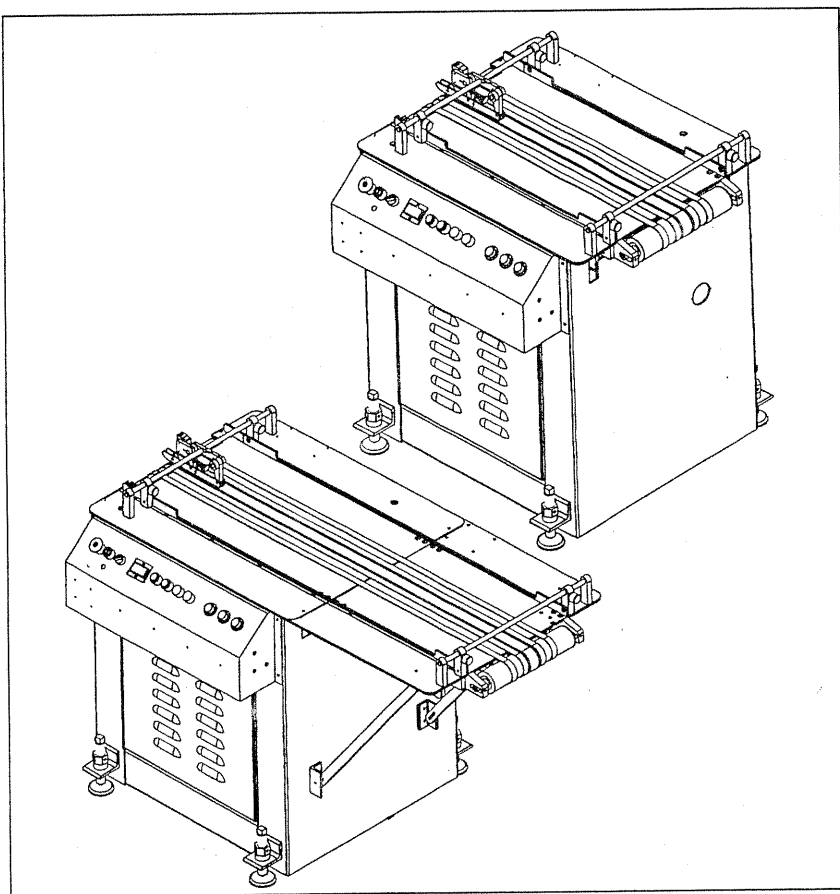


# ***Kirk-Rudy, Inc.***

## **Instruction**

## **and Parts Manual KR219**

## **Ink Jet Base & 20" Ext. 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.

10000-219IJ REV. 2 11/17/99

# **Manual**

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

# 1 Important Safety Instructions

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Intended Use Statement: The Kirk-Rudy Inc. 219 Ink Jet Base and Kirk-Rudy Inc. 219 Ink Jet Base plus 20" extension are inline transport tables.

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



## WARNING

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

## 2 SPECIFICATIONS

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PRODUCT SIZE RANGE	English	Metric
Minimum Size:	3" W x 5" L	7.6cm W x 12.7cm L
Maximum Size:	17" W x 16" L	43.2cm W x 40.6cm L
Minimum Thickness:	Card Stock (.007")	Card Stock (.10mm)
Maximum Thickness:	.625"	15.9 mm

### PHYISCAL SIZE (STANDARD)

Length	30.5"	77.4 cm
Width	30.5"	77.4 cm
Height	36"	91.4 cm
Weight	380 lbs	172 kg
Shipping	410 lbs	185 kg

### PHYISCAL SIZE (20" EXT)

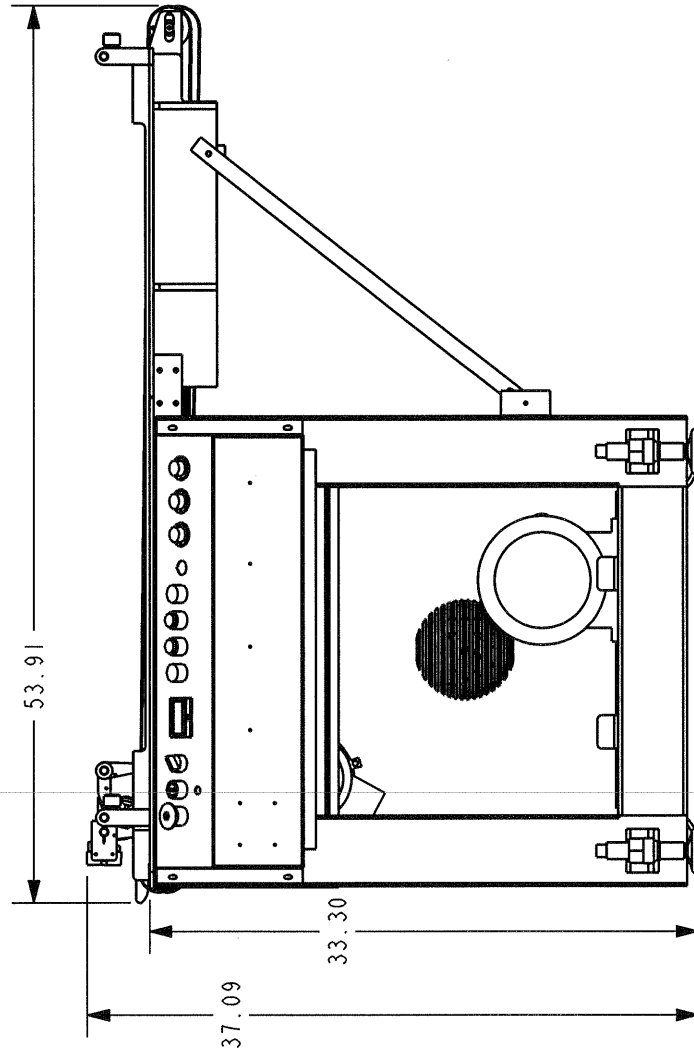
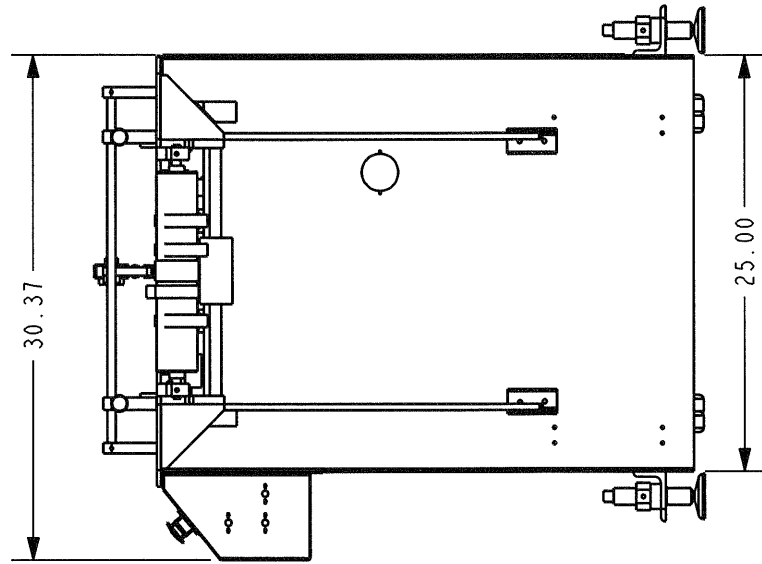
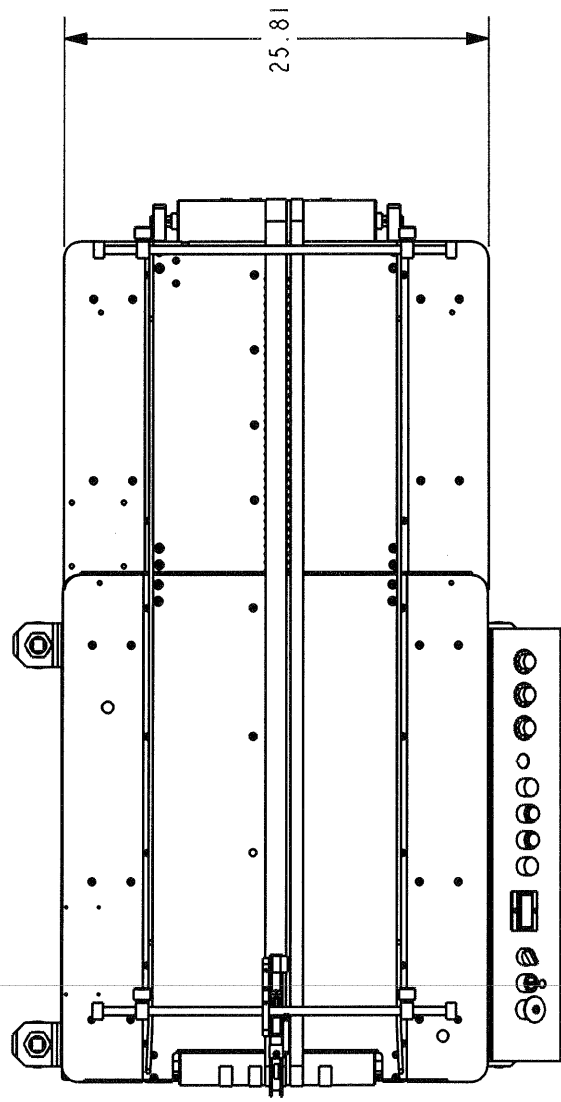
Length	53.5"	135 cm
Width	30.5"	77.4 cm
Height	36"	91.4 cm
Weight	430 lbs	195 kg
Shipping	460 lbs	208 kg

### MAXIMUM SPEED

650 feet per minute

### ELECTRICAL REQUIREMENTS

Main Power	120V, single phase, 60 cycle, AC 15 amps
Vacuum Pump	1/2 hp
Drive Motor	1/2 hp
NEMA Plug Connection	5-15P



KR219+20

## 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.

## 4 OPERATING INSTRUCTIONS



### **WARNING**

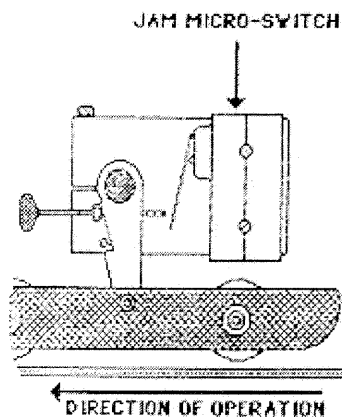
Read and follow all Safety Instructions in Section 1, Page 3 before proceeding.

#### 4.1 CONTROL PANEL (Figure 1.0)

1. POWER OFF BUTTON: Shuts power to machine.
2. POWER ON BUTTON: Turns on power to machine.
3. BLOWER TOGGLE SWITCH: Turns on/off blower.
4. COUNTER: Counts the product.
5. FEEDER STOP BUTTON: Turns off feeder.
6. MOTOR SPEED CONTROL: Controls the speed of the feeder. "0" is minimum speed, "10" is maximum speed.
7. CONVEYOR SPEED CONTROL: Controls the speed of the conveyor. "0" is minimum speed, "10" is maximum speed.
8. CONVEYOR SPEED UP CONTROL: Controls the speed up speed. "0" is minimum speed, "10" is maximum speed.

#### 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 two stop switches on the KR219IJ and KR219IJ+20. They are the jam microswitch on the skid bar assembly, and the control panel emergency stop button.



