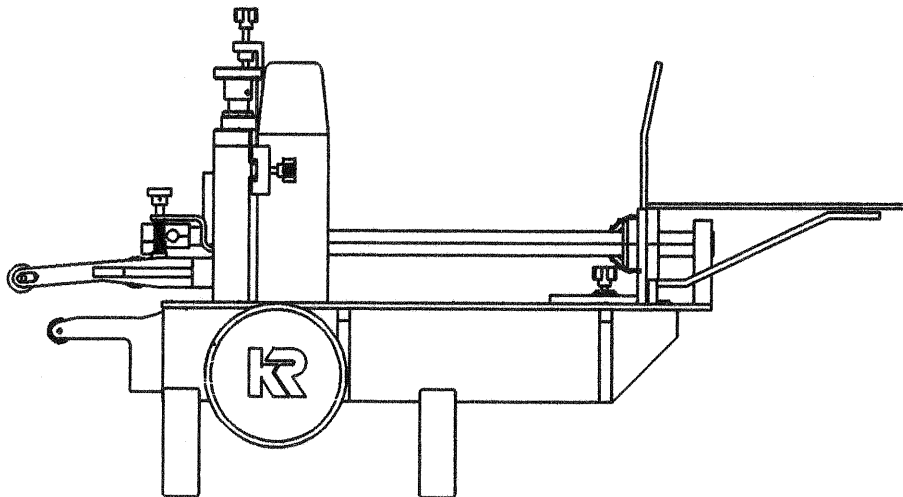


KIRK - RUDY, INCORPORATED

***MODEL # 324-1
SHUTTLE FEEDER
PARTS MANUAL
ISSUE #1***



**KIRK-RUDY, INC.
2700 DUE WEST DRIVE
KENNESAW, GEORGIA USA 30144-3588**

**PHONE: 770-427-4203
PARTS ORDER FAX: 770-427-4036**



Kirk - Rudy, Inc.

DESIGNING ENGINEERS AND MANUFACTURERS

2700 DUE WEST DRIVE • KENNESAW, GEORGIA 30144 • FACSIMILE (404) 427-4036

SPECIALISTS IN

PAPER HANDLING EQUIPMENT

PHONE (404) 427-4203

ACCIDENT PREVENTION GUIDE

1. Never operate the machine without all guards in place.
2. Never start the machine without first checking all personnel are clear of moving parts.
3. Keep fingers clear of all moving parts.
4. Never remove the product from the machine while the machine is running.
5. 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.
6. It is not recommended for loose clothing, jewelry, and long hair be worn while operating this machinery.
7. Always use an experienced electrician when trouble-shooting electrical problems.

11/05/92

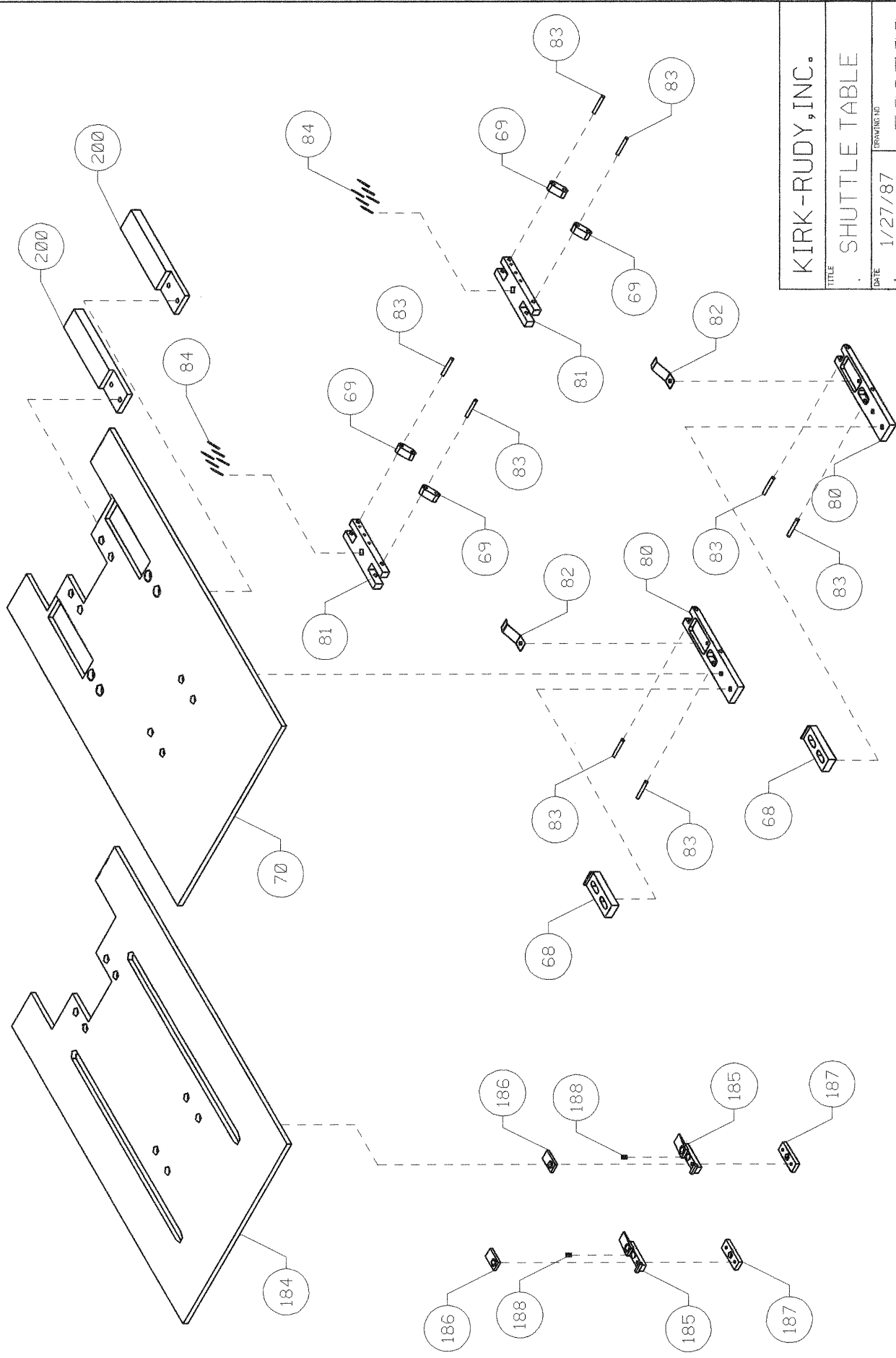
ITEM	QTY	PART ID NUMBER	DESCRIPTION
1	00001	508700	PLATE-RH FEEDER
2	00001	508604	PLATE-LH FEEDER
3	00001	508766	BAR-CROSS
4	00003	500721	BRACKET-SUPPORT
5	00002	500714	BRIDGE-REAR GUIDE
6	00001	500824	SHAFT-BELT GUIDE
7	00001	500785	BLOCK-SPRING
8	00001	500786	LEVER-SPRING
9	00001	500710-1	BRACKET-FEEDER SUP.
10	00001	500735	ROD-PUSH
11	00001	500769	SHAFT-REAR GUIDE
12	00001	500770	HUB-REAR GUIDE SHFT
13	00001	500750	CRANK-FEEDER
14	00002	500768	BRACKET-REAR GUIDE
15	00002	500737	WASHER-BUMPER
16	00002	500771	CLIP-REAR GUIDE
17	00001	500751	YOKE-FEEDER CRANK
18	00002	500755	CLAMP-SIDEGUIDE
19	00002	500746	ROLLER-BOTTOM FEED
20	00001	500734	LEVER-CAM
21	00001	500749	ROD-FEEDER SLIDE
22	00001	500718	HUB-SHAFT BEARING
23	00001	500729	CRADLE-FEEDER
24	00001	500797	SHAFT-P.C. HOLDER
25	00001	102200	COLLAR
26	00001	500744-2	SHAFT-TOP ROLLER
27	00001	500744-3	SHAFT-TOP ROLLER
28	00001	500744-4	SHAFT-TOP ROLLER
29	00002	105204	ROLL PIN
30	00001	500796	BRACKET-PHOTO CELL
31	00001	500715	PLATE-REAR GUIDE
32	00001	500810	SHAFT-SCREW ADJ.
33	00001	500806	PLATE-GATE END
34	00002	500807	NUT-LOCK
35	00024	103106	FLAT BRG-R6
36	00001	500808-1	PLATE-TOP BRIDGE
37	00001	500795-1	PLATE-BRIDGE
38	00002	500788	PLATE-SIDEGUIDE
39	00001	500733	HUB-ROLLER DRIVE
40	00001	500728	BRACKET-FEEDER
41	00001	500747	CAM-FEED ROLLER
42	00002	500847	BRACE-FORM REST

