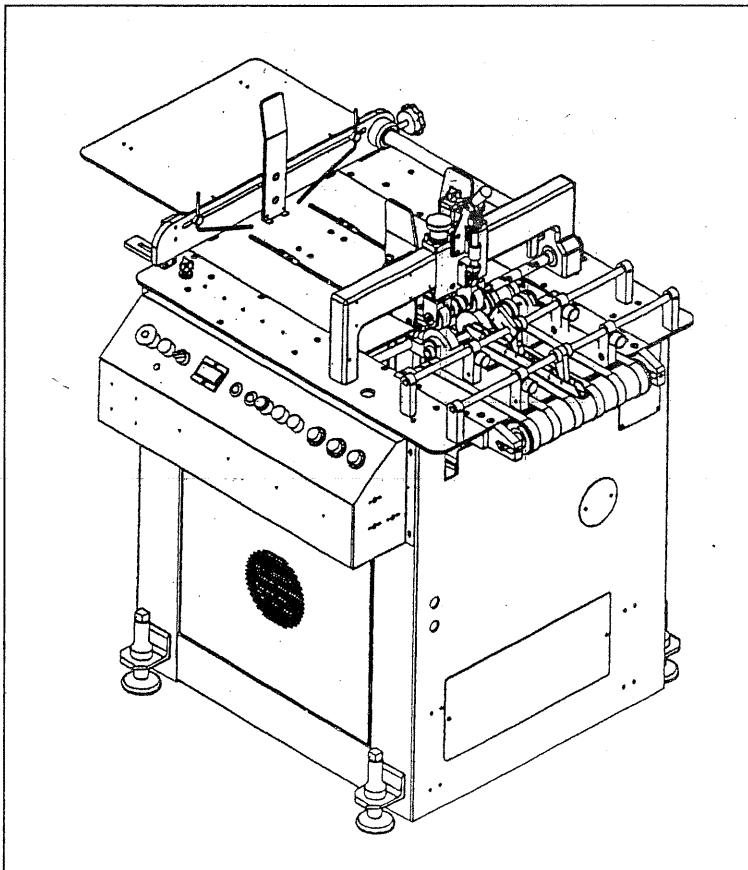


Kirk-Rudy, Inc.

Instruction and Parts Manual

KR224 Feeder Base



Manufactured by Kirk-Rudy, Inc.

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

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

1 Important Safety Instructions

Intended Use Statement: The KR224 is a top load, bottom feed transport designed to separate and feed product one at a time in a consistent manner.

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 PRESSES THE STOP BUTTON BEFORE CLEARING PRODUCT. IF THE STOP BUTTON IS NOT PRESSED AND THE JAM IS CLEARED, THE MACHINE WILL BEGIN RUNNING.
- * IT IS NOT RECOMMENDED THAT LOOSE CLOTHING, JEWELRY AND LONG HAIR BE WORN WHILE OPERATING THIS MACHINERY.
- * ALWAYS USE AN EXPERIENCED ELECTRICIAN WHEN TROUBLE-SHOOTING ELECTRICAL PROBLEMS.
- * CHANGES OR MODIFICATIONS TO THIS UNIT NOT EXPRESSLY APPROVED BY THE PARTY RESPONSIBLE FOR COMPLIANCE COULD VOID THE USER'S AUTHORITY TO OPERATE THE EQUIPMENT.

2 SPECIFICATIONS

<u>PRODUCT SIZE RANGE</u>	<u>English</u>	<u>Metric</u>
Minimum Size:	3" W x 5" L	7.6cm W x 12.7cm L
Maximum Size:	17" W x 17" L	43.2cm W x 40.6cm L
Minimum Thickness:	Card Stock (.007")	Card Stock (.10mm)
Maximum Thickness:	.625"	15.9 mm

PHYSICAL SIZE

Length	43.2" Max	109.7 cm
Width	31.175"	79.2 cm
Height	33.25"	84.5 cm
Weight	480 lbs	218 kg
Shipping	580 lbs	263 kg

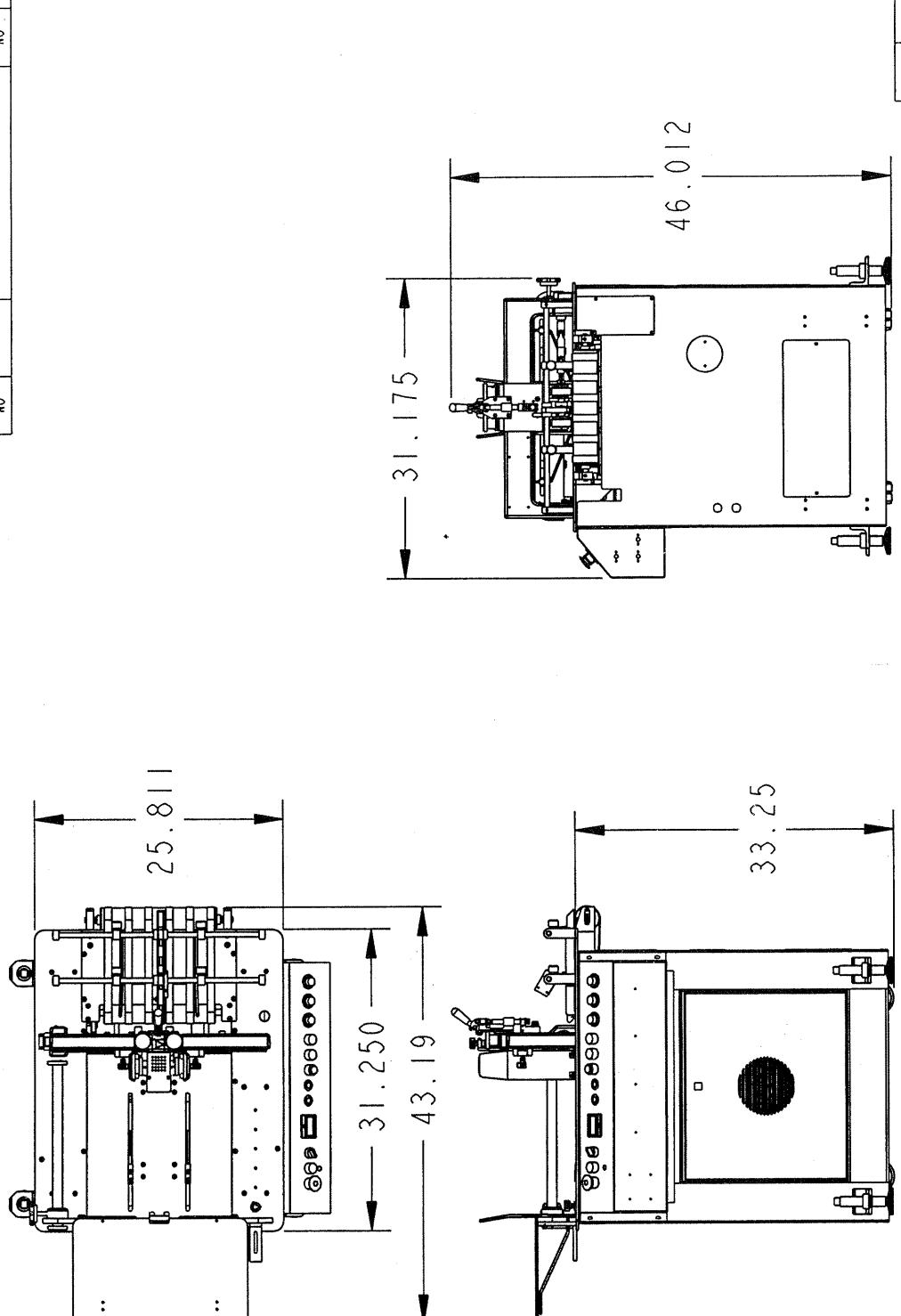
MAXIMUM CYCLE SPEED

14,000 cycles per hour for 1/2 HP Motor and Single Reduction Gear Box (Product Size Dependent)
30,000 cycles per hour using no reduction and 1 HP Motor (Product Size Dependent)

ELECTRICAL REQUIREMENTS

Main Power 120/220V, 1 phase, 60/50 cycle, AC 20/10 amps

REV NO	DATE	DESCRIPTION	ECN NO	BY



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CHECKED BY:	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED .01 .005 .5	HEAT TREAT: N / A	MODEL: KR224	TITLE: ASSY, KR224
TRACED BY: MASTER	DATE 17 - Mar - 05	FINISH: N / A	SHEET NO: 20F4	DRAWING # KR224
	REMOVED ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED	ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY		

3 INSTALLATION



WARNING

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

3.1 UNCRATING

1. Position crate near installation site.
2. Remove crate top and sides.
3. Locate accessories box and verify all items are present.
4. Remove metal strapping and securing blocks.
5. Use forklift to lift machine off skid. Be sure to position the forks in a centrally located position.
6. Machine is on casters and can be rolled to desired location.
7. Adjust the height of the base with the four leveling legs.

Note: A forklift should be used to lift machine from pallet. The base is mounted on casters.

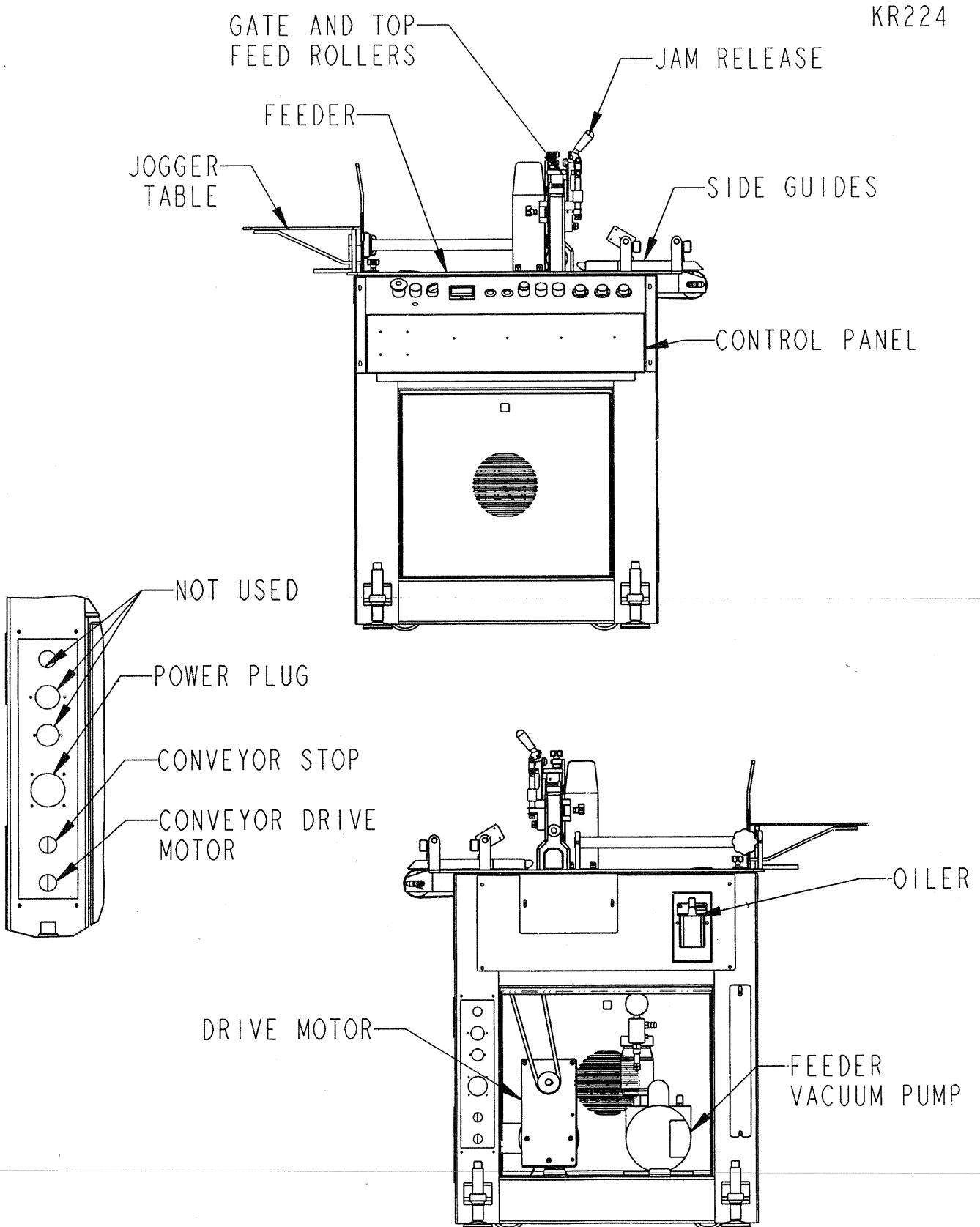
3.2 ACCESSORIES AND SPARE PARTS

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

3.3 COMPONENT DESCRIPTION (see Figure 1.0)

1. JOGGER TABLE: Used to set the backstop for the product being fed. Can also be used to hold extra product.
2. FEEDER: Pushes product under gate and into feed rollers.
3. GATE: Prevents more than one piece of product from being fed at one time.
4. TOP FEED ROLLERS: Along with the lower feed rollers, feeds product through the bridge.
5. JAM RELEASE: Raises top feed rollers, so a jam can be cleared.
6. SIDE GUIDES: Keeps product from skewing while traveling on the tabletop.
7. OILER: Used to lubricate machine.
8. FEEDER VACUUM PUMP: Supplies vacuum to the feeder.
9. DRIVE MOTOR: Drives the feeder pushers and tabletop belts.
10. CONTROL PANEL (for more detail, see Section 4.1 and Figure 2.0): Contains operator controls.

KR224



KR 224 MAJOR COMPONENTS
FIGURE 1.0

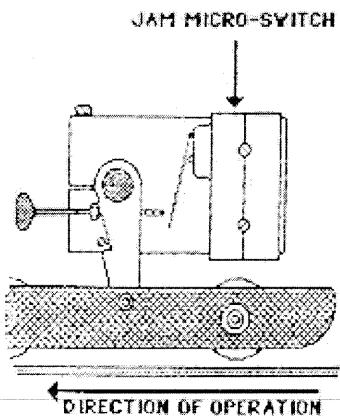
4 OPERATING INSTRUCTIONS

4.1 CONTROL PANEL (see Fig. 2.0)

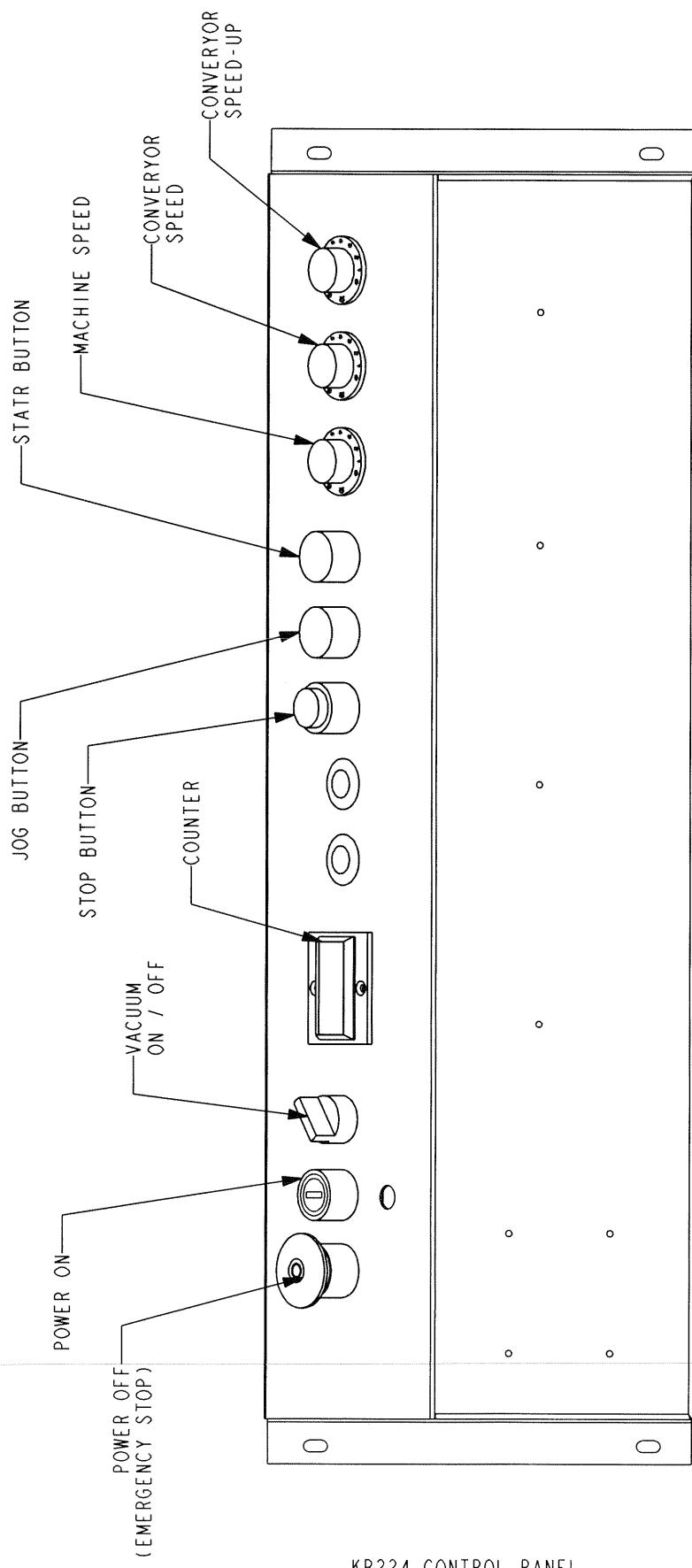
1. STOP BUTTON: Stops the feeder.
2. JOG BUTTON: The machine will run as long as this switch is depressed. This switch is designed as an aid for set-up and will also stop the machine when pressed and released.
3. START BUTTON: Starts the machine.
4. POWER OFF / EMERGENCY STOP BUTTON: This is a latching switch. To turn power on, unlatch emergency stop. Press button to turn machine power off. The green light in the power button will turn off when power is off.
5. POWER BUTTON: Press button to turn machine power on. Emergency stop button must be unlatched. Button will glow green when machine is on.
6. VACUUM SELECTION SWITCH: Turns on/off vacuum.
7. COUNTER: Counts the product.
8. MACHINE SPEED CONTROL: Controls the speed of the feeder. “0” is minimum speed, “10” is maximum speed.
9. CONVEYOR SPEED CONTROL: Controls the speed of the conveyor. “0” is minimum speed, “10” is maximum speed.
10. CONVEYOR SPEED UP CONTROL (OPTIONAL): Controls how fast the conveyor speeds up for zip code separation.

4.2 STOP CIRCUIT

The stop circuit is wired in series, this means that if one of the stop switches or buttons is open, the machine will not run. There are four stop switches on the KR224. They are the jam microswitch on the skid bar assembly (533821-01), the conveyor stop button, and the control panel emergency stop button (Figure 2.0).



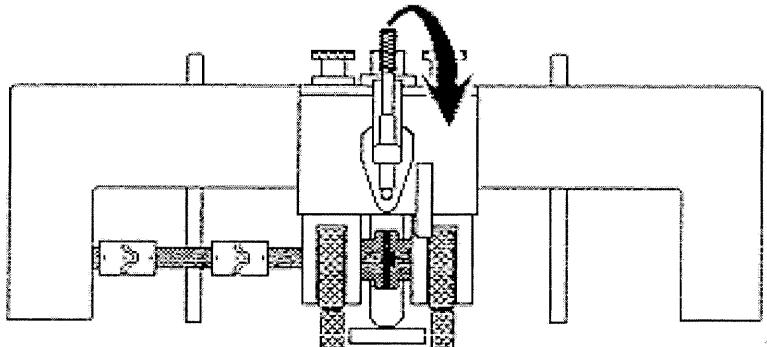
The switch that is open most often is the “jam microswitch” located on the skid bar (see Section 4.12). The second switch that is most often open is the conveyor stop button. If neither the machine nor the conveyor will run when the start button is depressed, check all the stop switches. If the machine will still not run, the problem must be isolated with a volt/ohm meter using the schematics and a qualified service person.



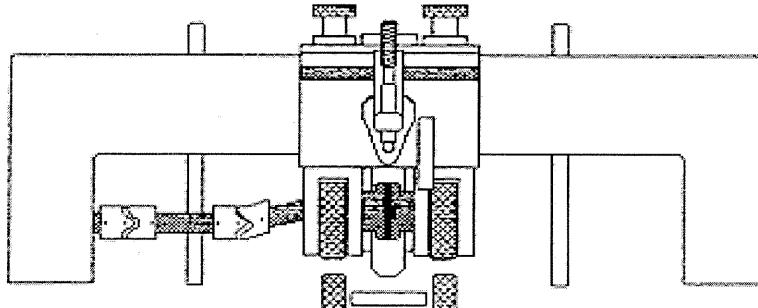
KR224 CONTROL PANEL
FIGURE 2.0

4.3 JAM RELEASE

The feeder bridge contains a “jam release” that allows the gate and top feed rollers to be raised in case of a double feed or jam. To engage the jam release, simply pull down on the handle. Be sure and push up the handle and lower the gate and feed rollers after the jam has been cleared and before continuing operation.



Jam release in up position with gate and feed rollers down.



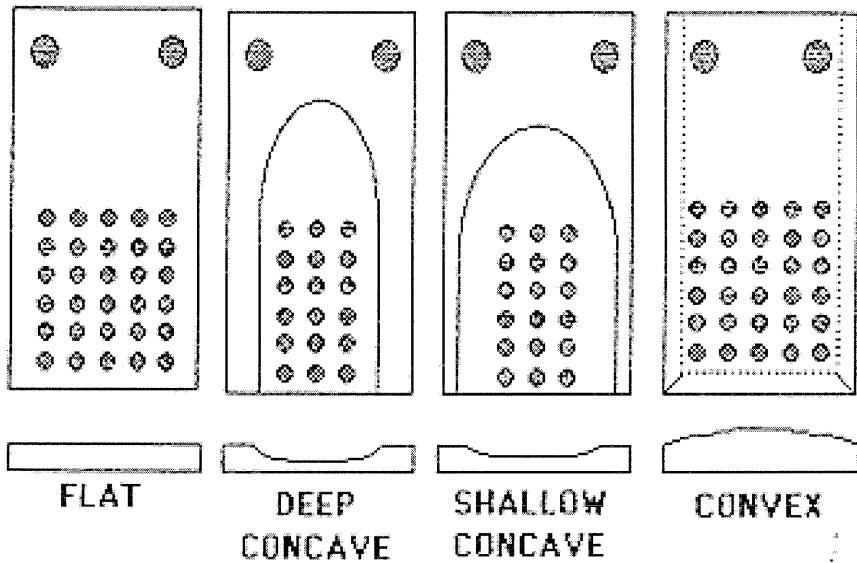
Jam release pulled down, raising gate and feed rollers.

4.4 SEQUENCE OF SET-UP

1. Perform daily maintenance.
2. Select and install proper vacuum plate.
3. Set upper feed rollers.
4. Adjust gate.
5. Engage needle blocks, lifters and/or pusher blocks.
6. Adjust feed hopper product guides and backstop.
7. Adjust tabletop belts.
8. Position tabletop side guides.
9. Position skid bar(s).
10. Adjust vacuum.
11. Set shuttle feeder speed.

4.5 VACUUM PLATES

Before setting up the feeder, the correct vacuum plate should be selected and installed. There are four vacuum plates available for the KR224.



FLAT PLATE: For thick product such as magazines and newspapers, any product that does not give or have bend to it.

DEEP CONCAVE PLATE: For thin product such as single sheets or flimsy product.

SHALLOW CONCAVE PLATE: For thicker product that has some flexibility.

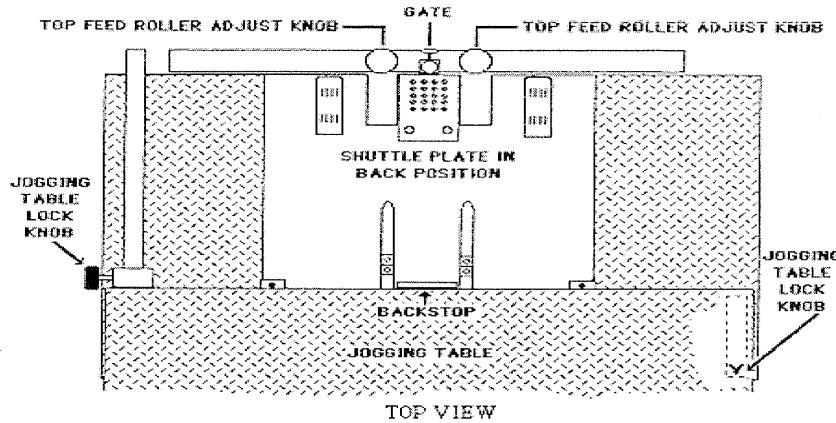
CONVEX PLATE: For tri-folded or self-mailers and can also be used for product that has a warp or bend. This plate is optional and not sent with machine.

To change vacuum plates, remove the two 5/32" hex head screws in the rear of the plate and lift the plate out from the shuttle on the feeder. Insert the desired plate and re-install the two screws.

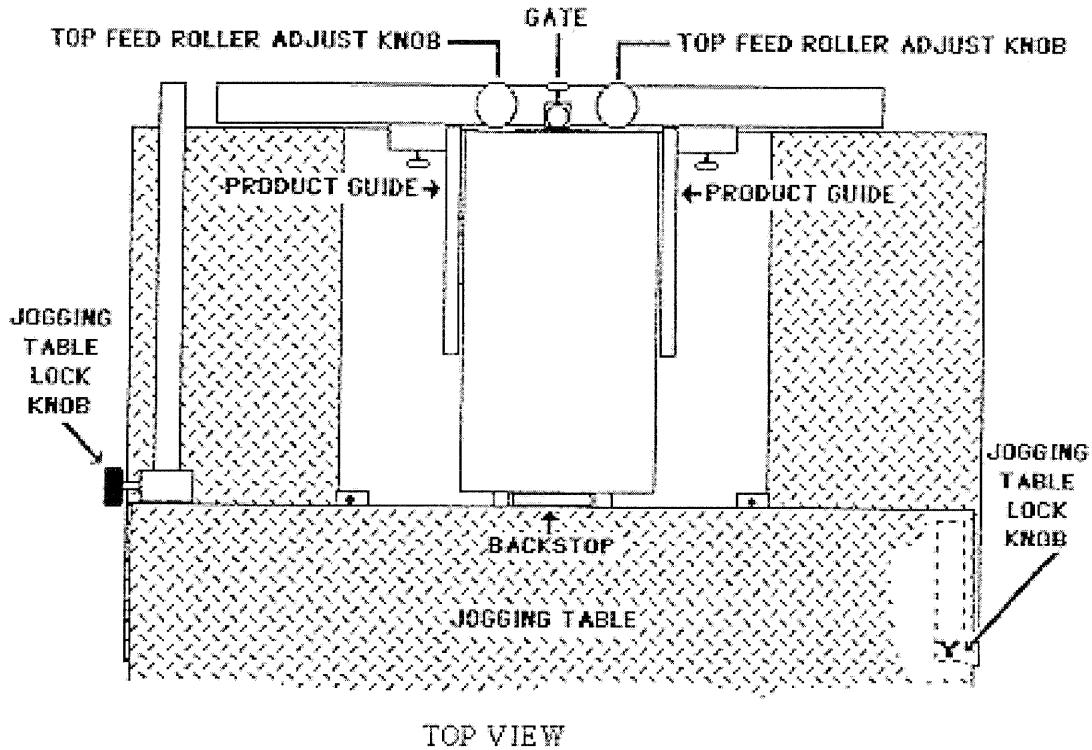
4.6 SHUTTLE/FEEDER SET-UP

To set up the feeder, loosen the back stop/jogging table and slide back. Loosen the two product guides and slide out from the center of the feeder.

