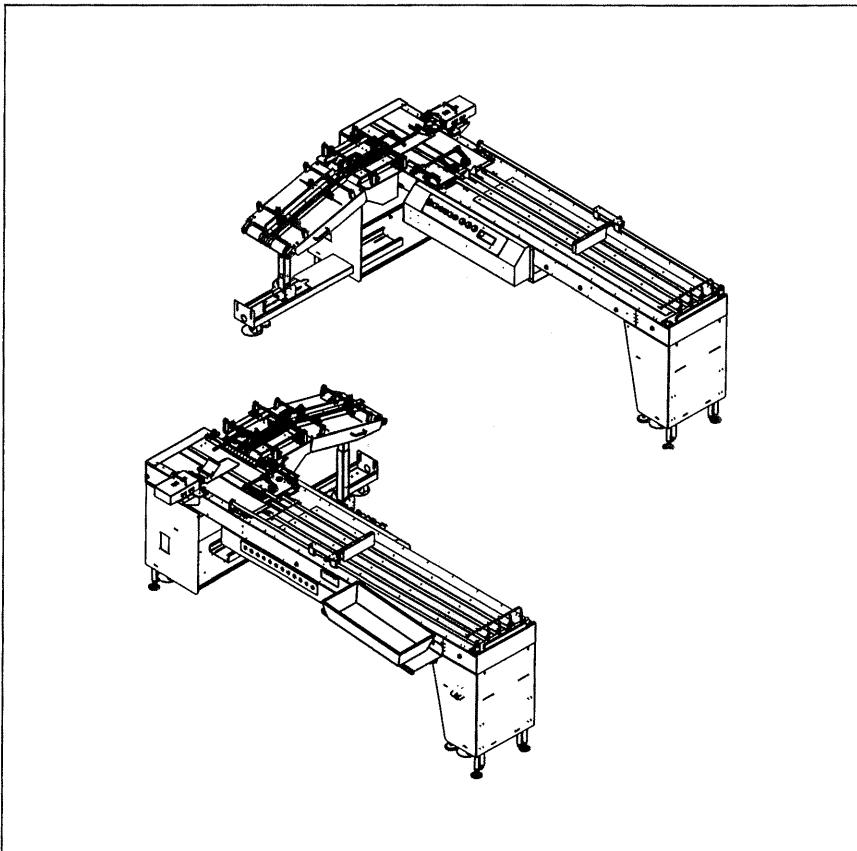


Kirk-Rudy Inc.

SA341-1 Instruction and Parts Manual

KR345 Edge 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.

10000-SA341-1 REV. 3 6/6/2006

SA341-1
Instruction
and Parts Manual
KR345 Edge Stacker

TABLE OF CONTENTS

<u>SECTION</u>	<u>DESCRIPTION</u>	<u>PAGE</u>
1	IMPORTANT SAFETY INSTRUCTIONS	3
2	SPECIFICATIONS	4
3	INSTALLATION	
	3.1 UNCRATING AND UNPACKING	5
	3.2 CABLE AND CORD CONNECTIONS	5
4	MACHINE DESCRIPTION	
	4.1 MECHANICAL COMPONENT DESCRIPTION	5
	4.1.1 INFEED CONVEYOR	
	4.1.2 CROSS FEED CONVEYOR	
	4.1.3 OUTFEED CONVEYOR	6
	4.2 ELECTRICAL COMPONENT DESCRIPTION	
	4.2.1 CONTROL PANEL	6
	4.2.2 ELECTRICAL CONNECTIONS TO BASE	7
	4.2.3 MACHINE SENSORS	7
	4.3 USER INTERFACE	
	4.3.1 SYSTEM OVERVIEW	7
	4.3.2 PUSH BUTTONS	7-8
	4.3.3 SCREENS	8-11
	4.3.4 IO TABLE	11
5	OPERATING INSTRUCTIONS	
	5.1 SYSTEM OVERVIEW	12
	5.2 SYSTEM SETUP	12
	5.3 INFEED CONVYOR	12
	5.4 CROSSFEED CONVEYOR	12-13
	5.5 OUTFEED CONVEYOR	13
	5.6 SYSTEM OPERATION	13
	5.7 TROUBLE SHOOTING	14
6	MAINTENANCE	
	6.1 INFEED CONVEYOR	15
	6.2 CROSSFEED CONVEYOR	15
	6.3 OUTFEED CONVEYOR	15
7	PARTS LIST AND DIAGRAMS	16
8	ELECTRICAL SCHEMATICS AND PARTS	
	8.1 WIRING DIAGRAMS LIST	17
	8.2 PARTS LIST	17-18
9	APPENDIX	19
10	NOTES	20
11	WARRANTY AND SERVICE INFORMATION	Inside Back Cover

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

1.0 Important Safety Instructions

Intended Use Statement: The SA341-1 KR345 is a belted conveyor transport designed to shingle or shingle and edge stack paper and plastic products. The system is made up of three major sections - the infeed, crossfeed and outfeed sections. Product enters the infeed section and is sped up, aligned and diverted onto the crossfeed section. Product is shingled and sorted on the crossfeed conveyor. The outfeed section is used for shingling or edge stacking the material. Product is slid off the outfeed conveyor directly into a mail tray. 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 MISFEED 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 A LICENSED ELECTRICIAN WHEN TROUBLE-SHOOTING ELECTRICAL PROBLEMS.
- * CHANGES OR MODIFICATIONS TO THIS UNIT NOT EXPRESSLY APPROVED BY THE PARTY RESPONSIBLE FOR COMPLIANCE COULD VOID THE USER'S AUTHORITY TO OPERATE THE EQUIPMENT.

2.0 SPECIFICATIONS

Physical

Length	9'
Height	42"
Width	38"
Infeed height	33.2" (can vary with optional infeed conveyor)
Conveyor exit direction	Specify left or right

Electrical Requirements

Voltage	120 VAC
Current	15 amps
Phase	single
Hertz	60

Production Rate

Infeed Belt speed	400 ft/min
Outfeed Belt speed	95 ft/min
Stacks/minute	55/min

***Material Handling**

Min stock size-Edge stacking	3" x 5" card stock or envelope
Max stock size-Edge stacking	6" x 12" and 6" x 12" card stock or envelope
Min stock size-shingle only	3" x 5"
Max stock size-shingle only	9" x 13"
Minimum stock thickness-shingle only	copy paper
Maximum stock thickness	3/16"

Features

- High speed infeed table
- Semi-automatic startup
- Standard inkjet interface
- Shingle only mode
- Batch counter mode
- Mail tray shelf

Options

- Hydraulic lift kit
- Left or right outfeed conveyor
- Stack mark reader
- *Incline infeed conveyor extension

***Note: With optional infeed extension product width is limited to 9.75". Product thickness may be limited dependent on conveyor incline angle.**

3.0 INSTALLATION



WARNING

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

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

3.1 Uncrating and Unpacking

Position crates near installation site.

1. Remove crate top and sides.
2. Remove metal strapping and securing blocks.
3. Locate accessories box and use checklist to verify all items were shipped.
4. Use a forklift to lift machine off skid. Be sure to position the forks in a central location.
5. Machine is on casters and can be rolled inline with feeder base.
6. Adjust height using the leveling legs or the optional hydraulic lift kit handle.

3.2 Cable and Cord Connections

1. A Turk connector is available for connecting to the stop circuit. This circuit stops the upstream machine whenever the KR345 stops.
2. Sort signal –Dual two-pin twist type connectors are supplied for connecting to the sort circuit. . Use one or the other depending on the type of sort signal provided. The connector marked “contact” is a female connector and is used when a close contact signal is used for sorting. The connector marked “volt” is a male connector and is used when a 5-volt dc signal is used for sorting. A switch marked Volt/Contact located in the electrical box must be switched to the type signal for the appropriate connector to work.
3. The power cord has a standard 110volt plug and a quick disconnect.

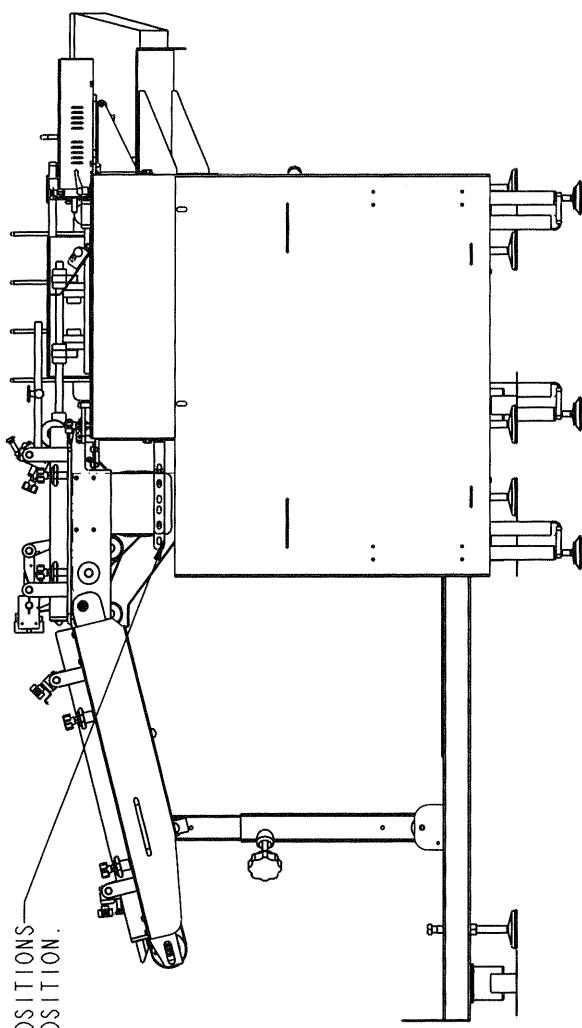
4.0 Machine Description

4.1 Mechanical Component Description

The **vertical stacking conveyor** consists of three sections – infeed, crossfeed and outfeed conveyors. The infeed conveyor speeds up, aligns and diverts product onto the crossfeed section. The crossfeed conveyor shingles and sorts product. The outfeed conveyor is where product vertically stacks. The crossfeed and outfeed conveyors can be operated together to act as a conventional conveyor.

4.1.1 Infeed conveyor (see figure 1 for two mounting positions).

LOWER L-BRACKET (BOTH SIDES). TWO SLOT POSITION
USE 544479-03 FOR LAST HOLE POSITION.



NOTES:

1. THE INFEED CONVEYOR CAN BE BOLTED IN ONE OF THREE POSITIONS.
2. SEE NOTES BELOW FOR PRODUCT SIZE AND CONVEYOR POSITION.
3. MACHINE HAS LOWER L-BRACKET THAT ALSO NEED TO BE ADJUSTED. SEE ABOVE.
4. FOR MAXIMUM SIZE PRODUCT USE L-BRACKETS 544479-03.

— USE FOR PRODUCT UP TO 13"

— USE FOR PRODUCT BETWEEN 11-12"

— USE FOR PRODUCT LESS THAN 11"

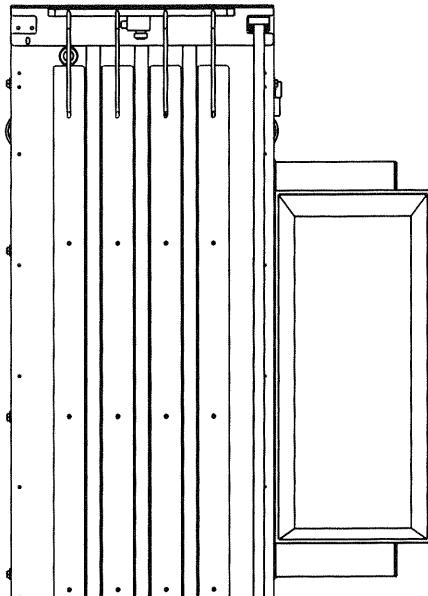
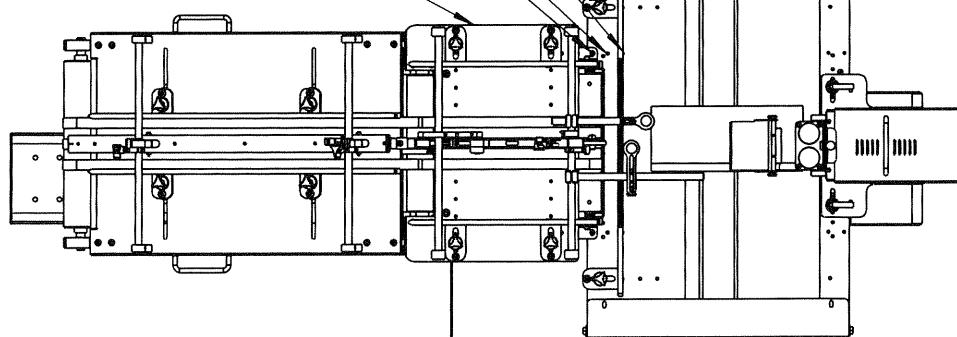


FIGURE #1
INFEED CONVEYOR MOUNTING POSITIONS

1. The spring-loaded skidbar assembly keeps product against the belts and is also used as a jam detector. It is height adjustable.
2. The spring-loaded pinch wheel assembly diverts product downward to the knockdown plate. It is height adjustable. It can also be radially adjusted around the belt drive roller.
3. The side guides align the product.

4.1.2 Crossfeed conveyor

1. The sort mechanism moves the knockdown plate/ball assembly in and out across the crossfeed conveyor. This creates offsets in the shingled stream indicating zip and bundle breaks. The knockdown can be adjusted in three directions: up/down, side to side and in/out. A brush mounted to the plate helps prevent material from bouncing off the steel balls.
2. The vacuum in the crossfeed tabletop holds product in place as it is being conveyed. A butterfly valve is available to control the vacuum level.
Note: vacuum blower not install on SA341 machine.
3. The press down roller assembly drives product up to a vertical position.

4.1.3 Outfeed conveyor

1. The spring-loaded wedge assembly directs product up against the backstop to start the vertical stacking process. The wedges are forced underneath the table as product flows across them.
2. The top edge of the mail piece stops against the upper product guide assembly. This unit adjusts vertically. Note:SA341 not equipped with this.
3. The backstop assembly moves along with the outfeed conveyor belts to support the stack. When using the KR 345 as a conventional shingle conveyor, $\frac{1}{4}$ " rods are installed at the end of the outfeed conveyor and the backstop is pivoted out of the way.

4.2 Electrical Component Description

4.2.1 Control Panel

- 1) Emergency Stop Button: Press button to turn machine power off. To turn power on, unlatch this button. The green “power on” indicator light will turn off when power is off.
- 2) Power on Button: Press this button to turn machine power on. Emergency stop button must be unlatched. Switch illuminates when activated.
- 3) Blower off/on: Turns the crossfeed blower on or off. . Note:SA341 not equipped with this.
- 4) Stop Button: Stops all drive motors.
- 5) Start Button: When the main power is on, the start button will start the drive motors. Always be sure personnel are clear of moving parts before pressing the start button.

- 6) Vertical/conventional: Sets the mode of operation to either edge stacking (vertical) or conventional shingling. When set to conventional mode, the cross feed and outfeed conveyors operate together. Note: SA341 not equipped with this.
- 7) Speed Control Knobs: Sets the speed of the unit's drive motors.
- 8) User Interface: See section 4.3 User Interface for complete description.

4.2.2 Electrical Connections to Base

1. A Turk connector is available for connecting to a stop circuit. When properly connect, the stop circuit stops upstream equipment whenever the KR345 stops.
2. Sort signal –Dual two-pin twist type connectors are supplied for connecting to the sort circuit. Use one or the other depending on the type of sort signal provided. The connector marked “contact” is a female connector and is used when a close contact signal is used for sorting. The connector marked “volt” is a male connector and is used when a 5-volt dc signal is used for sorting. A switch marked Volt/Contact located in the electrical box must be switched to the type signal for the appropriate connector to work.
3. The power cord has a standard 110volt plug and a quick disconnect.

4.2.3 Beam and Micro Switches

1. A micro switch is mounted on the skidbar on the infeed conveyor. A jam on the infeed conveyor will raise the skid bar activating the micro switch and stopping the vertical stacking conveyor.
2. The crossfeed beam switch controls the clutch on the crossfeed conveyor. The clutch engages and drives the crossfeed belts when the beam switch is covered.
3. The counter beam switch provides the count to the PLC for batch counting. If necessary, a time delay can be added to the signal by the PLC.
4. The outfeed stop beam switch is also a perfect prox type. This switch automatically stops the vertical stacking conveyor when the backstop is within two inches of it.

4.3 USER INTERFACE

4.3.1 Overview: The user interface is built into the PLC. The interface provides a way to electronically change certain machine settings and parameters. Settings and parameters are changed using the pushbuttons on the PLC. The pushbuttons are A, B, ESC, OK, +, and -.

4.3.2 Pushbuttons:

“A” button: Pressing this button will scroll through the screens programmed into the PLC. On the last screen, pressing the “A” button will return the display to the first screen.

“B” Button: This button is used on certain screens to reset the counters on that screen to zero.

“OK” Button: When a value on the display is flashing, pressing the “OK” button will allow the operator to enter the edit menu allowing the value displayed to be changed. After changing the value, pressing the “OK” button again will enter the value into the PLC.

“ESC” Button: This button will exit the editing menu and will return to the default condition for the screen.

“+” Button: On certain screens, multiple variables are shown. Pressing this button will highlight the next variable. In edit mode, the “+” button will increment the value that is highlighted.

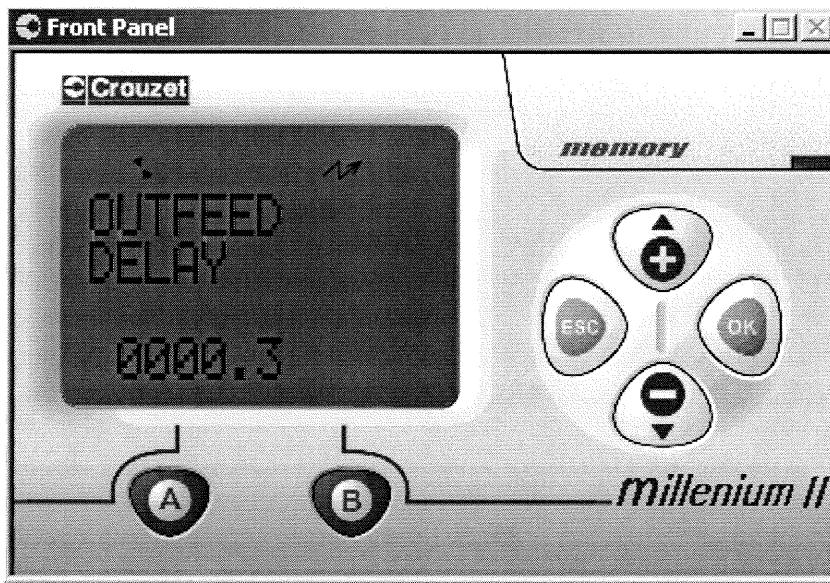
“-“ Button: This button works just like the “+” button except that it will decrement the value being edited.

4.3.3 Screens:

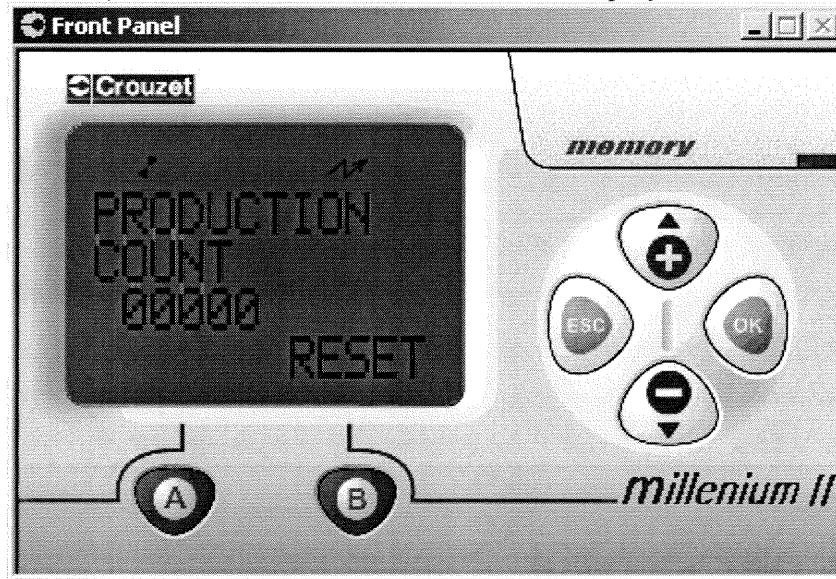
Main Screen: The main screen is the PLC default screen. It shows the current I/O status, the time, and the date. Pressing the “A” button will bring up the next screen.



Outfeed Delay Screen: This screen is for changing the delay on for the outfeed motor when the outfeed sensor is blocked. This is to keep the outfeed motor from starting when a piece of product blocks the sensor for a moment.



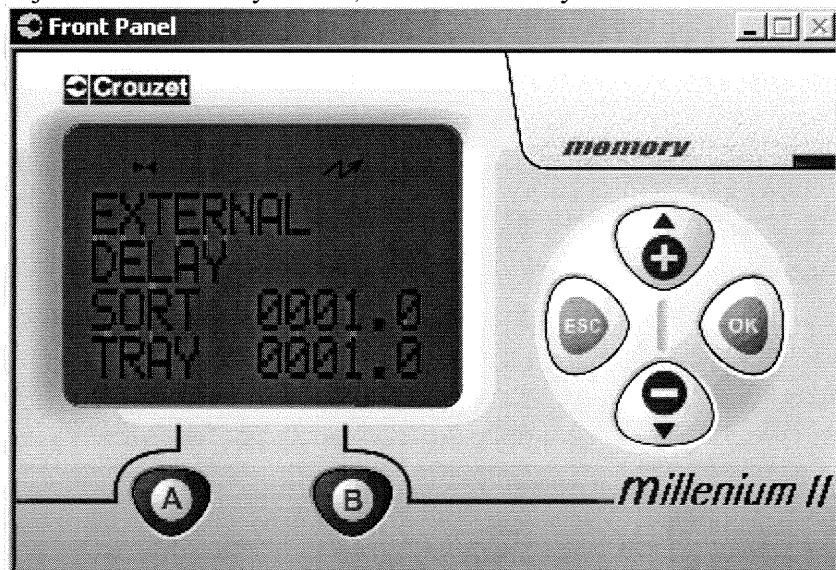
Production Count Screen: This keeps the running total of the number of pieces the stacker stacked. The "B" button will reset the count to zero. The "B" button will only reset the count when this screen is displayed.



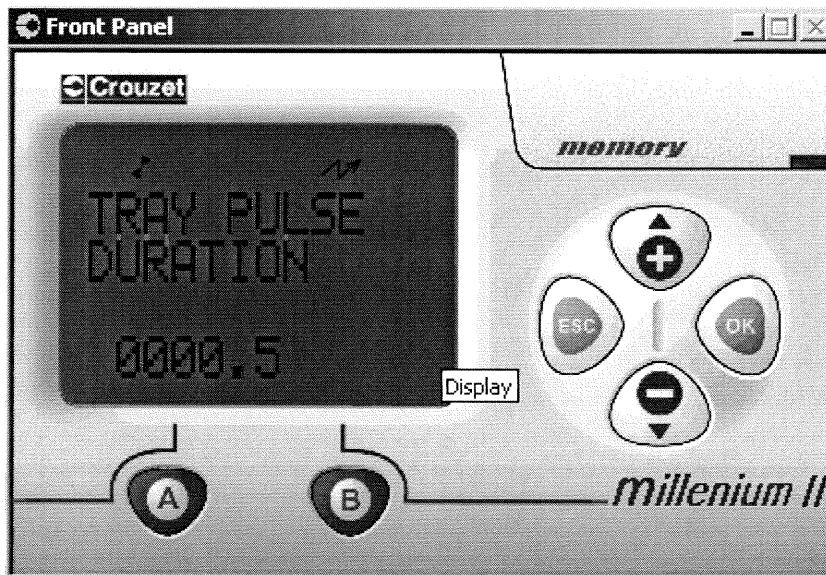
Sort Screen: This screen contains two variables. To move from one variable to the other, use the “+” and “-“ keys. Both functions operate off the Counter PE. The “Trig Delay” is a time delay before the sort actuator is activated after the sort count is complete. The Sort Preset is the number of pieces required for an automatic sort to occur.



