

PITNEY BOWES
Sure-Feed Engineering

SURE JET

MODEL SJVB - TUV

Parts Manual



SURE-FEED ENGINEERING

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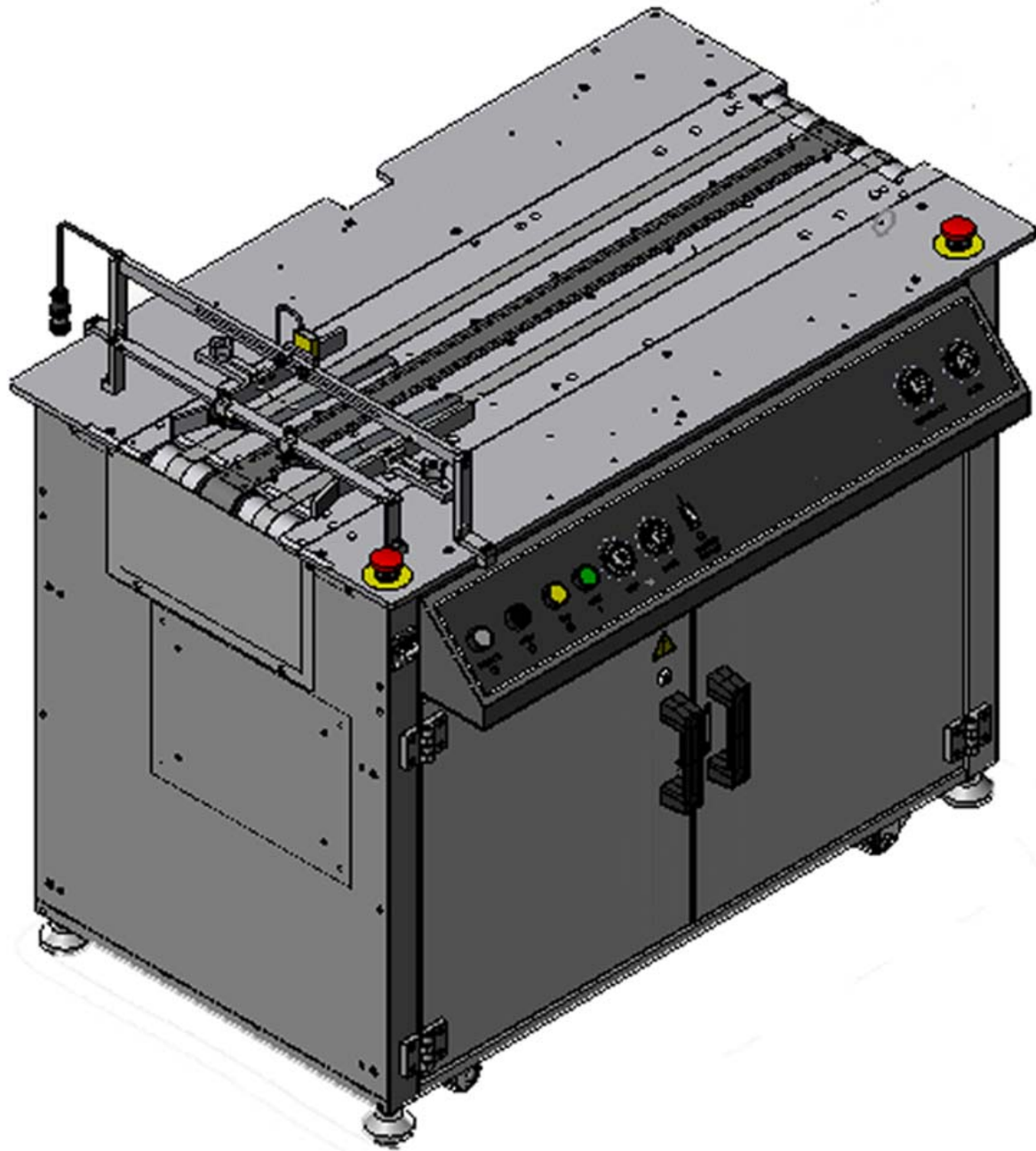
SURE JET- SJVB-TUV

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SURE JET VACUUM BASE

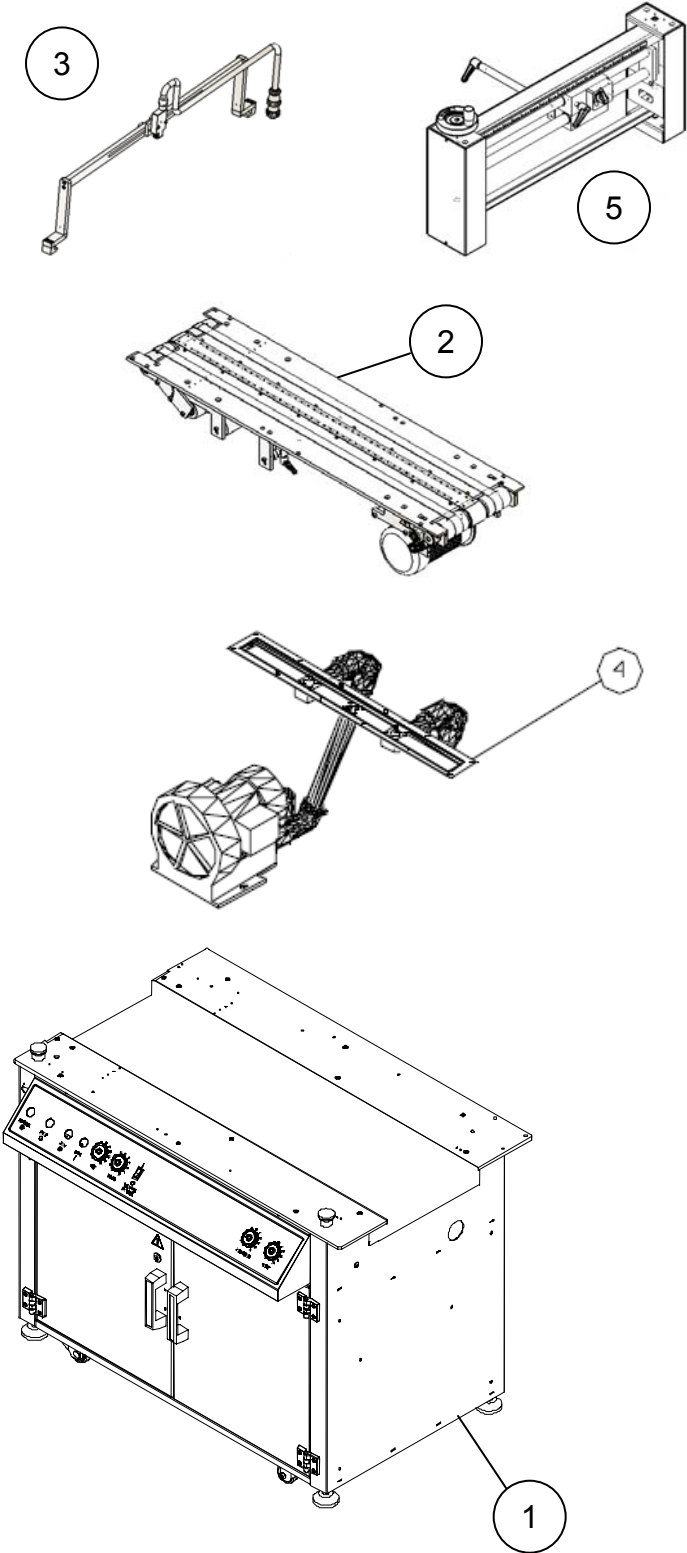
MODEL SJVB



PITNEY BOWES*Sure-Feed Engineering***SURE JET VACUUM BASE ASSEMBLY (Fig. 1)**

| ITEM | PART NO. | QTY. | DESCRIPTION |
|-------------|------------------|-------------|---|
| 1 | 16020-292 | 1 | FRAME ASSEMBLY (SEE FIG. 2) |
| 2 | 16020-178 | 1 | CONVEYOR ASSEMBLY (SEE FIG. 3 TO 6) |
| 3 | 16020-293 | 1 | ADJUSTABLE SENS'R ASSEMBLY (SEE FIG 3) |
| 4 | 16020-179 | 1 | VACUUM ASSEMBLY (SEE FIG. 8) |
| 5 | 16020-091 | 1 | PRINT BRIDGE ASSEMBLY (SEE FIG.) |

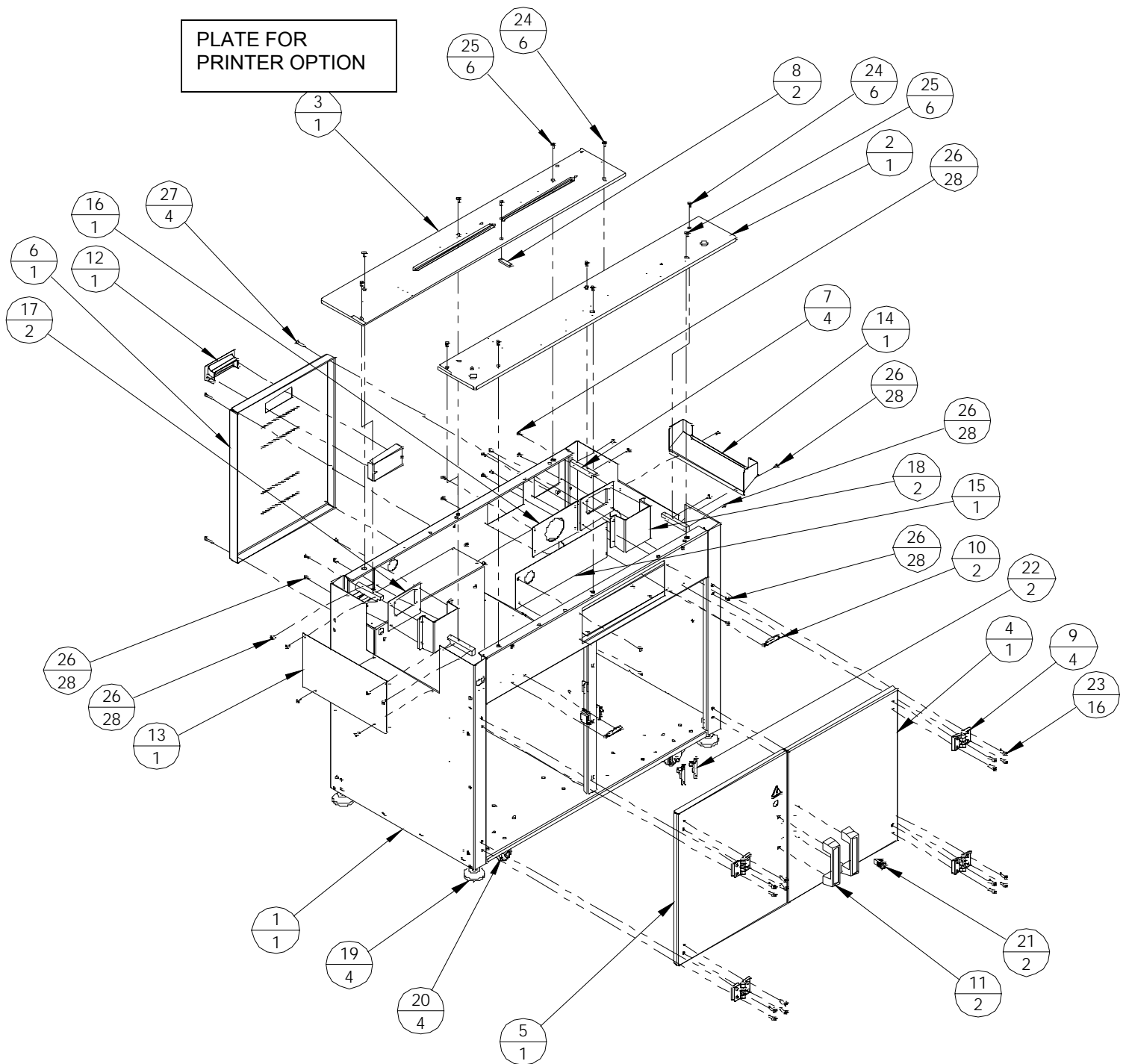
FIG. 1



**SURE JET VACUUM BASE (Fig. 2)
 FRAME ASSEMBLY 16020-292**

| ITEM | PART NO. | QTY | DESCRIPTION |
|------|-----------|-----|---|
| REF | 16020-605 | 1 | ASSEMBLY, FRAME INKJET BASE |
| 1 | 16000-035 | 1 | MAIN FRAME, INKJET BASE |
| 2 | 16011-023 | 1 | PLATE, INKJET TOP (RH) |
| 3 | 16011-127 | 1 | PLATE, TOP, BACK |
| OPT | 16011-061 | 1 | PLATE, INKJET TOP (FOR PRINT BRIDGE) <i>SHOWN</i> |
| 4 | 16013-005 | 1 | DOOR, FRONT, RH (INKJET) |
| 5 | 16013-006 | 1 | DOOR, FRONT, LH (INKJET) |
| 6 | 16013-080 | 1 | DOOR, REAR |
| 7 | 16007-003 | 4 | BLOCK, TOP PLATE SUPPORT |
| 8 | 16007-082 | 2 | BLOCK, SPLICE STRAP |
| 9 | 99011-002 | 4 | HINGE, DOOR |
| 10 | 16013-013 | 2 | HINGE, ELECTRICAL CONTROL CONSOLE |
| 11 | 99012-001 | 2 | DOOR HANDLE |
| 12 | 99012-004 | 1 | HANDLE, POCKET PULL |
| 13 | 16013-009 | 1 | COVER, END |
| 14 | 16013-062 | 1 | COVER, DRIVE |
| 15 | 16013-046 | 1 | COVER, INSIDE, INKJET PANEL |
| 16 | 16011-256 | 1 | PLATE, COVER |
| 17 | 16011-142 | 2 | PLATE, PLUG MTG |
| 18 | 16013-036 | 2 | COVER, WIRE |
| 19 | 99010-001 | 4 | FOOT, ADJUSTABLE, 5/8-11 |
| 20 | 99010-002 | 4 | CASTER, 2" |
| 21 | 99039-123 | 2 | LATCH, CABINET |
| 22 | 99013-001 | 2 | LATCH, DOOR |
| 23 | - | 16 | BOLT, SKT HD, 1/4-20 X 3/4 |
| 24 | - | 6 | SCREW, FLAT HD, #10-24 X 5/8 |
| 25 | - | 6 | SCREW, FLAT HD, #10-32 X 1/2 |
| 26 | - | 28 | SCREW, BUTTON HD, #10-24 X 3/8 |
| 27 | - | 4 | SCREW, BUTTON HD, #10-24 X 1-1/4 |
| | - | 4 | BOLT, SKT HD, 1/4-20 x 1/2 |