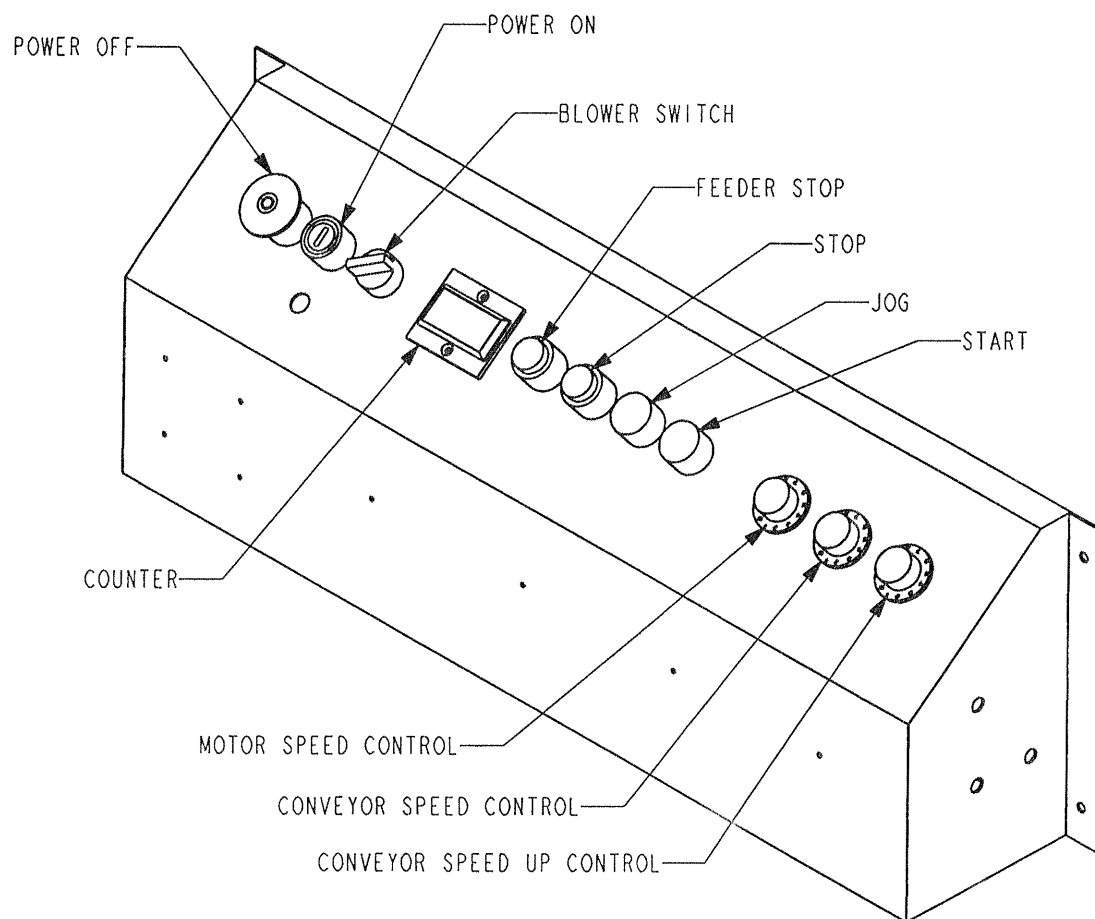


FIGURE 1.0 - 2191J &amp; 2191J+20" CONTROL PANEL

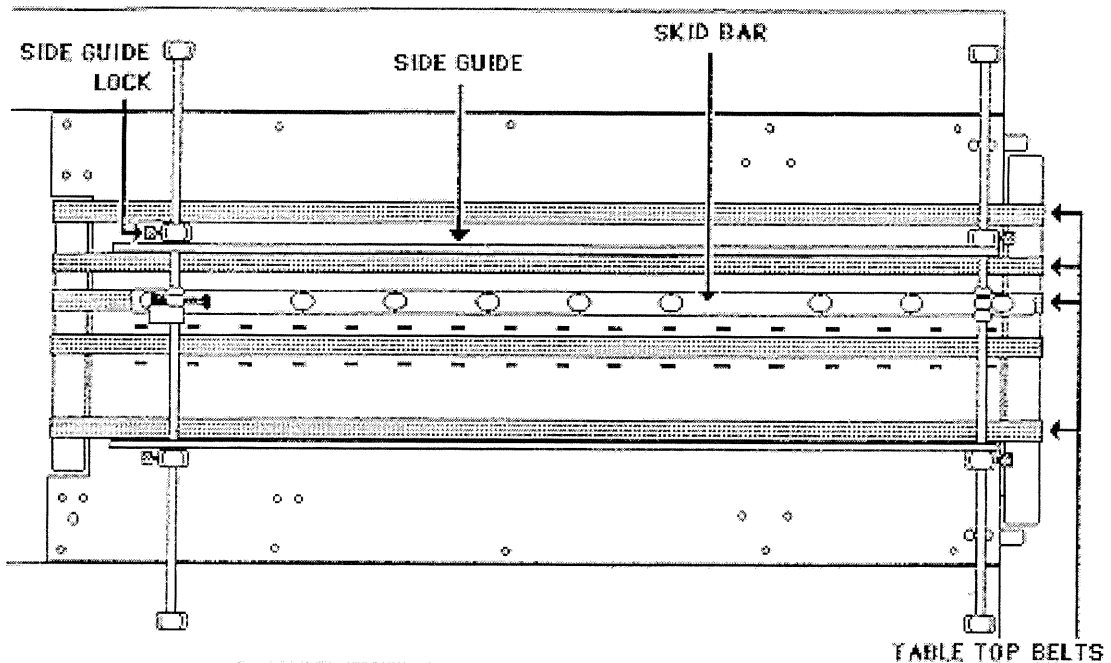


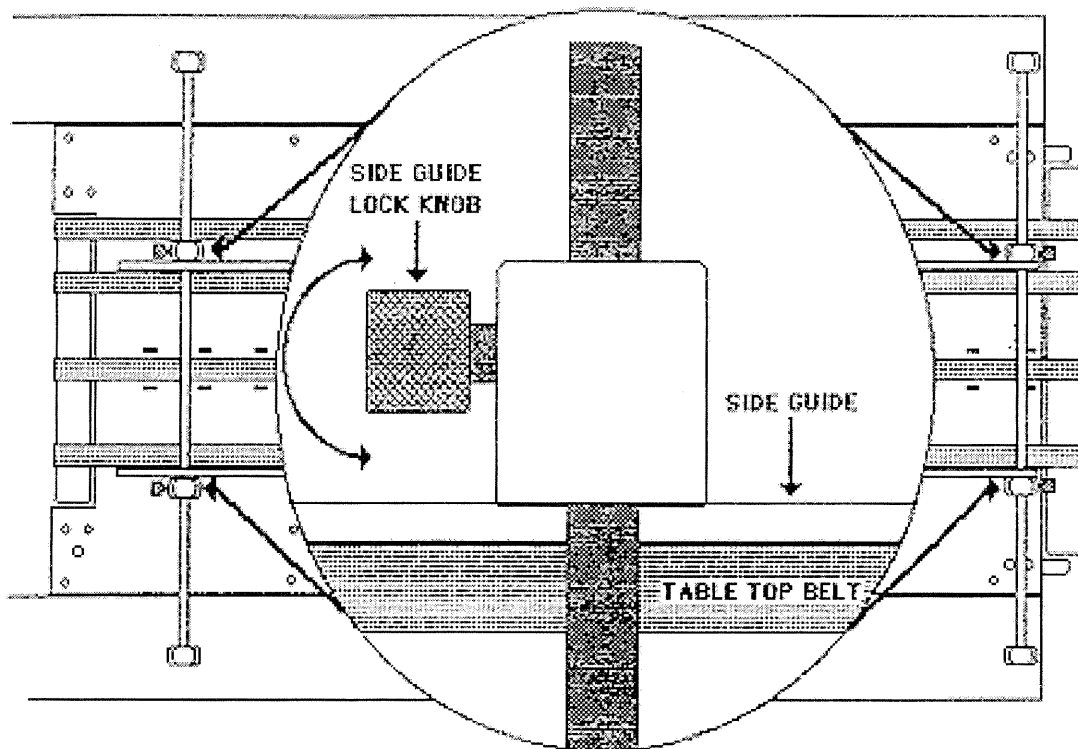
### 4.3 SEQUENCE OF SET-UP

1. Position tabletop side guides.
2. Set micro jam switch and adjust skid bar to product height.
3. Turn and pull the power off button and stop button.
4. Plug conveyor up or if no conveyor, use jumpers to complete circuit. Machine will not run with incomplete circuit.
5. Turn power on.
6. Press start button.
7. Adjust tabletop belts.

### 4.4 SIDE GUIDES

Side guides are used to keep the product feeding in one direction and in an orderly manner. It is an important part of the 219IJ and 219IJ+20. To adjust the side guides, place the product on the tabletop belts and unlock the side guide lock knobs. Slide side guides to 1/16" on both sides of the product. Lock side guides into place with lock knobs.

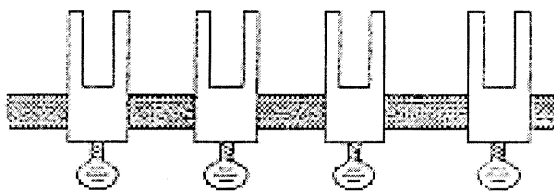




If the side guides are too tight, the mailing piece will not move across the tabletop. If they are too loose, the mailing piece may skew and the ink will be placed on crooked.

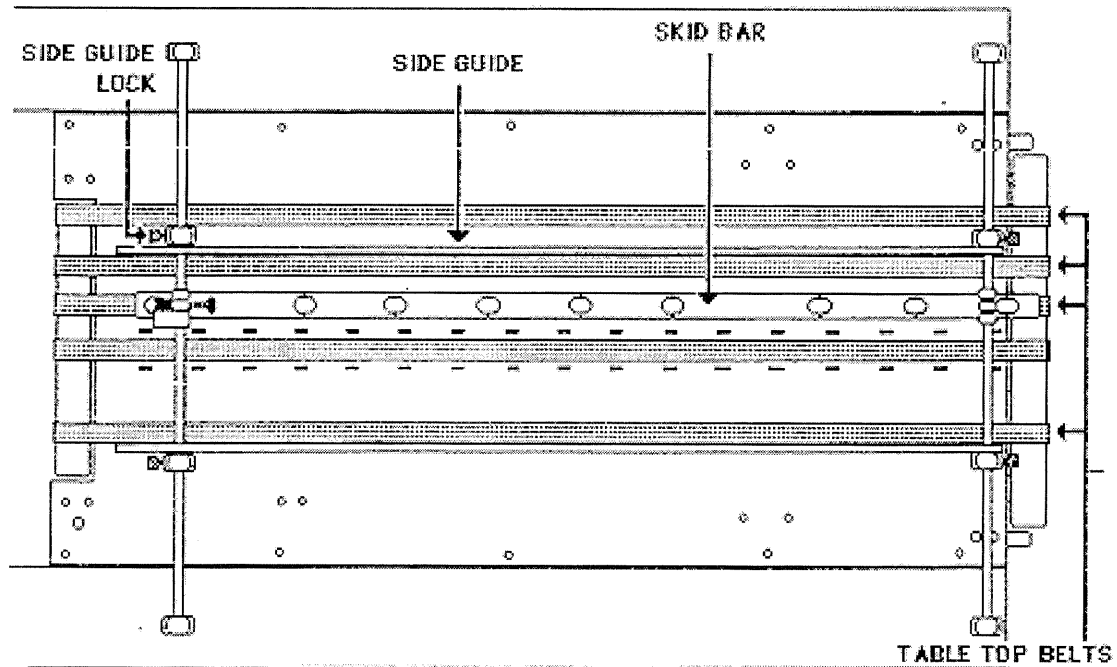
#### 4.5 TABLETOP BELTS

The tabletop belts are designed to transport the product from the feed rollers, under the labeling head and onto the conveyor. There are five tabletop belts on the KR219IJ and KR219IJ+20. However, not all of them are needed for every product. You may run the belts that are not needed outside of the side guides.



