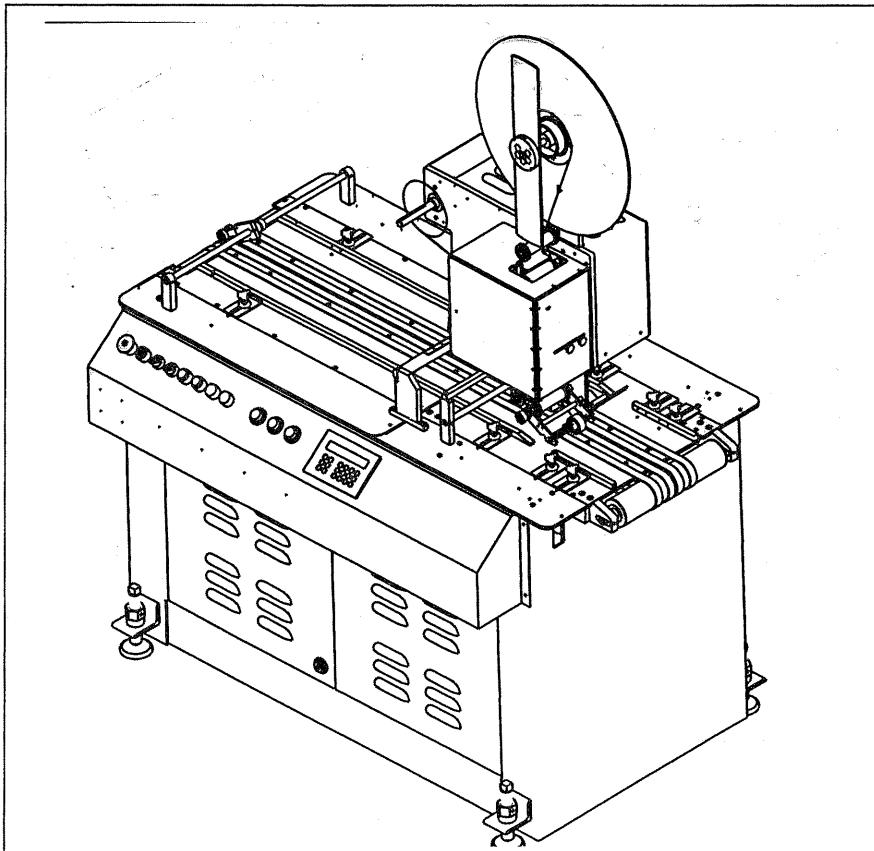


Kirk-Rudy Inc.

Instruction and Parts Manual

KR550 Labelmaster



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-KR550 REV. 2 9/26/2003

Labelmaster

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1.0 Important Safety Instructions

Intended Use Statement: The KR550 Labeling System is designed to apply a pressure sensitive label onto a product. The system is made up of two major components - the base and head. The labeling base carries the product underneath the head, where a label is applied to the product. Usage for other purposes may lead to an unsafe condition.

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



WARNING

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

2.0 SPECIFICATIONS

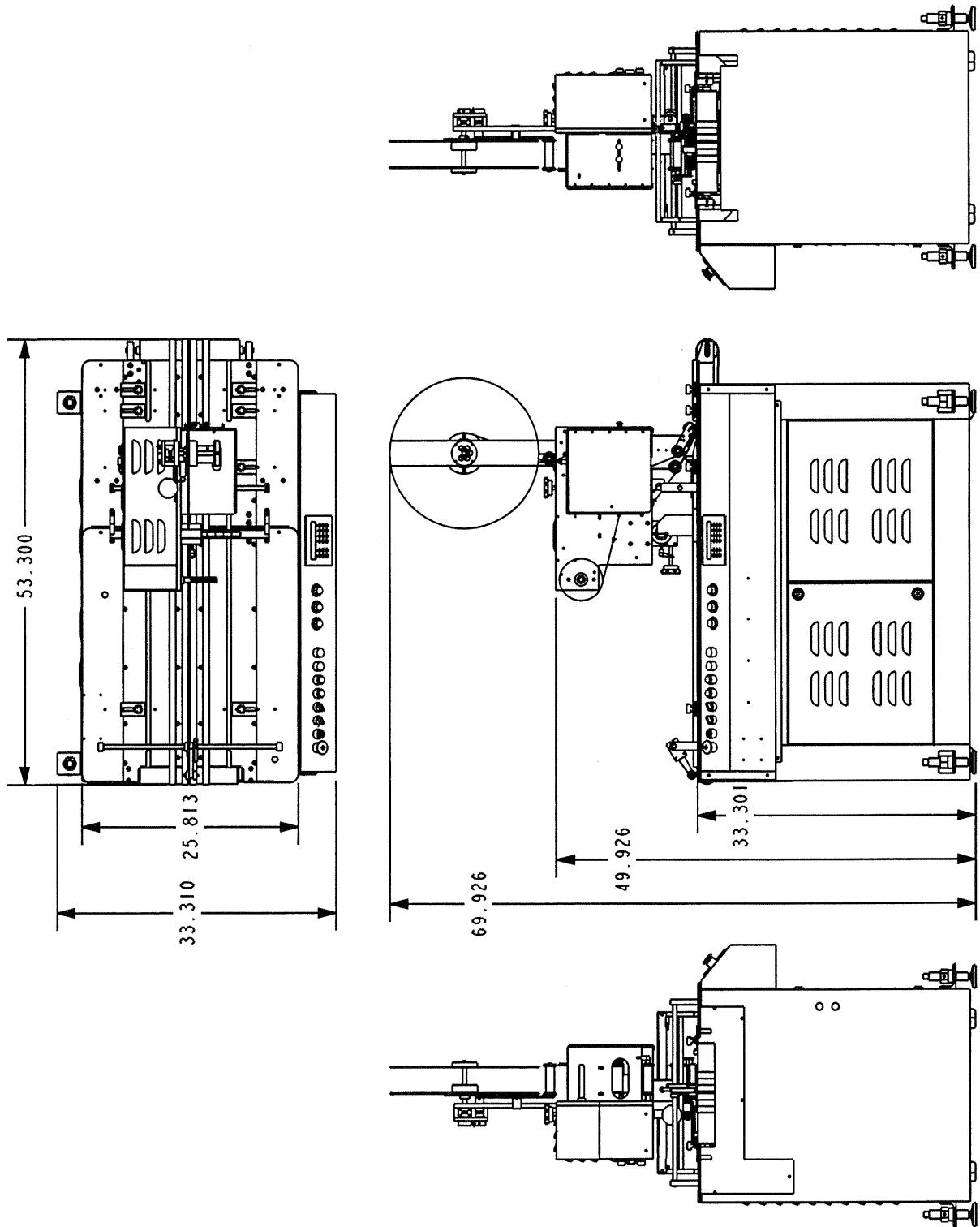
	<u>English</u>	<u>Metric</u>
<u>HEAD</u>		
Physical size:	28" X 24" X 8"	11.0 X 9.45 X 3.15cm
Weight	60 lbs	27.22 kg
Tabs:		
Material:	Paper, translucent and clear perforated and non-perforated labels.	
Size:	0.75" – 2.00" Diameter	19 – 51 mm
Labels:		
Minimum:	0.25" W x 1.5" L	6.4 X 38.1 mm
Maximum:	3" W x 2" L	76.2 x 51 mm
<u>BASE</u>		
Physical size LxWxH:	53" x 33.5" x 33"	134.62 x 85.09 x 13 cm
Weight:	510 lbs.	231 kg
Crated Weight:	540 lbs.	244 kg
Substrate:		
Minimum:	2.00" W x 3.00" L	51mm x 76 mm
Other sizes available on request		
Maximum:	17.00" W x 17.00" L	432 x 432 mm
Other sizes available on request		
Thickness:		
Minimum:	Card Stock (.007)	Card Stock (.10mm)
Maximum:	.375" thick booklet	9.5 mm

MAXIMUM OPERATING SPEEDS

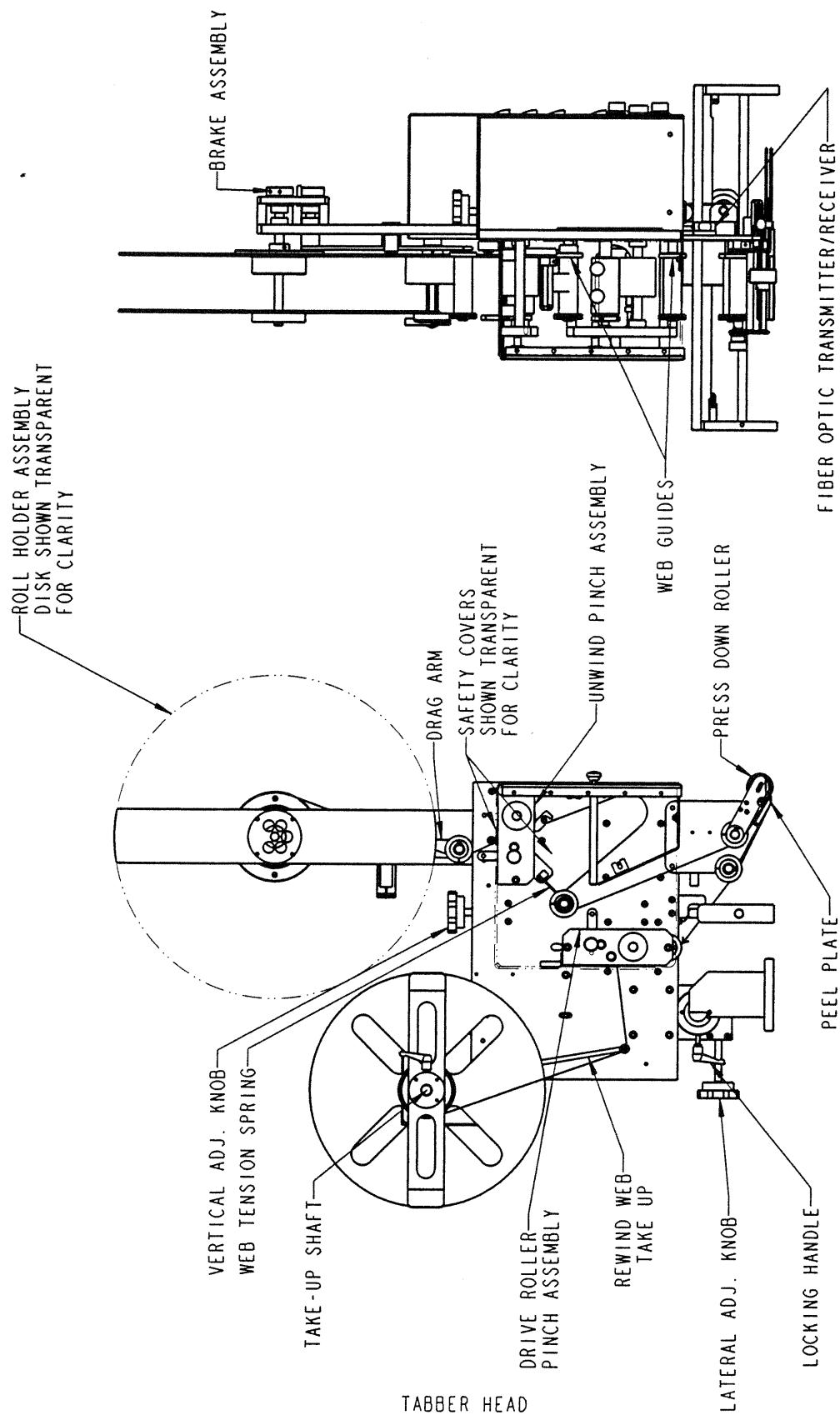
Single labeling:	30,000 pieces / hour
Double labeling:	30,000 pieces / hour
Note: Speeds are dependent on material being feed.	

ELECTRICAL REQUIREMENTS

System - Head & Base	120 VAC, 1 Phase, 50/60 Hz, 15 Amps
Head (when sold separately)	120 VAC, 1 Phase, 50/60 Hz, 10Amps
Electrical cord connection:	120V NEMA



KR550 LABELMASTER
VIEWS & DIMENSIONS
FIGURE 1.0



TABBER HEAD
COMPONENTS DESCRIPTION
FIGURE 2.0

3 INSTALLATION

3.1 UNCRATING AND UNPACKING



WARNING

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

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

Uncrating

1. Position crates near installation site.
2. Remove crate top and sides.
3. Remove metal strapping and securing blocks.
4. Locate accessories box and use checklist to verify all items were shipped.
5. Use a 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 inline with feeder base.
7. Adjust the height of the label base using the leveling legs.
8. Roll takeaway conveyor into place.
9. 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.

Cable and Cord Connections

1. Conveyor: Connect conveyor plugs into the connectors on the outfeed of the labeling base.
Note: Applies to KR bases only.
2. Connect conveyor plugs from the labeler into the feeder base plugs. The labeler base is now connected into the stop circuitry of the feeder base. Note: Applies to KR bases only.
Note: For feeder bases other than Kirk-Rudy, connect the conveyor plug into the base as usual. Wire the labeler base into the stop circuitry of the feeder base by connecting the feeder base stop wires to the S-402-CCT socket provided.
3. Power Cord: Plug the labeler base into an appropriate electrical outlet.

4.0 MACHINE DESCRIPTION

4.1 MECHANICAL COMPONENT DESCRIPTION

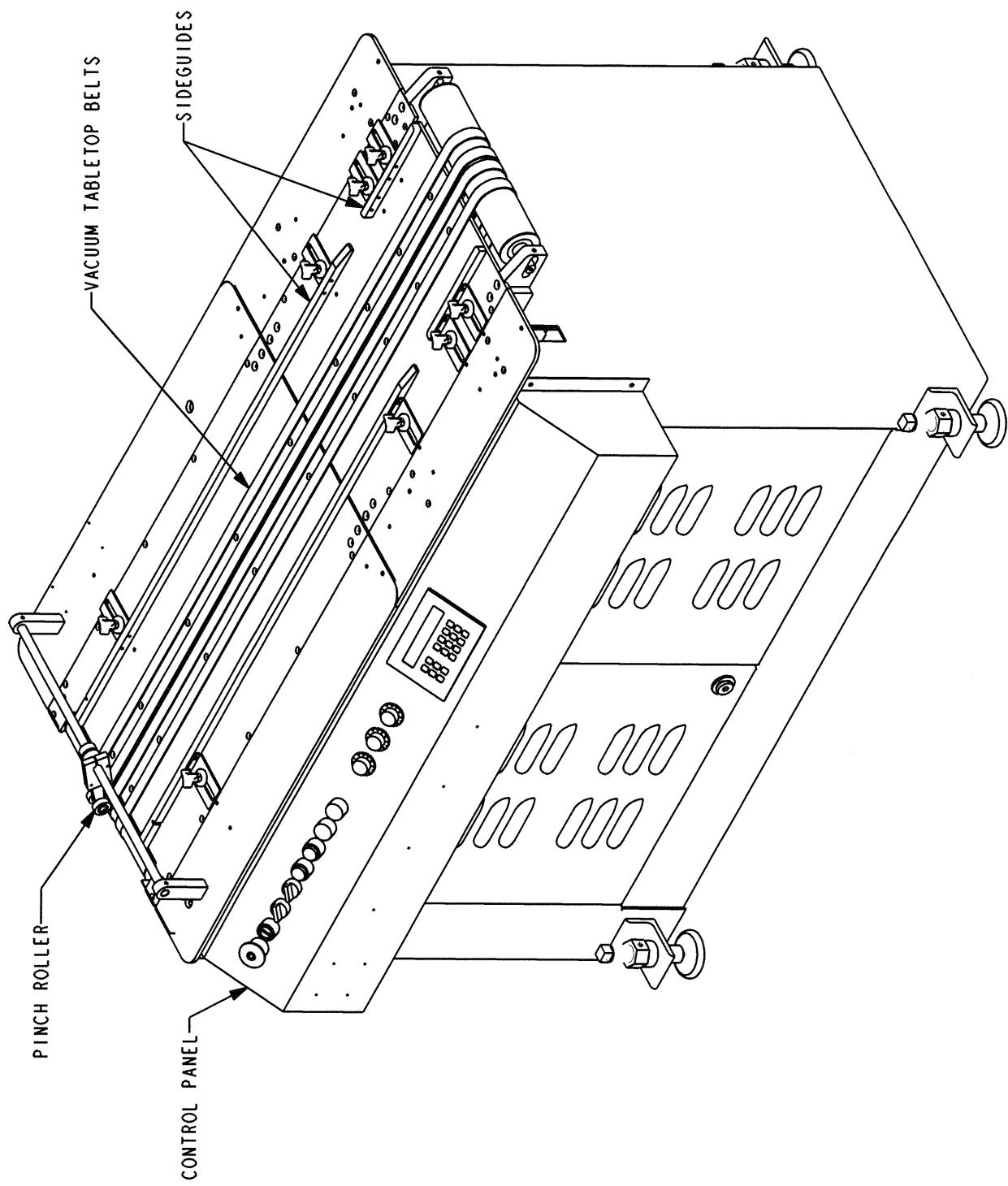
4.1.1 Head Assembly (see Figure 2.0)

1. Roll Holder Assembly: Holds the roll of tabs or labels. Front and back guides stabilize the roll. The front guide is easily removed by rotating it until the setscrew hole in the guide hub aligns with the flat on the core hub shaft. The three screws attaching the guide plate to the hub do not have to be removed when adding new rolls of tabs or labels.
2. Brake Assembly: Stops uncontrolled unwind of the label roll.

3. Drag Arm: Controls the core hub break assembly. Web tension swings the arm and releases the break on the core hub shaft.
4. Unwind Pinch Assembly: This assembly unwinds the roll of labels into a loop inside the label trey. A deflector underneath the roller prevents the web from sticking to the urethane roller and wrapping around it. The unwind motor is controlled by an unwind loop sensor in the bottom of the label trey (Figure 5.0). The machine stops if the sensor is not covered within two seconds of the unwind motor starting. This function eliminates pulling the end of the roll through the head and allows splicing onto the old roll. Pull the spring-loaded knob on the face of the assembly and rotate the lever clockwise to separate the two unwind rollers.
5. Web Tension Spring: Maintains web tension over the peel plate. The spring is located near the top of the label trey and rests on a fixed guide roller.
6. Web Guides: Guide the web through the head. The guides closest to the head frame align with the edge of the roller.
7. Fiber Optic Transmitter and Receiver: This system detects the gap between labels and controls when the drive roller stops.
8. Peel Plate: Labels are peeled off the web when it is dragged over the peel plate.
9. Press Down Roller: Labels are rolled onto the piece by the press down roller.
10. Drive Roller Pinch Assembly: The drive roller pinch assembly pulls the web over the peel plate. Pull the spring-loaded knob on the face of the assembly and rotate the lever clockwise to separate the two rollers.
11. Take-up Shaft: The take-up shaft rewinds the backing paper after the label is removed. Web tension around the take-up shaft is relieved when the u-shaped round bar is slid off the take-up shaft.
12. Locking Handle: Tightening this handle secures the head to the head support shaft.
13. Lateral Adjustment Knob: The head adjustment knob is used to slide the head across the base.
14. Vertical Adjustment Knob: Turning this knob pivots the label head and changes the distance between the peel plate and the tabletop.
15. Safety Covers: Enclose nip points on the head. Never operate the machine without all safety covers in place.

4.1.2 Base (see Figure 3.0)

1. Vacuum Tabletop Belts: The three center belts have vacuum between them to control the product.
2. Side Guides: The product is guided by the side guides to ensure product registration.
3. Control Panel: The switches and operator interface located on the front of the machine.
4. Pinch Rollers: The product is driven between the pinch rollers and the vacuum belts on the infeed of the machine.



BASE COMPONENTS DESCRIPTION
FIGURE 3.0

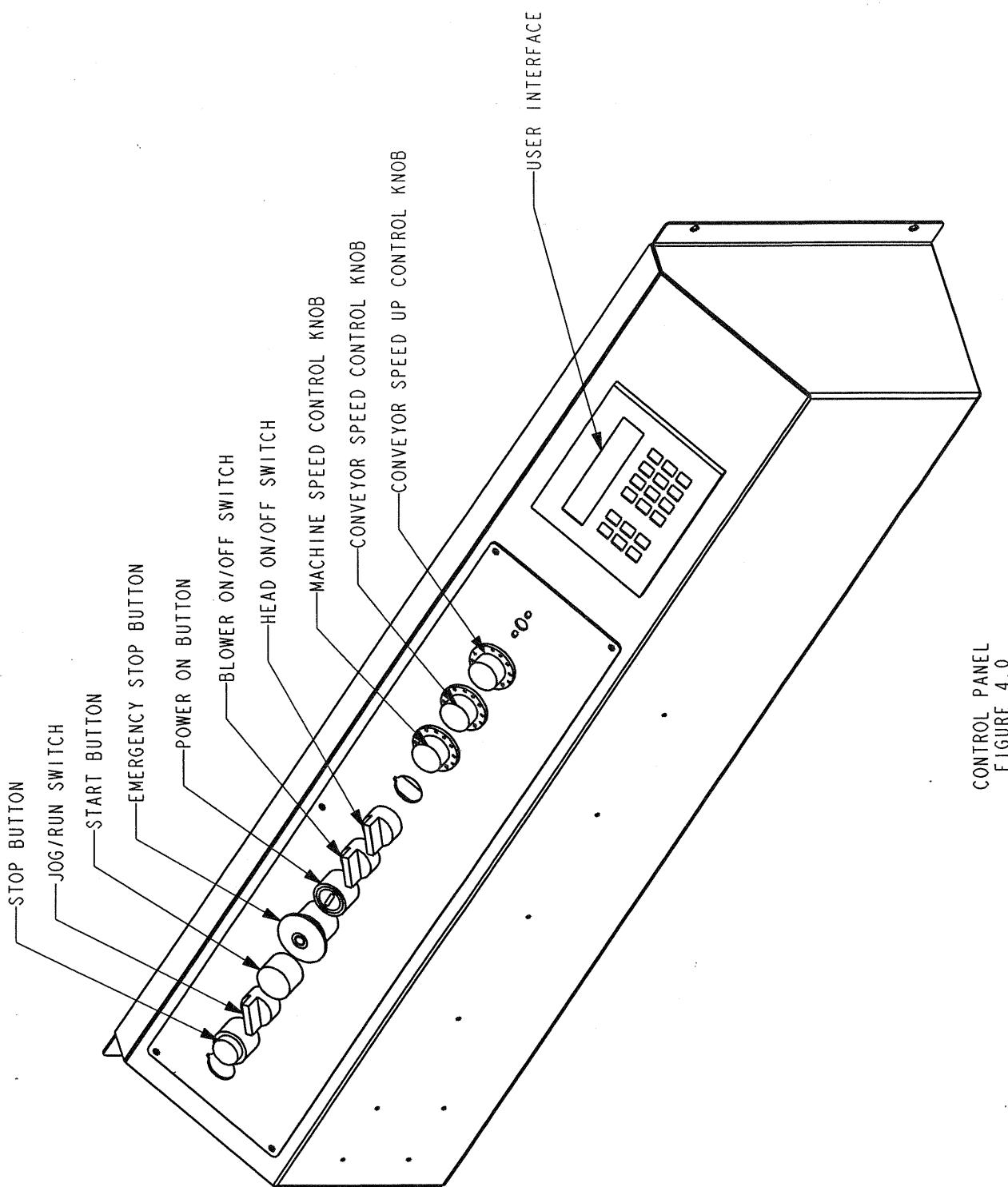
4.2 ELECTRICAL COMPONENT DESCRIPTION

4.2.1 Control Panel (Left to Right) (See Figure 4.0)

1. Emergency Stop Button: Press button to turn machine power off. To turn power on, unlatch this button. The green “power on” indicator light will turn off when power is off.
2. Power on Button: Press button to turn on machine power. Emergency stop button must be unlatched. Switch illuminates when activated.
3. Blower On/Off Switch: This switch is used to disconnect electrical power to the blower.
4. Head On/Off Switch: This switch is used to disconnect electrical power to the head.
5. Stop Button: Stops the base unit’s drive motor.
6. Jog Button: When the main power is on, depressing the jog button will start the base unit drive motor. As soon as the jog button is released, the main drive motor will stop.
7. Start Button: When the main power is on, the start button will start the base unit drive motor. Always be sure personnel are clear of moving parts before starting the main drive motor.
8. Feeder On/Off Switch: Disconnects power to the feeder drive motor when the stop out plug is used.
9. Machine Speed Control Knob: Sets the speed of the base unit’s drive motor.
10. Conveyor Speed Control Knob: Sets the speed of the conveyor unit’s drive motor.
11. Conveyor Speed Up Control Knob: Sets the distance between batches of product on the conveyor. A contact closure speed up signal from an outside source is required before this is functional. A two pin twist receptacle is provided on the rear of the machine. The speed up knob must be set higher than the Conveyor Speed Control Knob.
12. User Interface: See section 4.3 User Interface for complete description.

