

FLOWMASTER

12000

6 x 9 INSERTER

Parts Manual



SURE-FEED
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Table of Contents

FRONT TABLE	5
FRAME ASSEMBLY (Fig. 1-1).....	6
TOP PLATE / LINEAR ACTUATOR ASSEMBLY (Fig. 1-2).....	8
ENVELOPE CHAIN DRIVE ASSEMBLY (Fig. 1-3).....	10
CHAIN GUIDE ASSEMBLY (Fig. 1-4)	12
MOTOR / REDUCER / INDEXING BOX ASSEMBLY (Fig. 1-5)	14
DRIVE ASSEMBLY (Fig. 1-6)	16
CONVEYOR DRIVE ASSEMBLY (Fig. 1-7)	18
SHUTTLE DRIVE ASSEMBLY (Fig. 1-8).....	20
CENTER JAW OPENER ASSY. (Fig. 1-9)	22
RIGHT HAND JAW OPENER ASSY. (Fig. 1-10).....	Error! Bookmark not defined.
SHUTTLE ASSEMBLY (Fig. 1-11).....	26
SHUTTLE PLATE ASSEMBLY (Fig. 1-12)	28
SHUTTLE GUIDE / SHAFT ASSEMBLY (Fig. 1-13).....	30
FRONT TABLE GUIDE ASSEMBLY (Fig. 1-14)	33
PAPER GUIDE ASSEMBLY (Fig. 1-15).....	35
ENVELOPE PLOW ASSEMBLY (Fig. 1-16).....	37
GATE / INSERT GUIDE RAIL ASSEMBLY (Fig. 1-17)	39
ENVELOPE CLOSER / DISCHARGE ROLLER ASSEMBLY (Fig. 1-18)	41
COVERS (Fig. 1-19)	43
WATER SOLENIOD VALVE / WATER TANK ASEEMBLY (Fig. 1-20) ..	Error! Bookmark not defined.
COLLATOR	48
FRAME ASSEMBLY (Fig. 2-1).....	49
FRAME (Fig. 2-2).....	52
COVERS (Fig. 2-3).....	54
FEEDER ASSEMBLY	56
FRAME (Fig. 2-4).....	56
DOUBLE DETECTION ASSEMBLY (1 PER FEEDER) (Fig. 2-5).....	58
TONGUE ASSEMBLY (1 PER FEEDER) (Fig. 2-6).....	60
SEPERATOR DEVICE / SIDE GUIDE ASSEMBLY (1 PER FEEDER) (Fig. 2-7).....	62
PAPER GUIDE ASSEMBLY (Fig. 2-8).....	65
FEEDER ROLLER ASSEMBLY (Fig. 2-9).....	67
SHAFT ASSEMBLY - DOUBLE DETECTION, FRONT, IDDLER (Fig. 2-10)	Error! Bookmark not defined.
SHAFT ASSEMBLY – MAIN, REAR MAIN (Fig. 2-11).....	71
DRAG STRAP ASSEMBLY (Fig. 2-12).....	73
FEEDER DRIVE ASSEMBLY (Fig. 2-13).....	75
PULLEY DRIVE ASSEMBLY (Fig.2-14).....	77
FEEDER DRIVE MOTOR ASSEMBLY (Fig. 2-15).....	79
PUSHER ASSEMBLY (Fig. 2-16)	81
LEFT HAND PUSHER GUIDE ASSEMBLY (Fig. 2-17).....	83
RIGHT HAND PUSHER GUIDE ASSEMBLY (Fig. 2-18).....	85

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Table of Contents

PUSHER DRIVE SHAFT ASSEMBLY (Fig. 2-19)	87
PUSHER ARM SHAFT ASSEMBLY (Fig. 2-20)	89
PUSHER CHAIN ASSEMBLY (6 X 9) (Fig. 2-21)	91
FINGER DRIVE SHAFT ASSEMBLY (Fig. 2-22)	93
FINGER ARM SHAFT ASSEMBLY (Fig. 2-23)	95
PUSHER DRIVE ASSEMBLY (Fig. 2-24)	97
IDLER MOUNTING PLATE ASSEMBLY (Fig. 2-25)	99
CONVEYOR ASSEMBLY (Fig. 2-26)	101
COLLATOR DRIVE SHAFT ASSEMBLY (Fig. 2-27)	103
IDLER ASSEMBLY (REAR PULLEY) (Fig. 2-28)	105
TENSIONER / FLAT IDLER PULLEY ASSEMBLY (Fig. 2-29)	107
FRONT END COLLATOR ASSEMBLY (Fig. 2-30)	109
(DRIP PAN / ROLLER / STRIP BRUSH / GUIDE YOKE)	109
CONEYOR BELT TRACK ASSEMBLY (Fig. 2-31)	111
SIDE GUIDE ASSEMBLY (Fig. 2-32)	113
COVERS (Fig. 2-33)	115
WATER BRUSH ASSEMBLY (Fig. 2-34)	117
INFEED CONVEYOR	120
INFEED CONVEYOR ASSEMBLY (Fig. 3-1)	121
DRIVE SHAFT/ MOTOR ASSEMBLY (Fig. 3-2)	123
IDLER SHAFT ASSEMBLY (Fig. 3-3)	125
SIDE GUIDE / PAPER GUIDE ASSEMBLY (Fig. 3-4)	128
SHINGLE CONVEYOR	131
SHINGLE CONVEYOR ASSEMBLY (Fig. 4-1)	132
DRIVE SHAFT / MOTOR ASSEMBLY (Fig. 4-2)	134
IDLER SHAFT ASSEMBLY (Fig. 4-3)	136
TURNOVER	139
TURNOVER ASSEMBLY (Fig. 5-1)	140
FRAME ASSEMBLY (Fig. 5-2)	142
INFEED ASSEMBLY (Fig. 5-3)	144
DISCHARGE ASSEMBLY (Fig. 5-4)	146
MOTOR / MOTOR MOUNT ASSEMBLY (Fig. 5-5)	149
DRIVE ASSEMBLY (Fig. 5-6)	151
SEPERATOR ADJUSTING ASSEMBLY (Fig. 5-7)	154
COVER ASSEMBLY (Fig. 5-8)	156
CENTER COVER ASSEMBLY (Fig. 5-9)	158
TOUCH SCREEN	161
TOUCH SCREEN ASSEMBLY (Fig. 6-1)	162

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Table of Contents

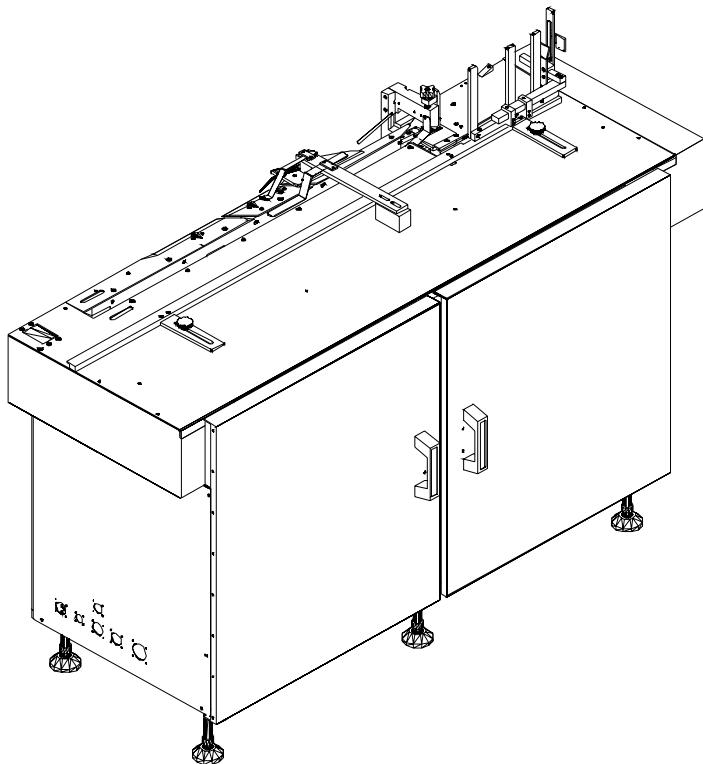
PNEUMATICS	165
PNEUMATICS (BEFORE 12/2000)	166
MOUNTING BAR ASSEMBLY (Fig. 7-1).....	166
MAIN FILTER / REGULATOR / VACUUM GENERATOR ASSY (Fig. 7-2)	168
INSERT AIR VALVE BANK / DIVERT AIR REGULATOR ASSEMBLY (Fig. 7-3)	170
VACUUM SHUTTLE / VACUUM DISH SOLENOID ASSY (Fig. 7-4).....	172
INSERT AIR ASSEMBLY (Fig.7-5).....	174
PNEUMATICS (AFTER 12/2000)	176
MOUNTING BAR ASSEMBLY (Fig 7-6).....	176
ELECTRICAL	179
ELECTRICAL COMPONENTS (FRONT TABLE) (Fig. 8-1).....	180
ELECTRICAL COMPONENTS (COLLATOR) (Fig. 8-2)	182
OPERATOR CONTROL SWITCH ASSEMBLY (Fig. 8-3)	184
PLUG / RECEPTACLE ASSEMBLY (Fig. 8-4).....	186
VFD ENCLOSURE COMPONENTS ASSEMBLY (Fig. 8-5).....	188
PLC ENCLOSURE COMPONENTS ASSEMBLY (Fig. 8-6).....	190
PLC / BREAKER / TERMINAL BLOCK ASSEMBLY (Fig. 8-7)	192
ELECTRICAL COMPONENTS (TURNOVER) (Fig. 8-8).....	194
ELECTRICAL COMPONENTS (SHINGLE CONVEYOR) (Fig. 8-9).....	196
ELECTRICAL COMPONENTS (INFEED CONVEYOR) (Fig. 8-10)	198
METER STAND	201
METER STAND (Fig. 9-1).....	202

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FRONT TABLE

6 X 9



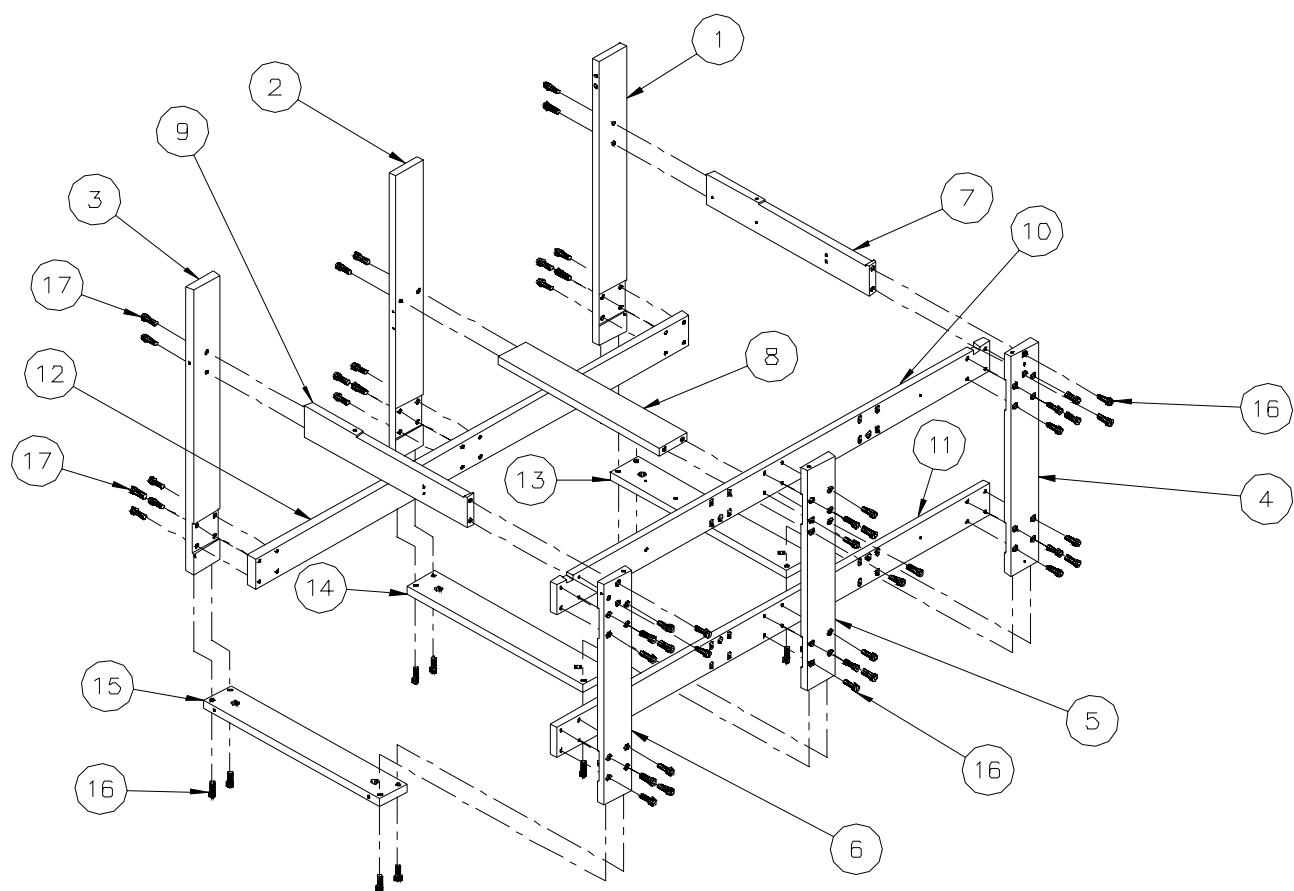
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FRONT TABLE - FRAME ASSEMBLY (Fig. 1-1)

ITEM	PART NO.	QTY.	DESCRIPTION
1	18010-012	1	LEG, FRONT TABLE, FRONT LEFT
2	18010-005	1	LEG, FRONT TABLE, FRONT MIDDLE
3	18010-013	1	LEG, FRONT TABLE, FRONT RIGHT
4	18010-010	1	LEG, FRONT TABLE, REAR
5	18010-007	1	LEG, FRONT TABLE, REAR
6	18010-011	1	LEG, FRONT TABLE, REAR
7	18003-022	1	CROSS BRACE, LEG, LEFT
8	18003-006	1	CROSS BRACE, LEG, CENTER
9	18003-005	1	CROSS BRACE, LEG, RIGHT
10	18008-003	1	BAR, FRONT TABLE BRACE, UPPER
11	18008-002	1	BAR, FRONT TABLE BRACE, LOWER REAR
12	18008-004	1	BAR, FRONT TABLE BRACE, FRONT
13	18003-024	1	CROSS BAR, FRONT TABLE, BOTTOM LEFT
14	18003-014	1	CROSS BAR, FRONT TABLE, BOTTOM MIDDLE
15	18003-023	1	CROSS BAR, FRONT TABLE, BOTTOM RIGHT
16		42	SCREW, SOCKET HD, 3/8-16 X 1
17		18	SCREW, SOCKET HD, 3/8-16 X 1-1/4

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FIG. 1-1



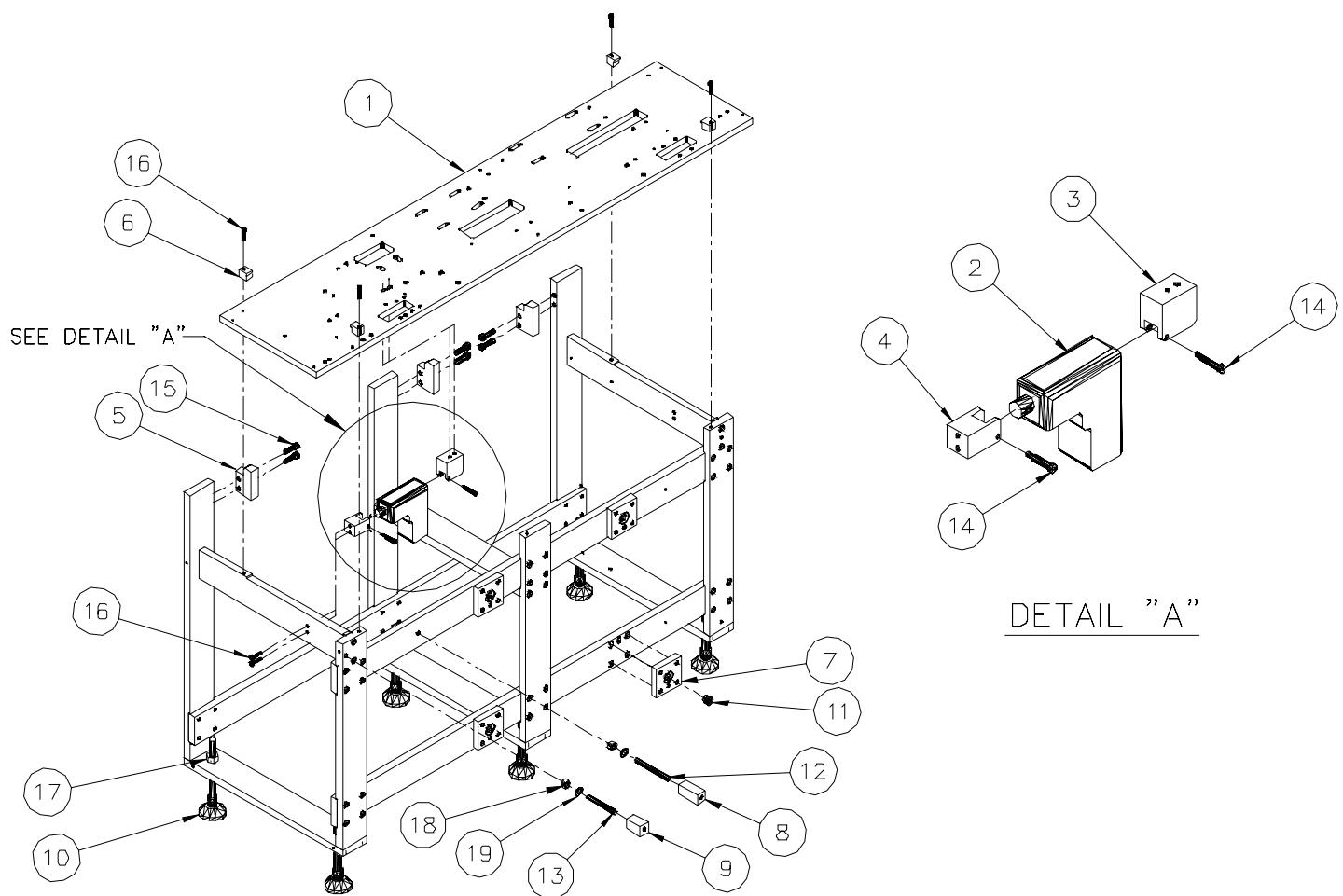
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FRONT TABLE -FRAME (Fig. 1-2)
TOP PLATE / LINEAR ACTUATOR ASSEMBLY

ITEM	PART NO.	QTY.	DESCRIPTION
1	18011-014	1	PLATE, FRONT TABLE DRIVE (REF. ONLY)
2	99014-001	1	LINEAR ACTUATOR, 2" ST.
3	18007-091	1	BLOCK, ACTUATOR MTG
4	18007-038	1	BLOCK, ACTUATOR MTG
5	18007-044	3	BLOCK, TABLE SUPPORT
6	18011-010	4	GIB DRIVE PLATE GUIDE
7	18011-011	4	PAD, COLLATOR MTG.
8	18012-011	1	SPACER, CONVEYOR, LONG
9	18012-010	1	SPACER, CONVEYOR, SHORT
10	99001-001	6	FOOT, ADJUSTING
11	99006-007	4	LINEAR, LOCATING PIN
12	18004-041	2	STUD, 3/8-16 X 4
13	99010-005	4	CASTOR (NOT SHOWN)
14	99003-001	2	BOLT, SHOULDER, 1/4 X 1
15		4	SCREW, SKY HD, 3/8-16 X 1-1/4
16		8	SCREW, SK HD, 1/4-20 X 1-1/4
17		6	NUT, HEX, 5/8-11 (ADJ FOOT)
18		2	NUT, HEX, 3/8-16
19		2	WASHER, FLAT, 3/8

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FIG. 1-2



DETAIL "A"

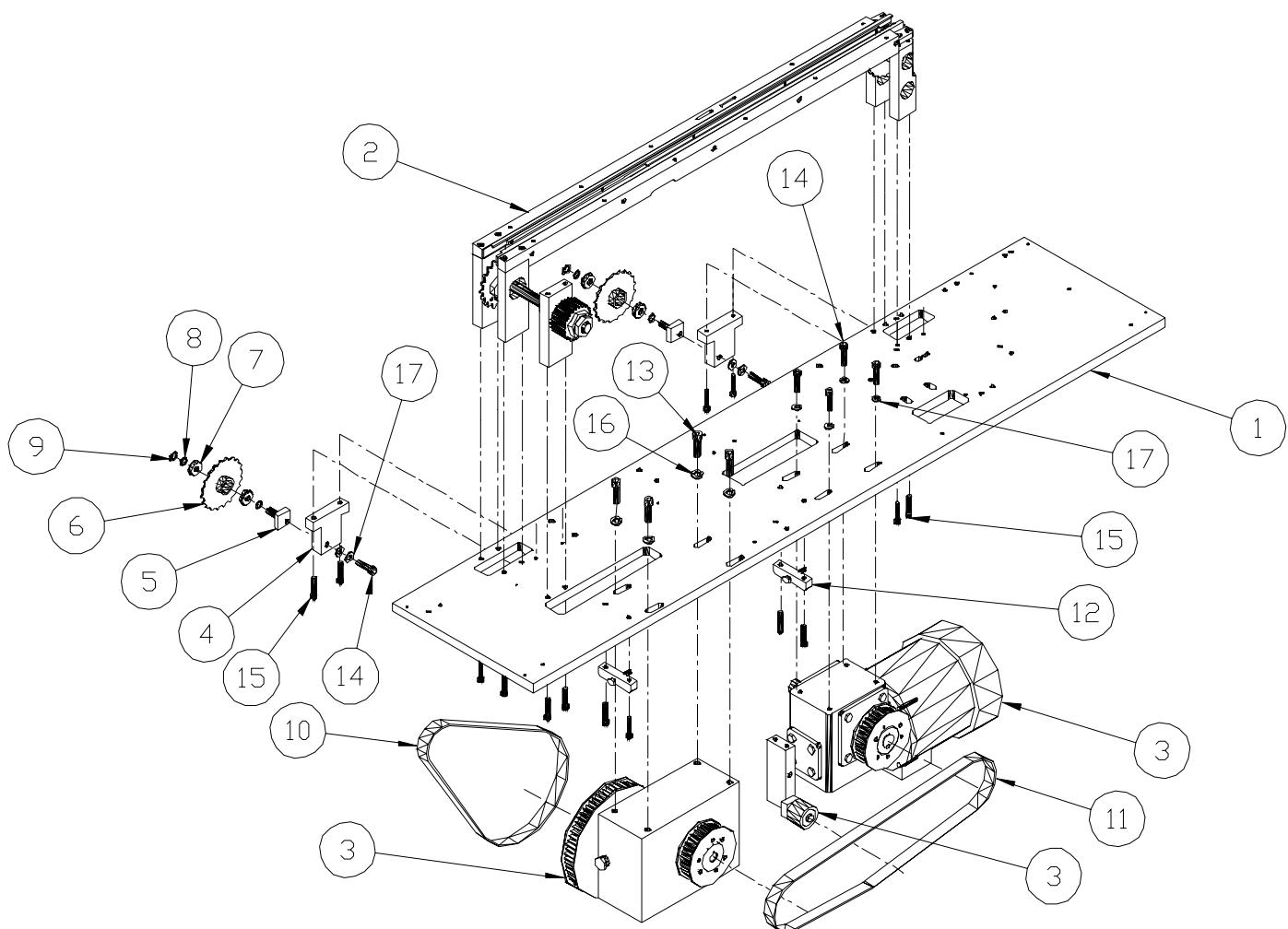
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FRONT TABLE - ENVELOPE CHAIN DRIVE ASSEMBLY (Fig. 1-3)

ITEM	PART NO.	QTY.	DESCRIPTION
1	18011-014	1	PLATE, FRONT TABLE DRIVE (REF)
2	(SEE FIG. 1-4)	1	CHAIN GUIDE ASSEMBLY
3	(SEE FIG. 1-5)	1	MOTOR / REDUCER / INDEXING BOX ASSEMBLY
4	18007-034	2	BLOCK, IDLER, MTG
5	18004-024	2	SHAFT, IDLER, 3/8, ECCENTRIC
6	18015-004	2	SPROCKET, IDLER, 20T
7	99003-008	4	BEARING, 3/8 X 7/8, SEALED
8	99003-017	4	WASHER, NYLON, 3/8 X 1/16
9	99022-003	2	SNAP RING, 3/8
10	99000-011	1	BELT, 840-8M-20
11	99000-010	1	BELT, 1000-8M-20
12		2	BLOCK TAKE UP ASSEMBLY
	18007-078	2	BLOCK, TAKE UP
		2	SCREW, HX HD, 1/4-20 X 2
		2	NUT, HEX, 1/4-20
13		4	SCREW, SK HD, 3/8-16 X 1-1/4
14		4	SCREW, SK HD, 5/16-18 X 1-1/4
15		18	SCREW, SK HD, 1/4-20 X 1-1/4
16		4	WASHER, FLAT (SAE), 3/8
17		6	WASHER, FLAT (SAE), 5/16
18		2	BOLT, HEX HD,(SAE) 5/16-18X1-1/4

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FIG. 1-3



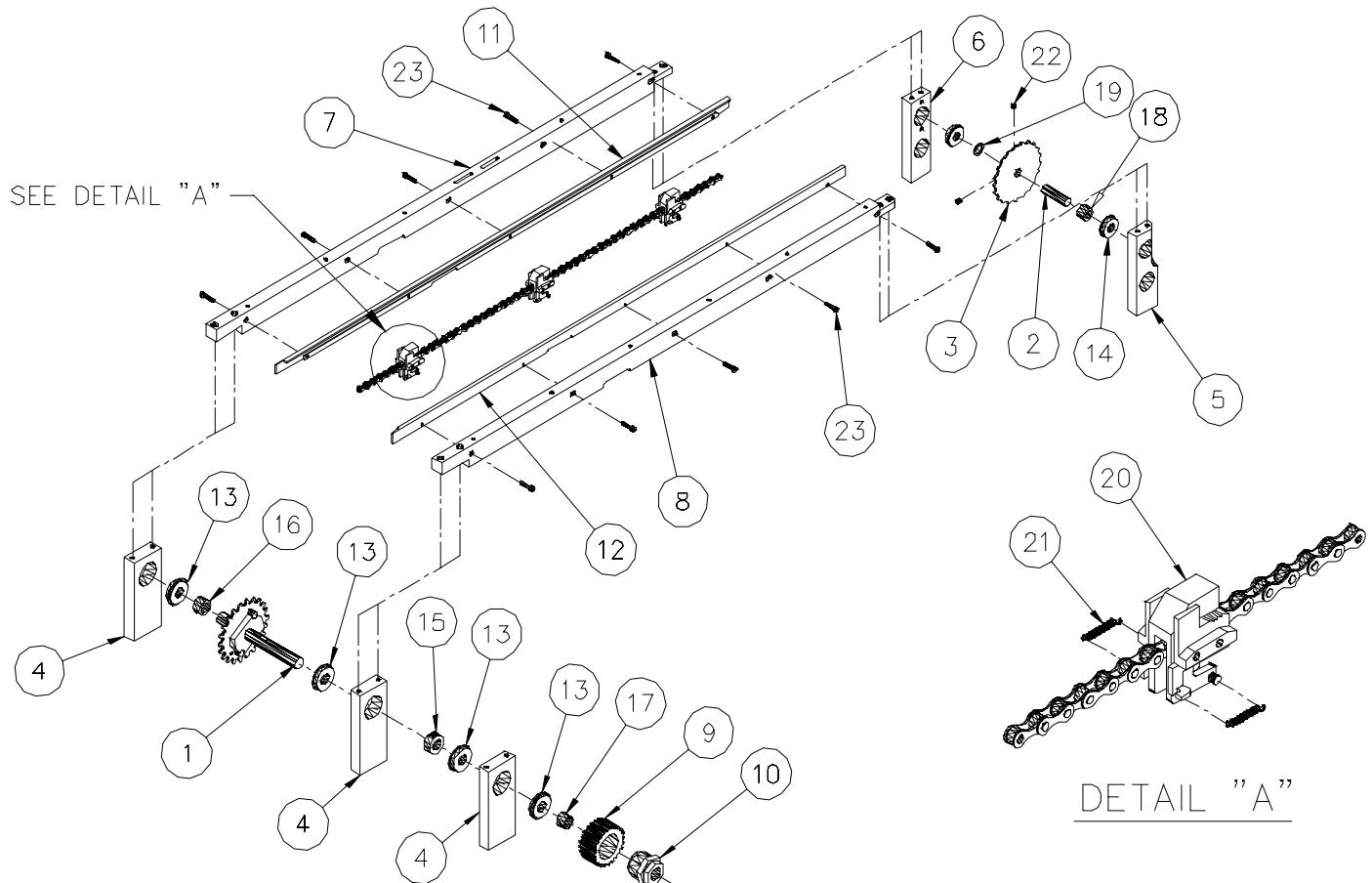
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FRONT TABLE – ENVELOPE CHAIN DRIVE (Fig. 1-4)
CHAIN GUIDE ASSEMBLY

ITEM	PART NO.	QTY.	DESCRIPTION
1	18004-025	1	SPROCKET, SHAFT ASSEMBLY, 22T
2	18004-030	1	SHAFT, IDLER, 1/2
3	18015-005	1	SPROCKET, IDLER, 21T
4	18007-028	3	BLOCK, BEARING, CHAIN SUPPORT
5	18007-026	1	BLOCK, BEARING, CHAIN SUPPORT
6	18007-046	1	BLOCK, BEARING, CHAIN SUPPORT
7	18003-020	1	BAR, CHAIN GUIDE SUPPORT W/ SLOT
8	18003-015	1	BAR, CHAIN GUIDE SUPPORT
9	18006-020	1	PULLEY, 24-8M-20 1-1/2 B
10	99017-010	1	TRANTORQUE, 5/8 B
11	18005-010	1	GUIDE, ENVELOPE CHAIN, RH
12	18005-011	1	GUIDE, ENVELOPE CHAIN, LH
13	99003-006	4	BEARING, 5/8 X 1-3/8, SEALED
14	99003-007	2	BEARING, 1/2 X 1-1/8, SEALED
15	99017-005	1	COLLAR, 5/8 SHAFT
16	99003-030	1	BUSHING, 5/8 X 7/8 X 1/2 (TRIM TO FIT)
17	99003-029	1	BUSHING, 5/8 X 3/4 X 1/2
18	99003-039	1	BUSHING, 1/2 X 3/4 X 1/2
19	99003-018	1	WASHER, NYLON, 1/2 X 1/16
20	18014-008	1	ENVELOPE CHAIN ASSEMBLY (6 X 9)
21	99005-012	2	SPRING, GRIPPER JAW
22		2	SCREW, SET, 1/4-28 X 1/4
23		18	SCREW, SK HD, 8-32 X 3/4

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FIG. 1-4



DETAIL "A"

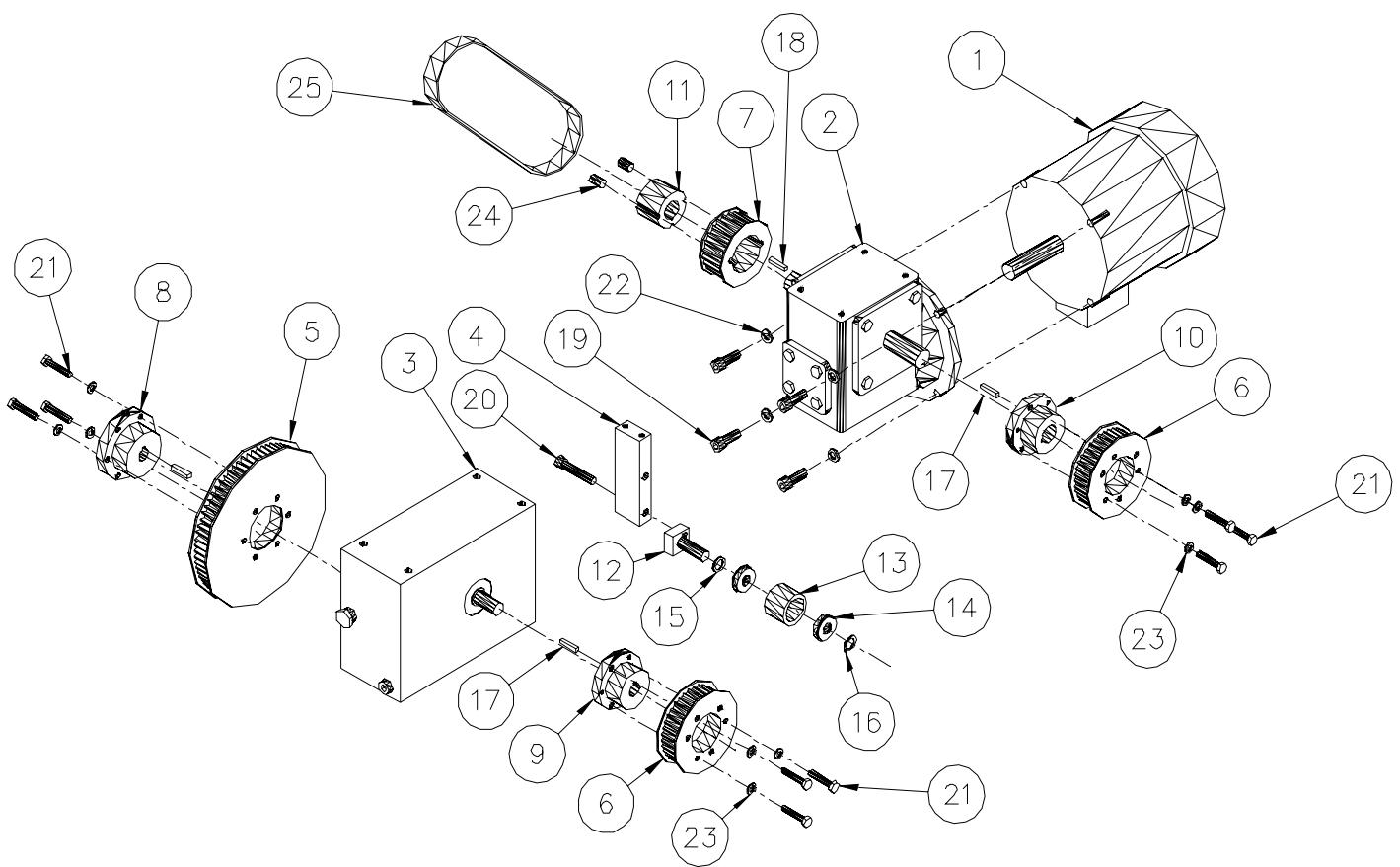
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FRONT TABLE - ENVELOPE CHAIN DRIVE (Fig. 1-5)
MOTOR / REDUCER / INDEXING BOX ASSEMBLY

ITEM	PART NO.	QTY.	DESCRIPTION
1	99001-006	1	MOTOR, 3/4 HP, 1750 RPM
2	99015-001	1	REDUCER, DALTON 1.75 C.D. 10:1
3	99015-003	1	INDEXING BOX, CAMCO 3-180
4	18007-031	1	BLOCK, TENSIONER
5	99002-013	1	PULLEY, 72-8M-20 SDS
6	99002-012	2	PULLEY, 36-8M-20 SH
7	99002-014	1	PULLEY, TL24L100 SH (1210 TAPER LOCK)
8	99017-009	1	BUSHING, QD SDS 5/8 B
9	99017-008	1	BUSHING, QD SH 5/8 B
10	99017-007	1	BUSHING, QD SH 7/8 B
11	99017-011	1	BUSHING, TAPER LOCK 1210 7/8 B
12	18004-022	1	STUD, IDLER, 1/2 ECCENTRIC
13	18006-012	1	PULLEY, IDLER, FLAT
14	99003-007	2	BEARING, 1/2 X 1-1/8 SEALED
15	99003-018	1	WASHER, NYLON, 1/2 X 1-1/16
16	99022-004	1	SNAP RING, 1/2
17	99034-002	2	KEY, SQ 3/16 X 1
18	99034-003	1	KEY, SQUARE, 1/8 X 3/4
19		4	SCREW, SK HD, 3/8-16 X 1
20		1	SCREW, SK HD, 5/16-18 X 2
21		9	SCREW, HX HD, 1/4-20 X 1-3/8
22		4	WASHER, LOCK, 3/8
23		9	WASKER, LOCK, 1/4
24		2	SCREW, SET, 3/8-16 X 5/8
25	99000-012	1	BELT, 187L100

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FIG. 1-5



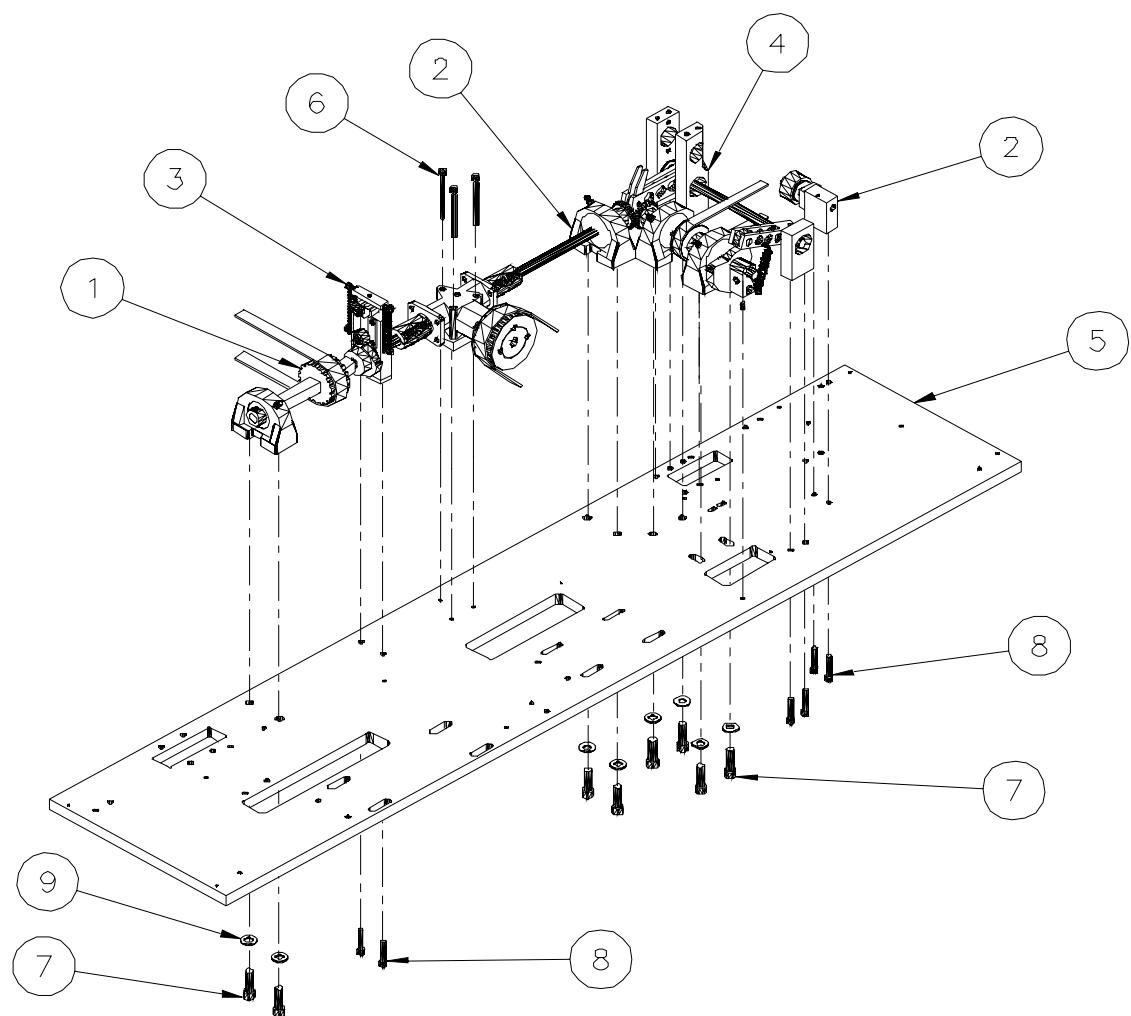
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FRONT TABLE - DRIVE ASSEMBLY (Fig. 1-6)

ITEM	PART NO.	QTY.	DESCRIPTION
1	(SEE FIG. 1-7)	1	CONVEYOR DRIVE ASSEMBLY
2	(SEE FIG. 1-8)	1	SHUTTLE DRIVE ASSEMBLY
3	(SEE FIG. 1-9)	1	CENTER JAW OPENER ASSEMBLY
4	(SEE FIG. 1-10)	1	RIGHT HAND JAW OPENER ASSEMBLY
5	18011-014	1	PLATE, FRONT TABLE DRIVE (REF. ONLY)
6		3	SCREW, SK HD, 1/4-20 X 2-3/4
7		8	SCREW, SK HD, 3/8-16 X 1-1/4
8		6	SCREW, SK HD, 1/4-20 X 1-1/4
9		8	WASHER, FLAT (SAE), 3/8

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FIG. 1-6



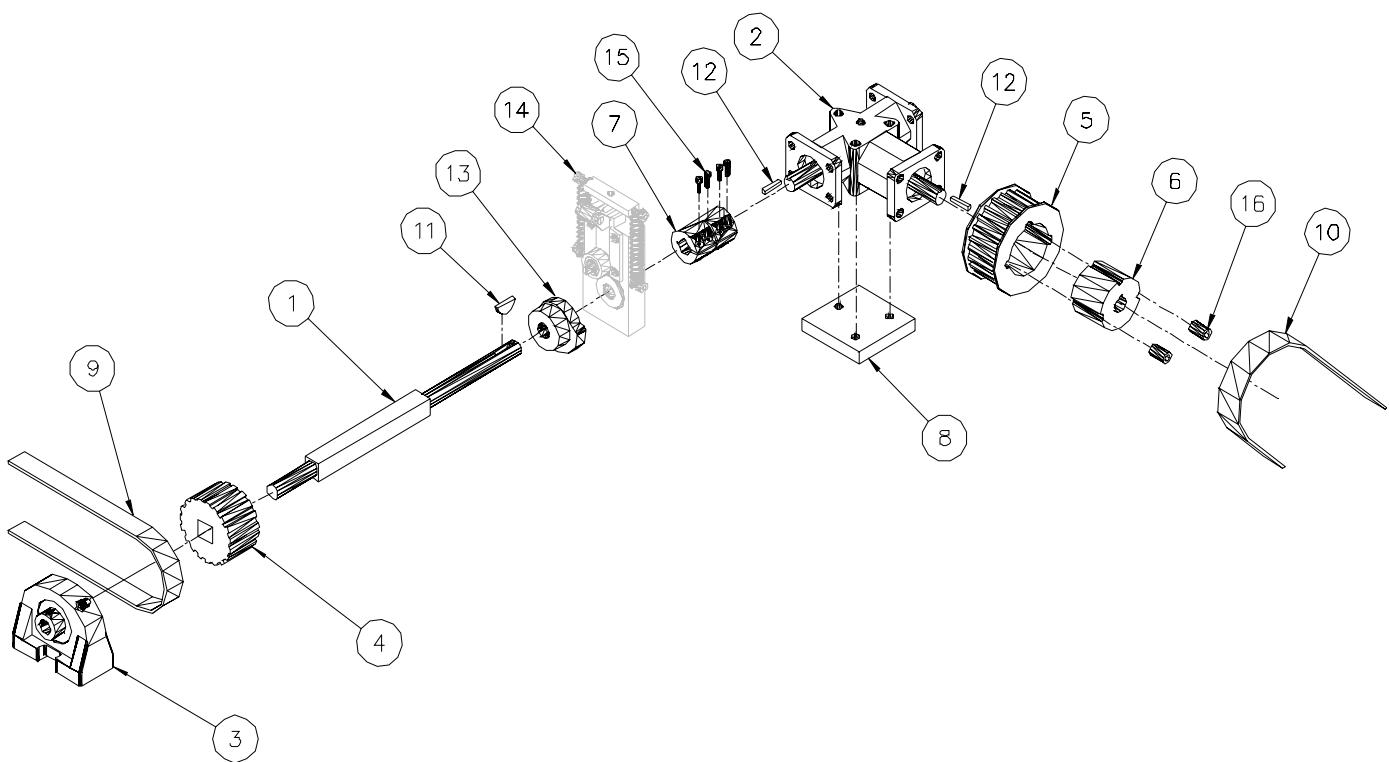
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FRONT TABLE - CONVEYOR DRIVE ASSEMBLY (Fig. 1-7)

ITEM	PART NO.	QTY.	DESCRIPTION
1	18004-026	1	SHAFT, CONVEYOR DRIVE
2	99015-002	1	GEAR BOX, RIGHT ANGLE
3	99003-009	1	BEARING, PILLOW BLOCK, 1/2
4	18006-014	1	PULLEY, 19L 5/8 SQ BORE
5	99002-014	1	PULLEY, TL24L100 SH (1210 TAPER LOCK)
6	99017-012	1	BUSHING, TAPER LOCK 1210 1/2 B
7	99017-001	1	COUPLING, RIGID, 1/2 B
8	18011-009	1	SPACER, GEAR BOX
9	99000-009	1	BELT, TIMING, 337L075
10	99000-012	1	BELT, 187L100 (REF. ONLY)
11	99034-001	1	KEY, WOODRUFF, 1/8 X 3/4
12	99034-003	2	KEY, SQUARE, 1/8 X 3/4
13	18016-008	1	CAM, CENTER JAW OPENER
14	(REF FIG 1-9)	1	CENTER JAW OPENER ASSY
15		4	SCREW, SK HD, 6-32 X 1/2
16		2	SCREW, SET, 5/16-18

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FIG. 1-7



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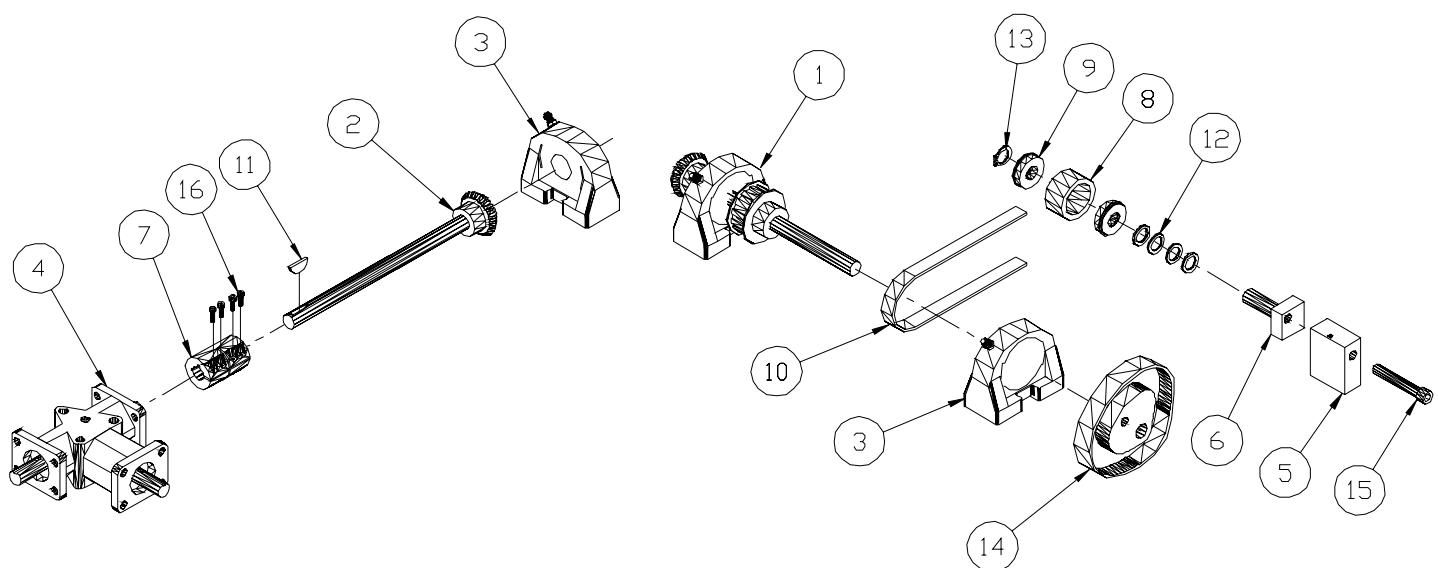
FRONT TABLE – SHUTTLE DRIVE ASSEMBLY (Fig. 1-8)

ITEM	PART NO.	QTY.	DESCRIPTION
1	18004-062	1	SHAFT ASSY, SECONDARY SHUTTLE DRIVE
2	18004-060	1	SHAFT ASSY, PRIMARY SHUTTLE DRIVE
3	99003-009	2	BEARING, PILLOW BLOCK, 1/2
4	99015-002	1	GEAR BOX, RIGHT ANGLE (REF. ONLY)
5	18007-030	1	BLOCK, IDLER MTG
6	18004-022	1	SHAFT, ECCENTRIC IDLER, 1/2
7	99017-001	1	COUPLING, RIGID, 1/2 B
8	18006-011	1	PULLEY, IDLER, FLAT
9	99003-007	2	BEARING, SEALED, 1/2 X 1-1/8
10	99000-013	1	BELT, 240L050
11	99034-001	1	KEY, WOODRUFF, 1/8 X 3/4
12	99003-018	4	WASHER, NYLON, 1/2 X 1/16
13	99022-004	1	SNAP RING, 1/2
14	**18016-026	1	BOX CAM, RH JAW OPENER
15		1	SCREW, SK HD, 5/16-18 X 2
16		4	SCREW, SK HD, 6-32 X 1/2

*** THIS PART NUMBER USED TO BE 18016-012 ***

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FIG.1-8



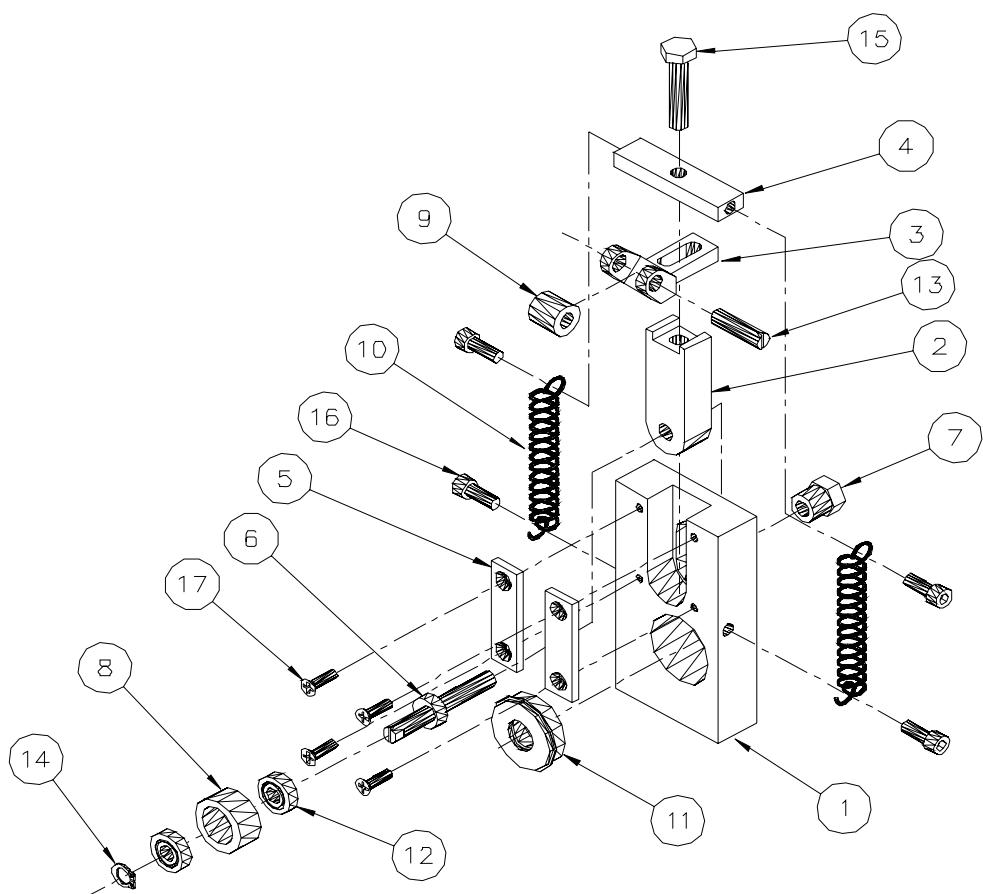
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FRONT TABLE –CENTER JAW OPENER ASSY. (Fig. 1-9)

ITEM	PART NO.	QTY.	DESCRIPTION
1	18007-025	1	BLOCK, CENTER JAW OPENER
2	18007-055	1	SLIDE, CENTER JAW OPENER
3	18009-031	1	BRACKET, ROLLER MTG.
4	18009-004	1	BRACKET, SPRING ATTACHMENT
5	18005-024	2	GIB, CENTER, JAW OPENER
6	99006-008	1	PIN, ECCENTRIC, CTR JAW OPENER
7	99006-014	1	NUT, ECCENTRIC PIN
8	18006-021	1	ROLLER, CTR JAW OPENER
9	99019-001	1	ROLLER, CTR JAW OPENER
10	99005-002	2	SPRING, EXTENSION, CTR JAW OPENER
11	99003-007	1	BEARING, SEALED, 1/2 X 1-1/8
12	99003-002	2	BEARING, SEALED, 1/4 X 5/8
13	99006-015	1	PIN, CENTER JAW ROLLER
14	99022-001	1	SNAP RING, 1/4
15		1	SCREW, HEX HD, 1/4-20 X 1-1/4
16		4	SCREW, SK HD, 10-24 X 5/8
17		4	SCREW, FLAT HD, 6-32 X 3/8

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FIG. 1-9



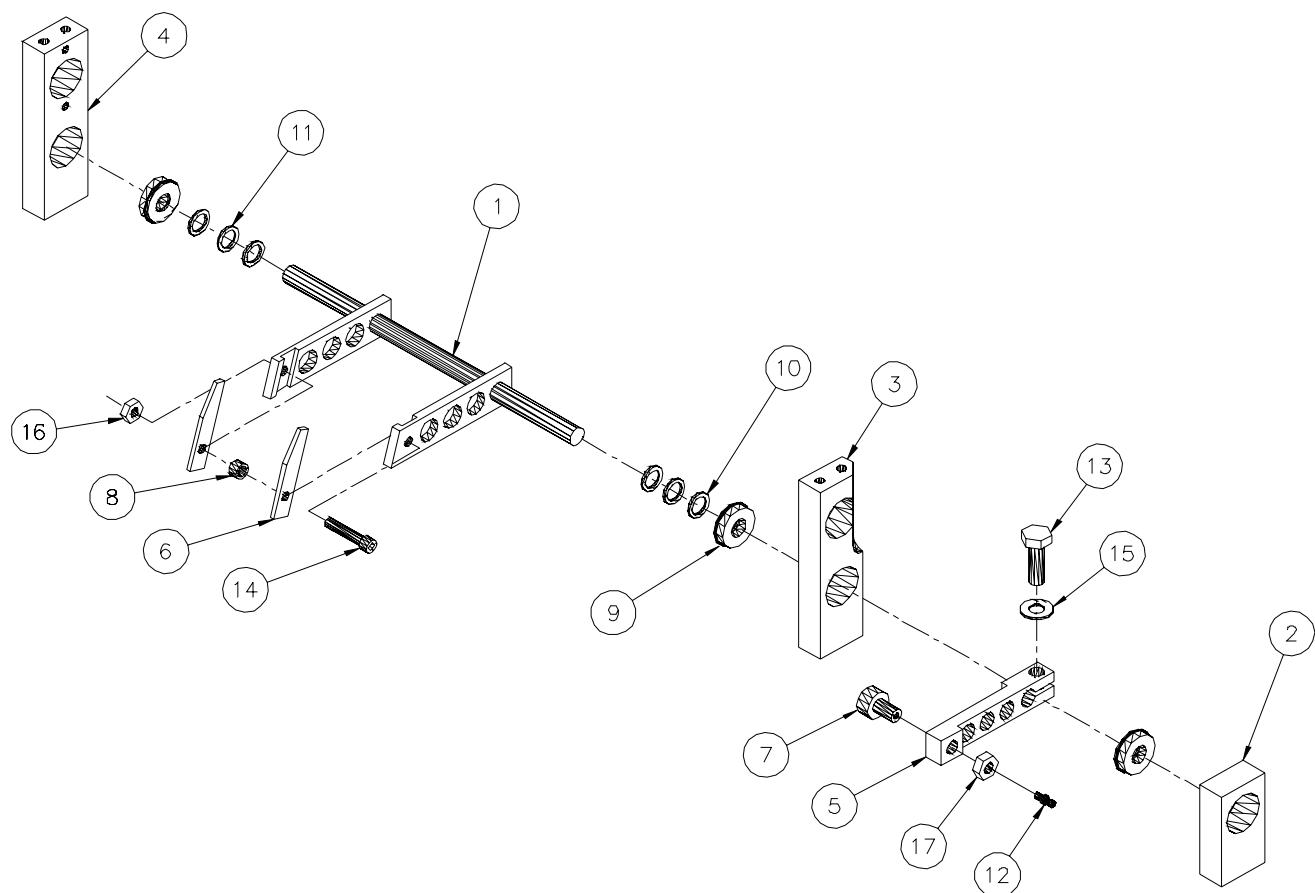
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FRONT TABLE –RIGHT HAND JAW OPENER ASSY. (Fig. 1-10)

