P-1250
Feeder

Manual

Shown as
EX Configuration

BW Integrated Systems
A **Barry-Wehmiller** Packaging Company

Streamfeeder®

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Before You Begin

Message Conventions

DANGER signifies an action or specific equipment area that can result in serious injury or death if proper precautions are not taken.

WARNING signifies an action or specific equipment area that can result in personal injury if proper precautions are not taken.

CAUTION signifies an action or specific equipment area that can result in equipment damage if proper precautions are not taken.

ELECTRICAL DANGER signifies an action or specific equipment area that can result in personal injury or death from an electrical hazard if proper precautions are not taken.

TIP signifies information that is provided to help minimize problems in the installation or operation of the feeder.

NOTE provides useful additional information that the installer or operator should be aware of to perform a certain task.

CHECK signifies an action that should be reviewed by the operator before proceeding.

IMPORTANT alerts the installer or operator to actions that can potentially lead to problems or equipment damage if instructions are not followed properly.

TECHNICIAN indicates that a qualified technician should be alerted to the corresponding tasks and information.

OPERATOR indicates that an operator should be alerted to the corresponding tasks and information.

WARNING LABELS affixed to this product signify an action or specific equipment area that can result in serious injury or death if proper precautions are not taken.

SAFETY

TECHNICIAN

OPERATOR

Make sure you thoroughly read this section to become familiar with all the safety issues relating to the safe operation of this product.

Please read all of the warnings that follow to avoid possible injury. Although Thiele-Streamfeeder has made every effort to incorporate safety features in the design of this feeder, there are residual risks that an installer or operator should be aware of to prevent personal injury.

Please read all of the cautions that follow to prevent damage to this product. This product is built with the highest quality materials. However, damage can occur if the system is not operated and cared for within design guidelines as recommended by Thiele-Streamfeeder.

To insure proper machine operation make sure that all the safety devices are installed properly and functioning. If the feeder has the media sensor on the side guides insure that these are properly installed. Do not attempt to defeat a safety interlock or safety feature.

Danger

Equipment interior contains incoming 115 or 230VAC electrical power. Bodily contact with these high voltages can cause electrocution, which can result in serious injury or death.

SPECIFICATIONS

Maximum Product Size..... 12 W x 14 L in (30.4 x 35.5 cm)

Minimum Material Size..... 2.0 in. W x 2.5 in. L (50.8 mm x 63.5 mm)

Min/Max Product Thickness.... .003 in to 1 in. (.07 mm - 25.4 mm)

Belt Speed..... 7000 in/min (14,000 cm/min or 178 meters)

Batch Size..... 1-999

Electrical Requirements..... 115/230V, 50/60Hz, 12/6A (configured)

Overall Dimensions..... 23.32 in. L (5.9 cm)
13.15 in. W (3.3 cm)
28.82 in. H (adjustable) (7.3 cm)

Weight..... 75 lbs. (34kg) (feeder)
25 lbs. (11.34) (control box)

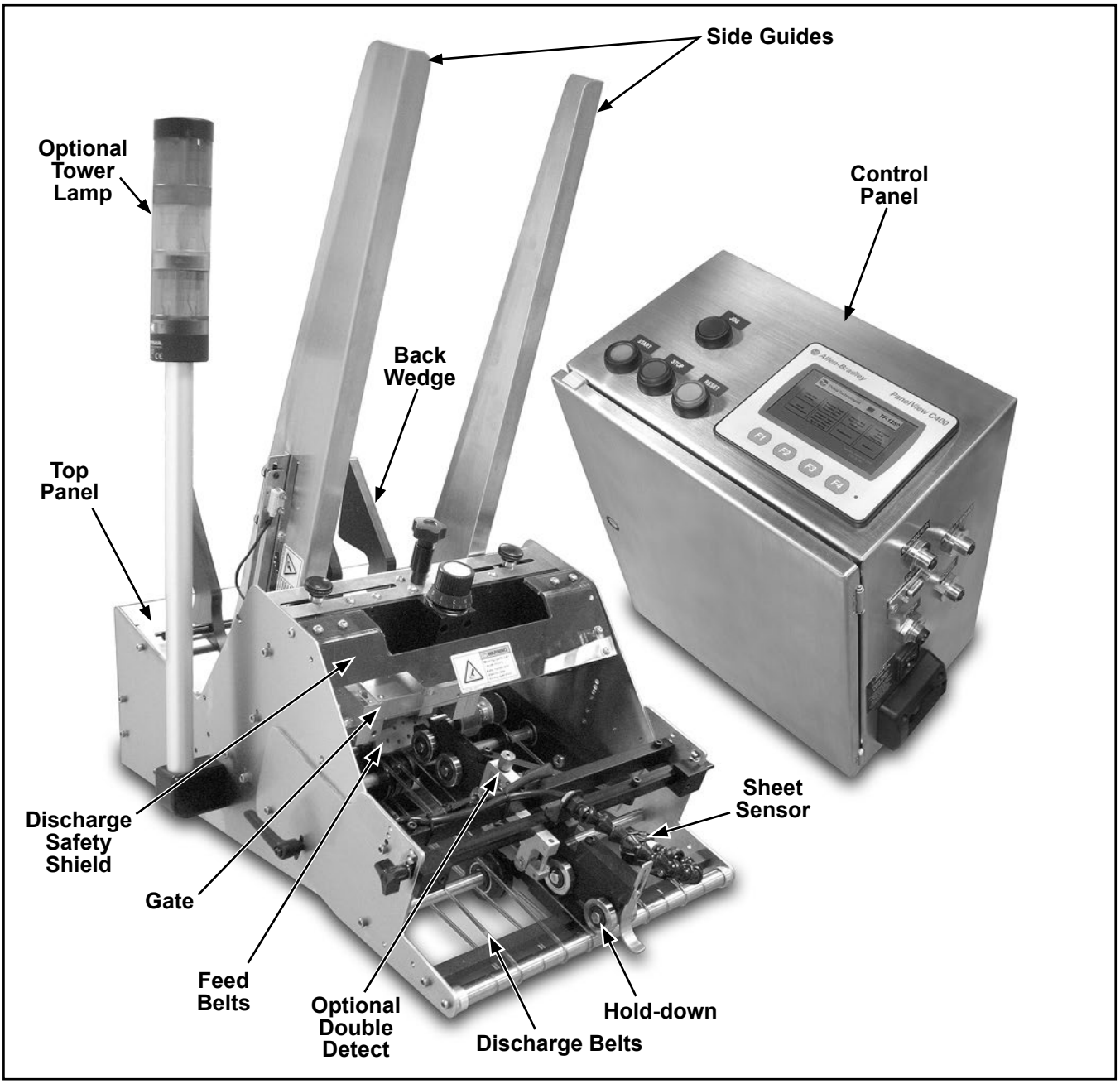
1 About the Machine

Features

The TF-1250 is designed for reliability, flexibility, and ease of use.

Review the diagram below to become familiar with names and locations of feeder parts and adjustments. This will help to prepare you for initial setup.

