545672-01	GUIDE, INFEED DIVERT	1
101	543936-01	RACK, PUSHER DRIVE	1	618	545673-01	ASSY, BELT TAKE UP	1
136	543936-02	RACK, PUSHER DRIVE	1	619	545674-02	ASSY, ROLLER	4
963	547522-01	RACK, ROLLER ADJUST	2	575	545675-01	ROLLER, DIVERT	2
19	191237	REDUCER, SERVO MOTOR	1	675	545675-01	ROLLER, DIVERT	2
324	191300-1	REGULATOR, AIR	1	620	545675-02	ROLLER, DIVERT	1
45	543918-01	RING, HTD BELT GUIDE	4	591	545675-03	ROLLER, DIVERT	2
44	543918-02	RING, HTD BELT GUIDE	2	624	545677-01	ARM, SPRING MOUNT	2
724	545726-01	ROD, THREADED CRANK	1	625	545678-01	ASSY, TAKEUP 1 IN BELT	4
228	547509-01	ROLLER, ADJUST	1	626	545679-01	ARM, BELT TIGHTENER	1
233	547509-02	ROLLER, ADJUST GUIDE	1	627	545680-01	SHAFT, BELT TIGHTENER	1
438	545639-01	ROLLER, BELT ADJUST	1	693	545680-01	SHAFT, BELT TIGHTENER	1
439	545639-02	ROLLER, BELT ADJUST	1	706	545680-01	SHAFT, BELT TIGHTENER	1
575	545675-01	ROLLER, DIVERT	2	637	545681-01	SHAFT, SPRING MOUNT	1
675	545675-01	ROLLER, DIVERT	2	639	545682-01	BRACKET, SPRING ANCHOR	4
620	545675-02	ROLLER, DIVERT	1	463	545683-01	SPACER, TABLETOP	3
591	545675-03	ROLLER, DIVERT	2	506	545683-02	SPACER, TABLETOP	1
741	545701-01	ROLLER, DIVERT IDLER	1	663	545684-01	ASSY, UPPER BELT	1
914	545757-01	ROLLER, FLAT BELT	1	665	545685-01	PLATE, UPPER BELT SUPPORT	1
916	545757-02	ROLLER, FLAT BELT	1	566	545685-02	PLATE, UPPER BELT SUPPORT	2
962	545757-02	ROLLER, FLAT BELT	1	664	545685-03	PLATE, UPPER BELT SUPPORT	1
958	545757-03	ROLLER, FLAT BELT	1	667	545686-01	SHAFT, UPPER BELT DRIVE	1
921	545759-01	ROLLER, FLAT BELT	2	669	545689-01	SHAFT, UPPER ARM ADJUST	1
961	545759-01	ROLLER, FLAT BELT	2	568	545689-02	SHAFT, UPPER ARM ADJUST	1
23	543922-01	ROLLER, HTD DIVERT BELT	1	583	545690-01	ARM, UPPER BELT AJUST	1
114	543922-01	ROLLER, HTD DIVERT BELT	1	682	545690-01	ARM, UPPER BELT AJUST	1
635	510611	ROLLER, IDLER	1	585	545691-01	SHAFT, ARM PIVOT	1
696	510611-1	ROLLER, IDLER	1	684	545691-01	SHAFT, ARM PIVOT	1
709	510611-1	ROLLER, IDLER	1	686	545692-01	SHAFT, VERTICAL ARM	1
690	545695-01	ROLLER, UPPER BELT DRIVE	2	587	545692-02	SHAFT, VERTICAL ARM	1
433	545635-01	ROLLER,BELT IDLER	1	689	545693-01	ARM, UPPER BELT AJUST	1
918	545635-02	ROLLER,BELT IDLER	1	590	545693-02	ARM, UPPER BELT AJUST	1
430	545635-03	ROLLER,BELT IDLER	1	729	545693-03	ARM, UPPER BELT AJUST	1

71	543969-01	RULE, FLAT SIDEGUIDE PLACEMENT	2	573	545694-01	SHAFT, UPPER ROLLER IDLER	1
177	543969-01	RULE, FLAT SIDEGUIDE PLACEMENT	2	674	545694-01	SHAFT, UPPER ROLLER IDLER	1
527	543969-01	RULE, FLAT SIDEGUIDE PLACEMENT	1	690	545695-01	ROLLER, UPPER BELT DRIVE	2
788	545744-01	RULE, FLAT SIDEGUIDE PLACEMENT	1	691	545696-01	ASSY, TAKEUP 1 IN BELT	1
87	106811	SCREW, BUTTON HEAD #10-32X.250	2	704	545696-02	ASSY, TAKEUP 1 IN BELT	1
96	106811	SCREW, BUTTON HEAD #10-32X.250	2	692	545697-01	ARM, BELT TIGHTENER	1
139	106811	SCREW, BUTTON HEAD #10-32X.250	4	705	545697-01	ARM, BELT TIGHTENER	1
161	106811	SCREW, BUTTON HEAD #10-32X.250	2	594	545698-01	SHAFT, ARM LOCK	1
317	106811	SCREW, BUTTON HEAD #10-32X.250	4	717	545698-01	SHAFT, ARM LOCK	1
353	106811	SCREW, BUTTON HEAD #10-32X.250	4	522	545698-02	SHAFT, ARM LOCK	1
403	106811	SCREW, BUTTON HEAD #10-32X.250	6	739	545699-01	ASSY, BELT DIVERT ROLLER	1
462	106811	SCREW, BUTTON HEAD #10-32X.250	6	740	545700-01	BLOCK, IDLER ROLLER BEARING	2
541	106811	SCREW, BUTTON HEAD #10-32X.250	4	741	545701-01	ROLLER, DIVERT IDLER	1
762	106811	SCREW, BUTTON HEAD #10-32X.250	4	565	545704-01	ASSY, UPPER BELT	1
773	106811	SCREW, BUTTON HEAD #10-32X.250	4	567	545705-01	SHAFT, UPPER BELT DRIVE	1
790	106811	SCREW, BUTTON HEAD #10-32X.250	2	745	545707-01	ASSY, UPPER SIDEGUIDE	1
932	106811	SCREW, BUTTON HEAD #10-32X.250	8	746	545709-01	PALTE, LH SIDE GUIDE MOUNT	2
979	106811	SCREW, BUTTON HEAD #10-32X.250	4	747	545710-01	PLATE, SIDEGUIDE BEARING	4
846	106810	SCREW, BUTTON HEAD #10-32X.500	6	748	545711-01	PLATE, SIDEGUIDE SHAFT MOUNT	2
847	CSFF54	SCREW, BUTTON HEAD #8-32X.625	2	749	545712-01	SHAFT, SIDEGUIDE MOUNT	2
906	CSFF55	SCREW, BUTTON HEAD #8-32X.750	2	750	545713-01	SHAFT, PULLEY IDLER	1
487	CSFF63	SCREW, BUTTON HEAD 1/4X.250	4	751	545714-01	SHAFT, SIDEGUIDE JOGGER	1
661	CSFF63	SCREW, BUTTON HEAD 1/4X.250	2	752	545715-01	PULLEY, TIMING 288M20 .625B .188KEY	2
67	106816	SCREW, BUTTON HEAD 1/4X.375	11	757	545716-01	PLATE, SIDEGUIDE MOUNT	1
131	106818	SCREW, BUTTON HEAD 1/4X.500	2	769	545716-01	PLATE, SIDEGUIDE MOUNT	1
448	106818	SCREW, BUTTON HEAD 1/4X.500	2	760	545717-01	GUIDE, UPPER SIDE	1
582	106818	SCREW, BUTTON HEAD 1/4X.500	2	771	545717-02	GUIDE, UPPER SIDE	1
660	106818	SCREW, BUTTON HEAD 1/4X.500	8	765	545717-05	GUIDE, UPPER SIDE	1
943	106818	SCREW, BUTTON HEAD 1/4X.500	24	776	545717-06	GUIDE, UPPER SIDE	1
318	106815	SCREW, BUTTON HEAD 1/4X.625	4	778	545717-08	GUIDE, UPPER SIDE	1
947	106815	SCREW, BUTTON HEAD 1/4X.625	4	766	545717-09	GUIDE, UPPER SIDE	1
474	106800	SCREW, BUTTON HEAD 1/4X.750	6	755	545718-01	ASSY, RH SIDEGUIDE	1
787	106800	SCREW, BUTTON HEAD 1/4X.750	4	767	545719-01	ASSY, RH SIDEGUIDE	1
482	106801	SCREW, BUTTON HEAD 1/4X.875	1	779	545722-01	WHEEL, SIDEGUIDE ADJUST	1
52	107506	SCREW, FLATHEAD 1/4-20X.750	2	780	545723-01	PLATE, SIDEGUIDE CLAMP	1
178	107537	SCREW, FLATHEAD 1/4-20X.875	4	719	545724-01	PLATE, BEARING	1
483	107521	SCREW, FLATHEAD 10-32X.250	6	720	545725-01	SPACER, BEARING PLATE	4
980	107521	SCREW, FLATHEAD 10-32X.250	6	724	545726-01	ROD, THREADED CRANK	1
255	107502	SCREW, FLATHEAD 10-32X.375	4	464	545727-01	ASSY, PRODUCT DISHING	1
376	107500	SCREW, FLATHEAD 10-32X.500	8	465	545728-01	PLATE, DISHING MOUNT	2
398	107500	SCREW, FLATHEAD 10-32X.500	12	466	545729-01	SHAFT, DISHING MOUNT	1
764	107526	SCREW, FLATHEAD 10-32X.625	4	784	545730-01	HUB, SIDEGUIDE CLAMP	1
775	107526	SCREW, FLATHEAD 10-32X.625	4	467	545731-01	ARM, DISHING ADJUSTMENT	1
130	107541	SCREW, FLATHEAD 5/16-18X.750	2	468	545732-01	SHAFT, ARM PIVOT	1
183	107546	SCREW, FLHD UNDERCUT 10-32X.250	12	469	545733-01	ARM, BEARING MOUNT SKID	2
484	107546	SCREW, FLHD UNDERCUT 10-32X.250	18	471	545734-01	SHAFT, DISHING ADJUST	1
546	107546	SCREW, FLHD UNDERCUT 10-32X.250	20	379	545735-01	BRACKET, FINGER MOUNT BAR	2

