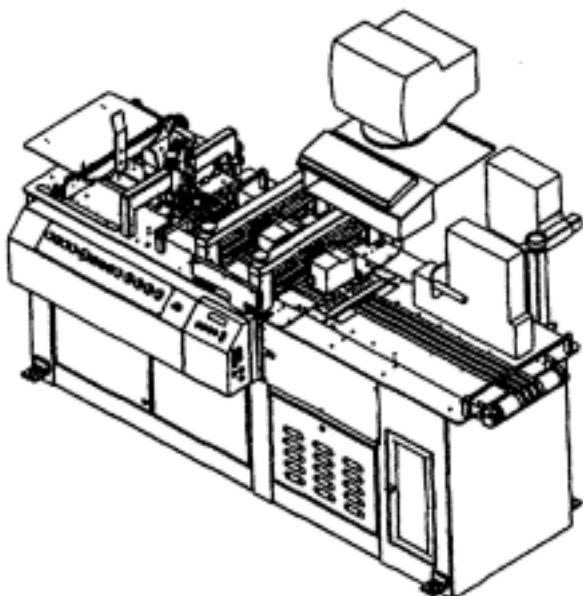


Kirk-Rudy, Inc.

Instruction and Parts Manual



Instruction
and Parts Manual

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1 Important Safety Instructions

Intended Use Statement: The KR215B is a top load, bottom feed transport designed to separate and feed product for inkjet printing and drying. Once product has left the shuttle feeder, a vacuum conveyor table will be used to transport the product under inkjet heads for printing. Next, product will be transferred to a heat belt section. The heat belt section will use a high temperature vacuum blower to control the product as it is conveyed under an inkjet print dryer. Usage for other purposes may lead to an unsafe condition.

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



WARNING

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

NOTE: THIS EQUIPMENT HAS BEEN TESTED AND FOUND TO COMPLY WITH THE LIMITS FOR A CLASS A DIGITAL DEVICE, PURSUANT TO PART 15 OF THE FCC RULES. THESE LIMITS ARE DESIGNED TO PROVIDE REASONABLE PROTECTION AGAINST HARMFUL INTERFERENCE WHEN RADIO FREQUENCY ENERGY AND, IF NOT INSTALLED AND USED IN ACCORDANCE WITH THE INSTRUCTION MANUAL, MAY CAUSE HARMFUL INTERFERENCE TO RADIO COMMUNICATIONS. OPERATION OF THIS EQUIPMENT IN A RESIDENTIAL AREA IS LIKELY TO CAUSE HARMFUL INTERFERENCE IN WHICH CASE THE USER WILL BE REQUIRED TO CORRECT THE INTERFERENCE AT HIS OWN EXPENSE. SHIELDED CABLES MUST BE USED WITH THIS UNIT TO ENSURE COMPLIANCE WITH THE FCC CLASS A LIMITS.

2 SPECIFICATIONS

<u>PRODUCT SIZE RANGE</u>	<u>English</u>	<u>Metric</u>
Minimum Size:	3" W x 5" L	7.6cm W x 12.7cm L
Maximum Size:	17" W x 12" L	43.1cm W x 33cm L
Minimum Thickness:	Card Stock (.007")	Card Stock (.10mm)
Maximum Thickness:	.625"	15.9 mm

MACHINE DATA BASE

Length	90.5"	230 cm
Width	44.75"	113.7 cm
Height	49"	124.5 cm
Weight	lbs	kg
Shipping	lbs	kg

ELECTRICAL

Base Main Power Input:	220 VAC, Single Phase,4-WIRE 60/50 Hz,30 A
Feeder Drive Motor:	½ H.P. DC
Vacuum Pump:	½ H.P. DC
Table Conveyor Motor:	½ H.P. DC
Vacuum Blower:	120 Volt, AC 60/50 Cycle, 1.4 A
Speed Up Conveyor Motor:	¼ H.P. DC

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
8. Locate and attach electrically the KR Conveyor (if purchased with KR215B). The electrical connections for the conveyor are located on the left side of the machine from the direction of product flow.
9. Locate and attach electrically the dryer. **Warning: Dryer must be externally powered. DO NOT USE ELECTRICAL OUTLETS INSIDE CABINET FOR DRYER.** The electrical connection (two pin twist) to enable the dryer is located on the left side of the machine from the direction of product flow.

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

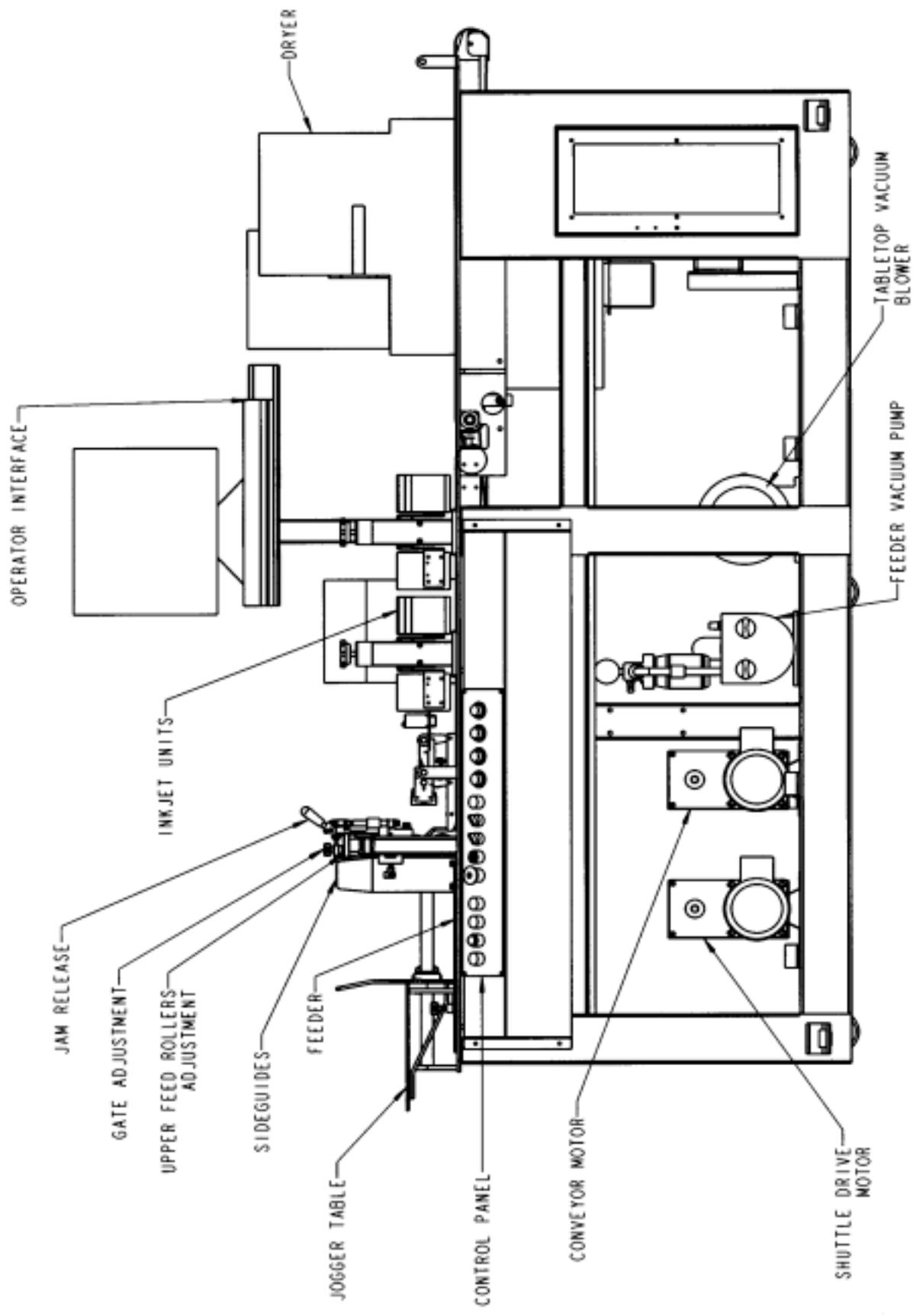
3.2 ACCESSORIES AND SPARE PARTS

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

3.3 COMPONENT DESCRIPTION (see Figure 2)

1. JOGGER TABLE: Used to set the backstop for the product being fed. Can also be used to hold extra product.
2. FEEDER: Pushes product into gate and feed rollers.
3. GATE ADJUSTMENT: Prevents more than one piece of product from being fed at one time.
4. UPPER FEED ROLLER ADJUSTMENT: Along with the lower feed rollers, feeds product through the bridge.
5. JAM RELEASE: Raises top feed rollers, so a jam can be fixed.
6. SIDE GUIDES: Keeps product from skewing while traveling on the tabletop.
7. OILER: Used to lubricate machine.

8. FEEDER VACUUM PUMP: Supplies vacuum to the feeder.
9. SHUTTLE DRIVE MOTOR: Drives the feeder shuttle table.
10. TABLETOP VACUUM BLOWER: Supplies vacuum to the tabletop.
11. CONTROL PANEL (for more detail, see Section 4.1 and Figure 2.0): Contains operator controls.
12. BRYCE TACHOMETER: This device measures speed of belts. This is used to get the correct speed for printing.
13. INKJET AREA: The position of the Bryce Inkjet Unit.



NOTE: SOME ITEMS SHOWN ARE FOR VIEW REFERENCE ONLY
KR215B COMPONENTS DESCRIPTION
FIG. 2

4 OPERATING INSTRUCTIONS

4.1 BASE – ELECTRICAL OPERATION

OVERVIEW OPERATOR CONTROLS



WARNING

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

The following controls are located on the operator side of the feeder base. (**FIG. 1**)

Main Power Off Switch: This switch cuts power to the entire machine. Twist to unlatch.

Main Power Switch: When this two-position switch is depressed, source voltage is supplied to the electrical panel. This will make all of the switches on the electrical control panel active. The switch will be light green when activated.

Vacuum Switch, Feeder: Rotate this switch to actuate the feeder vacuum pump.

Blower Switch: Rotate this switch to actuate both vacuum blowers. One is for the inkjet table. One is for the dryer table.

215 or 496 Mode Switch: This (optional) switch enables a 496 friction feeder, which can be used on top of the existing shuttle feeder. The 496 feeder (optional) will plug (two pin twist) into the left side panel of the electrical control box.

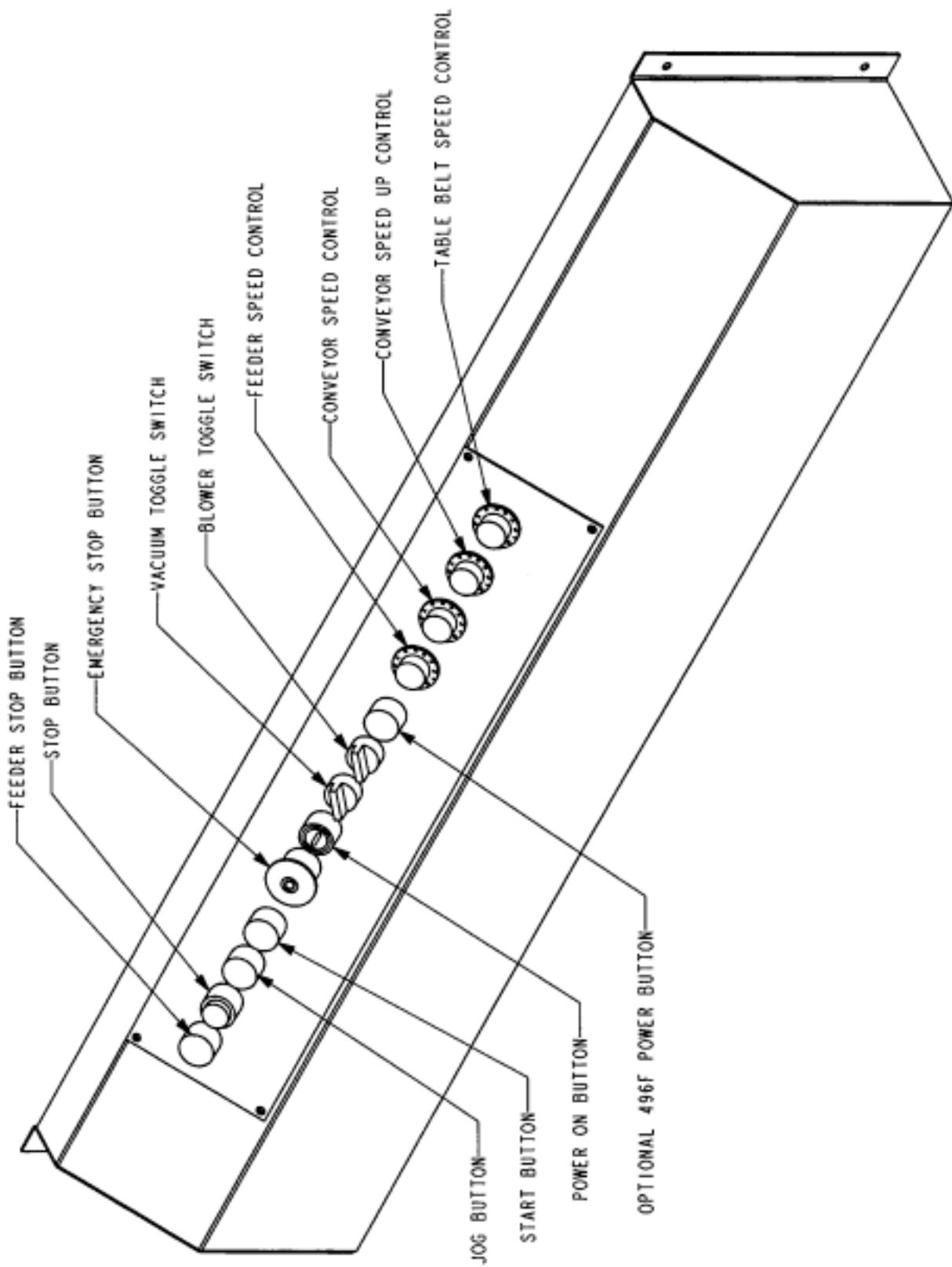
Feeder Stop Switch: When this two-position switch is depressed the feeder portion of the machine will turn off. The rest of the machine past the feeder will continue to operate.

Stop Switch (red): Machine operation can be manually stopped by depressing the stop button on the operator panel or the button on the left panel of the conveyor.

Jog Switch (black): The machine can be inched or jogged by depressing and releasing this switch. The machine will continue to cycle if this button is held depressed.

Start Switch (green): Continuous machine operation is achieved by depressing this switch momentarily and releasing.

Speed Control, Feeder: Machine speed can be varied by turning the first knob. Turn knob clockwise to increase shuttle speed, counterclockwise to decrease.



KRR15 CONTROL PANEL
FIGURE 1.0

Speed Control, Conveyor: The second knob controls the speed of the belts on the shingle conveyor. When the main drive motor speed is set at a convenient range to continually replenish product in the feed hopper and for zip code sorting requirements, the conveyor speed should be adjusted for required product overlap. Turn knob clockwise to increase belt speed, counterclockwise to decrease.

Speed Control, Conveyor Speed Up: The third knob controls the speed up of the belts on the shingle conveyor. Turn knob clockwise to increase belt speed, counterclockwise to decrease.

Speed Control, Table Conveyor: The forth knob controls the speed of the belts on the dryer table. Turn knob clockwise to increase belt speed, counterclockwise to decrease.

ELECTRICAL COMPONENT DESCRIPTION

Photocell- Stack Detection: Detects the presence of a stack in the hopper area. If no stack is detected the feeder drive motor will stop. This sensor is mounted to the bottom of the left side guide.

Safety Features, Electrical: All devices are fully protected as follows:

- Main Drive Motor: The solid state component board mounted inside the electrical panel has a 12ABC input fuse and a 8AGC armature output fuse. The main drive motor will not operate with this fuse blown.
- Table Conveyor Drive Motor: The conveyor drive board has a 12ABC and 8AGC fuse.
- Vacuum Pump Motor: Mounted on the inside of the electrical panel, are two 8MDL fuses.
- Shingle Conveyor Drive Motor: The conveyor drive board has a 12ABC and 4AGC fuse.
- Inkjet Table Vacuum Blower Motor: Mounted on the inside of the electrical panel is a 3.2 MDL fuse.
- Dryer Table Vacuum Blower Motor: Mounted on the inside of the electrical panel is a 3.2 MDL fuse.
- AC Outlet Boxes: Each box is fused at 8 amps/120 VAC.



Plug Interfaces:

215B Plug Listing:

Plug #	Description	Voltages Present	Plug Type
Inkjet Plugs:			
PL1:	Bryce Conveyor Speed UpDC Common	4 Pin	
PL2:	Bryce & 215 Enable	1-2: Contact, 3-4: 12 Vdc	4 Pin
Dryer Plugs:			
	Dryer Enable: Contact Closure	Open Relay Contact	Male 2 Pin Twist
	Dryer Enable: +24 Vdc	DC Voltage Supplied	Female 3 Pin T.
Power Supply Plugs:			
	220 Vac/I Phase/30 Amp	215 Power Input	
	120 Vac, 8 Amperes	120 Vac Output	
Stop Plug:			
	Conveyor Stop: Contact Closure	24 Vdc	Female 2 Pin Turck
Conveyor Plug:			
	Conveyor Motor	Variable Motor Voltage	Female 3 Pin Turck

Programmable Logic Controller: The 215B is controlled by an Allen-Bradley MicroLogix Programmable Logic Controller (PLC). This unit monitors devices and controls outputs based on these inputs. This unit does not require any maintenance .

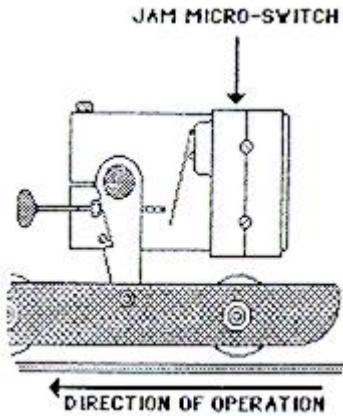
Conveyor Speed Up: The conveyor speed is triggered from an external signal, PL1. The amount of time for the speed up is set as follows:

Reset Timer Value: To reset speed up time to zero, first press and hold *Power On*, then press *Run*. Then release *Run*, then release *Power On*. The machine will not enter run mode.

Increase Timer Value: To increase speed up time by 0.1 second, press and hold *Power On*, then press *Jog*. The machine will not enter jog mode. Each jog press will increase the conveyor speed up time by 0.1 second. Finally, release *Jog*, then release *Power On*. Machine is back to normal mode and is ready to run.

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 six stop switches on the KR215B. They are the jam microswitch on the skid bar assembly, the Bryce stop out, the stop button, conveyor stop (E-box input), low hopper and the control panel emergency stop button.



The switch that is open most often is the “jam microswitch” located on the skid bar (see Section 4.12).

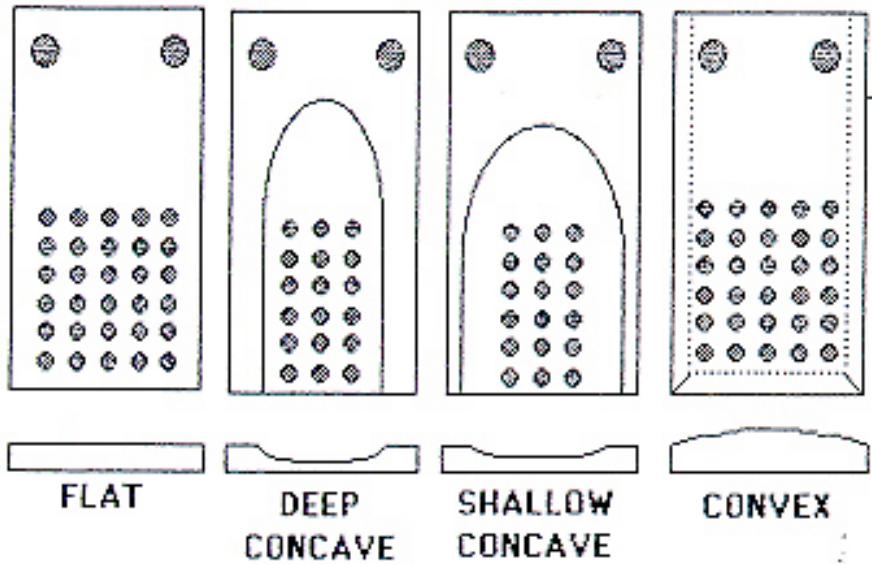
The second switch that is most often open is the conveyor stop button. This button is usually open because of improper seating of the plug that goes into the back of the machine. If neither the machine nor the conveyor will run (conveyor power switch in “automatic” position) when the start button is depressed, check all the stop switches. If the machine will still not run, the problem must be isolated with a volt/ohm meter using the schematics.

4.3 SEQUENCE OF SET-UP

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

4.4 VACUUM PLATES

Before setting up the feeder, the correct vacuum plate should be selected and installed. There are four vacuum plates available for the KR215B.



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

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

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

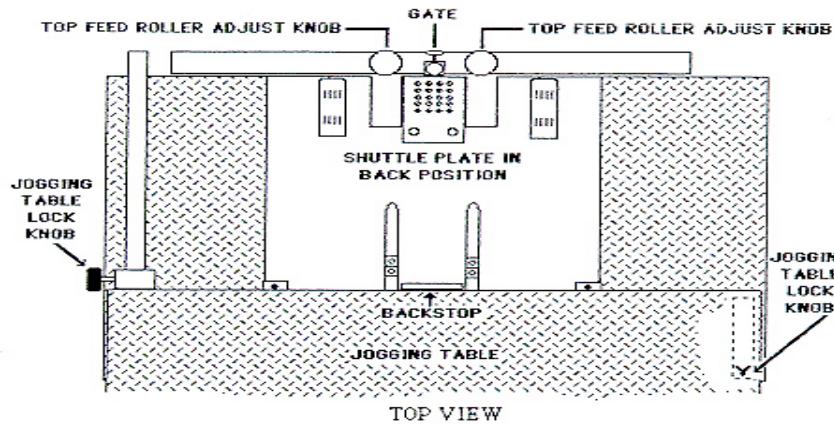
CONVEX PLATE: For tri-folded or self-mailers and can also be used for product that has a warp or bend.

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

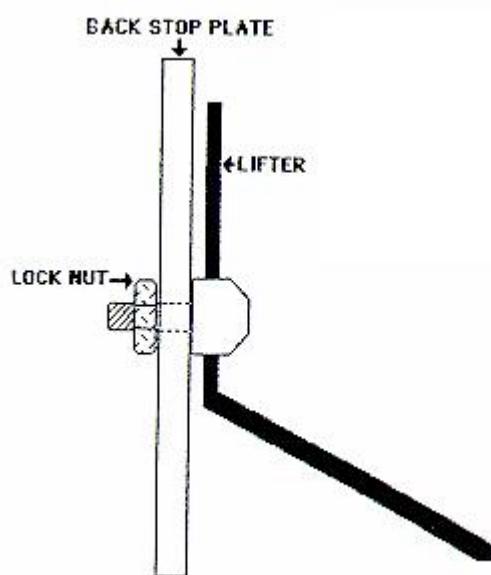
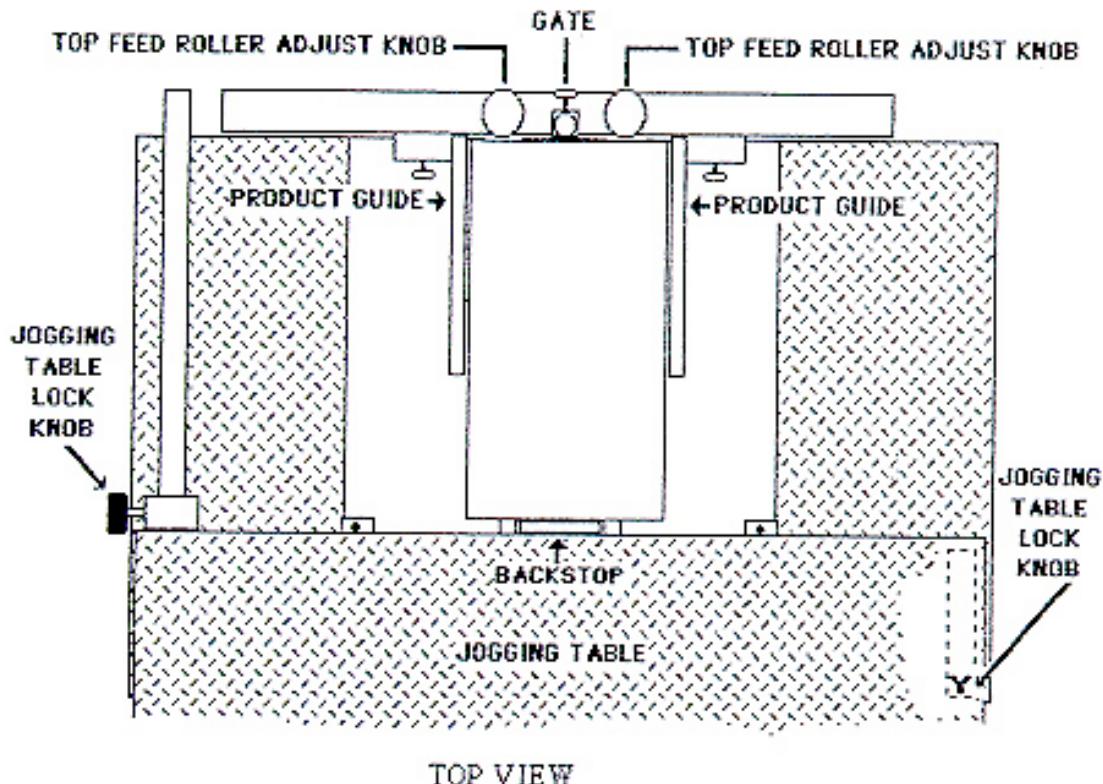
4.5 SHUTTLE/FEEDER SET-UP

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

Jog the machine until the shuttle plate is in the extreme back position.



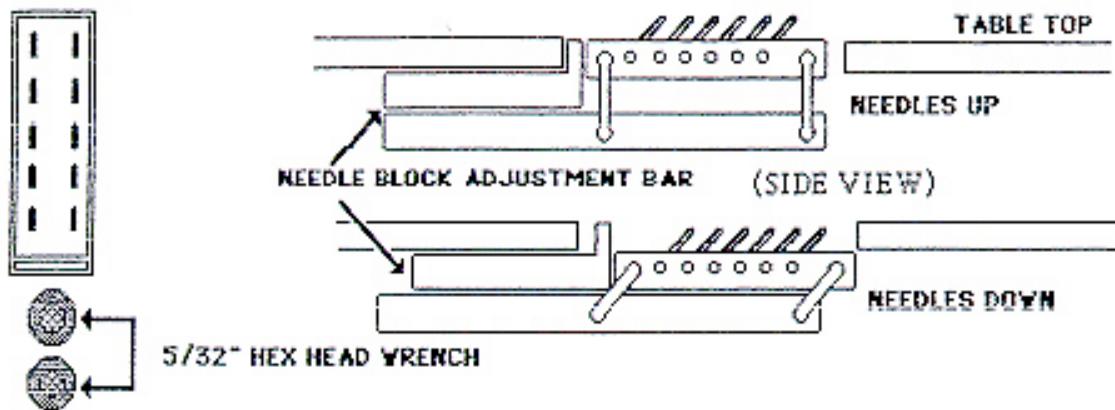
Place the product on the shuttle plate up against the gate. Bring the backstop up against the product and lock in place. Bring both product side guides in to the product. Allow approximately 1/8" play between guides and the product. Lock in place.



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

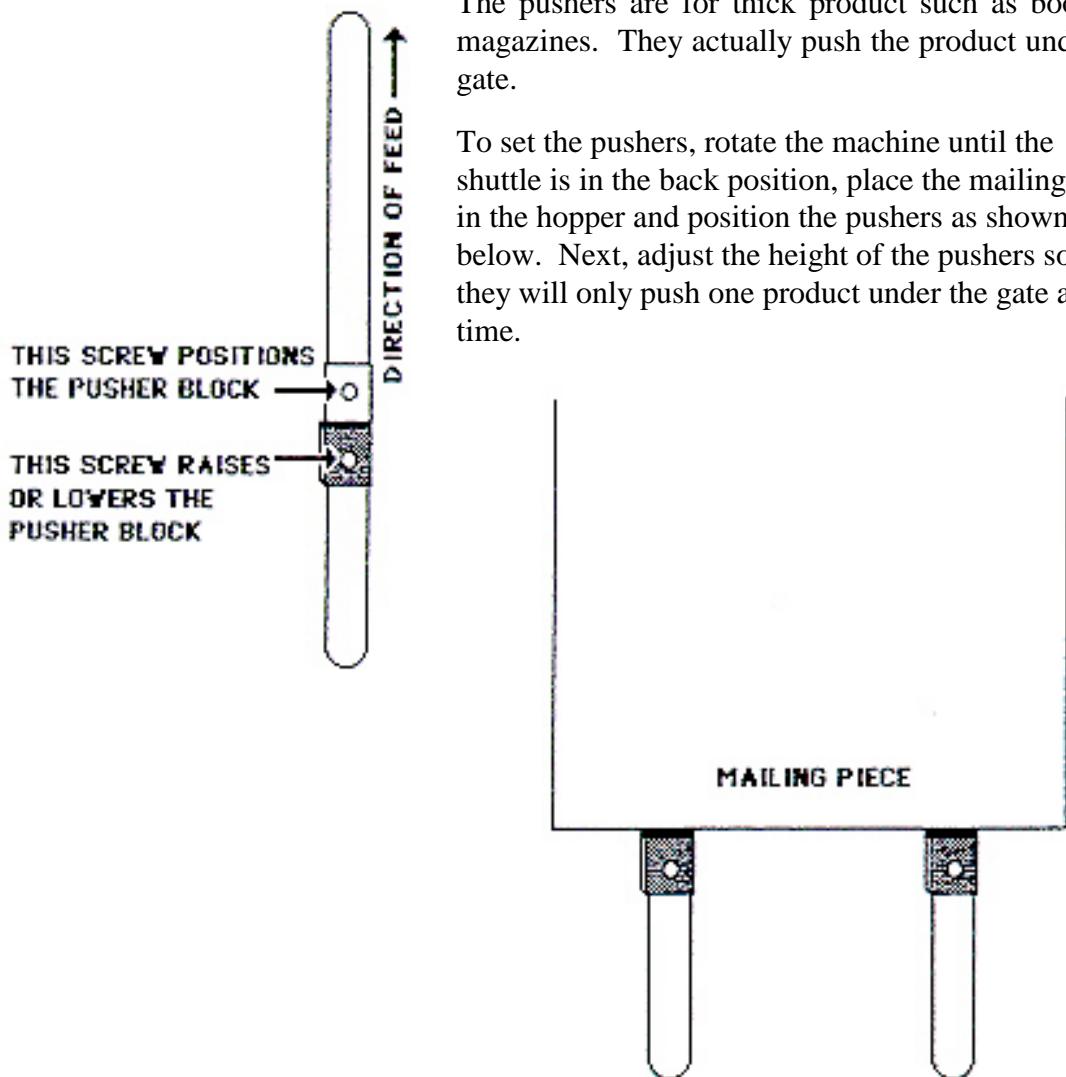
The lifters are designed to lift up the back of the product and angle the front edge toward the gate to aid in feeding. These are most commonly used for large products such as newspapers, magazines, and etc.