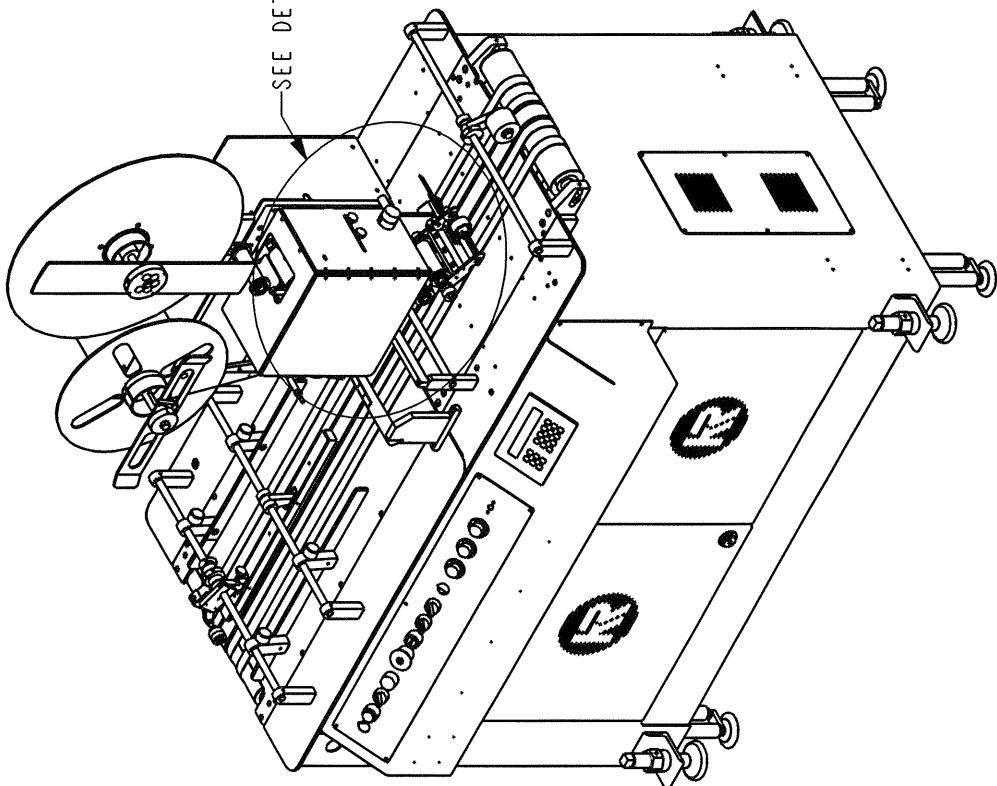
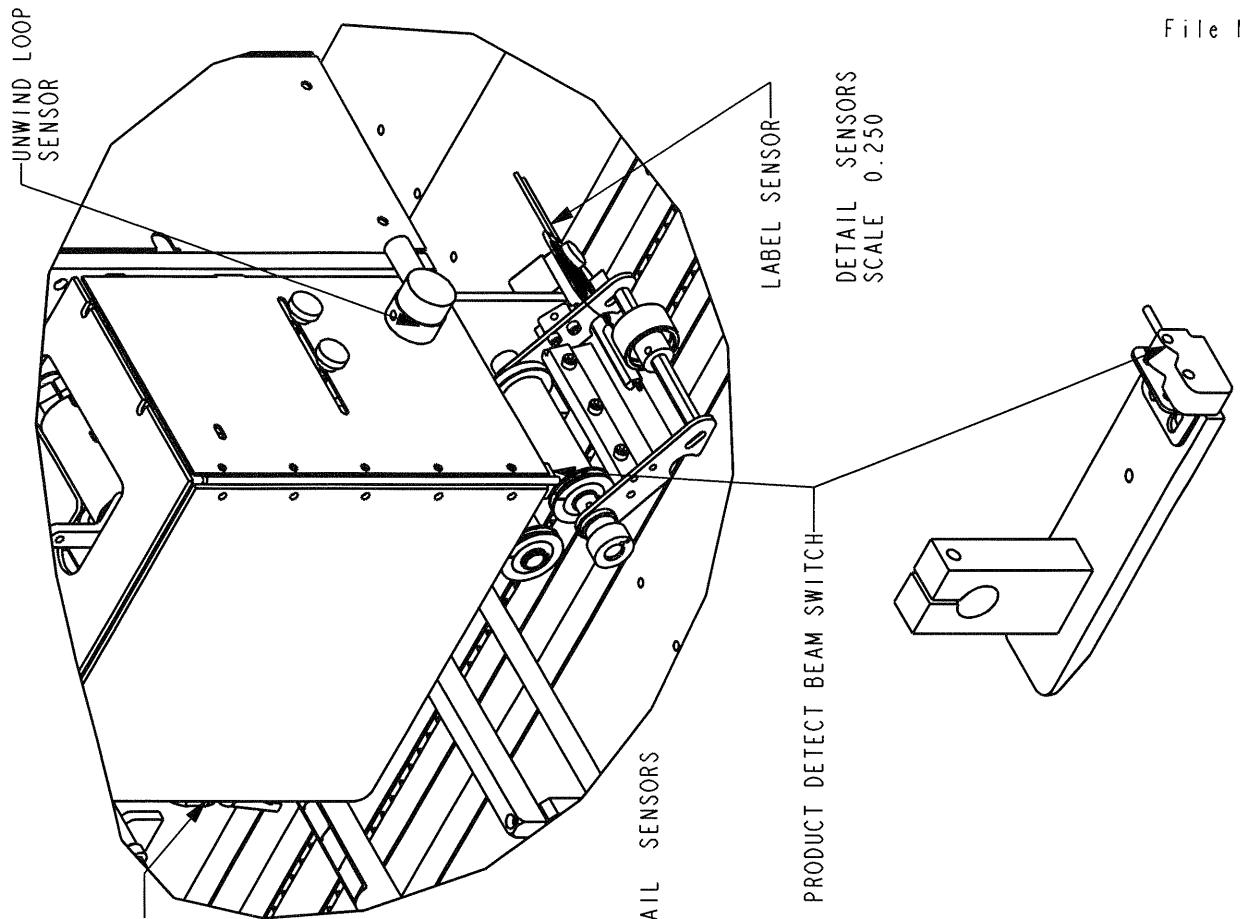
4.2.2 Electrical Connections to Base

1. Main Power Cord – The main power cord, located on the panel at the rear of the base, has a built in disconnect which can be released by pushing the latch on the connector and twisting the connector off.
2. Conveyor Stop Plug – located on the panel at the rear of the base below main power, connects to the KR314 conveyor for a stop signal.
3. Conveyor Power Plug - located on the panel at the rear of the base below the main power, connects to the KR314 conveyor for power.
4. Conveyor Power Feed through Cable and Plug – located coiled up inside the base cabinet and accessible through the rear door feeds the power from the KR feeder through the KR535 to the Kr314 Conveyor. (3-Pin Cable/Plug # RSM 36D-6M)
5. Feeder Stop Cable and Plug – located coiled up inside the base cabinet and accessible through the rear door stops the feeder upstream. (2-Pin Cable/Plug # RSM 20-6M).



CONTROL PANEL
FIGURE 4.0

File Name KR550



MACHINE SENSOR
FIGURE 5.0

4.2.3 Machine Sensors (Figure 5.0)

1. Product Detect Beam Switch: Detects the product's leading edge. The sensor is mounted on the head assembly and sends a beam to a reflector between the vacuum belts.
2. Label/Tab Sensor: Detects the gap between labels or tabs and is located on the peel plate. The change in the amount of light reaching the receiver as a label passes through the beam activates a switch that stops the stepper motor. The beam can be seen as a red dot on the web between the transmitter and receiver. Fiber optic cables connect the label sensor to an amplifier unit mounted to the backside of the head. Lights on the end of the amplifier denote sensor mode. A red light means the sensor is in teach mode while a green light means run mode.
3. Unwind Loop Sensor: This sensor is attached to the bottom of the label tray and detects the presence of webbing in the tray.
4. Head Door Magnet Switch: When the head door is open, base and head operation is disabled. Must press start button to operate.

4.3 USER INTERFACE (See Figure 6.0)

4.3.1 Overview: The user interface provides a way to electronically change certain machine settings. This system eliminates most mechanical adjustments and makes the machine more user-friendly. Machine speed, labeling mode (single or dual), error messages and a piece counter is presented on a display screen. Settings are modified using the keypad next to the screen. To change a setting, press the applicable button, type in a value and save the new value by pressing enter. Values associated with a particular job can be saved and recalled at a later time. A total of 10 different jobs can be saved. A multi-tasking controller permits changes to be made "on the fly."

4.3.2 Function Keys

1 or 2 Labels: Provides a way to change the number of labels (one or two) applied to the product. Pressing the key toggles the mode between one and two labels.

Label size: Enter the diameter or length of the label. Note: when a new label or product size is entered, the label position is automatically recalculated.

Load or Save: Press this button to load or save job data. Type in a 1 to load a job or type in a 2 to save the current settings for future use. To save a job, type in a number between 1-10 to identify this configuration. Use the back of the manual to record this number next to a job description. **Important note**: When the system is turned off, settings not saved to a job are discarded. If a job # had been loaded it will be reloaded when power is re-applied.

Machine Information: Press this button to scroll through the current settings.

Label Position: Provides a way to change the location of the label on the product.

Label location is measured from the lead edge of the product to the label edge. Single label location defaults to the center of the product.

Label Position: Provides a way to change the location of the label on the product. Label location is measured from the lead edge of the product to the label edge. Single label location defaults to the center of the product.

Label Type: Select either white or clear. When selecting white label (opaque) the sensor operates by not being able to look through the label and by being able to look through the web between label gaps. When selecting clear label (translucent) the sensor operates by being able to look through the label and not being able to look through the web gap due to black lines in the gap.

Machine Setup: Use of this function key is limited to Kirk Rudy service technicians. A password is required to access speed compensation values, tab roll unwind parameters and other default settings.

Product size: Enter the size of the product. This value is used to calculate label location on the product. Note: when a new label or product size is entered, the label position is automatically recalculated.

Reset counter: Press this button and type “1” to reset the counter displayed on the screen.

Sensor Teach: When the label type changes, recalibrate the label sensor by pressing this button and running a single product through the machine. Belt speed must be less than 35 feet/minute for the sensor to correctly teach itself. The sensor amplifier unit will display a red light immediately after the label sensor button is pressed. The sensor amplifier unit is located on the rear of the peel plate support. The amplifier will display a green light when it is finished with its adjustments.

Clear: Press this button to clear the current numeric entry.

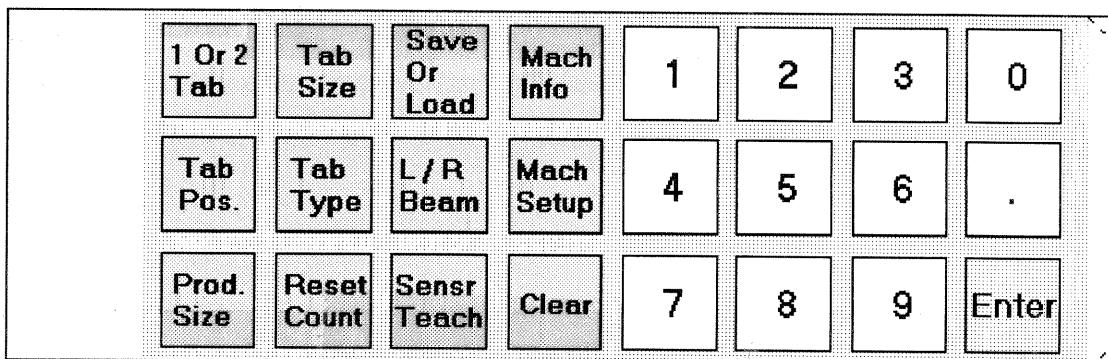


Figure 6.0 Interface Control Panel

4.3.3 Error Messages

1. Jam under card detect beam switch: A machine stop will occur if the product detect beam switch is covered for more than 1 second while the machine is running.
2. Tabber Door: A machine stop will occur when the door on the label head is opened while the machine is running.
3. Stop Circuit: A machine stop will occur if the stop circuit cords are unplugged.
4. Unwind beam switch: A machine stop will occur if the sensor is not covered within two seconds of the unwind motor starting.

5.0 OPERATING INSTRUCTIONS



WARNING

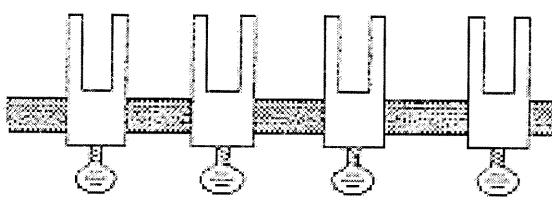
Read and follow all Safety Instructions in Section 1, Page 3 before proceeding.

5.1 System Overview

A product enters the KR550 and is conveyed by vacuum belts underneath the label head. The product detect beam switch detects the leading edge and sends a signal to the control unit. Labels are applied to the piece according to operator input parameters using the operator interface. The control unit starts the main drive roller peeling a label off the webbing and onto the product. The main drive roller is stopped once the label sensor detects the gap between labels. Speed sensing capabilities enable the control unit to apply labels accurately as the speed is changed.

5.2 Base Setup

1. Turn the main power on. Turn the head on/off switch to off for base setup.
2. Jog the feeder base until the product is delivered to the infeed of the label base.
3. Align product to run down the center of the vacuum belts and adjust the side guides to the product.
4. Check tabletop height and adjust the leveling legs if necessary.
5. Adjust the pinch rollers over the two vacuum belts. Adjust the pressure of the pinch rollers placing the product underneath the rollers. Loosen the clamp collar and set the desired height of the pinch rollers and tighten. Spring tension can be adjusted by loosening the collar set screw and rotating the collar to add more tension on the spring.
6. Raise the head using the vertical adjustment knob enough to allow the piece under the peel plate.
7. Check product runs through smoothly by running a few pieces through the unit.
8. The position of the tabletop belts can be moved if necessary. There are four tabletop belts on the KR550. 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 if possible, and one belt on either side of the vacuum holes.

5.3 Head Setup

5.3.1 Roll Installation and Web Path (Figure 7.0)

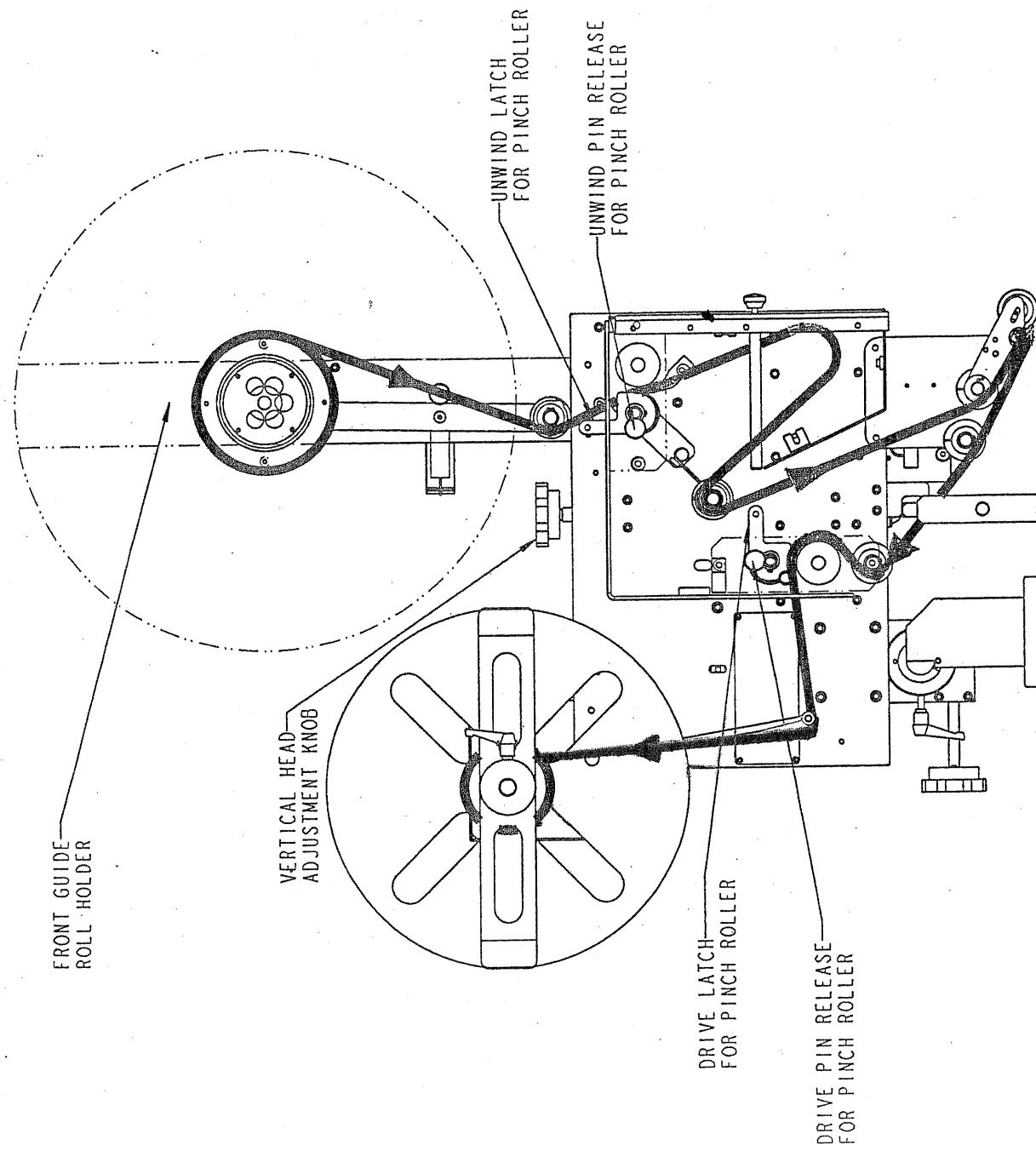
1. Remove the front guide of the roll holder assembly and install a new roll of labels onto the mounting hub. Install the roll so that as the free end is pulled, the roll rotates in the clockwise direction. Reinstall the front guide.
2. Disengage both pinch roller assemblies by pulling out each release pin. Unravel approximately 4 feet of webbing. The web guides closest to the frame are fixed. Adjust outer web guides as necessary. Use the vertical adjustment knob to raise the head if necessary to make threading around the peel plate easier. Thread the webbing as shown in **Figure 7.0** and re-engage both pinch roller assemblies
3. Position web guides against the web edge.
4. Check web tracking by rotating the main drive roller by hand.
5. Turn power on and check the label sensor is positioned in the center of the web. If the sensor isn't positioned properly loosen the sensor knob and slide the sensor so that the red light is lined up with the registration mark or center of the label.

5.3.2 Head Position

1. Jog a product through the machine and stop it as the lead edge passes the peel plate. Release the locking knob and use the lateral adjustment knob to position the label to the desired location on the product. Read the scale at the bearing hub and record this measurement for future reference.
2. Lower the head using the vertical adjusting knob until the bottom edge of the peel plate just clears the top of the product. Make sure the top of the product does not rub against the webbing along the bottom of the peel plate.
3. Lower the press down roller onto the top of the product. Jog the product clear of the peel plate and check for clearance between the press down and vacuum belts. The press down roller should not contact the vacuum belts.

5.4 Operator Interface

1. Turn power on and set machine speed to ~ 35 feet/minute.
2. Press **Product Size** function key and enter the product length or select a previously saved job by pressing the **Read from Job** function key.
3. Press **Label Type** function key and enter the label material.
4. Press **Label Size** function key and enter the label size or the label length.
5. Press **Label Sensor Teach** function key and verify red light on amplifier is illuminated.
6. Run one product through the machine.
7. A single label will dispense passing the web under the label sensor. Verify the red light on the amplifier goes out and the green light illuminates. If the green light does not illuminate, repeat the procedure at a lower base belt speed.
8. Press **Label Mode** function key and select the number of labels to apply to the product.
9. If necessary, adjust label position using the **Label Position** function key.



WEB PATH
FIGURE 7.0

10. Press **Reset Counter** function key.
11. Press **Save or Load** function key and save to a Job #.

5.5 TROUBLE SHOOTING

Problem	Solution
Machine will not start	Unlatch stop button Close head door Check stop circuit cords are properly connected Check speed control is above zero
Label head is not dispensing labels	Check unwind and drive roller pinch levers are locked in place.
Erratic label placement	Lower head until peel plate is slightly above the top of the product. Lower press down roller. Verify label size matches the label size parameter value in the user interface. Run label sensor teach program Clean product detect beam switch and its reflector. Increase spring tension on press down roller Reduce machine speed
Web breaks	Inspect web for die cuts or edge nicks Ensure wear tape is attached to peel plate Remove adhesive buildup on web rollers.
Web wraps around unwind roller	Clean adhesive off of the unwind roller Center web deflector on the web and position it slightly away from the unwind roller.
Grooves in urethane unwind roller	Adjust position of web deflector

6.0 MAINTENANCE



WARNING

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

6.1 HEAD

1. Periodically clean adhesive from all web rollers
2. Check wear tape on peel plate
3. Check label roll brake system operation and adjust if necessary.
4. Remove dust from loop sensor using a dry tissue.

6.2 Base

1. Check table top belts for wear and tension if necessary.
2. Check product sensor and reflector. Clean if necessary.

6.3 Belt Change Procedure

Note: The machine is oriented looking down stream with the control panel on the right hand side.

1. Unplug the machine.
2. Remove the infeed left-hand outside tabletop by removing the 10-32 flat head screws.
3. Remove the rear panel by removing the 10-32 button head screws.
4. Loosen the motor tensioning bar and swing up the motor by unscrewing the two hex head bolts with a 9/16 wrench and remove the 255L075 timing belt.
5. Remove the two vacuum hoses from underneath the tabletop by sliding them off the manifold nipples.
6. Remove the two center tabletops together by removing the fourteen 10-32 flat head screws.
7. Loosen the ¼-20 set screws from the end of the outfeed takeup shaft to unlock the belt tensioning set screws.
8. Loosen the ¼-20 set screws from the end of the mount blocks to relieve the tension on the vacuum belts.
9. Remove the old belts and replace with the new belts taking care not to over tighten.
10. Reassemble in reverse order.

7.0 PARTS LISTS AND DIAGRAMS

Diagrams are shown in order as indicated below. Sub-assemblies are indented under the main assembly.

7.1 DIAGRAMS

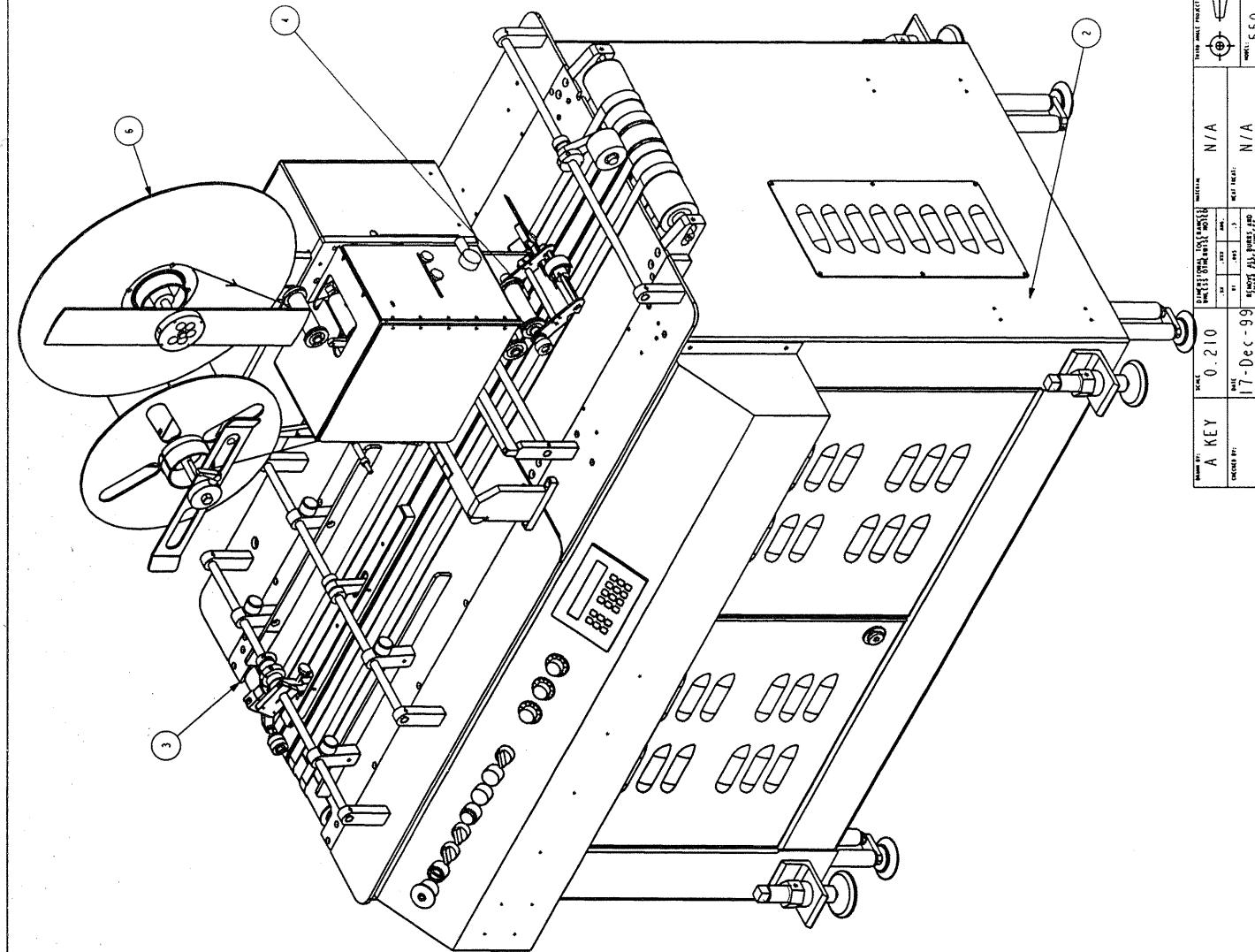
DRAWING #	DESCRIPTION
KR550 BASE	KR550 BASE
537864-01	Assy, Beam Switch Mount
537857-01	Assy, 219IJ+20 in Ext 535HD
537858-01	Assy, 219 535HD 20 in Ext
537865-01	Assy, Front Roller
537866-01	Assy, Dynapar Encoder Mount
538022-01	Assy, Motor Mount
537855-01	Assy, 219IJ Cabinet
541881-01	Assy, Control Panel
538024-01	Assy, 1 in Leveling Leg
538869-01	KR535HD
536382-04	Assy, Frame Mount
536399-02	Assy, Pinch Roller, Drive
536320-02	Assy, Roller Drive
536400-01	Assy, Bearing Plate
537667-01	Assy, Nip Roller
537668-01	Assy, Eccentric Shaft w/Pin
536738-03	Assy, Pinch Roller, Unwind
536320-03	Assy, Roller Drive
536400-02	Assy, Bearing Plate, Unwind
536817-01	Assy, Web Drag
536746-01	Assy, Label Roll
536763-01	Assy, Unwind Wheel
537670-01	Assy, Unwind Support Bar
537671-01	Assy, Unwind Bearing Plate
537674-01	Assy, Swing Arm Brake
536749-02	Assy, Rewind
536959-01	Assy, Slip Clutch
537673-01	Assy, Rewind Bearing Support
536767-01	Assy, Vertical Adjustment
536769-02	Assy, Stripper Plate
536581-02	Assy, Sensor Slide
536806-01	Assy, Pinch Roller Arm
536832-01	Assy, Guide Roller
536832-03	Assy, Guide Roller
537672-01	Assy, Pinch Roller

