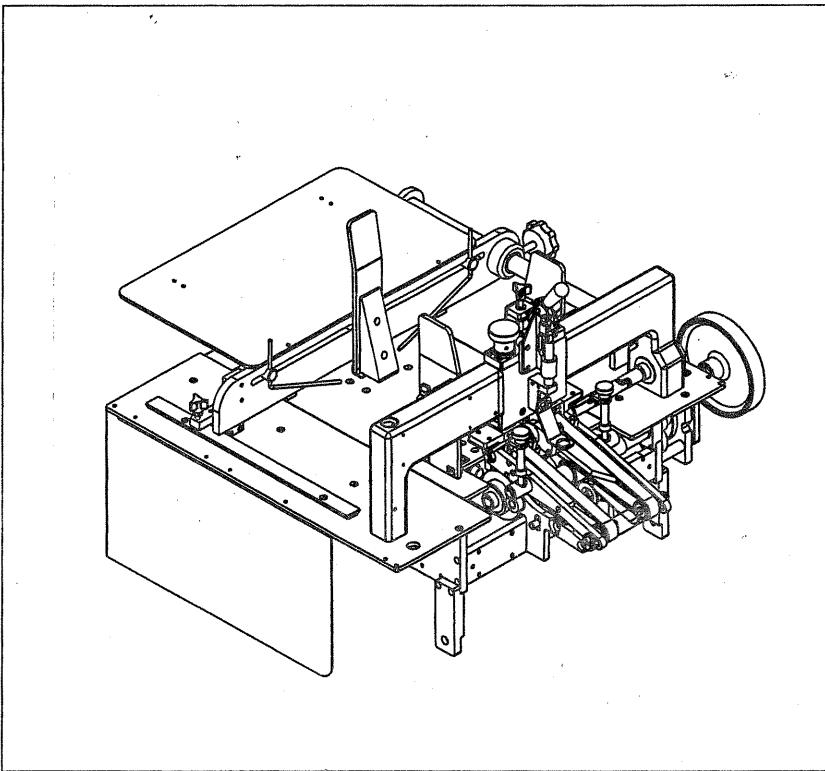


# *Kirk-Rudy, Inc.*

## Instruction and Parts Manual

### KR324-1 Standard & Wide Shuttle Feeder



Manufactured by Kirk-Rudy, Inc.

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

Instruction  
and Parts Manual

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

# **1    IMPORTANT SAFETY INSTRUCTIONS**

Intended Use Statement: This product has been designed to be a sheet-fed, top loading, bottom feed, vacuum shuttle system. 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.
- \* READ ANY ADDITIONAL PRODUCT MANUALS THAT ARE SUPPLIED WITH KIRK-RUDY MACHINES FOR INSTRUCTIONS AND IMPORTANT SAFETY INSTRUCTIONS.

## **2 SPECIFICATIONS**

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<u>PRODUCT SIZE RANGE</u>	<u>English</u>	<u>Metric</u>
Minimum Size:	4" W x 3" L	102mm W x 76mm L
Maximum Size:	17" W x 14" L	438mm W x 355mm L
Minimum Thickness:	Card Stock (.007")	Card Stock (.18mm)
Maximum Thickness:	3/8"	9.5mm

### SPEED

Maximum 12,000/hr.

### MACHINE DATA

#### BASE

Length:	33"	83.82cm
Width:	31"	78.74cm
Height:	20"	50.8cm

Weight: Net

Shipping Crate:

### ELECTRICAL

CLUTCH ON/OFF	24VDC
MISFEED	24VDC
E-STOP	24VDC
FEEDER ON/OFF	24VDC

## **3 INSTALLATION**

---

### **3.1 UNCRATING AND UNPACKING**



#### **WARNING**

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

The KR324-1 Shuttle Feeder is normally supplied mounted to a KR512 Inserter. If shipped separately it will be crated. Remove feeder and all packaging from crate.

Note: Boxes are located inside the crate.

Note: A forklift should be used to lift feeder from pallet.

### **3.2 ACCESSORIES AND SPARE PARTS**

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

### **3.3 ASSEMBLY ON BASE**

**NOTE:** Read all Safety and Operating Instructions contained in this manual before beginning operation and assembly.

1. The shuttle feeder mounts direct to the frame of the KR512 with (4) screws.
2. Make sure proper gear engagement between feeder and base.
3. Locate and attach the vacuum, electrical, oil line and pneumatic connections.
4. Attach the sheet metal covers.

## **4 OPERATING INSTRUCTIONS**

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### **4.1 BASE ELECTRICAL OPERATION**



#### **WARNING**

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

#### 4.1.1 OVERVIEW OPERATOR CONTROLS

Feeder On/Off: This rotary knob will turn the feeder off by disengaging the clutch. This will stop the shuttle, but the out feed belts will continue to run.

E-Stop Button: This push button will stop the entire KR512 machine.

#### 4.1.2 ELECTRICAL COMPONENT DESCRIPTION

Misfeed Beamswitch: This beamswitch detects product misfeeds.

Air Valve: 24 DC Used to actuate air cylinder for shuttle clutch.

### **4.2 MECHANICAL OPERATION**

#### 4.2.1 MECHANICAL COMPONENT DESCRIPTION & SET UP

Vacuum Plate: The vacuum plate is located on the front edge of the shuttle. Its purpose is to pull the bottom piece from the product stack. Four vacuum plates are available with your machine so different types of product can be feed.

1. Deep concave: Used for lightweight material. Material that will conform to the depression when vacuum is applied. (Part # 503751-3)
2. Shallow concave - for medium weight material: e.g., self-mailers, light newspapers, folded sheets, pamphlets, etc. - material that will conform to the depression when vacuum is applied. (Part # 503751-2)
3. Flat - for heavy material such as catalogs, booklets, magazines, etc. (Part # 503751-1)
4. Convex- (optional) for feeding product open edge first. (Part # 503751-4)

Select the proper vacuum plate using the above information as a guide. Humidity and/or static in some mailing piece stocks may require interchanging the vacuum feed plates to achieve optimum feed operation. For greater vacuum control, a 10-32 tap can be run partially into each hole of the vacuum plate. 10-32 set screws can then be used as needed for controlling the vacuum. The vacuum plate is mounted to the feed shuttle by two Allen cap screws. Before mounting, clean all foreign material from bottom of vacuum plate and shuttle mounting block. A light coating of grease on the bottom periphery of the vacuum plate is helpful to ensure a good seal.

Side Guides: The side guides are used to guide the product so it has the correct orientation from left to right. Loosen the thumbscrews to move each side guide to its correct position (1/16" gap between product & guide) and retighten thumbscrews. The product is normally centered with the gate and upper feed rollers, however it can be offset as needed. The photocell that detects a low stack is mounted to the bottom of the left side guide.

Jogger Table: The jogger table has two purposes. The first purpose of the jogger table is to use the large flat plate to jog a stack of product for more reliable feeding. The second purpose is to set the position of the vertical back plate. This position is dependent upon product length. The distance between the gate and vertical back plate (which is located on the jogger table assembly) can be varied by loosening the locking knob and siding the jogger table assembly on it's mounting shaft. The jogger table assembly should be positioned so there is a 1/16" gap between the product and vertical back plate with the product touching the gate.

Pusher Blocks: Two pusher block assemblies are provided to assist in feeding heavy material when vacuum alone will not suffice. To adjust, jog machine until feed table has reached its back position. Loosen the front screws and slide pusher block assemblies until pusher 'lip' is 1/4" from rear of mailing piece. By turning the rear pusher block Allen screws counterclockwise, the front edge of the spring-loaded pusher 'lip' can be raised - adjust height of lip to approximately one-half the thickness of an individual mailing piece.

Lifter Fingers: Two lifter finger assemblies are provided to assist in feeding wide, limp material (e.g., tabloids, newspaper stock, etc.) more effectively. The lifter fingers give this type material more rigidity at the gate separation area. They are made from 1/4" round steel, and can be found mounted on either side of the back guide. To adjust, loosen retaining nuts, thereby permitting movement of the fingers laterally in their respective slots on the jogger plate, and up and down in the hex head bolt assemblies. Position each finger approximately 1/4 to 1/3" in from the edge of the mailing piece and raise to within 1/2 to 1" from feed table. **Warning:** Lifter fingers should always be at least 1/8" above shuttle table.

Gate: The gate is used to separate the product as the vacuum plate pulls the bottom piece from the stack. Loosen the round knob that holds the gate adjusting knob secure. To raise the gate, turn the knob counterclockwise. Clockwise lowers the gate. The gate is adjusted properly when only one piece can fit between the gate and vacuum plate. To correctly set the height of the gate, follow these steps:

1. Move shuttle to maximum back position.
2. With vacuum pump on, install 1 piece of product in hopper.
3. Jog shuttle table forward 1/8"
4. Adjust gate height so only one piece will slide under gate.
5. Fine tune during running. If more than one piece is being feed, lower the gate. If product is damaged during feeding, raise the gate.
6. Secure gate adjusting knob.

Upper Feeder Pinch Rollers: The height of these rollers is determined by product thickness. To adjust them, use an Allen wrench to loosen the securing rings around each upper feed

roller adjusting knob. Turning the knob clockwise lowers the feed roller; counter clockwise raises the roller. It is important the feed rollers apply the same amount of pressure otherwise the product will skew as it leaves the hopper. To correctly set the height of the feed rollers follow these steps:

1. Install one piece of product in hopper.
2. Move shuttle to maximum forward position.
3. Adjust roller height so there is slight drag between rollers and product.
4. Fine tune upper rollers during running. If product skews, increase/decrease roller pressure one side at a time until product runs straight.
5. Lock securing rings.

Vacuum Pump Regulator Adjuster: Different types of product require varying amounts of suction at the vacuum plate in order to feed properly. For example, a very thin, porous stock requires less vacuum than a heavy card stock. Too much vacuum at the vacuum plate will result in double feeds. A suction of 20-25" Hg. is a typical starting point. To determine the present setting, remove the plastic hose that connects the pump and the vacuum body. Cover the inlet with your finger. The gauge on the pump will display the amount of vacuum the pump is producing. To adjust the vacuum pump regulator follow this procedure:

1. Locate the vacuum inlet manifold. A gauge located on top of this manifold indicates the suction created by the pump in inches of mercury. A spring-loaded valve on the bottom of this manifold functions as a regulator.
2. To increase the suction, loosen the locknut and turn the nuts to decrease spring pressure.
3. To decrease the suction, loosen the locknut and turn the nuts to increase spring pressure.

Shuttle Clutch: This mechanism disengages the shuttle table and allows all of the outfeed rollers and belts to continue running. This mechanism is used to turn the feeder off for the reject system and the feeder off switch.

#### 4.2.2 FEEDER SET UP

The following steps are used to setup the feeder to run a given product. Perform these steps in the order they are listed. Refer to Mechanical Component Description (section 4.2.1) if detailed information is needed on how to perform each step.

1. Determine the correct vacuum plate to use and install it.
2. Adjust the vacuum pump regulator.
3. Jog product to be ran.
4. Set position of side guides. (1/16" gap)
5. Set position of jogger table assembly. (1/16" gap)
6. Set gate height.
7. Set height of upper feed rollers.
8. Determine if use of lifter fingers or pusher block is necessary.
9. Fine tune gate height, upper feed rollers and vacuum pump regulator as needed during test run to get reliable product feeding.

## 5 MAINTENANCE

### 5.1 LUBRICATION:

The KR324-1 feeder is usually mounted on the KR512 Inserter, which is equipped with an automatic central oiling system. See KR512 Inserter manual for instructions. If the KR324-1 feeder is not mounted on a KR512 Inserted, a manual central oiling system should be used. This will require the operator to pull the oiler once a day.

### 5.2 DAILY FUNCTIONS OF OPERATOR



### WARNING

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

Daily Functions of Key Operator KR324M		
Item	Function	Remarks
Photocells & Reflective Tape	Remove dust, ink, glue and all other foreign materials.	Use clean soft rag.
Vacuum Pump Filters (Internal and external)	Remove dust.	Use compressed air to remove contaminants.
Vacuum Pump Filter Jars	Clean jars thoroughly.	Use warm water and dry thoroughly. <b>CAUTION:</b> Improper replacement or cracked rims of jars can result in a loss of vacuum. Insure jar is installed correctly and have a proper seal.
Vacuum Pump Baffle	Remove dust	Soak the baffle in a solvent to remove contaminants.
Lubrication	Increase machine life.	See Section 5.1

Shuttle Feeder Vacuum System: Clean on an as-needed basis. Cleaning intervals will vary depending on what type of product is being run. Dust will collect underneath the grit plate and must be removed for proper feeding.

1. Remove grit plate on shuttle feeder.
2. Remove the two panhead screws that secure the spring steel valve.
3. Clean and re-assemble

### **5.3 MECHANICAL TIMING AND SET-UP**

#### Bottom Feed Roller Setup

The bottom rollers are set at the factory. If the bottom rollers need to be adjusted or replaced, take the following steps:

1. Remove feeder from machine.
  - a. Remove drive chain.
  - b. Remove the four bolts securing feeder frame plates to cross channels.
  - c. Lift feeder off of cross bars.
2. Adjust lower feed roller height. The lower feed roller assembly rotates up and down approximately  $1/16"$ . A cam located on the crankshaft provides this motion. When the lower feed rollers are set properly, they will rise above the shuttle table approximately  $1/32"$  at the high point of the cycle. At the low point of the cycle, they have to be underneath the shuttle table.
  - a. Loosen spring-loaded arm on right side of feeder frame plate.
  - b. Rotate the feeder ccw such that the cam on the crankshaft lifts the cam follower to its high point.
  - c. Lift lower feed roller assembly such that the top of the feed rollers are approximately  $1/32"$  above the shuttle table. At the same time, rotate arm slightly downward ( $15^\circ$ ) against the spring and tighten the clamp.
3. Mount feeder onto machine.
4. Turn on vacuum pump for the feeder.
5. Jog machine such that feeder shuttle table is in its most forward position, and the vacuum valve assembly cuts the section to the feeder plate.
6. Loosen the set screws which secure the lower feed roller cam to the to crankshaft.
7. Rotate cam CCW such that the lower feed roller assembly rotates up to its high point.
8. Secure cam to crankshaft.

Vacuum Body Timing Adjustment: The vacuum plate has vacuum for  $\frac{1}{2}$  of a feed cycle. Vacuum starts when the shuttle table is in its rear position and then turns off when it is in its forward position. Push rod and spring valve assemblies control the vacuum. These are set at the factory and adjustment is not necessary, except for maintenance. If the vacuum body needs to be adjusted or replaced, take the following steps:

1. Remove the product from hopper and rotate the feeder until the shuttle table is in its most rear position
2. Locate the push rod underneath the shuttle table and loosen both collars.
3. Slide the push rod forward into the vacuum manifold until vacuum is present at the vacuum manifold plate.
4. Holding the push rod in place, slide the front collar back against the cross brace and tighten.
5. Advance the shuttle table to its most forward position.
6. Slide the push rod back until vacuum is no longer at the vacuum manifold plate.
7. Slide the rear collar up against the cross brace and tighten.

# **6 PARTS LISTS AND DIAGRAMS**

---

## **6.1 DIAGRAMS**

This section contains the entire mechanical bill of materials and assembly drawings.

<b>ASSEMBLY NUMBER</b>	<b>DESCRIPTION</b>
534734-01	ASSY, 324-1 FEEDER
531021-01	ASSY, SHUTTLE TABLE
500708A	ASSY, VACUUM BODY
500728A	ASSY, BUSHING BLOCK
500751A	ASSY, BEARING BLOCK
531022-02	LOWER FEED ROLLER ASY
500734A	CLAMP ARM ASY
531102-01	HUB GEAR ASY
531405-01	ASSY, JOGGER TABLE
536892-01	ASSY, REAR BRIDGE
536406-01	ASSY, JOGGER TABLE SLIDE
500764A	ASSY, LIFTER
534733-01	ASSY, SHUTTLE TABLE
SP39952-A	ASSY, BLOCK ONE WAY ROLLER RH
SP39952-1A	ASSY, BLOCK ONE WAY ROLLER LH
534735-01	ASSY, FRAME RH
534736-01	ASSY, FRAME LH
531106-01	ASSY, HUB
534739-01	ASSY, IDLER 1626 GEAR
534740-01	ASSY, CRANK SHAFT
508624A	ASSY – GEAR W/ PAWL
534746-01	ASSY, CYLINDER MOUNT
533824-01	ASSY, SOLENOID
534737-01	ASSY, THROWOUT CLUTCH FRAME
534738-01	ASSY, BRIDGE DRIVE SHAFT
534741-01	ASSY, HANDWHEEL SHAFT
SP39266A	ASSY, THROWOUT YOKE
534742-01	ASSY, LOWER OUTFD FRAME
534743-01	ASSY, LOWER OUTFD ROLLER
534744-01	ASSY, BELT TENSIONER IDLER
534745-01	ASSY, LOWER OUTFD DRIVE
540033-02	ASSY, 324-1 BRIDGE
100800-1	ASSY, UNIVERSAL JOINT
500814-1A	ASSY, SIDE GUIDE RAIL
535412-01	ASSY, SIDE GUIDE
500755AL	ASSY, SIDE GUIDE LH
500755AR	ASSY, SIDE GUIDE RH

102119-A	ASSY, KNOB
536712-01	ASSY, TOP FEED ROLLER
508746-A	ASSY, ROLLER ALUMINUM
508761-2A	ASSY, ROLLER
534750-01	ASSY, INSIDE SWING LH
534750-02	ASSY, INSIDE SWING RH
533185-01	ASSY, OUTSIDE SWING PLATE
536713-01	ASSY, ARM ADJUST SCREW
536714-01	ASSY, SPRING SHAFT HOLDER
536716-01	ASSY, GATE
500730-11	ASSY, GATE
541203-02	ASSY, BRIDGE
536728-01	ASSY, ELECTRICAL BUTTON BOX

## 6.2 PARTS LIST

See the following pages for complete list of parts of the standard feeder.

ITEM QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	500824	SHAFT-BELT GUIDE					
2	508925-5	COVER, GEAR					
3	526650-2	COVER, STANDARD					
4	531021-01	ASSY, SHUTTLE TABLE					
5	531022-02	LOWER FEED ROLLER ASY					
6	531405-01	ASSY, JOGGER TABLE					
7	534733-02	ASSY, SHUTTLE TABLE					
8	534735-01	ASSY, FRAME RH					
9	534736-01	ASSY, FRAME LH					
10	534737-01	ASSY, THROWOUT CLUTCH FRAME					
11	534742-01	ASSY, LOWER OUTFD FRAME					
12	540033-02	ASSY, BRIDGE 324-1					
13	541755-01	WEDGE, REAR PRODUCT LIFT					

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WOODSTOCK, GA 30188 USA

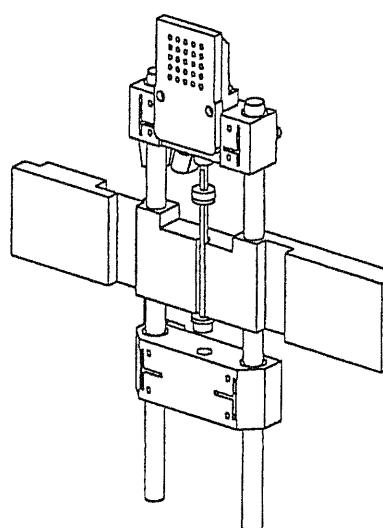
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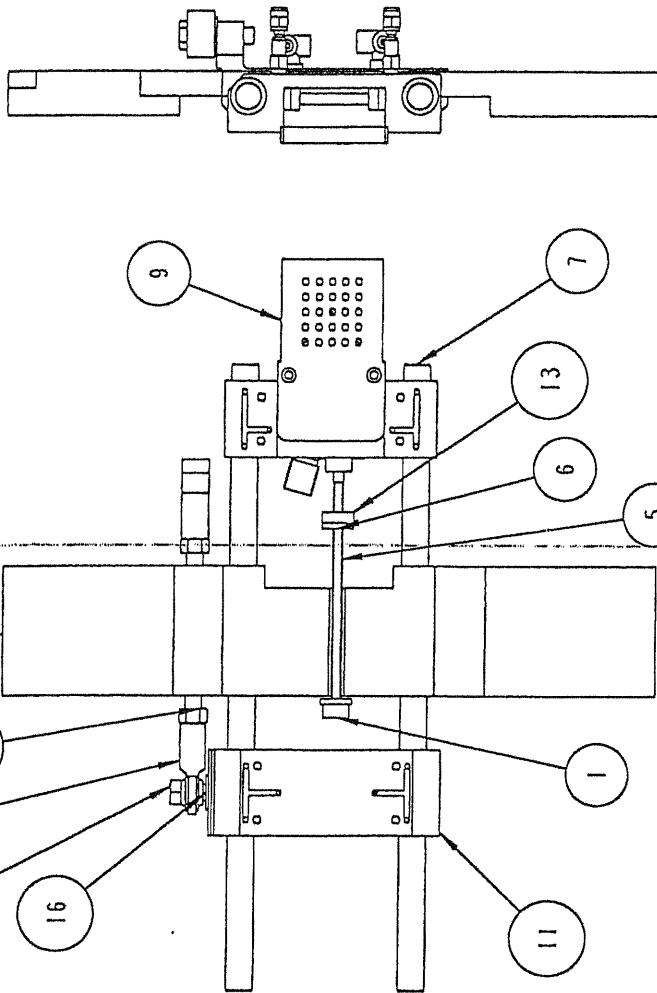
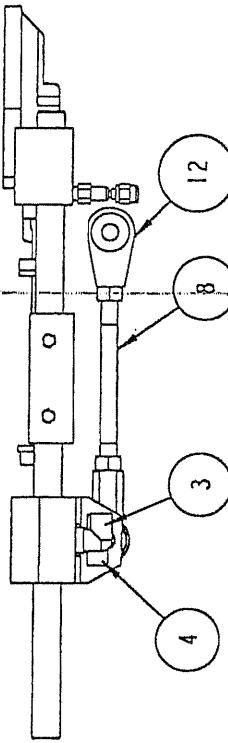
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ASSY, 324-1 FEEDER

DRAWING #: 324-1  
SHEET NO.: 0F3  
534734-01

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1	2	102225	COLLAR .250				
2	1	103500	BEARING - ROD END				
3	1	109523	JUNCTION, 2-WAY				
4	1	109524	JUNCTION, 3-WAY				
5	1	500735	ROD - PUSH				
6	2	500737	WASHER - BUMPER				
7	2	500741	SHAFT - FEEDER				
8	1	500749	ROD - FEEDER SLIDE				
9	1	500708A	ASSY, VACUUM BODY				
10	1	500710-1	BRACKET - FEEDER SUPPORT				
11	1	500728A	ASSY, BUSHING BLOCK				
12	1	500751A	ASSY, BEARING BLOCK				
13	1	530253-01	RING				
14	1	RHB082	HEX HEAD BOLT				
15	2	RHN012	HEX NUT				
16	1	WA013	WASHER				

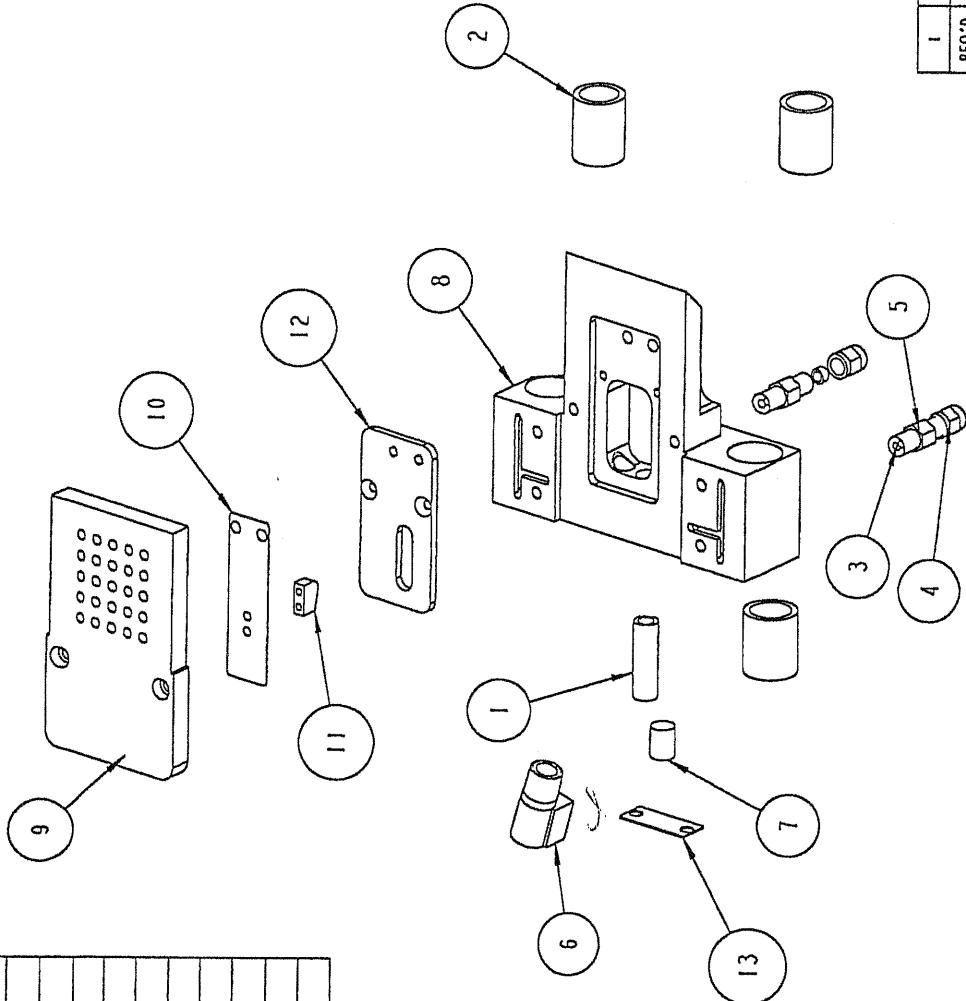


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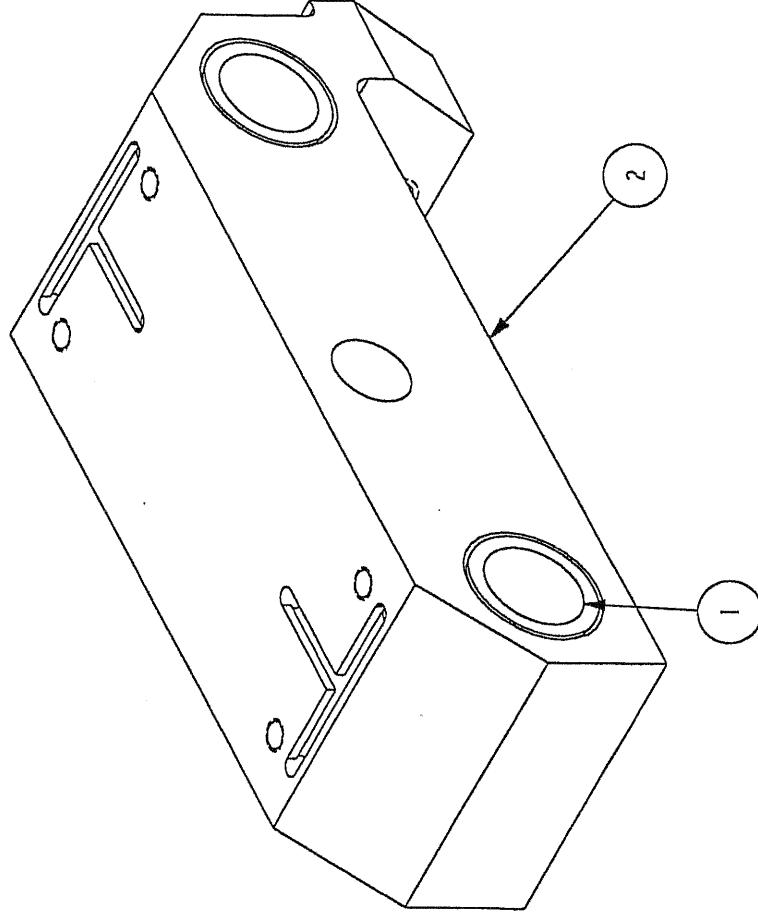
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1	1	100131	BUSHING, SL.250ID.375OD.1.250LG					
2	4	100145	BUSHING, SL.625ID.813OD.1.000LG					
3	2	109521	OIL METER UNIT					
4	2	109528	NUT, COMPRESSION FEMALE					
5	2	109537	SLEEVE, COMPRESSION					
6	1	190606	FITTING - 90 DEG 1/4 NPT					
7	1	190769	MAGNET. BUNTING					
8	1	500708	BODY, VACUUM VALVE					
9	1	500709	PLATE - VACUUM FEEDER					
10	1	500738	SPRING - VALVE					
11	1	500739	BLOCK - PUSHER					
12	1	500740	PLATE - VACUUM					
13	1	531155-01	PLATE, MAGNETIC					