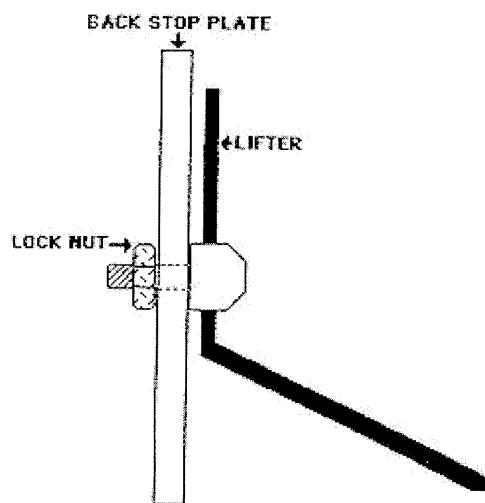
Rotate the machine by hand until the shuttle plate is in the extreme back position.



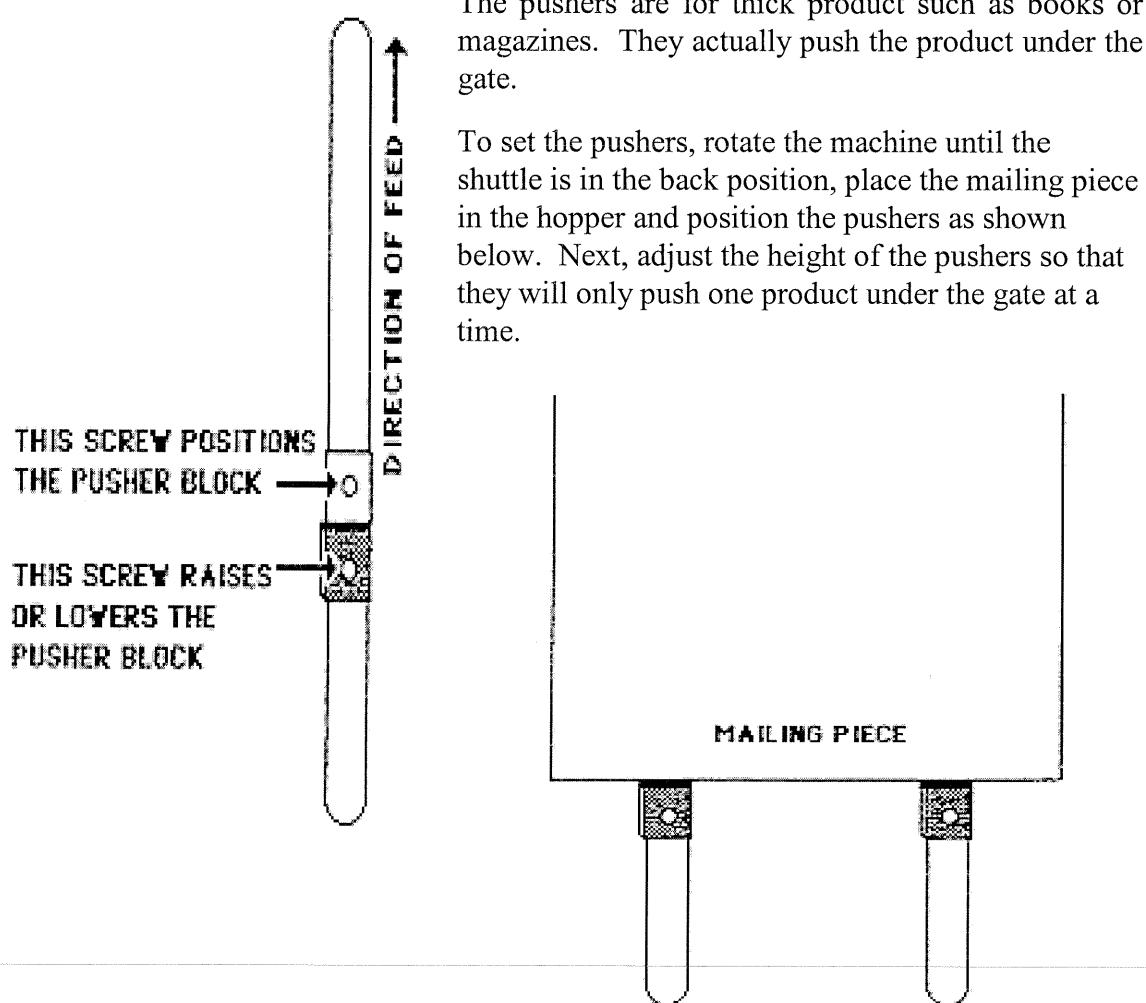
Place the product on the shuttle plate up against the gate. Bring the backstop up against the product and lock in place. Bring both product side guides in to the product. Allow approximately 1/8" play between guides and the product. Lock in place.



The feeder is equipped with lifters, and pushers to aid in the feeding of various products.

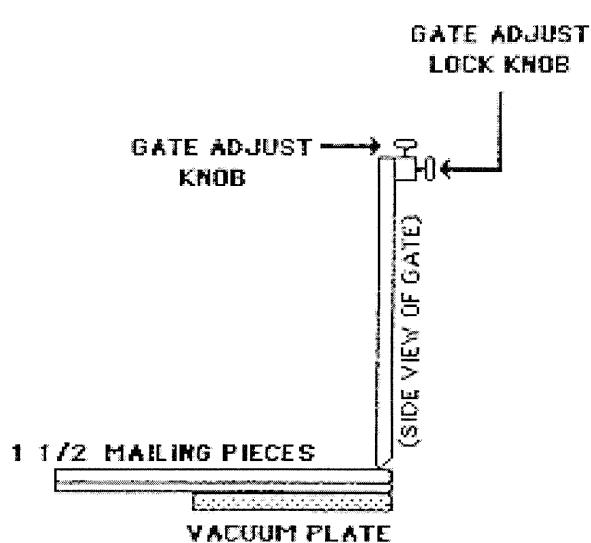


The lifters are designed to lift up the back of the product and angle the front edge toward the gate to aid in feeding. These are most commonly used for large products such as newspapers, magazines, and etc.



4.7 GATE SET-UP

To set the gate, loosen the gate lock knob and turn gate adjusts knob counter clockwise to raise the gate. Turn the main power and the feeder vacuum pump switches on. To rotate the gate, adjust the knob clockwise until the gate is snug against the mailing piece. (When setting up on a mailing piece that is two or more pages, the gate should be set snug to $1 \frac{1}{2}$ times the thickness of the mailing piece. Simply take $1 \frac{1}{2}$ pieces and place underneath the gate). After the gate is set, lock in place with the gate lock knob.



This should allow one piece to feed smoothly but keep two pieces from going under the gate at the same time. If two pieces are fed and the gate is set properly, the piece on top will jam or tear. If this happens, the problem is either the mailing pieces are stuck together or too much vacuum is being applied to the vacuum plate. To adjust the amount of vacuum being applied to the plate, see Section 4.8.

4.8 PRODUCT SPACING

Varying the speed of both the shuttle feeder and tabletop belts controls spacing of product.

An optimum speed should be obtained on the tabletop belts by adjusting the speed control. This optimum speed should be determined by the quality of the ink jet. Once this speed has been determined and set, the shuttle feeder speed can be determined.

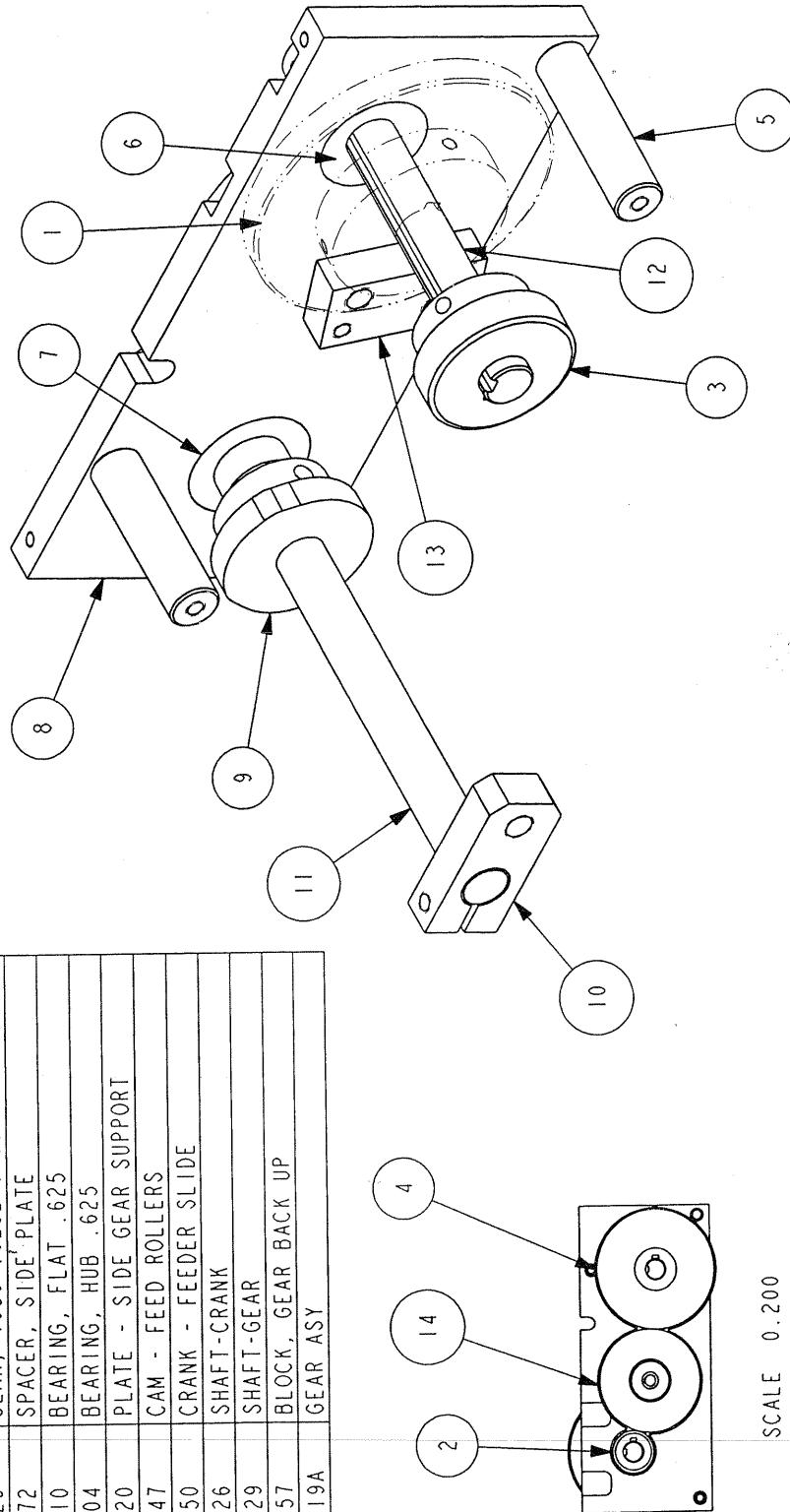
The shuttle feeder speed should be set to maintain a minimum spacing between the product being fed, allowing for maximum production. If the shuttle feeder speed is set too high, the products being fed will overlap and create problems with the ink jet.

For controls layout, see Figure 2.0.

22 IN. SPACING OPTION

For 22 in. spacing between the product, Change Gear Plate 22 in Assembly (535810-01) is used in place of Change Gear Plate 11 in Assembly (535812-01). See following page for 535810-01. This option is only with a labeler.

ITEM	QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	1	101760	GEAR, 2075 .625B .188K					
2	1	101913	GEAR, 1620 .625B .188K					
3	1	101916	GEAR, 1628 .625B .188K					
4	1	101920	GEAR, 1656 .625B .188K					
5	2	102672	SPACER, SIDE PLATE					
6	1	103110	BEARING, FLAT .625					
7	1	103804	BEARING, HUB .625					
8	1	500720	PLATE - SIDE GEAR SUPPORT					
9	1	500747	CAM - FEED ROLLERS					
10	1	500750	CRANK - FEEDER SLIDE					
11	1	500826	SHAFT-CRANK					
12	1	500829	SHAFT-GEAR					
13	1	500857	BLOCK, GEAR BACK UP					
14	1	101919A	GEAR ASSY					



NOTES:
1. FOR 22 IN SPACING.

I 535804-01
REV'D WHERE USED

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IN WHOLE OR IN PART WITHOUT THE
EXPRESS WRITTEN PERMISSION
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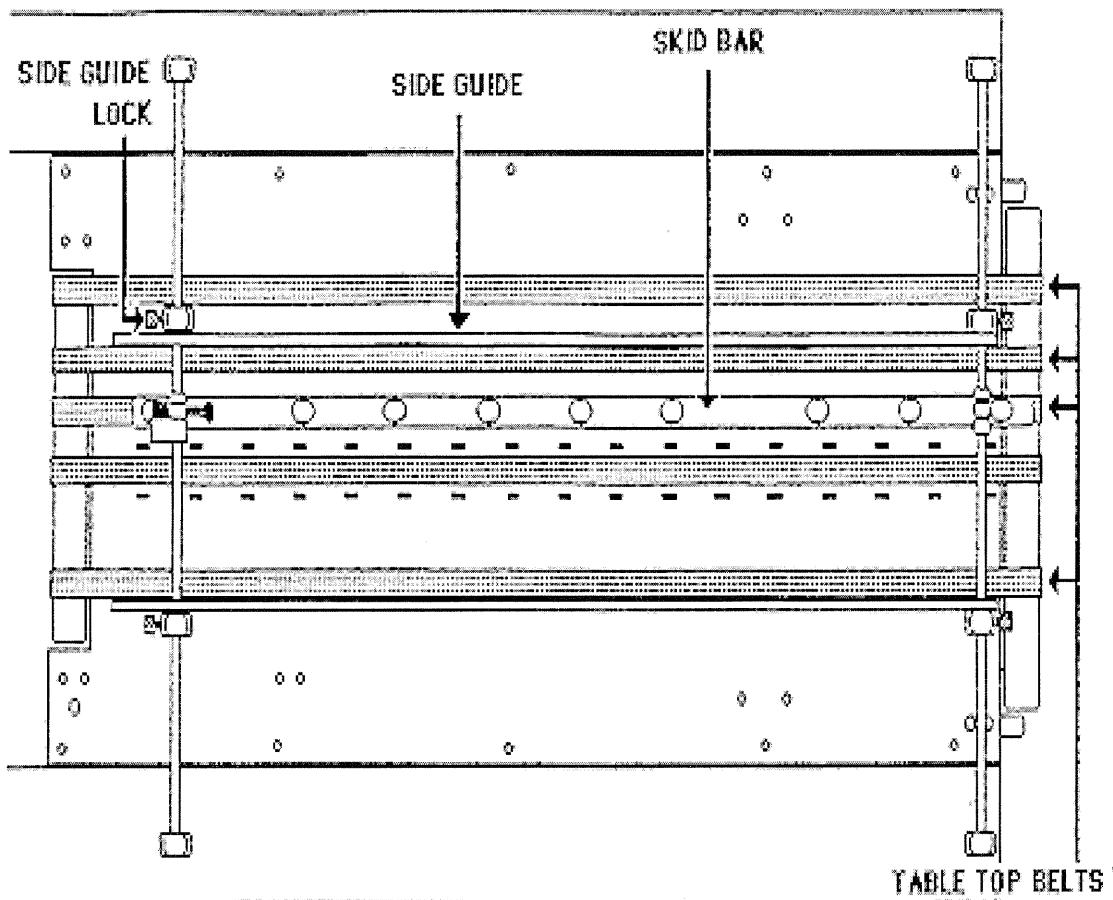


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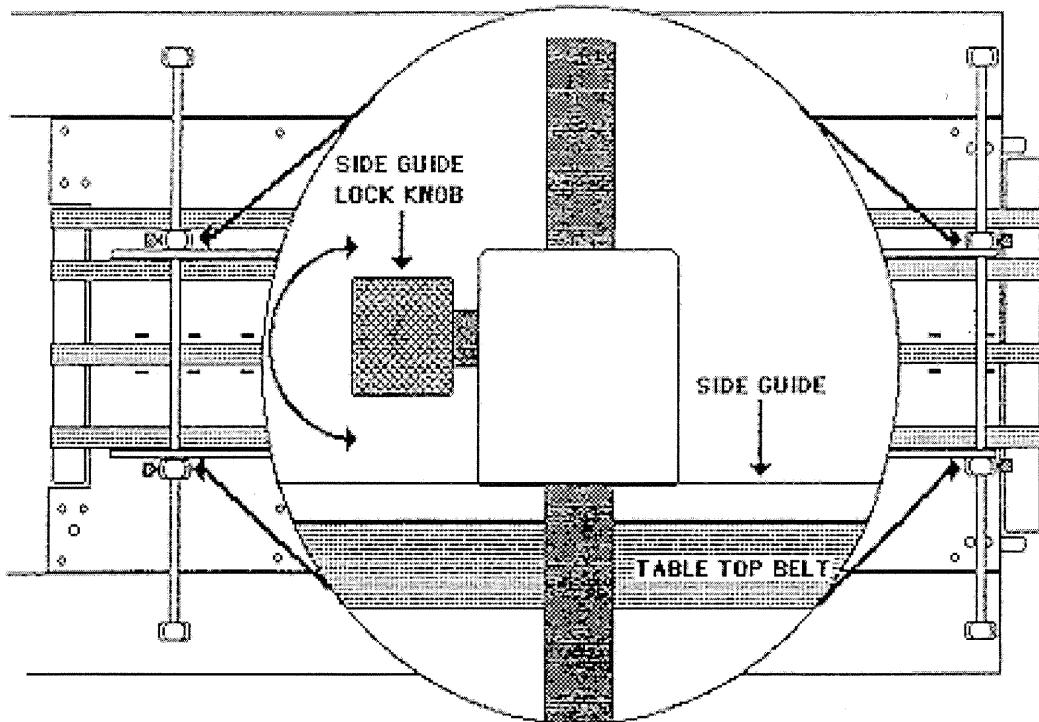
FILE: 151J
TITLE: ASSY, CHANGE GEAR PLATE 22IN
SHEET NO. 1 OF 1
DRAWING #

DRAWN BY:	SCALE	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	MATERIAL:	THIRD ANGLE PROJECTION	RECD'D WHERE USED
A Y B	0 .500	.01 .005 .5	N / A	⊕ ⊖	I 51J
DATE	29-Apr-99	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED	N / A		ASSY, CHANGE GEAR PLATE 22IN
CHECKED BY:		ALL DIMENSIONS ARE FINISHED DIRECTIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY	N / A		535810-01
TRACED BY:	MASTER				

4.9 SIDE GUIDES



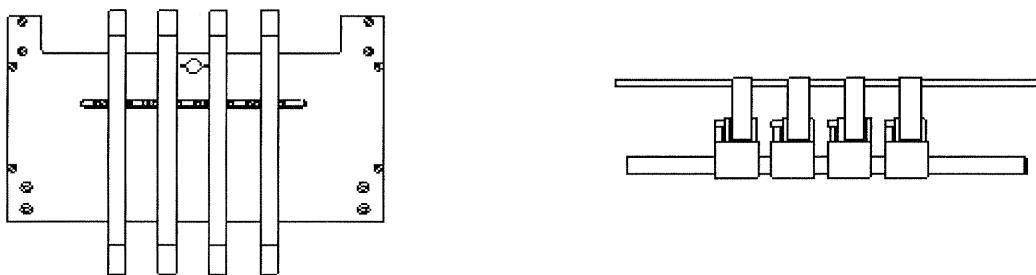
Once the product has been fed out through the feed rollers, the tabletop can be set. The first item to set up is the side guides. With the main power and feeder vacuum pump on, load the hopper and feed apiece out past the feed rollers. At this point, the two side guides can be brought in to either side of the piece with approximately 1/8" play on either side. The side guides are held in place with lock knobs that can be turned either way to lock the guides in place.



If the side guides are too tight, the mailing piece will not move across the tabletop. If they are too loose, the mailing piece may skew and the ink will be placed on crooked.

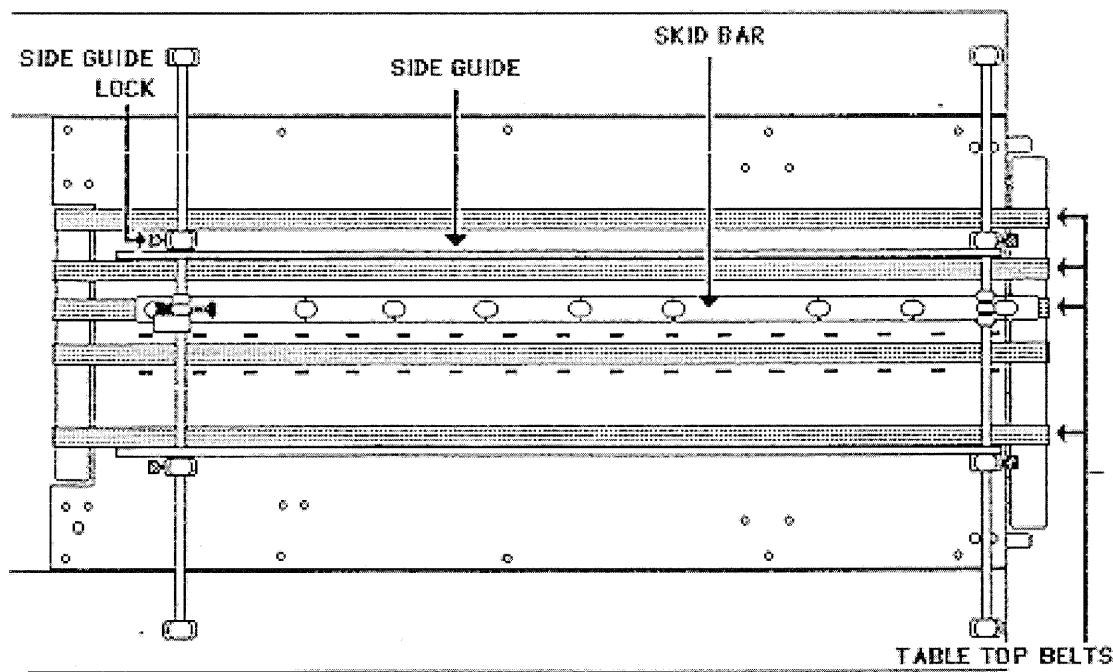
4.10 TABLETOP BELTS

The tabletop belts are designed to transport the product from the feed rollers onto the conveyor. There are four tabletop belts on the KR224. However, not all of them are needed for every product. You may run the belts that are not needed outside of the side guides. The guides can be adjusted from the top of the table through a slot with an allen wrench. NOTE: Caution should be taken when adjusting belts while the machine is in operation.



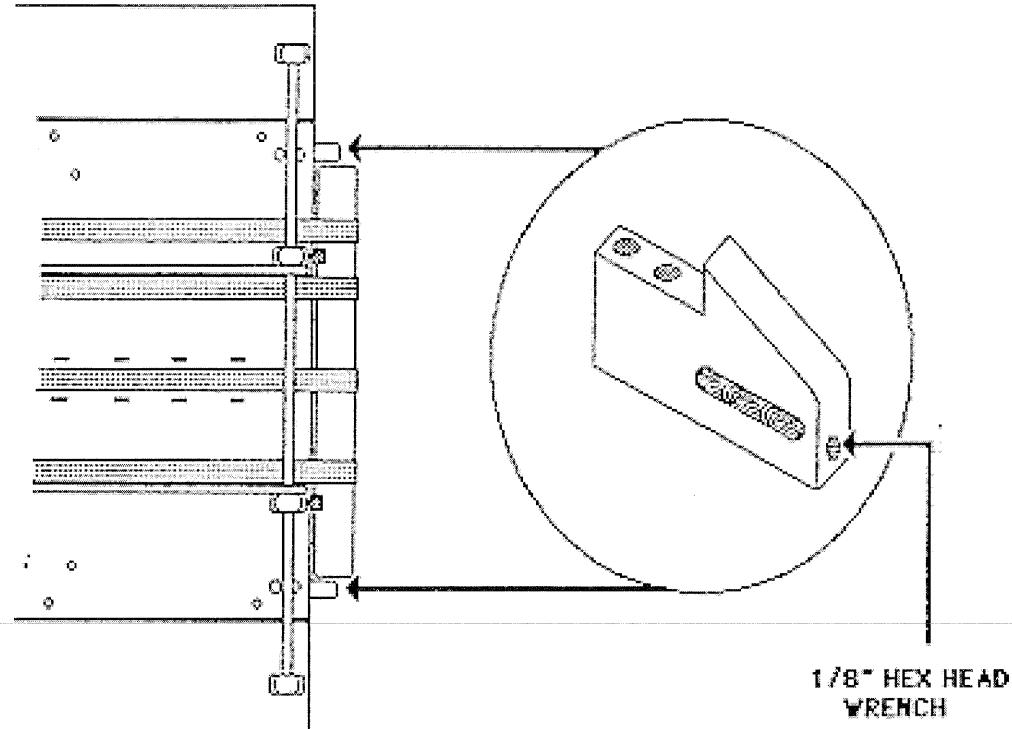
Each belt has its own guide. To move the belts, simply loosen the screw through the tabletop slot on the top of the belt guide and slide the guide on the shaft to the desired position and then tighten the screw.

The belts should be positioned so that there is a belt riding next to each side guide, and one underneath the skid bar.



The fourth and additional belts are normally used when running large product such as newspapers or heavy product such as magazines.

