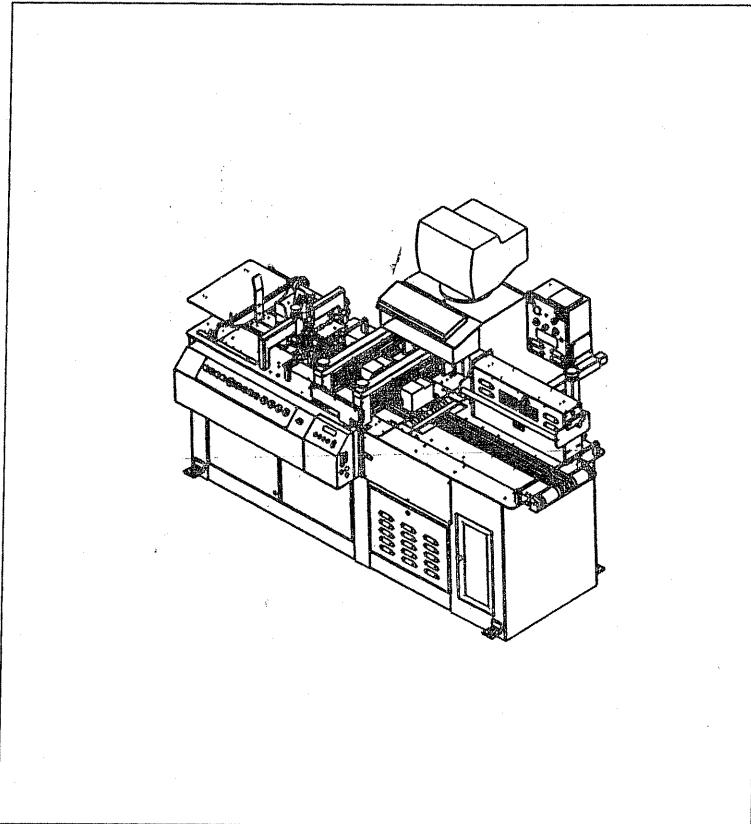


Kirk-Rudy, Inc.

Instruction and Parts Manual

KR215N InkJet Base



NOTE: Some items are for view reference only.
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.

10000-215N REV. 2 1/12/2007

Kirk-Rudy

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

1 Important Safety Instructions

Intended Use Statement: The KR215N 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.

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	770 lbs	349 kg
Shipping Box	970 lbs	395kg
Shipping Crate	1070 lbs	485 kg

ELECTRICAL

Base Main Power Input:	220 VAC, Single Phase, 4-WIRE 60/50 Hz, 30 A
NEMA Plug Specs:	L1430P, 250V/125V, 30Amp, 4-Wire
Feeder Drive Motor:	½ HP DC
Table Conveyor Motor:	½ HP DC
Vacuum Pump:	½ HP DC
Vacuum Blower InkJet:	1/8 HP 120 Volt, AC 60/50 Cycle, 2.0 A
Vacuum Blower Dryer:	1/8 HP 120 Volt, AC 60/50 Cycle, 1.3 A

KR314 Conveyor (Optional)
Conveyor Motor: ¼ H.P. DC

Note:

110V, 8 Amp max Electrical Box (4) Plug, located inside base for Computer connections.

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 KR215N). 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. SKID BAR: Detects jam up and provides friction to drive product.
8. OILER: Used to lubricate shuttle bushings.

9. FEEDER VACUUM PUMP: Supplies vacuum to the feeder.
10. SHUTTLE DRIVE MOTOR: Drives the feeder shuttle table.
11. TABLETOP VACUUM BLOWER: Supplies vacuum to the tabletop.
12. HIGH TEMPERATURE VACUUM BLOWER: Supplies vacuum to the dryer tabletop.
13. CONTROL PANEL (for more detail, see Section 4.1 and Figure 2.0): Contains operator controls.
14. ENCODER: This device measures speed of belts and is driven off the front roller shaft. This is used to get the correct speed for printing.
15. INKJET UNITS: This is location of inkjet heads.
16. NETJET CONTROLLER: This controller interfaces with computer to control all inkjet functions.

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**)

Feeder Stop Switch: When this two-position switch is depressed the feeder portion of the machine will turn off. The feeder that is controlled is dependent on the position of the 215/496 mode switch. 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. This will stop all conveyors and the feeder.

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.

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: 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.

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

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

Stack Detection Beamswitch: 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.

Dryer Product Detect Beamswitch: Detects the presence of product on the base. If no product is detected for a certain amount of time the dryer lamps are turned off. This feature is used to increase belt life and decrease power consumption.

NetJet Product Detect Beamswitch: Detects the presence of product on the base for print placement.

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

Plug Description	Plug Type
NetJet controller interface Plugs (see figure #1)	
NetJet / 215N	8-Pin
Encoder	9-Pin
Product Beamswitch	4-pin
Dryer Plugs:	
Dryer Enable: Contact Closure	Male 2-Pin Twist
Dryer Enable: +24 VAC	Female 3-Pin Twist
Dryer Drive Control	Female 4-pin Molex
Power Supply Plugs:	
220 Vac/I Phase/30 Amp	4-Pin/4-wire
120 Vac, 8 Amp	Standard 120VAC outlet
Stop Plug:	
Conveyor Stop: Contact Closure	Female 2-Pin Turck
Conveyor Plug:	
Conveyor Motor	Female 3-Pin Turck
Stacker Plug:	
Stacker cycle	Female 3-pin Molex
Stacker divert	Female 3-pin twist

NETJET CONTROLLER OUTPUT SIGNALS

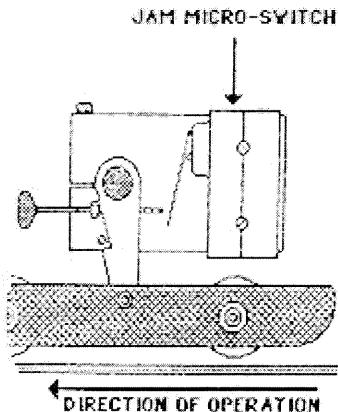
Conveyor Speed Up/ Stack Cycle: The conveyor speed up/stacker cycle output signal is used for two different functions depending on which machine is placed inline with the 215. The conveyor speed up is used to control speed up on a shingle conveyor for address breaks. The amount of time for the speed up is determined by the NetJet controller. The stacker cycle function (bundle break) uses the NetJet controller to signal the KR630/703 stacker for bundle breaks. Note: Use optional KR938 Signal Tracking System when installing equipment between KR215N and KR630/703 stackers.

Feeder Stop: The feeder stop function is used to stop the shuttle motor at the end of a run.

Stacker Divert: The NetJet controller divert function is used to signal the divert on the KR630/703 stacker.

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 KR215N. 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).

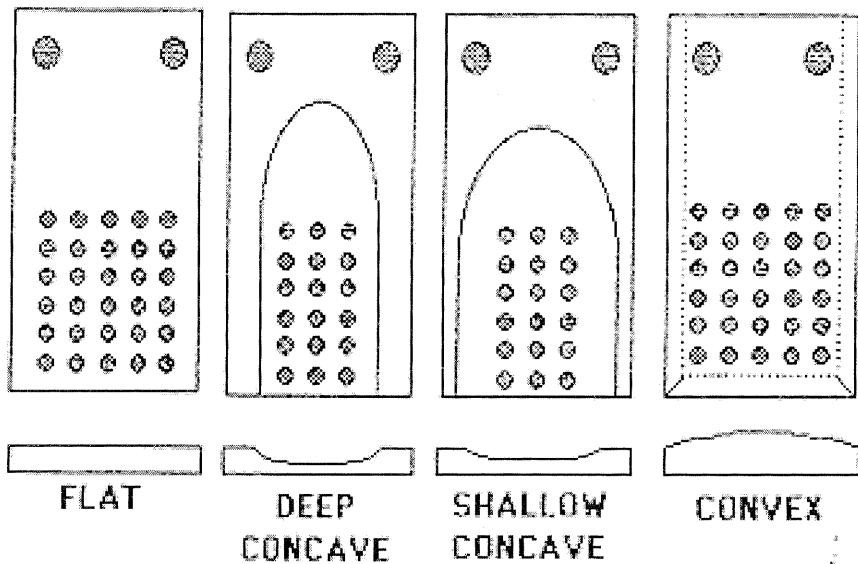
The second switch that is most often open is the conveyor stop button. This button is usually open because of improper seating of the plug that goes into the back of the machine. If neither the machine nor the conveyor will run (conveyor power switch in “automatic” position) when the start button is 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 KR215N.



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.

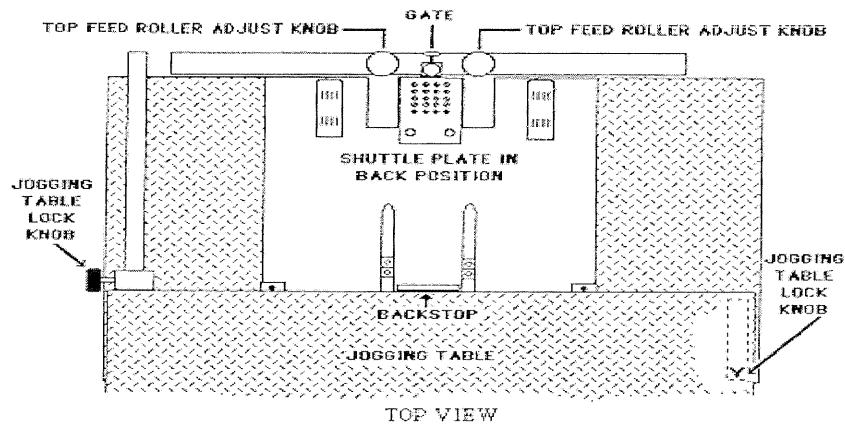
CONVEX PLATE: For tri-folded or self-mailers and can also be used for product that has a warp or bend.

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.

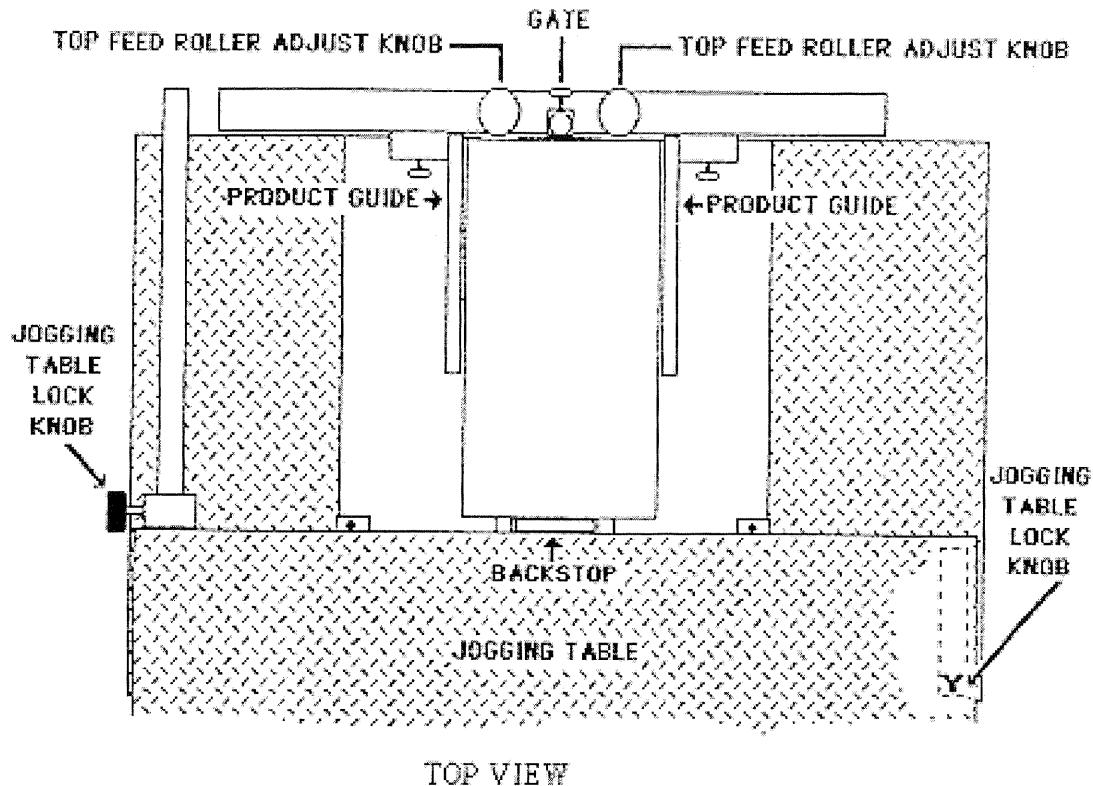
4.5 SHUTTLE/FEEDER SET-UP

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.

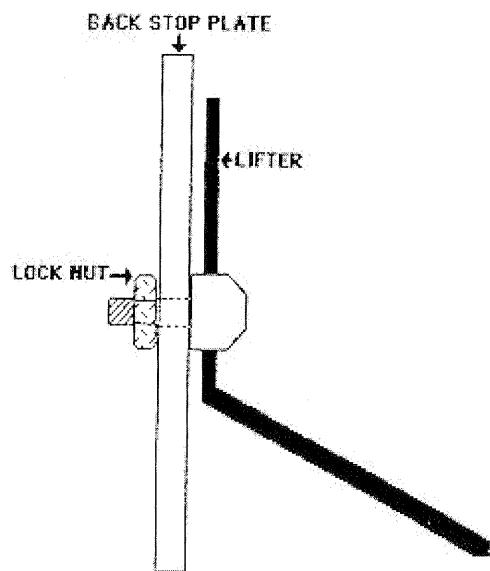
Jog the machine until the shuttle plate is in the extreme back position.



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.



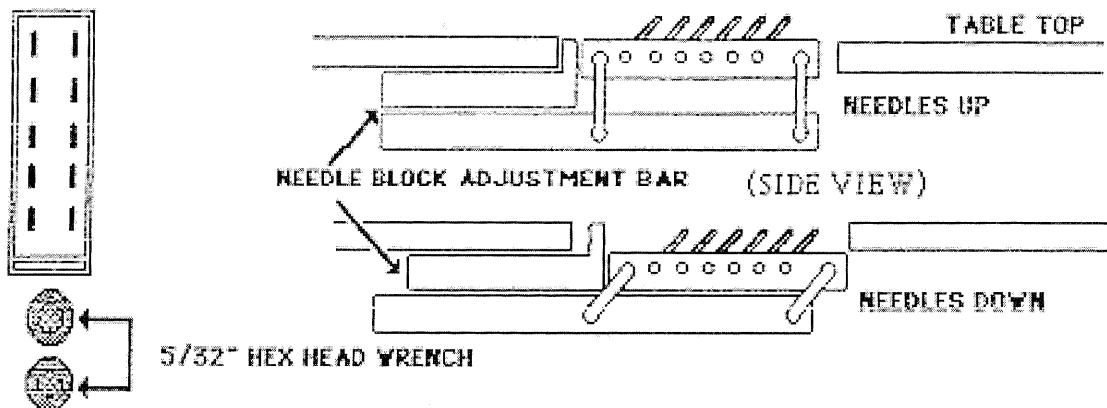
TOP VIEW



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

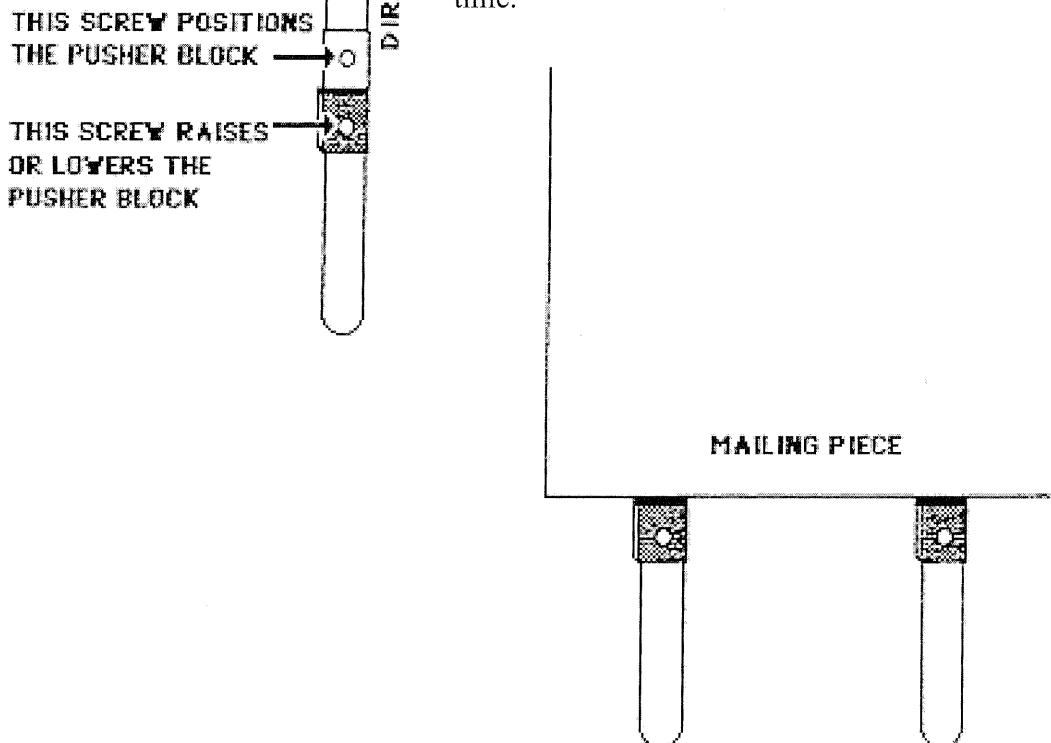
The lifters are designed to lift up the back of the product and angle the front edge toward the gate to aid in feeding. These are most commonly used for large products such as newspapers, magazines, and etc.

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.



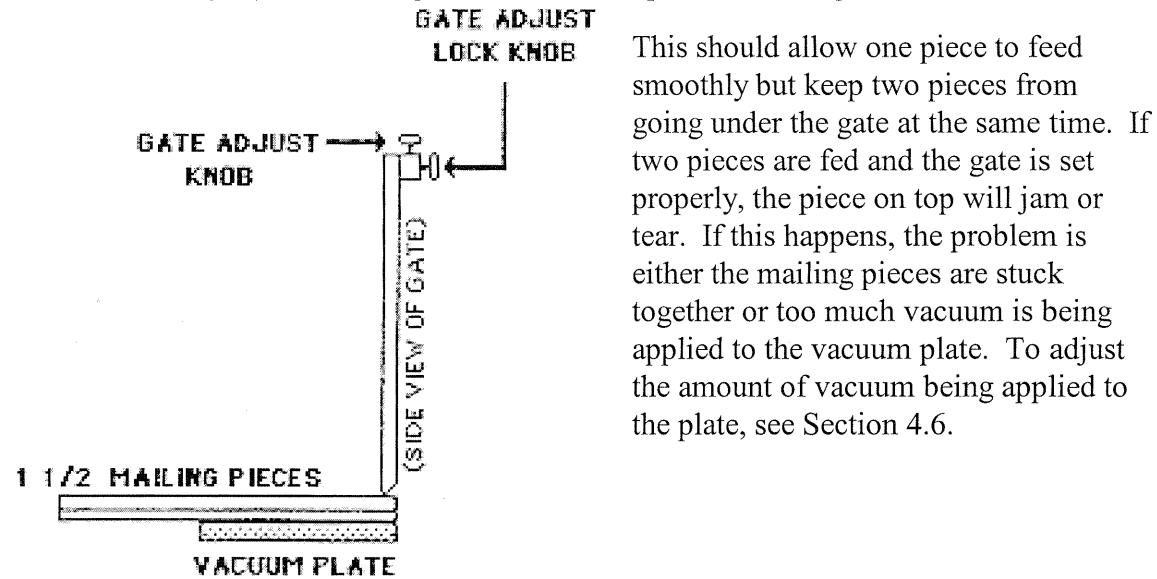
The pushers are for thick product such as books or magazines. They actually push the product under the gate.

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 $1\frac{1}{2}$ times the thickness of the mailing piece. Simply take $1\frac{1}{2}$ pieces and place underneath the gate). After the gate is set, lock in place with the gate lock knob.

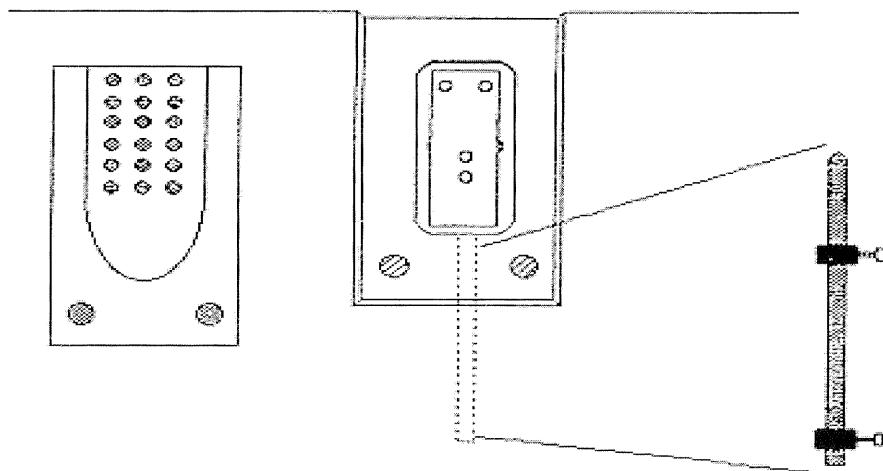


This should allow one piece to feed smoothly but keep two pieces from going under the gate at the same time. If two pieces are fed and the gate is set properly, the piece on top will jam or tear. If this happens, the problem is either the mailing pieces are stuck together or too much vacuum is being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

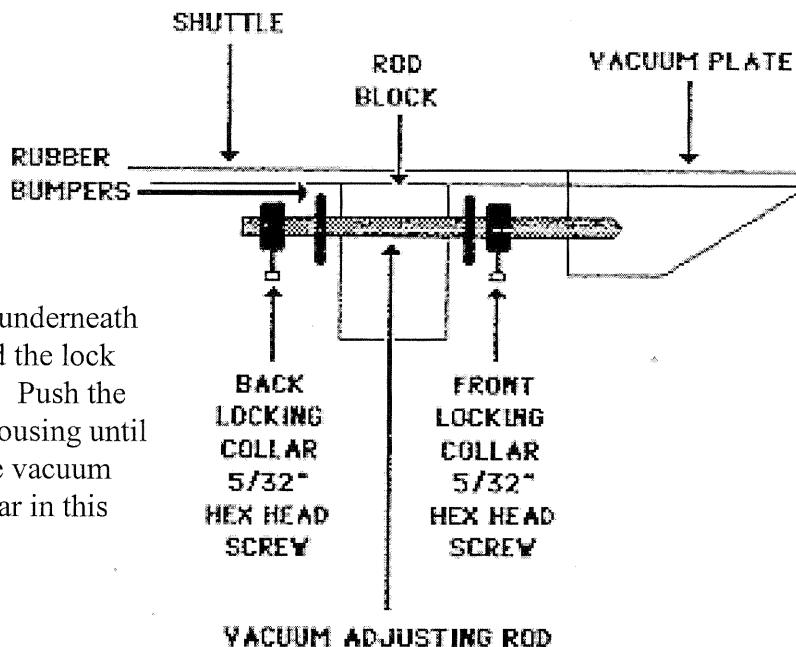
4.7 VACUUM TIMING AND TOP FEED ROLLER SET-UP

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.

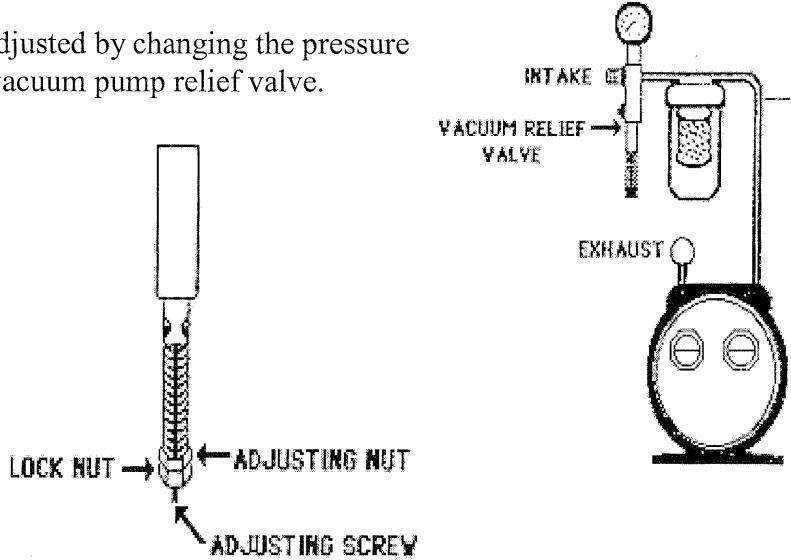


To adjust the vacuum on, turn the main power and feeder vacuum pump switches on and rotate the machine by hand until the shuttle plate is 1/8" from its maximum backstroke. Locate the front lock collar on the rod underneath the feeder and loosen. Hold the lock collar against the rod block. Push the rod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

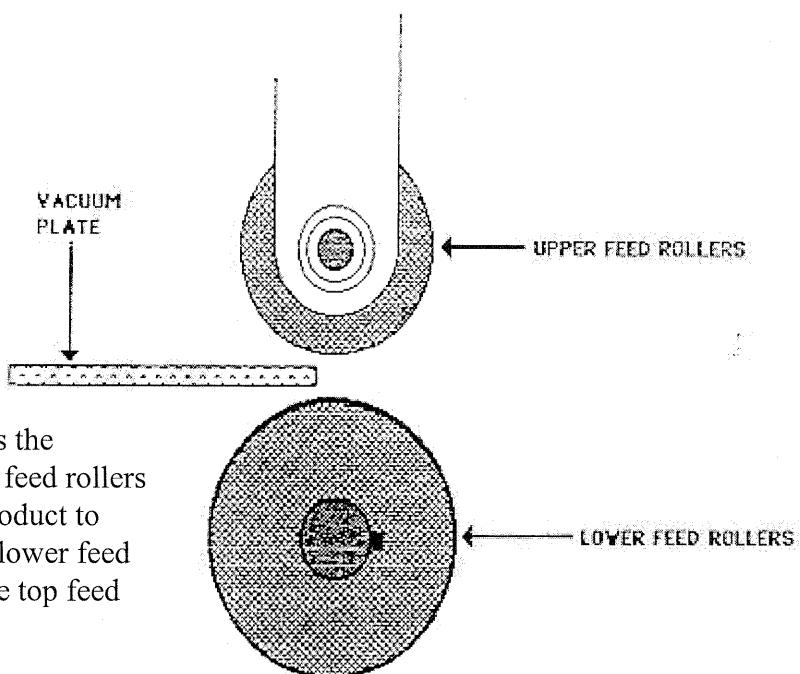


Vacuum to the plate can be adjusted by changing the pressure on the spring located on the vacuum pump relief valve.

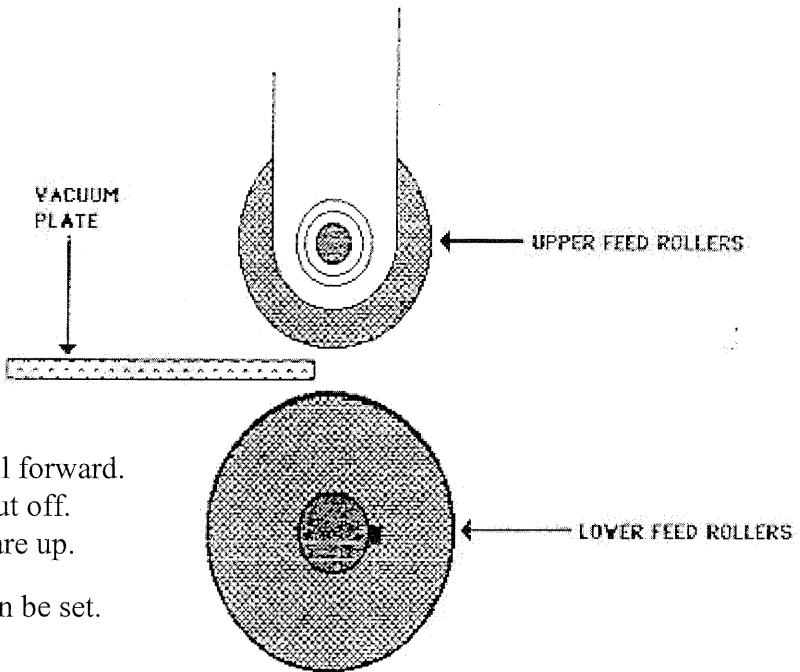
Locate the vacuum relief valve on the feeder vacuum pump (located on the left of the machine) and loosen the lock nut. Now the vacuum can be adjusted by holding the adjustment screw and turning the adjustment nut. As the spring is compressed, the vacuum increases. Loosening the compression spring decreases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



At this position the upper feed rollers can be set.



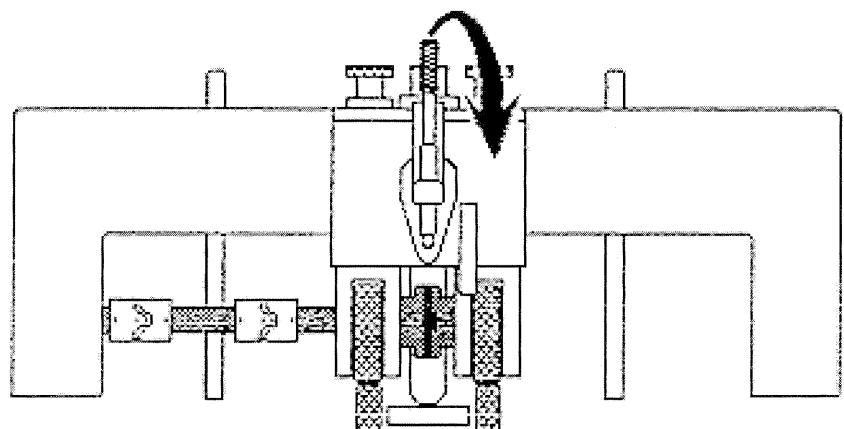
To set the top feed rollers, place a mailing piece in the shuttle feeder. Turn on the main power and feeder vacuum pump. Rotate the machine by hand until the piece is fed underneath the gate, between the top and lower feed rollers, and the lower feed rollers have come up. Adjust the top feed rollers 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.

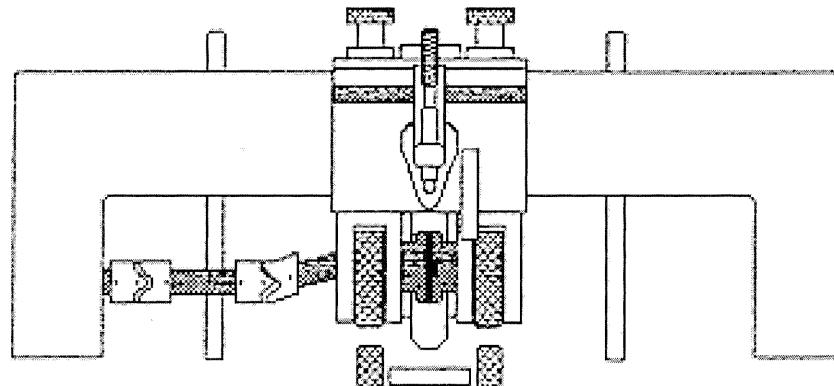
Place several pieces in the feeder and run the machine using the run or jog button. If the piece pulls to one side as it leaves the feed rollers, the top feed rollers are not set properly. Adjust until the mailing piece is fed smoothly by raising or lowering one of the top feed rollers.

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

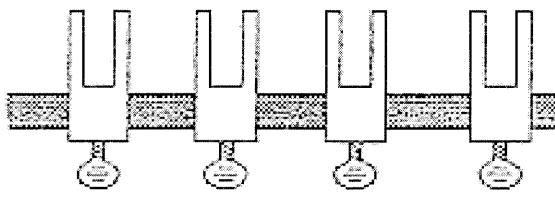
Varying the speed of both the shuttle feeder and tabletop belts controls spacing of product.

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.