143	191319	SCREW, SET 1/2-20X.500	5	400	545735-01	BRACKET, FINGER MOUNT BAR	2
473	107633	SCREW, SET 1/4-20X.250	2	485	545736-01	BRACKET, PROX MOUNT	1
382	107403	SCREW, SHCS 1/4-20X.375	8	380	545737-01	BRACKET, PROX TRIGGER	1
401	107403	SCREW, SHCS 1/4-20X.375	8	423	545738-01	ASSY, BELT DRIVE FRAME	1
402	107410	SCREW, SHCS 1/4-20X.500	3	488	545740-01	INDICATOR, SIDEGUIDE	1
480	107410	SCREW, SHCS 1/4-20X.500	1	526	545741-01	SPACER, FRAME	2
542	107410	SCREW, SHCS 1/4-20X.500	10	528	545742-01	PLATE, SIDEGUIDE ADJUST CLAMP	1
580	107410	SCREW, SHCS 1/4-20X.500	8	786	545743-01	WHEEL, SIDEGUIDE ADJUST	1
643	107410	SCREW, SHCS 1/4-20X.500	4	788	545744-01	RULE, FLAT SIDEGUIDE PLACEMENT	1
681	107410	SCREW, SHCS 1/4-20X.500	10	789	545745-01	INDICATOR, SIDEGUIDE	1
981	107410	SCREW, SHCS 1/4-20X.500	12	794	545746-01	SPACER, FRAME	1
377	107428	SCREW, SHCS 1/4-20X.625	16	617	545746-02	SPACER, FRAME	1
399	107428	SCREW, SHCS 1/4-20X.625	16	623	545746-03	SPACER, FRAME	1
540	107428	SCREW, SHCS 1/4-20X.625	2	802	545747-01	SPACER, MOTOR MOUNT	1
703	107428	SCREW, SHCS 1/4-20X.625	2	819	545748-01	ASSY, SIDE FRAME	1
716	107428	SCREW, SHCS 1/4-20X.625	2	820	545749-01	FRAME, RH SIDE	1
785	107428	SCREW, SHCS 1/4-20X.625	4	821	545749-02	FRAME, LH SIDE	1
316	107401	SCREW, SHCS 1/4-20X.750	4	804	545750-01	ASSY, INFEED LIFT	1
396	107401	SCREW, SHCS 1/4-20X.750	4	805	545751-01	WLDMT, TUBING CLAMP	1
495	107401	SCREW, SHCS 1/4-20X.750	2	806	545752-01	TUBING, VERTICAL CLAMP	1
732	107401	SCREW, SHCS 1/4-20X.750	1	808	545753-01	TUBING, VERTICAL BUMPTURN	1
971	107401	SCREW, SHCS 1/4-20X.750	4	909	545754-01	ASSY, OUTFEED CONVEYOR	1
455	107411	SCREW, SHCS 1/4-20X.875	12	910	545755-01	TABLETOP, OUTFEED CONVEYOR	1
763	107411	SCREW, SHCS 1/4-20X.875	6	911	545756-01	PLATE, OUTFEED CONVEYOR	1
774	107411	SCREW, SHCS 1/4-20X.875	6	912	545756-02	PLATE, OUTFEED CONVEYOR	1
934	107411	SCREW, SHCS 1/4-20X.875	7	914	545757-01	ROLLER, FLAT BELT	1
974	107411	SCREW, SHCS 1/4-20X.875	4	916	545757-02	ROLLER, FLAT BELT	1
59	107407	SCREW, SHCS 1/4-20X1.000	2	962	545757-02	ROLLER, FLAT BELT	1
456	107407	SCREW, SHCS 1/4-20X1.000	4	958	545757-03	ROLLER, FLAT BELT	1
512	107407	SCREW, SHCS 1/4-20X1.000	4	209	545758-01	BRACKET, CONVEYOR MOUNT	6
600	107407	SCREW, SHCS 1/4-20X1.000	4	921	545759-01	ROLLER, FLAT BELT	2
631	107407	SCREW, SHCS 1/4-20X1.000	1	961	545759-01	ROLLER, FLAT BELT	2
727	107407	SCREW, SHCS 1/4-20X1.000	1	922	545760-01	SHAFT, FLAT BELT DRIVE	1
878	107407	SCREW, SHCS 1/4-20X1.000	6	929	545761-01	SHAFT, MOTOR MOUNT SPACER	3
953	107407	SCREW, SHCS 1/4-20X1.000	2	930	545762-01	SHAFT, CONVEYOR SPACER	3
70	107402	SCREW, SHCS 1/4-20X1.250	5	931	545763-01	COVER, CONVEYOR BOTTOM	1
730	107402	SCREW, SHCS 1/4-20X1.250	1	822	545764-01	COVER, OUTFEED FRAME	1
970	107404	SCREW, SHCS 1/4-20X1.500	2	823	545765-01	COVER, INFEED FRAME	1
454	107425	SCREW, SHCS 1/4-20X1.750	4	894	545765-02	COVER, INFEED FRAME	1
459	107447	SCREW, SHCS 1/4-20X2.000	2	824	545766-01	BAR, FRAME SPACER	10
815	107447	SCREW, SHCS 1/4-20X2.000	1	825	545767-01	COVER, FRAME END	1
818	107443	SCREW, SHCS 1/4-20X2.250	1	826	545768-01	COVER, OUTFEED TOP LEXAN	1
138	CSD304	SCREW, SHCS 1/4-20X3.000	4	827	545769-01	COVER, TOP LEXAN	1
142	107417	SCREW, SHCS 10-32X.375	5	829	545770-01	COVER, FRONT LEXAN	1
579	107409	SCREW, SHCS 10-32X.500	8	830	545771-01	WLDMT, COVER TIMING BELT	2
680	107409	SCREW, SHCS 10-32X.500	8	831	545772-01	COVER, TIMING BELT	1
977	107409	SCREW, SHCS 10-32X.500	4	832	545773-01	STRIP, COVER TIMING BELT	1

69	107429	SCREW, SHCS 10-32X.625	8	828	545774-01	BAR, INFEED DOOR MOUNT	1
141	107429	SCREW, SHCS 10-32X.625	5	833	545775-01	SPACER, COVER MOUNT	4
273	107429	SCREW, SHCS 10-32X.625	2	834	545776-01	BAR, FRAME MOUNT	4
501	107429	SCREW, SHCS 10-32X.625	4	850	545777-01	COVER, UPPER SIDE LEXAN	1
976	107429	SCREW, SHCS 10-32X.625	8	862	545777-01	COVER, UPPER SIDE LEXAN	1
145	107430	SCREW, SHCS 10-32X.750	8	842	545778-01	COVER, LOWER SIDE LEXAN	1
461	107430	SCREW, SHCS 10-32X.750	8	836	545779-01	ASSY, DOOR HINGE	2
51	107408	SCREW, SHCS 10-32X1.000	2	851	545779-01	ASSY, DOOR HINGE	2
62	107408	SCREW, SHCS 10-32X1.000	2	863	545779-01	ASSY, DOOR HINGE	2
137	107408	SCREW, SHCS 10-32X1.000	6	837	545780-01	BLOCK, DOOR HINGE MOUNT	1
502	107406	SCREW, SHCS 10-32X1.250	4	852	545780-01	BLOCK, DOOR HINGE MOUNT	1
140	107440	SCREW, SHCS 3/8-16X1.000	8	864	545780-01	BLOCK, DOOR HINGE MOUNT	1
170	107468	SCREW, SHCS 4-40X1.000	6	840	545781-01	BRACKET, DOOR HINGE MOUNT	1
43	107427	SCREW, SHCS 5/16-18X.500	1	855	545781-01	BRACKET, DOOR HINGE MOUNT	1
56	107427	SCREW, SHCS 5/16-18X.500	1	867	545781-01	BRACKET, DOOR HINGE MOUNT	1
649	107427	SCREW, SHCS 5/16-18X.500	6	835	545782-01	ASSY, LEXAN DOOR	2
85	CSDD320	SCREW, SHCS 5/16-18X.750	1	843	545783-01	PLATE, DOOR HANDLE MOUNT	1
93	CSDD320	SCREW, SHCS 5/16-18X.750	1	857	545783-01	PLATE, DOOR HANDLE MOUNT	1
321	CSDD320	SCREW, SHCS 5/16-18X.750	2	869	545783-01	PLATE, DOOR HANDLE MOUNT	1
253	107422	SCREW, SHCS 5/16-18X1.000	1	941	545784-02	FRAME, OUTFEED CONVEYOR COVER	2
515	107448	SCREW, SHCS 5/16-18X2.25	2	937	545785-02	COVER, TUNNEL OUTFEED	1
613	107448	SCREW, SHCS 5/16-18X2.25	1	942	545785-03	COVER, OUTFEED CONV. TOP	1
728	107448	SCREW, SHCS 5/16-18X2.25	1	935	545786-02	ASSY, OUTFEED CONVEYOR COVER	1
544	CSDD212	SCREW, SHCS 6-32X.750	8	945	545787-01	SPACER, COVER MOUNT	4
381	CSDD236	SCREW, SHCS 8-32X.250	2	946	545788-01	HANDLE, COVER MOUNT	2
84	202718-3	SENSOR, PROXIMITY INDUCTIVE	1	849	545789-01	ASSY, SIDE COVER DOOR	1
92	202718-3	SENSOR, PROXIMITY INDUCTIVE	1	861	545789-03	ASSY, SIDE COVER DOOR	1
594	545698-01	SHAFT, ARM LOCK	1	848	545790-01	BLOCK, DOOR KEEPER	2
717	545698-01	SHAFT, ARM LOCK	1	860	545790-01	BLOCK, DOOR KEEPER	2
522	545698-02	SHAFT, ARM LOCK	1	872	545790-01	BLOCK, DOOR KEEPER	2
585	545691-01	SHAFT, ARM PIVOT	1	874	545791-01	BAR, MAGNET MOUNT	2
684	545691-01	SHAFT, ARM PIVOT	1	876	545792-01	BRACKET, DOOR STOP	2
468	545732-01	SHAFT, ARM PIVOT	1	640	545794-01	WLDMNT, AIR CYLINDER COVER	1
968	547523-01	SHAFT, AUTOLOADER ADJUSTMENT	1	641	545795-01	COVER, REJECT AIR CYLINDER	1
491	547210-01	SHAFT, BEAM SWITCH MOUNT	1	642	545796-01	COVER, REJECT AIR CYLINDER	1
509	545641-01	SHAFT, BELT ADJUST MOUNT	2	644	545797-01	SPACER, BEARING PLATE	3
627	545680-01	SHAFT, BELT TIGHTENER	1	886	545798-01	BOX, BUTTON	1
693	545680-01	SHAFT, BELT TIGHTENER	1	33	545799-01	GUIDE, PRODUCT TRANSFER	1
706	545680-01	SHAFT, BELT TIGHTENER	1	34	545799-02	GUIDE, PRODUCT TRANSFER	1
297	547194-01	SHAFT, CONTROL ARM PIVOT	2	35	545799-03	GUIDE, PRODUCT TRANSFER	1
930	545762-01	SHAFT, CONVEYOR SPACER	3	358	545800-01	ASSY, INFEED CONVEYOR/FRAME	1
471	545734-01	SHAFT, DISHING ADJUST	1	32	547182-01	ASSY, TURN TABLE GUIDE	1
466	545729-01	SHAFT, DISHING MOUNT	1	36	547183-01	SPACER, TURN TABLE GUIDE	12
407	545624-01	SHAFT, FINGER DRIVE	1	888	547184-01	LOGO, KR950	1
363	543984-01	SHAFT, FINGER SLIDE	2	889	547185-01	PLATE, KR950 LOGO BACKING	1
427	545634-01	SHAFT, FLAT BELT DRIVE	1	887	547186-01	ASSY, KR950 LOGO	2
426	545634-02	SHAFT, FLAT BELT DRIVE	1	291	547187-01	ASSY, STACKER CONTROL PANEL	1

514	545634-03	SHAFT, FLAT BELT DRIVE	1	299	547188-01	BOX, STACKER CONTROL PANEL	1
922	545760-01	SHAFT, FLAT BELT DRIVE	1	300	547188-02	BOX, STACKER CONTROL PANEL	2
55	543927-01	SHAFT, HTD TAKE UP ADJUST	1	301	547189-01	PANEL, STACKER CONTROL	1
551	545671-01	SHAFT, INFEED ROLLER	1	294	547190-01	TUBE, CONTROL PANEL ARM	1
314	547198-01	SHAFT, KNOB SPACER	1	296	547191-01	GLIDE, CONTROL ARM	1
929	545761-01	SHAFT, MOTOR MOUNT SPACER	3	293	547192-01	WLDmnt, CONTROL PANEL TUBE	1
103	543939-01	SHAFT, PINION	1	295	547193-01	FLANGE, WIRE TUBE	1
153	543958-01	SHAFT, PRODUCT LIFT SUPPORT	1	297	547194-01	SHAFT, CONTROL ARM PIVOT	2
411	545627-01	SHAFT, PULLEY IDLER	1	292	547195-01	PLATE, BOTTOM PIVOT CLAMP	1
750	545713-01	SHAFT, PULLEY IDLER	1	311	547196-01	PLATE, TOP PIVOT	1
107	543942-01	SHAFT, RACK GEAR SLIDE	1	312	547197-01	PLATE, TOP PIVOT MOUNT	1
543	545667-01	SHAFT, RACK GEAR SPACER	1	314	547198-01	SHAFT, KNOB SPACER	1
521	545661-01	SHAFT, SIDE GUIDE ADJUST	1	288	547199-01	ANGLE, CABINET SUPPORT	2
751	545714-01	SHAFT, SIDEGUIDE JOGGER	1	197	547199-02	ANGLE, CABINET SUPPORT	2
749	545712-01	SHAFT, SIDEGUIDE MOUNT	2	208	547199-03	ANGLE, CABINET SUPPORT	1
637	545681-01	SHAFT, SPRING MOUNT	1	322	547200-01	PANEL, ELECTRICAL	1
811	105601-1	SHAFT, THREADED 3/8-16	1	323	547201-02	ASSY, AIR REGULATOR	1
559	105633	SHAFT, THREADED 3/8-24 X 2.375	1	289	547202-01	BOX, REGULATOR MOUNT	1
257	547512-02	SHAFT, THREADED ADJUSTMENT	1	340	547203-01	HOLDER, MANUAL	1
669	545689-01	SHAFT, UPPER ARM ADJUST	1	601	547204-01	ASSY, OUTFEED CONVEYOR COVER	1
568	545689-02	SHAFT, UPPER ARM ADJUST	1	603	547205-01	TOP, INFEED BELT COVER	1
667	545686-01	SHAFT, UPPER BELT DRIVE	1	602	547206-01	FRAME, OUTFEED CONVEYOR COVER	2
567	545705-01	SHAFT, UPPER BELT DRIVE	1	609	547207-01	BRACKET, INFD BELT COVER MNT	2
573	545694-01	SHAFT, UPPER ROLLER IDLER	1	489	547208-01	ASSY, BEAM SWITCH MOUNT	1
674	545694-01	SHAFT, UPPER ROLLER IDLER	1	490	547209-01	POST, BEAM SWITCH MOUNT	1
686	545692-01	SHAFT, VERTICAL ARM	1	491	547210-01	SHAFT, BEAM SWITCH MOUNT	1
587	545692-02	SHAFT, VERTICAL ARM	1	646	547211-01	SPACER, CONVEYOR SUPPORT	1
320	100629	SHIM, 5/16 X 5/8 X 1/16	2	298	547212-01	WLDmnt, CONTROL PANEL	1
599	104100	SNAPRING, .375	1	416	547213-01	ASSY, FINGER VALVE	1
629	104100	SNAPRING, .375	1	520	547215-01	ASSY, SIDEGUIDE ADJUST SHAFT	1
694	104100	SNAPRING, .375	1	890	547217-01	BAR, TOP MOUNT	2
707	104100	SNAPRING, .375	1	891	547217-02	BAR, TOP MOUNT	2
726	104100	SNAPRING, .375	1	212	547220-01	COVER, HYDRALIFT	1
478	104106	SNAPRING, .500	4	319	547222-04	BAR, FRAME SUPPORT	2
26	104104	SNAPRING, .625	1	650	547223-01	BRACKET, INFEED RAMP SUPP	1
791	104104	SNAPRING, .625	4	651	547223-02	BRACKET, INFEED RAMP SUPP	1
598	104103	SNAPRING, .750	2	496	547226-01	BRACKET, SIDEGUIDE JOGGER	1
725	104103	SNAPRING, .750	2	892	547227-01	BRACKET, SAFETY SWITCH MNT	1
797	530511-01	SPACER, 3/4OD X 2L	2	213	547228-01	COVER, CONVEYOR PLUG	3
112	543946-01	SPACER, BEARING PLATE	4	214	547229-01	BLOCK, AIR MANIFOLD	1
720	545725-01	SPACER, BEARING PLATE	4	698	547231-01	BRACKET, SPRING ADJUST	1
644	545797-01	SPACER, BEARING PLATE	3	711	547231-01	BRACKET, SPRING ADJUST	1
646	547211-01	SPACER, CONVEYOR SUPPORT	1	497	547233-01	BLOCK, GUIDE PIVOT	2
833	545775-01	SPACER, COVER MOUNT	4	498	547234-01	BLOCK, GUIDE PIVOT	2
945	545787-01	SPACER, COVER MOUNT	4	163	547235-01	ASSY, AIR VALVE	1
526	545741-01	SPACER, FRAME	2	345	547236-01	ASSY, AIR MANIFOLD	1
794	545746-01	SPACER, FRAME	1	895	547236-02	ASSY, AIR BLOW DOWN	1

