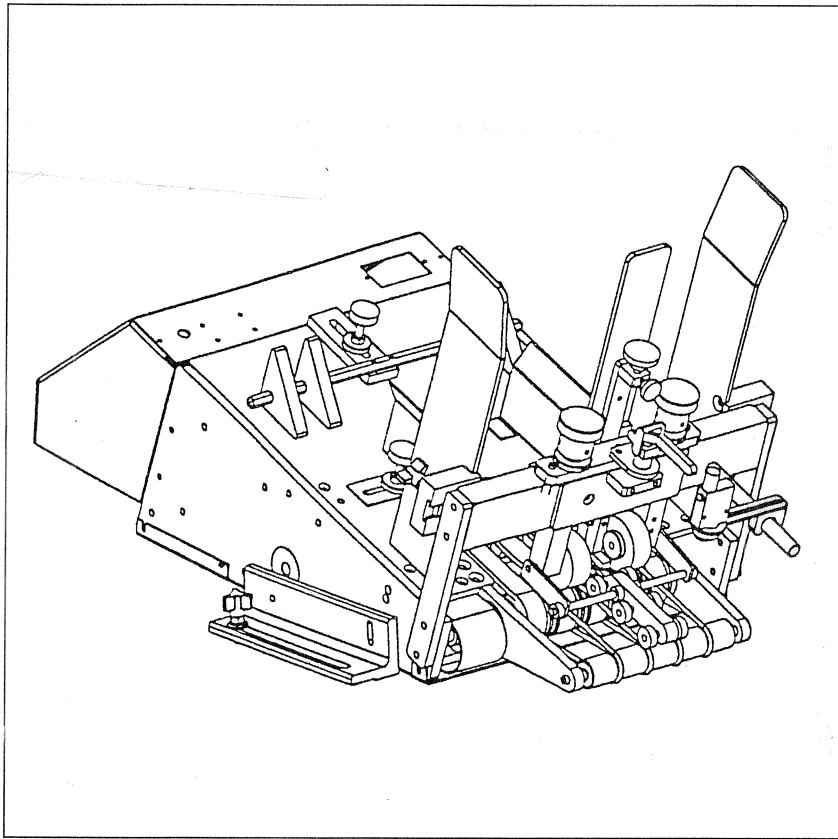


Kirk-Rudy, Inc.

Instruction and Parts Manual

496FC Friction Feeder



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.

10000-496FC REV. C 07/30/2001

Instruction
and Parts Manual

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1.0 Important Safety Instructions

Intended Use Statement: This product has been designed to feed paper products from a stack for the purpose of gathering, labeling and or inkjet printing. Product is loaded into a hopper with the bottom piece resting on high friction feed belts. The feeder drive motor runs continuous, when product is needed the clutch is engaged (triggered by an external device) and the belts move forward. Product is fed by the friction between the paper and belts pulling the bottom piece forward into a gap created by the feed belts and a set of top mounted, non-rotating rollers. A set of outfeed belts accelerates the product from the hopper area to produce a gap for batch counting and clutch disengagement. Usage for other purposes may lead to an unsafe condition.

SAVE THESE INSTRUCTIONS
Read all instructions before using this product.



WARNING

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

2. SPECIFICATIONS

<u>PRODUCT SIZE RANGE</u>	<u>English</u>	<u>Metric</u>
Minimum Size:	3" W x 4" L	76 mm W x 101 mm L
Maximum Size:	11.5" W x 12" L	29 cm W x 30.5 cm L
Minimum Thickness:	Card Stock (.004")	Card Stock (.10mm)
Maximum Thickness:	.25"	6 mm
Maximum Stack Height:	10"	25 cm

SPEED

Variable to 600 ft per minute maximum (continuous mode only)
Variable to 350 ft per minute maximum (all other modes)

FEED DIRECTION

Open end or folded edge leading.

MACHINE DATA (SEE NEXT SHEET FOR DRAWING)

Length:	26.63"	67.7 cm
Width:	16.63"	42.3 cm
Height:	17.05"	43.3 cm
Weight:	Net 53 lbs	21 kgs
	Shipping 75 lbs	29.5 kgs

ELECTRICAL DATA

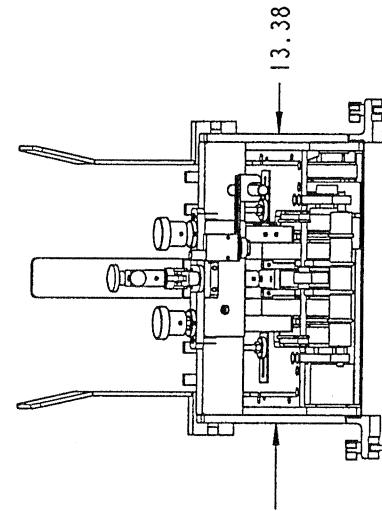
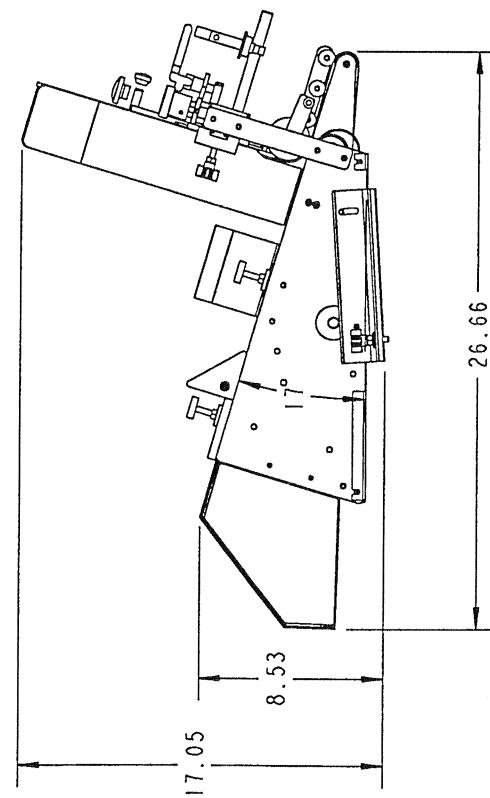
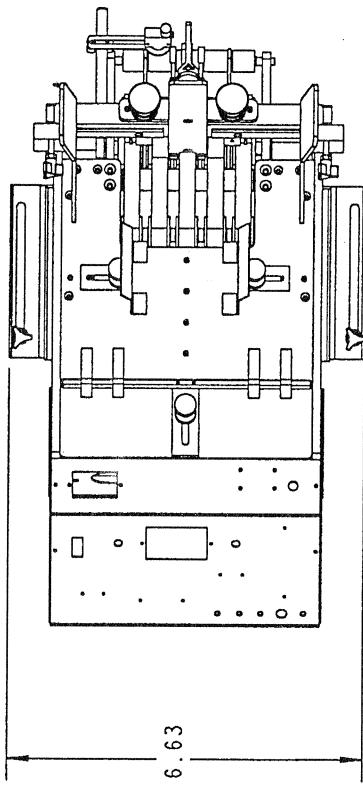
Main Power Input: 120 Volt, Single Phase, 60/50 Cycle, AC, 5 A.

OPTIONS

Bridge Extension Kits

535777-01	KIT, 14 IN WIDE 496F
535778-01	KIT, 16 IN WIDE 496F
535779-01	KIT, 18 IN WIDE 496F
535780-01	KIT, 24 IN WIDE 496F

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CHECKED BY:		DATE	.XX .XXX .ANG.	.01 .005 .5	HEAT TREAT: NOTED			
TRACED BY:		MASTER	17 - Nov - 98	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED	FINISH: NOTED	SHEET NO: 20F3	DRAWING #: ASSY , 496FC	496FC

3.0 UNCRATING

Remove machine and all packaging from crate. Inspect for damage.

The accessories and spare parts are boxed and located inside the crate. The box should be opened and checked against the packing list. Please check the enclosed checklist to insure all items have been received.

4.0 OPERATING INSTRUCTIONS



WARNING

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

4.1 OVERVIEW OPERATION MODES

496FC Motor Operation: In continuous mode, the motor will turn on and off when the lead machine does. In all other modes, the 496FC motor remains on and the clutch/brake unit will start and stop the feeding.

Machine Input Signals: The 496FC feeder may require an input signal depending on the options and the machine mode selected. This input signal can come from various devices (proximity, beamswitch, limit switch etc...), for simplicity this manual will assume a proximity switch will be used on a one to one ratio rotating shaft, other set ups are possible if needed. The external input signal on this shaft will be the start in signal.

Machine Mode Selector Switch: A selector switch on the console sets the 496FC to run in one of four modes. See below for a description of these modes.

Machine Modes

1. Continuous: This mode is used to feed product as a standard 496F machine. This is accomplished by keeping the clutch engaged and using the motor to control the starting and stopping of the friction belts. This is controlled by a stop in contact closure from the lead machine.
2. Demand: In this mode, an external signal engages the clutch. The outfeed beamswitch disengages the clutch when the leading edge of the next product blocks the beam. This stages the product for the next feed. If the staged product is pulled from the outfeed section, another piece will feed out (no external signal required) to stage the next piece.
3. Stage: This mode is used for gripper lugs to pull a single sheet from the feeder outfeed section. When the outfeed beamswitch is uncovered, the clutch will engage and feed until the outfeed beamswitch is covered with the next product.
4. Batch: This mode is used to feed out a predetermined number of pieces set through the PLC. An external signal will engage the clutch to start the feeding. The outfeed beamswitch will count the pieces and then disengage the clutch. The external input is also used to reset the counter to zero.

4.2 MISSFEED DETECT

Missfeed Detection: Missfeed is an error that occurs when product does not feed properly. The missfeed detection is used in the *demand* and *stage* modes only. This mode is enabled by pushing the Missfeed Enable toggle switch up.

Missfeed Detection Demand Mode: The sequence for this operation is:

1. The 496FC is powered up and it automatically feeds out product until the beamswitch is block. The product is staged on the outfeed belts of the feeder.
2. The feeder receives an external (start) in signal, the clutch engages and the staged product begins to feed.
3. The outfeed (round) belts pull on the staged product faster than the next available product that is driven by the friction (tan) belts. This produces a gap for the beamswitch to detect.
4. The beamswitch detects the gap and disengages the clutch and applies the brake. The product stops directly under the beamswitch blocking the beam.
5. The next external (start) in signal is received, if product is not blocking the beamswitch, a missfeed is detected and the stop out circuit is disabled to the stop the lead machine.

