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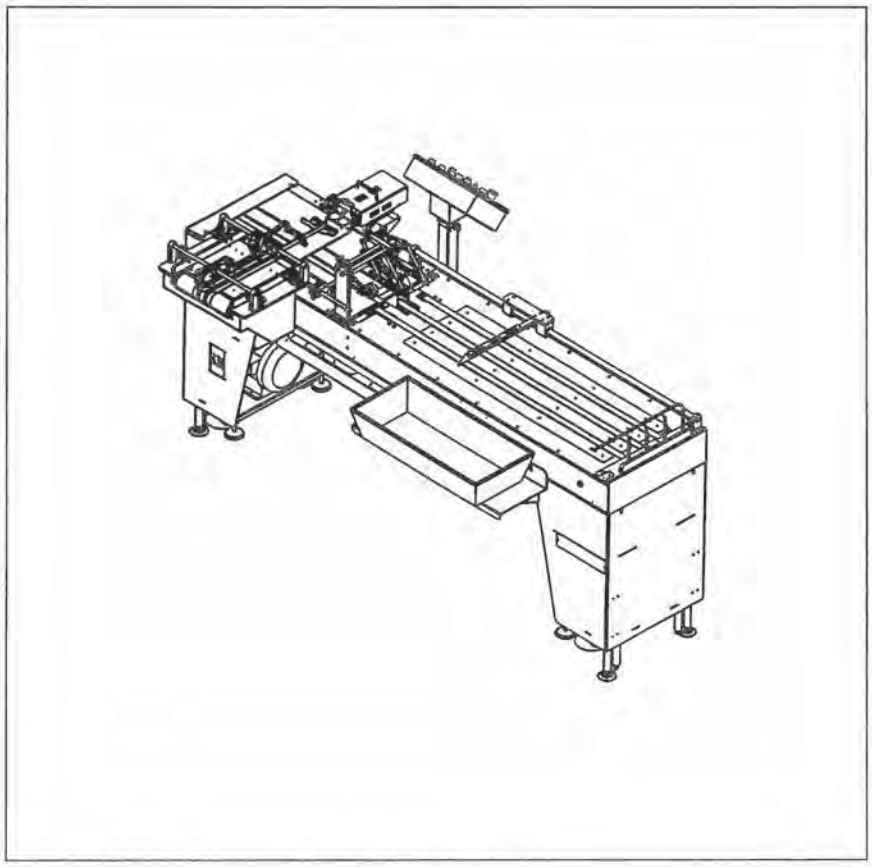
Kirk-Rudy Inc.

Instruction and Parts Manual KR345 Edge Stacker

Manual



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.

10000-345 REV. 4 8/13/04

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1.0 Important Safety Instructions

Intended Use Statement: The KR 345 is a belted conveyor transport designed to shingle or shingle and edge stack paper and plastic products. The system is made up of three major sections - the infeed, crossfeed and outfeed sections. Product enters the infeed section and is sped up, aligned and diverted onto the crossfeed section. Product is shingled and sorted on the crossfeed conveyor. The outfeed section is used for shingling or edge stacking the material. Product is slid off the outfeed conveyor directly into a mail tray. Usage for other purposes may lead to an unsafe condition.

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

⚠ WARNING

* NEVER OPERATE THE MACHINE WITHOUT ALL GUARDS OR SAFETY DEVICES IN PLACE.

* ALWAYS TURN POWER OFF WHEN MAKING ADJUSTMENTS.

* ALWAYS DISCONNECT THE POWER SUPPLY BEFORE ANY MAINTENANCE OR SERVICE WORK.

* NEVER START THE MACHINE WITHOUT FIRST CHECKING ALL PERSONNEL ARE CLEAR OF MOVING PARTS.

* KEEP FINGERS CLEAR OF ALL MOVING PARTS.

* NEVER REMOVE THE PRODUCT FROM THE MACHINE WHILE MACHINE IS RUNNING.

* SHOULD MISFEED PRODUCT JAM THE MACHINE AND STOP IT FROM RUNNING, ALWAYS PRESS THE STOP BUTTON BEFORE CLEARING PRODUCT. IF THE STOP BUTTON IS NOT PRESSED AND THE JAM IS CLEARED, THE MACHINE WILL BEGIN RUNNING.

* IT IS NOT RECOMMENDED THAT LOOSE CLOTHING, JEWELRY AND LONG HAIR BE WORN WHILE OPERATING THIS MACHINERY.

* ALWAYS USE A LISCENSED ELECTRICIAN WHEN TROUBLE-SHOOTING ELECTRICAL PROBLEMS.

* CHANGES OR MODIFICATIONS TO THIS UNIT NOT EXPRESSLY APPROVED BY THE PARTY RESPONSIBLE FOR COMPLIANCE COULD VOID THE USER'S AUTHORITY TO OPERATE THE EQUIPMENT.

2.0 SPECIFICATIONS

Physical

Length	7'
Height	42"
Width	38"
Infeed height	33.2" (can vary with optional infeed conveyor)
Conveyor exit direction	Specify left or right

Electrical Requirements

Voltage	120 VAC
Current	15 amps
Phase	single
Hertz	60

Production Rate

Belt speed	400 ft/min
Stacks/minute	55/min

***Material Handling**

Min stock size-Edge stacking	3" x 5" card stock or envelope
Max stock size-Edge stacking	6" x 9" and 6" x 11" card stock or envelope
Min stock size-shingle only	3" x 5"
Max stock size-shingle only	9" x 12"
Minimum stock thickness-shingle only	copy paper
Maximum stock thickness	1/ 4"

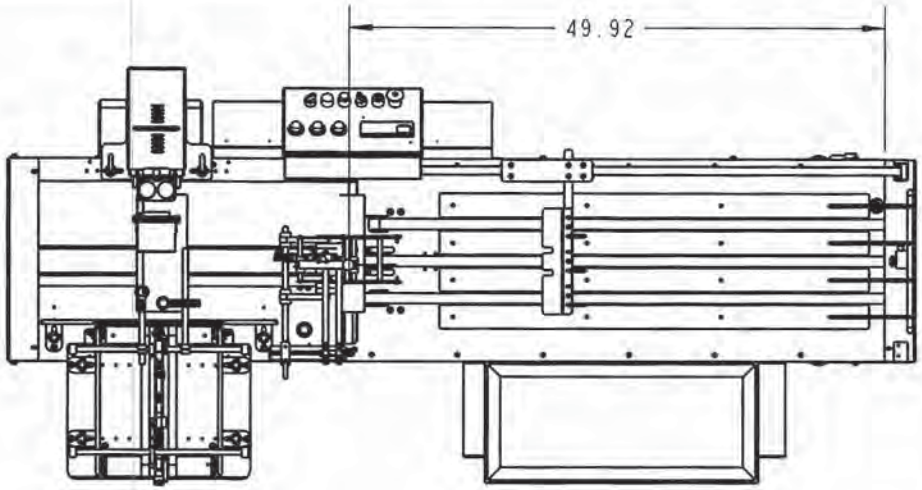
Features

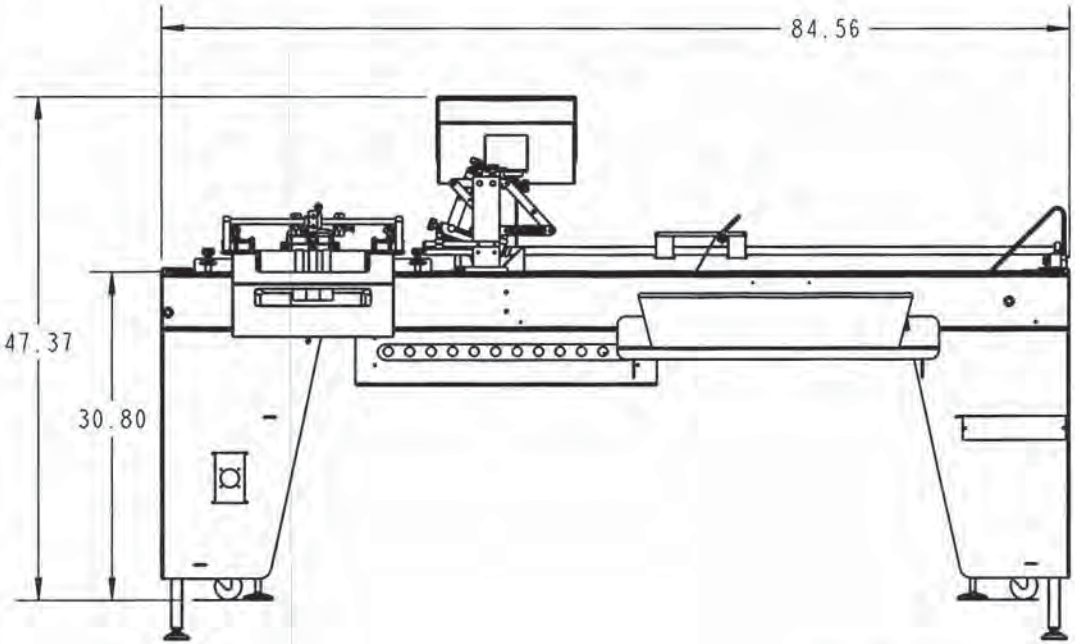
High speed infeed table
Two position backstop
Semi-automatic startup
Standard inkjet interface
Shingle only mode
Batch counter mode
Mail tray shelf

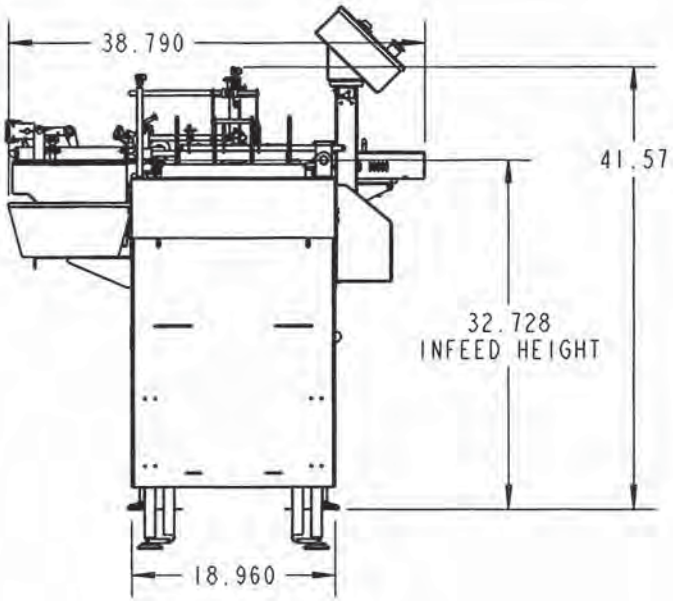
Options

Hydraulic lift kit
Left or right outfeed conveyor
Stack mark reader
*Incline infeed conveyor extension

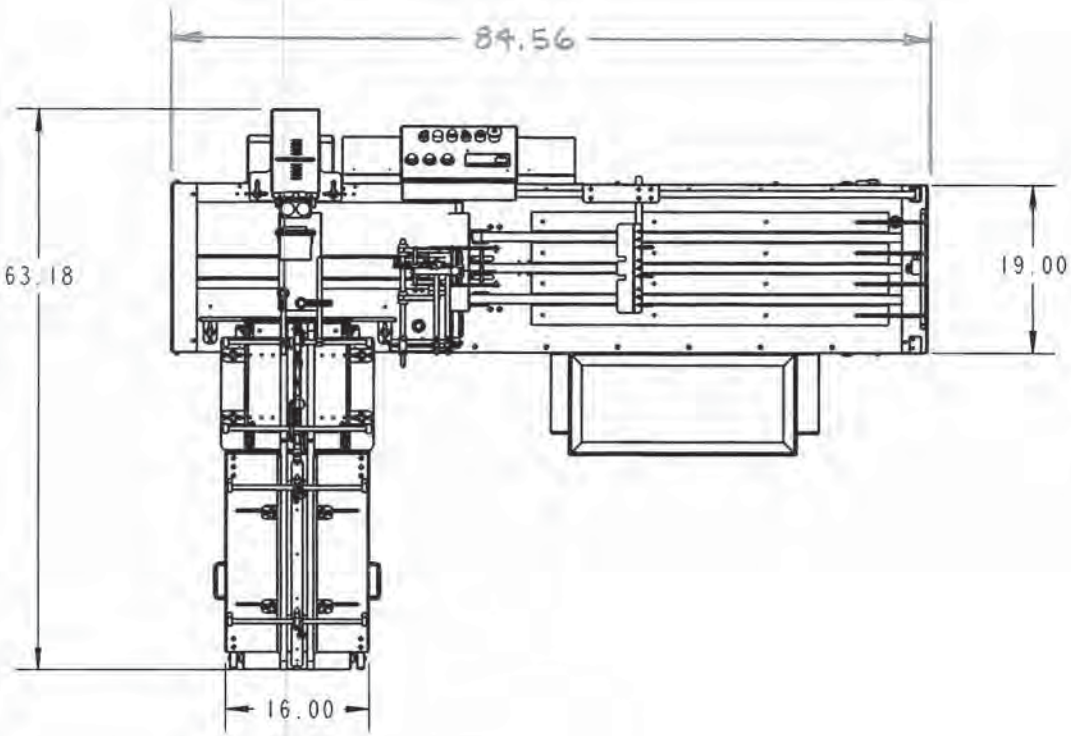
***Note: With optional infeed extension product width is limited to 9.75". Product thickness may be limited dependent on conveyor incline angle.**

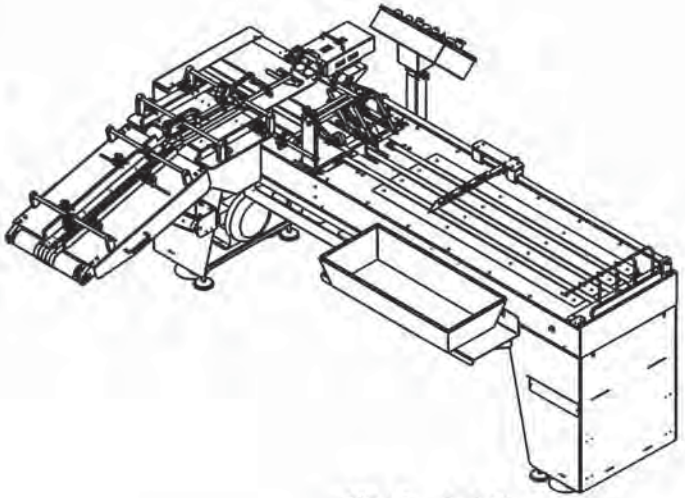






KR345R W/STANDARD INFEED





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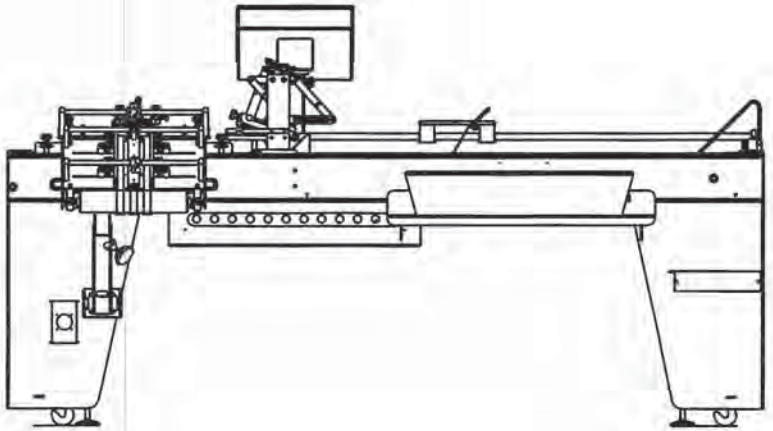
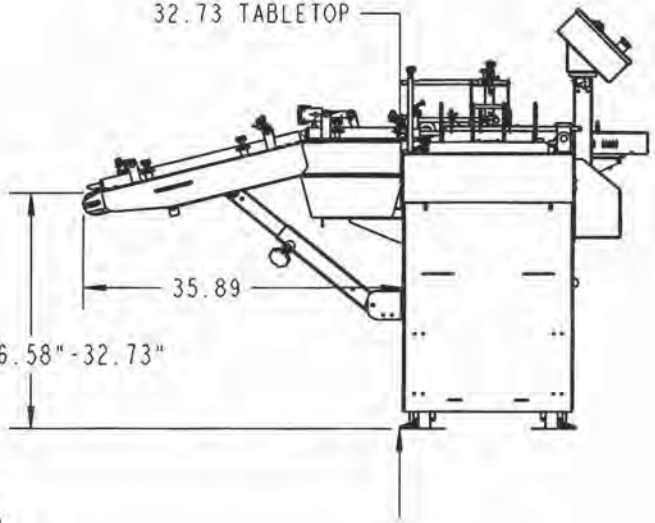
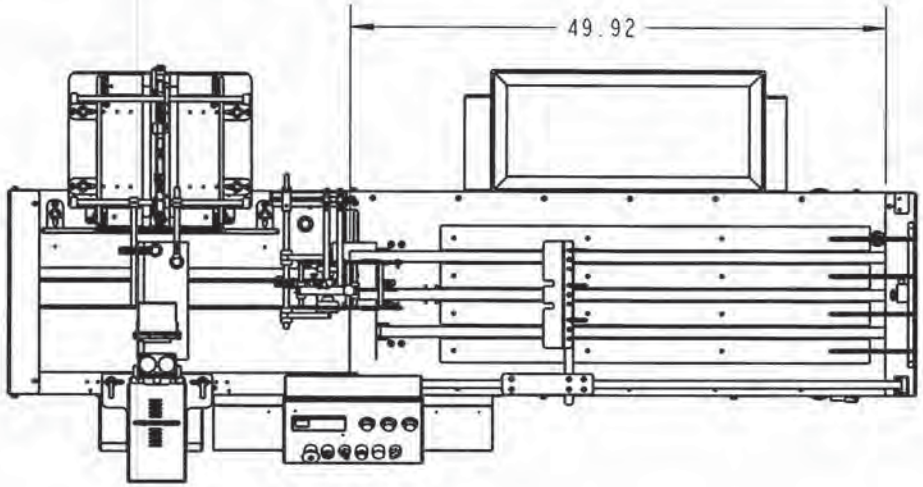
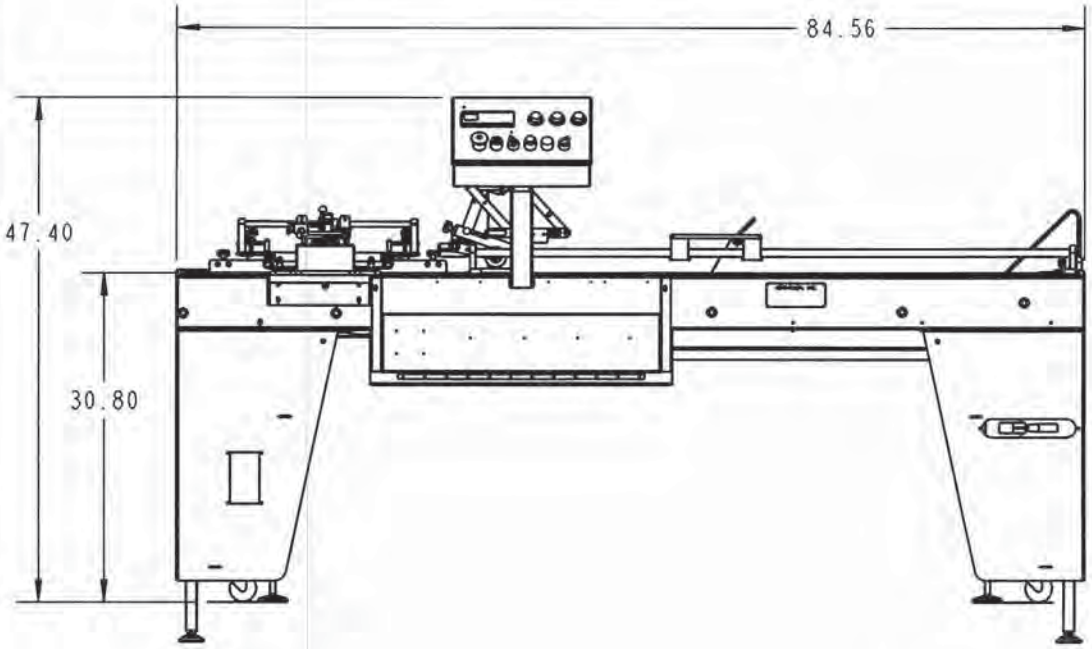
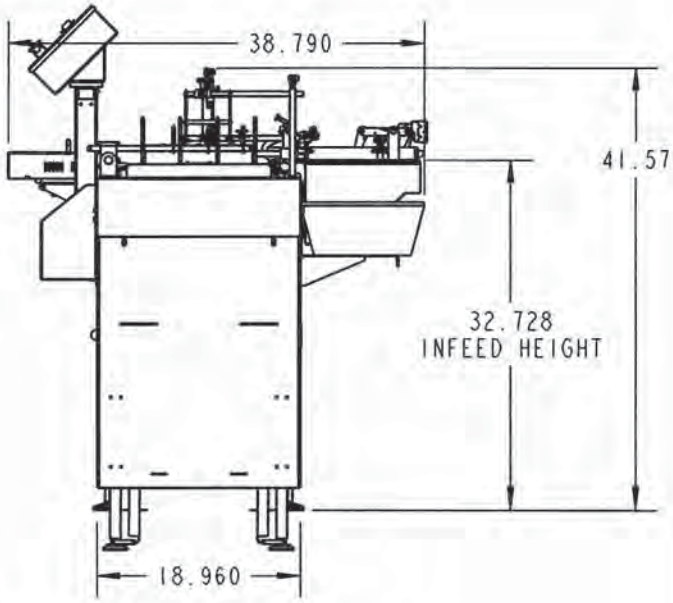




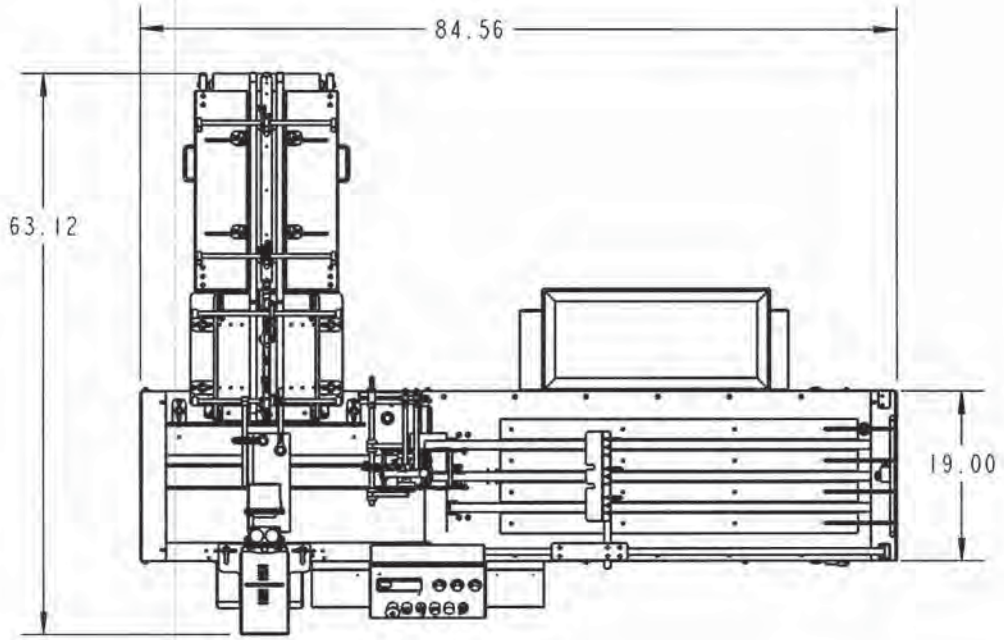
KR345R WITH EXTENDED
INFEED CONVEYOR

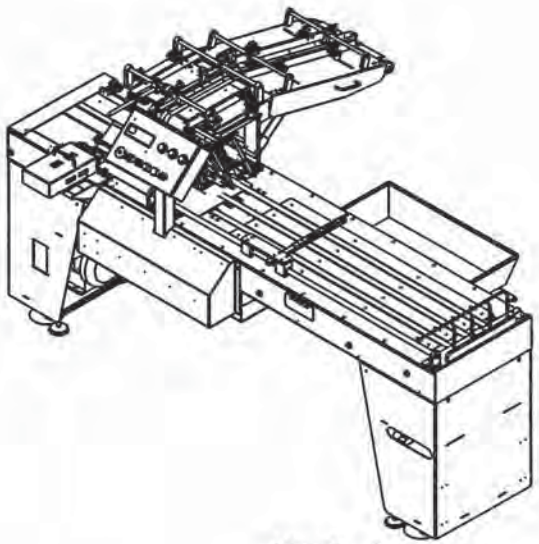






KR345L W/STANDARD INFEED





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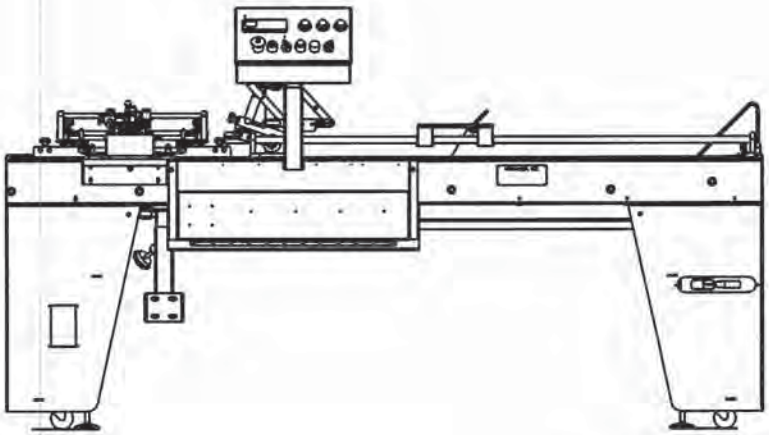
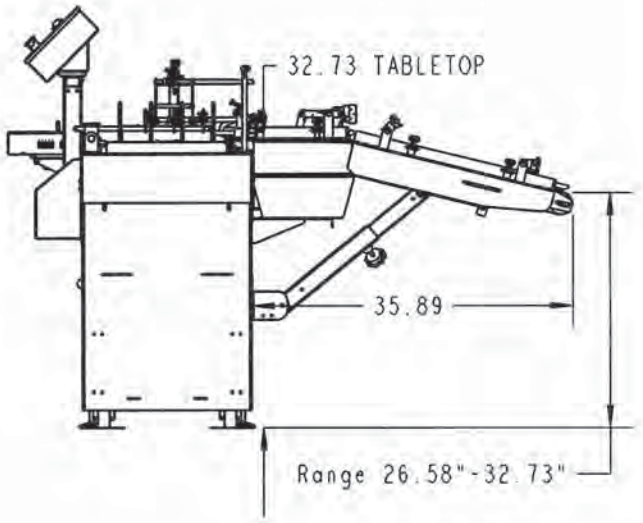


KR345L WITH EXTENDED
INFEED CONVEYOR



3.0 INSTALLATION

WARNING

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

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

3.1 Uncrating and Unpacking

Position crates near installation site.

1. Remove crate top and sides.
2. Remove metal strapping and securing blocks.
3. Locate accessories box and use checklist to verify all items were shipped.
4. Use a forklift to lift machine off skid. Be sure to position the forks in a central location.
5. Machine is on casters and can be rolled inline with feeder base.
6. Adjust height using the leveling legs or the optional hydraulic lift kit handle.

3.2 Cable and Cord Connections

1. A Turk connector is available for connecting to the stop circuit. This circuit stops the upstream machine whenever the KR345 stops.
2. Sort signal –Dual two-pin twist type connectors are supplied for connecting to the sort circuit. . Use one or the other depending on the type of sort signal provided. The connector marked "contact" is a female connector and is used when a close contact signal is used for sorting. The connector marked "volt" is a male connector and is used when a 5-volt dc signal is used for sorting. A switch marked Volt/Contact located in the electrical box must be switched to the type signal for the appropriate connector to work.
3. The power cord has a standard 110volt plug and a quick disconnect.

4.0 Machine Description

4.1 Mechanical Component Description

The **vertical stacking conveyor** consists of three sections – infeed, crossfeed and outfeed conveyors. The infeed conveyor speeds up, aligns and diverts product onto the crossfeed section. The crossfeed conveyor shingles and sorts product. The outfeed conveyor is where product vertically stacks. The crossfeed and outfeed conveyors can be operated together to act as a conventional conveyor.

4.1.**Infeed conveyor**

1. The spring-loaded skidbar assembly keeps product against the belts and is also used as a jam detector. It is height adjustable.

2. The spring-loaded pinch wheel assembly diverts product downward to the knockdown plate. It is height adjustable. It can also be radially adjusted around the belt drive roller.
3. The side guides align the product.

4.2 **Crossfeed conveyor**

1. The sort mechanism moves the knockdown plate/ball assembly in and out across the crossfeed conveyor. This creates offsets in the shingled stream indicating zip and bundle breaks. The knockdown can be adjusted in three directions: up/down, side to side and in/out. A brush mounted to the plate helps prevent material from bouncing off the steel balls.
2. The vacuum in the crossfeed tabletop holds product in place as it is being conveyed. A butterfly valve is available to control the vacuum level.
3. The press down roller assembly drives product up to a vertical position.

4.1.3 **Outfeed conveyor**

1. The spring-loaded wedge assembly directs product up against the backstop to start the vertical stacking process. The wedges are forced underneath the table as product flows across them.
2. The top edge of the mail piece stops against the upper product guide assembly. This unit adjusts vertically.
3. The backstop assembly moves along with the outfeed conveyor belts to support the stack. When using the KR 345 as a conventional shingle conveyor, ¼" rods are installed at the end of the outfeed conveyor and the backstop is pivoted out of the way.

4.2 Electrical Component Description

4.2.1 Control Panel

1) Emergency Stop Button: Press button to turn machine power off. To turn power on, unlatch this button. The green "power on" indicator light will turn off when power is off.
2) Power on Button: Press this button to turn machine power on. Emergency stop button must be unlatched. Switch illuminates when activated.
3) Blower off/on: Turns the crossfeed blower on or off
4) Stop Button: Stops all drive motors.
5) Start Button: When the main power is on, the start button will start the drive motors. Always be sure personnel are clear of moving parts before pressing the start button.
6) Vertical/conventional: Sets the mode of operation to either edge stacking (vertical) or conventional shingling. When set to conventional mode, the cross feed and outfeed conveyors operate together.
7) Speed Control Knobs: Sets the speed of the unit's drive motors.
8) User Interface: See section 4.3 User Interface for complete description.

