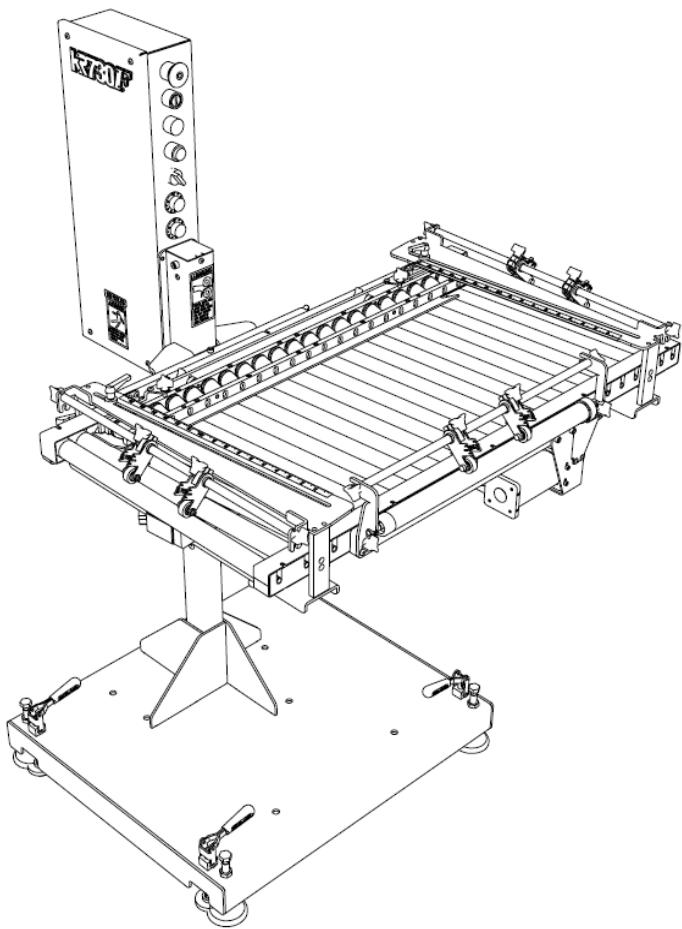




Instruction and Parts Manual

KR730F Roller Registration

Conveyor



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.

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

1 Important Safety Instructions

Intended Use Statement: The KR730F Roller Registration Conveyor is designed to run in line with other modular equipment to register product. Product flow can enter from the side or from the infeed end of the KR730F. Also, the direction of the flow of the product can be changed from left to right or right to left by turning the tube roller conveyor over during the make ready procedures. When product enters the KR730F from the side a speed up roller is used to control the speed of the product and angle of the product to cross over the tube rollers. The vertical height of the tube roller conveyor is can be adjusted from 24 inches to 37-1/2 inches by pulling up or pushing down on the electrical box. A gas cylinder in the vertical upright tube stand assists in height adjustment. The tube roller conveyor on the KR730F can tilt from level to 16 degrees infeed end down, outfeed end up or infeed end up, out feed end down to allow for transfer of product to two different tabletop heights up to 10 inches in difference. Usage for other purposes may lead to an unsafe condition.

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



WARNING

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

2 SPECIFICATIONS

PRODUCT SIZES	Standard	Metric
PRODUCT SIZE RANGE	English	Metric
Minimum Size:	3" W x 3" L	76mm W x 76mm L
Maximum Size:	17" W x 17" L	432mm W x 432mm L
Minimum Thickness:	.004"	.1mm
Maximum Thickness:	.25"	6.5mm

SPEED

Maximum	Variable to 500 f/m	153m/min
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MACHINE DATA (see Figure 1.0)

Length:	38.25"	97.2cm
Width:	34.00"	86.4cm
Height:	58.50"	148.6cm
Conveyor Height Minimum	24.00"	60.9cm
Conveyor Height Maximum	37.50"	95.2cm
Maximum Height Difference	12.50"	25.4cm
Max Tilt Angle	16 Degrees	
Weight: Net	lbs.	kgs
Shipping Crate:	lbs.	kgs

ELECTRICAL

120 VAC, Single Phase 60/50 Cycle, 8A
1/2 HP DC Motor 2500RPM Main Motor
1/15 HP DC Motor 3500RPM Speed Up Motor
Stop In and Stop Out Signal Connections

OPTIONS

Foot Operated Floor Jack (4 required) - 554036-02

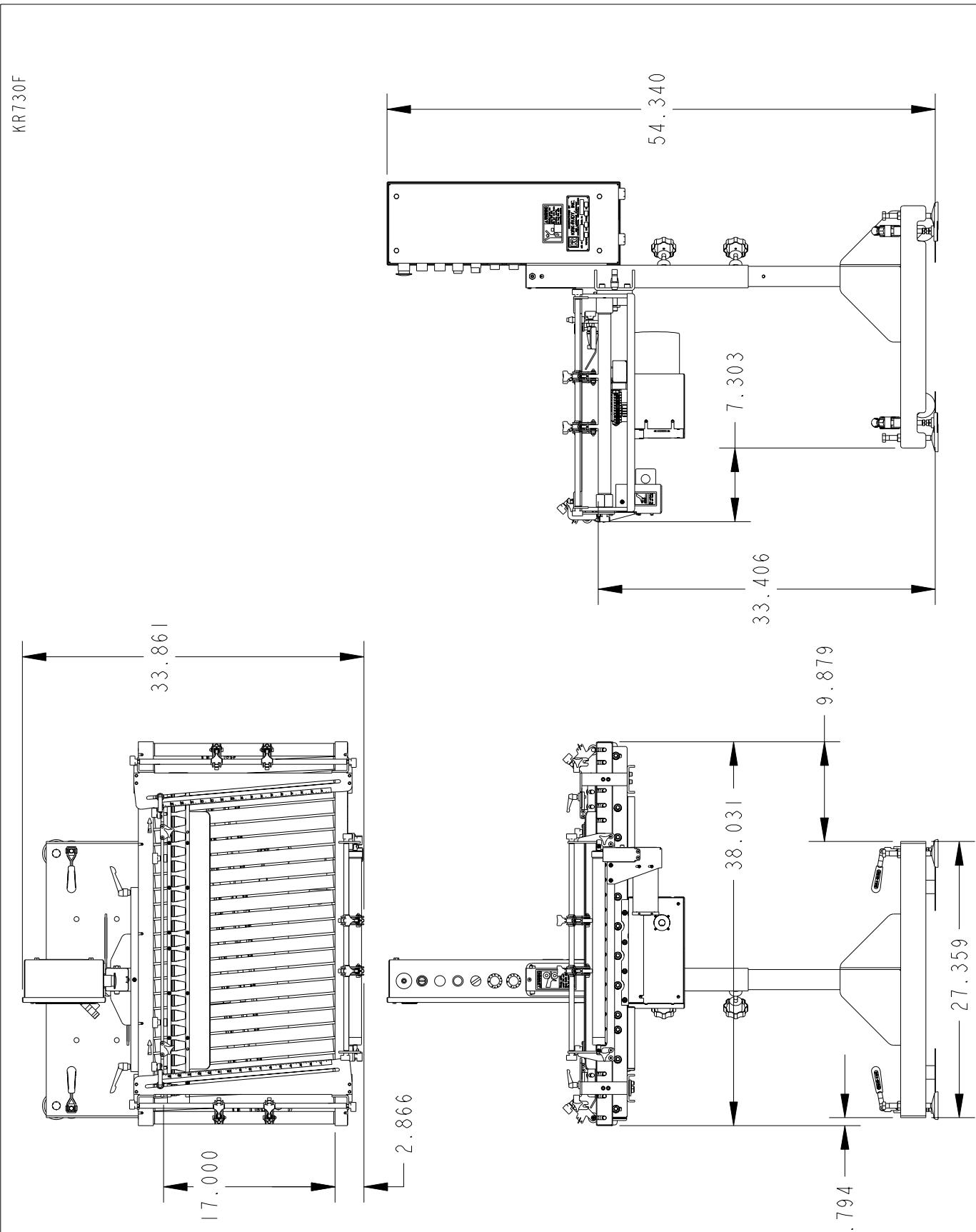


FIGURE 1.0

3 INSTALLATION



WARNING

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

3.1 UNCRATING

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

1. Position crate in a suitable open area.
2. Remove crate top and sides.
3. Remove metal strapping and securing blocks.
4. Locate accessories box and use checklist to verify all items were shipped.
5. Use a forklift to raise the base out of the crate.
6. Roll the base in the desired location.

4 MACHINE DESCRIPTION



WARNING

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

4.1 COMPONENT DESCRIPTION (see Figure 2.0 through 6.0)

4.1.1 Main Component Description (see Figure 2.0)

1. **Control Panel/Electrical Box:** Houses all of the electrical controls and components. (See **Figure 3.0** for further illustration)
2. **Tube Roller Conveyor:** Twenty-five tube rollers make up the tube roller conveyor. Twenty-three tube rollers are angled in one direction to register a product against the skid bar guide. The infeed and outfeed end rollers are perpendicular to the product flow for accurate transfer onto and off of the tube roller conveyor.
3. **Tilt Adjustment Knobs:** Unscrewing and removing the screw knobs allows the tube roller conveyor to be tilted up to 16 degrees and allows the height difference between in-line equipment to be up to 10 inches or completely turned over. Each screw knob can be screwed into one of three holes to secure the tube roller conveyor at the angle and direction desired.
4. **Height Adjustment Knobs:** Used to hold the height of the tube roller conveyor. Loosening both of these knobs allows for up and down movement of the tube roller conveyor for setting the height. The height adjustment is assisted by a gas spring in the vertical upright tube. After loosening the height adjustment knobs lift or lower the conveyor by on the standing backside of the base and lifting up or pushing down on the electrical box.

Note: After setting the height of the tube roller conveyor, make sure to tighten both knobs tightly to prevent vibration of the conveyor.

KR730F

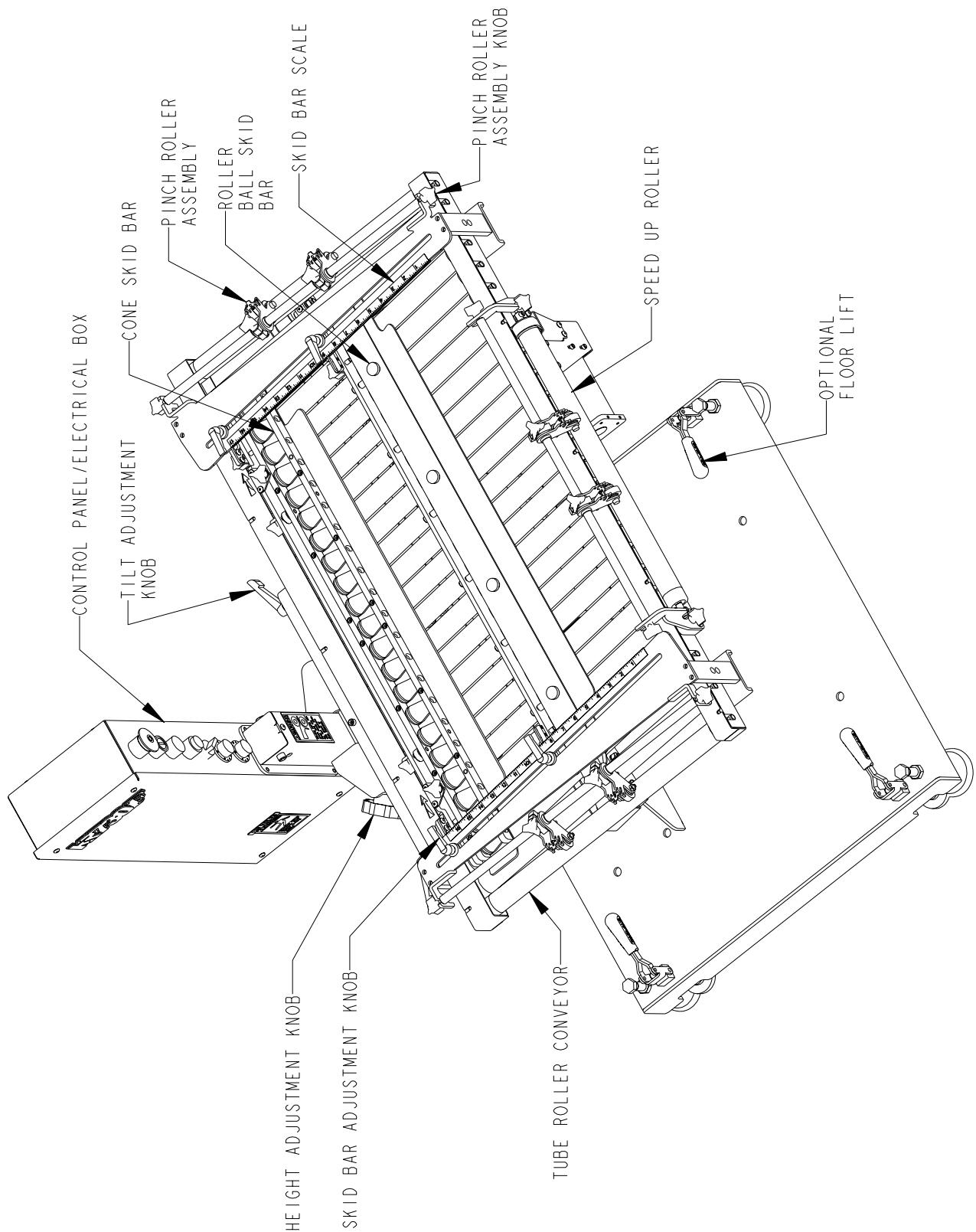


FIGURE 2.0

5. **Cone Skid Bar Assembly:** Two skid bar assemblies are supplied with each machine – a cone skid bar assembly and a roller ball skid bar assembly. The cone skid bar assembly consists of a product guide, a skid bar guide and cone rollers and is normally used as a registration guide for thicker products.
6. **Roller Ball Skid Bar Assembly:** The roller ball skid bar assembly (not shown in Figure 2.0) consists a product guide, a skid bar guide, and plastic or steel roller balls and is normally used as a registration guide for thinner products. The plastic roller balls are normally used when a lighter roller ball is needed to allow the product to get under the skid bar roller balls when fed from the side.
7. **Skid Bar Adjustment Knobs:** Provides a way to adjust and secure the skid bar assembly in place.
8. **Skid Bar Scale:** A scale on each end of the conveyor is provided to help the operator position the skid bar assembly. The scales are to ensure the alignment of the skid bar assembly for accurate registration. Adjust the skid bar so both indicators line up with the same tick mark on each scale and, as a rule of thumb, add an inch to the product size for setting the scale.
9. **Speed Up Roller Assembly:** The speed up roller is only used in side feeding product on the tube rollers. The purpose of the speed up roller is to control the product speed and angle as it crosses over the angled tube rollers to the skid bar guide. The speed of the speed up roller is set to drive the product underneath the cone rollers or roller balls (depending on which skid bar assembly is used) and to the skid bar guide with minimum bounce back when hitting the skid bar guide.
10. **Pinch Roller Assembly(s):** Two pinch roller assemblies are supplied with each machine. One set of pinch roller assemblies is mounted on the speed up roller (side feed) or infeed roller (end feed) and the other pinch roller assembly is used on the outfeed roller. The pinch rollers help drive the product and ensure the product is transferred straight on and off the tube roller conveyor. They also can be used to direct the product upward or downward while passing over the speed up roller when the product is being fed from the side.
11. **Pinch Roller Assembly Knob:** This knob is used to secure the pinch roller assembly in place. Loosen these knobs to move the assembly to another roller or adjust the pinch roller tangent position to control the angle of the product after it passes under the pinch roller.
12. **Floor Lifts (Optional):** The floor lifts are a quick way to move the base in place and lift the base off of the floor. Each floor lift toggles over and can be operated by foot.

4.1.2 Electrical Box Component Description (See Figure 3.0)

1. **Emergency Stop/Power Off Button:** Pressing this button cuts the power off to the control panel during normal operating conditions or in an emergency to kill the power to the machine.
2. **Power Button:** Pressing this button powers up the control panel. The button is lighted green when the machine is powered up.
3. **Start Button:** Pressing this button starts the main conveyor tube rollers and the speed up rollers (if used). The button is lighted green when the machine is running.
4. **Stop Button:** Pressing this button stops the machine.

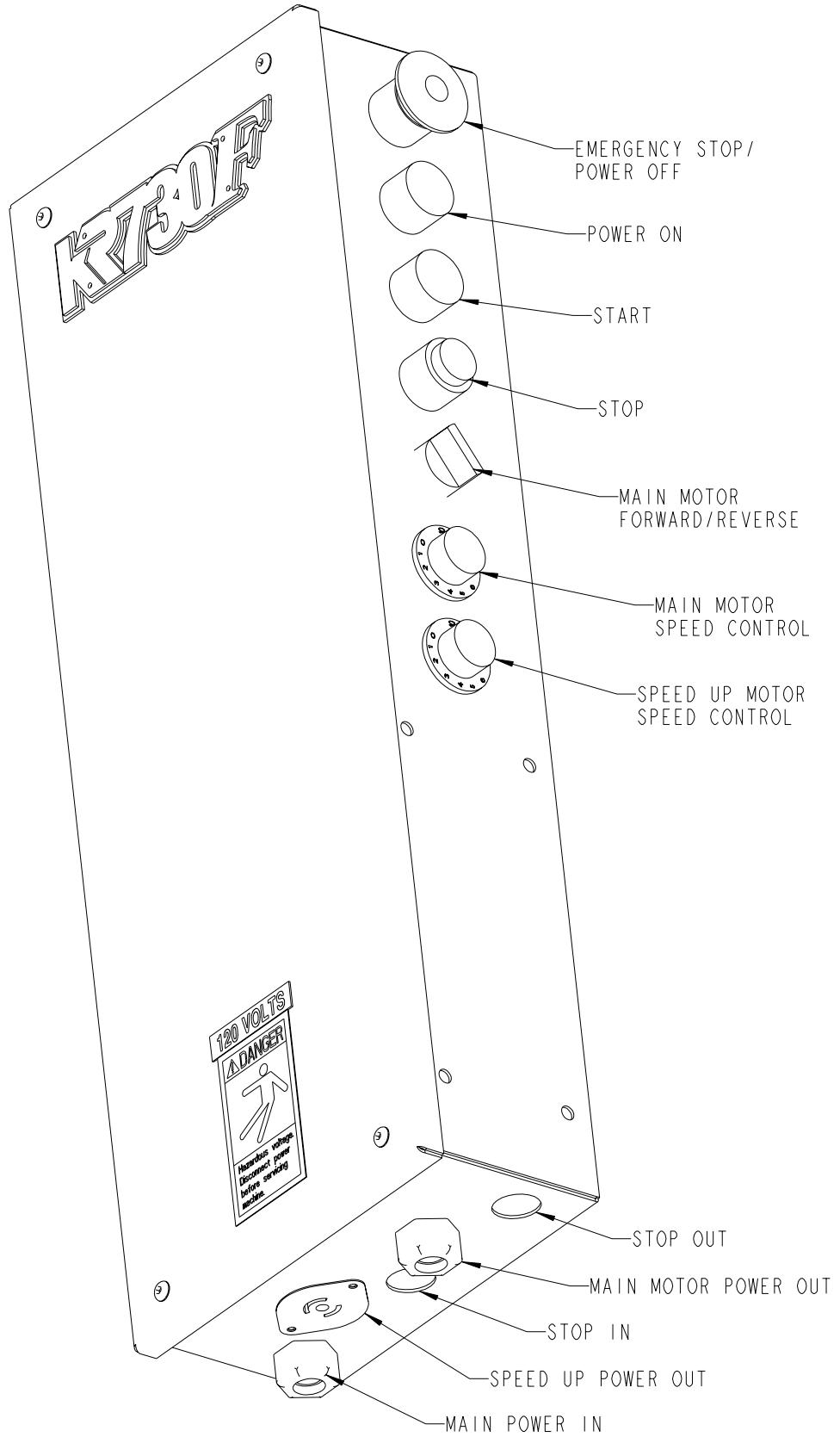


FIGURE 3.0

5. **Main Motor Forward/Reverse Switch:** The two-position switch is used to control the direction of the motor for the tube rollers. **NOTE: It is best to stop the machine before changing switch settings.**
6. **Main Motor Speed Control Knob:** Controls the speed of the tube rollers.
7. **Speed Up Motor Speed Control Knob:** Controls the speed of the speed up roller.
8. **Stop Out Connector:** Used to stop an upstream machine when the machine is stopped.
9. **Stop In Connector:** Used to stop the machine when a downstream machine is stopped. **NOTE: If not using a stop in input, a jumper plug must be installed for the machine to run.**
10. **Main Motor Power Out Connector:** Supplies power to the machine motor driving the tube rollers. **CAUTION: The main motor power must be disconnected when changing the machine to run the opposite direction.**
11. **Speed Up Power Out Connector:** Supplies power to the speed up motor. **CAUTION: The speed up power must be disconnected when removing the speed up roller assembly.**
12. **Main Power In Connector:** Used to provide power to the machine.