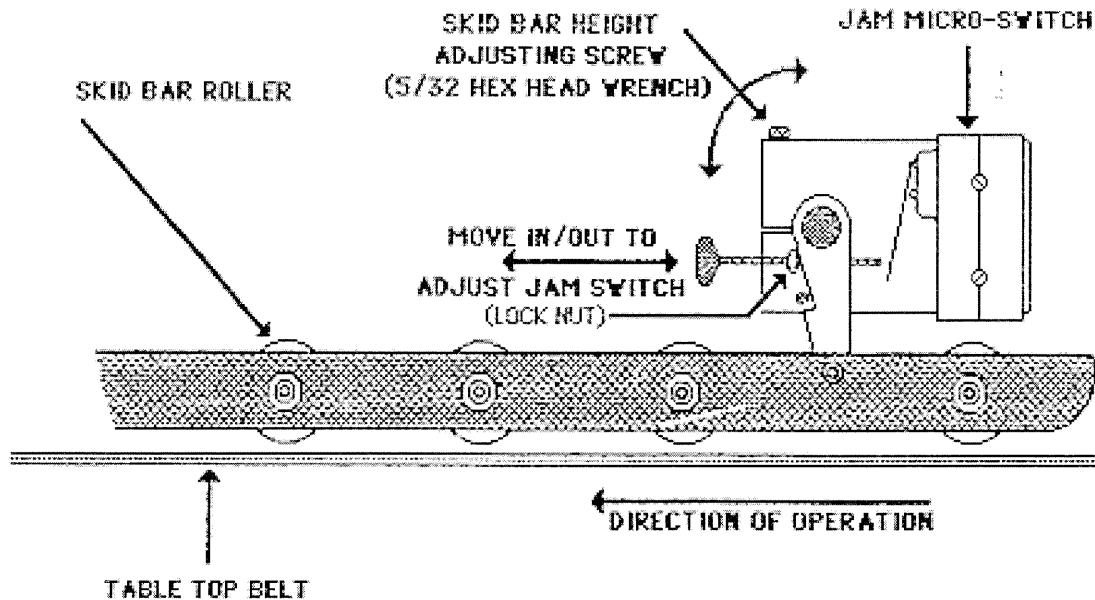
The tabletop belt tension can be adjusted. Caution should be taken not to over tighten. There should be just enough tension to prevent belt slippage.



4.11 SKID BAR

The skid bar rides on top of the product to help transport the mailing piece across the tabletop. The skid bar should be placed over one of the tabletop belts for best results. To move the skid bars locate and loosen the 1/8" hex head set screws in the lock collars on the right-hand side of the machine. The left-hand side of the machine has a lock collar and a skid bar block that is held in place with a 5/32" hex head screw. The KR224 is furnished with one skid bar, and is not needed when running small pieces such as cards or envelopes but can be installed when running large or heavy product.

Attached to one end of the skid bars is a "jam detector switch" on certain machines. This switch, when properly set, will stop the machine when a jam or double feed occurs.



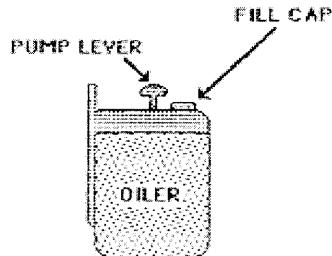
To set the skid bar, rotate the machine until a mailing piece is under the skid bar. Loosen the 5/32" hex head screw on the skid bar block. Adjust until the skid bar is resting on the mailing piece and the skid bar rollers rotate as the product is transported. Lock in place with the 5/32" hex head screw.

The jam switch is adjusted by loosening the lock nut, moving the adjustment knob in or out and tightening the lock nut. The microswitch should disengage and stop the machine when a jam or double feed occurs.

NOTE: The machine will not run if the jam switch is not set properly (see Section 4.2).

5 MAINTENANCE

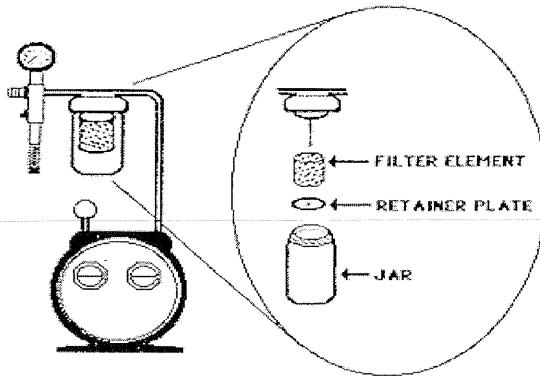
5.1 LUBRICATION



The operator should keep the KR224 clean and lubricated on a regular basis. The base has a central oiling system that only requires the operator to pull the pump lever on the oilier. This should be done every two hours of operation. The oil recommended is a 20 weight SAE machine oil.

5.2 DAILY MAINTENANCE

Item	Function	Remarks
Upper & Lower Feed Rollers	Remove glazing and all other foreign materials from feed surfaces.	Use alcohol.
Base (General)	Remove excessive paper dust, ink, glue, and all other foreign materials from the tabletop and inside of	Use clean soft rag. (Dampen with water if necessary.)
Vacuum Pump Filters	Remove paper dust.	Wrap edge of filter against a hard surface or vacuum. If unable to clean replace with new filter.
Vacuum Pump Filters Jars	Clean jars thoroughly.	Use warm water and dry thoroughly. CAUTION: Improper replacement of cracked rims of jars can result in a loss of vacuum. Insure jar is installed correctly and has a proper seal.
Vacuum Body and Vacuum Valve	Clean feeder vacuum body & valve thoroughly.	Blow out with air hose.
Internal Filters	Clean or replace	Clean by blowing out



6 DIAGRAMS AND PARTS LISTS

6.1 DIAGRAMS

DRAWING #	DESCRIPTION
. KR224	ASSY, KR224
. 548081-01	ASSY, 224 FEEDER
. 531022-01	ASSY, LOWER FEED ROLLER
. 531102-01	ASSY, HUB GEAR
. 530619-01	ASSY, IDLER ROLLER
. 531274-01	ASSY, FRONT ROLLER DRIVE
. 530676-01	ASSY, ROLLER FRONT DRIVE
. 531106-01	ASSY, HUB
. 535812-01	ASSY, CHANGE GEAR PLATE 11IN
. 101919A	GEAR ASY
. 531021-01	ASSY, SHUTTLE TABLE
. 500728A	ASSY, BUSHING BLOCK
. 500708A	ASSY, VACUUM BODY
. 500751A	ASSY, BEARING BLOCK
. 531105-01	ASSY, GEAR
. 531405-07	ASSY, JOGGER TABLE
. 500714-A	ASSY, REAR BRIDGE
. 500764AL	ASSY, LIFTER
. 500764AR	ASSY, LIFTER
. 500880A	ASSY, BRACKET
. 541202-01	ASSY, BRIDGE TIMING BELT
. 541203-01	ASSY, BRIDGE
. 500814-1A	ASSY, SIDE GUIDE RAIL
. 531582-01	EG ASSY, BRIDGE DRIVE AND GATE
. 531584-01	EG ASSY, FORK
. 500811A	ASSY, FORK WITH BEARINGS
. 500811	FORK ASY
. 500745A	ASSY, UPPER FEED ROLLER
. 500744	SHAFT - TOP ROLLER ASSY
. 500743	SHAFT - TOP ROLLER DRIVE
. 535412-01	ASSY, SIDE GUIDE
. 500755AL	ASSY, SIDE GUIDE LH
. 500755AR	ASSY, SIDE GUIDE RH
. 102119-A	ASSY, KNOB
. 100800	ASSY, UNIVERSAL JOINT
. 100800-1	ASSY, UNIVERSAL JOINT
. 538572-01	ASSY, SIDEGUIDE & SKIDBAR
. 500800-A	ASSY, LINK
. 500801A	ASSY, LINK
. 500802A	ASSY, CLAMP

. 541992-01	ASSY, 3/4 BELT GUIDE
. 500760-A	ASSY, LIFTER FEEDER PUSHER
. 548080-01	ASSY, KR224 CABINET & COVERS
. 538038-05	ASSY, 224 CONTROL PANEL
. 531168-01	ASSY, 3/4 HP VACUUM PUMP
. 509000-8A	ASSY, MTR/REDUCER SR 1/2HP VERT

6.2 PARTS LIST

See following pages for parts list.

Quantity	Drawing #	Description
1	100109	BUSHING, SL1.000ID1.250OD1.500LG
1	100131	BUSHING, SL.250ID.375OD1.250LG
8	100145	BUSHING, SL.625ID.813OD1.000LG
2	100162	BUSHING, SL.500ID.625OD.625LG
2	100400	WASHER, THRUST TW31
2	100402	WASHER, THRUST TB612
2	100409	WASHER, THRUST
2	100601	WASHER, FLAT .500
2	101100	BEARING, ONEWAY .375
1	101760	GEAR, 2075 .625B .188K
1	101914	GEAR, 1640 .625B .188K
1	101915	GEAR, 1628 .750B .188K
2	101916	GEAR, 1628 .625B .188K
1	101917	GEAR, 1621 .625B .188K
2	101918	GEAR, FEED ROLLER DRIVE
2	101919	GEAR, 1648 1.124B NK
1	101920	GEAR, 1656 .625B .188K
1	102112	KNOB
1	102114	KNOB
1	102117	KNOB
3	102119	KNOB
3	102205	COLLAR .500
3	102225	COLLAR .250
1	102345	SHIM, .375X.625X.125
2	102672	SPACER, SIDE PLATE
2	102700	SPRING, COIL
3	102701	SPRING
6	103106	BEARING, FLAT .375
4	103107	BEARING, FLAT .312
4	103108	BEARING, FLAT .500
1	103110	BEARING, FLAT .625
1	103405	CAM FOLLOWER
1	103500	BEARING - ROD END
4	103803	BEARING, HUB .500
1	103804	BEARING, HUB .625
2	103805	BEARING, HUB .750
3	103812	BEARING, HUB .625
2	104400	BOLT - HEX HEAD
1	105026	V-PULLEY, MAVR. 2200
1	105201	PIN, ROLL .125X 1.000

1	105400	DOWEL, PIN .188X1.250
1	105601	SHAFT, THREADED 3/8-16
2	106702	NUT, 3/8-16
2	107104	BOLT, SHOULDER 5/16X3/4
1	108888	PULLEY, TIMING 12L050 .625B.188K
2	109521	OIL METER UNIT
1	109523	JUNCTION, 2-WAY
1	109524	JUNCTION, 3-WAY
2	109528	NUT, COMPRESSION FEMALE
2	109537	SLEEVE, COMPRESSION
1	190600	SPIDER - ROLLER DRIVE
1	190606	FITTING - 90 DEG 1/4 NPT
4	190634	FOOT, MOUNTING
1	190637	OIL PUMP
1	190660	NIPPLE, 1/2 IN TUBING
2	190669	CASTER, 3.500 RIGID
2	190670	CASTER, 3.500 SWIVEL
1	190685	LEVER - QUICK RELEASE
1	190769	MAGNET, BUNTING
4	191001	LATCH
4	191008	ANGLE, LEVELING LEG
4	191009	INSERT, LEVELING LEG
4	191010	LEVELING BOLT, CABINET
1	200102	VALVE, RELIEF GAST 822/823
1	200108	STEM GAST 822/823
1	200109	PLATE GAST 822/823
1	200124	PUMP, VACUUM GAST
3	209016	KNOB, POT
1	500708	BODY, VACUUM VALVE
1	500709	PLATE - VACUUM FEEDER
1	500714	BRIDGE - READ GUIDE
1	500715	PLATE - REAR CENTER GUIDE
2	500716	BRACKET - BELT TAKE-UP
1	500718	HUB - SHAFT BEARING
1	500720	PLATE - SIDE GEAR SUPPORT
4	500721	GUSSET - TABLETOP SUPPORT
1	500728	BRACKET - FEEDER
1	500730	PLATE, GATE FEEDER
1	500734	LEVER - CAM
1	500735	ROD - PUSH
2	500737	WASHER - BUMPER
1	500738	SPRING - VALVE
1	500739	BLOCK - PUSHER
1	500740	PLATE - VACUUM
2	500741	SHAFT - FEEDER

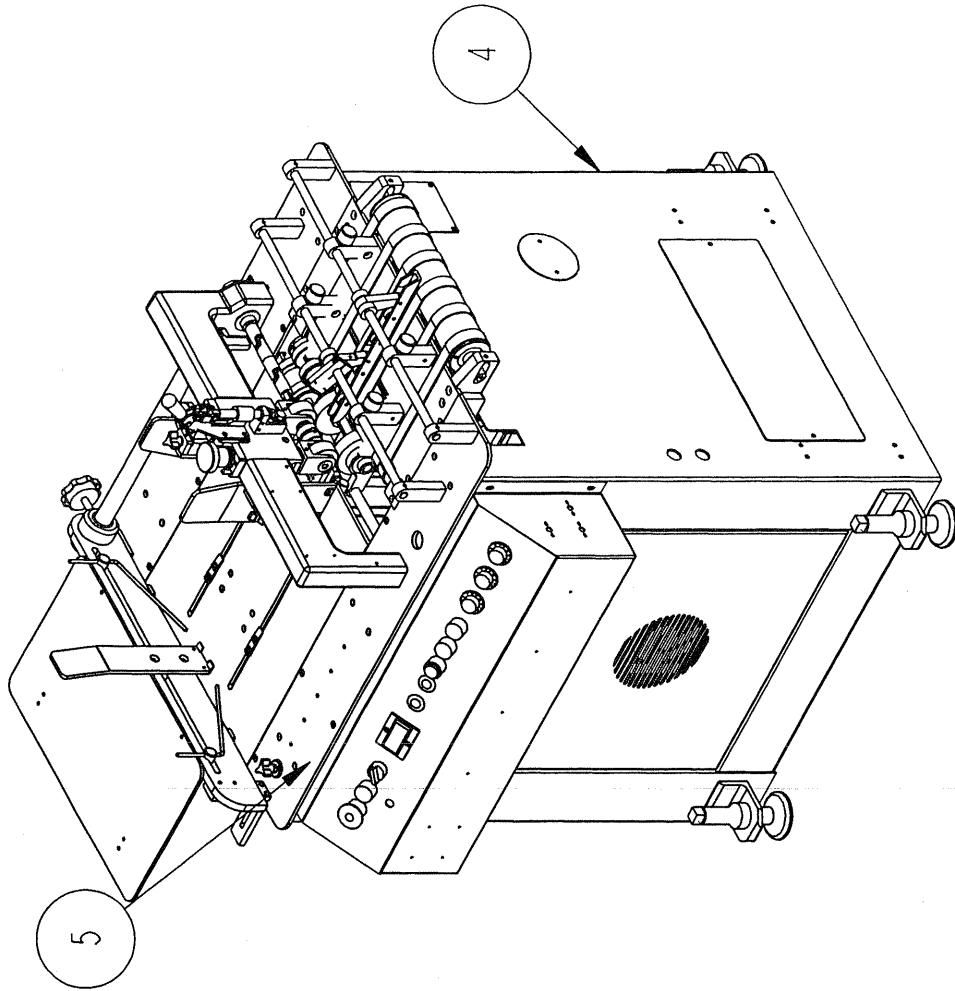
2	500745	ROLLER, UPPER
2	500746	ROLLER - BOTTOM FEED
1	500747	CAM - FEED ROLLERS
1	500749	ROD - FEEDER SLIDE
1	500750	CRANK - FEEDER SLIDE
1	500751	YOKE - FEEDER CRANK
2	500755	CLAMP - SIDE GUIDE
2	500760	LIFTER- FEEDER PUSHER
2	500762	PLATE-FEEDER PUSHER BOTTOM
2	500764	LIFTER - REAR BRIDGE
2	500766	SCREW - MACHINE REAR GUIDE
1	500769	SHAFT - REAR GUIDE
1	500770	HUB - REAR GUIDE SHAFT
6	500771	CLIP-SIDE GUIDE
2	500775	PLATE-FEEDER PUSHER TOP
1	500786	LEVER, SPRING
2	500787	SHAFT-SIDE GUIDE ADJ.
4	500791	POST, SIDEGUIDE
4	500792	POST, SIDE GUIDE
4	500793	LOCK, SIDE GUIDE CAM
1	500800	LINK-SKID-FRONT
1	500801	LINK-SKID-REAR
1	500802	HOLDER-SKID SWITCH
2	500805	PLATE - HOLD DOWN
1	500806	PLATE - GATE END
2	500807	NUT - LOCK
2	500809	SLEEVE - THREADED
1	500810	SHAFT - SCREW ADJ
2	500812	KNOB, ROLLER ADJUSTMENT
1	500817	SHAFT-GEAR SPUR
1	500823	SHAFT, IDLER ROLLER
1	500824	SHAFT-BELT GUIDE
1	500826	SHAFT-CRANK
1	500829	SHAFT-GEAR
2	500832	BRACKET-REAR-GUIDE
1	500835	ROLLER, BELT IDLER
2	500836	HUB
2	500839	HUB-BELT DRIVE
1	500845	TABLE, JOGGER
2	500847	BRACE, COMPUTER FORM REST
1	500857	BLOCK, GEAR BACK UP
2	500859	SPACER
1	500865	COVER - GEAR
1	500878	SUPPORT - JOGGER TABLE
1	500880	BRACKET - JOG TABLE SUPP

1	501645	BLOCK, CONNECTOR (VACUUM PUMP)
1	502405	TABLETOP, CENTER
1	502408	CHANNEL, SKID BAR
1	503619	SHAFT
1	503622	HUB, GEAR
1	509006	PLATE-REAR SIDE
1	509007	PLATE-GEARBOX 1/2 HP SINGLE RED
1	509037	COVER, REDUCER
2	100800-1_1	UNIVERSAL
2	100800_1	UNIVERSAL
2	100800_3	UNIVERSAL
1	101707-1	GEAR, 2048 .500B NK
1	102200-2	COLLAR
1	105000-1	V-PULLEY
6	105921-4	BELT, 3/4 X 26.5 GREEN
1	106029-8	V BELT, AX41
1	108912-1	BELT, TIMING 187L050
1	109319-1	PULLEY, TIMING 32L050 .625B .188K
1	200012A	COUNTER, LCD 310
1	200100-1	GAUGE, VACUUM GAST 822/823
1	200100-2	FILTER, VACUUM GAST 822/823
1	200100-3	JAR, GLASS GAST 822/823
1	200100-13	NIPPLE, STEEL
1	200100-14	ELBOW, PIPE GAST 822/823
1	200100-16	COUPLING GAST 822/823
1	200100-21	NIPPLE, STEEL
1	200100-22	COUPLING, STEEL
1	200100-23	PLUG, SQUARE HEAD GAST 822/823
1	200100-26	COVER FOR AB992 GAST 822/823
2	200124-2	FILTER, FELT GAST 823
2	200124-4	END CAP, AK510 GAST 823
1	200124-5	MUFFLER, SINTERED GAST 823
2	200124-6	O-RING, GASKET GAST 823
1	200152-2	MOTOR, LEESON DC 1/2HP
2	200373-6	PLUG, .875
1	201124-2	BUTTON, START
1	201124-4	BUTTON, POWER ON
1	201125-3	BUTTON, STOP
1	201125-5	BUTTON, POWER OFF
1	201126-1	BUTTON, JOG
1	201145-1	SELECTOR, 2 POSITIONS
1	500710-1	BRACKET - FEEDER SUPPORT
1	500721-1	GUSSET, CUTOUT
1	500729-4L	ARM, FEEDER CRADLE HUBBRG LH
1	500729-4R	ARM, CRADLE FEEDER HUBBRG RH

1	500742-4	ROLLER, TUBE BELT DRIVE
1	500743_2	SHAFT - TOP ROLLER
2	500744_5	COLLAR- TOP ROLLER SHAFT
1	500744_6	SHAFT - TOP ROLLER
1	500748-1	SHAFT - FEEDER ROLLER
1	500788-18L	SIDEGUIDE, FEEDER W/ ROLLERS LH
1	500788-18R	SIDEGUIDE, FEEDER W/ROLLERS RH
1	500795-1	PLATE - BACK
1	500799-3	CLAMP - MOUNTING PLATE
1	500799-5	BLOCK, CLAMP SUPPORT
2	500799-6	STUD, BRIDGE (LONG)
2	500799-7	STUD, BRIDGE (SHORT)
1	500799_2	BLOCK - CONNECTOR
1	500803-1	SHAFT, UNIVERSAL
1	500808-1	PLATE, TOP BRIDGE
2	500814-1	RAIL - SIDEGUIDE
2	500814-2	RAIL - SIDE GUIDE
2	500819-1	BLOCK, BEARING
1	500825-1	SHAFT
1	500827-1	SHAFT, SPRING LEVER
1	500828-1	SHAFT - FRONT ROLLER
1	500863-12	TABLETOP, WIDE SHUTTLE
1	501410-1	PANEL, SIDE COVER
1	502401-1	PLATE, BASE SUPPORT R.H.
1	502402-3	PLATE, BASE SUPPORT LH
1	502403-1	TABLETOP, R/H SIDE
1	502404-1	TABLETOP, SIDE 224 LH
1	502409-L	RAIL, GUIDE
1	502409-R	RAIL, GUIDE
1	528247-5	BOX, 219 CONTROL
1	530182-02	BRIDGE - FEEDER
1	530253-01	RING
1	530441-01	BOX, ELECTRICAL INLET 20A
1	530592-01	ANGLE, SUPPORT
1	530592-02	ANGLE, SUPPORT
2	530593-03	CHANNEL, CROSS
1	530865-02	PANEL, ELECTRICAL
2	530866-01	DOOR, LOUVER LOCK
1	530983-02	PLATE, 224 CABINET COVER
1	531155-01	PLATE, MAGNETIC
2	531672-01	BAR, FORK
2	531673-01	YOKE
1	532130-01	GUARD, SHUTTLE
1	532582-01	PLATE, VACUUM HOSE COVER
1	535167-01	BOX, OILER

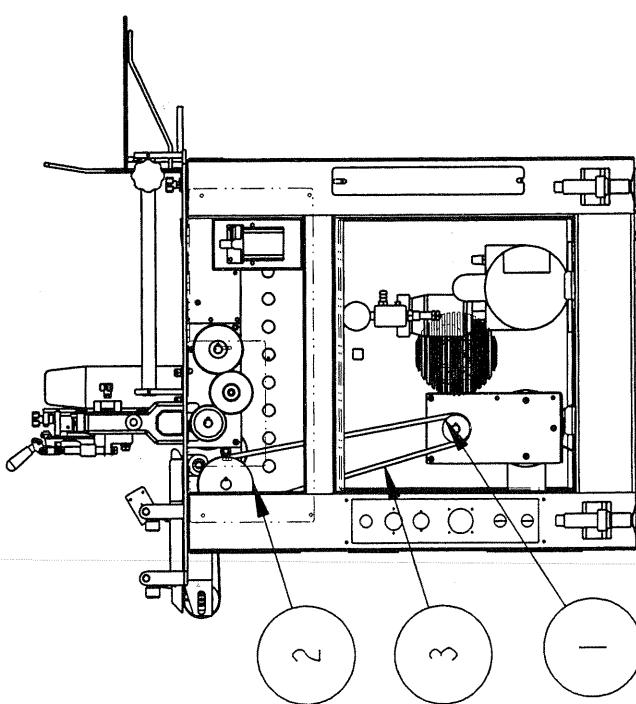
1	537344-02	COVER, LIFT KIT HOLE
1	541166-01	SHAFT, BRIDGE DRIVE
1	541204-01	COVER, HUB BEARING
6	541989-01	GUIDE, BELT 3/4
1	545092-01	BASE, CABINET
1	545093-01	PANEL, INFEED END
1	545094-01	PANEL, OUTFEED END
1	546573-01	COVER
5	SP16208	SPACER, REDUCER
1	SP6383-1	SPACER, GEAR COVER

ITEM QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	105026	V-PULLEY, MAVR. 2200					
2	105000-1	V-PULLEY					
3	106029-8	V BELT, AX41					
4	548080-01	ASSY, KR224 CABINET & COVERS					
5	548081-01	ASSY, 224 FEEDER					



1	KR224
REQ'D	WHERE USED

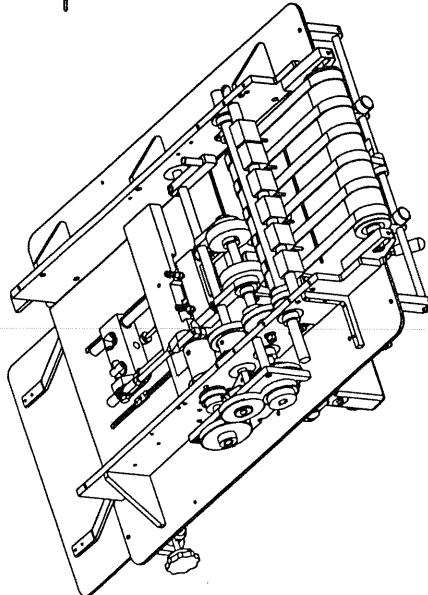
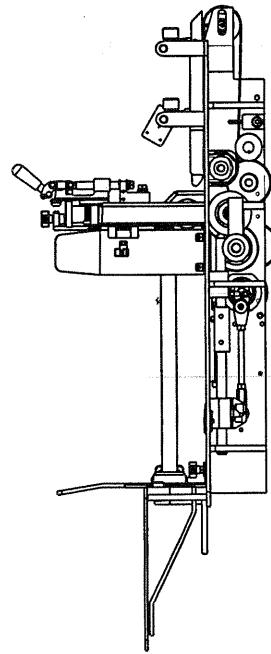
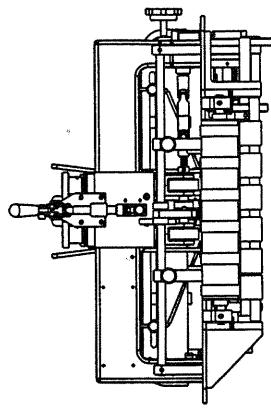
PROPRIETARY AND CONFIDENTIAL	
NO PORTION OF THIS DRAWING	
MAY BE QUOTED OR REPRODUCED	
IN ANY FORM WITHOUT THE	
EXPRESS WRITTEN PERMISSION	
OF KIRK-RUDY INC.,	
KENNESAW, GA 30144 U.S.A.	
TITLE:	
ASSY, KR224	
DRAWING #	
SCALE	0 . 080
MATERIAL:	N / A
DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	
.XX	.XXX
.01	.005
ANG.	.5
HEAT TREAT:	N / A
FINISH:	N / A
MODEL:	KR224
SHEET NO.	OF 4



DRAWN BY: CMC	SCALE 0 . 100	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	
CHECKED BY:	DATE 17 - Mar - 05	.XX	.XXX
		.01	.005
		ANG.	.5
TRACED BY:	MASTER <i>m</i>	REMOVE ALL BURS AND SHARP EDGES UNLESS OTHERWISE NOTED	ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY

