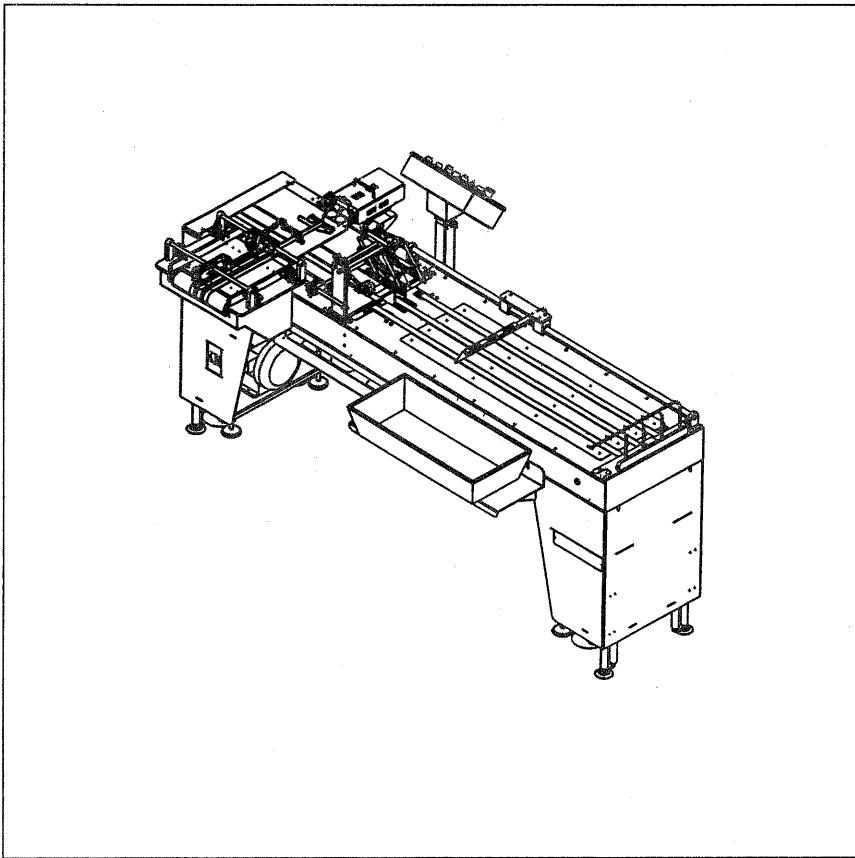


Kirk-Rudy Inc.

Instruction and Parts Manual

KR345 Edge Stacker



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.

10000-345 REV. 4 8/13/04

Instruction
and Parts Manual

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1.0 Important Safety Instructions

Intended Use Statement: The KR 345 is a belted conveyor transport designed to shingle or shingle and edge stack paper and plastic products. The system is made up of three major sections - the infeed, crossfeed and outfeed sections. Product enters the 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

- * 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 LISCENSED 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	7'
Height	42"
Width	38"
Infeed height	33.2" (can vary with optional infeed conveyor)
Conveyor exit direction	Specify left or right

Electrical Requirements

Voltage	120 VAC
Current	15 amps
Phase	single
Hertz	60

Production Rate

Belt speed	400 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 9" and 6" x 11" card stock or envelope
Min stock size-shingle only	3" x 5"
Max stock size-shingle only	9" x 12"
Minimum stock thickness-shingle only	copy paper
Maximum stock thickness	1/4"

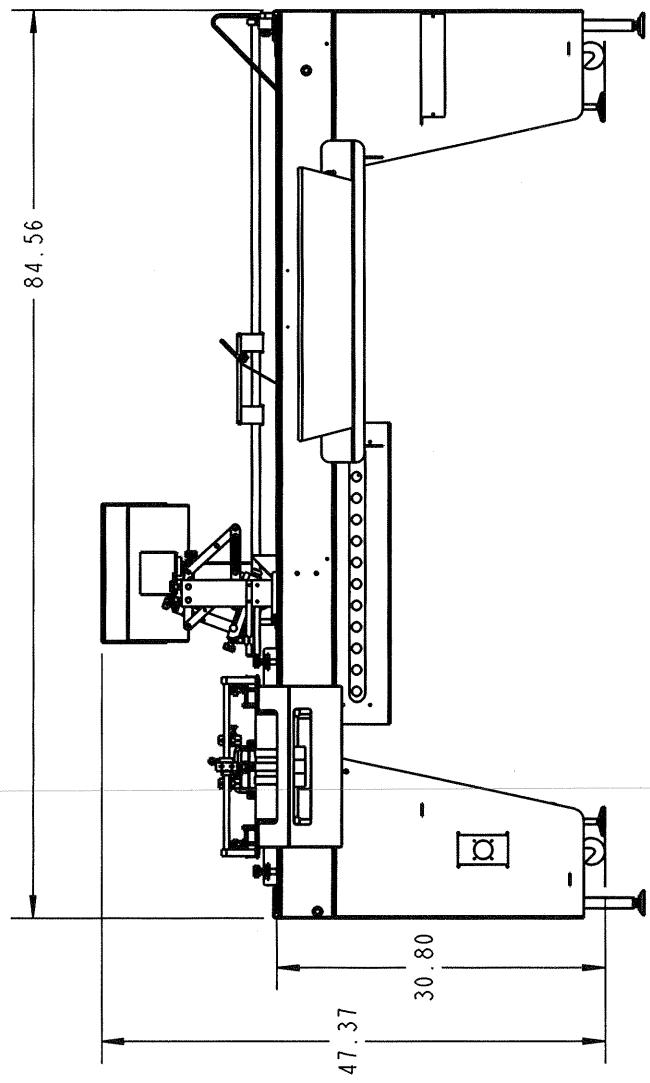
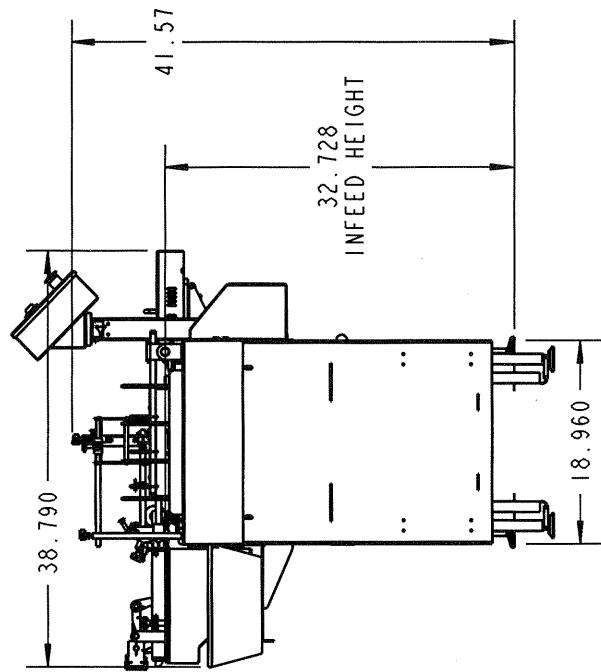
Features

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

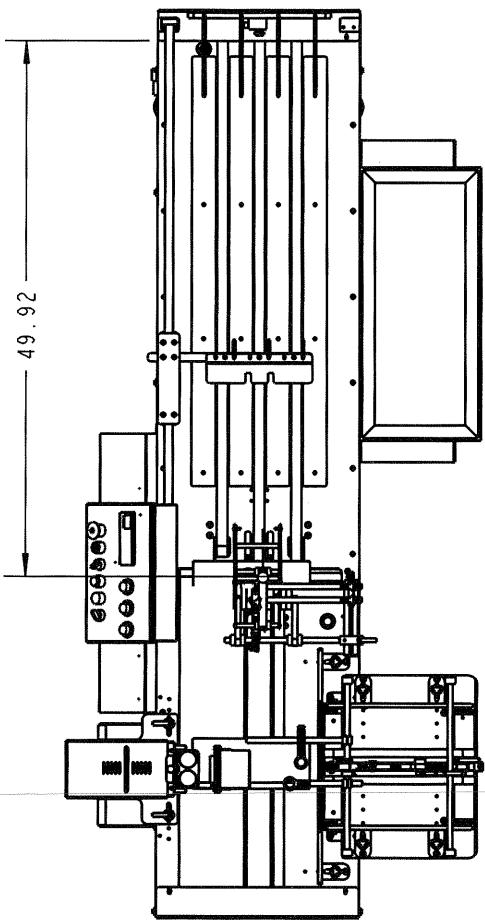
Options

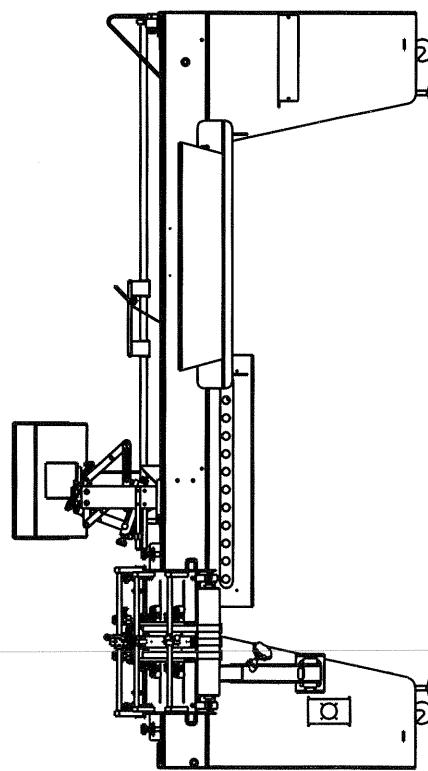
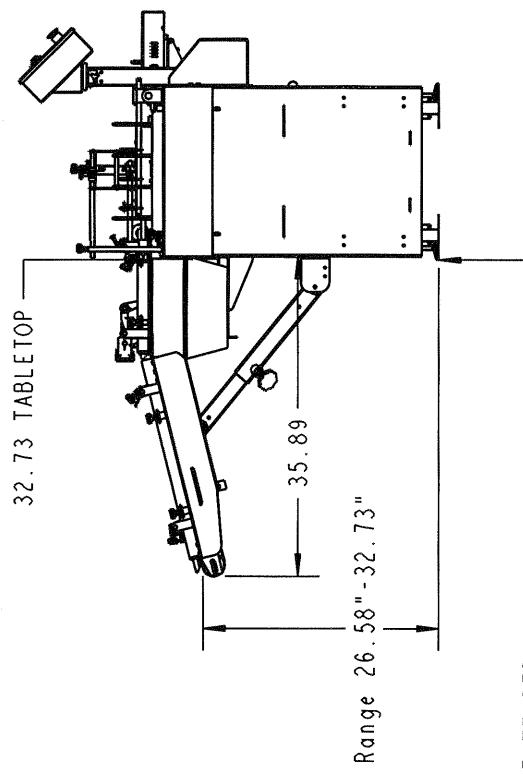
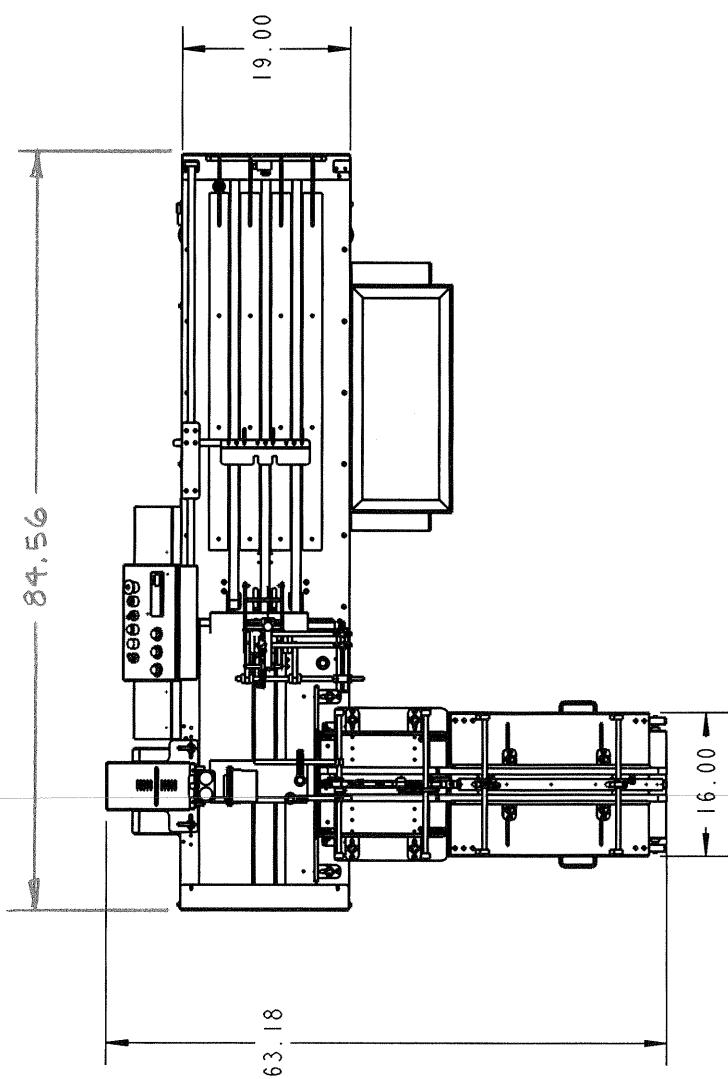
Hydraulic lift kit
Left or right outfeed conveyor
Stack mark reader
*Incline infeed conveyor extension

***Note: With optional infeed extension product width is limited to 9.75". Product thickness may be limited dependent on conveyor incline angle.**

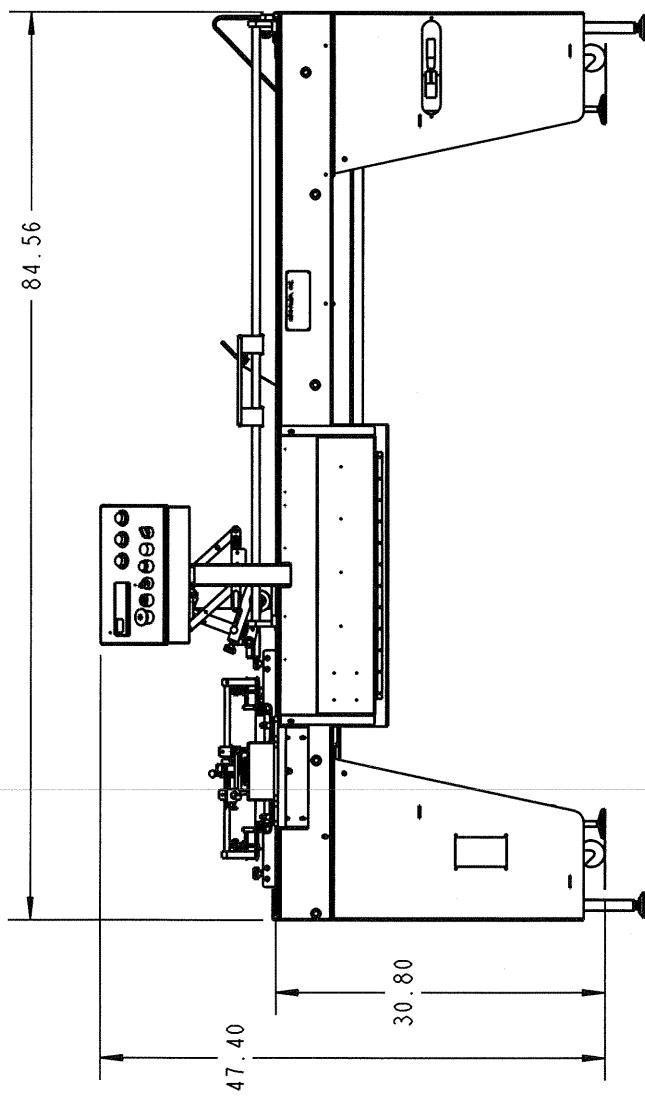
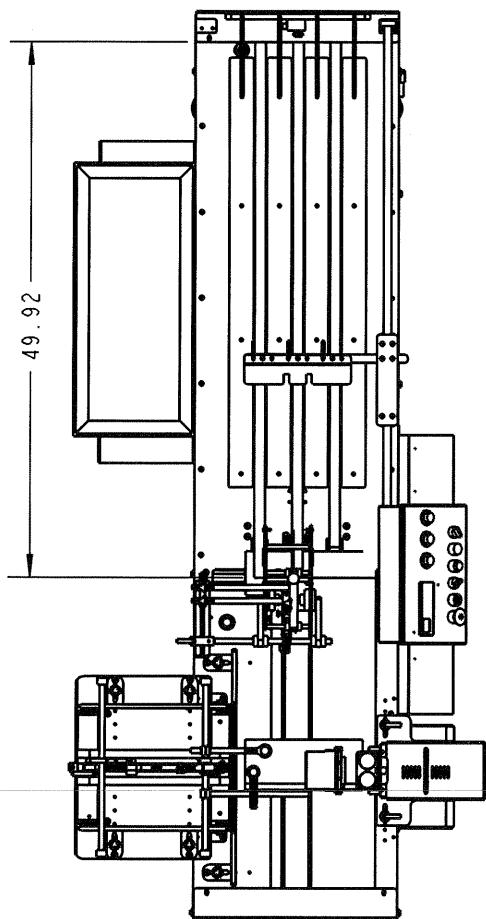
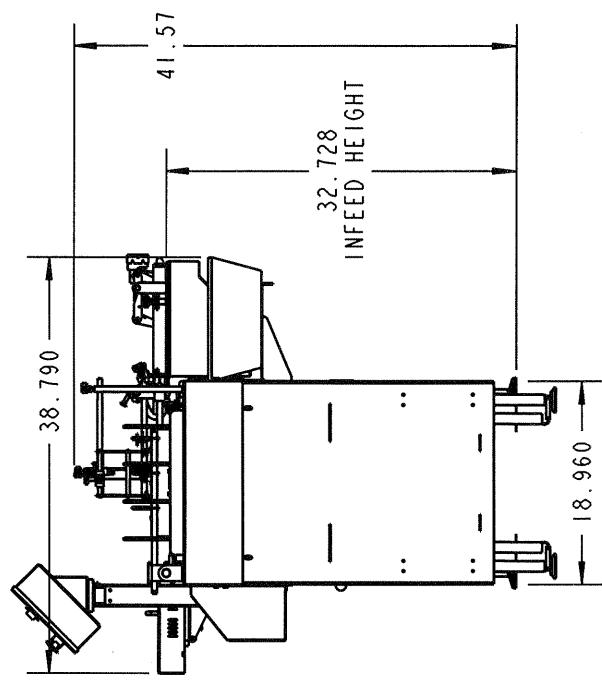


KR345R W/ STANDARD INFEED

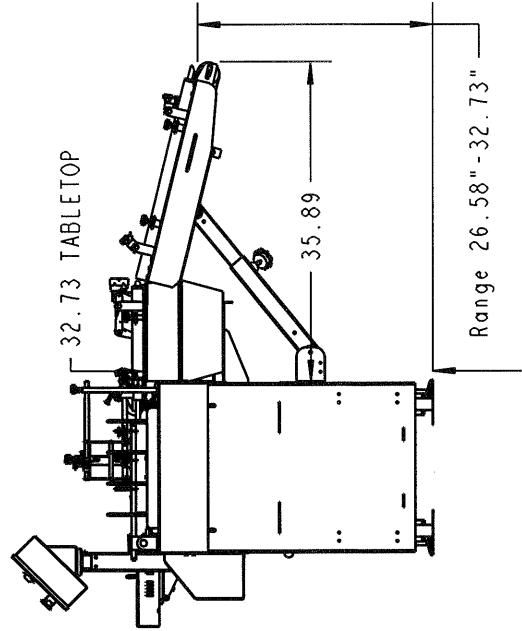
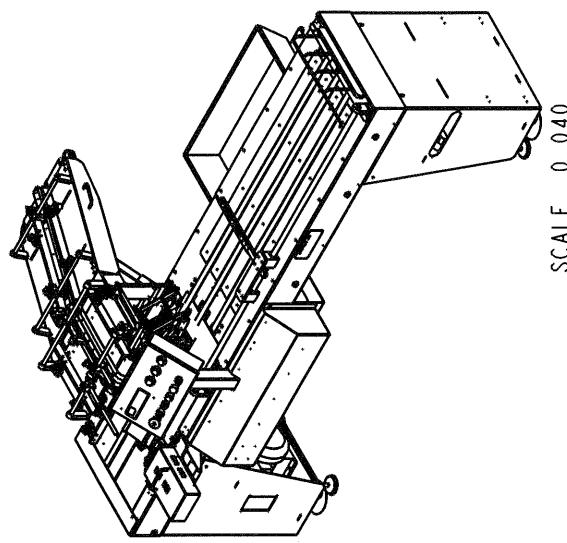
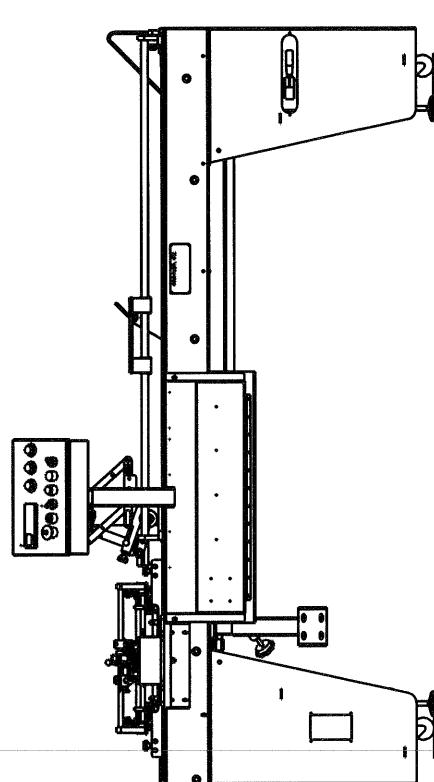
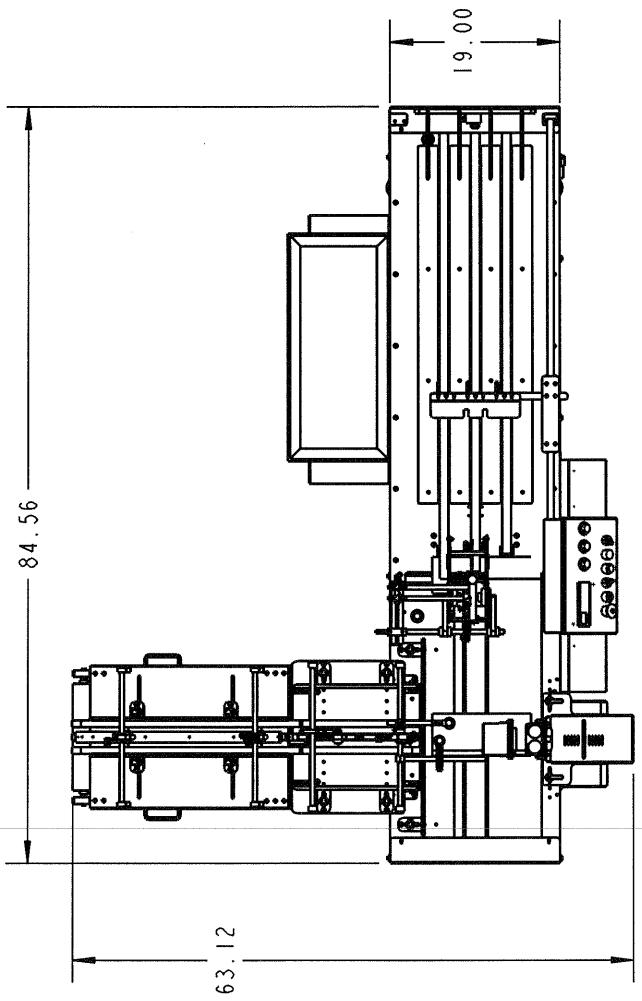




KR345R WITH EXTENDED
INFEED CONVEYOR



KR345L W/ STANDARD INFEED



KR345L WITH EXTENDED
INFEED CONVEYOR

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 – infeed, crossfeed and outfeed conveyors. The infeed conveyor 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. 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.