4.1.3 Cone Skid Bar Assembly Component Description (See Figure 4.0)

1. **Skid Bar Mount Knob:** Used to secure the cone skid bar assembly in place and is removed to remove the cone skid bar assembly.
2. **Skid Bar Guide:** Used to stop the product when the product is fed from the side and used to register the product whether being fed from the side or the infeed end of the machine.
3. **Skid Bar Release Knob:** Used to secure the skid bar guide in place. **NOTE: The height of the skid bar guide is set at the factory but the knob is in a slotted hole to allow removal or installation of the skid bar assembly on the machine. It is important the skid bar guide is at its lowest position when the knobs are tightened keeping the skid bar guide .020 to .030 inches above the tube rollers when in operation. This will keep the skid bar guide at minimum clearance above the tube rollers.**
4. **Product Guide:** Used to guide the product under the cone rollers when the product is fed onto the tube rollers from the side.
5. **Cone Rollers:** The cone rollers are mounted in slots in the cone roller mount bars so that they ride on and are driven by the tube rollers by use of o-rings. The slots allow product to move the cone rollers upward and pass underneath. When the product is fed from the side, the cone of the cone rollers allow product to move the cone rollers upward and pass underneath. The o-rings also help to control bounce back after the skid bar guide stops the product. Whether fed from the infeed end or the side, the cone rollers help drive the product to register against the skid bar guide as the tube rollers conveys the product to the outfeed end of the machine.
6. **Height Adjustment Knob:** Controls the height of the skid bar guide and the cone roller mount bars. **NOTE: The skid bar height adjustment lock knobs must be loosen before the height adjustment knobs are turned.**

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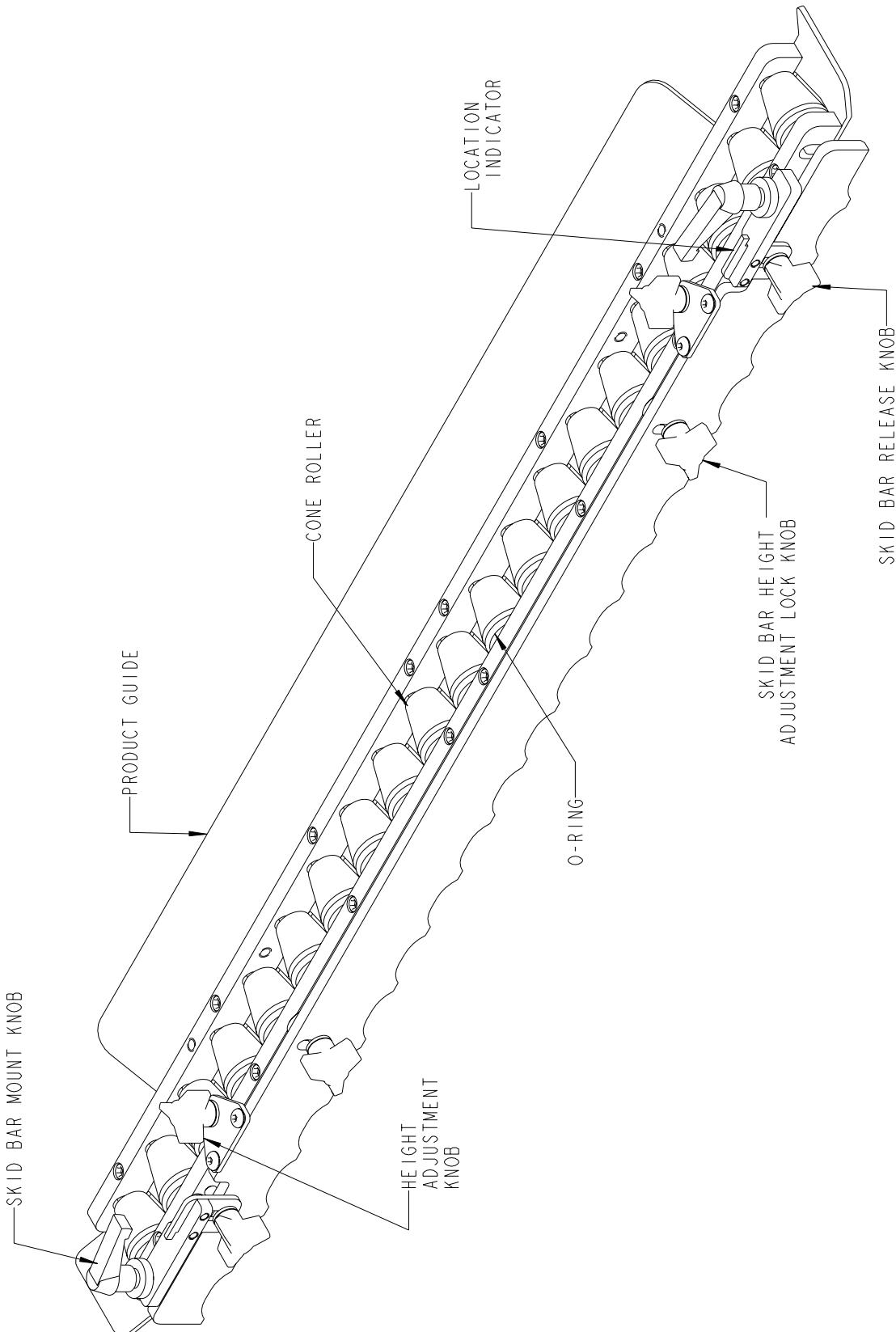


FIGURE 4.0

INDIVIDUALLY DRIVEN CONE ROLLER SKID BAR

7. **Skid Bar Height Adjustment Lock Knob:** Used to secure the cone roller mount bars and product guide assembly. **NOTE: The knobs must be loosened to adjust the height of the skid bar guide and cone roller mounts.**
8. **Location Indicators:** Used to indicate the location of the ends of the skid bar assembly on the conveyor in relation to the skid bar scales.

4.1.4 Roller Ball Skid Bar Assembly Component Description (See Figure 5.0)

1. **Skid Bar Mount Knob:** Used to secure the roller ball skid bar assembly in place and is removed to remove the roller ball skid bar assembly.
2. **Skid Bar Guide:** Used to stop the product when the product is fed from the side and used to register the product whether being fed from the side or the infeed end of the machine.
3. **Skid Bar Release Knob:** Used to secure the skid bar guide in place. **NOTE: The height of the skid bar guide is set at the factory but the knob is in a slotted hole to allow removal or installation of the skid bar assembly on the machine. It is important the skid bar guide is at its lowest position when the knobs are tightened keeping the skid bar guide .020 to .030 inches above the tube rollers when in operation. This will keep the skid bar guide at minimum clearance above the tube rollers.**
4. **Product Guide:** Used to guide the product under the roller balls when the product is fed onto the machine from the side.
5. **Ball Skid Bar:** Holds the roller balls. Slots in the mounting screw holes allow for adjustment in height; however, for the roller ball skid bar to work, each roller ball must be touching the tube rollers when no product is under the roller ball.
6. **Roller Balls:** The roller balls are inserted in holes in the ball skid bar that keeps each ball directly over a tube roller. There are two types of balls, steel balls and plastic balls. The plastic balls are used when less weight is needed. (Such as when product is fed in from the side and the product is too light to drive under the steel balls.)
7. **Ball Keeper Bracket:** Keeps the roller balls in the ball skid bar. Thumbscrew knobs allow for removal of the ball keeper bracket to change out roller balls. A magnet can be used to remove the steel roller balls. A piece of tape can be used to remove the plastic roller balls.

4.1.5 Speed Up Roller Component Description (See Figure 6.0)

1. **Pinch Roller Spring Tension Adjustment:** The spring tension is adjusted by pulling the spring anchor bracket out of the slot and either moving it to a closer or further away slot.
2. **Pinch Roller Adjustment Knob:** Used to adjust the pinch roller placement horizontally and vertically. **NOTE: The adjustment has a built-in stop to allow the pinch roller to be lifted upward from the speedup roller for thicker product; yet, have spring pressure when the product is between the pinch roller and the speedup roller.**
3. **Pinch Roller Assembly Adjustment Knob:** This knob is used to remove or adjust the pinch roller assembly. The mounting slot allows adjustment to position the roller at different tangent points on the speed up roller. This feature allows the

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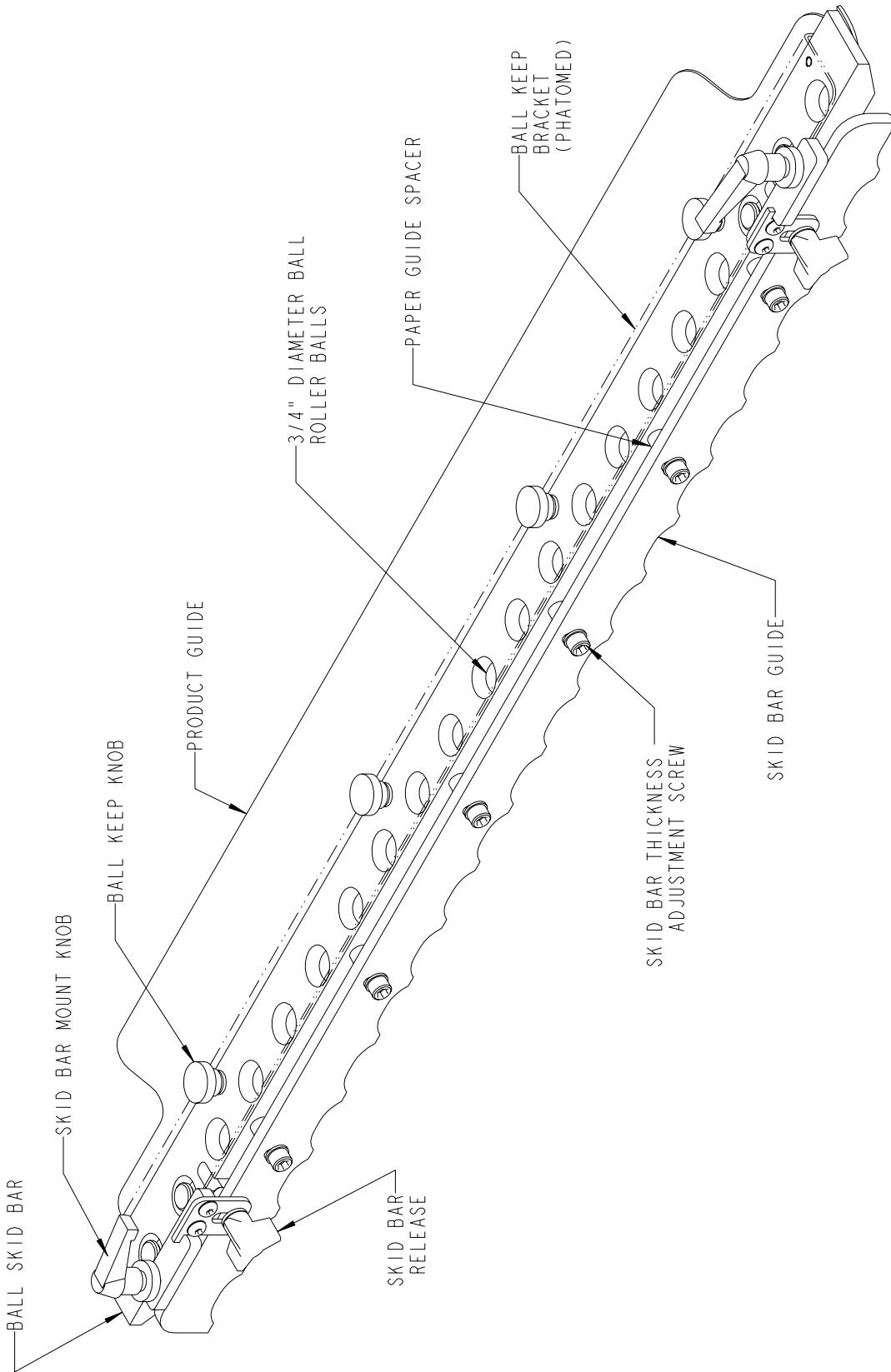


FIGURE 5.0

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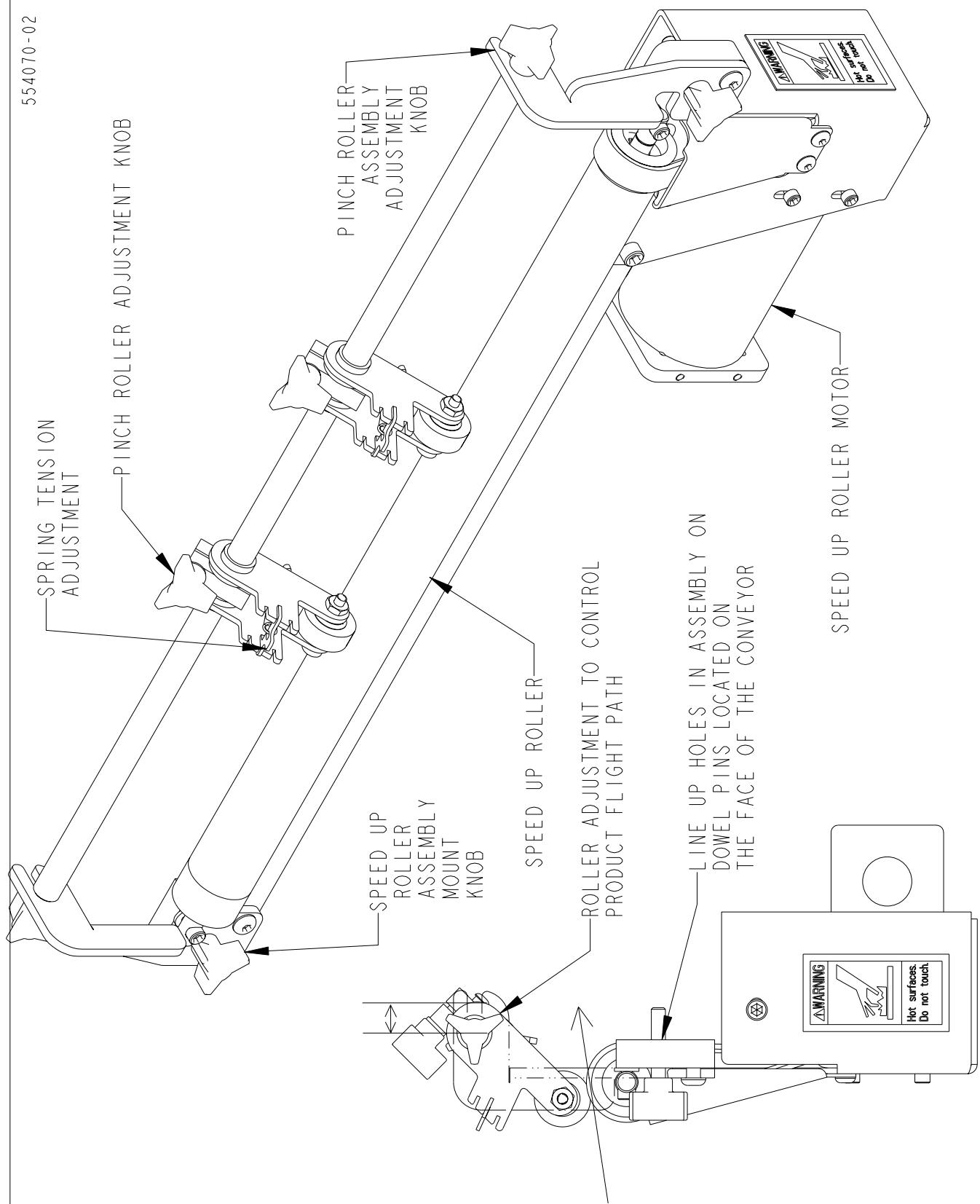


FIGURE 6.0

operator to aim the product to control the vector of the product. The less the product touches the angled rollers while feeding from the side the less the product will have a chance to skew before reaching the product guide on the skid bar.

4. **Speed Up Roller Motor:** The speed up roller motor is used to drive the speed up roller. The max speed is approximately 500 fpm.
5. **Speed Up Roller Assembly Mount Knob:** These knobs fasten the speed up roller assembly to the conveyor. Line up the dowel pins on the conveyor with the holes in the speed up roller assembly to mount. **Note: Make sure the two mounting knobs are tight after installation.**

5 MAKE READY INSTRUCTIONS



WARNING

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

5.1 INTRODUCTION

The make ready instructions provided in this section describe the recommended procedures for preparing the tube roller registration conveyor for a production run. The following steps and adjustments should be made prior to the use of the tube roller registration conveyor in production.

5.2 MAKE READY PROCEDURE

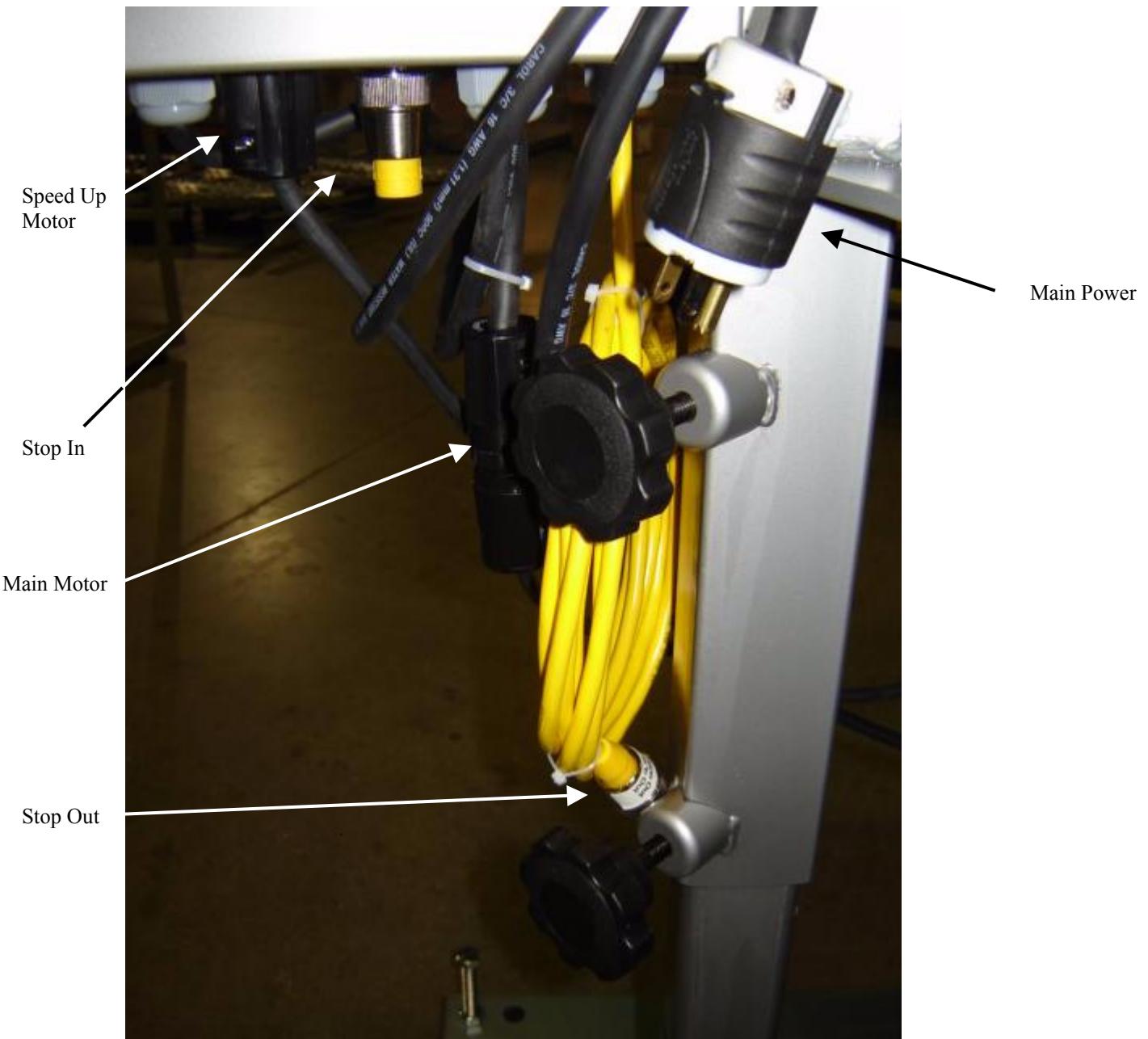
Before setting up the machine, it should be cleaned of any foreign material. Paper debris is easily removed with low-pressure air. When the machine is clean, proceed with the following make ready procedure.



WARNING

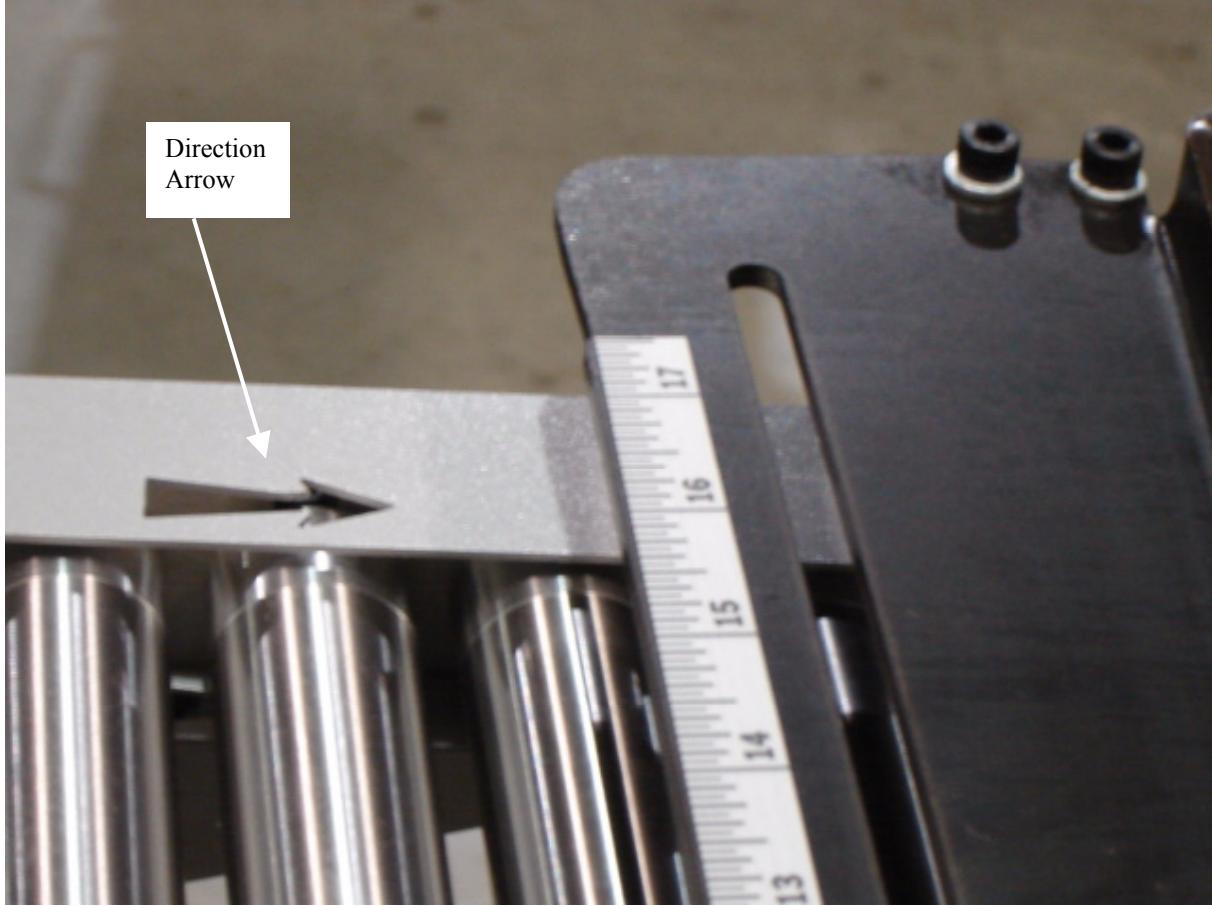
The power must be off before proceeding with the make ready procedure.