ITEM NO.	PART #	DESCRIPTION	REV. NO.	DATE	ECN NO.	BY
1	100402	WASHER, THRUST TB612				
2	101915	GEAR, 168.750B .188K				
3	2	03805				
4	3	103812				
5	4	103812				
6	5	500721				
7	6	500817				
8	7	500824				
9	8	502405				
10	9	102119-A				
11	10	105921-4				
12	11	GUSSET, CUTOUT				
13	12	500760-A				
14	13	ASSY, LITTER FEEDER PUSHER SHAFT				
15	14	500853-1/2				
16	15	TABLETOP, WIDE SHUTTLE PLATE, BASE SUPPORT R.H.				
17	16	502402-3				
18	17	PLATE, BASE SUPPORT LH				
19	18	502403-1				
20	19	TABLETOP, R/H SIDE				
21	20	502404-1				
22	21	TABLETOP, SIDE 224 LH				
23	22	530619-01				
24	23	ASSY, IDLER ROLLER				
25	24	531021-01				
26	25	ASSY, SHUTTLE TABLE				
27	26	531022-01				
28	27	ASSY, LOWER FEED ROLLER				
29	28	531105-01				
30	29	ASSY, GEAR				
31	30	531106-01				
32	31	ASSY, HUB				
33	32	ASSY, FRONT ROLLER DRIVE				
34	33	531405-07				
35	34	ASSY, JOGGER TABLE				
36	35	5358.2-01				
37	36	ASSY, CHANGE GEAR PLATE 11IN				
38	37	538512-01				
39	38	ASSY, SIDEGUIDE & SLIDEBAR				
40	39	541202-01				
41	40	ASSY, BRIDGE TIMING BELT				
42	41	541992-01				
43	42	ASSY, 3/4 BELT GUIDE				
44	43	541990-2				
45	44	NUT, HEX 3/8				
46	45	SPACER, GEAR COVER				

SCALE 0.090

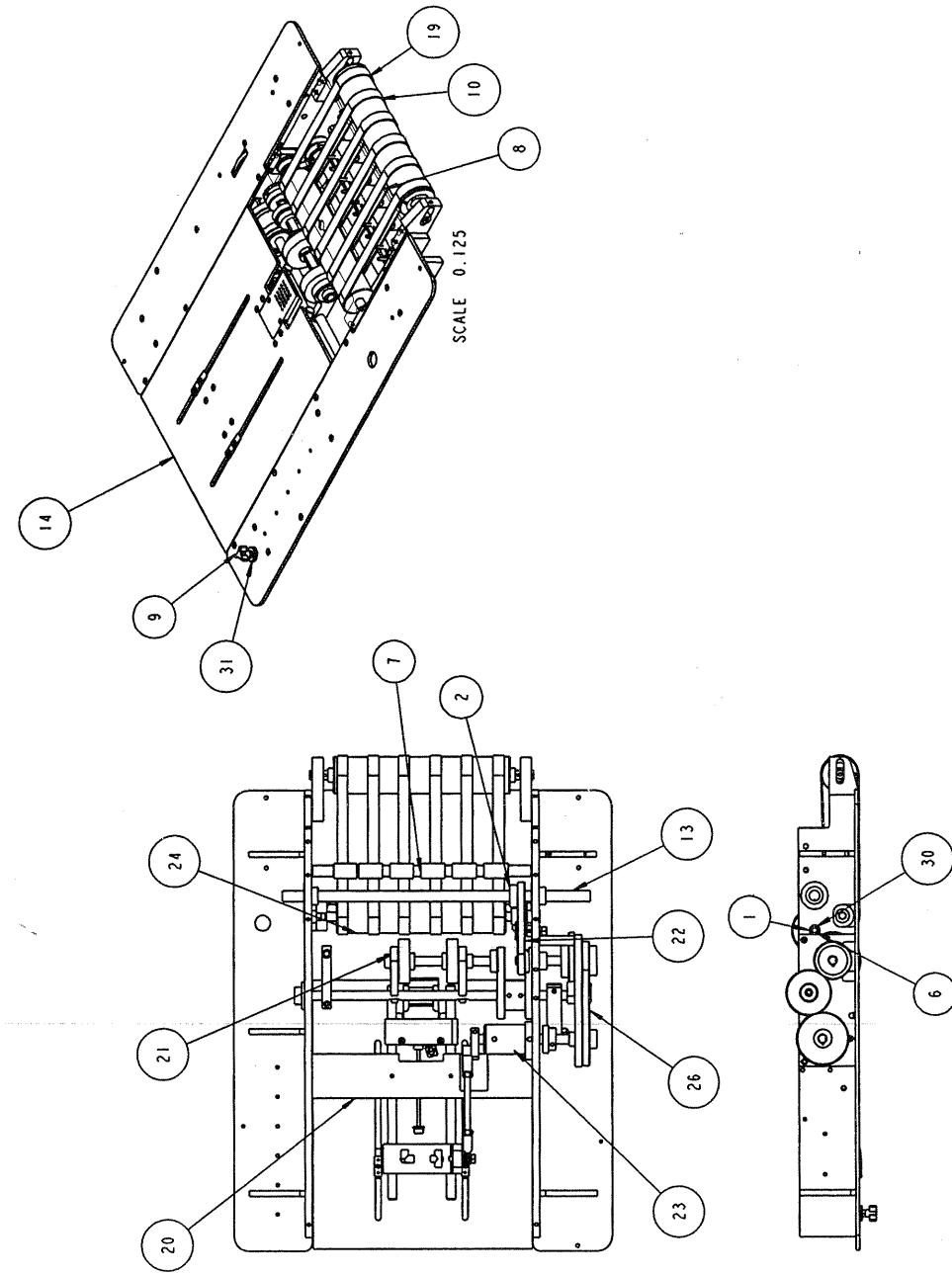


REF ID:	CMC	SCALE	0 .125	DIMENSIONS IN INCHES UNLESS OTHERWISE NOTED	XXX	TRIM LINE PROJECTION	PROPRIETARY AND CONFIDENTIAL
CHECKED BY:		DATE		IN. MM		XXXX	NO COPIES OR QUOTATIONS OF THIS DRAWING OR SPECIFICATIONS MAY BE MADE WITHOUT THE EXPRESSED WRITTEN CONSENT OF KIRK-RUDY INC., WOODSTOCK, GA 30188 USA
TRADED BY:	MASTER	7 - Mar - 05		IN. MM	XXX	KKR 224	ASSY, 224 FEEDER
REMOVED BY:				IN. MM	XXX	20F4	548081-01
REMOVED DATE:							

REF ID:	KRK	KRK - RUDY, INC
REF ID:	KKR	WOODSTOCK, GEORGIA

ITEM NO.	PART #	DESCRIPTION	REV NO.	DATE	ECN NO.	BY
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ITEM NO.	PART #	DESCRIPTION
1	100402	WASHER, THRUST TB612
2	101915	GEAR, 1628 .750B .185K
3	2 103805	BEARING, HUB .750
4	3 103812	BEARING, HUB .625
5	4 500712	GUSSET - TABLETOP SUPPORT
6	1 500617	SHAFT-GEAR SPUR
7	1 500824	SHAFT-BELT GUIDE
8	1 502405	TABLETOP, CENTER
9	1 102119-A	ASSY, KNOB
10	6 10392-4	BELT, 3/4 X 26.5 GREEN
11	1 500721-1	GUSSET, CUTOUT
12	2 500760-A	ASSY, LIFTER FEEDER PUSHER
13	1 500825-1	SHAFT
14	1 500863-12	TABLETOP, WIDE SHUTTLE
15	1 502401-1	PLATE, BASE SUPPORT R.H.
16	1 502402-3	PLATE, BASE SUPPORT LH
17	1 502403-1	TABLETOP, RH SIDE
18	1 502404-1	TABLETOP, SIDE 22-LH
19	1 530619-01	ASSY, IDLER ROLLER
20	1 531021-01	ASSY, SHUTTLE TABLE
21	1 531022-01	ASSY, LOWER FEED ROLLER
22	1 531105-01	ASSY, GEAR
23	1 531106-01	ASSY, HUB
24	1 531274-01	ASSY, FRONT ROLLER DRIVE
25	1 531405-07	ASSY, JOGGER TABLE
26	1 533612-01	CHANGE GEAR PLATE LIN
27	1 538512-01	ASSY, SIDEGUIDE & SKIDBAR
28	1 541202-01	ASSY, BRIDGE TIMING BELT
29	6 541992-01	ASSY, 3/4 BELT GUIDE
30	1 RH0012	NUT, HEX 3/8
31	1 SP6383-1	SPACER, GEAR COVER

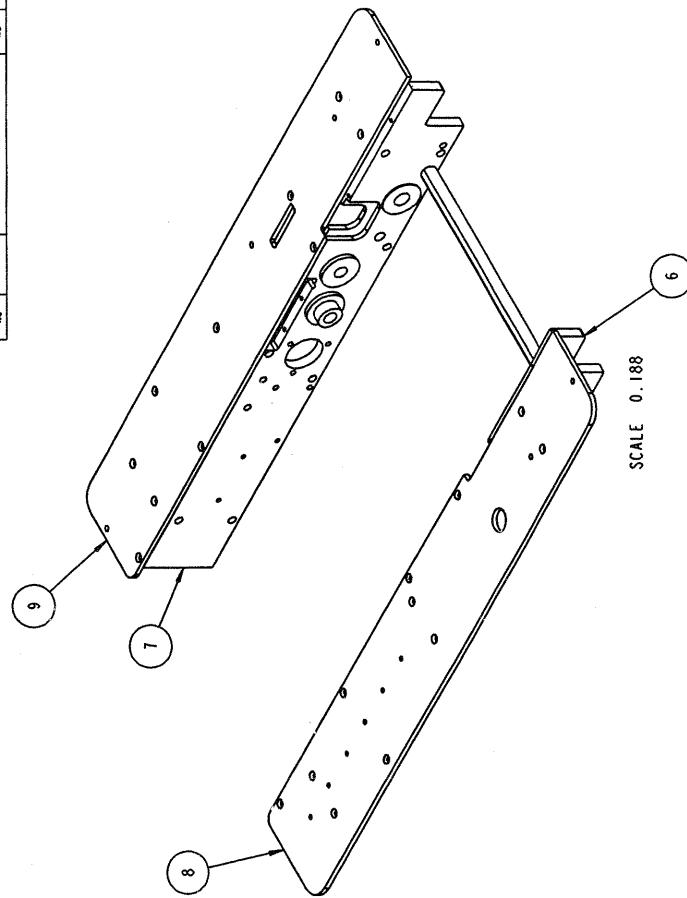


1	KR224
REO	WHERE 1510
KIRK - RUDY, INC.	
WOODSTOCK, GEORGIA	
ASSY, -224 FEEDER	
SCALE:	0.125
CMC	0.125
DATE:	17-Mar-05
CHECKED BY:	
TRACED BY:	M
PRINTED:	TOF4
REVISION:	548081-01

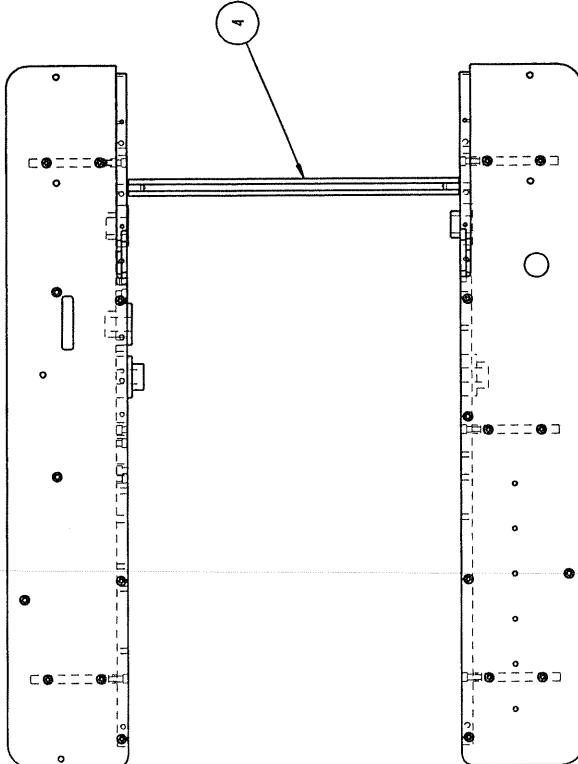
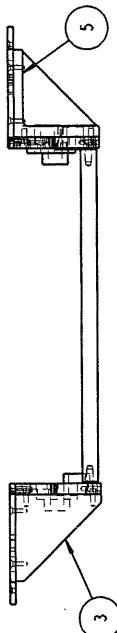
Drawing #

548081-01

ITEM NO	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	2	103805 BEARING, HUB .750					
2	3	103812 BEARING, HUB .625					
3	4	500121 GUSSET - TABLETOP SUPPORT					
4	1	500824 SHAFT-BELT GUIDE					
5	1	500121-1 GUSSET, CUTOUT					
6	1	502401-1 PLATE, BASE SUPPORT R.H.					
7	1	502402-3 PLATE, BASE SUPPORT L.H.					
8	1	502403-1 TABLETOP, R/H SIDE					
9	1	502404-1 TABLETOP, SIDE 224 LH					



SCALE 0.188



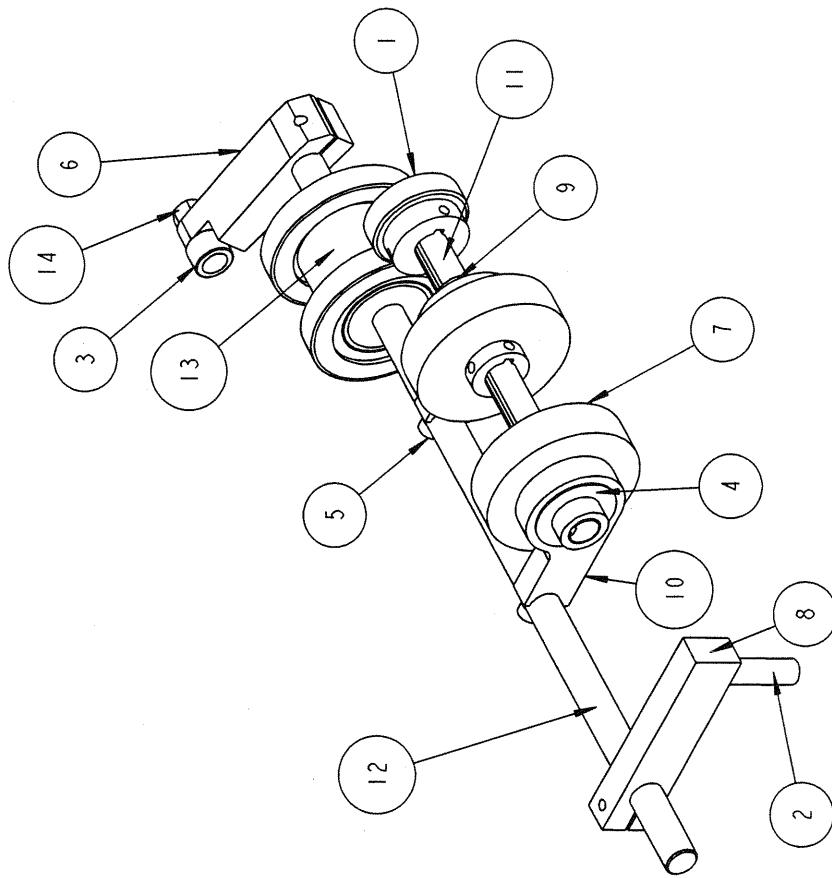
1	KR224	RECD WHERE USED
KIRK - RUDY, INC WOODSTOCK, GEORGIA		
ITEM:	KR 224	ASSY, 224 FEEDER
SCALE:	0.188	SCALE 0.188
DRAWN BY:	CMC	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED
MADE BY:	17-Mar-05	XX X
REVIEWED BY:		XX X
APPROVED BY:		XX X
PRINTED BY:		XX X
MASTER:	M	ALL DIMENSIONS ARE IN INCHES. NOT SCALE - DRAW DIMENSIONS ONLY
TRACED BY:		30F 4

Drawing #

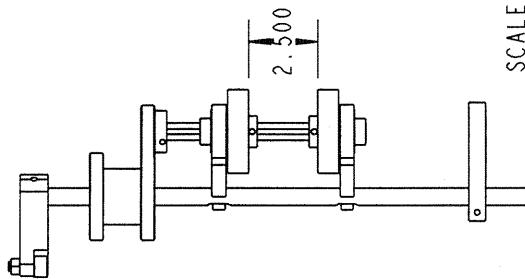
548081-01

DRAWING • 531022-01

ITEM QTY	PART #	DESCRIPTION
1	101916	GEAR, 1628 .625B .188K
2	102701	SPRING
3	103405	CAM FOLLOWER
4	2 103804	BEARING, HUB .625
5	2 107104	BOLT, SHOULDER 5/16X3/4
6	1 500734	LEVER - CAM
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 500748-1	SHAFT - FEEDER ROLLER
12	1 500827-1	SHAFT, SPRING LEVER
13	1 531102-01	ASSY, HUB GEAR
14	1 RHNO12	NUT, HEX 3/8



SCALE 0.156



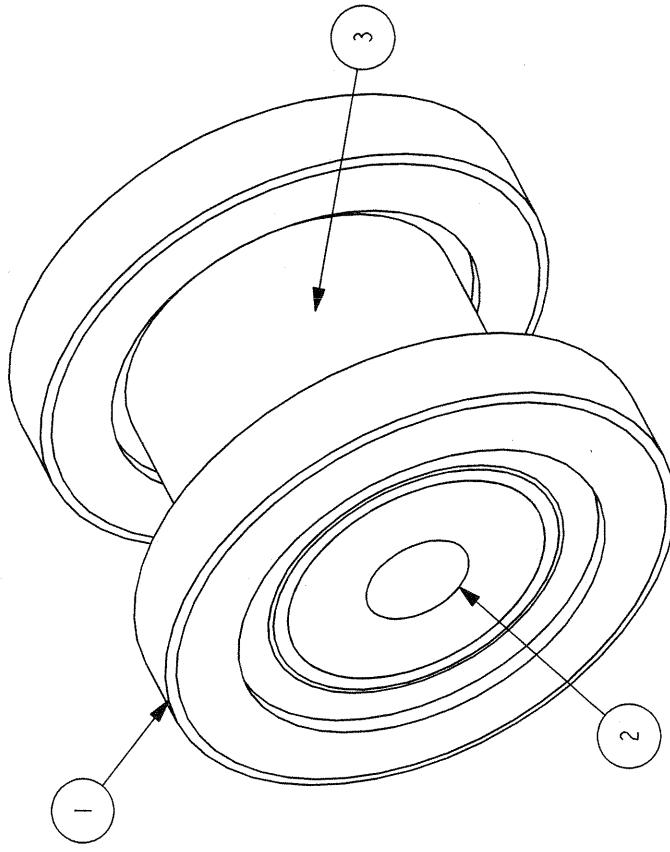
REV NO	DATE	DESCRIPTION	ECN NO	BY
1	11/24/2000	REPLACE 500729-2 WITH 500729-4 REPLACE FLAT BRG W/ HUB BRG	6624	TJG

I	536173-01
REQ'D	WHERE USED

KIRK - RUDY, INC.
KENNESAW, GEORGIA

DRAWN BY: TVK	SCALE 0 .313	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
DATE 04-May-98	.XX .XXX .01 .005 .5	ANG. HEAT TREAT:	XXX	MODEL: XXX	TITLE: ASSY, LOWER FEED ROLLER
CHECKED BY:		FINISH:	XXX	SHEET NO.: XXX	DRAWING #
TRACED BY:	MASTER M	DO NOT SCALE - WORK TO DIMENSIONS ONLY	OFF 1		531022-01

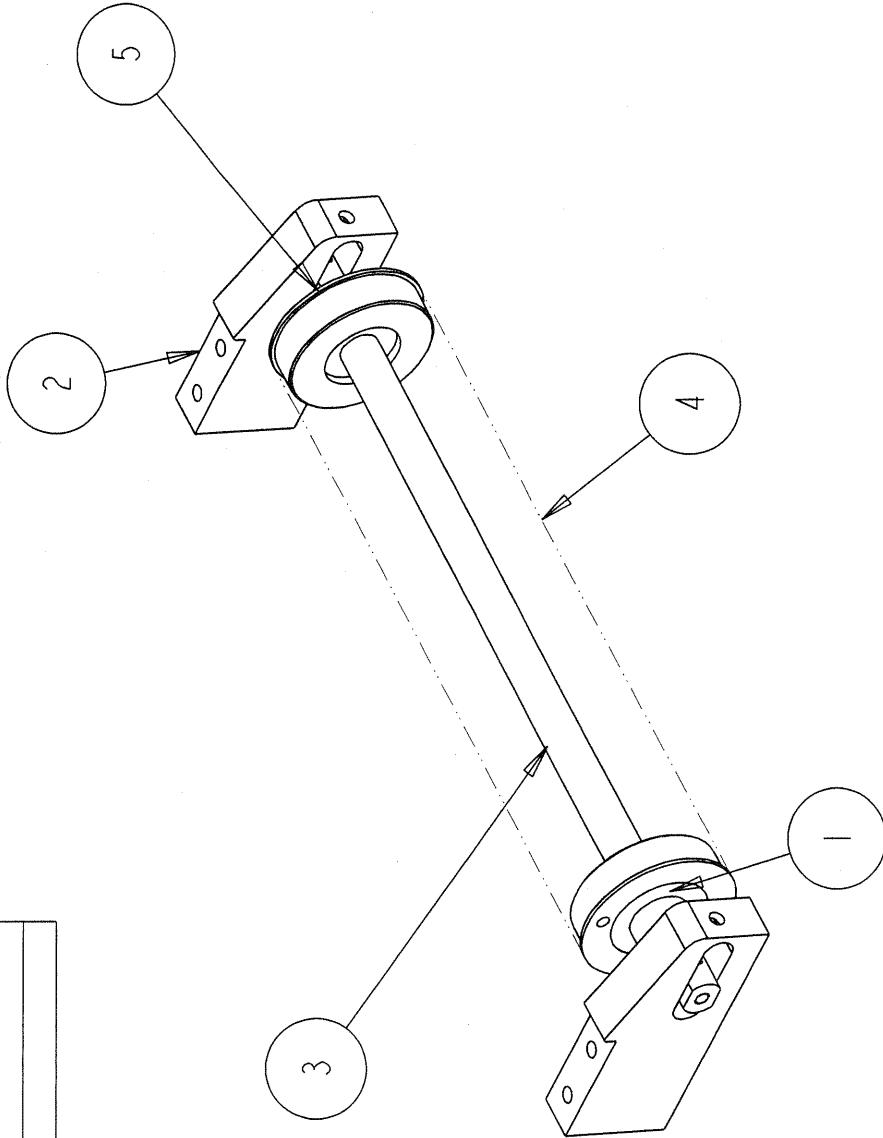
ITEM QTY	PART #	DESCRIPTION
1 2	101918	GEAR, FEED ROLLER DRIVE
2 2	103804	BEARING, HUB .625
3 1	503622	HUB, GEAR



ITEM	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	2	101918					
2	2	103804					
3	1	503622					

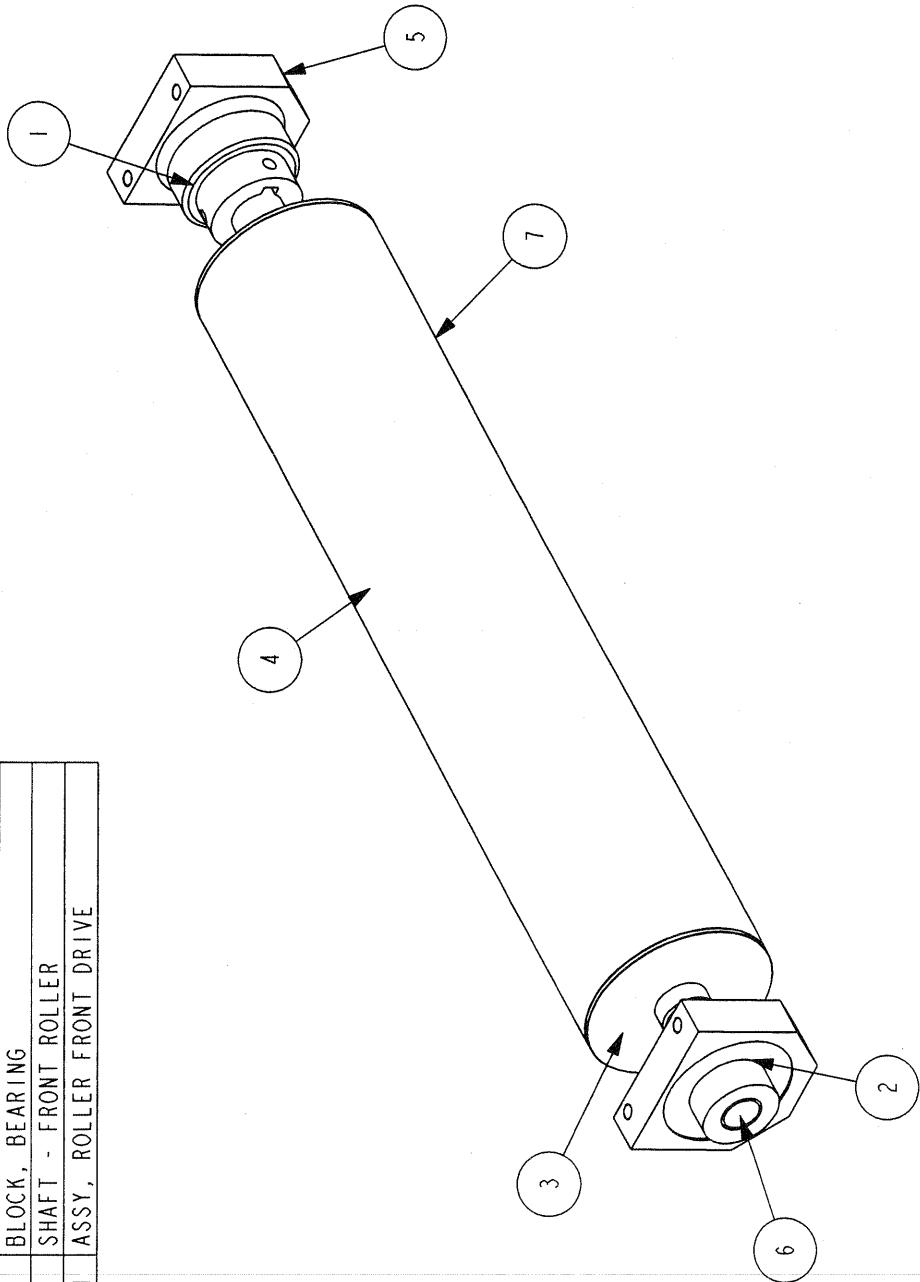
DRAWN BY:	SCALE	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED		THIRD ANGLE PROJECTION	PROPRIETARY AND CONFIDENTIAL NO PART OF THIS DRAWING MAY BE COPIED OR REPRODUCED IN WHOLE OR IN PART WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC. KENNESAW, GA 3044 USA
M.Y	1	.000	N/A		KIRK - RUDY, INC. KENNESAW, GEORGIA
CHECKED BY:	DATE	.xx	.xxx	HEAT TREAT:	MODEL: 215
	12 - Apr - 99	.01	.005	N/A	TITLE: ASSY, HUB GEAR
TRACED BY:	MASTER	FINISH: ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY		SHEET NO.: 1 OF 1	DRAWING #
	M				531102-01