ITEM	PART NO.	QTY.	DESCRIPTION
1	11004-072	1	SHAFT ASSEMBLY, RH JAW OPENER
2	18007-027	1	BLOCK, BEARING, RH JAW OPENER
3	18007-026	1	BLOCK, BEARING, CHAIN SUPPORT
4	18007-046	1	BLOCK, BEARING, CHAIN SUPPORT
5	18008-082	1	ARM, RH JAW OPENER
6	18008-048	2	BAR, JAW OPENER
7	99003-052	1	CAM FOLLOWER, RH JAW OPENER
8	99036-001	1	SPACER, RH JAW OPENER
9	99003-007	3	BEARING, SEALED, 1/2 X 1-1/8
10	99003-032	2	WASHER, NYLON, 1/2 X 1/32
11	99003-018	4	WASHER, NYLON, 1/2 X 1/16
12	99028-089	1	GREASE FITTING, .191
13		1	SCREW, HEX HD, 3/8-28 X 3/4
14		1	SCREW, SK HD, 1/4-20 X 1-1/4
15		1	WASHER, FLAT (SAE), 3/8
16		1	NUT, LOCK, 1/4-20
17		1	NUT, LOCK, 3/8-24

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FIG.1-10



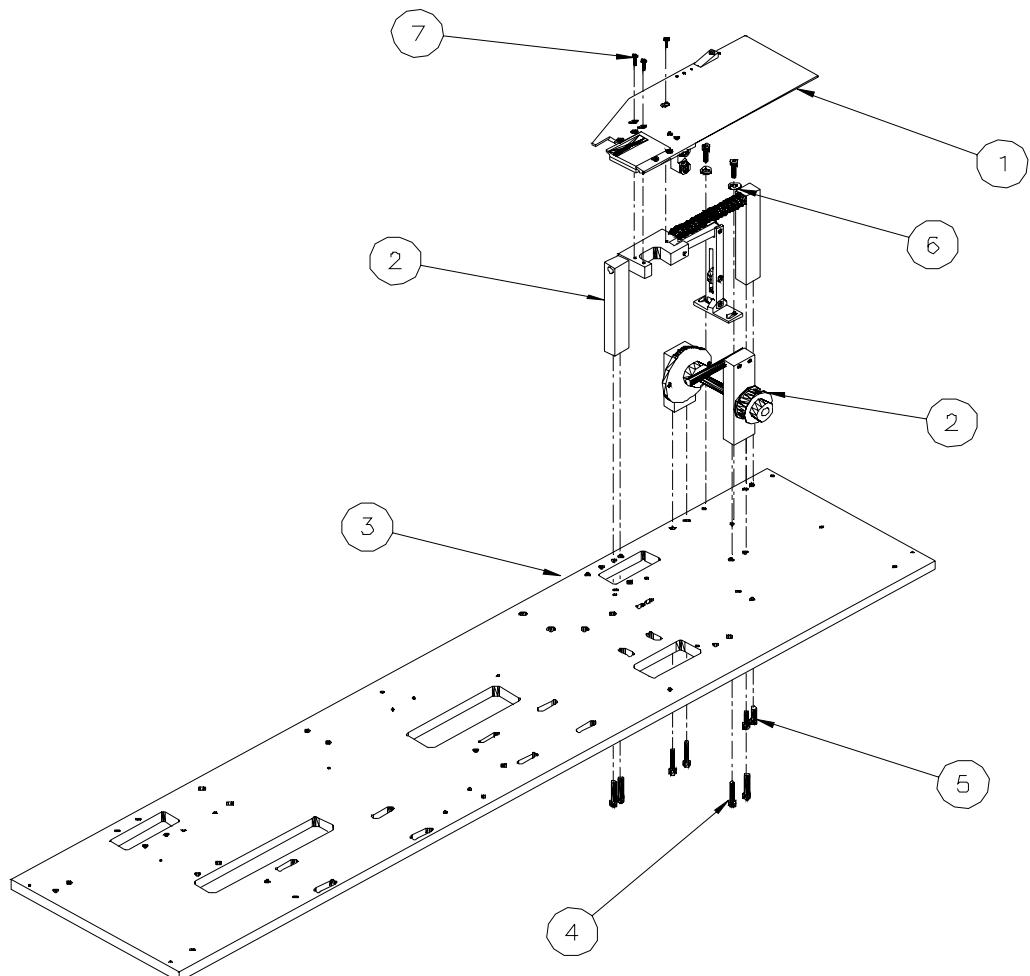
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FRONT TABLE – SHUTTLE ASSEMBLY (Fig. 1-11)

ITEM	PART NO.	QTY.	DESCRIPTION
1	(SEE FIG. 1-12)	1	SHUTTLE PLATE ASSEMBLY
2	(SEE FIG. 1-13)	1	SHUTTLE GUIDE / SHAFT ASSEMBLY
3	18011-014	1	PLATE, FRONT TABLE DRIVE (REF. ONLY)
4		6	SCREW, SK HD, 1/4-20 X 1-1/4
5		4	SCREW, SK HD, 1/4-20 X 3/4
6		2	WASHER, FLAT (SAE), 1/4
7		3	SCREW, PAN HD, 6-32 X 1/2

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FIG.1-11



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FRONT TABLE – SHUTTLE (Fig. 1-12)
SHUTTLE PLATE ASSEMBLY

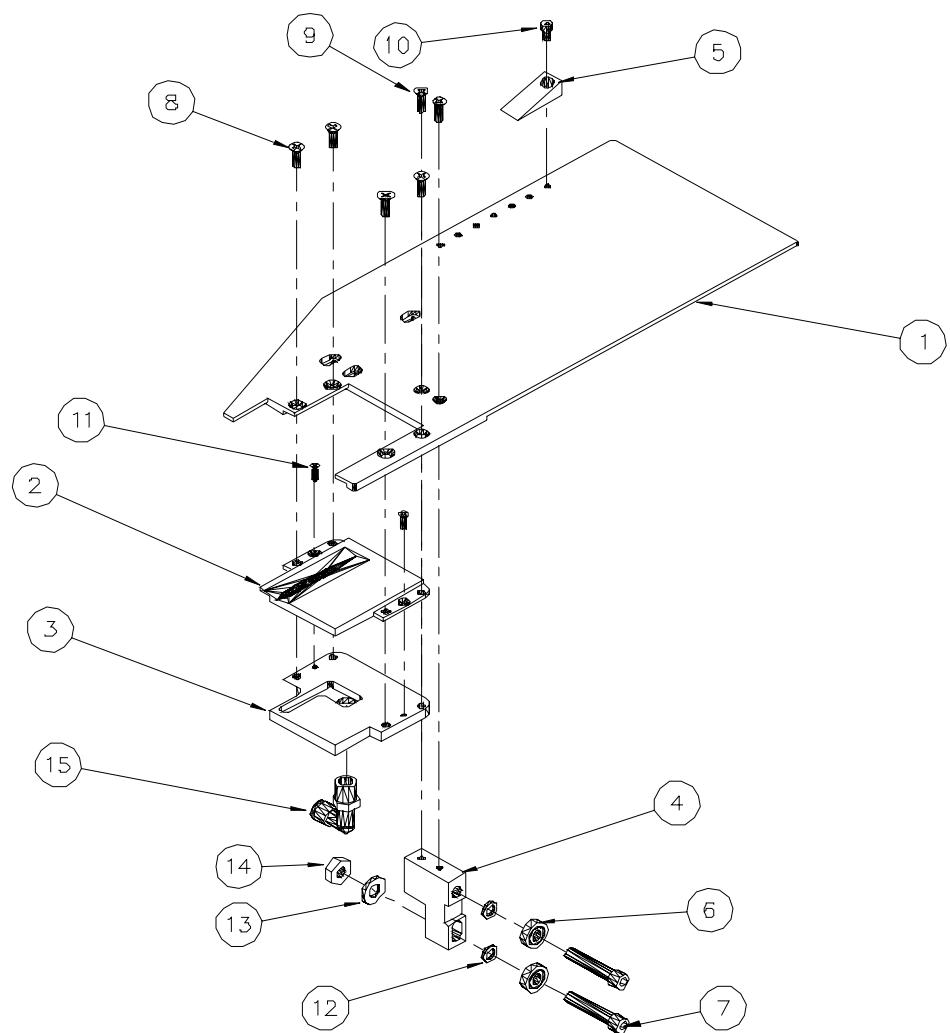
ITEM	PART NO.	QTY.	DESCRIPTION
1	18011-008	1	PLATE, SHUTTLE
2	18011-048	1	PLATE, VACUUM, TOP (SHALLOW) (SEE BELOW REF.)
REF.	(SEE FIG. 1-17)	1	GATE (18005-077) USED W/ ITEM #2, VACUUM PLATE
3	18011-013	1	PLATE, VACUUM, BOTTOM
4	18007-024	1	BLOCK, CAM ROLLER
5	18007-077	1	BLOCK, VIBRATOR
6	99003-002	2	BEARING, SEALED, 1/4 X 5/8
7		2	SCREW, SK HD, 1/4 –20 X
8		4	SCREW, FLAT HD, 8-32 X 3/8
9		2	SCREW, FLAT HD, 6-32 X 1/2
10		1	SCREW, SK HD, 8-32 X 1/4
11		2	SCREW, FLAT HD, 4-40 X 1/4
12	99036-022	2	WASHER, FLAT, HARDENED, 1/4 X 1/16
13		1	WASHER, FLAT (SAE), 1/4
14		1	NUT, LOCK, 1/4
15	99028-085	1	FITTING, MALE ELBOW, 3/8 TUBE X 1/2 NPT

NOTE: OPTIONAL VACUUM PLATES (ITEM 2)

18011-012 - TOP VACUUM PLATE (DEEP), MUST USE W/ GATE (18005-016)
 18011-038 – TOP VACUUM PLATE (FLAT), MUST USE W/ GATE (18005-077)

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FIG. 1-12



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FRONT TABLE – SHUTTLE (Fig. 1-13)
SHUTTLE GUIDE / SHAFT ASSEMBLY

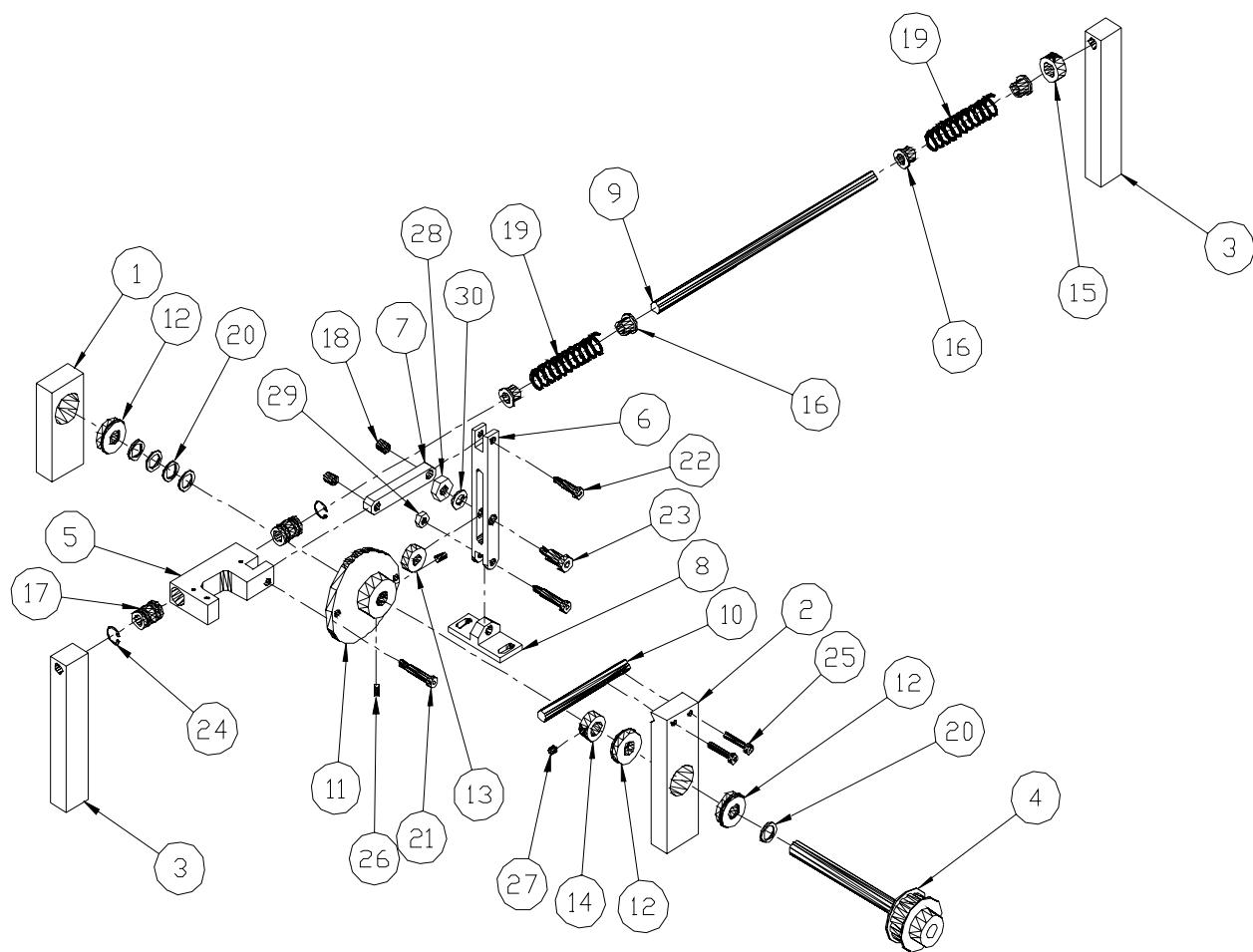
ITEM	PART NO.	QTY.	DESCRIPTION
1	18007-021	1	BLOCK, SHUTTLE DRIVE BEARING
2	18007-020	1	BLOCK, GUIDE SUPPORT
3	18007-019	2	POST, SHUTTLE SUPPORT
4	18004-063	1	SHAFT ASSEMBLY, SHUTTLE DRIVE
5	18007-023	1	BLOCK, SHUTTLE DRIVE
6	18008-017	1	ARM, SHUTTLE DRIVE
7	18008-018	1	LINK, SHUTTLE DRIVE
8	18007-022	1	BLOCK, ARM PIVOT
9	18004-018	1	SHAFT, SHUTTLE GUIDE
10	18004-019	1	SHAFT, SHUTTLE SUPPORT
11	18016-007	1	CAM, SHUTTLE
12	99003-007	3	BEARING, SEALED, 1/2 X 1-1/8
13	99003-008	1	BEARING, 3/8 X 7/8
14	99017-004	1	COLLAR, SHAFT, 1/2
15	99017-003	1	COLLAR, SHAFT, 3/8
16	99003-022	4	BUSHING, FLANGE, 3/8 X 1/2 X 3/8
17	99003-010	2	BEARING, LINEAR, 3/8 B
18	99003-011	3	BUSHING, 1/4 X 5/16 X 3/8
19	99005-005	2	SPRING, SHUTTLE
20	99003-018	5	WASHER, NYLON, 1/2 X 1/16
21	99033-001	1	BOLT, SHOULDER, 1/4 X 1
22	99033-002	2	BOLT, SHOULDER, 1/4 X 5/8
23	99033-003	1	BOLT, SHOULDER, 3/8 X 5/8
24	99022-006	2	RETAINING RING
25		2	SCREW, SK HD, 10-24 X 1
26		2	SCREW, SET, 1/4-28 X 3/8
27		1	SCREW, SET, 1/4-28 X 1/4
28		1	NUT, HEX, 5/16-18
29		1	NUT. LOCK, 10-24

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30		1	WASHER, LOCK, 5/16
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FIG. 1-13



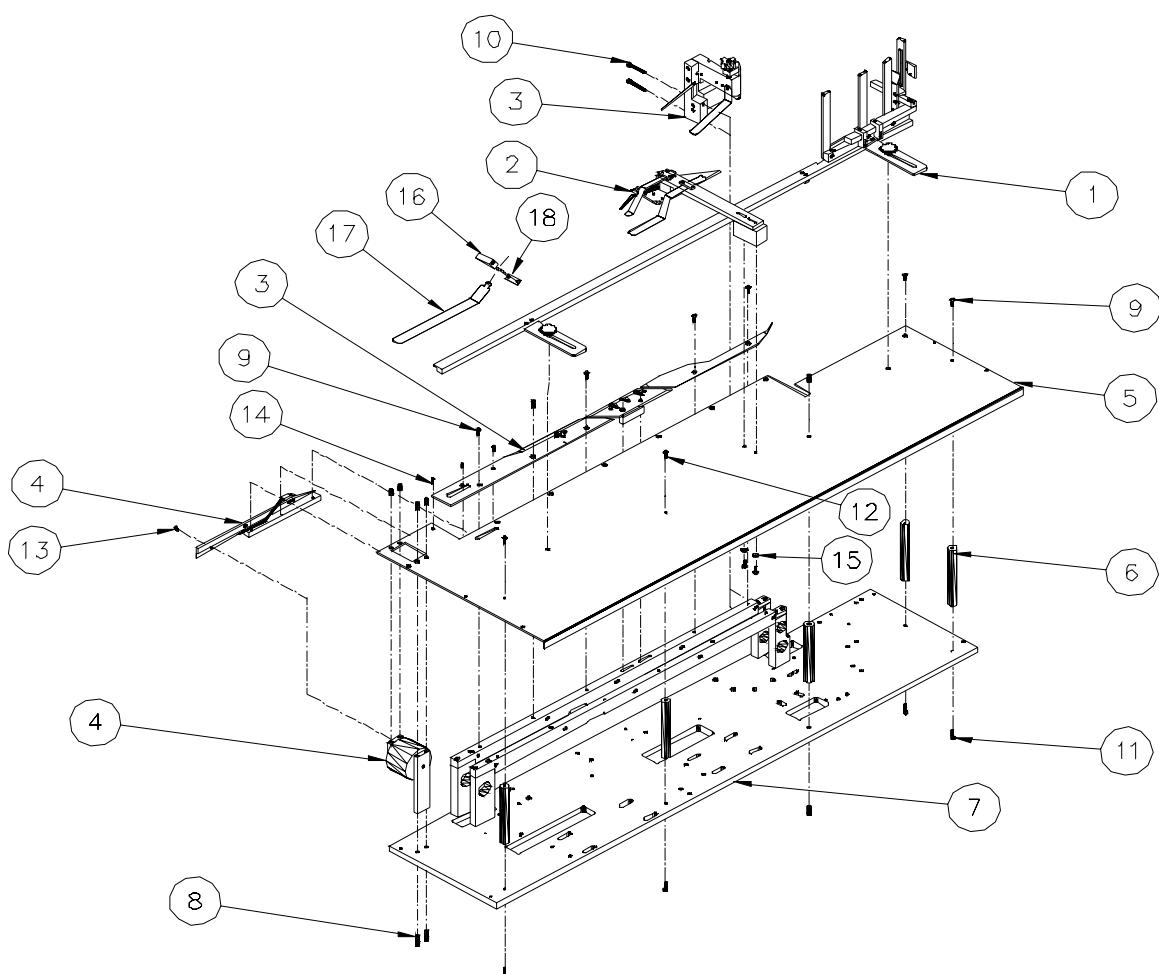
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FRONT TABLE – FRONT TABLE GUIDE ASSEMBLY (Fig. 1-14)

ITEM	PART NO.	QTY.	DESCRIPTION
1	(SEE FIG. 1-15)	1	PAPER GUIDE ASSY.
2	(SEE FIG. 1-16)	1	ENVELOPE PLOW ASSY.
3	(SEE FIG. 1-17)	1	GATE / INSERT GUIDE RAIL ASSEMBLY
4	(SEE FIG. 1-18)	1	ENVELOPE CLOSER / DISCHARGE ROLLER ASSY.
5	18011-016	1	PLATE, TOP, FRONT TABLE
6	18012-008	5	STANDOFF, FRONT TABLE
7	18011-014	1	PLATE, FRONT TABLE DRIVE, 6 X 9 (REF. ONLY)
8		2	SCREW, SK HD, 1/4-20 X 3/4
9		14	SCREW, FLAT HD, 10-24 X 1/2
10		2	SCREW, SK HD, 10-24 X 1-3/4
11		5	SCREW, SK HD, 10-24 X 3/4
12		3	SCREW, BUTTON HD, 10-24 X 1/2
13		1	SCREW, BUTTON HD, 8-32 X 1/4
14		3	SCREW, FLAT HD, 6-32 X 1/2
15		2	WASHER, FLAT, #10
16	18007-061	1	BLOCK, STRAP MTG.
17	18005-028	1	GUIDE, SPRING STEEL @ CLOSING
18	18009-016	1	PLATE, SPRING STEEL CLAMP, 1" CTRS

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FIG. 1-14



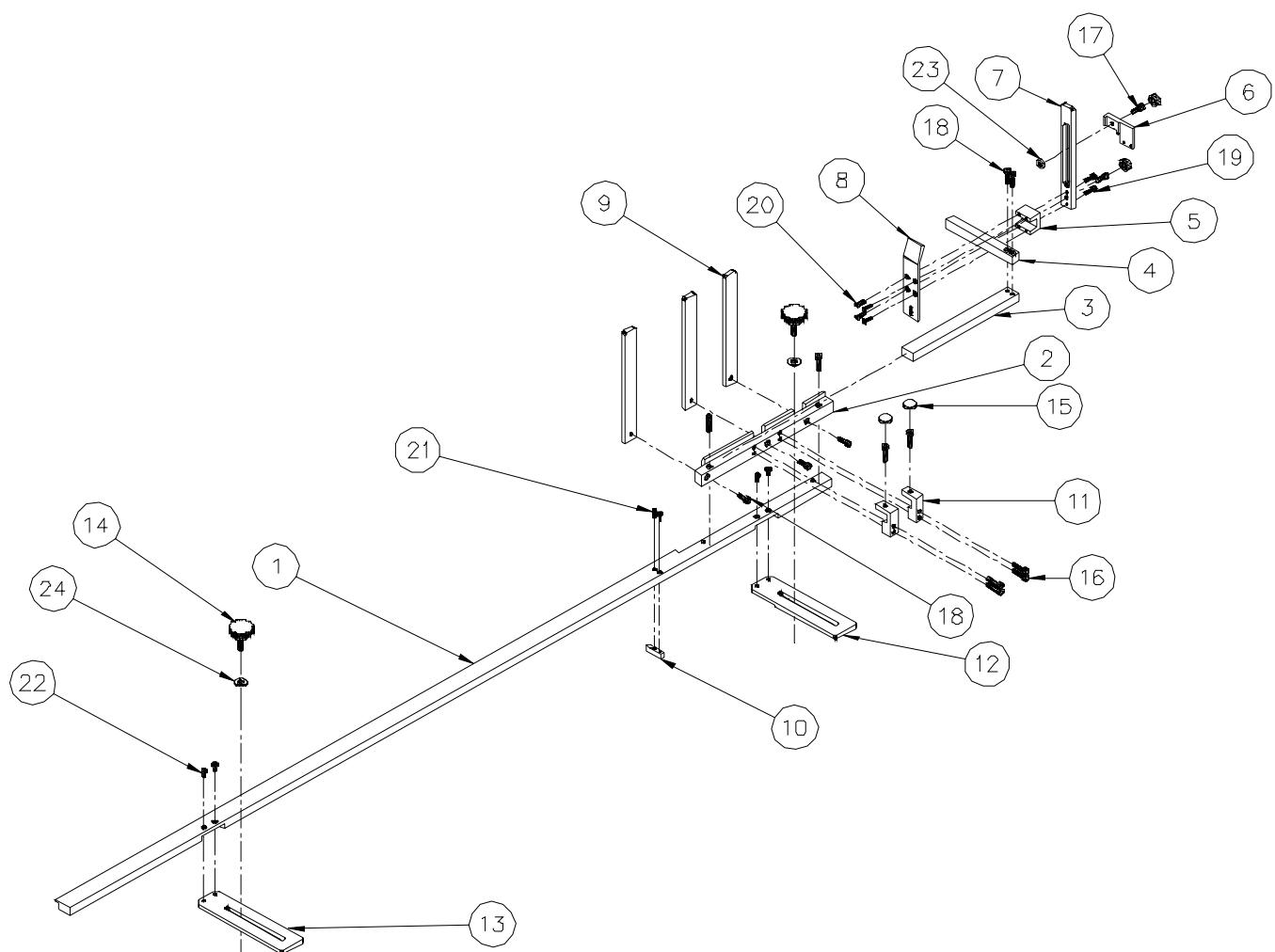
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FRONT TABLE – FRONT TABLE GUIDE (Fig. 1-15)
PAPER GUIDE ASSEMBLY

ITEM	PART NO.	QTY.	DESCRIPTION
1	18005-013	1	RAIL, ENVELOPE GUIDE
2	18007-035	1	BLOCK, PAPER GUIDE MTG.
3	18008-020	1	BAR, PAPER GUIDE ADJ.
4	18008-021	1	BAR, REAR GUIDE SUPPORT
5	18007-047	1	CLAMP, REAR GUIDE MTG.
6	18009-005	1	BRACKET, SENSOR MTG.
7	18005-022	1	GUIDE, ENV HOPPER W/ SLOT
8	18005-015	1	GUIDE, PAPER, REAR
9	18005-014	3	GUIDE, ENV. HOPPER
10	18005-050	1	GUIDE, ENV. CORNER (LOWER)
11	18007-036	2	CLAMP, REAR GUIDE ADJ.
12	18008-026	1	BAR, RAIL MTG. W/ RECESS
13	18008-019	1	BAR, RAIL MTG.
14	99004-004	2	KNOB, RAIL ADJ.
15		4	THUMB CAP, KNULED, #10
16		8	SCREW, SK HD, 10-24 X 3/4
17		5	SCREW, SK HD, 10-24 X 1/2
18		2	SCREW, SK HD, 10-24 X 5/8
19		2	SCREW, SK HE, 6-32 X 1/2
20		4	SCREW, FLAT HD, 6-32 X 3/8
21		2	SCREW, SK HD, 6-32 X 5/8
22		4	SCREW, SK HD, 8-32 X 1/4
23		1	NUT, HEX HD, 10-24
24		2	WASHER, FLAT (SAE), 1/4

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FIG. 1-15



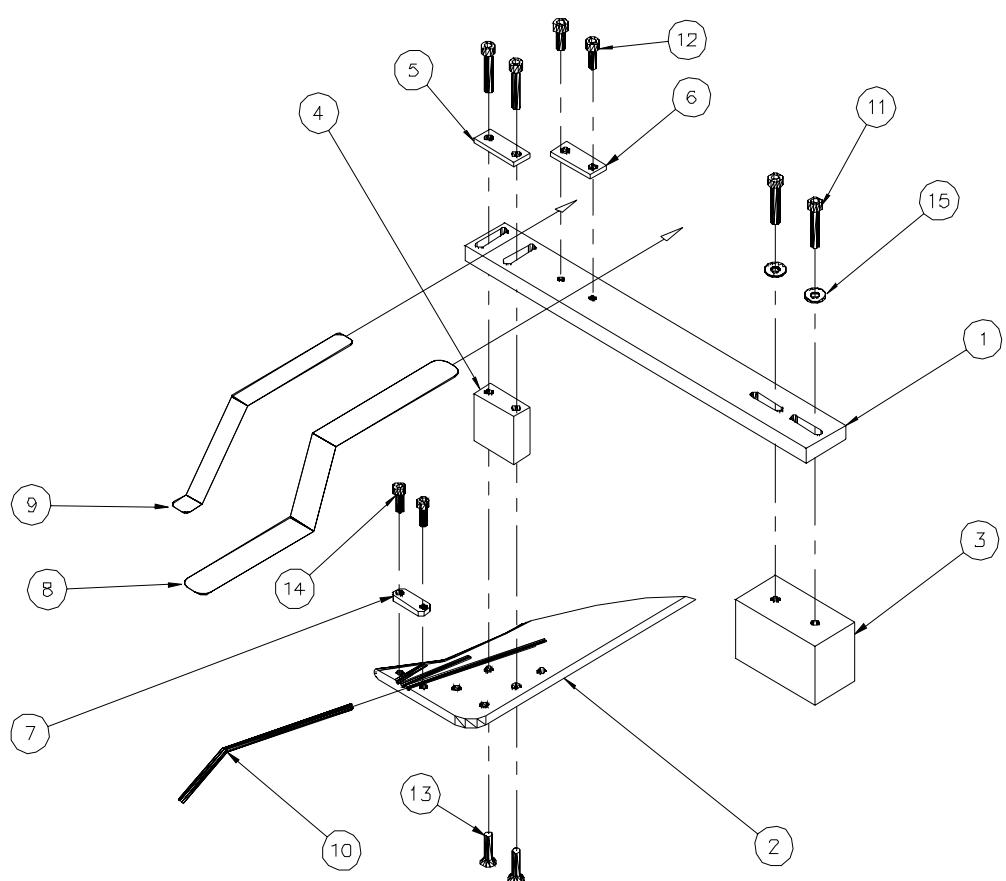
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FRONT TABLE – FRONT TABLE GUIDE (Fig. 1-16)
ENVELOPE PLOW ASSEMBLY

ITEM	PART NO.	QTY.	DESCRIPTION
1	18008-024	1	BAR, ENV. PLOW SUPPORT
2	18005-021	1	PLOW, ENV. OPENER
3	18007-041	1	BLOCK, ENV. PLOW SUPPORT
4	18007-010	1	BLOCK, ENV. PLOW MTG.
5	18009-015	1	BRACKET, SPRING STEEL CLAMP, 7/8" CTRS
6	18009-016	1	BRACKET, SPRING STEEL CLAMP, 1" CTRS
7	18009-007	1	BRACKET, GUIDE WIRE CLAMP
8	18005-027	1	GUIDE, SPRING STEEL @ INSERT
9	18005-026	1	GUIDE, SPRING STEEL @ PLOW
10	18005-060	1	GUIDE WIRE, ENV. PLOW (LONG)
	18005-059	1	GUIDE WIRE, ENV. PLOW (MEDUIM)
	18005-058	1	GUIDE WIRE, ENV. PLOW (SHORT)
11		4	SCREW, SK HD, 10-24 X 1
12		2	SCREW, SK HD, 10-24 X 1/2
13		2	SCREW, FLAT HD, 10-24 X 1/2
14		2	SCREW, SK HD, 8-32 X 1/2
15		2	WASHER, FLAT, #10

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FIG. 1-16



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FRONT TABLE – FRONT TABLE GUIDE (Fig. 1-17)
GATE / INSERT GUIDE RAIL ASSEMBLY

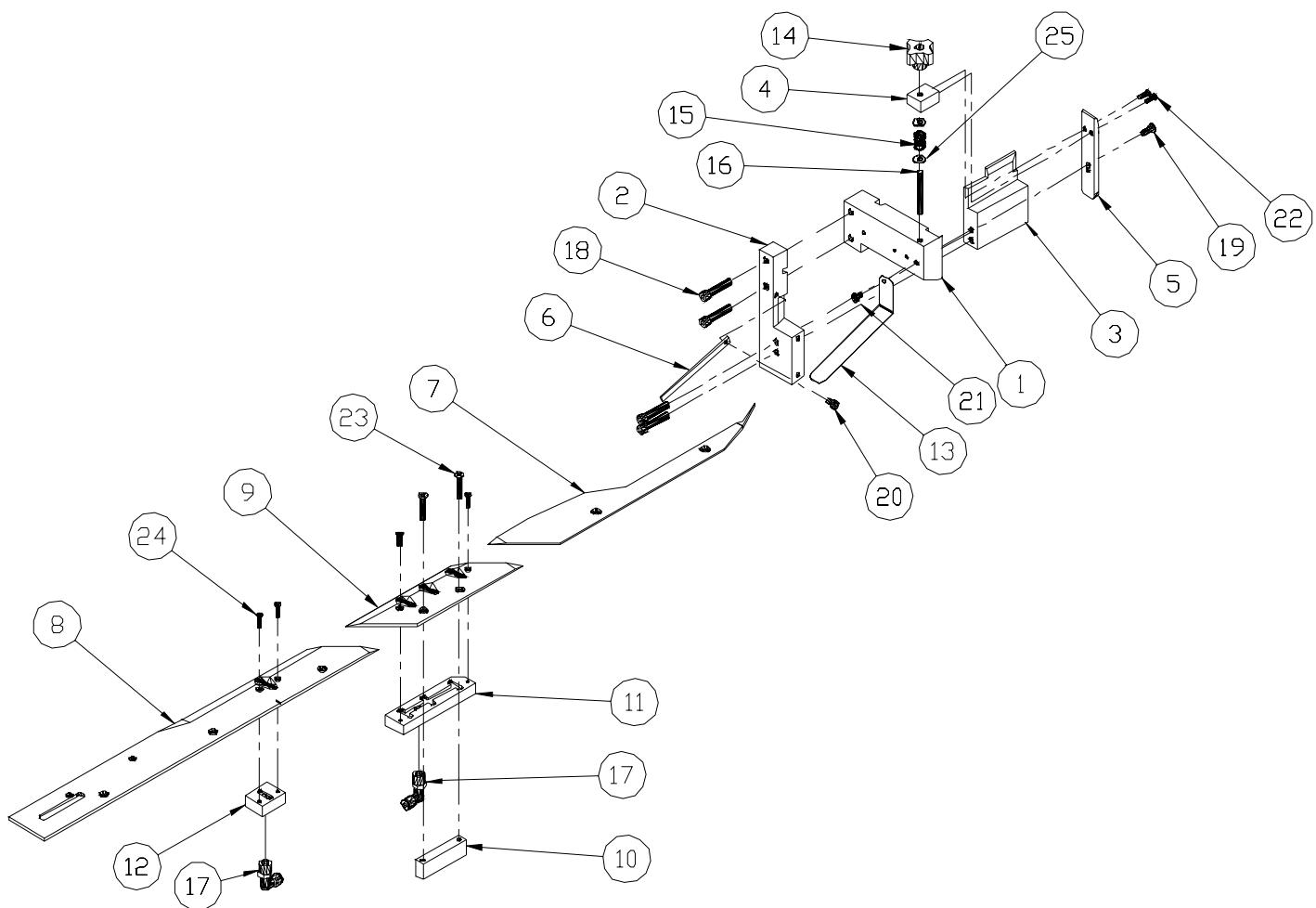
ITEM	PART NO.	QTY.	DESCRIPTION
1	18007-037	1	BLOCK, GATE MTG.
2	18008-022	1	BLOCK, GATE SUPPORT
3	18005-054	1	GUIDE, LOWER ENVELOPE
4	18007-045	1	BLOCK, GATE ADJUSTING
5	18005-077	1	GATE, SEPERATOR (SHALLOW) (SEE BELOW REF.)
REF.	(SEE FIG. 1-14)	1	VACUUM PLATE (SHALLOW)(18011-048) OR VACUUM PLATE (FLAT) (18011-038) USED W/ ITEM 5, GATE
6	18005-073	1	GUIDE, ENVELOPE, PRE-OPENER
7	18011-031	1	RAIL, TOP, INSERT GUIDE
8	18011-017	1	RAIL, TOP, INSERT GUIDE
9	18011-030	1	RAIL, TOP, INSERT GUIDE
10	18008-043	1	BAR, SLIDING NUT
11	18007-069	1	BLOCK, MANIFOLD (ADJUSTABLE)
12	18007-081	1	BLOCK, MANIFOLD (FIXED)
13	18005-025	1	GUIDE, SPRING STEEL @GATE
14	99004-005	1	KNOB, 10-32, FEMALE
15	99005-007	1	SPRING, GATE ADJ
16	99032-004	1	STUD, 10-32 X 2-1/2
17	99028-022	2	FITTING, MALE ELBOW, 3/8 TUBE X 1/8 NPT
18		4	SCREW, SK HD, 1/4-20 X 1-1/4
19		1	SCREW, PAN HD, 10-24 X 1/2
20		1	SCREW, SK HD, 10-24 X 1/4
21		1	SCREW, PAN HD, 10-24 X 1/4
22		2	SCREW, FLAT HD, 8-32 X 1/2
23		2	SCREW, FLAT HD, 10-24 X 1
24		4	SCREW, FLAT HD, 6-32 X 1/2
25		2	WASHER, FLAT, #10

NOTE: OPTIONAL GATE (ITEM 5)

18005-016 GATE, SEPERATOR (DEEP), MUST USE W/ VACUUM PLATE (DEEP) (18011-012)

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FIG. 1-17



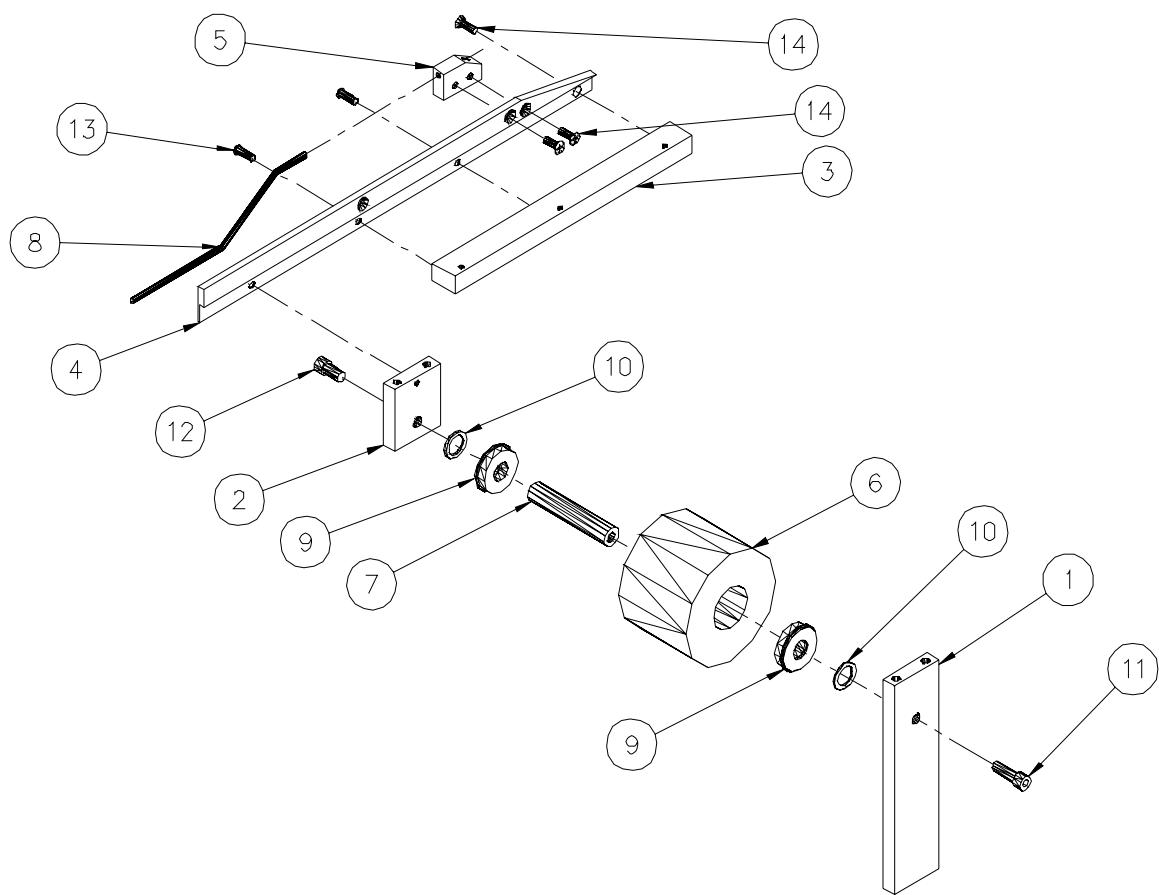
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FRONT TABLE – FRONT TABLE GUIDE (Fig. 1-18)
ENVELOPE CLOSER / DISCHARGE ROLLER ASSEMBLY

ITEM	PART NO.	QTY.	DESCRIPTION
1	18007-032	1	BLOCK, MTG, BEARING
2	18007-033	1	BLOCK, MTG, BEARING SUPPORT
3	18007-052	1	BLOCK, ENVELOPE CLOSER MTG.
4	18005-023	1	GUIDE, ENVELOPE CLOSER
5	18009-006	1	BRACKET, ENVELOPE CLOSER
6	18006-013	1	ROLLER, DISCHARGE
7	18004-023	1	SHAFT, DISCHARGE ROLLER
8	18005-061	1	GUIDE WIRE, ENVELOPE CLOSER
9	99003-007	2	BEARING, SEALED, 1/2 X 1-1/8
10	99003-018	2	WASHER, NYLON, 1/2 X 1/16
11		1	SCREW, SK HD, 1/4-20 X 3/4
12		1	SCREW, SK HD, 1/4-20 X 1/2
13		1	SCREW, BUTTON HD, 8-32 X 1/2
14		3	SCREW, FLAT HD, 8-32 X 1/2

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FIG. 1-18



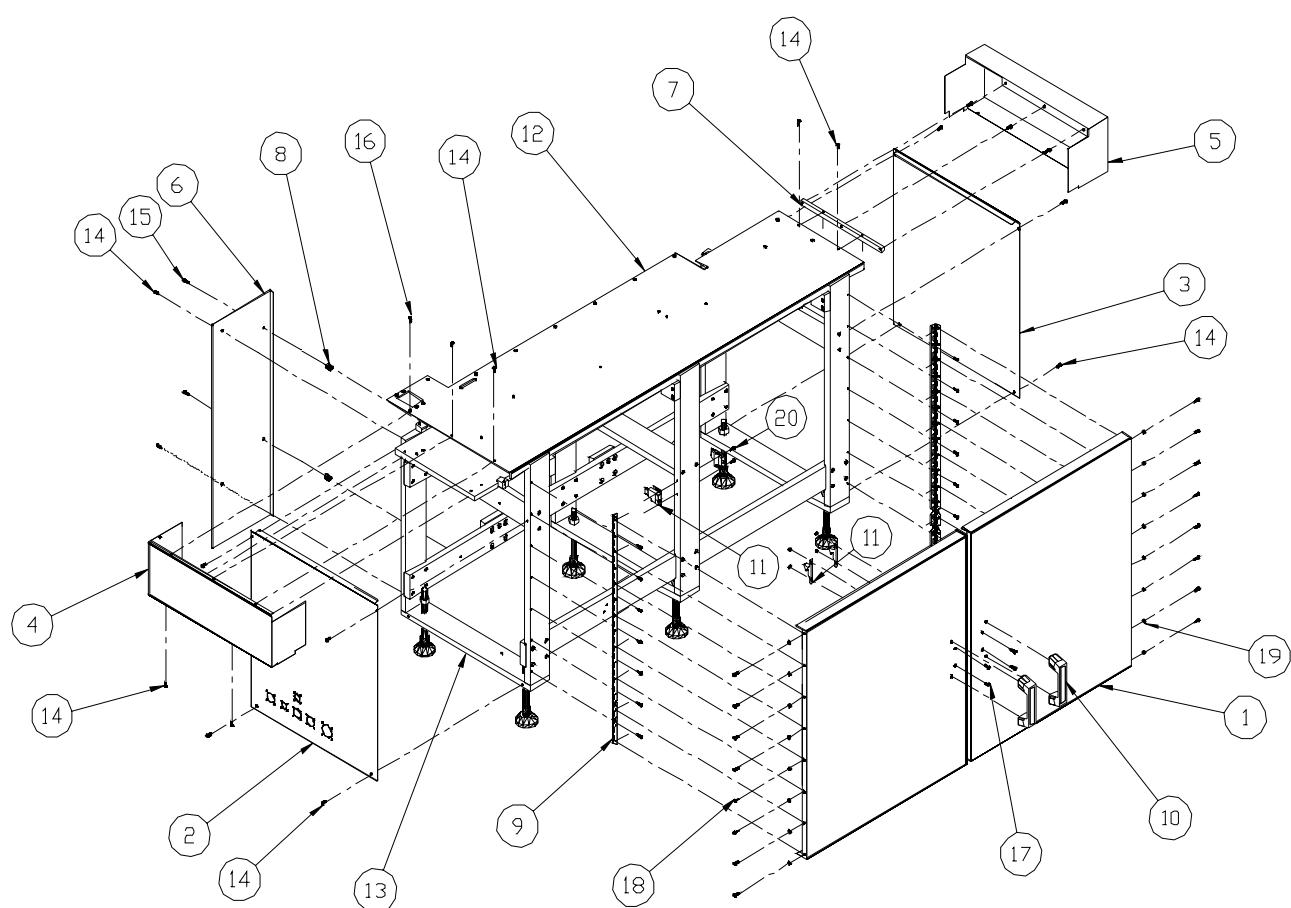
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FRONT TABLE – COVERS (Fig. 1-19)

ITEM	PART NO.	QTY.	DESCRIPTION
1	18013-004	2	DOOR, FRONT TABLE
2	18013-012	1	COVER, SIDE W/ HOLES
3	18013-007	1	COVER, SIDE
4	18013-006	1	COVER, END CAP, LH
5	18013-005	1	COVER, END CAP, RH
6	18013-008	1	COVER, REAR, RH
7	18008-025	1	BAR, END COVER MTG.
8	18012-007	2	STANDOFF, 1/2 X 5/8
9	18013-013	2	HINGE, FRONT TABLE DOOR
10	99012-001	2	HANDLE, FRONT TABLE DOOR
11	99013-002	2	LATCH W/ SWITCH
12	18011-016	1	PLATE, TOP, FRONT TABLE (REF ONLY)
13		1	FRAME, 6 X 9 (REF ONLY)
14		16	SCREW, BUTTON HD, 10-24 X 1/2
15		5	SCREW, SK HD, 10-24 X 1/2
16		1	SCREW, FLAT HD, 10-24 X 1/2
17		4	SCREW, PAN HD, 8-32 X 1/2
18		28	SCREW, BUTTON HD, 8-32 X 1/2
19		18	NUT, LOCK, 8-32
20		4	SCREW, SK HD, 6-32 X 1/2

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FIG. 1-19



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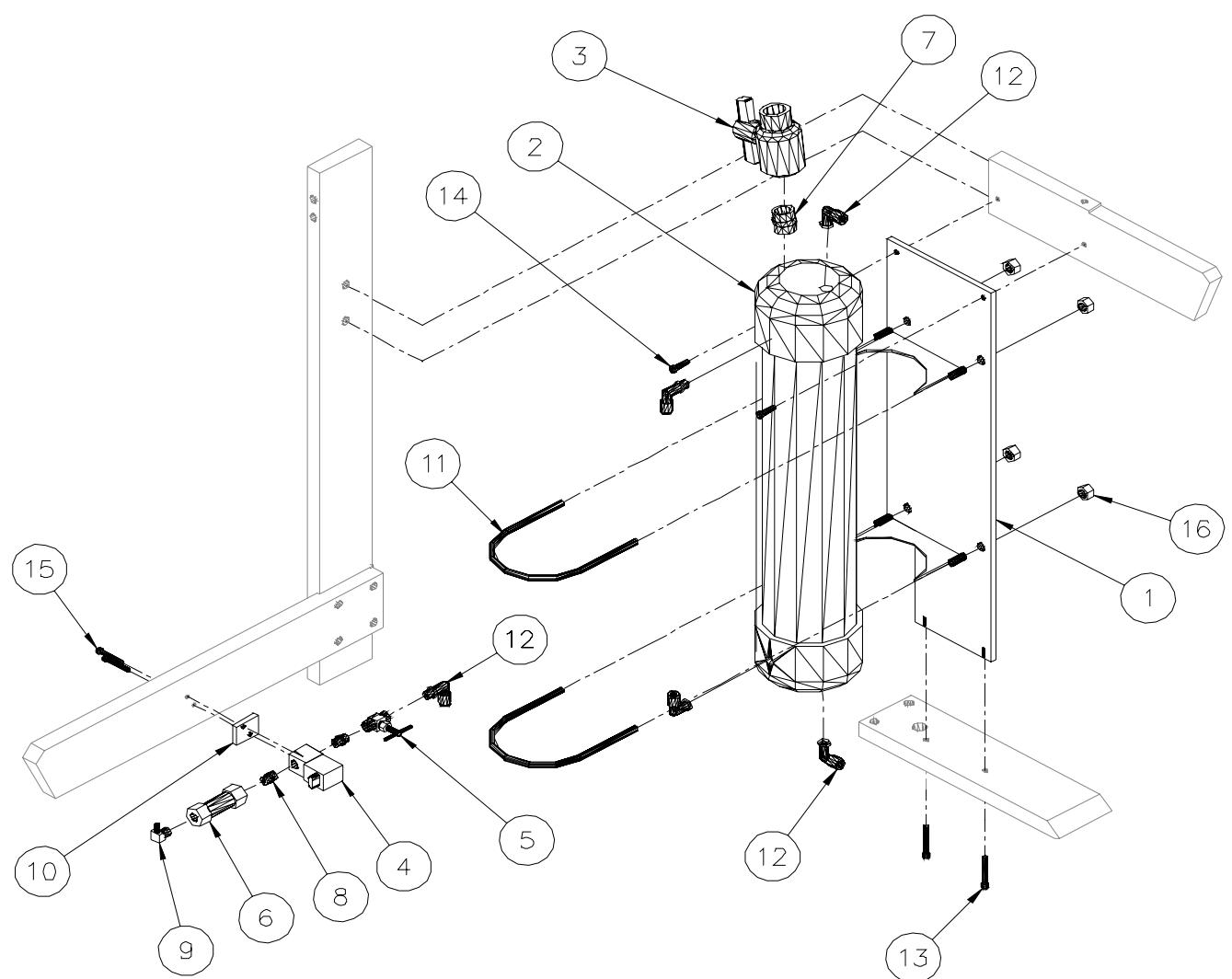
FRONT TABLE – WATER BRUSH ASSEMBLY (Fig. 1-20)

ITEM	PART NO.	QTY.	DESCRIPTION
1	18011-037	1	PLATE, WATER TANK MTG.
2	18019-008	1	TANK, WATER
3	99025-008	1	VALVE, BALL PVC, 1/2 NPT
4	99025-007	1	VALVE, WATER SOLENIOD, 24 VOLT DC, 1/8 NPT
5	99028-044	1	VALVE, PET COCK
6	99027-003	1	STRAINER, 1/8 NPT
7	99028-081	1	NIPPLE, CLOSE, PVC, 3/4 NPT
8	99028-041	2	NIPPLE, CLOSE, 1/8 NPT
9	99028-043	1	FITTING, HOSE BARB, ELBOW, 1/8 NPT X 1/8 ID HOSE
10	18012-019	1	SPACER, WATER SOLENIOD
11	99024-001	2	U-BOLT, 4" PIPE
12	99028-074	5	MALE ELBOW, 1/8 NPT X 1/4 T
13		2	SCREW, SKT HD, 10-24 X 1-1/4
14		2	SCREW, SKT HD, 10-24 X 3/4
15		2	SCREW, SKT HD, 8-32 X 1-1/4
16		4	NUT, HEX, 3/8-16
17	99031-012	10'	HOSE, CLEAR, 1/4" (NOT SHOWN)

NOTE: VYNYL TUBING NOT SHOWN (ITEM 21)

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FIG. 1-20

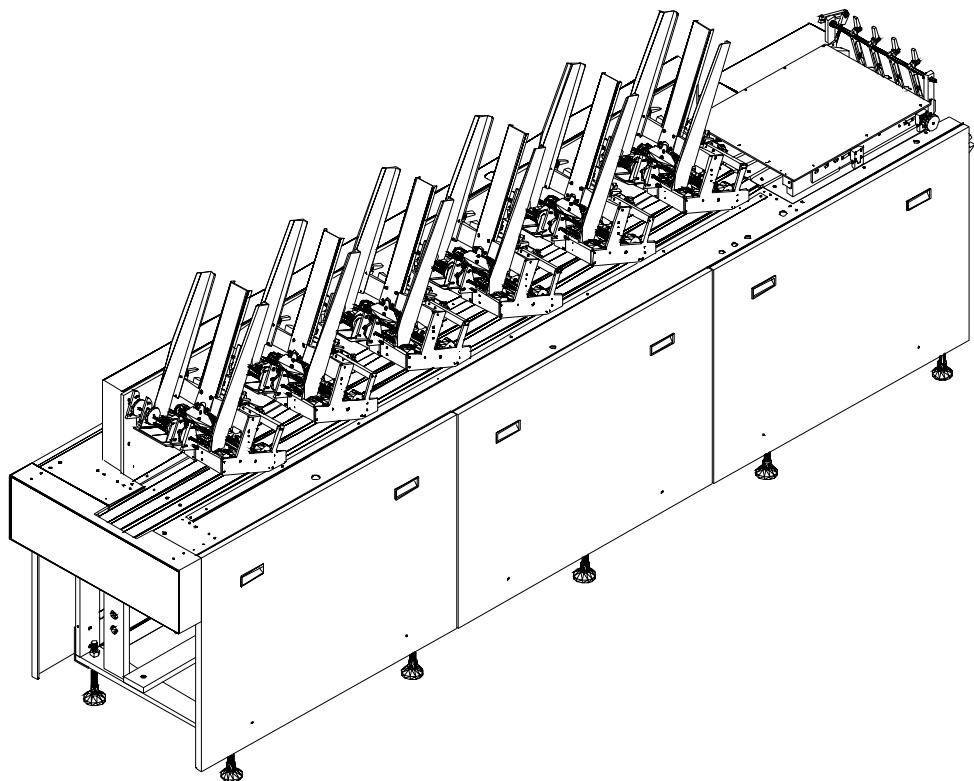


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COLLATOR

6 X 9



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COLLATOR – FRAME ASSEMBLY (Fig. 2-1)

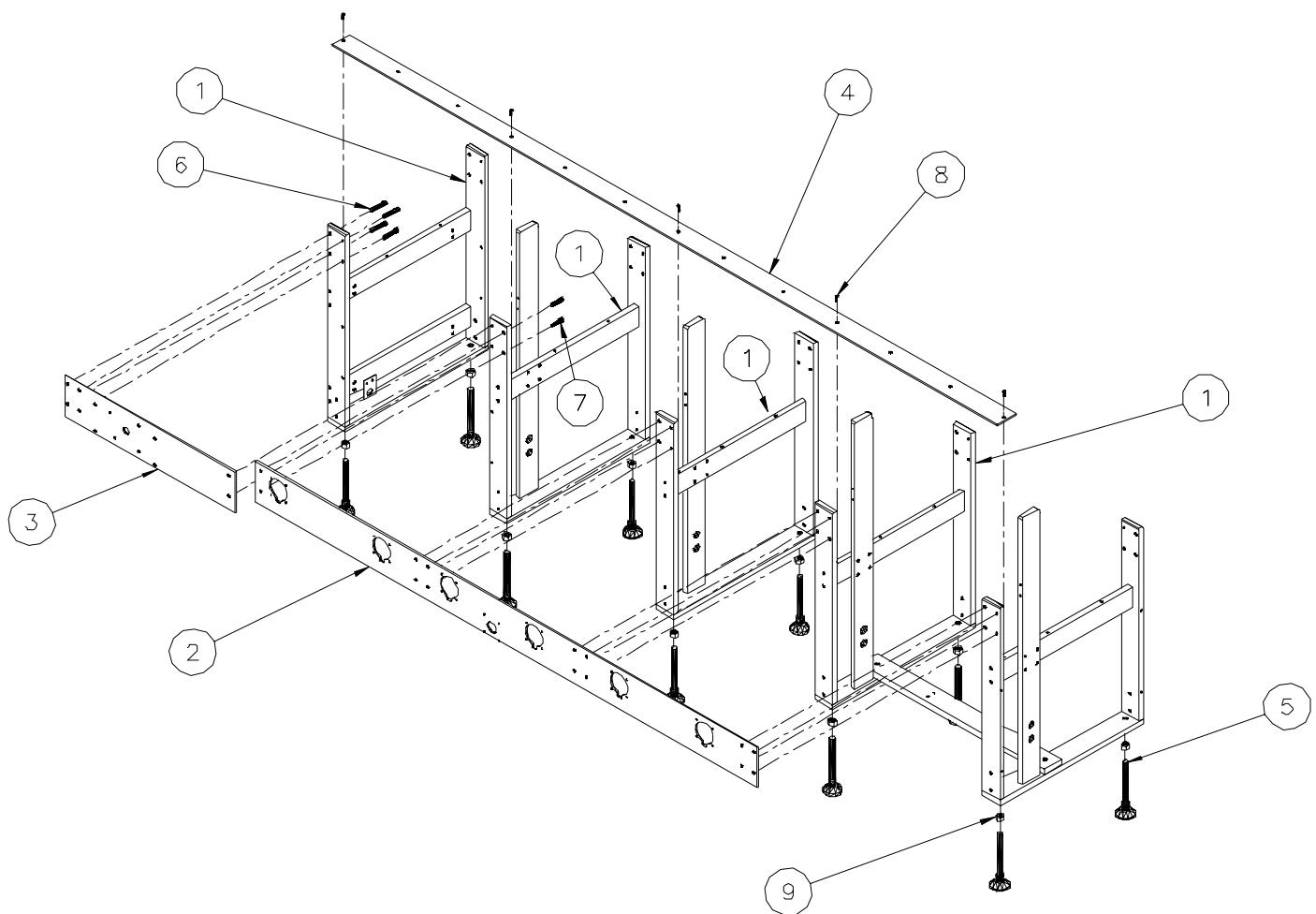
ITEM	PART NO.	QTY.	DESCRIPTION
1	(SEE FIG. 2-2)	1	FRAME ASSEMBLY
*2	18011-050	1	PLATE, CLUTCH MTG. (6 STATION)
2a	18011-063	1	PLATE, CLUTCH MTG. (3 STATION) ALSO USED AS 9 STATION EXTEXSION)
3	18011-066	1	PLATE, PUSHER DRIVE MTG. (6 X 9)
4	18008-072	1	BAR, WIREWAY MTG. (6 STATION)
4a	18008-092	1	BAR, WIREWAY MTG. (3 STATION)
4b	18008-075	1	BAR, WIREWAY MTG. (9 STATION)
5	99010-001	10	FOOT, ADJUSTING
6		6	SCREW, SKT HD, 3/8-16 X 2
7		14	SCREW, SKT HD, 3/8-16 X 1-1/2
8		5	SCREW, FLAT HD. 10-24 X 1/2
9		10	NUT, HEX, 5/8-11