Missfeed Stage Mode: This method uses a timer (in the PLC) that is set by the user. If the outfeed beamswitch remains uncovered longer than the time set, a missfeed error will occur.

4.3 DOUBLE DETECT (OPTIONAL)

Double Detect: A double is two pieces of product coming out of the friction belts on top of each other and are detected using an emitter/receiver. The double detect amplifier module has two items that require set up which are dependent on product material and product print. The sensor sensitivity (see manufactures sheet) must be set up so it will read through one piece but not through two pieces. The amplifier module also has a timer that can be used to prevent false errors caused by text or product shingling. The timer requires that the sensor be blocked for a user set amount of time before it sends a stop signal. Reference Banner instruction sheet.

4.4 ELECTRICAL COMPONENT DESCRIPTION (see figure #1)

The following controls are located on the electrical box mounted on the rear of the feeder.

Main Power Switch: Press this switch up to turn the 496FC on. Press down to turn off. The switch will glow red when the power is on.

Drive Motor Speed Control: Turning this knob varies KR 496FC machine speed. 0 is minimum speed, 10 is maximum speed.

External (start) Input: 3-Pin electrical socket receives input signal to engage clutch and start feeding product in demand mode. This input is also used to reset counter in the batch mode.

Stop In: 2-Pin electrical socket input, which in the continuous mode, enables the drive motor. In demand, stage and batch modes, the 496FC motor runs regardless of this input, however, this input enables the clutch. When disconnected from the lead machine, a jumper plug must be inserted for the feeder to operate.

Stop Out: 2-Pin electrical socket, which opens a contact when a 496FC stop occurs. This would stop the lead machine.

Tach Input (optional): 3-Pin electrical socket receives an input for automatic speed control.

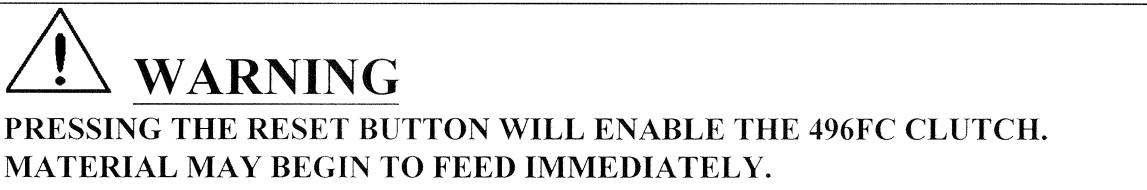
Missfeed Toggle Switch (optional): Switch in the up position enables missfeed detect, and down disables missfeed detect.

Double Detect Toggle Switch (optional): Switch in the up position enables double detect, and down disables double detect.

Clutch Enable Toggle Switch: Switch in the up position enables the clutch, and down disables the clutch.

Speed Control Manual/Auto Toggle Switch (optional): Switch in the up position (Auto) uses tachometer input to automatically control motor speed. Switch in the down position (Manual) uses speed pot to control motor speed.

Error Light: The error light on top of the electrical cabinet turns on at power up and on for missfeed and double errors. Light is turned off reset switch.



Reset Button:

Push this button to enable 496FC at power up and after machine errors.

PLC Interface Screen: The LCD interface screen is used for:

1. Monitor PLC Inputs and Outputs
2. Set parameters: \wedge and \vee arrow to choose parameter, $<$ and $>$ to select digits column, and OK to accept new value.
 - T1: Sets stage missfeed time out
 - C1: Sets batch mode product count
 - C2: Product count. Resets at power down
3. Check product counter (counter resets at power down)

Double Detect Amp Module or Counter (both optional): The double detect amp module is used to control the double detect sensitivity and timed functions. If double detect is not optioned, a counter may be installed.

Outfeed Beamswitch: Monitors product feeding. This signal is used for counting product, starting and stopping the clutch/brake unit.

External (start) In: Used only in the demand and the batch mode to engage the clutch. In demand mode, mount this sensor such that one pulse occurs per machine cycle. In batch mode, this input resets the batch count and enables the clutch.

Electrical Safety Features: The 496FC has an input fuse, and the motor is separately fused.

4.5 MECHANICAL COMPONENT DESCRIPTION (see figure #2)

Feed Belts: Grooved rubber belts pull the bottom piece forward into the gate area.

Outfeed Section: This section has round belts to speed up the product therefore, producing a gap between products for beamswitch detection. See Outfeed Section 4.7 for more information.

Wedge: The wedge assembly is used to lift the backside of the product off the feed belts. This reduces surface contact area between the feed belts and product and has an affect on the gap between product as the feeder is running.

Side Guides: Keeps the stack of product together and helps keep product feeding straight.

Gate Bar: Provides a front guide for the stack and a mounting surface for curved plates, which keep the lead edge of the stack from contacting the retard rollers. A vertical adjustment allows for product thickness changes.

Gate Bar Locking Knob: Secures the gate bar in place. Loosen this knob to vertically adjust the gate bar.

Jam Release Lever: Raises the retard roller and gate bar as an assembly to clear jams.

Retard Roller: A non-rotating urethane roller. A gap between the retard roller and feed belts prevents double feeds. Rotate the roller for a new wear surface.

Retard Roller Vertical Adjustment Knob: Provides vertical adjustment of the retard roller. A locking collar at the base of the knob secures the roller in place.

Retard Roller Vertical Locking Ring: Used to lock the vertical height of retard rollers.

Mounting Angle: Secures the feeder to the mounting bars. Slots allow front to back adjustment of the feeder. An angular slot in the side of the angle provides rotational adjustment of the feeder.

Bearing Skid Bar: This bar located above the round belts provides friction between the product and belt. The friction created between the round belt and product will be used to stop the product and accelerated it from the outfeed section.

4.6 FEEDER SETUP

1. Power is off.
2. Slip one piece of product under one of the retard rollers and turn the adjustment knob clockwise lowering the roller onto the paper until the roller just contacts the paper. Raise the roller until the piece is just free to move and slides easily under the roller. Use the same procedure to adjust the other roller.
3. Remove the paper and lower the gate bar until approximately 1/64" of the retard roller extends below the gate bar deflectors. If too much of the retard roller extends past the gate bar, the leading edge of the product will tend to curl as it contacts the retard roller.
4. Center the product on feeder and position the front and middle side guides 1/32" from each edge.
5. Position the wedge bar to lift the backside of the stack off the feed belts. Slide the wedges along the mounting bar to provide equal support along the backside of the product.
6. Fan and shingle a small stack of product so the lead edge will conform to the curved plates on the gate bar. Place in hopper and slide the feed belts forward until the product is forced into the gate bar and conforms to the curved plates. Finish loading hopper.
7. DEMAND MODE ONLY: Set input signal proximity switch timing. Set magnet to trigger proximity when product is required. This position may change depending on belt speed.
8. Turn speed control to zero and turn power on.
9. Slowly turn the speed control knob to increase motor speed.
10. Use toggle switch to engage clutch and check feeder set up.
11. Secure the gate bar locking knob and retard roller locking ring.

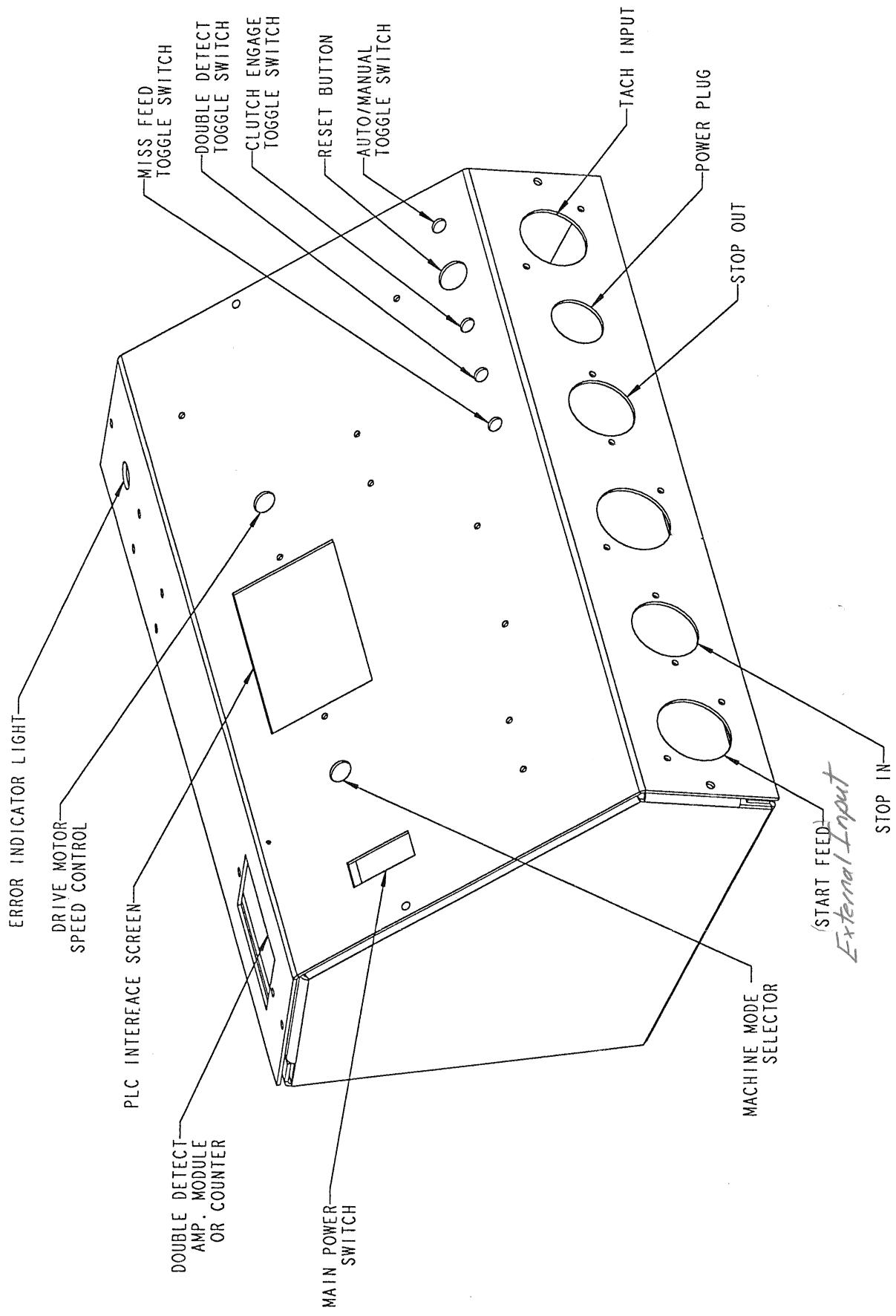
4.7 OUTFEED SECTION

Purpose: The outfeed section uses round belts to accelerate the product away from the retard rollers. This speed up produces a gap between product for counting and clutch off signals. The round belts are mechanically connected to the friction belts and only moves when the friction belts are moving. Depending upon product length more than one piece may be staged in the round belt section. The position of the outfeed beamswitch can be moved to expel the last piece if needed. Increasing the belt speed can also expel the last piece. The product stop point will vary dependent on belt speed (faster belt speed=longer stopping distance). The stopping distance must not be longer than the product. The grip between product and round belt is controlled with the bearing skid bar.