4.2 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.
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.
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.

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
- 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.
- 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 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.
2. The crossfeed beam switch controls the clutch on the crossfeed conveyor. The clutch engages and drives the crossfeed belts when the beam switch is covered.
3. 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.
4. The outfeed beam switch is a perfect prox type. This switch controls the clutch on the outfeed conveyor. When the product is within two inches of the switch, the clutch engages and drives the outfeed belts. To keep the clutch from constantly cycling, set an outfeed delay of .4 seconds in 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.

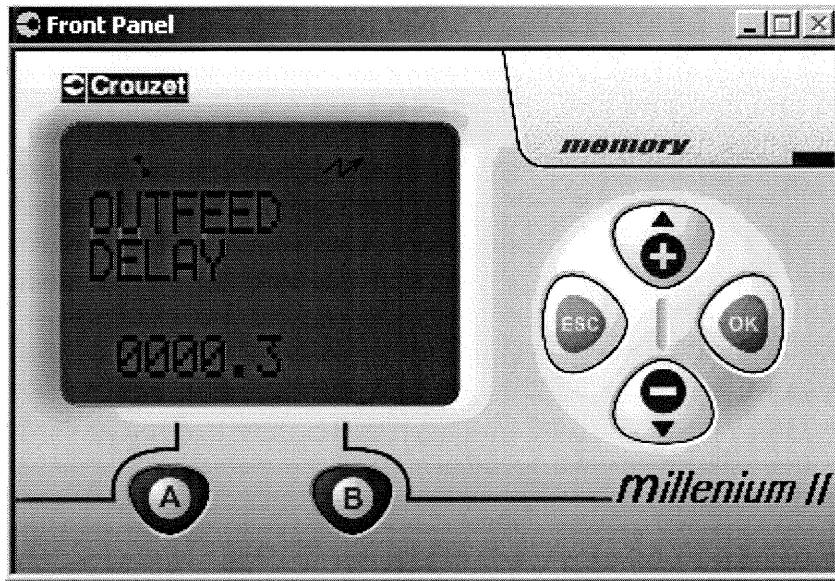
“-“ Button: This button works just like the “+” button except that it will decrement the value being edited.

4.3.3 Screens:

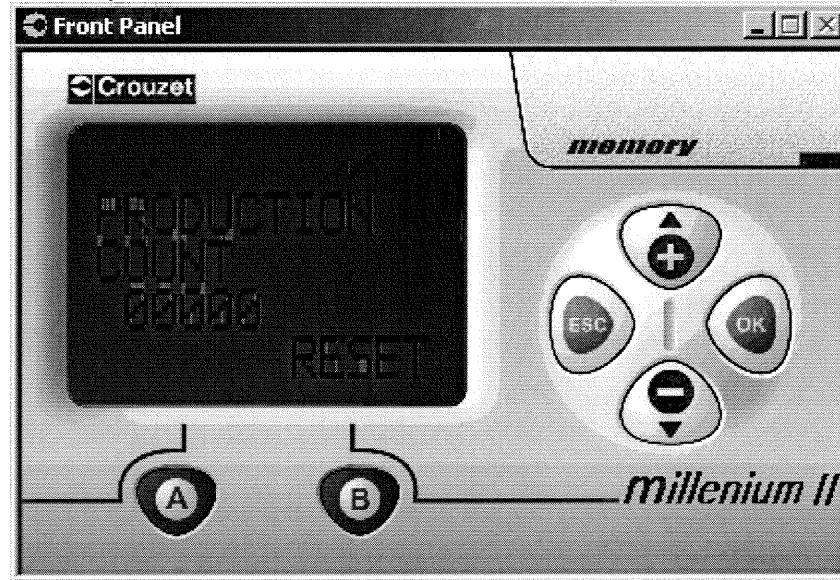
Main Screen: The main screen is the PLC default screen. It shows the current I/O status, the time, and the date. Pressing the “A” button will bring up the next screen.



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.



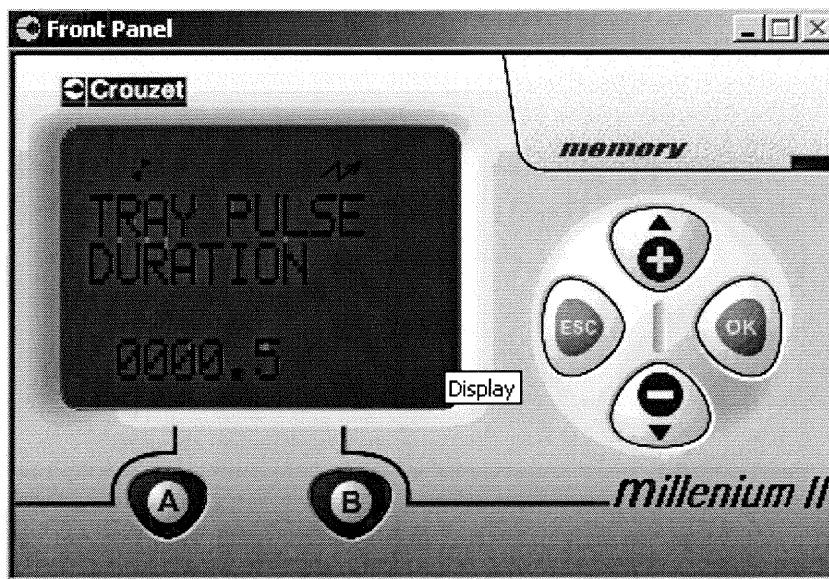
Sort Screen: This screen contains two variables. To move from one variable to the other, use the “+” and “-“ keys. Both functions operate off the Counter PE. The “Trig Delay” is a time delay before the sort actuator is activated after the sort count is complete. The Sort Preset is the number of pieces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

5.4 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.

5.5 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. Place a single mail piece against the wedges.
3. Adjust the outfeed proximity switch.
 - i. Set the height to one inch below the top of the mail piece.
 - ii. Set the distance between the switch and the mail piece to slightly more than 2". If the distance is less than 2", the outfeed conveyor will start and move the backstop downstream causing the wedges to fall away. If edge stacking occurs on the cross feed section, the cross feed belt will jostle the stack sideways.
4. Set the height of the vertical stop bar. Leaving a 1 4-1/2" space will allow for a more vertical stack.
5. Ensure the press down roller assembly is centered on the piece.

5.6 System operation

1. Set the infeed and crossfeed speeds to mid range and the outfeed speed at the minimum setting.
 - a. The 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. Turn the blower on.
3. Make sure all personnel and tools are clear, then press start.
4. Run one product and make necessary adjustments.
5. To use as a conventional conveyor, lift the backstop out of the way and install the 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.

5.7 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 Infeed Conveyor

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

6.2 Cossfeed 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

ASSEMBLY #	DESCRIPTION
KR345L	ASSY, KR345 ON-EDGE STACKER LH
KR345R	ASSY, KR345 ON-EDGE STACKER RH
544193-01	ASSY, UPPER PRODUCT GUIDE LH
544193-02	ASSY, UPPER PRODUCT GUIDE RH
544729-01	ASSY, ROLLER PRODUCT LH
544729-02	ASSY, ROLLER PRODUCT RH
544284-01	ASSY, SHINGLE SECTION LH
544284-02	ASSY, SHINGLE SECTION RH
530656-01	ASSY, VACUUM MANIFOLD
544207-01	ASSY, LINEAR GUIDE BRACKET
544756-01	ASSY, PRODUCT STOP
544287-01	ASSY, IDLER SHAFT LH
544287-02	ASSY, IDLER SHAFT RH
544295-01	ASSY, IDLER CONVEYOR BELT
544498-01	ASSY, SIDGUIDE SHINGLE SECTION
544293-01	ASSY, INFEED SECTION
544492-01	ASSY, SIDEGUIDE INFEED
544567-01	ASSY, SKIDBAR KR345
544454-01	ASSY, KR345 OUTFEED SECTION LH
544454-02	ASSY, KR345 OUTFEED SECTION RH
530610-01	ASSY, TAKEUP 1 IN BELT
530610-02	ASSY, TAKEUP 1 IN BELT
544459-01	ASSY, BACKSTOP LH
544459-02	ASSY, BACKSTOP RH
544469-01	ASSY, CONVEYOR FRAME LH
544469-02	ASSY, CONVEYOR FRAME RH
538171-04	ASSY, 1/4HP GEARHEAD W/CLUTCH
539424-01	ASSY, RH HYDRALIFT LEG
539425-01	ASSY, LH HYDRALIFT LEG
544335-01	ASSY, CONTROL PANEL KR345

Optional Infeed Extension

544293-02	ASSY, INFEED SECTION
532466-01	ASSY, DRYER ARM PIVOT
546475-01	ASSY, CONVEYOR ANGLED
530619-01	ASSY, IDLER ROLLER
537284-09	ASSY, SKID BAR BUMPTURN
546482-01	ASSY, SIDEGUIDE INCLINE CONVEYOR

DRAWING 1 KR345L

ITEM QTY	PART #	DESCRIPTION	REV	DATE	ECN	RD	BY
1	2	10656-6 BELT, FLAT 1 X 110 5					
2	1	110020-61 CHAIN, #35 X 31.50"					
3	1	110020-62 CHAIN, #35 X 31.50"					
4	1	544193-01 ASSY, UPPER PRODUCT GUIDE LH					
5	1	544228-01 ASSY, SHINGLE SECTION LH					
6	1	544229-01 ASSY, INFED SECTION					
7	1	544229-02 ASSY, INFED SECTION					
8	1	544454-01 ASSY, MR345 OUTFEED SECTION LH					
9	1	544463-01 ASSY, CONVEYOR FRAME LH					

KR345 W/ STANDARD INFED

KR345 W/ EXTENDED INFED CONVEYOR ASSY# 546233-02

SCALE 0.090

KR345L W/ EXTENDED INFED CONVEYOR ASSY# 546233-02

KR345 ON-EDGE STACKER LH

SCALE 0.060

KR345L

DRAWING 1		REO 0 WHERE USED	
PROPRIETARY AND CONFIDENTIAL		NO PARTS OR INFORMATION CONTAINED HEREIN MAY BE COPIED, REPRODUCED, TRANSMITTED, EXPRESSED, OR MADE AVAILABLE IN WHOLE OR IN PART, IN ANY MANNER, WITHOUT THE WRITTEN CONSENT OF KIRK-RUDY, INC.	
1	KRK	KIRK - RUDY, INC. WOODSTOCK, GEORGIA	100
2	SAL184	ASSY, KR345 ON-EDGE STACKER LH	100
3	10F4	10F4	100

DRAWING 1		REO 0 WHERE USED	
PROPRIETARY AND CONFIDENTIAL		NO PARTS OR INFORMATION CONTAINED HEREIN MAY BE COPIED, REPRODUCED, TRANSMITTED, EXPRESSED, OR MADE AVAILABLE IN WHOLE OR IN PART, IN ANY MANNER, WITHOUT THE WRITTEN CONSENT OF KIRK-RUDY, INC.	
1	KRK	KIRK - RUDY, INC. WOODSTOCK, GEORGIA	100
2	SAL184	ASSY, KR345 ON-EDGE STACKER LH	100
3	10F4	10F4	100

ITEM	QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	2	100120	BUSHING, SL 375ID 500OD .750IG					
2	1	102131	KNOB, THUMB 1/4-20 SHCS					
3	2	102132	KNOB, 10-32 CAP SCREW					
4	4	102200	COLLAR .315					
5	2	102223	COLLAR .250					
6	1	102749	SPRING, COMP .88L .360D .045W					
7	2	500790	ASSY, KNOB					
8	1	500794	PLATE-MOUNTING					
9	1	202263-7	SENSOR, PERFECT PROX					
10	2	500790-3	ASSY, TRI-KNOB 1/4-20 STUD					
11	1	532750-01	CLAMP, BEAMSWITCH					
12	1	532750-02	CLAMP, BEAMSWITCH					
13	2	544194-01	LINK, PRODUCT GUIDE					
14	1	544195-01	BAR, UPPER PRODUCT GUIDE					
15	3	544196-01	SHAFT, LINK SPACER					
16	1	544197-01	SHAFT, LINK SPACER					
17	2	544198-01	LINK, PRODUCT GUIDE					
18	2	544199-01	LINK, PRODUCT GUIDE					
19	1	544200-01	BRACKET, BEAMSWITCH VERTICAL					
20	1	544201-01	BRACKET, BEAMSWITCH					
21	1	544202-01	BAR, UPPER PRODUCT GUIDE MOUNT					
22	2	544203-01	SHAFT, PRODUCT GUIDE MOUNT					
23	2	544585-01	PLATE, PRODUCT GUIDE					
24	2	544586-01	PLATE, THREADED PRODUCT GUIDE					
25	1	544729-01	ASSY, ROLLER PRODUCT LH					
26	2	CSDD267	SCREW, SHCS 10-32X .750					
27	2	CSDD297	SCREW, SHCS 1/4-20X 1.250					
28	10	CSFF57	SCREW, BUTTON HEAD #10-32X .375					
29	4	CSFF59	SCREW, BUTTON HEAD #10-32X .625					
30	6	LOCKNUT-10 BX STUD						
31	1	WAV09	WASHER, FLAT 1/4					

TITLE: ASSY, UPPER PRODUCT GUIDE LH

DRAWING # 544193-01

ITEM NO.	7 JG	SCALE	0 .312	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	XXX	MATERIAL:	XXX
CHECKED BY:		DATE	25-JUL-03	IN	IN	WEIGHT:	XXX
TRACED BY:		MASTER		IN	IN	FORM:	XXX
				SPECIFY ALL SURFACES AND SHAPES UNLESS OTHERWISE NOTED			
				FILLING HISTORIES, ALL FILLING HISTORIES, ALL DO NOT SCALE, WORK DO SURFACES ONLY			
				PRINTED ON 10/04/2003			
				SHEET NO. 1 OF 1			
				SCALE 0.250			

ITEM	QTY	PART #	DESCRIPTION	REV NO	DATE	ECN NO	BY
1	2	1001120	BUSHING, SL. 375ID.500OD.150LG				
2	1	102131	KNOB, THUMB 1/4-20 SHCS				
3	2	102132	KNOB, 10-32 CAP SCREW				
4	4	102200	COLLAR .315				
5	2	102223	COLLAR .250				
6	1	102749	SPRING COMP 88L 3600 .045W				
7	2	500790	ASSY, KNOB				
8	1	500794	PLATE-MOUNTING				
9	1	20226-7	SENSOR, PERFECT PROX				
10	2	500790-3	ASSY, TRI-KNOB 1/4-20 STUD				
11	1	532750-01	CLAMP BEAMSWITCH				
12	1	532750-02	CLAMP BEAMSWITCH				
13	1	539683-01	SPACER, TABLETOP				
14	2	54419-01	LINK, PRODUCT GUIDE				
15	1	544193-01	BAR, UPPER PRODUCT GUIDE				
16	3	544196-01	SHAFT, LINK SPACER				
17	1	544197-01	SHAFT, LINK SPACER				
18	2	544198-01	LINK, PRODUCT GUIDE				
19	2	544198-01	LINK, ROLLER PRODUCT RH				
20	1	544200-01	BRACKET, BEAMSWITCH VERTICAL				
21	1	544201-01	BRACKET, BEAMSWITCH				
22	1	544202-01	BAR, UPPER PRODUCT GUIDE MOUNT				
23	2	544203-01	SHAFT, PRODUCT GUIDE MOUNT				
24	1	544729-02	ASSY, ROLLER PRODUCT RH				
25	2	CSD267	SCREW, SHCS 10-32X .750				
26	1	CSD296	SCREW, SHCS 1/4-20X1.000				
27	2	CSD287	SCREW, SHCS 1/4-20X1.250				
28	1	CSD300	SCREW, SHCS 1/4-20X2.000				
29	10	CSFF57	SCREW, BUTTON HEAD 10-32X.315				
30	4	CSFF59	SCREW, BUTTON HEAD 10-32X.625				
31	6	LOCKNUT-10 BPX STUD					
32	1	WA009	WASHER, FLAT 1/4				
			SCALE 0.250				
			SCALE 0.312				
			DATE 25-Jul-03				
			MASTER				
			TRACED BY:				
			RECD WHERE USED				
			TIME: 10:51 AM				
			NAME: SA184				
			INITIALS: XXX				
			REASON: ALL SURFACES UNLESS OTHERWISE NOTED				
			NOTES: 1. NO. 10 SURFACE IS TO BE SHARP CHAMFERED UNLESS OTHERWISE NOTED				
			2. ALL FINISHED DIMENSIONS ARE IN INCHES. UNLESS NOTED, DIMENSIONS ARE IN MILLIMETERS.				
			3. ALL DIMENSIONS ARE IN MILLIMETERS.				
			4. NO. 10 SURFACE IS TO BE SHARP CHAMFERED UNLESS OTHERWISE NOTED				
			5. NO. 10 SURFACE IS TO BE SHARP CHAMFERED UNLESS OTHERWISE NOTED				
			6. NO. 10 SURFACE IS TO BE SHARP CHAMFERED UNLESS OTHERWISE NOTED				
			7. NO. 10 SURFACE IS TO BE SHARP CHAMFERED UNLESS OTHERWISE NOTED				
			8. NO. 10 SURFACE IS TO BE SHARP CHAMFERED UNLESS OTHERWISE NOTED				
			9. NO. 10 SURFACE IS TO BE SHARP CHAMFERED UNLESS OTHERWISE NOTED				
			10. NO. 10 SURFACE IS TO BE SHARP CHAMFERED UNLESS OTHERWISE NOTED				
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			27. NO. 10 SURFACE IS TO BE SHARP CHAMFERED UNLESS OTHERWISE NOTED				
			28. NO. 10 SURFACE IS TO BE SHARP CHAMFERED UNLESS OTHERWISE NOTED				
			29. NO. 10 SURFACE IS TO BE SHARP CHAMFERED UNLESS OTHERWISE NOTED				
			30. NO. 10 SURFACE IS TO BE SHARP CHAMFERED UNLESS OTHERWISE NOTED				
			31. NO. 10 SURFACE IS TO BE SHARP CHAMFERED UNLESS OTHERWISE NOTED				
			32. NO. 10 SURFACE IS TO BE SHARP CHAMFERED UNLESS OTHERWISE NOTED				