* USE IN GREATER QUANTITY FOR EVERY 6 STATION ADDED TO LENGTH OF MACHINE

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Fig. 2-1



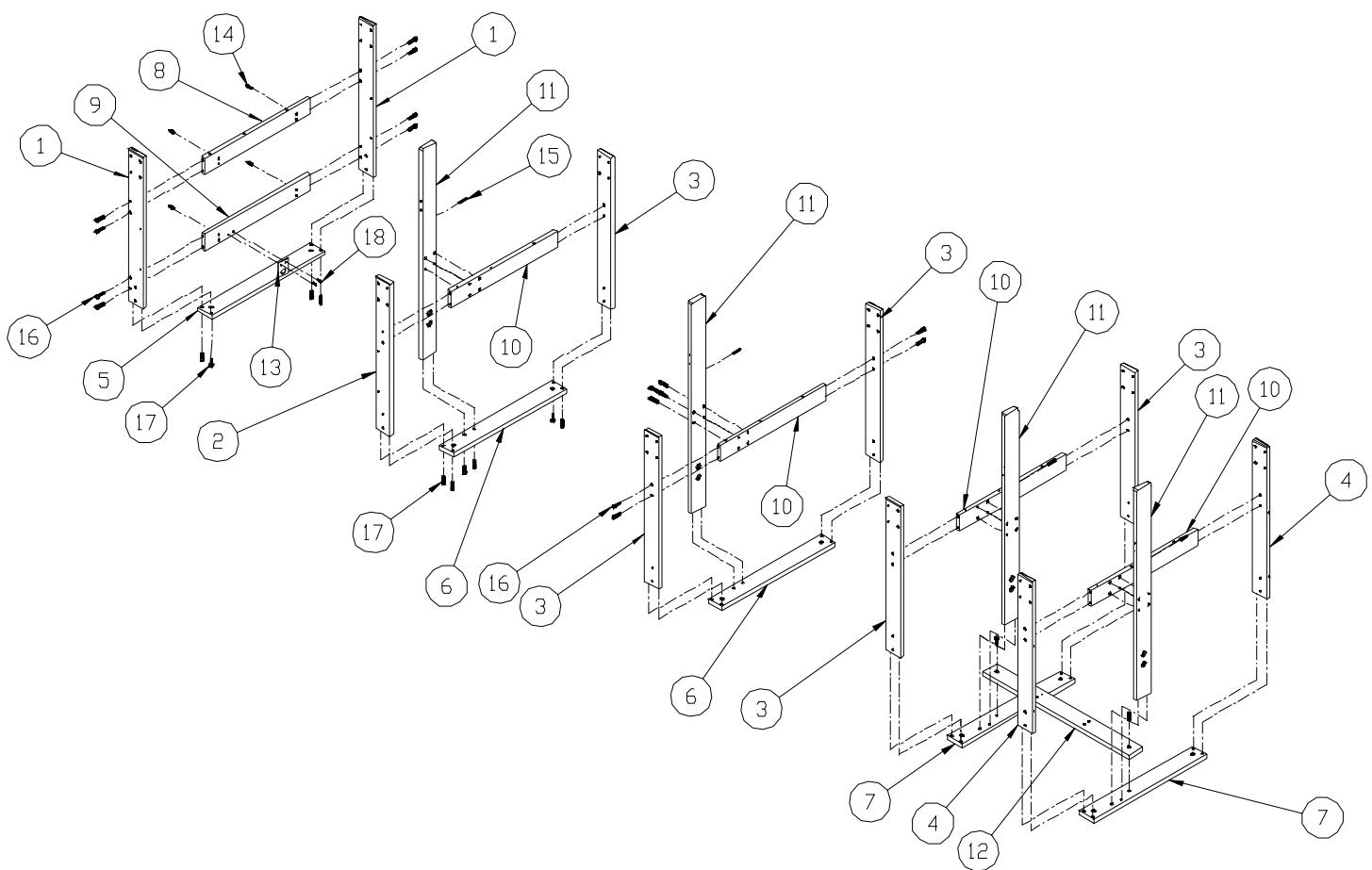
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COLLATOR – FRAME (Fig. 2-2)
FRAME ASSEMBLY

ITEM	PART NO.	QTY.	DESCRIPTION
1	18010-003	2	LEG, COLLATOR, RH - END
2	18010-014	1	LEG, COLLATOR (AT PNEUMATICS)
3	18010-002	1	LEG, COLLATOR
4	18010-001	2	LEG, COLLATOR, LH - END
5	18003-004	1	CROSS BAR, BOTTOM - END
6	18003-002	1	CROSS BAR, BOTTOM - LH
7	18003-003	2	CROSS BAR, BOTTOM - RH
8	18003-012	1	CROSS BRACE, FRONT TABLE MOUNT, UPPER
9	18003-013	1	CROSS BRACE, FRONT TABLE MOUNT, LOWER
10	18003-001	1	CROSS BRACE, LEG
11	18008-001	1	BAR, FEEDER PLATE MOUNTING
12	18003-016	1	CROSS BAR, ENCLOSURE MTG.
13	18009-027	1	BRACKET, MOTOR PLUG MTG
14	99006-006	4	PIN, ALIGNMENT
15	99006-011	4	PIN, ROLL, 3/8 X 1-1/2 LG – REID TOOL #P-59
16		42	SCREW, SKT HD, 3/8-16 X 1-1/4
17		28	SCREW, SKT HD, 3/8-16 X 1
18		2	SCREW, SKT HD, 10-24 X 1/2

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Fig. 2-2



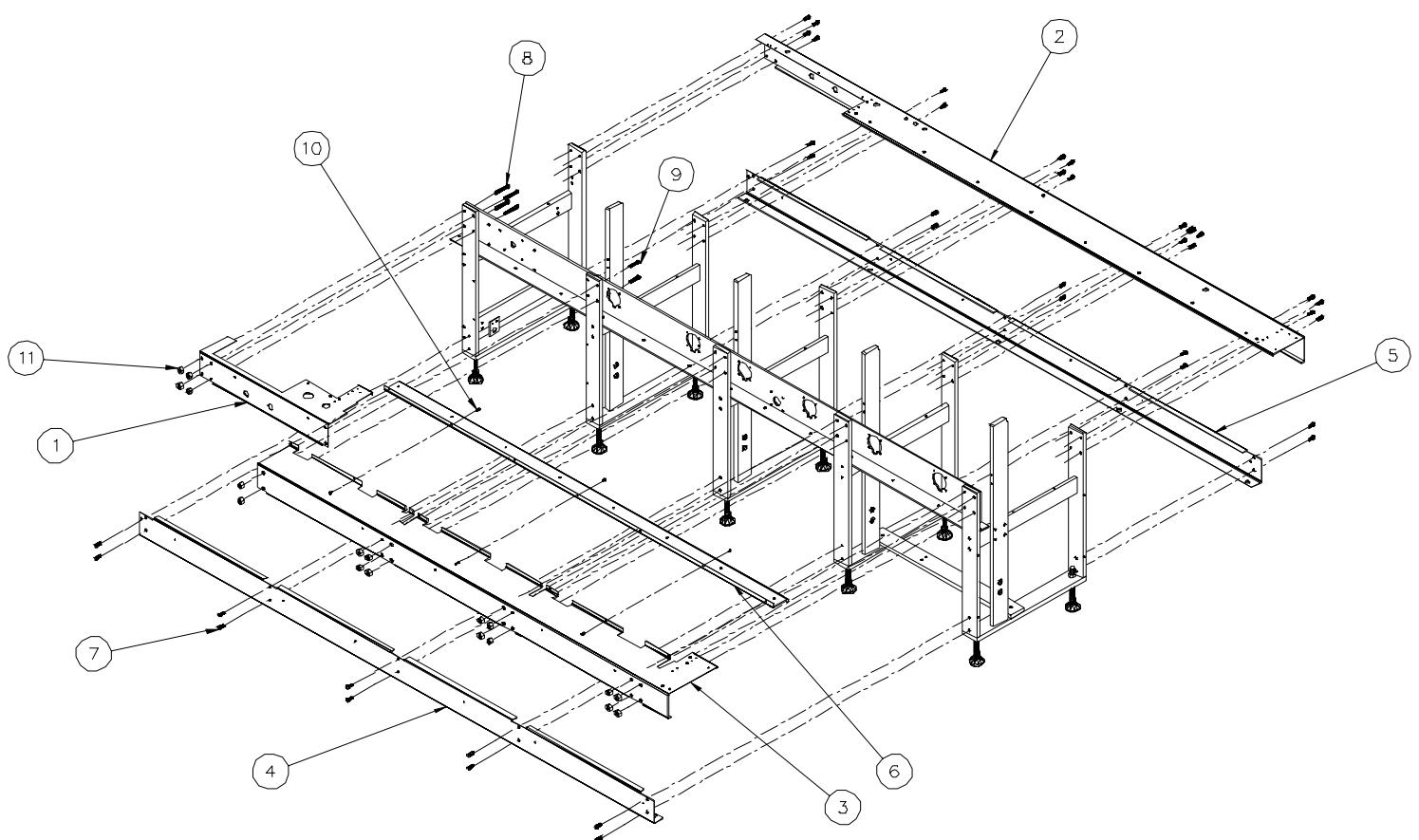
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COLLATOR – FRAME (Fig. 2-3)
COVERS

ITEM	PART NO.	QTY.	DESCRIPTION
1	18001-032	1	COVER, TOP, LH SHORT
2	18001-027	1	COVER, TOP, RH
3	18001-028	1	COVER, TOP, LH
4	18001-026	1	COVER, BOTTOM, LH
5	18001-025	1	COVER, BOTTOM, RH
6	18001-023	1	COVER, TOP, INNER
7		40	SCREW, SKT HD, 3/8-16 X 3/4
8		6	SCREW, SKT HD, 3/8-16 X 2
9		14	SCREW, SKT HD, 3/8-16 X 1-1/2
10		6	SCREW, BUTTON HD, 10-24 X 1/4
11		20	NUT, HEX HD, 3/8-16

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Fig. 2-3



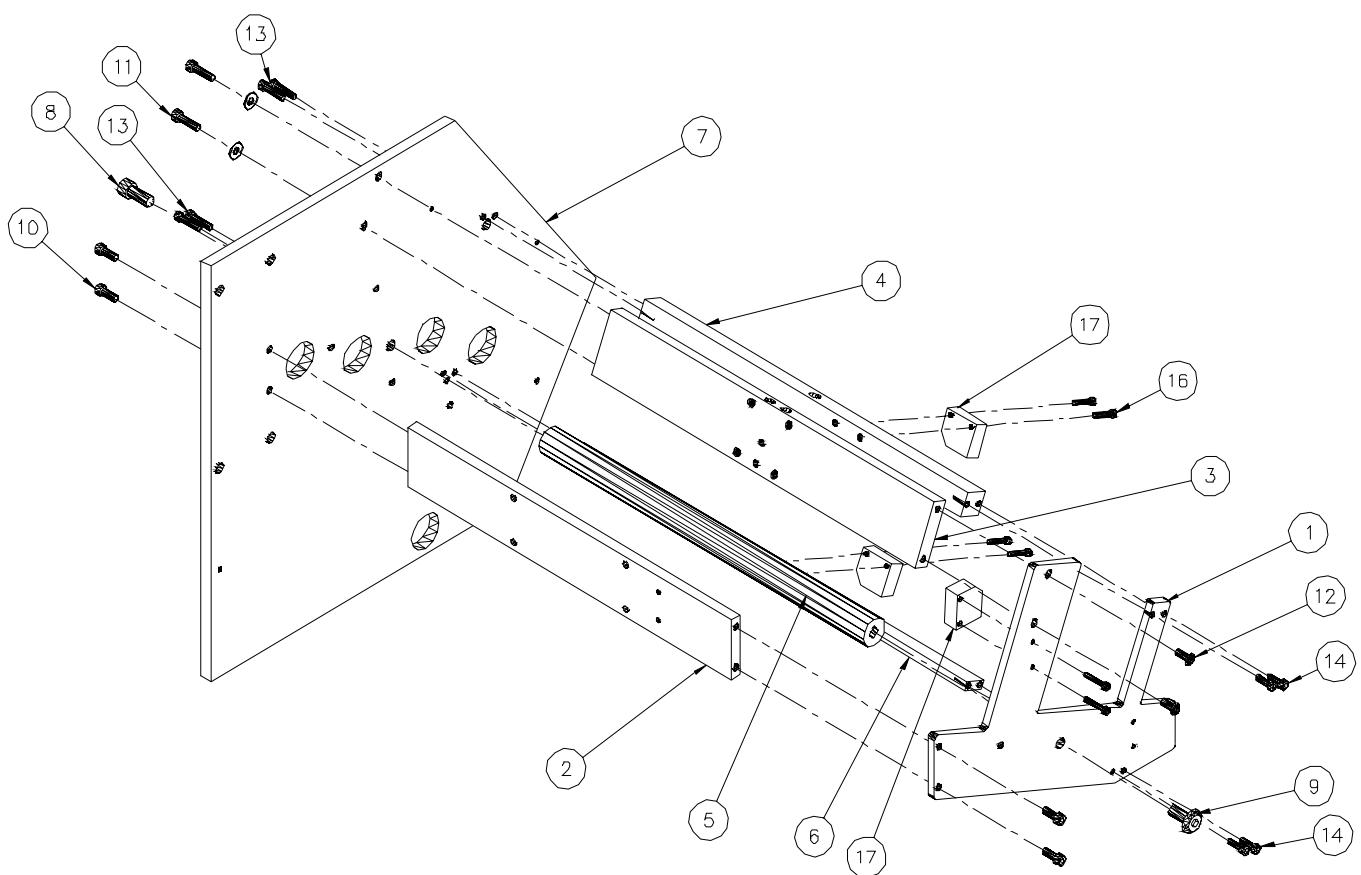
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COLLATOR – FEEDER ASSEMBLY (Fig. 2-4)
FRAME

ITEM	PART NO.	QTY.	DESCRIPTION
1	10000-017	6	SIDE FRAME, COLLATOR FEEDER, 6 X 9
2	18003-011	6	BAR, BACK SUPPORT
3	18003-010	6	CROSSBAR, PAPER GUIDE
4	18008-012	6	BAR, DBL DETECTION
5	18004-003	6	SHAFT, MAIN SUPPORT
6	18008-013	6	BAR, SENSOR MTG.
7	18011-001	1	PLATE, FEEDER MOUNTING (6 X 9) (REF ONLY)
8		1	SCREW, SKT HD, 5/6-18 X 3/4
9		1	SCREW, BUTTON HD, 5/6-18 X 3/4
10		4	SCREW, SKT HD, 10-24 X 1/2
11		2	SCREW, SKT HD, 10-24 X 3/4
12		2	SCREW, BUTTON HD, 10-24 X 1/2
13		4	SCREW, SKT HD, 8-32 X 3/4
14		4	SCREW, SKT HD, 8-32 X 1/2
15		2	WASHER, FALT, #10
16		6	SCREW, SKT HD, 4-40 X 3/4
17	98009-002	3	SENSOR, SENDER / RECIEVER

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Fig. 2-4



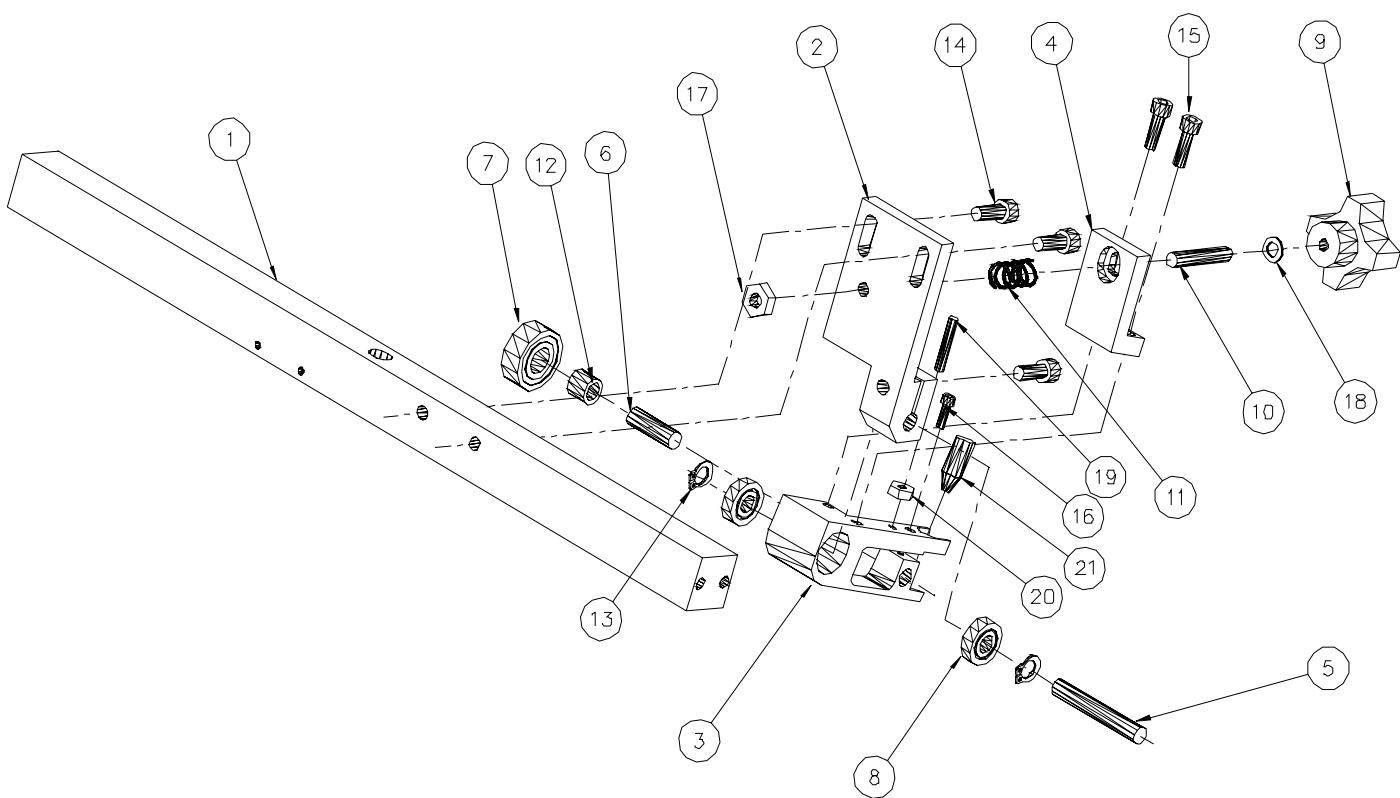
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COLLATOR – FEEDERS (Fig. 2-5)
DOUBLE DETECTION ASSEMBLY (1 PER FEEDER)

ITEM	PART NO.	QTY.	DESCRIPTION
1	18008-012	1	BAR, DOUBLE DETECTION
2	18009-001	1	BRACKET, DOUBLE DETECTION MTG.
3	10009-012	1	TUNING FORK, DBL DETECTION
4	10009-013	1	BRACKET, PIVOT TUNING FORK
5	10004-052	1	SHAFT, DBL DETECTION PIVOT
6	10004-053	1	SHAFT, DBL DTECTION ROLLER
7	99003-001	1	BEARING, 3/8 X 7/8
8	99003-002	2	BEARING, SEALED, 1/4 X 5/8
9	99004-005	1	KNOB, FEMALE
10	99032-003	1	STUD, 10-32 X 1-1/2
11	99005-007	1	SPRING, DBL DETECTION
12	99003-005	1	BUSHING, 1/4 X 3/8 X 5/16
13	99022-001	2	SNAP RING, 1/4
14		3	SCREW, SKT HD, 10-24 X 1/2
15		2	SCREW, SKT HD, 8-32 X 1/2
16		1	SCREW, SKT HD, 4-40 X 3/8
17		1	NUT, HEX HD, 10-32
18		1	WASHER, FLAT, #10
19		1	SCREW, SET, 6-32 X 1
20		1	NUT, HEX, 6-32
21	98009-004	1	SWITCH, DOUBLE DETECT

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Fig. 2-5



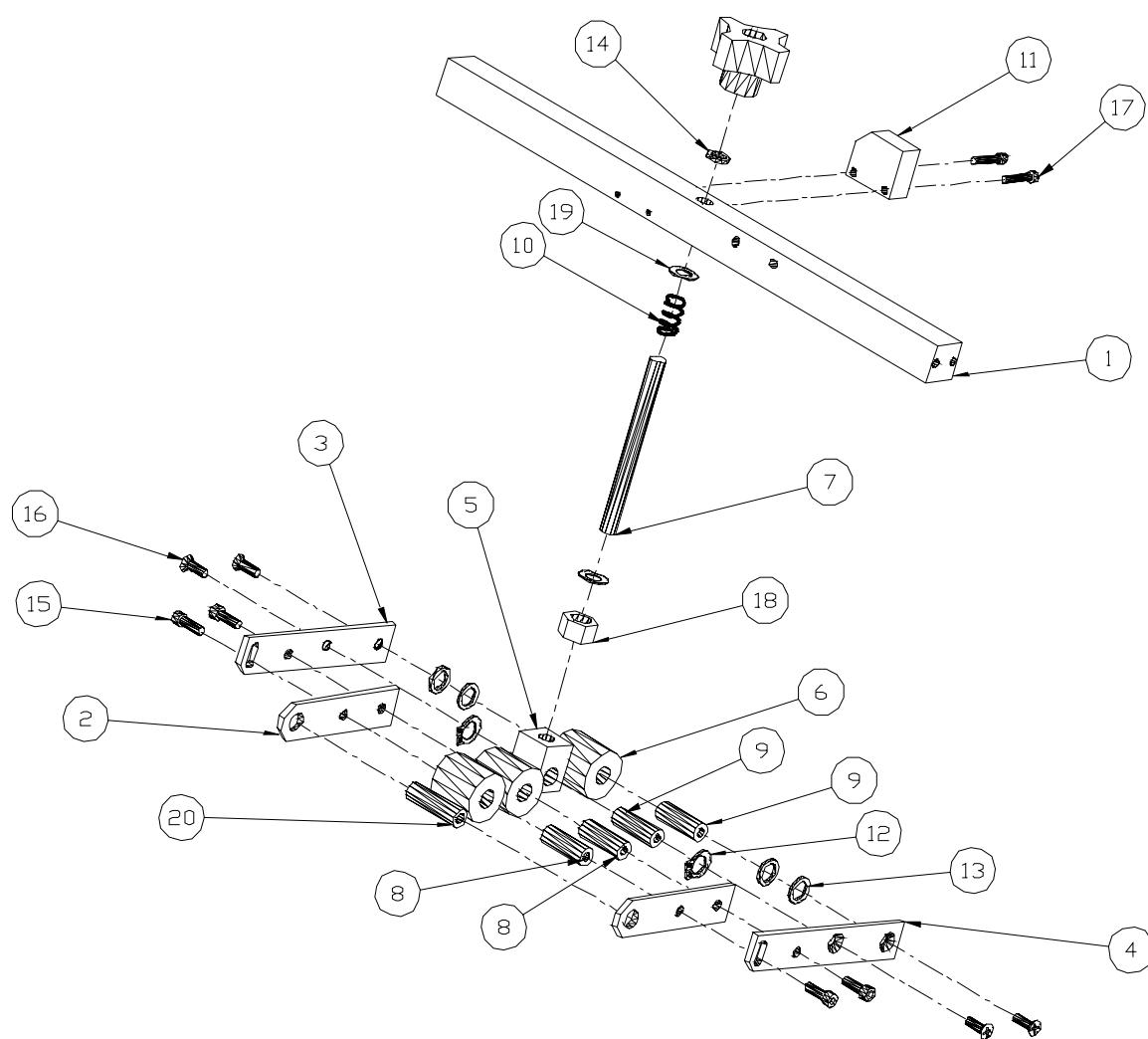
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COLLATOR – FEEDERS (Fig. 2-6)
TONGUE ASSEMBLY (1 PER FEEDER)

ITEM	PART NO.	QTY.	DESCRIPTION
1	18008-012	1	BAR, DOUBLE DETECTION
2	10008-015	2	PLATE, REAR
3	10008-016	1	PLATE, FRONT, RH
4	10008-017	1	PLATE, FRONT, LH
5	10007-012	1	BLOCK, TONGUE ADJUST
6	10006-016	3	ROLLER, TONGUE
7	10004-055	1	STUD, TONGUE ADJ
8	10012-003	2	SPACER, TONGUE SUPPORT
9	10004-054	2	SHAFT, TRAILING ARM, 1-1/4"
10	99005-006	1	SPRING, ACCELERATOR ADJ
11	98009-002	1	SENSOR, SENDER
12	99022-003	2	SNAP RING, 3/8
13	99003-017	4	WASHER, NYLON, 3/8 X 1/16
14	99003-015	1	WASHER, NYLON, 5/16 X 1/16
15		4	SCREW, SKT HD, 8-32 X 3/4
16		4	SCREW, FLAT HD, 8-32 X 1/2
17		2	SCREW, SKT HD, 4-40 X 3/4
18		1	NUT, HEX HD, 5/16-24
19		2	WASHER, FLAT, 5/16
20	99006-001	1	PIN, DOWEL, 3/8 X 1-1/4
21	99004-001	1	KNOB, 5/16-24, FEMALE

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Fig. 2-6



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COLLATOR - FEEDERS (Fig. 2-7)
SEPERATOR DEVICE / SIDE GUIDE ASSEMBLY (1 PER
FEEDER)

ITEM	PART NO.	QTY.	DESCRIPTION
1	18003-010	1	BAR, CROSS
2	10005-002	1	GUIDE, FRONT PAPER (TALL)
3	10005-008	1	GUIDE, SIDE LH (TALL)
4	10005-009	1	GUIDE, SIDE RH (TALL)
5	10007-001	1	BLOCK, SEPARATOR 3" ROLLER
6	10011-001	1	PLATE, MOTOR MOUNT (SEPARATOR)
7	10009-002	2	BRACKET, SIDE GUIDE MTG.
8	10004-001	1	SHAFT, SEPARATOR
9	10005-003	1	SHROUD, SEPARATOR
10	99001-001	1	MOTOR, SEPARATOR
11	99002-001	1	PULLEY, 100MXL025 (NO HUB 3/8" B.)
12	99002-002	1	PULLEY, 16MXL025 (3/16" B.)
13	10006-001	2	WHEEL, SEPARATOR 3" DIA.
14	99000-006	1	BELT, 115 MXL025
15	10007-010	1	BLOCK, SEPARATOR ADJUSTING
16	10004-028	1	STUD, SEPARATOR ADJUSTING
17	99003-001	3	BEARING, 3/8" I.D. X 7/8" O.D.
18	99004-001	1	KNOB 5/16-24 FEMALE
19	10014-002	8	O-RING, SEPARATOR 3"
20	10019-001	1	SPRING, .068 X .48 X 1-7/16"
21	99006-001	1	PIN DOWELL, 3/8" X 1 1/4"
22	10012-002	2	STANDOFF, SEPARATOR MOTOR
23	99004-003	2	HANDLE, RATCHET, 10-24
24	99004-002	2	KNOB, #10 SCREW
25	99003-017	4	WASHER, NYLON 3/8 ID X 1/16
26	99003-016	2	WASHER, NYLON 3/8 ID X 1/32
27	99006-002	2	PIN DOWEL, 5/16" X 3"
28	99003-015	1	WASHER, NYLON, 5/16 X 1/16
29		1	NUT, HEX 5/16-24
30		2	WASHER, FLAT 5/16
31		2	SCREW, PAN HD 6-32 X 2 1/2

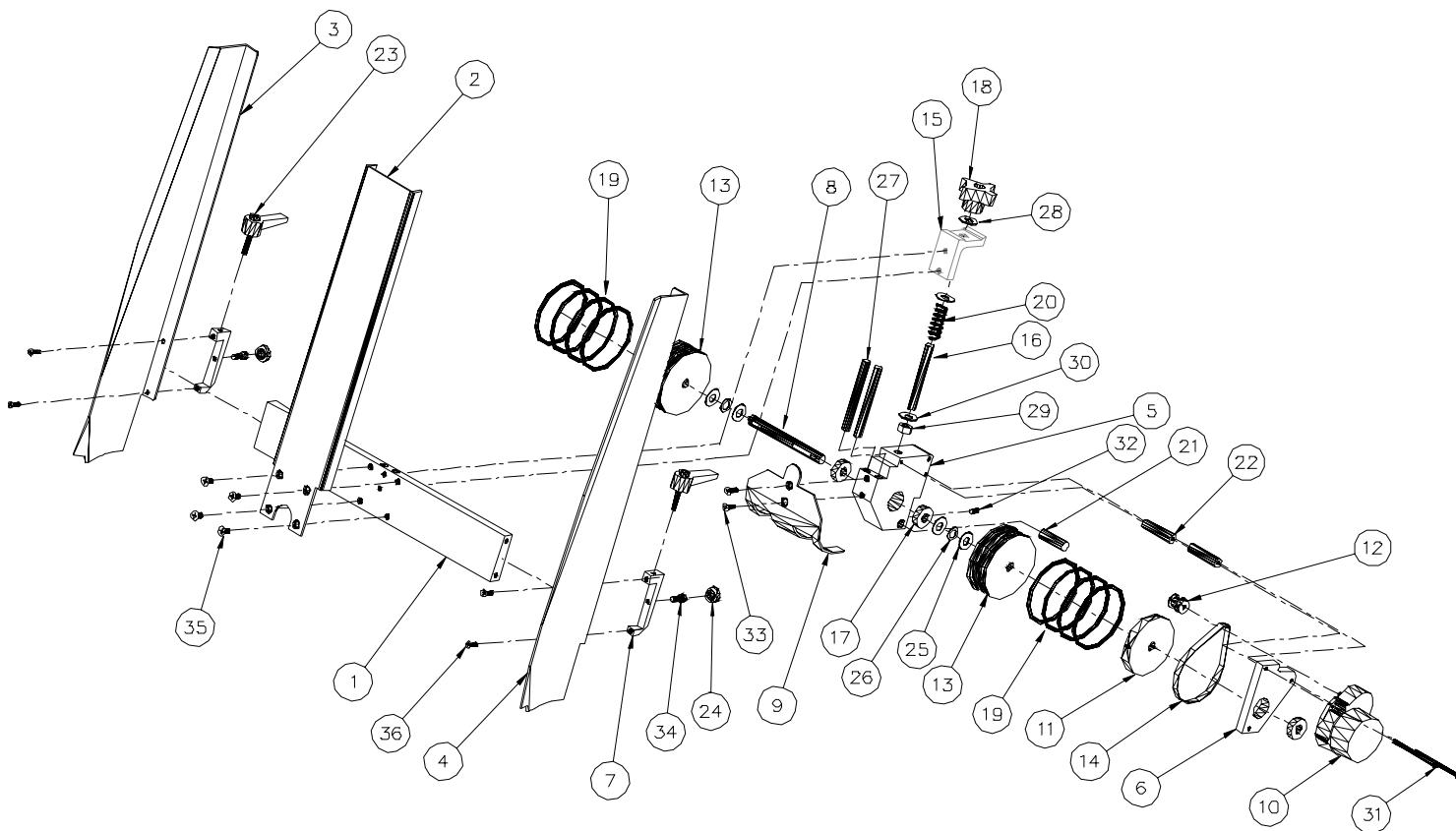
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32		1	SCREW, SET 10-24 X 1/8
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ITEM	PART NO.	QTY.	DESCRIPTION
33		2	SCREW, FL HD 8-32 X 1/2
34		2	SCREW, SKT HD, 10-24 X 1/2
35		4	SCREW, FLAT HD, 10-24 X 3/8
36		4	SCREW, FLAT HD, 6-32 X 1/2

FIG. 2-7



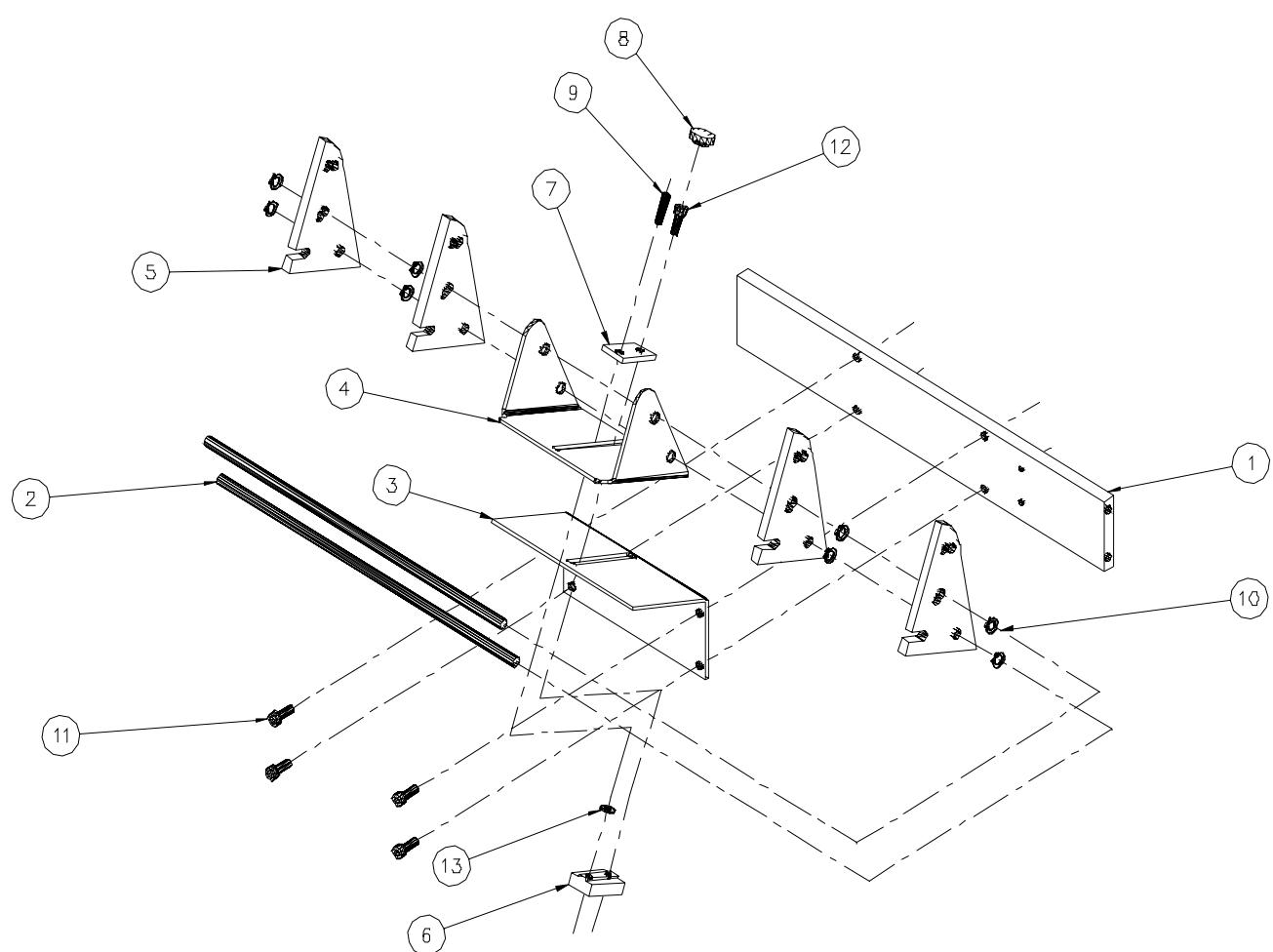
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COLLATOR – FEEDERS (Fig. 2-8)
PAPER GUIDE ASSEMBLY

ITEM	PART NO.	QTY.	DESCRIPTION
1	18003-011	1	BAR, BACK SUPPORT
2	10004-014	2	SHAFT, PAPER SLIDE
3	18005-005	1	SUPPORT, PAPER SLIDE
4	10009-003	1	BRACKET, PAPER SLIDE
5	10005-016	4	PAPER SLIDE
6	10007-003	1	NUT, PAPER SLIDE
7	10007-004	1	WASHER, PAPER SLIDE
8	99004-002	1	KNOB, #10 SCREW
9	99006-020	1	ROLL PIN, 5/32 X 3/4
10	99022-001	8	SNAP RING, 1/4
11		4	SCREW, SKT HD, 10-24 X 3/8
12		1	SCREW, SKT HD, 10-24 X 1/2
13		1	WASHER, FLAT, #6
14	10006-033	4	PAPER SLIDE ROLLER (FOUND ON EVERY THIRD FEEDER)

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FIG. 2-8



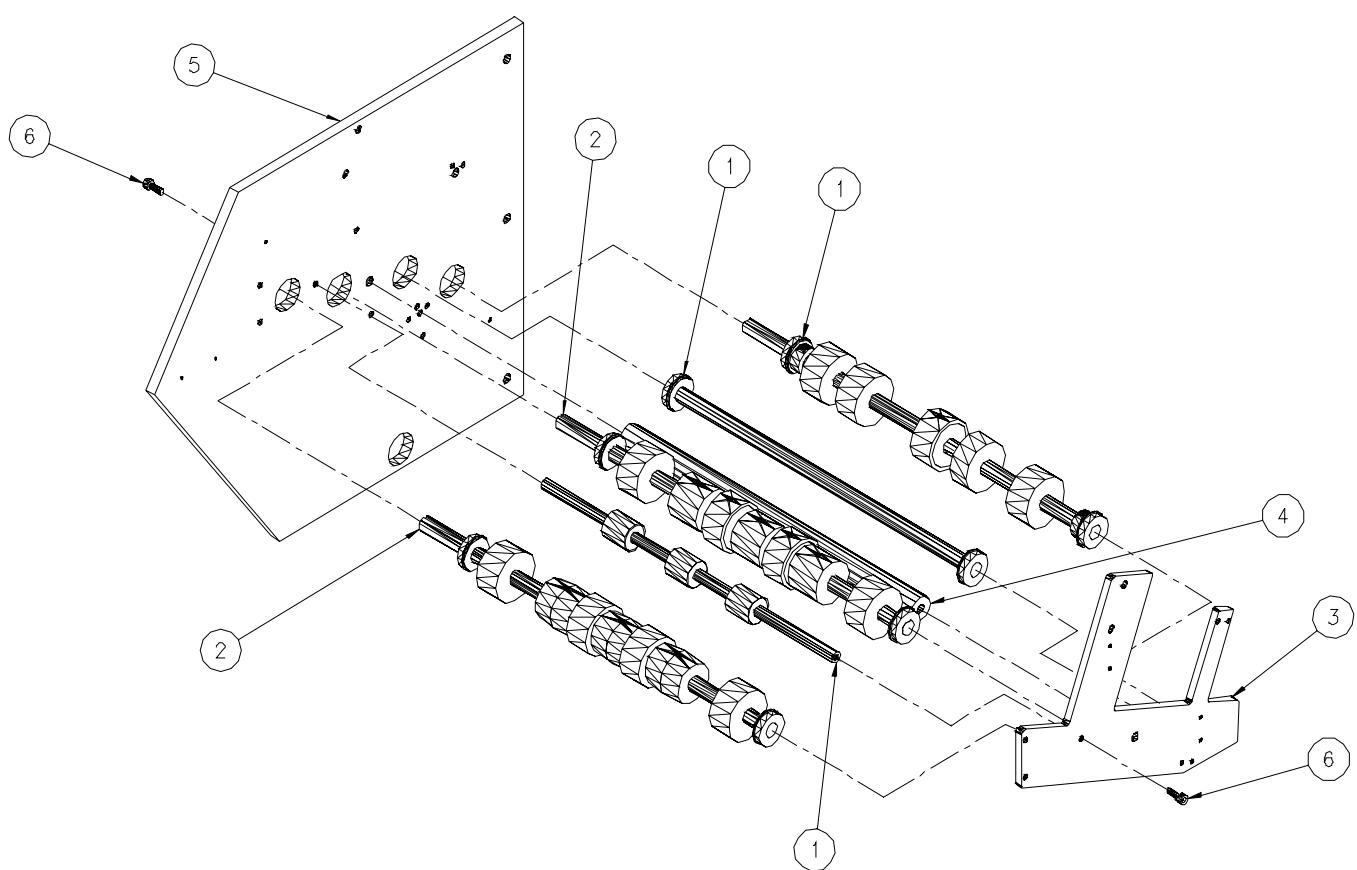
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COLLATOR – FEEDERS (Fig. 2-9)
FEEDER ROLLER ASSEMBLY

ITEM	PART NO.	QTY.	DESCRIPTION
1	(SEE FIG. 2-12)	6	SHAFT ASSY., DOUBLE DET., FRONT, IDLER SUPPORT
2	(SEE FIG. 2-13)	6	SHAFT ASSY., MAIN, REAR MAIN
3	10000-017	1	SIDE FRAME, COLLATOR FEEDER (6 X 9)
4	18004-003	1	SHAFT, MAIN SUPPORT
5	18011-001	1	PLATE, FEEDER MTG. (6 X 9) (REF. ONLY)
6		2	SCREW, SKT HD, 10-24 X 1/2

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FIG. 2-9



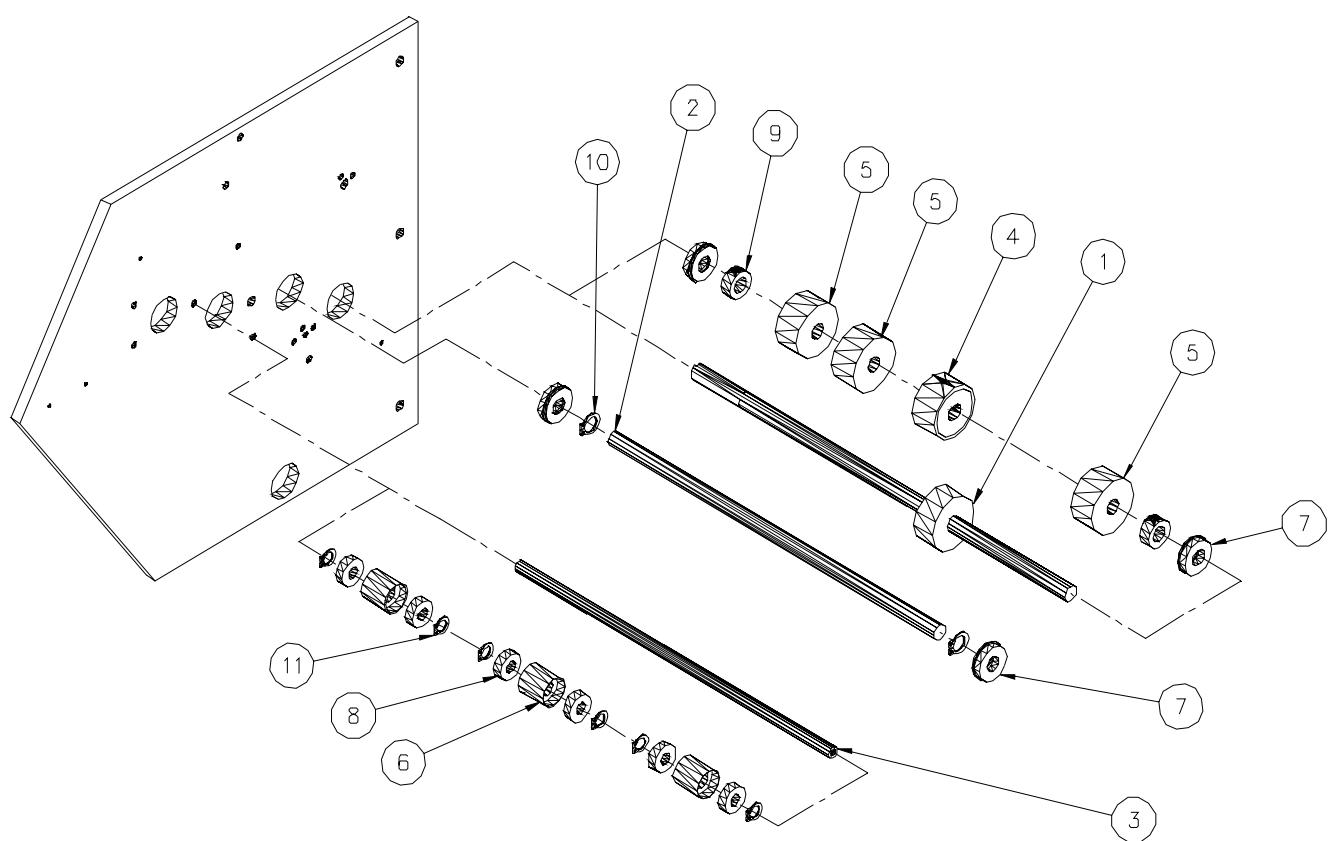
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COLLATOR – FEEDERS (Fig. 2-10)
SHAFT ASSEMBLY - DOUBLE DETECTION, FRONT, IDDLER

ITEM	PART NO.	QTY.	DESCRIPTION
1	18004-064	1	ROLLER/SHAFT ASSY, DOUBLE DETECTION
2	18004-007	1	SHAFT, FRONT
3	18004-004	1	SHAFT, IDLER SUPPORT
4	10006-013	1	ROLLER, NIP
5	10006-007	3	ROLLER, FEEDER
6	10006-012	3	ROLLER, IDLER SUPPORT
7	99003-007	4	BEARING, 1/2 X 1-1/8, (SEALED W/ SNAP RING)
8	99003-008	6	BEARNG, SEALED, 3/8 X 7/8
9	99017-004	2	COLLAR, SHAFT, 1/2
10	99022-004	2	SNAP RING, 1/2
11	99022-003	6	SNAP RING, 3/8
12		2	SCREW, SKT HD 10-24 X 1/2
13	18011-001	1	PLATE, FEEDER MTG. (6X9) (REF.ONLY)
14		4	NYLON WASHER 1/2 X 1/32

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FIG. 2-10



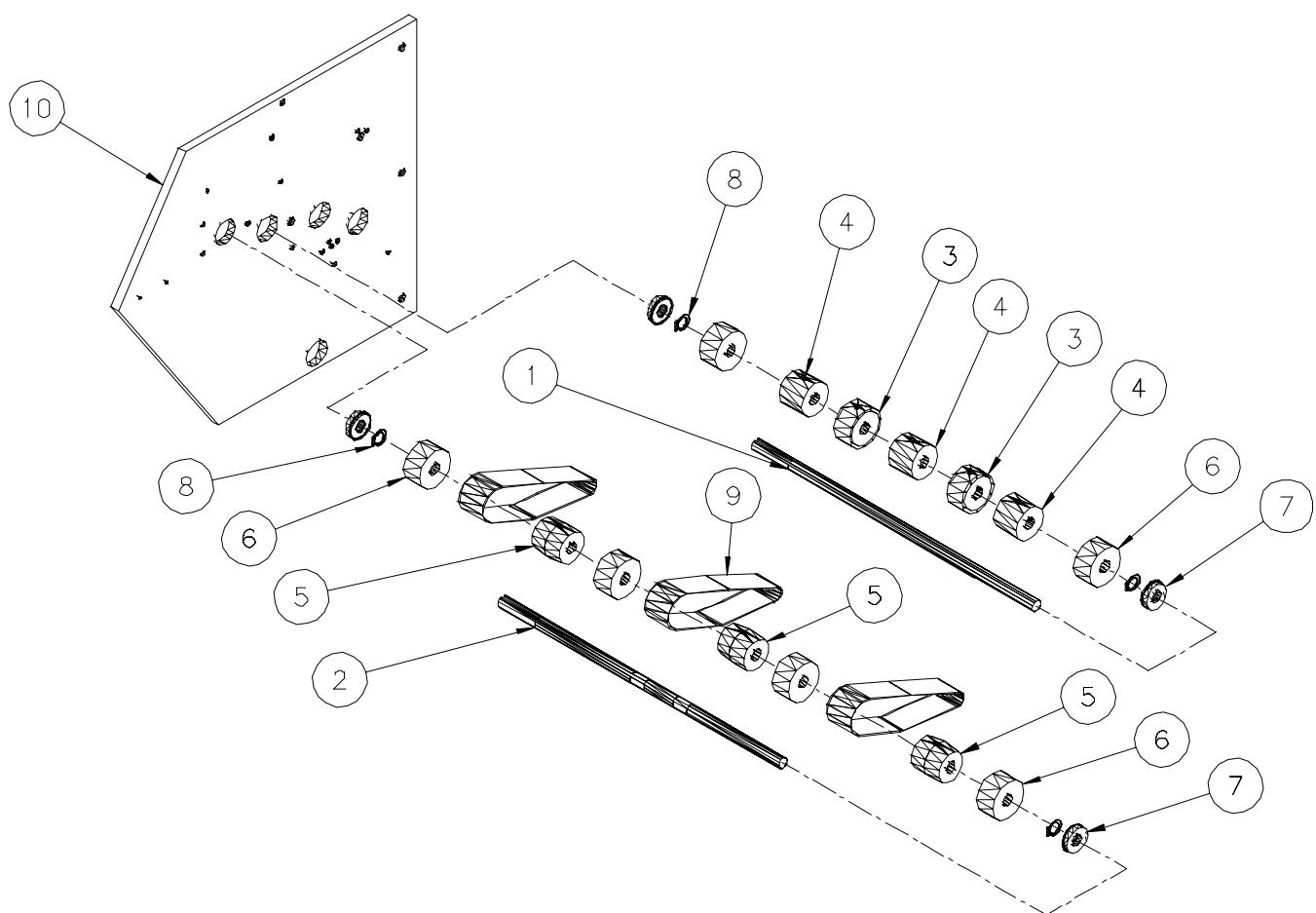
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COLLATOR – FEEDERS (Fig. 2-11)
SHAFT ASSEMBLY – MAIN, REAR MAIN

ITEM	PART NO.	QTY.	DESCRIPTION
1	18004-006	1	SHAFT, MAIN
2	18004-058	1	SHAFT, ELEVATOR BELT DRIVE
3	10006-013	2	ROLLER, NIP
4	10006-015	3	PULLEY, MATE
5	10006-018	3	PULLEY, CROWNED
6	10006-007	6	ROLLER, FEEDER
7	99003-007	4	BEARING, 1/2 X 1-1/8, (SEALED W/ SNAP RING)
8	99022-004	4	SNAP RING, 1/2
9	99000-004	3	BELT, RED GUM
10	18011-001	1	PLATE, FEEDER MTG. (6 X 9) (REF. ONLY)

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FIG. 2-11



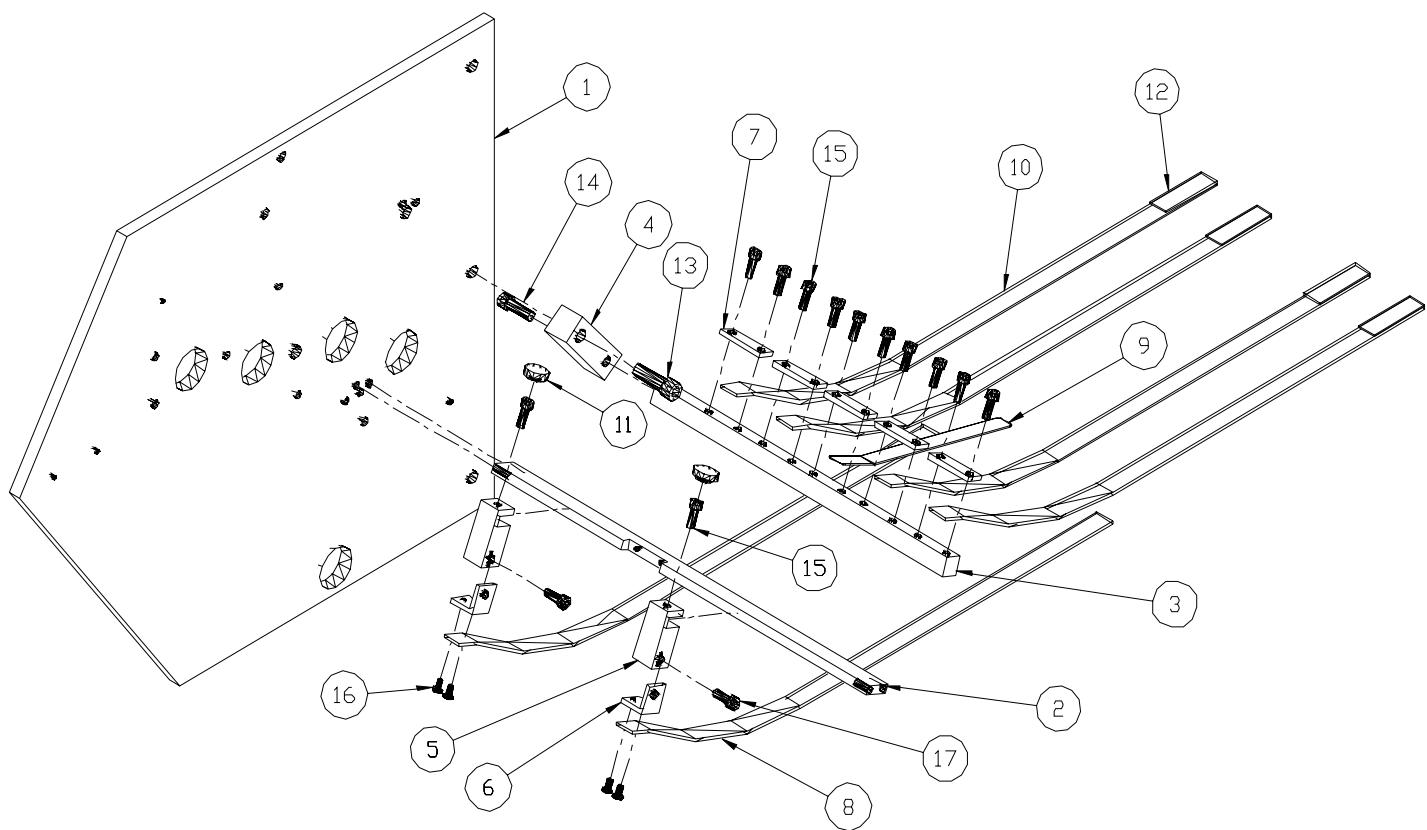
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COLLATOR – FEEDERS (Fig. 2-12)
DRAG STRAP ASSEMBLY

ITEM	PART NO.	QTY.	DESCRIPTION
1	18011-001	1	PLATE, FEEDER MTG. (6 X 9)
2	18008-013	6	BAR, DRAG STRAP MTG.
3	18008-030	1	BAR, STRAP MTG.
4	18007-060	1	BLOCK, BAR STRAP MTG.
5	18009-014	10	BRACKET, DRAG STRAP MTG.
6	18009-029	10	BRACKET, DRAG STRIP PIVOT
7	18009-016	5	CLAMP, DRAG STAP, PUSHER
8	18014-010	10	DRAG STRAP, FEEDER
9	18005-063	1	SRING STEEL, DRAG STRAP
10	18014-011	4	DRAG STRAP, PUSHER, 2.5'
11	99004-002	10	KNOB, #10 SCREW
12	18019-006	4	WEIGHT, DRAG STRAP
13		1	SCREW, SKT HD, 5/6-18 X 1
14		1	SCREW, SKT HD, 1/4-20 X 3/4
15		20	SCREW, SKT HD, 10-24 X 1/2
16		20	SCREW, PAN HD, 6-32 X 1/4
17		10	SCREW, SKT HD, 8-32 X 1/4