1	531021-01	REO'D WHERE USED
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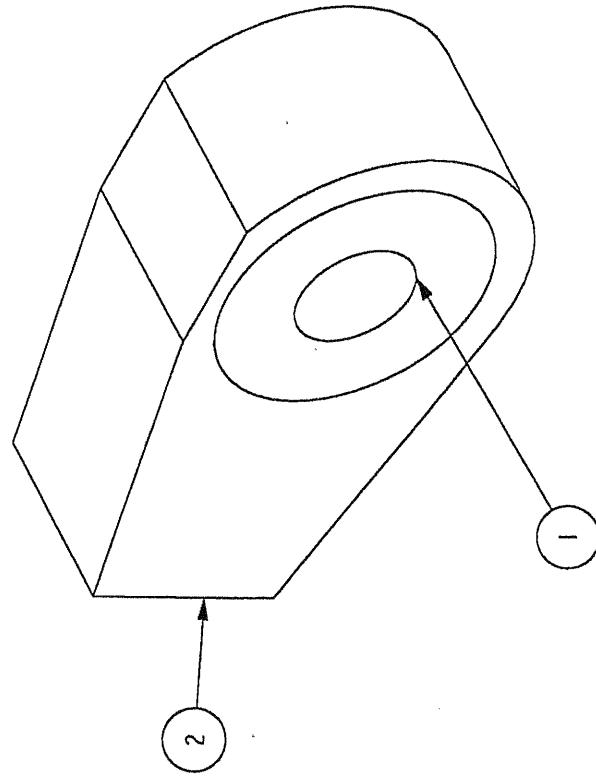
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1	4	100145 BUSHING, SL. 62510.8130D1.0000LG
2	1	500728 BRACKET - FEEDER



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							DRAWING #		500728A	
							REV NO	531021-01	RECD WHERE USED	

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



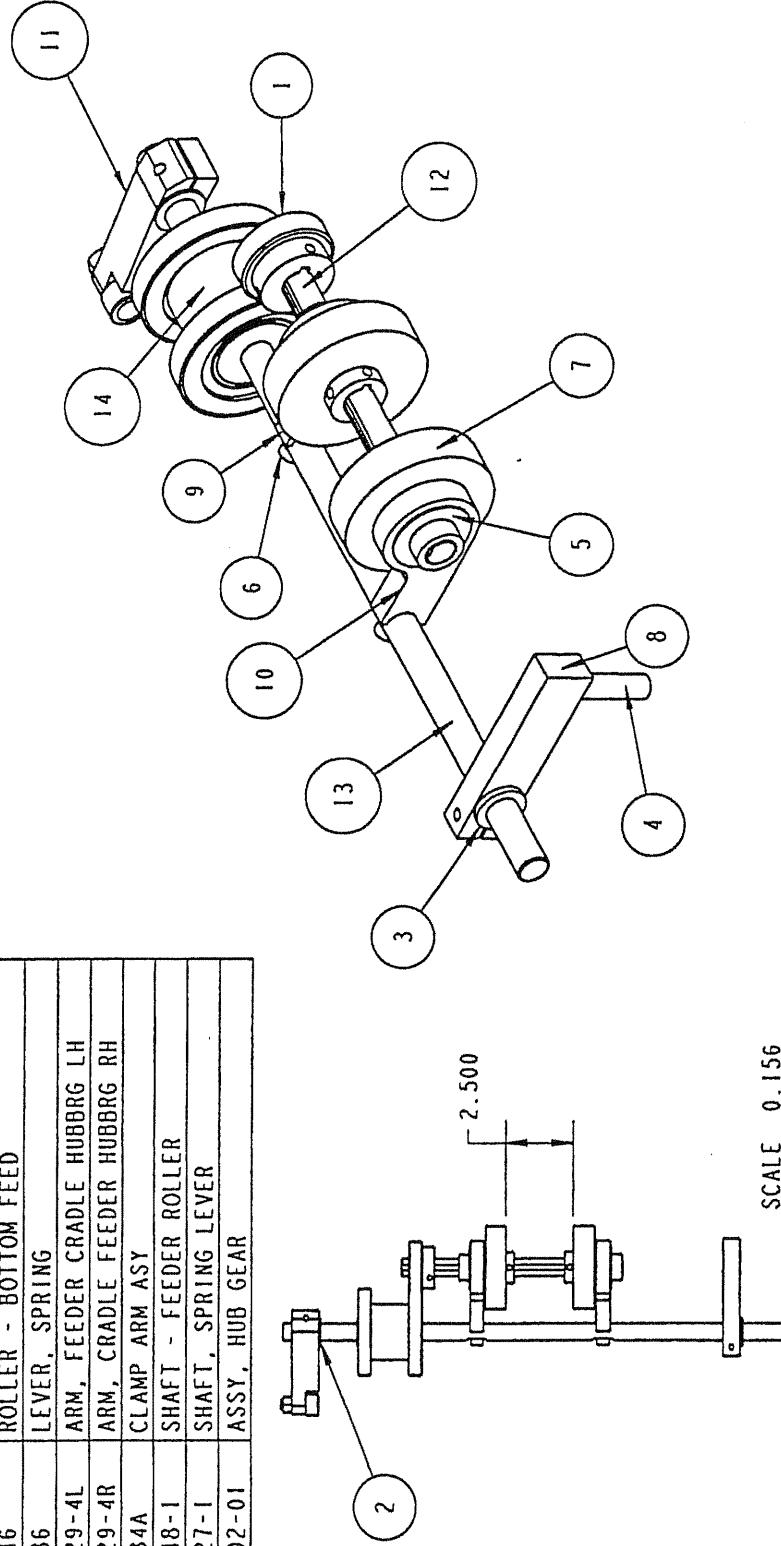
REV NO	DATE	DESCRIPTION	FCN NO	BY

DRAWN BY: M.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 KENNESAW, GA 30144 USA	
CHECKED BY:	DATE 09-Apr-99	.01	.005	ANG. .5	HEAT TREAT: N / A	MODEL: 215	TITLE: ASSY, BEARING BLOCK
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: 10F1	DRAWINGS: 500751A

1	531021-01
RECD WHERE USED	

ITEM QTY	PART #	DESCRIPTION
1	101916	GEAR, 1628 .625B .188K
2	102320	SHIM, .625X1.000X.062
3	2 102657	SHIM, .625X1.000X.125
4	1 102701	SPRING
5	2 103804	BEARING - HUB
6	2 107104	BOLT, SHOULDER 5/16X3/4
7	2 500746	ROLLER - BOTTOM FEED
8	1 500786	LEVER, SPRING
9	1 500729-4L	ARM, FEEDER CRADLE HUBBRG LH
10	1 500729-4R	ARM, CRADLE FEEDER HUBBRG RH
11	1 500734A	CLAMP ARM ASY
12	1 500748-1	SHAFT - FEEDER ROLLER
13	1 500827-1	SHAFT, SPRING LEVER
14	1 531102-01	ASSY, HUB GEAR



DRAWN BY:	SCALE	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	MATERIAL:
T JG	0 . 3   3	.005 .005 .005 .005	XXX
CHECKED BY:	DATE	.005 .005 .005 .005	HEAT TREAT:
TRACED BY:	MASTER	ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED	FINISH:

6 - 0C † - 98

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

M

REV NO	DATE	DESCRIPTION	L.C.N. NO	BY
1	11/27/2000	REPLACE 500729-2 WITH 500729-4 REPLACE FLAT BIRD W/ HUB BIRD	6624	TJG

1	534734-01
RECD	WHERE USED

KIRK - RUDY INC.  
KENNESAW, GEORGIA

324 - 1

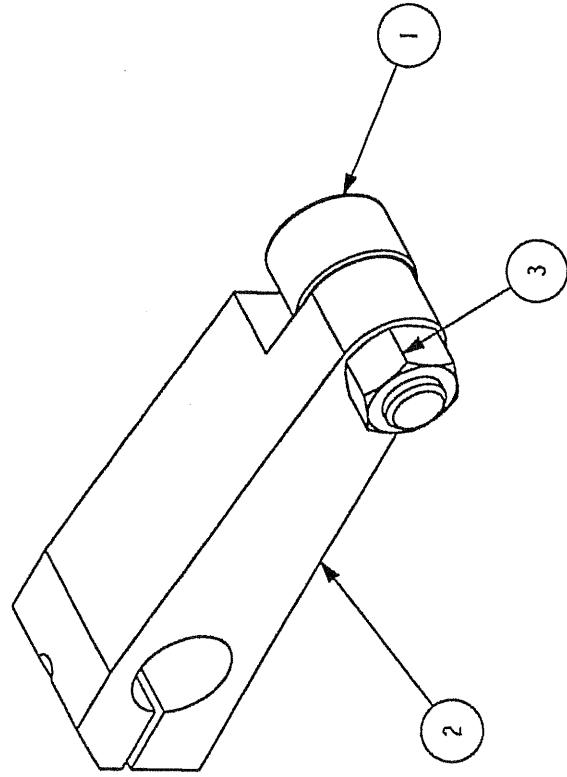
LOWER FEED ROLLER ASY

1 OF 1

DRAWING #

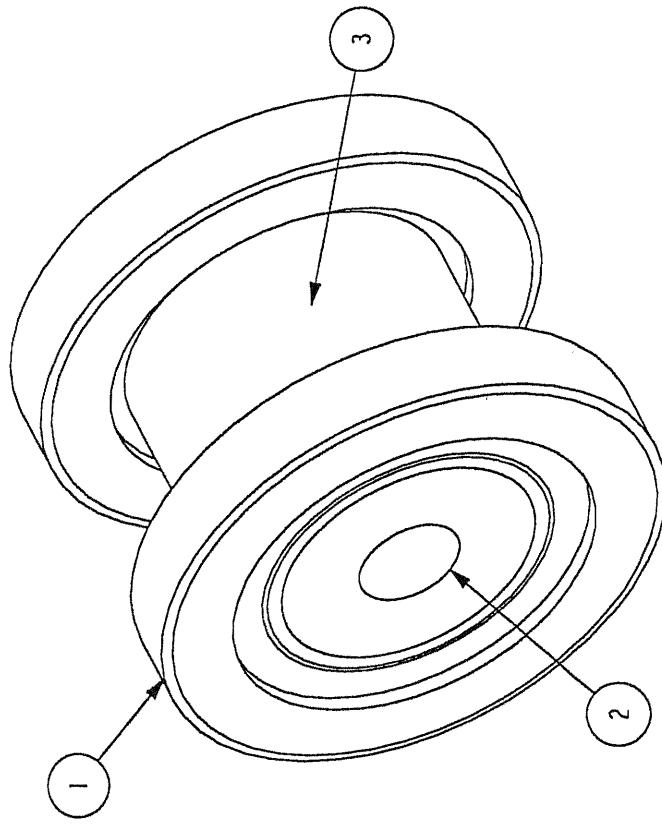
531022-02

ITEM QTY	PART #	DESCRIPTION
1	103405	CAM FOLLOWER
2	1	500734 LEVER - CAM
3	1	RHN012 HEX NUT



DRIVEN BY:	JLG	SCALE	1.000	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	MATERIAL: XXX	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. MENESAW, GA 30144 USA	PROPRIETARY AND CONFIDENTIAL RECO'D WHERE USED
CHECKED BY:		DATE	29-JUL-99	.01 -.005 .5	MEAT TREAT: XXX	NOTE: XXX	1
TRACED BY:		MASTER	M	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY	FINISH: XXX	SHEET NO.: 1 OF 1	531022-02
				KIRK - RUDY, INC. KENNE SAW, GEORGIA		DRAWING # 500734A	

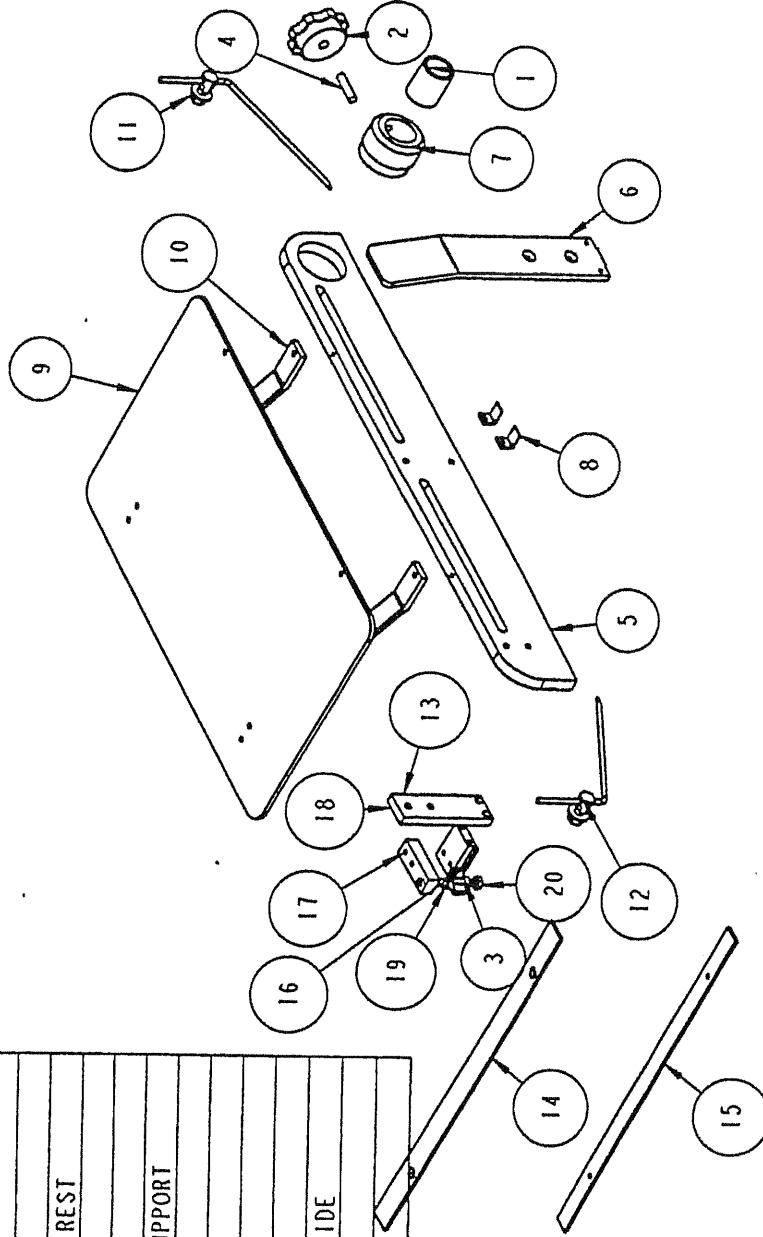
ITEM	QTY	PART #	DESCRIPTION
1	2	101918	GEAR, FEED ROLLER DRIVE
2	2	103804	BEARING, HUB .625
3	1	503622	HUB, GEAR



REV	NO	DATE	DESCRIPTION	ECR	NO	BT

1	531022-01
REV'D	WHERE USED
KR	KIRK - RUDY, INC.
KR	KENNESAW, GEORGIA
INTL:	
2   5	ASSY, HUB GEAR
SHEET NO. 1	DRAWING 1
M	53102-01



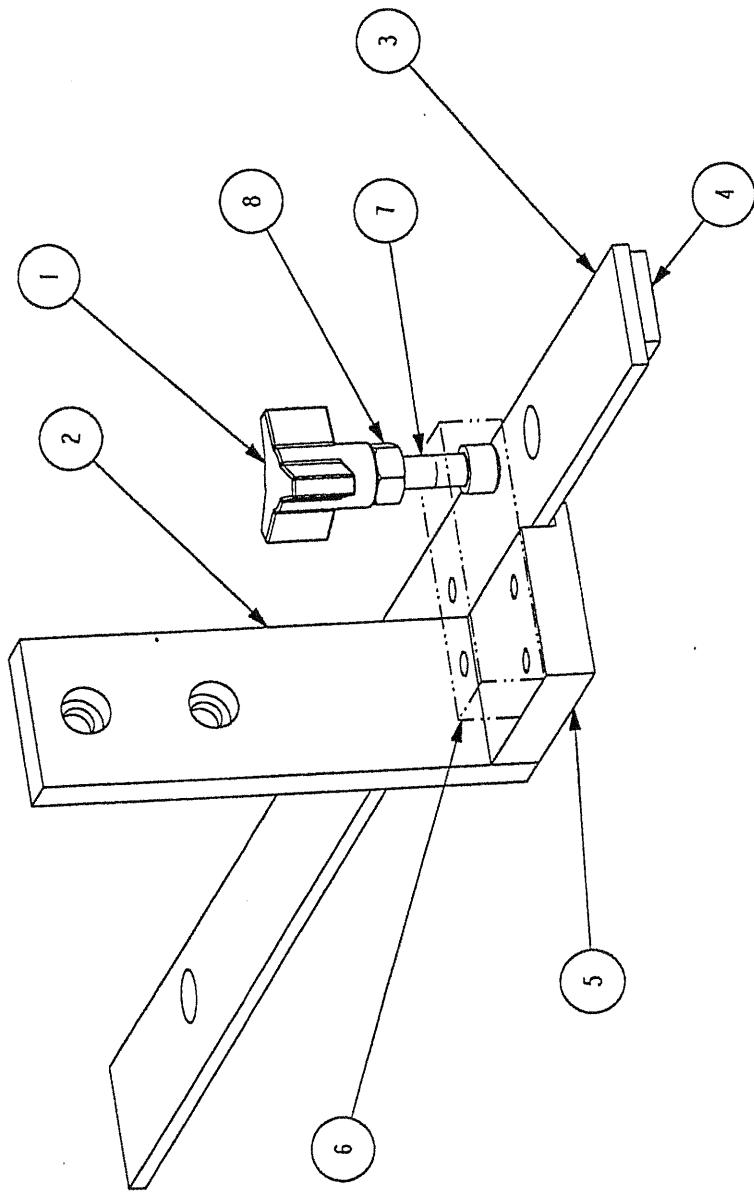


ITEM QTY	PART #	DESCRIPTION
1	1 100109	BUSHING, S.L. .000/01D. 25000D1. 5000LG
2	1 102112	KNOB, PURCHASED
3	1 102117	KNOB
4	1 105601	SHAFT, THREADED 5/16-18
5	1 500714	BRIDGE - READ GUIDE
6	1 500715	PLATE - REAR CENTER GUIDE
7	1 500770	HUB - REAR GUIDE SHAFT
8	2 500771	CLIP-SIDE GUIDE
9	1 500845	TABLE, JOGGER
10	2 500847	BRACE, COMPUTER FORM REST
11	1 500764AL	ASSY, LIFTER
12	1 500764AR	ASSY, LIFTER
13	1 500880-2	BRACKET, JOG TABLE SUPPORT
14	1 535813-01	BAR, SLIDE
15	1 535813-02	BAR, SLIDE
16	1 535814-01	BLOCK, SLIDE
17	1 536191-01	BAR, LOCKING
18	1 536406-01	ASSY, JOGGER TABLE SLIDE
19	1 CSDD297	
20	1 RHN010	HEX NUT

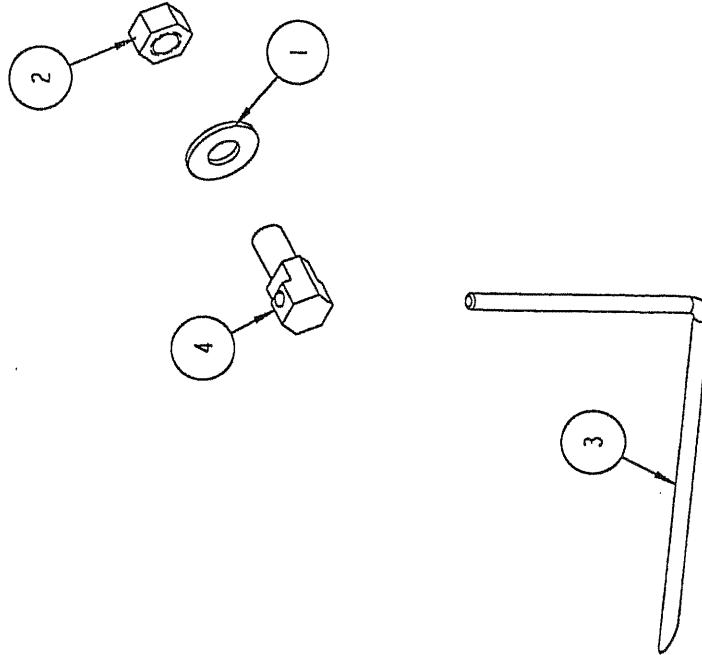
DRAWN BY:	SCALE:	DATE:	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	MATERIAL:	THIRD ANGLE PROJECTION	PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE QUOTED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY INC. KENNESAW, GA 30044 USA
RHM	0 . 150	.01 .005 .005	N/A	N/A	324-1	534734-01
CHECKED BY:	DATE:	8 - Nov - 99	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED	N/A	SCALE IN INCHES	REO'D WHERE USED
MAILED BY:	MASTER	M	ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY	N/A	1 OF 1	KIRK - RUDY, INC. KENNESAW, GEORGIA

536892-01

ITEM QTY	PART #	DESCRIPTION
1	102117	KNOB
2	500880-2	BRACKET, JOG TABLE SUPPORT
3	535813-01	BAR, SLIDE
4	535813-02	BAR, SLIDE
5	535814-01	BLOCK, SLIDE
6	536191-01	BAR, LOCKING
7	CSDD297	
8	RHN010	HEX NUT



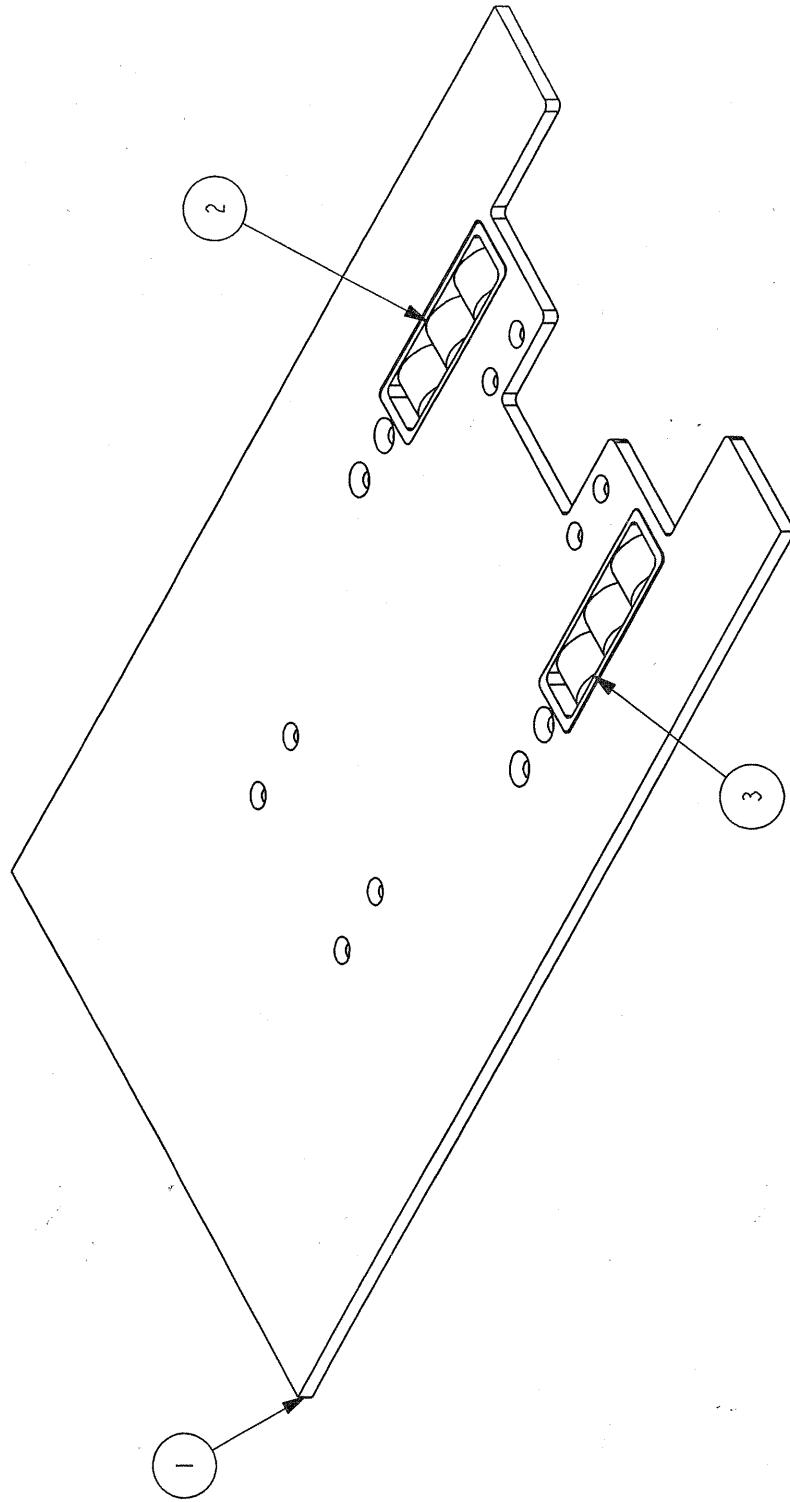
DRWNG BY:	SCALE	DATE	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	MATERIAL:	THIRD ANGLE PROJECTION	PROPRIETARY AND CONFIDENTIAL
AYB	0 . 750	-XX	.005	N/A		NOT TO BE COPIED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY INC., KENNESAW, GA 30144 USA
CHECKED BY:	06-May-99	.01	.005	HEAT TREAT:	MODEL: 512	TITLE:
TRACED BY:	MASTER			FINISH:	SHEET NO. 10F 1	DRAWING 1
REMOVE ALL BURS AND SHARP EDGES UNLESS OTHERWISE NOTED						ASSY, JOGGER TABLE SLIDE
ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY						536406-01