4.2.2 Electrical Connections to Base

1. A Turk connector is available for connecting to a stop circuit. When properly connect, the stop circuit stops upstream equipment whenever the KR345 stops.
2. Sort signal –Dual two-pin twist type connectors are supplied for connecting to the sort circuit. . Use one or the other depending on the type of sort signal provided. The connector marked "contact" is a female connector and is used when a close contact signal is used for sorting. The connector marked "volt" is a male connector and is used when a 5-volt dc signal is used for sorting. A switch marked Volt/Contact located in the electrical box must be switched to the type signal for the appropriate connector to work.
3. The power cord has a standard 110volt plug and a quick disconnect.

4.2.3 Beam and Micro Switches

1. A micro switch is mounted on the skidbar on the infeed conveyor. A jam on the infeed conveyor will raise the skid bar activating the micro switch and stopping the vertical stacking conveyor.
2. The crossfeed beam switch controls the clutch on the crossfeed conveyor. The clutch engages and drives the crossfeed belts when the beam switch is covered.
3. The counter beam switch provides the count to the PLC for batch counting. If necessary, a time delay can be added to the signal by the PLC.
4. The outfeed beam switch is a perfect prox type. This switch controls the clutch on the outfeed conveyor. When the product is within two inches of the switch, the clutch engages and drives the outfeed belts. To keep the clutch from constantly cycling, set an outfeed delay of .4 seconds in the PLC.
5. The outfeed stop beam switch is also a perfect prox type. This switch automatically stops the vertical stacking conveyor when the backstop is within two inches of it.

4.3 USER INTERFACE

4.3.1 Overview: The user interface is built into the PLC. The interface provides a way to electronically change certain machine settings and parameters. Settings and parameters are changed using the pushbuttons on the PLC. The pushbuttons are A, B, ESC, OK, +, and -.

4.3.2 Pushbuttons:

"A" button: Pressing this button will scroll through the screens programmed into the PLC. On the last screen, pressing the "A" button will return the display to the first screen.

"B" Button: This button is used on certain screens to reset the counters on that screen to zero.
"OK" Button: When a value on the display is flashing, pressing the "OK" button will allow the operator to enter the edit menu allowing the value displayed to be changed. After changing the value, pressing the "OK" button again will enter the value into the PLC.
"ESC" Button: This button will exit the editing menu and will return to the default condition for the screen.
"+" Button: On certain screens, multiple variables are shown. Pressing this button will highlight the next variable. In edit mode, the "+" button will increment the value that is highlighted.
"-" Button: This button works just like the "+" button except that it will decrement the value being edited.

4.3.3 Screens:

Main Screen: The main screen is the PLC default screen. It shows the current I/O status, the time, and the date. Pressing the "A" button will bring up the next screen.

Outfeed Delay Screen: This screen is for changing the delay on for the outfeed motor when the outfeed sensor is blocked. This is to keep the outfeed motor from starting when a piece of product blocks the sensor for a moment.

Production Count Screen: This keeps the running total of the number of pieces the stacker stacked. The "B" button will reset the count to zero. The "B" button will only reset the count when this screen is displayed.

Sort Screen: This screen contains two variables. To move from one variable to the other, use the "+" and "-" keys. Both functions operate off the Counter PE. The "Trig Delay" is a time delay before the sort actuator is activated after the sort count is complete. The Sort Preset is the number of pieces required for an automatic sort to occur.

External Delay Screen: An external sort or tray signal and may require a time delay before actuating the sort/tray actuator. This screen allows the operator to adjust the time delay. **Note**, sort and the tray must have the same delay value.

Tray Pulse Duration Screen: The External Tray Signal uses the same input as the Sort Signal. The difference between the two signals is the duration of the signal. The tray signal is only a short duration pulse long enough to move the linear actuator forward and then back again for one piece of product. A sort signal tells the machine to move the linear actuator over until another signal is recceived. Any signal equal to or greater then the Tray Pulse Duration value is considered a sort signal. Any signal less then the Tray Puslse Duration value is considered a tray pulse.

4.3.4 Inputs and Outputs (I/O):

Inputs:

Input 1: Not Used
Input 2: Start PB input.
Input 3: Stop PB input.
Input 4: Crossfeed PE.
Input 5: Outfeed PE. Must be off for machine to run.
Input 6: Break PE.
Input 7: Mode Vert/Conv. Switch
Input 8: Product Counter PE.
Input 9: Skid Bar Limit Switch. Must be on for the machine to run.

Outputs:

Output 1: Break Solenoids.
Output 2: Not Used.
Output 3: Crossfeed Clutch.
Output 4: Outfeed Clutch.
Output 5: Run Latch. Activates drives and closes stop out relay.

5.0 Operating Instructions

5.1 System Overview: Product enters the infeed conveyor where it is sped up, aligned and driven onto the cross feed conveyor. The main purpose of the infeed conveyor is to make sure product shingles onto the cross feed consistently. If the speed is set too high, the piece will have a tendency to bounce off the balls and not align properly. If the speed is set too low, the piece will not be driven against the steel balls.

The cross feed conveyor is where product shingles. A knockdown plate directs the product underneath a brush and up against two steel balls. A product sensor on the cross feed conveyor detects the trailing edge of the piece and keeps the crossfeed conveyor running as long as it is covered. Once the beam switch becomes uncovered, the cross feed clutch disengages, stopping the crossfeed conveyor. This ensures the next piece will shingle overtop the previous piece. A continuous shingle is required to convert the shingle into a vertical position. The press down rollers on the cross feed section drive the shingled stream into a vertical position. The outfeed conveyor is where edge stacking occurs. Spring-loaded wedges direct the first piece up and against the backstop, then fall underneath the table. The adjustable linkage over the wedge assembly keeps the top of the stack consistent.

5.2 System Setup

1. Center and square the infeed conveyor of the vertical stacking conveyor with the upstream machine.
2. Use the jackscrews (or the optional hydraulic lift kit) to elevate the vertical stacking conveyor to a height where the infeed conveyor is even or just below the supply machine.
3. Connect the power, stop out and contact or volt cables.

5.3 Infeed section

1. Adjust side guides for product width.
2. Adjust skid bar height and jam micro switch..
3. Adjust outfeed pinch roller so that product is driven into the midsection of the knockdown plate.

5.4 Cross feed Section

1. Center the knock down plate with the flow of the product and lock in place. (Depending on the piece, the knock down assembly sometimes works better a little off center).
2. Adjust the front to back position of the knockdown assembly. This adjustment is usually made with the unit in the retracted position. Its position depends on the piece to be run. For longer pieces, move it away from the infeed section. Remember, for the cross feed beam switch to function, the trailing edge of the piece needs to extend between the beam switch and the reflective tape. Very short pieces require placing reflective tape between the vacuum belts and relocating the beam switch to this area.

3. Adjust the height of the knockdown/ball assembly. The setting should accommodate at least two products in a shingle. Make sure the brush is in contact with the belt.

5.5 Outfeed Section

1. The wedges are spring-loaded and will lift up from underneath the table when product is clear above them. Bring the backstop against the wedges.
2. Place a single mail piece against the wedges.
3. Adjust the outfeed proximity switch.
    i. Set the height to one inch below the top of the mail piece.
    ii. Set the distance between the switch and the mail piece to slightly more than 2". If the distance is less than 2", the outfeed conveyor will start and move the backstop downstream causing the wedges to fall away. If edge stacking occurs on the cross feed section, the cross feed belt will jostle the stack sideways.

4. Set the height of the vertical stop bar. Leaving a 1/ 4-1/2" space will allow for a more vertical stack.
5. Ensure the press down roller assembly is centered on the piece.

5.6 System operation

1. Set the infeed and crossfeed speeds to mid range and the outfeed speed at the minimum setting.
    a. The infeed speed needs to be fast enough to drive product into the steel balls. If the speed is set too high, product will rebound off the balls and not shingle consistently. If the speed is set too low, product will not stop against the steel balls. The brush assembly helps reduce bounce back. The brush should be set at a shallow angle to allow the piece to slide by. A steep angle will not allow the piece to slide past the brush. Balance the speed and the height of the brush for best results.
    b. Set the cross feed conveyor speed to keep the clutch from cycling. When the speed is set correctly, the crossfeed conveyor will run smoothly and never stop in between product. If it is set too high, the conveyor will start and stop after each piece. If it set too low, product will build up underneath the knockdown plate and hang up.
    c. Set the outfeed speed to a low setting (about 1 or less on the dial.)
2. Turn the blower on.
3. Make sure all personnel and tools are clear, then press start.
4. Run one product and make necessary adjustments.
5. To use as a conventional conveyor, lift the backstop out of the way and install the ¼" rods at the end of the conveyor. Set the mode switch to "conv" and adjust the speed of the outfeed conveyor to that of the crossfeed conveyor. Run and fine-tune as necessary.

5.7 TROUBLE SHOOTING

Problem	Solution
Machine will not start	Unlatch stop button Check stop circuit cords are properly connected Check speed control is above zero Check outfeed proximity switch is clear
Material does not shingle in a consistent manner	Check infeed conveyor speed. If the speed is set too high, material will bounce off the steel balls. If it is set too low, material will not be driven up against the steel balls. Check the infeed pinch roller. It should drive material down into the knockdown plate. Check the height of the knockdown plate. The height should accommodate several pieces of material. Check brush setting. Set brush to a shallow angle. A steep angle will not allow product underneath. Check blower is on.
Cross feed conveyor does not run smooth	Slow down the cross feed section. The trailing edge of the last piece is clearing the beam switch before the next piece arrives.
The sort is off one piece	Adjust sort signal delay. Adjust position of counter beam switch.
Stack appears to vibrate and jostles to one side.	Adjust stack proximity switch towards the stack. This will move the stack off of the crossfeed belts and onto the outfeed belts.
Stack falls down	Check rubber stripping on backstop. The rubber stripping creates friction between the edge of the backstop and the outfeed belts. The weight of large stacks can make the backstop slip on the belts and not support the stack.

6.0 MAINTENANCE

WARNING

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

6.1 Infeed Conveyor

1. Check table belts for wear and proper tension.
2. Check functionality of jam detector switch.

6.2 Cossfeed Conveyor

1. Remove dust from product sensors and reflector using a clean cloth.
2. Check table belts for wear and proper tension.
3. Check condition of brush on backstop.

6.3 Outfeed Conveyor

1. Check table belts for wear and proper tension.
2. Remove dust from product sensors and reflector using a clean cloth.

7.0 PARTS LISTS AND DIAGRAMS

ASSEMBLY #	DESCRIPTION
KR345L	ASSY, KR345 ON-EDGE STACKER LH
KR345R	ASSY, KR345 ON-EDGE STACKER RH
544193-01	ASSY, UPPER PRODUCT GUIDE LH
544193-02	ASSY, UPPER PRODUCT GUIDE RH
544729-01	ASSY, ROLLER PRODUCT LH
544729-02	ASSY, ROLLER PRODUCT RH
544284-01	ASSY, SHINGLE SECTION LH
544284-02	ASSY, SHINGLE SECTION RH
530656-01	ASSY, VACUUM MANIFOLD
544207-01	ASSY, LINEAR GUIDE BRACKET
544756-01	ASSY, PRODUCT STOP
544287-01	ASSY, IDLER SHAFT LH
544287-02	ASSY, IDLER SHAFT RH
544295-01	ASSY, IDLER CONVEYOR BELT
544498-01	ASSY, SIDGUIDE SHINGLE SECTION
544293-01	ASSY, INFEED SECTION
544492-01	ASSY, SIDEGUIDE INFEED
544567-01	ASSY, SKIDBAR KR345
544454-01	ASSY, KR345 OUTFEED SECTION LH
544454-02	ASSY, KR345 OUTFEED SECTION RH
530610-01	ASSY, TAKEUP 1 IN BELT
530610-02	ASSY, TAKEUP 1 IN BELT
544459-01	ASSY, BACKSTOP LH
544459-02	ASSY, BACKSTOP RH
544469-01	ASSY, CONVEYOR FRAME LH
544469-02	ASSY, CONVEYOR FRAME RH
538171-04	ASSY, 1/4HP GEARHEAD W/CLUTCH
539424-01	ASSY, RH HYDRALIFT LEG
539425-01	ASSY, LH HYDRALIFT LEG
544335-01	ASSY, CONTROL PANEL KR345

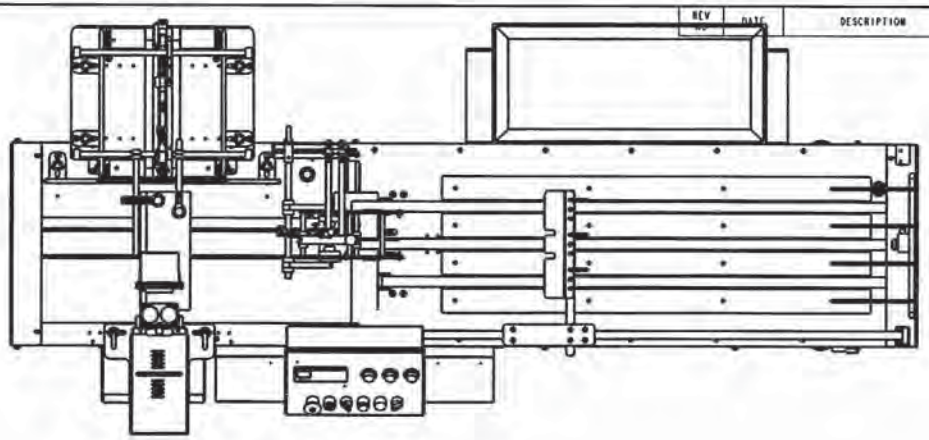
Optional Infeed Extension

544293-02	ASSY, INFEED SECTION
532466-01	ASSY, DRYER ARM PIVOT
546475-01	ASSY, CONVEYOR ANGLED
530619-01	ASSY, IDLER ROLLER
537284-09	ASSY, SKID BAR BUMPTURN
546482-01	ASSY, SIDEGUIDE INCLINE CONVEYOR

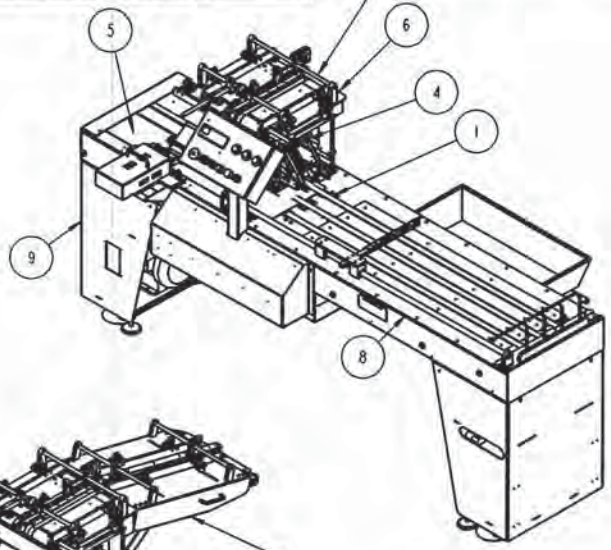
KR345L

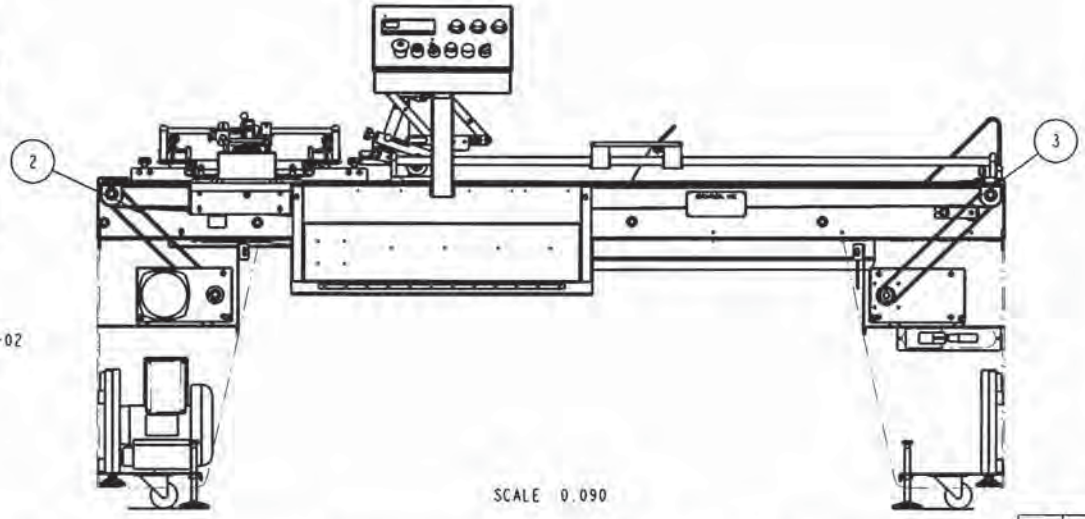
ITEM	QTY	PART #	DESCRIPTION
1	2	106566-6	BELT, FLAT 1 X 110.5
2	1	110020-61	CHAIN, #35 X 31.50"
3	1	110020-62	CHAIN, #35 X 31.50"
4	1	544193-01	ASSY, UPPER PRODUCT GUIDE LH
5	1	544284-01	ASSY, SHINGLE SECTION LH
6	1	544293-01	ASSY, INFEED SECTION
7	1	544293-02	ASSY, INFEED SECTION
8	1	544454-01	ASSY, KR345 OUTFEED SECTION LH
9	1	544469-01	ASSY, CONVEYOR FRAME LH

REV	DATE	DESCRIPTION	ECR NO	BY

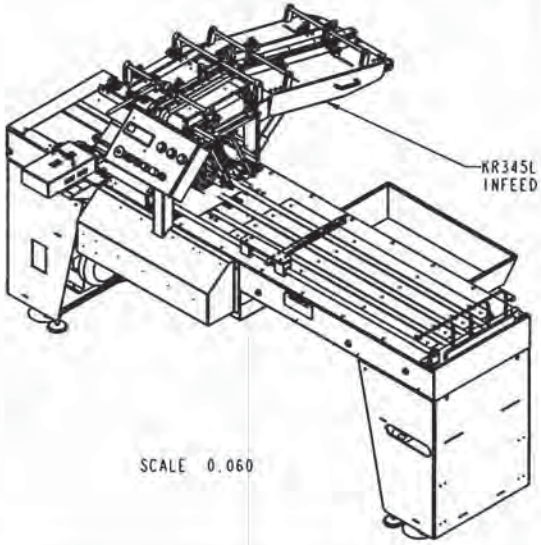


KR345 W/STANDARD INFEED





SCALE 0.090



KR345L W/ EXTENDED
INFEED CONVEYOR ASSY# 546293-02

SCALE 0.060

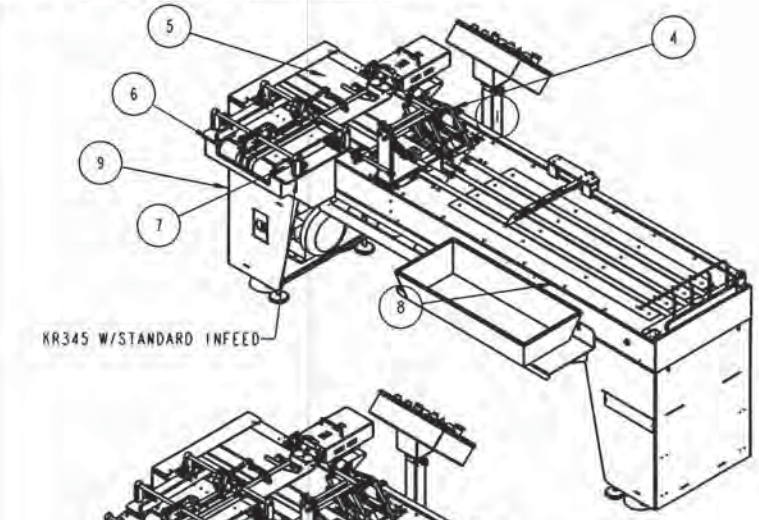
ITEM	XXX
REQ'D	WHERE USED

DRAWN BY: TJG	SCALE: 0.060	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED: .X ±.1, .XX ±.05, .XXX ±.010, ANG ±.5	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. WOODSTOCK, GA 30188 USA	KIRK - RUDY, INC. WOODSTOCK, GEORGIA
CHECKED BY:	DATE: 29-Jul-03	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED	HEAT TREAT: XXX	MODEL: SA184	TITLE: ASSY, KR345 ON-EDGE STACKER LH
TRACED BY:	MASTER	ALL DIMENSIONS ARE FINISHED DIMENSIONS. DO NOT SCALE - WORK TO DIMENSIONS ONLY	FINISH: XXX	SHEET NO. 1 OF 4	DRAWING # KR345L

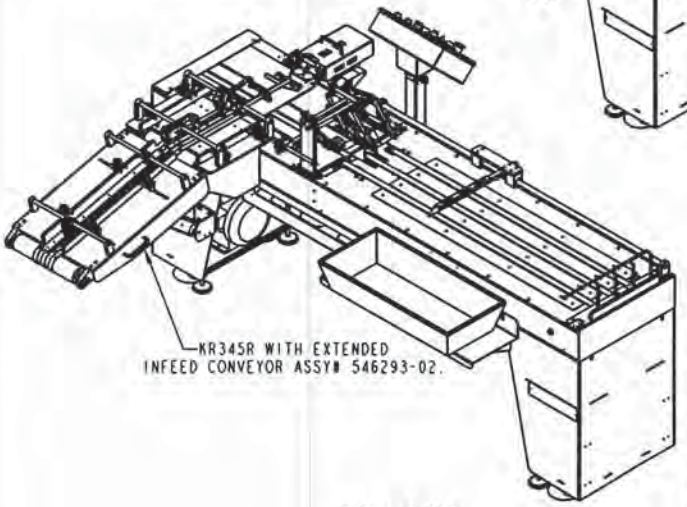
KR345R

ITEM	QTY	PART #	DESCRIPTION
1	2	106566-7	BELT, FLAT 1 X 110.5
2	1	110020-63	CHAIN, #35 X 24.75"
3	1	110020-64	CHAIN, #35 X 31.50"
4	1	544193-02	ASSY, UPPER PRODUCT GUIDE RH
5	1	544284-02	ASSY, SHINGLE SECTION RH
6	1	544293-01	ASSY, INFEED SECTION
7	1	544293-02	ASSY, INFEED SECTION
8	1	544454-02	ASSY, KR345 OUTFEED SECTION RH
9	1	544469-02	ASSY, CONVEYOR FRAME RH

REV NO	DATE	DESCRIPTION	ECN NO	BY

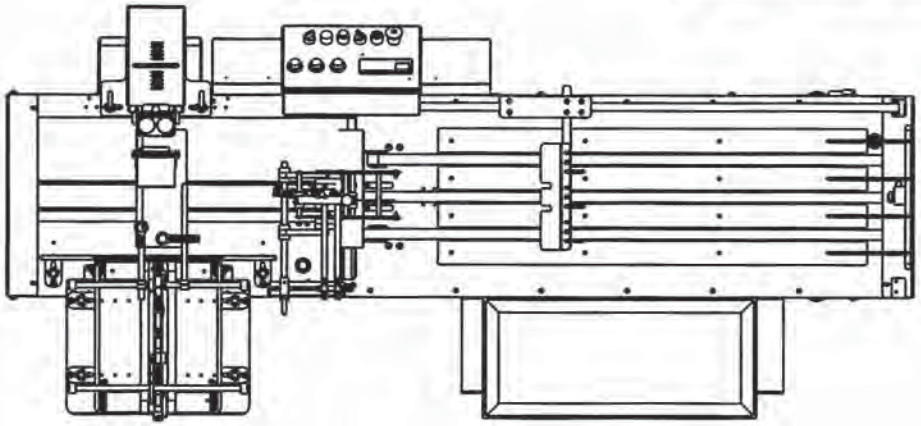


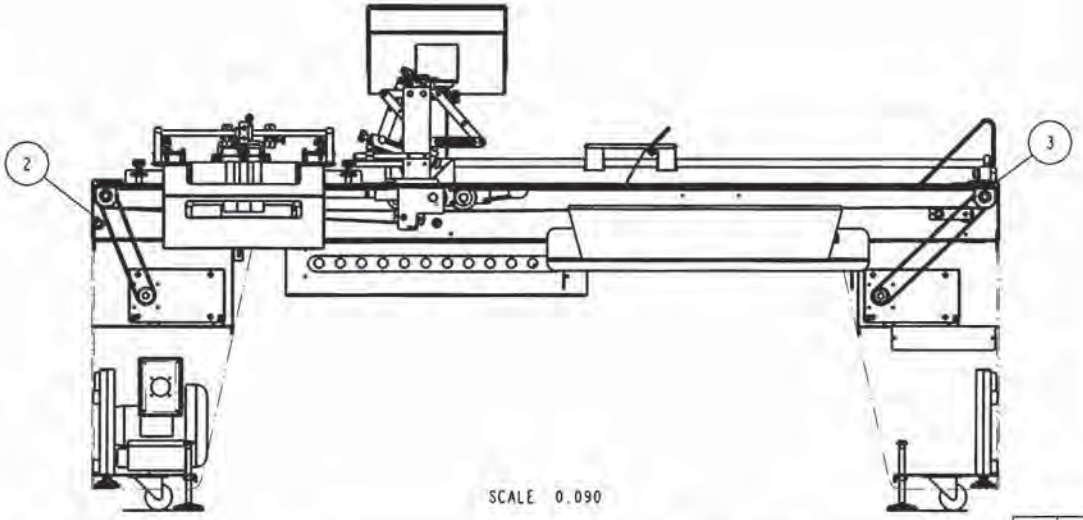
KR345 W/STANDARD INFEED



KR345R WITH EXTENDED INFEED CONVEYOR ASSY# 546293-02.

SCALE 0.060





SCALE 0.090

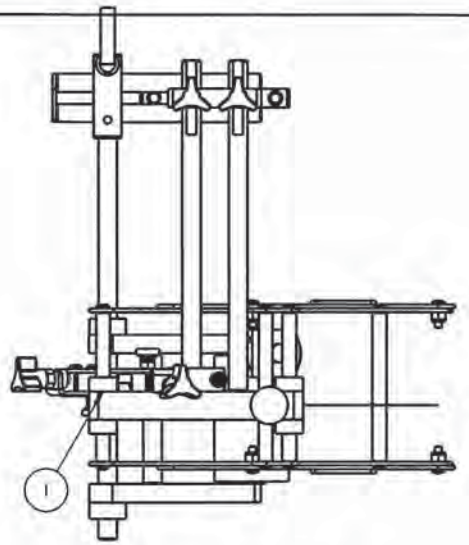
I	III
REQ'D	WHERE USED

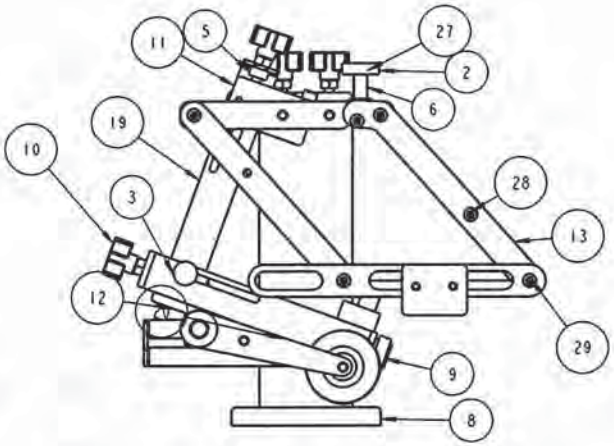
DRAWN BY: TJG	SCALE: 0.060	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED: .X ±.1, .XX ±.05, .XXX ±.5. REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED. ALL DIMENSIONS ARE FINISHED DIMENSIONS. DO NOT SCALE - WORK TO DIMENSIONS ONLY.	MATERIAL: XXX	THIRD ANGLE PROJECTION	PROPRIETARY AND CONFIDENTIAL. NO PORTION OF THIS DRAWING MAY BE QUOTED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC. WOODSTOCK, GA 30188 USA	KIRK - RUDY, INC. WOODSTOCK, GEORGIA
CHECKED BY:	DATE: 29-Jul-03		HEAT TREAT: XXX	MODEL: SA184		TITLE: ASSY, KR345 ON-EDGE STACKER RH
TRACED BY:	MASTER		FINISH: XXX	SHEET NO: 1 OF 4		DRAWING # KR345R

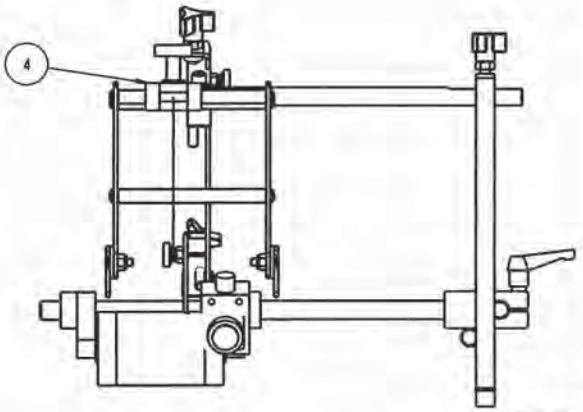
544193-01

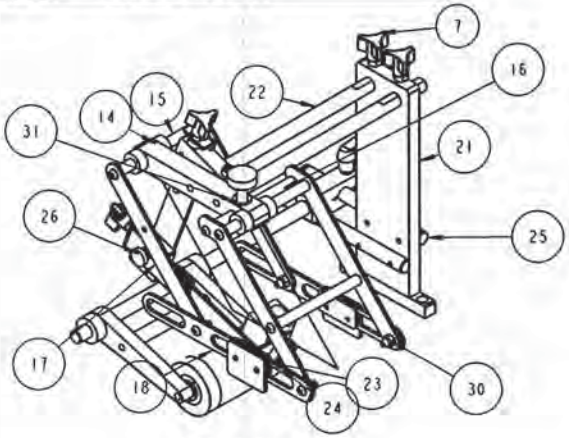
REV NO	DATE	DESCRIPTION	ECN NO	BY

ITEM	QTY	PART #	DESCRIPTION
1	2	100120	BUSHING, SL.3751D.5000D.750LG
2	1	102131	KNOB, THUMB 1/4-20 SHCS
3	2	102132	KNOB, 10-32 CAP SCREW
4	4	102200	COLLAR .375
5	2	102223	COLLAR .250
6	1	102749	SPRING, COMP. .88L. 360D .045W
7	2	500790	ASSY, KNOB
8	1	500794	PLATE-MOUNTING
9	1	202263-7	SENSOR, PERFECT PROX
10	2	500790-3	ASSY, TRI-KNOB 1/4-20 STUD
11	1	532750-01	CLAMP, BEAMSWITCH
12	1	532750-02	CLAMP, BEAMSWITCH
13	2	544194-01	LINK, PRODUCT GUIDE
14	1	544195-01	BAR, UPPER PRODUCT GUIDE
15	3	544196-01	SHAFT, LINK SPACER
16	1	544197-01	SHAFT, LINK SPACER
17	2	544198-01	LINK, PRODUCT GUIDE
18	2	544199-01	LINK, PRODUCT GUIDE
19	1	544200-01	BRACKET, BEAMSWITCH VERTICAL
20	1	544201-01	BRACKET, BEAMSWITCH
21	1	544202-01	BAR, UPPER PRODUCT GUIDE MOUNT
22	2	544203-01	SHAFT, PRODUCT GUIDE MOUNT
23	2	544585-01	PLATE, PRODUCT GUIDE
24	2	544586-01	PLATE, THREADED PRODUCT GUIDE
25	1	544729-01	ASSY, ROLLER PRODUCT LH
26	2	CSDD267	SCREW, SHCS 10-32X.750
27	2	CSDD297	SCREW, SHCS 1/4-20X1.250
28	10	CSFF57	SCREW, BUTTON HEAD #10-32X.375
29	4	CSFF59	SCREW, BUTTON HEAD #10-32X.625
30	6	LOCKNUT_10	8PX STUD
31	1	WA009	WASHER, FLAT 1/4