536784-01	Assy, Electrical Connection Plate
536805-01	Assy, Motor Tab Drive
536805-02	Assy, Motor Unwind
536832-19	Assy, Guide Roller Drag
536951-01	Assy, Frame Cross Adjustment
536766-02	Assy, Cross Adjustment
536957-01	Assy, Label Trey Cover
537669-01	Assy, Frame w/ Bearings

KRS550

ITEM QTY	PART #	DESCRIPTION
1	100932-3	BELT, TIMING 255L075
2	533855-01	ASSY, 2191J CABINET
3	533857-02	ASSY, 2191J+20 IN EXT 535HD
4	533864-01	ASSY, BEAM SWITCH MOUNT
5	538022-01	ASSY, MOTOR MOUNT
6	538889-01	ASSY, KRS55HD

ITEM QTY	PART #	DESCRIPTION
1	100932-3	BELT, TIMING 255L075
2	533855-01	ASSY, 2191J CABINET
3	533857-02	ASSY, 2191J+20 IN EXT 535HD
4	533864-01	ASSY, BEAM SWITCH MOUNT
5	538022-01	ASSY, MOTOR MOUNT
6	538889-01	ASSY, KRS55HD

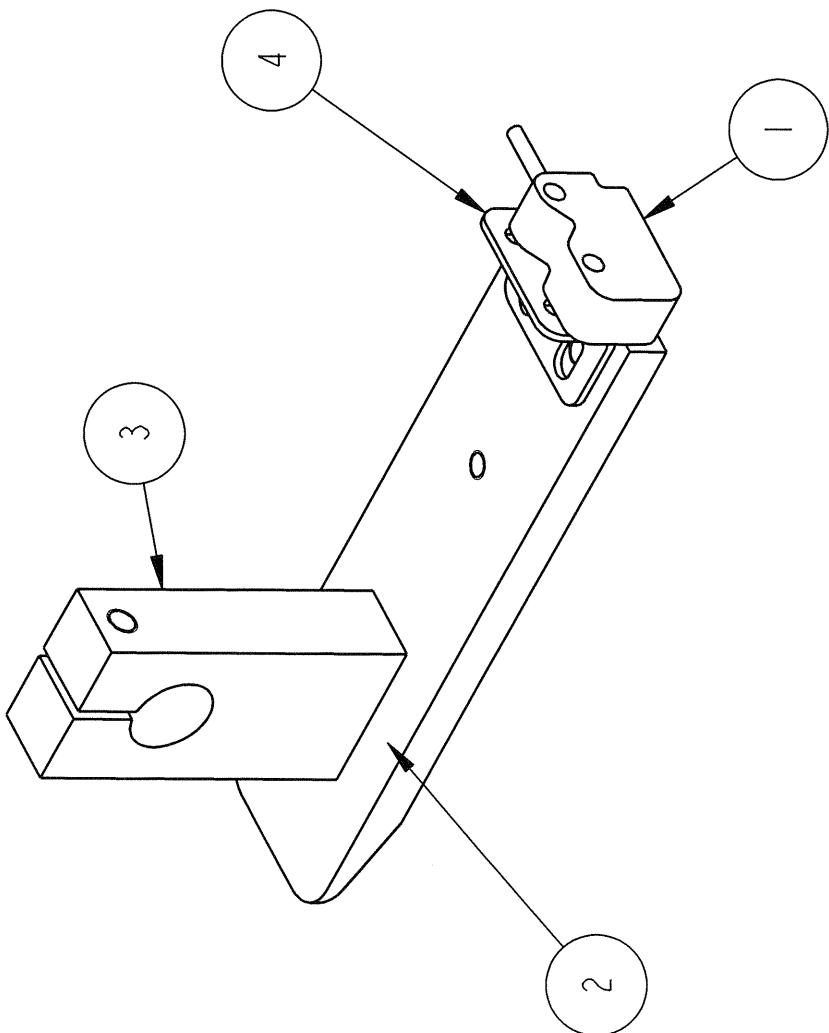


ITEM QTY		PART #	DESCRIPTION	REMARKS
1	1	5550	ASSY, 2191-20 KRS55HD BASE	ASSEMBLED
2	1	100932-3	BELT, TIMING 255L075	
3	1	533855-01	ASSY, 2191J CABINET	
4	1	533857-02	ASSY, 2191J+20 IN EXT 535HD	
5	1	533864-01	ASSY, BEAM SWITCH MOUNT	
6	1	538022-01	ASSY, MOTOR MOUNT	
7	1	538889-01	ASSY, KRS55HD	

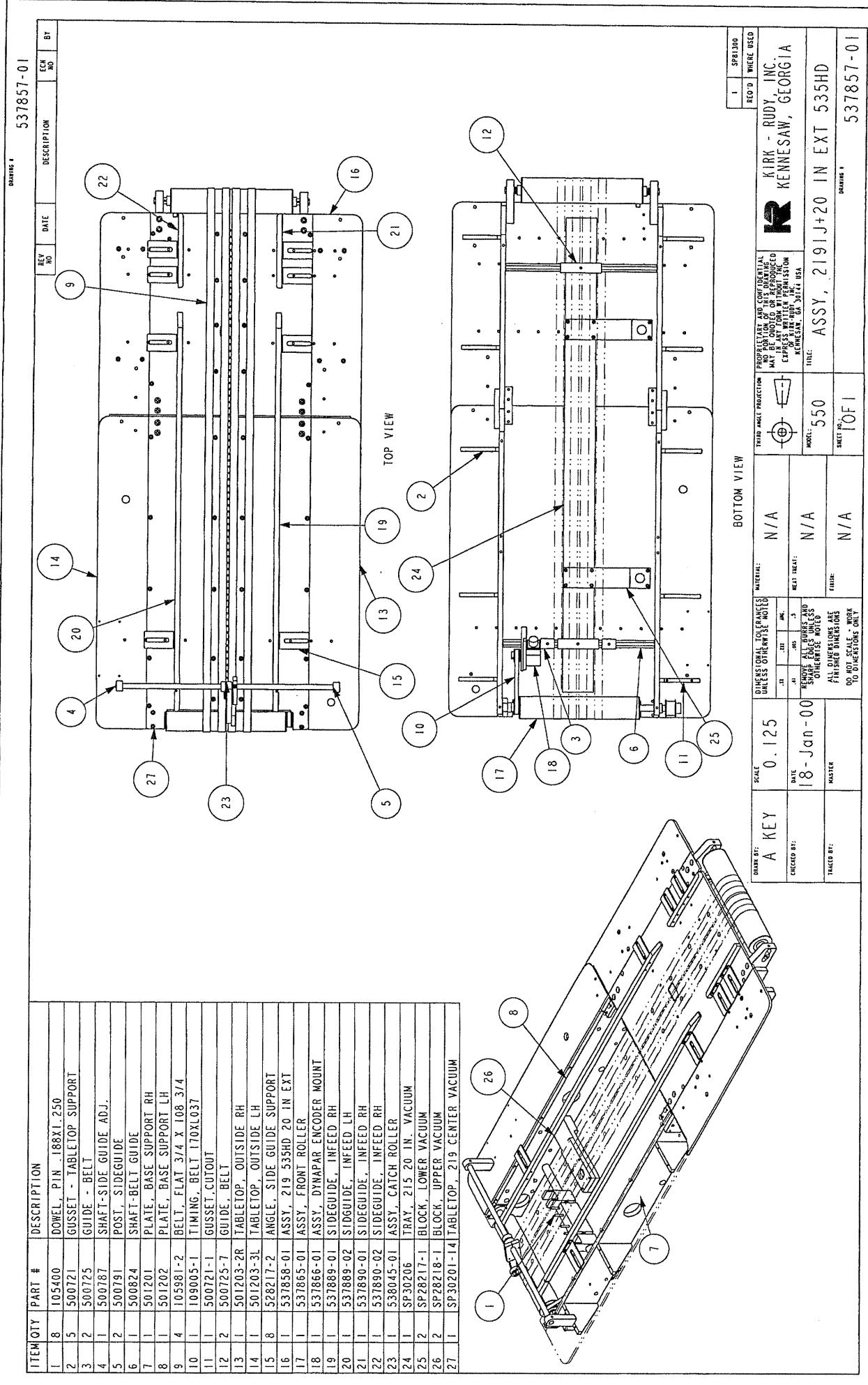
ITEM QTY	PART #	DESCRIPTION
1	1	202261-27 BANNER SWITCH, SENSOR
2	1	537862-01 BRACKET, BEAMSWITCH MOUNT
3	1	537863-01 CLAMP, BEAMSWITCH MOUNT
4	1	544720-01 BRACKET, SENSOR MOUNTING

ITEM	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	1	REPLACED SENSOR ADDED	1	9/26/2003	544720-01 SENSOR BRACKET	7000	TJG

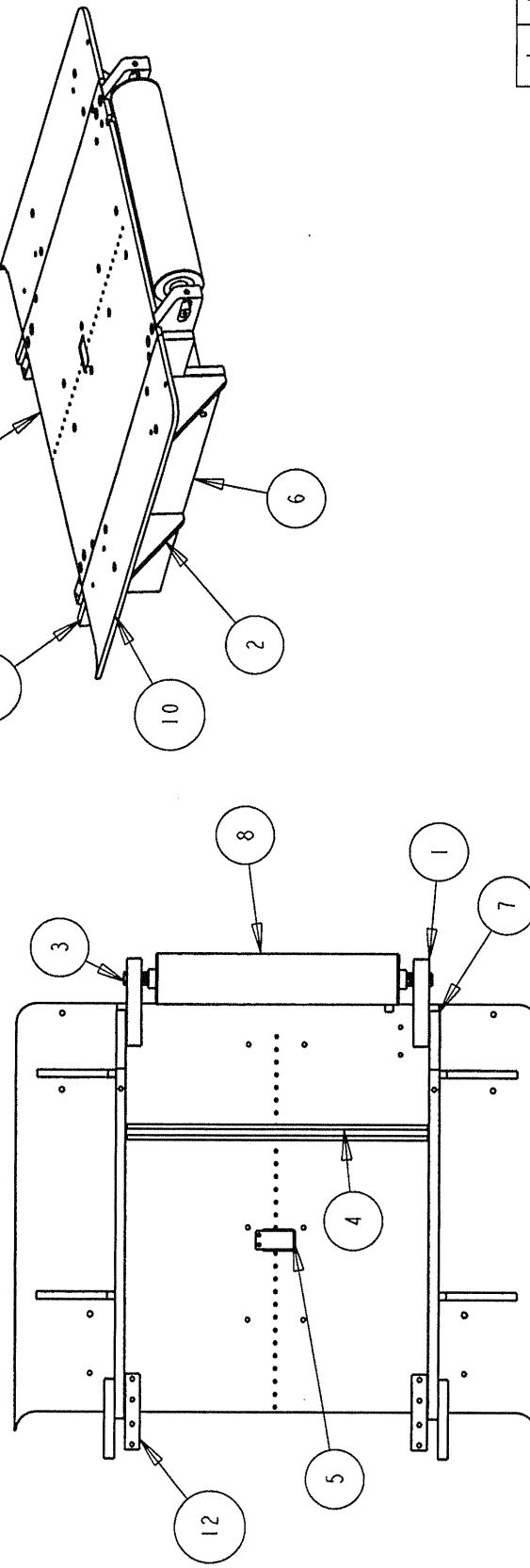
I	SP81300
REQ'D	WHERE USED



DRAWN BY: A KEY	SCALE .000	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED			MATERIAL: N/A	THIRD ANGLE PROJECTION +---+ +---+	PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE COPIED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC. WOODSTOCK, GA 30188 USA
CHECKED BY:	DATE 28 - Jan - 00	.XX	.XXX	ANG. .01 .005 .5	HEAT TREAT: N/A	MODEL: 550	TITLE: ASSY, BEAM SWITCH MOUNT
TRACED BY:	MASTER	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED			FINISH: N/A	SHEET NO: 1 OF 1	DRAWING #: 537864-01



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	1	202246-1 REFLECTOR, RECTANGLE					
6	1	500701-1L PLATE BASE SUPPORT 20 IN EXT LH&RH					
7	1	500701-1R PLATE BASE SUPPORT 20 IN EXT LH&RH					
8	1	500835-A ASSY, TUBE ROLLER					
9	1	536267-03 TABLETOP RH OUTSIDE 20 IN. EXT.					
10	1	536267-04 TABLETOP LH OUTSIDE 20 IN. EXT.					
11	2	SPI 8606 PLATE, SCAB					
12	2	SP 8616 PLATE - TABLETOP SPLICE					
13	1	SP30205-2 TABLETOP-CENTER					



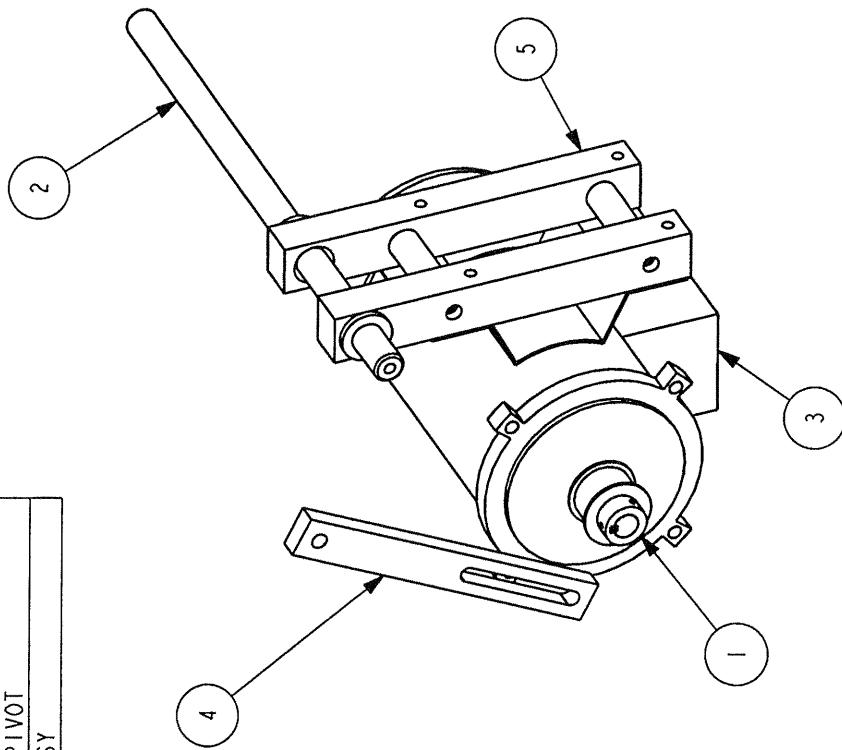
DRAWN BY: A KEY	SCALE: 0 . 125	MATERIAL: N/A	THIRD ANGLE PROJECTION +---+	PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE COPIED OR REPRODUCED IN WHOLE OR IN PART WITHOUT PERMISSION OF KIRK-RUDY, INC. KENNESAW, GA 30144 USA
CHECKED BY:	DATE: 22-Dec-99	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED .01 .005 .005 .005 .005 .005 .005 .005 .01 .005 .005 .005 .005 .005 .005 .005 .01 .005 .005 .005 .005 .005 .005 .005 .01 .005 .005 .005 .005 .005 .005 .005	HEAT TREAT: N/A	KIRK - RUDY, INC. KIRK-RUDY, INC. KENNESAW, GEORGIA
TRACED BY: MASTER	FINISH: N/A	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY	MODEL: 550	TITLE: ASSY, 219 535HD 20 IN EXT
	SHEET NO: 10F 1		537858-01	DRAWING #: 537858-01

ITEM	PART #	DESCRIPTION
1	108785	PULLEY 16XL037 .375B MK
2	202388-2	ENCODER, DYNAPAR
3	SP45241	PLATE - ENCODER MOUNT

ITEM NO.	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	SP81300				
RECD	WHERE USED				

DRAWING NO.:	SCALE	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	MATERIAL:	THIN 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	.11 .115 .005 .005 .005 .005	N/A	-	
TRACED BY:	MASTER	28-Jan-00	N/A	N/A	KIRK-RUDY, INC. KENNESAW, GA 30144 USA
		REMOVES ALL PURSES AND SHARP EDGES UNLESS OTHERWISE NOTED	FINISH:	SET UP TO FLOOR	ASSY, DYNAPAR ENCODER MOUNT
		ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE WORK TO DIMENSIONS ONLY	FINISH:		537866-01

ITEM	QTY	PART #	DESCRIPTION
1	1	108809	PULLEY, TIMING 12L075 .625B .188K
2	1	500824	SHAFT-BELT GUIDE
3	1	2000152-2	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

1	KR2191J20
1	KR2191J

REQ'D WHERE USED

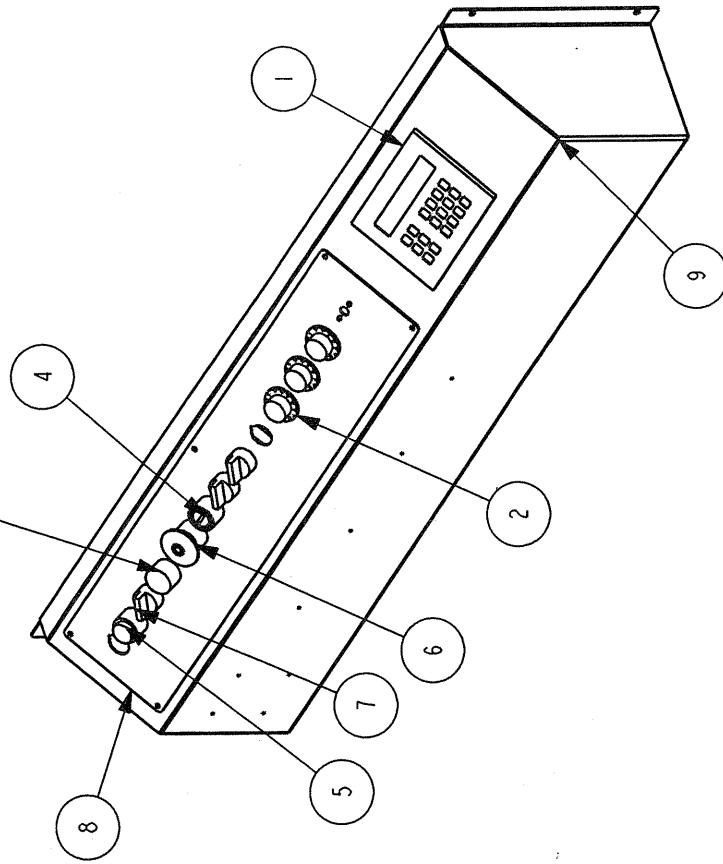
DRAWN BY: A Y B	SCALE 0 . 250	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED		MATERIAL: N / A	THIRD ANGLE PROJECTION	PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE QUOTED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC. KENNESAW, GA 30144 USA	
CHECKED BY:	DATE 16 - Nov - 99	.01	.005	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. 10F 1	DRAWING # 538022-01	

ITEM QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	200120	BLOWER, GAST	1	9/26/2003	REPLACED CONTROL BOX ASSY 537867-01 WITH ASSY 541881-01	7000	TJG
2	190689-1	DOOR LATCH					
3	191029-1	PUMP, MOVOTEC PB4612FC					
4	530441-01	BOX, ELECTRICAL INLET 20A					
5	530865-03	PANEL, 219 FRONT COVER					
6	537343-01	SPACER, LIFT KIT MOUNT					
7	537344-01	COVER, LIFT KIT HOLE					
8	537345-02	WLDMNT, ELECTRICAL BOX					
9	537367-01	COVER, CABINET FAN					
10	537856-01	WLDMNT, 219 BASE CABINET					
11	4	538024-01 ASSY, 1 IN. LEVELING LEG					
12	2	539424-01 ASSY, RH HYDRAULIFT LEG					
13	2	539425-01 ASSY, LH HYDRAULIFT LEG					
14	1	541881-01 ASSY, CONTROL PANEL					

A KEY SCALE 0 .080 DIMENSIONAL TOLERANCES MATERIAL: N/A THIRD ANGLE PROJECTION PROPRIETARY AND CONFIDENTIAL
UNLESS OTHERWISE NOTED NO PORTION OF THIS DRAWING
DATE 21-Dec-99 .xx .xxx .005 .5 ANG. MAY BE QUOTED OR REPRODUCED
CHECKED BY: REMOVE ALL BURRS AND OTHERWISE NOTED IN ANY FORM WITHOUT THE
TRACED BY: SHARP EDGES UNLESS EXPRESS WRITTEN PERMISSION
MASTER N/A FINISH: N/A OF KIRK-RUDY, INC.
TO DIMENSIONS ONLY

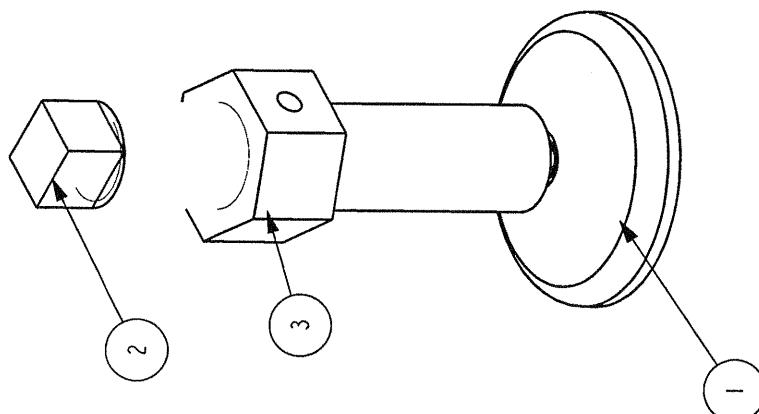
I	SP81300
RECD WHERE USED	

ITEM QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	1	202466 DISPLAY, MAPLE					
2	3	209016 KNOB, POT					
3	1	201124-2 BUTTON, START					
4	1	201124-4 BUTTON, POWER ON					
5	1	201125-3 BUTTON, STOP					
6	1	201125-5 BUTTON, POWER OFF					
7	3	201145-1 SELECTOR, 2 POSITIONS					
8	1	500421-1 PNL, CONTROL					
9	1	541882-01 BOX, CONTROL					



DRAWN BY:	A KEY	SCALE	0 . 150	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	MATERIAL:	N / A	THIRD ANGLE PROJECTION	KIRK - RUDY, INC.
CHECKED BY:		DATE	06 - Mar - 02	.XX .XXX ANG.	HEAT TREAT:	N / A		
TRACED BY:	MASTER			.01 .005 .5	FINISH:	N / A	WOODS STOCK, GEORGIA	WOODS STOCK, GA 30186 USA
				REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED			TITLE:	ASSY, CONTROL PANEL
				ALL DIMENSIONS ARE FINISHED DIMENSIONS			SHEET NO.	1 OF 2
				DO NOT SCALE - WORK TO DIMENSIONS ONLY			DRAWING #	541881-01

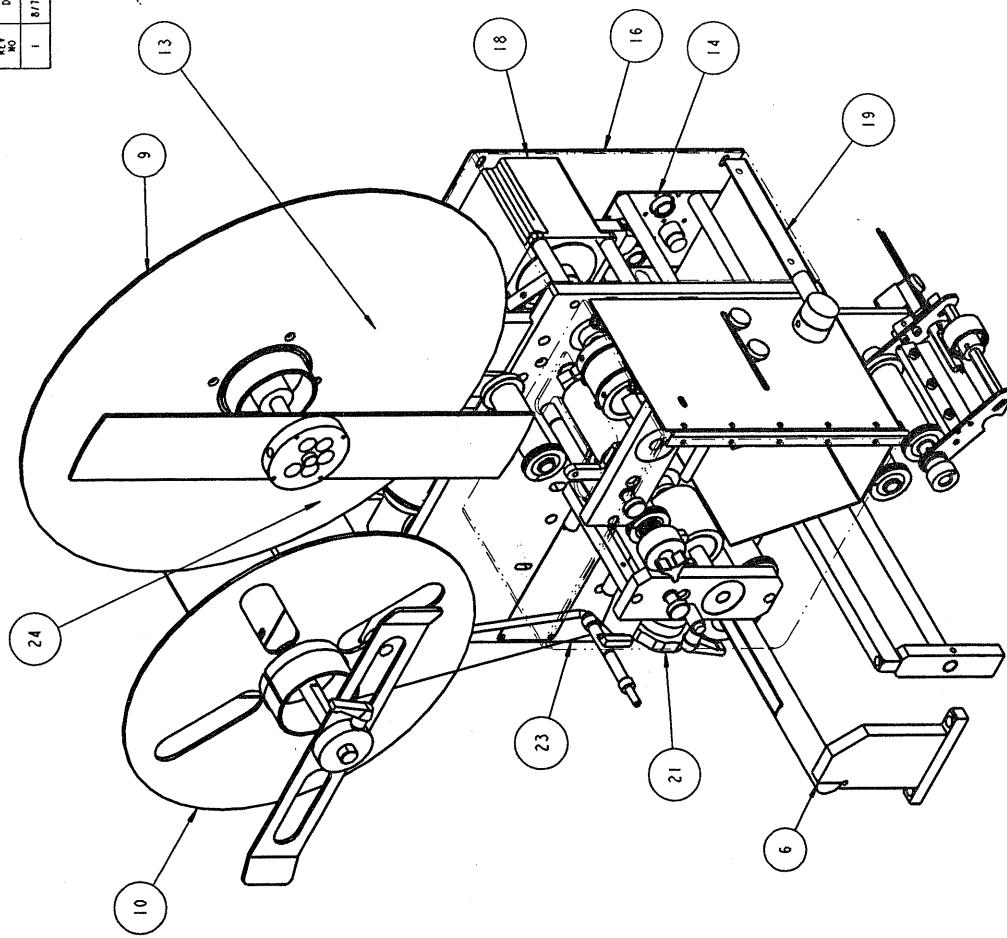
ITEM QTY	PART #	DESCRIPTION
1	190634	FOOT, MOUNTING
2	191010	LEVELING BOLT, CABINET
3	191011	NUT, CABINET LEVELING