1	KA3458
2	RECD WHERE USED
3	TIME: 10:51 AM
4	NAME: KIRK - RUDY, INC
5	ADDRESS: 100 WOODSTOCK, GEORGIA
6	PHONE: (404) 368-0000
7	FAX: (404) 368-0000
8	INITIALS: XXX
9	REASON: ALL SURFACES UNLESS OTHERWISE NOTED
10	NOTES: 1. NO. 10 SURFACE IS TO BE SHARP CHAMFERED UNLESS OTHERWISE NOTED
11	2. ALL FINISHED DIMENSIONS ARE IN INCHES. UNLESS NOTED, DIMENSIONS ARE IN MILLIMETERS.
12	3. NO. 10 SURFACE IS TO BE SHARP CHAMFERED UNLESS OTHERWISE NOTED
13	4. NO. 10 SURFACE IS TO BE SHARP CHAMFERED UNLESS OTHERWISE NOTED
14	5. NO. 10 SURFACE IS TO BE SHARP CHAMFERED UNLESS OTHERWISE NOTED
15	6. NO. 10 SURFACE IS TO BE SHARP CHAMFERED UNLESS OTHERWISE NOTED
16	7. NO. 10 SURFACE IS TO BE SHARP CHAMFERED UNLESS OTHERWISE NOTED
17	8. NO. 10 SURFACE IS TO BE SHARP CHAMFERED UNLESS OTHERWISE NOTED
18	9. NO. 10 SURFACE IS TO BE SHARP CHAMFERED UNLESS OTHERWISE NOTED
19	10. NO. 10 SURFACE IS TO BE SHARP CHAMFERED UNLESS OTHERWISE NOTED
20	11. NO. 10 SURFACE IS TO BE SHARP CHAMFERED UNLESS OTHERWISE NOTED
21	12. NO. 10 SURFACE IS TO BE SHARP CHAMFERED UNLESS OTHERWISE NOTED
22	13. NO. 10 SURFACE IS TO BE SHARP CHAMFERED UNLESS OTHERWISE NOTED
23	14. NO. 10 SURFACE IS TO BE SHARP CHAMFERED UNLESS OTHERWISE NOTED
24	15. NO. 10 SURFACE IS TO BE SHARP CHAMFERED UNLESS OTHERWISE NOTED
25	16. NO. 10 SURFACE IS TO BE SHARP CHAMFERED UNLESS OTHERWISE NOTED
26	17. NO. 10 SURFACE IS TO BE SHARP CHAMFERED UNLESS OTHERWISE NOTED
27	18. NO. 10 SURFACE IS TO BE SHARP CHAMFERED UNLESS OTHERWISE NOTED
28	19. NO. 10 SURFACE IS TO BE SHARP CHAMFERED UNLESS OTHERWISE NOTED
29	20. NO. 10 SURFACE IS TO BE SHARP CHAMFERED UNLESS OTHERWISE NOTED
30	21. NO. 10 SURFACE IS TO BE SHARP CHAMFERED UNLESS OTHERWISE NOTED
31	22. NO. 10 SURFACE IS TO BE SHARP CHAMFERED UNLESS OTHERWISE NOTED
32	23. NO. 10 SURFACE IS TO BE SHARP CHAMFERED UNLESS OTHERWISE NOTED

DRAWING # 544193-02

SCALE 0.250

REV NO

DATE 25-Jul-03

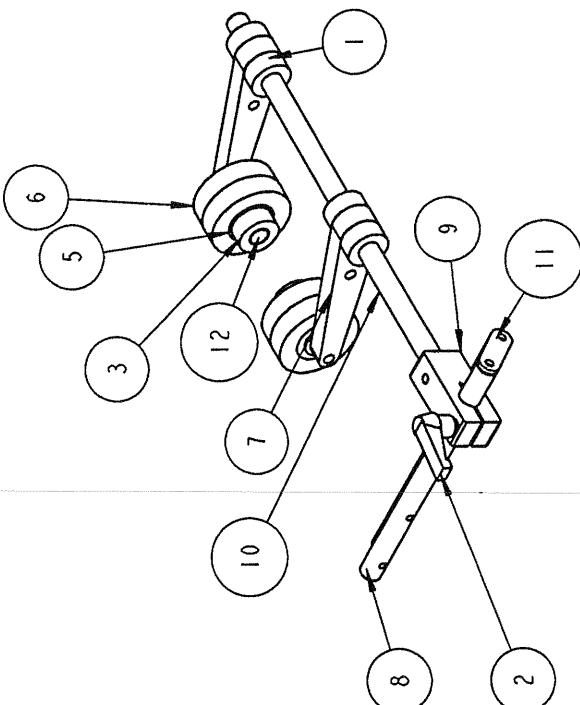
ECN NO

BY

ITEM QTY	PART #	DESCRIPTION
1 2	100135	BUSHING, SL.500ID.625OD.500LG
2 1	102140	HANDLE, RELEASE 1/4-20 X 1.0
3 6	102205	COLLAR .500
4 2	102302	SHIM, .500X.750X.062
5 4	103108	BEARING, FLAT .500
6 2	515288	ROLLER, BELT CROWN IN EXTENSION
7 2	500801-22	LINK, PINCH ROLLER
8 2	544730-01	SHAFT, ROLLER SUPPORT
9 1	544731-01	CLAMP, ROLLER SUPPORT
10 1	544732-01	SHAFT, ROLLER SUPPORT
11 1	544733-01	PLATE, SHAFT SUPPORT
12 2	544734-02	SHAFT, SPACER LINK

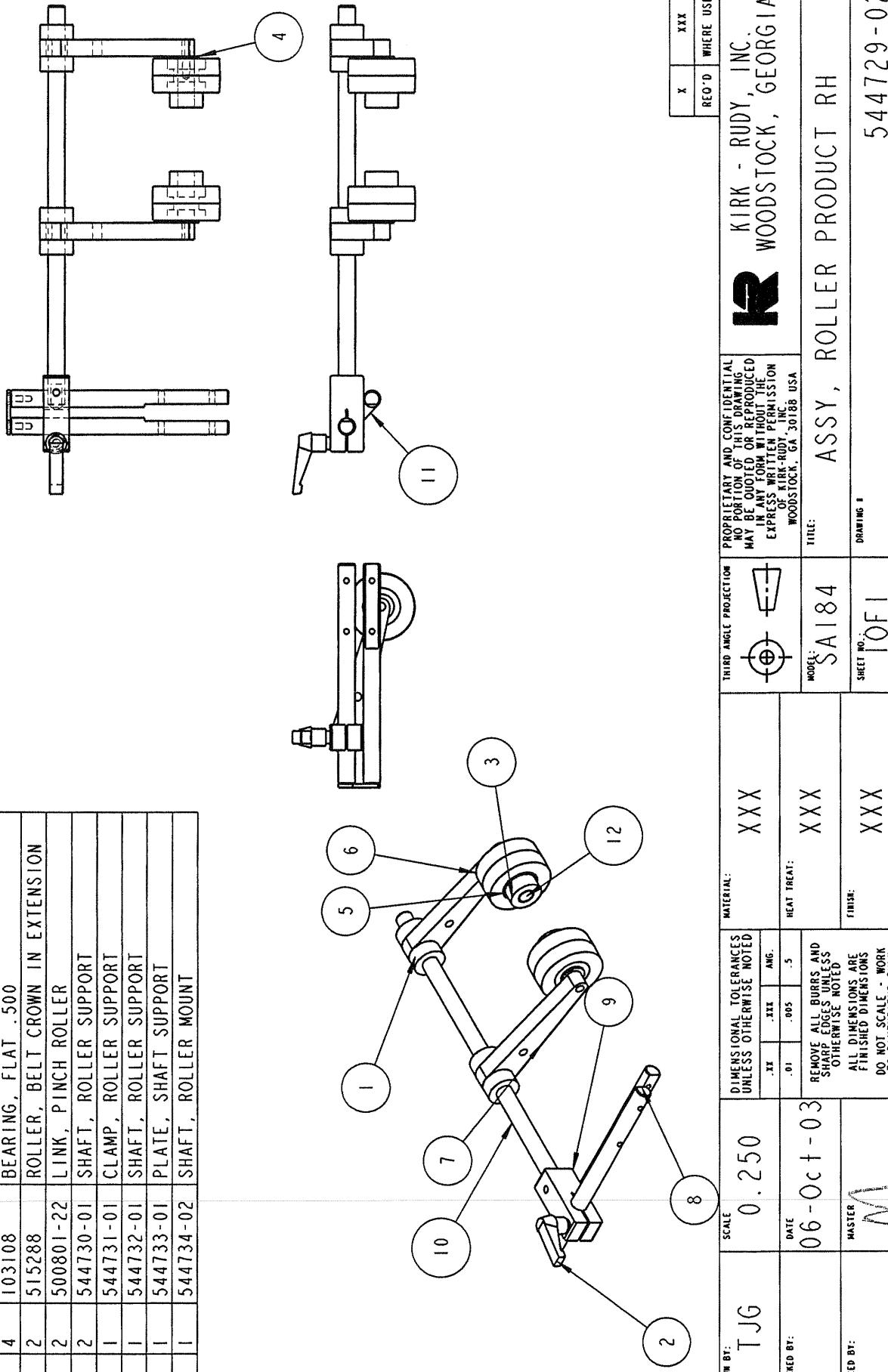
REV NO	DATE	DESCRIPTION	ECN NO	BY
I	3/27/2004	REPLACE 544734-01 WITH 544734-02. ADDED COLLARS	7034	TJG

X	XXX
REQ'D	WHERE USED



DRAWN BY: TJG	SCALE: 0.250	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, GEORGIA		
DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED		.01	.005	.5	DATE: 06-0c1-03
		MM	XXX	ANG.	NOTE: REMOVE ALL BURS AND SHARP EDGES UNLESS OTHERWISE NOTED
					ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY
CHECKED BY:	MASTER	FIRMS:	XXX	SHEET NO.: 1 OF 1	TITLE: SA184 ASSY, ROLLER PRODUCT LH DRAWING #: 544729-01

ITEM QTY	PART #	DESCRIPTION	REV NO	DATE	ECN NO	BY
1 2	100135	BUSHING, SL. 500 ID. 625 OD. 500 LG	1	3/2/2004	REPLACE 544734-01 WITH 544734-02. ADDED COLLARS	TJG
2 1	102140	HANDLE, RELEASE 1/4-20 X 1.0				
3 6	102205	COLLAR .500				
4 2	102302	SHIM .500X.750X.062				
5 4	103108	BEARING, FLAT .500				
6 2	515288	ROLLER, BELT CROWN IN EXTENSION				
7 2	500801-22	LINK, PINCH ROLLER				
8 2	544730-01	SHAFT, ROLLER SUPPORT				
9 1	544731-01	CLAMP, ROLLER SUPPORT				
10 1	544732-01	SHAFT, ROLLER SUPPORT				
11 1	544733-01	PLATE, SHAFT SUPPORT				
12 1	544734-02	SHAFT, ROLLER MOUNT				



DRAWING # 544284-01

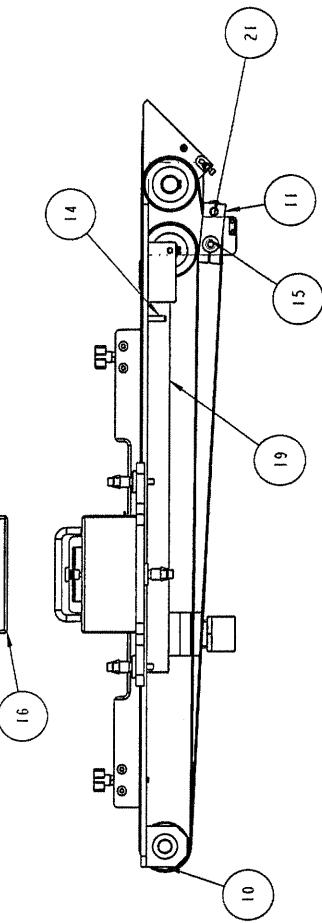
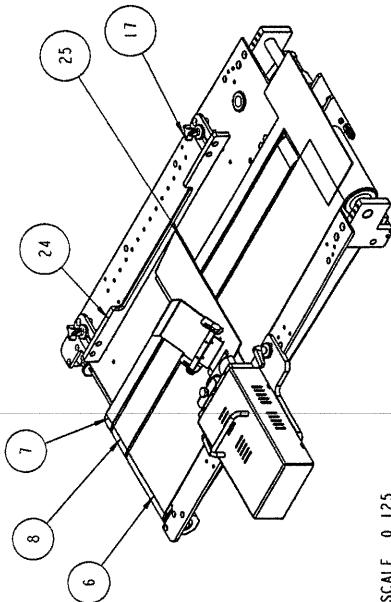
ITEM NO	PART #	DESCRIPTION
1	2	SHIM, .375X.625X.094
2	102305	SHIM, .375X.625X.031
3	4	BEARING, FLAT .375
4	2	BEARING, HUB .625
5	1	SPIKET, 35B12 .625B .188K
6	1	BELT, FLAT 6 X 68 .75
7	1	BELT, FLAT 1 X 68 .75*
8	1	BELT, FLAT 2.25 X 62.00
9	1	GROMMET, RUBBER .75DX1 .375DX.56TH
10	2	BLOCK, BEARING 500819-2
11	2	TAKUP, CLAMP BELT 504949-3
12	2	ROLLER, TRANSFER 501292-8
13	1	ASSY, VACUUM MANIFOLD 530656-01
14	2	BLOCK, ADJUSTMENT ROLLER 536770-02
15	2	STUD, ROLLER IDLER 538970-01
16	1	ASSY, LINEAR GUIDE BRACKET 544201-01
17	1	TABLETOP, VACUUM CENTER 544285-01
18	1	ASSY, IDLER SHAFT LH 544287-01
19	1	BLOCK, VACUUM 4" WIDE 544294-01
20	1	ASSY, IDLER CONVEYOR BELT 544295-01
21	1	SHAFT, ROLLER IDLER 544298-01
22	1	ASSY, ROLLER DRIVER CROWNED 544451-01
23	1	SHAFT, FRONT ROLLER 544456-01
24	1	ASSY, SIDEGUIDE SHINGLE SECTION 544498-01
25	3	ENVELOPE, PIPINGTOPE, NO. 10

ITEM NO	REV NO	DATE	ECN NO	BT
1	1	3/31/2004	REPLACE 536770-01 WITH 536770-02	1034 T-6

I	KR3454
REV'D WHERE USED	
KRK - RUDY, INC.	
WOODSTOCK, GEORGIA	
DRAFTING NO. SA184 DATE 25-JUL-03	
SHEET NO. 1 OF 1	

SCALE 0.125

PROPRIETARY AND CONFIDENTIAL		THIRD PARTY PROTECTION	
ALL INFORMATION CONTAINED		HEREIN IS UNPUBLISHED	
IN THIS DRAWING IS THE PROPERTY	OF KR-RUDY INC.	OF THE UNITED STATES GOVERNMENT	OF K.R. RUDY INC.
AND IS PROTECTED BY	WOODSTOCK, GA 30188 USA	BY LAW. IT MAY NOT BE REPRODUCED,	WOODSTOCK, GA 30188 USA



PRINTED 3/1/2004

544284-02

ITEM #	PART #	DESCRIPTION	REV NO	DATE	ECN NO	B1
1	2	SHIM, .375X.625X.094				
2	2	SHIM, .375X.625X.031				
3	4	BEARING, FLAT .375				
4	2	BEARING, HUB .625				
5	1	SPARK, 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 .75IDX.375ODX.561H				
10	2	BLOCK, BEARING .50819-2				
11	2	TAKEUP, CLAMP BELT				
12	2	ROLLER, TRANSFER				
13	1	ASSY, VACUUM MANIFOLD				
14	2	BLOCK, ADJUSTMENT ROLLER				
15	2	SLID. IDLER IDLER				
16	1	ASSY, LINEAR GUIDE BRACKET				
17	1	TABLETOP, VACUUM CENTER				
18	1	ASSY, IDLER SHAFT RH				
19	1	544294-01 BLOCK, VACUUM 4" WIDE				
20	1	544295-01 ASSY, IDLER CONVEYOR BELT				
21	1	544298-01 SHAFT, ROLLER IDLER				
22	1	544451-01 ASSY, ROLLER DRIVER CROWDED				
23	1	SHAFT, FRONT ROLLER				
24	1	544498-01 ASSY, SIDEGUIDE SHINGLE SECTION				
25	3	ENVELOPE, P. DOWCOLOPE, NO. 10				

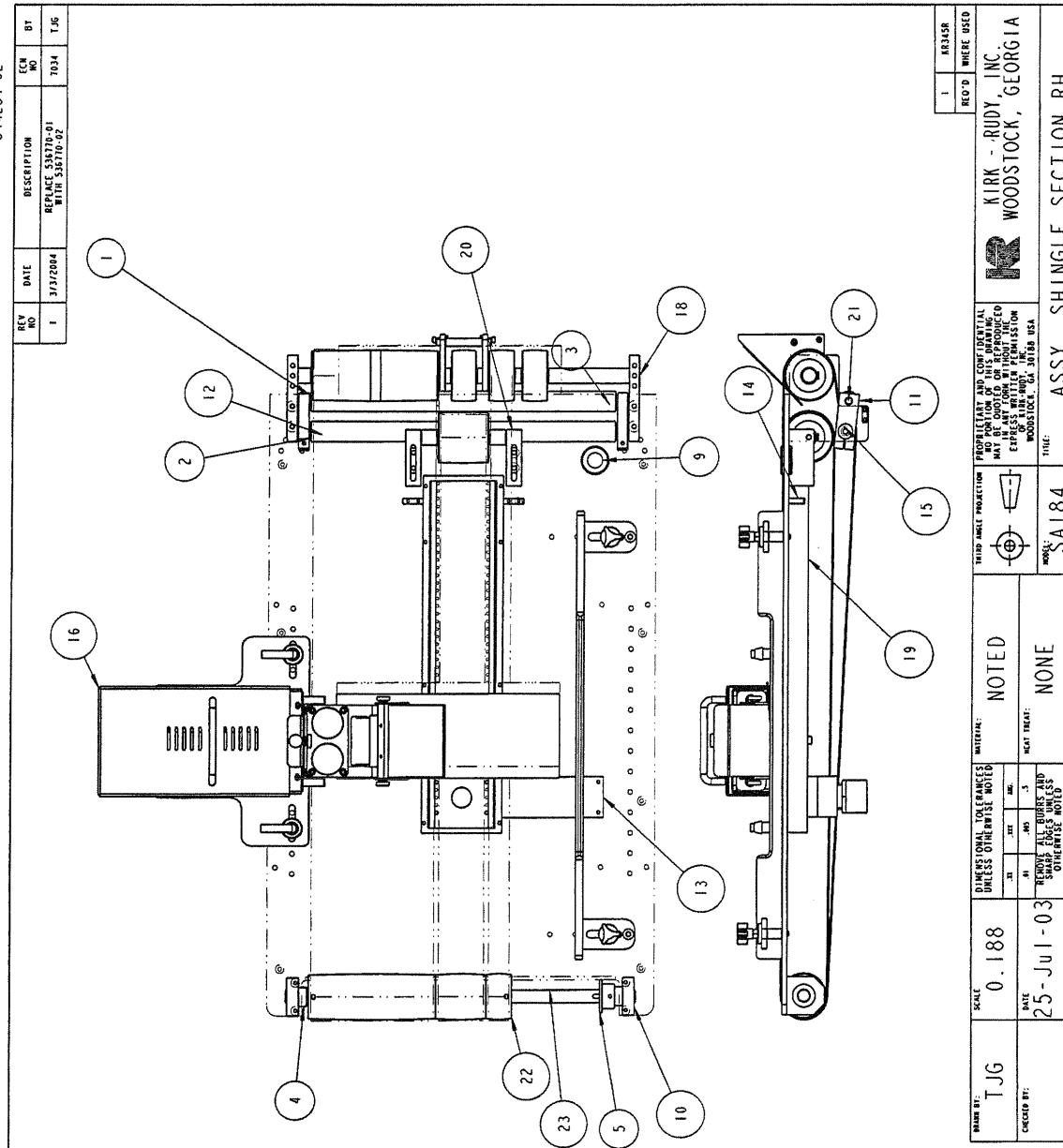
PLATE #:	JIG	SCALE	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	MATERIAL:	NOTED	THINWALLED PRODUCTION PARTS ONLY	PRODUCTION AND CONFIDENTIAL PARTS ONLY
CHECKED #:			"	"	"	"	"
TRACK #:			"	"	"	"	"
SCALE:	0.125	0 .188	.000	.000	.000	.000	.000

25 - JUL - 03

REMOVED ALL THICKNESS UNLESS
OTHERWISE NOTED

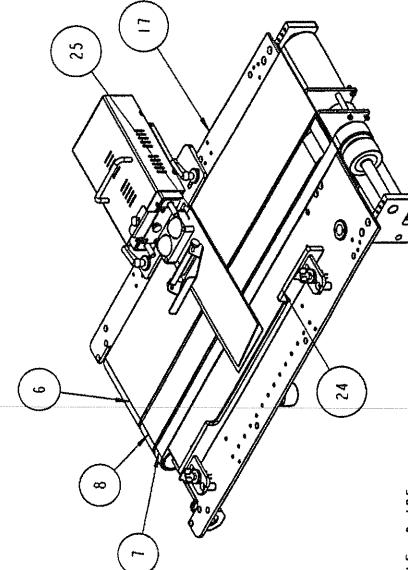
ALL DIMENSIONS ARE
IN INCHES UNLESS
NOTED