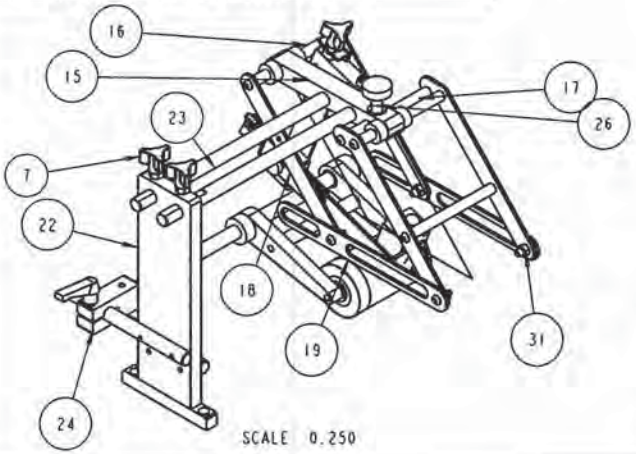
SCALE 0.250

I	III
REQ'D	WHERE USED

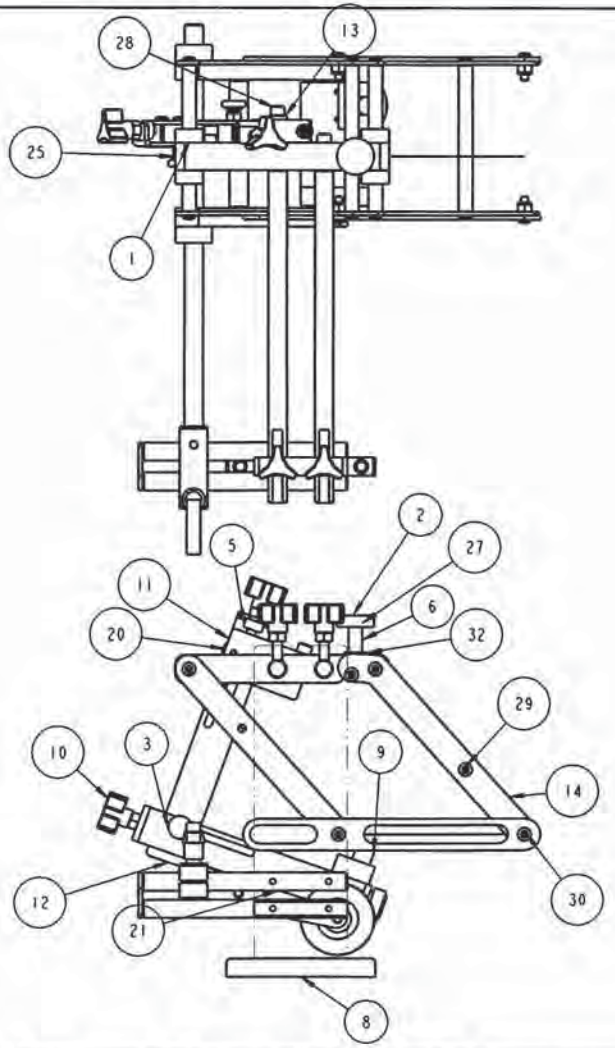
DRAWN BY: TJG	SCALE: 0.312	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED .XX ±.01 .XXX ±.005 ANG ±.5	MATERIAL: XXX	THIRD ANGLE PROJECTION	PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE QUOTED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC. WOODSTOCK, GA 30188 USA	KIRK - RUDY, INC. WOODSTOCK, GEORGIA
CHECKED BY:	DATE: 25-Jul-03	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED	HEAT TREAT: XXX	MODEL: SA184	TITLE: ASSY, UPPER PRODUCT GUIDE LH	
TRACED BY:	MASTER	ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY	FINISH: XXX	SHEET NO: 1 OF 1	DRAWING #: 544193-01	

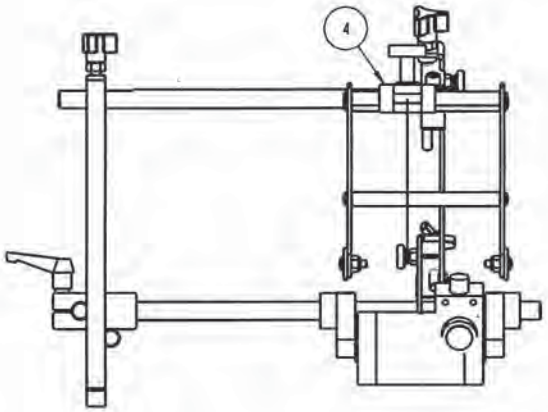
544193-02

ITEM	QTY	PART #	DESCRIPTION
1	2	100120	BUSHING, SL .375ID .500OD .750LG
2	1	102131	KNOB, THUMB 1/4-20 SHCS
3	2	102132	KNOB, 10-32 CAP SCREW
4	4	102200	COLLAR .375
5	2	102223	COLLAR .250
6	1	102749	SPRING, COMP .88L .360D .045W
7	2	500790	ASSY, KNOB
8	1	500794	PLATE-MOUNTING
9	1	202263-7	SENSOR, PERFECT PROX
10	2	500790-3	ASSY, TRI-KNOB 1/4-20 STUD
11	1	532750-01	CLAMP, BEAMSWITCH
12	1	532750-02	CLAMP, BEAMSWITCH
13	1	539684-01	SPACER, TABLETOP
14	2	544194-01	LINK, PRODUCT GUIDE
15	1	544195-01	BAR, UPPER PRODUCT GUIDE
16	3	544196-01	SHAFT, LINK SPACER
17	1	544197-01	SHAFT, LINK SPACER
18	2	544198-01	LINK, PRODUCT GUIDE
19	2	544199-01	LINK, PRODUCT GUIDE
20	1	544200-01	BRACKET, BEAMSWITCH VERTICAL
21	1	544201-01	BRACKET, BEAMSWITCH
22	1	544202-01	BAR, UPPER PRODUCT GUIDE MOUNT
23	2	544203-01	SHAFT, PRODUCT GUIDE MOUNT
24	1	544729-02	ASSY, ROLLER PRODUCT RH
25	2	CSDD267	SCREW, SHCS 10-32X.750
26	1	CSDD296	SCREW, SHCS 1/4-20X1.000
27	2	CSDD297	SCREW, SHCS 1/4-20X1.250
28	1	CSDD300	SCREW, SHCS 1/4-20X2.000
29	10	CSFF57	SCREW, BUTTON HEAD #10-32X.375
30	4	CSFF59	SCREW, BUTTON HEAD #10-32X.625
31	6	LOCKNUT_10	8PX STUD
32	1	WA009	WASHER, FLAT 1/4



SCALE 0.250





REV NO	DATE	DESCRIPTION	ECR NO	BY

ITEM	KR345R
REQ'D	WHERE USED

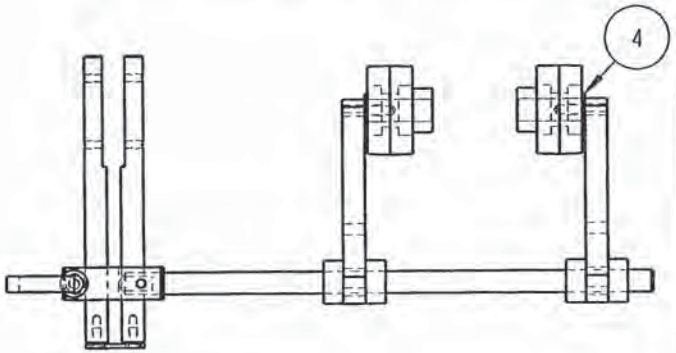
DRAWN BY: TJG	SCALE: 0.312	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED .XX .XXX ANG .01 .005 .5 REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY	MATERIAL: XXX	THIRD ANGLE PROJECTION	PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE QUOTED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC. WOODSTOCK, GA 30188 USA	KIRK - RUDY, INC. WOODSTOCK, GEORGIA
CHECKED BY:	DATE: 25-Jul-03		HEAT TREAT: XXX	MODEL: SA184	TITLE: ASSY, UPPER PRODUCT GUIDE RH
TRACED BY:	MASTER		FINISH: XXX	SHEET NO: 1OF1	DRAWING #: 544193-02

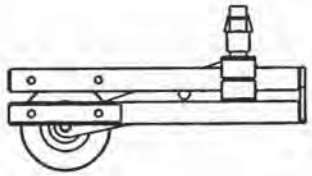
DRAWING #

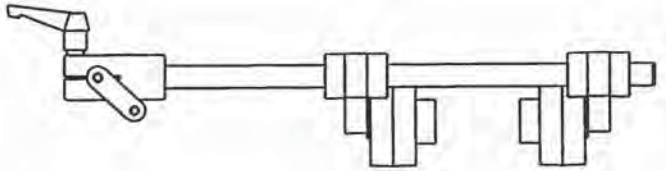
544729-01

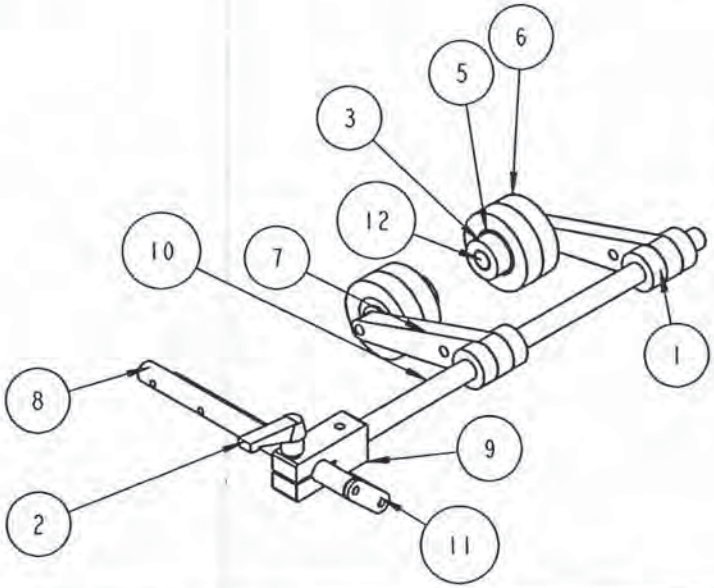
ITEM	QTY	PART #	DESCRIPTION
1	2	100135	BUSHING, SL.500ID.625OD.500LG
2	1	102140	HANDLE, RELEASE 1/4-20 X 1.0
3	6	102205	COLLAR .500
4	2	102302	SHIM, .500X.750X.062
5	4	103108	BEARING, FLAT .500
6	2	515288	ROLLER, BELT CROWN IN EXTENSION
7	2	500801-22	LINK, PINCH ROLLER
8	2	544730-01	SHAFT, ROLLER SUPPORT
9	1	544731-01	CLAMP, ROLLER SUPPORT
10	1	544732-01	SHAFT, ROLLER SUPPORT
11	1	544733-01	PLATE, SHAFT SUPPORT
12	2	544734-02	SHAFT, SPACER LINK

REV NO	DATE	DESCRIPTION	ECN NO	BY
1	3/2/2004	REPLACE 544734-01 WITH 544734-02. ADDED COLLARS	7034	TJG









X	XXX
REQ'D	WHERE USED

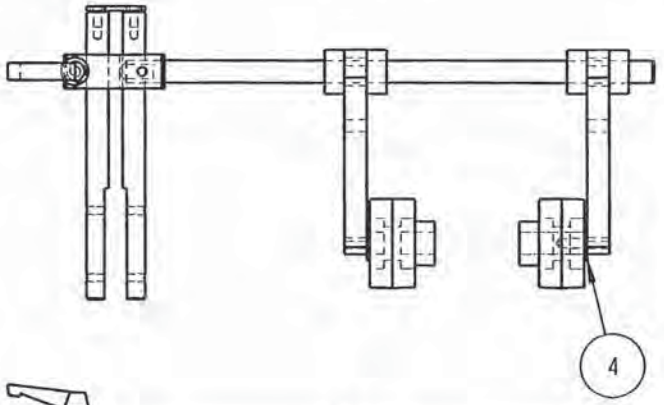
DRAWN BY: TJG	SCALE 0.250	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED .XX .XXX ANG. .01 .005 .5 REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY	MATERIAL: XXX HEAT TREAT: XXX FINISH: XXX	THIRD ANGLE PROJECTION	PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE QUOTED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC. WOODSTOCK, GA 30188 USA	KIRK - RUDY, INC. WOODSTOCK, GEORGIA
CHECKED BY:	DATE 06-Oct-03			MODEL: SA184	TITLE: ASSY, ROLLER PRODUCT LH	
TRACED BY:	MASTER			SHEET NO.: 1OF1	DRAWING # 544729-01	

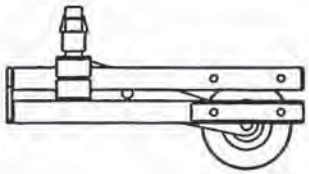
DRAWING #

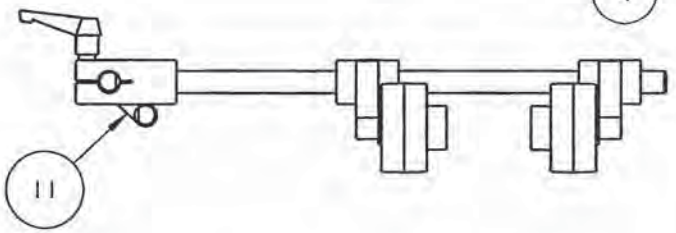
544729-02

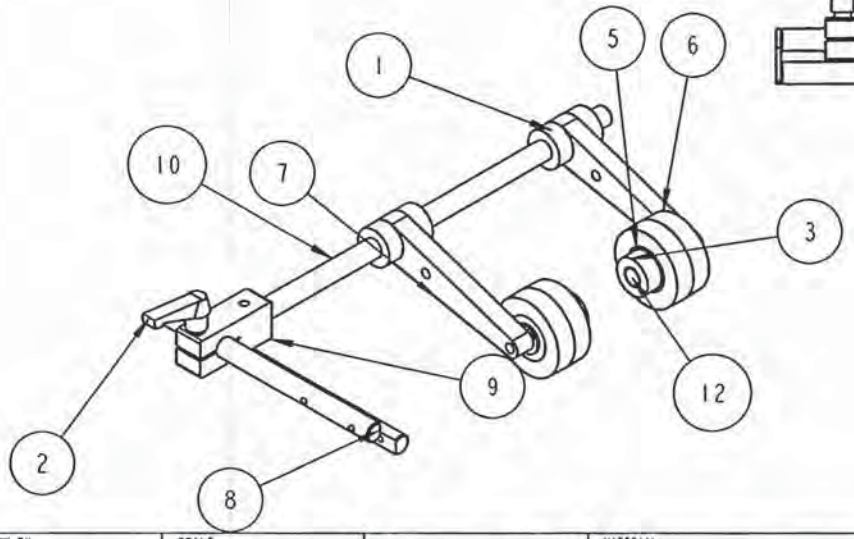
ITEM	QTY	PART #	DESCRIPTION
1	2	100135	BUSHING, SL.500ID.625OD.500LG
2	1	102140	HANDLE, RELEASE 1/4-20 X 1.0
3	6	102205	COLLAR .500
4	2	102302	SHIM, .500X.750X.062
5	4	103108	BEARING, FLAT .500
6	2	515288	ROLLER, BELT CROWN IN EXTENSION
7	2	500801-22	LINK, PINCH ROLLER
8	2	544730-01	SHAFT, ROLLER SUPPORT
9	1	544731-01	CLAMP, ROLLER SUPPORT
10	1	544732-01	SHAFT, ROLLER SUPPORT
11	1	544733-01	PLATE, SHAFT SUPPORT
12	1	544734-02	SHAFT, ROLLER MOUNT

REV NO	DATE	DESCRIPTION	ECN NO	BY
1	3/2/2004	REPLACE 544734-01 WITH 544734-02. ADDED COLLARS	7034	TJG









X	XXX
REQ'D	WHERE USED

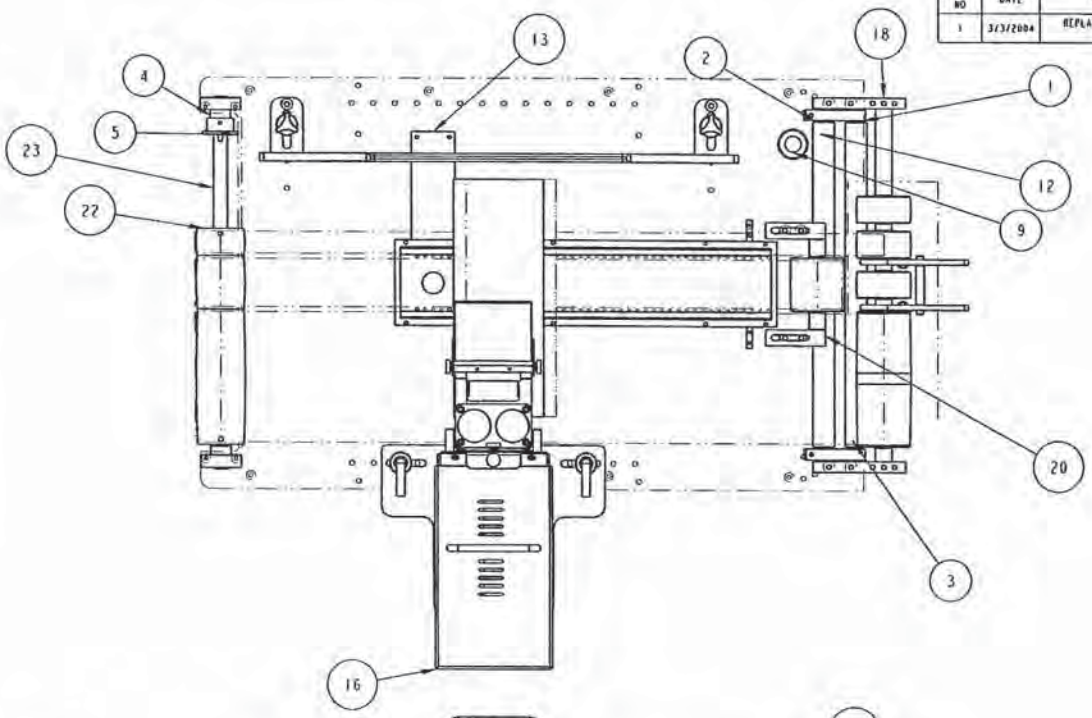
DRAWN BY: TJG	SCALE 0.250	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED .XX .01 / .XXX .005 / ANG. .5 REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY	MATERIAL: XXX HEAT TREAT: XXX FINISH: XXX	THIRD ANGLE PROJECTION	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., WOODSTOCK, GA 30188 USA	KIRK - RUDY, INC. WOODSTOCK, GEORGIA
CHECKED BY:	DATE 06-Oct-03			MODEL: SA184	TITLE: ASSY, ROLLER PRODUCT RH	
TRACED BY:	MASTER			SHEET NO.: 1OF1	DRAWING # 544729-02	

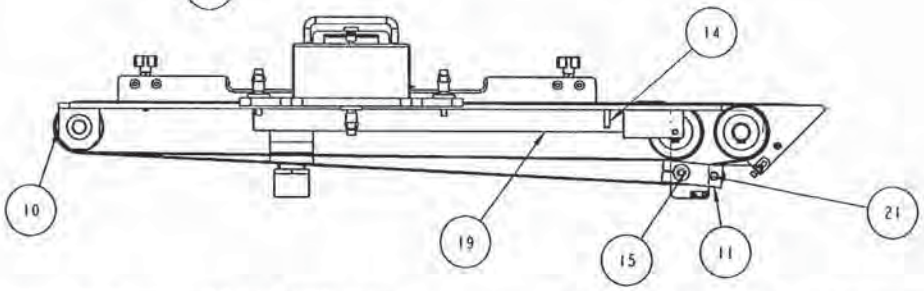
DRAWING #

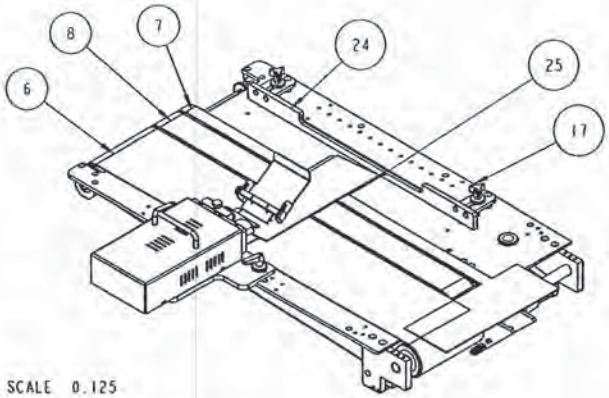
544284-01

ITEM	QTY	PART #	DESCRIPTION
1	2	102305	SHIM, .375X.625X.094
2	2	102306	SHIM, .375X.625X.031
3	4	103106	BEARING, FLAT .375
4	2	103804	BEARING, HUB .625
5	1	110742	SPRKT, 35B12 .625B .188K
6	1	111839-2	BELT, FLAT 6 X 68.75
7	1	111840-2	BELT, FLAT 1 X 68.75"
8	1	111841-2	BELT, FLAT 2.25 X 62.00
9	1	200513-5	GROMMET, RUBBER .751DX1.3750DX.56TH
10	2	500819-2	BLOCK, BEARING
11	2	504949-3	TAKEUP, CLAMP BELT
12	2	507262-8	ROLLER, TRANSFER
13	1	530656-01	ASSY, VACUUM MANIFOLD
14	2	536770-02	BLOCK, ADJUSTMENT ROLLER
15	2	538970-01	STUD, ROLLER IDLER
16	1	544207-01	ASSY, LINEAR GUIDE BRACKET
17	1	544285-01	TABLETOP, VACUUM CENTER
18	1	544287-01	ASSY, IDLER SHAFT LH
19	1	544294-01	BLOCK, VACUUM 4" WIDE
20	1	544295-01	ASSY, IDLER CONVEYOR BELT
21	1	544298-01	SHAFT, ROLLER IDLER
22	1	544451-01	ASSY, ROLLER DRIVER CROWNED
23	1	544456-01	SHAFT, FRONT ROLLER
24	1	544498-01	ASSY, SIDEGUIDE SHINGLE SECTION
25	3	ENVELOPE-PRODUCT	ENVELOPE, NO. 10

REV NO	DATE	DESCRIPTION	ECN NO	BY
1	3/3/2004	REPLACE 536770-01 WITH 536770-02	7034	TJG







SCALE 0.125

1	XR345L
REQ'D	WHERE USED

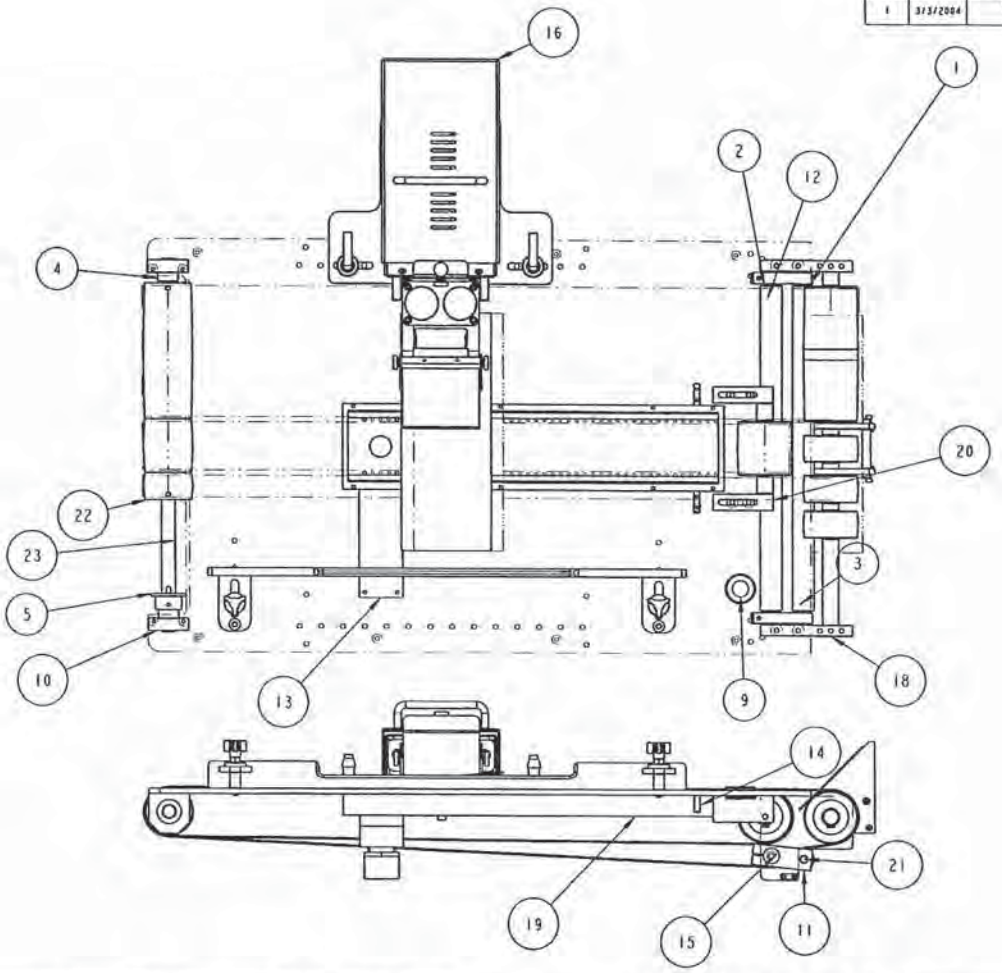
DRAWN BY: TJG	SCALE: 0.188	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED: .XX ±.010, .XXX ±.005, ANG. ±.5. REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED. ALL DIMENSIONS ARE FINISHED DIMENSIONS. DO NOT SCALE - WORK TO DIMENSIONS ONLY	MATERIAL: NOTED	THIRD ANGLE PROJECTION	PROPRIETARY AND CONFIDENTIAL. NO PORTION OF THIS DRAWING MAY BE QUOTED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC. WOODSTOCK, GA 30188 USA
CHECKED BY:	DATE: 25-Jul-03		HEAT TREAT: NONE	MODEL: SA184	KIRK - RUDY, INC. WOODSTOCK, GEORGIA
TRACED BY:	MASTER:		FINISH: NOTED	SHEET NO: 1OF1	TITLE: ASSY, SHINGLE SECTION LH
					DRAWING #: 544284-01

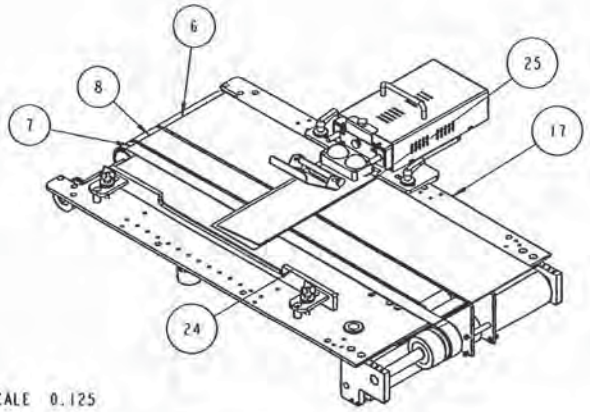
DRAWING #

544284-02

ITEM	QTY	PART #	DESCRIPTION
1	2	102305	SHIM, .375X.625X.094
2	2	102306	SHIM, .375X.625X.031
3	4	103106	BEARING, FLAT .375
4	2	103804	BEARING, HUB .625
5	1	110742	SPRKT, 35B12 .625B .188K
6	1	111839-3	BELT, FLAT 6 X 68.75
7	1	111840-3	BELT, FLAT 1 X 68.75"
8	1	111841-3	BELT, FLAT 2.25 X 62.00
9	1	200513-5	GROMMET, RUBBER .751DX1.375ODX.56TH
10	2	500819-2	BLOCK, BEARING
11	2	504949-3	TAKEUP, CLAMP BELT
12	2	507262-8	ROLLER, TRANSFER
13	1	530656-01	ASSY, VACUUM MANIFOLD
14	2	536770-02	BLOCK, ADJUSTMENT ROLLER
15	2	538970-01	STUD, ROLLER IDLER
16	1	544207-01	ASSY, LINEAR GUIDE BRACKET
17	1	544285-01	TABLETOP, VACUUM CENTER
18	1	544287-02	ASSY, IDLER SHAFT RH
19	1	544294-01	BLOCK, VACUUM 4" WIDE
20	1	544295-01	ASSY, IDLER CONVEYOR BELT
21	1	544298-01	SHAFT, ROLLER IDLER
22	1	544451-01	ASSY, ROLLER DRIVER CROWNED
23	1	544456-01	SHAFT, FRONT ROLLER
24	1	544498-01	ASSY, SIDEGUIDE SHINGLE SECTION
25	3	ENVELOPE-PRODUCT	ENVELOPE, NO. 10

