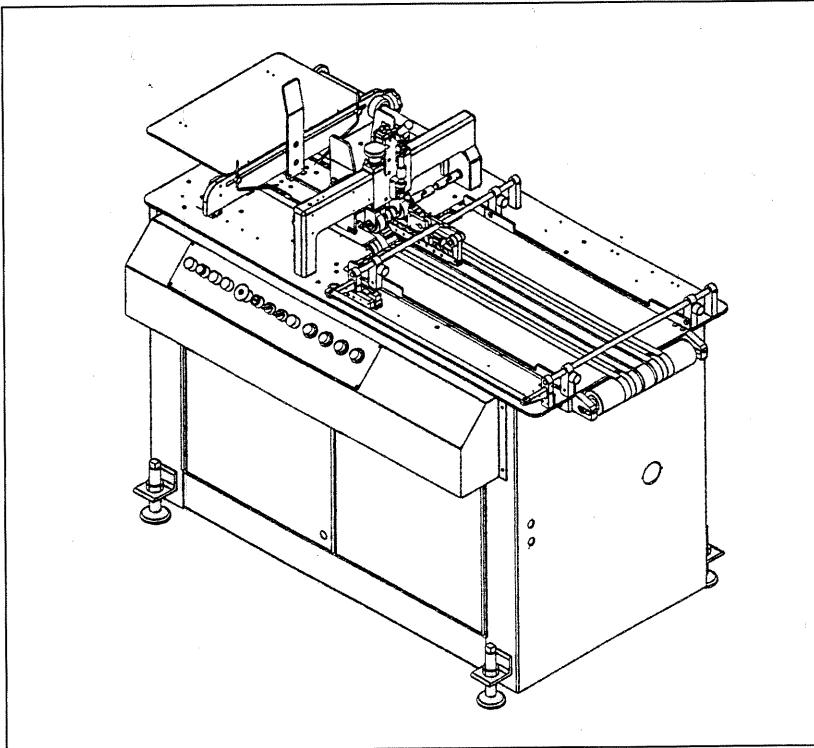


Kirk-Rudy, Inc.

Instruction and Parts Manual

KR215 Ink Jet Base Dual Motor Standard



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.

Instruction
and Parts Manual

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

1 Important Safety Instructions

Intended Use Statement: The KR215IJ base is a top load bottom feed transport designed to separate and feed product one at a time in a consistent manner.

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



WARNING

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

2 SPECIFICATIONS

<u>PRODUCT SIZE RANGE</u>	<u>English</u>	<u>Metric</u>
Minimum Size:	3" W x 5" L	7.6cm W x 12.7cm L
Maximum Size:	17" W x 16" L	43.2cm W x 40.6cm L
Minimum Thickness:	Card Stock (.007")	Card Stock (.10mm)
Maximum Thickness:	.625"	15.9 mm

PHYSICAL SIZE

Length	91"	231.1cm
Width	30.5"	77.5cm
Height	45"	114.3cm
Weight	1100 lbs	500 kg
Shipping	1325 lbs	601 kg

MAXIMUM CYCLE SPEED

30,000 cycles per hour

ELECTRICAL REQUIREMENTS

Main Power	220V, single phase, 60 cycle, AC 20 amps
Vacuum Pump	1/2 hp
Drive Motors	1/2 hp

3 INSTALLATION



WARNING

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

3.1 UNCRATING

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

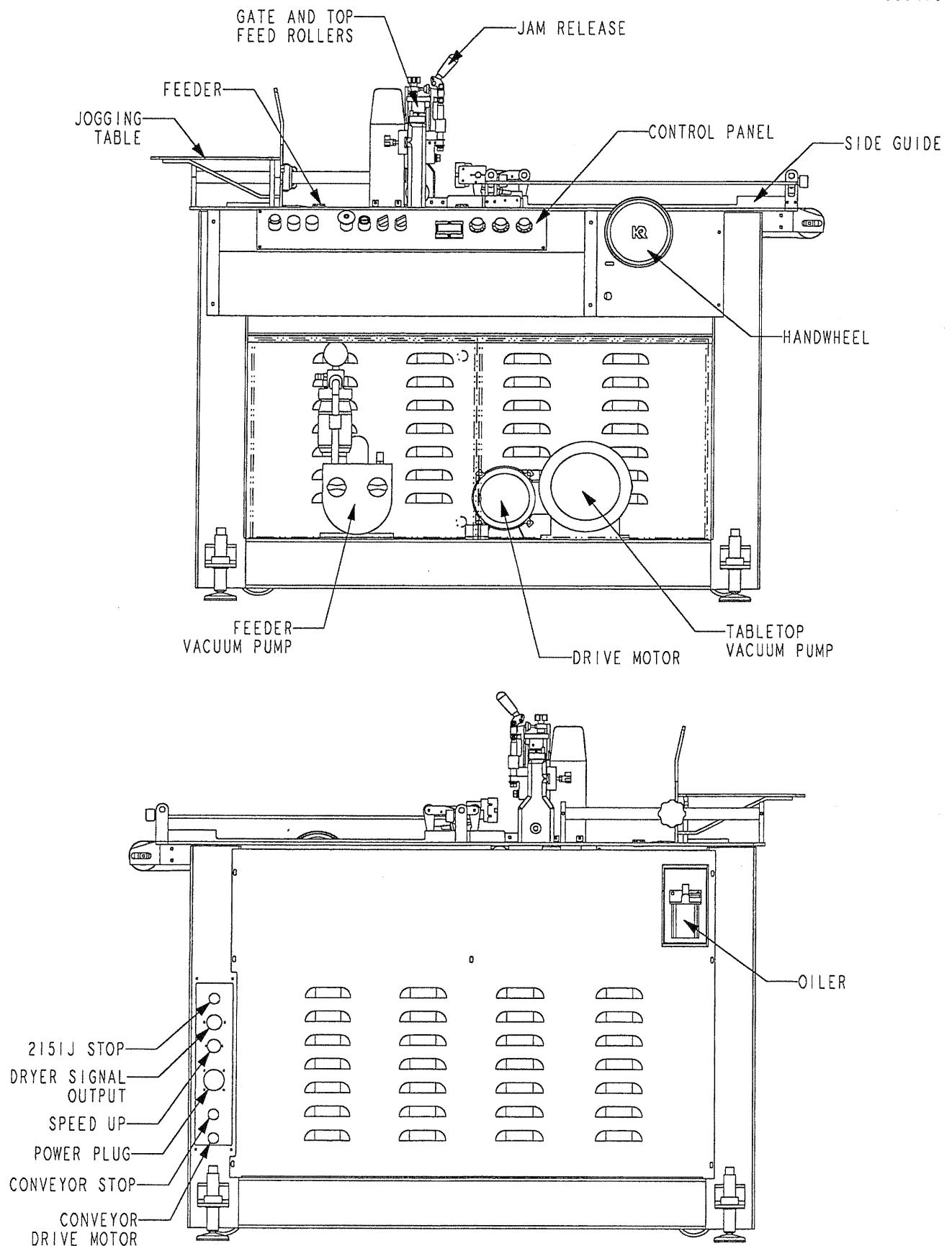
1. Position crate near installation site.
2. Remove crate top and sides.
3. Locate accessories box and verify all items are present.
4. Remove metal strapping and securing blocks.
5. Use forklift to lift machine off skid. Be sure to position the forks in a centrally located position.
6. Machine is on casters and can be rolled to desired location.
7. Adjust the height of the base with the four leveling legs.

3.2 ACCESSORIES AND SPARE PARTS

The accessories and spare parts are packaged and located inside the base cabinet. The box should be opened and checked against the enclosed packing list.

3.3 COMPONENT DESCRIPTION (see Figure 1.0)

1. JOGGER TABLE: Used to set the backstop for the product being fed. Can also be used to hold extra product.
2. FEEDER: Pushes product under gate and into feed rollers.
3. GATE: Prevents more than one piece of product from being fed at one time.
4. TOP FEED ROLLERS: Along with the lower feed rollers, feeds product through the bridge.
5. JAM RELEASE: Raises top feed rollers, so a jam can be cleared.
6. SIDE GUIDES: Keeps product from skewing while traveling on the tabletop.
7. HANDWHEEL: Used to move the feed shuttle by hand during setup.
8. OILER: Used to lubricate machine.
9. FEEDER VACUUM PUMP: Supplies vacuum to the feeder.
10. DRIVE MOTOR: Drives the feeder pushers and tabletop belts.
11. TABLETOP VACUUM PUMP: Supplies vacuum to the tabletop.
12. CONTROL PANEL (for more detail, see Section 4.1 and Figure 2.0): Contains operator controls.



KR215IJ MAJOR COMPONENTS
FIGURE 1.0

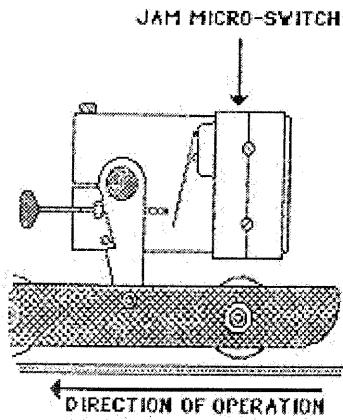
4 OPERATING INSTRUCTIONS

4.1 CONTROL PANEL (see Fig. 2.0)

1. STOP BUTTON: Stops the feeder when pressed and released.
2. JOG BUTTON: The machine will run as long as this switch is depressed. This switch is designed as an aid for set-up and will also stop the machine when pressed.
3. START BUTTON: Starts the machine.
4. POWER OFF / EMERGENCY STOP BUTTON: This is a latching switch. To turn power on, unlatch emergency stop. Press button to turn machine power off. The green light in the power button will turn off when power is off.
5. POWER BUTTON: Press button to turn machine power on. Emergency stop button must be unlatched. Button will glow green when machine is on.
6. VACUUM SELECTOR SWITCH: Turns on/off vacuum.
7. BLOWER SELECTOR SWITCH: Turns on/off blower.
8. COUNTER: Counts the product.
9. FEEDER SPEED CONTROL: Controls the speed of the feeder. “0” is minimum speed, “10” is maximum speed.
10. CONVEYOR SPEED CONTROL: Controls the speed of the conveyor. “0” is minimum speed, “10” is maximum speed.
11. CONVEYOR SPEED UP CONTROL: Controls how fast conveyor speeds up for zip code separation.

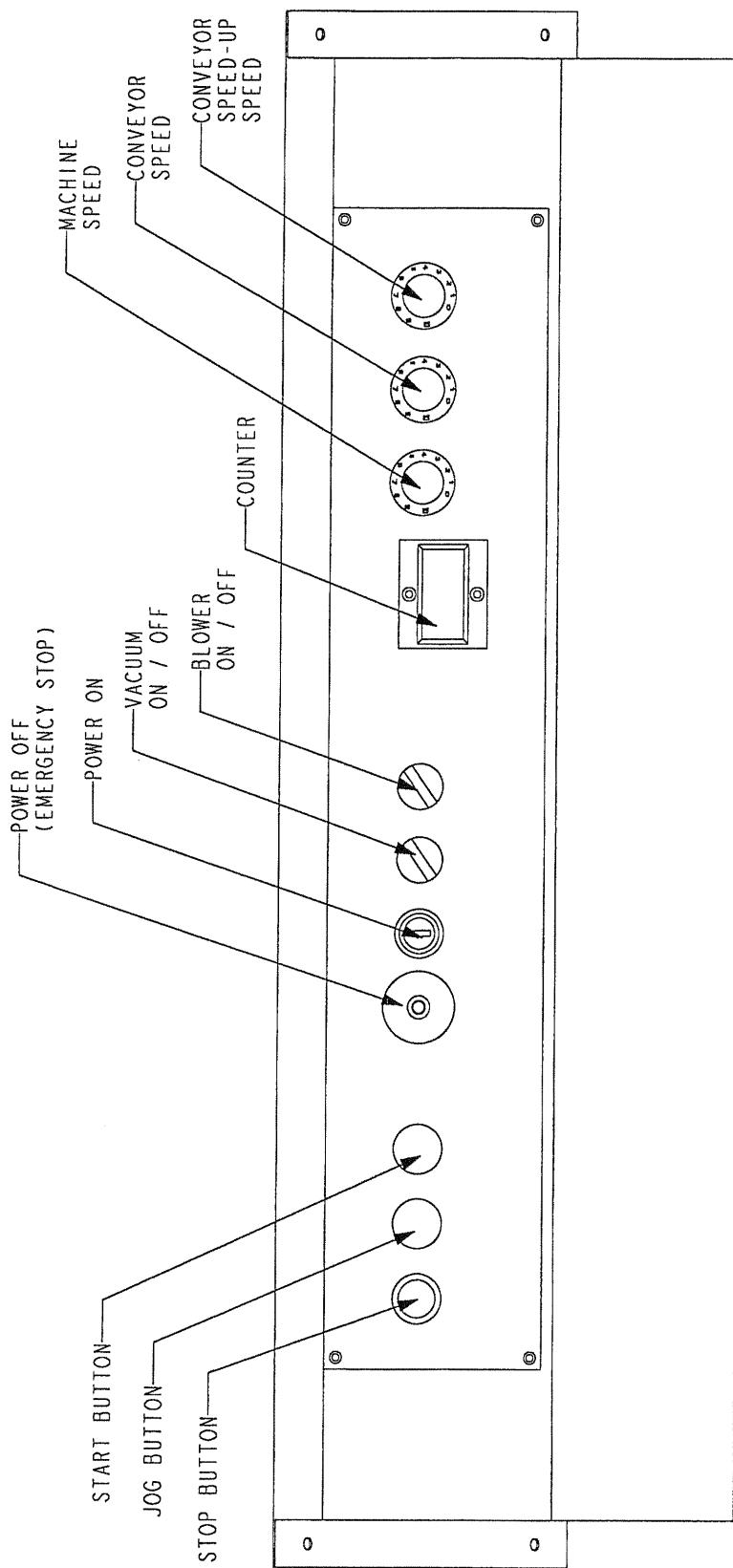
4.2 STOP CIRCUIT

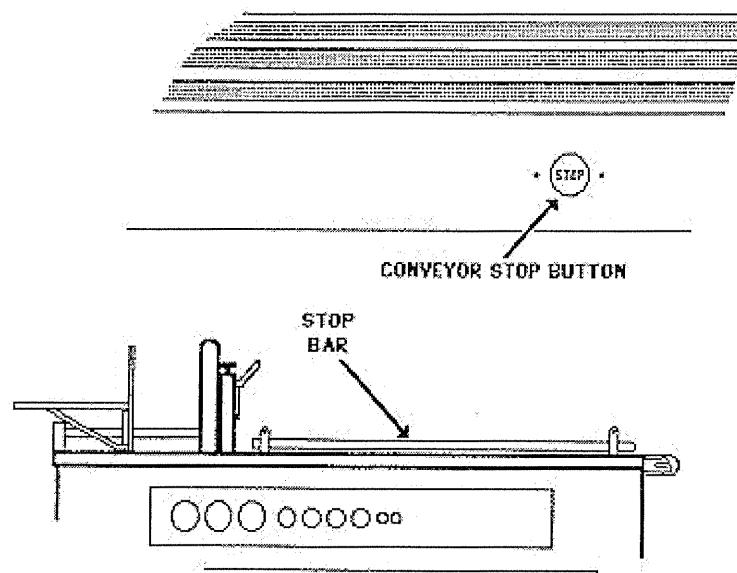
The stop circuit is wired in series, this means that if one of the stop switches or buttons is open, the machine will not run. There are four stop switches on the KR215IJ. They are the jam microswitch on the skid bar assembly (533821-01), the panic stop bar (535275-01), the conveyor stop button, and the control panel emergency stop button (Figure 2.0).



The switch that is open most often is the “jam microswitch” located on the skid bar (see Section 4.12).

The second switch that is most often open is the conveyor stop button. This button is usually open because of improper seating of the plug that goes into the back of the machine. If neither the machine nor the conveyor will run (conveyor power switch in “automatic” position) when the start button is depressed, check all the stop switches. If the machine will still not run, the problem must be isolated with a volt/ohm meter using the schematics.

KR215IJ CONTROL PANEL
FIGURE 2.0



4.3 SEQUENCE OF SET-UP

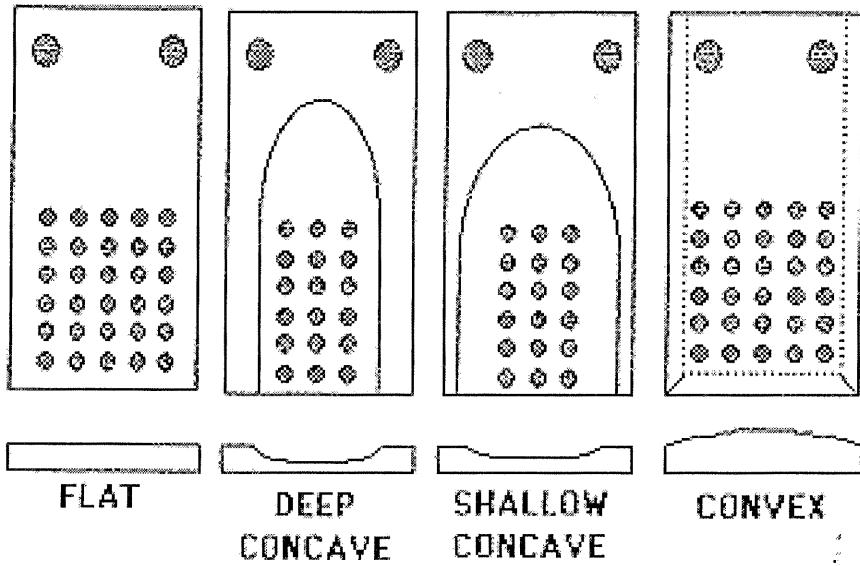
Note: Daily maintenance should be performed at the start of each day.

1. Select and install proper vacuum plate.
2. Set upper feed rollers.
3. Adjust gate.
4. Engage needle blocks, lifters and/or pusher blocks.
5. Adjust feed hopper product guides and backstop.
6. Adjust tabletop belts.
7. Position tabletop side guides.
8. Position skid bar(s).
9. Adjust vacuum.
10. Set shuttle feeder and tabletop speeds.

Insert KR215IJ09 & KR215IJ10

4.4 VACUUM PLATES

Before setting up the feeder, the correct vacuum plate should be selected and installed. There are four vacuum plates available for the KR215IJ.



FLAT PLATE: For thick product such as magazines and newspapers, any product that does not give or have bend to it.

DEEP CONCAVE PLATE: For thin product such as single sheets or flimsy product.

SHALLOW CONCAVE PLATE: For thicker product that has some flexibility.

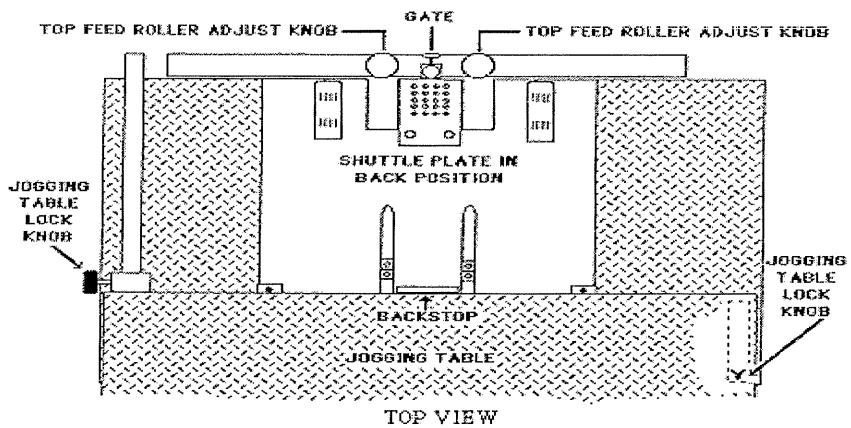
CONVEX PLATE: For tri-folded or self-mailers and can also be used for product that has a warp or bend. (Optional: not sent with machine.)

To change vacuum plates, remove the two 5/32" hex head screws in the rear of the plate and lift the plate out from the shuttle on the feeder. Insert the desired plate and re-install the two screws.

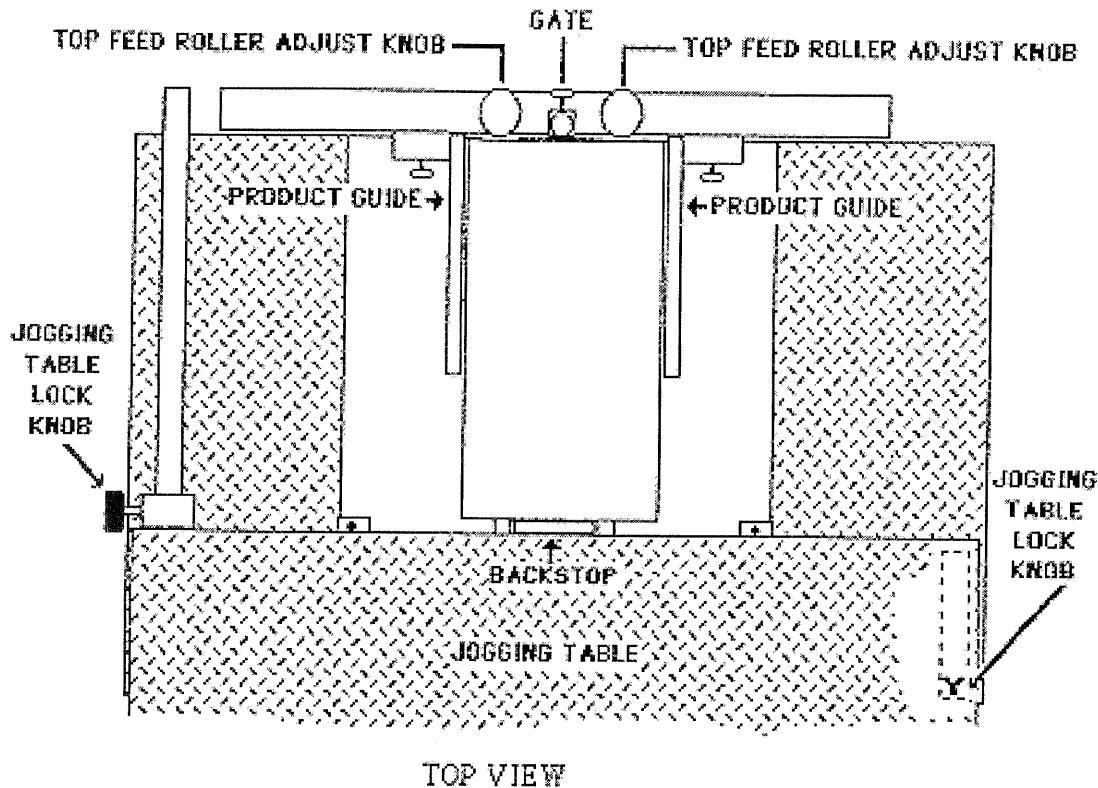
4.5 SHUTTLE/FEEDER SET-UP

To set up the feeder, loosen the back stop/jogging table and slide back. Loosen the two product guides and slide out from the center of the feeder.

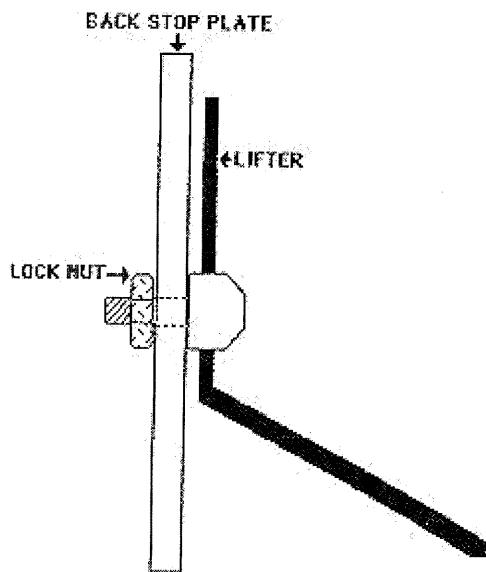
Rotate the machine by hand until the shuttle plate is in the extreme back position.



Place the product on the shuttle plate up against the gate. Bring the backstop up against the product and lock in place. Bring both product side guides in to the product. Allow approximately 1/8" play between guides and the product. Lock in place.



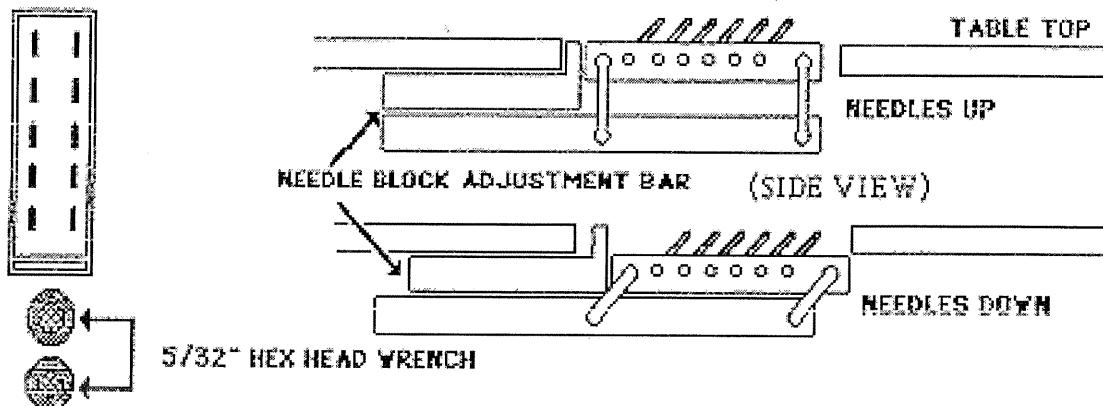
TOP VIEW



The feeder is equipped with lifters, needle blocks, and pushers to aid in the feeding of various products.

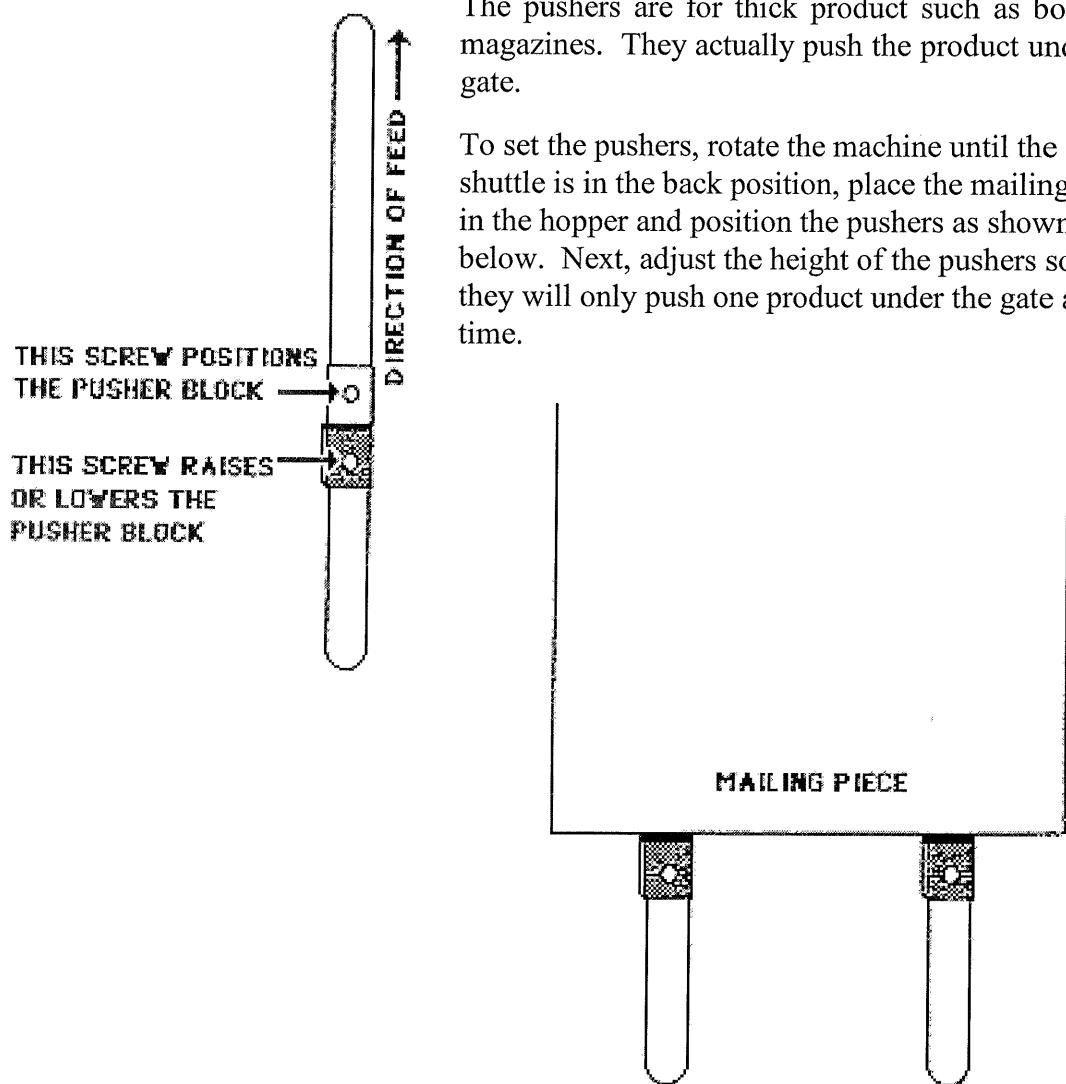
The lifters are designed to lift up the back of the product and angle the front edge toward the gate to aid in feeding. These are most commonly used for large products such as newspapers, magazines, and etc.

