

FORCE FLEX FEEDER

Parts Manual



SURE-FEED ENGINEERING

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14" FORCE FLEX FEEDER

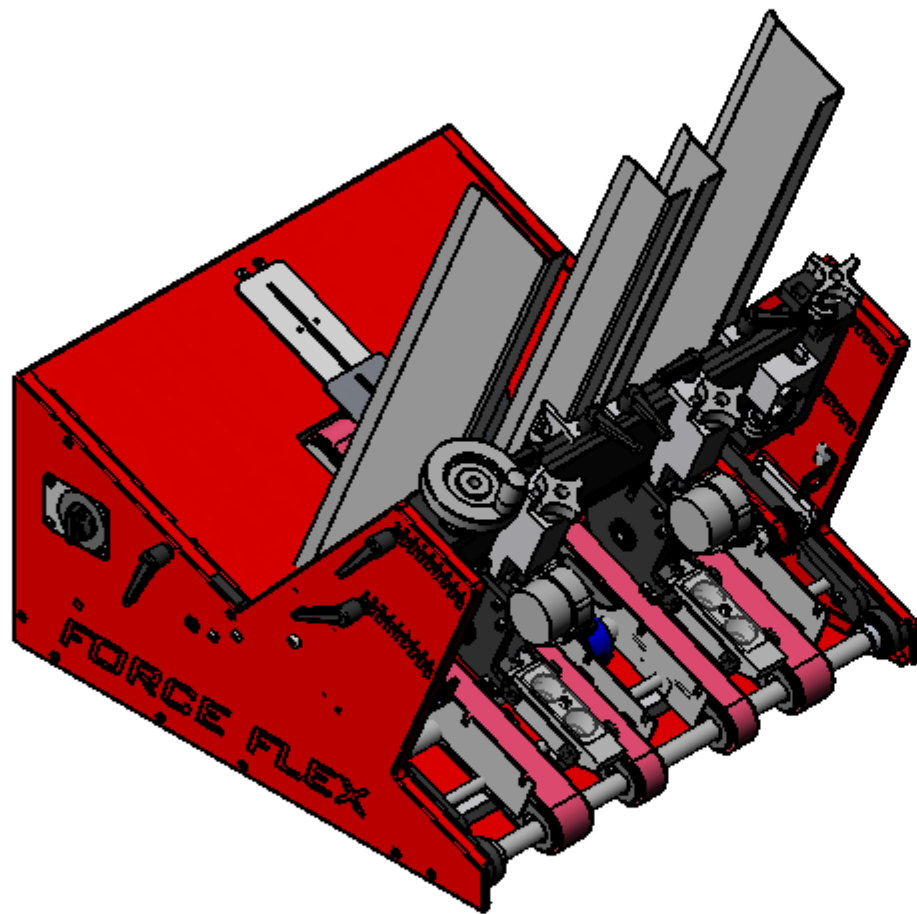


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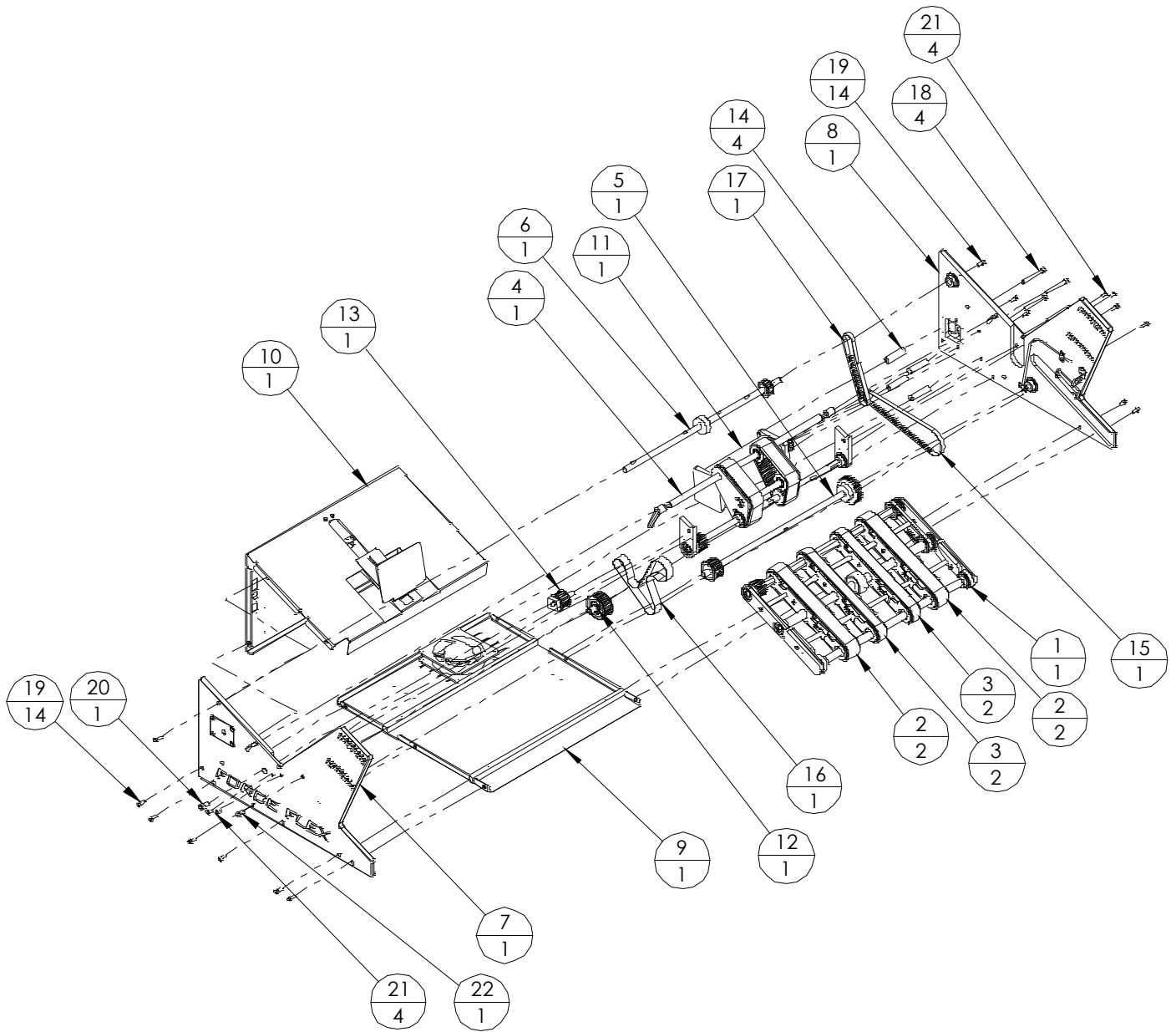
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14" FORCE FLEX FEEDER ASSEMBLY (Fig. 1)
(10022-015)

ITEM	PART NO.	QTY.	DESCRIPTION
1	SEE FIG. 3	1	ASSY, TRANSPORT BELT CARRIAGE (10020-336)
2	SEE FIG. 4	2	ASSY, BELT TRACK, WIDE (10020-337)
3	SEE FIG. 5	2	ASSY, BELT TRACK, NARROW (10020-351)
4	SEE FIG. 6	1	ASSEMBLY, ELEVATOR (10020-338)
5	SEE FIG. 7	1	ASSEMBLY, DRIVE SHAFT (10020-340)
6	SEE FIG. 7	1	ASSEMBLY, CAM SHAFT (10020-341)
7	SEE FIG. 12	1	ASSY, RH SIDEFRAE (10020-406)
8	SEE FIG. 12	1	ASSY, LH SIDEFRAE (10020-407)
9	SEE FIG. 13	1	ASSY, BOTTOM PLATE (10020-412)
10	SEE FIG. 14	1	ASSY, TOP COVER (10020-415)
11	SEE FIG. 13	1	ASSY, DRIVR MOTOR (10020-426)
12	SEE FIG. 15	1	ASSY, IDLER, CARRIAGE (10020-423)
13	SEE FIG. 15	1	ASSY, TENSIONER, CARRIAGE (10020-424)
14	10012-037	4	STANDOFF, DC MOTOR
15	99000-093	1	BELT, TIMING, 200XL037
16	99000-308	1	BELT, TIMING, DBL SIDE, 230XL075
17	99000-056	1	BELT, TIMNG, 140XL037
18	-	4	SCREW, SKT HEAD, 1/4-20 X 2-1/4
19	-	14	SCREW, SKT HEAD, #10-24 X 1/2
20	-	1	SCREW, SKT HEAD, 5/16-18 X 1/2
21	-	4	SCREW, BUTTON HEAD, #10-24 X 3/8
22	-	1	SCREW, BUTTON HEAD, 1/4-20 X 1/2