4.8 EXTENDED OUTFEED SECTION (OPTIONAL)

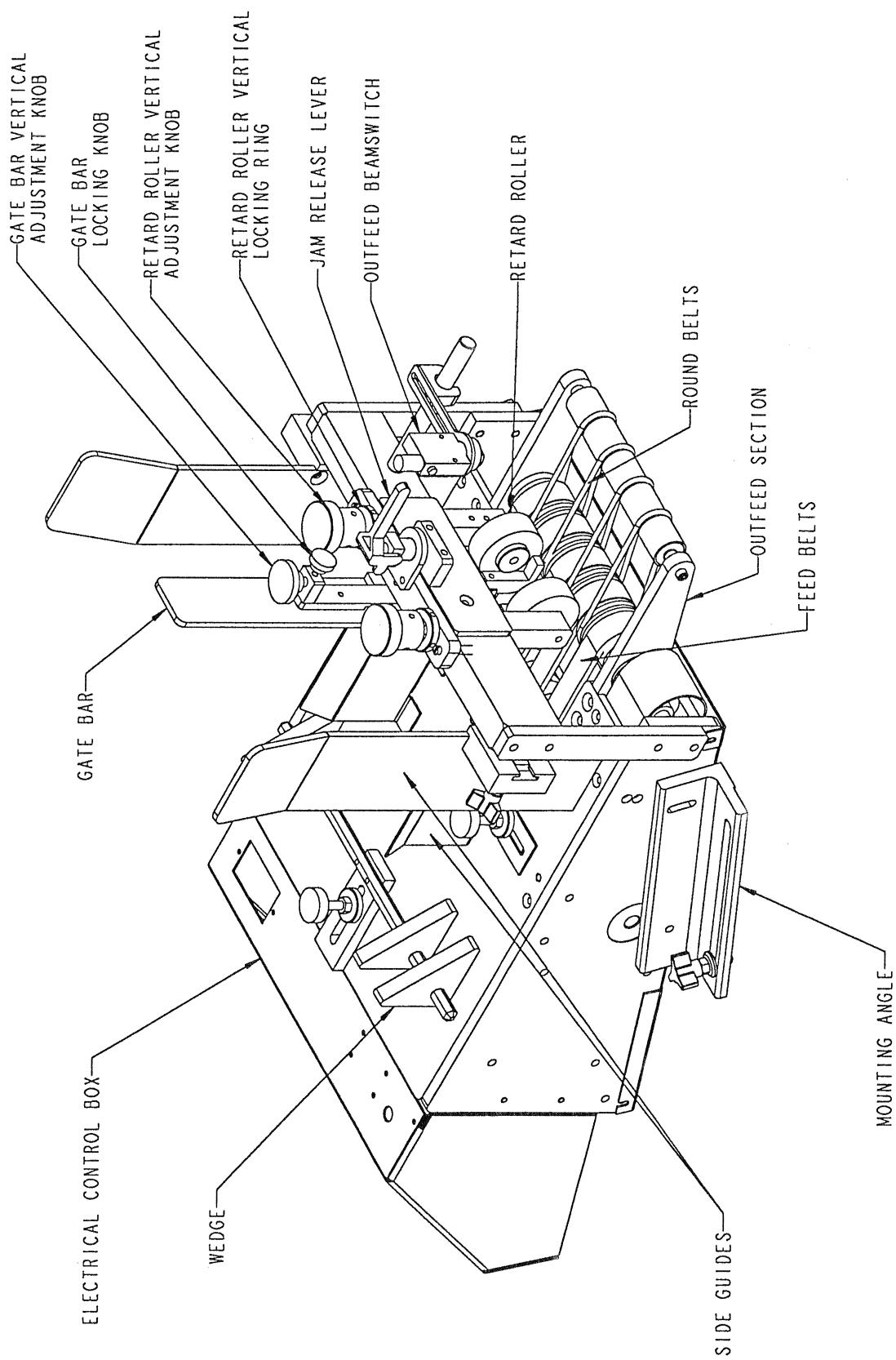
This optional outfeed section has upper and lower round belts for better product control. Contact Kirk-Rudy Inc. for these special applications.

FG000139



ELECTRICAL COMPONENT DESCRIPTION
FIGURE #1

FG000140



MECHANICAL COMPONENT DESCRIPTION
FIGURE #2

5.0 ASSEMBLY ONTO FEED BASE



WARNING

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

5.1 MECHANICAL FEEDER INSTALLATION

KR 215 IJ (CONTINUOUS MODE) AND KR 215 LABEL HEAD (DEMAND MODE)

1. Remove jogger table locking knob and rotate table clear of shuttle table area.
2. Jog the feed base to position the shuttle table in the forward position and the lower feed rollers in the up position. **Remove the change gear from KR215 base.** This will allow the lower feed roller to remain in the up position and disable the shuttle motion.
3. Remove the four flat head screws from the KR 215 tabletop.
4. Attach the feeder mounting bars to the KR 215 tabletop replacing the four flat head screws with the four #10 x 1" cap screws supplied with the feeder.
5. Position the KR 496FC onto the mounting bars. Continuous Mode: Locate the feeder on the base so the lead edge of the piece enters the KR215 feed rollers as the trailing edge of product passes through centerline of the retard rollers. Demand Mode: Locate the feeder on the base so the lead edge of product stops .25"-.50" before the KR 215 feed rollers. The trailing edge of product should have 1-1.5" of friction belt contact.

5.2 ELECTRICAL FEEDER INSTALLATION

Continuous Mode:

1. Connect the Stop In two-pin twist plug from the electrical kit into the receptacle on the feeder.
2. Turn the KR 496FC speed pot to zero then run the KR 215 at desired speed. Increase KR 496FC speed until the gap between product is minimized.

Demand Mode:

1. Connect the Stop In two-pin twist plug into the receptacle on the feeder.
2. Connect the External (start) In three-pin twist plug to feeder. Mount the proximity and magnet ring to a rotating shaft that is in time with lugged base.

6.0 TROUBLE SHOOTING



WARNING

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

PROBLEMS	SOLUTION
Feeder does not run	Check jumper plug on electrical box. If the feeder is not electrically connected to the transport base, a jumper plug must be inserted into the socket to complete the circuit.
Motor does not run	Check fuses in motor board. Check electrical schematic at end of manual.
Inconsistent feed	Clean belts Adjust wedge position Reorient product in hopper (rotate 90 degrees or offset product to one side.)
Product does not feed out one piece at a time. Continuous stream of product.	Gap is not being produced between product. Adjust retard roller and/or gate down in small increments to decrease product shingling. Do not lower retard rollers so low that product will not fit between friction belts and retard roller. Damage to machine clutch and/or friction belts may result. Move wedges in more to decrease friction belt contact area. Product should exit friction belts end to end not overlapping (shingled). Beamswitch may need to be moved more downstream (gap between products is larger).
Product feeding sensitive to product stack height	Adjust wedge position.
Double feeds	Lower the retard rollers. Do not lower retard rollers so low that product will not fit between friction belts and retard roller. Damage to machine clutch and/or friction belts may result. Bend or fan product prior to loading hopper. Adjust wedge position. Decrease product stack height. Spread wedges apart to bow product in the hopper. This will tend to stiffen the lead edge.
Product skews as it feeds	Balance the gap between the two retard rollers. If the product is thicker on one, independently adjust the retard rollers to compensate for thickness variation. Angle wedge bar to reduce traction on one side of friction belts.

7.0 MAINTENANCE



WARNING

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

7.1 LUBRICATION

No parts on the KR 496FC require lubrication. Refer to the motor specification sheet for maintenance information.

7.2 FEED BELT TENSION

Belts should be installed with a snug fit, neither too tight nor too loose. High tension will shorten belt and bearing life. Tension belts only enough to prevent them from slipping on the pulley. Provisions have been made for center distance adjustment for ease in installing and removing belts. Do not force belts over pulley flanges.

The round, green out feed belts are made from an elastic material and do not require tensioning.

7.3 FEED & ROUND BELT REPLACEMENT PROCEDURE

Molded natural rubber feed belts are seamless and can run in either direction. When replacing feed belts, replace them as a group since the belts in one group may not be the same length as the belts from another group.

1. Remove feeder from power source.
2. Remove sheet metal guards.
3. Remove the four flat head screws that secure the feed belt assembly to the feeder.
4. Slide the drive belt off the pulley shaft and remove the assembly.
5. Loosen belt tension by turning belt tension screws counterclockwise.
6. Remove both screws securing out feed idler shaft.
7. Remove screws that secure the left side bearing plate to the idler shafts.
8. Loosen left side hub bearing set screws.
9. Remove left side bearing plate.
10. Replace belts.

11. Reassemble in the opposite order. Make sure all guards are re-installed.

7.4 DAILY MAINTENANCE

Daily Functions of Operator		
Item	Function	Remarks
Clean belts	Remove paper dust.	Use clean soft rag soaked in water. Do not use solvents to clean belts.

