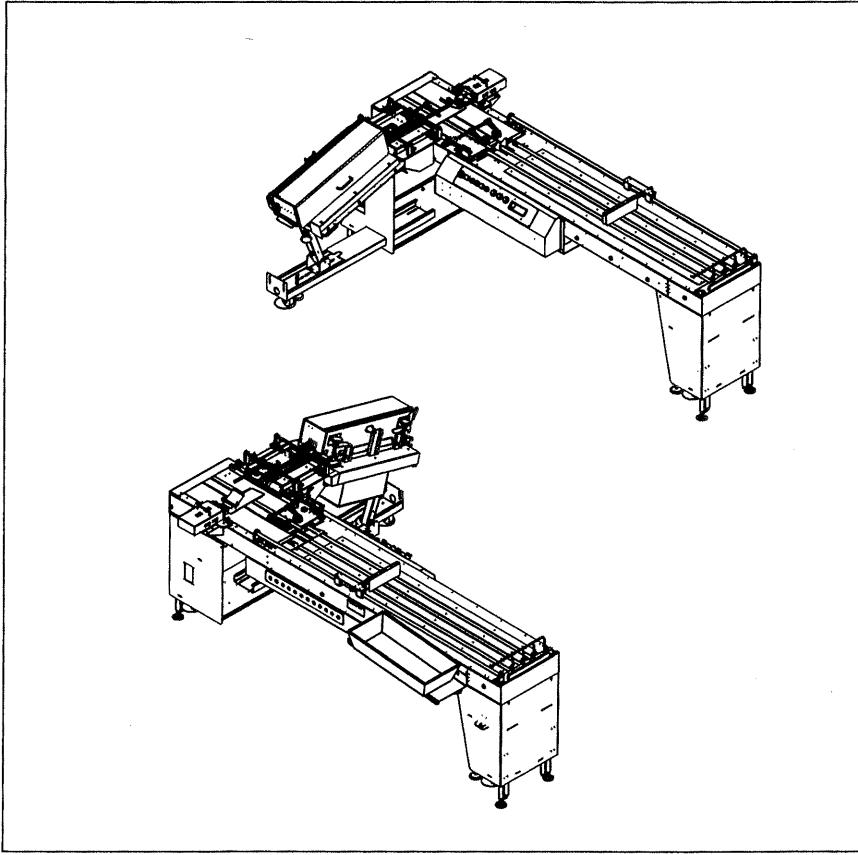


Kirk-Rudy Inc.

KR345T On-Edge Stacker With Turnover Instruction and Parts Manual



Manufactured by Kirk-Rudy, Inc.

Before using this machine, all operators must study this manual to understand and follow the safety warnings and instructions. Keep these instructions with the machine for future reference. If you have any questions, contact your local Kirk-Rudy, Inc. Distributor.

10000-KR345T REV. 2 6/22/06

Turnover
Instruction
and Parts Manual

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1.0 Important Safety Instructions

Intended Use Statement: The KR345T On-Edge Stack is a belted conveyor transport designed to turnover, shingle and edge stack paper and plastic products. The system is made up of three major sections - the turnover/infeed, crossfeed and outfeed sections. Product enters the turnover/infeed section and is sped up, aligned and diverted onto the crossfeed section. Product is shingled and sorted on the crossfeed conveyor. The outfeed section is used for shingling or edge stacking the material. Product is slid off the outfeed conveyor directly into a mail tray. Usage for other purposes may lead to an unsafe condition.

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

	WARNING
<ul style="list-style-type: none">* NEVER OPERATE THE MACHINE WITHOUT ALL GUARDS OR SAFETY DEVICES IN PLACE.* ALWAYS TURN POWER OFF WHEN MAKING ADJUSTMENTS.* ALWAYS DISCONNECT THE POWER SUPPLY BEFORE ANY MAINTENANCE OR SERVICE WORK.* NEVER START THE MACHINE WITHOUT FIRST CHECKING ALL PERSONNEL ARE CLEAR OF MOVING PARTS.* KEEP FINGERS CLEAR OF ALL MOVING PARTS.* NEVER REMOVE THE PRODUCT FROM THE MACHINE WHILE MACHINE IS RUNNING.* SHOULD MISFEED PRODUCT JAM THE MACHINE AND STOP IT FROM RUNNING, ALWAYS PRESS THE STOP BUTTON BEFORE CLEARING PRODUCT. IF THE STOP BUTTON IS NOT PRESSED AND THE JAM IS CLEARED, THE MACHINE WILL BEGIN RUNNING.* IT IS NOT RECOMMENDED THAT LOOSE CLOTHING, JEWELRY AND LONG HAIR BE WORN WHILE OPERATING THIS MACHINERY.* ALWAYS USE A LICENSED ELECTRICIAN WHEN TROUBLE-SHOOTING ELECTRICAL PROBLEMS.* CHANGES OR MODIFICATIONS TO THIS UNIT NOT EXPRESSLY APPROVED BY THE PARTY RESPONSIBLE FOR COMPLIANCE COULD VOID THE USER'S AUTHORITY TO OPERATE THE EQUIPMENT.	

2.0 SPECIFICATIONS

Physical

Length	108.6"
Height	41"
Width	69"
Infeed height	24"-32"

Electrical Requirements

Voltage	120 VAC
Current	15 amps
Phase	single
Hertz	60

Production Rate

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

***Material Handling**

Min stock size-Edge stacking	3" x 5" card stock or envelope
Max stock size-Edge stacking	*6" x 10" card stock or envelope
Minimum stock thickness-shingle only	copy paper
*Maximum stock thickness	*.09"

Width x Length

3" x 5" card stock or envelope
*6" x 10" card stock or envelope
copy paper
*.09"

* Maximum thickness and size may be reduced with stiff product.

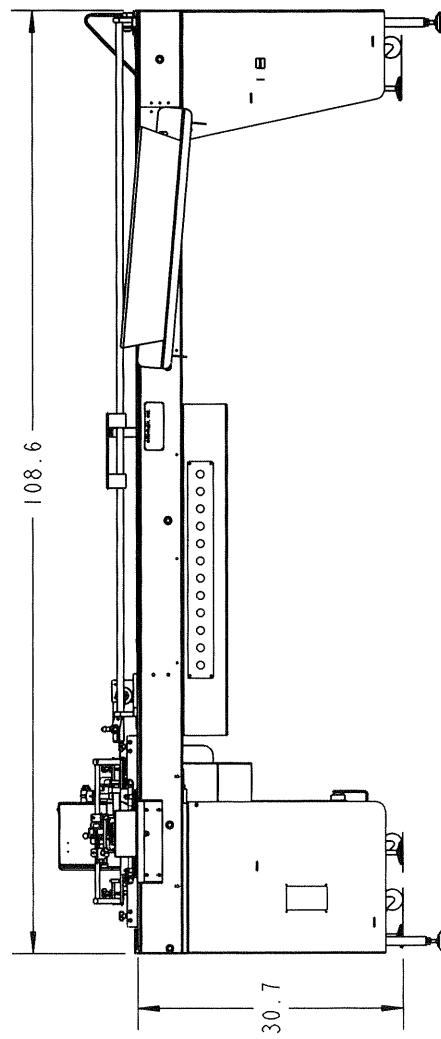
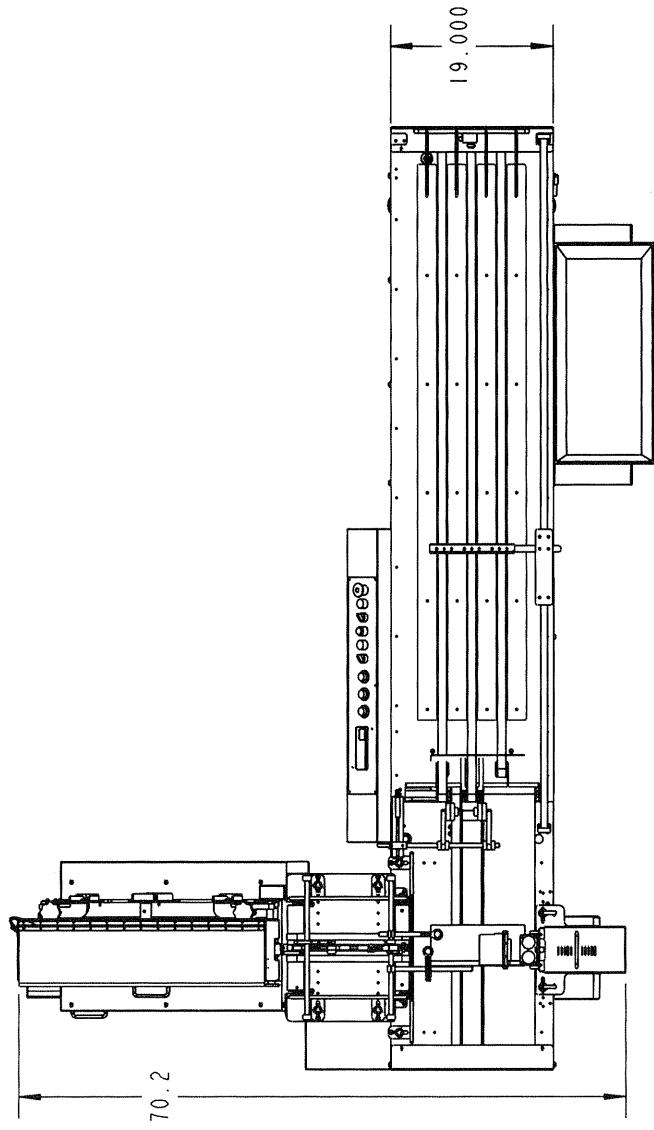
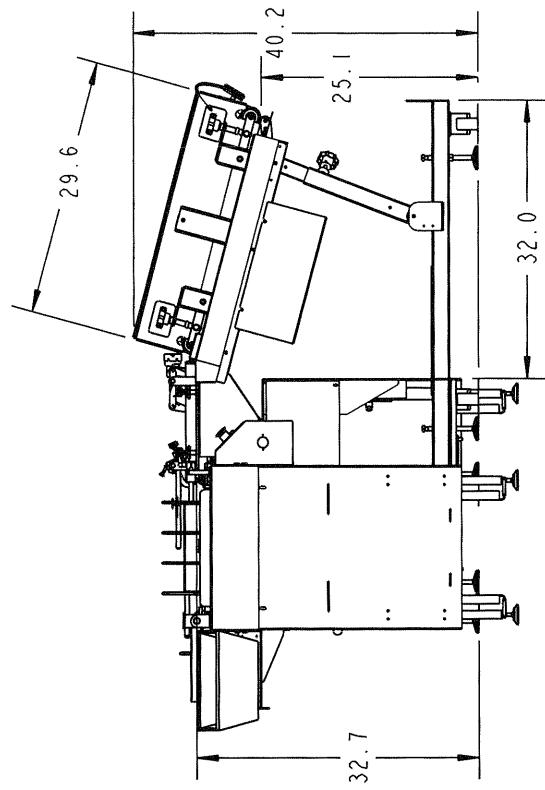
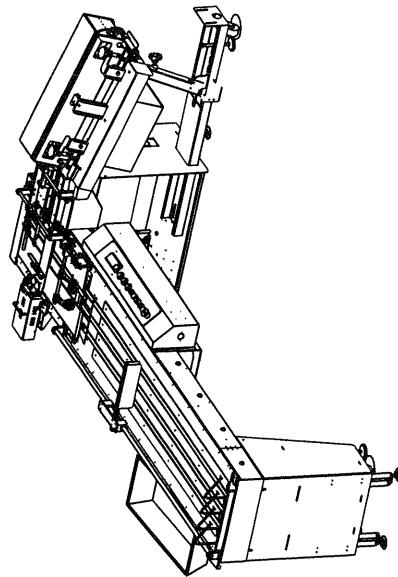
Features

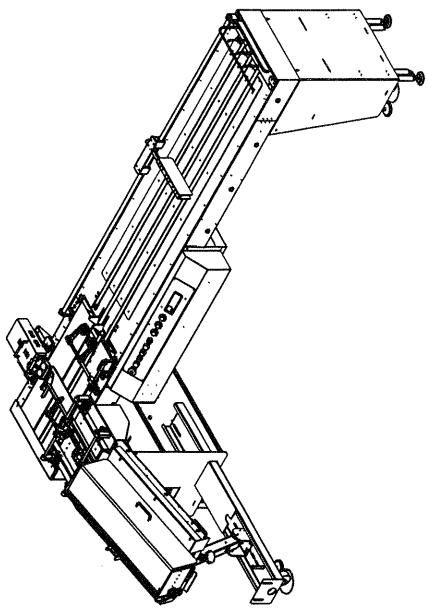
High speed infeed table
Semi-automatic startup
Standard inkjet interface
Shingle only mode
Batch counter mode
Mail tray shelf

Options

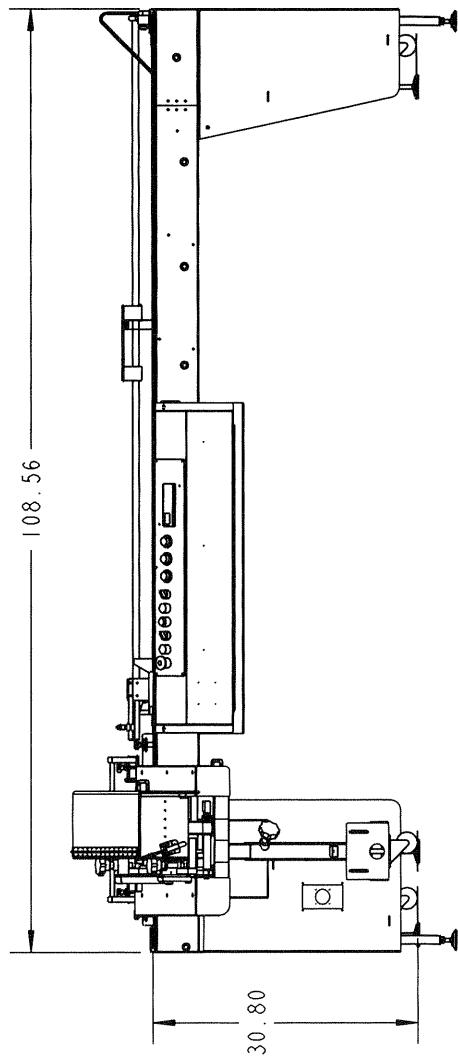
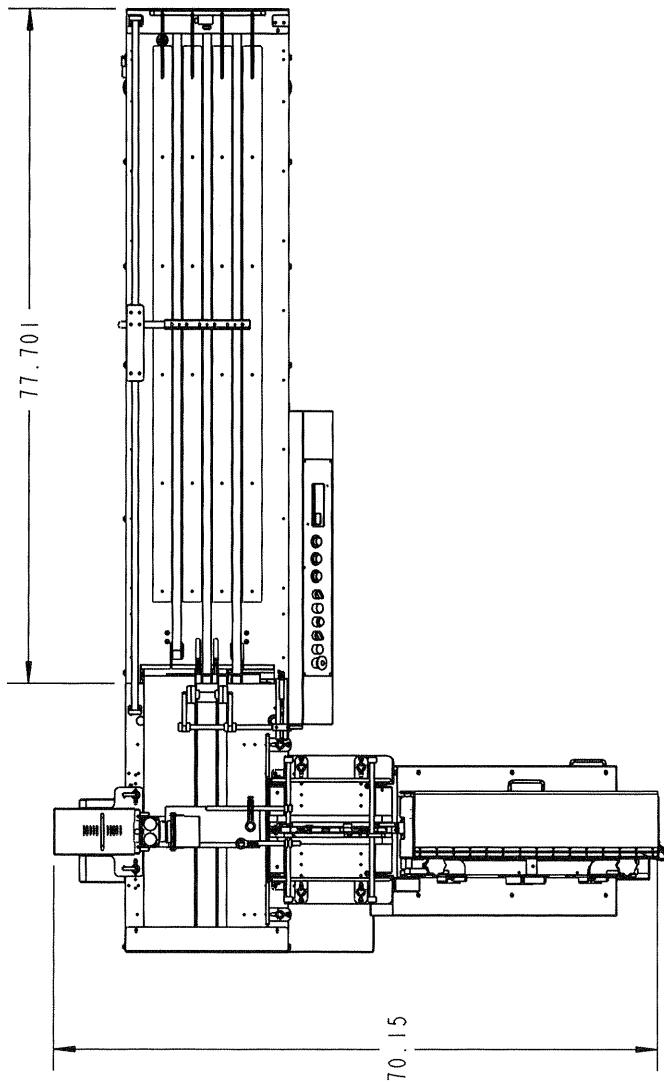
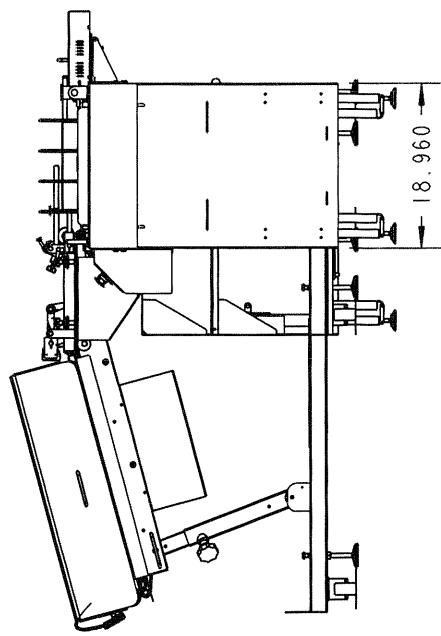
Hydraulic lift kit
Left or right outfeed conveyor
Stack mark reader

SA397-L KR345-L W/ TURNOVER





SCALE 0.030



SA397-R KR345R W/TURNOVER

3.0 INSTALLATION



WARNING

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

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

3.1 Uncrating and Unpacking

Position crates near installation site.

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

3.2 Cable and Cord Connections

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

4.0 Machine Description

4.1 Mechanical Component Description

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

4.1.1 Turnover/Infeed Conveyor

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

4.1.2 Crossfeed conveyor

1. The sort mechanism moves the knockdown plate/ball assembly in and out across the crossfeed conveyor. This creates offsets in the shingled stream indicating zip and bundle breaks. The knockdown can be adjusted in three directions: up/down, side to side and in/out. A brush mounted to the plate helps prevent material from bouncing off the steel balls.
2. The vacuum in the crossfeed tabletop holds product in place as it is being conveyed. A butterfly valve is available to control the vacuum level.
Note: vacuum blower not install on KR345T machine.
3. The press down roller assembly drives product up to a vertical position.

4.1.3 Outfeed conveyor

1. The spring-loaded wedge assembly directs product up against the backstop to start the vertical stacking process. The wedges are forced underneath the table as product flows across them.
2. The top edge of the mail piece stops against the upper product guide assembly. This unit adjusts vertically. Note:KR345T not equipped with this.
3. The backstop assembly moves along with the outfeed conveyor belts to support the stack. When using the KR 345 as a conventional shingle conveyor, $\frac{1}{4}$ " rods are installed at the end of the outfeed conveyor and the backstop is pivoted out of the way.