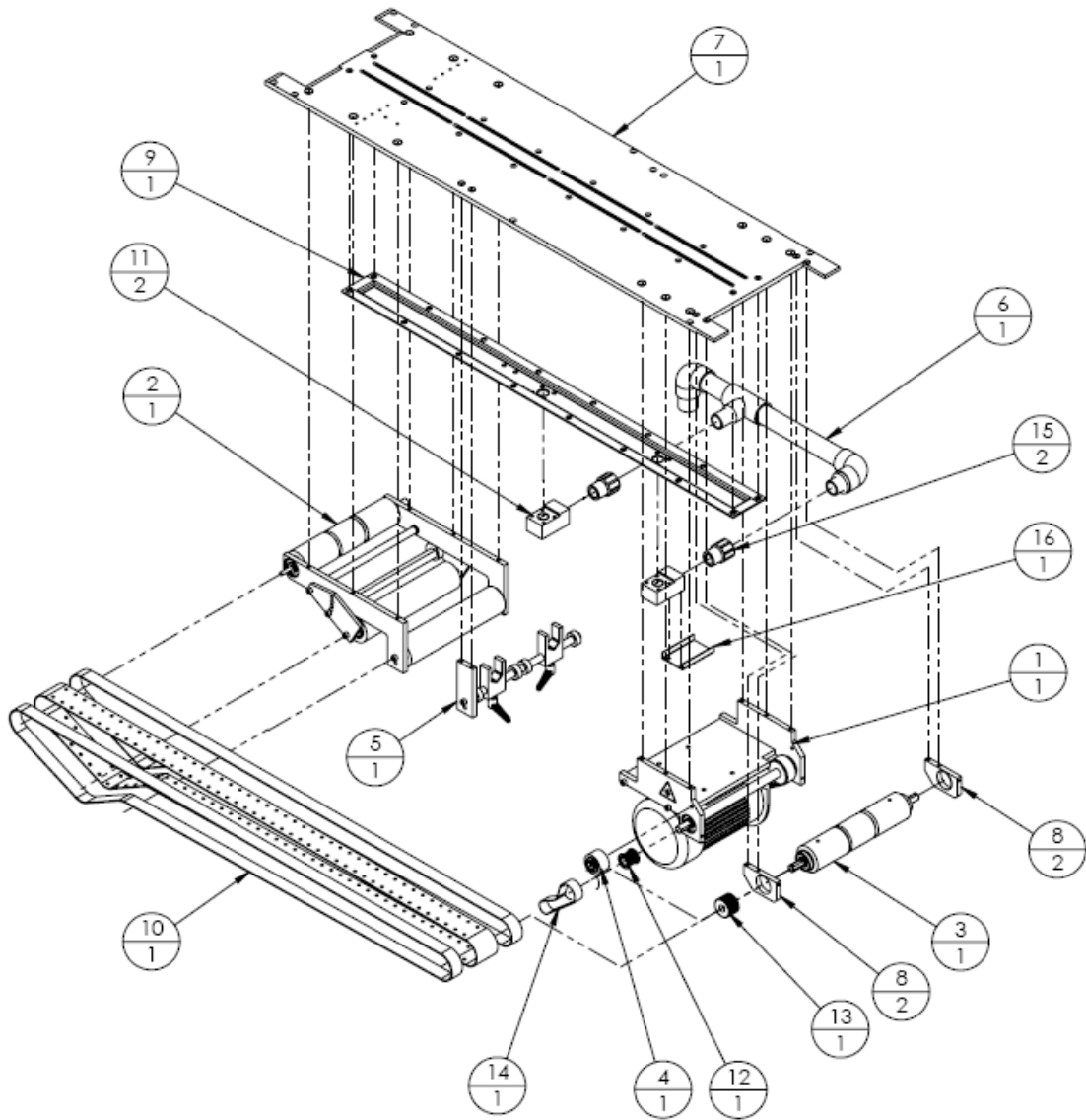
FIG. 2



**SURE JET VACUUM BASE (Fig. 3)
 CONVEYOR DRIVE ASSEMBLY 16020-178rA**

| ITEM | PART NO. | QTY | DESCRIPTION |
|------|-----------|-------|--|
| 1 | 16020-063 | 1 | ASSEMBLY, MOTOR DRIVE (REF FIG. 4) |
| 2 | 16020-449 | 1 | ASSEMBLY, IDLER PULLEY TENSIONER (REF FIG. 5) |
| 3 | 16020-054 | 1 | ASSY, DRIVE PULLEY |
| 4 | 16020-092 | 1 | ASSY, BELT TENSIONER |
| 5 | 16020-062 | 1 | ASSY, BELT GUIDE (REF FIG.) |
| 6 | 16020-475 | 1 | ASSY, PVC, MANIFOLD |
| 7 | 16011-062 | 1 | PLATE, INKJET TOP, CENTER |
| 8 | 16007-056 | 2 | BLOCK, BEARING, 5/8 |
| 9 | 16013-055 | 1 | VACUUM CHAMBER |
| 10 | 16014-005 | 1 SET | BELT, SEAMLESS INKJET |
| 11 | 16007-053 | 2 | BLOCK, ADAPTER, VACUUM CHAMBER |
| 12 | 16006-005 | 1 | PULLEY, 14XL075 1/2 B W/FLANGE |
| 13 | 16006-006 | 1 | PULLEY, 22XL075 1/2 B |
| 14 | 99000-060 | 1 | BELT, TIMING, 100XL075 |
| 15 | 99028-055 | 2 | ADAPTER, MALE, 3/4" NPT X 3/4" |
| 16 | 16009-147 | 1 | BRACKET, FERRITE GUIDE |
| | | | |

FIG. 3



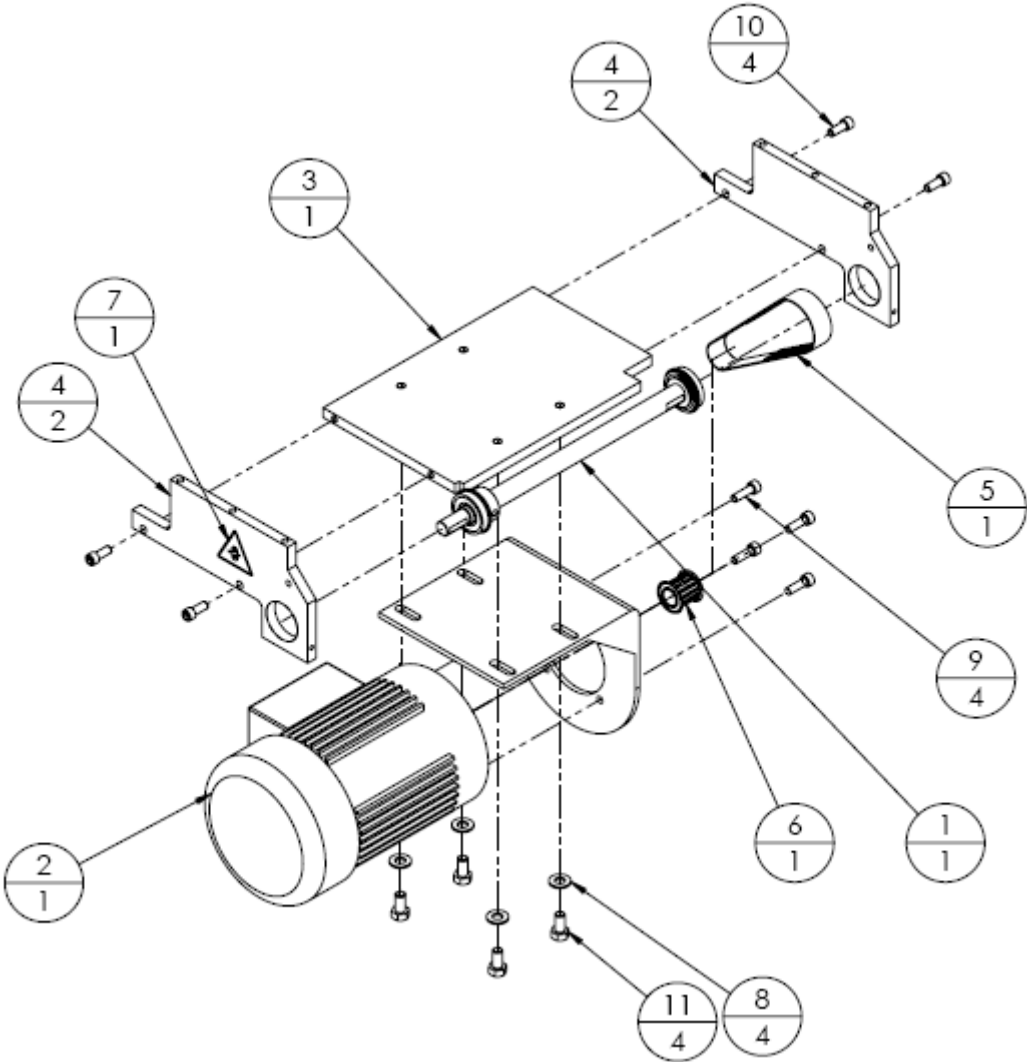
SURE JET VACUUM BASE – CONVEYOR DRIVE (Fig. 4)

REF: 16020-178

MOTOR DRIVE ASSEMBLY 16020-063

| ITEM | PART NO | QTY | DESCRIPTION |
|----------|------------------|----------|--|
| 1 | 16020-055 | 1 | ASSY, INTERMEDIATE DRIVE SHAFT |
| 1a | 16004-010 | 1 | SHAFT, INTERMEDIATE |
| 1b | 99003-051 | 2 | BEARING, 5/8" ID |
| 1c | 99036-021 | 2 | SHIM, STEEL, 5/8 X 1/16 |
| 1d | 16006-007 | 1 | PULLEY, 28XL075 5/8 B |
| 1e | 99017-005 | 1 | COLLAR, SHAFT, 5/8 |
| 2 | 16021-004 | 1 | ASSY, MOTOR |
| 2a | 99001-042 | 1 | MOTOR, 1/2 HP, 1700 RPM, 230/460 3-PHASE |
| 2b | 16021-036 | 1 | CABLE ASSEMBLY (NOT SHOWN) |
| - | 98010-034 | 3 ft | CABLE, MOTOR, 14/4 (NOT SHOWN) |
| - | 98016-013 | 1 | PLUG, AMP, SERIES 3, 23-7 (NOT SHOWN) |
| - | 98016-014 | 1 | BACKSHELL, PLASTIC, SIZE 23 (NOT SHOWN) |
| - | 98016-026 | 4 | CONTACT, PIN, 16-12 AWG (NOT SHOWN) |
| - | 98016-221 | 4 | TERMINAL RING, #8, 14-16 AWG |
| 3 | 16011-008 | 1 | PLATE, MOTOR MTG. |
| 4 | 16011-071 | 2 | PLATE, MOTOR MTG SUPPORT |
| 5 | 99000-059 | 1 | BELT, TIMING, 130XL075 |
| 6 | 16006-109 | 1 | PULLEY, TIMING, 14XL075, 14 MM BORE |
| 7 | 99039-071 | 1 | LABEL, PINCH POINT |