DRAWN BY:	SCALE	0 . 625	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	MATERIAL: N / A	THIRD ANGLE PROJECTION	PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE QUOTED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC. KENNESAW, GA 30144 USA
CHECKED BY:	DATE	16 - Nov - 99	.XX .XXX .01 .065 .5	HEAT TREAT: N / A	GENERAL	TITLE: ASSY, 1 IN. LEVELLING LEG
TRACED BY:	MASTER		REMOVE ALL BURS AND SHARP EDGES UNLESS OTHERWISE NOTED ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY	FINISH: N / A	SHEET NO.: 1 OF 1	DRAWING #: 538024-01

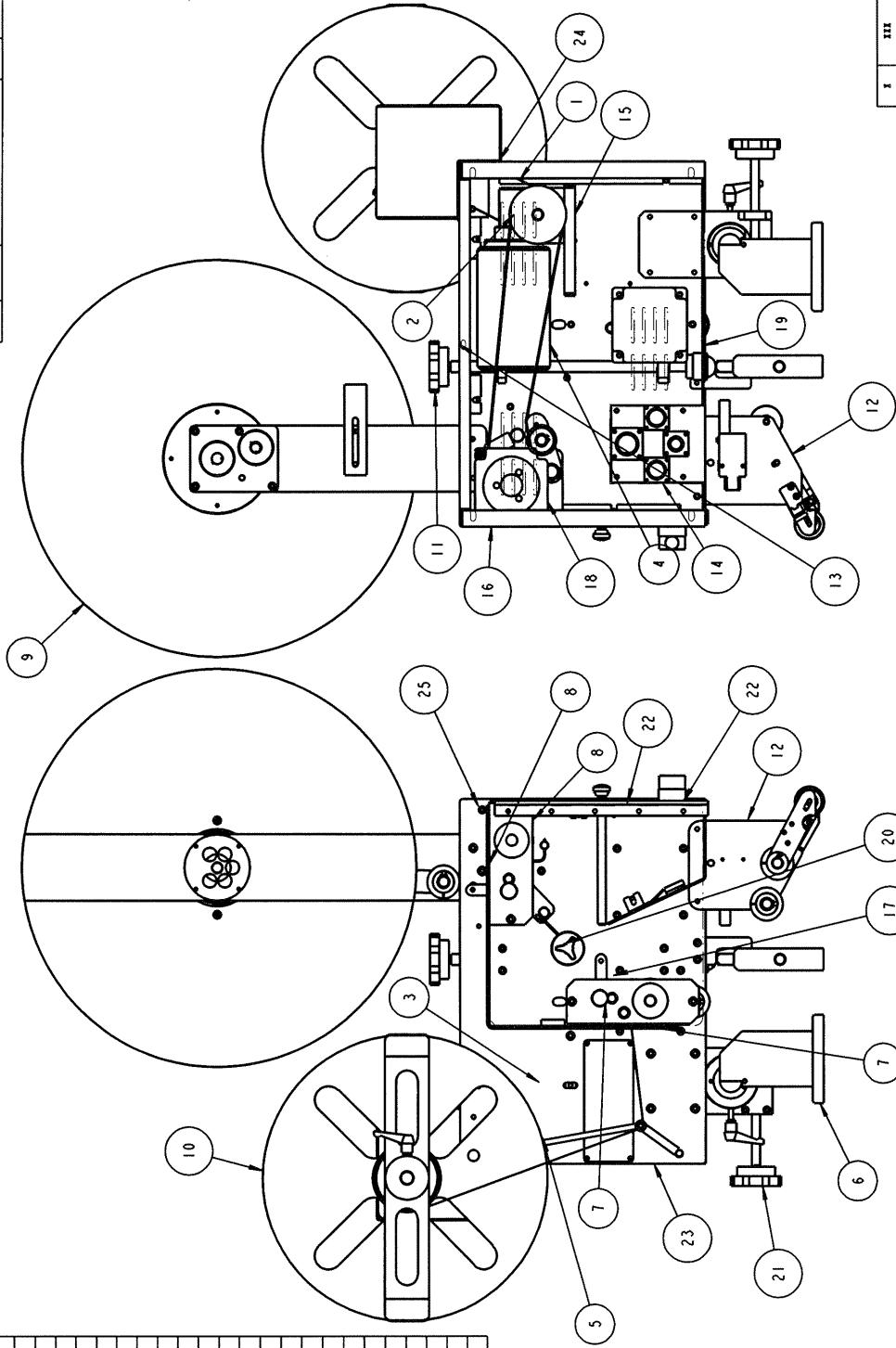
ITEM QTY	PART #	DESCRIPTION
1	109014	BELT, TIMING 200XL037
2	109857	PULLEY, 32XL037 .500B NK
3	109990	PULLEY, TIMING 20L050 .500B NK
4	200613	MOTOR, AC 1/20 HP
5	108909-5	BELT, TIMING 322L050
6	536382-04	ASSY-FRAME MOUNT
7	536399-02	ASSY, PINCH ROLLER DRIVE
8	536738-03	ASSY, PINCH ROLLER UNWIND
9	536746-01	ASSY-LABEL ROLL
10	536749-02	ASSY, REWIND
11	536761-01	ASSY, VERTICAL ADJUSTMENT
12	536769-02	ASSY-STRIpper PLATE
13	536780-02	COVER-LH
14	536784-01	ASSY-ELECTRICAL CONNECTION PLAT
15	536794-02	PLATE-TAKEUP MOTOR
16	536797-02	PLATE-COVER
17	536805-01	ASSY, MOTOR TAB DRIVE
18	536805-02	ASSY, MOTOR UNWIND
19	536826-01	COVER-BOTTOM
20	536832-19	ASSY, GUIDE ROLLER DRAG
21	536951-01	ASSY, FRAME CROSS ADJUSTMENT
22	536957-01	ASSY, LABEL TRAY COVER
23	531669-01	ASSY, FRAME W/ BEARINGS
24	538164-02	COVER, REWIND SHAFT
25	538829-01	ASSY, UNWIND CLUTCH

ITEM QTY	PART #	DATE	DESCRIPTION	ECN NO	BT
1	109014	8/17/2001	NAME WAS KR535HD	9725	1.96



DRAWING NUMBER:		DRAWING DATE:		PROPRIETARY AND CONFIDENTIAL	
1	III	REC'D	NAME USED	KRK - RUDY, INC.	
2	26-Mar-01			WOODSTOCK, GEORGIA	
3	535HD				
4	1 OF 4				
NAME:		REVISION:		DATE:	
T J G		0 . 300		N/A	
CHECKED BY:		IN		IN	
TRACK #:		26 - Mar - 01		N/A	
MAILED:		ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED		N/A	
NOTES:		REF ID: 538869-01		538869-01	

ITEM QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BT
1	1	109014 BELT, TIMING 200XL037	1	8/7/2001	NAME WAS KR535HD	6125	1.6
2	1	1098570 PULLEY, TIMING 32XL037 500B MK					
3	1	1099190 PULLEY, TIMING 20L050 .500B MK					
4	1	200613 MOTOR, AC 1/20 HP					
5	1	108909-5 BELT, TIMING 322L050					
6	1	536382-04 ASSY-FRAME MOUNT					
7	1	536399-02 ASSY, PINCH ROLLER DRIVE					
8	1	536738-03 ASSY, PINCH ROLLER UNWIND					
9	1	536746-01 ASSY-LABEL ROLL					
10	1	536749-02 ASSY, REWIND					
11	1	536761-01 ASSY, VERTICAL ADJUSTMENT					
12	1	536769-02 ASSY-STRIpper PLATE					
13	1	536780-02 COVER-LH					
14	1	536784-01 ASSY-ELECTRICAL CONNECTION PLAT					
15	1	536794-02 PLATE-TAKEUP MOTOR					
16	1	536797-02 PLATE-COVER					
17	1	536805-01 ASSY, MOTOR TAB DRIVE					
18	1	536805-02 ASSY, MOTOR UNWIND					
19	1	536826-01 COVER-BOTTOM					
20	1	536832-19 ASSY, GUIDE ROLLER DRAG					
21	1	536951-01 ASSY, FRAME CROSS ADJUSTMENT					
22	1	536957-01 ASSY, LABEL TRAY COVER					
23	1	531669-01 ASSY, FRAME W/ BEARINGS					
24	1	538164-02 COVER, REWIND SHAFT					
25	1	538829-01 ASSY, UNWIND CLUTCH					



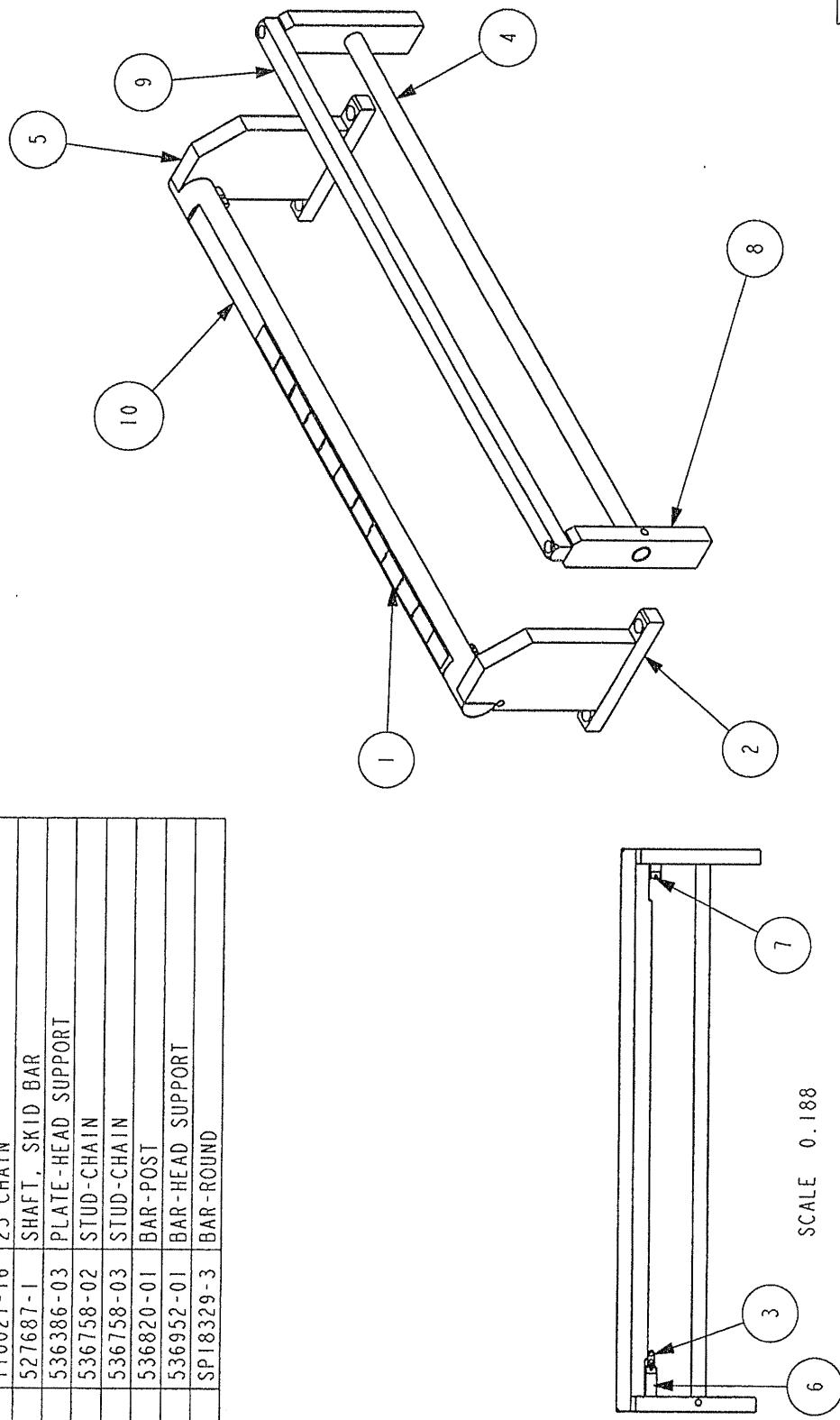
DRAWING #:		SCALE:		DIMENSION TOLERANCES		MATERIAL:		FINISH:		REMOVED:		WHERE USED:	
ITEM	NUMBER	IN	MM	IN	MM	IN	MM	IN	MM	IN	MM	IN	MM
1	T JG	0	.200	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	KIRK - RUDY, INC.	
CHECKED BY:		DATE:	26 - Mar - 01	INCHES	MM	INCHES	MM	INCHES	MM	INCHES	MM	WOODSTOCK, GEORGIA	
TRACED BY:		MASTER											

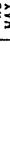
ASSY, KR535HD

ITEM	NUMBER	DESCRIPTION	REV NO	DATE	DESCRIPTION	REV NO	DATE

DRAWING # 538869-01

ITEM QTY	PART #	DESCRIPTION
1	190838	SCALE
2	500794	PLATE - MOUNTING
3	110021-16	25 CHAIN
4	527687-1	SHAFT, SKID BAR
5	536386-03	PLATE - HEAD SUPPORT
6	536758-02	STUD-CHAIN
7	536758-03	STUD-CHAIN
8	536820-01	BAR - POST
9	536952-01	BAR - HEAD SUPPORT
10	SP18329-3	BAR - ROUND



DRAWN BY:	SCALE	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	REC'D WHERE USED
TVK	0 . 250	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED			
CHECKED BY:	DATE	.xx .xxx .005 .5	ANG.		
	22-0c†-99		MEAT TREAT:		
TRACED BY:	MASTER	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED	NONE	MODEL: SP 76300	NAME: ASSY-FRAME MOUNT
		ALL DIMENSIONS ARE FINISHED DIMENSIONS	FINISH:	SHEET NO. 1 OF 1	DRAWING # 536382-04
		DO NOT SCALE - WORK TO DIMENSIONS ONLY			

ITEM	QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	1	102793	SPRING, COMP OD .36 W.03 L.75					
2	2	104100	SNAPRING .375					
3	4	104106	SNAPRING .500					
4	1	104107	SNAPRING .250					
5	1	190839	MAGNET, BUNTING					
6	1	532785-01	ASSY, SPRING CLIP					
7	1	536037-01	PLATE-RELEASE					
8	1	536044-01	KNOB-LOCKING					
9	1	536320-02	ASSY, ROLLER DRIVE					
10	1	536329-01	SHAFT, SPACER					
11	1	536400-01	ASSY-BEARING PLATE					
12	1	536801-01	BAR-SPACER,BEARING PLATE					
13	1	536804-01	SHAFT-DRIVE					
14	1	536833-01	ROLLER, WEB					
15	1	536958-01	SPACER-MAGNET					
16	1	537667-01	ASSY, NIP ROLLER					
17	1	537668-01	ASSY, ECCENTRIC SHAFT W/PIN					
18	1	538101-01	DISK, TAB GUIDE					
19	2	539684-01	SPACER, TABLETOP					
20	1	CSD213	SCREW, SHCS 6-32X.875					
21	1	HMSN08	NUT, HEX #6-32					

SCALE 0.250

ITEM	QTY	PART #	DESCRIPTION
1	1	536312-02	ROLLER CORE
2	1	536313-02	ROLLER-CORE, KEYED
3	1	536397-02	COATING, URETHANE DUR60

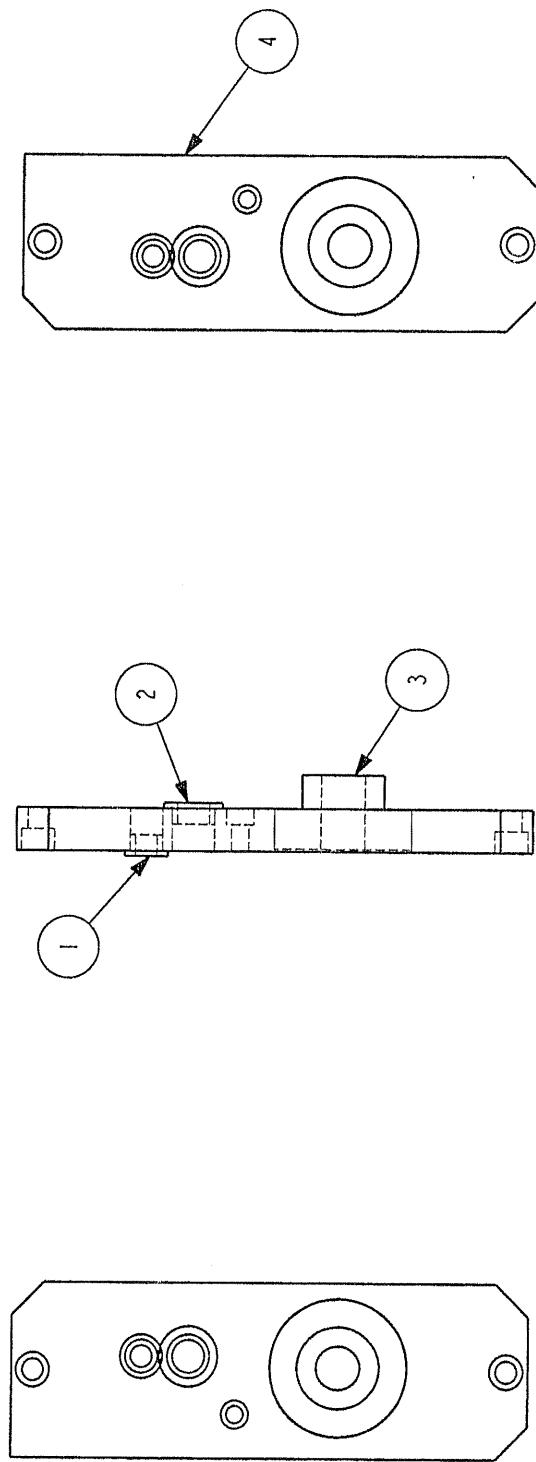
REV NO	DATE	DESCRIPTION	ECN NO	BY

SCALE 0.500

NOTE:
1. DUROMETER 60

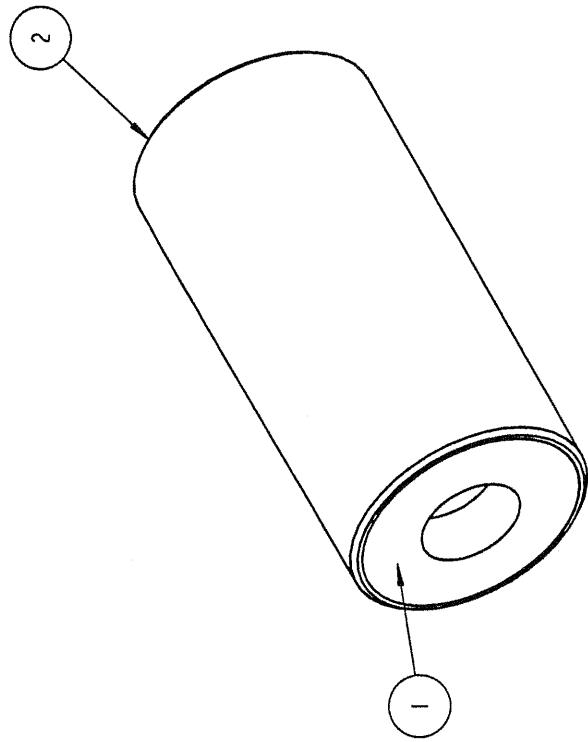
2	535
REQ'D	WHERE USED

ITEM QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ETCH NO	BY
1	100309	BUSHING, FL. 250ID.375OD.250LG					
2	100330	BUSHING, FL. 375ID.500OD.250LG					
3	103803	BEARING, HUB .500					
4	1	536732-01 BAR-BEARING, DRIVE					



I	SP76300	
RECD	WHERE USED	
ASSY - BEARING PLATE		
536400-01		
DRAWN BY: TVK		
SCALE: 0 . 500		
DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED		
.XX	.XX	ANG.
.01	.065	.5
HEAT TREAT:		XXX
NOTE: REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED		SP76300
ALL DIMENSIONS ARE FINISHED DIMENSIONS		SHEET NO. 1 OF 1
DO NOT SCALE - WORK TO DIMENSIONS ONLY		DRAWING #
CHECKED BY: 13 - Aug - 99		KIRK - RUDY, INC.
MASTER M		KENNESAW, GEORGIA

ITEM	QTY	PART #	DESCRIPTION
1	2	103110	BEARING, FLAT .625
2	1	536040-02	ROLLER, UNWIND PINCH



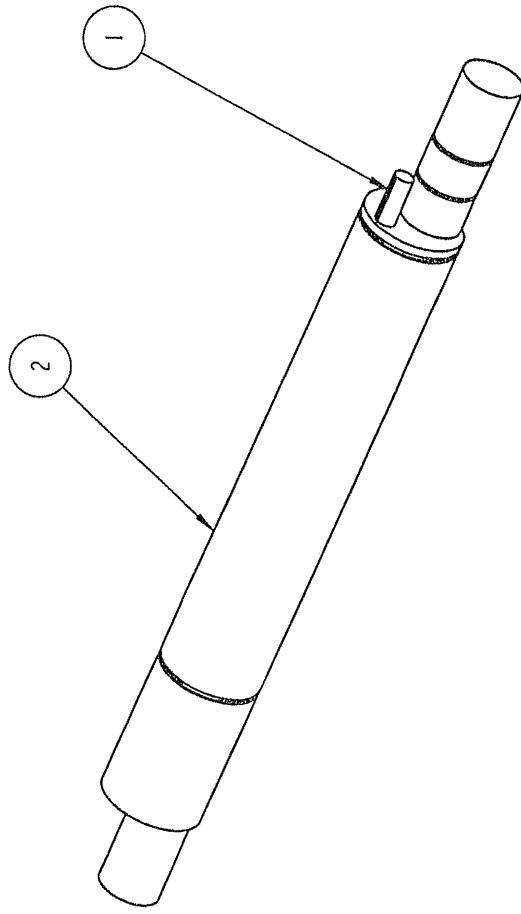
REV NO	DATE	DESCRIPTION	ECN NO	BY
-----------	------	-------------	-----------	----

2	KR53540
REC'D	WHERE USED
JOY, INC. GEORGIA	
337667-02	

OKANE

537668-01

ITEM	QTY	PART #	DESCRIPTION
1	1	05210	PIN, ROLL .125X.750
2	1	536328-01	SHAFT-ECCENTRIC

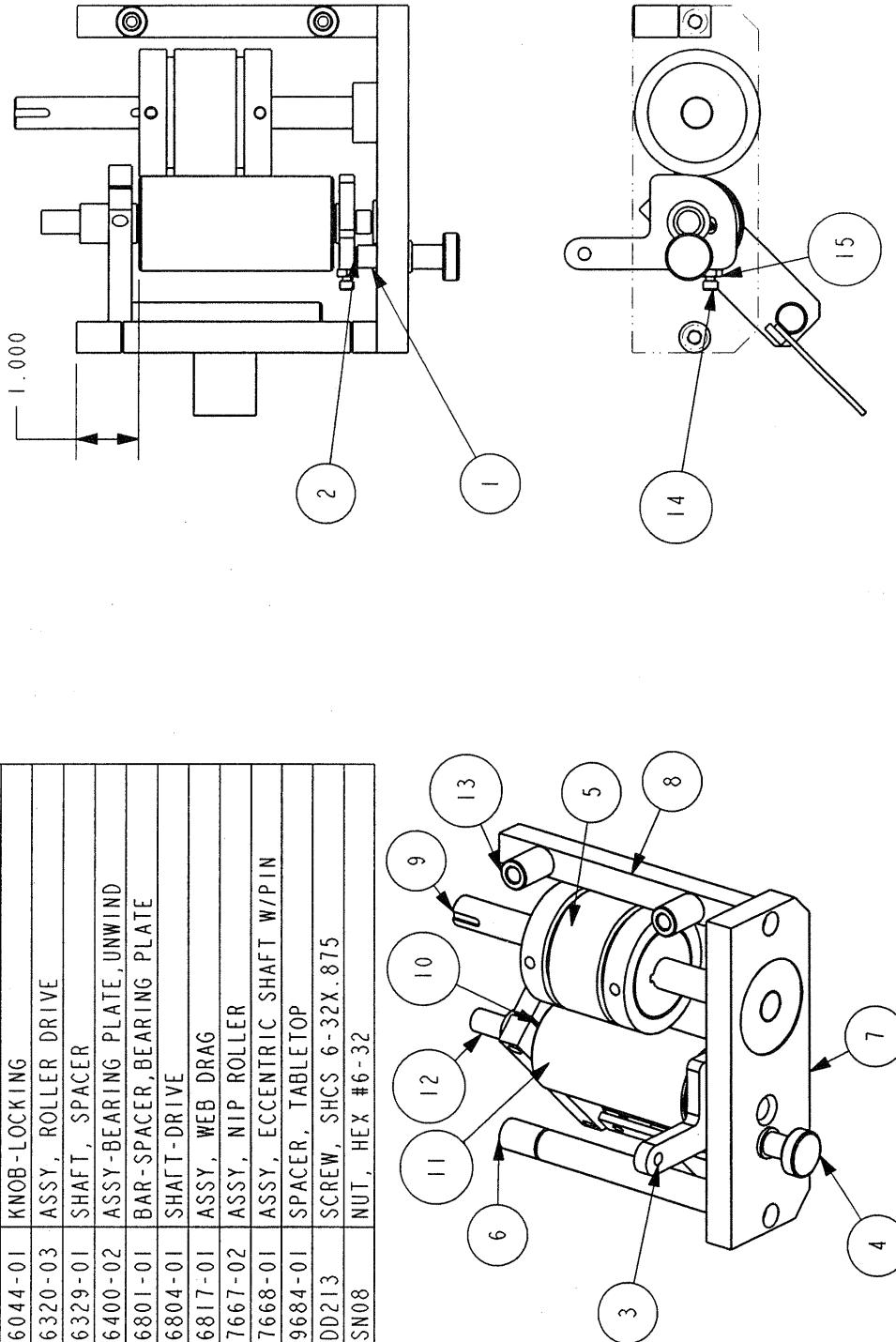


REV NO	DATE	DESCRIPTION	ECN NO	BY
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2 | 536328-01 SHAFT-ECCENTRIC

DRAWN BY:	T J G	SCALE	1 . 000	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED			MATERIAL:	X X X	THIRD ANGLE PROJECTION	PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE QUOTED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC. KENNESAW, GA 30144 USA			KIRK - RUDY, INC.	KIRK-RUDY, INC.	2	KR535HD
CHECKED BY:		DATE	01 - NOV - 99	.01	.005	.5	ANG.								REO'D	WHERE USED
TRACED BY:		MASTER	M	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED			HEAT TREAT:	X X X		MODEL:	535	NAME:	ASSY , ECCENTRIC SHAFT W/PIN	SHEET NO.	DRAWING #	
				ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE WORK TO DIMENSIONS ONLY			FINISH:	X X X								