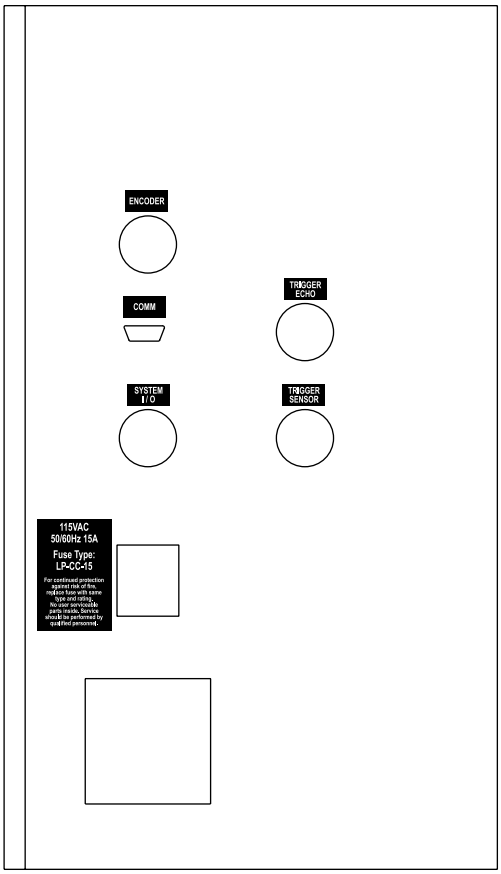
Main Assemblies



Main Assemblies Feature Descriptions

Feature	Description
Gate assembly and adjustment	*Mounted on a gate plate directly above the feed belts, this device provides a curvature to help preshingle stacked product. Adjustment knob allows you to set downward pressure. When properly adjusted, a one-thickness gap is created to help singulate product.*
Top panel (table top)	*Used to support the back wedge.*
Side guides and adjustments	*Holds a stack of product to be fed and helps keep it straight for proper entry through the gate assembly area. Adjustment knob allows you to move the side guides equally or offset for different size products.*
Back wedge and adjustments	*Lifts the product to keep it off the table top, reduces excessive contact with the feed belts, and helps push the product against the curvature of the gate assembly.*
Hold-down	*This series of rollers provides a varying pressure on top of product to force it down on the discharge belt, helping to singulate product after it exits the gate assembly area.*
Sheet Sensor	*Mounted on the feeder extension arm, it "looks" for the leading edge of the product to stop the feeder momentarily. For effective operation, a flexible extension allows you to adjust for various stopping positions.*
Feed belts	*Provides the friction and motion necessary to pull individual product from the bottom of the stack and through the gate assembly area.*
Discharge belts	*Combined with the hold-down rollers, provides the friction and motion necessary to pull product away from the gate assembly area. Rotates 50% faster than feed belts to separate and eject the bottom product away from next product entering the gate assembly area.*
Control panel	*All connectors and switches for sensor, interface, and AC power are located here. Also contains HMI display for operator control interface.*
Discharge safety shield	*Provides residual risk protection to operator when feeder is running.*
Stand (optional)	*Supports the feeder and allows for easy mobility. Includes built-in height adjustment.*
Tower lamp (optional)	*Mounted on the feeder, it contains green, amber, and red colored lights which alert the operator to various status conditions.*
Double Detect (optional)	*When active, will detect multiple products overlapped on one another. Also known as double feed.*

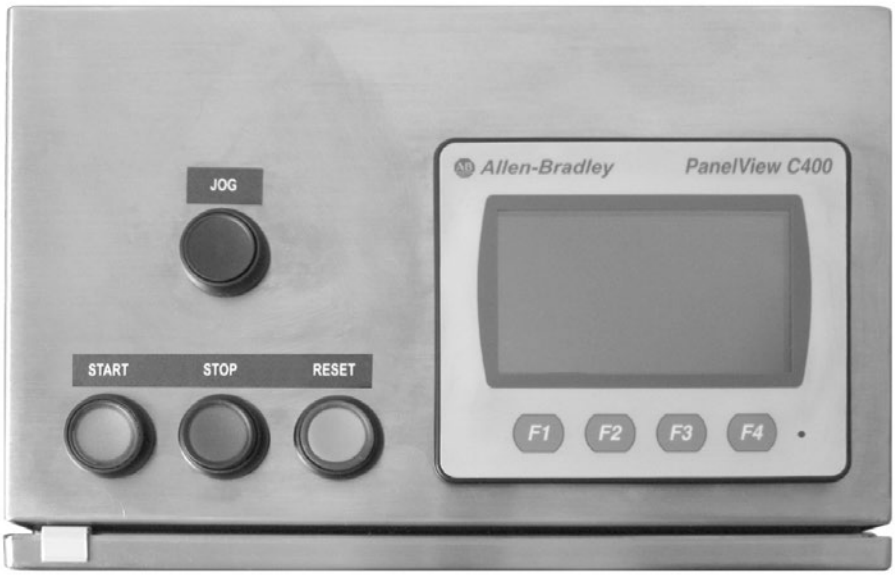
Control Panel Components



Feature	Description
AC power cordset connector	Cordset plugs into this IEC320 connector to provide feeder with power from 115-VAC or 230-VAC outlet.
Power On/Off	Toggles AC power On or Off.
Encoder	This 4 pin connector is used to interface with an encoder signal. The speed following feature requires this input from an optional encoder kit.
Communications port (COMM)	This 9-pin connector is used to either receive control/data signals from a computer, or send control/data signals to a computer.
Trigger Echo	Used to trigger a secondary device. Matches trigger signal supplied by trigger sensor.
System I/O	This 14 pin connector is used for output to other devices, either AC or DC voltages, and/or receive input control signals.
Trigger Sensor	The remote flight-detect sensor plugs into this 4 pin connector to provide a “start” signal to begin a feed cycle.

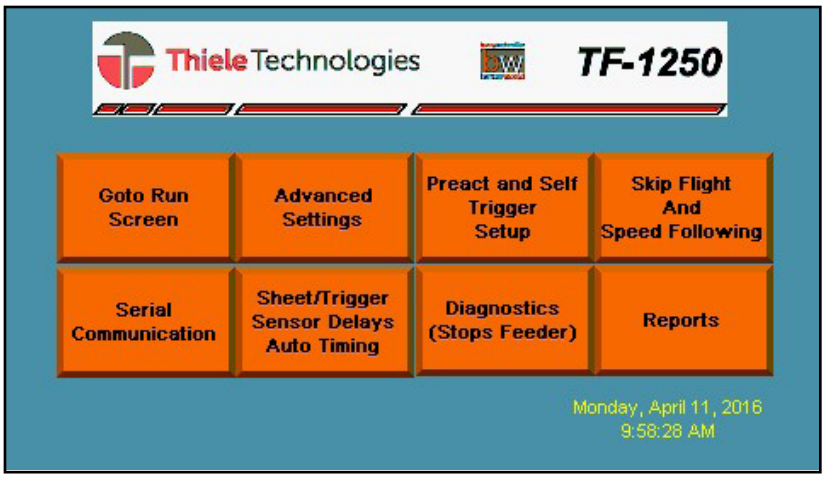
Control Interface Components

The control interface consists of an HMI display which allows you to not only control the operation of the TF-1250, but it also allows you to monitor the status of the job being run.



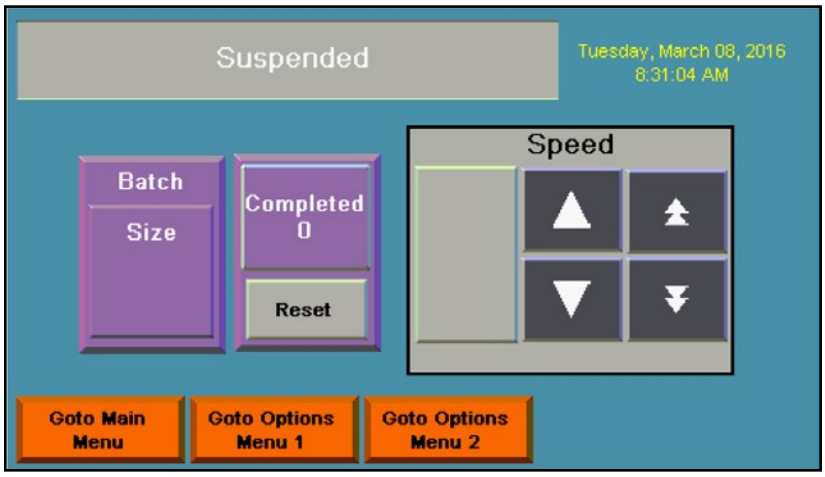
Feature	Description
Jog	When pressed, advances the feed and discharge belts. Used during setup and to clear feeding errors.
Start	When depressed will start feeder.
Stop	When depressed will stop feeder and become illuminated along with red lamp on optional tower lamp. Will stay illuminated until start button is depressed. Both red lamps will then shut off.
Reset	Will illuminate during fault conditions. Once fault has been addressed, depressing button will allow feeder to return to stop mode. Shutting off amber pushbutton and optional tower lamp illumination.
Operating Touch Screen (HMI)	All operating functions and setups (menu navigation) are managed and controlled from this screen.

Control Interface (continued)



MAIN MENU

This is the MAIN menu. Upon power up, this screen is displayed. The buttons when pressed open up the designated screen.



RUN SCREEN

Upper left box will show a number of different message displays dependent on the current feeder condition. They may fall under three different scenarios.

Control Interface (continued)

RUN SCREEN (continued)

Status: Running, Staging, Suspended, Stopped, Continuous Mode, Self-Trigger Mode, and Pre-act Count Too Large.

Fault: Time Out, Double Product Detected, Miss, and Guard Switch Open.