1. Make sure the power to the machine is off by checking the machine does NOT have the power cord (see **Picture 1**) plugged into the power source.



Picture 1 – Electrical Connections.

2. Check the direction of the machine, left to right or right to left by looking at the arrows on the back tube roller cover (see **Picture 2**). If necessary, follow the change direction instructions in Chapter 6 then proceed with the rest of the make ready instructions.



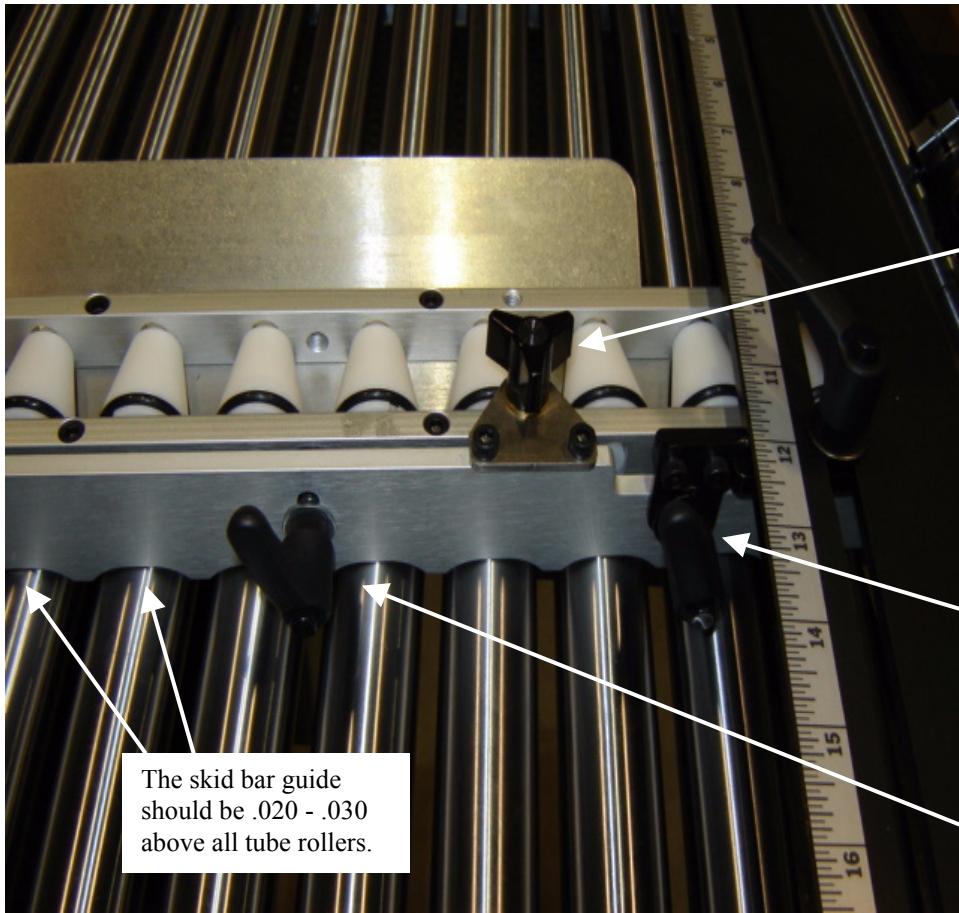
Picture 2 – Arrows on the back tube roller cover indicate the direction the machine should be running.

3. Roll the machine in place centering the tube roller conveyor with the center of product flow.
4. Raise the base of the machine off the floor with the floor lifts provided (see **Figure 2**).
5. Adjust the angle of the tube roller conveyor (if necessary) by loosening the tilt adjustment knobs (see **Figure 2**). Then, retighten the tile adjustment knobs.
6. Adjust the height of the tube roller conveyor by loosening the height adjustment knobs (see **Figure 2**). Then, stand on the backside of the base and lift up or push down on the electrical box till the top of the tube rollers are at the same height as the bottom of the incoming product. Then, tighten the height adjustment knobs. Make sure both knobs are tight.
7. Select and install the skid bar (see **Picture 3**). **NOTE: The roller ball skid bar assembly is normally used for thinner product and the cone skid bar assembly is normally used for thicker product.**



Picture 3 – Installing or removing skid bar assembly

8. Check the skid bar for correct adjustment (see **Picture 4**). **NOTE:** The skid bar guide should be **.020 -.030** above all tube rollers and each cone roller or roller ball should be touching a tube roller.



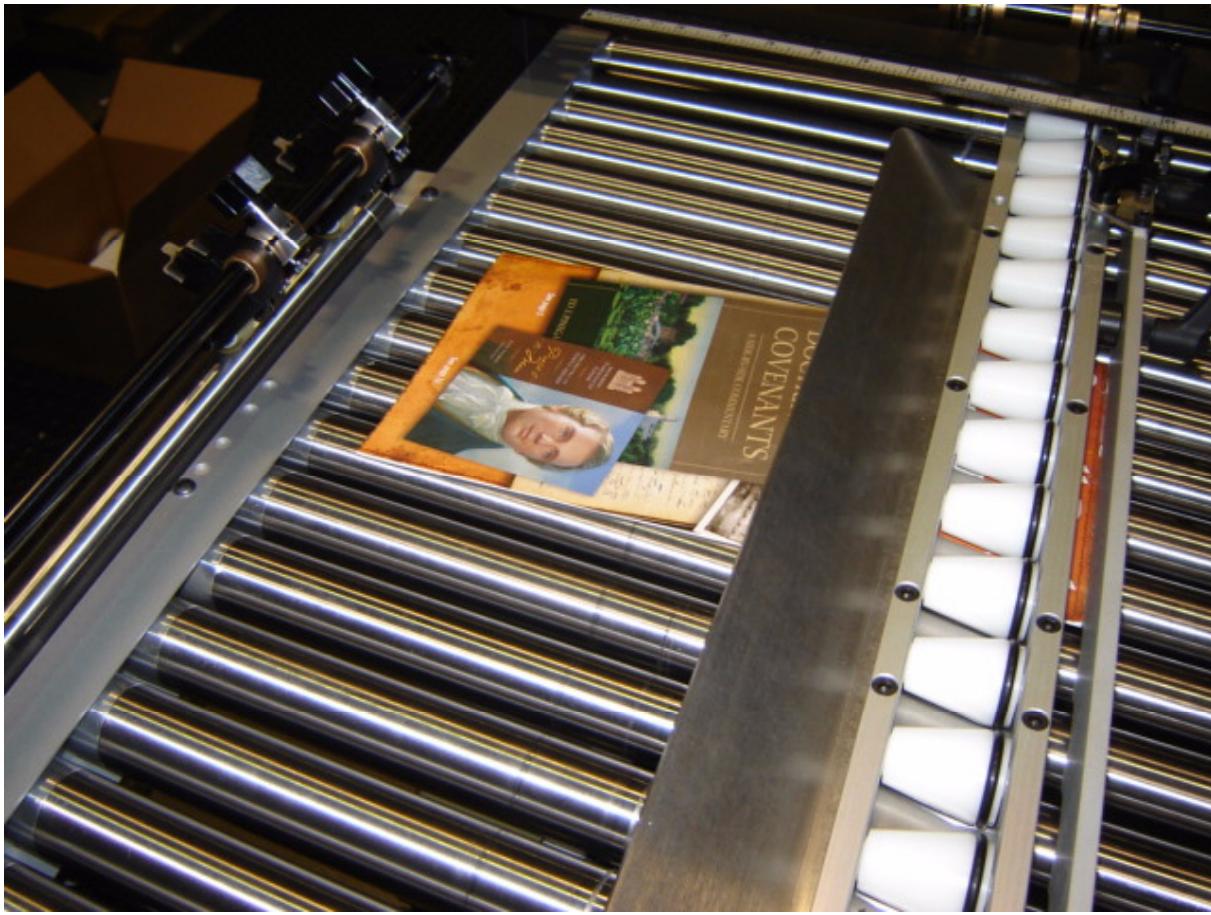
This knob is used to adjust the height of the cone roller bar. Loosen the height adjustment lock knob before turning. All cone rollers should touch the tube rollers.

The skid bar release knob is in a slotted hole. Make sure the skid bar guide is at its lowest position when tightening.

Skid bar height adjustment lock knob

Picture 4 – Check both ends of the skid bar for correct adjustment.

9. Position the skid bar according to the product size (see Picture 4). **NOTE: If feeding product from the side, the trailing end of the product should be about an inch from the end of the tube rollers when the leading edge of the product is against the skid bar guide. Make sure the skid bar is straight by using the skid bar scale tick marks.**



Picture 5 – Skid bar assembly set so that the trailing edge of the product is an inch from the end of the tube rollers.

10. Check the direction the machine is running by plugging the main power (see **Picture 1**) into the power source and pressing the main power button; then, the start button (see **Figure 3**). Make sure the rollers are turning in the direction of the arrow on the back tube roller cover (see **picture 2**). If not, stop the machine by pressing the stop button (see **Figure 3**) and turn the two-position selector switch (see **Figure 3**) to the opposite setting, press the start button and recheck the direction the machine is running.
11. If feeding product from the side, install the speed up roller assembly (see **Picture 6**) and connect the speed up roller motor to the electrical box (see **Picture 1**). Adjust the pinch rollers for the size and thickness of the product using the pinch roller adjustment knobs (see **Figure 5.0**).



Picture 6 – Installing or removing speed up roller assembly.

12. Set the main speed (see **Figure 3**) so that the tube rollers run slightly faster than the upstream equipment. If feeding product from the side set the speed of the speed up roller (see **Figure 3**) so the product has enough speed to reach the skid bar guide without skewing (Too much speed will cause excessive bounce back off the skid bar guide.). Adjust the trajectory of the product using the pinch roller assembly adjustment knobs (see **Figure 5.0**)
13. Connect the stop in and stop out (see **Picture 1**) as necessary and test. **NOTE: If not using a stop in input, a jumper plug must be installed for the machine to run.**
14. Test the machine by running multiple products through the machine to insure that all products are properly registered and conveyed.

6 CHANGING DIRECTION INSTRUCTIONS



WARNING

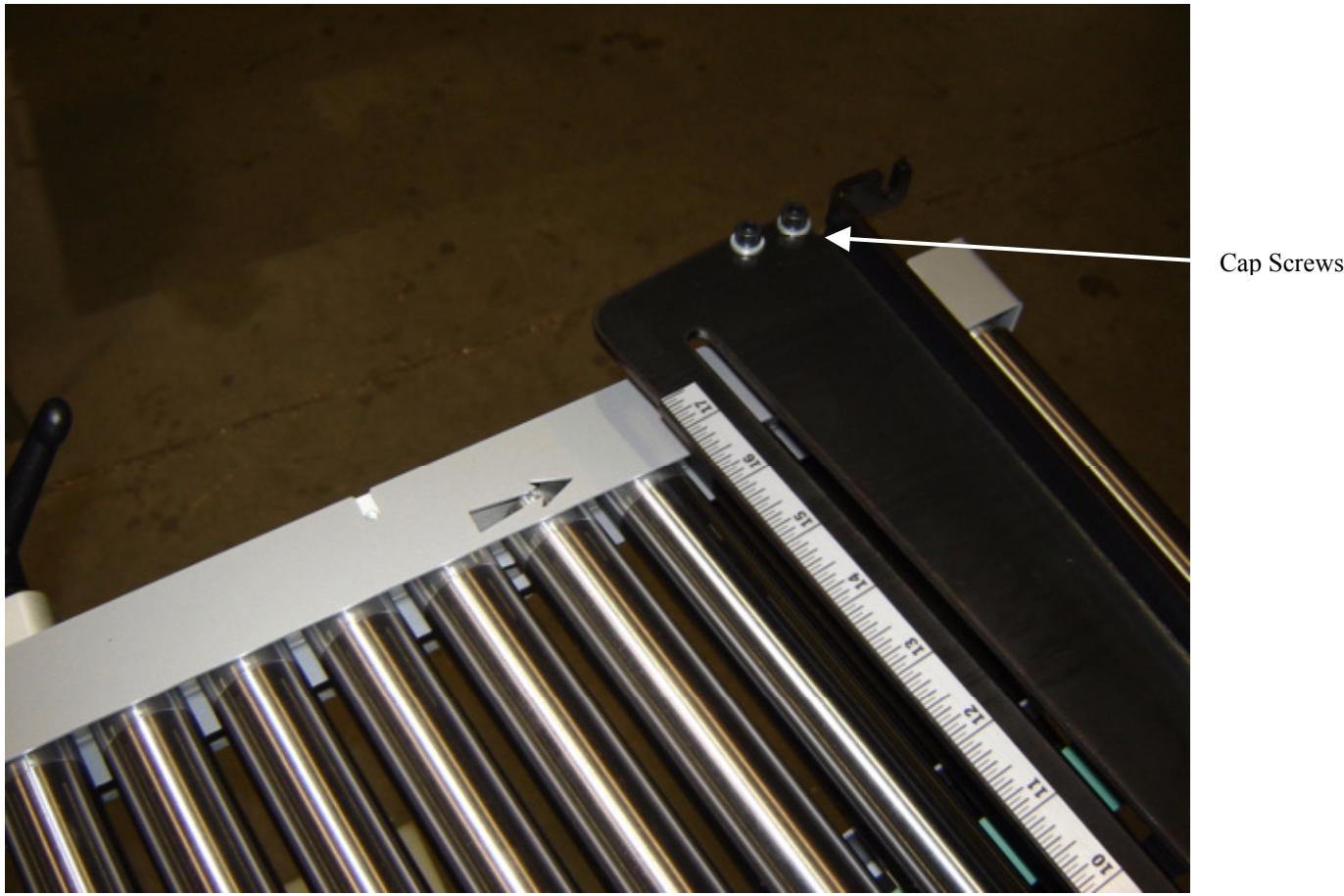
Read and follow all Safety Instructions in Section 1, Page 3 before proceeding.



WARNING

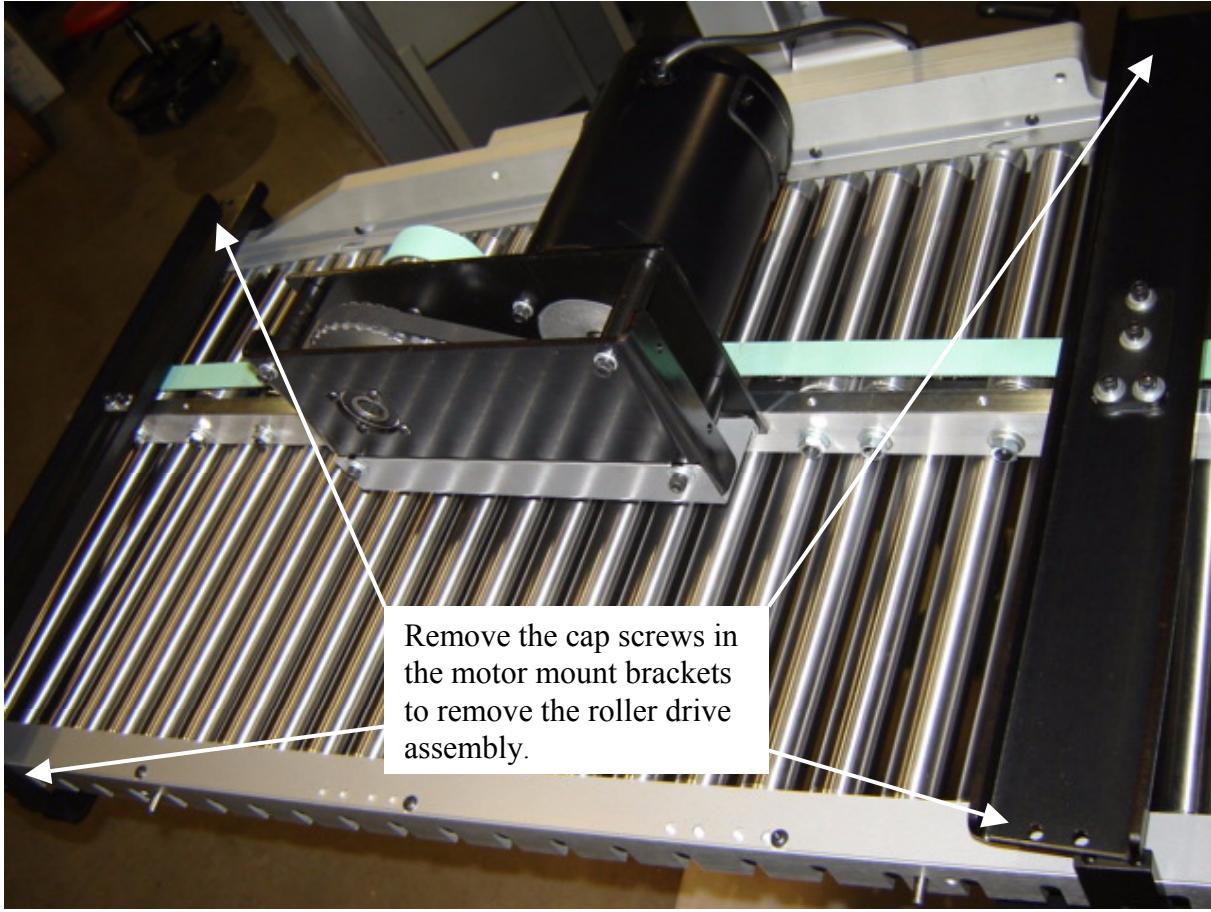
The power must be off before proceeding with the make ready procedure.

1. Make sure the power to the machine is off by checking the machine does **NOT** have the power cord (see **Picture 1**) plugged into the power source.
2. Unplug the motor connection for the speed up roller (see **Picture 1**), remove the knobs on each end of the speed up assembly (see **Figure 5.0**), remove the speed up assembly (see **Picture 6**) and set aside.
3. Remove the skid bar assembly (see **Picture 3**) by removing the skid bar mount knobs (see **Figure 4.0**) and loosening the skid bar release knobs (see **Figure 4.0**). Set aside the skid bar assembly.
4. Loosen the pinch roller assembly knobs (see **Figure 2.0**) and remove the pinch roller assembly on and infeed roller (if installed) and the outfeed roller. Set aside.
5. Remove both side guide support brackets (four cap screws each) and set aside (see **Picture 7**).



Picture 7 - Side guide support bracket cap screws.

6. Unplug the motor connection for the roller drive assembly (see **Picture 1**).
CAUTION: Failure to unplug the motor connection may cause the power cord to be severed when turning the tube rollers over.
7. Remove the tilt adjustment knobs (see **Figure 2**), turn the tube roller conveyor over, reinsert the tilt adjustment knobs and tighten.
8. Remove the roller drive assembly by removing the cap screws on the motor mount brackets (four cap screws each side) and set aside (see **Picture 8**).



Picture 8 – Removing and installing motor mount assembly.

9. Remove the tilt adjustment knobs (see **Figure 2**), turn the tube roller conveyor over, reinsert the tilt adjustment knobs and tighten.
10. Reinstall the roller drive assembly (see **Picture 8**)(four cap screws for each motor mount bracket).
11. Loosen the cap screws on the roller plate mount (two cap screws each side)(see **Pictures 9 and 10**) shift the roller plate mount to the so that the cap screws are at the other end of the slots on the motor mount brackets and retighten the cap screws for the roller plate mount. (The drive belt should end up perpendicular to the slanted rollers.)(See **Picture 8**).