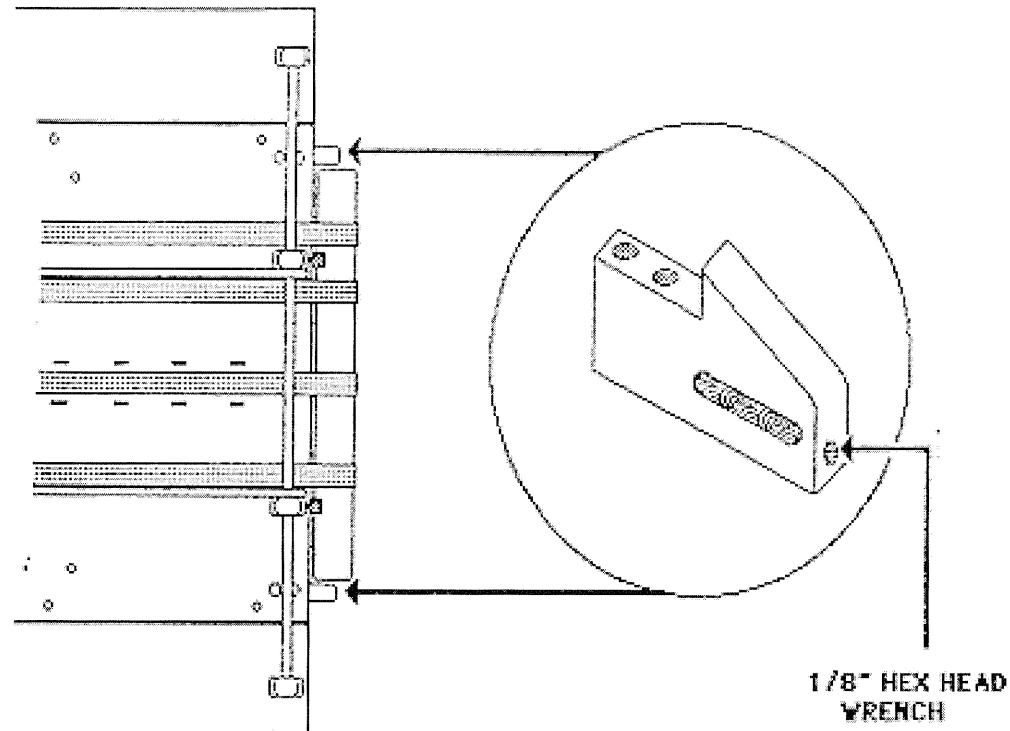


Underneath the tabletop is located guides for the tabletop belts. Each belt has its own guide. To move the belts, simply loosen the thumbscrew on the bottom of the guide and slide the guide on the shaft to the desired position and then tighten the thumbscrew.

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.

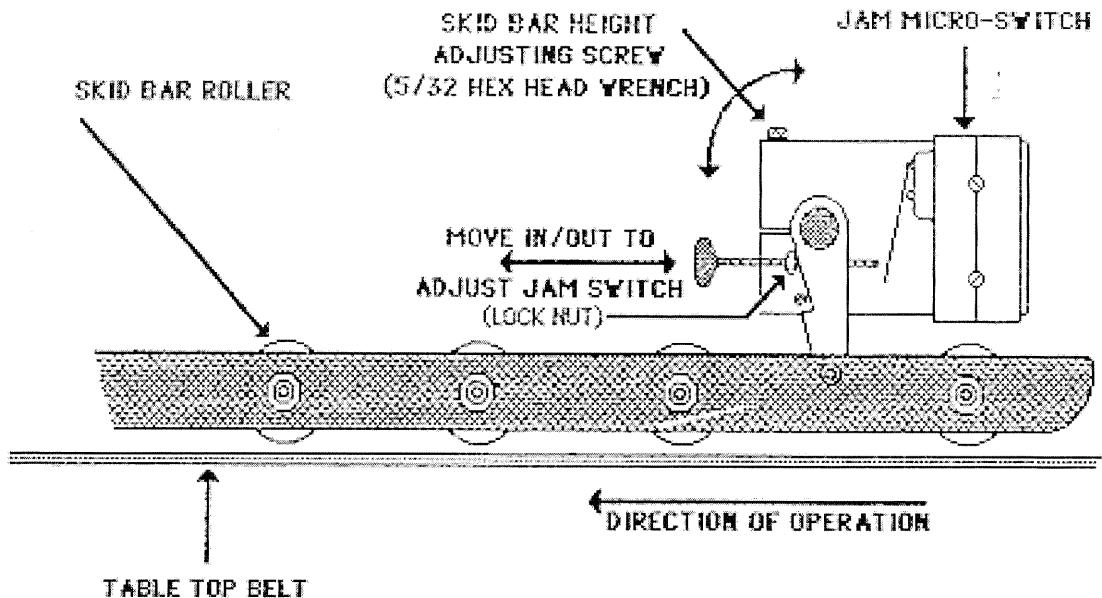
The tabletop belt tension can be adjusted. Caution should be taken not to over tighten. There should be just enough tension to prevent belt slippage.



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 KR215N 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.

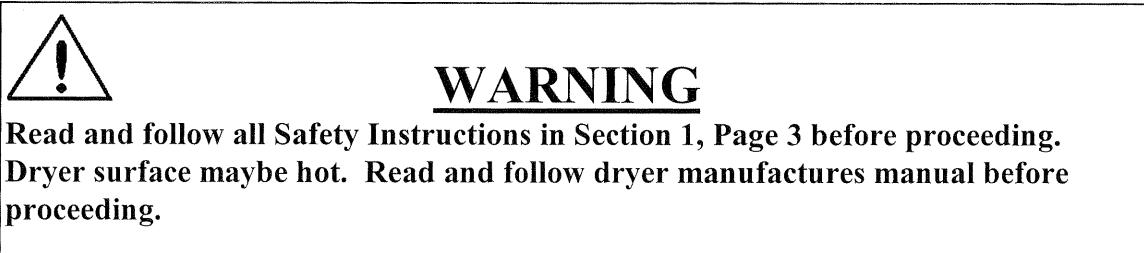


To set the skid bar, rotate the machine until a mailing piece is under the skid bar. Loosen the 5/32" hex head screw on the skid bar block. Adjust until the skid bar is resting on the mailing piece and the skid bar rollers rotate as the product is transported. Lock in place with the 5/32" hex head screw.

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.

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.

4.13 V-Pulley torque limiter

Reference: Prints 542566-01, 02 & 542833-01,02

Purpose: The v-pulley torque limiter has been designed to protect the Kirk Rudy, Inc. equipment it drives. During high-speed operation product can jam and cause a torque overload, which may break certain timing belts or damage other machine equipment. This torque limiter assembly will release the torque to protect the machine.

Operation: The v-pulley torque limiter uses nylon #10-32 screws KR#107463 as drive pins. If a torque overload conditions happens the nylon screws will shear, therefore disengaging the v-pulley from the motor/pulley box output shaft. The v-pulley is supported with flat ball bearings; therefore the v-pulley will “freewheel” until the nylon screws are replaced. **Warning: This device does not stop the machine motor if an overload occurs. The operator must stop the motor using the control panel stop button. If the machine belts or shuttle stops and the motor is still turing; stop the machine as soon possible. Do not touch any parts that are suppose to be operating until the machine stop button has been depress and the drive motor is not turning.**

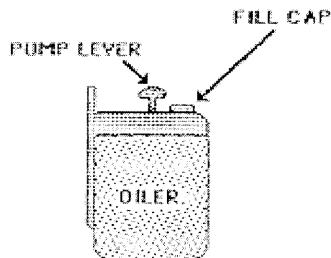
Torque Level Setup: The torque release setting is adjustable by changing the number of nylon screws. The minimum number of screws that can still drive the machine should be used for the best torque overload protection. If speeds are low and product is light only one screw maybe required to drive the machine. A service technician must test the unit to determine the correct number of screws to use.

Resetting Torque Limiter: If an overload has occurred the nylon screws must be replaced. **Warning: Machine power must be disconnected before screw replacement.** To replace the screws remove the machine covers to get access to the drive v-pulley. Make note of the number of nylon screws in the drive hub (#542568-01). Remove and replace the screws with KR#107463. Do not use any other type of screw such as steel or brass. Replace machine covers and test.

Torque Limiter Installation (ref. Print 542833-01/02): The torque limiter must be installed on the drive shaft of the motor or the pulley gearbox output shaft that is driving the machine. The torque limiter assembly should be installed with drive hub #542568-01 facing outward so the nylon screws can be easily replaced. The first step is to remove the existing v-pulley. Next, slip on the torque limiter assembly, make sure the same outside diameter v-pulley is use. A key (KR# 105312) will need to be install under the drive hub #542568-01. Next, check the v-pulley alignment. The following may have to be done to get the correct alignment: move the motor (holes may have to be drilled and tapped, move the upper pulley on the shaft inside the machine, move the output shaft in or out in the pulley box. Finally, set the belt tension and follow the directions above for “torque level setup”.

5 MAINTENANCE

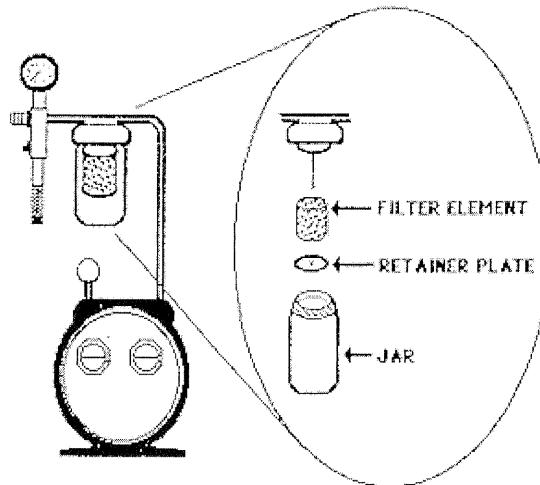
5.1 LUBRICATION



The operator should keep the KR215N 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 oiler. 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.



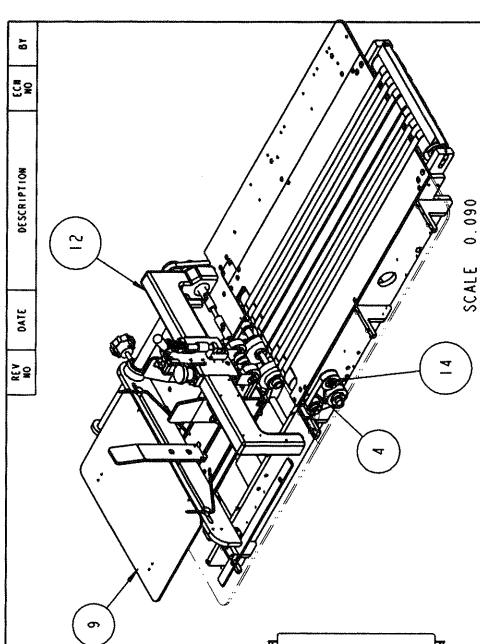
6 DIAGRAMS AND PARTS LIST

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

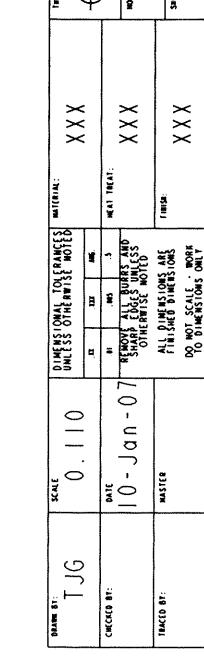
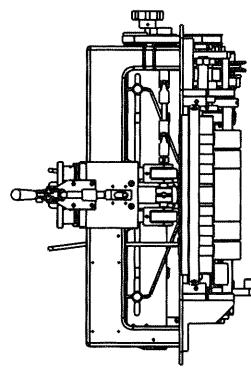
NOTE: KR215 machines manufactured in 2007 and up have a dual HTD timing belt drive system. Reference the drawings listed below for dual drive part numbers. These drawings represent a generic KR215 section. Use assembly drawings placed after these drawings for part numbers for your individual machine and any pre-2007 machine.

Assembly Number	Description
SA492	ASSY, 215 SECTION DUAL HTD BELT
551179-01	ASSY, 215 SECTION DUAL HTD BELT
536178-07	ASSY, BELT DRIVE PLATE
536468-05	ASSY, CENTER TABLETOP DUAL HTD
551182-01	ASSY, 215 FRAMES DUAL BELT
537680-03	ASSY, ECCENTRIC TAKE UP 28-5M-15

ITEM	PART #	DESCRIPTION	REV NO	DATE	ECN NO
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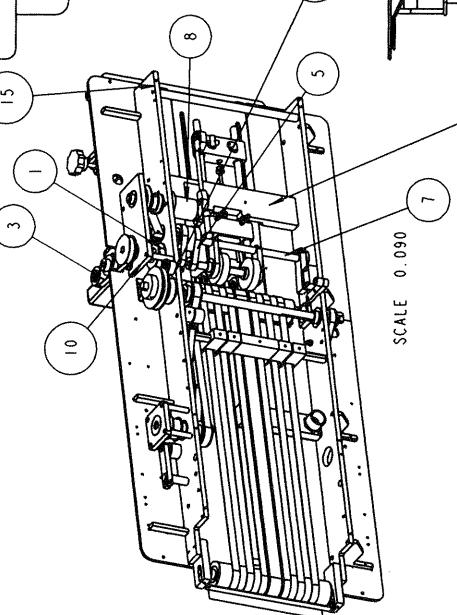


SCALE 0.090



SCALE 0.090

ITEM	PART #	DESCRIPTION	REV NO	DATE	ECN NO
1	109148	BELT, TIMING 425-SM-15			
2	500705	TABLETOP - NARROW SHUTTLE			
3	108961-13	BELT, TIMING D.871050			
4	109120-3	BELT, TIMING 350-SM-15			
5	2 109125-19	BELT, TIMING 255-SM-15			
6	1 531021-01	ASSY, SHUTTLE TABLE			
7	1 531022-03	ASSY, LOWER FEED BELT DR.			
8	1 531106-01	ASSY, HUB			
9	1 5311405-01	ASSY, JOGGER TABLE			
10	1 536178-07	ASSY, BELT DRIVE PLATE			
11	1 536468-05	ASSY, CENTER TABLETOP DUAL HTD			
12	1 537549-01	ASSY, BRIDGE TIMING BELT			
13	1 537680-01	ASSY, ECCENTRIC TAKE UP			
14	1 537680-03	ASSY, ECCENTRIC TAKE UP 285H5			
15	1 551182-01	ASSY, 215 FRAMES DUAL BELT			



SCALE 0.090

NOTES:

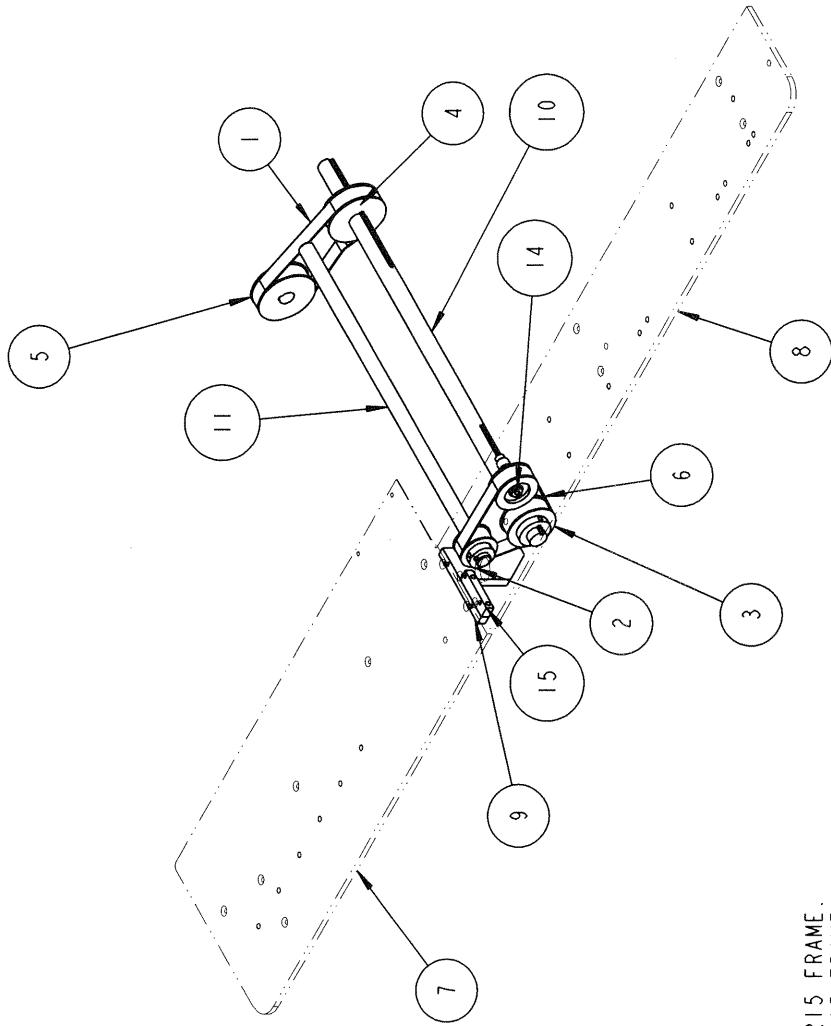
1. THIS BELT CONFIGURATION USED ON ALL KRAIS BELT DRIVE MACHINES MANUFACTURED FROM 2007 AND UP.
2. SEE DRAWING 551179-01 KIT, DUAL HTD BELT CONVERSION. THIS KIT TO REFIT OLDER MACHINES.

DRAWING #		SCALE		DIMENSIONAL TOLERANCES		NOTES	
TJG	0.110	INCH	MM	XXX	XXX	XXX	XXX
CHECKED BY:				IN	MM	IN	MM
DATE:	10-Jan-07			(4) 1/8"	(4) 1/8"		
TRACED BY:	MASTER						
				SHARP EDGES UNLESS OTHERWISE NOTED.		ALL DIMENSIONS ARE IN MILLIMETERS.	
				DO NOT SCALE. POUR TO DRAWING ONLY.			

DRAWING #		SCALE		DIMENSIONAL TOLERANCES		NOTES	
KR	215 SECTION DUAL HTD BELT ASSY	0.110	INCH	XXX	XXX	XXX	XXX
CHECKED BY:				IN	MM	IN	MM
DATE:	10-Jan-07			(4) 1/8"	(4) 1/8"		
TRACED BY:	MASTER						
		SHARP EDGES UNLESS OTHERWISE NOTED.		ALL DIMENSIONS ARE IN MILLIMETERS.		DO NOT SCALE. POUR TO DRAWING ONLY.	

DRAWING #		SCALE		DIMENSIONAL TOLERANCES		NOTES	
KR	215 SECTION DUAL HTD BELT ASSY	0.110	INCH	XXX	XXX	XXX	XXX
CHECKED BY:				IN	MM	IN	MM
DATE:	10-Jan-07			(4) 1/8"	(4) 1/8"		
TRACED BY:	MASTER						
		SHARP EDGES UNLESS OTHERWISE NOTED.		ALL DIMENSIONS ARE IN MILLIMETERS.		DO NOT SCALE. POUR TO DRAWING ONLY.	

ITEM	QTY	PART #	DESCRIPTION
1	1	109148	BELT, TIMING 425-5M-15
2	1	109738	PULLEY, TIMING 245M15 .625B 188K
3	1	109741	PULLEY, TIMING 325M15 .750B 188K
4	1	109742	PULLEY, TIMING 385M15 .750B 188K
5	1	109743	PULLEY, TIMING 385M15 .625B 188K
6	1	109120-3	BELT, TIMING 350-5M-15
7	1	500702-1IR	TABLETOP, RH SIDE SPLIT BELT ACCESS
8	1	500702-14R	TABLETOP, RH SIDE SPLIT BELT ACCESS
9	1	500721-26	GUSSET, TABLETOP CUTOUT SPLICE
10	1	500825-1	SHAFT, 215 MAIN DRIVE
11	1	534181-02	SHAFT, FRONT ROLLER
12	1	536178-07	ASSY, BELT DRIVE PLATE
13	1	536468-05	ASSY, CENTER TABLETOP DUAL HTD
14	1	537680-03	ASSY, ECCENTRIC TAKE UP 285M15
15	1	551150-01	BAR, TABLETOP SPLICE
16	1	551182-01	ASSY, 215 FRAMES DUAL BELT



NOTES:

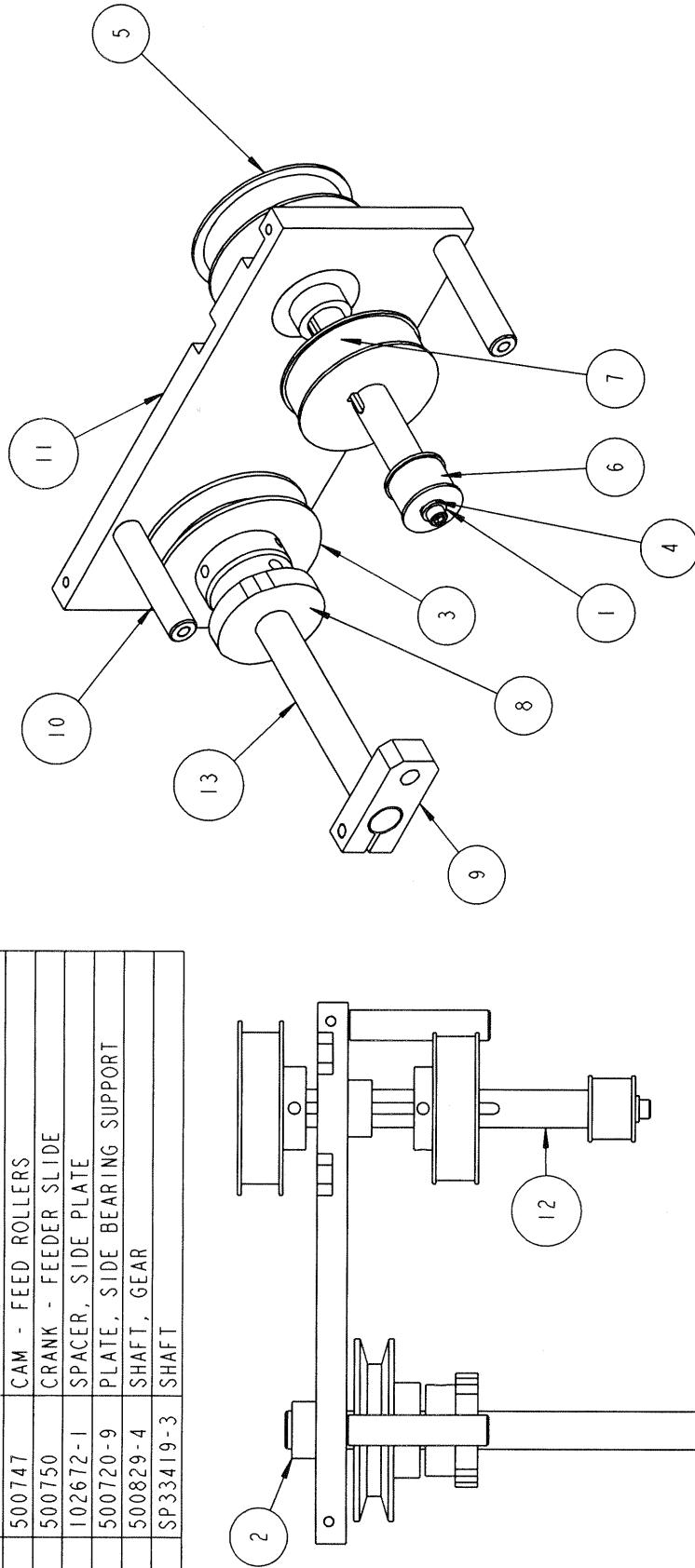
1. KIT KR#551179-01
2. TABLETOPS OPTIONAL
3. SEE SA492 MANUAL FOR COMPLETE ASSEMBLY.
4. USE JIG #551149-01 TO INSTALL HOLE IN RH KR215 FRAME.
5. USE JIG #551149-02 TO INSTALL HOLE IN LH KR215 FRAME.

REV NO	DATE	DESCRIPTION	ECN NO	BY

X	XXX
REC'D	WHERE USED
KIRK - RUDY, INC. WOODSTOCK, GEORGIA	
SA492	HTD BELT ASSY, 215 SECTION DUAL
OF 2	DRAWING ■
551179-01	

DRAWN BY:	SCALE	MATERIAL:	THIRD ANGLE PROJECTION
T JG	0 . 145	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	XXX
CHECKED BY:	DATE	.XX .XXX ANG.	
JAN - 07	.01 .005 .5	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	XXX

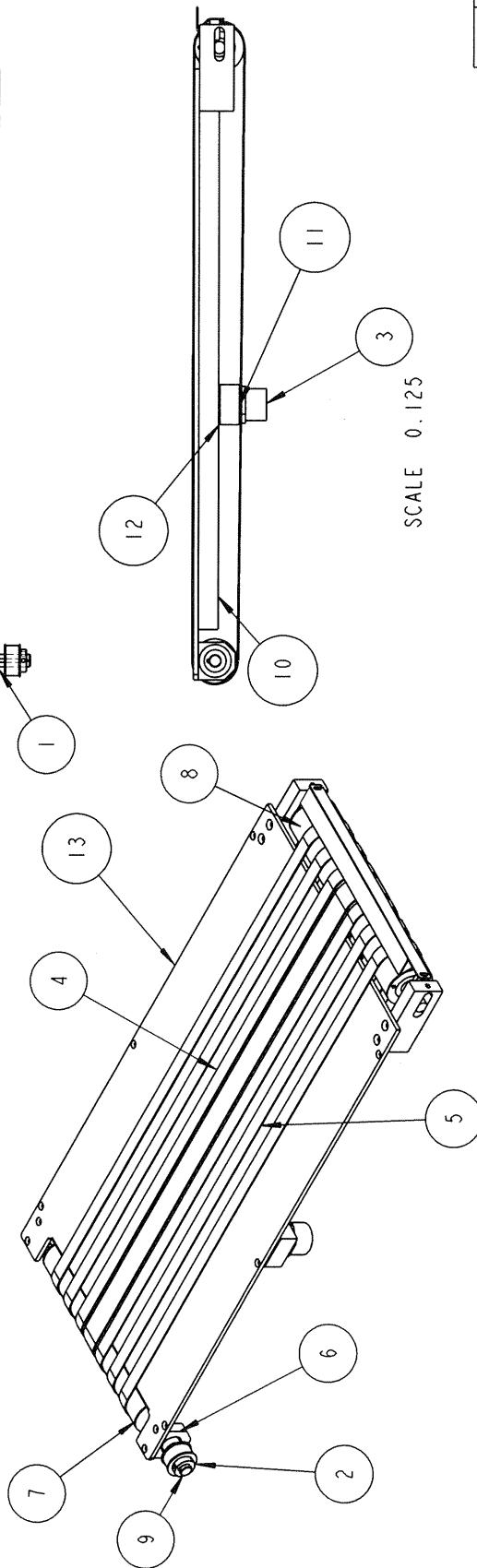
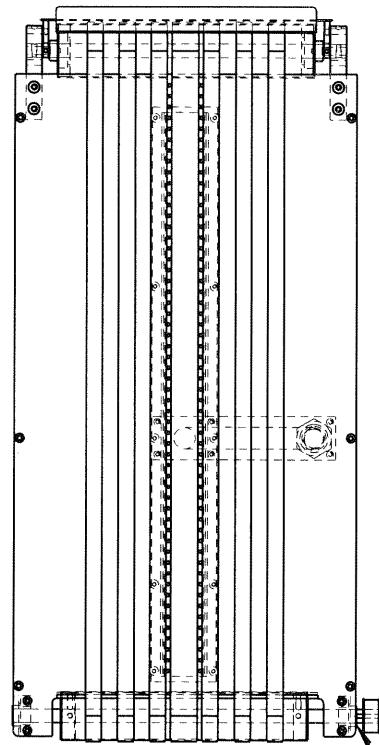
ITEM	QTY	PART #	DESCRIPTION
1	1	100619	WASHER, FLAT 10-32
2	2	103804	BEARING, HUB .625
3	1	105021	V-PULLEY, AK30
4	1	107409	SCREW, SHCS 10-32X.500
5	1	108841	PULLEY, TIMING 21L050 .625B .188K
6	1	109719	PULLEY, TIMING 16M15 .375B .125K
7	1	109743	PULLEY, TIMING 385M15 .625B .188K
8	1	500747	CAM - FEED ROLLERS
9	1	5001750	CRANK - FEEDER SLIDE
10	2	102672-1	SPACER, SIDE PLATE
11	1	500720-9	PLATE, SIDE BEARING SUPPORT
12	1	500829-4	SHAFT, GEAR
13	1	SP33419-3	SHAFT



REV NO	DATE	DESCRIPTION	ECN NO	BY

1	2151J
REOD	WHERE USED
KIRK - RUDY, INC.	
KR WOODSTOCK, GEORGIA	
PROPRIETARY AND CONFIDENTIAL	
NO PORTION OF THIS DRAWING	
MAY BE QUOTED OR REPRODUCED	
EXCEPT WITHIN THE TERMS	
OF M.R. RUDY, INC.	
WOODSTOCK, GA 30188 USA	
MODEL:	SAA492
TITLE:	ASSY, BELT DRIVE PLATE
SHEET NO.	OF 1
DRAWN BY:	T JG
SCALE:	0 .375
DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	
.XX	.XXX
.01	.005
ANG.	.5
HEAT TREAT:	N/A
CHECKED BY:	JAN - 07
DATE:	
REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED	
ALL DIMENSIONS ARE IN INCHES	
FINISH: N/A	
TRACED BY:	M
DO NOT SCALE WORK TO DIMENSIONS ONLY	

ITEM QTY	PART #	DESCRIPTION
1	2	103804 BEARING, HUB .625
2	1	109738 PULLEY, TIMING 245M15 .625B .188K
3	1	190715 PVC COUPLING
4	6	105901-30 BELT, FLAT CONVEYOR 3/4" X 68.75"
5	1	106202-20 BELT, FLAT CONVEYOR 1.25" X 68.75"
6	2	5008 9-2 BLOCK, BEARING
7	1	530676-01 ASSY, ROLLER FRONT DRIVE
8	1	533876-02 ASSY, IDLER ROLLER
9	1	534481-02 SHAFT, FRONT ROLLER
10	1	SP30202 BLOCK, VACUUM
11	1	SP28217-1 BLOCK, LOWER VACUUM
12	1	SP28218-1 BLOCK, UPPER VACUUM
13	1	SP30201-1 TABLETOP 30.5 IN EXT. CANTER VA



SCALE 0.125

DRAWN BY: T JG

CHECKED BY: J - Jan - 07

TRACED BY:

REV NO DATE DESCRIPTION ECN NO BY

1	KR215
RECO'D	WHERE USED

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IN ANY FORM WITHOUT THE
EXPRESS WRITTEN PERMISSION
OF KIRK-RUDY, INC.
KR WOODSTOCK, GEORGIA

SCALE: 0.125

MODEL: SA492

DATE: 11-10-07

FINISH: N/A

THIRD ANGLE PROJECTION

DRAWING #: DUAL HTD

TITLE: ASSY, CENTER TABLETOP DUAL HTD

SHEET NO. 0F1

536468-05

ITEM NO.	PART #	DESCRIPTION	REV. NO.	DATE	ECN NO.
1	2	103804 BEARING, HUB .625			
2	4	103805 BEARING, HUB .750			
3	1	103812 BEARING, HUB .625			
4	1	108820 PULLEY, TIMING 16L075 .750B .188K			
5	2	108821 PULLEY, TIMING 19L075 .750B .188K			
6	1	109741 PULLEY, TIMING 325M15 .750B .188K			
7	1	109742 PULLEY, TIMING 385M15 .750B .188K			
8	4	500725 GUIDE - BELT			
9	1	500785 BLOCK, SPRING			
10	1	500824 SHAFT - BELT GUIDE			
11	1	508540 STUD			
12	1	525408 STUD, TAKEUP ARM			
13	4	102672-1 SPACER, SIDE PLATE			
14	1	105000-1 V-PULLEY			
15	1	108946-16 BELT, TIMING 36L015			
16	1	500701-L PLATE, FRAME KR215 LH			
17	1	500701-R PLATE, FRAME KR215 RH			
18	1	500702-1LR TABLETOP, RH SIDE SPLIT BELT ACCESS			
19	1	500702-14R TABLETOP, RH SIDE SPLIT BELT ACCESS			
20	1	500702-9L TABLETOP, L/H SIDE			
21	3	500721-8 GUSSET, TABLETOP SUPPORT CUTOUT			
22	3	500721-24 GUSSET, TABLETOP SUPPORT			
23	1	500721-26 GUSSET, TABLETOP CUTOUT SPLICE			
24	1	500725-7 GUIDE, BELT			
25	1	500824-1 SHAFT, FRAME SPACER			
26	1	500825-1 SHAFT, 215 MAIN DRIVE			
27	1	508684-1 ARM, TAKE UP			
28	1	508810-5 SHAFT, JACK			
29	1	510628-7 BLOCK, BEARING SPACER OFFSET			
30	1	516055A ASSY, IDLER I .376 DIA X 1.00			
31	1	536417-01 ASSY, TAKE UP TIMING BELT			
32	1	537638-01 BAR, PLATE SPLICE			
33	1	531639-01 PLATE, TABLETOP INSERT			
34	1	531691-01 BAR, ENCODER STUD MNT			
35	1	538341-01 STUD, ENCODER MOUNT			
36	1	538936-01 ASSY, ECCENTRIC BELT IDLER			
37	1	551150-01 BAR, TABLETOP SPLICE			

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2	ASSY, 215 FRAMES DUAL BELT	SCALE 0.090
3	551182-01	REF. TO WHERE USED

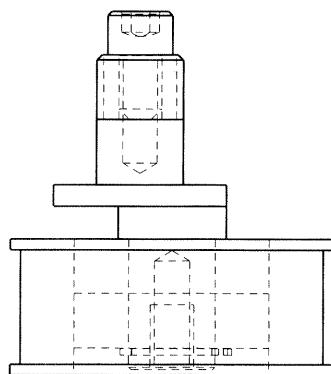
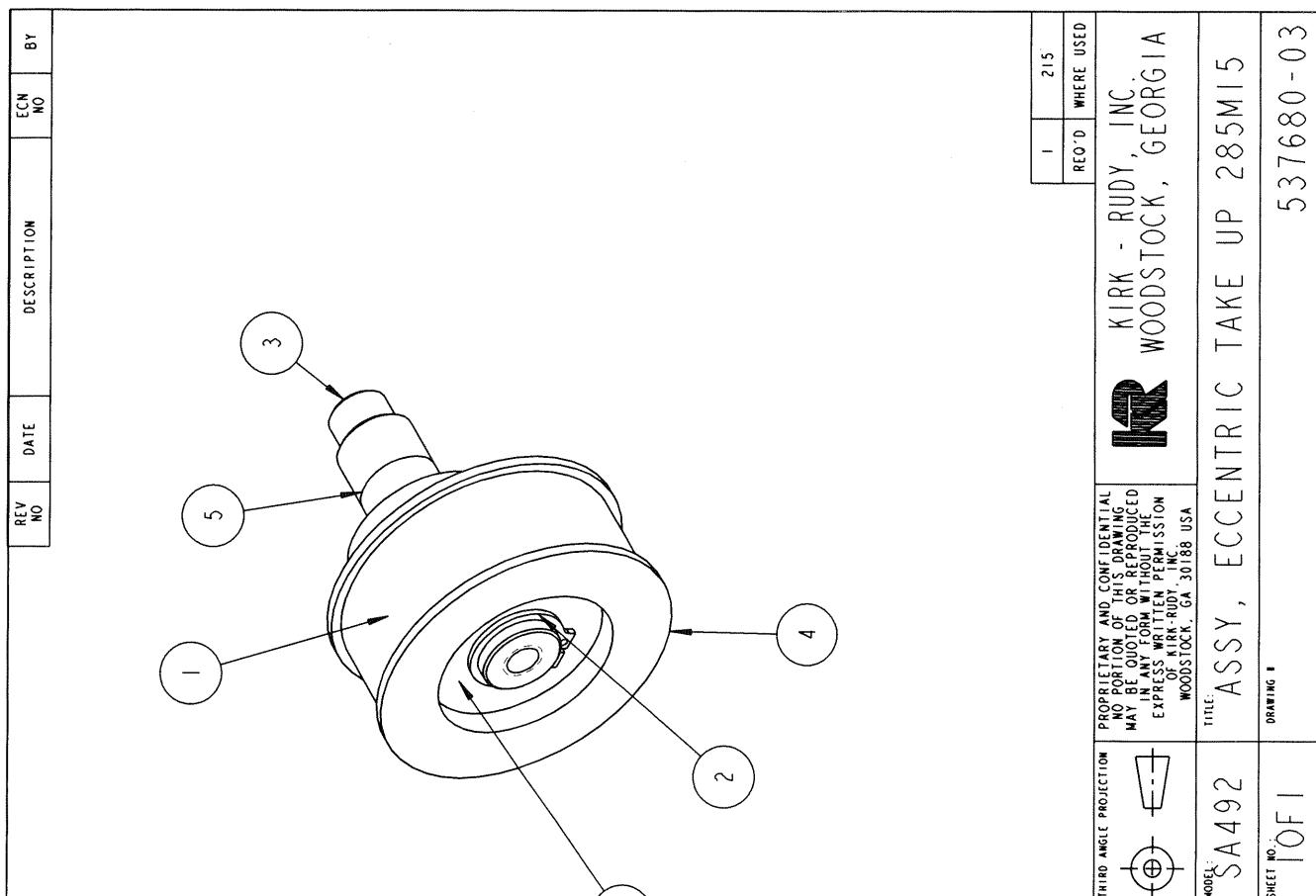
DRAWN BY: T JG SCALE 0 .125 DIMENSION TO FRANCES MATERIAL: XXX

CHECKED BY: DATE 11-10-07 MEAS. INCHES: -3 REMOVE ALL GUAGES AND
SHOW ALL UNLESS OTHERWISE SPECIFIED

TRACED BY: MASTER SCALE 1" OF 1

PRINTED BY: KIRK RIDY, INC.