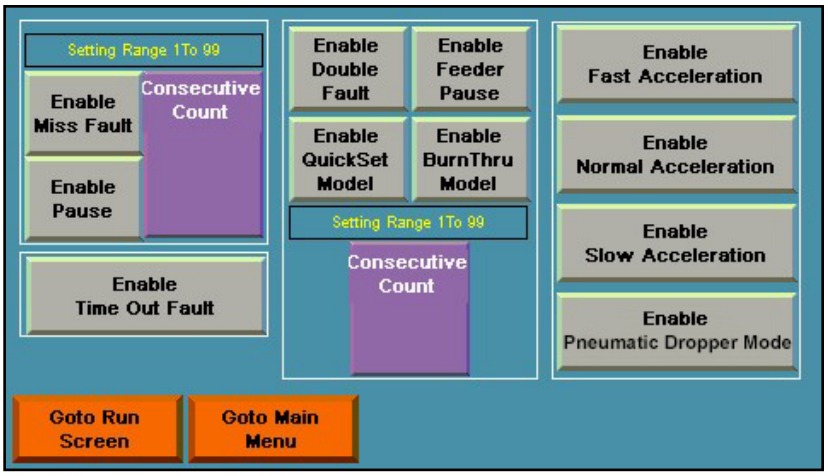
Warning: Low Product, and Barcode Error.

Batch Size: When depressed, batch size can be entered ranging from 1 to 999.

Completed Batches: Display shows completed batches range from 1 to 999. Depressing “Reset” returns batch size to 0.

Speed: Display shows feeder speed as a percentage of total speed capability. Depress arrows to set desired speed. Double arrows changes speed by 10’s. Single arrow allows setting to be controlled by single digits.

Control Interface (continued)



ADVANCED SETTINGS

NOTE

With any box enabled, box will illuminate in "green".

Enable Miss Fault: When enabled a trigger coming before the last batch is complete increments the Miss Count.

Enable Pause: When enabled stops the feeder on a Miss Fault.

Consecutive Count: Enter the number off consecutive misses allowed before the fault is activated.

Enable Double Fault: When enabled a Double Product Detector senses if multiple pieces have fed through the separator on top of each other and increments the Double Count.

Enable QuickSet Model: Enable this when a QuickSet model detector is installed.

Enable Feeder Pause: when enabled stops the feeder on a Double Fault.

Enable BurnThru Model: Enable this when a BurnThru model detector is installed.

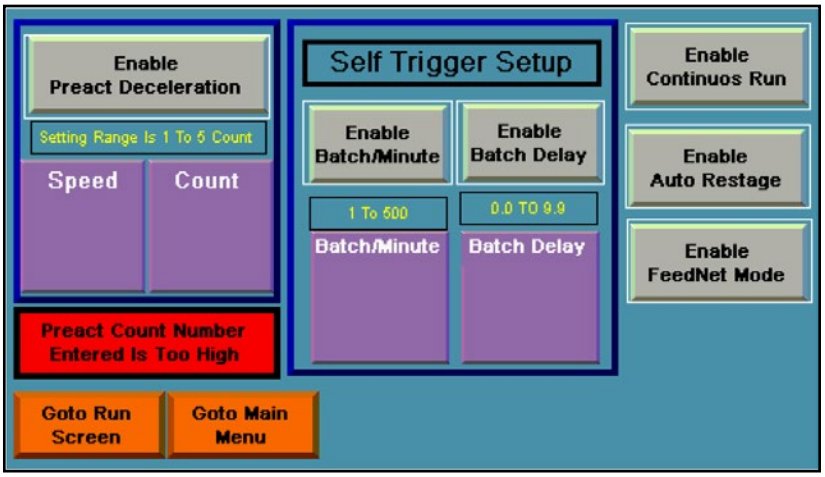
Consecutive Count: Enter the number off consecutive double feeds allowed before the fault is activated.

Enable Fast, Normal, Slow Acceleration: Select the aggressiveness of feeder acceleration required to achieve needed rates using the lowest speed setting as possible.

Enable Timeout Fault: Enables a timer that suspends feeder operation if no product passes under the sheet sensor for a predetermined amount of time.

Enable Pneumatic Dropper Mode: Enable Pneumatic Dropper Mode: When selected, feeder PLC acknowledges the fact that the pneumatic dropper is an attached accessory to the feeder and functions as necessary.

Control Interface (continued)



PREACT AND SELF TRIGGER SETUP

Self Trigger Setup: Provides automatic operation of machine for offline operation.

Enable Batch/Minute: When depressed will cycle the machine at a given rate.

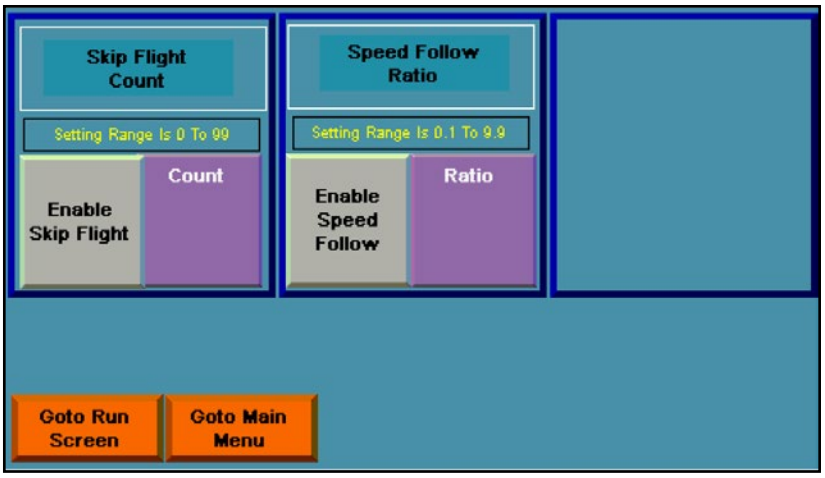
Enable Batch Delay: When depressed will allow batches to be based on a value of time from completion of a batch to the start of the next batch. Pre-set from 0 to 9.9 seconds between batches.

Enable Continuous Run: When depressed feeder will disregard the sheet sensor thus not stopping each piece at the sheet sensor as in One-Shot mode. Product will run continuously when the feeder is started.

Enable Auto Restage: When depressed assures the next piece of product within the feeder is automatically positioned at the sheet sensor when in ready mode.

Enable FeedNet Mode: When depressed allows feeder to be controlled by optional FeedNet supplied software and hardware (Controls).

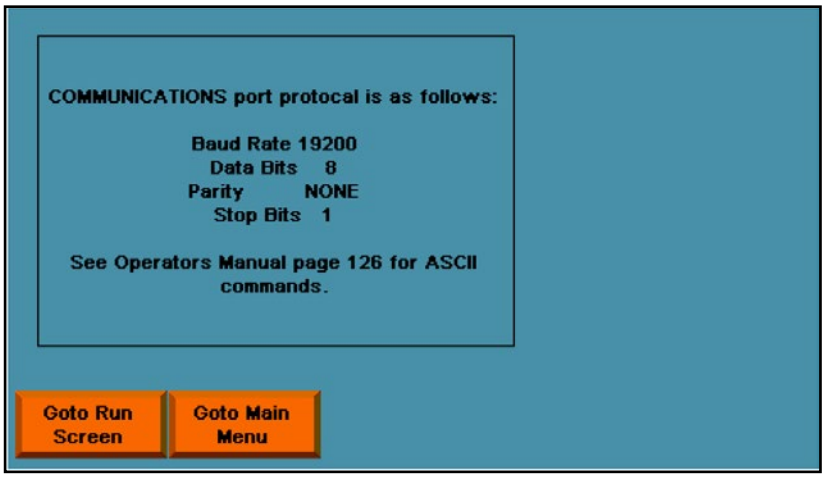
Control Interface (continued)



SKIP FLIGHT AND SPEED FOLLOWING

Enable Skip Flight: When depressed allows feeder to be set to skip feeds in sequential pocket after the first pocket which will always populate pocket. Downstream pockets to be skipped can be set from a minimum of 0 to a maximum of 99 lugs, triggers, or pockets.