External Delay Screen: An external sort or tray signal and may require a time delay before actuating the sort/tray actuator. This screen allows the operator to adjust the time delay. **Note**, sort and the tray must have the same delay value.



Tray Pulse Duration Screen: The External Tray Signal uses the same input as the Sort Signal. The difference between the two signals is the duration of the signal. The tray signal is only a short duration pulse long enough to move the linear actuator forward and then back again for one piece of product. A sort signal tells the machine to move the linear actuator over until another signal is received. Any signal equal to or greater than the Tray Pulse Duration value is considered a sort signal. Any signal less than the Tray Pulse Duration value is considered a tray pulse.



4.3.4 Inputs and Outputs (I/O):

Inputs:

- Input 1: Not Used
- Input 2: Start PB input.
- Input 3: Stop PB input.
- Input 4: Crossfeed PE.
- Input 5: Outfeed PE. Must be off for machine to run.
- Input 6: Break PE.
- Input 7: Mode Vert/Conv. Switch
- Input 8: Product Counter PE.
- Input 9: Skid Bar Limit Switch. Must be on for the machine to run.

Outputs:

- Output 1: Break Solenoids.
- Output 2: Not Used.
- Output 3: Crossfeed Clutch.
- Output 4: Outfeed Clutch.
- Output 5: Run Latch. Activates drives and closes stop out relay.

5.0 Operating Instructions

5.1 System Overview: Product enters the infeed conveyor where it is sped up, aligned and driven onto the cross feed conveyor. The main purpose of the infeed conveyor is to make sure product shingles onto the cross feed consistently. If the speed is set too high, the piece will have a tendency to bounce off the balls and not align properly. If the speed is set too low, the piece will not be driven against the steel balls.

The cross feed conveyor is where product shingles. A knockdown plate directs the product underneath a brush and up against two steel balls. A product sensor on the cross feed conveyor detects the trailing edge of the piece and keeps the crossfeed conveyor running as long as it is covered. Once the beam switch becomes uncovered, the cross feed clutch disengages, stopping the crossfeed conveyor.

This ensures the next piece will shingle overtop the previous piece. A continuous shingle is required to convert the shingle into a vertical position. The press down rollers on the cross feed section drive the shingled stream into a vertical position. The outfeed conveyor is where edge stacking occurs. Spring-loaded wedges direct the first piece up and against the backstop, then fall underneath the table. The adjustable linkage over the wedge assembly keeps the top of the stack consistent.

5.2 System Setup

1. Center and square the infeed conveyor of the vertical stacking conveyor with the upstream machine.
2. Use the jackscrews (or the optional hydraulic lift kit) to elevate the vertical stacking conveyor to a height where the infeed conveyor is even or just below the supply machine.
3. Connect the power, stop out and contact or volt cables.

5.3 Infeed section

1. Adjust side guides for product width.
2. Adjust skid bar height and jam micro switch..
3. Adjust outfeed pinch roller so that product is driven into the midsection of the knockdown plate.

5.4 Cross feed Section

1. Center the knock down plate with the flow of the product and lock in place. (Depending on the piece, the knock down assembly sometimes works better a little off center).
2. Adjust the front to back position of the knockdown assembly. This adjustment is usually made with the unit in the retracted position. Its position depends on the piece to be run. For longer pieces, move it away from the infeed section. Remember, for the cross feed beam switch to function, the trailing edge of the piece needs to extend between the beam switch and the reflective tape. Very short pieces require placing reflective tape between the vacuum belts and relocating the beam switch to this area.

3. Adjust the height of the knockdown/ball assembly. The setting should accommodate at least two products in a shingle. Make sure the brush is in contact with the belt.

5.5 Outfeed Section

1. The wedges are spring-loaded and will lift up from underneath the table when product is clear above them. Bring the backstop against the wedges.
2. Place a single mail piece against the wedges.
3. Adjust the outfeed proximity switch.
 - i. Set the height to one inch below the top of the mail piece.
 - ii. Set the distance between the switch and the mail piece to slightly more than 2". If the distance is less than 2", the outfeed conveyor will start and move the backstop downstream causing the wedges to fall away. If edge stacking occurs on the cross feed section, the cross feed belt will jostle the stack sideways.
4. Set the height of the vertical stop bar. Leaving a 1/4-1/2" space will allow for a more vertical stack.
5. Ensure the press down roller assembly is centered on the piece.

5.6 System operation

1. Set the infeed and crossfeed speeds to mid range and the outfeed speed at the minimum setting.
 - a. The infeed speed needs to be fast enough to drive product into the steel balls. If the speed is set too high, product will rebound off the balls and not shingle consistently. If the speed is set too low, product will not stop against the steel balls. The brush assembly helps reduce bounce back. The brush should be set at a shallow angle to allow the piece to slide by. A steep angle will not allow the piece to slide past the brush. Balance the speed and the height of the brush for best results.
 - b. Set the cross feed conveyor speed to keep the clutch from cycling. When the speed is set correctly, the crossfeed conveyor will run smoothly and never stop in between product. If it is set too high, the conveyor will start and stop after each piece. If it is set too low, product will build up underneath the knockdown plate and hang up.
 - c. Set the outfeed speed to a low setting (about 1 or less on the dial.)
2. Turn the blower on.
3. Make sure all personnel and tools are clear, then press start.
4. Run one product and make necessary adjustments.
5. To use as a conventional conveyor, lift the backstop out of the way and install the 1/4" rods at the end of the conveyor. Set the mode switch to "conv" and adjust the speed of the outfeed conveyor to that of the crossfeed conveyor. Run and fine-tune as necessary.

5.7 TROUBLE SHOOTING

Problem	Solution
Machine will not start	Unlatch stop button Check stop circuit cords are properly connected Check speed control is above zero Check outfeed proximity switch is clear
Material does not shingle in a consistent manner	Check infeed conveyor speed. If the speed is set too high, material will bounce off the steel balls. If it is set too low, material will not be driven up against the steel balls. Check the infeed pinch roller. It should drive material down into the knockdown plate. Check the height of the knockdown plate. The height should accommodate several pieces of material. Check brush setting. Set brush to a shallow angle. A steep angle will not allow product underneath. Check blower is on.
Cross feed conveyor does not run smooth	Slow down the cross feed section. The trailing edge of the last piece is clearing the beam switch before the next piece arrives.
The sort is off one piece	Adjust sort signal delay. Adjust position of counter beam switch.
Stack appears to vibrate and jostles to one side.	Adjust stack proximity switch towards the stack. This will move the stack off of the crossfeed belts and onto the outfeed belts.
Stack falls down	Check rubber stripping on backstop. The rubber stripping creates friction between the edge of the backstop and the outfeed belts. The weight of large stacks can make the backstop slip on the belts and not support the stack.

6.0 MAINTENANCE



WARNING

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

6.1 Infeed Conveyor

1. Check table belts for wear and proper tension.
2. Check functionality of jam detector switch.

6.2 Crossfeed Conveyor

1. Remove dust from product sensors and reflector using a clean cloth.
2. Check table belts for wear and proper tension.
3. Check condition of brush on backstop.

6.3 Outfeed Conveyor

1. Check table belts for wear and proper tension.
2. Remove dust from product sensors and reflector using a clean cloth.

7.0 PARTS LISTS AND DIAGRAMS

ASSEMBLY #	DESCRIPTION
SA341-1L	ASSY, KR345 ON-EDGE STACKER LH
SA341-1R	ASSY, KR345 ON-EDGE STACKER RH
544193-03	ASSY, PRODUCT ROLLERS LH
544193-04	ASSY, PRODUCT ROLLERS RH
544729-01	ASSY, ROLLER PROCUCT LH
544729-03	ASSY, ROLLER PROCUCT RH
544284-03	ASSY, SHINGLE SECTION LH
544284-04	ASSY, SHINGLE SECTION RH
544207-01	ASSY, LINEAR GUIDE BRACKET
544756-01	ASSY, PRODUCT STOP
544287-03	ASSY, IDLER SHAFT LH
544287-04	ASSY, IDLER SHAFT RH
544295-01	ASSY, IDLER CONVEYOR BELT
544498-01	ASSY, SIDGUIDE SHINGLE SECTION
544293-01	ASSY, INFEED SECTION
544492-01	ASSY, SIDEGUIDE INFEED
544567-01	ASSY, SKIDBAR KR345
544454-04	ASSY, KR345 OUTFEED SECTION LH
544454-05	ASSY, KR345 OUTFEED SECTION RH
530610-01	ASSY, TAKEUP 1 IN BELT
530610-02	ASSY, TAKEUP 1 IN BELT
544459-03	ASSY, BACKSTOP RH
544459-04	ASSY, BACKSTOP LH
544469-06	ASSY, CONVEYOR FRAME LH
544469-07	ASSY, CONVEYOR FRAME RH
538171-04	ASSY, 1/4HP GEARHEAD W/CLUTCH
539424-01	ASSY, RH HYDRALIFT LEG
539425-01	ASSY, LH HYDRALIFT LEG
544335-02	ASSY, CONTROL PANEL KR345

Optional Infeed Extension

544293-02	ASSY, INFEED SECTION
532466-01	ASSY, DRYER ARM PIVOT
546475-01	ASSY, CONVEYOR ANGLED
530619-01	ASSY, IDLER ROLLER
537284-09	ASSY, SKID BAR BUMPTURN
546482-01	ASSY, SIDEGUIDE INCLINE CONVEYOR

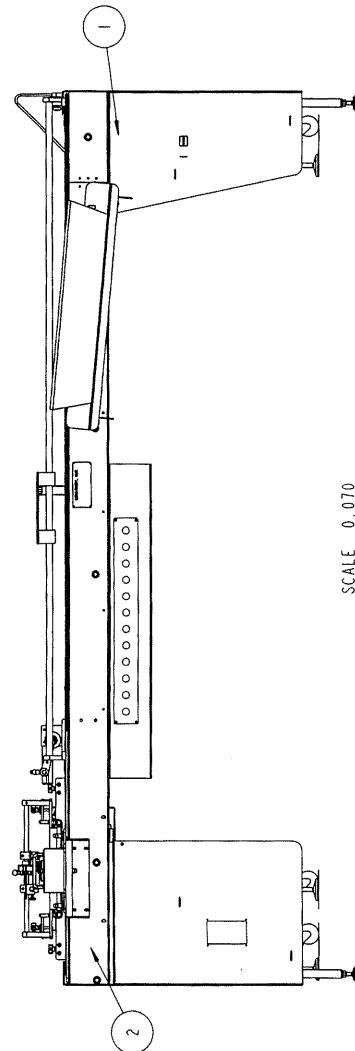
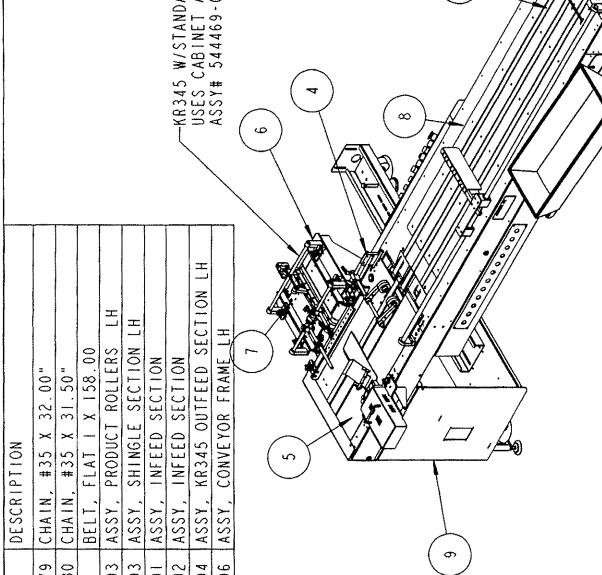
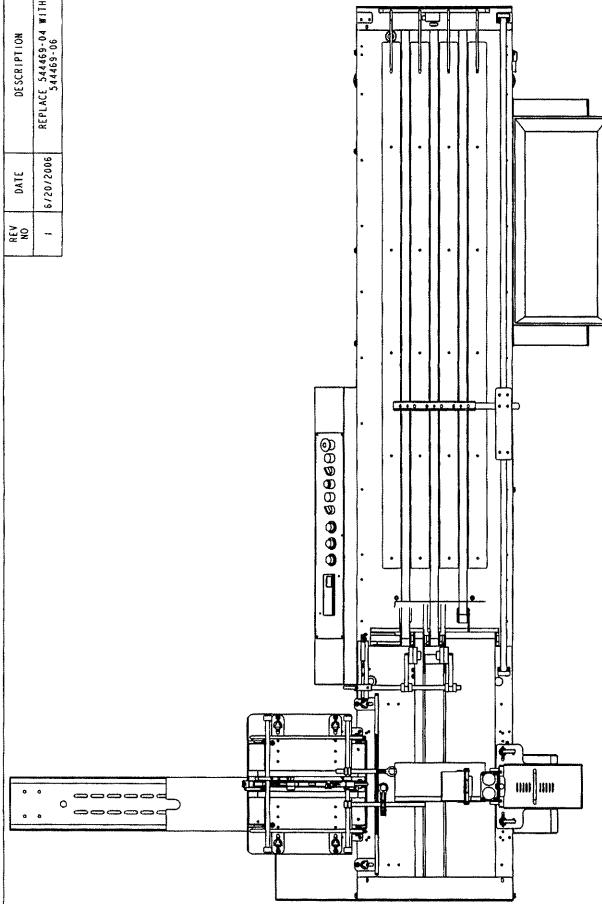
DRAWING 1 SA341 - 1L

ITEM QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	1	110020-79 CHAIN, #35 X 32.00"	I	6/20/2006	REPLACE 54469-04 W/1H	7-32	TG
2	1	110020-80 CHAIN, #35 X 31.50"					
3	2	111894-1 BELT, FLAT 1 X 158.00					
4	1	544193-03 ASSY, PRODUCT ROLLERS LH					
5	1	544284-03 ASSY, SHINGLE SECTION LH					
6	1	544293-01 ASSY, INFEED SECTION					
7	1	544293-02 ASSY, INFEED SECTION					
8	1	544454-04 ASSY, KR345 OUTFEED SECTION LH					
9	1	544469-06 ASSY, CONVEYOR FRAME LH					

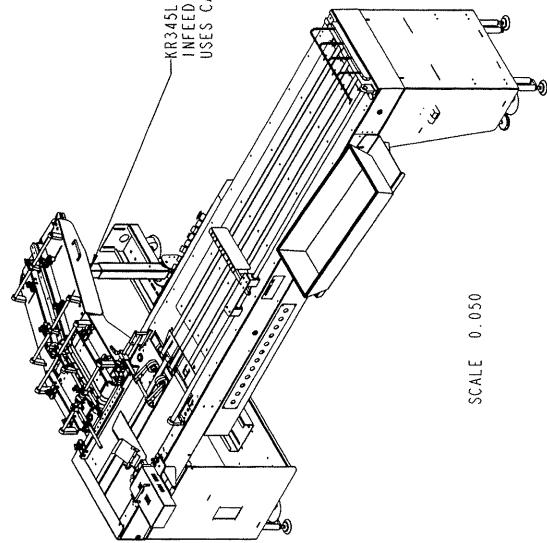
KR345 W/ STANDARD INFEED
USES CABINET ASSY# 544469-06 SHOWN
ASSY# 544469-06 SHOWN

KR345L W/ EXTENDED
INFEED CONVEYOR ASSY# 546293-02
USES CABINET ASSY# 544469-06

7 8 9 3 4 5 6

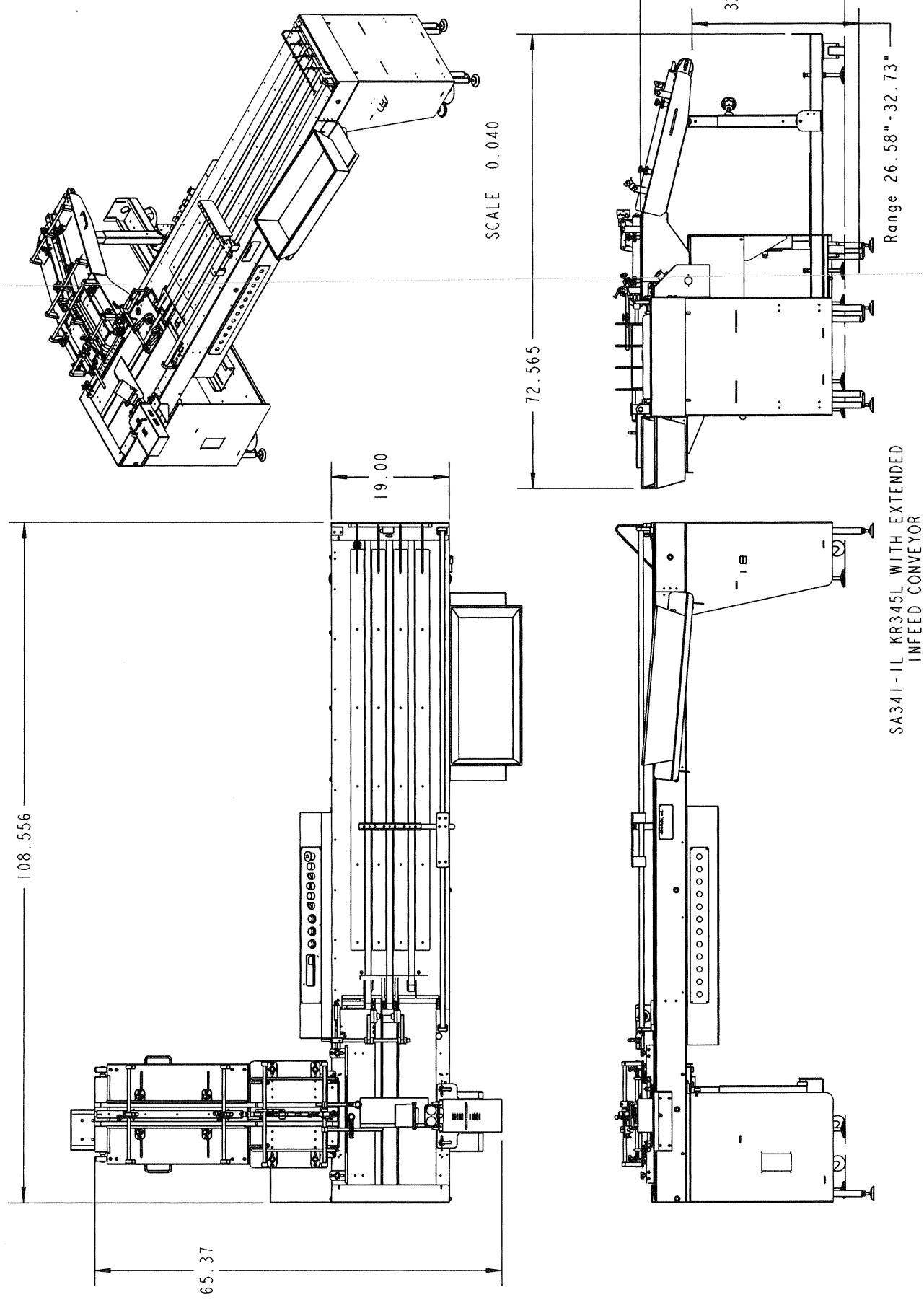


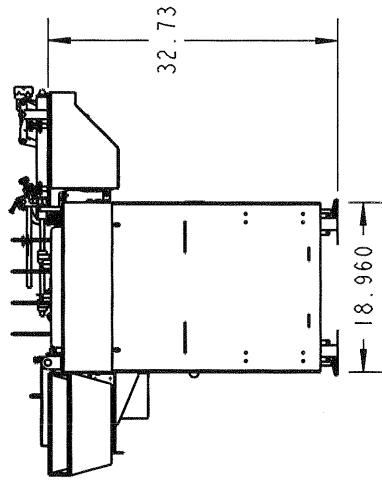
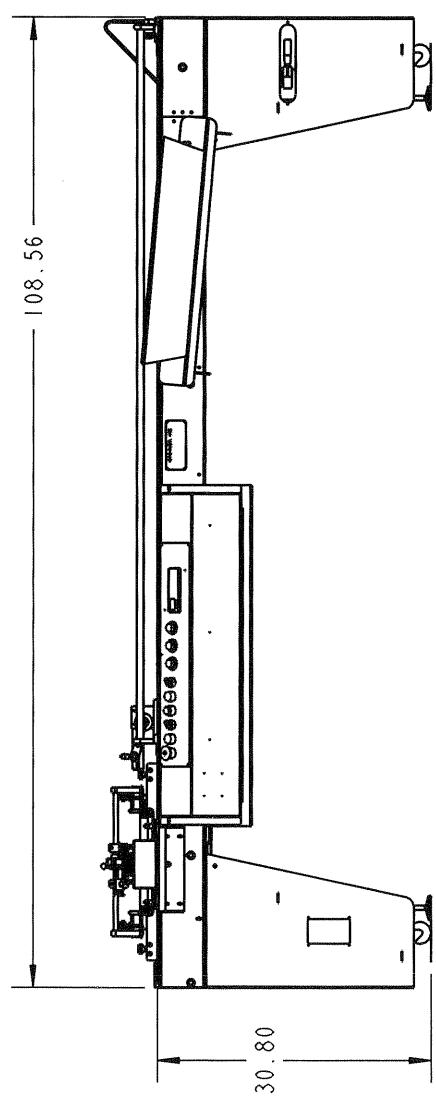
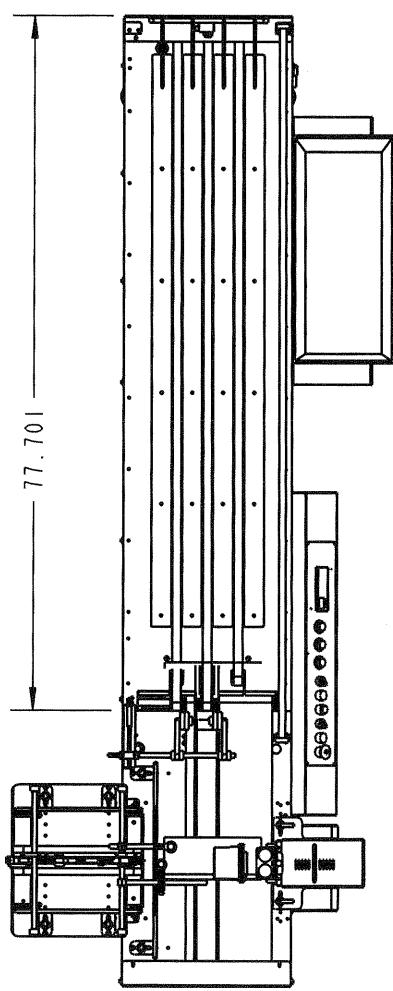
SCALE 0.070



SCALE 0.050

DRAWING BY:		SCALE	0 .050	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED		THIRD ANGLE PROJECTION	PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE COPIED OR REPRODUCED EXCEPT WRITTEN PERMISSION OF KIRK-RUDY, INC. WOODSTOCK, GEORGIA 750-925-1100 USA		X XXX	RED'D WHERE USED
CREATED BY:	JIG	DATE	07-Apr-05	IN.	.000	HEAT TREAT:	XX	SA341 - 1	KR345 ON-EDGE STACKER LH	
TRACED BY:				IN.	.5	SHARP EDGES AND SHARP CORNERS UNLESS OTHERWISE NOTED	XX			
MATERIAL:		MASTER		IN.	.000	ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE, WORK TO DIMENSIONS ONLY	XX	10F5	SA341 - 1L	