ITEM	QTY	PART ID NUMBER	DESCRIPTION
43	00001	500860	LEG-JOGGER TABLE
44	00001	500827	SHAFT-SPRING LEVER
45	00002	500814	RAIL-SIDEGUIDE
46	00002	500812	KNOB-ROLLER
47	00001	500845	TABLE-JOGGER
48	00001	100109	BUSHING-P102-12
49	00008	100145	BUSHING-P 63-8
50	00001	105601	SHAFT-THREADED
51	00002	105600	SHAFT-THREADED
52	00004	102119	KNOB
53	00001	102112	KNOB
54	00005	103804	ASS 202-010N
55	00003	103817	ER-10
56	00009	102657	SPACER
57	00002	102320	SPACER
58	00001	102671	SPACER
59	00003	102225	SPACER
60	00001	500880	BRACKET-JOG TBL SUP
61	00001	500878	SUPPORT-JOGGER TABLE
62	00001	508865	SHAFT-FEED ROLLER
63	00005	103110	FLAT BRG-A10
64	00001	508645	PAWL
65	00004	508937	BLOCK-BEARING
66	00002	508751	PLATE-SWING
67	00002	508752	GUIDE-BELT
68	00002	508839	SPACER-NEEDLE BLOCK
69	00004	508854	ARM-NEEDLE BLOCK
70	00001	508703	PLATE-FEEDER
71	00004	508741	LEG-FEEDER
72	00002	508759	SCREW
73	00002	508750	BAR-SPRING
74	00004	508761-2	ROLLER-TAKE UP
75	00001	508763	ROLLER-IDLER
76	00002	508753	ROLLER-BELT
77	00001	508721	PLATE-BEARING
78	00001	508721-1	PLATE-BEARING
79	00001	508614	PLATE-SIDE
80	00002	508728	BLOCK-NEEDLE SUPPORT
81	00002	508628	BLOCK-NEEDLE
82	00002	102601	SPRING
83	00008	105419	PIN-DOWEL
84	00012	190656	NEEDLE

ITEM	QTY	PART ID NUMBER	DESCRIPTION
85	00001	500708	BODY-VACUUM VALVE
86	00001	100131	BUSHING-P26 10
87	00001	500740	PLATE-VACUUM
88	00001	500738	SPRING-VALVE
89	00001	500739	BLOCK-PUSHER
90	00001	500709	PLATE-VACUUM
91	00001	103500	BEARING-ROD END
92	00001	508719	PLATE-SOLENOID
93	00002	100310	BUSHING-FL26-3
94	00001	508718	YOKE-THROW OUT
95	00001	SP12199	PIN-YOKE PIVOT
96	00002	104107	RING-EXT. RETAINING
97	00001	508704 LH	TOP-FEEDER TABLE
98	00001	508704 RH	TOP-FEEDER TABLE
99	00001	102672	SPACER
100	00003	102670	SPACER
101	00002	103408	FOLLOWER-CAM
102	00001	103405	CAM FOLLOWER
103	00001	501638	SHAFT-FEEDER ROLL
104	00001	508637	SHAFT-CRANK
105	00001	508648	SHAFT-HANDWHEEL
106	00001	102108	HANDWHEEL
107	00002	501040	WASHER
108	00001	500955	LINK-THROW OUT
109	00001	202200	SOLENOID-813 103
110	00001	508720	CLUTCH-SHUTTLE DRIVE
111	00002	104104	RING-EXT. RETAINING
112	00001	508624	HUB-CLUTCH
113	00001	100146	BUSHING-P66 8
114	00002	101918	GEAR-1648
115	00001	101988	GEAR-1654
116	00001	101946	GEAR-1626
117	00002	101916	GEAR-1628
118	00001	102401	GEAR-1616
119	00001	101962	GEAR-1620
120	00001	508747	GEAR-1633
121	00001	508755	BLOCK-BEARING
122	00006	103108	FLAT BRG-R8
123	00001	105608	SHAFT-THREADED
124	00002	508746	ROLLER-UPPER FEED
125	00002	500741	SHAFT-FEEDER
126	00002	500809	SLEEVE-TOP ROLLER