ITEM QTY	PART #	DESCRIPTION
1	102793	SPRING, COMP OD. 36 W.03 L.75
2	104107	SNAPRING, .250
3	536037-01	PLATE-RELEASE
4	536044-01	KNOB-LOCKING
5	536320-03	ASSY, ROLLER DRIVE
6	536329-01	SHAFT, SPACER
7	536400-02	ASSY-BEARING PLATE, UNWIND
8	536801-01	BAR-SPACER, BEARING PLATE
9	536804-01	SHAFT-DRIVE
10	536817-01	ASSY, WEB DRAG
11	537667-02	ASSY, NIP ROLLER
12	537668-01	ASSY, ECCENTRIC SHAFT W/PIN
13	2	539684-01 SPACER, TABLETOP
14	1	CSDD213 SCREW, SHCS 6-32X.875
15	1	HMSN08 NUT, HEX #6-32



REV NO	DATE	DESCRIPTION	ECN NO	BY
1	10/10/2000	MODIFIED FOR WIRE STRIPPER ADDED WIRE GROOVES TO ROLLER	6596	TJG

1 000	XRS35HD
REQ'D	WHERE USED

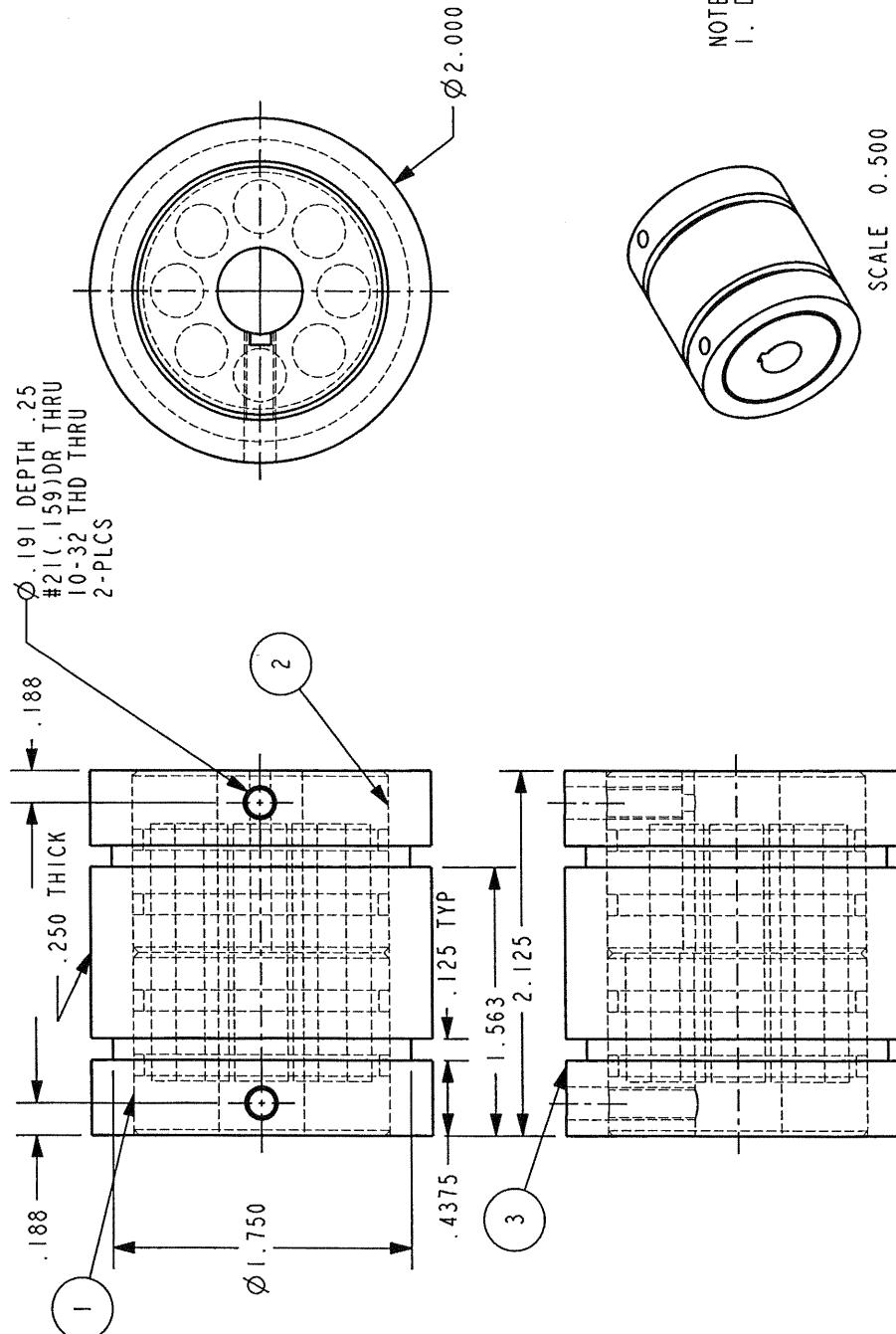
1	2	3	4	5	6	7	8	9	10	11	12	13	14	15
1	2	3	4	5	6	7	8	9	10	11	12	13	14	15
1	2	3	4	5	6	7	8	9	10	11	12	13	14	15
1	2	3	4	5	6	7	8	9	10	11	12	13	14	15
1	2	3	4	5	6	7	8	9	10	11	12	13	14	15

DRAWN BY:	SCALE	MATERIAL:	THIRD ANGLE PROJECTION	PROPRIETARY AND CONFIDENTIAL PORTION OF THIS DRAWING MAY NOT BE QUOTED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC. KENNESAW, GA 30144, USA
TVK	0.375	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	XXX	
CHECKED BY:	DATE	.XX .XXX .005 .5	HEAT TREAT:	
	22-0ct-99	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED	XXX	
TRACED BY:	MASTER	ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY	FINISH:	535
			SHEET NO.	1 OF 1
			NAME:	DRAWING #

KIRK - RUDY, INC.
KENNESAW, GEORGIA

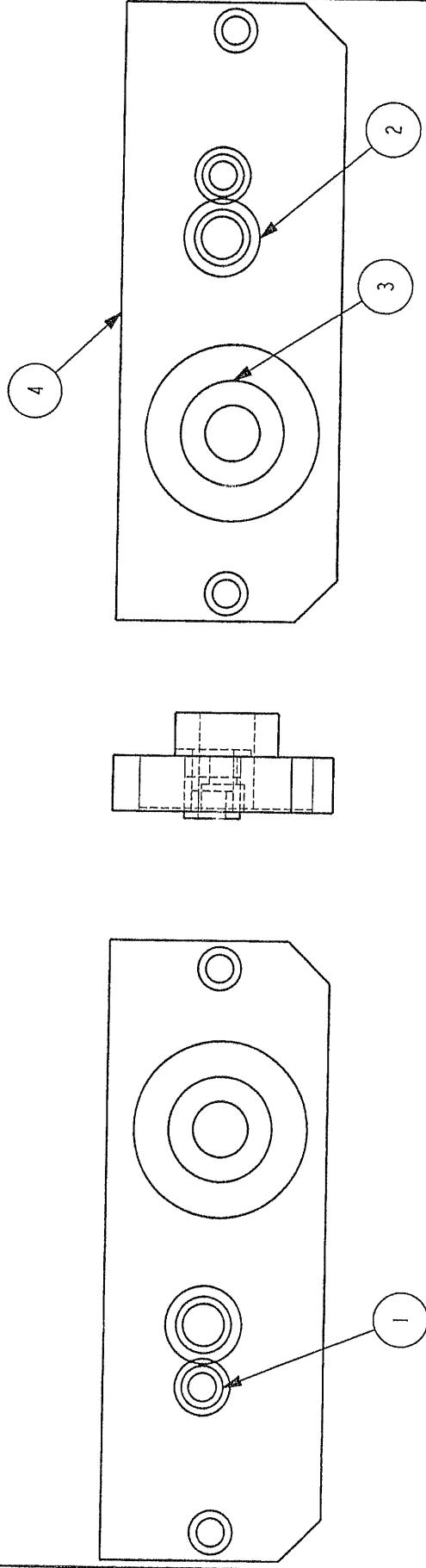
536738-03

ITEM QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	1	536312-02 ROLLER-CORE					
2	1	536313-02 ROLLER-CORE, KEYED					
3	1	536397-02 COATING, URETHANE DUR60					



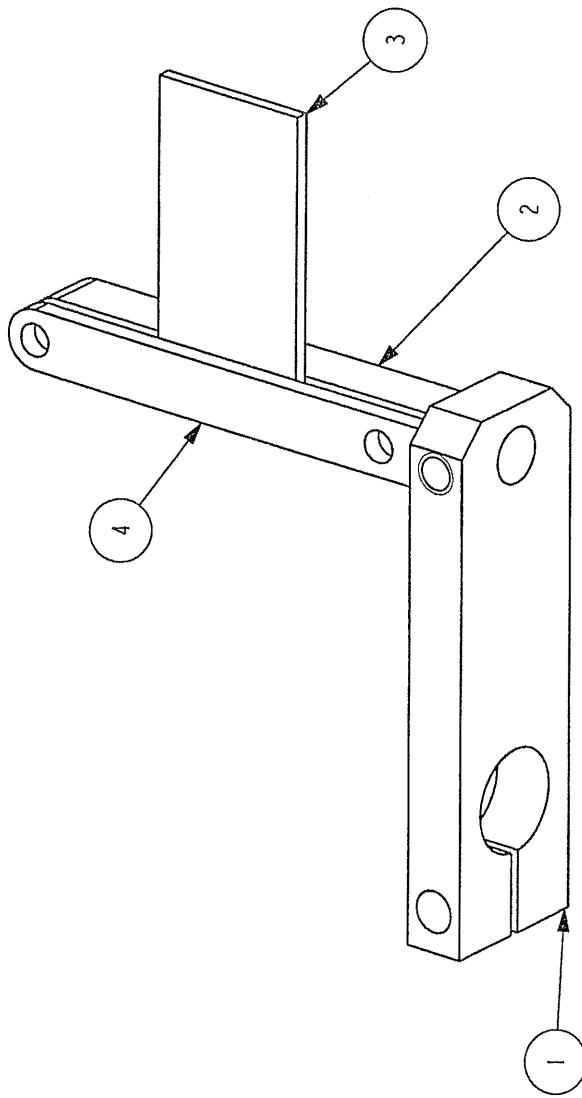
DRAWN BY: T JG	SCALE: .000	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED		MATERIAL: XXX	THIRD ANGLE PROJECTION		PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE COPIED OR REPRODUCED IN WHOLE OR IN PART EXCEPT WITH WRITTEN PERMISSION OF KIRK-RUDY INC. KENNESAW, GA 30144 USA	NOTE: 1. DUROMETER 60
CHECKED BY: 19-MAY-00	DATE 19-MAY-00	.01	.005	ANG. .5	HEAT TREAT: XXX		MODEL: 535	TITLE: KIRK - RUDY INC. KENNESAW, GEORGIA
TRACED BY: M	MASTER	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED		FINISH: XXX	SHEET NO.: 10F1	DRAWING #: 536320-03		
		ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY						

ITEM QTY	PART #	DESCRIPTION
1	100309	BUSHING, FL. 250ID. 375OD. 250LG
2	100330	BUSHING, FL. 375ID. 500OD. 250LG
3	103803	BEARING, HUB .500
4	536732-02	PLATE-BEARING, UNWIND



REV NO	DATE	DESCRIPTION	ECN NO	BY
I	SP76300			
				RECD WHERE USED
				KIRK - RUDY, INC.
				KENNESAW, GEORGIA
				
				KENNESAW, GA 30144 USA
				TITLE:
				ASSY-BEARING PLATE, UNWIND
				SHEET NO. 1 OF 1
				DRAWING # 536400-02

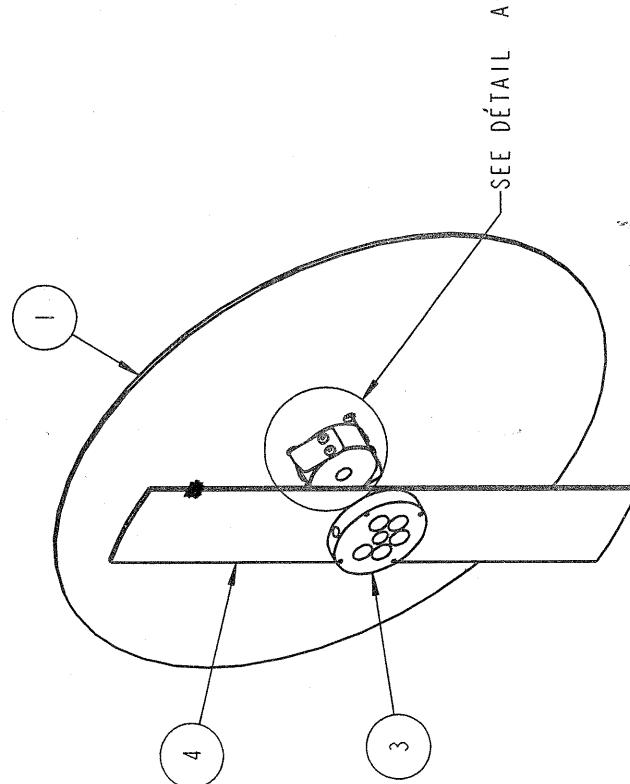
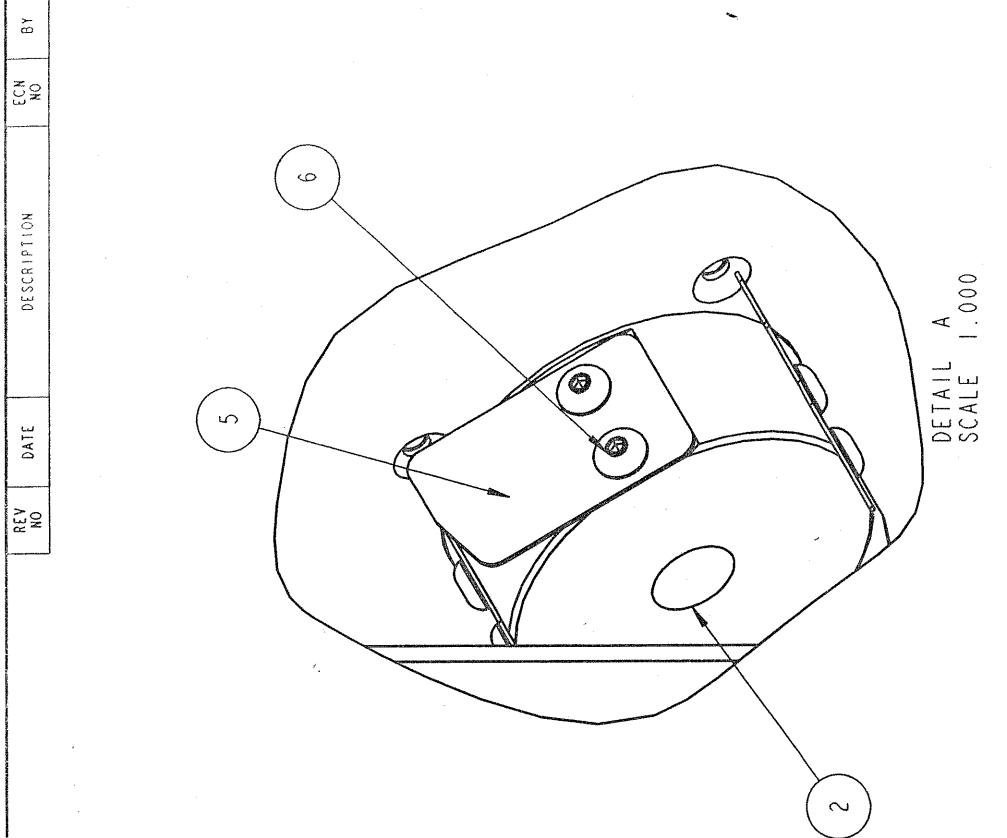
ITEM QTY	PART #	DESCRIPTION
1	1	536814-01 CLAMP-BELT MOUNT
2	1	536815-01 BAR-BRUSH MOUNT
3	1	536818-01 DRAG BELT
4	1	536824-01 BAR-CLAMP, BRUSH



ITEM QTY	PART #	DESCRIPTION	REV NO	DATE	ECN NO	BY
1	SP76300	KIRK - RUDY, INC.				WHERE USED
		KENNEBREW, GEORGIA				
		KR				
		ASSY - WEB DRAG				
		536817-01				

DRAWN BY: TVK	SCALE: 1 . 000	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED		MATERIAL: XXX	THIRD ANGLE PROJECTION	PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE QUOTED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC. KENNEBREW, GA 30144 USA
CHECKED BY:	DATE: 03-Sep-99	.01	.005	HEAT TREAT: XXX	MODEL: SP76300	TITLE:
TRACED BY:	MASTER	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED		FINISH: XXX	SHEET NO: 10F1	DRAWING #
		ALL DIMENSIONS ARE FINAL SHED DIMENSIONS		DO NOT SCALE - WORK TO DIMENSIONS ONLY		

ITEM QTY	PART #	DESCRIPTION
1	1	527651-12 DISK, LABEL UNWIND
2	1	536352-10 HUB, UNWIND REEL
3	1	536353-01 HUB-REEL
4	1	536354-01 PLATE-UNWIND
5	4	548325-01 CLIP, UNWIND REEL
6	8	CSFF51 SCREW, BUTTON HEAD #8-32X.250

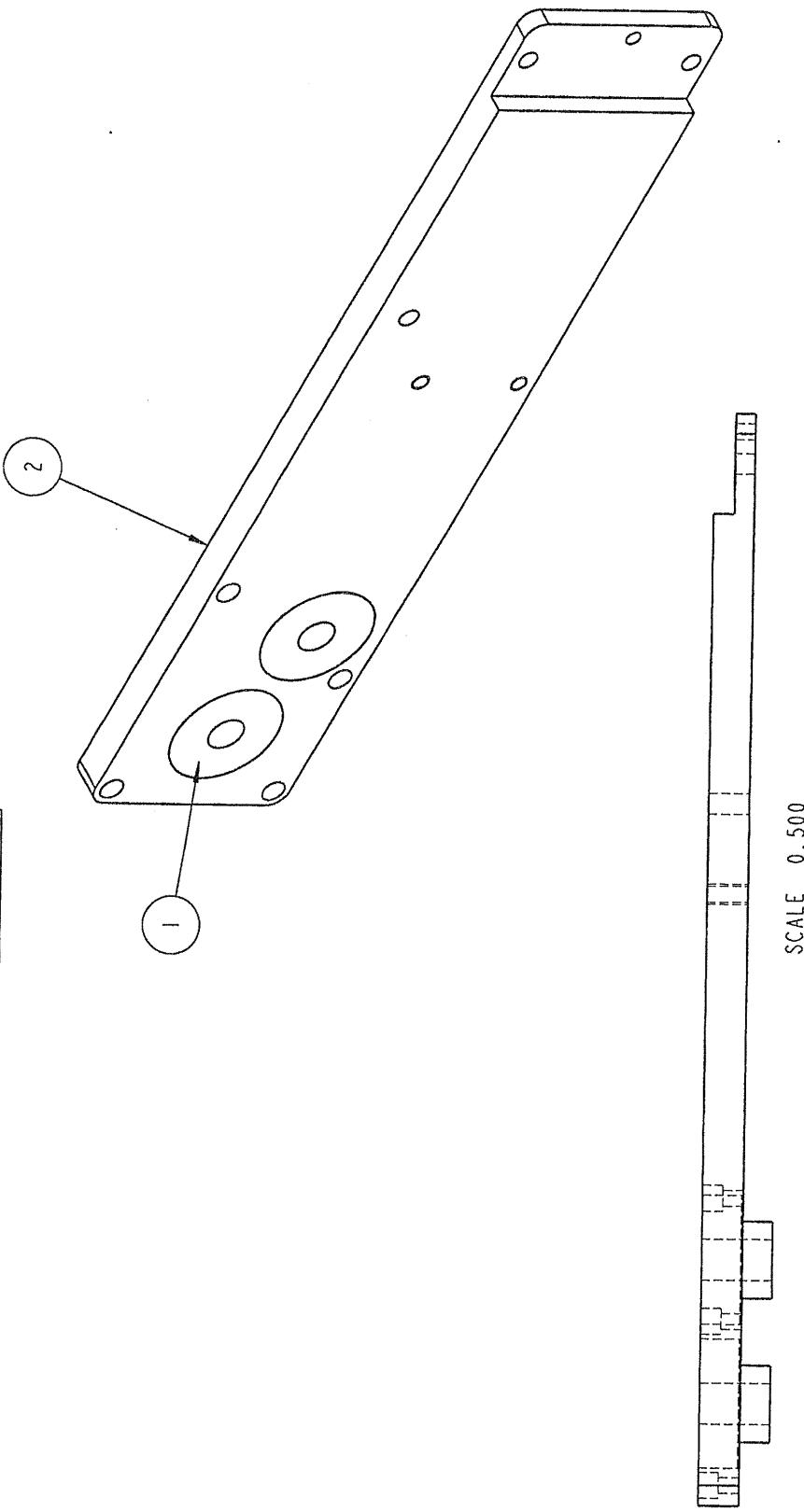


ITEM	REV NO	DATE	DESCRIPTION	ECN NO	BY
1					

I	KR535
REQ'D	WHERE USED

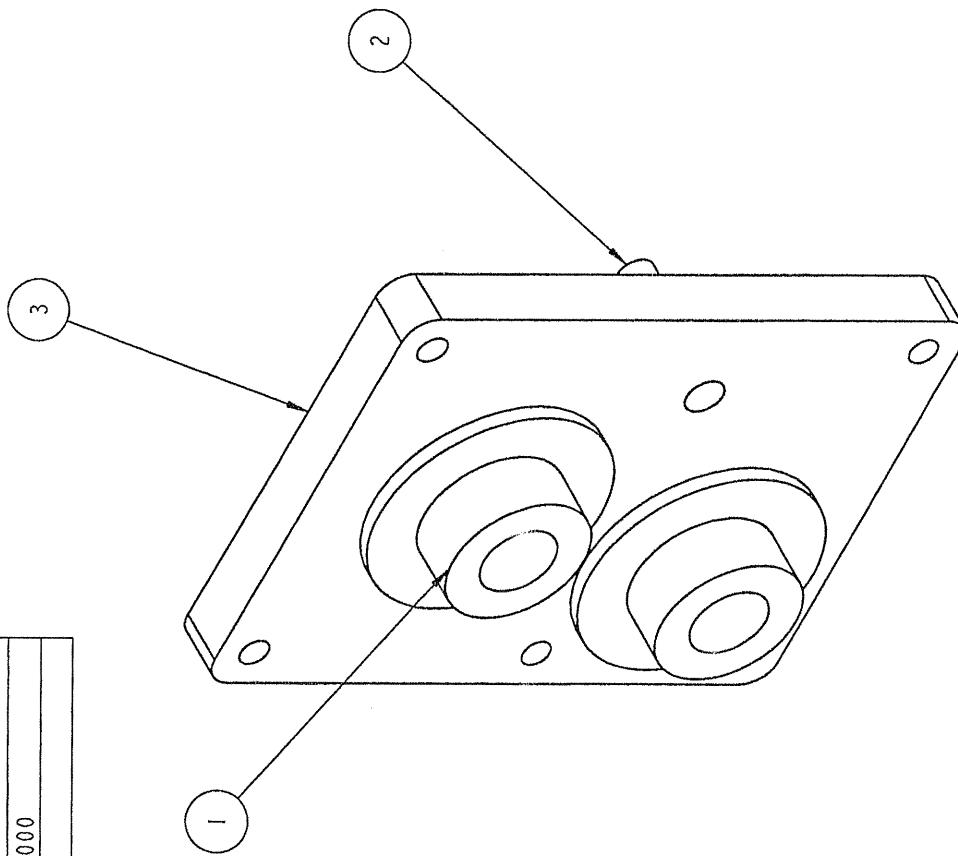
DRAWN BY: T JG		SCALE 0.188	MATERIAL: N/A	THIRD ANGLE PROJECTION		PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE QUOTED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC. KENNESAW, GA 30144 USA	
CHECKED BY:		DATE 05-NOV-04	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED XX .XXX ANS.	.01	.005	.5	HEAT TREAT:
TRACED BY:		MASTER M	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED	N/A	ALL DIMENSIONS ARE FINISHED DIMENSIONS		TITLE: ASSY, UNWIND WHEEL
			FINISH:	N/A	DO NOT SCALE - WORK TO DIMENSIONS ONLY		DRAWING #: 10317
				N/A			536763-01