DRAWING # 548666-01

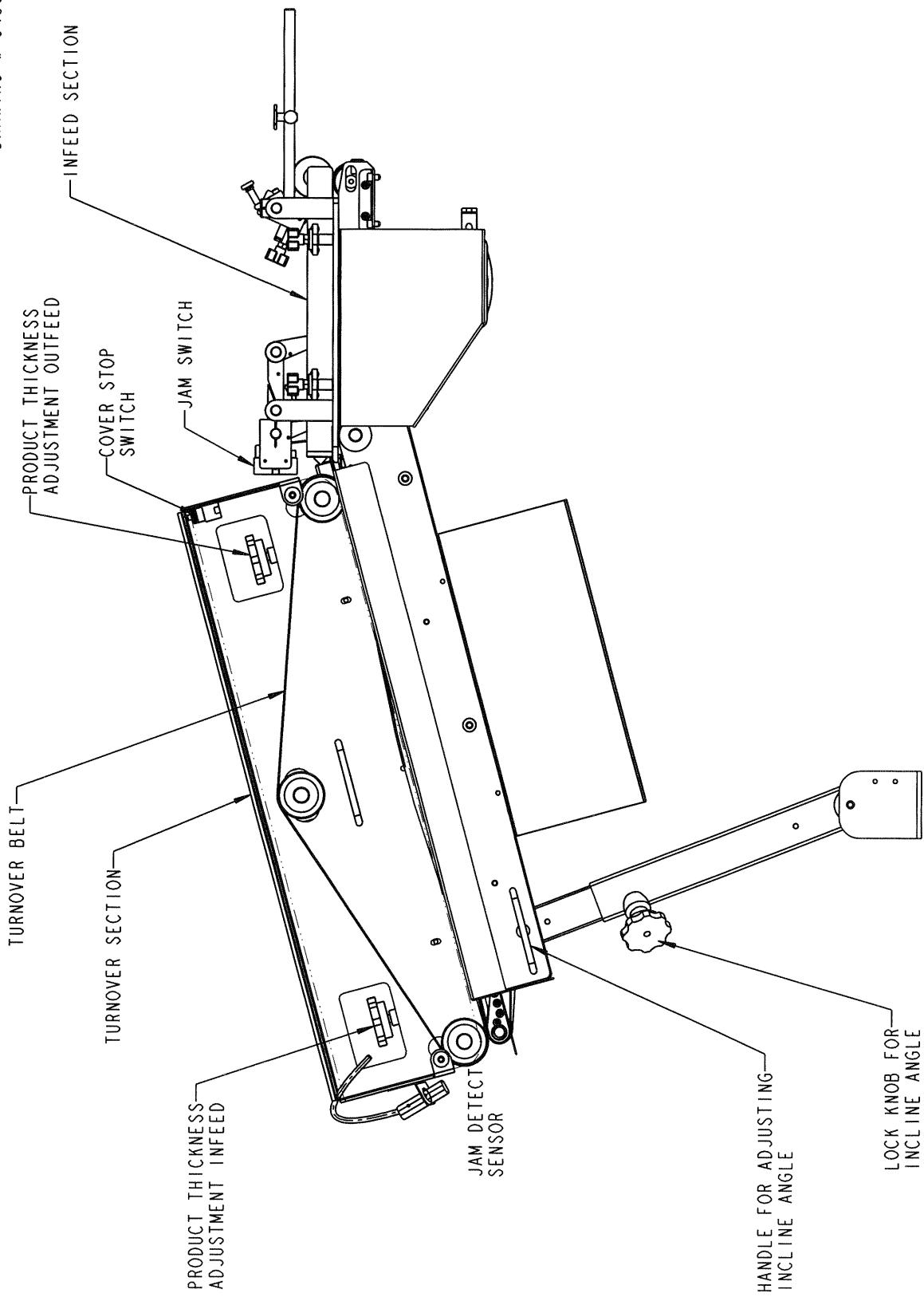


FIGURE #2
TURNOVER/INFEED SECTION

4.2 Electrical Component Description

4.2.1 Control Panel

- 1) Emergency Stop Button: Press button to turn machine power off. To turn power on, unlatch this button. The green “power on” indicator light will turn off when power is off.
- 2) Power on Button: Press this button to turn machine power on. Emergency stop button must be unlatched. Switch illuminates when activated.
- 3) Blower off/on: Turns the crossfeed blower on or off. . Note:KR345T not equipped with this.
- 4) Stop Button: Stops all drive motors.
- 5) Start Button: When the main power is on, the start button will start the drive motors. Always be sure personnel are clear of moving parts before pressing the start button.
- 6) Vertical/conventional: Sets the mode of operation to either edge stacking (vertical) or conventional shingling. When set to conventional mode, the cross feed and outfeed conveyors operate together. Note:KR345T not equipped with this.
- 7) Speed Control Knobs: Sets the speed of the unit’s drive motors.
- 8) User Interface: See section 4.3 User Interface for complete description.

4.2.2 Electrical Connections to Base

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

4.2.3 Beam and Micro Switches

1. A beam switch mounted to the infeed of turnover is used to sense product jams. The KR345 will stop and turnoff upstream machines if the beamswitch is covered for more than a preset amount of time.
2. A micro switch is mounted on the skidbar on the infeed conveyor. A jam on the infeed conveyor will raise the skid bar activating the micro switch and stopping the vertical stacking conveyor.

4. The counter beam switch provides the count to the PLC for batch counting. If necessary, a time delay can be added to the signal by the PLC.
5. The outfeed stop beam switch is also a perfect prox type. This switch automatically stops the vertical stacking conveyor when the backstop is within two inches of it.

4.3 USER INTERFACE

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

4.3.2 Pushbuttons:

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

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

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

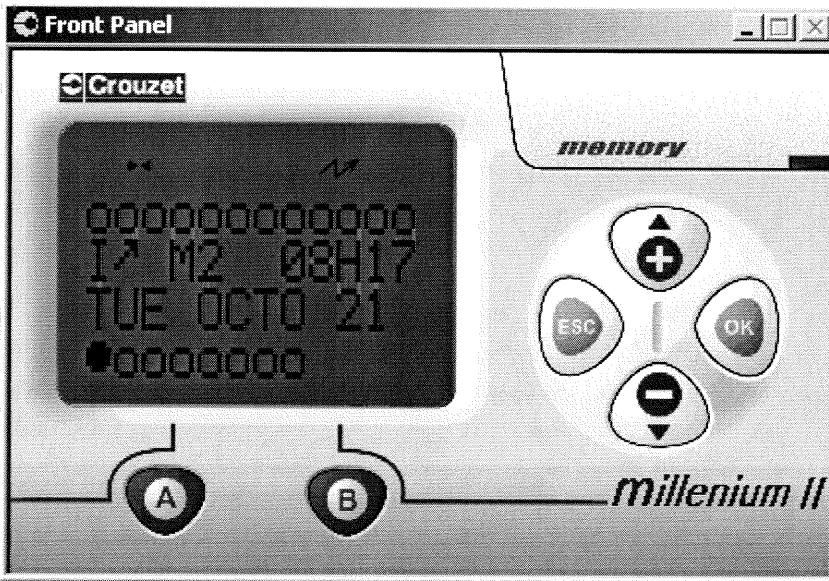
“ESC” Button: This button will exit the editing menu and will return to the default condition for the screen.

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

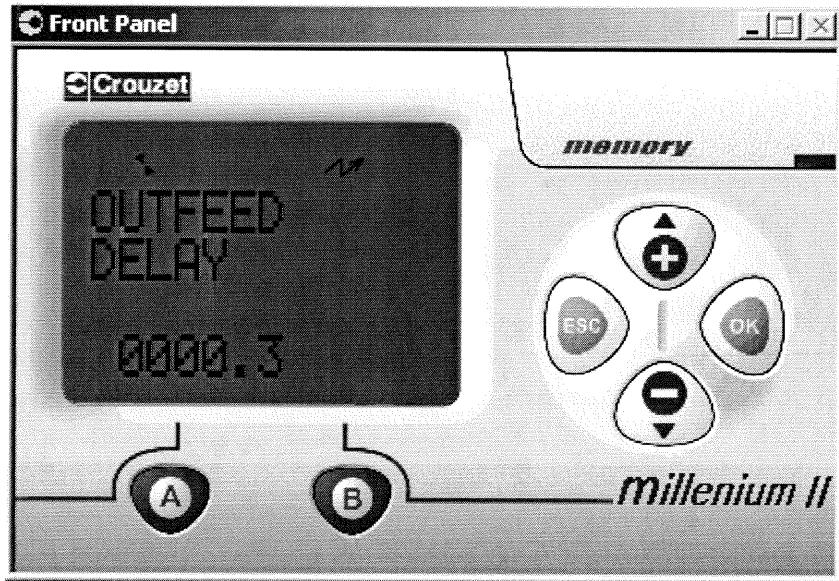
“-” Button: This button works just like the “+” button except that it will decrement the value being edited.

4.3.3 Screens:

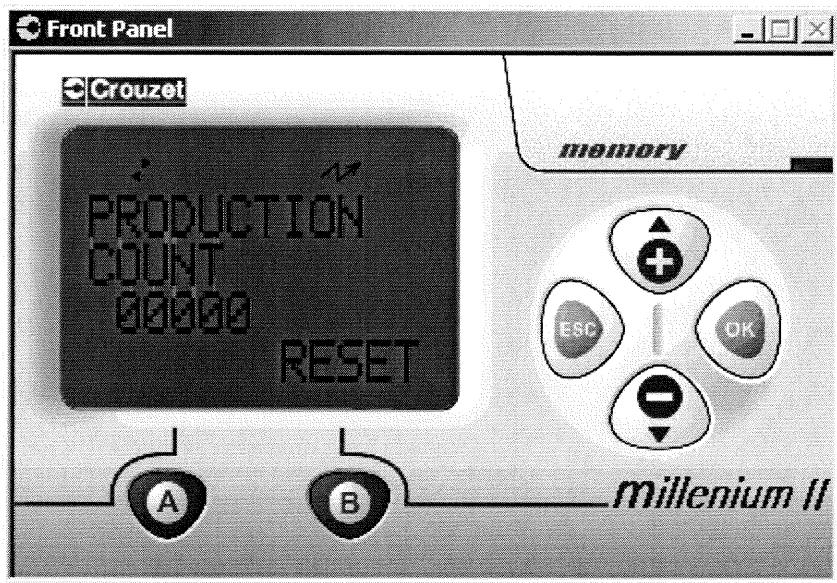
Main Screen: The main screen is the PLC default screen. It shows the current I/O status, the time, and the date. Pressing the “A” button will bring up the next screen.



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



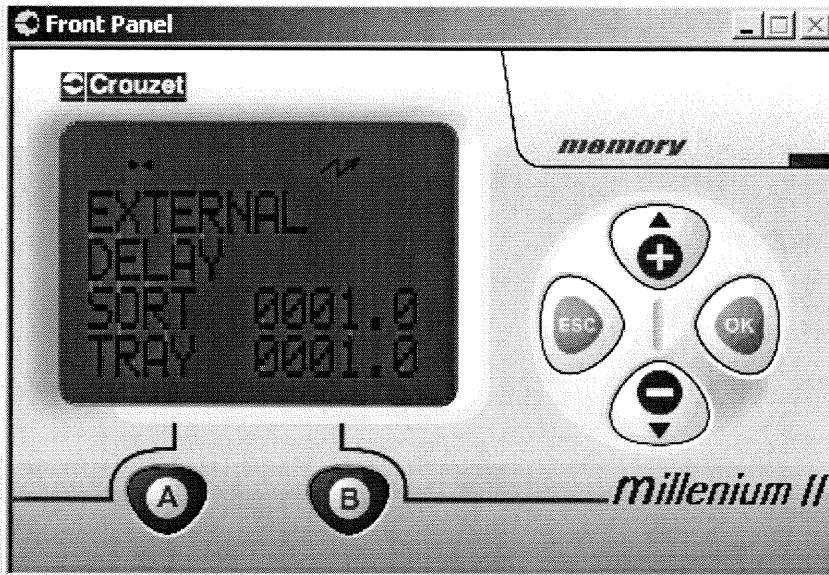
Production Count Screen: This keeps the running total of the number of pieces the stacker stacked. The "B" button will reset the count to zero. The "B" button will only reset the count when this screen is displayed.



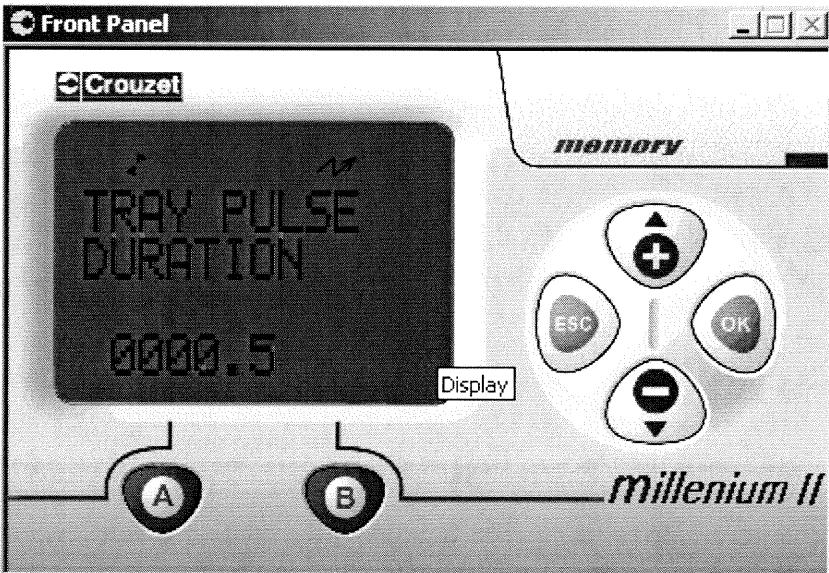
Sort Screen: This screen contains two variables. To move from one variable to the other, use the “+” and “-“ keys. Both functions operate off the Counter PE. The “Trig Delay” is a time delay before the sort actuator is activated after the sort count is complete. The Sort Preset is the number of pieces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



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



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



4.3.4 Inputs and Outputs (I/O):

Inputs:

Input 1: Not Used

Input 2: Start PB input.

Input 3: Stop PB input.
Input 4: Crossfeed PE.
Input 5: Outfeed PE. Must be off for machine to run.
Input 6: Break PE.
Input 7: Mode Vert/Conv. Switch
Input 8: Product Counter PE.
Input 9: Skid Bar Limit Switch. Must be on for the machine to run.

Outputs:

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

5.0 Operating Instructions

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

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

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

5.2 System Setup

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

5.3 Turnover section (see figure #2)

1. Loosen knob on tubing to adjust turnover incline angle to match upstream machine output height. Use handle to support turnover before loosening knob. Tighten knob after the correct height is reached.
2. Adjust upper roller height for product thickness on infeed and outfeed.

5.4 Infeed section

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

5.5 Cross feed Section

1. Center the knock down plate with the flow of the product and lock in place. (Depending on the piece, the knock down assembly sometimes works better a little off center).
2. Adjust the front to back position of the knockdown assembly. This adjustment is usually made with the unit in the retracted position. Its position depends on

the piece to be run. For longer pieces, move it away from the infeed section. Remember, for the cross feed beam switch to function, the trailing edge of the piece needs to extend between the beam switch and the reflective tape. Very short pieces require placing reflective tape between the vacuum belts and relocating the beam switch to this area.

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

5.6 Outfeed Section

1. The wedges are spring-loaded and will lift up from underneath the table when product is clear above them. Bring the backstop against the wedges.
2. Ensure the press down roller assembly is centered on the piece.

5.7 System operation

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

5.8 TROUBLE SHOOTING

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

6.0 MAINTENANCE



WARNING

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

6.1 Turnover/Infeed Conveyor

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

6.2 Crossfeed Conveyor

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

6.3 Outfeed Conveyor

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

7.0 PARTS LISTS AND DIAGRAMS

7.1 ASSEMBLY DRAWING LIST

ASSEMBLY #	DESCRIPTION
SA397-L	ASSY, KR345 W/TURNOVER LH
SA397-R	ASSY, KR345 W/TURNOVER RH
544193-03	ASSY, PRODUCT ROLLERS LH
544193-04	ASSY, PRODUCT ROLLERS RH
544284-03	ASSY, SHINGLE SECTION LH
544207-01	ASSY, LINEAR GUIDE BRACKET
544756-01	ASSY, PRODUCT STOP
544287-03	ASSY, IDLER SHAFT LH
544287-04	ASSY, IDLER SHAFT RH
544295-01	ASSY, IDLER CONVEYOR BELT
544498-01	ASSY, SIDGUIDE SHINGLE SECTION
544454-04	ASSY, KR345 OUTFEED SECTION LH
544454-05	ASSY, KR345 OUTFEED SECTION RH
530610-01	ASSY, TAKEUP 1 IN BELT
530610-02	ASSY, TAKEUP 1 IN BELT
544459-03	ASSY, BACKSTOP RH
544459-04	ASSY, BACKSTOP LH
544469-06	ASSY, CONVEYOR FRAME LH
544469-07	ASSY, CONVEYOR FRAME RH
538171-04	ASSY, 1/4HP GEARHEAD W/CLUTCH
539424-01	ASSY, RH HYDRALIFT LEG
539425-01	ASSY, LH HYDRALIFT LEG
544335-02	ASSY, CONTROL PANEL KR345
548666-01	ASSY, TURNOVER + INFEED
532466-01	ASSY, DRYER ARM PIVOT
544293-03	ASSY, INFEED SECTION
544492-01	ASSY, SIDEGUIDE INFEED
544567-01	ASSY, SKIDBAR KR345
547332-03	ASSY, MINI TURN OVER
547335-01	ASSY, INFEED ROLLER
548335-02	ASSY, INFEED ROLLER
547407-01	ASSY, UPPER BELT ROLLER
547407-02	ASSY, UPPER BELT ROLLER
547419-02	ASSY, DIVERT ROLLER
547480-03	ASSY, TURN OVER COVER
548591-01	ASSY, TENSIONER TURNOVER BELT

7.2 SPARE PARTS LIST

KR PART#	DESCRIPTION
105908	BELT, FLAT 3/4 X 30.75"
108911	BELT, TIMING 150L075
108937	BELT, TIMING 255L050
108945	BELT, TIMING 270L050
109115	BELT, TIMING 098L050
111839	BELT, FLAT 6 X 68.75
111840	BELT, FLAT 1 X 68.75"
111841	BELT, FLAT 2.25 X 62.00
111891	BELT, FLAT 133" X 1.25" 2RH TWIST
111893	BELT, FLAT 1 X 152.25
111894	BELT, FLAT 1 X 158.00

SA397-L

ITEM NO.	PART #	DESCRIPTION	REV. NO.	DATE	DESCRIPTION	REV. NO.
1	110020-83	CHAIN, #35 X 32.00"				
2	110020-84	CHAIN, #35 X 31.50"				
3	2	111894-3 BELT, FLAT 1 X 158.00				
4	1	544193-03 ASSY, PRODUCT ROLLERS LH				
5	1	544284-03 ASSY, SHINGLE SECTION LH				
6	1	544454-04 ASSY, KR345 OUTFEED SECTION LH				
7	1	544669-06 ASSY, CONVEYOR FRAME LH				
8	1	548166-01 ASSY, TURNOVER + INFED				

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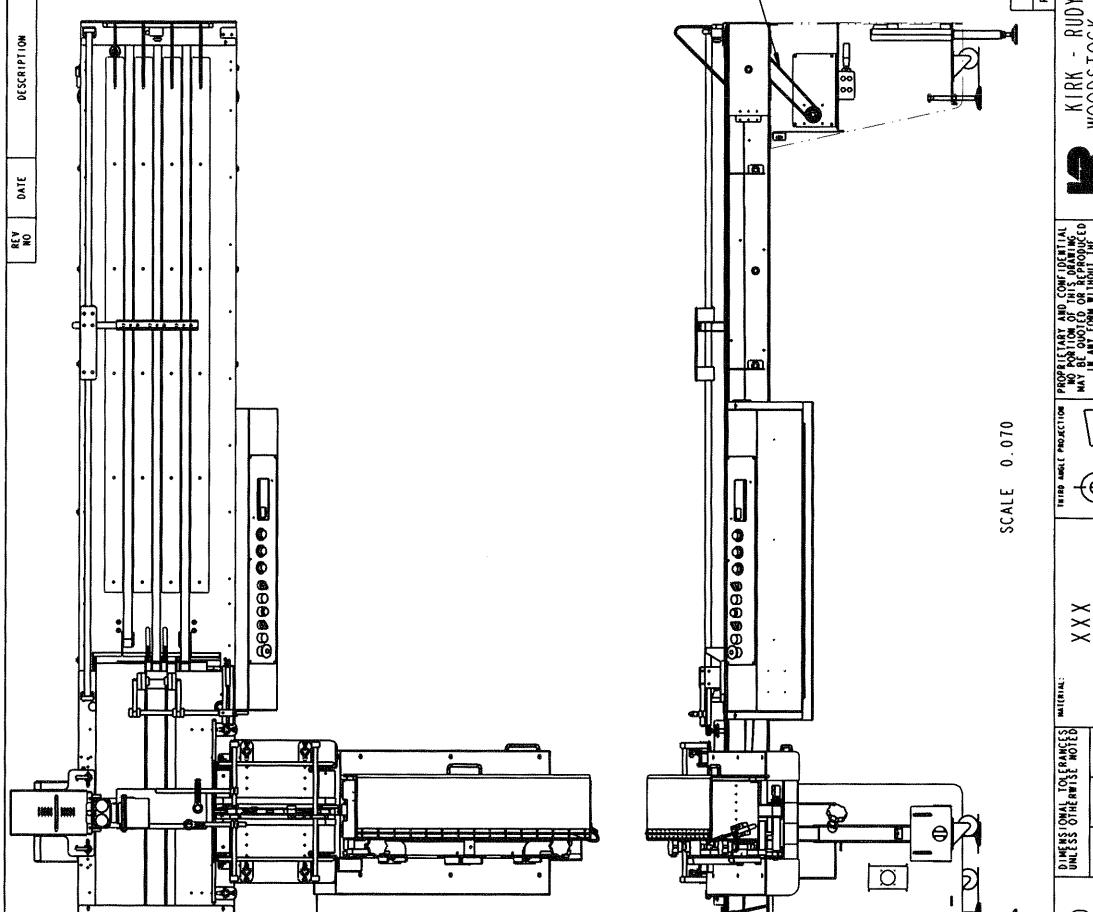
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DRAWING #