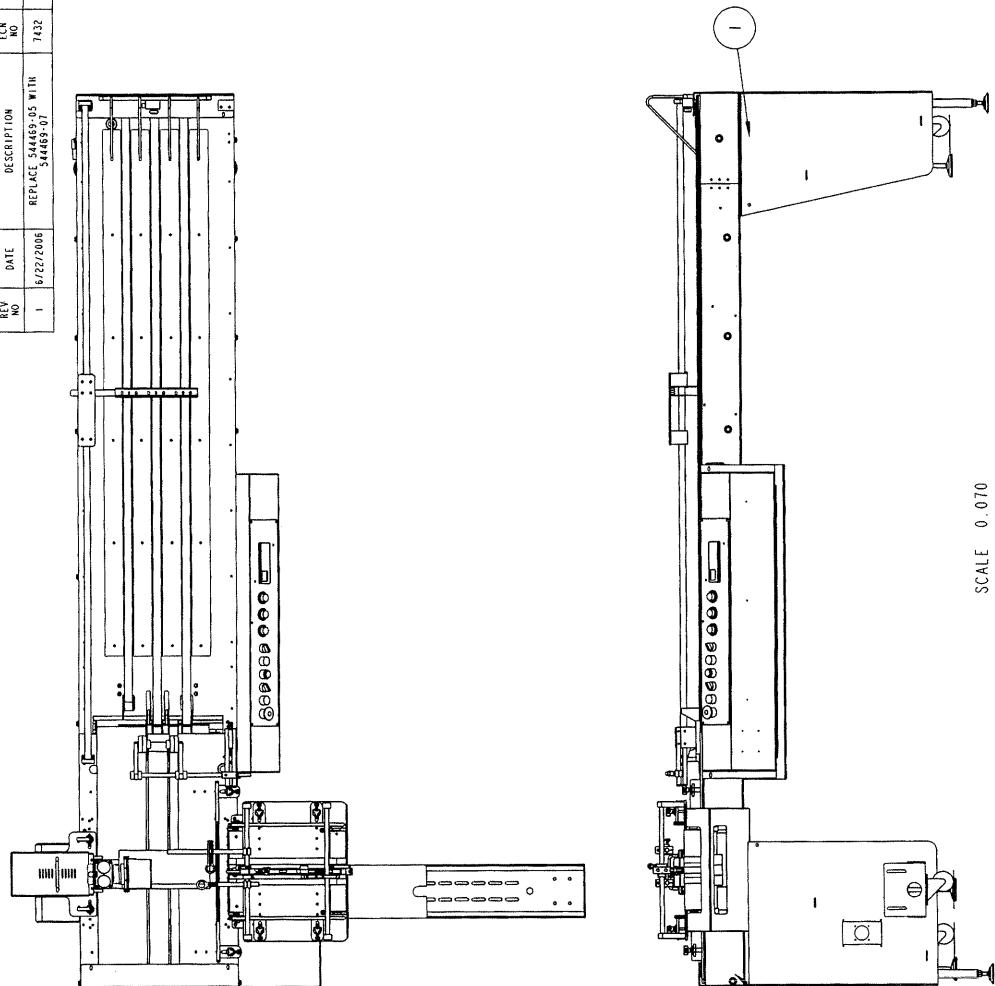
SA341-1L KR345L W/STANDARD INFED

DRAWING 6

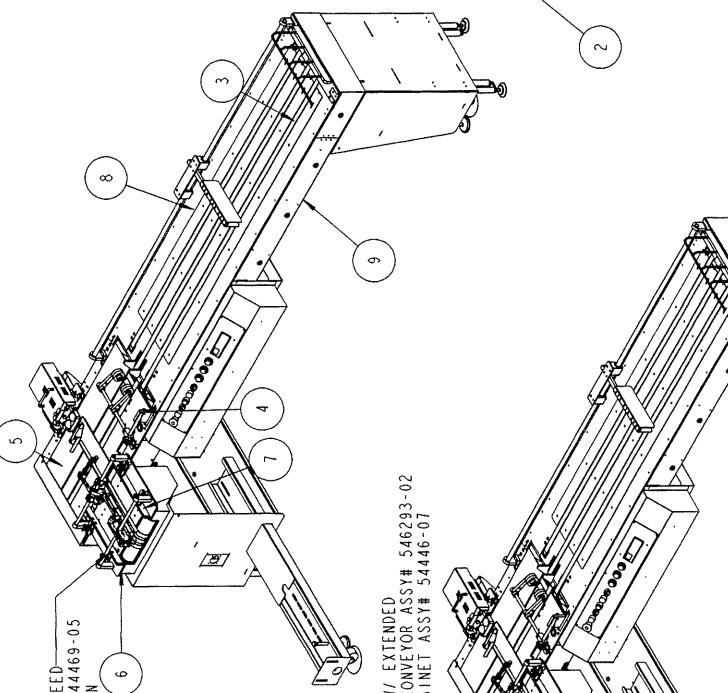
SA341 - 1 R					
DRAWING #		DESCRIPTION			
REV NO	DATE	DESCRIPTION		CCN NO	BY
1	6/22/2006	REPLACE 544469-05 WTR	544469-07	7432	J.G.

ITEM #	PART #	DESCRIPTION
1	110020-81	CHAIN, #35 X 32 00"
2	110020-82	CHAIN, #35 X 24 75"
3	111834-2	BELT, FLAT 1 X 158.00
4	544193-04	ASSY, PRODUCT ROLLERS RH
5	544284-04	ASSY, SINGLE SECTION RH
6	544293-01	ASSY, INFED SECTION
7	544293-02	ASSY, INFED SECTION
8	544454-05	ASSY, KR345 OUTFEED SECTION RH
9	544469-07	ASSY, CONVEYOR FRAME RH

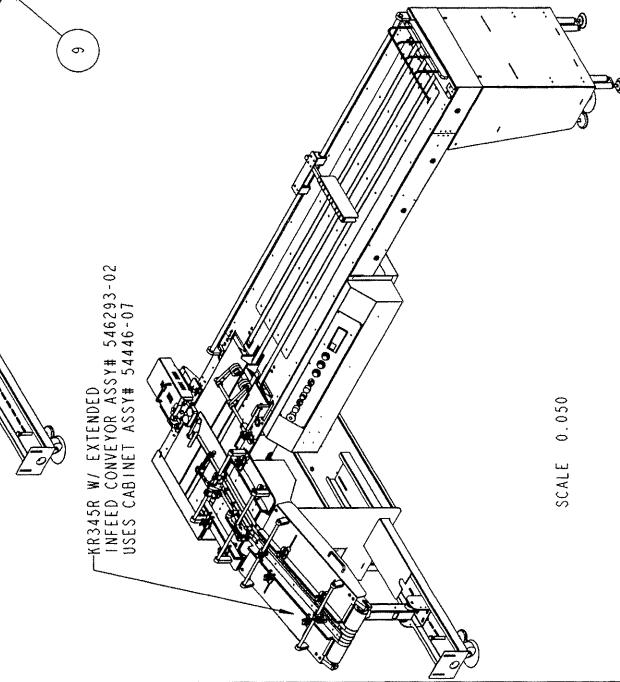
KR345 W/STANDARD INFEED
USES CABINET ASSY# 544469-05
ASSY# 544469-07 SHOWN



卷之三

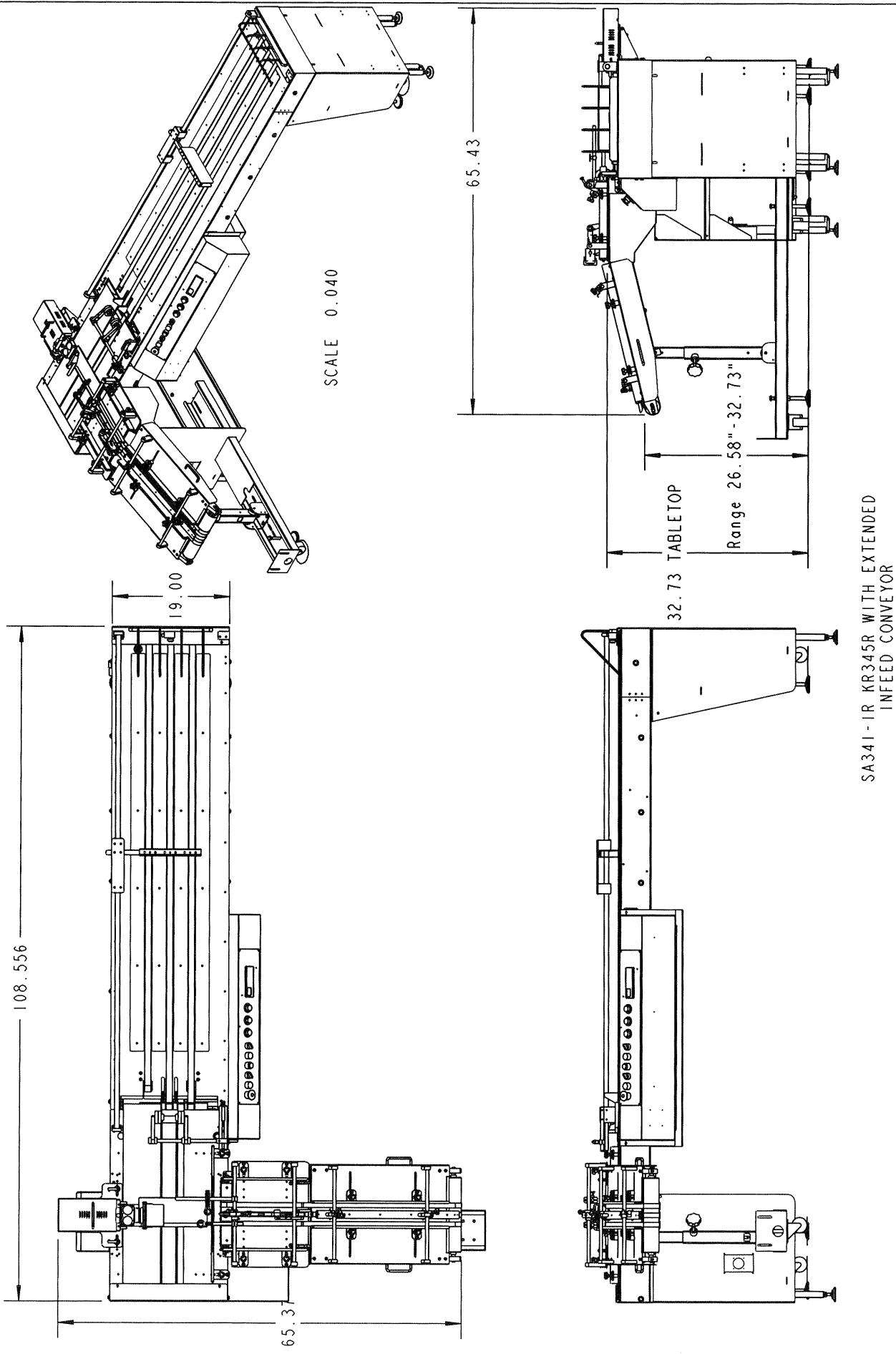


-KR345R W/ EXTENDED
INFEED CONVEYOR ASSY# 546293-02
USES CABINET ASSY# 54446-07

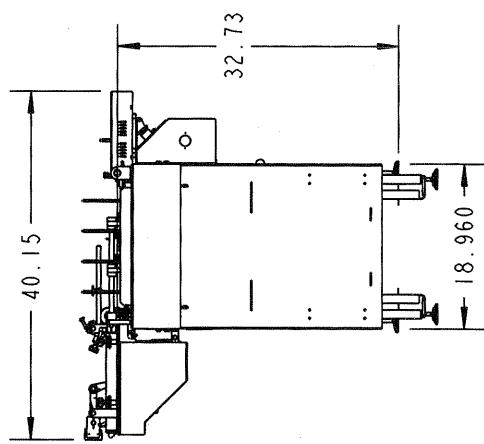
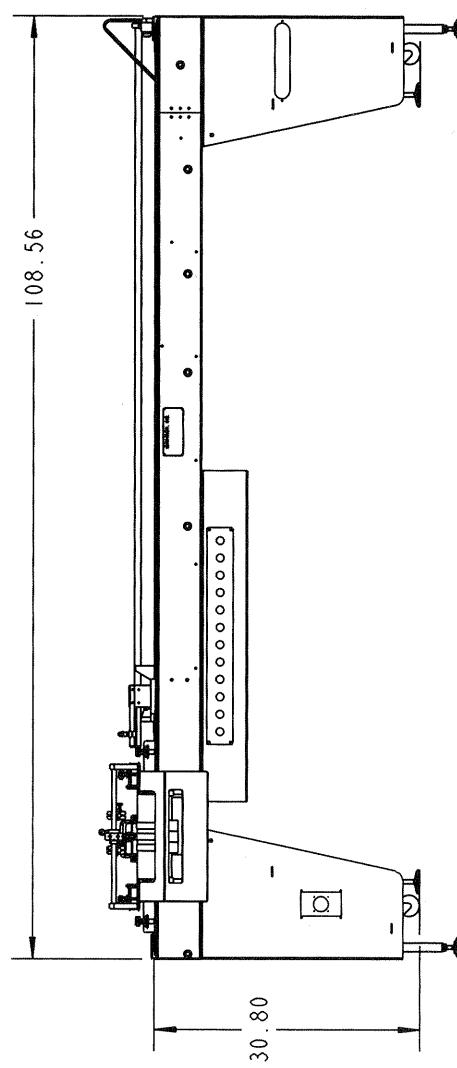
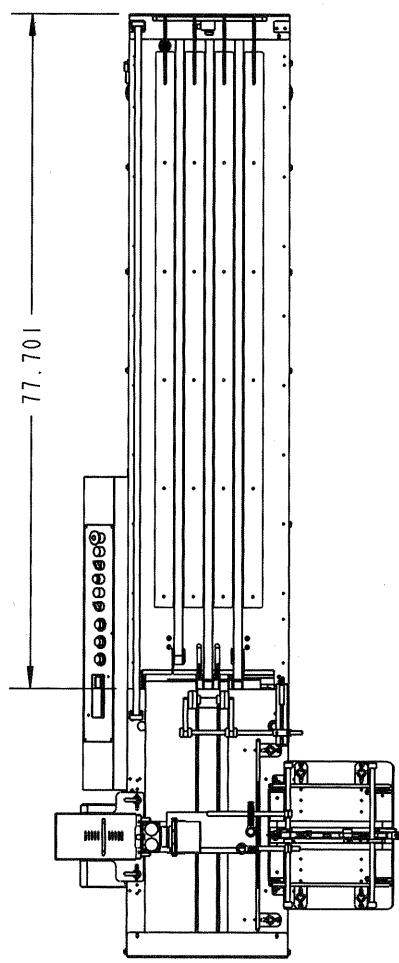


DRAWN BY: T JG		SCALE 0 . 050	DIMENSIONAL TOLERANCES MATERIAL: UNLESS OTHERWISE NOTED XXXX	HEAT TREAT: XXX	HARDWARE PROJECTION PROBLEMS OF THIS DRAWING DO NOT EXIST. USE AS IS. EXCEPT AS WRITTEN IN THE DRAWING.	KIRK - RUDY, INC. WOODSTOCK, GEORGIA
CHECKED BY:		DATE 08 - Aug - 05	NOTES: ALL DIMENSIONS SHARP EDGES, CRACKS, UNLINED OTHERWISE NOTED	NOTES: XXX	NOTES: SA 341-1	NOTES: IR
TRACED BY:		MASTER	ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE. WORK TO DIMENSIONS ONLY	XXX	NOTES: 10F5	NOTES: IR

SCALE 0.050

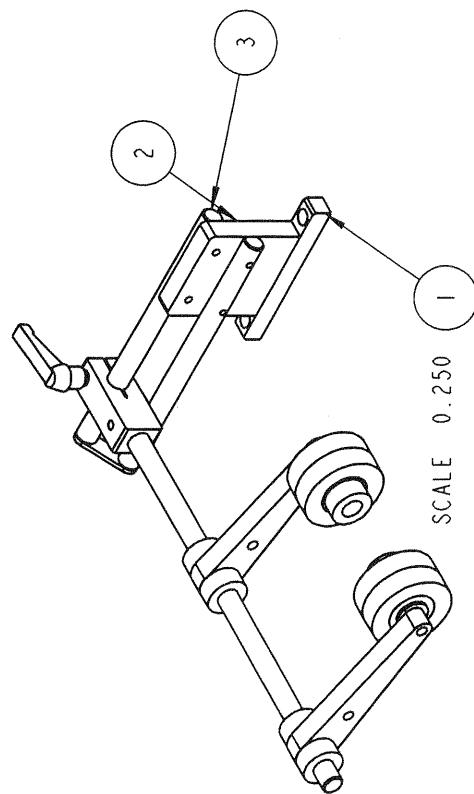
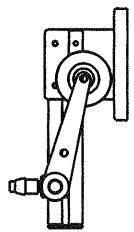
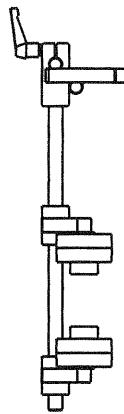
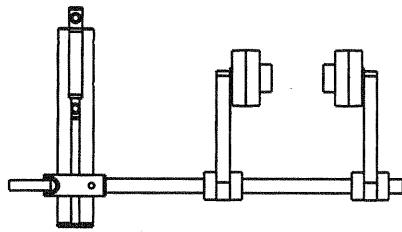


SA341 - IR KR345R W/STANDARD INFEED



ITEM QTY	PART #	DESCRIPTION
1	500794	PLATE-MOUNTING
2	544202-02	BAR, UPPER PRODUCT GUIDE MOUNT
3	544729-01	ASSY, ROLLER PRODUCT LH

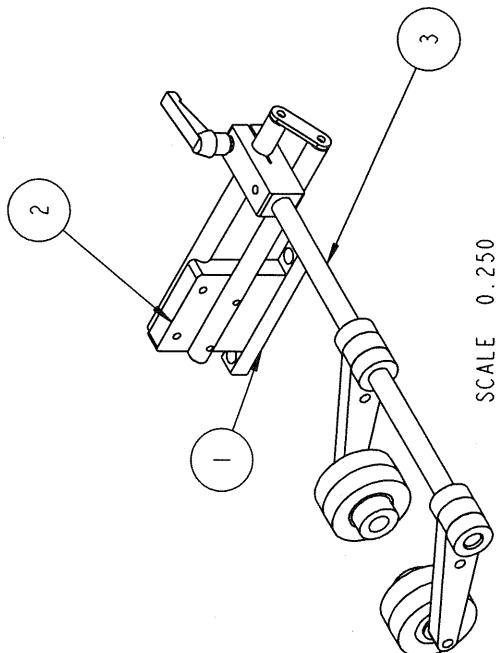
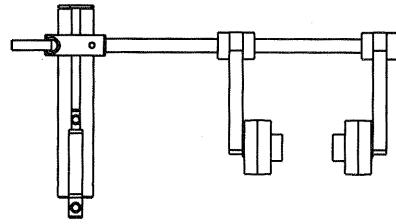
REV NO	DATE	DESCRIPTION	ECN NO	BY
			X	XXX



DRAWN BY:	SCALE	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED		THIRD ANGLE PROJECTION	PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE QUOTED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC. KENNESAW, GA 30144 USA
T JG	0 . 156	.XX	.XXX	ANG.	
CHECKED BY:	DATE	.01	.005	.5	HEAT TREAT:
	07 - Apr - 05				MATERIAL: XXX
TRACED BY:	MASTER	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED		FINISH: XXX	MODEL: SA341-1
	M	ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY		SHEET NO: 10F 1	ASSY, PRODUCT ROLLERS LH
		DRAWING:			544193-03

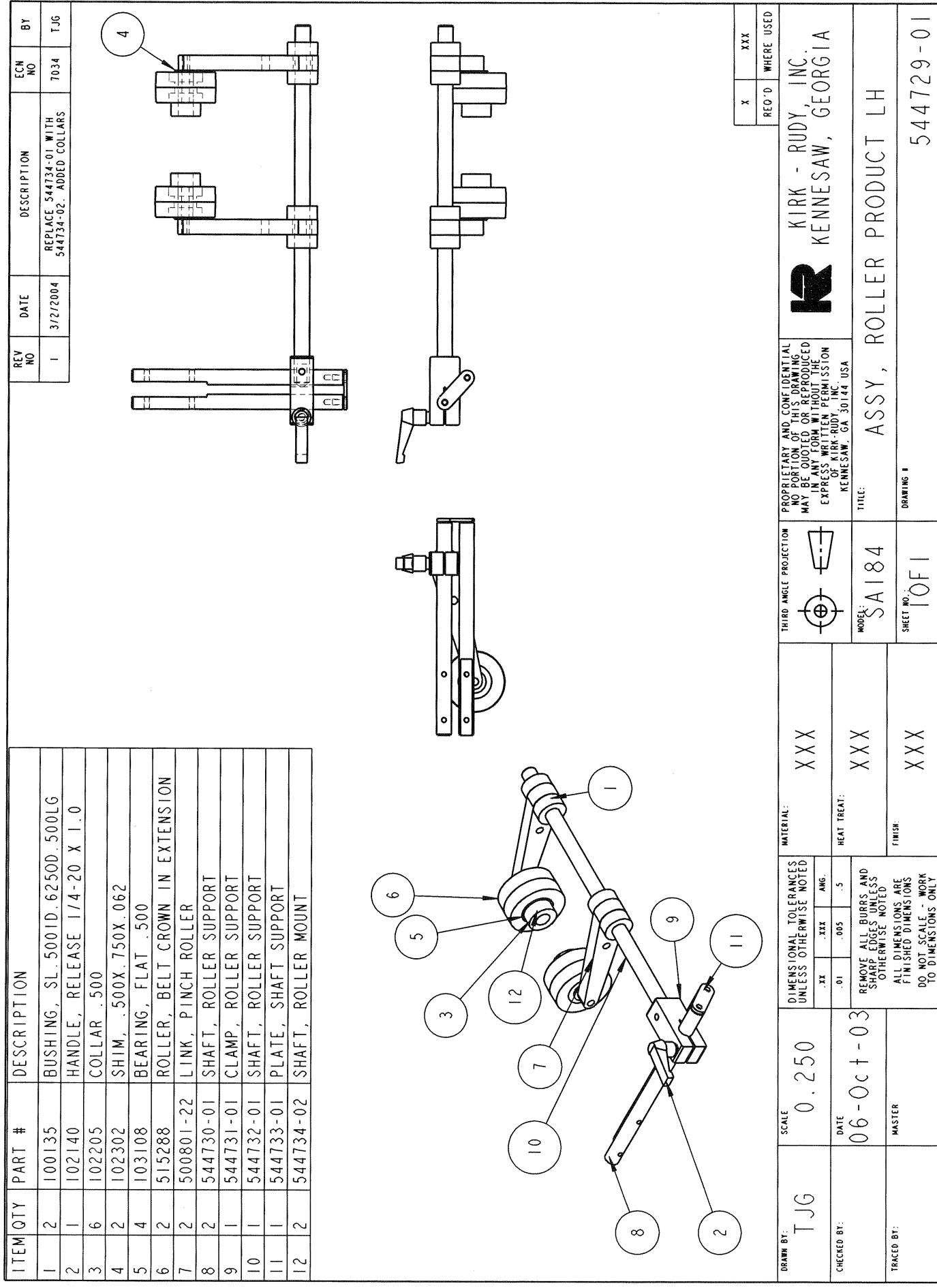
ITEM QTY	PART #	DESCRIPTION
1	1	500794 PLATE-MOUNTING
2	1	544202-02 BAR, UPPER PRODUCT GUIDE MOUNT
3	1	544729-03 ASSY, ROLLER PRODUCT RH

REV NO	DATE	DESCRIPTION	ECN NO	BY



RECD BY	SCALE	DATE	DESCRIPTION	ECN NO	BY
T JG	0 . 156				
			DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	X X X	THIRD ANGLE PROJECTION
			.XX .XXX ANG.	.01 .005 .5	MATERIAL:
CHECKED BY:	08 - Aug - 05		HEAT TREAT:	X X X	KIRK - RUDY, INC. KIRK RUDY WOODSTOCK, GEORGIA
TRACED BY:	MASTER		FINISH:	X X X	WOODSTOCK, GA 30188 USA
			REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED		MODEL: SA341-1
			ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY		TITLE: ASSY, PRODUCT ROLLERS RH
					SHEET NO. 1 OF 1
					DRAWING # 544193-04
				X	XXX
					REC'D WHERE USED