NO. 10F1



544284-02

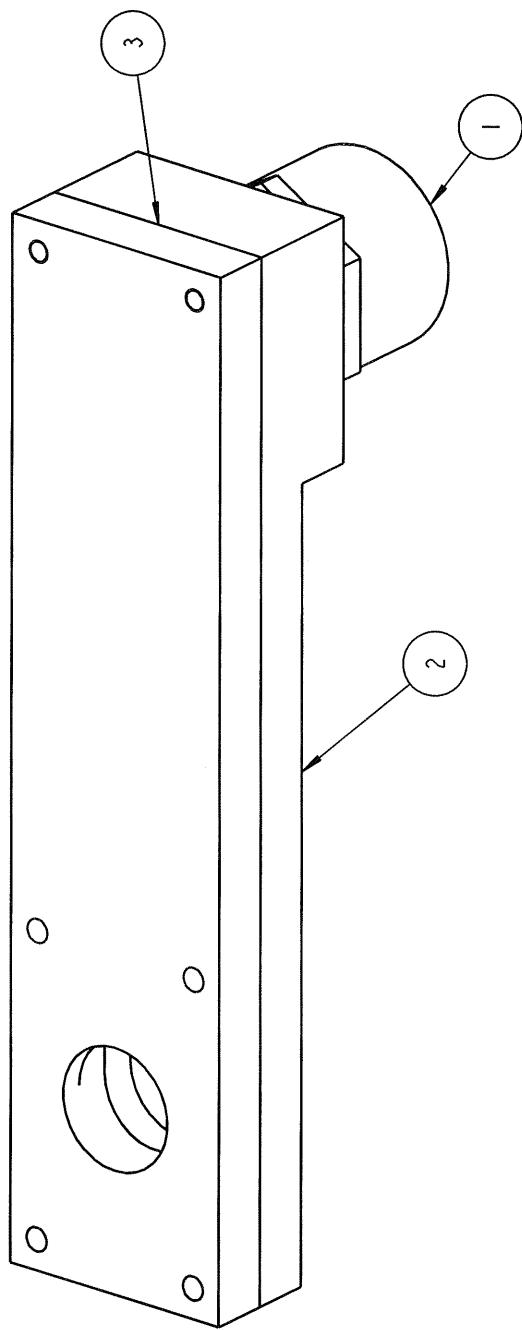
1	AR445R	RED WHERE USED
KIRK - RUDY, INC.	KR	KIRK - RUDY, INC.
WOODSTOCK, GEORGIA		
TIME:		ASSY, SHINGLE SECTION RH



ITEM QTY	PART #	DESCRIPTION
1	190715	PVC COUPLING
2	SP28217-1	BLOCK, LOWER VACUUM
3	SP28218-1	BLOCK, UPPER VACUUM

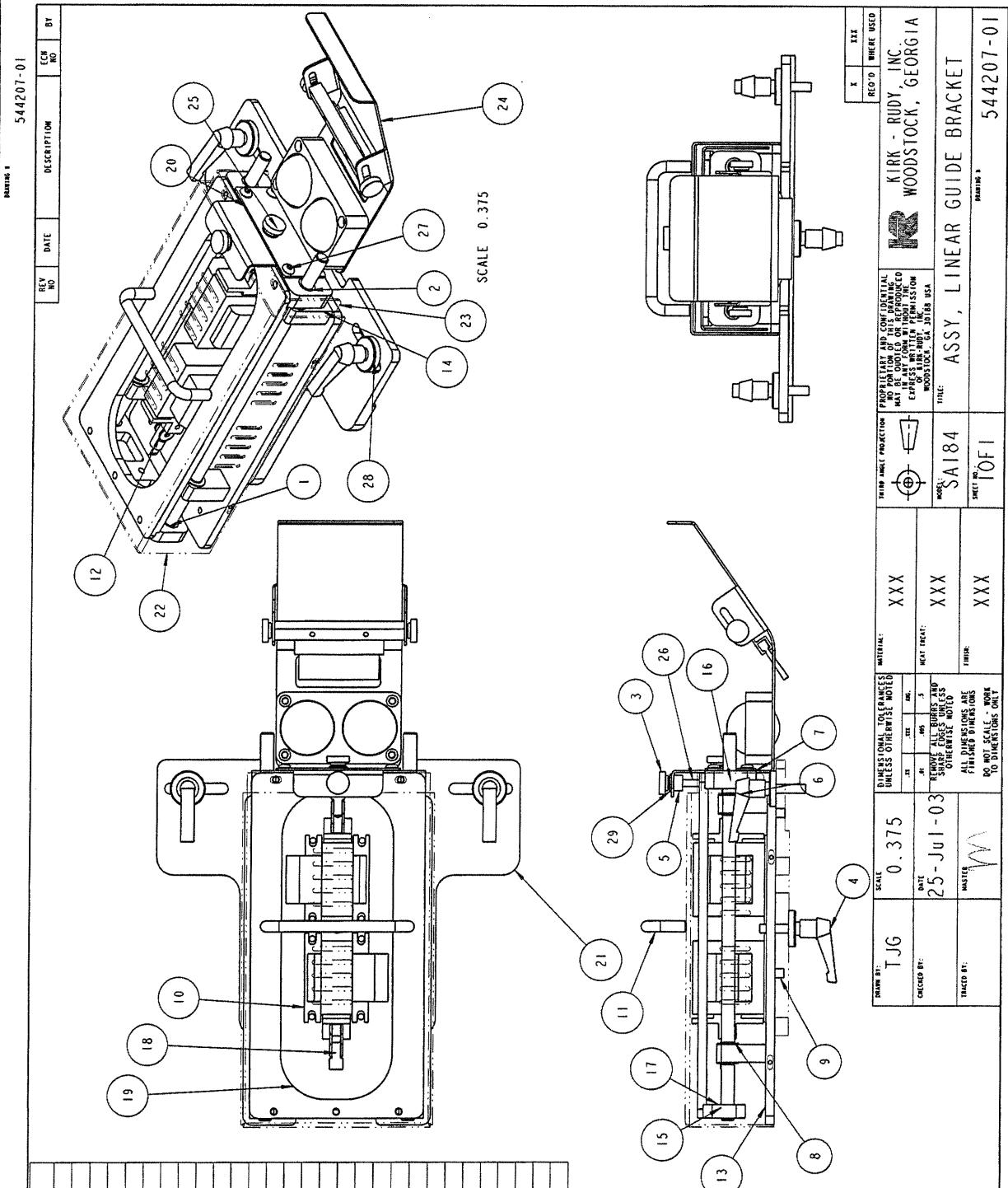
REV NO	DATE	DESCRIPTION	ECN NO	BY

X	ALL
RECD	WHERE USED



SCALE		DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED		MATERIAL:	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, GEORGIA
RHM	0.750	.XX	.XXX	ANG.			KR KIRK - RUDY, INC. WOODSTOCK, GEORGIA
CHECKED BY:	DATE	.01	.005	.5	HEAT TREAT:	NONE	
TRACED BY:	28-JUL-98	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED			FINISH:	NONE	
MASTER		ALL DIMENSIONS ARE FINISHED DIMENSIONS			DO NOT SCALE: WORK TO DIMENSIONS ONLY		
					SHEET NO.	OF	
							DRAWING #
							530656-01

ITEM QTY	PART #	DESCRIPTION
1	2 100101	BUSHING, SL .375ID .500OD .375LG
2	2 100129	BUSHING, SL .375ID .500OD .500LG
3	2 102132	KNOB, 10-32 CAP SCREW
4	3 102140	HANDLE RELEASE 1/4-20 X 1.0
5	1 102210	COLLAR .188
6	8 102306	SHIM, .375X .625X .031
7	4 102575	SHIM, .250X .500X .010
8	8 104100	SPRING, .315
9	2 105415	DOWEL, PIN .250X .500
10	2 190003	SOLENOID, 120VAC
11	1 190955	HANDLE
12	4 40CHAINPLATE, #40 CHAIN LINK	
13	1 544208-01	PLATE, LINEAR ACTUATOR
14	4 544209-01	BAR, LINEAR SHAFT MOUNT
15	2 544210-01	SHAFT, LINEAR GUIDE
16	1 544211-01	BAR, LINEAR GUIDE
17	1 544211-02	BAR, LINEAR GUIDE
18	2 544213-01	SHAFT, SOLENOID CONNECTOR
19	1 544214-01	PLATE, SOLENOID SLIDE
20	1 544217-01	PLATE, BRACKET RETAINER
21	1 544220-01	BRACKET, LINEAR ACTUATOR
22	1 544221-01	COVER, SOLENOID
23	1 544283-01	COVER, LINEAR SHAFT
24	1 544156-01	ASST, PRODUCT STOP
25	1 CSD264	SCREW, SHCS .10-.32X .375
26	1 CSD0270	SCREW, SHCS .10-.32X .250
27	4 CSIF57	SCREW, BUTTON HEAD #10-.32X .375
28	3 SP6383-1	SPACER, GEAR COVER
29	2 WAD006	WASHER, FLAT #10

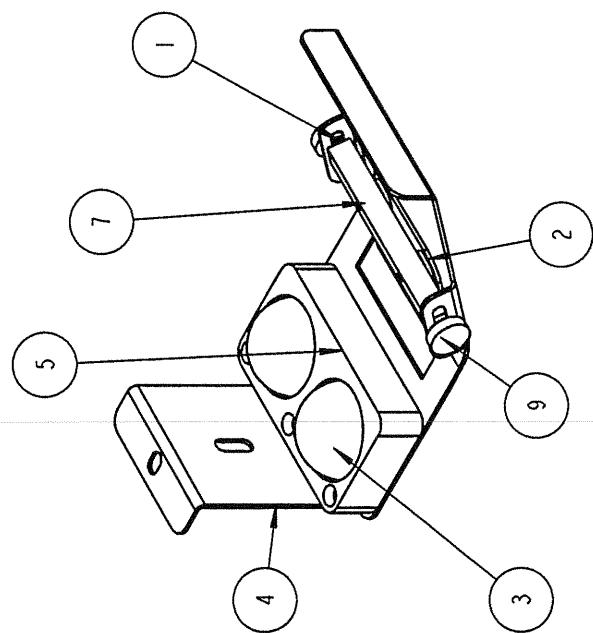
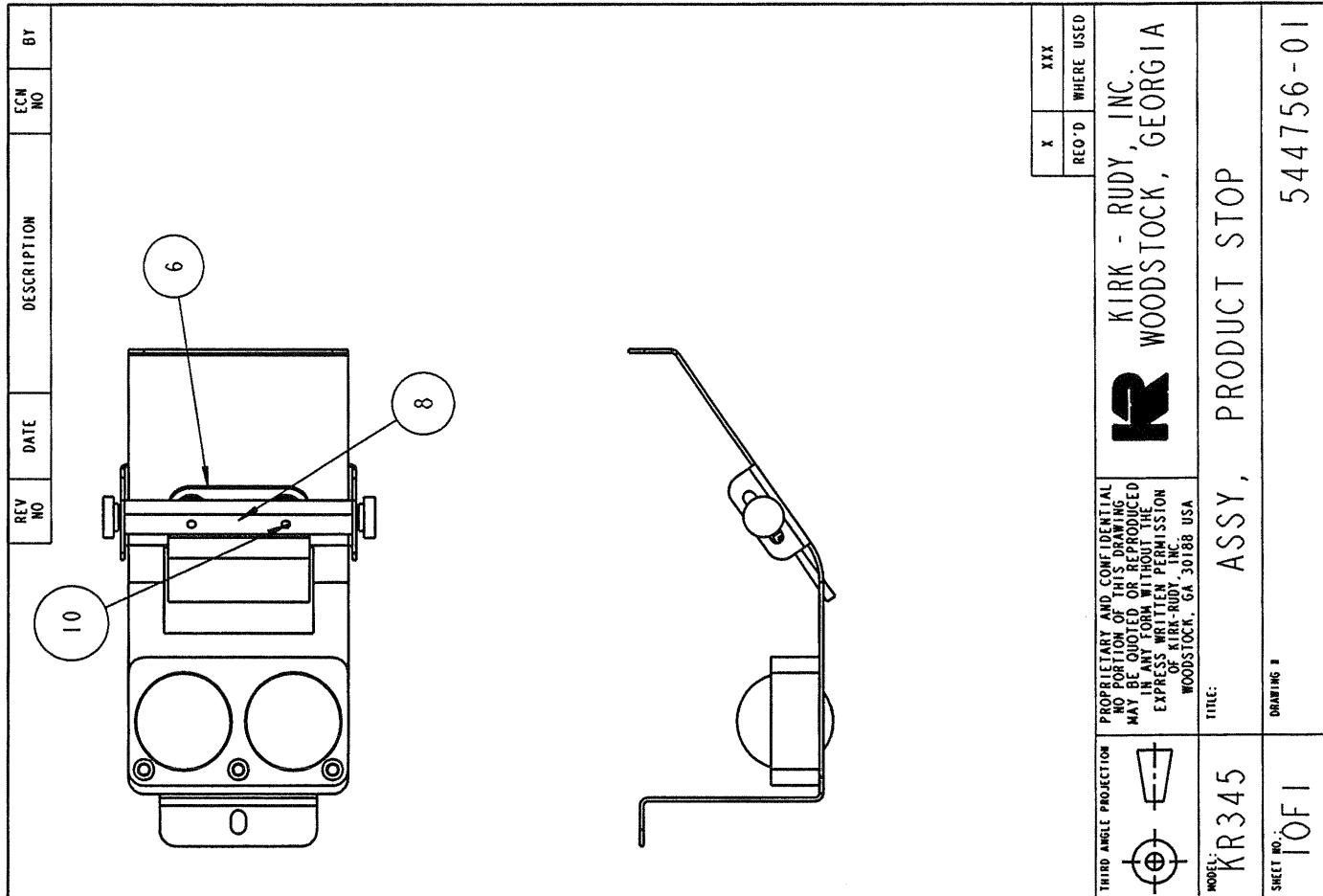


DRAWING BY:		SCALE	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED		MATERIAL:	THREE ANGLE PROJECTION		PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MADE OR REPRODUCED EXCEPT AS SPECIFIED IN THE CONTRACT EXCEPT AS WRITTEN PERMISSION WOODSTOCK, GEORGIA JULY 25, 1984			
MASTER		0 .375	.005	.005	XXX	1	2	3	4	5	6
TRACED BY:		DATE	25-JUL-03	REMOVED	XXX	REMOVED	REMOVED	REMOVED	REMOVED	REMOVED	REMOVED

ASSY, LINEAR GUIDE BRACKET

544207-01

ITEM QTY	PART #	DESCRIPTION
1 2	102132	KNOB, 10-32 CAP SCREW
2 2	102562	SHIM, .25X.500X.062
3 2	191175	STEEL BALL, 1.5" DIAMETER
4 1	544215-03	BRACKET, BALL MOUNT
5 1	544218-01	BLOCK, BALL RETAINER
6 1	544754-01	BRUSH, MOUNT PRODUCT STOP
7 1	544755-01	BRUSH, PRODUCT STOP
8 1	544757-01	BAR, BRUSH ADJUSTMENT
9 2	CSDD264	SCREW, SHCS 10-32X.375
10 2	CSEE227	SCREW, FLATHEAD 8-32X.500



DRAWN BY:	SCALE	0 .375	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	.17 - 0 ^c + - 0 .3	.01 .005 .5 ANG.	HEAT TREAT: XXX	MODEL: KR 345	TITLE: ASSY, PRODUCT STOP
TRACED BY:	MASTER		REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED ALL DIMENSIONS ARE IN INCHES DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY	FINISH: XXX	SHEET NO: 10F1	DRAWING #: 544756-01

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	544291-01 GUIDE, PRODUCT WEDGE					
10	1	544292-01 SHAFT, SPACER WEDGE					
11	2	CSDD239 SCREW, SHCS 8-32X .625					
12	2	CSDD265 SCREW, SHCS 10-32X .500					
13	2	HMSN09 NUT, HEX # 8-32					

X XXX
REQ'D WHERE USED

THIRD ANGLE PROJECTION

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

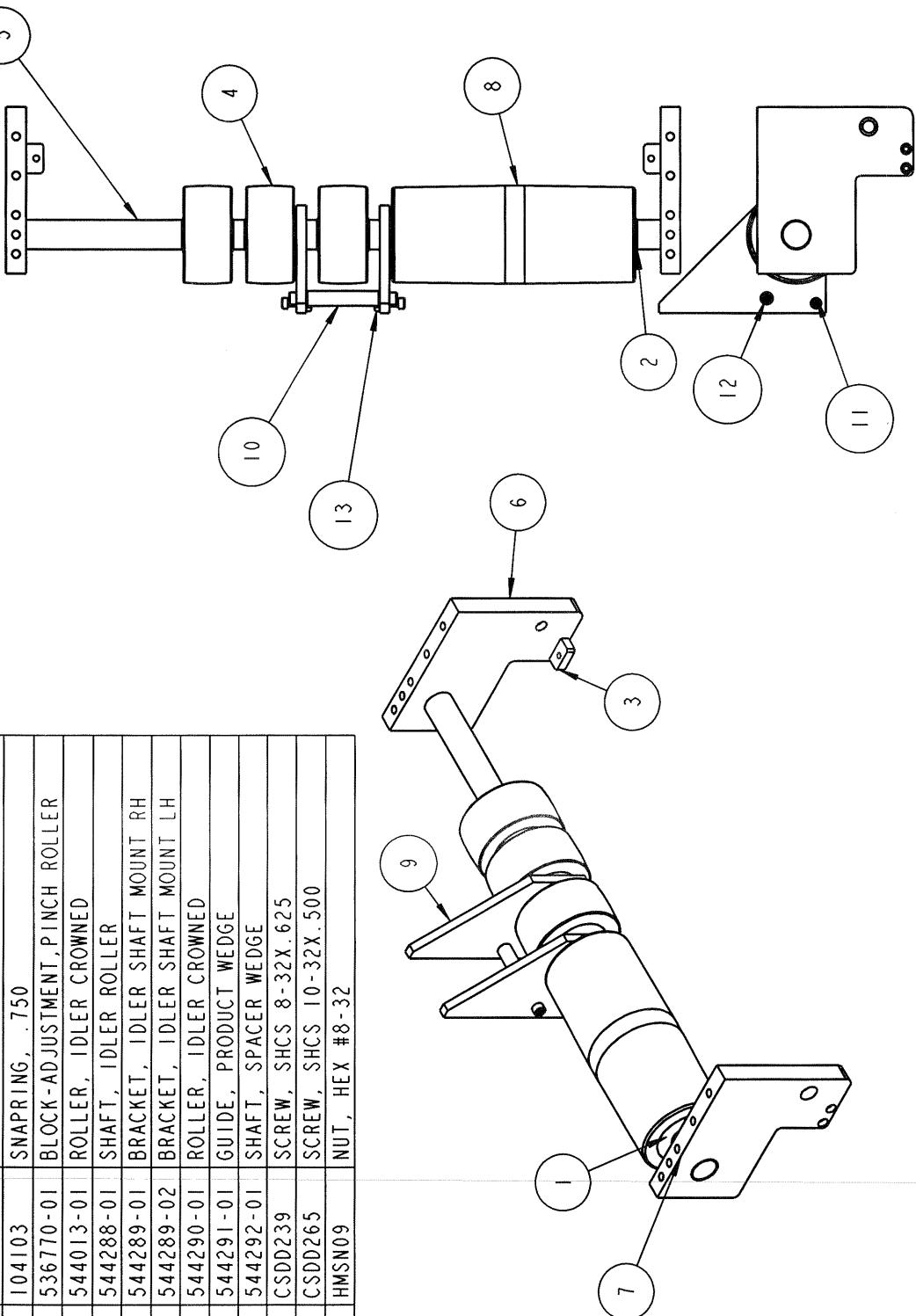
KIRK - RUDY, INC.
WOODSTOCK, GEORGIA

DRAWN BY:	SCALE	0 .250	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED		MATERIAL: XXX	MODEL: SA184	
			.XX	.XXX	ANG.	HEAT TREAT:	
CHECKED BY:	DATE	25-JUL-03	.01	.005	.5	XXXX	TITLE: ASSY, IDLER SHAFT LH
TRACED BY:	MASTER		REMOVE ALL BURS AND SHARP EDGES UNLESS OTHERWISE NOTED				SHEET NO.: 0F1
			ALL DIMENSIONS ARE FINISHED DIMENSIONS				DRAWING #: 544287-01
			DO NOT SCALE - WORK TO DIMENSIONS ONLY				

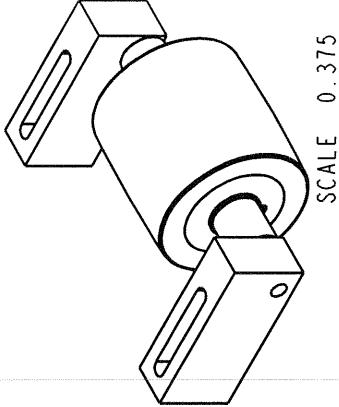
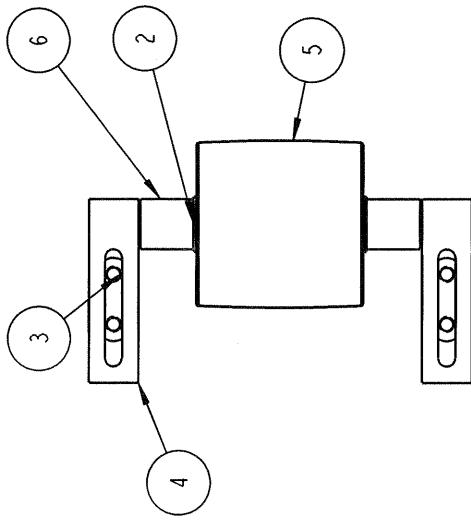
DRAWING 1