FIG. 4



**SURE JET VACUUM BASE – CONVEYOR DRIVE (Fig. 5)
 REF:16020-178**

IDLER PULLEY TENSIONER ASSEMBLY 16020-449

| ITEM | PART NO | QTY | DESCRIPTION |
|------|-----------|-----|---|
| 1 | 16020-059 | 2 | ASSY, IDLER PULLEY, FIXED |
| 1a | 16006-002 | 1ea | PULLEY, IDLER 10" FLAT |
| 1b | 99003-007 | 2ea | BEARING, 1/2" ID X 1-1/8" OD |
| 2 | 16020-065 | 1 | ASSY, IDLER PULLEY (W / ENCODER) SEE FIG 5A |
| 2-1 | 16006-020 | 1 | PULLEY, DRIVE |
| 2-2 | 16004-027 | 1 | SHAFT, STUB IDLE |
| 2-3 | 99036-021 | 2 | SHIM, STEEL, 5/8 X .062 |
| 2-4 | 99003-051 | 2 | BEARING, 5/8" OD |
| 2-5 | 16004-029 | 1 | SHAFT, STUB IDLE W/ STEP |
| 3 | 16004-044 | 1 | SHAFT, ECCENTRIC MOUNTING |
| 4 | 16004-045 | 2 | SHAFT, IDLER |
| 5 | 16004-046 | 1 | SHAFT, IDLER |
| 6 | 16007-052 | 2 | BLOCK, BEARING MOUNTING |
| 7 | 16008-021 | 2 | BAR, IDLER TENSIONER |
| 8 | 16006-028 | 2 | ROLLER, ECCENTRIC |
| 9 | 99022-004 | 4 | SNAP RING, 1/2" |
| 10 | 99003-043 | 2 | BUSHING, FL, 1/2 X 5/8 X 1/2 |
| 11 | 99036-004 | 3 | SHIM, BEARING, 1/2 X 3/4 X 0.02 |
| 12 | - | 8 | BOLT, SKT HD, 1/4-20 X 5/8 |

FIG. 5

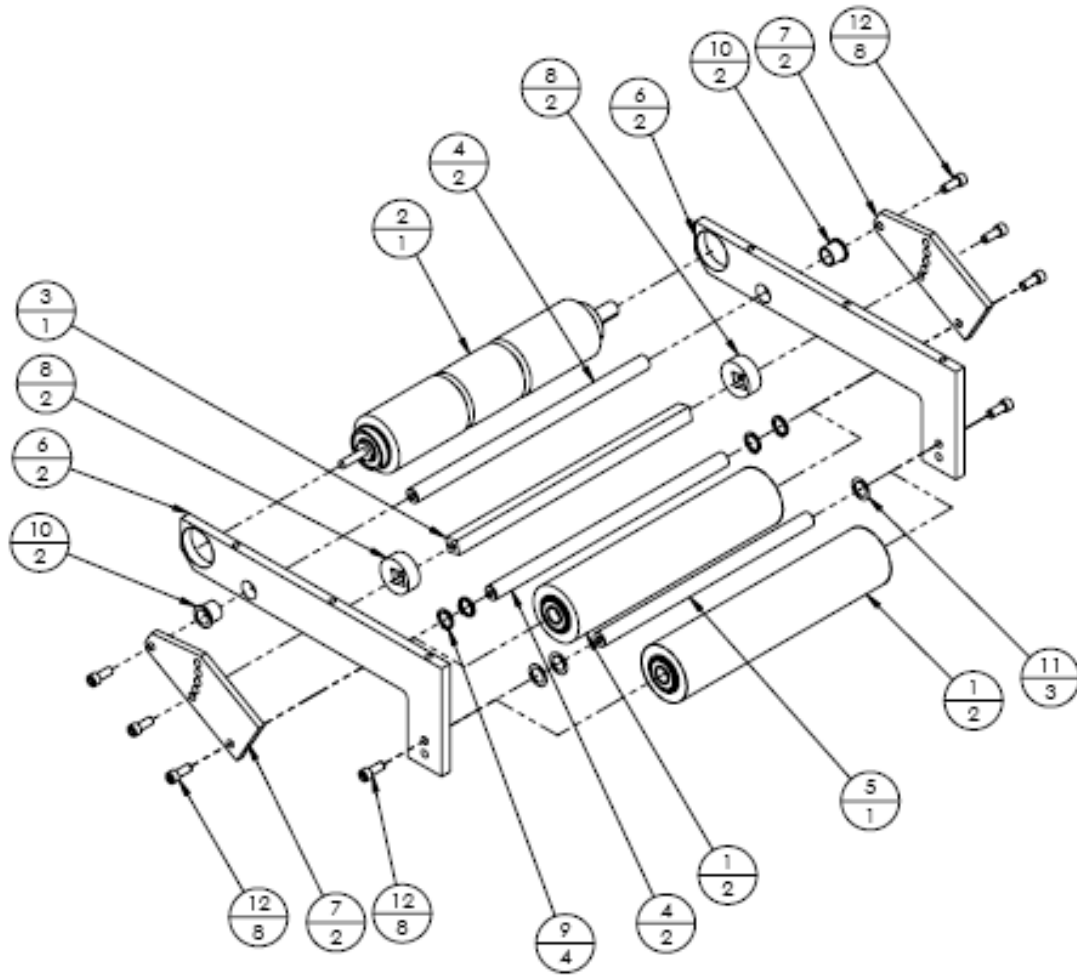
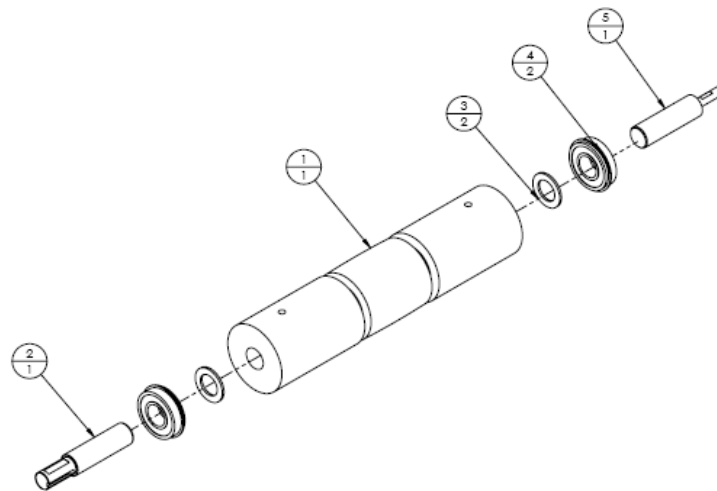


FIG. 5A



SURE JET VACUUM BASE – CONVEYOR DRIVE (Fig. 6)
REF: 16020-178
ASSEMBLIES 16020- 054 / - 092

| ITEM | PART NO | QTY | DESCRIPTION |
|----------|------------------|----------|--|
| A | 16020-054 | 1 | ASSY, DRIVE PULLEY (INK JET BASE) |
| 1 | 16006-020 | 1 | PULLEY, DRIVE |
| 2 | 16004-027 | 2 | SHAFT, STUB DRIVE |
| 3 | 99036-021 | 2 | SHIM, STEEL, 5/8 X 1/16 |
| 4 | 99003-051 | 2 | BEARING, 5/8" ID |
| | | | |
| B | 16020-092 | 1 | ASSY, TENSIONER INKJET |
| 1 | 16004-037 | 1 | SHAFT, TENSIONER |
| 2 | 16006-026 | 1 | PULLEY, IDLER 1" W |
| 3 | 99003-018 | 1 | WASHER, NYLON, 1/2" X 1/16 |
| 4 | 99003-032 | 1 | WASHER, NYLON, 1/2" X 1/32 |
| 5 | 99022-004 | 1 | SNAP RING, 1/2" |
| 6 | 99003-003 | 2 | BEARING, 1/2" ID X 1-1/8" OD |

FIG 6A

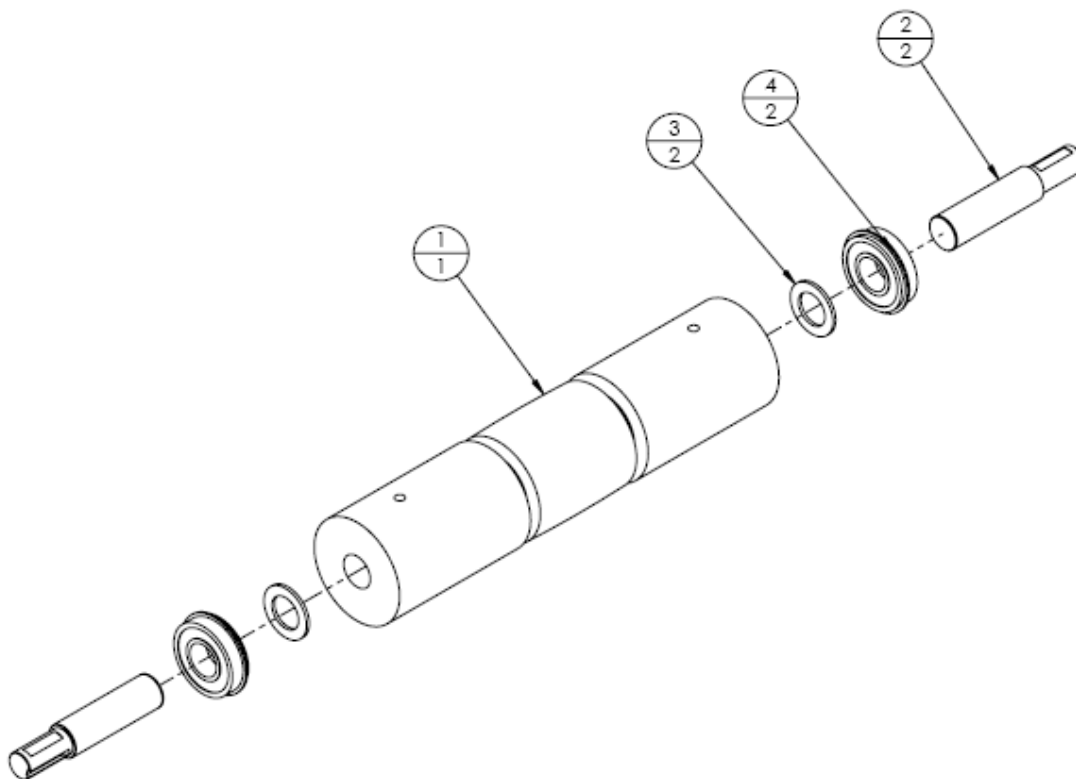
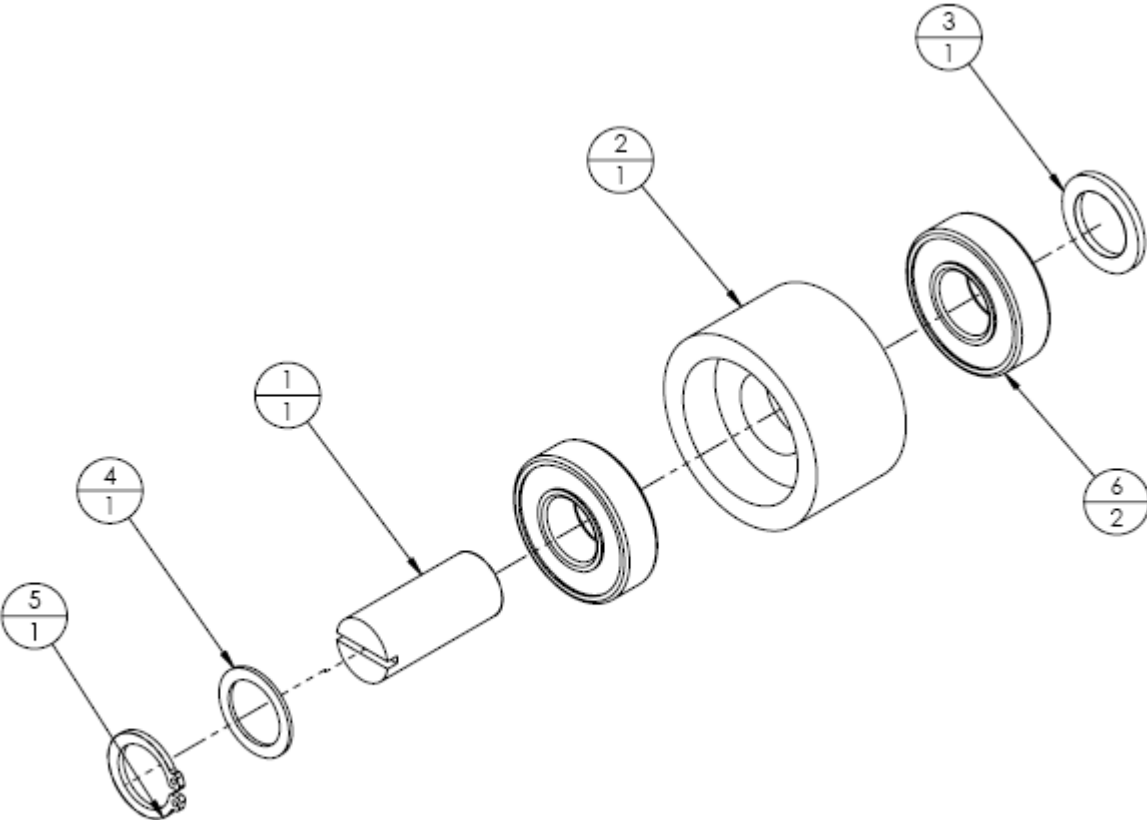