8.0 PARTS LIST AND DIAGRAMS

8.1 Parts List

Item	Qty	Part #	Description
1	00001	100132	BUSHING, SLEEVE .250
2	00001	102113	KNOB, PLASTIC
3	00001	102114	KNOB
4	00004	102119	KNOB
5	00003	102131	KNOB
6	00004	102223	COLLAR, .250
7	00002	102301	SHIM, .500X .750X .125
8	00002	102787	SPRING
9	00006	103105	BEARING, FLAT .250 ID .750 OD
10	00005	103106	BEARING, FLAT .375
11	00010	103110	BEARING, FLAT .625
12	00004	103803	BEARING, HUB .500
13	00001	104036	CLUTCH/BRAKE, INERTIA DYNAMICS
14	00004	104100	SNAP RING, .375
15	00010	104104	SNAP RING, .625
16	00004	106419	BELT, ROUND
17	00005	106434	BELT, FEED
18	00002	107334	BOLT, HEX HO MACH
19	00001	109120	BELT, TIMING HTD 70-5M-15
20	00002	109708	PULLEY, TIMING 205M15 .500B .125K
21	00001	109711	PULLEY, TIMING 325M15 .500B .125K
22	00001	109712	PULLEY, TIMING 365M15 1.00B NK
23	00001	190733	CLAMP, QUICK RELEASE
24	00002	500755	CLAMP, SIDE GUIDE
25	00002	500807	NUT, LOCK
26	00001	500809	SLEEVE, THREADED
27	00002	501093	WASHER
28	00001	501629	CLAMP, GUIDE STRIP
29	00001	502232	BLOCK, GATE BLADE
30	00004	502255	SPACER, GEAR COVER
31	00002	502261	ROLLER, UPPER FEED
32	00001	109121-1	BELT, TIMING HTD 107-5M-15
33	00001	200165-1	MOTOR, DC 1/4 HP
34	00001	202261-5	BEAMSWITCH, RETRO REFLECTIVE
35	00001	496FC	ASSY, 496FC

Item	Qty	Part #	Description
36	00002	500799-6	STUD, BRIDGE (LONG)
37	00002	500812-2	KNOB, ROLLER ADJUSTMENT
38	00001	502233-R	GIB
39	00001	502233-L	GIB
40	00001	530471-04	ROLLER, DRIVE
41	00002	530472-01	BLOCK, BEARING
42	00002	530473-02	SHAFT, FRICTION IDLER
43	00001	530475-01	ROLLER, OUTFEED IDLER
44	00001	530475-02	ROLLER, FRICTION BELT IDLER
45	00005	530476-01	ROLLER, BELT IDLER
46	00002	530478-01	PLATE, DEFLECTOR
47	00001	530481-01	SHAFT, BELT IDLER
48	00005	530484-01	ASSY, BELT IDLER ROLLER
49	00001	530488-01	SHAFT, DRIVE
50	00001	530528-01	ANGLE
51	00001	530528-02	ANGLE
52	00001	530529-02	PLATE, RH FRAME
53	00001	530534-01	PLATE, MOTOR MTG
54	00001	530544-01	SIDE GUIDE, RH
55	00001	530545-01	SIDE GUIDE, LH
56	00001	530548-01	BAR, CROSS
57	00001	530549-01	ASSY, BACK STOP
58	00001	530675-01	BAR
59	00001	530728-01	BAR, SPACER
60	00001	530730-01	TABLETOP
61	00004	530731-01	WEDGE
62	00002	530753-01	BAR
63	00002	530754-01	STUD
64	00001	530755-01	ASSY, ROLLER
65	00001	530756-01	PLATE, QUICK RELEASE
66	00001	530757-01	BAR, BRIDGE
67	00001	530758-01	PLATE
68	00002	530785-01	ASSY, KNOB
69	00002	530787-01	ASSY, KNOB
70	00002	530788-01	SIDE GUIDE

Item	Qty	Part #	Description
71	00003	530789-01	ASSY, KNOB ROUND CAP
72	00001	530887-01	ASSY, BRIDGE
73	00001	530888-01	BLOCK, QUICK RELEASE
74	00001	530889-01	PLATE, QUICK RELEASE
75	00001	530890-01	GATE, CENTER ROLLER
76	00001	530893-01	GUIDE, FRONT
77	00002	530908-01	BAR, BRIDGE MTG
78	00002	530910-01	ANGLE
79	00001	530911-02	PLATE, LH FRAME
80	00001	530912-01	COVER, BOTTOM
81	00001	532138-01	SHAFT, C-CLAMP
82	00001	533336-01	ASSY, FRICTION BELT IDLER
83	00001	533337-01	STOPPER, CLUTCH KICKER
84	00001	534911-01	ASSY, FRICTION BELTS
85	00001	535017-01	WELDMENT, ELEC. CONTROL BOX
86	00001	535018-01	ASSY, ELEC. CONTROL BOX
87	00001	535019-01	COVER, ELEC. CONTROL
88	00001	535020-01	BOX, ELEC. FRAME
89	00001	535031-01	SHAFT, CLUTCH DRIVE
90	00001	535032-01	ASSY, ELEC. CONTROL BOX
91	00001	535033-01	ASSY, 496 FRAME
92	00001	535034-01	ASSY, MOTOR DRIVE
93	00001	535050-01	ASSY, BEAMSWITCH MOUNT
94	00001	535051-01	ASSY, OUTFEED SKID BAR
95	00001	535176-01	BAR, SKID
96	00001	535177-01	SHAFT, SKID BAR
97	00002	535178-01	PLATE, SKID BAR
98	00004	CSDD267	
99	00002	CSDD294	
100	00003	CSDD298	
101	00007	RHN010	
102	00001	SP37361	BRACKET, PHOTOCCELL
103	00001	SP49620	SPACER
104	00001	SP49625	COVER
105	00002	SP49631	BLOCK, TABLETOP SUPPORT

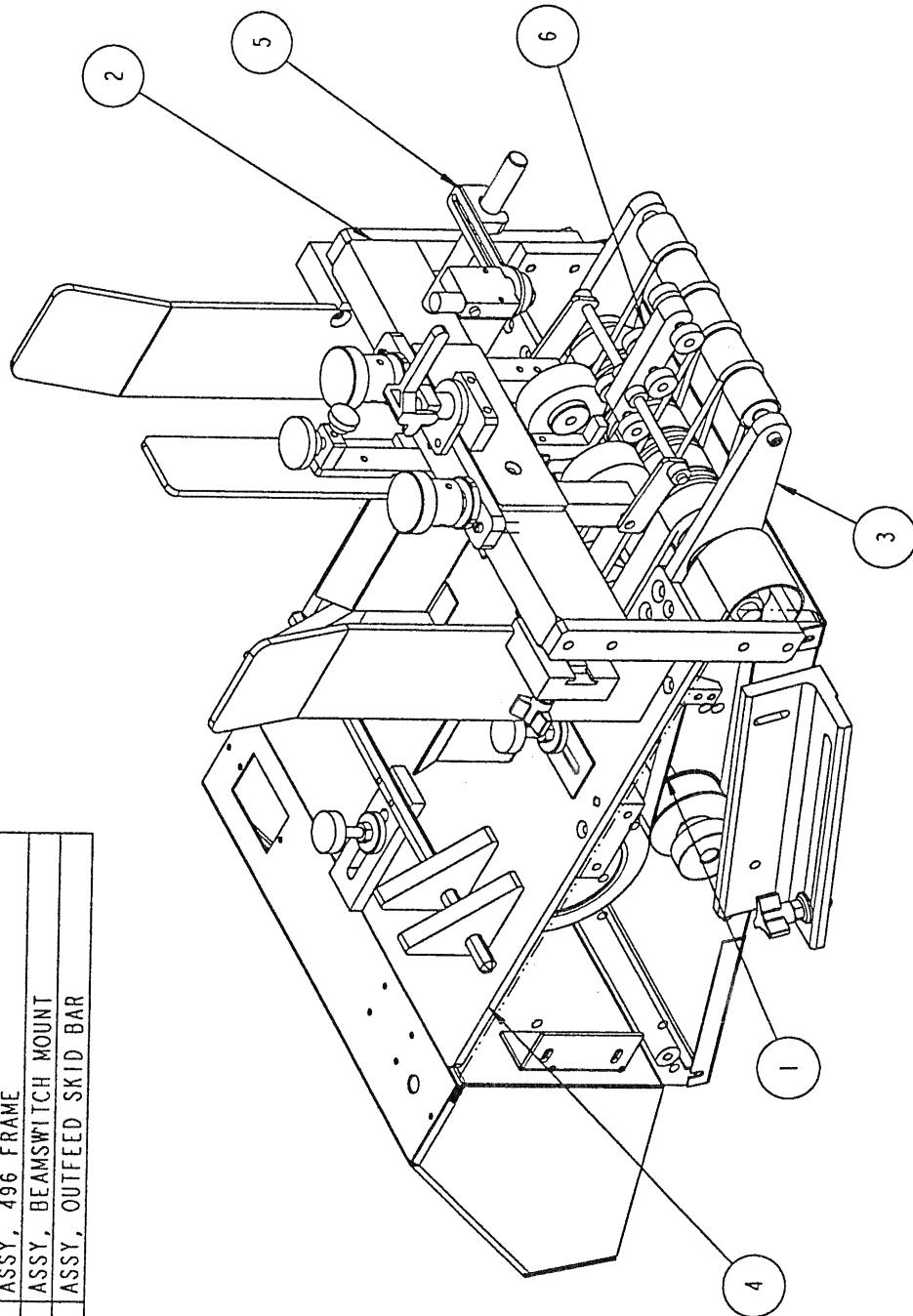
Item	Qty	Part #	Description
106	00002	SP49675	BAR, SLIDE
107	00001	SP49662-1	PLATE, SIDE COVER LH
108	00001	SP49662-2	PLATE, SIDE COVER RH
109	00005	SP6383-1	WASHER
110	00004	SYA601	

8.2 Diagrams

Assembly Diagrams: Prints (located after parts manual) are shown in order as indicated below. Sub-assemblies are indented under the main assemblies.