544287-02

ITEM QTY	PART #	DESCRIPTION
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	544291-01 GUIDE, PRODUCT WEDGE
10	1	544292-01 SHAFT, SPACER WEDGE
11	2	CSDD239 SCREW, SHCS 8-32X .625
12	2	CSDD265 SCREW, SHCS 10-32X .500
13	2	HMSN09 NUT, HEX #8-32



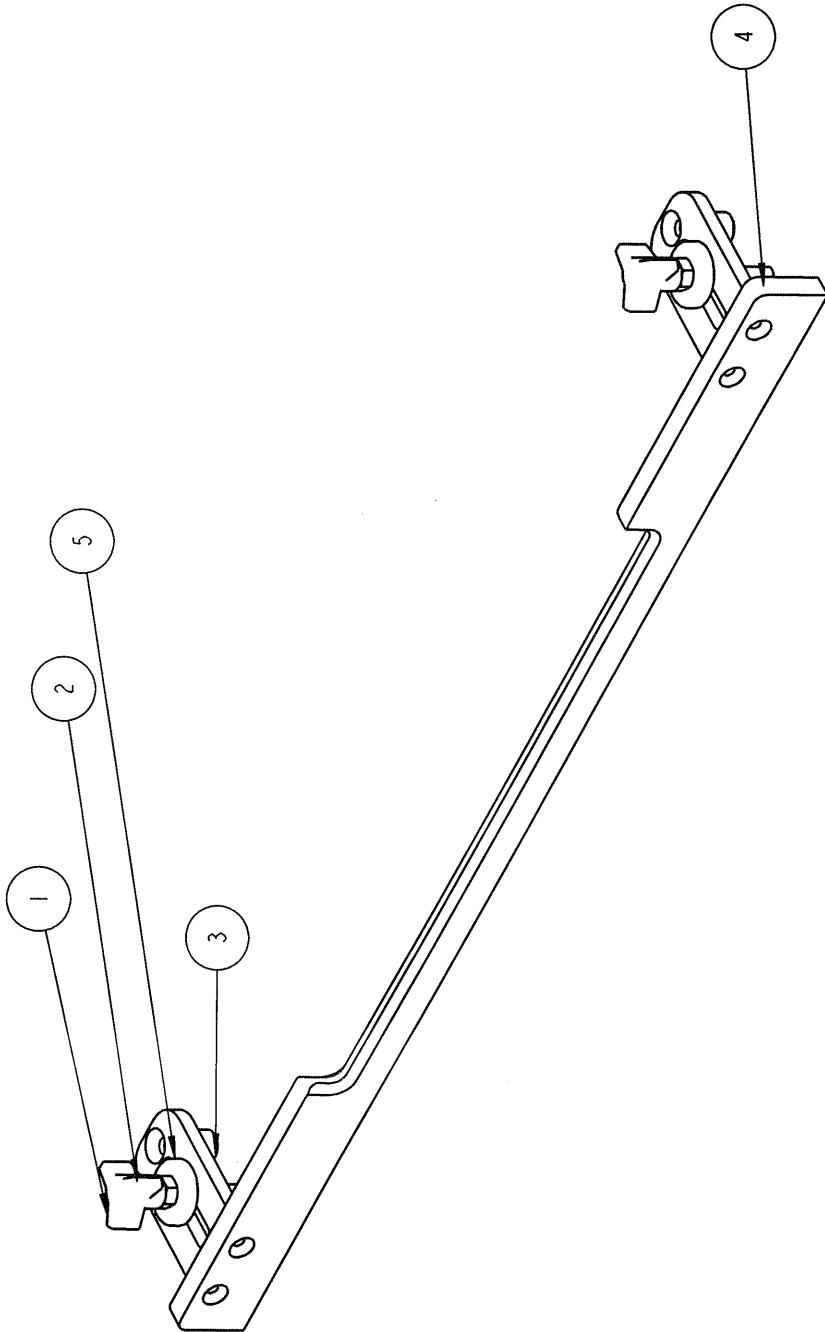
ITEM	QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	2	103112	BEARING, FLAT .750					
2	2	104103	SNAPRING, .750					
3	2	542147-02	BAR, THREADED BELT TAKEUP					
4	2	544041-01	BRACKET, IDLER SHAFT MOUNT					
5	1	544296-01	ROLLER, IDLER CROWNED					
6	1	544297-01	SHAFT, IDLER ROLLER					



ITEM	QTY	PART #	DESCRIPTION
1	2	103112	BEARING, FLAT .750
2	2	104103	SNAPRING, .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

DRAWN BY:	T JG	SCALE	0 . 375	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	MATERIAL: 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, GEORGIA	KR345
CHECKED BY:		DATE	28 - Jul 1 - 03	.xx .xxx ANG.	HEAT TREAT: NONE		KR	ASSY , IDLER CONVEYOR BELT
TRACED BY:		MASTER		.01 .005 .5	FINISH: REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED		SAI 84	544295-01
					ALL DIMENSIONS ARE FINISHED. DO NOT SCALE - WORK TO DIMENSIONS ONLY			544295-01

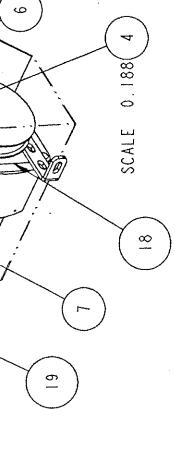
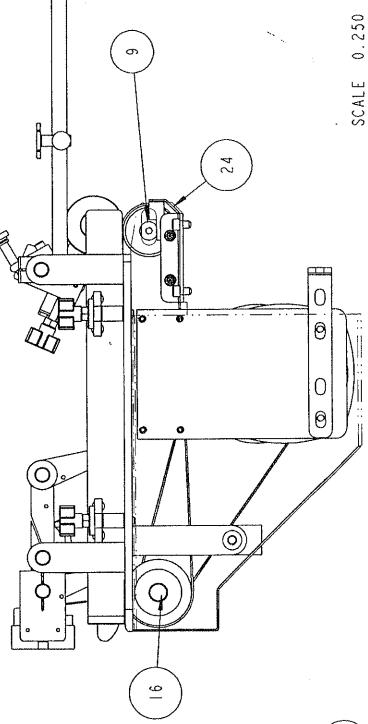
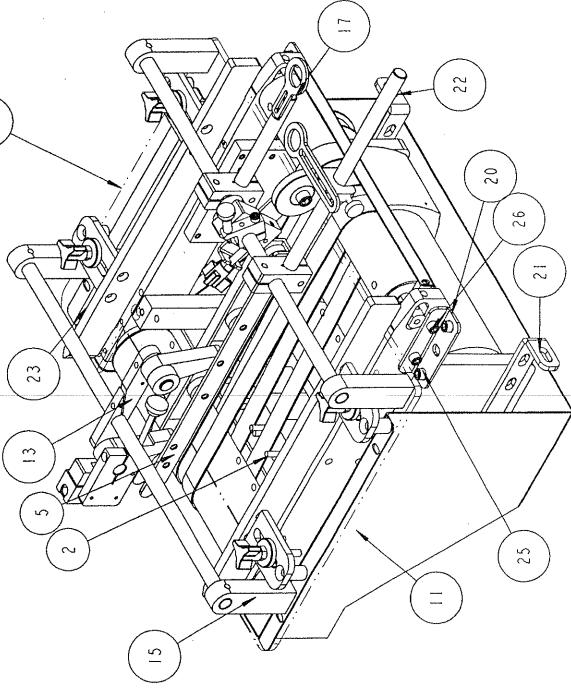
ITEM QTY	PART #	DESCRIPTION
1	2	500790-1 ASSY, TRI-KNOB 1/4-20 STUD
2	2	541709-01 BRACKET, SIDEGUIDE
3	2	541710-01 SPACER, SIDEGUIDE MOUNT
4	1	544499-01 SIDEGUIDE, INFEED KR345
5	2	SP6383-1 SPACER, GEAR COVER



DRAWN BY:	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, GEORGIA
CHECKED BY:	DATE	.XX .XXX ANG.	N / A	-	KR345
TRACED BY:	29-JUL-03	.01 .005 .5	HEAT TREAT:	N / A	REMOVED ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED
MASTER			FINISH:	N / A	ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY
			SHEET NO.:	O/F	DRAWING #
					ASSY, SIDEGUIDE SHINGLE SECTION
					544498-01

ITEM / PART #	DESCRIPTION	REV NO.	DATE	DESCRIPTION	ECN NO.	BY
1 4	103504 BEARING, HUB .625					
2 6	105419 DOWEL, PIN 1.88X1.000					
3 1	108888 PULLY, TIMING 12L050 625B .188K					
4 1	109963 PULLEY, TIMING 36L050 .750B .188K					
5 3	105308-16 BELT, FLAT 3/4 X 30 75"					
6 1	108337-3 BELT, TIMING 255L050					
7 1	200169-2 MOTOR, BODINE 4180					
8 3	500125-3 GUIDE, BELT 3/4					
9 1	500923-15 SHAFT, IDLER ROLLER					
10 1	500924-13 SHAFT-BELT GUIDE					
11 2	532163-01 STAND, BELT GUIDE					
12 2	533369-02 BLOCK, DEFLECTOR MOUNT					
13 1	538434-03 ASSY, DRIVE ROLLER					
14 1	544320-01 TABLETOP, INFEED					
15 2	544458-01 FRAME, INFEED SECTION					
16 1	544471-01 SHAFT, ROLLER DRIVE					
17 1	544475-01 ROLLER, IDLER INFEED					
18 1	544476-01 PLATE, MOTOR MOUNT LH					
19 1	544476-02 PLATE, MOTOR MOUNT RH					
20 2	544477-01 BRACKET, L CONVEYOR MOUNT					
21 1	544478-01 WLDNN, INFEED SECTION COVER					
22 2	544479-01 BRACKET, L CONVEYOR MOUNT					
23 1	544482-01 ASSY, SIDEGUIDE INFEED					
24 1	544501-01 COVER, ROLLER GUARD					
25 4	CSDD291 SCREW, SHCS 1/4-20X .375					
26 4	CS00293 SCREW, SHCS 1/4-20X .625					
27 4	CSDD296 SCREW, SHCS 1/4-20X 1.000					

ITEM / PART #	DESCRIPTION	SCALE	DATE	NOTES	MATERIAL	THIRD ANGLE PROJECTION
1 T JG	0.250	25 - JU 1 - 03	III	REMOVED ALL BURRS AND OTHERWISE NOTED	None	KIRK - RUDY, INC. WOODSTOCK, GEORGIA
2			III			
3			III			

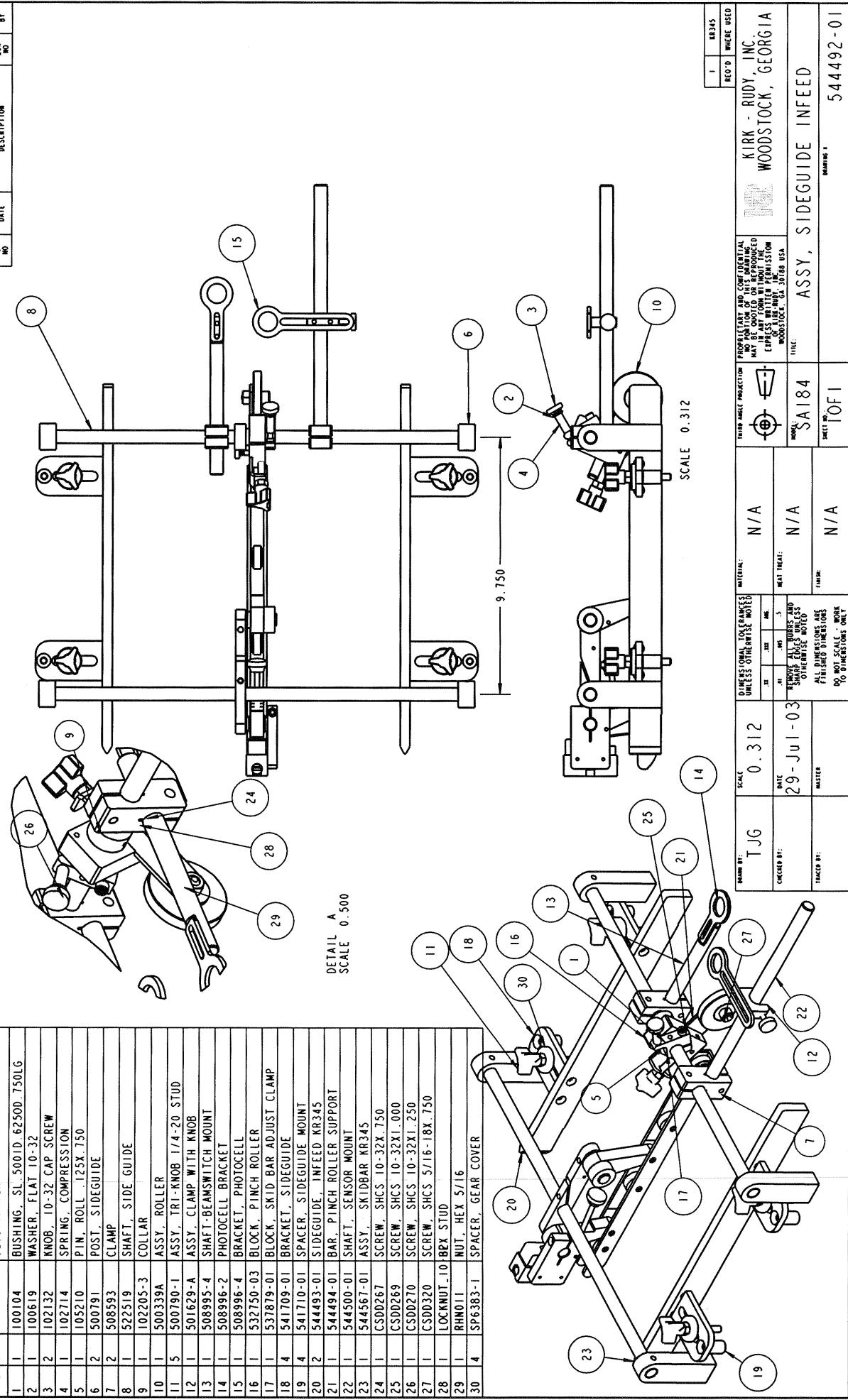


1	KR345	REO'D WHERE USED
2	KR	KIRK - RUDY, INC. WOODSTOCK, GEORGIA
3	SA 184	ASSY, INFEED SECTION
4	OF 2	SCALE 0.250
5		SCALE 0.188 4
6		SCALE 0.188
7		
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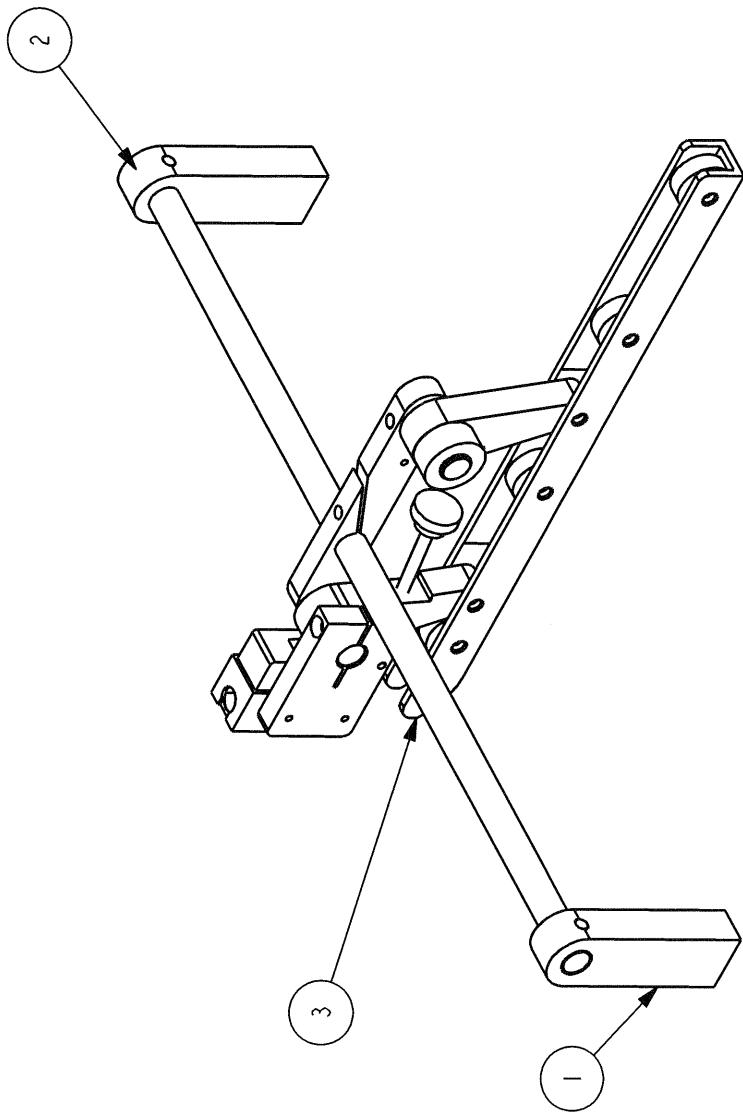
Drawing 1

544492-01

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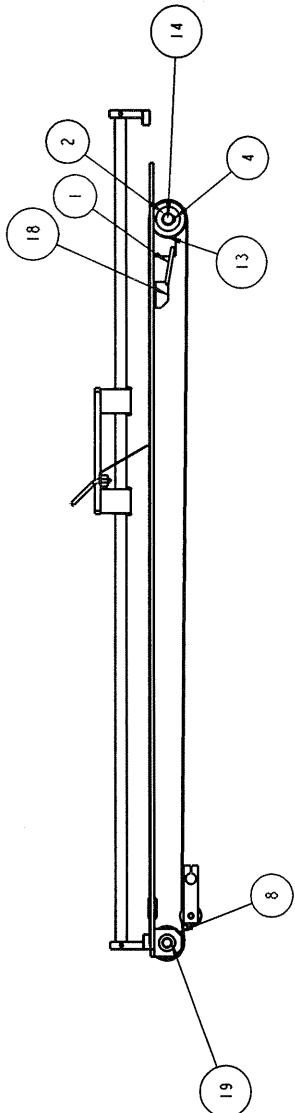
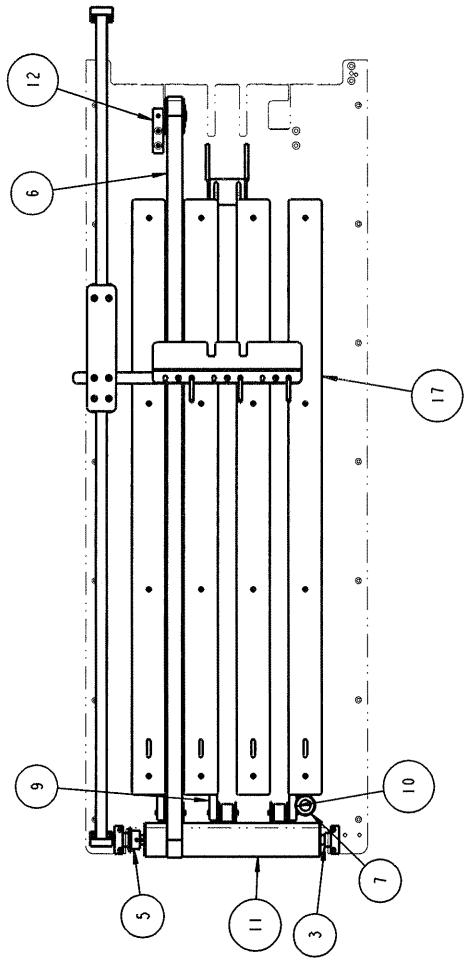
ITEM QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	2	500791 POST, SIDE GUIDE					
2	1	522519 SHAFT, SIDE GUIDE					
3	1	538021-02 ASSY, SKID BAR					



DRAWN BY:	T JG	SCALE	0 . 375	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	2 - Sep - 03	.xx .xxx ANG.	HEAT TREAT:	N / A	MODEL:	KR WOODSTOCK, GEORGIA
TRACED BY:	MASTER	DATE		.01 .005 .5	FINISHES:	N / A	TITLE:	ASSY, SKIDBAR KR 345
				REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED			SHEET NO:	DRAWING #
				ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY			OF 1	544567-01

ITEM QTY	PART #	DESCRIPTION
1	2	SPRING, EXTENSION
2	102627	BEARING, FLAT .750
2	103112	BEARING, FLAT .750
3	2	BEARING, HUB .625
4	2	SNAPRING, .750
5	1	SPRK. 35812 .625B .188K
6	1	BELT, FLAT 1 X 104 .75
7	1	GROMMET, RUBBER .75IDX1.375ODX .56TH
8	2	BLOCK, BEARING
9	2	500819-2 ASSY, TAKEUP 1 IN BELT
10	1	530610-01 ASSY, TAKEUP 1 IN BELT
11	1	530616-01 ASSY, ROLLER FRONT DRIVE
12	1	533975-03 BRACKET, IDLER SHAFT MOUNT
13	1	544013-01 ROLLER, IDLER CROWNED
14	1	544051-01 SHAFT, IDLER ROLLER
15	1	544455-01 TABLETOP, OUTFEED CENTER
16	1	544459-01 ASSY, BACKSTOP LH
17	4	544467-01 GUIDE, BELT TABLETOP
18	1	544490-01 BRACKET, SPRING MOUNT
19	1	544497-01 SHAFT, FRONT ROLLER