ITEM QTY	PART #	DESCRIPTION
1	2	100135 BUSHING, SL 50010 .62500 .500LG
2	1	102140 HANDLE, RELEASE 1/4-20 X 1.0
3	6	102205 COLLAR .500
4	2	102302 SHIM, .500X.750X.062
5	4	103108 BEARING, FLAT .500
6	2	515288 ROLLER, BELT CROWN IN EXTENSION
7	2	500801-22 LINK, PINCH ROLLER
8	2	544730-01 SHAFT, ROLLER SUPPORT
9	1	544731-01 CLAMP, ROLLER SUPPORT
10	1	544732-01 SHAFT, ROLLER SUPPORT
11	1	544733-01 PLATE, SHAFT SUPPORT
12	2	544734-02 SHAFT, ROLLER MOUNT



ITEM	QTY	PART #	DESCRIPTION
1	2	100135	BUSHING, SL. 50001D 62500 500LG
2	1	102140	HANDLE, RELEASE 1/4-20 X 1.0
3	6	102205	COLLAR .500
4	2	102302	SHIM, .500X.750X.062
5	4	103108	BEARING, FLAT .500
6	2	515288	ROLLER, BELT CROWN IN EXTENSION
7	2	500801-22	LINK, PINCH ROLLER
8	2	544730-01	SHAFT, ROLLER SUPPORT
9	1	544731-01	CLAMP, ROLLER SUPPORT
10	1	544732-01	SHAFT, ROLLER SUPPORT
11	1	544733-01	PLATE, SHAFT SUPPORT
12	2	544734-02	SHAFT, ROLLER MOUNT

REV NO	DATE	DESCRIPTION	ECN NO	BY
X	XXX			
REC'D	WHERE USED			

DRAWN BY: T JG	SCALE 0 . 250	MATERIAL: XXXX	THIRD ANGLE PROJECTION	PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE OBTAINED OR REPRODUCED IN ANY FORM WITHOUT WRITTEN PERMISSION OF KIRK-RUDY, INC. WOODSTOCK, GA 30188 USA
CHECKED BY:	DATE 08 - Aug - 05	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED XX XXX .01 .005 .5 ANG.	MODE: SA34	KIRK - RUDY, INC WOODSTOCK, GEORGIA
TRACED BY:	MASTER	HEAT TREAT: XXXX	SHEET NO. 1 OF 1	TITLE: ASSY, ROLLER PRODUCT RH DRAWING # 544729-03
REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED ALL DIMENSIONS ARE FINISHED DO NOT SCALE - WORK TO DIMENSIONS ONLY				

ITEM NO	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BT
1	2	102305					
2	2	102306	SHIM.	.315X .625X .094			
3	4	103106	SHIM.	.315X .625X .031			
4	2	103804	BEARING, FLAT	.375			
5	1	110142	BEARING, HUB	.625			
6	1	111839-4	BELT, FLAT .6 X .68-.75				
7	1	111840-4	BELT, FLAT 1 X .68-.75				
8	1	111841-4	BELT, FLAT 2.25 X .62.00				
9	1	200513-5	GROMMET, RUBBER .75IDX1 .375ODX .561H				
10	2	500819-2	BLOCK, BEARING				
11	2	504949-3	TANCUP, CLAMP BELT				
12	2	507362-8	ROLLER, TRANSFER				
13	2	536770-02	BLOCK, ADJUSTMENT ROLLER				
14	2	538910-01	STUD, ROLLER IDLER				
15	1	544207-01	ASSY, LINEAR GUIDE BRACKET				
16	1	544285-02	TABLETOP, AR345, CENTER NO VAC.				
17	1	544287-03	ASSY, IDLER SHAFT LH				
18	1	544295-01	ASSY, IDLER CONVEYOR BELT				
19	1	544298-01	SHAFT, ROLLER IDLER				
20	1	544251-01	ASSY, ROLLER DRIVER CROWNED				
21	1	544256-01	SHAFT, FRONT ROLLER				
22	1	544498-01	ASSY, SIDEGUIDE SHINGLE SECTION				
23	3	ENVELOPE-PROD ENV	ENVELOPE, NO. 10				

1 SA341
RECD WHERE USED

DIMENSIONS IN INCHES UNLESS OTHERWISE NOTED

NAME OR:	SCALE:	0.188	NOTED	
CHECKED BY:	DATE:	04 - Feb - 05	III	
MAILED BY:	TIME:		IV	
ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE WORK TO DIMENSIONS ONLY				

PRINTED ON: 10/10/2005

PRINTED BY: KIRK-RUDY, INC.
WOODSTOCK, GEORGIA
WOODSTOCK, GA 30188 USA

SCALE: 0.125

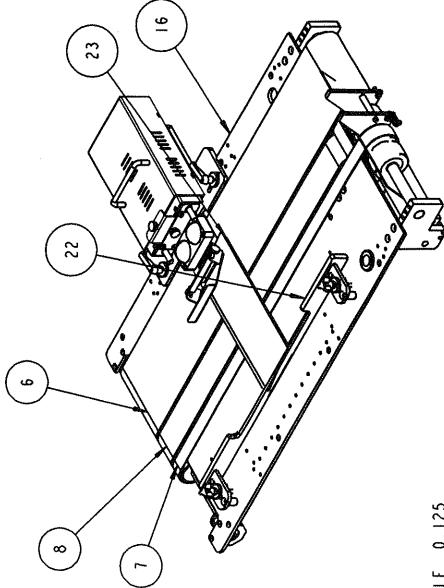
DRAWING # 544284-03

ASSY, SHINGLE SECTION LH

ITEM NO.	PART #	DESCRIPTION	REV. NO.	DATE	DESCRIPTION	REV. NO.
1	2	102305			SHIM, .375X .625X .094	
2	2	102306			SHIM, .375X .625X .031	
3	4	103106			BEARING, FLAT .375	
4	2	103804			BEARING, HUB .625	
5	1	110742			SPIKET, .3581/2 .625B .188K	
6	1	111839-5			BELT, FLAT 6 X 68.75	
7	1	111840-5			BELT, FLAT 1 X 68.75"	
8	1	111841-5			BELT, FLAT 2.25 X 62.00	
9	1	200513-5			GROMMET, RUBBER .75IDX .56TH	
10	2	500819-2			BLOCK, BEARING	
11	2	504949-3			TAKEUP, CLAMP BELT	
12	2	507662-8			ROLLER, TRANSFER	
13	2	536710-02			BLOCK, ADJUSTMENT ROLLER	
14	2	538910-01			STUD, ROLLER IDLER	
15	1	544207-01			ASSY, LINEAR GUIDE BRACKET	
16	1	544285-02			TABLETOP, KR345 CENTER NO VAC.	
17	1	544287-04			ASSY, IDLER SHAFT RH	
18	1	544295-01			ASSY, IDLER CONVEYOR BELT	
19	1	544298-01			SHAFT, ROLLER IDLER	
20	1	544451-01			ASSY, ROLLER DRIVER CROWNED	
21	1	544456-01			SHAFT, FRONT ROLLER	
22	1	544498-01			ASSY, SIDEGUIDE SHINGLE SECTION	
23	3	ENVELOPE-PRODLINE ENVELOPE, NO. 10				

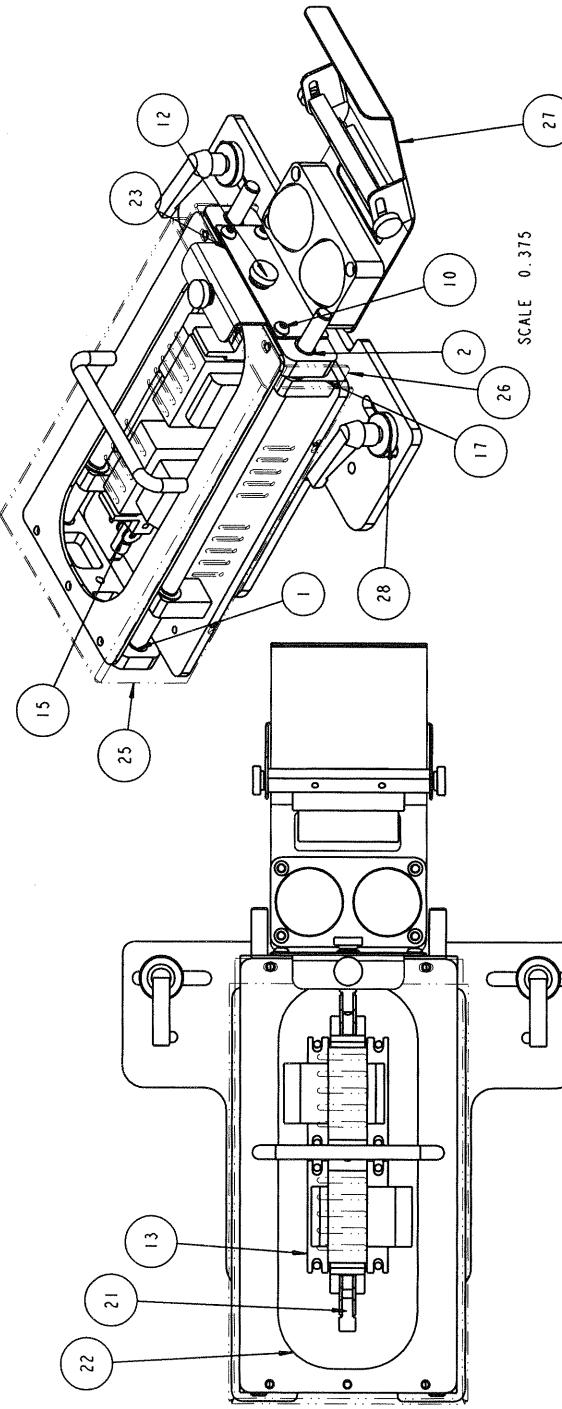
1	SP341	REO 0 WHERE USED
2	KRK	KIRK - RUDY, INC.
		WOODSTOCK, GEORGIA
3	ASSY, SHINGLE SECTION RH	DRAWING #
4	544284-04	SCALE

DRAWING #: T JG		SCALE	0 .188	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	MATERIAL:	NOTED	
CHECKED BY:		DATE:	08-Aug-05	.005	HEAT TREAT:	NONE	
INSTRUMENTS:		IN:		.005	REMOVED ALL SURFACES AND SHARP EDGES FROM PARTS		
MASTERS:		MM:		.005	ALL SURFACES AND SHARP EDGES FROM PARTS		
INSTRUMENTS:		INCHES:		.005	ALL SURFACES AND SHARP EDGES FROM PARTS		
MASTERS:		MM:		.005	ALL SURFACES AND SHARP EDGES FROM PARTS		
INSTRUMENTS:		IN:		.005	ALL SURFACES AND SHARP EDGES FROM PARTS		
MASTERS:		MM:		.005	ALL SURFACES AND SHARP EDGES FROM PARTS		



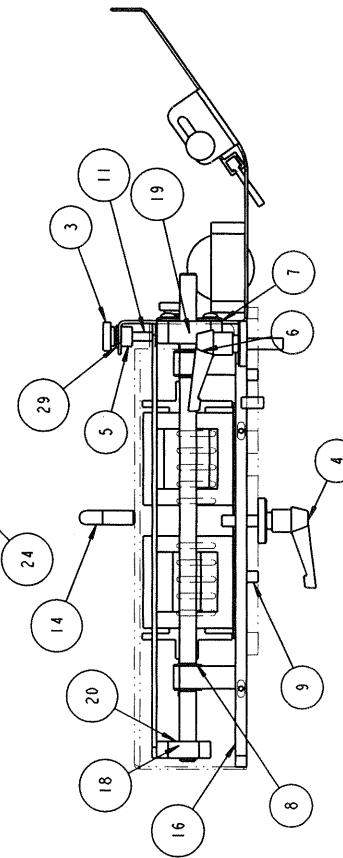
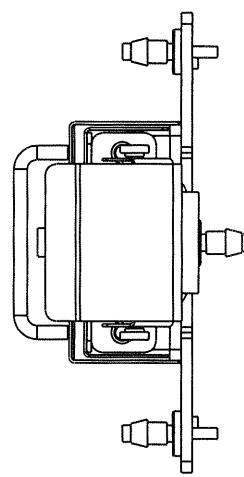
SCALE 0.125

REV NO	DATE	DESCRIPTION	ECH NO	BT
--------	------	-------------	--------	----



SCANN 0376

SCALE 0.313

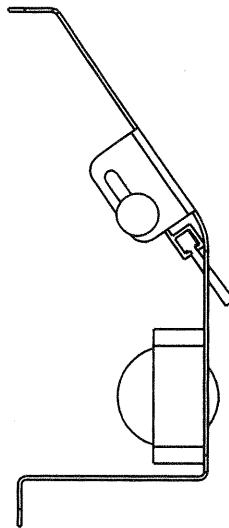
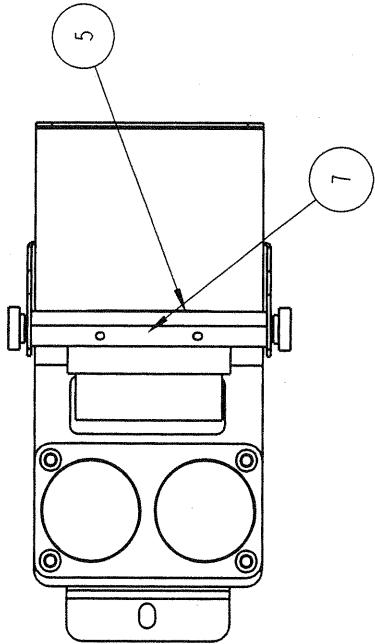
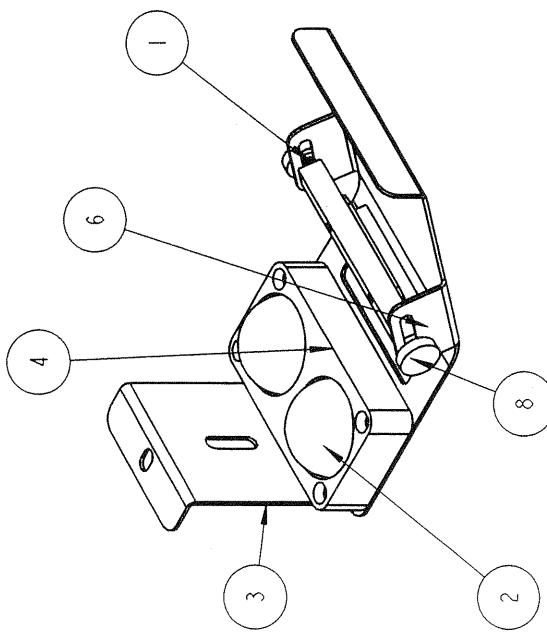


NAME:	T J G	SCALE:	0 . 375	DIMENSIONAL DATA:	FRANCIS UNLESS OTHERWISE NOTED	MATERIAL:	XXX	DATE:	25 - Ju l - 03	REMARKS:	SHOT FULL SIZE AND ALL DIMENSIONS IN INCHES	MEAT TREAT:	XXX	DATE:	25 - Ju l - 03	REMARKS:	ALL DIMENSIONS ARE INCHES. THIS DRAWING DOES NOT SCALE. WORK TO DIMENSIONS ONLY	MEAT TREAT:	XXX
CHECKED BY:		DATE:		REMARKS:		MODEL:	S A I 84	DATE:		REMARKS:		SCREW NO.	OF	DATE:		REMARKS:		SCREW NO.	OF
TRACED BY:	MASTER	DATE:		REMARKS:		LINE:	KIRK - RUDY INC. WOODSTOCK, GEORGIA	DATE:		REMARKS:		LINE:	ASSY, LINEAR GUIDE BRACKET	DATE:		REMARKS:		LINE:	ASSY, LINEAR GUIDE BRACKET
												BLOOD	WHERE USED	544207-01					

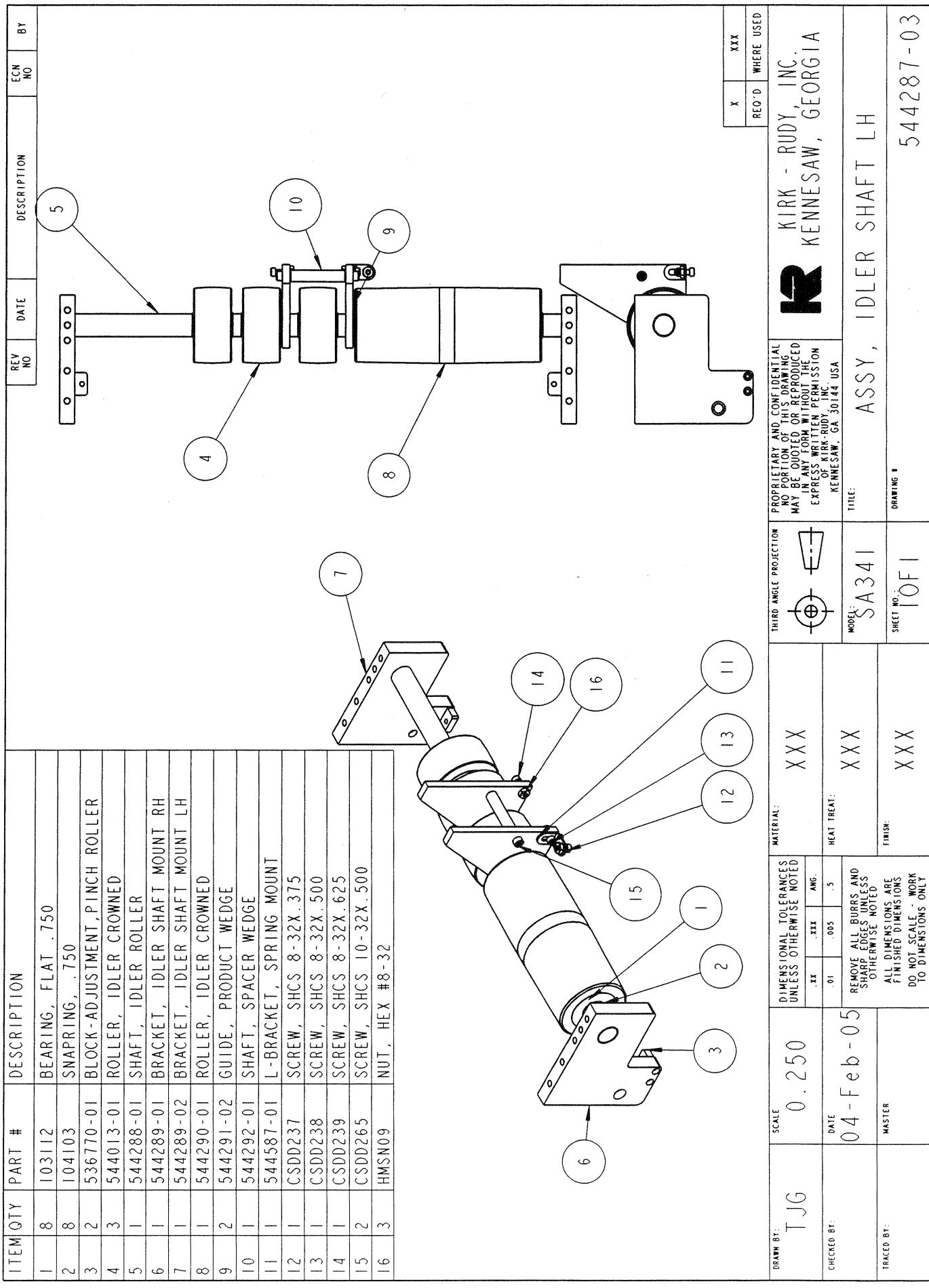
For more information about the study, please contact Dr. Michael J. Hwang at (319) 356-4530 or via email at mhwang@uiowa.edu.

ITEM QTY	PART #	DESCRIPTION
1	2	100101 BUSHING, SL 37510.50000D.37516
2	2	100129 BUSHING, SL 37510.50000.50016
3	2	102132 KNOB, 10-32 CAP SCREW
5	1	102140 HANDLE, RELEASE 1/4-20 X 1.0
5	1	102210 COLLAR .188
6	8	102306 SHIM, .375X .625X .031
7	4	102515 SHIM, .250X .500X .010
8	8	104100 SPRING, .315
9	4	105415 DOWEL, PIN 250L.500
10	4	106813 SCREW, BUTTON HEAD #10-32X.375
11	1	107406 SCREW, SHCSC 10-.32X1.250
12	1	107417 SCREW, SHCSC 10-.32X .375
13	2	190003 SOLENOID, 120VAC
14	1	190955 HANDLE
15	4	40CHAINPLATE, #40 CHAIN LINK
16	1	544208-01 PLATE, LINEAR ACTUATOR
17	4	544209-01 BAR, LINEAR SHAFT MOUNT
18	2	544210-01 SHAFT, LINEAR GUIDE
19	1	544211-01 BAR, LINEAR GUIDE
20	1	544211-02 BAR, LINEAR GUIDE
21	2	544213-01 SHAFT, SOLENOID CONNECTOR
22	1	544214-01 PLATE, SOLENOID SLIDE
23	1	544217-01 PLATE, BRACKET RETAINER
24	1	544220-01 BRACKET, LINEAR ACTUATOR
25	1	544221-01 COVER, SOLENOID
26	1	544283-01 COVER, LINEAR SHAFT
27	1	544156-01 ASSY, PRODUCT STOP
28	3	SP6383-1 SPACER, GEAR COVER
29	2	WA006 WASHER, FLAT #10

ITEM	QTY	PART #	DESCRIPTION
1	2	102132	KNOB, 10-32 CAP SCREW
2	2	191175	STEEL BALL, 1.5" DIAMETER
3	1	544215-03	BRACKET, BALL MOUNT
4	1	544218-01	BLOCK, BALL RETAINER
5	1	544754-01	BRUSH, MOUNT PRODUCT STOP
6	1	544755-01	BRUSH, PRODUCT STOP
7	1	544757-01	BAR, BRUSH ADJUSTMENT
8	2	CSDD264	SCREW, SHCS 10-32X .375



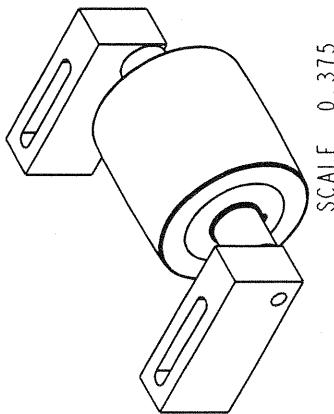
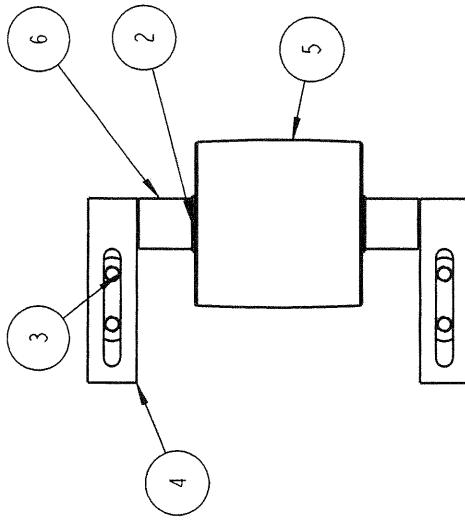
DRAWN BY:	T J G	SCALE	0 . 375	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	MATERIAL: XXX	THIRD ANGLE PROJECTION	PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE OPIATED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY INC. KENNESAW, GA 30144 USA
CHECKED BY:		DATE	17-0C+03	.01 .005 .5	HEAT TREAT: XXX	MODEL: KR345	TITLE: ASSY, PRODUCT STOP
TRACED BY:	MASTER	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED			FINISH: XXX	SHEET NO.: 10F	DRAWING #: 544756-01