ITEM	QTY	PART ID NUMBER	DESCRIPTION
127	00001	508682	STUD-IDLER
128	00005	104106	RING-EXT. RETAINING
129	00001	101708	GEAR-2072
130	00001	101707	GEAR-2048
131	00003	102701	SPRING
132	00002	102723	SPRING
133	00001	102722	SPRING
134	00001	500704	BRIDGE-FEEDER
135	00001	190600	SPIDER-DRIVE
136	00005	190612	CLIP-WIRE
137	00001	100409	WASHER
138	00001	100401	WASHER
139	00002	500805	PLATE-HOLD DOWN
140	00001	500730	PLATE-GATE FEEDER
141	00002	508989	BRACKET-ARM
142	00001	508875	HOLDER-LIGHT
143	00002	508748	MOUNT-ROLLER
144	00002	101100	BEARING-ONE WAY
145	00002	SP6307-1	PLATE-INSIDE SWING
146	00002	508754	GUSSET
147	00002	500811-2	FORK-TOP ROLLER
148	00002	508722	PLATE-INSIDE SWING
149	00002	508723	PLATE-BELT SUPPORT
150	00001	508763-2	ROLLER-IDLER
151	00001	508765	SHAFT-ROLLER
152	00001	512303	SHAFT-ROLLER
153	00001	500799	CLAMP-PHOTO CELL
154	00001	500798	HOLDER-PHOTO CELL
155	00001	190229	CELL-PHOTO EYE
156	00001	190246	LENS
157	00001	500830	SHAFT-DRIVE
158	00006	104100	RING-EXTERNAL
159	00002	100800-1	JOINT-UNIVERSAL
160	00001	500803-1	SHAFT-UNIVERSAL
161	00001	500803	SHAFT-UNIVERSAL
162	00001	500744-1	SHAFT-TOP ROLLER
163	00001	102494	GEAR-1656
164	00001	508756-1	SHAFT-BELT DRIVE
165	00001	508756-2	SHAFT-LOWER BELT
166	00001	500748-1	SHAFT-FEED ROLLER
167	00004	508762	STUD-TAKE UP
168	00001	508637-1	SHAFT-FEEDER

ITEM	QTY	PART ID NUMBER	DESCRIPTION
169	00002	508760	SHAFT-SPRING
170	00002	508757	HOLDER-SPRING SHAFT
171	00002	100135	BUSHING-P50 4
172	00002	100162	BUSHING-P50 5
173	00002	102204	COLLAR
174	00002	SP6306-1	PLATE-BELT SUPPORT
175	00002	105913	BELT-FBG20
176	00002	105974	BELT-FBG20
177	00002	105954	BELT-FBG20
178	00002	105914	BELT-FBG20
179	00005	102308	SPACER
180	00005	102345	SPACER
181	00004	101302	SPACER
182	00008	101301	SPACER
183	00002	100601	WASHER-FLAT
184	00001	508703-1	PLATE-FEEDER
185	00002	500760	LIFTER-FEEDER PUSHER
186	00002	500775	PLATE-FEEDER PUSHER
187	00002	500762	PLATE-FEEDER PUSHER
188	00002	102700	SPRING-COIL
189	00001	500799-2	BLOCK-CONNECTOR
190	00001	500799-5	BLOCK-CLAMP SUPPORT
191	00001	500799-3	PLATE-CLAMPING
192	00001	190685	QUICK RELEASE
193	00001	508861	PLATE-SPACER
194	00001	508637-1	SHAFT-SHUTTLE FEEDER
195	00002	500799-6	STUD
196	00002	500799-7	STUD
197	00001	508925-1	COVER-GEAR (WIDE)
	00001	508925-2	COVER-GEAR (NARROW)
198	00002	500766	SCREW-MACH REAR GUIDE
199	00002	500764	LIFTER-REAR BRIDGE
200	00002	SP12182	BLOCK-PLUG REPL NDL BCK



KIRK-RUDY, INC.