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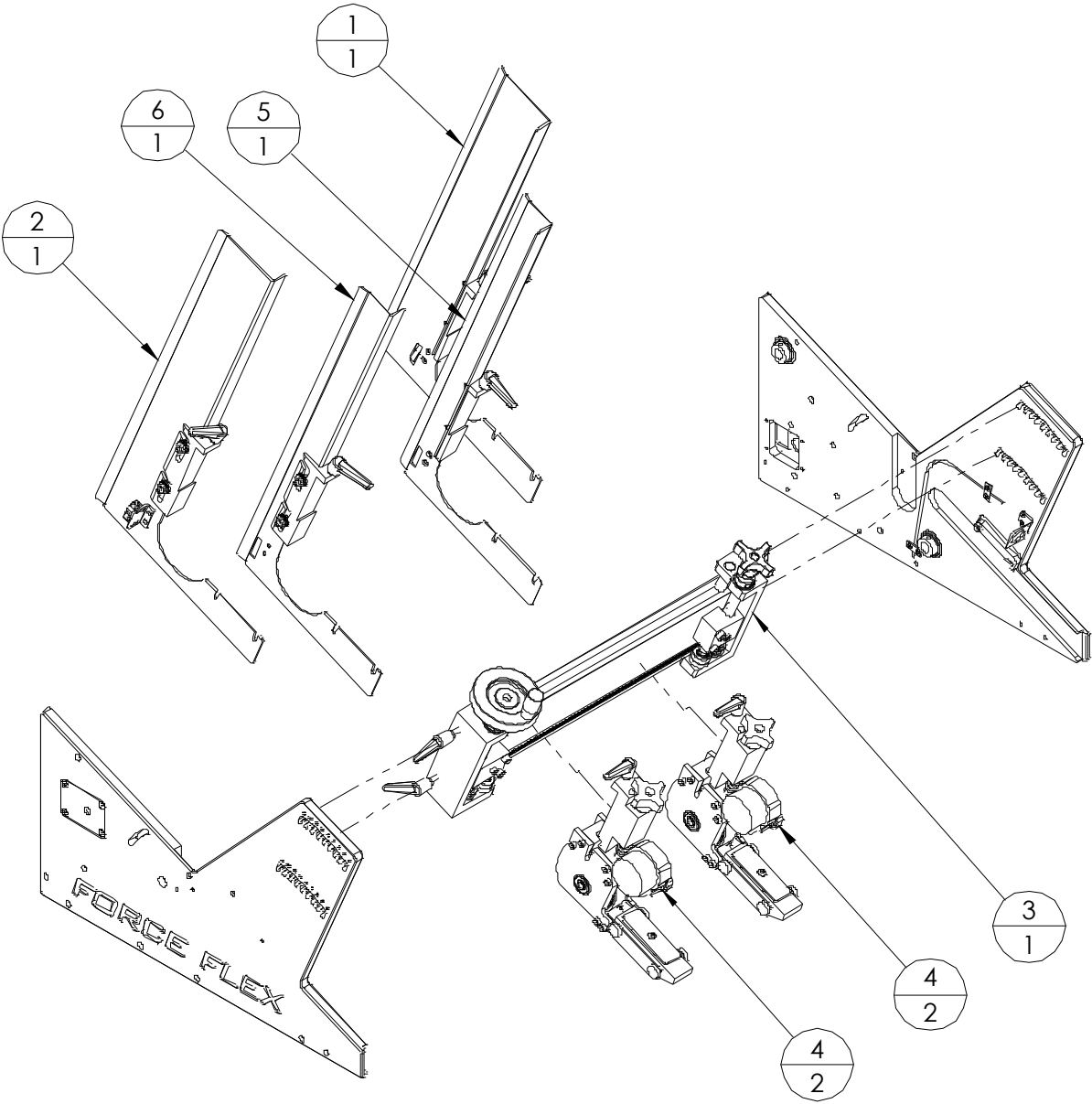


14" FORCE FLEX FEEDER ASSEMBLY (Fig. 2)
(10022-015)

ITEM	PART NO.	QTY.	DESCRIPTION
1	SEE FIG. 10	1	ASSY, SIDE GUIDE , LH (10020-342)
2	SEE FIG. 10	1	ASSY, SIDE GUIDE, RH (10020-343)
3	SEE FIG. 8	1	ASSY, ADJUSTABLE CROSSBAR (10020-335)
4	SEE FIG. 9	2	ASST, SEPERATOR (10020-339)
5	SEE FIG. 11	1	ASSY, SIDE GUIDE, LH NARROW (10020-352)
6	SEE FIG. 11	1	ASSY, SIDE GUIDE, RH NARROW (10020-353)

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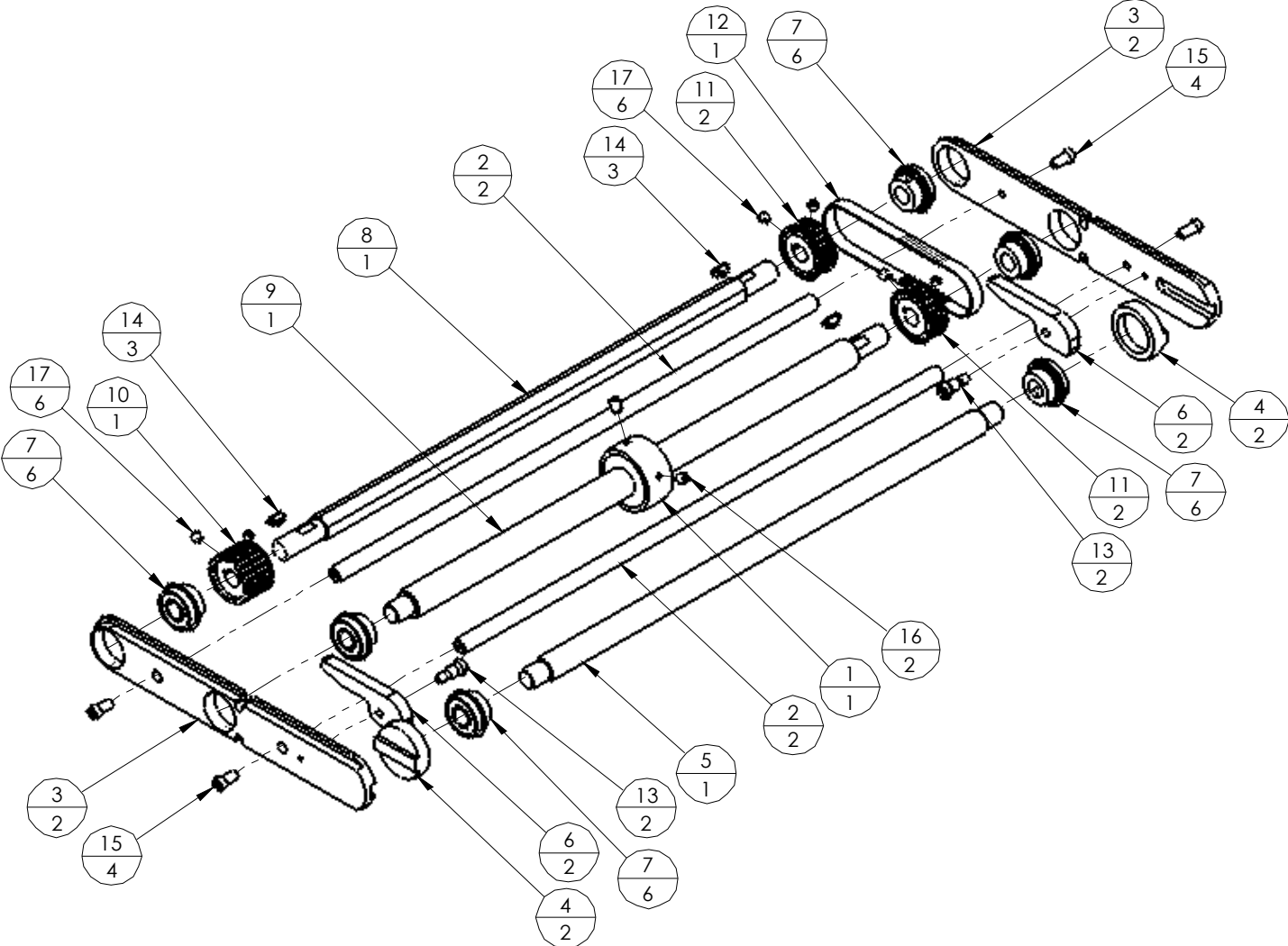


14" FORCE FLEX FEEDER (Fig. 3)
TRANSPORT BELT CARRIAGE ASSEMBLY (10020-366)

ITEM	PART NO.	QTY.	DESCRIPTION
1	10006-070	1	ROLLER, NIP, 3/4"
2	10004-223	2	SHAFT, BELT TRACK SUPPORT
3	10011-058	2	PLATE, CARRIAGE, SIDE
4	10007-116	2	BLOCK, ADJ BEARING
5	10004-220	1	SHAFT, FRONT IDLER
6	10016-006	2	CAM, BELT TENSIONER
7	99003-093	6	BEARING, 1/2 X 1-1/8, SEALED W/ LOCKING COLLAR
8	10004-221	1	SHAFT, HEX DRIVE
9	10004-222	1	SHAFT, NIP SUPPORT
10	10006-114	1	PULLEY, TIMING, 22XL075 W/ RECESS
11	99002-054	2	PULLEY, TIMING, 20XL037, 1/2 BORE W/ KEYWAY
12	99000-003	1	BELT, TIMING, 120XL027
13	99033-004	2	SHOULDER BOLT, 1/4 X 3/8
14	99034-004	3	KEY, WOODRUFF, 1/2 X 1/8
15	-	4	SCREW, SKT HEAD, #10-24 X 1/2
16	-	2	SET SCREW, FLAT, #10-24 X 3/8
17	-	6	SET SCREW, CUP, #10-24 X 1/4

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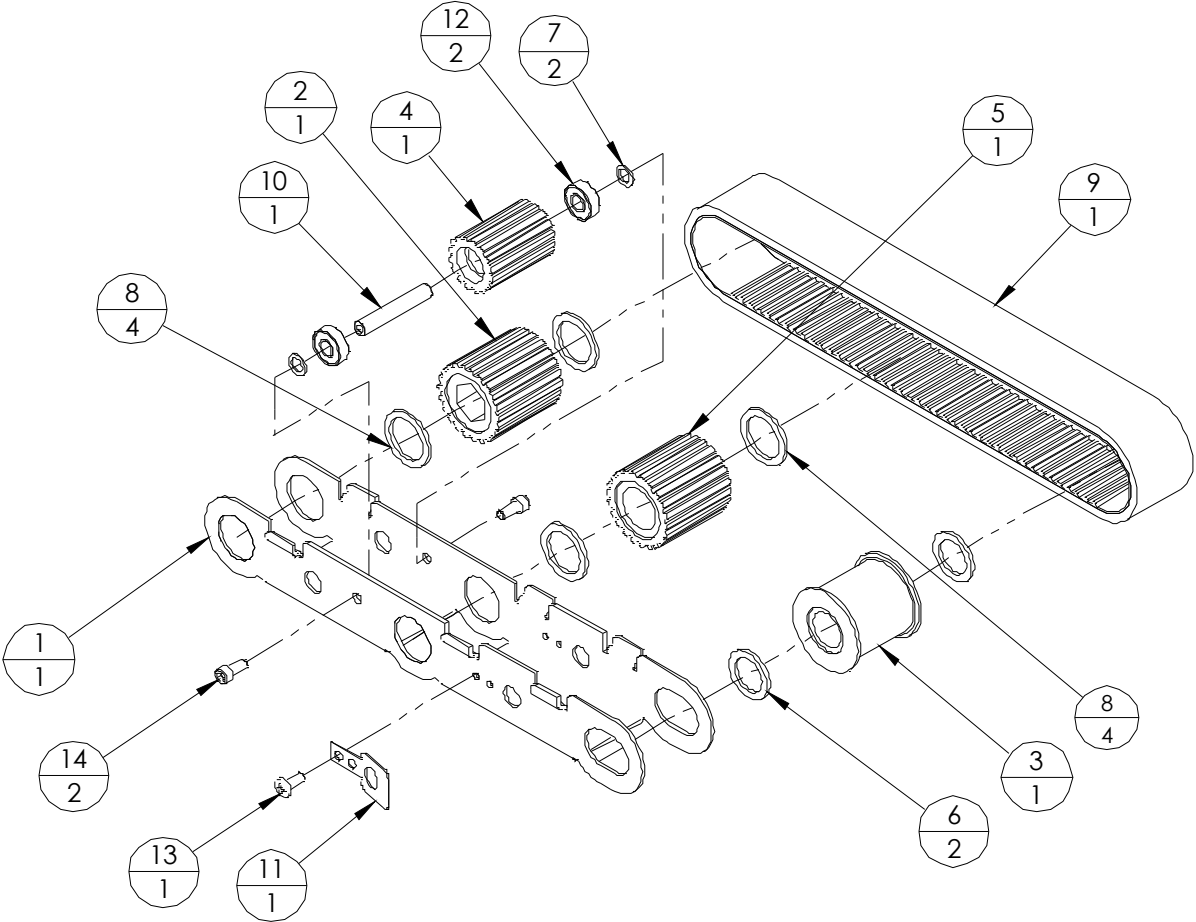
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14" FORCE FLEX FEEDER (Fig. 4)
WIDE BELT TRACK ASSEMBLY (10020-337)