REV NO	DATE	DESCRIPTION	ECN NO	BY
1	3/3/2004	REPLACE 536770-01 WITH 536770-02	7034	TJG





SCALE 0.125

1	KR345R
REQ'D	WHERE USED

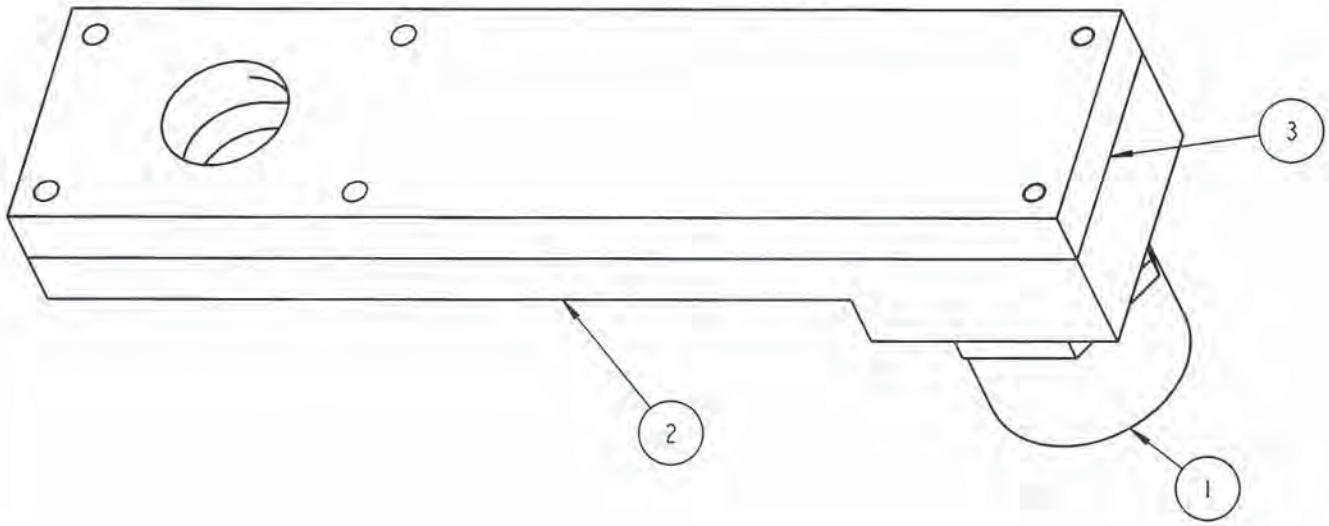
DRAWN BY: TJG	SCALE 0.188	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED .XX ±.01 / .XXX ±.005 / ANG. ±.5	MATERIAL: NOTED	THIRD ANGLE PROJECTION	PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE COPIED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC. WOODSTOCK, GA 30188 USA	KIRK - RUDY, INC. WOODSTOCK, GEORGIA
CHECKED BY:	DATE 25-Jul-03	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED	HEAT TREAT: NONE	MODEL: SA184	TITLE: ASSY, SHINGLE SECTION RH	
TRACED BY:	MASTER	ALL DIMENSIONS ARE FINISHED DIMENSIONS. DO NOT SCALE - WORK TO DIMENSIONS ONLY.	FINISH: NOTED	SHEET NO. 1OF1	DRAWING # 544284-02	

DRAWING #

530656-01

ITEM	QTY	PART #	DESCRIPTION
1	1	190715	PVC COUPLING
2	1	SP28217-1	BLOCK, LOWER VACUUM
3	1	SP28218-1	BLOCK, UPPER VACUUM

REV NO	DATE	DESCRIPTION	ECN NO	BY



X	ALL
REQ'D	WHERE USED

DRAWN BY: RHM

SCALE: 0.750

DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED

.XX	.XXX	ANG.
.01	.005	.5

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.
WOODSTOCK, GA 30188 USA

KIRK - RUDY, INC.
WOODSTOCK, GEORGIA

CHECKED BY:

DATE: 28-Jul-98

HEAT TREAT: NONE

MODEL: 215

TITLE: ASSY, VACUUM MANIFOLD

TRACED BY:

MASTER

REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED

ALL DIMENSIONS ARE FINISHED DIMENSIONS

DO NOT SCALE - WORK TO DIMENSIONS ONLY

FINISH: NONE

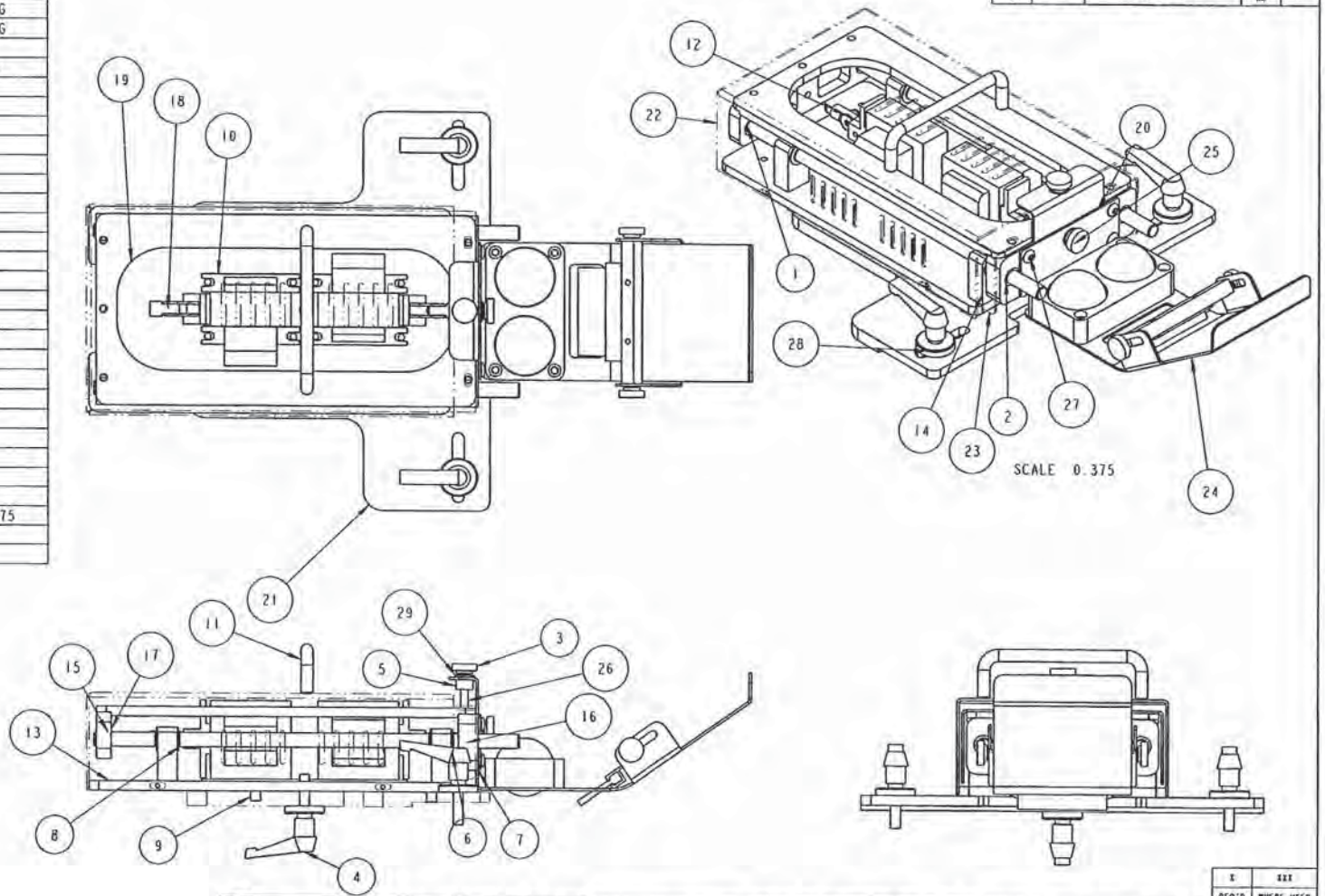
SHEET NO.: 1OF1

DRAWING #: 530656-01

DRAWING # 544207-01

ITEM	QTY	PART #	DESCRIPTION
1	2	100101	BUSHING, SL.3751D.5000D.375LG
2	2	100129	BUSHING, SL.3751D.5000D.500LG
3	2	102132	KNOB, 10-32 CAP SCREW
4	3	102140	HANDLE, RELEASE 1/4-20 X 1.0
5	1	102210	COLLAR .188
6	8	102306	SHIM, .375X.625X.031
7	4	102575	SHIM, .250X.500X.010
8	8	104100	SNAPRING, .375
9	2	105415	DOWEL, PIN .250X.500
10	2	190003	SOLENOID, 120VAC
11	1	190955	HANDLE
12	4	40CHAINPLA	PLATE, #40 CHAIN LINK
13	1	544208-01	PLATE, LINEAR ACTUATOR
14	4	544209-01	BAR, LINEAR SHAFT MOUNT
15	2	544210-01	SHAFT, LINEAR GUIDE
16	1	544211-01	BAR, LINEAR GUIDE
17	1	544211-02	BAR, LINEAR GUIDE
18	2	544213-01	SHAFT, SOLENOID CONNECTOR
19	1	544214-01	PLATE, SOLENOID SLIDE
20	1	544217-01	PLATE, BRACKET RETAINER
21	1	544220-01	BRACKET, LINEAR ACTUATOR
22	1	544221-01	COVER, SOLENOID
23	1	544283-01	COVER, LINEAR SHAFT
24	1	544756-01	ASSY, PRODUCT STOP
25	1	CSDD264	SCREW, SHCS 10-32X.375
26	1	CSDD270	SCREW, SHCS 10-32X1.250
27	4	CSFF57	SCREW, BUTTON HEAD #10-32X.375
28	3	SP6383-1	SPACER, GEAR COVER
29	2	WA006	WASHER, FLAT #10

REV NO	DATE	DESCRIPTION	ECN NO	BY



I	III
REQ'D	WHERE USED

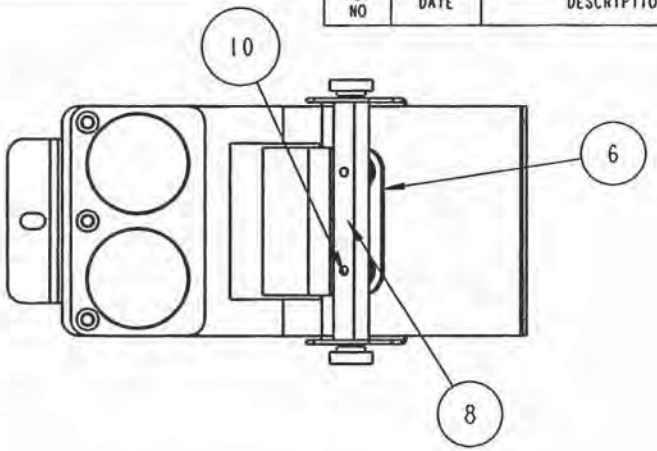
DRAWN BY: TJG	SCALE: 0.375	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED .XX ±.01 .XXX ±.005 ANG. ±.5 REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY	MATERIAL: XXX	THIRD ANGLE PROJECTION	PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE QUOTED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC. WOODSTOCK, GA 30188 USA	KIRK - RUDY, INC. WOODSTOCK, GEORGIA
CHECKED BY:	DATE: 25-Jul-03		HEAT TREAT: XXX	MODEL: SA184	TITLE: ASSY, LINEAR GUIDE BRACKET	
TRACED BY:	MASTER: VV		FINISH: XXX	SHEET NO.: 1OF1	DRAWING #: 544207-01	

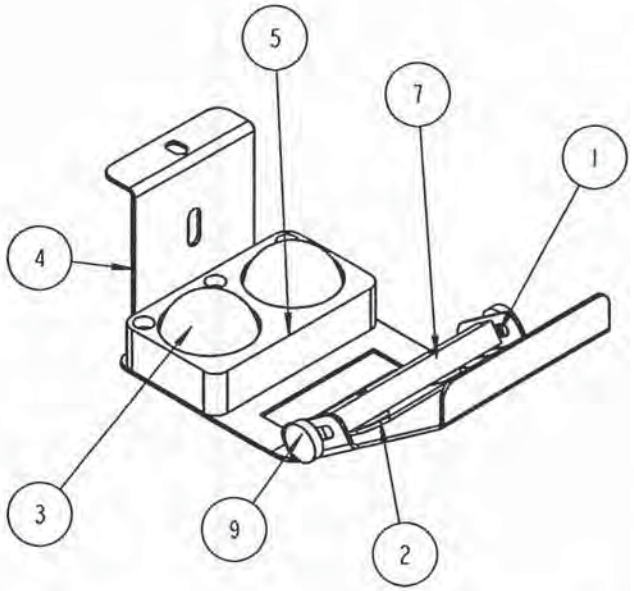
DRAWING #

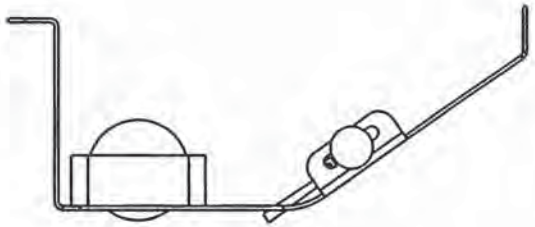
544756-01

ITEM	QTY	PART #	DESCRIPTION
1	2	102132	KNOB, 10-32 CAP SCREW
2	2	102562	SHIM, .25X.500X.062
3	2	191175	STEEL BALL, 1.5" DIAMETER
4	1	544215-03	BRACKET, BALL MOUNT
5	1	544218-01	BLOCK, BALL RETAINER
6	1	544754-01	BRUSH, MOUNT PRODUCT STOP
7	1	544755-01	BRUSH, PRODUCT STOP
8	1	544757-01	BAR, BRUSH ADJUSTMENT
9	2	CSDD264	SCREW, SHCS 10-32X.375
10	2	CSEE227	SCREW, FLATHEAD 8-32X.500

REV NO	DATE	DESCRIPTION	ECN NO	BY







X	XXX
REQ'D	WHERE USED

DRAWN BY: TJG	SCALE 0.375	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED: .XX .01, .XXX .005, ANG. .5	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. WOODSTOCK, GA 30188 USA
CHECKED BY:	DATE 17-Oct-03	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED	HEAT TREAT: XXX	MODEL: KR345	TITLE: ASSY, PRODUCT STOP
TRACED BY:	MASTER	ALL DIMENSIONS ARE FINISHED DIMENSIONS. DO NOT SCALE - WORK TO DIMENSIONS ONLY	FINISH: XXX	SHEET NO.: 1OF1	DRAWING # 544756-01

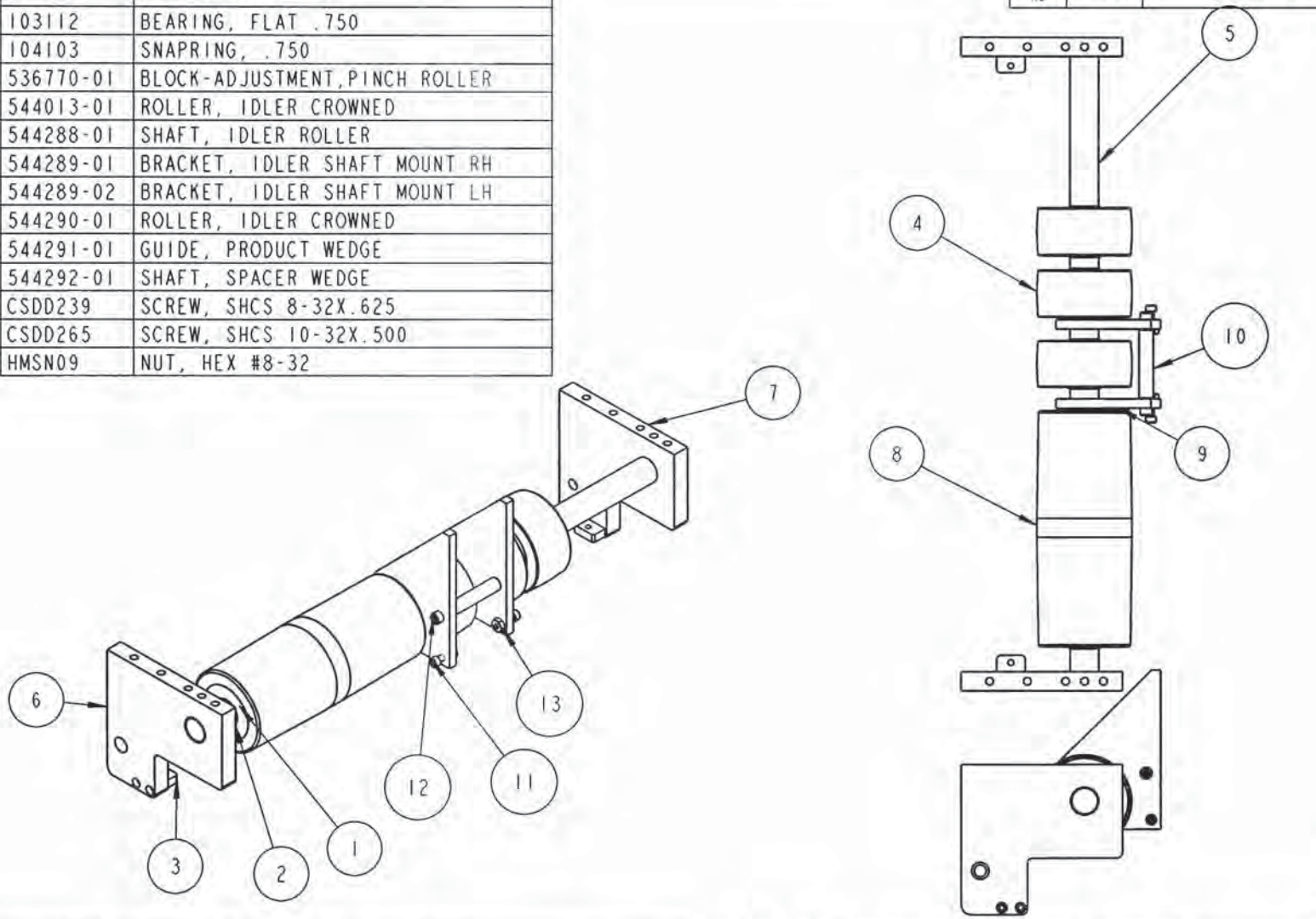
KIRK - RUDY, INC.
WOODSTOCK, GEORGIA

DRAWING #

544287-01

ITEM	QTY	PART #	DESCRIPTION
1	8	103112	BEARING, FLAT .750
2	8	104103	SNAPRING, .750
3	2	536770-01	BLOCK-ADJUSTMENT, PINCH ROLLER
4	3	544013-01	ROLLER, IDLER CROWNED
5	1	544288-01	SHAFT, IDLER ROLLER
6	1	544289-01	BRACKET, IDLER SHAFT MOUNT RH
7	1	544289-02	BRACKET, IDLER SHAFT MOUNT LH
8	1	544290-01	ROLLER, IDLER CROWNED
9	2	544291-01	GUIDE, PRODUCT WEDGE
10	1	544292-01	SHAFT, SPACER WEDGE
11	2	CSDD239	SCREW, SHCS 8-32X.625
12	2	CSDD265	SCREW, SHCS 10-32X.500
13	2	HMSN09	NUT, HEX #8-32

REV NO	DATE	DESCRIPTION	ECN NO	BY



X	XXX
REQ'D	WHERE USED

DRAWN BY: TJG	SCALE 0.250	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED: .XX .01, .XXX .005, ANG. .5	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. WOODSTOCK, GA 30188 USA
CHECKED BY:	DATE 25-Jul-03	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED	HEAT TREAT: XXX	MODEL: SA184	TITLE: ASSY, IDLER SHAFT LH
TRACED BY:	MASTER	ALL DIMENSIONS ARE FINISHED DIMENSIONS. DO NOT SCALE - WORK TO DIMENSIONS ONLY	FINISH: XXX	SHEET NO. 1OF1	DRAWING # 544287-01

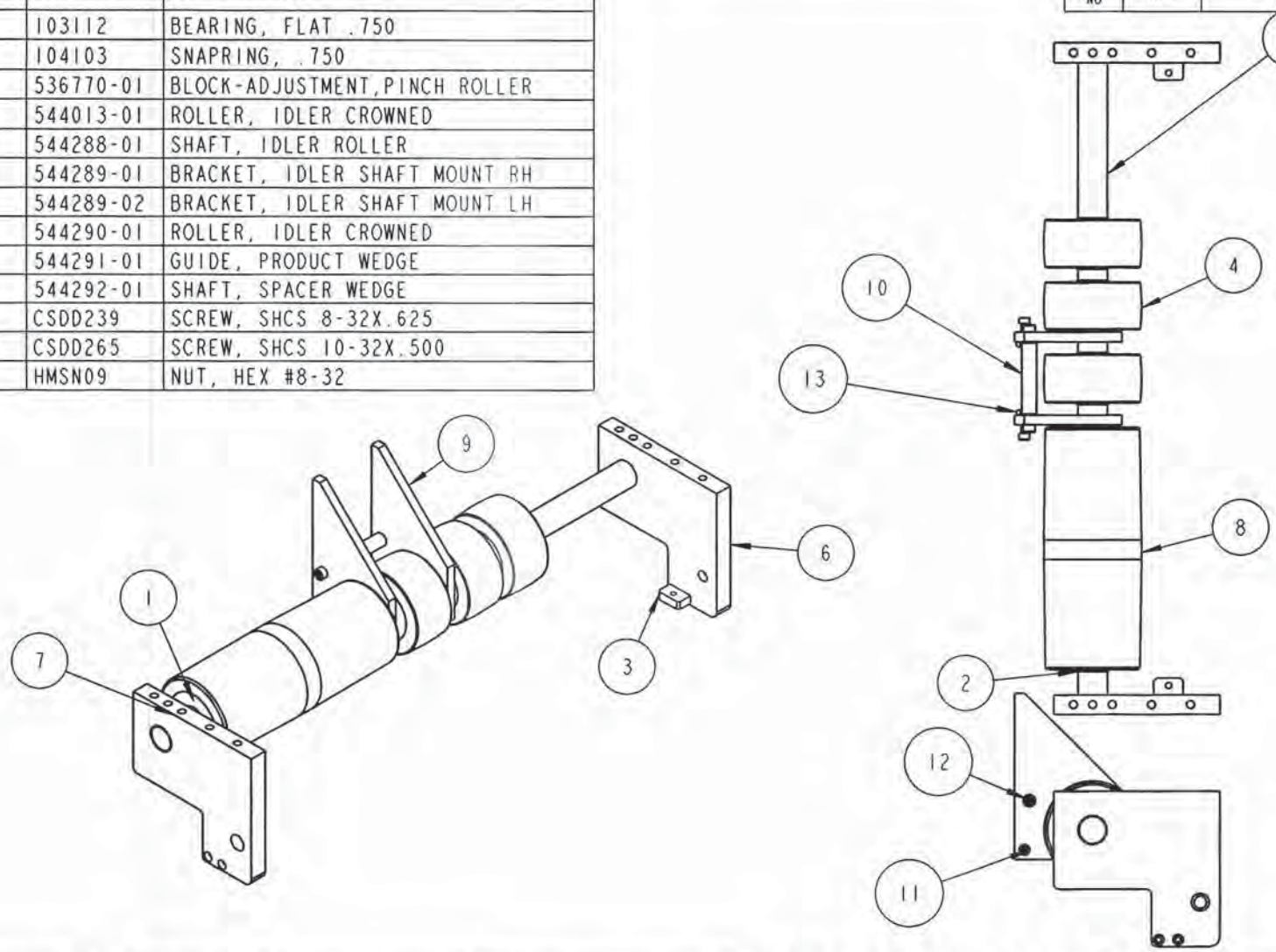
KIRK - RUDY, INC.
WOODSTOCK, GEORGIA

DRAWING #

544287-02

ITEM	QTY	PART #	DESCRIPTION
1	8	103112	BEARING, FLAT .750
2	8	104103	SNAPRING, .750
3	2	536770-01	BLOCK-ADJUSTMENT, PINCH ROLLER
4	3	544013-01	ROLLER, IDLER CROWNED
5	1	544288-01	SHAFT, IDLER ROLLER
6	1	544289-01	BRACKET, IDLER SHAFT MOUNT RH
7	1	544289-02	BRACKET, IDLER SHAFT MOUNT LH
8	1	544290-01	ROLLER, IDLER CROWNED
9	2	544291-01	GUIDE, PRODUCT WEDGE
10	1	544292-01	SHAFT, SPACER WEDGE
11	2	CSDD239	SCREW, SHCS 8-32X.625
12	2	CSDD265	SCREW, SHCS 10-32X.500
13	2	HMSN09	NUT, HEX #8-32

REV NO	DATE	DESCRIPTION	ECN NO	BY



1	KR345
REQ'D	WHERE USED

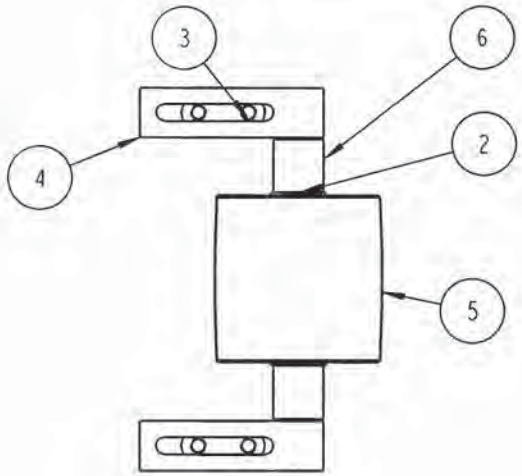
DRAWN BY: TJG	SCALE 0.250	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED .XX .01 / .XXX .005 / ANG. .5 REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY	MATERIAL: XXX HEAT TREAT: XXX FINISH: XXX	THIRD ANGLE PROJECTION	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. WOODSTOCK, GA 30188 USA	KIRK - RUDY, INC. WOODSTOCK, GEORGIA
CHECKED BY:	DATE 25-Jul-03			MODEL: SA184	TITLE: ASSY, IDLER SHAFT RH	
TRACED BY:	MASTER			SHEET NO.: 1OF1	DRAWING #: 544287-02	

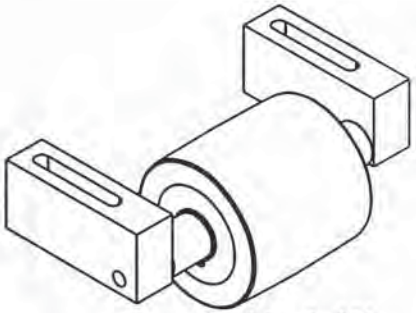
DRAWING #

544295-01

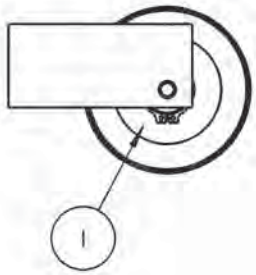
ITEM	QTY	PART #	DESCRIPTION
1	2	103112	BEARING, FLAT .750
2	2	104103	SNAPRING, .750
3	2	542147-02	BAR, THREADED BELT TAKEUP
4	2	544041-01	BRACKET, IDLER SHAFT MOUNT
5	1	544296-01	ROLLER, IDLER CROWNED
6	1	544297-01	SHAFT, IDLER ROLLER

REV NO	DATE	DESCRIPTION	ECN NO	BY





SCALE 0.375



1	KR345
REQ'D	WHERE USED

DRAWN BY: TJG	SCALE 0.375	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED .XX .01 / .XXX .005 / ANG. .5	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. WOODSTOCK, GA 30188 USA
CHECKED BY:	DATE 28-Jul-03	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED	HEAT TREAT: NONE	MODEL: SA184	TITLE: ASSY, IDLER CONVEYOR BELT
TRACED BY:	MASTER	ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY	FINISH: NOTED	SHEET NO.: 1OF1	DRAWING #: 544295-01

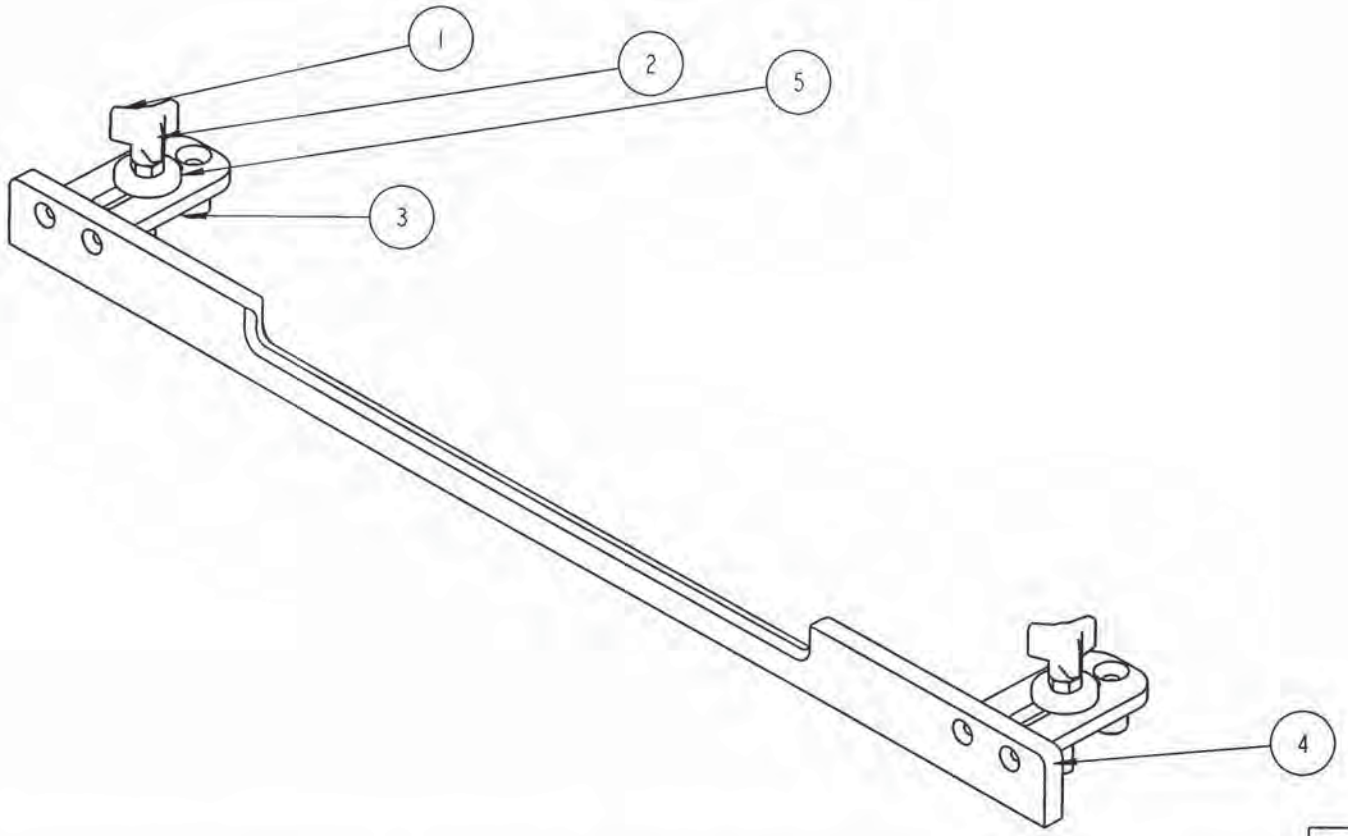
KIRK - RUDY, INC.
WOODSTOCK, GEORGIA

DRAWING #

544498-01

ITEM	QTY	PART #	DESCRIPTION
1	2	500790-1	ASSY, TRI-KNOB 1/4-20 STUD
2	2	541709-01	BRACKET, SIDEGUIDE
3	2	541710-01	SPACER, SIDEGUIDE MOUNT
4	1	544499-01	SIDEGUIDE, INFEED KR345
5	2	SP6383-1	SPACER, GEAR COVER