ITEM	QTY	PART #	DESCRIPTION
1	2	103803	BEARING, HUB .500
2	1	536741-01	PLATE-REEL



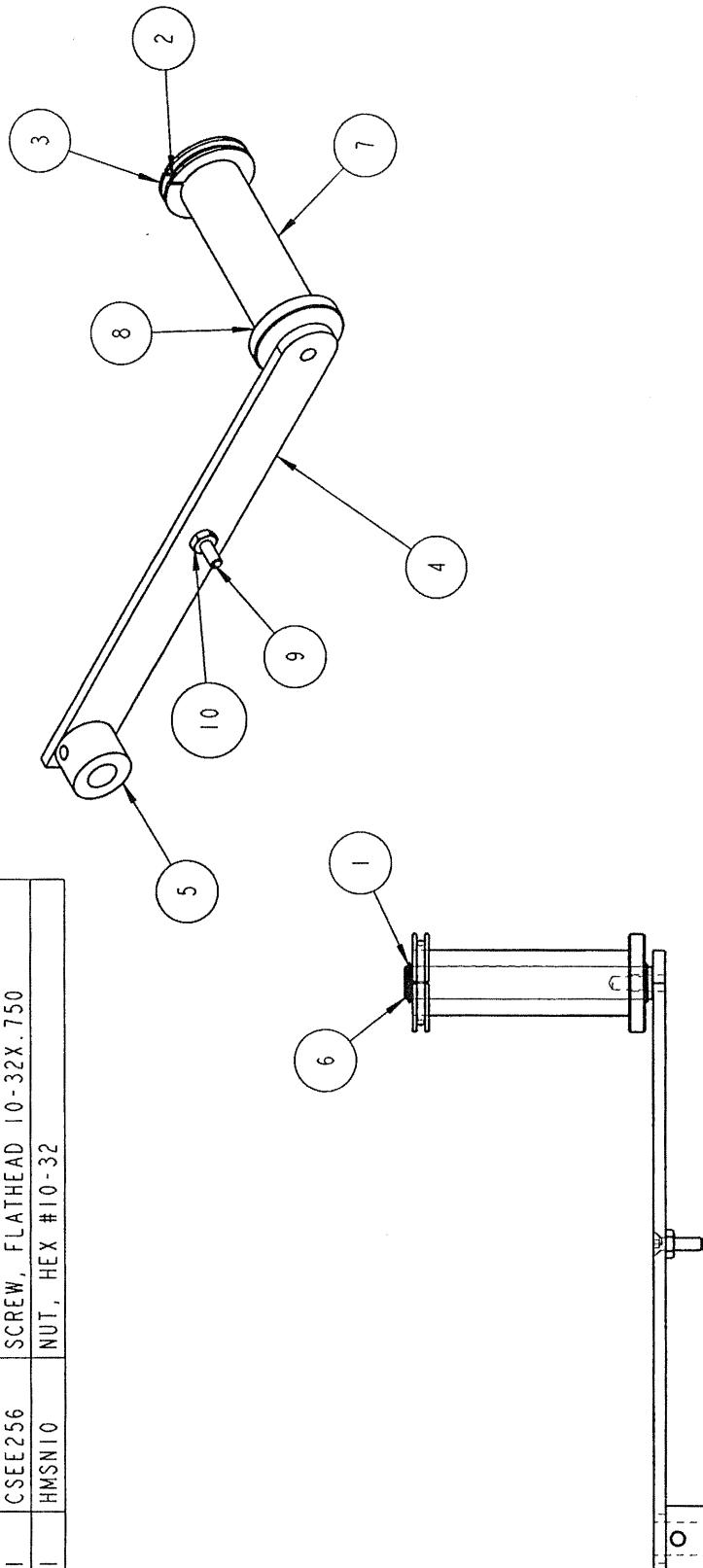
DRAWN BY:	SCALE	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	MATERIAL:	THIRD ANGLE PROJECTION	PROPRIETARY AND CONFIDENTIAL
T JG	0 . 500	.01 .005 .5	XXX		NO PORTION OF THIS DRAWING MAY BE QUOTED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC. KENNESAW, GA 30144 USA
CHECKED BY:	DATE	ANG.	HEAT TREAT:		NOTE: 535
	01 - Nov - 99		XXX		TITLE: ASSY , UNWIND SUPPORT BAR
TRACED BY:	MASTER		FINISH:	Sheet No. 10F1	DRAWING # 537670-01

ITEM	QTY	PART #	DESCRIPTION
1	2	103803	BEARING, HUB .500
2	1	105401	DOWEL, PIN .250X1.000
3	1	5336762-01	PLATE-REEL



DRAWN BY: T JG		SCALE 1 . 000	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED		MATERIAL: XXX	THIRD ANGLE PROJECTION		PROPRIETARY AND CONFIDENTIAL NOT TO BE COPIED OR REPRODUCED EXCEPT WITH THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY INC. KENNESAW, GA 30144 USA	
CHECKED BY:		DATE 01 - NOV - 99	.01 .005	ANG. 5	HEAT TREAT: XXX			MODEL: 535	TITLE: ASSY, UNWIND BRG PLATE
TRACED BY:	MASTER	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED		FINISH: XXX				SHEET NO.: 10F1	DRAWING #: 537671-01

ITEM	TYPE	QTY	PART #	DESCRIPTION
1	PART	2	104106	SNAPRING, .500
2	PART	1	190895	O-RING, 1.125 X 1.312 X .093
3	PART	1	525205	GUIDE, RING
4	PART	1	536807-01	BAR-SWING
5	PART	1	536808-01	HUB-SWING ARM
6	PART	1	536831-01	SHAFT, WEB UNWIND
7	PART	1	536833-01	ROLLER, WEB
8	PART	1	538101-01	DISK, TAB GUIDE
9	PART	1	CSEE256	SCREW, FLATHEAD 10-32X.750
10	PART	1	HMSN10	NUT, HEX #10-32

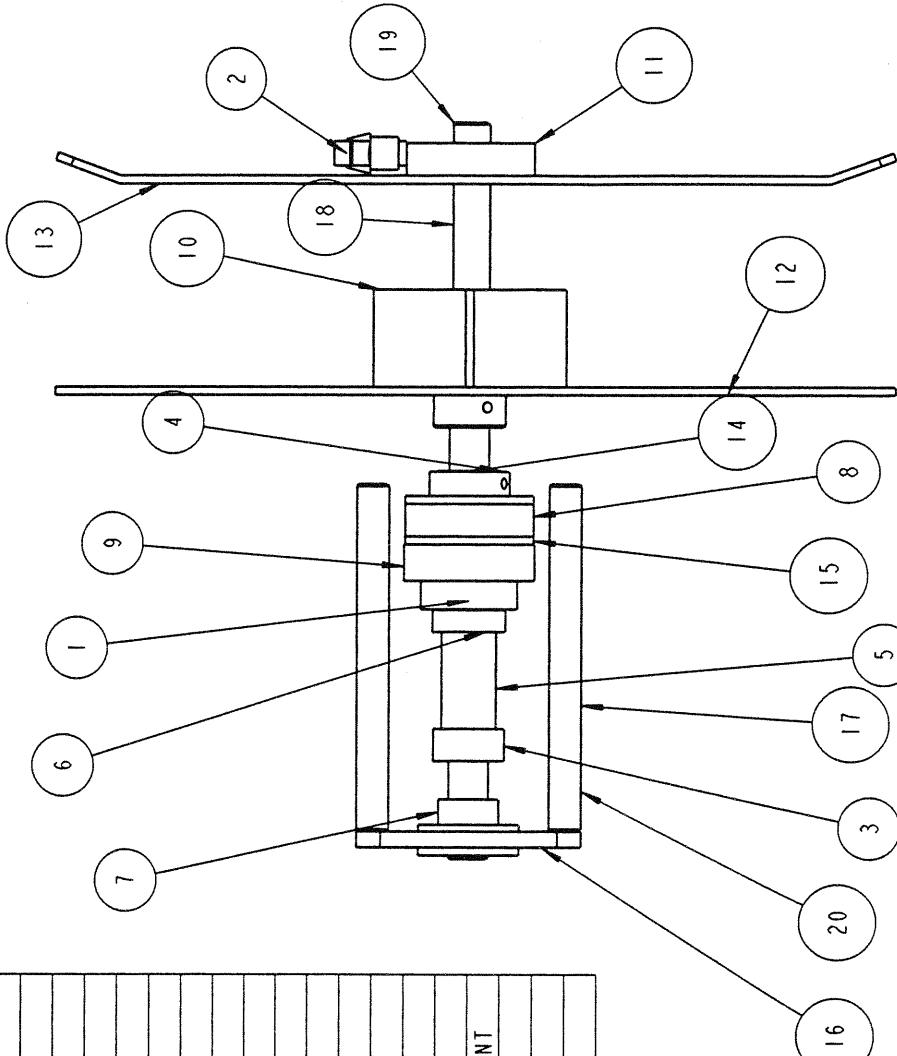


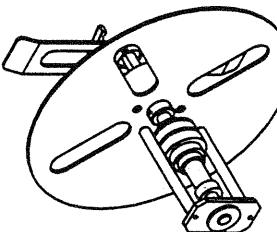
REV NO	DATE	DESCRIPTION	ECN NO	BY
1	1/12/2001	REPLACED EXT. SPRING WITH O-RING	6713	TJG

I	KRS33HD
REQ'D	WHERE USED

DRAWN BY:	SCALE:	0 . 375	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	MATERIAL: XXX	THIRD ANGLE PROJECTION	PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE COPIED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY INC. KENNESAW, GA 30144 USA
CHECKED BY:	DATE:	.xx .xxx .01 .005 .5	HEAT TREAT:	XXX		
TRACED BY:	MASTER:	01 - Nov - 99	REMOVE ALL BURRS AND SHARP EDGES, UNLESS OTHERWISE NOTED	XXX	MODEL: 5335	TITLE: ASSY, SWING ARM BRAKE
			ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE. WORK TO DIMENSIONS ONLY	XXX	SHEET NO. 10F1	DRAWING #
						537674-01

ITEM QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	100145	BUSHING, SL. 625ID.8130D1.000LG					
2	102140	HANDLE, RELEASE 1/4-20 X .75					
3	102203	COLLAR .625					
4	102564	SHIM, .625X1.000X.010					
5	102722	SPRING, COMPRESSION					
6	103211	BEARING, BALL THRUST .625					
7	103804	BEARING, HUB .625					
8	190720	DISC, F3 FELT					
9	108772-1	PULLEY. 32XL037					
10	527610-2	ROLLER, TAKE UP					
11	527625-3	HUB, ROLL					
12	527651-4	RING, RETAINING					
13	527651-5	RING, RETAINING					
14	527695-1	HUB, TAKEUP					
15	527697-1	DISC, TAKEUP					
16	536795-01	PLATE-BEARING					
17	536802-01	BAR-ROUND, BEARING PLATE MOUNT					
18	536803-01	SHAFT, TAKE-UP					
19	536959-01	ASSY- SLIP CLUTCH					
20	537673-01	ASSY, REWIND BRG SUPPORT					

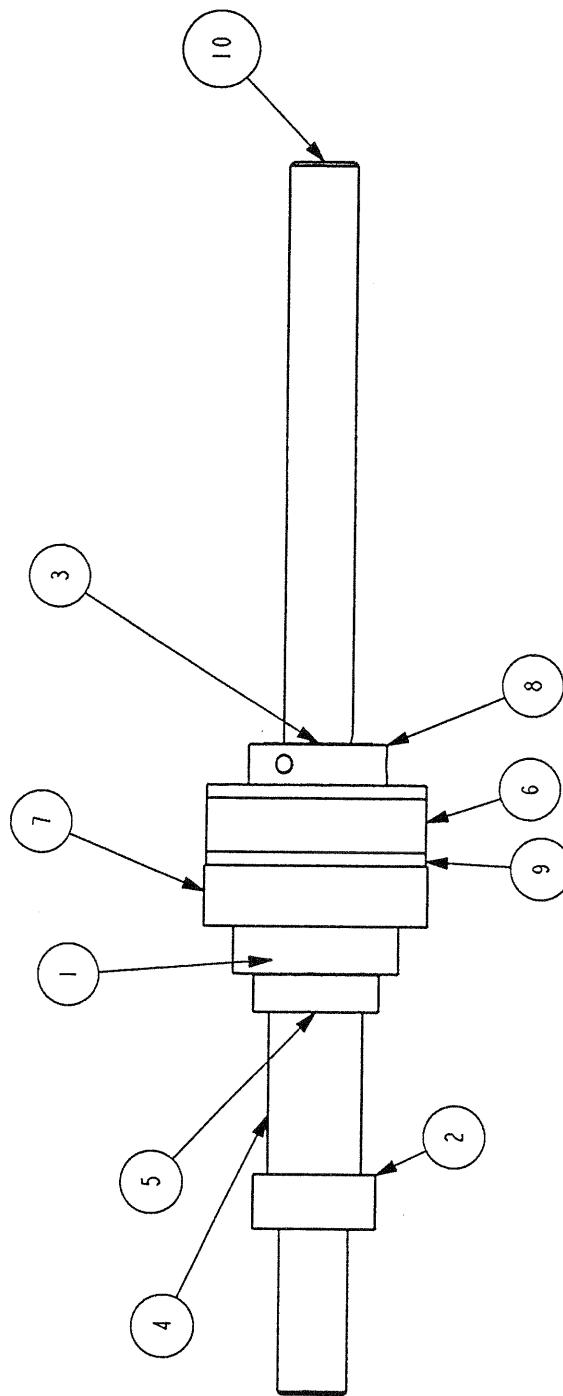




DRAWN BY: T JG	SCALE: 0 .125	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED		MATERIAL: N / A	THIRD ANGLE PROJECTION	PROPRIETARY AND CONFIDENTIAL NO PART OF THIS DRAWING MAY BE COPIED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY INC. KENNESAW, GA 30044 USA	
CHECKED BY:	DATE: 22-0c+-.99	.01	.005	HEAT TREAT: N / A	MODEL: 535	RECD:	KIRK - RUDY, INC. KENNESAW, GEORGIA
TRACED BY:	MASTER: M	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED		FINISH: N / A	SHEET NO: 10F 1	DRAWING #: 536749-02	

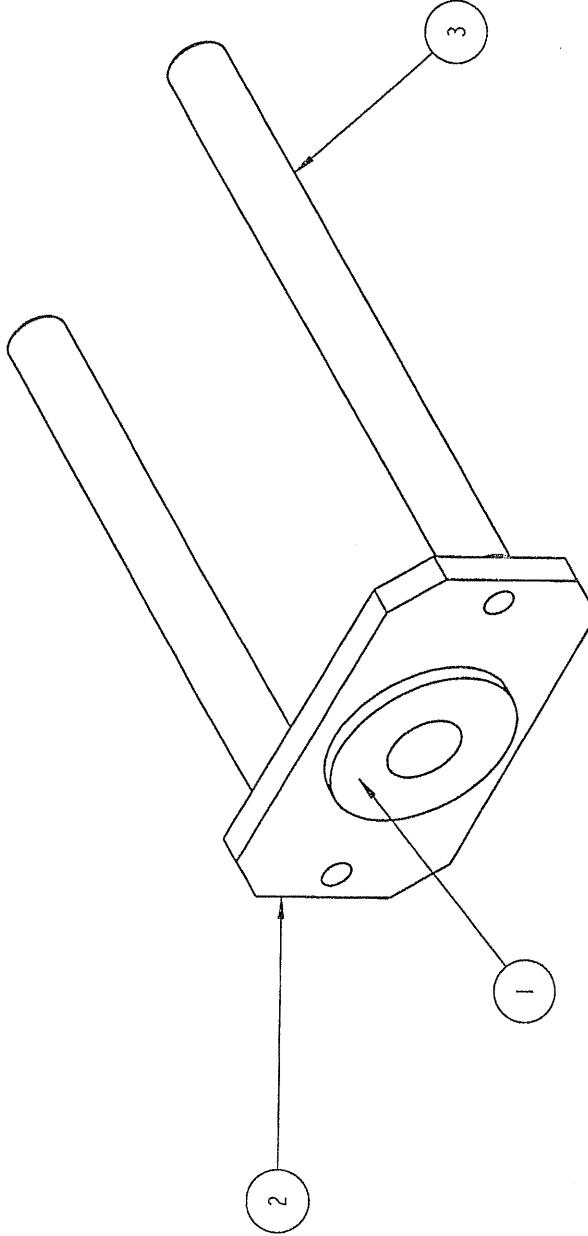
ITEM QTY	PART #	DESCRIPTION
1	100145	BUSHING, SL. 6251D.8130D1 .0001G
2	102203	COLLAR .625
3	2 102564	SHIM, .625X1 .000X .010
4	1 102722	SPRING, COMPRESSION
5	1 103211	BEARING, BALL THRUST .625
6	1 190720	DISC, F3 FELT
7	1 108772-1	PULLEY, 32XL037
8	1 527695-1	HUB, TAKEUP
9	1 527697-1	DISC, TAKEUP
10	1 536803-01	SHAFT, TAKE-UP

SCALE 0.375



REV NO	DATE	DESCRIPTION	ECN NO	BY
1 SP76300				REF'D WHERE USED
KRK KIRK - RUDY, INC. KENNESAW, GEORGIA				
ASSY - SLIP CLUTCH				536959-01
DRAWN BY: TVK SCALE 0 .625				THIRD ANGLE PROJECTION
DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED				MATERIAL: N/A
.01 .005 .5				HEAT TREAT: N/A
DATE 24-Sep-99				MODEL: 535
CHECKED BY:				TITLE:
TRACED BY:				SHEET NO: 1 OF 1
MASTER M				DRAWING I
ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY				

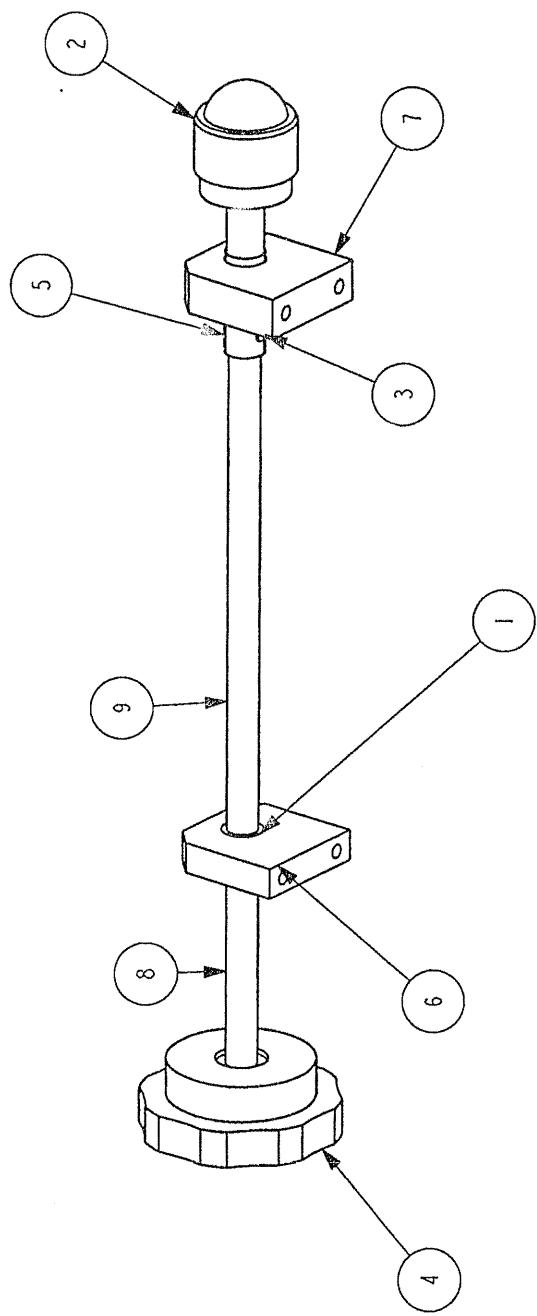
ITEM	QTY	PART #	DESCRIPTION
1	1	103804	BEARING, HUB .625
2	1	536795-01	PLATE-BEARING
3	2	536802-01	BAR-ROUND, BEARING PLATE MOUNT



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
CHECKED BY:	DATE	.XX .XXX ANG.	XXX		
TRACED BY:	MASTER	.01 .005 .5	REAR TREAT: XXX		MODEL: 5335 DATE: 01-NOV-99
			REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED		FINISH: XXX
			ALL DIMENSIONS ARE IN INCHES. DO NOT SCALE - WORK TO DIMENSIONS ONLY		SHEET 1 OF 1 DRAWING #

537673-01

ITEM	QTY	PART #	DESCRIPTION
1	1	100101	BUSHING, SL. 3751D. 50000D. 3751G
2	1	103955	BALL TRANSFER
3	1	105202	PIN, ROLL .125X.500
4	1	500772	KNOB
5	1	536759-02	SCREW-ADJUSTMENT
6	1	536796-01	PLATE-BUSHING
7	1	536796-02	PLATE-THREADED ADJUSTMENT
8	1	536822-01	SHAFT-VERT. ADJ
9	1	537675-01	ASSY, THREADED ROD SHAFT



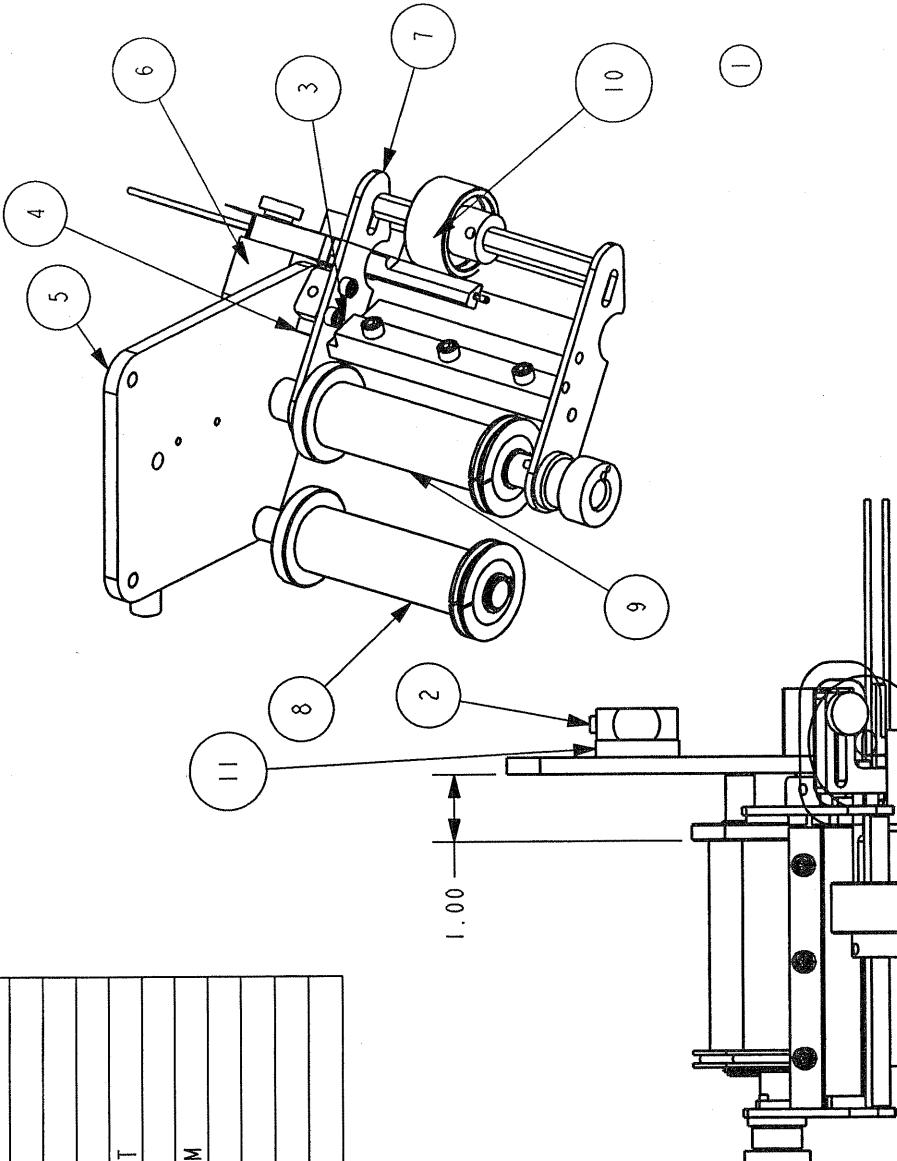
DRAWN BY:	SCALE:	DATE:	MASTER:	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	MATERIAL:	HEAT TREAT:	FINISH:	THIRD ANGLE PROJECTION	PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE QUOTED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC., KENNESAW, GA. 30144, USA	RECD' D:	WHERE USED
TVK	0 . 500	25 - 0C + - 99	M	.01 .005 .5	N / A	N / A	N / A	-	KIRK - RUDY, INC. KENNE SAW, GEORGIA	1.000	KRS35HD
CHECKED BY:											
TRACED BY:											

ASSY - VERTICAL ADJUSTMENT

DRAWING # 536767-01

SHEET NO. 1 OF 1

ITEM QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	1 190837	WEAR TAPE.					
2	1 202261-11	SENSOR, FIBER OPTIC					
3	1 527616-7	PLATE-PEEL PLATE					
4	1 527665-2	BLOCK, STRIPPER					
5	1 532967-03	PLATE-PEEL PLATE MOUNT					
6	1 536581-02	ASSY, SENSOR SLIDE					
7	1 536806-01	ASSY, PINCH ROLLER ARM					
8	1 536832-01	ASSY, GUIDE ROLLER					
9	1 536832-03	ASSY, GUIDE ROLLER					
10	1 537672-01	ASSY, PINCH ROLLER					
11	1 538190-01	BLOCK, SENSOR SPACER					

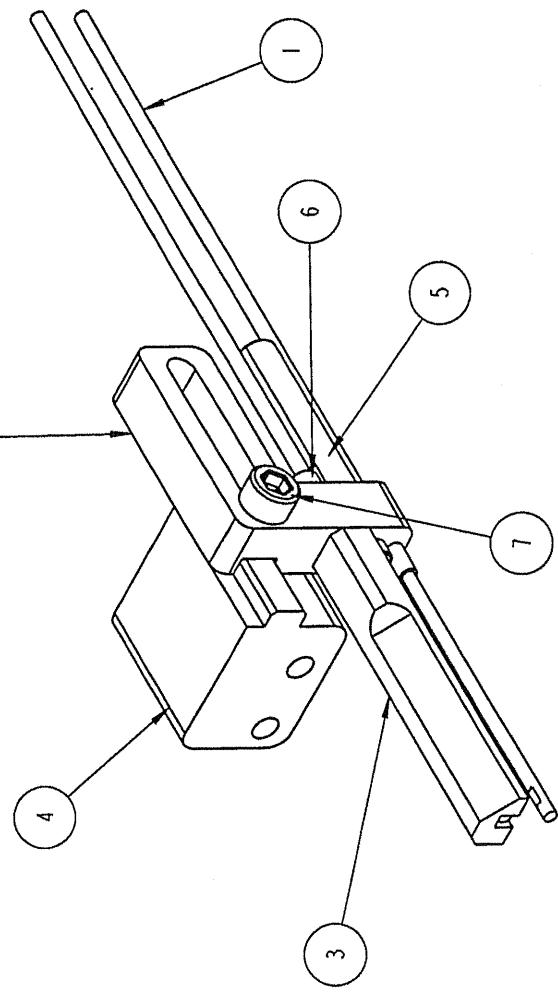


NOTES:
1. SENSOR NOT INCLUDED IN ASSEMBLY. FOR REFERENCE ONLY.