DRAWING #

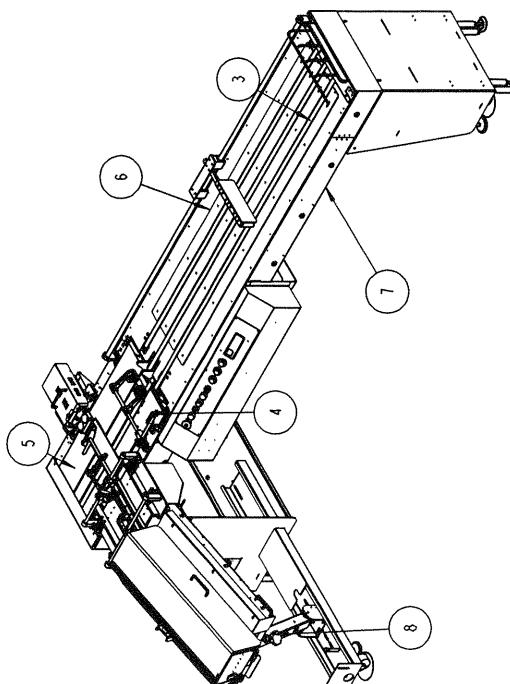
DRAWING # SA397-R

ITEM QTY	PART #	DESCRIPTION
1	110020-87	CHAIN, #35 X 32.00"
2	110020-88	CHAIN, #35 X 24.75"
3	111894-4	BELT, FLAT 1 X 158.00
4	541193-04	ASSY, PRODUCT ROLLERS RH
5	54284-04	ASSY, SINGLE SECTION RH
6	541454-05	ASSY, KR345 OUTFEED SECTION RH
7	544469-07	ASSY, CONVEYOR FRAME RH
8	546666-01	ASSY, TURNOVER + INFEEED



SCALE 0.070

DRAWN BY:		SCALE	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED		MATERIAL:	PRINTED WITH PROJECTION AND DRAWING COPIES ARE MADE IN THAT FORM WITH THE EXCEPTION OF WHEN PERMITTED WOODSTOCK, GA 30088 USA		REMOVED WHERE USED
TR. JG		0 . 050	IN	.000	XXX	IN	.000	XXX
CHECKED BY:		DATE	30 - Mar - 06	IN	.000	MM	-3	MM
TRACTED BY:		MASTER		REMOVED ALL BURRS AND SHARP EDGES. NO TOLLS. FINISH SURFACES AS SHOWN. DIMENTIONS NOT SCALE. WORK TO DIMENSIONS ONLY	XXX	TIME:	SA397	10F4



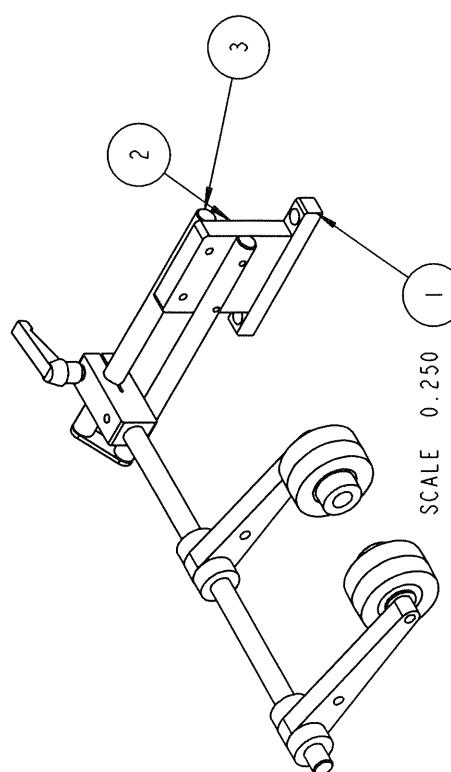
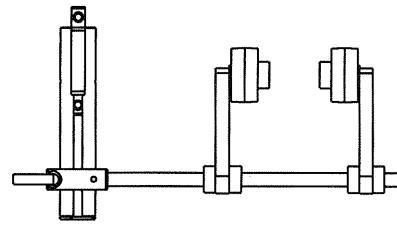
DRAWN BY:		SCALE	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED		MATERIAL:	PRINTED WITH PROJECTION AND DRAWING COPIES ARE MADE IN THAT FORM WITH THE EXCEPTION OF WHEN PERMITTED WOODSTOCK, GA 30088 USA		REMOVED WHERE USED
TR. JG		0 . 050	IN	.000	XXX	IN	.000	XXX
CHECKED BY:		DATE	30 - Mar - 06	IN	.000	MM	-3	MM
TRACTED BY:		MASTER		REMOVED ALL BURRS AND SHARP EDGES. NO TOLLS. FINISH SURFACES AS SHOWN. DIMENTIONS NOT SCALE. WORK TO DIMENSIONS ONLY	XXX	TIME:	SA397	10F4

DRAWN BY:		SCALE	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED		MATERIAL:	PRINTED WITH PROJECTION AND DRAWING COPIES ARE MADE IN THAT FORM WITH THE EXCEPTION OF WHEN PERMITTED WOODSTOCK, GA 30088 USA		REMOVED WHERE USED
TR. JG		0 . 050	IN	.000	XXX	IN	.000	XXX
CHECKED BY:		DATE	30 - Mar - 06	IN	.000	MM	-3	MM
TRACTED BY:		MASTER		REMOVED ALL BURRS AND SHARP EDGES. NO TOLLS. FINISH SURFACES AS SHOWN. DIMENTIONS NOT SCALE. WORK TO DIMENSIONS ONLY	XXX	TIME:	SA397	10F4

DRAWN BY:		SCALE	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED		MATERIAL:	PRINTED WITH PROJECTION AND DRAWING COPIES ARE MADE IN THAT FORM WITH THE EXCEPTION OF WHEN PERMITTED WOODSTOCK, GA 30088 USA		REMOVED WHERE USED
TR. JG		0 . 050	IN	.000	XXX	IN	.000	XXX
CHECKED BY:		DATE	30 - Mar - 06	IN	.000	MM	-3	MM
TRACTED BY:		MASTER		REMOVED ALL BURRS AND SHARP EDGES. NO TOLLS. FINISH SURFACES AS SHOWN. DIMENTIONS NOT SCALE. WORK TO DIMENSIONS ONLY	XXX	TIME:	SA397	10F4

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

REV NO	DATE	DESCRIPTION	ECN NO	BY

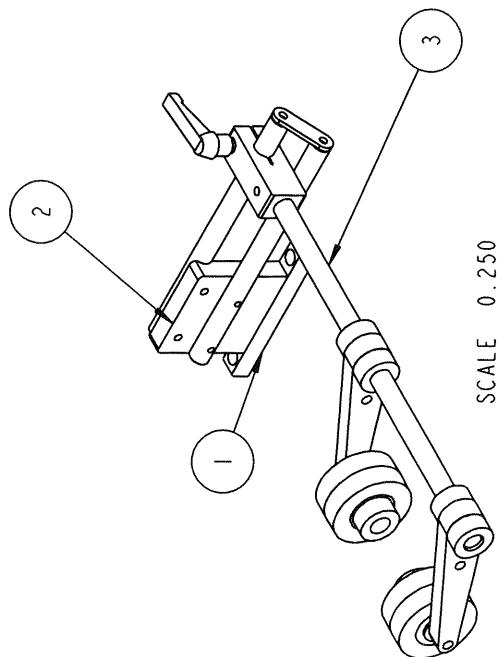
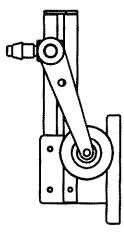
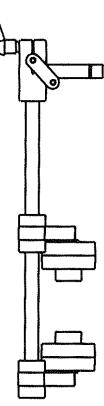
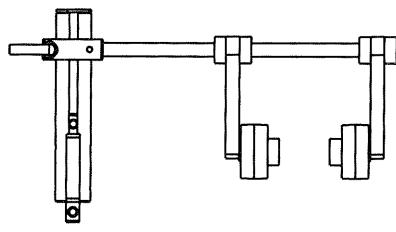


SCALE 0 . 250

DRAWN BY:	SCALE	MATERIAL:	THIRD ANGLE PROJECTION	PROPRIETARY AND CONFIDENTIAL
T JG	0 . 156	X X X		NO PORTION OF THIS DRAWING MAY BE QUOTED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC. WOODSTOCK, GA 30888 USA
CHECKED BY:	DATE	XX . XXX ANG.		KIRK - RUDY, INC. WOODSTOCK, GEORGIA
	07 - Apr - 05	.01 .005 .5		
TRACED BY:	MASTER	HEAT TREAT:	MODEL: SA341-1	TITLE: ASSY , PRODUCT ROLLERS LH
		X X X	SHEET NO: 1 OF 1	DRAWING #
		FINISH:		544193-03
		X X X		
		DO NOT SCALE - WORK TO DIMENSIONS ONLY		

ITEM	PART #	DESCRIPTION
1	1	5000794 PLATE-MOUNTING
2	1	544193-02 BAR, UPPER PRODUCT GUIDE MOUNT
3	1	544193-03 ASSY, ROLLER PRODUCT RH

REV NO	DATE	DESCRIPTION	ECN NO	BY



DRAWN BY:	T JG	SCALE	0 . 156	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	MATERIAL:	X X X	THIRD ANGLE PROJECTION	PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE QUOTED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC. WOODSTOCK, GA 30188 USA <th>REO'D WHERE USED</th>	REO'D WHERE USED
CHECKED BY:		DATE	08 - Aug - 05	.XX	.XXX	.01	.005	.5	ANG.
TRACED BY:	MASTER	FINISH:		HEAT TREAT:	X X X				MODEL: SA341-1
		FINISH:		REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED	X X X				SHEET NO. 10F1
		FINISH:		ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE WORK TO DIMENSIONS ONLY	X X X				TITLE: ASSY, PRODUCT ROLLERS RH DRAWING #

ITEM #	PART #	DESCRIPTION	REV NO	DATE	ECN NO	BT
1	2	SHIM, .315X .625X .094				
2	2	SHIM, .375X .625X .031				
3	4	BEARING, FLAT .375				
4	2	BEARING, HUB .625				
5	1	SPRKIT, 35B12 625B 188K				
6	1	BELT, FLAT 6 X 68-.75				
7	1	BELT, FLAT 1 X 68-.75*				
8	1	BELT, FLAT 2.25 X 62.00				
9	1	GROMMET, RUBBER .75IDX1.375ODX.56TH				
10	2	BLOCK, BEARING				
11	2	50494-9-3 TAKEUP, CLAMP BELT				
12	2	ROLLER, TRANSFER				
13	2	BLOCK, ADJUSTMENT ROLLER				
14	2	STUD, ROLLER IDLER				
15	1	54420-7-01 ASSY, LINEAR GUIDE BRACKET				
16	1	54428-5-02 TABLETOP, KR345 CENTER NO VAC				
17	1	54428-7-03 ASSY, IDLER SHAFT LH				
18	1	54429-5-01 ASSY, IDLER CONVEYOR BELT				
19	1	54429-8-01 SHAFT, ROLLER IDLER				
20	1	54445-1-01 ASSY, ROLLER DRIVER CROWNED				
21	1	54446-6-01 SHAFT, FRONT ROLLER				
22	1	544498-0-01 ASSY, SIDEGUIDE SHINGLE SECTION				
23	3	ENVELOPE-PROOF ENVELOPE, NO. 10				

DRAWING 1
 REV NO
 DATE
 DESCRIPTION
 ECN NO
 BT

1
 5A341
 REV D WHERE USED
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 WOODSTOCK, GEORGIA
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 WOODSTOCK, GA 30188 USA
 DRAWING 1
 5A341
 REV F
 544284-03

DRAWING 1
 5A341
 REV F
 544284-03

DRAWING 1
 T JG
 SCALE 0 .188
 DATE 04-Feb-05
 CHECKED BY: MASTERS
 DRAWN BY: MASTERS
 DIMENSIONS ARE
 IN MILLIMETERS
 FINISH SPECIFICATIONS
 NOT TO DIMENSIONS ONLY

DRAWING 1
 T JG
 SCALE 0 .125
 DATE 04-Feb-05
 CHECKED BY: MASTERS
 DRAWN BY: MASTERS
 DIMENSIONS ARE
 IN MILLIMETERS
 FINISH SPECIFICATIONS
 NOT TO DIMENSIONS ONLY

ITEM QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BT
1	102305	SHIM, .375X .625X .034					
2	102306	SHIM, .375X .625X .031					
3	103106	BEARING, FLAT .375					
4	103804	BEARING, HUB .625					
5	110742	SPRKT, 33B112 .625B .188K					
6	111839-5	BELT, FLAT 6 X 68.75					
7	111840-5	BELT, FLAT 1 X 68.75"					
8	111841-5	BELT, FLAT 2.25 X 62.00					
9	200513-5	GROMMET, RUBBER .75IDX .375ODX .56TH					
10	500819-2	BLOCK, BEARING					
11	2	504919-3					
12	2	507262-8					
13	2	536710-02					
14	2	538910-01					
15	1	544207-01					
16	1	544285-02					
17	1	544287-04					
18	1	544295-01					
19	1	544298-01					
20	1	544451-01					
21	1	544456-01					
22	1	544498-01					
23	3	ENVELOPE-PRODUCED ENVELOPE, NO. 10					

RECD WHERE USED

1	SA341
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OF KIRK-RUDY, INC., WOODSTOCK, GA, USA.

DATE: 08-AUG-05 **NOTES:** NONE

MAKER: SA341 **RECD:** ASSY, SHINGLE SECTION RH

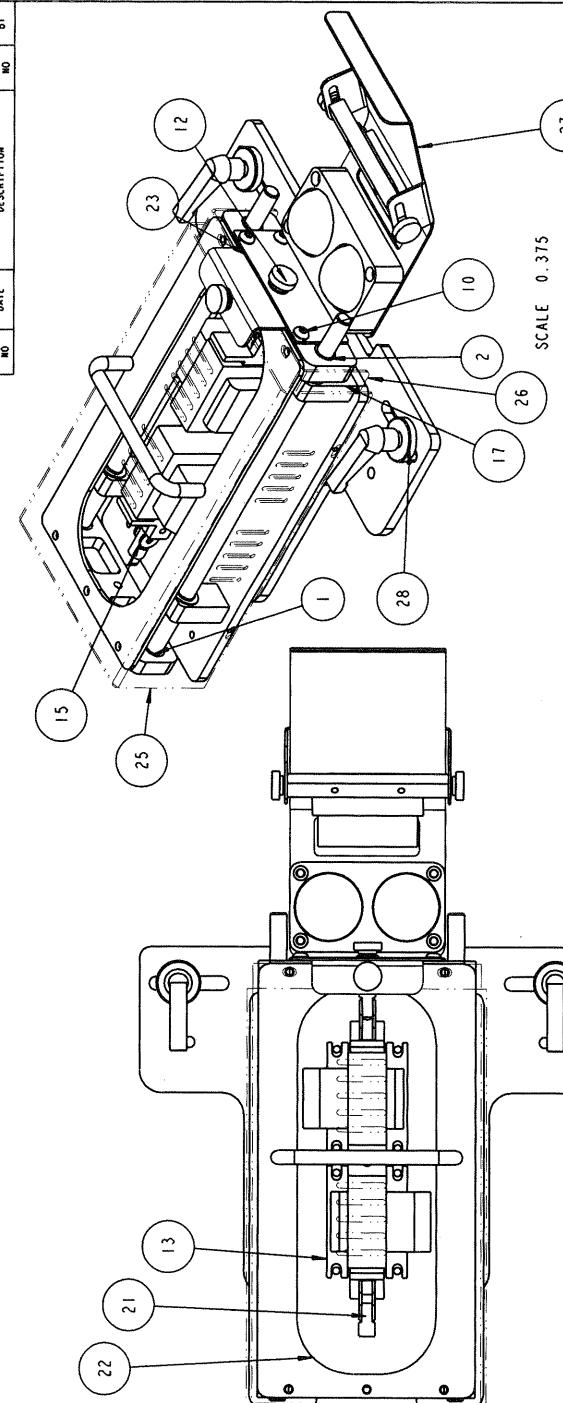
DRAWN BY: T J G **SCALE:** 0 .188 **MATERIAL:** DIMENSIONAL TOLERANCES NOTED

CHECKED BY: DATE: 08-AUG-05 **NOTE D:** NOTED

TRACED BY: SCALE: 0 .125 **NOTE E:** NOTED

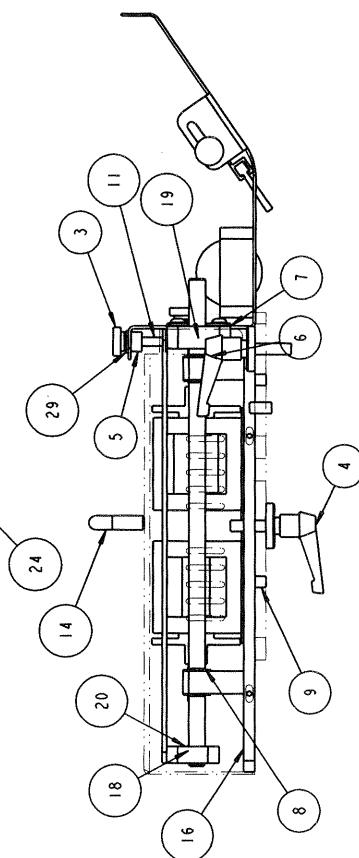
DRAWING #: 544207-01

ITEM/OPTY	PART #	DESCRIPTION	REV. NO	DATE	ECN NO	BT
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SCALE .0375

ITEM/OPTY	PART #	DESCRIPTION
1	100101	BUSHING, SL.375ID.50000.375LG
2	100129	BUSHING, SL.375ID.50000.500LG
3	102132	KNOB, 10-32 CAP SCREW
4	102140	HANDLE, RELEASE 1/4-20 X 1.0
5	102210	COLLAR, 188
6	102306	SHIM, .375X.625X.031
7	102575	SHIM, .250X.500X.010
8	104100	SNAFFLING, .375
9	105415	DOWEL, PIN .250X.500
10	106813	SCREW, BUTTON HEAD #10-32X.375
11	107406	SCREW, SHCS 10-32X1.250
12	107417	SCREW, SHCS 10-32X.375
13	190003	SOLENOID, 120VAC
14	190955	HANDLE
15	40CHA1NPLATE	#40 CHAIN LINK
16	544208-01	PLATE, LINEAR ACTUATOR
17	544209-01	BAR, LINEAR SHAFT MOUNT
18	544210-01	SHAFT, LINEAR GUIDE
19	544211-01	BAR, LINEAR GUIDE
20	544211-02	BAR, LINEAR GUIDE
21	544213-01	SHAFT, SOLENOID CONNECTOR
22	544214-01	PLATE, SOLENOID SLIDE
23	544217-01	PLATE, BRACKET RETAINER
24	544220-01	BRACKET, LINEAR ACTUATOR
25	544221-01	COVER, SOLENOID
26	544223-01	COVER, LINEAR SHAFT
27	544756-01	ASSY, PRODUCT STOP
28	SP6383-1	SPACER, GEAR COVER
29	WA006	WASHER, FLAT #10



ITEM/OPTY	SCALE	DATE	ECN NO	BT
1	0 .375	25 - Jul - 03		
2				
3				

RECD WHERE USED

ITEM/OPTY	SCALE	DATE	ECN NO	BT
1	0 .375	25 - Jul - 03		
2				
3				

RECD WHERE USED

ITEM/OPTY	SCALE	DATE	ECN NO	BT
1	0 .375	25 - Jul - 03		
2				
3				

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BY KIRK-RUDY, INC.