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FIG. 2-12



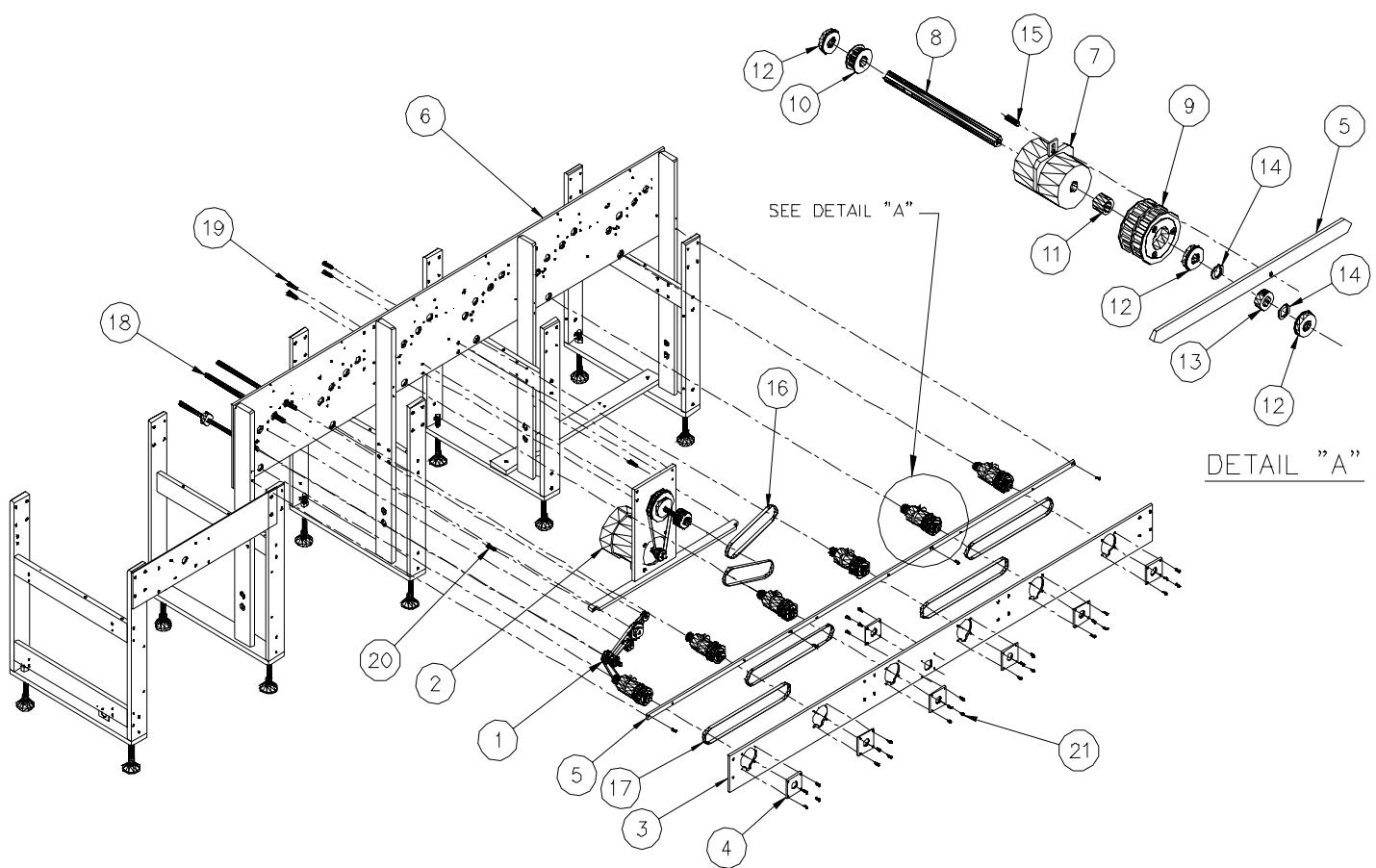
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COLLATOR – FEEDER DRIVE ASSEMBLY (Fig. 2-13)

ITEM	PART NO.	QTY.	DESCRIPTION
1	(SEE FIG. 2-16)	6	PULLEY DRIVE ASSEMBLY
2	(SEE FIG. 2-18)	1	FEEDER DRIVE MOTOR ASSEMBLY
3	18011-004	1	PLATE, CLUTCH
4	18007-051	7	BLOCK BEARING
5	18008-029	1	BAR, CLUTCH STOP
6	18011-001	1	PLATE, FEEDER MTG. (REF. ONLY)
7	99008-001	1	CLUTCH, FEEDER, 90 VOLT (BEFORE 4/2000)
	99008-006	1	CLUTCH, FEEDER, 24 VOLT (AFTER 4/2000)
8	18004-015	1	SHAFT, CLUTCH
9	18006-008	1	PULLEY, DBL 20L050
10	18006-042	1	PULEY, 20XL037 (W/ KEYWAY)
11	10006-029	1	BUSHING, CLUTCH PULLEY
12	99003-007	3	BEARING, SEALED, 1/2 X 1-1/8
13	99017-004	1	COLLAR, SHAFT, 1/2
14	99003-018	2	WASHER, NYLON, 1/2 X 1/16
15	99006-022	1	PIN, 10-32 X 3/4 (THIS WAS CHANGED TO #18007-109)
16	99000-025	2	BELT, 225L050
17	99000-026	4	BELT, 360L050
18		1	FEEDER SHAFTS (REF ONLY)
19		4	SCREW, SKT HD, 3/8-16 X 1-1/4
20		2	SCREW, SKT HD, 5/16-18 X 1-1/4
21		32	SCREW, SKT HD, 10-24 X 1/2

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FIG. 2-13



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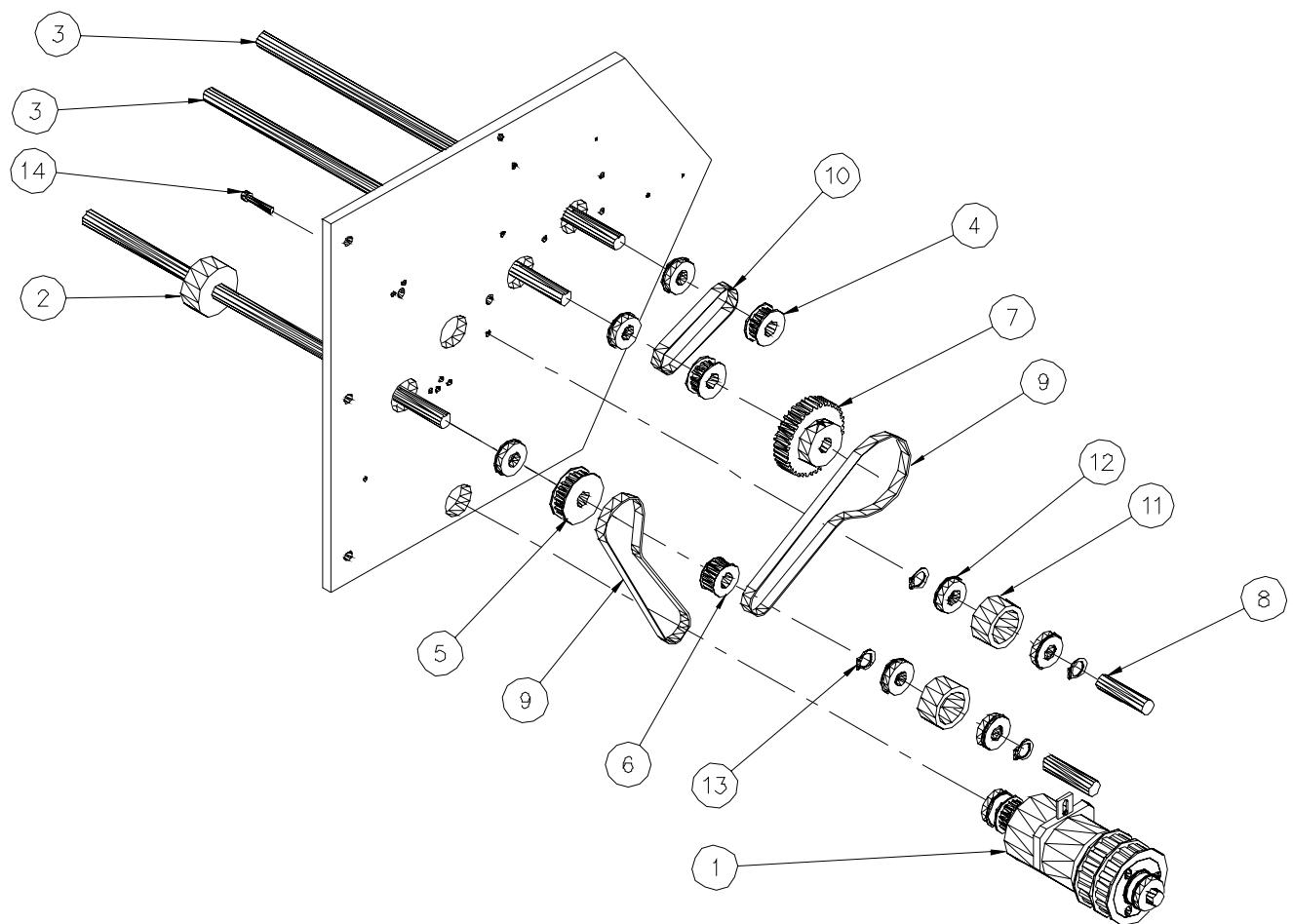
COLLATOR – FEEDER DRIVE (Fig. 2-14)
PULLEY DRIVE ASSEMBLY

ITEM	PART NO.	QTY.	DESCRIPTION
1	(REF FIG. 2-13)	6	CLUTCH ASSEMBLY
2	18011-001	1	PLATE, FEEDER MTG. (REF. ONLY)
3	18004-064	1	DOUBLE DETECTION SHAFT ASSEMBLY
4	18004-006	2	SHAFT, MAIN
5	18006-042	2	PULLEY, 20XL037 (W/ KEYWAY)
7*	99002-031	1	PULLEY, 24XL037 (NO HUB, 1/2 BORE W/ KEYWAY)
6*	99002-032	1	PULLEY, 16XL037 (NO HUB, 1/2 BORE W/ KEYWAY)
8	99002-017	1	PULLEY, 32XL037 (1/2 B. W/ KEYWAY)
9	18004-031	2	SHAFT, STUB IDLER
10	99000-027	2	BELT, 160XL037
11	99000-001	1	BELT, 90XL037
12	18006-011	2	PULLEY, IDLER, FLAT
13	99003-007	7	BEARING, SEALED, 1/2 X 1-1/8
14	99022-004	4	SNAP RING, 1/2
15		2	SCREW, SKT HD, 10-24 X 1

** Correction was made.

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FIG. 2-14



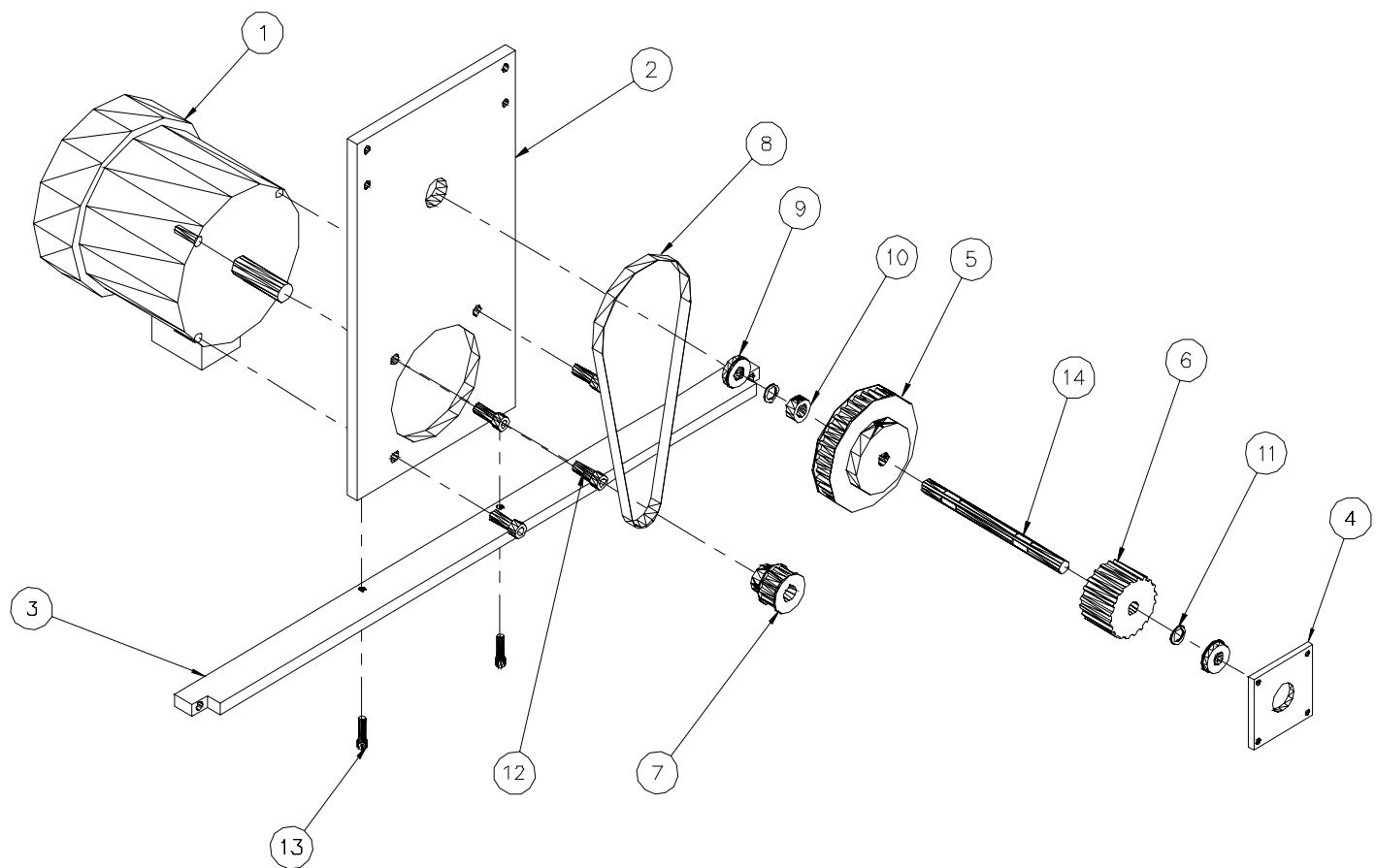
**Sure-Feed
Engineering Inc**

**COLLATOR – FEEDER DRIVE (Fig. 2-15)
FEEDER DRIVE MOTOR ASSEMBLY**

ITEM	PART NO.	QTY.	DESCRIPTION
1	99001-005	1	MOTOR, 1/2 HP
2	18011-003	1	PLATE, MOTOR MOUNT
3	18008-028	1	BAR, MOTOR MOUNT SUPPORT
4	18007-051	1	BLOCK, BEARING
5	99002-019	1	PULLEY, 36L075
6	18006-017	1	PULLEY, WIDE, 20L050
7	99002-018	1	PULLEY, 12L075
8	99000-028	1	BELT, 255L075
9	99003-007	2	BEARING, SEALED, 1/2 X 1-1/8
10	99017-004	1	COLLAR, SHAFT, 1/2
11	99003-018	2	WASHER, NYLON, 1/2 X 1/16
12		4	SCREW, SKT HD, 3/8-16 X 1
13		2	SCREW, SKT HD, 5/16-18 X 1-1/4
14	18004-016	1	SHAFT, INTERMEDIATE

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FIG. 2-15



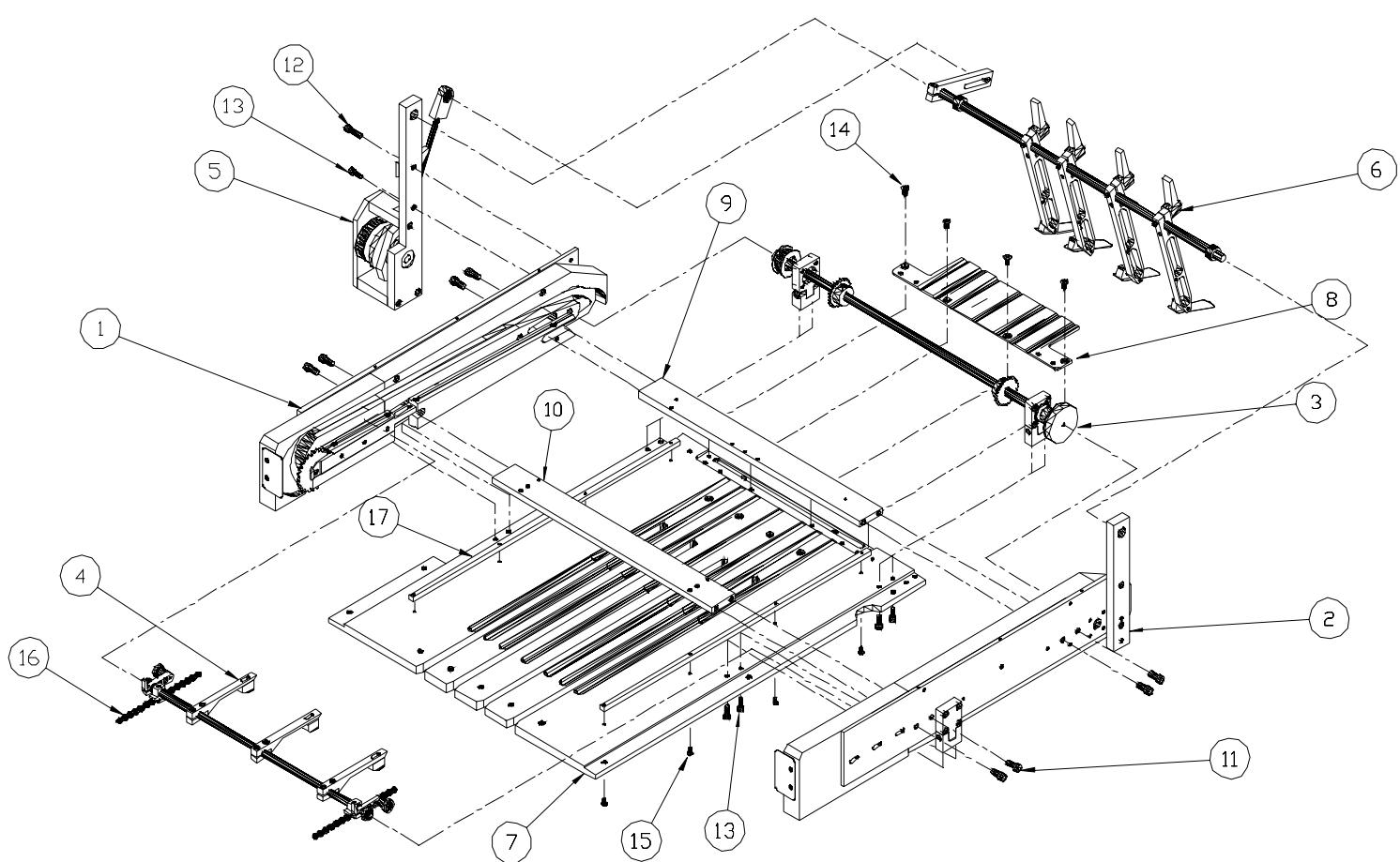
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COLLATOR – PUSHER ASSEMBLY (Fig. 2-16)

ITEM	PART NO.	QTY.	DESCRIPTION
1	(SEE FIG. 2-17)	1	PUSHER GUIDE, LEFT HAND
2	(SEE FIG. 2-18)	1	PUSHER GUIDE, RIGHT HAND
3	(SEE FIG. 2-19)	1	PUSHER DRIVE SHAFT
4	(SEE FIG. 2-20)	3	PUSHER ARM SHAFT
5	(SEE FIG. 2-22)	1	FINGER DRIVE SHAFT
6	(SEE FIG. 2-23)	1	FINGER ARM SHAFT
7	18005-001	1	PLATE, PUSHER, 6 X 9
8	18005-044	1	PLATE, PUSHER GUIDE EXTENSION (6 X 9)
9	18003-008	1	CROSS BRACE PUSHER, FRONT
10	18003-007	1	CROSS BRACE PUSHER, REAR
11		8	SCREW, SKT HD, 1/4-20 X 1/2
12		1	SCREW, SKT HD, 10-24 X 3/4
13		9	SCREW, SKT HD, 10-24 X 1/2
14		4	SCREW, FLAT HD, 10-24 X 1/4
15		8	SCREW, PAN HD, 6-32 X 1/4
16	18005-045	1	PLATE, PUSHER GUIDE EXT. (8"), OPTION TO ITEM 8
17	18005-012	1	PLATE, PUSHER GUIDE EXT. (#10), OPTION TO ITEM 8
18	18005-046	1	PLATE, PUSHER GUIDE EXT. (7.5"), OPTION TO ITEM 8
19	18005-047	1	PLATE, PUSHER GUIDE EXT. (#7), OPTION TO ITEM 8
20	18014-002	2	PUSHER CHAIN ASSEMBLY (6 X 9) (SEE FIG. 2-21)
21	18005-035	2	GUIDE, CAM ROLLER (LOWER)

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FIG. 2-16



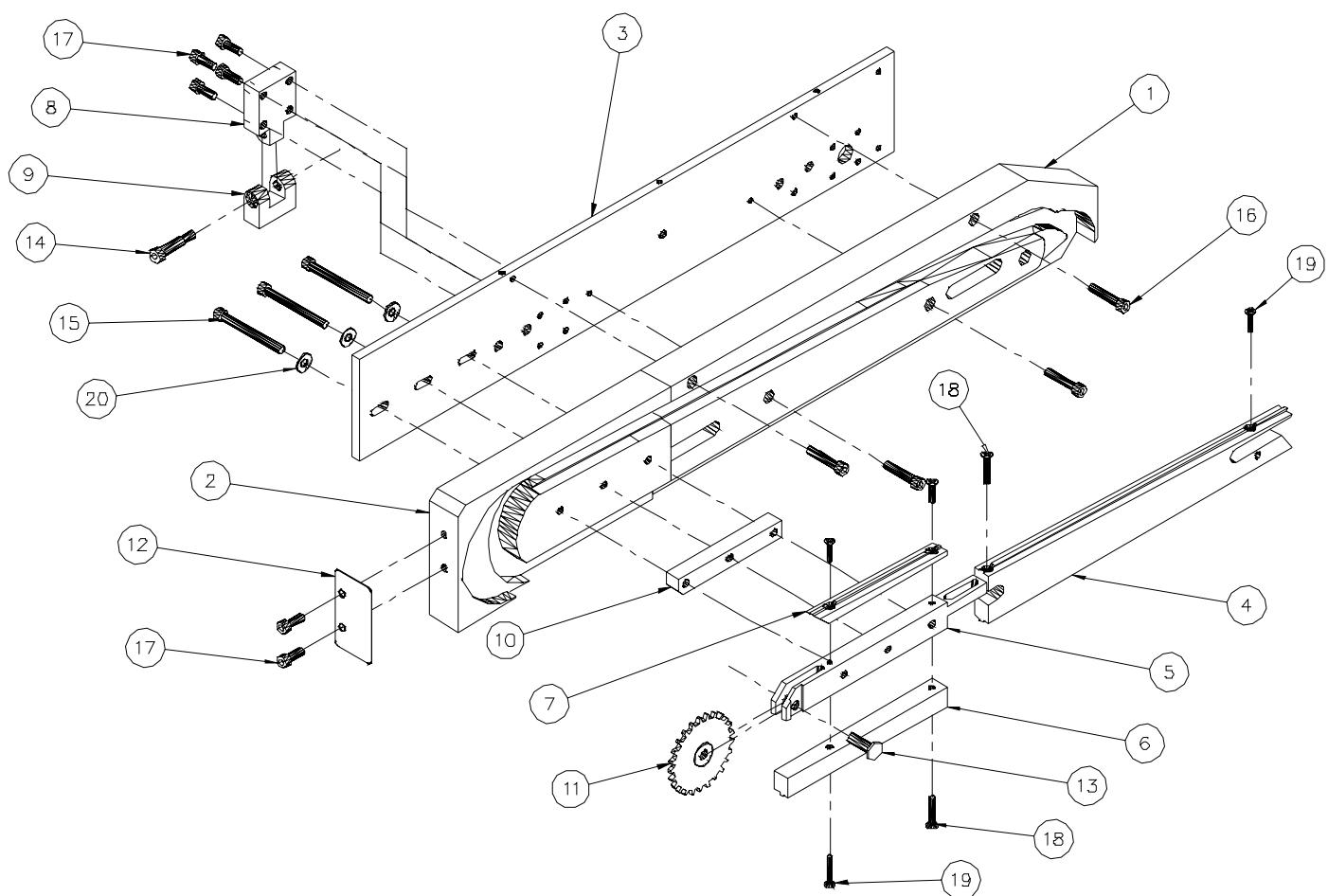
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COLLATOR – PUSHER (Fig. 2-17)
LEFT HAND PUSHER GUIDE ASSEMBLY

ITEM	PART NO.	QTY.	DESCRIPTION
1	18016-001	1	CAM, PUSHER CONTROL, LH FRONT
2	18016-009	1	CAM, PUSHER CONTROL, LH REAR
3	18011-002	1	PLATE, PUSHER CAM MOUNTING
4	18005-007	1	GUIDE, CHAIN, FRONT
5	18008-050	1	BAR, IDLER MOUNTING, LH
6	18005-049	1	GUIDE, LOWER CHAIN
7	18005-006	1	GUIDE, CHAIN
8	18007-003	1	BLOCK, PIVOT (UPPER)
9	18007-001	1	BLOCK, PIVOT
10	18012-003	1	STANDOFF, REAR CAM MTG.
11	18015-001	1	SPROCKET, IDLER
12	18005-041	1	GUIDE, SPRING STEEL, ANTI - FLIP
13	18004-047	1	SCREW, IDLER SHAFT
14	99033-005	1	BOLT, SHOULDER, 1/4 X 3/4
15		3	SCREW, SKT HD, 10-24 X 2
16		4	SCREW, SKT HD, 10-24 X 1
17		6	SCREW, SKT HD, 10-24 X 1/2
18		3	SCREW, FLAT HD, 6-32 X 3/4
19		3	SCREW, FLAT HD, 6-32 X 1/2
20		3	WASHER, FLAT, #10

**Sure-Feed
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FIG. 2-17



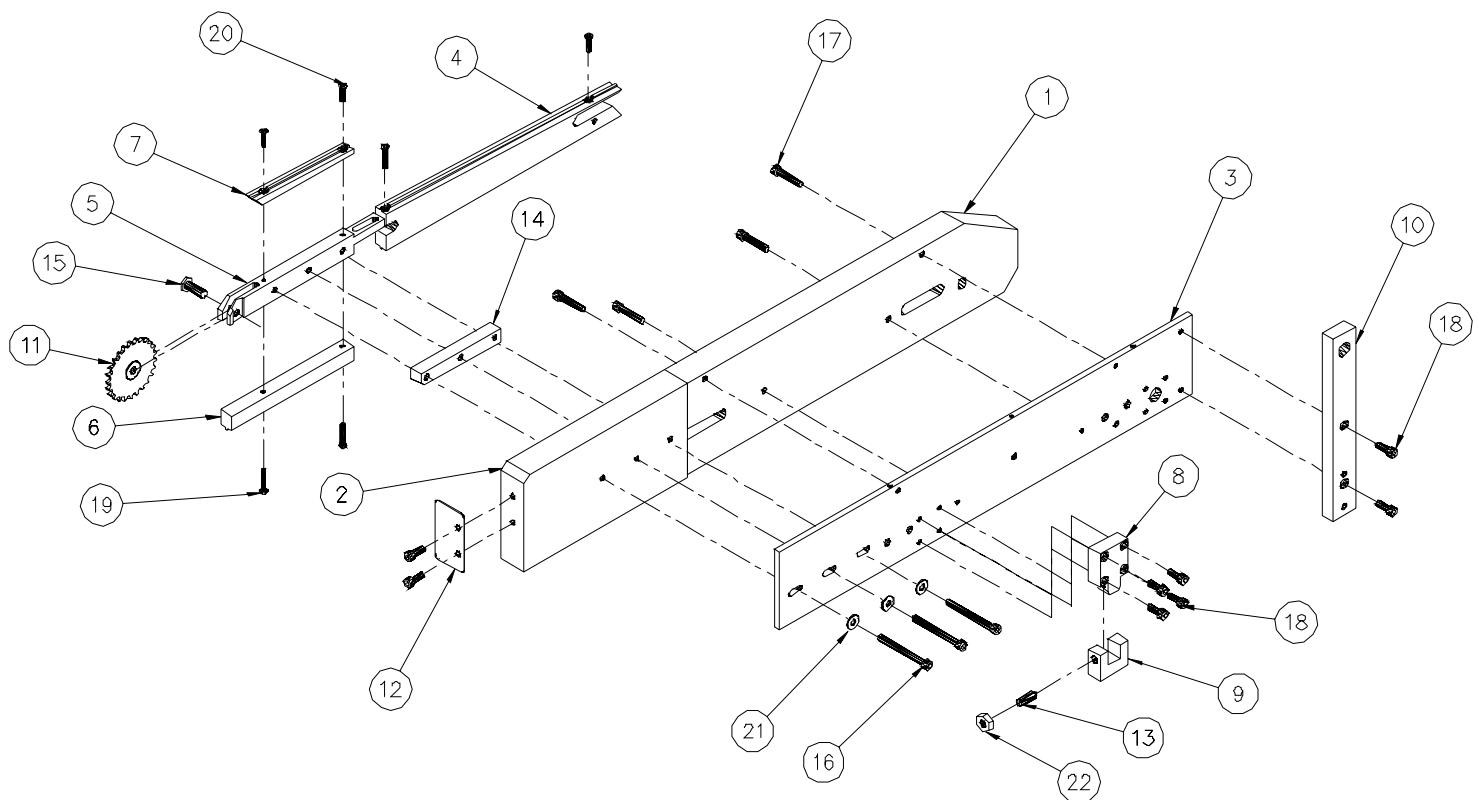
Sure-Feed
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COLLATOR – PUSHER (Fig. 2-18)
RIGHT HAND PUSHER GUIDE ASSEMBLY

ITEM	PART NO.	QTY.	DESCRIPTION
1	18016-002	1	CAM, PUSHER CONTROL, RH FRONT
2	18016-010	1	CAM, PUSHER CONTROL, RH REAR
3	18011-002	1	PLATE, PUSHER CAM MTG.
4	18005-007	1	GUIDE, CHAIN
5	18008-007	1	BAR, IDLER MOUNTING, RH
6	18005-049	1	GUIDE, LOWER CHAIN
7	18005-006	1	GUIDE, CHAIN
8	18007-004	1	BLOCK, LATCH (UPPER)
9	18007-002	1	BLOCK, LATCH
10	18007-005	1	BAR, FINGER SUPPORT, RH
11	18015-001	1	SPROCKET, IDLER
12	18005-041	1	GUIDE, ANTI-FLIP
13	99005-008	1	PLUNGER, SPRING, 1/4-20 X 3/4
14	18012-003	1	STANDOFF
15	18004-047	1	SCREW, IDLER SHAFT
16		3	SCREW, SKT HD, 10-24 X 2
17		4	SCREW, SKT HD, 10-24 X 1
18		6	SCREW, SKT HD, 10-24 X 1/2
19		3	SCREW, FLAT HD, 6-32 X 3/4
20		3	SCREW, FLAT HD, 6-32 X 1/2
21		3	WASHER, FLAT, #10
22		1	NUT, HEX HD, 10-24

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FIG. 2-18



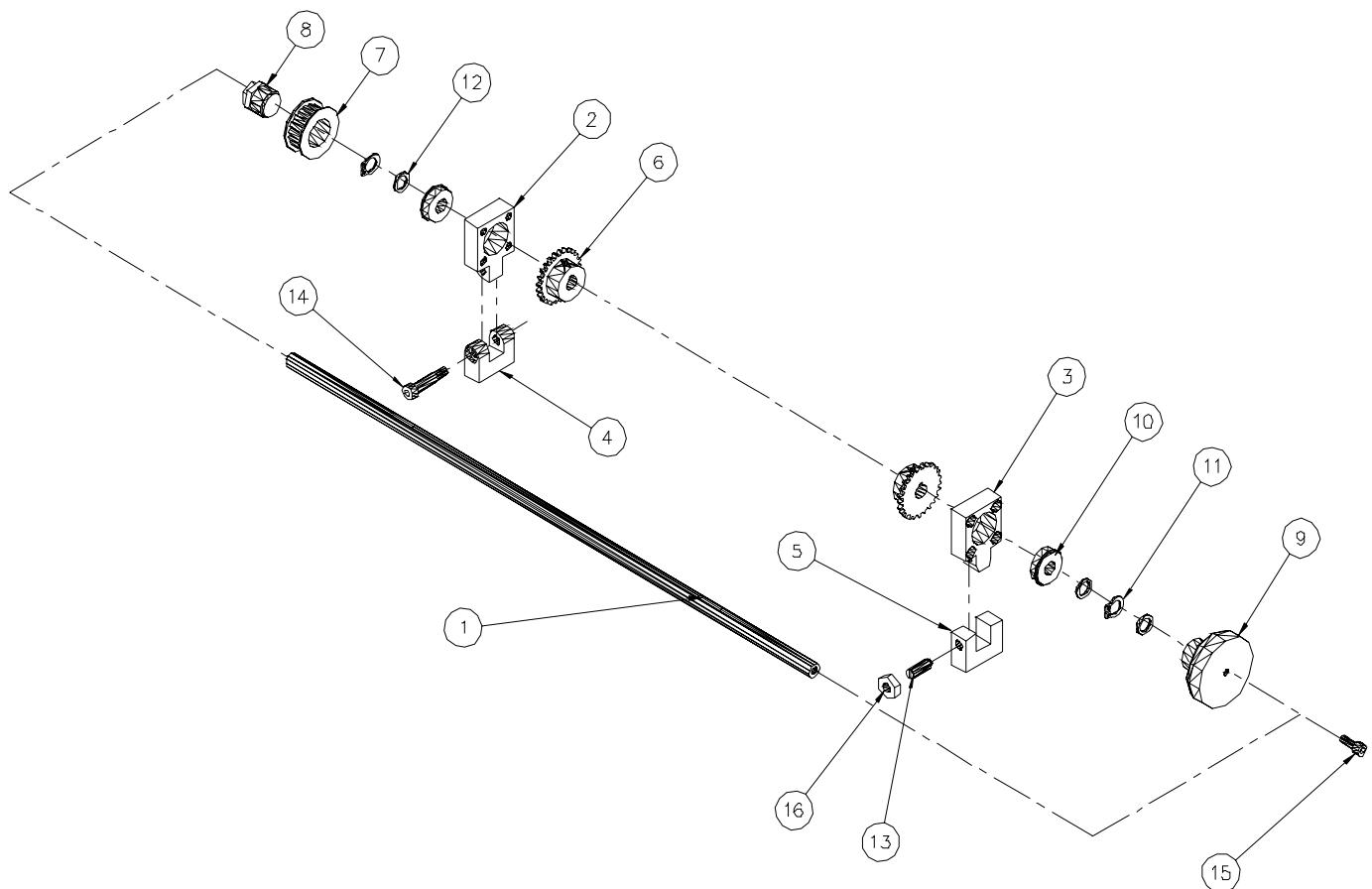
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COLLATOR – PUSHER (Fig. 2-19)
PUSHER DRIVE SHAFT ASSEMBLY

ITEM	PART NO.	QTY.	DESCRIPTION
1	18004-008	1	SHAFT, PUSHER DRIVE
2	18007-008	1	BLOCK, PIVOT W/ BEARING (UPPER)
3	18007-009	1	BLOCK, LATCH W/ BEARING (UPPER)
4	18007-001	1	BLOCK, PIVOT
5	18007-002	1	BLOCK, LATCH
6	18015-002	1	SPROCKET, DRIVE, MATCHED SET
7	18006-015	1	PULLEY, 18XL037
8	99017-013	1	TRANSTORQUE. 3/8
9	18019-007	1	KNOB ASSEMBLY
10	99003-020	2	BEARING, SEALED W/ SNAP RING, 3/8 X 7/8
11	99022-003	2	SNAP RING, 3/8
12	99003-017	3	WASHER, NYLON, 3/8 X 1/16
13	99005-008	1	SPRING PLUNGER, 1/4-20 X 3/4
14	99033-005	1	BOLT, SHOULDER, 1/4 X 3/4
15		1	SCREW, SKT HD, 10-24 X 1/2
16		1	NUT, HEX HD, 10-24

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FIG. 2-19



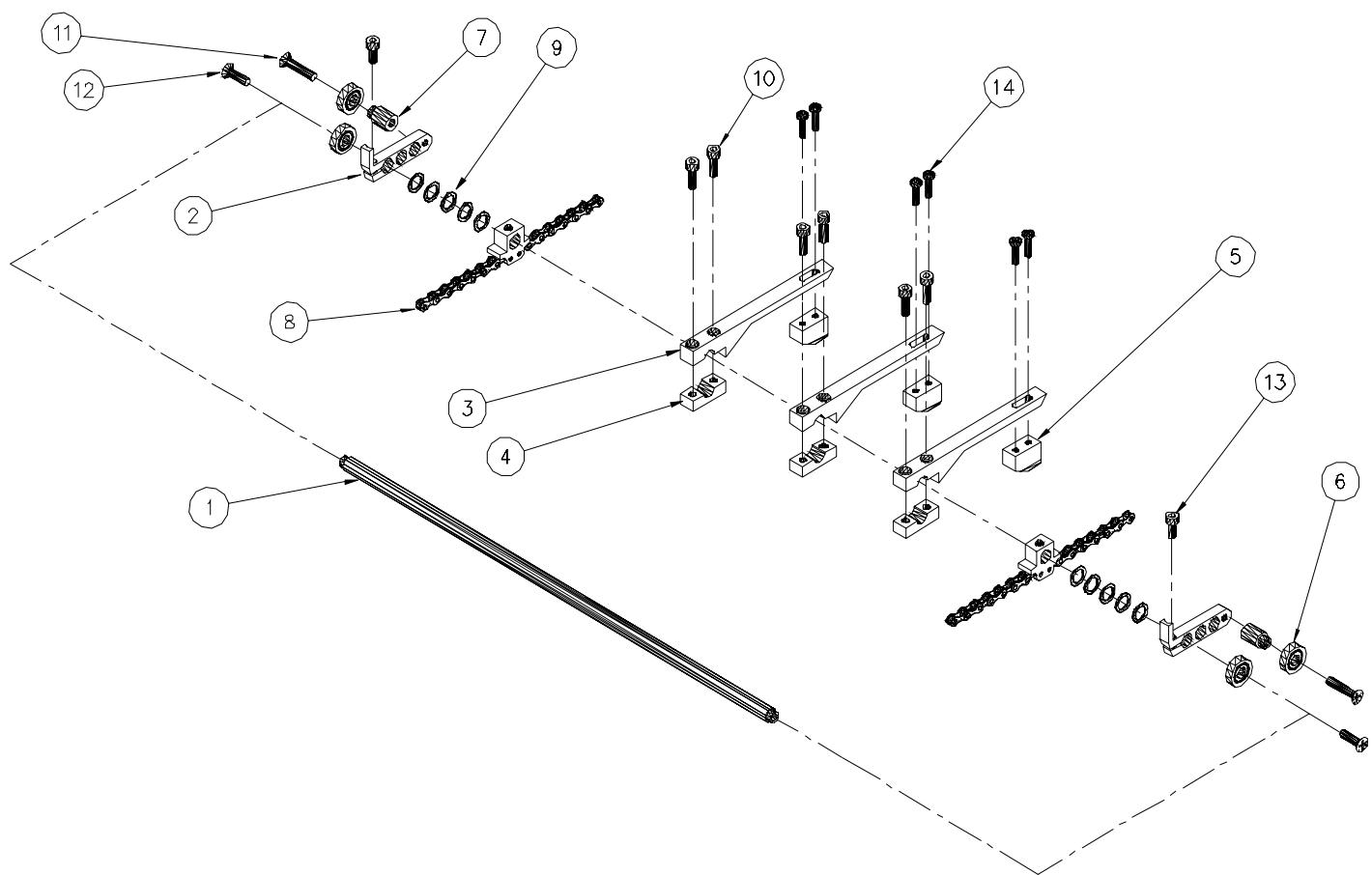
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COLLATOR – PUSHER (Fig. 2-20)
PUSHER ARM SHAFT ASSEMBLY

ITEM	PART NO.	QTY.	DESCRIPTION
1	18004-001	1	SHAFT, PUSHER
2	18008-010	2	BAR, PUSHER LINK
3	18008-009	3	BAR, PUSHER ARM
4	18008-053	3	CLAMP, PUSHER ARM
5	18007-015	3	BLOCK, PUSHER
6	99003-002	4	BEARING, SEALED, 1/4 X 5/8
7	18006-004	2	SPACER, BEARING
8	18014-002	2	PUSHER CHAIN ASSEMBLY (6 X9) (SEE FIG. 2-21)
9	99003-014	10	WASHER, NYLON, 5/16 X 1/32
10		6	SCREW, SKT HD, 8-32 X 1/2
11		2	SCREW, FLAT HD, 8-32 X 3/4
12		2	SCREW, FLAT HD, 8-32 X 1/2
13		2	SCREW, SKT HD, 8X 32 X 3/8
14		6	SCREW, PAN HEAD, 6-32 X 1/2
15	18020-051	3	PUSHER ARM ASSEMBLY CONSISTS OF ONE OF EACH (ITEMS 2, 3, AND 4)

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FIG. 2-20



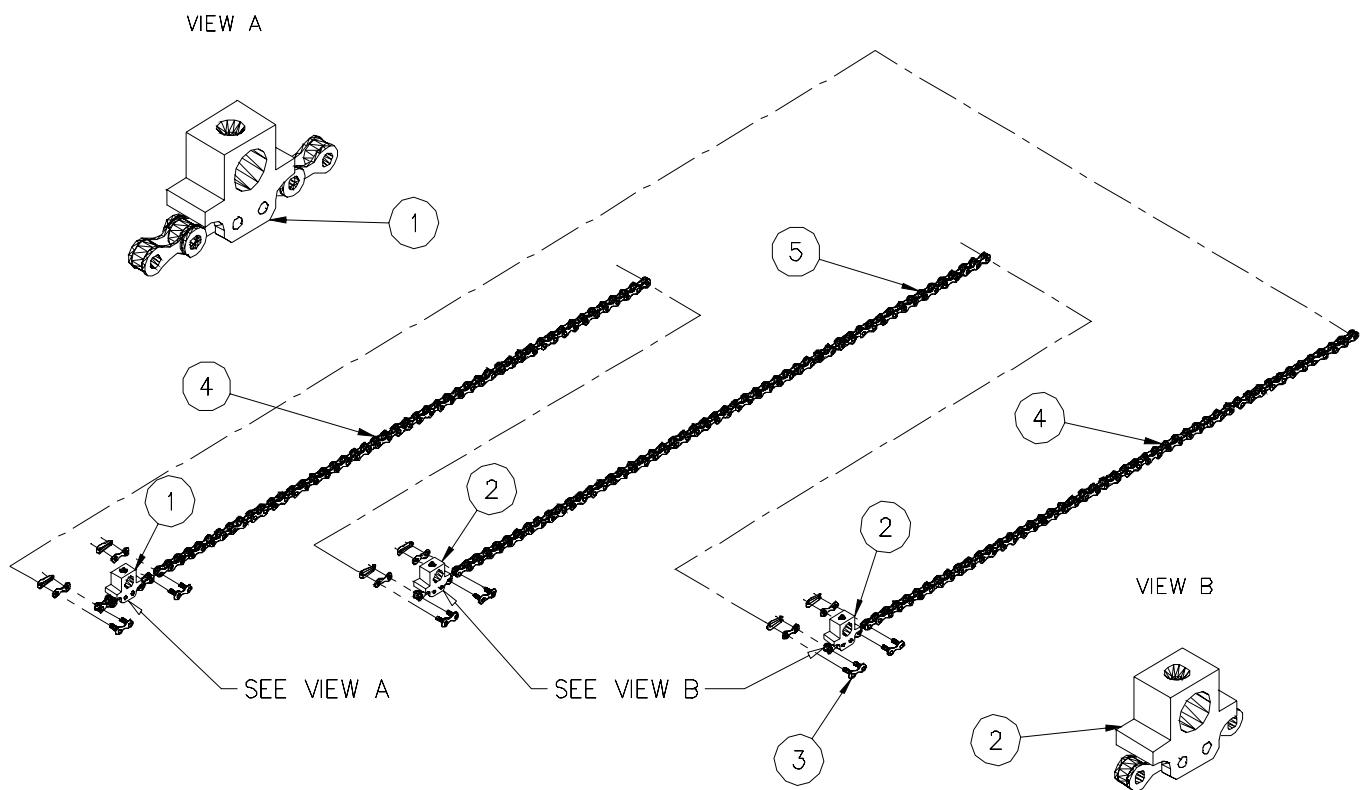
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COLLATOR – PUSHER (Fig. 2-21)
PUSHER CHAIN ASSEMBLY (6 X 9)

ITEM	PART NO.	QTY.	DESCRIPTION
1	18014-023	2	BLOCK, PUSHER CHAIN (W/ OFFSET LINK) (6 X9)
2	18014-022	4	BLOCK, PUSHER CHAIN (6 X 9)
3	99020-006	12	LINK, CONNECTING #25, MASTER
4	18014-012	4	CHAIN, #25, 11-3/4 LONG
5	18014-013	2	CHAIN, #25, 12-1/4 LONG
			NOTE: ALSO AVAILABLE
	18014-016	1	REBUILD KIT, PUSHER CHAIN (6 X 9) CONSISTING OF
	99020-006	12	LINK, CONNECTING #25, MASTER
	18014-012	4	CHAIN, #25, 11-3/4 LONG
	18014-013	2	CHAIN, #25, 12-1/4 LONG
			THIS KIT REBUILDS 2 CHAINS (1 MACHINE)

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FIG. 2-21



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COLLATOR – PUSHER (Fig. 2-22)
FINGER DRIVE SHAFT ASSEMBLY

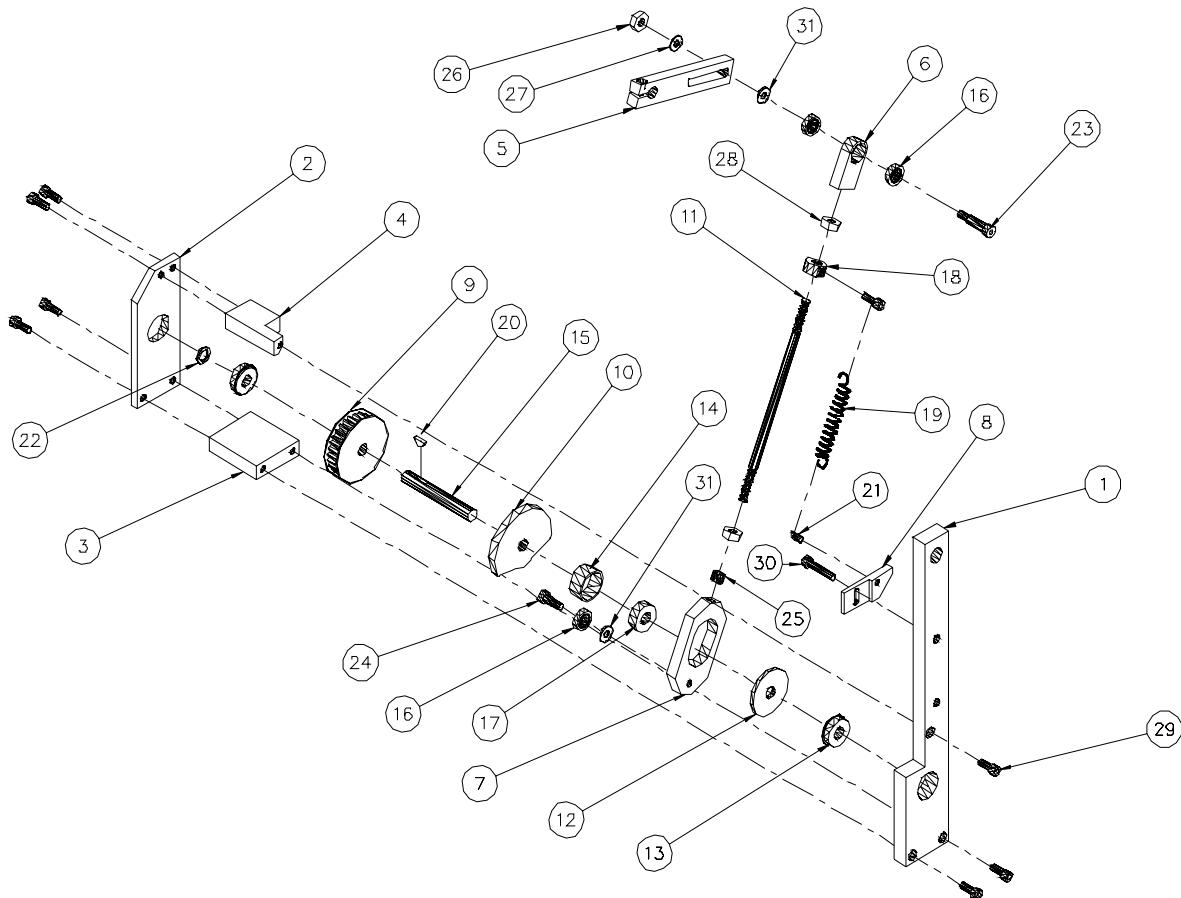
ITEM	PART NO.	QTY.	DESCRIPTION
1	18007-006	1	BAR, FINGER SUPPORT, LH
2	18007-007	1	PLATE, BEARING MTG
3	18008-005	1	SPACER BAR, LOWER
4	18008-006	1	SPACER BAR, UPPER
5	18008-015	1	LINK, FINGER
6	11015-002	1	ROD END, 5/8 BEARING
7	18007-017	1	YOKE, FINGER
8	18009-013	1	BRACKET, SPRING MOUNTING
9	99002-020	1	PULLEY, 30XL037, 3/8 BORE, NO HUB
10	18016-006	1	CAM, FINGER
11	18004-011	1	PUSH ROD
12	18006-010	1	WASHER, THRUST
13	99003-020	2	BEARING, SEALED W/ SNAP RING, 3/8 X 7/8
14	18006-027	1	ROLLER, YOKE GUIDE
15	18004-009	1	SHAFT, FINGER DRIVE
16	99003-002	3	BEARING, SEALED, 1/4 X 5/8
17	99003-008	1	BEARING, SEALED, 3/8 X 7/8
18	99017-002	1	COLLAR, SHAFT, 1/4
19	99005-009	1	SPRING, EXTENSION
20	99034-004	1	KEY. WOODRUF, 1/8 X 1/2
21	99006-016	1	PIN, SPRING CLIP, 10-32 X 3/8
22	99003-016	1	WASHER, NYLON, 3/8 X 1/32
23	99033-005	1	BOLT, SHOULDER, 1/4 X 3/4
24	99033-006	1	BOLT, SHOULDER, 1/4 X 1/4
25	99036-001	1	SPACER, RH JAW
26		1	NUT, LOCK, 1/4-20

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**COLLATOR – PUSHER (Fig. 2-22)
FINGER DRIVE SHAFT ASSEMBLY CONTINUED**

ITEM	PART NO.	QTY.	DESCRIPTION
27		1	WASHER, FLAT, 1/4
28		2	NUT, HEX HEAD, 10-28
29		8	SCREW, SKT HD, 10-24 X 1/2
30		1	SCREW, SKT HD, 10-24 X 1
31	99036-002	2	SPACER, 1/4 X 3/8 X 1/16, HARDENED

FIG. 2-22



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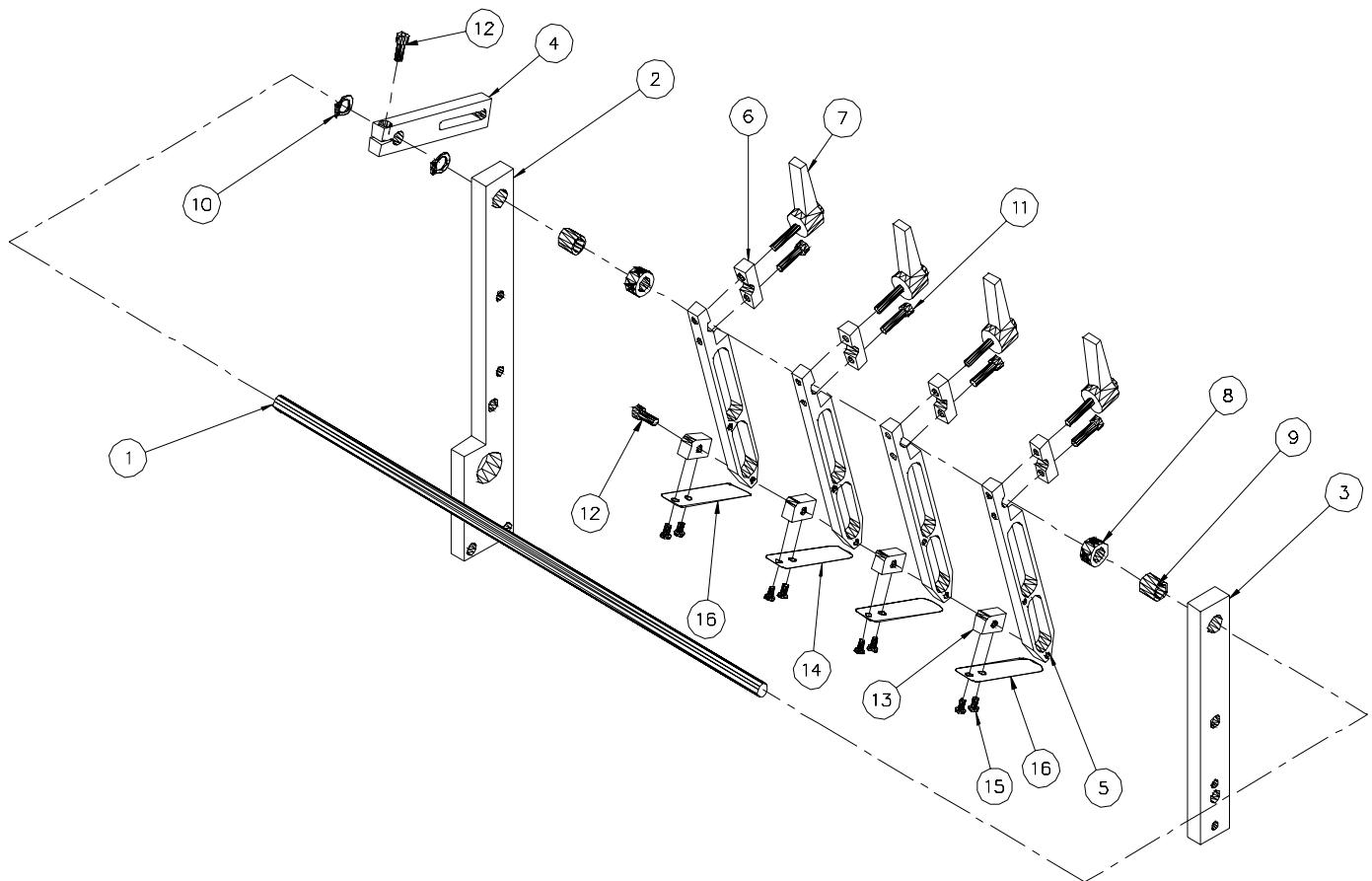
COLLATOR – PUSHER (Fig. 2-23)
FINGER ARM SHAFT ASSEMBLY

ITEM	PART NO.	QTY.	DESCRIPTION
1	18004-010	1	SHAFT, FINGER
2	18007-006	1	BAR, FINGER SUPPORT, LH
3	18007-005	1	BAR, FINGER SUPPORT, RH
4	18008-015	1	BAR, FINGER LINK
5	*18008-016	4	BAR, FINGER ARM
6	**18008-049	4	CLAMP, FINGER ARM
7	99004-003	4	HANDLE, ADJUSTING
8	99017-003	2	COLLARS, SHAFT, 3/8
9	99003-026	2	BUSHING, 3/8 X 1/2 X 1/2
10	99022-003	2	SNAP RING, 3/8
11		4	SCREW, SKT HD, 10-24 X 3/4
12		5	SCREW, SKT HD, 10-24 X 1/2
13	18007-018	4	BLOCK, FINGER MTG.
14	18005-008	2	GUIDE, ENTERING FINGER, INNER
15		8	SCREW, PAN HD, 6-32 X 1/4
16	18005-090	2	GUIDE, ENTERING FINGER, OUTER

*= This part for a Servo System has changed to # 18008-111
 **= This part for a Servo System has changed to # 18008-112