ITEM	PART NO.	QTY.	DESCRIPTION
1	10000-077	1	FRAME, BELT TRACK
2	10006-110	1	PULLEY, BELT TRACK DRIVE
3	10006-111	1	PULLEY, BELT TRACK IDLER
4	10006-113	1	PULLEY, BELT IDLER SUPPORT
5	10006-112	1	PULLEY, BELT TRACK SUPPORT
6	99003-021	2	WASHER, NYLON, 5/8 X 1/16
7	99003-032	2	WASHER, NYLON, 1/4 X 1/32
8	99003-082	4	WASHER, NYLON, 3/4 X 1/16
9	10014-042	1	BELT, FEEDER TRANSPORT, 214XL
10	10004-202	1	SHAFT, IDLER SUPPORT
11	10011-055	1	PLATE, SPRING, LOCATING
12	99003-002	2	BEARING, SEALED, 1/4 X 5/8
13	-	1	#8 SHEET METAL SCREW, SELF TAPPING
14	-	2	SCREW, SKT HEAD, #8-32 X 3/8

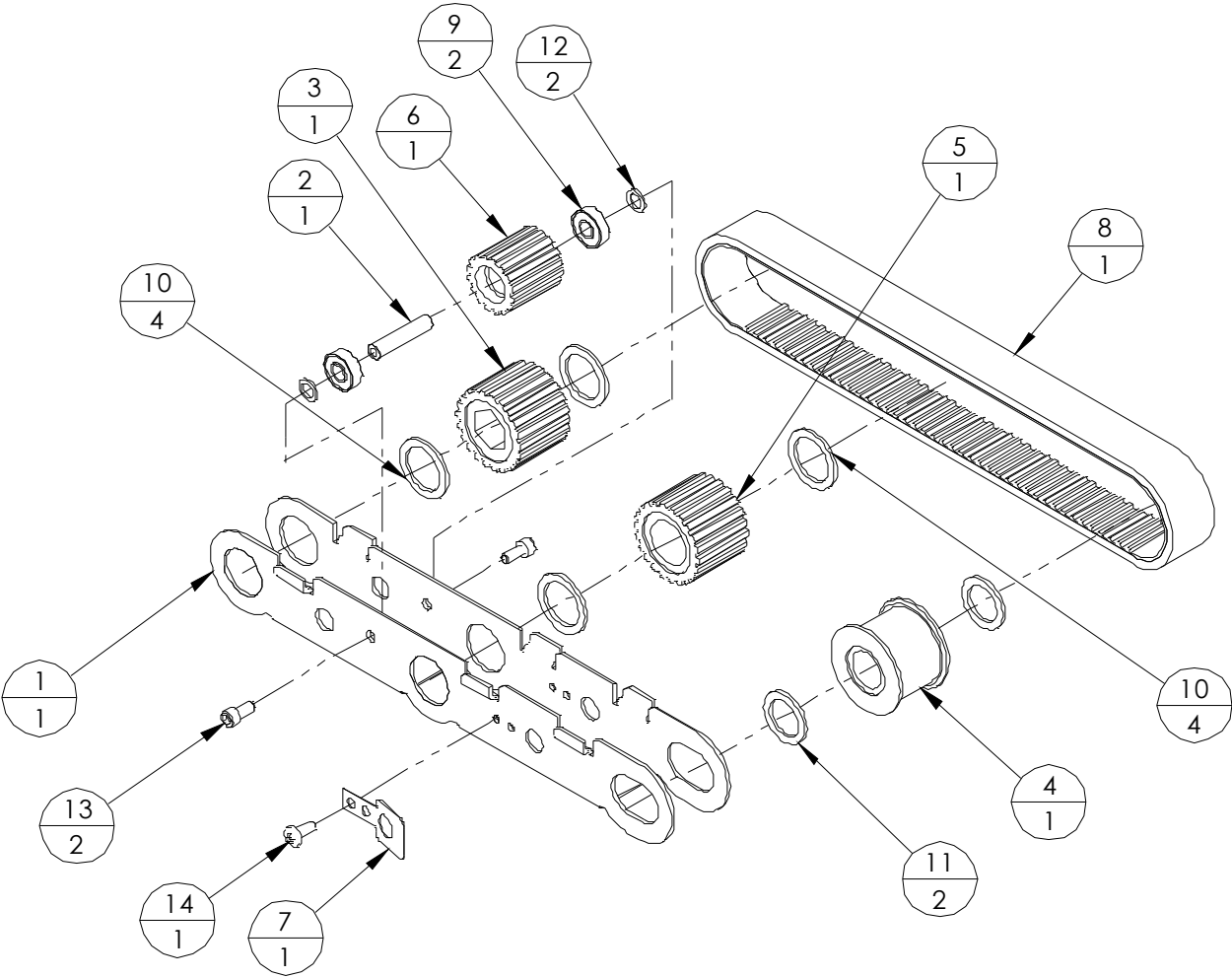
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14" FORCE FLEX FEEDER (Fig. 5)
NARROW BELT TRACK ASSEMBLY (10020-351)

ITEM	PART NO.	QTY.	DESCRIPTION
1	10000-080	1	FRAME, BELT TRACK, NARROW
2	10004-232	1	SHAFT, IDLER SUPPORT, NARROW
3	10006-119	1	PULLEY, BELT TRACK DRIVE, NARROW
4	10006-120	1	PULLEY, BELT TRACK IDLER, NARROW
5	10006-121	1	PULLEY, BELT TRACK SUPPORT, NARROW
6	10006-122	1	PULLEY, BELT IDLER SUPPORT, NARROW
7	10011-055	1	PLATE, SPRING LOCATING
8	10014-044	1	BELT, FEEDER TRANSPORT, 214XL, 7/8 WIDE
9	99003-002	2	BEARING, SEALED, 1/4 X 5/8
10	99003-082	4	WASHER, NYLON, 3/4 X 1/16
11	99003-021	2	WASHER, NYLON, 5/8 X 1/16
12	99003-034	2	WASHER, NYLON, 1/4 X 1/32
13	-	2	SCREW, SKT HEAD, #8-32 X 3/8
14	-	1	#8 SHEET METAL SCREW, SELF TAPPING

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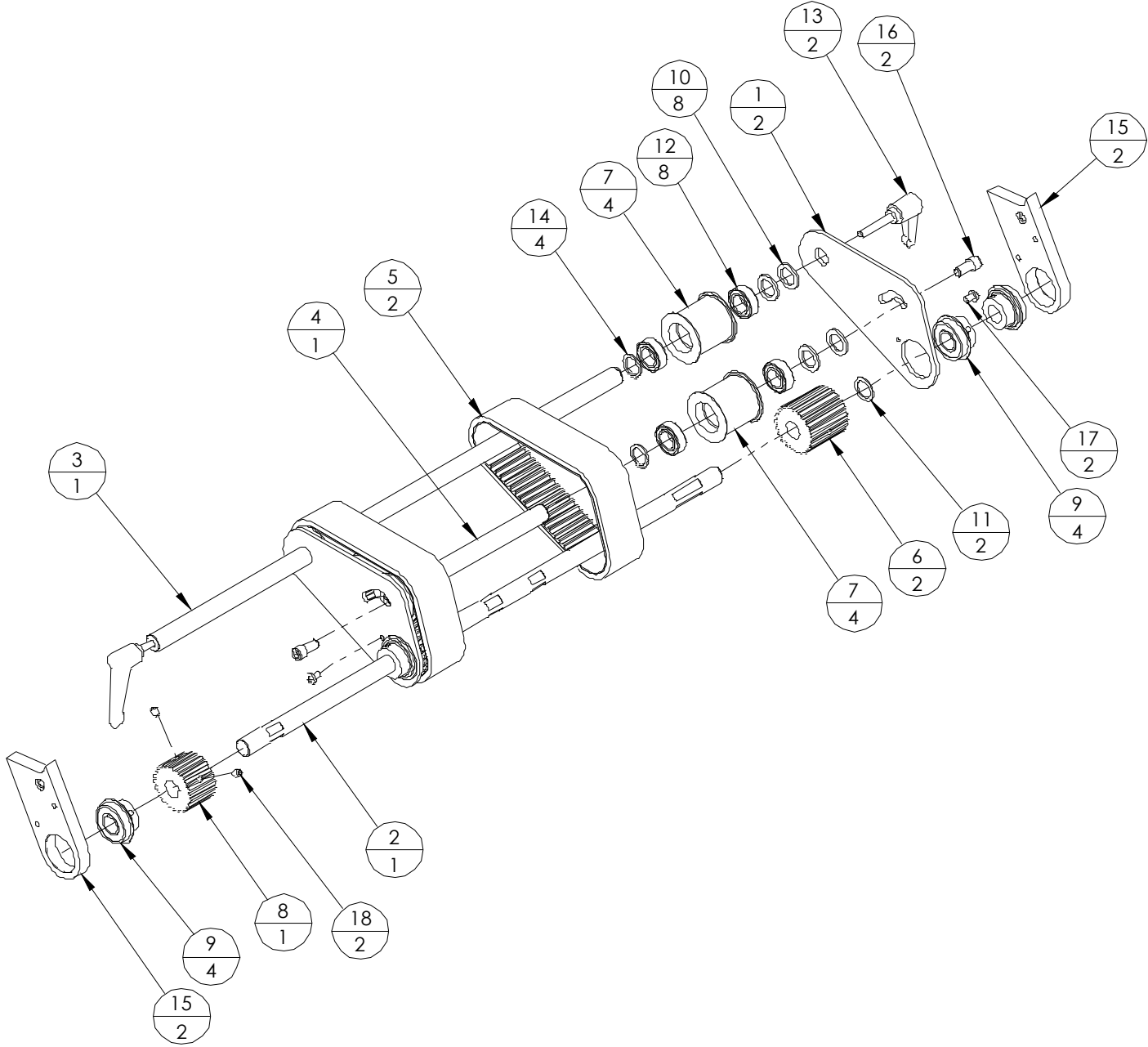