WOODSTOCK, GEORGIA

WOODSTOCK, GA 30092 USA

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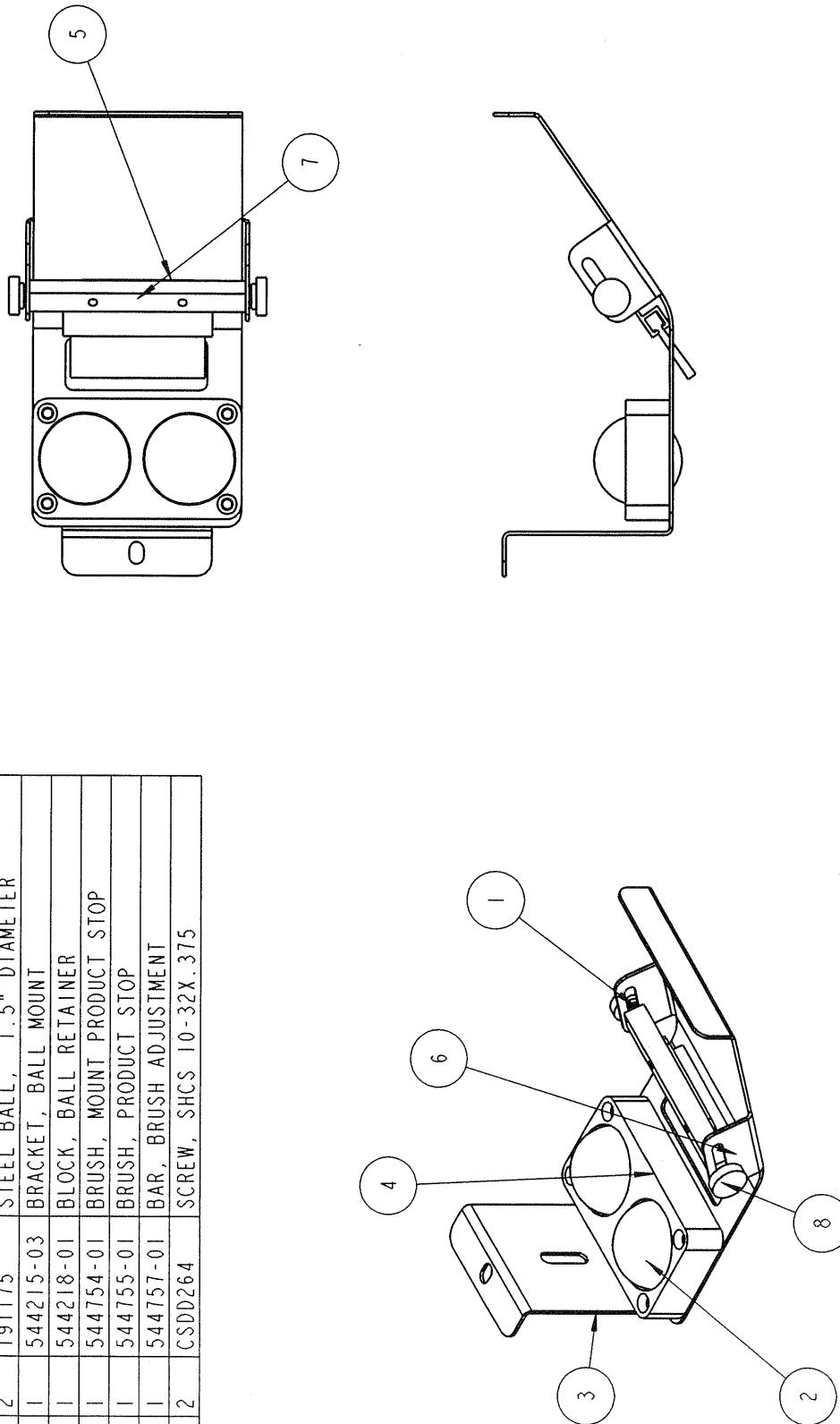
544207-01

ASSY, LINEAR GUIDE BRACKET

DRAWING #: 544207-01

ITEM	QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	2	102132	KNOB, 10-32 CAP SCREW					
2	2	191175	STEEL BALL, 1.5" DIAMETER					
3	1	544215-03	BRACKET, BALL MOUNT					
4	1	544218-01	BLOCK, BALL RETAINER					
5	1	544754-01	BRUSH, MOUNT PRODUCT STOP					
6	1	544755-01	BRUSH, PRODUCT STOP					
7	1	544757-01	BAR, BRUSH ADJUSTMENT					
8	2	CSD264	SCREW, SHCS 10-32X.375					

DRAWN BY:	SCALE	PART #	DESCRIPTION	REMOVED BY:	DATE	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	MATERIAL	FINISHES:	HEAT TREAT:
T J G	0 . 375					.XX .XXX .01 .005 .5	XXX	XXX	XXX
CHECKED BY:									
TRACED BY:									



REF'D	X	xxx
WHERE USED		
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THIRD ANGLE PROJECTION		
MODEL:	KR345	TITLE: ASSY, PRODUCT STOP
SHEET NO:	OF 1	DRAWING ■

ITEM QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	8	103112 BEARING, FLAT .750					
2	8	104103 SNAPRING, .750					
3	2	536770-01 BLOCK ADJUSTMENT, PINCH ROLLER					
4	3	544013-01 ROLLER, IDLER CROWNED					
5	1	544288-01 SHAFT, IDLER ROLLER					
6	1	544289-01 BRACKET, IDLER SHAFT MOUNT RH					
7	1	544289-02 BRACKET, IDLER SHAFT MOUNT LH					
8	1	544290-01 ROLLER, IDLER CROWNED					
9	2	544291-02 GUIDE, PRODUCT WEDGE					
10	1	544292-01 SHAFT, SPACER WEDGE					
11	1	544587-01 L-BRACKET, SPRING MOUNT					
12	1	CSDD237 SCREW, SHCS 8-32X .375					
13	1	CSDD238 SCREW, SHCS 8-32X .500					
14	1	CSDD239 SCREW, SHCS 8-32X .625					
15	2	CSDD265 SCREW, SHCS 10-32X .500					
16	3	HMSN09 NUT, HEX #8-32					

X XXX
REQ'D WHERE USED

DRAWN BY: T JG SCALE 0 .250 DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED

DATE	.01	.005	.5
04 - Feb - 05			

CHECKED BY:

MASTER TRACED BY:

THIRD ANGLE PROJECTION

MATERIAL: XXX	HEAT TREAT: XXX	FINISH: XXX
REMOVE ALL BURS AND SHARP EDGES UNLESS OTHERWISE NOTED		
ALL DIMENSIONS ARE FINISHED DIMENSIONS		
DO NOT SCALE - WORK TO DIMENSIONS ONLY		

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OF KIRK-RUDY, INC.,
KENNESAW, GA 3044 USA

KRK KIRK - RUDY, INC.
KENNESAW, GEORGIA

MODEL: SAA341 TITLE: ASSY, IDLER SHAFT LH

SHEET NO.: 0F1 DRAWING #

544287-03

ITEM	QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	8	103112	BEARING, FLAT .750					
2	8	104103	SNAPRING, .750					
3	3	106707	NUT, HEX #8-32					
4	2	107409	SCREW, SHCS 10-32X.500					
5	1	107413	SCREW, SHCS 8-32X.500					
6	1	107433	SCREW, SHCS 8-32X.375					
7	2	536770-01	BLOCK-ADJUSTMENT, PINCH ROLLER					
8	3	544013-01	ROLLER, IDLER CROWNED					
9	1	544288-01	SHAFT, IDLER ROLLER					
10	1	544289-01	BRACKET, IDLER SHAFT MOUNT RH					
11	1	544289-02	BRACKET, IDLER SHAFT MOUNT LH					
12	1	544290-01	ROLLER, IDLER CROWNED					
13	2	544291-02	GUIDE, PRODUCT WEDGE					
14	1	544292-01	SHAFT, SPACER WEDGE					
15	1	544587-01	L-BRACKET, SPRING MOUNT					
16	1	CSD0239	SCREW, SHCS 8-32X.625					

DRAWN BY: T JG SCALE: 0 . 250 MATERIAL: XXX
 DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED
 .01 .005 .5 ANG.

CHECKED BY: DATE: 08 - Aug - 05 HEAT TREAT: XXX
 REMOVE ALL BURRS AND
 SHARP EDGES UNLESS
 OTHERWISE NOTED

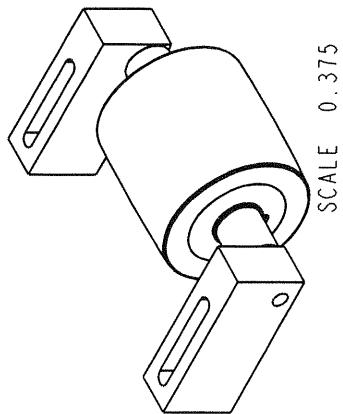
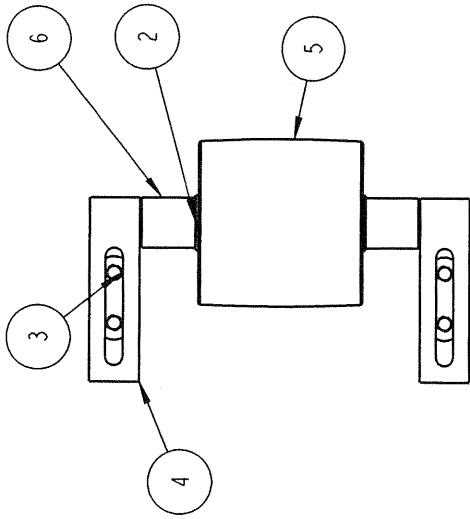
TRACED BY: MASTER FINISH: XXX
 ALL DIMENSIONS ARE
 FINISHED DIMENSIONS
 DO NOT SCALE - WORK
 TO DIMENSIONS ONLY

THIRD ANGLE PROJECTION
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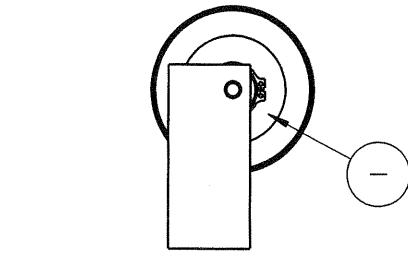
MODEL: S A 34 | TITLE: ASSY, IDLER SHAFT RH
 SHEET NO. 1 OF 1 DRAWING ■

X XXX
 REV'D WHERE USED

ITEM QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	2	103112 BEARING, FLAT .750					
2	2	104103 SPRING, .750					
3	2	542147-02 BAR, THREADED BELT TAKEUP					
4	2	544041-01 BRACKET, IDLER SHAFT MOUNT					
5	1	544296-01 ROLLER, IDLER CROWNED					
6	1	544297-01 SHAFT, IDLER ROLLER					

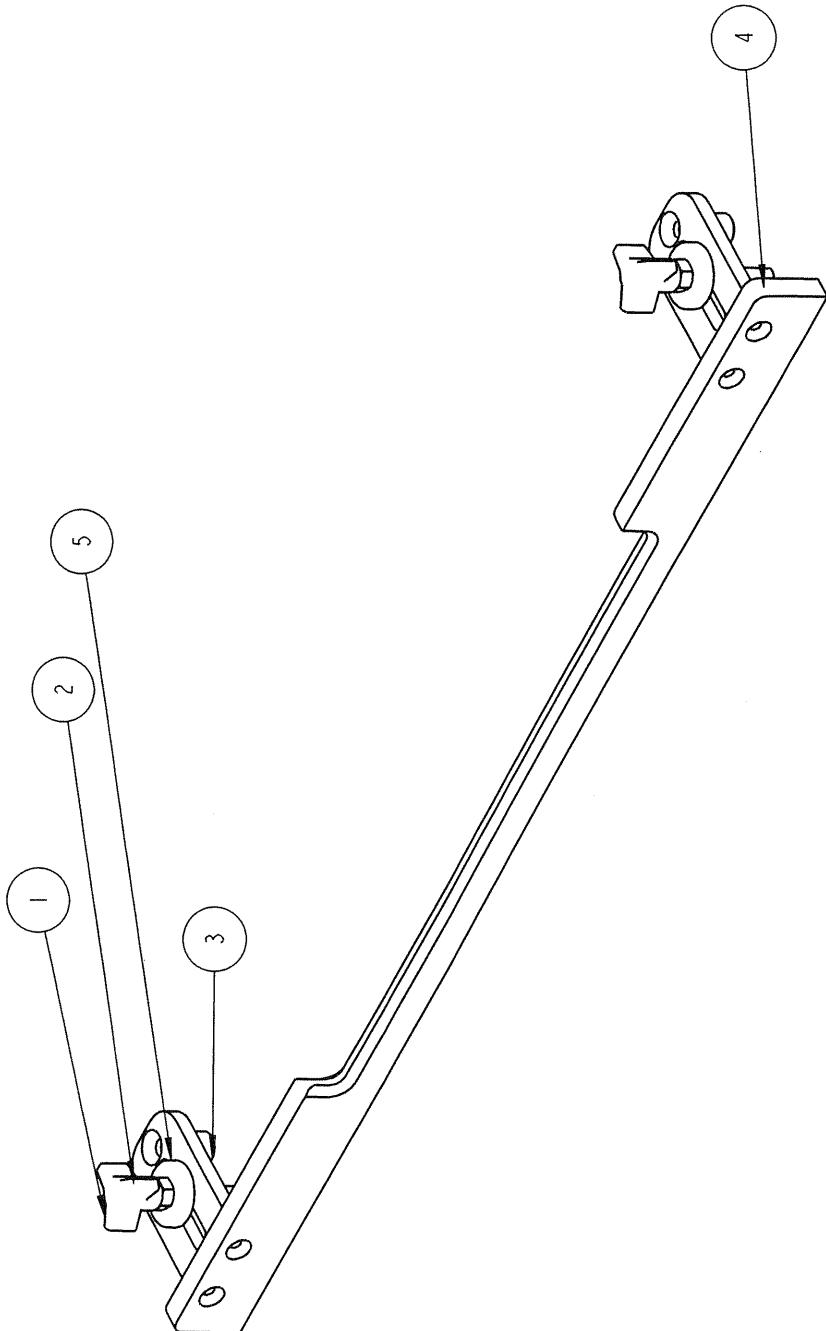


SCALE 0.375



DRAWN BY: T JG	SCALE 0 . 375	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED			MATERIAL: NOTED	THRO ANGLE PROJECTION PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE COPIED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN CONSENT OF KIRK-RUDY INC., USA KENNESAW, GA 3044 USA	REO'D KR345 WHERE USED
CHECKED BY:	DATE 28 - Ju l - 03	.005	.01	.005	HEAT TREAT: NONE	MODEL: SA184	TITLE: ASSY, IDLER CONVEYOR BELT
TRACED BY:	MASTER	FINISH: ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY			FINISH: NOTED	SHEET NO.: 0F1	DRAWING # 544295-01

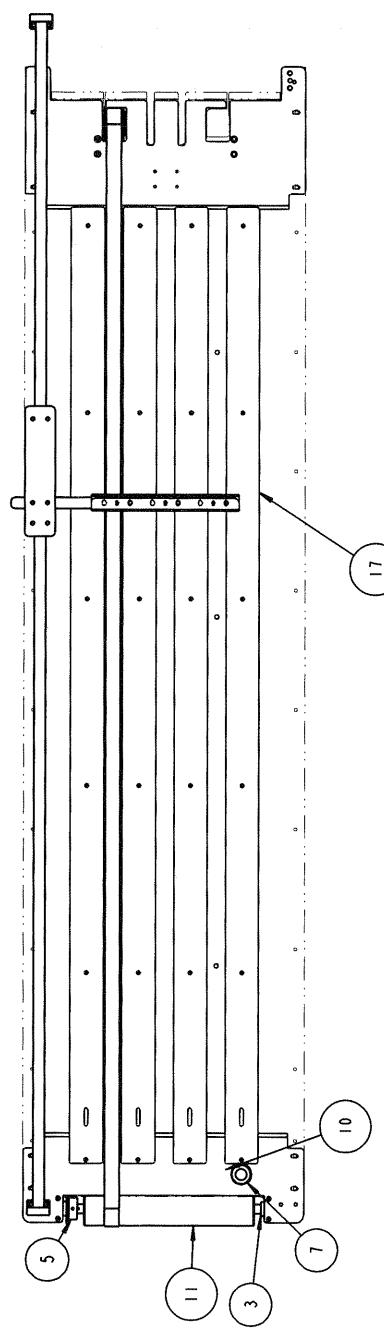
ITEM QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	2	500790-1 ASSY, TRI-KNOB 1/4-20 STUD					
2	2	541709-01 BRACKET, SIDEGUIDE					
3	2	541710-01 SPACER, SIDEGUIDE MOUNT					
4	1	544499-01 SIDEGUIDE, INFEED KR345					
5	2	SP6383-1 SPACER, GEAR COVER					



DRAWN BY:	T JG	SCALE:	0 . 375	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	MATERIAL: N/A	THIRD ANGLE PROJECTION NO POSITION OF THIS DRAWING MAY BE QUOTED OR REPRODUCED IN ANY FORM, WHETHER REDUCED OR ENLARGED, WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC., KENNESAW, GA 30144, USA	REO'D WHERE USED
CHECKED BY:		DATE:	29 - JUL 1 - 03	.xx .xxx ANG. .01 .005 .5	HEAT TREAT: N/A	MODEL: SA184	ASSY, SIDEGUIDE SHINGLE SECTION
TRACED BY:	MASTER			REMOVE ALL BURRS AND SHARP EDGES, UNLESS OTHERWISE NOTED ALL DIMENSIONS ARE FINISHED DIMENSIONS	FINISH: N/A	SHEET NO: 10F1	DRAWING #: 544498-01
				DO NOT SCALE - WORK TO DIMENSIONS ONLY			

ITEM QTY	PART #	DESCRIPTION
1	2	102627 SPRING, EXTENSION
2	2	103112 BEARING, FLAT .750
3	2	103804 BEARING, HUB .655
4	2	104103 SNAPPING .750
5	1	110234 SPRKT. 33816 .655B .188K
6	1	111833-1 BELT, FLAT 1 X 152.25
7	1	200513-5 GROMMET, RUBBER .751DX1 .3750DX .561H
8	2	500819-2 BLOCK, BEARING
9	2	53060-0-01 ASSY, TAKEUP IN BELT
10	1	530610-02 ASSY, TAKEUP IN BELT
11	1	530616-01 ASSY, ROLLER FRONT DRIVE
12	1	533915-03 BRACKET, IDLER SHAFT MOUNT
13	1	544013-01 ROLLER, IDLER CROWNED
14	1	544051-01 SHAFT, IDLER ROLLER
15	1	544455-03 TABLETOP, OUTFEED CENTER
16	1	544459-04 ASSY, BACKSTOP LH
17	4	544461-02 GUIDE, BELT TABLETOP
18	1	544490-01 BRACKET, SPRING MOUNT
19	1	544491-01 SHAFT, FRONT ROLLER
20	1	548494-01 BRACKET, TAKEUP BLOCK SPACER
21	1	548495-01 BRACKET, TAKEUP BLOCK SPACER

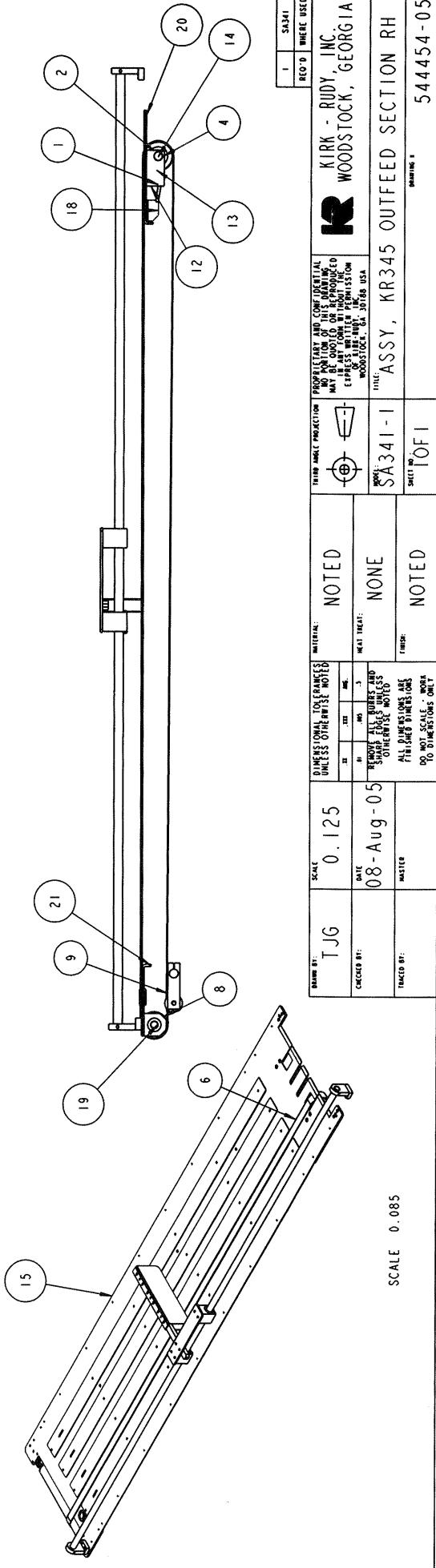
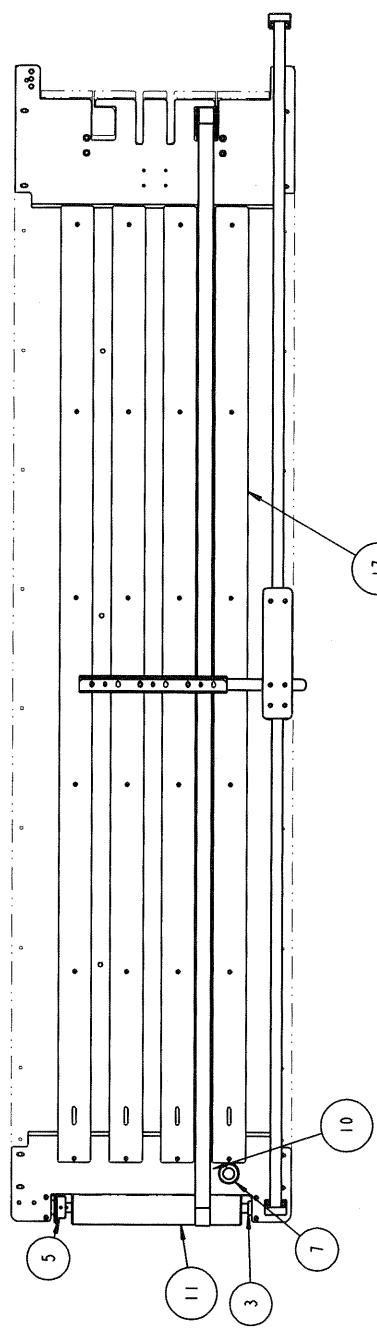
ITEM QTY	REV NO	DATE	DESCRIPTION	ECN NO	BT
1					