REV NO	DATE	DESCRIPTION	ECN NO	BY



1	KR345
REQ'D	WHERE USED

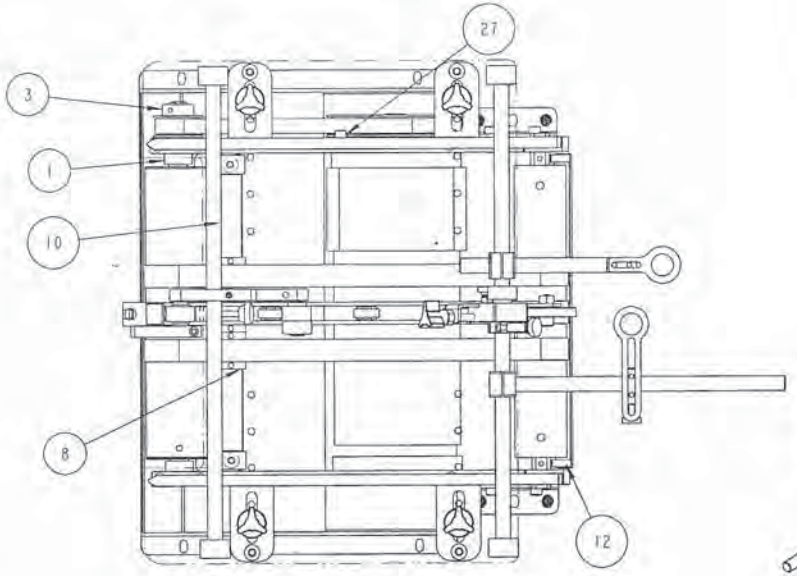
DRAWN BY: TJG	SCALE 0.375	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED .XX .XXX ANG. .01 .005 .5 REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY	MATERIAL: N/A HEAT TREAT: N/A FINISH: N/A	THIRD ANGLE PROJECTION	PROPRIETARY 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 29-Jul-03			MODEL: SA184	TITLE: ASSY, SIDEGUIDE SHINGLE SECTION	
TRACED BY:	MASTER			SHEET NO.: 1OF1	DRAWING # 544498-01	

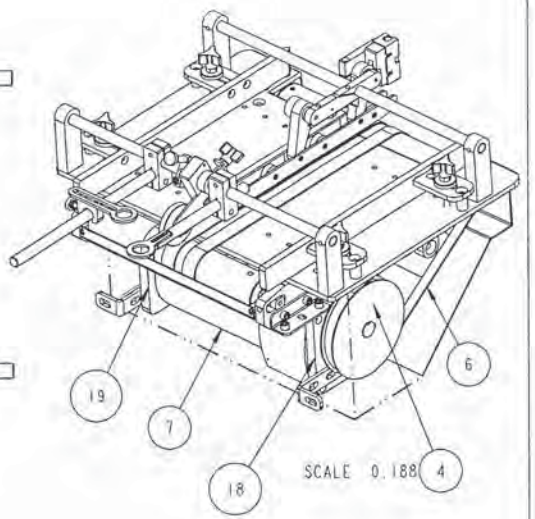
DRAWING #

544293-01

REV NO	DATE	DESCRIPTION	ECN NO	BY

ITEM	QTY	PART #	DESCRIPTION
1	4	103804	BEARING, HUB .625
2	6	105419	DOWEL, PIN .188X1.000
3	1	108888	PULLEY, TIMING 12L050 .625B .188K
4	1	109963	PULLEY, TIMING 36L050 .750B .188K
5	3	105908-16	BELT, FLAT 3/4 X 30.75"
6	1	108937-3	BELT, TIMING 255L050
7	1	200169-2	MOTOR, BODINE 4180
8	3	500725-13	GUIDE, BELT 3/4
9	1	500823-15	SHAFT, IDLER ROLLER
10	1	500824-13	SHAFT-BELT GUIDE
11	2	532163-01	STAND, BELT GUIDE
12	2	533669-02	BLOCK, DEFLECTOR MOUNT
13	1	538434-03	ASSY, DRIVE ROLLER
14	1	544300-01	TABLETOP, INFEED
15	2	544458-01	FRAME, INFEED SECTION
16	1	544471-01	SHAFT, ROLLER DRIVE
17	1	544475-01	ROLLER, IDLER INFEED
18	1	544476-01	PLATE, MOTOR MOUNT LH
19	1	544476-02	PLATE, MOTOR MOUNT RH
20	2	544477-01	BRACKET, L CONVEYOR MOUNT
21	1	544478-01	WLDMNT, INFEED SECTION COVER
22	2	544479-01	BRACKET, L CONVEYOR MOUNT
23	1	544492-01	ASSY, SIDEGUIDE INFEED
24	1	544501-01	COVER, ROLLER GUARD
25	4	CSDD291	SCREW, SHCS 1/4-20X.375
26	4	CSDD293	SCREW, SHCS 1/4-20X.625
27	4	CSDD296	SCREW, SHCS 1/4-20X1.000





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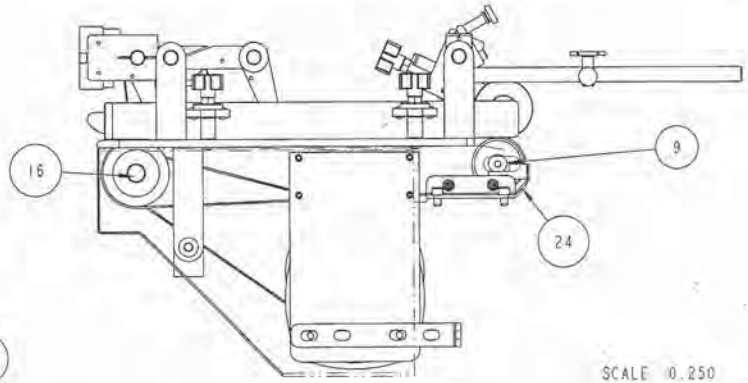
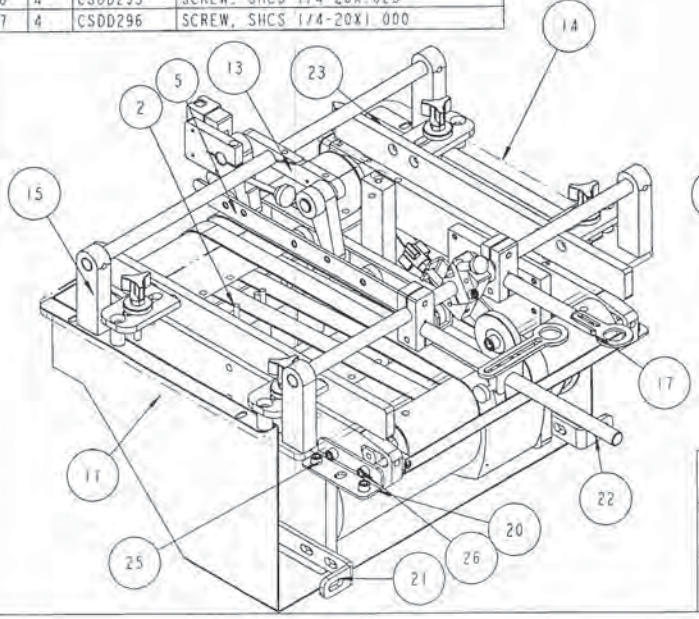


SCALE 0.250



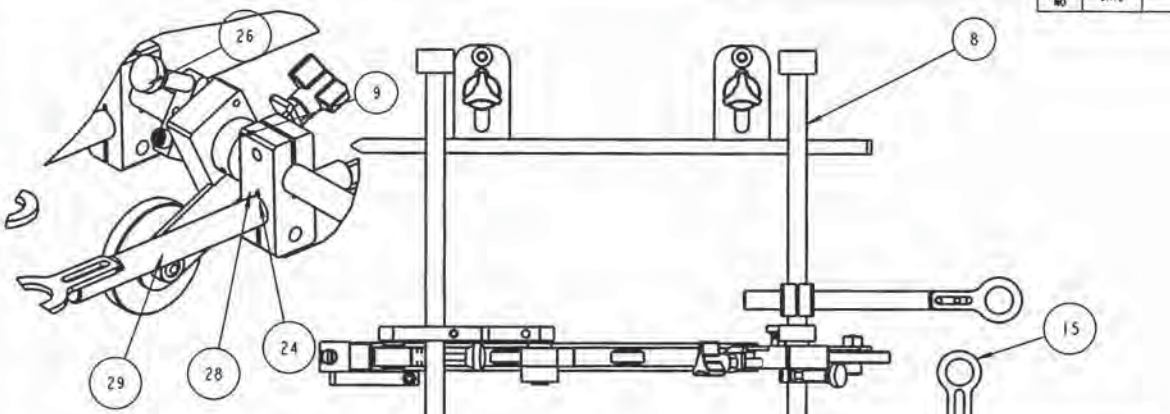
1	KR345
REQ'D	WHERE USED

DRAWN BY: TJG	SCALE: 0.250	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED: .XX ±.010, .XXX ±.005, ANG. ±.5; REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED; ALL DIMENSIONS ARE FINISHED DIMENSIONS; DO NOT SCALE - WORK TO DIMENSIONS ONLY	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. WOODSTOCK, GA 30188 USA	KIRK - RUDY, INC. WOODSTOCK, GEORGIA
CHECKED BY:	DATE: 25-Jul-03		HEAT TREAT: NONE	MODEL: SA184	TITLE: ASSY, INFEED SECTION	
TRACED BY:	MASTER		FINISH: NOTED	SHEET NO: 1OF2	DRAWING #: 544293-01	

544492-01

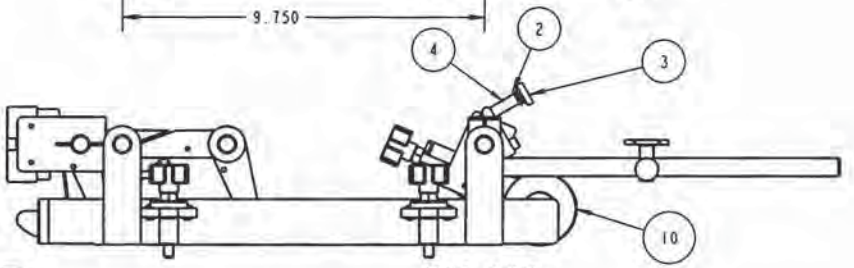
ITEM	QTY	PART #	DESCRIPTION
1	1	100104	BUSHING, SL.500ID .625OD .750LG
2	1	100619	WASHER, FLAT 10-32
3	2	102132	KNOB, 10-32 CAP SCREW
4	1	102714	SPRING, COMPRESSION
5	1	105210	PIN, ROLL .125X.750
6	2	500791	POST, SIDEGUIDE
7	2	508593	CLAMP
8	1	522519	SHAFT, SIDE GUIDE
9	1	102205-3	COLLAR
10	1	500339A	ASSY, ROLLER
11	5	500790-1	ASSY, TRI-KNOB 1/4-20 STUD
12	1	501629-A	ASSY, CLAMP WITH KNOB
13	1	508995-4	SHAFT-BEAMSWITCH MOUNT
14	1	508996-2	PHOTOCELL BRACKET
15	1	508996-4	BRACKET, PHOTOCELL
16	1	532750-03	BLOCK, PINCH ROLLER
17	1	537879-01	BLOCK, SKID BAR ADJUST CLAMP
18	4	541709-01	BRACKET, SIDEGUIDE
19	4	541710-01	SPACER, SIDEGUIDE MOUNT
20	2	544493-01	SIDEGUIDE, INFEED KR345
21	1	544494-01	BAR, PINCH ROLLER SUPPORT
22	1	544500-01	SHAFT, SENSOR MOUNT
23	1	544567-01	ASSY, SKIDBAR KR345
24	1	CSDD267	SCREW, SHCS 10-32X.750
25	1	CSDD269	SCREW, SHCS 10-32X1.000
26	1	CSDD270	SCREW, SHCS 10-32X1.250
27	1	CSDD320	SCREW, SHCS 5/16-18X.750
28	1	LOCKNUT_10-32	BRX STUD
29	1	RHN011	NUT, HEX 5/16
30	4	SP6383-1	SPACER, GEAR COVER

REV NO	DATE	DESCRIPTION	ECN NO	BY

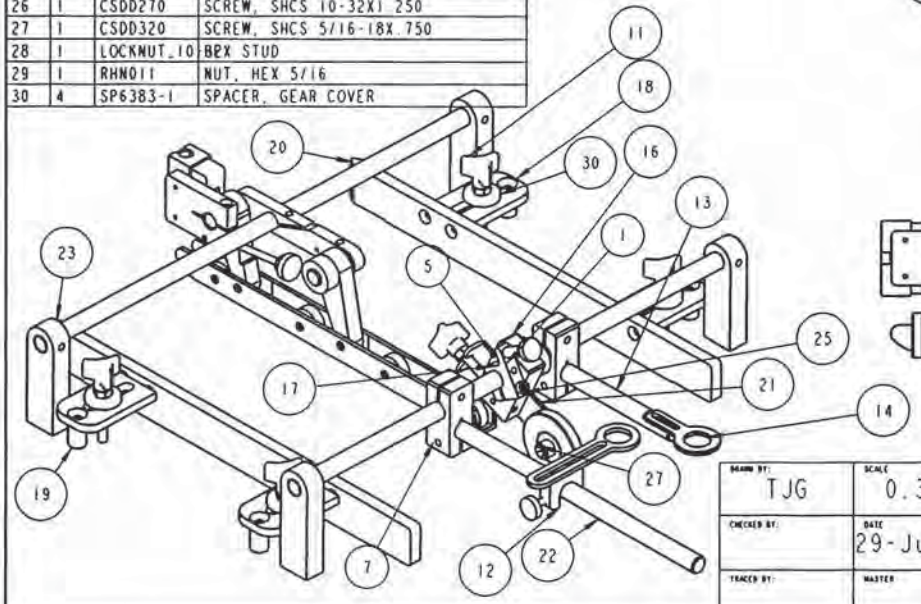


DETAIL A
SCALE 0.500

9.750



SCALE 0.312



1	68345
REQ'D	WHERE USED

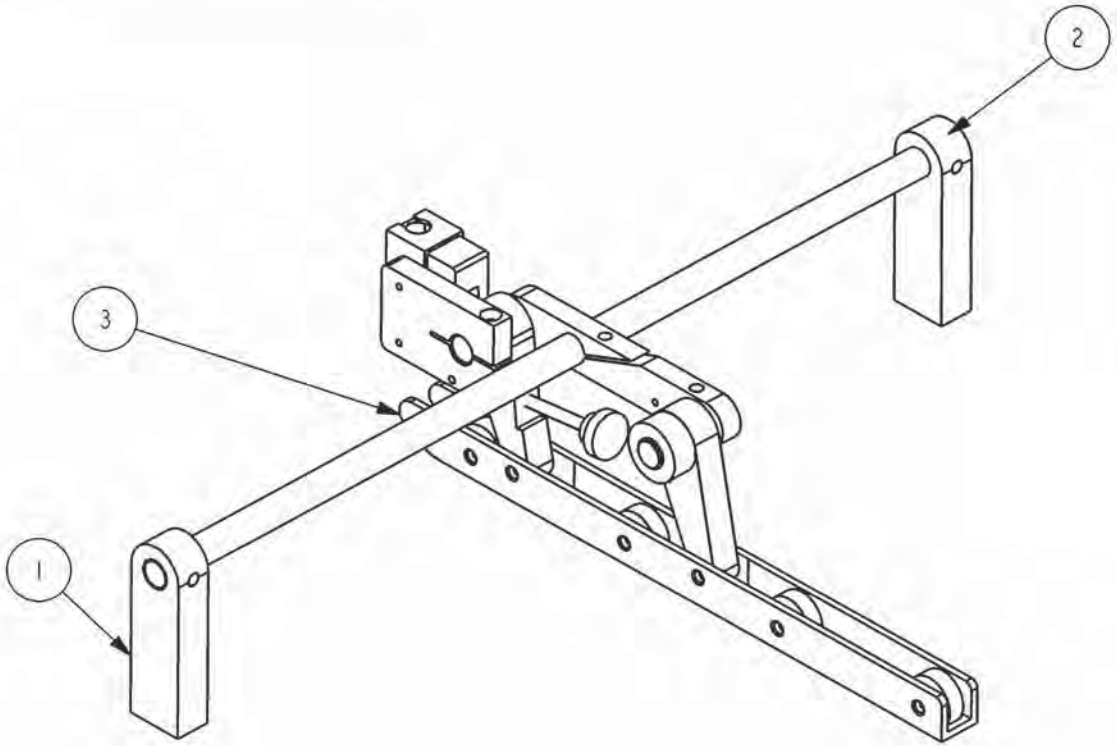
DRAWN BY: TJG	SCALE: 0.312	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED .XX ±.01 .XXX ±.005 ANG ±.5 REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY	MATERIAL: N/A	THIRD ANGLE PROJECTION	PROPRIETARY AND CONFIDENTIAL 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: 29-Jul-03		HEAT TREAT: N/A	MODEL: SA184	TITLE: ASSY, SIDEGUIDE INFEED	
TRACED BY:	MASTER		FINISH: N/A	SHEET NO: 1OF1	DRAWING #: 544492-01	

DRAWING #

544567-01

ITEM	QTY	PART #	DESCRIPTION
1	2	500791	POST, SIDEGUIDE
2	1	522519	SHAFT, SIDE GUIDE
3	1	538021-02	ASSY, SKID BAR

REV NO	DATE	DESCRIPTION	ECN NO	BY



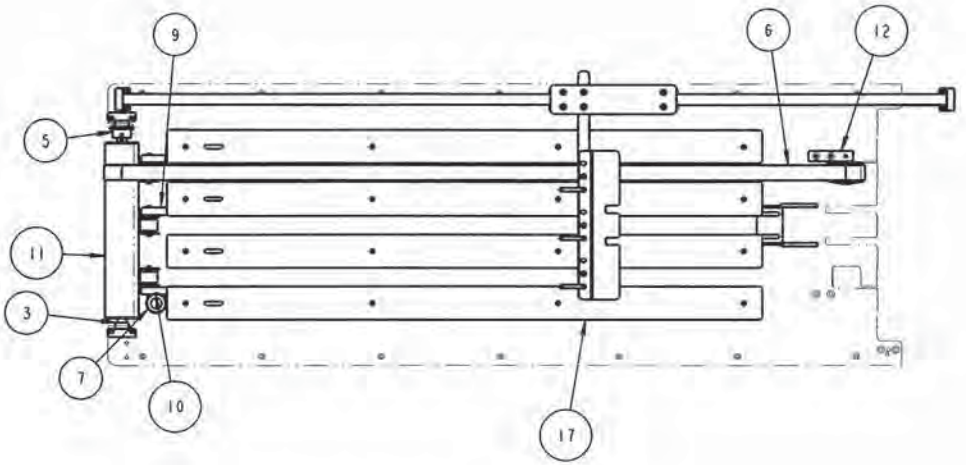
1	XXX
REQ'D	WHERE USED

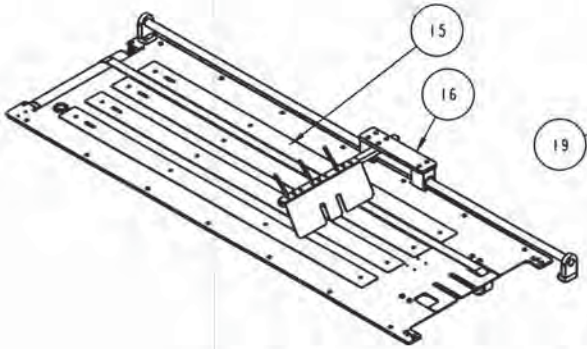
DRAWN BY: TJG	SCALE 0.375	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED .XX .01 / .XXX .005 / ANG .5 REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY	MATERIAL: N/A	THIRD ANGLE PROJECTION	PROPRIETARY AND CONFIDENTIAL 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 12-Sep-03		HEAT TREAT: N/A	MODEL: SA184	TITLE: ASSY, SKIDBAR KR345	
TRACED BY:	MASTER		FINISH: N/A	SHEET NO. 1OF1	DRAWING # 544567-01	

544454-01

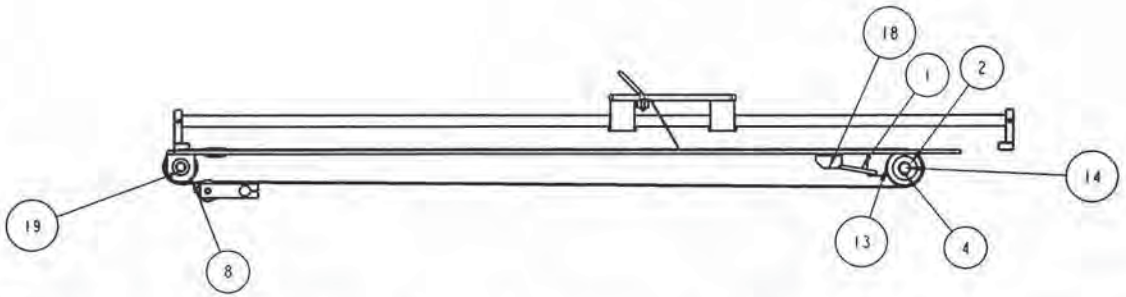
ITEM	QTY	PART #	DESCRIPTION
1	2	102627	SPRING, EXTENSION
2	2	103112	BEARING, FLAT .750
3	2	103804	BEARING, HUB .625
4	2	104103	SNAPRING, .750
5	1	110742	SPRKT, 35B12 .625B .188K
6	1	111842-2	BELT, FLAT 1 X 104.75
7	1	200513-5	GROMMET, RUBBER .751DX1.375ODX.56TH
8	2	500819-2	BLOCK, BEARING
9	2	530610-01	ASSY, TAKEUP 1 IN BELT
10	1	530610-02	ASSY, TAKEUP 1 IN BELT
11	1	530676-01	ASSY, ROLLER FRONT DRIVE
12	1	533975-03	BRACKET, IDLER SHAFT MOUNT
13	1	544013-01	ROLLER, IDLER CROWNED
14	1	544051-01	SHAFT, IDLER ROLLER
15	1	544455-01	TABLETOP, OUTFEED CENTER
16	1	544459-01	ASSY, BACKSTOP LH
17	4	544467-01	GUIDE, BELT TABLETOP
18	1	544490-01	BRACKET, SPRING MOUNT
19	1	544497-01	SHAFT, FRONT ROLLER

REV NO	DATE	DESCRIPTION	ECN NO	BY





SCALE 0.090



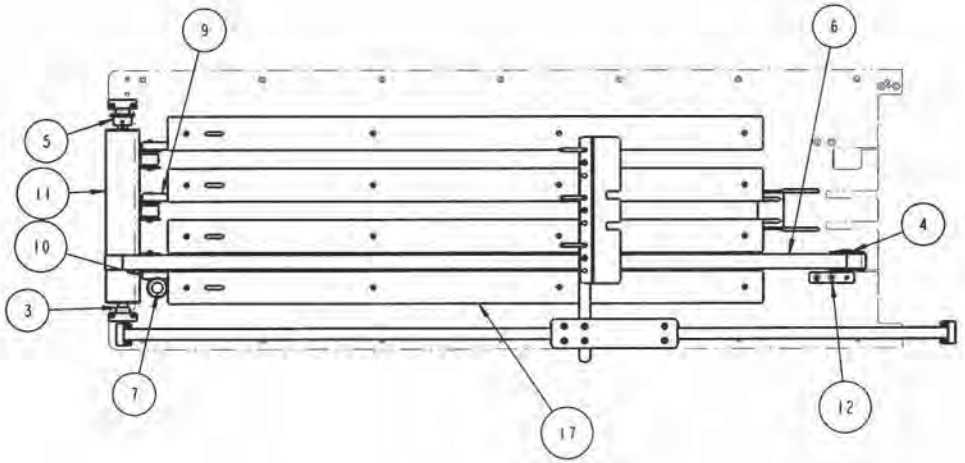
1	KR345L
REQ'D	WHERE USED

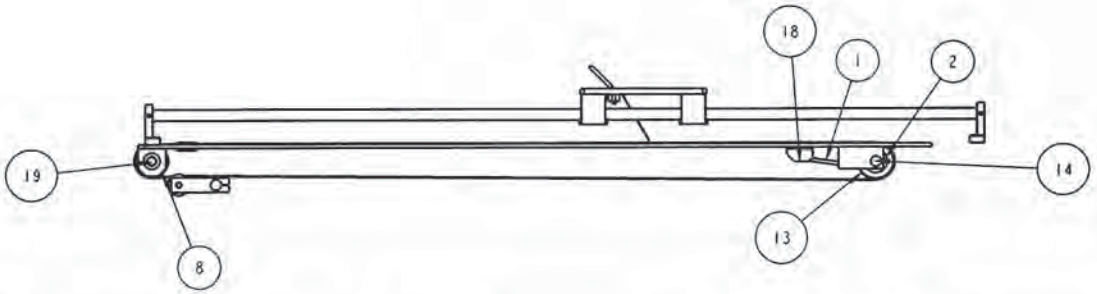
DRAWN BY: TJG	SCALE: 0.125	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED: .XX ±.01, .XXX ±.005, ANG ±.5	MATERIAL: NOTED	THIRD ANGLE PROJECTION	PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE QUOTED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC. WOODSTOCK, GA 30188 USA
CHECKED BY:	DATE: 28-Jul-03	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED	HEAT TREAT: NONE	MODEL: SA184	KIRK - RUDY, INC. WOODSTOCK, GEORGIA
TRACED BY:	MASTER	ALL DIMENSIONS ARE FINISHED DIMENSIONS. DO NOT SCALE - WORK TO DIMENSIONS ONLY	FINISH: NOTED	SHEET NO.: 1 OF 1	TITLE: ASSY, KR345 OUTFEED SECTION LH
					DRAWING #: 544454-01

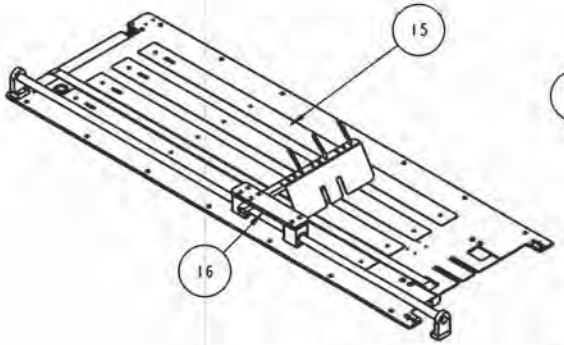
544454-02

ITEM	QTY	PART #	DESCRIPTION
1	2	102627	SPRING, EXTENSION
2	2	103112	BEARING, FLAT .750
3	2	103804	BEARING, HUB .625
4	2	104103	SNAPRING, .750
5	1	110742	SPRKT, 35B12 .625B .188K
6	1	111842-3	BELT, FLAT 1 X 104.75
7	1	200513-5	GROMMET, RUBBER .751DX1.3750DX.56TH
8	2	500819-2	BLOCK, BEARING
9	2	530610-01	ASSY, TAKEUP 1 IN BELT
10	1	530610-02	ASSY, TAKEUP 1 IN BELT
11	1	530676-01	ASSY, ROLLER FRONT DRIVE
12	1	533975-03	BRACKET, IDLER SHAFT MOUNT
13	1	544013-01	ROLLER, IDLER CROWNED
14	1	544051-01	SHAFT, IDLER ROLLER
15	1	544455-01	TABLETOP, OUTFEED CENTER
16	1	544459-02	ASSY, BACKSTOP RH
17	4	544467-01	GUIDE, BELT TABLETOP
18	1	544490-01	BRACKET, SPRING MOUNT
19	1	544497-01	SHAFT, FRONT ROLLER

REV NO	DATE	DESCRIPTION	ECN NO	BY







SCALE 0.090

1	KR345R
REQ'D	WHERE USED

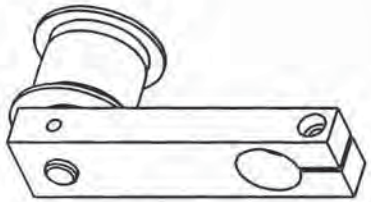
DRAWN BY: TJG	SCALE 0.125	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED .XX .XXX ANG .01 .005 .5 REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED ALL DIMENSIONS ARE FINISHED DIMENSIONS. DO NOT SCALE - WORK TO DIMENSIONS ONLY	MATERIAL: NOTED	THIRD ANGLE PROJECTION	PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE QUOTED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC. WOODSTOCK, GA 30188 USA.
CHECKED BY:	DATE 28-Jul-03		HEAT TREAT: NONE	MODEL: SA184	KIRK - RUDY, INC. WOODSTOCK, GEORGIA
TRACED BY:	MASTER		FINISH: NOTED	SHEET NO: 1 OF 1	TITLE: ASSY, KR345 OUTFEED SECTION RH
					DRAWING #: 544454-02