**14" FORCE FLEX FEEDER (Fig. 6)
ELEVATOR ASSEMBLY (10020-338)**

ITEM	PART NO.	QTY.	DESCRIPTION
1	10011-061	2	PLATE, ELEVATOR SIDE
2	10004-228	1	SHAFT, FEEDER DRIVE
3	10004-230	1	SHAFT, ELEVATOR ADJ.
4	10004-229	1	SHAFT, ELEVATOR IDLER
5	10014-043	2	BELT, ELEVATOR, 130XL, 1.25" WIDE
6	10006-116	2	PULLEY, TIMING, 22XL125, 1/2" BORE
7	10006-115	4	PULLEY, ELEVATOR IDLER
8	10006-114	1	PULLEY, DRIVE, 22XL075 W/ RECESS
9	99003-093	4	BEARING, 1/2 X 1-1/8, SEALED W/ LOCKING COLLAR
10	99003-018	8	WASHER, NYLON, 1/2 X 1/16
11	99003-032	2	WASHER, NYLON, 1/2 X 1/32
12	99003-046	8	BEARING, 1/2 X 7/8
13	99004-027	2	HANDLE, ADJ, #10-24 X 1.18
14	99022-004	4	SNAP RING, 1/2"
15	10007-121	2	BLOCK, ELEVATOR BEARING
16	-	2	SCREW, SKT HEAD, 1/4-20 X 1/2
17	-	2	SCREW, SHEET METAL, #8-32 X 3/8
18	-	2	SET SCREW, CUP, #10-24 X 1/4

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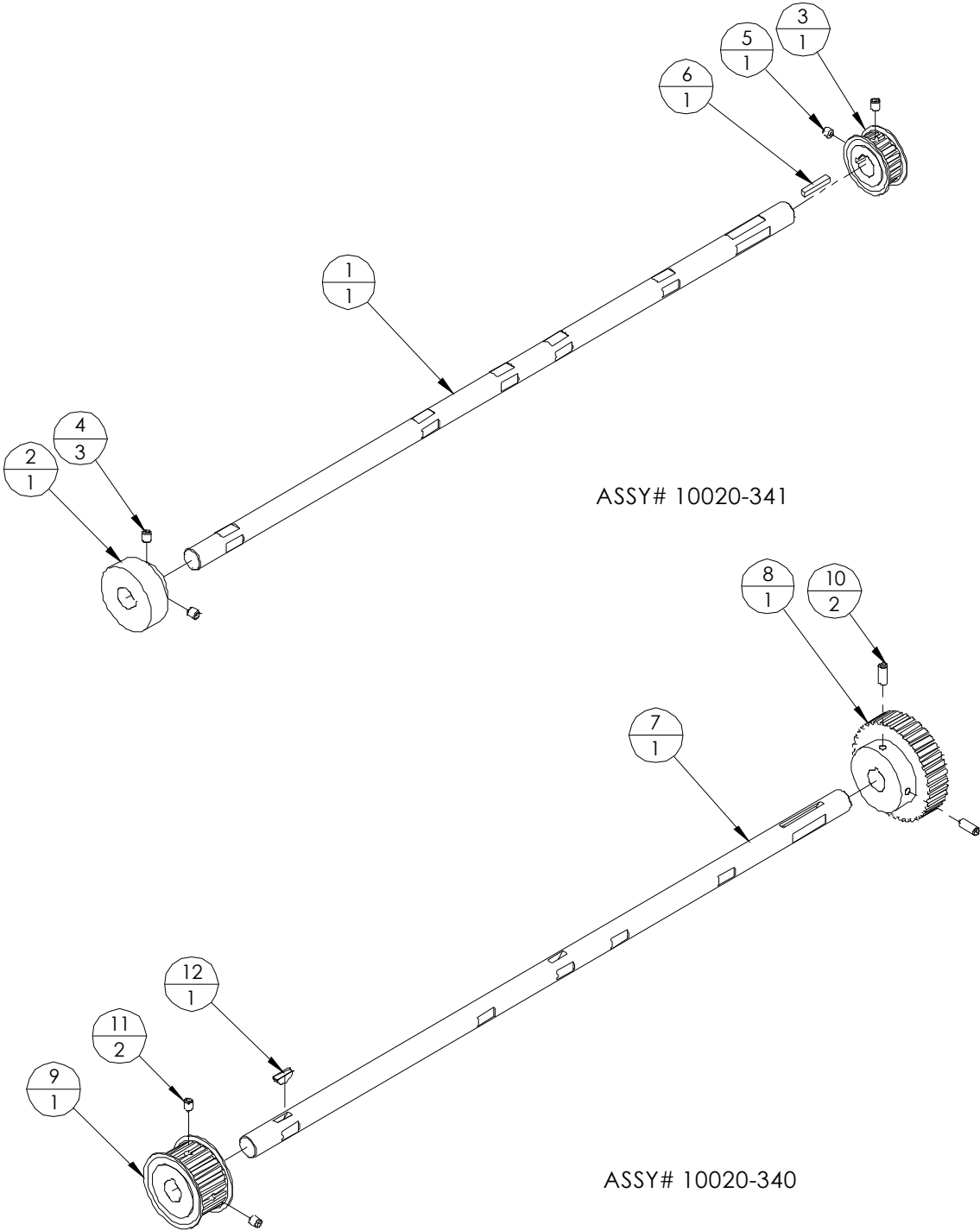
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**14" FORCE FLEX FEEDER (Fig. 7)
CAM AND DRIVE SHAFT ASSEMBLIES**

ITEM	PART NO.	QTY.	DESCRIPTION
	10020-341	1	ASSEMBLY, CAM SHAFT
1	10004-228	1	SHAFT, FEEDER DRIVE
2	10006-048	1	CAM, VIBRATING TOP PLATE
3	99002-026	1	PULLEY, TIMING, 18XL037, 1/2 BORE
4	-	3	SET SCREW, CUP, #8-32 X 1/4
5	-	1	SET SCREW, CUP, #8-32 X 3/16
6	99034-003	1	KEY, SQUARE, 1/8 X 3/4
	10020-340	1	ASSEMBLY, DRIVE SHAFT
7	10004-228	1	SHAFT, FEEDER DRIVE
8	99002-005	1	PULLEY, TIMING, 36XL037, 1/2 BORE
9	99002-131	1	PULLEY, TIMING, 24XL075, 1/2 BORE W/ 1/8 KEYWAY
10	99034-004	1	KEY, WOODRUFF, 1/2 X 1/8
11	-	2	SET SCREW, CUP, #10-24 X 1/2
12	-	2	SET SCREW, CUP, #10-24 X 1/4

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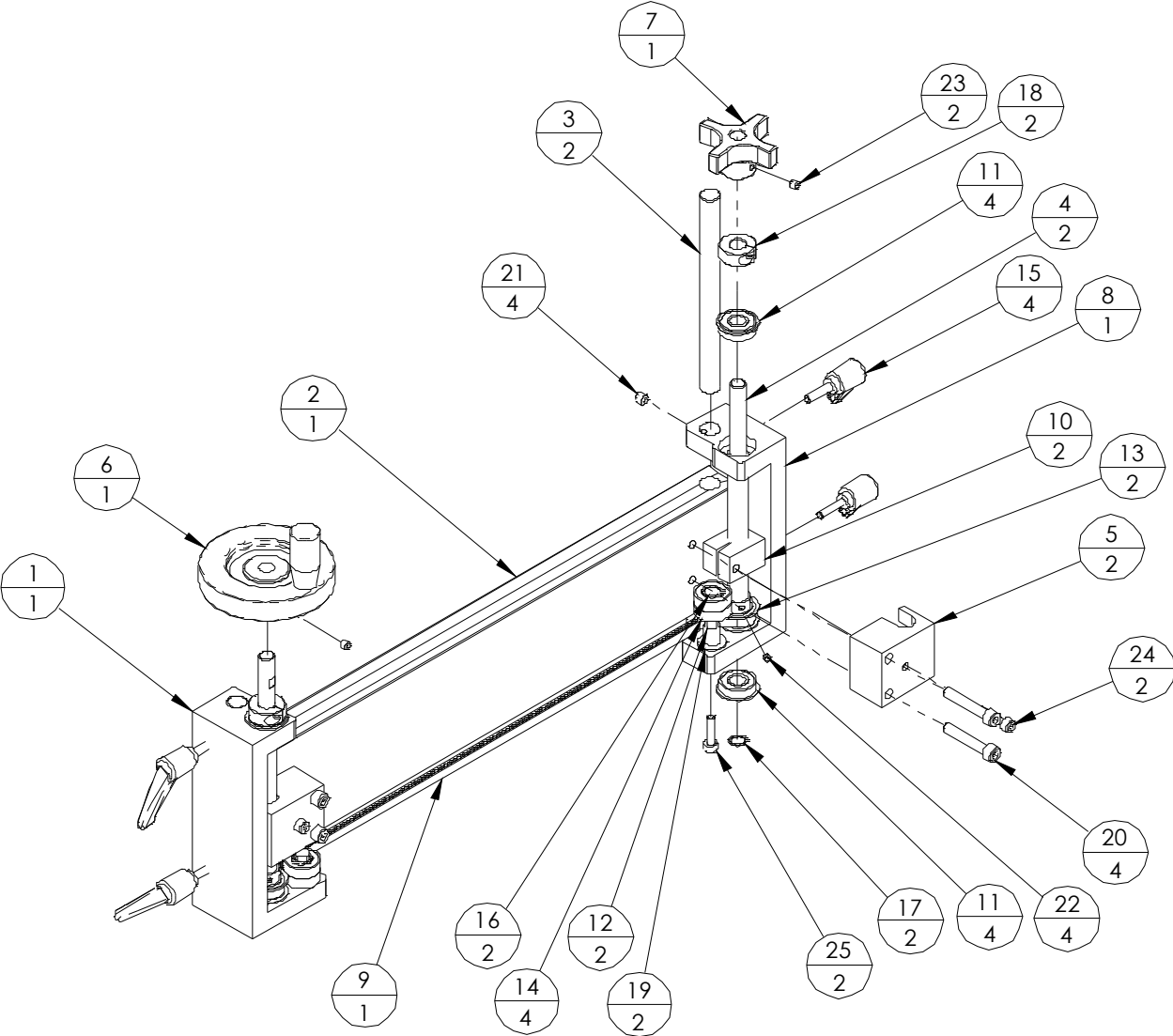