The needle blocks are designed to grab the product and help in the feed under the gate. The needle blocks can damage the product and are almost always used for newspapers. They are often used in conjunction with the lifters.



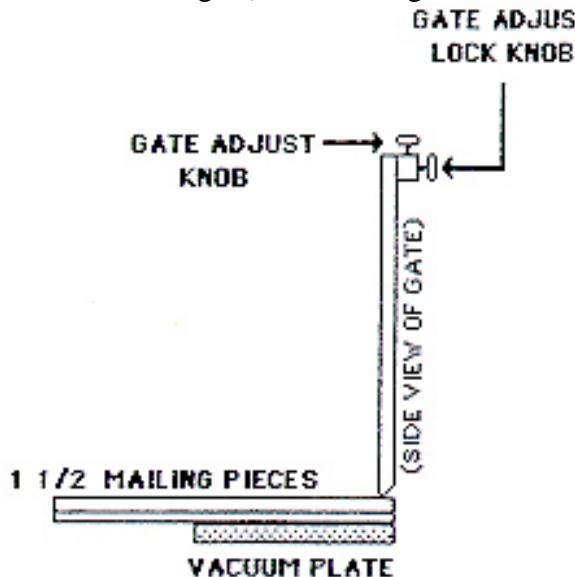
The pushers are for thick product such as books or magazines. They actually push the product under the gate.

To set the pushers, rotate the machine until the shuttle is in the back position, place the mailing piece in the hopper and position the pushers as shown below. Next, adjust the height of the pushers so that they will only push one product under the gate at a time.



4.6 GATE SET-UP

To set the gate, loosen the gate lock knob and turn gate adjust knob counter clockwise to raise the gate. Turn the main power and the feeder vacuum pump switches on. To rotate the gate, adjust the knob clockwise until the gate is snug against the mailing piece. (When setting up on a mailing piece that is two or more pages, the gate should be set snug to 1 ½ times the thickness of the mailing piece. Simply take 1 ½ pieces and place underneath the gate). After the gate is set, lock in place with the gate lock knob.

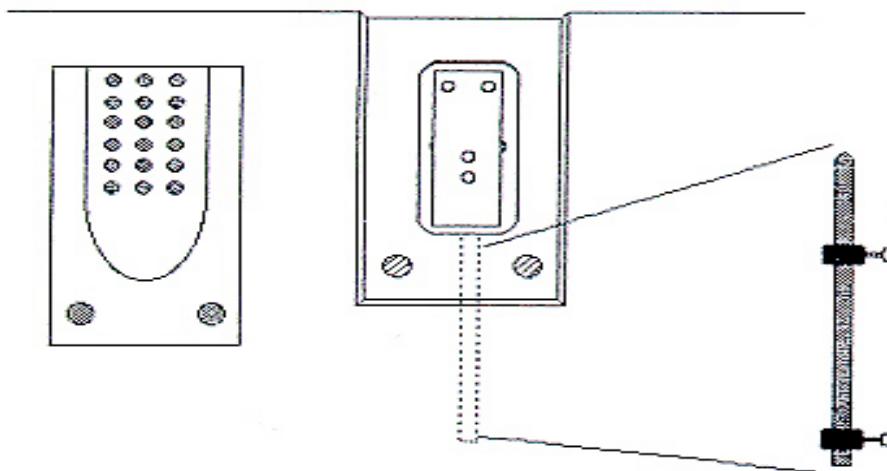


This should allow one piece to feed smoothly but keep two pieces from going under the gate at the same time. If two pieces are fed and the gate is set properly, the piece on top will jam or tear. If this happens, the problem is either the mailing pieces are stuck together or too much vacuum is being applied to the vacuum plate. To adjust the amount of vacuum being applied to the plate, see Section 4.6.

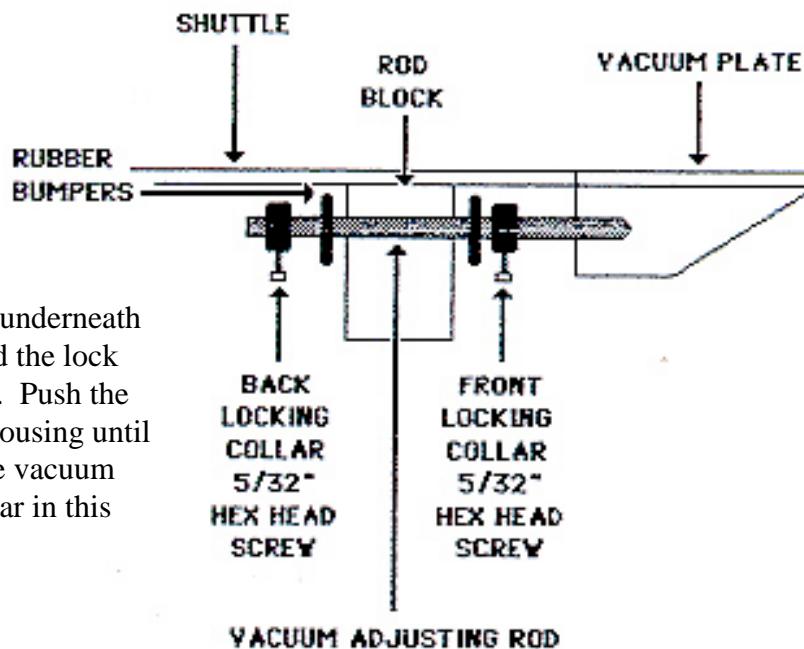
4.7 VACUUM TIMING AND TOP FEED ROLLER SET-UP

The vacuum connected to the vacuum plate is designed to come on 1/8" before the shuttle plate reaches the maximum backstroke. The vacuum connected to the vacuum plate should go off after the vacuum plate has transported the product underneath the gate and between the feed rollers. The lower feed rollers will come up.

The vacuum is turned on and off by two lock collars set-screwed to a rod that rides underneath the vacuum plate. When this rod is pushed in it turns the vacuum on and when it is pulled out the vacuum is turned off.

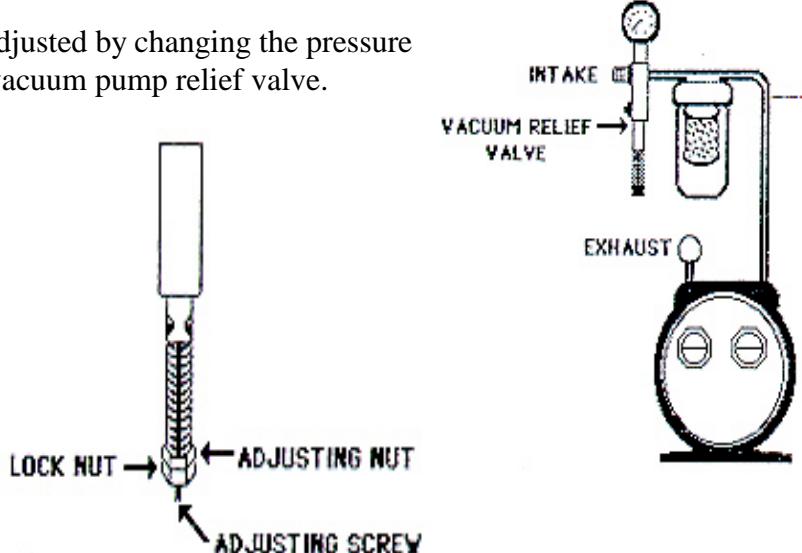


To adjust the vacuum on, turn the main power and feeder vacuum pump switches on and rotate the machine by hand until the shuttle plate is 1/8" from its maximum backstroke. Locate the front lock collar on the rod underneath the feeder and loosen. Hold the lock collar against the rod block. Push the rod into the vacuum plate housing until the vacuum comes on to the vacuum plate. Tighten the lock collar in this position.

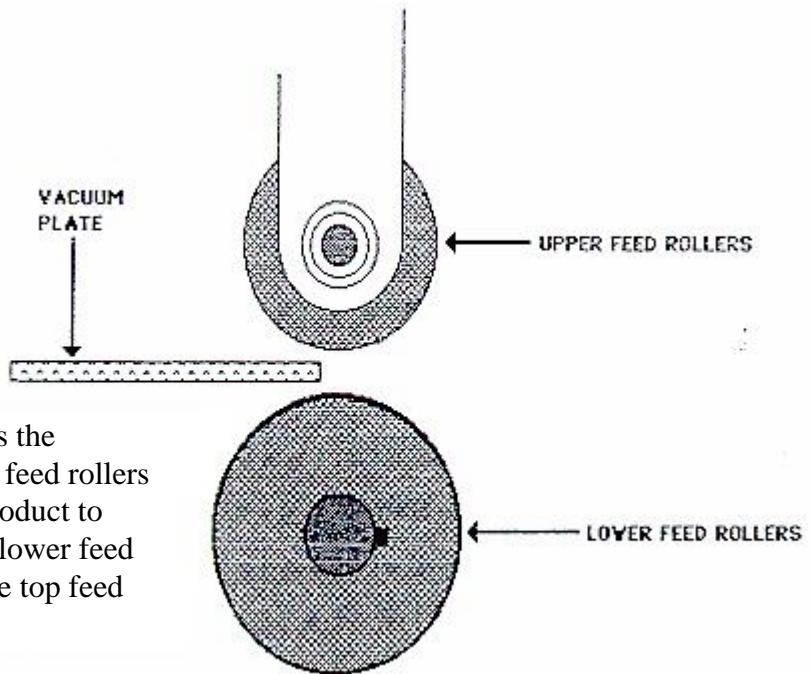


Vacuum to the plate can be adjusted by changing the pressure on the spring located on the vacuum pump relief valve.

Locate the vacuum relief valve on the feeder vacuum pump (located on the left of the machine) and loosen the lock nut. Now the vacuum can be adjusted by holding the adjustment screw and turning the adjustment nut. As the spring is compressed, the vacuum increases. Loosening the compression spring decreases vacuum.

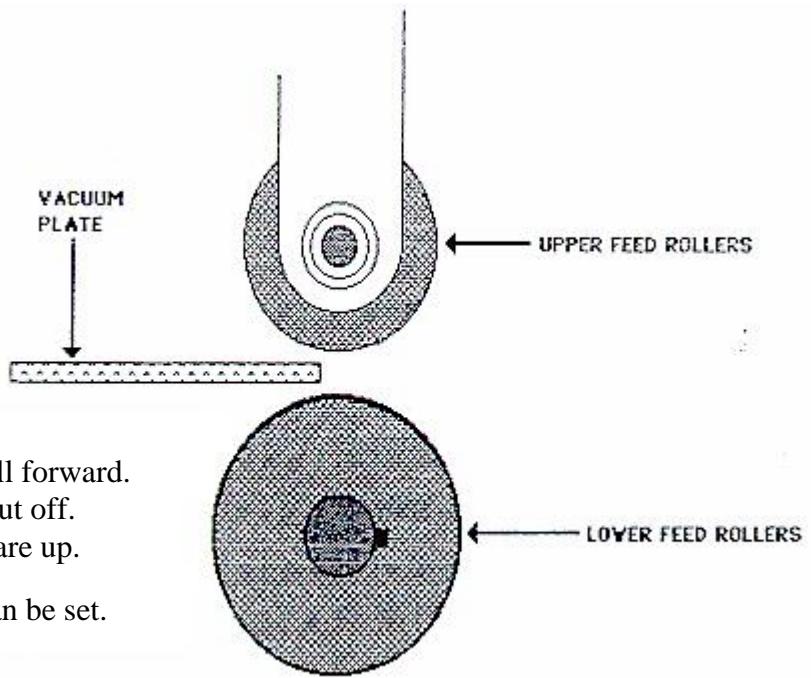


Rotate the machine with the handwheel and move the shuttle forward until the lower feed rollers come up. At this point the vacuum should go off. To adjust the vacuum off, loosen the back lock collar and hold against the rod block, pull the rod out of the vacuum plate housing until the vacuum goes off. Tighten in this position.



As the vacuum plate moves the product forward, the lower feed rollers move down to allow the product to move between the top and lower feed rollers. DO NOT adjust the top feed rollers at this point.

At this position the upper feed rollers can be set.



1. The vacuum plate is full forward.
2. The vacuum plate is shut off.
3. The lower feed rollers are up.

Now the top feed rollers can be set.

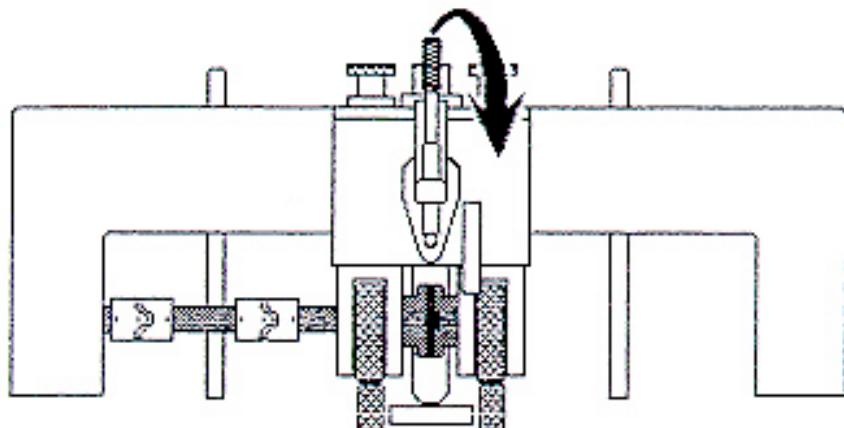
To set the top feed rollers, place a mailing piece in the shuttle feeder. Turn on the main power and feeder vacuum pump. Rotate the machine by hand until the piece is fed underneath the gate, between the top and lower feed rollers, and the lower feed rollers have come up. Adjust the top feed rollers up and down until there is enough pressure on the mailing piece to be able to pull the piece back out without tearing it.

After setting the top feed rollers, lock them in place with the locking nuts.

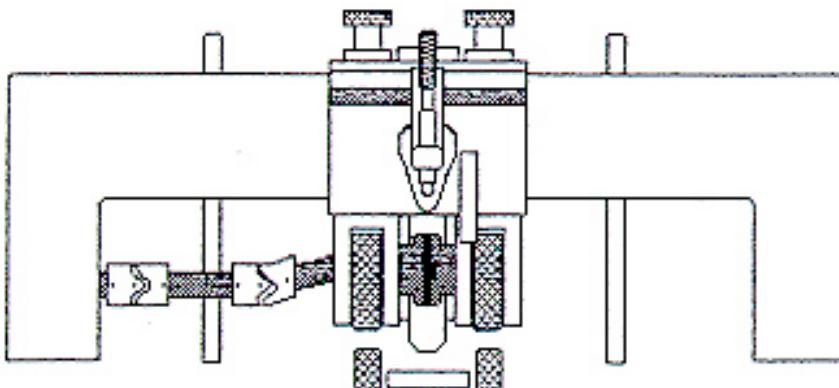
Place several pieces in the feeder and run the machine using the run or jog button. If the piece pulls to one side as it leaves the feed rollers, the top feed rollers are not set properly. Adjust until the mailing piece is fed smoothly by raising or lowering one of the top feed rollers.

4.8 JAM RELEASE

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



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



Jam release pulled down, raising gate and feed rollers.

4.9 SPACING

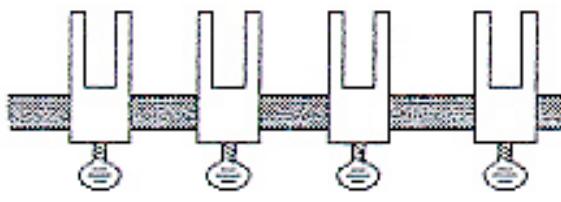
Varying the speed of both the shuttle feeder and tabletop belts controls spacing of product.

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

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

4.10 TABLETOP BELTS

The tabletop belts are designed to transport the product from the feed rollers, under the inkjet head and onto the dryer conveyor. There are seven tabletop belts on the KR215A. However, not all of them are needed for every product. You may run the belts that are not needed outside of the side guides.

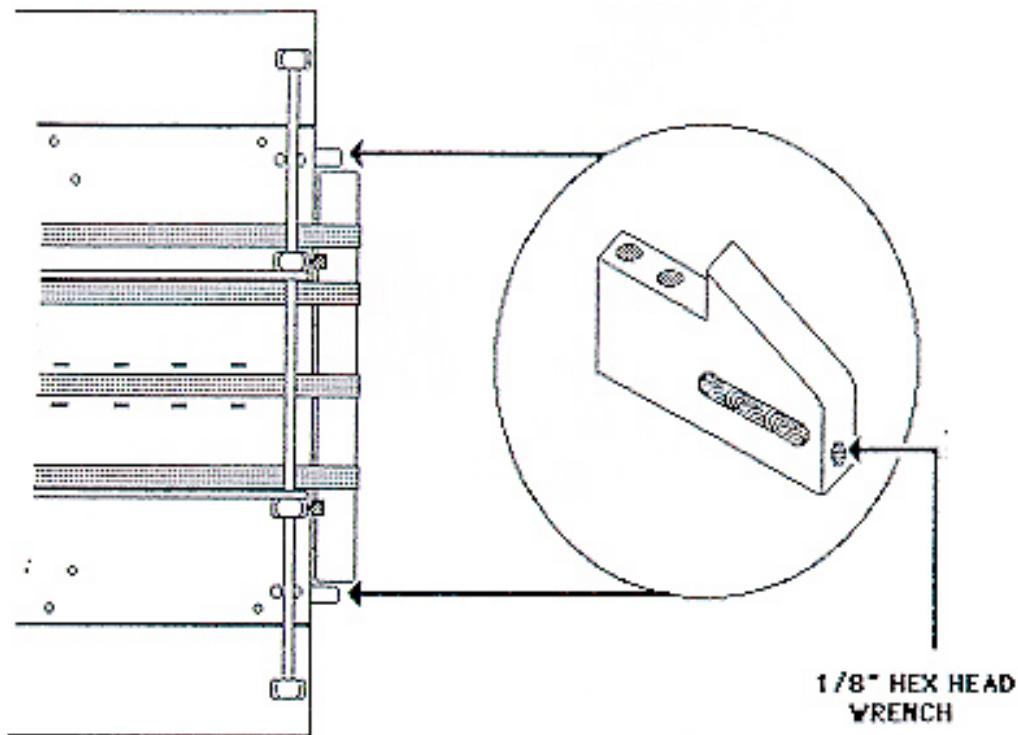


Underneath the tabletop is located guides for the tabletop belts. Each belt has its own guide. To move the belts, simply loosen the thumbscrew on the bottom of the guide and slide the guide on the shaft to the desired position and then tighten the thumbscrew.

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.

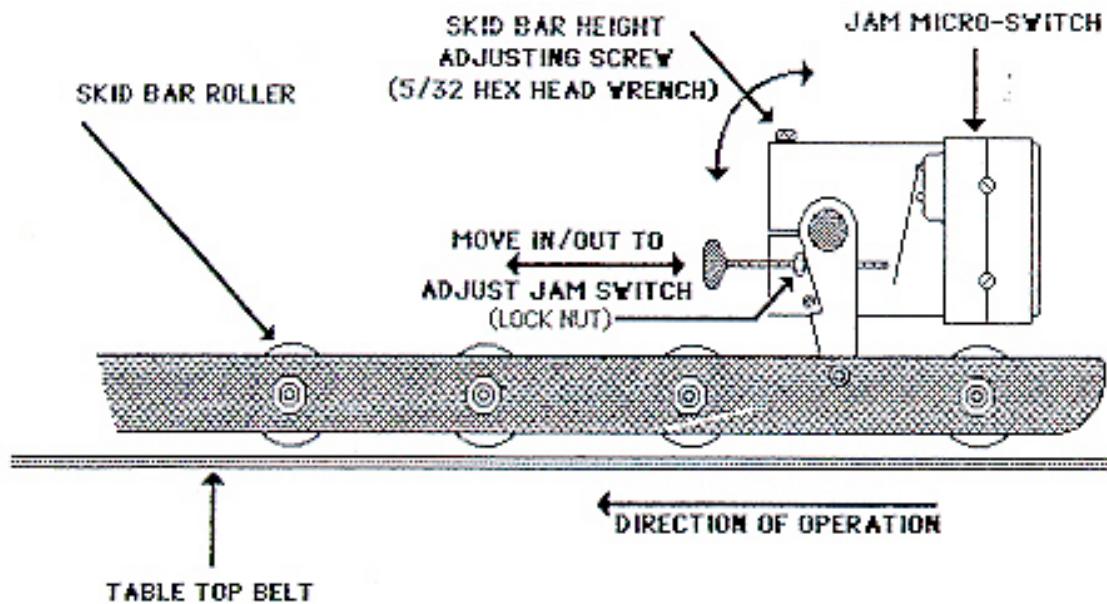
The tabletop belt tension can be adjusted. Caution should be taken not to over tighten. There should be just enough tension to prevent belt slippage.



4.11 SKID BAR

The skid bar rides on top of the product to help transport the mailing piece across the tabletop. The skid bar should be placed over one of the tabletop belts for best results. To move the skid bars locate and loosen the 1/8" hex head set screws in the lock collars on the right-hand side of the machine. The left-hand side of the machine has a lock collar and a skid bar block that is held in place with a 5/32" hex head screw. The KR215B is furnished with one skid bar, and is not needed when running small pieces such as cards or envelopes but can be installed when running large or heavy product.

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



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

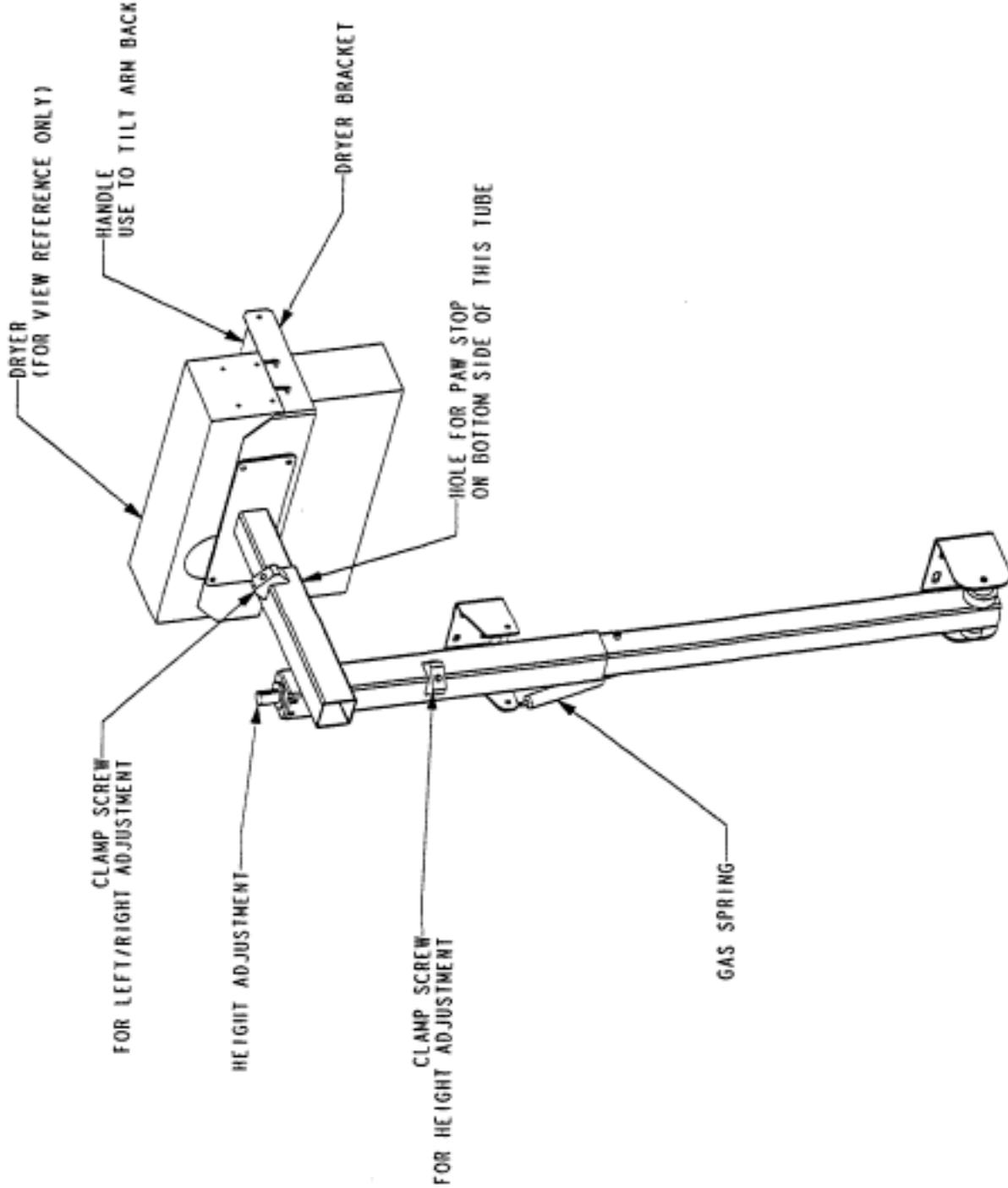
The jam switch is adjusted by loosening the lock nut, moving the adjustment knob in or out and tightening the lock nut. The microswitch should disengage and stop the machine when a jam or double feed occurs.

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

4.12 DRYER ARM SETUP & USAGE (FIG 4)



Height Adjustment: The height of the dryer can be adjusted using the wheel on the top of the dryer Arm. First loosen the clamp screw on the vertical tube of the dryer arm. Next, turn the crank clockwise to move the dryer down or counter clockwise to move the dryer up. Retighten clamp screw when dryer is at desired height.



DRYER ARM SET UP/USAGE
FIGURE 4.0

Left/Right Adjustment: The left/right position of the dryer can be adjusted by loosening the clamp screw on the horizontal tube, continue to hold the clamp screw handle and slide the dryer in and out. Retighten clamp screw when dryer is at desired location.

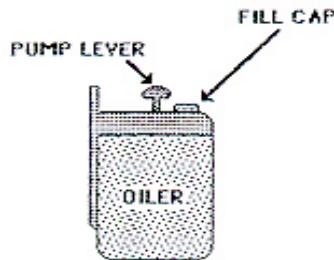
Clearing Jam Under Dryer: Use handle to push dryer arm back approximately 15 degrees. Dryer arm will remain back so jam can be cleared. **Note: On Research Dryers** (Dryer will automatically turn off in the back position.) Pull on handle to position the dryer back over the conveyor for normal operation.

Horizontal Tube Removal: The inside horizontal tube has a paw stop to prevent the dryer from being pulled out too far. The spring loaded paw will automatically stop the tube at the end of its stroke. The spring loaded paw automatically resets when the tubing is pushed in the opposite direction. To remove the horizontal tube follow these steps:

1. Remove dryer from dryer bracket.
2. Loosen horizontal clamp screw.
3. Slide tube out until the paw stops it.
4. Use allen wrench to push paw up and out of the hole located on the bottom of the larger horizontal tubing, at same time pull inside tubing out.

5 MAINTENANCE

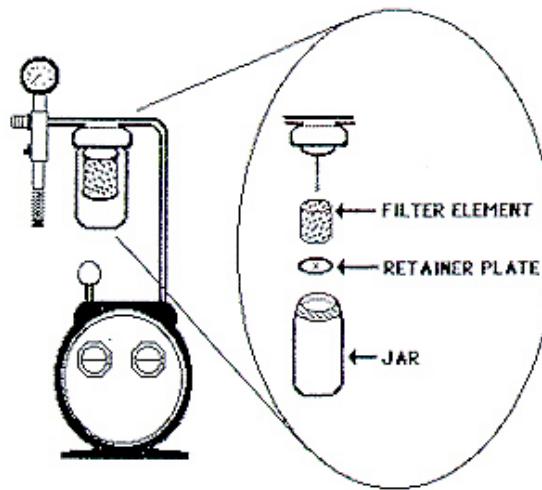
5.1 LUBRICATION



The operator should keep the KR215B clean and lubricated on a regular basis. The base has a central oiling system that only requires the operator to pull the pump lever on the oilier. This should be done every two hours of operation. The oil recommended is a 20 weight SAE machine oil.