REV NO	DATE	DESCRIPTION	ECN NO	BT



DRAWING #:		SCALE:		DIMENSIONAL TOLERANCES: UNLESS OTHERWISE NOTED		NOTED		TECH. AND CONFIDENTIAL INFORMATION:		PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING OR INFORMATION CONTAINED HEREIN MAY BE COPIED, REPRODUCED, TRANSMITTED, EXPRESSED, WRITTEN, COMMUNICATED WHOLE OR IN PART, IN ANY FORM, BY WHOMSOEVER IT MAY BE RECEIVED.	
NAME #: T JG	DATE: 28-JUL-03	IN	MM	.005	.005	MEAT TREAT:	NONE	EX-1	EX-2	EX-3	EX-4
CHECKED BY:	MASTER					REMOVED ALL SPURS AND SHARP EDGES UNLESS OTHERWISE NOTED					

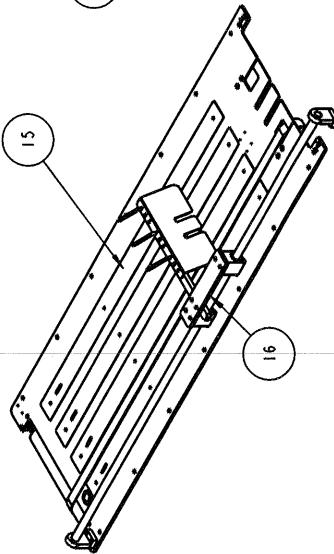
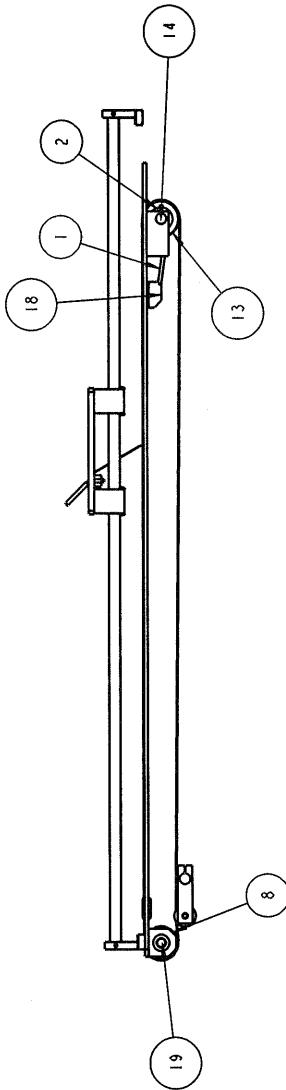
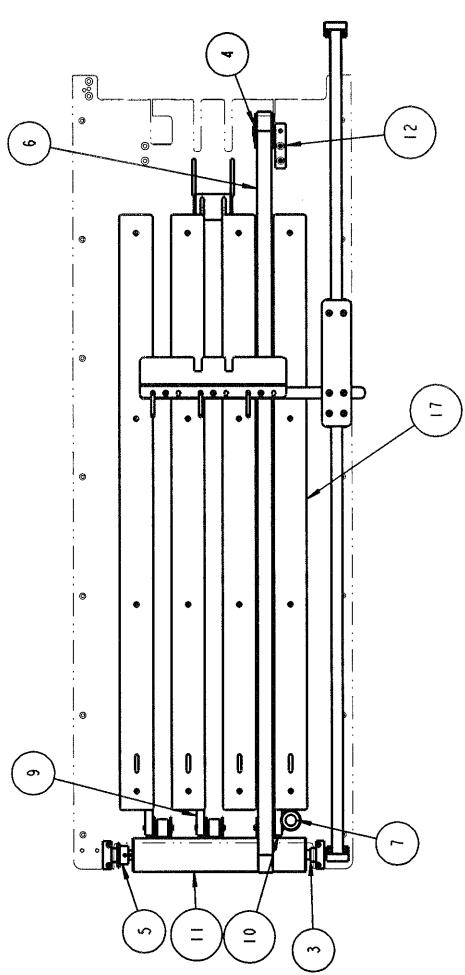
DRAWING #:		SCALE:		DIMENSIONAL TOLERANCES: UNLESS OTHERWISE NOTED		NOTED		TECH. AND CONFIDENTIAL INFORMATION:		PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING OR INFORMATION CONTAINED HEREIN MAY BE COPIED, REPRODUCED, TRANSMITTED, EXPRESSED, WRITTEN, COMMUNICATED WHOLE OR IN PART, IN ANY FORM, BY WHOMSOEVER IT MAY BE RECEIVED.	
NAME #: SAI 184	DATE: 28-JUL-03	IN	MM	.005	.005	MEAT TREAT:	NONE	EX-1	EX-2	EX-3	EX-4
CHECKED BY:	MASTER					REMOVED ALL SPURS AND SHARP EDGES UNLESS OTHERWISE NOTED					

SCALE 0.090

DRAWING # 544454-01

REF NO.	DATE	DESCRIPTION	ECN NO.	BY
---------	------	-------------	---------	----

ITEM NO.	PART #	DESCRIPTION
1	2	SPRING, EXTENSION
2	102627	BEARING, FLAT .750
2	103112	BEARING, FLAT .750
3	2	BEARING, HUB .625
4	2	SNAPRING, .750
4	2	104103
5	1	SPRKIT, 33812 .625B .188K
6	1	111842-3 BELT, FLAT 1 X 104.75
7	1	200513-5 GROMMET, RUBBER .75IDX.375ODX.565H
8	2	500819-2 BLOCK, BEARING
9	2	530610-01 ASSY, TAKEUP 1 IN BELT
10	1	530610-02 ASSY, TAKEUP 1 IN BELT
11	1	530616-01 ASSY, ROLLER FRONT DRIVE
12	1	533975-03 BRACKET, IDLER SHAFT MOUNT
13	1	544013-01 ROLLER, IDLER CROWNED
14	1	544051-01 SHAFT, IDLER ROLLER
15	1	544455-01 TABLETOP, OUTFEED CENTER
16	1	544459-02 ASSY, BACKSTOP RH
17	4	544467-01 GUIDE, BELT TABLETOP
18	1	544490-01 BRACKET, SPRING MOUNT
19	1	544497-01 SHAFT, FRONT ROLLER

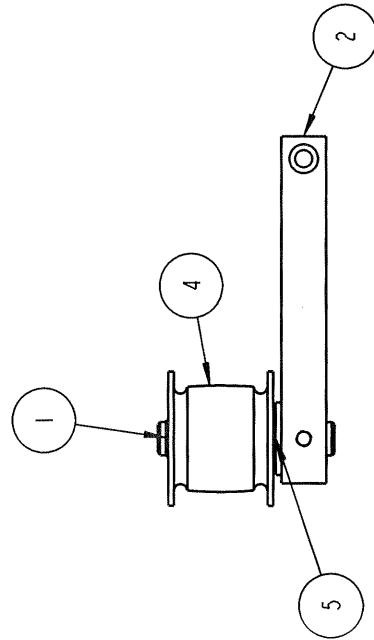
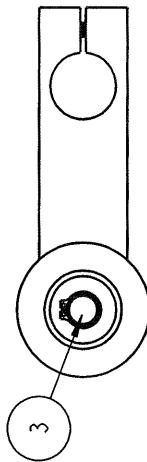
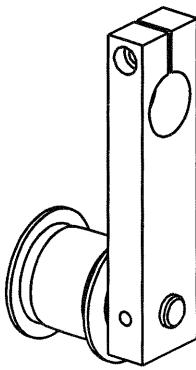


REF'D WHERE USED
1 KIRK-RUDY, INC.
2 KIRK-RUDY, INC.
3 KIRK-RUDY, INC.
4 KIRK-RUDY, INC.
5 KIRK-RUDY, INC.

DRAWING PROJECTION		PROPRIETARY AND CONFIDENTIAL	
THIS DRAWING IS THE PROPERTY OF KIRK-RUDY, INC.		NO COPIES OR PARTS THEREOF MAY BE MADE OR REPRODUCED	
IN WHOLE OR IN PART, WITHOUT THE EXPRESS WRITTEN PERMISSION		OF KIRK-RUDY, INC., 30788 USA	
NAME: SAI184		TITLE: ASSY, KR345 OUTFEED SECTION RH	
SCALE: 0.090		DATE: 28-JUL-03	
CHECKED BY: MISTER		REMOVED ALL CAVITIES UNLESS OTHERWISE NOTED	
TRACED BY: MISTER		ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE, WORK TO DIMENSIONS ONLY	

REF'D WHERE USED
1 KIRK-RUDY, INC.
2 KIRK-RUDY, INC.
3 KIRK-RUDY, INC.
4 KIRK-RUDY, INC.

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
REO-D	WHERE USED

KR KIRK - RUDY, INC.
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

THIRD ANGLE PROJECTION
TITLE: ASSY, TAKE UP IN BELT

MODEL: XXX

SHEET NO: 1 OF 1

DRAWING #: 530610-01

REV: 0

DATE: 26-May-98

SCALE: 0.500

MATERIAL: XXX

DIMENSIONAL TOLERANCES
UNLESS OTHERWISE NOTED

.01 .005 .005 .5

ANG.

HEAT TREAT:

NONE

FINISH:

N/A

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

MASTER

TRACED BY:

CHECKED BY:

DRAWN BY:

TVK

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
RECD	WHERE USED

PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE OCULATED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC. WOODSTOCK, GEORGIA		TITLE: ASSY, TAKEUP IN BELT	DRAFTING #: 530610-02
DATE:	XX	MODEL:	XXX
MASTER	FINISH:	SHEET NO.:	OF 1

DRAWN BY: TVK	SCALE: 0.500	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED		MATERIAL: XXX		
		.01	.005	.5	HEAT TREAT:	NONE
CHECKED BY:	DATE: 26-May-98	.005 ANG.		REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED		
TRACED BY:	MASTER	.5 ANG.		ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY		

ITEM QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	2	537280-01	BUSHING BLOCK ASY				
2	1	544460-01	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	1	544464-01	BACKSTOP, PRODUCT				
7	2	544465-01	PLATE, MOUNTING				
8	3	544491-01	ROD, PRODUCT GUIDE				
9	3	CSFF58	SCREW, BUTTON HEAD #10-32X.500				
10	8	CSFF63	SCREW, BUTTON HEAD 1/4X.250				

RECD WHERE USED
I KR345L

DRAWN BY: T JG SCALE 0.156 DIMENSIONAL TOLERANCES MATERIAL: XXX UNLESS OTHERWISE NOTED .XXX ANG. .01 .005 .5 HEAT TREAT: XXX

CHECKED BY: DATE 28-JUL-03 REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED FINISH: XXX

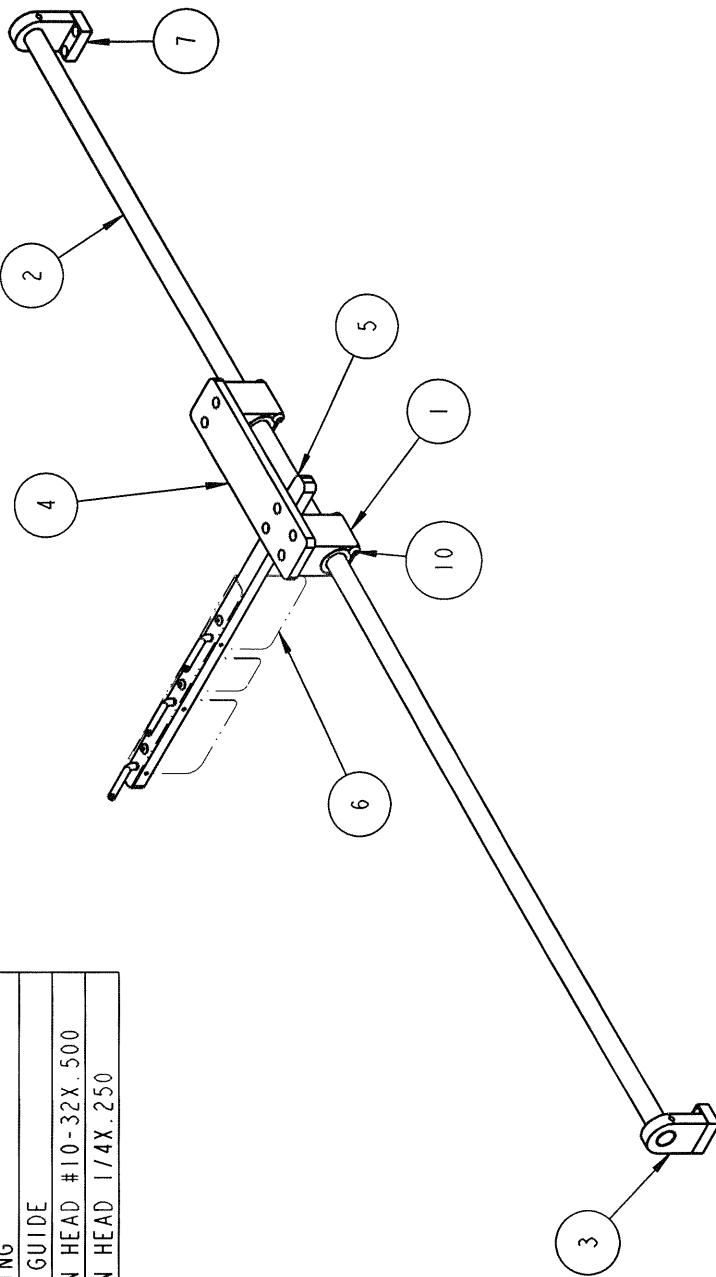
TRACED BY: MASTER ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY

THIRD ANGLE PROJECTION

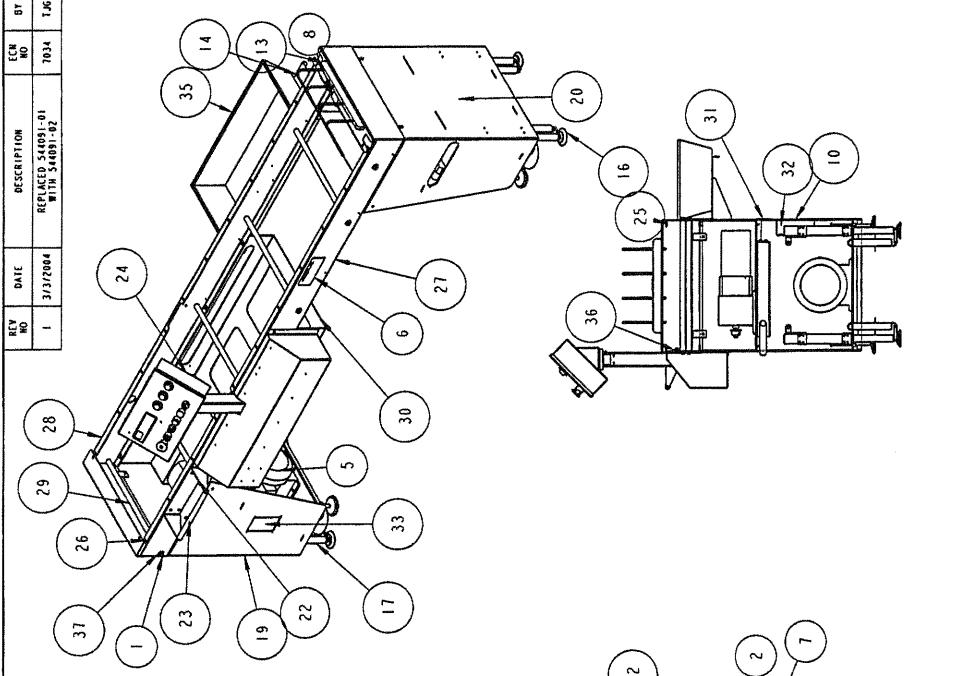
KIRK - RUDY, INC.
WOODSTOCK, GEORGIA

MODEL: SAI84 TITLE: ASSY, BACKSTOP LH
SHEET NO: 0F1 DRAWING ■ 544459-01

ITEM QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	2	537280-01			BUSHING BLOCK ASY		
2	1	544460-01			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	1	544464-01			BACKSTOP, PRODUCT		
7	2	544465-01			PLATE, MOUNTING		
8	3	544491-01			ROD, PRODUCT GUIDE		
9	3	CSEFF58			SCREW, BUTTON HEAD #10-32X.500		
10	8	CSFF63			SCREW, BUTTON HEAD 1/4X.250		



I	KR345R
REV'D	WHERE USED
PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE QUOTED OR REPRODUCED IN ANY FORM WITHOUT THE EXERCISE WRITTEN PERMISSION OF KIRK-RUDY INC. WOODSTOCK, GA 30188 USA	
THIRD ANGLE PROJECTION	
MATERIAL:	X X X
DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	
.XX .XXX	
ANG.	
.01 .005 .5	
HEAT TREAT:	X X X
FINISHES:	X X X
REMOVED ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED	
ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY	
SCALE: 0.156	DATE: 28-JUL-03
DRAWN BY: T JG	CHECKED BY:
TRACED BY: MASTER	
SHEET NO: 0F1	TITLE: ASSY, BACKSTOP RH
	544459-02



ITEM QTY PART # DESCRIPTION

ITEM QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BT
1	11	101336 BOLT, HEX HEAD 5/16-18X .75			REPLACED 544469-01 WITH 544469-02	7034	1.06
2	2	10742 SPRING 35612 .655B .188K					
3	4	190620 CASTER 2.5IN					
4	4	190634 FOOT, MOUNTING					
5	1	200120 BLOWER, GAST					
6	1	190619-1 PLATE, NAME					
7	1	19029-1 PUMP, MOVOTEC PB4612FC					
8	1	202263-7 SENSOR, PERFECT PROX					
9	4	501812-1 LEG, LEVELING					
10	1	530441-05 BOX, ELECTRICAL INLET 20A					
11	1	530575-05 WELDMENT, CONVEYOR OUTFD GUARD					
12	1	530575-06 WELDMENT, CONVEYOR OUTFD GUARD					
13	1	530759-08 ROD, HOLDER					
14	4	530160-01 ROD, STOP					
15	2	538711-04 ASSY, 1/4HP GEARHEAD W/CLUTCH					
16	2	539424-01 ASSY, RH HYDRAULIFT LEG					
17	2	539425-01 ASSY, LH HYDRAULIFT LEG					
18	1	544091-02 WDMT, SHELF MAIL TRAY					
19	1	544102-01 WDMT, CONVEYOR LEG					
20	1	544102-02 WDMT, CONVEYOR LEG					
21	2	544165-01 COVER, CHAIN LEG					
22	1	544222-01 BRACKET, SHAFT MOUNT					
23	1	544223-01 SHAFT, REAR SUPPORT					
24	1	5444335-01 ASSY, CONTROL PANEL KR345					
25	2	544466-01 BAR, TABLETOP MOUNT					
26	2	544466-02 BAR, TABLETOP MOUNT					
27	1	544410-01 CHANNEL, CONVEYOR CABINET RH					
28	1	544470-02 CHANNEL, CONVEYOR CABINET LH					
29	6	544472-01 SHAFT, FRAME SPACER					
30	1	544474-01 BRACKET, CONTROL BOX MOUNT					
31	1	544487-01 COVER, HYDRAULIFT SLOT					
32	1	544517-01 COVER, E-BOX MR345					
33	1	544518-01 COVER, E-BOX HOLE					
34	2	6500320 SCREW, SHCS 5/16-18X .750					
35	1	MAIL-TRAY MAIL TRAY					
36	1	IRHNO11 NUT, HEX 5/16					
37	12	WA012 WASHER, FLAT 5/16					