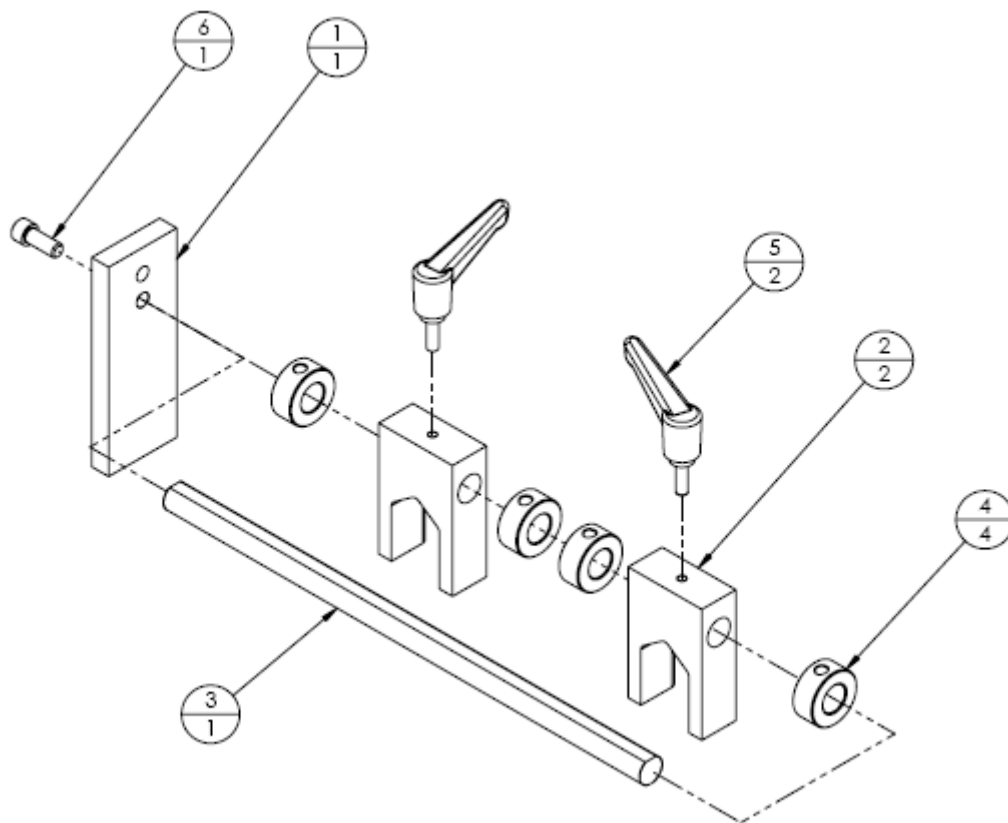
FIG. 6B



SURE JET VACUUM BASE – CONVEYOR DRIVE (Fig 7)
REF: 16020-178
BELT GUIDE ASSEMBLY 16020-062

| ITEM | PART NO | QTY | DESCRIPTION |
|------|-----------|-----|-----------------------------|
| 1 | 16009-002 | 1 | BRACKET, BELT GUIDE SUPPORT |
| 2 | 16005-003 | 2 | GUIDE, BELT , 1" |
| 3 | 16004-011 | 1 | SHAFT, BELT GUIDE SUPPORT |
| 4 | 99017-004 | 4 | COLLAR, SHAFT, 1/2" |
| 5 | 99004-003 | 2 | HANDLE, RATCHET |
| 6 | - | 1 | BOLT, SKT HD, 1/4-20 X 5/8 |

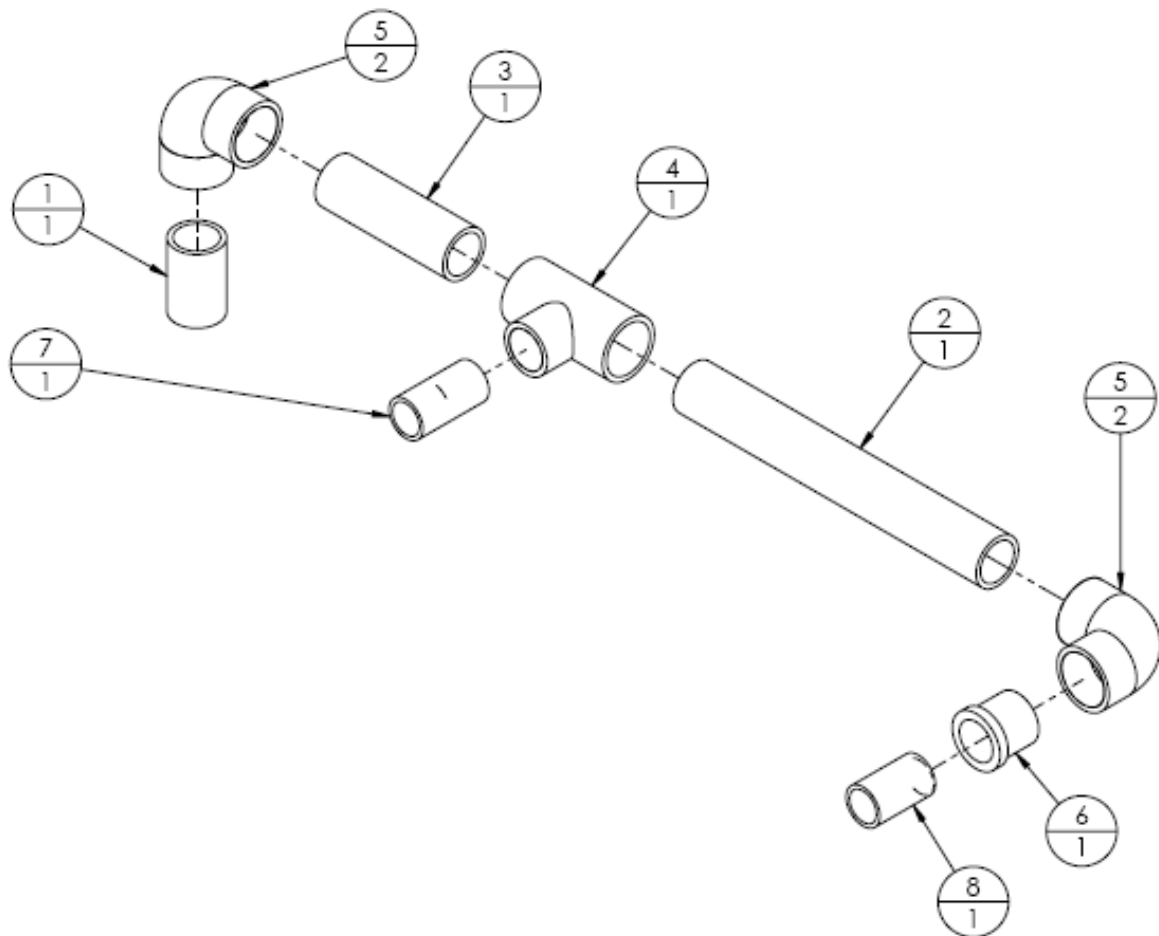
FIG. 7



**SURE JET VACUUM BASE (Fig. 8)
 MANIFOLD PVC ASSEMBLY 16020-475**

| ITEM | PART NO | QTY | DESCRIPTION |
|------|-----------|-----|-------------------------------|
| 1 | 16018-001 | 1 | PIPE, PVC, 1" X 2.00" |
| 2 | 16018-021 | 1 | PIPE, PVC, 1" X 9.50" |
| 3 | 16018-030 | 1 | PIPE, PVC, 1" X 4.00" |
| 4 | 99028-052 | 1 | TEE, REDUCING, 1" X 3/4" PVC |
| 5 | 99028-050 | 2 | ELBOW, 90 DEG, 1", PVC |
| 6 | 99028-053 | 1 | REDUCER, 1" TO 3/4" SLIP, PVC |
| 7 | 16018-015 | 1 | PIPE, PVC, 3/4" X 2.07" |
| 8 | 16018-027 | 1 | PIPE, PVC, 3/4" X 1.735" |