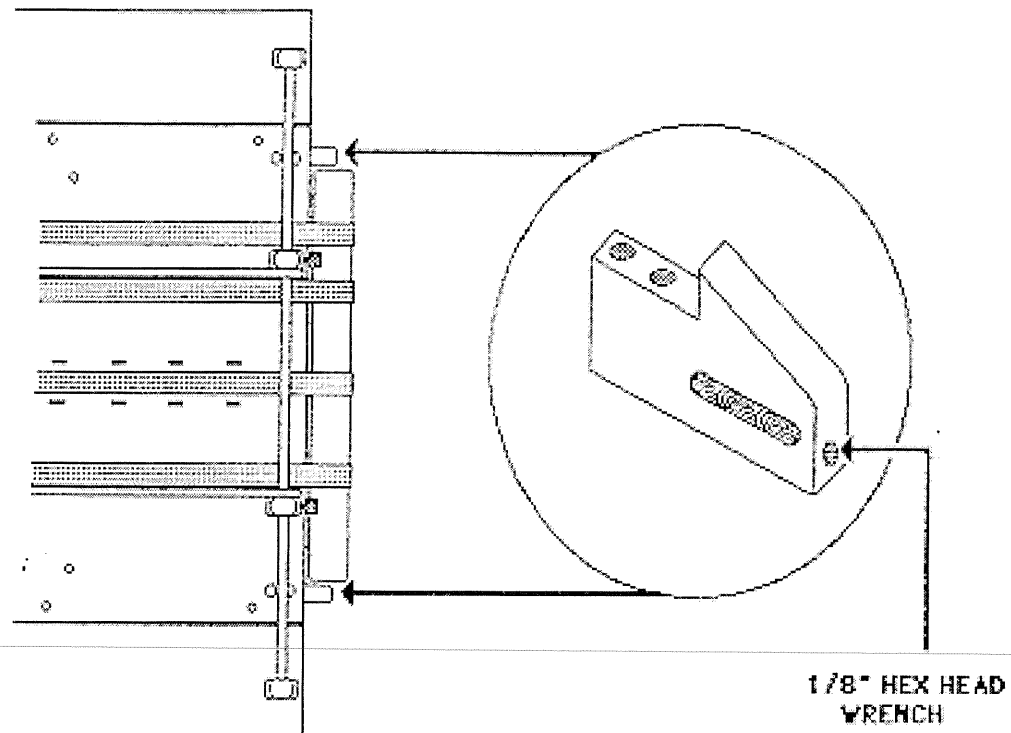
Underneath the tabletop is located guides for the tabletop belts. Each belt has its own guide. To move the belts, simply loosen the thumbscrew on the bottom of the guide and slide the guide on the shaft to the desired position and then tighten the thumbscrew.

The belts should be positioned so that there is a belt riding next to each side guide, one belt between the vacuum ports and, if used, 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.

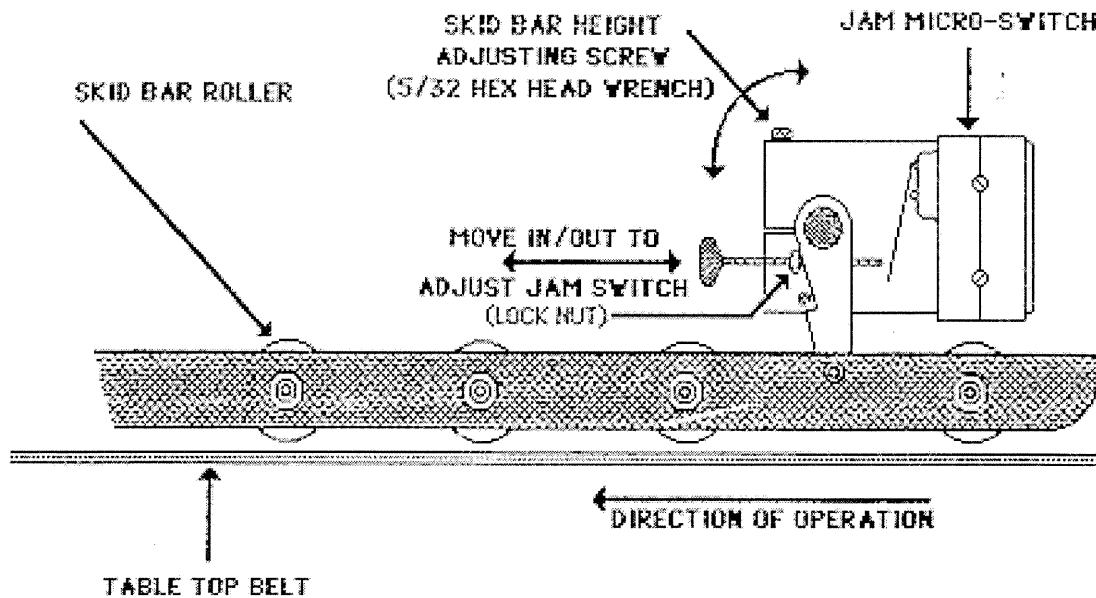
The tabletop belt tension can be adjusted. Caution should be taken not to over tighten. There should be just enough tension to prevent belt slippage.



## 4.6 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 KR219IJ and KR219IJ+20 are furnished with one skid bar. The skid bar is not needed when running small pieces such as cards or envelopes, but it 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

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### **WARNING**

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

#### **5.1 DAILY MAINTENANCE**

Remove excessive paper dust, ink, glue, and all other foreign materials from the tabletop and inside the base. Use a clean soft rag. Dampen rag with water if necessary.

## 6 PARTS LISTS AND DIAGRAMS

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### 6.1 PARTS LIST

See following pages for parts list.

### 6.2 DIAGRAMS

Drawing #	Description
KR219IJ	Assy, KR219IJ
535806-02	Assy, Side Guide
538019-01	Assy, 219IJ Tabletop
530619-01	Assy, Idler Roller
538018-01	Assy, Front Roller
538021-01	Assy, Skid Bar
538022-01	Assy, Motor Mount
530654-01	Assy, Motor Mtg Bar
538023-01	Assy, 219IJ Cabinet
538038-01	Assy, 219IJ Control Panel
KR219IJ20	Assy, KR219IJ w/ 20 in Ext
535806-03	Assy, Side Guide 20 in
538020-01	Assy, 219IJ Tabletop w/ 20 in Ext
536266-01	Assy, 20 in Ext Std IJ Base
500835-A	Assy, Tube Roller

ITEM#	QTY	PART#	DESCRIPTION
1	2	100162	BUSHING, SL.500ID.625OD.625LG
2	2	100320	BUSHING, FL.750ID1.000OD1.000LG
3	1	102114	KNOB
4	1	102205	COLLAR .500
5	2	103107	BEARING, FLAT .312
6	4	103804	BEARING, HUB .625
7	1	105201	PIN, ROLL .125X 1.000
8	8	105400	DOWEL, PIN .188X1.250
9	1	105602	SHAFT, THREADED 5/16-18
10	2	108809	PULLEY, TIMING 12L075 .625B .188K
11	1	190101	MICROSWITCH, LEVER
12	1	190203	COVER, MICROSWITCH
13	4	190634	FOOT, MOUNTING
14	4	191010	LEVELING BOLT, CABINET
15	4	191011	NUT, CABINET LEVELING
16	1	200120	BLOWER, GAST
17	3	209016	KNOB, POT
18	2	500716	BRACKET - BELT TAKE-UP
19	9	500721	GUSSET - TABLETOP SUPPORT
20	2	500725	GUIDE - BELT
21	2	500787	SHAFT-SIDE GUIDE ADJ.
22	4	500791	POST, SIDEGUIDE
23	4	500792	POST, SIDE GUIDE
24	4	500793	LOCK, SIDE GUIDE CAM
25	1	500800	LINK-SKID-FRONT
26	1	500801	LINK-SKID-REAR
27	1	500802	HOLDER-SKID SWITCH
28	1	500823	SHAFT, IDLER ROLLER
29	3	500824	SHAFT-BELT GUIDE
30	2	500834	SHAFT, SKID ROLLER
31	1	500835	ROLLER
32	2	500836	HUB
33	2	500838	HUB-BELT DRIVE
34	2	500875	BAR - SUPPORT EXT.
35	2	500876	ANGLE SUPP., ATTACHED TO CABINET
36	1	501201	PLATE, BASE SUPPORT RH
37	1	501202	PLATE, BASE SUPPORT LH
38	1	501210	WLDMNT, 219 BASE CABINET
39	1	503794	CLAMP
40	4	105981-2	BELT, FLAT 3/4 X 108 3/4
41	1	106212-1	BELT, FLAT 1 1/4 X 108 3/4
42	1	108952-2	BELT, TIMING 255L075
43	1	190101A	ASSY-SWITCH WITH COVER
44	1	200012A	COUNTER, LCD 310
45	1	200152-2	MOTOR, LEESON DC 1/2HP
46	1	201124-2	BUTTON, START
47	1	201124-4	BUTTON, POWER ON
48	2	201125-3	BUTTON, STOP
49	1	201125-5	BUTTON, POWER OFF
50	1	201126-1	BUTTON, JOG
51	1	201145-1	SELECTOR, 2 POSITIONS
52	1	500701-1L	PLATE BASE SUPPORT 20 IN EXT LH&RH

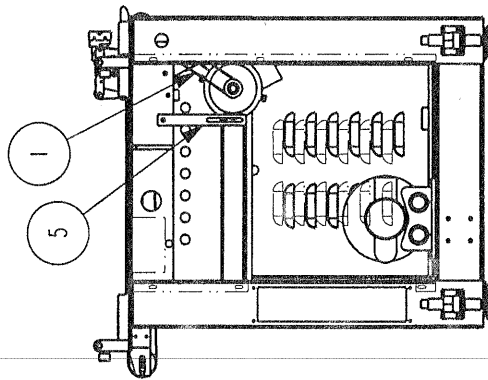
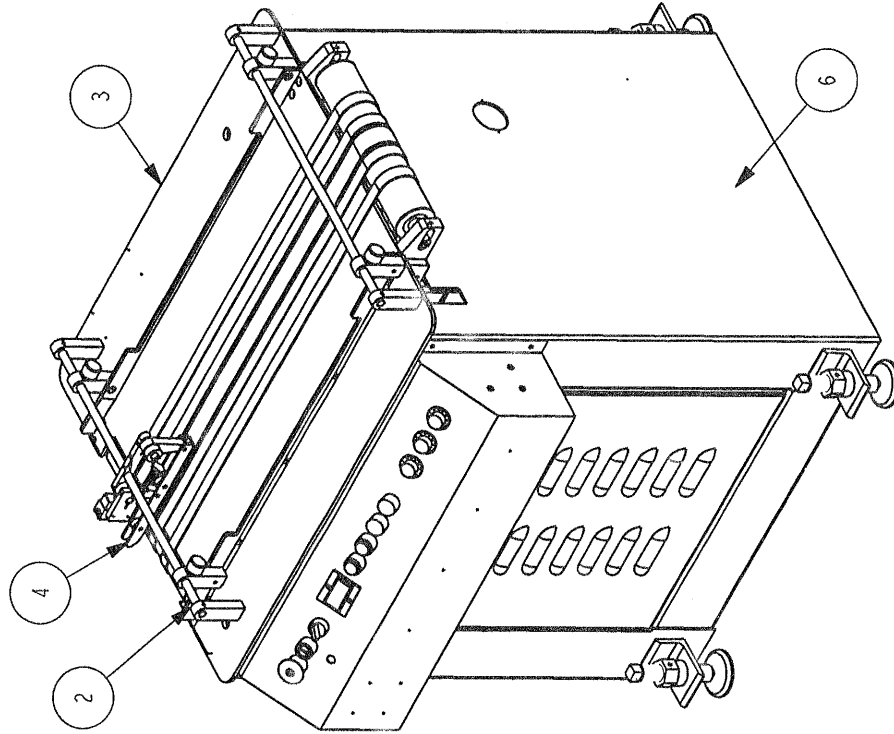
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KR2191J