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
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	THIRD ANGLE PROJECTION
MODEL: SP71700	TITLE: ASSY, IDLER ROLLER
SHEET NO.: 1 OF 1	DRAWING #
MADE BY: TVK	SCALE 0 .375
DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	MATERIAL: N/A
.XX .XXX .01 .005 .5	HEAT TREAT: N/A
REMOVED ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED	FINISH: N/A
ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE WORK TO DIMENSIONS ONLY	
DATE 02 - Mar - 99	
MASTER M	

ITEM QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	101917	GEAR, 1621 .625B .188K					
2	103803	BEARING, HUB .500					
3	2	HUB-BELT DRIVE					
4	1	500742-4 ROLLER, TUBE BELT DRIVE					
5	2	500819-1 BLOCK, BEARING					
6	1	500828-1 SHAFT - FRONT ROLLER					
7	1	530676-01 ASSY, ROLLER FRONT DRIVE					

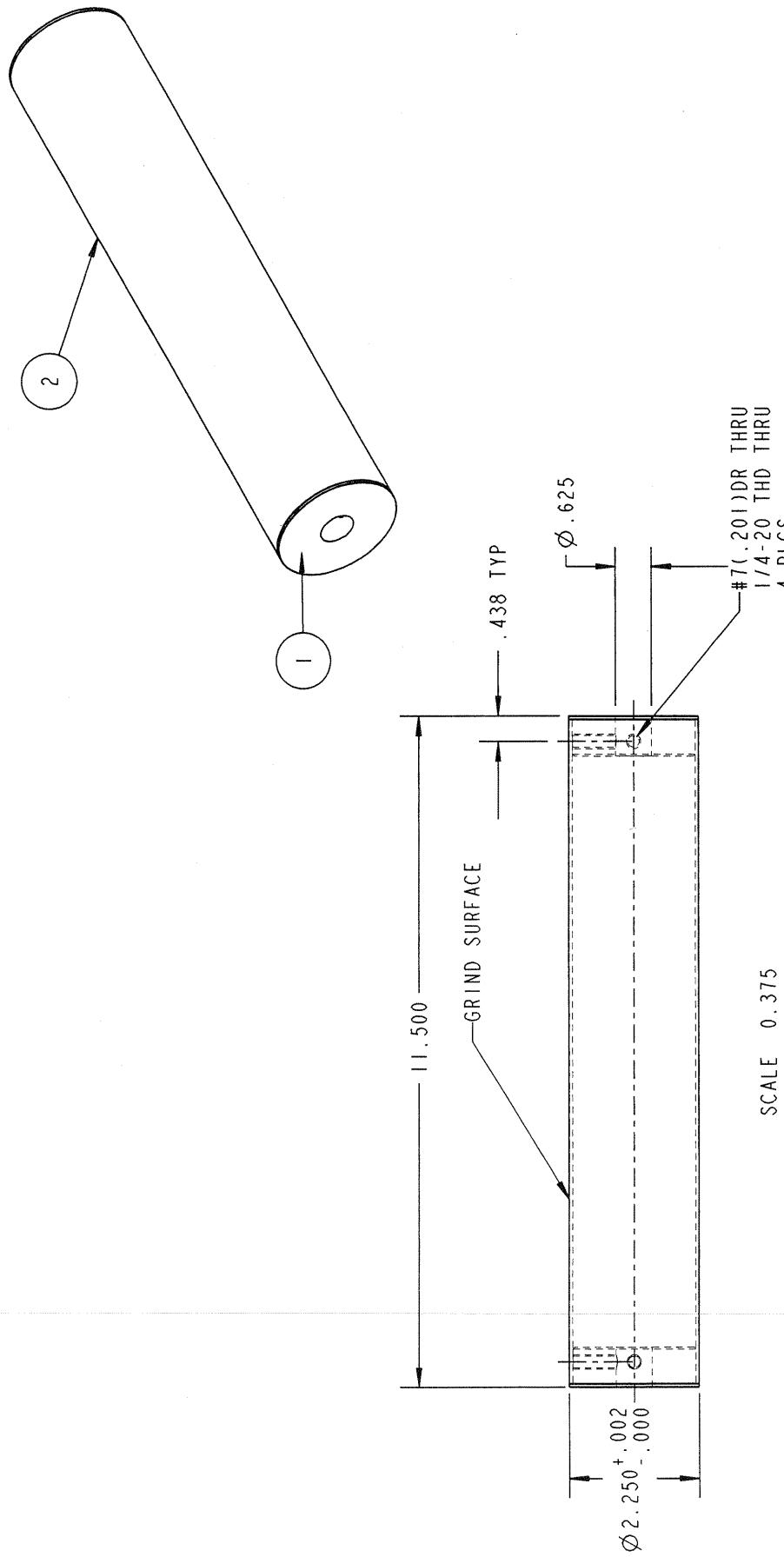


1	535289-01
REQ'D	WHERE USED
KIRK - RUDY, INC.	
KENNESEE, GEORGIA	
PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE QUOTED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY KENNESEE, GA 30144 USA	
THIRD ANGLE PROJECTION	ORTHOGRAPHIC
MATERIAL:	N/A
DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	
SCALE	0 .500
DATE	09 - Apr - 99
CHECKED BY:	
MASTER	M
TRACED BY:	
REMOVED ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED	HEAT TREAT:
.01 .005 .5	N/A
ALL DIMENSIONS ARE FINISHED DIMENSIONS	FINISH:
DO NOT SCALE, WORK TO DIMENSIONS ONLY	N/A
TITLE: ASSY, FRONT ROLLER DRIVE	
SHEET NO.: 10F1	DRAWING #
531274-01	

DRAWING # 530676-01

ITEM	QTY	PART #	DESCRIPTION
1	2	500839	HUB-BELT DRIVE
2	1	500742-4	ROLLER, TUBE BELT DRIVE

REV NO	DATE	DESCRIPTION	ECN NO	BY
1	10/5/2004	ADDED GRIND SURFACE AND OD TOLERANCE	7100	T.G



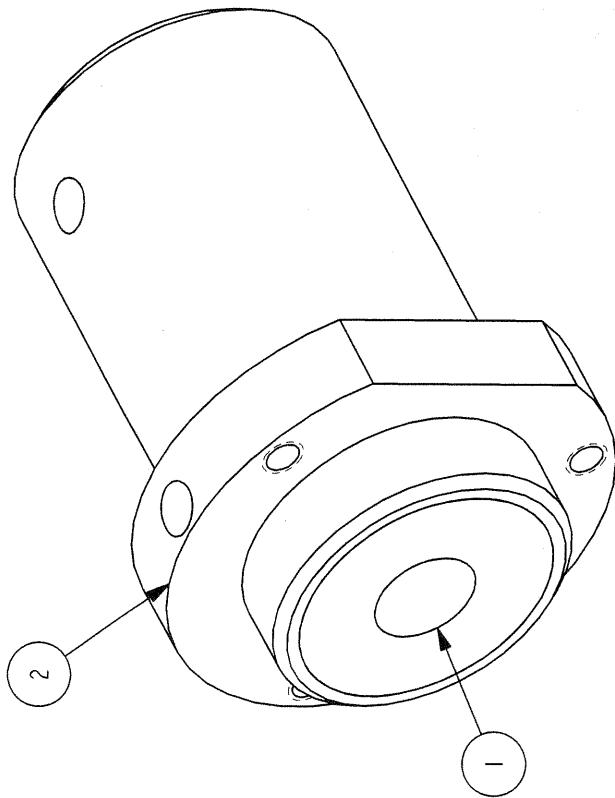
X	215
REQ'D	WHERE USED
KIRK - RUDY, INC.	KIRK - RUDY, INC.
KENNE SAW, GEORGIA	KENNE SAW, GEORGIA
215	ASSY, ROLLER FRONT DRIVE
SHEET NO. 0F1	DRAWING # 530676-01

DRAWN BY: T JG SCALE 0.375 DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED

CHECKED BY: 24-Mar-99 DATE .01 .005 .5

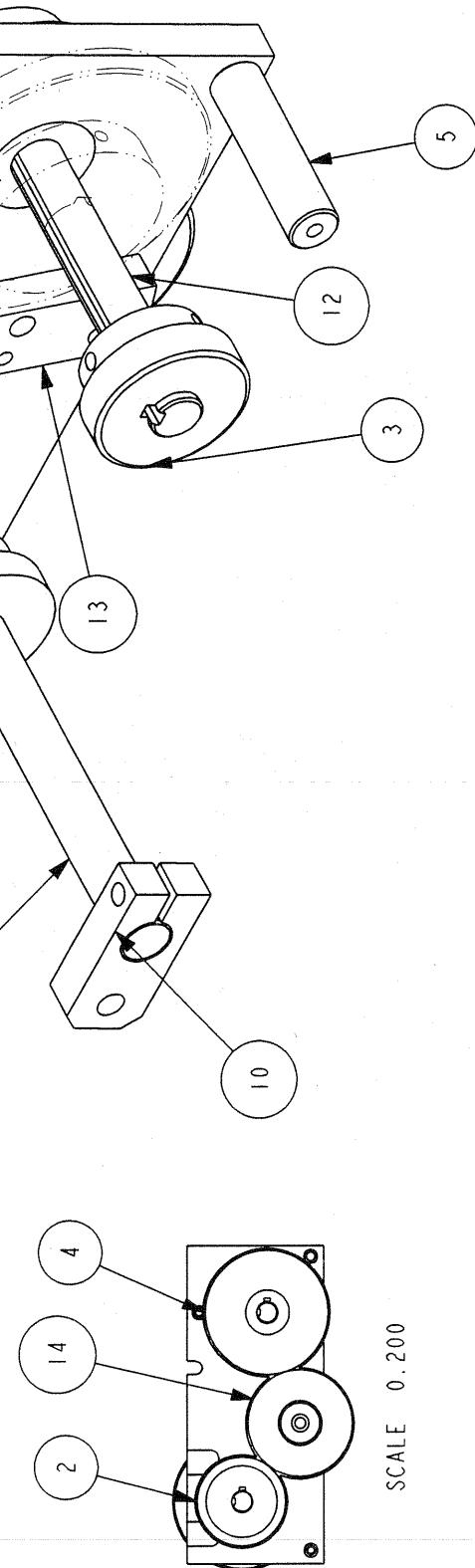
TRACED BY: M MASTER FINISH: N/A

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



DRAWN BY:	SCALE:	DESCRIPTION:	REV NO	DATE	ECN NO	BY
MY	1 . 000	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	N/A			
CHECKED BY:	DATE:	.xx .xxx ANG.	N/A			
	12 - Apr - 99	.01 .005 .5	HEAT TREAT:			
TRACED BY:	MASTER:	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY	TIME:	215	MODEL:	KIRK - RUDY, INC. KENNESAW, GEORGIA
	M		SHEET NO.:	OF 1	DRAWING NO.:	531106-01
			WHERE USED:		I	536176-01
			REQ'D:			

ITEM QTY	PART #	DESCRIPTION	REV N0	DATE	DESCRIPTION	ECN N0	BY
1	101760	GEAR, 2075 .625B .188K					
2	101914	GEAR, 1640 .625B .188K					
3	101916	GEAR, 1628 .625B .188K					
4	101920	GEAR, 1656 .625B .188K					
5	2 102672	SPACER, SIDE PLATE					
6	1 103110	BEARING, FLAT .625					
7	1 103804	BEARING, HUB .625					
8	1 500720	PLATE - SIDE GEAR SUPPORT					
9	1 500747	CAM - FEED ROLLERS					
10	1 500750	CRANK - FEEDER SLIDE					
11	1 500826	SHAFT-CRANK					
12	1 500829	SHAFT-GEAR					
13	1 500857	BLOCK, GEAR BACK UP					
14	1 101919A	GEAR ASY					



SCALE 0.200

NOTES:
1. FOR 11 IN SPACING.

DRAWN BY: A Y B	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 WHOLE OR IN PART EXPRESS WRITTEN PERMISSION OF KIRK-RUDY INC. KENNESAW, GA 30044 USA
CHECKED BY:	DATE 29-Apr-99	.xx	.xxx	ANG. .01 .005 .5	HEAT TREAT: N/A	MODEL: 2151J
TRACED BY:	MASTER M	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED	ALL DIMENSIONS ARE FINISHED DIMENSIONS	FINISH: N/A	SHEET NO. 10F1	TITLE: ASSY, CHANGE GEAR PLATE 111N
		DO NOT SCALE TO DIMENSIONS ONLY				RECD WHERE USED 1 535804-01

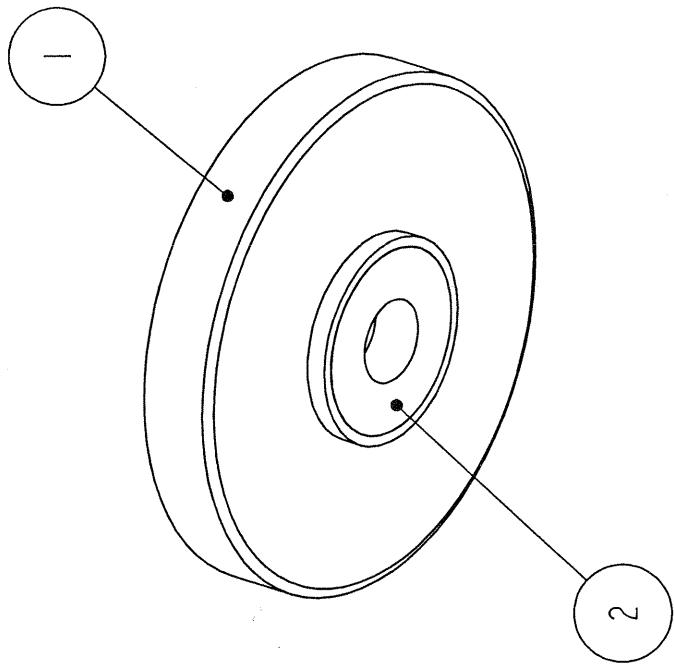
535812-01

DRAWING #

101919A

ITEM QTY	PART #	DESCRIPTION
1	101919	GEAR, 1648 1.124B NK
2	103108	BEARING, FLAT .500

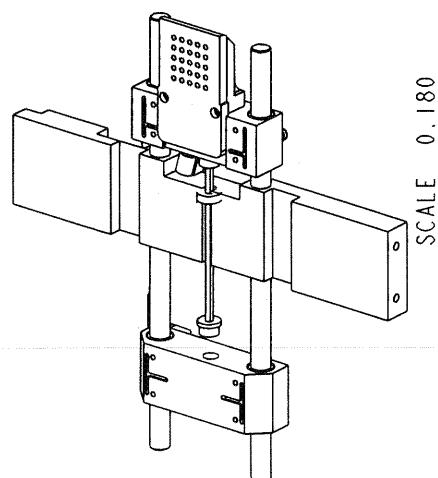
REV NO	DATE	DESCRIPTION	ECN NO	BY



RE'D	WHERE USED
KRK	KIRK - RUDY INC. KENNE SAW, 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. KENNE SAW, GA 30144 USA	
MODEL: XXX	TITLE: GEAR ASY
SHEET NO: 10F	DRAWING # 101919A

DRAWN BY:		SCALE	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED			HEAT TREAT:	FINISH:
NAME	SIGNATURE		.000	.005	.01	ANG.	
JMW			.000	.005	.01		
CHECKED BY:		DATE	.000	.005	.01		
-		4 - Jan - 05				REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED	
TRACED BY:		MASTER				ALL DIMENSIONS ARE FINISHED DIMENSIONS	
-		M				DO NOT SCALE - WORK TO DIMENSIONS ONLY	

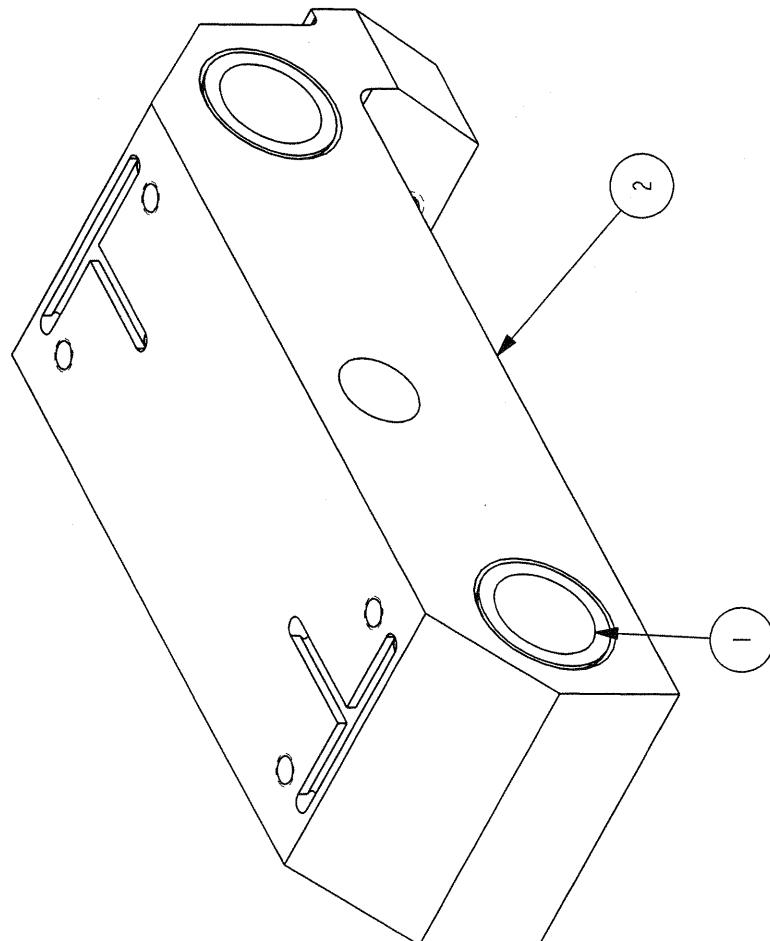
ITEM QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	2	102225			COLLAR .250		
2	1	103500			BEARING - ROD END		
3	1	109523			JUNCTION, 2-WAY		
4	1	109524			JUNCTION, 3-WAY		
5	1	500735			ROD - PUSH		
6	2	500737			WASHER - BUMPER		
7	2	500741			SHAFT - FEEDER		
8	1	500749			ROD - FEEDER SLIDE		
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			BOLT, HEX HEAD 3/8-16X1.50		
15	2	RHN012			NUT, HEX 3/8		
16	1	WA013			WASHER, FLAT 3/8		



SCALE 0 .180

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 30144 USA
TVK	0 .250	.XX .XXX ANG.	N / A		
CHECKED BY:	DATE	.01 .005 .5	HEAT TREAT:		KIRK - RUDY, INC.
	05 - May - 98	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED	N / A		KENNESAW, GEORGIA
TRACED BY:	MASTER	ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY	N / A		
			SHEET NO.: 0F1	DRAWING #	215
				REF'D WHERE USED	1 215
					531021-01

ITEM QTY	PART #	DESCRIPTION
1	4	100145 BUSHING, SL.6251D.8130DI.000LG
2	1	500728 BRACKET - FEEDER



DRAWN BY:	SCALE	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	MATERIAL:	REMOVED ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED	THIRD ANGLE PROJECTION	PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE QUOTED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC. KENNESAW, GA 30144 USA
	MY	.000	N/A			
CHECKED BY:	DATE	.XX .XXX .005 .5	HEAT TREAT:	N/A		
TRACED BY:	MASTER	09-Apr-99	FINISH:	N/A	MODEL: 215	TITLE: ASSY, BUSHING BLOCK
					SHEET NO.: 0F1	DRAWING # 500728A

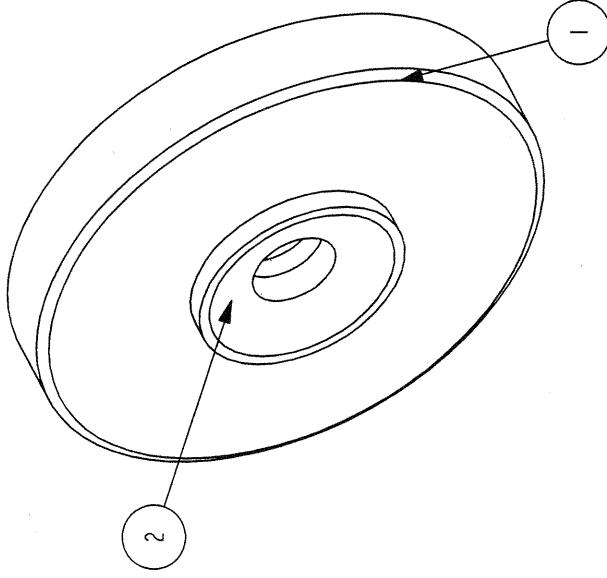
ITEM OTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	100131	BUSHING, SL. 250ID.375OD 1.250LG					
2	100145	BUSHING, SL. 625ID.813OD 1.000LG					
3	2	OIL METER UNIT					
4	2	109528 NUT, COMPRESSION FEMALE					
5	2	109537 SLEEVE, COMPRESSION					
6	1	190606 FITTING - 90 DEG 1/4 NPT					
7	1	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					

DRAWN BY: TVK		SCALE: 0 .380	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	
			.xx	.xxx	ANG.			
CHECKED BY:		DATE: 05-May-98	.01	.005	.5	HEAT TREAT:	KIRK - RUDY, INC. KENNESAW, GEORGIA	
TRACED BY:		MASTER:	TIME: 215		N/A	MODEL: 215	TITLE: ASSY, VACUUM BODY	
					N/A	SHEET NO.: 0F1	DRAWING #: 500708A	

ITEM QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	2	103106 BEARING, FLAT .375					
2	1	500751 YOKE - FEEDER CRANK					

DRAWN BY:	SCALE	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED			THIRD ANGLE PROJECTION	PROPRIETARY AND CONFIDENTIAL
MY	2.000	.XX	.XXX	ANG.		NO PORTION OF THIS DRAWING
CHECKED BY:	DATE	.01	.005	.5		MADE FOR USE OR REPRODUCED
	09-Apr-99	REMOVE ALL BURS AND SHARP EDGES UNLESS OTHERWISE NOTED			MODEL:	IN ANY FORM, WITHOUT THE
TRACED BY:	MASTER	ALL DIMENSIONS ARE FINISHED DIMENSIONS			215	EXPRESS WRITTEN PERMISSION
	M	DO NOT SCALE WORK TO DIMENSIONS ONLY			SHEET NO.:	OF 1
					DRAWING #:	ASSY, BEARING BLOCK
					REQ'D	500751A
					WHERE USED	

ITEM QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	1	101919 GEAR, 1648 I. 124B NK					
2	2	103108 BEARING, FLAT .500					



1	536176-01	REO'D WHERE USED
KIRK - RUDY, INC.	KENNEBUNK, GEORGIA	
PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE COPIED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY INC. KENNEBUNK, ME 04044 USA		
THIRD ANGLE PROJECTION		
MATERIAL: N/A		
DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED		
xx .xxx .01 .005 .5	ANG.	
DATE 12-Apr-99	HEAT TREAT:	N/A
CHECKED BY: M	MODEL: 215	
TRACED BY: M	SHEET NO. 10F1	DRAWING #
		531105-01

ITEM QTY	PART #	DESCRIPTION
1	1	500769 SHAFT - REAR GUIDE
2	2	500832 BRACKET-REAR-GUIDE
3	1	500714-A ASSY, REAR BRIDGE

REV NO	DATE	DESCRIPTION	ECN NO	BY
1.000	215			
REV'D	WHERE USED			

DRAWN BY: TJG	SCALE 0 . 250	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED		MATERIAL: N / A
CHECKED BY:	DATE 18 - May - 00	.xx	.xxx	ANG. .01 .005 .5
TRACED BY:	MASTER 	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED		HEAT TREAT: N / A
		ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE WORK TO DIMENSIONS ONLY		TIME: N / A
				SHEET NO.: OF 1

TITLE:
ASSY, JOGGER TABLE

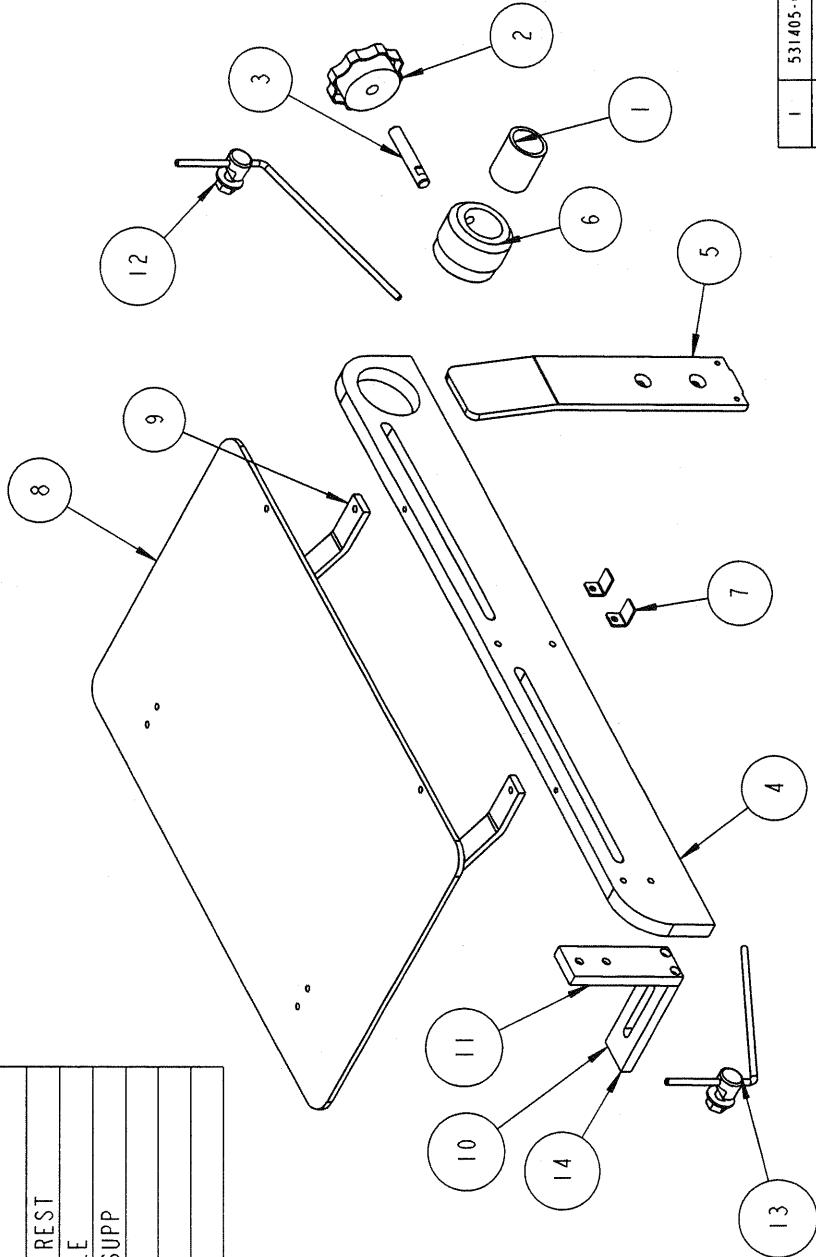
DRAFTING #:
531405-07

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

KIRK - RUDY, INC.
KENNESAW, GEORGIA

ITEM QTY	PART #	DESCRIPTION
1	1 100109	BUSHING, SLI. 0001DI.2500DI.500LG
2	1 102112	KNOB
3	1 105601	SHAFT, THREADED 3/8-16
4	1 500714	BRIDGE - READ GUIDE
5	1 500715	PLATE - REAR CENTER GUIDE
6	1 500770	HUB - REAR GUIDE SHAFT
7	2 500771	CLIP-SIDE GUIDE
8	1 500845	TABLE, JOGGER
9	2 500847	BRACE, COMPUTER FORM REST
10	1 500878	SUPPORT - JOGGER TABLE
11	1 500880	BRACKET - JOG TABLE SUPP
12	1 500764AL	ASSY, LIFTER
13	1 500764AR	ASSY, LIFTER
14	1 500880A	ASSY, BRACKET