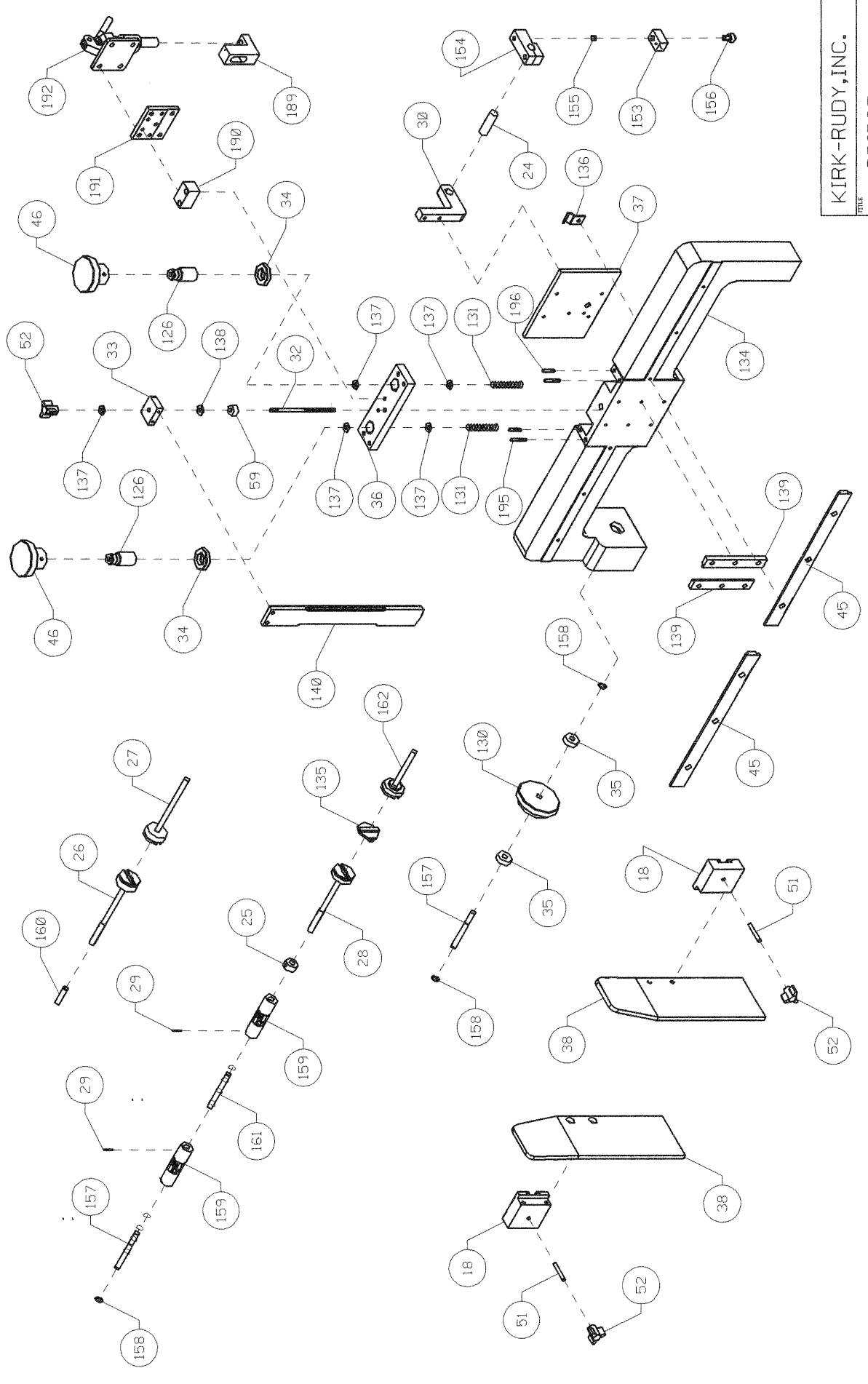
TITLE SHUTTLE TABLE

DATE 1/27/87

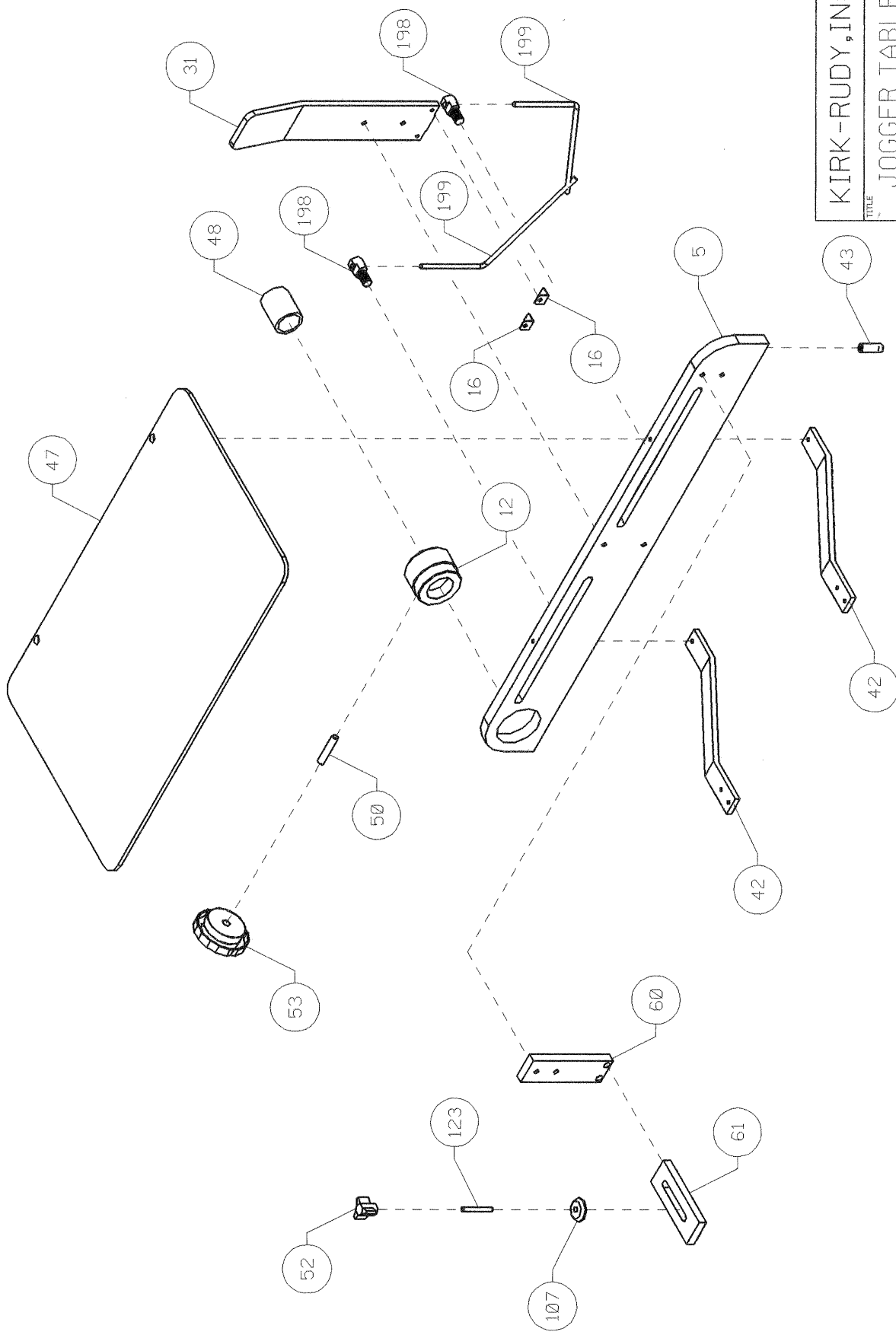
ISSUE 1

508700

5087-p07.eal



KIRK-RUDY, INC.			
TITLE BRIDGE			
DATE	1/27/87	FIGURING NO.	
DESIGNED BY	MM	REVISION	
DRAWN BY	MM	REVISION	
CHECKED BY		REVISION	
APPROVED BY		REVISION	
5087			508700
5087 pos. ex1			