5.2 DAILY MAINTENANCE

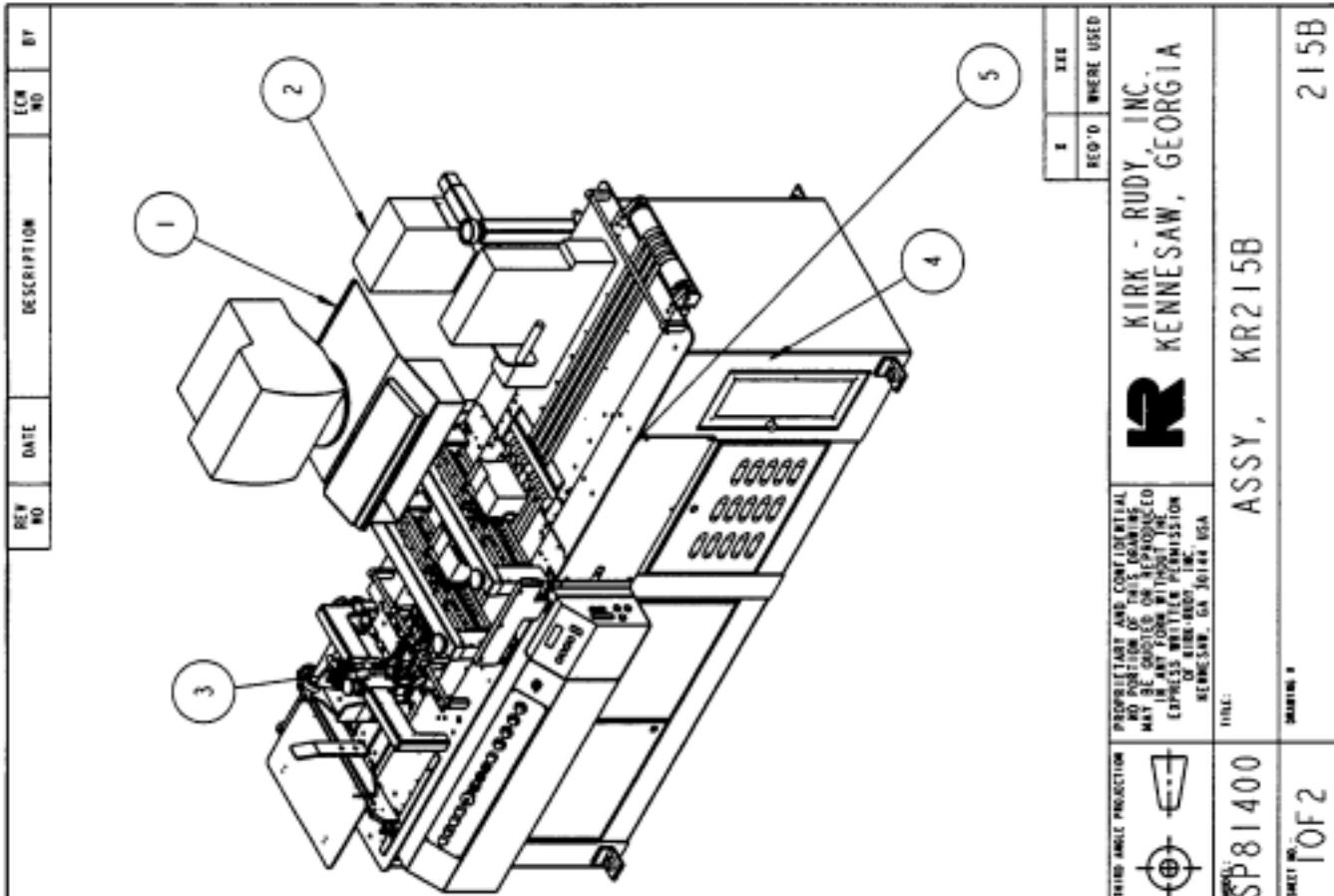
Item	Function	Remarks
Upper & Lower Feed	Remove glazing and all other foreign materials from feed	Use alcohol.
Base (General)	Remove excessive paper dust, ink, glue, and all other foreign materials from the tabletop and inside of base.	Use clean soft rag. (Dampen with water if necessary.)
Vacuum Pump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



6 DIAGRAMS AND PARTS LIST

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

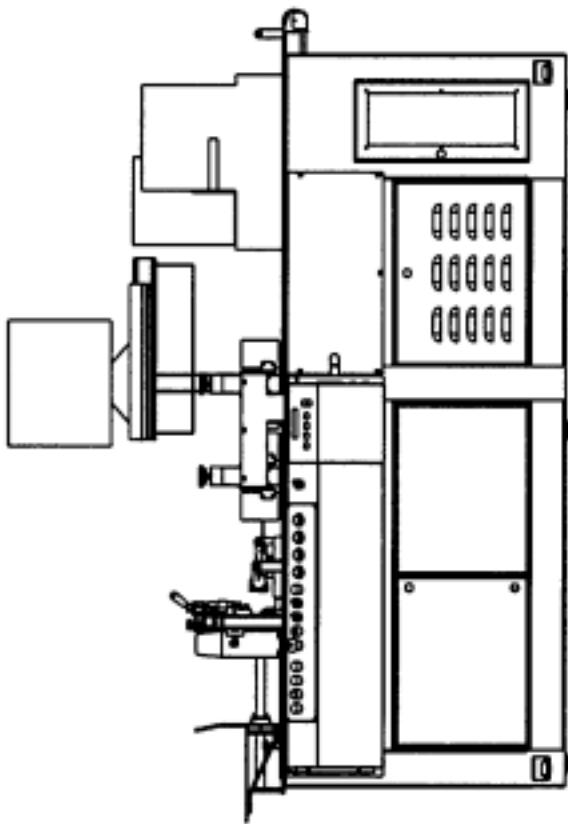
ITEM QTY	PART #	DESCRIPTION
1	1	532152-02 ASSY, MONITOR STAND W/ 2 TRAY
2	1	533708-01 ASSY, 215 DRYER MT
3	1	536470-02 ASSY, 215 MOD. + 36 FRAMES
4	1	538288-01 ASSY, CABINET & COVERS
5	1	AIRDUCT DUCT, EXTENDABLE ALUM 6 IN.



REV NO	DATE	DESCRIPTION	LCN NO	BY

REV'D	WHERE USED

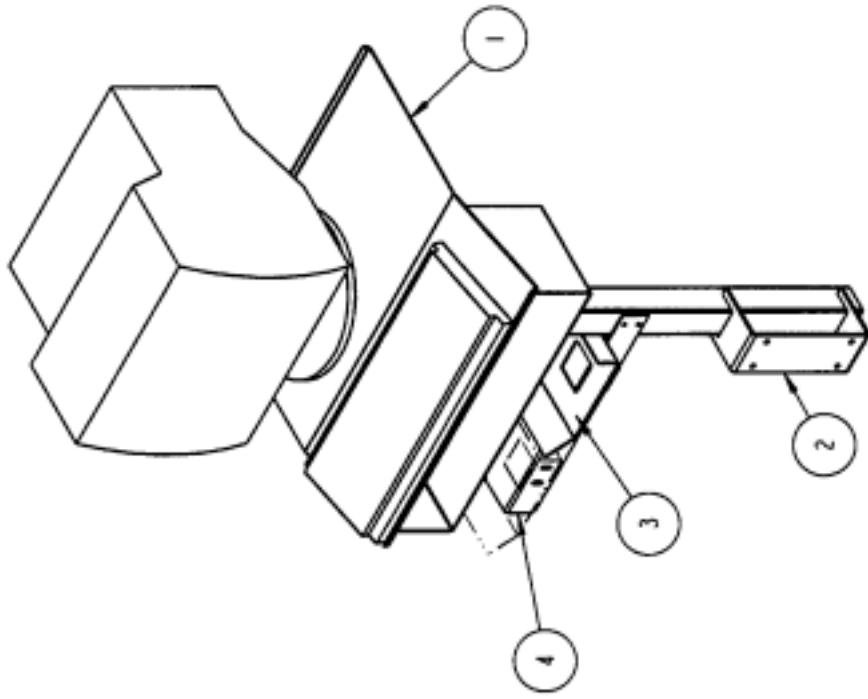
PROHIBITANT AND CONFIDENTIAL NO PROJECTION ON THIS DRAWING MAY BE CANCELLED OR FORWARDED EXCEPT BY WRITTEN PERMISSION OF KIRK-RUDY INC. KENNESAW, GA 30046 USA	KR KIRK - RUDY INC. KENNESAW, GEORGIA
DATE:	ASSY, KR215B



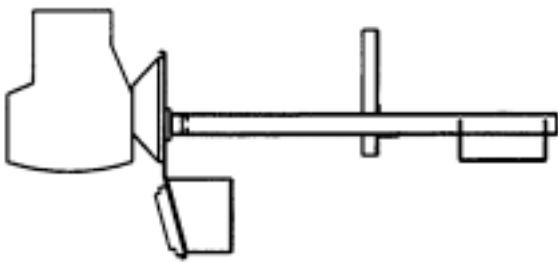
ITEM #	SCALE	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	MATERIAL	REVISION	REVISION
TJG	0 . 050	.00 .005 .005 .005	XXX		
CHECKED BY:	DATE:	.01 .005 .005 .005	XXX		
TRACED BY:	MASTER	ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK (Do Dimensions Only)	XXX	TOF 2	215B

REV NO	DATE	DESCRIPTION	ECON NO	BY
93.919				
<input checked="" type="checkbox"/> 100% <input type="checkbox"/> 50% <input type="checkbox"/> 25% <input type="checkbox"/> 10% <input type="checkbox"/> 5% <input type="checkbox"/> 2% <input type="checkbox"/> 1%				
<input checked="" type="checkbox"/> ASSEMBLED <input type="checkbox"/> EXPLODED <input type="checkbox"/> PARTS LIST <input type="checkbox"/> BILL OF MATERIALS <input type="checkbox"/> DRAWING				
KIRK - RUDY, INC. KR KENNESEE, GEORGIA				
PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE QUOTED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC. Kennesaw, GA 30044 USA				
DRAWN BY: TJG SCALE: 0 . 050 DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED .03 .005 .005 .00 .001 .001				
CHECKED BY: 17-Jan-00 DATE: XXX FILE NUMBER: SP81400				
TRACED BY: M DATE: XXX FILE NUMBER: 20F2				
DRAWING #: 215B				

ITEM QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BT
1	1	532155-02 ASSY, MONITOR PIVOT	1	25-JUL-03	ASMBL 536932-01 & 538095-01	6569	A10
2	1	536586-01 WLDMT, MONITOR STAND					
3	2	536932-01 SHELF, INKCARTRIDGE HP					
4	1	538095-01 BRACKET, INK TRAY MTG SHORT					



SCALE 0.060



NOTES:
1. OPTIONAL FOUR (4) TRAY SYSTEM AVAILABLE.

DRAWING NO:		SCALE	DIMENSIONAL TOLERANCES			MATERIAL	NOTED	THIN WALL PROJECTION	PROPRIETARY AND CONFIDENTIAL
CHANGER NO:	TJG	0 . 100	UNLESS OTHERWISE NOTED					+/- .010	
DATE:	27-Aug-99		.01	.005	.005				
TRACER NO:	MASTER		NOTES: REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE MOLDED ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE, WORK TO DIMENSIONS ONLY				NONE		
			ITEM:	NOTED	ITEM:	NOTED	ITEM:	NOTED	ITEM:

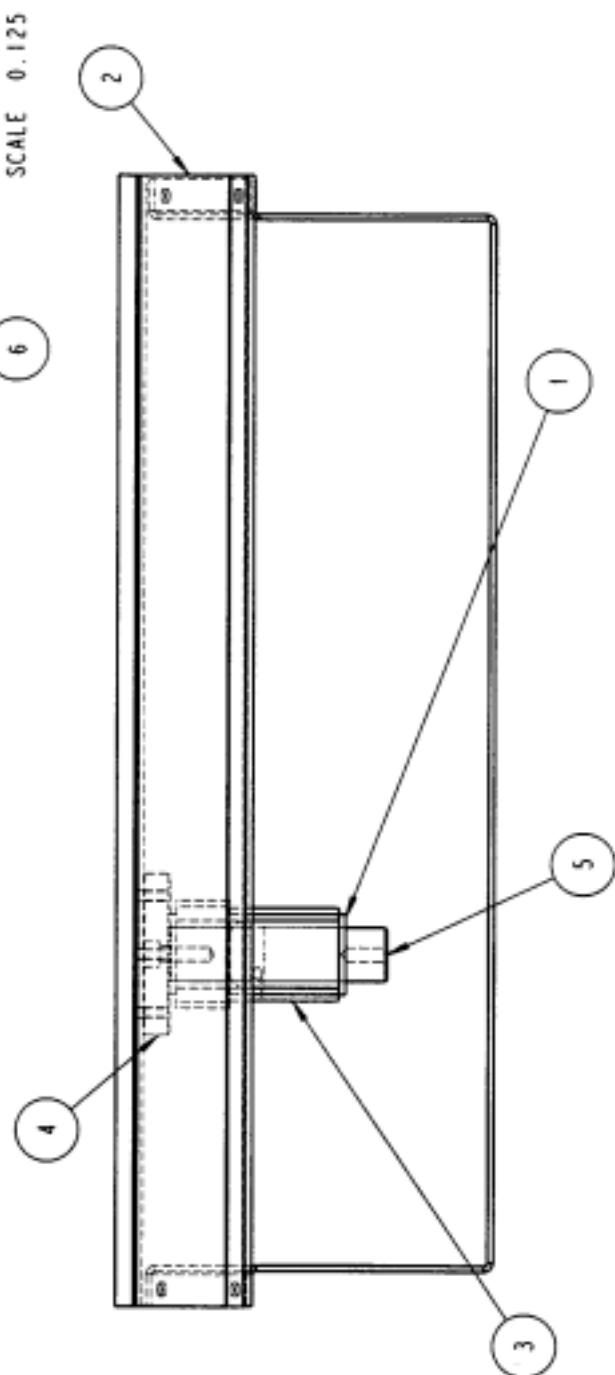
I	SPT76500
REQ'D	WHERE USED



KIRK - RUDY INC.
KENNESAW, GEORGIA

532152-02

ITEM QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECON NO	BY
1	2	100338 BUSHING, FLI. 0001DI. 250001. 5001LG					
2	1	53228-02 TRAY, KEYBOARD					
3	1	532154-01 HOUSING, PIVOT					
4	1	532157-01 SPACER, PIVOT					
5	1	532467-01 SHAFT, DRYER PIVOT					
6	1	538343-01 TRAY, MOUSE PAD					



1	532152-02
NO/D	WHILE USED
KR	KIRK - RUDY, INC. KENNESAW, GEORGIA
SP76500	ASSY, MONITOR PIVOT
10F1	DRAWING 1

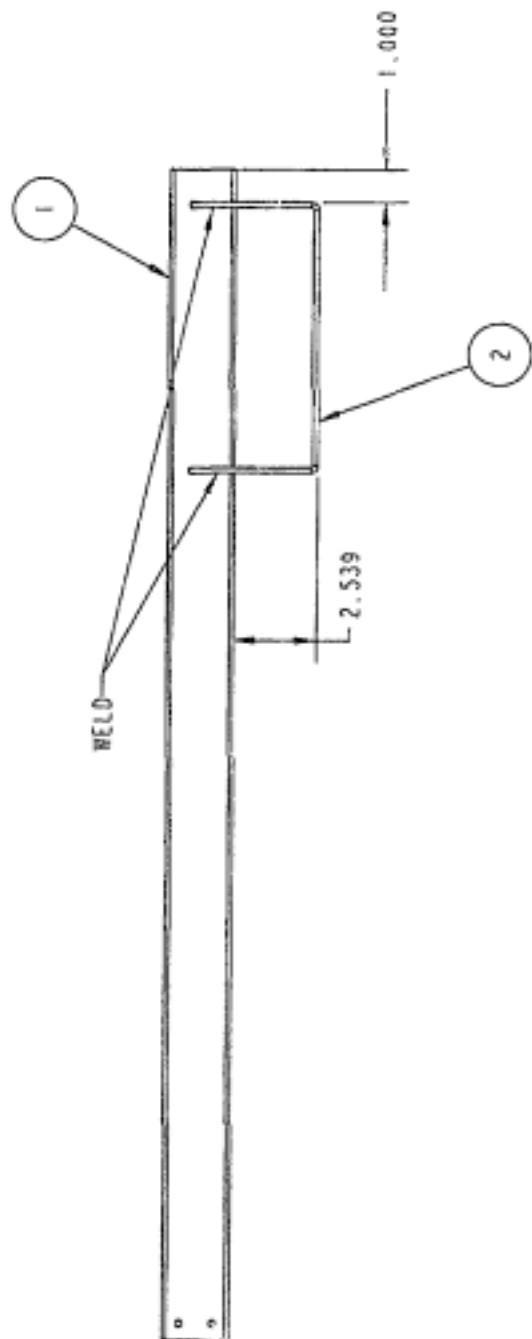
ITEM NO.	SCALE	NOTED	NOTES AND RESTRICTIONS
CREATED BY:			PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE COPIED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC. KENNESAW, GA. 30044 USA
DATE:	0 . 312	NOTED	ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
MAKER:	26 - Aug - 99	NOTED	REMOVED ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED
MAKER:	M	NOTED	ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE. WORK TO DIMENSIONS ONLY

536586-01

536586-01

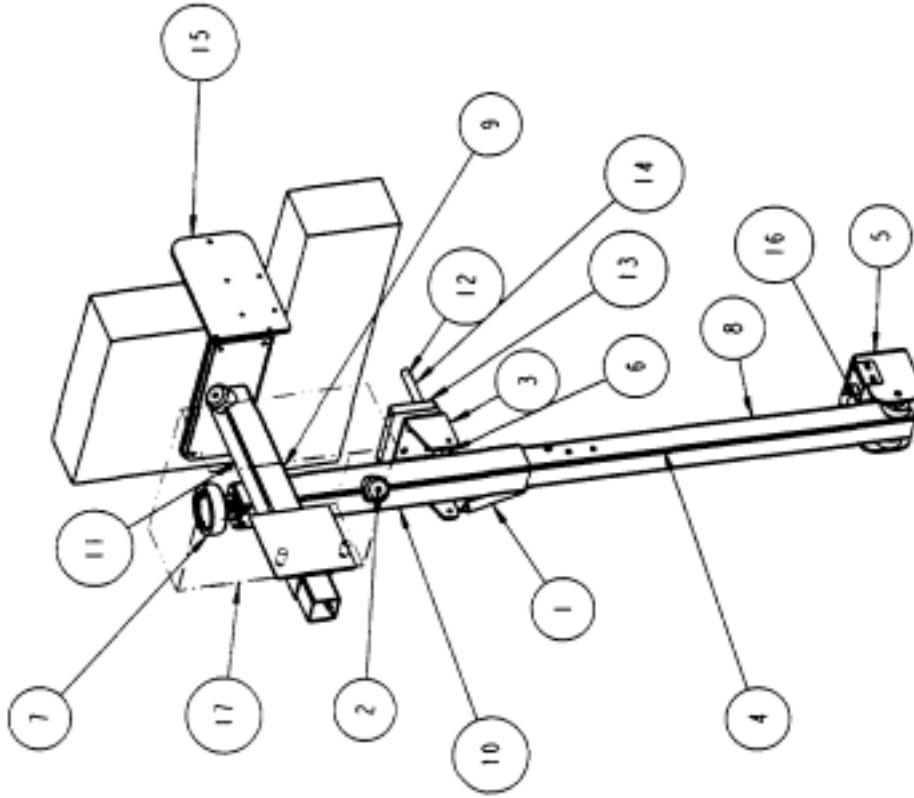
ITEM #	CITY	PART #	DESCRIPTION
1	1	532153-01	TUBING, VERTICAL
2	1	532164-01	BRACKET, INTERFACE

BLV NO	DATE	DESCRIPTION	LCN NO	BY
--------	------	-------------	--------	----



DRAWN BY:		SCALE	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	NOTES	THIN ALUM. PREDRACTION	PROJECTION MATERIAL NOT DRAWN OR QUOTED IN REPRODUCED PRINTS. PRINTED BY KIRK-RUDY, INC. AT KENNESAW, GA. 30046.	KIRK - RUDY, INC. KENNESAW, GEORGIA	NO. 0 WHERE USED
CHECKED BY:	TJG	0 . 188	.08 .045	.002 .13				
RECHECKED BY:		BASIC						
MAILED BY:		27 - AUG - 99						

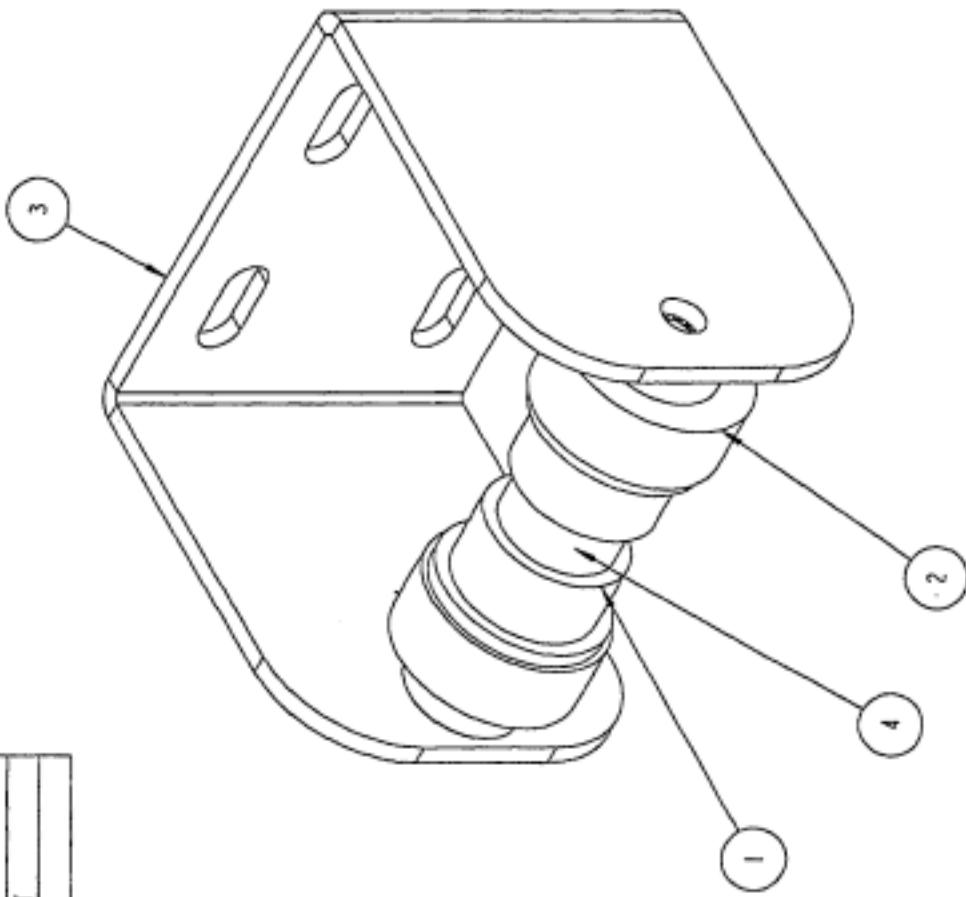
ITEM QTY	PART #	DESCRIPTION
1	190804	GAS SPRING
2	532129-01	BLOCK, LOCK DOWN
3	1	532452-01 BRACKET, GAS SHOCK
4	1	532453-01 GAS SHOCK LINKAGE
5	1	532466-01 ASSY, DRYER ARM PIVOT
6	1	532468-01 SHAFT, DRYER STOP
7	1	532736-01 ASSY, SCREW HOUSING
8	1	532738-01 WELD, TUBING DRYER STAND
9	1	532739-02 WELD, TUBING SLIDE
10	1	532741-01 TUBING, BASE
11	1	532744-02 WELD, TUBING IN/OUT ADJ.
12	1	533190-01 ASSY, STOPPER MOUNT BRACKET
13	1	533191-01 PLATE, STOPPER MOUNT
14	1	533192-01 SHAFT, SPACER
15	1	533711-01 ASSY, DRYER T-BRACKETS
16	1	533714-01 ASSY, SWITCH
17	1	RE54560C DRYER, CONTROL BOX 4560



NOTE:
1. SHOWN WITH RESEARCH DRYER 4560-16HV

REF ID:	SCALE	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	NOTED	ITEM AND PART NUMBER	REASON AND PART NUMBER	REF ID:	ITEM AND PART NUMBER
1	T JG	0 .100		4 - May - 98	REMOVE ALL RINGS AND SHARP EDGES UNLESS OTHERWISE NOTED	1	KIRK - RUDY, INC. KENNESAW, GEORGIA
CHIEFED BY:	DATE				NEAR THREADS	2	215 DRYER MT
INSTRUMENT #:	INITIALS				NONE	3	533708-01

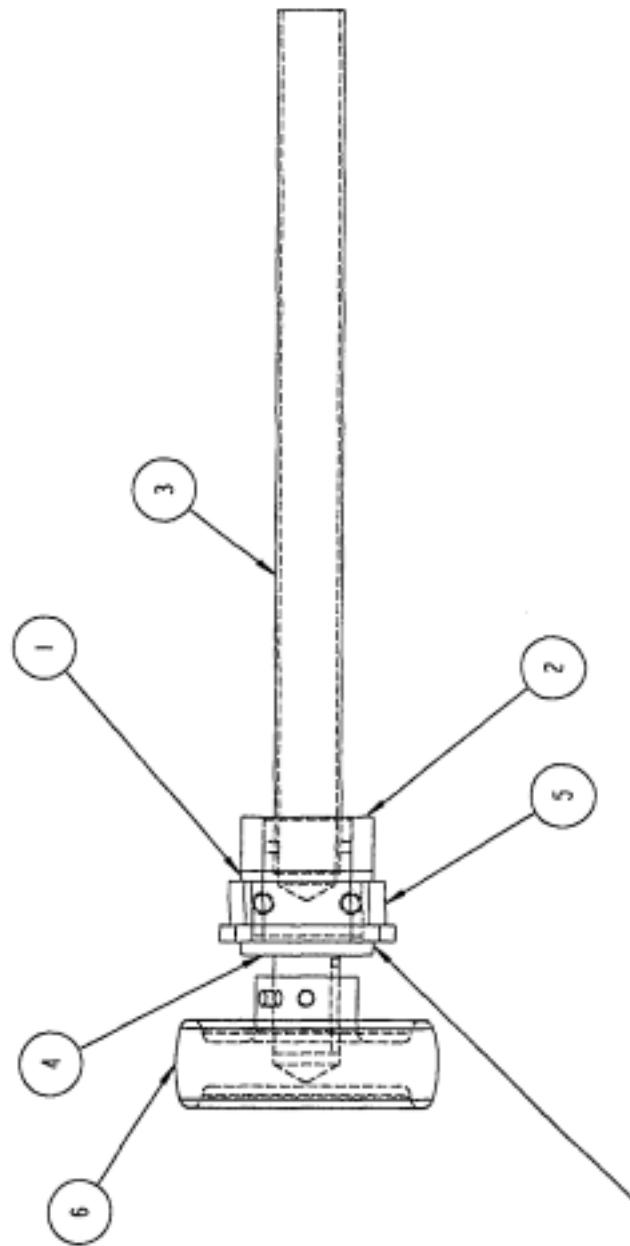
ITEM QTY	PART #	DESCRIPTION
1 2	100326	BUSHING, FLANGE 1.000
2 2	102212	COLLAR 1.000
3 1	532465-01	BRACKET, DRYER ARM PIVOT
4 1	532467-01	SHAFT, DRYER PIVOT



REF ID:	532466-01
REF ID:	532466-01
REF ID:	KR KENNEAW, GEORGIA
REF ID:	KIRK - RUDY INC.
REF ID:	PROPRIETARY AND CONFIDENTIAL NOT TO BE COPIED OR REPRODUCED IN WHOLE OR IN PART EXCEPT AS EXPRESSLY AUTHORIZED IN WRITING BY KIRK-RUDY INC. KENNEAW, GA 30144 USA
REF ID:	TIME: SP 62500
REF ID:	ASSY, DRYER ARM PIVOT
REF ID:	CHASER #:
REF ID:	MAKER #:
REF ID:	532466-01

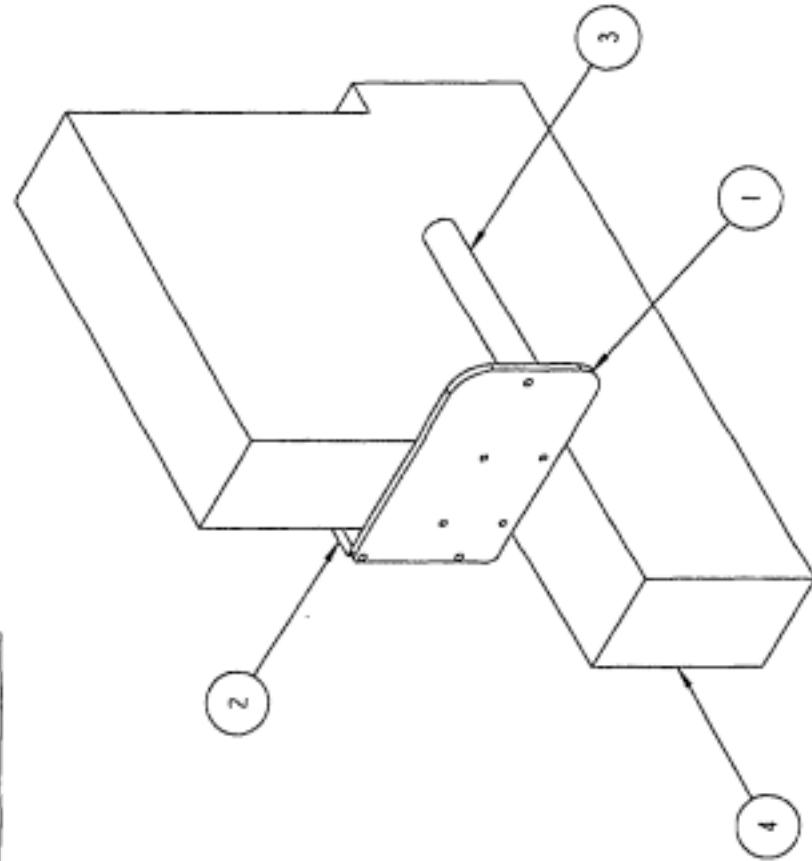
KEY NO	DATE	DESCRIPTION	ICN NO	BT

ITEM QTY	PART #	DESCRIPTION
1	100326	BUSHING, FLANGE 1.000
2	102217	COLLAR 1.000
3	503734	THREADED ROD, 3/4-10
4	503736	HUB
5	532737-01	BLOCK, ROD MOUNT
6	533006-01	HANDWHEEL, W/ KR LOGO



REV NO:	DATE:	DESCRIPTION:	ECN NO:	BT
1	10-JUN-98	REPLACED 532737-01 WITH 533006-01	5343	WT
STG's WHERE USED				
1 532734-01				
KR KIRK - RUDY, INC. KENNESAW, GEORGIA				
PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE QUOTED OR REPRODUCED IN ANY FORM WITHOUT EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC. KENNESAW, GA 30046 USA				
ITEM:	SP 62500	NOTE:	ASSY, SCREW HOUSING	
DRAWN BY:	TJG	SCALE:	NOTED	DRAWN BY:
DESIGNED BY:	20-Feb-98	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	NOTED	DESIGNED BY:
MASTER:	M	.38 .175 .045 .005	NOTED	MASTER:
REMOVED ALL GURGS AND SHARP EDGES UNLESS OTHERWISE NOTED				
ALL DIMENSIONS ARE IN INCHES. EXCEPT WHERE SPECIFIED TO DIMENSIONS ONLY				

ITEM QTY	PART #	DESCRIPTION
1	1	533709-01 PLATE, T-BRACKET
2	1	533710-01 PLATE, T-BRACKET
3	1	533712-01 SHAFT, DRYER HANDLE
4	1	RES4560-16HV DRYER, RESEARCH 4560-16HV