1-000	KR535HD
REC'D	WHERE USED

DRAWN BY:	SCALE	DATE	THIRD ANGLE PROJECTION	PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE QUOTED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC. WOODSTOCK, GA 30188 USA
T JG	0.375	12-Nov-03	MATERIAL: DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED .005 .005 .005 .01 .005 .005 ANG. ANG. ANG.	N/A N/A N/A
CHECKED BY:			HEAT TREAT: FINISH:	535
TRACED BY:	MASTER			SHEET NO.: 0F2 TITLE: ASSY - STRIPPER PLATE DRAWING #: 536769-02

ITEM QTY	PART #	DESCRIPTION
1	2	202261-12 FIBER, PLASTIC PIPSM26U
2	1	538157-01 BLOCK, FIBER OPTIC MOUNT
3	1	538158-01 GUARD, FIBER OPTIC
4	1	538159-01 BLOCK, SENSOR SLIDE
5	1	538163-01 SHAFT, FIBER OPTIC SUPPORT
6	3	CSDD153
7	1	CSDD266



REV NO	DATE	DESCRIPTION	ECN NO	BY

1	536769-02
REQ'D	WHERE USED

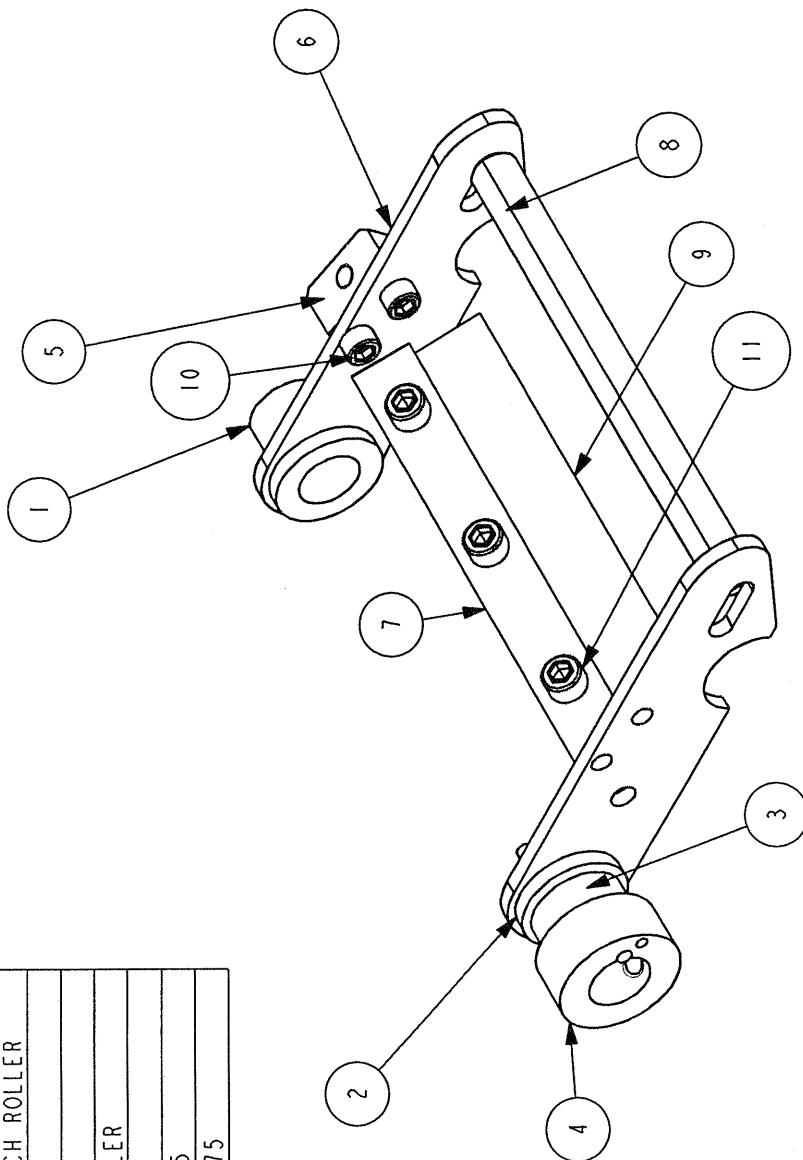
KR

KIRK - RUDY, INC.
KENNEBUNK, GEORGIA

DRAWN BY:	SCALE	DATE	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 EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC.
T JG	1 . 000	29-Dec-99	.01 .005 .5	XXX	-	TITLE:
CHECKED BY:				HEAT TREAT:	XXX	MODEL: 535
TRACED BY:	MASTER			FINISH:	XXX	SHEET NO. 10F DRAWMG 1

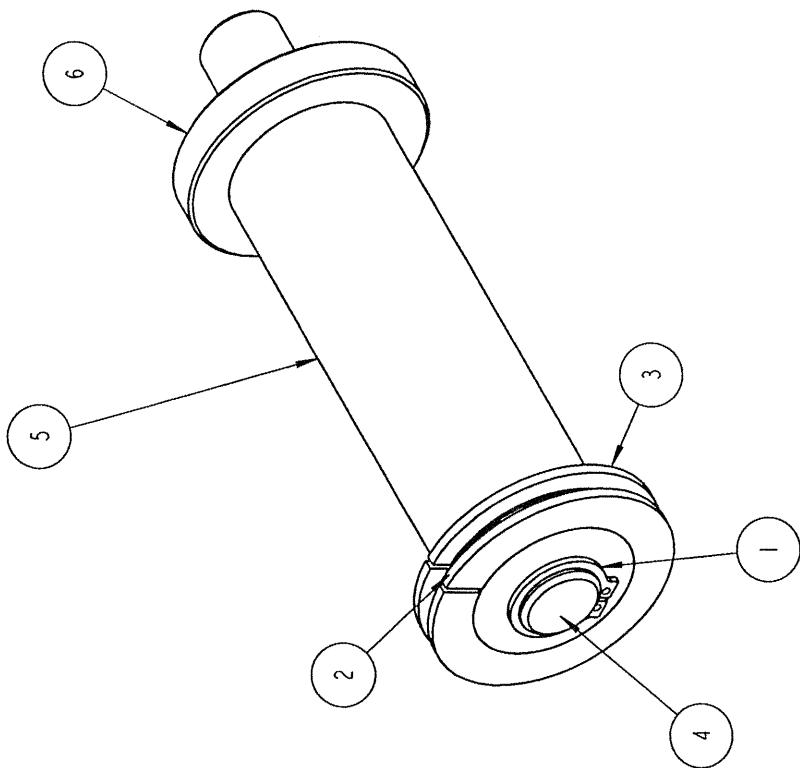
536581-02

ITEM QTY	PART #	DESCRIPTION
1	100304	BUSHING, FL. 500ID. 625OD. 750LG
2	100323	BUSHING, FL. 500ID. 625OD. 375LG
3	102785	SPRING, TORSION
4	102205-2	COLLAR
5	536770-01	BLOCK-ADJUSTMENT, PINCH ROLLER
6	536772-01	PLATE, BUSHING
7	536773-04	BAR, BRUSH MOUNT
8	536774-01	BAR-ROUND, PINCH ROLLER
9	543367-01	BRUSH, HOLD DOWN
10	2 CSDD237	SCREW, SHCS 8-32X.375
11	3 CSDD264	SCREW, SHCS 10-32X.375



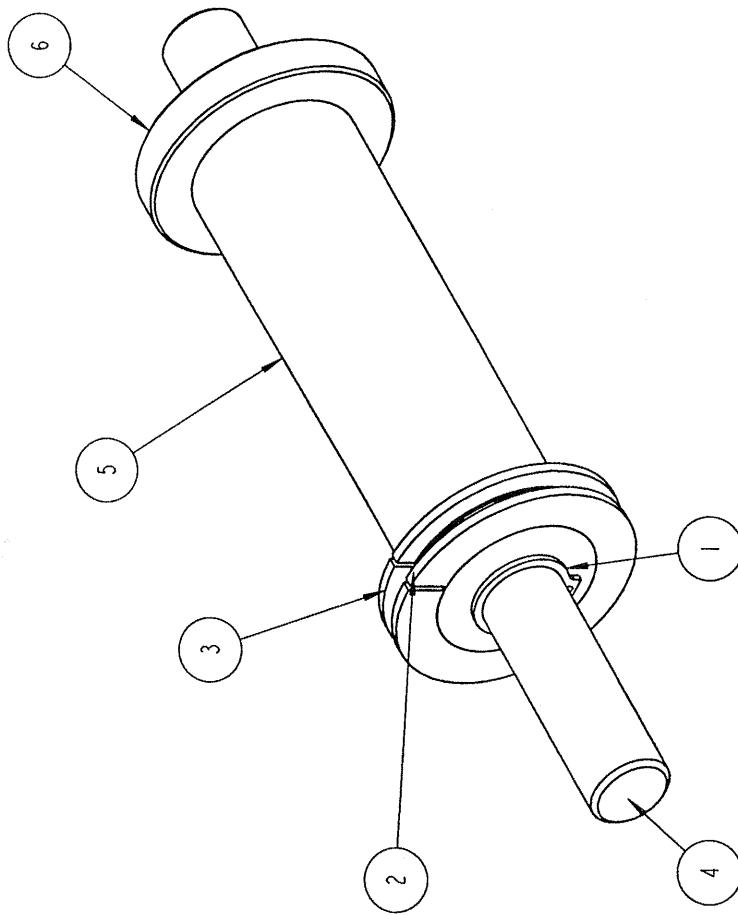
ITEM	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	1	8/1/2002	ADDED 543367-01 AND 536773-04 DELETED 536773-01	6865	TJG
KIRK - RUDY, INC.					
KENNEBUNK, GEORGIA					
1	SP16300			REF'D	WHERE USED
PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE COPIED OR REPRODUCED IN WHOLE OR IN PART WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, KENNEBUNK, ME 04044 USA					
DRAWN BY: TVK		SCALE 0 .750	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	MATERIAL: XXX	THIRD ANGLE PROJECTION
CHECKED BY:		DATE 10-Sep-99	.XX -.XX ANG.	XXXX	PRINTED
TRACED BY:		MASTER M	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED	XXXX	MODEL: SP76300
			ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY	FINISH: XXX	SHEET NO.: 10F1
					DRAWING #
536806-01					

ITEM	QTY	PART #	DESCRIPTION
1	2	104106	SNAPRING, .500
2	1	190895	O-RING, 1.125 X 1.312 X .093
3	1	525205	GUIDE, RING
4	1	536777-01	SHAFT WEB
5	1	536833-01	ROLLER, WEB
6	1	538101-01	DISK, TAB GUIDE



DRAWN BY:	SCALE	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	MATERIAL:	REF'D	WHERE USED
T JG	.000	.XX .XXX ANG.	N / A	I	KRS5SHD
CHECKED BY:	DATE	.01 .005 .5	HEAT TREAT:		
25 - OC 1 - 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	N / A	SHEET NO. 1 OF 1	DRAWING #
	M				ASSY, GUIDE ROLLER
					536832-01

ITEM QTY	PART #	DESCRIPTION
1	104106	SNAPRING .500
2	190895	O-RING .1.125 X 1.312 X .093
3	525205	GUIDE, RING
4	536777-03	SHAFT WEB
5	536833-01	ROLLER, WEB
6	538101-01	DISK, TAB GUIDE



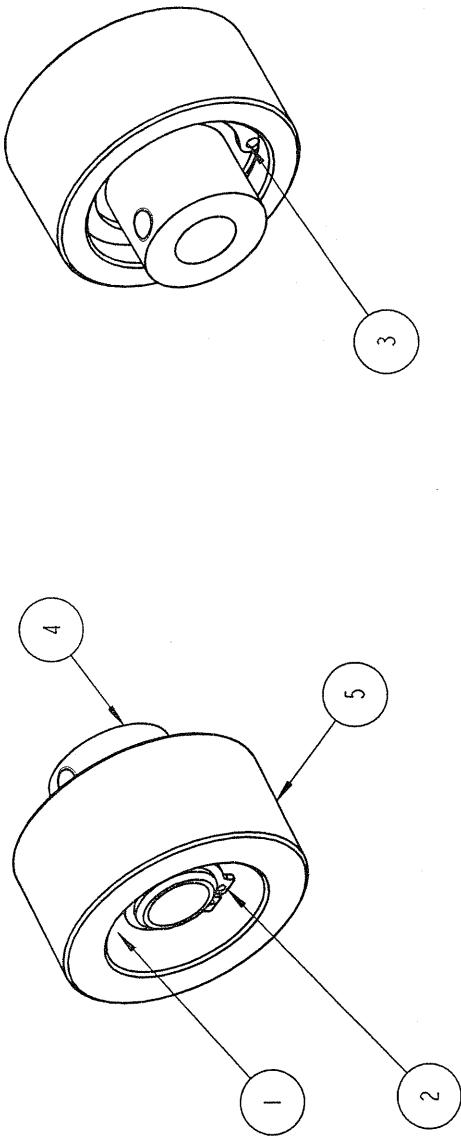
REV NO	DATE	DESCRIPTION	ECN NO	BY
1	1/12/2001	REPLACED EXT. SPRING WITH O-RING	6713	TJG

1	KR535HD
REQ'D	WHERE USED

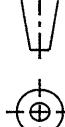
DRAWN BY:	SCALE	MASTER	THIRD ANGLE PROJECTION	PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE COPIED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY INC. KENNESAW, GA 30144 USA
TJG	1 . 000	N / A	⊕ - - ⊕	KIRK - RUDY, INC. KENNESAW, GEORGIA
CHECKED BY:	DATE	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	MODEL:	SP76300 TITLE:
	25-0Cf-99	.xx .xxx ANG. .01 .005 .5 HEAT TREAT:	N / A	ASSY, GUIDE ROLLER
TRACED BY:	MASTER	FINISH:	SHEET NO.:	DRAWING #:
	M	N / A	1 OF 1	536832-03

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

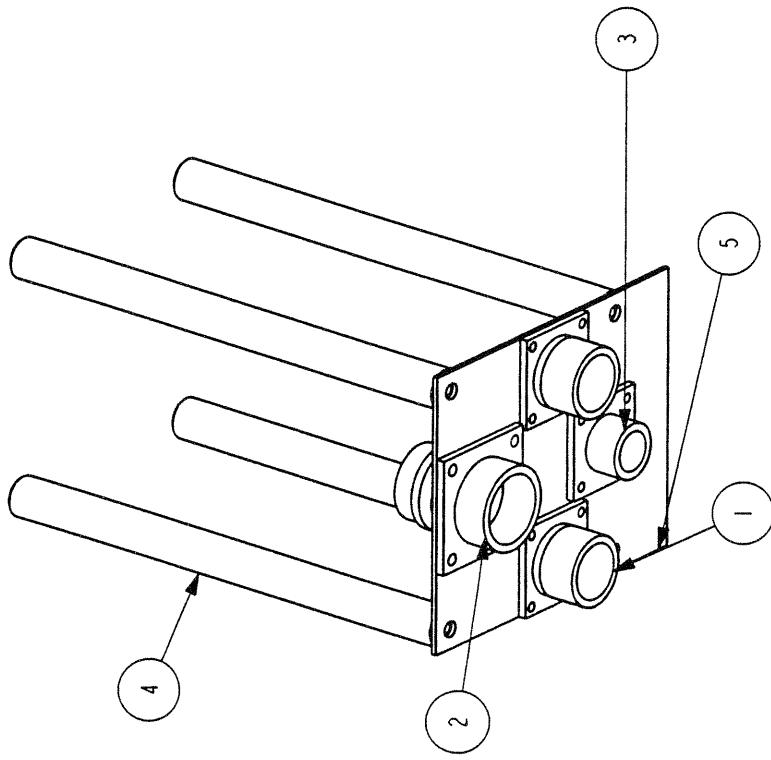
ITEM QTY	PART #	DESCRIPTION
1	103108	BEARING, FLAT .500
2	104106	SNAPRING .500
3	104205	SNAPRING, INTERNAL 1.125 BORE
4	1	536771-01 STUD-ROLLER
5	1	536775-01 ROLLER, ARM



ITEM	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	103108	BEARING, FLAT .500	1	10/30/2001	ADDED INTERNAL SNAPRING	6756	TJG

X	XXX			
REF'D	WHERE USED			
 KIRK - RUDY, INC. KENNEBUNK, GEORGIA				
				
PROPRIETARY AND CONFIDENTIAL NO PART OF THIS DRAWING MAY BE QUOTED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY INC. KENNEBUNK, GA 30144 USA				
DRAWN BY:	SCALE	MATERIAL	THIRD ANGLE PROJECTION	PROPRIETARY AND CONFIDENTIAL
TJG	1.000	XXX	-	NO PART OF THIS DRAWING MAY BE QUOTED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY INC. KENNEBUNK, GA 30144 USA
CHECKED BY:	DATE	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	-	NO PART OF THIS DRAWING MAY BE QUOTED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY INC. KENNEBUNK, GA 30144 USA
TRACED BY:	MASTER	.xx .005 .005 .005	HEAT TREAT:	NO PART OF THIS DRAWING MAY BE QUOTED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY INC. KENNEBUNK, GA 30144 USA
		REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED	MODEL:	535
		ALL DIMENSIONS ARE FINISHED DIMENSIONS	TITLE:	ASSY, PINCH ROLLER
		DO NOT SCALE - WORK TO DIMENSIONS ONLY	SHEET NO.	10F1
			DRAWING #	537672-01

ITEM QTY	PART #	DESCRIPTION
1	2	200499 RECEPTACLE, AMPHENOL 4 PIN
2	1	200500 RECEPTACLE, AMPHENOL 16 PIN
3	1	200501 RECEPTACLE, AMPHENOL 4 PIN
4	4	536783-01 BAR-ROUND, ELECTRICAL PLATE
5	1	536785-01 PLATE-ELECTRICAL CONNECTION

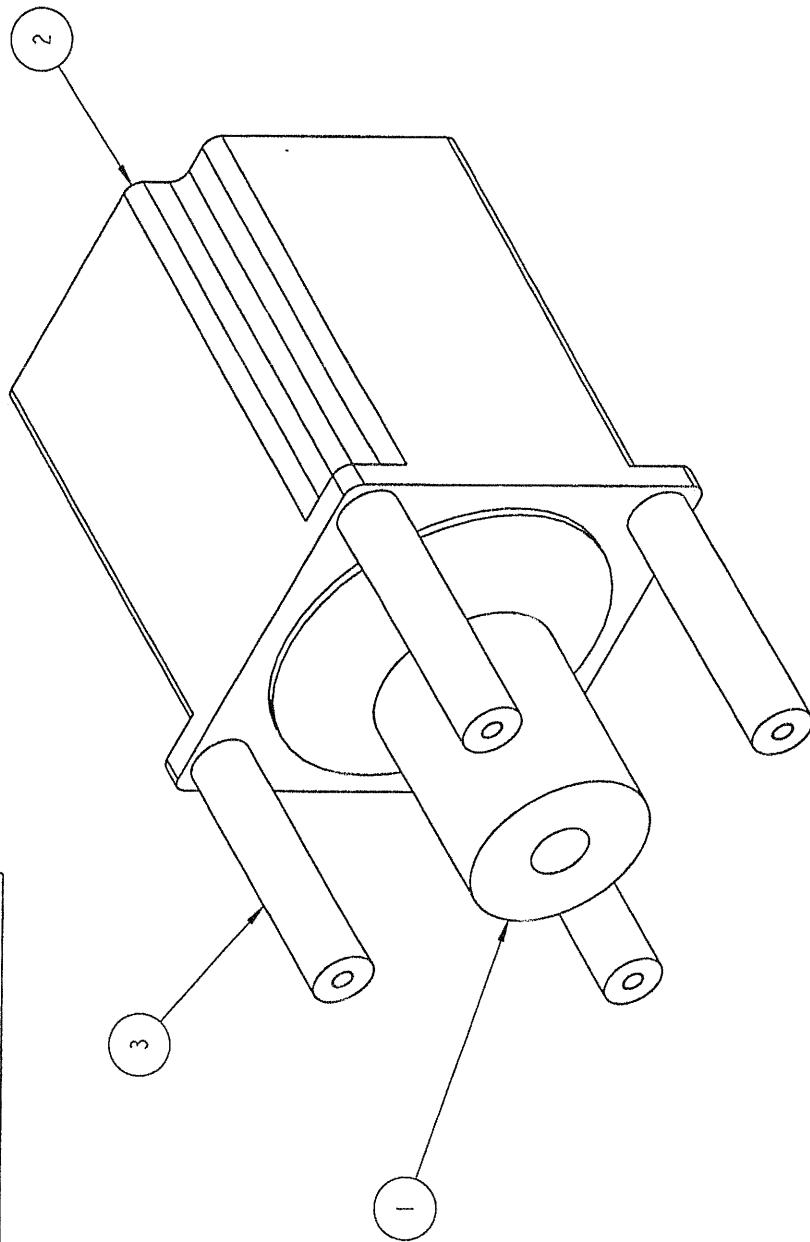


REV NO	DATE	DESCRIPTION	ECN NO	BY

I	KRS35HD
REC'D	WHERE USED

DRWNG BY:	TVK	SCALE	0 . 500	MATERIAL:	X X X	THIRD ANGLE PROJECTION	PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE QUOTED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC. KENNESAW, GEORGIA 30044 USA
CHECKED BY:		DATE	10 - Sep - 99	MEAT TREAT:	X X X	WORKS:	SP76300 ASSY-ELECTRICAL CONNECTION PLATE
TRACED BY:		MASTER	M	FINISH:	X X X	SHEET NO:	1 OF 1
						DRAWING #:	536784-01

ITEM	QTY	PART #	DESCRIPTION
1	1	101222	COUPLING, SHAFT SC035
2	1	200159-4	MOTOR, STEPPER KML092-F07
3	4	536950-01	SHAFT, MOTOR MOUNT



REV NO	DATE	DESCRIPTION	ECN NO	BY

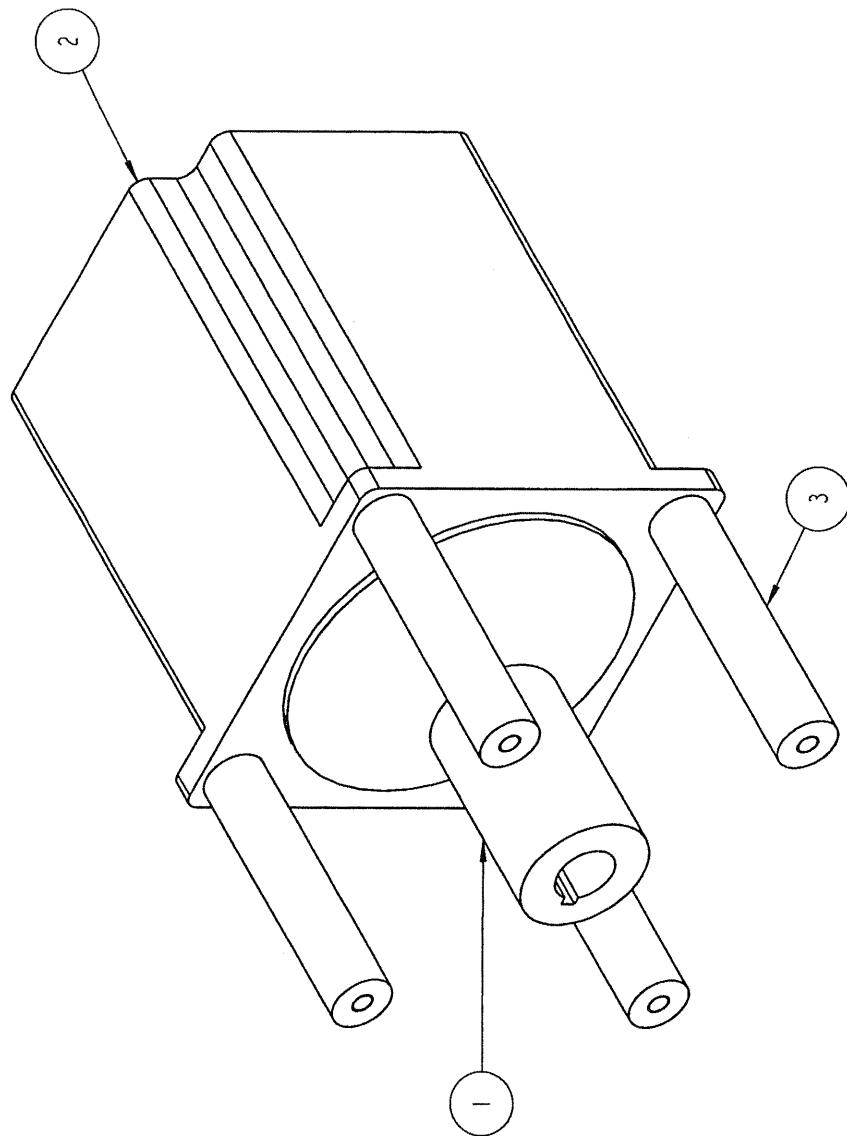
REV'D	KRS35HD	WHERE USED
2		

DRAWN BY: T JG	SCALE 0 . 750	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	
		.xx	.xx	.005			HEAT TREAT:	XXX
CHECKED BY:	DATE 25-0c + -99	.01	.005	.5			MODEL: SP76300	NAME: ASSY, MOTOR TAB DRIVE
TRACED BY:	MASTER	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED			FINISH: XXX		SHEET NO.: 10F1	DRAWING #: 536805-01
		ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY						

ITEM	QTY	PART #	DESCRIPTION
1	1	101223	COUPLING, SHAFT .500B .125K
2	1	200159-4	MOTOR, STEPPER KML092-F07
3	4	536950-01	SHAFT, MOTOR MOUNT

ITEM	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	1	1/12/2001	ELIMINATED PART 536905-02	6714	TJG

2	KR535HD
REQ'D	WHERE USED



DRAWN BY: T JG SCALE 0 .750

DIMENSIONAL TOLERANCES

UNLESS OTHERWISE NOTED

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ANG.