REV NO	DATE	DESCRIPTION	ECN NO	BY
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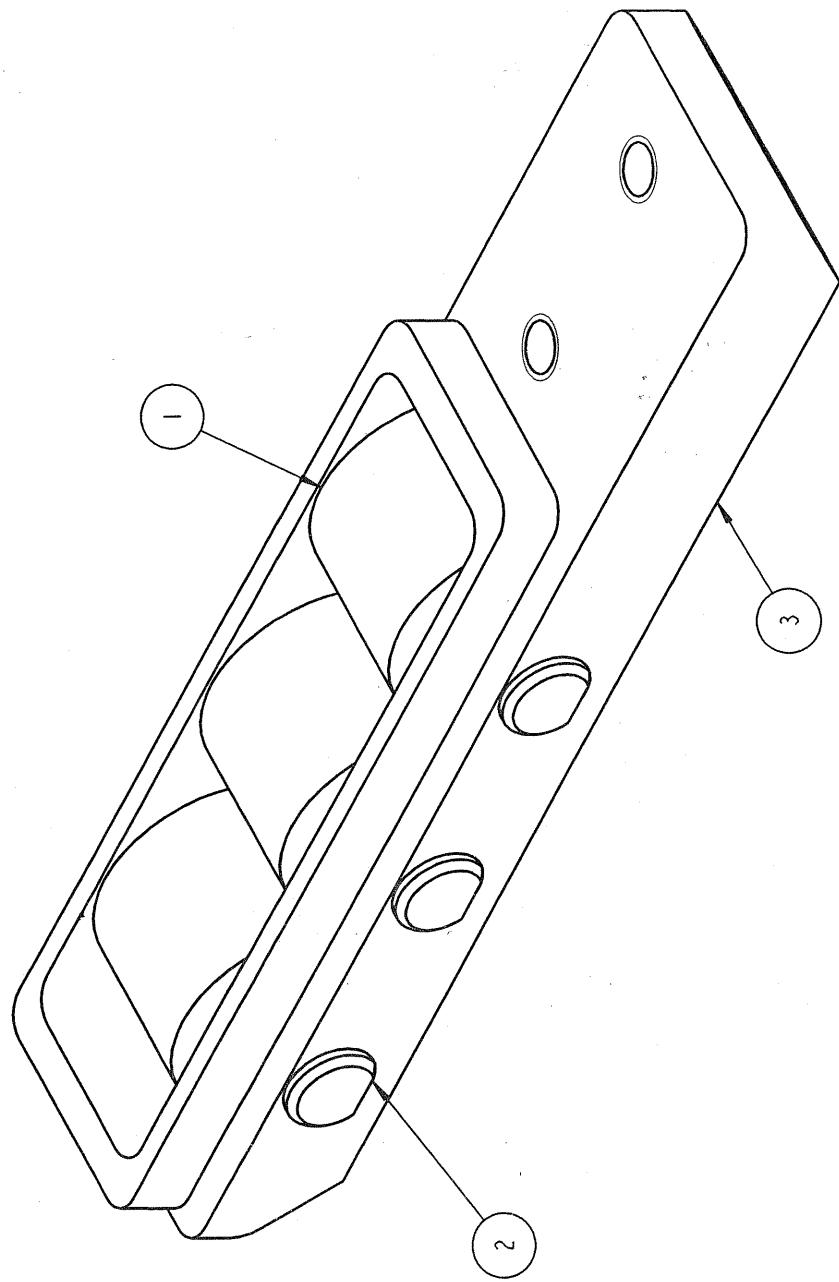
RECD:		WHERE USED							
DRWNG BT#:	N JG	SCALE	0 . 500	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	MATERIAL:	N / A	THIRD ANGLE PROJECTION	PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE COPIED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY INC. KENNESAW, GA 30144 USA	KIRK - RUDY, INC. KENNESAW, GEORGIA
CHECKED BT#:		DATE	23 - Ju l - 97	.005 .005 .5	HEAT TREAT:	N / A	MODEL:	215	ASSY, LIFTER
TRACED BT#:		MASTER		REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED	FINISH:	N / A	SHEET NO.:	10F1	DRAWING #:

ITEM QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	EON NO	BY
1	1	508703 PLATE, FEEDER					
2	1	SP39952-1A ASSY, BLOCK ONE WAY ROLLER LH					
3	1	SP39952-A ASSY, BLOCK ONE WAY ROLLER RH					



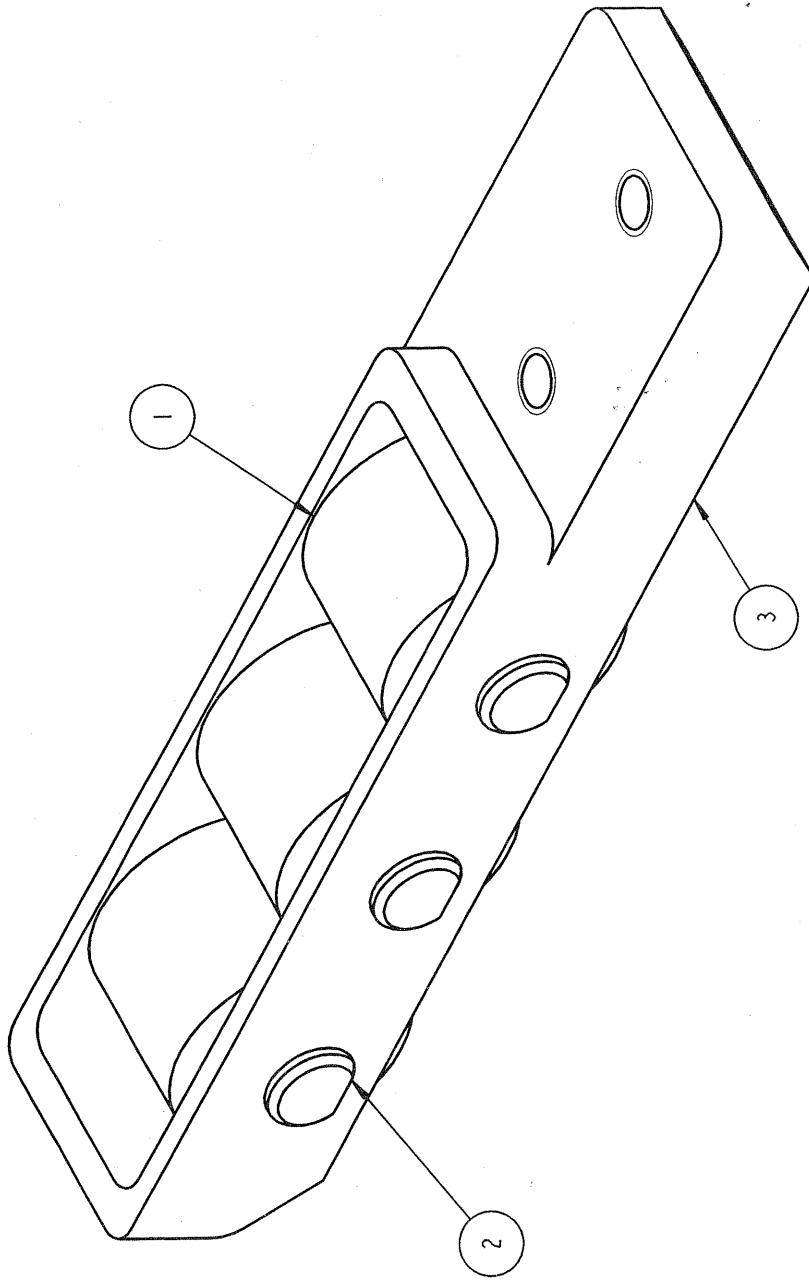
DRAWN BY:	CMC	SCALE	0 . 375	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	MATERIAL: XXX	THIRD ANGLE PROJECTION	KIRK - RUDY, INC.
CHECKED BY:		DATE	07 - Jun - 04	.xx .xxx .01	.005 .5	NO PORTION OF THIS DRAWING MAY BE QUOTED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC. WOODSTOCK, GA 30188 USA	WOODSTOCK, GEORGIA
TRACED BY:	M	FINISH:	XXX	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED	XXX	NOTE: 324-1	ASSY, SHUTTLE TABLE
				ALL DIMENSIONS ARE FINISHED DIMENSIONS		SHEET NO.: 10F1	DRAWING #:
				DO NOT SCALE - WORK TO DIMENSIONS ONLY			534733-02

ITEM QTY	PART #	DESCRIPTION
1	3	533194-01 ASSY, ONEWAY ROLLER
2	3	SP25751-1 SHAFT, ONE WAY
3	1	SP39952-R BLOCK, ONE WAY ROLLER RH



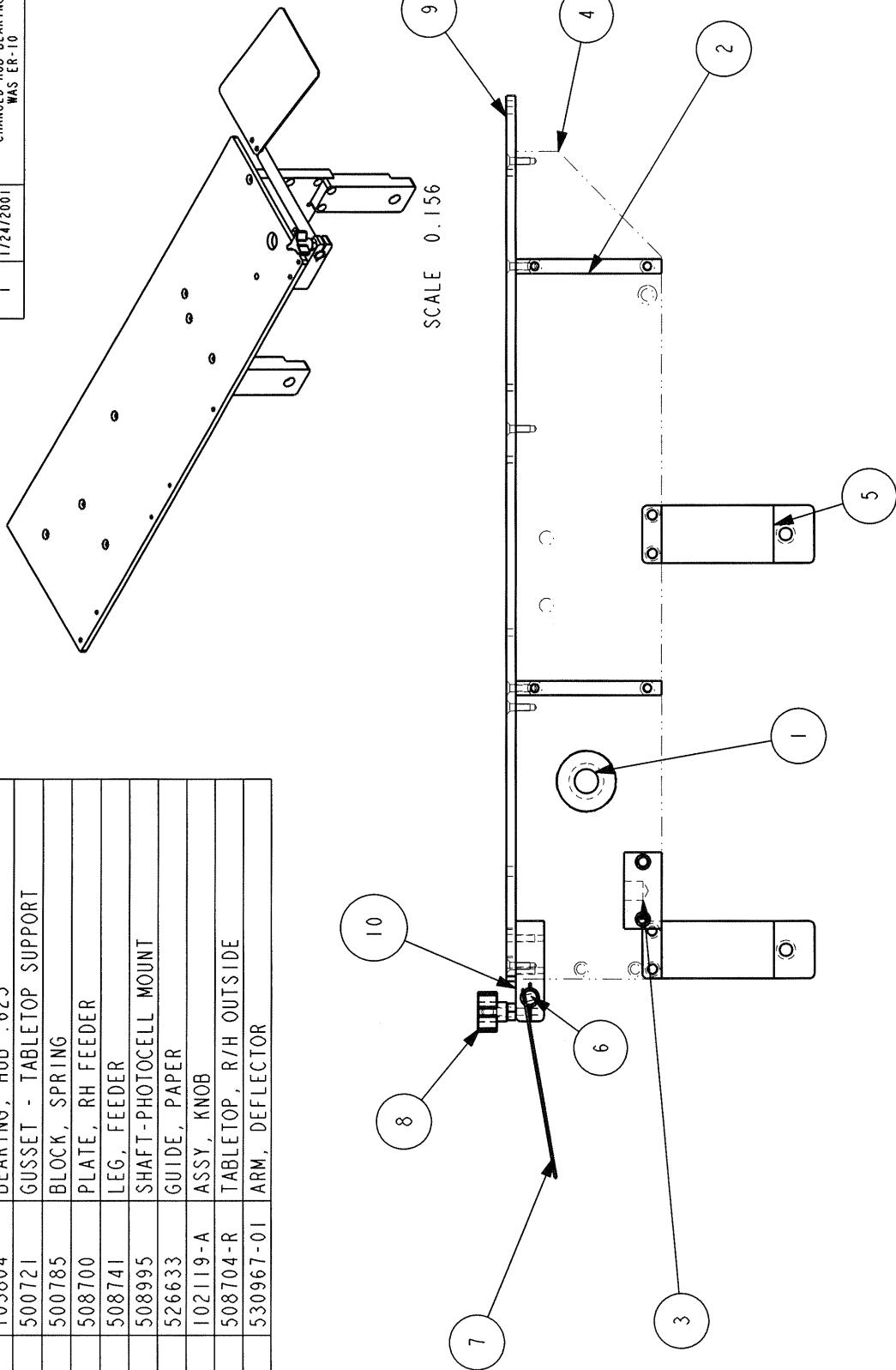
DRAWN BY: A KEY	SCALE 1 . 500	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED			MATERIAL: NOTED	THIRD ANGLE PROJECTION - - -	PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE COPIED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC. KENNESAW, GA 30144 USA	
CHECKED BY:	DATE 25-JUL-01	.XX	.XXX	ANG. .01 .005 .5	HEAT TREAT: NONE	MODEL: 324-1	TITLE: ASSY, BLOCK ONE WAY ROLLER RH	
TRACED BY:	MASTER <i>[Signature]</i>	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED			FINISH: NOTED	SHEET NO. 1 OF 1	DRAWING # SP39952-A	
ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY								

ITEM	QTY	PART #	DESCRIPTION
1	3	533194-01	ASSY, ONEWAY ROLLER
2	3	SP25751-1	SHAFT, ONE WAY
3	1	SP39952-L	BLOCK, ONE WAY ROLLER LH



DRAWN BY:	T JG	SCALE	.500	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	MATERIAL: NOTED	THIRD ANGLE PROJECTION	KIRK - RUDY, INC.
CHECKED BY:		DATE	17 - Sep - 02	.XX XXX ANG.	HEAT TREAT: NONE	MODEL: 324-1	KENNESAW, GEORGIA
TRACED BY:		MASTER		REMOVE ALL BURS AND SHARP EDGES UNLESS OTHERWISE NOTED		SHEET NO: 10F 1	SP39952-1A
				ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY		DRWING #: DRAFTING	

ITEM QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	1	103804 BEARING, HUB .625	1	1/24/2001	CHANGED HUB BEARING WAS ER 10	6652	TJS
2	2	500721 GUSSET - TABLETOP SUPPORT					
3	1	500785 BLOCK, SPRING					
4	1	508700 PLATE, RH FEEDER					
5	2	508741 LEG, FEEDER					
6	1	508995 SHAFT - PHOTOCELL MOUNT					
7	1	526633 GUIDE, PAPER					
8	1	102119-A ASSY, KNOB					
9	1	508704-R TABLETOP, R/H OUTSIDE					
10	1	530967-01 ARM, DEFLECTOR					

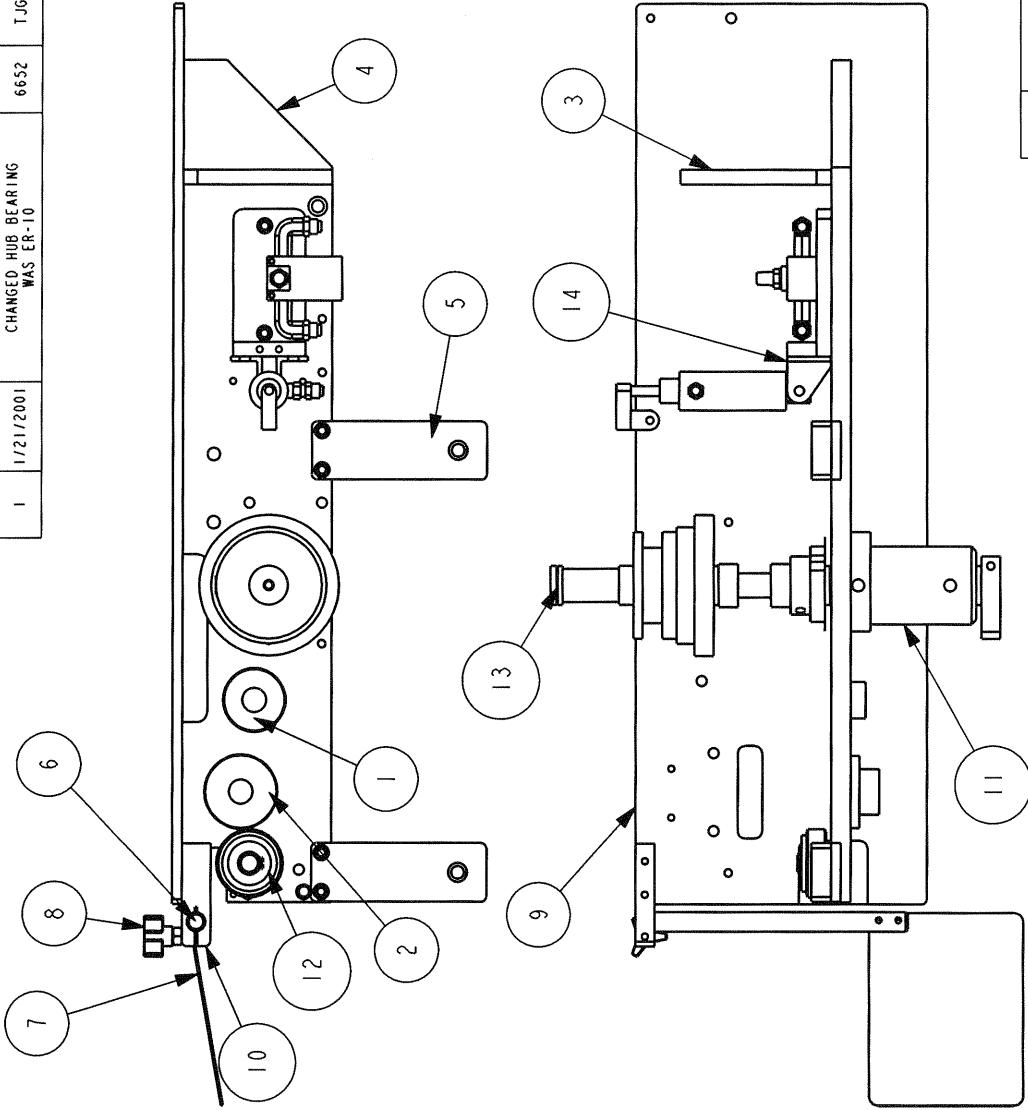


1	534734-01
REQ'D	WHERE USED
1	534734-01
PROPRIETARY AND CONFIDENTIAL	
NO PORTION OF THIS DRAWING	
MAY BE QUOTED OR REPRODUCED	
IN ANY FORM WITHOUT THE	
EXPRESS WRITTEN PERMISSION	
OF KIRK-RUDY, INC.	
WOODSTOCK, GA 30186 USA	
KIRK - RUDY - INC.	ASSY, FRAME RH
324-1	DRAWING #
SHEET NO. 1 OF 1	534735-01

DRAWING I

534736-01

REV NO	DATE	DESCRIPTION	ECN NO	BY
1	1/21/2001	CHANGED HUB BEARING WAS ER-0	6642	TJG



ITEM	QTY	PART #	DESCRIPTION
1	1	103804	BEARING, HUB .625
2	1	103812	BEARING, HUB .625
3	1	500721	GUSSET - TABLETOP SUPPORT
4	1	508604	PLATE, LH FEEDER
5	2	508741	LEG, FEEDER
6	1	508995	SHAFT-PHOTOCELL MOUNT
7	1	526633	GUIDE, PAPER
8	1	102119-A	ASSY, KNOB
9	1	508704-L	TABLETOP, L/H OUTSIDE
10	1	530967-01	ARM, DEFLECTOR
11	1	531106-01	ASSY, HUB
12	1	534739-01	ASSY, IDLER 1626 GEAR
13	1	534740-01	ASSY, CRANK SHAFT
14	1	534746-01	CYLINDER MOUNT

DRAWN BY:		SCALE		DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED		MATERIAL:	THIRD ANGLE PROJECTION	PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE QUOTED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC. WOODSTOCK, GA 30188 USA	
JL G		0 . 2   8		.01	.005	ANG.			
CHECKED BY:		DATE		HEAT TREAT:		N/A	TITLE:		ASSY, FRAME LH
		28 - JU 1 - 99		REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED		N/A	DRAWING #		DRAWING 1
TRACED BY:		MASTER		ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE • WORK TO DIMENSIONS ONLY		N/A	SHEET NO.		1 OF 1

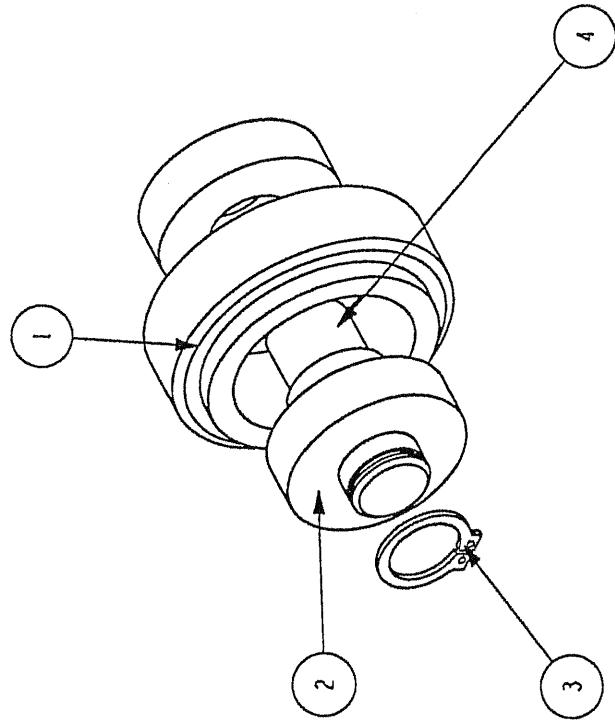
DRAWING II

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

A technical line drawing of a mechanical assembly. It features a long cylindrical shaft with a flange at one end. A circular component, labeled with a circled '2' (2), is attached to the shaft. This component has two small circular holes. The shaft extends into a housing, which contains a bearing. The housing has two larger circular holes. A second circular component, labeled with a circled '-' (−), is shown below the housing, also featuring a central hole.

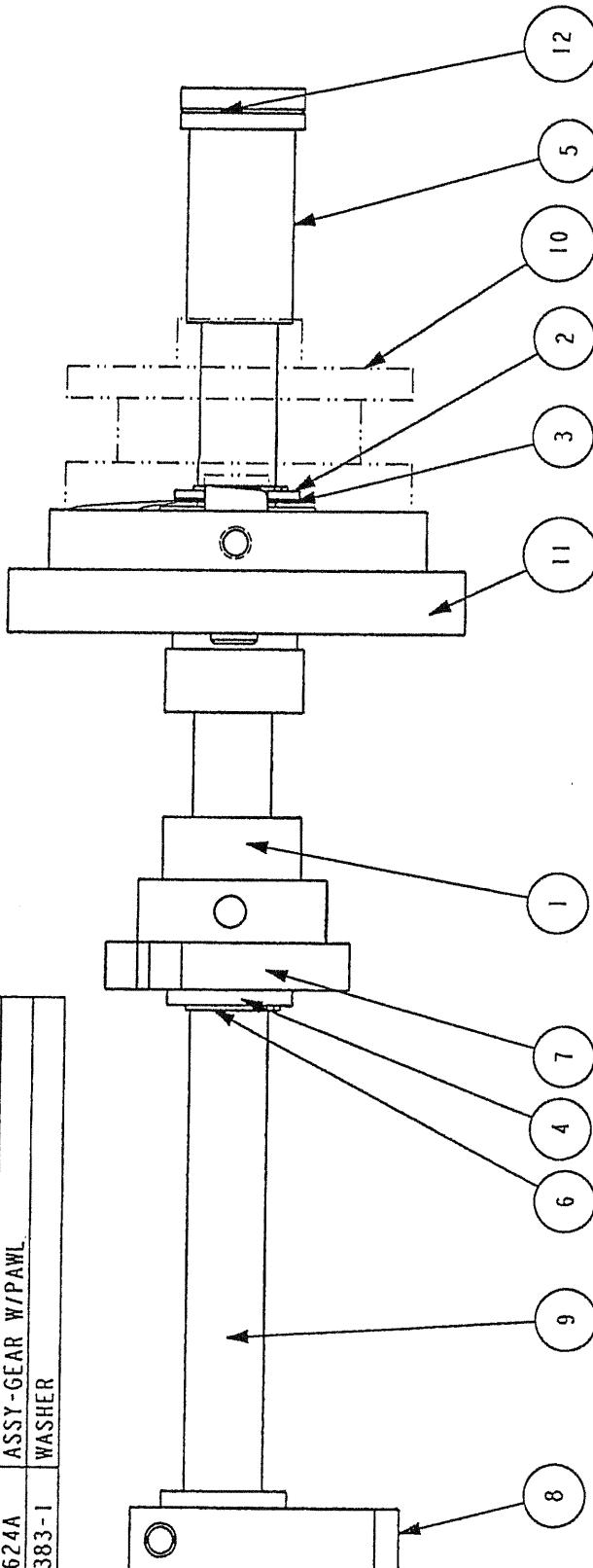
DRAWN BY:	JLG	SCALE	.000	MATERIAL:	N/A	THIRD ANGLE PROJECTION	KIRK - RUDY, INC.	RECD' WHERE USED
DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED				PROPRIETARY AND CONFIDENTIAL NO BORROWING OF THIS DRAWING MAY BE QUOTED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC. KENNESAW, GA 30144 USA				
CHECKED BY:		DATE	28-JUL-99	MEAT TREAT:	N/A	MODEL:	215	MAIL:
REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED				DRAWING:				DRAWING A
TRACED BY:	MASTER	FINISH:	N/A	SHEET NO.:	10F1			

ITEM	QTY	PART #	DESCRIPTION
1	1	101946	GEAR, 1626 1.124B NK
2	2	103108	BEARING, FLAT .500
3	1	104106	SNAPRING, .500
4	1	508682	STUD, IDLER GEAR



DRAWN BY:	JLG	SCALE:	1.000	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	MATERIAL: XXX	THIRD ANGLE PROJECTION	PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE QUOTED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC. KENNESAW, GA 30144 USA
CHECKED BY:		DATE:	28-JUL-99	.XX	.XXX	VIEW:	KRK - KIRK-RUDY, INC. KENNESAW, GEORGIA
TRACED BY:				.01	.005	NOTE:	ASSY, IDLER 1626 GEAR
						SHEET NO.:	1 OF 1
						DRAWING #:	534739-01

ITEM/OITY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	2	102203 COLLAR .625					
2	1	102320 SHIM, .625X1.000X.062					
3	1	102560 SHIM, .625X1.000X.025					
4	4	102657 SHIM, .625X1.000X.125					
5	1	102722 SPRING, COMPRESSION					
6	2	104104 SNAPPING, .625					
7	1	500747 CAM - FEED ROLLERS					
8	1	500750 CRANK - FEEDER SLIDE					
9	1	508637 SHAFT, CRANK					
10	1	508720 COLLAR, SHUTTLE DRIVE					
11	1	508624A ASSY-GEAR W/PAWL					
12	1	SP6383-1 WASHER					