PROPRIETARY AND CONFIDENTIAL NO PART OF THIS DRAWING MAY BE COPIED OR REPRODUCED EXCEPT WRITTEN PERMISSION GIVEN BY KIRK-RUDY, INC., WOODSTOCK, GA, USA.		REF'D SHEET USED	
KIRK - RUDY, INC. WOODSTOCK, GEORGIA		SHEET 1 OF 4	
ASSY, KR345 OUTFEED SECTION LH		SCALE 0.085	
NAME: T JG DATE: 07-Apr-05		DIMENSIONAL OR FINISHES UNLESS OTHERWISE NOTED	
CHECKED BY:		IN	MM
TRACED BY:		IN	MM
MASTER		NOTED	
NOTE: ALL SURFACES SHALL BE POLISHED UNLESS OTHERWISE NOTED ALL DIMENSIONS ARE TO INCHES. INCHES TO MM. MM TO INCHES ONLY		NOTE: HEAT TREAT: NONE	

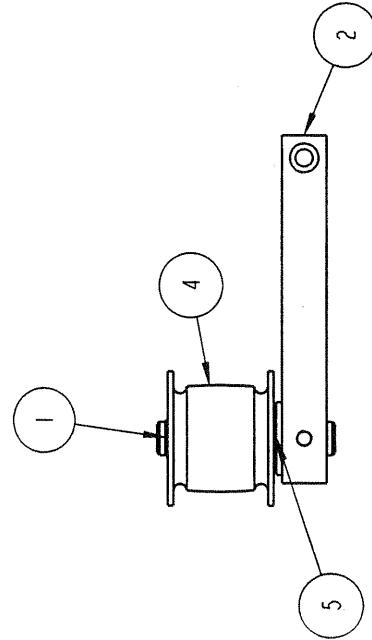
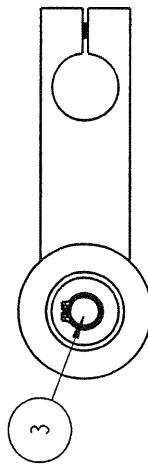
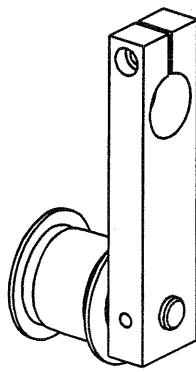
DRAWING #: 544454-05

ITEM QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO
1	2	102627 SPRING, EXTENSION				67
2	2	103112 BEARING, FLAT .750				
3	2	103804 BEARING, HUB .625				
4	2	104103 SPRING, .750				
5	1	110234 SPRKT. 35B16 .625B .188K				
6	1	111833-2 BELT, FLAT 1 X 152.25				
7	1	200513-5 GROMMET, RUBBER .751DX1 .3750DX .561H				
8	2	500819-2 BLOCK, BEARING				
9	2	530600-01 ASSY, TAKEUP I IN BELT				
10	1	530610-02 ASSY, TAKEUP I IN BELT				
11	1	530616-01 ASSY, ROLLER FRONT DRIVE				
12	1	533915-03 BRACKET, IDLER SHAFT MOUNT				
13	1	544013-01 ROLLER, IDLER CROWNED				
14	1	544051-01 SHAFT, IDLER ROLLER				
15	1	544455-03 TABLETOP, OUTFEED CENTER				
16	1	544459-03 ASSY, BACKSTOP RH				
17	4	544461-02 GUIDE, BELT TABLETOP				
18	1	544490-01 BRACKET, SPRING MOUNT				
19	1	544491-01 SHAFT, FRONT ROLLER				
20	1	548494-01 BRACKET, TAKEUP BLOCK SPACER				
21	1	548495-01 BRACKET, TAKEUP BLOCK SPACER				



1	SA31	REO'D WHERE USED
KIRK - RUDY, INC.		
WOODSTOCK, GEORGIA		
DATE:	08-AUG-05	PRINTED:
CHECKED BY:		SA341-1
TRACED BY:	MASTER	SECTION:
SCALE:	0.085	544454-05

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



I	GEN
REQ'D	WHERE USED

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

TITLE: ASSY, TAKEUP IN BELT

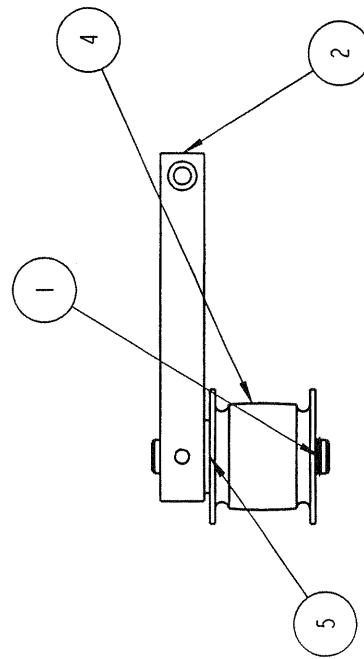
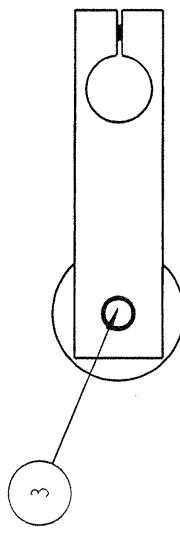
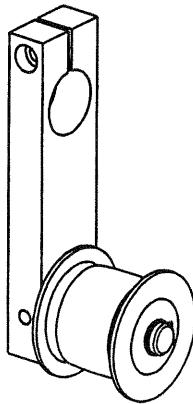
MODEL: XXX

SHEET NO.: 0F1

DRAWING #: 530610-01

DRAWN BY: TVK	SCALE 0 . 500	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. WOODSTOCK, GA 30188 USA
CHECKED BY:	DATE 26-May-98	.xx	.xxx	ANG. .01	.005	.5	HEAT TREAT:
TRACED BY:	MASTER	REMOVE ALL BURS AND SHARP EDGES UNLESS OTHERWISE NOTED		N / A	FINISH: ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY		

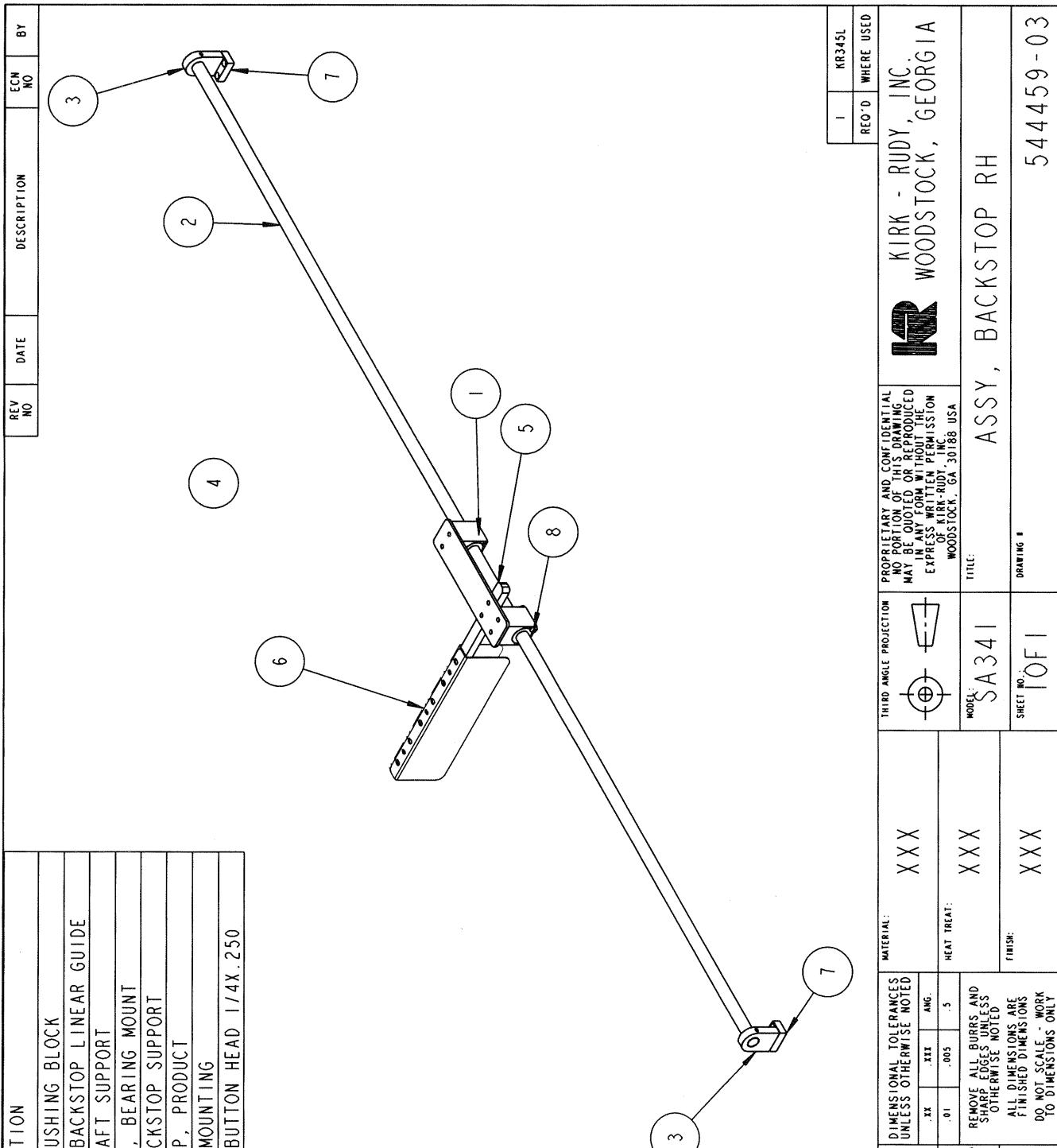
ITEM	QTY	PART #	DESCRIPTION	ECN NO	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	1	104100	SNAPRING, .375						
2	1	504949	ARM BELT TIGHTENER						
3	1	504988-1	SHAFT, BELT TIGHTENER						
4	1	510611A	ASSY-ROLLER						
5	1	WA013	WASHER, FLAT 3/8						



I	GEN	REO'D	WHERE USED
1			
KIRK - RUDY, INC.			
RR WOODSTOCK, GEORGIA			
PROPRIETARY AND CONFIDENTIAL			
NO PORTION OF THIS DRAWING			
MAY BE QUOTED OR REPRODUCED			
IN ANY FORM WITHOUT THE			
EXPRESS WRITTEN PERMISSION			
OF KIRK-RUDY, INC.			
WOODSTOCK, GA 30188 USA			
THRO ANGLE PROJECTION			
MODEL: XXX			
SHEET NO.: 0F1			DRAWING #
ASSY, TAKEUP IN BELT			

DRAWN BY:	SCALE	MATERIAL:	
TVK	0.500	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	XXX
		.XX	.XX
		.01	.005
		ANG.	.5
CHECKED BY:	DATE	HEAT TREAT:	
	26-May-98	NONE	
TRACED BY:	MASTER	FINISH:	
		N/A	
		ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE " WORK TO DIMENSIONS ONLY	

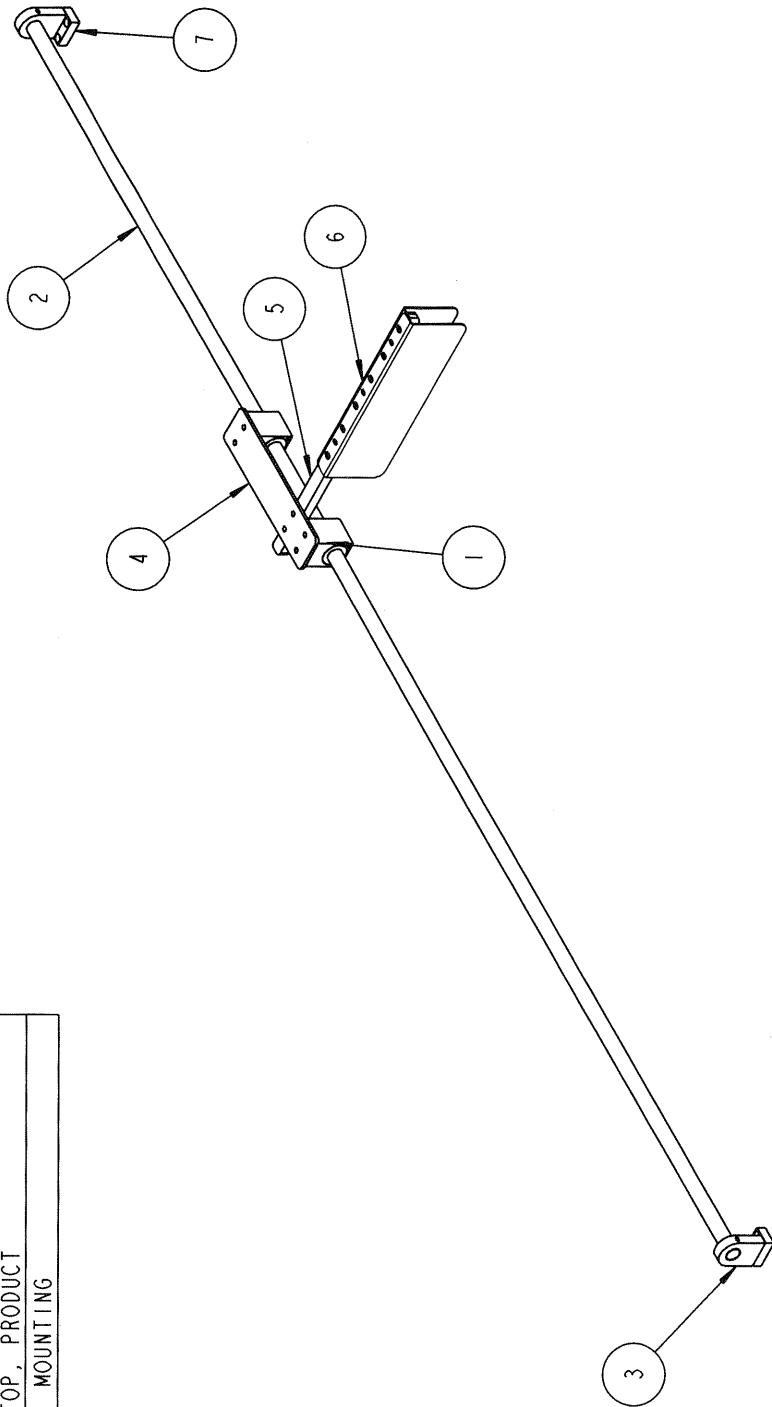
ITEM	QTY	PART #	DESCRIPTION
1	2	537280-01	ASSY, BUSHING BLOCK
2	1	544460-02	SHAFT, BACKSTOP LINEAR GUIDE
3	2	544461-01	BAR, SHAFT SUPPORT
4	1	544462-01	BRACKET, BEARING MOUNT
5	1	544463-01	BAR, BACKSTOP SUPPORT
6	2	544464-02	BACKSTOP, PRODUCT
7	2	544465-01	PLATE, MOUNTING
8	4	CSEF63	SCREW, BUTTON HEAD 1/4X.250



DRAWN BY:	SCALE	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	MATERIAL:	THIRD ANGLE PROJECTION	RECD WHERE USED
T JG	0.125	.XX .XXX .01 .005 .5	X X X HEAT TREAT: FINISH:	KIRK RUDY INC. WOODSTOCK, GEORGIA	I KR345L
CHECKED BY:	DATE		X X X	ASSY, BACKSTOP RH	
TRACED BY:	MASTER		X X X	DRAWING # 544459-03	

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

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



ITEM	REV NO	DATE	DESCRIPTION	ECN NO	BY

1	SA341-1
RECD	WHERE USED

KIRK - RUDY, INC.
WOODSTOCK, GEORGIA

THIRD ANGLE PROJECTION
PROPRIETARY AND CONFIDENTIAL
NO PORTION OF THIS DRAWING
MAY BE ODED OR REPRODUCED
IN ANY FORM, WHOLLY OR IN PART,
EXPRESS WRITTEN CONSENT
OF KIRK - RUDY, INC.,
WOODSTOCK, GA 30188 USA

ASSY, BACKSTOP LH

MODEL: SA341-1
TITLE:

SHEET NO. 1 OF 1
DRAWING #

DRAWN BY:	SCALE	MATERIAL:	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	THIRD ANGLE PROJECTION
T JG	0 . 125	XXX	.XX .XXX .01 -.005 .5 ANG.	⊕ - - - ⊕
CHECKED BY:	DATE	HEAT TREAT:	XXX	⊕
- Apr - 06				
TRACED BY:	MASTER	FINISH:	XXX	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY

544459-04

ITEM / QTY	PART #	DESCRIPTION	REV	DATE	DESCRIPTION	REV	DATE
1	15	BOLT, HEX HEAD 5/16-18X .75	A0		ROD CONTROL PANEL TO POSITION	B1	
2	1	110332	SPRKT, 35B11 .625B .188K		TO POSITION, 1 INCHES		1.16
3	1	110442	SPRKT, 35B12 .625B .188K				
4	5	190320	CASTER-2.5IN, SWIVEL				
5	5	190334	FOOT MOUNTING				
6	1	190619-1	PLATE, NAME				
7	1	191029-1	PUMP, MOYOTEC PB4612FC				
8	1	20263-7	SENSOR, PERFECT PROX				
9	5	501812-1	LEG, LEVELING				
10	1	530441-05	BOX, ELECTRICAL INLET 20A				
11	1	530515-06	WELDMENT, CONVEYOR OUTFD GUARD				
12	1	530375-12	WELDMENT, CONVEYOR OUTFD GUARD				
13	1	530159-08	ROD, HOLDER				
14	4	530160-01	ROD, STOP				
15	2	537558-02	BAR, PLATE SPLICE				
16	2	538171-04	ASSY, 1/4HP GEARHEAD W/CLUTCH				
17	2	539224-01	ASSY, RH HYDRAULIFT LEG				
18	2	539225-01	ASSY, LH HYDRAULIFT LEG				
19	1	544091-02	WLDMT, SHELF MAIL TRAY				
20	1	54402-02	WLDMT, CONVEYOR LEG				
21	1	544102-03	WLDMT, LEG KR345/TURNOVER				
22	1	544165-01	COVER, CHAIN LEG				
23	1	544165-02	COVER, CHAIN LEG				
24	1	544222-01	BRACKET, SHAFT MOUNT				
25	1	544223-01	SHAFT, REAR SUPPORT				
26	1	544335-02	ASSY, CONTROL PANEL KR345				
27	2	544666-02	BAR, TABLETOP MOUNT				
28	2	544666-03	BAR, TABLETOP MOUNT				
29	1	544710-03	CHANNEL, CONVEYOR CABINET RH				
30	1	544710-04	CHANNEL, CONVEYOR CABINET LH				
31	1	544710-05	CHANNEL, CONVEYOR CABINET RH				
32	1	544710-06	CHANNEL, CONVEYOR CABINET LH				
33	8	544712-01	SHAFT, FRAME SPACER				
34	1	54474-02	BRACKET, CONTROL BOX MOUNT				
35	1	544869-01	PANEL, ELECTRICAL KR345				
36	1	544517-01	COVER, E-BOX KR345				
37	1	544518-01	COVER, E-BOX HOLE				
38	2	548193-01	SPACER, STRIP TABLETOP				
39	3	548196-01	BRACKET, TABLETOP SUPPORT				
40	6	548197-01	BLOCK, SHAFT CLAMP				
41	1	548668-01	WLDMT, BRACKET 345/CMC 400				
42	2	548684-01	BAR, LEG SPACER				
43	1	548689-01	SPACER, CASTER				
44	1	MAIL-TRAY	MAIL TRAY				
45	15	WA012	WASHER, FLAT 5/16				

ITEM #:	T JG	SCALE	0 .050	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	XXXX	TRIM MARK PROJECTION	PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE COPIED OR REPRODUCED WITHOUT PERMISSION OF KIRK-RUDY INC., VICKSBURG, MISSISSIPPI, USA
CHECKED BY:		DATE		xx	xx	xx	
INSTRUMENTS USED:				xx	xx	xx	
RECHECKED BY:				xx	xx	xx	
SET UP BY:				xx	xx	xx	
REMOVED BY:				xx	xx	xx	
RECORDED BY:				xx	xx	xx	
RECORDED DATE:				xx	xx	xx	
RECORDED BY:				xx	xx	xx	
RECORDED DATE:				xx	xx	xx	