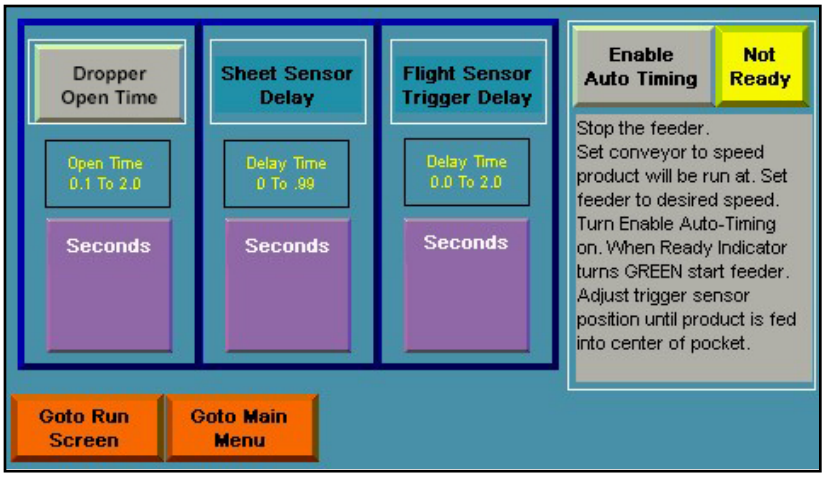
Enable Speed Follow: When enabled the speed of the feeder belts is determined by encoder counts from an optional encoder driven by a conveyor. Speed adjust is from 1 to 100, at a setting of 50 the feeder advances approximately 9 ½ inches of travel per revolution of a 100 PPR encoder. A setting of less than 50 lowers the travel distance per revolution and a setting of greater than 50 increases the distance per revolution. 50 setting is factory set as a match to the factory supplied encoder.



SERIAL COMMUNICATIONS

Baud rate is fixed and there is only 1 com port as of the current design.

Control Interface (continued)



SHEET/TRIGGER SENSOR DELAY - AUTO TIMING

Dropper Open Time *(for machines equipped with the dropper option)*: When enabled the Ready output turns on when a batch is ready in the dropper. The trigger input opens the dropper and when the dropper open time is done a new batch is fed into the dropper.

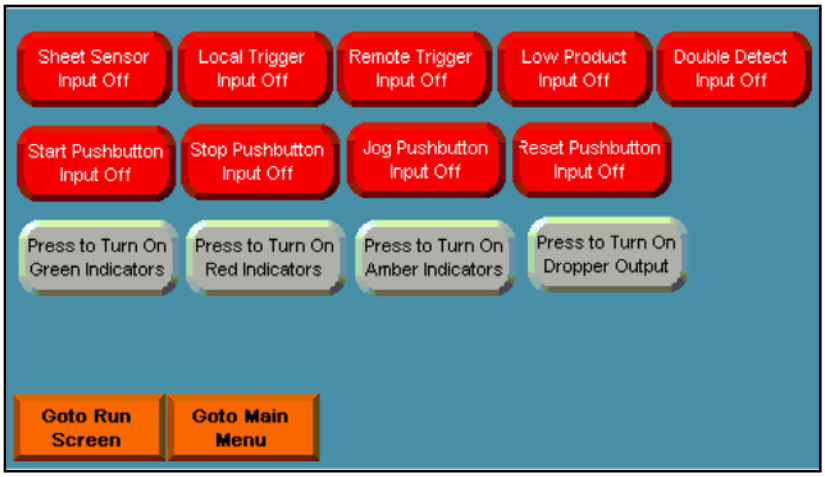
Sheet Sensor Delay: When depressed will delay the sensing of the leading product edge based on value added from 0 to .99 seconds. Result will be a slight coasting of the leading edge of the product past the sheet sensor location.

Flight Sensor Trigger Delay: When depressed will delay in the sent trigger signal after sensor is initiated by a value ranging from 0 to 2 seconds. Can be used to position product within pocket length.

Enable Auto Timing: There is an indicator indicating that the lug timing has been determined (turns green and displays 'Ready') and it is ok to start adjusting the position of the trigger sensor for placement in the pocket.

- Works with conveyor lug only
- PLC keeps track of time between lugs
- Can be used when sensor and encoder isn't available
- Changes timing of feeder trigger to match conveyor (lug) speed

Control Interface (continued)



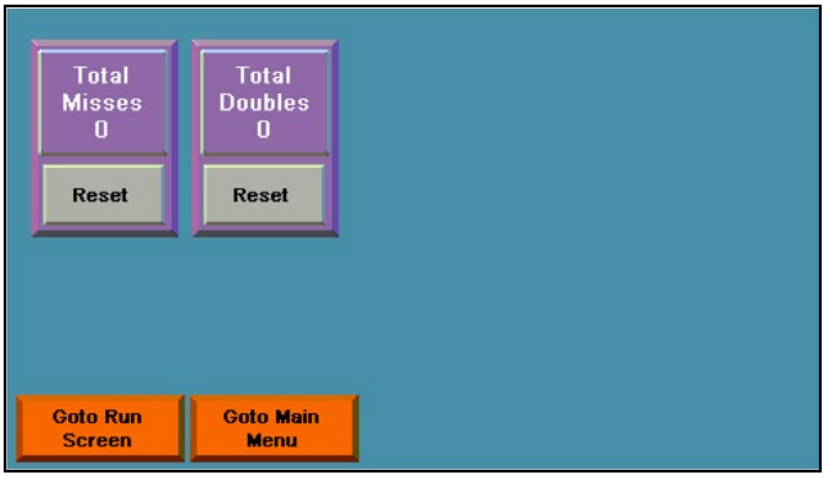
DIAGNOSTICS

When viewing this screen the feeder is disabled.

The input indicators turn green when the input for the corresponding actuator turns the PLC input on.

The Press to turn on buttons activate the associated output function when pressed.

Control Interface (continued)



REPORTS

Total Misses: When Miss Fault is enabled the total number of misses are tracked by this counter. Pressing Reset clears the count to zero.

Total Doubles: When Double Fault is enabled the total number of double faults are tracked by this counter. Pressing Reset clears the count to zero.

2 Preparing for Operation

When performing initial adjustments prior to operation, always make sure you turn Off the main power switch, open the discharge safety shield (to disengage the interlock), and disconnect feeder from the electrical power source. Failure to do so can expose you to a potential start-up and moving parts which can cause serious injury.

Do not attempt to make any adjustments while the machine is running. Failure to do so can expose you to moving parts which can cause serious injury. Do not wear loose clothing when operating the feeder. Avoid making adjustments with loose or unsecured parts. This can potentially damage parts.

Once the feeder is installed, you are ready to prepare the machine for operation. You must perform several adjustments with the product you are going to be feeding and do a test run with this product to verify that it is set correctly before going on-line. *You will have to perform this procedure for each product you plan to feed.*

The adjustments you must make (in order) are as follows:

1: Gate assembly adjustment

2: Side guides setting

3: Back wedge setting

4: Photo sensor adjustment

5: Manual test to verify

STEP 1: Gate Assembly Adjustment

NOTE

Hopper refers to the space where the product is stacked (made up of the side guides and gate plate).

NOTE

Keep in mind that the gate assembly works with the wedge to provide the proper lift, curvature of the product, and proper belt/product contact to separate and feed one sheet at a time.

Review

The gate assembly provides the curvature to help preshingle product and the proper gap to help the feed belts advance product through the gate assembly area — one at a time. The downward pressure (or weight) of the stack in the hopper will provide the force to help push the product against the curvature of the gate assembly, and help it contact the feed belts. This preshingling will allow the gate assembly to separate (and singulate) product as it moves toward the gap.

To achieve the optimum separation, you have to use the adjustment knob to either increase (clockwise) or decrease (counterclockwise) the gap between gate assembly and the feed belts. Depending upon the characteristics of the product you are using, you may have to change the gate assembly from the factory-set *high* spring tension to a *low* spring tension. See “Changing from Factory Set High-Tension to Low-Tension” to follow.

Objective

Adjust the gate assembly for minimum gap, with minimum pressure on the product. Feeding problems will occur with either too much pressure on the product, or too large a gap between the gate assembly and the product.

STEP 1: Gate Assembly Adjustment (continued)

Excessive lowering of the gate assembly can damage product or lead to premature wear of the O-rings or feed belts.

If bottom piece of material does not move freely, then the gate assembly is too tight. This can lead to premature wear of the O-rings or feed belts.

Due to the discharge belt and hold-down assembly spinning 50% faster than the feed belts, excessive gate assembly pressure can cause premature wear to O-rings or feed belts. Also see Step 4, Hold-Down Setting.

TIP

A wider gap between product and belt provides the highest tolerance for curled and bent edges.