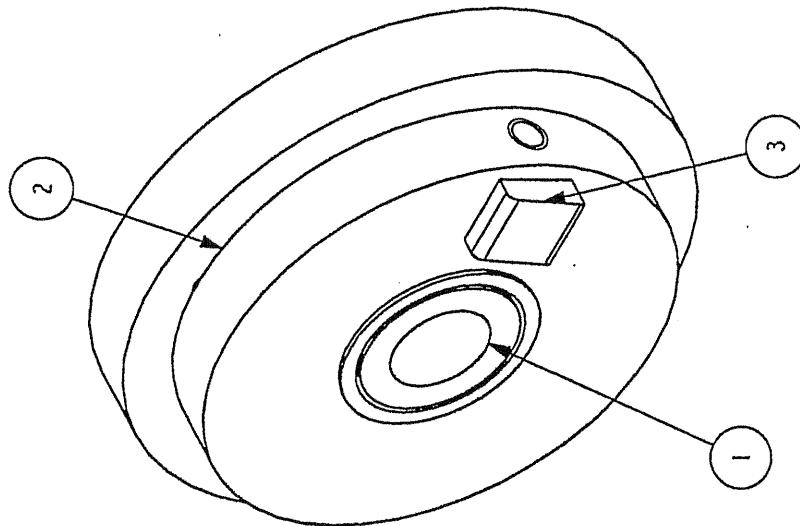
I	534736-01
RECD	WHERE USED

**K** KIRK - RUDY INC.  
**K** KENNESEE, GEORGIA

ASSY, CRANK SHAFT

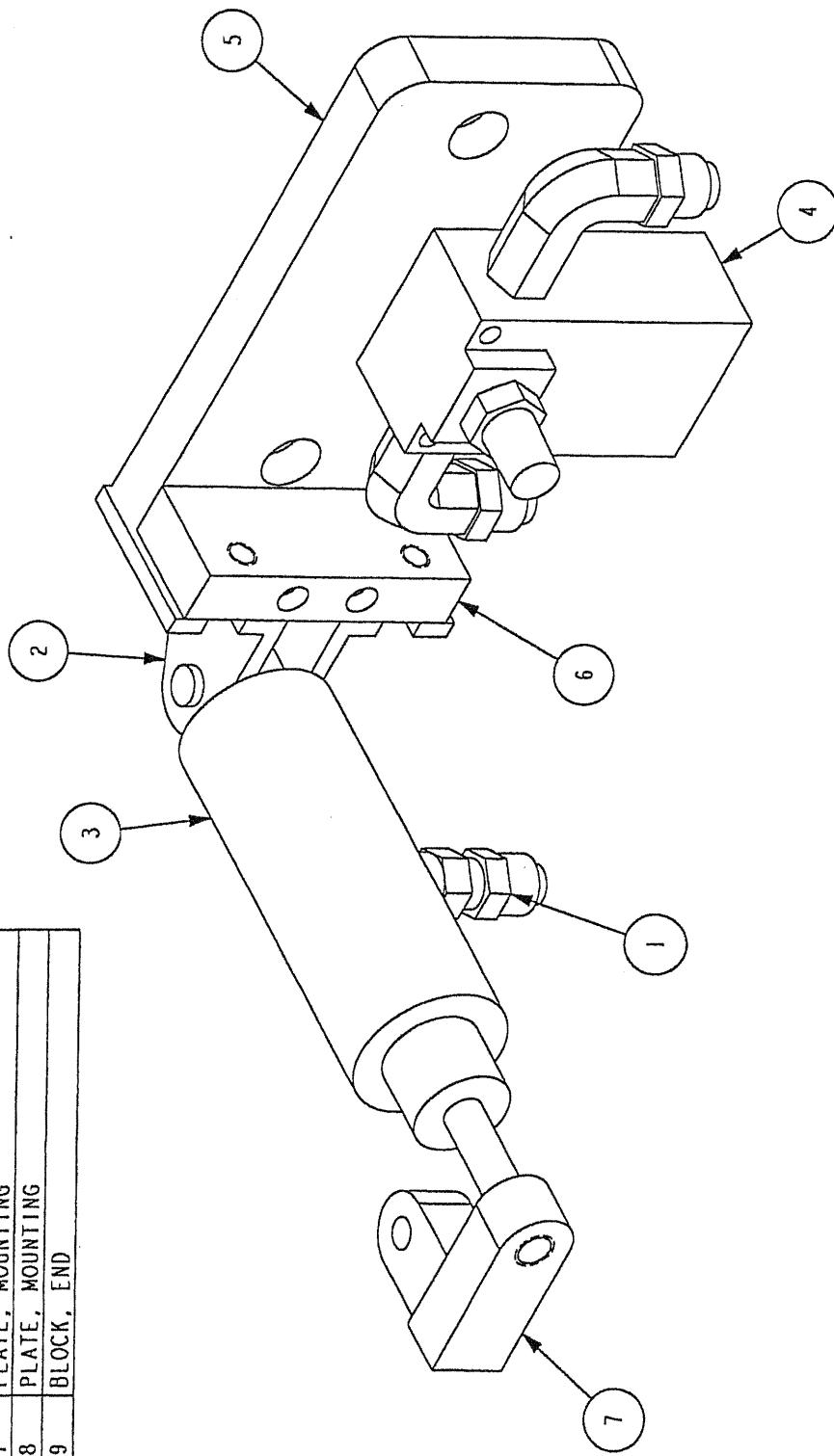
DRAWN BY:	JLG	SCALE:	0 .750	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	XXX	THIRD ANGULAR PROJECTION	PROPRIETARY AND CONFIDENTIAL MAY BE OBLITERATED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC. KENNESSEE, GA 30444 USA	
CHECKED BY:		DATE:	28-JUL-99	.01 .015 .065 .06	REAT TREAT:	XXX	MODEL:	324-1
TRACED BY:	M	MASTER		REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED	FINS:	XXX	STL#:	10F
				ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY			DRAWING #	534740-01

ITEM QTY	PART #	DESCRIPTION
1	1 00146	BUSHING, SL. 6251D1.0000D1.000LG
2	1 508624	HUB, CLUTCH
3	1 508645	PAWL



1	534740-01
REV'D	WHERE USED
<b>KR KIRK-RUDY, INC.</b>	
<b>KR KENNESEAW, GEORGIA</b>	
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. KENNESEAW, GA 30144 USA	
DATE:	SP 65900
REAR:	XXX
MAKER:	MASTER M
FINISH:	XXX
NOTE:	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY
THIRD ANGLE PROJECTION	TOP VIEW
MATERIAL:	XXX
DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	.01 .005 .005 .005 .005 .005
SCALE:	1 .000
DRAWN BY:	JLG
CHECKED BY:	28-JUL-99
TRACED BY:	
SHEET NO. 1 OF 1	DRAWINGS 1

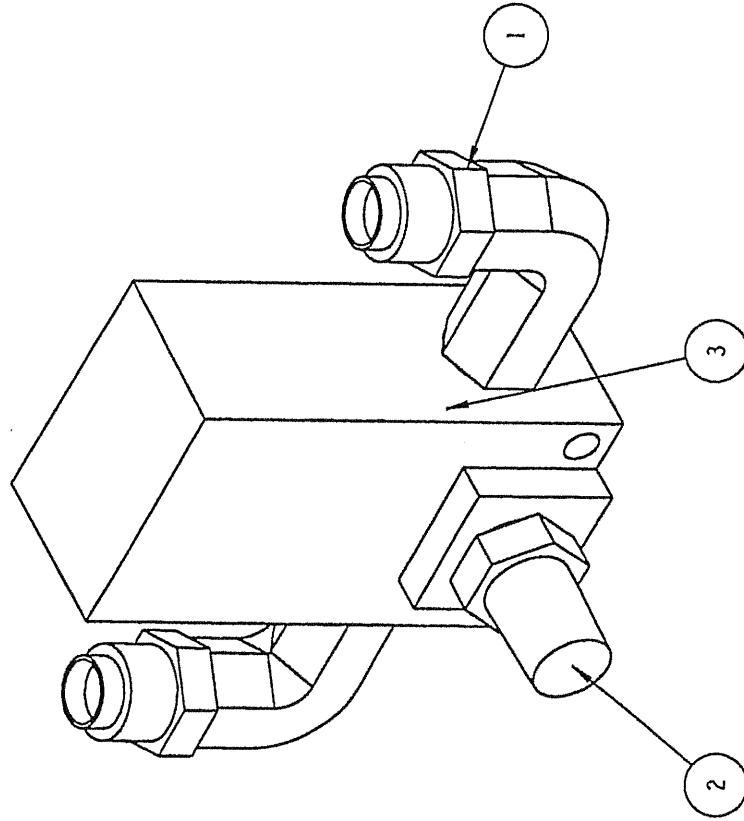
ITEM	QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	1	109529	CONNECTOR, PIPE					
2	1	109552	PIVOT BRACKET, BIMBA					
3	1	109606	CYLINDER, AIR BIMBA					
4	1	533824-01	ASSY, SOLENOID					
5	1	SP39267	PLATE, MOUNTING					
6	1	SP39268	PLATE, MOUNTING					
7	1	SP39269	BLOCK, END					



DRAWN BY:	JG	SCALE	1 . 000	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	N/A	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	6-0 c t - 98	.xx .xxx .xx .xx .xx .xx	N/A	HEAT TREAT:	N/A		
TRACED BY:		MASTER	M	-61 -.605 -.5	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED	FINISH:	N/A	MODEL:	324-1
				ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY		SKETCH NO.:	10F1	TITLE:	ASSY, CYLINDER MOUNT

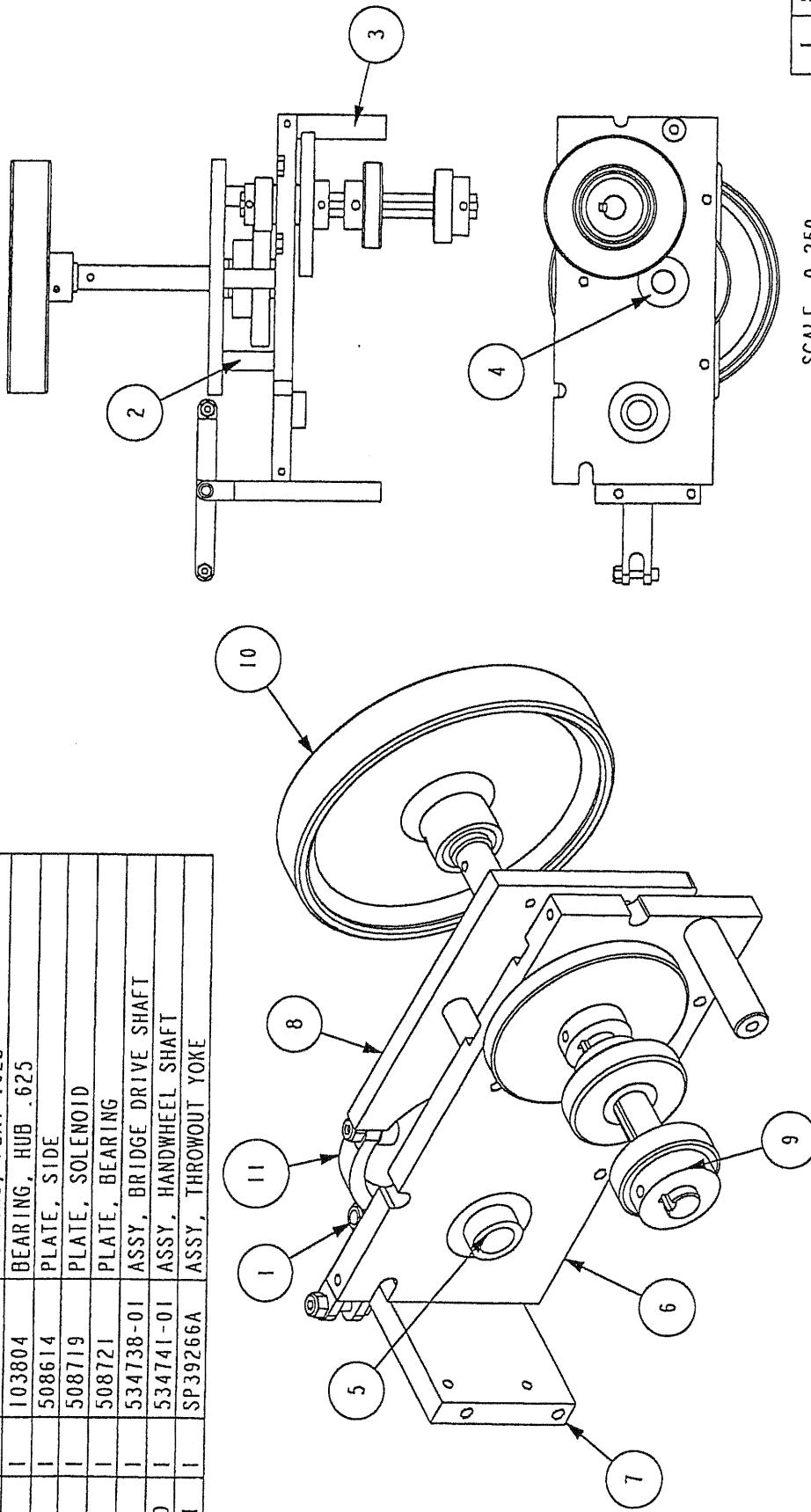
534746-01

ITEM	QTY	PART #	DESCRIPTION
1	2	109530	ELBOW, MALE 1/4 NPT
2	1	109671	MUFFLER, SINTERED
3	1	202298	VALVE, AIR 2AVDC



DRAWN BY:	SCALE	MATERIAL:	PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE DUPLICATED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC. KENNESAW, GA. 30144 USA
MY	.500	N/A	
CHECKED BY:	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	HEAT TREAT:	DATE:
	.01 .005 ANG.	N/A	26 - May - 98
TRACED BY:	MASTER	FINISH:	STREET NO.:
	M	N/A	10F1
RECD	WHERE USED		
		KIRK - RUDY, INC. KENNESAW, GEORGIA	
		ASSY, SOLENOID	
		DRAWING # 533824-01	

ITEM	QTY	PART #	DESCRIPTION
1	2	100310	BUSHING, FL.250ID.375OD.375LG
2	3	102670	SPACER
3	1	102672	SPACER, SIDE PLATE
4	3	103110	BEARING, FLAT .625
5	1	103804	BEARING, HUB .625
6	1	508614	PLATE, SIDE
7	1	508719	PLATE, SOLENOID
8	1	508721	PLATE, BEARING
9	1	534738-01	ASSY, BRIDGE DRIVE SHAFT
10	1	534741-01	ASSY. HANDWHEEL SHAFT
11	1	SP39266A	ASSY, THROWOUT YOKE



DRAWN BY: SCALD

**REQ'D WHERE USED**

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REQ'D	WHERE USED
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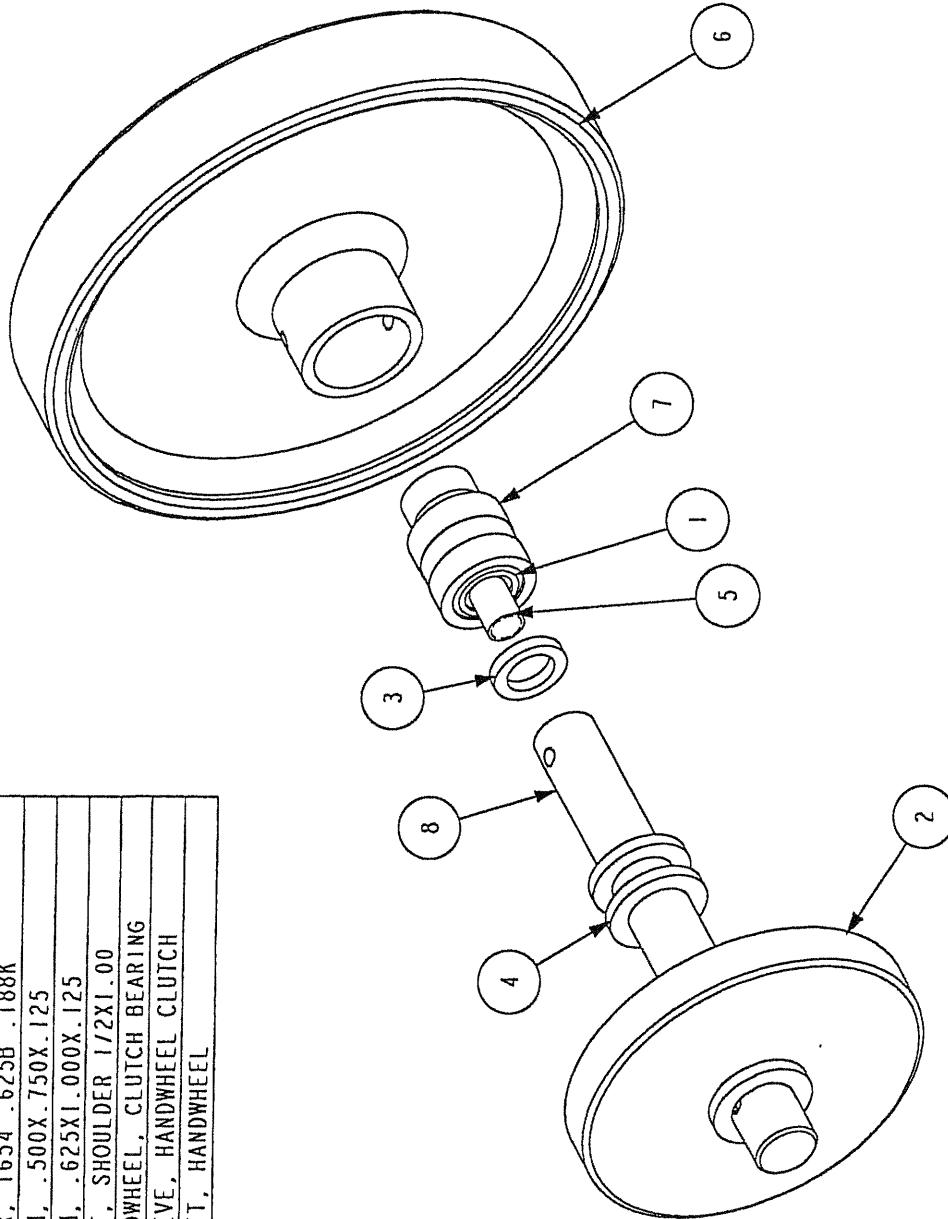
ITEM	QTY	PART #	DESCRIPTION
1	1	101708	GEAR, 2072 .625B .188K
2	1	101916	GEAR, 1628 .625B .188K
3	3	102657	SHIM, .625X1.000X.125
4	2	102671	SHIM, .625X1.000X.031
5	1	501638	SHAFT, FEEDER ROLL
6	1	508747	GEAR, SPUR 1633
7	1	101902-1	GEAR, 1620 .625B .188K

REV NO	DATE	DESCRIPTION	ECN NO	BY

1 534737-01  
REV'D WHERE USED

SCALE: <b>JLG</b>	0 . 750	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	XXX	THIRD ANGLE PROJECTION	PROPRIETARY AND CONFIDENTIAL NO REPRODUCTION OR DERIVATION MAY BE CONDUCTED OR MADE IN WHOLE OR IN PART EXCEPT WITH THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, KENNESAW, GA 3044 USA
CHECKED BY:		.005	.005		
DATE:	28-JUL-99				
REMADE BY:					
MASTER:	<b>M</b>	REMADE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED	XXX	MODEL: <b>324-1</b>	NAME: <b>KIRK - RUDY, INC.</b>
TRACED BY:		ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY	XXX	SHEET NO: <b>10F1</b>	ADDRESS: <b>KIRK-RUDY, KENNESAW, GA 3044 USA</b>
				DRAWING #	534738-01

ITEM	QTY	PART #	DESCRIPTION
1	1	101102	BEARING, ONEWAY .500
2	1	101988	GEAR, 1654 .625B .188K
3	1	102301	SHIM, .500X.750X.125
4	3	102657	SHIM, .625X1.000X.125
5	1	107254	BOLT, SHOULDER 1/2X1.00
6	1	102108-2	HANDWHEEL, CLUTCH BEARING
7	1	500763-6	SLEEVE, HANDWHEEL CLUTCH
8	1	508648-2	SHAFT, HANDWHEEL



REV NO	DATE	DESCRIPTION	ECN NO	BY

1	534731-01
REQ'D	WHERE USED

**KR** KIRK - RUDY, INC.  
KENNESAW, GEORGIA



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

DATE:

324-1

MODEL:

ASSY, HANDWHEEL SHAFT

REVISION:

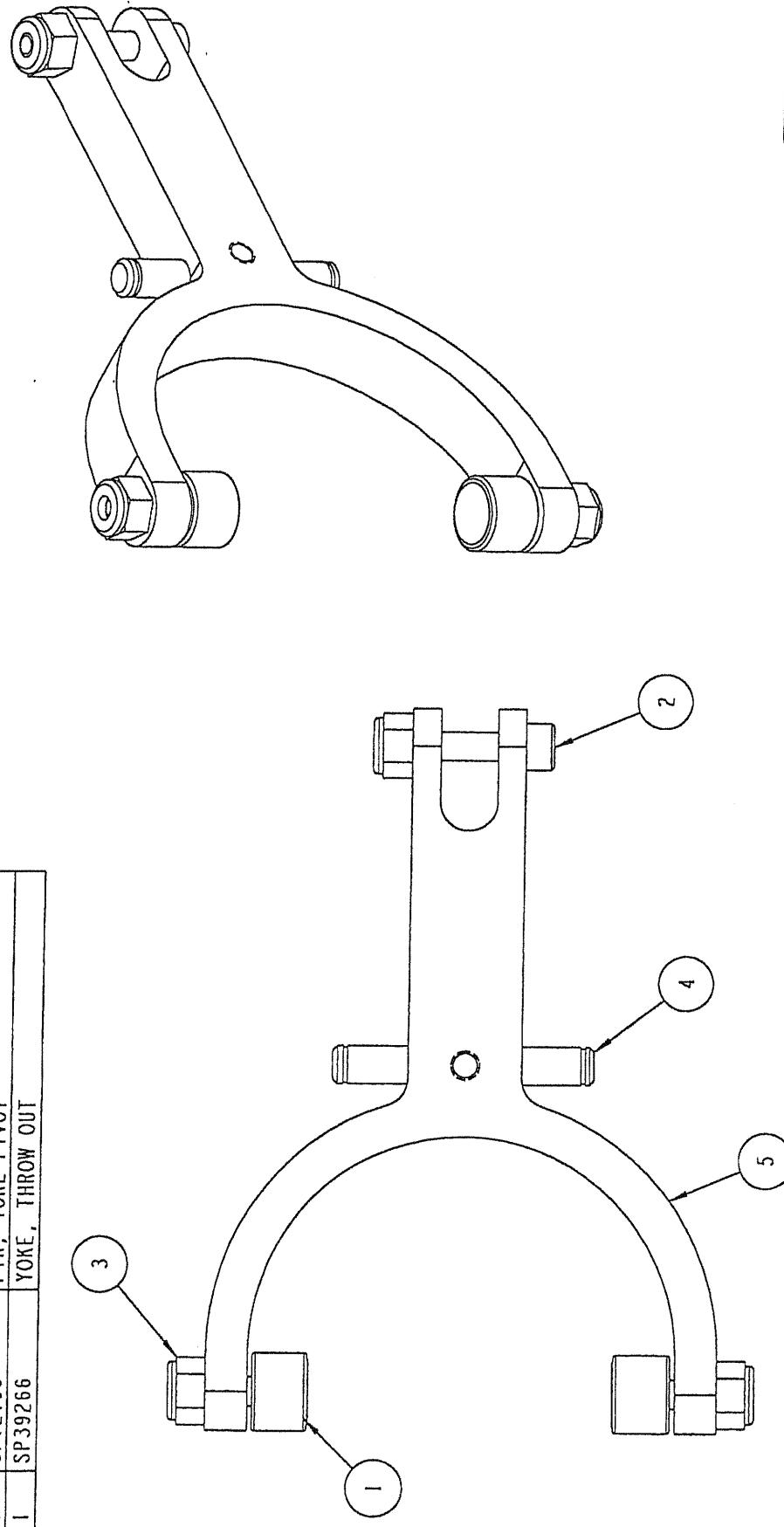
10F

DRAWING #:

534741-01

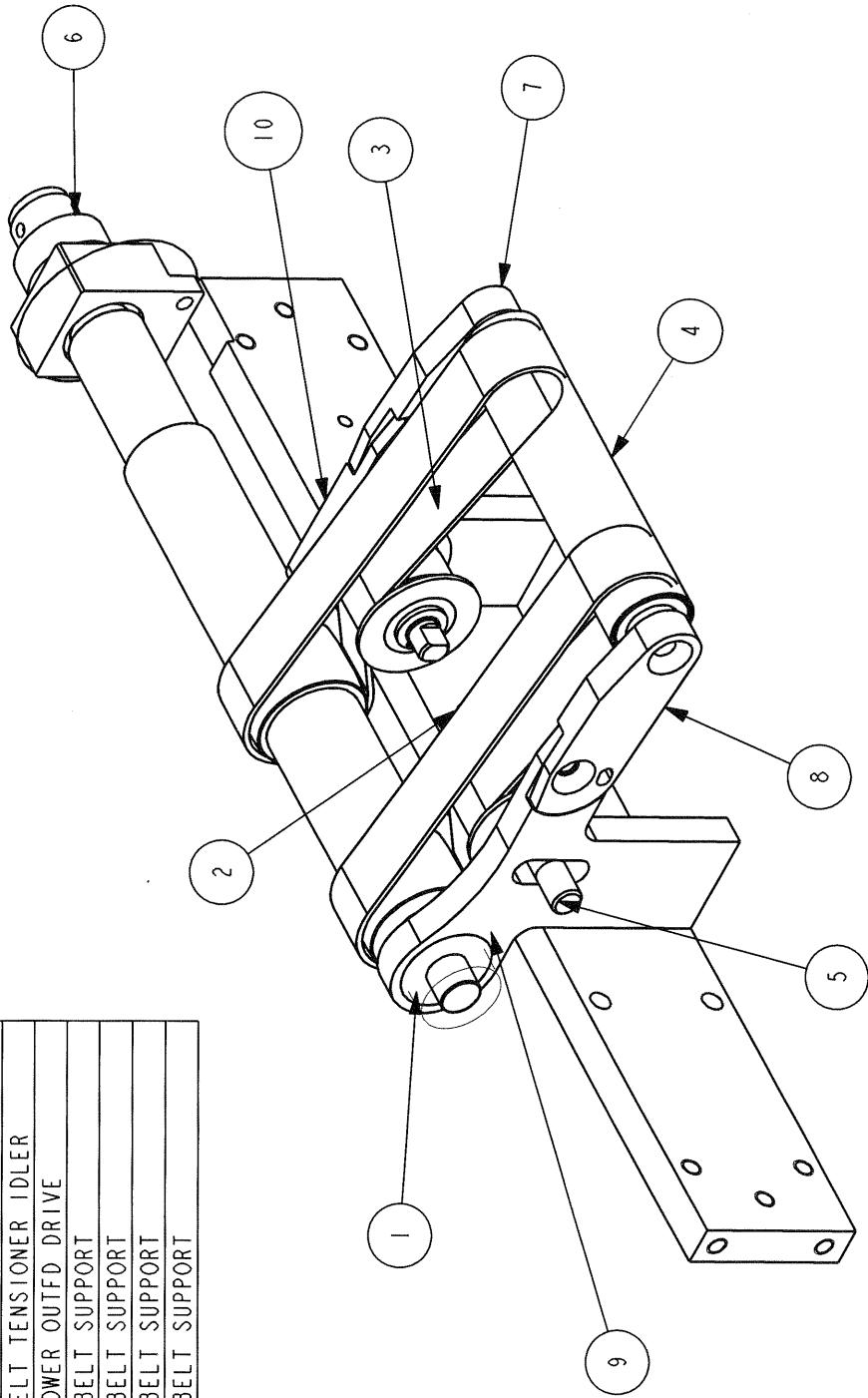
DRAWN BY:	SCALE	DATE	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	MATERIAL:	THIRD ANGLE PROJECTION	PROPRIETARY AND CONFIDENTIAL
JL G	0 .600	-	.XX -.XX -.XX	XXX	-	NO PORTION OF THIS DRAWING MAY BE QUOTED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC. KENNESAW, GA 30144 USA
CHECKED BY:		28-JUL-99	.61 -.005 -.5	WEAT TREAT:	XXX	
TRACED BY:	MASTER			FINISH:	XXX	