DIAGRAM #	DESCRIPTION
496FC	ASSY, 496FC
530887-01	BRIDGE ASY
534911-01	ASSY, FRICTION BELTS
533336-01	ASSY, FRICTION BELT IDLER
530484-01	ASSY, BELT IDLER ROLLER
535033-01	ASSY, 496 FRAME
530549-01	BACKSTOP ASY
535018-01	ASSY, ELECT. CONTROL BOX
535032-01	ASSY, CLUTCH SHAFT
535034-01	ASSY, MOTOR DRIVE
535050-01	ASSY, BEAMSWITCH MOUNT
535051-01	ASSY, OUTFEED SKID BAR

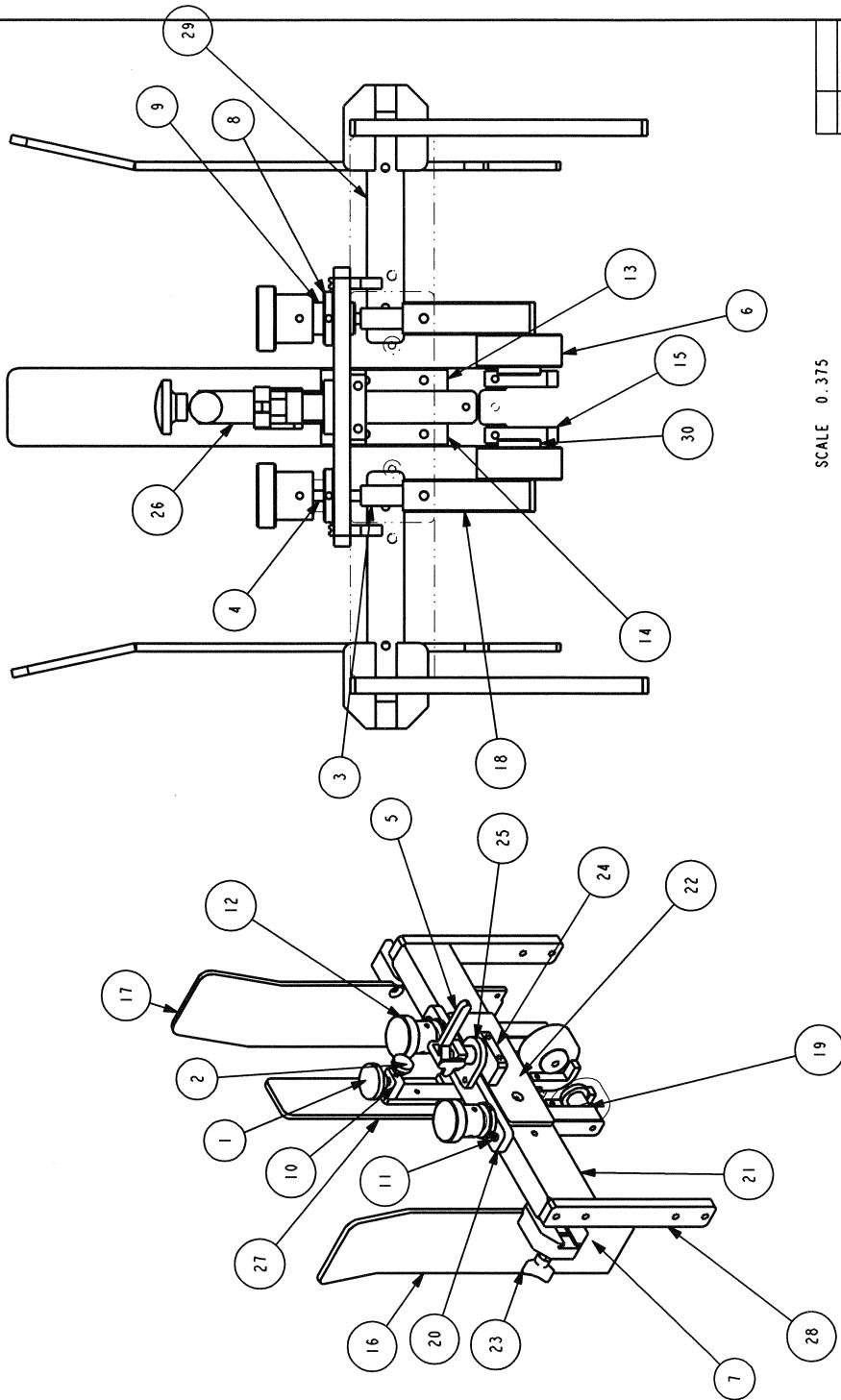
ITEM QTY	PART #	DESCRIPTION
1	109121-1	BELT, TIMING HTD 107-5M-15
2	530887-01	BRIDGE ASSY
3	1	534911-01 ASSY, FRICTION BELTS
4	1	535033-01 ASSY, 496 FRAME
5	1	535050-01 ASSY, BEAMSWITCH MOUNT
6	1	535051-01 ASSY, OUTFEED SKID BAR



REV NO	DATE	DESCRIPTION	ECN NO	BY
1	496FC			

DRAWN BY:		SCALE	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	MATERIAL:	NOTED	THIRD ANGLE PROJECTION	PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE QUOTED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC. KENNESAW, GA 30144 USA
DATE	16 - Nov - 98	.01 .005 .005	ANG.	HEAT TREAT:	NOTED		
CHECKED BY:							KIRK - RUDY, INC. KENNESAW, GEORGIA
TRACED BY:							
MASTER:	M			FINISH:	NOTED	SHEET NO. 10 OF 1	DRAWING #

ITEM	QTY	PART #	DESCRIPTION	REV NO	DATE	REvised DRAWING NO	ECN NO
1	1	102113	KNOB, PLASTIC	1	12/15/2000		
2	1	102114	KNOB	2	10/31/01	REPLACE 502261 WITH 500145	6151
3	2	102787	SPRING				JPI
4	2	107334	BOLT, HEX HO MACH				
5	1	190133	CLAMP, QUICK RELEASE				
6	2	500145	ROLLER, UPPER				
7	2	500155	CLAMP - SIDE GUIDE				
8	2	500807	NUT - LOCK				
9	2	500809	SLEEVE - THREADED				
10	1	502232	BLOCK, GATE BLADE				
11	2	500199-6	STUD, BRIDGE (LONG)				
12	2	500812-2	KNOB, ROLLER ADJUSTMENT				
13	1	502233-R	GIB				
14	1	502233LH	GIB				
15	2	530478-01	DEFLECTOR PLATE				
16	1	530544-01	SIDE GUIDE, RH				
17	1	530545-01	SIDE GUIDE, LH				
18	2	530153-01	BAR, RETARD ROLLER MOUNT				
19	2	530154-01	STUD				
20	1	530156-01	PLATE, QUICK RELEASE				
21	1	530157-01	BAR, BRIDGE				
22	1	530158-01	PLATE				
23	2	530187-01	KNOB ASY				
24	1	530888-01	BLOCK, QUICK RELEASE				
25	1	530889-01	PLATE, QUICK RELEASE				
26	1	530890-01	GATE, CENTER ROLLER				
27	1	530893-01	FRONT GUIDE				
28	2	530908-01	BRIDGE MTG BAR				
29	2	SP49675	BAR, TOP SLIDE				
30	2	SP6383-1	SPACER, GEAR COVER				



SCALE 0.375

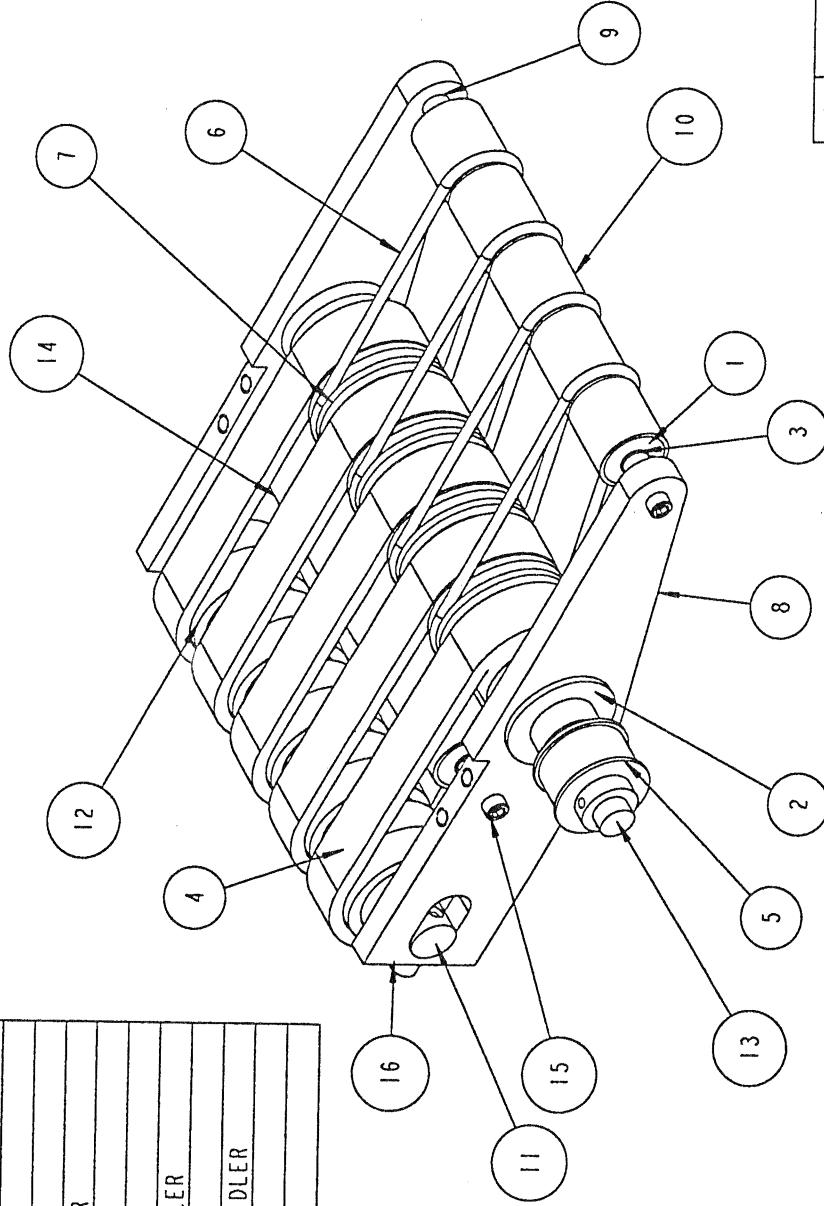
REF ID:	NAME	SCALE	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	NOTES:	REMARKS:	REMOVED WHERE USED
TVK	0 . 250	.000 .005	.000 .005	XXX	XXX	
CHECKED BY:	DATE	.000 .005	.000 .005	WEAR TEST:	NONE	
TRACED BY:	MASTER			TIME:	XX X	SET TO 0F 1