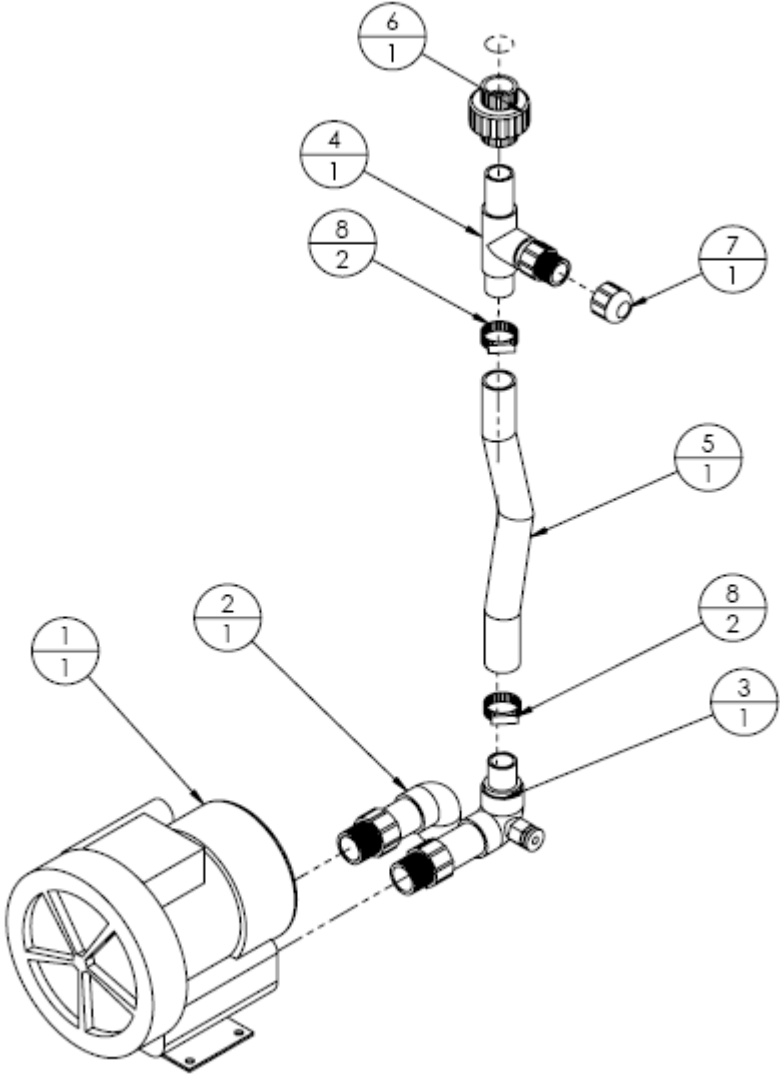
FIG. 8



SURE JET VACUUM BASE (Fig. 9)
VACUUM COMPONENTS ASSEMBLY 16020-179

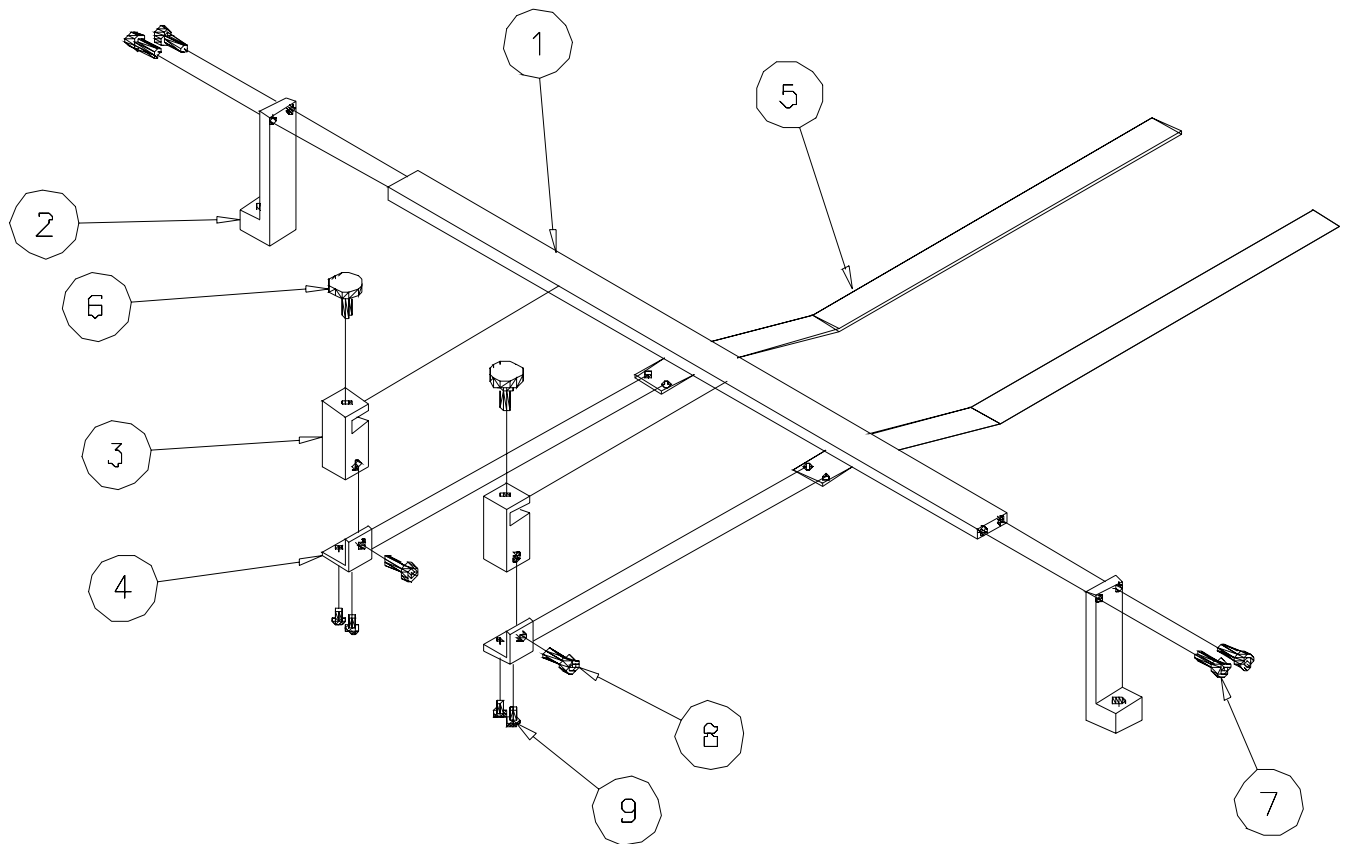
| ITEM | PART NO | QTY | DESCRIPTION |
|----------|------------------|----------|--|
| 1 | 16021-008 | 1 | ASSEMBLY, BLOWER, 80 CFM |
| a | 99029-007 | 1 | BLOWER, VACUUM BUSCH#SB0080 DOHT.UBXX |
| b | 98010-182 | 7 FT | CABLE, 16/3 HAR |
| c | 98015-001 | 1 | STRAIN RELIEF, 1/2 |
| d | 98016-221 | 2 | TERMINAL RING, #8, 14-16 AWG |
| e | 98016-004 | 1 | PLUG, REVERSE, SERIES 3, 17-3 |
| f | 98016-005 | 1 | BACKSHELL, PLASTIC SIZE 17 |
| g | 98016-026 | 2 | CONTACT, PIN, 16-12 AWG |
| h | 98016-237 | 1 | PIN, EXTENDED, 16-12 AWG GOLD |
| 2 | 16020-469 | 1 | ASSY, VACUUM PUMP EXHAUST PVC |
| a | 99028-105 | 1 | ADAPTER, MALE, 1-1/4 NPT X 1-1/4 SLIP, PVC |
| b | 16018-026 | 1 | PIPE, PVC, 1-1/4" X 4" |
| c | 99028-106 | 1 | ELBOW, 90 DEG, 1-1/4 SLIP, PVC |
| 3 | 16020-478 | 1 | ASSY, VACUUM PUMP INTAKE PVC |
| a | 99028-105 | 1 | ADAPTER, MALE, 1-1/4 NPT X 1-1/4 SLIP, PVC |
| b | 16018-026 | 1 | PIPE, PVC, 1-1/4" X 4" |
| c | 99028-039 | 1 | ELBOW, 90 DEG, 1-1/4 SLIP, PVC |
| d | 99028-108 | 1 | REDUCER, 1-1/4 TO 1" SLIP, PVC |
| e | 16018-003 | 1 | PIPE, PVC, 1" X 2.25" |
| f | 99025-024 | 1 | VALVE, VACUUM RELIEF |
| 4 | 16020-476 | 1 | ASSY, PVC, ADAPTER TEE |
| a | 16018-003 | 2 | PIPE, PVC, 1" X 2.25" |
| b | 16018-007 | 1 | PIPE, PVC, 1" X 3.038" |
| c | 99028-112 | 1 | TEE, 1" PVC |
| d | 99028-047 | 1 | ADAPTER, MALE, 1" NPT X 1" SLIP, PVC |
| 5 | 99031-020 | 2 FT | HOSE, 1" ID |
| 6 | 99028-049 | 1 | UNION, PVC 1" |
| 7 | 99028-079 | 1 | CAP, END, 1" NPT, PVC |
| 8 | 90017-042 | 2 | HOSE, CLAMP, SS, 2" |

FIG. 9



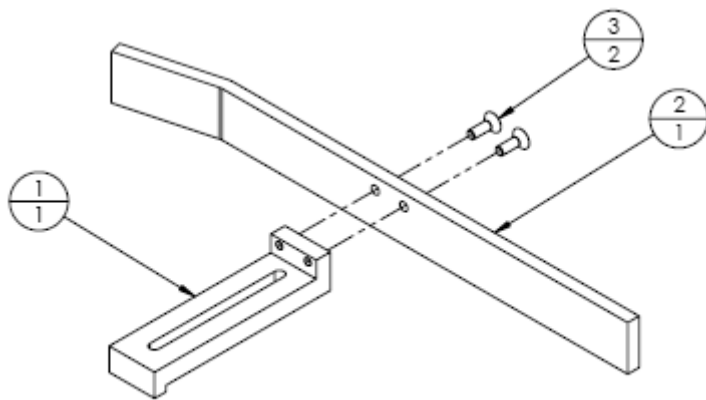
**SURE JET VACUUM BASE (Fig. 10)
 HOLD DOWN ASSEMBLY 16020-103**

| ITEM | P/N | QTY | DESCRIPTION |
|------------|------------------|----------|---|
| REF | 16020-013 | 1 | ASSEMBLY, DRAG STRAP MTG BAR (INKJET BASE) |
| 1 | 16008-007 | 1 | BAR, DRAG STRAP MOUNTING |
| 2 | 16009-008 | 2 | BRACKET, DRAG STRAP SUPPORT |
| 7 | - | 4 | SCREW, SKT.HD, 8-32 X 1/2 LG |
| REF | 16020-230 | 2 | ASSEMBLY, DRAG STRAP |
| 3 | 18009-014 | 1 EA | BRACKET, DRAG STRAP MOUNTING |
| 4 | 18009-029 | 1 EA | BRACKET, DRAG STRAP PIVOT |
| 5 | 18005-105 | 1 EA | GUIDE, SPRING STEEL |
| 6 | 10020-317 | 1 EA | ASSY, KNOB #10-24 X 1/2LG |
| 8 | | 1 EA | SCREW, SKT.HD, 10-24 X 3/8LG |
| 9 | | 2 EA | SCREW, PAN HD, 6-32 X 3/8LG |

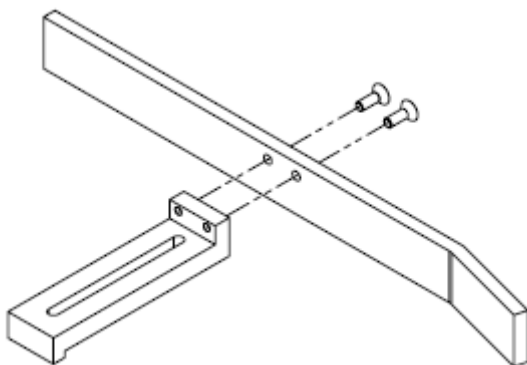


**SURE JET VACUUM BASE (Fig. 11)
 PRODUCT GUIDE ASSEMBLIES**

| ITEM | PART NO | QTY | DESCRIPTION |
|------------|------------------|----------|--------------------------------|
| REF | 16020-528 | 1 | ASSY, PRODUCT GUIDE, RH |
| 1 | 12005-009 | 1 | GUIDE, SIDE, RH |
| 2 | 16007-016 | 1 | BLOCK, SIDE GUIDE MTG (LONG) |
| | - | 2 | SCREW, FLAT HD, #8-32 X 1/2 |
| REF | 16020-529 | 1 | ASSY, PRODUCT GUIDE, LH |
| 1 | 12005-010 | 1 | GUIDE, SIDE, LH |
| 2 | 16007-016 | 1 | BLOCK, SIDE GUIDE MTG (LONG) |
| | - | 2 | SCREW, FLAT HD, #8-32 X 1/2 |



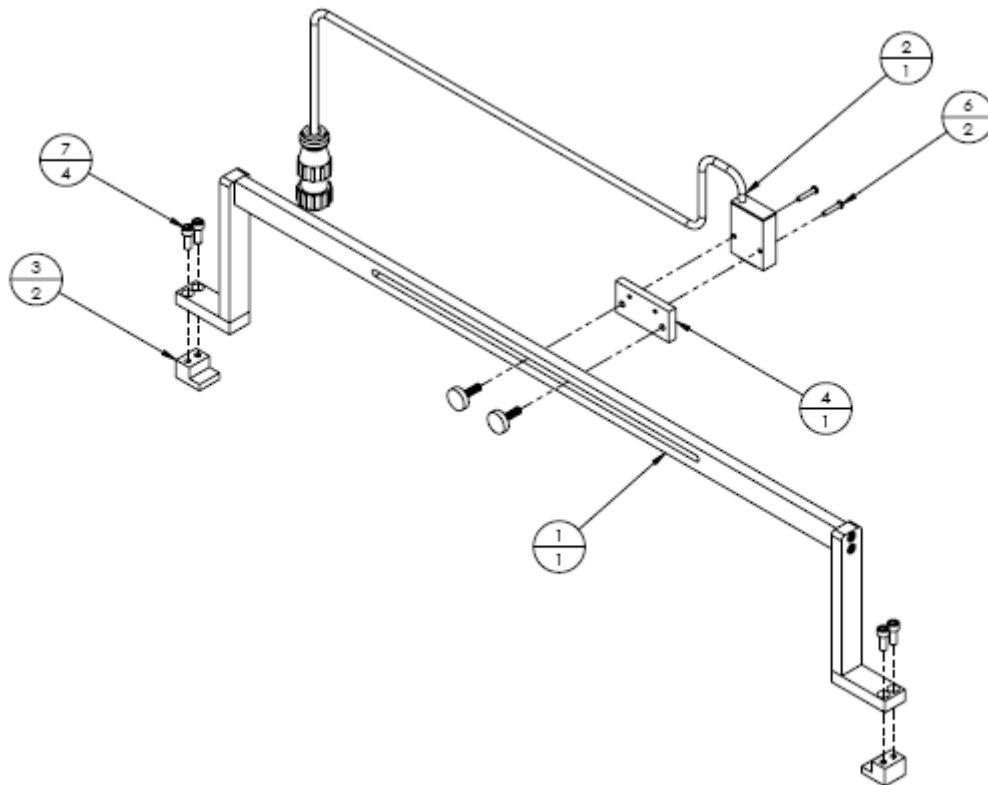
RIGHT HAND



LEFT HAND

**SURE JET VACUUM BASE (Fig. 12)
 ADJUSTABLE SENSOR ASSEMBLY 16020-305**

| ITEM | PART NO | QTY | DESCRIPTION |
|----------|------------------|----------|-------------------------------------|
| 1 | 16020-044 | 1 | ASSY, BAR, ADJUSTABLE SENSOR |
| a | 16007-034 | 2 | BLOCK, SENSOR SUPPORT |
| b | 16007-035 | 2 | BLOCK, SENSOR CLAMP |
| c | 16008-022 | 1 | BAR, SENSOR MTG |
| 2 | 16021-029 | 1 | ASSY, MINI BEAM SENSOR |
| a | 98009-027 | 1 | SENSOR, BANNER MINI BEAM |
| b | 98016-029 | 1 | PLUG, AMP, SERIES 1, 11-4 |
| c | 98016-015 | 1 | BACKSHELL, PLASTIC, SIZE 11 |
| d | 98016-114 | 4 | CONTACT, PIN, 26-24 AWG |
| 3 | 16007-033 | 2 | BLOCK, CLAMP |
| 4 | 16011-016 | 1 | PLATE, SENSOR MTG |
| 5 | 10020-429 | 2 | ASSY, KNOB, #10-24 X 5/8 |
| 6 | - | 2 | SBHCS, 4-40 X 5/8 |
| 7 | - | 4 | SHCS, #10-24 X 1/2 |