Optional: The needle blocks are designed to grab the product and help in the feed under the gate. The needle blocks can damage the product and are almost always used for newspapers. They are often used in conjunction with the lifters.



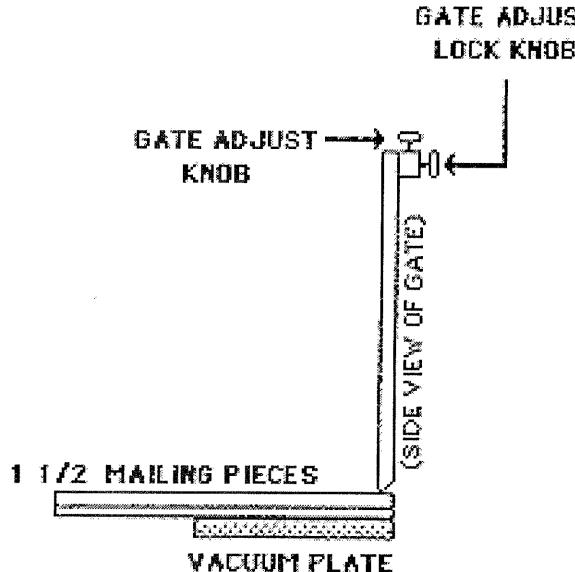
The pushers are for thick product such as books or magazines. They actually push the product under the gate.

To set the pushers, rotate the machine until the shuttle is in the back position, place the mailing piece in the hopper and position the pushers as shown below. Next, adjust the height of the pushers so that they will only push one product under the gate at a time.



4.6 GATE SET-UP

To set the gate, loosen the gate lock knob and turn gate adjust knob counter clockwise to raise the gate. Turn the main power and the feeder vacuum pump switches on. To rotate the gate, adjust the knob clockwise until the gate is snug against the mailing piece. (When setting up on a mailing piece that is two or more pages, the gate should be set snug to $1 \frac{1}{2}$ times the thickness of the mailing piece. Simply take $1 \frac{1}{2}$ pieces and place underneath the gate). After the gate is set, lock in place with the gate lock knob.

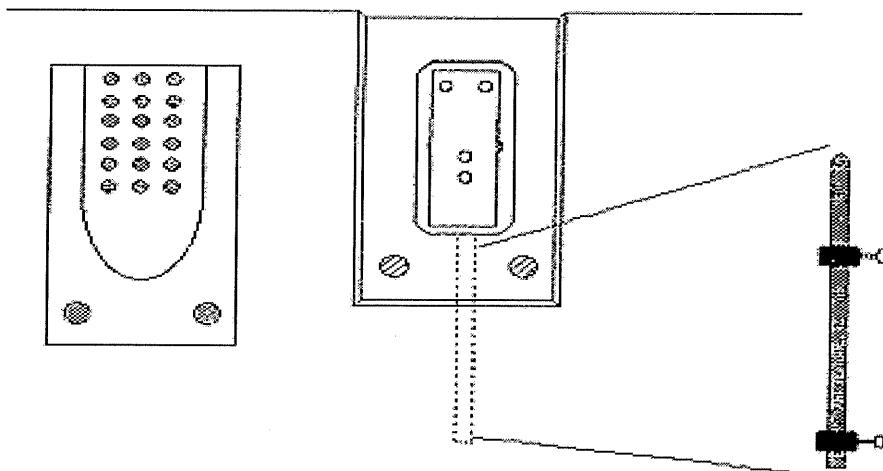


This should allow one piece to feed smoothly but keep two pieces from going under the gate at the same time. If two pieces are fed and the gate is set properly, the piece on top will jam or tear. If this happens, the problem is either the mailing pieces are stuck together or too much vacuum is being applied to the vacuum plate. To adjust the amount of vacuum being applied to the plate, see Section 4.6.

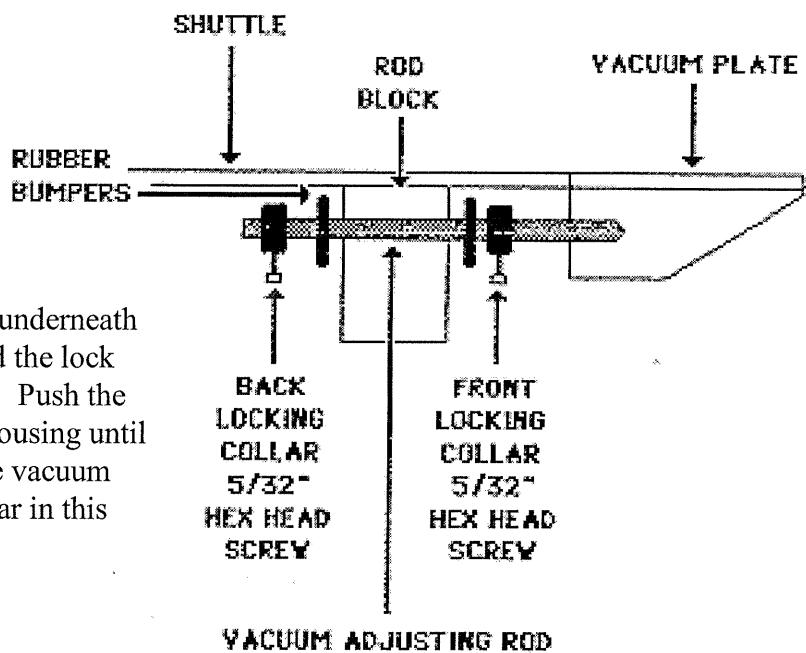
4.7 VACUUM TIMING AND TOP FEED ROLLER SET-UP

The vacuum connected to the vacuum plate is designed to come on $1/8"$ before the shuttle plate reaches the maximum backstroke. The vacuum connected to the vacuum plate should go off after the vacuum plate has transported the product underneath the gate and between the feed rollers. The lower feed rollers will come up.

The vacuum is turned on and off by two lock collars set-screwed to a rod that rides underneath the vacuum plate. When this rod is pushed in it turns the vacuum on and when it is pulled out the vacuum is turned off.

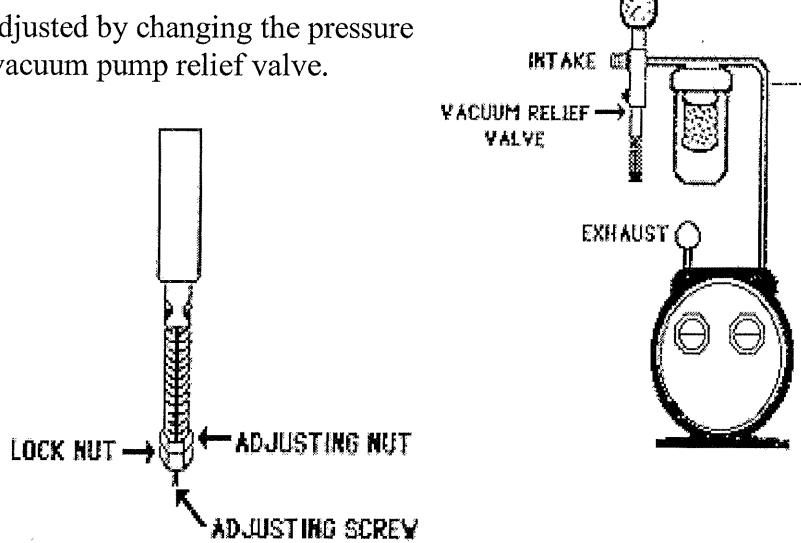


To adjust the vacuum on, turn the main power and feeder vacuum pump switches on and rotate the machine by hand until the shuttle plate is 1/8" from its maximum backstroke. Locate the front lock collar on the rod underneath the feeder and loosen. Hold the lock collar against the rod block. Push the rod into the vacuum plate housing until the vacuum comes on to the vacuum plate. Tighten the lock collar in this position.

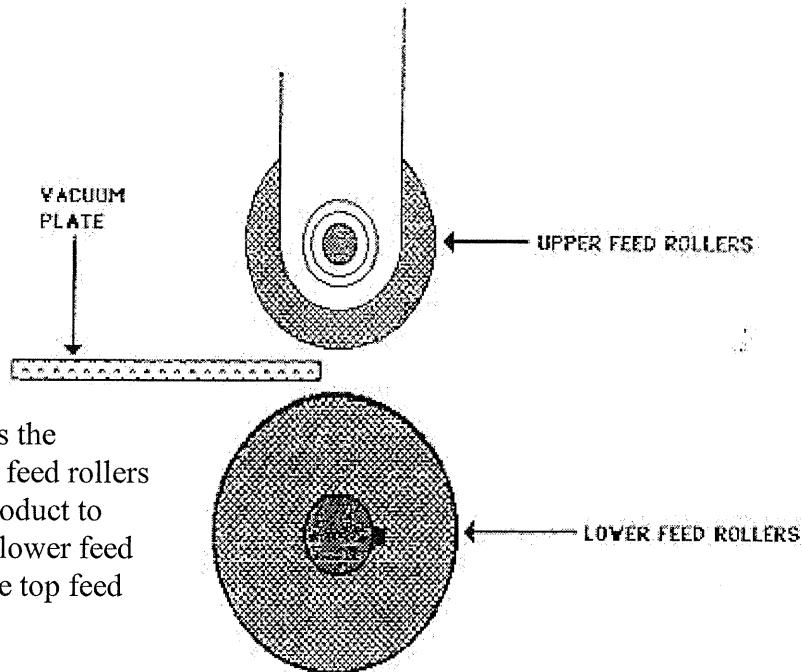


Vacuum to the plate can be adjusted by changing the pressure on the spring located on the vacuum pump relief valve.

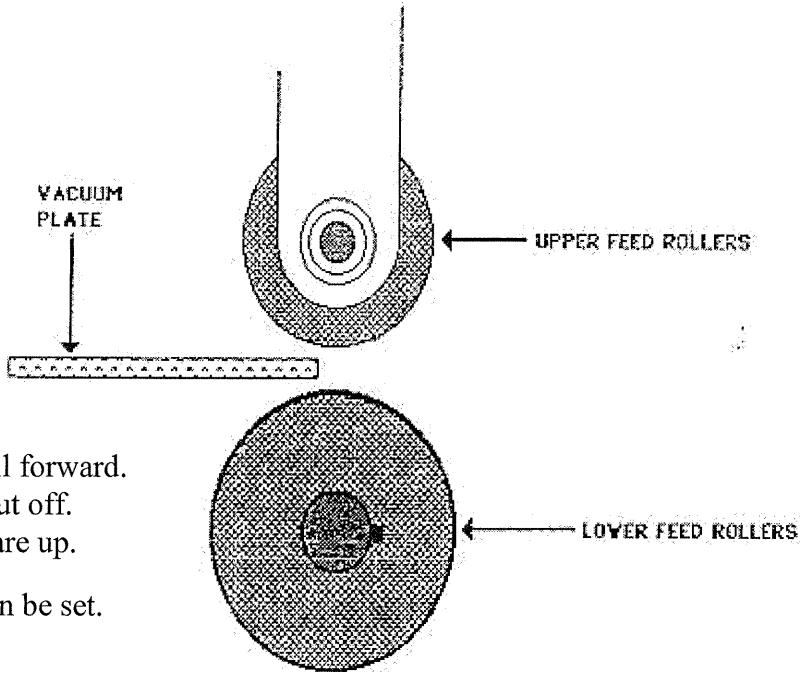
Locate the vacuum relief valve on the feeder vacuum pump (located on the left of the machine) and loosen the lock nut. Now the vacuum can be adjusted by holding the adjustment screw and turning the adjustment nut. As the spring is compressed, the vacuum increases. Loosening the compression spring decreases vacuum.



Rotate the machine with the handwheel and move the shuttle forward until the lower feed rollers come up. At this point the vacuum should go off. To adjust the vacuum off, loosen the back lock collar and hold against the rod block, pull the rod out of the vacuum plate housing until the vacuum goes off. Tighten in this position.



At this position the upper feed rollers can be set.



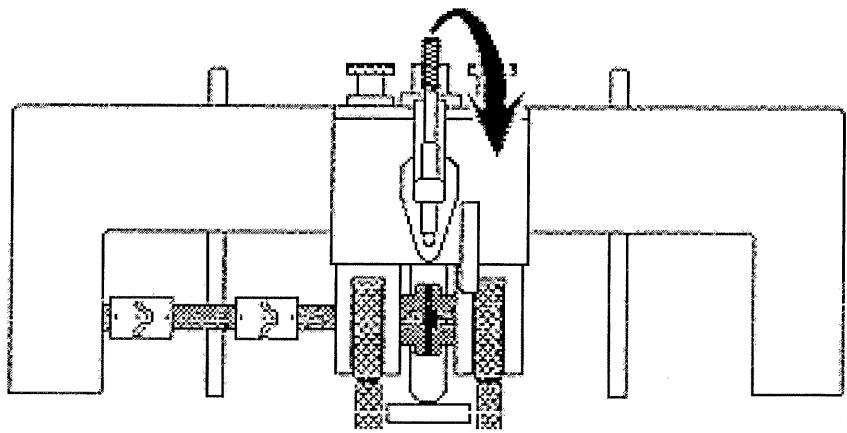
To set the top feed rollers, place a mailing piece in the shuttle feeder. Turn on the main power and feeder vacuum pump. Rotate the machine by hand until the piece is fed underneath the gate, between the top and lower feed rollers, and the lower feed rollers have come up. Adjust the top feed rollers up and down until there is enough pressure on the mailing piece to be able to pull the piece back out without tearing it.

After setting the top feed rollers, lock them in place with the locking nuts.

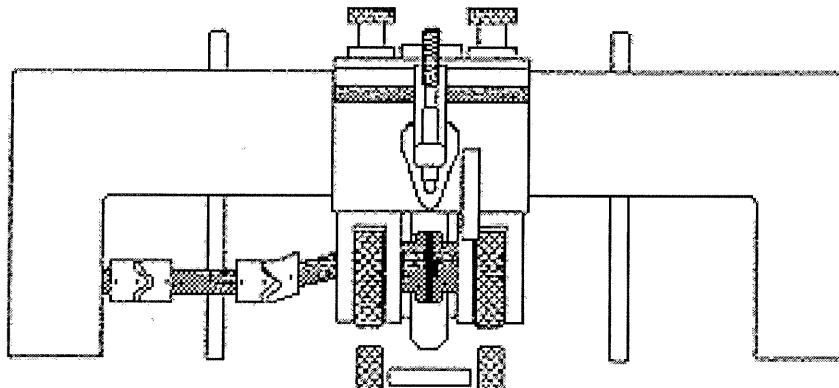
Place several pieces in the feeder and run the machine using the run or jog button. If the piece pulls to one side as it leaves the feed rollers, the top feed rollers are not set properly. Adjust until the mailing piece is fed smoothly by raising or lowering one of the top feed rollers.

4.8 JAM RELEASE

The feeder bridge contains a “jam release” that allows the gate and top feed rollers to be raised in case of a double feed or jam. To engage the jam release, simply pull down on the handle. Be sure and push up the handle and lower the gate and feed rollers after the jam has been cleared and before continuing operation.



Jam release in up position with gate and feed rollers down.



Jam release pulled down, raising gate and feed rollers.

4.9 SPACING

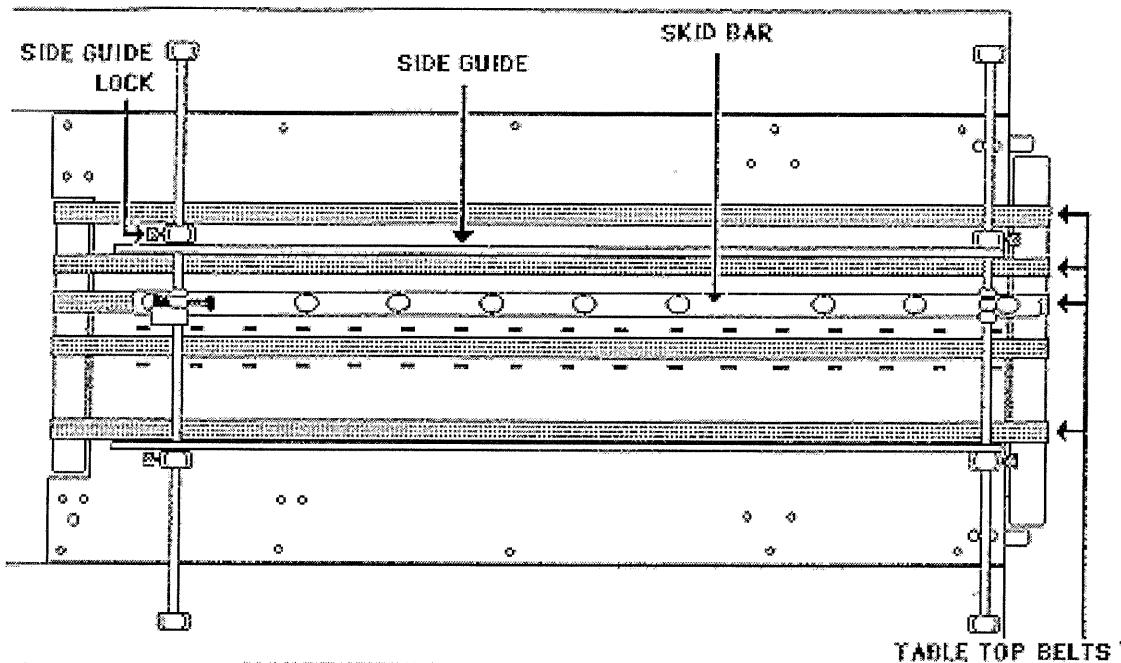
Varying the speed of both the shuttle feeder and tabletop belts controls spacing of product.

An optimum speed should be obtained on the tabletop belts by adjusting the speed control. This optimum speed should be determined by the quality of the ink jet. Once this speed has been determined and set, the shuttle feeder speed can be determined.

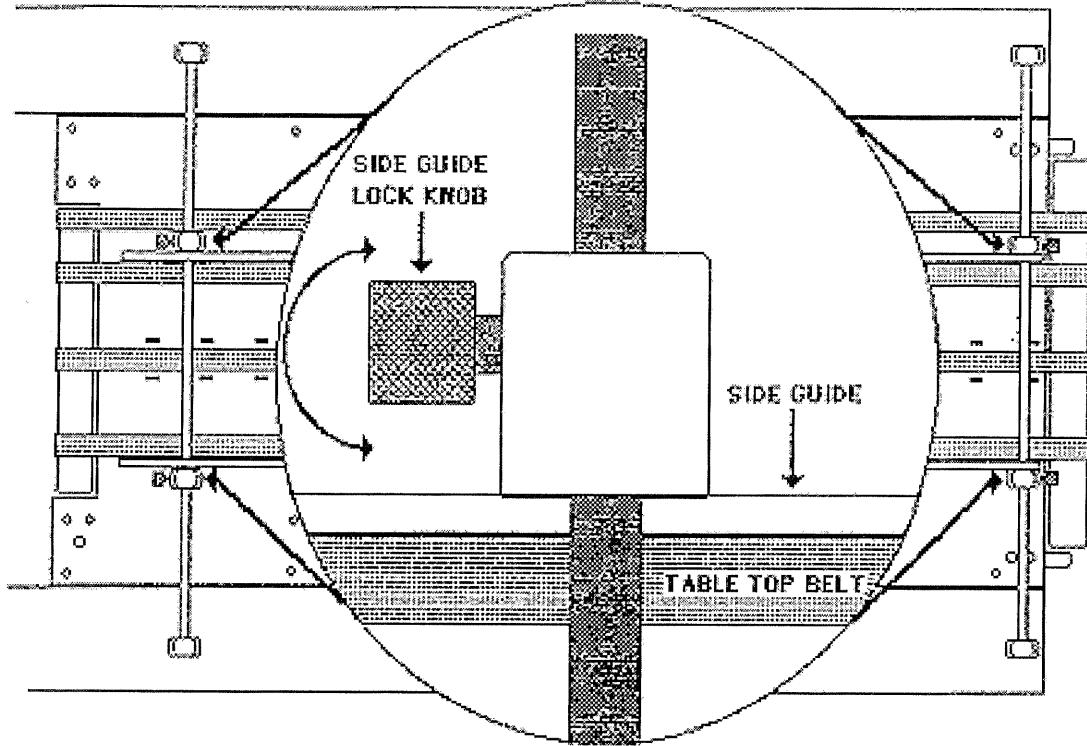
The shuttle feeder speed should be set to maintain a minimum spacing between the product being fed, allowing for maximum production. If the shuttle feeder speed is set too high, the products being fed will overlap and create problems with the ink jet.

For controls layout, see Figure 1.0.

4.10 SIDE GUIDES



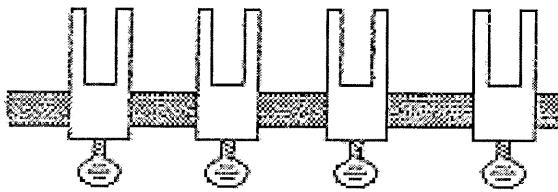
Once the product has been fed out through the feed rollers, the tabletop can be set. The first item to set up is the side guides. With the main power and feeder vacuum pump on, load the hopper and feed a piece out past the feed rollers. At this point, the two side guides can be brought in to either side of the piece with approximately 1/8" play on either side. The side guides are held in place with lock knobs that can be turned either way to lock the guides in place.



If the side guides are too tight, the mailing piece will not move across the tabletop. If they are too loose, the mailing piece may skew and the ink will be placed on crooked.

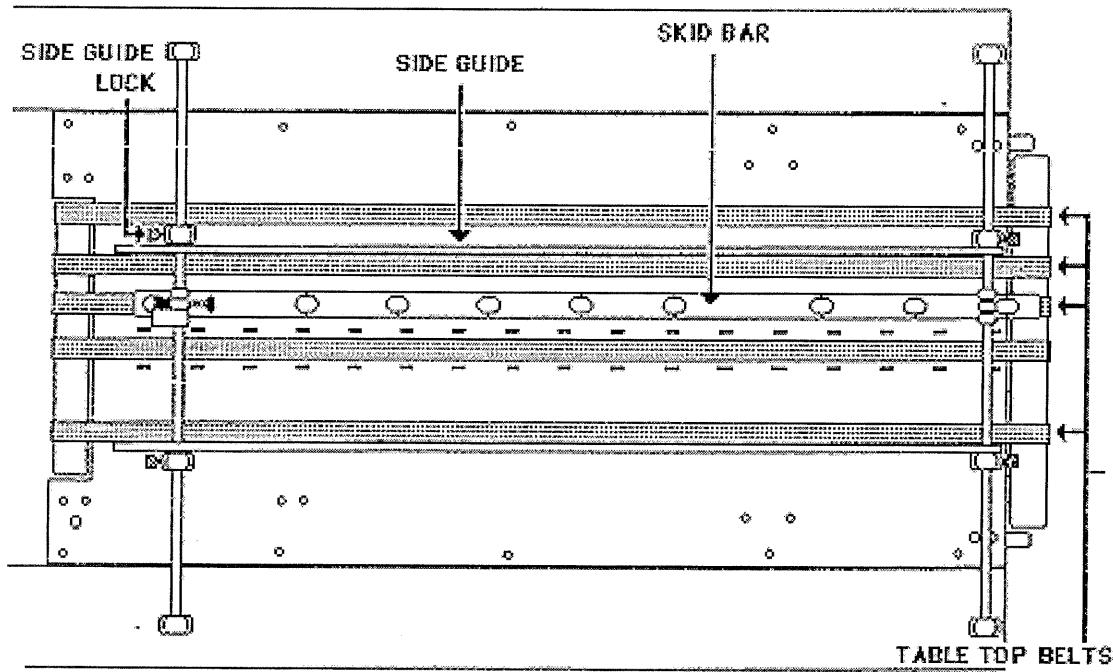
4.11 TABLETOP BELTS

The tabletop belts are designed to transport the product from the feed rollers, under the labeling head and onto the conveyor. There are five tabletop belts on the KR215IJ. However, not all of them are needed for every product. You may run the belts that are not needed outside of the side guides.



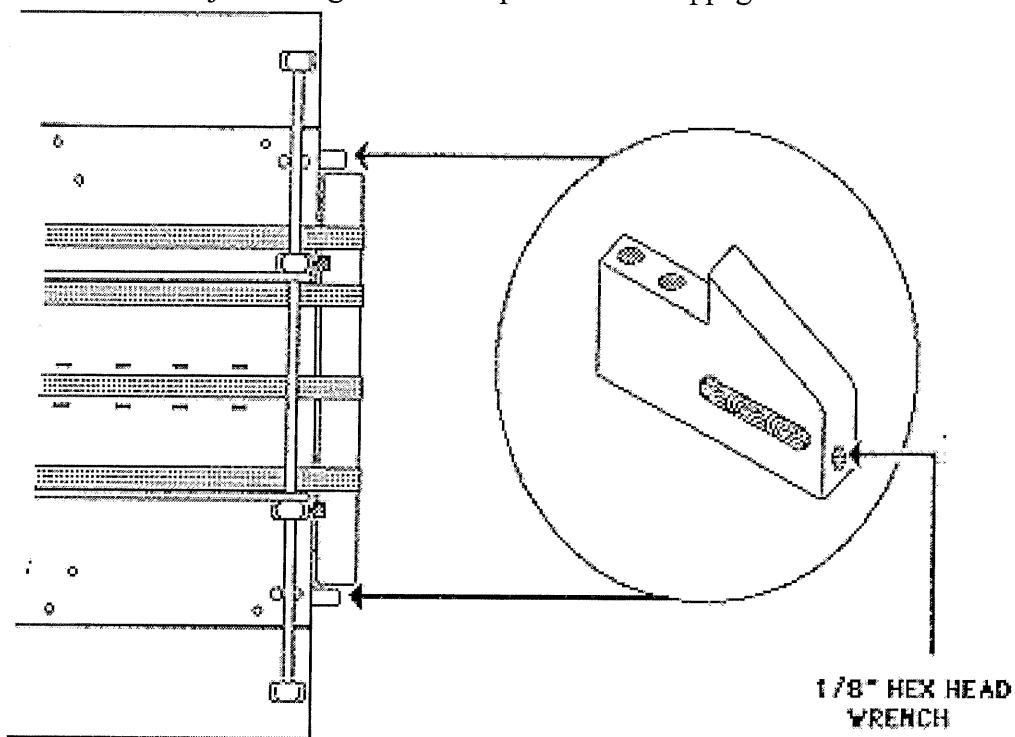
Underneath the tabletop is located guides for the tabletop belts. Each belt has its own guide. To move the belts, simply loosen the thumbscrew on the bottom of the guide and slide the guide on the shaft to the desired position and then tighten the thumbscrew.

The belts should be positioned so that there is a belt riding next to each side guide, one belt between the vacuum ports and, if used, one underneath the skid bar.



The fourth and additional belts are normally used when running large product such as newspapers or heavy product such as magazines.

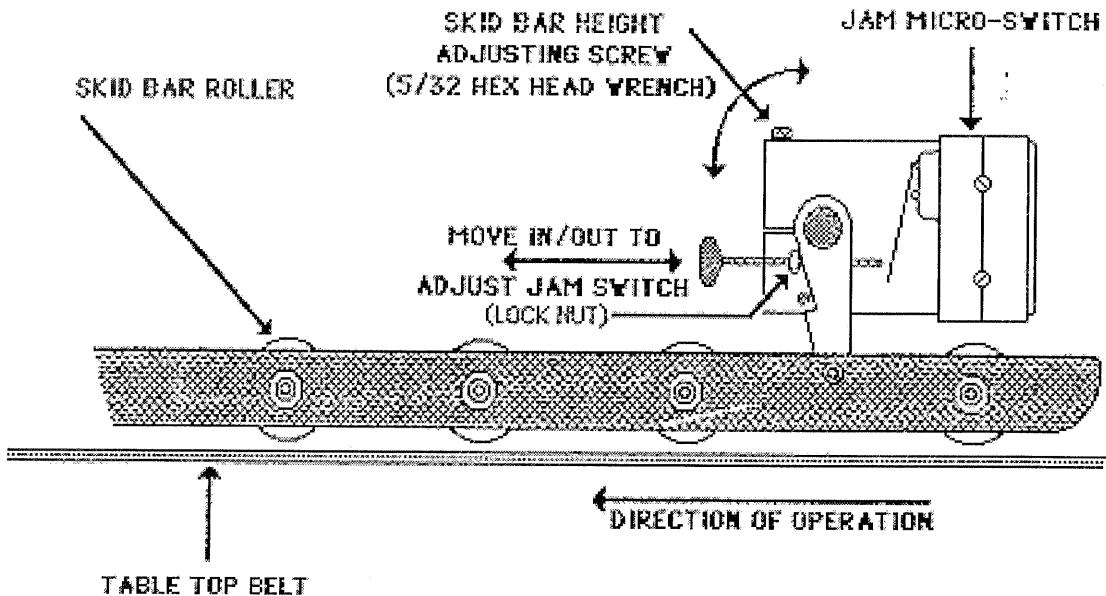
The tabletop belt tension can be adjusted. Caution should be taken not to over tighten. There should be just enough tension to prevent belt slippage.