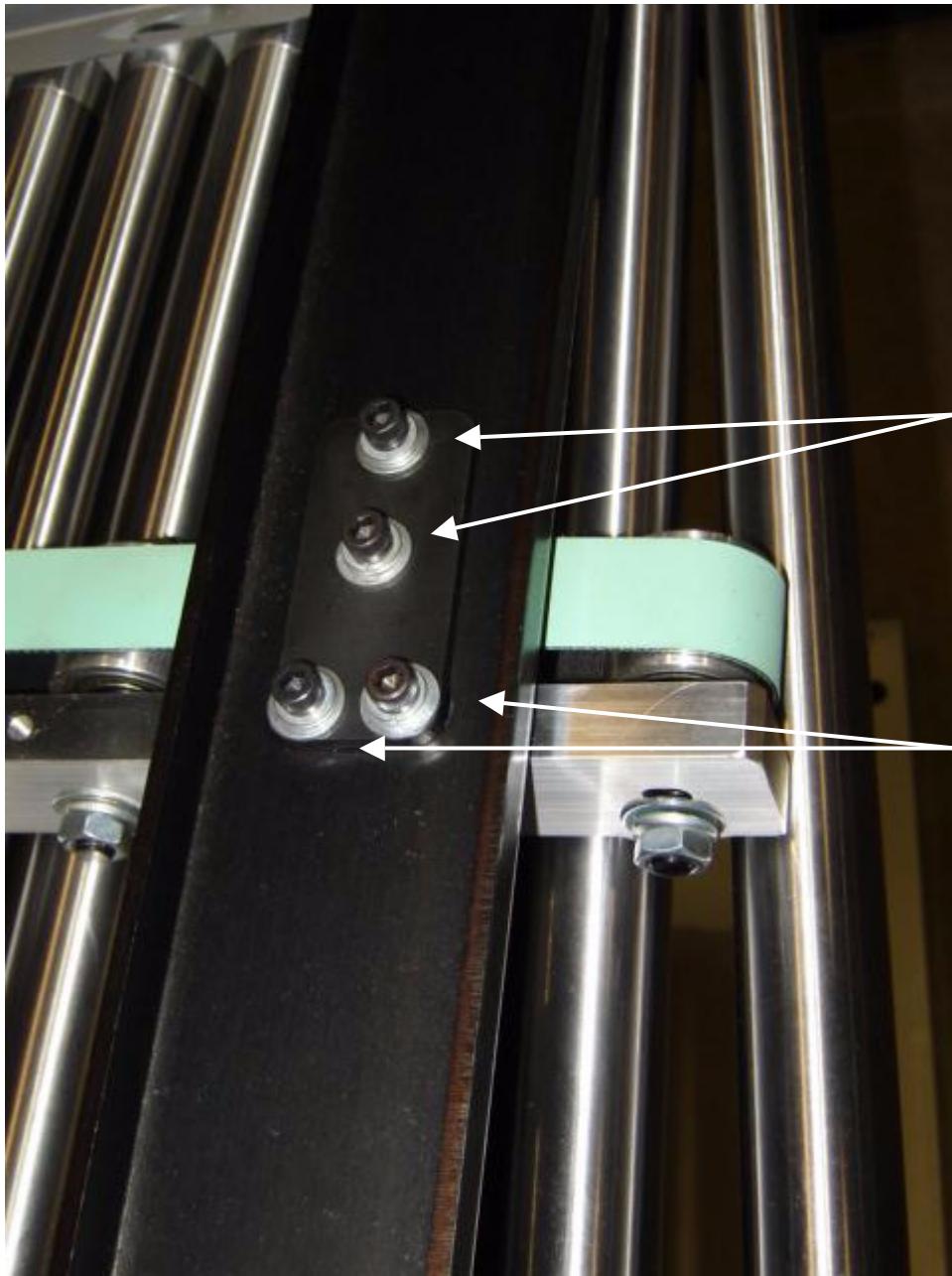


Loosen these
cap screws
for
repositioning.

Always move
the cap
screws to the
end of the
slots before
retightening.

Picture 9 – Pictured above is the left end of the motor drive assembly.

To change directions the main motor drive unit is removed from one side of the tube roller conveyor and reinstalled on the other side of the tube roller conveyor. Then, the two cap screws in the mount are loosened on each end and unit is reposition so as the drive belt is perpendicular to the slanted rollers and the end screws are retightened. The cap screws should always be at one end or the other of the slots in the motor mount bracket.

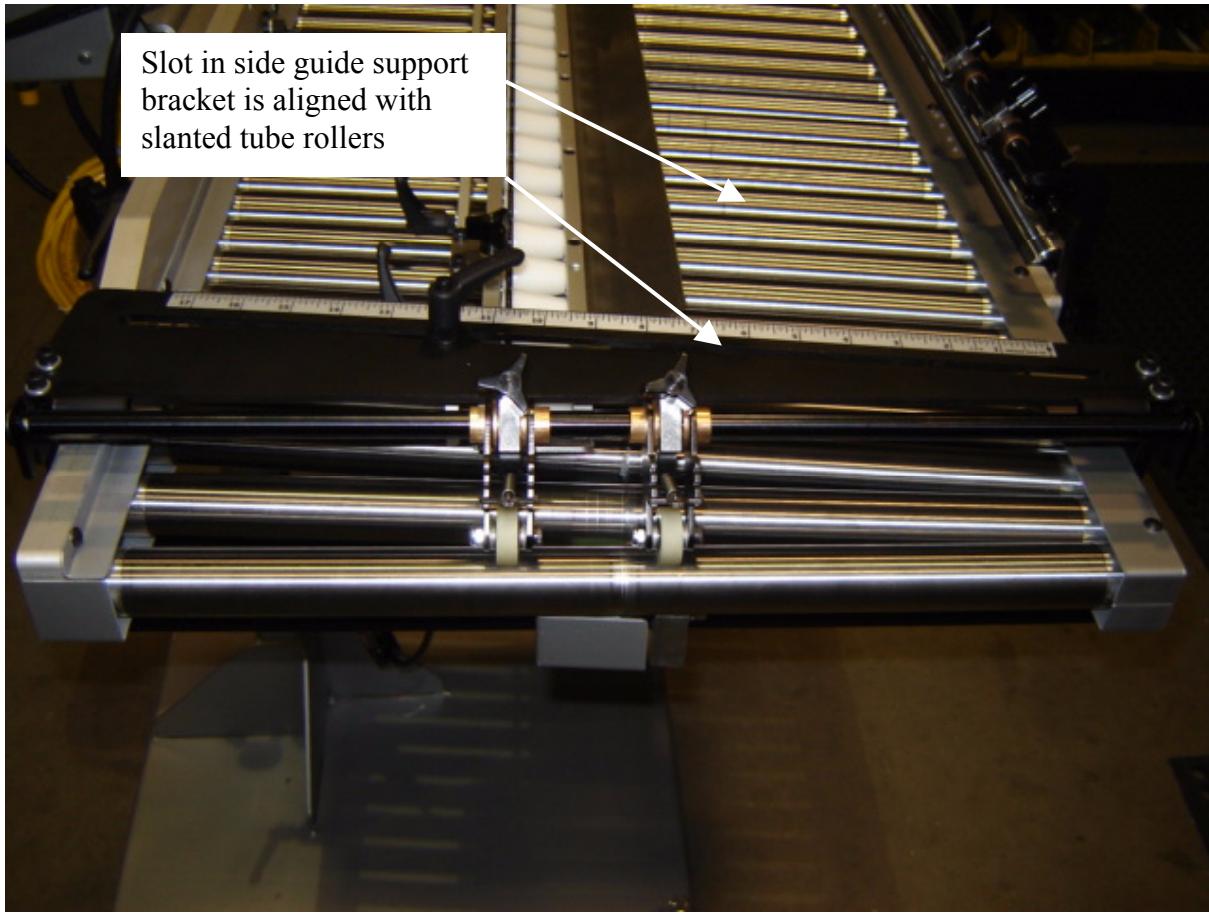


Loosen these
cap screws
for
repositioning.

Leave these
cap screws
alone.

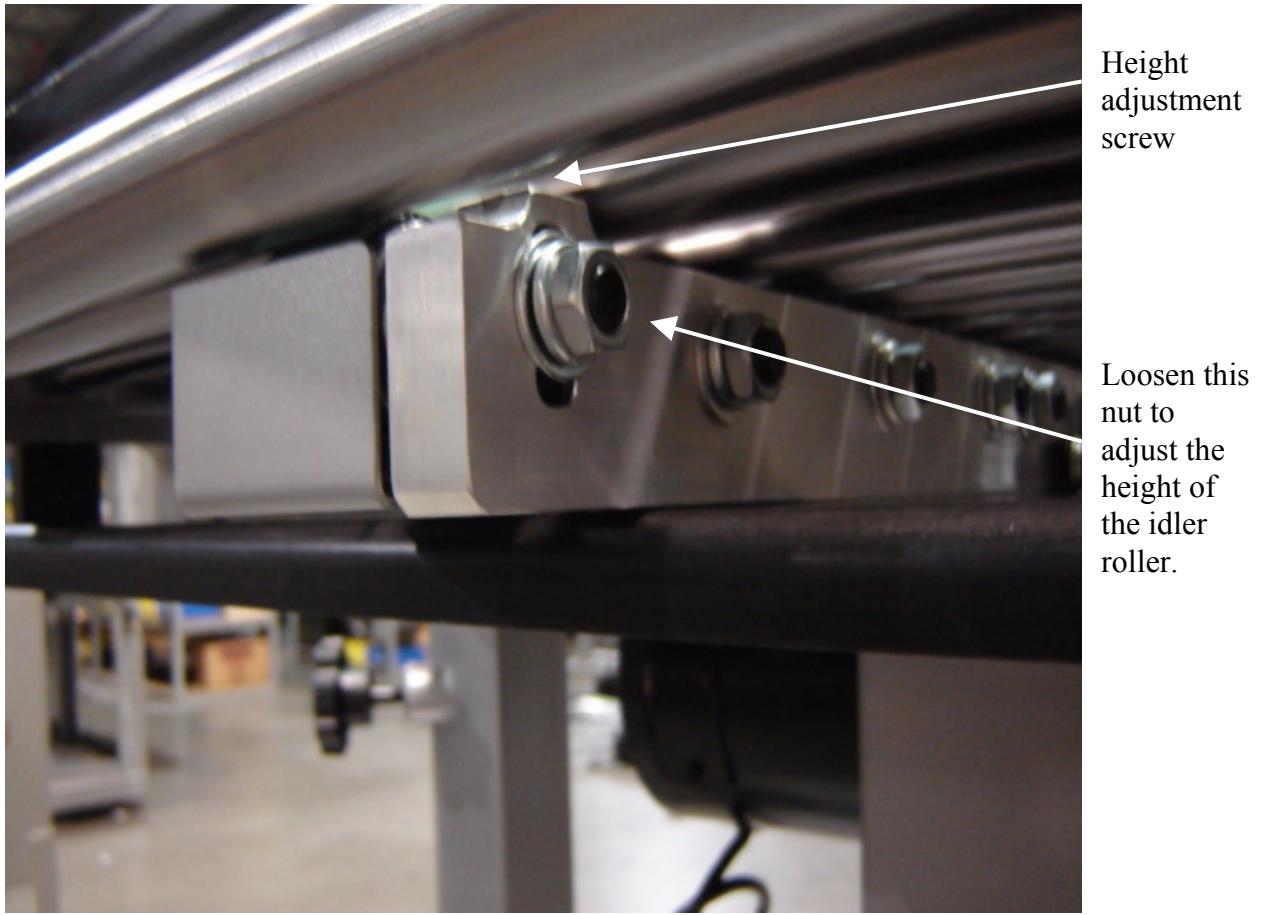
Picture 10 – Pictured above is the right end of the motor mount assembly. Only the top cap screws are loosened to change directions and then retightened after the left end has been repositioned so that the cap screws are at the other end of the slots.

12. Remove the tilt adjustment knobs (see **Figure 2.0**), turn the tube roller conveyor over, reinsert the tilt adjustment knobs and tighten.
13. Reinstall the side guide support brackets by turning the brackets over so that the slot is in alignment with the tube rollers. **Note: On earlier models, the side guide support brackets cannot be turned over and the unit is shipped with two sets of side guide support brackets, a set for left to right flow and a set for right to left flow.**



Picture 11 – Guide support bracket and pinch roller assembly.

14. Reinstall the skid bar assembly (see **Picture 3**).
15. Reinstall the pinch roller assemblies (see **Figure 2.0**)
16. Switch the main motor forward/reverse switch (see **Figure 1**) so that the top of the switch is turned in the direction of the arrows on the back tube roller cover (see **Picture 2**).
17. Reinstall the speed up roller assembly (see **Picture 6**).
18. Plug up the main motor, the speed up motor, and then the machine (see **Picture 1**).
19. Press the power button and the start button (see **Figure 3.0**) to run the machine. Test the machine and check the tension of the roller belt drive against the end rollers. The end rollers should spin with the machine is running and stop when light hand pressure is applied. Too much belt pressure on the end roller will cause excessive belt wear. Adjust the height of the end belt rollers (see **Picture 11**) if necessary.



Picture 12 – You should be able to stop the end rollers with light hand pressure. Loosening the nut and turning the screw that goes through the middle of the stud can adjust the height of the end idler roller assembly.

20. Proceed with make ready instructions.

7 TROUBLE SHOOTING

Problem	Solution
Product skew when the product is being fed from in from the side.	<p>Increase or decrease the speed of the speed up roller when the product is running.</p> <p>Make sure both pinch rollers have equal pressure on the product.</p>
Product jam when the product is being fed in from the side.	<p>Increase the speed of the angled rollers.</p> <p>Slow the speed of the speed up roller.</p> <p>Increase the spacing between products entering the conveyor.</p>
Product doesn't make it all the way under the cone rollers when product is being fed in from the side.	<p>Light product may have a difficult time driving under the cone rollers.</p> <p>Adjust the height of the roller rollers so that just the rollers that contact the product as it is cross-fed doesn't spin or use the roller ball skid bar.</p>
Product bounces back and cannot register when product is being fed in from the side.	<p>Slow the speed of the speed up roller.</p> <p>Lower the skid bar.</p> <p>On heavy product use the optional cone skid bar.</p> <p>Adjust the skid bar to be further away from the product.</p>
Product stalls and doesn't drive through.	<p>Lower the skid bar.</p> <p>Make sure the product guide is as close as possible (.020 - .030) to the angled rollers.</p>
Product fly's over the product guide on the skid bar when being fed in from the side.	<p>Adjust the tangent position of the speed up roller pinch rollers.</p> <p>Speed up the angled rollers.</p>
Loud screeching noises are coming from the rollers.	<p>Raise the product guide off of the angled rollers.</p>
Some rollers aren't turning.	<p>Make sure the main drive belt is tight enough to drive the rollers.</p>
Product is skewing as it leaves the conveyor	<p>Lower the product guide to be closer to the angled rollers (Not lower than .02-.03 above the rollers.).</p> <p>Make sure even pressure is on both pinch rollers.</p>
The conveyor will not run.	<p>Make sure the machine is plugged in.</p> <p>Turn the power button on.</p> <p>If equipped with a stop in make sure that the cable is connected or a jumper is used.</p> <p>Check stop condition of upstream</p>

	<p>equipment.</p> <p>Check the fuses.</p> <p>Make sure the speed knob is set above zero.</p> <p>Check to make sure the drive belt is operative.</p>
--	---

8 MAINTENANCE



WARNING

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

8.1 MONTHLY MAINTENANCE

Maintenance to be performed monthly		
Item	Function	Remarks
Base (General)	Remove excessive paper dust, ink, glue, and all other foreign materials from the base.	Use clean soft rag. (Dampen with water if necessary.)
Flat Drive Belt	Clean or replace.	Use clean soft rag soaked in water. Do not use solvents to clean belts.
Timing Belt Drive	Check condition of timing belt.	Replace if worn.

9 PARTS LISTS AND DIAGRAMS

9.1 PARTS LIST

See following pages for parts list.

9.2 DIAGRAMS

NO	DRAWING #	DESCRIPTION
1	KR730F	ASSY, ROLLER REGISTER
2	547338-09	ASSY, BASE
3	554036-02	ASSY, OPTIONAL FLOOR JACK
4	554062-01	ASSY, GAS SHOCK
5	548886-10	ASSY, CONTROL BOX
6	554037-06	ASSY, ROLLER REGISTER
7	554058-01	ASSY, PINCH ROLLER ARM
8	554100-04	ASSY, 225 PINCH ROLLER ARM
9	554055-03	ASSY, SKID BAR
10	554148-01	ASSY, LH SKID BAR MOUNT
11	554149-01	ASSY, RH SKID BAR MOUNT
12	554152-08	ASSY, ROLLER DRIVE
13	554156-02	ASSY, TAKE UP ROLLER
14	554155-06	ASSY, ROLLER IDLER
15	554155-05	ASSY, ROLLER IDLER
16	554042-15	ASSY, TUBE ROLLER
17	554042-16	ASSY, TUBE ROLLER
18	554070-02	ASSY, SPEED UP ROLLER
19	554042-20	ASSY, TUBE ROLLER
20	554042-21	ASSY, TUBE ROLLER
21	554058-01	ASSY, PINCH ROLLER ARM
22	554100-04	ASSY, 225 PINCH ROLLER ARM

DRAWING #		REF NO		DATE	DESCRIPTION	ECN NO	BY
					KR 730F		
ITEM #	PART #	DESCRIPTION					
1	1	541338-09 ASSY, BASE					
2	1	554037-06 ASSY, ROLLER REGISTER					
3	1	554010-02 ASSY, SPEED UP ROLLER					

KR KIRK-RUDY, INC.
WOODSTOCK, GEORGIA

ITEM #		NAME	SIZE	DIMENSION TO BE REFERRED UNLESS OTHERWISE NOTED		MATERIAL	THICKNESS PROJECTION	NOTES	
A	KEY	0 .250	INCH	MM	MM	N/A	N/A	1	1
CHECKED BY:									
DRAFTED BY:									

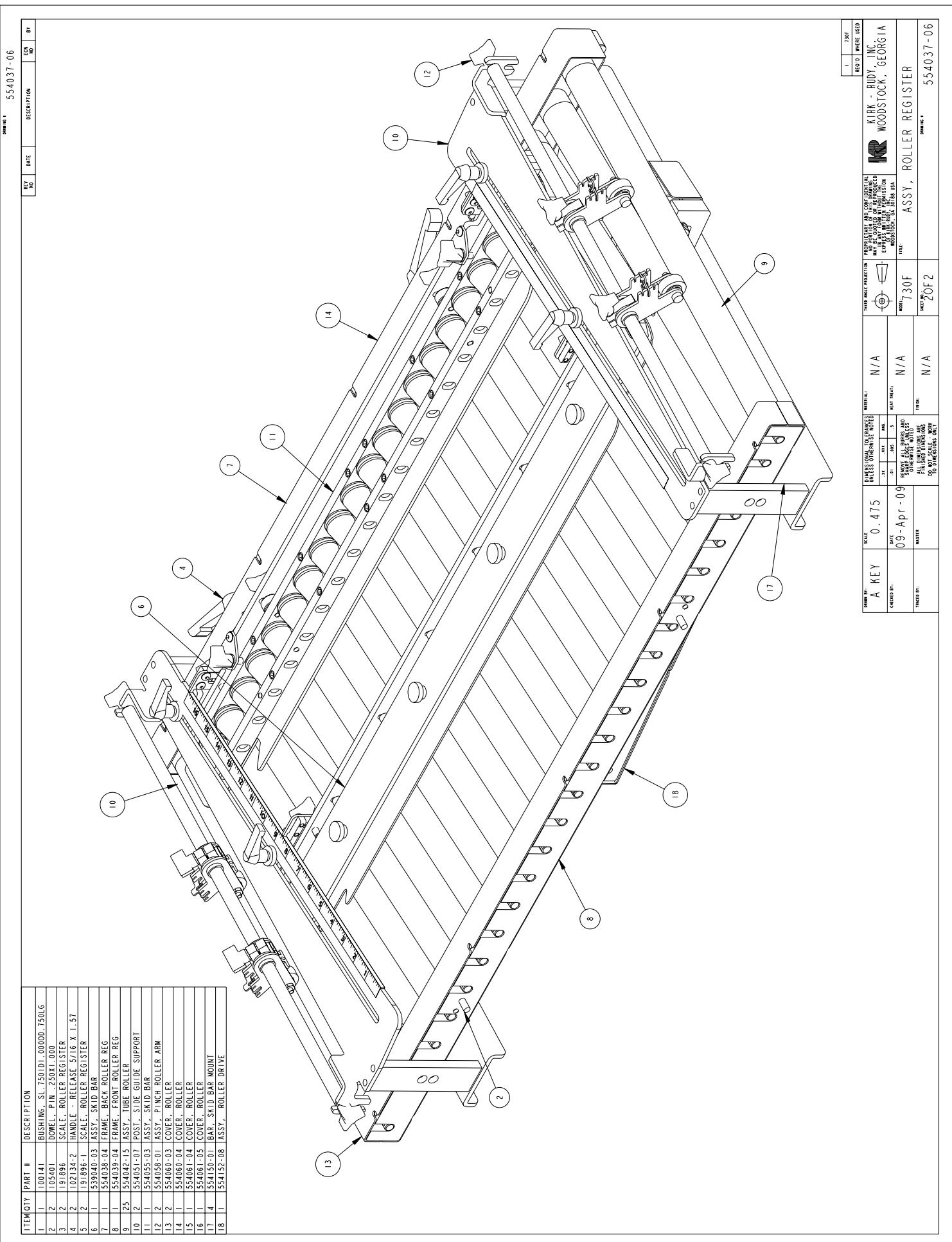
1 1/2" 13MF
45° D WIRE 0510

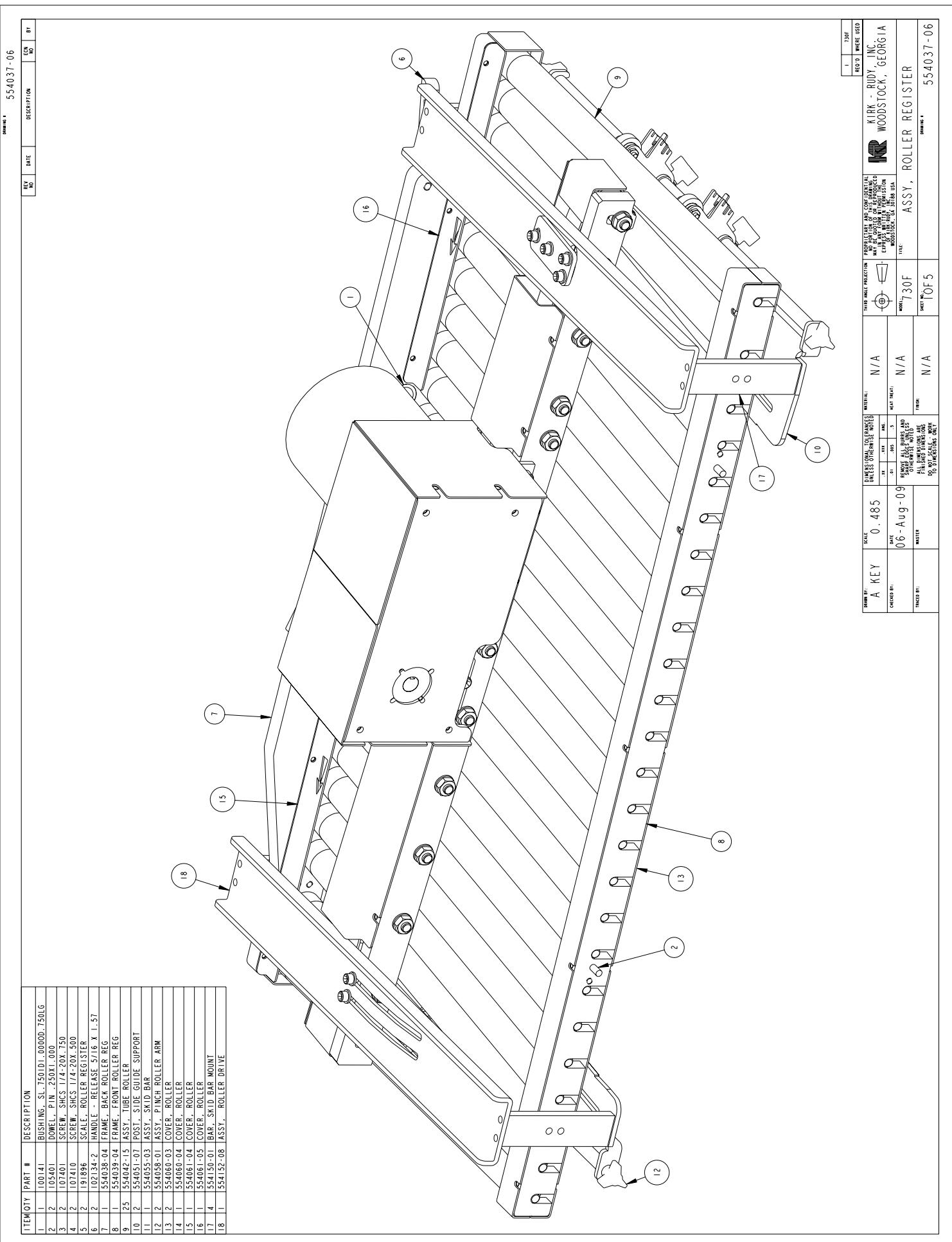
DRAWING #		REF NO		DATE	DESCRIPTION	ECN NO	BY
					KR 730F		
ITEM #	PART #	DESCRIPTION					
1	1	ROLLER REGISTER					