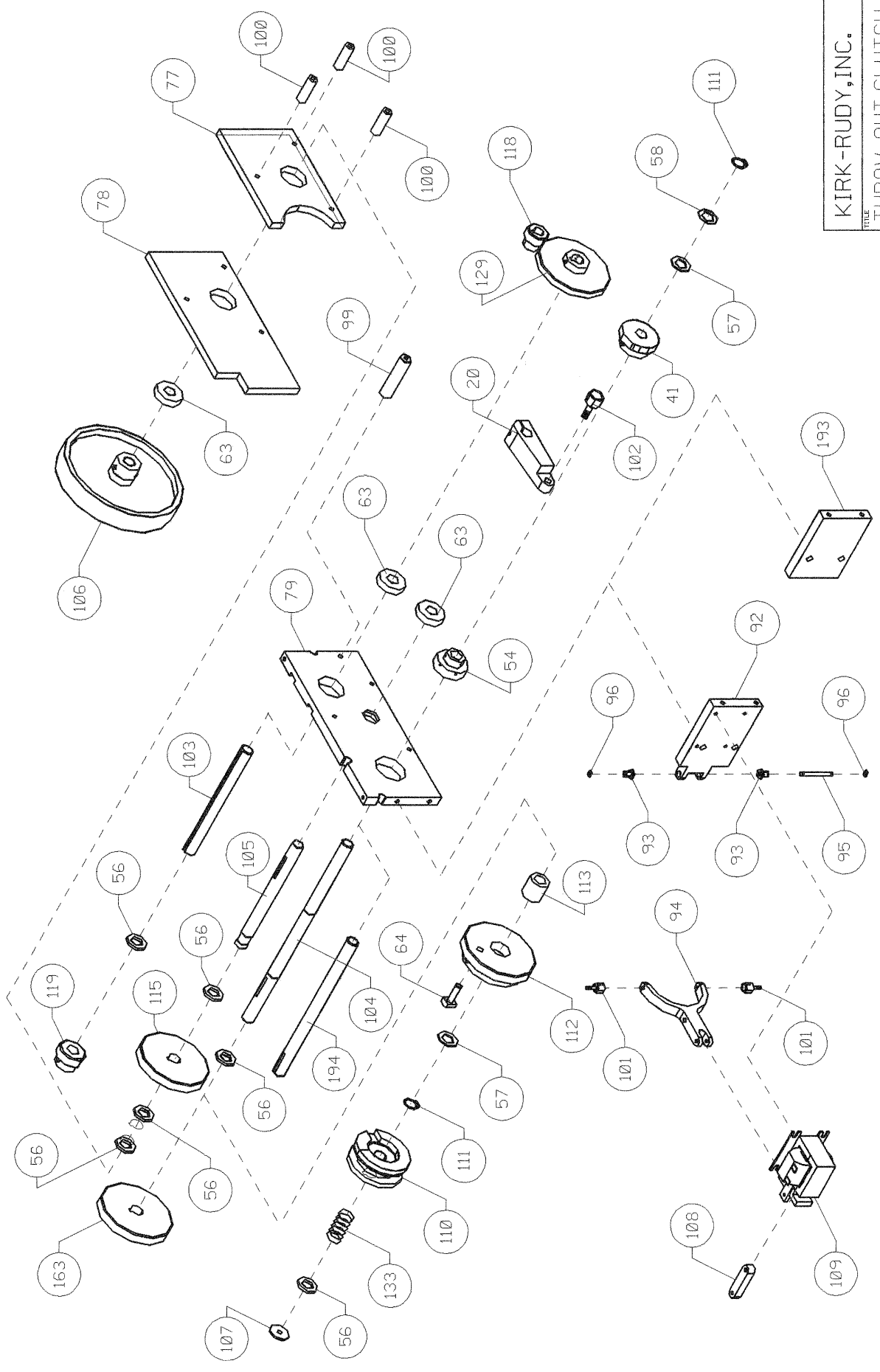


KIRK-RUDY, INC.