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FIG. 2-23



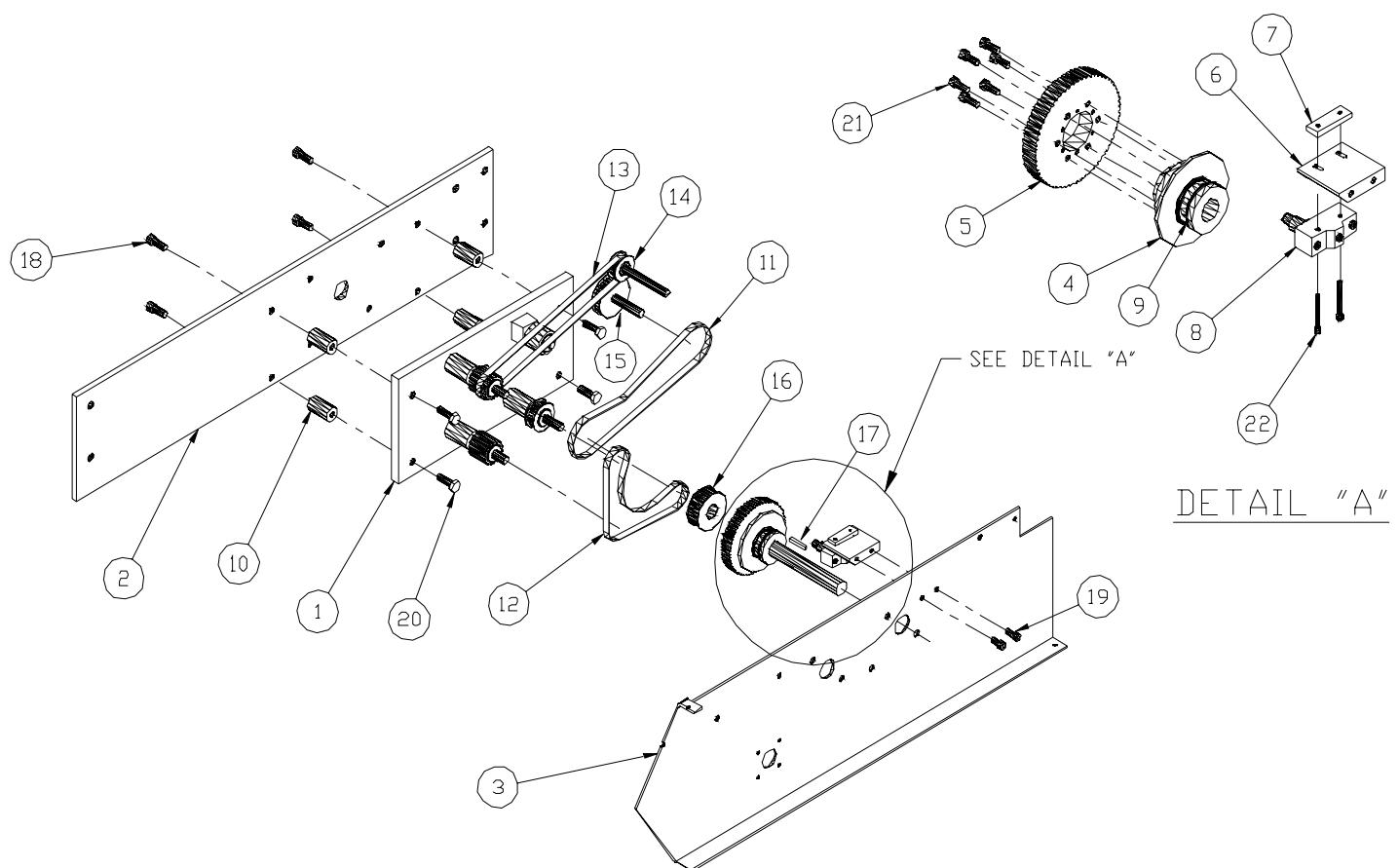
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COLLATOR – PUSHER DRIVE ASSEMBLY (Fig. 2-24)

ITEM	PART NO.	QTY.	DESCRIPTION
1	(SEE FIG. 2-25)	1	IDLER MOUNTING PLATE ASSEMBLY
2	18011-019	1	PLATE, PUSHER DRIVE MOUNTING
3	18000-010	1	SIDEFRAME, LH (REF. ONLY)
4	99008-002	1	CLUTCH, OVERLOAD
5	18006-022	1	PULLEY, CLUTCH, 60XL037
6	18009-003	1	BRACKET, SWITCH MTG.
7	18011-022	1	NUT PLATE, SWITCH
8	98000-002	1	SWITCH, OVERLOAD CLUTCH
9	99005-004	1	SPRING, OVERLOAD CLUTCH
10	18012-009	4	STANDOFF, IDLER MTG. PLATE
11	99000-029	1	BELT, TIMING, 210XL037
12	99000-031	1	BELT, TIMING, DOUBLE 200XL037
13	99000-030	1	BELT, TIMING, 220XL037
14	18006-015	1	PULLEY, 18XL037, PUSHER DRIVE SHAFT (REF. ONLY)
15	99002-020	1	PULLEY, 30XL037, FINGER DRIVE SHAFT (REF. ONLY)
16	99002-049	1	PULLEY, 30XL037, 3/4 BORE
17	99034-002	1	KEY, 3/16 X 1"
18		4	SCREW, SKT HD, 5/6-18 X 3/4
19		2	SCREW, SKT HD, 1/4-20 X 1/2
20		4	BOLT, HEX HD, 5/6-18 X 1
21		6	SCREW, SKT HD, 10-24 X 1/2
22		2	SCREW, SKT HD, 6-32 X 1-1/4

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FIG. 2-24



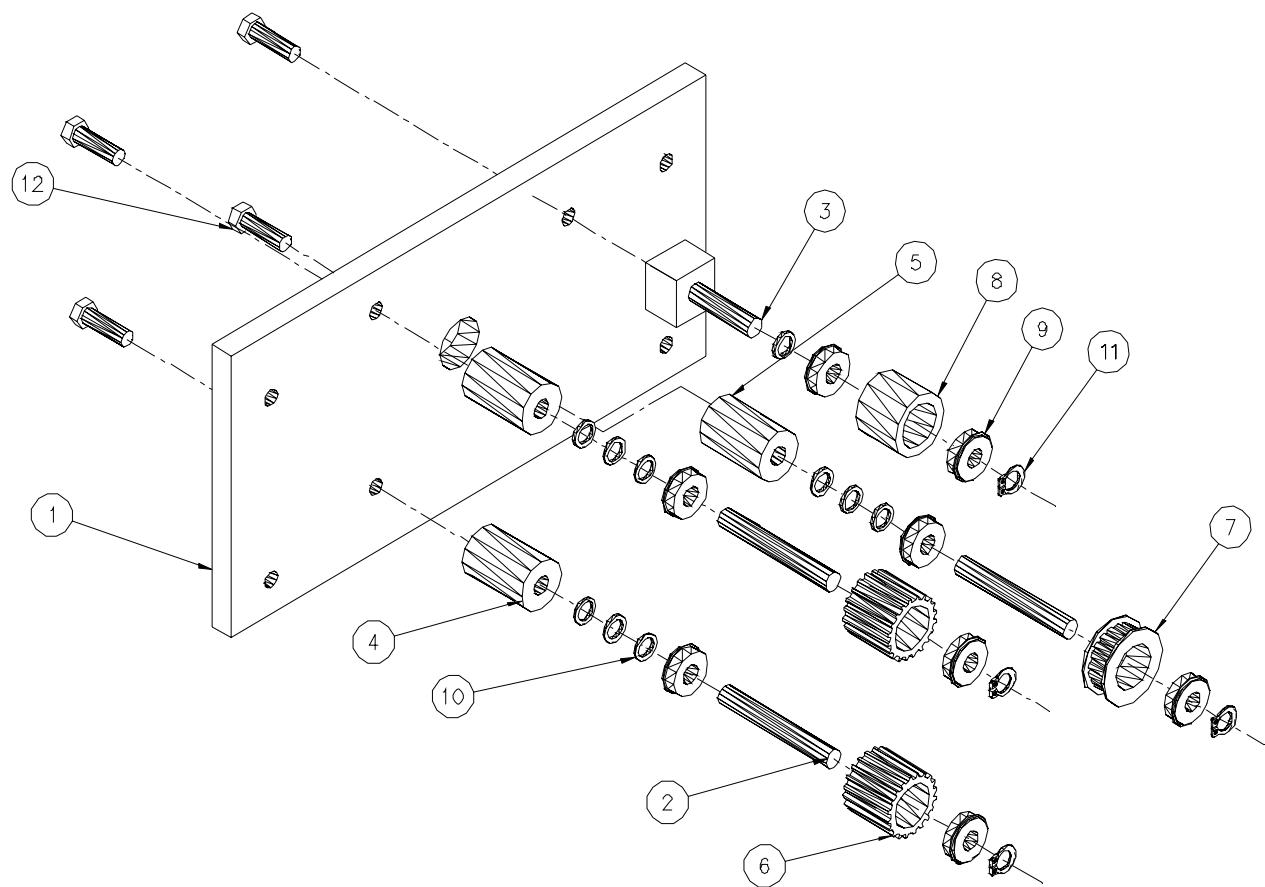
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COLLATOR – PUSHER DRIVE (Fig. 2-25)
IDLER MOUNTING PLATE ASSEMBLY

ITEM	PART NO.	QTY.	DESCRIPTION
1	18011-018	1	IDLER MOUNTING PLATE
2	18004-037	3	SHAFT, STUB IDLER, 3/8 X 2-3/4
3	18007-058	1	SHAFT, ECCENTRIC IDLER. 3/8 X 2-1/4
4	18007-012	2	BLOCK, IDLER MTG. ECCENTRIC
5	18007-059	1	BLOCK, IDLER MTG., STRAIGHT
6	10006-027	2	PULLEY, IDLER, 20XL 1-1/8" WIDE
7	18006-024	1	PULLEY, IDLER, 20XL037, 7/8 BORE W/ FLANGES
8	18006-001	1	PULLEY, IDLER, FLAT
9	99003-020	8	BEARING, 3/8 X 7/8 SEALED W/ SNAP RING
10	99003-017	10	WASHER, NYLON, 3/8
11	99022-003	4	SNAP RING, 3/8
12		4	BOLT, HEX HD, 5/16-18 X 1

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FIG. 2-25



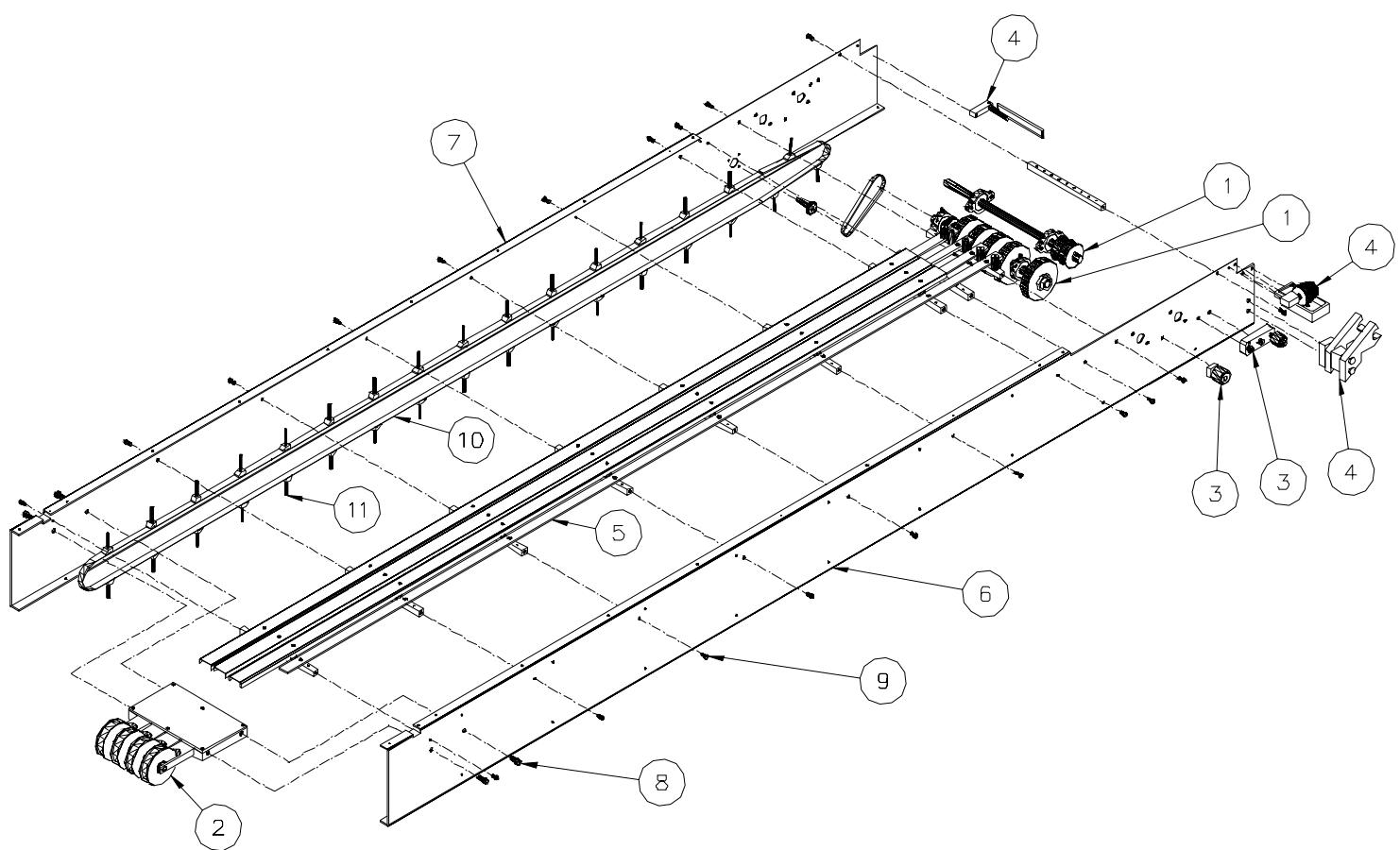
**Sure-Feed
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COLLATOR – CONVEYOR ASSEMBLY (Fig. 2-26)

ITEM	PART NO.	QTY.	DESCRIPTION
1	(SEE FIG. 2-27)	1	COLLATOR DRIVE SHAFT ASSEMBLY
2	(SEE FIG. 2-28)	1	IDLER ASSEMBLY, REAR PULLEY
3	(SEE FIG. 2-29)	1	TENSIONER ASSY., IDLER PULLEYS
4	(SEE FIG. 2-30)	1	FRONT END COLLATOR ASSEMBLY (DRIP PAN / ROLLER / STRIP BRUSH / PULLEY GUIDE YOKE)
5	(SEE FIG. 2-31)	1	CONVEYOR BELT GUIDE ASSEMBLY
6	18000-010	1	SIDEFRAME, LH, 6 X 9
7	18000-009	1	SIDEFRAME, RH, 6 X 9
8		4	SCREW, SKT HD, 3/8-16 X 3/4
9		20	SCREW, SKT HD, 1/2-20 X 1/2
10	18014-001	4	BELT, COLLATOR, (6 STATION) (Before 2001)
10a	18014-028	4	BELT, COLLATOR, (6 STATION)
10b	18014-032	4	BELT, COLLATOR, (3 STATION)
10c	18014-030	4	BELT, COLLATOR, (9 STATION)
10d	18014-019	4	BELT, COLLATOR , (12 STATION)
10e	18014-035	4	BELT, COLLATOR, (18 STATION)
11	18004-039	128	PIN, COLLATOR (6 STATION) (Note: Increase pin count by 48 for every 3 feeder stations added to the length of machine)

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FIG. 2-26



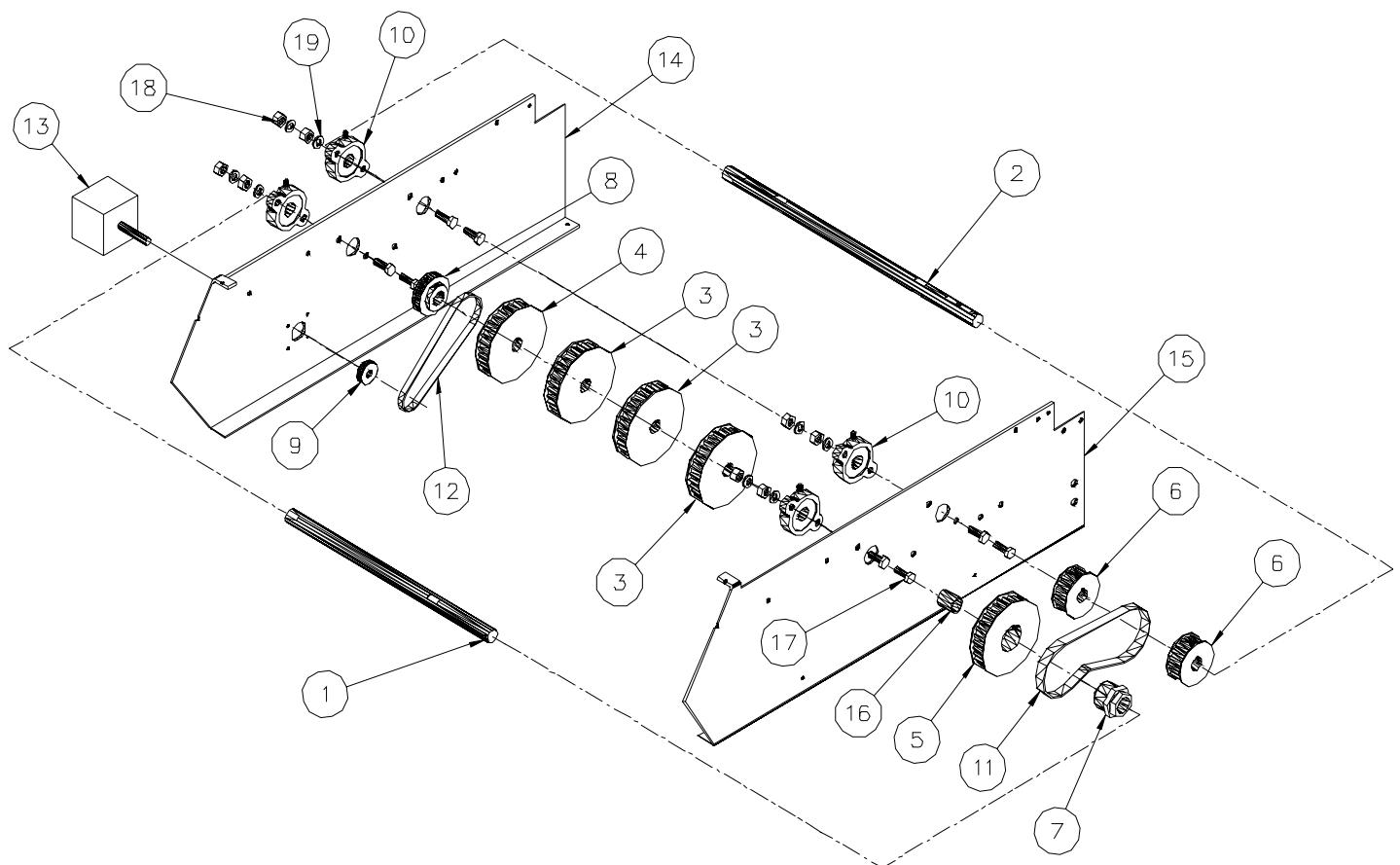
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COLLATOR – CONVEYOR (Fig. 2-27)
COLLATOR DRIVE SHAFT ASSEMBLY

ITEM	PART NO.	QTY.	DESCRIPTION
1	18004-012	1	SHAFT, COLLATOR DRIVE
2	18004-021	1	SHAFT, COLLATOR DRIVE (1 TO 1)
3	18006-006	3	PULLEY, 32L075, 3/4 BORE
4	18006-029	1	PULLEY, 32L075, 3/4 BORE W/ KEYWAY
5	18006-007	1	PULLEY, 32L075, 1-1/2 BORE
6	18006-025	2	PULLEY, 19L075, 3/4 BORE W/ KEYWAY, NO HUB
7	99017-014	1	TRANTORQUE, 3/4 BORE
8	99002-011	1	PULLEY, 32XL075, 3/4 BORE
9	99002-010	1	PULLEY, 19XL037, 3/8 BORE
10	99003-019	4	BEARING, 2 BOLT FLANGE
11	99000-022	1	BELT, TIMING, 202L075
12	99000-008	1	BELT, TIMING, 150XL037
13	98017-001	1	ENCODER
14	18000-010	1	SIDEFRAME, LH, 6 X 9 (REF. ONLY)
15	18000-009	1	SIDEFRAME, RH, 6 X 9 (REF. ONLY)
16	99003-025	1	BUSHING, 3/4 X 7/8 X 1
17		8	BOLT, HEX HD, 3/8-16 X 1
18		8	NUT, HEX HD, 3/8-16
19		8	WASHER, LOCK, 3/8

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FIG. 2-27



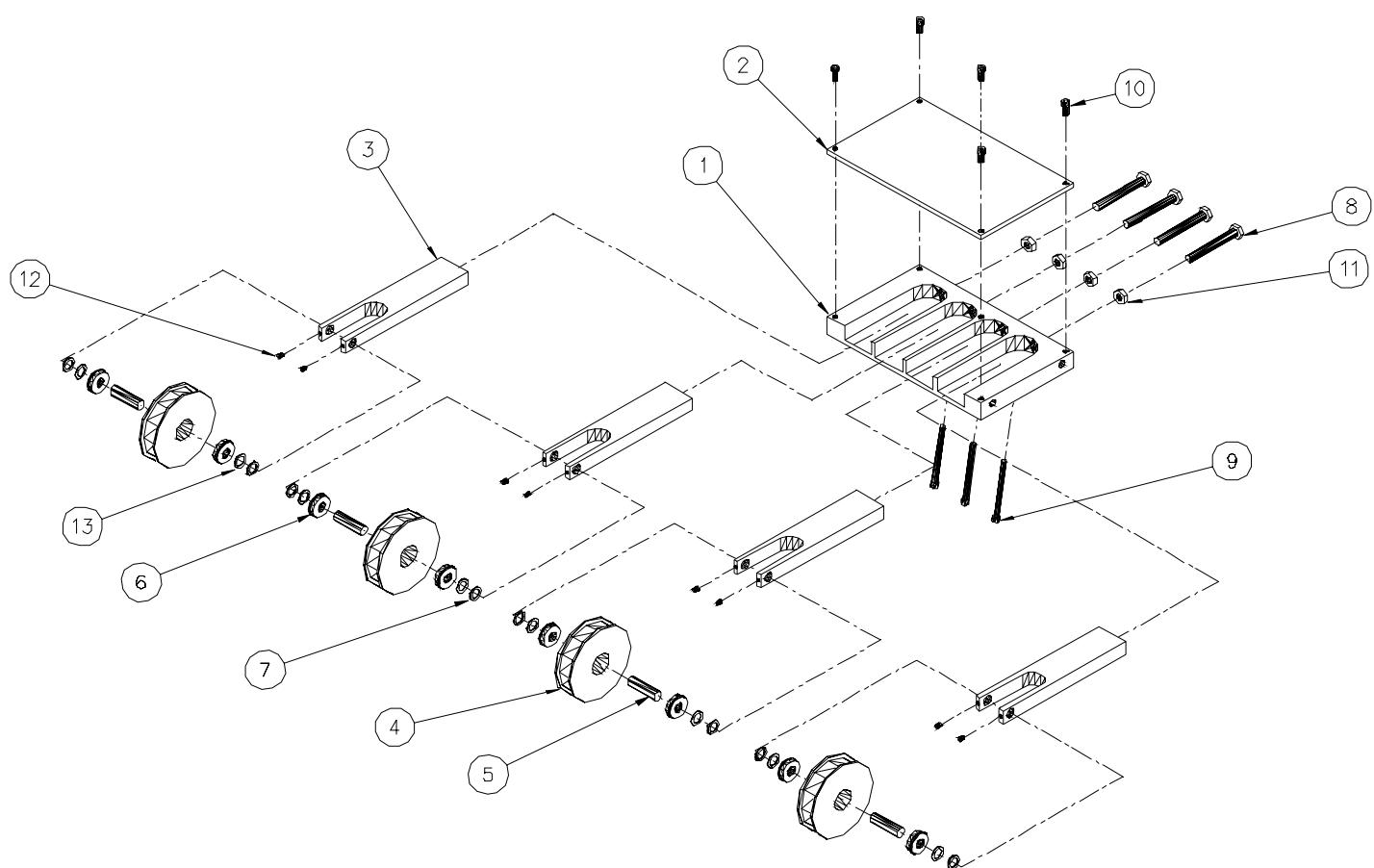
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COLLATOR – CONVEYOR (Fig. 2-28)
IDLER ASSEMBLY (REAR PULLEY)

ITEM	PART NO.	QTY.	DESCRIPTION
1	18007-014	1	BLOCK, IDLER MTG.
2	18011-006	1	PLATE, IDLER BLOCK
3	18008-008	4	BAR, IDLER MTG.
4	18006-005	4	PULLEY, IDLER
5	18004-002	4	SHAFT, STUB IDLER
6	99003-007	8	BEARING, SEALED, 1/2 X 1-1/8
7	99003-018	8	WASHER, NYLON, 1/2 X 1/16
8		4	BOLT, HEX HD, 3/8-16 X 3
9		3	SCREW, SKT HD, 1/4-20 X 3
10		5	SCREW, SKT HD, 1/4-20 X 1/2
11		4	NUT, HEX HD, 3/8-16
12		8	SCREW, SET, 10-24 X 1/4
13	99036-004	8	SHIM, 1/2 X 3/4 X .020

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FIG. 2-28



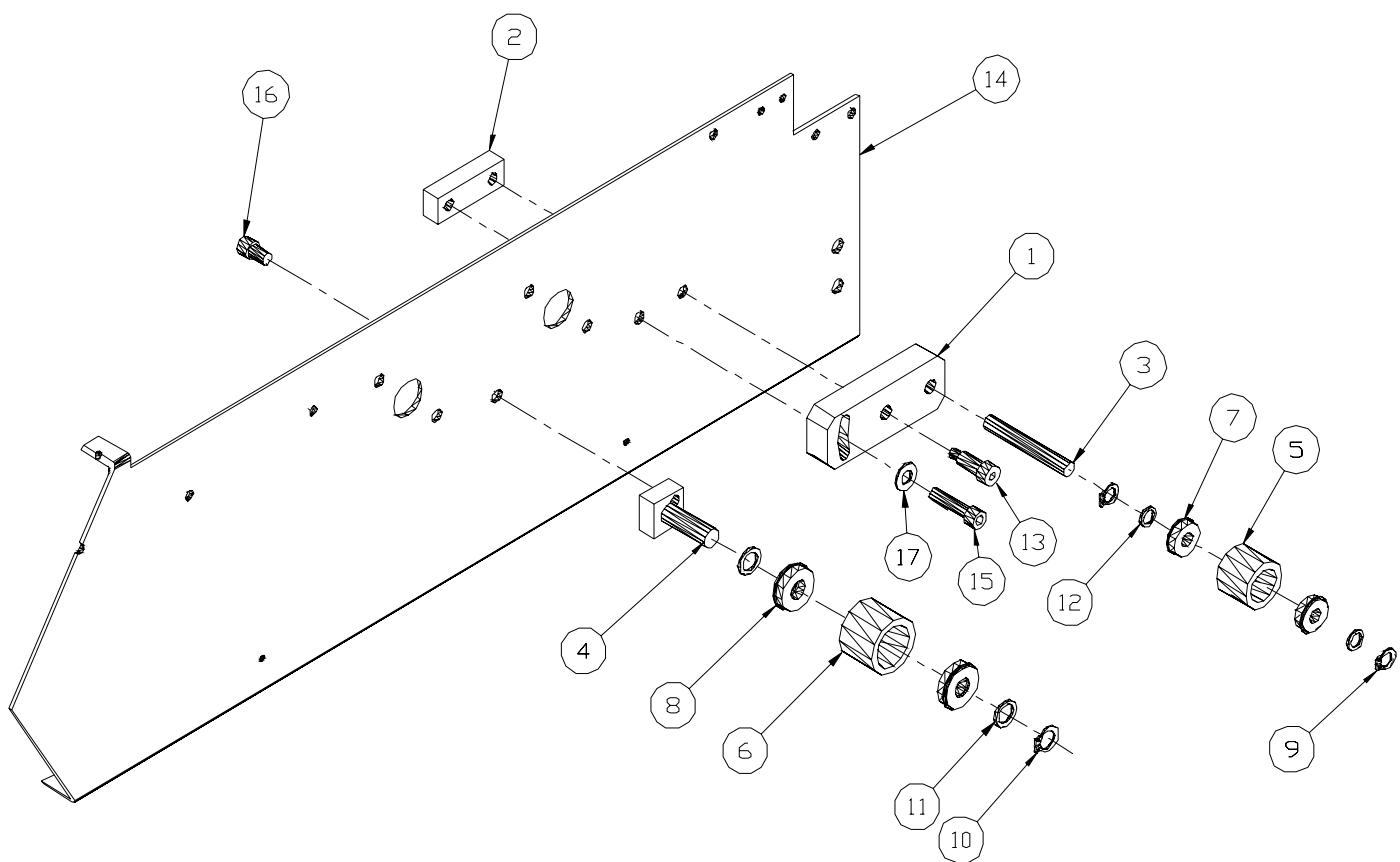
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COLLATOR – CONVEYOR (Fig. 2-29)
TENSIONER / FLAT IDLER PULLEY ASSEMBLY

ITEM	PART NO.	QTY.	DESCRIPTION
1	18007-057	1	BLOCK, TENSIONER
2	18011-025	1	NUT PLATE, TENSIONER
3	18004-037	1	SHAFT, STUB IDLER, 3/8 X 2-3/4
4	18004-022	1	SHAFT, ECCENTRIC IDLER, 1/2
5	18006-001	1	PULLEY, FLAT IDLER, 1-1/4 DIAM. X 1
6	18006-012	1	PULLEY, FLAT IDLER, 1-1/2 DIAM. X 1-1/8
7	99003-020	2	BEARING, SEALED W/ SNAP RING, 3/8 X 7/8
8	99003-007	2	BEARING, SEALED W/ SNAP RING, 1/2 X 1-1/8
9	99022-003	2	SNAP RING, 3/8
10	99022-004	1	SNAP RING, 1/2
11	99003-018	2	WASHER, NYLON, 1/2 X 1/16
12	99003-017	2	WASHER, NYLON, 3/8 X 1/16
13	99033-011	1	BOLT, SHOULDER, 3/8 X 3/4
14	18000-010	1	SIDEFRAME, RH, 6 X 9 (REF. ONLY)
15		1	SCREW, SKT HD, 5/16-18 X 1-1/4
16		1	SCREW, SKT HD, 5/6-18 X 1/2
17		1	WASHER, FLAT, 5/16

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FIG. 2-29



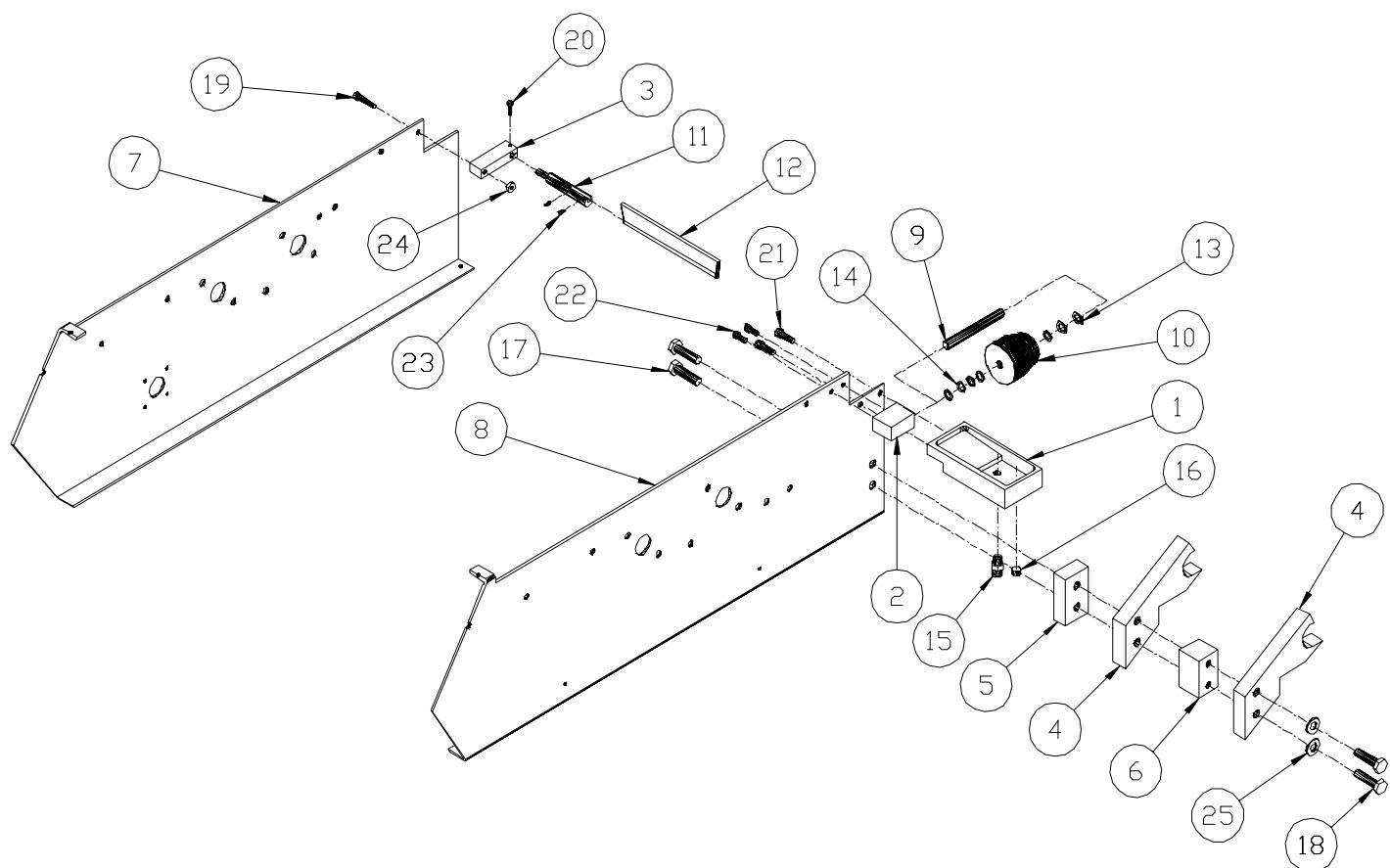
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COLLATOR – CONVEYOR (Fig. 2-30)
FRONT END COLLATOR ASSEMBLY
(DRIP PAN / ROLLER / STRIP BRUSH / GUIDE YOKE)

ITEM	PART NO.	QTY.	DESCRIPTION
1	18019-004	1	DRIP PAN, 10 X 13
2	18007-054	1	BLOCK, ROLLER MTG.
3	18007-080	1	BLOCK, LOWER BRUSH MTG
4	18007-049	2	BLOCK, YOKE, 6 X 9
5	18012-012	1	SPACER, PULLEY GUIDE YOKE
6	18007-050	1	BLOCK, PULLEY GUIDE YOKE MTG.
7	18000-009	1	SIDEFRAME, RH, 6 X 9 (REF. ONLY)
8	18000-010	1	SIDEFRAME, LH, 6 X 9 (REF. ONLY)
9	18004-032	1	SHAFT, ROLLER MTG.
10	18006-019	1	ROLLER, BRUSH
11	18009-023	1	BRACKET, LOWER BRUSH CLAMP
12	99023-001	1	BRUSH STRIP, 6" X 1" X .003
13	99022-007	2	SNAP RING, 3/8, SST
14	99003-017	5	WASHER, NYLON, 3/8 X 1/16
15	99028-029	1	FITTING, HOSE BARB, 1/4 NPT X 3/8 ID HOSE
16	99028-009	1	PLUG, FLUSH 1/4 NPT
17		2	BOLT, HEX HEAD, 3/8-16 X 1-1-3/4
18		2	BOLT, HEX HD, 3/8-16 X 1
19		1	SCREW, SKT HD, 10-24 X 3/4
20		1	SCREW, SKT HD, 8-32 X 1/2
21		2	SCREW, SKT HD, 1/4-20 X 3/4
22		2	SCREW, SKT HD, 10-24 X 1/2
23		2	SCREW, SET, 6-32 X 1/4
24		1	NUT, HEX, #10
25		2	WASHER, FLAT, 3/8

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FIG. 2-30



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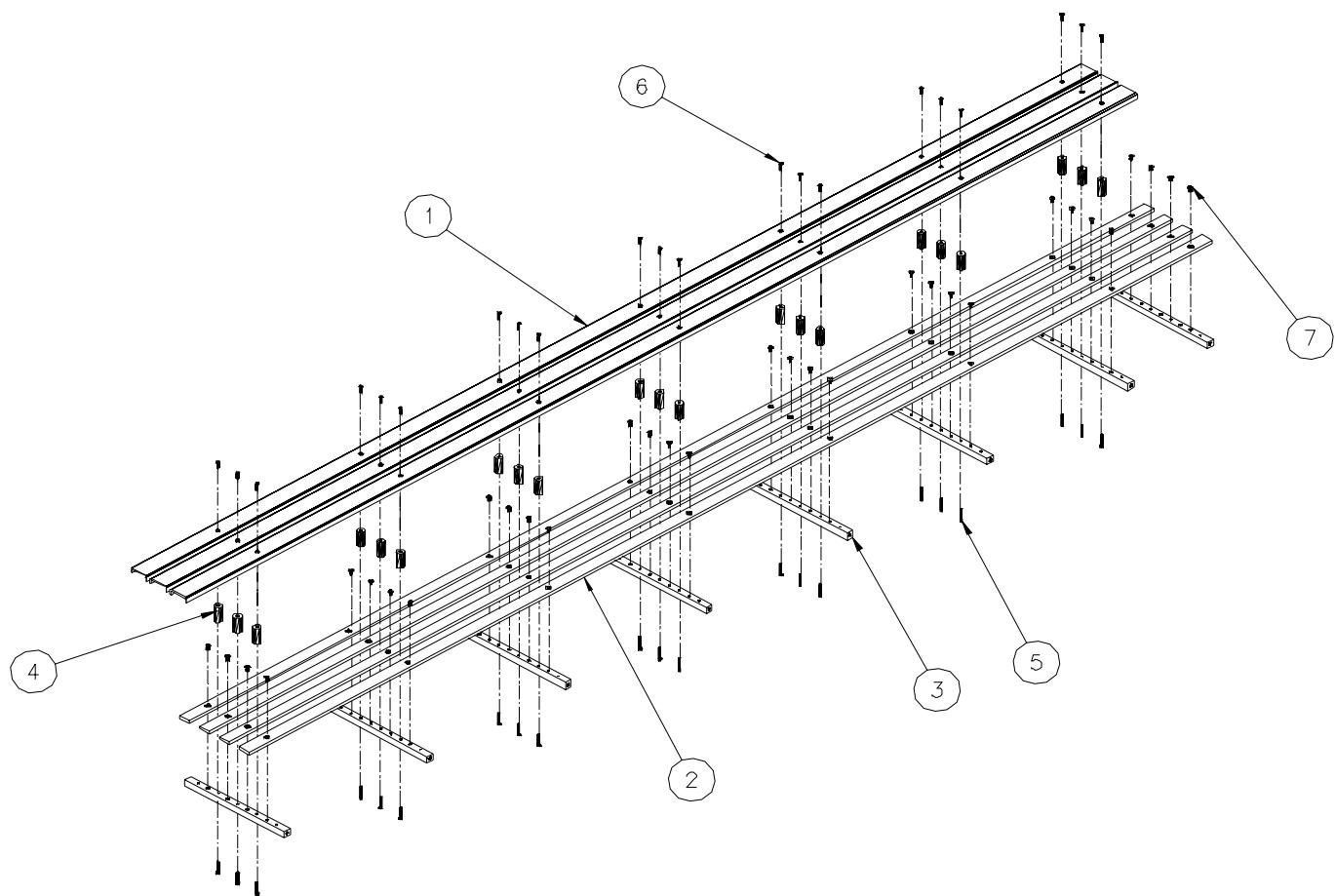
COLLATOR – CONVEYOR (Fig. 2-31)
CONVEYOR BELT TRACK ASSEMBLY

ITEM	PART NO.	QTY.	DESCRIPTION
1	18005-080	3	GUIDE, PAPER SLIDE, FRONT (6 STATION)
1a	18005-109	3	GUIDE, PAPER SLIDE, FRONT (3 STATION)
*1b	18005-096	3	GUIDE, PAPER SLIDE, REAR (9 STATION)
*1c	18005-079	3	GUIDE, PAPER SLIDE, REAR (12 STATION)
2	18008-071	4	BAR, BELT SUPPORT (6 STATION)
2b	18008-091	4	BAR, BELT SUPPORT (3 STATION)
2c	18008-077	4	BAR, BELT SUPPORT (9 STATION)
2d	18008-068	4	BAR, BELT SUPPORT (12 STATION)
3	18003-009	8	BAR, CROSS, 10"
4	18012-001	21	STANDOFF, 5/8-DIAM X 1.42 LG.
5		21	SCREW, SKT HD, 6-32 X 1
6		21	SCREW, FLAT HD, 6-32 X 1/2
7		32	SCREW, FLAT HD, 10-24 X 1/4

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* USE WITH GUIDE, PAPER SLIDE, FRONT FROM 6 STATION

FIG 2-31



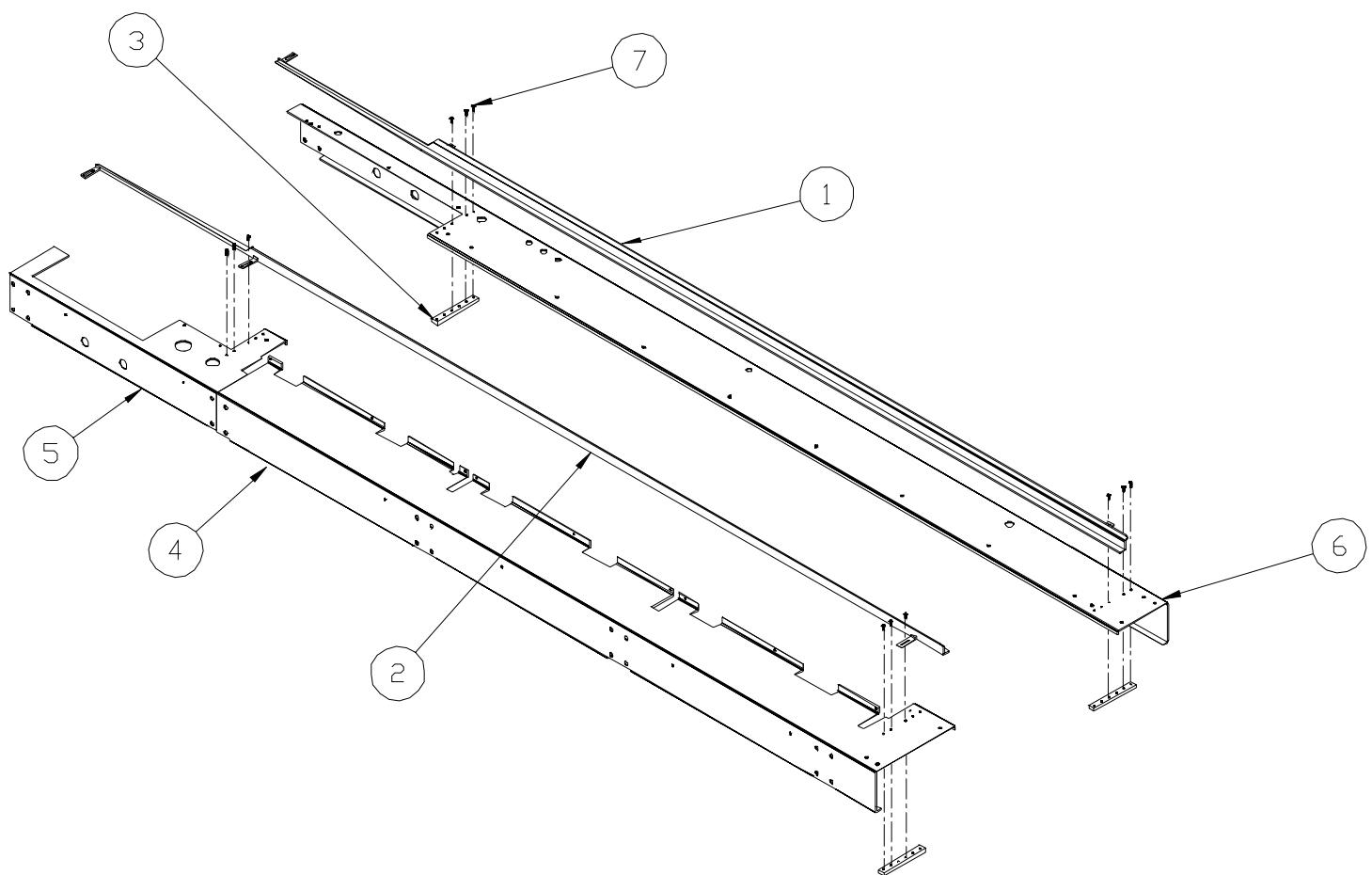
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COLLATOR – CONVEYOR (Fig. 2-32)
SIDE GUIDE ASSEMBLY

ITEM	PART NO.	QTY.	DESCRIPTION
1	18005-085	1	PAPER GUIDE, RH
2	18005-086	1	PAPER GUIDE, LH
3	18011-036	4	PLATE, NUT (SIDE GUIDE)
4	18001-002	1	COVER, TOP, LH (REF. ONLY)
5	18001-032	1	COVER, TOP, LH SHORT (REF. ONLY)
6	18001-027	1	COVER, TOP, RH (REF. ONLY)
7		12	SCREW, BUTTON HD, 10-24 X 1/2

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FIG. 2-32



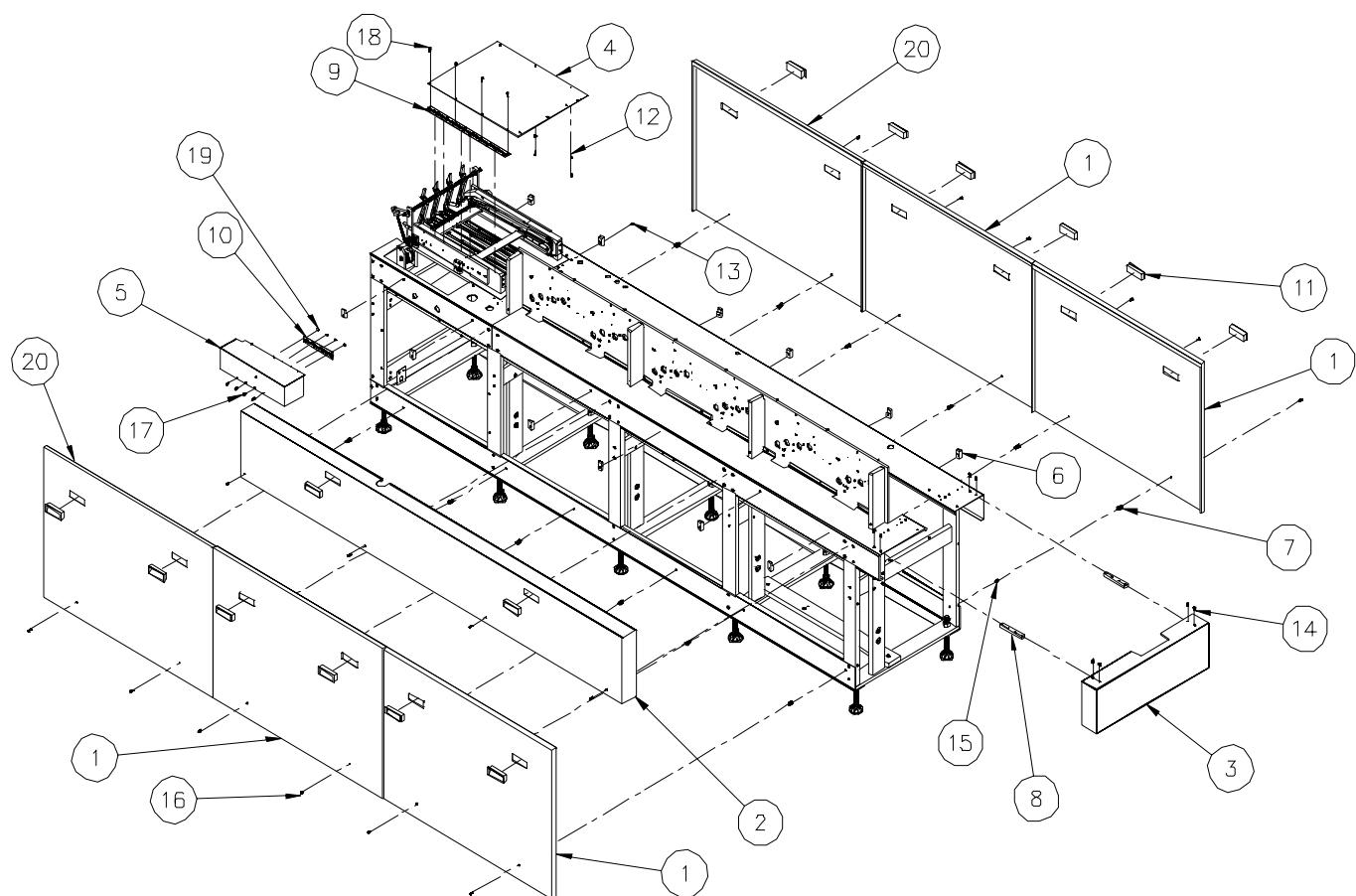
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COLLATOR – COVERS (Fig. 2-33)

ITEM	PART NO.	QTY.	DESCRIPTION
1	18013-044	4	COVER, LOWER SIDE
2	18001-004	1	COVER, FEEDER DRIVE
3	18013-003	1	COVER, REAR
4	18013-022	1	COVER, PUSHER
5	18013-011	1	COVER, PUSHER DRIVE
6	18007-042	12	BLOCK, SIDE COVER MTG
7	18012-006	12	STANDOFF, SIDE COVER MTG
8	18007-043	2	BLOCK, END COVER MTG
9	18013-025	1	HINGE, PUSHER COVER
10	18013-024	1	HINGE, PUSHER DRIVE COVER
11	99012-002	14	HANDLE, POCKET PULL
12	99010-004	3	BUMPER
13		12	SCREW, SKT HD, 10-24 X 1/2
14		12	SCREW, BUT HD, 10-24 X 1/2
15		12	SCREW, SKT HD, 10-24 X 3/8
16		16	SCREW, BUT HD, 10-24 X 3/8
17		9	SCREW, BUT HD, 8-32 X 1/2
18		4	SCREW, PAN HD, 8-32 X 1/2
19		8	NUT, HEX, #8
20	18013-039	2	COVER, LOWER SIDE

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FIG. 2-33



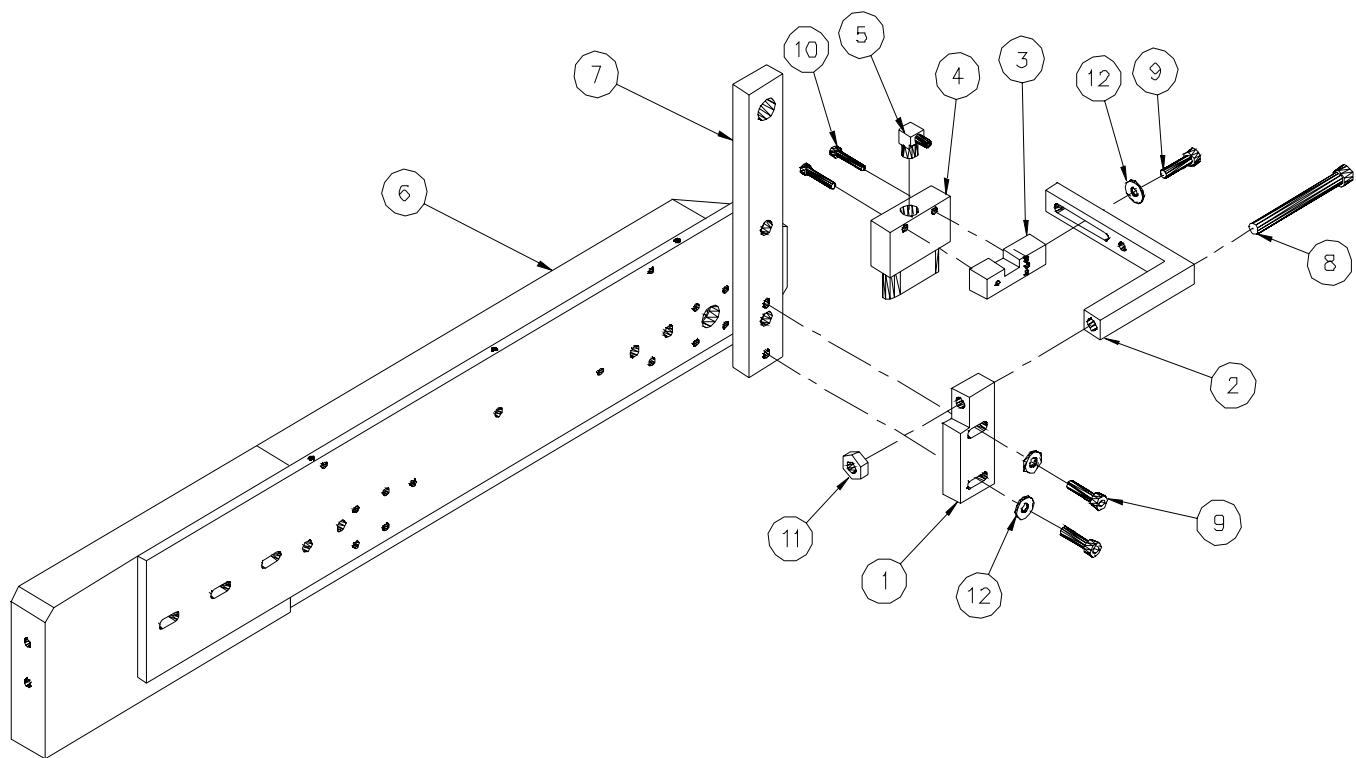
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COLLATOR – WATER BRUSH ASSEMBLY (Fig. 2-34)

ITEM	PART NO.	QTY.	DESCRIPTION
1	18007-053	1	BLOCK, BRUSH MTG.
2	18009-008	1	BRACKET, BRUSH MTG.
3	18007-067	1	BLOCK, BRUSH ADJ.
4	18019-005	1	BRUSH, WATER
5	99028-038	1	HOSE BARB, ELBOW, 1/4 OD TUBE X 1/16 NPT
6	18016-002	1	CAM, PUSHER CONTROL, RH FRONT (REF. ONLY)
7	18007-005	1	BAR, FINGER SUPPORT, RH (REF. ONLY)
8		1	SCREW, SKT HD, 1/4-20 X 2-1/2
9		3	SCREW, SKT HD, 10-24 X 3/4
10		2	SCREW, SKT HD, 6-32 X 3/4
11		1	NUT, LOCK, 1/4-20
12		3	WASHER, FLAT, #10
13	99031-005	4'	TUBING, 1/8 ID X 1/4 OD (NOT SHOWN)

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FIG. 2-34

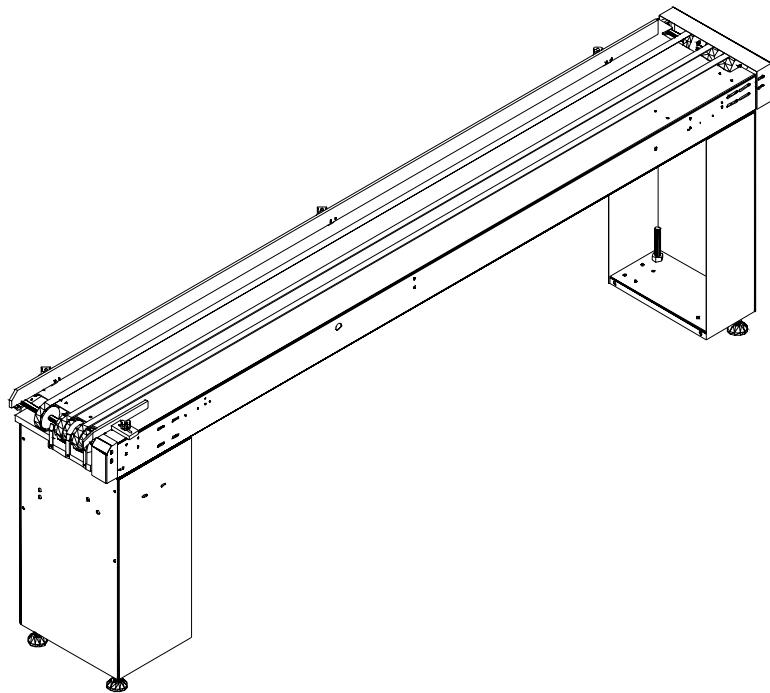


NOTE: TUBING NOT SHOWN (ITEM 13) – CONNECTS TO HOSE BARB (ITEM 5)

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**INFEED
CONVEYOR
6 X 9**



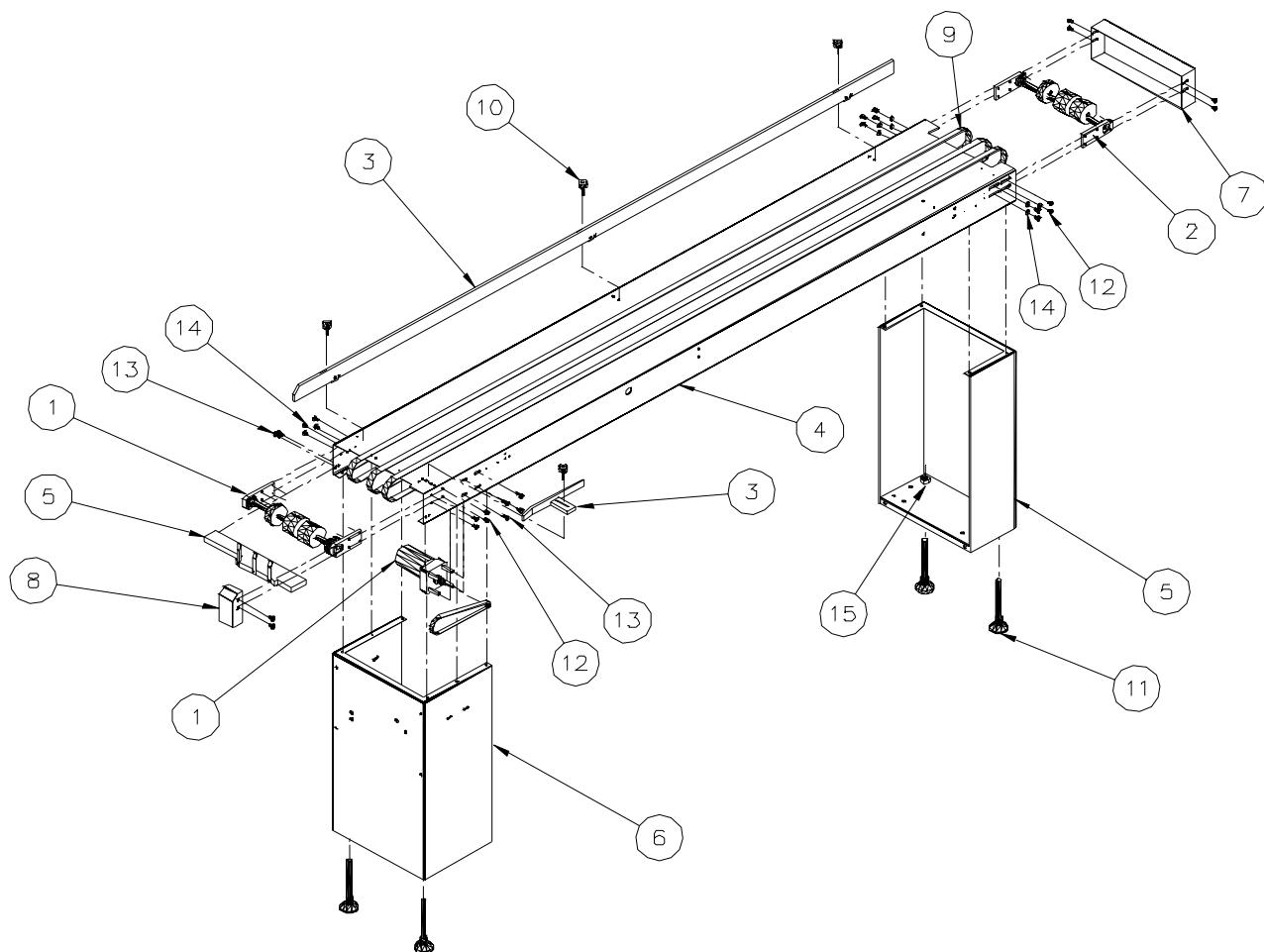
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INFEED CONVEYOR ASSEMBLY (Fig. 3-1)