**SURE JET VACUUM BASE (Fig. 13)
 ELECTRICAL ENCLOSURE ASSEMBLY**

| ITEM | PART NO | QTY | DESCRIPTION |
|------------|------------------|----------|---|
| REF | 16020-510 | 1 | ASSEMBLY, ELECTRICAL ENCLOSURE |
| a | 98003-016 | 1 | QUADBLOC, TYPE 4752.4200 |
| b | 98015-037 | 7 | GROMMET, RUBBER, 7/8" |
| c | 98015-038 | 3 | GROMMET, RUBBER, 1-1/16 |
| d | 16011-045 | 1 | PLATE, PLUG MTG |
| e | 98019-068 | 2 | STRAIGHT PRESSURE TONGUE, GROUND |
| REF | 16021-051 | 1 | ASSY, CABLE, MOTOR POWER INLET |
| a | 98016-009 | 1 | RECEPTACLE, SQ FLG, AMP, 23-7 |
| b | 98016-028 | 4 | CONTACT, SOCKET, 16-12 AWG |
| c | 98010-034 | 4 FT | CABLE, MOTOR, 14/4 COND |
| REF | 16021-009 | 1 | ASSEMBLY, BACK PANEL, MAIN ENCLOSURE |
| 1 | 16013-044 | 1 | BACKPLATE, MAIN ENCLOSURE |
| 2 | 98004-047 | 4 | 4A SLO-BLO FUSE (FU 1A,B; 2A,B) |
| 3 | 98004-023 | 6 | FUSE, 2 A, 250V 5X20MM GDC (FU 3A,B;4A,B;6A,B) |
| 4 | 98004-017 | 1 | FUSE, 1 AMP, 250V, 5X20MM GMC (FU 7) |
| 5 | 98004-038 | 1 | CIRCUIT BREAKER, 8A, 2 POLE |
| 6 | 98004-050 | 1 | CIRCUIT BREAKER, 8 A |
| 7 | 98001-060 | 43 | TERMINAL BLOCK, SPRING |
| 8 | 98002-005 | 3 | RELAY SOCKET, DPDT |
| 9 | 98002-007 | 3 | RELAY, DPDT, 24VDC |
| 10 | 98002-012 | 4 | RELAY SOCKET, 5 PIN |
| 11 | 98002-022 | 1 | RELAY, SPST, 120 VAC (or 98002-015 for 24VDC) CR2 |
| 12 | 98002-011 | 3 | RELAY, SPDT, 24VDC |
| 13 | 98002-032 | 1 | CONTROL RELAY, 24VAC |
| 14 | 98005-007 | 2 | MOTOR CONTROLLER, 90VDC |
| 15 | 98006-024 | 2 | POWER RESISTOR, 0.1 Ω (MOTOR CONTROLLER) |
| 16 | 98001-022 | 3 FT | DIN RAIL |
| 17 | 98012-008 | 8 FT | DUCT, WIREWAY, 1" X 3" |
| 18 | 98012-002 | 8 FT | DUCT COVER, 1" |
| 19 | 98013-068 | 2 | FR-S520E-0.75K-NA, INVERTER |
| 20 | 98004-006 | 2 | FUSE, 6A, 225V 5X20MM (FU 5A,B) |
| 21 | 98001-073 | 11 | BRIDGE, 2 POSITION |
| 22 | 98010-034 | 7 FT | MOTOR CABLE, 14/4 |
| 23 | 98001-089 | 4 | TERMINAL, DOUBLE LAYER (STTB 2,5) |
| 24 | 98001-093 | 2 | TERMINAL, DOUBLE LAYER, SHORTED |
| 25 | 98001-072 | 4 | END STOP TERMINAL |

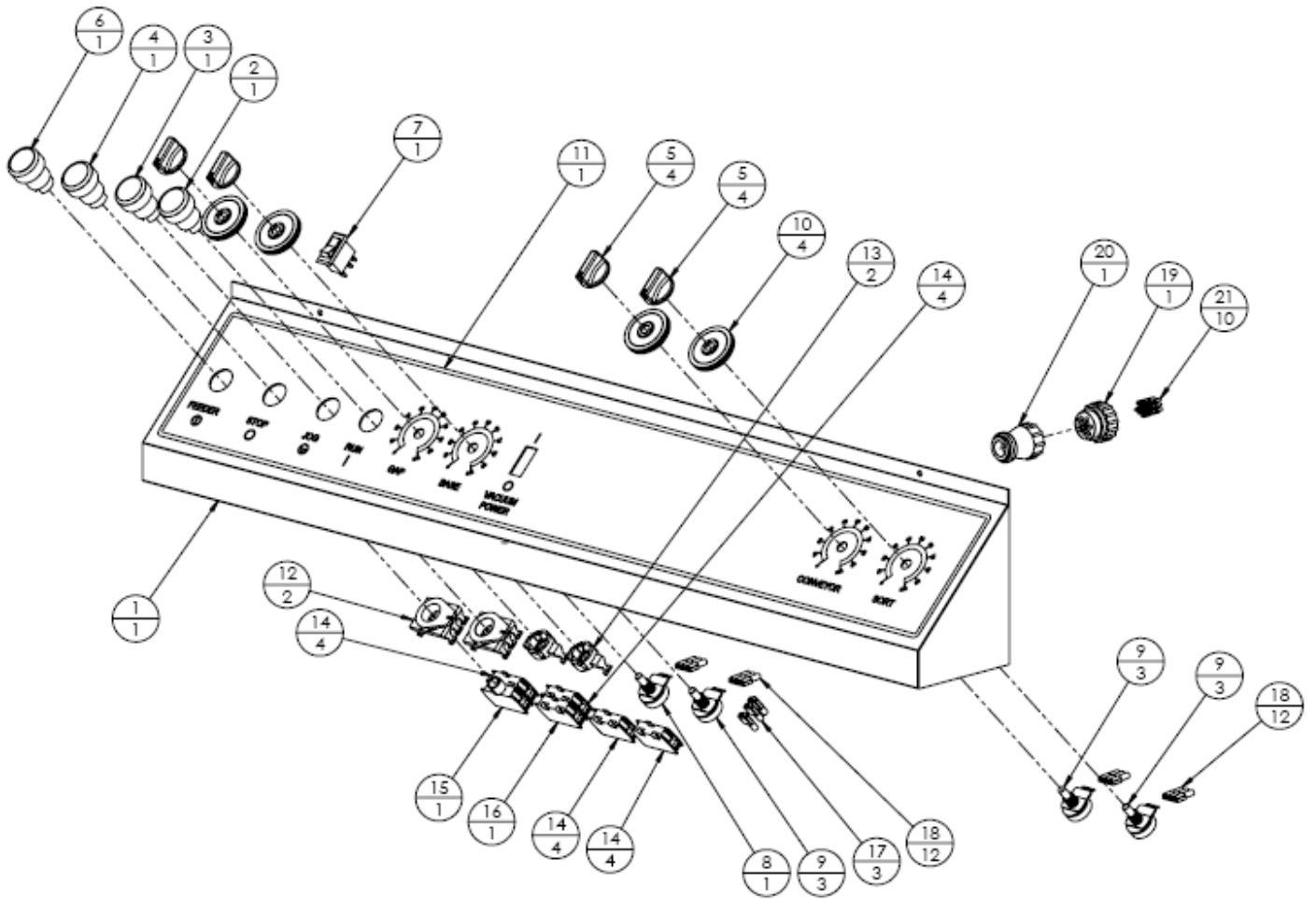
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| ITEM | PART NO | QTY | DESCRIPTION |
|-------------|----------------|------------|-------------------------------|
| 26 | 98001-064 | 9 | SIDE COVER TERMINAL BLOCK |
| 27 | 98001-008 | 2 | END COVER, DBL LAYER TERMINAL |
| 28 | 98001-074 | 4 | BRIDGE, 3 POSITION |
| 29 | 98001-075 | 2 | BRIDGE, 4 POSITION |
| 30 | 98004-063 | 2 | FUSE BRIDGE, 20 POSITION |
| 31 | 98001-063 | 13 | FUSE BLOCK |
| 32 | 98001-062 | 3 | GROUND TERMINAL |
| 33 | 98001-061 | 5 | SPRING GROUND TERMINAL |
| 34 | 98016-216 | 6 | QUICK DISCONNECT, .250 FEMALE |
| 35 | 98016-218 | 4 | QUICK DISCONNECT, .110 FEMALE |
| 36 | 98016-219 | 8 | QUICK DISCONNECT, .250 FEMALE |
| 37 | 98019-068 | 2 | STRAIGHT PRESSURE TONGUE |
| 38 | 98002-037 | 1 | RELAY, SPDT, 24 VAC, (OMRON) |

**SURE JET VACUUM BASE (Fig. 14)
 ELECTRICAL CONTROL CONSOLE 16020-163rB**

| ITEM | PART NO | QTY | DESCRIPTION |
|------|-----------|------|-------------------------------|
| 1 | 16013-012 | 1 | CONSOLE ENCLOSURE |
| 2 | 98000-117 | 1 | PUSH BUTTON, "RUN", GREEN |
| 3 | 98000-118 | 1 | PB MOM, "JOG", YELLOW |
| 4 | 98000-119 | 1 | PUSH BUTTON, "STOP", BLACK |
| 5 | 99006-021 | 4 | KNOB, POTENTIOMETER |
| 6 | 98000-099 | 1 | PB, MOM, ILLUMINATED, FLUSH |
| 7 | 98000-041 | 1 | SWITCH ROCKER, WHITE |
| 8 | 98006-036 | 1 | SPEED POT, 10 K |
| 9 | 98006-007 | 3 | SPEED POT KIT |
| 10 | 98006-035 | 4 | KNOB LOCK |
| 11 | 16015-007 | 1 | LABEL, INKJET CONSOLE |
| 12 | 98000-103 | 2 | CLIP, THREE POSITIONS |
| 13 | 98000-102 | 2 | CLIP, ONE POSITION |
| 14 | 98000-105 | 4 | CONTACT BLOCK, N.O. |
| 15 | 98000-110 | 1 | LED BLOCK, WHITE |
| 16 | 98000-108 | 1 | CONTACT BLOCK, N.C., GOLD |
| 17 | 98016-216 | 3 | QUICK DISCONNECT, .250 FEMALE |
| 18 | 98016-218 | 12 | QUICK DISCONNECT, .110 FEMALE |
| 19 | 98016-092 | 1 | PLUG, AMP, 17-14 REV (MALE) |
| 20 | 98016-005 | 2 | BACKSHELL, PLASTIC SIZE 11 |
| 21 | 98016-025 | 10 | CONTACT, PIN, 24-20 AWG |
| 22 | 98010-075 | 17FT | CABLE, SHIELDED, 22/3 |
| 23 | 98010-119 | 10FT | CABLE, SHIELDED, 22/4 |

FIG. 14



**SURE JET VACUUM BASE (Fig. 15A & B)
 ELECTRICAL ASSEMBLY 16020-160**

| ITEM | PART NO | QTY | DESCRIPTION |
|------------|------------------|----------|--|
| 1 | 98015-002 | 1 | STRAIN RELIEF, 3/4" |
| 2 | 98004-044 | 1 | CIRCUIT BREAKER, 20A |
| 3 | 16009-071 | 1 | BRACKET, 2 POLE BREAKER |
| 4 | 16009-155 | 1 | BRACKET, DIN RAIL, 3" |
| 5 | 98001-062 | 2 | GROUND TERMINAL |
| 6 | 98016-100 | 1 | RECEPTACLE, FREE-HANGING, 14 PIN |
| 7 | 98016-005 | 1 | BACKSHELL, PLASTIC SIZE 17 |
| 8 | 98016-027 | 10 | CONTACT, SOCKET, 24-20 AWG |
| REF | 16021-005 | 1 | ASSEMBLY, TRANSFORMER (SEE FIG 15A) |
| 9 | 16009-057 | 1 | BRACKET, TERMINAL MTG |
| 10 | 16009-068 | 1 | BRACKET, TRANSFORMER MTG |
| 11 | 98008-011 | 1 | TRANSFORMER, 110V |
| 12 | 98020-023 | 1 | FILTER-30A, 115/250V |
| 13 | 98010-074 | 6 FT | CABLE, SHIELDED, 18/3 |
| 14 | 98010-186 | 18 FT | WIRE, 12/3 HAR EXPORT BLACK |
| 15 | 98010-182 | 17 FT | WIRE, 16/3, HAR EXPORT BLACK |
| 16 | 98001-022 | 2 FT | DIN RAIL |
| 17 | 98001-101 | 2 | RAIL ADAPTOR |
| 18 | 98001-067 | 13 | SCREW TERMINAL, 10 GA |
| 19 | 98001-079 | 1 | TERMINAL END PLATE |
| 20 | 98001-062 | 3 | GROUND TERMINAL |
| | 98001-052 | 10 IN | GROUND STRAP, FLAT BRAID |
| | 98001-025 | 2 | TERMINAL, RING, 1/4", 6 AWG |
| | 98001-050 | 5 | TERMINAL, RING, #8, 12-10 AWG |
| | 98016-221 | 1 | TERMINAL, RING, #8, 14-16 |
| | 98016-220 | 4 | QUICK DISCONNECT, .250 FEMALE |
| | 99039-119 | 1 | VIBRATION ISOLATOR |
| REF | 16020-535 | 1 | ASSEMBLY, E-STOP (SEE FIG 15B) |
| 26 | 98000-016 | 2 | SWITCH, PUSH-PULL STOP |
| 27 | 98000-037 | 2 | CLIP, SWITCH |
| 28 | 98000-038 | 4 | CONTACT BLOCK, N.C. |
| 29 | 98000-028 | 2 | CONTACT BLOCK, 1XNO, PROTECTED |
| | 98000-053 | 2 | E-STOP PLATE, SMALL (TUV) |