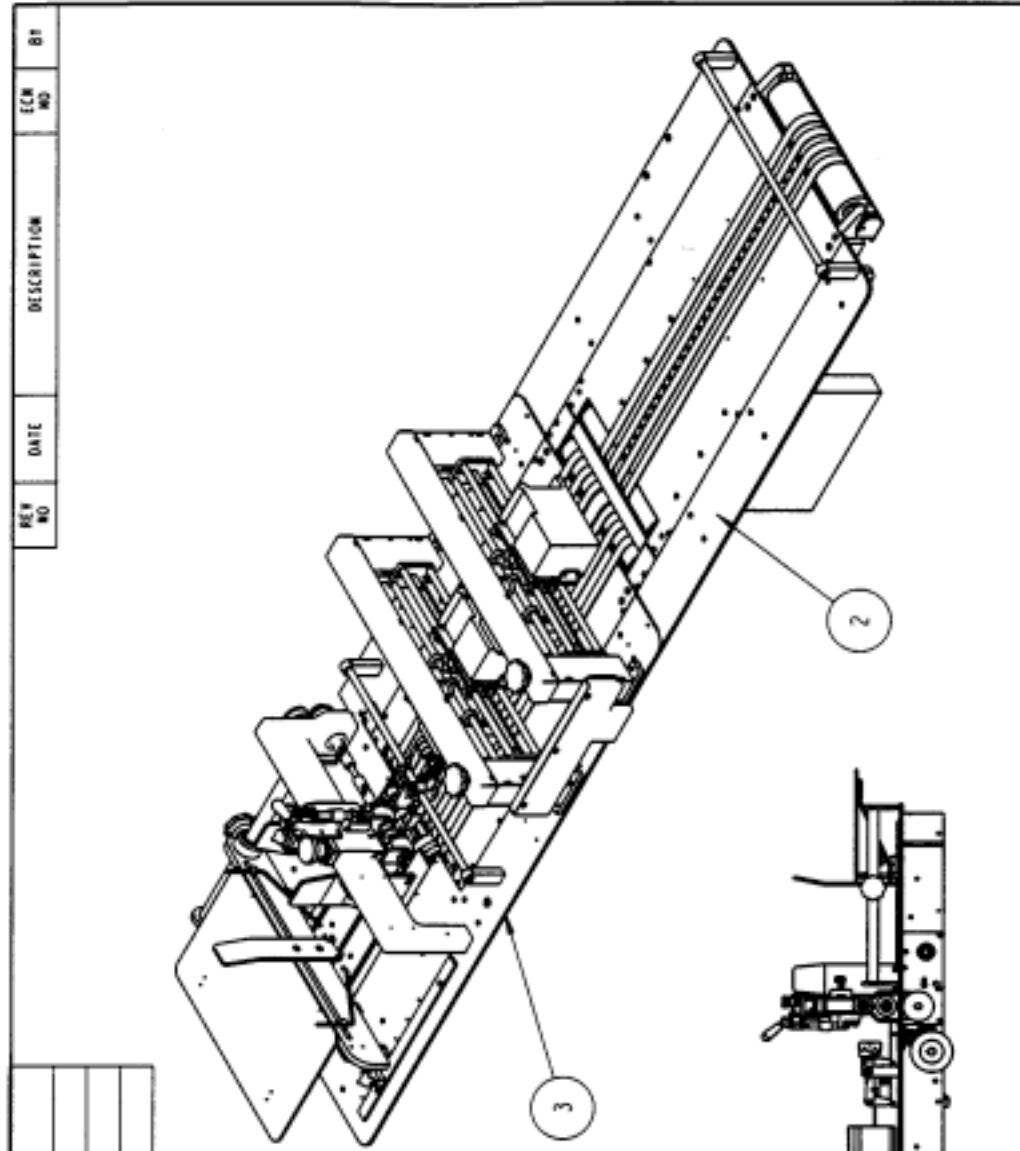


REV NO	DATE	DESCRIPTION	LCN NO	BY
1	11-SEP-86	REMOVED RES4560-16HV WAS MODIFIED	52113	WT

1	533711-01	REG'D WHERE USED
---	-----------	------------------

PRINTED BY:	SCALE:	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	NOTED	THREE 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. KIRK-RUDY, INC. KENNESAW, GEORGIA
DRAWN BY:	DATE:	.11 .075 .063 .035	NOTE: MEAN		KIRK - RUDY, INC. KENNESAW, GEORGIA
VERIFIED BY:	4-May-98	NONE	SP 65600	PRINTED:	533711-01
MAILED BY:	M	NOTED	SHEET NO. 1 OF 1	REVISION:	533711-01

ITEM QTY	PART #	DESCRIPTION
1	1	108940-3 BELT, TIMING 420L075
2	1	536479-02 ASSY, 36IN FRAME EXT
3	1	536491-02 ASSY, FEEDER & FRAMES



SCALE 0.060

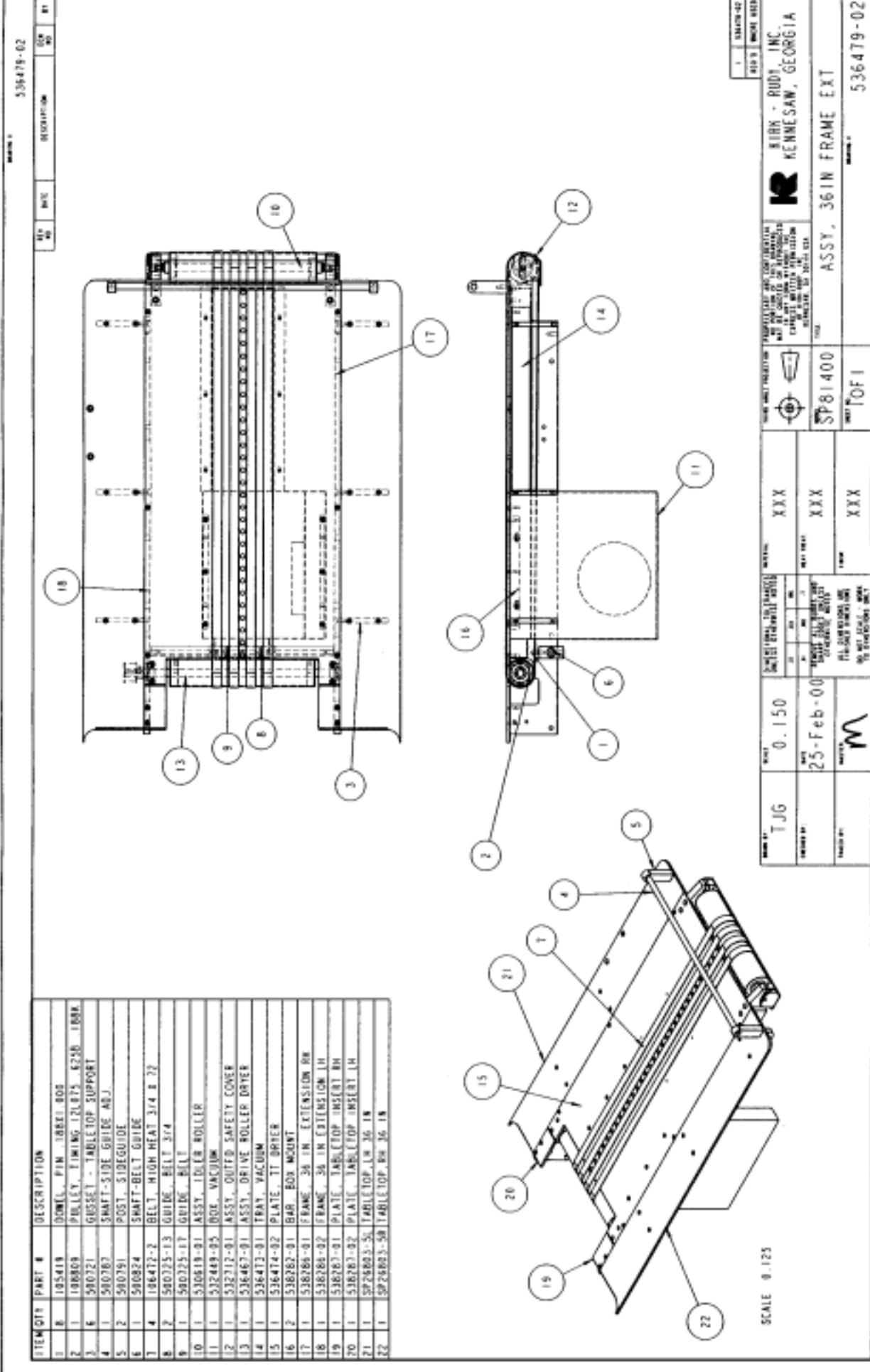
DRAWN BY:	SCALE	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	MATERIAL	PROPS/ADL PRINTATION	1	215
T JG	0 . 080		N / A		KIRK - RUDY, INC.	
CHECKED BY:	DATE	IN	IN	IN	REQ'D	WIRE USED
17-Jan-00	IN	IN	IN		KENNESEAW, GEORGIA	
TRACED BY:	MASTER	IN	IN	IN	REQ'D	WIRE USED
M					ASSY, 215 MOD. + 36 FRAMES	

NOTES:
1. SET UP FOR DUAL MOTOR 215

PROPRIETARY AND CONFIDENTIAL
NOT FOR PURCHASE OR REPRODUCED
IN ANY FORM WITHOUT THE EXPRESS
WRITTEN PERMISSION
OF KIRK-RUDY, INC.
KENNESEAW, GA 30044 USA

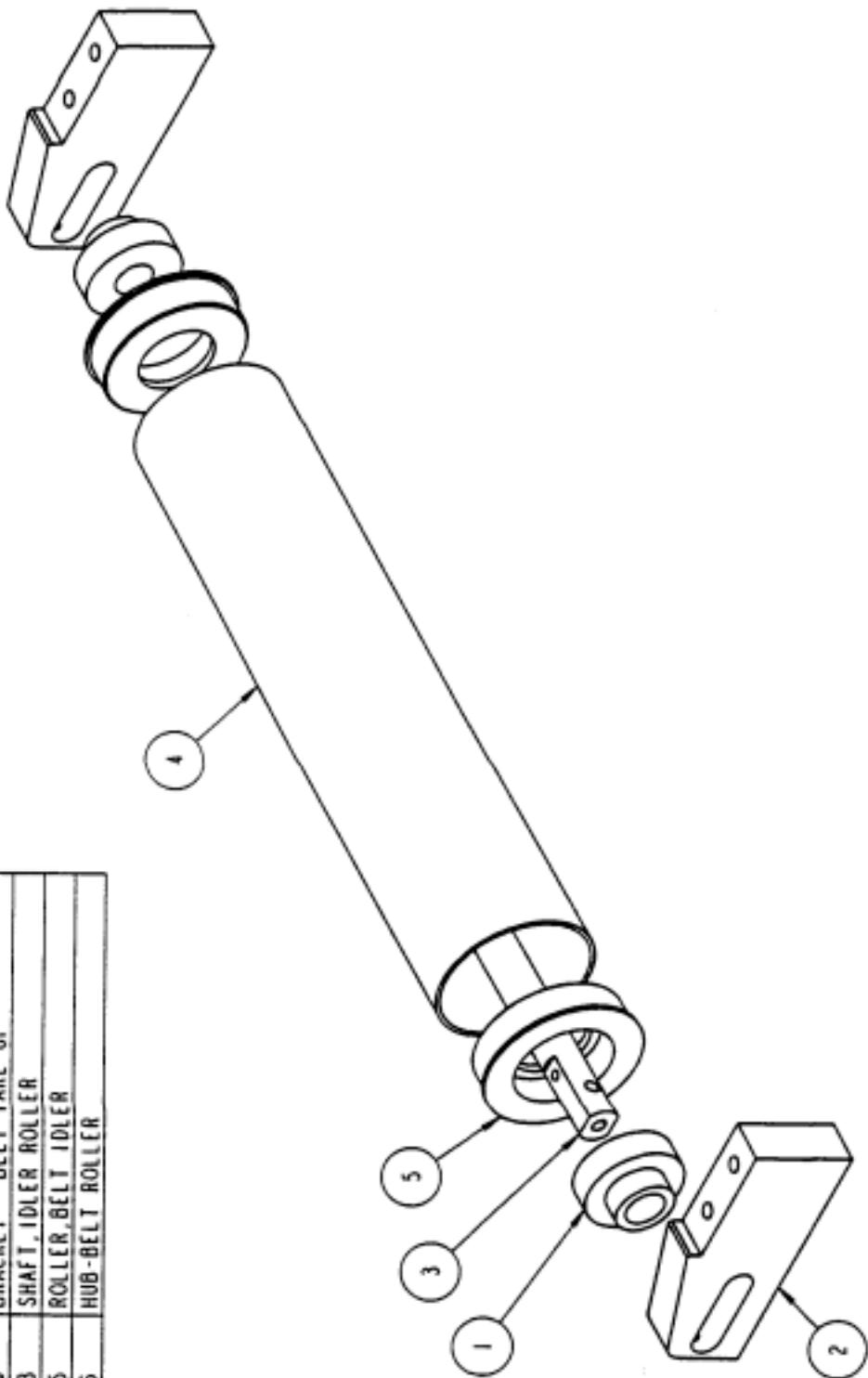
SP81400

536470-02



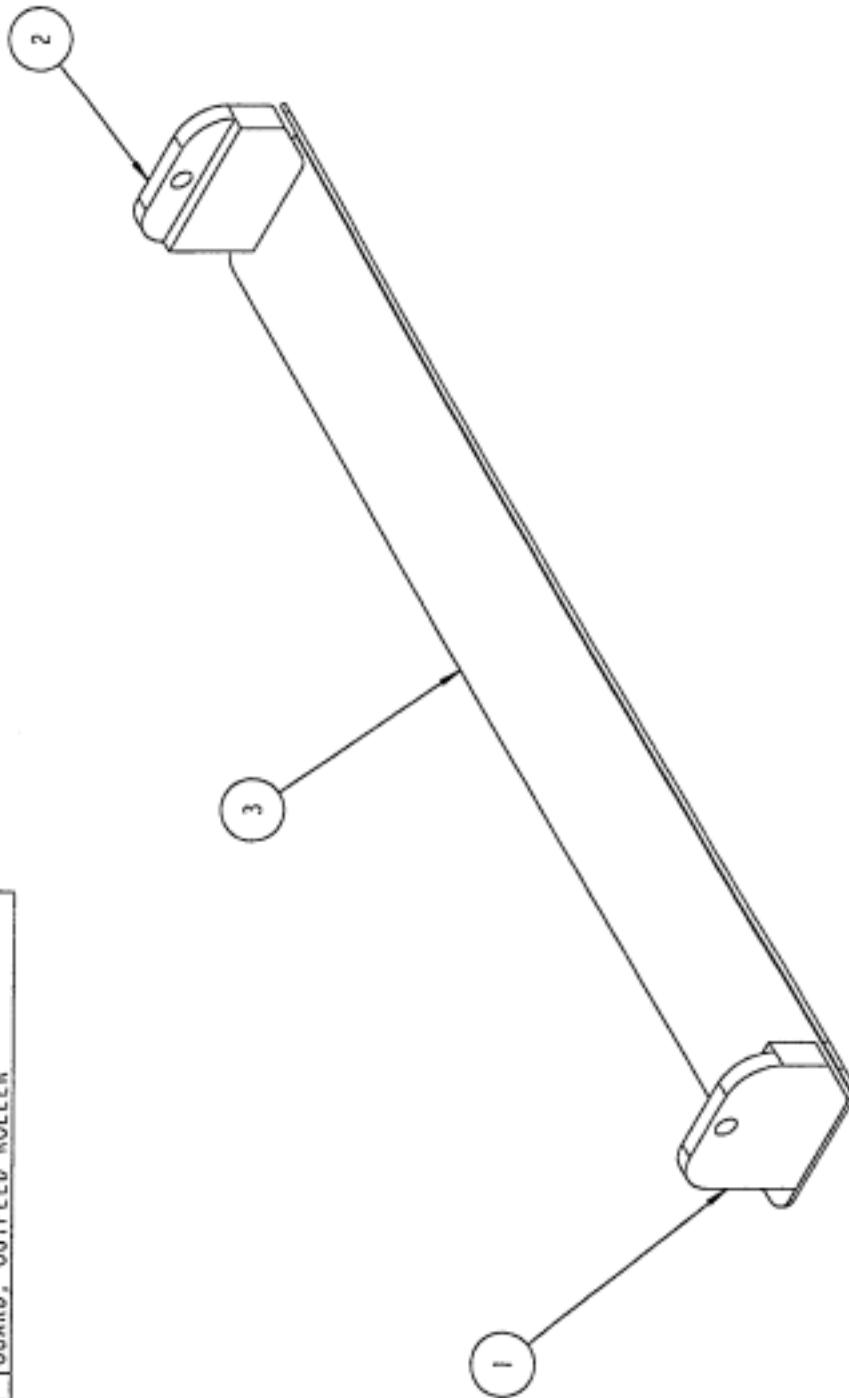
ITEM QTY	PART #	DESCRIPTION
1	2	103804 BEARING, HUB .625
2	2	500716 BRACKET - BELT TAKE-UP
3	1	500823 SHAFT, IDLER ROLLER
4	1	500835 ROLLER, BELT IDLER
5	2	500836 HUB-BELT ROLLER

ITEM	KEY NO.	DATE	DESCRIPTION	ITEM NO.	BY
				1	SP21199 REQ'D WHERE USED



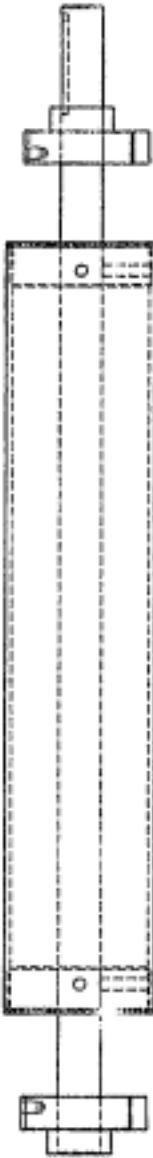
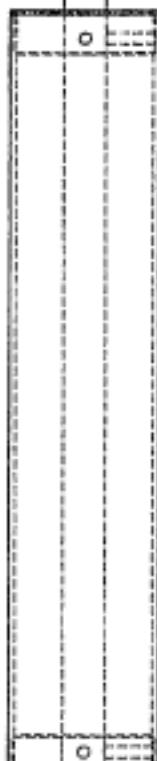
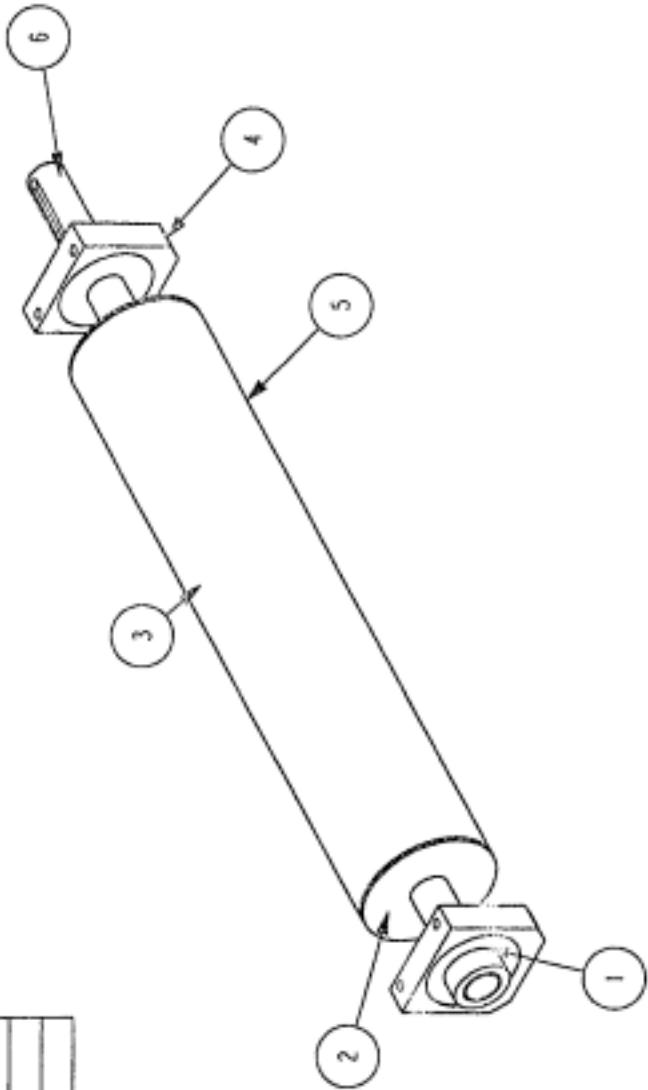
ITEM NO.	SCALE	DIMENSION FOR DRAWINGS UNLESS OTHERWISE NOTED	MATERIAL	LEADSHEET NUMBER	PROPRIETARY AND CONFIDENTIAL NO PART OF THIS DRAWING MAY BE COPIED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC. KENNESAW, GA 30046 USA
A KEY	0 .410	N / A	N / A	SP71700	KIRK - RUDY, INC. KENNESAW, GEORGIA
REFL. NO.	01	Mar - 99	N / A	1	PRINTED: 10-10-01
REMARKS:			N / A	1	MATING 1
REMARKS:			N / A	1	530619-01

ITEM QTY	PART #	DESCRIPTION
1	1	530816-01 BRKT. RH OUTFD RLLR GRD
2	1	530817-01 BRKT. LH OUTFD ROLLR GRD
3	1	530818-01 GUARD. OUTFEED ROLLER



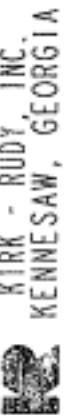
REV'D:	T JG	SCALE:	0 . 500	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	NOTED	NOTES:	PROPRIETARY AND CONFIDENTIAL. NO PORTION OF THIS DRAWING MAY BE REPRODUCED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY INC., KENNESAW, GA 30044 USA.
CREATED BY:	DATE:		.45	.033	.005	WEAR SPOT:	KIRK - RUDY INC. KENNESAW, GEORGIA
REVIEWED BY:	DATE:		6-Feb-98	ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED		FROM:	ASSY, OUTFD SAFETY COVER
APPROVED BY:	DATE:		MARSHAL	ALL DIMENSIONS ARE FINALIZED DIMENSIONS DO NOT SCALE. WORK TO DIMENSIONS ONLY		SHEET NO.:	532712-01
PRINTING:							

ITEM QTY	PART #	DESCRIPTION
1	2	103804 BEARING - HUB
2	2	500839 HUB-BELT DRIVE
3	1	500742-4 ROLLER - TUBE BELT DRIVE
4	2	500819-1 BLOCK-BEARING
5	1	530676-01 ROLLER ASY
6	1	534181-02 SHAFT, FRONT ROLLER



DRAWN BY:	SCALE:	DIMENSIONAL TOL /2ARC/LS UNLESS OTHERWISE NOTED	MATERIAL:	REV:	REMOVED ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED	ALL DIMENSIONS ARE IN INCHES DO NOT SCALE - REFER TO DIMENSIONS Q.C.!	PRINTED BY:	DATE:	ITEM NO.:	QTY:	REV'D:	PRINT USED
T JG	0 . 375	.03 .016 .005 .03	N/A						SP76500	ASSY , DRIVE ROLLER DRYER		536467-01
DESIGNER #: 27 - Aug - 99	MAKER:		N/A									
TECHNICIAN #: M	MAKER:		N/A									

1 536467-01
REV'D: PRINT USED

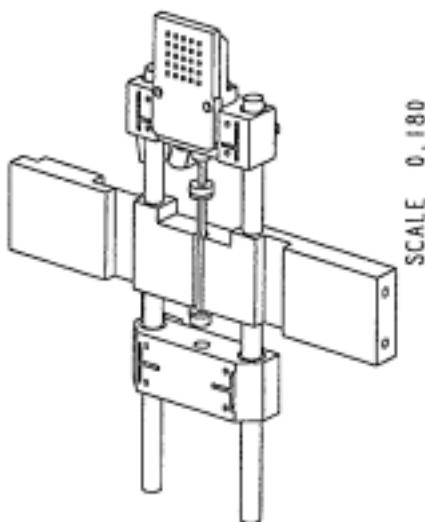
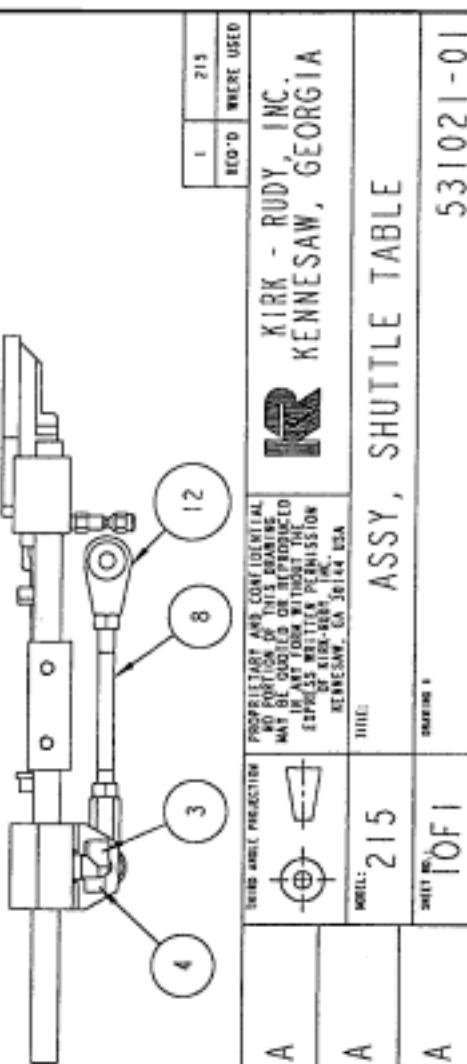
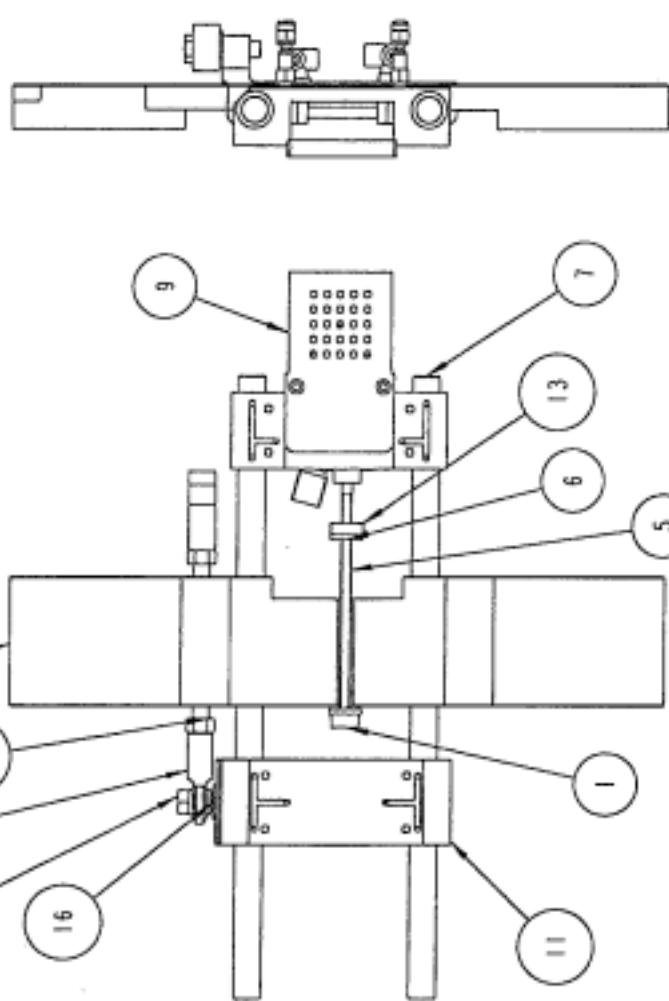


KIRK - RUDY INC.

KENNEBUNK, GEORGIA

ITEM #	PART #	DESCRIPTION	REV M	DATE ISSUED	REVISION NO.
1	109805	BELT, TIMING - HUB			
2	109839	PULLEY, TIMING 16075 .7500 .188K			
3	2	PULLEY, TIMING 19075 .7500 .188K			
4	1	PULLEY, TIMING D1621-050			
5	1	PULLEY, TIMING 285815 .7500 .188K			
6	1	PULLEY 28X1037 .6250 MM			
7	1	109848 PULLEY 24X1032 .3158 MM			
8	1	500175 TABLETOP - NARROW SHUTTLE			
9	4	500175 GUIDE - BELT			
10	3	500824 SHAFT - BELT GUIDE			
11	1	500825 SHAFT - SPROCKET DRIVE			
12	1	508820 SHAFT, GEARBOX			
13	1	105400-1 V-PULLEY			
14	1	108946-2 BELT, TIMING 361015			
15	1	109815-1 BELT, TIMING 1601037			
16	1	109724-3 BELT, TIMING 144-5H-15			
17	2	109725-4 BELT, TIMING 5-5W-15			
18	1	500102-48 TABLETOP AIR SIDE			
19	1	500102-91 TABLETOP L/H SIDE			
20	1	500125-7 GUIDE, BELT			
21	1	500131-1 CHANNEL, JACKSHAFT SUPPORT			
22	1	510628-1 BLOCK, BEARING			
23	1	531021-01 ASSY, SHUTTLE TABLE			
24	1	511022-03 ASSY, LOWER FEED BELT DR			
25	1	531495-01 ASSY, JOGGER TABLE			
26	1	536178-02 ASSY, BELT DRIVE PLATE			
27	1	536468-02 ASSY, CENTER TABLE TOP			
28	1	536475-01 ASSY, 215 FRAME RH			
29	1	536476-01 ASSY, 215 FRAME LH			
30	1	536497-01 BAR, CABLE COVER			
31	1	536594-01 COVER, CABLE FRONT			
32	1	536535-01 COVER, CABLE FRONT			
33	1	531549-01 ASSY, BRIDGE TIMING BELT			
34	1	537658-01 BAR, PLATE SPLICE			
35	1	537659-01 PLATE, TABLETOP INSERT			
36	2	530169-01 ASSY, DRIVE IMJET BRACKET			
37	1	538119-01 BRACKET, TACH MOUNT			
38	1	538188-01 ASSY, SKIDBAR SENSOR			
39	1	BRYCE ENCODER IMK JET			
		SCALE 0.060			
		KIRK-RUDY INC. KENNESAW, GEORGIA			
		SP81400 ASSY, FEEDER & FRAME S			
		536491-02			

ITEM QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BT
1	2	102225 COLLAR .250					
2	1	103500 BEARING - ROD END					
3	1	109523 JUNCTION, 2-WAY					
4	1	109524 JUNCTION, 3-WAY					
5	1	500735 ROD - PUSH					
6	2	500737 WASHER - BUMPER					
7	2	500741 SHAFT - FEEDER					
8	1	500749 ROD - FEEDER SLIDE					
9	1	500708A ASSY. VACUUM BODY					
10	-	500710-1 BRACKET - FEEDER SUPPORT					
11	-	500728A ASSY. BUSHING BLOCK					
12	-	500751A ASSY, BEARING BLOCK					
13	1	530253-01 RING					
14	1	RHB082 HEX HEAD BOLT					
15	2	RHN012 HEX NUT					
16	1	WA013 WASHER					



SCALE 0.180

MADE BY:	TVK	SCALE:	0 . 250	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	MATERIAL:	N/A	
CHECKED BY:		DATE:	05-May-98	-X1 -X2 -X3 -X4 -X5 -X6 -X7	HEAVY HEAVY	N/A	
TRACED BY:		MASTER:	M	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED	ALL DIMENSIONS ARE FINISHED DIMENSIONS NO MWT SCALE - WORK TO OVERSTOCKS ONLY	N/A	

REQ'D WHERE USED

1 213

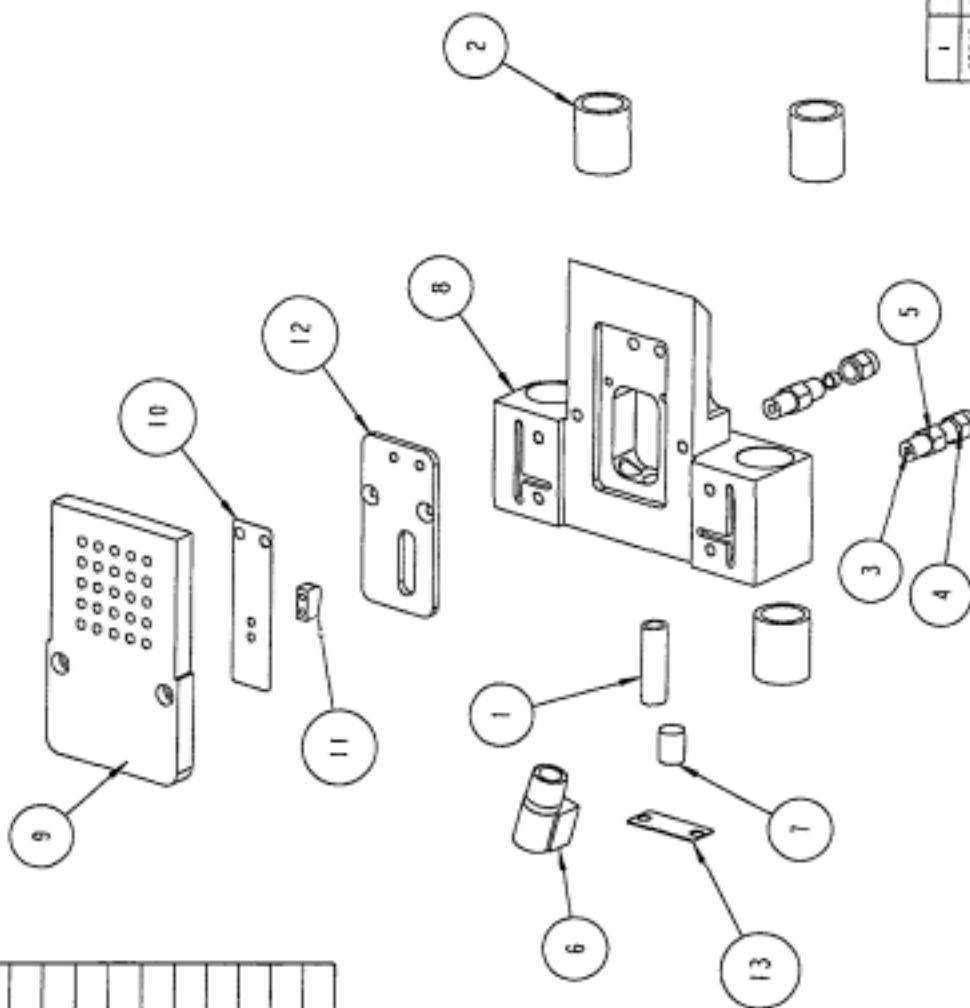
KIRK - RUDY, INC.