4.12 SKID BAR

The skid bar rides on top of the product to help transport the mailing piece across the tabletop. The skid bar should be placed over one of the tabletop belts for best results. To move the skid bars locate and loosen the 1/8" hex head set screws in the lock collars on the right-hand side of the machine. The left-hand side of the machine has a lock collar and a skid bar block that is held in place with a 5/32" hex head screw. The KR215IJ is furnished with one skid bar, and is not needed when running small pieces such as cards or envelopes but can be installed when running large or heavy product.

Attached to one end of the skid bars is a "jam detector switch" on certain machines. This switch, when properly set, will stop the machine when a jam or double feed occurs.



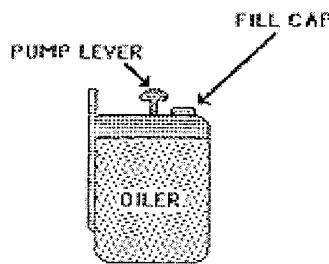
To set the skid bar, rotate the machine until a mailing piece is under the skid bar. Loosen the 5/32" hex head screw on the skid bar block. Adjust until the skid bar is resting on the mailing piece and the skid bar rollers rotate as the product is transported. Lock in place with the 5/32" hex head screw.

The jam switch is adjusted by loosening the lock nut, moving the adjustment knob in or out and tightening the lock nut. The microswitch should disengage and stop the machine when a jam or double feed occurs.

NOTE: The machine will not run if the jam switch is not set properly (see Section 4.2).

5 MAINTENANCE

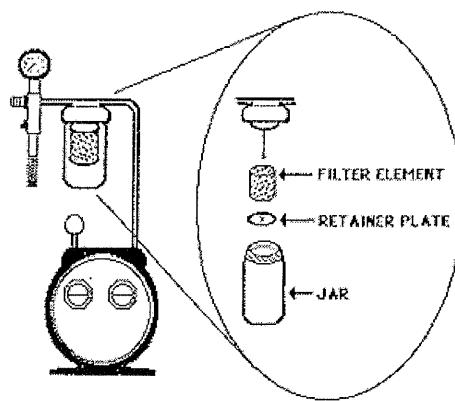
5.1 LUBRICATION



The operator should keep the KR215IJ clean and lubricated on a regular basis. The base has a central oiling system located on the left side near the jogger table, looking down stream. The oiler only requires the operator to pull the pump lever on the oiler. This should be done every two hours of operation. The oil recommended is a 20 weight SAE machine oil.

5.2 DAILY MAINTENANCE

Item	Function	Remarks
Upper & Lower Feed Rollers	Remove glazing and all other foreign materials from feed surfaces.	Use alcohol.
Base (General)	Remove excessive paper dust, ink, glue, and all other foreign materials from the tabletop and inside of base.	Use clean soft rag. (Dampen with water if necessary.)
Vacuum Pump Filters	Remove paper dust.	Wrap edge of filter against a hard surface or vacuum. If unable to clean replace with new filter.
Vacuum Pump Filters Jars	Clean jars thoroughly.	Use warm water and dry thoroughly. CAUTION: Improper replacement of cracked rims of jars can result in a loss of vacuum. Insure jar is installed correctly and has a proper seal.
Vacuum Body	Remove paper dust.	Remove vacuum plate and valve to remove debri around valve.



6 DIAGRAMS AND PARTS LISTS

6.1 DIAGRAMS

Drawing #	Description
KR215IJ_DM	KR215IJ DUAL MOTOR
536172-01	ASSY, ELECTRICAL PANEL
536433-01	ASSY, TOP 215IJ DUAL MOTOR
500705A	ASSY, SHUTTLE TABLE
530656-01	ASSY, VACUUM MANIFOLD
531021-01	ASSY, SHUTTLE TABLE
500708A	ASSY, VACUUM BODY
500728A	ASSY, BUSHING BLOCK
500751A	ASSY, BEARING BLOCK
531022-01	ASSY, LOWER FEED ROLLER
531102-01	ASSY, HUB GEAR
531405-01	ASSY, JOGGER TABLE
500714-A	ASSY, REAR BRIDGE
500764A	ASSY, LIFTER
500880A	ASSY, BRACKET
533442-01	ASSY-TOP,215IJ
531274-01	ASSY, FRONT ROLLER DRIVE
530619-01	ASSY, IDLER ROLLER
538021-01	ASSY, SKID BAR
500800-A	ASSY, LINK
500801A	ASSY, LINK
500802A	ASSY, CLAMP
500834A	ASSY, STUD WITH BEARING
534319-01	ASSY,215IJ OUTSIDE TABLETOP
535411-01	ASSY, 215 STD BRIDGE
500704A	ASSY, BRIDGE
500726A	ASSY, SHAFT UNIVERSAL
500814-1A	ASSY, SIDE GUIDE RAIL
531582-01	EG ASSY, BRIDGE DRIVE AND GATE
535412-01	ASSY, SIDE GUIDE
500755AL	ASSY, SIDE GUIDE LH
500755AR	ASSY, SIDE GUIDE RH
535806-01	ASSY, SKID BAR & SIDE GUIDE
535275-01	ASSY, PANIC BAR

Drawing #	Description
536176-01	ASSY, LH FRAME
531105-01	ASSY, GEAR
531106-01	ASSY, HUB
536177-01	ASSY, RH FRAME
536178-01	ASSY, CHANGE GEAR PLATE
536434-01	ASSY, 215IJ DUAL MOTOR CABINET
509000-8A	ASSY, MTR/REDUCER SR 1/2HP VERT
531168-01	ASSY, 1/2 HP VACUUM PUMP

6.2 PARTS LIST

See following pages for parts list.

215IJ PARTS MANUAL
KR215IJ DUAL MOTOR

27-NOV-00
PAGE 1

ITEM#	QTY	PART#	DESCRIPTION
1	1	100131	BUSHING, SL.250ID.375OD1.250LG
2	8	100145	BUSHING, SL.625ID.813OD1.000LG
3	2	100400	WASHER, THRUST TW31
4	1	100402	WASHER, THRUST TB612
5	2	100409	WASHER, THRUST
6	1	100800	ASSY, UNIVERSAL JOINT
7	2	101100	BEARING, ONEWAY .375
8	1	101707	GEAR, 2048 .375B NK
9	1	101760	GEAR, 2075 .625B .188K
10	1	101915	GEAR, 1628 .750B .188K
11	1	101916	GEAR, 1628 .625B .188K
12	1	101917	GEAR, 1621 .625B .188K
13	2	101918	GEAR, FEED ROLLER DRIVE
14	1	101919	GEAR, 1648 1.124B NK
15	1	101961	GEAR, 1626 .625B .188K
16	1	102114	KNOB
17	1	102117	KNOB
18	2	102119	KNOB
19	3	102225	COLLAR .250
20	1	102345	SHIM, .375X.625X.125
21	2	102672	SPACER, SIDE PLATE
22	2	102700	SPRING, COIL
23	3	102701	SPRING
24	8	103106	BEARING, FLAT .375
25	2	103108	BEARING, FLAT .500
26	1	103110	BEARING, FLAT .625
27	1	103405	CAM FOLLOWER
28	1	103500	BEARING - ROD END
29	2	103803	BEARING - HUB
30	11	103804	BEARING - HUB
31	2	103805	BEARING - HUB
32	3	103817	HUBBEARING 5/8 ID
33	2	104100	SNAPRING, .375
34	1	104106	SNAPRING, .500
35	2	104400	BOLT - HEX HEAD
36	1	105001	V-PULLEY, DBL D2200
37	1	105021	V-PULLEY, AK30
38	1	105026	V-PULLEY, MAVR. 2200
39	3	105200	PIN, ROLL .063X.875
40	4	105418	DOWEL, PIN .188X1.500
41	2	107104	BOLT, SHOULDER 5/16X3/4
42	1	108821	PULLEY, TIMING 12L050 .500B NK
43	2	109521	OIL METER UNIT
44	1	109523	JUNCTION, 2-WAY
45	1	109524	JUNCTION, 3-WAY
46	2	109528	NUT, COMPRESSION FEMALE
47	2	109537	SLEEVE, COMPRESSION
48	1	190101	MICROSWITCH, LEVER
49	2	190202	BUSHING, PLASTIC
50	1	190203	COVER, MICROSWITCH
51	1	190600	SPIDER - ROLLER DRIVE
52	1	190606	FITTING - 90 DEG 1/4 NPT

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53	4	190634	FOOT, MOUNTING
54	1	190637	OIL PUMP
55	1	190660	NIPPLE, 1/2 IN TUBING
56	1	190685	LEVER - QUICK RELEASE
57	1	190715	PVC COUPLING
58	1	190769	MAGNET, BUNTING
59	4	191010	LEVELING BOLT, CABINET
60	1	200102	VALVE, RELIEF GAST 822/823
61	1	200108	STEM GAST 822/823
62	1	200109	PLATE GAST 822/823
63	1	200120	BLOWER, GAST
64	1	200124	PUMP, VACUUM GAST
65	4	209016	KNOB, POT
66	1	500704	BRIDGE - FEEDER
67	1	500705	TABLETOP - NARROW SHUTTLE
68	1	500708	BODY, VACUUM VALVE
69	1	500709	PLATE - VACUUM FEEDER
70	2	500716	BRACKET - BELT TAKE-UP
71	1	500718	HUB - SHAFT BEARING
72	1	500720	PLATE - SIDE GEAR SUPPORT
73	4	500721	GUSSET - TABLETOP SUPPORT
74	2	500725	GUIDE - BELT
75	1	500728	BRACKET - FEEDER
76	1	500730	PLATE, GATE FEEDER
77	1	500734	LEVER - CAM
78	1	500735	ROD - PUSH
79	2	500737	WASHER - BUMPER
80	1	500738	SPRING - VALVE
81	1	500739	BLOCK - PUSHER
82	1	500740	PLATE - VACUUM
83	2	500741	SHAFT - FEEDER
84	1	500743	SHAFT - TOP ROLLER DRIVE
85	1	500744	SHAFT - TOP ROLLER ASSY
86	2	500745	ROLLER, UPPER
87	2	500746	ROLLER - BOTTOM FEED
88	1	500747	CAM - FEED ROLLERS
89	1	500749	ROD - FEEDER SLIDE
90	1	500750	CRANK - FEEDER SLIDE
91	1	500751	YOKE - FEEDER CRANK
92	2	500755	CLAMP - SIDE GUIDE
93	2	500760	LIFTER - FEEDER PUSHER
94	2	500762	PLATE - FEEDER PUSHER BOTTOM
95	1	500769	SHAFT - REAR GUIDE
96	4	500771	CLIP-SIDE GUIDE
97	2	500775	PLATE - FEEDER PUSHER TOP
98	1	500785	BLOCK-SPRING
99	1	500786	LEVER, SPRING
100	2	500787	SHAFT-SIDE GUIDE ADJ.
101	2	500791	POST, SIDEGUIDE
102	4	500792	POST, SIDE GUIDE
103	4	500793	LOCK, SIDE GUIDE CAM
104	1	500803	SHAFT-UNIVERSAL JOINT
105	2	500805	PLATE - HOLD DOWN

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KR215IJ DUAL MOTOR

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106	I	500806	PLATE - GATE END
107	2	500807	NUT - LOCK
108	2	500809	SLEEVE - THREADED
109	I	500810	SHAFT - SCREW ADJ
110	2	500811	FORK ASY
111	2	500812	KNOB, ROLLER ADJUSTMENT
112	I	500817	SHAFT-GEAR SPUR
113	I	500823	SHAFT, IDLER ROLLER
114	3	500824	SHAFT-BELT GUIDE
115	I	500825	SHAFT-SPROCKET DRIVE
116	I	500830	SHAFT - UNIVERSAL DRIVE
117	2	500832	BRACKET-REAR-GUIDE
118	I	500835	ROLLER
119	2	500836	HUB
120	2	500839	HUB-BELT DRIVE
121	2	500859	SPACER
122	I	501645	BLOCK, CONNECTOR (VACUUM PUMP)
123	I	503619	SHAFT
124	I	503622	HUB, GEAR
125	2	504604	STOP BAR ARM
126	I	504605	BRACKET, SWITCH
127	I	504607	STOP BAR
128	I	509006	PLATE-REAR SIDE
129	I	509007	PLATE-GEARBOX 1/2 HP SINGLE RED.
130	I	509037	COVER, REDUCER
131	I	100800-1	ASSY, UNIVERSAL JOINT
132	2	100800-1_I	UNIVERSAL
133	2	100800_1	UNIVERSAL
134	2	100800_3	UNIVERSAL
135	I	102114A	ROUND KNOB ASY
136	2	102119-A	ASSY, KNOB
137	I	102200-2	COLLAR
138	I	105000-1	V-PULLEY
139	4	105901-2	BELT, FLAT 3/4 X 68.75
140	I	106000-2	BELT, V AX51
141	I	106025-2	BELT, V AX40
142	I	106202-2	BELT, FLAT 1 1/4 X 68.75
143	I	108912-1	BELT, TIMING 187L050
144	I	109319-1	PULLEY, TIMING 32L050 .625B .188K
145	I	190101A	ASSY-SWITCH WITH COVER
146	I	200100-1	GAUGE, VACUUM GAST 822/823
147	I	200100-2	FILTER, VACUUM GAST 822/823
148	I	200100-3	JAR, GLASS GAST 822/823
149	I	200100-13	NIPPLE, STEEL
150	I	200100-14	ELBOW, PIPE GAST 822/823
151	I	200100-16	COUPLING GAST 822/823
152	I	200100-21	NIPPLE, STEEL
153	I	200100-22	COUPLING, STEEL
154	I	200100-23	PLUG, SQUARE HEAD GAST 822/823
155	I	200100-26	COVER FOR AB992 GAST 822/823
156	2	200124-2	FILTER, FELT GAST 823
157	2	200124-4	END CAP, AK510 GAST 823
158	I	200124-5	MUFFLER, SINTERED GAST 823

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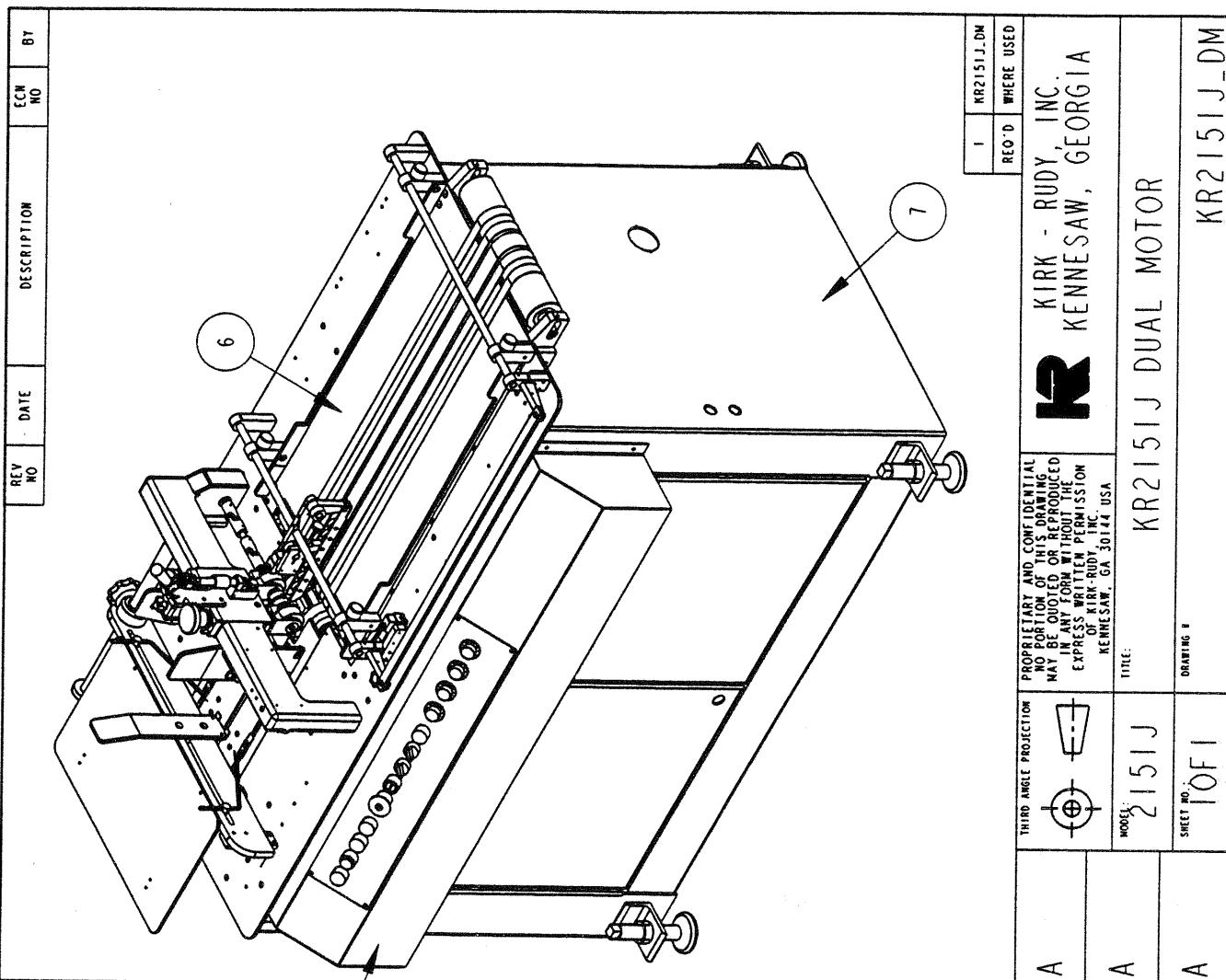
159	2	200124-6	O-RING, GASKET GAST 823
160	2	200152-2	MOTOR, LEESON DC 1/2HP
161	2	201124-2	BUTTON, START
162	1	201124-4	BUTTON, POWER ON
163	1	201125-3	BUTTON, STOP
164	1	201125-5	BUTTON, POWER OFF
165	2	201126-1	BUTTON, JOG
166	2	201145-1	SELECTOR, 2 POSITIONS
167	1	500421-1	PNL, CONTROL
168	1	500701-L	frame plate
169	1	500701-R	BAR-FRAME PLATE
170	1	500702-4L	TABLETOP,L/H SIDE
171	1	500702-4R	TABLETOP,R/H SIDE
172	1	500704A	ASSY, BRIDGE
173	1	500705A	ASSY, SHUTTLE TABLE
174	1	500708A	ASSY, VACUUM BODY
175	1	500710-I	BRACKET - FEEDER SUPPORT
176	3	500721-1	GUSSET,CUTOUT
177	1	500722-4L	SIDE GUIDE, R/H
178	1	500722-4R	RAIL, GUIDE RH
179	1	500725-7	GUIDE, BELT
180	1	500726A	ASSY, SHAFT UNIVERSAL
181	1	500728A	ASSY, BUSHING BLOCK
182	1	500729-4L	ARM, FEEDER CRADLE HUBBRG LH
183	1	500729-4R	ARM, CRADLE FEEDER HUBBRG RH
184	1	500742-4	ROLLER - TUBE BELT DRIVE
185	2	500745A	ASSY, UPPER FEED ROLLER
186	1	500748-1	SHAFT - FEEDER ROLLER
187	1	500751A	ASSY, BEARING BLOCK
188	1	500755AL	ASSY, SIDE GUIDE LH
189	1	500755AR	ASSY, SIDE GUIDE RH
190	1	500788L	PLATE - RH SIDEGUIDE
191	1	500788LA	ASSY-SIDE GUIDE PLATE
192	1	500788R	PLATE, SIDEGUIDE RH
193	1	500795-1	PLATE - BACK
194	1	500799-3	CLAMP - MOUNTING PLATE
195	1	500799-5	BLOCK, CLAMP SUPPORT
196	2	500799-6	STUD, BRIDGE (LONG)
197	2	500799-7	STUD, BRIDGE (SHORT)
198	1	500799_2	BLOCK - CONNECTOR
199	1	500808-1	PLATE, TOP BRIDGE
200	2	500811A	ASSY, FORK WITH BEARINGS
201	2	500814-1	RAIL - SIDEGUIDE
202	2	500814-2	RAIL - SIDE GUIDE
203	2	500814-1A	ASSY, SIDE GUIDE RAIL
204	2	500819-1	BLOCK, BEARING
205	1	500827-1	SHAFT, SPRING LEVER
206	1	500828-1	SHAFT - FRONT ROLLER
207	1	500890-3	WLDMNT, 215 INKJET BASE CABINET
208	1	503630-1	SHAFT, GEAR
209	2	504602-1	POST - STOP BAR
210	1	504606-1	BLOCK - ARM STOP
211	1	509000-8A	ASSY, MTR/REDUCER SR 1/2HP VERT

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212	I	528717-2	COVER, CONTROL
213	I	530253-01	RING
214	I	530441-01	BOX, ELECTRICAL INLET 20A
215	I	530619-01	ASSY, IDLER ROLLER
216	I	530656-01	ASSY, VACUUM MANIFOLD
217	I	530676-01	ROLLER ASY
218	I	530697-01	PANEL, INKJET BASE BACK
219	I	531021-01	ASSY, SHUTTLE TABLE
220	I	531022-01	ASSY, LOWER FEED ROLLER
221	I	531102-01	ASSY, HUB GEAR
222	I	531105-01	ASSY, GEAR
223	I	531106-01	ASSY, HUB
224	2	531117-01	ASSY, PUSHER
225	I	531155-01	PLATE, MAGNETIC
226	I	531168-01	ASSY, 1/2 HP VACUUM PUMP
227	I	531274-01	ASSY, FRONT ROLLER DRIVE
228	I	531405-01	ASSY, JOGGER TABLE
229	I	531582-01	EG ASSY, BRIDGE DRIVE AND GATE
230	2	531584-01	EG ASSY, FORK
231	2	531672-01	BAR, FORK
232	2	531673-01	YOKE
233	I	533273-01	ASSY, PANIC POST & SWITCH
234	I	533274-01	ASSY-PANIC BAR POST
235	I	533442-01	ASSY-TOP, 215IJ
236	I	534319-01	ASSY, 215IJ OUTSIDE TABLETOP
237	I	535275-01	ASSY, PANIC BAR
238	I	535411-01	ASSY, 215 STD BRIDGE
239	I	535412-01	ASSY, SIDE GUIDE
240	I	535806-01	ASSY, PANIC BAR & SIDE GUIDE
241	I	536172-01	ASSY, ELECTRICAL PANEL
242	I	536176-01	ASSY, LH FRAME
243	I	536177-01	ASSY, RH FRAME
244	I	536178-01	ASSY, CHANGE GEAR PLATE
245	I	536433-01	ASSY, TOP 215IJ DUAL MOTOR
246	I	536434-01	ASSY, 215IJ DUAL MOTOR CABINET
247	I	536892-01	ASSY, REAR BRIDGE
248	I	538021-01	ASSY, SKID BAR
249	I	RHB051	HEX HEAD BOLT
250	I	RHB081	HEX HEAD BOLT
251	I	RHB082	HEX HEAD BOLT
252	2	RHN010	HEX NUT
253	3	RHN012	HEX NUT
254	5	SP16208	SPACER, REDUCER
255	I	SP30202	BLOCK, VACUUM
256	I	SP28217-I	BLOCK, LOWER VACUUM
257	I	SP28218-I	BLOCK, UPPER VACUUM
258	I	SP30201-I	TABLETOP 30.5 IN EXT. CANTER VACUUM
259	I	SP33419-3	SHAFT
260	I	SYA590	SET SCREW
261	2	SYA601	SET SCREW
262	I	WA013	WASHER
263	I	WHS010	LOCK WASHER
264	I	WHS011	LOCK WASHER

ITEM QTY	PART #	DESCRIPTION
1	105001	V-PULLEY, DBL D2200
2	105026	V-PULLEY, MAVR 2200
3	106000-2	BELT, V AX51
4	106025-2	BELT, V AX40
5	536172-01	ASSY, ELECTRICAL PANEL
6	536433-01	ASSY, TOP 2151J DUAL MOTOR
7	536434-01	ASSY, 2151J DUAL MOTOR CABINET



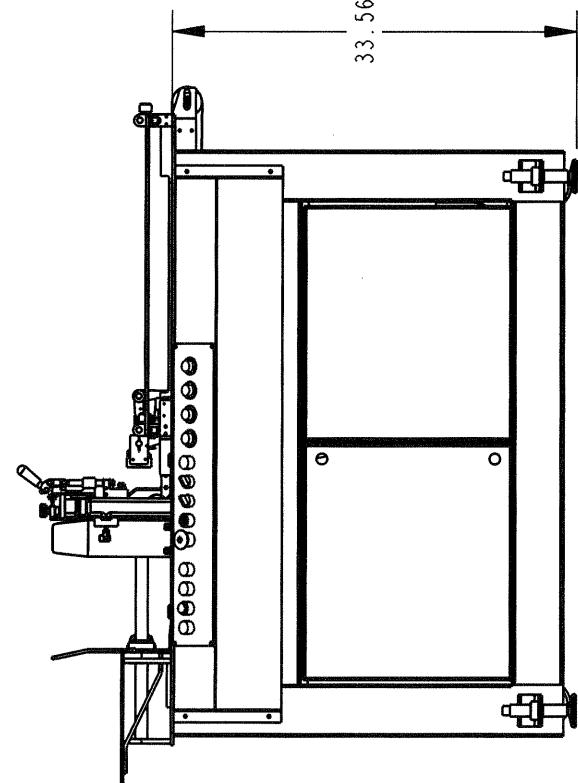
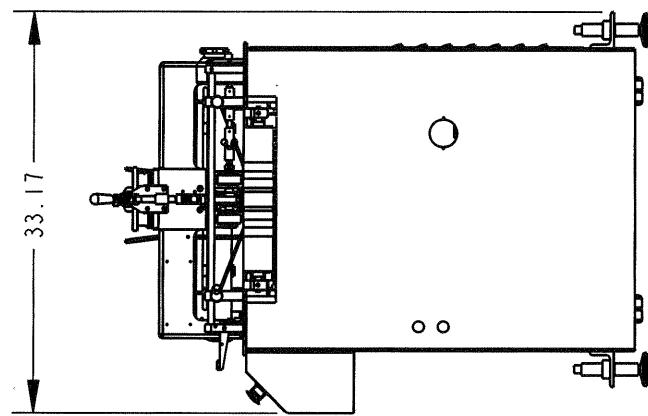
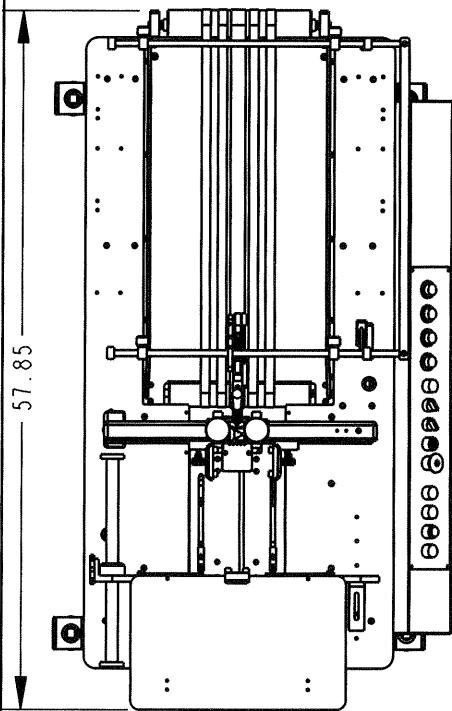
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DRAFTER BY:	SCALE	SCALE	MATERIAL:	THIRD ANGLE PROJECTION
MY	0 . 094		N / A	
CHECKED BY:			DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	
DATE	.01	.005	.005	
03 - Jun - 99			ANG.	
TRACED BY:			REMOVAL ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED	
MASTER	M		ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE. WORK TO DIMENSIONS ONLY	
			FINISH:	
			N / A	
			SHEET NO. 1 OF 1	
			DRAWING #	KR2151J DUAL MOTOR
			REV'D	KR2151J-DM
			ECN NO	
			BY	
			REC'D WHERE USED	
			1	KR2151J-DM

DRAWING # KR2151J-DM

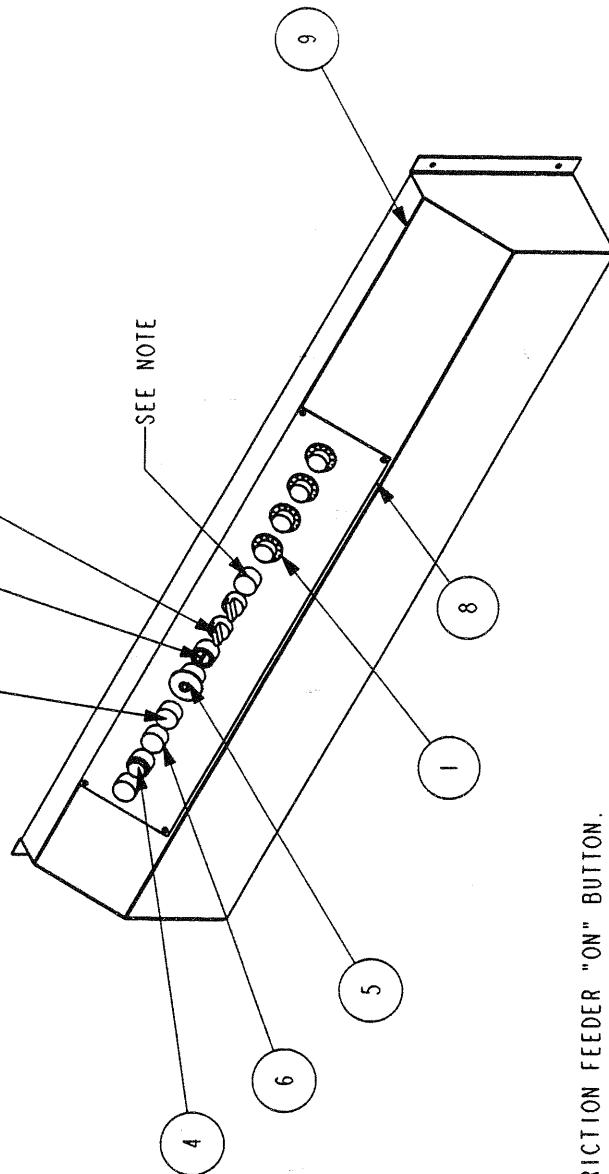
REV NO	DATE	DESCRIPTION	ECN NO	BY
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I KR2151J-DM
REV'D WHERE USED