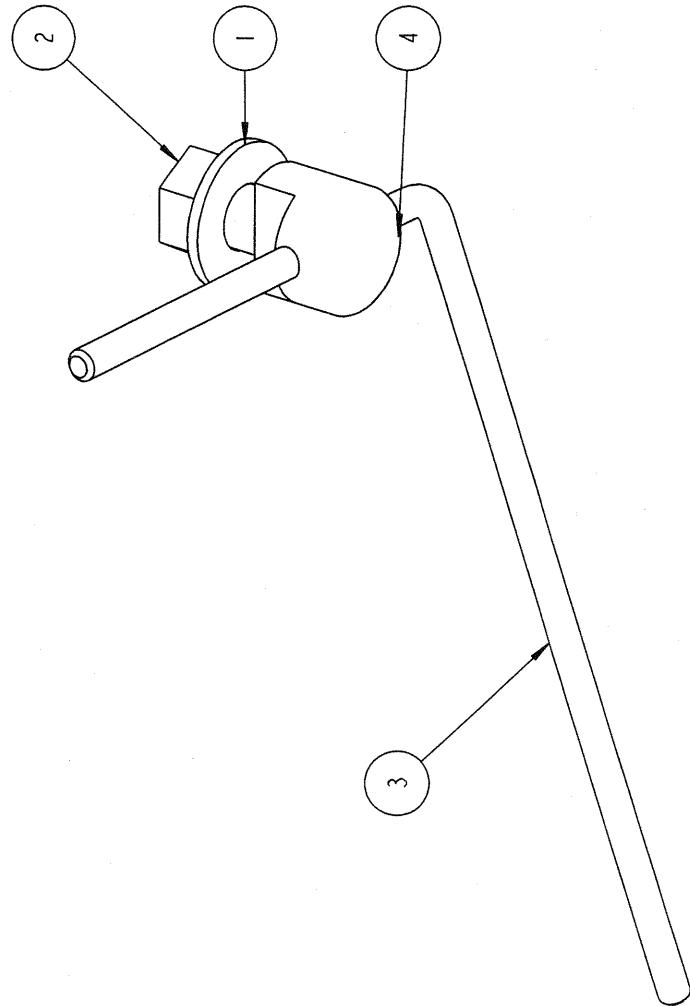
REV NO	DATE	DESCRIPTION	ECN NO	BY
1	09-APR-99	REMOVED SPACER 500765	6458	MY

REQ'D	WHERE USED
1	531405-01

DRAWN BY:	N J G	SCALE:	0 . 188	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	N / A	MATERIAL:	N / A	THIRD ANGLE PROJECTION	KIRK - RUDY, INC., KENNESAW, GEORGIA
CHECKED BY:		DATE:	12-Apr-99	.XX .XXX .01 .005 .5 ANG.		HEAT TREAT:	N / A	MODEL:	215
TRACED BY:		MASTER:	M	REMOVE ALL BURRS AND SHARP EDGES AND MASS OFF PRINTED	ALL DIMENSIONS ARE FINISHED DIMENSIONS	FINISH:	N / A	SHEET NO.:	OF 1

500714-A

ITEM QTY	PART #	DESCRIPTION
1	100601	WASHER, FLAT .500
2	106702	NUT, 3/8-16
3	500764	LIFTER - REAR BRIDGE
4	500766	SCREW - MACHINE REAR GUIDE



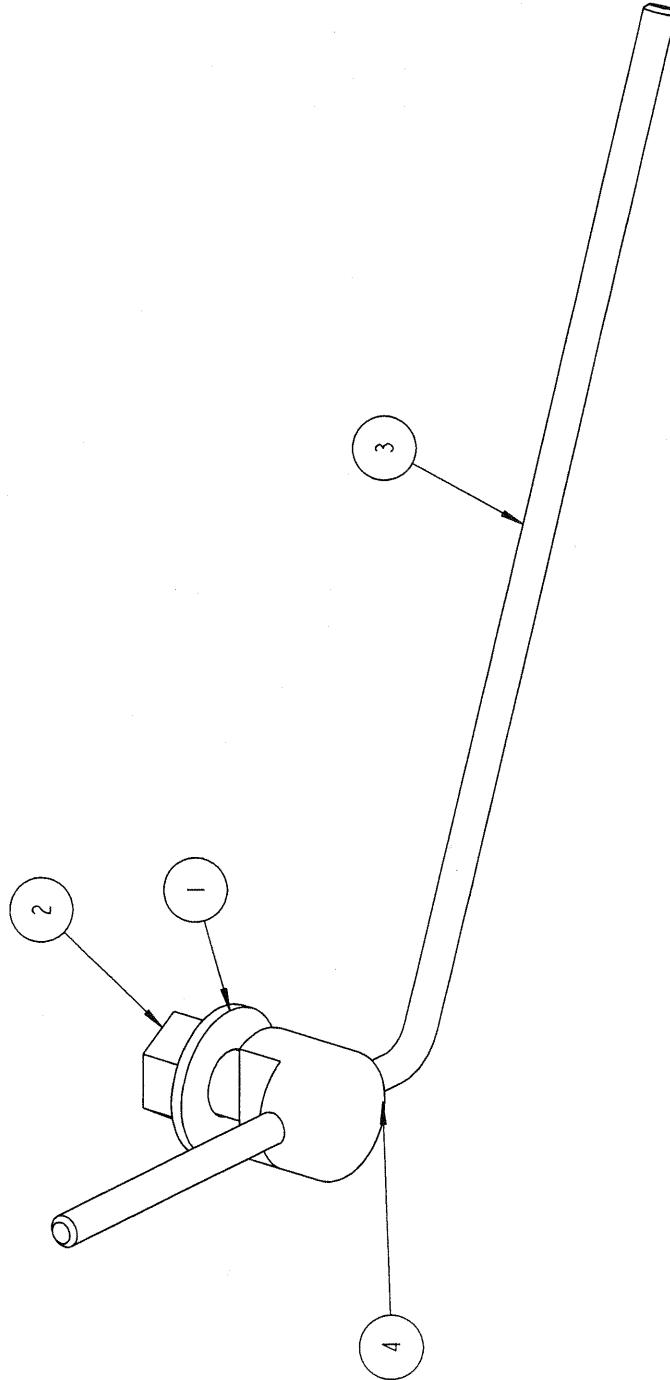
ITEM QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	100601	WASHER, FLAT .500					
2	106702	NUT, 3/8-16					
3	500764	LIFTER - REAR BRIDGE					
4	500766	SCREW - MACHINE REAR GUIDE					

DRAWN BY: A KEY	SCALE 1 . 000	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED			MATERIAL: N / A	THIRD ANGLE PROJECTION	PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE QUOTED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC. KENNESAW, GA 30144 USA
CHECKED BY:	DATE 26 - Jan - 01	.xx	.xxx	ANG. .01	HEAT TREAT: N / A	MODEL: 215	KIRK - RUDY, INC. KENNESAW, GEORGIA
TRACED BY:	MASTER <i>M</i>	FINISH: REMOVE ALL BURS AND SHARP EDGES UNLESS OTHERWISE NOTED ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY			SHEET NO.: OF 1	DRAWING #: ASSY, LIFTER	

I	215SP20
REQ'D	WHERE USED

500764AL

ITEM QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	1 100601	WASHER, FLAT .500					
2	1 106702	NUT, 3/8-16					
3	1 500764	LIFTER - REAR BRIDGE					
4	1 500766	SCREW - MACHINE REAR GUIDE					

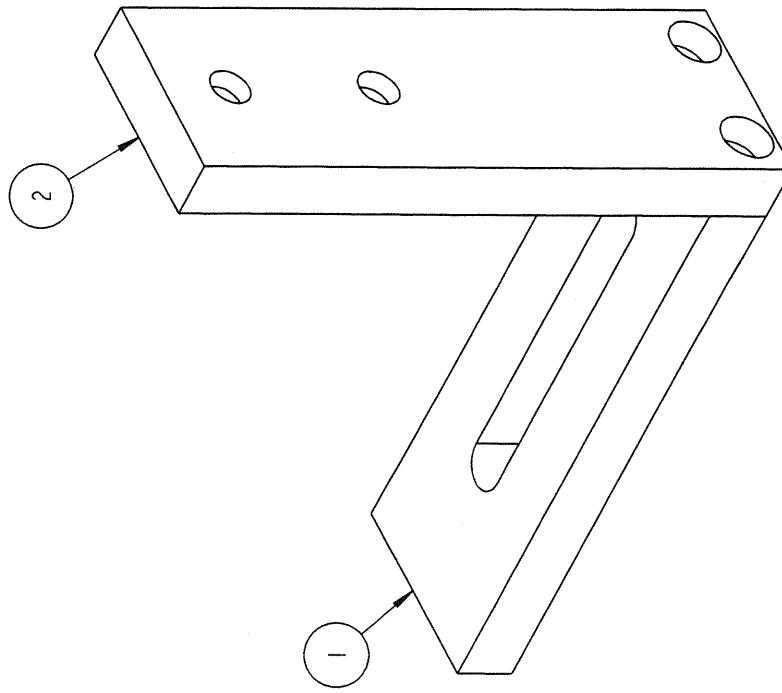


DRAWN BY: A KEY	SCALE 1 .000	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED			MATERIAL: N/A	THIRD ANGLE PROJECTION NO PORTION OF THIS DRAWING MAY BE QUOTED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY INC. KENNEBUNK, GEORGIA KIRK - RUDY, INC. KENNEBUNK, GEORGIA KIRK-RUDY, INC. KENNEBUNK, GA 30446 USA	REO'D WHERE USED I 215SP20
CHECKED BY:	DATE 26 - Jan - 01	.xx	.005	.5	HEAT TREAT: N/A	MODEL: 215	TITLE: ASSY, LIFTER
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: N/A	SHEET NO.: 10F1	DRAWING ■ 500764AR		

DRAWING #

500880A

ITEM QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	1	500878 SUPPORT - JOGGER TABLE					
2	1	500880 BRACKET - JOG TABLE SUPP					



DRAWN BY:	N JG	SCALE	.000	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	MATERIAL: N/A	THIRD ANGLE PROJECTION	KIRK - RUDY, INC.
CHECKED BY:		DATE	24-JUL-97	.xx .xxx .01 .005 .5	ANG. HEAT TREAT: N/A	VIEW:	KENNE SAW, GEORGIA
TRACED BY:	MASTER	MASTER	M	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED	FINISH: N/A	MODEL: 215	KENNE SAW, GA 30144 USA
				ALL DIMENSIONS ARE FINISHED DIMENSIONS		SHEET NO.: 10F1	TITLE: ASSY , BRACKET
				DO NOT SCALE WORK TO DIMENSIONS ONLY		DRAWING #: 500880A	

ITEM QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	100800	ASSY, UNIVERSAL JOINT					
2	100800-1	ASSY, UNIVERSAL JOINT					
3	101707-1	GEAR, 2048 .500B NK					
4	1 500803-1	SHAFT, UNIVERSAL					
5	2 500814-1A	ASSY, SIDE GUIDE RAIL					
6	1 531582-01	EG ASSY, BRIDGE DRIVE AND GATE					
7	1 535412-01	ASSY, SIDE GUIDE					
8	1 541166-01	SHAFT, BRIDGE DRIVE					
9	1 541203-01	ASSY, BRIDGE					
10	1 541204-01	COVER, HUB BEARING					

1	215
REO'D	WHERE USED

KRK	KIRK - RUDY, INC.
	KENNESEEW, 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.	
KENNESEEW, GA 30144 USA	

THIRD ANGLE PROJECTION	
MODEL: 215	TITLE: ASSY, BRIDGE TIMING BELT

SHEET NO. 1 OF 1	DRAWING # 541202-01
------------------	---------------------

SCALE: A KEY	SCALE: 0.375	MATERIAL: N/A	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	
DATE: 23-May-01	.xx .xxx	.01 .005	ANG.: .5	HEAT TREAT: N/A
CHECKED BY: M		FINISHES:		N/A
TRACED BY: M		ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY		

DRAWING # 541203-01

ITEM QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	2	103803 BEARING, HUB .500					
2	1	530182-02 BRIDGE - FEEDER					

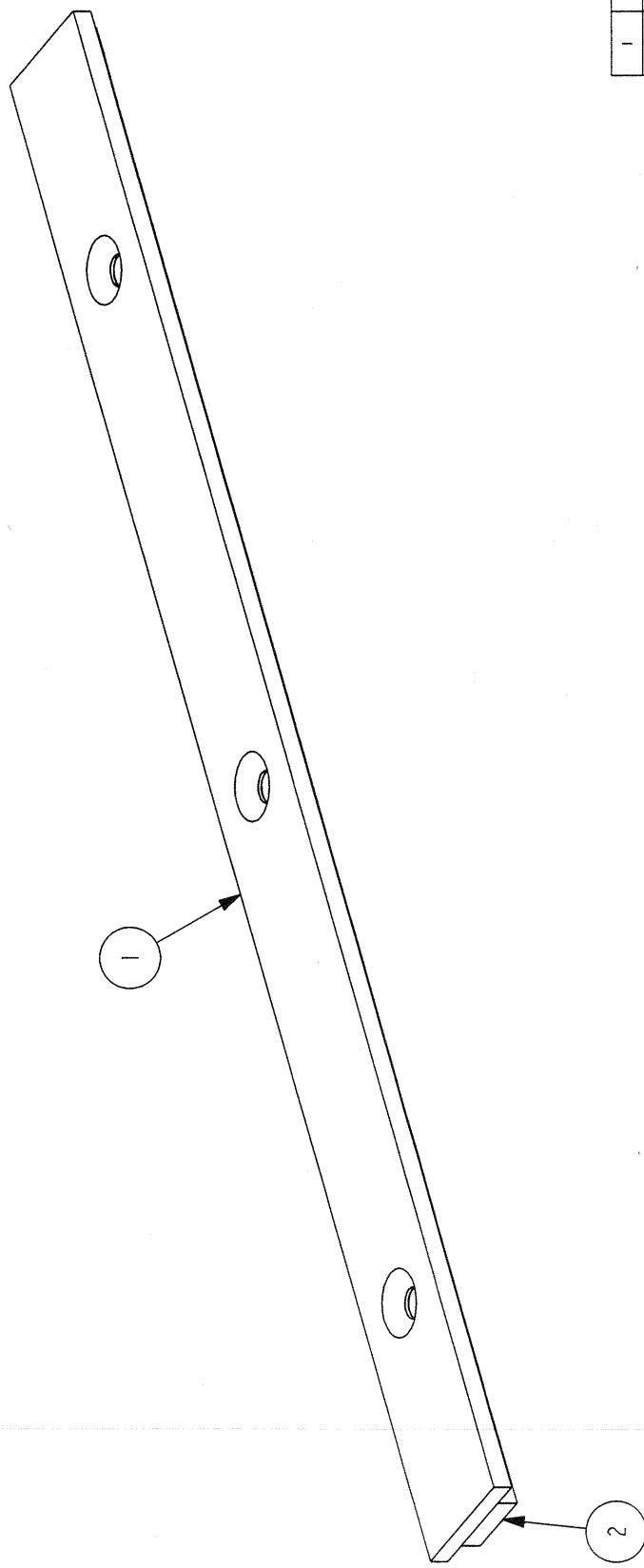
DRAWN BY: A KEY	SCALE 0 .375	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED		MATERIAL: N/A	HEAT TREAT: N/A		REMOVED ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED
DATE 06-06-00	.xx .005 .5	.xx .005 .5	FINISH: N/A				ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY
CHECKED BY:							
TRACED BY:							
MASTER	<i>m</i>						

I	SP86900
REQ'D	WHERE USED

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		KRK KIRK - RUDY, INC. KENNESAW, GEORGIA
ASSY , BRIDGE	215	TITLE:
SHEET NO: OF 1	DRAWING #	541203-01

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

REV NO	DATE	DESCRIPTION	ECN NO	BY



DRAWN BY:	MY	SCALE	1 . 000	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	MATERIAL:	N / A	THIRD ANGLE PROJECTION	PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE QUOTED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY INC. KENNESAW, GEORGIA	KIRK - RUDY, INC. KENNESAW, GEORGIA
CHECKED BY:		DATE	12 - Apr - 99	.XX .XXX ANG.	HEAT TREAT:	N / A	MODEL:	215	ASSY , SIDE GUIDE RAIL
TRACED BY:	MASTER			.01 .005 .5	FINISH:	N / A	SHEET NO:	OF 1	DRAWING ■
				REMOVE ALL BURRS AND SHARP EDGES UNLESS NOTED	ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE TO DIMENSIONS ONLY				500814-1A

ITEM NO.	PART #	DESCRIPTION	REV. NO.	DATE	ECN NO.	BY
1	2	100400 WASHER, THRUST TW31				
2	1	100402 WASHER, THRUST TB612				
3	2	100409 WASHER, THRUST				
4	2	101100 BEARING, ONEWAY .375				
5	1	102114 KNOB				
6	1	102117 KNOB				
7	1	102225 COLLAR .250				
8	1	102345 SHIM .315X .625X .125				
9	2	102701 SPRING				
10	4	103106 BEARING, FLAT .375				
11	2	104400 BOLT - HEX HEAD				
12	1	190600 SPIDER - ROLLER DRIVE				
13	1	190685 LEVER - QUICK RELEASE				
14	1	500730 PLATE, GATE FEEDER				
15	1	500743 SHAFT - TOP ROLLER DRIVE				
16	1	500744 SHAFT - TOP ROLLER ASSY				
17	2	500145 ROLLER, UPPER				
18	2	500805 PLATE - HOLD DOWN				
19	1	500806 PLATE - GATE END				
20	2	500807 NUT - LOCK				
21	2	500809 SLEEVE - THREADED				
22	1	500810 SHAFT - SCREW ADJ				
23	2	500811 FORK ASSY				
24	2	500812 KNOB - ROLLER ADJUSTMENT				
25	2	500859 SPACER				
26	1	102114A ROUND KNOB ASSY				
27	1	102200 2 COLLAR				
28	1	500743 .2 SHAFT - TOP ROLLER				
29	2	500144 .5 COLLAR - TOP ROLLER SHAFT				
30	1	500744 .6 SHAFT - TOP ROLLER				
31	2	500745A ASSY, UPPER FEED ROLLER				
32	1	500195 .1 PLATE - BACK				
33	1	500199 .3 CLAMP - MOUNTING PLATE				
34	1	500199 .5 BLOCK, CLAMP SUPPORT				
35	2	500199 .6 STUD, BRIDGE (LONG)				
36	2	500199 .7 STUD, BRIDGE (SHORT)				
37	1	500199 .2 BLOCK - CONNECTOR				
38	1	500808 .1 PLATE, TOP BRIDGE				
39	2	500811 .4 ASSY, FORK WITH BEARINGS				
40	1	531582 .01 EG ASSY, BRIDGE DRIVE AND GATE				
41	2	531584 .01 EG ASSY, FORK				
42	2	531672 .01 BAR, FORK				
43	2	531673 .01 YONE				
44	1	RHB051 BOLT, HEX HEAD 5/16-.18X1.25				
45	1	RHB081 BOLT, HEX HEAD 3/8-.16X1.25				
46	1	WHS010 WASHER, LOCK 5/16				
47	1	WHS011 WASHER, LOCK 3/8				

ITEM NO.	PART #	DESCRIPTION	REV. NO.	DATE	ECN NO.	BY
1		KRK - RUDY, INC				
		WOODSTOCK, GEORGIA				
		1 535411-01				

ITEM NO.	PART #	DESCRIPTION	REV. NO.	DATE	ECN NO.	BY
1		EG ASSY, BRIDGE DRIVE AND GATE				
		1 531582 - 01				
		REMOVED WHERE USED				

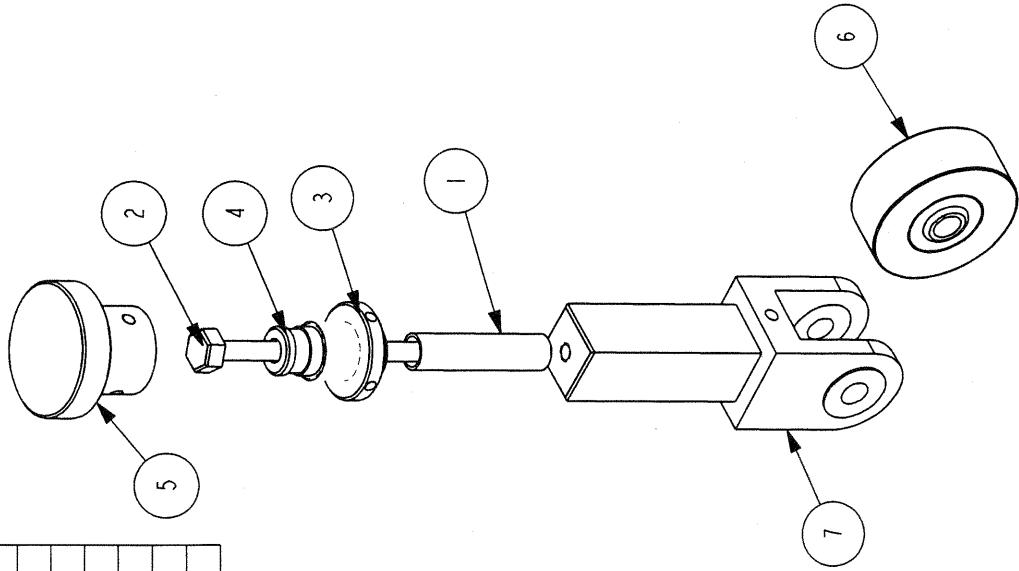
ITEM NO.	PART #	DESCRIPTION	REV. NO.	DATE	ECN NO.	BY
1		EG ASSY, BRIDGE DRIVE AND GATE				
		1 531582 - 01				
		REMOVED WHERE USED				
		1 531582 - 01				

ITEM NO.	PART #	DESCRIPTION	REV. NO.	DATE	ECN NO.	BY
1		EG ASSY, BRIDGE DRIVE AND GATE				
		1 531582 - 01				
		REMOVED WHERE USED				
		1 531582 - 01				

DRAWING 1

531582-01

ITEM QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	1 02701	SPRING					
2	1 104400	BOLT - HEX HEAD					
3	1 500807	NUT - LOCK					
4	1 500809	SLEEVE - THREADED					
5	1 500812	KNOB, ROLLER ADJUSTMENT					
6	1 500745A	ASSY, UPPER FEED ROLLER					
7	1 500811A	ASSY, FORK WITH BEARINGS					



DRAWN BY:		SCALE	0 . 438	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 30044 USA		REQ'D	WHERE USED
CHECKED BY:		DATE	12 - Apr - 99	.XX	.XXX	ANG.						
				.01	.005	.5	HEAT TREAT:	N / A				
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						
				SHEET NO. 0F1		DRAWING #						
				531584-01								

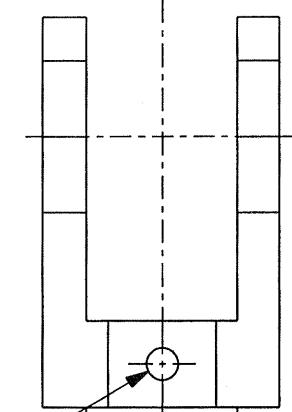
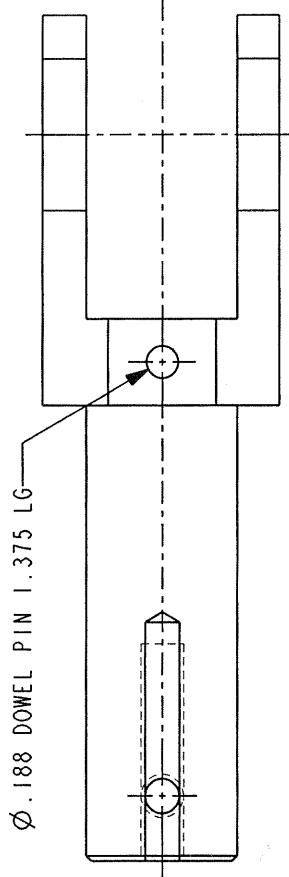
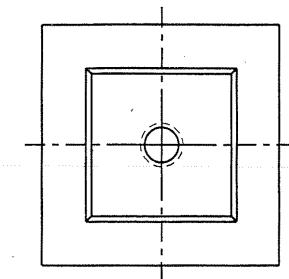
ITEM QTY	PART #	DESCRIPTION
1	2	103106 BEARING, FLAT .375
2	1	500811 FORK ASY
3	1	531672-01 BAR, FORK
4	1	531673-01 YOKE

REV NO	DATE	DESCRIPTION	ECN NO	BY	REO'D WHERE USED

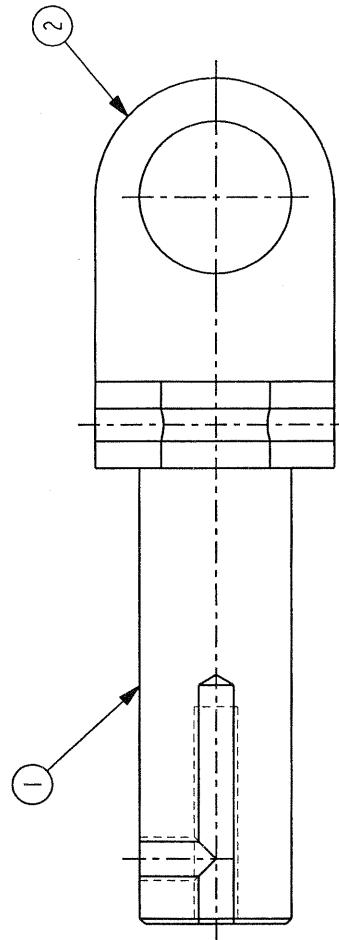
DRAWN BY: M.Y.	SCALE 1.000	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED .xx .005 .01 .005 .05 .5 ANG.	MATERIAL: N/A	THIRD ANGLE PROJECTION NO PORTION OF THIS DRAWING MAY BE QUOTED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY INC. KENNESAW, GA 30040 USA	KIRK - RUDY, INC. KENNESAW, GEORGIA
CHECKED BY: 12 - Apr - 99	DATE MASTER	HEAT TREAT: N/A	FINISH: N/A	MODEL: 215	TITLE: ASSY, FORK WITH BEARINGS
TRACED BY: m		REMOVE ALL BURS AND SHARP EDGES UNLESS NOTED ALL DIMENSIONS ARE FINISHED DIMENSIONS 00, NOT SCALE, WORK TO DIMENSIONS ONLY		SHEET NO.: 0F1	DRAWING #: 500811A

ITEM #	QTY	PART #	DESCRIPTION
1	1	531672-01	BAR, FORK
2	1	531673-01	YOKE

REV NO	DATE	DESCRIPTION	ECN NO	BY
2	9-5-97	REDRAWN IN PRO	6195	SLB



φ .188 DOWEL PIN 1.375 LG



NOTES:

1. MATERIAL
1. 875 SQUARE GROUND STOCK 3.125 LG.
2. SQUARE CRS 2.25 LG
2. SEE 500811-2 SSY FOR 24 FEEDER.
3. BEARING No 103106 4-REQ'D.