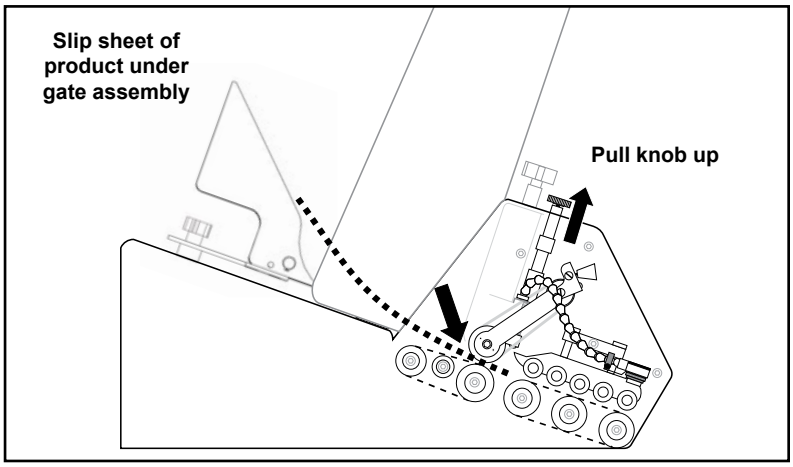
NOTE

Feeding problems will occur with either too much material in the hopper, or too large a gap between the gate assembly and the material.

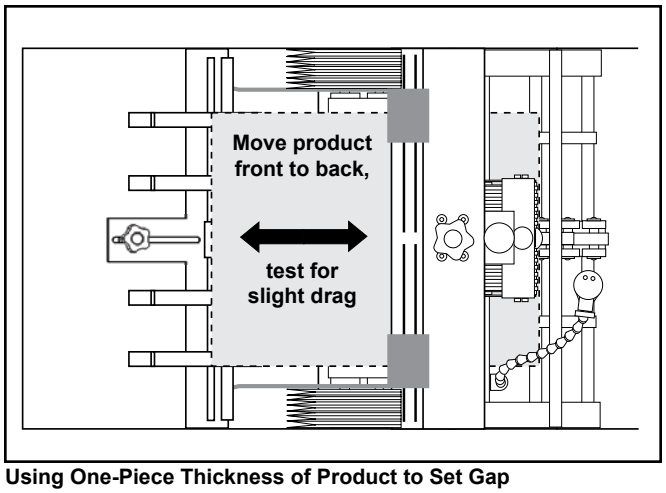
Procedure

To adjust the gate assembly for proper gap:

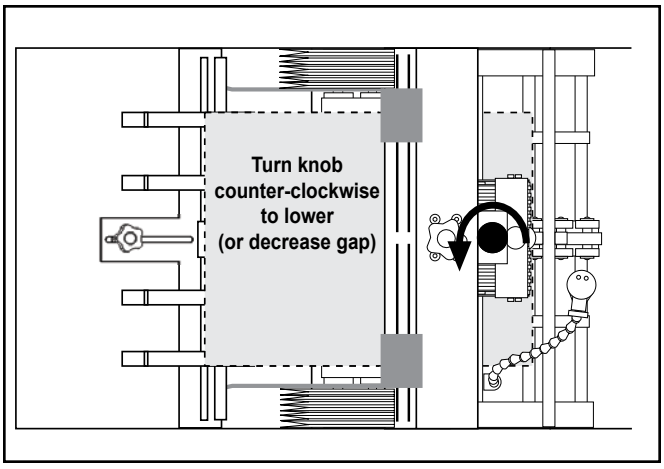
1. Slide a single sheet of test product under the gate assembly. It may be necessary to pull up on the adjustment knob to allow the piece to be inserted.
2. Test the piece for clearance. Grasp the product with two hands and slide it front-to-back under the gate assembly. A proper adjustment allows a slight amount of drag on the top of the piece.
3. Adjust the knob on the gate assembly until the piece has the desired drag. Turn the knob clockwise to increase clearance or counterclockwise to decrease clearance.
4. Repeat the drag tests and adjust as needed to achieve acceptable clearance.



Lifting Gate Assembly Upward to Insert Product



Using One-Piece Thickness of Product to Set Gap



Adjusting Gate Assembly for Correct Gap

STEP 1: Gate Assembly Adjustment (continued)

NOTE

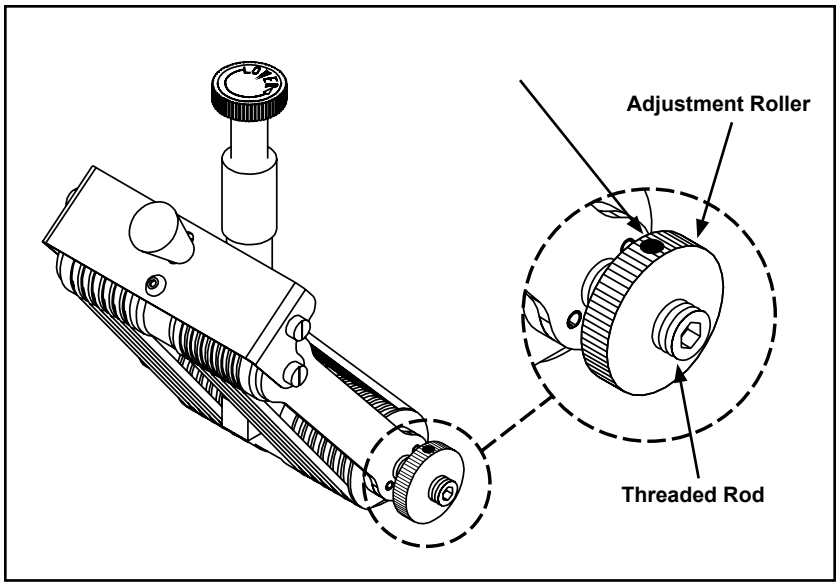
When feeding product with varying thickness throughout, it may be necessary to turn both adjustment rollers 1-2 ***full turns*** *counter-clockwise to compensate for the differential thickness. This procedure allows the gate horizon to "float."*

IMPORTANT

The adjustment knob set screws are pre-set at the factory to lock the knob to the threaded rod. DO NOT OVERTIGHTEN! Over-tightening the set screws may damage the components.

To adjust the Advancing O-ring Gate for effective material skew control, follow these steps:

1. Repeat drag test detailed on previous page.
2. Test the piece for uneven side-to-side drag. Grasp with two hands and slide it front-to-back under the gate assembly. A proper adjustment allows for equal drag on the left and right sides of the piece of material.
3. To compensate for greater drag on one side of the material, turn the *opposite* adjustment roller *counterclockwise* 1/8 turn. Next, turn the other adjustment roller *clockwise* 1/8 turn.
4. Repeat drag tests and adjust as needed until equal drag is achieved. You may need to repeat this procedure after observing the feeder cycling (refer to Section 3, How to Operate).

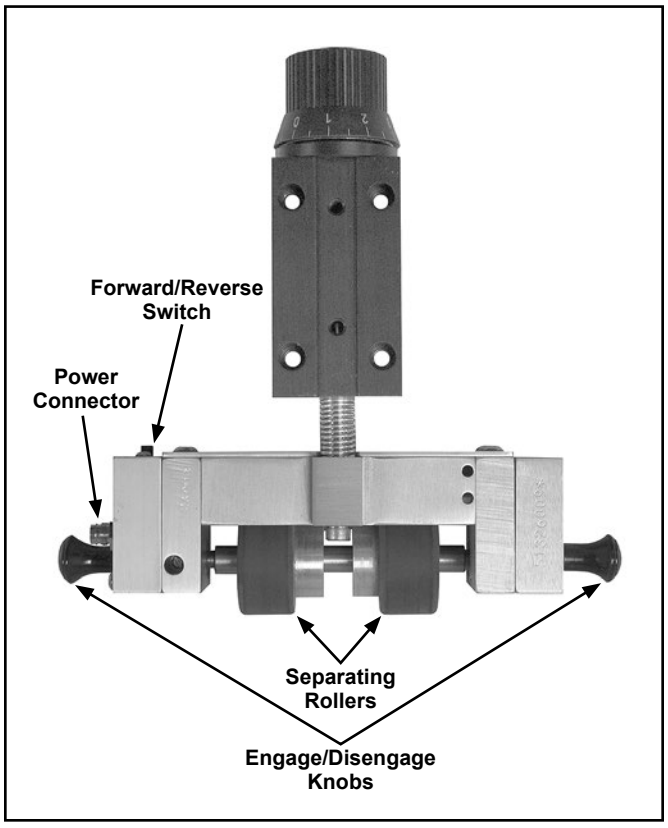


Horizon Adjustment Mechanism (shown on Advancing O-Ring Gate)

STEP 1: Gate Assembly Adjustment (continued)

NOTE

The ability to maintain the engaged position resides in the spring loaded ball-detent set screw as it is located directly across from a matching groove in the shaft. Sliding the shaft from side to side engages or disengages this ball detent.