KIRK-RUDY, INC.
WOODSTOCK, GEORGIA

ITEM #		NAME	SIZE	DIMENSION TO BE REFERRED UNLESS OTHERWISE NOTED		MATERIAL	THICKNESS PROJECTION	NOTES	
A	KEY	0 .250	INCH	MM	MM	N/A	N/A	1	1
CHECKED BY:									
DRAFTED BY:									

1 1/2" 13MF
45° D WIRE 0510





ITEM NO	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	6 100803	WASHER, FLAT 1/4ID					
2	2 102144	KNOB, 3 ARM, 1/4-20 X 1" STUD					
3	6 102145	KNOB, HAND 3 PRONG 1/4-20 STUD					
4	8 106813	SCREW, BUTTON HEAD #10-32X.375					
5	16 107429	SCREW, SHCS 10-32X.625					
6	21 191895-2	O-RING					
7	1 539057-08	GUIDE, SKID BAR					
8	1 554054-03	GUIDE, PRODUCT					
9	1 554055-03	ASSY, SKID BAR					
10	21 554056-02	CONC. REGISTRATION					
11	2 554125-01	PLATE, SKIDBAR MOUNT					
12	2 554129-01	BRACKET, SKID BAR MOUNT					
13	1 554148-01	ASSY, LH SKID BAR MOUNT					
14	1 554149-01	ASSY, RH SKID BAR MOUNT					
15	2 554193-01	BAR, CONE ROLLER MOUNT					
16	2 554194-01	BRACKET, ADJUSTMENT					
17	2 554195-01	SPACER, SIDEGUIDE					
18	2 SP6383-4	WASHER, 1/4					

1 730F
REO D WHERE USED

KRK KIRK - RUDY, INC.
WOODSTOCK, GEORGIA

ASSY, SKID BAR

DRAWING # 554055-03

1 730F
REO D WHERE USED

KRK KIRK - RUDY, INC.
WOODSTOCK, GEORGIA

ASSY, SKID BAR

DRAWING # 554055-03

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KRK KIRK - RUDY, INC.
WOODSTOCK, GEORGIA

ASSY, SKID BAR

DRAWING # 554055-03

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WOODSTOCK, GEORGIA

ASSY, SKID BAR

DRAWING # 554055-03

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WOODSTOCK, GEORGIA

ASSY, SKID BAR

DRAWING # 554055-03

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WOODSTOCK, GEORGIA

ASSY, SKID BAR

DRAWING # 554055-03

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WOODSTOCK, GEORGIA

ASSY, SKID BAR

DRAWING # 554055-03

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WOODSTOCK, GEORGIA

ASSY, SKID BAR

DRAWING # 554055-03

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KRK KIRK - RUDY, INC.
WOODSTOCK, GEORGIA

ASSY, SKID BAR

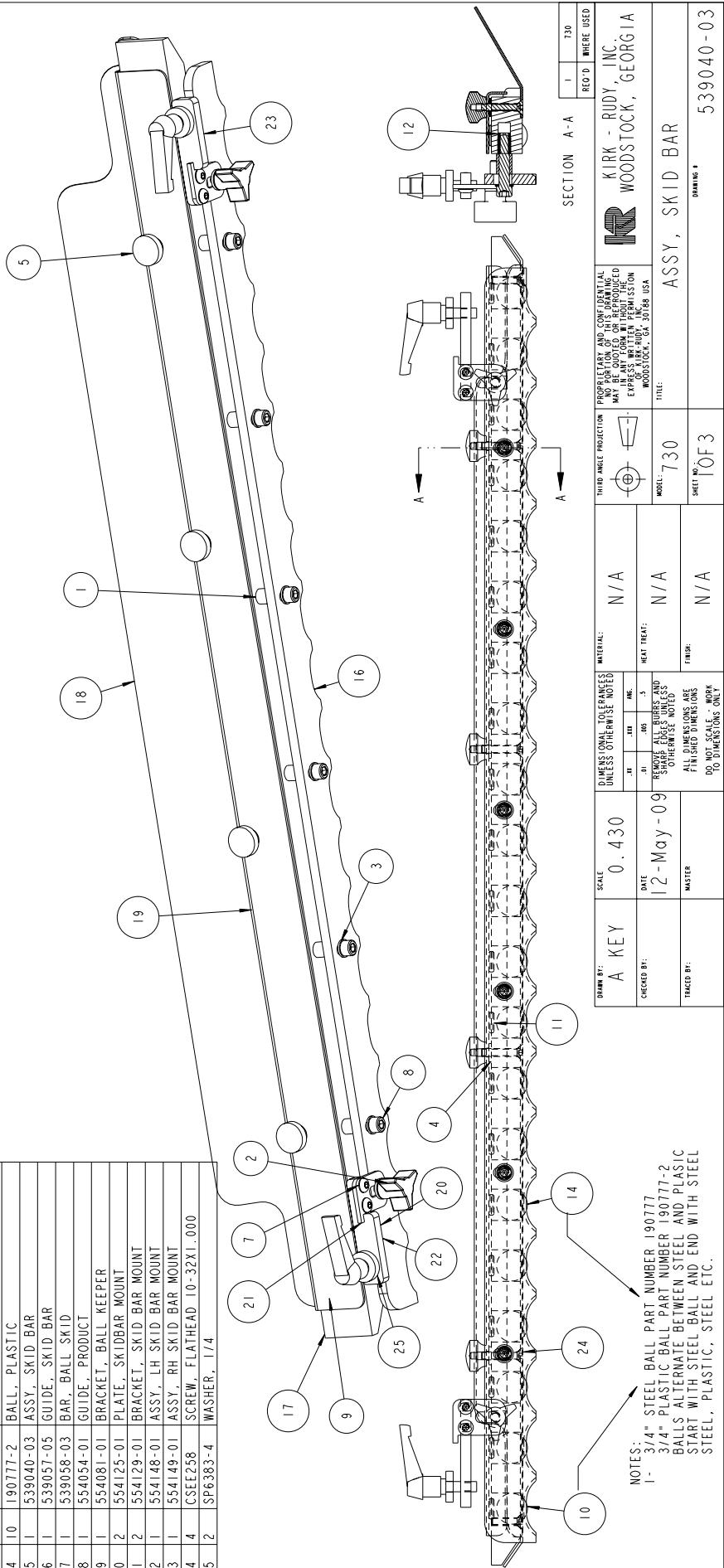
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1 730F
REO D WHERE USED

KRK KIRK - RUDY, INC.
WOODSTOCK, GEORGIA

ASSY, SKID BAR

REV NO	DATE	DESCRIPTION	ECN NO	BY
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NOTES: → → →
 - 3/4" STEEL BALL PART NUMBER 190777
 - 3/4" PLASTIC BALL PART NUMBER 190777-2
 BALLS ALTERNATE BETWEEN STEEL AND PLASTIC
 START WITH STEEL BALL AND END WITH STEEL
 PLASTIC, STEEL, ETC.

NOTES 3

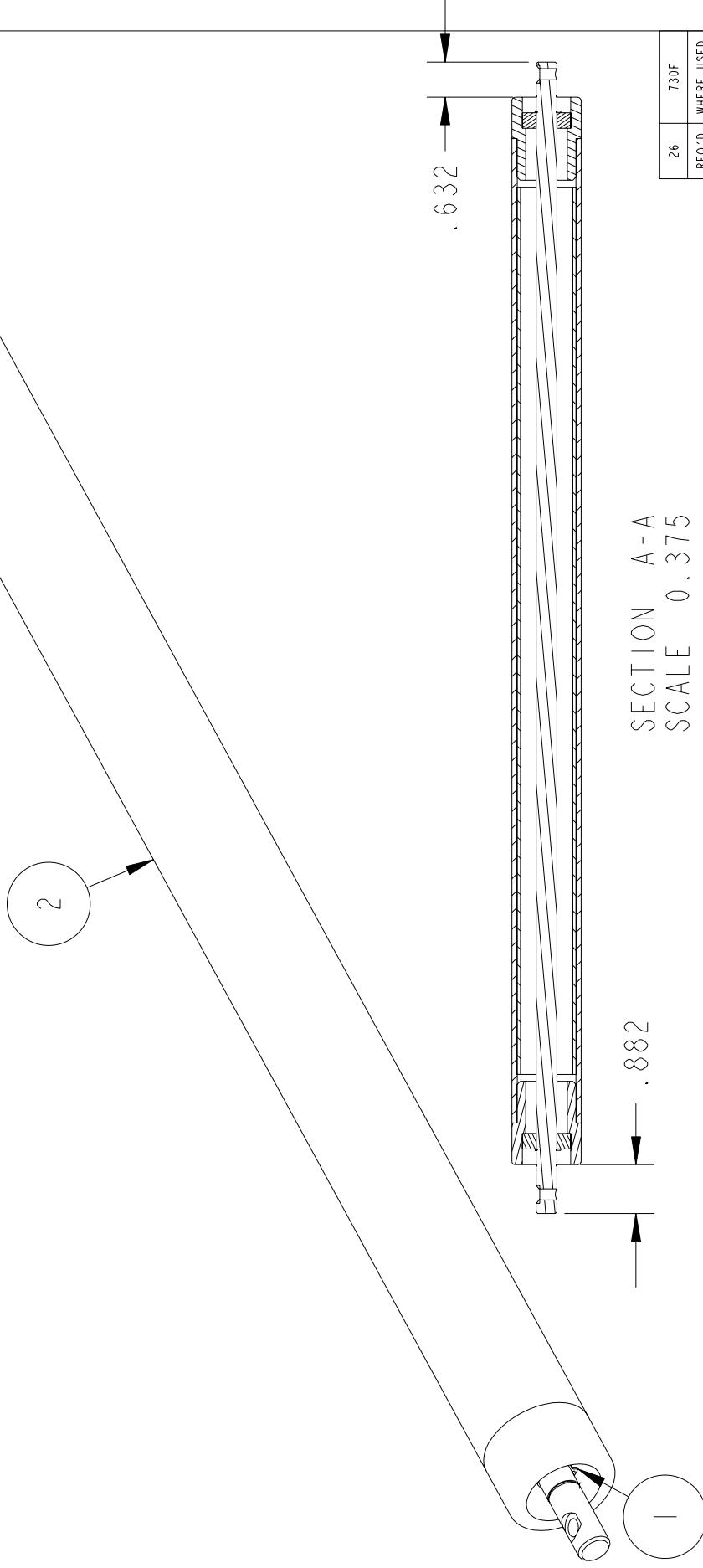
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REF'D	WHERE USED	
KIRK - RUDY, INC.		
WOODSTOCK, GEORGIA		
PROPRIETARY AND CONFIDENTIAL		
MANUFACTURED OR REPRODUCED		
IN ANY FORM WITHOUT THE		
EXPRESS WRITTEN PERMISSION		
OF THE OWNER		
WOODSTOCK, GA 30188 USA		
MATERIAL:		
DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED		
SCALE A KEY	0 .430	N/A
DATE 12-May-09	.065 .5	HEAT TREAT:
CHECKED BY: TRACED BY:	N/A	
MASTER	FINISH: N/A	
DO NOT SCALE, DRAW, OR ALTER DIMENSIONS		
ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE INDICATED		
REMOTE ALL BURRS AND OTHER SURFACE IRREGULARITIES		
FINISH SURFACES ARE AS SHOWN		
N/A		
ASSY, SKID BAR		
SHEET NO. 1 OF 3		
DRAWN BY:		

ITEM	QTY	PART #	DESCRIPTION
1	2	104100	SNAPRING, .375
2	1	554042-16	ASSY, TUBE ROLLER
3	1	554044-02	SHAFT, TUBE ROLLER

REV NO	DATE	DESCRIPTION	ECN NO	BY

2

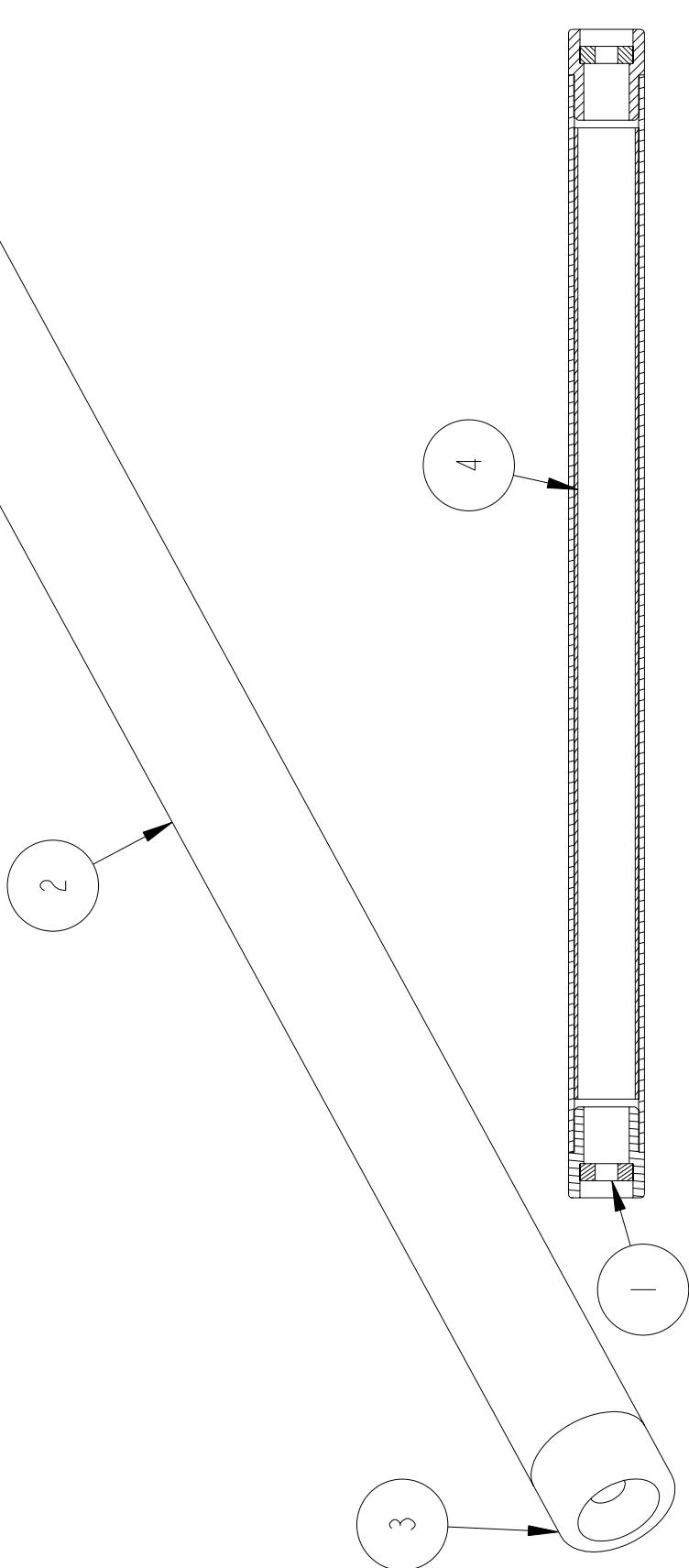
3



DRAWN BY:	A K E Y	SCALE	MATERIAL: N/A	THIRD ANGLE PROJECTION	PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE QUOTED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC. WOODSTOCK, GA 30188 USA
CHECKED BY:		DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	.XX .XXX ANG.	MODEL: 730F	KIRK - RUDY, INC. WOODSTOCK, GEORGIA
TRACED BY:		DATE: 06-Aug-09	.01 .005 .5	FINISH: N/A	TITLE: ASSY, TUBE ROLLER
	MASTER	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY		SHEET NO.: OFF	DRAWING #: 554042-15

ITEM	QTY	PART #	DESCRIPTION
1	2	103106	BEARING, FLAT .375
2	1	554041-02	TUBE, ROLLER
3	2	554043-01	HUB, TUBE ROLLER IDLER
4	1	554122-01	CORE, SOUND DEADENING

REV NO	DATE	DESCRIPTION	ECN NO	BY



SECTION A-A
SCALE 0.375

26 730F
REQ'D WHERE USED

26 730F

REQ'D WHERE USED



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IN ANY FORM WITHOUT THE
EXPRESS WRITTEN PERMISSION
OF KIRK-RUDY, INC.
WOODSTOCK, GA 30188 USA

KIRK - RUDY, INC.
WOODSTOCK, GEORGIA

MODEL: 730F

TITLE: ASSY, TUBE ROLLER

SHEET NO.: OFF 1

DRAWING #

554042-16

DRAWN BY: A KERY SCALE 0.625

DIMENSIONAL TOLERANCES
UNLESS OTHERWISE NOTED

.00 .000 ANG.