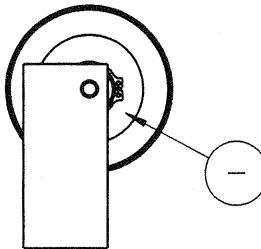
ITEM QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	103112	BEARING, FLAT .750					
2	104103	SNAPRING, .750					
3	106707	NUT, HEX #8-32					
4	107409	SCREW, SHCS 10-32X.500					
5	107413	SCREW, SHCS 8-32X.500					
6	107433	SCREW, SHCS 8-32X.375					
7	2	BLOCK ADJUSTMENT, PINCH ROLLER					
8	3	ROLLER, IDLER CROWNED					
9	1	SHAFT, IDLER ROLLER					
10	1	BRACKET, IDLER SHAFT MOUNT RH					
11	1	BRACKET, IDLER SHAFT MOUNT LH					
12	1	ROLLER, IDLER CROWNED					
13	2	GUIDE, PRODUCT WEDGE					
14	1	SHAFT, SPACER WEDGE					
15	1	L-BRACKET, SPRING MOUNT					
16	1	SCREW, SHCS 8-32X.625					
		CSD0239					

DRAWN BY:		SCALE	DIMENSIONAL TOLERANCES		MATERIAL:	THIRD ANGLE PROJECTION		PROPRIETARY AND CONFIDENTIAL	
T JG		0 . 250	UNLESS OTHERWISE NOTED		XXX	NO PORTION OF THIS DRAWING		NO PORTION OF THIS DRAWING	
			.XX	.XXX	ANG.				
CHECKED BY:		DATE	.01	.005	.5	HEAT TREAT:		MAY BE QUOTED OR REPRODUCED	
		08 - Aug - 05				IN ANY FORM WITHOUT THE		IN ANY FORM WITHOUT THE	
TRACED BY:		MASTER	REMOVE ALL BURRS AND		EXPRESS WRITTEN PERMISSION		OF KIRK-RUDY, INC.		
			SHARP EDGES UNLESS		FROM KIRK-RUDY, INC.		WOODSTOCK, GA 30188 USA		
			OTHERWISE NOTED		TITLE:				
			ALL DIMENSIONS ARE		S A 34				
			FINISHED		ASSY, IDLER SHAFT RH				
			DO NOT SCALE - WORK		SHEET NO. 1 OF 1		DRAWING #		
			TO DIMENSIONS ONLY				544287-04		

ITEM	QTY	PART #	DESCRIPTION
1	2	103112	BEARING, FLAT .750
2	2	104103	SNAPRING, .750
3	2	542147-02	BAR, THREADED BELT TAKEUP
4	2	544041-01	BRACKET, IDLER SHAFT MOUNT
5	1	544296-01	ROLLER, IDLER CROWNED
6	1	544297-01	SHAFT, IDLER ROLLER



SCALE 0.375



DRAWN BY:	T JG	SCALE	0 . 375	MATERIAL:	NOTED	THIRD ANGLE PROJECTION	KIRK - RUDY, INC.
DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED				.01	.005		KENNESAW, GEORGIA
CHECKED BY:		DATE	28 - JUL - 03	ANG.	5	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.	
TRACED BY:	MASTER	HEAT TREAT:				KENNESAW, GA 3044 USA	
REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED				NONE		MODEL:	SHEET NO.: 1 OF 1
ALL DIMENSIONS ARE FINISHED DIMENSIONS				FINISH:		ASSY, IDLER CONVEYOR BELT	DRAWING #: 544295-01

ITEM QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	2	500790-1 ASSY, TRI-KNOB 1/4-20 STUD					
2	2	541709-01 BRACKET, SIDEGUIDE					
3	2	541710-01 SPACER, SIDEGUIDE MOUNT					
4	1	544499-01 SIDEGUIDE, INFEED KR345					
5	2	SP6383-1 SPACER, GEAR COVER					

1	2	3	4	5
---	---	---	---	---

DRAWN BY: T JG SCALE 0 .375 DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED

xx	.005	5
xx	.01	xx
xx	xx	ANG.

HEAT TREAT: N/A

DATE 29-JUL-03 REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED

FINISH: N/A

ALL DIMENSIONS ARE FINISHED DIMENSIONS

MASTER DO NOT SCALE - WORK TO DIMENSIONS ONLY

TRACED BY:

1	KR345
REQ'D	WHERE USED

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



DRAWING #

SA184

TITLE:

ASSY, SIDEGUIDE SHINGLE SECTION

SHEET NO:

10F1

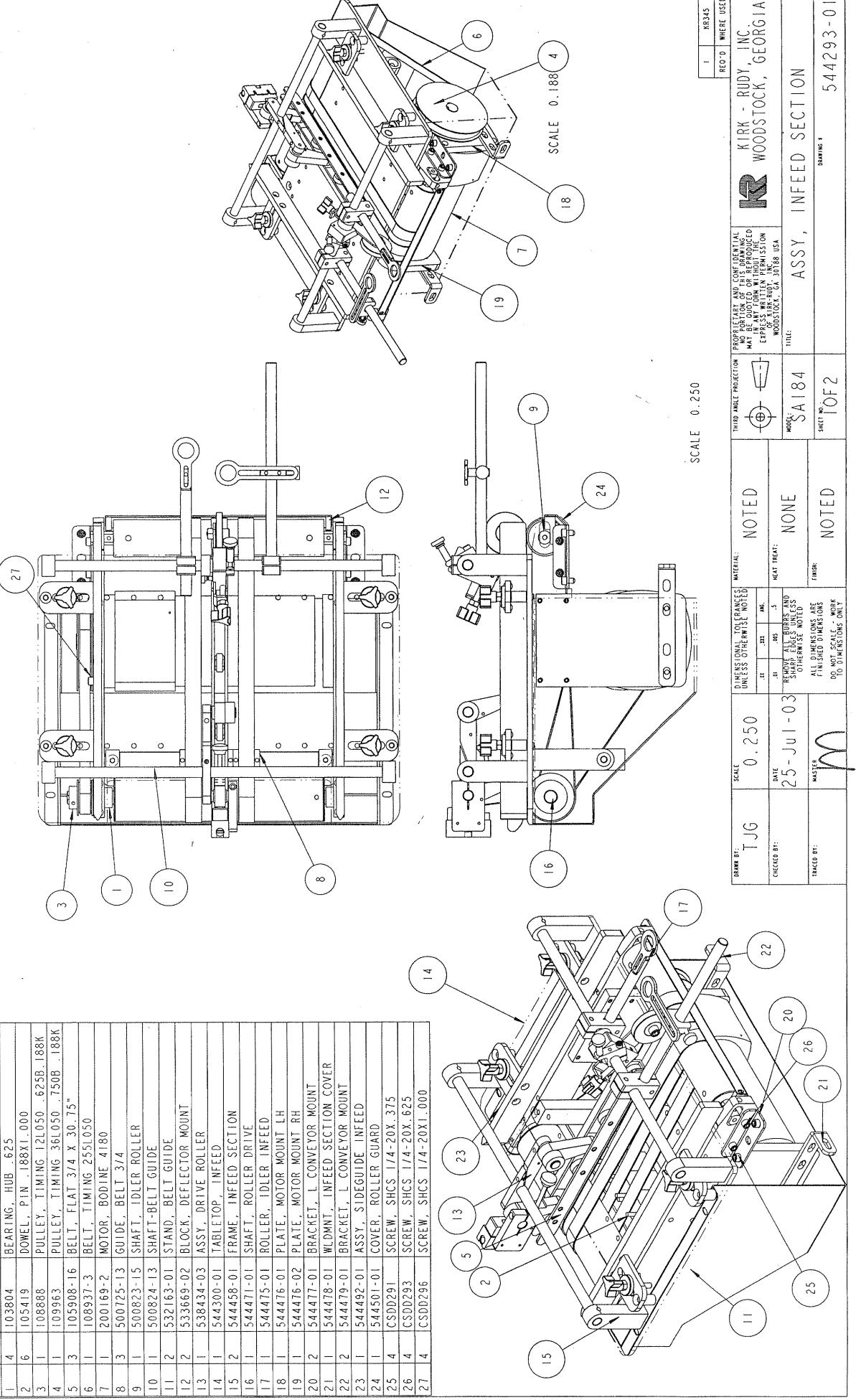
DRAWING #

544498-01

544293-01

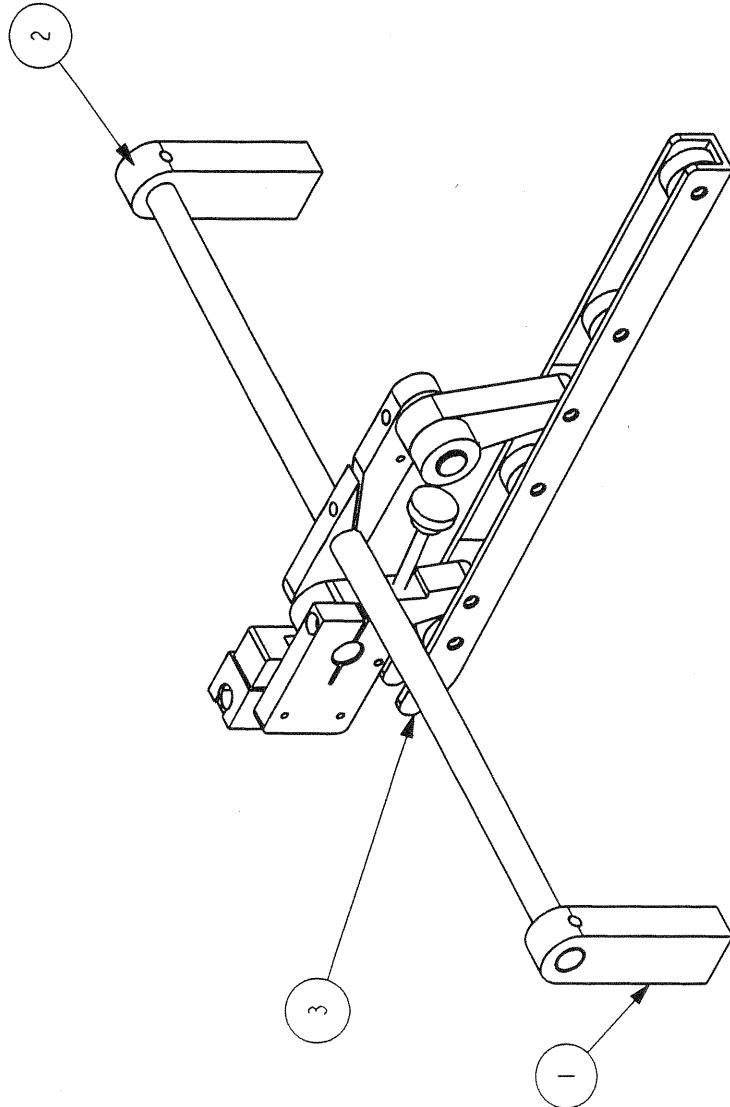
544293-01

REV NO	DATE	DESCRIPTION	ECN NO	BY
--------	------	-------------	--------	----



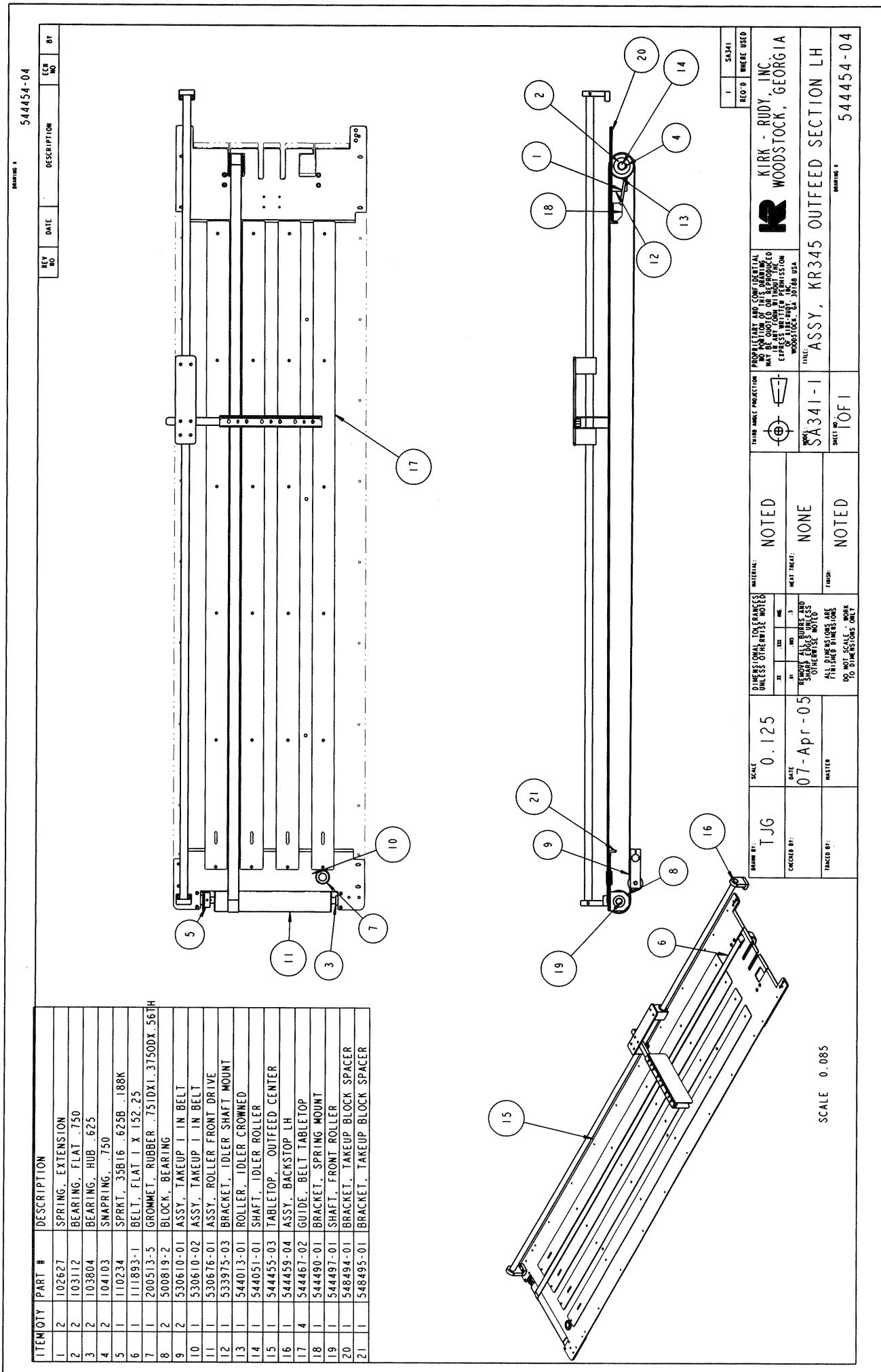
ITEM QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	100104	BUSHING, SL 500ID .625OD .750LG					
2	100619	WASHER, FLAT 10-32					
3	102132	KNOB, 10-32 CAP SCREW					
4	102714	SPRING, COMPRESSION					
5	105210	PIN, ROLL .125X .750					
6	500791	POST, SIDEGUIDE					
7	2	508593 CLAMP					
8	1	522519 SHAFT, SIDE GUIDE					
9	1	102205-3 COLLAR					
10	1	500339A ASSY, ROLLER					
11	5	500790-1 ASSY, TRI-KNOB 1/4 20 STUD					
12	1	501629-A ASSY, CLAMP WITH KNOB					
13	1	508995-4 SHAFT BEAMSWITCH MOUNT					
14	1	508996-2 PHOTOCELL BRACKET					
15	1	508996-4 BRACKET, PHOTOCELL					
16	1	532750-03 BLOCK PINCH ROLLER					
17	1	537819-01 BLOCK, SKID BAR ADJUST CLAMP					
18	4	541709-01 BRACKET, SIDEGUIDE					
19	4	541710-01 SPACER, SIDEGUIDE MOUNT					
20	2	544493-01 SIDEGUIDE, INFED KR345					
21	1	544494-01 BAR, PINCH ROLLER SUPPORT					
22	1	544500-01 SHAFT, SENSOR MOUNT					
23	1	544561-01 ASSY, SLIDERBAR KR345					
24	1	CSD0267 SCREW, SHCS 10-32X .750					
25	1	CSD0269 SCREW, SHCS 10-32X1.000					
26	1	CSD0270 SCREW, SHCS 10-32X1.250					
27	1	CSD0320 SCREW, SHCS 5/16-18X .750					
28	1	LOCKNUT 10-BPX STUD					
29	1	RHN011 NUT, HEX 5/16					
30	4	SP63833-1 SPACER, GEAR COVER					
		DETAIL A					
		SCALE 0.500					
		2					
		3					
		4					
		5					
		6					
		7					
		8					
		9					
		10					
		11					
		12					
		13					
		14					
		15					
		16					
		17					
		18					
		19					
		20					
		21					
		22					
		23					
		24					
		25					
		26					
		27					
		28					
		29					
		30					
		31					
		32					
		33					
		34					
		35					
		36					
		37					
		38					
		39					
		40					
		41					
		42					
		43					
		44					
		45					
		46					
		47					
		48					
		49					
		50					
		51					
		52					
		53					
		54					
		55					
		56					
		57					
		58					
		59					
		60					
		61					
		62					
		63					
		64					
		65					
		66					
		67					
		68					
		69					
		70					
		71					
		72					
		73					
		74					
		75					
		76					
		77					
		78					
		79					
		80					
		81					
		82					
		83					
		84					
		85					
		86					
		87					
		88					
		89					
		90					
		91					
		92					
		93					
		94					
		95					
		96					
		97					
		98					
		99					
		100					
		101					
		102					
		103					
		104					
		105					
		106					
		107					
		108					
		109					
		110					
		111					
		112					
		113					
		114					
		115					
		116					
		117					
		118					
		119					
		120					
		121					
		122					
		123					
		124					
		125					
		126					
		127					
		128					
		129					
		130					
		131					
		132					
		133					
		134					
		135					
		136					
		137					
		138					
		139					
		140					
		141					
		142					
		143					
		144					
		145					
		146					
		147					
		148					
		149					
		150					
		151					
		152					
		153					
		154					
		155					
		156					
		157					
		158					
		159					
		160					
		161					
		162					
		163					
		164					
		165					
		166					
		167					
		168					
		169					
		170					
		171					
		172					
		173					
		174					
		175					
		176					
		177					
		178					
		179					
		180					
		181					
		182					
		183					
		184					
		185					
		186					
		187					
		188					
		189					
		190					
		191					
		192					
		193					
		194					
		195					
		196					
		197					
		198					
		199					
		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					

ITEM QTY	PART #	DESCRIPTION
1 2	500791	POST, SIDE GUIDE
2 1	522519	SHAFT, SIDE GUIDE
3 1	538021-02	ASSY, SKID BAR



REV NO	DATE	DESCRIPTION	ECN NO	BY
--------	------	-------------	--------	----

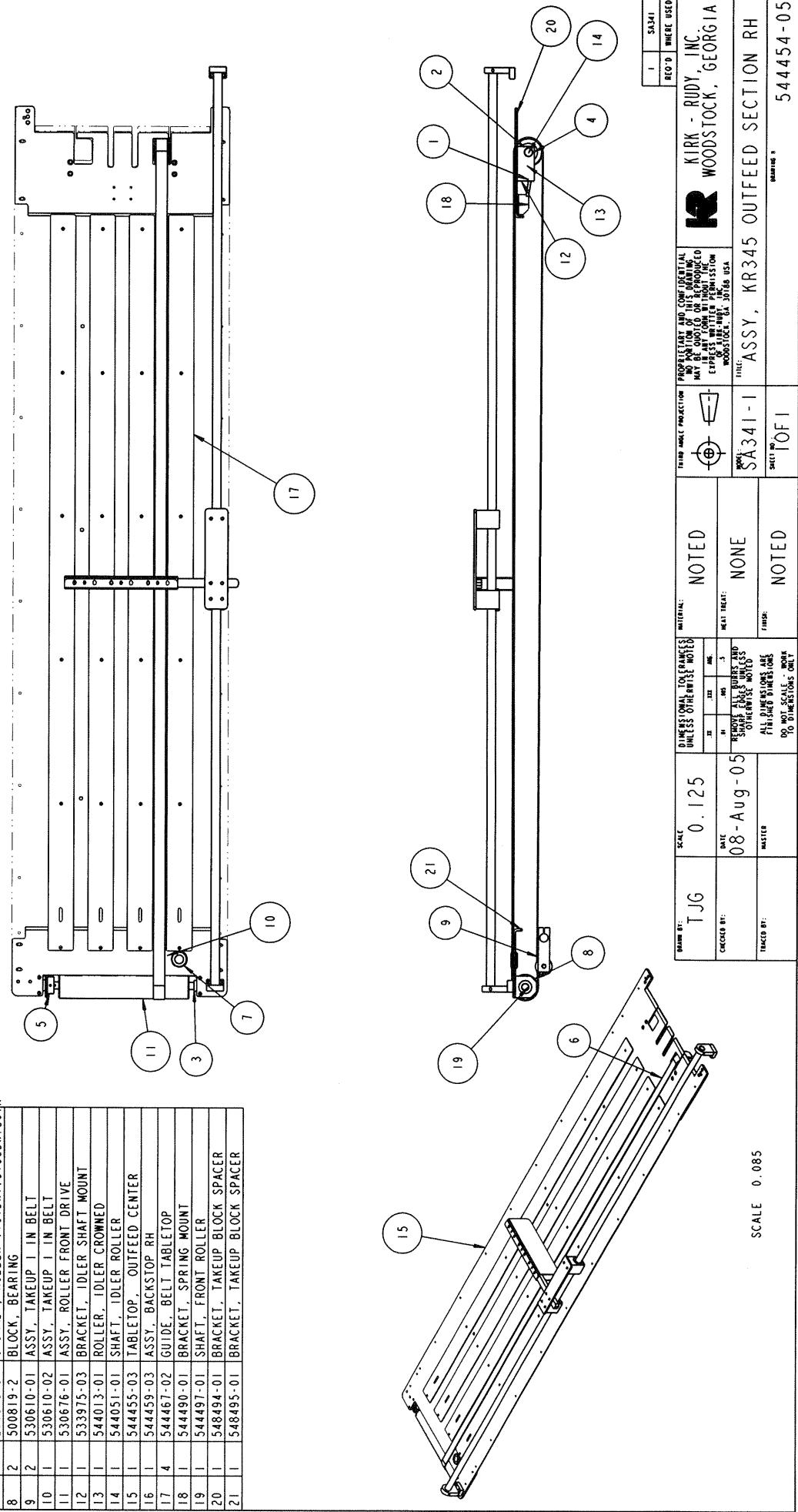
I	XXX				
REQ'D	WHERE USED				
KIRK - RUDY, INC. WOODSTOCK, GEORGIA					
DRAWN BY: T JG		SCALE 0 . 375	MATERIAL N/A	THIRD ANGLE PROJECTION 	PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE QUOTED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC. WOODSTOCK, GA 30188 USA
CHECKED BY:		DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED XX XXX ANG. .01 .005 .5	HEAT TREAT: N/A	MODEL: SA 184	ASSY, SKIDBAR KR345 Title:
TRACED BY:		DATE 12 - Sep - 03	REMOVED ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED	W.H.SR.: N/A	SHEET NO. 1 OF 1 DRAWING #
MASTER		ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY			