617	545746-02	SPACER, FRAME	1	893	547237-01	TRAY, TOOL	2
623	545746-03	SPACER, FRAME	1	175	547238-01	GUIDE, AIR HOSE	1
611	SP6383-1	SPACER, GEAR COVER	4	351	547239-01	BRACKET, PHOENIX CONNECTOR	1
242	547510-01	SPACER, HANDLE ADJUST	1	356	547239-02	BLOCKOFF, PHOENIX CONNECTOR	1
29	543930-01	SPACER, MOTOR MOUNT	4	758	547240-01	PLATE, SIDEGUIDE MOUNT	1
802	545747-01	SPACER, MOTOR MOUNT	1	777	547240-01	PLATE, SIDEGUIDE MOUNT	1
578	547765-01	SPACER, ROLLER ARM	1	337	547453-01	WLDMNT, LH ELECTRICAL DOOR	1
679	547765-01	SPACER, ROLLER ARM	2	341	547454-01	WLDMNT, RH ELECTRICAL DOOR	1
463	545683-01	SPACER, TABLETOP	3	206	547456-01	WLDMNT, CONVEYOR MOUNT	1
506	545683-02	SPACER, TABLETOP	1	951	547457-01	PLATE, OUTFEED ROLLER TAKEUP	2
975	547527-01	SPACER, TABLETOP	6	957	547457-01	PLATE, OUTFEED ROLLER TAKEUP	2
36	547183-01	SPACER, TURN TABLE GUIDE	12	952	547458-01	BLOCK, OUTFEED TAKEUP	2
615	102962	SPRING, COMPRESSION	1	290	547459-01	HOLDER, TABLE LIFT WING	1
736	102962	SPRING, COMPRESSION	1	82	547460-01	BRACKET, PROX MOUNT	1
632	102607	SPRING, EXTENSION	1	95	547460-01	BRACKET, PROX MOUNT	1
733	102607	SPRING, EXTENSION	1	900	547461-01	ASSY, STACK LIGHT	1
251	102792	SPRING, EXTENSION	1	902	547462-01	BRACKET, STACK LIGHT MNT	1
270	102792	SPRING, EXTENSION	1	217	547463-02	ASSY, HORIZONTAL ADJUSTMENT	1
278	102792	SPRING, EXTENSION	1	218	547464-01	TUBE, FRONT MOUNT	1
699	102964	SPRING, EXTENSION	1	219	547464-02	TUBE, SIDE MOUNT	1
712	102964	SPRING, EXTENSION	1	221	547465-01	TUBE, SIDE MOUNT	1
832	545773-01	STRIP, COVER TIMING BELT	1	220	547466-02	WLDMNT, SIDE TUBE MOUNT	2
25	543924-01	STUD, BELT DIVERT IDLER	1	223	547467-01	ANGLE, TUBE SIDE MOUNT	1
116	543924-02	STUD, BELT DIVERT IDLER	1	222	547467-02	ANGLE, SIDE TUBE MOUNT	1
370	543991-01	STUD, FINGER MOUNT	1	225	547468-01	PLATE, ADJUSTMENT MOUNT	2
389	543991-01	STUD, FINGER MOUNT	1	226	547507-01	ASSY, ADJUST ROLLER	2
372	543998-01	STUD, FORK END	1	231	547507-02	ASSY, ADJUST ROLLER	2
391	543998-01	STUD, FORK END	1	228	547509-01	ROLLER, ADJUST	1
549	545669-02	TABLETOP, INFEED RAMP	1	233	547509-02	ROLLER, ADJUST GUIDE	1
910	545755-01	TABLETOP, OUTFEED CONVEYOR	1	242	547510-01	SPACER, HANDLE ADJUST	1
148	543947-01	TABLETOP, PRODUCT LIFT	1	260	547511-02	BLOCK, THREADED ROD MOUNT	1
179	543973-01	TABLETOP, PRODUCT LIFT SUPPORT	2	257	547512-02	SHAFT, THREADED ADJUSTMENT	1
180	543973-02	TABLETOP, PRODUCT LIFT SUPPORT	2	245	547513-01	ASSY, HYDRALIFT LEG	4
659	547535-01	TABLETOP, STATIC BAR FILLER	1	246	547514-01	PLATE, HYDRALIFT LEG MOUNT	1
460	545665-01	TOP, HORZ. TABLETOP	1	252	547515-01	COVER, HYDRALIFT LEG	1
603	547205-01	TOP, INFEED BELT COVER	1	262	547517-02	BLOCK, SCREW CAPTURE	1
973	547525-01	TOP, ROLLER ADJUST TABLE	1	256	547518-02	ASSY, HANDWHEEL	1
134	543964-02	TRACK, PUSHER ROLLER	2	954	547519-01	ASSY, OUTFEED BELT ADJUST	1
41	543898-01	TRACK, V ROLLER GUIDE	4	955	547520-01	PLATE, OUTFEED ADJUST MOUNT	2
893	547237-01	TRAY, TOOL	2	956	547521-01	PLATE, ROLLER MOUNT	2
294	547190-01	TUBE, CONTROL PANEL ARM	1	963	547522-01	RACK, ROLLER ADJUST	2
218	547464-01	TUBE, FRONT MOUNT	1	968	547523-01	SHAFT, AUTOLOADER ADJUSTMENT	1
219	547464-02	TUBE, SIDE MOUNT	1	973	547525-01	TOP, ROLLER ADJUST TABLE	1
221	547465-01	TUBE, SIDE MOUNT	1	972	547526-01	BAR, FRAME SPACER	2
808	545753-01	TUBING, VERTICAL BUMPTURN	1	975	547527-01	SPACER, TABLETOP	6
806	545752-01	TUBING, VERTICAL CLAMP	1	978	547528-01	PLATE, BELT ADJUST SPLICE	2
898	191349	VALVE, 1/4 NPT MALE	2	982	547529-01	COVER, CONVEYOR BOTTOM	1

326	191303-1	VALVE, AIR SAFETY	1	938	547530-01	END, TUNNEL COVER	1
168	191343	VALVE, THREE POSITION EXHAUST CTR	1	939	547530-02	END, TUNNEL COVER	1
167	191342	VALVE, THREE POSTION CLOSED CENTER	1	936	547531-01	WLDMNT, OUTFEED CONV. COVER	1
417	191342	VALVE, THREE POSTION CLOSED CENTER	1	157	547532-01	BUSHING, .625ID 1.125OD CROWNED	2
558	202708	VALVE, THREE WAY AIR	1	366	547532-01	BUSHING, .625ID 1.125OD CROWNED	4
169	191341	VALVE, TWO POSITION SINGLE	1	385	547532-01	BUSHING, .625ID 1.125OD CROWNED	4
616	547778-01	WASHER, 7 GA 3/8 ID 3/4 OD	4	443	547532-01	BUSHING, .625ID 1.125OD CROWNED	4
737	547778-01	WASHER, 7 GA 3/8 ID 3/4 OD	4	535	547532-01	BUSHING, .625ID 1.125OD CROWNED	4
230	100633	WASHER, 750 X .125 FLAT	2	654	547533-01	KIT, STATIC BAR	1
235	100633	WASHER, 750 X .125 FLAT	2	655	547534-01	BRACKET, STATIC BAR	2
58	111509	WASHER, FLAT .257ID .515OD .120TH	2	657	547534-02	BRACKET, STATIC BAR	2
702	111509	WASHER, FLAT .257ID .515OD .120TH	2	659	547535-01	TABLETOP, STATIC BAR FILLER	1
715	111509	WASHER, FLAT .257ID .515OD .120TH	2	658	547536-01	BRACKET, TABLETOP MOUNT	4
68	100603	WASHER, FLAT 1/4ID	11	265	547537-01	KIT, 950 1000LB HYDRALIFT	1
128	100603	WASHER, FLAT 1/4ID	1	581	547539-01	HANDLE, INFEED ROLLER RELEASE	1
378	100603	WASHER, FLAT 1/4ID	8	671	547762-01	PLATE, BEARING MNT	2
397	100603	WASHER, FLAT 1/4ID	12	574	547762-02	PLATE, BEARING MNT	1
475	100603	WASHER, FLAT 1/4ID	6	570	547762-03	PLATE, BEARING MNT	1
944	100603	WASHER, FLAT 1/4ID	6	572	547763-01	BLOCK, ROLLER STUD MOUNT	1
446	100604	WASHER, FLAT 1/4ID BRASS	1	673	547763-01	BLOCK, ROLLER STUD MOUNT	1
479	100604	WASHER, FLAT 1/4ID BRASS	2	672	547764-01	BRACKET, ROLLER ARM	2
50	100619	WASHER, FLAT 10-32	2	571	547764-02	BRACKET, ROLLER ARM	2
61	100619	WASHER, FLAT 10-32	2	578	547765-01	SPACER, ROLLER ARM	1
628	WA013	WASHER, FLAT 3/8	7	679	547765-01	SPACER, ROLLER ARM	2
75	100602	WASHER, FLAT 5/16ID	1	670	547766-01	ASSY, UPPER BELT	1
614	100602	WASHER, FLAT 5/16ID	3	569	547766-02	ASSY, UPPER BELT	1
723	100602	WASHER, FLAT 5/16ID	5	616	547778-01	WASHER, 7 GA 3/8 ID 3/4 OD	4
9	100616	WASHER, FLAT 5/16ID .020TK	1	737	547778-01	WASHER, 7 GA 3/8 ID 3/4 OD	4
14	100616	WASHER, FLAT 5/16ID .020TK	1	908	547779-01	BRACKET, SPRING MOUNT	1
42	100616	WASHER, FLAT 5/16ID .020TK	1	544	CSDD212	SCREW, SHCS 6-32X.750	8
123	100616	WASHER, FLAT 5/16ID .020TK	1	381	CSDD236	SCREW, SHCS 8-32X.250	2
933	100401	WASHER, THRUST TB410	3	138	CSDD304	SCREW, SHCS 1/4-20X3.000	4
966	100401	WASHER, THRUST TB410	2	85	CSDD320	SCREW, SHCS 5/16-18X.750	1
155	100402	WASHER, THRUST TB612	2	93	CSDD320	SCREW, SHCS 5/16-18X.750	1
241	100402	WASHER, THRUST TB612	2	321	CSDD320	SCREW, SHCS 5/16-18X.750	2
783	100400	WASHER, THRUST TW31	4	847	CSFF54	SCREW, BUTTON HEAD #8-32X.625	2
27	100407	WASHER, THRUST TW62	2	906	CSFF55	SCREW, BUTTON HEAD #8-32X.750	2
259	100407	WASHER, THRUST TW62	2	487	CSFF63	SCREW, BUTTON HEAD 1/4X.250	4
8	102908	WHEEL, GUIDE W3X	1	661	CSFF63	SCREW, BUTTON HEAD 1/4X.250	2
13	102908	WHEEL, GUIDE W3X	1	244	HJN012	NUT, JAM 3/8-16	12
122	102908	WHEEL, GUIDE W3X	1	162	HJN013	NUT, JAM 7/16-14	2
779	545722-01	WHEEL, SIDEGUIDE ADJUST	1	28	HJN016	NUT, JAM 5/8-12	2
786	545743-01	WHEEL, SIDEGUIDE ADJUST	1	193	HJN019	NUT, JAM 1-8	4
640	545794-01	WLDMNT, AIR CYLINDER COVER	1	224	HJN019	NUT, JAM 1-8	2
283	545614-01	WLDMNT, CONTROL BOX	1	263	HJN019	NUT, JAM 1-8	1
298	547212-01	WLDMNT, CONTROL PANEL	1	158	HMSN14	NUT, HEX 3/8-16	2
293	547192-01	WLDMNT, CONTROL PANEL TUBE	1	589	HMSN14	NUT, HEX 3/8-16	1