.01 .005 .5 HEAT TREAT:

N/A

REMOVE ALL BURRS AND
SHARP EDGES UNLESS
OTHERWISE NOTED

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

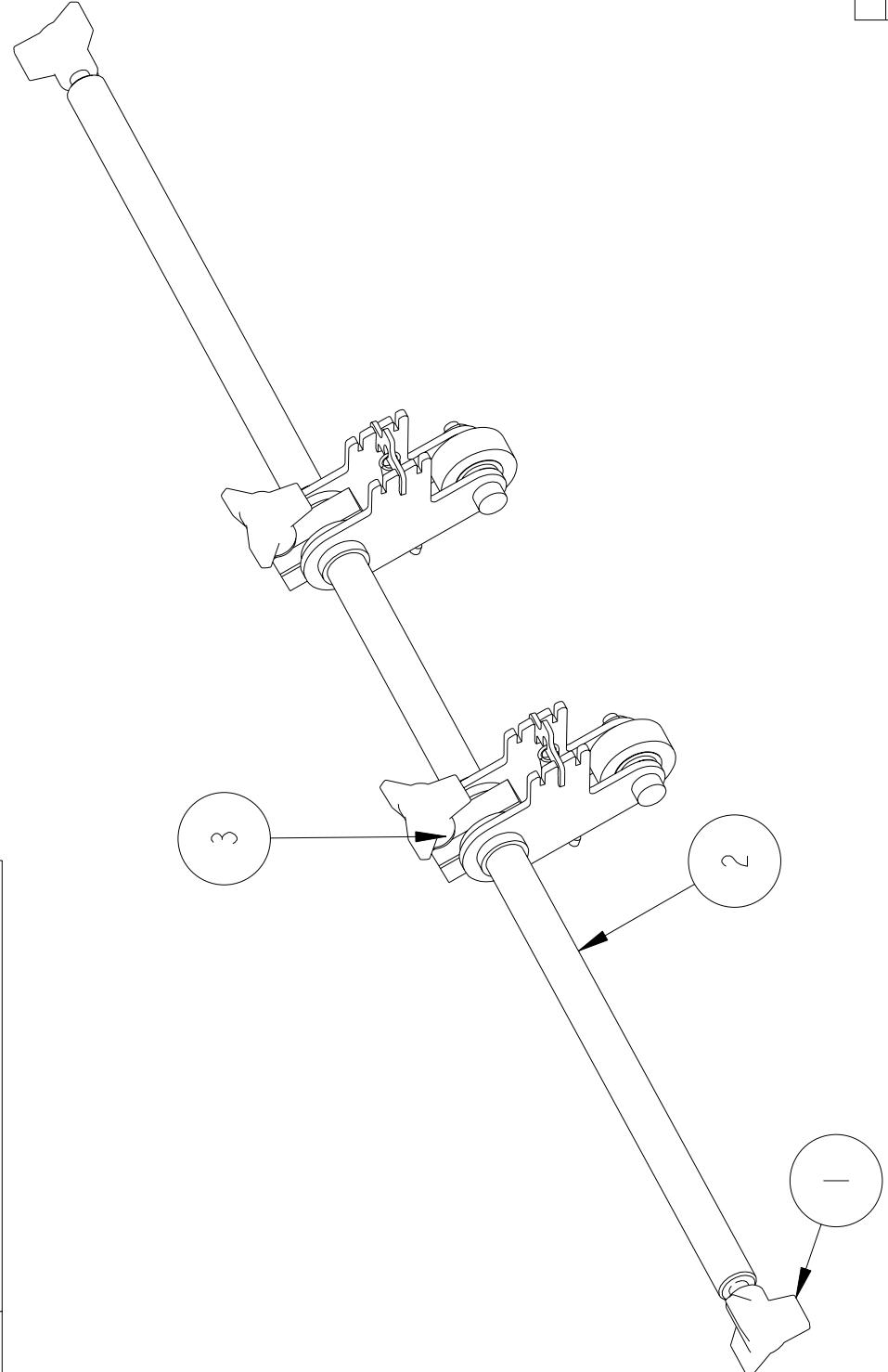
TRACED BY: MASTER

DATE: 06-Aug-09

DRAWING # 554058 - 01

ITEM	QTY	PART #	DESCRIPTION
1	2	102145	KNOB, HAND 3 PRONG 1/4-20 STUD
2	1	554052-01	SHAFT, SIDE GUIDE MOUNT
3	2	554100-04	ASSY, 2.25 PINCH ROLLER ARM

REV NO	DATE	DESCRIPTION	ECN NO	BY



2	730F
REQ'D	WHERE USED

PROPRIETARY AND CONFIDENTIAL
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EXPRESS WRITTEN PERMISSION
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WOODSTOCK, GA 30188 USA

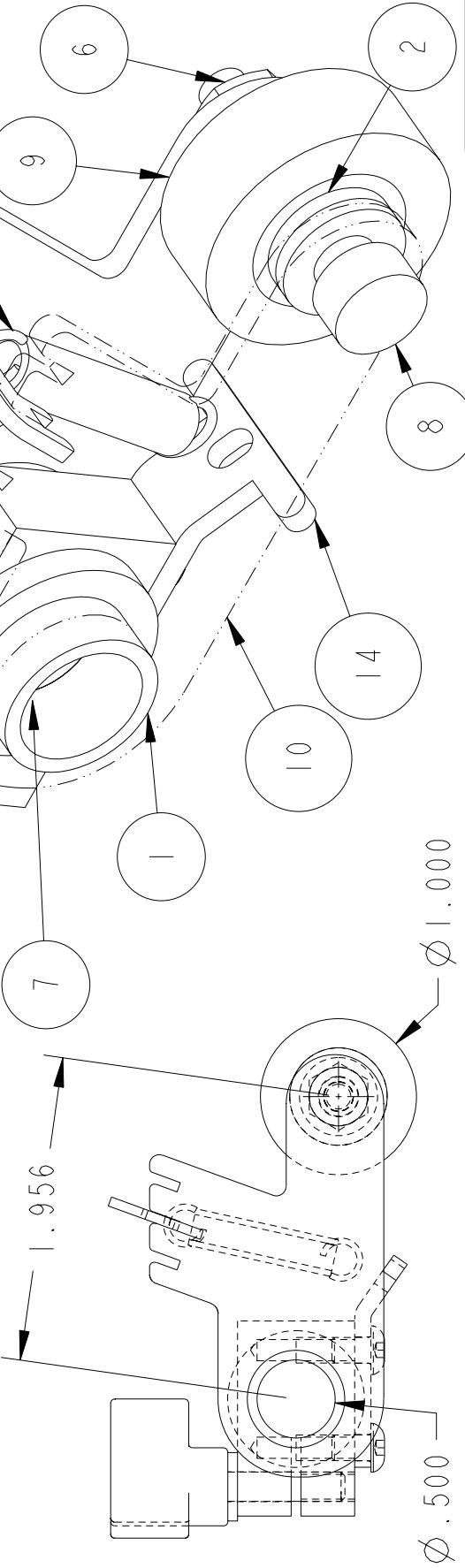
KIRK - RUDY, INC.
WOODSTOCK, GEORGIA

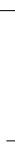
THIRD ANGLE PROJECTION	
MODEL: 730F	TITLE: ASSY, PINCH ROLLER ARM

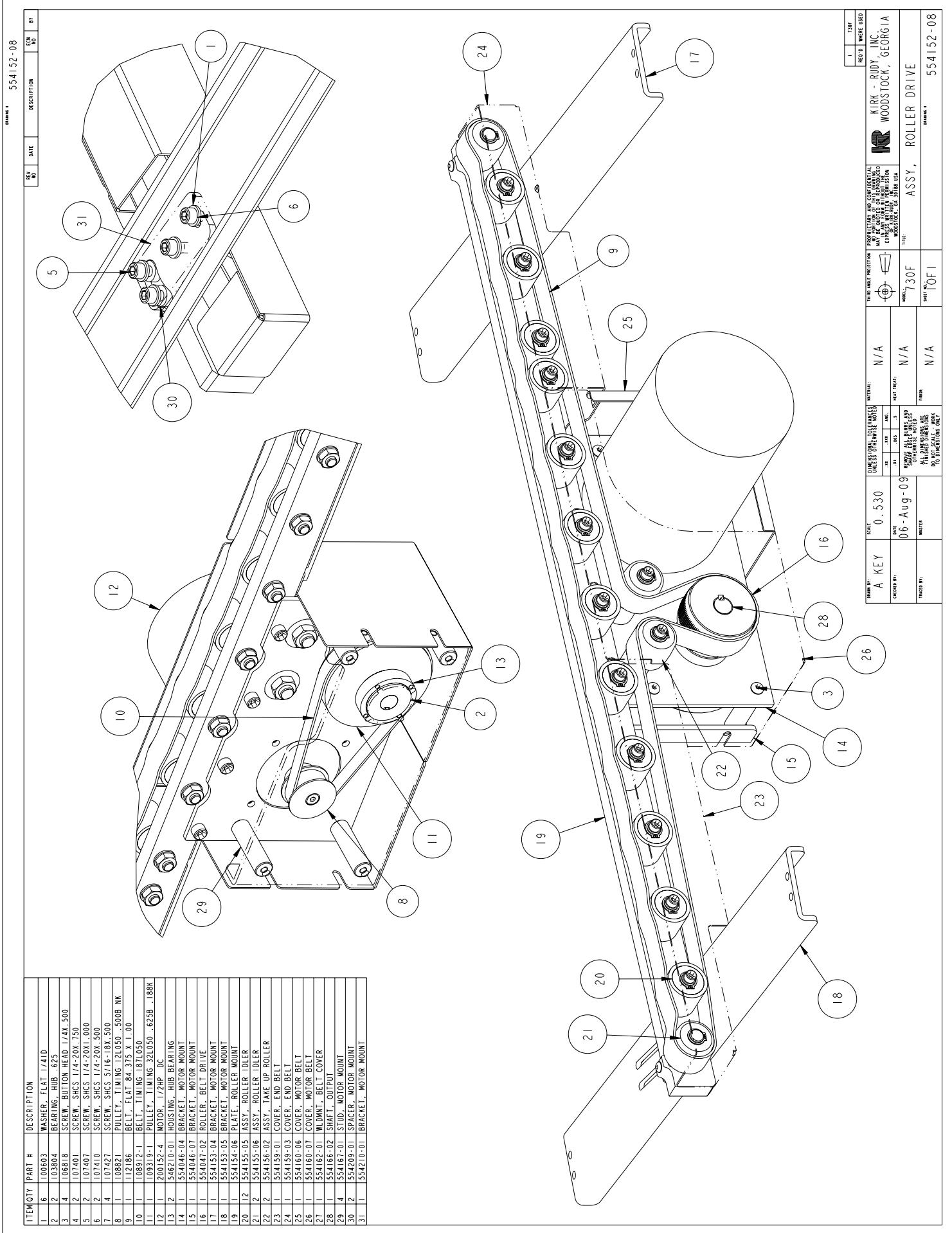
SHEET NO.: 0F | DRAWING # 554058 - 01

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DATE: 09 - Apr - 09	.XX .XXX ANG. .01 .005 .5	HEAT TREAT: N / A	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED
CHECKED BY: MASTER	ALL DIMENSIONS ARE FINISHED TO WORK DIMENSIONS ONLY	FINISH: N / A	ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY
TRACED BY: MASTER			

ITEM	QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	2	100323	BUSHING, FL. 5001D. 6250D. 375LG					
2	4	100603	WASHER, FLAT 1/4ID					
3	1	100619	WASHER, FLAT 10-32					
4	1	102158	KNOB, HAND 3 PRONG 10-32 X .75 STUD					
5	1	102762	SPRING, EXTENSION					
6	1	106709	NUT, HEX #10-24					
7	2	106819	SCREW, BUTTON HEAD #8-32X.250					
8	1	107005	BOLT, SHOULDER 1/4X3/4					
9	1	501057-A	ASSY, ROLLER					
10	1	554096-05	ARM, PINCH ROLLER					
11	1	554096-06	ARM, PINCH ROLLER					
12	1	554099-03	BRACKET, SPRING ANCHOR					
13	1	554101-02	BLOCK, 1" DIA CLAMP					
14	1	554102-02	BRACKET, ARM STOP					

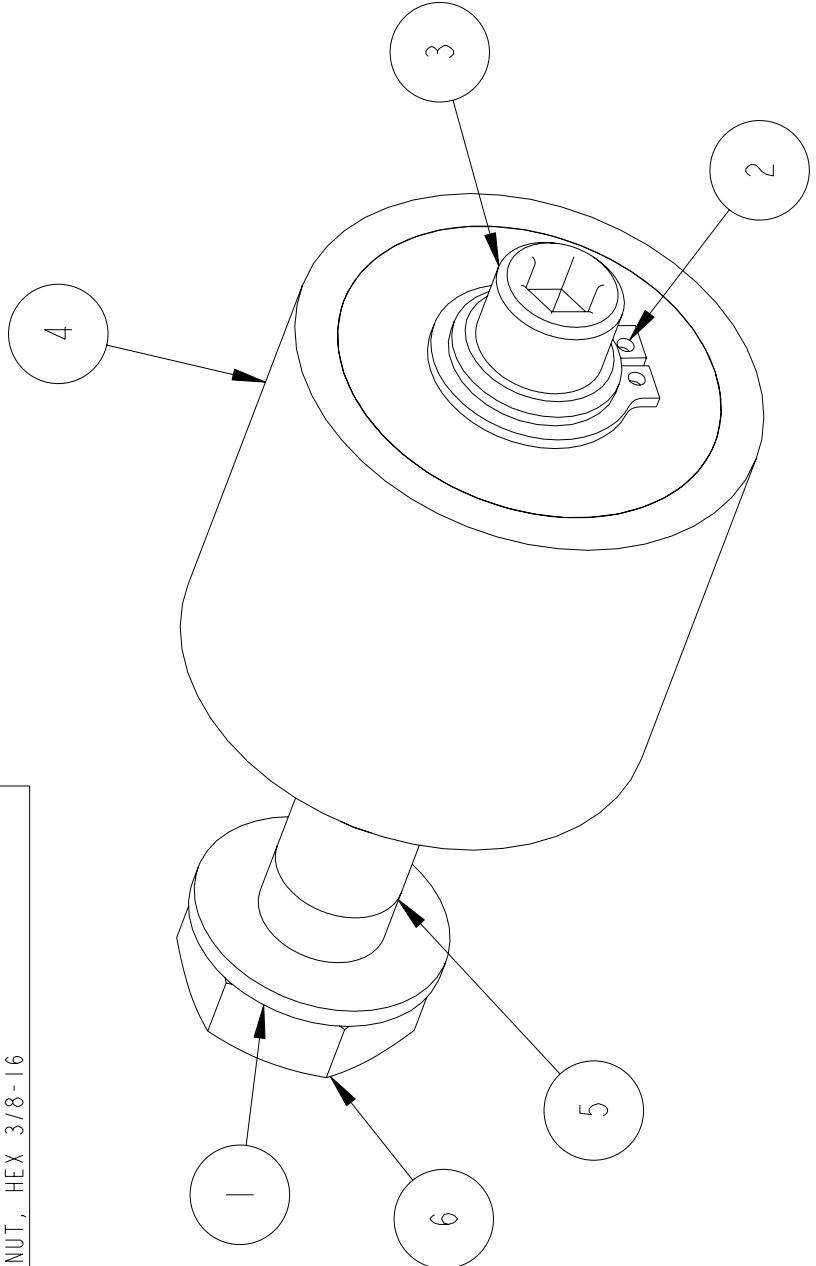


DRAWN BY:	A KEY	SCALE	.750	MATERIAL: N/A	THIRD ANGLE PROJECTION 	PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE QUOTED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY INC. WOODSTOCK, GA 30188 USA	REQ'D	WHERE USED
CHECKED BY:		DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	.XX .XXX .005 .5	HEAT TREAT:				
DATE	12-Jun-09	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED			MODEL: 730	TITLE: ASSY , 2.25 PINCH ROLLER ARM		
TRACED BY:	MASTER	ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DRAWING SIZE ONLY		N/A	SHEET NO.: 0F	DRAWING #: 554100-04		
SCALE 1.000								



DRAWING # 554155-05

ITEM	QTY	PART #	DESCRIPTION
1	1	100402	WASHER, THRUST TB612
2	1	104106	SNAPRING, .500
3	1	107410	SCREW, SHCS 1/4-20X .500
4	1	516045-10A	ASSY, FLAT BELT IDLER
5	1	554157-02	STUD-IDLER SPROCKET
6	1	HMSN14	NUT, HEX 3/8-16



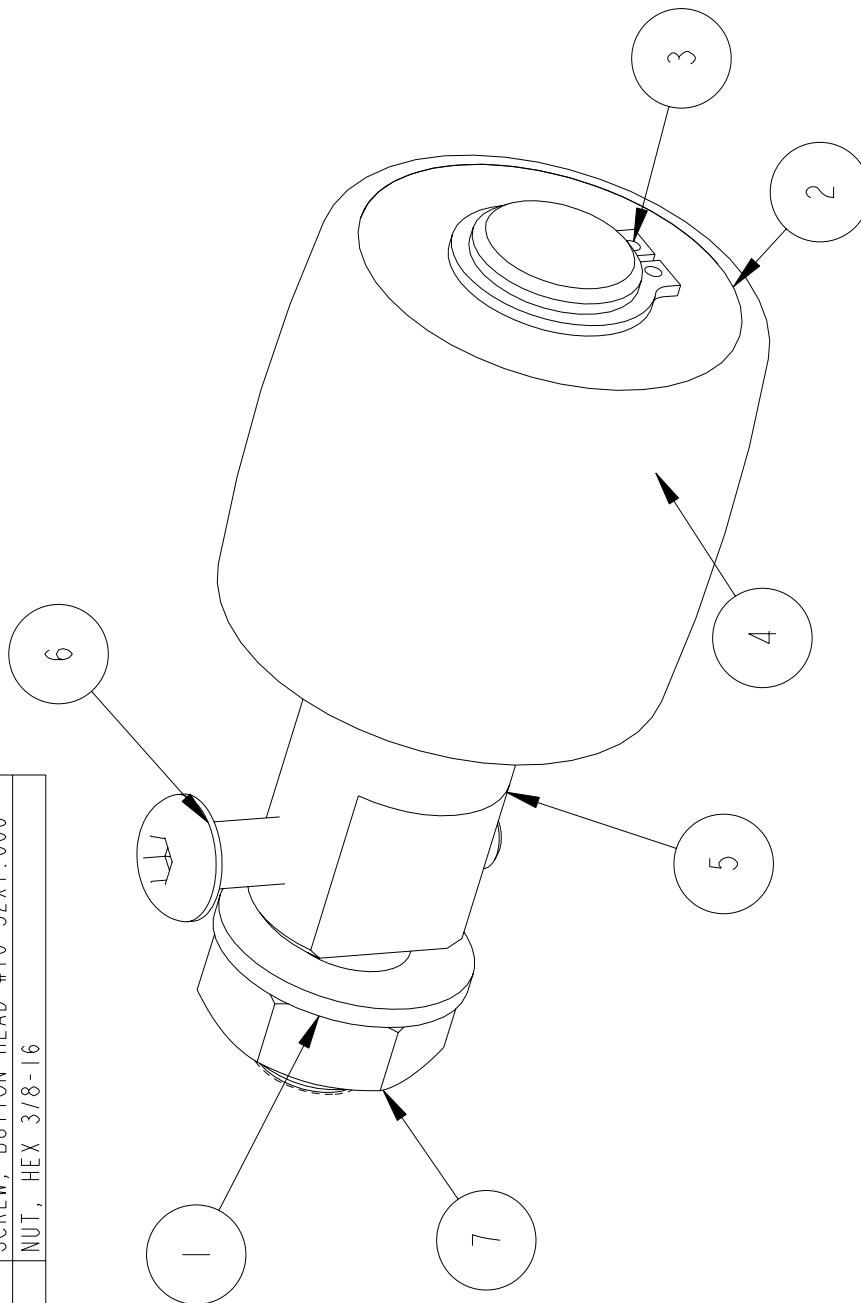
REV NO	DATE	DESCRIPTION	ECN NO	BY

12	730
REQ'D	WHERE USED

PROPRIETARY AND CONFIDENTIAL
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IN ANY FORM WITHOUT THE
EXPRESS WRITTEN PERMISSION
OF KIRK RUDY, INC.
WOODSTOCK, GA 30188 USA

DRAWN BY: A K E Y	SCALE 2.000	MATERIAL: N/A	THIRD ANGLE PROJECTION +---+ +---+ +---+	KIRK - RUDY, INC. WOODSTOCK, GEORGIA
CHECKED BY:	DATE 9-JUN-09	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED .00 .005 .005 ANG.	HEAT TREAT: N/A	MODEL: 730 TITLE: ASSY, ROLLER IDLER
TRACED BY:	MASTER	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED ALL DIMENSIONS ARE FINISHED DO NOT SCALE - WORK TO DIMENSIONS ONLY	FINISH: N/A	SHEET NO.: OFF DRAWING #: 554155-05

ITEM	QTY	PART #	DESCRIPTION
1	1	100402	WASHER, THRUST TB612
2	2	103108	BEARING, FLAT .500
3	1	104106	SNAPRING, .500
4	1	554082-01	ROLLER, IDLER
5	1	554158-02	STUD-IDLER SPROCKET
6	1	CSFF62	SCREW, BUTTON HEAD #10-32X1.000
7	1	HMSN14	NUT, HEX 3/8-16



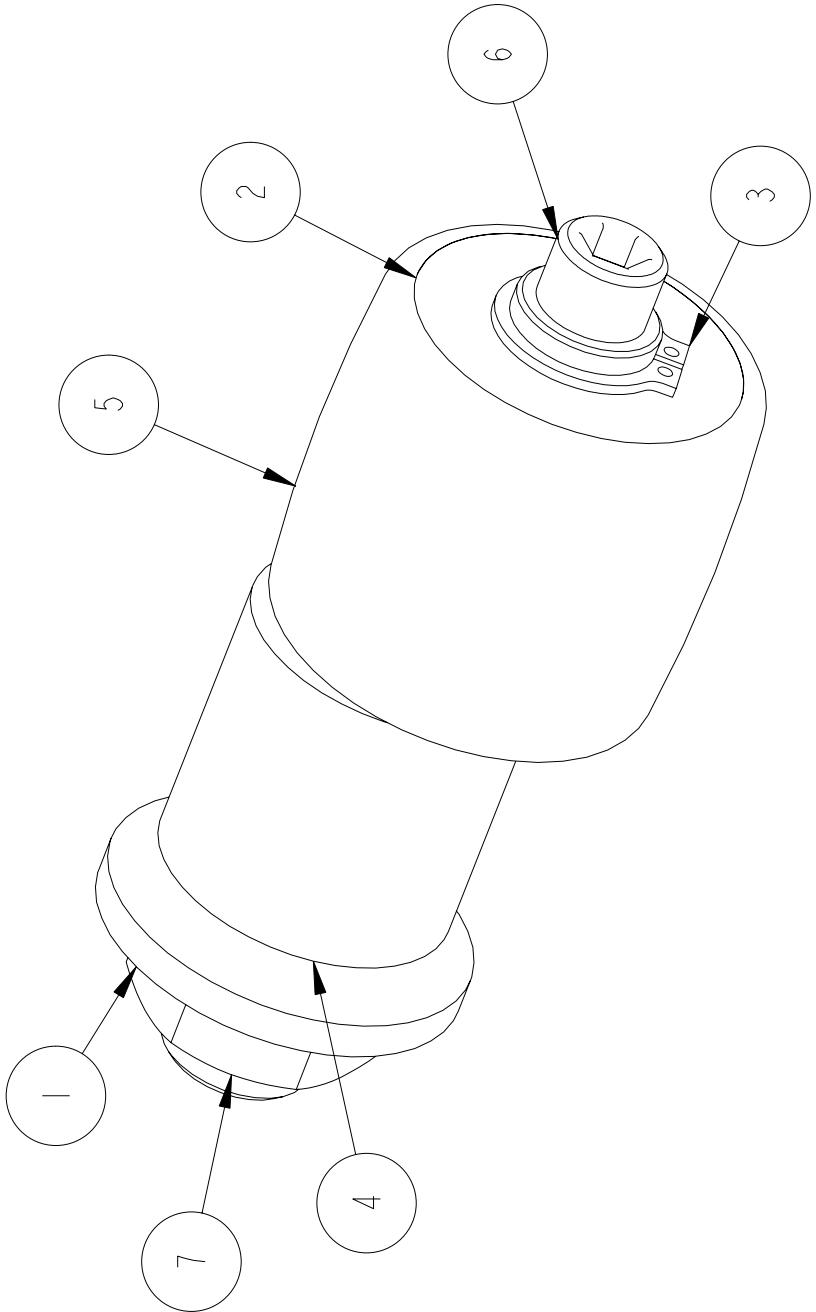
ITEM	QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	1	100402	WASHER, THRUST TB612					
2	2	103108	BEARING, FLAT .500					
3	1	104106	SNAPRING, .500					
4	1	554082-01	ROLLER, IDLER					
5	1	554158-02	STUD-IDLER SPROCKET					
6	1	CSFF62	SCREW, BUTTON HEAD #10-32X1.000					
7	1	HMSN14	NUT, HEX 3/8-16					