14" FORCE FLEX FEEDER (Fig. 8)
ADJUSTABLE CROSSBAR ASSEMBLY (10020-335)

ITEM	PART NO.	QTY.	DESCRIPTION
1	10009-076	1	BRACKET, ADJ CROSSBAR, RH
2	10003-025	1	CROSSBAR, ADJUSTABLE
3	10004-227	2	SHAFT, ADJ CROSSBAR GUIDE
4	10004-225	2	SHAFT, THREADED, CROSSBAR ADJUSTING
5	10007-118	2	BLOCK, ADJUSTMENT NUT RETAINER
6	99004-008	1	HANDWHEEL, 3.15 O.D, 3/8 BORE W/ HANDLE
7	99004-032	1	KNOB, 2" O.D, 3/8 B ALUM
8	10009-077	1	BRACKET, ADJ. CROSSBAR, LH
9	99000-297	1	BELT, TIMING, 425MXL025
10	10019-012	2	NUT, CROSSBAR ADJUSTMENT
11	99003-020	4	BEARING, 3/8 X 7/8 SEALED W/ S.R.
12	10004-226	2	SHAFT, STUB, ECCENTRIC IDLER
13	99002-142	2	PULLEY, TIMING, 32MXL025, 3/8 BORE
14	99003-001	4	BEARING, 3/8 X 7/8, SEALED
15	99004-025	4	HANDLE, RACHET, #10-24 X .078
16	99022-003	2	GRIP RING, 3/8"
17	99022-009	2	SNAP RING, 3/8 EXTERNAL
18	99017-048	2	COLLAR, ONE PIECE CLAMP, 3/8 BORE
19	99003-016	2	WASHER, NYLON, 3/8 X 1/32
20	-	4	SCREW, SKT HEAD, 1/4-20 X 1-3/8
21	-	4	SET SCREW, CUP, 1/4-28 X 1/4
22	-	4	SET SCREW, CUP, #8-32 X 1/8
23	-	2	SET SCREW, CUP, #10-24 X 3/8
24	-	2	SCREW, SKT HEAD, #10-24 X 7/8
25	-	2	SCREW, SKT HEAD, #10-24 X 3/4

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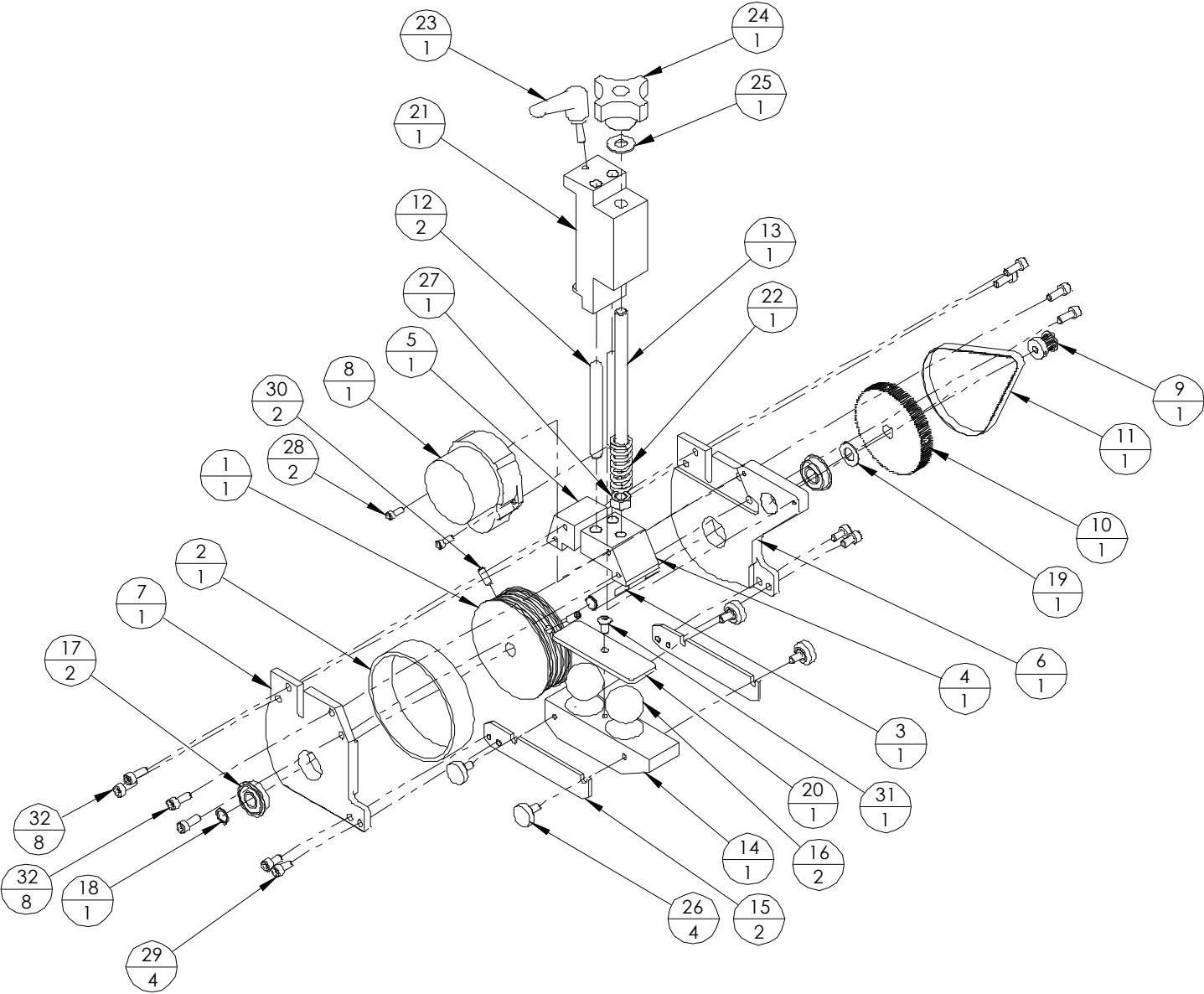


**14" FORCE FLEX FEEDER (Fig. 9)
 SEPERATOR ASSEMBLY (10020-339)**

ITEM	PART NO.	QTY.	DESCRIPTION
1	10006-001	1	WHEEL, SEPERATOR, 3"
2	10014-001	1	BELT, SEPERATOR
3	10004-224	1	SHAFT, SEPERATOR
4	10007-117	1	BLOCK, SEPERATOR MTG.
5	10007-125	1	BLOCK, SEPERATOR MTG, REAR
6	10011-060	1	PLATE, SEPERATOR, LH SIDE
7	10011-059	1	PLATE, SEPERATOR, RH SIDE
8	10018-074	1	ASSEMBLY, MOTOR SEPERATOR W/ PLUG (24 VAC)
9	99002-002	1	PULLEY, TIMNG, 16MXL025, 3/16 BORE
10	99002-001	1	PULLEY, TIMING, 100MXL025, 3/8 BORE
11	99000-311	1	BELT, TIMNG, 134MXL025
12	99006-002	2	PIN, DOWEL, 5/16 X 3
13	10004-211	1	STUD, SEPERATOR ADJUSTMENT
14	10007-119	1	BLOCK, BALL RACK
15	10008-106	2	BAR, BALL RACK MTG.
16	99037-003	2	BALL, 1" CHROME
17	99003-020	2	BEARING, 3/8 X 7/8, SEALED W/ S.R.
18	99022-009	1	SNAP RING, 3/8 EXTERNAL
19	99003-016	1	WASHER, NYLON, 3/8 X 1/32
20	10013-041	1	COVER, BALL RACK
21	10007-123	1	BLOCK, SEPERATOR ADJ.
22	99005-045	1	SPRING, SEPERATOR
23	99004-003	1	HANDLE, RATCHET, #10-24 X 5/8
24	99004-001	1	KNOB, 5/16-24 FEMALE
25	99003-015	1	WASHER, NYLON, 5/16 X 1/16
26	10020-316	4	ASSY, KNOB, #10-24 X 3/8
27	-	1	NUT, HEX, 5/16-24
28	-	2	SCREW, SKT HEAD, #6-32 X 3/8
29	-	4	SCREW, SKT HEAD, #10-24 X 3/8
30	-	2	SET SCREW, #10-24 X 1/2
31	-	1	SCREW, BUTTON HEAD, #10-24 X 3/8
32	-	8	SCREW, SKT HEAD, #10-24 X 1/2