ITEM	QTY	PART #	DESCRIPTION
1	2	103408	CAM FOLLOWER
2	1	CSD269	
3	3	LOCKNUT-10-32	HEX STUD
4	1	SP12199	PIN, YOKE PIVOT
5	1	SP39266	YOKE, THROW OUT



DRAWN BY:	SCALE	1 . 000	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	X X X	THIRD ANGLE PROJECTION	PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE QUOTED OR REPRODUCED IN WHOLE OR IN PART EXCEPT WITH WRITTEN PERMISSION OF KIRK-RUDY INC. KENNESAW, GA 30144 USA
CHECKED BY:	DATE	.005	.005	X X X	HEAT TREAT:	SP 65900
TRACED BY:	MASTER	M	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY	X X X	SMALL NO.	10F 1
					DRAWING #	SP39266A
					REV'D	XXX

ITEM QTY	PART #	DESCRIPTION
1	103108	BEARING, FLAT .500
2	111874	BLUE BELT, FLAT 3/4 X 13.25
3	508766	BAR, CROSS
4	534743-01	ASSY, LOWER OUTFD ROLLER
5	534744-01	ASSY, BELT TENSIONER IDLER
6	534745-01	ASSY, LOWER OUTFD DRIVE
7	SP6306-IL	PLATE, BELT SUPPORT
8	SP6306-IR	PLATE, BELT SUPPORT
9	SP6306-6R	PLATE, BELT SUPPORT
10	SP6306-8L	PLATE, BELT SUPPORT



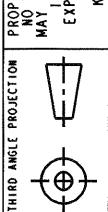
ITEM	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	1	12/8/2004	MODIFIED 534745-01 ASSY WITH ONE PIECE SHAFT/TROLLER	7126	TJG

1	534734-01
REQ'D	WHERE USED

KRK KIRK - RUDY, INC.  
KENNESAW, GEORGIA



PROPRIETARY AND CONFIDENTIAL  
NO PORTION OF THIS DRAWING  
MAY BE QUOTED OR REPRODUCED  
IN ANY FORM, WITHOUT THE  
EXPRESS WRITTEN PERMISSION  
OF KIRK-RUDY, INC.  
KENNESAW, GA 30044 USA



THIRD ANGLE PROJECTION

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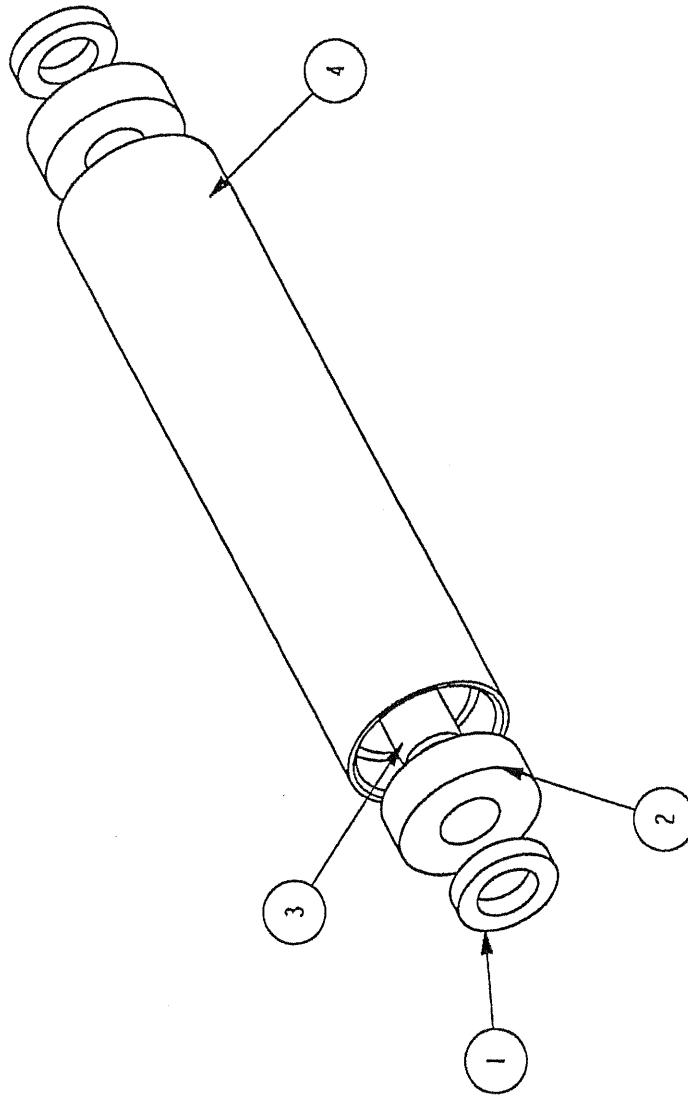
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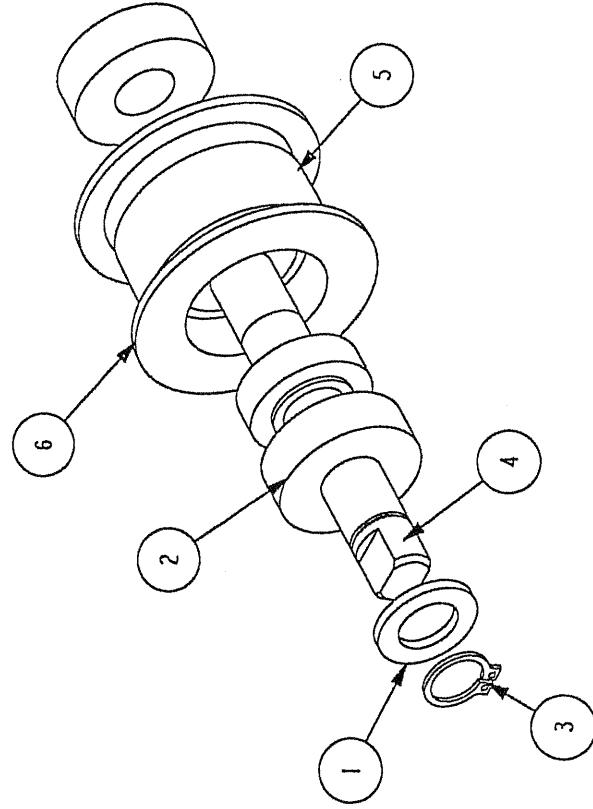
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ITEM	QTY	PART #	DESCRIPTION
1	2	102345	SHIM. .375X.625X.125
2	2	103106	BEARING, FLAT .375
3	1	512303	SHAFT, ROLLER
4	1	508763-2	ROLLER, IDLER



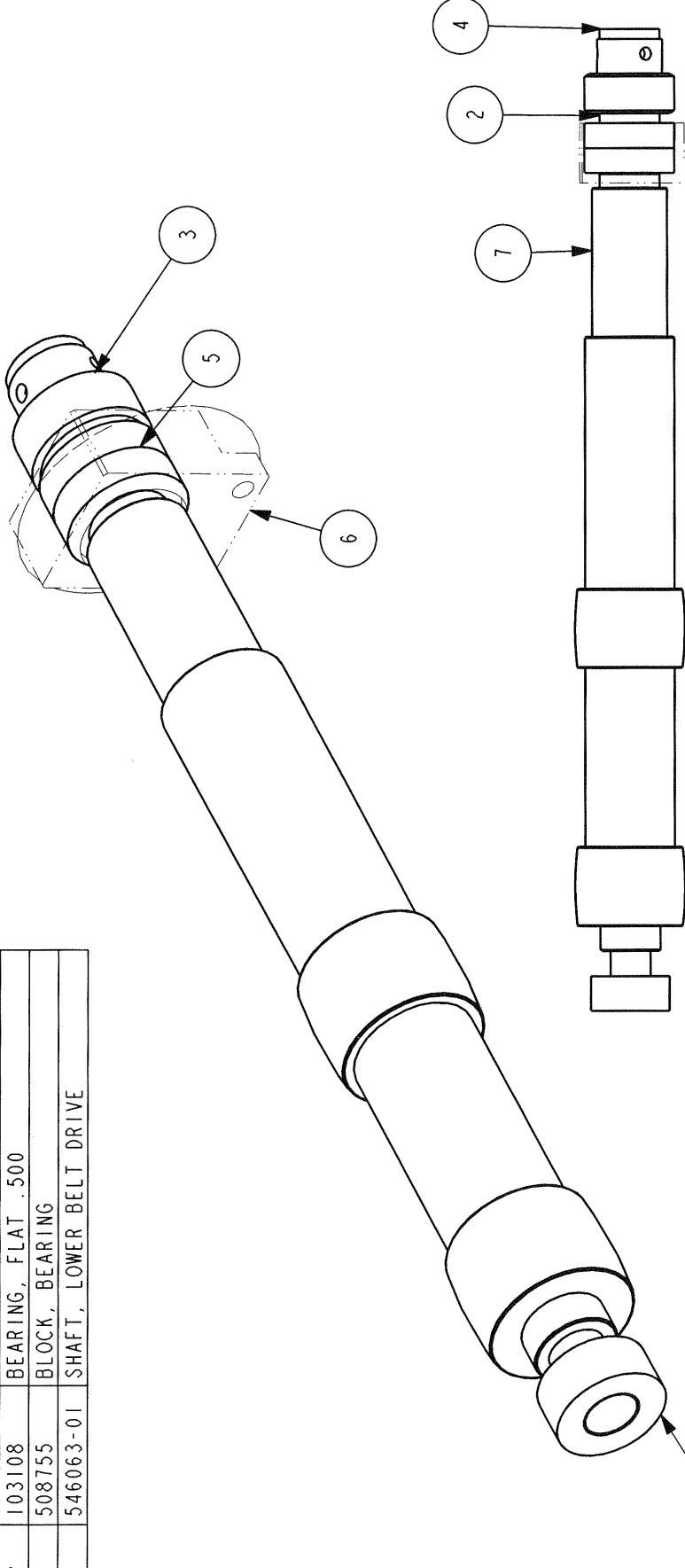
DRAWN BY:	SCALE:	1 . 000	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	MATERIAL: XXX	THIRD ANGEL PROJECTION	PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE QUOTED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC. KENNESAW, GA 30144 USA
CHECKED BY:	DATE:	27 - JU 1 - 99	.xx .xxx .xxx .xxx .5	HEAT TREAT:	NOTE: 324 - 1	NAME: KIRK - RUDY, INC.
TRACED BY:	MASTER:	M	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY	FINISH:	STL# 10F	ADDRESS: KENNESAW, GEORGIA
				DRWING #:	534743-01	534743-01

ITEM QTY	PART #	DESCRIPTION
1	102308	SHIM, .375X.625X.062
2	103106	BEARING, FLAT .375
3	1	104100 SNAPRING, .375
4	1	508762 STUD, TAKE UP
5	1	510611-1 ROLLER, IDLER
6	1	510611-1A ASSY-ROLLER



REV NO	DATE	DESCRIPTION	ECN NO
			BY
2			534742-01
REQ'D WHERE USED			
<b>KRK</b> KIRK - RUDY, INC.			
KENNESAW, GEORGIA			
PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE QUOTED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC. KENNESAW, GA 30144 USA			
DRAWING #:			ASSY, BELT TENSIONER IDLER
SCALE:			534744-01
JLG	1.000	MATERIAL: XXX	THIRD ANGLE PROJECTION
DATE:	27-JUL-99	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	NOTE: - .01 .005 .5
CHECKED BY:		ANG.	HEAT TREAT: XXX
TRACED BY:	MASTER M	REMOVED ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED	FINISH: XXX
		ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE WORK TO DIMENSIONS ONLY	SHEET NO.: 10F1

ITEM QTY	PART #	DESCRIPTION
1	102205	COLLAR .500
2	1 102301	SHIM, .500X.750X.125
3	1 102401	GEAR, 1616 .500B .125K
4	1 102552	SHIM, .25X.750X.125
5	2 103108	BEARING, FLAT .500
6	1 508755	BLOCK, BEARING
7	1 546063-01	SHAFT, LOWER BELT DRIVE



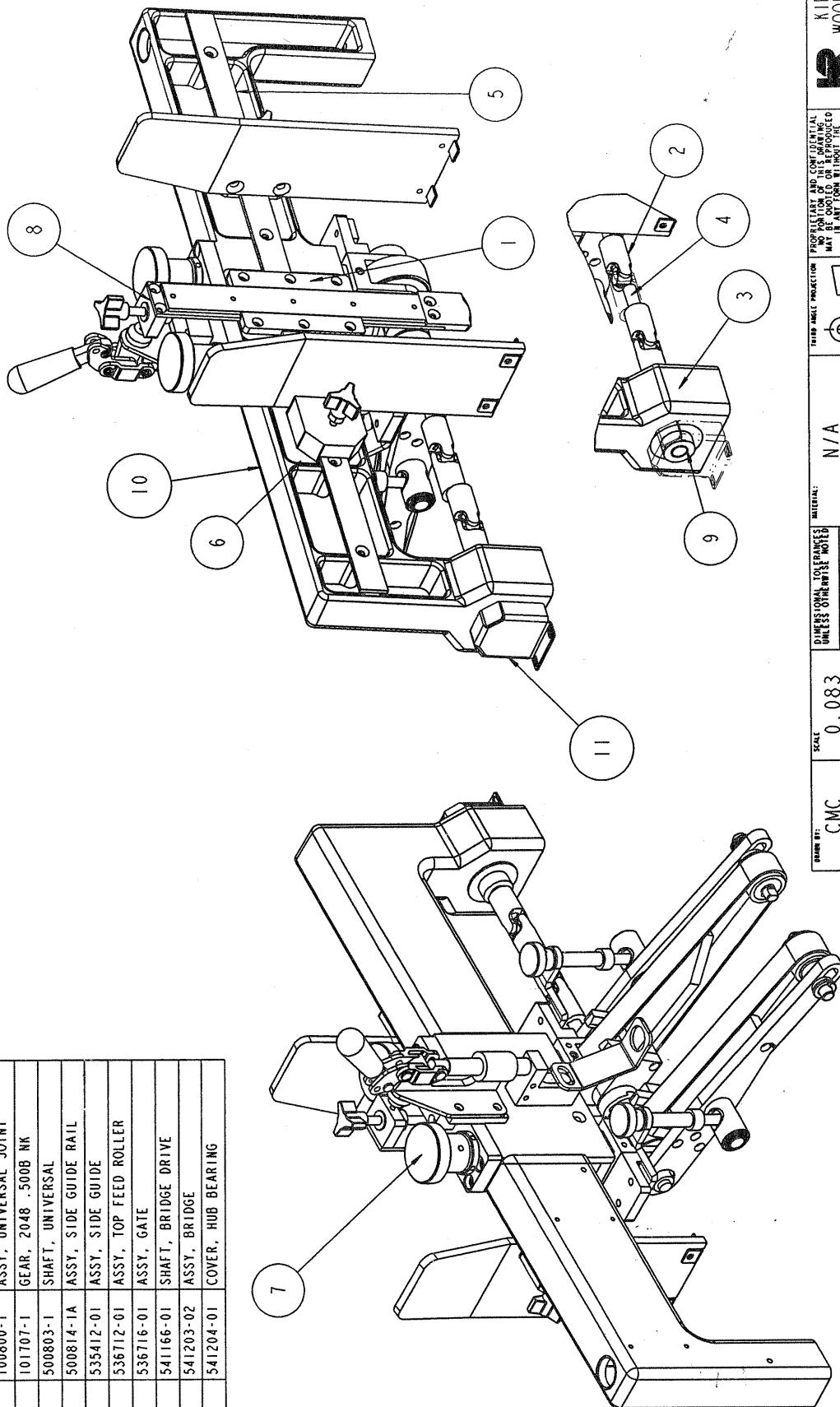
SCALE 0.500

DRAWN BY:	SCALE	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	MATERIAL:	THRO 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 30042, USA
JLG	0 .750	.XX .XXX .01 -.005 .5	N/A	⊕ - - - ⊕	KIRK - RUDY - INC.
CHECKED BY:	DATE	REMOVED ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED	HEAT TREAT:	324 - I	KENNE SAW, GEORGIA
TRACED BY:	MASTER	ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY	FINISH:	SHEET NO.: OF 1	TITLE: ASSY, LOWER OUTFD DRIVE
					534745-01

I 534742-01

REC'D WHERE USED

ITEM	QTY	PART #	DESCRIPTION	REV NO	DATE	ECN NO	ST
1	2	500805	PLATE - HOLD DOWN				
2	2	100800-1	ASSY, UNIVERSAL JOINT				
3	1	101707-1	GEAR, 2048 - 5008 HK				
4	2	500803-1	SHAFT, UNIVERSAL				
5	2	500814-1A	ASSY, SIDE GUIDE RAIL				
6	1	535412-01	ASSY, SIDE GUIDE				
7	1	536712-01	ASSY, TOP FEED ROLLER				
8	1	536716-01	ASSY, GATE				
9	1	541166-01	SHAFT, BRIDGE DRIVE				
10	1	541203-02	ASSY, BRIDGE				
11	1	541204-01	COVER, HUB BEARING				

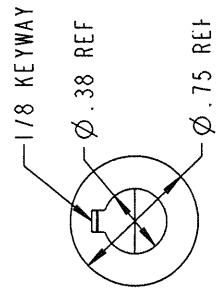
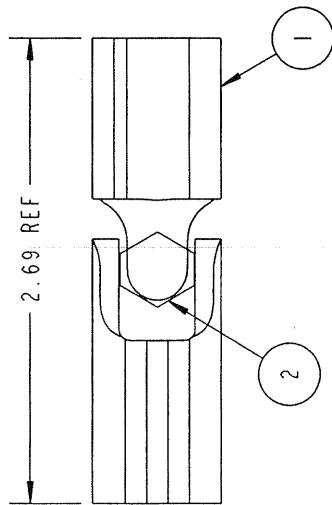


1	324-1
REO'D	WHERE USED

DRAWING BY: CMC	SCALE 0 . 083	DIMENSIONAL TOLERANCES		MATERIAL: N/A	TOLERANCE PRODUCTION PROPOSITION AND CONVENTIONAL MANUFACTURE OR REPRODUCED EXACT AND CONTROLLED IN MANUFACTURE BY THE MFG. CO., INC. WOODSTOCK, GA 30088 USA	TITLE: 324-1	KIRK-RUDY, INC. WOODSTOCK, GEORGIA
		IN.	MM.				
CHECKED BY:	DATE 07-JUN-04	.IN.	.MM.	WEAR TREAT:	N/A		
REMOVED FILE, SURFACE AND OPENNESS OF PARTS TO THIS DRAWING				ALL DIMENSIONS ARE INCHES UNLESS OTHERWISE NOTED. WORK DIMENSIONS ONLY	N/A	MAKER	540033-02
TRACED BY:						10F 1	

ITEM	QTY	PART #	DESCRIPTION
1	2	100800-1_1	UNIVERSAL
2	1	100800-3	UNIVERSAL

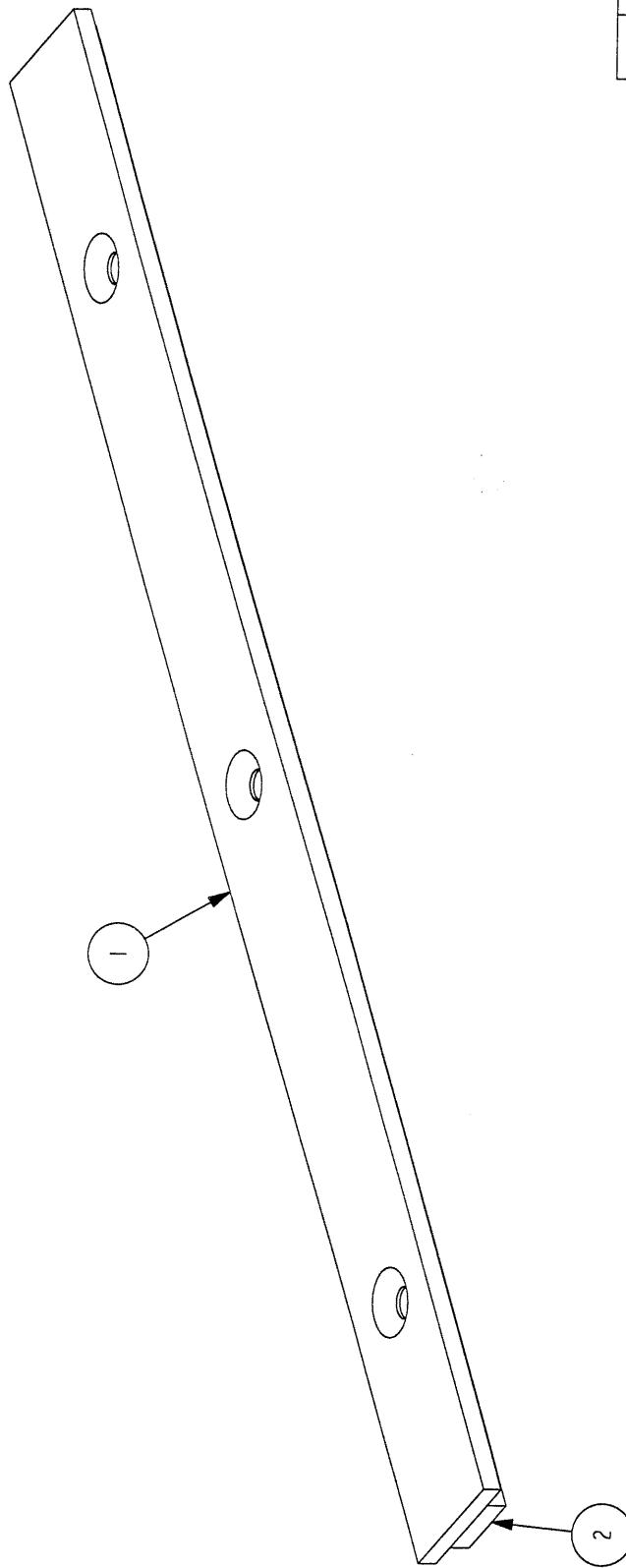
REV NO	DATE	DESCRIPTION	ECN NO	BY
I	2-11-98	RE-DRAW IN PRO-E	6254	N6



DRAWN BY:	SCALE	MATERIAL:	DIMENSIONAL TOLERANCES UNLESS OTHERWISE 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. KENNESAW, GA 30144 USA
CHECKED BY:	DATE	PURCHASED	.XX .XXX ANG.	-	
TRACED BY:	31 - JUL - 79	HEAT TREAT:	.01 .005 .5	MODEL: 215	TITLE: ASSY, UNIVERSAL JOINT
	MASTER	FINISH:	N/A	SHEET NO: 0F 1	DRAWING #: 100800-1

I	531679-01
I	500704-A
REQ'D	WHERE USED

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



DRAWN BY:	MY	SCALE	1 . 000	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 3044 USA
CHECKED BY:		DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	.01 .005 .5	HEAT TREAT:	N / A	MODEL:	215
TRACED BY:		DATE	12 - Apr - 99	FINISH:	N / A	STREET NO.	10F1
REMOVED ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED				ASSY, SIDE GUIDE RAIL			
ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE " WORK TO DIMENSIONS ONLY				DRAWING #			
MASTER				M			

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

REV NO	DATE	DESCRIPTION	ECN NO	BY

1 535411-01  
REV'D WHERE USED

DRAWN BY: TVK SCALE: 0 .500 DIMENSIONAL TOLERANCES MATERIAL: N/A  
NO. OF DIMENSIONS UNLESS OTHERWISE NOTED .01 .005 .005 ANG.  
CHECKED BY: DATE 06-00C+00 HEAT TREAT: N/A  
REMOVED ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED  
ALL DIMENSIONS ARE FINISHED DIMENSIONS  
DO NOT SCALE - WORK TO DIMENSIONS ONLY

TRACED BY: MASTER FINISH: N/A SHEET NO: 1 OF 1 DRAWING #

KRK KIRK - RUDY, INC.  
KENNE SAW, GEORGIA  
30144 USA

ASSY, SIDE GUIDE  
535412-01

ITEM	QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	1	102119	KNOB					
2	1	500755	CLAMP - SIDE GUIDE					
3	2	500771	CLIP-SIDE GUIDE					
4	1	102119-A	ASSY, KNOB					
5	1	500788-18L	PLATE - RH SIDEGUIDE					
6	1	RHN010	NUT, HEX 1/4					
7	1	SYA601	SET SCREW					

REF'D WHERE USED

I 535412-01

SCALE 0.500

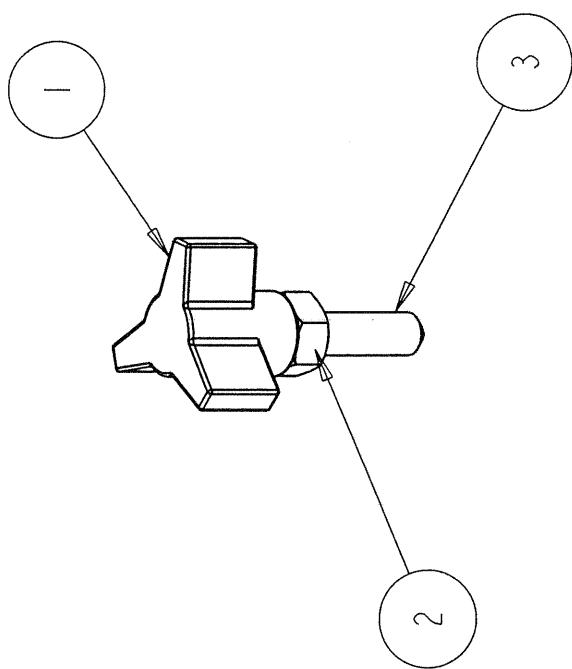
DRAWN BY:	SCALE	0 . 500	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED		MATERIAL:	N / A	THIRD ANGLE PROJECTION		PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE QUOTED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC. KENNESAW, GA 30144 USA	
checked by:	DATE	12-Apr-99	.01	.005	AMG.	.5	HEAT TREAT:	N / A		
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. 1 OF 1	DRAWING #	
								ASSY, SIDE GUIDE LH		
								500755AL		

ITEM	QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	1	102119	KNOB					
2	1	500755	CLAMP - SIDE GUIDE					
3	2	500771	CLIP-SIDE GUIDE					
4	1	102119-A	ASSY, KNOB					
5	1	500788-18R	PLATE, RH & LH SIDE GUIDE					
6	1	RHN010	NUT, HEX 1/4					
7	1	SYA601	SET SCREW					

1      2      3  
4      5      6      7

DRAWN BY:	MY	SCALE	0 . 500	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED		MATERIAL:	N / A	THIRD ANGLE PROJECTION	PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE QUOTED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC. KENNESAW, GA 30144 USA	
CHECKED BY:		DATE	12 - Apr - 99	.01	.005	AMG.	.5	HEAT TREAT:	N / A	KIRK - RUDY, INC. KENNESAW, GEORGIA
TRACED BY:	MASTER	FINISH:	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED		MODEL:		215	TITLE:	ASSY, SIDE GUIDE RH	
			ALL DIMENSIONS ARE FINISHED DIMENSIONS					DRAWING NO.:	500755AR	
			DO NOT SCALE - WORK TO DIMENSIONS ONLY				SHEET NO.:	0F1		

ITEM QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	102119	KNOB					
2	RHN010	NUT, HEX 1/4					
3	SYA601	SET SCREW					