ITEM	PART NO.	QTY.	DESCRIPTION
1	(SEE FIG. 3-2)	1	DRIVE SHAFT / MOTOR ASSEMBLY
2	(SEE FIG. 3-3)	1	IDLER SHAFT ASSEMBLY
3	(SEE FIG. 3-4)	1	SIDE GUIDE / PAPER GUIDE ASSEMBLY
4	12000-007	1	SIDE FRAME, 9' CONVEYOR
5	12010-001	1	LEG, IDLE, 36"
6	12010-002	1	LRG, DRIVE, 36"
7	12011-006	1	END CAP, IDLE
8	12011-009	1	END CAP, DRIVE
9	99000-053	3	BELT, ENDLESS, 18'- 1" X 1" W
10	99004-011	4	KNOB, MALE, 10-32 X 3/4
11	99010-001	4	FOOT, ADJUSTING
12		22	SCREW, BUTTON HD, 1/4-20 X 1/2
13		6	SCREW, BUTTON HD, 1/4-20 X 3/4
14		8	WASHER, FLAT, 1/4
15		4	NUT, HEX HD, 5/8-11

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FIG. 3-1



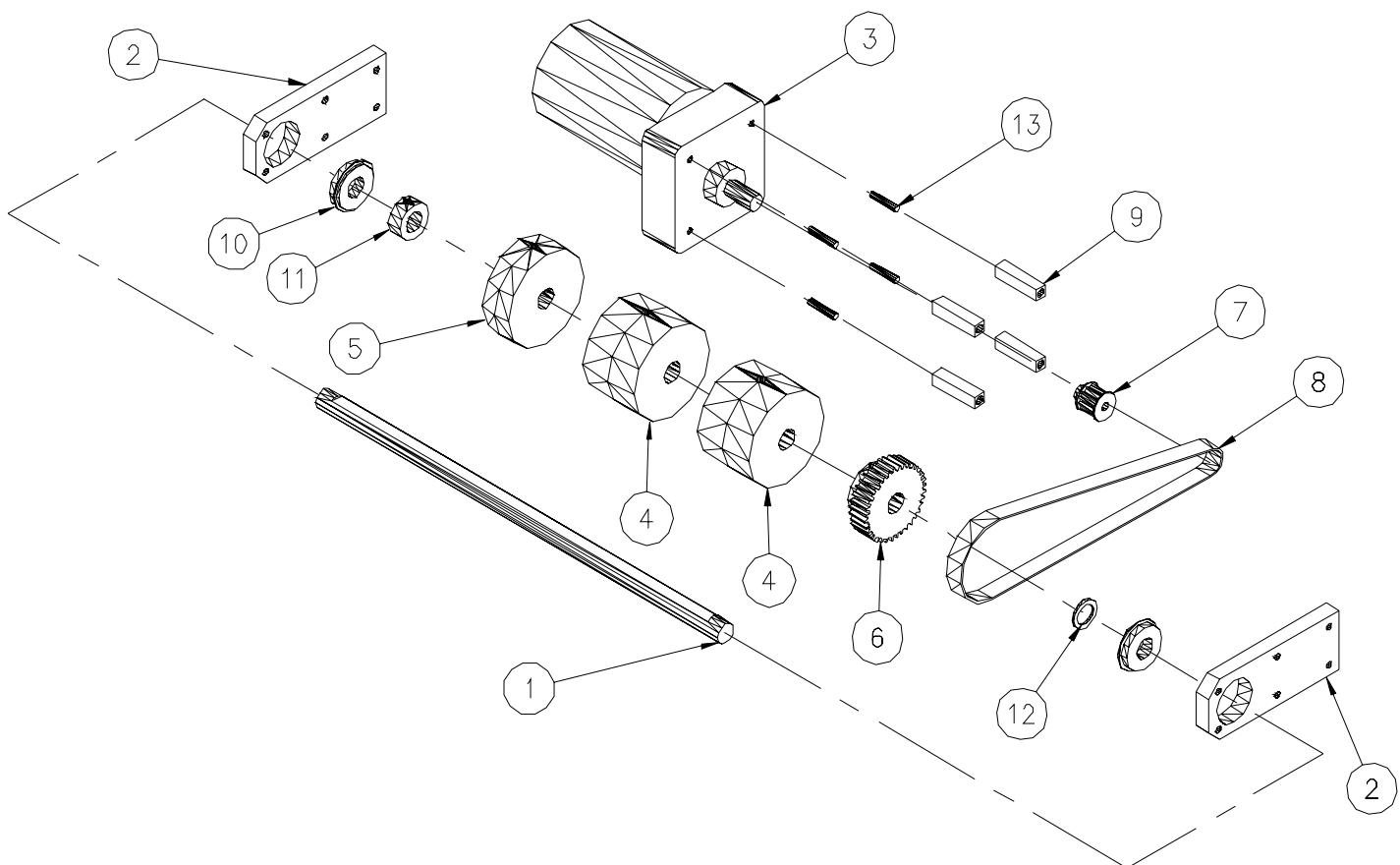
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INFEED CONVEYOR (Fig. 3-2)
DRIVE SHAFT/ MOTOR ASSEMBLY

ITEM	PART NO.	QTY.	DESCRIPTION
1	12004-003	1	SHAFT, DRIVE, CONVEYOR
2	12007-001	2	BLOCK, BEARING
3	99001-008	1	MOTOR, 11 RPM
4	12006-002	2	PULLEY, CROWNED, 2" WIDE
5	12006-001	1	PULLEY, CROWNED, 1" WIDE
6	99002-033	1	PULLEY, 36XL037
7	99002-008	1	PULLEY, 12XL037
8	99000-030	1	BELT, 220XL037
9	12012-001	4	STANDOFF, MOTOR
10	99003-006	2	BEARING, SEALED, 5/8 X 1-3/8
11	99017-005	1	COLLAR, SET, 5/8
12	99003-021	1	WASHER, NYLON, 5/8 X 1/16
13		4	SCREW, SET, 10-32 X 1

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FIG. 3-2



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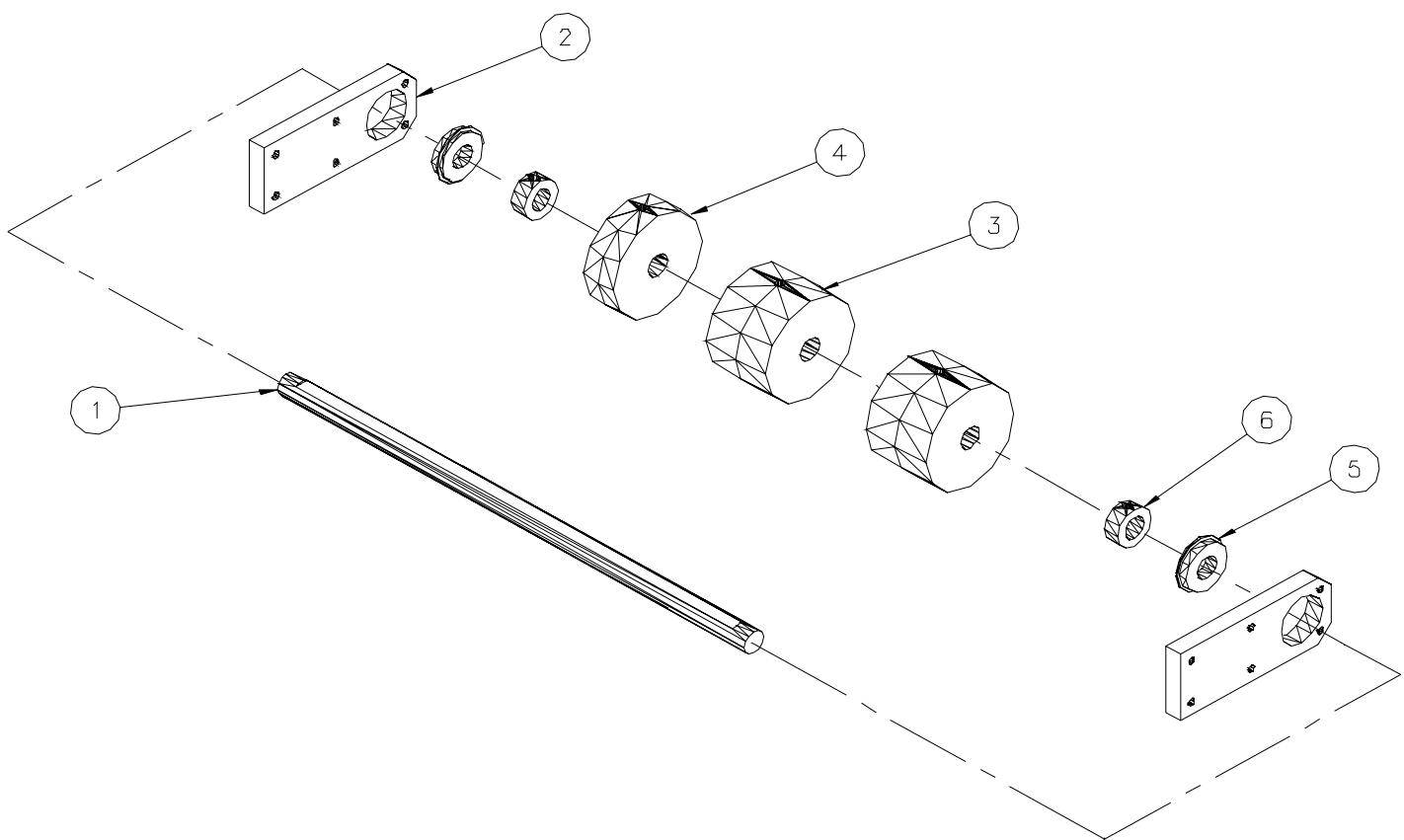
**INFEED CONVEYOR (Fig. 3-3)
IDLER SHAFT ASSEMBLY**

ITEM	PART NO.	QTY.	DESCRIPTION
1	12004-003	1	SHAFT, DRIVE, CONVEYOR
2	12007-001	2	BLOCK, BEARING
3	12006-002	2	PULLEY, CROWNED, 2" WIDE
4	12006-001	1	PULLEY, CROWNED, 1" WIDE
5	99003-006	2	BEARING, SEALED, 5/8 X 1-3/8
6	99017-005	2	COLLAR, SET, 5/8

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FIG. 3-3



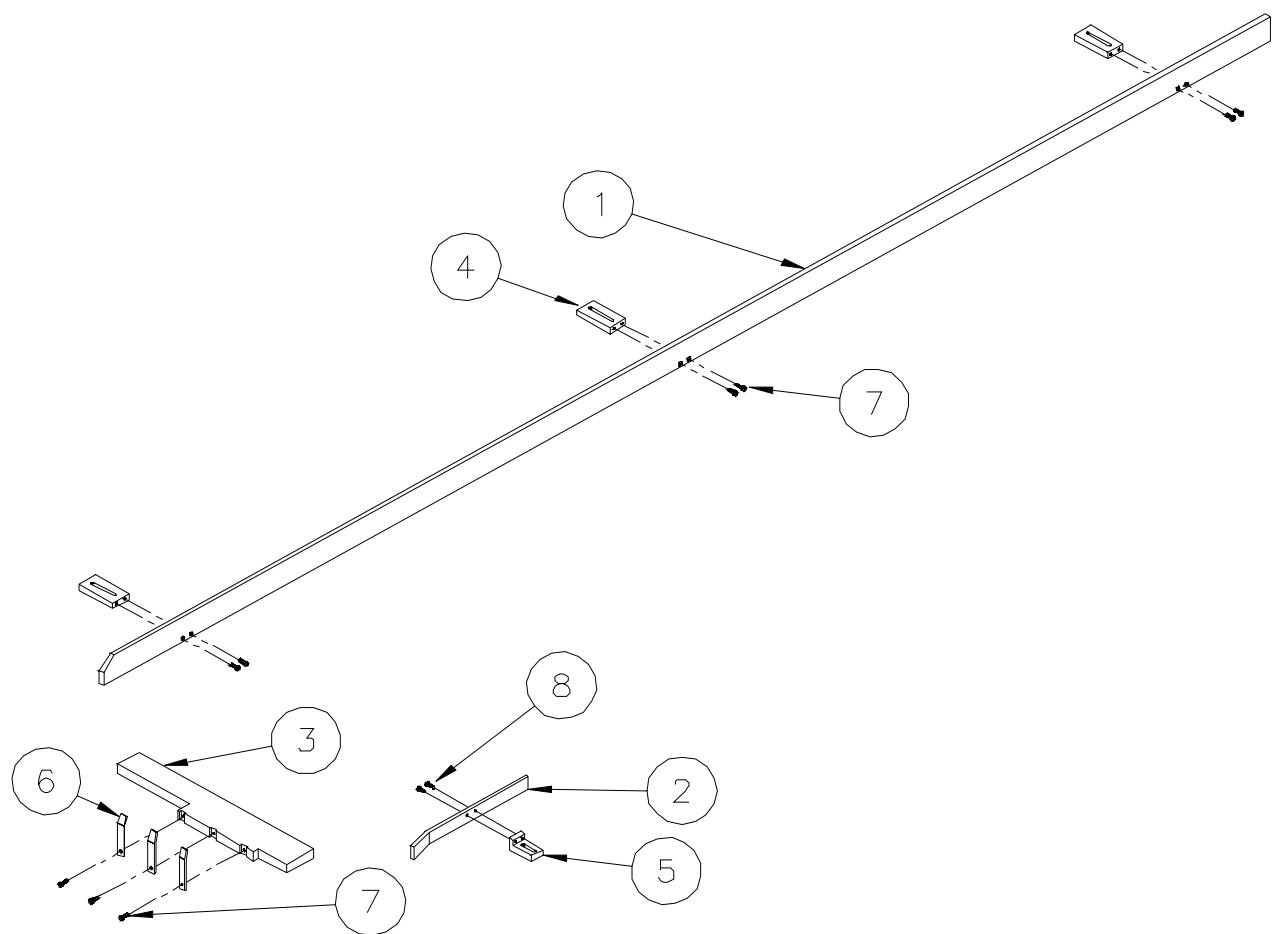
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INFEED CONVEYOR (Fig. 3-4)
SIDE GUIDE / PAPER GUIDE ASSEMBLY

ITEM	PART NO.	QTY.	DESCRIPTION
1	18005-029	1	GUIDE, RH SIDE, ENVELOPE CONVEYOR
2	12005-010	1	GUIDE, SIDE, LH
3	18008-023	1	BAR, REAR ENVELOPE GUIDE MTG.
4	18008-031	3	BAR, RH SIDE GUIDE MTG.
5	12007-008	1	BLOCK, SIDE GUIDE MTG.
6	18005-017	3	GUIDE, REAR ENVELOPE
7		9	SCREW, SKT HD, 10-24 X 1/2
8		2	SCREW, FLAT HD, 10-24 X 1/2

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FIG. 3-4

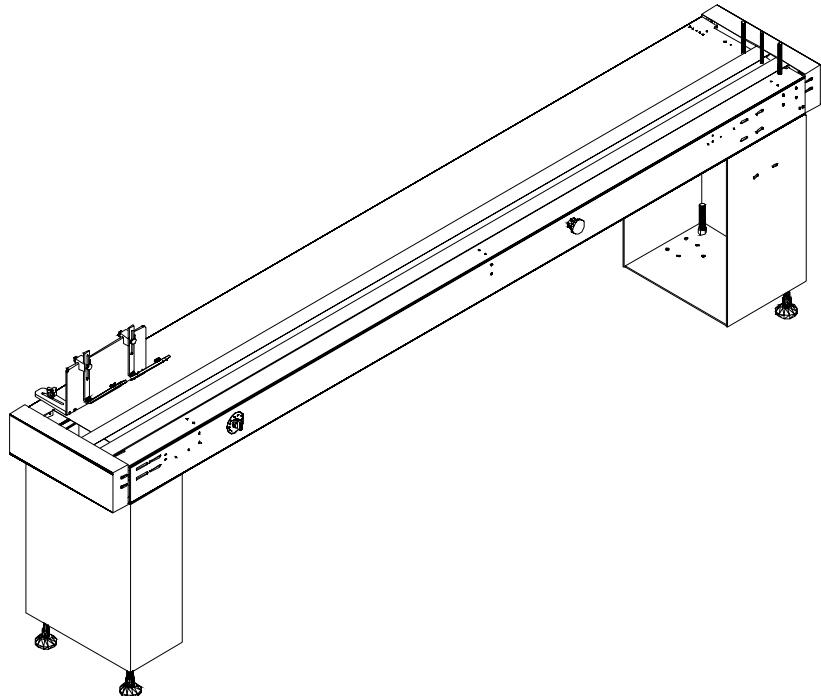


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SHINGLE CONVEYOR

6 X 9



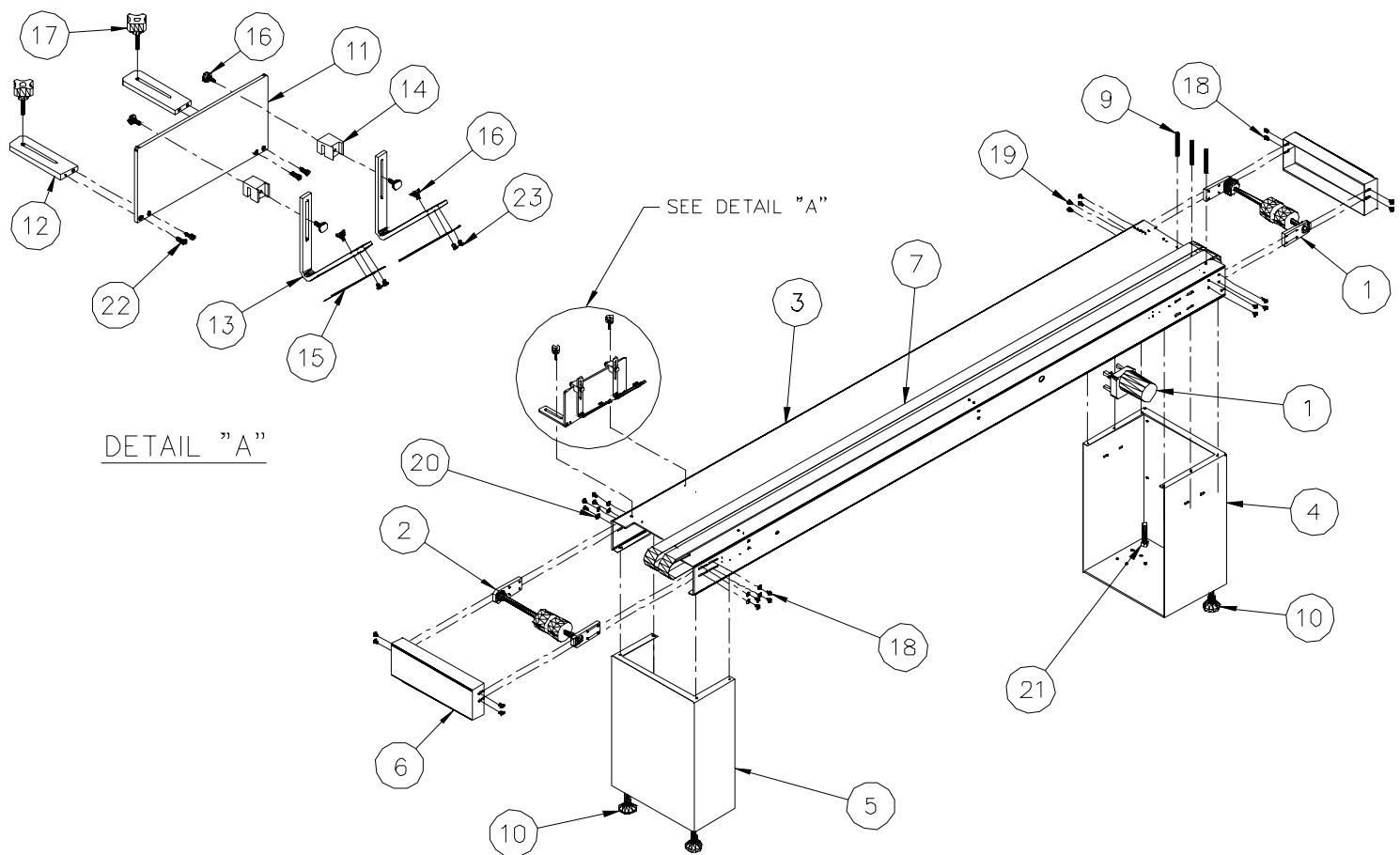
**Sure-Feed
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SHINGLE CONVEYOR ASSEMBLY (Fig. 4-1)

ITEM	PART NO.	QTY.	DESCRIPTION
1	(SEE FIG. 4-2)	1	DRIVE SHAFT / MOTOR ASSEMBLY
2	(SEE FIG. 4-3)	1	IDLER SHAFT ASSEMBLY
3	12000-007	1	SIDE FRAME, 9' CONVEYOR
4	12010-004	1	LEG, DRIVE, 30"
5	12010-003	1	LEG, IDLE, 30"
6	12011-006	2	END CAP, IDLE
7	99000-052	3	BELT, ENDLESS, 18'- 1" X 2" W
9	12004-008	3	SHAFT, STOP
10	99010-001	4	FOOT, ADJUSTING
11	12011-007	1	PLATE, KNOCK DOWN
12	12007-006	2	BAR, PLATE MTG.
13	12008-001	2	BRACKET, KNOCK DOWN
14	12007-007	2	BRACKET, KNOCK DOWN MTG.
15	12005-007	2	STRAP, KNOCK DOWN
16	99004-002	6	KNOB, #10 SCREW
17	99004-011	2	KNOB, MALE, 10-32 X 3/4
18		24	SCREW, BUTTON HD, 1/4-20 X 1/2
19		4	SCREW, BUTTON HD, 1/4-20 X 3/4
20		12	WASHER, FLAT, 1/4
21		4	NUT, HEX, 5/8-11
22		4	SCREW, SKT HD, 10-24 X 1/2
23		4	SCREW, BUT HD, 10-24 X 1/4

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FIG. 4-1



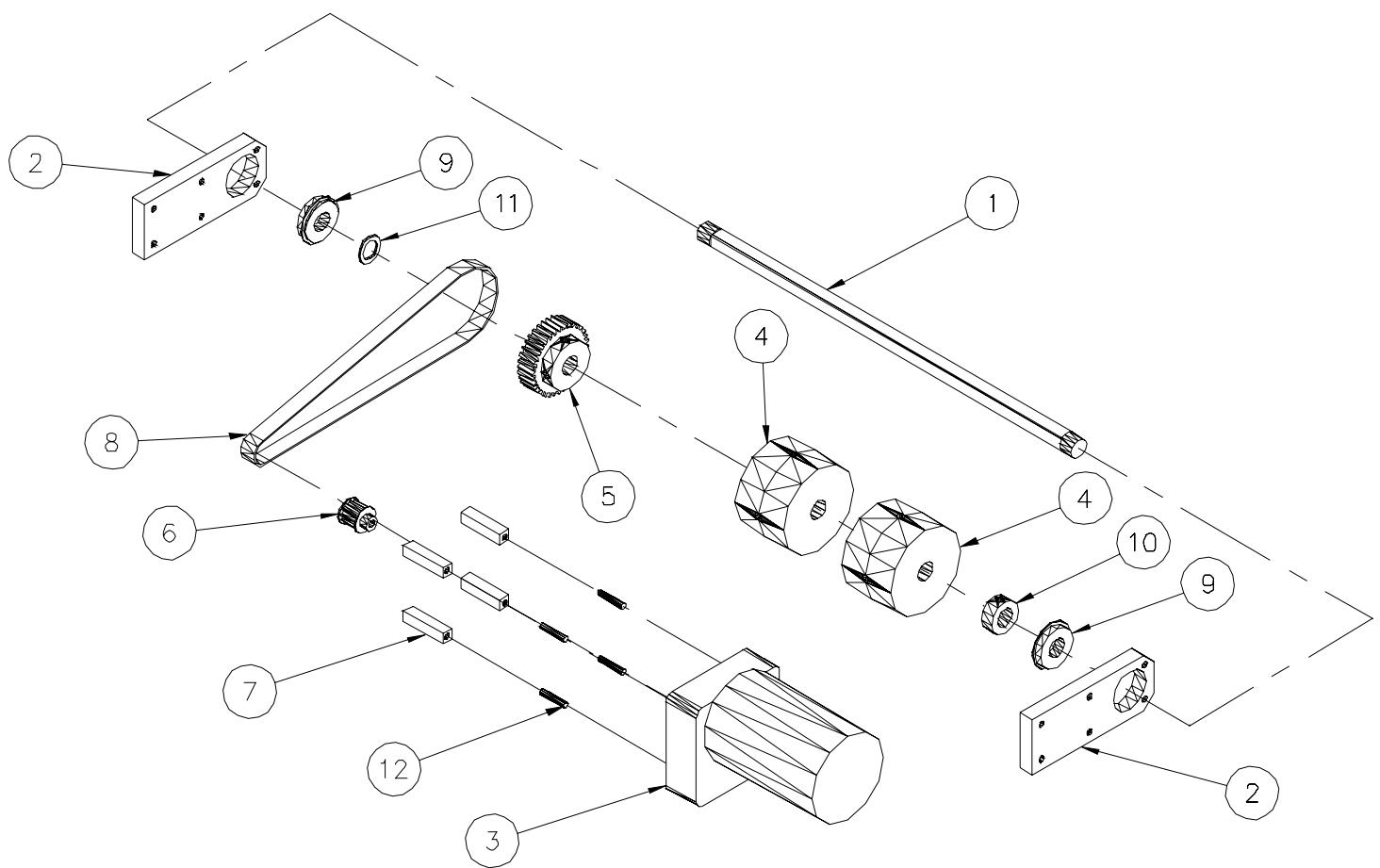
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SHINGLE CONVEYOR (Fig. 4-2)
DRIVE SHAFT / MOTOR ASSEMBLY

ITEM	PART NO.	QTY.	DESCRIPTION
1	12004-003	1	SHAFT, DRIVE, CONVEYOR
2	12007-001	2	BLOCK, BEARING
3	99001-009	1	MOTOR, 32 RPM
4	12006-002	2	PULLEY, CROWNED, 2" WIDE
5	99002-033	1	PULLEY, 36XL037
6	99002-008	1	PULLEY, 12XL037
7	12012-001	4	STANDOFF, MOTOR
8	99000-030	1	BELT, 220XL037
9	99003-006	2	BEARING, SEALED, 5/8 X 1-3/8
10	99017-005	1	COLLAR, SET, 5/8
11	99003-021	1	WASHER, NYLON, 5/8 X 1/16
12		4	SCREW, SET, 10-32 X 1

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FIG. 4-2



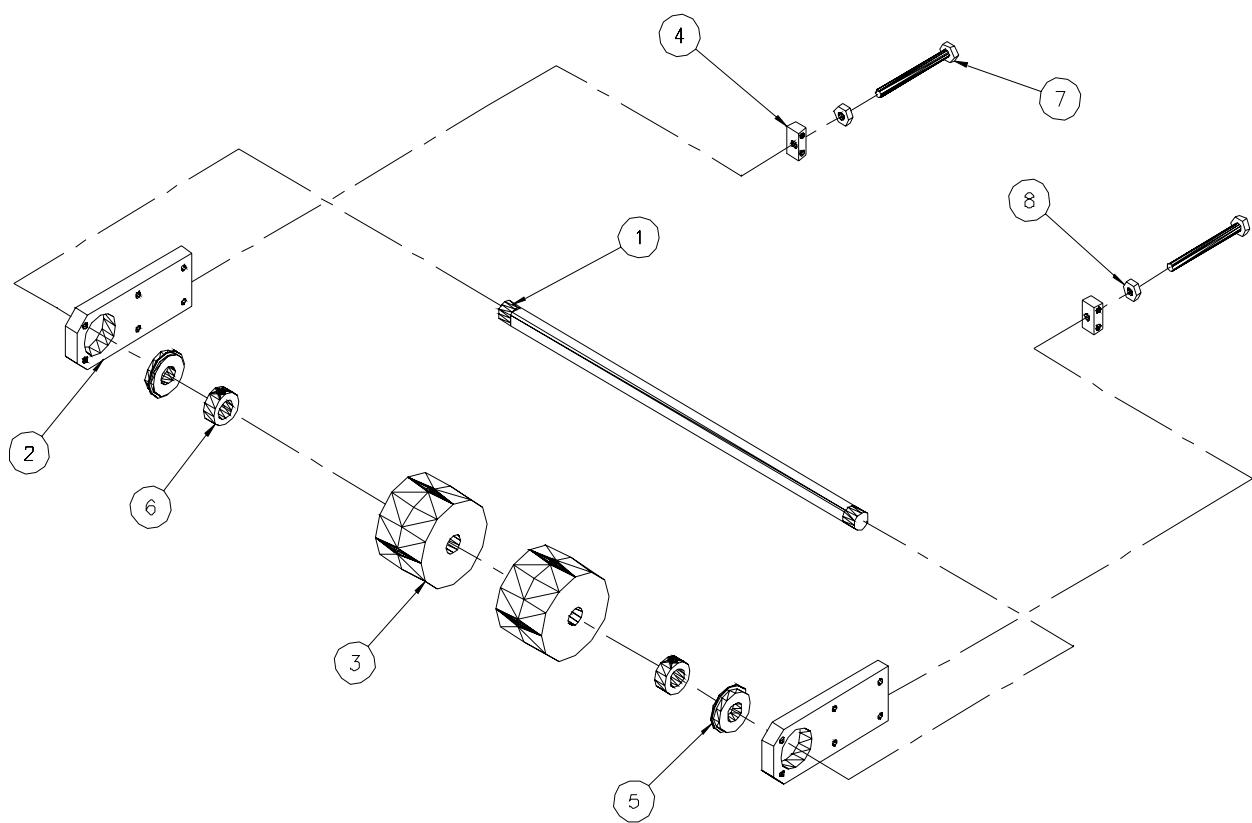
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SHINGLE CONVEYOR (Fig. 4-3)
IDLER SHAFT ASSEMBLY

ITEM	PART NO.	QTY.	DESCRIPTION
1	12004-003	1	SHAFT, DRIVE, CONVEYOR
2	12007-001	2	BLOCK, BEARING
3	12006-002	2	PULLEY, CROWNED, 2" WIDE
4	12007-002	2	BLOCK, TENSIONER
5	99003-006	2	BEARING, SEALED, 5/8 X 1-3/8
6	99017-005	2	COLLAR, SET, 5/8
7		2	SCREW, HEX HD, 1/4-20 X 3 (ALL THREAD)
8		2	NUT, HEX, 1/4-20

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FIG. 4-3

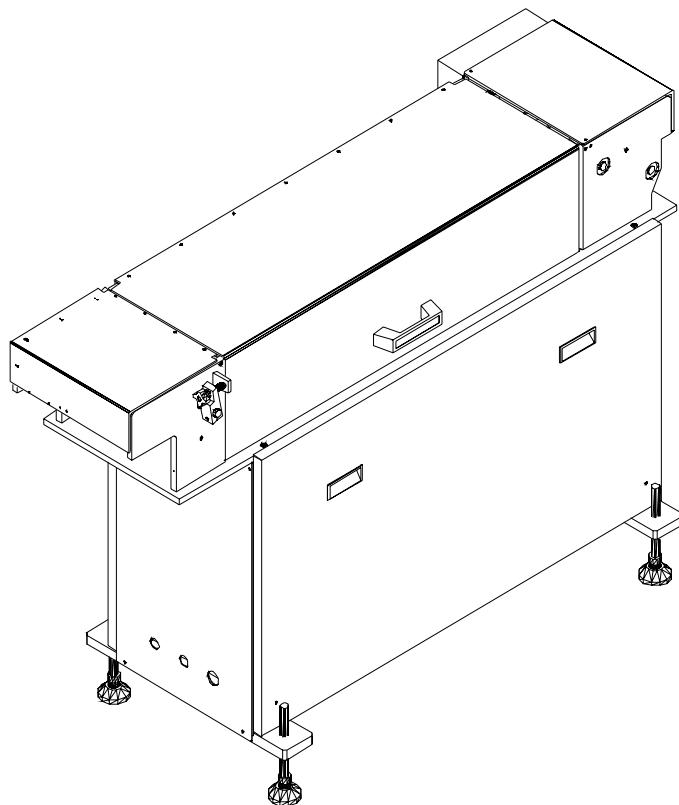


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TURNOVER

6 X 9



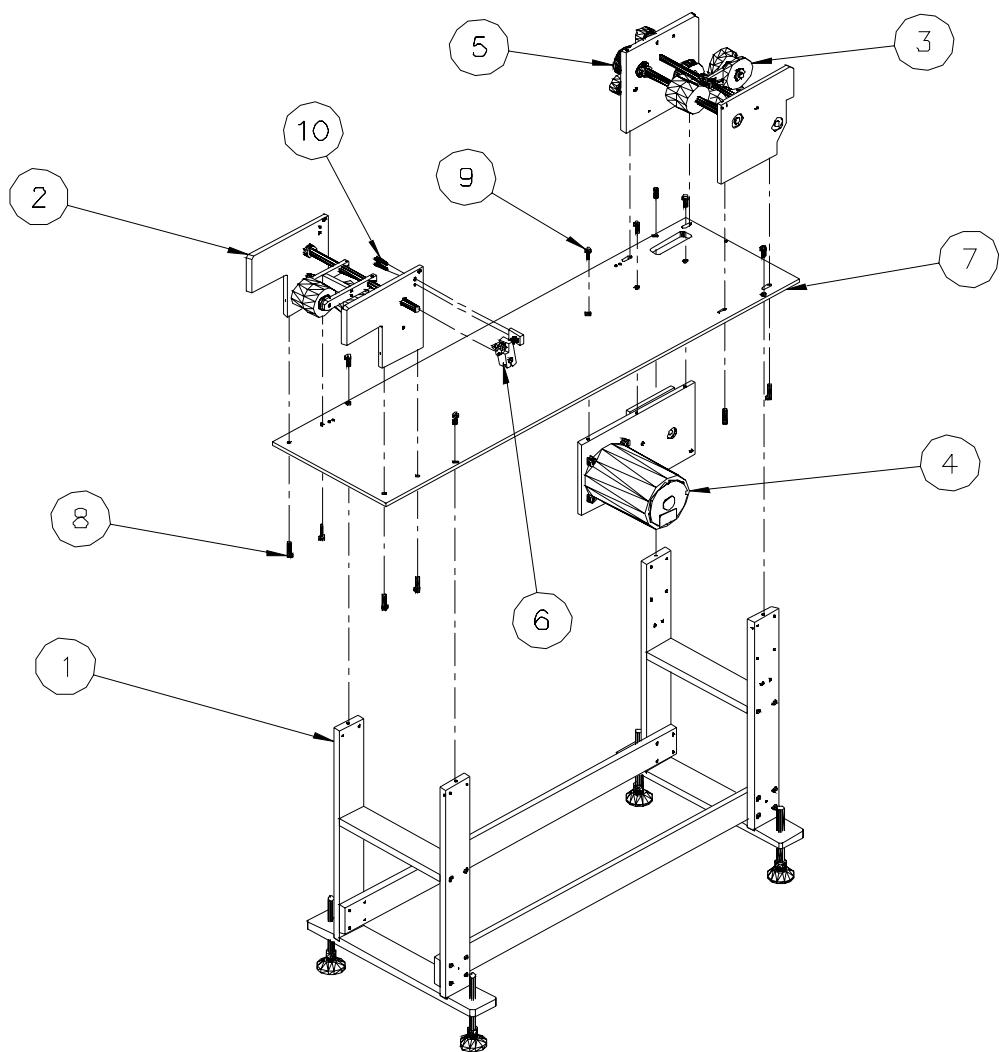
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TURNOVER ASSEMBLY (Fig. 5-1)

ITEM	PART NO.	QTY.	DESCRIPTION
1	(SEE FIG. 5-2)	1	FRAME, TURNOVER
2	(SEE FIG. 5-3)	1	INFEED ASSEMBLY
3	(SEE FIG. 5-4)	1	DISCHARGE ASSEMBLY
4	(SEE FIG. 5-5)	1	MOTOR / MOTOR MOUNT ASSEMBLY
5	(SEE FIG. 5-6)	1	DRIVE ASSEMBLY
6	(SEE FIG. 5-7)	1	SEPERATOR ADJUSTER ASSEMBLY
7	20001-001	1	PLATE, DECK
8		8	SCREW, SKT HD, 5/16-18 X 1-1/4
9		7	SCREW, SKT HD, 5/16-18 X 3/4
10		2	SCREW, SKT HD, 1/4-20 X 1
11	99000-038	1	BELT, TURNOVER, 91.645 (NOT SHOWN)
12	99000-039	1	BELT, TURNOVER, 111.601 (NOT SHOWN)
13	(SEE FIG. 5-8)	1	COVER ASSEMBLY, TURNOVER (NOT SHOWN)

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FIG. 5-1



NOTE: ITEM 11, TURNOVER BELT (91.645) NOT SHOWN
ITEM 12, TURNOVER BELT (111.601) NOT SHOWN

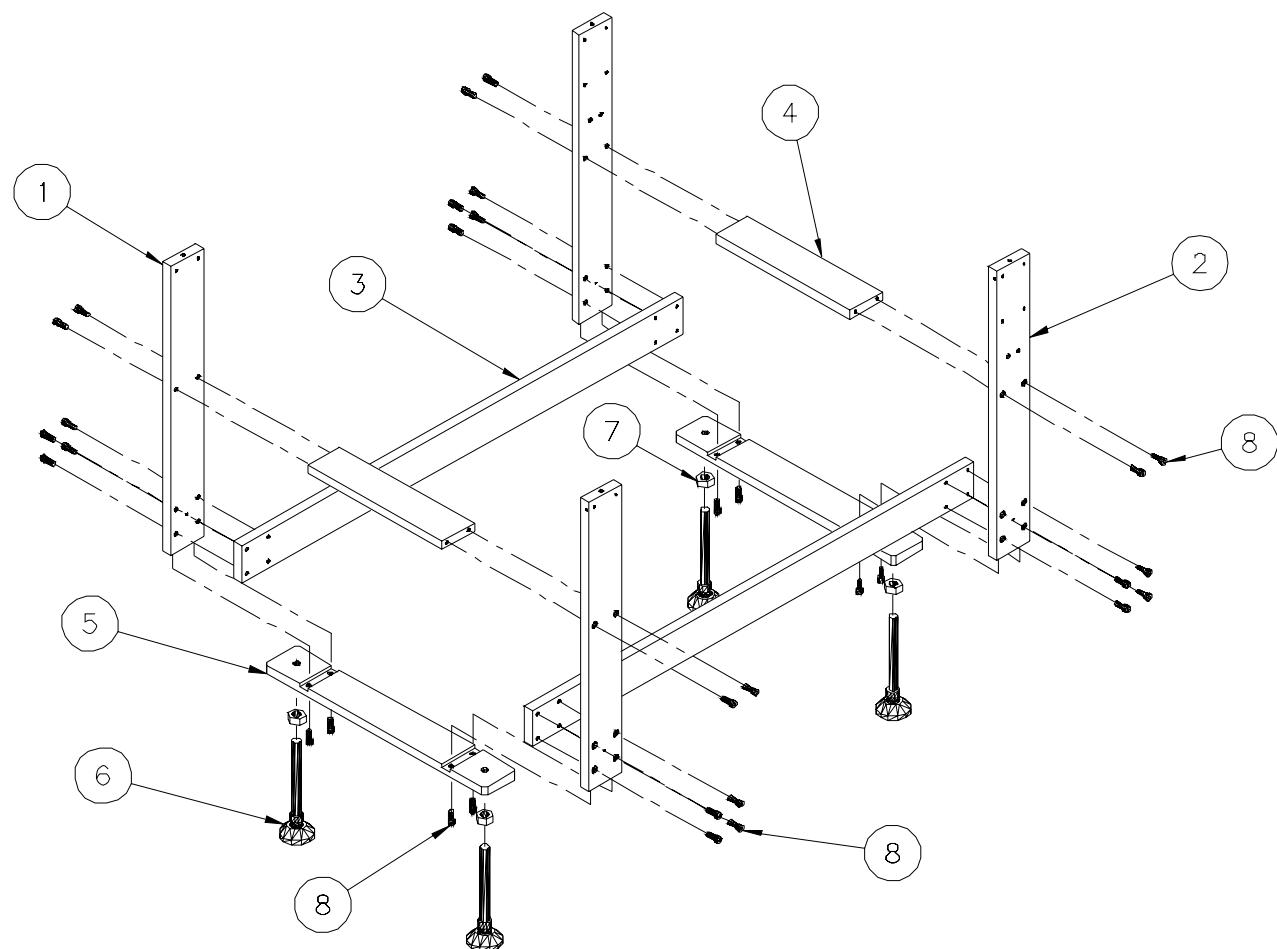
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TURNOVER (Fig. 5-2)
FRAME ASSEMBLY

ITEM	PART NO.	QTY.	DESCRIPTION
1	20010-002	2	LEG, INFEED, TURNOVER
2	20010-001	2	LEG, DISCHARGE, TURNOVER
3	20003-003	2	CROSSBAR, SIDE, TURNOVER
4	20003-002	2	CROSSBAR, UPPER, TURNOVER
5	20003-001	2	CROSSBAR, LOWER, TURNOVER
6	99010-001	4	FOOT, ADJUSTING
7		4	NUT, HEX, 5/8-11
8		32	SCREW, SKT HD, 5/16-18 X 1

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FIG. 5-2



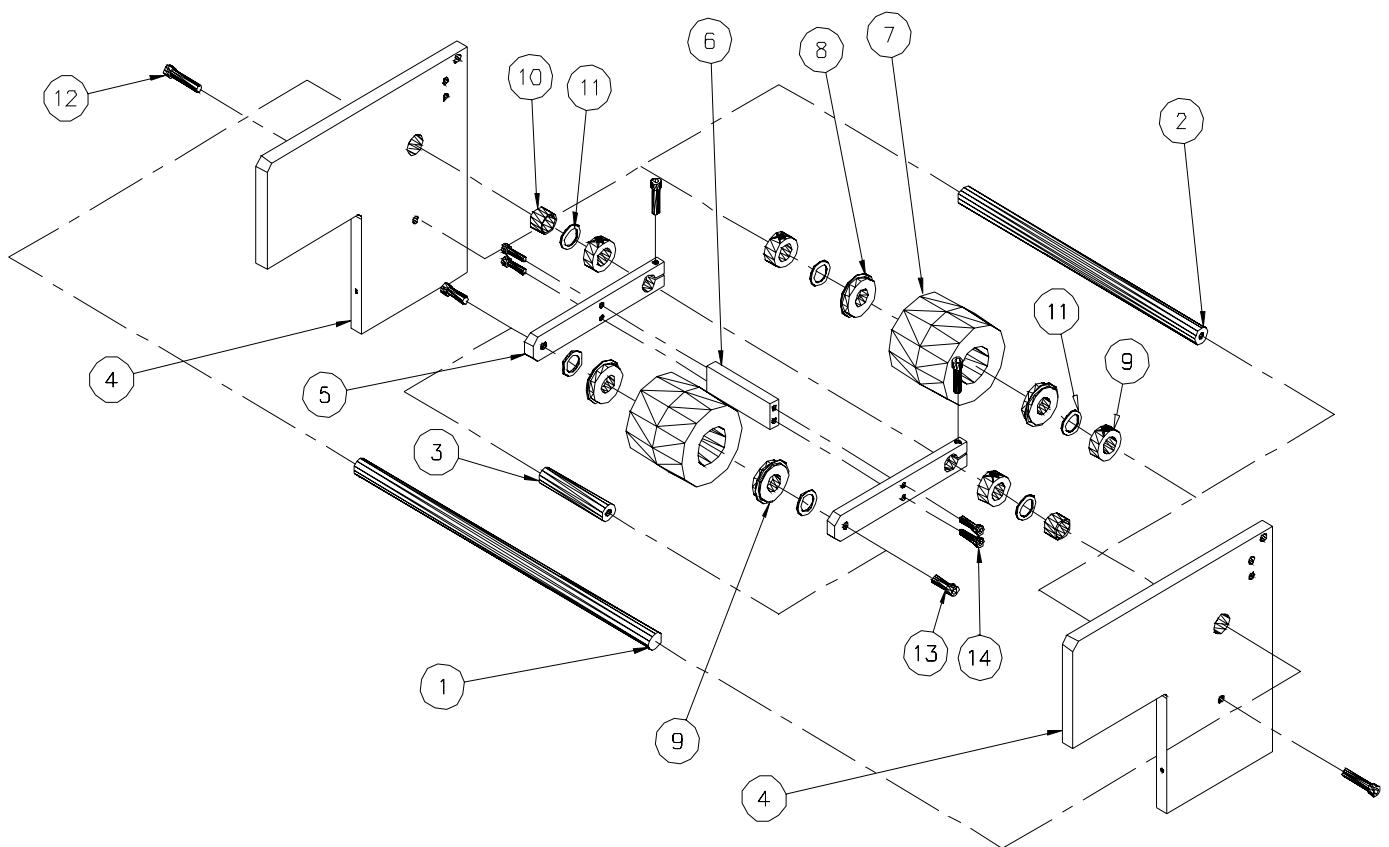
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TURNOVER (Fig. 5-3)
INFEED ASSEMBLY

ITEM	PART NO.	QTY.	DESCRIPTION
1	20004-003	1	SHAFT, IDLER PIVOT
2	20004-002	1	SHAFT, IDLER (LONG)
3	20004-001	1	SHAFT, IDLER (SHORT)
4	20000-001	2	SIDEPLATE, INFEED
5	20008-001	2	BAR, IDLER ROLLER MTG.
6	20012-002	1	SPACER, IDLER ROLLER
7	20006-001	2	ROLLER, CROWNED (IDLER)
8	99003-006	4	BEARING, SEALED, 5/8 X 1-3/8
9	99017-005	4	COLLAR, SET, 5/8
10	99003-029	2	BUSHING, 5/8 X 3/4 X 1/2
11	99003-021	6	WASHER, NYLON, 5/8 X 1/16
12		4	SCREW, SKT HD, 1/4-20 X 1
13		2	SCREW, SKT HD, 1/4-20 X 3/4
14		4	SCREW, SKT HD, 10-24 X 3/4

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FIG. 5-3



Sure-Feed
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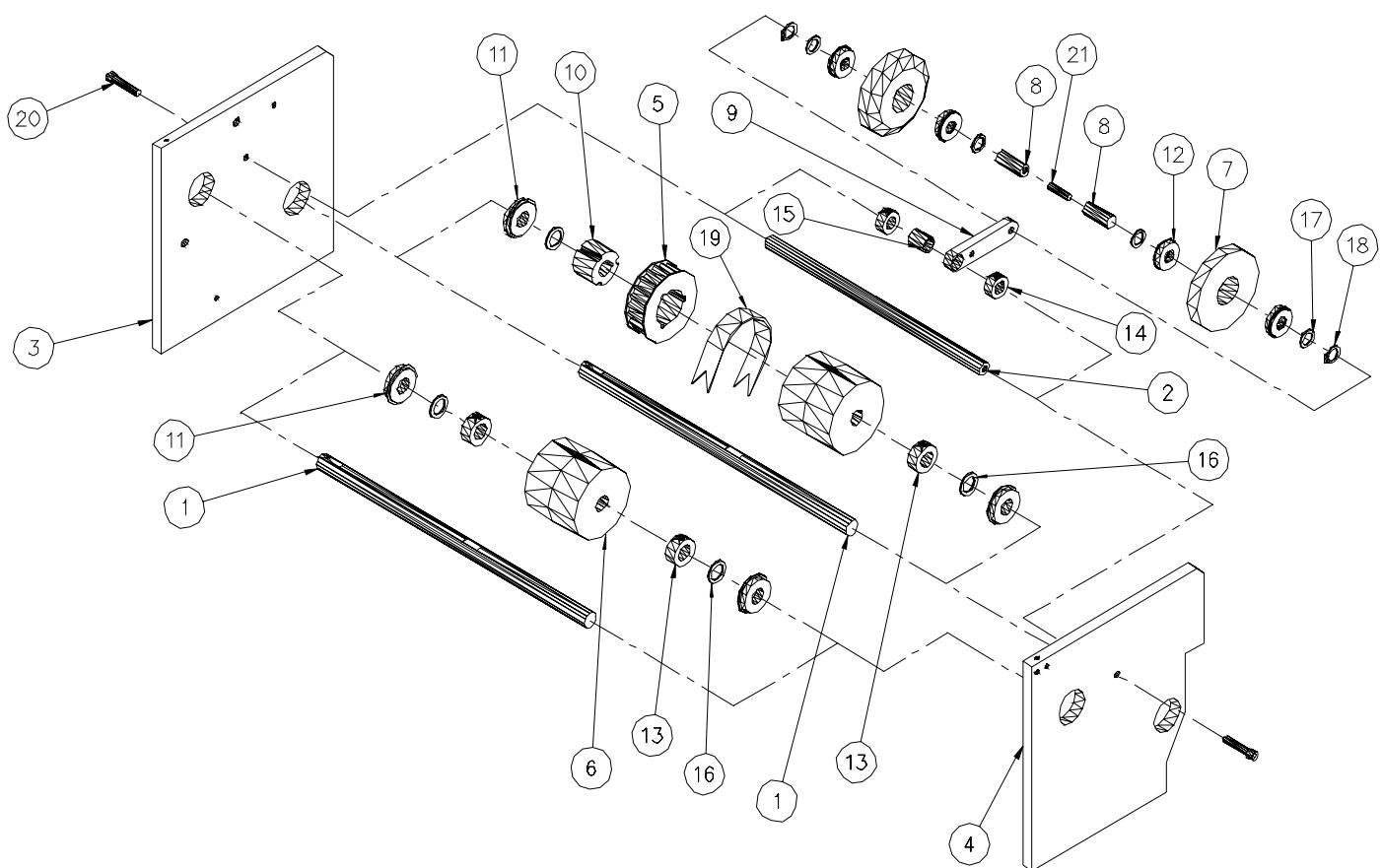
**TURNOVER (Fig. 5-4)
DISCHARGE ASSEMBLY**

ITEM	PART NO.	QTY.	DESCRIPTION
1	20004-007	2	SHAFT, DRIVE
2	20004-004	1	SHAFT, NIP PIVOT
3	20000-003	1	SIDEPLATE, DISCHARGE, LH
4	20000-002	1	SIDEPLATE, DISCHARGE, RH
5	99002-035	1	PULLEY, TL22L075, 1008
6	20006-002	2	PULLEY, CROWNED (DRIVE)
7	20006-003	2	ROLLER, EXIT
8	20004-005	2	SHAFT, EXIT ROLLER
9	20008-002	1	BAR, EXIT, ROLLER MTG.
10	99017-019	1	BUSHING, TAPERLOCK 1008, 5/8 BORE
11	99003-006	4	BEARING, SEALED, 5/8 X 1-3/8
12	99003-007	4	BEARING, SEALED, 1/2 X 1-1/8
13	99017-005	3	COLLAR, SET, 5/8
14	99017-004	2	COLLAR, SET, 1/2
15	99003-038	1	BUSHING, 1/2 X 5/8 X 3/4
16	99003-021	4	WASHER, NYLON, 5/8 X 1/16
17	99003-018	4	WASHER, NYLON, 1/2 X 1/16
18	99022-004	2	SNAP RING, 1/2
19	99000-028	1	BELT, 255L075
20		2	SCREW, SKT HD, 1/4-20 X 1
21		1	SCREW, SET, 1/4-20 X 1

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FIG. 5-4



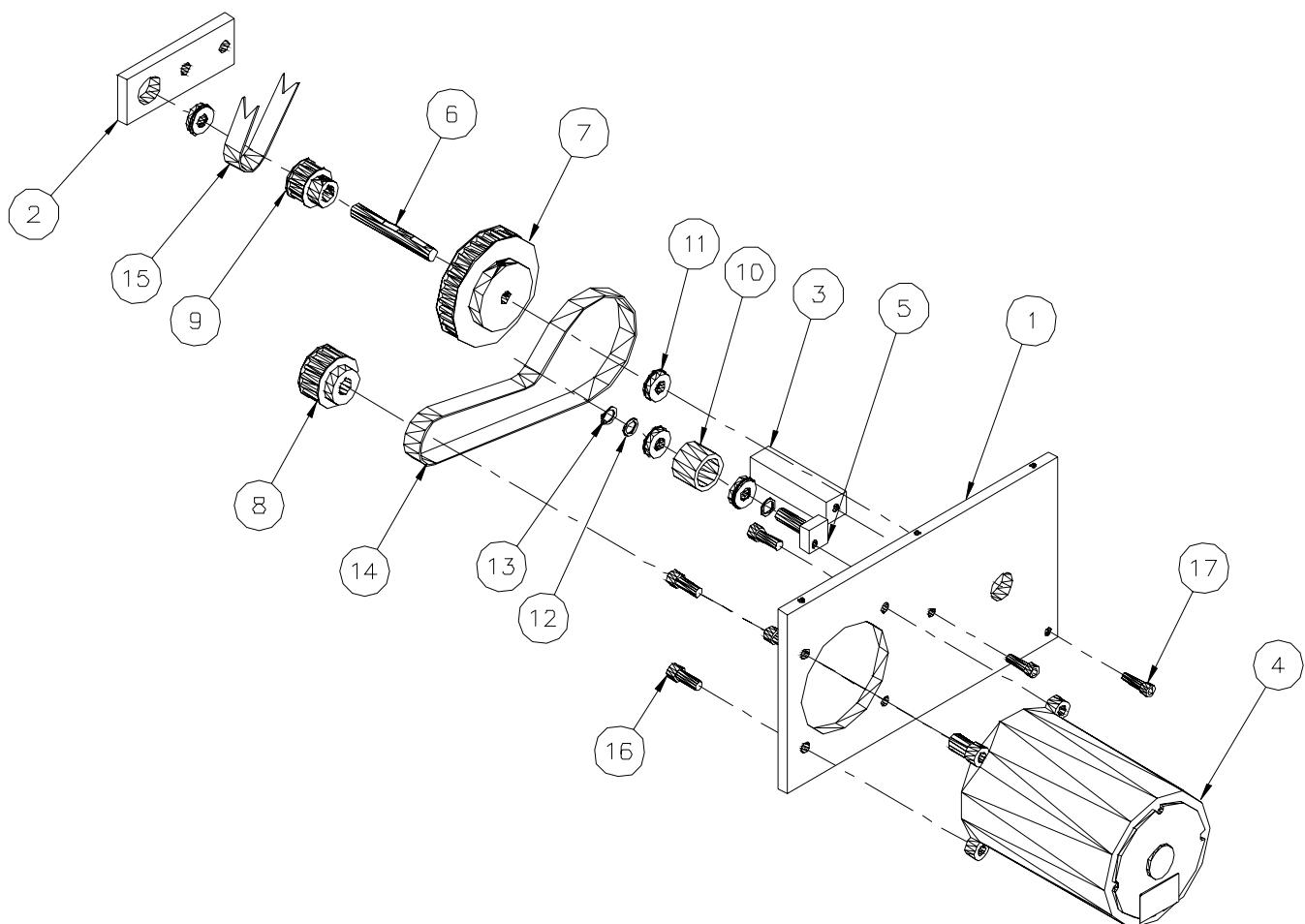
Sure-Feed
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TURNOVER (Fig. 5-5)
MOTOR / MOTOR MOUNT ASSEMBLY