DRAWN BY:	MY	SCALE	0 . 070	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	N / A	MATERIAL:	N / A	THIRD ANGLE PROJECTION	KIRK - RUDY, INC.
CHECKED BY:		DATE	30 - Nov - 99	.01 .005 .5	HEAT TREAT:	N / A			KENNESEE, GEORGIA
TRACED BY:		MASTER		REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED		FINISH:	N / A	MODEL:	KR2151J DUAL MOTOR
				ALL DIMENSIONS ARE FIRMED DIMENSIONS				SHEET NO:	20F2
				DO NOT SCALE - WORK TO DIMENSIONS ONLY				DRAWING #:	KR2151J-DM

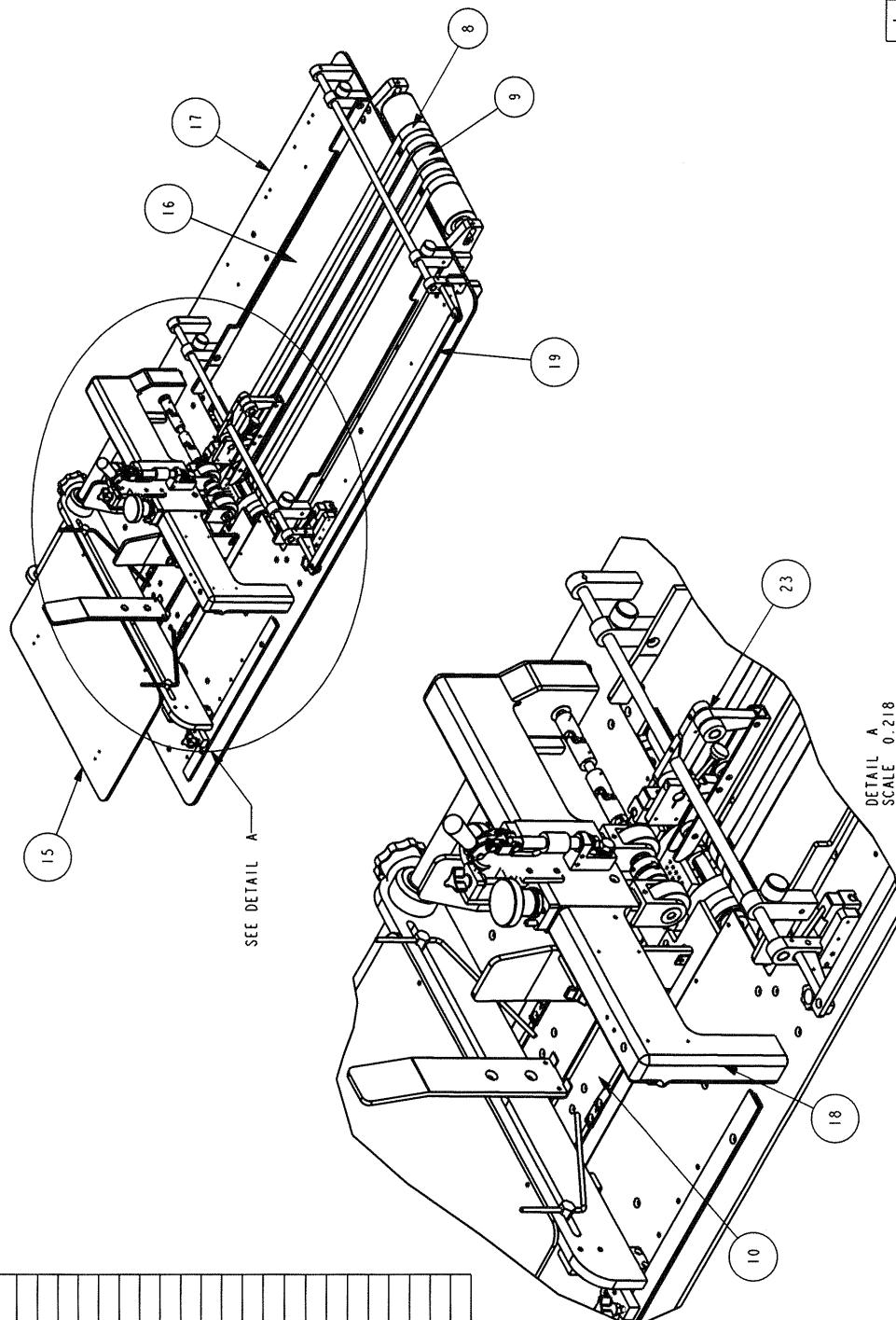
ITEM QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	4	209016			KNOB, POT		
2	2	201124-2			BUTTON, START		
3	1	201124-4			BUTTON, POWER ON		
4	1	201125-3			BUTTON, STOP		
5	1	201125-5			BUTTON, POWER OFF		
6	2	201126-1			BUTTON, JOG		
7	2	201145-1			SELECTOR, 2 POSITIONS		
8	1	500421-1			PNL, CONTROL		
9	1	528717-2			COVER, CONTROL		



NOTES:
1. OPTIONAL 496 FRICTION FEEDER "ON" BUTTON.

DRAWN BY:	SCALE	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	MATERIAL:	THIRD ANGLE PROJECTION	PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE OBLITERATED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC. KENNESAW, GA 30144 USA	REO'D	WHERE USED
MY	0 . 125	.XX .XXX .005 .5	N/A		KIRK - RUDY, INC. KENNESAW, GEORGIA	KR215+36	
CHECDED BY:	DATE		HEAT TREAT:		2151J		
TRACED BY:	MASTER	07 - Apr - 99 	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY		1 OF 1	ASSY, ELECTRICAL PANEL	536172-01

ITEM QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BT
1	1 01915	GEAR, 1628 .750B .188K					
2	4 105418	DOWELL, PIN .188X1.500					
3	2 500725	GUIDE - BELT					
4	1 500747	CAM - FEED ROLLERS					
5	3 500824	SHAFT-BELT GUIDE					
6	1 500825	SHAFT-SPROCKET DRIVE					
7	1 105000-1	V-PULLEY					
8	4 105901-2	BELT, FLAT 3/4 X 68.75					
9	1 106202-2	BELT, FLAT 1 1/4 X 68.75					
10	1 500705A	ASSY, SHUTTLE TABLE					
11	1 500725-7	GUIDE, BELT					
12	1 530656-01	ASSY, VACUUM MANIFOLD					
13	1 531021-01	ASSY, SHUTTLE TABLE					
14	1 531022-01	ASSY, LOWER FEED ROLLER					
15	1 531405-01	ASSY, JOGGER TABLE					
16	1 533442-01	ASSY-TOP, 215IJ					
17	1 534319-01	ASSY, 215IJ OUTSIDE TABLE TOP					
18	1 535411-01	ASSY, 215 STD BRIDGE					
19	1 533806-01	ASSY, PANIC BAR & SIDE GUIDE					
20	1 536176-01	ASSY, LH FRAME					
21	1 536177-01	ASSY, RH FRAME					
22	1 536178-01	ASSY, CHANGE GEAR PLATE					
23	1 538021-01	ASSY, SKID BAR					
24	1 SP30202	BLOCK, VACUUM					

DETAIL A
SCALE 0.218

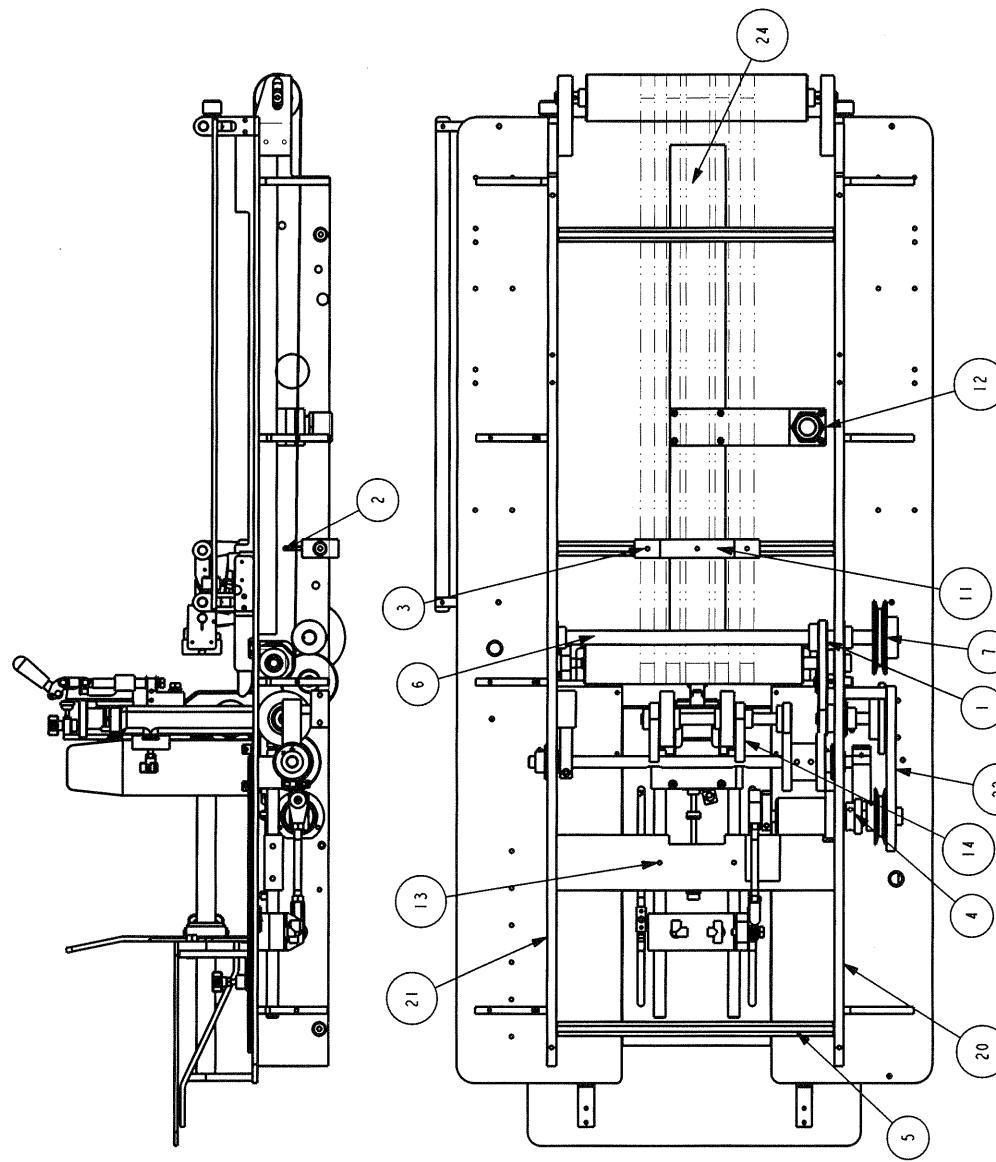
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					ALL EDGES ARE SHARP EXCEPT THOSE NOTED OTHERWISE	N/A	ALL EDGES ARE SHARP EXCEPT THOSE NOTED OTHERWISE	N/A	ALL EDGES ARE SHARP EXCEPT THOSE NOTED OTHERWISE
					FINISH:	N/A	FINISH:	N/A	FINISH:
					WEIGHT:	N/A	WEIGHT:	N/A	WEIGHT:
					PACKING:	N/A	PACKING:	N/A	PACKING:
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					PRINTED AT:	N/A	PRINTED AT:	N/A	PRINTED AT:
					PRINTED BY:	N/A	PRINTED BY:	N/A	PRINTED BY:
					PRINTED DATE:	N/A	PRINTED DATE:	N/A	PRINTED DATE:

I		MRIS.DCM REC'D WHERE USED	
KIRK-RUDY INC.		KENNESEAW, GEORGIA	
		TIME: 215IJ	

ASSY, TOP 215IJ DUAL MOTOR		Drawing 1	
536433-01			

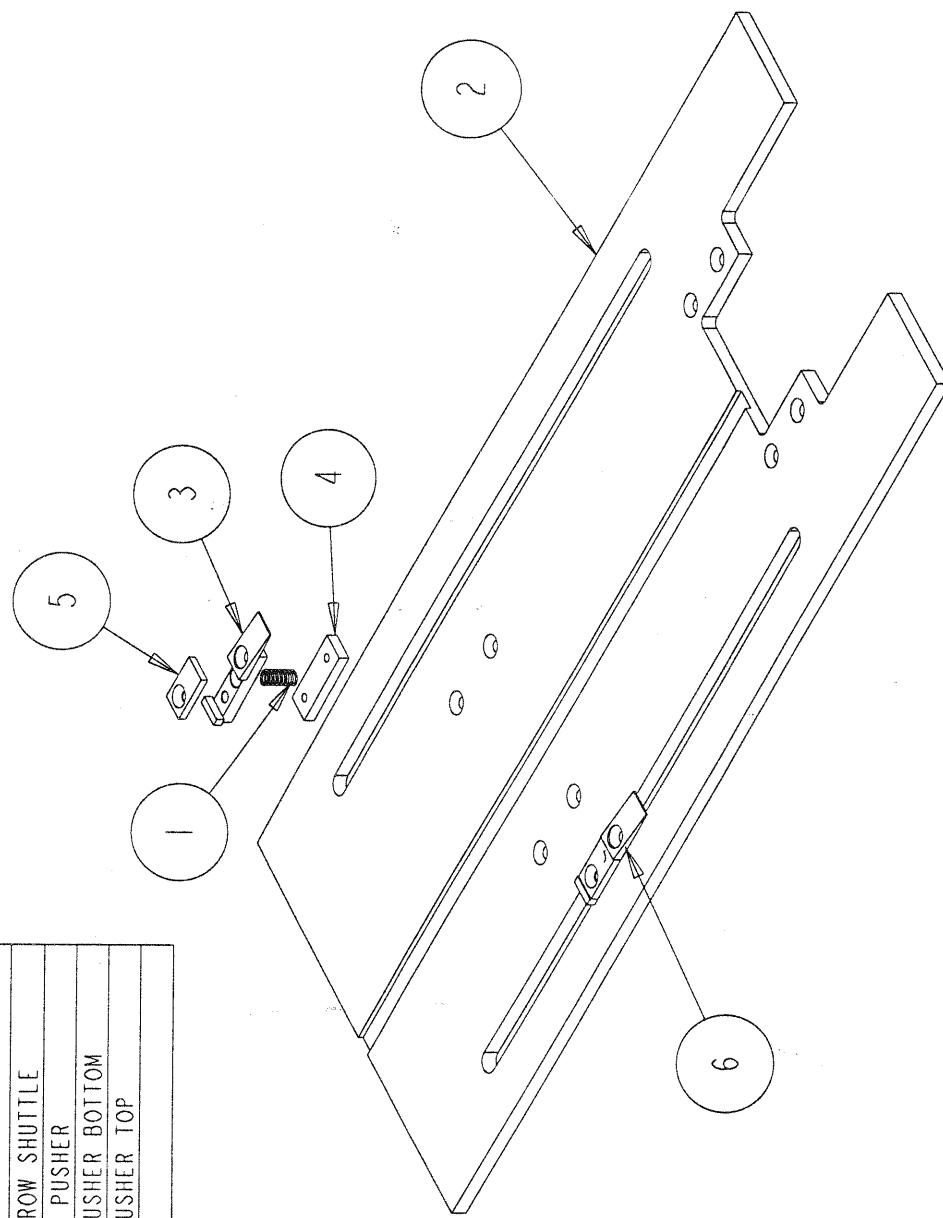
REV NO	DATE	DESCRIPTION	EN ID
			67

I	MR215.0M
RECD	WHERE USED



DRAWING #: 536433-01		TITLE: ASSY, TOP 215IJ DUAL MOTOR	
SCALE:	0 . 156	UNLESS OTHERWISE SPECIFIED	MATERIAL: N/A
CHECKED BY:	3 - Jun - 99	REMOVED DATE:	N/A
INSTRUMENTS:		WEIGHT:	N/A
MAKER:		TIME:	N/A
ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY			

ITEM QTY	PART #	DESCRIPTION
1	2	102700 SPRING, COIL
2	1	500705 TABLETOP - NARROW SHUTTLE
3	2	500760 LIFTER - FEEDER PUSHER
4	2	500762 PLATE-FEEDER PUSHER BOTTOM
5	2	500775 PLATE-FEEDER PUSHER TOP
6	2	531117-01 ASSY, PUSHER

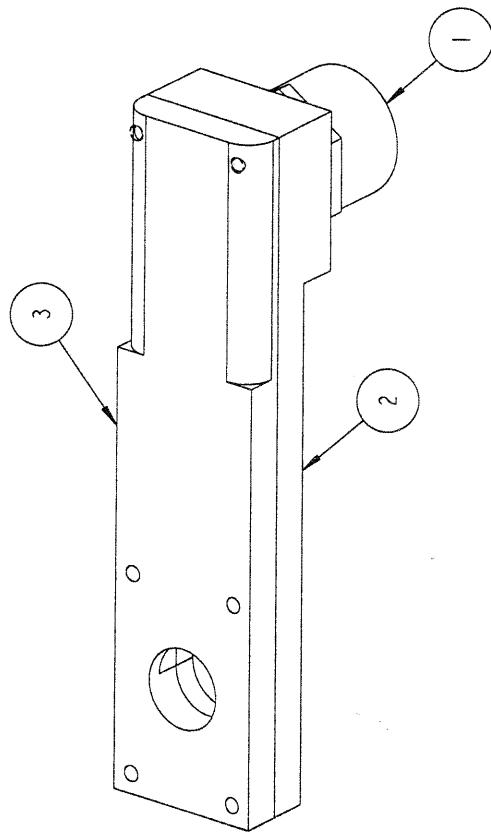


REV NO	DATE	DESCRIPTION	ECN NO	BY

1	215	RE'D WHERE USED
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. KEENESAW, GA 30044 USA		KIRK-RUDY INC. KEENESAW, GEORGIA
DRAWN BY: TVK	SCALE: 0 . 375	THIRD ANGLE PROJECTION
CHECKED BY:	DATE: 0 Mar - 99	MODEL: 215
TRACED BY:	MASTER M	SHEET NO. 1 OF 1
		DRAWING 1

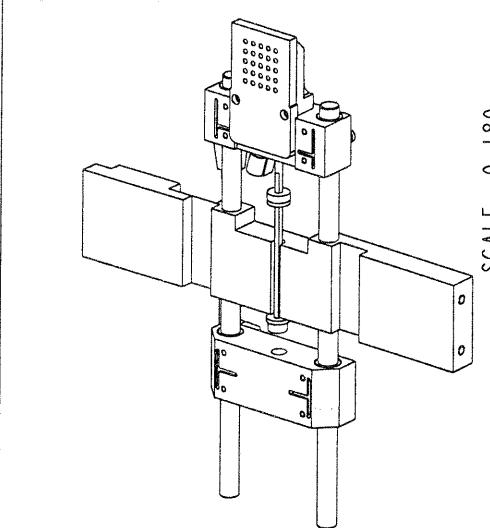
500705A

ITEM QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION:	ECN NO	BY
1	1	190715			PVC COUPLING		
2	1	SP28217-1			BLOCK, LOWER VACUUM		
3	1	SP28218-1			BLOCK, UPPER VACUUM		



X	ALL
RECD	WHERE USED
 KIRK - RUDY, INC. KENNESAW, GEORGIA	
<small>PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE COPIED OR REPRODUCED IN ANY FORM WITHOUT THE EXRESSES WRITTEN PERMISSION OF KIRK-RUDY, INC. KENNESAW, GA. 30144 USA</small>	
<small>THIRD ANGLE PROJECTION</small>	
	
MATERIAL: NOTED	
SCALE: 0 .500	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED
RHM	.xx .xxx ANG.
DATE: 24-JUL-98	.01 .005 .5
CHECKED BY: MASTER M	HEAT TREAT: NONE
TRACED BY:	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED
	ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY
MODEL: 215	FINISH: NONE
SHEET NO.: 10F1	TITLE: ASSY, VACUUM MANIFOLD
DRAWINGS:	
530656-01	

ITEM QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	1 102225	COLLAR .250					
2	1 103500	BEARING - ROD END					
3	1 109523	JUNCTION, 2 WAY					
4	1 109524	JUNCTION, 3 WAY					
5	1 500735	ROD - PUSH					
6	2 500737	WASHER - BUMPER					
7	2 500741	SHAFT - FEEDER					
8	1 500749	ROD - FEEDER SLIDE					
9	1 500708A	ASSY, VACUUM BODY					
10	1 500710-1	BRACKET - FEEDER SUPPORT					
11	1 500728A	ASSY, BUSHING BLOCK					
12	1 500751A	ASSY, BEARING BLOCK					
13	1 530253-01	RING					
14	1 RHB082	HEX HEAD BOLT					
15	2 RHNO12	HEX NUT					
16	1 WA013	WASHER					



SCALE 0.180

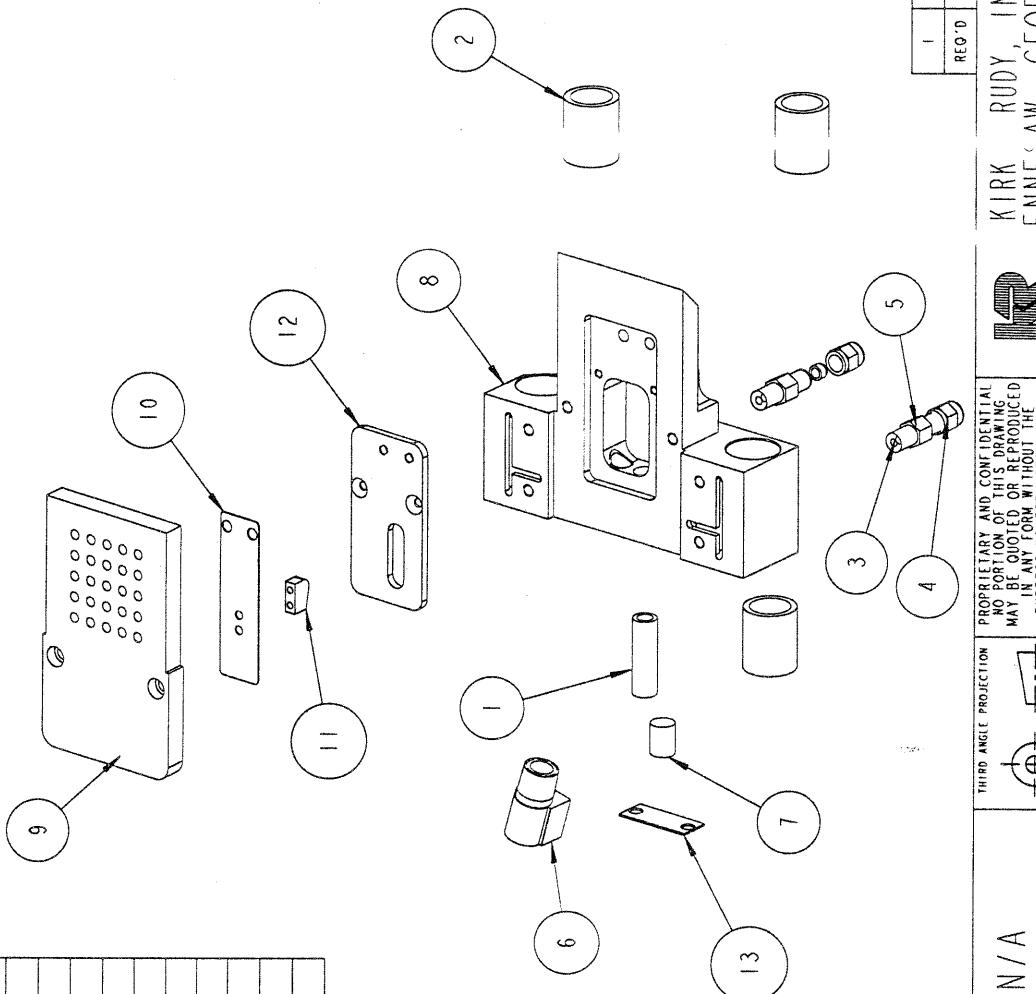
DRAWN BY:		SCALE	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED		MATERIAL:
	TVK	0.250	.005	.005	N/A
CHECKED BY:		DATE	.005	.005	HEAT TREAT:
TRACED BY:		05 - May - 98	.01	.005	N/A

REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED
ALL DIMENSIONS ARE FINISHED DIMENSIONS
DO NOT SCALE - WORK TO DIMENSIONS ONLY

THIRD ANGLE PROJECTION		PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE QUOTED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY INC. KENNESAW, GA 30040 USA		KIRK - RUDY, INC. KENNESAW, GEORGIA
TITLE:		ASSY, SHUTTLE TABLE		DRAWING #

MASTER	SCALE	DATE	DESCRIPTION	ECN NO	BY
	10F1	215	ASSY, SHUTTLE TABLE	01	531021-01

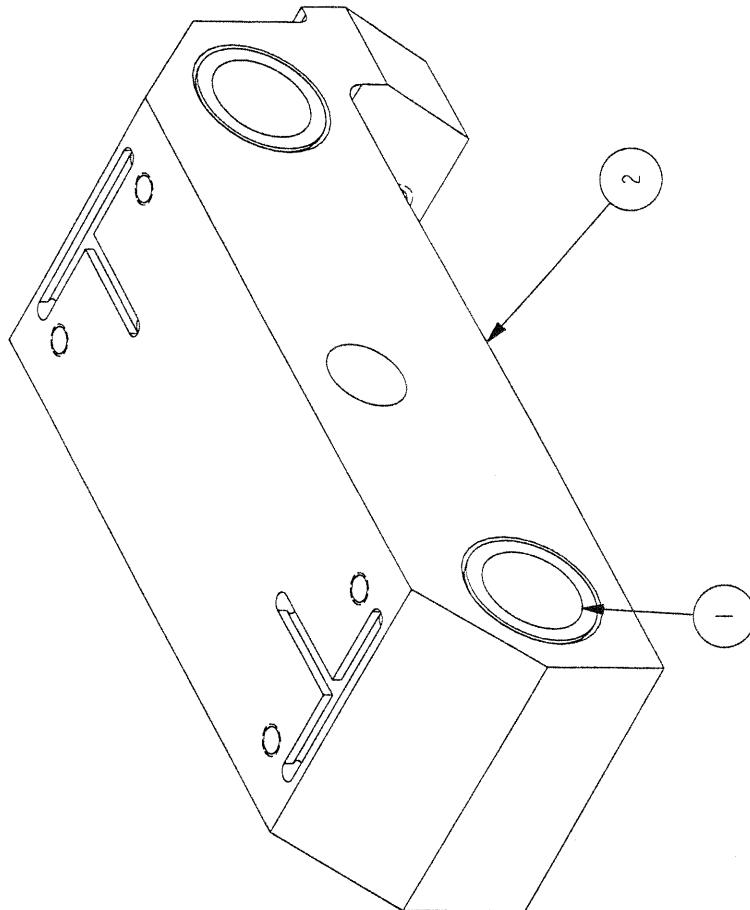
ITEM QTY	PART #	DESCRIPTION
1	100131	BUSHING, SL.250ID.3750DI.250LG
2	100145	BUSHING, SL.625ID.8130DI.000LG
3	2 109521	OIL METER UNIT
4	2 109528	NUT, COMPRESSION FEMALE
5	2 109537	SLEEVE, COMPRESSION
6	1 190606	FITTING - 90 DEG 1/4 NPT
7	1 190769	MAGNET, BUNTING
8	1 500708	BODY, VACUUM VALVE
9	1 500709	PLATE - VACUUM FEEDER
10	1 500738	SPRING - VALVE
11	1 500739	BLOCK - PUSHER
12	1 500740	PLATE - VACUUM
13	1 531155-01	PLATE, MAGNETIC



DRAWN BY:	SCALE	DATE	MADE BY:	REV NO	DATE	DESCRIPTION	ECN NO	BY
TVK	0 . 380	05 - May - 98	KIRK RUDY, INC.					
CHECKED BY:			KIRK RUDY, INC.					
TRACED BY:			KIRK RUDY, INC.					
DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED			MATERIAL: N/A			PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE COPIED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK RUDY, KENNSAW, GA 30430 USA		
.005 .005 .005			HEAT TREAT: N/A			ASSY, VACUUM B)DY		
.01 .005 .005			FINISH: N/A			DRAWING #: 500708A		
REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED			ALL DIMENSIONS ARE FINISHED DIMENSIONS			STREET NO: 10F1		
ALL DIMENSIONS ARE DO NOT SCALE - WORK TO DIMENSIONS ONLY								