1 SA397

1 RECORD WHERE USED

1 ASSY, CONVEYOR FRAME LH

1 DRAWING # 544469-06

ITEM #	PART #	DESCRIPTION	REV NO.	DATE	DESCRIPTION	REV NO.	DATE
1	15	107336	BOLT, HEX HEAD 5/16-18X .75				
2	1	110732	SPRKIT, 35B11 .625B .188K				
3	1	110742	SPRKIT, 35B12 .625B .188K				
4	5	190620	CASTER- 2.5IN, SWIVEL				
5	5	190634	FOOT, MOUNTING				
6	1	190619-1	PLATE, NAME				
7	1	191029-1	PUMP, MOVOTEC PB4612FC				
8	1	20263-7	SENSOR, PERFECT PROX				
9	5	501812-1	LEG, LEVELING				
10	1	530441-05	BOX, ELECTRICAL INLET 20A				
11	1	530515-06	WELDMENT, CONVEYOR OUTFD GUARD				
12	1	530515-12	WELDMENT, CONVEYOR OUTFD GUARD				
13	1	530759-08	ROD, HOLDER				
14	4	530160-01	ROD, STOP				
15	2	537638-02	BAR, PLATE SPLICE				
16	2	538111-04	ASSY, 1/4HP GEARHEAD W/CLUTCH				
17	2	539424-01	ASSY, RH HYDRALIFT LEG				
18	2	539425-01	ASSY, LH HYDRALIFT LEG				
19	1	54402-02	WLDMT, CONVEYOR LEG				
20	1	54402-04	WLDMT, LEG KR345/TURNOVER RH				
21	1	54465-01	COVER, CHAIN LEG				
22	1	544222-01	BRACKET, SHAFT MOUNT				
23	1	544223-01	SHAFT, REAR SUPPORT				
24	1	544335-02	ASSY, CONTROL PANEL KR345				
25	2	544466-02	BAR, TABLETOP MOUNT				
26	2	544466-03	BAR, TABLETOP MOUNT				
27	1	544410-03	CHANNEL, CONVEYOR CABINET RH				
28	1	544410-04	CHANNEL, CONVEYOR CABINET LH				
29	1	544410-05	CHANNEL, CONVEYOR CABINET RH				
30	1	544410-06	CHANNEL, CONVEYOR CABINET LH				
31	8	544412-01	SHAFT, FRAME SPACER				
32	1	544414-02	BRACKET, CONTROL BOX MOUNT				
33	1	544489-01	PANEL, ELECTRICAL KR345				
34	1	544517-01	COVER, E-BOX KR345				
35	1	544518-01	COVER, E-BOX HOLE				
36	2	54893-01	SPACER, STRIP TABLETOP				
37	3	548496-01	BRACKET, TABLETOP SUPPORT				
38	6	548497-01	BLOCK, SHAFT CLAMP				
39	1	548568-01	WLDMT, BRACKET 345/CMC 400				
40	2	548884-01	BAR, LEG SPACER				
41	1	548889-01	SPACER, CASTER				
42	15	WA012	WASHER, FLAT S/16				

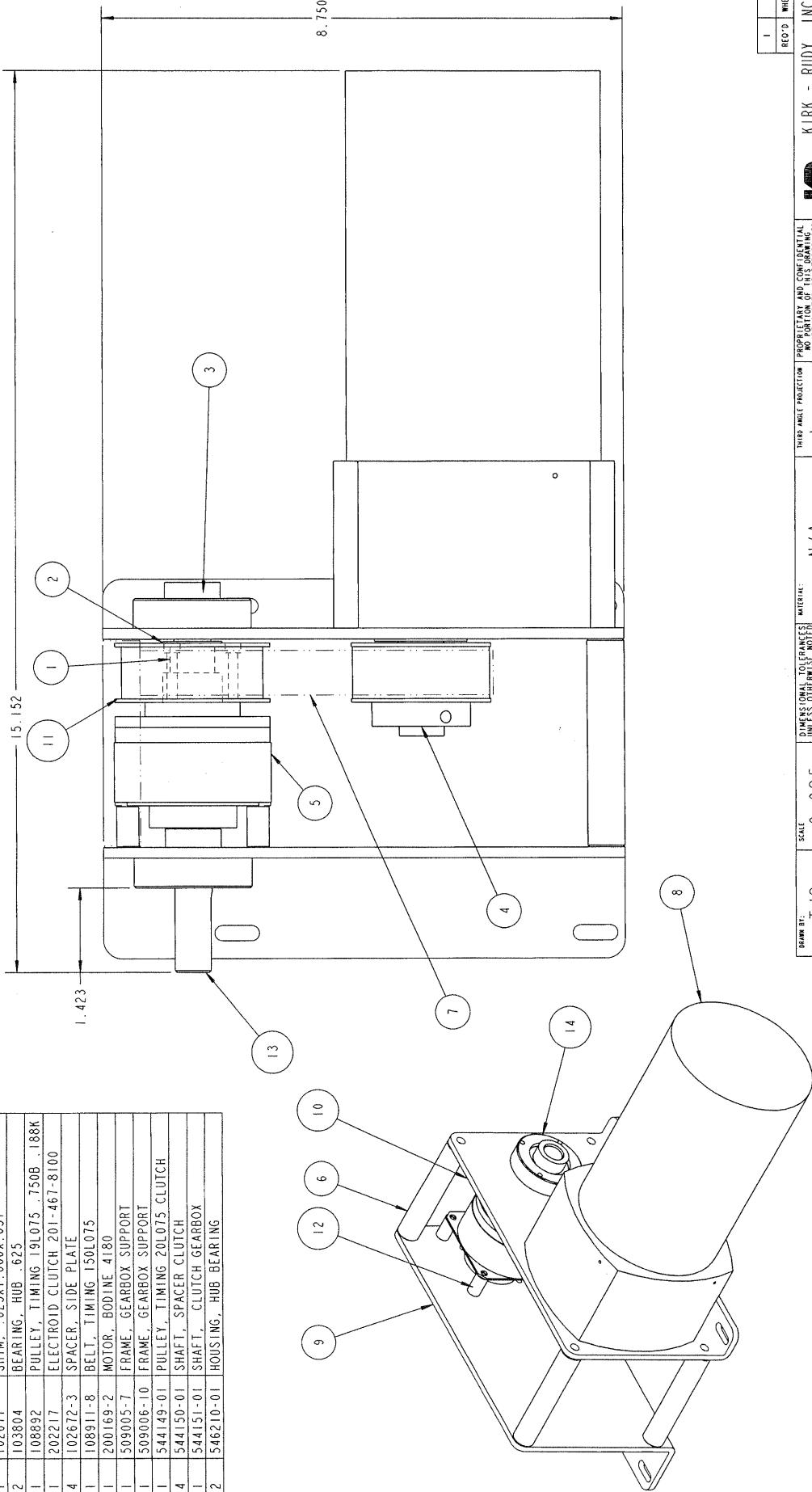
1	SAR17-8
REO 0	WHERE USED
KIRK - RUDY, INC	
KIRK - RUDY, INC	
WOODSTOCK, GEORGIA	
WOODSTOCK, GA, 30098 USA	
TELEPHONE: 404-929-3977	
FAX: 404-929-3977	
E-MAIL: ASSY, CONVEYOR FRAME RH	
DRAWING # 544469-07	

NAME BY:	T JG	SCALE	0 . 050
DATE:	08 Aug -05	UNITS:	XX
CHECKED BY:		XX	XX
TRACED BY:	MASTER	XX	XX
REMARKS:	ALL DIMENSIONS ARE IN INCHES. NO. OF SECTIONINGS	XX	XX

DRAWING #

538171-04

ITEM QTY	PART #	DESCRIPTION	REV NO	DATE	EGN NO	BT
1	1	100258 BUSHING, SL. 625 ID. 7500D 500LG				
2	1	102671 SEAL, 625A-.0001N. 031				
3	2	103804 BEARING, HUB .625				
4	1	108992 PULLEY, TIMING 19L075 .750B .188K				
5	1	202217 ELECTROD CLUTCH 201-467-8100				
6	4	102672-3 SPACER, SIDE PLATE				
7	1	108911-8 BELT, TIMING 150L075				
8	1	200169-2 MOTOR, BODINE 4180				
9	1	509005-7 FRAME, GEARBOX SUPPORT				
10	1	509006-10 FRAME, GEARBOX SUPPORT				
11	1	544149-01 PULLEY, TIMING 20L015 CLUTCH				
12	4	544150-01 SHAFT, SPACER CLUTCH				
13	1	544151-01 SHAFT, CLUTCH GEARBOX				
14	2	546210-01 HOUSING, HUB BEARING				



DRAWN BY:	T JG	SCALE:	0 .625	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	MATERIAL:	N/A	THIRD ANGLE PROJECTION	PROPRIETARY AND CONFIDENTIAL NO COPIES OF THIS DRAWING MAY BE MADE IN WHOLE OR PART EXCEPT AS SPECIFIED IN THE EXCLUSIVELY HELD TRADE SECRET REGISTRATION DOCUMENT WOODSTOCK, GA 30188 USA
CHECKED BY:		DATE:	05 - May - 03	IN.	.01	NET	SHARP EDGES AND SHARP EDGES UNLESS OTHERWISE NOTED	ASSY, 1/4HP GEARHEAD W/CLUTCH
TRACED BY:		MASTER:	M	IN.	.01	NET	ALL DIMENSIONS ARE IN INCHES UNLESS NOTED DO NOT SCALE DRAWINGS DO NOT STRETCH DRAWINGS	538171-04
							1 OF 1	KIRK-RUDY, INC. WOODSTOCK, GEORGIA

SCALE 0.375

REC'D WHERE USED

1 K8345

ITEM QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECON NO	BY
1	102792	SPRING, EXTENSION					
2	191029-2	CYLINDER, LIFT CB415					
3	191029-3	GLIDE, SUSPA					
4	537371-01	BRACKET, SPRING RETURN MOUNT					
5	537596-01	BLOCK, HYDRAULIC LIFT LH					
6	537597-01	BRACKET, HYDRAULIC LIFT SPRING					

10-32 CAP SCEW X .625 LONG
4 PLACES

DRAWN BY: A KEY SCALE 0 .375 DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED MATERIAL: N/A

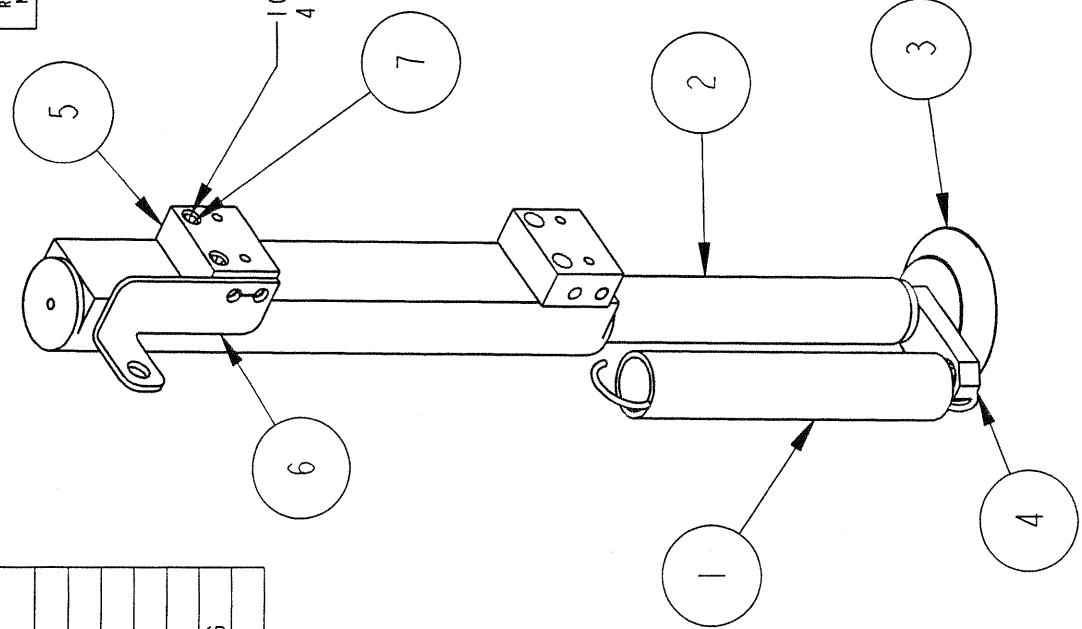
DATE 26-JUL-00	.01	.005	.5	HEAT TREAT: N/A
REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED				FINISH: N/A
ALL DIMENSIONS ARE IN INCHES				DO NOT SCALE - WORK TO DIMENSIONS ONLY

CHECKED BY: TRACED BY: MASTER

REPROD WHERE USED

2	SP84700
ASSY , RH HYDRALIFT LEG	
SHEET NO: OF 1	DRAWING ■ 539424-01

ITEM QTY	PART #	DESCRIPTION
1	102792	SPRING, EXTENSION
2	191029-2	CYLINDER, LIFT CB415
3	191029-3	GLIDE, SUSPA
4	537371-01	BRACKET, SPRING RETURN MOUNT
5	537596-01	BLOCK, HYDRAULIC LIFT LH
6	537597-02	BRACKET, HYDRAULIC LIFT SPRING
7	CSDD266	SCREW, SHCS 10-32X .625



DRAWN BY:	SCALE	KEY	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	MATERIAL:	REMOVED ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED	DATE	MASTER	TRACED BY:	REMOVED ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED	ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY	RECD WHERE USED	
A	0 . 375		.01 -.005 .5	N / A		26 - JUL - 00					2	SP84700
CHECKED BY:												
TRACED BY:												

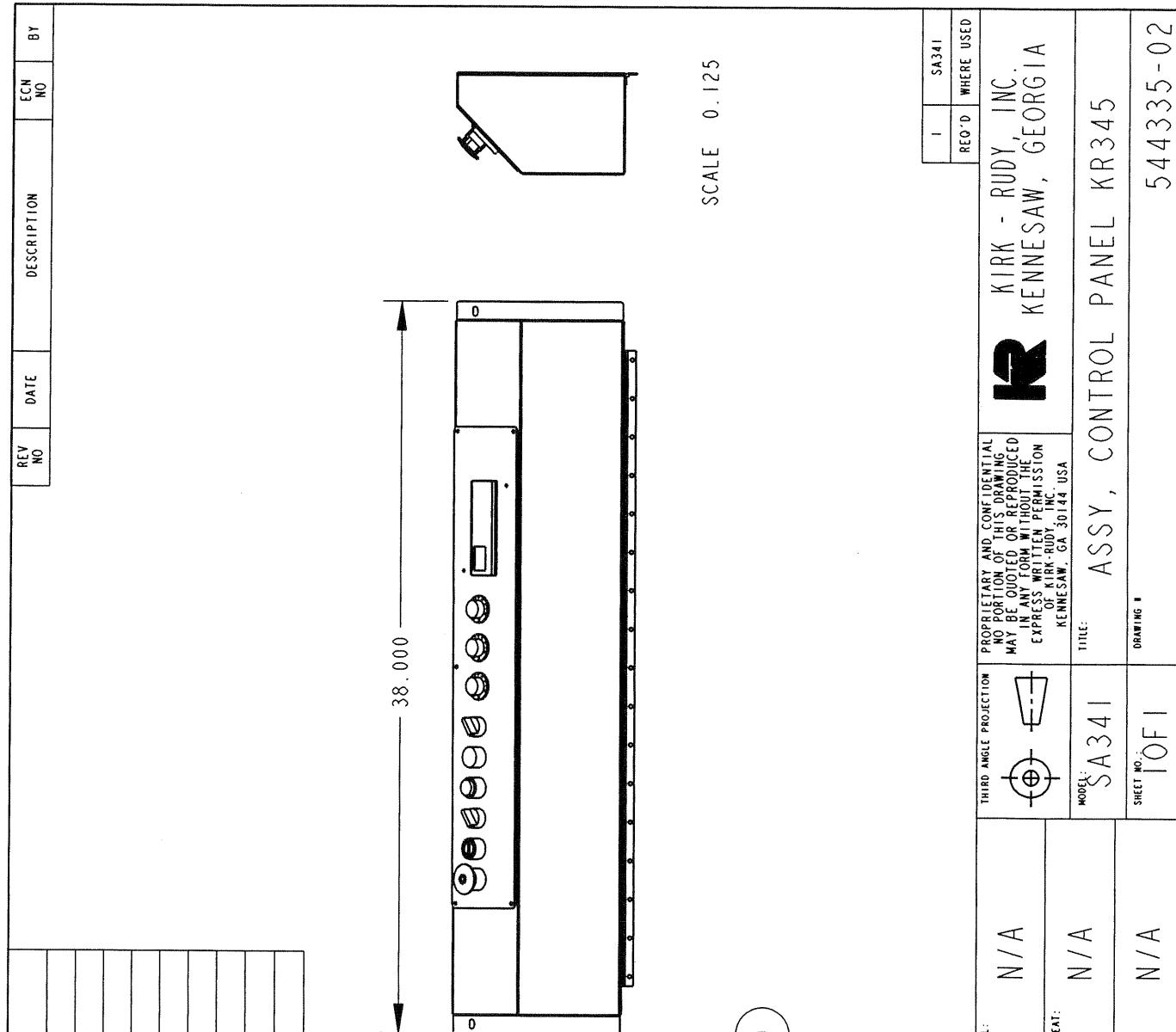
ASSY, LH HYDRAULIFT LEG

DRAWING # 539425-01

KIRK - RUDY, INC.
WOODSTOCK, GEORGIA

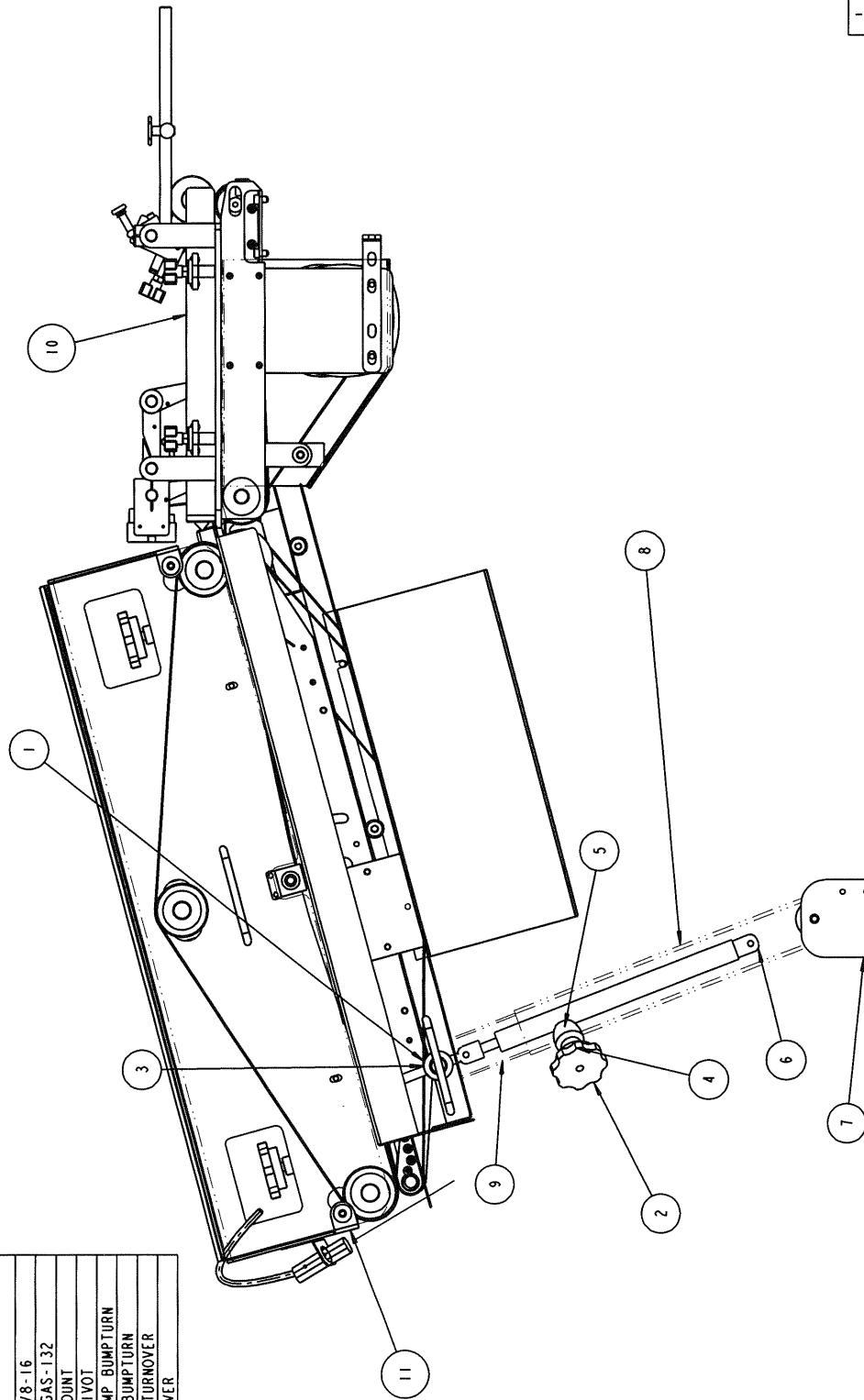
PROPRIETARY AND CONFIDENTIAL
NO PORTION OF THIS DRAWING
MAY BE COPIED OR REPRODUCED
IN ANY FORM WITHOUT THE
EXPRESS WRITTEN PERMISSION
OF KIRK-RUDY, INC.
WOODSTOCK, GA 30188 USA

ITEM QTY	PART #	DESCRIPTION
1	202524	PLC, CROUZET
2	209016	KNOB, POT
3	201124-4	BUTTON, POWER ON
4	201125-3	BUTTON, STOP
5	201125-5	BUTTON, POWER OFF
6	201126-1	BUTTON, JOG
7	201145-1	SELECTOR, 2 POSITIONS
8	544330-02	PANEL, SA341 KR345 CONTROL
9	548431-01	WLDMT, CONTROL BOX COVER



DRAWN BY: T J G	SCALE: 0 . 090	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: 04-Feb-05	.xx	.xxx	ANG.: .01 .005 .5	HEAT TREAT: N / A	MODEL: SA341	KIRK - RUDY INC. KENNESAW, GEORGIA
TRACED BY:	MASTER	. REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED		FINISH: ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY	SHEET NO.: 10F1	TITLE: DRAWING #: 544335-02	