206	547456-01	WLDMNT, CONVEYOR MOUNT	1	688	HMSN14	NUT, HEX 3/8-16	1
337	547453-01	WLDMNT, LH ELECTRICAL DOOR	1	839	HMSN14	NUT, HEX 3/8-16	1
936	547531-01	WLDMNT, OUTFEED CONV. COVER	1	854	HMSN14	NUT, HEX 3/8-16	1
341	547454-01	WLDMNT, RH ELECTRICAL DOOR	1	866	HMSN14	NUT, HEX 3/8-16	1
220	547466-02	WLDMNT, SIDE TUBE MOUNT	2	1	KR950	ASSY, COMPENSATION STACKER	1
187	545603-01	WLDMNT, STACKER CABINET	1	243	RHB085	BOLT, HEX HEAD 3/8-16X2.25	12
830	545771-01	WLDMT, COVER TIMING BELT	2	611	SP6383-1	SPACER, GEAR COVER	4
805	545751-01	WLDMT, TUBING CLAMP	1	628	WA013	WASHER, FLAT 3/8	7

ASSEMBLY INDEX LIST

Index #	Part #	Description	Qty.
1	KR950	.ASSY, COMPENSATION STACKER	1
2	543899-01	. ASSY, TURN TABLE AND MOUNT	1
3	543994-01	. ASSY, TURN TABLE DRIVE	1
4	543900-01	. PLATE, TURN TABLE MOUNT	1
5	543900-02	. PLATE, TURN TABLE MOUNT	1
6	543902-01	. ASSY, GUIDE WHEEL CONCENTRIC	2
7	102909	. BUSHING, ADAPTER STRAIGHT B3	1
8	102908	. WHEEL, GUIDE W3X	1
9	100616	. WASHER, FLAT 5/16ID .020TK	1
10	107330	. BOLT, HEX HEAD 5/16-18X1.50	1
11	543901-01	. ASSY, GUIDE WHEEL ECCENTRIC	1
12	102910	. BUSHING, ADAPTER ADJ. BX3	1
13	102908	. WHEEL, GUIDE W3X	1
14	100616	. WASHER, FLAT 5/16ID .020TK	1
15	107330	. BOLT, HEX HEAD 5/16-18X1.50	1
16	102911	. COVER, V ROLLER WC3A	1
17	543919-02	. ASSY, SERVO MOTOR	1
18	543920-01	. PLATE, STEPPER MOTOR MOUNT	1
19	191237	. REDUCER, SERVO MOTOR	1
20	200615	. MOTOR, SERVO	1
21	543921-01	. PULLEY, 26-8M-20 HTD 16mm BORE	1
22	543923-01	. ASSY, DIVERT ROLLER	2
23	543922-01	. ROLLER, HTD DIVERT BELT	1
24	103804	. BEARING, HUB .625	2
25	543924-01	. STUD, BELT DIVERT IDLER	1
26	104104	. SNAPRING, .625	1
27	100407	. WASHER, THRUST TW62	2
28	HJN016	. NUT, JAM 5/8-12	2
29	543930-01	. SPACER, MOTOR MOUNT	4
30	543931-01	. BRACKET, PROX MOUNT	1
31	201055-1	. PROXIMITY	2
32	547182-01	. ASSY, TURN TABLE GUIDE	1
33	545799-01	. GUIDE, PRODUCT TRANSFER	1
34	545799-02	. GUIDE, PRODUCT TRANSFER	1

35	545799-03	GUIDE, PRODUCT TRANSFER	1
36	547183-01	SPACER, TURN TABLE GUIDE	12
37	543896-01	ASSY, TURN TABLE	1
38	543972-01	ASSY, TURN TABLE	1
39	543897-01	PLATE, RH TURN TABLE	1
40	543897-02	PLATE, RH TURN TABLE	1
41	543898-01	TRACK, V ROLLER GUIDE	4
42	100616	WASHER, FLAT 5/16ID .020TK	1
43	107427	SCREW, SHCS 5/16-18X.500	1
44	543918-02	RING, HTD BELT GUIDE	2
45	543918-01	RING, HTD BELT GUIDE	4
46	543926-01	ASSY, HTD BELT TAKE UP	1
47	543925-01	PULLEY, 26-8M-20 HTD TAKE UP	1
48	543928-02	PLATE, HTD TAKE UP MOUNT	1
49	543929-01	PLATE, HTD BELT CLAMP	1
50	100619	WASHER, FLAT 10-32	2
51	107408	SCREW, SHCS 10-32X1.000	2
52	107506	SCREW, FLATHEAD 1/4-20X.750	2
53	543926-02	ASSY, HTD BELT TAKE UP	1
54	543925-01	PULLEY, 26-8M-20 HTD TAKE UP	1
55	543927-01	SHAFT, HTD TAKE UP ADJUST	1
56	107427	SCREW, SHCS 5/16-18X.500	1
57	543928-01	PLATE, HTD TAKE UP MOUNT	1
58	111509	WASHER, FLAT .257ID .515OD .120TH	2
59	107407	SCREW, SHCS 1/4-20X1.000	2
60	543929-01	PLATE, HTD BELT CLAMP	1
61	100619	WASHER, FLAT 10-32	2
62	107408	SCREW, SHCS 10-32X1.000	2
63	543932-01	BRACKET, PROX SCREW	4
64	543962-01	ASSY, TABLE ROLLER	2
65	543963-01	BRACKET, PULLEY ROLLER	1
66	103104	BEARING, FLAT .250	11
67	106816	SCREW, BUTTON HEAD 1/4X.375	11
68	100603	WASHER, FLAT 1/4ID	11
69	107429	SCREW, SHCS 10-32X.625	8
70	107402	SCREW, SHCS 1/4-20X1.250	5
71	543969-01	RULE, FLAT SIDEGUIDE PLACEMENT	2
72	543910-01	ASSY, SIDE GUIDE	2
73	543907-01	BLOCK, SIDE GUIDE ADJUST CLAMP	1
74	543912-01	BLOCK, PRODUCT GUIDE MOUNT	1
75	100602	WASHER, FLAT 5/16ID	1
76	102149	HANDLE, RELEASE 5/16-18 X 1.26	1
77	543911-01	PLATE, PRODUCT GUIDE	1
78	543974-01	PLATE, SIDEGUIDE SUPPORT	1
79	543915-01	ASSY, RETRACTABLE PRODUCT GUIDE	1
80	109694	CYLINDER, PRODUCT GUIDE AIR	1
81	543916-01	BLOCK, AIR CYLINDER MOUNT	1
82	547460-01	BRACKET, PROX MOUNT	1
83	543917-01	PLATE, AIR CYLINDER CLAMP	1
84	202718-3	SENSOR, PROXIMITY INDUCTIVE	1
85	CSDD320	SCREW, SHCS 5/16-18X.750	1
86	191337	FITTING, ELBOW 1/8 NPT 1/4 TUBE	2
87	106811	SCREW, BUTTON HEAD #10-32X.250	2

88	543915-02	ASSY, RETRACTABLE PRODUCT GUIDE	1
89	109694	CYLINDER, PRODUCT GUIDE AIR	1
90	543916-01	BLOCK, AIR CYLINDER MOUNT	1
91	543917-01	PLATE, AIR CYLINDER CLAMP	1
92	202718-3	SENSOR, PROXIMITY INDUCTIVE	1
93	CSDD320	SCREW, SHCS 5/16-18X.750	1
94	191337	FITTING, ELBOW 1/8 NPT 1/4 TUBE	2
95	547460-01	BRACKET, PROX MOUNT	1
96	106811	SCREW, BUTTON HEAD #10-32X.250	2
97	543933-01	ASSY, PUSHER	1
98	109692	CYLINDER, 8" STROKE 2-1/2 DIA AIR	1
99	543934-01	PLATE, AIR CYLINDER MNT	2
100	543935-01	BLOCK, PUSHER AIR CYLINDER MNT	1
101	543936-01	RACK, PUSHER DRIVE	1
102	543938-01	GEAR, 1624 PINION	1
103	543939-01	SHAFT, PINION	1
104	103805	BEARING, HUB .750	2
105	543940-01	PULLEY, 40-8M-20 HTD	1
106	543941-01	PLATE, PUSHER MOUNT	1
107	543942-01	SHAFT, RACK GEAR SLIDE	1
108	543943-01	BLOCK, BUSHING MOUNT	2
109	102912	LINEAR BUSHING, THOMSON	2
110	543944-01	POST, RACK SHAFT MOUNT	1
111	543945-01	PLATE, BEARING MOUNT	1
112	543946-01	SPACER, BEARING PLATE	4
113	543923-02	ASSY, DIVERT ROLLER	4
114	543922-01	ROLLER, HTD DIVERT BELT	1
115	103804	BEARING, HUB .625	2
116	543924-02	STUD, BELT DIVERT IDLER	1
117	109138	BELT, HTD 8M-1440-20	1
118	543948-01	ASSY, PUSHER BAR	1
119	543949-01	PLATE, PUSHER BAR SLIDE	1
120	543902-01	ASSY, GUIDE WHEEL CONCENTRIC	2
121	102909	BUSHING, ADAPTER STRAIGHT B3	1
122	102908	WHEEL, GUIDE W3X	1
123	100616	WASHER, FLAT 5/16ID .020TK	1
124	107330	BOLT, HEX HEAD 5/16-18X1.50	1
125	543950-01	BAR, PUSHER	1
126	543965-02	BRACKET, PUSHER BELT MNT	1
127	107327	BOLT, 1/4-20 X .500	2
128	100603	WASHER, FLAT 1/4ID	1
129	190965	BALL PLUNGER, DELRIN NOSE 3/8-16	2
130	107541	SCREW, FLATHEAD 5/16-18X.750	2
131	106818	SCREW, BUTTON HEAD 1/4X.500	2
132	543951-01	PLATE, PUSHER TRACK MOUNT	1
133	543952-01	PLATE, VERTICAL PUSHER MOUNT	2
134	543964-02	TRACK, PUSHER ROLLER	2
135	543966-02	PLATE, TRACK SUPPORT	1
136	543936-02	RACK, PUSHER DRIVE	1
137	107408	SCREW, SHCS 10-32X1.000	6
138	CSDD304	SCREW, SHCS 1/4-20X3.000	4
139	106811	SCREW, BUTTON HEAD #10-32X.250	4
140	107440	SCREW, SHCS 3/8-16X1.000	8