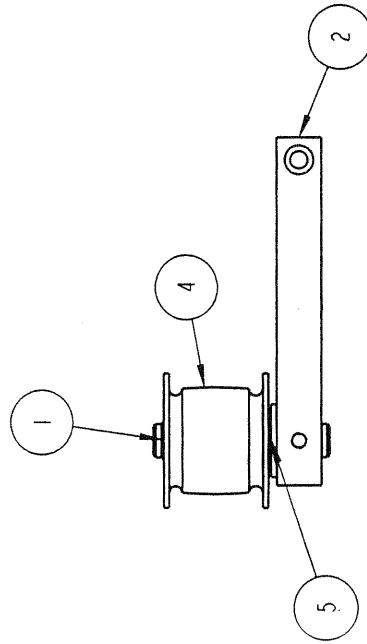
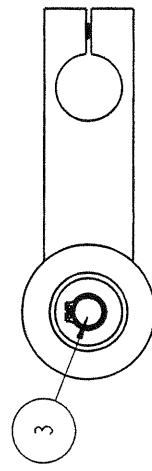
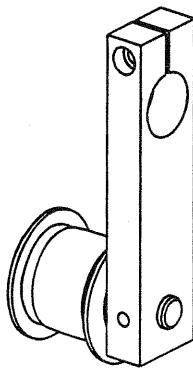
DRAWING #: 544454-05

ITEM #	PART #	DESCRIPTION	REF. NO.	DATE	DESCRIPTION	LIN. NO.
1	2	102627 SPRING, EXTENSION				B7
2	2	103112 BEARING, FLAT .750				
3	2	103804 BEARING, HUB .625				
4	2	104103 SNAPPING, .750				
5	1	110292 SPRKT, 35816 .9250 .188K				
6	1	111893-2 BELT, FLAT 1 X 152.25				
7	1	200513-5 GROMMET, RUBBER .15 IDX .3750DX .561H				
8	2	500819.2 BLOCK, BEARING				
9	2	530610-01 ASSY, TAKEUP 1 IN BELT				
10	1	530610-02 ASSY, TAKEUP 1 IN BELT				
11	1	530616-01 ASSY, ROLLER FRONT DRIVE				
12	1	533915-03 BRACKET, IDLER SHAFT MOUNT				
13	1	544013-01 ROLLER, IDLER CROWNED				
14	1	544051-01 SHAFT, IDLER ROLLER				
15	1	544455-03 TABLETOP, OUTFEED CENTER				
16	1	544459-03 ASSY, BACKSTOP RH				
17	4	544467-02 GUIDE, BELT TABLETOP				
18	1	544490-01 BRACKET, SPRING MOUNT				
19	1	544497-01 SHAFT, FRONT ROLLER				
20	1	548494-01 BRACKET, TAKEUP BLOCK SPACER				
21	1	548495-01 BRACKET, TAKEUP BLOCK SPACER				

ITEM #	PART #	DESCRIPTION
1	2	102627 SPRING, EXTENSION
2	2	103112 BEARING, FLAT .750
3	2	103804 BEARING, HUB .625
4	2	104103 SNAPPING, .750
5	1	110292 SPRKT, 35816 .9250 .188K
6	1	111893-2 BELT, FLAT 1 X 152.25
7	1	200513-5 GROMMET, RUBBER .15 IDX .3750DX .561H
8	2	500819.2 BLOCK, BEARING
9	2	530610-01 ASSY, TAKEUP 1 IN BELT
10	1	530610-02 ASSY, TAKEUP 1 IN BELT
11	1	530616-01 ASSY, ROLLER FRONT DRIVE
12	1	533915-03 BRACKET, IDLER SHAFT MOUNT
13	1	544013-01 ROLLER, IDLER CROWNED
14	1	544051-01 SHAFT, IDLER ROLLER
15	1	544455-03 TABLETOP, OUTFEED CENTER
16	1	544459-03 ASSY, BACKSTOP RH
17	4	544467-02 GUIDE, BELT TABLETOP
18	1	544490-01 BRACKET, SPRING MOUNT
19	1	544497-01 SHAFT, FRONT ROLLER
20	1	548494-01 BRACKET, TAKEUP BLOCK SPACER
21	1	548495-01 BRACKET, TAKEUP BLOCK SPACER



ITEM QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	104100	SNAPRING, .375					
2	504949	ARM BELT TIGHTENER					
3	504988-1	SHAFT, BELT TIGHTENER					
4	510611A	ASSY-ROLLER					
5	WA013	WASHER, FLAT 3/8					



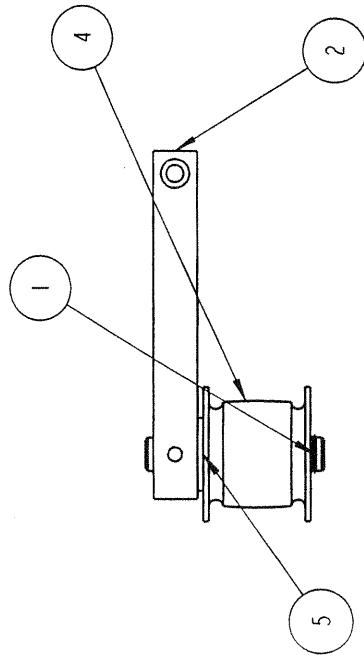
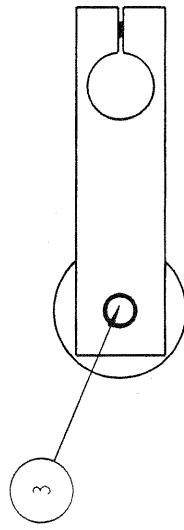
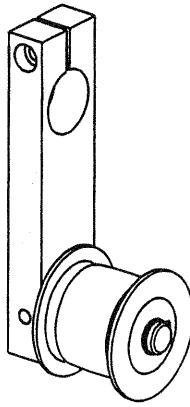
I	GEN
REQ'D	WHERE USED
<p>KR KIRK - RUDY, INC. WOODSTOCK, GEORGIA</p> <p>PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE QUOTED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK RUDY, INC. WOODSTOCK, GA 30188 USA</p>	
THRO ANGLE PROJECTION	THRO A
MATERIAL:	X X X
DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	
.XX	.XXX
.01	.005
ANG.	.5
HEAT TREAT:	NONE
FINISH:	N / A
MODEL:	X X X
SHEET NO.:	10F1
TITLE:	ASSY, TAKEUP IN BELT
DRAWING #:	530610-01

DRAWN BY: TVK SCALE: 0 .500 DIMENSIONAL TOLERANCES MATERIAL: X X X

CHECKED BY: DATE: 26-May-98 REMOVE ALL BURRS AND SHARP EDGES UNLESS HEAT TREAT: NONE

TRACED BY: FINISH: N / A ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY

ITEM QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	10400	SNAPRING .375					
2	504949	ARM BELT TIGHTENER					
3	504988-1	SHAFT, BELT TIGHTENER					
4	510611A	ASSY-ROLLER					
5	WA013	WASHER, FLAT 3/8					



I	GEN
REQ'D	WHERE USED

KR KIRK - RUDY, INC.
WOODSTOCK, GEORGIA

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

TITLE:

ASSY, TAKEUP IN BELT

DRAWING # 530610-02

SHEET NO. 1 OF 1

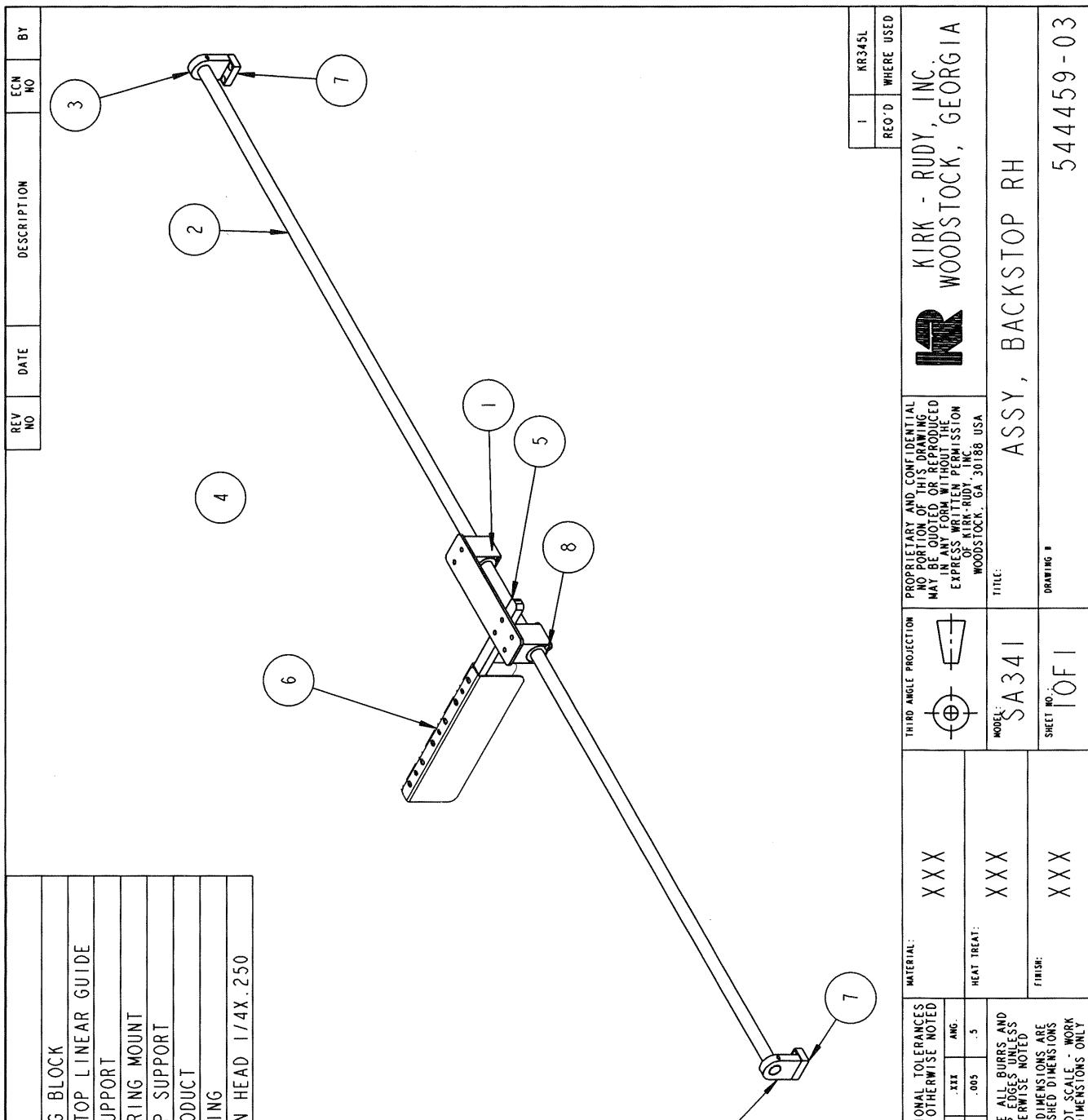
DRAFTING #

REVISIONS

DRAWN BY:	SCALE	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	MATERIAL:
TVK	0 . 500	X X X	
		.01 .005 .005	HEAT TREAT:
CHECKED BY:	DATE		NONE
	26-May-98		
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

DRAWN BY:	SCALE	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	MATERIAL:
TVK	0 . 500	X X X	
		.01 .005 .005	HEAT TREAT:
CHECKED BY:	DATE		NONE
	26-May-98		
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

ITEM QTY	PART #	DESCRIPTION
1 2	537280-01	ASSY, BUSHING BLOCK
2 1	544460-02	SHAFT, BACKSTOP LINEAR GUIDE
3 2	544461-01	BAR, SHAFT SUPPORT
4 1	544462-01	BRACKET, BEARING MOUNT
5 1	544463-01	BAR, BACKSTOP SUPPORT
6 2	544464-02	BACKSTOP, PRODUCT
7 2	544465-01	PLATE, MOUNTING
8 4	CSF63	SCREW, BUTTON HEAD 1/4X.250

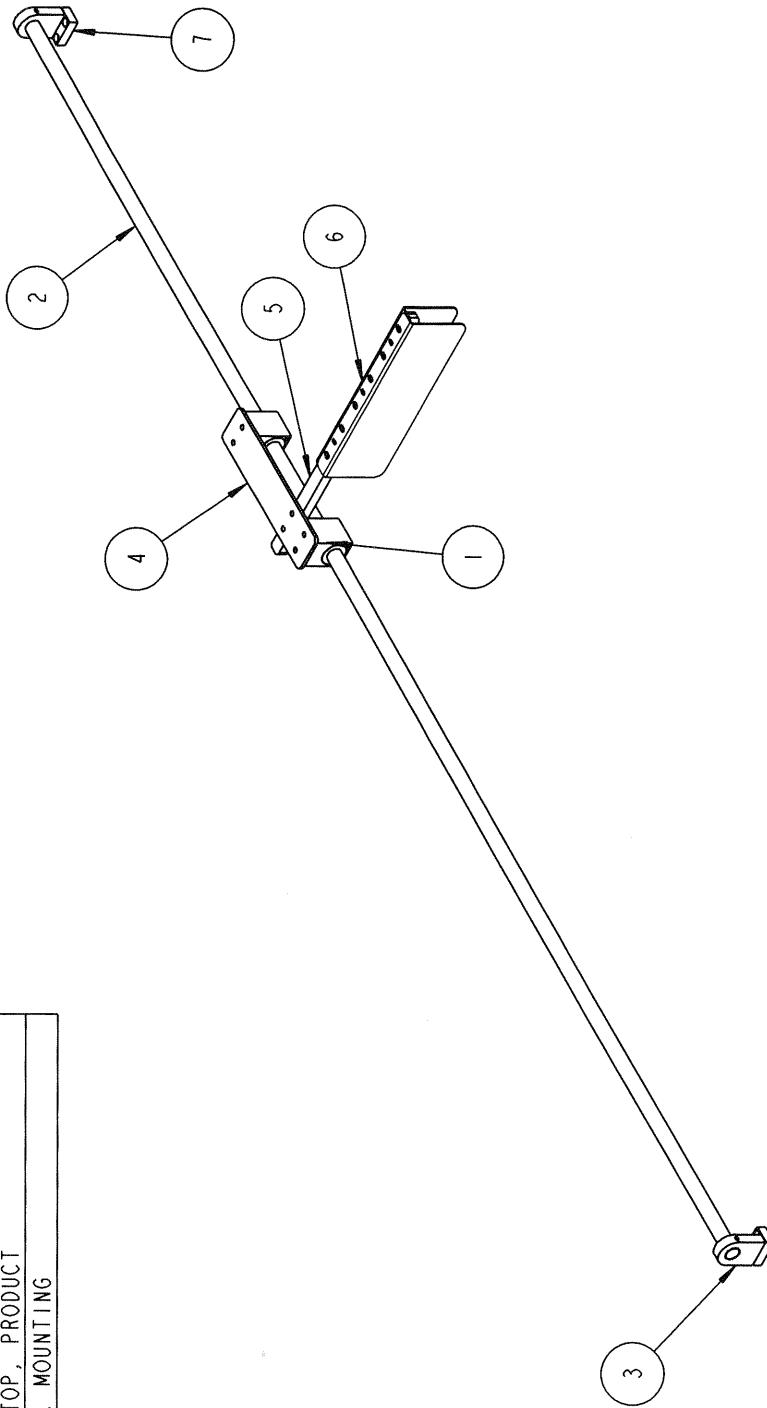


REV NO	DATE	DESCRIPTION	ECN NO	BY
1	KR345L			

REQ'D	WHERE USED

DRAWN BY:		SCALE	MATERIAL:	THIRD ANGLE PROJECTION	PROPRIETARY AND CONFIDENTIAL
T JG		0 . 125	X X X		KIRK - RUDY, INC. WOODSTOCK, GEORGIA
CHECKED BY:	DATE	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED			NO PORTION OF THIS DRAWING MAY BE COPIED OR REPRODUCED IN WHOLE OR IN PART, OR COMMUNICATED EXPRESSLY WITH THE WRITTEN PERMISSION OF KIRK-RUDY WOODSTOCK, GA 30188 USA
		.XX .XXX .005 .5	ANG.		
TRACED BY:	MASTER	HEAT TREAT:	X X X	MODEL: SA341	TITLE: ASSY, BACKSTOP RH
		FINISH:	X X X	SHEET NO. 1 OF 1	DRAWING #
		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
1	2	537280-01	ASSY, BUSHING BLOCK
2	1	544460-02	SHAFT, BACKSTOP LINEAR GUIDE
3	2	544461-01	BAR, SHAFT SUPPORT
4	1	544462-01	BRACKET, BEARING MOUNT
5	1	544463-01	BAR, BACKSTOP SUPPORT
6	2	544464-02	BACKSTOP, PRODUCT
7	2	544465-01	PLATE, MOUNTING



ITEM	QTY	PART #	DESCRIPTION	REV NO	DATE	ECN NO	BY
1	2	537280-01	ASSY, BUSHING BLOCK				

I	SA341-1
REQ'D	WHERE USED
PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE QUOTED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC. WOODSTOCK, GA 30188 USA	
THIRD ANGLE PROJECTION	
MATERIAL:	X X X
DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	X X .XXX ANG.
XX	.01 .005 .5
HEAT TREAT:	X X X
DATE	11 - Apr - 06
REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED	
MASTER	ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY
TRACED BY:	SHEET # OF 1
	DRAWING #
	544459-04

ITEM	QTY	PART #	DESCRIPTION	REV	NO.	DATE	DESCRIPTION	REV	NO.
1	15	107336	BOLT, HEX HEAD 5/16-18X .75				WIND CONTROL PANEL TO OPPOSITE SIDE AND BOTTOM LINE PLATES		
2	1	110132	SPRKTL, 35B 11 .625B .188K						
3	1	110142	SPRKTL, 35B 12 .625B .188K						
4	5	190620	CASTER-2.5IN. SWIVEL						
5	5	190634	FOOT, MOUNTING						
6	1	190619-1	PLATE, NAME						
7	1	191029-1	PUMP, MOYOTE C PBA612FC						
8	1	202263-7	SENSOR, PERFECT PROX						
9	5	501812-1	LEG, LEVELING						
10	1	530344-05	BOX, ELECTRICAL INLET 20A						
11	1	530575-06	WELDMENT, CONVEYOR OUTFIT GUARD						
12	1	530575-12	WELDMENT, CONVEYOR OUTFIT GUARD						
13	1	530759-08	ROD, HOLDER						
14	4	530760-01	ROD, STOP						
15	2	537658-02	BAR, PLATE SPLICE						
16	2	538171-04	ASSY, 1/4HP GEARHEAD W/CLUTCH						
17	2	539424-01	ASSY, RH HYDRAULIFT LEG						
18	2	539425-01	ASSY, LH HYDRAULIFT LEG						
19	1	544091-02	WLDML, SHELF MAIL TRAY						
20	1	544102-02	WLDML, CONVEYOR LEG						
21	1	544102-03	WLDML, LEG KR345/TURNOVER						
22	1	54416-01	COVER, CHAIN LEG						
23	1	54416-02	COVER, CHAIN LEG						
24	1	54422-01	BRACKET, SHAFT MOUNT						
25	1	54427-01	SHAFT, REAR SUPPORT						
26	1	544335-02	ASSY, CONTROL PANEL KR345						
27	2	54446-02	BAR, TABLETOP MOUNT						
28	2	54446-03	BAR, TABLETOP MOUNT						
29	1	544470-03	CHANNEL, CONVEYOR CABINET RH						
30	1	544470-04	CHANNEL, CONVEYOR CABINET LH						
31	1	544470-05	CHANNEL, CONVEYOR CABINET RH						
32	1	544470-06	CHANNEL, CONVEYOR CABINET LH						
33	8	54447-01	SHAFT, FRAME SPACER						
34	1	544474-02	BRACKET, CONTROL BOX MOUNT						
35	1	544489-01	PANEL, ELECTRICAL KR345						
36	1	544517-01	COVER, E-BOX KR345						
37	1	544518-01	COVER, E-BOX HOLE						
38	2	548493-01	SPACER, STRIP TABLETOP						
39	3	548496-01	BRACKET, TABLETOP SUPPORT						
40	6	548497-01	BLOCK, SHAFT CLAMP						
41	1	548868-01	WLDML, BRACKET 345/CMC 400						
42	2	548868-01	BAR, LEG SPACER						
43	1	548868-01	SPACER, CASTER						
44	1	MAIL-TRAY	MAIL-TRAY						
45	15	WA012	WASHER, FLAT 5/16						

FIELD WHERE USED

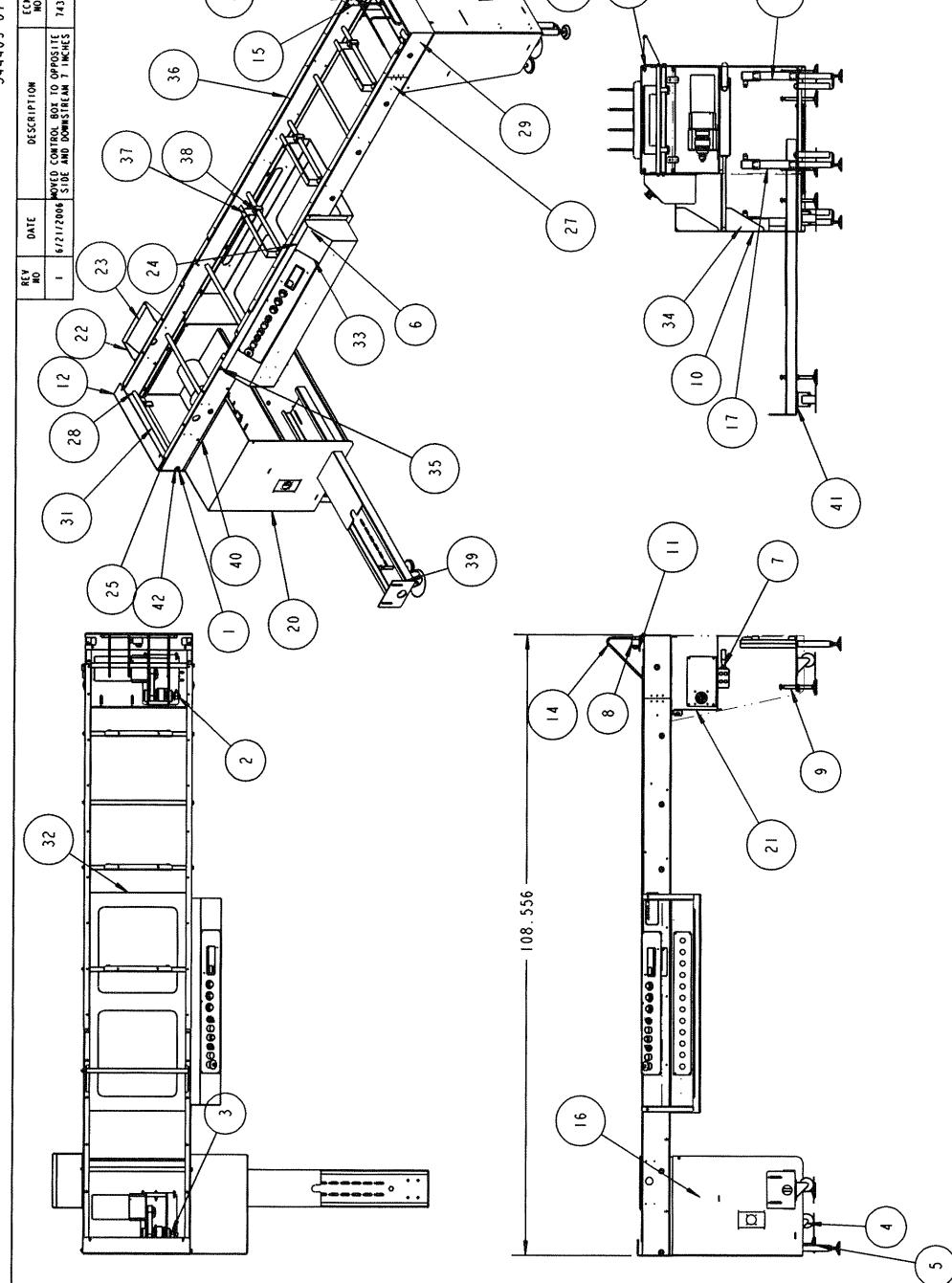
T JG		SCALE	0 .050	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED		PROPRIETARY AND CONFIDENTIAL NOT FOR DISTRIBUTION OR RELEASE TO OTHERS WITHOUT THE EXPLICIT WRITTEN PERMISSION OF KRK - RUDY, INC. WOODSTOCK, GA 30188 USA	
CHECKED BY:		DATE	03-06-05	.005	.005	NET TOLERANCE:	XXX
TRADED BY:		MATERIAL				STAINLESS STEEL	XXX
						ALL DIMENSIONS ARE IN INCHES. DRAWINGS ARE NOT SCALE DRAWINGS DO NOT DILATE OR CONTRACT	