Powered Rotating Gate Adjustments

To adjust the Powered Rotating Gate for effective material skew control, follow these steps:

1. Repeat drag test detailed on previous page.
2. Test the piece for uneven side-to-side drag. Grasp with two hands and slide it front-to-back under the gate assembly. A proper adjustment allows for equal drag on the left and right sides of the piece of material.
3. To compensate for greater drag on one side of the material, turn the *opposite* adjustment roller *counterclockwise* 1/8 turn. Next, turn the other adjustment roller *clockwise* 1/8 turn.
4. Repeat drag tests and adjust as needed until equal drag is achieved. You may need to repeat this procedure after observing the feeder cycling (refer to Section 3, How to Operate).

In addition to set-up, the Rotating gate has its own unique features. They are as follows:

- Power Connector: Black/Orange Cable & 3-pin connector provides gate motor with 24vdc power.
- Forward/Reverse Slide Switch: Changes polarity on the drive motor in turn changing the rotation of blue separating rollers. Common uses for both are:
  - o Forward: Thick product , slow speed, lower stack heights
  - o Reverse: Thin product, high speed, tall stack height
- Engaged /Disengaged “Blue” separating rollers: Both blue separating roller are attached to a common shaft. The shaft is equipped with a black knob located on each end. Adjustment right to left will assure you’re in the engaged position. In this position all the gearing is engaged with the motor providing the necessary drive for rotation and proper product separation.

Adjustment left to right separates the gearing from the drive motor which allows “free-rotation” of the blue rollers. This position is used for clearing product jams and the cleaning of the blue rollers.

Changing From Factory Set High-Tension to Low-Tension

Excessive lowering of the gate assembly can damage product or lead to premature wear of the O-rings or feed belts.

NOTE

Does not apply to Powered Rotating Gate.

Review

The feeder is shipped to you with a high-tension spring in the gate assembly. Certain types of product may demand that you change the gate assembly from a *high-tension* setting to a *low-tension* setting (for example, irregular shaped product). *This works well for most materials, allows for tall stack height, and helps provide the best performance in preventing doubles.*

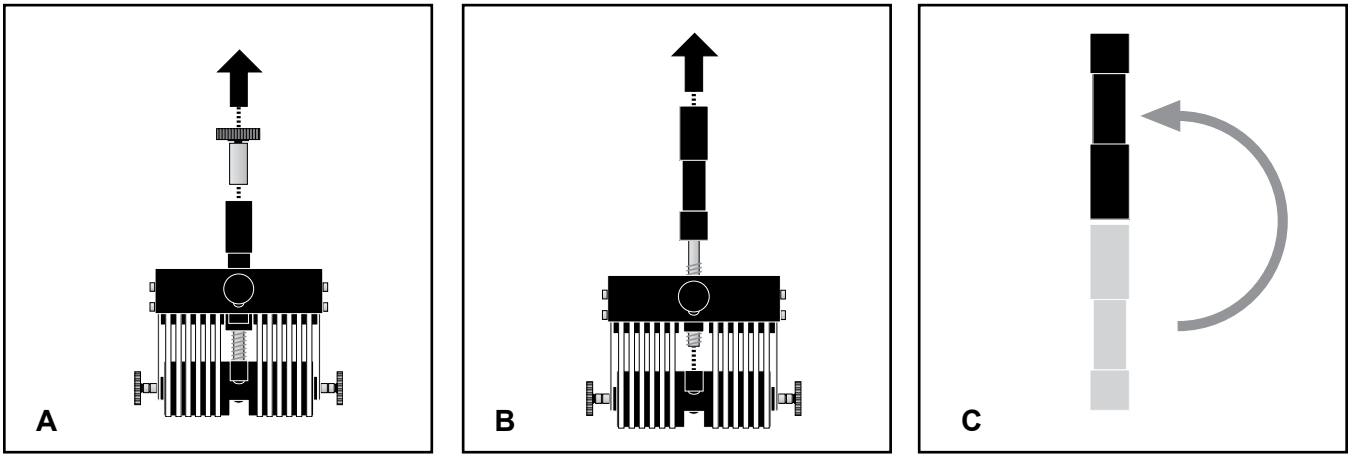
If you are feeding a product of irregular thickness, you should change to low-tension. This provides the following benefits:

- Allows the gate assembly to adjust to the irregular thickness among product pieces.
- Prevents marking on the product by the gate assembly.
- Prevents peeling back the top sheet of a multi-page product.

Procedure

To change the spring from a *high* to a *low* spring tension, follow these steps:

1. Remove the gate assembly from gate plate (lift up on knob and tip at slight angle to remove).
2. Remove the adjustment knob by turning counterclockwise (Fig. A).
3. Lift the cylinder off of top of spring (Fig. B).
4. Turn the cylinder around so that the cylinder collar faces up (Fig. C).
5. Place the cylinder on top of the spring.
6. Replace the adjustment knob (make about 8 revolutions of the knob before reinstalling gate assembly on gate plate).

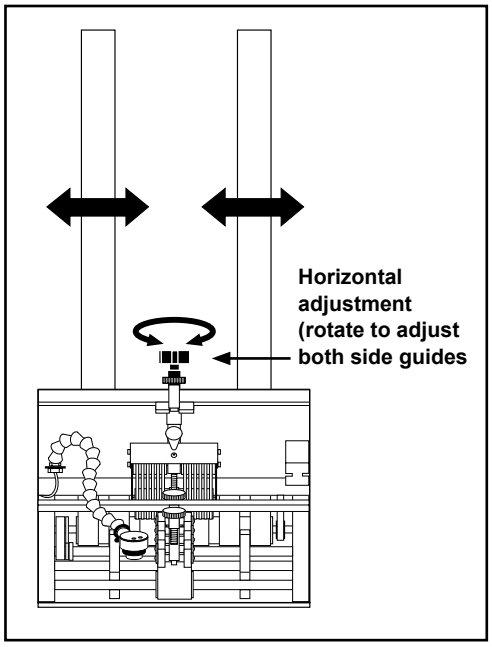


Adjusting Gate Assembly for Low-Tension

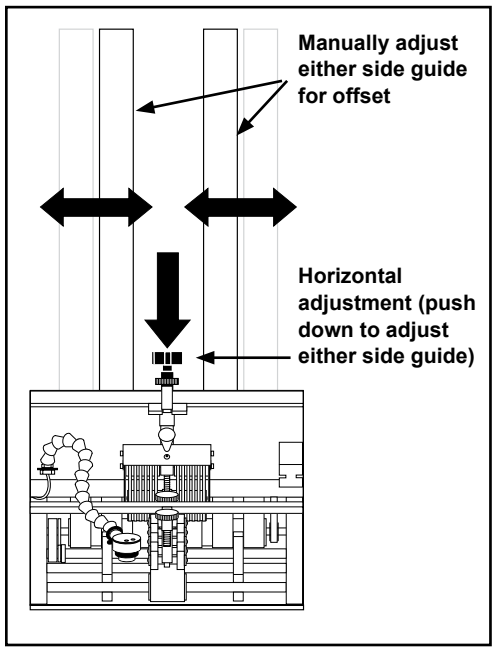
STEP 2:
Side Guides Setting

TIP

A good "rule-of-thumb" measurement to use is about 1/16 in. (1.6 mm) between product edge and side guide (1/8 in. or 3.1 mm overall).



Horizontal Adjustment of Side Guides



Individual Side Guide Offset

Review

The side guides hold the stack of product being fed and guide the product through the feeder in a straight line of movement. You can adjust the side guides to accommodate different sizes of product.

Objective

Adjust the side guides so the product stack maintains uniformity from top to bottom, with no drifting or binding. Adjustments are made *horizontally*.

Make sure the space between the side guides can accommodate the size of the product being fed. Consider the following as you adjust the guides:

- An initial starting point should always be that each guide is of equal distance from the center point of the machine.
- Each edge of the product should rest equally on belts either side of gate assembly (or equidistant spacing). *There can be certain instances where guides do not need to be centered due to product characteristics. This is called offset spacing.*
- Adjust both side guides to be as close as possible to either sides of the product, without causing binding, curling of edges, or resistance to movement.