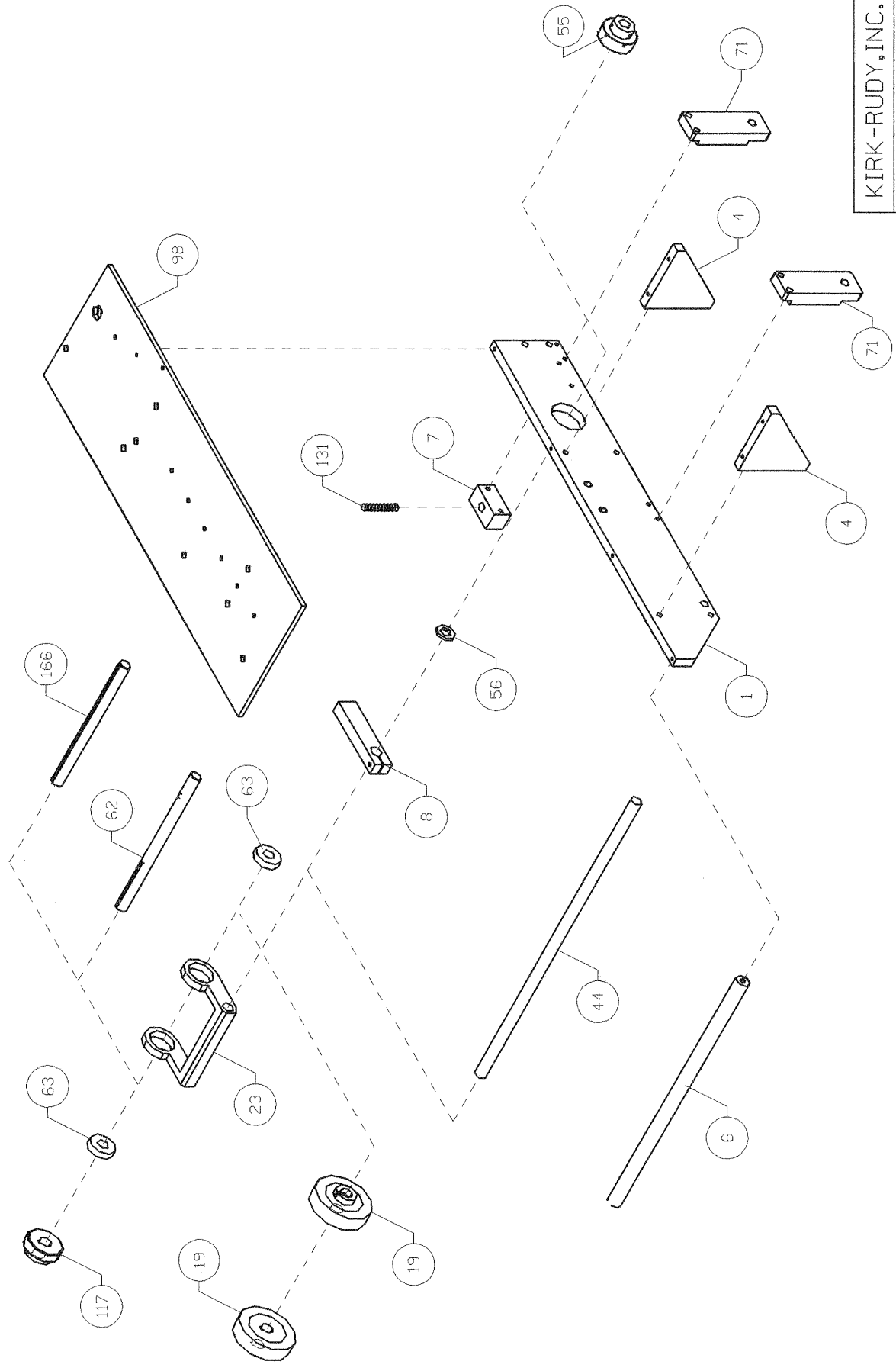
JOGGER TABLE

DATE 1/27/87		DRAWING NO.
DRAWN BY MWM	ISSUE 1	508700

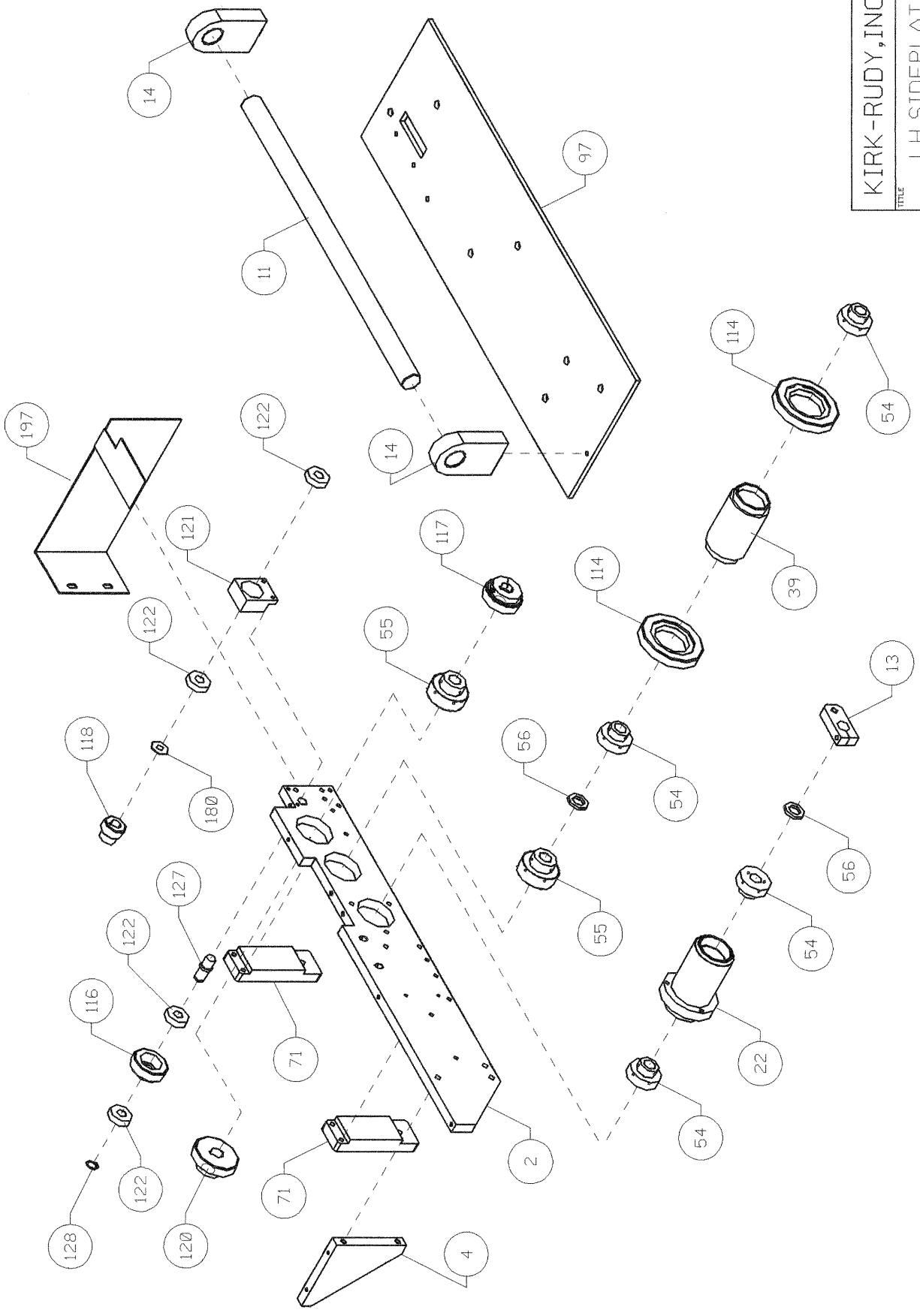
5087.p09.ex1



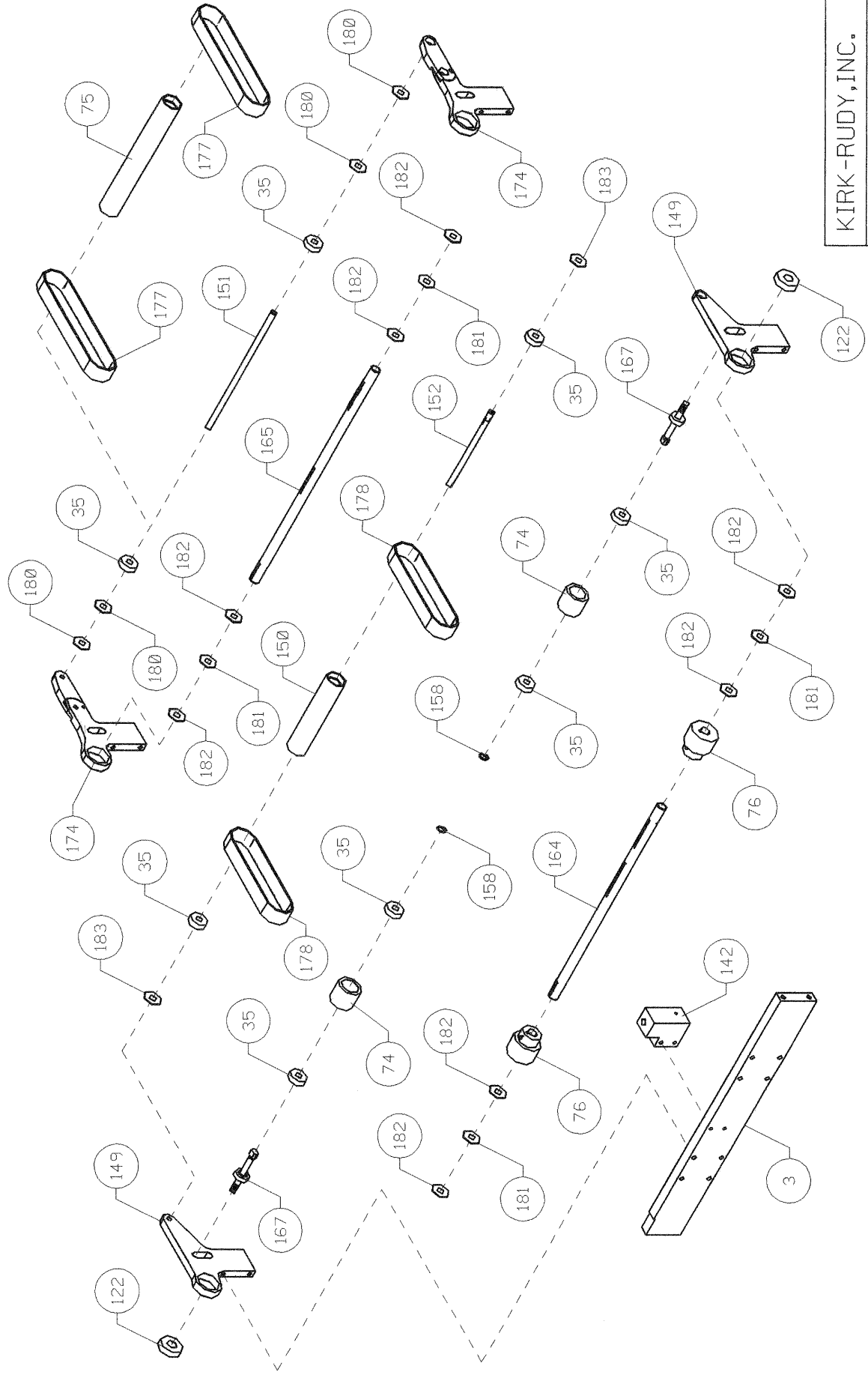
KIRK-RUDY, INC.	
THROW-OUT CLUTCH	
DATE	1/27/87
DESIGNED BY	MJM
REVIEWED BY	1
FIG. NO.	508700
5087P10.ex1	