KENNESAW, GEORGIA

ASSY, SHUTTLE TABLE

531021-01

ITEM #	PART #	DESCRIPTION
1	100131	BUSHING, SL.250ID.375OD1.250LG
2	4 100145	BUSHING, SL.625ID.813OD1.000LG
3	2 109521	OIL METER UNIT
4	2 109528	NUT, COMPRESSION FEMALE
5	2 109537	SLEEVE, COMPRESSION
6	1 190606	FITTING - 90 DEG 1/4 NPT
7	1 190769	MAGNET, BUNTING
8	1 500708	BODY, VACUUM VALVE
9	1 500709	PLATE - VACUUM FEEDER
10	1 500738	SPRING - VALVE
11	1 500739	BLOCK - PUSHER
12	1 500740	PLATE - VACUUM
13	1 531155-01	PLATE, MAGNETIC



ITEM #:	SCALE:	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	MATERIAL:	REMARKS:	ITEM #:	SCALE:	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	MATERIAL:	REMARKS:
TVK	0 . 380	.005-.005	N/A		05 - May - 98	.005-.005	N/A	N/A	
EXCHANGER:	INCHES			HEAT TREAT:	MASTER:	INCHES			
TRACER #:									

REMARKS:
REMOVE ALL DURRS AND
SHARP EDGES UNLESS
OTHERWISE NOTED
ALL DIMENSIONS ARE
FINISHED ON ONE SURFACE
NO. NOT SCALE, WORK
TO SPECIFICATIONS ONLY

ITEM #:

MASTER: M

REMARKS:
ASSY, VACUUM BODY

ITEM #:

MASTER: 10F1

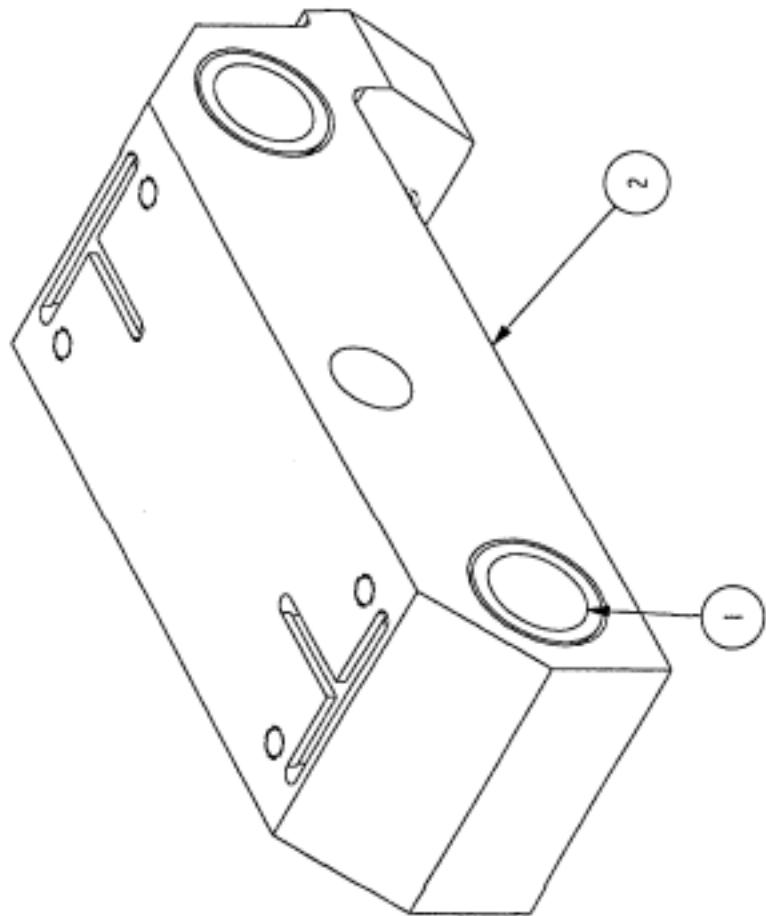
REMARKS:
DRAWING 4

ITEM #:

MASTER: 500708A

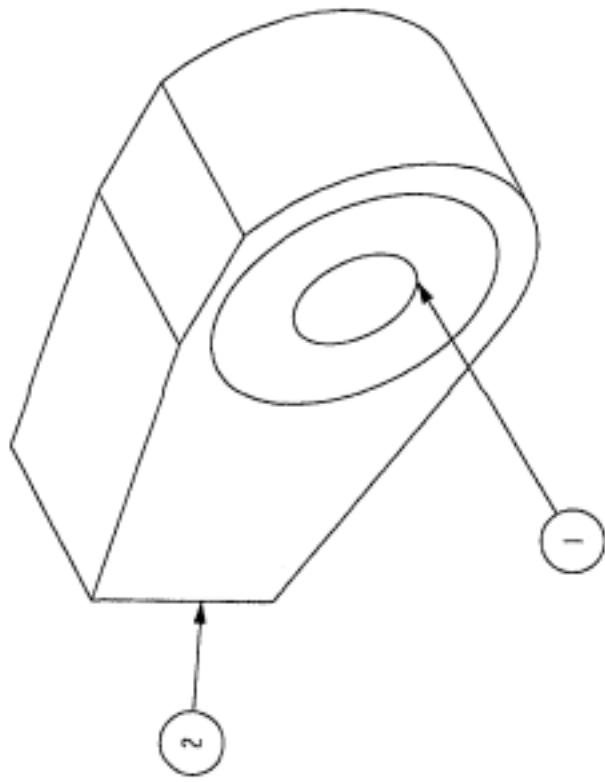
REMARKS:
NO. 500708-A

ITEM #	PART #	DESCRIPTION
1	4	100145 BUSHING, SL. 62510.8130D1.000LG
2	1	500728 BRACKET - FEEDER



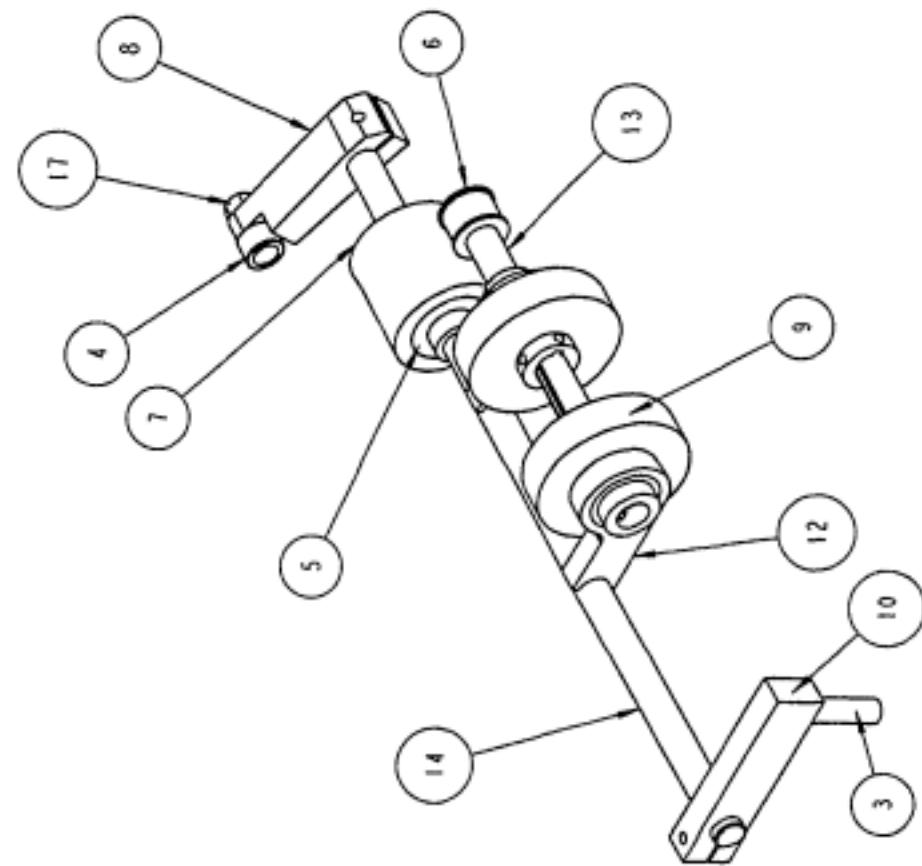
ITEM #:	SCALE:	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	NOTES:	THIRD ANGLE PROJECTION	REG'D. WHERE USED
MANUFACTURER:	MY	.000	N/A	KIRK - RUDY, INC. KIRK KENNEBUNK, GEORGIA	
CHIEF DRAWN BY:	DATE:	.000 .000 .000	MEAT THICK:		
REVIEWED BY:	MASTER:	.000 .000 .000	REMOVE ALL DRAFTS AND SHARP EDGES UNLESS OTHERWISE NOTED	215	ASSY, BUSHING BLOCK
			ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE. DRAW TO DIMENSIONS ONLY	POF 1	500728A

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



ITEM #:	REVISION:	DATE:	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	MATERIAL:	MANUFACTURER:	TECHNICAL DRAWING	REV'D	WEIGHT
ITEM #1:	MY	2 . 000	.005 .010 .005 .005 .005 .005 .005 .005 .005	N/A	N/A	1111	KIRK - RUDY, INC.	
CREATED BY:		09-Apr-99					KR	KENNESEAW, GEORGIA
TRACED BY:	MASTER	"M"	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED ALL DIMENSIONS ARE IN INCHES DO NOT SCALE - WORK TO DIMENSIONS ONLY	N/A	N/A	1111	ASSY, BEARING BLOCK	500751A

ITEM QTY	PART #	DESCRIPTION
1	2 102201	COLLAR .625
2	1 102221	COLLAR .625
3	1 102701	SPRING
4	1 103405	CAM FOLLOWER
5	2 103804	BEARING, HUB .625
6	1 109719	PULLEY, TIMING 165M15 .375B .125K
7	1 109722	PULLEY, TIMING 365M15 1.574 DIA
8	1 500734	LEVER - CAM
9	2 500746	ROLLER - BOTTOM FEED
10	1 500786	LEVER, SPRING
11	1 500729-2A-L	ASSY, ARM CRADLE LH
12	1 500729-2A-R	ASSY, ARM CRADLE RH
13	1 500748-5	SHAFT - FEEDER ROLLER
14	1 500827-1	SHAFT, SPRING LEVER
15	1 531683-01	WASHER, NO. 10 .75 OD .08TH
16	1 CSD265	
17	1 RHNO12	HEX NUT

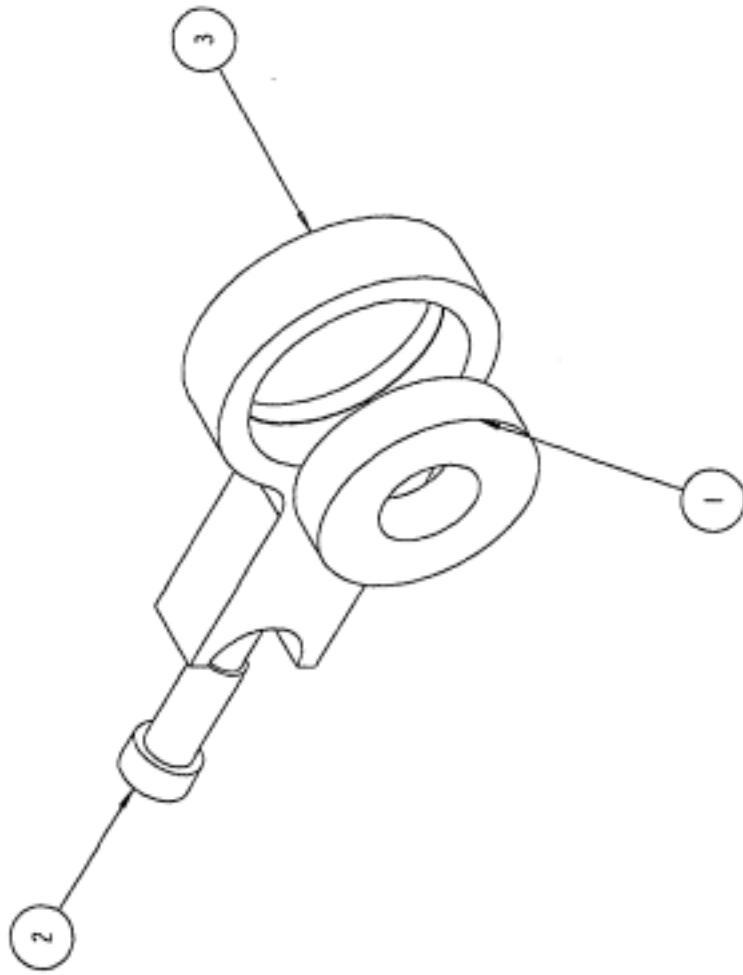


SCALE 0.125

DRAWN BY:	SUPERVISED BY:	SCALE:	NOTES:	PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE COPIED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC. KENNESAW, GA 30044-3316	PRINTED BY:	REV'D:	WHERE USED
T JG		0 .313	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	XXX	SP79000		KIRK - RUDY, INC. KENNESAW, GEORGIA
02-Nov-99	MASTER	.02	.025 .025 .025	XXX	MASTER	10F1	ASSY, LOWER FEED BELT DR.

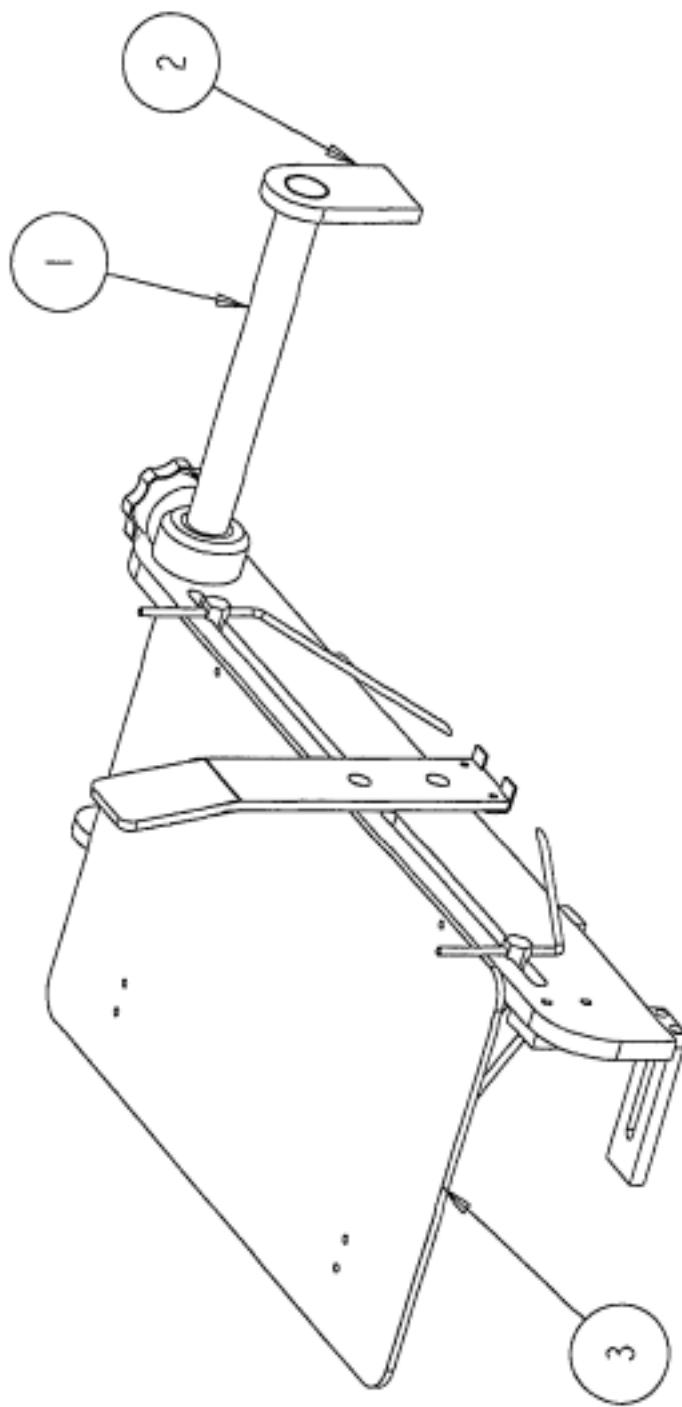
531022-03

ITEM QTY	PART #	DESCRIPTION
1	103110	BEARING, FLAT .625
2	107104	BOLT, SHOULDER 5/16X3/4
3	500729-2	ARM, CRADLE FEEDER



ITEM #:	SCALE:	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	MATERIAL:	NOTED	PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE COPIED OR DISCLOSED EXCEPT WITH WRITTEN PERMISSION KIRK-RUDY, INC. KENNESAW, GA 30144 USA	NOTE TO WHERE USED
CARTRIDGE #: 21 - Jan - 98	INCH	.000	.000	.000	-	532658-41
MASTER #: 500729-2	MASTER	M	REMANE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED	NONE	324	KIRK-RUDY, INC. KENNESAW, GA 30144 USA
TECHNICAL #: 500729-2A			ALL DIMENSIONS ARE FINISHED DIMENSIONS NO DRAFT SCALE, WORK TO DIMENSIONS ONLY	NOTED	NOTES: 1 OF 1	ASSY, ARM CRADLE FEEDER PRINTING *

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



KEY NO	DATE	DESCRIPTION	ECA #0	BT

1.000	215
REF'D	WHERE USED

KR KIRK-RUDY, INC.
KENNESAW, GEORGIA

THREE ANGLE PROJECTION
PROPRIETARY AND CONFIDENTIAL
NO PART OF THIS DRAWING MAY BE COPIED OR REPRODUCED
IN WHOLE OR IN PART, WHETHER BY MEANS OF
PHOTOSTATIC, ELECTRICAL, MECHANICAL
OR OTHER PROCESS, WITHOUT THE WRITTEN
CONSENT OF KIRK-RUDY, INC.
KENNESAW, GA 30044 USA



FILE:

215

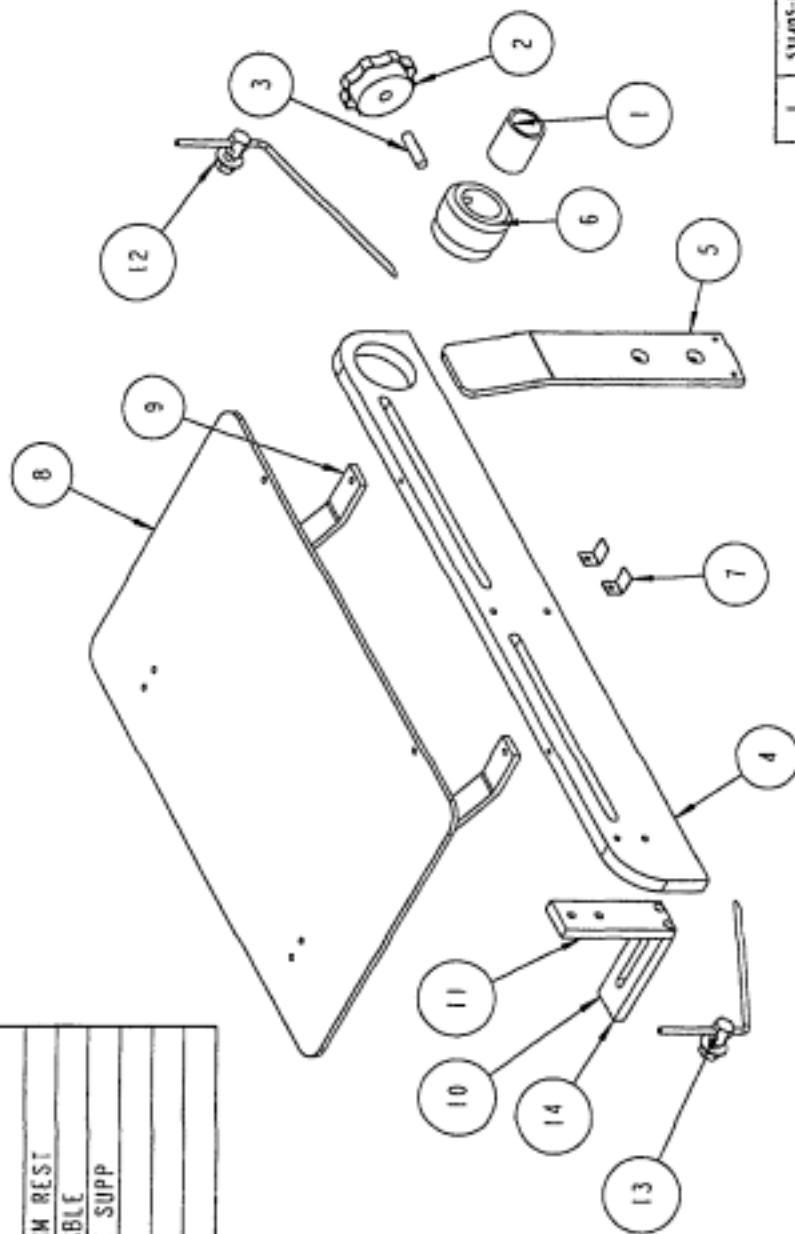
ASSY., JOGGER TABLE

STAMP #: 1

531405-01

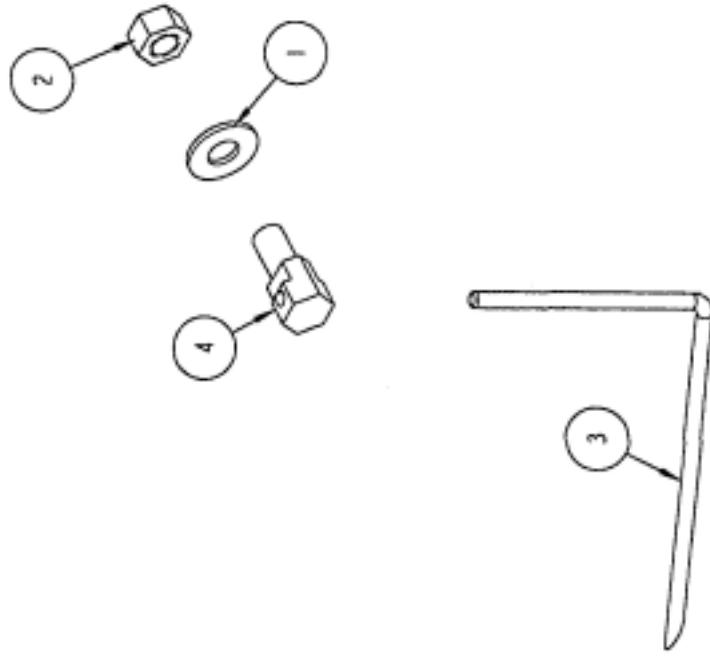
STAMP #: 1

ITEM QTY	PART #	DESCRIPTION
1	100109	BUSHING, SL1-0001D1-2500D1-5001G
2	102112	KNOB, PURCHASED
3	105601	SHAFT, THREADED 5/16-18
4	500714	BRIDGE - REAR CENTER GUIDE
5	500715	PLATE - REAR CENTER GUIDE
6	1	500770 HUB - REAR GUIDE SHAFT
7	2	500771 CLIP-SIDE GUIDE
8	1	500845 TABLE, JOGGER
9	2	500847 BRACE, COMPUTER FORM REST
10	1	500878 SUPPORT - JOGGER TABLE
11	1	500880 BRACKET - JOG TABLE SUPP
12	1	500764AL ASSY, LIFTER
13	1	500764AR ASSY, LIFTER
14	1	500880A ASSY, BRACKET



ITEM	REV NO	DATE	DESCRIPTION	CCN NO	BT
1	1	5-APR-99	REAR SPACER ASSEMBLY	4453	NY
<hr/>					
REG'D WHERE USED					
1 531495-01					
<hr/>					
PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE COPIED OR REPRODUCED IN ANY FORM WITHOUT THE EXPLICT WRITTEN PERMISSION OF KIRK-RUDY, INC. KENNESAW, GA 30044 USA					
<hr/>					
TRANS. ANGLE PROJECTION					
<hr/>					
DRAWN BY: NJG SCALE: 0 . 188 DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED					
CHECKED BY: DATE: 12-Apr-99 REMOVE ALL CHARS. AND SHARP EDGES UNLESS OTHERWISE NOTED					
SIGNED BY: MASTERS DATE: 215 N/A					
SHEET NO: 1 OF 1 N/A					
<hr/>					
KIRK - RUDY, INC. KENNESAW, GEORGIA					
<hr/>					
ASSY, REAR BRIDGE					
<hr/>					
500714-A					

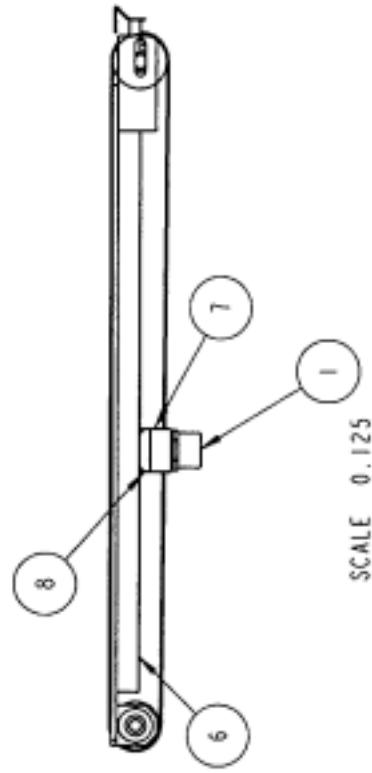
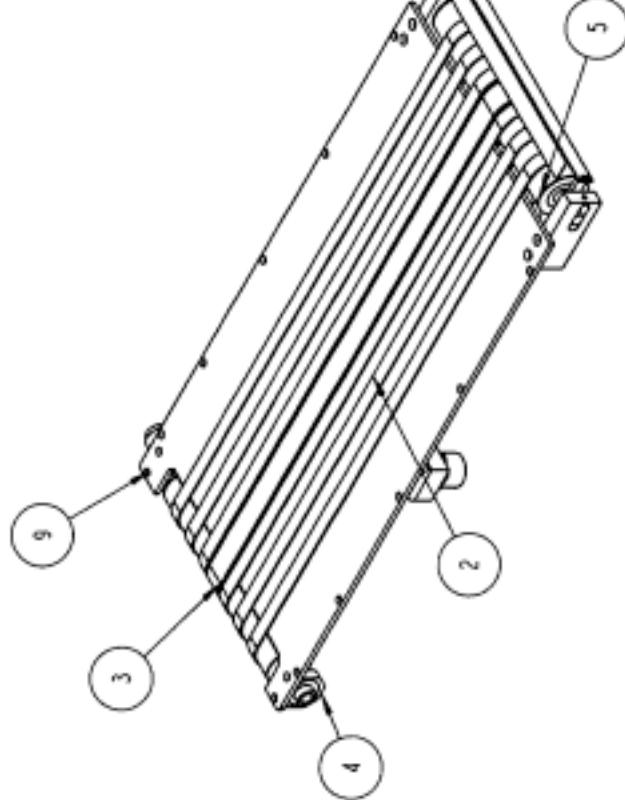
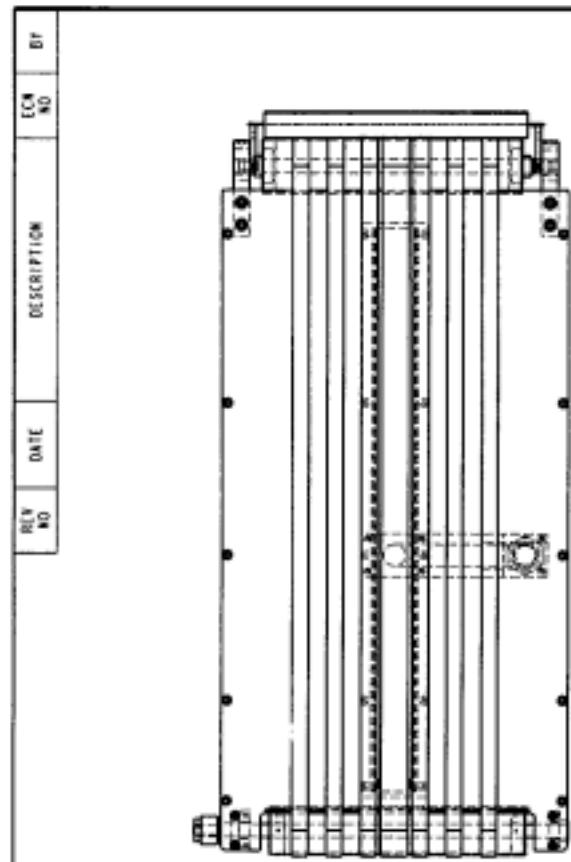
ITEM QTY	PART #	DESCRIPTION	REV AD	DATE	DESCRIPTION	ECN RD	BY
1	100601	THRUST WASHER					
2	106702	NUT, 3/8-16					
3	500764	LIFTER - REAR BRIDGE					
4	500766	SCREW - MACHINE REAR GUIDE					