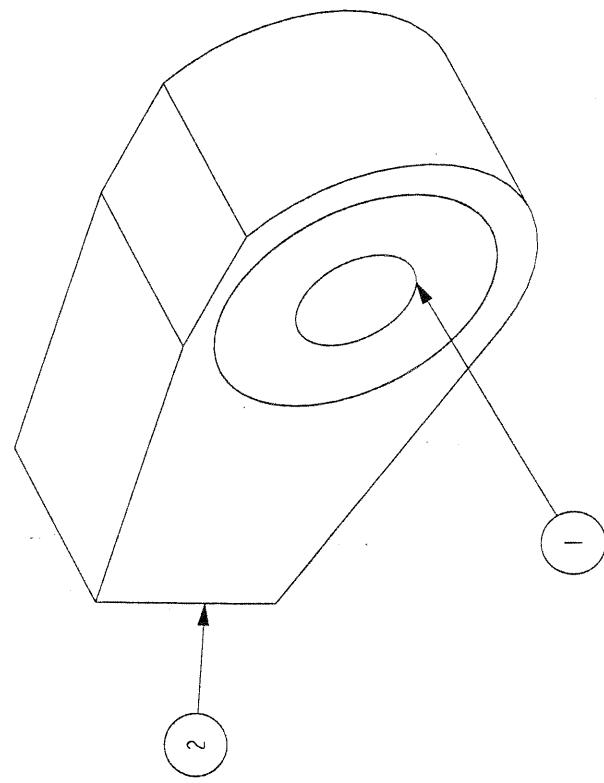
ITEM	QTY	PART #	DESCRIPTION
1	4	100145	BUSHING, SL. 625 ID 8130D1 .000LG
2	1	500728	BRACKET - FEEDER

REV NO	DATE	DESCRIPTION	FCN NO	BY



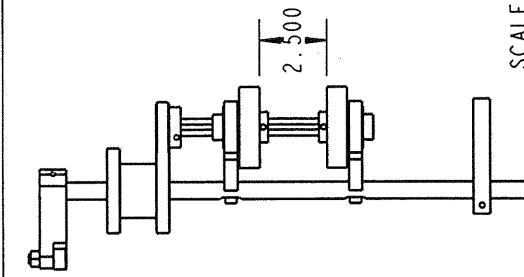
DRAWN BY:	MY	SCALE	.000	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED			MATERIAL:	N/A	THIRD ANGLE PROJECTION			PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE COPIED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY INC. KENNESAW, GA 30044 USA	REF'D WHERE USED
CHECKED BY:		DATE	09 - Apr - 99	.000 .005 .5			HEAT TREAT:	N/A	E-7				
TRACED BY:		MASTER	M	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED			FINISH:	N/A	MODEL: 215			ASSY, BUSHING BLOCK	TITLE:
				ALL DIMENSIONS ARE FINISHED DIMENSIONS					SHEET NO. 1 OF 1			DRAWING #	
				DO NOT SCALE - WORK TO DIMENSIONS ONLY					500728A				

ITEM	QTY	PART #	DESCRIPTION
1	2	103106	BEARING, FLAT .375
2	1	500751	YOLKE - FEEDER CRANK



DRAWN BY:	SCALE	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	MATERIAL:	THIRD ANGLE PROJECTION	PROPRIETARY AND CONFIDENTIAL NO COPIES OR DERIVED MAY BE QUOTED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC. KENNESAW, GEORGIA	RECD'D WHERE USED
MY	2.000	.XX .XXX .01 .005 .5	N/A	+---+ +---+	KIRK - RUDY, INC. KENNESAW, GEORGIA	I
CHECKED BY:	DATE		HEAT TREAT:			
	09-Apr-99		N/A			
TRACED BY:	MASTER		FINISH:		TITLE:	
	M		N/A		DRAWING #	
				10F1	500751A	

ITEM QTY	PART #	DESCRIPTION
1	101916	GEAR, 1628 .625B .188K
2	102701	SPRING
3	103405	CAM FOLLOWER
4	103804	BEARING - HUB
5	107104	BOLT, SHOULDER 5/16X3/4
6	500734	LEVER - CAM
7	500746	ROLLER - BOTTOM FEED
8	500786	LEVER, SPRING
9	500729-4L	ARM, FEEDER CRADLE HUBBRG LH
10	500729-4R	ARM, CRADLE FEEDER HUBBRG RH
11	500748-1	SHAFT - FEEDER ROLLER
12	500827-1	SHAFT, SPRING LEVER
13	531102-01	ASSY, HUB GEAR
14	RHN012	HEX NUT



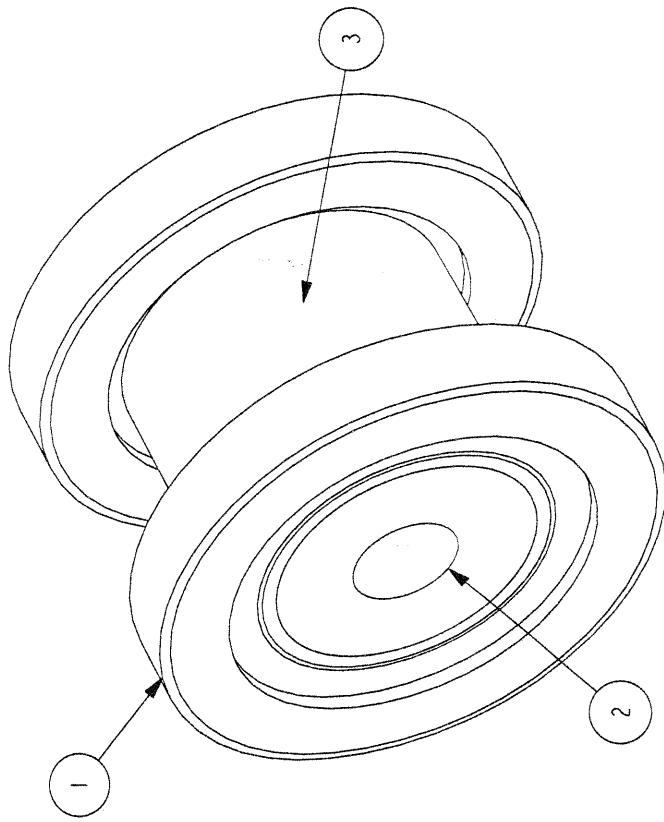
SCALE 0.156

REV NO	DATE	DESCRIPTION	ECN NO	BY
1	11/24/2000	REPLACE 500729-2 WITH 500729-4 REPLACE FLAT BRG W/ HUB BRG	6624	TJG

I	5336173-01
REQ'D	WHERE USED

DRAWN BY: TVK	SCALE 0 . 313	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED		MATERIAL: XXX	THIRD ANGLE PROJECTION - - -	PROPRIETARY AND CONFIDENTIAL NOT FOR USE OR DISCLOSURE MAY BE QUOTED ON THE PROVIDED IN PART FORM, WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK RUDY INC., USA KENNESAW, GA 30442, USA
CHECKED BY:	DATE 04-May-98	.01	.005	HEAT TREAT: XXX	MODEL: XXX	TITLE: ASSY, LOWER FEED ROLLER
TRACED BY:	MASTER	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED		FINISH: XXX	SHEET NO. 1 OF 1	DRAWING # 531022-01

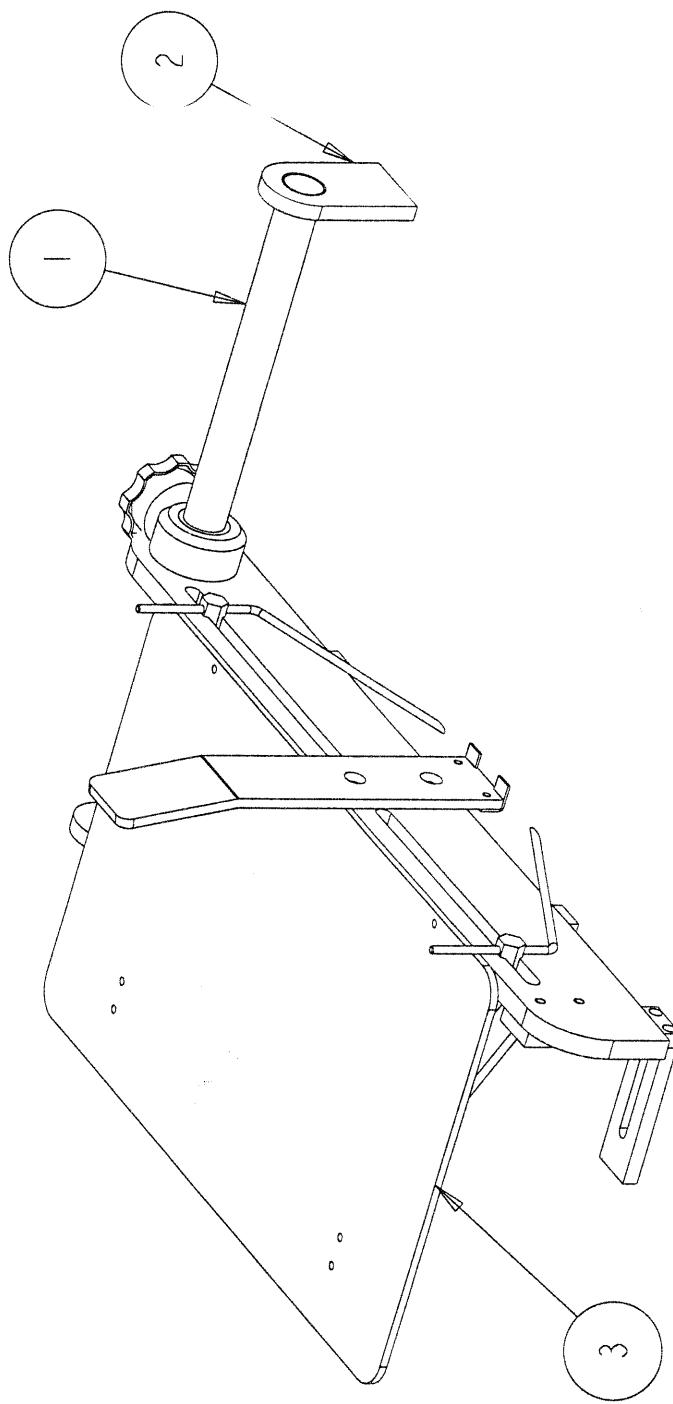
ITEM QTY	PART #	DESCRIPTION
1 2	101918	GEAR, FEED ROLLER DRIVE
2 2	103804	BEARING, HUB .625
3 1	503622	HUB, GEAR



REV NO	DATE	DESCRIPTION	ECN NO	BY

DRAWN BY:	SCALE	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED			MATERIAL:	THIRD ANGLE PROJECTION			PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE QUOTED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC. KENNESAW, GA 30144 USA
MY	.000	.XX	.XXX	ANG.	N / A				KIRK - RUDY, INC. KENNESAW, GEORGIA
CHECKED BY:	DATE	.01	.005	5	HEAT TREAT:	MODEL: 215			TITLE: ASSY, HUB GEAR
TRACED BY:	MASTER	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED			FINISH:	SHEET NO: 1 OF 1			DRAWING #: 531102-01
	M	ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY							

ITEM QTY	PART #	DESCRIPTION
1	1	500769 SHAFT - REAR GUIDE
2	2	500832 BRACKET-REAR-GUIDE
3	1	500714-A ASSY, REAR BRIDGE



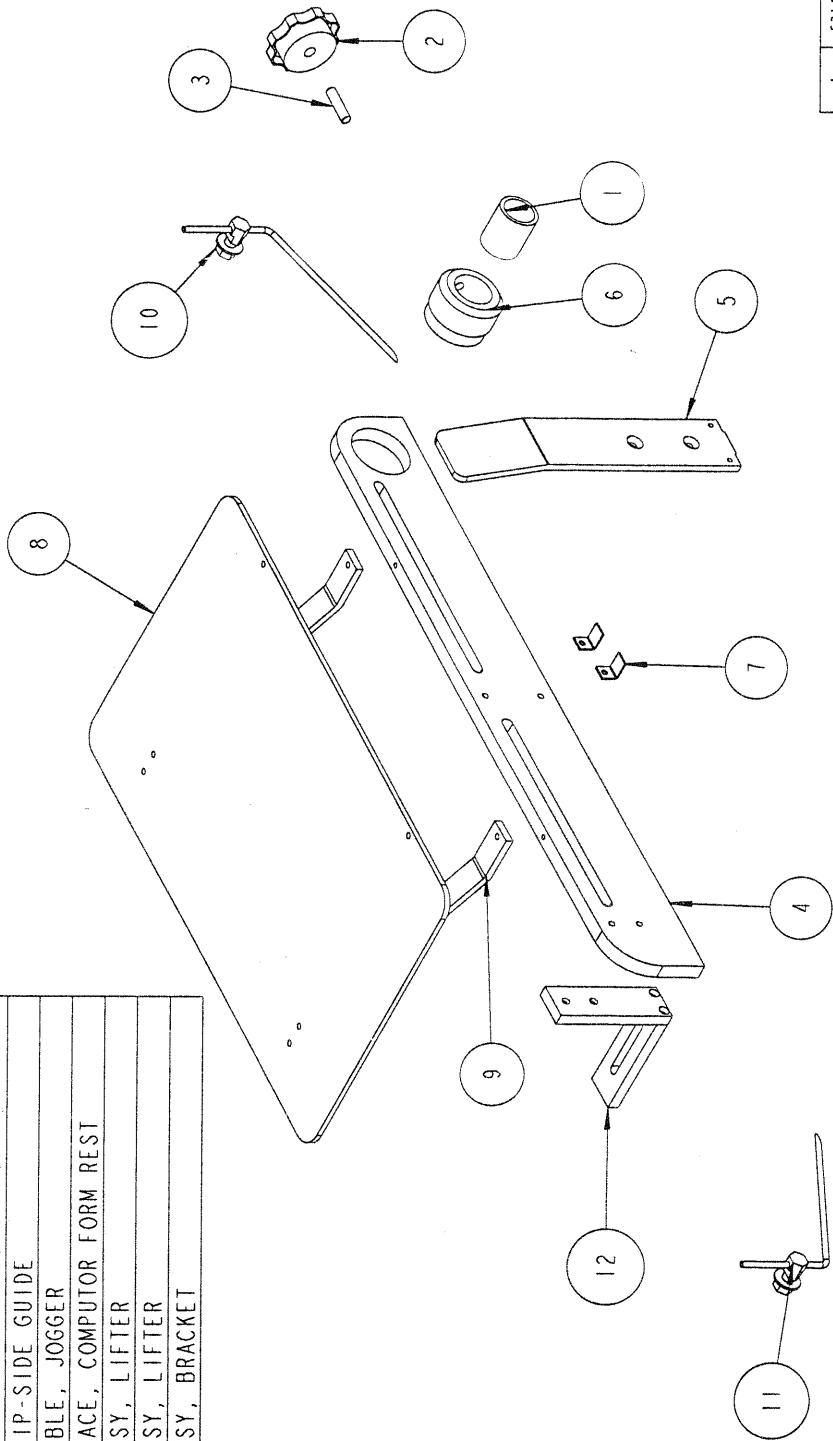
1.000	215
REQ'D	WHERE USED
KRK	KIRK RUDY, INC.
	KENNESW, GEORGIA
MODEL:	215
SHEET NO.	10F1
DRAWING #	531405-01

PROPRIETARY AND CONFIDENTIAL
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IN ANY FORM WITHOUT THE
EXPRESS WRITTEN PERMISSION
OF KIRK-RUDY, INC.
KENNESW, GA 30144 USA

THIRD ANGLE PROJECTION

TITLE: ASSY, JOGGER TABLE

ITEM QTY	PART #	DESCRIPTION
1	100109	BUSHING, SLI.0001DI.2500DI.500LG
2	102112	KNOB, PURCHASED
3	105601	SHAFT, THREADED 5/16-18
4	500714	BRIDGE - READ GUIDE
5	500715	PLATE - REAR CENTER GUIDE
6	500770	HUB - REAR GUIDE SHAFT
7	500771	CLIP-SIDE GUIDE
8	500845	TABLE, JOGGER
9	500847	BRACE, COMPUTER FORM REST
10	500764AL	ASSY, LIFTER
11	500764AR	ASSY, LIFTER
12	500880A	ASSY, BRACKET



DRAWN BY:

N J G

SCALE

0 . 188

REV NO

1

DATE

09 APR 99

REMOVED SPACER

500765

ECN NO

6458

BY

MF

REQ'D WHERE USED

1

531405-01

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EXPRESS WRITTEN PERMISSION

OF KIRK RUDY, INC.

KENNESAW, GA 30044 USA

TITLE:

ASSY, REAR BRIDGE

THIRD ANGLE PROJECTION

+---+

+---+

+---+

+---+

+---+

+---+

+---+

+---+

MODEL:

215

SHEET NO.:

10F1

DRAWING #:

500714-A

REMOVED SPACER

500765

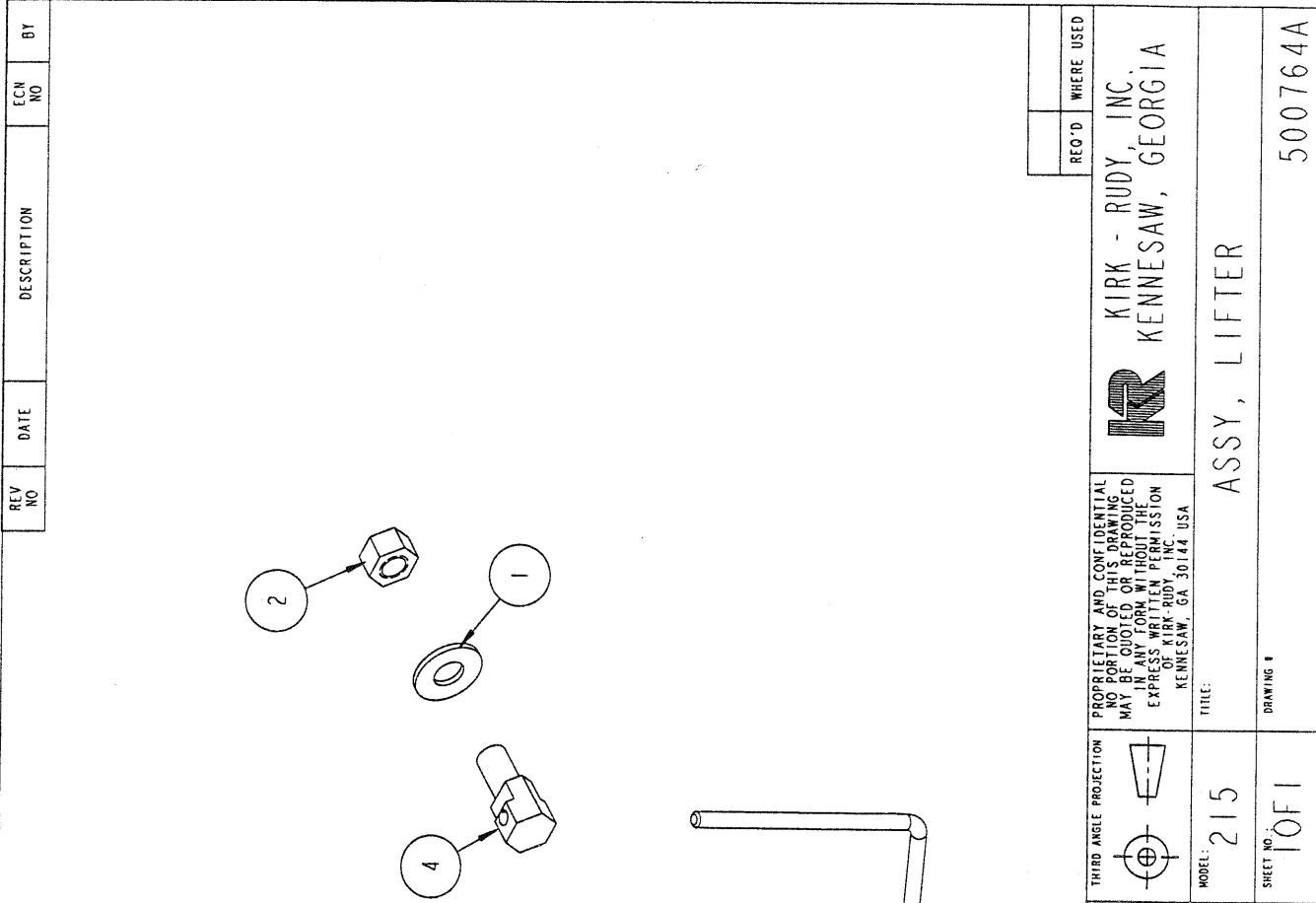
ECN NO

6458

BY

MF

ITEM QTY	PART #	DESCRIPTION
1	100601	THRUST WASHER
2	106702	NUT, 3/8-16
3	500764	LIFTER - REAR BRIDGE
4	500766	SCREW - MACHINE REAR GUIDE



REV NO	DATE	DESCRIPTION	ECN NO	BY	RECD WHERE USED

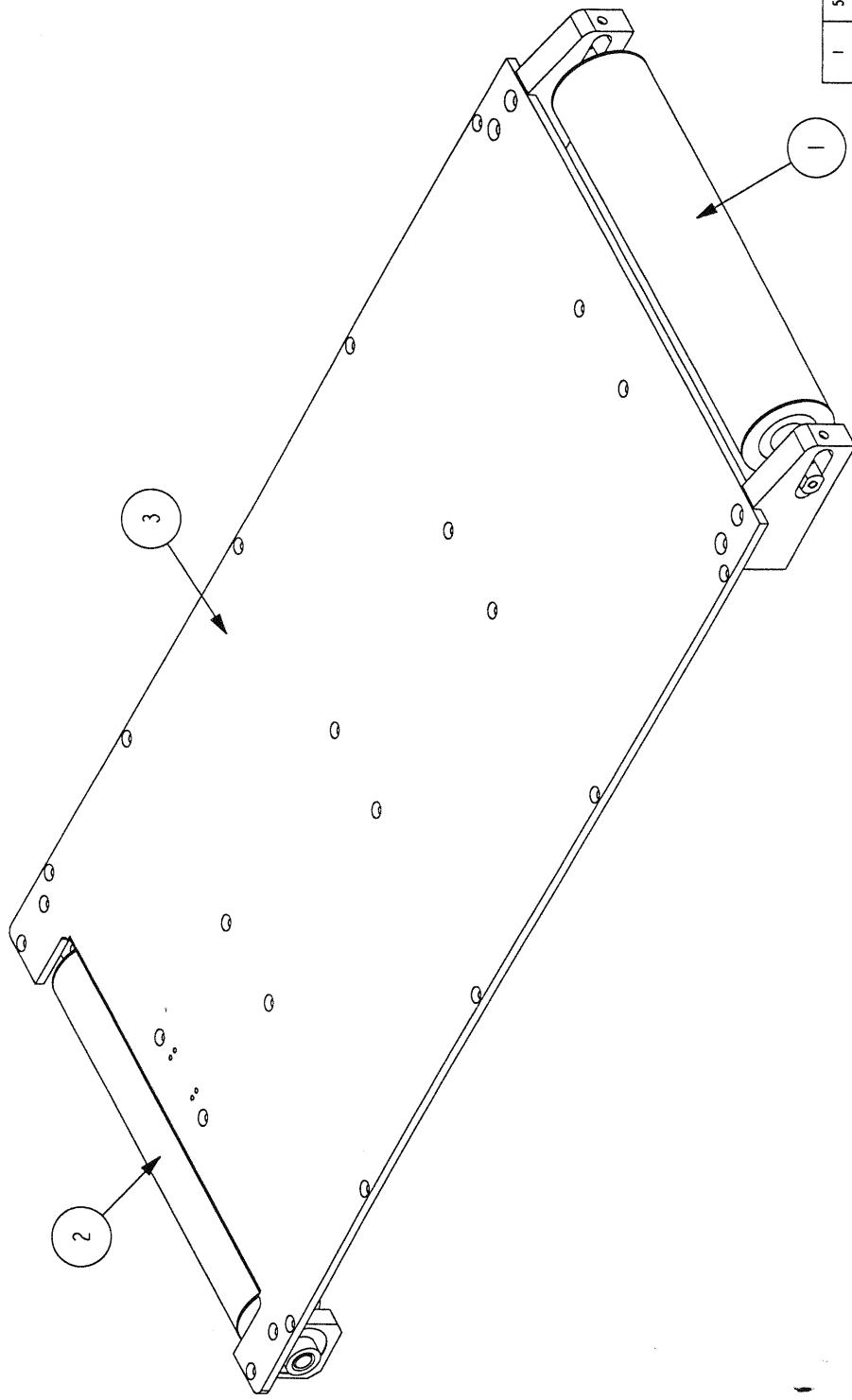
DRAWN BY: N JG	SCALE 0 . 500	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	THIRD ANGLE PROJECTION		PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE QUOTED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY INC. KENNESAW, GA 3014 USA
			.xx	.xxx	
CHECKED BY:	DATE 23 - Jul 1 - 97	HEAT TREAT: N/A	.01	.005	
TRACED BY:	MASTER W	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. 10F1	DRAWING # ASSY, LIFTER	
					500764A

ITEM	QTY	PART #	DESCRIPTION
1	1	500878	SUPPORT - JOGGER TABLE
2	1	500880	BRACKET - JOG TABLE SUPP

REV NO	DATE	DESCRIPTION	ECN NO	BY	RECD WHERE USED

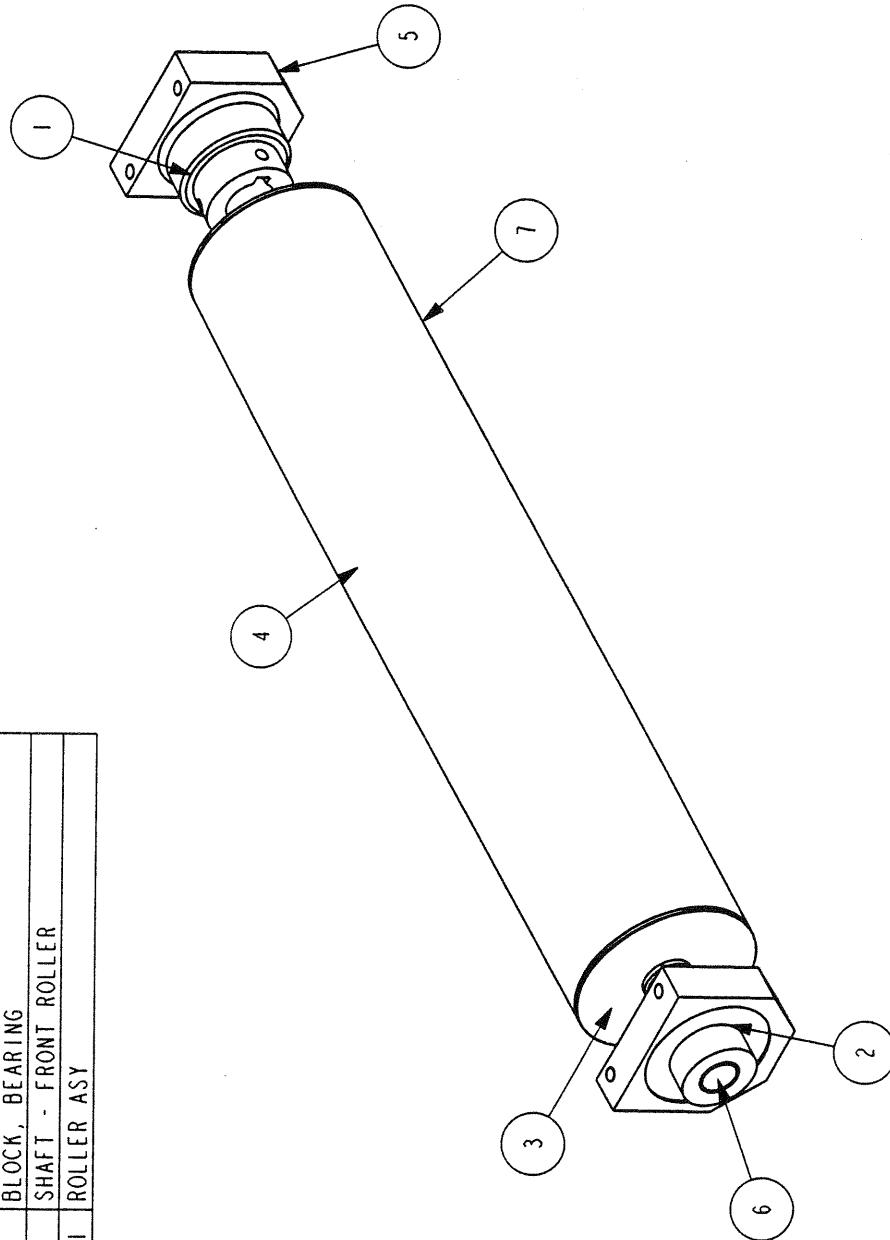
DRAWN BY: NJG	SCALE: 1 . 000	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED		MATERIAL: N/A	THIRD ANGLE PROJECTION	PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE QUOTED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC. KENNESAW, GEORGIA KIRK-RUDY, INC. KENNESAW, GEORGIA GA 30144 USA	
CHECKED BY:	DATE: 24-JUL-97	.XX	.XXX	ANG. 01 005 .5	HEAT TREAT:	N/A	TITLE: ASSY , BRACKET
TRACED BY:	MASTER	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED				MODEL: 215	SHEET NO. OF 1
		ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE WORK TO DIMENSIONS ONLY				DRAWING #	500880A