DRAWN BY: A K E Y	SCALE 2.000	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED		MATERIAL: N/A	THIRD ANGLE PROJECTION	PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE QUOTED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK RUDY, INC. WOODSTOCK, GA 30188 USA	
CHECKED BY:	DATE 9-JUN-09	.XX	.XXX	ANG. .01 -.005 .5	HEAT TREAT: N/A	MODEL: 730	TITLE: ASSY, ROLLER IDLER
TRACED BY:	MASTER	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED		ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY		SHEET NO.: OFF 1	DRAWING #: 554155-06

ITEM	QTY	PART #	DESCRIPTION
1	1	100618	WASHER, FLAT 1/2ID 1/8TK
2	2	103108	BEARING, FLAT .500
3	1	104106	SNAPRING, .500
4	1	500983-15	STUD, IDLER SPROCKET
5	1	554082-01	ROLER, IDLER
6	1	CSD290	SCREW, SHCS 1/4-20X.250
7	1	HJN014	NUT, JAM 1/2-13

REV NO	DATE	DESCRIPTION	ECN NO	BY

2	730
REQ'D	WHERE USED



DRAWN BY: A K E Y	SCALE 1 . 750	MATERIAL: N / A	THIRD ANGLE PROJECTION	PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE QUOTED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK RUDY, INC. WOODSTOCK, GA 30188 USA
CHECKED BY:	DATE 06 - Aug - 09	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED .00 .000 .005 .005 ANG.	HEAT TREAT: N / A	MODEL: 730
TRACED BY:	MASTER	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY	FINISH: N / A	SHEET NO.: 0F
				TITLE: ASSY , TAKE UP ROLLER DRAWING #: 554156-02

ITEM NO	PART #	DESCRIPTION	REV NO	DATE	ECN NO	BY
1	2	WASHER, FLAT 10-32				
2	2	KNOB, HAND 3 PRONG 1/4-20 X 1-25				
3	2	BEARING, FLAT .375				
4	2	SNARING, FLAT .375				
5	2	SCREW, BUTTON HEAD #10-32X .250				
6	4	SCREW, SHCS 1/4-20X .500				
7	3	SCREW, SHCS 1/4-20X .500				
8	2	SCREW, SHCS 8-32X .500				
9	2	SCREW, SHCS 10-32X .750				
10	1	LABEL, HOT SURFACE				
11	1	BOX, CONDUIT				
12	1	BELT, MULTI-V 140J-6RIB				
13	1	MOTOR, DC 1/15HP 3300 RPM				
14	1	ASSY, TUBE ROLLER				
15	1	ASSY, PINCH ROLLER ARM				
16	1	PLATE, SPEED UP ROLLER MNT				
17	1	PULLEY, MULTI-V DRIVE				
18	1	PULLEY, FLAT BELT IDLER				
19	1	BRACKET, MOTOR MOUNT				
20	1	SIUD, PULLEY IDLER				
21	1	COVER, BELT				
22	1	BRACKET, PINCH ROLLER MNT				
23	1	BRACKET, PINCH ROLLER MNT				

DRAWING #: 554070-02

REVISION #: 0

DATE: 06 - Aug - 09

ECN NO: 0

BY: KIRK - RUDY, INC.

WHERE USED: WOODSTOCK, GEORGIA

PROPRIETARY AND CONFIDENTIAL
MANUFACTURED FOR KIRK-RUDY INC.
IN ANY FORM WITHOUT THE
EXPLORATION AND EXPLOITATION
RIGHTS RESERVED IN THE
WOODSTOCK, GA 30188 USA

DRAWING #: 554070-02

SCALE: A KEY

DATE: 06 - Aug - 09

MASTER

DIMENSIONAL TOLERANCES
UNLESS OTHERWISE NOTED

	.01	.03	.06	.12
1	N/A	N/A	N/A	N/A
2	N/A	N/A	N/A	N/A
3	N/A	N/A	N/A	N/A
4	N/A	N/A	N/A	N/A
5	N/A	N/A	N/A	N/A
6	N/A	N/A	N/A	N/A
7	N/A	N/A	N/A	N/A
8	N/A	N/A	N/A	N/A
9	N/A	N/A	N/A	N/A
10	N/A	N/A	N/A	N/A
11	N/A	N/A	N/A	N/A
12	N/A	N/A	N/A	N/A
13	N/A	N/A	N/A	N/A
14	N/A	N/A	N/A	N/A
15	N/A	N/A	N/A	N/A
16	N/A	N/A	N/A	N/A
17	N/A	N/A	N/A	N/A
18	N/A	N/A	N/A	N/A
19	N/A	N/A	N/A	N/A
20	N/A	N/A	N/A	N/A

HEAT TREAT: N/A

FINISH: N/A

THIRD ANGLE PROJECTION

DRAWING #: 554070-02

REVISION #: 0

DATE: 06 - Aug - 09

MASTER

ECN NO: 0

BY: KIRK - RUDY, INC.

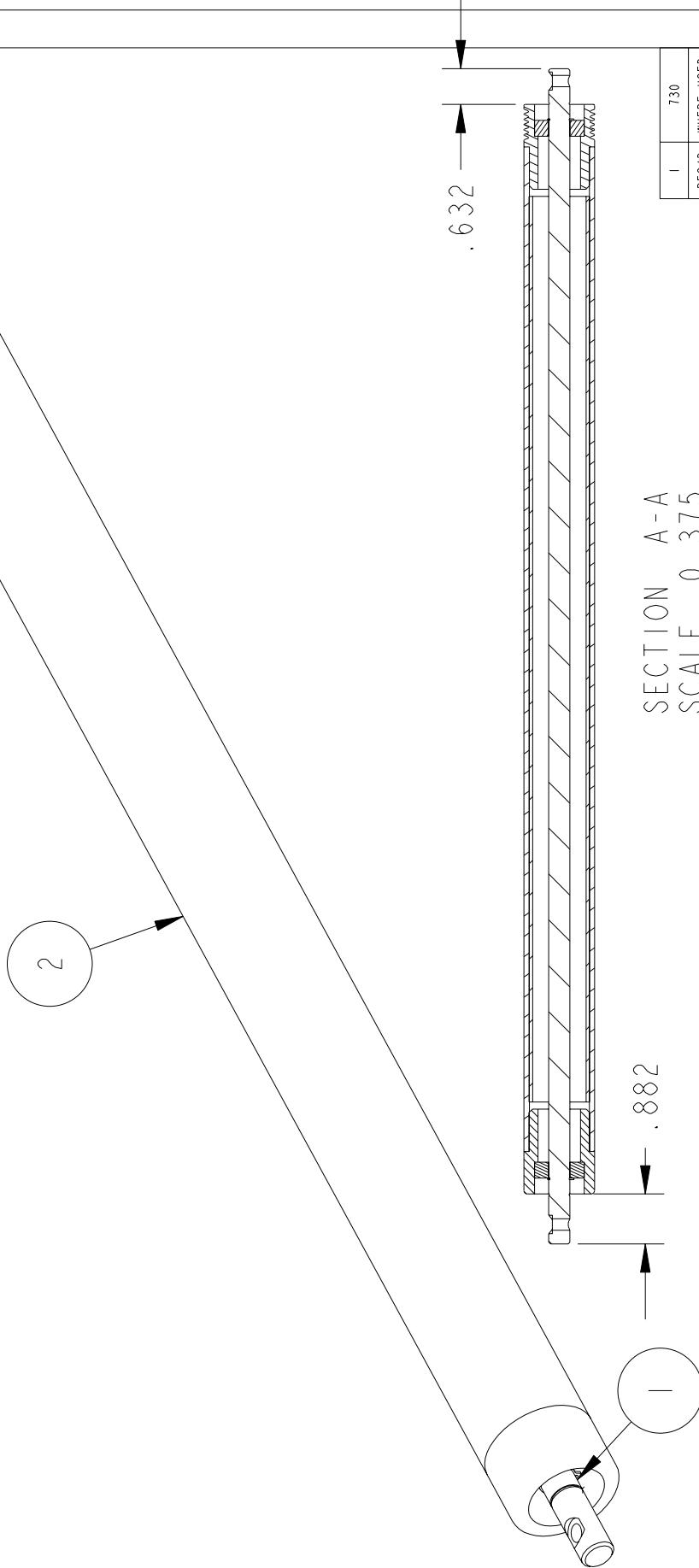
WHERE USED: WOODSTOCK, GEORGIA

PROPRIETARY AND CONFIDENTIAL
MANUFACTURED FOR KIRK-RUDY INC.
IN ANY FORM WITHOUT THE
EXPLORATION AND EXPLOITATION
RIGHTS RESERVED IN THE
WOODSTOCK, GA 30188 USA

DRAWING #: 554070-02

ITEM	QTY	PART #	DESCRIPTION
1	2	104100	SNAPRING, .375
2	1	554042-21	ASSY, TUBE ROLLER
3	1	554044-01	SHAFT, TUBE ROLLER

REV NO	DATE	DESCRIPTION	ECN NO	BY



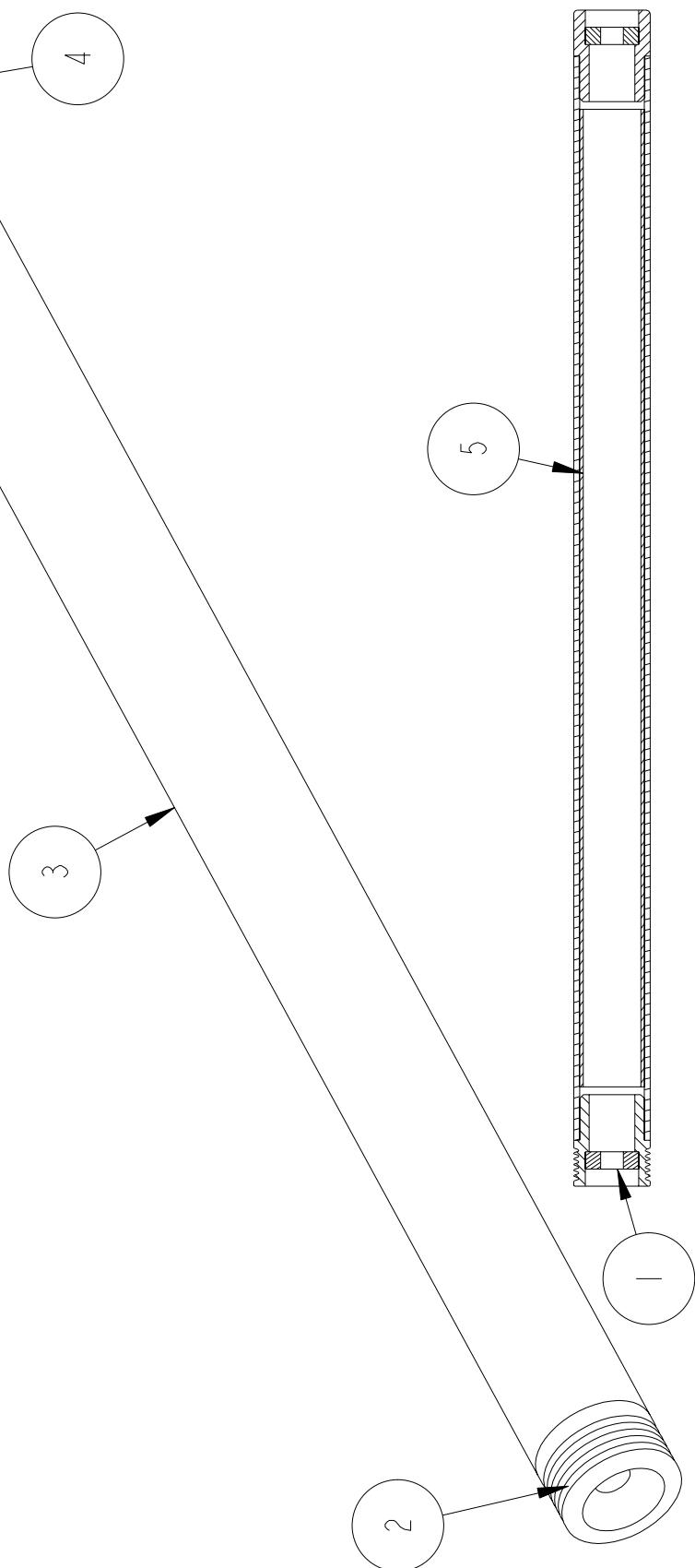
SECTION A-A
SCALE 0.375

I	730
REQ'D	WHERE USED

DRAWN BY: A K E Y	SCALE 0 . 625	MATERIAL: N / A	THIRD ANGLE PROJECTION NO PORTION OF THIS DRAWING MAY BE QUOTED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK RUDY, INC. WOODSTOCK, GA 30188 USA	KIRK - RUDY, INC. WOODSTOCK, GEORGIA
CHECKED BY:	DATE 06 - Aug - 09	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED .XX .XXX ANG. .01 .005 .5 HEAT TREAT: N / A	MODEL: 730F	TITLE: ASSY, TUBE ROLLER
TRACED BY:	MASTER	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED ALL DIMENSIONS ARE FINISHED FINISH: N / A	SHEET NO.: OFF	DRAWING #: 554042-20

ITEM	QTY	PART #	DESCRIPTION
1	2	103106	BEARING, FLAT .375
2	1	554040-04	PULLEY, TWO BELT IDLER
3	1	554041-02	TUBE, ROLLER
4	1	554043-01	HUB, TUBE ROLLER IDLER
5	1	554122-01	CORE, SOUND DEADENING

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



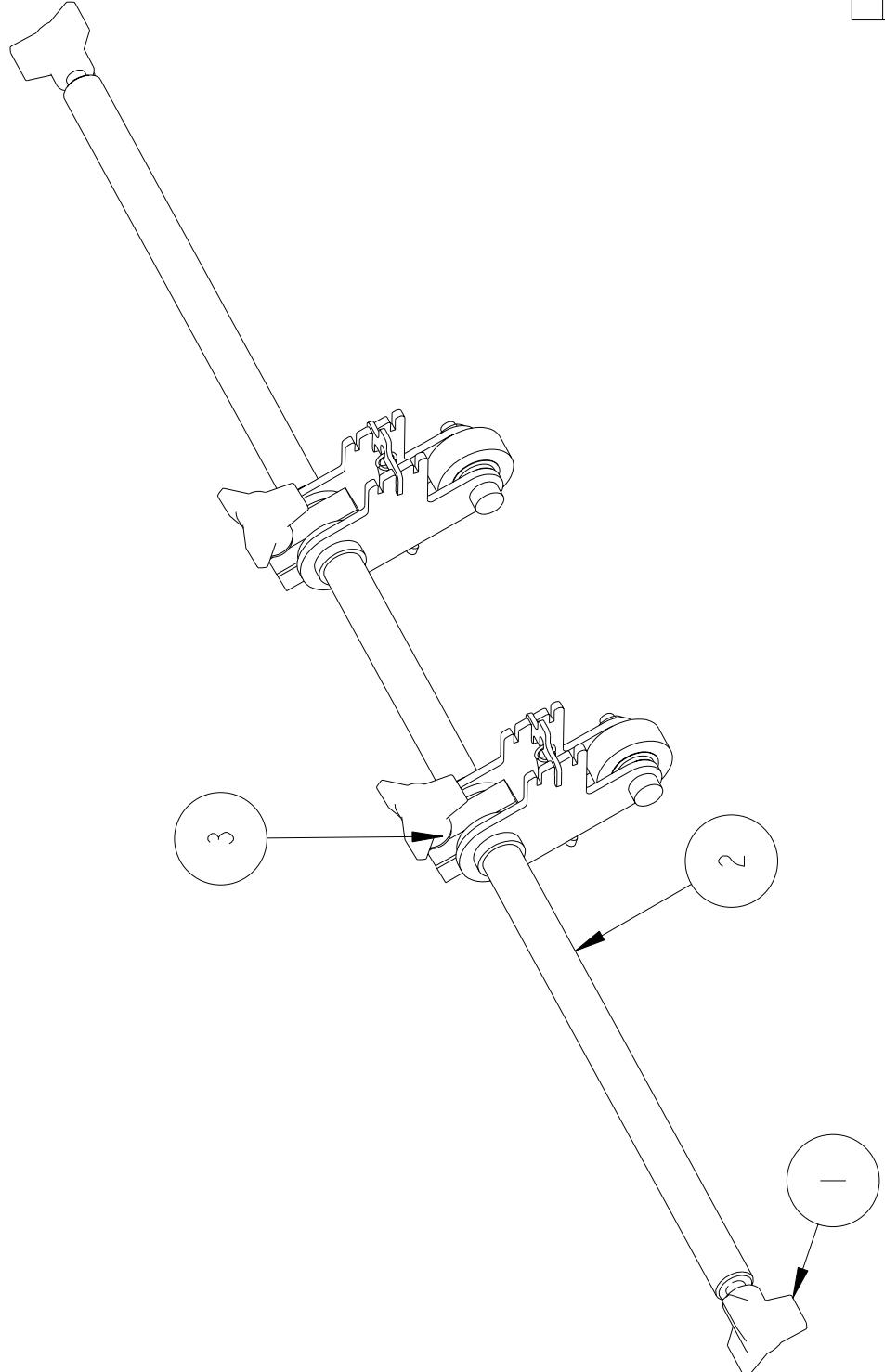
SECTION A - A
SCALE 0.375

DRAWN BY: A K E Y	SCALE 0 . 625	MATERIAL: N / A	THIRD ANGLE PROJECTION NO PORTION OF THIS DRAWING MAY BE QUOTED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK RUDY, INC. WOODSTOCK, GA 30188 USA	KIRK - RUDY, INC. WOODSTOCK, GEORGIA
CHECKED BY:	DATE 06 - Aug - 09	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED .00 .000 ANG. .01 .005 .5 HEAT TREAT: N / A	MODEL: 730 f	TITLE: ASSY, TUBE ROLLER
TRACED BY:	MASTER	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED ALL DIMENSIONS ARE FINISH: N / A	SHEET NO.: OFF	DRAWING #: 554042-21

DRAWING # 554058 - 01

ITEM	QTY	PART #	DESCRIPTION
1	2	102145	KNOB, HAND 3 PRONG 1/4-20 STUD
2	1	554052-01	SHAFT, SIDE GUIDE MOUNT
3	2	554100-04	ASSY, 2.25 PINCH ROLLER ARM

REV NO	DATE	DESCRIPTION	ECN NO	BY



DRAWN BY: A K E Y	SCALE 0 . 500	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED .00 .000 ANG.	THIRD ANGLE PROJECTION N/A	PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE QUOTED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC. WOODSTOCK, GA 30188 USA
CHECKED BY: 09 - Apr - 09	DATE MASTER	.01 -.005 .5 HEAT TREAT: REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED ALL DIMENSIONS ARE FINISHED: DO NOT SCALE - WORK TO DIMENSIONS ONLY	MODEL: 730F SHEET NO.: OFF	KIRK - RUDY, INC. WOODSTOCK, GEORGIA TITLE: ASSY, PINCH ROLLER ARM DRAWING # 554058 - 01
TRACED BY:				

ITEM QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	2	100323 BUSHING, FL. 500ID. 625OD. 375LG					
2	4	100603 WASHER, FLAT 1/4ID					
3	1	100619 WASHER, FLAT 10-32					
4	1	102158 KNOB, HAND 3 PRONG 10-32 X .75 STUD					
5	1	102762 SPRING, EXTENSION					
6	1	106709 NUT, HEX #10-24					
7	2	106819 SCREW, BUTTON HEAD #8-32X.250					
8	1	107005 BOLT, SHOULDER 1/4X3/4					
9	1	501057-A ASSY, ROLLER					
10	1	554096-05 ARM, PINCH ROLLER					
11	1	554096-06 ARM, PINCH ROLLER					
12	1	554099-03 BRACKET, SPRING ANCHOR					
13	1	554101-02 BLOCK, 1" DIA CLAMP					
14	1	554102-02 BRACKET, ARM STOP					

SCALE 1.000

$\phi .500$

$\phi 1.000$

$\phi 1.956$

$\phi 1.000$

4 730
REQ'D WHERE USED

4 730
DRAWING #

DRAWN BY: A KEY	SCALE 1.000	MATERIAL: N/A	THIRD ANGLE PROJECTION NO PORTION OF THIS DRAWING MAY BE QUOTED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC. WOODSTOCK, GA 30188 USA
CHECKED BY:	DATE 12- JUN - 09	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED .00 .005 .005 ANG.	MODEL: 730 TITLE: ASSY, 2.25 PINCH ROLLER ARM
TRACED BY:	MASTER	HEAT TREAT: N/A	SHEET NO. 0F 1 DRAWING #
ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY			

ITEM NO	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	2	KNOB, 2.38" HANDLE .375BORE					
2	4	COLLAR .3.3					
3	2	SHAFT, THREADED 3/8-16					
4	2	NUT, HEX 5/16-18					
5	1	SCREW, BUTTON HEAD #10-32X .375					
6	1	SCREW, SHCS 1/4-20X1.500					
7	4	SCREW, SHCS 3/8-16X1.000					
8	1	SCREW, SHCS 5/16-18X2.50					
9	4	FOOT, MOUNTING					
10	1	LABEL, ROLLER VERT WARNING					
11	1	SCREW, FLATHEAD 5/16-18X2.00					
12	4	LEG, LEVELING					
13	1	SCREW 5/16-05 W/DNNT, TURN OVER BASE					
14	1	PLATE, TURNOVER ARM MOUNT					
15	1	W/MONT, VERTICAL TUBE					
16	1	ASSY, CONTROL BOX					
17	4	ASSY, OPTIONAL FLOOR JACK					
18	1	ASSY, GAS SHOCK					
19	1	STUD, PIVOT					
20	1	WASHER, HOLD BACK					
21	1	COVER, TUBE TOP					
22	1	CSD0346 SCREW, SHCS 3/8-16X1.750					
23	4	NUT, JAM 1/2-13					