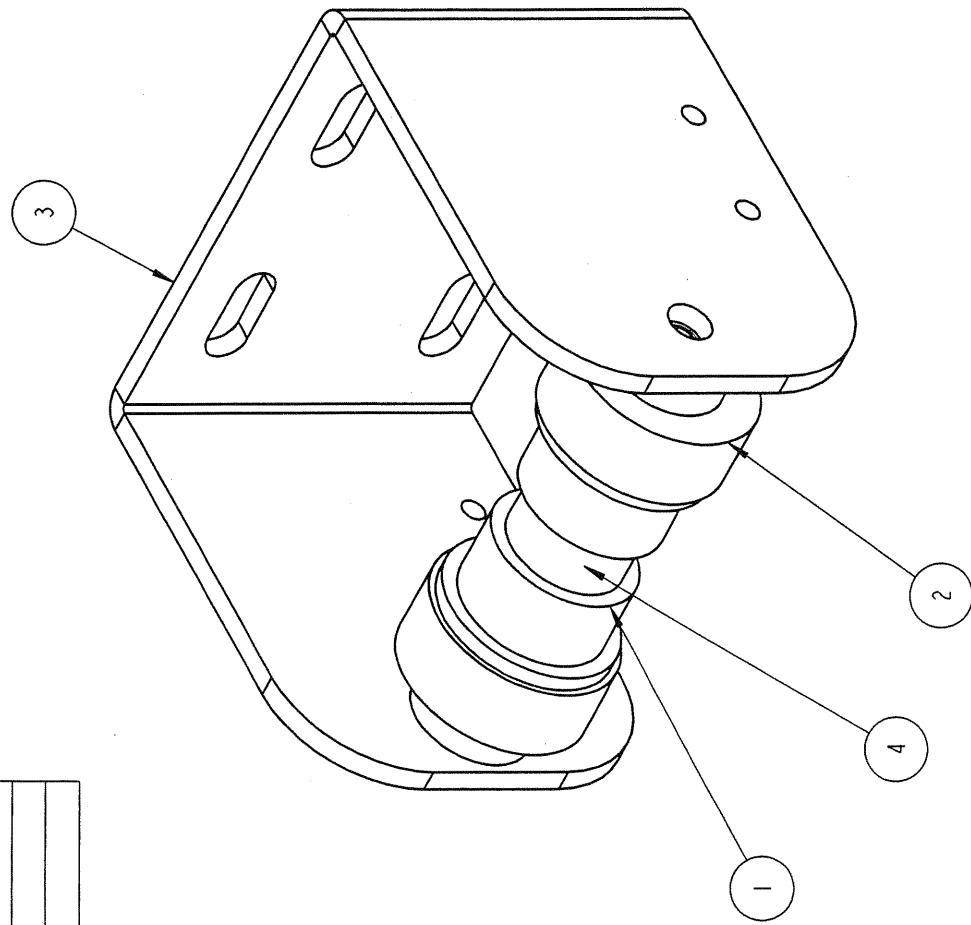
ITEM #	PART #	DESCRIPTION	REV #	DATE	DESCRIPTION	REV #
1	2 100329	BUSHING. F.L. 7501D1.00000.750LG				
2	1 102112	KNOB				
3	2 102215	COLLAR .750				
4	1 105601	SHAFT, THREADED 3/8-16				
5	1 190334	GAS SPRING, 30LB GAS-132				
6	2 190341	BLOCK, CYL INDER MOUNT				
7	1 532466-01	ASSY, DRYER ARM PIVOT				
8	1 542803-01	WLDMT. TUBING CLAMP BUMPTURN				
9	1 542805-01	TUBING, VERTICAL BUMPTURN				
10	1 544293-03	ASSY, INFEED FOR TURNOVER				
11	1 547332-03	ASSY, MINI TURN OVER				



1	SA397
REV D	WHERE USED
KIRK - RUDY, INC.	
WOODSTOCK, GEORGIA	
TITLE: ASSY, TURNOVER + INFEED	
DRAWING #: 548666-01	SCALE: 1/4"
1 OF 2	

DRAWING #: T JG		0 .218	DIMENSION IN INCHES UNLESS OTHERWISE NOTED		MATERIAL: XXX	THE DRAWING PRODUCTION
CHECKED BY:		DATE: 03-06-05	IN	IN	MEAT TREAT: XXX	PRINTED ON HEAVY COATED MANUFACTURED ON COMPUTER BY KIRK-RUDY INC. EXCEPT WHERE SPECIFIED WOODSTOCK, GA 30188 USA
TRACED BY:		MASTER	IN	IN	FINISH: XXX	NAME: SA397
						SET UP BY: XXX

ITEM QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	2	100326 BUSHING, FLI. 000 DI .25000D .750 LG					
2	2	102212 COLLAR 1.000					
3	1	532465-01 BRACKET, DRYER ARM PIVOT					
4	1	532467-01 SHAFT, DRYER PIVOT					



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

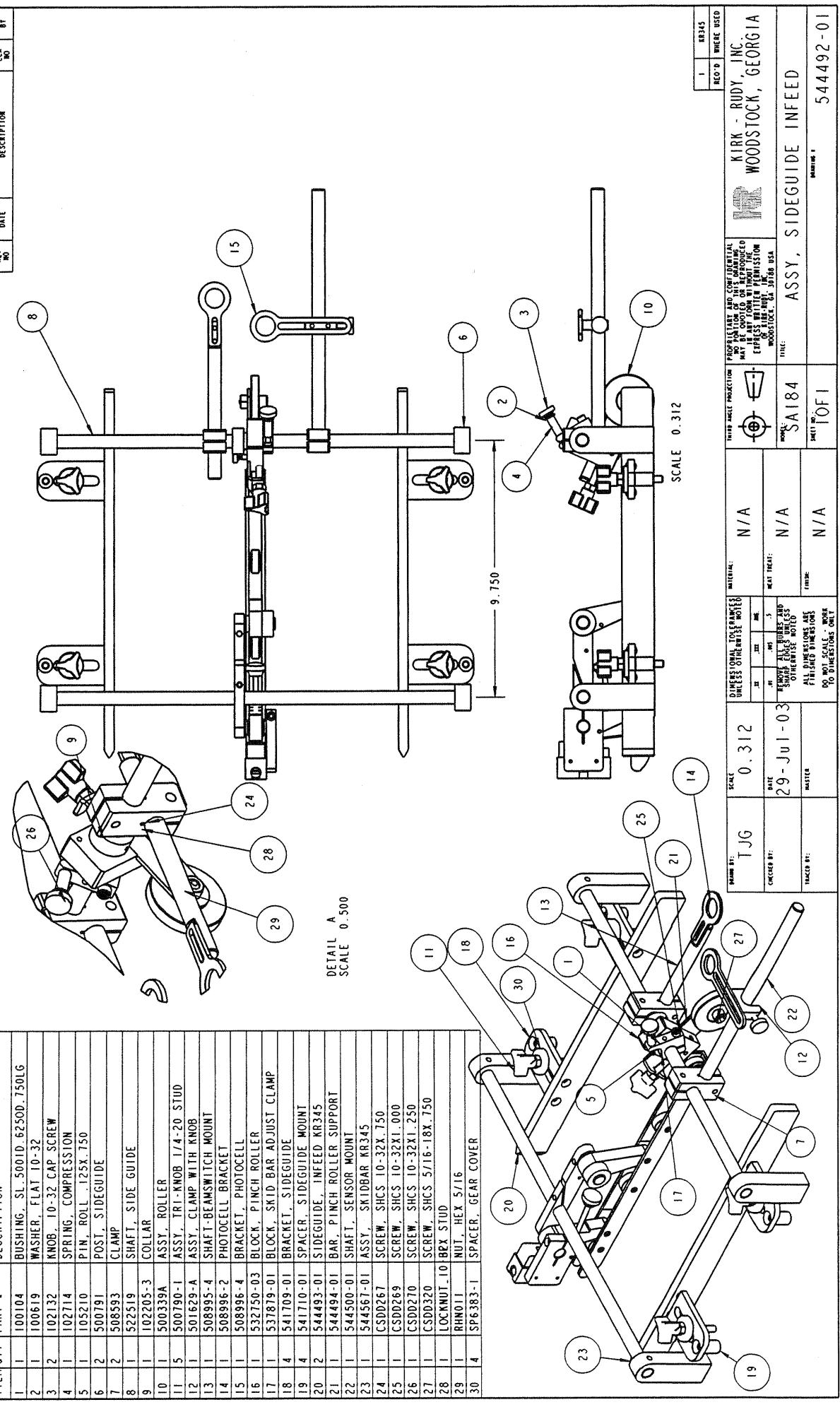
ITEM #	PART #	DESCRIPTION	REV A	DATE	DESCRIPTION	ECN NO
1	4	103804 BEARING, HUB .625				61
2	6	105419 DOWEL, PIN .188X1.000				
3	4	104043 SCREW, SHCS 1/4-20X .375				
4	4	101407 SCREW, SHCS 1/4-20X1.000				
5	4	101428 SCREW, SHCS 1/4-20X .625				
6	1	103888 PULLEY, TIMING 12L050 625B .188K				
7	1	1039963 PULLEY, TIMING 36L030 .750B .188K				
8	3	103908-19 BELT, FLAT 3/4 X 30 75*				
9	1	103937-6 BELT, TIMING 255L050				
10	1	200169-2 MOTOR, BODINE 4180				
11	3	500725-13 GUIDE, BELT 3/4				
12	1	500823-15 SHAFT, IDLER ROLLER				
13	1	500824-13 SHAFT-BELT GUIDE				
14	2	532163-01 STAND, BELT GUIDE				
15	2	533669-02 BLOCK, DEFLECTOR MOUNT				
16	1	53434-03 ASSY, DRIVE ROLLER				
17	1	544300-01 TABLETOP, INFEED				
18	1	544429-05 COVER, INFEED SIDE SECTION LH				
19	1	544429-07 COVER, INFEED SIDE SECTION RH				
20	1	544429-08 COVER, INFEED SIDE SECTION LH				
21	1	544458-01 FRAME, INFEED SECTION				
22	1	544471-02 SHAFT, ROLLER DRIVE				
23	1	544475-01 ROLLER, IDLER INFEED				
24	1	544476-01 PLATE, MOTOR MOUNT LH				
25	1	544476-02 PLATE, MOTOR MOUNT RH				
26	2	544477-01 BRACKET, L CONVEYOR MOUNT				
27	2	544479-01 BRACKET, L CONVEYOR MOUNT				
28	1	544492-01 ASSY, SIDEGUIDE INFEED				
29	1	544501-01 COVER, ROLLER GUARD				

NOTES:
 1. USE 54429-07 FOR RH MACHINE.
 2. USE 544429-08 FOR LH MACHINE.

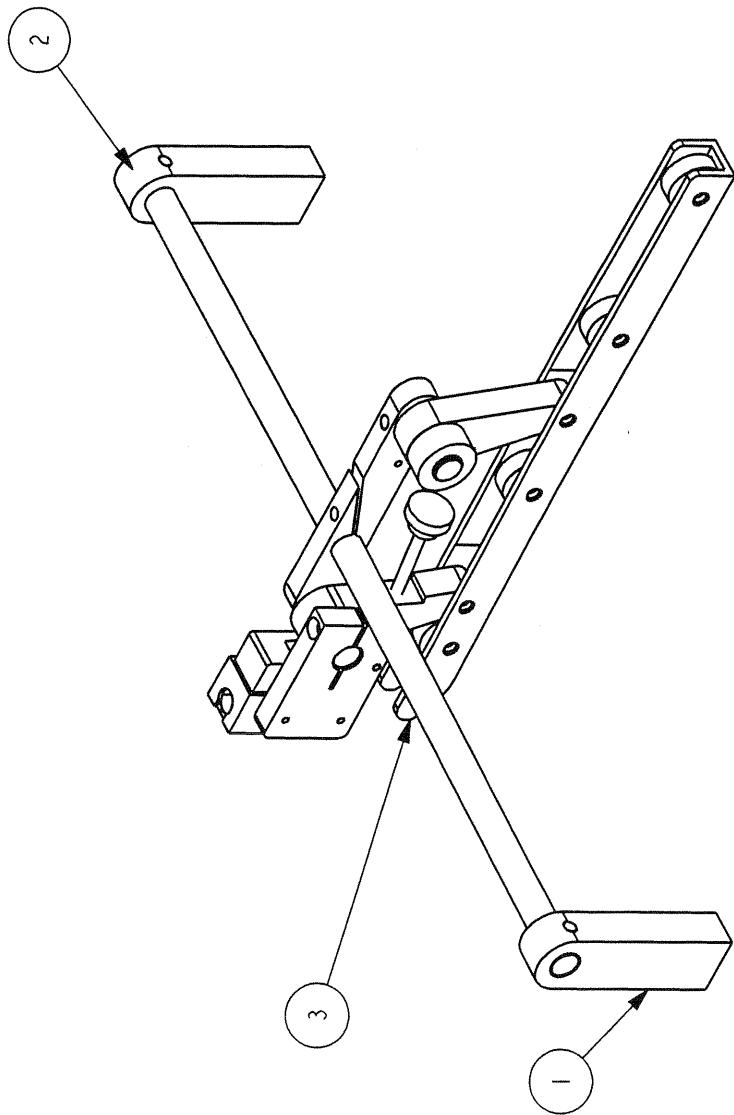
SCALE 0 250

RECD	53397	WHERE USED
PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE DUPLICATED OR REPRODUCED EXCEPT WRITTEN PERMISSION OF KIRK-RUDY, INC., WOODSTOCK, GA 30188 USA		
ITEM:	THREE ANGLE PROJECTION	
NOTED:	DIMENSION TO FRAMES 33351	
INCH	MM	MM
INCH	MM	MM
NOTE:	ALL SURFACES AND SHARP EDGES UNLESS OTHERWISE NOTED	
FINISH:	NONE	
MAKER:	SA397	
TRACTED BY:	NOTED	
MASTER	NOTED	
SCALE:	0 .250	
T JG	0 .250	
DATE:	30 - Sep - 05	
CHECKED BY:		
TRADED BY:		
RECD	544293-03	

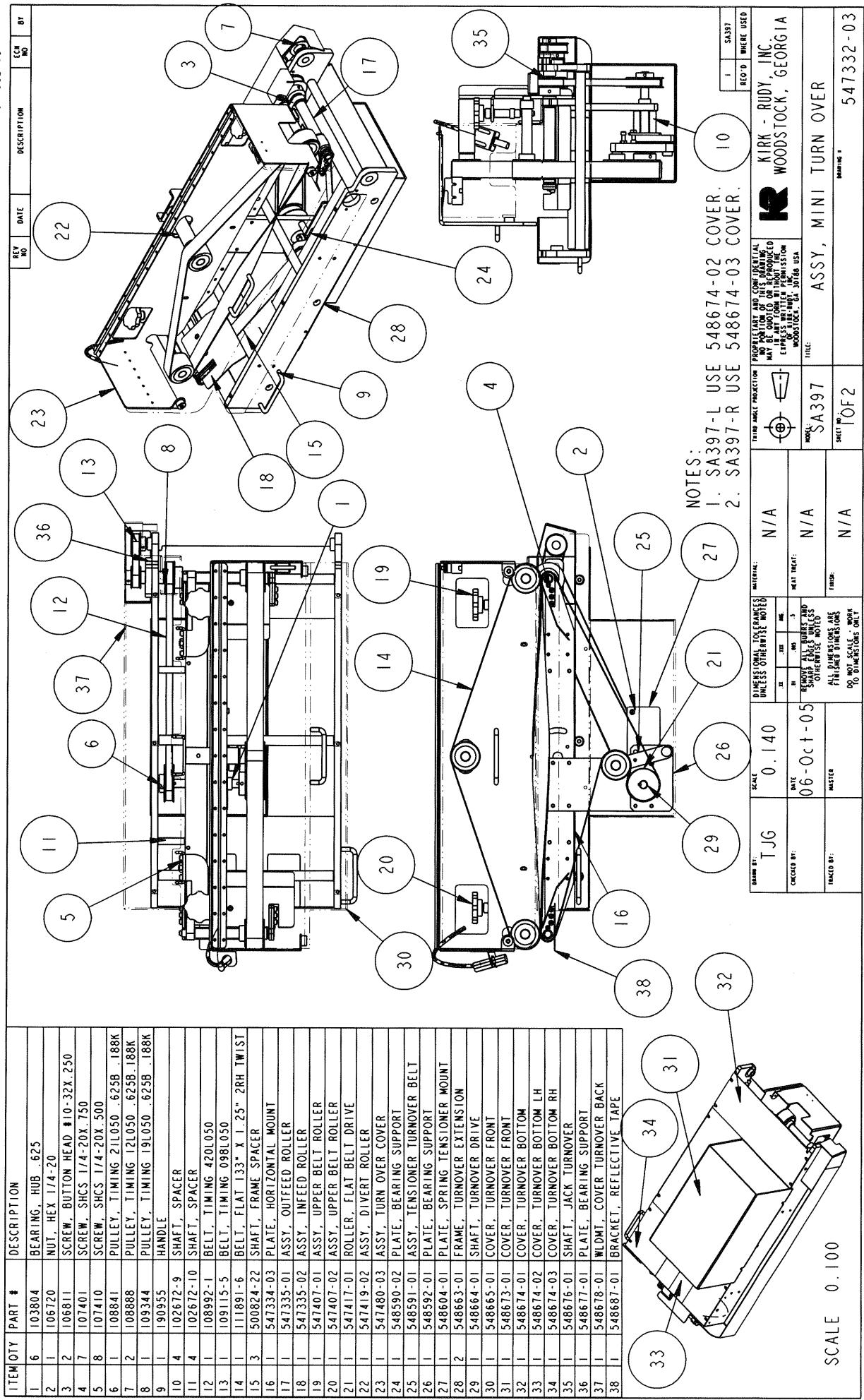
ITEM NO	PART #	DESCRIPTION	REV NO	DATE	ECN NO	BY
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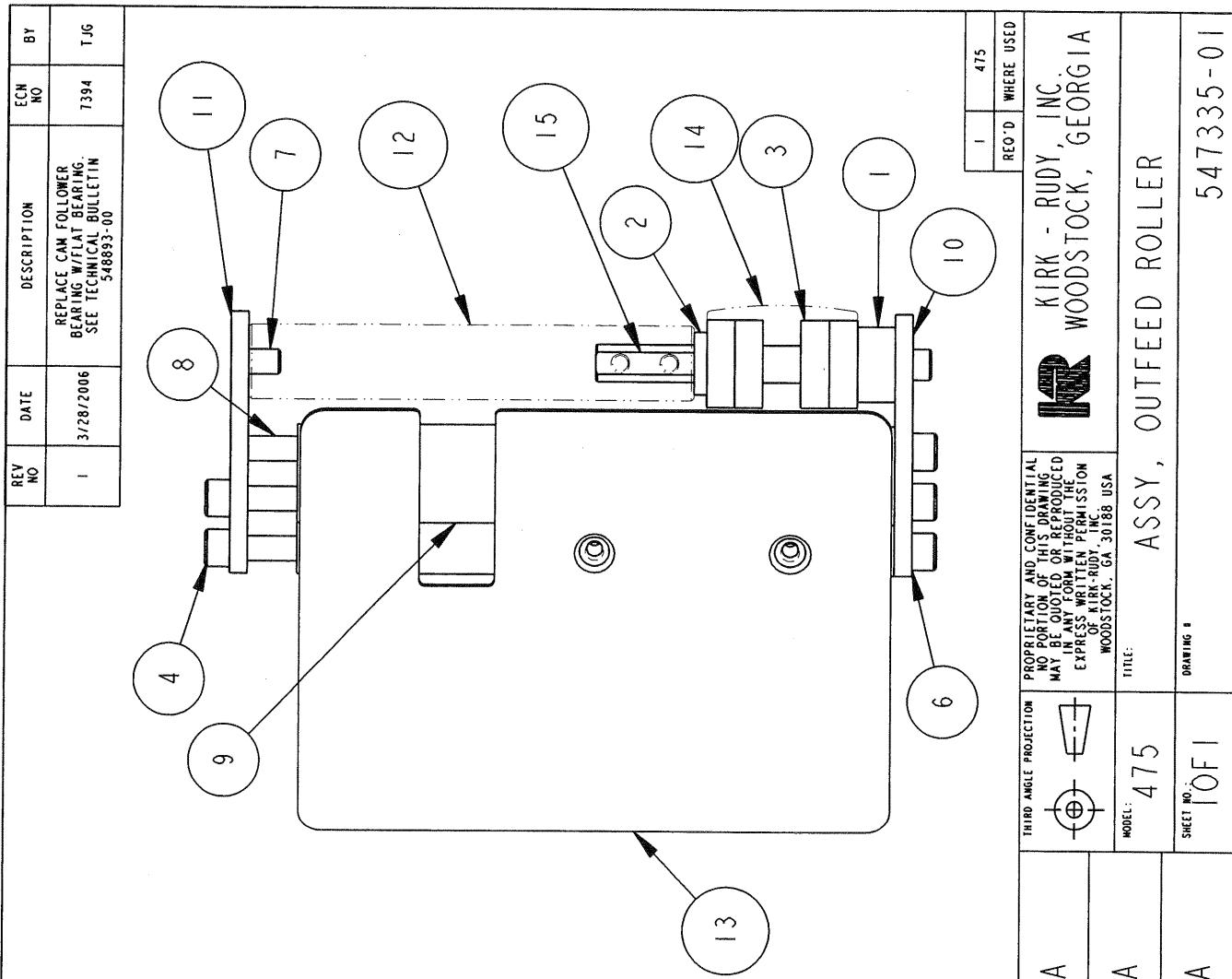
ITEM	QTY	PART #	DESCRIPTION
1	2	500791	POST, SIDEGUIDE
2	1	522519	SHAFT, SIDE GUIDE
3	1	538021-02	ASSY, SKID BAR