ITEM	QTY	PART #	DESCRIPTION
1	2	103108	BEARING, FLAT .500
2	1	104106	SNAPRING, .500
3	1	107403	SCREW, SHCS 1/4-20X .375
4	1	109710	PULLEY, TIMING 285M15 1.1248 DIA
5	1	500983-7	STUD, IDLER SPROCKET



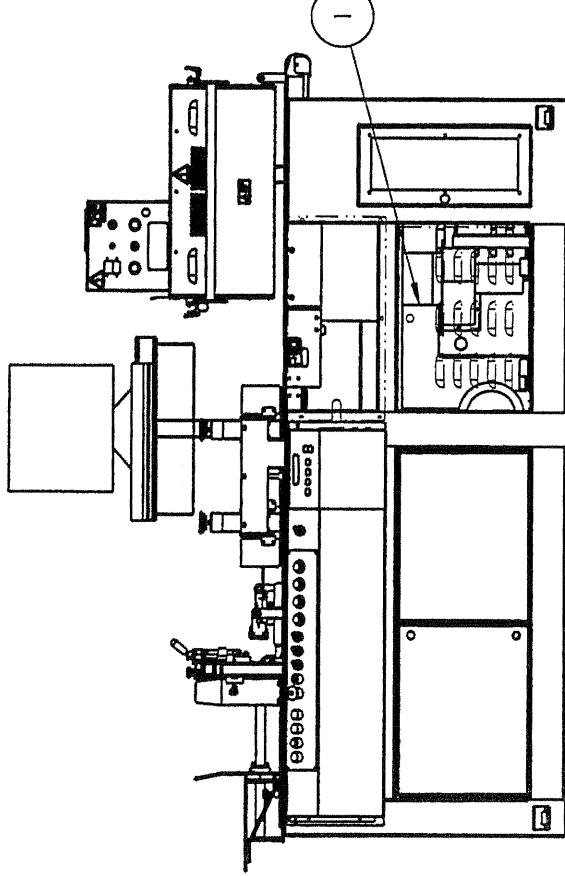
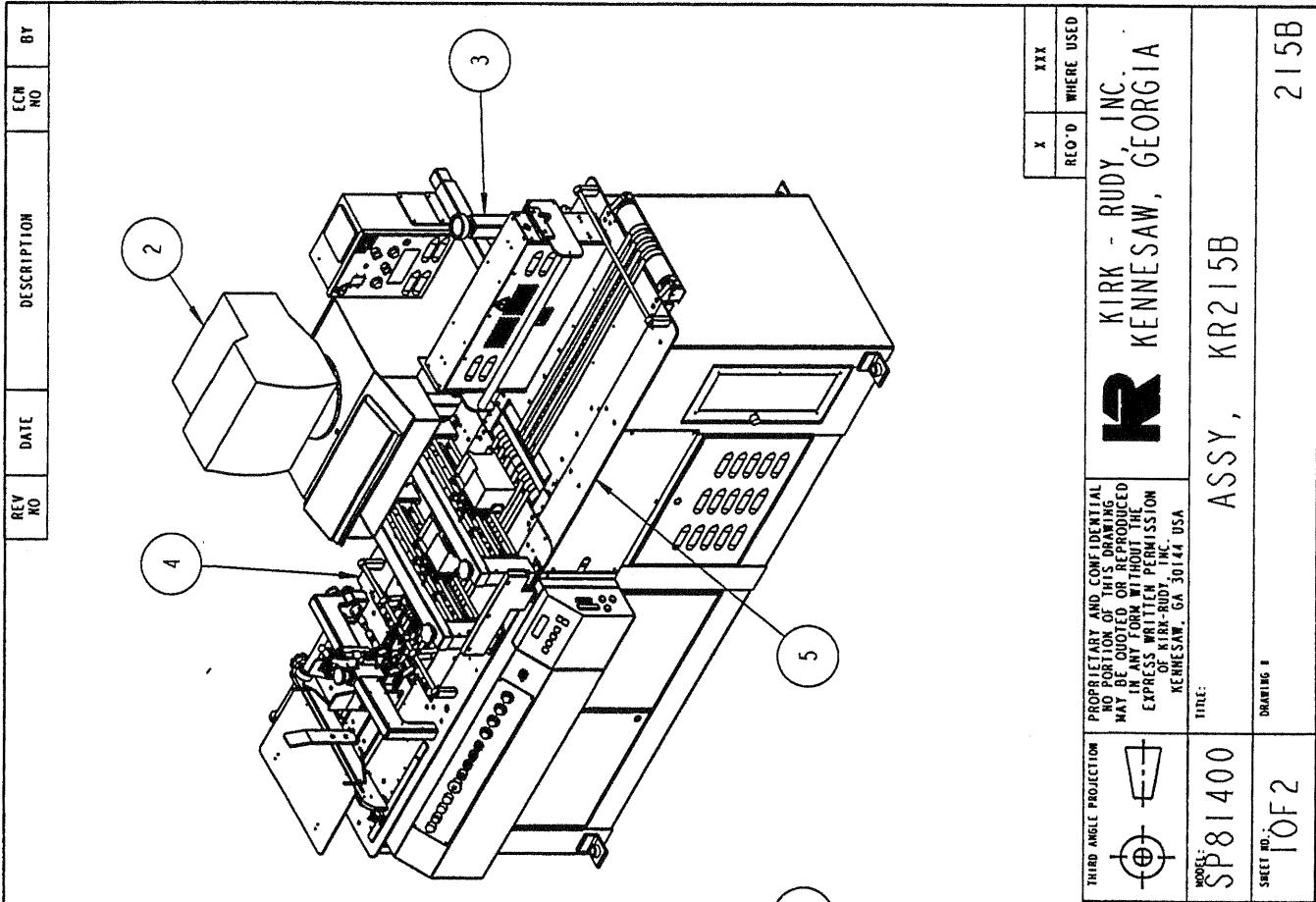
SCALE 1.000

REV NO	DATE	DESCRIPTION	ECN NO	BY
I	215	RECD WHERE USED		

DRAWN BY:	SCALE	MATERIAL:	THIRD ANGLE PROJECTION	PROPRIETARY AND CONFIDENTIAL INFORMATION CONTAINED ON THIS DRAWING AND IN THE ORIGINALLY SUBMITTED OR ACCORDINGLY PROVIDED DRAWINGS OR SPECIFICATIONS MAY BE OBTAINED OR DISCLOSED FROM KIRK-RUDY INC. WITHOUT PRIOR WRITTEN PERMISSION OF KIRK-RUDY INC., WOODSTOCK, GA 30188 USA
T JG	.000	XXX	XXX	KIRK - RUDY , INC WOODSTOCK , GEORGIA
CHECKED BY:	DATE	XX	XX	KIRK - RUDY , INC WOODSTOCK , GEORGIA
TRACED BY:	MASTER	01 .005 .5	HEAT TREAT:	ASSY , ECCENTRIC TAKE UP 285M15
			FINISH:	SHEET NO. 1 OF 1 DRAWING #

537680 - 03

ITEM QTY	PART #	DESCRIPTION
1	190948	DUCT, EXTENDABLE ALUM 6 IN.
2	532152-02	ASSY, MONITOR STAND W/ 2 TRAY
3	533708-04	ASSY, KR881 DRYER MOUNT
4	536470-02	ASSY, 215 MOD. + 36 FRAMES
5	538288-01	ASSY, CABINET & COVERS



X	XXX
RELO'D	WHERE USED

DRAWN BY:	T JG	SCALE	0 . 050	MATERIAL:	XXX	THIRD ANGLE PROJECTION	PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE QUOTED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC. KENNESAW, GA 30144 USA
CHECDED BY:		DATE	17 - Jan - 00	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	.01 .005 .005	ANG.	NOTE: SP81400
TRACED BY:	MASTER			REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED		HEAT TREAT:	ASSY , KR215B
				ALL DIMENSIONS ARE FINISH	XXX	SHEET NO. 10F2	DRAWING # 215B
				DO NOT SCALE - WORK TO DIMENSIONS ONLY			

REV NO	DATE	DESCRIPTION	ECN NO	BY

93.919

9.500

20.125

65.155

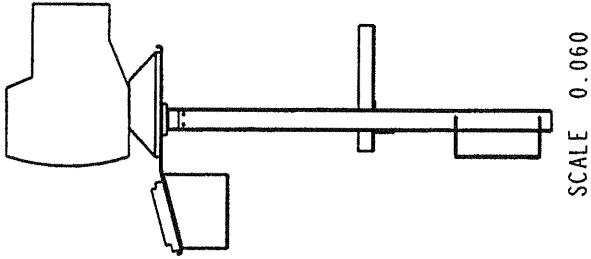
33.283

93.919

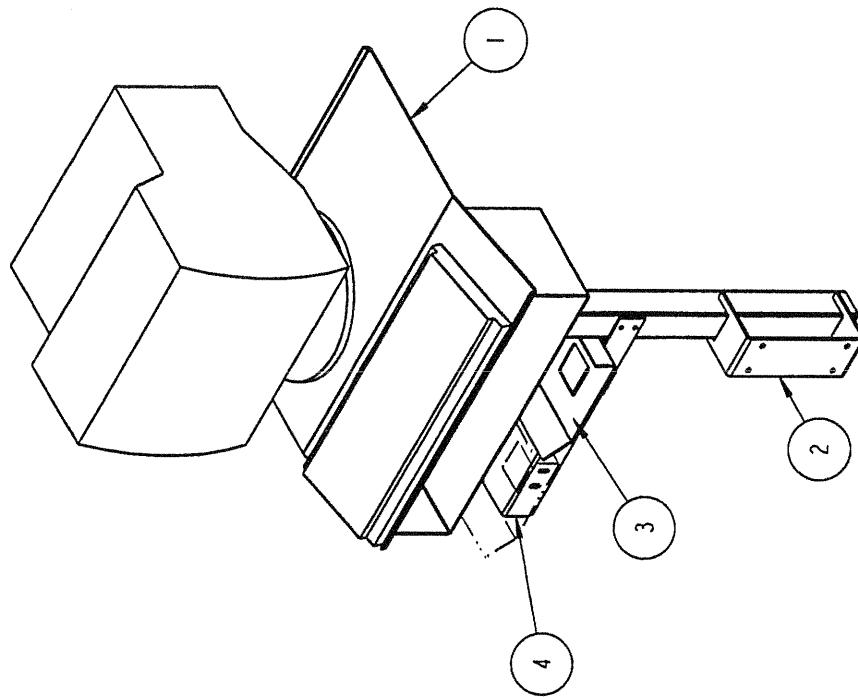
DRAWN BY: T JG	SCALE: 0 .050	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	MATERIAL: XXX	THIRD ANGLE PROJECTION	PROPRIETARY AND CONFIDENTIAL NO PART OF THIS DRAWING MAY BE OPIATED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY INC. KENNESAW, GA 30144 USA.
CHECKED BY:	DATE: 17 - Jan - 00	.01 .005 .5	WEAR TREAT: XXX	MODEL: SP81400	TITLE: ASSY , KR215B
TRACED BY:	MASTER M	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED	FINISH: XXX	SHEET NO. 20F2	DRAWING # 215B
ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY					

ITEM	QTY	PART #	DESCRIPTION
1	1	532155-02	ASSY, MONITOR PIVOT
2	1	536586-01	WLDWT, MONITOR STAND
3	2	536932-01	SHELF, INKCARTRIDGE HP
4	1	538095-01	BRACKET, INK TRAY MTG SHORT

REV NO	DATE	DESCRIPTION	ECN NO	BY
I	25-JUL-00	ADDED 536932-01 & 538095-01	6560	ATB



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



DRAWN BY:	SCALE	0 . 100	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
CHECKED BY:	DATE	27 - Aug - 99	.XX - .XXX	ANG. .01 -.005	MAT TREAT: NONE	NOTE: SP76500
TRACED BY:	MASTER			FINISH: NOTE D	SHEET NO.: 1 OF 1	TITLE: ASSY, MONITOR STAND W/ 2 TRAY
					DRAWING #	532152-02

ITEM QTY	PART #	DESCRIPTION
1	2	100338 BUSHING, FLI. 0001DI. 2500DI. 500L6
2	1	532128-02 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

ITEM	REV NO	DATE	DESCRIPTION	ECN NO	BY

SCALE 0.125

DRAWN BY: T JG SCALE 0 . 312 DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED MATERIAL: NOTED

XX	.01	.005	.5
JIT	ANG.		

NOTE: REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED

ALL DIMENSIONS ARE FINISHED DIMENSIONS

MASTER DRAWN BY: SP76500 SHEET NO: 1 OF 1 DRAWING #

TRACED BY: M DATE: 26 - AUG - 99 FINISH: XXX

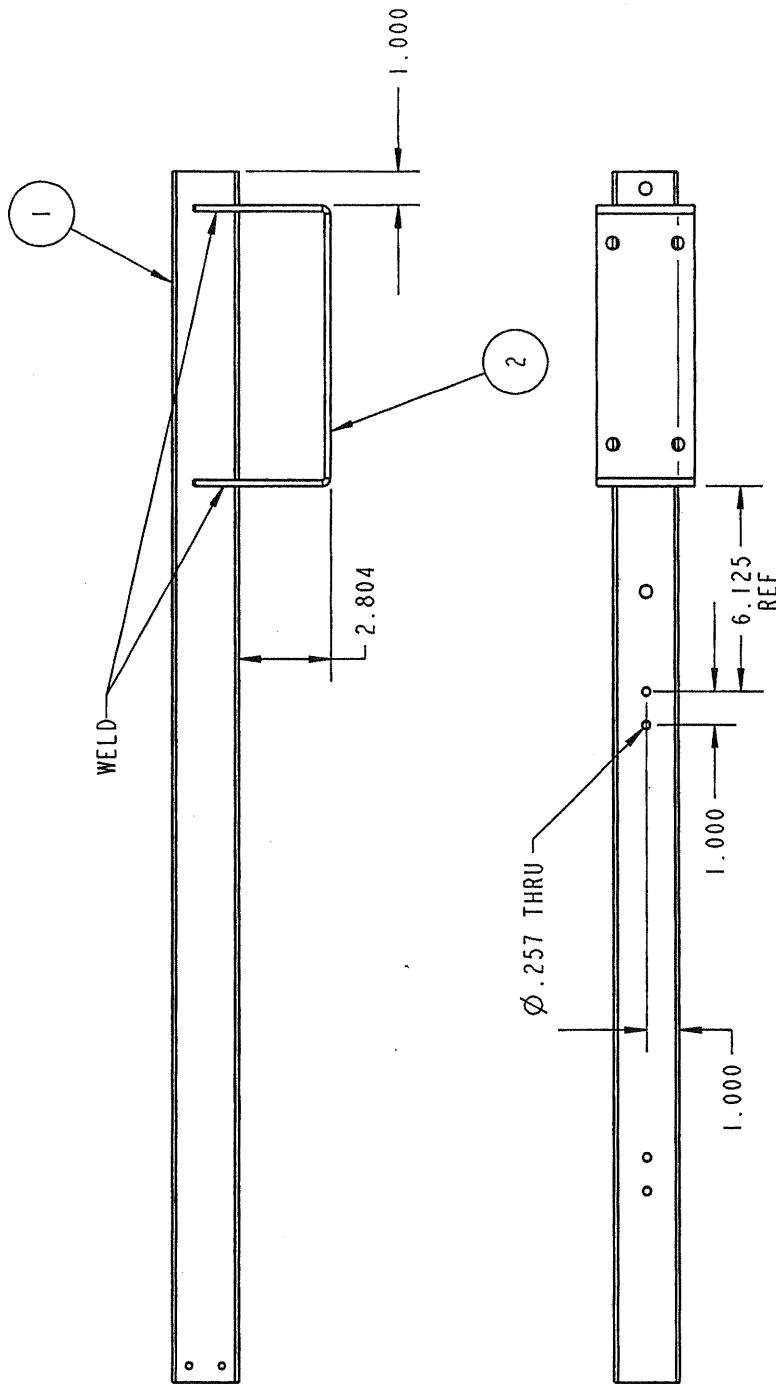
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KENNESAW, GA 30144 USA

KIRK - RUDY, INC.
KENNESAW, GEORGIA

ASSY, MONITOR PIVOT

1 532152-02
REQ'D WHERE USED

ITEM QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	1	532153-01			TUBING, VERTICAL		
2	1	532164-01			BRACKET, INTERFACE		



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 30144 USA			
KR KIRK - RUDY, INC. KENNESAW, GEORGIA			
TITLE: WLDMT, MONITOR STAND			
DRAWING # 536586-01			
SHEET NO. 1 OF 1			
SCALE: 0.188			
DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED			
.01	.005	.5	AMG.
DATE: 27-AUG-99			
CHECKED BY: M			
TRACED BY: M			
MASTER			
DRAWING: 1			
NOTE: REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED			
NOTE: ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE. WORK TO DIMENSIONS ONLY			

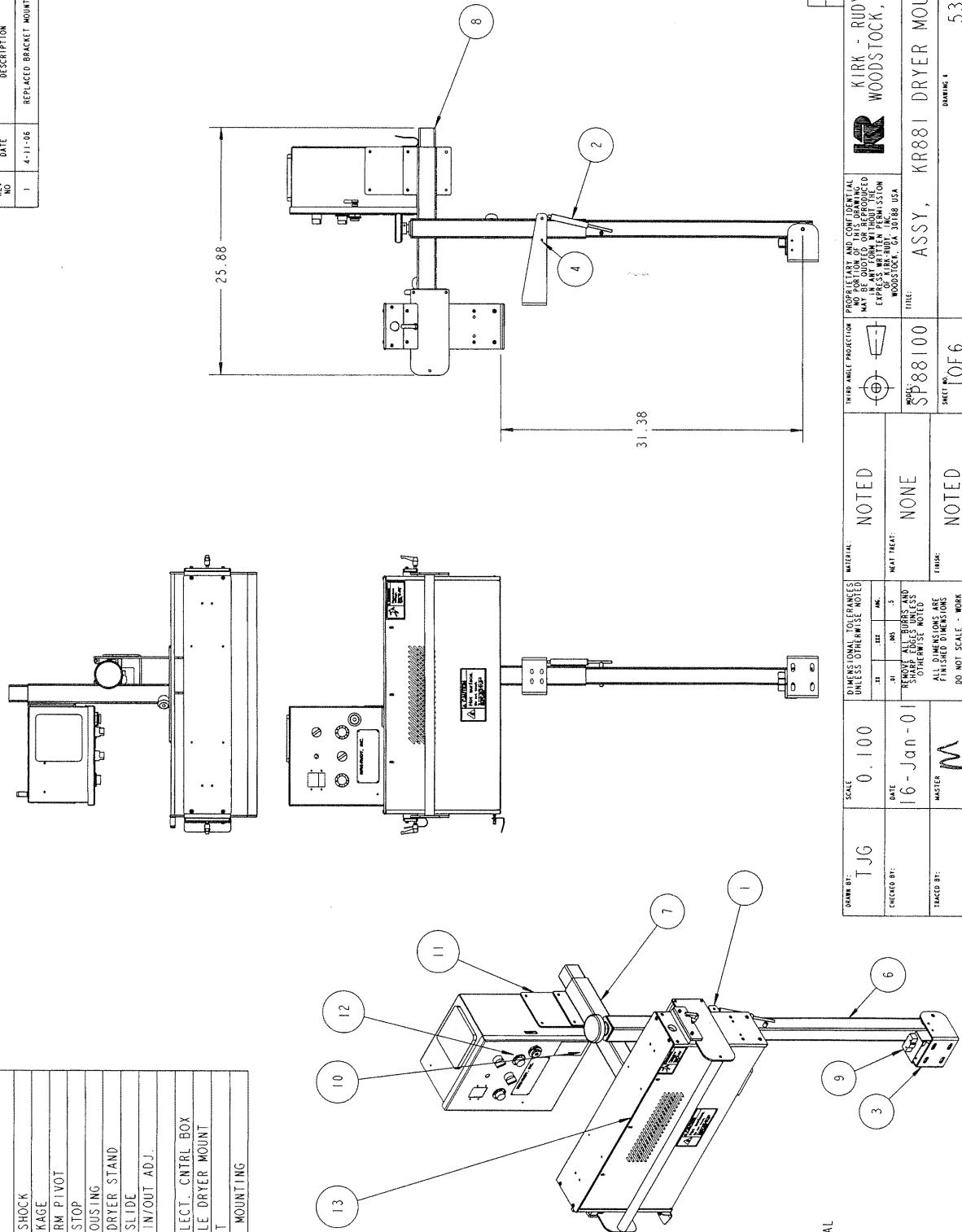
DRAWING I

533708-04

ITEM QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	1	532452-04			BRACKET, GAS SHOCK		
2	1	532453-01			GAS SHOCK LINKAGE		
3	1	532466-01			ASSY, DRYER ARM PIVOT		
4	1	532468-01			SHAFT, DRYER STOP		
5	1	532736-01			ASSY, SCREW HOUSING		
6	1	532738-01			WELD TUBING DRYER STAND		
7	1	532739-02			WELD TUBING SLIDE		
8	1	532744-02			WELD TUBING IN/OUT ADJ.		
9	1	533714-01			ASSY, SWITCH		
10	1	538722-01			ASSY, DRYER ELECT. CNTL BOX		
11	1	538734-01			BRACKET, SINGLE DRYER MOUNT		
12	1	538791-01			CLAMP, CONDUIT		
13	1	538792-01			ASSY, DRYER & MOUNTING		

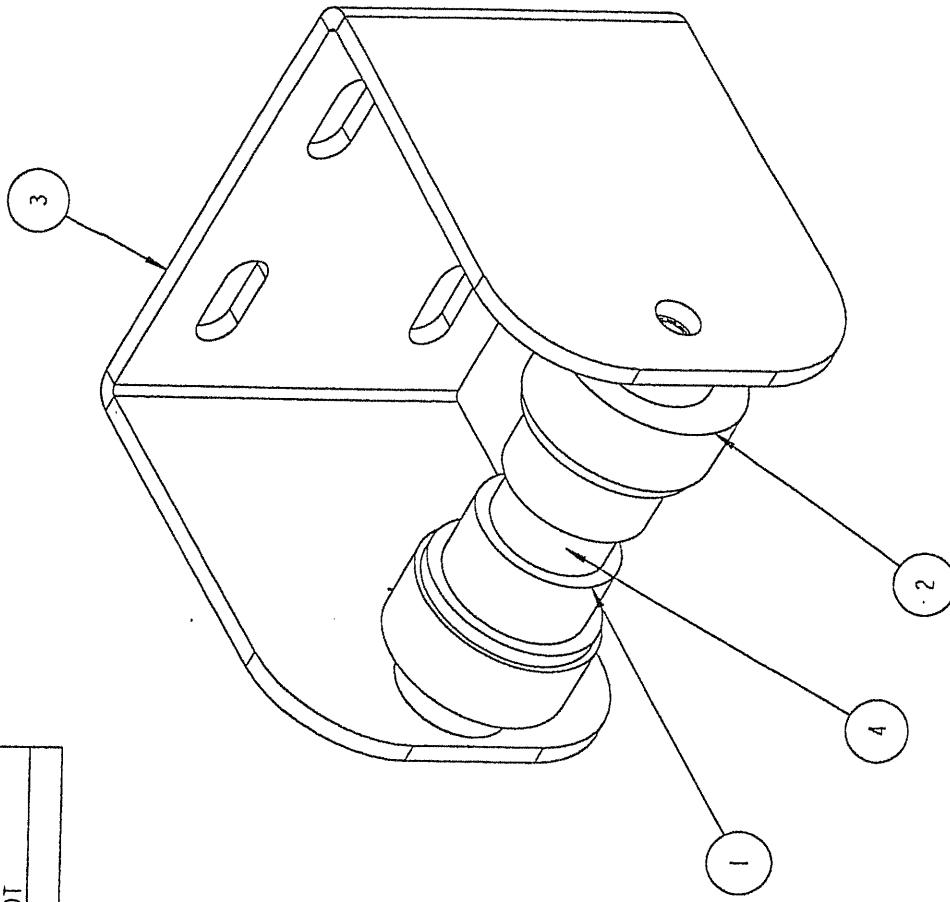
DRAWING I		DIMENSIONAL TOLERANCES MATERIAL:		NOTED		PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE QUOTED OR REPRODUCED EXCEPT AS PERMITTED BY EXPRESSIONS WRITTEN HEREIN. KIRK-RUDY INC. WOODSTOCK, GA 30188 USA	
SCALE	0 . 100	IN.	MM.	IN.	MM.	IN.	MM.
DRAWN BY:	T J G						
CHECKED BY:							
TRACED BY:							

NOTE:
 1. DRYER ARM IS OPTIONAL
 2. SINGLE DRYER SHOWN



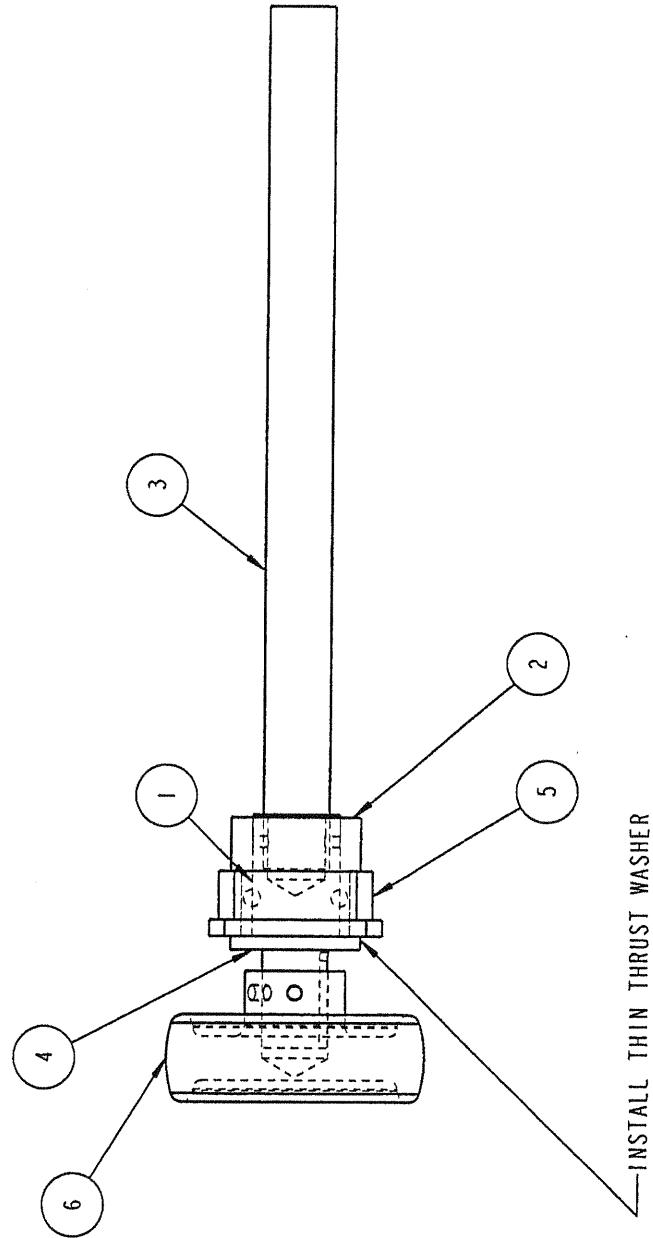
1	215B	RECD WHERE USED
KIRK - RUDY INC.		
KR		WOODSTOCK, GEORGIA
ASSY,	KR88100	DRYER MOUNT
SHEET NO.	10F6	DRAWING I

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



ITEM NO.	T JG	SCALE	0 .750	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	NOTED	THIRD ANGLE PROJECTION	PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE COPIED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC. KENNESAW, GA 30144 USA
CHECKED BY:	DATE		20 - Feb - 98	.01	.005	.5	HEAT TREAT:
TRACED BY:	MASTER		M	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY			NOTE:
							REV'D
							532466-01
							ASSY, DRYER ARM PIVOT
							DRAWING #
							532466-01