ITEM QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	1	530619-01 ASSY, IDLER ROLLER					
2	1	531274-01 ASSY, FRONT ROLLER DRIVE					
3	1	SP30201-1 TABLETOP 30.5 IN EXT. CANTER VACUUM					



DRAWN BY:	SCALE	0 . 250	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED		MATERIAL: XXX	THIRD ANGLE PROJECTION	PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE QUOTED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC. KENNESAW, GA 3044 USA	
CHECKED BY:	DATE	.XX	XXX	AMG.	HEAT TREAT: XXX	MODEL: 215	NAME:	ASSY - TOP , 2151J
TRACED BY:	MASTER	.01	.005	.5	FINISH: XXX	SHEET NO: 0F1	DRAWING #	533442-01
		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	101917 GEAR, 1621 .625B .188K					
2	2	103803 BEARING, HUB .500					
3	2	500839 HUB-BELT DRIVE					
4	1	500742-4 ROLLER - TUBE BELT DRIVE					
5	2	500819-1 BLOCK, BEARING					
6	1	500828-1 SHAFT - FRONT ROLLER					
7	1	530676-01 ROLLER ASY					



I	535289-01
REQ'D	WHERE USED
KIRK - RUDY, INC.	KENNEBUNK, GEORGIA
PROPRIETARY AND CONFIDENTIAL	NO PORTION OF THIS DRAWING
© KIRK-RUDY INC.	MAY BE QUOTED OR REPRODUCED
ALL DIMENSIONS IN INCHES	IN ANY FORM WITHOUT THE
EXCEPT WRITTEN PERMISSION	EXPRESS WRITTEN PERMISSION
OF KIRK-RUDY INC.	OF KIRK-RUDY INC.
KENNEBUNK, GA 30144 USA	KENNEBUNK, GA 30144 USA
MODEL: 215	TITLE: ASSY, FRONT ROLLER DRIVE
SHEET NO. 1 OF 1	DRAWING # 531274-01

ITEM	QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	2	103804	BEARING, HUB .625					
2	2	500716	BRACKET - BELT TAKE-UP					
3	1	500823	SHAFT, IDLER ROLLER					
4	1	500835	ROLLER, BELT IDLER					
5	2	500836	HUB-BELT ROLLER					

DRAWN BY:	A KEY	SCALE	0 .410	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
CHECHED BY:	01 - Mar - 99	DATE	.01	.005	.5	ANG.	HEAT TREAT:	N/A	MODEL:	SP71700	TIME:
TRACED BY:	MASTER	MASTER	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED						SHEET NO.	10F1	DRAWING #
			ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE. WORK TO DIMENSIONS ONLY								530619-01

I	SP71700
RECD	WHERE USED

ITEM	QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	2	100162	BUSHING, SL.500 ID.625OD 625LG					
2	1	102114	KNOB					
3	1	102205	COLLAR .500					
4	2	103107	BEARING, FLAT .312					
5	1	105201	PIN, ROLL .125X 1.000					
6	1	105602	SHAFT, THREADED 5/16-18					
7	1	190101	MICROSWITCH, LEVER					
8	1	190203	COVER, MICROSWITCH					
9	1	500800	LINK-SKID-FRONT					
10	1	500801	LINK-SKID-REAR					
11	1	500802	HOLDER-SKID SWITCH					
12	2	500834	SHAFT, SKID ROLLER					
13	1	503794	CLAMP					
14	1	190101A	ASSY-SWITCH WITH COVER					
15	1	500723-8	CHANNEL, SKID					
16	1	500800-A	ASSY, LINK					
17	1	500801A	ASSY, LINK					
18	1	500802A	ASSY, CLAMP					
19	2	500834A	ASSY, STUD WITH BEARING					
20	2	SP37359	SHAFT, SKID BAR SPACER					

SCALE 0 .500

DRAWN BY: A.Y.B. DATE: 0.750 DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED MATERIAL: N/A

CHECKED BY: 15 - NOV - 99 REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED DATE: N/A

TRACED BY: MASTER TRIM: N/A HEAT TREAT: N/A

RECD WHERE USED: 1 KRT191J20
1 KR2191J

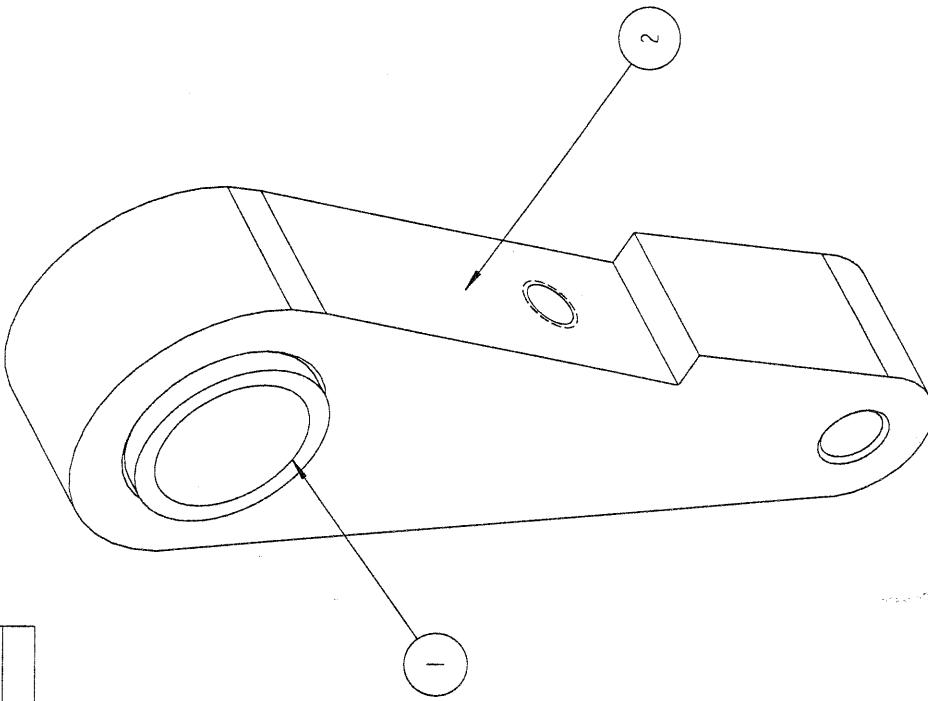
PROPRIETARY AND CONFIDENTIAL
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OF KIRK-RUDY, INC.,
KENNESAW, GA 30144 USA

KIRK - RUDY, INC.
KENNESAW, GEORGIA

TITLE: ASSY, SKID BAR

MODEL: 2191J SHEET NO. 1 OF 1 DRAWING # 538021-01

ITEM	QTY	PART #	DESCRIPTION
1	1	100162	BUSHING, SLEEVE .500
2	1	500800	LINK-SKID-FRONT



REV NO	DATE	DESCRIPTION	ECN NO	BY

I	533821-01
REQ'D	WHERE USED

KIRK-RUDY, INC.
KENNESAW, GEORGIA

ASSY, LINK

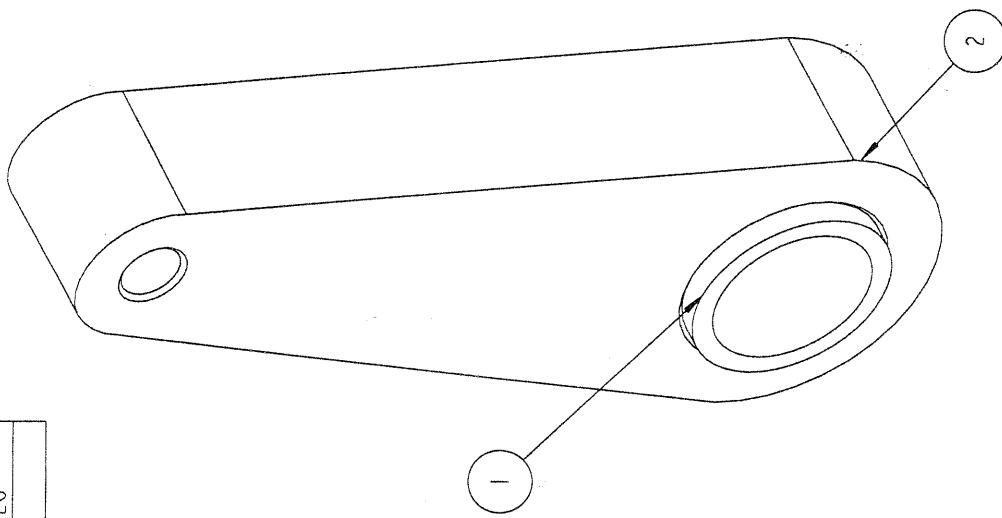
500800-A

DRAWN BY:	SCALE	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED		MATERIAL:	THIRD ANGLE PROJECTION		PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE QUOTED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC. KENNESAW, GA 30144 USA
checked by:	DATE	.XX	XXX	ANG.	.01	.005	.5
TRACED BY:	MASTER	2	- May - 98	HEAT TREAT:	N/A	N/A	TIME:
				REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED			
				ALL DIMENSIONS ARE FINISHED DIMENSIONS			
				DO NOT SCALE - WORK TO DIMENSIONS ONLY			
					SHEET NO.	10F1	DRAWING #

DRAWING #

500801A

ITEM QTY	PART #	DESCRIPTION
1	100162	BUSHING, SL. 5001D. 6250D. 625LG
2	500801	LINK-SKID-REAR



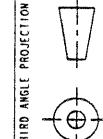
REV NO	DATE	DESCRIPTION	ECN NO	BY
1				
1				

REC'D	WHERE USED
1	533821-01
1	531925-01

KIRK - RUDY, INC.
KENNESAW, GEORGIA

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IN ANY FORM WITHOUT THE
EXPRESS WRITTEN PERMISSION
OF KIRK-RUDY, INC.
KENNESAW, GA 30144, USA

THIRD ANGLE PROJECTION
TITLE:



MODEL: 215

SHEET NO: 10F1

DRAWING #: 500801A

SCALE: MY

SCALE: 2.000

SCALE: N/A

MATERIAL: N/A

DIMENSIONAL TOLERANCES
UNLESS OTHERWISE NOTED

XX .XX ANG.

.01 .005 .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

DATE: 08-May-98

CHECKED BY:

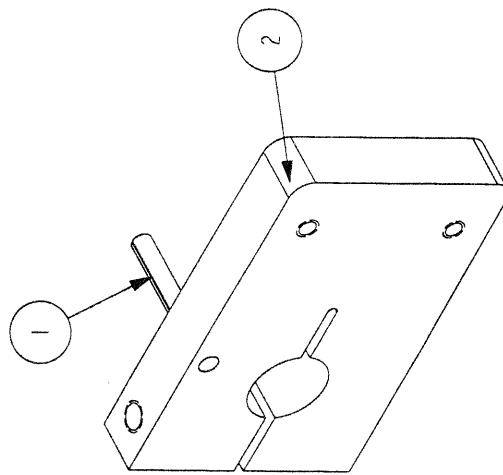
MASTER M

TRACED BY:

ASSY, LINK

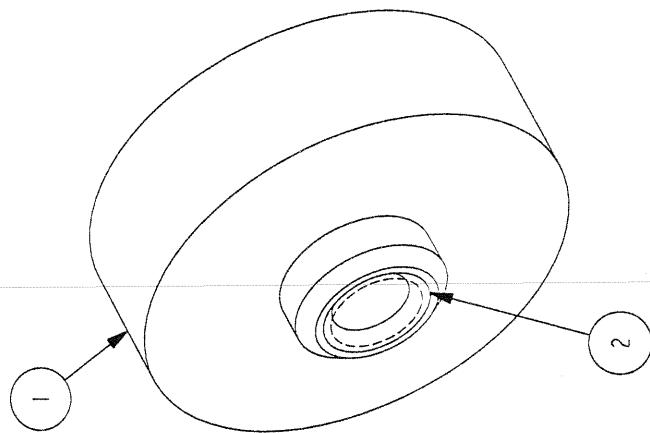
ITEM QTY	PART #	DESCRIPTION
1	105201	PIN, ROLL .125X 1.000
2	500802	HOLDER-SKID SWITCH

REV NO	DATE	DESCRIPTION	ECN NO	BY



DRAWN BY:	MY	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. KENNESAW, GA. 30144 USA		
CHECKED BY:		DATE	xx/xx/xx	XX	XXX	ANG.	.01	.005	5	HEAT TREAT:	N/A	KIRK RUDY, INC.		
TRACED BY:	MASTER	DATE	12-Apr-99	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED			ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY			MODEL:	215	KENNESAW, GEORGIA		
				FINISH:			SHEET NO.:			DRAWING #:	OF 1			
														ASSY, CLAMP
														500802A

ITEM	QTY	PART #	DESCRIPTION
1	1	103107	BEARING, FLAT .312
2	1	500834	SHAFT, SKID ROLLER

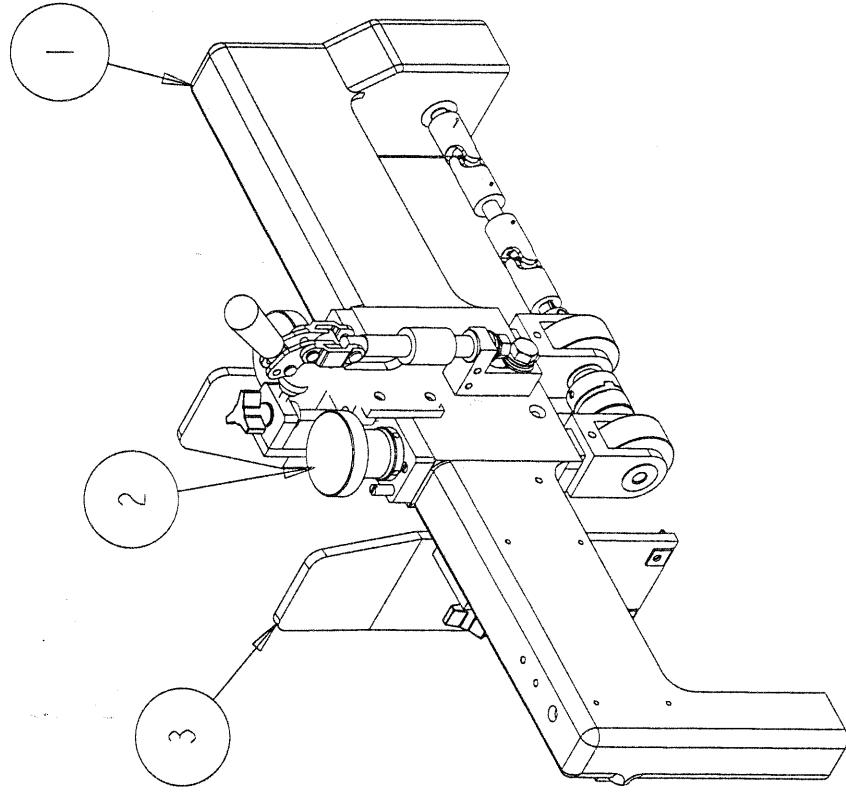


REV NO	DATE	DESCRIPTION	FCN NO	BY
-----------	------	-------------	-----------	----

DRAWN BY:		SCALE	DIMENSIONAL TOLERANCES		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		RECD WHERE USED	
MY		3 . 0 0 0	UNLESS OTHERWISE NOTED XX XXX .005 .5		N / A					6 533821-01	
CHECKED BY:		DATE	HEAT TREAT:		N / A	MODEL: 215		TITLE: ASSY, STUD WITH BEARING			
12 - Apr - 99		REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED									
TRACED BY:		MASTER	FINISH:		N / A	SHEET NO.: 10F1		DRAWING:			
M											

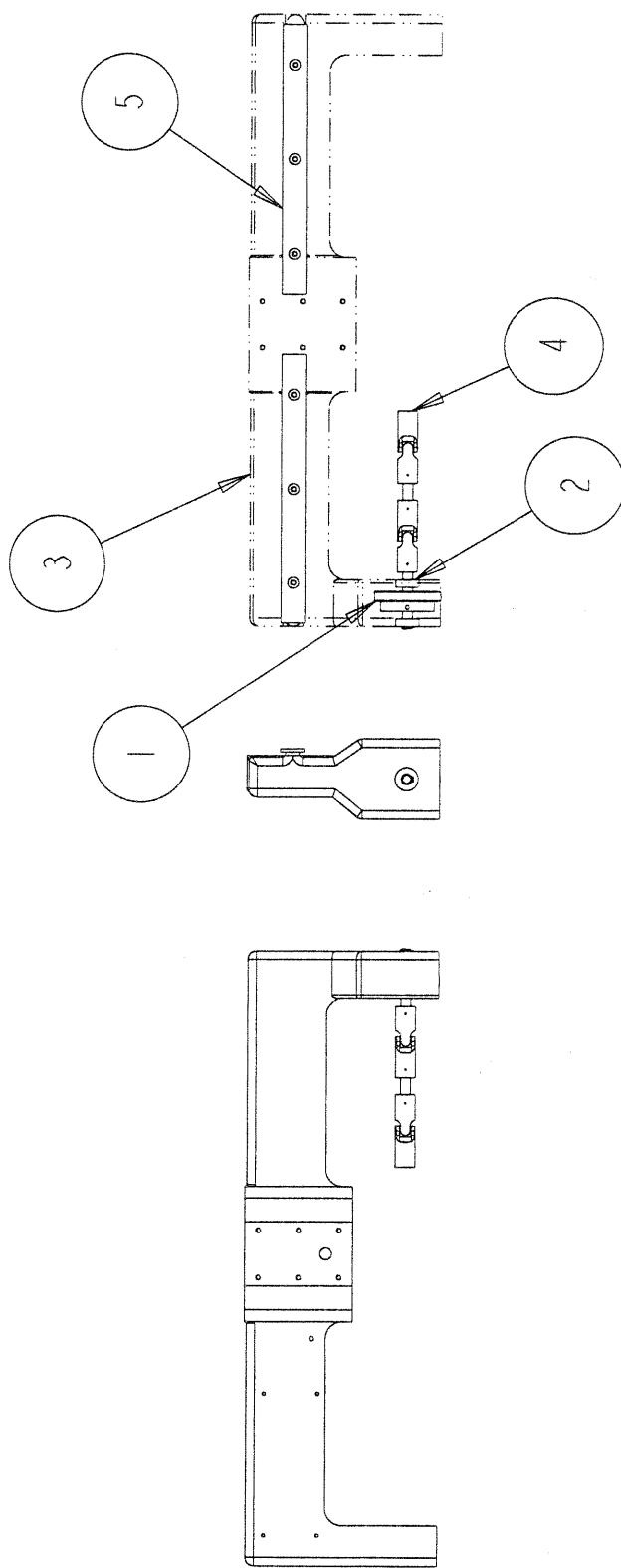
ITEM	QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	2	190202	BUSHING, PLASTIC					
2	1	500702-4L	TABLE TOP, L/H SIDE					
3	1	500702-4R	TABLE TOP, R/H SIDE					
DRAWN BY:		SCALE	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	MATERIAL:		THIRD ANGLE PROJECTION	PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE COPIED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC. KENNESAW, GA 30144 USA	
CHECKED BY:		DATE	.XX XXX ANG.	HEAT TREAT:			TITLE:	
TRACED BY:		MASTER	.01 .005 .5	N/A			ASSY, 2151J OUTSIDE TABLETOP	
				N/A			DRAWING #	
				N/A			534319-01	

ITEM QTY	PART #	DESCRIPTION
1	500704A	ASSY, BRIDGE
2	531582-01	EG ASSY, BRIDGE DRIVE AND GATE
3	535412-01	ASSY, SIDE GUIDE



DRAWN BY:	SCALE	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	MATERIAL:	THIRD ANGLE PROJECTION	RECORD	WHERE USED
TVK	0 . 250	.XX XXX .005 .005 .5	N / A		215	KIRK - RUDY, INC. KENNESAW, GEORGIA
CHECKED BY:	DATE		HEAT TREAT:			
	26 - Feb - 99		N / A			
TRACED BY:	MASTER		FINISH:			
	M		N / A			
			DO NOT SCALE - WORK TO DIMENSIONS ONLY			
						DRAWING 4
						ASSY, 215 STD BRIDGE
						535411-01

ITEM	QTY	PART #	DESCRIPTION
1	1	101707	GEAR, 2048 .375B NK
2	2	103106	BEARING, FLAT .375
3	1	500704	BRIDGE - FEEDER
4	1	500726A	ASSY, SHAFT UNIVERSAL
5	2	500814-1A	ASSY, SIDE GUIDE RAIL

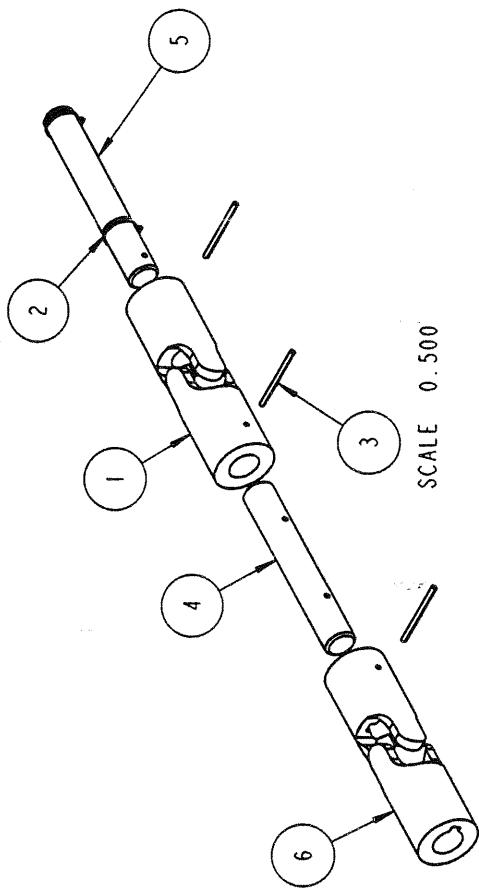


ITEM	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	535411-01				REQ'D WHERE USED

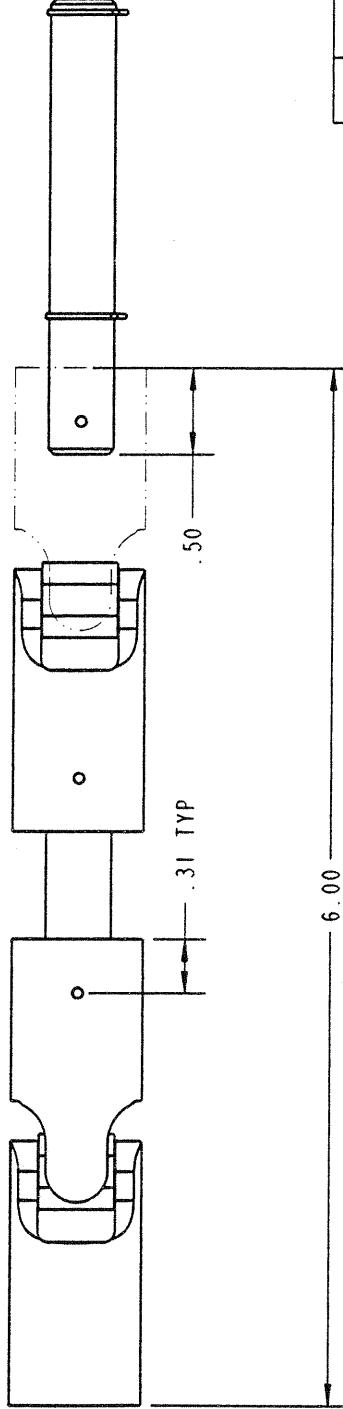
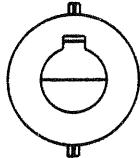
1	535411-01	
REQ'D WHERE USED		
KRK	KIRK-RUDY, INC.	
KRK	KENNEBUNK, GEORGIA	
PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE QUOTED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC. KENNEBUNK, ME 04044 USA		
THIRD ANGLE PROJECTION		
SCALE: 0.156	MATERIAL: N/A	MODEL: 215
DRAWN BY: TVK	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	TITLE: ASSY, BRIDGE
CHIEVED BY:	DATE: 26-Feb-99	DRAWING #:
TRACED BY:	TIME: .01 .005 .5	SHEET NO: 10F1
	HEAT TREAT: N/A	
	FINISH: N/A	
	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	1 100800	ASSY, UNIVERSAL JOINT
2	1 04100	SNAPRING, .375
3	1 05200	PIN, ROLL .063X.875
4	1 500803	SHAFT-UNIVERSAL JOINT
5	1 500830	SHAFT - UNIVERSAL DRIVE
6	1 100800-1	ASSY, UNIVERSAL JOINT

REV NO	DATE	DESCRIPTION	ECN NO	BY
1	28-JAN-98	REDRAW IN PROJE	6254	NJG
2	07-OCT-98	CHANGED JOINT TO AS BUILT	6389	WT

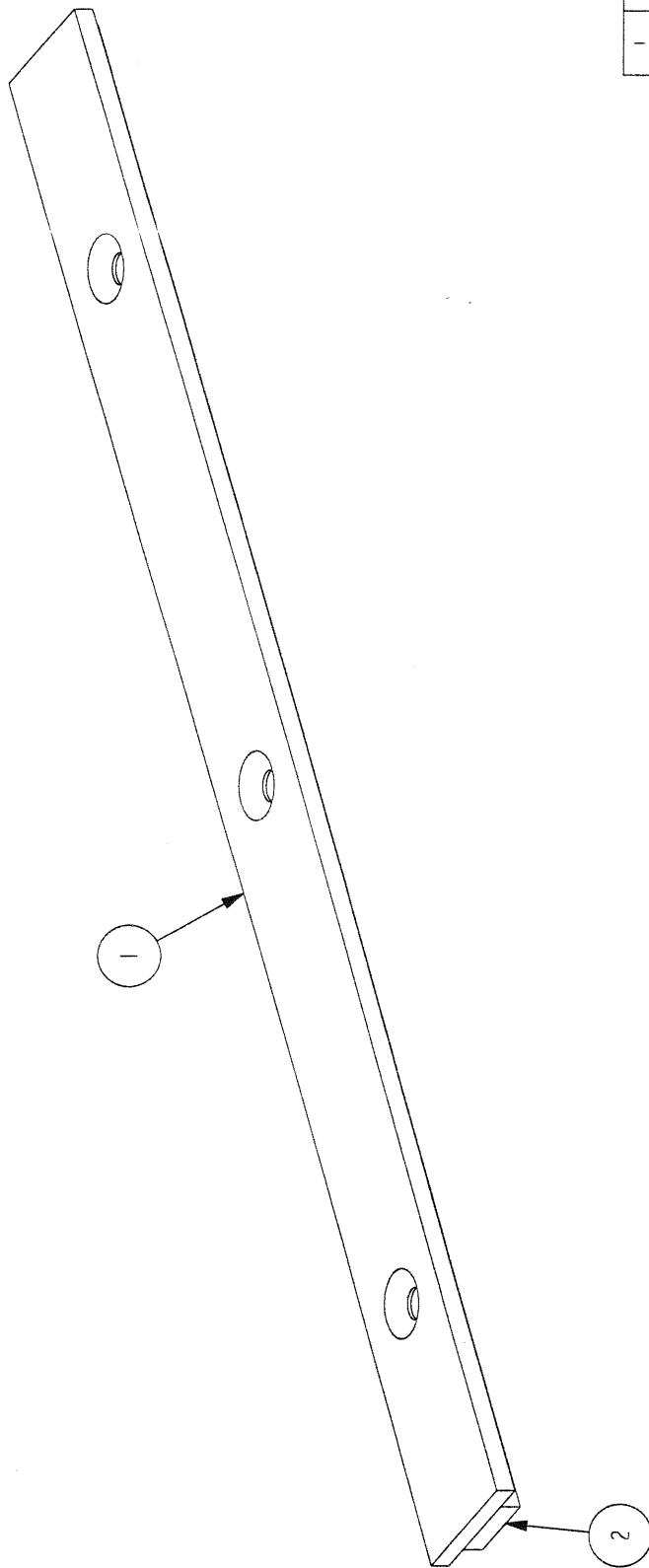


SCALE 0.500

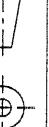


DRAWN BY:	SCALE:	NOTED	THIRD ANGLE PROJECTION	PROPRIETARY AND CONFIDENTIAL
TVK	.000			NO PORTION OF THIS DRAWING MAY BE QUOTED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC. KENNESAW, GA 30044 USA
CHECDED BY:	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	MATERIAL		KIRK - RUDY, INC.
TRACED BY:	DATE: 21-FEB-89	NOTED		KENNESAW, GEORGIA
	.01 .005 .005	NOTED		ASSY, SHAFT UNIVERSAL
MASTER	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED	HEAT TREAT: NONE	MODEL: 324M	DRAWING # 500726A
	ALL DIMENSIONS ARE FINISHED DIMENSIONS	FINISH: NOTED	SHEET NO: 1 OF 1	
	DO NOT SCALE - WORK TO DIMENSIONS ONLY			
				RECD'D WHERE USED
				1 324M