FIG. 15A

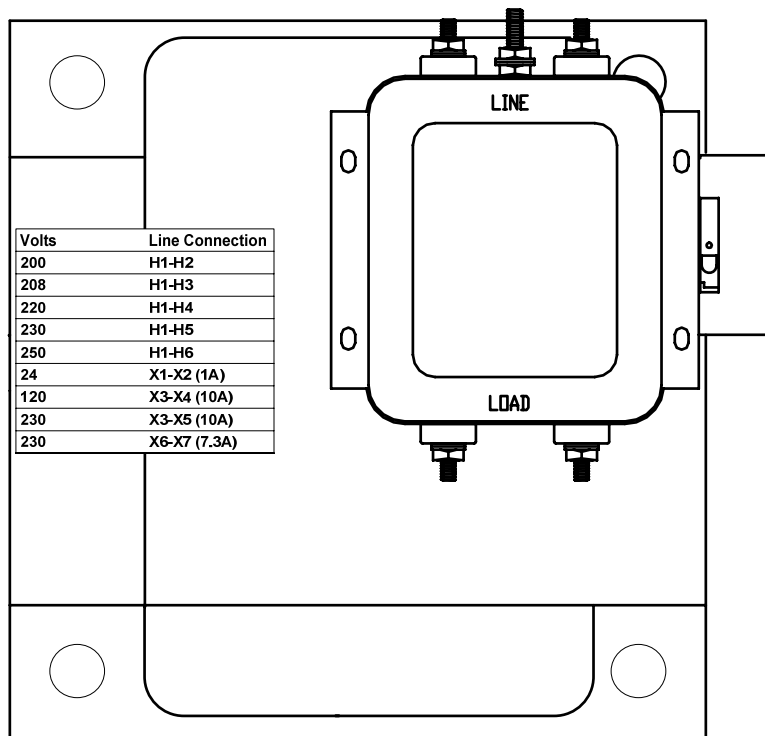
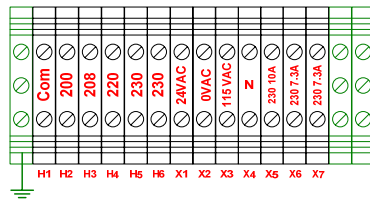
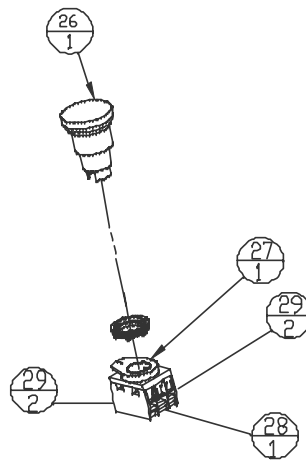


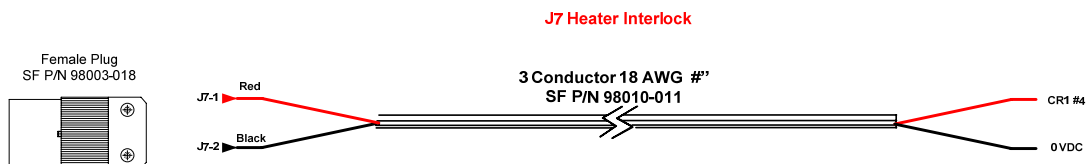
FIG. 15B



**SURE JET VACUUM BASE (Fig. 16)
 ELECTRICAL ASSEMBLY 16020-160**

| ITEM | PART NO | QTY | DESCRIPTION |
|------|------------------|----------|-----------------------------------|
| | 16021-007 | 1 | ASSEMBLY, HEATER CABLE, J7 |
| | 98010-074 | 6 FT | CABLE, SHIELDED, 18/3 |
| | 98003-018 | 1 | RECEPTACLE, HUBBLE TWIST LOCK |
| | 16021-006 | 1 | ASSEMBLY, POWER CABLE |
| | 98010-186 | 13.5 FT | WIRE, 12/3 HAR EXPORT BLACK |
| | 98003-017 | 1 | PLUG, HUBBLE TWIST LOCK 20A |

HEATER CABLE
 16021-007



POWER CABLE
 16021-006



**SURE JET VACUUM BASE (Fig. 17A & B)
 J-BOX PLC ASSEMBLY 16020-162**

| ITEM | PART NO | QTY | DESCRIPTION |
|------------|------------------|----------|--|
| 18 | 16013-088 | 1 | COVER, ENCLOSURE, J-BOX |
| 19 | 16013-087 | 1 | ENCLOSURE, J-BOX |
| | 16013-103 | 1 | COVER, TRANSFORMER |
| | 98015-037 | 1 | GROMMET, RUBBER, 7/8" |
| | 98015-038 | 1 | GROMMET, RUBBER, 1-1/16" |
| REF | 16021-010 | 1 | ASSY, BACK PANEL, J-BOX ENCLOSURE (SEE FIG 17A) |
| 2 | 98001-062 | 2 | GROUND TERMINAL |
| 3 | 98001-060 | 16 | SPRING TERMINAL BLOCK |
| 5 | 98001-063 | 5 | FUSE BLOCK |
| 6 | 98001-064 | 2 | SIDE COVER, TERMINAL BLOCK |
| 7 | 98004-017 | 5 | FUSE, 1 AMP, 250V, 5X20MM GMC |
| 9 | 98001-072 | 4 | TERMINAL, END STOP |
| 11 | 98001-065 | 2 | JUMPER, 3 POLE, TERMINAL BLOCK |
| 12 | 98001-022 | 1 FT | DIN RAIL |
| 13 | 98012-003 | 4 ft | DUCT, WIRE W/COVER, 1" X 3" |
| 14 | 98013-054 | 1 | PLC, FX1N |
| 17 | 98011-007 | 1 | POWER SUPPLY |
| 20 | 16011-155 | 1 | PLATE, PANEL MOUNTING |
| 21 | 98001-073 | 2 | BRIDGE, 2 POSITION |
| 22 | 98001-074 | 1 | BRIDGE, 3 " |
| 23 | 98001-075 | 1 | BRIDGE, 4 " |
| 24 | 98001-076 | 1 | BRIDGE , 5 POSITION |
| | 16021-033 | 1 | ASSY, COMPUTER CABLE, J4 (SEE FIG 17B) |
| | 98016-015 | 2 | BACKSHELL, PLASTIC, SIZE 11 |
| | 98016-046 | 1 | PLUG, AMP, 11-8 STD (FEMALE) |
| | 98016-145 | 8 | CONTACT, GOLD SOCKET, 20-24 AWG |
| | 98010-012 | 8 ft | CABLE, BELDEN, B9934-060 |
| | 16021-034 | 1 | ASSY, PHOTOCCELL CABLE, J1 OR J2 (SEE FIG 17B) |
| | 98016-117 | 3 | CONTACT, SOCKET 26-24 AWG |
| | 98015-004 | 1 | LOCK NUT, 3/4" |
| | 98016-114 | 3 | CONTACT, PIN, 26-24 AWG |

FIG 17A

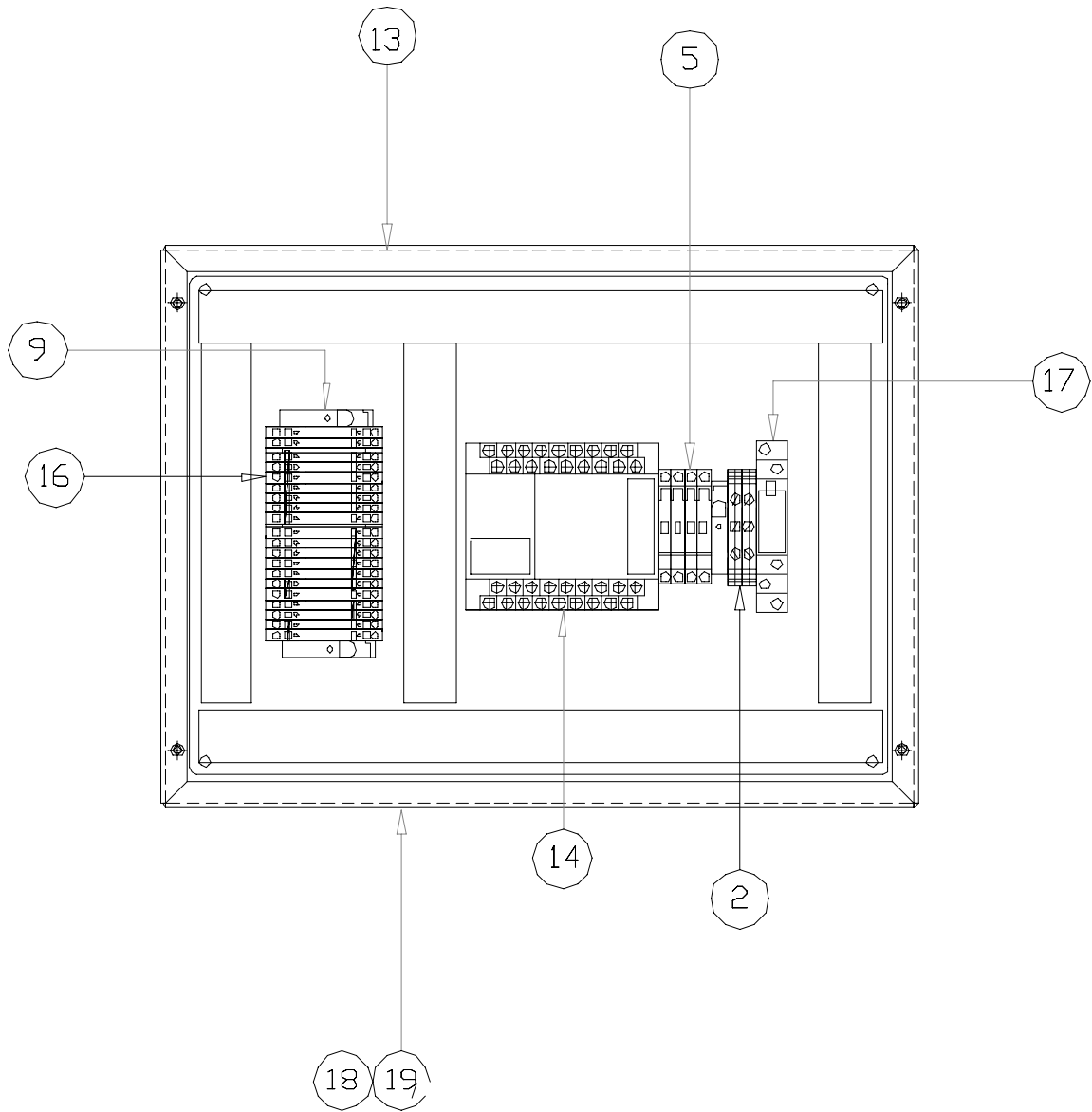
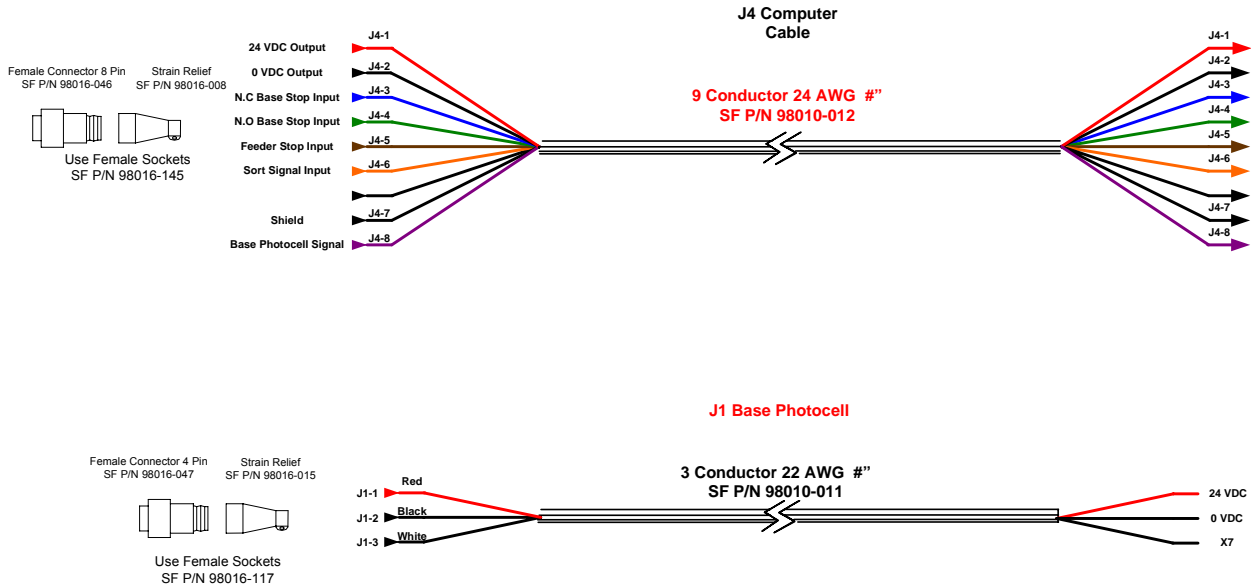