DRAWN BY:	SCALE	DATE	MASTER	MATERIAL: DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	SEE NOTE	NOTE	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	RECD WHERE USED
	LG	1 . 000		.01 .005 .5	N/A	HEAT TREAT:		KRK KIRK - RUDY, INC. KENNESAW, GEORGIA	2 502400
CHECKED BY:		05-AUG-68		REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED		FINISH:	MODEL: XXXX	TITLE: FORK ASY	2 501600
TRACED BY:				ALL DIMENSIONS ARE IN INCHES DO NOT SCALE - WORK TO DIMENSIONS ONLY	BLACK OXIDE		SHEET NO. 1 OF 1	DRAWING #	2 500700

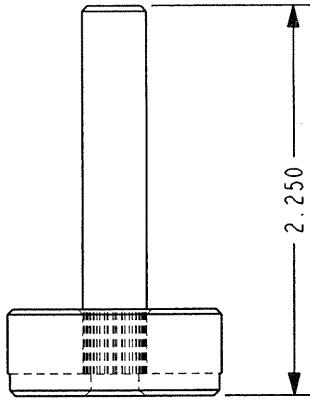
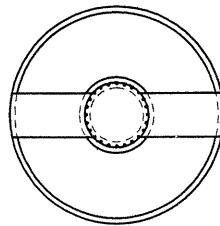
ITEM QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	1	101100 BEARING, ONEWAY .375					
2	1	500745 ROLLER, UPPER					

DRAWN BY:		SCALE	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED		MATERIAL:	THIRD ANGLE PROJECTION		REO'D WHERE USED	
NAME	SIGNATURE	1:1	.005	.005	N / A			REO'D	WHERE USED
MY		.000			N / A				
		.01	.005	.5	HEAT TREAT:				
					N / A				
					MODEL: 215				
					TITLE: ASSY, UPPER FEED ROLLER				
					SHEET NO. OF 1				
					500745A				

CHECKED BY:	DATE	MASTER
	12 - Apr - 99	
REMOVED ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED		
ALL DIMENSIONS ARE FINISHED DIMENSIONS		
DO NOT SCALE - WORK TO DIMENSIONS ONLY		

ITEM QTY	PART #	DESCRIPTION
1	1	500744_5 COLLAR - TOP ROLLER SHAFT
2	1	500744_6 SHAFT - TOP ROLLER

REV NO	DATE	DESCRIPTION	ECN NO	BY

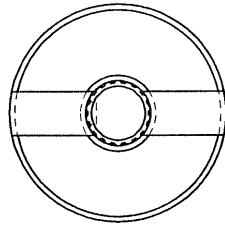
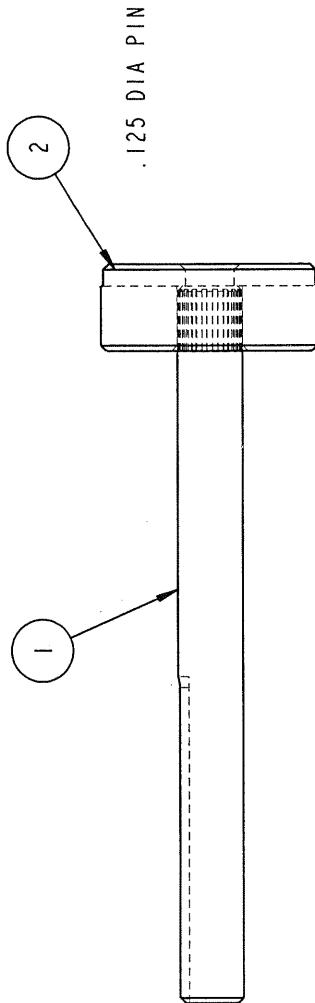
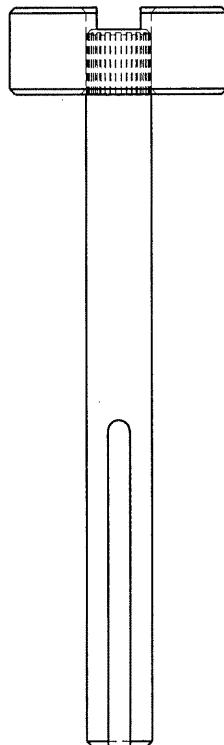


NOTES:
I. HARDEN - CYANIDE

DRAWN BY:	SCALE	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	MATERIAL:	THIRD ANGLE PROJECTION	RECORD	RECD	req	MACH
TH	1 . 000	.000 .005 .005 .005 .005 .005 .005 .005	CRS		KIRK - RUDY, INC.	KENNESAW, GEORGIA		
CHECKED BY:	DATE	AMG.	HEAT TREAT:					
	21 - JUL - 69	.01 .005 .005 .005 .005 .005 .005 .005	CYN IDE					
TRACED BY:	MASTER	FINISH:	MODEL: 215	TITLE: SHAFT - TOP ROLLER ASSY	SHEET NO.: 1 OF 1	DRAWING I		
	M	BLACK OXIDE						

ITEM QTY	PART #	DESCRIPTION
1	500743_2	SHAFT - TOP ROLLER
2	500744_5	COLLAR - TOP ROLLER SHAFT

REV NO	DATE	DESCRIPTION	ECN NO	BY
1	02-JUN-98	REDRAWN IN PRO/E	6254	WY



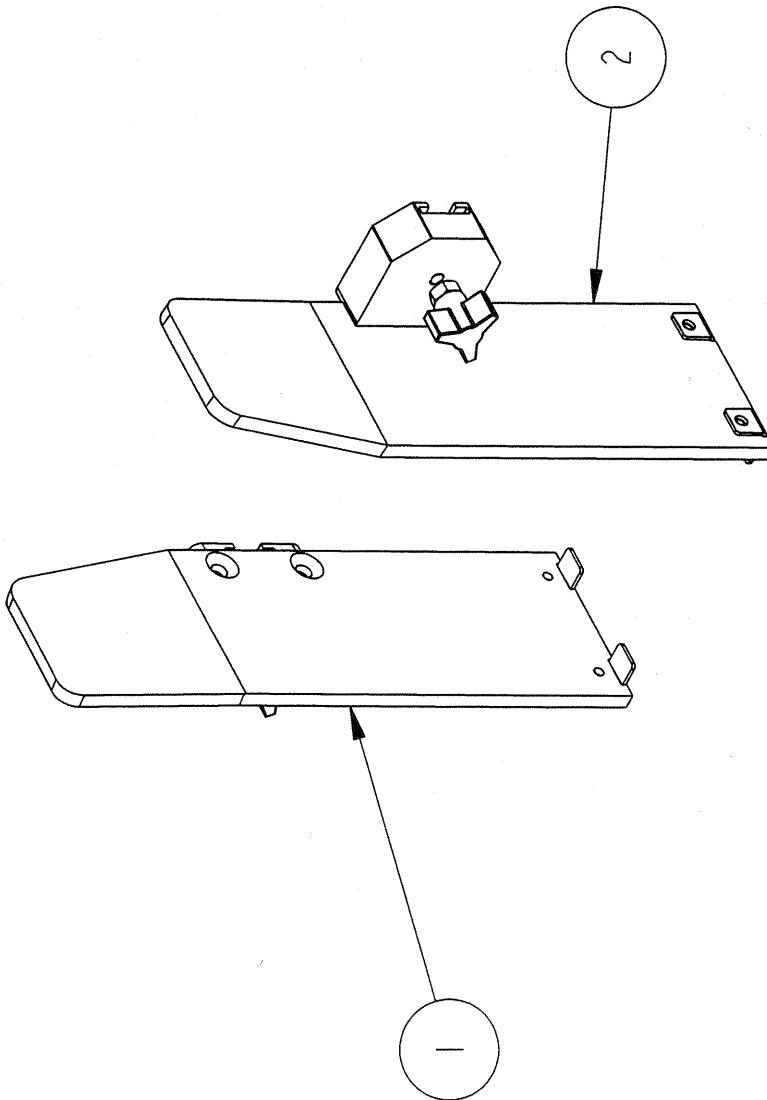
NOTES:
1. HARDEN - CYANIDE

1	502400
1	501600
1	500700

REQ'D WHERE USED

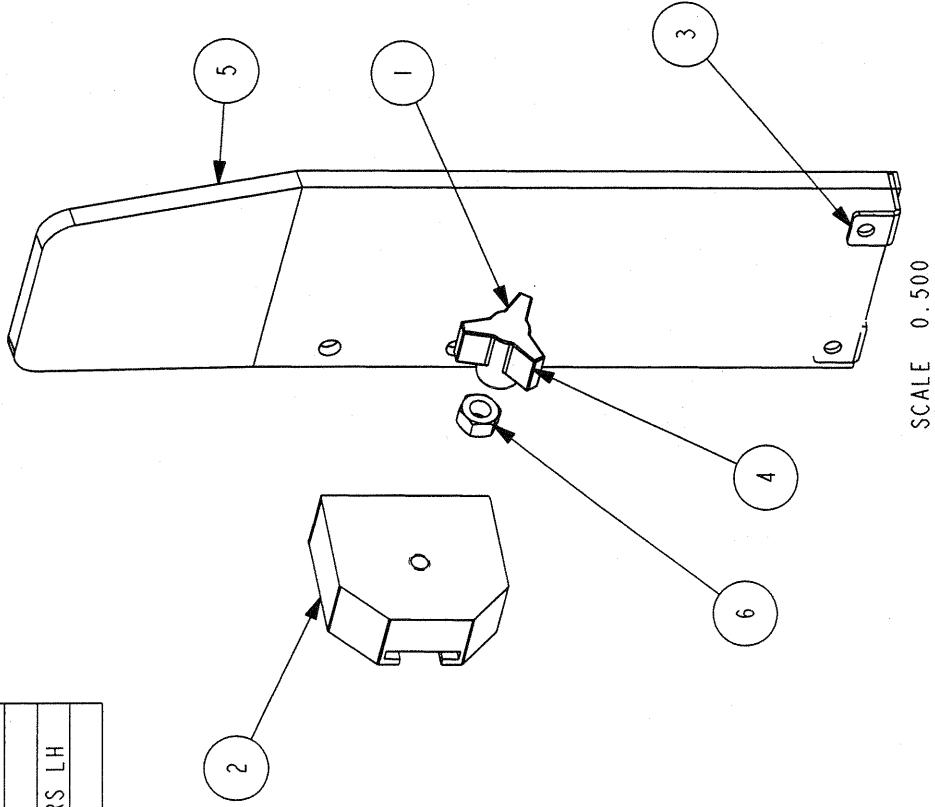
DRAWN BY:	SCALE	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	MATERIAL:	THIRD ANGLE PROJECTION	PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE COPIED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC. KENNESAW, GA 30144 USA
TH	1 . 000	CRS	.01 .005 .005	⊕ - - - - -	KIRK - RUDY, INC. KENNESAW, GEORGIA
CHECKED BY:	DATE	ANG.	.5	HEAT TREAT:	
	21 - JUL - 69			CH . 009 - .014	MODEL: 215
TRACED BY:	MASTER	FINISH:	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED	SHEET NO. 10F1	TITLE: SHAFT - TOP ROLLER DRIVE
			ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY		DRAWING # 500743

ITEM QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	1	500755AL ASSY, SIDE GUIDE LH					
2	1	500755AR ASSY, SIDE GUIDE RH					



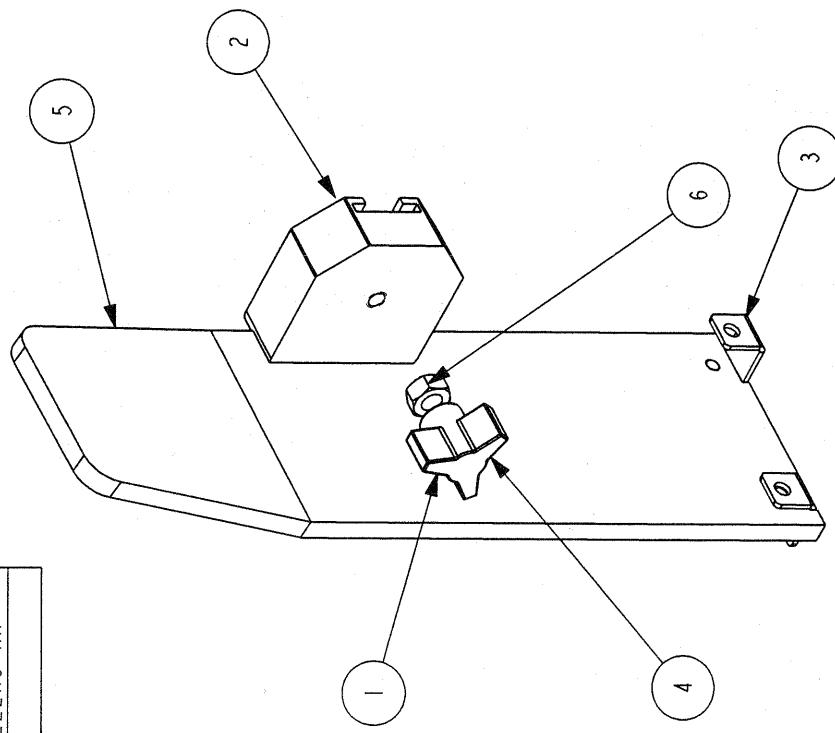
1	535411-01
REO D	WHERE USED
KIRK - RUDY INC.	
KENNESAW, GEORGIA	
PROPRIETARY AND CONFIDENTIAL	
NO PORTION OF THIS DRAWING	
MAY BE COPIED OR REPRODUCED	
IN ANY FORM WITHOUT THE	
EXPRESS WRITTEN PERMISSION	
OF KIRK-RUDY INC.	
KENNESAW, GA 30044 USA	
THIRD ANGLE PROJECTION	
MATERIAL:	N/A
DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	
.XX .XXX ANG.	.01 .005 .5
DATE	06-0C-00
CHECKED BY:	
TRACED BY:	
SCALE	0.375
MASTER	
SHEET NO.	10F1
TITLE:	ASSY, SIDE GUIDE
MODEL:	215
FINISHES:	N/A
REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED	
ALL DIMENSIONS ARE FINISHED DIMENSIONS	
DO NOT SCALE - WORK TO DIMENSIONS ONLY	

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			SIDEGUIDE, FEEDER W/ ROLLERS LH		
6	1	RHNO10			NUT, HEX 1/4		



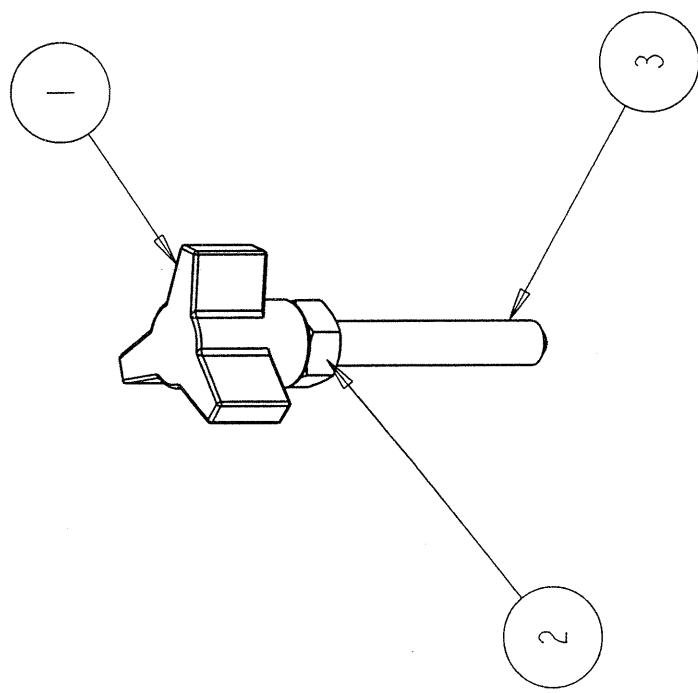
DRAWN BY:	MM	SCALE	0 . 500	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED		MATERIAL:	N / A	THIRD ANGLE PROJECTION	KIRK - RUDY, INC.
				.XX	.XXX	ANG.			KENNE SAW, GEORGIA
CHECKED BY:		DATE	12-Apr-99	.01	.005	.5	HEAT TREAT:	N / A	
TRACED BY:		MASTER	M	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED		FINISH:	N / A	MODEL: 215	TITLE: ASSY, SIDE GUIDE LH
				ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY					RECD WHERE USED
									I 535412-01

ITEM QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	102119	KNOB					
2	500755	CLAMP - SIDE GUIDE					
3	2	500771 CLIP-SIDE GUIDE					
4	1	102119-A ASSY, KNOB					
5	1	500788-18R SIDEGUIDE, FEEDER W/ROLLERS RH					
6	1	RHN010 NUT, HEX 1/4					



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 COPIED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY INC. KENNESAW, GEORGIA
CHECKED BY:	DATE	.xx	.xxx	ANG.	HEAT TREAT:	N / A		
TRACED BY:	MASTER	12 - Apr - 99	.01	.005	.5	FINISH:	N / A	TITLE: ASSY, SIDE GUIDE RH
			REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED		ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE. WORK TO DIMENSIONS ONLY			
					SHEET NO.: 1 OF 1		DRAWING #	500755AR

ITEM QTY	PART #	DESCRIPTION
1	102119	KNOB
2	RHN010	NUT, HEX 1/4
3	SYA604	SET SCREW



REV NO	DATE	DESCRIPTION	ECN NO	BY
1	10/5/2001	WAS 1.25" SET SCREW NOW 2" SET SCREW		TJG

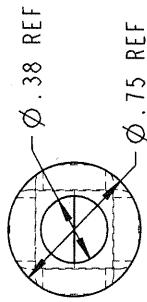
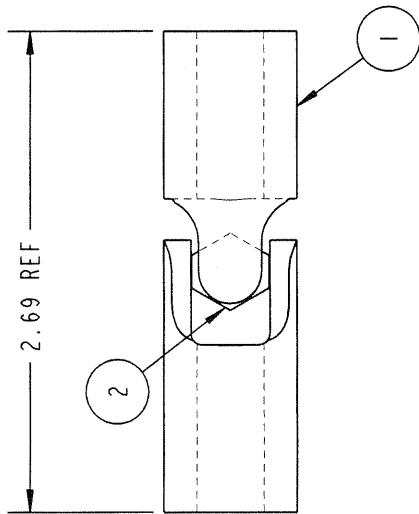
REQ'D	WHERE USED																									
KIRK - RUDY, INC KENNESAW, GEORGIA																										
<p>PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE COPIED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK - RUDY, KENNESAW, GA 30144 USA.</p> <p>THRO ANGLE PROJECTION</p>																										
<p>MATERIAL: N/A</p> <p>DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED</p> <table border="1"> <tr> <td>.01</td> <td>.005</td> <td>.005</td> <td>HEAT TREAT:</td> <td>N/A</td> </tr> <tr> <td>.01</td> <td>.005</td> <td>.005</td> <td>FINISH:</td> <td>N/A</td> </tr> <tr> <td colspan="4">REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED</td> <td></td> </tr> <tr> <td colspan="4">ALL DIMENSIONS ARE FINISHED DIMENSIONS</td> <td></td> </tr> <tr> <td colspan="4">DO NOT SCALE - WORK TO DIMENSIONS ONLY</td> <td></td> </tr> </table> <p>MODEL: GENERAL</p> <p>SHEET NO: 1 OF 1</p> <p>TITLE: ASSY, KNOB</p> <p>DRAWING #: 102119-A</p>		.01	.005	.005	HEAT TREAT:	N/A	.01	.005	.005	FINISH:	N/A	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED					ALL DIMENSIONS ARE FINISHED DIMENSIONS					DO NOT SCALE - WORK TO DIMENSIONS ONLY				
.01	.005	.005	HEAT TREAT:	N/A																						
.01	.005	.005	FINISH:	N/A																						
REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED																										
ALL DIMENSIONS ARE FINISHED DIMENSIONS																										
DO NOT SCALE - WORK TO DIMENSIONS ONLY																										
DRAWN BY: RSH	SCALE .000																									
CHECKED BY:	DATE 12 - Jun - 01																									
TRACED BY:	MASTER M																									

DRAWING #

100800

ITEM QTY	PART #	DESCRIPTION
1	2	100800_1 UNIVERSAL
2	1	100800_3 UNIVERSAL

REV NO	DATE	DESCRIPTION	ECN NO	BY
1	2-11-98	RE-DRWN IN PRO-E	6234	NJG



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

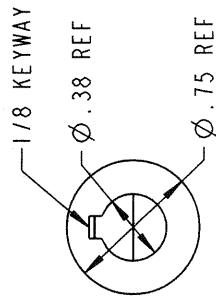
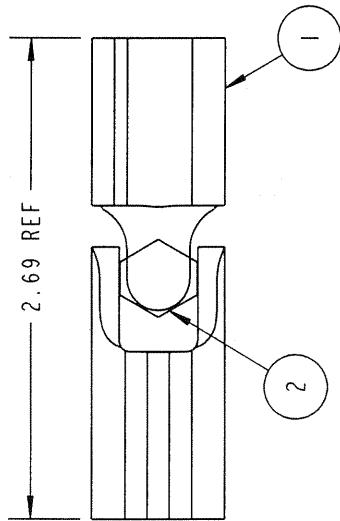
DRAWN BY: N A J	SCALE 1 . 000	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	MATERIAL: PURCHASED	THIRD ANGLE PROJECTION	PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE QUOTED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY INC. KENNESAW, GA 30144 USA
CHECKED BY:	DATE 30 - MAY - 90	.xx .xxx ANG. .01 .005 .5	HEAT TREAT: N / A	MODEL: 215	TITLE: ASSY, UNIVERSAL JOINT
TRACED BY:	MASTER <i>M</i>	REMOVE ALL BURRS AND SHARP EDGES UNLESS NOTED ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY	FINISH: N / A	SHEET NO.: OF 1	DRAWING # 100800

DRAWING #

100800 - 1

ITEM QTY	PART #	DESCRIPTION
1	2	100800-1-1 UNIVERSAL
2	1	100800_3 UNIVERSAL

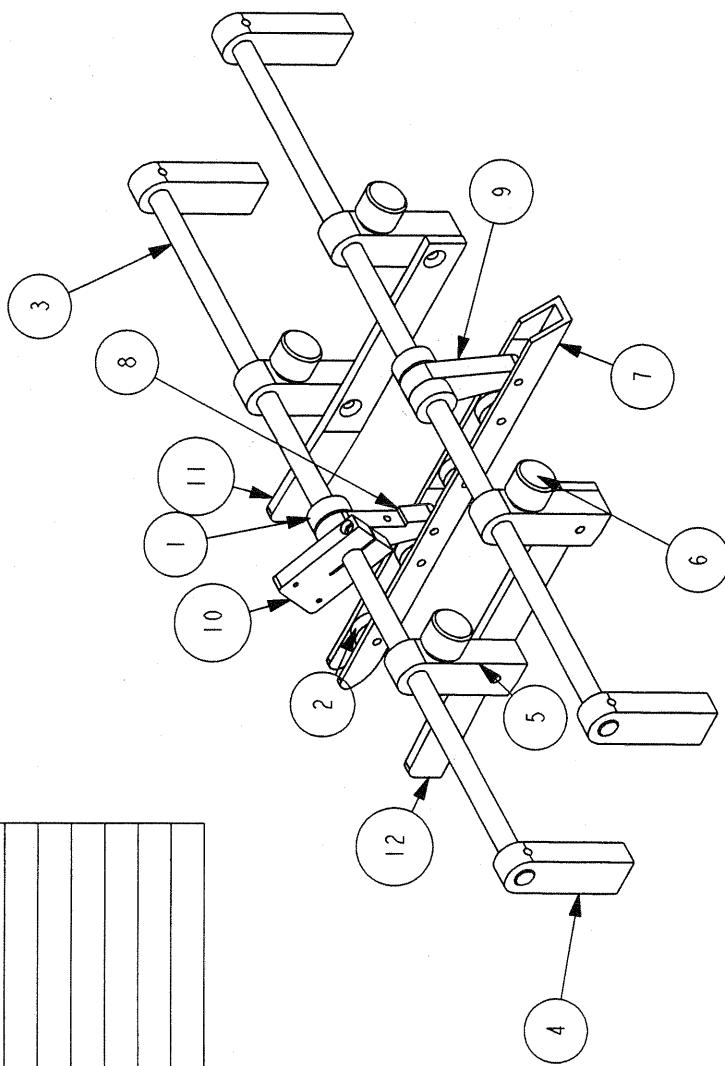
REV NO	DATE	DESCRIPTION	ECN NO	BY
I	2-11-98	RE-DRWN IN PRO-E	6234	NJG



1	531679-01
1	500704-A
REO'D WHERE USED	

DRAWN BY:	SCALE	1 .000	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	MATERIAL: PURCHASED	THIRD ANGLE PROJECTION	KIRK - RUDY INC, KENNESAW, GEORGIA
CHECKED BY:	DATE	.000	.01 .005 .005	HEAT TREAT: N/A	MODEL: 215	TITLE: ASSY, UNIVERSAL JOINT
TRACED BY:	MASTER	31 - JUL - 79	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED	FINISH: N/A	SHEET NO.: 1 OF 1	DRAWING #: 100800 - 1