ITEM QTY	PART #	DESCRIPTION
1	1	500814-1 RAIL - SIDE GUIDE
2	1	500814-2 RAIL - SIDE GUIDE



ITEM	REV NO	DATE	DESCRIPTION	ECN NO	BY

1	500704A	REQ'D WHERE USED						
KIRK - RUDY, INC.	KENNEBUNK, GEORGIA							
								
PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE COPIED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC. KENNEBUNK, GA 30144 USA								
DRAWN BY: MY	SCALE .000	THIRD ANGLE PROJECTION 						
CHECKED BY:	DATE 12-Apr-99	MATERIAL: N/A						
TRACED BY:	MASTER M	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
.XX	.XXX	ANG.						
.01	.005	.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						
		SHEET NO 10F1						
		TITLE: ASSY, SIDE GUIDE RAIL						
		DRAWING # 500814-1A						

Drawing # 531582-01					
ITEM #	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION
					ECF 40 BY
1	2	100400 THRUST WASHER			
2	1	100402 THRUST WASHER			
3	2	100409 THRUST WASHER			
4	2	101100 ONE WAY BEARING			
5	1	102114 KNOB			
6	1	102117 KNOB			
7	1	102225 COLLAR			
8	1	102345 SHIM			
9	2	102101 SPRING			
10	4	103106 BEARING - FLAT			
11	2	104400 BOLT - HEX HEAD			
12	1	190600 SPIDER - ROLLER DRIVE			
13	1	190685 LEVER - QUICK RELEASE			
14	1	500130 PLATE, GATE FEEDER			
15	1	500143 SHAFT - TOP ROLLER DRIVE			
16	1	500144 SHAFT - TOP ROLLER ASSY			
17	2	500145 ROLLER - IDLER			
18	1	500195 PLATE - BACK			
19	2	500805 PLATE - HOLD DOWN			
20	1	500806 PLATE - GATE END			
21	2	500807 NUT - LOCK			
22	1	500808 PLATE - TOP BRIDGE			
23	2	500809 SLEEVE - THREADED			
24	1	500810 SHAFT - SCREW ADJ			
25	2	500811 FORK ASY			
26	2	500812 KNOB, ROLLER ADJUSTMENT			
27	2	500859 SPACER			
28	1	102114A ROUND KNOB ASY			
29	1	102200-2 COLLAR			
30	1	500143-2 SHAFT - TOP ROLLER			
31	2	500144-5 COLLAR - TOP ROLLER SHAFT			
32	1	500144-6 SHAFT - TOP ROLLER			
33	2	500145A UPPER FEED ROLLER ASSY			
34	1	500199-5 BLOCK, CLAMP SUPPORT			
35	2	500199-6 STUD, BRIDGE (LONG)			
36	2	500199-7 STUD, BRIDGE (SHORT)			
37	1	500199-2 BLOCK - CONNECTOR			
38	1	500199-3 CLAMP - MOUNTING PLATE			
39	2	500811A FORK ASY WITH BEARINGS			
40	1	531582-01 EG BRIDGE DRIVE AND GATE ASY			
41	2	531584-01 EG FORK ASY			
42	2	531672-01 BAR, FORK			
43	2	531673-01 YOKE			
44	1	RHB051			
45	1	RHB081			
46	1	SYA590			
47	1	WHS010			
48	1	WHS011			

DRAWING
531582-01

 REV D WHERE USED
 KIRK - RUDY, INC.
 KENNESAW, GEORGIA
 KIRK RUDY, INC.
 ELEMENT, GA 30044 USA
 EG BRIDGE DRIVE AND GATE ASY
 DRAWN, 531582-01

DRAWING
531582-01

 PROPRIETARY AND CONFIDENTIAL
 THIS DRAWING MAY NOT BE COPIED OR REPRODUCED
 EXCEPT AS AUTHORIZED IN THE
 CONTRACT DOCUMENT
 KIRK RUDY, INC.
 ELEMENT, GA 30044 USA
 EG BRIDGE DRIVE AND GATE ASY
 DRAWN, 531582-01

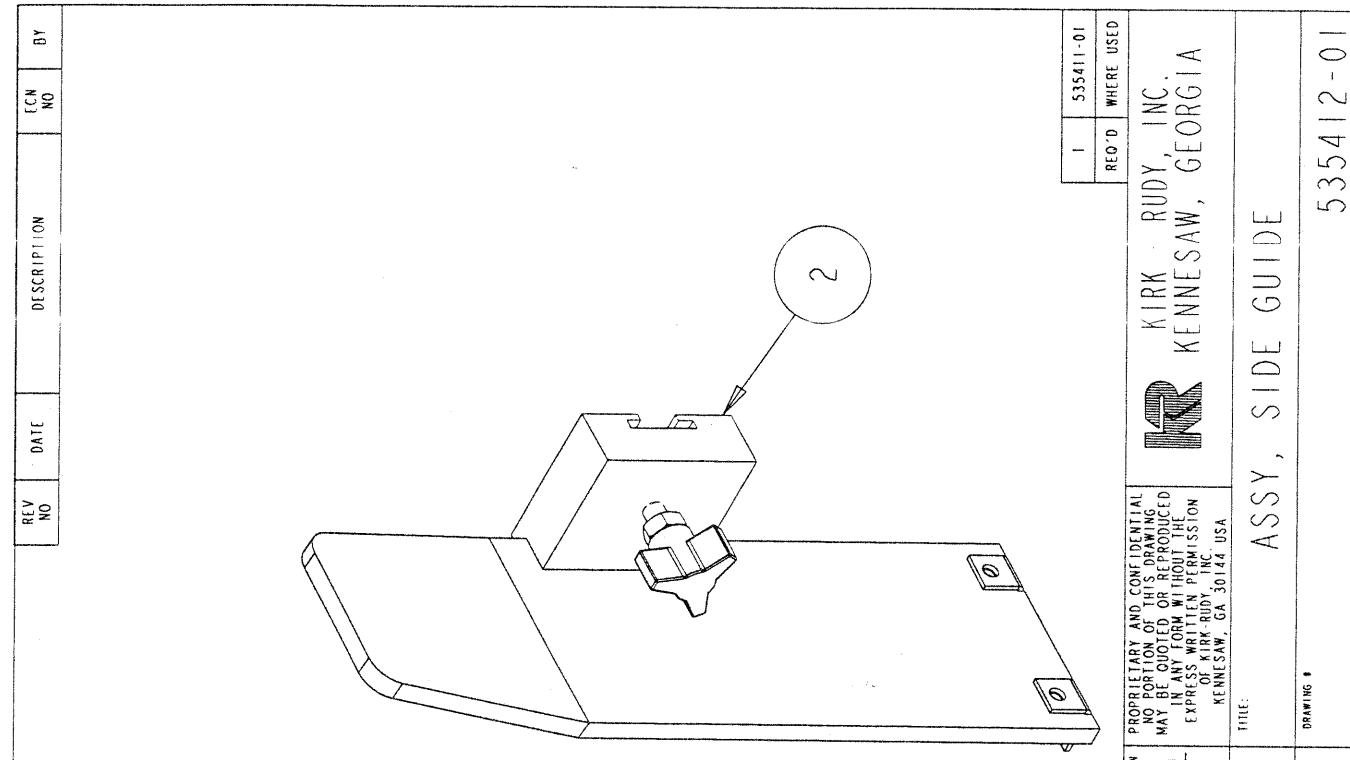
DRAWING
531582-01

 PROPRIETARY AND CONFIDENTIAL
 THIS DRAWING MAY NOT BE COPIED OR REPRODUCED
 EXCEPT AS AUTHORIZED IN THE
 CONTRACT DOCUMENT
 KIRK RUDY, INC.
 ELEMENT, GA 30044 USA
 EG BRIDGE DRIVE AND GATE ASY
 DRAWN, 531582-01

DRAWING
531582-01

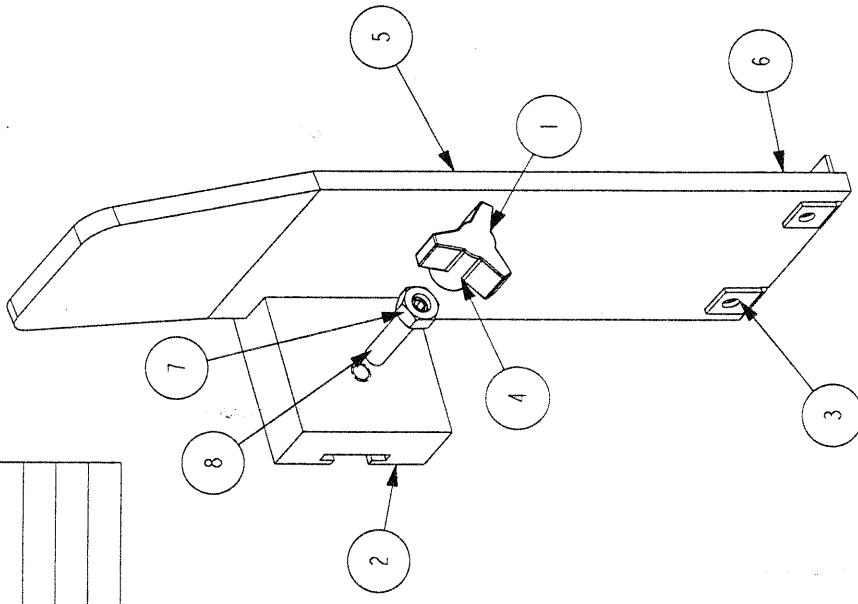
 PROPRIETARY AND CONFIDENTIAL
 THIS DRAWING MAY NOT BE COPIED OR REPRODUCED
 EXCEPT AS AUTHORIZED IN THE
 CONTRACT DOCUMENT
 KIRK RUDY, INC.
 ELEMENT, GA 30044 USA
 EG BRIDGE DRIVE AND GATE ASY
 DRAWN, 531582-01

ITEM QTY	PART #	DESCRIPTION
1	1	500755AL ASSY, SIDE GUIDE LH
2	1	500755AR ASSY, SIDE GUIDE RH



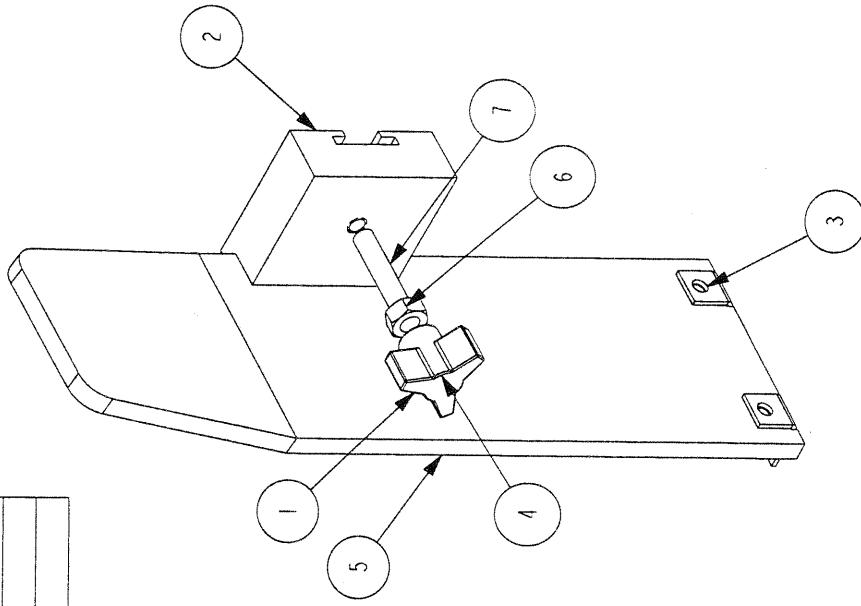
DRAWN BY:	TVK	SCALE	0 . 500	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED		
CHECKED BY:		DATE	02 Mar - 99	XX	XXX	ANG.
TRACED BY:				.01	.005	.5
HEAT TREAT:				N / A		
REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED				N / A		
ALL DIMENSIONS ARE FINISHED DIMENSIONS				N / A		
DO NOT SCALE - WORK TO DIMENSIONS ONLY				M		
				SHEET NO.:	10F1	DRAWING #:
						535412-01
				ASSY, SIDE GUIDE		
				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		
				TITLE:		
				215		

ITEM QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	FCN NO	BY
1	102119	KNOB					
2	500755	CLAMP - SIDE GUIDE					
3	2 500771	CLIP-SIDE GUIDE					
4	1 102119-A	ASSY, KNOB					
5	1 500788L	PLATE - RH SIDE GUIDE					
6	1 500788LA	ASSY-SIDE GUIDE PLATE					
7	1 RHN010	HEX NUT					
8	1 SYA601						



1	535412-01
REQ'D	WHERE USED
1	KIRK-RUDY, INC.
	KENNESAW, GEORGIA
THIRD ANGLE PROJECTION	PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE QUOTED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC. KENNESAW, GA 30144 USA
NOTE:	TIME:
SCALE	0.500
DRAWN BY:	MY
DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	N/A
xx	xxx
.01	.005
ANG.	.5
HEAT TREAT:	N/A
CHECKED BY:	12-Apr-99
DATE	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED
TRACED BY:	MASTER
FINISH:	ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY
SHEET NO:	10F1
DRAWING #	500755AL

ITEM QTY	PART #	DESCRIPTION
1	102119	KNOB
2	500755	CLAMP - SIDE GUIDE
3	2 500771	CLIP - SIDE GUIDE
4	1 102119-A	ASSY, KNOB
5	1 500788R	PLATE, SIDEGUIDE RH
6	1 RHN010	HEX NUT
7	1 SYA601	



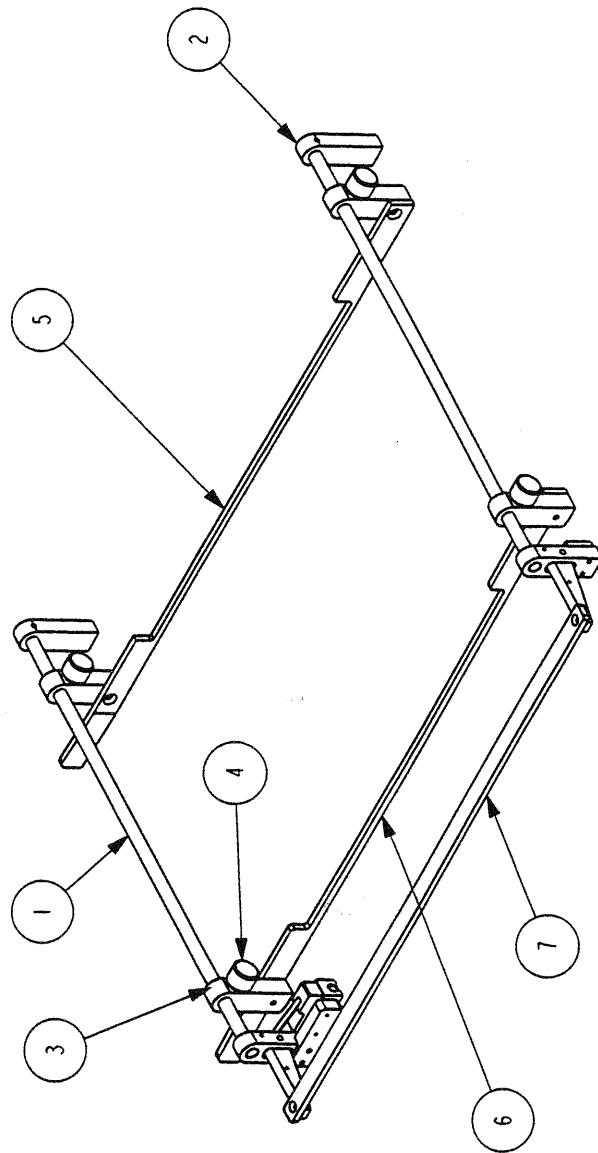
ITEM NO	REV NO	DATE	DESCRIP	ON	ECN NO	BY
1						

1	535412-01
REO'D	WHERE USED

DRAWN BY:	SCALE	0 . 500	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	MATERIAL:	N / A	THIRD ANGLE PROJECTION	PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE QUOTED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY INC. KENNESAW, GA 304 USA
CHECKED BY:	DATE	.xx	xxx	ANG.	.01	.005	.5
TRACED BY:	MASTER	12 - Apr - 99	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED	HEAT TREAT:	N / A	215	TITLE: ASSY, SIDE GUIDE
			ALL DIMENSIONS ARE FINISHED DIMENSIONS	FINISH:	N / A	SHEET NO. 10F	DRAWING # RH

500755AR

ITEM QTY	PART #	DESCRIPTION
1	2	500787 SHAFT - SIDE GUIDE ADJ.
2	2	500791 POST - SIDE SUPPORT
3	4	500792 POST, SIDE GUIDE
4	4	500793 LOCK, SIDE GUIDE CAM
5	1	500722-4L SIDE GUIDE, R/H
6	1	500722-4R RAIL, GUIDE RH
7	1	535275-01 ASSY, PANIC BAR



REV NO	DATE	DESCRIPTION	ETCH NO	B1
1	535804-01	KIRK - RUDY, INC. KENNESAW, GEORGIA	RECD WHERE USED	

DRAWN BY:	SCALE	MATERIAL:	THIRD ANGLE PROJECTION
A YB	0 . 156	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	N/A
		.01 .005 .005	ANG.
CHECKED BY:	DATE	HEAT TREAT:	
	29 - Apr - 99	N/A	
TRACED BY:	MASTER	FINISH:	
	M	N/A	
		REMOVE ALL RUGGS AND SHARP EDGES UNLESS OTHERWISE NOTED	
		ALL DIMENSIONS ARE FINISHED DIMENSIONS	
		DO NOT SCALE - WORK TO DIMENSIONS ONLY	
			1114F
			ASSY, SKID BAR & SIDE GUIDE
			535806-01

ITEM	QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	1	190101	MICROSWITCH, LEVER					
2	1	190203	COVER, MICROSWITCH					
3	2	504604	STOP BAR ARM					
4	1	504605	BRACKET, SWITCH					
5	1	504607	STOP BAR					
6	1	190101A	ASSY SWITC WITH COVER					
7	2	504602-1	POST - STOP BAR					
8	1	504606-1	BLOCK - ARM STOP					
9	1	533273-01	ASSY PANIC POST & SWITCH					
10	1	533274-01	ASSY PANIC BAR POST					
11	1	535275-01	ASSY, PANIC BAR					

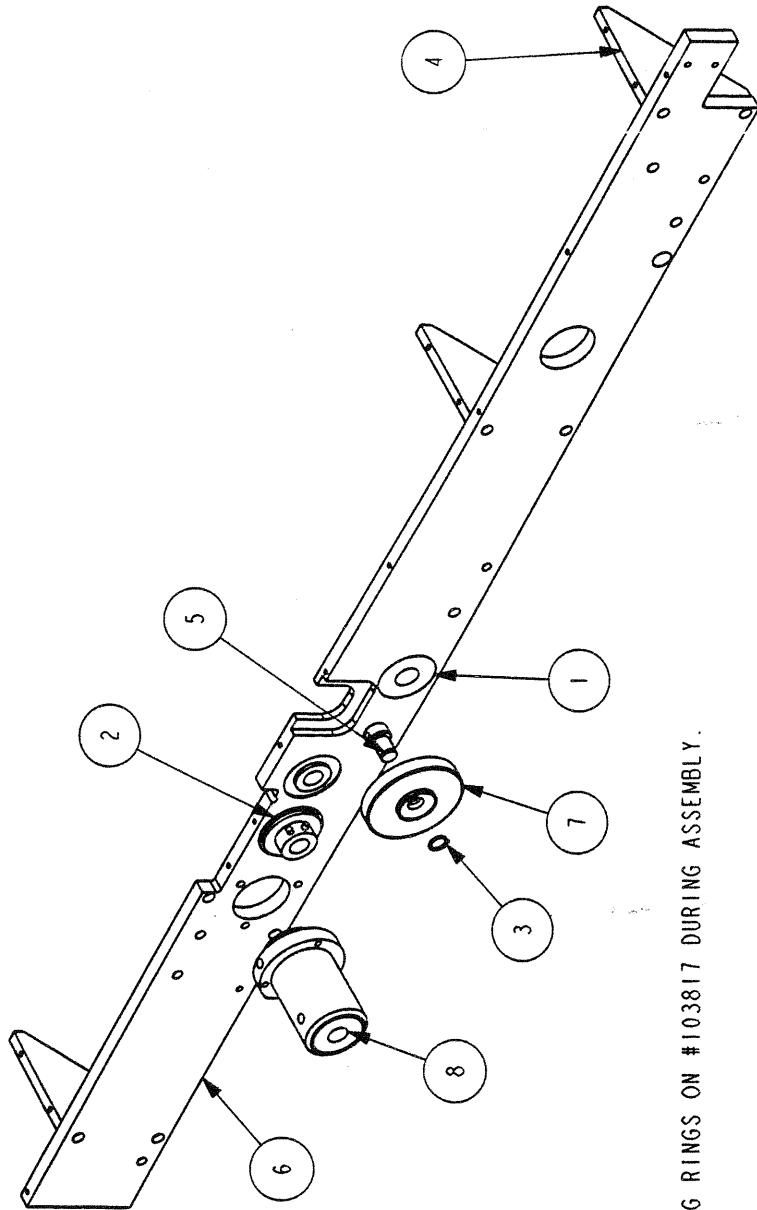
DRAWN BY: A KEY SCALE: 0 .375 DIMENSIONAL TOLERANCES MATERIAL: N/A
 UNLESS OTHERWISE NOTED .XX .XXX ANG. .01 .005 .5 HEAT TREAT:
 CHECKED BY: DATE 06 - NOV - 98 REMOVE ALL BURRS AND N/A
 OTHER EDGES UNLESS ANG.
 NOTED FINISH: N/A
 TRACED BY: MASTER M ALL DIMENSIONS ARE
 FINISHED DIMENSIONS
 DO NOT SCALE WORK
 TO DIMENSIONS ONLY

8	3	7	10	2	SP70500	REQ'D	WHERE USED
				2	535275-01		

KIRK - RUDY, INC.
 KENNEBUNK, GEORGIA
 KIRK-RUDY, INC.
 KENNEBUNK, GA 30144 USA

ASSY, PAN C BAR
 DRAWING # 535275-01

ITEM QTY	PART #	DESCRIPTION
1	103805	BEARING - HUB
2	103817	HUBBEARING 5/8 ID
3	104106	SNAPRING .500
4	3	GUSSET - TABLETOP SUPPORT
5	1	SHAFT - GEAR SPUR
6	1	500701-L frame plate
7	1	531105-01 ASSY. GEAR
8	1	531106-01 ASSY. HUB

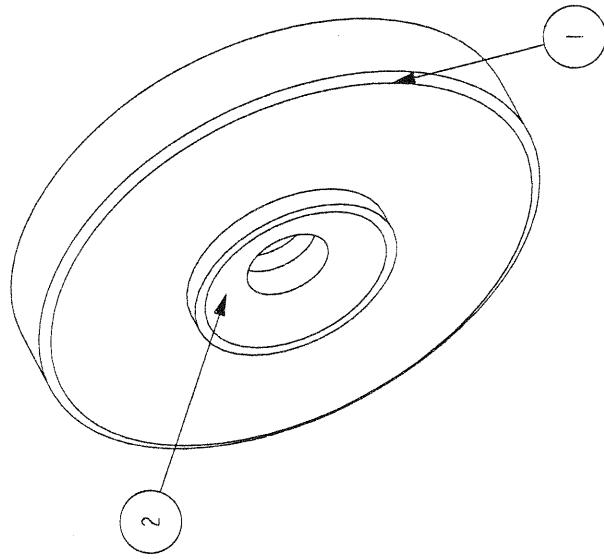


NOTES:
1. REMOVE RETAINING RINGS ON #103817 DURING ASSEMBLY.

DRAWN BY:	SCALE	DATE	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	MATERIAL:	HEAT TREAT:	FINISH:	NOTE:	THIRD ANGLE PROJECTION	RECD	WHERE USED
MY	0 . 188	.005	.005 .005	N/A	N/A	N/A	151J	-	536173-01	
CHECKED BY:	08 - Apr - 99									
TRACED BY:	MASTER									

KIRK - RUDY INC.
KENNESAW, GEORGIA
ASSY, LH FRAME
536176-01

ITEM	QTY	PART #	DESCRIPTION
1	1	101919	GEAR, 1648 1.124B NK
2	2	103108	BEARING, FLAT .500



REV NO	DATE	DESCRIPTION	ECN NO	BY

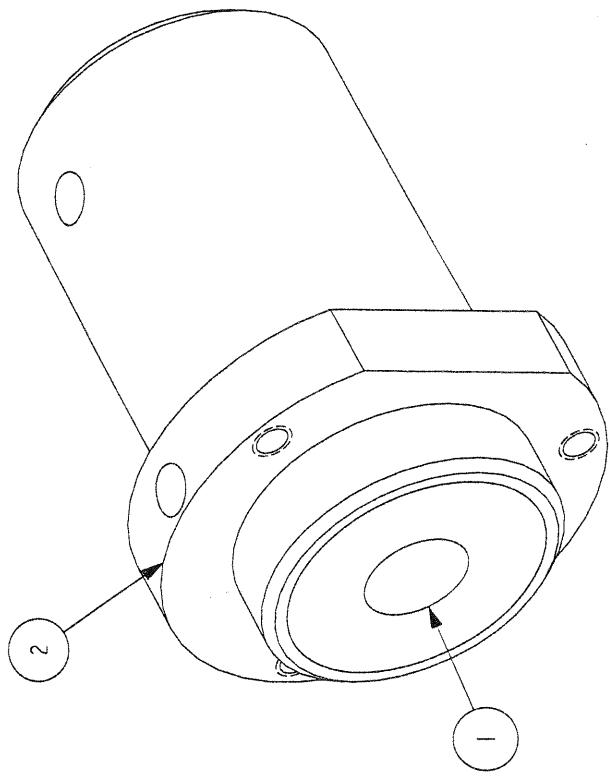
1	536176-01
REO'D	WHERE USED

KARK - RUDY, INC.
KENNEBUNK, GEORGIA

ASSY, GEAR
531105-01

DRAWN BY:	SCALE	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED		MATERIAL:	THIRD ANGLE PROJECTION	PROPRIETARY AND CONFIDENTIAL INFORMATION CONTAINED ON THIS DRAWING MAY BE QUOTED OR REPRODUCED IN ANY ORDER WITHOUT THE EXPRESS WRITTEN PERMISSION OF KARK-RUDY, INC., KENNEBUNK, ME 04044 USA
MY	.000	.xx	.xxx	N/A		
CHECKED BY:	DATE	.01	.005	HEAT TREAT:	MODEL: 215	TITLE:
	12-Apr-99	.5		N/A	SHEET NO. 10F1	DRAWING #
TRACED BY:	MASTER	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY		N/A		

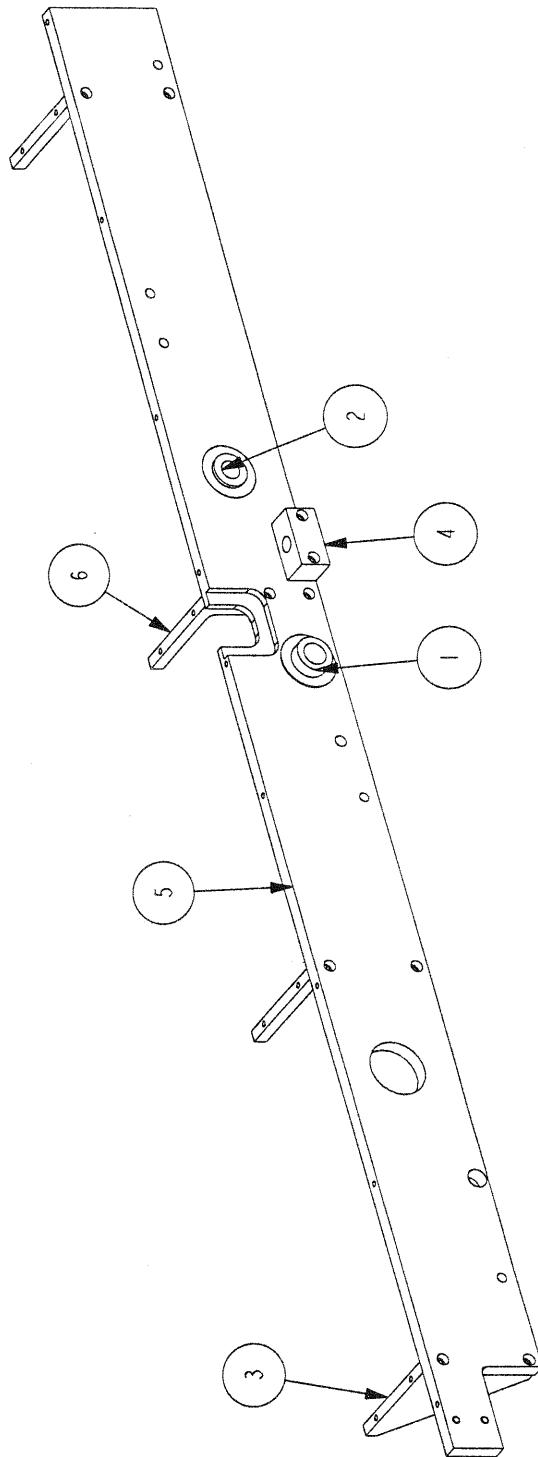
ITEM	QTY	PART #	DESCRIPTION
1	2	103804	BEARING, HUB .625
2	1	500718	HUB - SHAFT BEARING