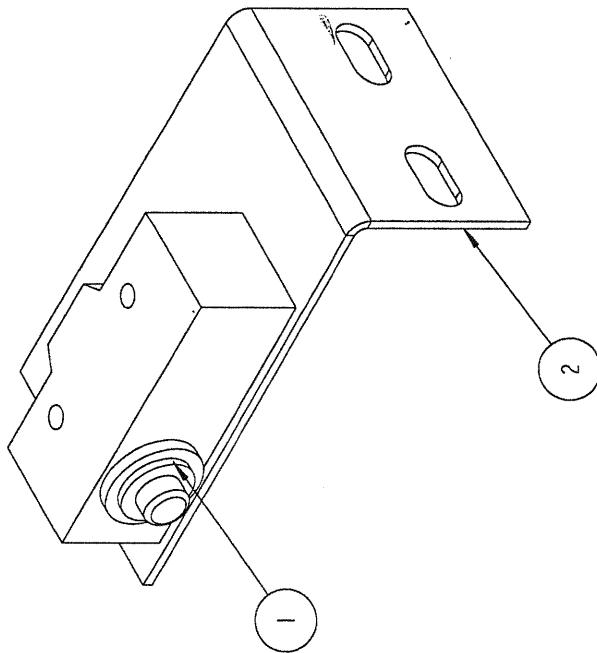
ITEM	QTY	PART #	DESCRIPTION
1	1	100257	BUSHING, SLI. 0001DI.2500D.750LG
2	1	102217	COLLAR 1.000
3	1	503734	THREADED ROD .3/4-10
4	1	503736	HUB
5	1	532737-01	BLOCK, ROD MOUNT
6	1	533006-01	HANDWHEEL, W/ KR LOGO



DRAWN BY:	SCALE	0 . 500	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	MATERIAL: NOTED	THIRD ANGLE PROJECTION	PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE COPIED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC. KENNESAW, GA 30044 USA
CHECKED BY:	DATE	20 - Feb - 98	.xx .xxx .005 .5	HEAT TREAT: NONE	MODEL:	KIRK - RUDY, INC. KENNESAW, GEORGIA
TRACED BY:	MASTER	M	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY	FINISH: NOTED	SHEET NO. 1 OF 1	TITLE: ASSY, SCREW HOUSING
				DRAWING #	532736 - 01	
				RECD'D	WHERE USED	
				1	532734-01	

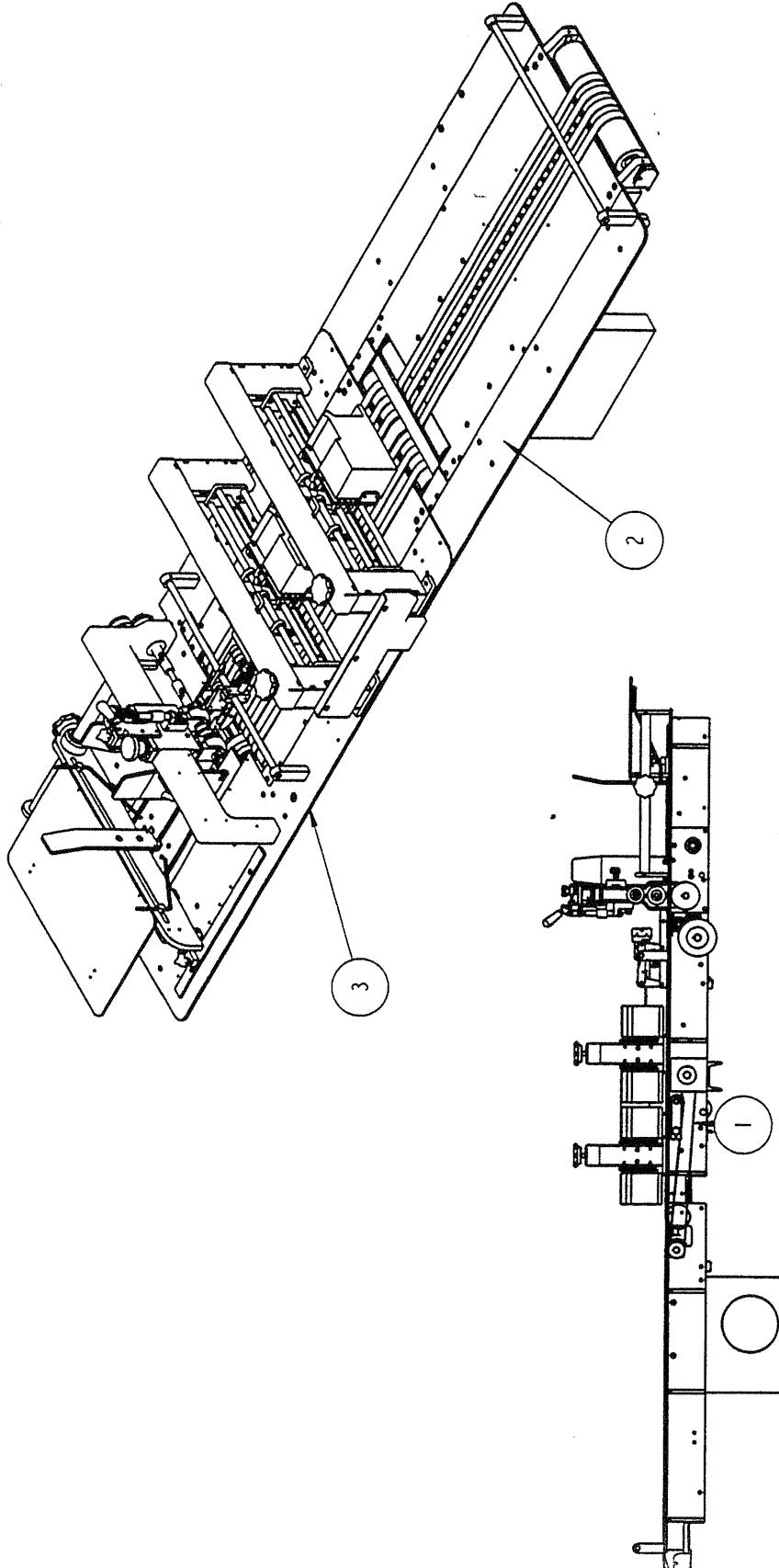
ITEM QTY	PART #	DESCRIPTION
1	1	201049-2 MICRO SWITCH
2	1	533713-01 BRACKET, SENSOR

ITEM	QTY	REV NO	DATE	DESCRIPTION	ECN NO	BY
	1	1	9/10/98	NEW MICROSWITCH	6370	RHM



1	533708-01
REQ'D	WHERE USED
KIRK - RUDY, INC.	
KENNESAW, GEORGIA	
KR	
PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE QUOTED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK - RUDY, KENNESAW, GA 3044 USA	
MODEL:	SP65600
TITLE:	ASSY, SWITCH
SHEET NO.:	10F1
DRAWING #:	533714-01

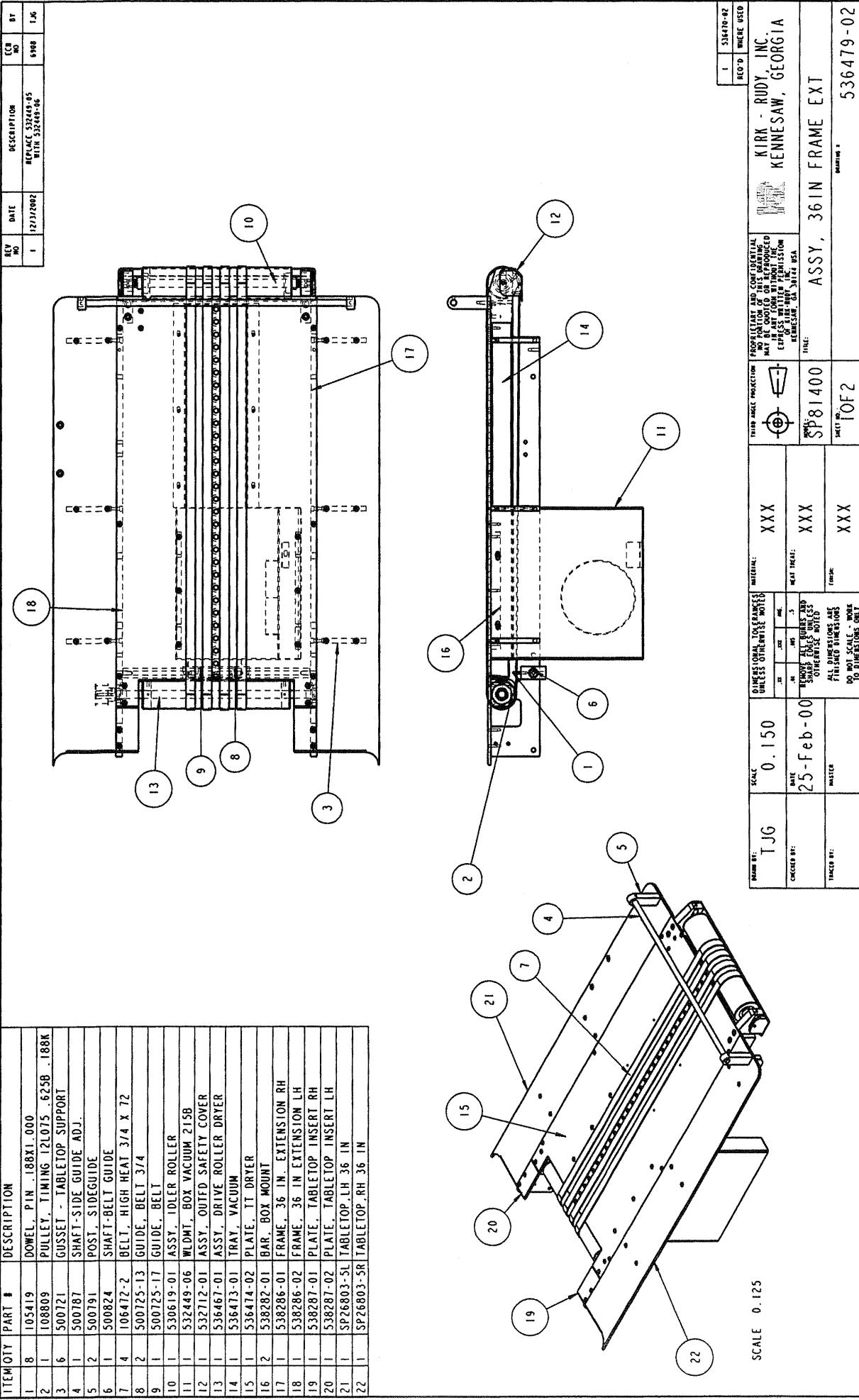
ITEM QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	1	108940-3	BELT, TIMING 420L075				
2	1	536479-02	ASSY, 36IN FRAME EXT				
3	1	536491-02	ASSY, FEEDER & FRAMES				



1	215B	
REO'D WHERE USED		
NOTES:		
1. SET UP FOR DUAL MOTOR 215		
KRK	KIRK - RUDY, INC.	
	KENNESEE, GEORGIA	
PROPRIETARY AND CONFIDENTIAL	NO DOCUMENTS OR DRAWINGS	
NO DOCUMENTS OR DRAWINGS	MADE BY KIRK - RUDY, INC.	
MADE BY KIRK - RUDY, INC.	OR DERIVED FROM DRAWINGS	
IN ANY FORM WHOM EVER MADE,	EXPRESS WRITTEN PERMISSION	
EXPRESS WRITTEN PERMISSION	OF KIRK - RUDY, INC.	
OF KIRK - RUDY, INC.	KENNESEE, GA 3044 USA	
TITLE:		
MODEL:	SP81400	
SHEET NO:	OF 2	
DRAWN BY:	T JG	
SCALE:	0 .080	
DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	N/A	
.XX	.XXX	ANG.
.01	.005	.5
DATE:	17 - Jan - 00	
CHECKED BY:		
TRACED BY:	MASTER	
SHARP EDGES UNLESS OTHERWISE NOTED	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED	
ALL DIMENSIONS ARE FINISHED DIMENSIONS	ALL DIMENSIONS ARE FINISHED DIMENSIONS	
DO NOT SCALE. WORK TO DIMENSIONS ONLY	DO NOT SCALE. WORK TO DIMENSIONS ONLY	

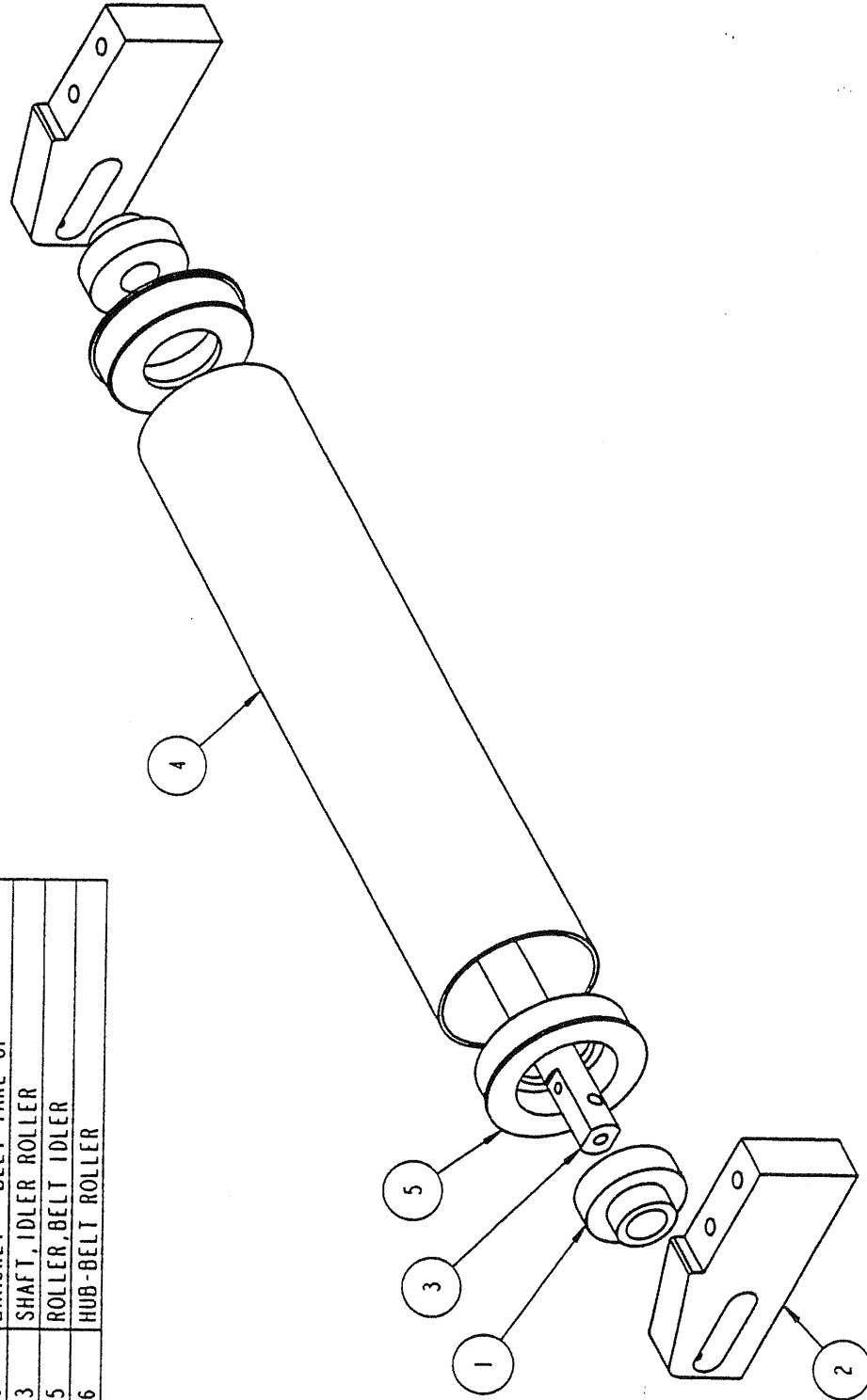
ITEM NO	PART #	DESCRIPTION
1	8	105419 DOWEL, PIN .1881L .000
2	1	108809 PULLEY, TIMING 12L015 .625B .188K
3	6	500721 GUSSET - TABLETOP SUPPORT
4	1	500787 SHAFT, SIDE GUIDE ADJ.
5	2	500791 POST, SIDEGUIDE
6	1	500824 SHAFT, BELT GUIDE
7	4	106412-2 BELT, HIGH HEAT 3/4 X 72
8	2	500725-13 GUIDE, BELT 3/4
9	1	500725-17 GUIDE, BELT
10	1	536474-01 ASSY, IDLER ROLLER
11	1	532449-06 WLDNT, BOX VACUUM 215B
12	1	532712-01 ASSY, OUTED SAFETY COVER
13	1	536461-01 ASSY, DRIVE ROLLER DRYER
14	1	536473-01 TRAY, VACUUM
15	1	536474-02 PLATE, IT DRYER
16	2	538282-01 BAR, BOX MOUNT
17	1	538286-01 FRAME, 36 IN EXTENSION RH
18	1	538286-02 FRAME, 36 IN EXTENSION LH
19	1	538281-01 PLATE, TABLETOP INSERT RH
20	1	538281-02 PLATE, TABLETOP INSERT LH
21	1	SP26803-5L TABLETOP, H 36 IN
22	1	SP26803-5R TABLETOP, RH 36 IN

REV NO	DATE	DESCRIPTION	CCN NO	BT
1	12/13/2002	REPLACE 532449-05 WITH 532449-06	6980	14



1	536479-02
RECORD	WORKED

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

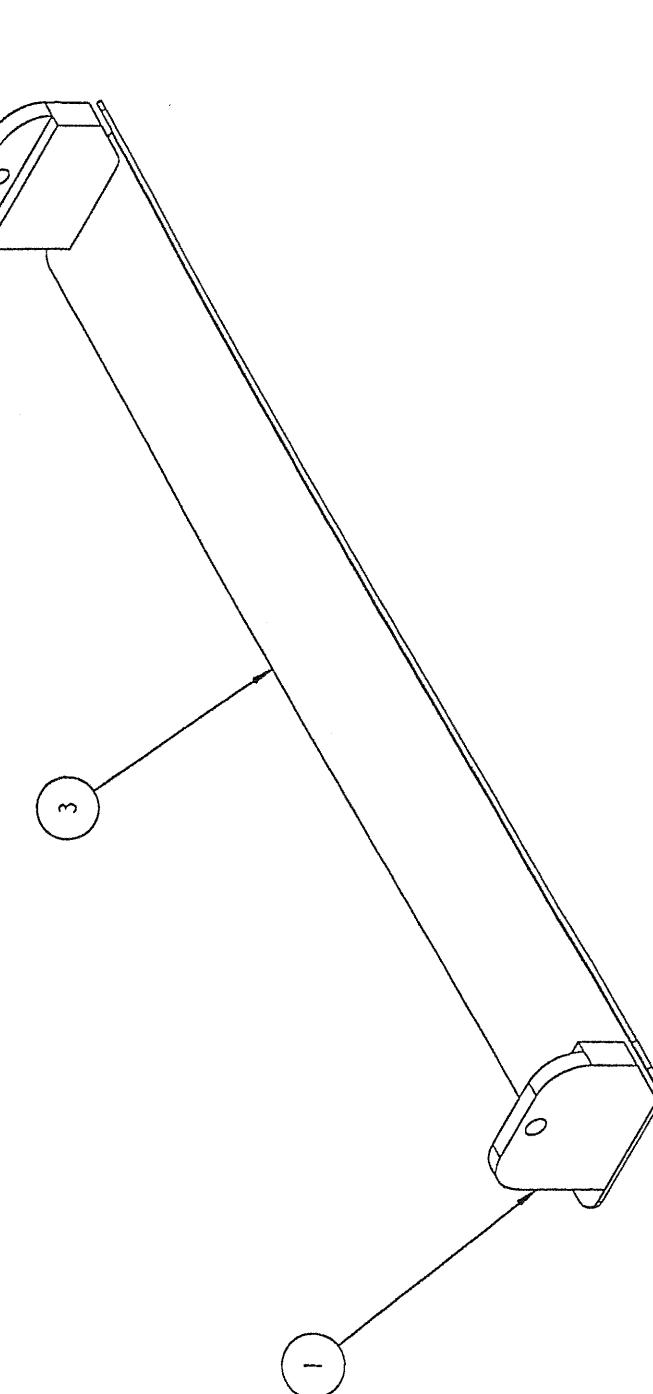


ITEM	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BT
1	2 103804	BEARING, HUB .625					
2	2 500716	BRACKET - BELT TAKE-UP					
3	1 500823	SHAFT, IDLER ROLLER					
4	1 500835	ROLLER, BELT IDLER					
5	2 500836	HUB-BELT ROLLER					

DRAWN BY:	SCALE	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	MATERIAL:	THIRD ANGLE PROJECTION	PROPRIETARY AND CONFIDENTIAL
A KEY	0 .410	.000 .000 .005 .5	N / A		NO PORTION OF THIS DRAWING MAY BE QUOTED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC.
CHEKED BY:	DATE		MEAT TREAT:		KIRK-RUDY, INC. KENNESAW, GEORGIA
TRACED BY:	MASTER			SP 71700	KENNESAW, GA 30446 USA
				Sheet No. 10 of 1	LINE:
					DRAWING #
					530619-01

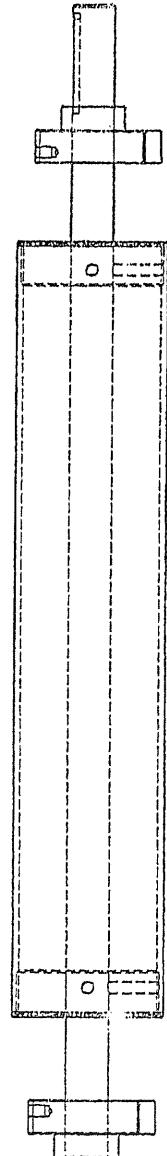
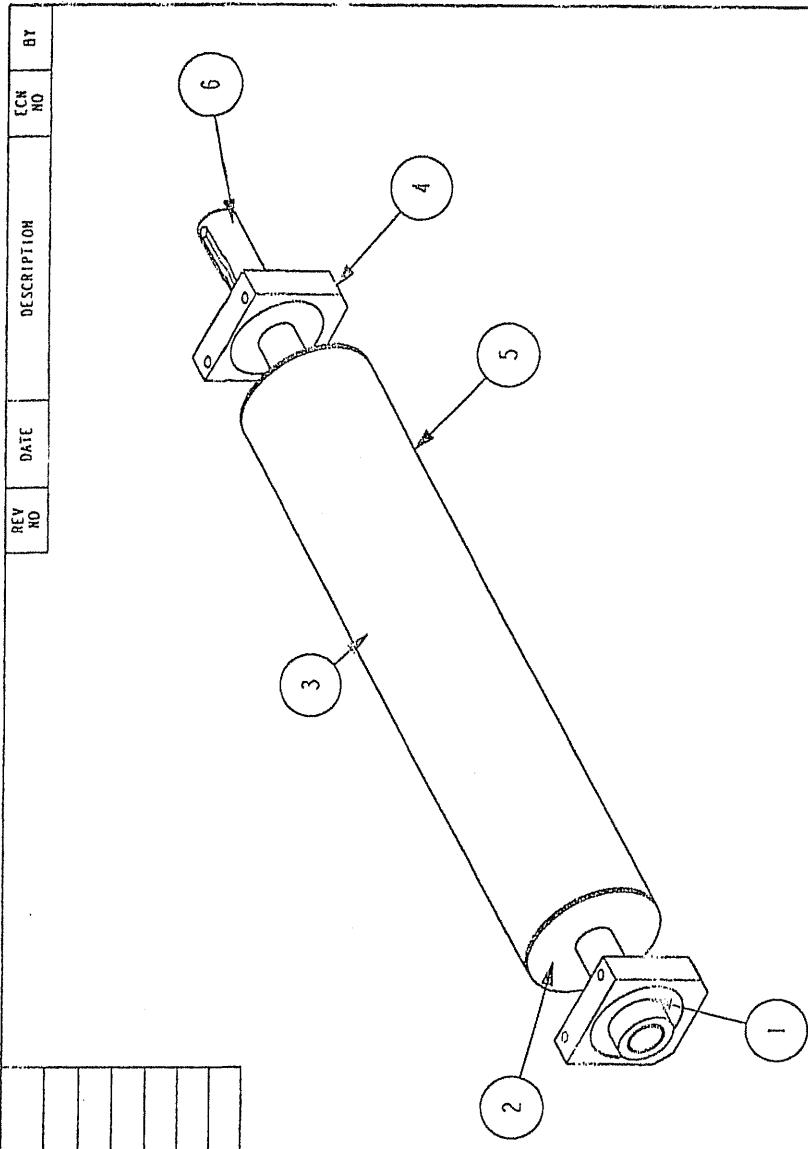
ITEM QTY	PART #	DESCRIPTION
1	1	530816-01 BURKT, RH OUTFD RLLR GRD
2	1	530817-01 BURKT, LH OUTFD ROLLR GRD
3	1	530818-01 GUARD, OUTFEED ROLLER

ITEM	SCALE	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	T JG	0 . 500	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	MATERIAL: NOTED	THIRD ANGLE PROJECTION	PROPRIETARY AND CONFIDENTIAL DO NOT REPRODUCE OR DISTRIBUTE. MAY BE USED ON COPY FOR PERSONAL USE IN ANY FORM WITHOUT EXPRESS WRITTEN PERMISSION ON KIRK-RUDY INC. KENNESAW, GA 30144 USA
2	MASTER	6 - Feb - 98	.000 -.005 .005 .5	HEAT TREAT: NONE	NOTE: 215	KIRK - RUDY, INC. KENNESAW, GEORGIA
3	MASTER	M	REMOVAL ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED	FINISH: NOTED	SHEET NO: 1 OF 1	TITLE: ASSY, OUTFD SAFETY COVER
			ALL DIMENSIONS ARE FINISHED DIMENSIONS			DRAWING #
			DO NOT SCALE - WORK TO DIMENSIONS ONLY			532712-01



1	532078-01
RE'D	WHERE USED

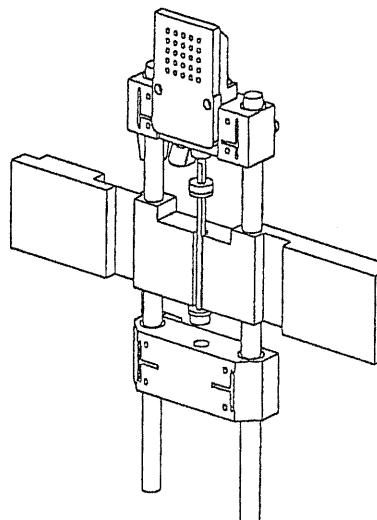
ITEM QTY	PART #	DESCRIPTION
1	2	103804 BEARING - HUB
2	2	500839 HUB-BELT DRIVE
3	1	500742-4 ROLLER - TUBE BELT DRIVE
4	2	500819-1 BLOCK-BEARING
5	1	530676-01 ROLLER ASY
6	1	534181-02 SHAFT, FRONT ROLLER



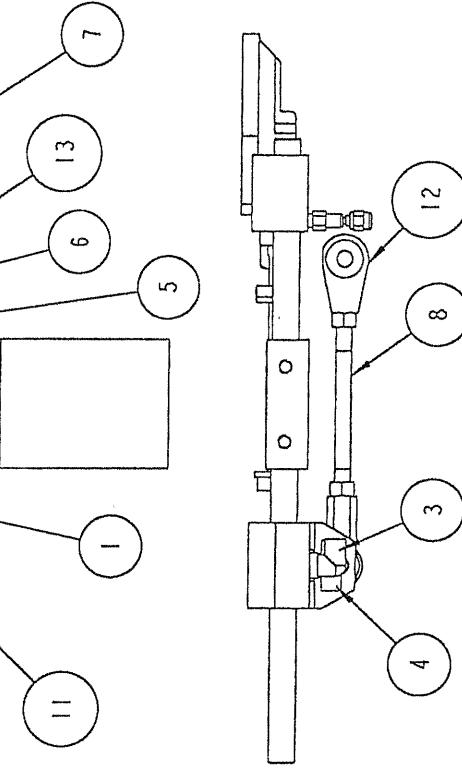
DRAWN BY:	SCALE:	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	MATERIAL:	THIRD ANGLE PROJECTION	PROPRIETARY AND TRADE IDENTIFICATION
T JG	0 . 375	.01 .015 .005 .5	N / A		KIRK - RUDY, INC. KENNESAW, GEORGIA
CHECKED BY:	DATE:		HEAT TREAT:		EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC. KENNESAW, GA 30144 USA
	27 - Aug - 99		N / A		TITLE: Sp76500 ASSY, DRIVE ROLLER DRYER
TRACED BY:	MASTER:		N / A	SHEET NO. 1 OF 1	DRAWING #
	M				536467-01

DRAWING 1			
ITEM #	PART #	DESCRIPTION	REV. NO.
			DATE
1	103805	BEARING, HUB .750	ECN NO. 61
2	103820	PULLEY, TIMING 161075 .750B .88K	
3	103892	PULLEY, TIMING 191075 .750B .88K	
4	103861	BELT, TIMING D187L050	
5	109123	PULLEY, TIMING 285M15 .750B .88K	
6	103847	PULLEY, 28XL037 .625B NK	
7	103848	PULLEY, 26XL037 .375B NK	
8	500105	TABLETOP - NARROW SHUTTLE	
9	4	GUIDE - BELT	
10	3	500824 SHAFT-BELT GUIDE	
11	1	500825 SHAFT-SPROCKET DRIVE	
12	1	500870 SHAFT, GEARBOX	
13	1	105000-1 Y-PULLEY	
14	1	103846-2 BELT, TIMING 367L075	
15	1	109015-1 BELT, TIMING 180XL037	
16	1	109124-3 BELT, TIMING 520-5M-15	
17	2	109125-4 BELT, TIMING 253-5M-15	
18	1	500702-4R TABLETOP, R/H SIDE	
19	1	500102-9L TABLETOP, L/H SIDE	
20	1	500125-7 GUIDE, BELT	
21	1	500131-3 CHANNEL, JACKSHAFT SUPPORT	
22	1	510628-1 BLOCK, BEARING	
23	1	531021-01 ASSY, SHUTTLE TABLE	
24	1	531022-03 ASSY, LOWER FEED BELT DR.	
25	1	531405-01 ASSY, JOGGER TABLE	
26	1	536178-02 ASSY, BELT DRIVE PLATE	
27	1	536168-02 ASSY, CENTER TABLETOP	
28	1	536175-01 ASSY, 215 FRAME RH	
29	1	536176-01 ASSY, 215 FRAME LH	
30	1	536197-01 BAR, CABLE COVER	
31	1	536194-01 COVER, CABLE FRONT	
32	1	536135-01 COVER, CABLE BACK	
33	1	5317549-01 ASSY, BRIDGE TIMING BELT	
34	1	537658-01 BAR, PLATE SPLICE	
35	1	537659-01 PLATE, TABLETOP INSERT	
36	2	538169-01 ASSY, BRYCE INK JET BRACKET	
37	1	538188-01 ASSY, SKIDBAR SENSOR	
DRAWING 1 OF 2			
RECORD WHERE USED			
PROPRIETARY AND CONFIDENTIAL NO COPIES OR DERIVED MATERIALS MAY BE MADE OR REPRODUCED EXCEPT AS EXPRESSLY PERMITTED BY THE LICENSE AGREEMENT OR PURCHASE ORDER. WOODSTOCK, GA 37384 USA			
KIRK-RUDY, INC. WOODSTOCK, GEORGIA			
DRAWING 1			
ASSY, FEEDER & FRAMES			
SCALE 0.060			
536491-02			

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



SCALE 0.180



1	215	RECD WHERE USED
1	1	215

DRAWN BY:	SCALE:	0.250	DIMENSIONAL TOLERANCES NO PORTION OF THIS DRAWING MAY BE QUOTED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, KENNESAW, GA 30144 USA
CHECKED BY:	DATE:	05-May-98	MATERIAL: N/A
TRACED BY:	MASTER:	M	HEAT TREAT: N/A
			FINISH: N/A

KR KIRK - RUDY, INC.
KENNESAW, GEORGIA



ASSY, SHUTTLE TABLE

531021-01

ITEM QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	2	102700 SPRING, COIL					
2	1	500705 TABLETOP - NARROW SHUTTLE					
3	2	500760 LIFTER- FEEDER PUSHER					
4	2	500762 PLATE-FEEDER PUSHER BOTTOM					
5	2	500775 PLATE-FEEDER PUSHER TOP					
6	2	531117-01 ASSY, PUSHER					

DRAWN BY: TVK Scale 0 . 375 DIMENSIONAL TOLERANCES MATERIAL: N / A
UNLESS OTHERWISE NOTED .01 .005 ANG. .5 HEAT TREAT: N / A