ITEM	PART NO.	QTY.	DESCRIPTION
1	20011-001	1	PLATE, MOTOR MOUNT
2	20011-002	1	PLATE, INTERMEDIATE SHAFT
3	20012-004	1	STANDOFF, MOTOR SUPPORT
4	99001-004	1	MOTOR, 1/4 HP
5	18004-022	1	TENSIONER, ECCENTRIC
6	20004-008	1	SHAFT, INTERMEDIATE
7	99002-019	1	PULLEY, 36L075, 1/2 BORE
8	99002-036	1	PULLEY, 16L075, 5/8 BORE
9	99002-018	1	PULLEY, 12L075, 1/2 BORE
10	18006-012	1	ROLLER, TENSIONER
11	99003-007	4	BEARING, SEALED W/ SNAP RING, 1/2 X 1-1/8
12	99003-018	2	WASHER, NYLON, 1/2 X 1/16
13	99022-004	1	SNAP RING, 1/2
14	90000-035	1	BELT, 270L075
15	90000-028	1	BELT, 255L075
16		4	SCREW, SKT HD, 3/8-16 X 1
17		2	SCREW, SKT HD, 5/16-18 X 1

**Sure-Feed
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FIG. 5-5



Sure-Feed
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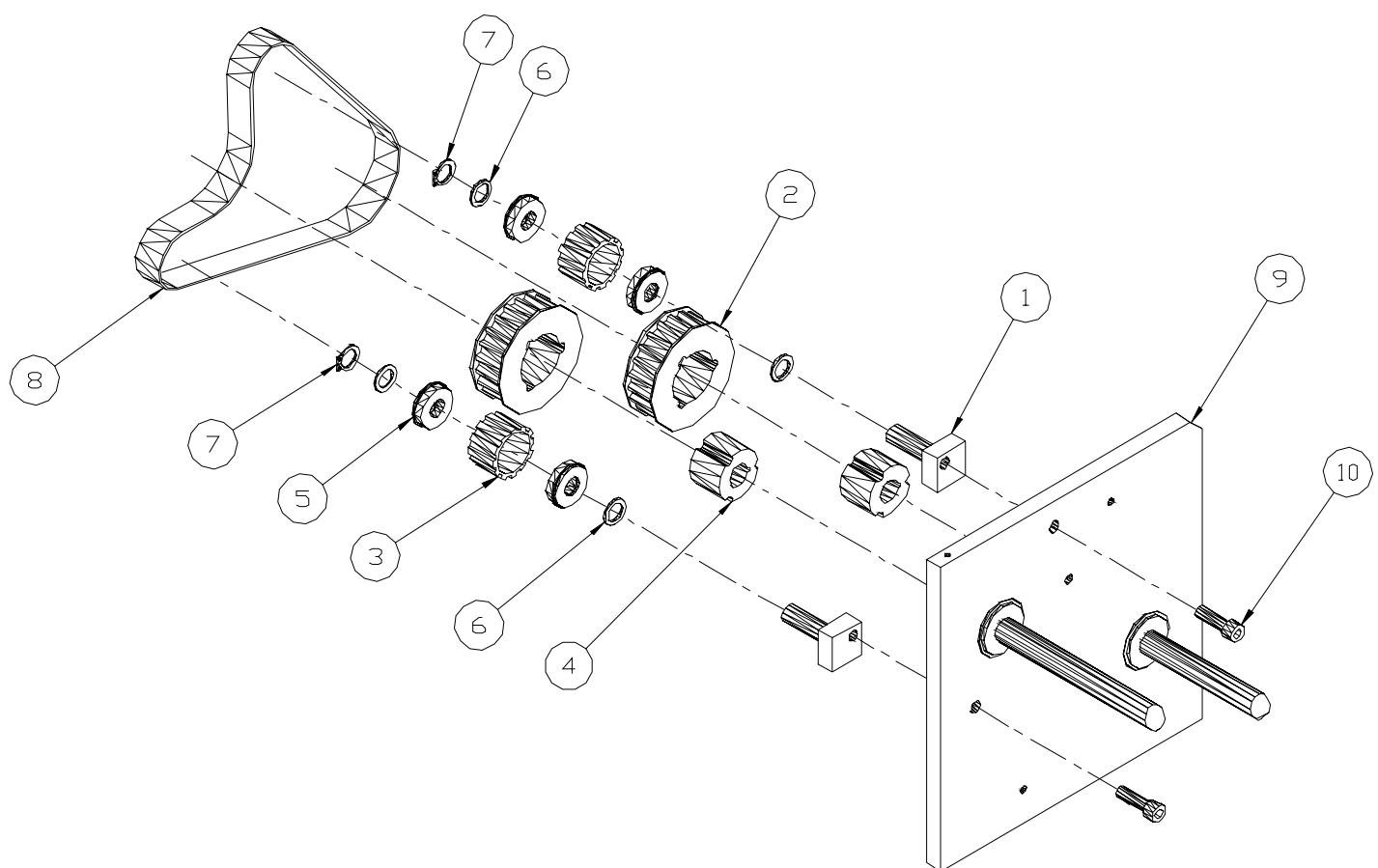
TURNOVER (Fig. 5-6)
DRIVE ASSEMBLY

ITEM	PART NO.	QTY.	DESCRIPTION
1	18004-022	2	TENSIONER, ECCENTRIC
2	99002-035	2	PULLEY, TL22L075 1008
3	20006-004	2	PULLEY, IDLER, 12L075
4	99017-019	2	BUSHING, TAPERLOCK, 1008, 5/8 BORE
5	99003-007	4	BEARING, SEALED W/ SNAP RING, 1/2 X 1-1/8
6	99003-018	4	WASHER, NYLON, 1/2 X 1/16
7	99022-004	2	SNAP RING, 1/2
8	99000-034	1	BELT, D240L075
9	20000-003	1	SIDEPLATE, DISCHARGE, LH (REF. ONLY)
10		2	SCREW, SKT HD, 5/16-18 X 1

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FIG. 5-6



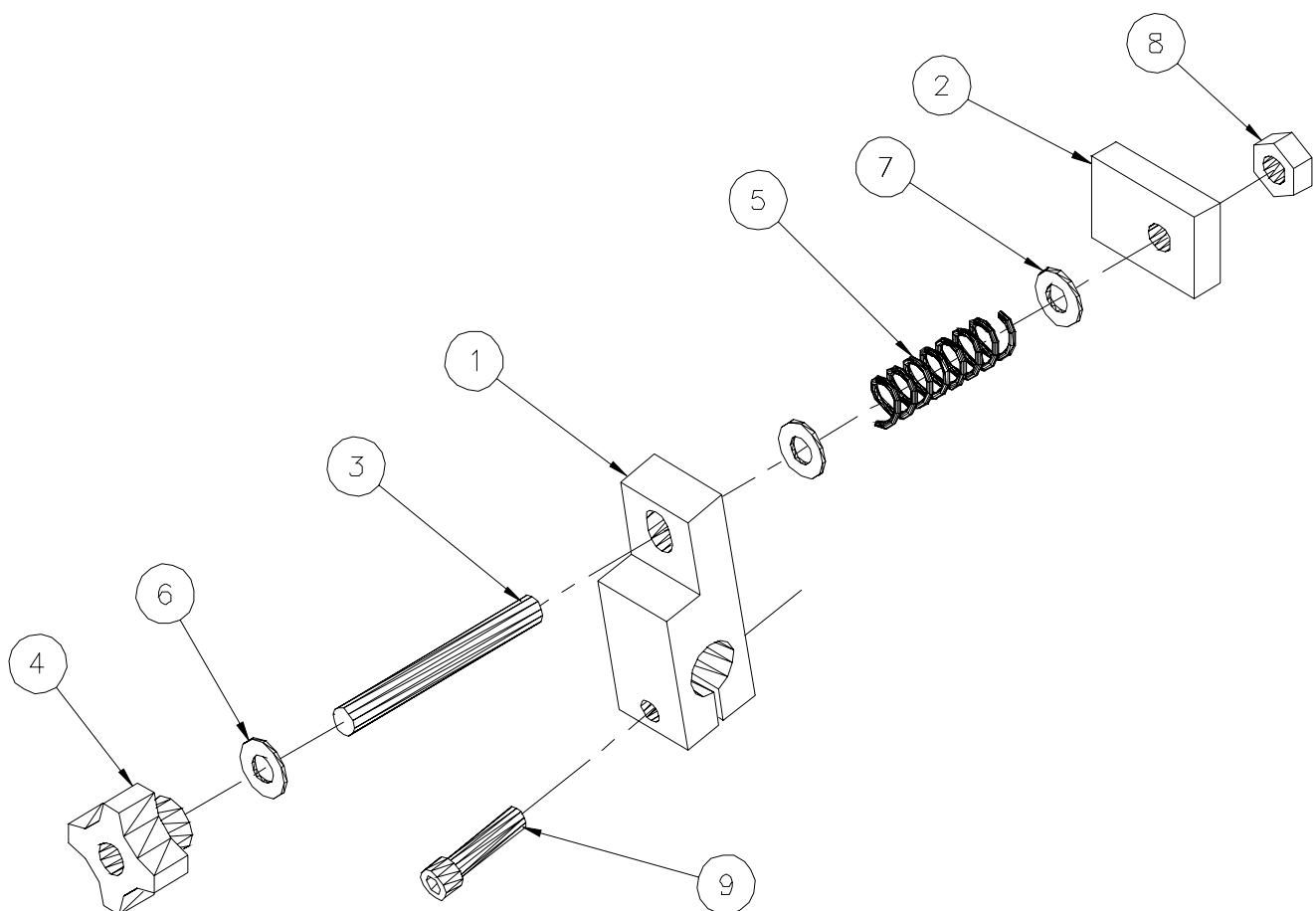
Sure-Feed
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TURNOVER (Fig. 5-7)
SEPERATOR ADJUSTING ASSEMBLY

ITEM	PART NO.	QTY.	DESCRIPTION
1	20007-002	1	BLOCK, SHAFT CLAMP
2	20007-001	1	BLOCK, SHAFT ADJUSTING
3	10004-028	1	STUD, SEPERATOR ADJUSTING
4	99004-001	1	KNOB, FEMALE, 5/16-24
5	10019-001	1	SPRING, SEPERATOR (ROTATING)
6	99003-015	1	WASHER, NYLON, 5/16 X 1/16
7		2	WASHER, FLAT, 5/16
8		1	NUT, HEX HD, 5/16-24
9		1	SCREW, SKT HD, 1/4-20 X 1

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FIG. 5-7



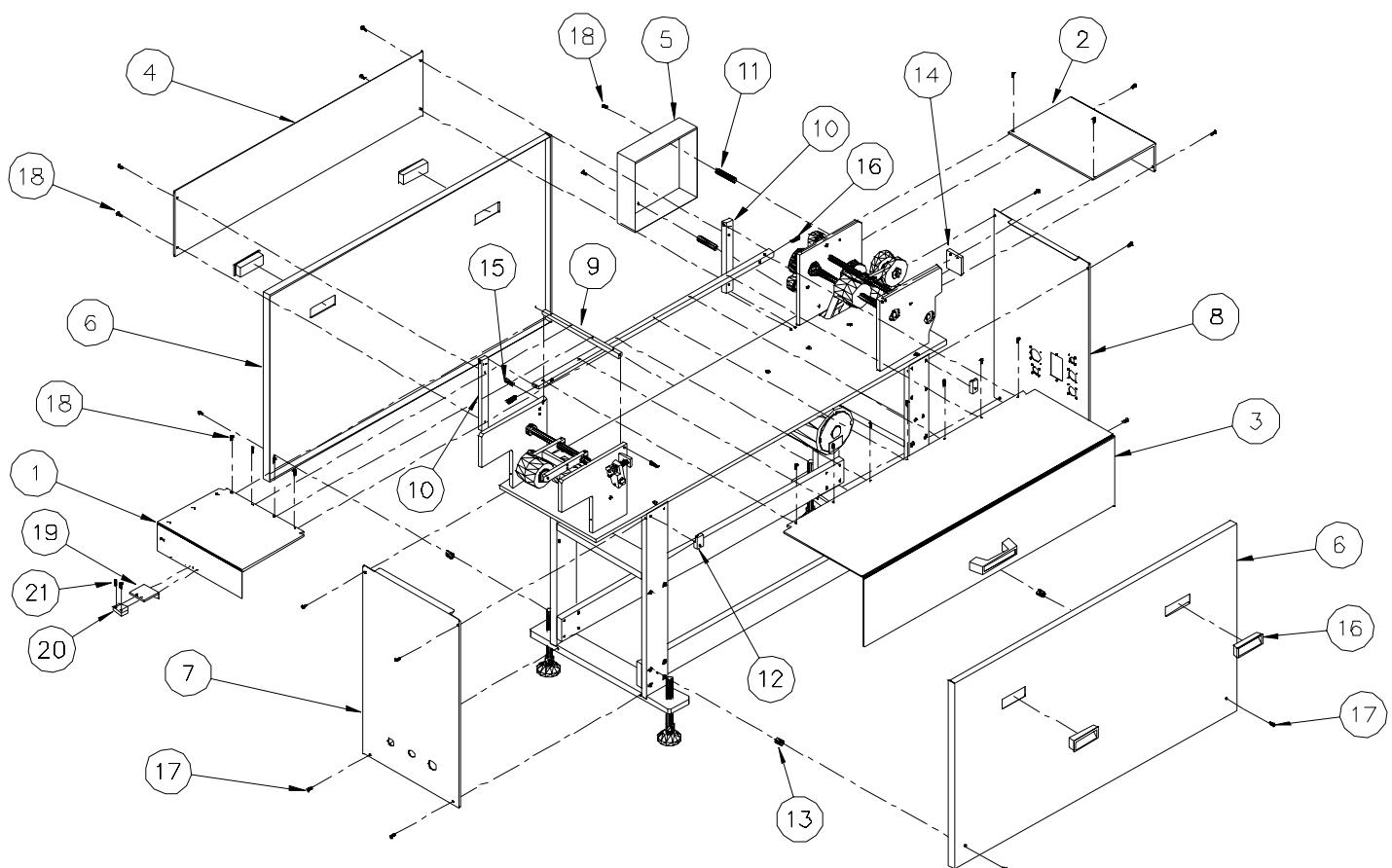
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TURNOVER (Fig. 5-8)
COVER ASSEMBLY

ITEM	PART NO.	QTY.	DESCRIPTION
1	20013-001	1	COVER, INFEED
2	20013-002	1	COVER, DISCHARGE
3	(SEE FIG. 5-9)	1	ASSEMBLY, CENTER COVER
4	20013-008	1	COVER, SIDE
5	20013-006	1	COVER, DRIVE
6	20013-003	2	COVER, SIDE GUARD
7	20013-004	1	COVER, END (INFEED)
8	20013-005	1	COVER, END (DISCHARGE)
9	20008-003	1	BAR, END COVER MTG.
10	20007-004	2	POST, COVER MTG.
11	20012-003	2	STANDOFF, DRIVE COVER
12	18007-042	4	BLOCK, SIDE GUARD COVER MTG.
13	18012-006	4	STANDOFF, SIDE GUARD COVER MTG.
14	20009-001	1	BRACKET, SWITCH MTG.
15	99006-024	4	PIN, STUD, 5/16-24 X 1-1/8
16	99012-002	4	HANDLE, SIDE GUARD COVER
17		12	SCREW, BUTTON HD, 10-24 X 1/2
18		21	SCREW, BUTTON HD, 8-32 X 1/2
19	99018-002	1	BRACKET, SENSOR MTG (TURNOVER)
20	98009-002	1	SENSOR, SENDER & RECIEVER, P & F THRU BEAM
21		2	SCREW, PAN HD, 6-32 X 1/4

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FIG. 5-8



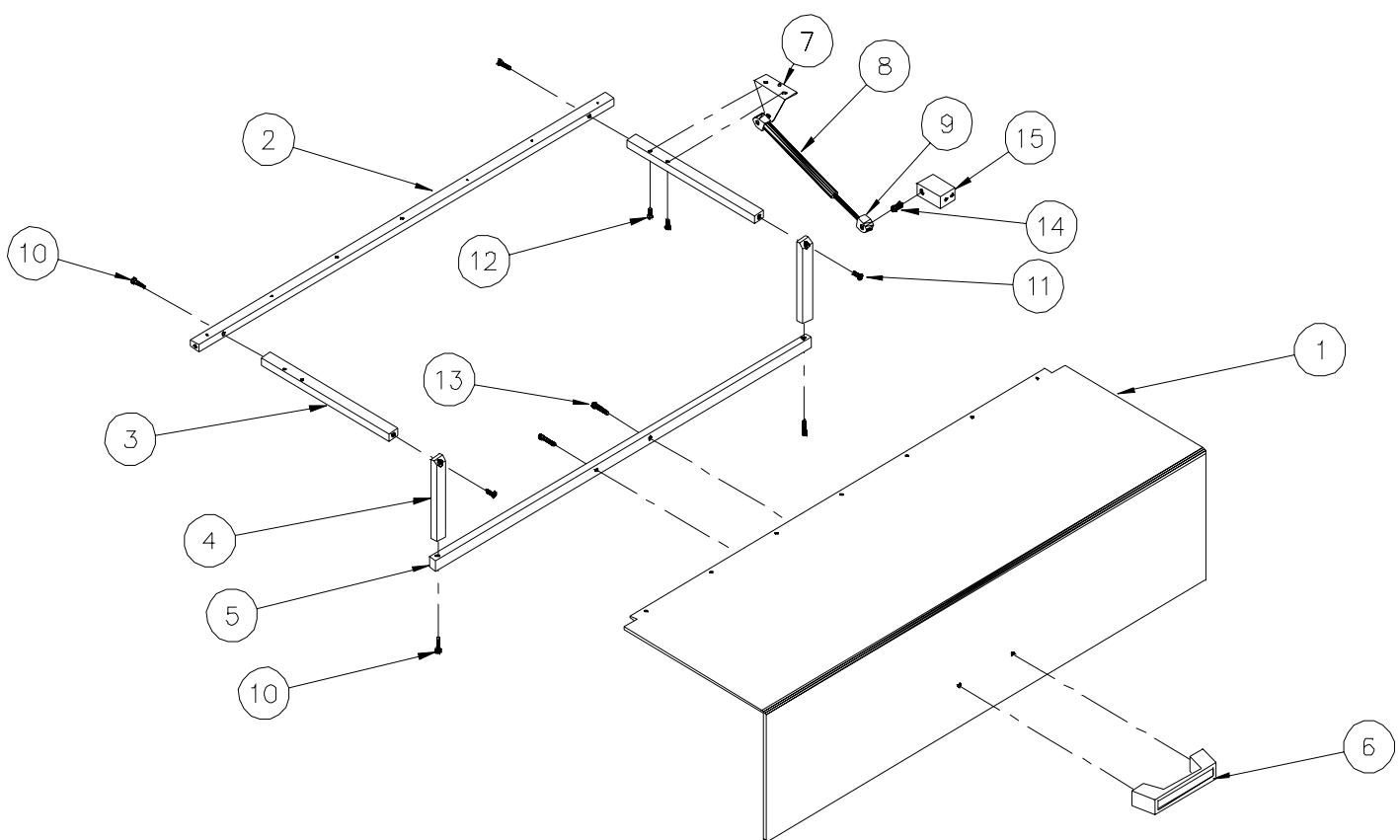
Sure-Feed
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TURNOVER - COVERS (Fig. 5-9)
CENTER COVER ASSEMBLY

ITEM	PART NO.	QTY.	DESCRIPTION
1	20013-007	1	COVER, CENTER
2	20008-004	1	BAR, COVER MTG.
3	20008-010	2	BAR, COVER SUPPORT (TOP)
4	20008-009	2	BAR, COVER SUPPORT (SIDE)
5	20008-006	1	BAR, COVER SUPPORT (HANDLE)
6	99012-001	1	HANDLE, CENTER COVER
7	99014-008	1	BALL STUD ANGLE BRACKET
8	99014-007	1	GAS SPRING
9	99014-005	2	BALL SOCKET END FITTING
10		4	SCREW, SKT HD, 1/4-20 X 3/4
11		2	SCREW, SKT HD, 1/4-20 X 1/2
12		2	SCREW, PAN HD, 10-24 X 1/2
13		2	SCREW, SKT HD, 1/4-20 X 1
14	99014-009	1	BALL STUD
15	20007-007	1	BLOCK, GAS SPRING MGT.

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FIG. 5-9

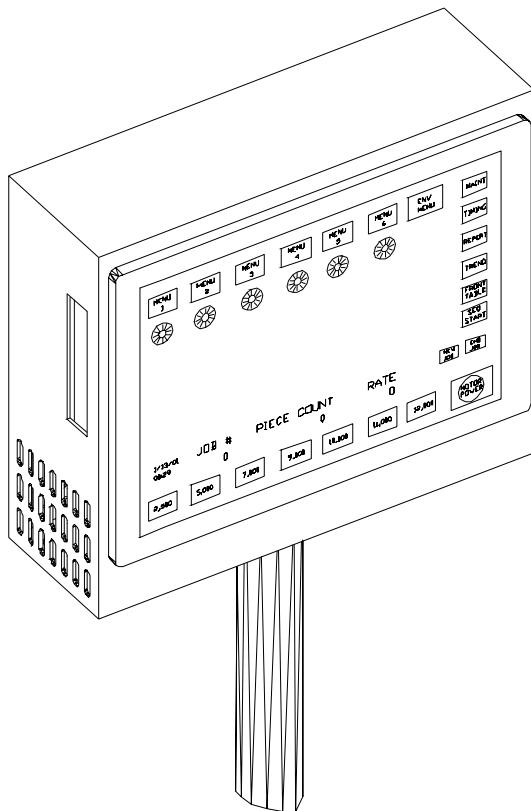


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TOUCH SCREEN

6 X 9



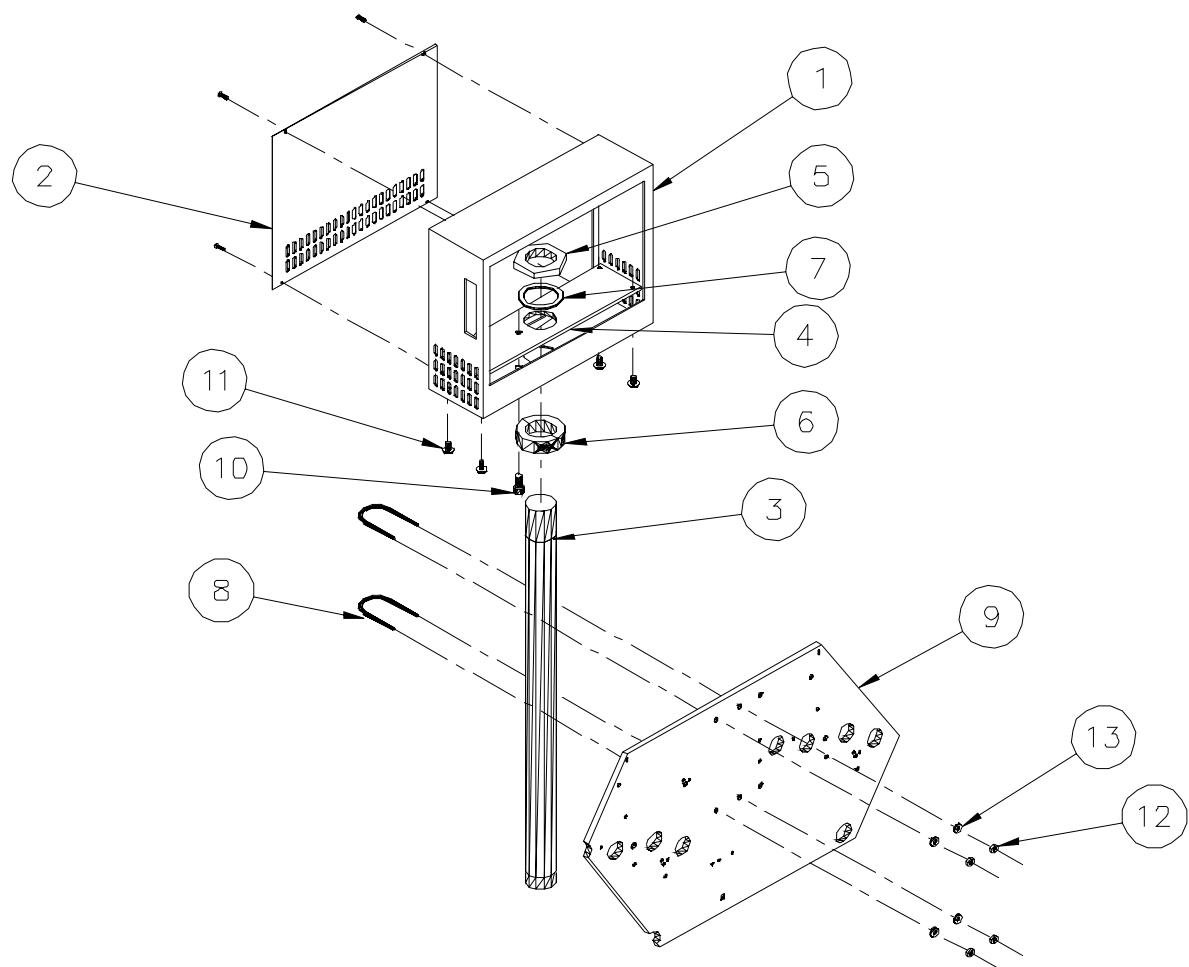
**Sure-Feed
Engineering Inc**

TOUCH SCREEN ASSEMBLY (Fig.6-1)

ITEM	PART NO.	QTY.	DESCRIPTION
1	18013-001	1	ENCLOSURE, OPERATOR INTERFACE
2	18011-021	1	PLATE, BACK – OPERATOR INTERFACE
3	18019-003	1	POST, OPERATOR INTERFACE SUPPORT
4	18011-020	1	PLATE, STIFFENER
5	18019-002	1	NUT, OPERATOR INTERFACE MTG.
6	99017-015	1	COLLAR, SHAFT, 1-5/8
7	99005-014	1	SPRING WASHER, 45.5 MM ID
8	99024-002	2	U-BOLT, 1-1/4 PIPE
9	18011-001	1	PLATE, FEEDER MOUNTING, 6 X 9 (REF. ONLY)
10		1	SCREW, SKT HD, 3/8-16 X 3/4
11		4	SCREW, BUTTON HD, 1/4-20 X 1/2
12		4	NUT, HEX HEAD, 5/16-18
13		4	WASHER, FLAT (SAE), 5/16
14	98013-003	1	TOUCH SCREEN INTERFACE, MITS. (NOT SHOWN)
15	98013-005	1	MEMORY CARD, 1 MEG, MITS. (NOT SHOWN)
16 NOT SHOWN	98010-003 98010-015	1 1	CABLE, COMM, MITSUBISHI (NOT SHOWN) (FX PLC) CABLE, COMM, MITSUBISHI (NOT SHOWN) (Q SERIES)
17	98013-006	1	COMM. MODULE, RS422, MITS. (NOT SHOWN)

Sure-Feed
Engineering Inc

FIG. 6-1



NOTE: INTERFACE, COMM MODULE, MEMORY CARD, COMM CABLE NOT SHOWN (ITEMS 14-17)

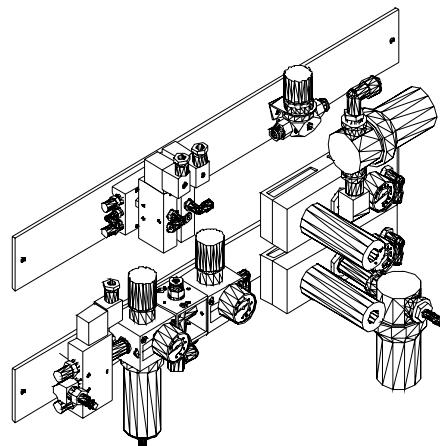
Sure-Feed
Engineering Inc

Sure-Feed
Engineering Inc

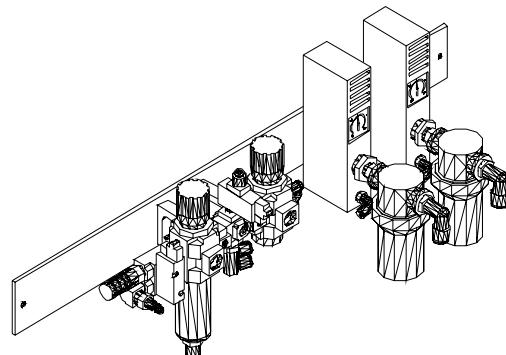
PNEUMATICS

6 X 9

BEFORE 12/2000



AFTER 12/2000



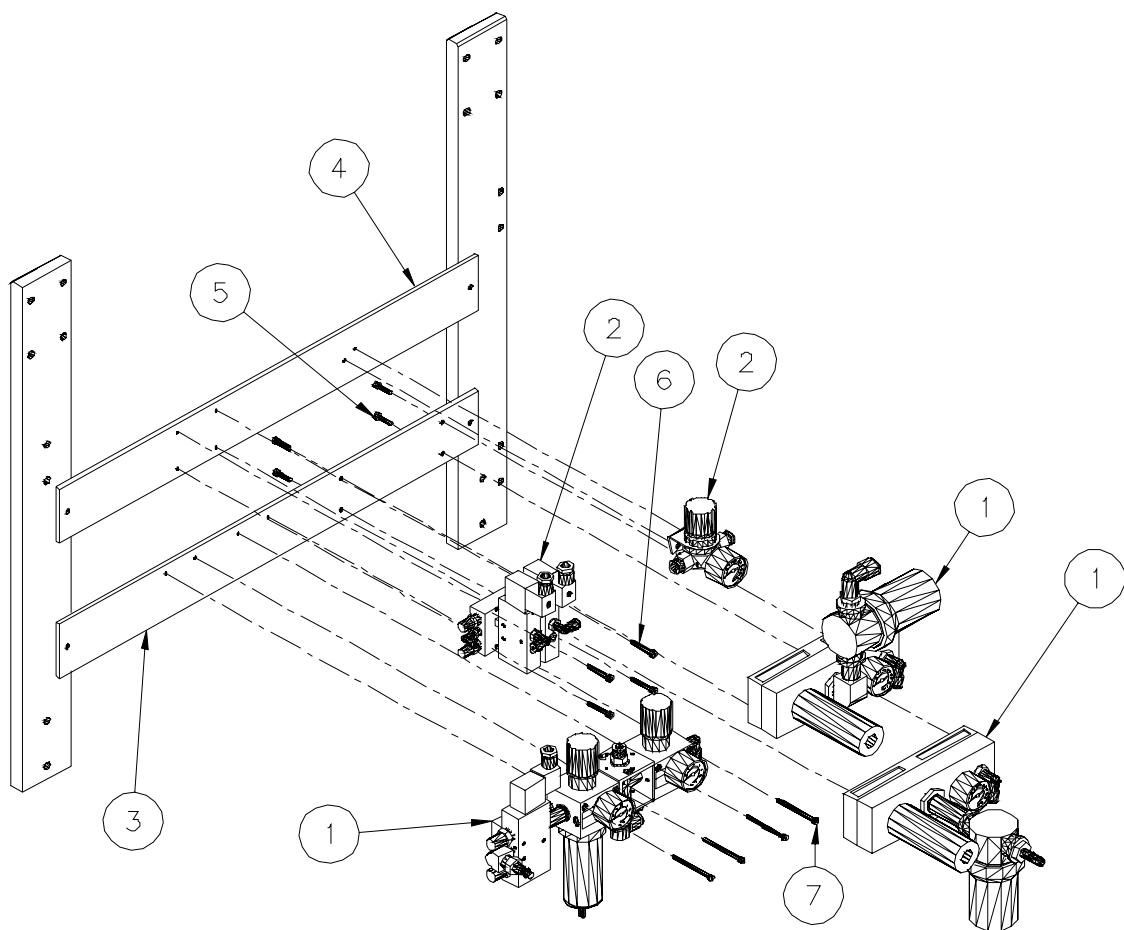
Sure-Feed
Engineering Inc

PNEUMATICS (BEFORE 12/2000) (Fig. 7-1)
MOUNTING BAR ASSEMBLY

ITEM	PART NO.	QTY.	DESCRIPTION
1	(SEE FIG. 7-2)	1	MAIN FILTER / REGULATOR / VAC. GEN. ASSY.
2	(SEE FIG 7-3)	1	INSERT / DIVERT AIR VALVE AND REGULATOR ASSY.
3	18008-032	1	BAR, PNEUMATICS MTG. (LOWER)
4	18008-033	1	BAR, PNEUMATICS MTG. (UPPER)
5		4	SCREW, SKT HD, 10-24 X 3/4
6		4	SCREW, SKT HD, 10-24 X 1-1/4
7		4	SCREW, SKT HD, 8-32 X 2-1/4

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FIG. 7-1



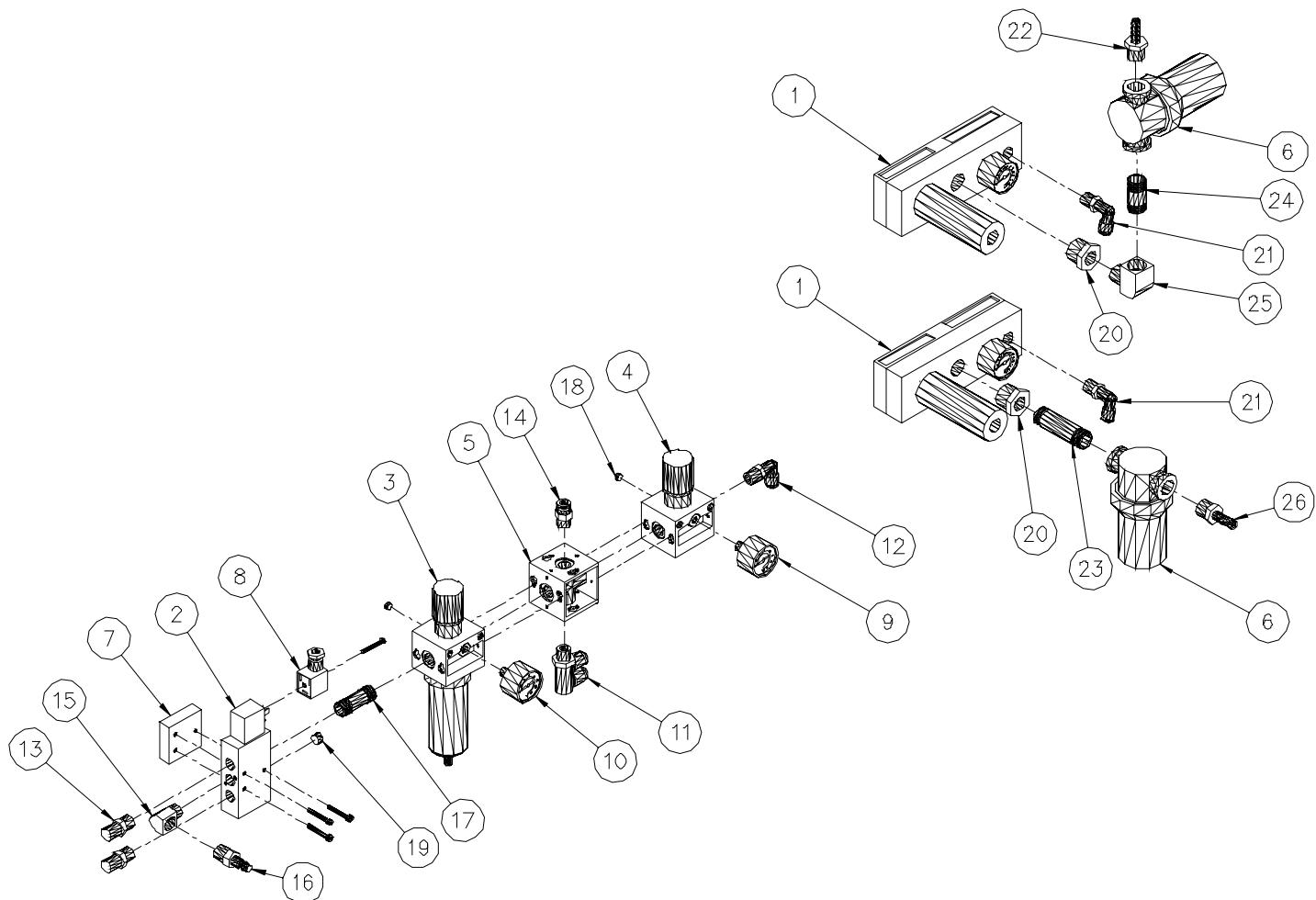
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**PNEUMATICS – MOUNTING BAR (BEFORE 12/2000) (Fig. 7-2)
MAIN FILTER / REGULATOR / VACUUM GENERATOR ASSY**

ITEM	PART NO.	QTY.	DESCRIPTION
1	99029-002	2	VACUUM GENERATOR (W/ GAUGE AND MUFFLER)
2	99025-001	1	VALVE, SOLENIOD, MAIN
3	99026-001	1	REGULATOR, FILTER
4	99026-003	1	REGULATOR, WATER
5	99026-002	1	BLOCK, DIVERTER
6	99027-001	2	FILTER, VACUUM
7	18007-062	1	BLOCK, SEPERATOR
8	99025-003	1	PLUG, SOCKET, 24VOLT W/ LIGHTS
9	99030-001	1	GUAGE, 0-15 PSI (WATER REG.)
10	99030-003	1	GUAGE, 0-160 PSI (FILTER REG.)
11	99028-061	1	FITTING, DOUBLE MALE ELBOW, 3/8 TUBE X 3/8 NPT
12	99028-020	1	FITTING, MALE ELBOW, 1/4 TUBE X 3/8 NPT
13	99028-007	2	MUFFLER, 3/8 NPT
14	99028-018	1	FITTING, MALE CONNECTOR, 3/8 TUBE X 3/8 NPT
15	99028-004	1	ELBOW, STREET BRASS, 3/8
16	99028-001	1	COUPLING, QUIKE DISCONNECT 1/4 X 3/8 NPT
17	99028-013	1	NIPPLE, BRASS, 3/8 NPT X 2
18	99028-008	2	PLUG, FLUSH, 1/8 NPT
19	99028-010	1	PLUG, FLUSH, 3/8 NPT
20	99028-037	2	FITTING, BRASS REDUCER, 3/4 NPT TO 1/2 NPT
21	99028-021	2	FITTING, MALE ELBOW, 3/8 TUBE X 1/4 NPT
22	99028-027	1	FITTING, HOSE BARB, 1/2 NPT X 3/8 ID HOSE
23	99028-040	1	NIPPLE, BRASS, 1/2 NPT X 3-1/2
24	99028-039	1	NIPPLE, BRASS, 1/2 NPT X 2
25	99028-005	1	ELBOW, STREET BRASS, 1/2
26	99028-026	1	FITTING, HOSE BARB, 1/2 NPT X 1/2 ID HOSE
27	99027-002	2	FILTER ELEMENT, REPLACEMENT (NOT SHOWN)
28	99031-002	20'	TUBING, PLOY FLOW, 3/8 (NOT SHOWN)
29	99031-001	10'	TUBING, POLY FLOW, 1/4 (NOT SHOWN)

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FIG. 7-2



NOTE: ITEM 27: 3/8 POLY FLOW TUBING (NOT SHOWN)

ITEM 28: 1/4 PLOY FLOW TUBING (NOT SHOWN)

ITEM 26: REPLACEMENT FILTER ELEMENT (NOT SHOWN)

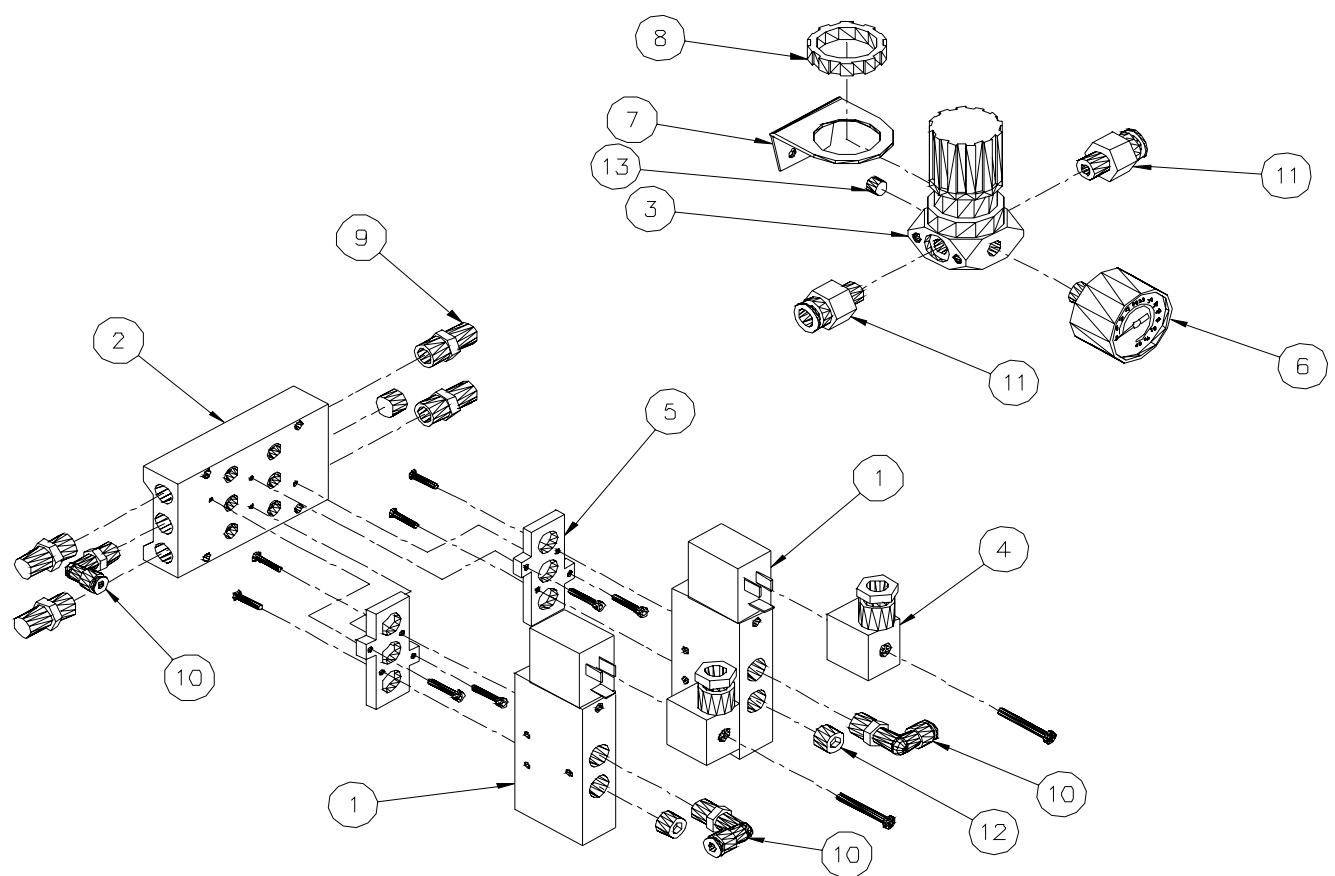
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PNEUMATICS – MOUNTING BAR (BEFORE 12/2000) (Fig. 7-3)
INSERT AIR / DIVERT AIR VALVE BANK AND DIVERT AIR
REGULATOR ASSEMBLY

ITEM	PART NO.	QTY.	DESCRIPTION
1	99025-002	2	VALVE, SOLENOID (ENVELOPE AIR)
2	99025-004	1	MANIFOLD, 2 STATION
3	99026-005	1	REGULATOR, (ENVELOPE AIR/DIVERT)
4	99025-003	2	PLUG, SOCKET, 24 VOLT W/ LIGHTS
5	99025-005	2	ADAPTER KIT, (L1 VALVE)
6	99030-004	1	GAUGE, 0-60 PSI
7	99026-007	1	BRACKET, REGULATOR MTG.
8	99026-006	1	NUT, PANEL MOUNT
9	99028-006	4	MUFFLER, 1/4 NPT
10	99028-021	3	FITTING, MALE ELBOW, 3/8 TUBE X 1/4 NPT
11	99028-035	2	FITTING, MALE CONNECTOR, 3/8 TUBE X 1/8 NPT
12	99028-008	1	PLUG, FLUSH, 1/8 NPT
13	99028-009	3	PLUG, FLUSH, 1/4 NPT

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FIG. 7-3



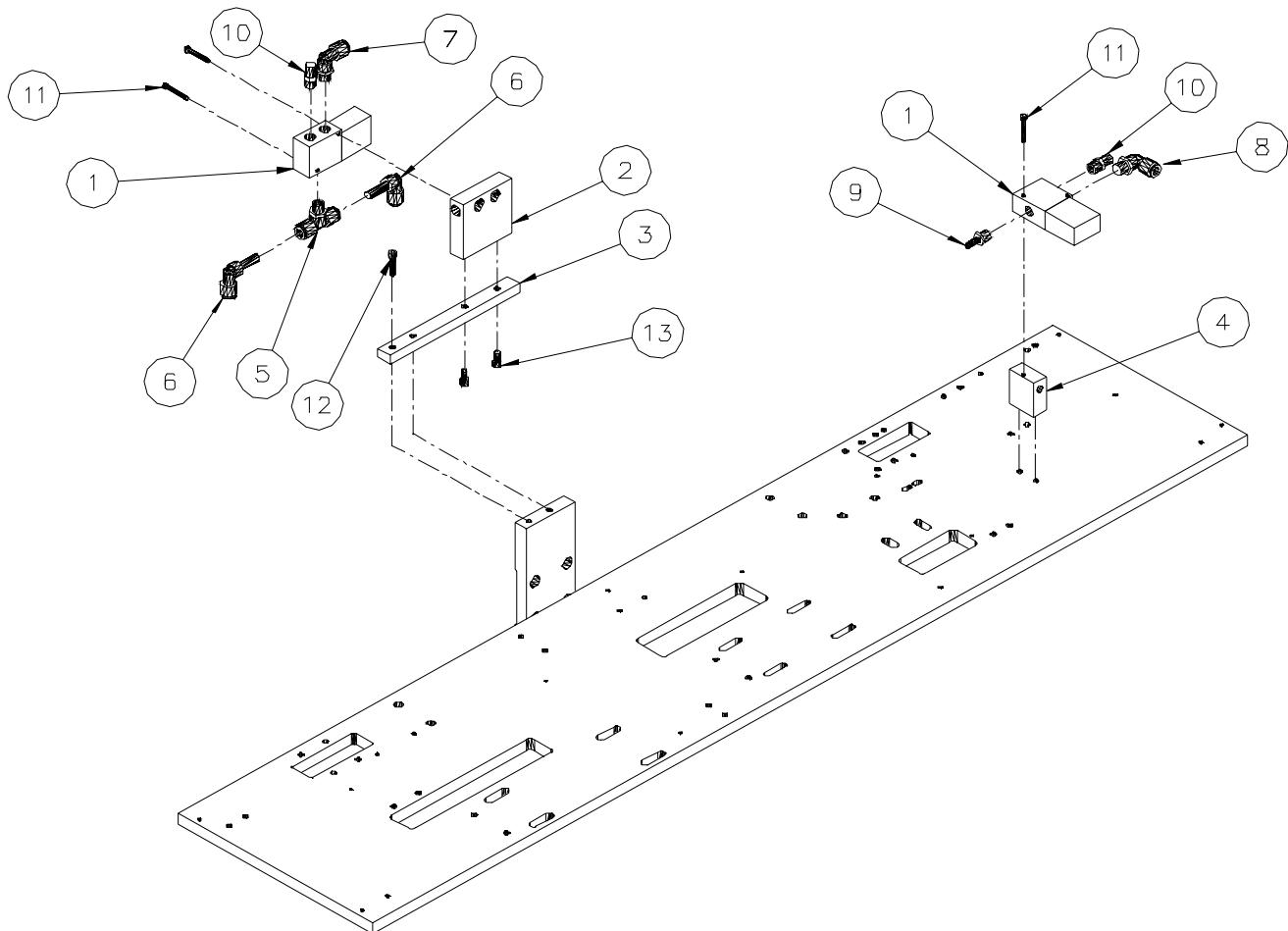
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PNEUMATICS (Fig. 7-4)
VACUUM SHUTTLE / VACUUM DISH SOLENOID ASSY

ITEM	PART NO.	QTY.	DESCRIPTION
1	99025-006	2	VALVE, SOLENOID (VACUUM)
2	18007-063	1	BLOCK, MANIFOLD
3	18008-034	1	BAR, MANIFOLD MTG.
4	18007-030	1	BLOCK, IDLER MTG
5	99028-064	1	FITTING, MALE BRANCH TEE, 1/4 NPT X 3/8 TUBE
6	99028-073	2	FITTING, ELBOW ADAPTER, 3/8 MALE TUBE X 3/8 TUBE
7	99028-021	1	FITTING, MALE ELBOW, 1/4 NPT X 3/8 TUBE
8	99028-080	1	FITTING, MALE ELBOW, 1/4 NPT X 1/2 ID HOSE
9	99028-029	1	FITTING, HOSE BARB, 1/4 NPT X 3/8 ID HOSE
10	99028-006	2	MUFFLER, 1/4 NPT
11		3	SCREW, SKT HD, 8-32 X 1-1/4
12		1	SCREW, SKT HD, 1/4-20 X 1
13		2	SCREW, SKT HD, 1/4-20 X 1/2
14	99031-004	4'	HOSE, 1/2 ID (NOT SHOWN)
15	99031-003	4'	HOSE, 3/8 ID (NOT SHOWN)

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FIG. 7-4



NOTE: 3/8 ID AND 1/2 ID HOSE NOT SHOWN (ITEMS 14 & 15)

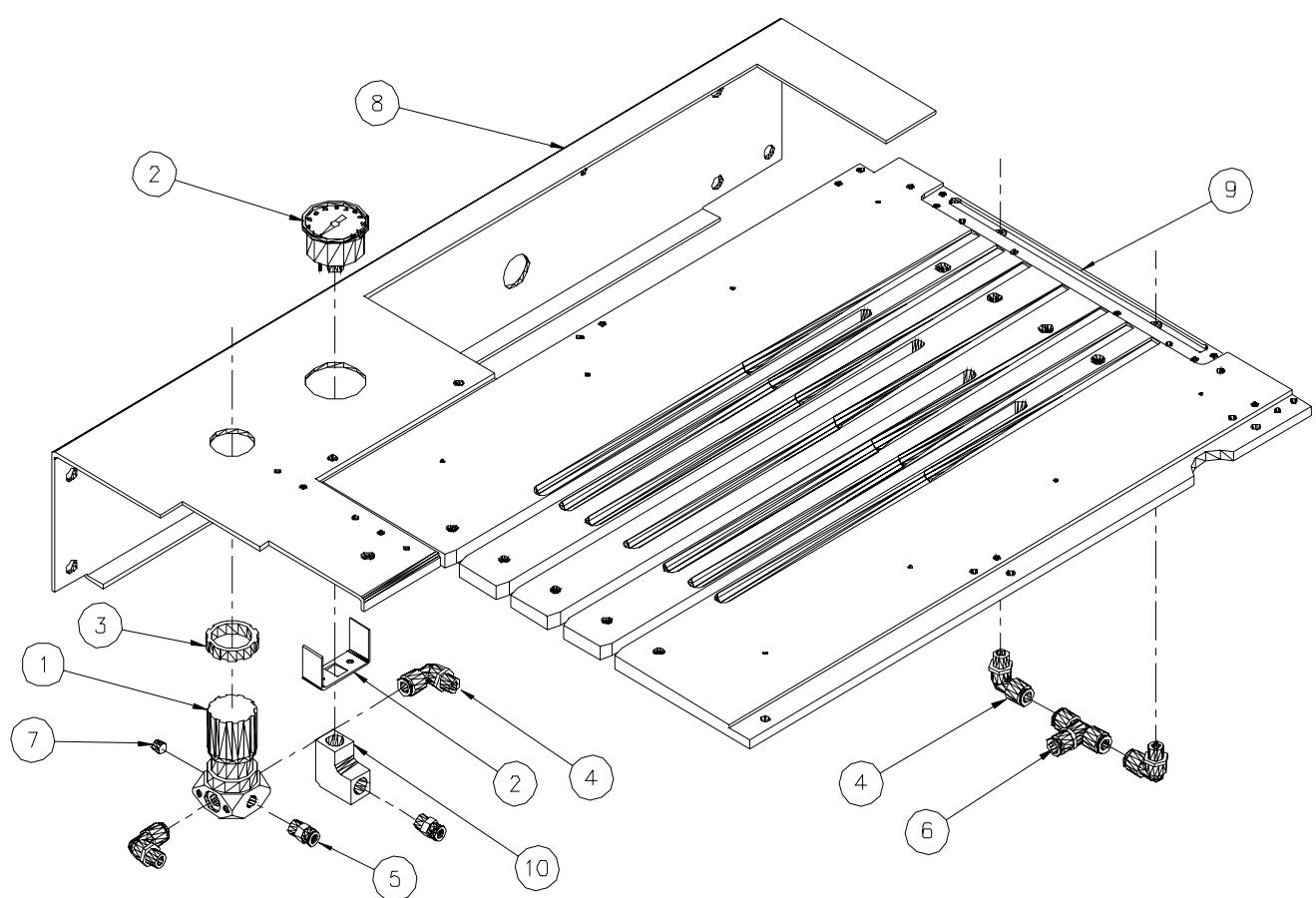
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PNEUMATICS (Fig. 7-5)
INSERT AIR ASSEMBLY

ITEM	PART NO.	QTY.	DESCRIPTION
1	99026-005	1	REGULATOR, INSERT AIR
2	99030-002	1	GUAGE, PANEL MOUNT, 0-60, W/ BRACKET
3	99026-006	1	NUT, PANEL MOUNT
4	99028-022	4	FITTING, MALE ELBOW, 3/8 TUBE X 1/8 NPT
5	99028-016	2	FITTING, MALE CONNECTOR, 1/4 TUBE X 1/8 NPT
6	99028-036	1	FITTING, TEE, 3/8 TUBE
7	99028-008	1	PLUG, FLUSH, 1/8 NPT
8	18001-007	1	COVER, TOP, LH SHORT (REF ONLY)
9	18005-001	1	PLATE, PUSHER GUIDE (REF. ONLY)
10	99028-024	1	ELBOW, 1/8 NPT

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FIG. 7-5



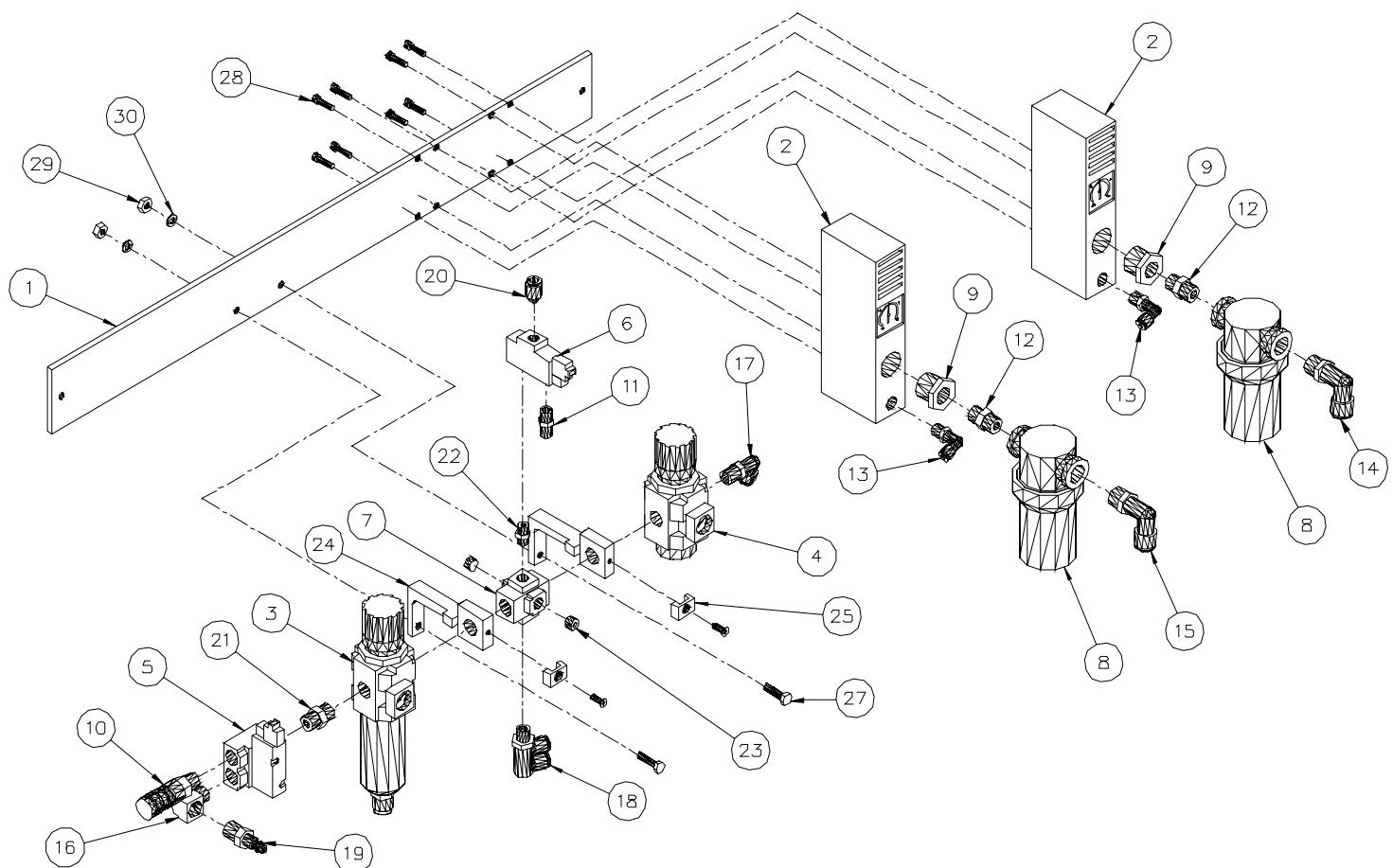
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**PNEUMATICS (AFTER 12/2000) (Fig. 7-6)
MOUNTING BAR ASSEMBLY**