ITEM NO.	SCALE	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	MATERIAL:	FINISH	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 30046 USA	RECD BY	WHERE USED
1	0 . 500	.00 -.005 .005	N/A	N/A			KR KIRK-RUDY INC. KENNESAW, GA 30046
2	1/4"	.00 -.005 .005	N/A	N/A		215	ASSY, LIFTER
3	1/4"	.00 -.005 .005	N/A	N/A		TOFI	STANES II

500764A

ITEM QTY	PART #	DESCRIPTION
1	190715	PVC COUPLING
2	105901-7	BELT, GREEN .75 X .68-.75
3	106202-6	BELT, GREEN 1.25 X .68-.75
4	531274-02	ASSY, ROLLER BELT DRIVE
5	533876-02	ASSY, IDLER ROLLER
6	SP30202	BLOCK, VACUUM
7	SP28217-1	BLOCK, LOWER VACUUM
8	SP28218-1	BLOCK, UPPER VACUUM
9	SP30201-1	TABLETOP 30.5 IN EXT. CENTER VACUUM



ISSUED BY:	DATE:	SCALE:	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	MATERIAL:	REINFORCED BY:	REINFORCED BY:	REINFORCED BY:
TJG	17-Jan-00	0.125	.000 -.000 .000 .000	N/A			
SEARCHED BY:				SEARCHED BY:			
INDEXED BY:				INDEXED BY:			

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

KIRK - RUDY, INC.
KENNESAW, GEORGIA

FILE: SP81400

SEARCHED BY: TOF I

INDEXED BY: SEARCHING #

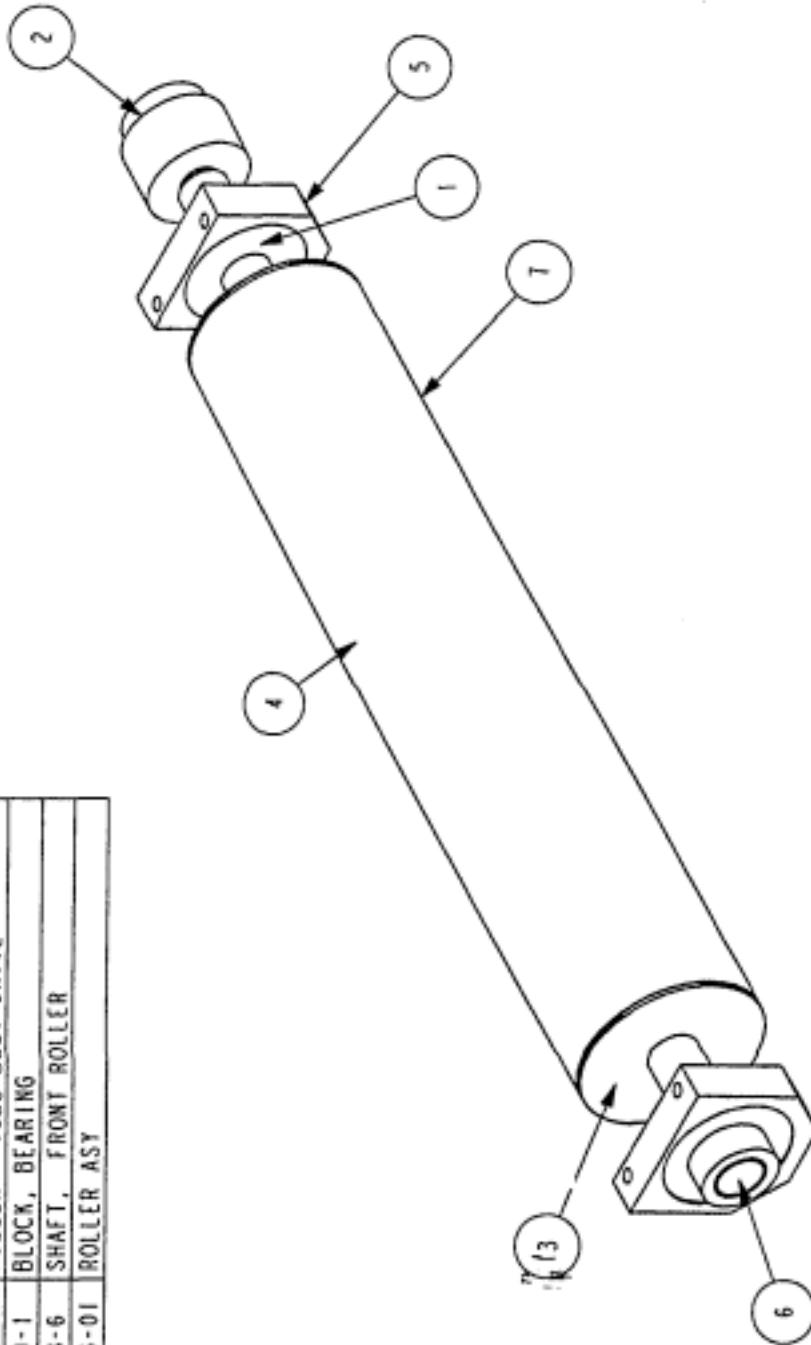
MASTER: M

DATE: 17-Jan-00

SCALE: 0.125

REINFORCED BY: 1 536468-02
REINFORCED BY: REC'D WHERE USED

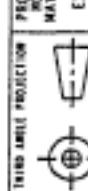
ITEM	QTY	PART #	DESCRIPTION
1	2	103804	BEARING, HUB .625
2	1	109721	PULLEY, TIMING 215M15 .5000B .125X
3	2	500839	HUB-BELT DRIVE
4	1	500742-4	ROLLER - TUBE BELT DRIVE
5	2	500819-1	BLOCK, BEARING
6	1	500828-6	SHAFT, FRONT ROLLER
7	1	530676-01	ROLLER ASY



ITEM NO.	DATE	DESCRIPTION	LCN NO.	BY
1	11-JAN-01	REPLACED 500828-5 WITH 500828-6	5514	TJS

REF ID	WHERE USED
1	215J

KRK KIRK-RUDY, INC.
KENNESAW, GEORGIA



PROPRIETARY AND CONFIDENTIAL
NOT TO BE COPIED OR REPRODUCED
IN ANY FORM WITHOUT THE
EXPRESS WRITTEN PERMISSION
OF KIRK-RUDY, INC.
KENNESAW, GA. 30044 USA

PRINT:

SP79000

ASSY, ROLLER BELT DRIVE

DRAWING #

10F1

531274-02

SCALE	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED		MATERIAL:	N/A	TELETYPE PROJECTION
1" = 1'-0"	.01	.015	ANSI		

04-Nov-99

REMOVED ALL BURRS AND
SHARP EDGES UNLESS
OTHERWISE NOTED

ALL DIMENSIONS ARE
FLICKED ONITIONS
DO NOT SCALE. WORK
TO OVERSIZE ONLY

MAILED

SP79000

ASSY, ROLLER BELT DRIVE

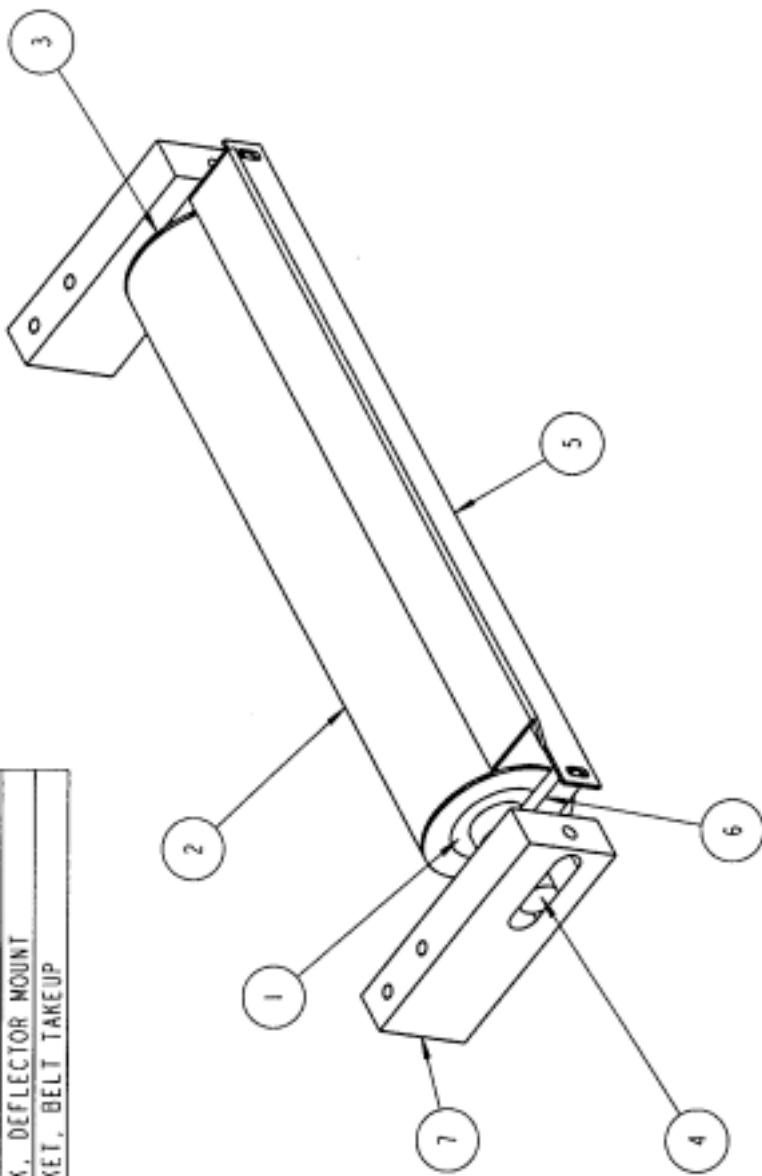
DRAWING #

10F1

531274-02

DRAWING NO.	SCALE	ITEM	QUANTITY	DESCRIPTION
1	1"-0"	1	1	ROLLER BELT DRIVE

ITEM QTY	PART #	DESCRIPTION
1	2	103804 BEARING - HUB
2	1	500835 ROLLER
3	2	500836 HUB
4	1	500823-10 SHAFT, IDLER ROLLER
5	1	533623-01 DEFLECTOR
6	2	533669-01 BLOCK, DEFLECTOR MOUNT
7	2	533975-01 BRACKET, BELT TAKEUP



REF NO	DATE	DESCRIPTION	ECN NO	ER

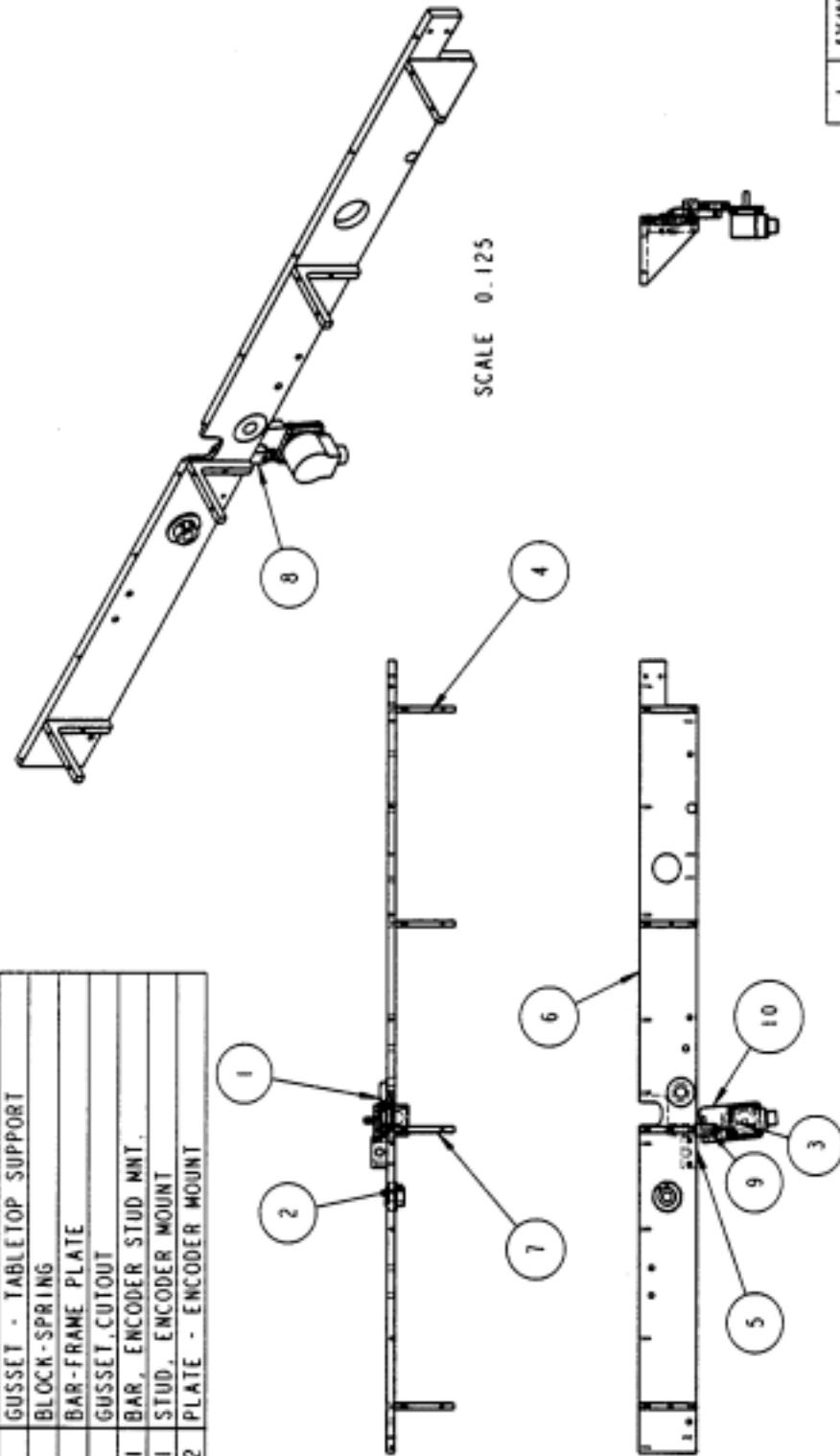
I	533876-02
REF'D	WHEN USED
KRK KIRK-RUDY, INC. KENNESAW, GEORGIA	
PRINT NAME PROJECTION	TOP
MATERIAL:	NOTED
DIMENSIONAL TO FRAMES	
UNLESS OTHERWISE NOTED	
.IN .MM .IN .MM .IN .MM	
IN .MM .IN .MM .IN .MM	
REMOVED ALL BURPS AND SHARP EDGES UNLESS OTHERWISE NOTED	NONE
ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE. WORK TO DIMENSIONS ONLY	NONE
MASTER	M
SHEET NO.	1 OF 1
DRAWING #	ASSY, IDLER ROLLER
	533876-02

DRAWING #

536475-01

ITEM #	PART #	DESCRIPTION
1	1 103805	BEARING - HUB
2	1 103817	HUBBEARING 5/8 ID
3	1 202492	ENCODER, DYNAPAR 1000PPR
4	1 500721	GUSSET - TABLETOP SUPPORT
5	1 500785	BLOCK-SPRING
6	1 500701-R	BAR-FRAME PLATE
7	3 500721-1	GUSSET,CUTOUT
8	1 537691-01	BAR, ENCODER STUD MNT.
9	1 538341-01	STUD, ENCODER MOUNT
10	1 SP45241-2	PLATE - ENCODER MOUNT

ITEM #	PART #	DATE	DESCRIPTION	ECN NO	ER



ITEM #	REVISION	WHERE USED
1	S04691-01	

KR KIRK-RUDY, INC.
KENNESAW, GEORGIA

ASSY, 215 FRAME RH
SP76500
UNIT 10f 1
DRAWING #

DESIGN BY:	SCALE:	DIMENSION TO NEAREST .001 UNLESS OTHERWISE NOTED	MATERIAL:	INSPECTION	PACKING
ENGINEER BY:	xx	xx	xxx	xx	xx
DATE:	xx	xx	xxx	xx	xx
TRACER BY:	MASTER	xx	xxx	xx	xx

REMOVED ALL BURRS AND
SHARP EDGES UNLESS
OTHERWISE NOTED
ALL DIMENSIONS ARE
FINISHED DIMENSIONS
NO SCALE WORK
TO DIMENSIONS ONLY

ITEM #	PART #	DESCRIPTION	LCN NO	REV NO	DATE	DESCRIPTION	LCN NO	BY
1	2	103108				BEARING, FLAT .500		
2	2	103805				BEARING - HUB		
3	2	103812				BEARING - HUB		
4	1	104106				SNAPRING, .500		
5	1	500721				GUSSET - TABLETOP SUPPORT		
6	1	508540				STUD		
7	1	525408				STUD, TAKEUP ARM		
8	2	500721-1				GUSSET, CUTOFF		
9	1	500983-1				STUD, IDLER SPROCKET		
10	1	508684-1				ARM, TAKE UP		
11	1	516045-4				ROLLER, BELT TAKEUP		
12	2	516045A				ASSY, IDLER 1.376 DIA. X 1.00 IN		
13	1	531106-01				ASSY, HUB		
14	1	536469-01				FRAME, 215A LH		
15	1	536477-01				ASSY, TAKE UP TIMING BELT		
16	1	538295-01				STUD, BELT IDLER		

SCALE 0.125

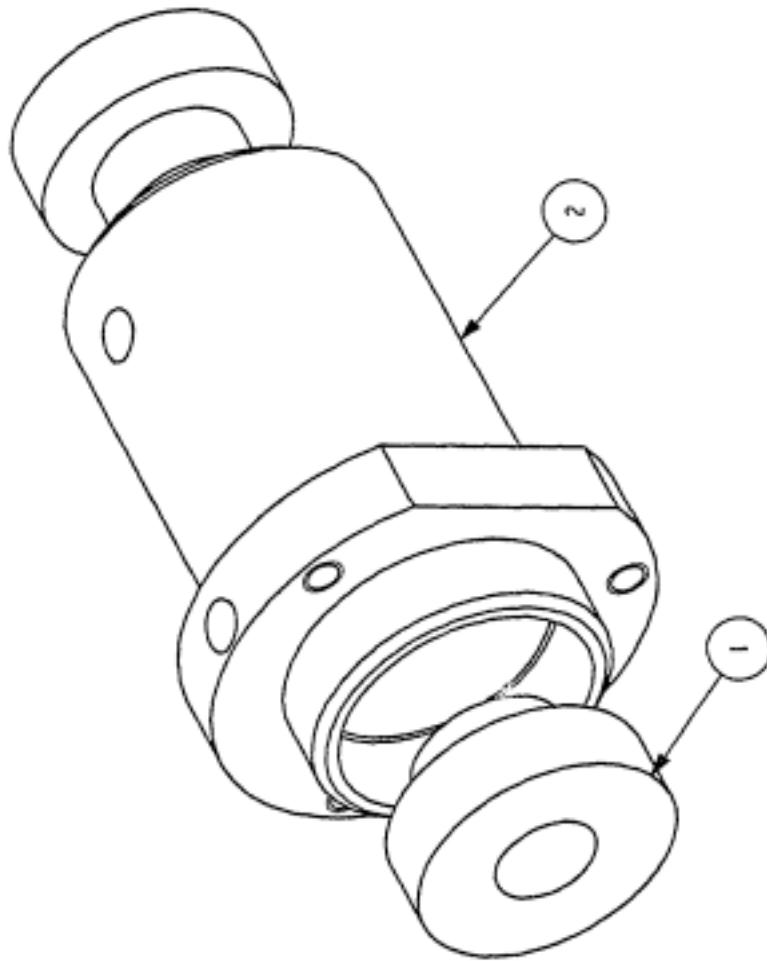
REF ID:	SCALE	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	MATERIAL	REF ID:	SCALE	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	MATERIAL	REF ID:
T JG	0 . 094	.00 .005	XXX	27 - Aug - 99	.00 .005	XXX	XXX	536476-01
EXCUSE #:	REV:	AM:	REF DATE:	REV:	AM:	REF DATE:	REV:	REF ID:
TRUCK #:	MASTER		REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED	SP	76500	ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY	ASSY, 215 FRAME LH	

DRAWING #

536476-01

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

ITEM QTY	REV NO	DATE	DESCRIPTION	ECN NO	B1
1	2				



DRAWING #:	JLG	SCALE:	1 . 000	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	MATERIAL:		N/A	PROJECTION AND CONVENTIONAL NO PROJECTION ON THIS DRAWING MANUFACTURED BY KIRK-KENNESAW, INC., KIRK-KENNESAW, GA 30144 USA EXCEPT WHERE OTHERWISE NOTED. THIS DRAWING IS THE PROPERTY OF KIRK-KENNESAW, INC., KIRK-KENNESAW, GA 30144 USA	
					.015	.015			
CHIEFED BY:		DATE:	28-JUL-99	WEAR THRESHOLD:	N/A		215	PRINT:	
TRACED BY:	MASTER			REMOVED ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED	N/A		100% TO PRINT	SEARCHED:	
				ALL DIMENSIONS ARE FINISHED DIMENSIONS				DO NOT SCALE - WORK TO SPECIFICATIONS ONLY	

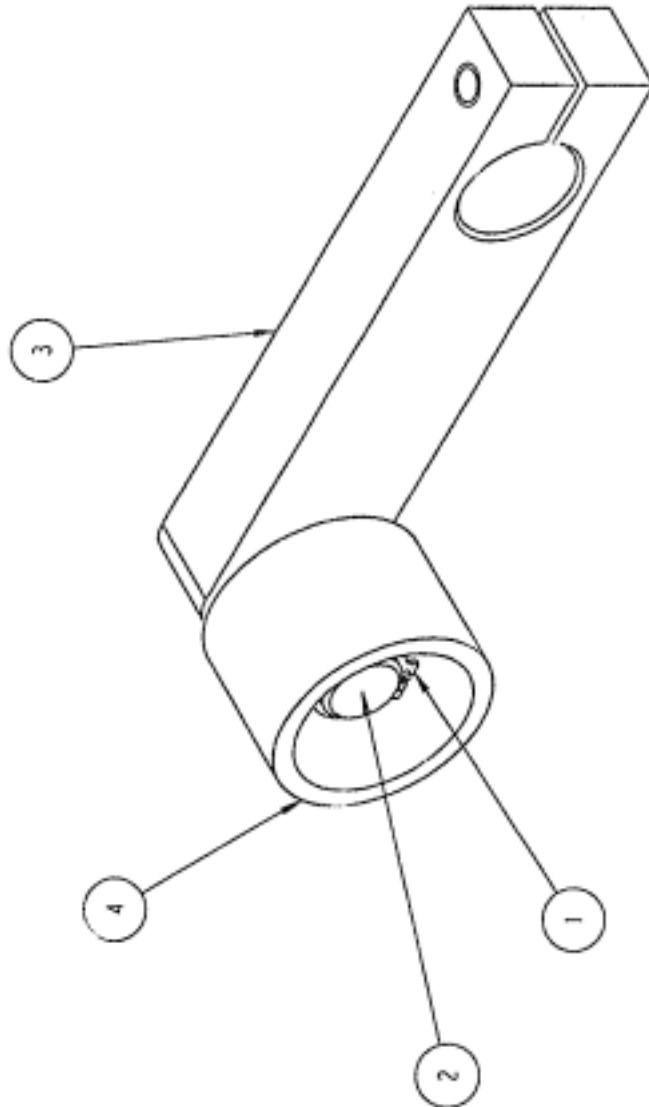
1	531106-01
REV'D	WHERE USED

KR KIRK - RUDY, INC.
KENNESAW, GEORGIA

ASSY, HUB

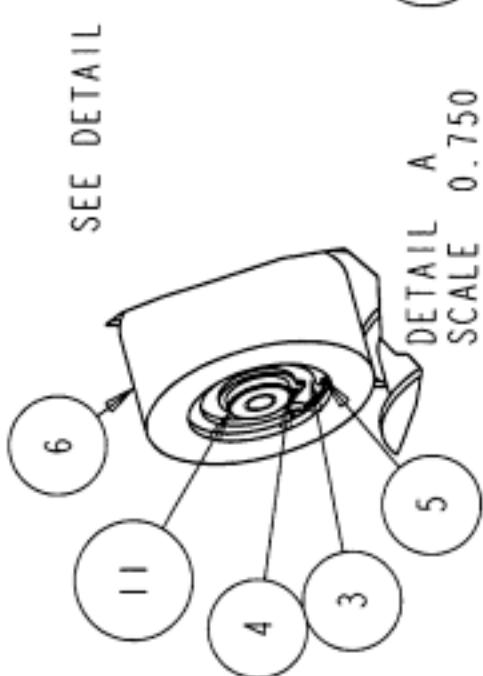
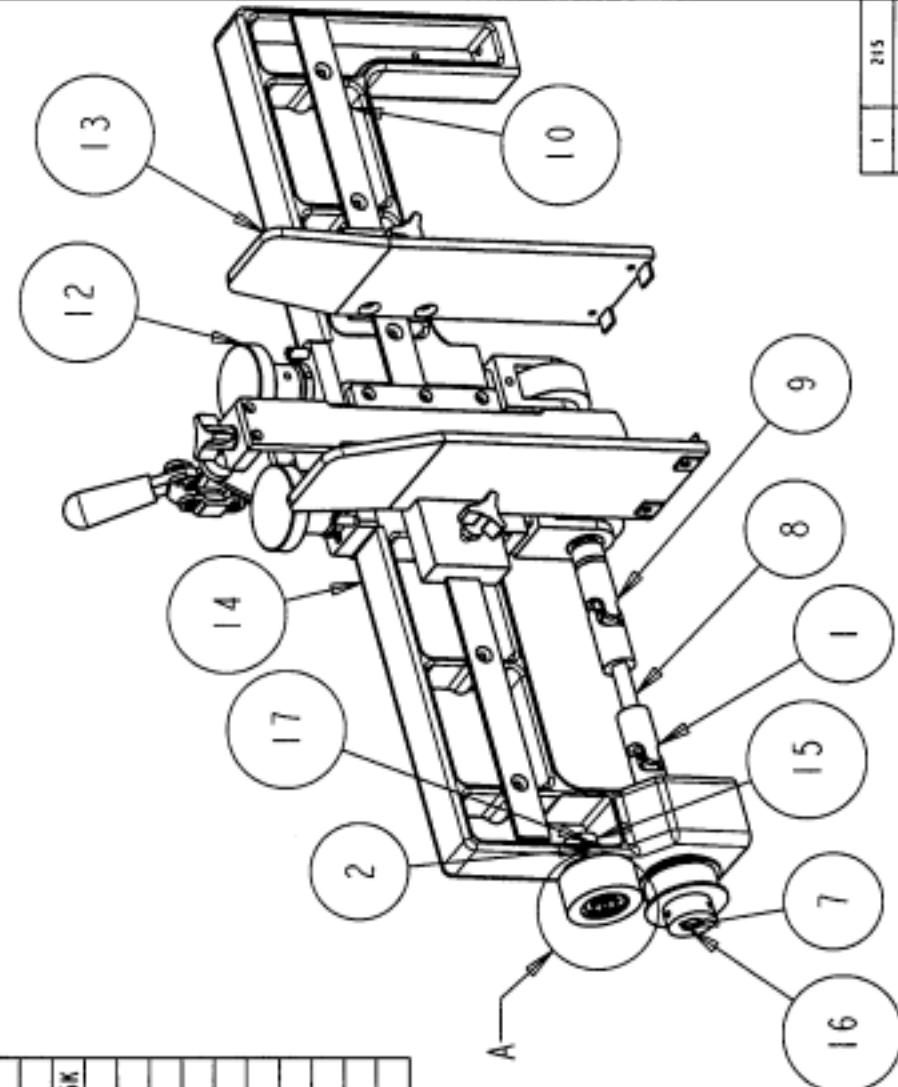
531106-01

ITEM	QTY	PART #	DESCRIPTION
1	1	104106	SNAPRING, .500
2	1	508540	STUD
3	1	506684-2	ARM, TAKE UP
4	1	516045A	ASSY, IDLER 1.376 DIA. X 1.00 IN



BAKER #:	T J G	SCALE:	1.000	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	XXXX	TRIM ANGLE POSITION	POSITIONING AND CONVENTIONAL PROJECTION OF THIS DRAWING MAY BE USED FOR MANUFACTURE AND ASSEMBLY. THIS DRAWING EXCLUDES WRITTEN SPECIFICATIONS OR DRAWINGS REFERRED TO HEREIN. GA 70147, USA.	KIRK - RUDY - NC, KENNEBUNK, GEORGIA
CHECKER #:	SART	DATE:	01 - Sep - 99	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED	XXXX	SP76500	ASSY , TAKE UP TIMING BELT	536477-01
HASLER #:	MASLIE	MAKER:		ALL DIMENSIONS ARE FINISHED IN INCHES DO NOT SCALE. WORKS TO DRAWINGS ONLY	XXXX	REF ID:	REAR	
				m				

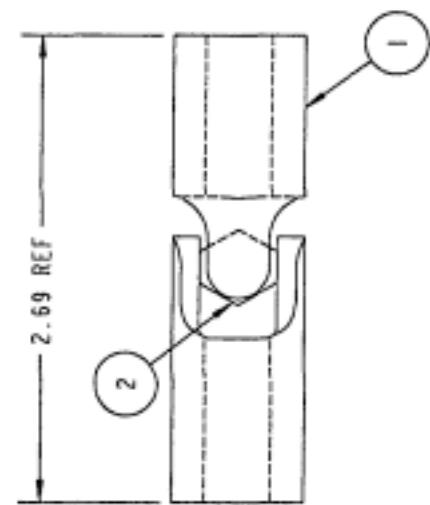
ITEM QTY	PART #	DESCRIPTION
1	100800	ASSY. UNIVERSAL JOINT
2	102302	SHIM, .500X.750X.062
3	2 103108	BEARING, FLAT .500
4	1 104106	SNAPRING, .500
5	1 104205	SNAPRING, INTERNAL 1.125 BORE
6	1 109386	PULLEY, TIMING 15L050 1.125B NK
7	1 109410	PULLEY, TIMING 14L050 .500B .125K
8	1 500803	SHAFT-UNIVERSAL JOINT
9	1 100800-1	ASSY. UNIVERSAL JOINT
10	2 500814-1A	ASSY, SIDE GUIDE RAIL
11	1 500983-7	STUD, IDLER SPROCKET
12	1 531582-01	EG ASSY, BRIDGE DRIVE AND GATE
13	1 535412-01	ASSY, SIDE GUIDE
14	1 537550-01	ASSY, BRIDGE
15	1 HJN014	
16	1 SP43307	SHAFT, UPPER FEED ROLLER
17	1 WHS013	LOCK WASHER