DRAWING #

544469-06

1 SA397

ITEM	QTY	PART #	DESCRIPTION	REV	NO	DATE	ECN	NO	BY
1	15	107336	BOLT, HEX HEAD 5/16-18X .75						
2	1	110132	SPRKIT, 35B 11 625B .188K						
3	1	110142	SPRKIT, 35B 12 625B .188K						
4	5	190620	CASTER-2.5IN. SWIVEL						
5	5	190634	FOOT, MOUNTING						
6	1	190619-1	PLATE, NAME						
7	1	191029-1	PUMP, MOYOTEC PB4612FC						
8	1	202263-7	SENSOR, PERFECT PROX						
9	5	501812-1	LEG, LEVELLING						
10	1	530341-05	BOX, ELECTRICAL INLET 20A						
11	1	530355-06	WELDMENT, CONVEYOR OUTED GUARD						
12	1	530351-12	WELDMENT, CONVEYOR OUTED GUARD						
13	1	530159-08	ROD, HOLDER						
14	4	530160-01	ROD, STOP						
15	2	531765-02	BAR, PLATE SPLICE						
16	2	538171-04	ASSY, 1/4HP GEARHEAD W/CLUTCH						
17	2	539424-01	ASSY, RH HYDRALIFT LEG						
18	2	539425-01	ASSY, LH HYDRALIFT LEG						
19	1	544102-02	WLDMT, CONVEYOR LEG						
20	1	544102-04	WLDMT, LEG KR345/TURNOVER RH						
21	1	544165-01	COVER, CHAIN LEG						
22	1	544222-01	BRACKET, SHAFT MOUNT						
23	1	544223-01	SHAFT, REAR SUPPORT						
24	1	544335-02	ASSY, CONTROL PANEL KR345						
25	2	544465-02	BAR, TABLETOP MOUNT						
26	2	544466-03	BAR, TABLETOP MOUNT						
27	1	544470-03	CHANNEL, CONVEYOR CABINET RH						
28	1	544470-04	CHANNEL, CONVEYOR CABINET LH						
29	1	544470-05	CHANNEL, CONVEYOR CABINET RH						
30	1	544470-06	CHANNEL, CONVEYOR CABINET LH						
31	8	544472-01	SHAFT, FRAME SPACER						
32	1	544474-02	BRACKET, CONTROL BOX MOUNT						
33	1	544489-01	PANEL, ELECTRICAL KR345						
34	1	544517-01	COVER, E-BOX KR345						
35	1	544518-01	COVER, E-BOX HOLE						
36	2	546493-01	SPACER, STRIP TABLETOP						
37	3	548196-01	BRACKET, TABLETOP SUPPORT						
38	6	548497-01	BLOCK, SHAFT CLAMP						
39	1	548668-01	WLDMT, BRACKET 345/CMC 400						
40	2	548684-01	BAR, LEG SPACER						
41	1	548689-01	SPACER, CASTER						
42	15	WA012	WASHER, FLAT 5/16						



1	544469-07	RED 0 WHERE USED
KIRK - RUDY INC		
KIRK - RUDY INC		
WOODSTOCK, GEORGIA		

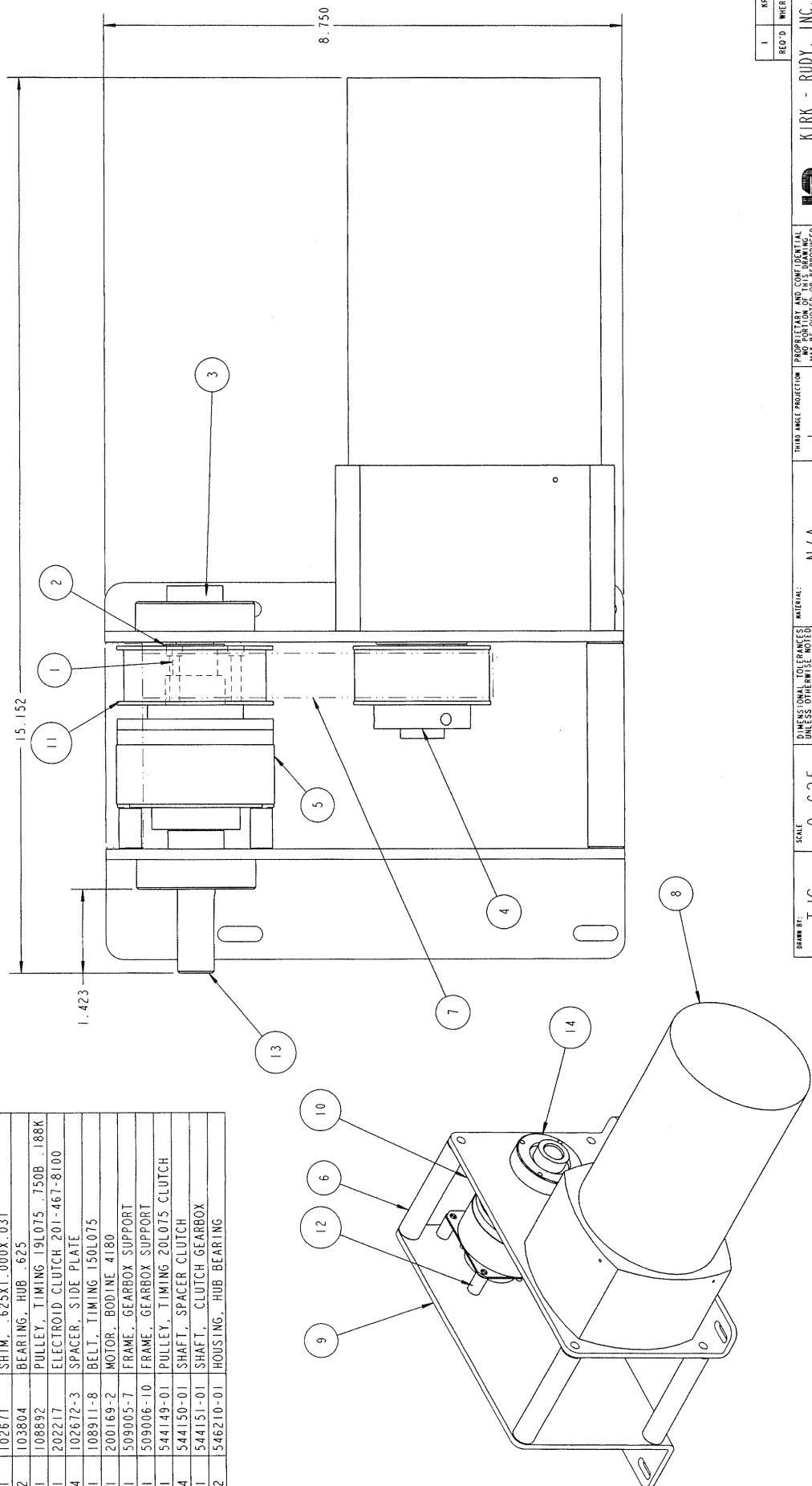
1	544469-07	RED 0 WHERE USED
ASSY, CONVEYOR FRAME RH		
ASSY, CONVEYOR FRAME RH		
544469-07		

DRAWING BY:		SCALE	0 .050	DIMENSIONAL TOLERANCES		MATERIAL		THIRD ANGLE PROJECTION	
				IN	MM	IN	MM	IN	MM
CHECKED BY:		DATE	08-Aug-05	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED		HEAT TREAT:	XXX	PROJECTION	XXX
TRACTED BY:		MASTER		ALL DIMENSIONS ARE IN INCHES		TIME:	XXX	REMOVED	XXX
				DO NOT SCALE DRAWINGS				NOTICE	XXX

DRAWING #

538171-04

ITEM QTY	PART #	DESCRIPTION	REV NO	DATE	ECN NO	BT
1	1 100258	BUSHING, SL 62510D .75000-.50016				
2	1 103671	SHIM, 623X1.00X.031				
3	2 103804	BEARING, HUB .625				
4	1 103892	PULLEY, TIMING 9L075 .750B .188K				
5	1 202117	ELECTROD CLUTCH 201-1467-8100				
6	4 103672-3	SPACER, SIDE PLATE				
7	1 103911-8	BELL, TIMING 150L075				
8	1 200169-2	MOTOR, BODINE 4180				
9	1 503005-7	FRAME, GEARBOX SUPPORT				
10	1 503006-10	FRAME, GEARBOX SUPPORT				
11	1 544149-01	PULLEY, TIMING 20L075 CLUTCH				
12	4 544150-01	SHAFT, SPACER CLUTCH				
13	1 544151-01	SHAFT, CLUTCH GEARBOX				
14	2 546210-01	HOUSING, HUB BEARING				



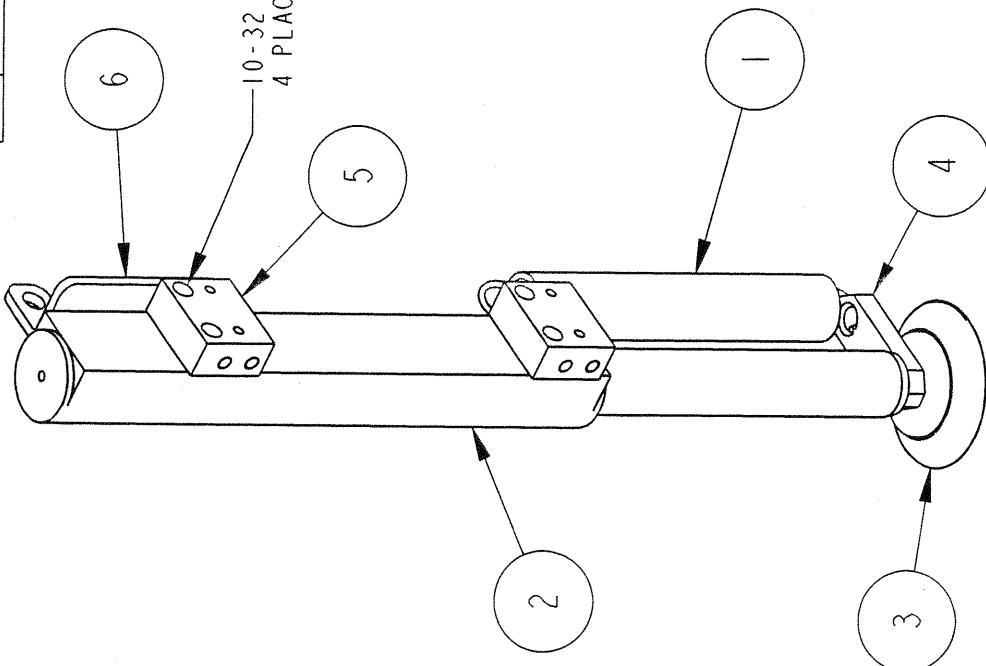
I	KB345
REC'D WHERE USED	
KIRK - RUDY, INC	
WOODSTOCK, GEORGIA	
KR	
PROPRIETARY AND CONFIDENTIAL	THIRD ANGLE PROJECTION
ALL DRAWINGS ARE IN INCHES	PRINTED ON ONE SIDE OF THE
EXCEPT AS NOTED	PAPER AND ARE TO BE READ
EXCEPT AS NOTED	FROM THE REVERSE SIDE
EXCEPT AS NOTED	IN THE DIRECTION OF THE
EXCEPT AS NOTED	ARROW
EXCEPT AS NOTED	PRINTED ON ONE SIDE OF THE
EXCEPT AS NOTED	PAPER AND ARE TO BE READ
EXCEPT AS NOTED	FROM THE REVERSE SIDE
EXCEPT AS NOTED	IN THE DIRECTION OF THE
EXCEPT AS NOTED	ARROW

SCALE 0.375

DRAWING #:	SCALE	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	MATERIAL:	HEAT TREAT:	REMOVED ALL SURFACES AND DETAILED AS SHOWN	NOTES:
T JG	0 .625		N / A	N / A		
CHECKED BY:	DATE	IN .000 .000 .000				
TRACED BY:	MASTER	05 - MAY - 03	NONE	N / A	SHEET 1 OF 1	ASSY, 1/4HP GEARHEAD W/CLUTCH

DRAWING # 538171-04

ITEM QTY	PART #	DESCRIPTION
1	102792	SPRING, EXTENSION
2	191029-2	CYLINDER, LIFT CB415
3	191029-3	GLIDE, SUSPA
4	537371-01	BRACKET, SPRING RETURN MOUNT
5	537596-01	BLOCK, HYDRAULIC LIFT LH
6	537597-01	BRACKET, HYDRAULIC LIFT SPRING

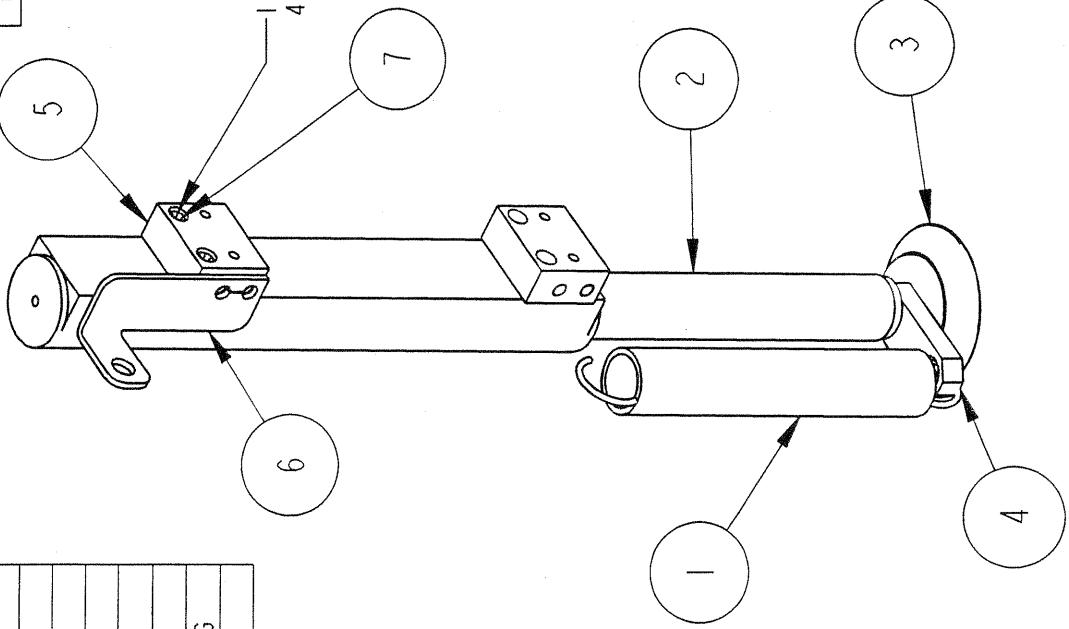


-10-32 CAP SCEW X .625 LONG
4 PLACES

RECD	SP84700
2	
DRAWN BY: A KEY	
SCALE	0 . 375
DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	
.XX	.XXX
.01	.005
ANG.	.5
HEAT TREAT:	
DATE 26 - JUL - 00	
CHECKED BY:	
TRACED BY:	
MASTER	
FINISH:	
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 COPIED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC. WOODSTOCK, GA 30188 USA	
THIRD ANGLE PROJECTION	
MODEL SP84700	
ASSY, RH HYDRAULIFT LEG	
SHEET NO. 1 OF 1	DRAWING #

ITEM QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	102792	SPRING, EXTENSION					
2	191029-2	CYLINDER, LIFT CB415					
3	191029-3	GLIDE, SUSPA					
4	537371-01	BRACKET, SPRING RETURN MOUNT					
5	537596-01	BLOCK, HYDRAULIC LIFT LH					
6	537597-02	BRACKET, HYDRAULIC LIFT SPRING					
7	CSDD266	SCREW, SHCS 10-32X.625					

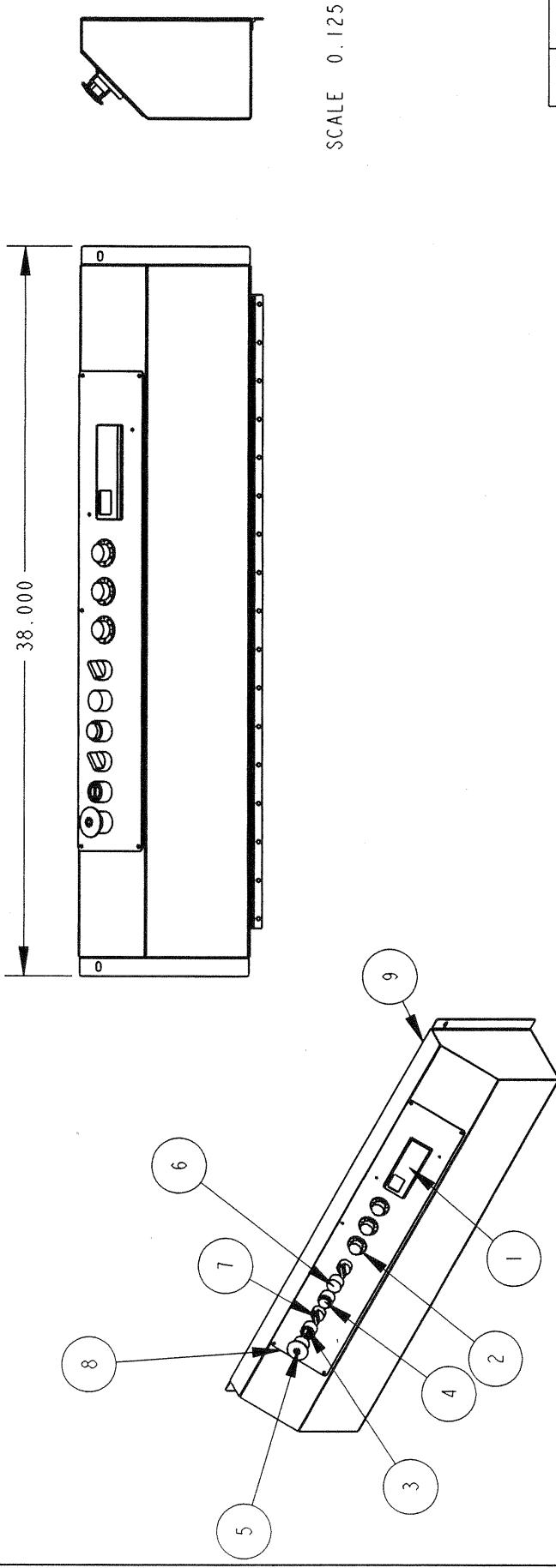
10-32 CAP SCREW X .625 LONG
4 PLACES



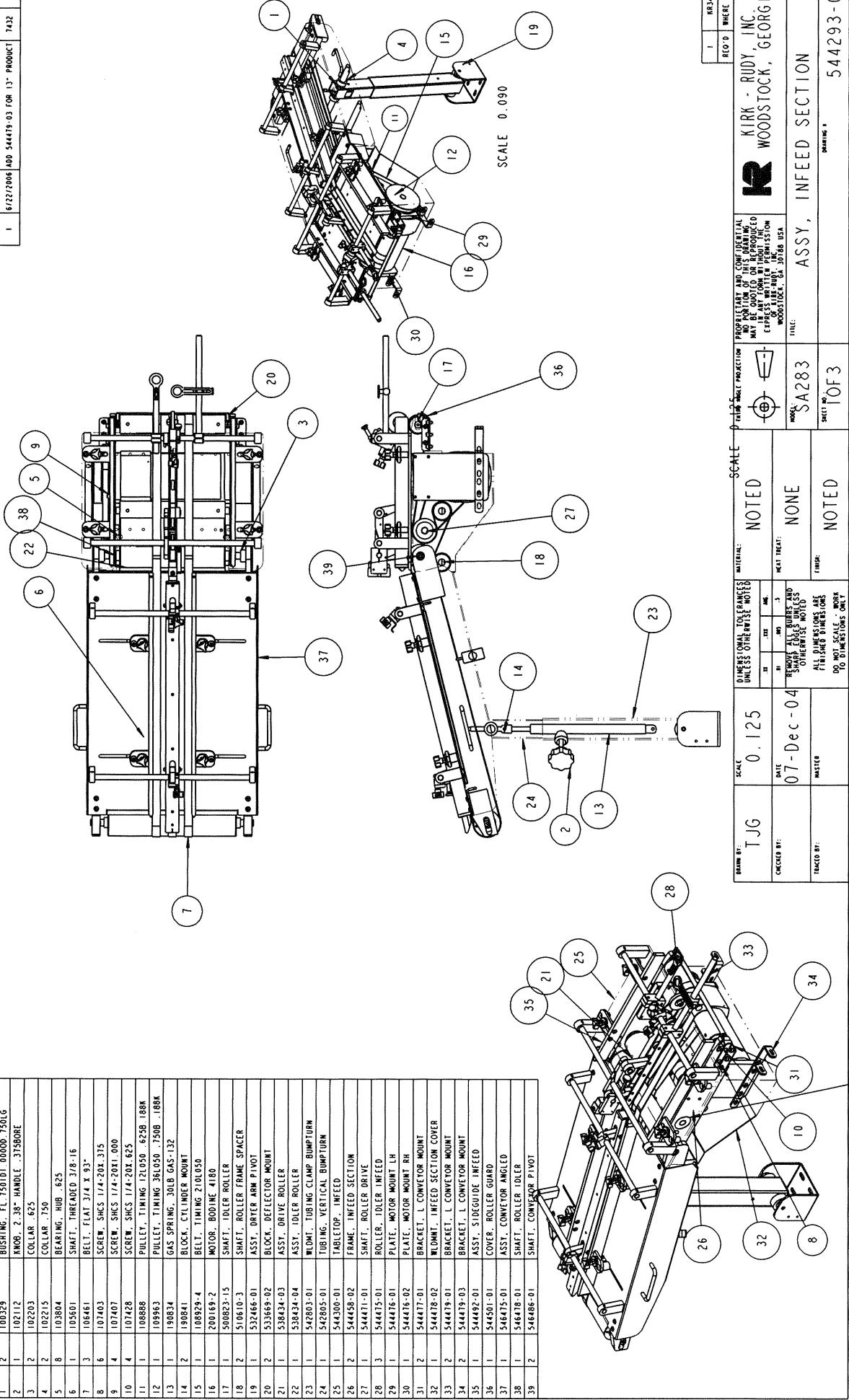
2	SP84700
REQ'D	WHERE USED
KIRK - RUDY, INC. K R WOODSTOCK, GEORGIA	
PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE QUOTED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC. WOODSTOCK, GA 30188 USA	
THIRD ANGLE PROJECTION	
NOTE:	ASSY, LH HYDRAULIFT LEG
SHEET NO. 10F1	DRAWING # 539425-01

DRAWN BY: A KEY	SCALE: 0 .375	MATERIAL: N/A	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	
			.01	.005
			ANG.	.5
CHECKED BY:	DATE: 26-JUL-00	HEAT TREAT:	N/A	
TRACED BY:	MASTER	FINISH:	N/A	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	202524			PLC, CROUZET		
2	3	209016			KNOB, POT		
3	1	201124-4			BUTTON, POWER ON		
4	1	201125-3			BUTTON, STOP		
5	1	201125-5			BUTTON, POWER OFF		
6	1	201126-1			BUTTON, JOG		
7	2	201145-1			SELECTOR, 2 POSITIONS		
8	1	544330-02			PANEL, SA341 KR345 CONTROL		
9	1	548431-01			WLDMT, CONTROL BOX COVER		

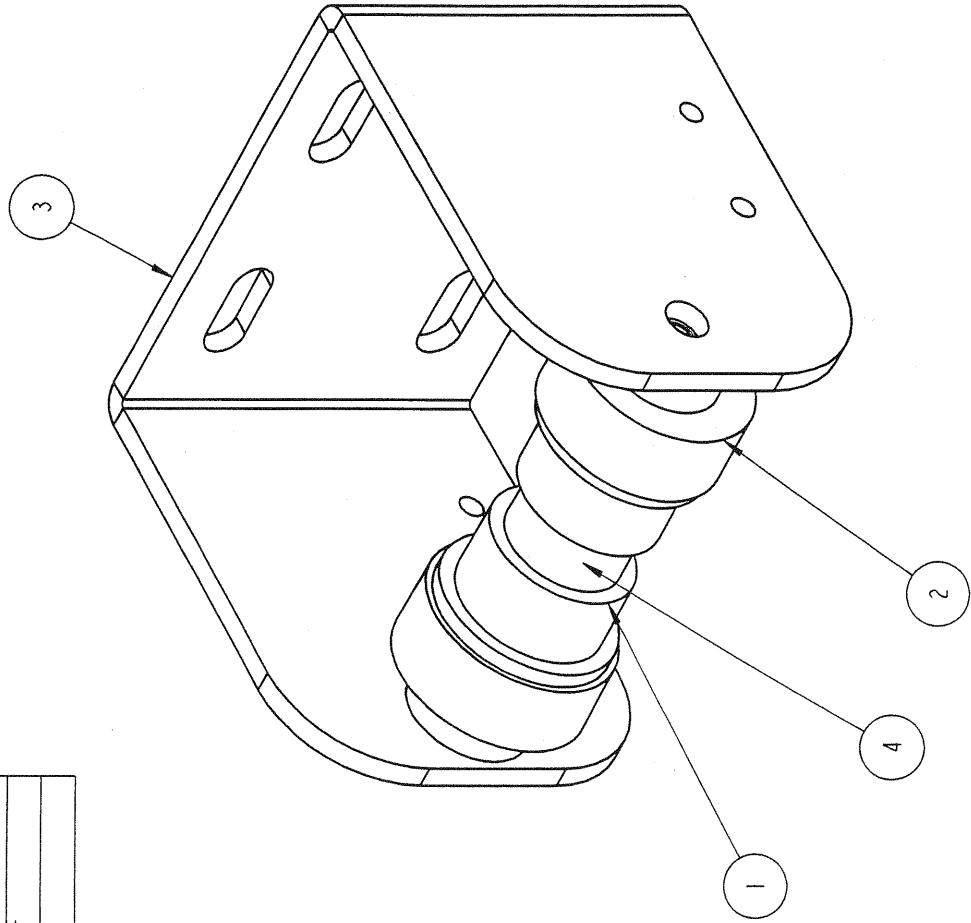


REV NO	DATE	DESCRIPTION	ECN NO	BT
1	6/22/2006	ADD 544479-03 FOR 13" PRODUCT	7432	TJG



A detailed technical diagram of a mechanical assembly, likely a component of a larger machine. The drawing shows a complex arrangement of gears, shafts, and structural elements. Several parts are labeled with numbers in circles: 8 at the bottom right, 10 near the center, 31 at the top right, 32 at the bottom left, 33 at the top left, and 34 at the top right. Other unlabeled parts include a large rectangular block on the left, a central vertical column, and a base structure.