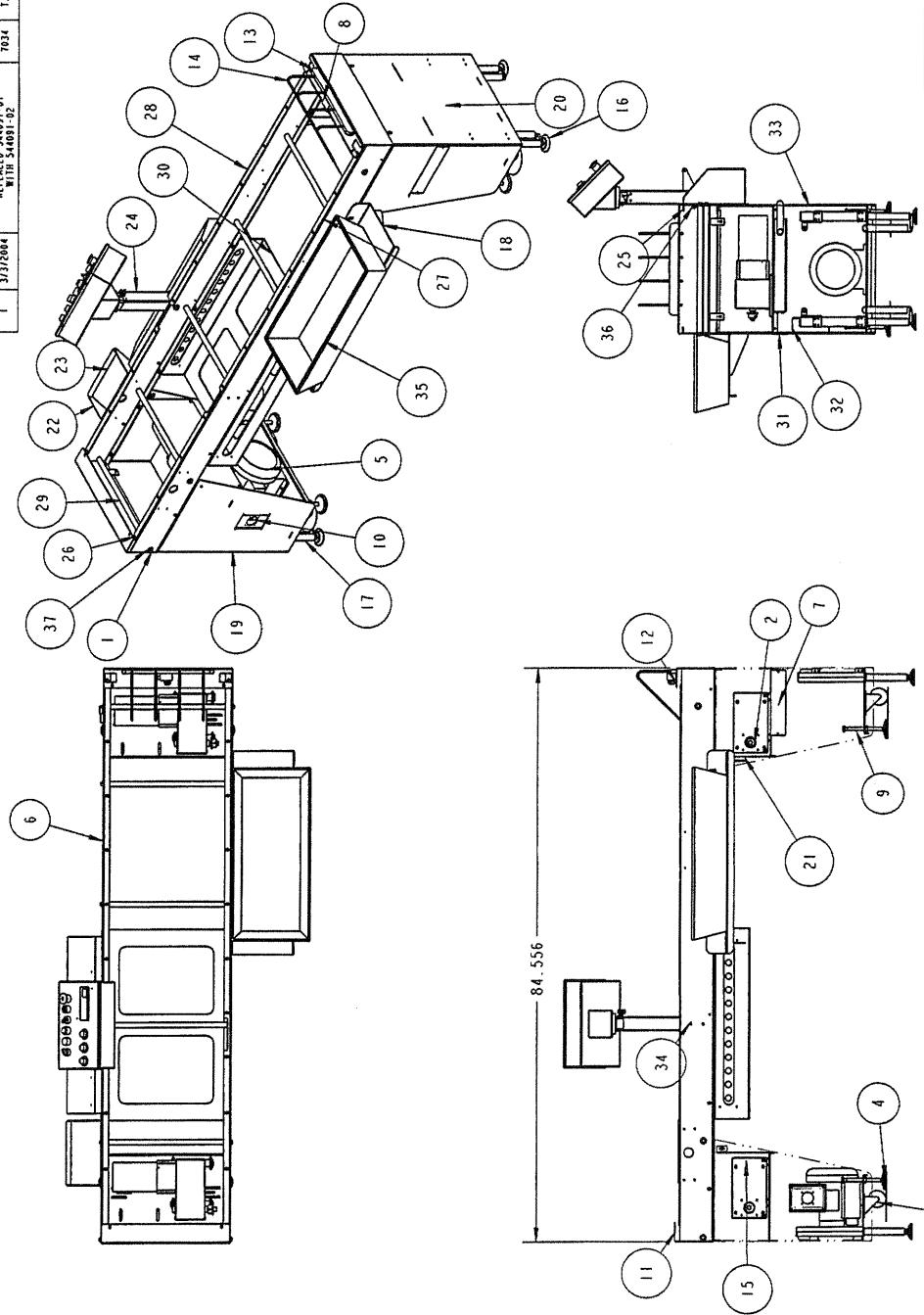
ITEM QTY	PART #	DESCRIPTION	REV NO	WHERE USED
1	68345L			
ASSY, CONVEYOR FRAME LH				
544469-01				
SAI 84				
SHEET 10F 1				

NAME BY:		SCALE	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED		MATERIAL:	
CHECKED BY:		DATE	IN.	MM	IN.	MM
		28 - JUL - 03				
			REMOVED	FOR USE	ALL DIMENSIONS ARE	IN HUNDREDTHS OF INCHES. EXCEPT WHERE OTHERWISE NOTED.
			INCHES	MM	INCHES	MM
MAILED BY:						

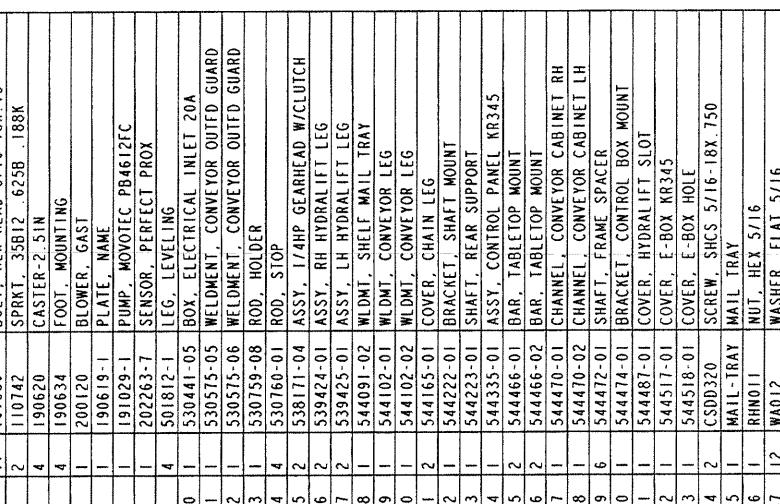
244463-02

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544469-02



ITEM #	QTY	PART #	DESCRIPTION
11	1	107336	BOLT, HEX HEAD 5/16-18X .75
2	2	107337	CDWV, SCREW, 5/16-18X .75
			1000



6

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KR345R
REO'D WHERE USED
JOY, INC., GEORGIA

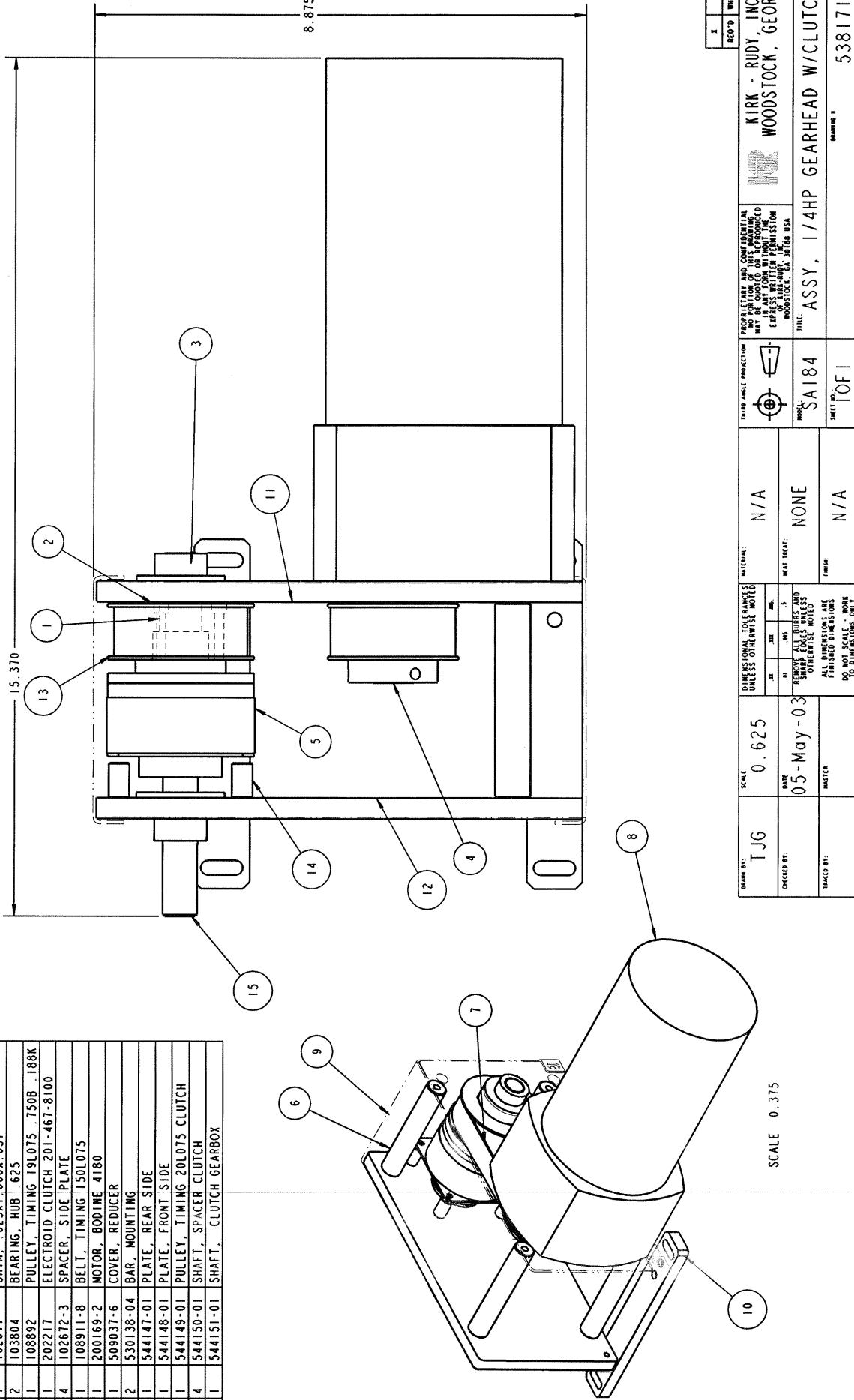
ASSY CONVEYOR FRAME BH

PRINTING 1

一

III

ITEM #	PART #	DESCRIPTION	REV NO.	DATE	DESCRIPTION	ECN NO.	BT
1	100258	BUSHING, SL-.825ID .750OD .500LG					
2	103671	SHIM, .625X1 .000Y .031					
3	2	103804 BEARING, HUB .625					
4	1	108892 PULLEY, TIMING 19L075 .750B .188K					
5	1	202217 ELECTROID 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	509037-6 COVER, REDUCER					
10	2	530138-04 BAR, MOUNTING					
11	1	544147-01 PLATE, REAR SIDE					
12	1	544148-01 PLATE, FRONT SIDE					
13	1	544149-01 PULLEY, TIMING 20L075 CLUTCH					
14	4	544150-01 SHAFT, SPACER CLUTCH					
15	1	544151-01 SHAFT, CLUTCH GEARBOX					



ITEM QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN 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 SCREW X .625 LONG
4 PLACES

2	SP84700
RECD WHERE USED	

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

KR KIRK - RUDY, INC
WOODSTOCK, GEORGIA

THIRD ANGLE PROJECTION

Model: SP84700

Title: ASSY, RH HYDRAULIFT LEG

Sheet No. 10F1

DRAWING # 539424-01

DRAWN BY:
A KEY

SCALE: 0 .375

ITEM: DIMENSIONAL TOLERANCES MATERIAL: N/A

.xx	.xxx	ANG.
.01	.005	.5

HEAT TREAT: N/A

FINISH: N/A

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

CHECKED BY:
26-JUL-00

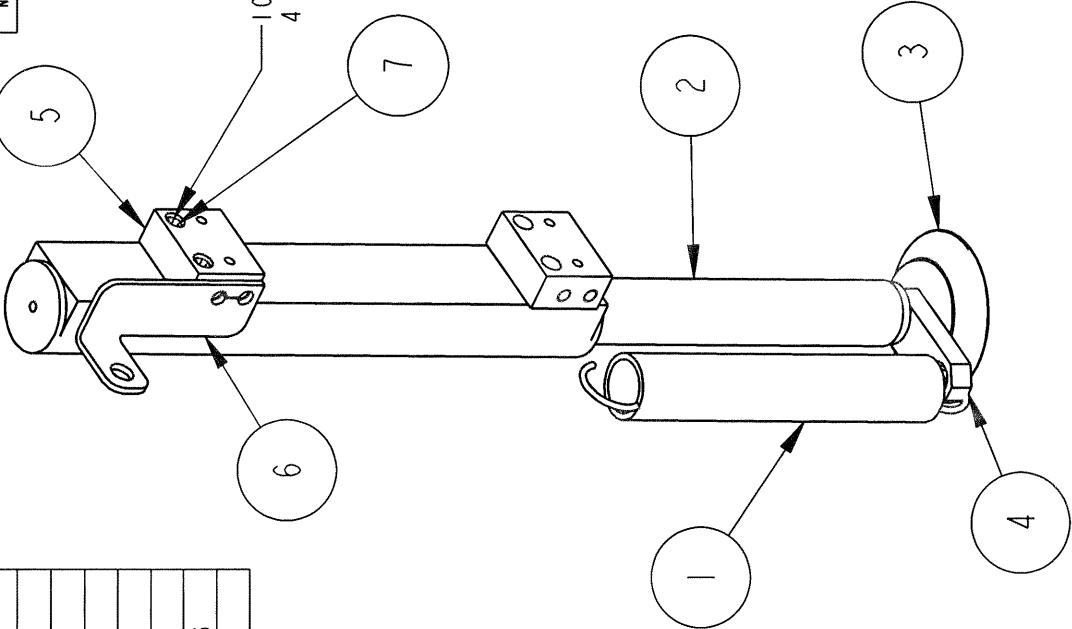
REMOVED ALL BURRS AND
SHARP EDGES UNLESS
OTHERWISE NOTED

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

TRACED BY:
MASTER

DRAWING # 539425-01

ITEM QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	1	102792 SPRING, EXTENSION					
2	1	191029-2 CYLINDER, LIFT CB415					
3	1	191029-3 GLIDE, SUSPA					
4	1	537371-01 BRACKET, SPRING RETURN MOUNT					
5	2	537596-01 BLOCK, HYDRAULIC LIFT LH					
6	1	537597-02 BRACKET, HYDRAULIC LIFT SPRING					
7	2	CSD266 SCREW, SHCS 10-32X.625					



2	SP84700
REQ'D	WHERE USED
<p>PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE QUOTED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY INC. WOODSTOCK, GEORGIA</p>	
3	KIRK - RUDY - INC KIRK-RUDY INC. WOODSTOCK, GEORGIA
4	TITLE: ASSY, LH HYDRALIFT LEG
5	MODEL: SP84700
6	SHEET NO: 0F1
7	DRAWING #: 539425-01

DRAWN BY:	A KE Y	SCALE	0 .375	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	MATERIAL:	N / A	
CHECKED BY:		DATE	26 - JUL - 00	.01 .005 .5 ANG.	HEAT TREAT:	N / A	
TRACED BY:	MASTER	REMOVED ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED			FINISHES:	N / A	
		ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY					

ITEM	QTY	PART #	DESCRIPTION	REV NO	DATE	ECN NO	BY
ASSEMBLY							
1	1	100338	BUSHING, FLI. 0001D1 250001 .50016				
2	1	105209	PIN, ROLL .188X1.250				
3	2	105228	PIN, ROLL .188X .625				
4	1	202524	PLC, CROUZET				
5	3	209016	KNOB, POT				
6	1	500790	ASSY, KNOB				
7	1	201124-4	BUTTON, POWER ON				
8	1	201125-3	BUTTON, STOP				
9	1	201125-5	BUTTON, POWER OFF				
10	1	201126-1	BUTTON, JOG				
11	2	201145-1	SELECTOR, 2 POSITIONS				
12	1	528247-12	BOX, CONTROL KR345				
13	1	532153-04	TUBING, VERTICAL				
14	1	532154-01	HOUSING, PIVOT				
15	1	544330-01	PANEL, ON EDGE STACKER CONTROL				
16	1	544332-01	WLDNT, CONTROL BOX KR345				
17	1	544333-01	WLDNT, PIVOT MOUNTING				
18	1	544488-01	HINGE, CONTROL BOX KR345				
19	1	544489-01	PANEL, ELECTRICAL KR345				
ASSEMBLY							
20	1	PEB	SCALE 0 .156	N/A	N/A	N/A	
21	1	SA184	25-Aug-03	N/A	N/A	N/A	
DETAILS							
DIMENSIONAL TOLERANCES: UNLESS OTHERWISE NOTED							
IN INCHES							
IN MILLIMETERS							
MAX. TOLERANCE: .5							
REPORT ALL SURFACES SHARP EDGES UNLESS OTHERWISE NOTED							
ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE. WORK TO DIMENSIONS ONLY							
PRINTED ON 08/25/2003 BY KIRK-RUDY INC.							
WOODSTOCK, GEORGIA							
DRAWING # 544335-01							

1	RE 345	REC'D WHERE USED
ASSY, CONTROL PANEL KR345		
DRAWING # 544335-01		

ITEM	QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	2	101329	BUSHING, FL. 150101.000000 75016					
2	1	102112	KNOB					
3	2	102203	COLLAR .625					
4	2	102215	COLLAR .750					
5	8	103804	BEARING, HUB .625					
6	1	105610	SHAFT, THREADED 3/8-16					
7	3	106461	BELT, FLAT 3/4 X 93"					
8	1	108888	PULLEY, TIMING 21050 .650 188K					
9	1	109963	PULLEY, TIMING 361050 750B .188K					
10	1	190834	GAS SPRING, SOLID GAS 1/2					
11	2	190841	BLOCK, CYLINDER MOUNT					
12	1	108929-4	BELT, TIMING 2101050					
13	1	200159-2	MOTOR, BODINE 4180					
14	1	500823-15	SHAFT, OILER ROLLER					
15	2	510610-3	SHAFT, ROLLER FRAME SPACER					
16	1	532466-01	ASSY, DIPPER ARM PIVOT					
17	2	533669-02	BLOCK, REFLECTOR MOUNT					
18	1	538434-03	ASSY, DRIVE ROLLER					
19	1	538434-04	ASSY, IDLER ROLLER					
20	1	542803-01	WDMT, LUBR CLAMP BUMP TURN					
21	1	542805-01	TUBING, VERTICAL BUMPTURN					
22	1	543309-01	TABLETOP, INFED					
23	2	544458-02	FRAME, INFED SECTION					
24	1	544471-01	SHAFT, ROLLER DRIVE					
25	3	544475-01	ROLLER, IDLER INFED					
26	1	544476-01	PLATE, MOTOR MOUNT LH					
27	1	544476-02	PLATE, MOTOR MOUNT RH					
28	2	544477-01	BRACKET, L CONVEYOR MOUNT					
29	1	544478-02	W/DNNT, INFED SECTION COVER					
30	2	544479-01	BRACKET, L CONVEYOR MOUNT					
31	1	544482-01	ASSY, SIEGUIDE INFED					
32	1	544501-01	COVER, ROLLER GUARD					
33	1	546475-01	ASSY, CONVEYOR ANGLED					
34	1	546478-01	SHAFT, ROLLER IDLER					
35	2	546485-01	SHAFT, CONVEYOR PIVOT					
36	6	CS0029-1	SCREW, SHCS 1/4-20X .375					
37	4	CS0029-3	SCREW, SHCS 1/4-20X .25					
38	4	CS0029-6	SCREW, SHCS 1/4-20X .000					
SCALE 0.125								
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ITEM QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	2	100326 BUSHING, FLI. 0001D1.2500D.750LG					
2	2	102212 COLLAR 1.000					
3	1	532465-01 BRACKET, DRYER ARM PIVOT					
4	1	532467-01 SHAFT, DRYER PIVOT					

I 532734-01
REV'D WHERE USED

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WOODSTOCK, GA 30188 USA

THIRD ANGLE PROJECTION

KIRK - RUDY, INC.
R WOODSTOCK, GEORGIA

MODEL: SP62500 TITLE: ASSY, DRYER ARM PIVOT

MATERIAL: NOTE D

XX	XXX	ANG.
.01	.005	.5

HEAT TREAT: NONE

FINISH: REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED

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

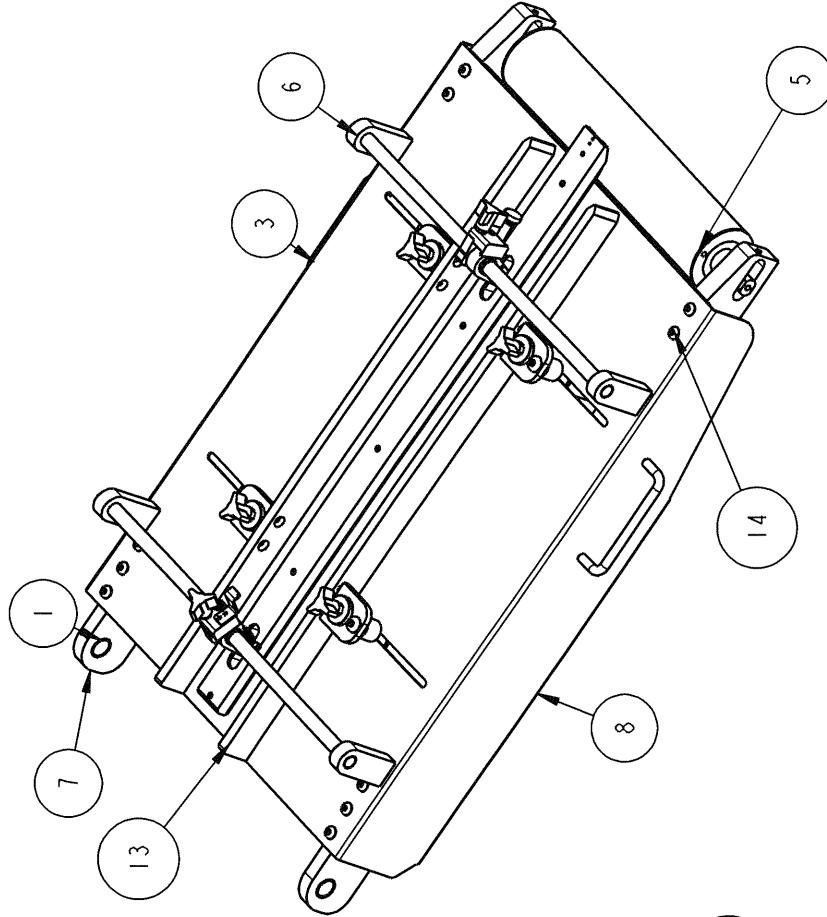
DRAWN BY: T JG SCALE: 0 .750 DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED

CHECKED BY: DATE: 20-Feb-98

TRACED BY: MASTER FINISH: NONE

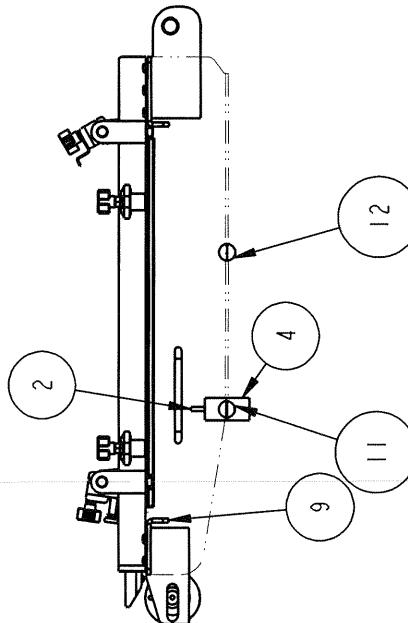
SHEET NO.: 0F1 DRAWING # 532466-01

REV NO	DATE	DESCRIPTION	ECN NO	BY
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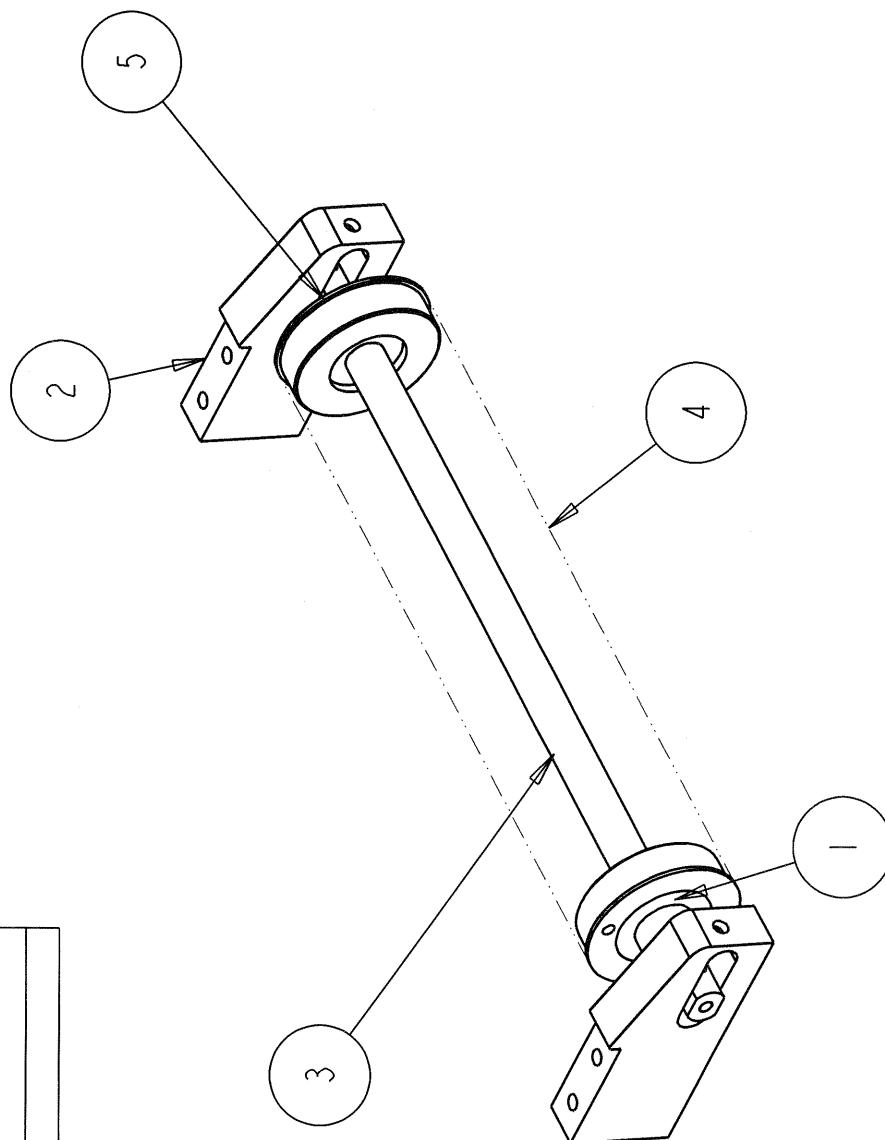
ITEM NO.	PART #	DESCRIPTION
1	100258	BUSHING, SL. 62510-07500D.500LG
2	105419	DOWEL, PIN .188X1.000
3	190955	HANDLE
4	50075-13	GUIDE, BELT 3/4
5	530619-01	ASSY, IDLER ROLLER
6	537284-09	ASSY, SKID BAR BUMPTURN
7	546476-01	PLATE, INFEED RAMP BEARING
8	546477-01	TABLETOP, INFEED CONVEYOR
9	546480-01	BRACKET, TAKEUP BLOCK SPACER
0	546480-02	BRACKET, TAKEUP BLOCK SPACER
1	546481-01	SHAFT, SPACER CONVEYOR
2	546481-02	SHAFT, SPACER CONVEYOR
3	546482-01	ASSY, SIDEGUIDE INCLINE CONVEYOR
4	CSFF67	SCREW, BUTTON HEAD 1/4 X 750

SCAI F 0 | 88



SCAI F 0 | 88

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



1	215
REQ'D	WHERE USED
KRK KIRK - RUDY, INC. WOODSTOCK, GEORGIA	
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THIRD ANGLE PROJECTION	
MODEL:	SP71700
TITLE:	ASSY, IDLER ROLLER
SHEET NO.:	1 OF 1
DRAWN BY:	TVK
SCALE:	0.375
DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	N/A
XX XXX ANG.	.01 .005 .5
CHECKED BY:	02-Mar-99
REMOVED ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED	N/A
MASTER	ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY
TRACED BY:	N/A

ITEM QTY	PART #	DESCRIPTION	REV NO	DATE	ECN NO	BT
WASHER, FLAT 10-32						
1	100619	WASHER, FLAT 10-32				
2	102117	KNOB				
3	102132	KNOB, 10-32 CAP SCREW				
4	102714	SPRING, COMPRESSION				
5	102716	SPRING, COIL EO 240-026-1000N				
6	105210	PIN, ROLL .125X .750				
7	105613	SHAFT, 10-32 X 2.00 LNG				
8	10 190854	BALL, 1/2 DIA STEEL				
9	9 190859	DISC, 1/2 DIA FELT				
10	4 503556	POST, SIDEGUIDE				
11	2 500787-19	SHAFT, SIDE GUIDE ADJ.				
12	2 500801-11A	ASSY, LINK				
13	1 529107-18	BAR, SILENT SKID				
14	1 529148-17	RETAINER PLATE-SKID PLATE				
15	1 537284-09	ASSY, SKID BAR BUMPTURN				
16	1 537819-01	BLOCK, SKID BAR ADJUST CLAMP				
17	1 537884-01	CAP, SKID BAR ADJUST				
18	1 537886-01	ASSY, TRIKNOB 10-32 X 2.000 LNG				
19	1 539817-03	ASSY, SKID BAR CLAMP				
20	1 CSD0242	SCREW, SHCS 8-32X1.000				
21	1 CSD0264	SCREW, SHCS 10-32X .375				
22	1 CSD0270	SCREW, SHCS 10-32X1.250				
23	2 CSD0271	SCREW, SHCS 10-32X1.500				
24	5 CSD0292	SCREW, SHCS 1/4-20X1.500				
25	4 CSD0293	SCREW, SHCS 1/4-20X1.625				
26	1 HNSM09	NUT, HEX #8-32				
27	3 HNSM10	NUT, HEX #10-32				
SCALE 0 .500						
<p>PRINT BY: T JG SCALE 0 .312 DIMENSION IN INCHES UNLESS OTHERWISE NOTED</p> <p>CHECKED BY: 07-Dec-04 N/A N/A N/A</p> <p>MAILED BY: 07-Dec-04 N/A N/A N/A</p> <p>REMOVED BY: 07-Dec-04 N/A N/A N/A</p> <p>STOCK NO: 10F1</p>						
<p>1 54283</p> <p>1 537284-09</p>						

1	54283	FLO O WHERE USED
THIS SHEET PERTAINS PROPRIETARY AND CONFIDENTIAL PRODUCTION INFORMATION NOT TO BE COPIED OR DISCLOSED EXCEPT WITH WRITTEN PERMISSION OF KIRK-RUDY, INC. WOODSTOCK, GEORGIA		
SA283 DATE:		
SHEET NO. 1 OF 1		

DRAWING #		546482-01		
ITEM #	QTY	DESCRIPTION	REV NO	DATE
1	4	500190-1 ASSY, TRI-KNOB 1/4-20 STUD		
2	4	541109-03 BRACKET, SIDEGUIDE		
3	4	541110-03 SPACER, SIDEGUIDE MOUNT		
4	2	546483-01 SIDEGUIDE, INCLINE CONVEYOR		
5	2	546484-01 STRIP, SIDEGUIDE CLAMP		
6	4	CSFF11 SCREW, BUTTON HEAD 5/16X .500		
7	4	SP6383-1 SPACER, GEAR COVER		

SCALE 0.375

1	KA245
REV'D	WHERE USED

KIRK-RUDY INC.
WOODSTOCK, GEORGIA

ASSY, SIDEGUIDE INCLINE CONVEYOR

DRAWING # 546482-01

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OF KIRK-RUDY INC.
WOODSTOCK, GA 30188 USA

SA283

SCALE 0.375

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8.0 ELECTRICAL SCHEMATICS AND PARTS



WARNING

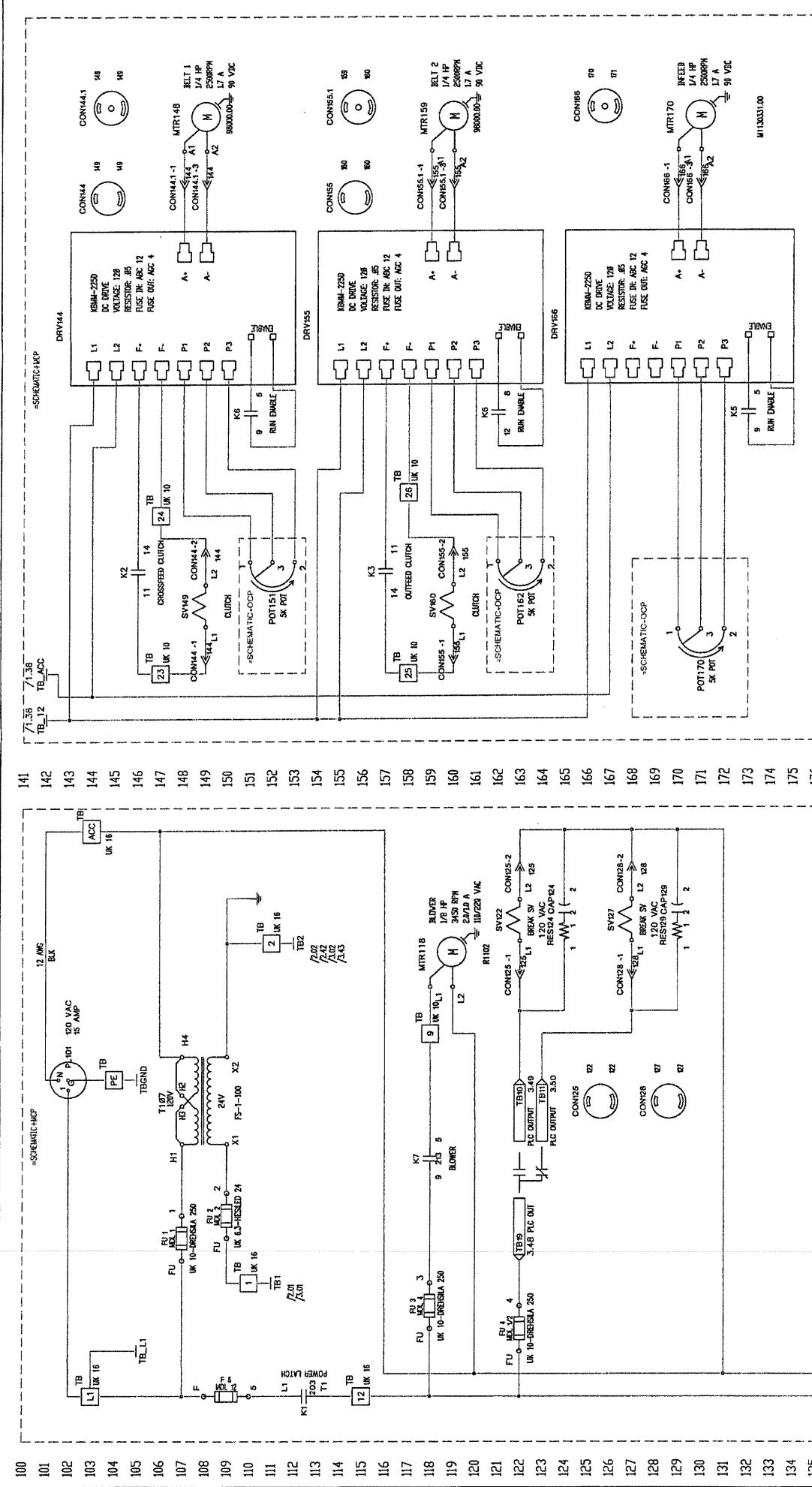
Read and follow all Safety Instructions in Section 1, Page 3 before proceeding.

8.1 SCHEMATIC NUMBER LIST

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.

210455 00 00 Schematic, KR345 Vertical Edge Stacker
SYMBOLS.ORG Schematic Symbols Reference

8.2 PARTS LIST



DRAWN BY:		DRAWN DATE:	
M.G.A		08/07/03	
DESIGNED BY:		DESIGN DATE:	
R.B		08/05/03	
SCALE:		SHEET:	
MASTER:		SA184	
DRAWING NO.:		DRAWING F:	
140		10/3	
136		DRAWING F:	
137		178	
138		179	
139		180	
140		181	
100		DRAWING F:	
101		DRAWING F:	
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Kirk-Rudy, Inc.
125 Lorine Parkway
Woodstock, Georgia 30188

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WOODSTOCK, GA 30188 USA

THE

ON-EDGE CONVEYOR STACKER/SORTER

WORK NO. KR345

DRAWING NO. KR345

DRAWING DATE: 08/07/03

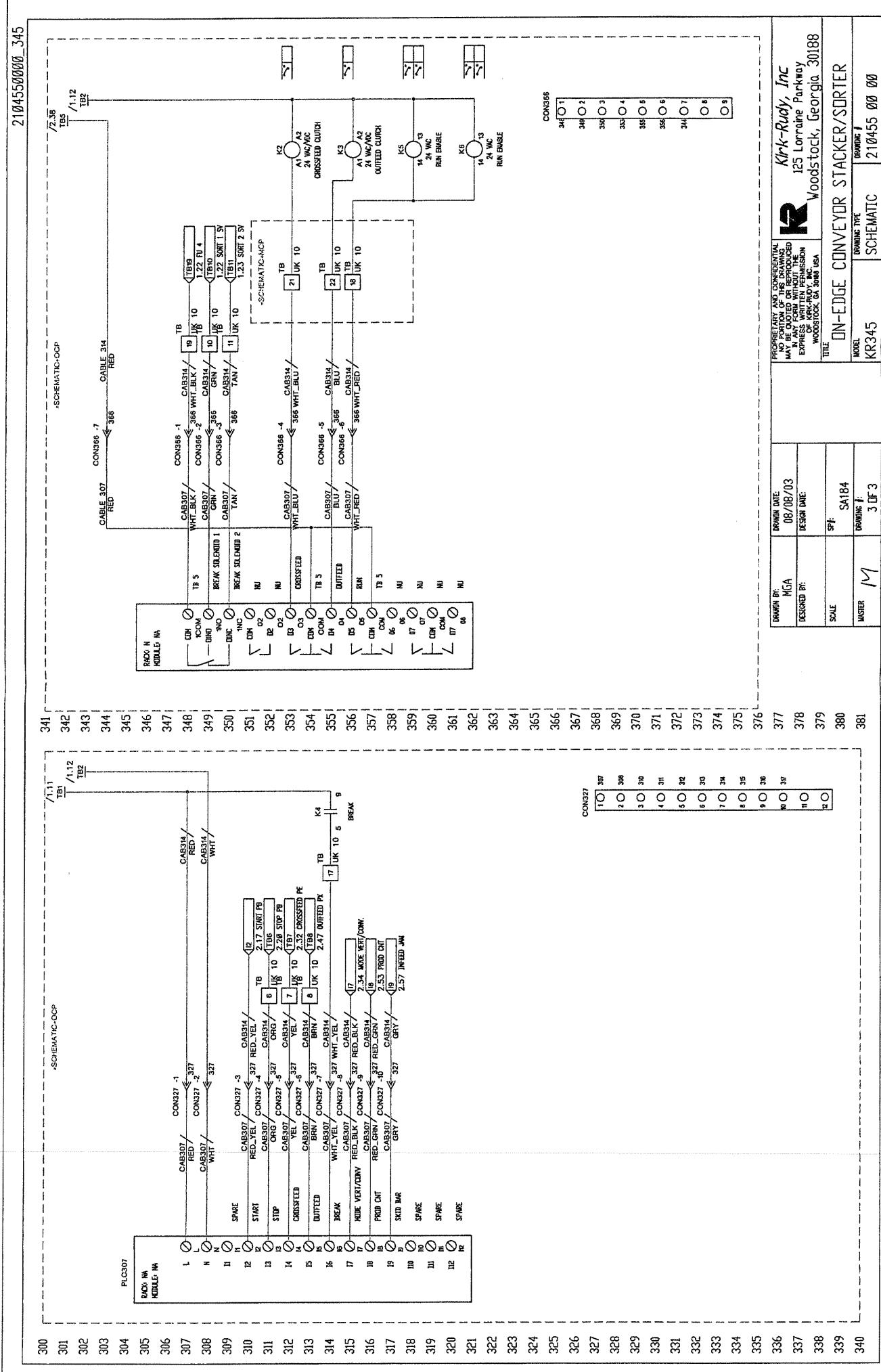
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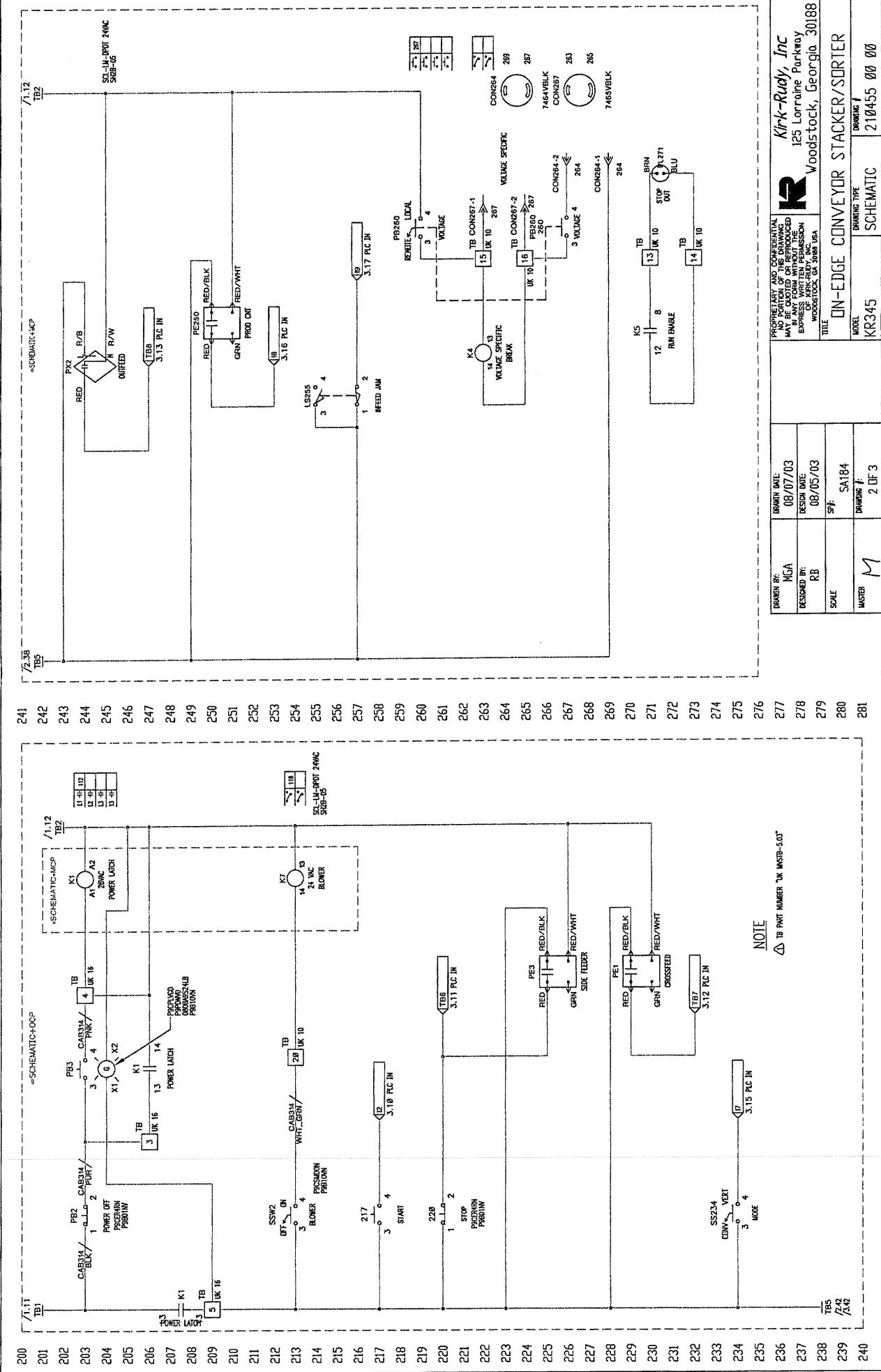
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9.0 APPENDIX



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