141	107429	.	SCREW, SHCS 10-32X.625	5
142	107417	.	SCREW, SHCS 10-32X.375	5
143	191319	.	SCREW, SET 1/2-20X.500	5
144	191336	.	FITTING, 1/4T 1/4NPT SPEED CONTROL	2
145	107430	.	SCREW, SHCS 10-32X.750	8
146	543953-01	.	ASSY, PRODUCT LIFT	1
147	109693	.	CYLINDER, 12 INCH LIFT	1
148	543947-01	.	TABLETOP, PRODUCT LIFT	1
149	543954-01	.	BLOCK, LIFT CYLINDER MOUNT	1
150	543955-01	.	BAR, LIFT MOUNT SPACER	2
151	543956-02	.	BLOCK, LIFT TABLE MOUNT	1
152	543957-01	.	BAR, LIFT SHAFT MOUNT	1
153	543958-01	.	SHAFT, PRODUCT LIFT SUPPORT	1
154	543956-01	.	BLOCK, LIFT TABLE MOUNT	1
155	100402	.	WASHER, THRUST TB612	2
156	543959-01	.	BLOCK, LIFT SHAFT BUSHING	2
157	547532-01	.	BUSHING, .625ID 1.125OD CROWNED	2
158	HMSN14	.	NUT, HEX 3/8-16	2
159	543960-01	.	BLOCK, LIFT CYLINDER MOUNT	1
160	543961-01	.	BLOCK, LIFT CYLINDER MOUNT	1
161	106811	.	SCREW, BUTTON HEAD #10-32X.250	2
162	HJN013	.	NUT, JAM 7/16-14	2
163	547235-01	.	ASSY, AIR VALVE	1
164	543967-01	.	PLATE, PNEUMATIC HARNESS	1
165	545622-01	.	BRACKET, TERMINAL MOUNT	1
166	543970-01	.	BLOCK, AIR MANIFOLD	1
167	191342	.	VALVE, THREE POSTION CLOSED CENTER	1
168	191343	.	VALVE, THREE POSITION EXHAUST CTR	1
169	191341	.	VALVE, TWO POSITION SINGLE	1
170	107468	.	SCREW, SHCS 4-40X1.000	6
171	191296	.	FITTING, STRAIGHT 1/4 T 1/8 NPT	4
172	191296	.	FITTING, STRAIGHT 1/4 T 1/8 NPT	1
173	191340	.	MUFFLER, 1/8 NPT AIR	6
174	191352	.	FITTING, 1/4NPT 3/8TUBE ROTARY	1
175	547238-01	.	GUIDE, AIR HOSE	1
176	191338	.	FITTING, 1/4 TUBE TEE	2
177	543969-01	.	RULE, FLAT SIDEGUIDE PLACEMENT	2
178	107537	.	SCREW, FLATHEAD 1/4-20X.875	4
179	543973-01	.	TABLETOP, PRODUCT LIFT SUPPORT	2
180	543973-02	.	TABLETOP, PRODUCT LIFT SUPPORT	2
181	545613-01	.	PLATE, PRODUCT LIFT SCAB	2
182	191337	.	FITTING, ELBOW 1/8 NPT 1/4 TUBE	1
183	107546	.	SCREW, FLHD UNDERCUT 10-32X.250	12
184	191394	.	FITTING, FLOW CONTROL METER OUT	1
185	191394	.	FITTING, FLOW CONTROL METER OUT	1
186	545602-01	.	ASSY, STACKER CABINET	1
187	545603-01	.	WLDMNT, STACKER CABINET	1
188	545604-01	.	BASE, CABINET	1
189	545605-01	.	PANEL, INFEED END	1
190	545606-01	.	PANEL, OUTFEED END SPEC.	1
191	545607-01	.	PANEL, TOP	1
192	190670	.	CASTER, 3.500 SWIVEL	4
193	HJN019	.	NUT, JAM 1-8	4

194	545609-01	PANEL, BASE END	1
195	545609-02	PANEL, BASE END	1
196	539527-06	CHANNEL, PUMP MOUNT	1
197	547199-02	ANGLE, CABINET SUPPORT	2
198	545612-01	PLATE, CABINET WEIGHT	10
199	545608-01	DOOR, DROPOUT CABINET	3
200	538024-02	ASSY, 1 IN. LEVELING LEG 8.00 LNG	4
201	191010-3	LEVELING BOLT, CABINET	1
202	190634	FOOT, MOUNTING	1
203	191011	NUT, CABINET LEVELING	1
204	190689-1	DOOR LATCH	6
205	545610-01	CHANNEL, REMOVABLE END	1
206	547456-01	WLDMNT, CONVEYOR MOUNT	1
207	545611-01	BRACKET, END CHANNEL MOUNT	1
208	547199-03	ANGLE, CABINET SUPPORT	1
209	545758-01	BRACKET, CONVEYOR MOUNT	6
210	107339	BOLT, HEX HEAD 5/16-18X1.25	6
211	107348	BOLT, HEX HEAD 5/16-18X1.75	6
212	547220-01	COVER, HYDRALIFT	1
213	547228-01	COVER, CONVEYOR PLUG	3
214	547229-01	BLOCK, AIR MANIFOLD	1
215	191298	FITTING, STRAIGHT 3/8 T 1/4 NPT	1
216	191351	FITTING, ELBOW .375T .250NPT	1
217	547463-02	ASSY, HORIZONTAL ADJUSTMENT	1
218	547464-01	TUBE, FRONT MOUNT	1
219	547464-02	TUBE, SIDE MOUNT	1
220	547466-02	WLDMNT, SIDE TUBE MOUNT	2
221	547465-01	TUBE, SIDE MOUNT	1
222	547467-02	ANGLE, SIDE TUBE MOUNT	1
223	547467-01	ANGLE, TUBE SIDE MOUNT	1
224	HJN019	NUT, JAM 1-8	2
225	547468-01	PLATE, ADJUSTMENT MOUNT	2
226	547507-01	ASSY, ADJUST ROLLER	2
227	104415	BOLT, HEX HEAD 3/4-10X2.00	1
228	547509-01	ROLLER, ADJUST	1
229	103112	BEARING, FLAT .750	2
230	100633	WASHER, 750 X .125 FLAT	2
231	547507-02	ASSY, ADJUST ROLLER	2
232	104415	BOLT, HEX HEAD 3/4-10X2.00	1
233	547509-02	ROLLER, ADJUST GUIDE	1
234	103112	BEARING, FLAT .750	2
235	100633	WASHER, 750 X .125 FLAT	2
236	538024-01	ASSY, 1 IN. LEVELING LEG	4
237	191010	LEVELING BOLT, CABINET	1
238	190634	FOOT, MOUNTING	1
239	191011	NUT, CABINET LEVELING	1
240	191361	KNOB, 375-16 QUICK ADJUST	2
241	100402	WASHER, THRUST TB612	2
242	547510-01	SPACER, HANDLE ADJUST	1
243	RHB085	BOLT, HEX HEAD 3/8-16X2.25	12
244	HJN012	NUT, JAM 3/8-16	12
245	547513-01	ASSY, HYDRALIFT LEG	4
246	547514-01	PLATE, HYDRALIFT LEG MOUNT	1

247	539425-03	ASSY, HYDRALIFT LEG	1
248	191029-3	GLIDE, SUSPA	1
249	191029-2	CYLINDER, LIFT CB415	1
250	537371-01	BRACKET, SPRING RETURN MOUNT	1
251	102792	SPRING, EXTENSION	1
252	547515-01	COVER, HYDRALIFT LEG	1
253	107422	SCREW, SHCS 5/16-18X1.000	1
254	106712	NUT, HEX 5/16-18	1
255	107502	SCREW, FLATHEAD 10-32X.375	4
256	547518-02	ASSY, HANDWHEEL	1
257	547512-02	SHAFT, THREADED ADJUSTMENT	1
258	102108-4	HANDWHEEL, CLUTCH BEARING	1
259	100407	WASHER, THRUST TW62	2
260	547511-02	BLOCK, THREADED ROD MOUNT	1
261	100144	BUSHING, SL.625ID.750OD.625LG	1
262	547517-02	BLOCK, SCREW CAPTURE	1
263	HJN019	NUT, JAM 1-8	1
264	190780	LABEL, TIMING BELT WARNING	3
265	547537-01	KIT, 950 1000LB HYDRALIFT	1
266	541180-02	ASSY, LH HYDRALIFT LEG	2
267	191029-3	GLIDE, SUSPA	1
268	191032-02	CYLINDER, LIFT CB615 1000LB	1
269	537371-01	BRACKET, SPRING RETURN MOUNT	1
270	102792	SPRING, EXTENSION	1
271	537596-03	BLOCK, HYDRAULIC LIFT LH	2
272	537597-03	BRACKET, HYDRAULIC LIFT SPRING	1
273	107429	SCREW, SHCS 10-32X.625	2
274	541179-02	ASSY, RH HYDRALIFT LEG 1000LB	2
275	191029-3	GLIDE, SUSPA	1
276	191032-02	CYLINDER, LIFT CB615 1000LB	1
277	537371-01	BRACKET, SPRING RETURN MOUNT	1
278	102792	SPRING, EXTENSION	1
279	537596-04	BLOCK, HYDRAULIC LIFT LH	2
280	537597-04	BRACKET, HYDRAULIC LIFT SPRING	1
281	191032-01	PUMP, MOVOTEC PB4615FC	1
282	545621-01	ASSY, ELECTRICAL BOX	1
283	545614-01	WLDMNT, CONTROL BOX	1
284	545620-01	PANEL, REAR ELECTRICAL	1
285	545616-01	PANEL, CONTROL BOX BOTTOM	1
286	107325	HEX HEAD BOLT 1/4-20 X 1.50"	4
287	545618-01	PANEL, CONTROL BOX TOP	1
288	547199-01	ANGLE, CABINET SUPPORT	2
289	547202-01	BOX, REGULATOR MOUNT	1
290	547459-01	HOLDER, TABLE LIFT WING	1
291	547187-01	ASSY, STACKER CONTROL PANEL	1
292	547195-01	PLATE, BOTTOM PIVOT CLAMP	1
293	547192-01	WLDMNT, CONTROL PANEL TUBE	1
294	547190-01	TUBE, CONTROL PANEL ARM	1
295	547193-01	FLANGE, WIRE TUBE	1
296	547191-01	GLIDE, CONTROL ARM	1
297	547194-01	SHAFT, CONTROL ARM PIVOT	2
298	547212-01	WLDMNT, CONTROL PANEL	1
299	547188-01	BOX, STACKER CONTROL PANEL	1

300	547188-02	BOX, STACKER CONTROL PANEL	2
301	547189-01	PANEL, STACKER CONTROL	1
302	202537	CONSOLE, TOUCH SCREEN	1
303	201169	PLATE, CUSTOM LABEL	6
304	201125-5	BUTTON, POWER OFF	1
305	201124-4	BUTTON, POWER ON	1
306	201124-2	BUTTON, START	1
307	201125-3	BUTTON, STOP	1
308	190955	HANDLE	2
309	201126-1	BUTTON, JOG	2
310	209016	KNOB, POT	2
311	547196-01	PLATE, TOP PIVOT	1
312	547197-01	PLATE, TOP PIVOT MOUNT	1
313	100326	BUSHING, FL1.000ID1.250OD.750LG	1
314	547198-01	SHAFT, KNOB SPACER	1
315	102134-1	HANDLE - RELEASE	1
316	107401	SCREW, SHCS 1/4-20X.750	4
317	106811	SCREW, BUTTON HEAD #10-32X.250	4
318	106815	SCREW, BUTTON HEAD 1/4X.625	4
319	547222-04	BAR, FRAME SUPPORT	2
320	100629	SHIM, 5/16 X 5/8 X 1/16	2
321	CSDD320	SCREW, SHCS 5/16-18X.750	2
322	547200-01	PANEL, ELECTRICAL	1
323	547201-02	ASSY, AIR REGULATOR	1
324	191300-1	REGULATOR, AIR	1
325	191299-1	FILTER, AIR	1
326	191303-1	VALVE, AIR SAFETY	1
327	191344	FITTING, 1/4 NPT 3/8 TUBE ELBOW	1
328	190606	FITTING - 90 DEG 1/4 NPT	1
329	109544	NIPPLE, 1/4 NPT AIR GUN	1
330	191353	BRACKET, AIR REGULATOR MOUNT	2
331	191393	MUFFLER, 1/4 NPT	1
332	208503	FAN, SUNON SP100A	2
333	208504-1	ASSY, FILTER/FINGER GUARD	2
334	208505	GUARD, FINGER	1
335	208504	FILTER, FAN	1
336	530441-06	BOX, ELECTRICAL INLET 30A	1
337	547453-01	WLDMNT, LH ELECTRICAL DOOR	1
338	545617-01	DOOR, CONTROL BOX	1
339	191223	HINGE, CONCEALED REMOVABLE	2
340	547203-01	HOLDER, MANUAL	1
341	547454-01	WLDMNT, RH ELECTRICAL DOOR	1
342	545619-01	DOOR, CONTROL BOX	1
343	191223	HINGE, CONCEALED REMOVABLE	2
344	190689-1	DOOR LATCH	2
345	547236-01	ASSY, AIR MANIFOLD	1
346	543970-02	BLOCK, AIR MANIFOLD	1
347	191298	FITTING, STRAIGHT 3/8 T 1/4 NPT	2
348	191296	FITTING, STRAIGHT 1/4 T 1/8 NPT	4
349	191296	FITTING, STRAIGHT 1/4 T 1/8 NPT	1
350	191381	ELBOW, FEMALE 1/4 TUBE	1
351	547239-01	BRACKET, PHOENIX CONNECTOR	1
352	200491-2	CONNECTOR, PHOENIX	6