PRINTED ON 02 - MAY - 97
BY KIRK - RUDY, INC.
142 KENNEBUNK, GEORGIA
EXCLUSIVELY PRODUCED
PROPRIETARY AND CONFIDENTIAL
NO PORTION OF THIS DRAWING
MAY BE COPIED OR REPRODUCED
IN WHOLE OR IN PART
EXCEPT AS EXPRESSLY AUTHORIZED
IN THE CONTRACT
EFFECTIVE, ONE YEAR FROM USA
PRINTED ON 02 - MAY - 97
BY KIRK - RUDY, INC.
142 KENNEBUNK, GEORGIA
EXCLUSIVELY PRODUCED
PROPRIETARY AND CONFIDENTIAL
NO PORTION OF THIS DRAWING
MAY BE COPIED OR REPRODUCED
IN WHOLE OR IN PART
EXCEPT AS EXPRESSLY AUTHORIZED
IN THE CONTRACT
EFFECTIVE, ONE YEAR FROM USA

ASSY, BRIDGE 496F

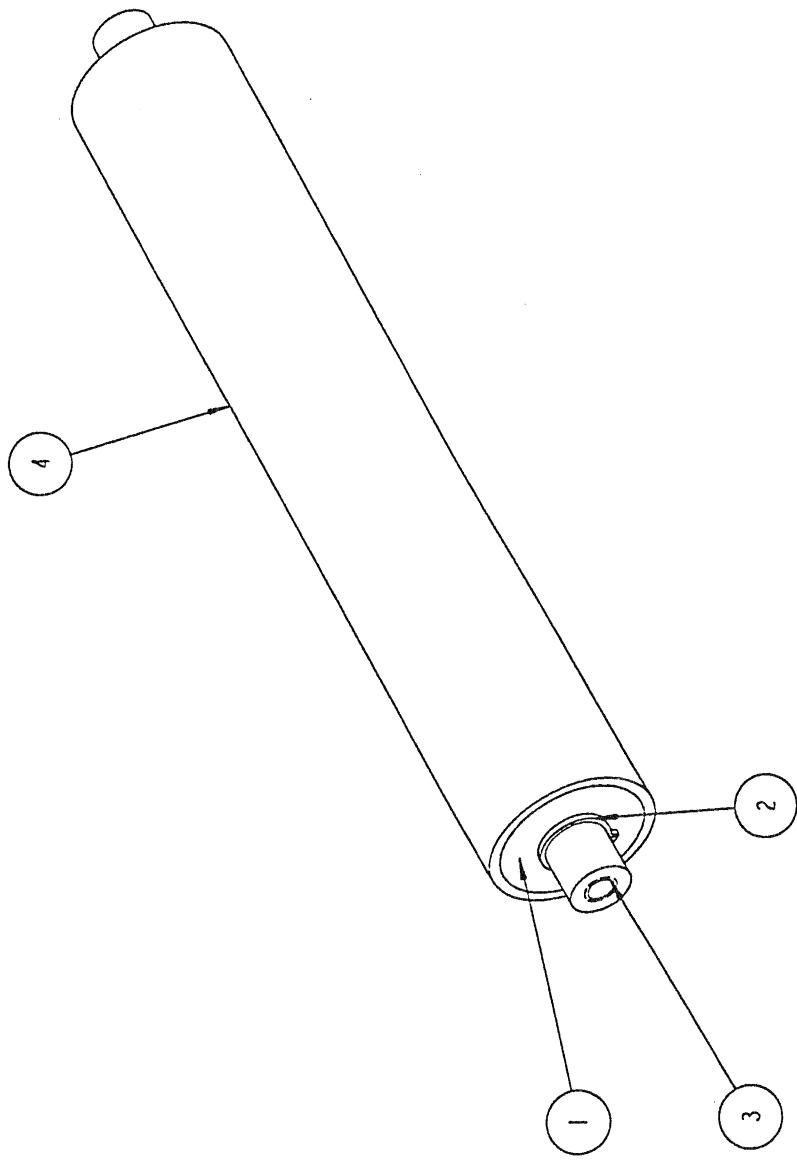
DRAWING 1
530887-01

ITEM QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	FCN NO	BY
1	3	103106 BEARING, FLAT .375					
2	2	103803 BEARING, HUB .500					
3	2	104100 SNAPPING, .375					
4	5	106434 FEED BELT					
5	1	109708 PULLEY, TIMING 205M15 .500B .125K					
6	4	106419-1 ROUND BELT					
7	1	530471-04 ROLLER, DRIVE					
8	2	530472-01 BEARING BLOCK					
9	1	530473-02 SHAFT, FRICTION IDLER					
10	1	530475-01 OUTFEED IDLER ROLLER					
11	1	530481-01 BELT IDLER SHAFT					
12	5	530484-01 ASSY, BELT IDLER ROLLER					
13	1	530488-01 DRIVE SHAFT					
14	1	5333336-01 ASSY, FRICTION BELT IDLER					
15	4	CSDD267					
16	2	CSDD294					



DRAWN BY: T JG	SCALE 0.437	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, WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDI, INC. KENNESAW, GA 30144 USA	REF'D WHERE USED 1 496FC
CHECKED BY:	DATE 16 - NOV - 98	.01 .015 .015 ANG.		HEAT TREAT: XXX	KIRK - RUDY - INC. KENNESAW, GEORGIA			
TRACED BY:	MASTER M	.01 -.005 .5 REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED		FINISH: XXX	TITLE: ASSY, FRICTION BELTS		SHEET NO.: 1 OF 1	DRAWING #: 534911-01

ITEM	QTY	PART #	DESCRIPTION
1	2	103106	BEARING, FLAT .375
2	2	104100	SNAPRING, .375
3	1	530473-02	SHAFT, FRICTION IDLER
4	1	530475-02	ROLLER, FRICTION BELT IDLER

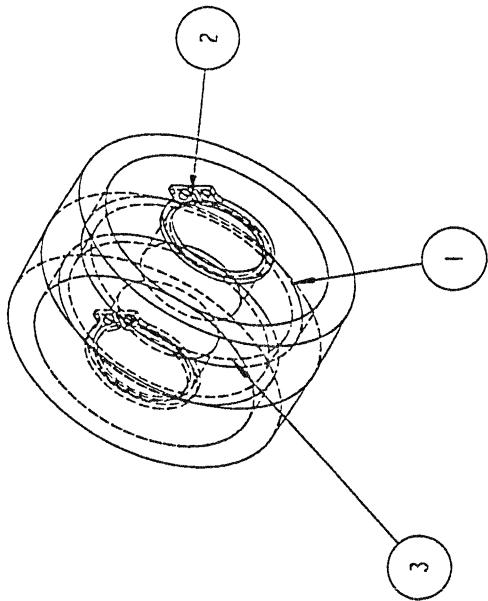


REV NO	DATE	DESCRIPTION	ECN NO	BY

1	531715-01	RECD WHERE USED
KIRK - RUDY, INC.	KENNESAW, GEORGIA	
NO PORTION OF THIS DRAWING MAY BE QUOTED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC.	KENNESAW, GA 30144 USA	
DATE: 7-Apr-98	MODEL: 496F	TIME:
MASTER: M	NOTE: NOTED	SHEET # OF 1 DRAWING #
		533336-01

ITEM QTY	PART #	DESCRIPTION
1	2	103110 BEARING, FLAT .625
2	2	104104 SNAPRING, .625
3	1	530476-01 BELT IDLER ROLLER

ITEM	REV NO	DATE	DESCRIPTION	ECN NO	RT



X	XXX
REV'D	WHERE USED
	KIRK - RUDY, INC.
	KENNESAW, GEORGIA
	TRAD. TRADE 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
	TIME:
	DRAWING #
	ASSY , BELT IDLER ROLLER
	530484-01
SHEET NO.	1 OF 1

DRAFTER:	SCALE	ITEM	NOTES	THIRD ANGLE PROJECTION	PROPRIETARY AND CONFIDENTIAL
RHM	.000		MATERIAL: UNLESS OTHERWISE NOTED		NO PORTION OF THIS DRAWING
			.IN .MM		MAY BE QUOTED OR REPRODUCED
			.01 .003		IN ANY FORM WITHOUT THE
			.5		EXPRESS WRITTEN PERMISSION
			HEAT TREAT:		OF KIRK-RUDY, INC.
CHECKED BY:	DATE		NONE		KENNESAW, GA 30144 USA
			FINISH:		
TRACED BY:	MASTER		NONE		
			DO NOT SCALE WORK TO DIMENSIONS ONLY		

13 - OCT - 98	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED
	ALL DIMENSIONS ARE FINISHED DIMENSIONS

ITEM QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	2	103803 BEARING, HUB .500					
2	1	109120 BELT, TIMING HTD 70-5M-15					
3	1	109708 PULLEY, TIMING 205M15 .5000B .125K					
4	1	530528-01 ANGLE					
5	1	530528-02 ANGLE					
6	1	530529-02 PLATE, RH FRAME					
7	1	530549-01 BACKSTOP ASSY					
8	1	530728-01 BAR, SPACER					
9	1	530730-01 TABLETOP					
10	2	530785-01 KNOB ASSY					
11	2	530788-01 SIDE GUIDE					
12	3	530789-01 KNOB ASSY, ROUND CAP					
13	2	530910-01 ANGLE					
14	1	530911-02 PLATE, LH FRAME					
15	1	530912-01 COVER, BOTTOM					
16	1	533337-01 STOPPER, CLUTCH KICKER					
17	1	535018-01 ASSY, ELECT. CONTROL BOX					
18	1	535032-01 ASSY, CLUTCH SHAFT					
19	1	535034-01 ASSY, MOTOR DRIVE					
20	1	SP49620 SPACER					
21	1	SP49625 COVER					
22	2	SP49631 BLOCK, TABLETOP SUPP					