ITEM QTY	PART #	DESCRIPTION
1	108952-1	BELT, TIMING 255L075
2	535806-02	ASSY, SIDE GUIDE
3	538019-01	ASSY, 2191J TABLETOP
4	538021-01	ASSY, SKID BAR
5	538022-01	ASSY, MOTOR MOUNT
6	538023-01	ASSY, 2191J CABINET

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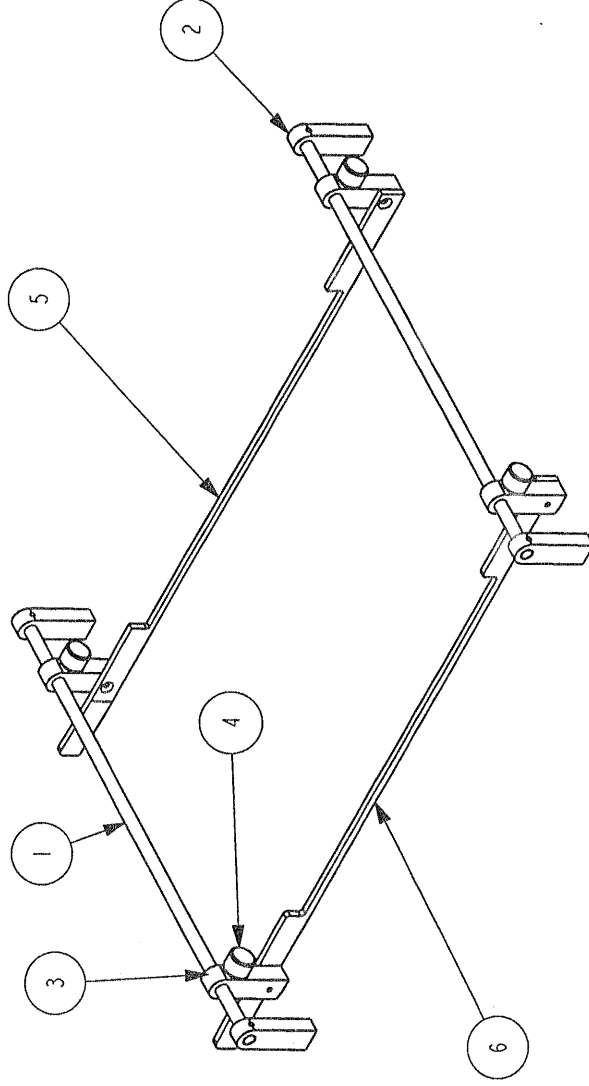


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	CHECKED BY: 16-Nov-99	DATE 16-Nov-99	REPEAT TREAT: N/A						
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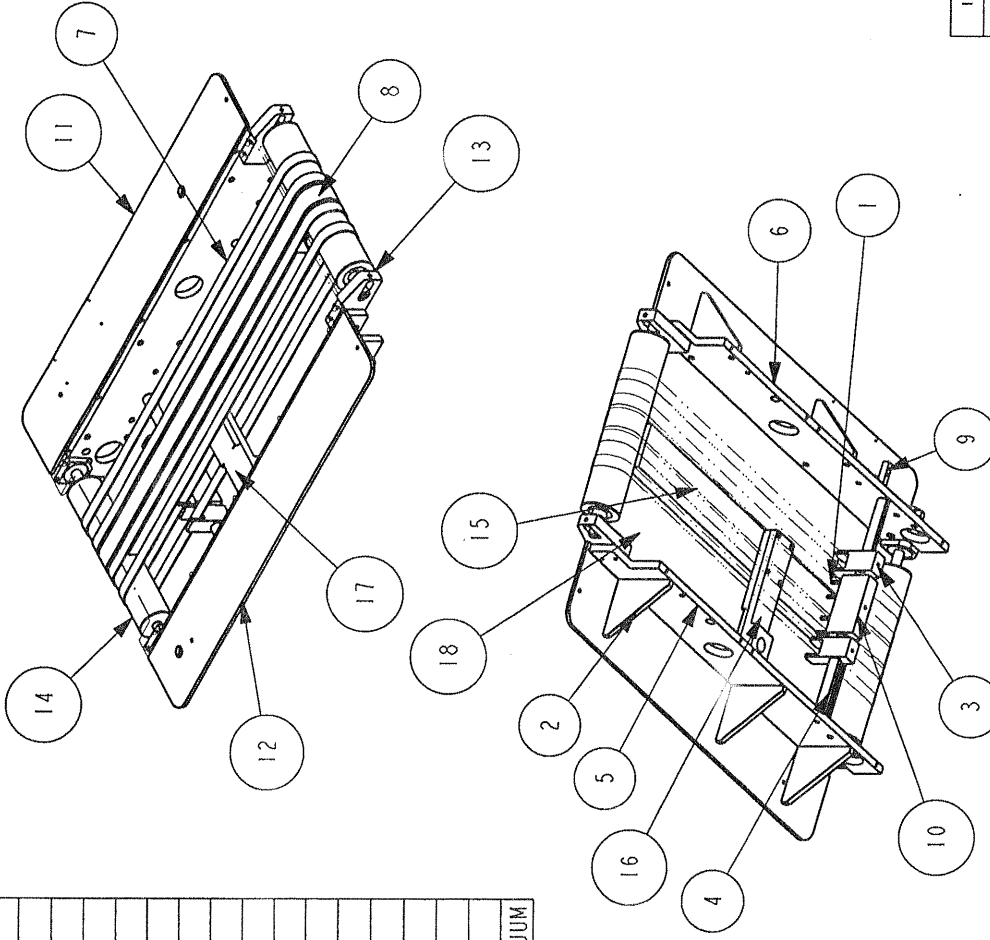
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2	4	500791	POST, SIDE GUIDE					
3	4	500792	POST, SIDE GUIDE					
4	4	500793	LOCK, SIDE GUIDE CAM					
5	1	500722-4L	SIDE GUIDE, R/H					
6	1	500722-4R	RAIL, GUIDE RH					



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538019-01

ITEM	QTY	PART #	DESCRIPTION
1	4	105400	DOWEL, PIN .188X1.250
2	5	500721	GUSSET - TABLETOP SUPPORT
3	2	500725	GUIDE - BELT
4	1	500824	SHAFT-BELT GUIDE
5	1	501201	PLATE, BASE SUPPORT RH
6	1	501202	PLATE, BASE SUPPORT LH
7	4	105901-6	BELT, FLAT 3/4 X 68 3/4
8	1	106202-5	BELT, FLAT 1 1/4 X 68 3/4
9	1	500721-1	GUSSET, CUTOUT
10	1	500725-7	GUIDE, BELT
11	1	501203-L	TABLETOP, OUTSIDE LH
12	1	501203-R	TABLETOP, OUTSIDE RH
13	1	530619-01	ASSY, IDLER ROLLER
14	1	538018-01	ASSY, FRONT ROLLER
15	1	SP30202	BLOCK, VACUUM
16	1	SP28217-1	BLOCK, LOWER VACUUM
17	1	SP28218-1	BLOCK, UPPER VACUUM
18	1	SP30201-1	TABLETOP 30.5 IN EXT. CANTER VACUUM



1	KR2191J
REQ'D	WHERE USED

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KENNESAW, GA 30144 USA

THIRD ANGLE PROJECTION  
2191J  
MODEL: 2191J

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HEAT TREAT: N/A  
FINISH: N/A

DIMENSIONAL TOLERANCES  
UNLESS OTHERWISE NOTED  
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REMOVE ALL BURRS AND  
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OTHERWISE NOTED  
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TO DIMENSIONS ONLY

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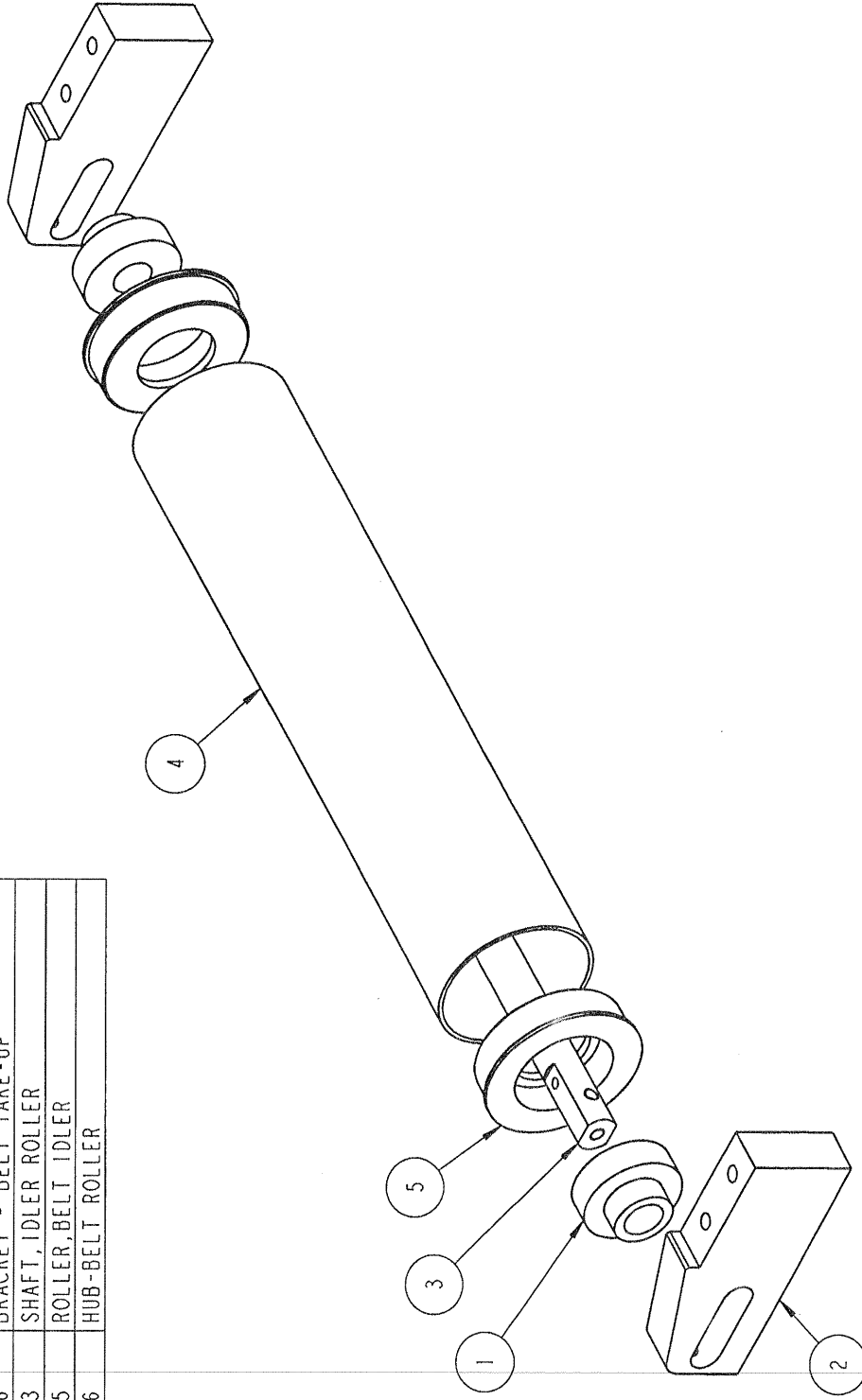
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KIRK - RUDY, INC.  
KENNESAW, GEORGIA

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SHEET NO. 10FI  
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538019-01