DRAWN BY:	SCALE	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	MATERIAL:	THRD ANGLE PROJECTION	PROPRIETARY AND CONFIDENTIAL NO COPIES OF THIS DRAWING MAY BE DUPLICATED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC. WOODSTOCK, GEORGIA WOODSTOCK, GA 30188 USA
T JG	0 . 375	.01 .005 .5	N / A		
CHECKED BY:	DATE	ANG.	HEAT TREAT:		
	12 - Sep - 03		N / A		
TRACED BY:	MASTER	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED	FINISH:	SHEET NO. 1 OF 1	TITLE: ASSY, SKIDBAR KR345 DRAWING # 544567-01



ITEM	QTY	PART #	DESCRIPTION
1	1	102200	COLLAR .375
2	1	102345	SHIM, .375X.625X.125
3	4	103106	BEARING, FLAT .375
4	2	107407	SCREW, SHCS 1/4-20X1.000
5	1	107409	SCREW, SHCS 10-32X.500
6	3	107410	SCREW, SHCS 1/4-20X.500
7	1	107504	SCREW, FLATHEAD 1/4-20X.500
8	1	107505	SCREW, FLATHEAD 1/4-20X1.000
9	1	547336-01	PLATE, BOTTOM ROLLER MNT
10	1	547337-02	PLATE, REAR BEARING
11	1	547337-03	PLATE, REAR BEARING
12	1	547410-03	STUD, LOWER BELT ROLLER
13	1	547422-02	GUIDE, PRODUCT
14	1	548715-02	ROLLER, IDLER CROWNED
15	1	548874-01	SHAFT, IDLER TURNOVER



ITEM	QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	1	375	REPLACE CAM FOLLOWER BEARING w/FLAT BEARING. SEE TECHNICAL BULLETIN 548893-00	1	3/28/2006		7394	TJG

1	475
REO'D	WHERE USED

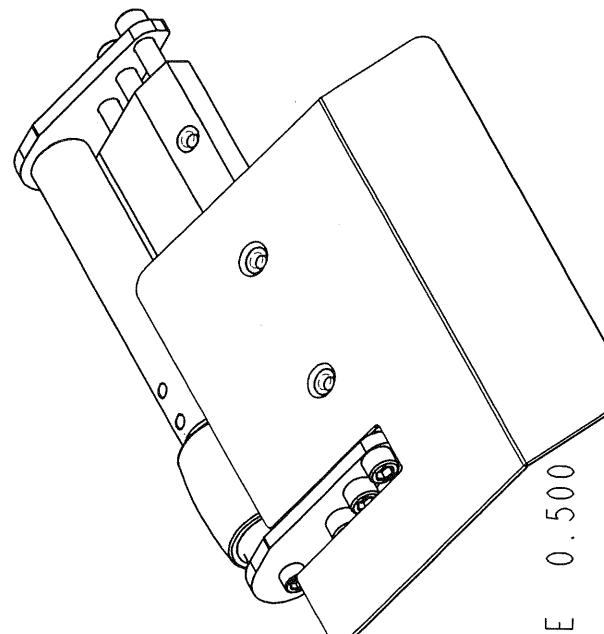
1	475
REO'D	WHERE USED

1	475
REO'D	WHERE USED

1	475
REO'D	WHERE USED

DRAWN BY: A KEY	SCALE 0 .625	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED		MATERIAL: N/A	THIRD ANGLE PROJECTION		PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE QUOTED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC., WOODSTOCK, GA 30188 USA	
CHECKED BY:	DATE 07 - Nov - 05	.XX	.XXX	ANG. .01 .005 .5	HEAT TREAT: N/A		MODEL: 475	TITLE: ASSY, OUTFEED ROLLER
TRACED BY:	MASTER <i>M</i>	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED		ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY			SHEET NO.: 0F1	DRAWING #

ITEM QTY	PART #	DESCRIPTION
1	102200	COLLAR .375
2	102345	SHIM, .375X.625X.125
3	103106	BEARING, FLAT .375
4	3	SCREW, SHCS 1/4-20X1.000
5	1	107409 SCREW, SHCS 10-32X.500
6	4	SCREW, SHCS 1/4-20X.500
7	1	547336-01 PLATE, BOTTOM ROLLER MNT
8	1	547337-02 PLATE, REAR BEARING
9	1	547337-04 PLATE, REAR BEARING
10	1	547410-03 STUD, LOWER BELT ROLLER
11	1	547422-02 GUIDE, PRODUCT
12	1	548715-02 ROLLER, IDLER CROWNED
13	1	548874-01 SHAFT, IDLER TURNOVER



SCALE 0.500

DRAWN BY:	KEY	SCALE	MATERIAL:	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., WOODSTOCK, GA 30188 USA
CHECKED BY:		DATE	.01 .005 .5	XX	XXX	ANG.	+ -	KIRK - RUDY, INC. WOODSTOCK, GA 30188 USA
TRACED BY:	MASTER	07 - NOV - 05	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY	N / A	N / A	HEAT TREAT:		TITLE: ASSY, INF EED ROLLER
				N / A	N / A	FINISH:	SHEET 10 OF 1	DRAWING # 547335-02

ITEM QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	100144	BUSHING, SL. 6251D. 7500D. 6251G					
2	100304	BUSHING, FL. 5001D. 6250D. 750LG					
3	2	100402	WASHER, THRUST TB612				
4	1	102112	KNOB				
5	2	102200	COLLAR .375				
6	1	103112	BEARING, FLAT .750				
7	1	103805	BEARING, HUB .750				
8	2	104104	SNAPRING, .625				
9	1	107253	BOLT, SHOULDER 1/2X3/4				
10	1	547408-01	BRACKET, UPPER BELT ROLLER MNT				
11	1	547409-01	ARM, UPPER ROLLER				
12	1	547410-01	STUD, UPPER BELT ROLLER				
13	1	547411-01	ROLLER, UPPER BELT				
14	1	547412-01	SHAFT, UPPER BELT ADJUST				
15	1	547413-01	SHAFT, UPPER BELT ROLLER				
16	1	CSD0349	SCREW, SHCS 3/8-16X1.250				
17	1	HMSN14	NUT, HEX 3/8-16				

- 475 -

DRAWN BY: A KEY	SCALE 0 .750	DIMENSIONAL TOLERANCES MATERIAL: UNLESS OTHERWISE NOTED		N / A		THIRD ANGLE PROJECTION	PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE COPIED OR REPRODUCED IN WHOLE OR IN PART, NOR MAILED EXCEPT WITH WRITTEN PERMISSION OF KIRK-RUDY INC. WOODSTOCK, GA 30188 USA
CHECKED BY:	DATE 05 - Nov - 04	.XX	.XX	.01	.005	ANG.	
TRACED BY:	MASTER	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED		N / A		HEAT TREAT:	KIRK - RUDY, INC. WOODSTOCK, GEORGIA
		ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY		N / A		MODEL: 475	TITLE: ASSY , UPPER BELT ROLLER
						SHEET NO. 1 OF 1	DRAWING #

ITEM	QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	1	100144	BUSHING, SL. 625ID. 750OD. 625LG					
2	1	100304	BUSHING, FL. 500ID. 625OD. 750LG					
3	2	100402	WASHER, THRUST TB612					
4	1	102112	KNOB					
5	2	102200	COLLAR .375					
6	1	103112	BEARING, FLAT .750					
7	1	103805	BEARING, HUB .750					
8	2	104104	SNAPRING .625					
9	1	107253	BOLT, SHOULDER 1/2X3/4					
10	1	547408-02	BRACKET, UPPER BELT ROLLER MNT					
11	1	547409-01	ARM, UPPER ROLLER					
12	1	547410-01	STUD, UPPER BELT ROLLER					
13	1	547411-01	ROLLER, UPPER BELT					
14	1	547412-01	SHAFT, UPPER BELT ADJUST					
15	1	547413-01	SHAFT, UPPER BELT ROLLER					
16	1	CSD0349	SCREW, SHCS 3/8-16X1.250					
17	1	HMSN14	NUT, HEX 3/8-16					

DRAWN BY: A KEY	SCALE 0 . 600	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	KIRK - RUDY, INC. KR WOODSTOCK, GEORGIA
CHECKED BY:	DATE 05 - NOV - 04	xx	xxx	ANG.: .01 .005 .5	HEAT TREAT:		
TRACED BY:	MASTER	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED		N / A	MODEL: 475	SHEET NO. 1 OF 1	TITLE: ASSY, UPPER BELT ROLLER
		ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY		N / A	DRAWING #	547407-02	

ITEM QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	103112	BEARING, FLAT .750					
2	103805	BEARING, HUB .750					
3	547411-01	ROLLER, UPPER BELT					
4	547420-02	STUD, DIVERT ROLLER					
5	548533-01	BRACKET, UPPER BELT ROLLER MNT					

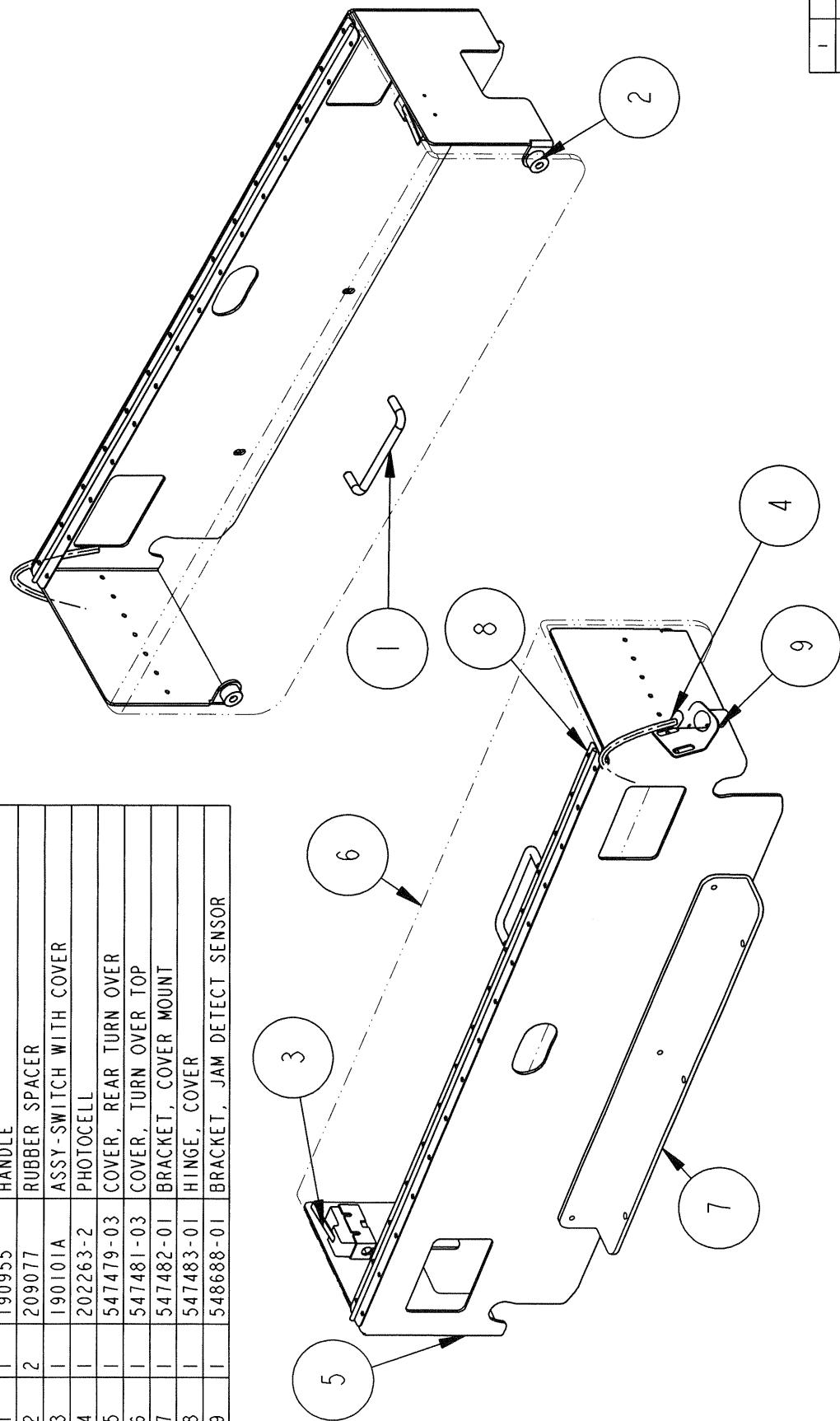
DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED

XX	.01	.005	.5	ANG.
----	-----	------	----	------

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

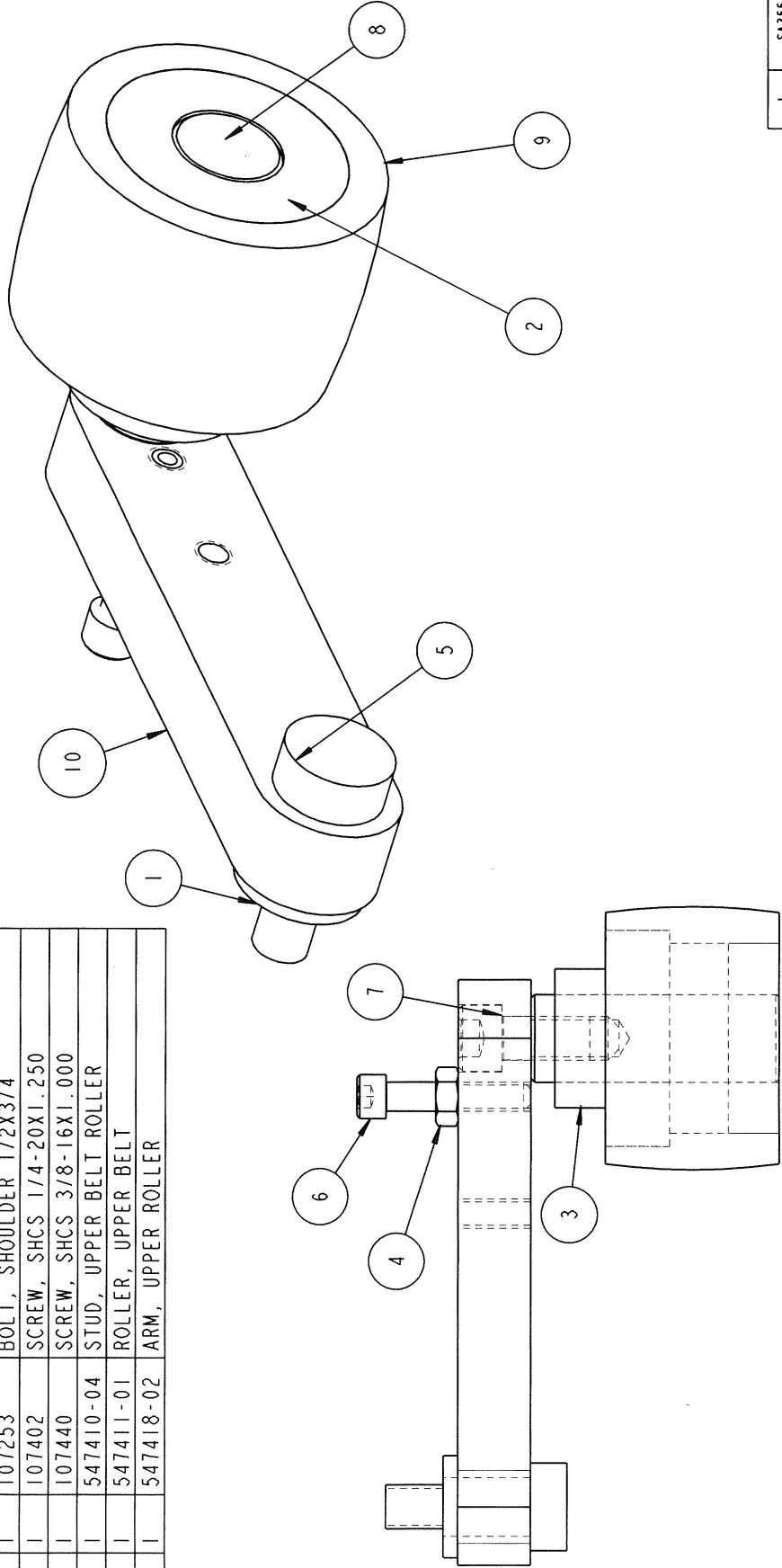
DRAWN BY: T JG	SCALE: 0 . 500	MATERIAL: N / A	THIRD ANGLE PROJECTION	PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE COPIED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY INC. WOODSTOCK, GA 30188 USA
CHECKED BY:	DATE: 18 - Aug - 05	HEAT TREAT: N / A	MODEL: SA355	KIRK - RUDY, INC. WOODSTOCK, GEORGIA
TRACED BY: MASTER	FINISH:	N / A	SHEET NO: 1 OF 1	TITLE: ASSY, DIVERT ROLLER

ITEM QTY	PART #	DESCRIPTION
1	190955	HANDLE
2	209077	RUBBER SPACER
3	190101A	ASSY-SWITCH WITH COVER
4	202263-2	PHOTOCELL
5	1	547479-03 COVER, REAR TURN OVER
6	1	547481-03 COVER, TURN OVER TOP
7	1	547482-01 BRACKET, COVER MOUNT
8	1	547483-01 HINGE, COVER
9	1	548688-01 BRACKET, JAM DETECT SENSOR



REV NO	DATE	DESCRIPTION	ECN NO	BY
1 SA397				REQ'D WHERE USED
				KIRK - RUDY, INC.
				KIRK WOODSTOCK, GEORGIA
				PROPRIETARY AND CONFIDENTIAL
				NO PORTION OF THIS DRAWING
				MA BE COPIED OR REPRODUCED
				IN WHOLE OR IN PART
				EXCEPT WRITTEN PERMISSION
				OF KIRK - RUDY, INC.
				WOODSTOCK, GA 30188 USA
				TITLE:
				ASSY, TURN OVER COVER
				DRAWING #
				547480-03
DRAWN BY: T J G SCALE: 0 . 188 DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED				
CHECKED BY: DATE: 03-0C1-05 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 1 OF 1				DRAWING #

ITEM	QTY	PART #	DESCRIPTION
1	1	100304	BUSHING, FL. 500ID. 625OD. 750LG
2	1	103112	BEARING, FLAT .750
3	1	103805	BEARING, HUB .750
4	1	106720	NUT, HEX 1/4-20
5	1	107253	BOLT, SHOULDER 1/2X3/4
6	1	107402	SCREW, SHCS 1/4-20XI. 250
7	1	107440	SCREW, SHCS 3/8-16XI. 000
8	1	547410-04	STUD, UPPER BELT ROLLER
9	1	547411-01	ROLLER, UPPER BELT
10	1	547418-02	ARM, UPPER ROLLER



REV NO	DATE	DESCRIPTION	ECN NO	BY
1	4/11/2006	REPLACE 547410-02 WITH 547410-04 BECAUSE OF ECN7286	7390	TIG

1	SA355
REQ'D	WHERE USED

KRK KIRK - RUDY, INC.
WOODSTOCK, GEORGIA

DRAWN BY:	SCALE	DATE	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	MATERIAL:	THIRD ANGLE PROJECTION	PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE QUOTED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC., WOODSTOCK, GA 30188 USA
T JG	.000	.xx .xxx .01 .005 .5	ANG.	N/A		
CHECKED BY:	DATE	26-JUL-05	HEAT TREAT:	NONE		
TRACED BY:	MASTER		FINISH:	N/A		

548591-01

8.0 ELECTRICAL SCHEMATICS AND PARTS



WARNING

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

8.1 SCHEMATIC NUMBER LIST

Schematic # 210 455 0005

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

210 Schematic, SA397-1 KR345 Vertical Edge Stacker
SYMBOLS.ORC Schematic Symbols Reference

8.2 PARTS LIST

9.0 APPENDIX



WARNING

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

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

COMPONENT

DC Supply
DC Motor Board
Beam/prox switch
Interface

MANUFACTURER

International Power
Penta-KB
Banner
Crouzet

10.0 NOTES

11.0 WARRANTY AND SERVICE

WARRANTY

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

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

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

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

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

USE ONLY GENUINE REPLACEMENT PARTS

For Service or Replacement Parts Please Call:

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

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