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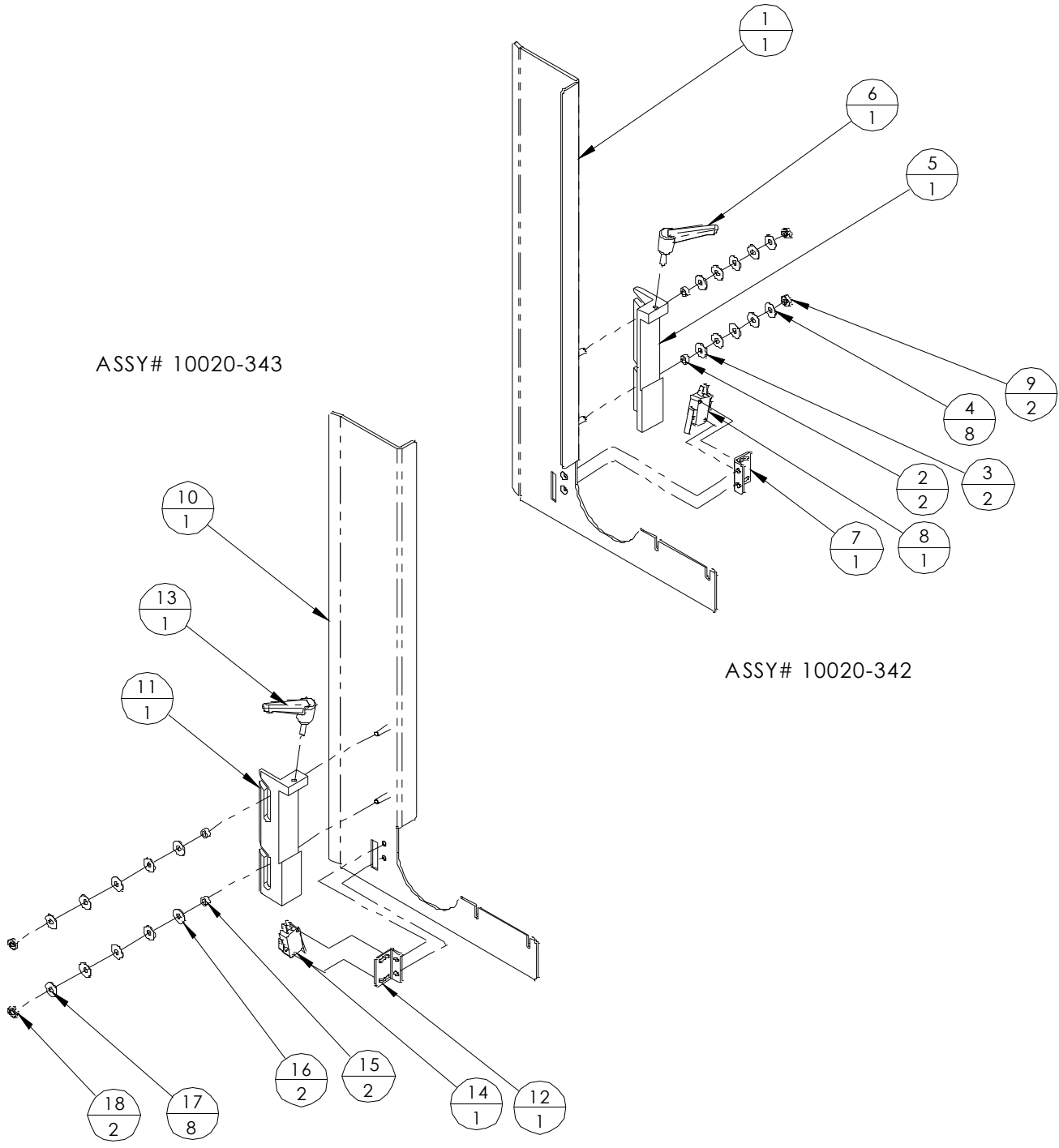


14" FORCE FLEX FEEDER (Fig. 10)
SIDE GUIDE ASSEMBLIES

ITEM	PART NO.	QTY.	DESCRIPTION
	10020-342	1	ASSEMBLY, SIDE GUIDE, LH
1	10005-179	1	SIDE GUIDE, LH
2	10012-039	2	SPACER, SIDE GUIDE MTG.
3	99003-012	2	WASHER, NYLON, .203 X .562 X .040
4	99005-058	8	SPRING WASHER, .190 X .562 X .019
5	10009-079	1	BRACKET, SIDE GUIDE MTG, LH
6	99004-003	1	HANDLE, RATCHET, #10-24 X 5/8
7	10009-089	1	BRACKET, SWITCH MTG.
8	98000-089	1	SWITCH, CHERRY
9	-	2	NUT, NYLOCK, #10-32
	10020-343	1	ASSEMBLY, SIDE GUIDE, RH
10	10005-178	1	SIDE GUIDE, RH
11	10009-078	1	BRACKET, SIDE GUIDE MTG, RH
12	10009-089	1	BRACKET, SWITCH MTG.
13	99004-003	1	HANDLE, RATCHET, #10-24 X 5/8
14	98000-089	1	SWITCH, CHERRY
15	10012-039	2	SPACER, SIDE GUIDE MTG.
16	99003-012	2	WASHER, NYLON, .203 X .562 X .040
17	99005-058	8	SPRING WASHER, .190 X .562 X .019
18	-	-	NUT, NYLOCK, #10-32

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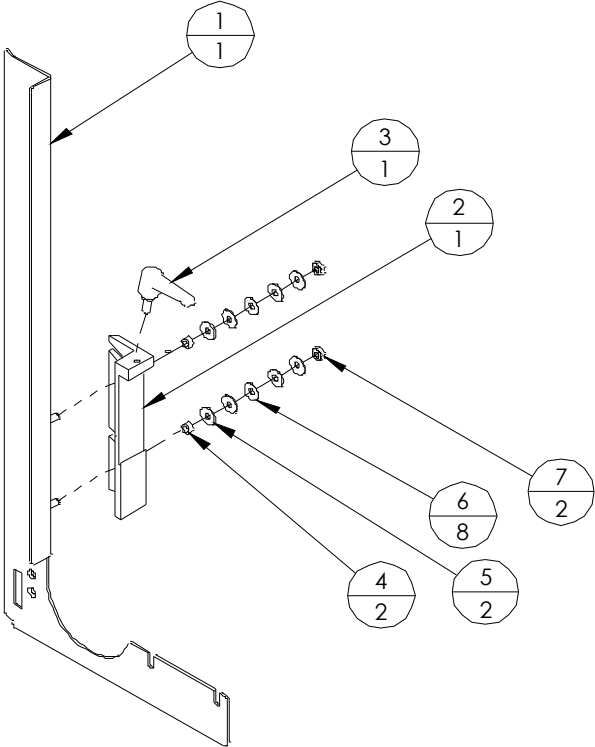


**14" FORCE FLEX FEEDER (Fig. 11)
 NARROW SIDE GUIDE ASSEMBLIES**

ITEM	PART NO.	QTY.	DESCRIPTION
	10020-352	1	ASSEMBLY, SIDE GUIDE, NARROW LH
1	10005-181	1	SIDE GUIDE, LH NARROW
2	10009-079	1	BRACKET, SIDE GUIDE MTG, LH
3	99004-003	1	HANDLE, RATCHET, #10-24 X 5/8
4	10012-039	2	SPACER, SIDE GUIDE MTG.
5	99003-012	2	WASHER, NYLON, .203 X .562 X .040
6	99005-058	8	SPRING WASHER, .190 X .562 X .019
7	-	-	NUT, NYLOCK, #10-32
	10020-353	1	ASSEMBLY, SIDE GUIDE, NARROW RH
8	10005-180	1	SIDE GUIDE, RH
9	10009-078	1	BRACKET, SIDE GUIDE MTG, RH
10	99004-003	1	HANDLE, RATCHET, #10-24 X 5/8
11	10012-039	2	SPACER, SIDE GUIDE MTG.
12	99003-012	2	WASHER, NYLON, .203 X .562 X .040
13	99005-058	8	SPRING WASHER, .190 X .562 X .019
14	-	-	NUT, NYLOCK, #10-32

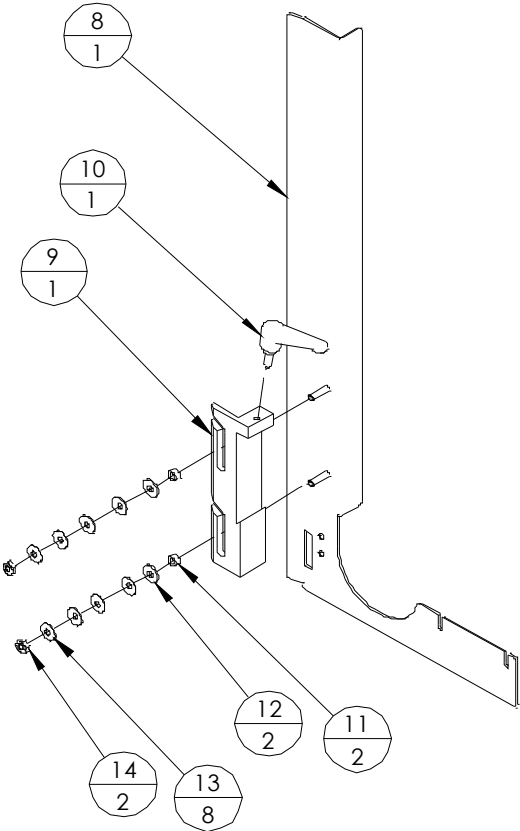
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ASSY# 10002-352