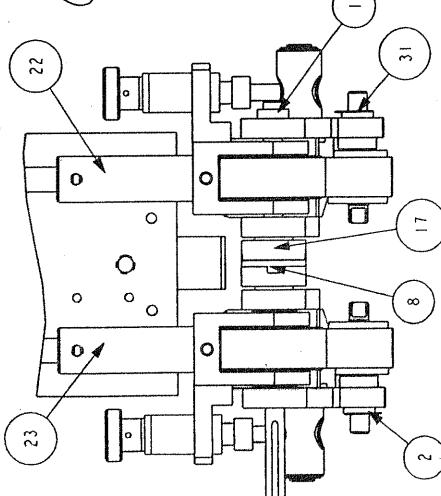
DRAWN BY:	SCALE	1 . 000	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED		MATERIAL:	N/A	THIRD ANGULAR PROJECTION	PROPRIETARY AND CONFIDENTIAL NOT FOR COMMERCIAL USE MADE FOR KENNE SAW CO. OR ITS SUBSIDIARIES IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY INC. KENNE SAW, GA 3044 USA	RECD WHERE USED
CHECKED BY:	DATE	12- Jun - 01	.01 .005 .5		HEAT TREAT:	N/A	MODEL:	KIRK-RUDY INC.	PRINT:
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:	ASSY , KNOB	DRAWING #	102119-A
						10F1			

ITEM NO.	PART #	DESCRIPTION	REV NO.	DATE	SCN NO.	BY
1	1	102211 COLLAR .375				
2	2	102345 SHIM .375X.625X.125				
3	2	102701 SPRING				
4	4	103106 BEARING, FLAT .375				
5	2	104100 SNAPPING .375				
6	2	104400 BOLT - HEX HEAD				
7	2	111882 BLUE BELT, FLAT .75 X 21.125				
8	1	190600 SPIDER - ROLLER DRIVE				
9	1	190685 LEVER - QUICK RELEASE				
10	2	500807 NUT - LOCK				
11	1	500808 PLATE, TOP BRIDGE				
12	2	500809 SLEEVE - THREADED				
13	2	500812 KNOB, ROLLER ADJUSTMENT				
14	2	508162 STUD, TAKE UP				
15	2	508989 BRACKET, ANGLE				
16	1	500744-4 SHAFT, TOP ROLLER				
17	1	500744-7 SHAFT, TOP ROLLER				
18	1	500795-1 PLATE - BACK				
19	1	500799-3 CLAMP - MOUNTING PLATE				
20	1	500799-5 BLOCK, CLAMP SUPPORT				
21	1	534799-2 BLOCK - CONNECTOR				
22	1	500811-2L FORK - ASSEMBLY				
23	1	500811-2R ASSY, FORK				
24	2	508746-A ASSY, ROLLER ALUMINUM				
25	2	508761-2A ASSY, ROLLER				
26	1	534750-01 ASSY, INSIDE SWING LH				
27	1	534750-02 ASSY, INSIDE SWING RH				
28	2	536713-01 ASSY, ARM ADJUST SCREW				
29	2	536714-01 ASSY, SPRING SHAFT HOLDER				
30	1	539711-01 BRACKET, BEAM SWITCH				
31	2	WHS011 WASHER, LOCK 3/8				

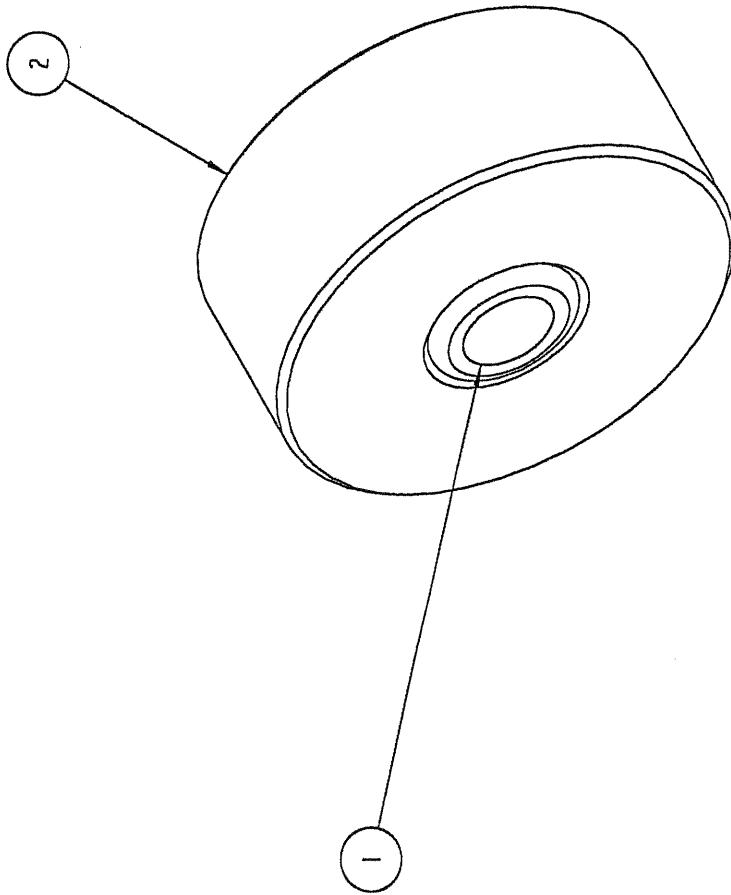
1 EA	324-1
RECO'D	WHERE USED
<b>KRK</b> KIRK - RUDY, INC. WOODSTOCK, GEORGIA	
THIS ANGLE PRACTICALLY AND CONFIDENTIAL PROPRIETARY AND CONFIDENTIAL INFORMATION MADE OUT OF THE INFORMATION IN REPRODUCED MAY NOT BE USED IN WHOLE OR IN PART EXCEPT WITH THE WRITTEN CONSENT OF KIRK - RUDY, INC., WOODSTOCK, GA 30188 USA	
MODEL NO:	324-1
DATE:	21 - JUL - 99
NOTED:	NONE
MASTER:	M
SCALE:	0.438

DRAWING #

536712-01



ITEM QTY	PART #	DESCRIPTION
1	101100	BEARING, ONEWAY .375
2	508746	ROLLER, UPPER FEED

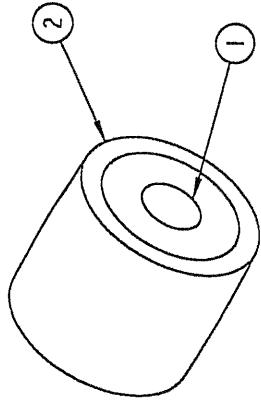


REV NO	DATE	DESCRIPTION	ECN NO	BT

2	324-1
REQ'D	WHERE USED
KR	KIRK - RUDY, INC. KENNESAW, GEORGIA
ASSY,	ROLLER ALUMINUM
508746-A	DRAWING #

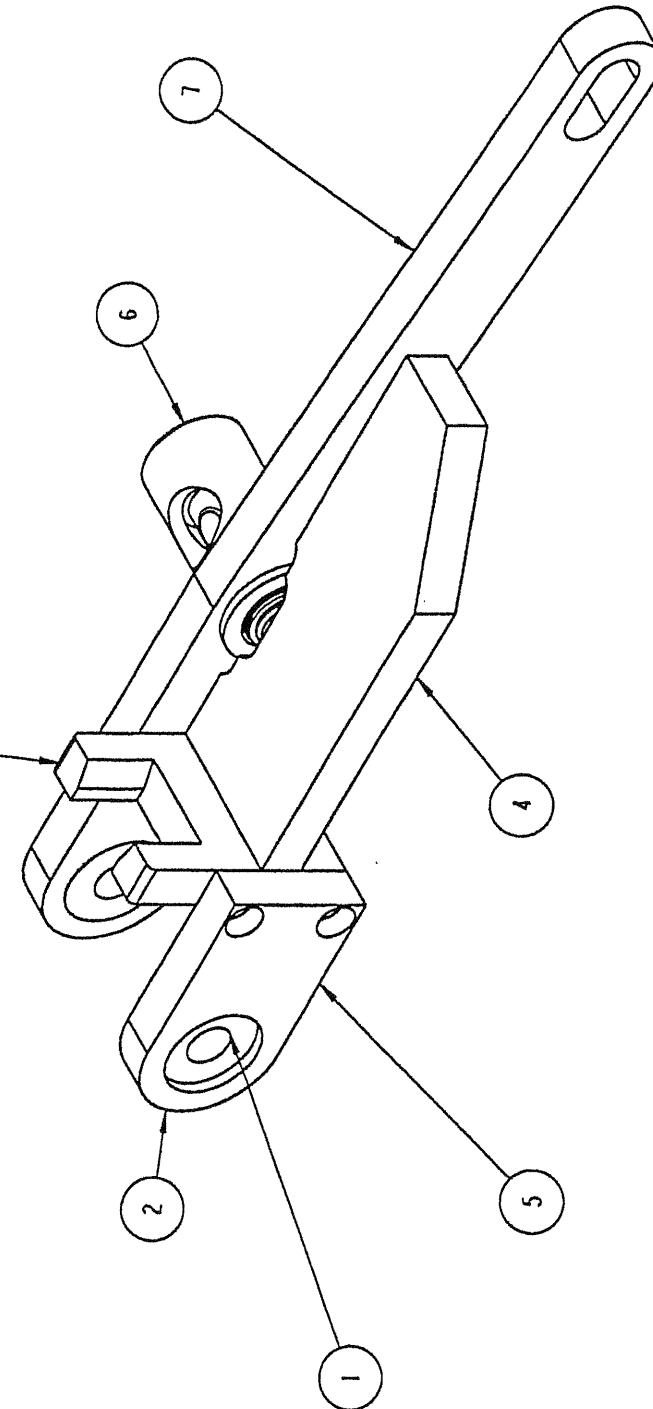
DRAWN BY: T J G	SCALE: 1 . 500	MATERIAL: N / A	THIRD ANGLE PROJECTION 	PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE QUOTED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC. KENNESAW, GA 30144 USA TRUE:
CHECKED BY: 4 - Sep - 98	DATE DIM.	AMT. .005	HEAT TREAT: N / A	MODEL: 324-1
TRACED BY: MASTER M	ALL DIMENSIONS ARE SHARP EDGES UNLESS OTHERWISE NOTED ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY	FINISH: N / A	SHEET NO. 10F1	DRAWING #

ITEM	QTY	PART #	DESCRIPTION
1	2	103106	BEARING, FLAT .375
2	1	508761-2	ROLLER, TAKE UP



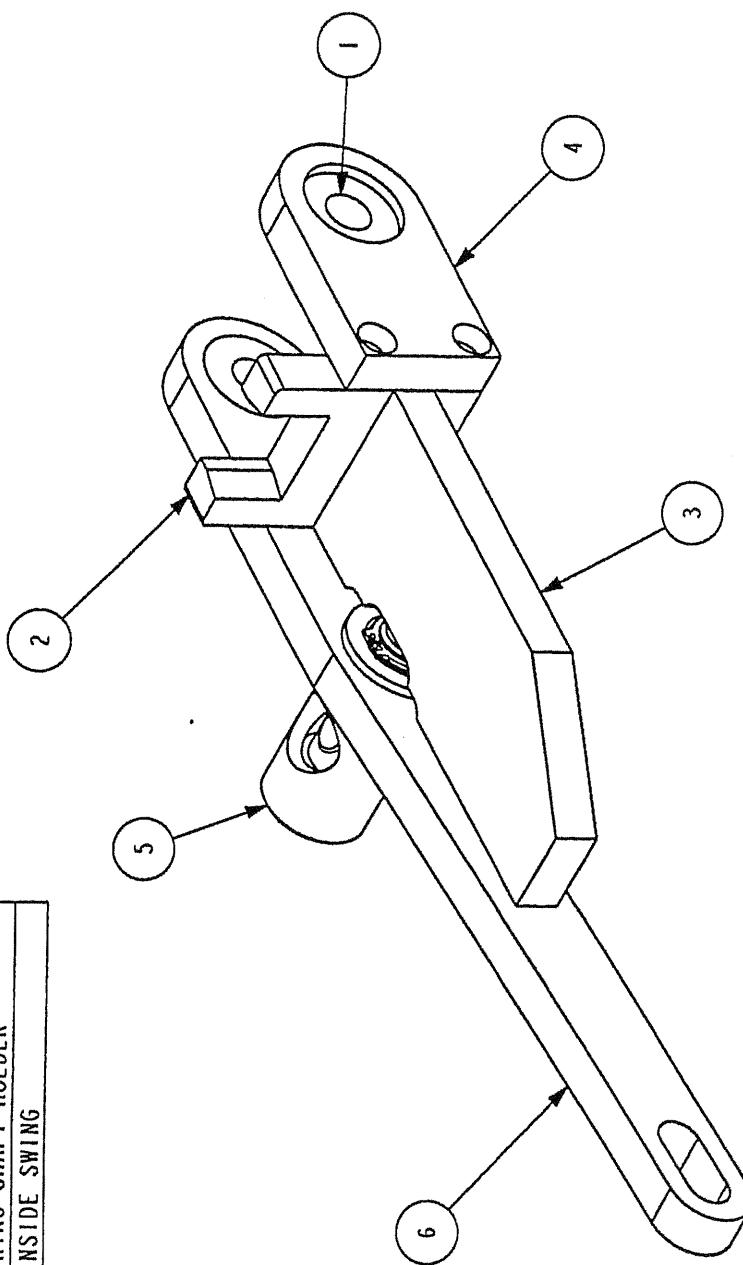
DRAWN BY:	SLB	SCALE	.000	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	MATERIAL:	N/A	THIRD ANGLE PROJECTION	PROPRIETARY AND CONFIDENTIAL NO FORGING OF THIS DRAWING MAY BE DUPLICATED OR REPRODUCED IN ANY MANNER WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY INC. KENNESAW, GA 30144 USA	RECD WHERE USED
CHEKED BY:		DATE	09 - Mar - 98	.1X .065 .5	AMT.				
TRACED BY:		MASTER	M	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED	HEAT TREAT:	N/A	MODEL:	SP 486	TITLE:
				ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY	FINISH:	N/A	SECT NO.:	TOP	DRAWING #:

ITEM QTY	PART #	DESCRIPTION
1 2	103106	BEARING, FLAT .375
2 1	508751	PLATE, OUTSIDE SWING
3 1	508752	GUIDE, BELT
4 1	508754	GUSSET
5 1	533185-01	ASSY, OUTSIDE SWING PLATE
6 1	536714-01	ASSY, SPRING SHAFT HOLDER
7 1	SP6307-IR	PLATE, INSIDE SWING



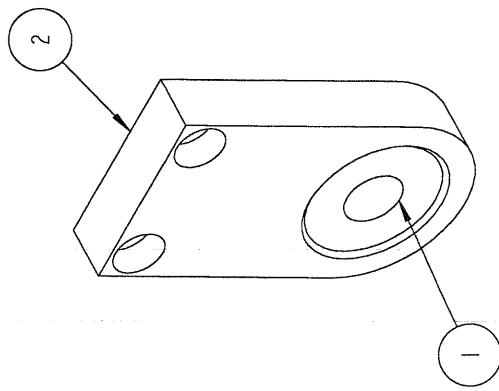
DRAWN BY:	T JG	SCALE	0 .750	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	MATERIAL: N/A	THIRD ANGLE PROJECTION	PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE QUOTED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC. KENNESAW, GA 30144 USA
CHECKED BY:		DATE	7-0c† - 98	.01 .005 .5	MEAT TREAT:	324 - 1	TITLE:
TRACED BY:		MASTER:	N	REMOVE ALL BURRS AND SHARP EDGES AND OTHERWISE WELD ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY	FINISH: N/A	SHEET NO. 10F 1	DRAWING #: ASSY, INSIDE SWING LH
							534750-01
							X XXX REV D WHERE USED

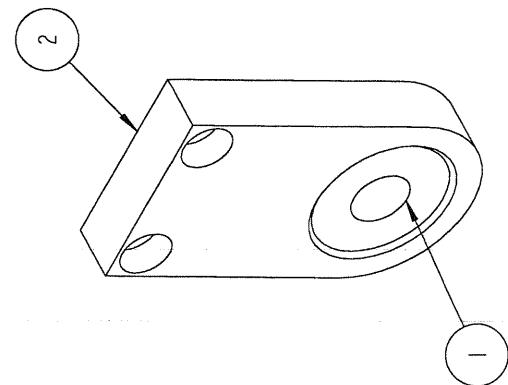
ITEM QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	1	103106 BEARING, FLAT .375					
2	1	508752 GUIDE, BELT					
3	1	508754 GUSSET					
4	1	533185-01 ASSY, OUTSIDE SWING PLATE					
5	1	536714-01 ASSY, SPRING SHAFT HOLDER					
6	1	SP6307-1L PLATE, INSIDE SWING					



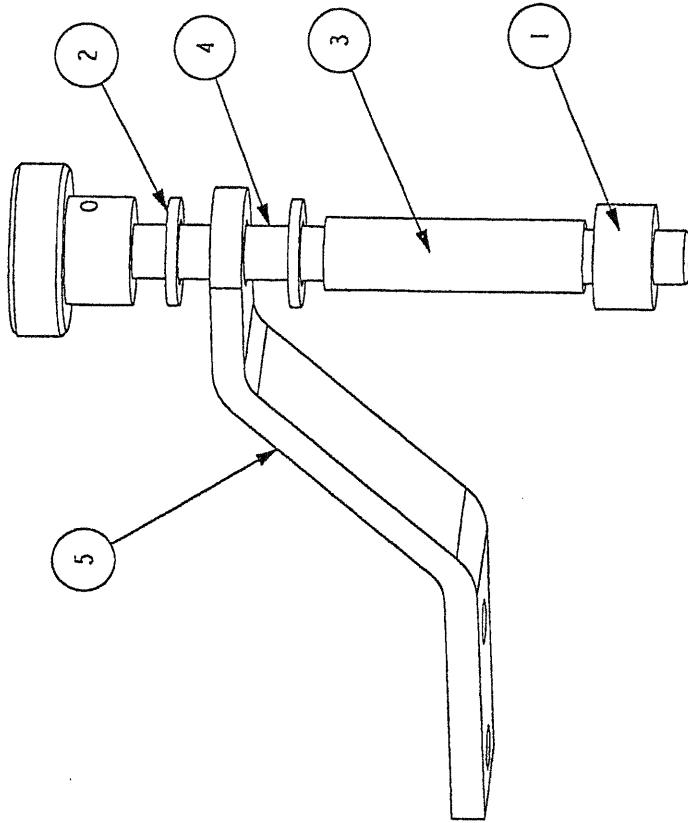
1	324-1	
REQ'D	WHERE USED	
<b>KR</b>	KIRK - RUDY INC.	
	KENNE SAW, GEORGIA	
324-1	TITLE:	ASSY, INSIDE SWING RH
SKETCH	DRAWING #	534750-2
MASTER	OF 1	

ITEM QTY	PART #	DESCRIPTION
1	103106	BEARING, FLAT .375
2	508751	PLATE, OUTSIDE SWING



ITEM QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	1	103106	BEARING, FLAT .375				
2	1	508751	PLATE, OUTSIDE SWING				
						REQ'D	WHERE USED
						DRAWN BY: SLD CHECKED BY: TRACED BY: DATE: 1- Mar - 98	
SCALE .000 DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED .XX .XXX ANG. .01 .005 .5 REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY						MATERIAL: N/A HEAT TREAT: N/A MODEL: SP486 SHEET NO.: 1 OF 1 DRAWING #: ASSY, OUTSIDE SWING PLATE TITLE: KIRK - RUDY, INC. KENNESAW, GEORGIA PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE QUOTED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC., KENNESAW, GA 30144, USA	

ITEM QTY	PART #	DESCRIPTION
1	102204	COLLAR .313
2	102308	SHIM .375X.625X.062
3	102723	SPRING
4	508759	SCREW
5	508750-3	BAR. SPRING



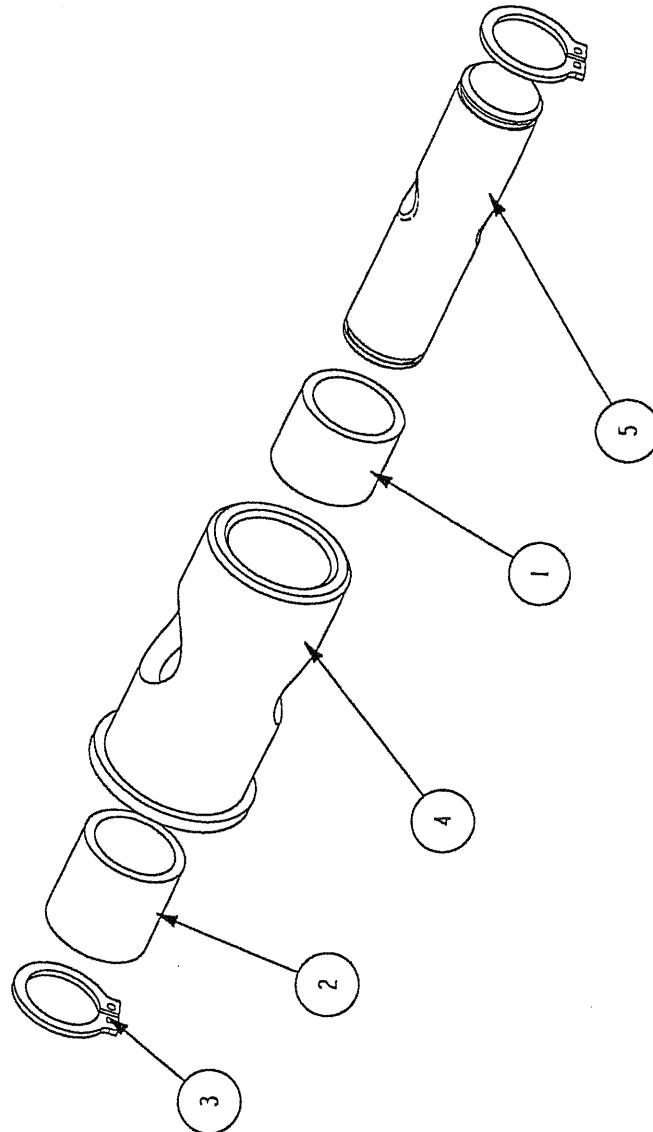
REV NO	DATE	DESCRIPTION	ECN NO	BY

2 EA	512
REQ'D	WHERE USED
<b>KRK KIRK - RUDY, INC.</b>	
<b>KRK KENNESSAW, GEORGIA</b>	
PRINT:	N/A
MODEL:	N/A
FINISH:	N/A
SHEET NO.:	1 OF 1
DRAWING #:	536713-01

## ITEM QTY PART # DESCRIPTION

ITEM QTY	PART #	DESCRIPTION
1	100135	BUSHING, SL. 500ID. 625OD. 500LG
2	100162	BUSHING, SL. 500ID. 625OD. 625LG
3	2 104106	SNAPRING, .500
4	1 508757	HOLDER, SPRING SHAFT
5	1 508760	SHAFT, SPRING

REV NO	DATE	DESCRIPTION	ECN NO	BY



2 EA	512
REQ'D	WHERE USED
<b>KR</b>	KIRK - RUDY, INC.
	KENNESAW, GEORGIA
	30144 USA
ASSY, SPRING SHAFT HOLDER	DRAWING #
536714-01	

DRAWN BY:	JLG	SCALE:	1.000	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:	20-JUL-99	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	.01 .015 .015 .015 .015 .015	HEAT TREAT:	N/A
TRACED BY:	MASTER	FINISH:	<b>M</b>	REMOVED ALL BURRS AND SHARP EDGES & RIBS ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY	N/A	NOTE:	N/A

ITEM QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	100401	WASHER, THRUST TB410			REPLACED GATE PLATE WITH NEW GATE ASSY	6669	A KEY
2	100409	WASHER, THRUST	1	2-21-2001			
3	102114	KNOB					
4	102119	KNOB					
5	102225	COLLAR .250					
6	1	500806 PLATE - GATE END					
7	1	500810 SHAFT - SCREW ADJ					
8	1	102114A ROUND KNOB ASSY					
9	1	500730-11 ASSY, GATE					
10	1	532132-01 GATE, TIP STD					
11	1	532133-01 GATE, TIP STD					
12	1	SYA590 SET SCREW					

RECD WHERE USED

1 536711-01

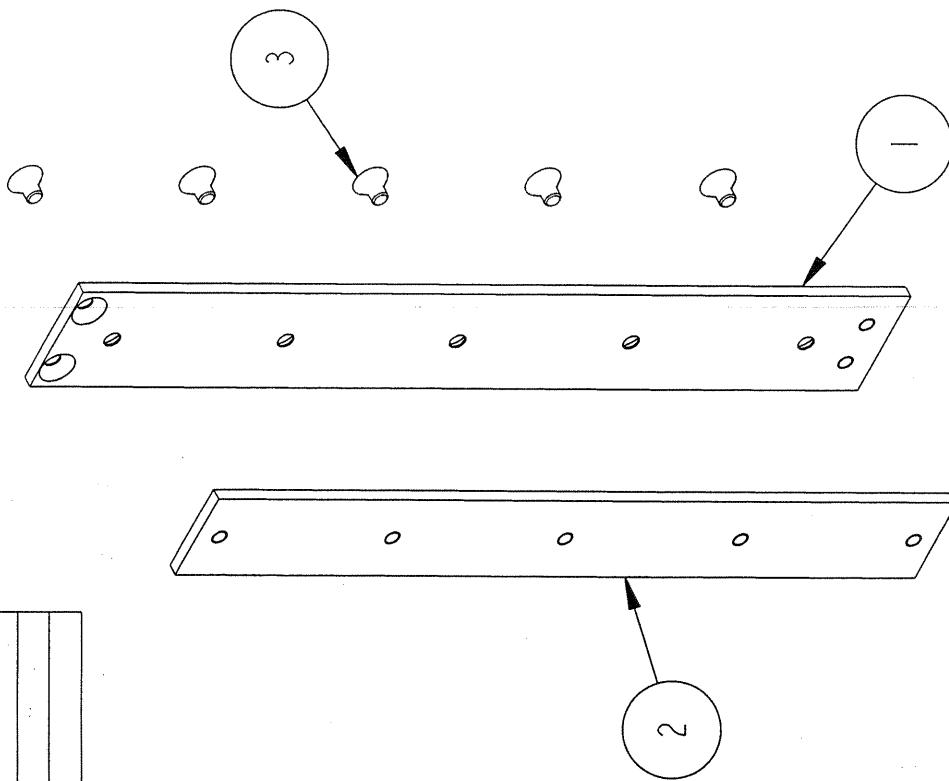
PROPRIETARY AND CONFIDENTIAL  
NO PORTION OF THIS DRAWING  
MAY BE COPIED OR REPRODUCED  
IN ANY FORM WITHOUT THE  
EXPRESS WRITTEN PERMISSION  
OF KIRK-RUDY, INC.,  
KENNESAW, GA 30144 USA