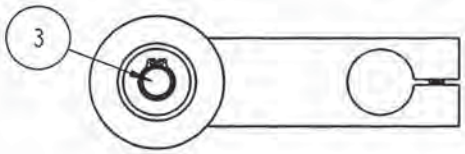
DRAWING #

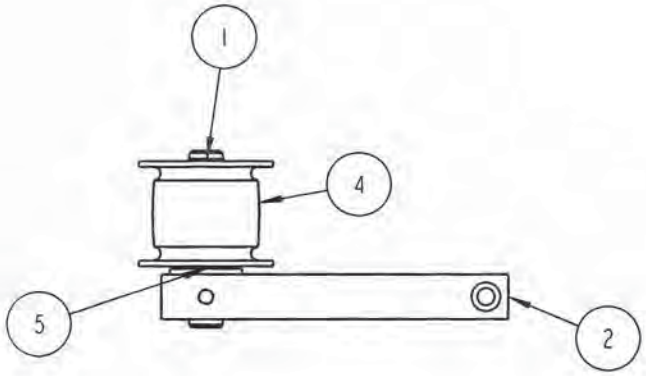
530610-01

ITEM	QTY	PART #	DESCRIPTION
1	1	104100	SNAPRING, .375
2	1	504949	ARM BELT TIGHTENER
3	1	504988-1	SHAFT, BELT TIGHTENER
4	1	510611A	ASSY-ROLLER
5	1	WA013	WASHER, FLAT 3/8

REV NO	DATE	DESCRIPTION	ECN NO	BY







1	GEN
REQ'D	WHERE USED

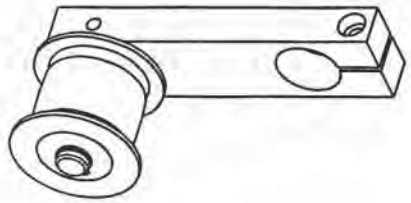
DRAWN BY: TVK	SCALE: 0.500	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED .XX .01 / .XXX .005 / ANG. .5 REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY	MATERIAL: XXX HEAT TREAT: NONE FINISH: N/A	THIRD ANGLE PROJECTION	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: 26-May-98			MODEL: XXX	TITLE: ASSY, TAKEUP 1 IN BELT	
TRACED BY:	MASTER			SHEET NO.: 1OF1	DRAWING #: 530610-01	

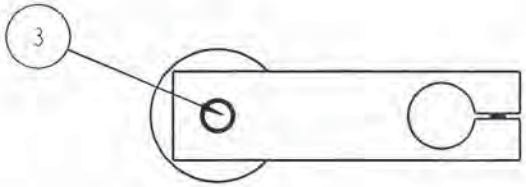
DRAWING #

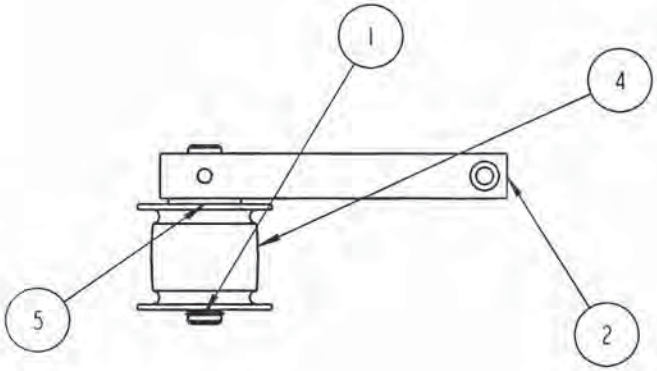
530610-02

ITEM	QTY	PART #	DESCRIPTION
1	1	104100	SNAPRING, .375
2	1	504949	ARM BELT TIGHTENER
3	1	504988-1	SHAFT, BELT TIGHTENER
4	1	510611A	ASSY-ROLLER
5	1	WA013	WASHER, FLAT 3/8

REV NO	DATE	DESCRIPTION	ECN NO	BY







1	GEN
REQ'D	WHERE USED

DRAWN BY: TVK	SCALE: 0.500	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED: .XX .01, .XXX .005, ANG. .5	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. WOODSTOCK, GA 30188 USA	KIRK - RUDY, INC. WOODSTOCK, GEORGIA
CHECKED BY:	DATE: 26-May-98	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED	HEAT TREAT: NONE	MODEL: XXX	TITLE: ASSY, TAKEUP 1 IN BELT	
TRACED BY:	MASTER:	ALL DIMENSIONS ARE FINISHED DIMENSIONS	FINISH: N/A	SHEET NO.: 1OF1	DRAWING #: 530610-02	

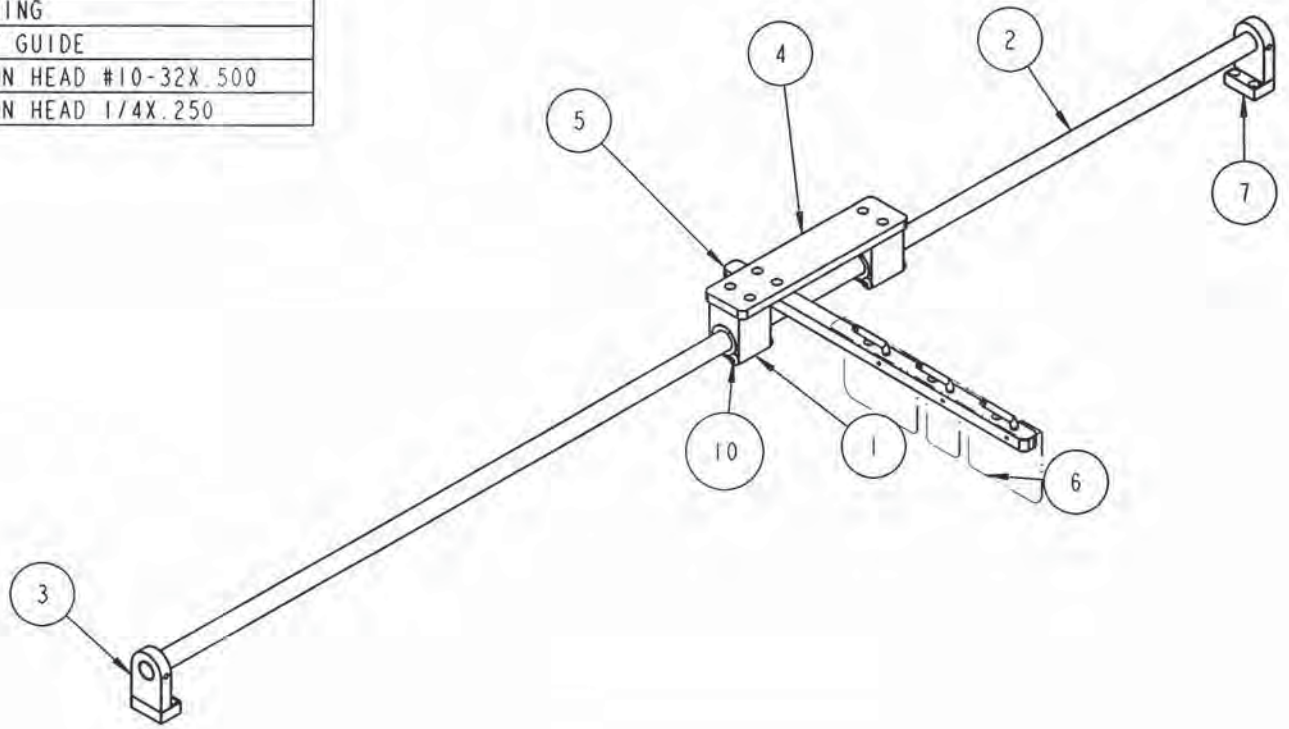
DO NOT SCALE - WORK TO DIMENSIONS ONLY

DRAWING #

544459-01

ITEM	QTY	PART #	DESCRIPTION
1	2	537280-01	BUSHING BLOCK ASY
2	1	544460-01	SHAFT, BACKSTOP LINEAR GUIDE
3	2	544461-01	BAR, SHAFT SUPPORT
4	1	544462-01	BRACKET, BEARING MOUNT
5	1	544463-01	BAR, BACKSTOP SUPPORT
6	1	544464-01	BACKSTOP, PRODUCT
7	2	544465-01	PLATE, MOUNTING
8	3	544491-01	ROD, PRODUCT GUIDE
9	3	CSFF58	SCREW, BUTTON HEAD #10-32X.500
10	8	CSFF63	SCREW, BUTTON HEAD 1/4X.250

REV NO	DATE	DESCRIPTION	ECN NO	BY



1	KR345L
REQ'D	WHERE USED

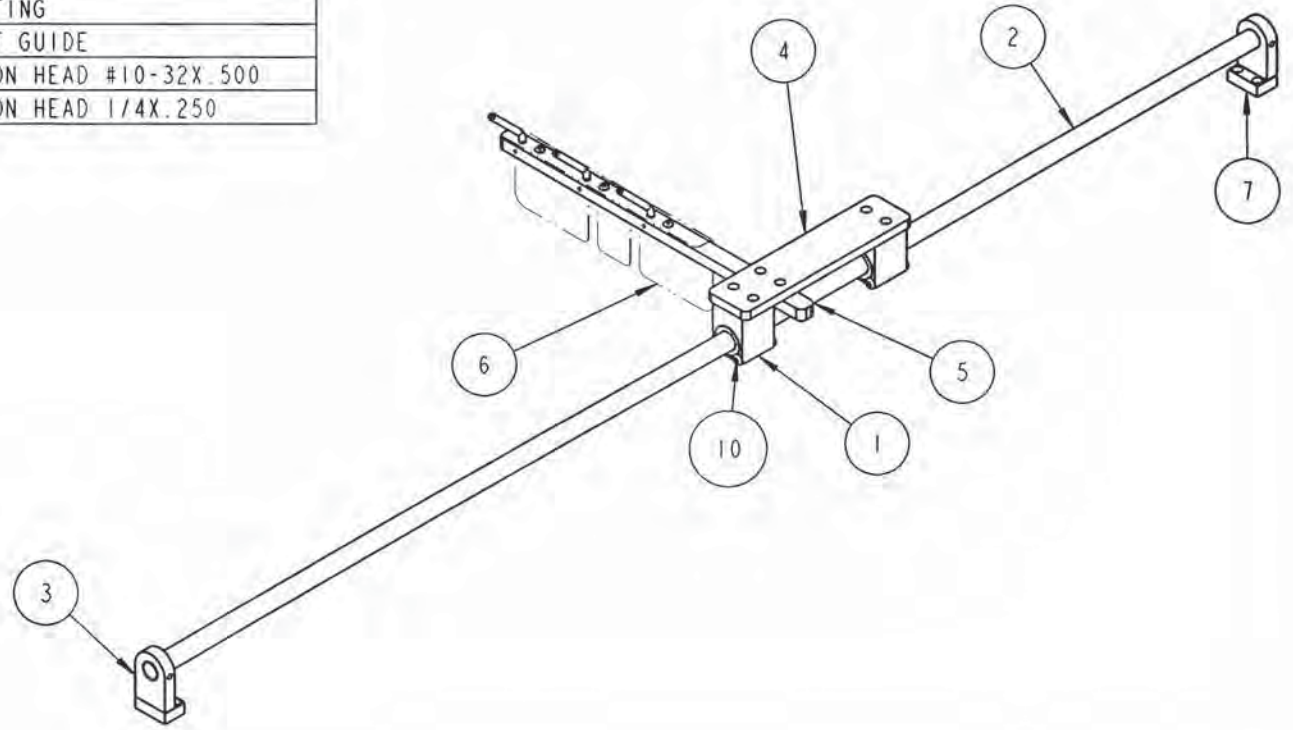
DRAWN BY: TJG	SCALE 0.156	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED .XX .01 / .XXX .005 / ANG. .5	MATERIAL: XXX	THIRD ANGLE PROJECTION	PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE QUOTED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC. WOODSTOCK, GA 30188 USA	KIRK - RUDY, INC. WOODSTOCK, GEORGIA
CHECKED BY:	DATE 28-Jul-03	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED	HEAT TREAT: XXX	MODEL: SA184	TITLE: ASSY, BACKSTOP LH	
TRACED BY:	MASTER	ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY	FINISH: XXX	SHEET NO.: 1OF1	DRAWING #: 544459-01	

DRAWING #

544459-02

ITEM	QTY	PART #	DESCRIPTION
1	2	537280-01	BUSHING BLOCK ASY
2	1	544460-01	SHAFT, BACKSTOP LINEAR GUIDE
3	2	544461-01	BAR, SHAFT SUPPORT
4	1	544462-01	BRACKET, BEARING MOUNT
5	1	544463-01	BAR, BACKSTOP SUPPORT
6	1	544464-01	BACKSTOP, PRODUCT
7	2	544465-01	PLATE, MOUNTING
8	3	544491-01	ROD, PRODUCT GUIDE
9	3	CSFF58	SCREW, BUTTON HEAD #10-32X.500
10	8	CSFF63	SCREW, BUTTON HEAD 1/4X.250

REV NO	DATE	DESCRIPTION	ECN NO	BY



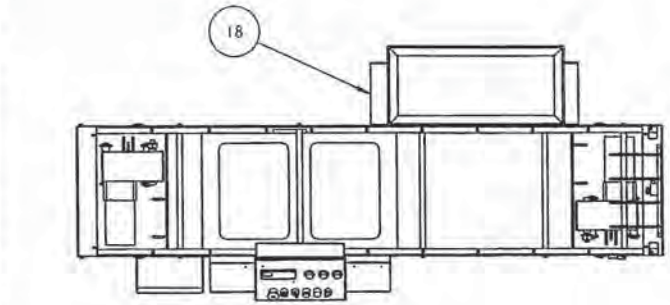
1	KR345R
REQ'D	WHERE USED

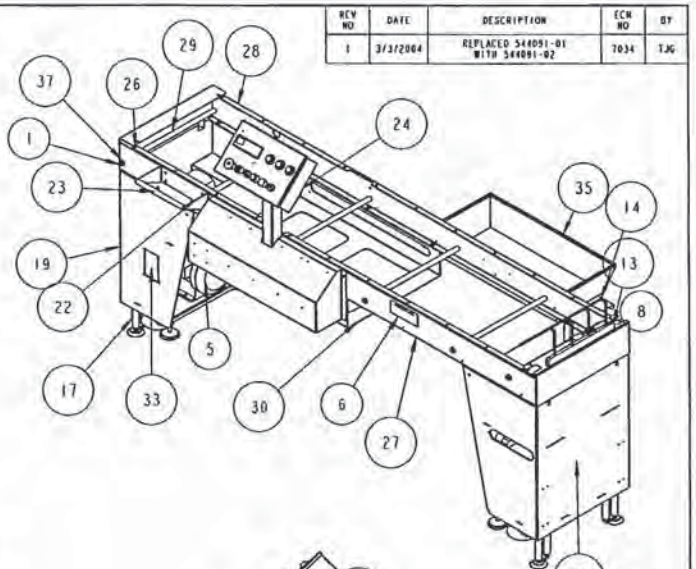
DRAWN BY: TJG	SCALE: 0.156	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED: .XX .01, .XXX .005, ANG. .5	MATERIAL: XXX	THIRD ANGLE PROJECTION	PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE QUOTED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC., WOODSTOCK, GA 30188 USA	KIRK - RUDY, INC. WOODSTOCK, GEORGIA
CHECKED BY:	DATE: 28-Jul-03	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED	HEAT TREAT: XXX	MODEL: SA184	TITLE: ASSY, BACKSTOP RH	
TRACED BY:	MASTER	ALL DIMENSIONS ARE FINISHED DIMENSIONS. DO NOT SCALE - WORK TO DIMENSIONS ONLY.	FINISH: XXX	SHEET NO.: 1OF1	DRAWING #: 544459-02	

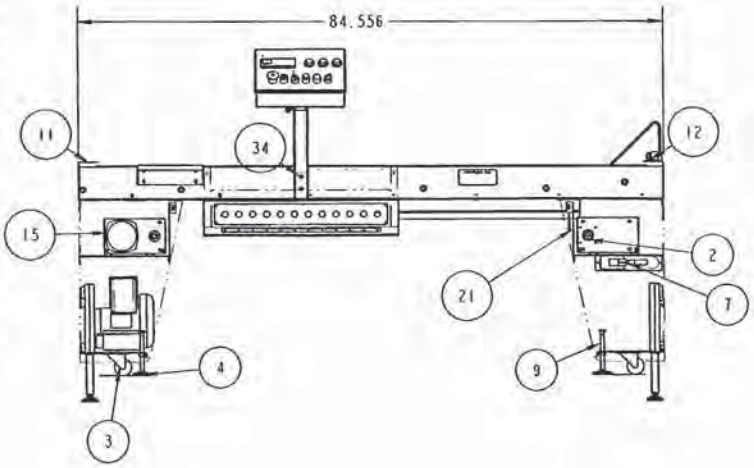
DRAWING #: 544469-01

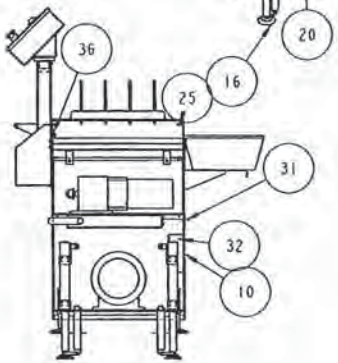
ITEM	QTY	PART #	DESCRIPTION
1	11	107336	BOLT, HEX HEAD 5/16-18X.75
2	2	110742	SPRKT, 35B12 .625B .188K
3	4	190620	CASTER-2.5IN
4	4	190634	FOOT, MOUNTING
5	1	200120	BLOWER, GAST
6	1	190619-1	PLATE, NAME
7	1	191029-1	PUMP, MOVOTEC PB4612FC
8	1	202263-7	SENSOR, PERFECT PROX
9	4	501812-1	LEG, LEVELING
10	1	530441-05	BOX, ELECTRICAL INLET 20A
11	1	530575-05	WELDMENT, CONVEYOR OUTFD GUARD
12	1	530575-06	WELDMENT, CONVEYOR OUTFD GUARD
13	1	530759-08	ROD, HOLDER
14	4	530760-01	ROD, STOP
15	2	538171-04	ASSY, 1/4HP GEARHEAD W/CLUTCH
16	2	539424-01	ASSY, RH HYDRALIFT LEG
17	2	539425-01	ASSY, LH HYDRALIFT LEG
18	1	544091-02	WLDMT, SHELF MAIL TRAY
19	1	544102-01	WLDMT, CONVEYOR LEG
20	1	544102-02	WLDMT, CONVEYOR LEG
21	2	544165-01	COVER, CHAIN LEG
22	1	544222-01	BRACKET, SHAFT MOUNT
23	1	544223-01	SHAFT, REAR SUPPORT
24	1	544335-01	ASSY, CONTROL PANEL KR345
25	2	544466-01	BAR, TABLETOP MOUNT
26	2	544466-02	BAR, TABLETOP MOUNT
27	1	544470-01	CHANNEL, CONVEYOR CABINET RH
28	1	544470-02	CHANNEL, CONVEYOR CABINET LH
29	6	544472-01	SHAFT, FRAME SPACER
30	1	544474-01	BRACKET, CONTROL BOX MOUNT
31	1	544487-01	COVER, HYDRALIFT SLOT
32	1	544517-01	COVER, E-BOX KR345
33	1	544518-01	COVER, E-BOX HOLE
34	2	CSDD320	SCREW, SHCS 5/16-18X.750
35	1	MAIL-TRAY	MAIL TRAY
36	1	RHN011	NUT, HEX 5/16
37	12	WA012	WASHER, FLAT 5/16

REV NO	DATE	DESCRIPTION	ECN NO	BY
1	3/3/2004	REPLACED 544091-01 WITH 544091-02	7034	TJG









REQ'D	WHERE USED
1	KR345L

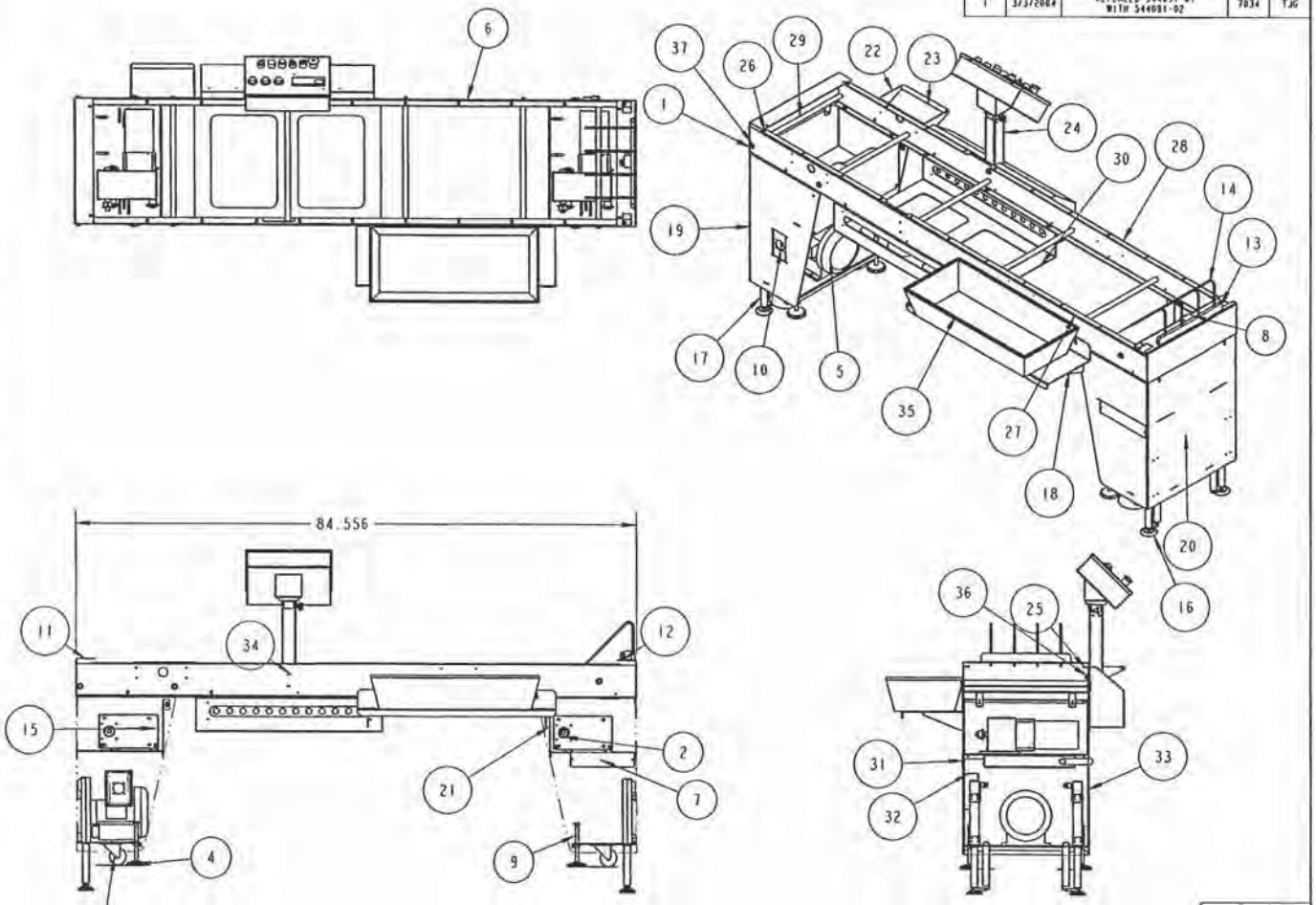
DRAWN BY: TJG	SCALE: 0.060	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED .XX ±.02 .XXX ±.005 ANG. ±.5	MATERIAL: XXX	THIRD ANGLE PROJECTION	PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE QUOTED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC. WOODSTOCK, GA 30188 USA
CHECKED BY:	DATE: 28-Jul-03	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED	HEAT TREAT: XXX	MODEL: SA184	TITLE: ASSY, CONVEYOR FRAME LH
TRACED BY:	MASTER	ALL DIMENSIONS ARE FINISHED DIMENSIONS	FINISH: XXX	SHEET NO: 1OF1	DRAWING #: 544469-01

KIRK - RUDY, INC.
WOODSTOCK, GEORGIA

DRAWING # 544469-02

ITEM	QTY	PART #	DESCRIPTION
1	11	107336	BOLT, HEX HEAD 5/16-18X.75
2	2	110742	SPRKT, 35B12 .625B .188K
3	4	190620	CASTER-2.5IN
4	4	190634	FOOT, MOUNTING
5	1	200120	BLOWER, GAST
6	1	190619-1	PLATE, NAME
7	1	191029-1	PUMP, MOVOTEC PB4612FC
8	1	202263-7	SENSOR, PERFECT PROX
9	4	501812-1	LEG, LEVELING
10	1	530441-05	BOX, ELECTRICAL INLET 20A
11	1	530575-05	WELDMENT, CONVEYOR OUTFD GUARD
12	1	530575-06	WELDMENT, CONVEYOR OUTFD GUARD
13	1	530759-08	ROD, HOLDER
14	4	530760-01	ROD, STOP
15	2	538171-04	ASSY, 1/4HP GEARHEAD W/CLUTCH
16	2	539424-01	ASSY, RH HYDRALIFT LEG
17	2	539425-01	ASSY, LH HYDRALIFT LEG
18	1	544091-02	WLDMT, SHELF MAIL TRAY
19	1	544102-01	WLDMT, CONVEYOR LEG
20	1	544102-02	WLDMT, CONVEYOR LEG
21	2	544165-01	COVER, CHAIN LEG
22	1	544222-01	BRACKET, SHAFT MOUNT
23	1	544223-01	SHAFT, REAR SUPPORT
24	1	544335-01	ASSY, CONTROL PANEL KR345
25	2	544466-01	BAR, TABLETOP MOUNT
26	2	544466-02	BAR, TABLETOP MOUNT
27	1	544470-01	CHANNEL, CONVEYOR CABINET RH
28	1	544470-02	CHANNEL, CONVEYOR CABINET LH
29	6	544472-01	SHAFT, FRAME SPACER
30	1	544474-01	BRACKET, CONTROL BOX MOUNT
31	1	544487-01	COVER, HYDRALIFT SLOT
32	1	544517-01	COVER, E-BOX KR345
33	1	544518-01	COVER, E-BOX HOLE
34	2	CSDD320	SCREW, SHCS 5/16-18X.750
35	1	MAIL-TRAY	MAIL TRAY
36	1	RHN011	NUT, HEX 5/16
37	12	WA012	WASHER, FLAT 5/16

REV NO	DATE	DESCRIPTION	ECN NO	BY
1	3/3/2004	REPLACED 544091-01 WITH 544091-02	7034	TJG



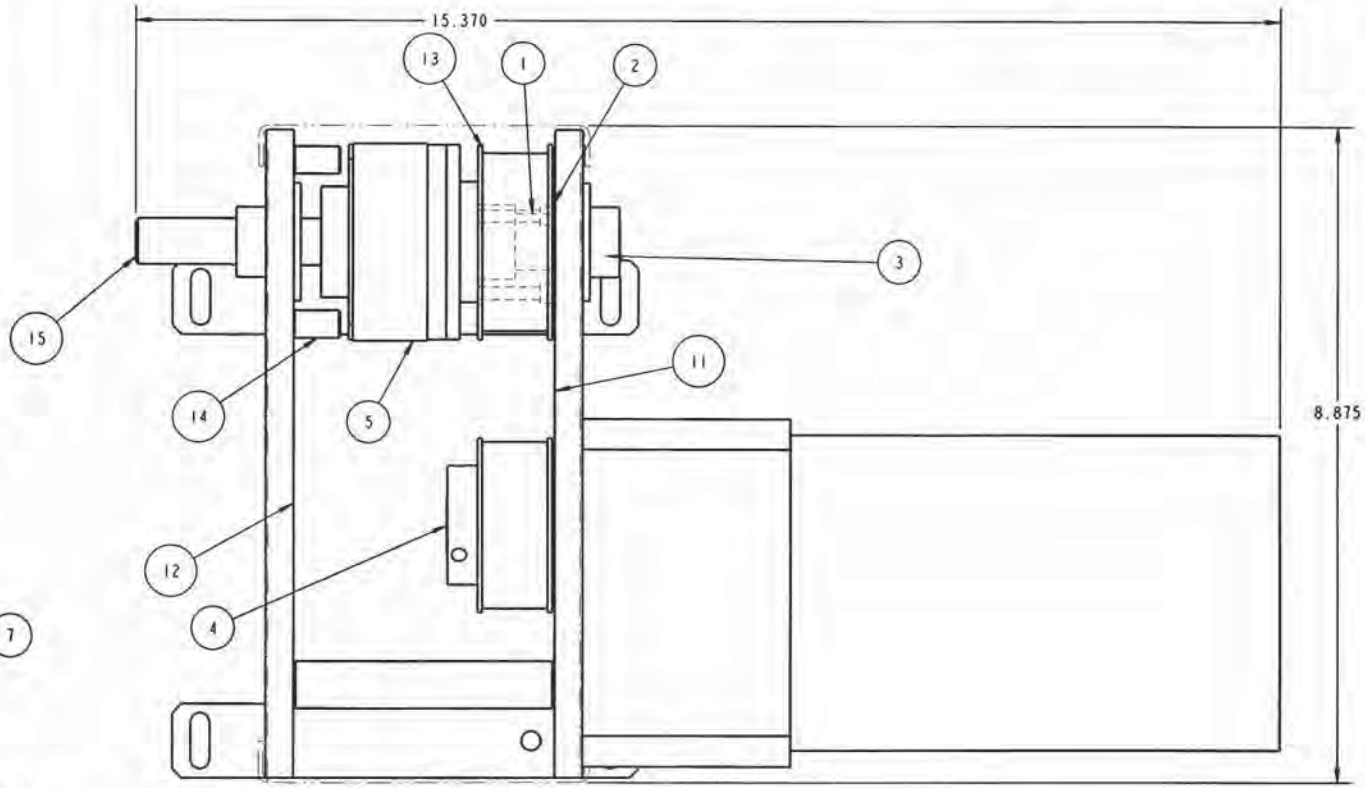
1	KR345N
REQ'D	WHERE USED

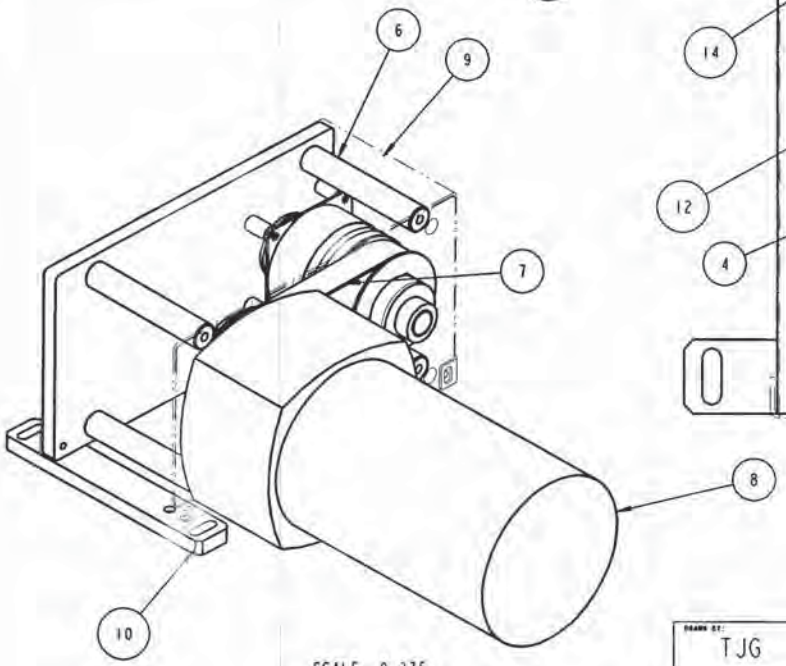
DRAWN BY: TJG	SCALE: 0.060	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED .XX ±.03 .XXX ±.005 ANG. ±1 REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY	MATERIAL: XXX HEAT TREAT: XXX FINISH: XXX	THIRD ANGLE PROJECTION	PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE QUOTED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC. WOODSTOCK, GA 30188 USA	KIRK - RUDY, INC. WOODSTOCK, GEORGIA
CHECKED BY:	DATE: 28-Jul-03			MODEL: SA184	TITLE: ASSY, CONVEYOR FRAME RH	
TRACED BY:	MASTER			SHEET NO.: 1OF1	DRAWING #: 544469-02	