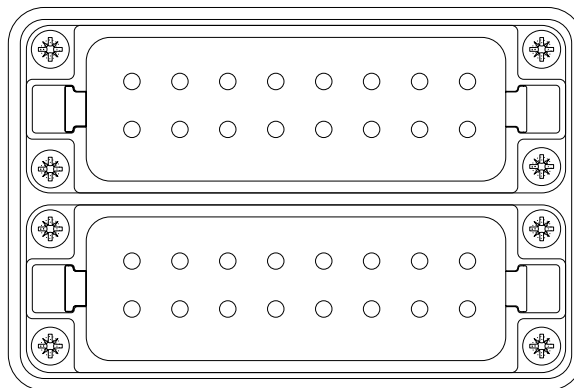
FIG 17B



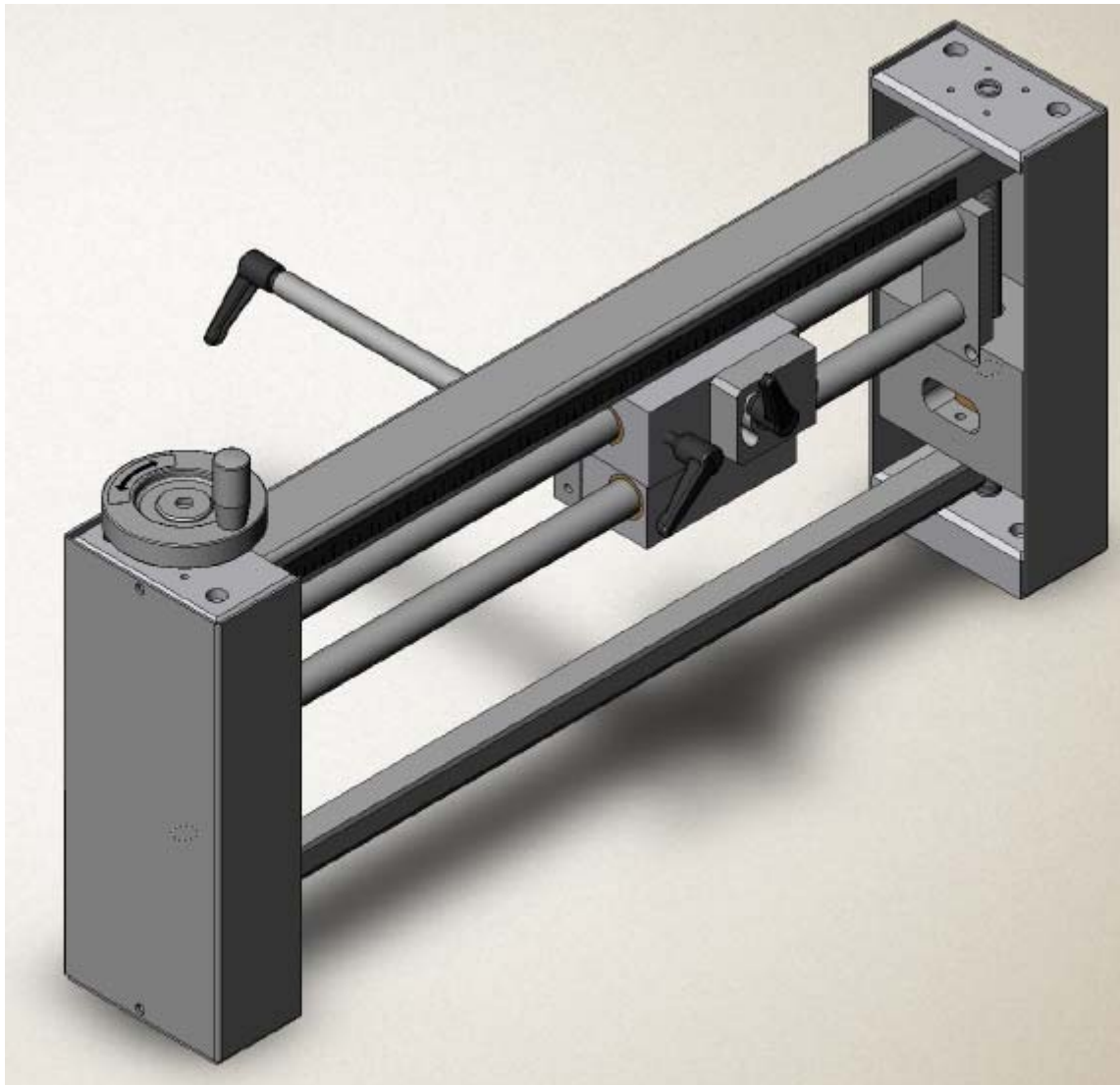
**SURE JET VACUUM BASE (Fig.18)
 PLUG RECEPTACLE ASSEMBLY**

| ITEM | PART NO | QTY | DESCRIPTION |
|------|------------------|----------|---|
| | 16020-159 | 1 | ASSEMBLY, PLUG RECEPTACLE (BASE 1 & 2) |
| 1 | 98016-154 | 2 | FEMALE INSERT, A16 SERIES, 16 POS, #1-16 |
| 2 | 98016-156 | 2 | FEMALE INSERT. A16 SERIES, 16 POS, #17-32 |
| 3 | 98016-158 | 2 | BASE, PANEL MTG, W/DOUBLE LOCKING LATCH |
| 4 | 98016-159 | 2 | PROTECTIVE COVER |
| 5 | 16011-142 | 2 | PLATE, PLUG MOUNTING (NOT SHOWN) |

J-11 & J-6



OPTIONAL PRINT HEAD



PRINT BRIDGE ASSEMBLY 16020-091 (Fig. 19)

| ITEM | PART NO. | QTY. | DESCRIPTION |
|-----------|------------------|----------|---|
| 1 | 16011-253 | 2 | PLATE, BASE INK JET BRIDGE |
| 2 | 16004-157 | 4 | SHAFT, BEARING, VERTICAL |
| 3 | 16011-038 | 2 | PLATE, BASE INK JET BRIDGE |
| 4 | 16007-139 | 2 | BLOCK, BEARING, VERTICAL |
| 5 | 99003-039 | 8 | BUSHING, SL, 1/2 X 3/4 X 1/2 |
| 6 | 16008-116 | 1 | BAR, BEARING LEVELER |
| 7 | 16009-104 | 2 | BAR, SHAFT MOUNTING |
| 8 | 16004-038 | 2 | SHAFT, HORIZONTAL BRIDGE |
| 9 | 99003-076 | 2 | BUSHING, FL, 1/4 X 3/8 X 3/8 |
| 10 | 99003-036 | 2 | BUSHING, 3/8 X 1/2 X 5/8 |
| 11 | 16004-034 | 1 | SHAFT, SCREW, VERTICAL, BRIDGE |
| 12 | 16004-035 | 1 | SHAFT, SCREW, VERTICAL, BRIDGE |
| 13 | 99002-075 | 2 | PULLEY, 15XL075, 1/2B W/ KEYWAY |
| 14 | 16013-026 | 1 | SHROUD, BELT GUARD |
| 15 | 99000-119 | 1 | BELT, 460XL037 |
| 16 | 16019-002 | 2 | NUT, ADJUSTING |
| 17 | 99004-008 | 1 | HANDWHEEL W/ REVOLVING KNOB |
| 18 | 16013-203 | 2 | GUARD, END, BRIDGE |
| 19 | 16020-508 | 1 | ASSEMBLY, PRINT HEAD MTG, RH |
| | 99003-085 | 2 | BUSHING, 3/4 X 15/16 X 1-1/2 |
| | 16007-050 | 1 | BLOCK, PRINT HD, MTG, RH |
| 20 | 16020-509 | 1 | ASSEMBLY, PRINT HEAD MTG, LH |
| | 99003-085 | 2 | BUSHING, 3/4 X 15/16 X 1-1/2 |
| | 16007-051 | 1 | BLOCK, PRINT HD, MTG, LH |
| 21 | 99004-027 | 3 | HANDLE, RATCHET, 1/4-20 X 1.18 |
| 22 | 16007-048 | 1 | BLOCK, PIVOT, HEAD MTG |
| 23 | 16007-049 | 1 | PIVOT BLOCK, HEAD MTG |
| 24 | 99033-017 | 2 | SHOULDER BOLT, 3/8 X 5/16-24 X 3/4 |
| 25 | 99004-026 | 2 | HANDLE, RATCHET, 1/4-20 X 0.59 |
| 26 | 99003-016 | 2 | WASHER, NYLON, 3/8 X 1/32 THK |
| 27 | 99003-017 | 2 | WASHER, NYLON, 3/8 X 1/16 THK |
| 28 | 99003-013 | 2 | WASHER, NYLON, 1/4 X 1/16 THK |
| 29 | 99036-011 | 2 | WASHER, CONICAL |
| 30 | 16015-010 | 1 | LABEL, BRIDGE ADJ |
| 31 | 16015-022 | 1 | LABEL, BRIDGE SCALE |
| 32 | 16004-040 | 1 | EXTENSION, RATCHET HANDLE |
| - | 16004-041 | OPT | EXTENSION, RATCHET HANDLE (USED W/4" PRISM HEAD |

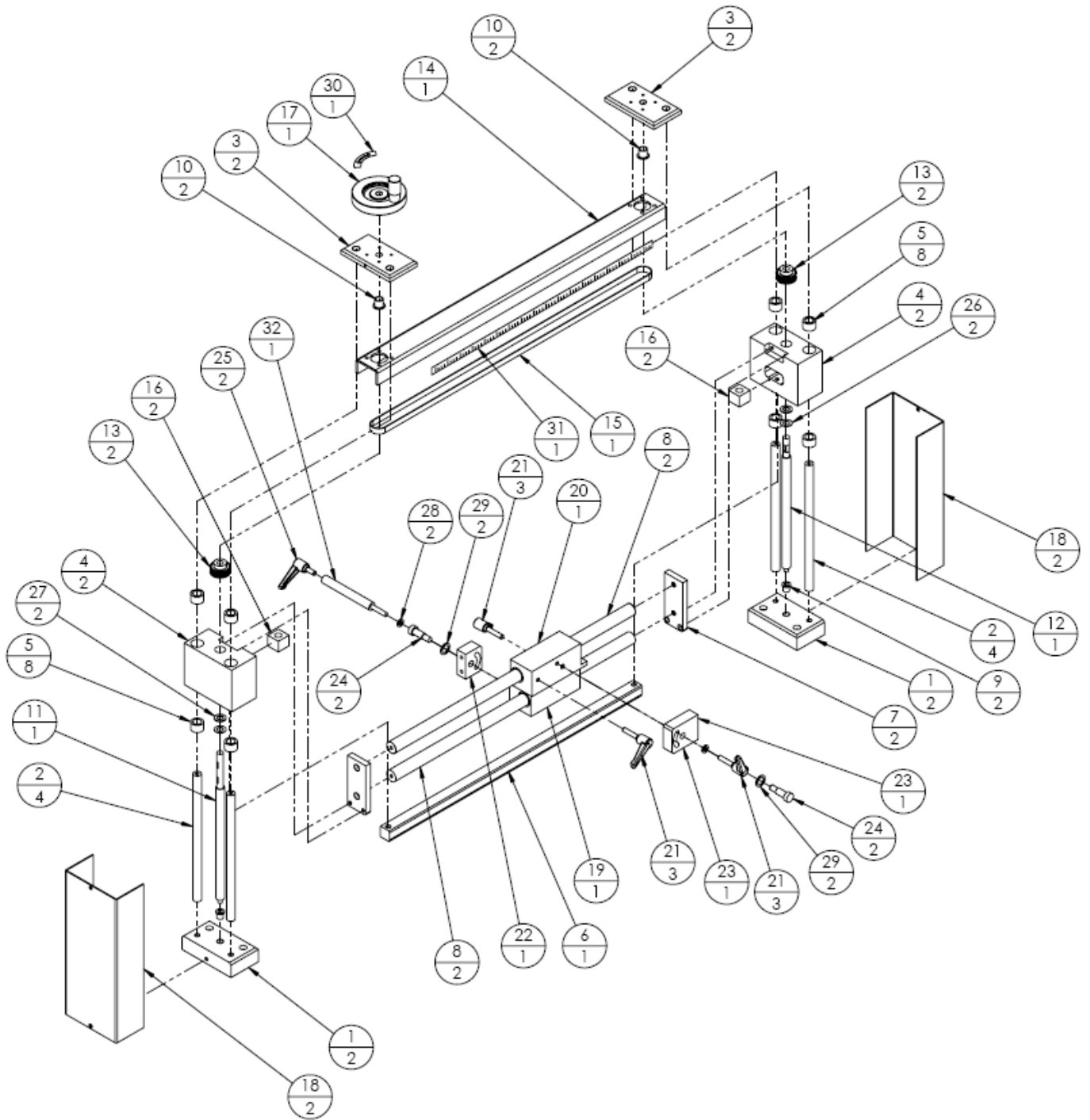


FIG 19