353	106811	.	SCREW, BUTTON HEAD #10-32X.250	4
354	190795	.	LABEL, 220 VOLTS	1
355	190788	.	LABEL, VOLTAGE WARNING LARGE	2
356	547239-02	.	BLOCKOFF, PHOENIX CONNECTOR	1
357	109134-1	.	BELT, HTD 2400-8M-20	1
358	545800-01	.	ASSY, INFEED CONVEYOR/FRAME	1
359	543980-01	.	ASSY, PRODUCT CATCH FINGER	1
360	543981-01	.	PLATE, FINGER MOUNT	2
361	543982-01	.	PLATE, FINGER MOUNT END	1
362	543983-01	.	PLATE, FINGER SHAFT MOUNT	1
363	543984-01	.	SHAFT, FINGER SLIDE	2
364	543985-01	.	ASSY, INFEED FINGER	1
365	543987-01	.	BLOCK, FINGER SLIDE	4
366	547532-01	.	BUSHING, .625ID 1.125OD CROWNED	4
367	543988-01	.	PLATE, INFEED FINGER MOUNT	1
368	543989-01	.	ASSY, PRODUCT CATCH FINGER	10
369	543990-01	.	FINGER, PRODUCT CATCH	1
370	543991-01	.	STUD, FINGER MOUNT	1
371	105221	.	PIN, ROLL .094X.500	2
372	543998-01	.	STUD, FORK END	1
373	545623-01	.	BAR, FINGER SLIDE MOUNT	2
374	545630-01	.	PLATE, FINGER BELT CLAMP	2
375	545631-01	.	PLATE, FINGER BELT CLAMP	2
376	107500	.	SCREW, FLATHEAD 10-32X.500	8
377	107428	.	SCREW, SHCS 1/4-20X.625	16
378	100603	.	WASHER, FLAT 1/4ID	8
379	545735-01	.	BRACKET, FINGER MOUNT BAR	2
380	545737-01	.	BRACKET, PROX TRIGGER	1
381	CSDD236	.	SCREW, SHCS 8-32X.250	2
382	107403	.	SCREW, SHCS 1/4-20X.375	8
383	543986-01	.	ASSY, OUTFEED FINGER	1
384	543987-01	.	BLOCK, FINGER SLIDE	4
385	547532-01	.	BUSHING, .625ID 1.125OD CROWNED	4
386	543988-02	.	PLATE, INFEED FINGER MOUNT	1
387	543989-01	.	ASSY, PRODUCT CATCH FINGER	11
388	543990-01	.	FINGER, PRODUCT CATCH	1
389	543991-01	.	STUD, FINGER MOUNT	1
390	105221	.	PIN, ROLL .094X.500	2
391	543998-01	.	STUD, FORK END	1
392	545623-01	.	BAR, FINGER SLIDE MOUNT	2
393	545629-01	.	BLOCK, AIR CYLINDER FINGER	1
394	545630-01	.	PLATE, FINGER BELT CLAMP	3
395	545631-01	.	PLATE, FINGER BELT CLAMP	3
396	107401	.	SCREW, SHCS 1/4-20X.750	4
397	100603	.	WASHER, FLAT 1/4ID	12
398	107500	.	SCREW, FLATHEAD 10-32X.500	12
399	107428	.	SCREW, SHCS 1/4-20X.625	16
400	545735-01	.	BRACKET, FINGER MOUNT BAR	2
401	107403	.	SCREW, SHCS 1/4-20X.375	8
402	107410	.	SCREW, SHCS 1/4-20X.500	3
403	106811	.	SCREW, BUTTON HEAD #10-32X.250	6
404	545628-01	.	PLATE, AIR CYLINDER MOUNT	2
405	191294	.	CYLINDER, AIR 1.25 D 10IN STROKE	1

406	103804	BEARING, HUB .625	2
407	545624-01	SHAFT, FINGER DRIVE	1
408	109732	PULLEY, TIMING 228M20 .625B .188KEY	2
409	545625-01	ASSY, BELT TAKEUP	2
410	545626-01	PLATE, BELT IDLER MOUNT	1
411	545627-01	SHAFT, PULLEY IDLER	1
412	109733	PULLEY, TIMING 228M20 1.5738 BORE	1
413	103804	BEARING, HUB .625	1
414	103110	BEARING, FLAT .625	1
415	109141	BELT, HTD 20008M20	2
416	547213-01	ASSY, FINGER VALVE	1
417	191342	VALVE, THREE POSITION CLOSED CENTER	1
418	191340	MUFFLER, 1/8 NPT AIR	2
419	191337	FITTING, ELBOW 1/8 NPT 1/4 TUBE	1
420	191339	FITTING, 1/8 NPT 1/4 TUBE ELBOW SP	1
421	191395	FITTING, FLOW CONTROL METER OUT	1
422	545632-01	ASSY, STACKER FLAT BELT	1
423	545738-01	ASSY, BELT DRIVE FRAME	1
424	545633-01	PLATE, STACKER BELT SIDE	1
425	545633-02	PLATE, STACKER BELT SIDE	1
426	545634-02	SHAFT, FLAT BELT DRIVE	1
427	545634-01	SHAFT, FLAT BELT DRIVE	1
428	103808	BEARING, HUB 1.000	2
429	545636-03	ASSY, CONVEYOR IDLER ROLLER	2
430	545635-03	ROLLER,BELT IDLER	1
431	103808	BEARING, HUB 1.000	2
432	545636-01	ASSY, CONVEYOR DRIVE ROLLER	1
433	545635-01	ROLLER,BELT IDLER	1
434	500330-9	HUB, ROLLER	2
435	545637-01	ASSY, BELT ADJUST	1
436	545638-01	PLATE, BELT ADJUST	2
437	545652-01	BLOCK, BEARING	2
438	545639-01	ROLLER, BELT ADJUST	1
439	545639-02	ROLLER, BELT ADJUST	1
440	103804	BEARING, HUB .625	4
441	543987-02	BLOCK, FINGER SLIDE	1
442	543987-01	BLOCK, FINGER SLIDE	3
443	547532-01	BUSHING, .625ID 1.125OD CROWNED	4
444	543987-03	BLOCK, FINGER SLIDE	1
445	543987-04	BLOCK, FINGER SLIDE	1
446	100604	WASHER, FLAT 1/4ID BRASS	1
447	103104	BEARING, FLAT .250	2
448	106818	SCREW, BUTTON HEAD 1/4X.500	2
449	545643-01	PLATE, SIDEGUIDE JOGGER	1
450	545644-01	PLATE, SIDE GUIDE MOUNT	2
451	545645-01	PLATE, SIDEGUIDE MOUNT	1
452	545650-01	GUIDE, FRONT SIDE	9
453	545651-01	BAR, UPPER BELT ADJUST SPACER	2
454	107425	SCREW, SHCS 1/4-20X1.750	4
455	107411	SCREW, SHCS 1/4-20X.875	12
456	107407	SCREW, SHCS 1/4-20X1.000	4
457	545656-01	PLATE, RACK GEAR MOUNT	2
458	545662-01	GEAR, SIDEGUIDE ADJUST RACK	2

459	107447	.	SCREW, SHCS 1/4-20X2.000	2
460	545665-01	.	TOP, HORIZ. TABLETOP	1
461	107430	.	SCREW, SHCS 10-32X.750	8
462	106811	.	SCREW, BUTTON HEAD #10-32X.250	6
463	545683-01	.	SPACER, TABLETOP	3
464	545727-01	.	ASSY, PRODUCT DISHING	1
465	545728-01	.	PLATE, DISHING MOUNT	2
466	545729-01	.	SHAFT, DISHING MOUNT	1
467	545731-01	.	ARM, DISHING ADJUSTMENT	1
468	545732-01	.	SHAFT, ARM PIVOT	1
469	545733-01	.	ARM, BEARING MOUNT SKID	2
470	103105	.	BEARING, FLAT .250 ID .750 OD	6
471	545734-01	.	SHAFT, DISHING ADJUST	1
472	102112	.	KNOB	1
473	107633	.	SCREW, SET 1/4-20X.250	2
474	106800	.	SCREW, BUTTON HEAD 1/4X.750	6
475	100603	.	WASHER, FLAT 1/4ID	6
476	100135	.	BUSHING, SL.500ID.625OD.500LG	1
477	100162	.	BUSHING, SL.500ID.625OD.625LG	2
478	104106	.	SNAPRING, .500	4
479	100604	.	WASHER, FLAT 1/4ID BRASS	2
480	107410	.	SCREW, SHCS 1/4-20X.500	1
481	106734	.	1/4 20 LOCK NUT WITH NYLON INSE	1
482	106801	.	SCREW, BUTTON HEAD 1/4X.875	1
483	107521	.	SCREW, FLATHEAD 10-32X.250	6
484	107546	.	SCREW, FLHD UNDERCUT 10-32X.250	18
485	545736-01	.	BRACKET, PROX MOUNT	1
486	201055-1	.	PROXIMITY	1
487	CSFF63	.	SCREW, BUTTON HEAD 1/4X.250	4
488	545740-01	.	INDICATOR, SIDEGUIDE	1
489	547208-01	.	ASSY, BEAM SWITCH MOUNT	1
490	547209-01	.	POST, BEAM SWITCH MOUNT	1
491	547210-01	.	SHAFT, BEAM SWITCH MOUNT	1
492	545201-02	.	PLATE, BEAM SWITCH MOUNT	1
493	543401-04	.	GUARD, BEAM SWITCH	1
494	202261-5	.	BEAMSWITCH, RETROREFLECTIVE	1
495	107401	.	SCREW, SHCS 1/4-20X.750	2
496	547226-01	.	BRACKET, SIDEGUIDE JOGGER	1
497	547233-01	.	BLOCK, GUIDE PIVOT	2
498	547234-01	.	BLOCK, GUIDE PIVOT	2
499	100132	.	BUSHING, SL.250ID.375OD.500LG	2
500	107000	.	BOLT, SHOULDER 1/4X1/2	2
501	107429	.	SCREW, SHCS 10-32X.625	4
502	107406	.	SCREW, SHCS 10-32X1.250	4
503	106736	.	NUT, HEX #10-32	2
504	100314	.	BUSHING, FL.313ID.438OD.250LG	1
505	107101	.	BOLT, SHOULDER 5/16X3/8	1
506	545683-02	.	SPACER, TABLETOP	1
507	106720	.	NUT, HEX 1/4-20	1
508	545640-02	.	PLATE, BELT ADJUST SHAFT MOUNT	4
509	545641-01	.	SHAFT, BELT ADJUST MOUNT	2
510	109330	.	PULLEY, TIMING 15L05 .750B .188K	1
511	108820	.	PULLEY, TIMING 16L075 .750B .188K	1

512	107407	SCREW, SHCS 1/4-20X1.000	4
513	545640-03	PLATE, BELT ADJUST SHAFT MOUNT	4
514	545634-03	SHAFT, FLAT BELT DRIVE	1
515	107448	SCREW, SHCS 5/16-18X2.25	2
516	545653-01	ASSY, BACK SIDE GUIDE	1
517	545654-01	PLATE, BACK SIDE GUIDE SIDE	1
518	545654-02	PLATE, BACK SIDE GUIDE SIDE	1
519	545640-02	PLATE, BELT ADJUST SHAFT MOUNT	2
520	547215-01	ASSY, SIDEGUIDE ADJUST SHAFT	1
521	545661-01	SHAFT, SIDE GUIDE ADJUST	1
522	545698-02	SHAFT, ARM LOCK	1
523	103803	BEARING, HUB .500	2
524	102401	GEAR, 1616 .500B .125K	2
525	545640-03	PLATE, BELT ADJUST SHAFT MOUNT	2
526	545741-01	SPACER, FRAME	2
527	543969-01	RULE, FLAT SIDEGUIDE PLACEMENT	1
528	545742-01	PLATE, SIDEGUIDE ADJUST CLAMP	1
529	102140	HANDLE, RELEASE 1/4-20 X 1.0	1
530	102112	KNOB	1
531	545657-01	ASSY, BACK SIDE GUIDE SLIDE	1
532	545658-01	PLATE, BACK SIDE GUIDE	1
533	545659-01	PLATE, VERTICAL SIDE GUIDE	2
534	543987-01	BLOCK, FINGER SLIDE	4
535	547532-01	BUSHING, .625ID 1.125OD CROWNED	4
536	545650-02	GUIDE, FRONT SIDE	10
537	545662-01	GEAR, SIDEGUIDE ADJUCT RACK	2
538	545663-01	BLOCK, RACK MOUNT	2
539	545664-01	BRACKET, RACK MOUNT	2
540	107428	SCREW, SHCS 1/4-20X.625	2
541	106811	SCREW, BUTTON HEAD #10-32X.250	4
542	107410	SCREW, SHCS 1/4-20X.500	10
543	545667-01	SHAFT, RACK GEAR SPACER	1
544	CSDD212	SCREW, SHCS 6-32X.750	8
545	106711	NUT, HEX #6-32	6
546	107546	SCREW, FLHD UNDERCUT 10-32X.250	20
547	545666-01	ASSY, INFEED BELT RAMP	1
548	545668-01	PLATE, INFEED RAMP BEARING	2
549	545669-02	TABLETOP, INFEED RAMP	1
550	545670-01	PLATE, HUB BEARING	2
551	545671-01	SHAFT, INFEED ROLLER	1
552	103804	BEARING, HUB .625	2
553	534814-07	ASSY, VALVE CYLINDER PLATE	1
554	190803-1	CYLINDER, AVB1 X 1B W/SHOCK PADS	1
555	508175	CLEVIS, AIR CYLINDER	1
556	508055	LINK, GATE	1
557	103500	BEARING - ROD END	1
558	202708	VALVE, THREE WAY AIR	1
559	105633	SHAFT, THREADED 3/8-24 X 2.375	1
560	191337	FITTING, ELBOW 1/8 NPT 1/4 TUBE	5
561	541779-02	ARM, REJECT CYLINDER	1
562	532226-02	ARM, REJECT CYLINDER	1
563	103106	BEARING, FLAT .375	4
564	545672-01	GUIDE, INFEED DIVERT	1