538171-04

ITEM	QTY	PART #	DESCRIPTION
1	1	100258	BUSHING, SL.625ID.7500D.500LG
2	1	102671	SHIM, .625X1.000X.031
3	2	103804	BEARING, HUB .625
4	1	108892	PULLEY, TIMING 19L075 .750B .188K
5	1	202217	ELECTROID CLUTCH 201-467-8100
6	4	102672-3	SPACER, SIDE PLATE
7	1	108911-8	BELT, TIMING 150L075
8	1	200169-2	MOTOR, BODINE 4180
9	1	509037-6	COVER, REDUCER
10	2	530138-04	BAR, MOUNTING
11	1	544147-01	PLATE, REAR SIDE
12	1	544148-01	PLATE, FRONT SIDE
13	1	544149-01	PULLEY, TIMING 20L075 CLUTCH
14	4	544150-01	SHAFT, SPACER CLUTCH
15	1	544151-01	SHAFT, CLUTCH GEARBOX

REV NO	DATE	DESCRIPTION	ECN NO	BY





SCALE 0.375

#	XXX
REQ'D	WHERE USED

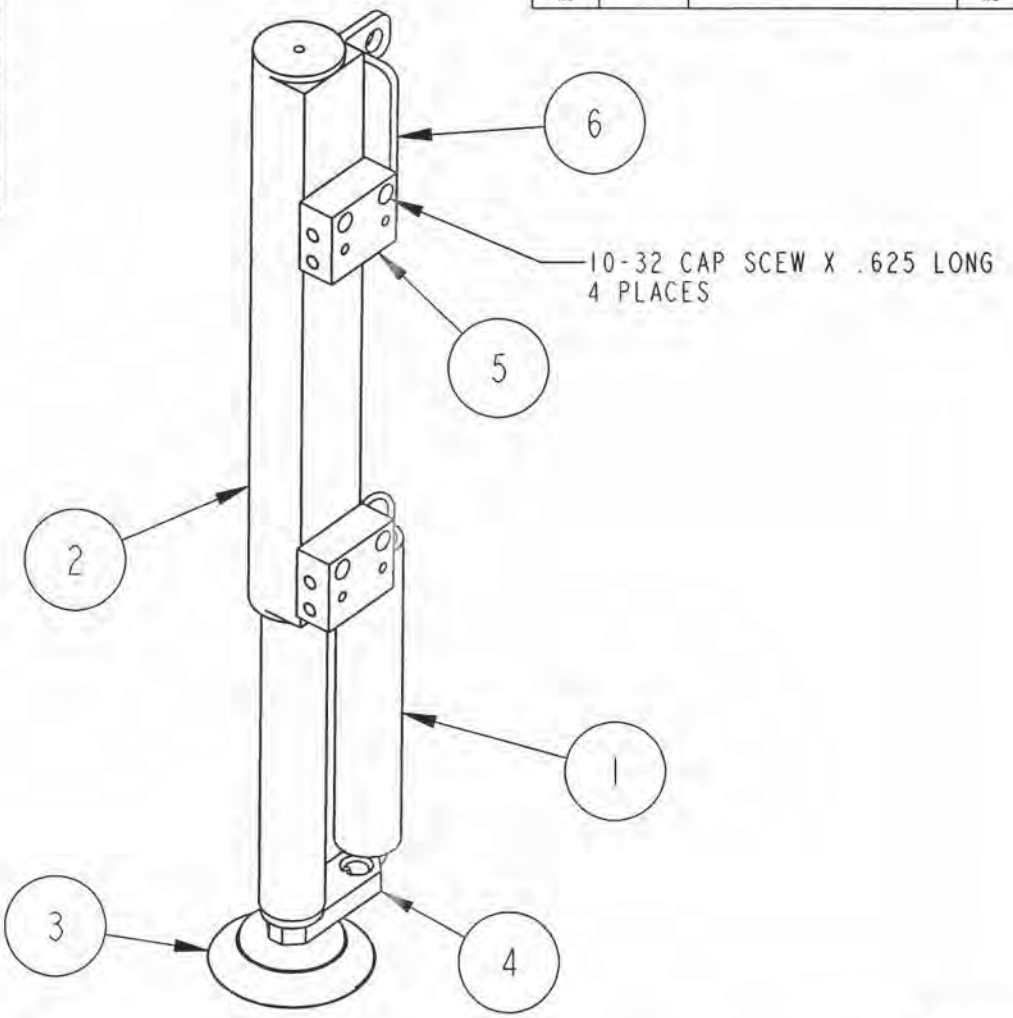
DRAWN BY: TJG	SCALE 0.625	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED .XX .XXX ANG .X .MS .5 REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY	MATERIAL: N/A	THIRD ANGLE PROJECTION	PROPRIETARY AND CONFIDENTIAL NO PORTION 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 05-May-03		HEAT TREAT: NONE	MODEL: SA184		TITLE: ASSY, 1/4HP GEARHEAD W/CLUTCH
TRACED BY:	MASTER		FINISH: N/A	SHEET NO: 1 OF 1		DRAWING # 538171-04

DRAWING #

539424-01

ITEM	QTY	PART #	DESCRIPTION
1	1	102792	SPRING, EXTENSION
2	1	191029-2	CYLINDER, LIFT CB415
3	1	191029-3	GLIDE, SUSPA
4	1	537371-01	BRACKET, SPRING RETURN MOUNT
5	2	537596-01	BLOCK, HYDRAULIC LIFT LH
6	1	537597-01	BRACKET, HYDRAULIC LIFT SPRING

REV NO	DATE	DESCRIPTION	ECN NO	BY



2	SP84700
REQ'D	WHERE USED

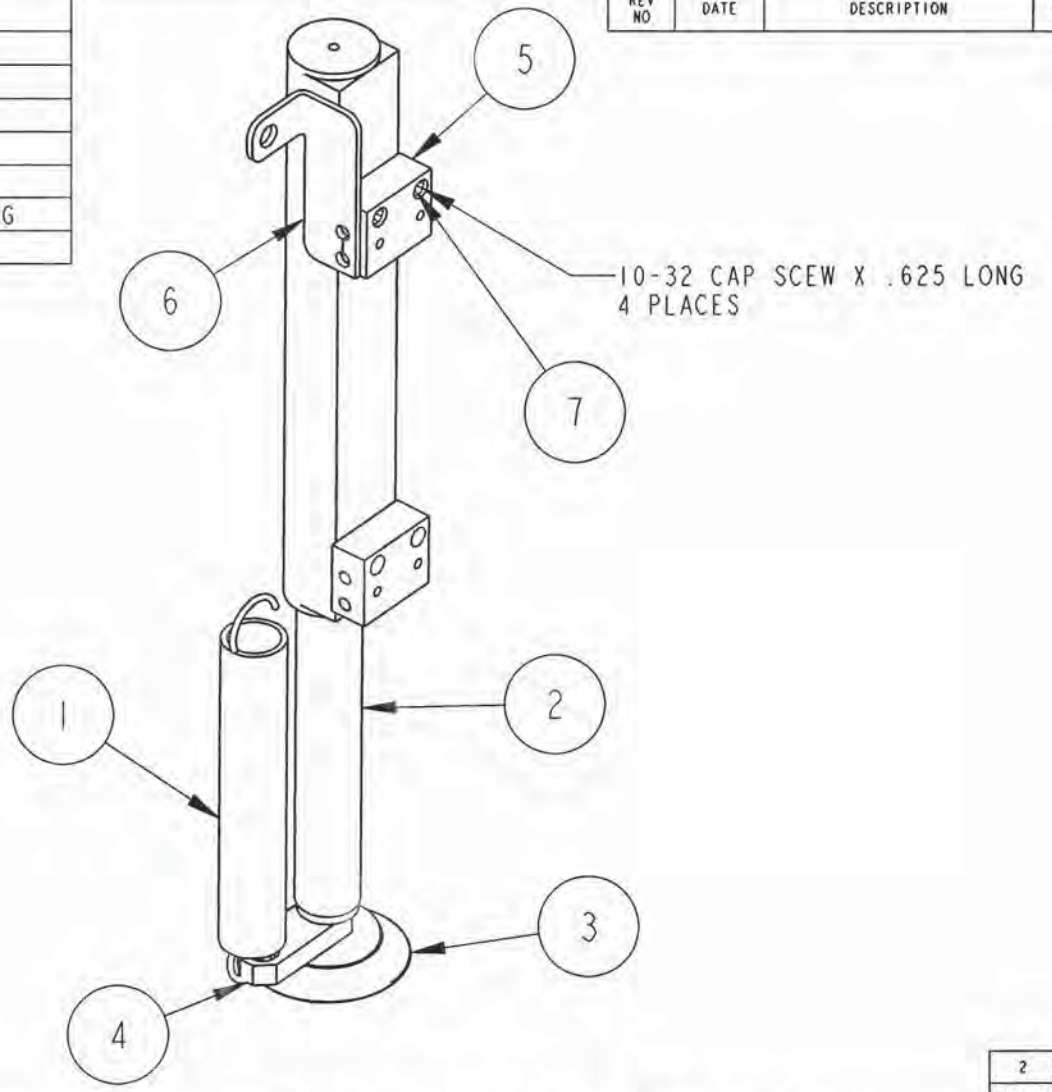
DRAWN BY: A KEY	SCALE 0.375	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED .XX .01 / .XXX .005 / ANG. .5 REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY	MATERIAL: N/A	THIRD ANGLE PROJECTION	PROPRIETARY AND CONFIDENTIAL 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 26-Jul-00		HEAT TREAT: N/A	MODEL: SP84700	TITLE: ASSY, RH HYDRALIFT LEG	
TRACED BY:	MASTER		FINISH: N/A	SHEET NO.: 1OF1	DRAWING # 539424-01	

DRAWING #

539425-01

ITEM	QTY	PART #	DESCRIPTION
1	1	102792	SPRING, EXTENSION
2	1	191029-2	CYLINDER, LIFT CB415
3	1	191029-3	GLIDE, SUSPA
4	1	537371-01	BRACKET, SPRING RETURN MOUNT
5	2	537596-01	BLOCK, HYDRAULIC LIFT LH
6	1	537597-02	BRACKET, HYDRAULIC LIFT SPRING
7	2	CSDD266	SCREW, SHCS 10-32X.625

REV NO	DATE	DESCRIPTION	ECN NO	BY



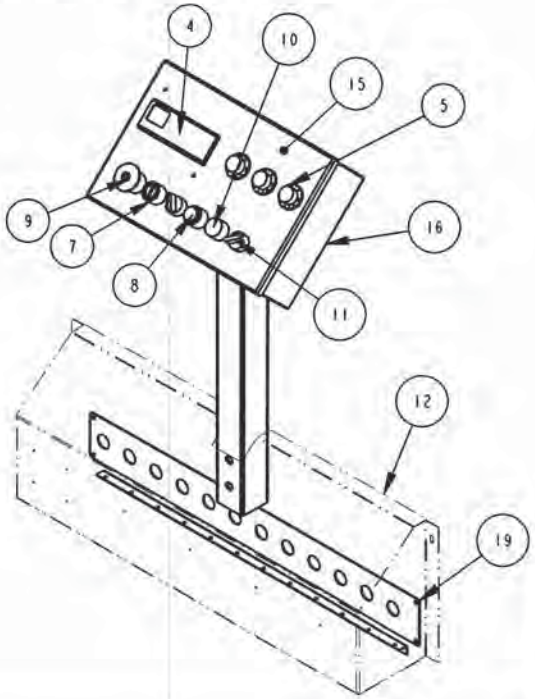
2	SP84700
REQ'D	WHERE USED

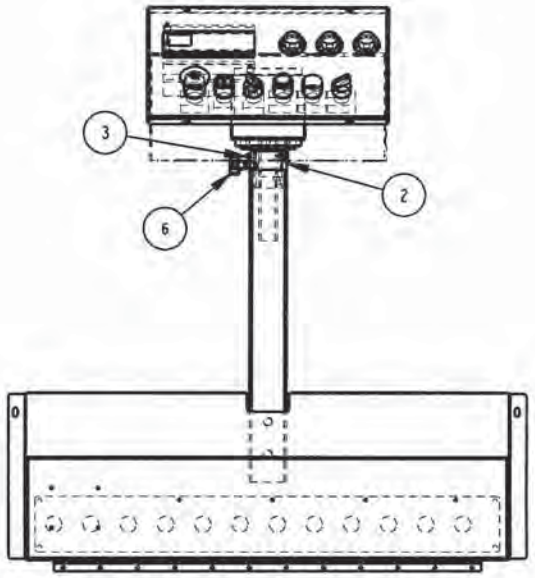
DRAWN BY: A KEY	SCALE: 0.375	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED: .X± / .XXX / ANG. .01 / .005 / .5	MATERIAL: N/A	THIRD ANGLE PROJECTION	PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE QUOTED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC. WOODSTOCK, GA 30188 USA	KIRK - RUDY, INC. WOODSTOCK, GEORGIA
CHECKED BY:	DATE: 26-Jul-00	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED	HEAT TREAT: N/A	MODEL: SP84700	TITLE: ASSY, LH HYDRALIFT LEG	
TRACED BY:	MASTER	ALL DIMENSIONS ARE FINISHED DIMENSIONS. DO NOT SCALE - WORK TO DIMENSIONS ONLY	FINISH: N/A	SHEET NO.: 1OF1	DRAWING #: 539425-01	

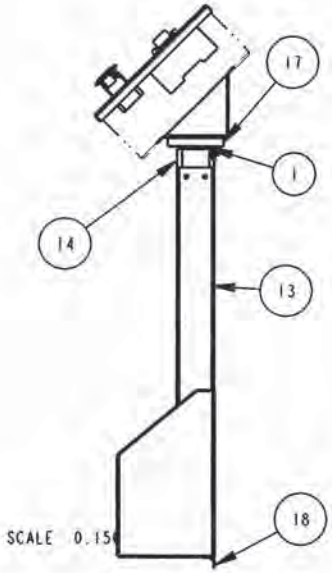
544335-01

ITEM	QTY	PART #	DESCRIPTION
1	1	100338	BUSHING, FLI.000ID1.250OD1.500LG
2	1	105209	PIN, ROLL .188X1.250
3	2	105228	PIN, ROLL .188X.625
4	1	202524	PLC, CROUZET
5	3	209016	KNOB, POT
6	1	500790	ASSY, KNOB
7	1	201124-4	BUTTON, POWER ON
8	1	201125-3	BUTTON, STOP
9	1	201125-5	BUTTON, POWER OFF
10	1	201126-1	BUTTON, JOG
11	2	201145-1	SELECTOR, 2 POSITIONS
12	1	528247-12	BOX, CONTROL KR345
13	1	532153-04	TUBING, VERTICAL
14	1	532154-01	HOUSING, PIVOT
15	1	544330-01	PANEL, ON-EDGE STACKER CONTROL
16	1	544332-01	WLDMT, CONTROL BOX KR345
17	1	544334-01	WLDMT, PIVOT MOUNTING
18	1	544488-01	HINGE, CONTROL BOX KR345
19	1	544489-01	PANEL, ELECTRICAL KR345

REV NO	DATE	DESCRIPTION	ECR NO	BY







SCALE 0.15

1	KR345
REQ'D	WHERE USED

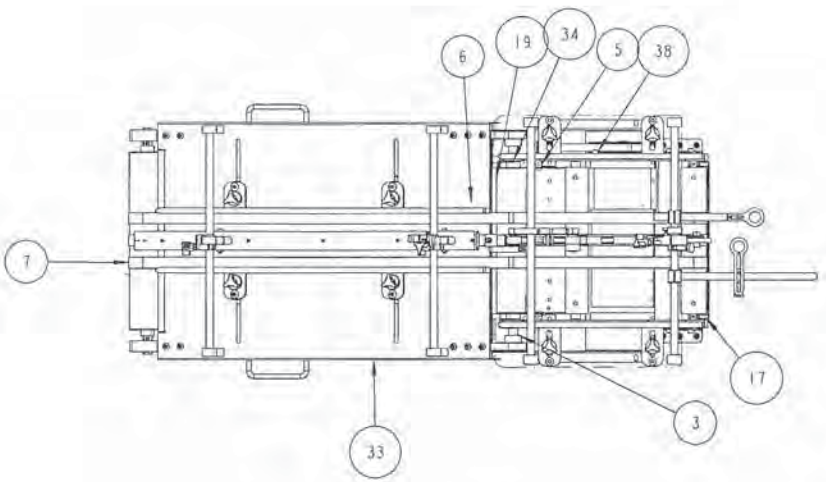
DRAWN BY: PEB	SCALE: 0.156	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED .XX .XXX .XXXX .YY .YYY .Y REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY	MATERIAL: N/A	THIRD ANGLE PROJECTION	PROPRIETARY AND CONFIDENTIAL NO 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
CHECKED BY:	DATE: 25-Aug-03		HEAT TREAT: N/A	MODEL: SA184	KIRK - RUDY, INC. WOODSTOCK, GEORGIA
TRACED BY:	MASTER		FINISH: N/A	SHEET NO: 1 OF 1	TITLE: ASSY, CONTROL PANEL KR345
					DRAWING # 544335-01

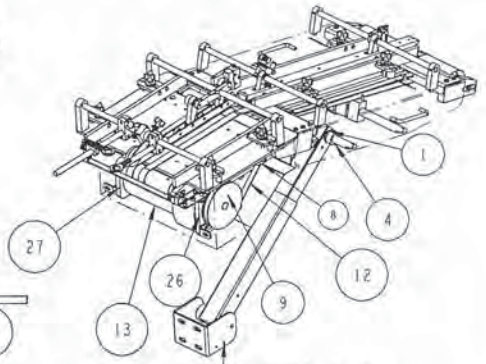
DRAWING #

544293-02

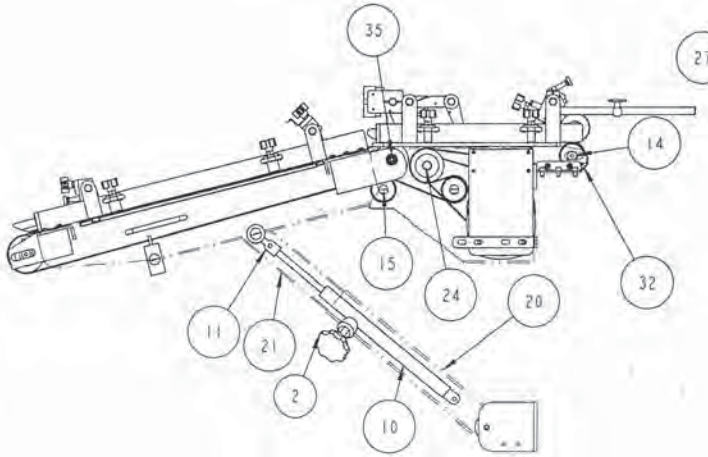
REV NO	DATE	DESCRIPTION	ECN NO	BY

ITEM	QTY	PART #	DESCRIPTION
1	2	100329	BUSHING, FL 750ID1.00OD .750LG
2	1	102112	KNOB
3	2	102203	COLLAR .625
4	2	102215	COLLAR .750
5	8	103804	BEARING, HUB .625
6	1	105601	SHAFT, THREADED 3/8-16
7	3	108461	BELT, FLAT 3/4 X 93"
8	1	108888	PULLEY, TIMING 12L050 .625B 188K
9	1	109963	PULLEY, TIMING 36L050 .750B .188K
10	1	190834	GAS SPRING, 30LB GAS 132
11	2	190841	BLOCK, CYLINDER MOUNT
12	1	108929-4	BELT, TIMING 210L050
13	1	200169-2	MOTOR, BODINE 4480
14	1	500823-15	SHAFT, IDLER ROLLER
15	2	510610-3	SHAFT, ROLLER FRAME SPACER
16	1	532466-01	ASSY, DRYER ARM PIVOT
17	2	533669-02	BLOCK, DEFLECTOR MOUNT
18	1	538434-03	ASSY, DRIVE ROLLER
19	1	538434-04	ASSY, IDLER ROLLER
20	1	542803-01	WLDMT, TUBING CLAMP BUMPTURN
21	1	542805-01	TUBING, VERTICAL BUMPTURN
22	1	544300-01	TABLETOP, INFEED
23	2	544458-02	FRAME, INFEED SECTION
24	1	544471-01	SHAFT, ROLLER DRIVE
25	3	544475-01	ROLLER, IDLER INFEED
26	1	544476-01	PLATE, MOTOR MOUNT LH
27	1	544476-02	PLATE, MOTOR MOUNT RH
28	2	544477-01	BRACKET, L CONVEYOR MOUNT
29	1	544478-02	WLDMNT, INFEED SECTION COVER
30	2	544479-01	BRACKET, L CONVEYOR MOUNT
31	1	544492-01	ASSY, SIDEGUIDE INFEED
32	1	544501-01	COVER, ROLLER GUARD
33	1	546475-01	ASSY, CONVEYOR ANGLED
34	1	546478-01	SHAFT, ROLLER IDLER
35	2	546486-01	SHAFT, CONVEYOR PIVOT
36	6	CSDD291	SCREW, SHCS 1/4-20X.375
37	4	CSDD293	SCREW, SHCS 1/4-20X.625
38	4	CSDD296	SCREW, SHCS 1/4-20X1.000





SCALE 0.090



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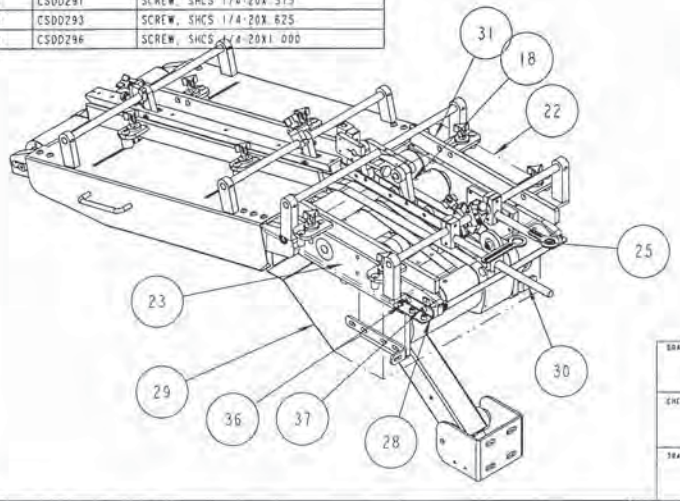


1	KR345
REQ'D	WHERE USED

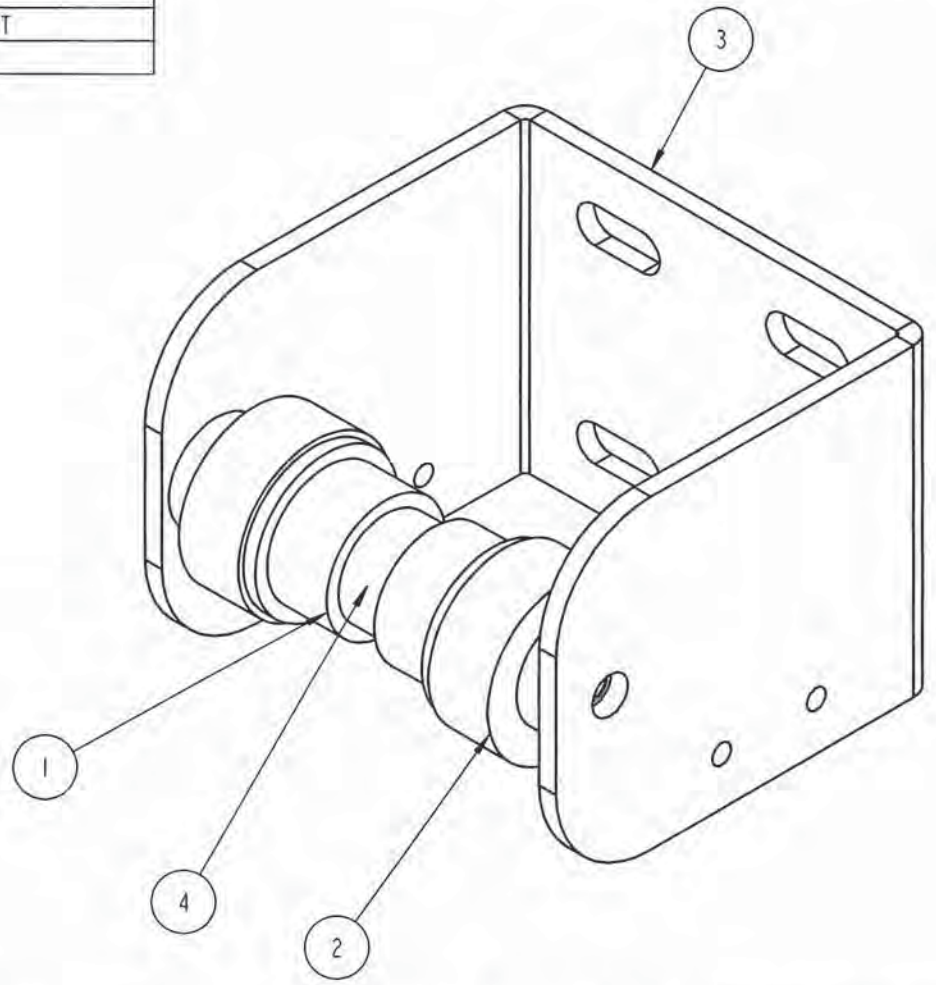
DRAWN BY: TJG	SCALE: 0.125	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED: .XX ±.01, .XXX ±.005, ANG. ±.5	MATERIAL: NOTED	THIRD ANGLE PROJECTION	PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE QUOTED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC. WOODSTOCK, GA 30188 USA	KIRK - RUDY, INC WOODSTOCK, GEORGIA
CHECKED BY:	DATE: 07-Dec-04	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED	HEAT TREAT: NONE	MODEL: SA283	TITLE: ASSY, INFEED SECTION	
TRACED BY:	MASTER:	ALL DIMENSIONS ARE FINISHED DIMENSIONS. DO NOT SCALE. WORK TO DIMENSIONS ONLY.	FINISH: NOTED	SHEET NO: 1OF3	DRAWING #: 544293-02	

DRAWING #

532466-01

ITEM	QTY	PART #	DESCRIPTION
1	2	100326	BUSHING, FLI.0001D1.2500D.750LG
2	2	102212	COLLAR 1.000
3	1	532465-01	BRACKET, DRYER ARM PIVOT
4	1	532467-01	SHAFT, DRYER PIVOT

REV NO	DATE	DESCRIPTION	ECN NO	BY



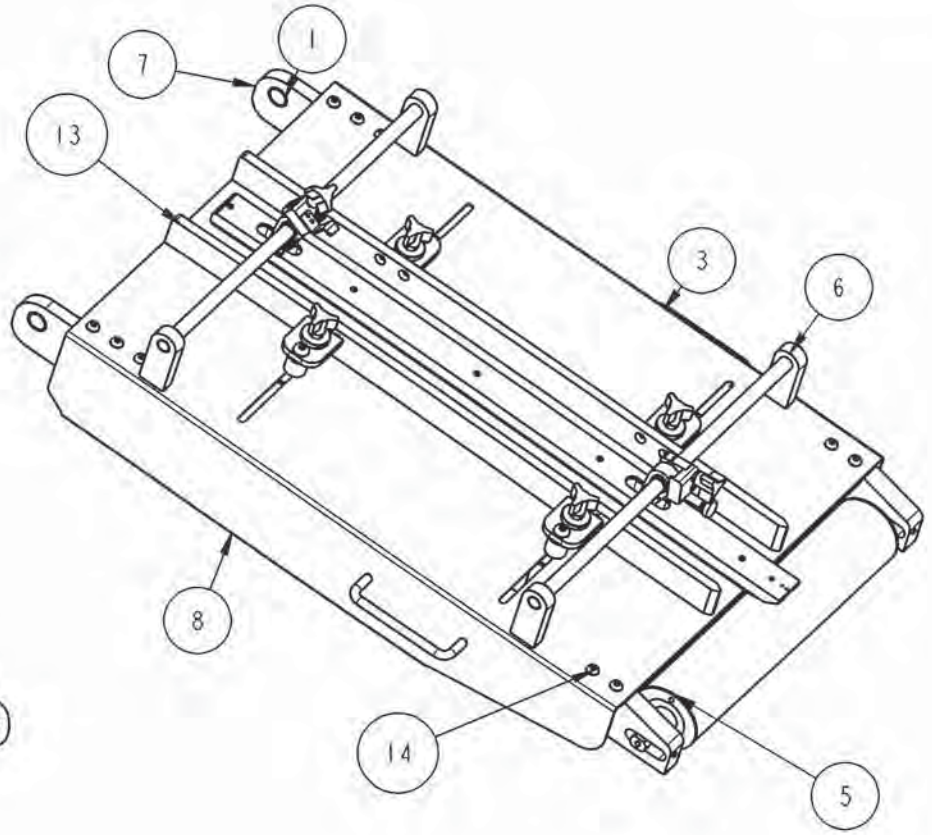
1	532734-01
REQ'D	WHERE USED

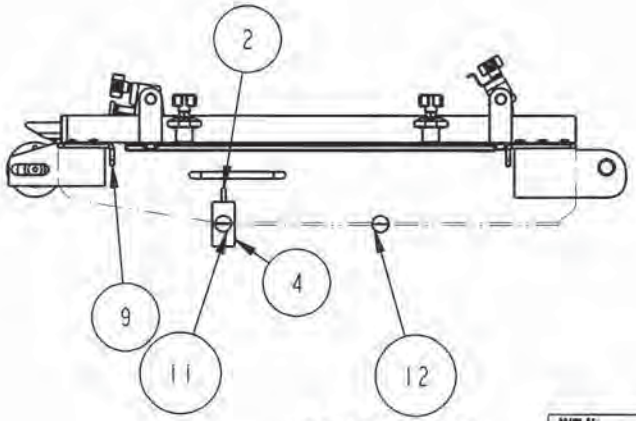
DRAWN BY: TJG	SCALE 0.750	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED .XX .01 / .XXX .005 / ANG. .5 REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY	MATERIAL: NOTED	THIRD ANGLE PROJECTION	PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE QUOTED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC. WOODSTOCK, GA 30188 USA	KIRK - RUDY, INC. WOODSTOCK, GEORGIA
CHECKED BY:	DATE 20-Feb-98		HEAT TREAT: NONE	MODEL: SP62500	TITLE: ASSY, DRYER ARM PIVOT	
TRACED BY:	MASTER		FINISH: NONE	SHEET NO. 1 OF 1	DRAWING # 532466-01	