ITEM	PART NO.	QTY.	DESCRIPTION
1	99026-014	1	BAR, MOUNTING, PNEUMATICS
2	99029-004	2	VACUUM GENERATOR, MULTI STAGE, ZL SERIES
3	99026-008	1	REGULATOR, FILTER
4	99026-009	1	REGULATOR, WATER
5	99025-010	1	VALVE, SOLENOID, BASE MOUNTED PORTS
6	99025-011	1	VALVE, SOLENOID, BODY PORTED PORTS
7	99026-010	1	BLOCK, DIVERT
8	99027-005	2	FILTER, VACUUM
9	99028-037	2	FITTING, BRASS REDUCER, 3/4 NPT TO 1/2 NPT
10	99028-069	1	MUFFLER, 3/8 NPT
11	99028-006	1	MUFFLER, 1/4 NPT
12	99028-072	2	NIPPLE, HEX, 1/2 NPT
13	99028-067	2	FITTING, MALE ELBOW, 5/16 TUBE X 1/8 NPT
14	99028-066	1	FITTING, MALE ELBOW, 1/2 TUBE X 1/2 NPT
15	99028-063	1	FITTING, MALE ELBOW, 3/8 TUBE X 1/2 NPT
16	99028-004	1	ELBOW, STREET BRASS, 3/8 NPT
17	99028-020	1	FITTING, MALE ELBOW, 1/4 TUBE X 3/8 NPT
18	99028-068	1	FITTING, DOUBLE MALE ELBOW, 5/16 TUBE X 1/4 NPT
19	99028-001	1	COUPLING, QUIKE DISCONNECT, 1/4 X 3/8 NPT
20	99028-017	1	FITTING, MALE CONNECTOR, 3/8 TUBE X 1/4 NPT
21	99028-071	1	NIPPLE, HEX, 3/8 NPT
22	99028-070	1	NIPPLE, HEX, 1/4 NPT
23	99028-009	2	PLUG, FLUSH, 1/4 NPT
24	99026-011	2	BRACKET, PNEUMATIC MOUNTING
25	99026-012	2	NUT, PNEUMATIC MOUNTING
26	99027-006	2	FILTER ELEMENT, REPLACEMENT (NOT SHOWN)
27		2	SCREW, HEX HD, 1/4-20 X 1
28		8	SCREW, SKT HD, 10-24 X 3/4
29		2	NUT, HEX HD, 1/4 -20
30		2	WASHER, LOCK, 1/4
31	99031-008	4'	TUBING, 5/16 OD (NOT SHOWN)
32	99031-002	4'	TUBING, 3/8 OD (NOT SHOWN)
33	99031-001	12'	TUBING, 1/4 OD (NOT SHOWN)

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FIG. 7-6



NOTE: FILTER ELEMENT NOT SHOWN (ITEM 26)

NOTE: TUBING (5/16, 1/4, 3/8 OD) NOT SHOWN (ITEMS 31-33)

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**ELECTRICAL
COMPONENTS**
6 X 9

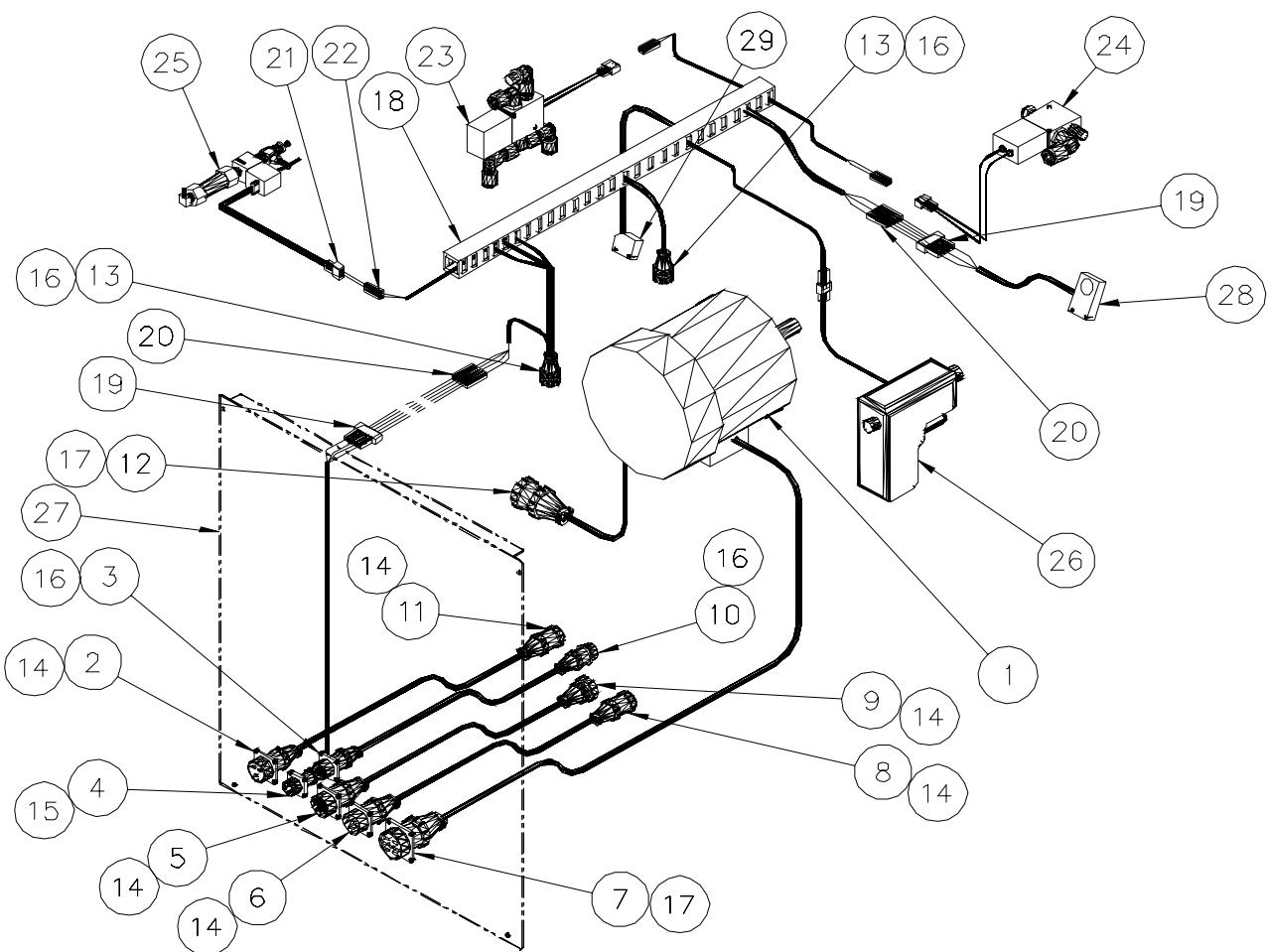
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ELECTRICAL COMPONENTS (FRONT TABLE) (Fig. 8-1)

ITEM	PART NO.	QTY.	DESCRIPTION
	99001-006	1	MOTOR, 3/4 HP, 1750 RPM
2	98016-002	1	RECEPTACLE, SQ FLANGE, AMP, SERIES 3, 17-3 REV.
3	98016-006	1	RECEPTACLE, SQ FLANGE, AMP, SERIES 1, 13-9 STD.
4	98016-011	1	RECEPTACLE, SQ FLANGE, AMP, SERIES 1, 11-4 REV.
5	98016-010	1	RECEPTACLE, SQ FLANGE, AMP, SERIES 1, 17-16 STD.
6	98016-001	1	RECEPTACLE, SQ FLANGE, AMP, SERIES 3, 17-3 STD.
7	98016-009	1	RECEPTACLE, SQ FLANGE, AMP, SERIES 3, 23-7 REV.
8	98016-004	1	PLUG, AMP, SERIES 3, 17-3 REV.
9	98016-012	1	PLUG, AMP, SERIES 1, 17-16 STD.
10	98016-016	1	RECEPTACLE, FR. HANGING, AMP, SERIES 1, 13-9 STD.
11	98016-003	1	PLUG, AMP, SERIES 3, 17-3 STD
12	98016-013	1	PLUG, AMP, SERIES 3, 23-7 REV.
13	98016-007	2	PLUG, AMP, SERIES 1, 13-9 STD
14	98016-005	4	BACKSHELL, PLASTIC, SIZE 17
15	98016-015	1	BACKSHELL, PLASTIC, SIZE 11
16	98016-008	1	BACKSHELL, PLASTIC, SIZE 13
17	98016-014	2	BACKSHELL, PLASTIC, SIZE 23
18	98012-004	1	DUCT, WIREWAY W/ COVER, 1 X 1 (FRONT TABLE)
19	98016-021	1	MALE CONNECTOR, 5 PIN
20	98016-022	1	FEMALE CONNECTOR, 5 PIN
21	98016-023	3	MALE CONNECTOR, 2 PIN
22	98016-024	3	FEMALE CONNECTOR, 2 PIN
23	99025-006	REF	VACUUM DISH SOLENOID (W/ FITTINGS)
24	99025-006	REF	VACUUM SHUTTLE SOLENOID (W/ FITTINGS)
25	99025-007	REF	VALVE, WATER SOLENIOD, 24 VOLT DC, 1/8 NPT
26	99014-001	REF	LINEAR ACTUATOR, 2" ST. (W/ 2 PIN CONNECTOR)
27	18013-012	REF	COVER, END, FRONT TABLE (W/ HOLES)
28	98009-001	1	SENSOR, BANNER AN7 (ENV. HOPPER)
29	98009-002	1	SENSOR, SENDER/RECIEVER, P&F THRU (GATE)

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FIG. 8-1



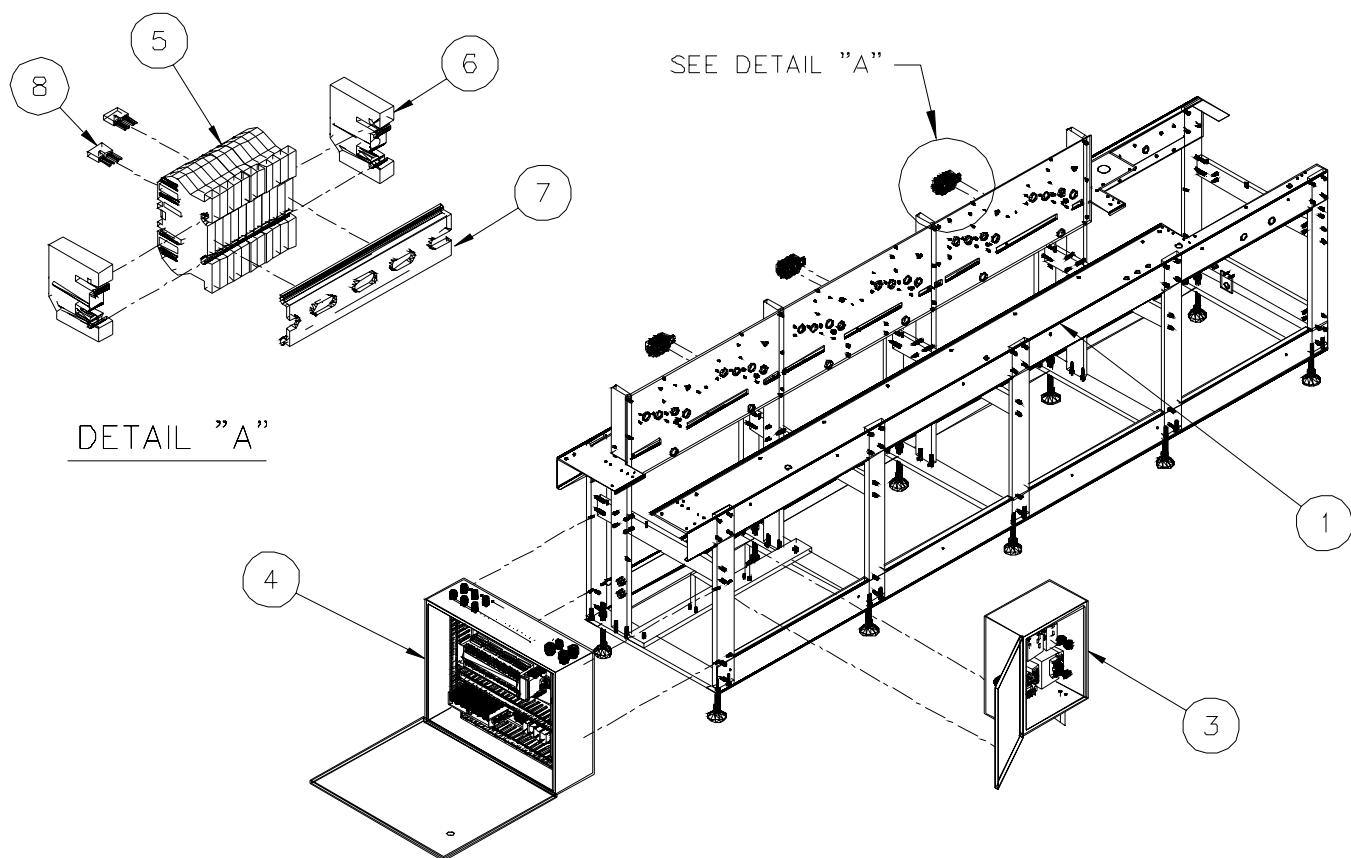
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ELECTRICAL COMPONENTS (COLLATOR) (Fig. 8-2)
COLLATOR ELECTRICAL ASSEMBLY

ITEM	PART NO.	QTY.	DESCRIPTION
1	(SEE FIG. 8-3)	1	OPERATOR CONTROL SWITCH ASSEMBLY
2	SEE FIG. 8-4)	1	PLUG / RECEPTICAL ASSEMBLY (NOT SHOWN)
3	(SEE FIG. 8-5)	1	VFD ENCLOSURE – COMPONENTS ASSEMBLY
4	(SEE FIG. 8-6)	1	PLC ENCLOSURE – COMPONENTS ASSEMBLY
5	98001-010	33	TERMINAL BLOCK, ENTRELEC
6	98001-014	6	END STOP, ENTRELEC, SCREW TYPE
7	98001-022	3	DIN RAIL, ENTRELEC
8	98001-016	6	JUMPER, 2 POLE, TERMINAL BLOCK

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FIG. 8-2



NOTE: PLUG / RECEPTICAL ASSEMBLY NOT SHOWN (ITEM 2)

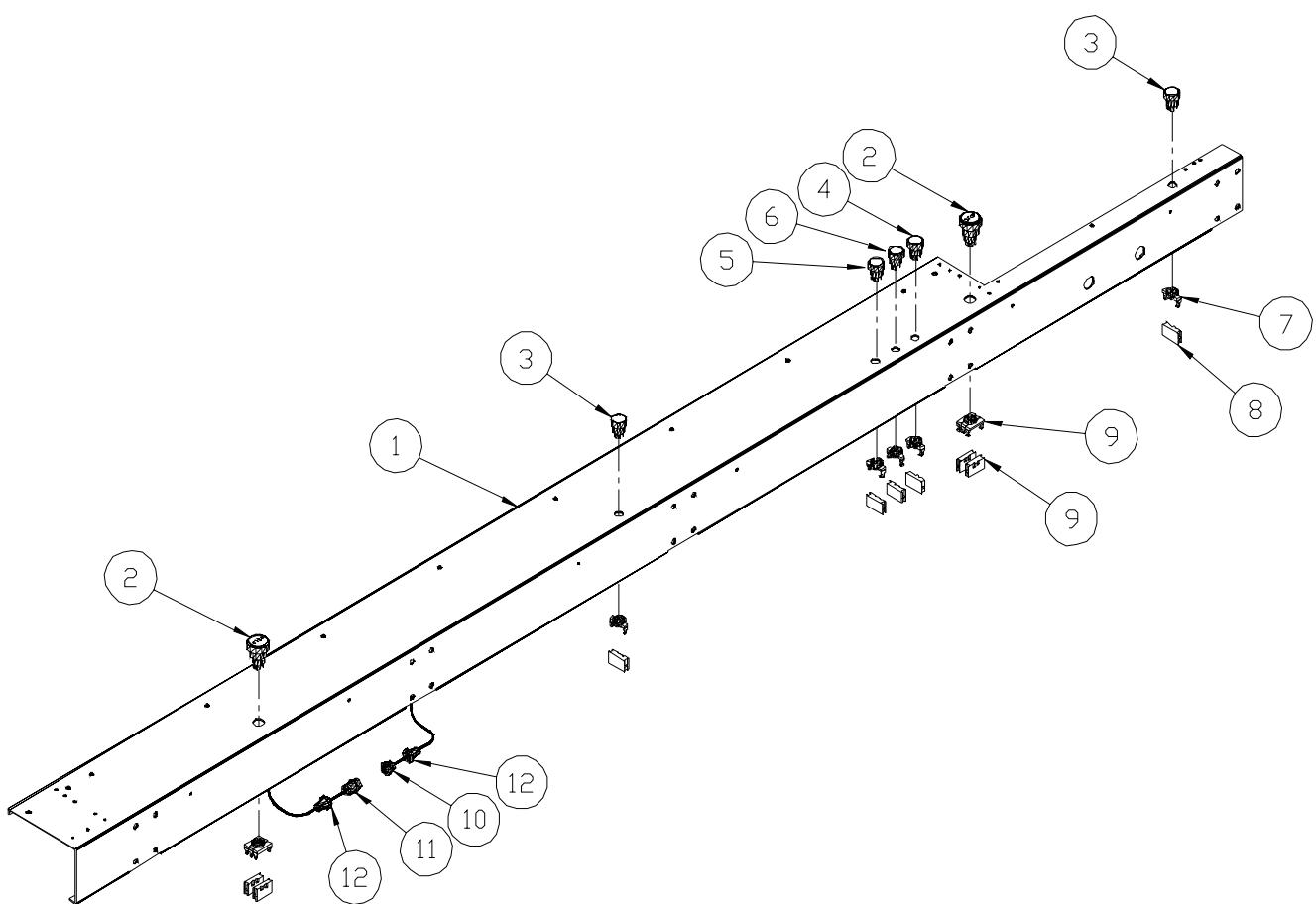
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ELECTRICAL COMPONENTS (COLLATOR) (Fig. 8-3)
OPERATOR CONTROL SWITCH ASSEMBLY

ITEM	PART NO.	QTY.	DESCRIPTION
1	18001-001	1	COVER, TOP, RH (REF. ONLY)
2	98000-016	2	STOP BUTTON, PUSH / PULL, MUSHROOM HEAD
3	98000-032	2	SWITCH, PUSH BUTTON, ROUND, BLUE
4	98000-030	1	SWITCH, PUSH BUTTON, ROUND, GREEN
5	98000-031	1	SWITCH, PUSH BUTTON, ROUND, YELLOW
6	98000-029	1	SWITCH, PUSH BUTTON, ROUND, RED
7	98000-027	5	SWITCH ASSEMBLY CLIP
8	98000-028	5	CONTACT BLOCK, 1 X NO
9	98000-017	2	CONTACT BLOCK, 1 X NO + 1 X NC + CLIP
10	98016-007	1	PLUG, AMP, SERIES 1, 13-9 STD
11	98016-016	1	RECEPTACLE, FR. HANGING, AMP, SERIES 1, 13-9 STD.
12	98016-008	2	BACKSHELL, PLASTIC, SIZE 13

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FIG. 8-3



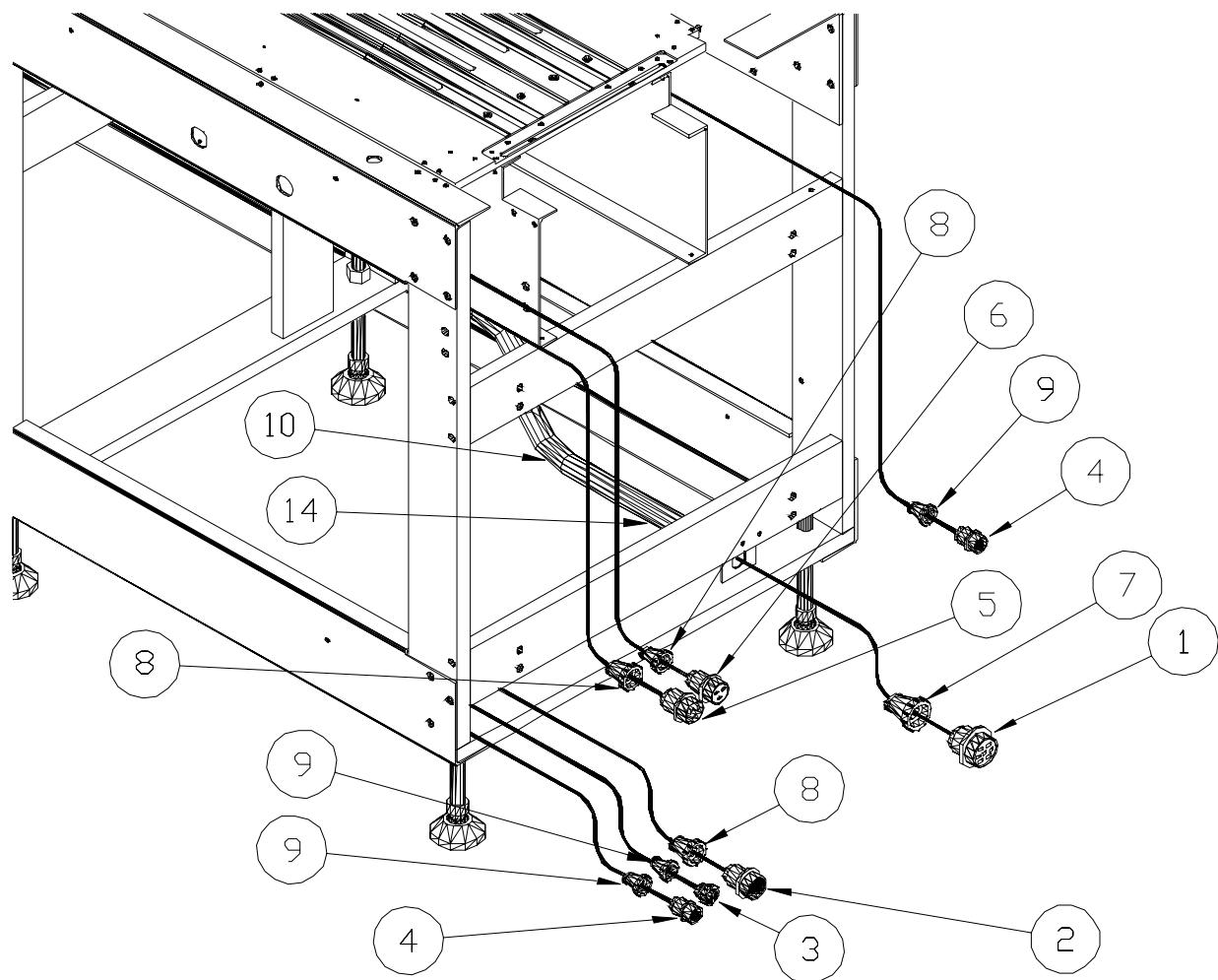
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ELECTRICAL COMPONENTS (COLLATOR) (Fig. 8-4)
PLUG / RECEPTACLE ASSEMBLY

ITEM	PART NO.	QTY.	DESCRIPTION
1	98016-017	1	RECEPTICAL, FR. HANGING, AMP, SERIES 3, 23-7 REV.
2	98016-018	1	RECEPTICAL, FR. HANGING, AMP, SERIES 1, 17-16 STD
3	98016-007	1	PLUG, AMP, SERIES 1, 13-9 STD
4	98016-016	2	RECEPTICAL, FR. HANGING, AMP, SERIES 1, 13-9 STD.
5	98016-019	1	RECEPTICAL, FR. HANGING, AMP, SERIES 3, 17-3 STD.
6	98016-020	1	RECEPTICAL, FR. HANGING, AMP, SERIES 3, 17-3 REV.
7	98016-014	1	BACKSHELL, PLASTIC, SIZE 23
8	98016-005	3	BACKSHELL, PLASTIC, SIZE 17
9	98016-008	3	BACKSHELL, PLASTIC, SIZE 13
10	98012-005	10'	CONDUIT, FLEXIBLE STEEL, 1/2"
11	98016-028	7	CONTACTS, SOCKET, 16-12 AWG. (NOT SHOWN)
12	98016-026	3	CONTACTS, PIN, 16-12 AWG. (NOT SHOWN)
13	98016-025	38	CONTACTS, PIN, 24-20 AWG. (NOT SHOWN)
14	98012-006	1	CONNECTOR, STRAIGHT, 1/2" FLEX CONDUIT

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FIG. 8-4



NOTE: CONTACTS (PIN AND SOCKET) NOT SHOWN (ITEMS 11-13)

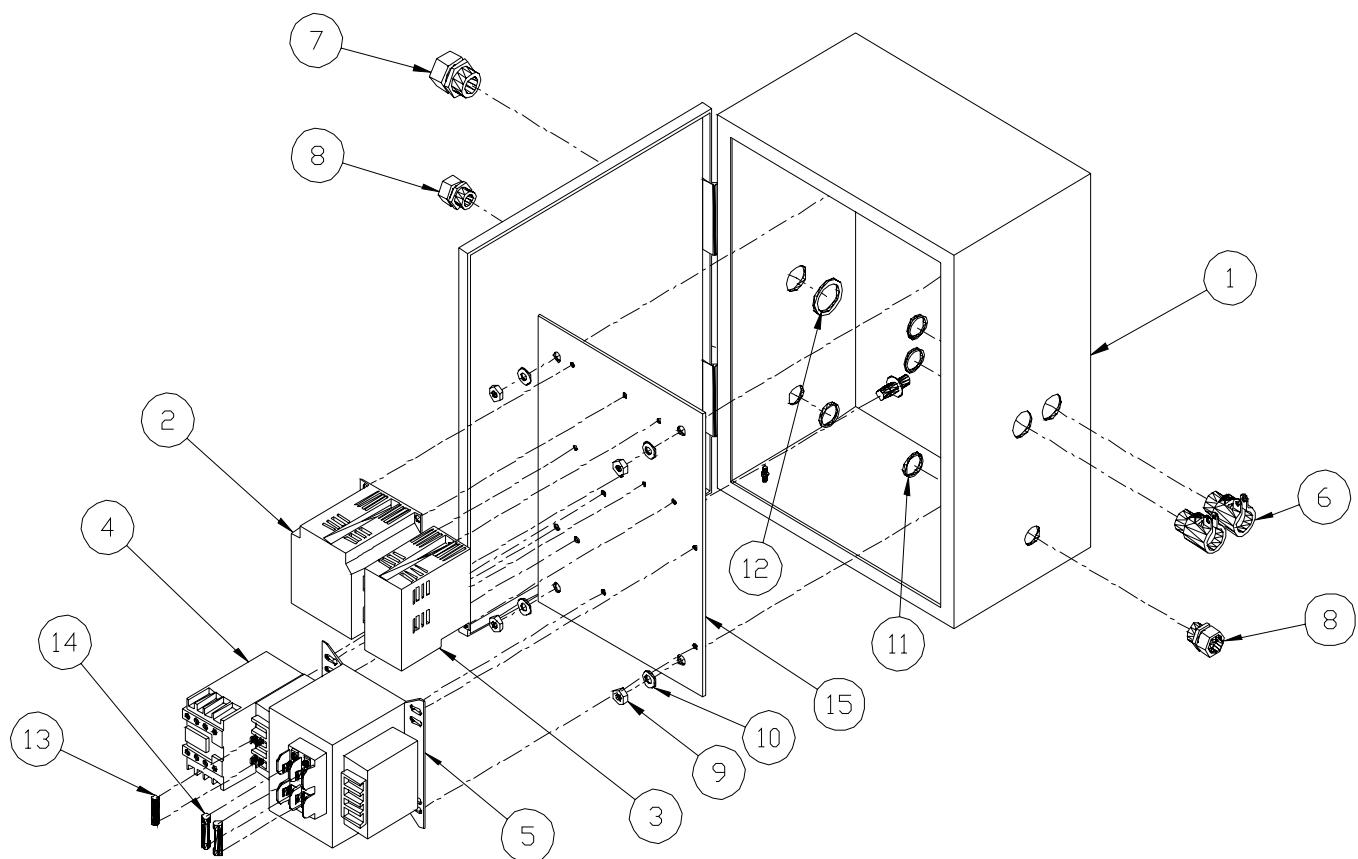
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ELECTRICAL COMPONENTS (COLLATOR) (Fig. 8-5)
VFD ENCLOSURE COMPONENTS ASSEMBLY

ITEM	PART NO.	QTY.	DESCRIPTION
1	98014-002	1	ENCLOSURE, 16" X 12" X 7", NEMA PANEL 1
2	98013-012	1	AC DRIVE, MITSUBISHI, 1.5 KW
3	98013-011	1	AC DRIVE, MITSUBISHI, 0.75 KW
4	98002-006	1	RELAY, DC CONTROL, 24 VOLT, 30 AMP
5	98008-002	1	TRANSFORMER, STEP DOWN, 1000VA
6	98012-006	2	CONNECTOR, STRAIGHT, 1/2" FLEX CONDUIT
7	98015-002	1	STRAIN RELIEF, 3/4"
8	98015-001	2	STRAIN RELIEF, 1/2"
9		4	NUT, HEX HD, 3/8 -16
10		4	WASHER, FLAT, 3/8
11	98015-004	1	NUT, LOCK, 1/2"
12	98015-003	2	NUT, LOCK, 3/4"
13	98004-005	1	FUSE, TIME DELAY, 10 AMP (FNQ)
14	98004-004	2	FUSE, CLASS CC, 10 AMP (FNQ-R)
15	98014-004	1	PANEL, BACK, VFD

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FIG. 8-5



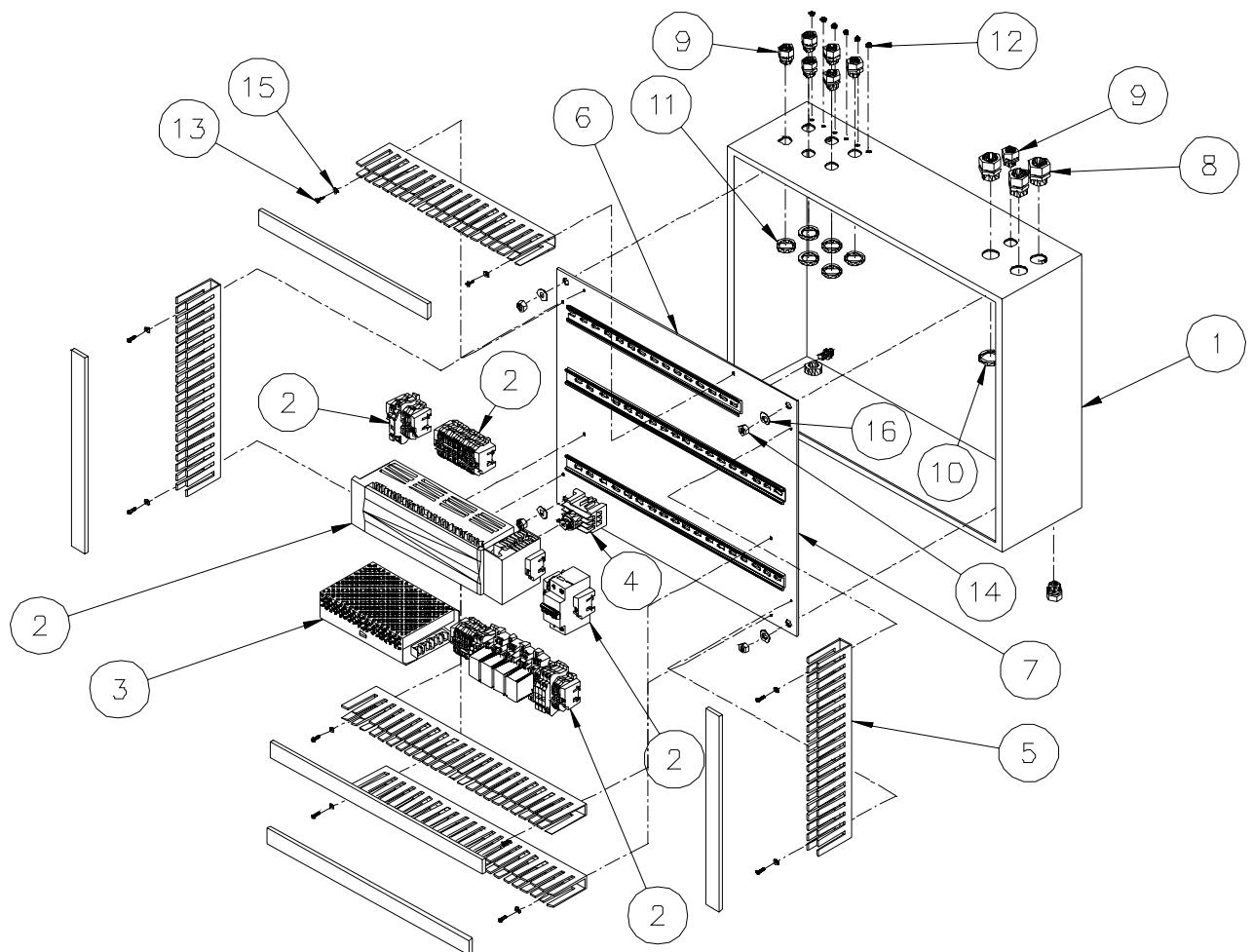
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**ELECTRICAL COMPONENTS (COLLATOR) (Fig. 8-6)
PLC ENCLOSURE COMPONENTS ASSEMBLY**

ITEM	PART NO.	QTY.	DESCRIPTION
1	98014-001	1	NEMA ENCLOSURE, 24" X 20" X 7"
2	(SEE FIG. 8-7)	1	PLC / BREAKER / TERMINAL BLOCK ASSEMBLIES
3	98011-003	1	POWER SUPPLY, 27 VOLT, 150 WATT, ASTRODYNE
4	98000-022	1	SWITCH ASSY, POWER DISCONNECT
5	98012-003	5	DUCT, WIRE WAY W/ COVER, 1" X 3"
6	98001-022	3	DIN RAIL, ENTRELEC
7	98014-003	1	PANEL, BACK, PLC
8	98015-002	4	STRAIN RELIEF, 3/4"
9	98015-001	8	STRAIN RELIEF, 1/2"
10	98015-004	4	NUT, LOCK, 3/4
11	98015-003	8	NUT, LOCK, 1/2
12	98015-005	6	GROMET, RUBBER, GROOVE, 1/16" WD, 1/2" DIAM.
13		16	SCREW, SHEET METAL, 8-18 X 1/2
14		4	NUT, 3/8-16
15		16	WASHER, FLAT, #8
16		4	WASHER, FLAT, 3/8

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FIG. 8-6



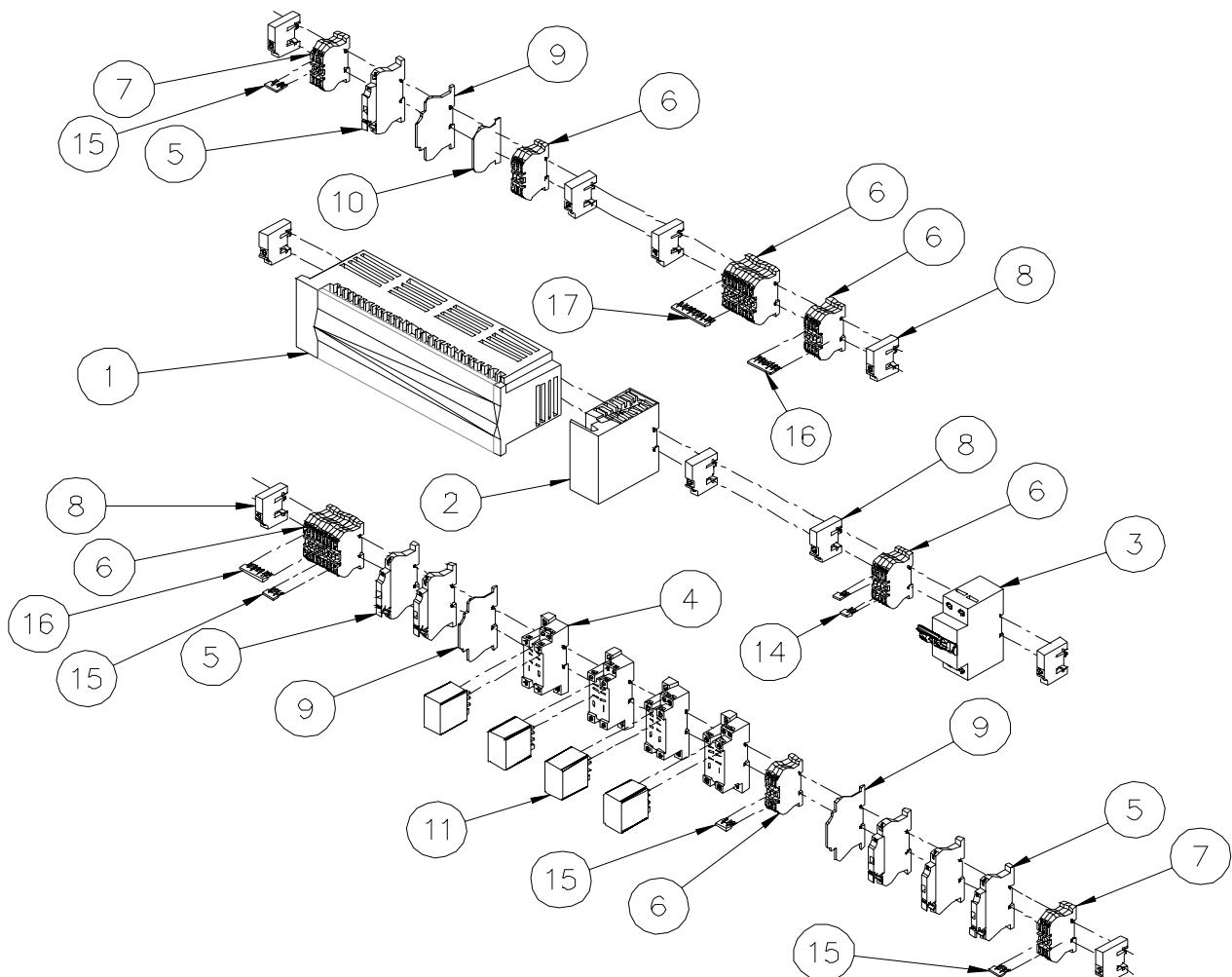
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**ELECTRICAL COMPONENTS (PLC ENCLOSURE) (Fig. 8-7)
PLC / BREAKER / TERMINAL BLOCK ASSEMBLY**

ITEM	PART NO.	QTY.	DESCRIPTION
1	98013-001	1	PLC, MITSUBISHI, FX2N-80MR-ES/UL
1**	98020-076	1	PLC, BACK UP BATTERY (Not Shown)
2	98013-004	1	OUTPUT EXT. BLOCK, MITSUBISHI, FX2N-16EYT
3	98004-003	1	BREAKER, 2 POLE, 25 AMP, MINITURE, ELFA AEG
4	98002-005	4	RELAY SOCKET, PRESSURE CLAMP TYPE
5	98001-012	6	FUSE BLOCK, ENTRELEC
6	98001-010	33	TERMINAL BLOCK, ENTRELEC
7	98001-013	6	GROUND TERMINAL, ENTRELEC
8	98001-014	10	END STOP, ENTRELEC, SCREW TYPE
9	98001-020	3	SIDE COVER, FUSE BLOCK, ENTRELEC
10	98001-015	1	END SECTION, TERMINAL BLOCK
11	98002-007	4	RELAY, DPDT, 10 AMP, 24 VOLT DC
12	98001-019	1	JUMPER, 3 POLE, FUSE BLOCK (NOT SHOWN)
13	98001-021	1	JUMPER, 2 POLE, FUSE BLOCK (NOT SHOWN)
14	98001-016	2	JUMPER, 2 POLE, TERMINAL BLOCK
15	98001-017	4	JUMPER, 3 POLE, TERMINAL BLOCK
16	98001-018	2	JUMPER, 6 POLE, TERMINAL BLOCK
17	98001-024	1	JUMPER, 8 POLE, TERMINAL BLOCK
18	98004-007	5	FUSE, 3.15 AMP, FAST ACTING, 5X20 MM (NOT SHWN)
19	98004-006	1	FUSE, 6 AMP, FAST ACTING, 5X20 MM (NOT SHOWN)

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FIG. 8-7



NOTE: JUMPERS (2 POLE AND 3 POLE) SPRING FUSE BLOCK NOT SHOWN (ITEMS 12 AND 13)
6 AMP FUSE AND 3.15 AMP FUSE NOT SHOWN (ITEMS 18 AND 19)

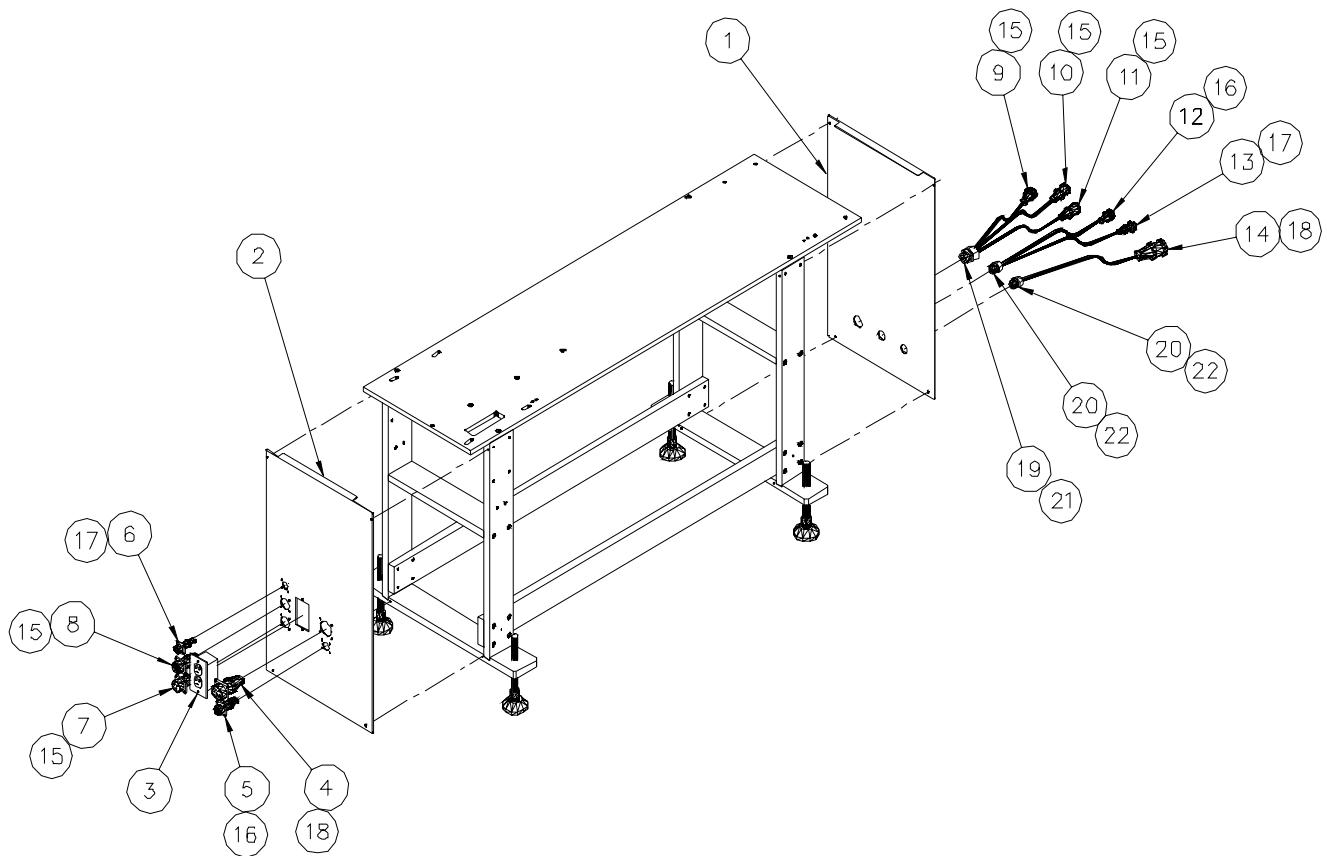
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ELECTRICAL COMPONENTS (TURNOVER) (Fig. 8-8)

ITEM	PART NO.	QTY.	DESCRIPTION
1	20013-004	1	COVER, END (INFEED)
2	20013-005	1	COVER, END (DISCHARGE)
3	98016-030	1	OUTLET ASSEMBLY (DISCHARGE COVER)
	98016-030	1	RECPETICAL, 110 V STANDARD OUTLET
	98016-031	1	CONDUIT BOX
	98016-032	1	COVER PLATE
	98015-006	1	STRAIN RELIEF, 3/8
4	98016-009	1	RECEPTACLE, SQ FLANGE, AMP, SERIES 3, 23-7 REV.
5	98016-006	1	RECEPTACLE, SQ FLANGE, AMP, SERIES 1, 13-9 STD.
6	98016-011	1	RECEPTACLE, SQ FLANGE, AMP, SERIES 1, 11-4 REV.
7	98016-002	1	RECEPTACLE, SQ FLANGE, AMP, SERIES 3, 17-3 REV.
8	98016-010	1	RECEPTACLE, SQ FLANGE, AMP, SERIES 1, 17-16 STD.
9	98016-012	1	PLUG, AMP, SERIES 1, 17-16 STD.
10	98016-003	1	PLUG, AMP, SERIES 3, 17-3 STD
11	98016-004	1	PLUG, AMP, SERIES 3, 17-3 REV.
12	98016-007	1	PLUG, AMP, SERIES 1, 13-9 STD
13	98016-029	1	PLUG, AMP, SERIES 1, 11-4 REV
14	98016-013	1	PLUG, AMP, SERIES 3, 23-7 REV.
15	98016-005	5	BACKSHELL, PLASTIC, SIZE 17
16	98016-008	2	BACKSHELL, PLASTIC, SIZE 13
17	98016-015	2	BACKSHELL, PLASTIC, SIZE 11
18	98016-014	2	BACKSHELL, PLASTIC, SIZE 23
19	98015-002	1	STRAIN RELIEF, 3/4"
20	98015-001	2	STRAIN RELIEF, 1/2"
21	98015-004	1	NUT, LOCK, 3/4
22	98015-003	2	NUT, LOCK, 1/2
23	NOT SHOWN	20	POP RIVOT, #6

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FIG. 8-8



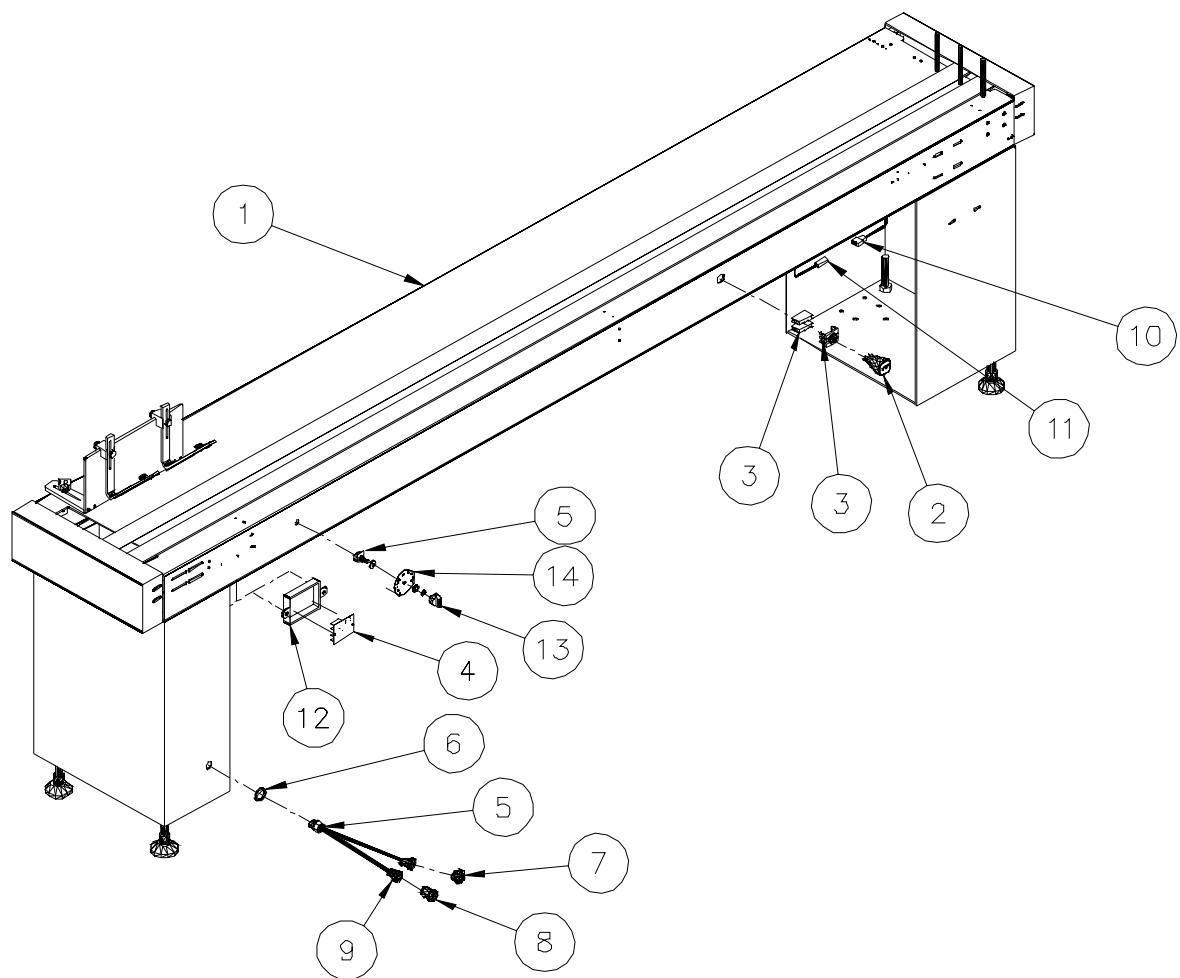
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**ELECTRICAL COMPONENTS (Fig. 8-9)
(SHINGLE CONVEYOR)**

ITEM	PART NO.	QTY.	DESCRIPTION
1	REF.	1	SHINGLE CONVEYOR
2	98000-016	1	STOP BUTTON, PUSH / PULL, MUSHROOM HEAD
3	98000-017	1	CONTACT BLOCK, 1 X NO + 1 X NC + CLIP
4	98006-001	1	SPEED CONTROL BOARD
5	98015-001	1	STRAIN RELIEF, 1/2"
6	98015-003	1	NUT, LOCK, 1/2
7	98016-012	1	PLUG, AMP, SERIES 1, 17-16 STD.
8	98016-004	1	PLUG, AMP, SERIES 3, 17-3 REV.
9	98016-005	2	BACKSHELL, PLASTIC, SIZE 17
10	98016-023	1	MALE CONNECTOR, 2 PIN
11	98016-024	1	FEMALE CONNECTOR, 2 PIN
12	98014-005	1	COVER, SPEED CONTROL BOARD
13	99004-015	1	KNOB, SPEED POT, SHINGLE CONVEYOR
14	98006-004	1	DIAL, SPEED POT

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FIG. 8-9



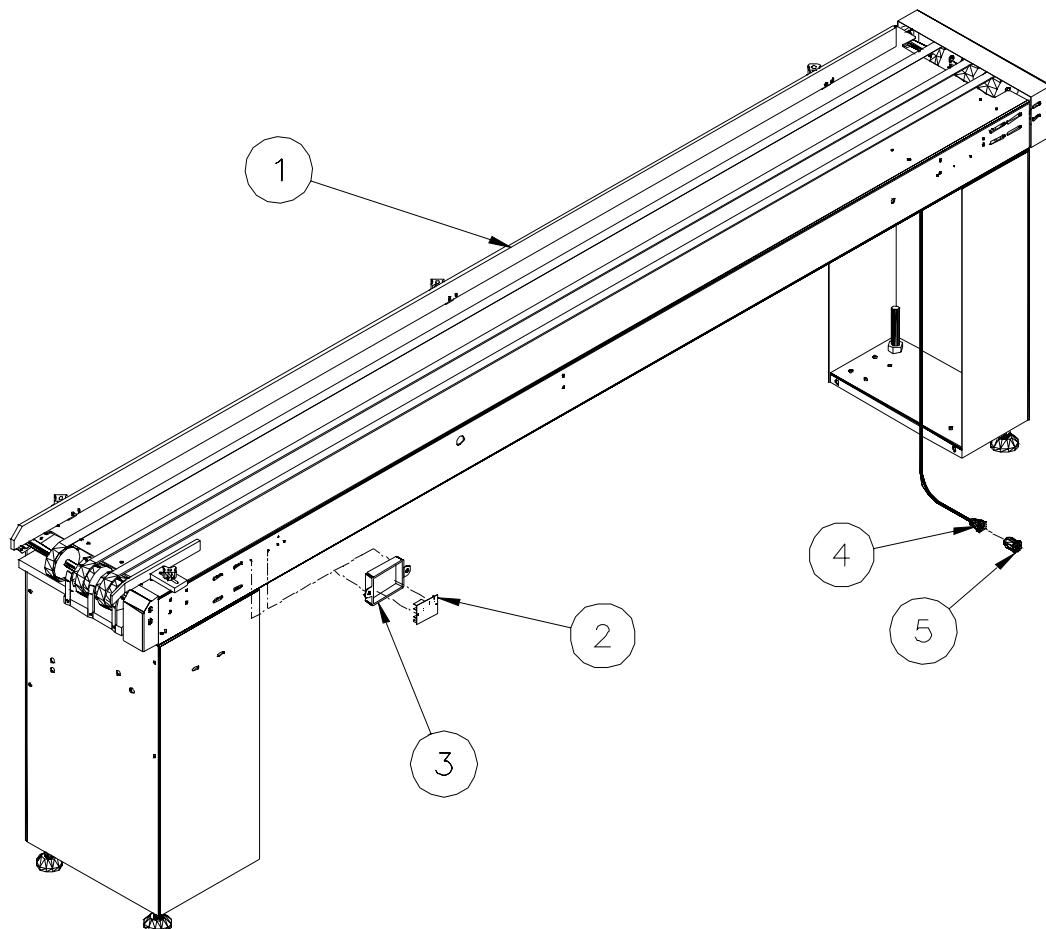
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ELECTRICAL COMPONENTS (Fig. 8-10)
(INFEED CONVEYOR)

ITEM	PART NO.	QTY.	DESCRIPTION
1	REF.	1	INFEED CONVEYOR
2	98006-001	1	SPEED CONTROL BOARD
3	98014-005	1	COVER, SPEED CONTROL BOARD
4	98016-004	1	PLUG, AMP, SERIES 3, 17-3 REV.
5	98016-005	1	BACKSHELL, PLASTIC, SIZE 17
6	98016-023	2	MALE CONNECTOR, 2 PIN (NOT SHOWN)
7	98016-024	2	FEMALE CONNECTOR, 2 PIN (NOT SHOWN)

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FIG. 8-10

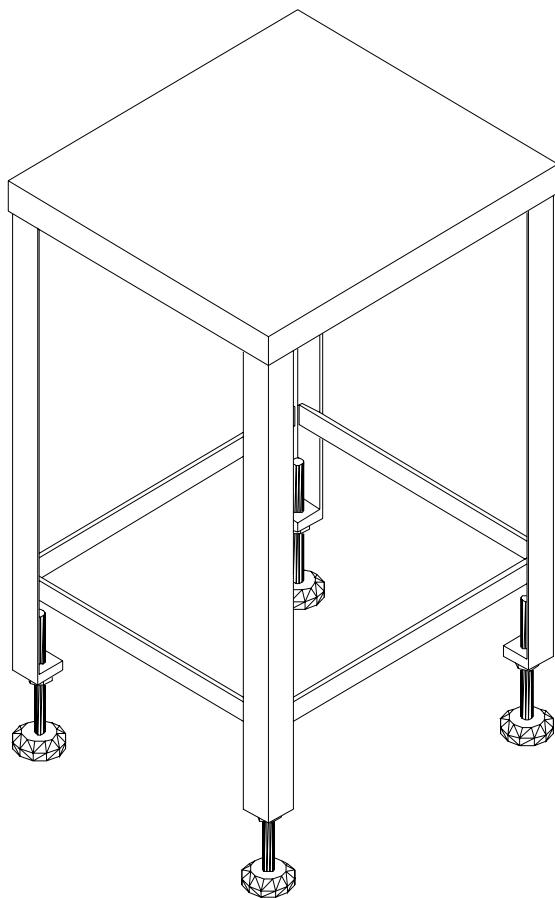


NOTE: MALE /FEMALE 2 PIN CONNECTORS NOT SHOWN (ITEM 6 AND 7)

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METER STAND



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METER STAND (Fig. 9-1)

ITEM	PART NO.	QTY.	DESCRIPTION
1	19000-004	1	BASE, METER STAND
2	99010-007	4	FOOT, ADJUSING, 1/2-13 X 6
3		4	NUT, HEX HD, 1/2-13

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FIG. 9-1