CHECKED BY: 01 - Mar - 99 REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED FINISH: N / A

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

RECD	215	WHERE USED
1	215	

KIRK - RUDY, INC.
KENNESAW, GEORGIA

K

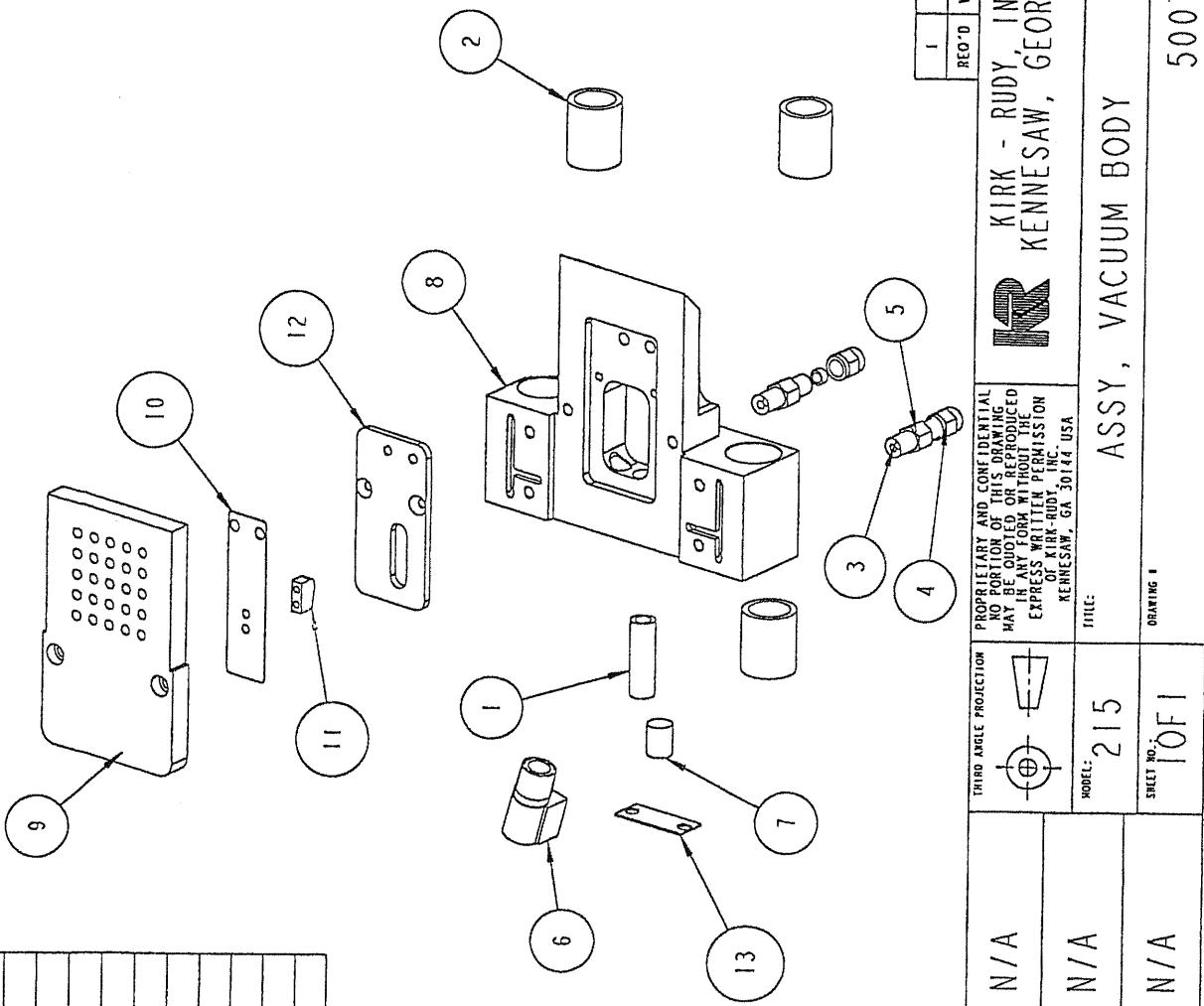
ASSY, SHUTTLE TABLE

215

500705A

DRAWING #

ITEM	QTY	PART #	DESCRIPTION
1	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	QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	1	531021-01	KIRK - RUDY, INC KENNESAW, GEORGIA					

DRAWN BY:	SCALE	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED		MATERIAL:	THIRD ANGLE PROJECTION		PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE QUOTED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK - RUDY, INC. KENNESAW, GA 30044 USA
TVK	0 . 380	.01	.005	N/A	.01	.005	HEAT TREAT:
CHECKED BY:	DATE:	.11	.005	N/A	.11	.005	FINISH:
TRACED BY:	MASTER	05-May-98	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED	N/A	215	N/A	SELECT NO.: 10F1

500708A

ITEM	QTY	PART #	DESCRIPTION
1	4	100145	BUSHING, SL.6251D.8130D1.000LG
2	1	500728	BRACKET - FEEDER

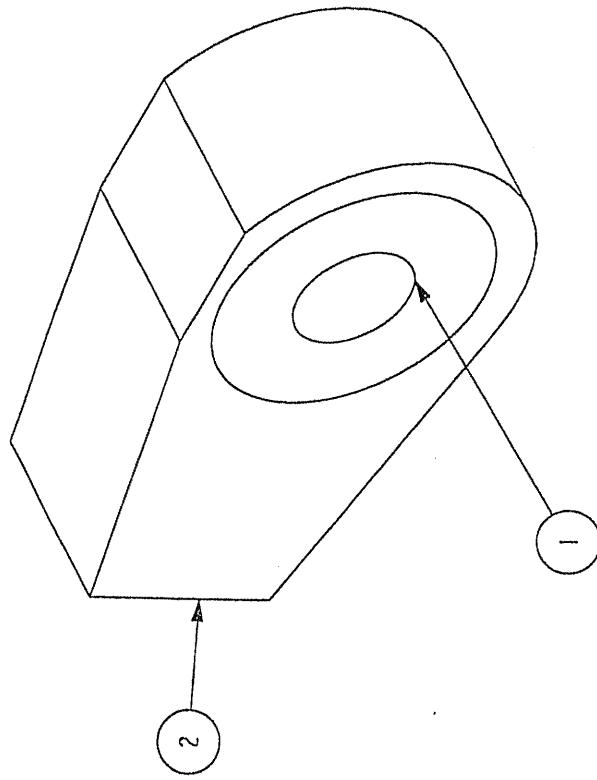
ITEM	REV NO	DATE	DESCRIPTION	ECN NO	BY

I 531021-01
REC'D WHERE USED

KIRK - RUDY, INC.
KENNESAW, GEORGIA

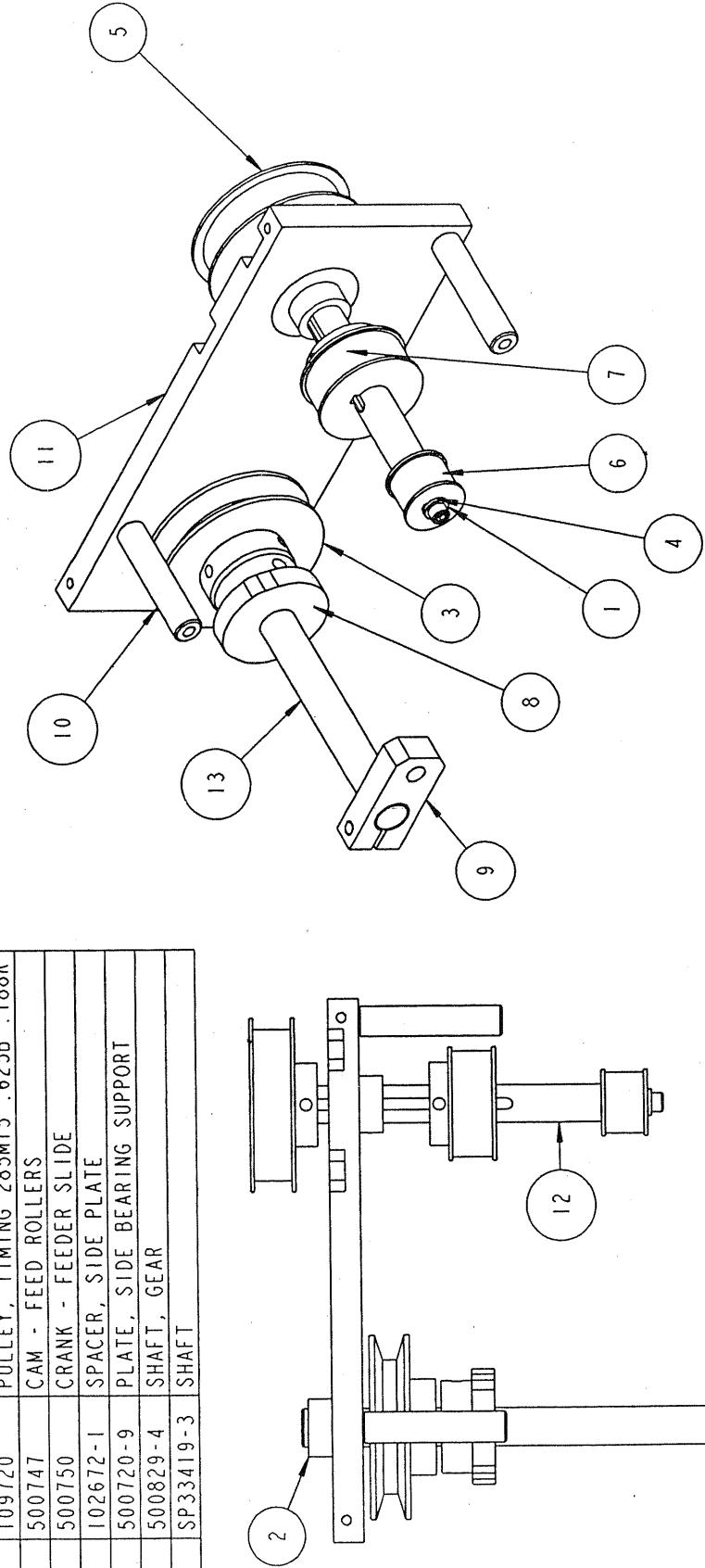
DRAWN BY:	M Y	SCALE	.000	MATERIAL:	N/A	THIRD ANGLE PROJECTION	PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE COPIED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC. KENNESAW, GA 30144 USA
CHECKED BY:		DATE	09 - Apr - 99	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	.01 .005 .5	AMG.	
TRACED BY:		MASTER	" M	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED		HEAT TREAT:	N/A
				ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY		NOTE:	215
						TITLE:	ASSY, BUSHING BLOCK
						SHEET NO.	1 OF 1
						DRAWING #	500728A

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



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 WHOLE OR IN PART WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY INC., KENNESAW, GEORGIA	REV'D	WHERE USED
MY	2 . 000	.000	.000	.000	N / A				
CHIEFED BY:	DATE:	.01	.005	.5	HEAT TREAT:				
	09 - Apr - 99	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED			FINISH:				
TRACED BY:	MASTER	ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY			FINISH:	N / A	SPLIT NO. 10F1	DRAWING #	500751A

ITEM QTY	PART #	DESCRIPTION
1	100619	WASHER, FLAT 10-32
2	103804	BEARING, HUB .625
3	105021	V-PULLEY, AK30
4	107409	SCREW, SHCS 10-32X.500
5	108841	PULLEY, TIMING 21L050 .625B .188K
6	109719	PULLEY, TIMING 165M15 .375B .125K
7	109720	PULLEY, TIMING 285M15 .625B .188K
8	500747	CAM - FEED ROLLERS
9	500750	CRANK - FEEDER SLIDE
10	2	102672-1 SPACER, SIDE PLATE
11	1	500720-9 PLATE, SIDE BEARING SUPPORT
12	1	500829-4 SHAFT, GEAR
13	1	SP33419-3 SHAFT

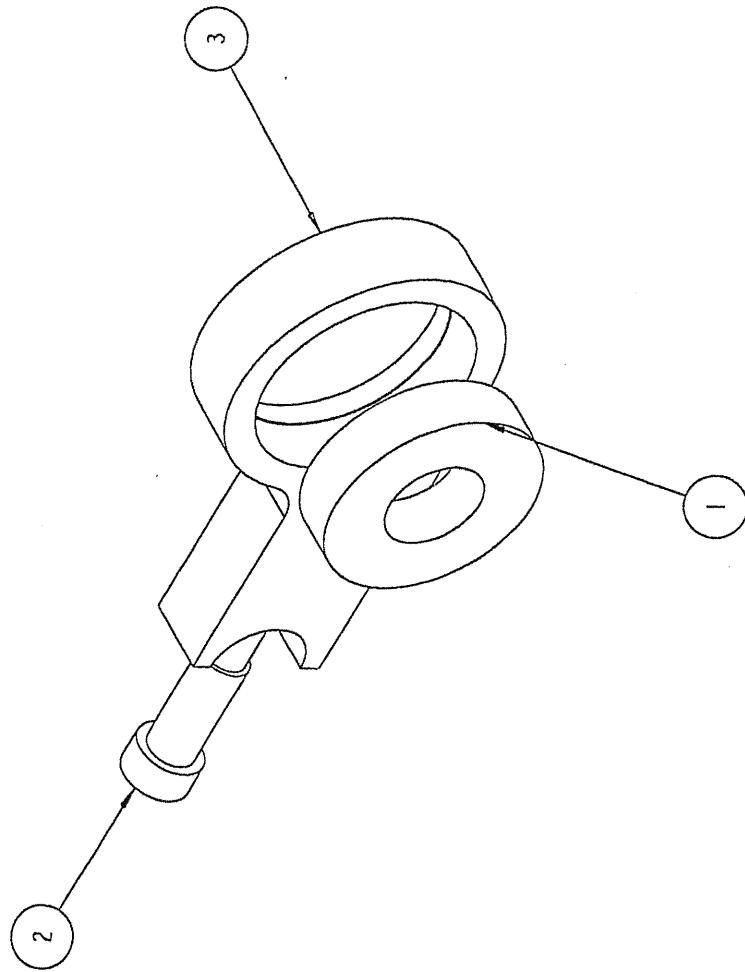


ITEM QTY	PART #	DESCRIPTION	REV N	DATE	DESCRIPTION	ECN NO	BY
1	1	100619	1	3/22/2000	REPLACED 500720 W/ HUB BRG.	6531	TJG
2	2	103804	2	6/22/2005	REPLACED WASHER 531683-01 WITH 100619	7258	CNC

REF'D	2151J
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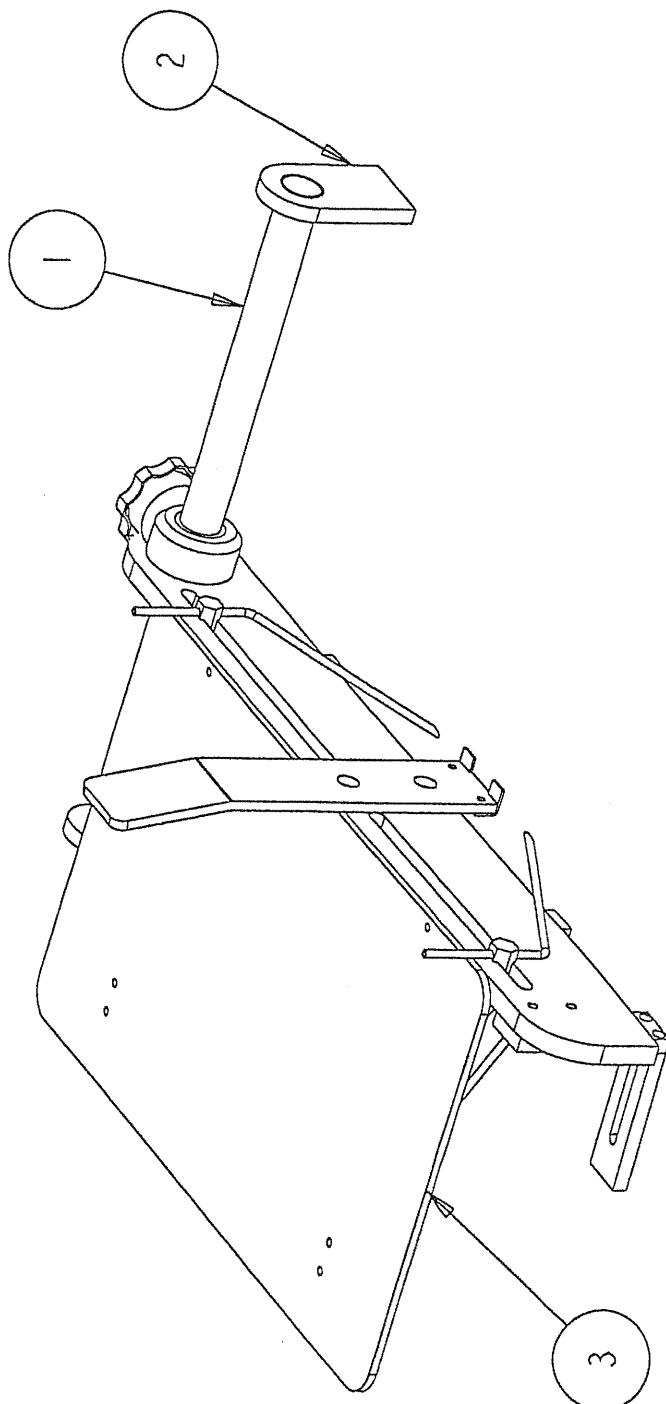
DRAWN BY:	SCALE	0 .375	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED		MATERIAL:	N/A	THIRD ANGLE PROJECTION	PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE COPIED OR REPRODUCED IN WHOLE OR IN PART, EXCEPT EXRESS WRITTEN PERMISSION OF KIRK-RUDY WOODSTOCK, GA 30188 USA	
checked by:	DATE	.01	.005	.5	HEAT TREAT:	N/A	MODEL:	KIRK-RUDY INC WOODSTOCK, GEORGIA	
TRACED BY:	MASTER	04 - Nov - 99		REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED		SHEET NO.		TITLE:	
				ALL DIMENSIONS ARE IN INCHES UNLESS NOTED DO NOT SCALE - WORK TO DIMENSIONS ONLY		10F1		ASSY , BELT DRIVE PLATE	
								DRAWING # 536178-02	

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



DRAWN BY:	T JG	SCALE	1 . 000	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	MATERIAL: NOTED	THIRD ANGLE PROJECTION	PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE COPIED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC. KENNESAW, GA 30144 USA	RECD WHERE USED
CHECKED BY:		DATE	21 - Jan - 98	.01 .005 .5	HEAT TREAT: NONE	KIRK - RUDY, INC.	KR KENNESAW, GEORGIA	
TRACED BY:	MASTER	FINISH:	M	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED ALL DIMENSIONS ARE FIRMED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY	NOTED	ASSY, ARM CRADLE FEEDER	DRAWING #	
		SHEET NO.	10F1			500729-2A		

ITEM	QTY	PART #	DESCRIPTION
1	1	500769	SHAFT - REAR GUIDE
2	2	500832	BRACKET - REAR-GUIDE
3	1	50074-A	ASSY, REAR BRIDGE

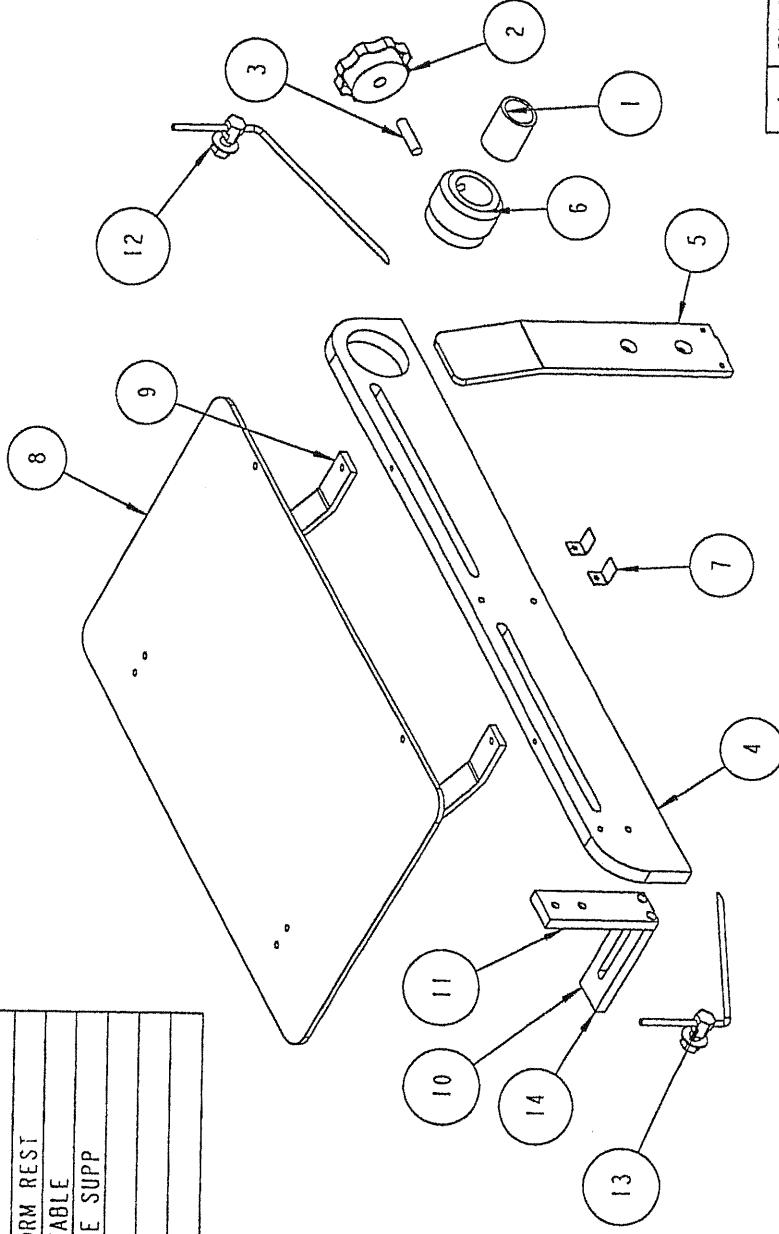


DRAWN BY:	TVK	SCALE	0 . 250	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	N / A	THIRD ANGLE PROJECTION	PROPRIETARY AND CONFIDENTIAL NO DRAWING OR SPECIFICATIONS MADE IN THIS DRAWING MAY BE COPIED, QUOTED, EXPRESSED, OR REPRODUCED IN ANY FORM, WHETHER WHOLE OR IN PART, BY WHOMSOEVER MADE, KEPT, HELD, OR USED.	RECD	WHERE USED
CHECKED BY:		DATE	J.III	AMT.	.01				
TRACED BY:		DATE	02 - Mar - 99	HEX HEAD:	N / A	MODEL:	215	NAME:	KIRK - RUDY, INC. KENNESAW, GEORGIA
MASTER				FINISH:	N / A	SHEET NO.:	10F1	DRAWING NO.:	ASSY, JOGGER TABLE
				ALL DIMENSIONS ARE FINISHED DIMENSIONS					GRANTING 1
				DO NOT SCALE - WORK TO DIMENSIONS ONLY					

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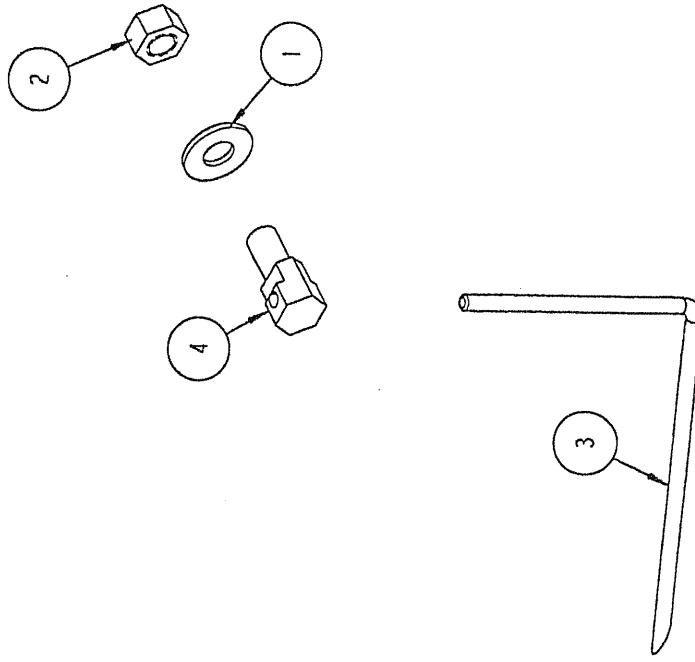
500714-A

ITEM QTY	PART #	DESCRIPTION
1	100109	BUSHING, SLI.000101.2500DI.500LG
2	102112	KNOB, PURCHASED
3	105601	SHAFT, THREADED 5/16-18
4	500714	BRIDGE - READ GUIDE
5	500715	PLATE - REAR CENTER GUIDE
6	500770	HUB - REAR GUIDE SHAFT
7	500771	CLIP-SIDE GUIDE
8	500845	TABLE, JOGGER
9	500847	BRACE, COMPUTER FORM REST
10	500878	SUPPORT - JOGGER TABLE
11	500880	BRACKET - JOG TABLE SUPP
12	500764AL	ASSY, LIFTER
13	500764AR	ASSY, LIFTER
14	500880A	ASSY, BRACKET



DRAWN BY:	N J G	SCALE	0 . 188	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	MATERIAL:	N / A	THIRD ANGLE PROJECTION	PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE QUOTED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY INC. KENNESAW, GA 30144 USA	RECD' WHERE USED
CHECKED BY:		DATE	12 - Apr - 99	.01 .005 .5 .01 .005 ANG.	HEAT TREAT:	N / A		KIRK - RUDY, INC. KENNESAW, GEORGIA	JUL 4 1999-A
TRACED BY:		MASTER	" M	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED	FINISH:	N / A	215	ASSY, REAR BRIDGE	DRAWING #
				ALL DIMENSIONS ARE IN INCHES DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY				500714-1	SHEET NO. 2 OF 1

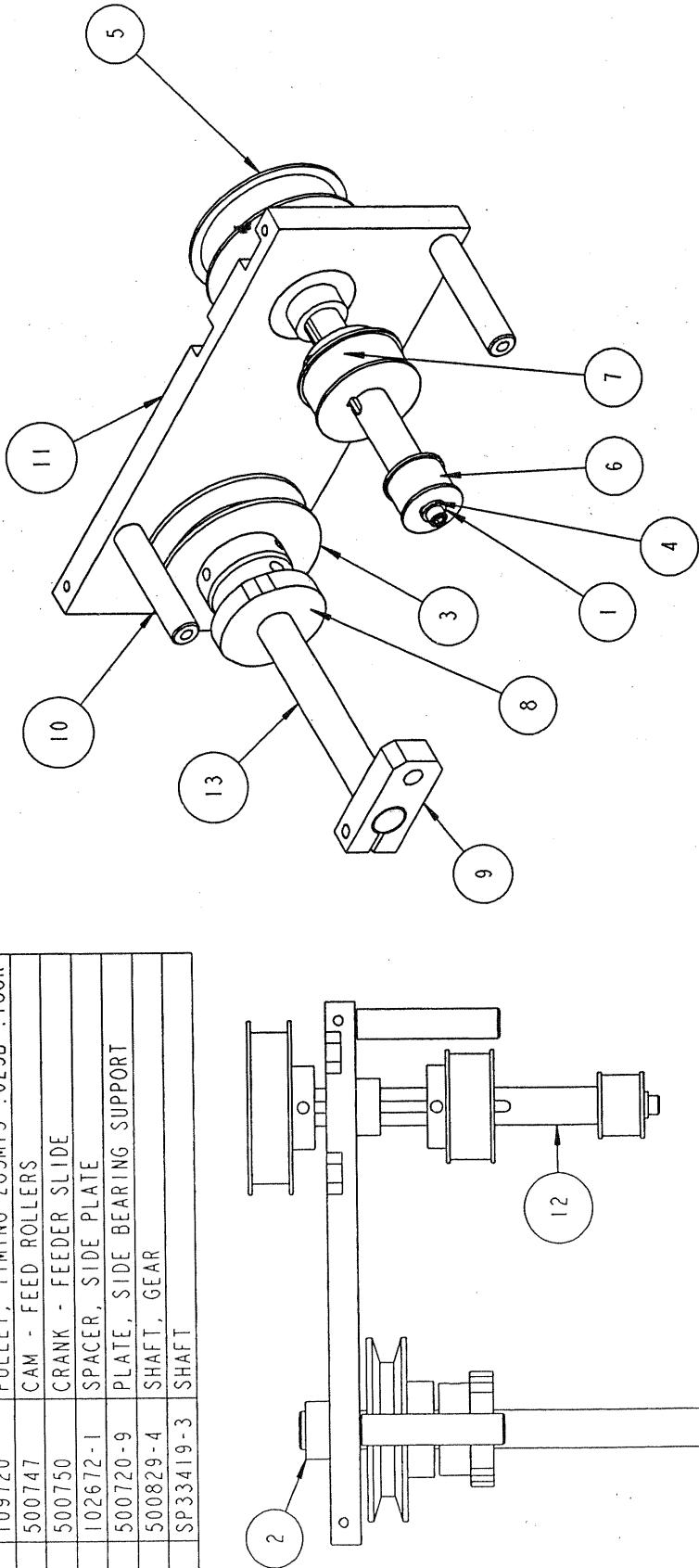
ITEM QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	1	100601					
2	1	106702					
3	1	500764			LIFTER - REAR BRIDGE		
4	1	500766			SCREW - MACHINE REAR GUIDE		



DRAWN BY:	N JG	SCALE:	0 . 500	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED		MATERIAL:	N/A	THIRD ANGLE PROJECTION	PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE QUOTED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC. KENNESAW, GA 30144 USA	KIRK - RUDY, INC.
CHECKED BY:		DATE:	23-JUL-97	.01	.005	HEAT TREAT:	N/A	VIEW:	KENNESAW, GEORGIA	
TRACED BY:	M	MASTER	"	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED		MODEL:	215	TITLE:	ASSY, LIFTER	
				ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY		SHEET NO:	10F1	DRAWING #	500764A	

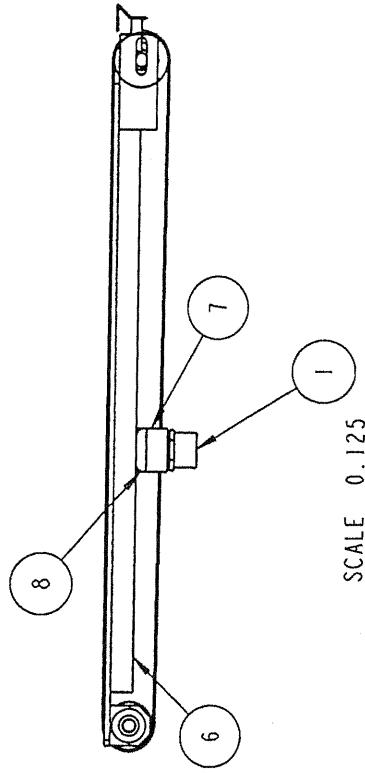
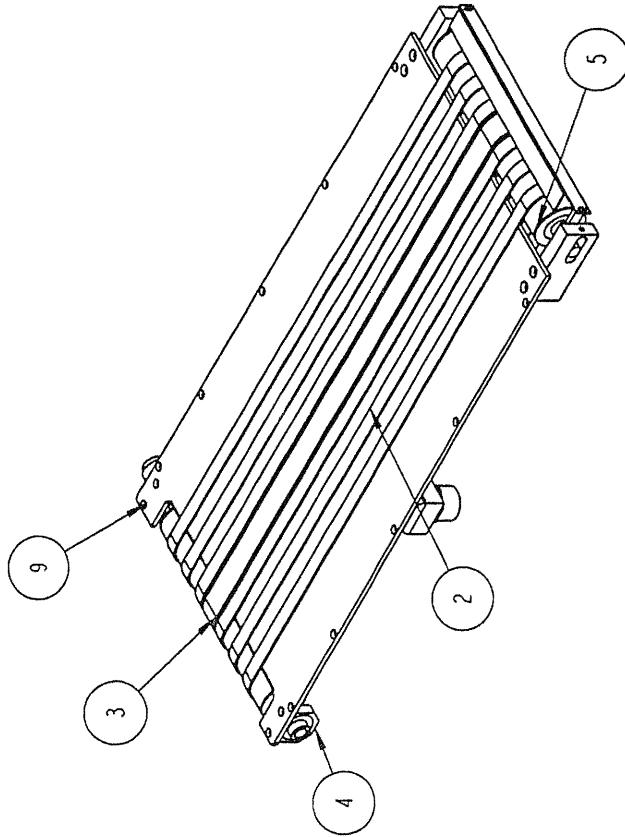
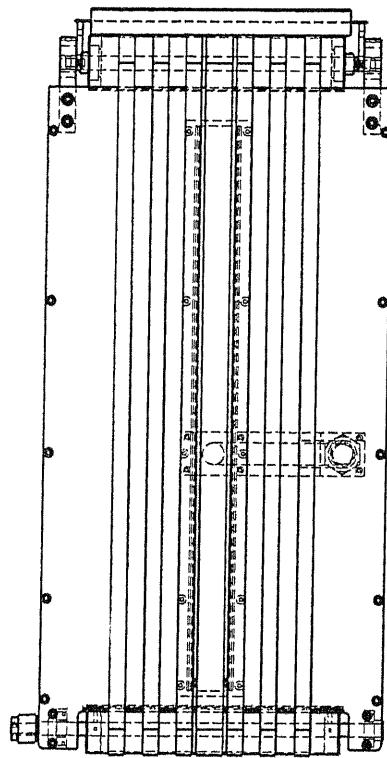
ITEM QTY	PART #	DESCRIPTION
1	1 00619	WASHER, FLAT 10-32
2	2 103804	BEARING, HUB .625
3	1 105021	V-PULLEY, AK30
4	1 107409	SCREW, SHCS 10-32X .500
5	1 108841	PULLEY, TIMING 21L050 .625B .188K
6	1 109719	PULLEY, TIMING 165M15 .375B .125K
7	1 109720	PULLEY, TIMING 285M15 .625B .188K
8	1 500747	CAM - FEED ROLLERS
9	1 500750	CRANK - FEEDER SLIDE
10	2 102672-1	SPACER, SIDE PLATE
11	1 500720-9	PLATE, SIDE BEARING SUPPORT
12	1 500829-4	SHAFT, GEAR
13	1 SP33419-3	SHAFT