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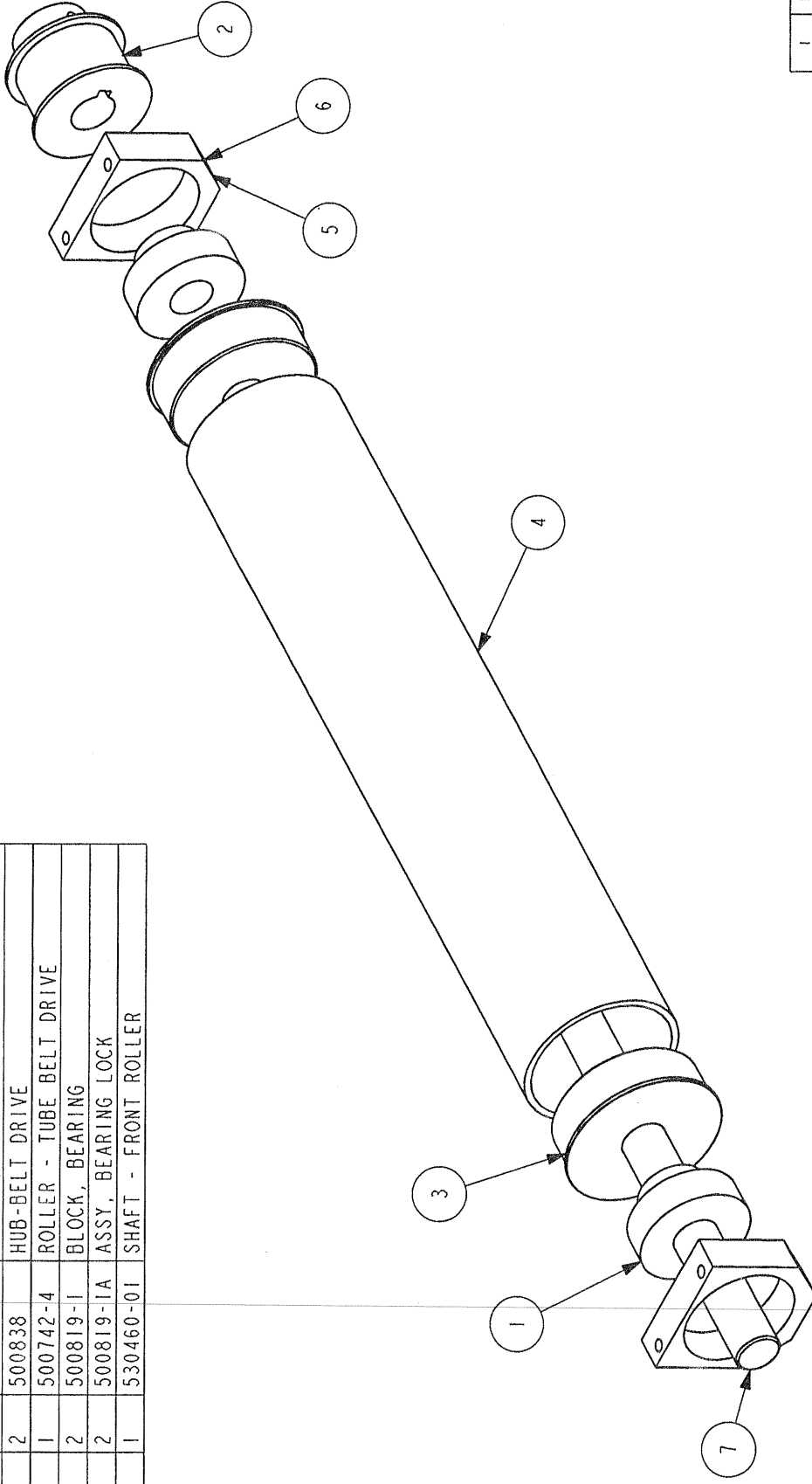
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2	2	500716	BRACKET - BELT TAKE-UP
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4	1	500835	ROLLER, BELT IDLER
5	2	500836	HUB-BELT ROLLER



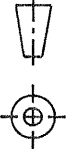

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ITEM	QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
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1	2	103804	BEARING, HUB .625
2	1	108809	PULLEY, TIMING 12L075 .625B .188K
3	2	500838	HUB-BELT DRIVE
4	1	500742-4	ROLLER - TUBE BELT DRIVE
5	2	500819-1	BLOCK, BEARING
6	2	500819-1A	ASSY, BEARING LOCK
7	1	530460-01	SHAFT - FRONT ROLLER

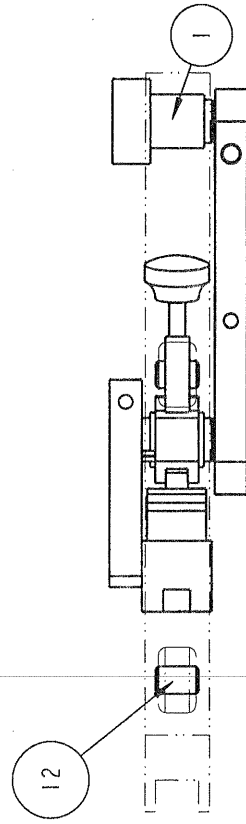
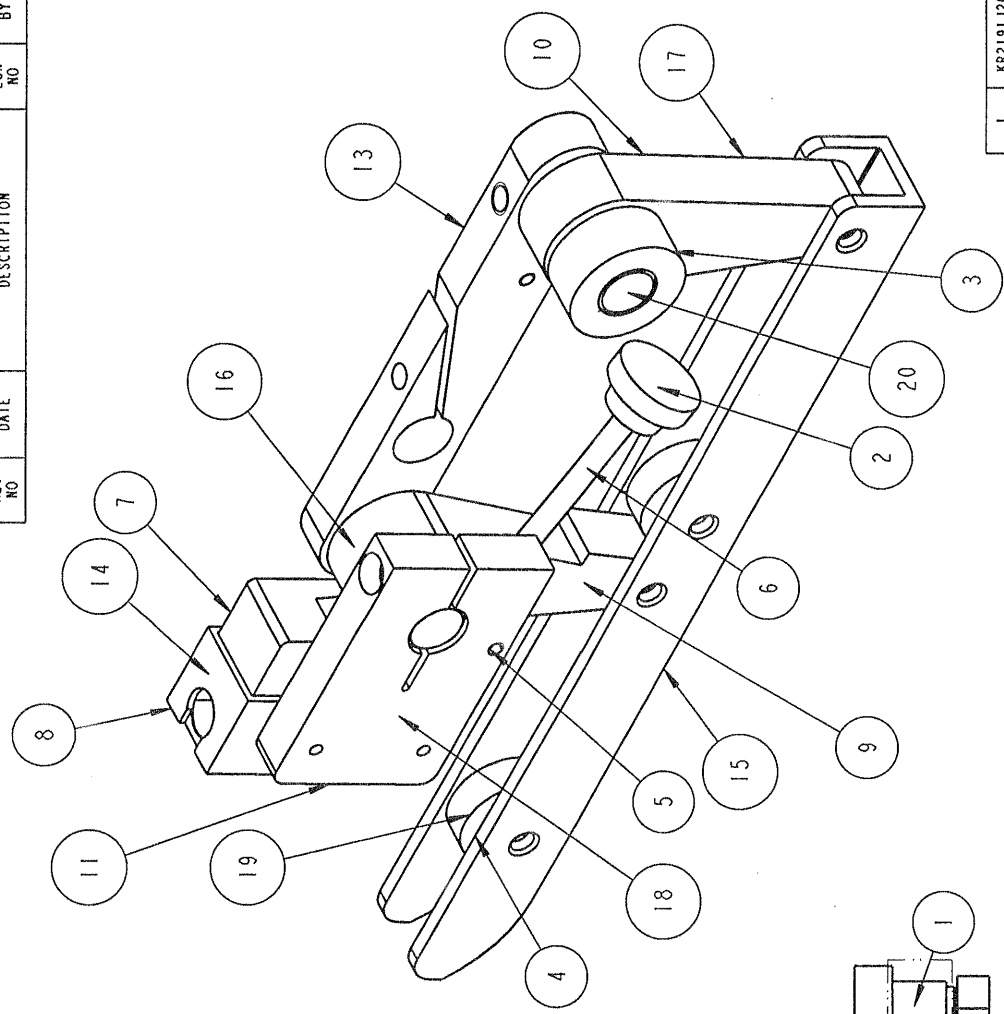


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1	KR2191J
REQ'D	WHERE USED

DRAWN BY: AYB	SCALE 0.500	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED .XX .XX .XX ANG. .01 .005 .5	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	KIRK - RUDY, INC. KENNESAW, GEORGIA	1	KR2191J20
CHECKED BY:	DATE 12-Nov-99	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY	HEAT TREAT: N/A	MODEL: 2191J	TITLE: ASSY, FRONT ROLLER			
TRACED BY:	MASTER 		FINISH: N/A	SHEET NO. 10F1	DRAWING # 538018-01			

ITEM	QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
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1	2	100162	BUSHING, SL.500ID.625OD.625LG
2	1	102114	KNOB
3	1	102205	COLLAR .500
4	2	103107	BEARING, FLAT .312
5	1	105201	PIN, ROLL .125X 1.000
6	1	105602	SHAFT, THREADED 5/16-18
7	1	190101	MICROSWITCH, LEVER
8	1	190203	COVER, MICROSWITCH
9	1	500800	LINK-SKID-FRONT
10	1	500801	LINK-SKID-REAR
11	1	500802	HOLDER-SKID SWITCH
12	2	500834	SHAFT, SKID ROLLER
13	1	503794	CLAMP
14	1	190101A	ASSY-SWITCH WITH COVER
15	1	500723-8	CHANNEL, SKID
16	1	500800-A	ASSY, LINK
17	1	500801A	ASSY, LINK
18	1	500802A	ASSY, CLAMP
19	2	500834A	ASSY, STUD WITH BEARING
20	2	SP37359	SHAFT, SKID BAR SPACER



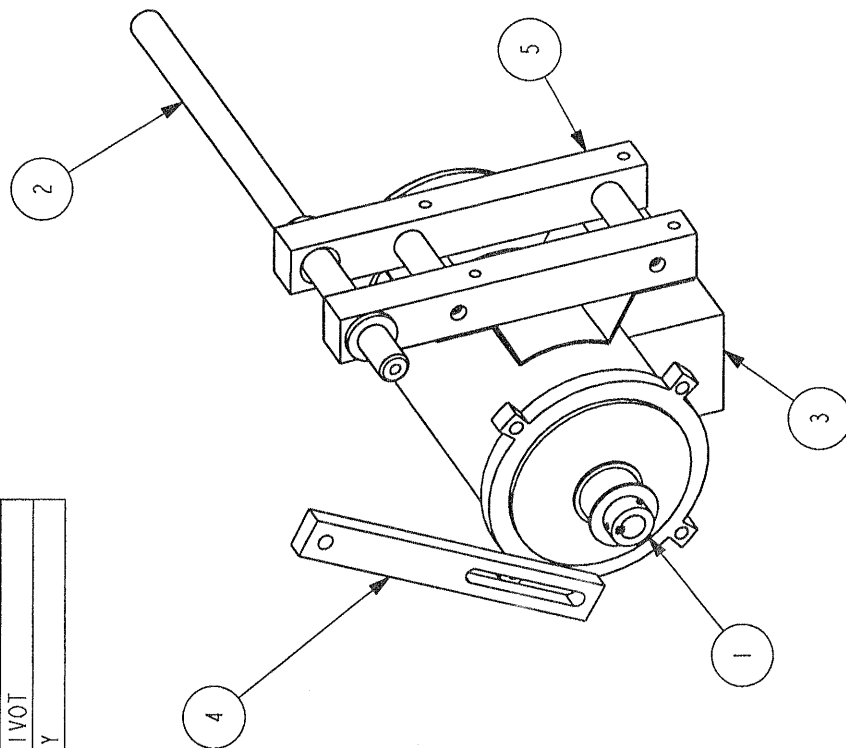
SCALE 0.500

1	KR2191J20
1	KR2191J
REQ'D	WHERE USED




DRAWN BY: AYB	SCALE 0.750	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	MATERIAL: N/A	THIRD ANGLE PROJECTION	PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE QUOTED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC. KENNESAW, GA 30144 USA	KIRK - RUDY, INC. KENNESAW, GEORGIA
	CHECKED BY: DATE 15-NOV-99	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED	HEAT TREAT: N/A	MODEL: 2191J	TITLE: ASSY, SKID BAR	
TRACED BY: 	MASTER	ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY	FINISH: N/A	SHEET NO.: 10F1	DRAWING # 538021-01	