ITEM #	KEY	SCALE	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	MATERIAL	ITEM ANGLE PROJECTION	PROJECTION AND CONVENTIONAL NOTATION OF THIS DRAWING MAY BE USED ON OTHER DRAWINGS EXPRESSED IN INCHES OR MILLIMETERS WHEN NECESSARY. KIRK-RUDY, INC., KENNESEEW, GEORGIA
1	01-0c † - 99	.250	.38 .005 .005 .005	N/A	215	ASSY, BRIDGE TIMING BELT
2	01-0c † - 99	.062	.062 .005 .005 .005	N/A	215	ASSY, BRIDGE TIMING BELT
3	M			N/A	10f 1	537549-01

ITEM	QTY	PART #	DESCRIPTION
1	2	100800-1	UNIVERSAL
2	1	100800-3	BLOCK, PIN

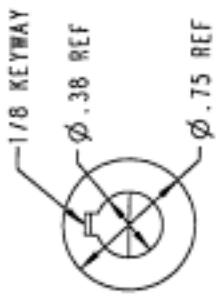
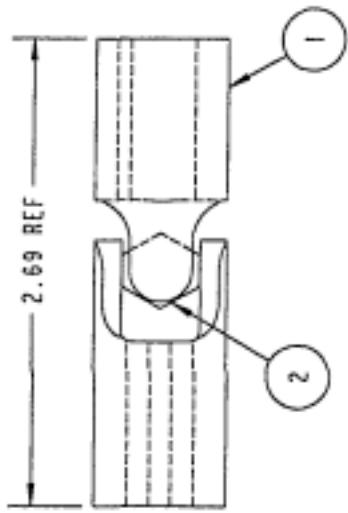
ITEM	REV NO	DATE	DESCRIPTION	ECN NO	BT
	1	2-11-88	RE-DRAW IN PRO-E	6254	N/A



PRINTED BY:	NAJ	SCALE:	1.000	MATERIAL:	PURCHASED	THIS DRAWING PROHIBITS THE REPRODUCTION OR QUOTING OF THIS DRAWING EXCEPT AS QUOTED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK - RUDY, INC.	KIRK - RUDY, INC.
CHECKED BY:	BAK	DIMENSION TOLERANCES UNLESS OTHERWISE NOTED	.38 .075 .065 .065	MAINTENANCE:	N/A	PRINTED ON 30 - MAY - 90	KENNESAW, GEORGIA
MAILED BY:	[REDACTED]	REMOVED ALL BURRS AND SHARP EDGES, SHARP OTHERWISE NOTED		TIME:	215	TIME:	KENNESAW, GA 30044 USA
MASTER BY:	[REDACTED]	ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY		QUANTITY:	1 OF 1	QUANTITY:	100800

ITEM QTY	PART #	DESCRIPTION
1 2	100800-1-1	UNIVERSAL
2 1	100800-3	BLOCK, PIN

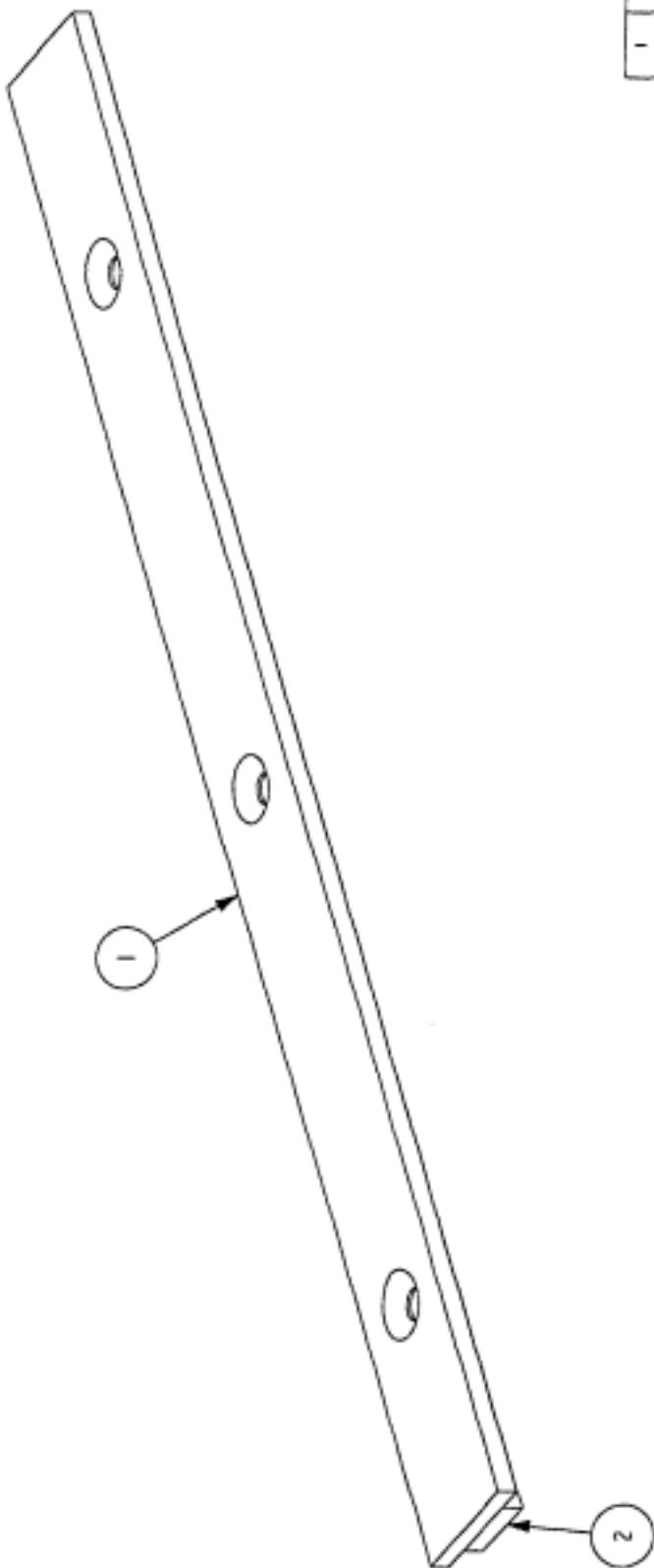
ITEM NO	DATE	DESCRIPTION	ECN NO	BT
1	2-11-88	RE-DRAWN IN PRO-E	6124	8.05



REF ID:	Y0	SCALE:	1 . 000	DIMENSIONAL TOLERANCES SINLESS OTHERWISE NOTED	NOTES:	PURCHASED	MANUFACTURE:	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:	.81 - JUL - 79	.005 .005 .005	REMOVES ALL PIRAS AND SCAUF. ALSO UNLACES OTHER WELDS	N/A	REF ID:	KIRK-RUDY INC. KENNESAW, GA 30144 USA
TELECO ID:		MASTER:	[REDACTED]		ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE MAX TO 0.146 INCHES ONLY	N/A	REF ID:	ASSY, UNIVERSAL JOINT
						10F1	REF ID:	100800-1

REF ID:	551618-01
REF ID:	580704-A

ITEM QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	1	500814-1 RAIL - SIDE GUIDE					
2	1	500814-2 RAIL - SIDE GUIDE					



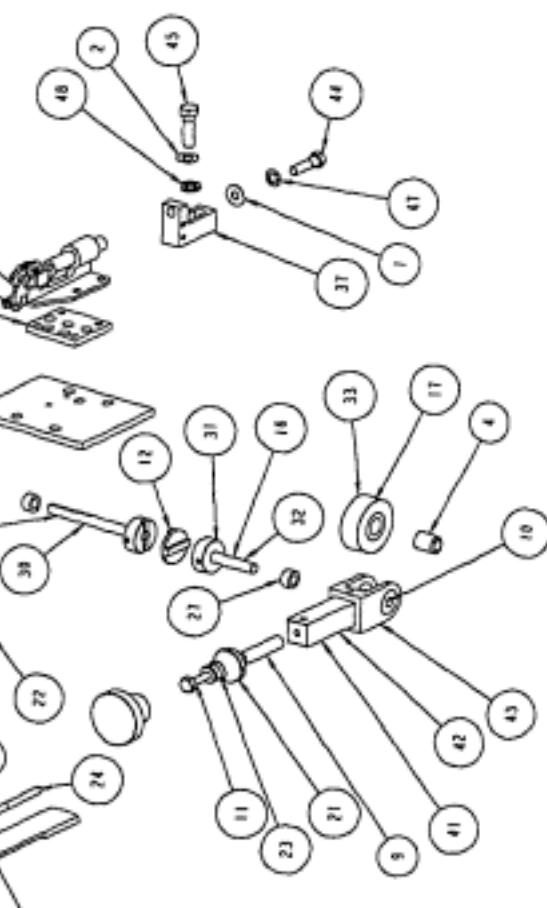
ITEM NO:	MY	SCALE:	1 . 000	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	MAXIMUM:	PROPOSITION AND CONFIDENTIAL NO COPIES OF THIS DRAWING MAY BE QUOTED OR REPRODUCED IN ANY FORM WITHOUT THE EXPLICT WRITTEN PERMISSION OF KIRK-RUDY INC. KENNESAW, GA 30144 USA	KIRK - RUDY INC. KENNESAW, GEORGIA
CHARGE NO:	12-Apr-99	DATE:	.000	.000	.000	TRADE ASSEMBLY	TRADE ASSEMBLY
INSTRUMENT:	M	MASTERS:	M	N/A	N/A	NOTES:	NOTES:
REMARKS:						REMARKS:	REMARKS:

REMOVE ALL SHARP EDGES UNLESS
OTHERWISE NOTED
ALL DIMENSIONS ARE
IN INCHES
NO. NOT SCALE: WORK
TO DIMENSIONS ONLY

500814-1A

ITEM #	PART #	DESCRIPTION	QTY	NAME	NUMBER	UNIT	SP
--------	--------	-------------	-----	------	--------	------	----

1	2	BOLTS THRUST WASHER	2				
2	1	90602 THRUST WASHER	1				
3	2	90609 THRUST WASHER	2				
4	2	91109 ONE WAY BEARING	2				
5	1	92114 SHIM	1				
6	1	92117 SHIM	1				
7	1	92225 COLLAR	1				
8	1	92345 SHIM	1				
9	2	92701 SPRING	2				
10	4	BEARING - FLAT	4				
11	2	BOLT - HEX HEAD	2				
12	1	90109 SPIDER - ROLLER DRIVE	1				
13	1	192685 Lever - Quick Release	1				
14	1	509135 PLATE, GATE FEEDER	1				
15	1	509143 SHAFT - TOP ROLLER DRIVE	1				
16	1	509144 SHAFT - TOP ROLLER ASSY	1				
17	2	509145 ROLLER - TOWER	2				
18	1	509195 PLATE - BACK	1				
19	2	509195 PLATE - HOLD DOWN	2				
20	1	509085 PLATE - GATE END	1				
21	2	NUT - LOCK	2				
22	1	509088 PLATE - TOP BRIDGE	1				
23	2	360409 SLEEVE - THREADED	2				
24	1	509816 SPAS1 - SCREW ADJ	1				
25	2	509817 FORK ASY	2				
26	2	509812 RACK, ROLLER ADJUSTMENT	2				
27	2	509859 SPACER	2				
28	1	(92114A ROUND RING ASY	1				
29	1	102706 COLLAR	1				
30	1	509143 SHAFT - TOP ROLLER	1				
31	2	509144 COLLAR - TOP ROLLER SHAFT	2				
32	1	509144 SHAFT - TOP ROLLER	1				
33	2	509145 UPPER FIELD ROLLER ASSY	2				
34	1	300795 BLOCK, CLAMP SUPPORT	1				
35	2	509196 STUB, BRIDGE (SOLID)	2				
36	2	300797 STUB, BRIDGE (SOLID)	2				
37	1	509199 BLOCK - CONNECTOR	1				
38	1	508679 CLAMP - MOUNTING PLATE	1				
39	2	508679 FORK ASY WITH BEARING	2				
40	1	531582-01 EG BRIDGE DRIVE AND GATE ASY	1				
41	2	531584-01 EG FORK ASY	2				
42	2	531572-01 BAR, FORM	2				
43	2	531573-01 TUBE	2				
44	1	690951	1				
45	1	800081	1				
46	1	STA510	1				
47	1	W5010	1				
48	1	W5011	1				



ITEM #	PART #	DESCRIPTION	QTY	NAME	NUMBER	UNIT	SP
1	TYK	0.250	1	TOP BRIDGE	XXX		
2	DATE	2-3-Sep-97	1	DATE	XXX		
3	REVISION	REV A	1	REVISION	XXX		
4	M	% THICKNESS, 20%	1	M	XXX		
5	TDF I	% THICKNESS, 20%	1	TDF I	XXX		

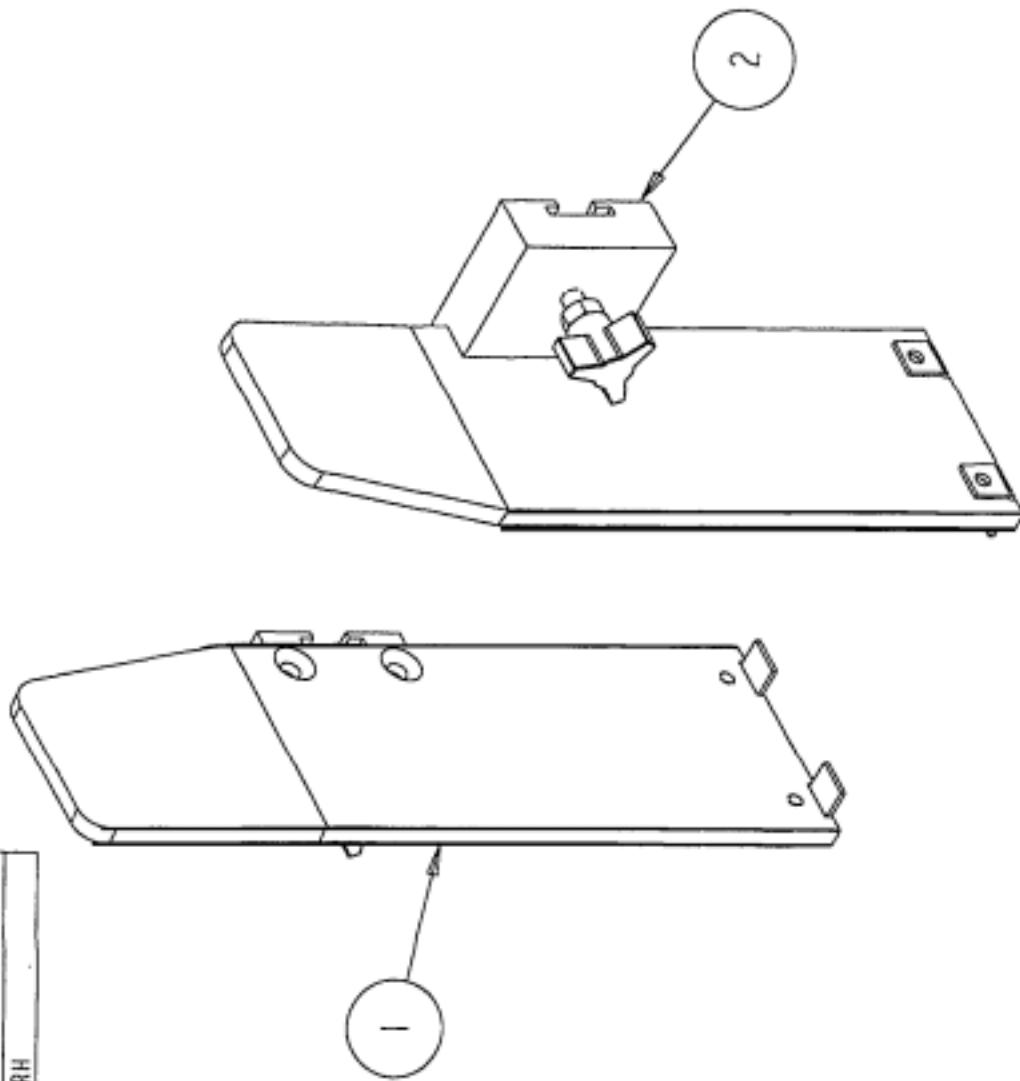
KIRK - RUDY, INC.
KENNESAW, GEORGIA

BRIDGE DRIVE AND GATE ASY

531582-01

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

REF NO	DATE	DESCRIPTION	LCN NO	BT
1				
2				



REF ID:	SCALE:	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	NOTES:	REF ID:	REF ID:
TVK	0 . 500	N/A	(SEE DRAWING)	KIRK - RUDY, INC.	KIRK - RUDY, INC.
02-Mat-99	02-Mat-99	N/A	(SEE DRAWING)	KENNESAW, GEORGIA	KENNESAW, GEORGIA
MASTER	M	N/A	ALL DIMENSIONS ARE IN INCHES UNLESS NOTED	PRINTED BY KIRK-RUDY, INC., KENNESAW, GA. 30044 USA	PRINTED BY KIRK-RUDY, INC., KENNESAW, GA. 30044 USA

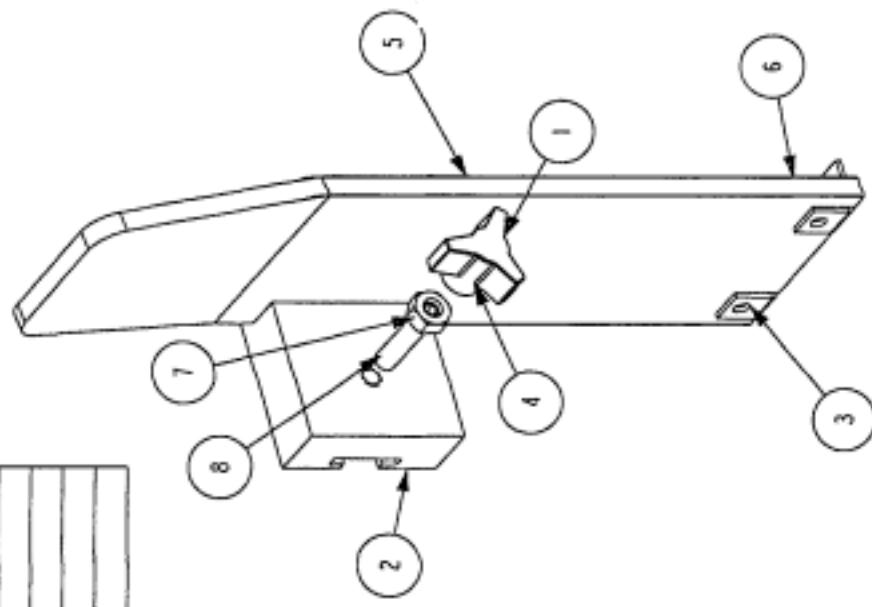
1 535412-01
REF ID WHERE USED

2 535412-01
REF ID WHERE USED

ASSY, SIDE GUIDE

535412-01

ITEM QTY	PART #	DESCRIPTION
1	1	102119 KNOB
2	1	500755 CLAMP - SIDE GUIDE
3	2	500771 CLIP-SIDE GUIDE
4	1	102119-A ASSY, KNOB
5	1	500788L PLATE - RH SIDEGUIDE
6	1	500788LA ASSY-SIDE GUIDE PLATE
7	1	RHN010 HEX NUT
8	1	SYA601

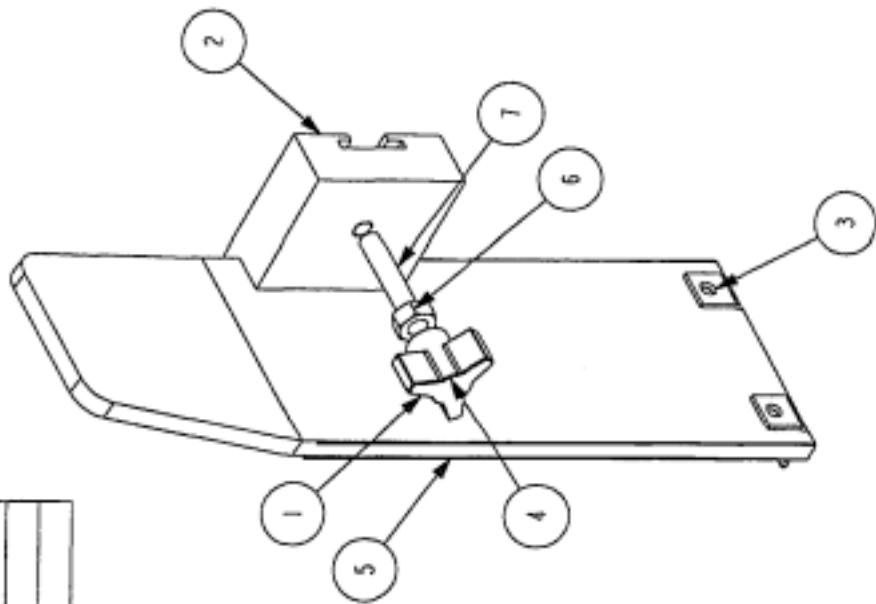


ITEM NO.	SCALE	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	MATERIAL:	REMOVED:	THIN END PROJECTION	PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE DUPLICATED OR REPRODUCED IN WHOLE OR IN PART, THE EXCEPT WITH THE WRITTEN PERMISSION OF KIRK-RUDY, INC. KENNESAW, GA 30044 USA	REF'D	WHERE USED
MY	0 . 500	.003 .005 .005 .005	N/A				1	335817 01
DATE:	12-Apr-99							
TRACER:	MASTER							

REMOVED: ALL BURRS AND
SHARP EDGES UNLESS
OTHERWISE NOTED
ALL DIMENSIONS ARE
FINAL DIMENSIONS
(O) NOT SCALE - WORK
TO DIMENSIONS ONLY

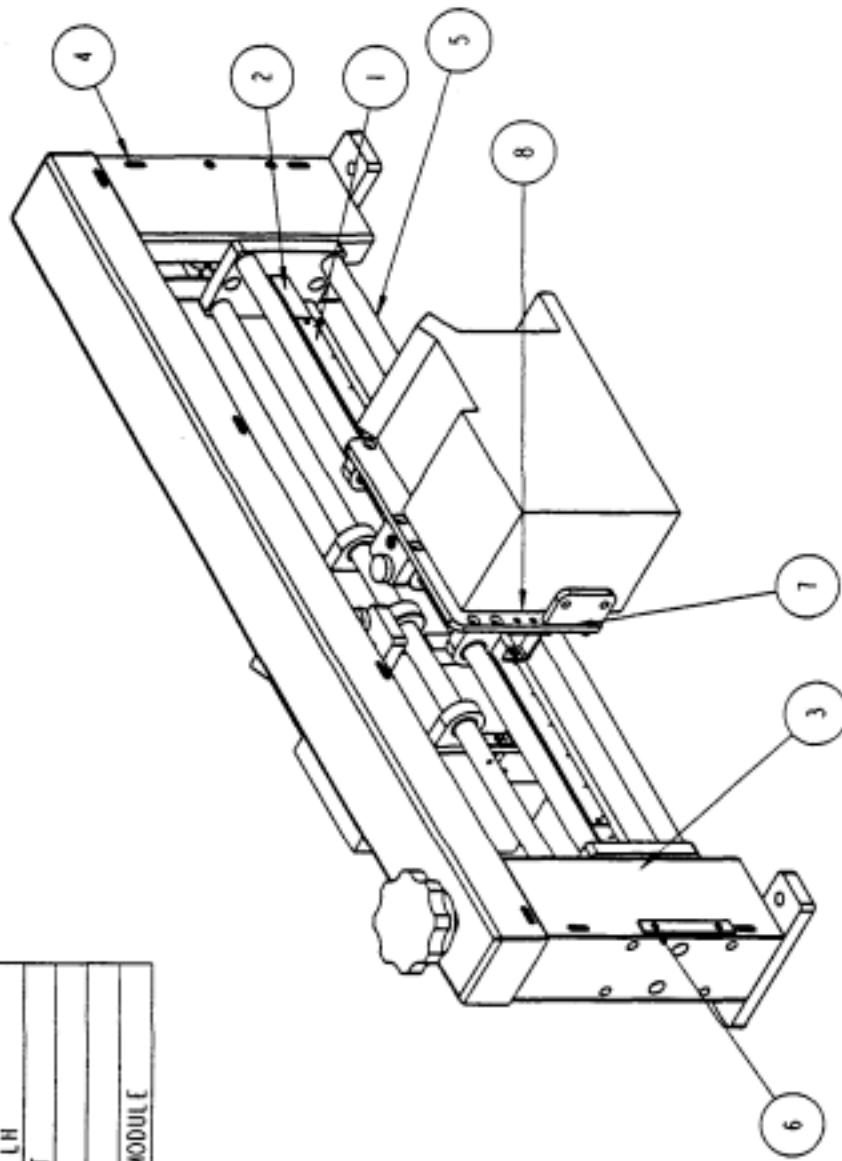
1	215	ASSY, SIDE GUIDE LH
2	TOP	DRAWING:
3	500755AL	

ITEM QTY	PART #	DESCRIPTION
1	102119	KNOB
2	500755	CLAMP - SIDE GUIDE
3	500771	CLIP-SIDE GUIDE
4	102119-A	ASSY. KNOB
5	500788R	PLATE, SIDEGUIDE RH
6	RHNO10	HEX NUT
7	SYA601	



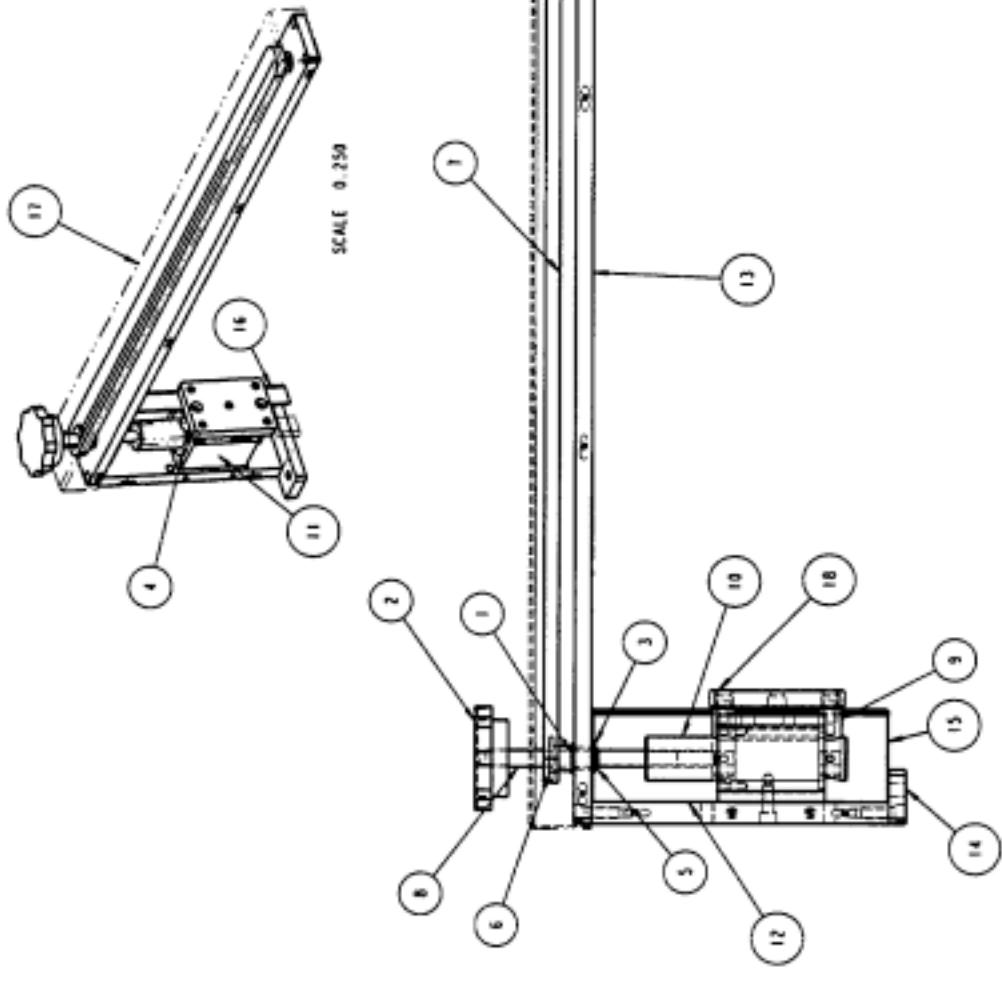
REF ID:	REV:	SCALE:	NAME:	DESIGNER:	PROPS:	RECD BY:	WHERE USED
REF ID:	MY	0 . 500	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	N / A	THREE ANGLES INDICATED NO POSITION OF THIS DRAWING MAY BE QUOTED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC.	KIRK - RUDY, INC. KENNESAW, GEORGIA	
Design ID:	DATE:	PI:	AMP.	AMP. (RMS)	PI	215	ASSY, SIDE GUIDE RH
	12-Apr-99	.000	0				
Design ID:	MASTER:	M	FINISHED DIMENSIONS DO NOT SCALE, DO NOT DISTORT ONLY	N / A	SHEET NO. 1 DRAWING 1	OF 1	500755AR

ITEM	QTY	PART #	DESCRIPTION
1	2	190771	SCALE, CENTER ZERO
2	1	531678-02	BAR, SCALE SUPPORT
3	1	538153-01	ASSY, VERTICAL ADJ. RH
4	1	538153-02	ASSY, VERTICAL ADJ. LH
5	4	538168-01	SHAFT, HEAD SUPPORT
6	2	538178-01	STRAP, RIBBON CLAMP
7	2	538269-01	ASSY, INKJET MOUNT
8	2	BRYCE, INKHJET BYCCE	INKJET HEAD MODULE