Procedure

To adjust each side guide for proper *equidistant* horizontal spacing, follow these steps:

1. Place a small stack of product in the hopper.
2. Using the side guides adjustment knob (centrally located between the two guides), turn in either direction until guides are located at the recommended distance from the product: 1/16 in. (1.6 mm) for each edge, 1/8 in. (3.1 mm) overall.
3. Visually check both guides for proper spacing from product.

To adjust each side guide for proper *offset* horizontal spacing, follow these steps:

1. Push down on the side guides adjustment knob to disengage guides from gear mechanism.
2. Grasp whichever side you wish to offset first and move into position.
3. Place a small stack of product in the hopper, with edge of paper against offset guide.
4. Move the second side guide so that it is located at the recommended distance from the product: 1/16 in. (1.6 mm) for each edge, 1/8 in. (3.1 mm) overall.
5. Lift up on the adjustment knob so that the guides lock into place.
6. Visually check both guides for proper spacing from product.

STEP 3: Back Wedge Adjustment

NOTE

See Section 6 for detailed information for your specific wedge configuration.

NOTE

Keep in mind the back wedge works with the gate assembly to provide the proper lift, curvature of the product, and proper belt/product contact to separate and feed one sheet at a time.

TIP

There are a number of feeding problems which can be solved by simply adjusting the back wedge to different positions. Some of these problems include double feeds, skewing, twisting, poor singulation, ink or varnish buildup on the belts, and jamming at the gate assembly area.

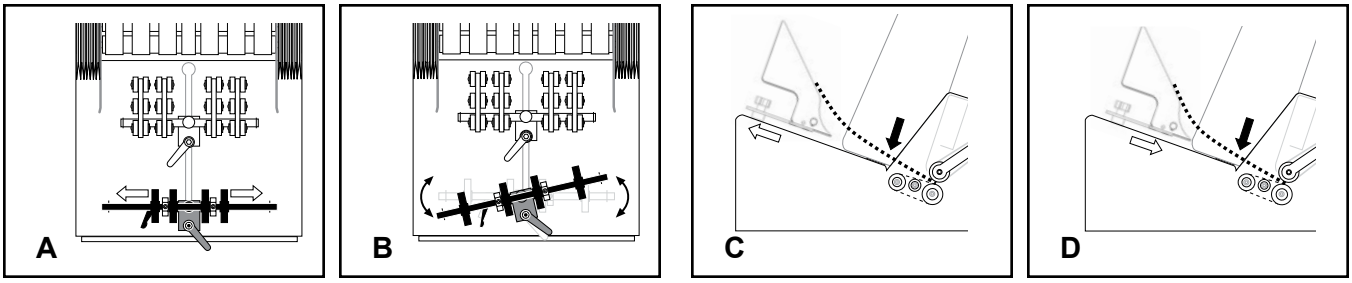
Review

The back wedge provides proper lift to the product to help keep it off the table top and feed belts, and it creates the force necessary to push product against the gate assembly. By adjusting it back and forth from the gate assembly or pivoting side to side, you can create the lift and force necessary to preshingle product against the curvature of the gate assembly. Also, it keeps other sheets off the feed belts until proper separation of the bottom sheet at the gate assembly has occurred.

Here are some general guidelines that should help you determine how the back wedge should be positioned for your particular product (for illustration purposes, the optional Articulating Roller Wedge is shown):

- *Moving the individual rollers to the outside* of the back wedge shaft (Fig. A) will create a bow in the center. The bow will stiffen the product to promote better singulation of thinner product.
- *Pivoting the back wedge from its perpendicular to the gate assembly* (Fig. B) will increase or decrease the amount of drag of contact (or traction) on the feed belts for a given side. This can also be used to control twisting or skewing of product as it leaves the gate assembly area.
- *If the back wedge is positioned too far backward* from the gate assembly (Fig. C), then the belts are driving the product before the bottom sheet has separated and left the gate assembly area. This pushes the gate assembly up, creating more pressure on the product, O-rings, and feed belts. The result can be premature buildup of ink or varnish on the belt surfaces. It can also cause more than one product at a time to be forced under the gate assembly, creating a double feed.

  By moving the back wedge forward, only the bottom product can make contact with the belt surface. Slippage is reduced, minimizing buildup on the belt surface. Double feeding is also reduced.
- *If the back wedge is positioned too far forward* to the gate assembly (Fig. D), then a pinch point can be created between the top surfaces of the individual rollers and the product. Moving the back wedge even closer toward the gate assembly can allow product to overhang the wedge, creating too much lift of the product off the feed belts.



Tips for Proper Back Wedge Adjustment

STEP 3:
Back Wedge Adjustment (continued)

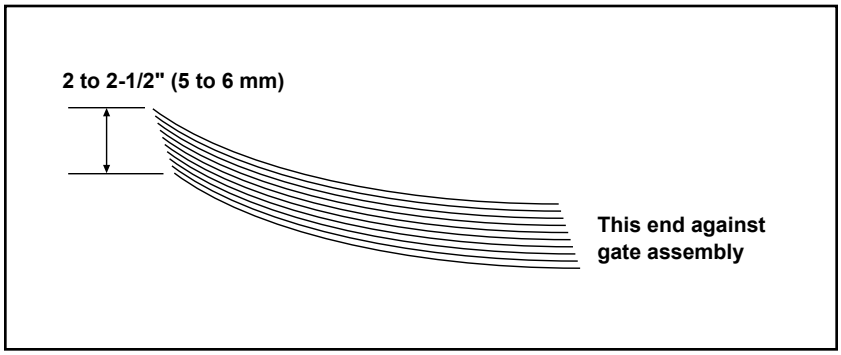
Objective

Adjust the back wedge for proper support of the product off the table top, without creating any pinch or stress points.

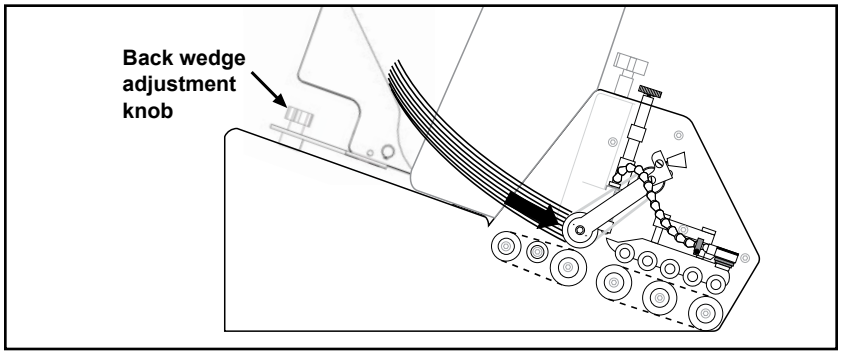
Procedure

To adjust the back wedge for initial proper positioning, follow these steps:

1. Grasp a handful of product, approximately 2 to 2-1/2 in. (5 to 6 cm) thick, and preshingle the edges with your thumb.
2. Place the preshingled material in the hopper so the edges rest against the curvature of the gate assembly.
3. Turn the back wedge adjustment knob counterclockwise to loosen the wedge.