ASSY# 10002-353

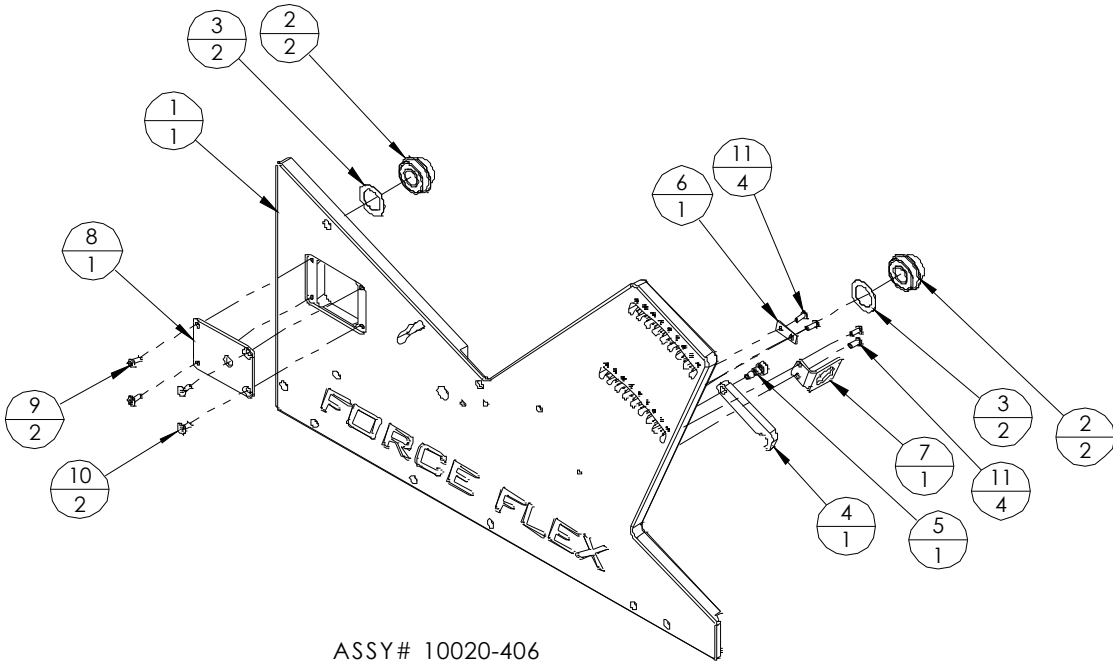


**14" FORCE FLEX FEEDER (Fig. 12)
 SIDE FRAME ASSEMBLIES**

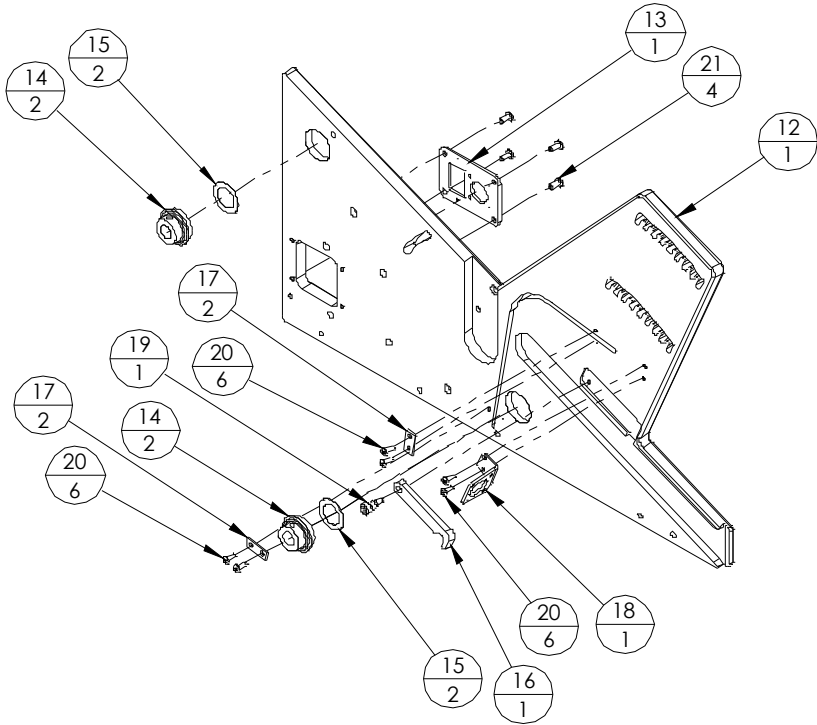
ITEM	PART NO.	QTY.	DESCRIPTION
	10020-406	1	ASSEMBLY, RH SIDEFAME
1	10000-078	1	SIDEFAME, RH
2	99003-093	2	BEARING, 1/2 X 1-1/8, SEALED W/ LOCKING COLLAR
3	99036-003	2	SHIM, BEARING, 3/4 X 1-1/8 X .009
4	10008-107	1	LATCH, CARRIAGE
5	99033-006	1	SHOULDER BOLT, 1/4 X 1/4
6	10011-068	1	PLATE, WIRE CLAMP
7	10009-082	1	BRACKET, PLUG MTG, RH
8	10011-065	1	BRACKET, SPEED POT MTG.
9	-	2	SCREW, BUTTON HEAD, #8-32 X 3/8
10	-	2	SCREW, FLAT HEAD, #8-32 X 3/8
11	-	4	SCREW, BUTTON HEAD, #6-32 X 3/8
	10020-407	1	ASSEMBLY, LH SIDEFAME
12	10000-079	1	SIDEFAME, LH
13	10011-063	1	PLATE, ELECTRICAL CONNECTOR, LH
14	99003-093	2	BEARING, 1/2 X 1-1/8, SEALED W/ LOCKING COLLAR
15	99036-003	2	SHIM, BEARING, 3/4 X 1-1/8 X .009
16	10008-107	1	LATCH, CARRIAGE
17	10011-068	2	PLATE, WIRE CLAMP
18	10009-083	1	BRACKET, PLUG MTG, LH
19	99033-006	1	SHOULDER BOLT, 1/4 X 1/4
20	-	6	SCREW, BUTTON HEAD, #6-32 X 3/8
21	-	4	SCREW, BUTTON HEAD, #8-32 X 3/8

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ASSY# 10020-406



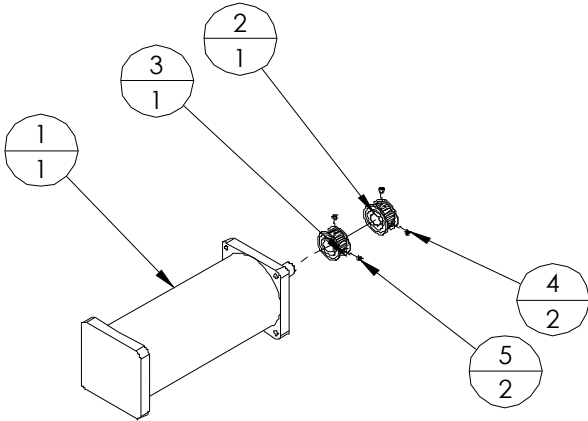
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**14" FORCE FLEX FEEDER (Fig. 13)
 BOTTOM PLATE & MOTOR DRIVE ASSEMBLIES**

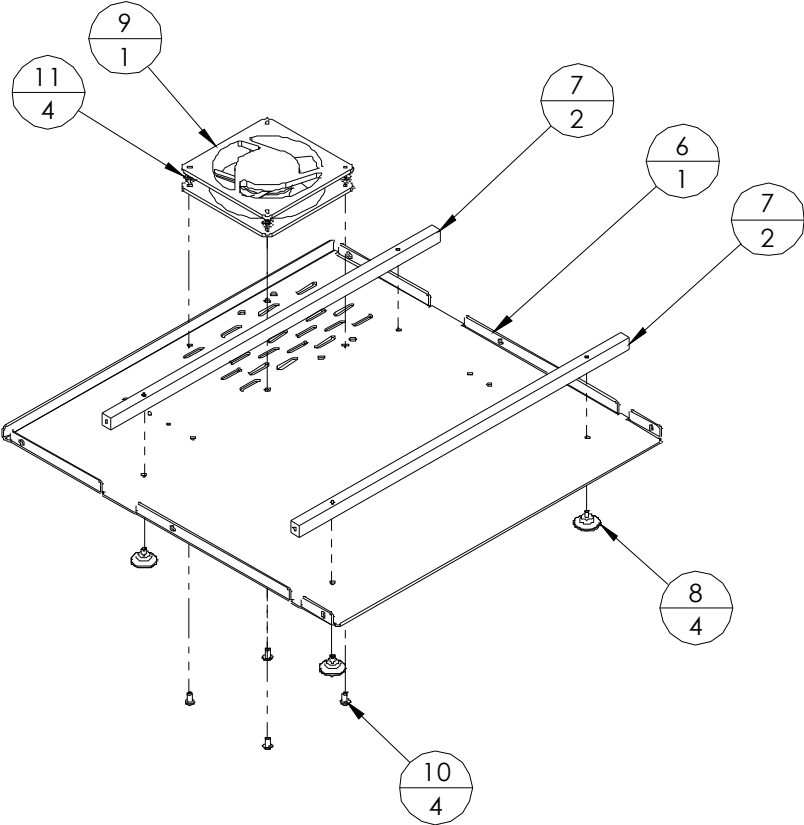
ITEM	PART NO.	QTY.	DESCRIPTION
	10020-426	1	ASSEMBLY, MOTOR DRIVE
1	99001-050	1	MOTOR, 1/4 HP, 90VDC, 3500 RPM
2	99002-048	1	PULLEY, TIMING, 16XL037, 1/2" BORE
3	99002-067	1	PULLEY, TIMING, 15XL037, 1/2" BORE
4	-	2	SET SCREW, #8-32 X 3/16 FLAT
5	-	2	SET SCREW, #8-32 X 1/8 FLAT
	10020-412	1	ASSEMBLY, BOTTOM PLATE
6	10002-024	1	BOTTOM PLATE
7	10003-026	2	CROSSBAR, LOWER
8	99007-001	4	FOOT, SUCTION, #8-32
9	10020-428	1	ASSEMBLY, FAN, 115 VAC, 81 CFM
10	-	4	SCREW, BUTTON HEAD, #10-24 X 1/2
11	-	4	HEX NUT, #10-24

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ASSY# 10020-426



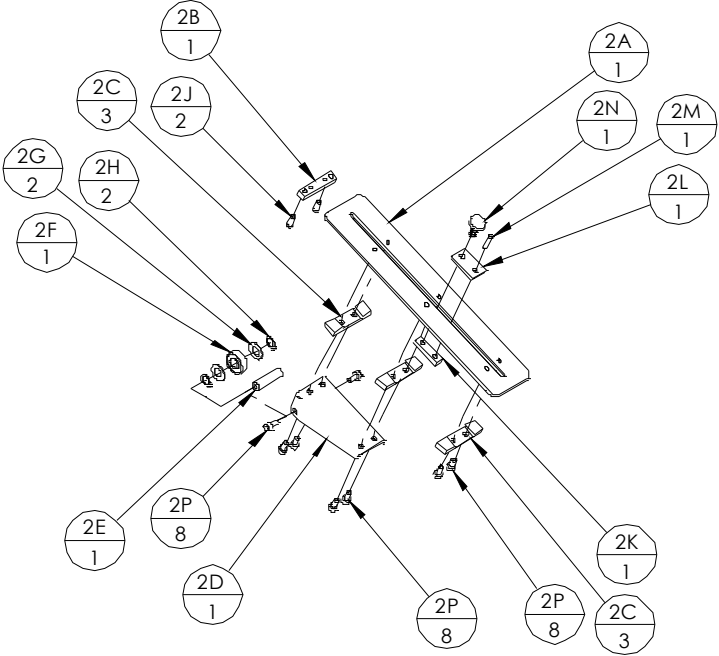
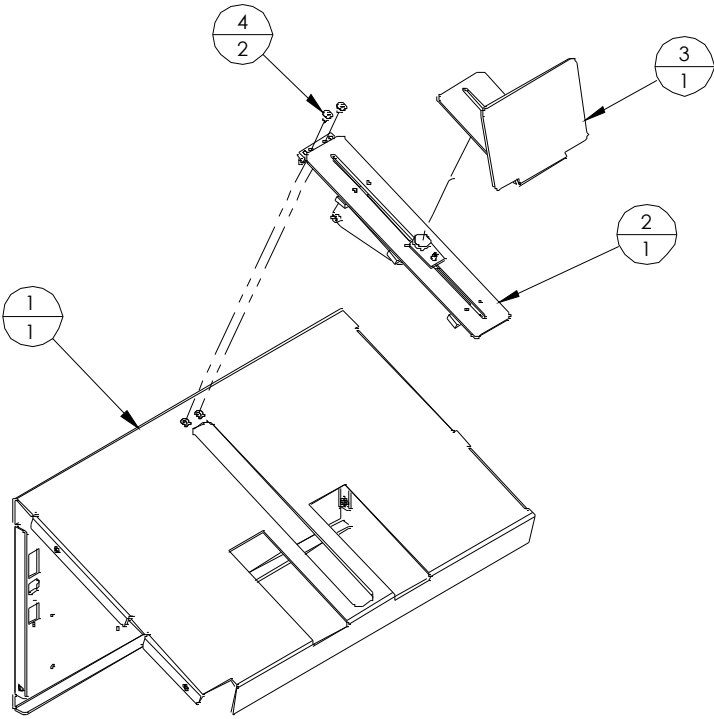
ASSY# 10020-412