TITLE: ASSY, GATE

DRAWING # 536716-01

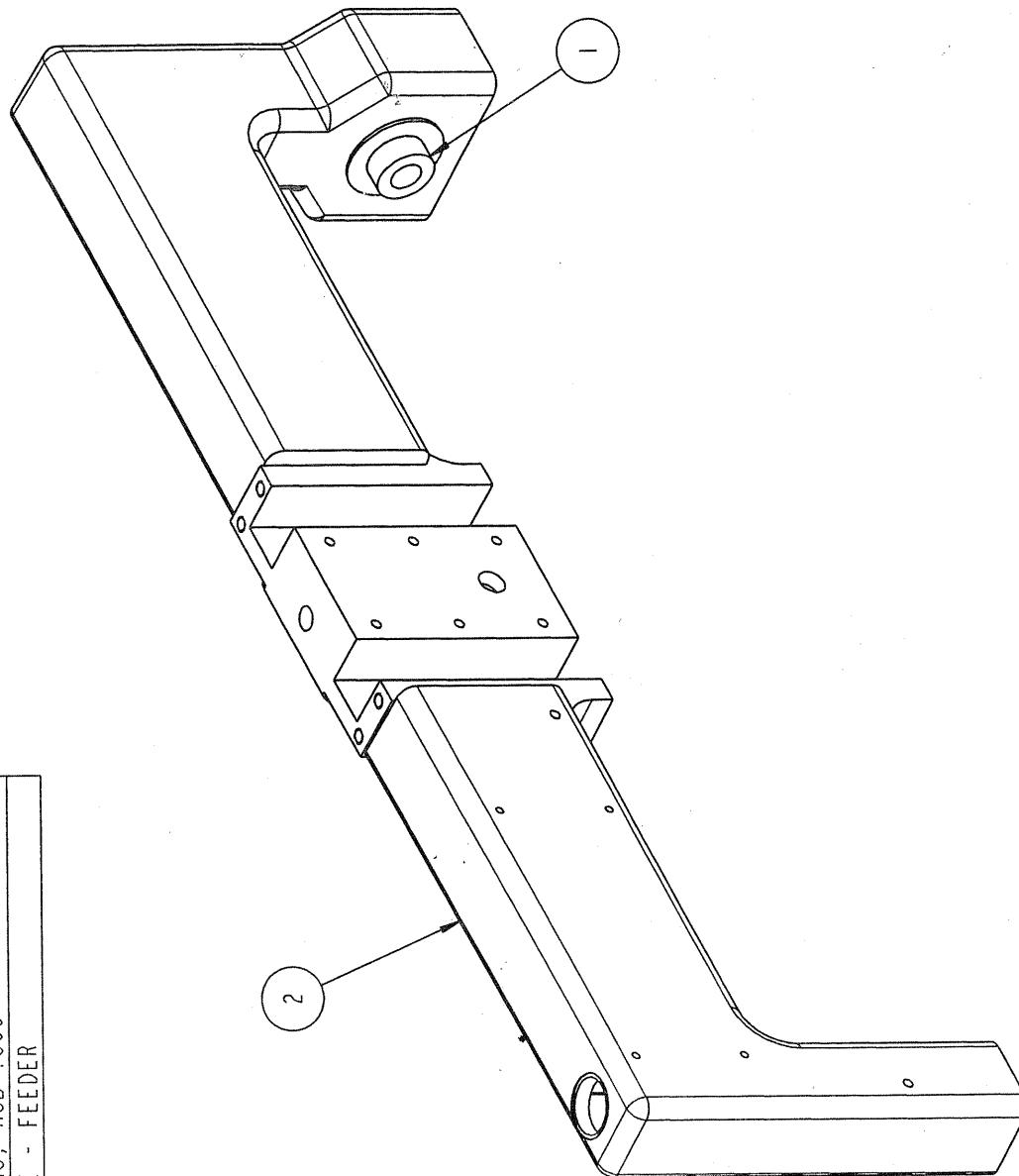
DRAWN BY: JLG	SCALE 0 . 438	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED		MATERIAL: N / A	THIRD ANGLE PROJECTION		
		.01	.005	ANG.			
CHECKED BY:	DATE 20-JUL-99			HEAT TREAT: N / A			
TRACED BY:	MASTER 	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED		ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY			
				FINISH: N / A	SHEET NO.: 10F1	DRAWING #	

ITEM QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	1	539993-01			BAR, GATE BACK		
2	1	539994-01			BAR, GATE FRONT		
3	5	CSEE225					



1	324-1
REQ'D	WHERE USED
 KIRK-RUDY INC.  KENNEBUNK, GEORGIA KENNEBUNK, GA 30144 USA	
PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE QUOTED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY INC. KENNEBUNK, GA 30144 USA	
DRAWN BY: A KEY	SCALE: 0 . 625
DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	
.01	.005 .005 ANG.
HEAT TREAT:	
REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED	
ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY	
CHECKED BY: 21-Feb-01	MASTER M
TRACED BY:	SHEET NO. 1 OF 1
TITLE: ASSY, GATE	
DRAFTING # 500730-11	

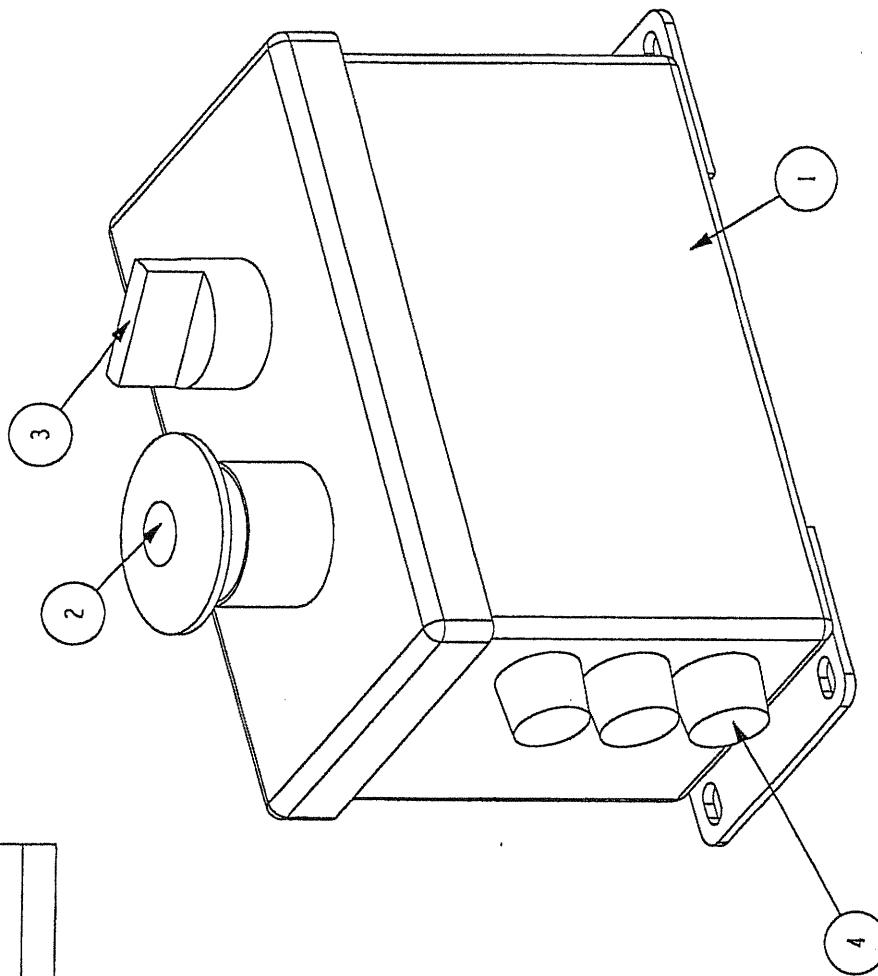
ITEM QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	2	103803 BEARING, HUB .500					
2	1	530182-03 BRIDGE - FEEDER					



DRAWN BY:	SCALE	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	MATERIAL:	THIRD ANGLE PROJECTION	KIRK - RUDY, INC. WOODSTOCK, GEORGIA
CMM	0 . 375	.xx .xxx .005 .5	N / A	⊕ - - ⊕	<b>KR</b>
CHECKED BY:	DATE	REAR TREAT:	FINISH:	MODEL:	TITLE:
	07 - Jun - 04	N / A	N / A	324 - 1	ASSY, BRIDGE
TRACED BY:	MASTER	ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY	SHEET NO. OF 1	DRAWING #	541203-02

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

ITEM	QTY	PART #	DESCRIPTION
1	1	200266-1	ELECTRICAL SWITCH BOX, 2 HOLE
2	1	201125-4	BUTTON, MUSHROOM STOP
3	1	201145-1	SELECTOR, 2 POSITIONS
4	3	209204-3	LENS, RED LIGHT



REV NO	DATE	DESCRIPTION	ECN NO	BY

1	324-1 REV'D	WHERE USED
KRK	KIRK - RUDY, INC. KENNESAW, GEORGIA	
324-1	ASSY, ELECTRICAL BUTTON BOX	DRAWING I
10F1		536728-01

DRAWN BY:	SCALE:	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	MATERIAL:	THIRD ANGLE PROJECTION	PROPRIETARY AND CONFIDENTIAL NO PART OF THIS DRAWING MAY BE OUTFOLDED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC. KENNESAW, GA 30144 USA
MY	0 . 750	.01    .005    .005	XXX		
CHECKED BY:	DATE	REMOVED:    HEAT TREAT:	XXX		
TRADED BY:	MASTER	ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY	XXX		

### **6.3 DIAGRAMS AND PARTS LIST FOR WIDE FEEDER**

This section contains the diagrams for the wide feeder which are different from the standard feeder and a complete mechanical bill of materials for the wide feeder.

ITEM#	QTY	PART#	DESCRIPTION
1	1	100109	BUSHING, SL1.000ID1.250OD1.500LG
2	1	100131	BUSHING, SL.250ID.375OD1.250LG
3	2	100135	BUSHING, SL.500ID.625OD.500LG
4	8	100145	BUSHING, SL.625ID.813OD1.000LG
5	1	100146	BUSHING, SL.625ID1.000OD1.000LG
6	2	100162	BUSHING, SL.500ID.625OD.625LG
7	2	100310	BUSHING, FL.250ID.375OD.375LG
8	1	100401	WASHER, THRUST TB410
9	1	100409	WASHER, THRUST
10	2	100601	WASHER, FLAT .500
11	1	100800	ASSY, UNIVERSAL JOINT
12	2	101100	BEARING, ONEWAY .375
13	1	101102	BEARING, ONEWAY .500
14	1	101707	GEAR, 2048 .375B NK
15	1	101708	GEAR, 2072 .625B .188K
16	2	101916	GEAR, 1628 .625B .188K
17	2	101918	GEAR, FEED ROLLER DRIVE
18	1	101946	GEAR, 1626 1.124B NK
19	1	101988	GEAR, 1654 .625B .188K
20	1	102112	KNOB, PURCHASED
21	1	102114	KNOB
22	1	102117	KNOB
23	3	102119	KNOB
24	2	102203	COLLAR .625
25	2	102204	COLLAR .313
26	2	102205	COLLAR .500
27	3	102211	COLLAR .375
28	3	102225	COLLAR .250
29	4	102301	SHIM, .500X.750X.125
30	1	102302	SHIM, .500X.750X.062
31	6	102308	SHIM, .375X.625X.062
32	2	102320	SHIM, .625XI.000X.062
33	1	102326	SPACER, .500X.750X.812
34	4	102345	SHIM, .375X.625X.125
35	1	102398	SHIM, .750XI.125X.125
36	1	102401	GEAR, 1616 .500B .125K
37	1	102552	SHIM, .25X.750X.125
38	1	102560	SHIM, .625XI.000X.025
39	12	102657	SHIM, .625XI.000X.125
40	3	102670	SPACER
41	2	102671	SHIM, .625XI.000X.031
42	1	102672	SPACER, SIDE PLATE
43	2	102700	SPRING, COIL
44	3	102701	SPRING
45	1	102722	SPRING, COMPRESSION
46	2	102723	SPRING
47	22	103106	BEARING, FLAT .375
48	5	103108	BEARING, FLAT .500
49	3	103110	BEARING, FLAT .625
50	1	103405	CAM FOLLOWER
51	2	103408	CAM FOLLOWER
52	1	103500	BEARING - ROD END

53	7	103804	BEARING, HUB .625
54	3	103812	BEARING, HUB .625
55	6	104100	SNAPRING, .375
56	2	104104	SNAPRING, .625
57	5	104106	SNAPRING, .500
58	2	104400	BOLT - HEX HEAD
59	3	105200	PIN, ROLL .063X.875
60	1	105601	SHAFT, THREADED 5/16-18
61	2	106301	BELT, FLAT 3/4 X 13.875
62	2	106702	NUT, 3/8-16
63	1	107254	BOLT, SHOULDER 1/2X1.00
64	2	109521	OIL METER UNIT
65	1	109523	JUNCTION, 2-WAY
66	1	109524	JUNCTION, 3-WAY
67	2	109528	NUT, COMPRESSION FEMALE
68	1	109529	CONNECTOR, PIPE
69	2	109530	ELBOW, MALE 1/4 NPT
70	2	109537	SLEEVE, COMPRESSION
71	1	109552	PIVOT BRACKET, BIMBA
72	1	109606	CYLINDER, AIR BIMBA
73	1	109671	MUFFLER, SINTERED
74	1	190600	SPIDER - ROLLER DRIVE
75	1	190606	FITTING - 90 DEG 1/4 NPT
76	1	190685	LEVER - QUICK RELEASE
77	1	190769	MAGNET, BUNTING
78	1	202298	VALVE, AIR 24VDC
79	1	500704	BRIDGE - FEEDER
80	1	500708	BODY, VACUUM VALVE
81	1	500709	PLATE - VACUUM FEEDER
82	1	500714	BRIDGE - READ GUIDE
83	1	500715	PLATE - REAR CENTER GUIDE
84	1	500718	HUB - SHAFT BEARING
85	3	500721	GUSSET - TABLETOP SUPPORT
86	1	500728	BRACKET - FEEDER
87	1	500734	LEVER - CAM
88	1	500735	ROD - PUSH
89	2	500737	WASHER - BUMPER
90	1	500738	SPRING - VALVE
91	1	500739	BLOCK - PUSHER
92	1	500740	PLATE - VACUUM
93	2	500741	SHAFT - FEEDER
94	2	500746	ROLLER - BOTTOM FEED
95	1	500747	CAM - FEED ROLLERS
96	1	500749	ROD - FEEDER SLIDE
97	1	500750	CRANK - FEEDER SLIDE
98	1	500751	YOKE - FEEDER CRANK
99	2	500755	CLAMP - SIDE GUIDE
100	2	500760	LIFTER - FEEDER PUSHER
101	2	500762	PLATE - FEEDER PUSHER BOTTOM
102	2	500764	LIFTER - REAR BRIDGE
103	2	500766	SCREW - MACHINE REAR GUIDE
104	1	500769	SHAFT - REAR GUIDE
105	1	500770	HUB - REAR GUIDE SHAFT

106	6	500771	CLIP-SIDE GUIDE
107	2	500775	PLATE-FEEDER PUSHER TOP
108	1	500785	BLOCK-SPRING
109	1	500786	LEVER, SPRING
110	2	500805	PLATE - HOLD DOWN
111	1	500806	PLATE - GATE END
112	2	500807	NUT - LOCK
113	1	500808	PLATE, TOP BRIDGE
114	2	500809	SLEEVE - THREADED
115	1	500810	SHAFT - SCREW ADJ
116	2	500812	KNOB, ROLLER ADJUSTMENT
117	1	500824	SHAFT-BELT GUIDE
118	1	500830	SHAFT - UNIVERSAL DRIVE
119	2	500832	BRACKET-REAR-GUIDE
120	1	500845	TABLE, JOGGER
121	2	500847	BRACE, COMPUTER FORM REST
122	1	501638	SHAFT, FEEDER ROLL
123	1	503622	HUB, GEAR
124	1	508604	PLATE, LH FEEDER
125	1	508614	PLATE, SIDE
126	1	508624	HUB, CLUTCH
127	1	508637	SHAFT, CRANK
128	1	508645	PAWL
129	1	508682	STUD, IDLER GEAR
130	1	508700	PLATE, RH FEEDER
131	1	508719	PLATE, SOLENOID
132	1	508720	COLLAR, SHUTTLE DRIVE
133	1	508721	PLATE, BEARING
134	4	508741	LEG, FEEDER
135	2	508746	ROLLER, UPPER FEED
136	1	508747	GEAR, SPUR 1633
137	2	508748	ASS'Y, ROLLER MTG
138	2	508751	PLATE, OUTSIDE SWING
139	2	508752	GUIDE, BELT
140	2	508753	ROLLER, LOWER BELT DRIVE
141	2	508754	GUSSET
142	1	508755	BLOCK, BEARING
143	2	508757	HOLDER, SPRING SHAFT
144	2	508759	SCREW
145	2	508760	SHAFT, SPRING
146	4	508762	STUD, TAKE UP
147	1	508763	ROLLER, IDLER
148	1	508765	SHAFT, IDLER ROLLER
149	1	508766	BAR, CROSS
150	1	508865	SHAFT, FEED ROLLER
151	4	508937	BLOCK, ROLLER BEARING
152	1	100800-1	ASSY, UNIVERSAL JOINT
153	2	100800-1_1	UNIVERSAL
154	2	100800_1	UNIVERSAL
155	2	100800_3	UNIVERSAL
156	1	101902-1	GEAR, 1620 .625B .188K
157	1	102108-2	HANDWHEEL, CLUTCH BEARING
158	1	102114A	ROUND KNOB ASY

159	2	102119-A	ASSY, KNOB
160	2	106302-9	BELT, FLAT .75 X 21.375
161	1	500704A-1	ASSY, BRIDGE WIDE
162	1	500708A	ASSY, VACUUM BODY
163	1	500710-1	BRACKET - FEEDER SUPPORT
164	1	500726A-2	ASSY, SHAFT UNIVERSAL WIDE
165	1	500728A	ASSY, BUSHING BLOCK
166	1	500729-4L	ARM, FEEDER CRADLE HUBRG LH
167	1	500729-4R	ARM, CRADLE FEEDER HUBRG RH
168	1	500730-11	PLATE, GATE FEEDER
169	1	500734A	CLAMP ARM ASY
170	1	500744-2	SHAFT, TOP ROLLER
171	1	500744-3	SHAFT, TOP ROLLER
172	1	500751A	ASSY, BEARING BLOCK
173	1	500755AL	ASSY, SIDE GUIDE LH
174	1	500755AR	ASSY, SIDE GUIDE RH
175	2	500760-A	ASSY, LIFTER FEEDER PUSHER
176	1	500763-6	SLEEVE, HANDWHEEL CLUTCH
177	1	500764AL	ASSY, LIFTER
178	1	500764AR	ASSY, LIFTER
179	1	500788L	PLATE - RH SIDEGUIDE
180	1	500788LA	ASSY-SIDE GUIDE PLATE
181	1	500788R	PLATE, SIDEGUIDE RH
182	1	500795-1	PLATE - BACK
183	1	500799-3	CLAMP - MOUNTING PLATE
184	1	500799-5	BLOCK, CLAMP SUPPORT
185	1	500799-2	BLOCK - CONNECTOR
186	1	500803-1	SHAFT, UNIVERSAL
187	2	500814-1	RAIL - SIDEGUIDE
188	2	500814-2	RAIL - SIDE GUIDE
189	2	500814-1A	ASSY, SIDE GUIDE RAIL
190	1	500827-1	SHAFT, SPRING LEVER
191	1	500880-2	BRACKET, JOG TABLE SUPPORT
192	1	508624A	ASSY-GEAR W/PAWL
193	1	508648-2	SHAFT, HANDWHEEL
194	1	508703-1	PLATE, FEEDER
195	1	508704-L	TABLETOP, L/H OUTSIDE
196	1	508704-R	TABLETOP, R/H OUTSIDE
197	2	508746-A	ASSY, ROLLER ALUMINUM
198	2	508750-3	BAR, SPRING
199	1	508756-2	SHAFT, LOWER BELT DRIVE
200	2	508761-2	ROLLER, TAKE UP
201	2	508761-2A	ASSY, ROLLER
202	2	510611-1	ROLLER, IDLER
203	2	510611-1A	ASSY-ROLLER
204	1	530253-01	RING
205	1	531021-0F	ASSY, SHUTTLE TABLE
206	1	531022-05	ASSY, LOWER FEED ROLLER WIDE
207	1	531102-01	ASSY, HUB GEAR
208	1	531106-01	ASSY, HUB
209	1	531155-01	PLATE, MAGNETIC
210	1	531405-01	ASSY, JOGGER TABLE
211	1	532132-01	GATE, TIP STD

212	1	532133-01	GATE, TIP STD
213	2	533185-01	ASSY, OUTSIDE SWING PLATE
214	1	533824-01	ASSY, SOLENOID
215	1	534733-01	ASSY, SHUTTLE TABLE
216	1	534735-01	ASSY, FRAME RH
217	1	534736-01	ASSY, FRAME LH
218	1	534737-01	ASSY, THROWOUT CLUTCH FRAME
219	1	534738-01	ASSY, BRIDGE DRIVE SHAFT
220	1	534739-01	ASSY, IDLER 1626 GEAR
221	1	534740-01	ASSY, CRANK SHAFT
222	1	534741-01	ASSY, HANDWHEEL SHAFT
223	1	534742-02	ASSY, LOWER OUTFD FRAME WIDE
224	1	534743-02	ASSY, LOWER OUTFD ROLLER WIDE
225	2	534744-01	ASSY, BELT TENSIONER IDLER
226	1	534745-02	ASSY, LOWER OUTFD DRIVE WIDE
227	1	534746-01	ASSY, CYLINDER MOUNT
228	2	534749-01	ASSY, UPPER DRIVE ROLLER
229	1	534750-01	ASSY, INSIDE SWING LH
230	1	534750-02	ASSY, INSIDE SWING RH
231	1	535412-01	ASSY, SIDE GUIDE
232	1	535813-01	BAR, SLIDE
233	1	535813-02	BAR, SLIDE
234	1	535814-01	BLOCK, SLIDE
235	1	536191-01	BAR, LOCKING
236	1	536406-01	ASSY, JOGGER TABLE SLIDE
237	1	536711-02	ASSY, 324-1 BRIDGE WIDE
238	1	536712-02	ASSY, TOP FEED ROLLER WIDE
239	2	536713-01	ASSY, ARM ADJUST SCREW
240	2	536714-01	ASSY, SPRING SHAFT HOLDER
241	1	536716-01	ASSY, GATE
242	1	536892-01	ASSY, REAR BRIDGE
243	1	CSDD269	
244	1	CSDD297	
245	3	LOCKNUT_10-32	HEX STUD
246	1	RHB082	HEX HEAD BOLT
247	3	RHN010	HEX NUT
248	3	RHN012	HEX NUT
249	1	SP12199	PIN, YOKE PIVOT
250	1	SP39266	YOKE, THROW OUT
251	1	SP39267	PLATE, MOUNTING
252	1	SP39268	PLATE, MOUNTING
253	1	SP39269	BLOCK, END
254	1	SP38237-1	BRACKET, PHOTOCELL
255	1	SP39266A	ASSY, THROWOUT YOKE
256	1	SP6306-1L	PLATE, BELT SUPPORT
257	1	SP6306-IR	PLATE, BELT SUPPORT
258	1	SP6306-6L	PLATE, BELT SUPPORT
259	1	SP6306-6R	PLATE, BELT SUPPORT
260	1	SP6307-1L	PLATE, INSIDE SWING
261	1	SP6307-IR	PLATE, INSIDE SWING
262	1	SP6383-1	WASHER
263	1	SYA590	SET SCREW
264	2	SYA601	SET SCREW

324-1 PARTS MANUAL  
ASSY, 324-1 FEEDER W DE

27-NOV-00  
PAGE 6

ITEM QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	1	500824 SHAFT-BELT GUIDE					
2	1	531021-01 ASSY, SHUTTLE TABLE					
3	1	531022-05 ASSY, LOWER FEED ROLLER WIDE					
4	1	531405-01 ASSY, JOGGER TABLE					
5	1	534733-02 ASSY, SHUTTLE TABLE					
6	1	534735-01 ASSY, FRAME RH					
7	1	534736-01 ASSY, FRAME LH					
8	1	534737-01 ASSY, THROUWOUT CLUTCH FRAME					
9	1	534742-02 ASSY, LOWER OUTFD FRAME WIDE					
10	1	540034-02 ASSY, BRIDGE 324-1 WIDE					

1 324-1  
REO-D WHERE USED

SCALE 0.100

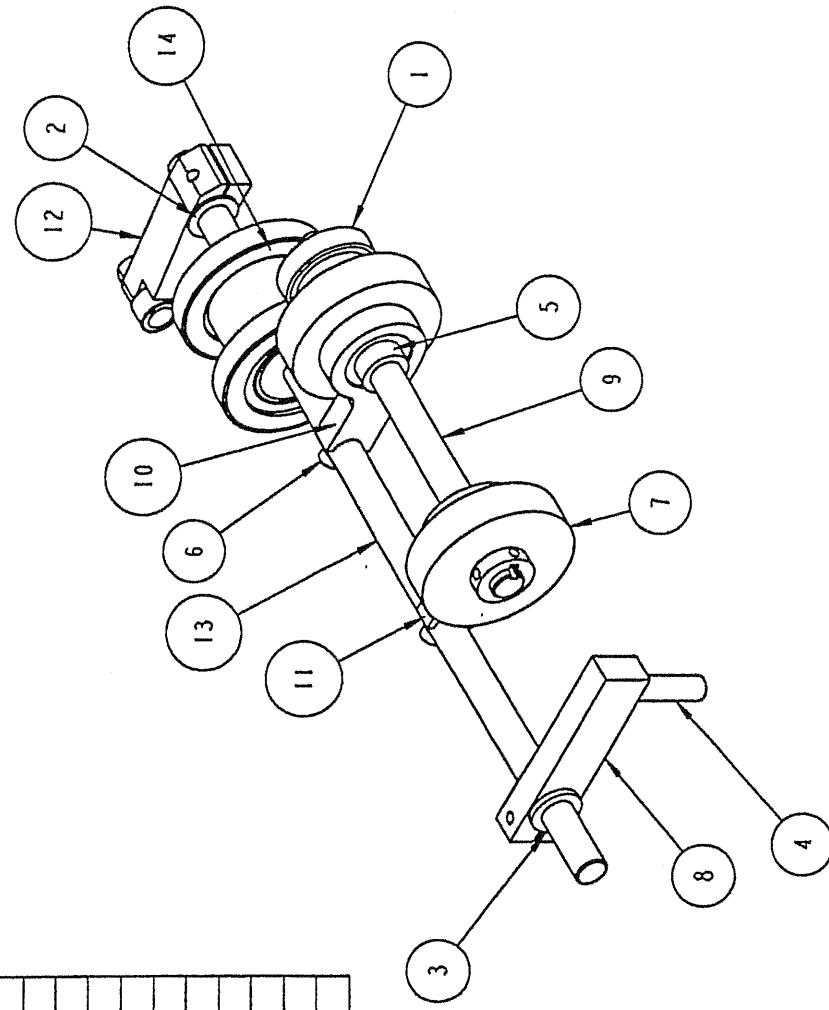
1 324-1  
REO-D WHERE USED

PROPRIETARY AND CONFIDENTIAL  
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MAY BE QUOTED OR REPRODUCED  
IN ANY FORM WITHOUT THE  
EXPRESS WRITTEN PERMISSION  
OF KIRK-RUDY, INC.  
WOODSTOCK, GA 30188 USA

KRK KIRK - RUDY, INC.  
WOODSTOCK, GEORGIA

DRAWN BY: CMC	SCALE 0 . 156	MATERIAL: N/A	THIRD ANGLE PROJECTION [Diagram showing projection types]
CHECKED BY:	DIMENSIONAL TOLERANCES .00 .005 .5 .00 .005 .5 ANG.	HEAT TREAT: N/A	MODEL: 324-1
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: OF 2	TITLE: ASSY, 324-1 FEEDER WIDE DRAWING # 534734-02