565	545704-01	ASSY, UPPER BELT	1
566	545685-02	PLATE, UPPER BELT SUPPORT	2
567	545705-01	SHAFT, UPPER BELT DRIVE	1
568	545689-02	SHAFT, UPPER ARM ADJUST	1
569	547766-02	ASSY, UPPER BELT	1
570	547762-03	PLATE, BEARING MNT	1
571	547764-02	BRACKET, ROLLER ARM	2
572	547763-01	BLOCK, ROLLER STUD MOUNT	1
573	545694-01	SHAFT, UPPER ROLLER IDLER	1
574	547762-02	PLATE, BEARING MNT	1
575	545675-01	ROLLER, DIVERT	2
576	103112	BEARING, FLAT .750	2
577	103805	BEARING, HUB .750	4
578	547765-01	SPACER, ROLLER ARM	1
579	107409	SCREW, SHCS 10-32X.500	8
580	107410	SCREW, SHCS 1/4-20X.500	8
581	547539-01	HANDLE, INFEED ROLLER RELEASE	1
582	106818	SCREW, BUTTON HEAD 1/4X.500	2
583	545690-01	ARM, UPPER BELT AJUST	1
584	100170	BUSHING, SL.750ID.875OD.625LG	1
585	545691-01	SHAFT, ARM PIVOT	1
586	100129	BUSHING, SL.375ID.500OD.500LG	1
587	545692-02	SHAFT, VERTICAL ARM	1
588	103500	BEARING - ROD END	1
589	HMSN14	NUT, HEX 3/8-16	1
590	545693-02	ARM, UPPER BELT AJUST	1
591	545675-03	ROLLER, DIVERT	2
592	100149	BUSHING, SL.750ID.875OD.500LG	1
593	102207	COLLAR .750	1
594	545698-01	SHAFT, ARM LOCK	1
595	102112	KNOB	1
596	103805	BEARING, HUB .750	2
597	103112	BEARING, FLAT .750	2
598	104103	SNAPRING, .750	2
599	104100	SNAPRING, .375	1
600	107407	SCREW, SHCS 1/4-20X1.000	4
601	547204-01	ASSY, OUTFEED CONVEYOR COVER	1
602	547206-01	FRAME, OUTFEED CONVEYOR COVER	2
603	547205-01	TOP, INFEED BELT COVER	1
604	190758	MOUNTING BLOCK	4
605	190785	LABEL, ROLLER VERT WARNING	1
606	190782	LABEL, LOOSE CLOTHES	1
607	202261-5	BEAMSWITCH, RETROREFLECTIVE	1
608	543401-03	GUARD, BEAM SWITCH	1
609	547207-01	BRACKET, INFID BELT COVER MNT	2
610	102119	KNOB	4
611	SP6383-1	SPACER, GEAR COVER	4
612	100357	BUSHING, FL.750ID.875OD.625G	1
613	107448	SCREW, SHCS 5/16-18X2.25	1
614	100602	WASHER, FLAT 5/16ID	3
615	102962	SPRING, COMPRESSION	1
616	547778-01	WASHER, 7 GA 3/8 ID 3/4 OD	4
617	545746-02	SPACER, FRAME	1

618	545673-01	ASSY, BELT TAKE UP	1
619	545674-02	ASSY, ROLLER	4
620	545675-02	ROLLER, DIVERT	1
621	103805	BEARING, HUB .750	1
622	103112	BEARING, FLAT .750	1
623	545746-03	SPACER, FRAME	1
624	545677-01	ARM, SPRING MOUNT	2
625	545678-01	ASSY, TAKEUP 1 IN BELT	4
626	545679-01	ARM, BELT TIGHTENER	1
627	545680-01	SHAFT, BELT TIGHTENER	1
628	WA013	WASHER, FLAT 3/8	7
629	104100	SNAPRING, .375	1
630	100141	BUSHING, SL.750ID1.000OD.750LG	1
631	107407	SCREW, SHCS 1/4-20X1.000	1
632	102607	SPRING, EXTENSION	1
633	106720	NUT, HEX 1/4-20	1
634	510611A	ASSY-ROLLER	1
635	510611	ROLLER, IDLER	1
636	103106	BEARING, FLAT .375	2
637	545681-01	SHAFT, SPRING MOUNT	1
638	102207	COLLAR .750	4
639	545682-01	BRACKET, SPRING ANCHOR	4
640	545794-01	WLDMNT, AIR CYLINDER COVER	1
641	545795-01	COVER, REJECT AIR CYLINDER	1
642	545796-01	COVER, REJECT AIR CYLINDER	1
643	107410	SCREW, SHCS 1/4-20X.500	4
644	545797-01	SPACER, BEARING PLATE	3
645	190955	HANDLE	1
646	547211-01	SPACER, CONVEYOR SUPPORT	1
647	107332	BOLT, HEX HEAD 3/8-16X2.00	1
648	107307	BOLT, HEX HEAD 3/8-16X1.25	1
649	107427	SCREW, SHCS 5/16-18X.500	6
650	547223-01	BRACKET, INFEED RAMP SUPP	1
651	547223-02	BRACKET, INFEED RAMP SUPP	1
652	100326	BUSHING, FL1.000ID1.250OD.750LG	2
653	102217	COLLAR 1.000	2
654	547533-01	KIT, STATIC BAR	1
655	547534-01	BRACKET, STATIC BAR	2
656	508049-9	BAR, UPPER STATIC SUPPORT	4
657	547534-02	BRACKET, STATIC BAR	2
658	547536-01	BRACKET, TABLETOP MOUNT	4
659	547535-01	TABLETOP, STATIC BAR FILLER	1
660	106818	SCREW, BUTTON HEAD 1/4X.500	8
661	CSFF63	SCREW, BUTTON HEAD 1/4X.250	2
662	111873	BELT, FLAT 133.25 X 1.000	4
663	545684-01	ASSY, UPPER BELT	1
664	545685-03	PLATE, UPPER BELT SUPPORT	1
665	545685-01	PLATE, UPPER BELT SUPPORT	1
666	100357	BUSHING, FL.750ID.875OD.625G	1
667	545686-01	SHAFT, UPPER BELT DRIVE	1
668	109330	PULLEY, TIMING 15L05 .750B .188K	1
669	545689-01	SHAFT, UPPER ARM ADJUST	1
670	547766-01	ASSY, UPPER BELT	1

671	547762-01	PLATE, BEARING MNT	2
672	547764-01	BRACKET, ROLLER ARM	2
673	547763-01	BLOCK, ROLLER STUD MOUNT	1
674	545694-01	SHAFT, UPPER ROLLER IDLER	1
675	545675-01	ROLLER, DIVERT	2
676	103112	BEARING, FLAT .750	2
677	103805	BEARING, HUB .750	2
678	103808	BEARING, HUB 1.000	2
679	547765-01	SPACER, ROLLER ARM	2
680	107409	SCREW, SHCS 10-32X.500	8
681	107410	SCREW, SHCS 1/4-20X.500	10
682	545690-01	ARM, UPPER BELT AJUST	1
683	100170	BUSHING, SL.750ID.875OD.625LG	2
684	545691-01	SHAFT, ARM PIVOT	1
685	100129	BUSHING, SL.375ID.500OD.500LG	1
686	545692-01	SHAFT, VERTICAL ARM	1
687	103500	BEARING - ROD END	1
688	HMSN14	NUT, HEX 3/8-16	1
689	545693-01	ARM, UPPER BELT AJUST	1
690	545695-01	ROLLER, UPPER BELT DRIVE	2
691	545696-01	ASSY, TAKEUP 1 IN BELT	1
692	545697-01	ARM, BELT TIGHTENER	1
693	545680-01	SHAFT, BELT TIGHTENER	1
694	104100	SNAPRING, .375	1
695	510611-1A	ASSY-ROLLER	1
696	510611-1	ROLLER, IDLER	1
697	103106	BEARING, FLAT .375	2
698	547231-01	BRACKET, SPRING ADJUST	1
699	102964	SPRING, EXTENSION	1
700	103808	BEARING, HUB 1.000	1
701	102200	COLLAR .375	1
702	111509	WASHER, FLAT .257ID .515OD .120TH	2
703	107428	SCREW, SHCS 1/4-20X.625	2
704	545696-02	ASSY, TAKEUP 1 IN BELT	1
705	545697-01	ARM, BELT TIGHTENER	1
706	545680-01	SHAFT, BELT TIGHTENER	1
707	104100	SNAPRING, .375	1
708	510611-1A	ASSY-ROLLER	1
709	510611-1	ROLLER, IDLER	1
710	103106	BEARING, FLAT .375	2
711	547231-01	BRACKET, SPRING ADJUST	1
712	102964	SPRING, EXTENSION	1
713	103808	BEARING, HUB 1.000	1
714	102200	COLLAR .375	1
715	111509	WASHER, FLAT .257ID .515OD .120TH	2
716	107428	SCREW, SHCS 1/4-20X.625	2
717	545698-01	SHAFT, ARM LOCK	1
718	102112	KNOB	1
719	545724-01	PLATE, BEARING	1
720	545725-01	SPACER, BEARING PLATE	4
721	103503	BEARING - ROD END	2
722	107103	BOLT, SHOULDER 5/16X5/8	1
723	100602	WASHER, FLAT 5/16ID	5

724	545726-01	ROD, THREADED CRANK	1
725	104103	SNAPRING, .750	2
726	104100	SNAPRING, .375	1
727	107407	SCREW, SHCS 1/4-20X1.000	1
728	107448	SCREW, SHCS 5/16-18X2.25	1
729	545693-03	ARM, UPPER BELT AJUST	1
730	107402	SCREW, SHCS 1/4-20X1.250	1
731	106720	NUT, HEX 1/4-20	2
732	107401	SCREW, SHCS 1/4-20X.750	1
733	102607	SPRING, EXTENSION	1
734	103808	BEARING, HUB 1.000	2
735	102200	COLLAR .375	1
736	102962	SPRING, COMPRESSION	1
737	547778-01	WASHER, 7 GA 3/8 ID 3/4 OD	4
738	108905-12	BELT, TIMING 187L075	1
739	545699-01	ASSY, BELT DIVERT ROLLER	1
740	545700-01	BLOCK, IDLER ROLLER BEARING	2
741	545701-01	ROLLER, DIVERT IDLER	1
742	103808	BEARING, HUB 1.000	2
743	102217	COLLAR 1.000	4
744	111872	BELT, FLAT 138.25 X .75	2
745	545707-01	ASSY, UPPER SIDEGUIDE	1
746	545709-01	PALTE, LH SIDE GUIDE MOUNT	2
747	545710-01	PLATE, SIDEGUIDE BEARING	4
748	545711-01	PLATE, SIDEGUIDE SHAFT MOUNT	2
749	545712-01	SHAFT, SIDEGUIDE MOUNT	2
750	545713-01	SHAFT, PULLEY IDLER	1
751	545714-01	SHAFT, SIDEGUIDE JOGGER	1
752	545715-01	PULLEY, TIMING 288M20 .625B .188KEY	2
753	103804	BEARING, HUB .625	4
754	109138-1	BELT, HTD TIMING 1440-8M-20	1
755	545718-01	ASSY, RH SIDEGUIDE	1
756	543987-01	BLOCK, FINGER SLIDE	4
757	545716-01	PLATE, SIDEGUIDE MOUNT	1
758	547240-01	PLATE, SIDEGUIDE MOUNT	1
759	545631-01	PLATE, FINGER BELT CLAMP	1
760	545717-01	GUIDE, UPPER SIDE	1
761	100283	BUSHING, .625ID 1.125OD	3
762	106811	SCREW, BUTTON HEAD #10-32X.250	4
763	107411	SCREW, SHCS 1/4-20X.875	6
764	107526	SCREW, FLATHEAD 10-32X.625	4
765	545717-05	GUIDE, UPPER SIDE	1
766	545717-09	GUIDE, UPPER SIDE	1
767	545719-01	ASSY, RH SIDEGUIDE	1
768	543987-01	BLOCK, FINGER SLIDE	4
769	545716-01	PLATE, SIDEGUIDE MOUNT	1
770	545631-01	PLATE, FINGER BELT CLAMP	1
771	545717-02	GUIDE, UPPER SIDE	1
772	100283	BUSHING, .625ID 1.125OD	3
773	106811	SCREW, BUTTON HEAD #10-32X.250	4
774	107411	SCREW, SHCS 1/4-20X.875	6
775	107526	SCREW, FLATHEAD 10-32X.625	4
776	545717-06	GUIDE, UPPER SIDE	1