.01

.005

.5

HEAT TREAT:

XXX

FIRSD:

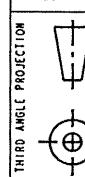
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FINISH:

XXX

DO NOT SCALE - WORK TO DIMENSIONS ONLY

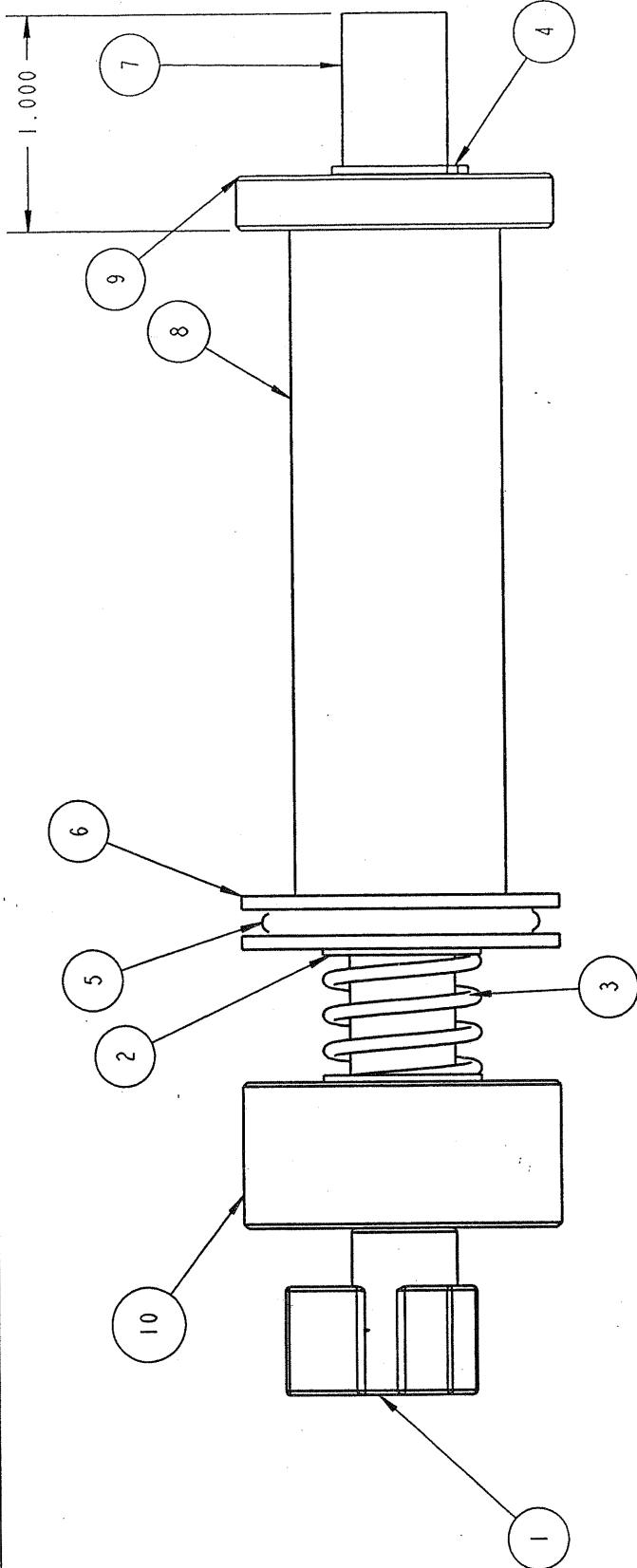
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OF KIRK-RUDY INC.
KENNESAW, GA 30144 USA



KIRK-RUDY, INC.
KENNESAW, GEORGIA

DRAWN BY:	T JG	SCALE	0 .750	MATERIAL:	XXX	THIRD ANGLE PROJECTION	KIRK-RUDY, INC.
CHECKED BY:		DATE	17-Dec-99	.xx	.xxx	ANG.	
TRACED BY:		MASTER	M	.01	.005	.5	MODEL: 535
				REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED	XXX		TITLE: ASSY, MOTOR UNWIND
				ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY	XXX		SHEET NO. 10F1
					XXX		DRAWING 1

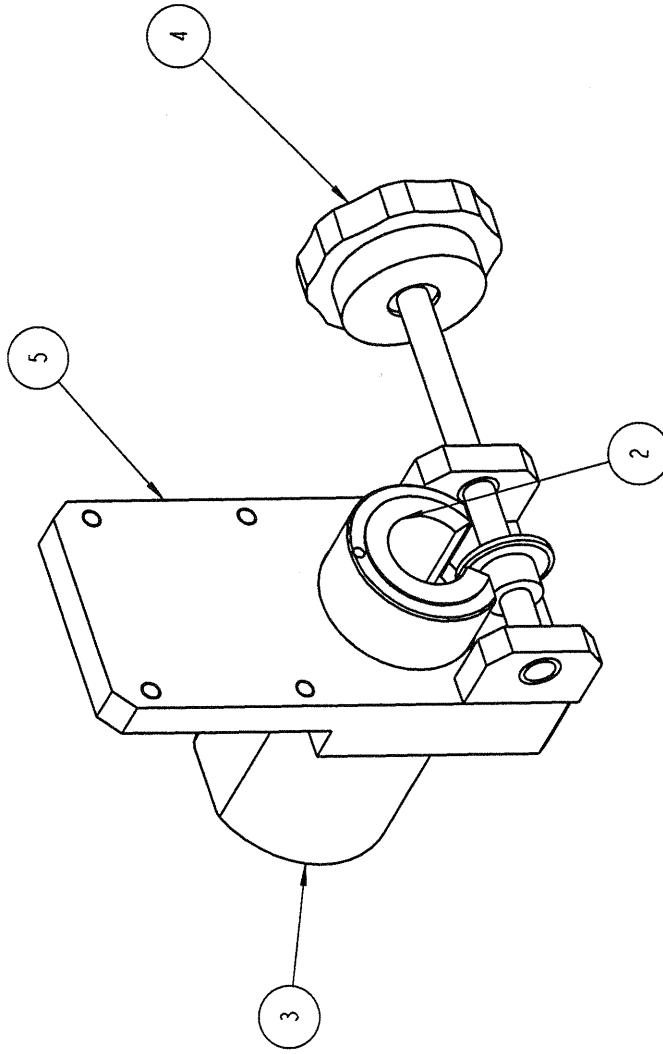
ITEM	QTY	PART #	DESCRIPTION
1	1	102117	KNOB
2	2	102303	SPACER, .500X.750X.312
3	1	102707	SPRING, COIL
4	1	104106	SNAPRING, .500
5	1	190895	O-RING, 1.125 X 1.312 X .093
6	1	525205	GUIDE, RING
7	1	536777-08	SHAFT, WEB BRAKE
8	1	536833-01	ROLLER, WEB
9	1	538101-01	DISK, TAB GUIDE
10	1	542329-01	COLLAR, THREADED BRAKE



DRAWN BY:	T J G	SCALE:	.250	MATERIAL:	N / A	THIRD ANGLE PROJECTION	PROPRIETARY AND CONFIDENTIAL
CHECKED BY:		DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	.01	.005	.005	-	NO PORTION OF THIS DRAWING MAY BE QUOTED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY INC. KENNESAW, GA 3044 USA
TRACED BY:		DATE:	5 - JU 1 - 03	HEAT TREAT:	N / A	-	KIRK - RUDY INC KENNESAW, GEORGIA
				FINISH:	N / A		
				SHEET NO.:	1 OF 1	TITLE:	ASSY, GUIDE ROLLER DRAG
						DRAWING NO.:	536832-19

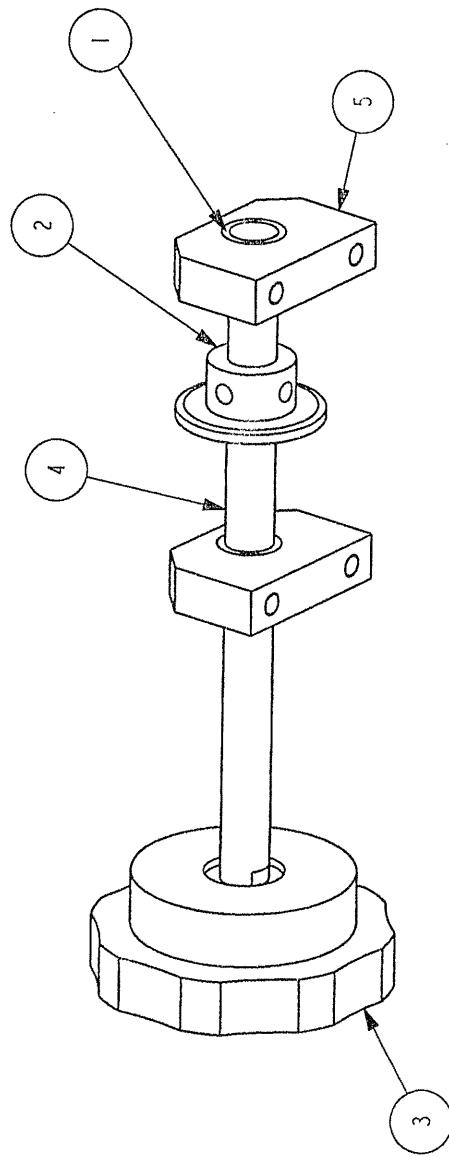
ITEM QTY	PART #	DESCRIPTION
1	102140	HANDLE, RELEASE 1/4-20 X .75
2	102906	BEARING, LINEAR SLEEVE OPEN
3	536351-03	HUB-LINEAR BEARING MOUNT
4	536766-02	ASSY-CROSS ADJUSTMENT
5	536819-02	BAR, BRG. HOUSING MOUNT

REV NO	DATE	DESCRIPTION	ECN NO	BY
1	KRS35HD			



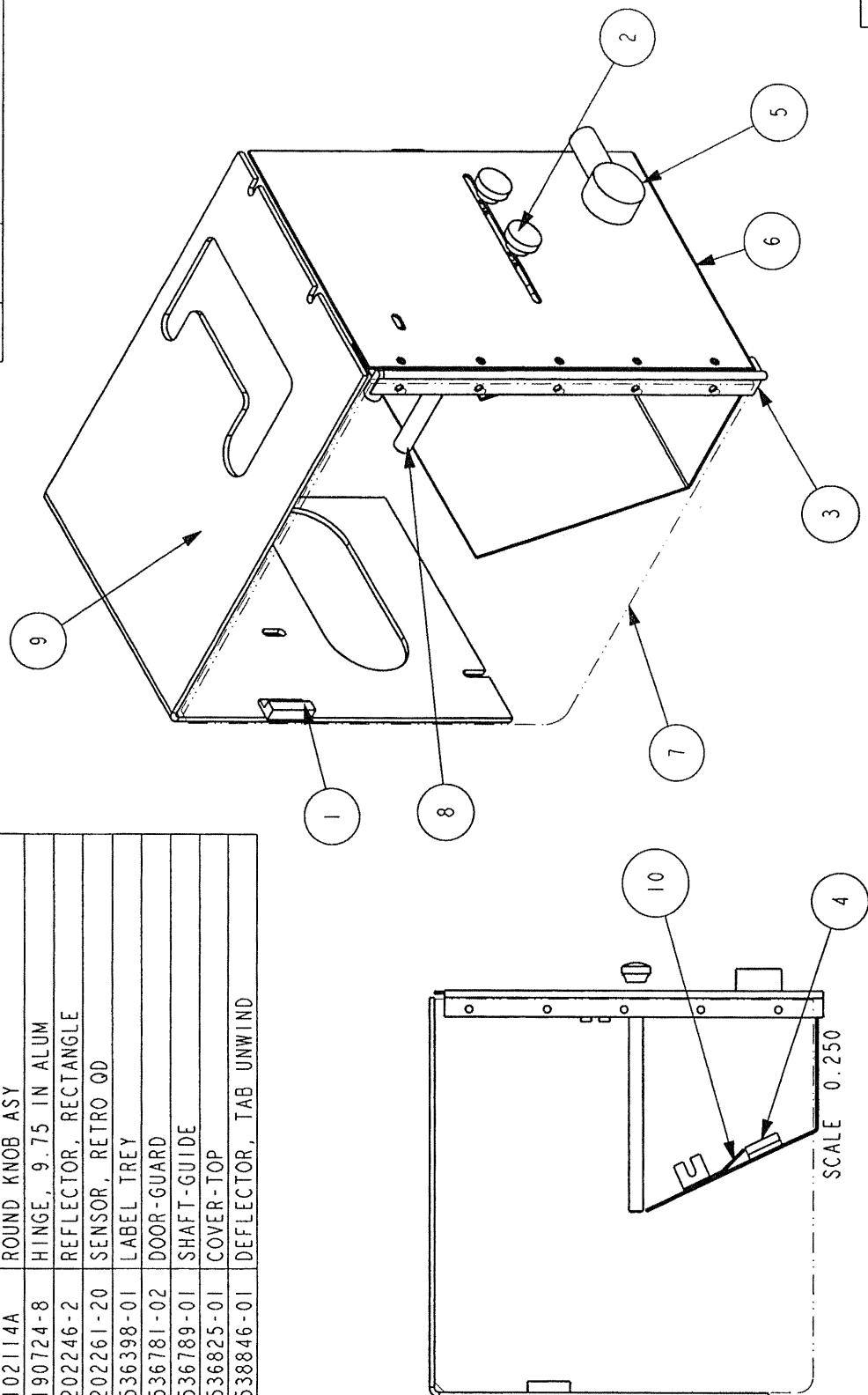
DRAWN BY:	SCALE	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	MATERIAL:	THIRD ANGLE PROJECTION	PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE QUOTED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC. KENNESAW, GA 30144 USA
CHECKED BY:	DATE	.01 .005 .5	ANG.	+	
TRACED BY:	MASTER	01-Nov-99	HEAT TREAT:	XXX	MODEL: 535
			FINISH:	XXX	TITLE: ASSY, FRAME CROSS ADJUSTMENT
				10F1	SHEET NO.: DRAWING #
					536951-01

ITEM QTY	PART #	DESCRIPTION
1	2	100101 BUSHING, SL. 3751D. 5000D. 375LG
2	1	111207 SPRKT, 25B13 .375B NK
3	1	500772 KNOB
4	1	536757-02 STUD-DRIVE SPROCKET
5	2	536796-04 PLATE-BUSHING



DRAWN BY:	SCALE	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	MATERIAL:	THIRD ANGLE PROJECTION	PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE QUOTED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY INC. KENNESAW, GA 30044 USA
TVK	0 .750	.11 .030 .005 .5	N / A	-	-
CHECKED BY:	DATE	AMG.	HEAT TREAT:	MODEL:	KIRK - RUDY, INC. KENNESAW, GEORGIA
	03-Sep-99	.01 .005 .5	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED	SP76300	
TRACED BY:	MASTER		ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY	SHEET NO: 10F1	DRAWING #: ASSY-CROSS ADJUSTMENT 536766-02

ITEM	QTY	PART #	DESCRIPTION
1	1	201170	SWITCH, SAFETY DOOR
2	2	102114A	ROUND KNOB ASSY
3	1	190724-8	HINGE, 9.75 IN ALUM
4	1	202246-2	REFLECTOR, RECTANGLE
5	1	202261-20	SENSOR, RETRO QD
6	1	536398-01	LABEL TREY
7	1	536781-02	DOOR-GUARD
8	2	536789-01	SHAFT-GUIDE
9	1	536825-01	COVER-TOP
10	1	538846-01	DEFLECTOR, TAB UNWIND



REV NO	DATE	DESCRIPTION	E&N NO
1	1/2/2001	REPLACED UNWIND SENSOR	6715 TJK

I	KR535HD
REF'D	WHERE USED

KR KIRK - RUDY, INC.
KENNESAW, GEORGIA

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OF KIRK-RUDY
KENNESAW, GA 30144 USA

>Title:

ASSY, LABEL TRAY COVER

DRAWING 1

Model:

5335

Sheet No:

10F1

Scale:

0.310

Material:

XXX

Dimensional Tolerances
UNLESS OTHERWISE NOTED

.xx .xxx .005 .005

ANG.

Heat Treat:

XXX

Finish:

XXX

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

Drawn By:

TVK

Checked By:

DATE

25-0C+ - 99

Remove All Burrs and
Sharp Edges Unless
Otherwise Noted

All Dimensions Are
Finished Dimensions
Do Not Scale - Work
To Dimensions Only

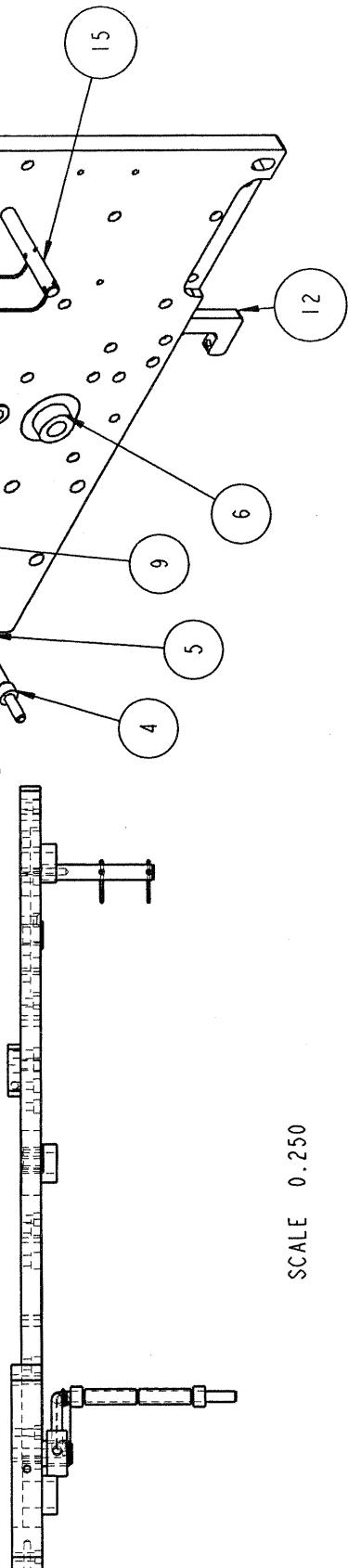
Traced By:

MASTER

M

536957-01

ITEM QTY	PART #	DESCRIPTION
1	2 100131	BUSHING, SL.250ID.375OD.1.250LG
2	1 100162	BUSHING, SL.500ID.625OD.625LG
3	2 100302	BUSHING, FL.375ID.500OD.500LG
4	2 102206	COLLAR .250
5	1 102623	SPRING, EXT.360D X .298ID X 2.5LG
6	2 103803	BEARING, HUB .500
7	1 103804	BEARING, HUB .625
8	1 104106	SNAPRING, .500
9	1 190619	PLATE, NAME
10	1 532788-02	WLDMNT, TAKE-UP ROD
11	1 536374-03	PLATE, TABBER FRAME
12	1 538124-01	BAR, VERTICAL STOP
13	1 538137-02	PLATE, TAKE-UP ROLL EXT.
14	1 538195-01	SHAFT, REWIND ARM PIVOT
15	1 538373-01	SHAFT, TAB STRIPPER
16	2 538374-01	STRIPPER, TAB UNWIND



SCALE 0.250

DRAWN BY:	T JG	SCALE	0 . 250	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	MATERIAL: XXX	THIRD ANGLE PROJECTION	PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE QUOTED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC. KENNESAW, GA 30144 USA
CHECKED BY:		DATE		.01 .005 .5	HEAT TREAT:		KIRK - RUDY, INC. KENNESAW, GEORGIA
TRACED BY:		MASTER	22-0C1-99	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED		MODEL: 535	TITLE: ASSY, FRAME W/ BEARINGS
				ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE. WORK TO DIMENSIONS ONLY		SHEET NO. 1 OF 1	DRAWING # 537669-01

8.0 ELECTRICAL SCHEMATICS AND PARTS



WARNING

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

8.1 SCHEMATIC NUMBER LIST

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

200 112 00 110 219 w/ 496F Interface, 120/220 VAC
 550 Labelmaster, High Speed
SYMBOLS.ORG Schematic Symbols Reference

8.2 PARTS LIST

KR Part #	Qty	Manufacturer	Manufacture Part #	Description
200338	1	Thomas & Betts	LT38P	Strain Relief - 3/8"
200339	1	Thomas & Betts	LT938P	Strain Relief - 90 Degree
201514	10	Hubbell	7594-VBLK	Plug - Twist, 3 Pin, Male
201541	1	Turck	RKF36-1M	Receptacle - 3 Pin, 1 Meter
201540	1	Turck	RKF20	Receptacle - 2 Pin
208503	2	Sunon	SP100A	Fan - 120 Vac
200323-1	7	Mencom	PCG-1/2R	Connector - Strain Relief
208043	1	Bussman		Fuse - 10 MDA
200159-1	1	Superior	M093 FD8208	Motor - 200 Steps/Rev
208023	1	Bussman		Fuse - 12 AGC
208044	1	Bussman		Fuse - 4 AGC
201542	1	Turck	RSM 20-6M	Plug - 2 Pin w/ Cable
202426	1	Penta Power	KBMM-225D	Board, Motor, DC, 120 Vac - For 90 Vdc Motor
209163	1	Phoenix	NS35/7.5	DIN Rail Strip - Length is application specific
202277	6	Idec	SH2B05	Socket, Relay - For 202 275, 202 276
204318	1	Clarostat	RV4NAYSD502A	Potentiometer - 5k Ohm
209237	3	Phoenix	USLKG16	Terminal, Ground
208015	3	Bussman		Fuse - 1 MDL
208022	2	Bussman		Fuse - 8 AGC
202427-1	1	Penta Power	9839	Resistor, .05 ohm
200341	1	Thomas & Betts	LT950P	Strain relief - 90 Degree
200340	1	Thomas & Betts	LT950P	Strain Relief - 1/2"
201515	1	Hubbell	7593-VBLK	Receptacle - Twist, 3pin, female
201546	1	Turck	RSM 20-6M	Plug with WIRENUT
201516	1	P/S	5266X	Plug, 15A 120V Power
201543	1	Turck	RSM 36C-6M	Plug, Conveyor Power
201160-3	1	Meltric	63-18075-X13	Inlet, 20A 110V
201161-3	1	Meltric	63-13075-180-X13	Connector, 20A 110V
201161-3A	1	Meltric	CABLE W/PLUG	Coonector, Assembly

KR Part #	Qty	Manufacturer	Manufacture Part #	Description
208504-1	1	Sunon	25726	Grill Fan Filter
200165-5	1	Leeson	M1130331.00	Motor, 1/4HP DC
209270	2	Leeson	M1900010.22	Brush, For 200165-5
209271	2	Leeson	M1900008.01	Brush, Cap for 200165-5
200608	1	Baldor	GP231001	Motor, Rewind
209272	2	Baldor		Brush for 200608
209092-1	2	Baldor		Brush Cap for 200608
200159-4	2	Warner	KML092F07	Motor, Stepping
202486	1	Warner	MX2000-1C	Board, Logic
209016-1	1	EHO	EH71-3N2S	Knob, Speed Pot
209016-2	1	EHO	KL1251G	Lock, Knob
201130-1	5	GE	P9B10VN	Contact, NO
201131-1	3	GE	P9B01VN	Contact, NC
201124-2	1	GE	P9CPNVG	Operator, Green Pushbutton
201124-4	1	GE	P9CPLVGD	Operator, Green Light
201124-5	1	GE	P9PDNVO	Socket, LED
201124-6	1	GE	080BA9S24LB	Bulb, 24VDC
201125-3	1	GE	P9CPNRS	Operator, Red Pushbutton

9.0 APPENDIX



WARNING

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

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

<u>COMPONENT</u>	<u>MANUFACTURER</u>
DC Supply	International Power
Stepper Drives	Warner Electric
DC Motor Board	Penta-KB
Beamswitch	Banner
Label Detector	Banner
Interface	Maple Systems

10 NOTES

11 WARRANTY AND SERVICE

WARRANTY

Warranty: Kirk-Rudy warrants to the original retail purchaser that this product is free from defects in the material and workmanship, and agrees to repair or replace, at Kirk-Rudy's option, any defective product within 90 days from the date of purchase. This warranty is not transferable. It covers damage resulting from defects in material or workmanship, and it does not cover conditions or malfunctions resulting from normal wear, neglect, abuse or accident. THIS WARRANTY IS IN LIEU OF ALL OTHER EXPRESSED WARRANTIES OR IMPLIED WARRANTY OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE OR ANY IMPLIED WARRANTY ARISING OUT OF A COURSE OF DEALING, CUSTOM, OR USAGE OF TRADE.

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

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

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

USE ONLY GENUINE REPLACEMENT PARTS

For Service or Replacement Parts Please Call:

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

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

Kirk-Rudy, Inc.
125 Lorraine Parkway
Woodstock, GA 30188
www.kirkrudy.com