ITEM	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	1	3/22/2000	REPLACED 500720 W/500720-9 REPLACE FLAT BRG W/HUB BRG.	6537	TJG
2	2	8/22/2005	REPLACED WASHER 5317683-01 WITH 100619	1258	CMC



DRAWN BY:	SCALE	0 . 375	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	MATERIAL:	N / A	THIRD ANGLE PROJECTION	PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE QUOTED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC. WOODSTOCK, GA 30188 USA	KIRK - RUDY, INC WOODSTOCK, GEORGIA
CHECKED BY:	DATE	.11	.005	ANG.	.5	HEAT TREAT:	N / A	ASSY , BELT DRIVE PLATE
TRACED BY:	MASTER	04 - Nov - 99	REMOVED ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED	FINISH:	N / A	SHEET NO.	OF 1	536178-02
			ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY					

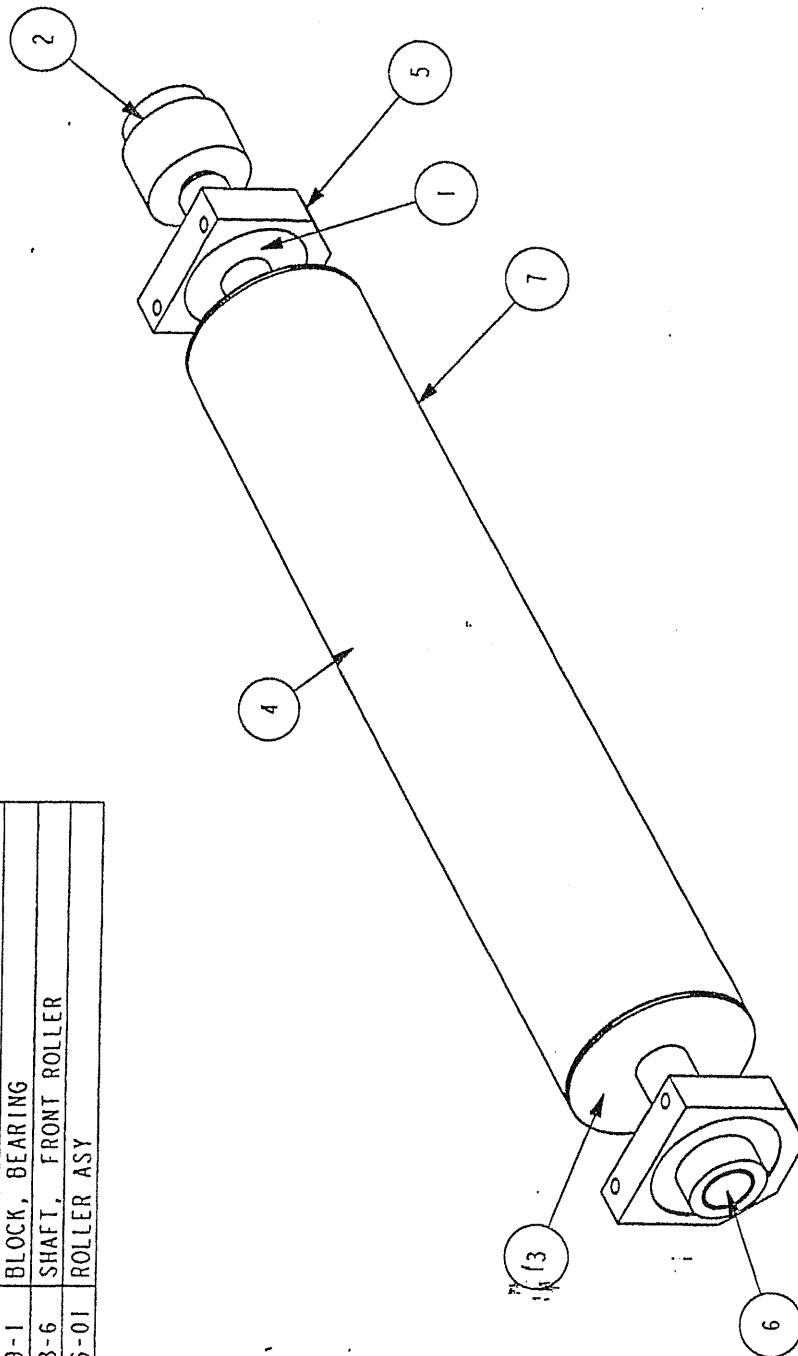
ITEM QTY	PART #	DESCRIPTION
1	190715	PVC COUPLING
2	6 105901-7	BELT, GREEN .75 X 68.75
3	1 106202-6	BELT, GREEN 1.25 X 68.75
4	1 531274-02	ASSY, ROLLER BELT DRIVE
5	1 533876-02	ASSY, IDLER ROLLER
6	1 SP30202	BLOCK, VACUUM
7	1 SP28217-1	BLOCK, LOWER VACUUM
8	1 SP28218-1	BLOCK, UPPER VACUUM
9	1 SP30201-1	TABLETOP 30.5 IN EXT. CENTER VACUUM



DRAWN BY:	T JG	SCALE	0 . 125	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED		MATERIAL:	N / A	THIRD ANGLE PROJECTION	PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE QUOTED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC. KENNESAW, GA 30144 USA
CHECKED BY:		DATE	17-Jan-00	.01	.005	ANG.	.5	HEAT TREAT:	N / A
TRACED BY:	M	MASTER		REMOVE ALL BURS AND SHARP EDGES UNLESS OTHERWISE NOTED		ALL DIMENSIONS ARE FINISHED DIMENSIONS		TITLE: SP81400 SHEET NO.: 10F1 DRAWING #: 536468-02	
ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY									

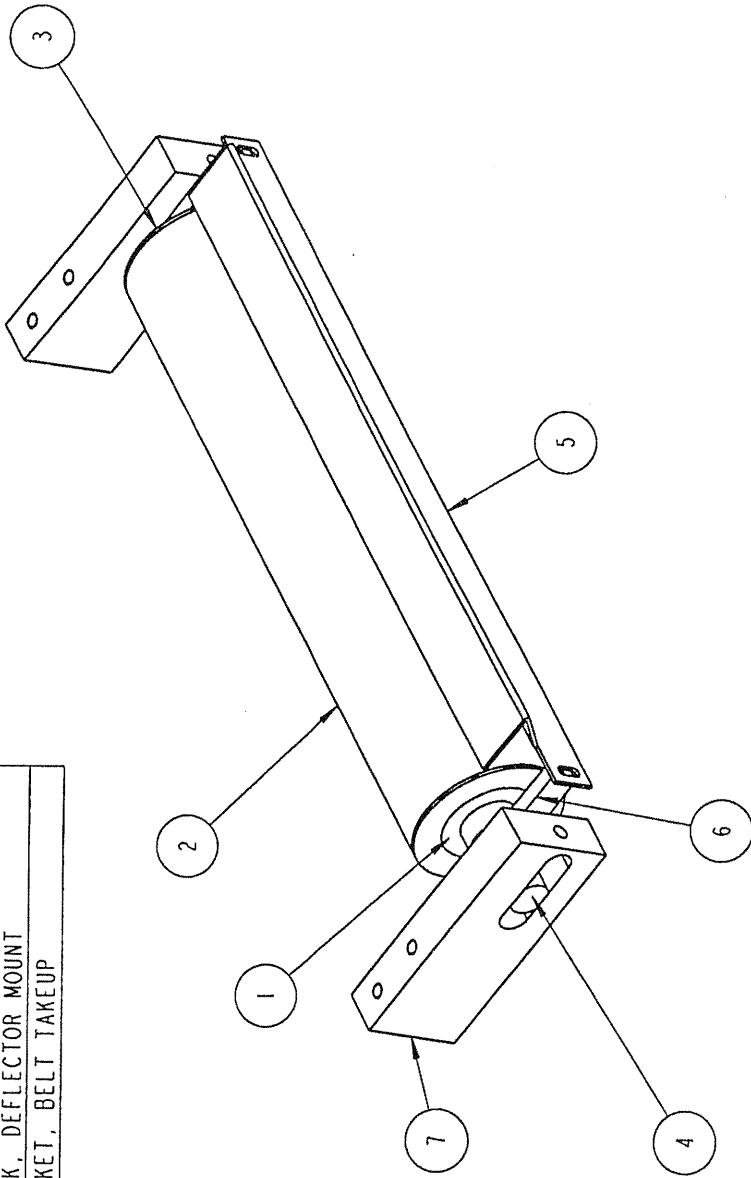
ITEM	QTY	PART #	DESCRIPTION
1	2	103804	BEARING, HUB .625
2	1	109721	PULLEY, TIMING 215M15 .5000B .125K
3	2	500839	HUB-BELT DRIVE
4	1	500742-4	ROLLER - TUBE BELT DRIVE
5	2	500819-1	BLOCK, BEARING
6	1	500828-6	SHAFT, FRONT ROLLER
7	1	530676-01	ROLLER ASY

REV NO	DATE	DESCRIPTION	TCK NO	BT
1	11-JAN-00	REPLACED 500828-5 WITH 500828-6	6514	TG



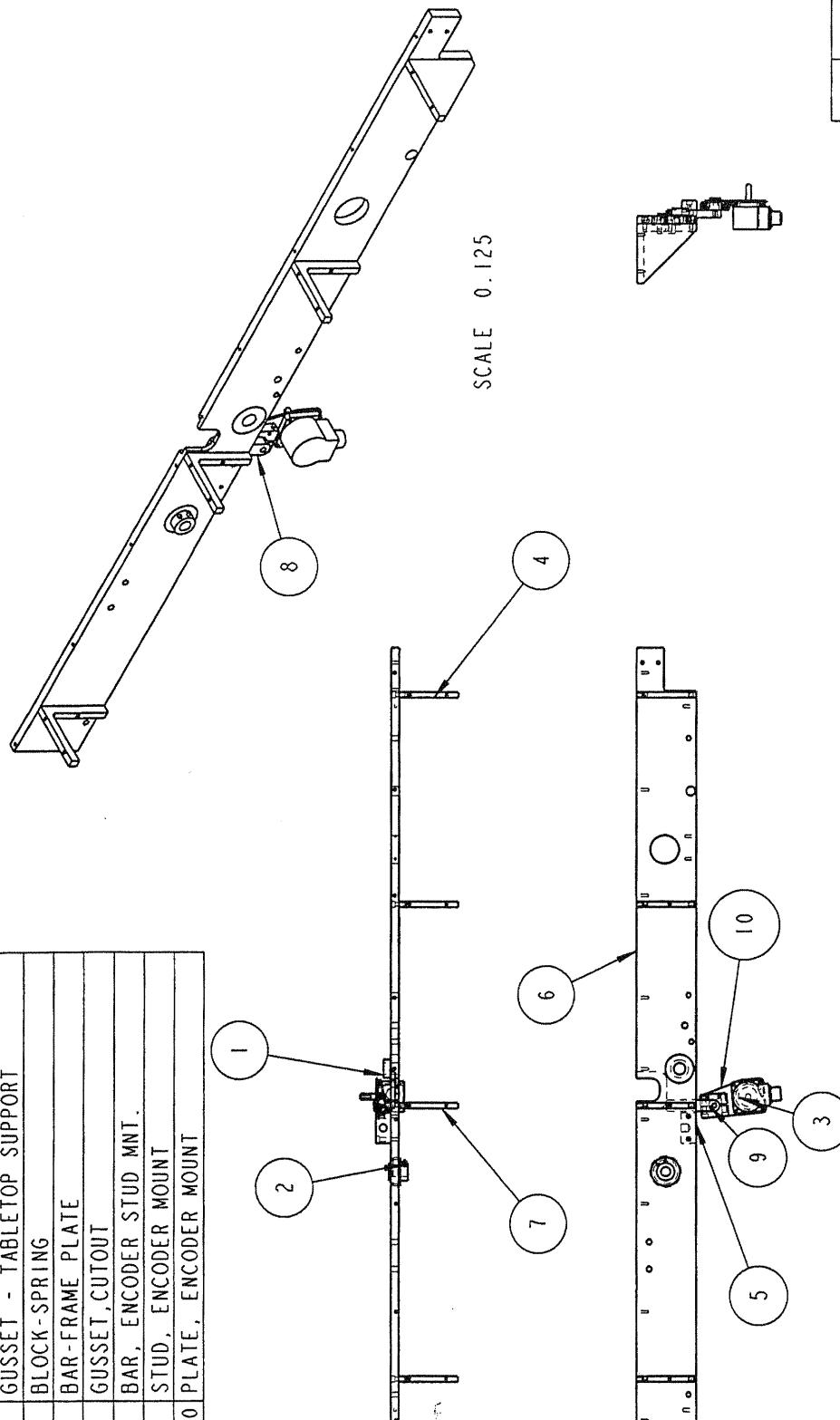
1	2151J
REQ'D	WHERE USED
 KIRK - RUDY, INC. KENNEBUNK, GEORGIA Model: SP79000 Date: 04-Nov-99	
Title: ASSY, ROLLER BELT DRIVE	
Sheet No: 1 Of 1	Drawing # 531274-02
DRAWN BY: T JG CHECKED BY: TRACED BY: M	
SCALE: 0 .500 MATERIAL: N/A DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED .01 .005 .5 .005 ANG.	
HEAT TREAT: N/A REMOVE ALL BURRS AND SHARP EDGES, UNLESS OTHERWISE NOTED ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY	

ITEM QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BT
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					



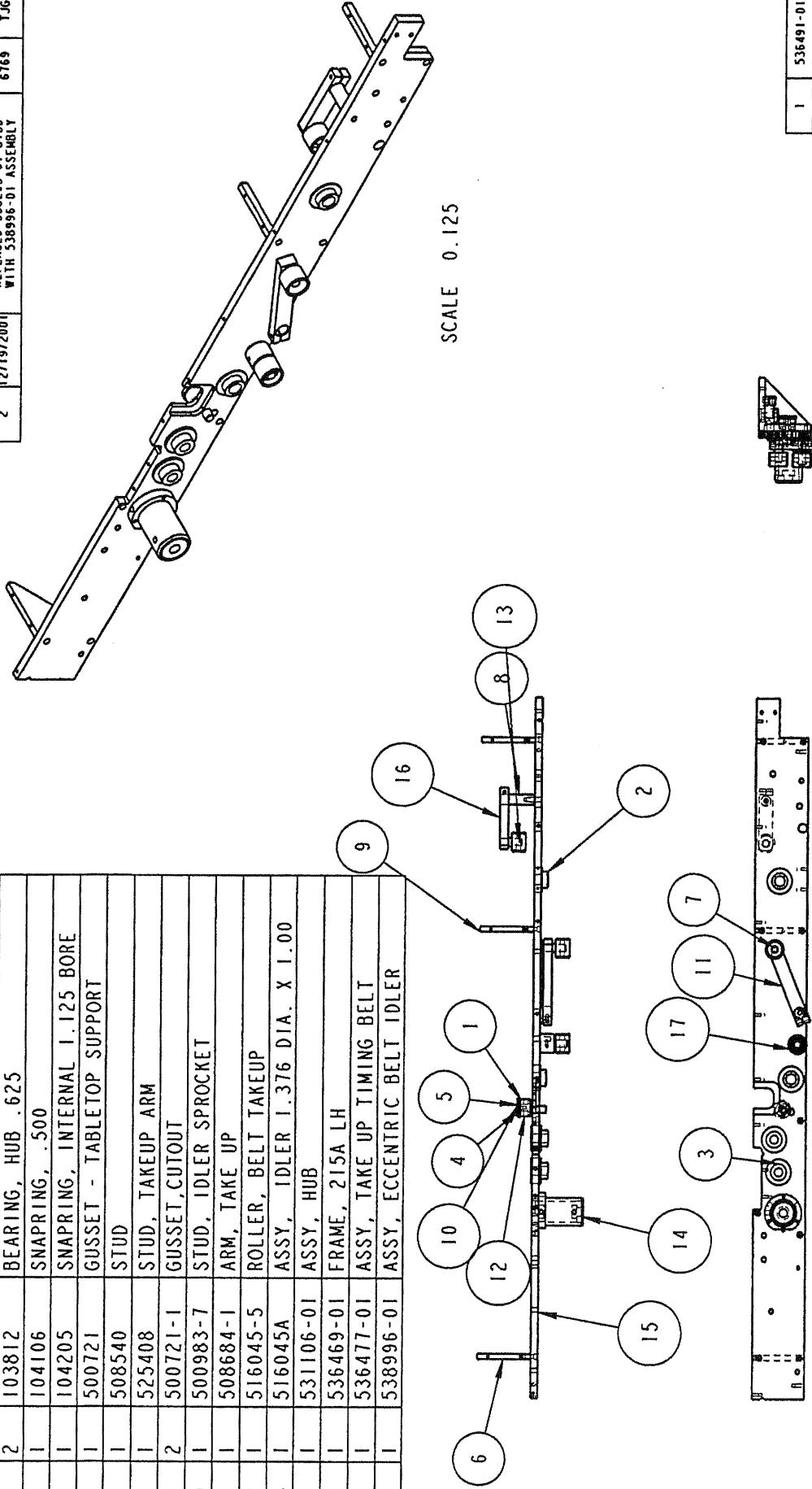
1	536468-02
REQ'D	WHERE USED
KRK KIRK-RUDY, INC.	
KR KENNESEE, GEORGIA	
PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE COPIED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC. KENNESEE, GA 30144 USA	
DRAWN BY: T JG	SCALE: 0 . 375
CHECKED BY:	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED
TRACED BY:	MATERIAL: NOTED
	THIRD ANGLE PROJECTION
	DATE: 28-Feb-00
	.xx .xxx .005 .01 .5
	HEAT TREAT:
	FINISH: M
	NOTE: REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY
	NOTE: SP 81400
	SHEET NO.: 10F1
	DRAWING #: ASSY, IDLER ROLLER
	533876-02

ITEM QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	1	103805 BEARING, HUB .750	1	1/1/2002	REPLACED ENCODER MOUNT WITH SP45241-10	6774	TJG
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	SP45241-10 PLATE, ENCODER MOUNT					



DRAWN BY:	TJG	SCALE	0.094	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	XXX	THIRD ANGLE PROJECTION	PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE QUOTED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC. KENNESAW, GA 30144 USA
CHECKED BY:		DATE	27-Aug-99	.XX	XXX	HEAT TREAT:	
TRACED BY:				.01	.005	.5	
		MASTER		REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED	XXX	NOTE:	KIRK - RUDY, INC. KENNESAW, GEORGIA
				ALL DIMENSIONS ARE FINISHED DIMENSIONS		SHEET NO:	536475-01
				DO NOT SCALE - WORK TO DIMENSIONS ONLY		DRAWING NO:	536475-01

ITEM QTY	PART #	DESCRIPTION
1	2 103108	BEARING, FLAT .500
2	2 103805	BEARING, HUB .750
3	2 103812	BEARING, HUB .625
4	1 104106	SNAPRING, .500
5	1 104205	SNAPRING, INTERNAL .125 BORE
6	1 500721	GUSSET - TABLETOP SUPPORT
7	1 508540	STUD
8	1 525408	STUD, TAKEUP ARM
9	2 500721-1	GUSSET, CUTOUT
10	1 500983-7	STUD, IDLER SPROCKET
11	1 508684-1	ARM, TAKE UP
12	1 516045-5	ROLLER, BELT TAKEUP
13	1 516045A	ASSY, IDLER 1.376 DIA. X 1.00
14	1 531106-01	ASSY, HUB
15	1 536469-01	FRAME, 215A LH
16	1 536477-01	ASSY, TAKE UP TIMING BELT
17	1 538996-01	ASSY, ECCENTRIC BELT IDLER



DRAWN BY:	SCALE	MASTER	ITEM NO.	REV'D
T JG	0.094		536476-01	WHERE USED
CHECKED BY:	DATE			
	27-Aug-99			
TRACED BY:				

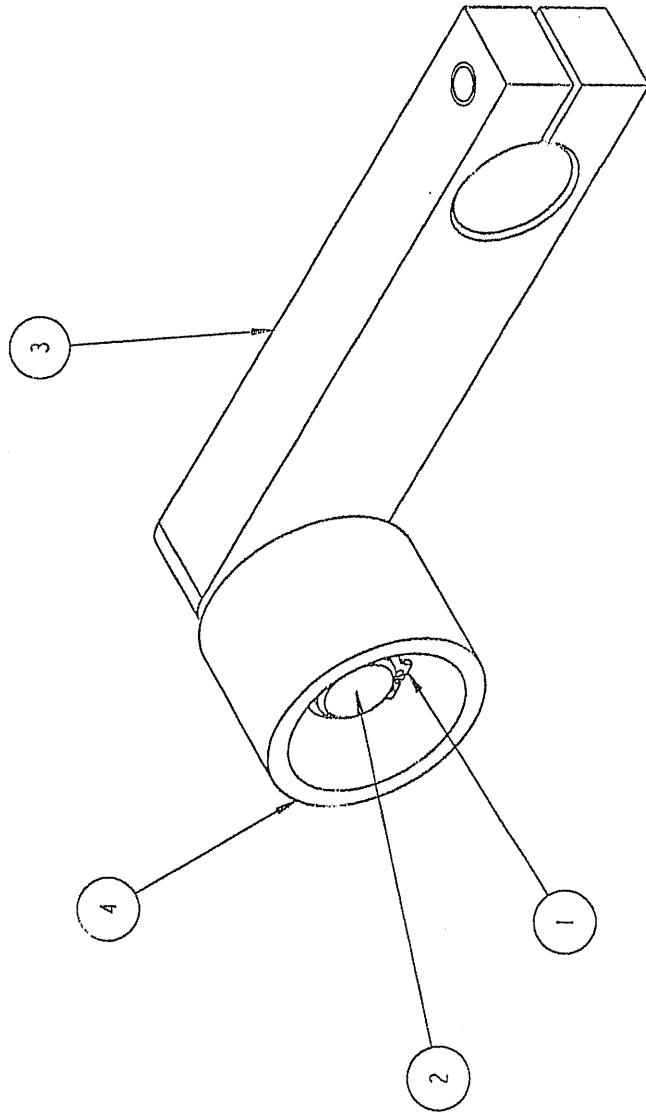
DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED		MATERIAL: XXX		THIRD ANGLE PROJECTION	PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE QUOTED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC. KENNESAW, GA. 30044 USA	
.01	.005	.005	.5	HEAT TREAT:	SP76500	TITLE:
				XXX		DRAWING #
				XXX		536476-01
				XXX		

REMOVED ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED
ALL DIMENSIONS ARE IN INCHES
DO NOT SCALE - WORK TO DIMENSIONS ONLY

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

ITEM NO:	REV NO:	DATE:	DESCRIPTION	ECN NO:	BT
JLG		1.000	SCALE		
CHECKED BY:		DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED		MATERIAL:	THIRD ANGLE PROJECTION
		.01	.005	N/A	NO PORTION OF THIS DRAWING MAY BE QUOTED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC. KENNESAW, GEORGIA
TRACED BY:		DATE: 28-JUL-99		HEAT TREAT:	MODEL: 215
				FINISH:	SHEET NO.: 10F1
				FINISH:	DRAWING #: 531106-01
				ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY	

ITEM QTY	PART #	DESCRIPTION
1	104106	SNAPRING, .500
2	508540	STUD
3	508684-2	ARM, TAKE UP
4	5116045A	ASSY. IDLER 1.376 DIA. X 1.00 IN



1	536476-01
RECD	WHERE USED
KIRK - RUDY, INC. KENNESAW, GEORGIA	
	
PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE COPIED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC. KENNESAW, GA. 30144 USA	
THIRD ANGLE PROJECTION	TIME:
	
MATERIAL: XXX	MODEL: SP76500
DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	SHEET NO. 10F1
.01 .005 .005 .01 .005 .005	DRAWING #
REMAINS: REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED	
FINISH: ALL DIMENSIONS ARE FINISHED DIMENSIONS	
MASTER M	
DO NOT SCALE - WORK TO DIMENSIONS ONLY	

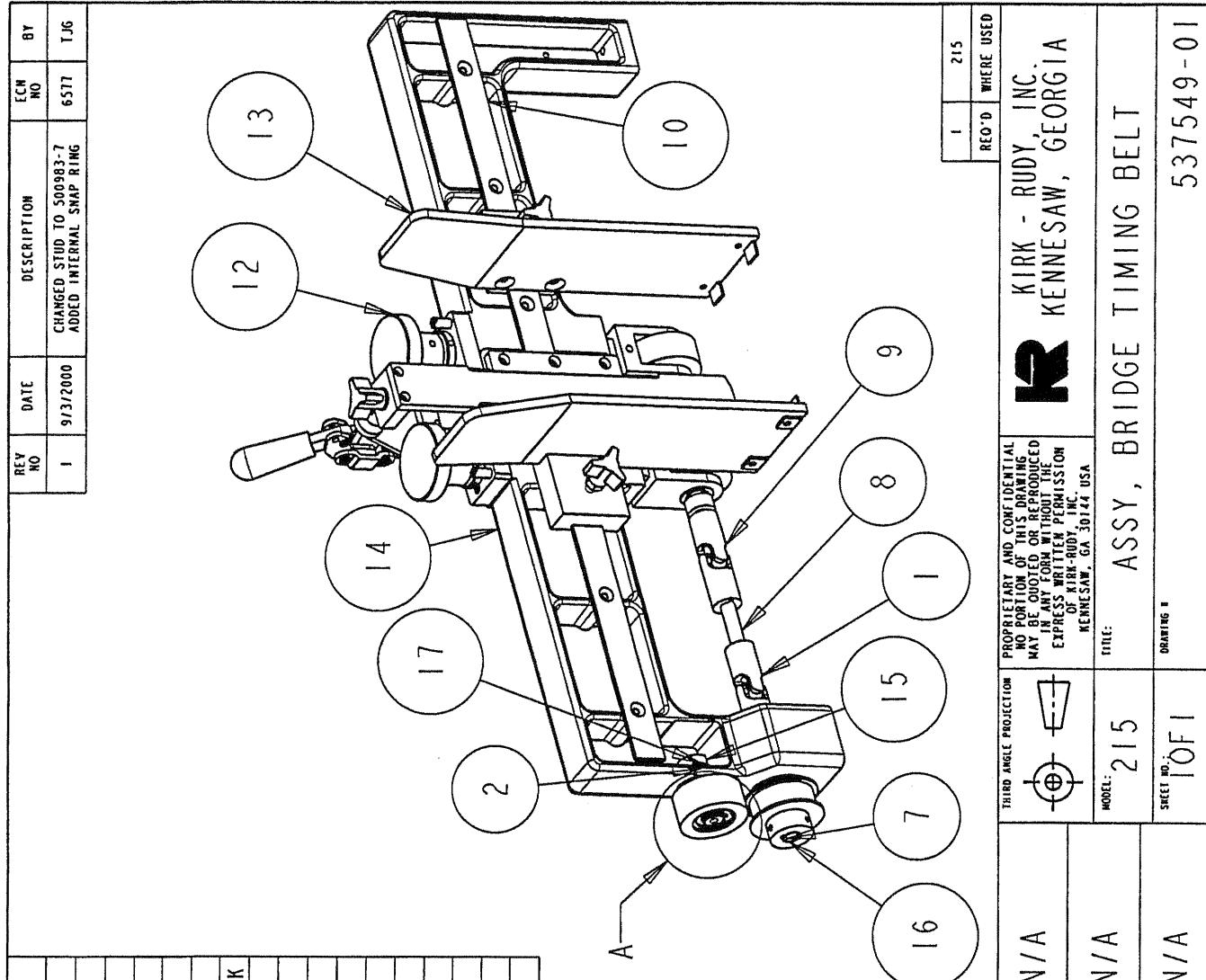
DRAWN BY: T JG SCALE: 1 .000 DATE: 01 - Sep - 99

CHECKED BY: TRACED BY: M

ASSY, TAKE UP TIMING BELT

536477-01

ITEM QTY	PART #	DESCRIPTION
1	100800	ASSY, UNIVERSAL JOINT
2	102302	SHIM, .500X.750X.062
3	2 103108	BEARING, FLAT .500
4	1 104106	SMAUTING, .500
5	1 104205	SMAUTING, 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 HNO14	
16	1 SP43307	SHAFT, UPPER FEED ROLLER
17	1 WHS013	LOCK WASHER



REV NO	DATE	DESCRIPTION	ECN NO	BY
1	9/3/2000	CHANGED STUD TO 500983-7 ADDED INTERNAL SNAP RING	6517	TJG

REF'D	WHERE USED
1	215

KRK
KIRK - RUDY, INC.
KENNESAW, GEORGIA

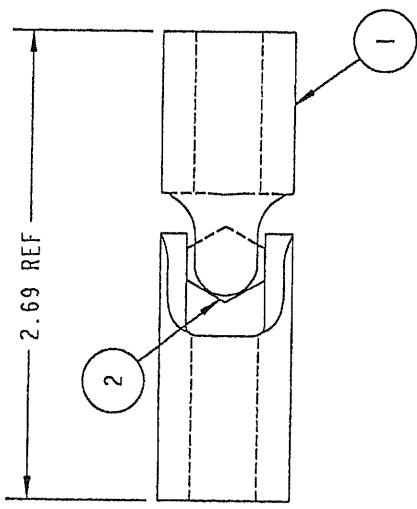
PROPRIETARY AND CONFIDENTIAL		NO PORTION OF THIS DRAWING	
		MAY BE QUOTED OR REPRODUCED	
		IN ANY FORM WITHOUT THE	
		EXPRESS WRITTEN PERMISSION	
OF KIRK-RUDY, INC.		KENNESAW, GA 30144 USA	
Print:		215	
Model:		SHEET NO 10F1	
Drawing #		537549-01	

A KEY	SCALE	MATERIAL:	THIRD ANGLE PROJECTION	PROPRIETARY AND CONFIDENTIAL
	0 .250	N/A		NO PORTION OF THIS DRAWING
CHECKED BY:	DATE	.01 -.005 .5	REMOVED ALL BURRS AND	MAY BE QUOTED OR REPRODUCED
	01-0c†-99		SHARP EDGES UNLESS	IN ANY FORM WITHOUT THE
TRACED BY:	MASTER		OTHERWISE NOTED	EXPRESS WRITTEN PERMISSION
			ALL DIMENSIONS ARE	OF KIRK-RUDY, INC.
			SHOWN DIMENSIONS	KENNESAW, GA 30144 USA
			DO NOT SCALE - WORK	
			TO DIMENSIONS ONLY	

DRAWING 1

100800

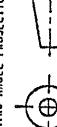
ITEM	QTY	PART #	DESCRIPTION
1	2	100800_1	UNIVERSAL
2	1	100800_3	BLOCK, PIN