ITEM	REV NO	DATE	DESCRIPTION	ECN NO	BY

1	536176-01
REQ'D	WHERE USED
KRK RUDY, INC.	KRKENNE SAW, GEORGIA
 KRK RUDY, INC. KRKENNE SAW, GEORGIA PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE COPIED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KRKRUDY INC. KRS 30144 USA	
THIRD ANGLE PROJECTION	
MATERIAL:	N/A
DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	
.XX .XXX .005 .5	HEAT TREAT:
DATE 12-Apr-99	MODEL: 215
CHECKED BY: M.Y	TIME:
TRACED BY: MASTER M	SHEET NO. 10F1
	DRAWING # 531106-01

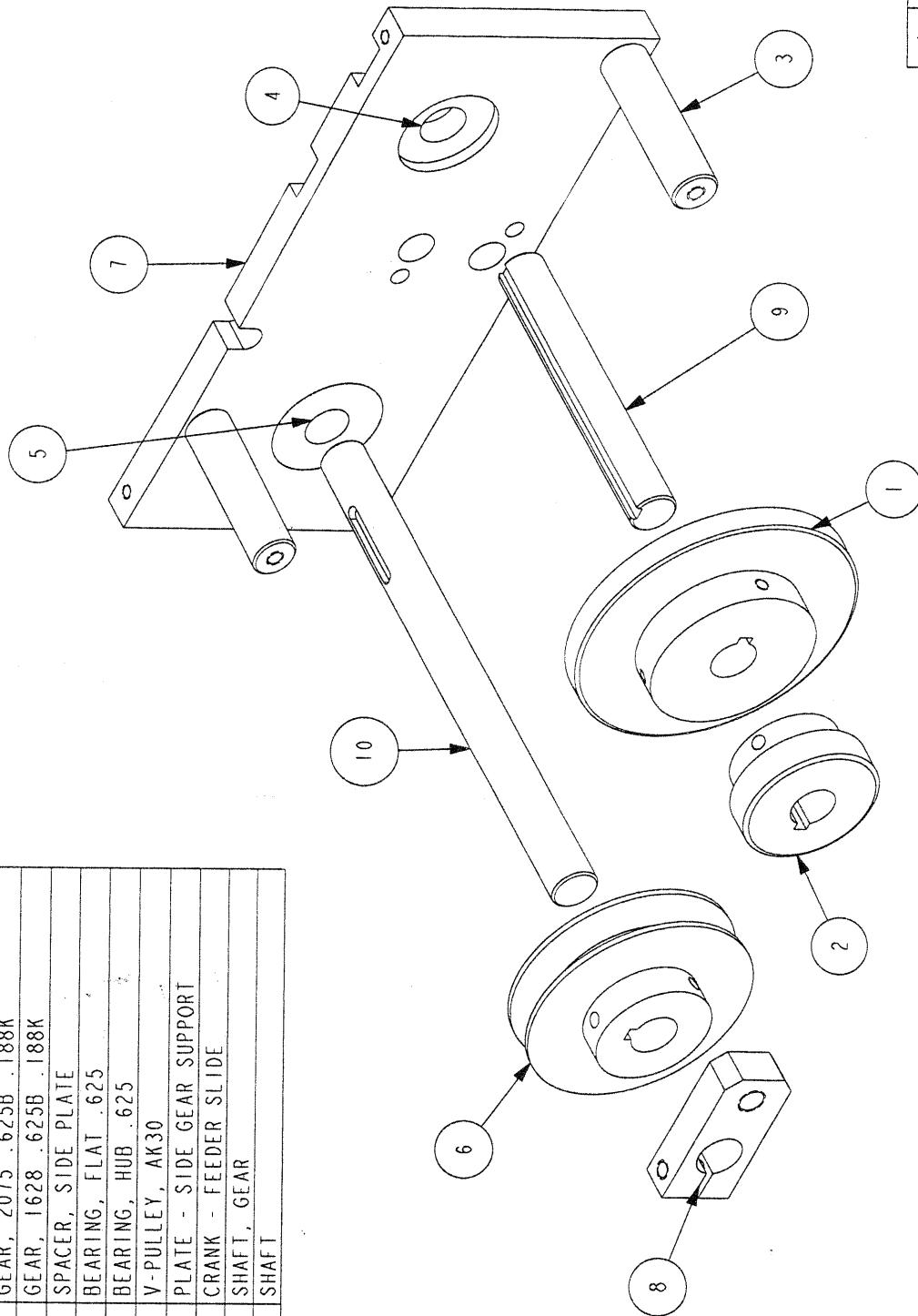
ITEM QTY	PART #	DESCRIPTION
1	103805	BEARING, HUB .750
2	103817	HUBBEARING 5/8 ID
3	500721	GUSSET - TABLETOP SUPPORT
4	500785	BLOCK - SPRING
5	500701-R	BAR FRAME PLATE
6	3 500721-1	GUSSET, CUTOUT



DRAWN BY:	MY	SCALE	0 . 188	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 WHOLE OR IN PART EXPRESS WRITTEN PERMISSION OF KIRK-KENNESAW, KIRK-KENNESAW, GA 30144 USA
CHECKED BY:		DATE	08-Apr-99	.XX .XXX ANG. .01 .005 .5	HEAT TREAT: N/A	MODEL: 2151J	TITLE: ASSY, RH FRAME
TRACED BY:	MASTER	MASTER	M	WNS:	N/A	SHEET NO.: 10F1	DRAWING #: 536177-01

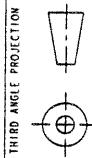
1	536173-01
RECD	WHERE USED

ITEM	QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	1	101760	GEAR, 2075 .625B .188K					
2	1	101916	GEAR, 1628 .625B .188K					
3	2	102672	SPACER, SIDE PLATE					
4	1	103110	BEARING, FLAT .625					
5	1	103804	BEARING, HUB .625					
6	1	105021	V PULLEY, AK30					
7	1	500720	PLATE - SIDE GEAR SUPPORT					
8	1	500750	CRANK - FEEDER SLIDE					
9	1	503630-1	SHAFT, GEAR					
10.	1	SP33419-3	SHAFT					



I	536173-01
REC'D	WHERE USED

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IN ANY FORM WITHOUT THE
EXPRESS WRITTEN PERMISSION
OF KIRK RUDY, INC.
KENNESAW, GA 30144 USA



TITLE:

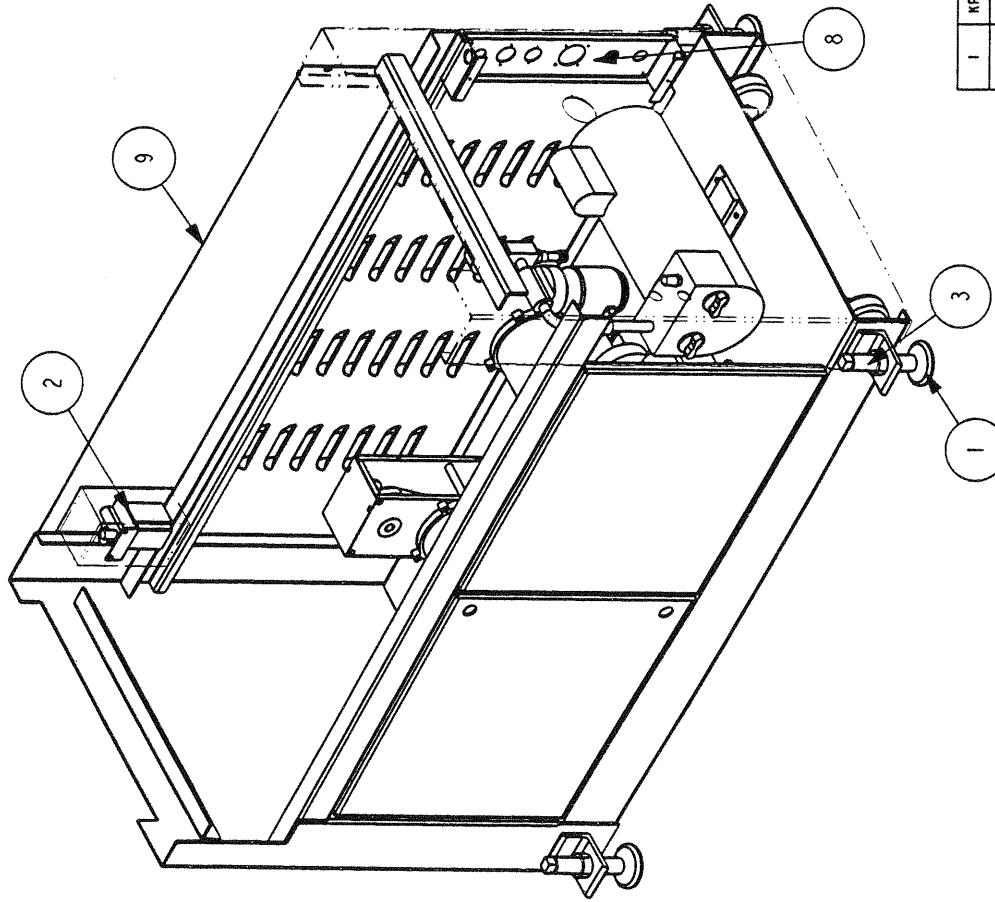
ASSY, CHANGE GEAR PLATE

DRAWING #

DRAWN BY:	SCALE	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	MATERIAL:	HEAT TREAT:	FINISH:	SHEET NO.	MASTER
MY	0 .500	.01 .005 .5	N / A	N / A		2151J	
CHECKED BY:	DATE						
TRACED BY:	MASTER	08-Apr-99	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY				M

536178-01

ITEM QTY	PART #	DESCRIPTION
1	4 190634	FOOT, MOUNTING
2	1 190637	OIL PUMP
3	4 191010	LEVELING BOLT, CABINET
4	1 200120	BLOWER, GAST
5	1 200152-2	MOTOR, LEESON DC 1/2HP
6	1 500890-3	WLDWN, 215 INKJET BASE CABINET
7	1 509000-8A	ASSY, MTR/REDUCER SR 1/2HP VERT
8	1 530441-01	BOX, ELECTRICAL INLET 20A
9	1 530697-01	PANEL, INKJET BASE BACK
10	1 531168-01	ASSY, 1/2 HP VACUUM PUMP



I KIRK-RUDY, INC.
REO'D WHERE USED



KENNESAW, GEORGIA

30144 USA

TIME:

10:00 AM

DATE:

06/23/01

MODEL:

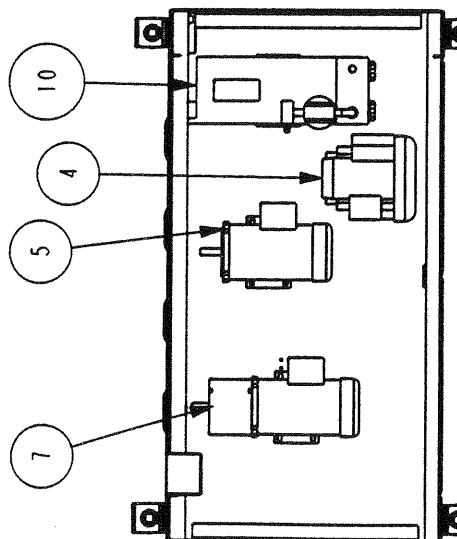
2151J

ASSY, 2151J DUAL MOTOR CABINET

DRAWING #:

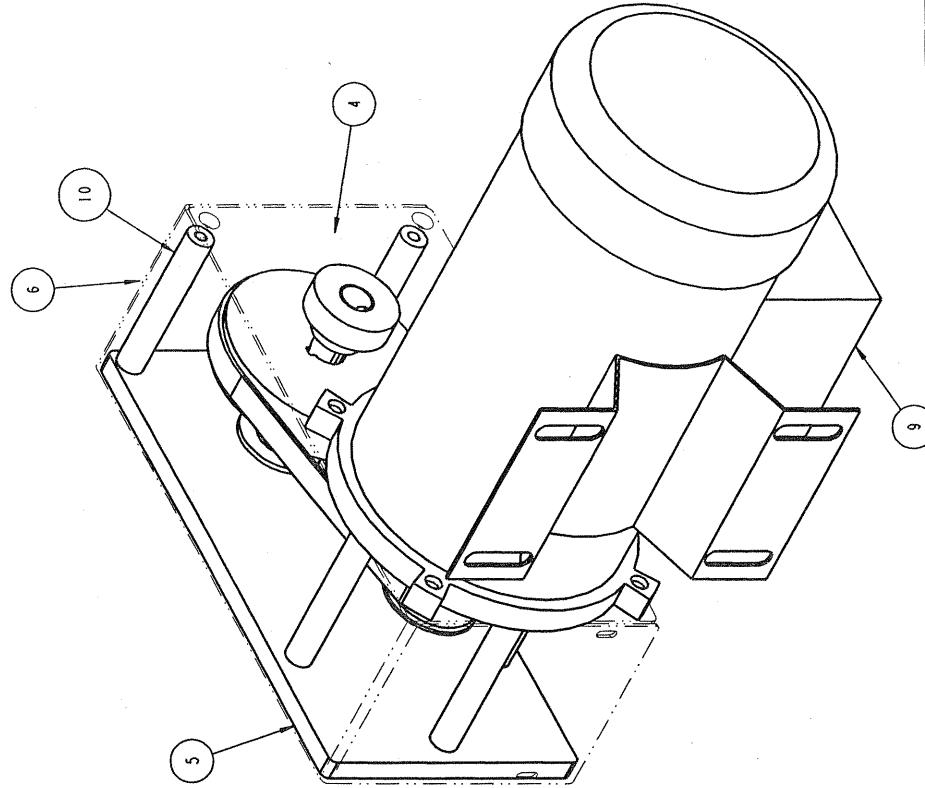
536434-01

SCALE 0.063

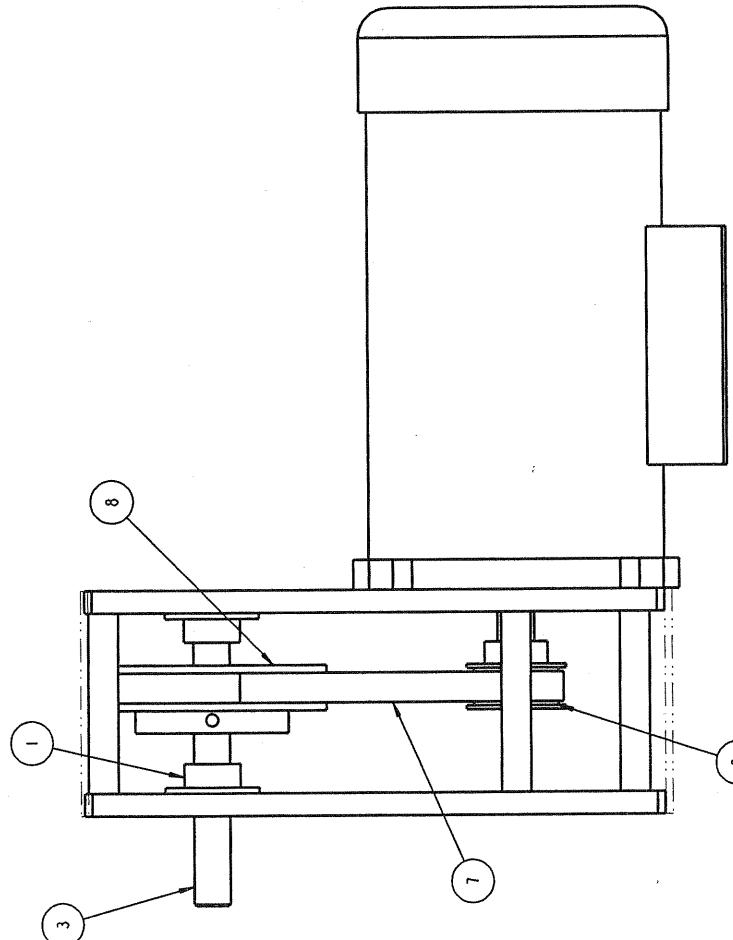


DRAWN BY:	MY	SCALE	0 . 094	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	MATERIAL:	N / A	THIRD ANGLE PROJECTION	PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE QUOTED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC. KENNESAW, GA 30144 USA
CHECKED BY:		DATE	3 - JUN - 99	.01 .005 .005	HEAT TREAT:	N / A		
TRACED BY:		MASTER	M	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

ITEM	QTY	PART #	DESCRIPTION	REV NO	DATE	CC# NO	BY
1	2	103804	BEARING, HUB .625				
2	1	108888	PULLEY, TIMING 12L050 .625B .188K				
3	1	503619	SHAFT				
4	1	509006	PLATE, REAR SIDE				
5	1	509007	PLATE, GEARBOX 1/2 HP SINGLE RED				
6	1	509037	COVER, REDUCER				
7	1	108917-1	BELT, TIMING 1817.050				
8	1	109319-1	PULLEY, TIMING 32L050 .625B .188K				
9	1	200152-2	MOTOR, LEESON DC 1/2HP				
10	5	SP 6208	SPACER, REDUCER				



ITEM	QTY	PART #	DESCRIPTION
1	2	103804	BEARING, HUB .625
2	1	108888	PULLEY, TIMING 12L050 .625B .188K
3	1	503619	SHAFT
4	1	509006	PLATE, REAR SIDE
5	1	509007	PLATE, GEARBOX 1/2 HP SINGLE RED
6	1	509037	COVER, REDUCER
7	1	108917-1	BELT, TIMING 1817.050
8	1	109319-1	PULLEY, TIMING 32L050 .625B .188K
9	1	200152-2	MOTOR, LEESON DC 1/2HP
10	5	SP 6208	SPACER, REDUCER



1	III	REF ID: MTRREDUCERSR1/2HPVERT
2	III	REF ID: MTRREDUCERSR1/2HPVERT
3	III	REF ID: MTRREDUCERSR1/2HPVERT
4	III	REF ID: MTRREDUCERSR1/2HPVERT
5	III	REF ID: MTRREDUCERSR1/2HPVERT

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WRITTEN PERMISSION
OF KIRK-RUDY, INC.
WOODSTOCK, GEORGIA
WOODSTOCK, GA 30188 USA

ITEM AND PRODUCTION NUMBER OR OTHER IDENTIFICATION:	MADE:	TECHNICAL DRAWING
SCALE:	N/A	NOTES:
T.J.G	0 .500	ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
CHECKED BY:	3 - Nov - 98	SHARP EDGES AND TRUNNIONS ARE SHARP UNLESS OTHERWISE NOTED
MAILED BY:	M	ALL DIMENSIONS ARE IN INCHES UNLESS NOTED TO POOL SCALE, WORK TO DIMENSIONS ONLY
TRACED BY:		PRINTED BY:

ITEM QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	FCN NO	BY
1	1	190660 NIPPLE, 1/2 IN TUBING					
2	1	200102 VALVE, RELIEF GAST 822/823					
3	1	200108 STEM GAST 822/823					
4	1	200109 PLATE GAST 822/823					
5	1	200124 PUMP, VACUUM GAST					
6	1	501645 BLOCK, CONNECTOR (VACUUM PUMP)					
7	1	200100-1 GAUGE, VACUUM GAST 822/823					
8	1	200100-2 FILTER, VACUUM GAST 822/823					
9	1	200100-3 JAR, GLASS GAST 822/823					
10	1	200100-13 NIPPLE, STEEL					
11	1	200100-14 ELBOW, PIPE GAST 822/823					
12	1	200100-16 COUPLING GAST 822/823					
13	1	200100-21 NIPPLE, STEEL					
14	1	200100-22 COUPLING, STEEL					
15	1	200100-23 PLUG, SQUARE HEAD GAST 822/823					
16	1	200100-26 COVER FOR AB992 GAST 822/823					
17	2	200124-2 FILTER, FELT GAST 823					
18	2	200124-4 END CAP, AK510 GAST 823					
19	1	200124-5 MUFFLER, SINTERED GAST 823					
20	2	200124-6 O-RING, GASKE T GAST 823					

RECD	WHERE USED				
1	215				
<table border="1"> <tr> <td>1</td> <td>ASSY, 1/2 HP VACUUM PUMP</td> </tr> <tr> <td>531168-01</td> <td></td> </tr> </table>		1	ASSY, 1/2 HP VACUUM PUMP	531168-01	
1	ASSY, 1/2 HP VACUUM PUMP				
531168-01					
<p>PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE QUOTED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC. KENNESAW, GA 3044 USA</p>					
<p>THIRD ANGLE PROJECTION</p>					
<p>MODEL: X</p>					
<p>SHEET NO. 10F1</p>					
<p>DRAWING #</p>					

DRAWN BY:	SCALE	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	MATERIAL:	NOTED	HEAT TREAT:
MY	0 . 156	.01 .005 .5	NONE		
CHECKED BY:	DATE				
TRACED BY:	MASTER				

REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED
ALL DIMENSIONS ARE FINISHED DIMENSIONS
DO NOT SCALE - WORK TO DIMENSIONS ONLY

7 ELECTRICAL SCHEMATICS AND PARTS

7.1 SCHEMATIC LIST

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

109-500-20-11K 215 Dual Motor Inkjet

7.2 PARTS LIST

KR Part #	Qty	Manufacturer	Description
202277	11	IDec	Socket, Relay 700HN116/SH2B-05
202291	11	IDec	Relay, 24VAC 700-HF32A24-4RH28-ULC
202426-2	3	KB	Board, 90VDC Motor KBMM 225D 240VAC
202427-1	1	KB	Resistor, 0.05 Ohm 9839 1/4hp 90VDC Motor
202427-2	2	KB	Resistor, 0.025 Ohm 9841 1/2hp 90V, 1hp 180V
203022-2	1	Micron	Transformer, B050-0021-GA 240VAC
205700	1	Dale	Resistor, RH-50 50W 20Ohm
208021	2	Buss	Fuse, 8 MDL
208022	2	Buss	Fuse, 8A AGC/GGC
208023	6	Buss	Fuse, 12A AGC/GGC
208029	2	Buss	Fuse, 3 2/10 MDL
208030	2	Buss	Fuse, 1 6/10A MDL/GDL
208043	2	Buss	Fuse, 10A MDA/GDL
208044	1	Buss	Fuse, 4A AGC/GGC
208047	1	Buss	Fuse, 4A MDL/GDL
209163	3.188	Phoenix	Din Rail, NS35/7.5 Per Foot
209234	11	Phoenix	Block, Terminal UK16
209236	54	Phoenix	Block, Terminal UK3MVSTB-5.08
209237	3	Phoenix	Terminal, Ground USLKG16
209238	3	Phoenix	End, Block E-UK
209241	9	Phoenix	Cover, End DUK3-MVSTB
209245	1	Phoenix	Holder, Fuse 24V UK6.3-HEILED24
209247	8	Phoenix	Holder, Fuse 250V UK10-Drehsila

8 APPENDIX

8.1 POSSIBLE OPTIONS

The KR215IJ base can be modified to handle a variety of applications, contact your Kirk-Rudy dealer or call Kirk-Rudy direct to discuss you specific application.

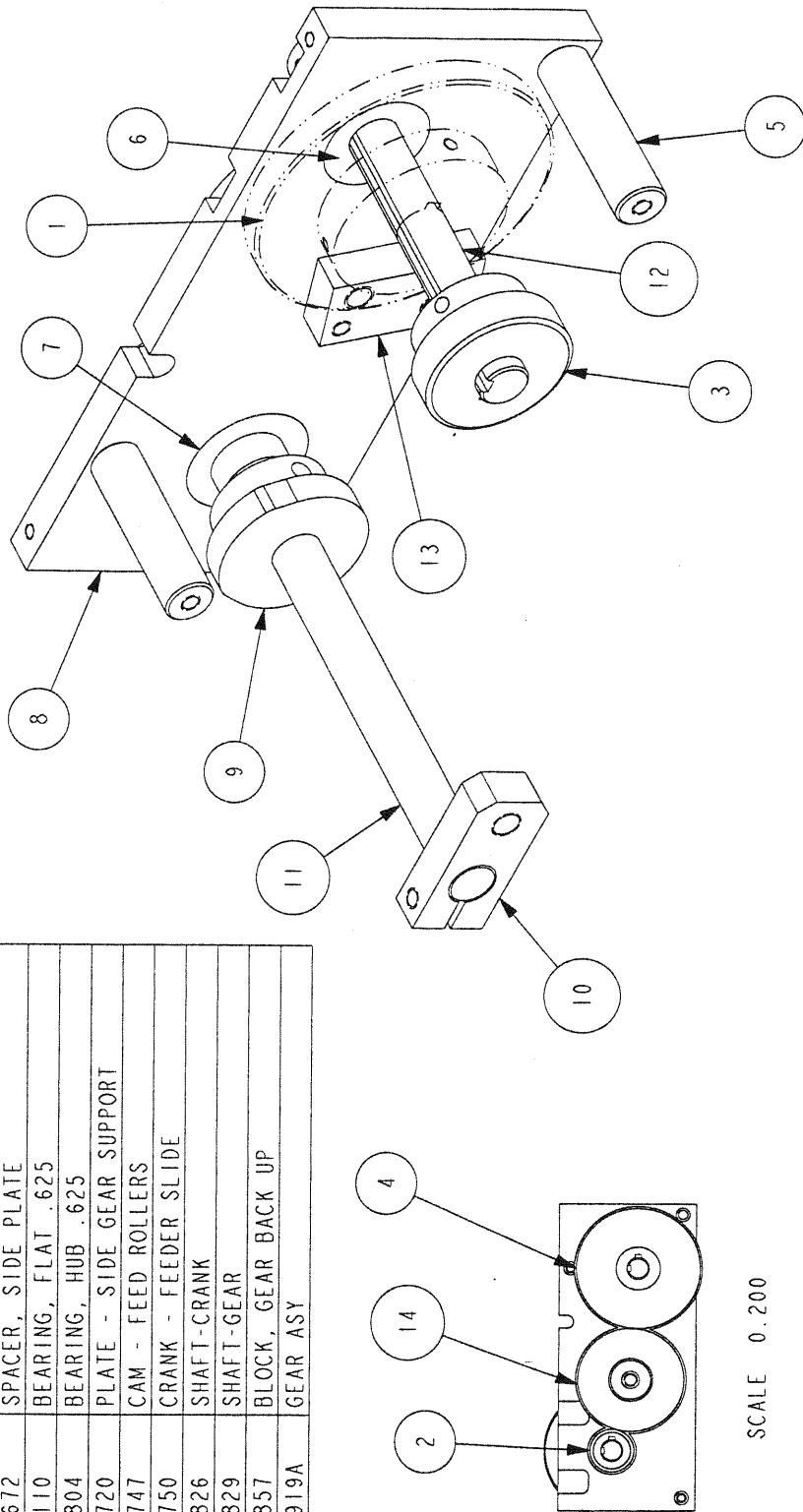
Here is a list of some of the options offered for the KR215IJ base:

- Rubber Tip Feeder Gate
- Inline Label Base for second application head
- Modifications to increase thickness limits
- Auto Load Conveyor. Designed for ease of loading of thick product, automatically maintains pre-determined level in feeder.
- Shuttle “Low Product” Detector (stops machine).

8.2 22 IN. SPACING OPTION

For 22 in. spacing between product, Change Gear Plate 22 in Assembly (535810-01) is used in place of Change Gear Plate 11 in Assembly (535812-01). See following page for 535810-01.

ITEM QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	FCN NO	BY
1	101760	GEAR, 2075 .625B .188K					
2	101913	GEAR, 1620 .625B .188K					
3	101916	GEAR, 1628 .625B .188K					
4	101920	GEAR, 1656 .625B .188K					
5	2 102672	SPACER, SIDE PLATE					
6	1 103110	BEARING, FLAT .625					
7	1 103804	BEARING, HUB .625					
8	1 500720	PLATE - SIDE GEAR SUPPORT					
9	1 500747	CAM - FEED ROLLERS					
10	1 500750	CRANK - FEEDER SLIDE					
11	1 500826	SHAFT - CRANK					
12	1 500829	SHAFT - GEAR					
13	1 500857	BLOCK, GEAR BACK UP					
14	1 101919A	GEAR ASSY					



SCALE 0.200

NOTES:
1. FOR 22 IN SPACING.

DRAWN BY: AYB	SCALE 0 .500	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED			MATERIAL: N/A	THIRD ANGLE PROJECTION NO. 151J	PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE QUOTED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC. KENNESAW, GA 30144, USA
CHECKED BY:	DATE 29-Apr-99	.01	.005	.5	HEAT TREAT: N/A		TIME: 10:11
TRACED BY:	MASTER m	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY			FINISH: N/A	SHEET NO. 10F1	DRAWING # 535810-01

9 NOTES

10 WARRANTY AND SERVICE

WARRANTY

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

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

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

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

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

USE ONLY GENUINE KIRK-RUDY REPLACEMENT PARTS

Kirk-Rudy, Inc.
2700 Kennesaw Due West Drive
Kennesaw, GA 30144
PH 770-427-4203
FX 770-427-4036