ITEM	QTY	PART #	DESCRIPTION
1	1	108809	PULLEY, TIMING 12L075 .625B .188K
2	1	500824	SHAFT-BELT GUIDE
3	1	200152-2	MOTOR, LEESON DC 1/2HP
4	1	530512-01	SUPPORT, MOTOR PIVOT
5	1	530654-01	MOTOR MTG BAR ASY

REV NO	DATE	DESCRIPTION	ECN NO	BY
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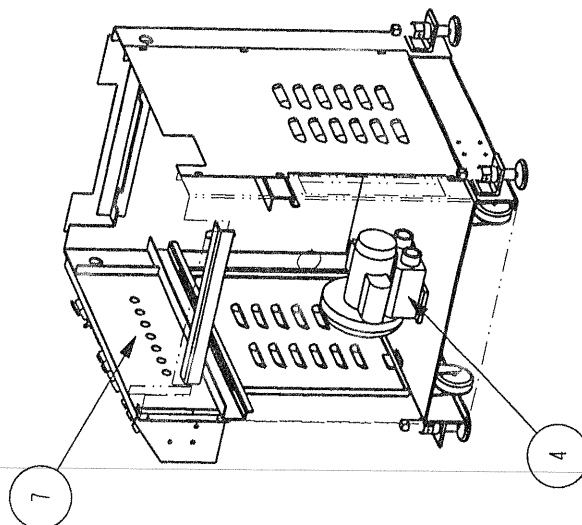
I	KR2191J20
I	KR2191J
REQ'D	WHERE USED

DRAWN BY: AYB	SCALE 0.250	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	 KIRK - RUDY, INC. KENNESAW, GEORGIA
CHECKED BY:	DATE 16 - Nov - 99	.XX - .01	.XXX - .005	ANG. - .5	HEAT TREAT: N/A	MODEL: 2191J	TITLE: ASSY, MOTOR MOUNT	
TRACED BY:	MASTER 	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED			FINISH: N/A	SHEET NO. 1 OF 1	DRAWING # 538022-01	

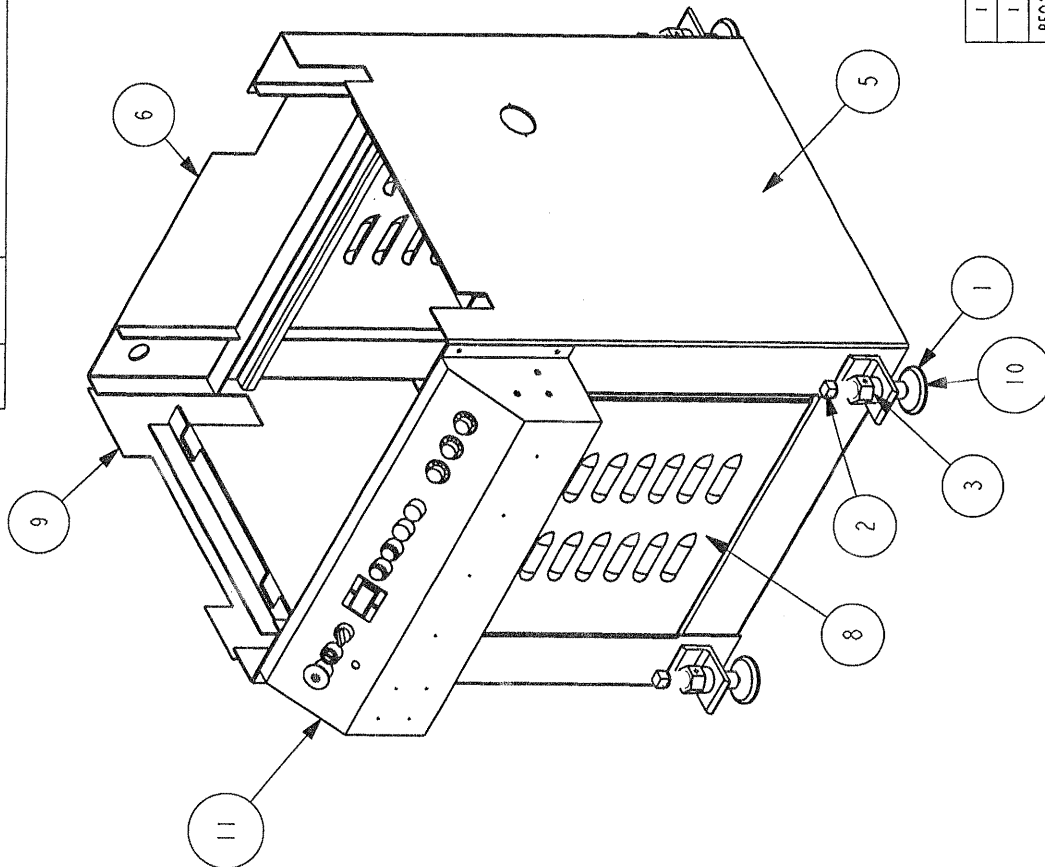
DRAWN BY: TJG	SCALE 0.500	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED			MATERIAL:	XXX
CHECKED BY:	DATE 11 - Aug - 97	.XX	.XX	ANG.	HEAT TREAT:	XXX
		.01	.005	.5		
TRACED BY:	MASTER m	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED			FINISH:	XXX
		ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY				



ITEM	QTY	PART #	DESCRIPTION
1	4	190634	FOOT, MOUNTING
2	4	191010	LEVELING BOLT, CABINET
3	4	191011	NUT, CABINET LEVELING
4	1	200120	BLOWER, GAST
5	1	501210	WLDMNT, 219 BASE CABINET
6	1	530865-01	PANEL, 219 FRONT COVER
7	1	530865-02	PANEL, ELECTRICAL
8	1	530866-01	DOOR, LOUVER LOCK
9	1	532998-01	GUARD
10	4	538024-01	ASSY, 1 IN. LEVELING LEG
11	1	538038-01	ASSY, 2191J CONTROL PANEL



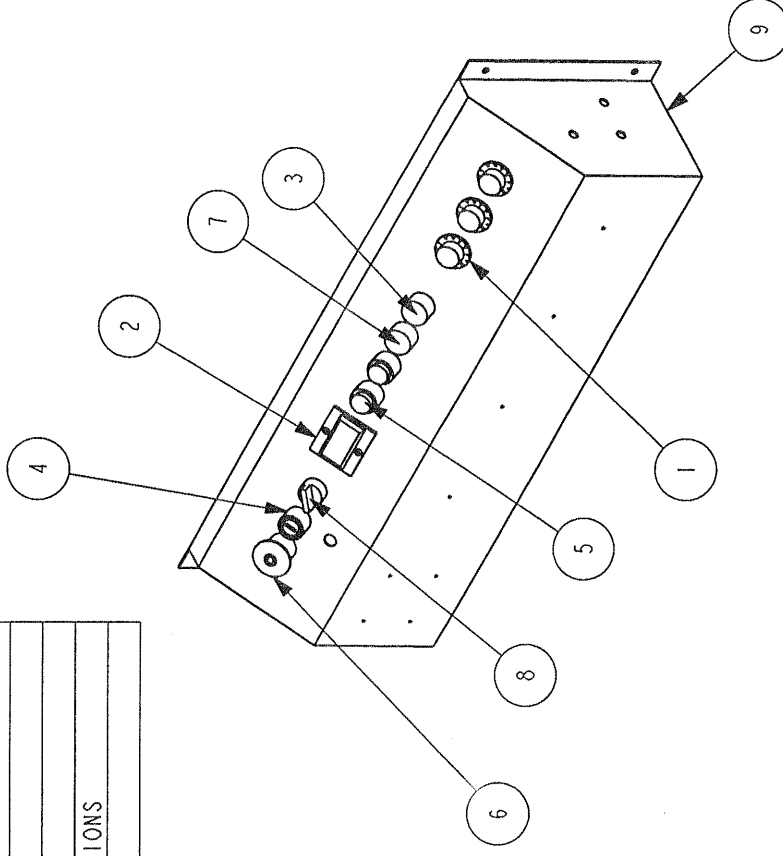
SCALE 0.062



1	KR2191J20
1	KR2191J
REQ'D	WHERE USED

DRAWN BY: AYB	SCALE 0.100	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	KIRK - RUDY, INC. KENNESAW, GEORGIA
CHECKED BY:	DATE 16-Nov-99	.XX .XXX ANG. .01 .005 .5	HEAT TREAT: N/A	MODEL: 2191J	TITLE: ASSY, 2191J CABINET	
TRACED BY:	MASTER 	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY	FINISH: N/A	SHEET NO.: 10F1	DRAWING # 538023-01	

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

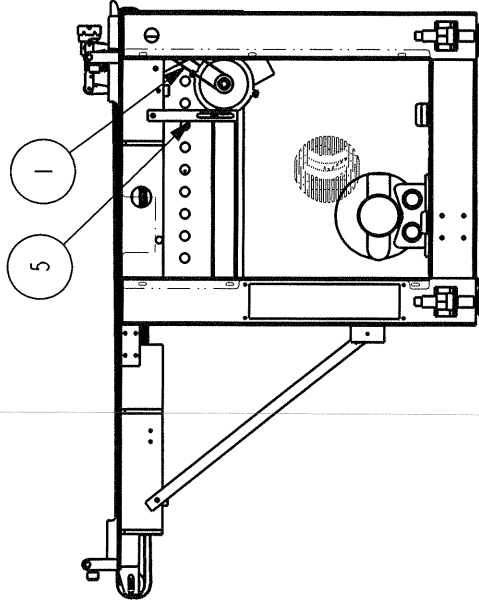
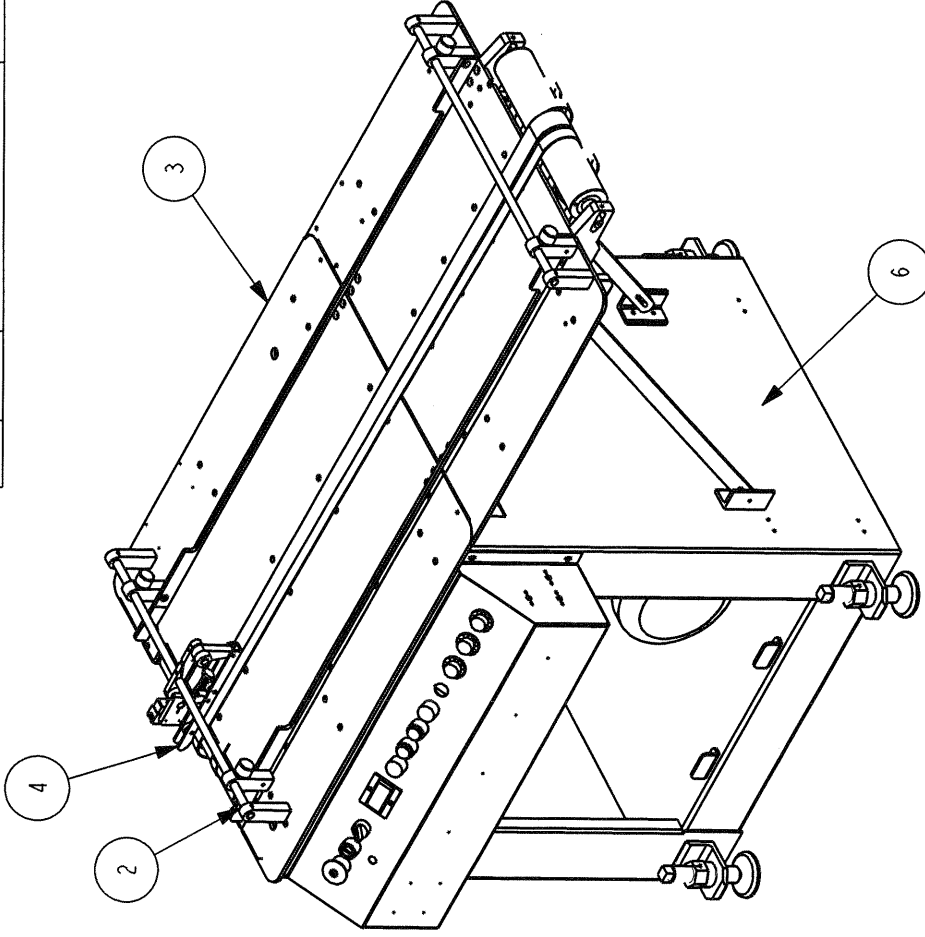