REV NO	DATE	DESCRIPTION	ECN NO	BY
I	2-11-98	RE-DRAWN IN PRO-E	6254	HJG

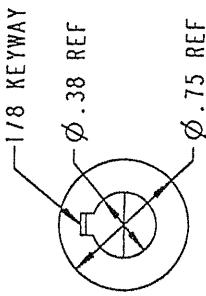
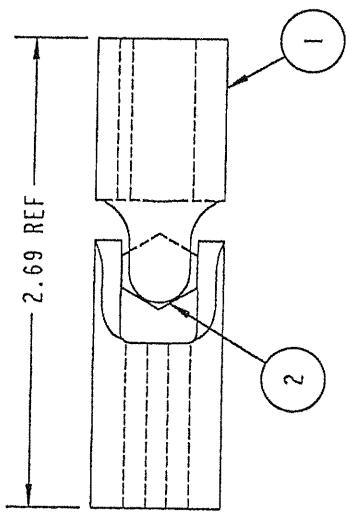
I	531679-01
I	500704-A

REF'D WHERE USED
 KIRK - RUDY, INC.
 KENNEBUNK, GEORGIA

DRAWN BY:	SCALE	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	MATERIAL: PURCHASED	THIRD ANGLE PROJECTION	PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE QUOTED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC. KENNEBUNK, GA 30444 USA.
CHICAGO BT:	DATE	.XX .XXX .005 .5	HEAT TREAT: N/A		 KIRK - RUDY, INC.  KENNEBUNK, GEORGIA
TRACED BY:	MASTER	REMOVED ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE WORK TO DIMENSIONS ONLY	FINISH: N/A	SCALE: 10F1	TIME: DRAWING #
					100800

REV NO	DATE	DESCRIPTION	ECN NO	BY
1	2-1-98	RE-DRAWN IN PROFILE	6254	MJC

ITEM QTY	PART #	DESCRIPTION
1	2	100800_1_1 UNIVERSAL
2	1	100800_3 BLOCK, PIN



Φ. 75 REF

118 VERVUL

DRAWING # 1000800-1

1-00800

DRAWN BY:	SCALE	.000	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED			MATERIAL: PURCHASED	THIRD ANGLE PROJECTION	PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE QUOTED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY INC. KENNESAW, GA 30144 USA	REQ'D WHERE USED	
CHECKED BY:	DATE	.xx	xxx	ANG.	.01	.005	.5	HEAT TREAT:	N/A	
TRACED BY:	MASTER	31 - JUL - 79			REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED			MODEL:	215	
						ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE ~ WORK TO DIMENSIONS ONLY			NAME:	N/A
									SKETCH NO.:	10F1
									DRAWING NO.:	ASSY, UNIVERSAL JOINT
									100800-1	

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

DRAWN BY:	MY	SCALE	1 . 000	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED		MATERIAL:	N/A	THIRD ANGLE PROJECTION	PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE ODED OR REPRODUCED IN ANY FORM WITHOUT EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC. KENNESAW, GA 3044 USA
CHECKED BY:		DATE	12-Apr-99	.01	.005	HEAT TREAT:	N/A		
TRACED BY:		MASTER	M	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED		MODEL:	215	TIME:	ASSY, SIDE GUIDE RAIL
				ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY		SHEET NO:	10F1	DRAWING #	500814-1A

ITEM #		PART #	DESCRIPTION	KEY NO	DATE	DESCRIPTION	CCW RD	RF
1	2	100400	THRUST WASHER					
2	1	100402	THRUST WASHER					
3	2	100409	THRUST WASHER					
4	2	101100	ONE WAY BEARING					
5	1	102114	KNOB					
6	1	102117	KNOB					
7	1	102225	COLLAR					
8	1	102345	SHIM					
9	2	102701	SPRING					
10	4	103106	BEARING - FLAT					
11	2	104400	BOLT - HEX HEAD					
12	1	190600	SPIDER - ROLLER DRIVE					
13	1	190605	LEVER - QUICK RELEASE					
14	1	500730	PLATE, GATE FEEDER					
15	1	500743	SHAFT - TOP ROLLER DRIVE					
16	1	500744	SHAFT - TOP ROLLER ASSY					
17	2	500745	ROLLER - IDLER					
18	1	500795	PLATE - BACK					
19	2	500805	PLATE - HOLD DOWN					
20	1	500806	PLATE - GATE END					
21	2	500807	NUT - LOCK					
22	1	500808	PLATE - TOP BRIDGE					
23	2	500809	SLEEVE - THREADED					
24	1	500810	SHAFT - SCREW ADJ					
25	2	500811	FORK ASY					
26	2	500812	KNOB, ROLLER ADJUSTMENT					
27	2	500839	SPACER					
28	1	102114A	ROUND KNOB ASY					
29	1	102200-2	COLLAR					
30	1	500743-2	SHAFT - TOP ROLLER					
31	2	500744-5	COLLAR - TOP ROLLER SHAFT					
32	1	500744-6	SHAFT - TOP ROLLER					
33	2	500745A	UPPER FEED ROLLER ASY					
34	1	500199-5	BLOCK, CLAMP SUPPORT					
35	2	500199-6	SLID, BRIDGE (LONG)					
36	2	500199-7	STUD, BRIDGE (SHORT)					
37	1	500199-2	BLOCK - CONNECTOR					
38	1	500199-3	CLAMP - MOUNTING PLATE					
39	2	500811A	FORK ASY WITH BEARINGS					
40	1	531582-01	LG BRIDGE DRIVE AND GATE ASY					
41	2	531584-01	LG FORK ASY					
42	2	531672-01	BAR, FORK					
43	2	531673-01	TOKE					
44	1	RHH051						
45	1	RHD081						
46	1	SYA590						
47	1	WH5010						
48	1	WH5011						

SHEET NO. 8
 DRAWN BY: J. COOPER
 CHECKED BY: J. COOPER
 APPROVED BY: J. COOPER
 DATE: 23-Sep-97
 REVISIONS: 0
 PAGE NO. 1
 TOTAL PAGES 1

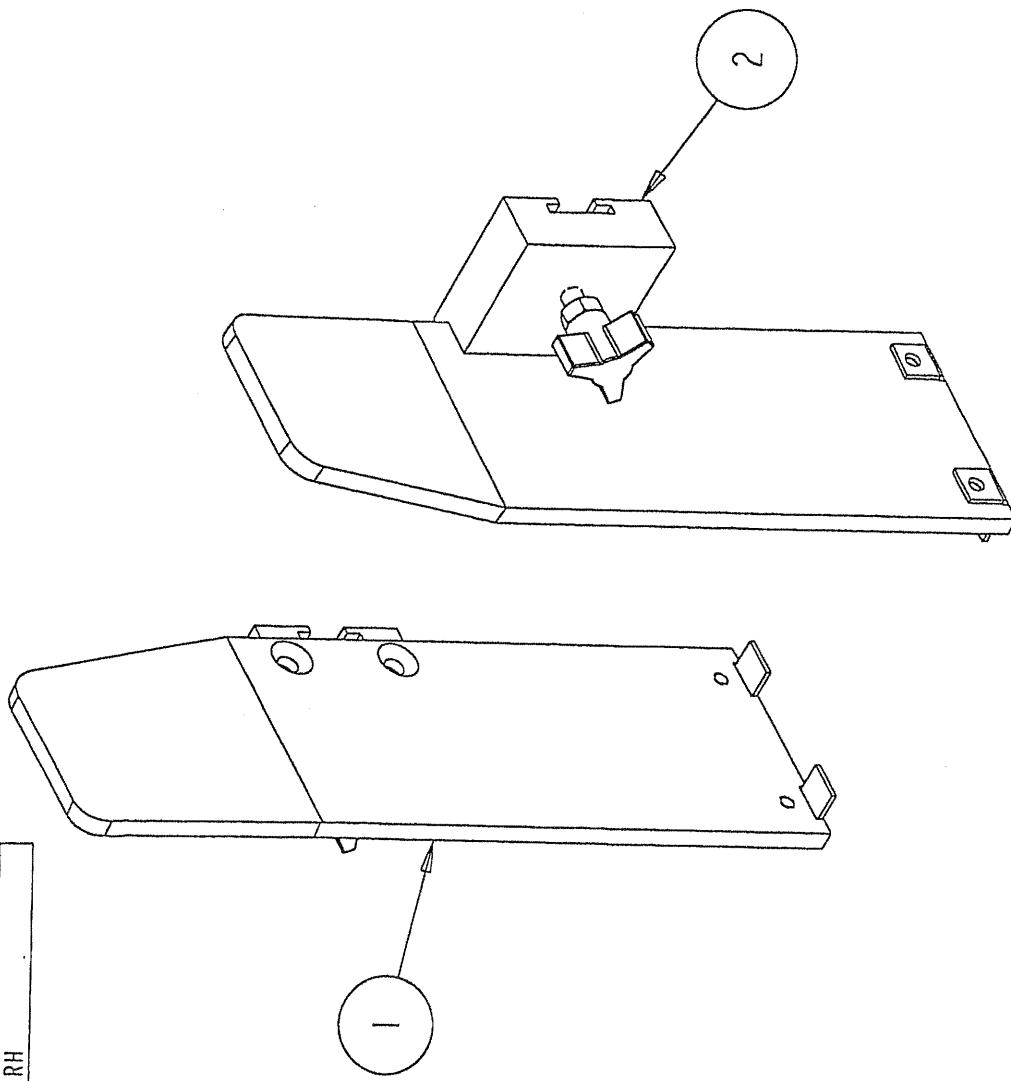
ECG'S WHICH USED
 KIRK - RUDY, INC.
 KENNESAW, GEORGIA

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 OR OTHERWISE MADE AVAILABLE
 TO OTHERS, WITHOUT THE
 WRITTEN CONSENT OF KIRK-RUDY,
 INC., KENNESAW, GA 30050

NAME: LG BRIDGE DRIVE AND GATE ASY
 DATE: 01
 PAGE NO. 1
 TOTAL PAGES 1

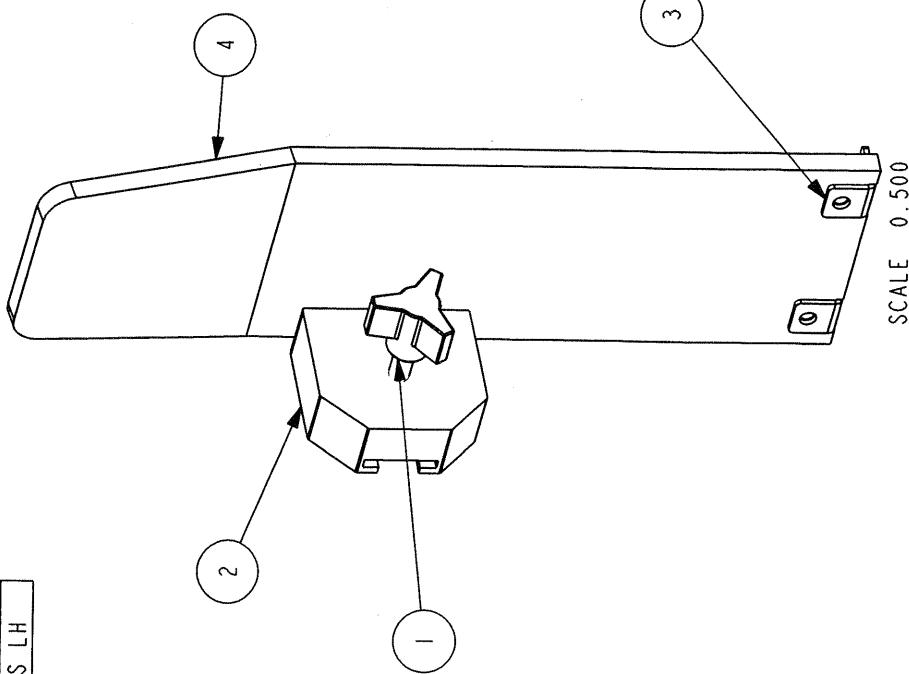
SHEET NO. 1
 DRAWN BY: J. COOPER
 CHECKED BY: J. COOPER
 APPROVED BY: J. COOPER
 DATE: 23-Sep-97
 REVISIONS: 0
 PAGE NO. 1
 TOTAL PAGES 1

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



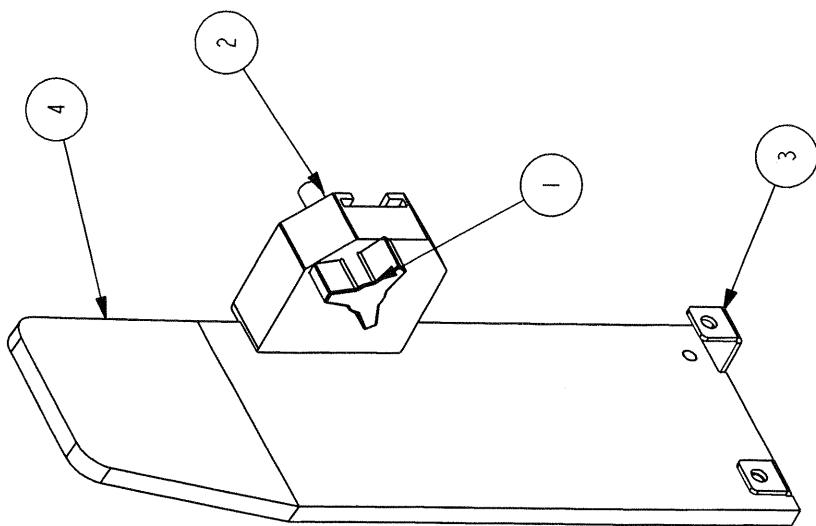
DRAWN BY:	SCALE	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED			MATERIAL:	THIRD ANGLE PROJECTION	PROPRIETARY AND CONFIDENTIAL NO FOR ION OF THIS DRAWING MA BE QUOTED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC. KENNESAW, GA 30144 USA	REQ'D WHERE USED
TVK	0 . 500	.01	.005	.5	N/A			535411-01
CHECKED BY:	DATE	.1X	.005	.5	HEAT TREAT:		KIRK - RUDY, INC., KENNESAW, GEORGIA	
TRACED BY:	MASTER	02 - M41 - 99			N/A		ASSY, SIDE GUIDE	
					MASTER		215	
					FINISH:		SHEET NO.: 0F1	DRAWING #
								535412-01

ITEM QTY	PART #	DESCRIPTION
1	102144	KNOB 3-ARM, 1/4-20 X 1" STUD
2	1 500755	CLAMP - SIDE GUIDE
3	2 500771	CLIP-SIDE GUIDE
4	1 500788-18L	SIDEGUIDE, FEEDER W/ ROLLERS LH



DRAWN BY:	SCALE	MATERIAL:	THIRD ANGLE PROJECTION	PROPRIETARY AND CONFIDENTIAL
MY	0 . 500	N / A	-	NO PORTION OF THIS DRAWING MAY BE QUOTED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC.
CHECKED BY:	DATE	xx	xx	WOODSTOCK, GEORGIA
	12 - Apr - 99	.01	.005	WOODSTOCK, GA 30188 USA
TRACED BY:	MASTER	ANG.	HEAT TREAT:	TITLE:
	M		N / A	215 ASSY, SIDE GUIDE LH
			FINISH:	SHEET NO. 1 OF 1 DRAWING #
			N / A	500755AL

ITEM	QTY	PART #	DESCRIPTION
1	1	102144	KNOB 3-ARM, 1/4-20 X 1" STUD
2	1	500755	CLAMP - SIDE GUIDE
3	2	500771	CLIP-SIDE GUIDE
4	1	500788-18R	SIDEGUIDE, FEEDER W/ROLLERS RH

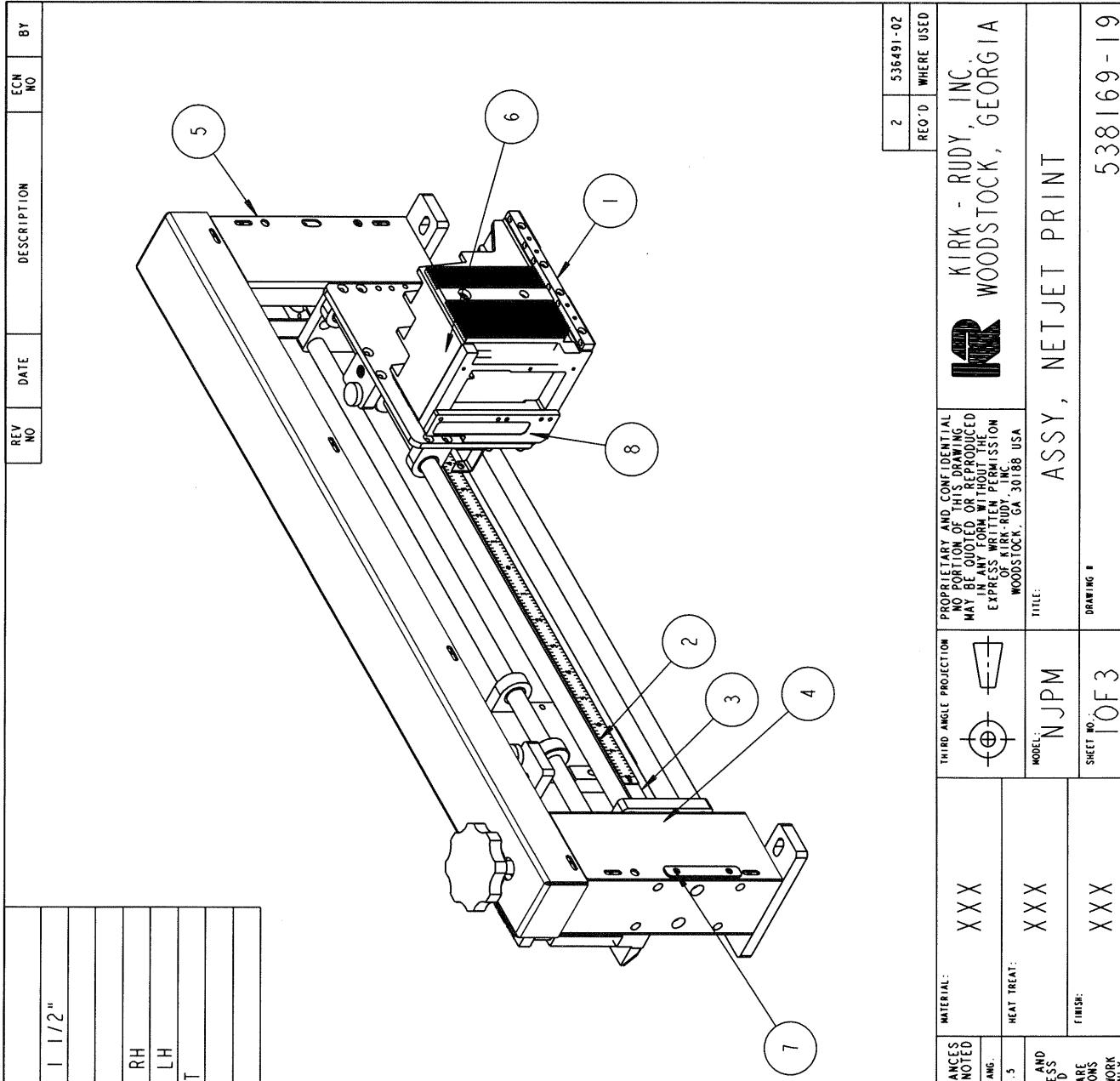


REV NO	DATE	DESCRIPTION	ECN NO	BY
1	535412-01			

RECD	WHERE USED
1	535412-01

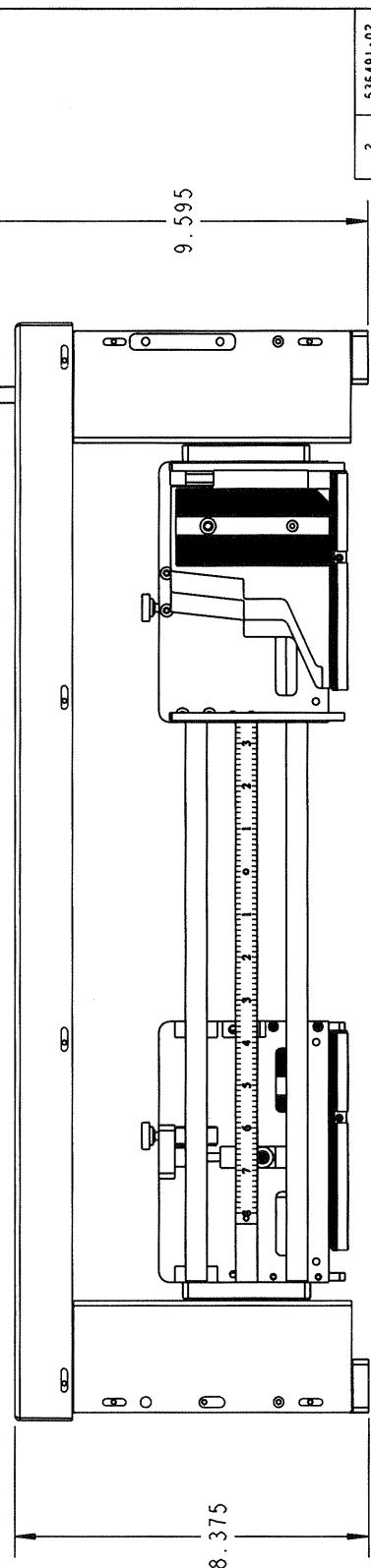
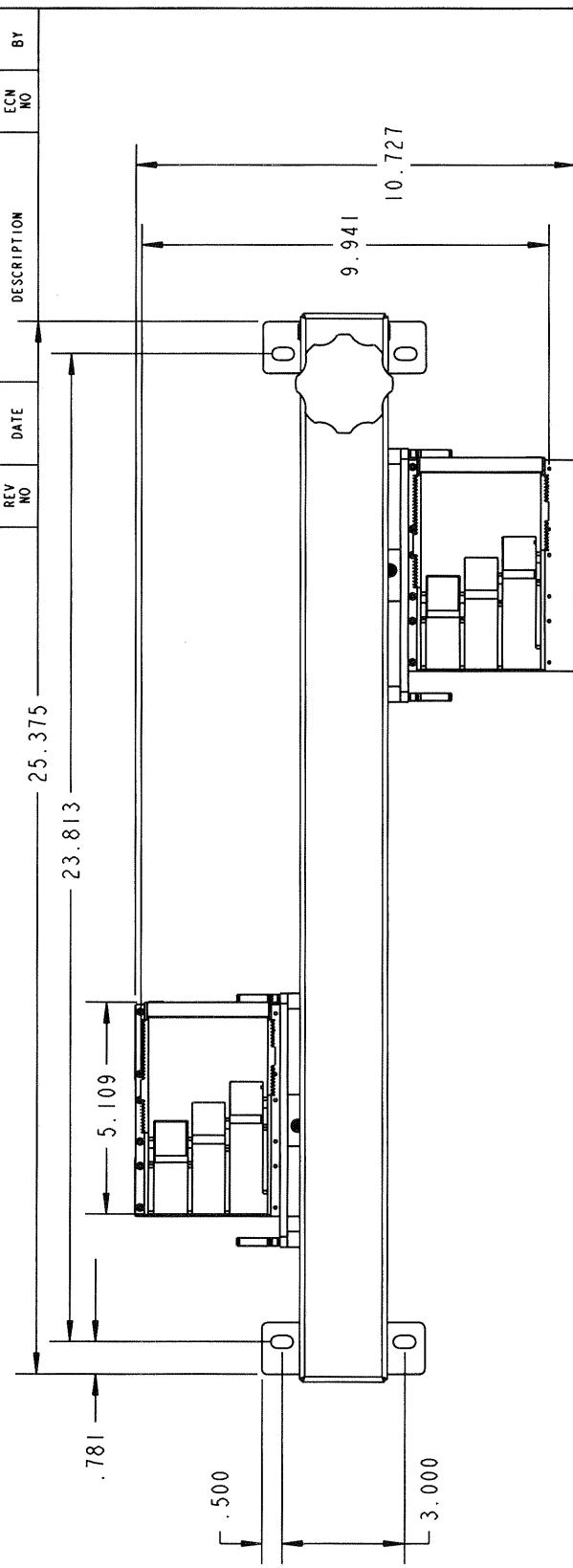
DRAWN BY:	SCALE	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	MATERIAL:	THIRD ANGLE PROJECTION	PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE OBTAINED OR REPRODUCED IN WHOLE OR IN PART WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY INC. WOODSTOCK, GA 30888 USA
MY	0 . 500	.000 -.000 ANG.	N / A		
CHECKED BY:	DATE	.01 .005 .5	HEAT TREAT:		KIRK - RUDY, INC. WOODSTOCK, GEORGIA
TRACED BY:	MASTER	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY	N / A		TITLE: ASSY, SIDE GUIDE RH SHEET NO. 10F1 DRAWING # 500755AR

ITEM	QTY	PART #	DESCRIPTION
1	2	3453	NETJET PRINT MODULE 1 1/2"
2	2	190771	SCALE, CENTER ZERO
3	1	531678-02	BAR, SCALE SUPPORT
4	1	538153-01	ASSY, VERTICAL ADJ. RH
5	1	538153-02	ASSY, VERTICAL ADJ. LH
6	4	538168-01	SHAFT, HEAD SUPPORT
7	2	538178-01	STRAP, RIBBON CLAMP
8	2	538269-11	ASSY, NETJET MOUNT



ITEM	REV NO	DATE	DESCRIPTION	ECN NO	BY
2				535491-02	REF D WHERE USED

DRAWN BY:	CMC	SCALE	0 . 250	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	X X X	MATERIAL:	X X X	THIRD ANGLE PROJECTION	PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE QUOTED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC. WOODSTOCK, GEORGIA WOODSTOCK, GA 30188 USA
CHECKED BY:		DATE		.XX .XXX .ANG.	.01 .005 .5	HEAT TREAT:	X X X		
TRACED BY:		04 - Feb - 04		REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED	X X X	MODEL:	N JPM	TITLE:	KIRK-RUDY, INC WOODSTOCK, GEORGIA
		MASTER		ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY	X X X	SHEET NO:	1 OF 3	DRAWING #	538169-19



DRAWN BY:	C M C	SCALE:	0 . 250	MATERIAL:	X X X	THIRD ANGLE PROJECTION	KIRK - RUDY, INC WOODSTOCK, GEORGIA
CHECKED BY:		DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	.XX .XXX .ANG.	HEAT TREAT:	X X X	PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE QUOTED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC. WOODSTOCK, GA 30188 USA	
DATE:	04-Feb-00	.01 .005 .5	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED	FINISH:	X X X	MODEL:	N JPM
TRACED BY:	MASTER	ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY	20F3	SHEET #:	20F3	TITLE:	ASSY, NET JET PRINT
						DRAWING #:	538169-19
						REF'D:	2 53491-02
						WHERE USED:	

Drawing # 538153-01

ITEM NO	PART #	DESCRIPTION	REV A	DATE	ECN NO	B7
1	2	100306				
2	1	102112				
3	1	102306				
4	1	102906				
5	1	104100				
6	1	110163				
7	1	110211-17				
8	1	500311-2				
9	2	538146-01				
10	1	538147-01				
11	1	538149-01				
12	1	538150-01				
13	1	538151-01				
14	1	538152-01				
15	1	538154-01				
16	1	538154-02				
17	1	538155-01				
18	1	538167-01				

SCALE 0.250

DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED

SCALE:	T JG	0	375	INCHES	XXX	INCHES	XXX
CHECKED BY:				IN	MM	IN	MM
TRACED BY:				WEIGHT:		WEIGHT:	
				REPORT ALL FIGURES AND SIZES IN INCHES UNLESS OTHERWISE NOTED		REPORT ALL FIGURES AND SIZES IN MILLIMETERS UNLESS OTHERWISE NOTED	

PRINTING # 10 - Jan - 00

PRINTING # SP81400

PRINTING # 1 OF 1

PRINTING # ASSY, VERTICAL ADJ. RH

PRINTING # KIRK - RUDY INC.

PRINTING # KENNESAW, GEORGIA

PRINTING # 538153-01

PRINTING # 1 538153-01

PRINTING # RED'D WHERE USED

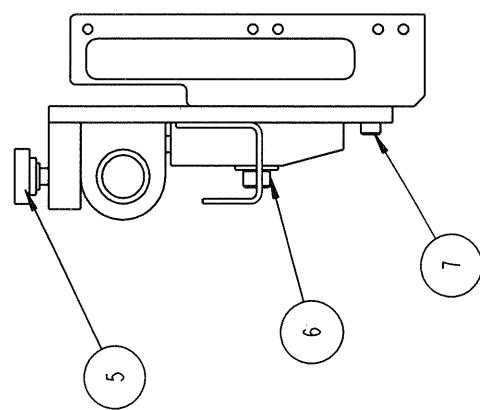
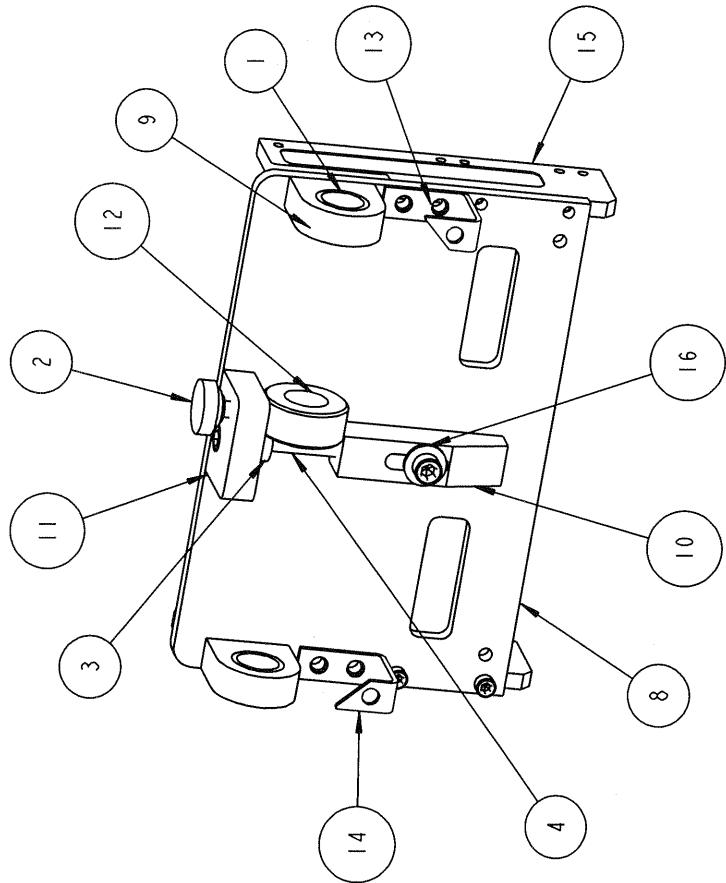
ITEM QTY	PART #	DESCRIPTION	REV	NO	DATE	DESCRIPTION		ECN	BY
1	1 02306	SHIM, .375X.625X.031							
2	1 02906	BEARING, LINEAR SLEEVE OPEN							
3	1 104100	SPRING, .375							
4	1 110163	SPRK1, 25B11 .375B NK							
5	1 500341-1	SHAFT, LIFT							
6	2 538146-01	SHAFT, BRACKET SUPPORT							
7	1 538147-01	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							

SCALE 0.375

1 SPR1400
REQ'D WHERE USED

DRAWN BY: T JG	SCALE 0 . 375	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED		MATERIAL: XXX	THIRD ANGLE PROJECTION		PROPRIETARY AND CONFIDENTIAL NO PART OF THIS DRAWING MAY BE QUOTED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY INC. KENNESAW, GA 30144 USA	
CHECKED BY:	DATE 10 - Jan - 00	.01	.005	AM6.			MODEL: SP81400	TITLE: ASSY, VERTICAL ADJ. LH
TRACED BY:	MASTER 	.5		HEAT TREAT: XXX			SHEET NO. 10F1	DRAWING # 538153-02
REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY								

ITEM	QTY	PART #	DESCRIPTION
1	2	100133	BUSHING, SL. 500ID. 625OD. 375LG
2	1	102132	KNOB, 10-32 CAP SCREW
3	1	102210	COLLAR .188
4	1	107416	SCREW, SHCS 10-32X1.750
5	1	107429	SCREW, SHCS 10-32X1.625
6	1	107430	SCREW, SHCS 10-32X.750
7	2	107436	SCREW, SHCS 6-32X.500
8	1	538270-01	PLATE, VERTICAL INKJET MNT.
9	2	538271-01	BLOCK, BUSHING MOUNT
10	1	538273-01	CAM, INKJET LEVEL
11	1	538280-01	BLOCK, SLIDE LOCK
12	1	538300-01	COLLAR, SLED LOCK
13	1	538305-01	INDICATOR, SCALE RH
14	1	538305-02	INDICATOR, SCALE LH
15	2	540185-01	PLATE, NETJET HEAD MOUNT
16	1	WA006	WASHER, FLAT #10