KIRK-RUDY, INC.	
RH SIDEPLATE	
DATE	1/27/87
DESIGNED BY	MM
ISSUED BY	1
ISSUE #	1
REVISION	
5087 p 11 of 1	

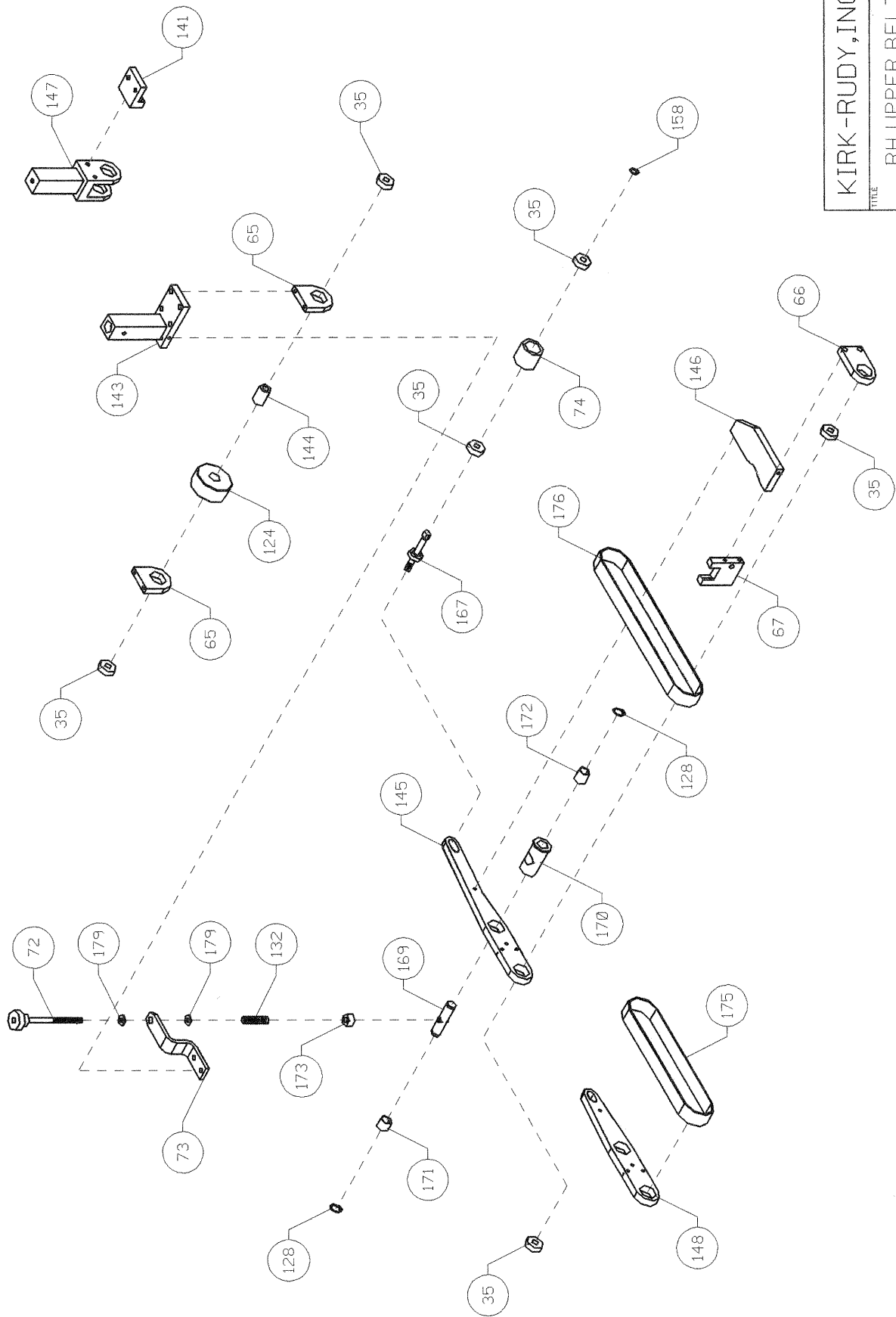


KIRK-RUDY, INC.	
LH SIDEPLATE	
DATE	1/27/87
DESIGNED BY	MWM
ISSUE	1
DRAWING NO.	508700
FILE NAME	5087 p12.ex1

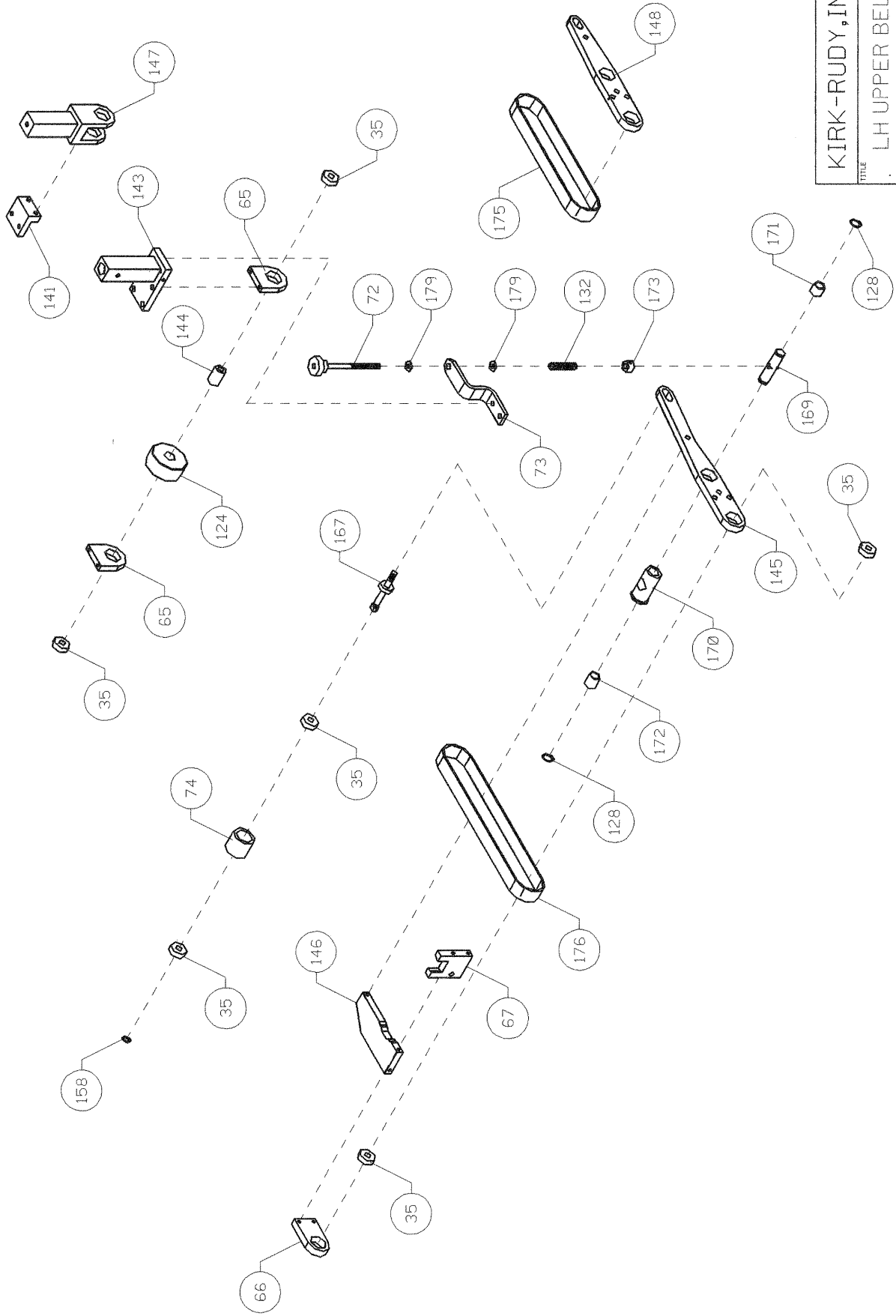


KIRK-RUDY, INC.	
TITLE	
LOWER BELTS	
DATE	1/27/87
DESIGNED BY	MWM
ISSUED BY	1
FIGURE NO.	508700

5087 p13.ea1



KIRK-RUDY, INC.			
RH UPPER BELT			
DATE	1/27/87	DESIGNED BY	MM
DRAWN BY	MWM	ISSUE	1
508700		5087 p 14.cw	



KIRK-RUDY, INC.

TITLE
LH UPPER BELT

DATE

1/27/87

DESIGNED BY

MWM

ISSUE

1

REV. NO.

508700

5087 p 15 of 21

FEEDER HOPPER SET UP

A. Vacuum Plates - three vacuum plates are furnished with your machine....

1. Deep hollow - used for light material: e.g., envelopes cards, etc. - material that will conform to the deep, concave depression when vacuum is applied.
2. Shallow hollow - for medium weight material; e.g. self-mailers, light newspapers, folded sheets pamphlets, etc. - material that will conform into the shallow concave depression when vacuum is applied.
3. Flat - for heavy material such as catalogs, booklets, magazines, etc.

Select the proper vacuum plate using the aforementioned as a guide - inherent peculiarities in some mailing piece stocks might require interchanging the vacuum feed plates to achieve optimum feed operation. The vacuum plate is mounted to the feed shuttle by two allen cap screws - clean all foreign material from the bottom of the vacuum plate and the shuttle mounting block before mounting. A light coating of grease on the bottom periphery of the vacuum plate is usually helpful to insure a good vacuum seal.

B. Side Guides - loosen thumb screws and move feeder side guides to allow approximately 1/8" clearance between the face of the guides and the mailing piece.

NOTE: the mailing piece should be centered with the gate and upper feed rollers when possible.

C. Jogger Table - insert a few mailing pieces between the side guides (front edge flush with the gate) and move the jogger table until the vertical back plate is approximately 1/8" behind the rear edge of the mailing pieces. The jogger table is easily traversed along its mounting bar by pushing in the area of the jogger table hand screw.