777	547240-01	PLATE, SIDEGUIDE MOUNT	1
778	545717-08	GUIDE, UPPER SIDE	1
779	545722-01	WHEEL, SIDEGUIDE ADJUST	1
780	545723-01	PLATE, SIDEGUIDE CLAMP	1
781	102140	HANDLE, RELEASE 1/4-20 X 1.0	1
782	107103	BOLT, SHOULDER 5/16X5/8	1
783	100400	WASHER, THRUST TW31	4
784	545730-01	HUB, SIDEGUIDE CLAMP	1
785	107428	SCREW, SHCS 1/4-20X.625	4
786	545743-01	WHEEL, SIDEGUIDE ADJUST	1
787	106800	SCREW, BUTTON HEAD 1/4X.750	4
788	545744-01	RULE, FLAT SIDEGUIDE PLACEMENT	1
789	545745-01	INDICATOR, SIDEGUIDE	1
790	106811	SCREW, BUTTON HEAD #10-32X.250	2
791	104104	SNAPRING, .625	4
792	543995-01	GUIDE, UPPER BELT ADJUSTMENT	1
793	538022-06	ASSY, MOTOR MOUNT	1
794	545746-01	SPACER, FRAME	1
795	530654-03	ASSY, MOTOR MTG BAR	1
796	530510-03	BAR, MOTOR MOUNT PIVOT	2
797	530511-01	SPACER, 3/4OD X 2L	2
798	100331	BUSHING, FL1.000ID1.250OD1.250LG	2
799	200151-2	MOTOR, LEESON DC 1 HP	1
800	108809	PULLEY, TIMING 12L075 .625B .188K	1
801	102217	COLLAR 1.000	2
802	545747-01	SPACER, MOTOR MOUNT	1
803	108952-17	BELT, TIMING 225L075	1
804	545750-01	ASSY, INFEED LIFT	1
805	545751-01	WLDMT, TUBING CLAMP	1
806	545752-01	TUBING, VERTICAL CLAMP	1
807	532129-01	BLOCK, LOCK DOWN	1
808	545753-01	TUBING, VERTICAL BUMPTURN	1
809	190841	BLOCK, CYLINDER MOUNT	2
810	190823-1	GAS SPRING, 100LB GAS-175	1
811	105601-1	SHAFT, THREADED 3/8-16	1
812	102112	KNOB	1
813	100326	BUSHING, FL1.000ID1.250OD.750LG	4
814	102217	COLLAR 1.000	2
815	107447	SCREW, SHCS 1/4-20X2.000	1
816	106720	NUT, HEX 1/4-20	2
817	102206	COLLAR .250	4
818	107443	SCREW, SHCS 1/4-20X2.250	1
819	545748-01	ASSY, SIDE FRAME	1
820	545749-01	FRAME, RH SIDE	1
821	545749-02	FRAME, LH SIDE	1
822	545764-01	COVER, OUTFEED FRAME	1
823	545765-01	COVER, INFEED FRAME	1
824	545766-01	BAR, FRAME SPACER	10
825	545767-01	COVER, FRAME END	1
826	545768-01	COVER, OUTFEED TOP LEXAN	1
827	545769-01	COVER, TOP LEXAN	1
828	545774-01	BAR, INFEED DOOR MOUNT	1
829	545770-01	COVER, FRONT LEXAN	1

830	545771-01	WLDMT, COVER TIMING BELT	2
831	545772-01	COVER, TIMING BELT	1
832	545773-01	STRIP, COVER TIMING BELT	1
833	545775-01	SPACER, COVER MOUNT	4
834	545776-01	BAR, FRAME MOUNT	4
835	545782-01	ASSY, LEXAN DOOR	2
836	545779-01	ASSY, DOOR HINGE	2
837	545780-01	BLOCK, DOOR HINGE MOUNT	1
838	190967	HAND PLUNGER, 3/8-16X1.13	1
839	HMSN14	NUT, HEX 3/8-16	1
840	545781-01	BRACKET, DOOR HINGE MOUNT	1
841	190769	MAGNET, BUNTING	1
842	545778-01	COVER, LOWER SIDE LEXAN	1
843	545783-01	PLATE, DOOR HANDLE MOUNT	1
844	190955	HANDLE	1
845	190769	MAGNET, BUNTING	2
846	106810	SCREW, BUTTON HEAD #10-32X.500	6
847	CSFF54	SCREW, BUTTON HEAD #8-32X.625	2
848	545790-01	BLOCK, DOOR KEEPER	2
849	545789-01	ASSY, SIDE COVER DOOR	1
850	545777-01	COVER, UPPER SIDE LEXAN	1
851	545779-01	ASSY, DOOR HINGE	2
852	545780-01	BLOCK, DOOR HINGE MOUNT	1
853	190967	HAND PLUNGER, 3/8-16X1.13	1
854	HMSN14	NUT, HEX 3/8-16	1
855	545781-01	BRACKET, DOOR HINGE MOUNT	1
856	190769	MAGNET, BUNTING	1
857	545783-01	PLATE, DOOR HANDLE MOUNT	1
858	190955	HANDLE	1
859	190769	MAGNET, BUNTING	2
860	545790-01	BLOCK, DOOR KEEPER	2
861	545789-03	ASSY, SIDE COVER DOOR	1
862	545777-01	COVER, UPPER SIDE LEXAN	1
863	545779-01	ASSY, DOOR HINGE	2
864	545780-01	BLOCK, DOOR HINGE MOUNT	1
865	190967	HAND PLUNGER, 3/8-16X1.13	1
866	HMSN14	NUT, HEX 3/8-16	1
867	545781-01	BRACKET, DOOR HINGE MOUNT	1
868	190769	MAGNET, BUNTING	1
869	545783-01	PLATE, DOOR HANDLE MOUNT	1
870	190955	HANDLE	1
871	190769	MAGNET, BUNTING	2
872	545790-01	BLOCK, DOOR KEEPER	2
873	190955	HANDLE	2
874	545791-01	BAR, MAGNET MOUNT	2
875	190769	MAGNET, BUNTING	2
876	545792-01	BRACKET, DOOR STOP	2
877	100247	BUSHING, SL.250ID.375OD.625LG	6
878	107407	SCREW, SHCS 1/4-20X1.000	6
879	106720	NUT, HEX 1/4-20	6
880	201125-5	BUTTON, POWER OFF	1
881	201126-1	BUTTON, JOG	2
882	201124-2	BUTTON, START	1

883	201125-3	BUTTON, STOP	1
884	201164	PLATE, YELLOW POWER OFF LABEL	1
885	201169	PLATE, CUSTOM LABEL	4
886	545798-01	BOX, BUTTON	1
887	547186-01	ASSY, KR950 LOGO	2
888	547184-01	LOGO, KR950	1
889	547185-01	PLATE, KR950 LOGO BACKING	1
890	547217-01	BAR, TOP MOUNT	2
891	547217-02	BAR, TOP MOUNT	2
892	547227-01	BRACKET, SAFETY SWITCH MNT	1
893	547237-01	TRAY, TOOL	2
894	545765-02	COVER, INFEED FRAME	1
895	547236-02	ASSY, AIR BLOW DOWN	1
896	543970-03	BLOCK, AIR MANIFOLD	1
897	191337	FITTING, ELBOW 1/8 NPT 1/4 TUBE	1
898	191349	VALVE, 1/4 NPT MALE	2
899	191350	HOSE, 1/4 ID 13"LNG	2
900	547461-01	ASSY, STACK LIGHT	1
901	202284-8	LIGHT, THREE BULB	1
902	547462-01	BRACKET, STACK LIGHT MNT	1
903	190785	LABEL, ROLLER VERT WARNING	4
904	190784	LABEL, STAMPING WARNING	2
905	190782	LABEL, LOOSE CLOTHES	2
906	CSFF55	SCREW, BUTTON HEAD #8-32X.750	2
907	190619-1	PLATE, NAME	1
908	547779-01	BRACKET, SPRING MOUNT	1
909	545754-01	ASSY, OUTFEED CONVEYOR	1
910	545755-01	TABLETOP, OUTFEED CONVEYOR	1
911	545756-01	PLATE, OUTFEED CONVEYOR	1
912	545756-02	PLATE, OUTFEED CONVEYOR	1
913	103405	CAM FOLLOWER	3
914	545757-01	ROLLER, FLAT BELT	1
915	107206	BOLT, SHOULDER 3/8X1/2	4
916	545757-02	ROLLER, FLAT BELT	1
917	545636-02	ASSY, CONVEYOR DRIVE ROLLER	1
918	545635-02	ROLLER,BELT IDLER	1
919	500330-4	HUB, ROLLER	2
920	103804	BEARING, HUB .625	6
921	545759-01	ROLLER, FLAT BELT	2
922	545760-01	SHAFT, FLAT BELT DRIVE	1
923	111871	BELT, FLAT 52.000 X 1.5	4
924	102201	COLLAR .625	16
925	200169-3	MOTOR, BODINE 4179	1
926	108871	PULLEY, TIMING 14L075 .750B .188K	1
927	109968	PULLEY, TIMING 14L075 .625B .188K	1
928	108914-17	BELT, TIMING 124L075	1
929	545761-01	SHAFT, MOTOR MOUNT SPACER	3
930	545762-01	SHAFT, CONVEYOR SPACER	3
931	545763-01	COVER, CONVEYOR BOTTOM	1
932	106811	SCREW, BUTTON HEAD #10-32X.250	8
933	100401	WASHER, THRUST TB410	3
934	107411	SCREW, SHCS 1/4-20X.875	7
935	545786-02	ASSY, OUTFEED CONVEYOR COVER	1

936	547531-01	WLDMMNT, OUTFEED CONV. COVER	1
937	545785-02	COVER, TUNNEL OUTFEED	1
938	547530-01	END, TUNNEL COVER	1
939	547530-02	END, TUNNEL COVER	1
940	190955	HANDLE	2
941	545784-02	FRAME, OUTFEED CONVEYOR COVER	2
942	545785-03	COVER, OUTFEED CONV. TOP	1
943	106818	SCREW, BUTTON HEAD 1/4X.500	24
944	100603	WASHER, FLAT 1/4ID	6
945	545787-01	SPACER, COVER MOUNT	4
946	545788-01	HANDLE, COVER MOUNT	2
947	106815	SCREW, BUTTON HEAD 1/4X.625	4
948	102119	KNOB	2
949	102200	COLLAR .375	4
950	200513-5	GROMMET, RUBBER .75IDX1.375ODX.56TH	1
951	547457-01	PLATE, OUTFEED ROLLER TAKEUP	2
952	547458-01	BLOCK, OUTFEED TAKEUP	2
953	107407	SCREW, SHCS 1/4-20X1.000	2
954	547519-01	ASSY, OUTFEED BELT ADJUST	1
955	547520-01	PLATE, OUTFEED ADJUST MOUNT	2
956	547521-01	PLATE, ROLLER MOUNT	2
957	547457-01	PLATE, OUTFEED ROLLER TAKEUP	2
958	545757-03	ROLLER, FLAT BELT	1
959	103405	CAM FOLLOWER	4
960	103804	BEARING, HUB .625	6
961	545759-01	ROLLER, FLAT BELT	2
962	545757-02	ROLLER, FLAT BELT	1
963	547522-01	RACK, ROLLER ADJUST	2
964	107102	BOLT, SHOULDER 5/16X1/2	4
965	101913	GEAR, 1620 .625B .188K	2
966	100401	WASHER, THRUST TB410	2
967	102140	HANDLE, RELEASE 1/4-20 X 1.0	2
968	547523-01	SHAFT, AUTOLOADER ADJUSTMENT	1
969	533006-01	HANDWHEEL	1
970	107404	SCREW, SHCS 1/4-20X1.500	2
971	107401	SCREW, SHCS 1/4-20X.750	4
972	547526-01	BAR, FRAME SPACER	2
973	547525-01	TOP, ROLLER ADJUST TABLE	1
974	107411	SCREW, SHCS 1/4-20X.875	4
975	547527-01	SPACER, TABLETOP	6
976	107429	SCREW, SHCS 10-32X.625	8
977	107409	SCREW, SHCS 10-32X.500	4
978	547528-01	PLATE, BELT ADJUST SPLIC	2
979	106811	SCREW, BUTTON HEAD #10-32X.250	4
980	107521	SCREW, FLATHEAD 10-32X.250	6
981	107410	SCREW, SHCS 1/4-20X.500	12
982	547529-01	COVER, CONVEYOR BOTTOM	1
983	111895	BELT, FLAT 70.750 X 1.500	4

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

For Service or Replacement Parts Please Call:

Your local Kirk-Rudy dealer or
Kirk-Rudy @ 770-427-4203

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