DRAWN BY: AYB	SCALE 0.150	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED .XX .XXX ANG. .01 .005 .5	MATERIAL: N/A	THIRD ANGLE PROJECTION 	PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE QUOTED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC. KENNESAW, GA 30144 USA	1 538023-01	REC'D WHERE USED
CHECKED BY:	DATE 01-Dec-99	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED	NEAT TREAT: N/A	MODEL: 2191J	TITLE: ASSY, 2191J CONTROL PANEL	KIRK - RUDY, INC. KENNESAW, GEORGIA	
TRACED BY:	MASTER 	ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE WORK TO DIMENSIONS ONLY	FINISH: N/A	SHEET NO. 10F1	DRAWING # 538038-01		



KR2191J20

ITEM	QTY	PART #	DESCRIPTION
1	1	108952-2	BELT, TIMING 255L075
2	1	535806-03	ASSY, SIDE GUIDE 20 IN
3	1	538020-01	ASSY, 2191J TABLETOP W/ 20 IN E
4	1	538021-01	ASSY, SKID BAR
5	1	538022-01	ASSY, MOTOR MOUNT
6	1	538023-01	ASSY, 2191J CABINET

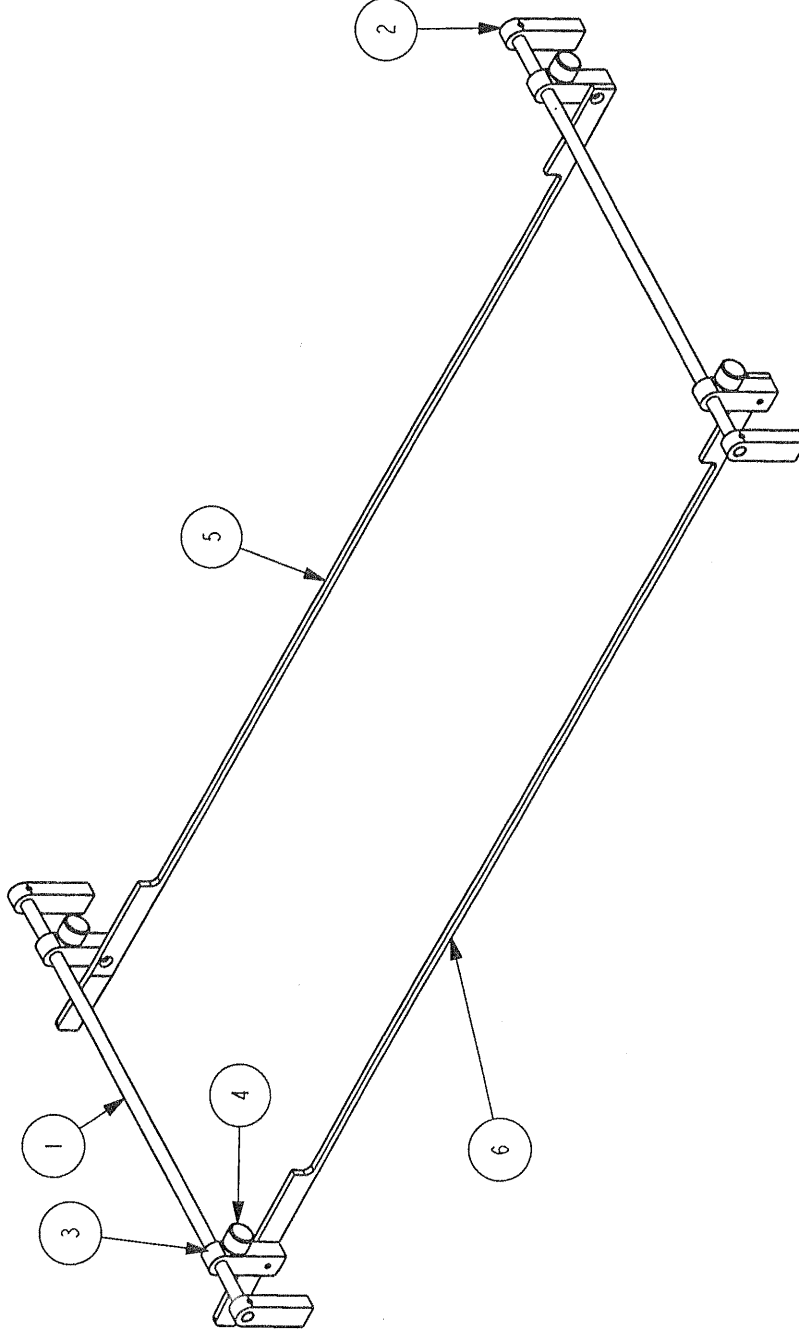
REV	NO	DATE	DESCRIPTION	ECN	BY
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SCALE 0.062

DRAWN BY: AYB	SCALE 0.093	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED			MATERIAL:  N/A	 THIRD ANGLE PROJECTION	 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	I KR2191J20	WHERE USED REQ'D
		.XX .01	.XXX .005	ANG. .5						
CHECKED BY:	DATE 16 - Nov - 99	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED			HEAT TREAT:  N/A	MODEL: 2191J20	TITLE: ASSY, KR2191J W/ 20 IN EXT	WOODSTOCK, GA 30188 USA		
		ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY								
TRACED BY:	MASTER				FINISH:  N/A	SHEET NO. : 1 OF 2	DRAWING #		KR2191J20	

ITEM	QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	2	500787	SHAFT-SIDE GUIDE ADJ.					
2	4	500791	POST, SIDE GUIDE					
3	4	500792	POST, SIDE GUIDE					
4	4	500793	LOCK, SIDE GUIDE CAM					
5	1	500722-6L	SIDE GUIDE, R/H					
6	1	500722-6R	RAIL, GUIDE RH					

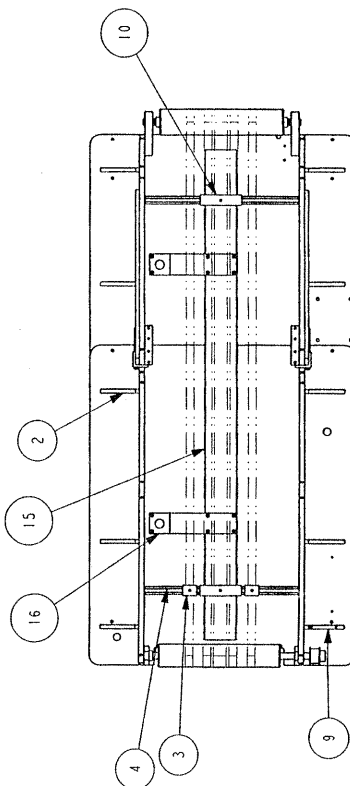
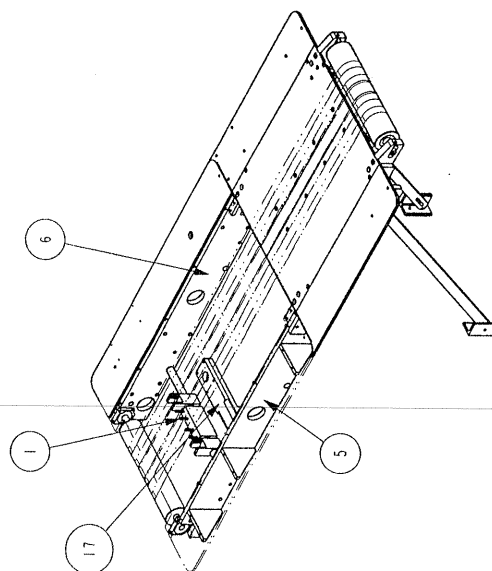
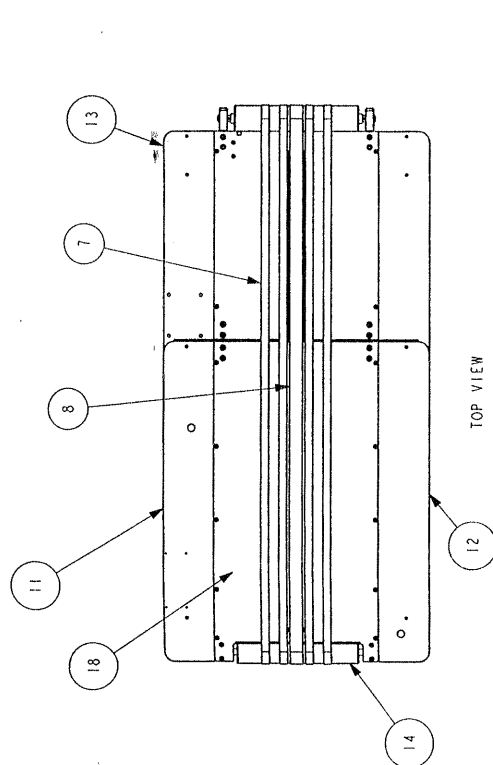


1	XR2191J20
REC'D	WHERE USED

DRAWN BY: AYB	SCALE 0.156	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED XX .01 .005 .5 ANG.	MATERIAL: N/A	THIRD ANGLE PROJECTION 	PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE QUOTED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC. KENNESAW, GA 30144 USA	KIRK - RUDY, INC. KENNESAW, GEORGIA	1 XR2191J20 REC'D WHERE USED
	CHECKED BY: 11-NOV-99						
TRACED BY:	MASTER 	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY	HEAT TREAT: N/A	FINISH: N/A	SHEET NO. 10F1	DRAWING 1 535806-03	

ITEM QTY	PART #	DESCRIPTION
1 8	105400	DOWEL, PIN 1/8X11 250
2 5	500721	GUSSET - TABLETOP SUPPORT
3 2	500725	GUIDE - BELT
4 1	500824	SHAFT-BELT GUIDE
5 1	501201	PLATE, BASE, SUPPORT RH
6 1	501202	PLATE, BASE, SUPPORT LH
7 4	105981-2	BELT, FLAT 3/4 X 108 3/4
8 1	106212-1	BELT, FLAT 1/4 X 108 3/4
9 1	500721-1	GUSSET,CUTOFF
10 2	500725-7	GUIDE, BELT
11 1	501203-1L	TABLETOP, OUTSIDE LH
12 1	501203-1R	TABLETOP, OUTSIDE RH
13 1	536266-01	ASSY, 20IN EXT. STD. IJ BASE
14 1	538018-01	ASSY, FRONT ROLLER
15 1	SP30206	TRAY, 215 20 IN VACUUM
16 2	SP28217-1	BLOCK, LOWER VACUUM
17 2	SP28218-1	BLOCK, UPPER VACUUM
18 1	SP30201-1	TABLETOP 30.5 IN EXT. CANTER VACUUM