NOTE: TABLETOP AND LH FRAME ARE SHOWN TRANSPARENT FOR CLARITY

DRAWN BY:	SCALE	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	MATERIAL:	NOTED	THIRD ANGLE PROJECTION	PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE QUOTED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC.
T JG	0 . 200	.005 .005 .005	ANG.			KIRK - RUDY, INC KENNESAW, GEORGIA
CHECKED BY:	DATE		HEAT TREAT:	NONE	MODEL:	496FC
	19-Oct-98				TITLE:	ASSY, 496 FRAME
TRACED BY:	MASTER		FINISH:	NOTED	SHEET NO.:	00F1
	M				DRAWING #:	535033-01

ITEM QTY	PART #	DESCRIPTION
1	530548-01	CROSS BAR
2	530675-01	BAR
3	530731-01	WEDGE

ITEM	REV NO	DATE	DESCRIPTION	CM NO	BT

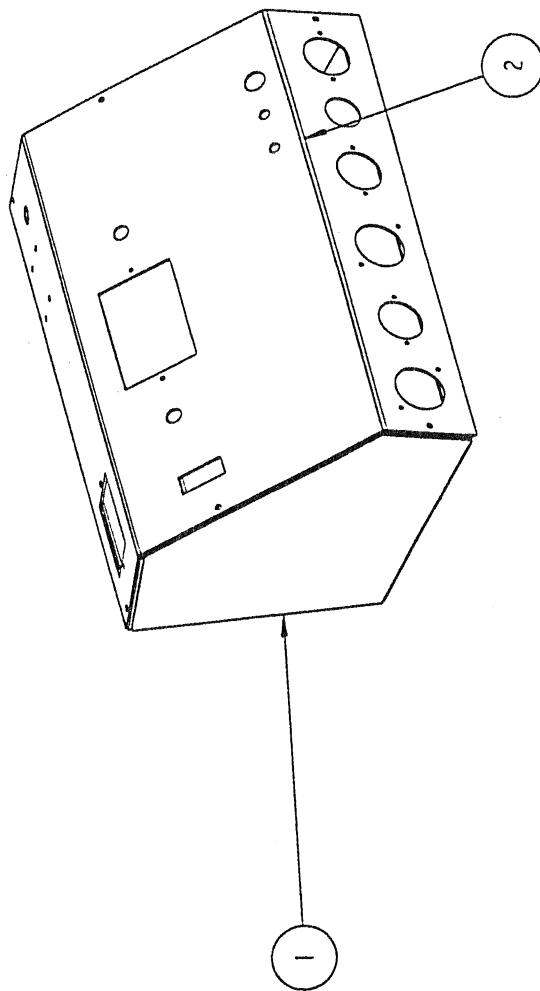
X	XXX
RECD	WHERE USED

PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE QUOTED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC. KENNESAW, GA 30444 USA	THIRD ANGLE PROJECTION
KIRK - RUDY, INC. KENNESAW, GEORGIA	TITLE:
	DRAWING #
	BACKSTOP ASY
	530549-01

DRAWN BY: TVK	SCALE: 0 . 750	MATERIAL: NOTED UNLESS OTHERWISE NOTED	NOTE D	NOTE E
CHCKED BY: DATE: 29-Apr-98	.01 .005 .5	ANG.	HEAT TREAT:	XXX
TRACED BY: MASTER	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY			
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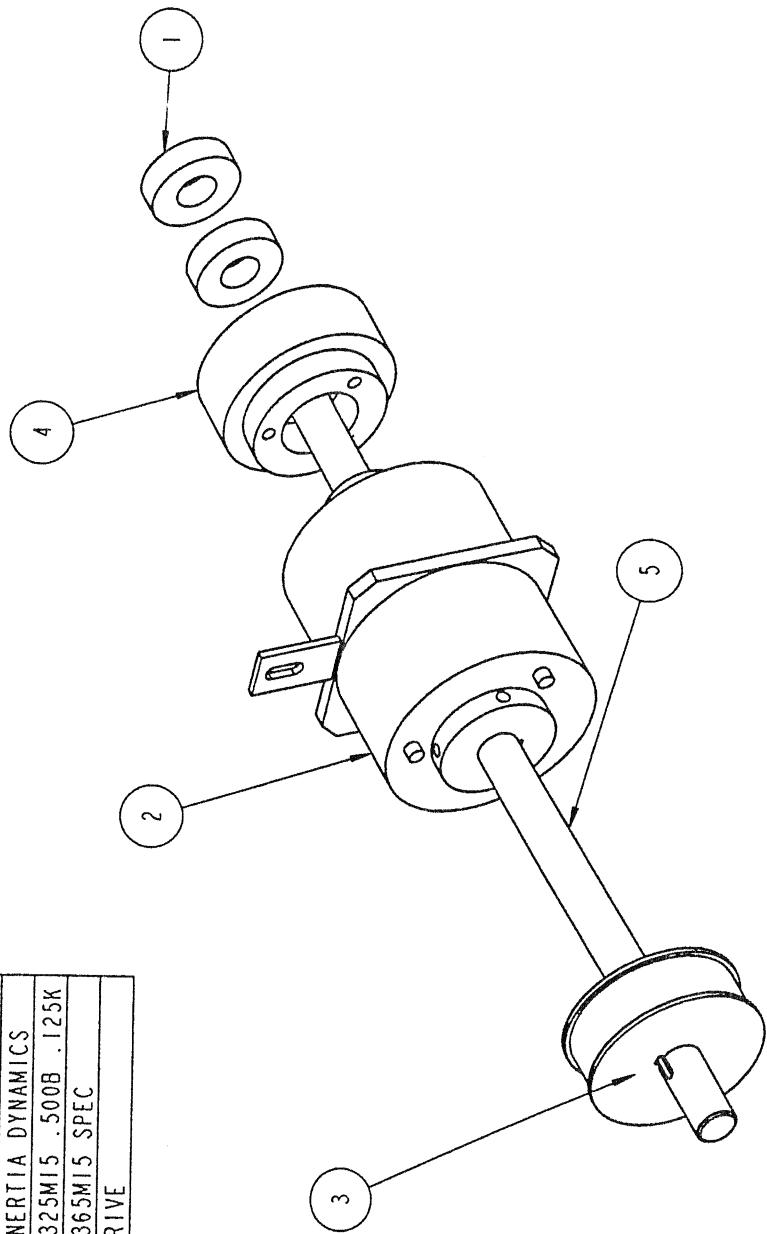
ITEM QTY	PART #	DESCRIPTION
1	1	535017-01 WLDMT, ELECT. CONTROL BOX
2	1	535019-01 COVER, ELECT. CONTROL

REV NO	DATE	DESCRIPTION	FCN NO	BY



1	1961C	REQ'D WHERE USED
		KIRK - RUDY, INC. KENNESAW, GEORGIA
		KR
		KENNESAW, GA 30144 USA
		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.
MATERIAL:	N/A	THIRD ANGLE PROJECTION
DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED		
.01 .005 .5	.01 .005 .5	REAR VIEW:
SCALE:	0 .250	MODEL:
DRAWN BY:	T JG	496 FC
CHECKED BY:	DATE 3-0-C.1 - 98	TITLE: ASSY, ELECT. CONTROL BOX
TRACED BY:	MASTER M	STL# 10F1
		DRAWING 1
		535018-01
		DO NOT SCALE & WORK TO DIMENSIONS ONLY

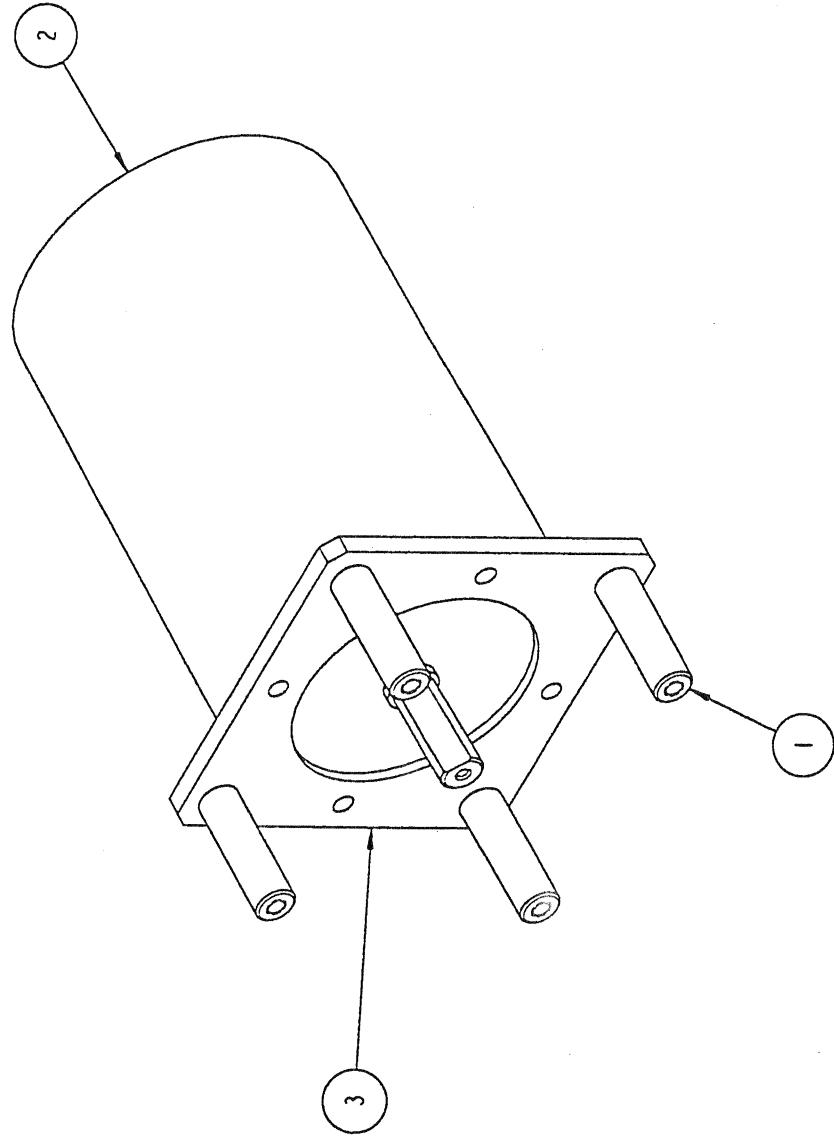
ITEM QTY	PART #	DESCRIPTION
1	103108	BEARING, FLAT .500
2	104036	CLUTCH/BRAKE, INERTIA DYNAMICS
3	109711	PULLEY, TIMING 325M15 .500B .125K
4	109712	PULLEY, TIMING 365M15 SPEC
5	535031-01	SHAFT, CLUTCH DRIVE