ITEM QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	3	102205 COLLAR .500					
2	4	103107 BEARING, FLAT .312					
3	2	500787 SHAFT-SIDE GUIDE ADJ.					
4	4	500791 POST, SIDE GUIDE					
5	4	500792 POST, SIDE GUIDE					
6	4	500793 LOCK, SIDE GUIDE CAM					
7	1	502408 CHANNEL, SKID BAR					
8	1	500800-A ASSY, LINK					
9	1	500801A ASSY, LINK					
10	1	500802A ASSY, CLAMP					
11	1	502409-L RAIL, GUIDE					
12	1	502409-R RAIL, GUIDE					



1	SP82700
REO-D	WHERE USED
ASSY, SIDE GUIDE & SKIDBAR	KIRK - RUDY INC., KENNESAW, GEORGIA
SP82700	TITLE: DRAWING #
1 OF 1	538572-01

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

THIRD ANGLE PROJECTION

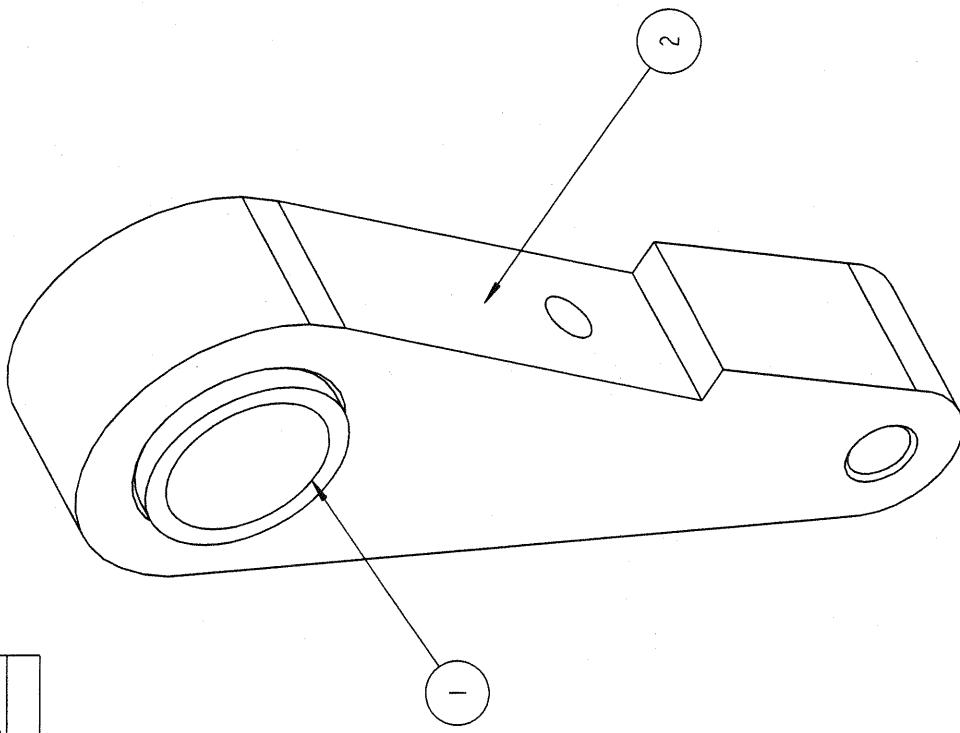
MATERIAL: N/A	NOTE: SP82700
DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	SHEET NO. 1 OF 1
.XX -.XXX .005 .01 .5 ANG.	
HEAT TREAT: N/A	
FINISH: N/A	

DRAWN BY: T J G SCALE: 0 .250 DIMENSIONS IN INCHES

CHECKED BY: DATE: 01-NOV-00 REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED

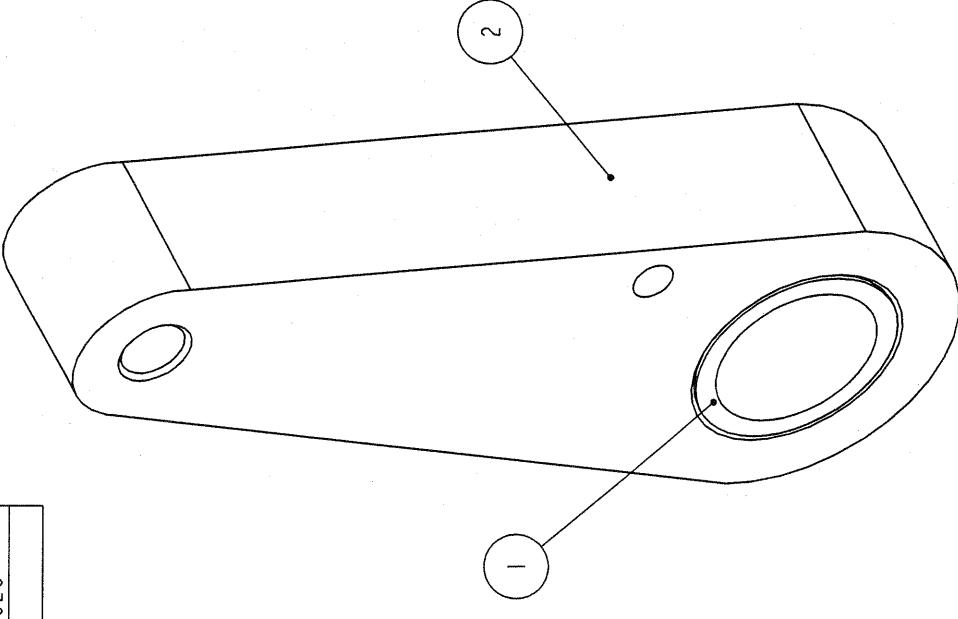
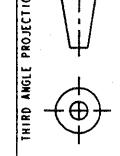
TRACED BY: MASTER M ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE WORK TO DIMENSIONS ONLY

ITEM QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	1	100162 BUSHING, SL. 500 ID. 625 OD. 625 LG					
2	1	500800 LINK-SKID-FRONT					

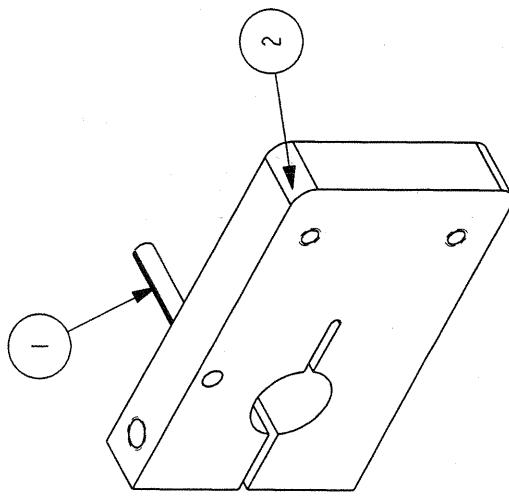


1	533821-01
REO'D	WHERE USED
<p style="text-align: center;">KRK KIRK - RUDY, INC. KENNESAW, GEORGIA</p>	
<p style="text-align: center;">PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE QUOTED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK RUDY INC. KENNESAW, GA 30044 USA</p>	
THIRD ANGLE PROJECTION	
MATERIAL:	N/A
DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	
.XX	.XXX
ANG.	ANG.
.01	.005
.5	
HEAT TREAT:	N/A
MODEL:	X
TITLE:	ASSY, LINK
SHEET NO.:	10F1
DRAWING ■	500800-A
DRAWN BY: MY	SCALE 2.000
DIMENSIONS IN INCHES	
CHECKED BY: - May - 98	DATE
TRACED BY: M	MASTER
<p style="text-align: center;">REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED</p>	
<p style="text-align: center;">ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE TO DIMENSIONS ONLY</p>	

DRAWING 1 A 500801

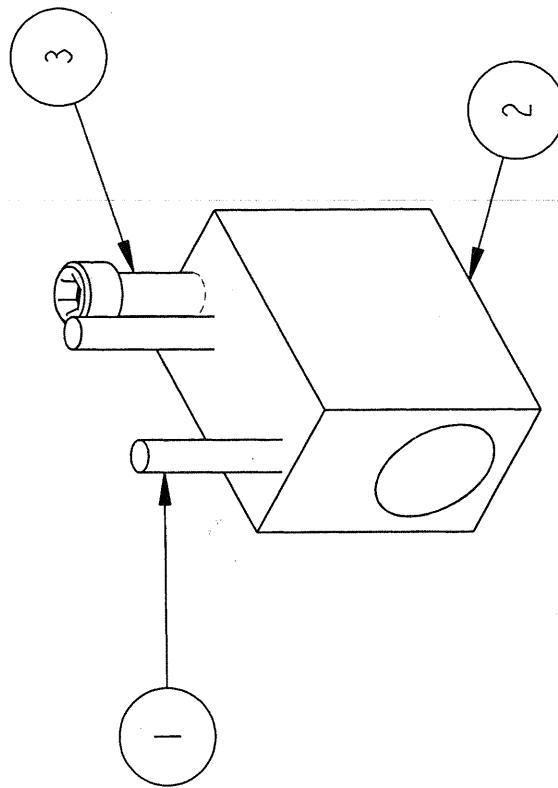
DRAWING #						500801A		
ITEM	QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	1	100162	BUSHING, SL. 5001D. 6250D. 625LG					
2	1	500801	LINK-SKID-REAR					
						1	533821-01	
						1	531925-01	REO-D WHERE USED
DRAWN BY:		SCALE	2 . 0 0 0	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	MATERIAL:	N / A	THIRD ANGLE PROJECTION	KIRK - RUDY INC.
			.xx	.xxx	ANG.			 KENNEBUNK, GEORGIA
CHECKED BY:		DATE	8 - May - 98		HEAT TREAT:	N / A	MODEL:	215
TRACED BY:		MASTER	/	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED	FINISH:	N / A	TITLE:	ASSY, LINK
				ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY			SHEET NO.:	OF 1
							DRAWING #	500801A

ITEM QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	1	105201 PIN, ROLL .125X 1.000					
2	1	500802 HOLDER-SKID SWITCH					



1	533821-01
REQ'D	WHERE USED
 KIRK - RUDY INC. KENNEBUNK, 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. KENNEBUNK, GA 30144 USA</small>	
THIRD ANGLE PROJECTION	TITLE:
	ASSY, CLAMP
MATERIAL:	215
N / A	SHEET NO.: 10F1
DRAWING # 500802A	
DRAWN BY: MY	SCALE: 1.000
DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	
xx	.000
.01	.005
.01	.005
ANG.	.5
HEAT TREAT:	
N / A	
DATE: 12 - Apr - 99	FINISH:
REMOVE ALL BURS AND SHARP EDGES UNLESS OTHERWISE NOTED	
ALL DIMENSIONS ARE FINISHED DIMENSIONS	
DO NOT SCALE. WORK TO DIMENSIONS ONLY	
CHECKED BY: M	MASTER
TRACED BY: M	

ITEM QTY	PART #	DESCRIPTION
1	2	105400 DOWEL, PIN .188X1.250
2	1	541989-01 GUIDE, BELT 3/4
3	1	CSD0297 SCREW, SHCS 1/4-20X1.250

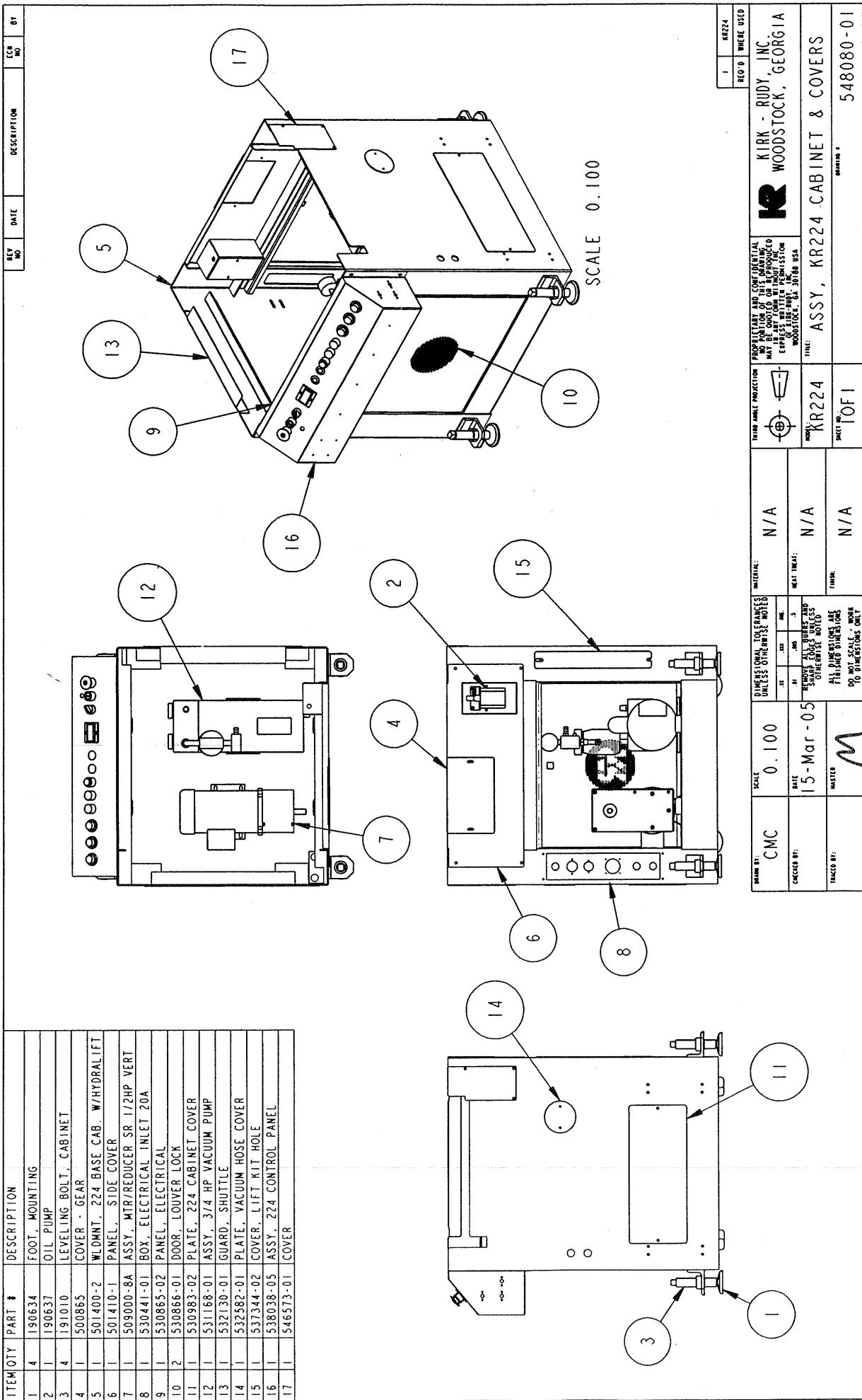


DRAWN BY: A KEY	SCALE: 1 .000	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED			MATERIAL: N/A	THIRD ANGLE PROJECTION	PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE QUOTED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC. KENNESAW, GA 30144 USA
CHECKED BY:	DATE: 20-Feb-02	.01	.005	.5	HEAT TREAT: N/A	MODEL: SP98100	ASSY, 3/4 BELT GUIDE
TRACED BY:	MASTER M	REMOVED 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: 1 OF 1	DRAWING # 541992-01
						2 SP98100 REQ'D WHERE USED	

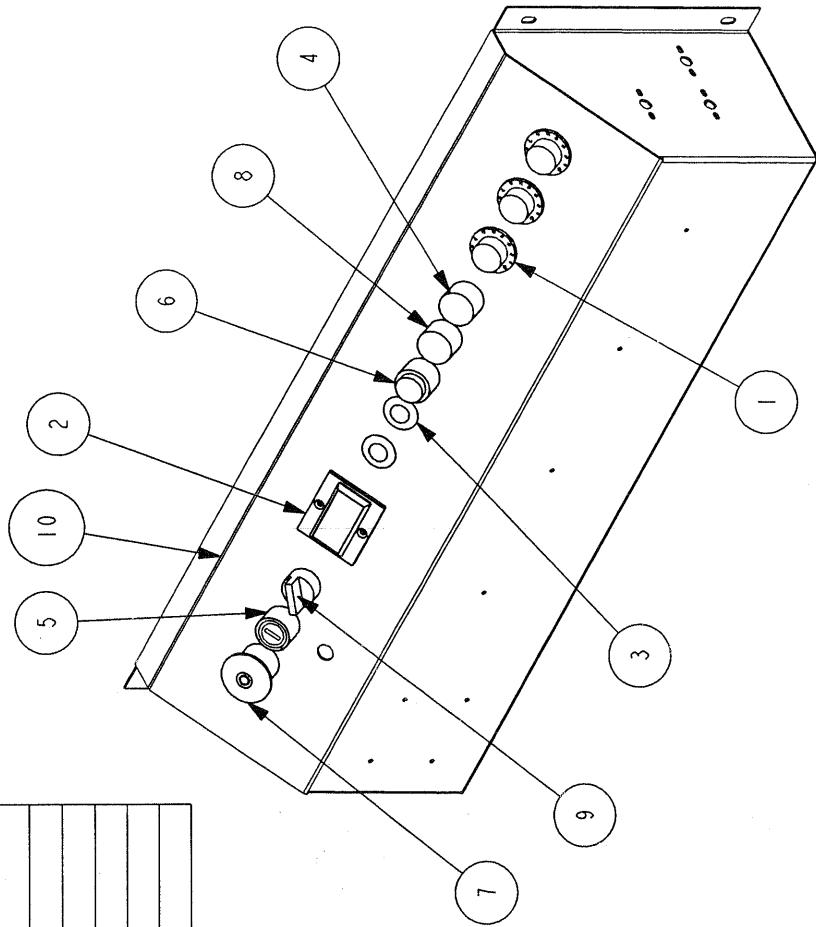
ITEM QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	1	SPRING, COIL					
2	1	LIFTER- FEEDER PUSHER					
3	1	PLATE-FEEDER PUSHER BOTTOM					
4	1	PLATE-FEEDER PUSHER TOP					

X XXX
REQ'D WHERE USED

DRAWN BY: T JG	SCALE 2.000	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED			MATERIAL: NOTED	THIRD ANGLE PROJECTION	
CHECKED BY:	DATE 19-Jan-98	.005	.01	.005	ANG. .5		NO. OF VIEWS 1
TRACED BY:	MASTER <i>M</i>	FINISH: REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY			NOTED	SHEET NO.: 1 OF 1	TITLE: ASSY, LIFTER FEEDER PUSHER
							DRAWING # 500760-A



ITEM QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	3	209016 KNOB, POT					
2	1	200012A COUNTER, LCD 310					
3	2	200373-6 PLUG, 875					
4	1	201124-2 BUTTON, START					
5	1	201124-4 BUTTON, POWER ON					
6	1	201125-3 BUTTON, STOP					
7	1	201125-5 BUTTON, POWER OFF					
8	1	201126-1 BUTTON, JOG					
9	1	201145-1 SELECTOR, 2 POSITIONS					
10	1	528247-5 BOX, 219 CONTROL					



DRAWN BY: CMC	SCALE: 0 .200	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: 26-May-05	.XX .XXX .005 .005 .5	HEAT TREAT: N/A	MODEL: 224	TIME: ASSY, 224 CONTROL PANEL
TRACED BY:	MASTER 	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED	FINISH: N/A	SHEET NO. 0F2	DRAWING I
		ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY			538038-05

I	548080-01
REQ'D	WHERE USED

ITEM QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	1	190660 NIPPLE, 1/2 IN TUBING					
2	1	200102 VALVE, RELIEF GAST 822/823					
3	1	200108 STEM GAST 822/823					
4	1	200109 PLATE GAST 822/823					
5	1	200124 PUMP, VACUUM GAST					
6	1	501645 BLOCK, CONNECTOR (VACUUM PUMP)					
7	1	200100-1 GAUGE, VACUUM GAST 822/823					
8	1	200100-2 FILTER, VACUUM GAST 822/823					
9	1	200100-3 JAR, GLASS GAST 822/823					
10	1	200100-13 NIPPLE, STEEL					
11	1	200100-14 ELBOW, PIPE GAST 822/823					
12	1	200100-16 COUPLING GAST 822/823					
13	1	200100-21 NIPPLE, STEEL					
14	1	200100-22 COUPLING, STEEL					
15	1	200100-23 PLUG, SQUARE HEAD GAST 822/823					
16	1	200100-26 COVER FOR AB992 GAST 822/823					
17	2	200124-2 FILTER, FELT GAST 823					
18	2	200124-4 END CAP, AK510 GAST 823					
19	1	200124-5 MUFFLER, SINTERED GAST 823					
20	2	200124-6 O-RING, GASKET GAST 823					

DRAWN BY:		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. KENNESAW, GA 30144 USA
		MY	.01 .005 .005	.01 .005 .005	AMG.		
CHECKED BY:		DATE	20-Jun-97	HEAT TREAT:	NONE	MODEL:	KIRK - RUDY, INC.
TRACED BY:		MASTER		FINISH:	NONE	SHEET NO.	KENNE SAW, GEORGIA
				ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY		DRAWING #	531168-01

ITEM	QTY	PART #	DESCRIPTION	REV	DATE	ECN	BD
1	2	103804	BEARING, HUB - 625				
2	1	108888	PULLEY, TIMING 12L050 .625B .188K				
3	1	5036.9	SHAFT				
4	1	509006	PLATE - REAR SIDE				
5	1	509007	PLATE - GEARBOX 1/2 HP SINGLE RED				
6	1	509037	COVER, REDUCER				
7	1	108912-1	BELT, TIMING 187L050				
8	1	109319-1	PULLEY, TIMING 32L050 .625B .188K				
9	1	200152-2	MOTOR, LEESON DC 1/2HP				
10	5	SP16208	SPACER, REDUCER				

1 XXX
RECD WHERE USED

Front View Drawing:

NAME #: T JG	SCALE: 0 .500	DIMENSIONAL TOLERANCES			FINISH PROJECTION		
DATE: 3 - Nov - 98	IN	MM	IN	MM	IN	MM	
MAKER: M	.000 -.005			.000 -.005			
TRACK #: 1	.000 -.005			.000 -.005			
REMOVED FROM BORES AND OTHER FEATURES				GENERAL			
FINISHED FEATURES				SET N/C OF 1			
NO. NOT SCALE - WORK TO DIMENSIONS ONLY							

KRK KIRK-RUDY, INC.
WOODSTOCK, GEORGIA

ASSY, MTR/REDUCER SR 1/2HP VERT
Drawing #: 509000-8A

7 ELECTRICAL SCHEMATICS AND PARTS

7.1 SCHEMATIC LIST

The following wiring diagrams are included in the manual packet for your reference.

200-171-00-14 224 Single Motor Inkjet

7.2 PARTS LIST

KR Part #	Qty	Manufacturer	Description
202277	4	IDec	Socket, Relay 700HN116/SH2B-05
202291	4	IDec	Relay, 24VAC 700-HF32A24-4RH28-ULC
202426	2	KB	Board, 90VDC Motor KBMM-2250 120VAC
202742	1	AEG	Contactor, 3P, 20A, 24VAC
208022	1	Buss	Fuse, 8A AGC/GGC
208023	4	Buss	Fuse, 12A AGC/GGC
208044	1	Buss	Fuse, 4A AGC/GGC
208045	2	Buss	Fuse, 2 MDL
209163	3.188	Phoenix	Din Rail, NS35/7.5 Per Foot
209234	11	Phoenix	Block, Terminal UK16
209236	54	Phoenix	Block, Terminal UK3MVSTB-5.08
209237	3	Phoenix	Terminal, Ground USLKG16
209238	3	Phoenix	End, Block E-UK
209241	9	Phoenix	Cover, End DUK3-MVSTB
209245	1	Phoenix	Holder, Fuse 24V UK6.3-HEILED24
209247	8	Phoenix	Holder, Fuse 250V CHCC1
202427-1	1	KB	Resistor, 0.05 Ohm 9839 1/4hp 90VDC Motor
202427-2	1	KB	Resistor, 0.025 Ohm 9841 1/2hp 90V, 1hp 180V
203022-2	1	Micron	Transformer, B050-0021-GA 240VAC
208056-0	2	Buss	Fuse, LP-CC 6/10
208056-7	2	Buss	Fuse, LP-CC 8
208056-10	1	Buss	Fuse, LP-CC 15
208056-15	2	Buss	Fuse, LP-CC 1.25

8 APPENDIX

8.1 POSSIBLE OPTIONS

The KR224 base can be modified to handle a variety of applications, contact your Kirk-Rudy dealer or call Kirk-Rudy direct to discuss you specific application.

Here is a list of some of the options offered for the KR224 base:

- Rubber Tip Feeder Gate
- Inline Label Base for second application head
- Modifications to increase thickness limits
- Auto Load Conveyor. Designed for ease of loading of thick product, automatically maintains pre-determined level in feeder.
- Shuttle “Low Product” Detector (stops machine).
- Hydra Lift to adjust machine height (see print 537341-01 on next page).

ITEM	QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	4	102792	SPRING, EXTENSION					
2	1	191029-1	PUMP, MOVOTEC PB4612FC					
3	4	191029-2	CYLINDER, LIFT CB415					
4	4	191029-3	GLIDE, SUSPA					
5	3	537343-01	SPACER, LIFT KIT MOUNT					
6	4	537371-01	BRACKET, SPRING RETURN MOUNT					
7	4	537596-01	BLOCK, HYDRAULIC LIFT LH					
8	4	537596-02	BLOCK, HYDRAULIC LIFT RH					
9	2	537597-01	BRACKET, HYDRAULIC LIFT SPRING					
10	2	537597-02	BRACKET, HYDRAULIC LIFT SPRING					
11	2	CSD0266	SCREW, SHCS 10-32X.625					

I SP76300
REV D WHERE USED

KIRK - RUDY, INC.
KIRK KENNESAW, GEORGIA

KR

THIS 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 30044 USA

Model: 5335
Title: KIT, TABBER HYDRAULIC LIFT

SHEET NO: 1 OF 1
Drawing #:

537341-01

DRAWN BY:
A KEY SCALE: 0 . 130
DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED
xx .005 .5
.01 .005 .5
HEAT TREAT:

DATE: 10-Dec-02	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED
MASTER	ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE TO DIMENSIONS ONLY

9 NOTES

10 WARRANTY AND SERVICE

WARRANTY

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

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

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

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

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

USE ONLY GENUINE KIRK-RUDY REPLACEMENT PARTS

770-427-4203

KIRK-RUDY, INC
125 LORRAINE PARKWAY
WOODSTOCK, GA 30188