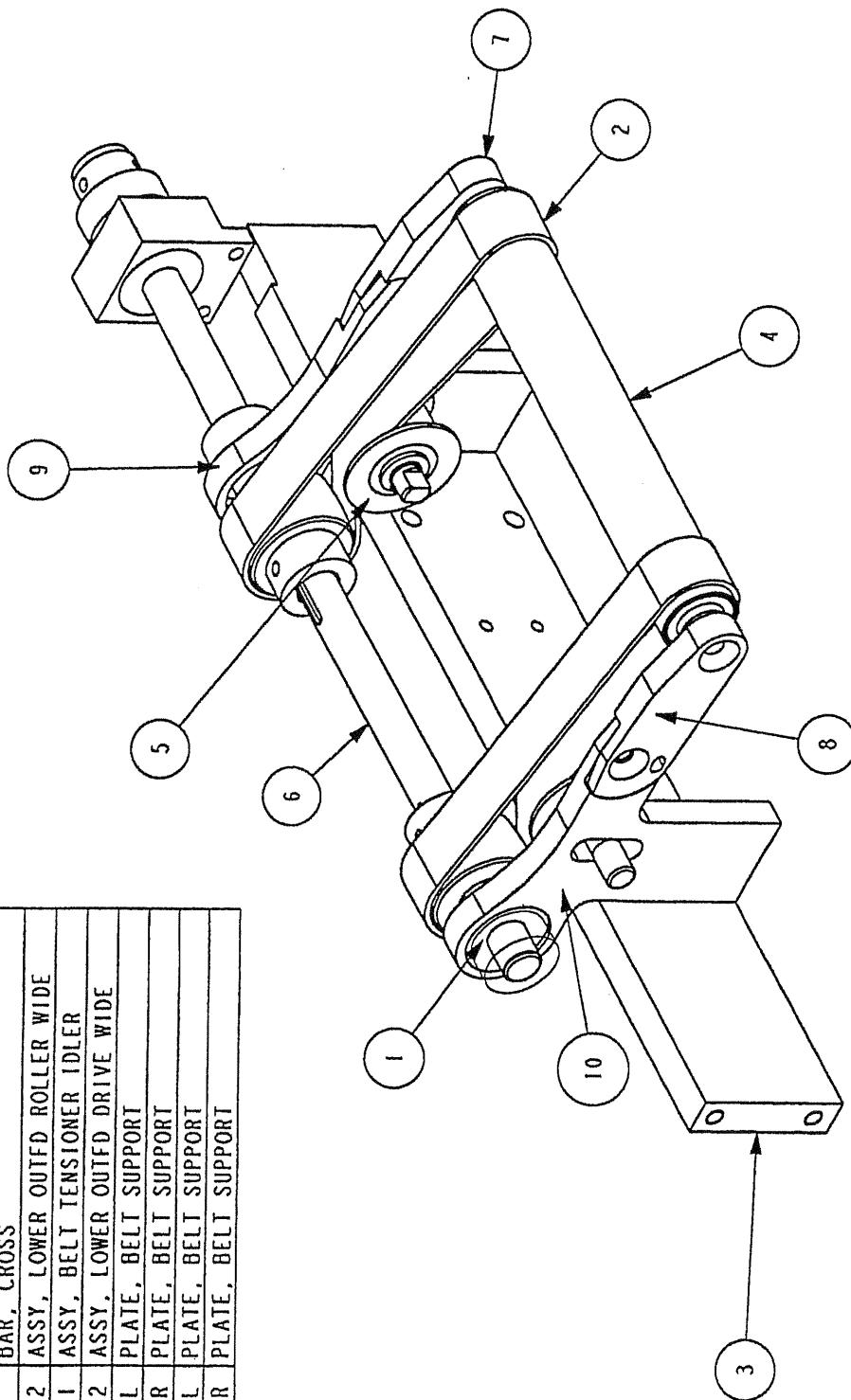
ITEM QTY	PART #	DESCRIPTION
1	1 01916	GEAR, 1628 .625B .188X
2	1 02320	SHIM, .625X1.000X.062
3	2 102657	SHIM, .625X1.000X.125
4	1 102701	SPRING
5	2 103804	BEARING - HUB
6	2 107104	BOLT, SHOULDER 5/16X3/4
7	2 500746	ROLLER - BOTTOM FEED
8	1 500786	LEVER, SPRING
9	1 508865	SHAFT, FEED ROLLER
10	1 500729-4L	ARM, FEEDER CRADLE HUBBRG LH
11	1 500729-4R	ARM, CRADLE FEEDER HUBBRG RH
12	1 500734A	CLAMP ARM ASY
13	1 500827-1	SHAFT, SPRING LEVER
14	1 531102-01	ASSY, HUB GEAR



REF NO	DATE	DESCRIPTION	CUST NO	BY
1	11/21/2000	REPLACED 500729-2 W/ 500729-4 REPLACED FLAT BRG W/ HUB BRG	6624	TJG
1				534134-02
RECD WHERE USED				

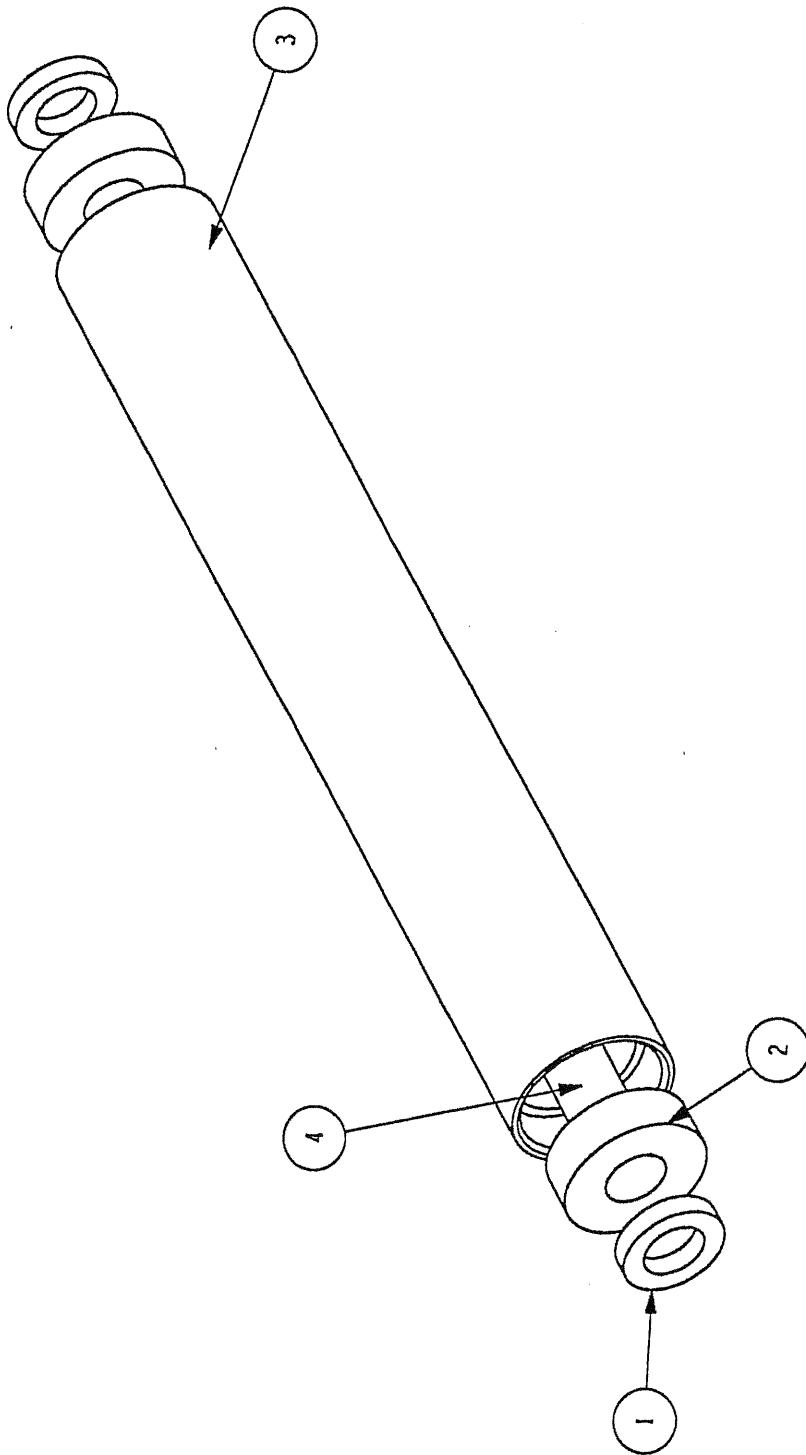
DRAWN BY:	SCALE	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	MATERIAL:	THIRD ANGLE PROJECTION	PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE QUOTED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC. KENNESAW, GA 30044 USA
AYB	0 .313	.000 .005 .005 .005	N/A		
CHECKED BY:	DATE	REMOVED ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED	MEAT TREAT:	MODEL:	KIRK - RUDY INC. KENNESAW, GEORGIA
TRACED BY:	MASTER	ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY	FINISH:	324-1	PRINT:
			QTY:	10F 1	531022-05

ITEM QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BT
1	1	103108 BEARING, FLAT .500					
2	2	106301 BELT, FLAT 3/4 X 13.875					
3	1	508766 BAR, CROSS					
4	1	534743-02 ASSY, LOWER OUTFD ROLLER WIDE					
5	2	534744-01 ASSY, BELT TENSIONER IDLER					
6	1	534745-02 ASSY, LOWER OUTFD DRIVE WIDE					
7	1	SP6306-LL PLATE, BELT SUPPORT					
8	1	SP6306-IR PLATE, BELT SUPPORT					
9	1	SP6306-6L PLATE, BELT SUPPORT					
10	1	SP6306-6R PLATE, BELT SUPPORT					



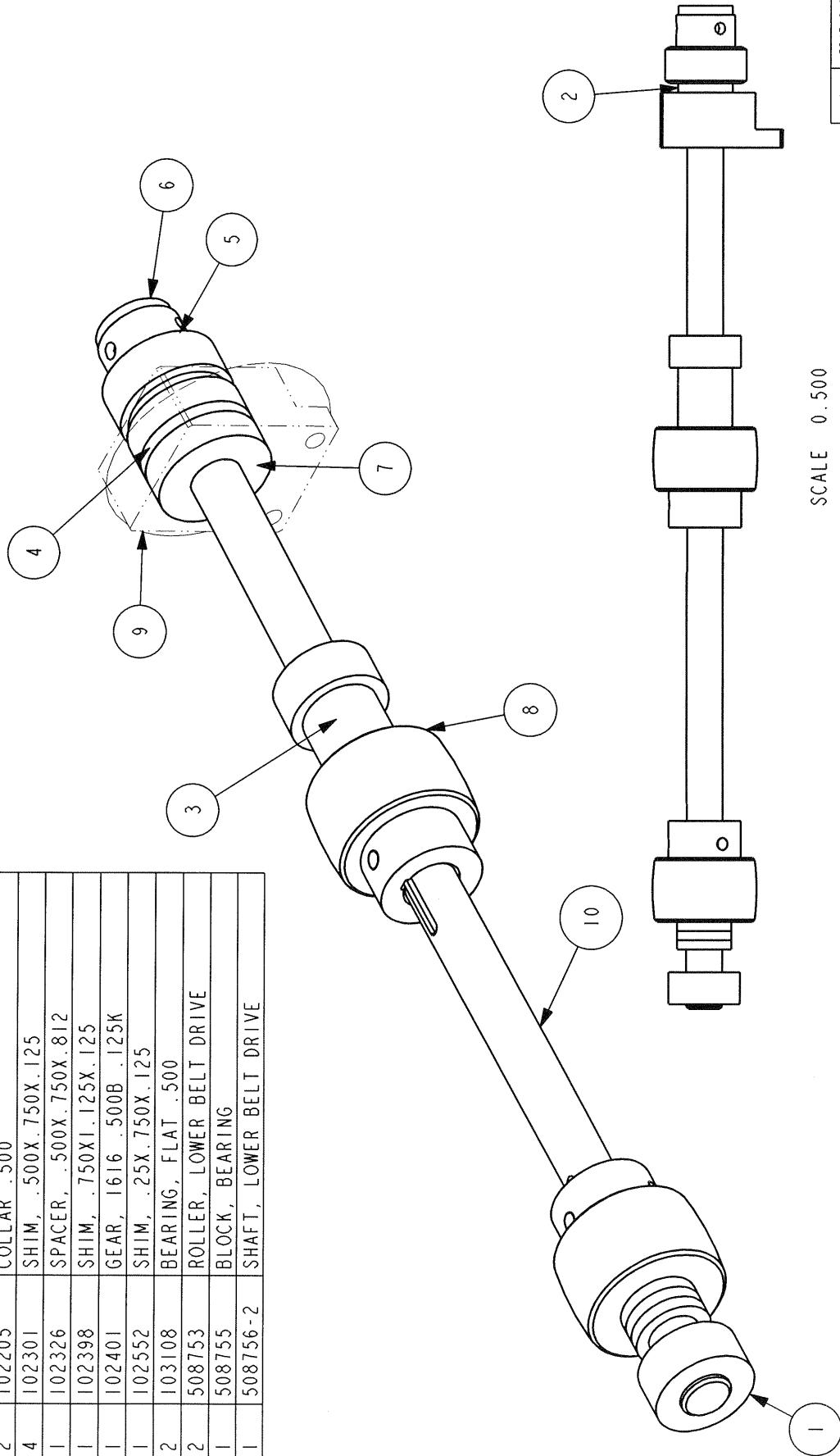
DRAWN BY:	SCALE	0 . 500	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	MATERIAL: N/A	THIN ANGLE PROJECTION	PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE COPIED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC. KENNESAW, GA 30144 USA
ENCLDED BY:	DATE	29 - JUN - 00	.01 .005 .005	MEAT TREAT: N/A	324-1	TIME: 324-1
TRACED BY:	MASTER		REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE. WORK TO DIMENSIONS ONLY	THINDE: N/A	SELECT NO: OF 1	DRAWING #: 534742-02

ITEM QTY	PART #	DESCRIPTION
1	2 102345	SHIM. .375X.625X.125
2	2 103106	BEARING, FLAT .375
3	1 508763	ROLLER, IDLER
4	1 508765	SHAFT, IDLER ROLLER



DRAWN BY:	SCALE	1 . 000	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	MATERIAL: N/A	THIRD ANGLE PROJECTION	PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE COPIED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC. KENNESAW, GA 30144 USA
CHECKED BY:	DATE	28 - JUN - 00	.11 .015 .005 .5	FINISH TREAT: N/A	MODEL:	TIME:
TRACED BY:	MASTER		REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED	FINISH:	324-1	ASSY, LOWER OUTFD ROLLER WIDE
			ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY	SHEET NO.	OF 1	DRAWING #
						534743 - 02

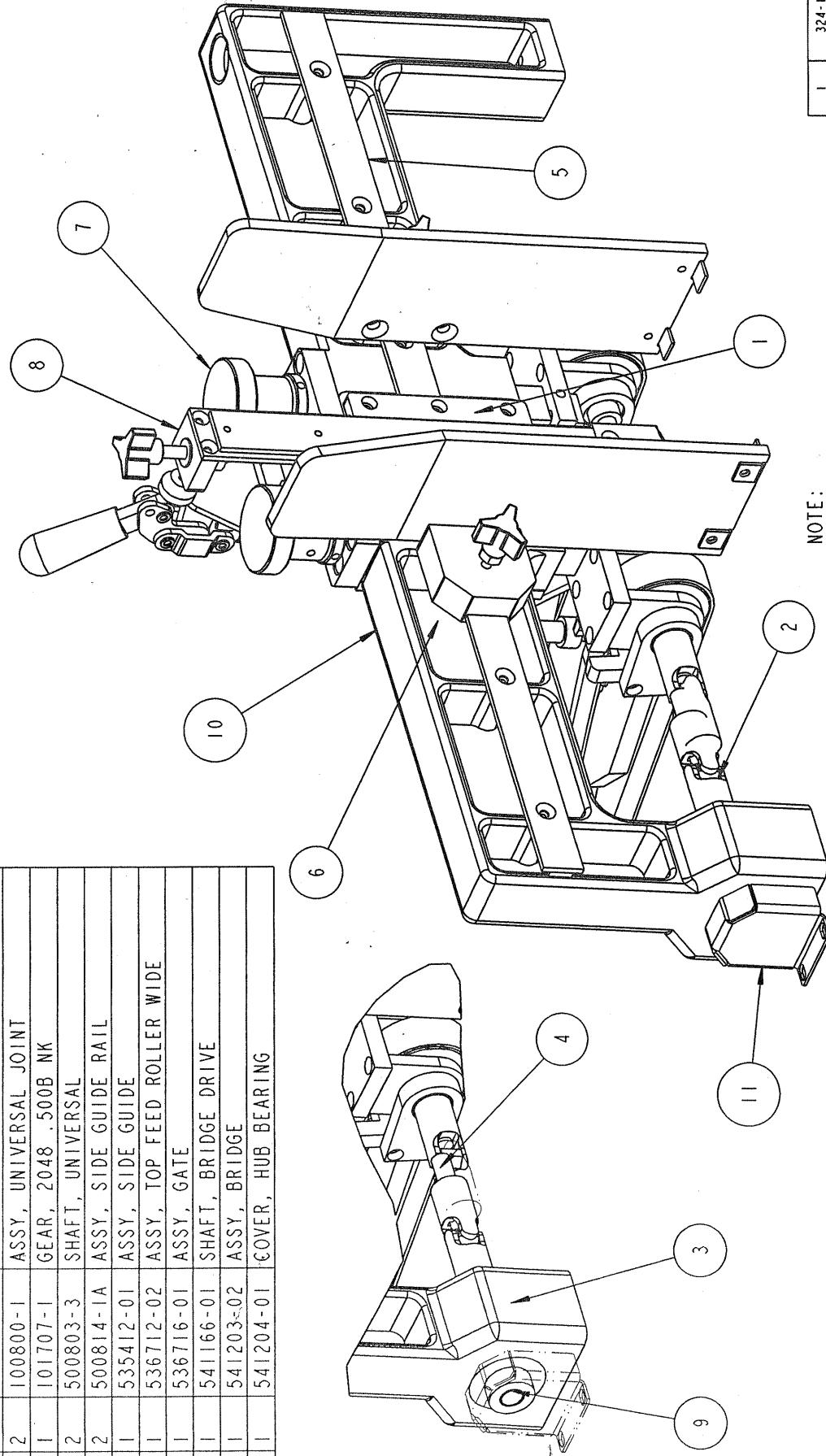
ITEM QTY	PART #	DESCRIPTION	REV NO	DATE	ECN NO	BY
1	2	102205 COLLAR .500				
2	4	102301 SHIM, .500X.750X.125				
3	1	102326 SPACER, .500X.750X.812				
4	1	102398 SHIM, .750X1.125X.125				
5	1	102401 GEAR, 1616 .500B .125K				
6	1	102552 SHIM, .25X.750X.125				
7	2	103108 BEARING, FLAT .500				
8	2	508753 ROLLER, LOWER BELT DRIVE				
9	1	508755 BLOCK, BEARING				
10	1	508756-2 SHAFT, LOWER BELT DRIVE				



SCALE 0.500

DRAWN BY:	AYB	SCALE	0 . 750	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	MATERIAL: N / A	THIRD ANGLE PROJECTION NO. 324 - 1	PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE COPIED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY INC. KENNESAW, GA 3044 USA	KIRK - RUDY, INC. KR KENNESAW, GEORGIA
CHECKED BY:		DATE	28 - Jun - 00	.01 .005 .5 XXX ANG.	HEAT TREAT: N / A	MODEL: 324 - 1	TITLE: ASSY, LOWER OUTFD DRIVE WIDE	REO D WHERE USED 1 534742-02
TRACED BY:		MASTER		REMOVE ALL BURS AND SHARP EDGES UNLESS OTHERWISE NOTED ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE " WORK TO DIMENSIONS ONLY	FINISH: N / A	SHEET NO.: 10F	DRAWING #	534745-02

ITEM QTY	PART #	DESCRIPTION
1 2	500805	PLATE - HOLD DOWN
2 2	100800-1	ASSY, UNIVERSAL JOINT
3 1	101707-1	GEAR, 2048 .500B NK
4 2	500803-3	SHAFT, UNIVERSAL
5 2	500814-1A	ASSY, SIDE GUIDE RAIL
6 1	535412-01	ASSY, SIDE GUIDE
7 1	536712-02	ASSY, TOP FEED ROLLER WIDE
8 1	536716-01	ASSY, GATE
9 1	541166-01	SHAFT, BRIDGE DRIVE
10 1	541203-02	ASSY, BRIDGE
11 1	541204-01	COVER, HUB BEARING

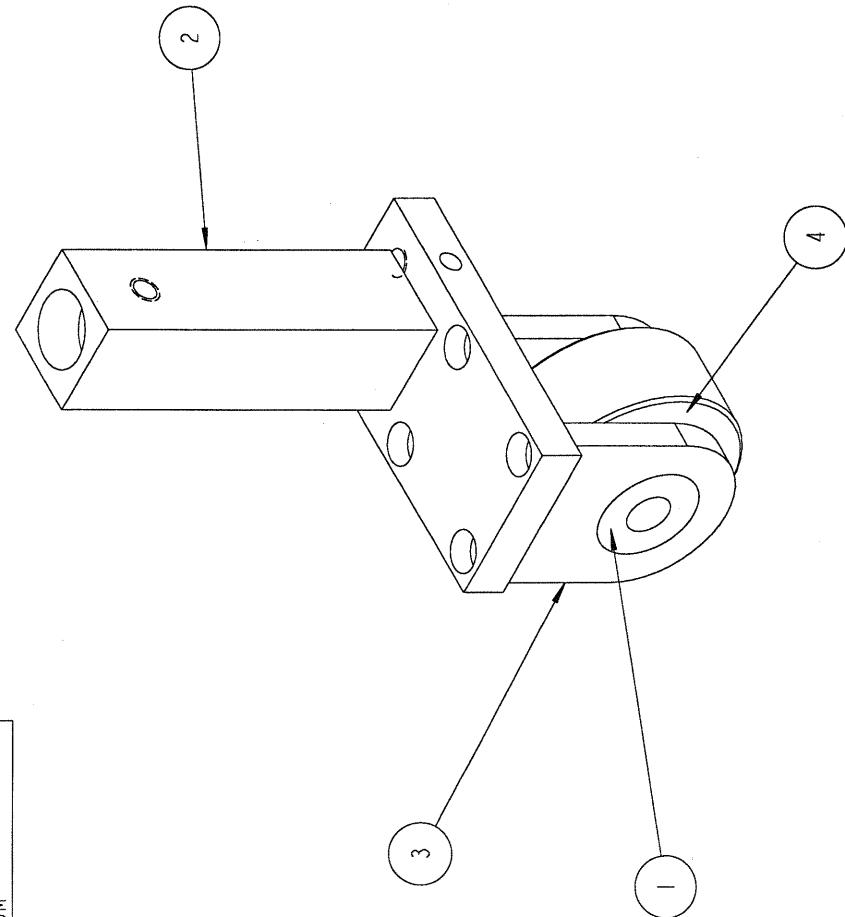


NOTE:  
1) FOR WIDE SHUTTLE

REV NO	DATE	DESCRIPTION	ECN NO	BY
1	324-1			REF'D WHERE USED

DRAWN BY:	CMC	SCALE	0 .083	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 - JUN - 04	.XX .XXX .01 .005 .5 ANG.	HEAT TREAT:	N/A	MODEL:	KIRK - RUDY , INC. WOODSTOCK , GEORGIA
TRACED BY:				REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED	FINISH:	N/A	TITLE:	ASSY , BRIDGE 324-1 WIDE
MASTER				ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY	SHEET NO. 1 OF 1		DRAWING #	540034-02





ITEM	QTY	PART #	DESCRIPTION
1	2	103106	BEARING, FLAT .375
2	1	508748	ASS'Y, ROLLER MTG
3	2	508937	BLOCK, ROLLER BEARING
4	1	508746-A	ASSY, ROLLER ALUMINUM

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

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

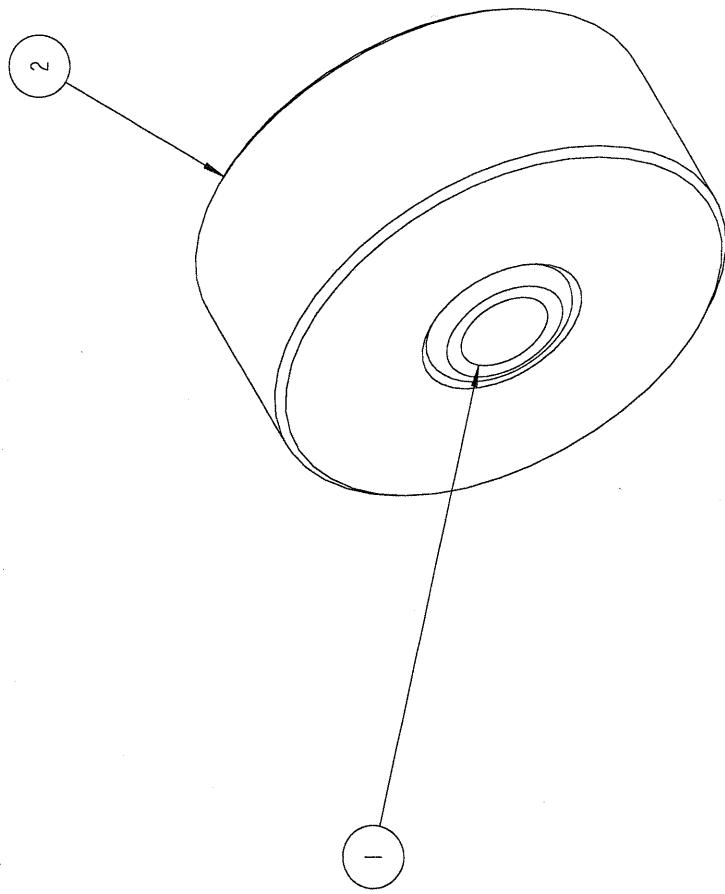
KIRK - RUDY, INC.  
KENNESAW, GEORGIA

TITLE: ASSY, UPPER DRIVE ROLLER

THIRD ANGLE PROJECTION

SCALE: T JG	0 . 750	MATERIAL: N/A	MODEL: 324-1
DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED		HEAT TREAT:	SHEET NO.: 10F
.XX	.XXX	ANG.	
.01	.005	.5	
REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED			
ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY			
DRAWN BY: T JG	DATE: 7-0c† - 98	MASTER M	
CHECKED BY:			
TRACED BY:			

ITEM QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	101100	BEARING, ONEWAY .375					
2	508746	ROLLER, UPPER FEED					



2	324-1
REQ'D WHERE USED	
 KIRK - RUDY, INC.  KENNESAW, GEORGIA	
<small>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</small>	
THIRD ANGLE PROJECTION	
	
MATERIAL:	N / A
DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	
.XX	.XXX
DATE	ANG.
.01	.005
CHECKED BY:	.5
4 - Sep - 98	HEAT TREAT:
	N / A
TRACED BY:	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED
MASTER	FINISH:
	ALL DIMENSIONS ARE FINAL SHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY
SHEET NO:	OF
ASSY, ROLLER ALUMINUM	
DRAWING #	
508746 - A	

## **7 ELECTRICAL SCHEMATICS AND PARTS**

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**7.1 WIRING DIAGRAMS LIST (SHEETS SUPPLIED SEPARATELY)**

**7.2 PARTS LIST**

**7.3 RELAY LIST**

## **8 APPENDIX**

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(THIS PAGE LEFT BLANK FOR FUTURE REFERENCES)

## 9 NOTES

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## **9 NOTES**

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## **10 WARRANTY AND SERVICE**

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### **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.

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