**14" FORCE FLEX FEEDER (Fig. 14)
TOP COVER ASSEMBLY (10020-415)**

ITEM	PART NO.	QTY.	DESCRIPTION
1	10001-047		TOP COVER, IJ
2	10020-422	1	ASSEMBLY, VIBRATOR TOP
2A	10007-120	1	PLATE, REAR WEDGE MTG.
2B	10007-124	1	BLOCK, SPRING MTG.
2C	10007-113	3	BLOCK, REAR WEDGE PLATE GUIDE
2D	10009-080	1	BRACKET, VIBRATION DRIVE
2E	10004-054	1	SHAFT, VIBRATING ROLLER MTG.
2F	99003-001	1	BEARING, SEALED, 3/8 X 7/8
2G	99003-016	2	WASHER, NYLON, 3/8 X 1/32
2H	99022-003	2	SNAP RING, 3/8
2J	99006-038	2	PIN, SPRING MTG, #10-32 X 5/8
2K	10007-111	1	NUT, PAPER SLIDE
2L	10007-004	1	WASHER, PAPER SLIDE
2M	99006-020	1	PIN ROLL, 5/32 X 5/8
2N	10020-429	1	KNOB, #10-24 X 5/8
2P	-	8	SCREW, SKT HEAD, #10-24 X 3/8
3	10020-421	1	ASSY, REAR WEDGES
4	-	2	SCREW, FLAT HEAD, #8-32 X 3/8

PITNEY BOWES

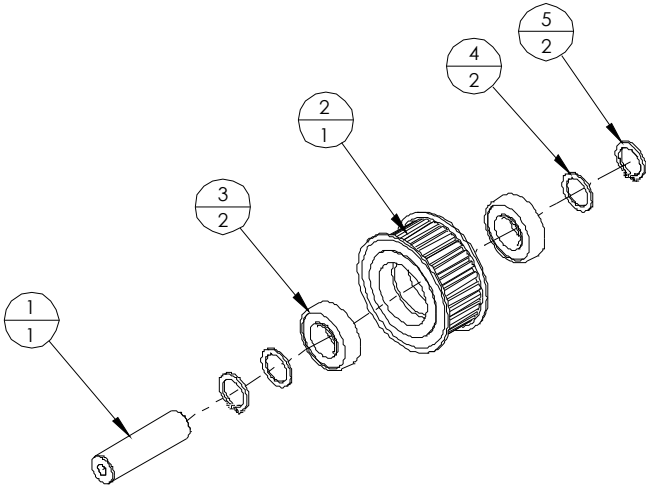
Sure-Feed Engineering



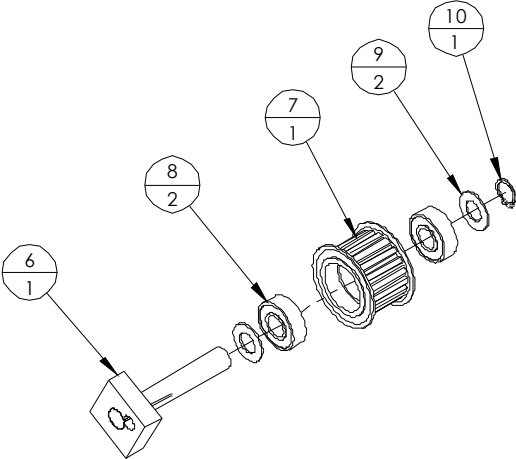
**14" FORCE FLEX FEEDER (Fig. 15)
 CARRIAGE TENSIONER & IDLER ASSEMBLIES**

ITEM	PART NO.	QTY.	DESCRIPTION
	10020-423	1	ASSEMBLY, CARRIAGE IDLER
1	10004-231	1	SHAFT, FIXED STUB IDLER
2	10006-118	1	PULLEY, IDLER, 30XL075
3	99003-003	2	BEARING, 1/2 X 1-1/8 SEALED
4	99003-032	2	WASHER, NYLON, 1/2 X 1/32
5	99022-004	2	SNAP RING, 1/2
	10020-424	1	ASSEMBLY, CARRIAGE TENSIONER
6	16004-032	1	SHAFT, ECCENTRIC IDLER, 3/8
7	10006-117	1	PULLEY, IDLER, 20XL075
8	99003-001	2	BEARING, 3/8 X 7/8
9	99003-016	2	WASHER, NYLON, 3/8 X 1/32
10	99022-003	1	SNAP RING, 3/8

PITNEY BOWES
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ASSY# 10020-423



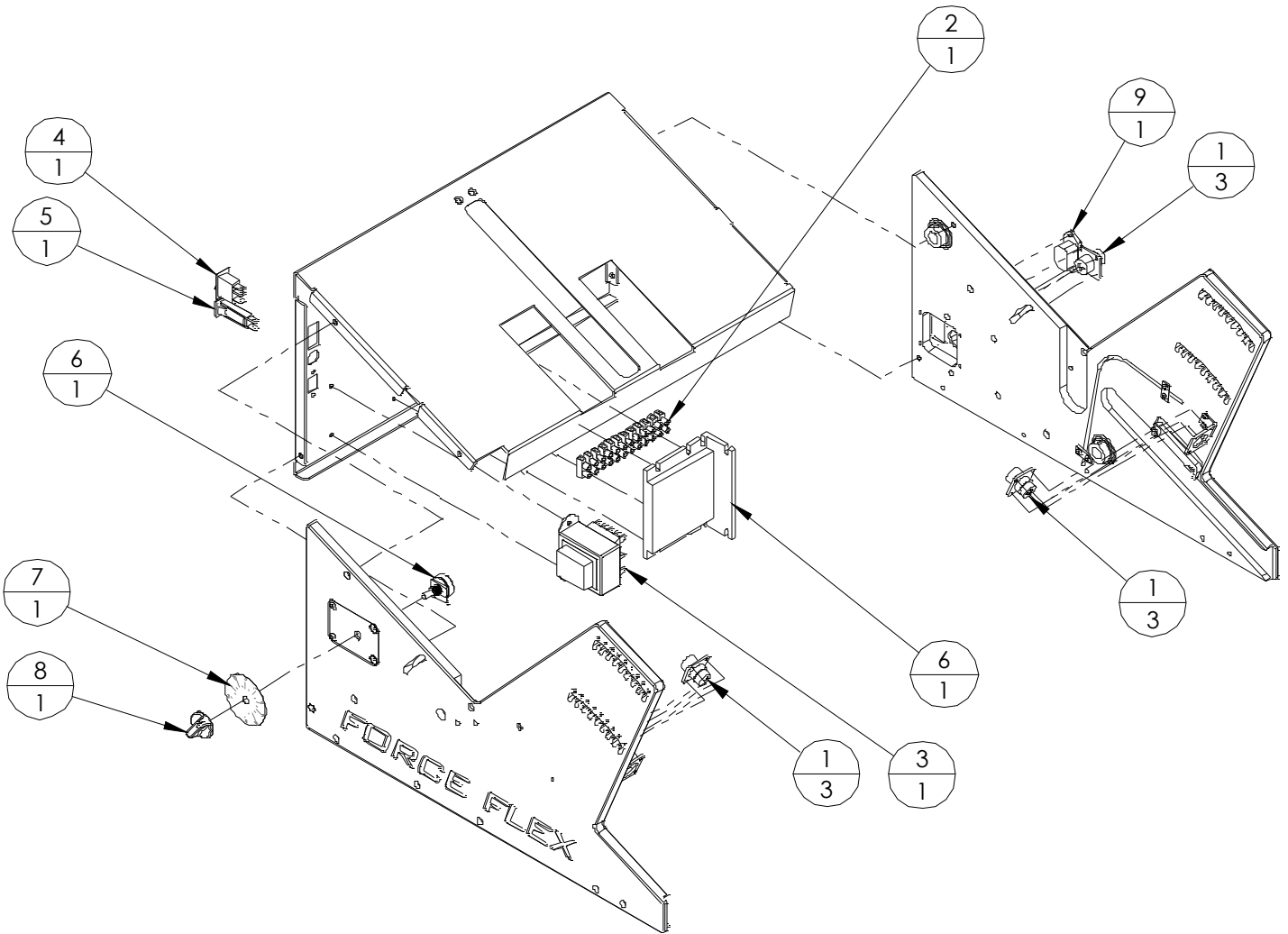
ASSY# 10020-424

14" FORCE FLEX FEEDER (Fig. 16)
MISC ELECTRICAL ASSEMBLY

ITEM	PART NO.	QTY.	DESCRIPTION
1	98016-011	3	RECEPTICAL, SQUARE FL, 11-4 FEMALE
2	98001-002	1	TERMAINAL STRIP, 12 CONNECTOR
3	98008-017	1	TRANSFORMER, 25VA, 110/24VAC
4	98000-001	1	SWITCH, RED ROCKER
5	98004-080	1	CIRCUIT BREAKER, 6 AMP
6	98005-007	1	MOTOR CONTROLLER, 90V DC
7	98006-004	1	DIAL, POTENTIOMTER
8	98006-021	1	KNOB, POTENTIOMETER
9	98003-001	1	RECEPTICAL, POWER CORD

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