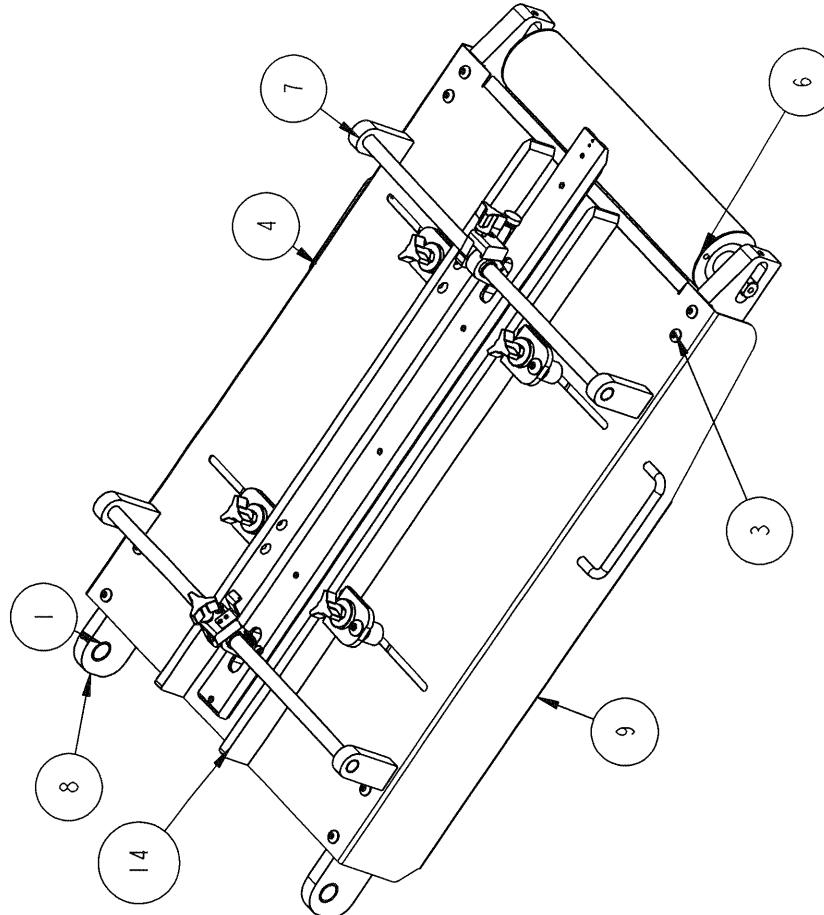
ITEM QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	2	100326 BUSHING, FLI. 0001DI.2500D.750LG					
2	2	102212 COLLAR 1.000					
3	1	532465-01 BRACKET, DRYER ARM PIVOT					
4	1	532467-01 SHAFT, DRYER PIVOT					



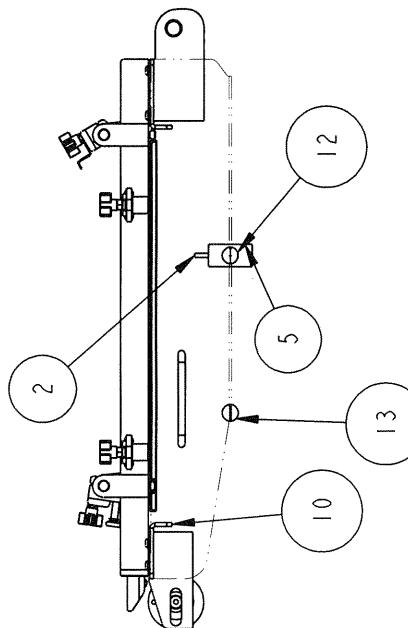
1	532734-01
REQ'D	WHERE USED
KR	KIRK - RUDY, INC. WOODSTOCK, GEORGIA
PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE QUOTED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC. WOODSTOCK, GA 30188 USA	
TIME:	ASSY, DRYER ARM PIVOT
SCALE:	0 . 750
DRAWN BY:	T JG
DATE:	20 - Feb - 98
CHECKED BY:	
TRACED BY:	MASTER
NOTES:	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED XX XXX .005 .005 ANG. .01 .005 5 HEAT TREAT: NONE REMOVE ALL BURRS AND SHARP EDGES, UNLESS OTHERWISE NOTED
ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE WORK TO DIMENSIONS ONLY	FINISH: NONE MODEL: SP62500 SHEET NO.: 0F1 DRAWING #: 532466 - 01

DRAWING #: 546475-01

ITEM QTY	PART #	DESCRIPTION	QTY NO	DATE	DESCRIPTION	QTY NO	BY
1	2	100238 BUSHING, SL 62510 .75000 .500LG	1	6/22/2006	SWITCHED SHAFTS FOR 08 ING AND BELT GUIDE	7432	136
2	6	105419 DOWEL, PIN 18X1.000					
3	8	106800 SCREW, BUTTON HEAD 1/4X .750					
4	2	190935 HANDLE					
5	3	500725 -13 GUIDE, BELT 3/4					
6	1	530619 -01 ASSY, IDLER ROLLER					
7	1	537284 -09 ASSY, SKID BAR BUMPTURN					
8	2	536476 -01 PLATE, INFEED RAMP BEARING					
9	1	546477 -01 TABLETOP, INFEED CONVEYOR					
10	1	546480 -01 BRACKET, TAKEUP BLOCK SPACER					
11	1	546480 -02 BRACKET, TAKEUP BLOCK SPACER					
12	1	546481 -01 SHAFT, SPACER CONVEYOR					
13	1	546481 -02 SHAFT, SPACER CONVEYOR					
14	1	546482 -01 ASSY, SIDEGUIDE INCLINE CONVEYOR					



SCALE	0 . 188	SCALE	0 . 250	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED		
CHECKED BY:	T JG	DATE	11 - Aug - 04	.005	.005	.005
TRACED BY:				REMOVE ALL SURGES AND SMOOTH ALL GROOVES AND DRAWS	REMOVE ALL SURGES AND SMOOTH ALL GROOVES AND DRAWS	REMOVE ALL SURGES AND SMOOTH ALL GROOVES AND DRAWS
		MASTER		FILE DOWN POINTS AND DO NOT SCALE WORK TO DIMENSIONS ONLY	N/A	N/A

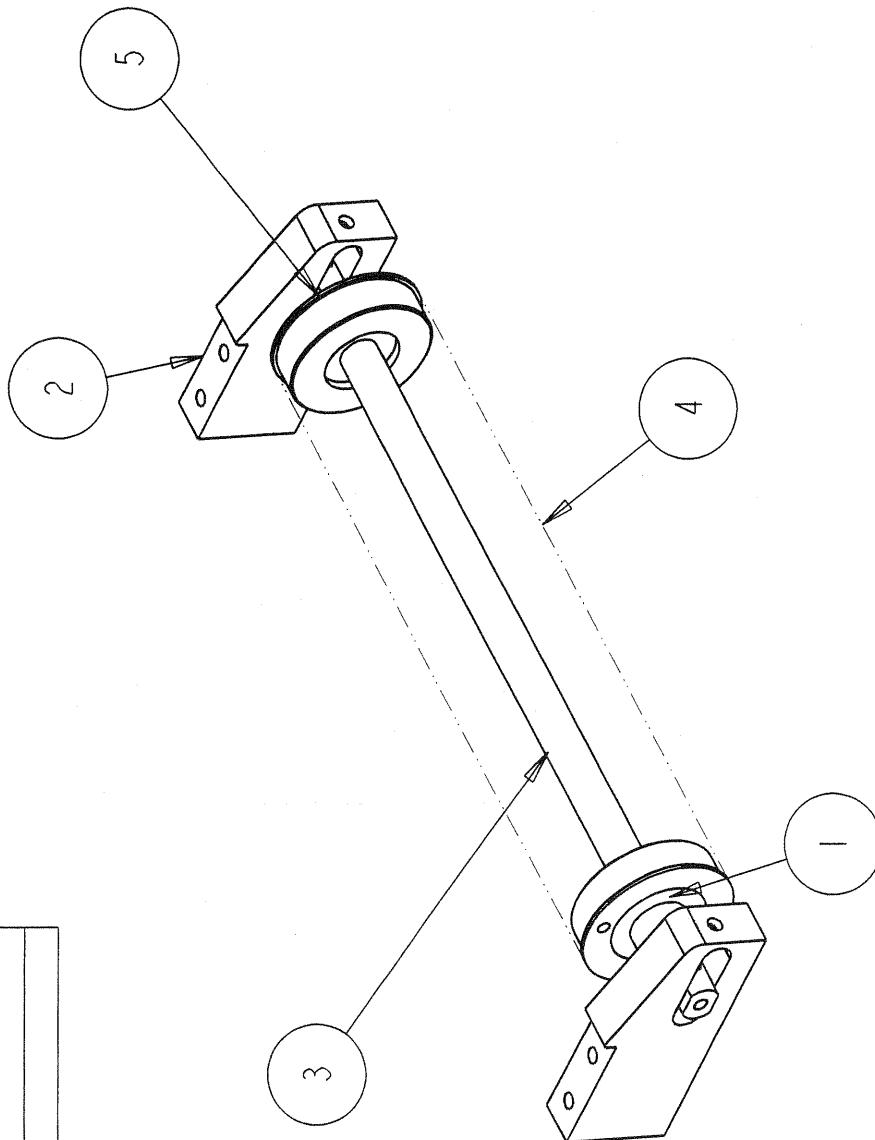


1	S4283	RECD WHERE USED
KR	KIRK - RUDY, INC	WOODSTOCK, GEORGIA
A283	ASSY, CONVEYOR ANGLED	111
546475 - 01		

DRAWING B 530619-0

530619-01

ITEM QTY	PART #	DESCRIPTION
1	2	103804 BEARING, HUB .625
2	2	500716 BRACKET - BELT TAKE-UP
3	1	500823 SHAFT, IDLER ROLLER
4	1	500835 ROLLER, BELT IDLER
5	2	500836 HUB



A technical drawing of an idler roller assembly. The drawing shows a central cylindrical roller with a keyway. A rectangular frame or housing is mounted over the top of the roller. Two triangular supports are attached to the frame, one on each side of the roller. A small circular component, labeled '5' with a leader line, is positioned above the frame. Another circular component, labeled '2' with a leader line, is positioned below the frame, near the bottom left corner of the drawing area.

REV NO	DATE	DESCRIPTION	ECN NO	BY

REF'D	215	WHERE USED
1		

IDENTICAL DRAWING PRODUCED AT THE MISSION C. 1986 USA	KIRK - RUDY, INC. WOODSTOCK, GEORGIA

ASSY, IDLER ROLLER

530619-01

RUDY, INC.
K, GEORGIA

ASSY | DIFER B01 | FEB
0188 USA

530619-01

15

REQ'D WHERE USED

JOY, INC.

GEORGIA

卷之三

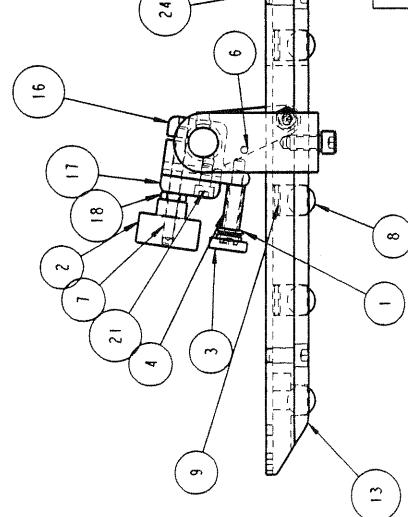
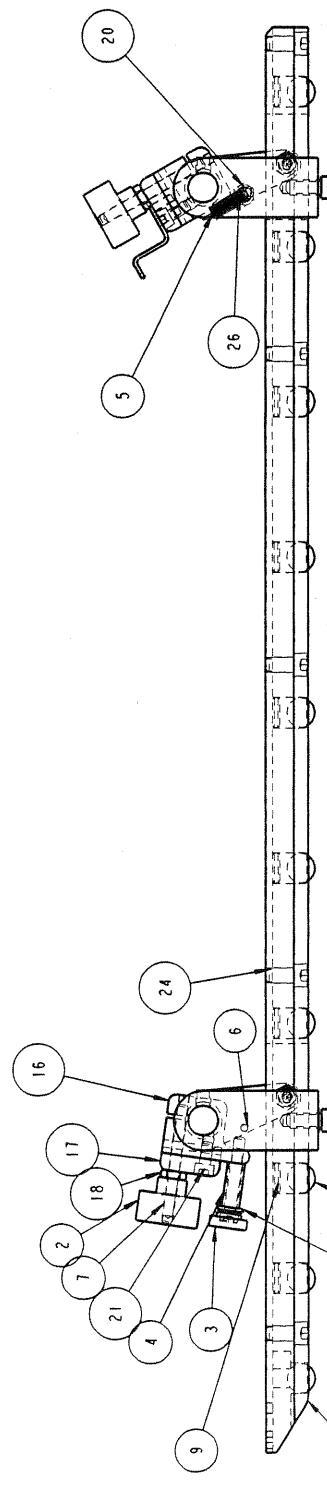
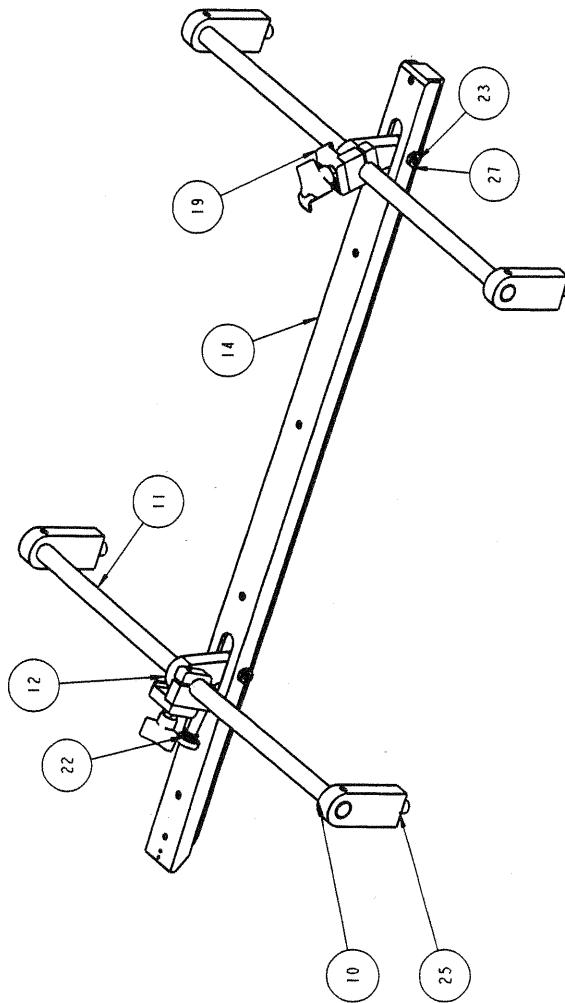
113

100

30190

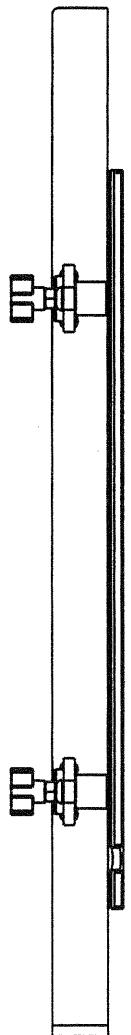
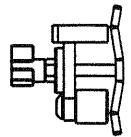
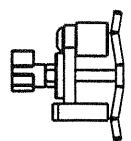
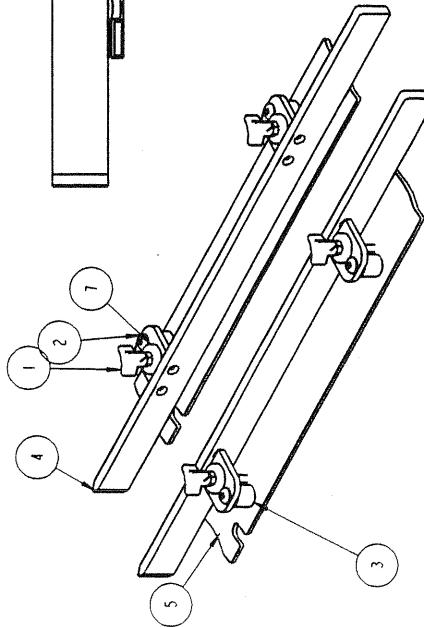
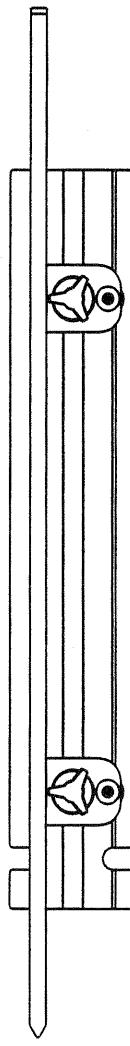
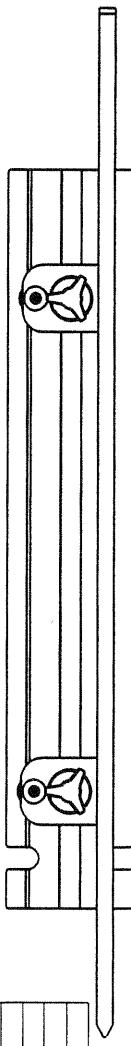
DRAWN BY:	TVK	SCALE	0 . 375	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED		MATERIAL:	N/A	THIRD ANGLE PROJECTION
CHECKED BY:		DATE	02 - Mar - 99	.xx	.005	ANG.		
TRACED BY:				REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED		HEAT TREAT:	N/A	MODEL: SP71700
				ALL DIMENSIONS ARE FROM INSIDE OUTSIDE		FINISHES:	N/A	SHEET NO.: OF 1
						MASTER		

ITEM/LOT	PART #	DESCRIPTION	REV NO.	DATE	ECN NO.	BY
1	1	LOCA-1				
		WASHED	A-1	10-10-02		



SCALE 0.500

ITEM / QTY	PART #	DESCRIPTION	REV. NO	DATE	DESCRIPTION	ECN NO	BY
1	4	500190-1 ASSY. TRI-KNOB 1/4-20 STUD					
2	4	541709-03 BRACKET, SIDEGUIDE					
3	4	541710-03 SPACER, SIDEGUIDE MOUNT					
4	2	546483-01 SIDEGUIDE, INCLINE CONVEYOR					
5	2	546484-01 STRIP, SIDEGUIDE CLAMP					
6	4	CSEF71 SCREW, BUTTON HEAD 5/16X .500					
7	4	SPG383-1 SPACER, GEAR COVER					



SCALE 0.375

DRAWING NO. T JG		SCALE 0.250	DIMENSIONS IN INCHES UNLESS OTHERWISE NOTED		TOLERANCE AND CONVENTIONAL		PROPRIETARY AND CONFIDENTIAL	
CHECKED BY:	DATED:		IN.	MM.	IN.	MM.	IN.	MM.
	07-Dec-04		.3	7.6	.3	7.6		
			THROUGH ALL Holes AND SHARP EDGES UNLESS OTHERWISE NOTED				EXCEPT AS SPECIFIED ON THIS DRAWING OR IN THE PARTS LIST	
			ALL SURFACES ARE FINISHED UNLESS OTHERWISE NOTED				ALL SURFACES ARE FINISHED UNLESS NOTED	
			DO NOT SCALE. WORK TO DIMENSIONS ONLY				DO NOT SCALE. WORK TO DIMENSIONS ONLY	

PRINTED ON 07-DEC-04 BY KIRK-RUDY, INC.
WOODSTOCK, GEORGIA

1	RE245	RECD WHERE USED

PRINTED ON 07-DEC-04 BY KIRK-RUDY, INC.
WOODSTOCK, GEORGIA

8.0 ELECTRICAL SCHEMATICS AND PARTS



WARNING

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

8.1 SCHEMATIC NUMBER LIST

Schematic # 210 455 0004

The following wiring diagrams are supplied in a separate package and enlarged with your manual for your reference. A reference of drawing symbols is also provided.

210 Schematic, SA341-1 KR345 Vertical Edge Stacker

SYMBOLS.ORC Schematic Symbols Reference

8.2 PARTS LIST

9.0 APPENDIX



WARNING

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

The following component's brochures are supplied in a separate package with your manual for your reference.

COMPONENT

DC Supply
DC Motor Board
Beam/prox switch
Interface

MANUFACTURER

International Power
Penta-KB
Banner
Crouzet

10.0 NOTES

11.0 WARRANTY AND SERVICE

WARRANTY

Warranty: Kirk-Rudy 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 OR 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 REPLACEMENT PARTS

For Service or Replacement Parts Please Call:

In the USA: Kirk-Rudy @PH 770-427-4203, FX 770-427-4036

In Europe: Grafibind @ PH 011-31-5553-41610