REV NO	DATE	DESCRIPTION	ECH NO	BY
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ITEM	QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	2	500716	BRACKET - BELT TAKE-UP					
2	4	500721	GUSSET - TABLETOP SUPPORT					
3	1	500823	SHAFT, IDLER ROLLER					
4	1	500824	SHAFT-BELT GUIDE					
5	2	500875	BAR - SUPPORT EXT.					
6	2	500876	ANGLE SUPP., ATTACHED TO CABINET					
7	1	500701-1L	PLATE BASE SUPPORT 20 IN EXT LH8RH					
8	1	500701-1R	PLATE BASE SUPPORT 20 IN EXT LH8RH					
9	1	500835-A	ASSY, TUBE ROLLER					
10	1	536267-01	TABLETOP LH OUTSIDE 20 IN. EXT.					
11	1	536267-02	TABLETOP LH OUTSIDE 20 IN EXT.					
12	2	SP18606	PLATE, SCAB					
13	2	SP18616	PLATE - TABLETOP SPLICE					
14	1	SP30205	TABLETOP-CENTER					

THIRD ANGLE PROJECTION	MODEL: 215	SHEET NO. 10FI	TITLE: ASSY, 20IN EXT. STD. 1J BASE

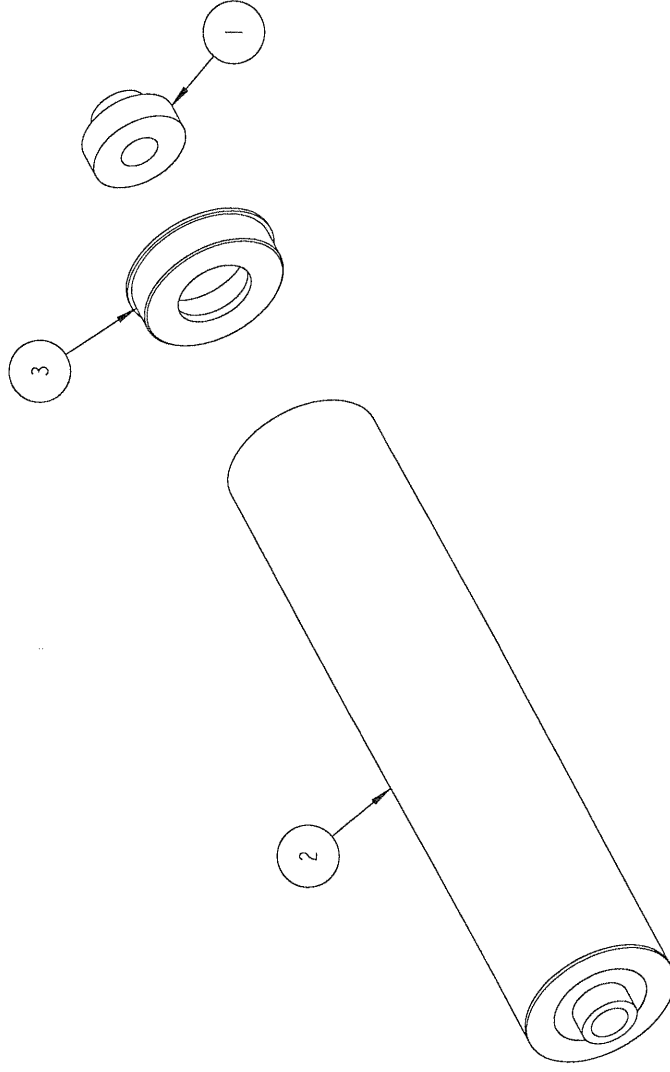
  

PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE QUOTED OR REPRODUCED WITHOUT THE WRITTEN PERMISSION OF KIRK-RUDY, INC. KENNESAW, GA 30144 USA	KIRK - RUDY, INC. KENNESAW, GEORGIA	1 SP77000 REQ'D WHERE USED

DRAWN BY: RHM	SCALE: 0.125	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED .XX .XXX ANG. .5	MATERIAL: N/A
CHECKED BY: 19-JUL-99 <td>DATE: 19-JUL-99<td>REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY<td>HEAT TREAT: N/A</td></td></td>	DATE: 19-JUL-99 <td>REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY<td>HEAT TREAT: N/A</td></td>	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY <td>HEAT TREAT: N/A</td>	HEAT TREAT: N/A
TRACED BY: MASTER	MASTER		FINISH: N/A

ITEM	QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	2	103804	BEARING - HUB					
2	1	500835	ROLLER-BELT IDLER					
3	2	500836	HUB-BELT ROLLER					



DRAWN BY: NJG	SCALE 0.375	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED .XX .XX .XX ANG. .5	MATERIAL: N/A	THIRD ANGLE PROJECTION 	PROPRIETARY AND CONFIDENTIAL MAY BE QUOTED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC. KENNESAW, GA 30144 USA	KIRK - RUDY, INC. KENNESAW, GEORGIA	REC'D	WHERE USED
CHECKED BY:	DATE 28-JUL-97	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY	HEAT TREAT: N/A	MODEL: 215	TITLE: ASSY, TUBE ROLLER			
TRACED BY:	MASTER M		FINISH: N/A	SHEET NO: 1 OF 1	DRAWING 1	500835-A		

## 7 ELECTRICAL SCHEMATICS AND PARTS

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### 7.1 SCHEMATIC LIST

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

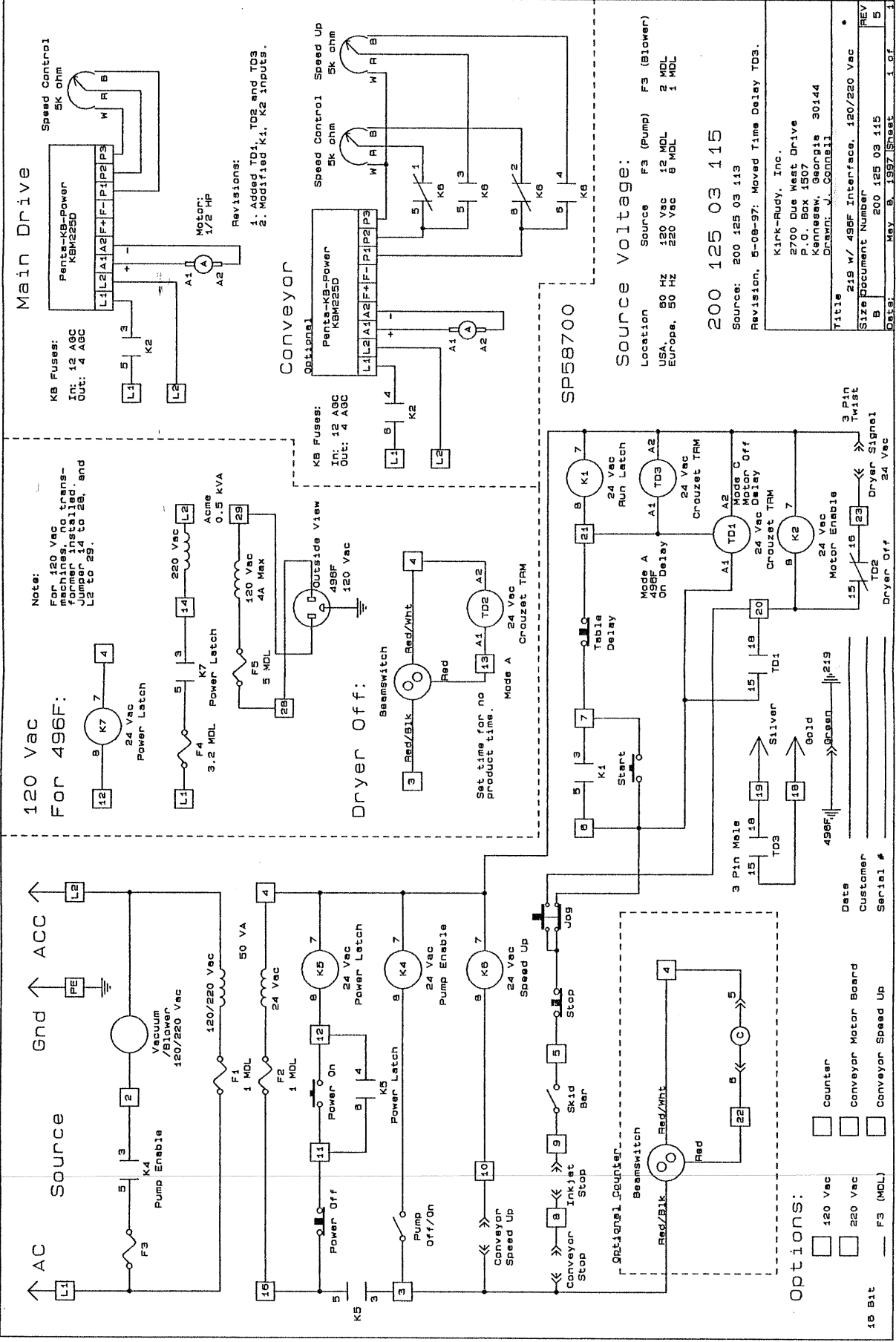
200 125 30 115      219 w/ 496F Interface, 120/220 VAC

### 7.2 PARTS LIST

KR Part #	Qty	Description
190101	1	Microswitch Lever BZ-ZRW80A2
190202	1	Bushing, .500"
200120	1	Blower, GAST R1102
200315	3	Bushing, .500" Drilled out
200332	5	Nut, .750" Steel
200334	3	Plug, Hole .375"
200336	2	Plug, Hole .875"
200338	3	Relief, Strain .375" ST
200339	1	Relief, Strain .375" 90 degrees
201127	1	Switchplate, Start
201128	1	Switchplate, Stop
201129	1	Switchplate, Jog
201169	1	Custom Plate
201512	1	Receptacle, 2 Pin Flanged Twist
201514	1	Plug, 3 Pin Twist 7594V
201522	1	Receptacle 5269 15A 125V
201528	1	Receptacle, 3 Pin Flanged Twist
201540	2	Receptacle, 2 Pin Turck RKF 20
201541	1	Receptacle, 3 Pin Turck RKF 36-1M
202277	6	Socket, Relay 8 Pin
202291	6	Relay, 24 VAC
202426	2	KB-Board 120VAC
203022	1	Transformer B050-0021-GA
204318	3	Kit, Potentiometer 4158
208029	2	Fuse 3.2 MDL
208030	2	Fuse 1.6 MDL
209007	3	Nut, Wire Grey
209008	2	Nut, Wire Blue
209016	3	Knob, Pot



209233	20	Terminal UK 10
209234	5	Terminal UK 16
209237	2	Terminal Ground
209245	1	Holder, Fuse 24V
209247	2	Holder, Fuse 120/220V
200165-4	1	Motor, Leeson 1/2 hp
200321-1	1	Relief, Strain
200323-1	2	Relief, Strain
201124-3	1	Button, Power On w/ Light
201125-6	1	Button, Stop
201125-7	1	Button, Power Off
201126-1	2	Button, Jog/Feeder Delay
201130-1	4	Contact NO
201131-1	4	Contact NC
201145-1	1	Selector, 2 Position
201160-3	1	Inlet Meltric 20A 125V
201161-3	1	Connector, Male Meltric 20A 125V
202263-2	1	Beamswitch 14102AQD03
202263-3	1	Cable Quick Disconnect QD03A-0406 6ft.
202297-1	3	Delay, Time Crozet Mur1
202427-1	1	Resistor .05"
202427-2	1	Resistor .025"



## **8 APPENDIX**

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### **8.1 POSSIBLE OPTIONS**

The KR219IJ and KR219IJ+20 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 KR215IJ base:

- Kirk Rudy dryer mount

## This image shows a single sheet of white paper with horizontal ruling lines. The lines are evenly spaced and run across the width of the page. There are no margins, text, or other markings on the paper.



## 10 WARRANTY AND SERVICE

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### WARRANTY

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

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.

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