NOTES:
 1. KEY FOR CLUTCH 1/8" X 2.75"
 2. BOLTS TO ATTACH PULLEY 3-PLCS #8-32 X 1.25"

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
T JG	0 . 500	.01 .005 .005 .005	N/A		
CHECKED BY:	DATE	AMG.	HEAT TREAT:		KIRK - RUDY, INC. KENNESAW, GEORGIA
	22-0c†-98		N/A		
TRACED BY:	MASTER		FINISH	SHEET NO. 1 OF 1	TITLE: ASSY, CLUTCH SHAFT
	M		N/A		DRAWING # 535032-01

ITEM QTY	PART #	DESCRIPTION
1	4	502255 SPACER, GEAR COVER
2	1	200165-1 MOTOR, DC 1/4HP
3	1	530534-01 PLATE, MOTOR MFG



1	535034-01	
REV NO	DATE	
DESCRIPTION		
ECN NO		
BY		
RECD	WHERE USED	
<p>PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE QUOTED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC. KENNESAW, GA 30444 USA</p> <p>KRK KIRK - RUDY, INC. KENNESAW, GEORGIA</p>		
<p>THIRD ANGLE PROJECTION</p> <p>(+)</p> <p>(-)</p>		
MODEL:	496F	
TITLE:	ASSY, MOTOR DRIVE	
INSTR. NO.:	10F1	
DRAWN BY:	T JG	
SCALE:	0 . 500	
DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED		
.01	.005	.5
ANG.	ANG.	HEAT TREAT:
NOTED		
CHIEVED BY:	DATE	30 - Oct - 98
REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED		
TRACED BY:	MASTER	<p><i>m</i></p> <p>ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY</p>

ITEM	QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	1	501629	CLAMP, GUIDE STRIP					
2	1	202261-5	BEAMSWITCH, RETROREFLECTIVE					
3	1	532138-01	SHAFT, C-CLAMP					
4	1	SP37361	PHOTOCELL BRACKET					

DRAWN BY: T JG SCALE: 1 . 000 MATERIAL: NOTED THIRD ANGLE PROJECTION

DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED		
.011	.011	ANG.
.011	.005	.5

HEAT TREAT: NONE

REMOVED ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED

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

CHECKED BY: DATE: 16 - NOV - 98 MODEL: 496FC TITLE: ASSY, BEAMSWITCH MOUNT

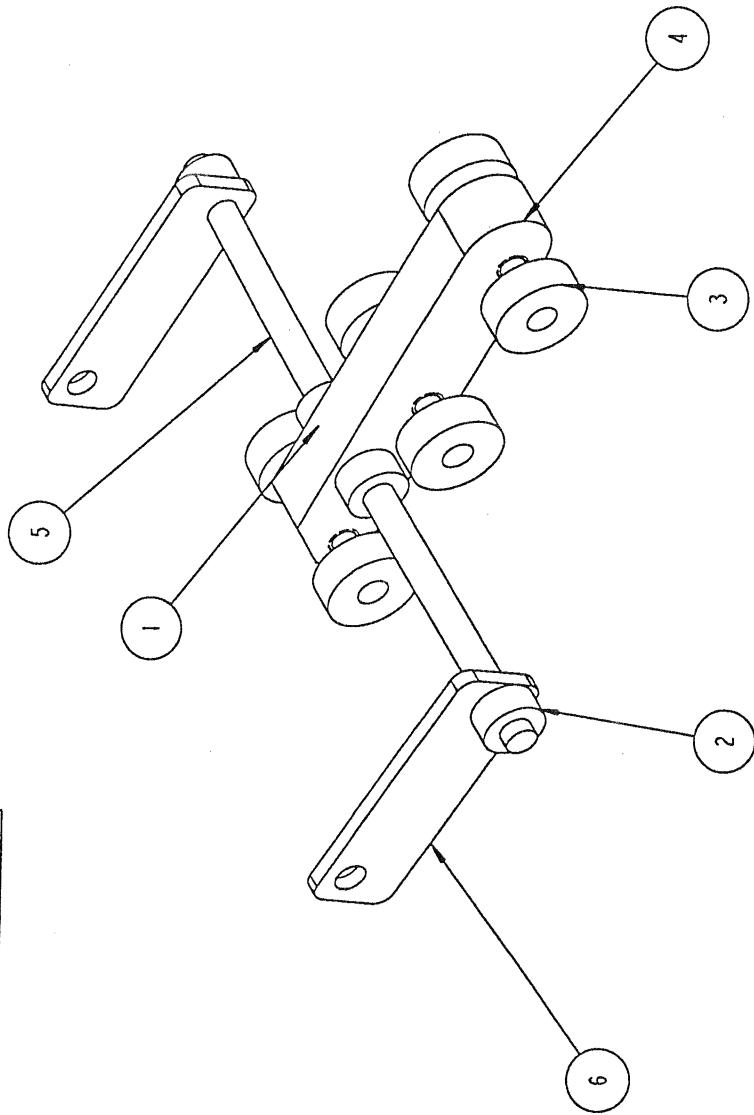
TRACED BY: MASTER: m SHEET NO. 1 OF 1 DRAWING #

I	496FC
RECD	WHERE USED

535051-01

535051-01

ITEM QTY	PART #	DESCRIPTION
1	100132	BUSHING, SLEEVE .250
2	102223	COLLAR .250
3	103105	BEARING, FLAT .250 ID .750 OD
4	535176-01	BAR, SKID
5	535177-01	SHFT, SKID BAR
6	535178-01	PLATE, SKID BAR



NOTE: SPACE BEARING .281" OUT FROM SKID BAR.

9.0 ELECTRICAL SCHEMATIC

The electrical schematic for the KR 496FC Feeder is drawing # 200 150 08 1X1.

10.0 APPENDIX

The following manufacturer's specification sheets are shipped with each feeder. Please read these specification sheets and keep them with your manual.

10.1 Bodine Electric Motor

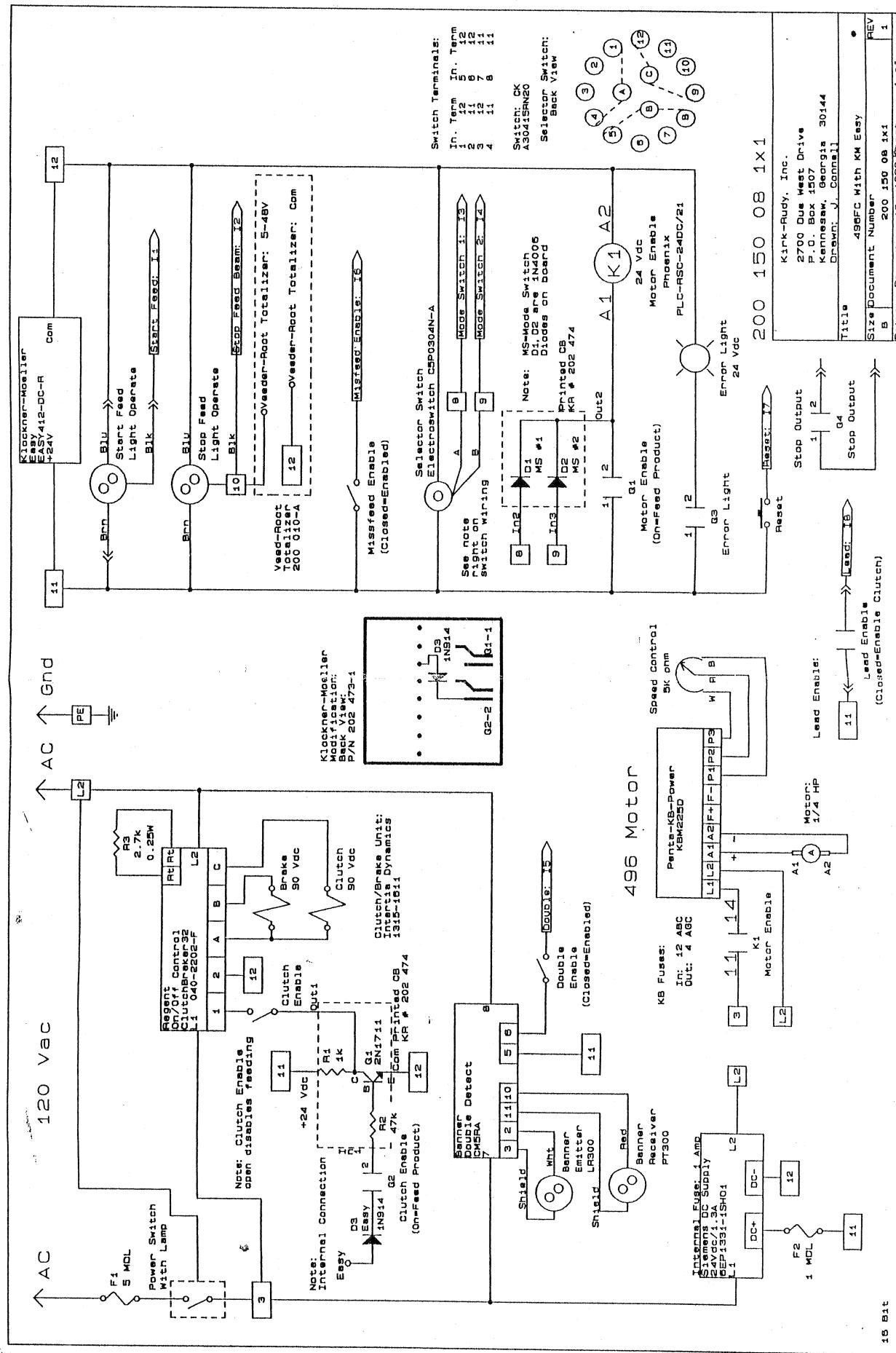
10.2 KB Motor Board

10.3 Klockner-Moeller PLC

10.4 Clutch/Brake on/off module

10.5 Banner beamswitch

10.6 Proximity switch



11.0 NOTES

12.0 WARRANTY AND SERVICE

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 the normal wear, neglect, abuse or accident.

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

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

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

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

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