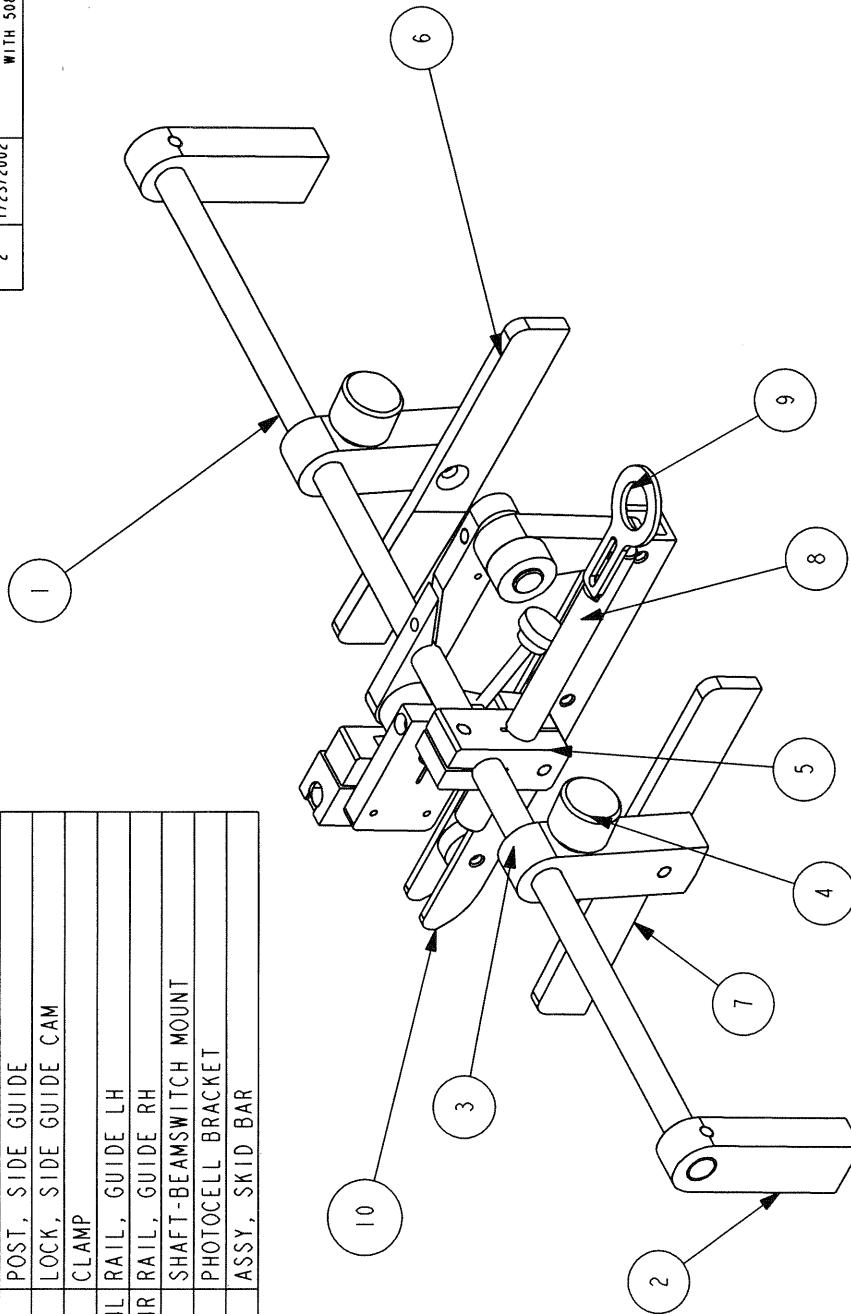
DRAWN BY:	SCALE	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	MATERIAL:	THIRD ANGLE PROJECTION	PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE QUOTED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK RUDY, INC. WOODSTOCK, GA 30188 USA
CHECKED BY:	DATE	.005	ANG.	X X X	KIRK - RUDY, INC. WOODSTOCK, GEORGIA
TRACED BY:	DATE	.01	HEAT TREAT:	X X X	SP 81400
MASTER			FINISH:	X X X	SHEET NO. 1 OF 1
					DRAWING # 538269-11

ITEM QTY	PART #	DESCRIPTION		REV NO	DATE	DESCRIPTION	ECN NO	BY
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, AK510 GAST 823						
19	200124-5	MUFFLER, SINTERED GAST 823						
20	200124-6	O-RING, GASKET GAST 823						

DRAWN BY:	SCALE	0 . 1 5 6	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED		NOTED	THIRD ANGLE PROJECTION	PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE COPIED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC. KENNESAW, GA 30144 USA	
CHECKED BY:	DATE	.XX	.XX	ANG.				
TRACED BY:	MASTER	20 - JUN - 97	.01	.005	.5	NOTE:	TITLE: ASSY, 1/2 HP VACUUM PUMP	
			HEAT TREAT:					
			NONE					
			FINISH:					
			NONE					
			DO NOT SCALE - WORK TO DIMENSIONS ONLY					

I	215	REO'D	WHERE USED
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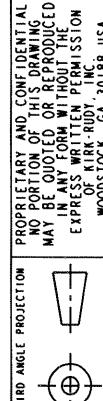
ITEM	QTY	PART #	DESCRIPTION
1	1	500787	SHAFT-SIDE GUIDE ADJ.
2	2	500791	POST, SIDEGUIDE
3	2	500792	POST, SIDE GUIDE
4	2	500793	LOCK, SIDE GUIDE CAM
5	1	508593	CLAMP
6	1	500722-24L	RAIL, GUIDE LH
7	1	500722-24R	RAIL, GUIDE RH
8	1	508995-4	SHAFT-BEAMSWITCH MOUNT
9	1	508996-2	PHOTOCELL BRACKET
10	1	538021-01	ASSY, SKID BAR



REV NO	DATE	DESCRIPTION	ECN NO	BY
1	11/22/2001	REPLACED 508995-1 WITH 508995-4		T.G
2	1/23/2002	REPLACED 508996-4 WITH 508996-2		T.G

REQ'D	WHERE USED
1	536491-02

KIRK - RUDY, INC.
WOODSTOCK, GEORGIA



ASSY, SKIDBAR/SENSOR

DRAWING I

538188-01

PROPRIETARY AND CONFIDENTIAL
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EXPRESS WRITTEN PERMISSION
OF KIRK-RUDY, INC.
WOODSTOCK, GA 30188 USA

THIRD ANGLE PROJECTION

MODEL: SP81400

DATE: 7- Jan - 00

TIME:

SHEET NO: 1 OF 1

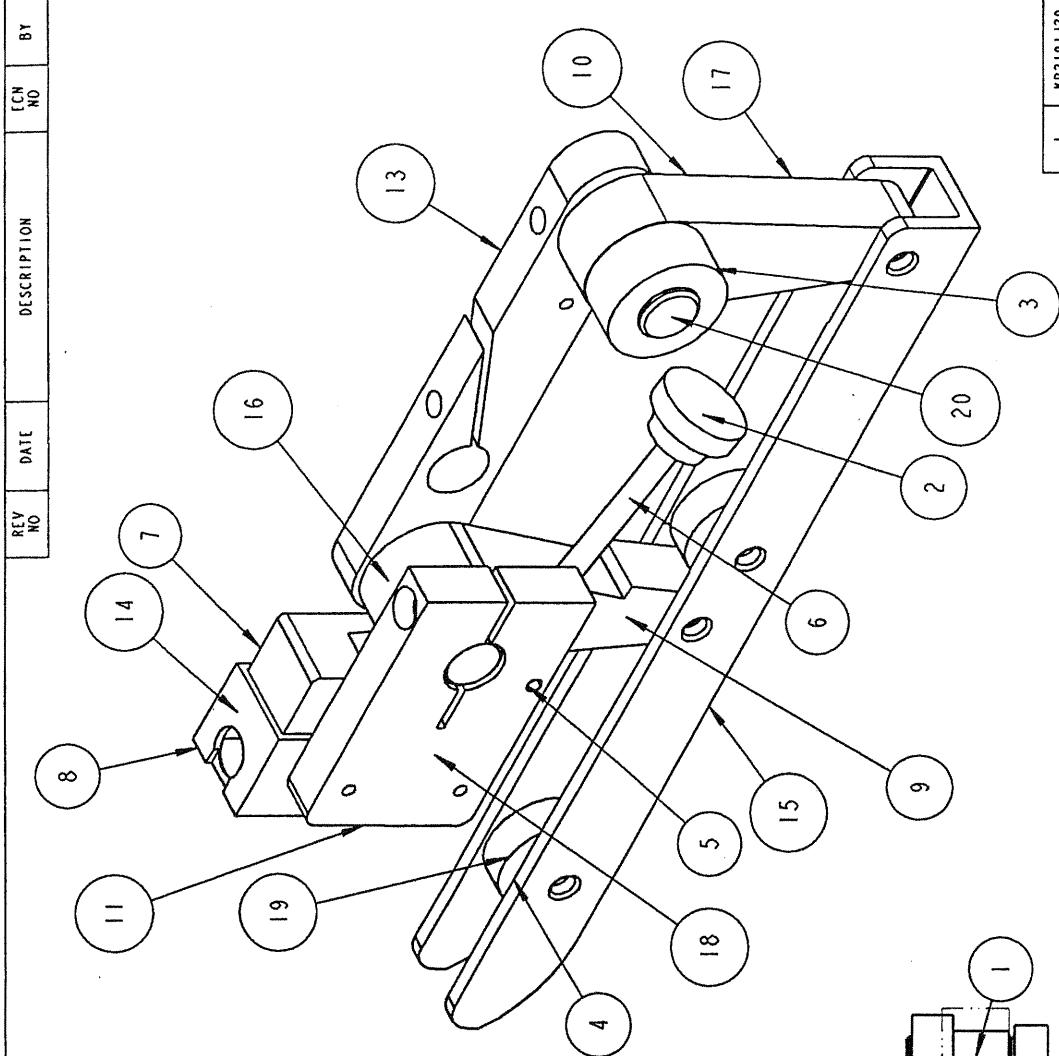
DRAWN BY: T JG SCALE 0 .375 DIMENSIONAL TOLERANCES MATERIAL: N / A

checked by: DATE .01 .005 .5 ANG

Traced by: MASTER FINISH: REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED. ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY

ITEM QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
----------	--------	-------------	--------	------	-------------	--------	----

1	2	100162	BUSHING, SL. 5001D. 6250D. 625LG				
2	1	102114	KNOB				
3	1	102205	COLLAR .500				
4	2	103107	BEARING, FLAT .312				
5	1	105201	PIN, ROLL .125X 1.000				
6	1	105602	SHAFT, THREADED 10-32				
7	1	190101	MICROSWITCH, LEVER				
8	1	190203	COVER, MICROSWITCH				
9	1	500800	LINK-SKID-FRONT				
10	1	500801	LINK-SKID-REAR				
11	1	500802	HOLDER-SKID SWITCH				
12	2	500834	SHAFT, SKID ROLLER				
13	1	503794	CLAMP				
14	1	190101A	ASSY-SWITCH WITH COVER				
15	1	500723-8	CHANNEL, SKID				
16	1	500800-A	ASSY, LINK				
17	1	500801A	ASSY, LINK				
18	1	500802A	ASSY, CLAMP				
19	2	500834A	ASSY, STUD WITH BEARING				
20	2	SP37359	SHAFT, SKID BAR SPACER				



1	KR2191J20
1	KR2191J

REV'D WHERE USED

KIRK - RUDY, INC.
KENNESAW, GEORGIA

ASSY, SKID BAR

538021-01

PROPRIETARY AND CONFIDENTIAL
NO PORTION OF THIS DRAWING
MAY BE COPIED OR REPRODUCED
IN ANOTHER FORM WITHOUT THE
EXPRESS WRITTEN PERMISSION
OF KIRK-RUDY, INC.
KENNESAW, GA 30040, USA



TITLE:

2191J

DRAWING #:

10F1

SCALE:

1

INCHES

MM

MM

ANG.

.01

.005

.5

HEAT TREAT:

N/A

FINISH:

N/A

SPEC. NO.:

10F1

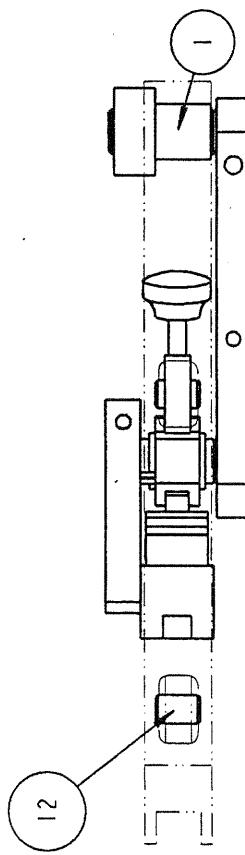
SCALE:

0.750

DIMENSIONAL TOLERANCES
UNLESS OTHERWISE NOTED

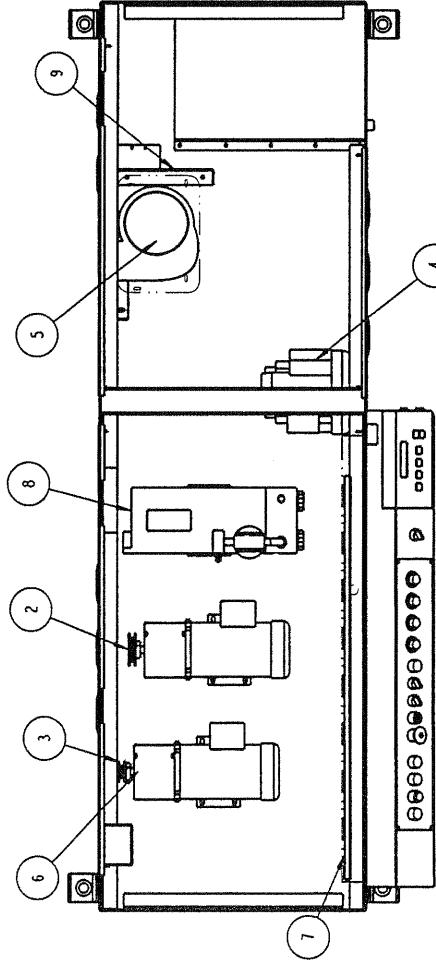
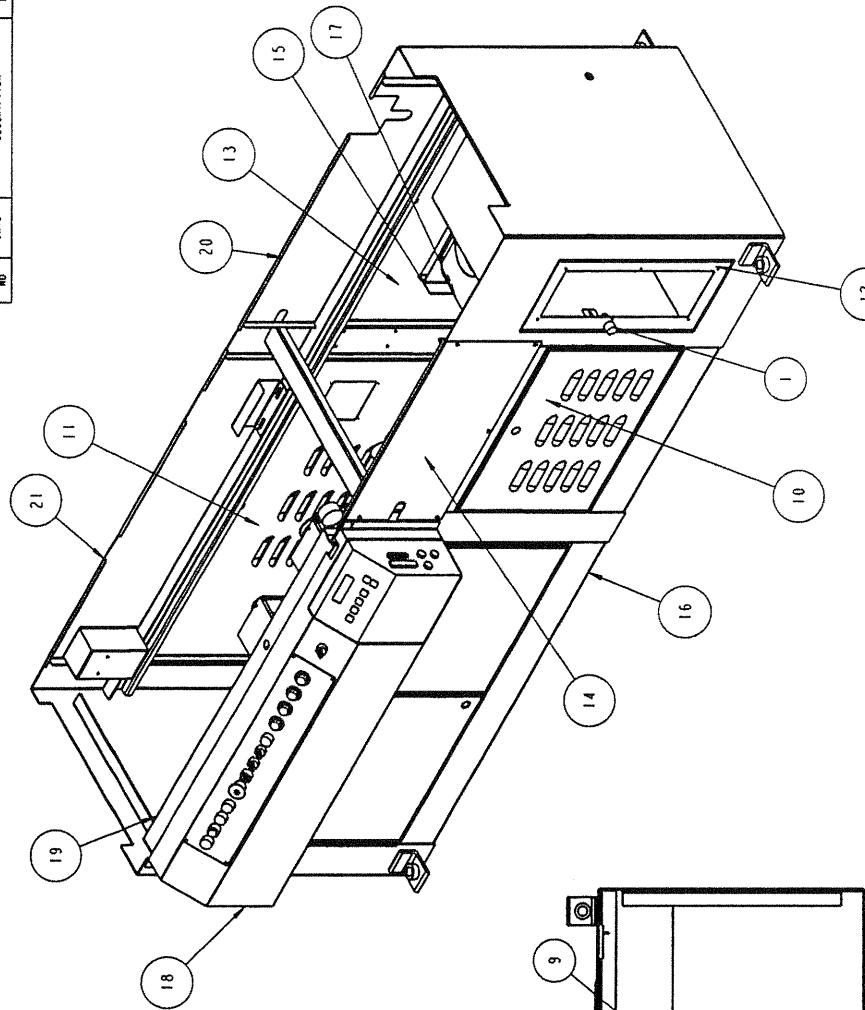
DRAWN BY: A Y B DATE: 15-NOV-99
CHECKED BY: TRACED BY: MASTER

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



SCALE 0.500

ITEM NO.	PART #	DESCRIPTION
1	1	102143 KNOB, CABINET LATCH
2	1	105021 V-PULLEY, AK30
3	1	105026 V-PULLEY, MAYR. 2200
4	1	2000120 BLOWER, GAST
5	1	2000129 BLOWER, FAN
6	2	509000-8A ASSY, MTR REDUCER SR 1/2HP VERT
7	1	528716-2 PANEL, WIRING 215J
8	1	531168-01 ASSY, 1/2 HP VACUUM PUMP
9	1	533823-01 WELMENT, ELECTRICAL BOX
10	1	536445-03 DOOR, FRONT DROP OUT
11	1	536445-04 DOOR, REAR DROP OUT
12	1	536478-01 COVER, DOOR INSERT
13	1	536492-02 DOOR, DRYER REAR
14	1	536493-02 COVER, DRYER UPPER FRONT
15	1	538284-01 BRACKET, BLOWER MOUNT
16	1	538285-01 WDNNT, 215B CABINET
17	1	538291-01 WLDNT, AIR HOSE MNT.
18	1	538292-01 ASSY, ELECTRICAL PANEL
19	1	538299-01 INSERT, 215B ELECTRICAL
20	1	538887-01 COVER, UPPER REAR OUTFO
21	1	538888-01 COVER, UPPER REAR INFO



SCALE 0.090

Drawing #: T JG		SCALE	DIMENSIONAL TOLERANCES (INCHES)	PROPS & PROD:	PROPS & PROD:	PROPS & PROD:
ITEM #:	T JG	0 . 090	XXX	ALL PARTS	ALL PARTS	ALL PARTS
CHECKED BY:			INCH	INCH	INCH	INCH
DATE:	25 - Feb - 00		.5	.5	.5	.5
REMOVED ALL SURFACES AND SHARP EDGES, UNLESS OTHERWISE SPECIFIED ALL SURFACES ARE FINISHED. DO NOT EXCEED WORK DIMENSIONS ON ONE SIDE.						
MAKER:						
TRACED BY:						
SCALE	0.090					
DATE:	538288-01					

1	215B	RELO'D WHERE USED
1	KIRK - RUDY, INC.	KENNESAW, GEORGIA

ASSY, CABINET & COVERS

538288-01

ITEM	QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	1	200152-2	MOTOR, LEESON DC 1/2HP					
2	1	542566-01	ASSY, AK20 V-PULLEY TOR. LIMITER					

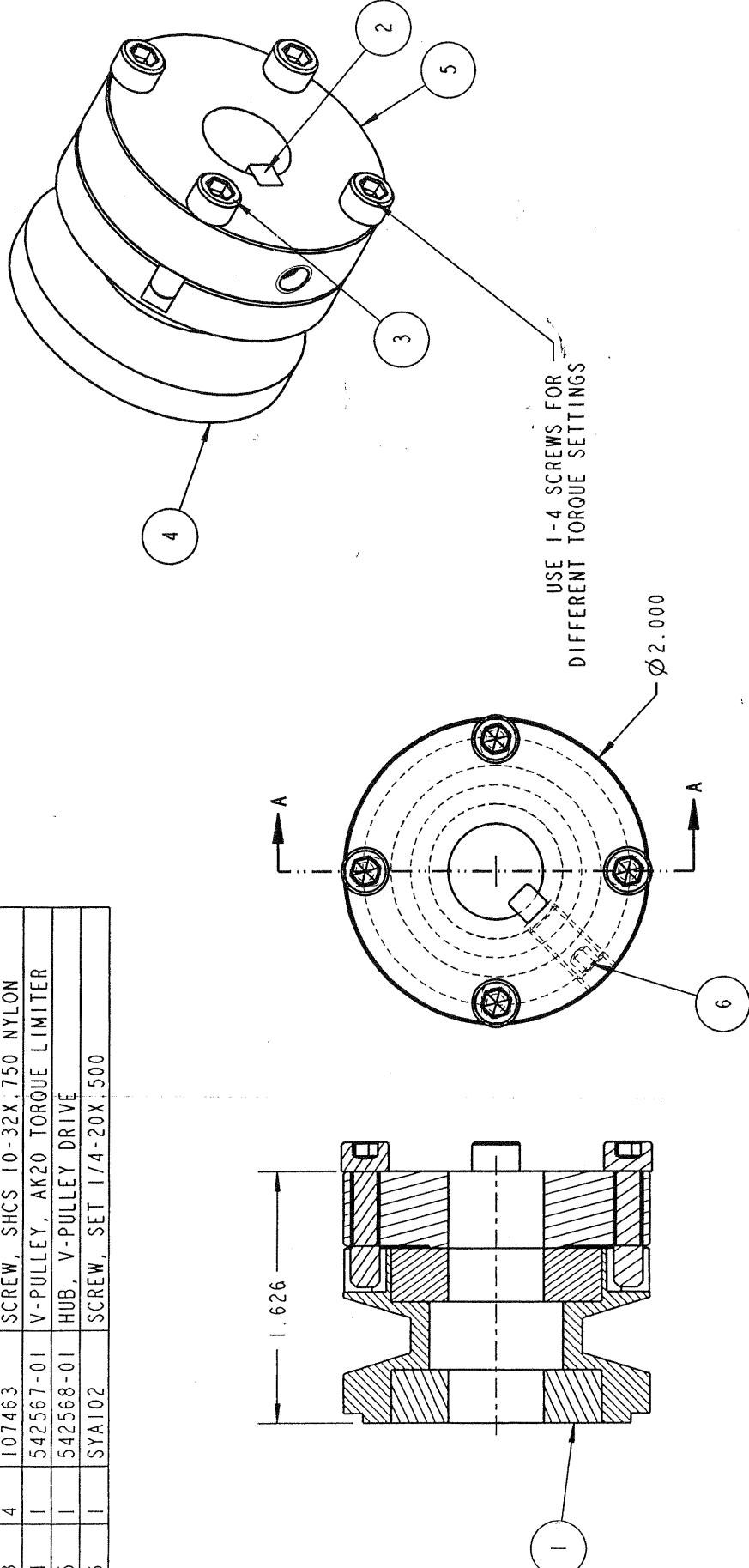
NOTES:

1. REFERENCE TECHNICAL BULLETIN 542832-00.
2. CAN BE USE ON ANY MOTOR WITH 5/8" SHAFT.

DRAWN BY: T JG	SCALE 0 . 250	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED			MATERIAL: XXX	THIRD ANGLE PROJECTION						
DATE 05-Dec-02	.01	.005	.5	HEAT TREAT: XXX	 MODEL: SA124							
CHECKED BY: M	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED			FINISH: XXX	TITLE: ASSY, MOTOR / TORQUE LIMITER							
TRACED BY: M	ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE. WORK TO DIMENSIONS ONLY			SHEET NO.: 10F1	DRAWING # 542833-01							
<table border="1"> <tr> <td>X</td> <td>XXX</td> </tr> <tr> <td>REO'D</td> <td>WHERE USED</td> </tr> </table>									X	XXX	REO'D	WHERE USED
X	XXX											
REO'D	WHERE USED											

ITEM QTY	PART #	DESCRIPTION
1	2	103110 BEARING, FLAT .625
2	1	105312 KEY, 3/16 X 1/2
3	4	107463 SCREW, SHCS 10-32X.750 NYLON
4	1	542567-01 V-PULLEY, AK20 TORQUE LIMITER
5	1	542568-01 HUB, V-PULLEY DRIVE
6	1	SYA102 SCREW, SET 1/4-20X.500

REV NO	DATE	DESCRIPTION	ECN NO	BY



NOTE:
1. REFERENCE TECHNICAL BULLETIN 542832-00.

DRAWN BY:	T JG	SCALE	.000	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	X X X	MATERIAL:	X X X	THIRD ANGLE PROJECTION	PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE QUOTED OR REPRODUCED IN WHOLE OR IN PART WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY INC. KENNESAW, GA 3044 USA
CHECKED BY:		DATE	- JU - 02	.01 .005 .005 .005 .005	X X X	HEAT TREAT:	X X X		
TRACED BY:		MASTER		REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED				MODEL: SAI24	TITLE: ASSY, AK20 V-PULLEY TOR. LIMITER
				ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE. WORK TO DIMENSIONS ONLY				SHEET NO. 10F1	DRAWING # 542566-01

ITEM QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	1	509000-8A ASSY, MTR/REDUCER SR 1/2HP VERT					
2	1	542566-02 ASSY, AK30 V-PULLEY TOR. LIMITER					

NOTES:

1. REFERENCE TECHNICAL BULLETIN 542832-00.
2. CAN BE USED ON ANY MOTOR WITH 5/8" SHAFT.

DRAWN BY: T JG SCALE 0 . 250 DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED

.01	.005	.5
xx	xxx	ANG.

HEAT TREAT: XXX

CHECKED BY: 05 - Dec - 02 DATE REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED

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

MASTER TRACED BY: MM

RECD WHERE USED X XXX

PROPRIETARY AND CONFIDENTIAL
NO PORTION OF THIS DRAWING
MAY BE QUOTED OR REPRODUCED
IN ANY FORM WITHOUT THE
EXPRESS WRITTEN PERMISSION
OF KIRK-RUDY, INC.
KENNESAW, GA 30144 USA

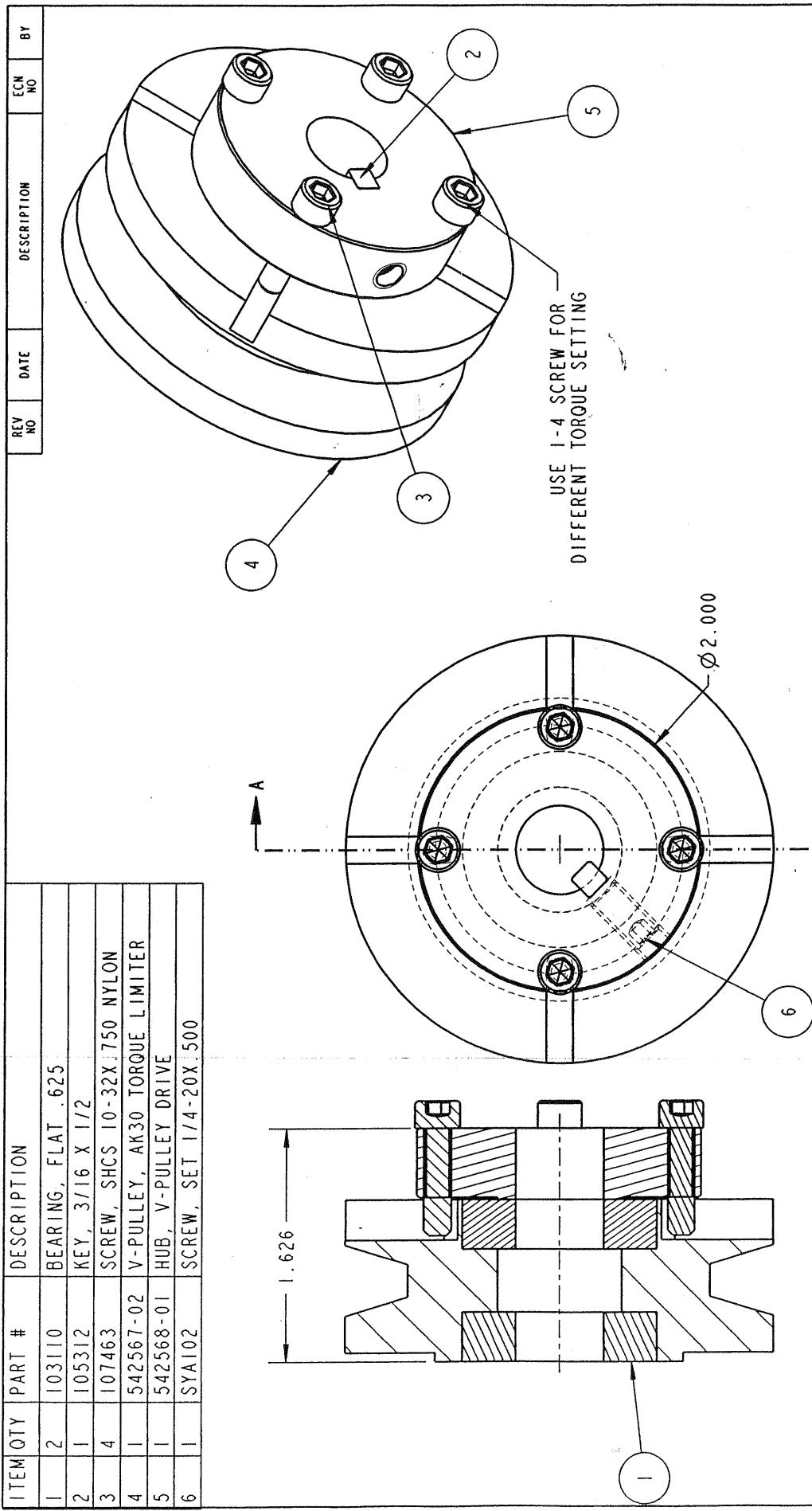
KIRK - RUDY - INC.
KENNESAW, GEORGIA

MODEL: SA124 TITLE: ASSY, MOTOR / TORQUE LIMITER

DRAWING # 542833-02

SHEET NO. 1 OF 1

ITEM QTY	PART #	DESCRIPTION
1	2 103110	BEARING, FLAT .625
2	1 105312	KEY, 3/16 X 1/2
3	4 107463	SCREW, SHCS 10-32X .750 NYLON
4	1 542567-02	V-PULLEY, AK30 TORQUE LIMITER
5	1 542568-01	HUB, V-PULLEY DRIVE
6	1 SYA102	SCREW, SET 1/4-20X .500



REV NO	DATE	DESCRIPTION	ECN NO	BY
REF'D WHERE USED				
X	XXX			
T JG	1.000	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	XXX	THIRD ANGLE PROJECTION
	.01	.005	.5	NO PORTION OF THIS DRAWING MAY BE COPIED OR REPRODUCED IN WHOLE OR IN PART WITHOUT EXPRESS WRITTEN PERMISSION OF KIRK-RUDY INC., KENNESAW, GA 3044 USA
DATE	JUL - 02	HEAT TREAT:	XXX	KIRK - RUDY, INC. KENNESAW, GA 3044 USA
CHECKED BY:		FINISH:	XXX	KIRK-RUDY INC. KENNESAW, GA 3044 USA
MASTER	M	ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY	XXX	ASSY, AK30 V-PULLEY TOR. LIMITER
TRACED BY:			10F1	DRAWING #
				542566-02

ITEM	QTY	PART #	DESCRIPTION	REV NO	DATE	DESCRIPTION	ECN NO	BY
1	1	1001	WINKJET CONTROL MODULE					
2	4	209016	KNOB, POT					
3	1	201124-2	BUTTON, START					
4	1	201124-4	BUTTON, POWER ON					
5	1	201125-3	BUTTON, STOP					
6	1	201125-5	BUTTON, POWER OFF					
7	2	201126-1	BUTTON, JOG					
8	4	201145-1	SELECTOR, 2 POSITIONS					
9	1	500421-1	PNL, CONTROL					
10	1	538293-01	WLDMT, CONTROL BOX COVER					

1 215B
RECD WHERE USED

ASSY, ELECTRICAL PANEL

538292-01

DRAWN BY:	JG	SCALE	0 . 125	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED			MATERIAL:	THIRD ANGLE PROJECTION	PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE QUOTED OR REPRODUCED IN WHOLE OR IN PART WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC., KENNESAW, GA 30144 USA	
CHECKED BY:		DATE:	17-Feb-00	.01	.005	.5	WEAT TREAT:	N/A	MODEL:	215B
TRACED BY:		MASTER	<i>m</i>	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY			SHEET NO.	10F2	TITLE:	ASSY, ELECTRICAL PANEL

7 ELECTRICAL SCHEMATICS AND PARTS

7.1 SCHEMATIC LIST

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

109 500 30-04

7.2 PARTS LIST

8 APPENDIX

8.1 POSSIBLE OPTIONS

The KR215N 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 KR215N 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

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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770-427-4203
FAX 770-427-4036
WWW.KIRKRUDY.COM