ITEM	REF NO	DATE	DESCRIPTION	ICN NO	BY
2				538491-02	

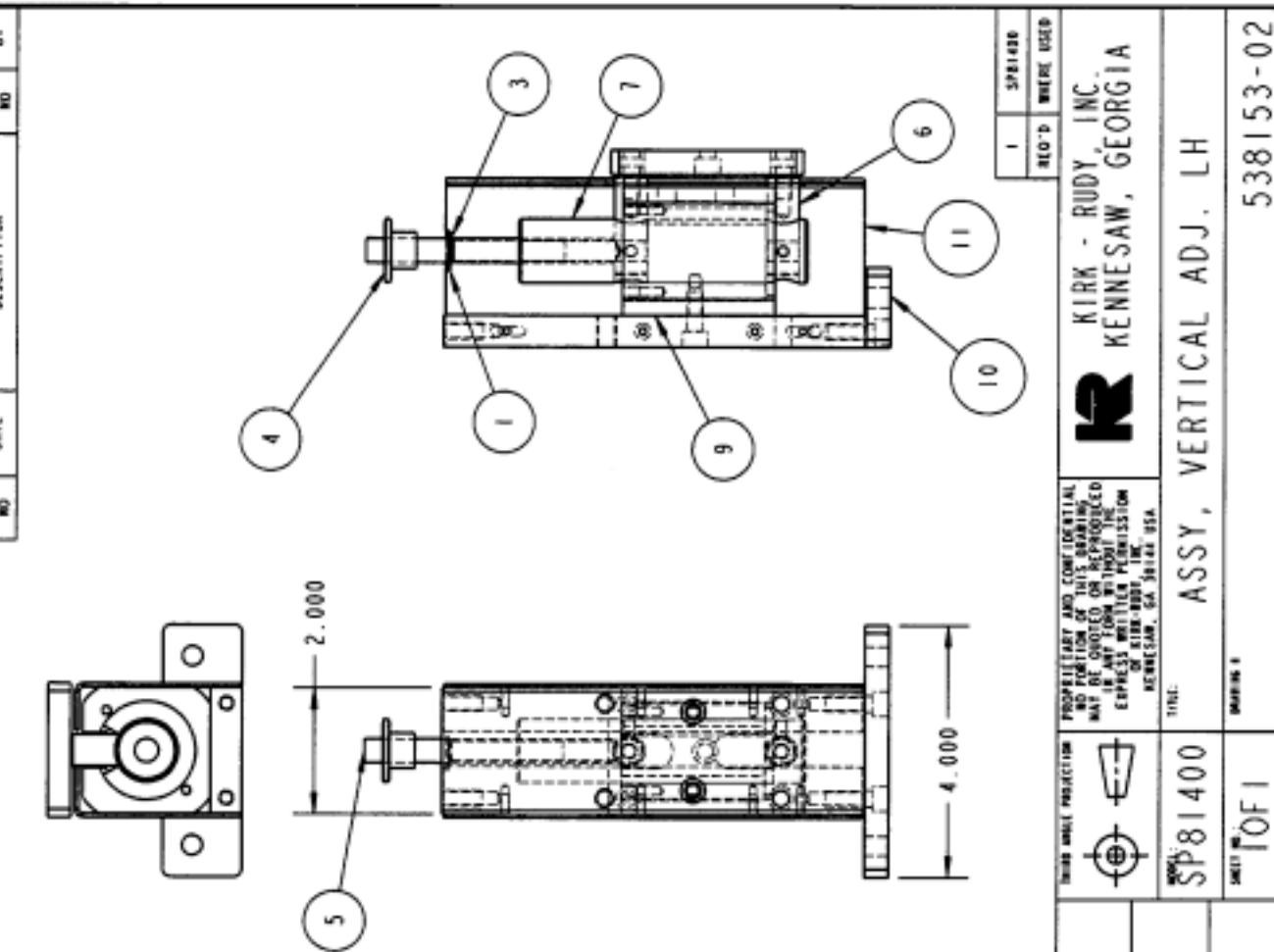
ITEM #:	SCALE	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	NOTES:	ITEM AND SUB-ITEM	PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE COPIED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC. KENNESAW, GA 30044 USA
TRUCK #::	0 . 250	.00 -.005 .005 .005	X X X	SP81400	KIRK - RUDY, INC. KENNESAW, GEORGIA
CHUCKER #::	10 - Jan - 00	REMOVE ALL SURBS, AND SHARP EDGES, SWELLS, OTHERWISE NOTED	X X X	ITEM #:	ASSY, BRYCE INKJET BRACKET
TRUCK #::	M	ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE, REFER TO DIMENSIONS ONLY	X X X	ITEM #:	538169-01



PART #	DESCRIPTION
1 2	100306 BUSHING, FL. 37510 .50000 .50000
2 1	1021117 4WKB, PURCHASED
3 1	102106 SHIM .375X .625X .021
4 1	102065 BEARING, LINEAR SLEEVE OPEN
5 1	1041008 SPRINGS, .375
6 1	110163 SPEK, 27011 .3750 MM
7 1	110021-17 CHAIN, NO. 25 X 47.5 IN.
8 1	500341-2 SHAFT, LIFT
9 2	51046-01 SHAFT, BRACKET SUPPORT
10 1	51047-01 SHAFT, VERTICAL SUPPORT
11 1	51049-01 BEARING, LINEAR SLIDING
12 1	51050-01 PLATE, VERTICAL MOUNT
13 1	51051-01 PLATE, SCREW ■ SUPPORT
14 1	51057-01 PLATE, BOTTOM SUPPORT
15 1	51054-01 COVER, LINEAR SLIDE RH
16 1	51054-02 COVER, LINEAR SLIDE LH
17 1	51055-01 COVER, CHAIN
18 1	51061-01 PLATE, SHAFT SUPPORT

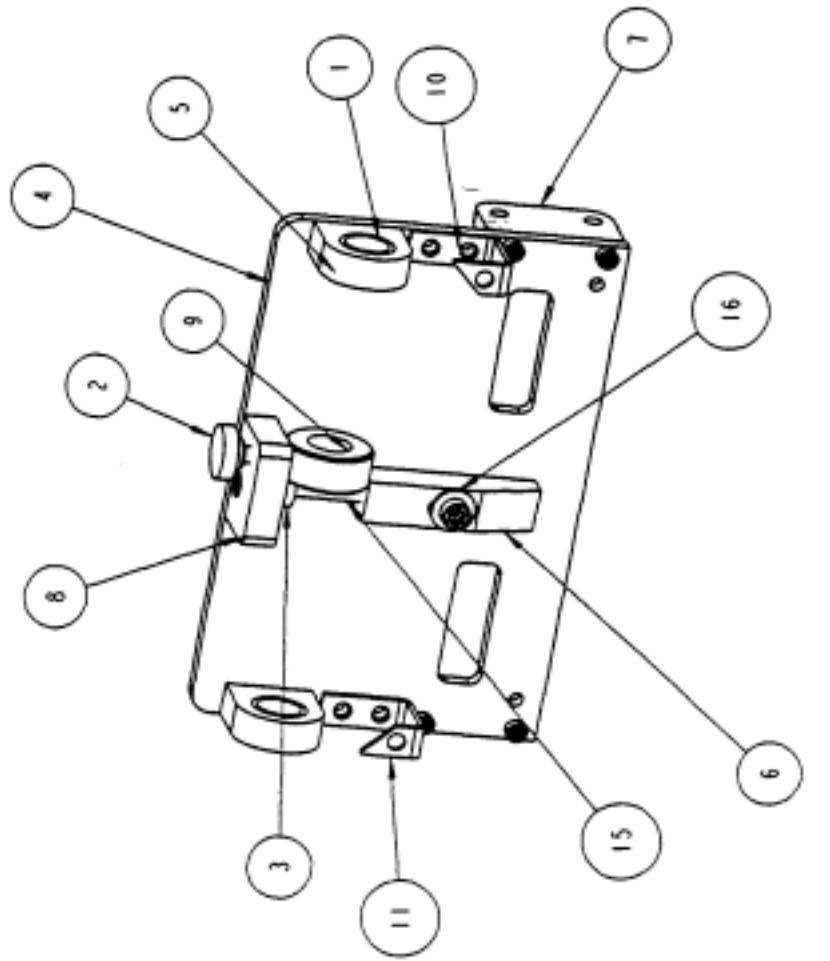
T JG 0 .375 XXX XXX SP81400 ASSY, VERTICAL ADJ. RH
 10-Jan-00 XXX XXX "Tof I
 KIRK - RUDY, INC.
 KENNESAW, GEORGIA

ITEM / QTY	PART #	DESCRIPTION
1 - 1	102306	SHIM, .375X.625X.031
2 - 1	102906	BEARING, LINEAR SLEEVE OPEN
3 - 1	104100	SPRING, .375
4 - 1	110163	SPKT, 258111 .375B NK
5 - 1	500341-1	SHAFT, LIFT
6 - 2	538146-01	SHAFT, BRACKET SUPPORT
7 - 1	538147-01	SHAFT, VERTICAL SUPPORT
8 - 1	538149-01	HOUSING, LINEAR BEARING
9 - 1	538150-01	PLATE, VERTICAL MOUNT
10 - 1	538152-01	PLATE, BOTTOM SUPPORT
11 - 1	538154-01	COVER, LINEAR SLIDE RH
12 - 1	538154-02	COVER, LINEAR SLIDE LH
13 - 1	538167-01	PLATE, SHAFT SUPPORT



REF ID:	SCALE	DESCRIPTION	ECN NO	REV NO	DATE	DESCRIPTION	ECN NO	REV NO
TJG	0 .375	DIMENSIONAL TOLERANCES NOTED: .00 -.005 .005 -.005	XXX			PROPRIETARY AND CONFIDENTIAL NO FURTHER COPIES OR REPRODUCTION MAY BE MADE THAN ON THE EXACT NUMBER OF COPIES NEEDED KIRK-RUDY INC. KENNESAW, GEORGIA		
CHECKED BY:	SAIT	HEAD: XXX				KIRK-RUDY INC. KENNESAW, GEORGIA		
MADE BY:	MASTER	REMARKS: REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED. ALL DIMENSIONS ARE FINISHED DIMENSIONS SO NOT SCALE. WORK TO DIMENSIONS ONLY	XXX			ASSY, VERTICAL ADJ. LH		
	M					MAP NO. 10F1	MAP NO. 1	

ITEM NO	PART #	DESCRIPTION
1	2	100133 BUSHING, SL. 50010.62500.375L6
2	1	102132 KNOB, 10-32 CAP SCREW
3	1	102210 COLLAR .188
4	1	538270-01 PLATE, VERTICAL INKJET MNT.
5	2	538271-01 BLOCK, BUSHING MOUNT
6	1	538273-01 CAM, INKJET LEVEL
7	2	538277-01 PLATE, INKJET HEAD MOUNT
8	1	538280-01 BLOCK, SLIDE LOCK
9	1	538300-01 COLLAR, SLIDE LOCK
10	1	538305-01 INDICATOR, SCALE RH
11	1	538305-02 INDICATOR, SCALE LH
12	4	C5DD210
13	1	C5DD266
14	1	C5DD267
15	1	C5DD272
16	1	WA006 WASHER

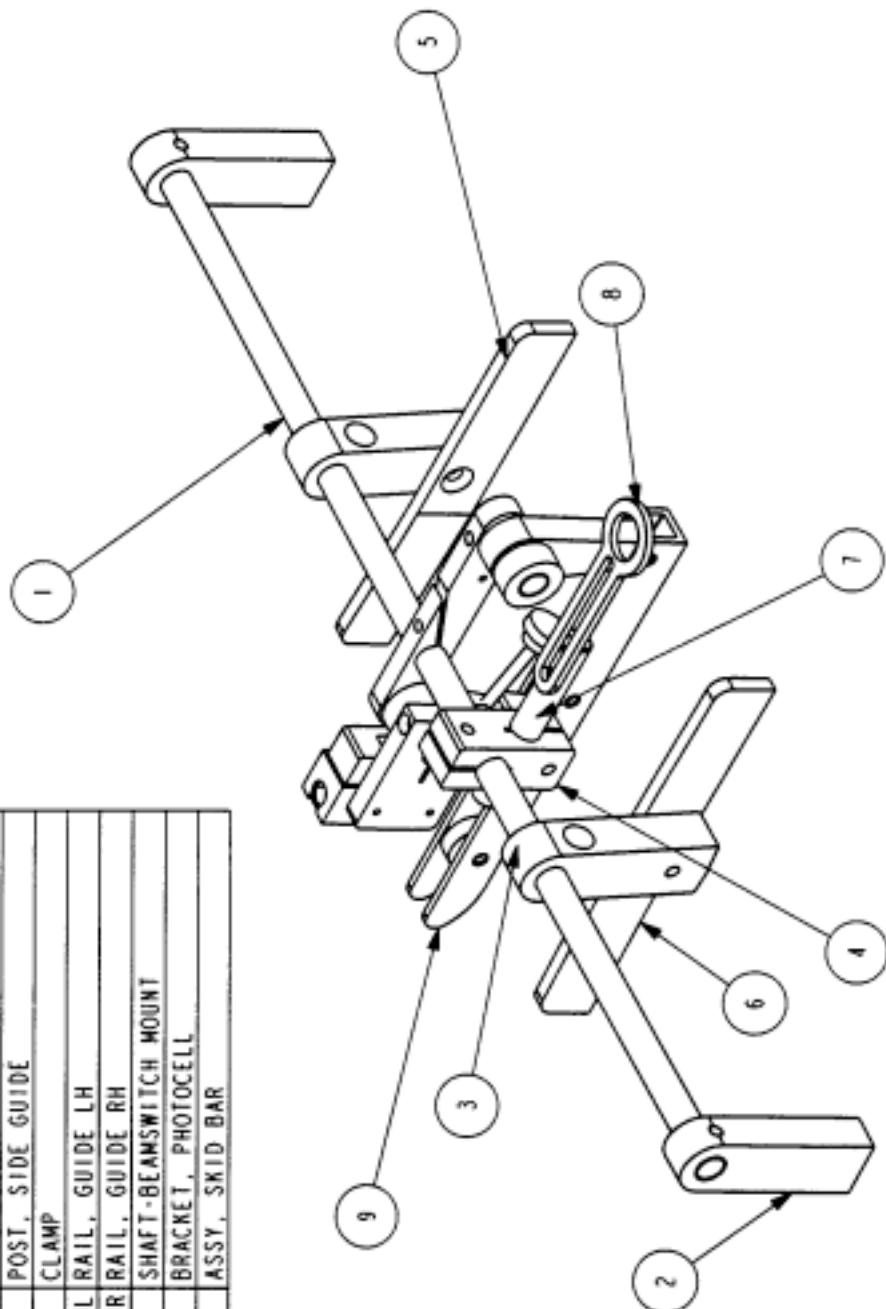


SCALE 0.500

ITEM NO:	SCALE	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	NOTES:
T JG	0 . 500	.00 -.005 .005 .005	XXX XXX XXX
ENCLURE NO:	REF:	INCHES & MM	MM
18-Feb-00	MATERIAL	REMOVED ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED	SP81400 1 OF 2
	MATERIAL	ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY	KIRK-RUDY, INC. KENNESAW, GEORGIA 538169-01 MATERIAL

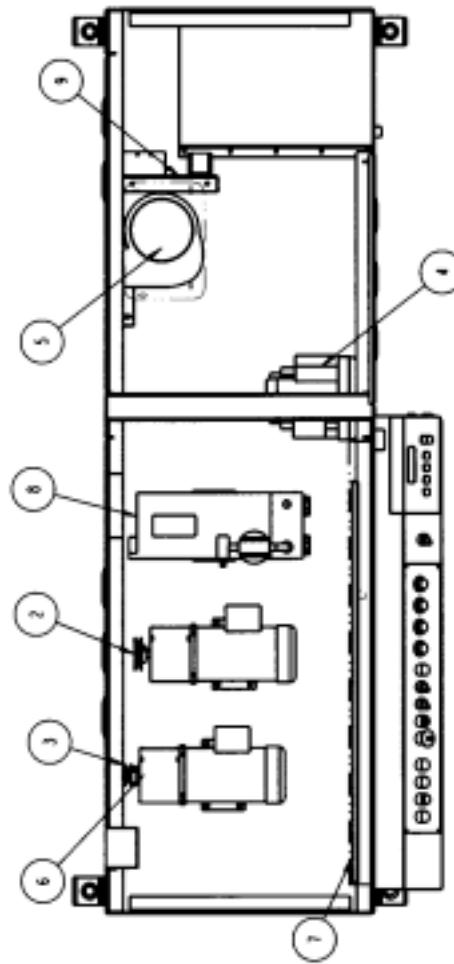
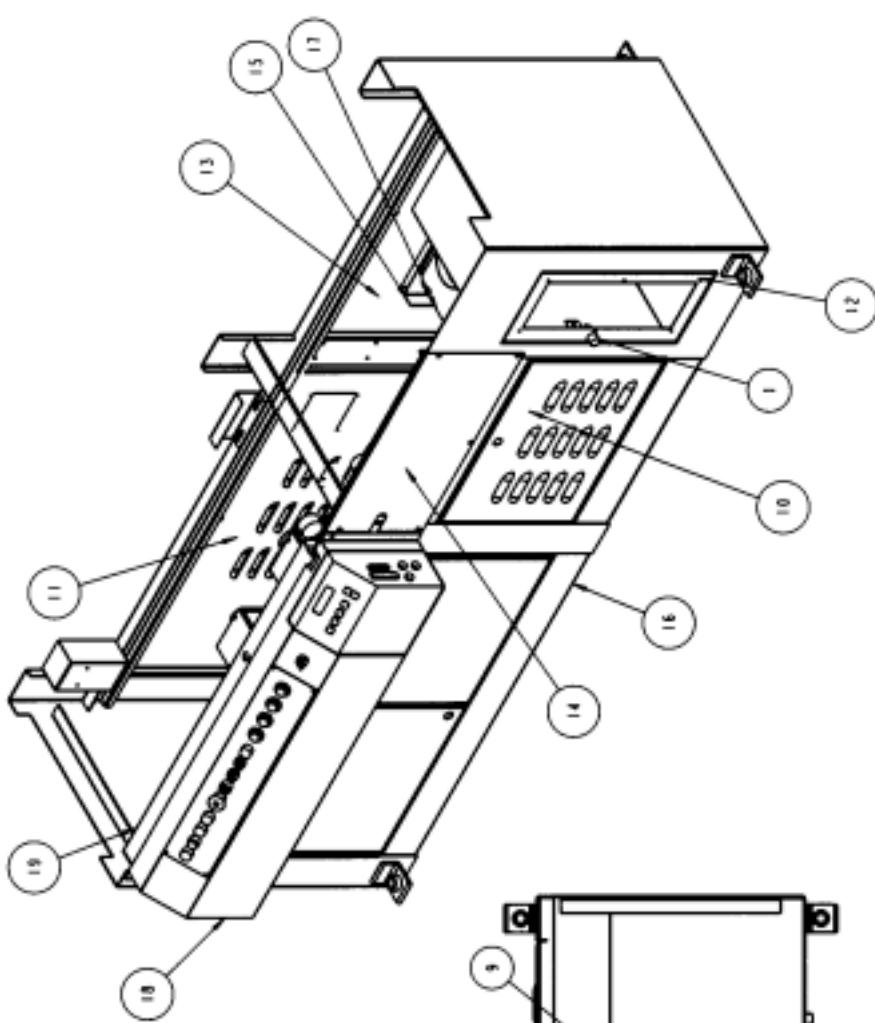
538269-01

ITEM	QTY	PART #	DESCRIPTION
1	1	500787	SHAFT-SIDE GUIDE ADJ.
2	2	500791	POST, SIDEGUIDE
3	2	500792	POST, SIDE GUIDE
4	1	508593	CLAMP
5	1	500722-24L	RAIL, GUIDE LH
6	1	500722-24R	RAIL, GUIDE RH
7	1	508995-1	SHAFT-BEAMSWITCH MOUNT
8	1	508996-4	BRACKET, PHOTOCELL
9	1	538021-01	ASSY, SKID BAR



ITEM #:	SCALE	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	NOTES:	REMOVED ALL PLATES AND SUPPORTS UNLESS OTHERWISE NOTED	TRIM ANGLE PROJECTION	PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE COPIED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC. KENNESAW, GA 30044 USA
CHECKER #: 17-Jan-00	0.375	.00 .000 .000	N/A	N/A	SP81400	KIRK - RUDY - INC. KENNESAW, GEORGIA
MAKER #: M	0.375	.00 .000 .000	N/A	N/A	SP81400	ASSY, SKIDBAR / SENSOR
					538188-01	DRAWING 1

PART #	DESCRIPTION
1 - 1	102143 KNOB, CABINET LATCH
2 - 1	105021 V-PULLEY, M30
3 - 1	105026 V-PULLEY, M40 2290
4 - 1	206120 BLOWER, GAST
5 - 1	206129 BLOWER, FAN
6 - 2	509093-0A ASSY, MINI-FDUCR SR 1/2HP VERT
7 - 1	528165-2 PANEL, WIRING 2151J
8 - 1	531168-01 ASSY, 1/2 HP VACUUM PUMP
9 - 1	531921-01 BELT(MNT), ELECTRICAL 803
10 - 1	534445-03 DOOR, FRONT, DROP OUT
11 - 1	534445-04 DOOR, REAR DROP OUT
12 - 1	536478-01 COVER, DOOR INSERT
13 - 1	536492-02 DOOR, DRIVER REAR
14 - 1	536493-02 COVER, DRYER SPHER FRONT
15 - 1	536284-01 BRACKET, BLOWER MOUNT
16 - 1	536285-01 M.DRNT, 2150 CABINET
17 - 1	536291-01 M.DRNT, AIR HOSE HNT
18 - 1	536292-01 ASSY, ELECTRICAL PANEL
19 - 1	536299-01 INSERT, 2150 ELECTRICAL



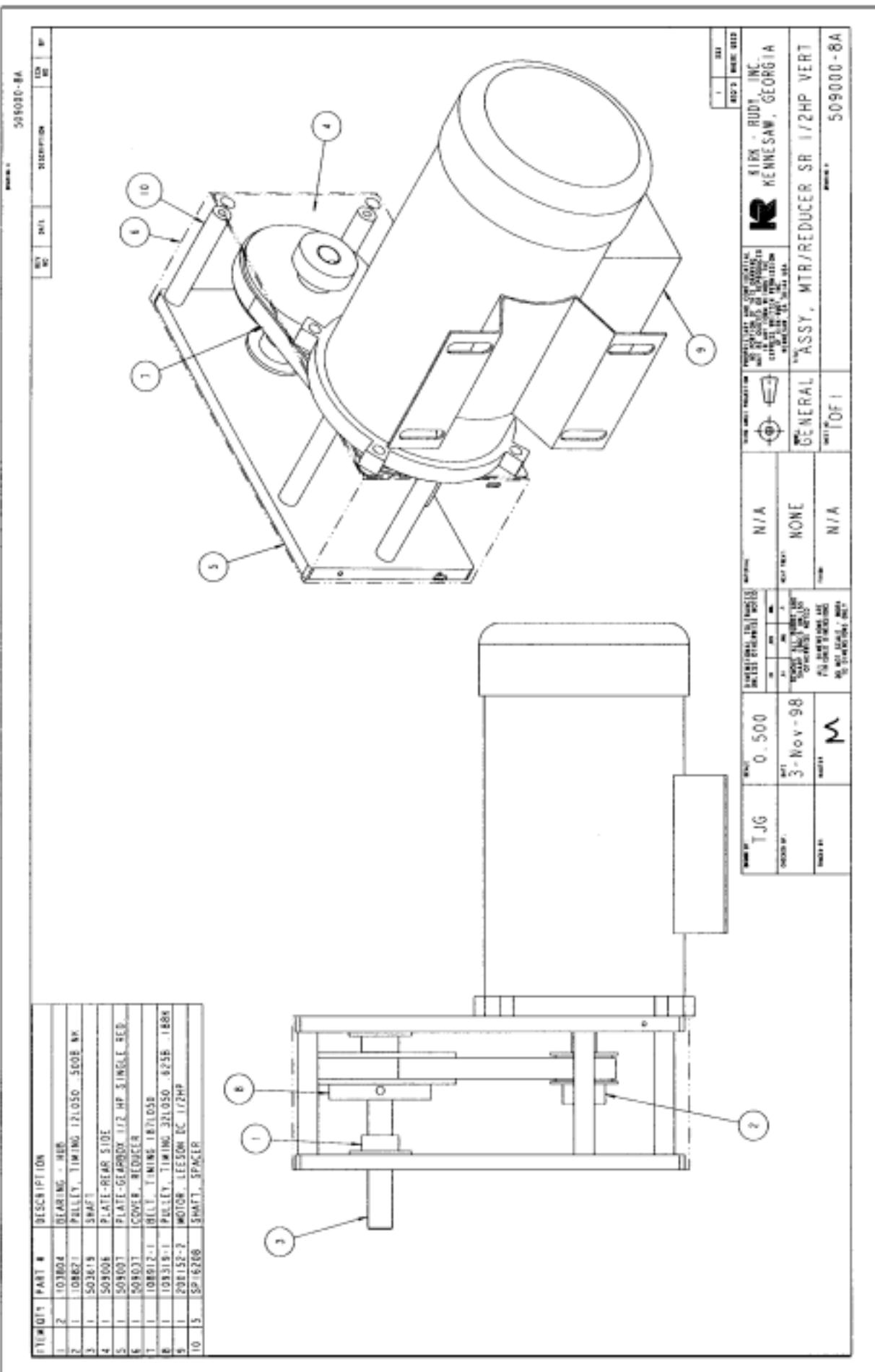
SCALE 0.090

REF ID:	DESIGN NO.	REV NO.	DATE ISSUED	REVISIONS	REMARKS
TJG	0 . 090			XXX	
25-Feb-00				XXX	
10000				XXX	

KIRK-RUDY INC.
KENNESAW, GEORGIA
ASSY, CABINET & COVERS
538288-01

1 216

REV 0 00000000



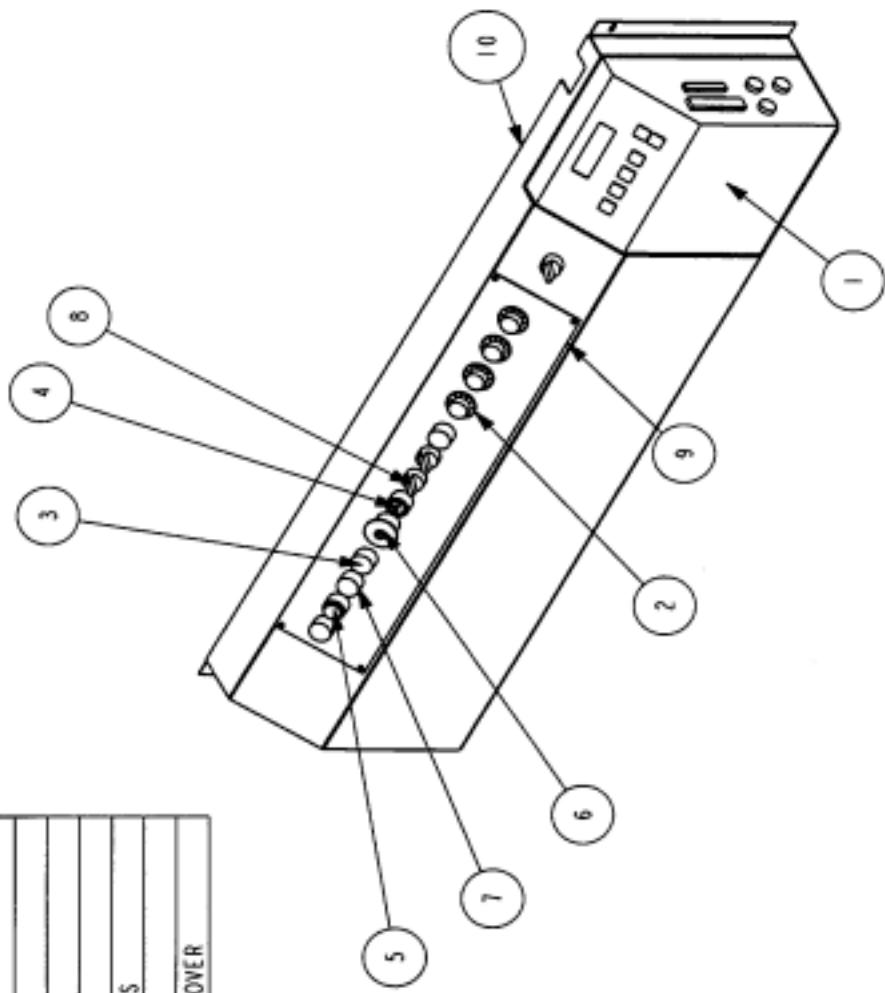
ITEM QTY	PART #	DESCRIPTION
1	190660	NIPPLE, 1/2 IN TUBING
2	200102	VALVE, RELIEF GAST 822/823
3	200108	STEM GAST 822/823
4	200109	PLATE GAST 822/823
5	200124	PUMP, VACUUM GAST
6	501645	BLOCK, CONNECTOR (VACUUM PUMP)
7	200100-1	GAUGE, VACUUM GAST 822/823
8	200100-2	FILTER, VACUUM GAST 822/823
9	200100-3	JAR, GLASS GAST 822/823
10	200100-13	NIPPLE, STEEL
11	200100-14	ELBOW, PIPE GAST 822/823
12	200100-16	COUPLING GAST 822/823
13	200100-21	NIPPLE, STEEL
14	200100-22	COUPLING, STEEL
15	200100-23	PLUG, SQUARE HEAD GAST 822/823
16	200100-26	COVER FOR AB992 GAST 822/823
17	200124-2	FILTER, FELT GAST 823
18	200124-4	END CAP, AN510 GAST 823
19	200124-5	MUFFLER, SINTERED GAST 823
20	200124-6	O-RING, GASKET GAST 823

1	215
RECD#	WHERE USED

1	215
RECD#	WHERE USED

DRAWING #: MY		SCALE: 0.156	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED		NOTED	TRIM ANGLE PROJECTION	PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE COPIED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY INC. KENNESAW, GA 30044 USA	
EXCHG'D BY:		DATE: 20-JUN-97	IN.	MM.	IN.	MM.		
REVIS'D BY:		MASTER	REMOVED ALL CORNERS AND SHARP EDGES UNLESS OTHERWISE NOTED		NONE	X	FILED:	ASSY, 1/2 HP VACUUM PUMP
			ALL DIMENSIONS ARE FLATBED MEASUREMENTS DO NOT SCALE - WORK TO DIMENSIONS ONLY		NONE	100%	DRAWING #	531168-01

ITEM QTY	PART #	DESCRIPTION
1	1	1001 WINKJET CONTROL MODULE
2	4	209016 KNOB, POT
3	2	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	2	201126-1 BUTTON, JOG
8	3	201145-1 SELECTOR, 2 POSITIONS
9	1	500421-1 PNL. CONTROL
10	1	538293-01 WLDNT. CONTROL BOX COVER



ITEM NO.	DATE	DESCRIPTION	ECN NO.	BR
1	215B			
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KRK KIRK - RUDY INC. KENNESAW, GEORGIA				
DRAWING #:				ASSY, ELECTRICAL PANEL
SCALE:				538292-01
MATERIAL:				
DIMENSIONAL TOLERANCES UNLESS OTHERWISE SPECIFIED				
IN .005 .005 .005				
MADE BY:				
CHECKED BY:				
MASTER BY:				

7 ELECTRICAL SCHEMATICS AND PARTS

7.1 SCHEMATIC LIST

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

109 500 26 110

7.2 PARTS LIST

8 APPENDIX

8.1 POSSIBLE OPTIONS

The KR215B 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 KR215B base:

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

9 NOTES

9 NOTES

10 WARRANTY AND SERVICE

WARRANTY

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

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

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

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

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

USE ONLY GENUINE KIRK-RUDY REPLACEMENT PARTS

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FX 770-427-4036