SECTION C-C

DRAWING #: 547338-09

RECD WHERE USED

KIRK - RUDY, NC.
WOODSTOCK, GEORGIA

DATE: 09-08-17
TIME: 10:30 AM
MASTER
NOTED
SHEET NO. 1 OF 1

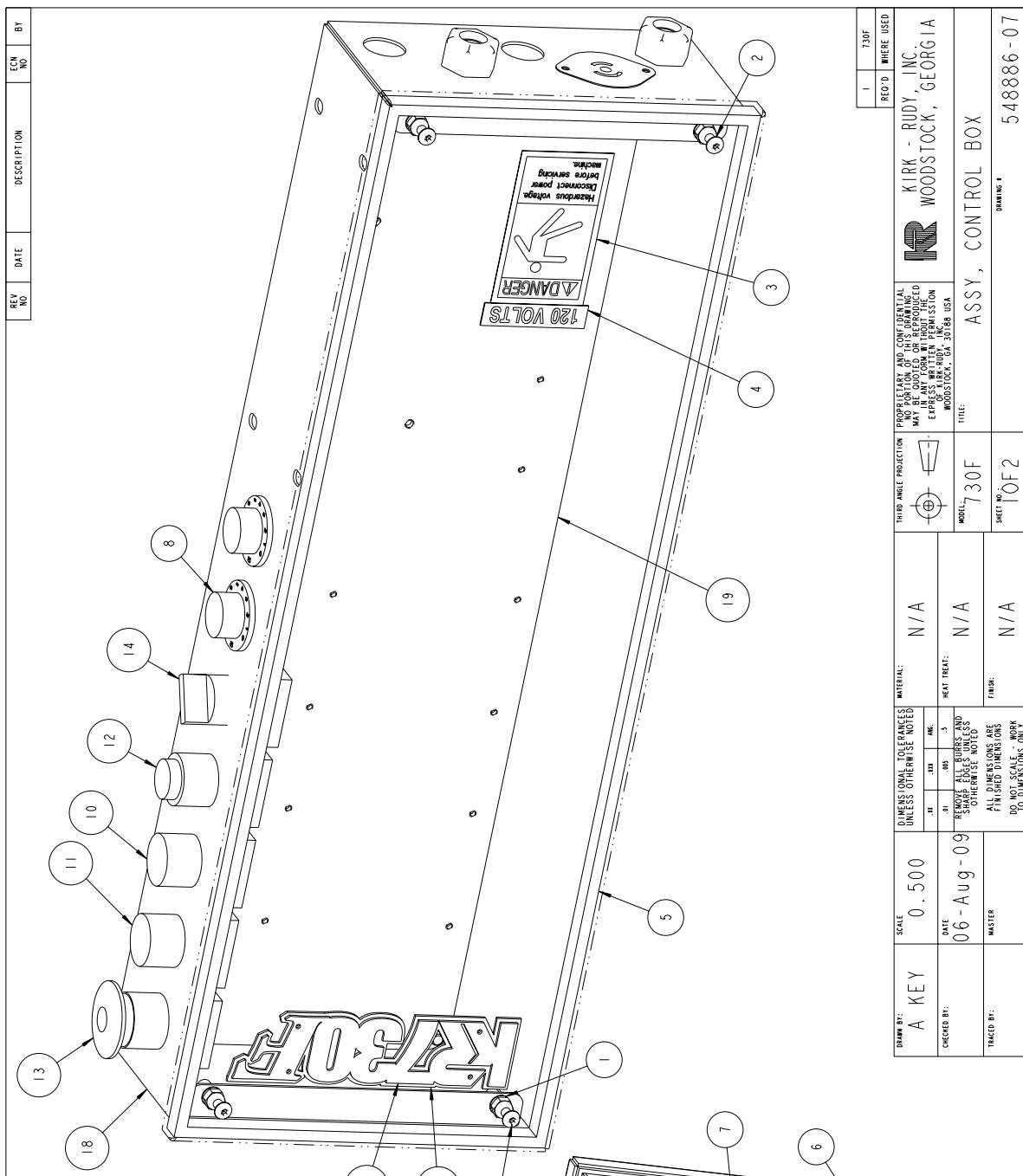
DRAWING #: 547338-09

RECD WHERE USED

ASSY, BASE

DATE: 09-08-17
TIME: 10:30 AM
MASTER
NOTED
SHEET NO. 1 OF 1

ITEM #	CY	PART #	DESCRIPTION
1	4	104502	RIVET NUT, 10-32 THREAD
2	4	106724	NUT, HEX # 10-32 SELF LOCKING
3	1	190188	LABEL, VOLTAGE WARNING LARGE
4	1	190194	LABEL, 120 VOLTS
5	1	190862	EDGING, RUBBER 16 GA
6	2	200123	STRAIN RELIEF
7	1	201528	RECEPTACLE, FLANGED TWIST 3 PIN
8	2	209016	KNOB, POT
9	1	190619-1	PLATE, NAME
10	1	2011124-2	BUTTON, START
11	1	2011124-4	BUTTON, POWER ON
12	1	2011125-3	BUTTON, STOP
13	1	2011125-5	BUTTON, POWER OFF
14	1	2011145-1	SELECTOR, 2 POSITIONS
15	1	530711-04	PANEL, CONTROL
16	1	547184-08	LOGO, KR730F
17	1	547185-09	PLATE, KR730F LOGO BACKING
18	1	551696-02	W/DNNT, CONTROL BOX
19	1	5540467-01	PANEL, CONTROL WHITE
20	4	CSFF62	SCREW, BUTTON HEAD # 10-32X1.000



ITEM #	REV NO	DATE	DESCRIPTION	ECN NO	BY
1					
2					
3					
4					
5					
6					
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8					
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11					
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19					
20					

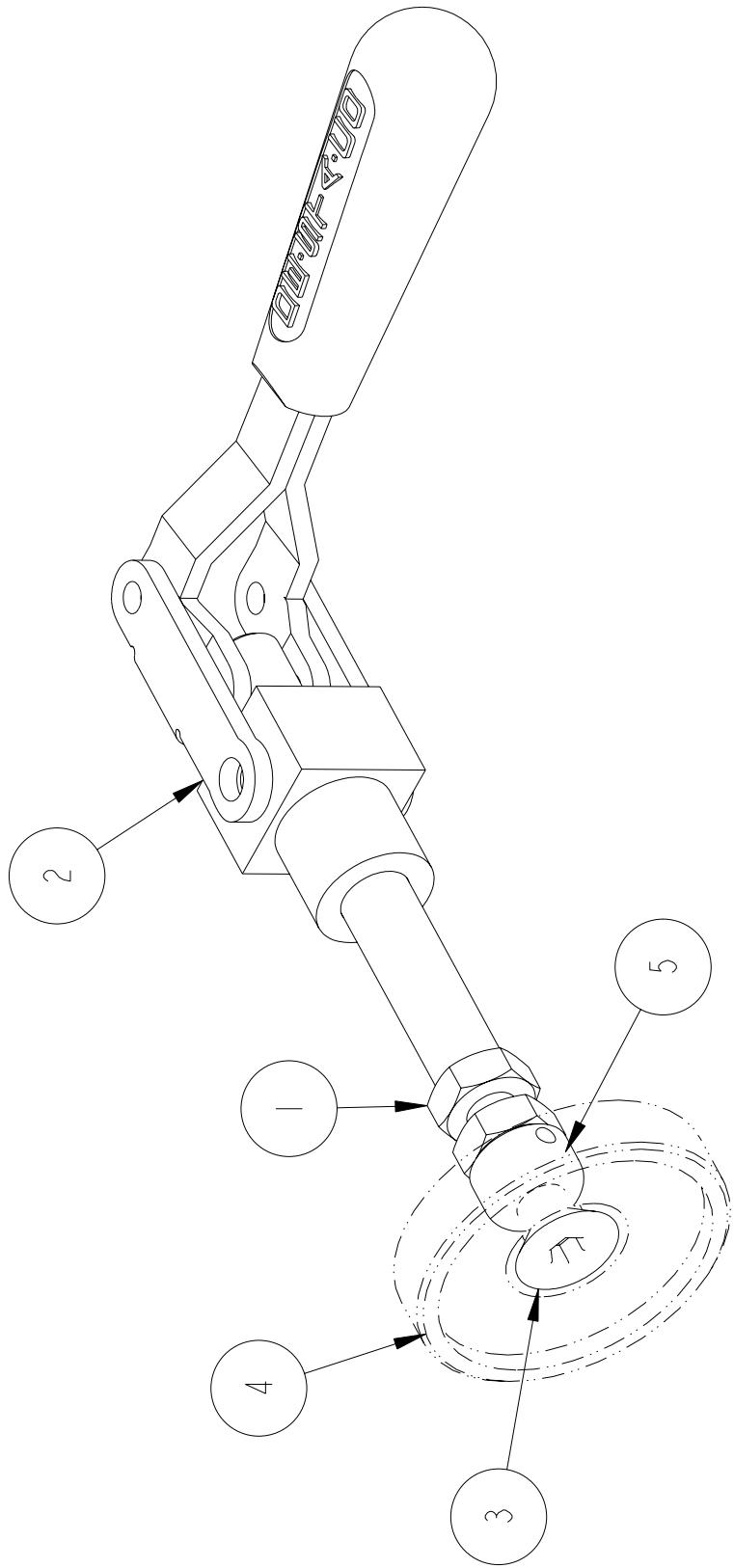
RECD WHERE USED
730F

DRAWING #:		SCALE	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED		MATERIAL:	THIRD ANGLE PROJECTION		PROPRIETARY AND CONFIDENTIAL MANUFACTURED BY KIRK-RUDY INC. IN ANY FORM WITHOUT THE EXPLICIT WRITTEN CONSENT OF WOODSTOCK, GA 30188 USA	
DRAWN BY:	A KE Y	0 . 500	.065	.065	N/A	.5	HEAT TREAT:	730F	RECD WHERE USED 730F
CHECKED BY:		DATE 06 - Aug - 09							
TRACED BY:	MASTER						FINISH:	N/A	SET NO 0F2

ASSY , CONTROL BOX

DRAWING # 548886-07

ITEM	QTY	PART #	DESCRIPTION
1	2	106712	NUT, HEX 5/16-18
2	1	191234	CLAMP, DESTACO QUICK RELEASE
3	1	107529-1	SCREW, FLATHEAD 5/16-18X1.750
4	1	554123-01	PAD, LIFT
5	1	554124-01	SHAFT, LIFT PAD



OPTIONAL FLOOR JACK

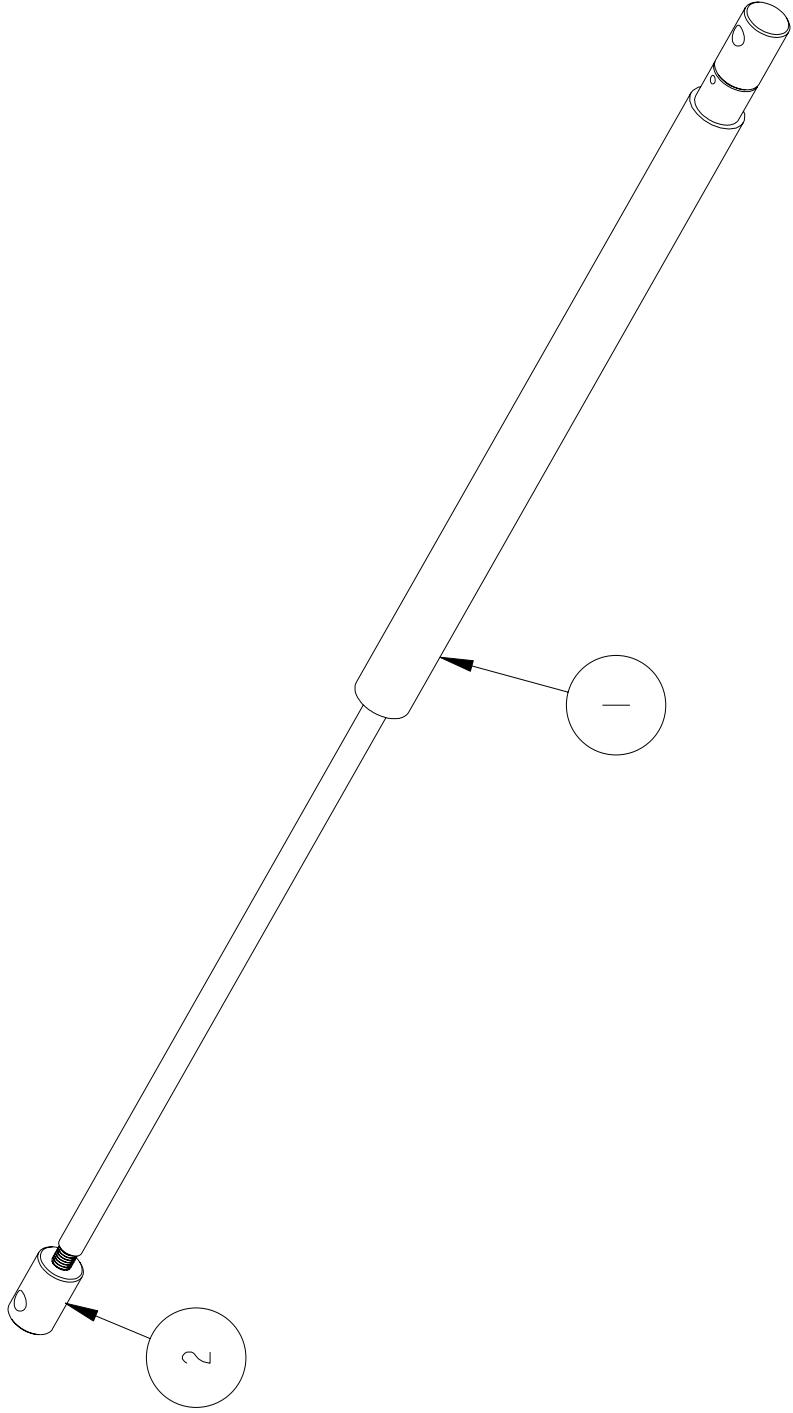
DRAWN BY:	SCALE	REV NO	DATE	DESCRIPTION	ECN NO	BY
A K E Y	1 . 0 0 0					
DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	.XX	.XXX	ANG.	MATERIAL: N / A	THIRD ANGLE PROJECTION	PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE QUOTED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK RUDY, INC. WOODSTOCK, GA 30188 USA
DATE:	.01	.005	.5	HEAT TREAT: N / A	MODEL: 730F	KIRK - RUDY, INC. WOODSTOCK, GEORGIA
CHECKED BY:	06 - Aug - 09			FINISH: N / A	SHEET NO.: OFF	TITLE: ASSY, OPTIONAL FLOOR JACK
TRACED BY:	MASTER					DRAWING #: 554036-02

DRAWING #

554062-01

ITEM	QTY	PART #	DESCRIPTION
1	1	191899	SPRING, GAS 270 LB 11.812 S
2	2	554078-02	BRACKET, GAS SHOCK

REV NO	DATE	DESCRIPTION	ECN NO	BY



DRAWN BY: A K E Y	SCALE 0 . 375	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED .00 -.000 ANG. .01 -.005 .5	THIRD ANGLE PROJECTION HEAT TREAT: N / A	PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE QUOTED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK RUDY, INC. WOODSTOCK, GA 30188 USA	KIRK - RUDY, INC. WOODSTOCK, GEORGIA
CHECKED BY: MASTER	DATE 7 - Aug - 09	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY	MODEL: 730F	TITLE: ASSY, GAS SHOCK	
TRACED BY: MASTER		FINISH: N / A	SHEET NO.: OF 1	DRAWING #: 554062-01	

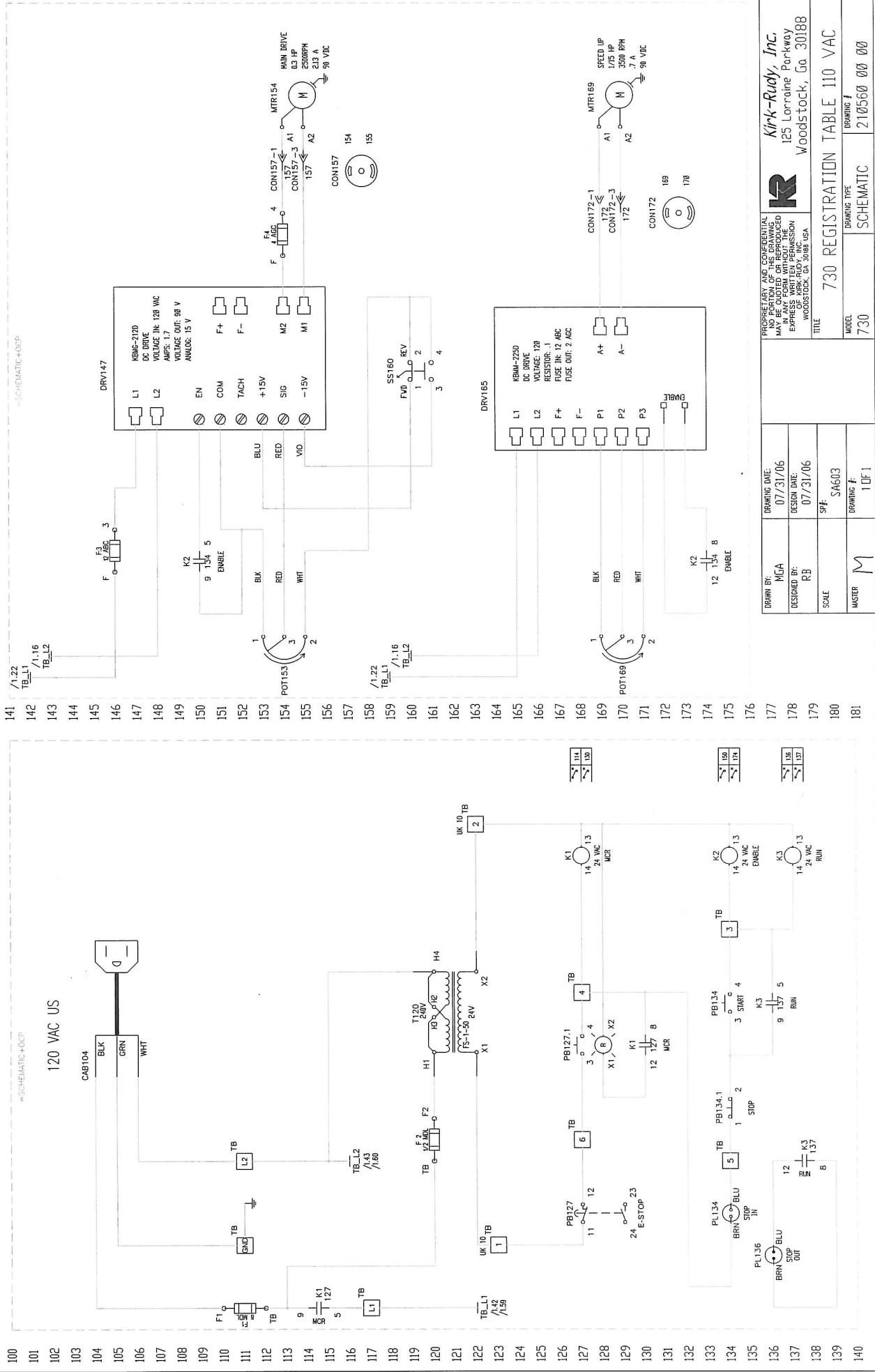
10.0 ELECTRICAL

10.1 SCHEMATIC

See following pages for the electrical diagram.

10.2 ELECTRICAL PARTS LIST

NO.	PART NO.	DESCRIPTION	QTY
1	201514	PLUG, MALE 3 PIN TWIST	1
2	201515	PLUG, FEMALE 3 PIN TWIST	1
3	201516	PLUG, POWER	1
4	201528	PLUG, 3 PIN TWIST FEMALE	1
5	201540	RECEPTICAL, STOP IN	1
6	201542	CABLE, TURCK STOP OUT	1
7	202277	SOCKET	3
8	202291	RELAY, 24VAC	3
9	202426	BOARD, KBMM-225D	1
10	203029	TRANSFORMER	1
11	204318	POTS 5K	2
12	208009	FUSE, 2 AGC	1
13	208017	FUSE, 1/2 MDL	1
14	208021	FUSE, 8 MDL	1
15	208023	FUSE, 12 AGC	2
16	208044	FUSE, 4 AGC	1
17	209238	CAP, END	2
18	209245	HOLDER, FUSE	1
19	209247	HOLDER, FUSE	3
20	200165-9	MOTOR, .3 HP DC BRUSH 2500RPM	1
21	200170-4	MOTOR, DC 1/15HP 3500RPM 90VDC LEESON M1110015.00	1
22	200323-1	RELIEF, STRAIN	3
23	201124-2	BUTTON, START	1
24	201124-4A	SWITCH, POWER ON	1
25	201125-3	SWITCH, STOP	1
26	201125-9	SWITCH, POWER OFF	1
27	201130-1	CONTACT, NORMALLY OPEN	3
28	201131-1	CONTACT, NORMALLY CLOSED	2
29	201145-1	SWITCH, SELECTOR	1
30	202426-4	BOARD, KBMG-212D	1
31	209016-2	DISC, POT KNOB LOCKING	2
32	209016-3	POT KNOB	2
33	209233-2	BLOCK, TERMINAL	6
34	209234-2	BLOCK, TERMINAL	2
35	209237-2	BLOCK, GROUND	1
36	209547-3	CABLE, 10' 16-3	1



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11 NOTES

12 WARRANTY AND SERVICE

WARRANTY

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

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

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

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

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

USE ONLY GENUINE KIRK-RUDY REPLACEMENT PARTS

For Service or Replacement Parts Please Call:
Your local Kirk-Rudy dealer or
Kirk-Rudy @ 770-427-4203

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