546475-01

ITEM	QTY	PART #	DESCRIPTION
1	2	100258	BUSHING, SL 6251D .7500D .500LG
2	6	105419	DOWEL, PIN .188X1.000
3	2	190955	HANDLE
4	3	500725-13	GUIDE, BELT 3/4
5	1	530619-01	ASSY, IDLER ROLLER
6	1	537284-09	ASSY, SKID BAR BUMPTURN
7	2	546476-01	PLATE, INFEED RAMP BEARING
8	1	546477-01	TABLETOP, INFEED CONVEYOR
9	1	546480-01	BRACKET, TAKEUP BLOCK SPACER
10	1	546480-02	BRACKET, TAKEUP BLOCK SPACER
11	1	546481-01	SHAFT, SPACER CONVEYOR
12	1	546481-02	SHAFT, SPACER CONVEYOR
13	1	546482-01	ASSY, SIDEGUIDE INCLINE CONVEYOR
14	10	CSFF67	SCREW, BUTTON HEAD 1/4X.750

REV NO	DATE	DESCRIPTION	ECN NO	BY





SCALE 0.188

1	SA283
REQ'D	WHERE USED

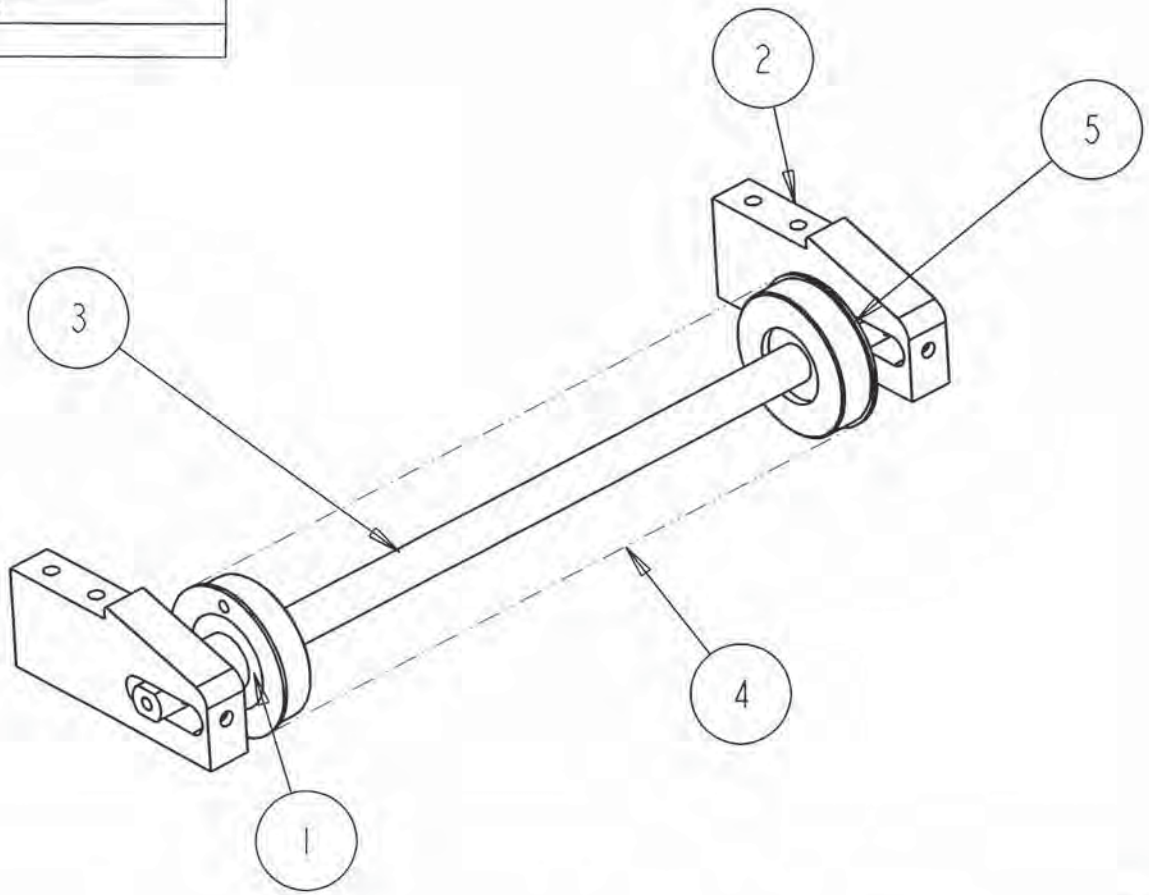
DRAWN BY: TJG	SCALE: 0.250	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED: .XX ±.01, .XXX ±.005, ANG ±.5	MATERIAL: N/A	THIRD ANGLE PROJECTION	PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE COPIED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC. WOODSTOCK, GA 30188 USA
CHECKED BY:	DATE: 07-Dec-04	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED	HEAT TREAT: N/A	MODEL: SA283	KIRK - RUDY, INC. WOODSTOCK, GEORGIA
TRACED BY:	MASTER	ALL DIMENSIONS ARE FINISHED DIMENSIONS	FINISH: N/A	SHEET NO: 1 OF 2	TITLE: ASSY, CONVEYOR ANGLED
		DO NOT SCALE - WORK TO DIMENSIONS ONLY			DRAWING #: 546475-01

DRAWING #

530619-01

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

REV NO	DATE	DESCRIPTION	ECN NO	BY



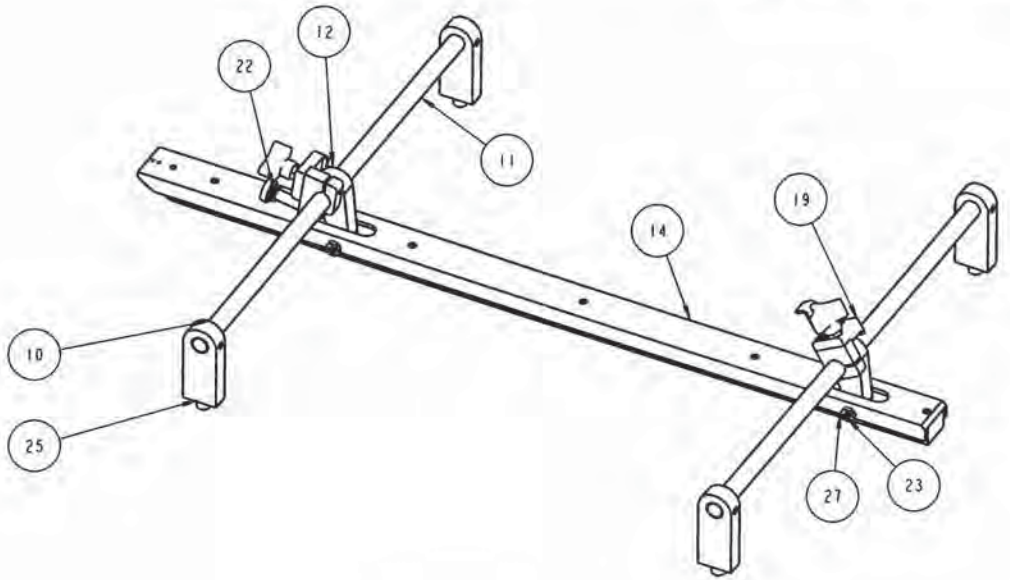
1	215
REQ'D	WHERE USED

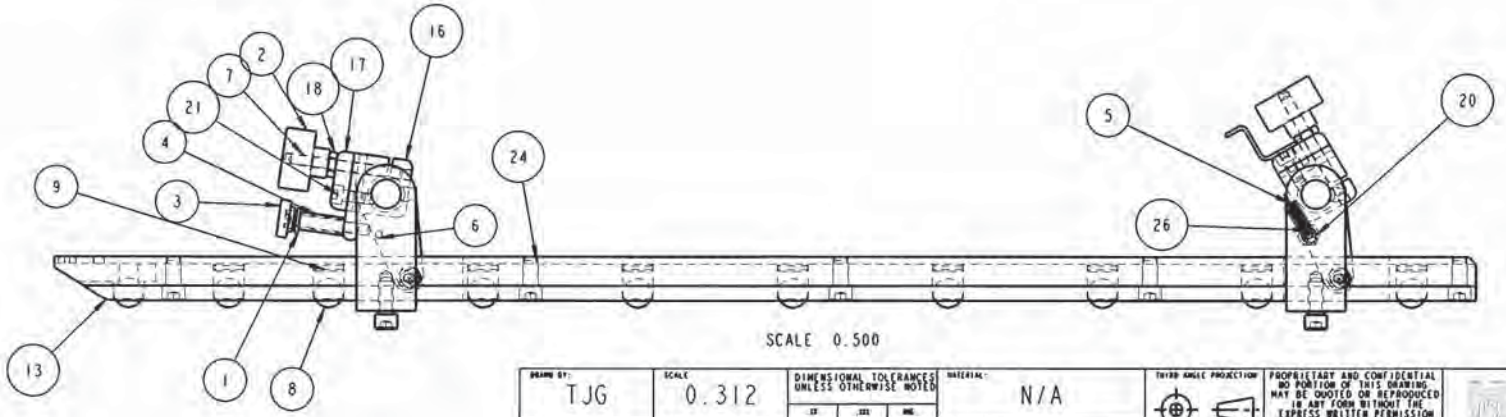
DRAWN BY: TVK	SCALE 0.375	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED .XX .XXX ANG. .01 .005 .5 REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY	MATERIAL: N/A	THIRD ANGLE PROJECTION	PROPRIETARY AND CONFIDENTIAL NO 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 02-Mar-99		HEAT TREAT: N/A	MODEL SP71700	TITLE: ASSY, IDLER ROLLER	
TRACED BY:	MASTER		FINISH: N/A	SHEET NO. 1 OF 1	DRAWING # 530619-01	

537284-09

ITEM	QTY	PART #	DESCRIPTION
1	1	100619	WASHER, FLAT 10-32
2	1	102117	KNOB
3	1	102132	KNOB, 10-32 CAP SCREW
4	1	102714	SPRING, COMPRESSION
5	1	102716	SPRING, COIL EO 240-026-1000M
6	1	105210	PIN, ROLL .125X.750
7	1	105613	SHAFT, 10-32 X 2.00 LNG
8	10	190864	BALL, 1/2 DIA STEEL
9	9	190869	DISC, 1/2 DIA FELT
10	4	503556	POST, SIDEGUIDE
11	2	500787-19	SHAFT, SIDE GUIDE ADJ.
12	2	500801-11A	ASSY, LINK
13	1	529107-18	BAR, SILENT SKID
14	1	529148-17	RETAINER PLATE-SKID PLATE
15	1	537284-09	ASSY, SKID BAR BUMPTURN
16	1	537879-01	BLOCK, SKID BAR ADJUST CLAMP
17	1	537884-01	CAP, SKID BAR ADUST
18	1	537886-01	ASSY, TRIKNOB 10-32 X 2.000 LNG
19	1	539817-03	ASSY, SKID BAR CLAMP
20	1	CSDD242	SCREW, SHCS 8-32X1.000
21	1	CSDD264	SCREW, SHCS 10-32X.375
22	1	CSDD270	SCREW, SHCS 10-32X1.250
23	2	CSDD271	SCREW, SHCS 10-32X1.500
24	5	CSDD292	SCREW, SHCS 1/4-20X.500
25	4	CSDD293	SCREW, SHCS 1/4-20X.625
26	1	HMSN09	NUT, HEX #8-32
27	3	HMSN10	NUT, HEX #10-32

REV NO	DATE	DESCRIPTION	ECN NO	BY





SCALE 0.500

ITEM	SA283
REQ'D	WHERE USED

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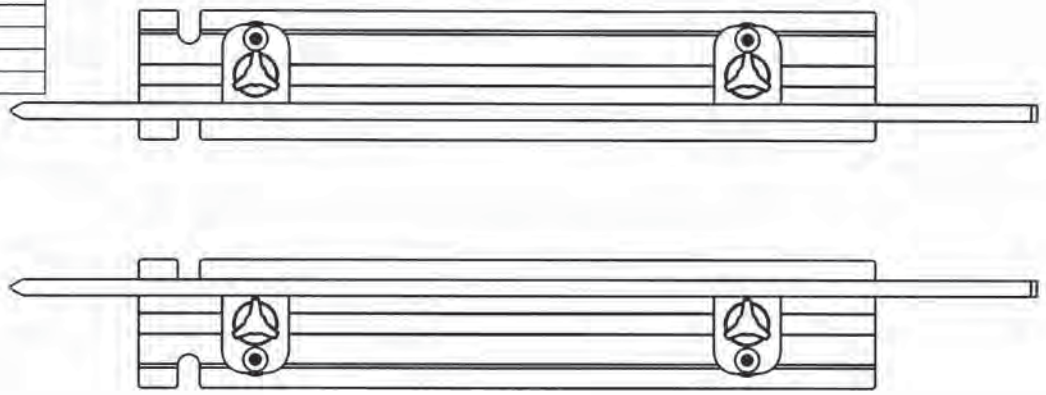
CHECKED BY:	DATE: 07-Dec-04	REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED	HEAT TREAT: N/A	MODEL: SA283	KIRK - RUDY, INC. WOODSTOCK, GEORGIA
TRACED BY:	MASTER	ALL DIMENSIONS ARE FINISHED DIMENSIONS	FINISH: N/A	SHEET NO.: 1 OF 1	TITLE: ASSY, SKID BAR BUMPTURN
		DO NOT SCALE - WORK TO DIMENSIONS ONLY			DRAWING #: 537284-09

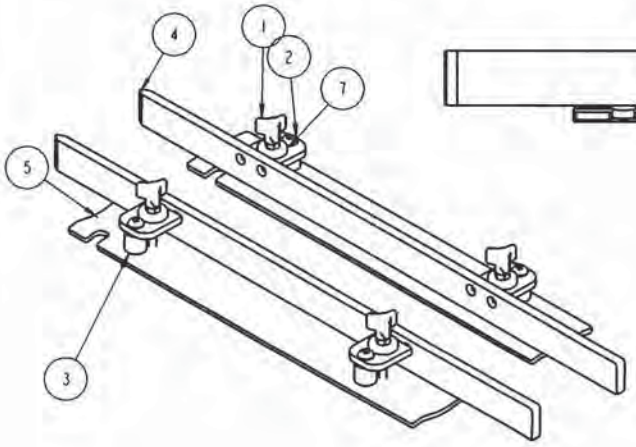
546482-01

ITEM	QTY	PART #	DESCRIPTION
1	4	500790-1	ASSY, TRI-KNOB 1/4-20 STUD
2	4	541709-03	BRACKET, SIDEGUIDE
3	4	541710-03	SPACER, SIDEGUIDE MOUNT
4	2	546483-01	SIDEGUIDE, INCLINE CONVEYOR
5	2	546484-01	STRIP, SIDEGUIDE CLAMP
6	4	CSFF71	SCREW, BUTTON HEAD 5/16X.500
7	4	SP6383-1	SPACER, GEAR COVER

REV NO	DATE	DESCRIPTION	ECN NO	BY



SCALE 0.375



1	KB345
REQ'D	WHERE USED

DRAWN BY: TJG	SCALE: 0.250	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED .XX ±.01 .XXX ±.005 ANG ±.5 REMOVE ALL BURRS AND SHARP EDGES UNLESS OTHERWISE NOTED ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY	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: 07-Dec-04		HEAT TREAT: N/A	MODEL: SA283	TITLE: ASSY, SIDEGUIDE INCLINE CONVEYOR
TRACED BY:	MASTER		FINISH: N/A	SHEET NO.: 1 OF 1	DRAWING #: 546482-01

8.0 ELECTRICAL SCHEMATICS AND PARTS

WARNING

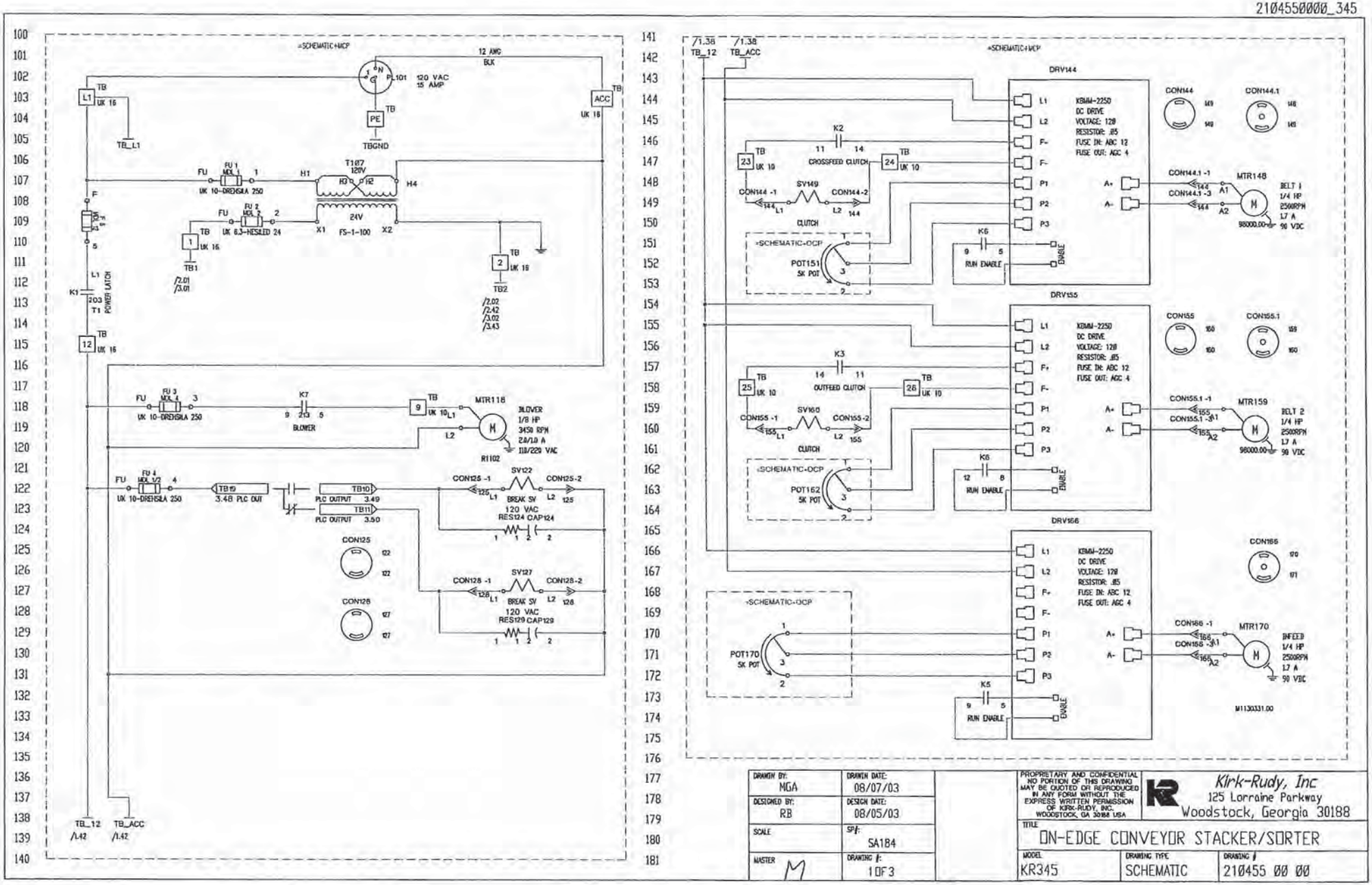
Read and follow all Safety Instructions in Section 1, Page 3 before proceeding.

8.1 SCHEMATIC NUMBER LIST

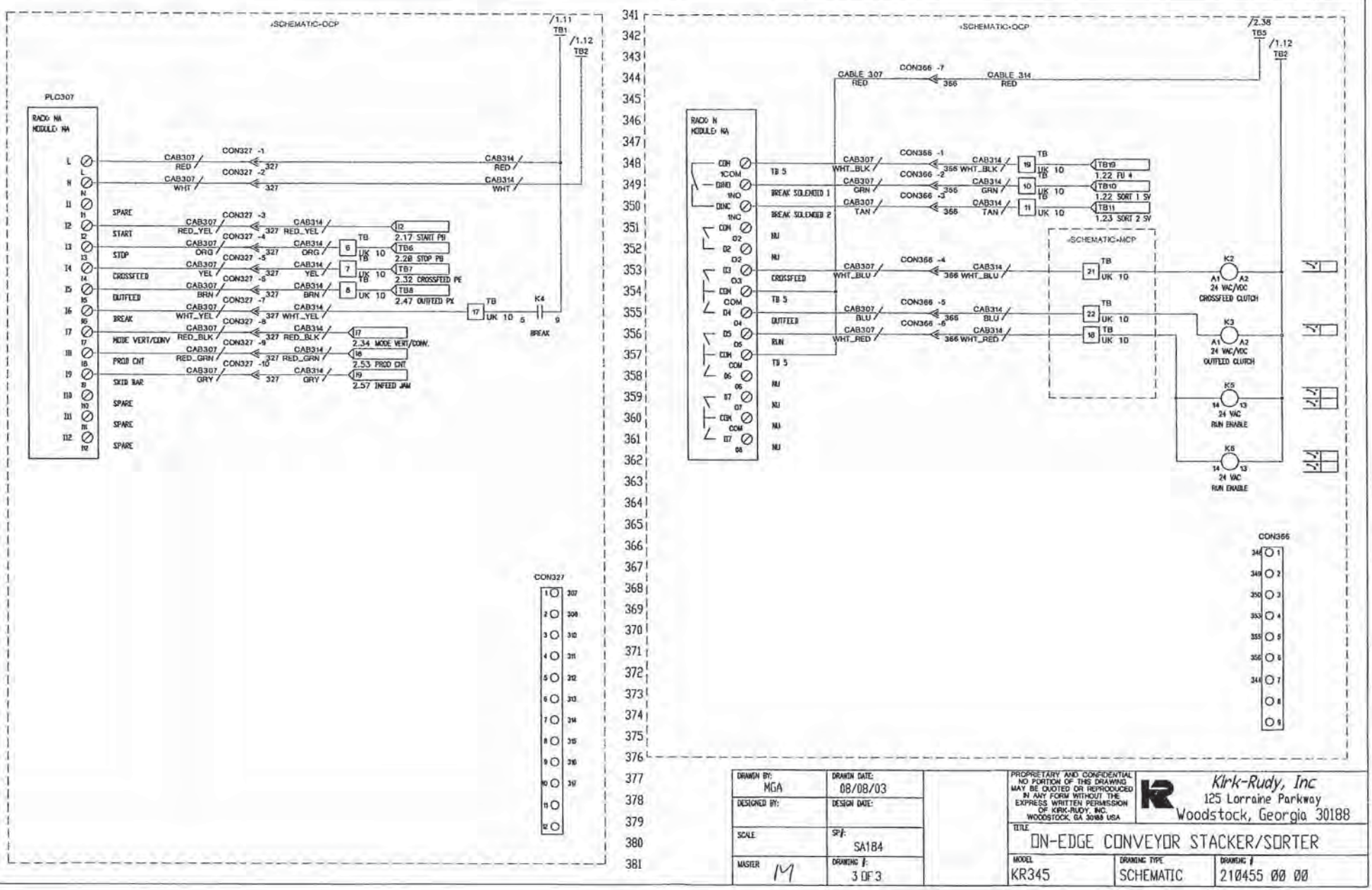
The following wiring diagrams are supplied in a separate package and enlarged with your manual for your reference. A reference of drawing symbols is also provided.

210455 00 00 Schematic, KR345 Vertical Edge Stacker
SYMBOLS.ORC Schematic Symbols Reference

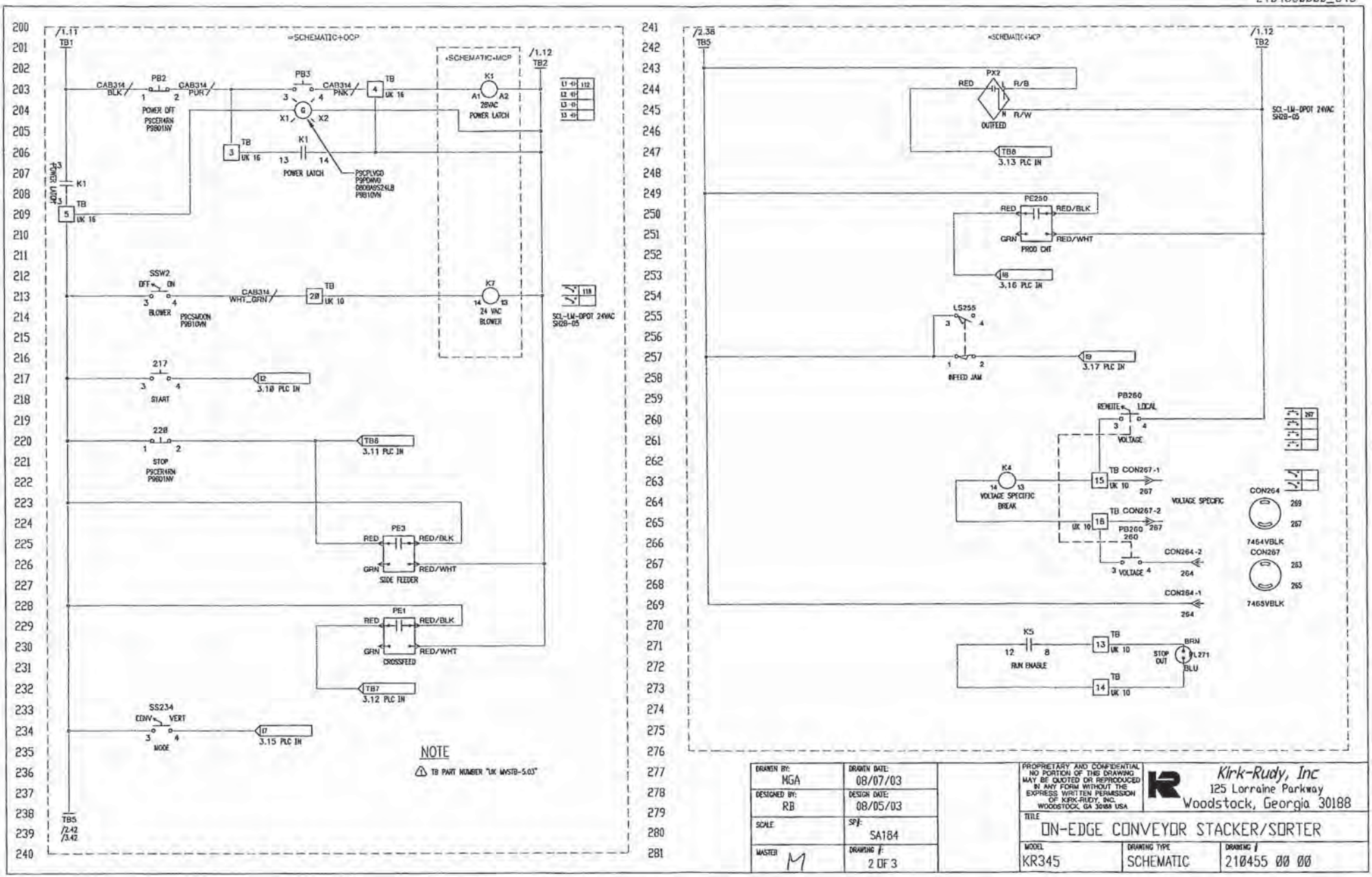
8.2 PARTS LIST



DRAWN BY: MGA	DRAWN DATE: 08/07/03	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 125 Lorraine Parkway Woodstock, Georgia 30188
DESIGNED BY: RB	DESIGN DATE: 08/05/03		
SCALE	SPF: SA184	TITLE: ON-EDGE CONVEYOR STACKER/SORTER	
MASTER M	DRAWING #: 1 OF 3	MODEL: KR345 / DRAWING TYPE: SCHEMATIC / DRAWING #: 210455 00 00	



DRAWN BY: MGA	DRAWN DATE: 08/08/03	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 125 Lorraine Parkway Woodstock, Georgia 30188
DESIGNED BY:	DESIGN DATE:	TITLE: ON-EDGE CONVEYOR STACKER/SORTER	
SCALE	SPF: SA184		
MASTER M	DRAWING #: 3 OF 3	MODEL: KR345	DRAWING TYPE: SCHEMATIC
			DRAWING #: 210455 ØØ ØØ



DRAWN BY: MGA	DRAWN DATE: 08/07/03	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 125 Lorraine Parkway Woodstock, Georgia 30188
DESIGNED BY: RB	DESIGN DATE: 08/05/03	TITLE: ON-EDGE CONVEYOR STACKER/SORTER	
SCALE	SPJ#: SA184		
MASTER M	DRAWING #: 2 OF 3	MODEL: KR345	DRAWING TYPE: SCHEMATIC
			DRAWING #: 210455 ØØ ØØ

9.0 APPENDIX

WARNING

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

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

COMPONENT	MANUFACTURER
DC Supply	International Power
DC Motor Board	Penta-KB
Beam/prox switch	Banner
Interface	Crouzet

10.0 NOTES

11.0 WARRANTY AND SERVICE

WARRANTY

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

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

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

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

USE ONLY GENUINE REPLACEMENT PARTS

For Service or Replacement Parts Please Call:
In the USA: Kirk-Rudy @PH 770-427-4203, FX 770-427-4036
In Europe: Grafibind @ PH 011-31-5553-41610