D. Pusher Blocks - two pusher assemblies are provided to assist in feeding heavy material when vacuum alone will not suffice. To adjust---rotate machine by hand until feed table has reached its extreme rear travel, loosen front allen holding screws and slide pusher block assemblies until pusher 'lip' is 1/4" from rear of mailing piece and ~~by~~ turning ^{the} rear pusher block allen screws counterclockwise ^{the} front

edge of the spring-loaded pusher 'lip' can be raised - adjust height of lip to approximately one half the thickness of an individual mailing piece.

- E. Lifter Fingers - two lifter finger assemblies are provided to assist in feeding wide, limp material (e.g., tabloids, newspaper stock, etc.) more effectively. The lifter fingers give this type material more rigidity at the gate separation area. To adjust, loosen retaining nuts thereby permitting movement of the fingers laterally in their respective slots on the jogger plate and up and down in the hex head bolt assemblies. Position each finger approximately $1/4$ to $1/3$ in from the edge of the mailing piece and raise to within $1/2$ to 1" from feed table.

NOTE: Lifter fingers should always be at least $1/8$ " above feed table.

- F. Gate - loosen the $3/8$ " locknut holding the gate adjusting knob secure - to raise the gate turn the knob counterclockwise, clockwise to lower. With mailing pieces in the feed hopper and feeder vacuum pump on, rotate machine by hand until feed table has just started its forward travel-at this point adjust gate to allow one piece to feed while restricting movement of other pieces. Check under operation and adjust gate up or down accordingly.
- G. Upper Feed Rollers - with mailing pieces in feed hopper and feeder vacuum pump actuated, rotate machine by hand until the feeder vacuum releases and the lower feed rollers make contact with the mailing piece. At this point sufficient pressure should be exerted from the upper feed roller to propel the mailing piece onto the table top. Loosen the upper feed roller locking collars and turn the feed roller adjusting knobs (clockwise for more pressure, counterclockwise for less feed roller pressure). It is important that both feed rollers exert even pressure on mailing piece - 'fish-tailing' from feed hopper indicates uneven feed roller pressure.