Preshingling a Small Stack of Material By Hand



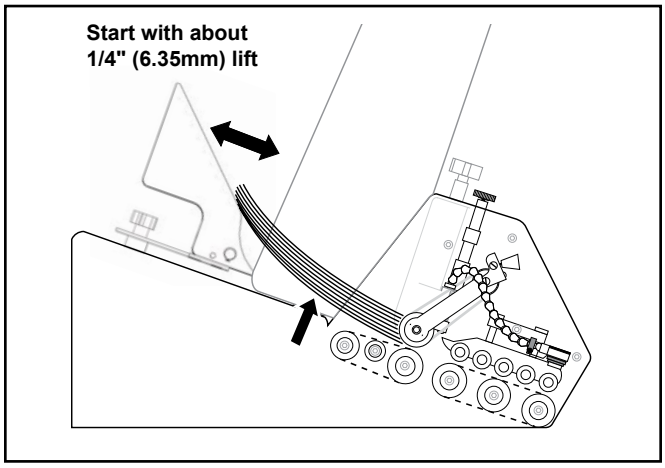
Positioning Product Prior to Loosening Back Wedge

STEP 3:
Back Wedge Adjustment (continued)

NOTE

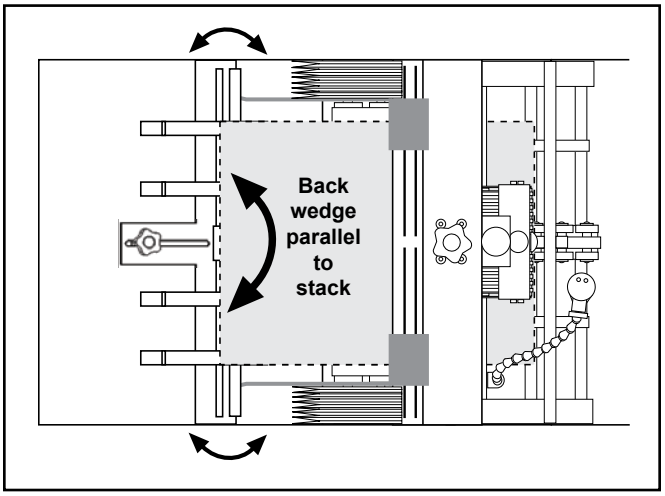
Moving the back wedge too far forward to the gate assembly can create a pinch point between upper surface of the wedge and the product. If moving the back wedge in is not effective, then an optional wedge may be required.

4. Move the back wedge forward and backward until the bottom sheet is not touching the table top. A good starting point is to measure about 1/4 in. (6.35 mm) from the bottom sheet to front edge of table top. Then as you test, you can "fine tune" from this point.

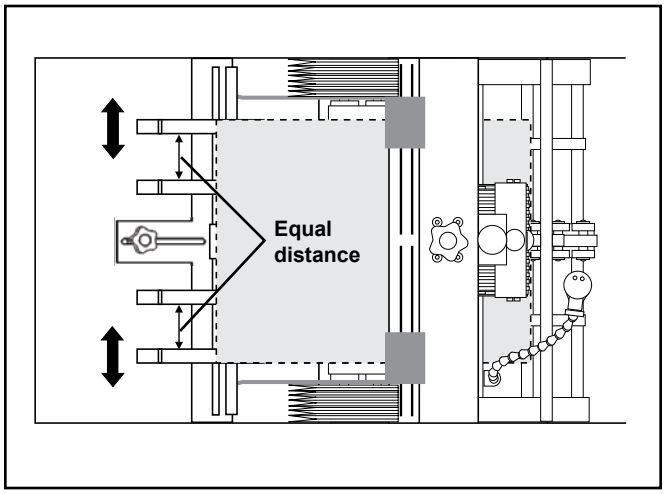


Adjusting Back Wedge for Proper Lift

5. Make sure the edge of the back wedge assembly is parallel with the edge of the product stack. Adjust as required and then tighten adjustment handle.
6. Check that individual wedge pegs are evenly spaced to provide enough support to lift the product off the table top and feed belts, without any bowing or twisting.



Adjusting Back Wedge for Parallel



Evenly Adjusting Individual Wedge Pegs

STEP 4: Photo Sensor Adjustment

Review

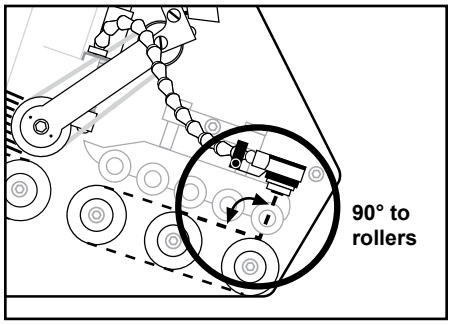
The **Flight-Detect** photo sensor is mounted on the line to detect a target and instruct the feeder to eject a product. The **Sheet-Detect** photo sensor is mounted on the flexible feeder extension assembly to detect the leading edge of a product about to be ejected.

Objective

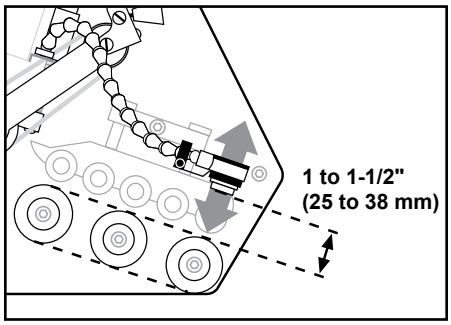
For the **Sheet-Detect** photo sensor to be effective, it must be adjusted within a specified range and angle to the product.

TIP

Avoid light colored backgrounds in the discharge area.



Adjusting for Perpendicular Position



Adjusting for Distance

Procedure

To adjust the **Sheet-Detect** photo sensor for proper positioning, follow these steps:

1. Aim and align the photo sensor straight toward (perpendicular to) the product. If the photo sensor is at an angle, the light will not be reflected straight back to the receiver.
2. Position the photo sensor at distance between 1 to 1-1/2 in. (25 to 38 mm) from the product. Initially, use the adjustable arms on the extension assembly. *When only the green LED is On, you will know when the photo sensor is positioned properly. The amber LED is On when product is staged.*
3. When making the adjustment, be aware of any background objects beyond the product range. *On the feeder, such objects as shafts, guides, belts, and supports may cause false returns if the photo sensor is not adjusted properly for the product (or target). The resulting problem can be continuous feeding. See Operational Troubleshooting for a solution.*

STEP 5:
Manual Test to Verify

Now that you have made all the necessary adjustments for operation, it is recommended that you verify the singulation and separation of product through the gate assembly area. Before you power-up and run your machine with a full hopper, manually feed several sheets of product through the gate assembly area.

Prepare your test by loading the hopper with approximately 2 to 2-1/2 in. (5 to 6 cm) of product. Make sure you preshingle the stack so that product rests against the curvature of the gate assembly.

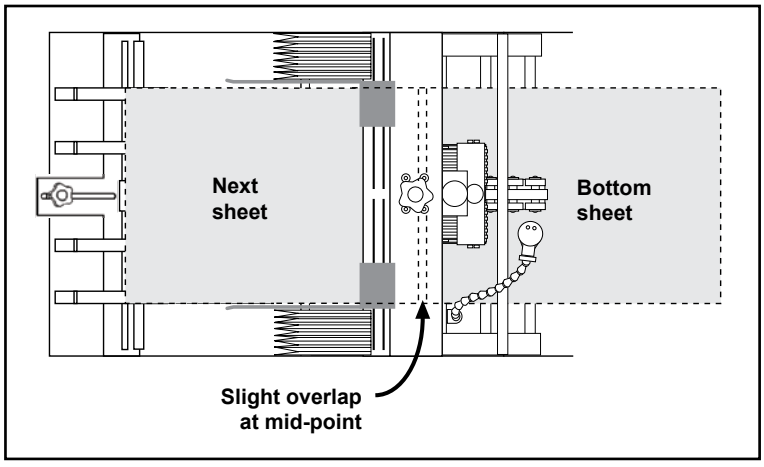
1. Manually feed several sheets of product slowly through the gate assembly area. Move the drive belts by pressing your thumb against the discharge belt.
2. Observe how individual product enters and exits the gate assembly area. Remember, a properly set gap will allow each new sheet to enter at about the centerline of the cylinder while the bottom sheet is exiting the gate assembly area (see below). Ideally, this means a slight overlap of both the first sheet and the second sheet (1/8 in. or 3 mm) at the gate assembly area. The overlap occurs as the bottom sheet is exiting, and the next sheet is entering.
3. If feeding doubles, move the wedge in toward the gate assembly. Test again.
4. If sheets are overlapping excessively or, if the machine is feeding doubles, reduce the gap slightly by moving the knob about 1/8 turn counterclockwise. Test again.
5. As product moves through the hold-down area, check for any skewing or jamming. Also check for damage to the product.

NOTE

If the gate assembly is too tight, the feeder will have difficulty pulling the product through the gate assembly area. This will cause "missed" feeds.

NOTE

Moving the back wedge too far forward to the gate assembly can create a pinch point between the tip of the wedge and the product. If moving the back wedge in is not effective, then an optional wedge may be required. See Section 6 for more information.



Optimum Overlap and Separation of Product

3 How to Operate

Operational Sequences

Successful power-up and operation of the feeder is assured if you apply each of following sets of procedures where needed:

- Loading product
- Quick setup/cycle sequence
- Accessing the menus for setup
- Starting a cycle
- Stopping the feeder
- Clearing a jam

Loading Product

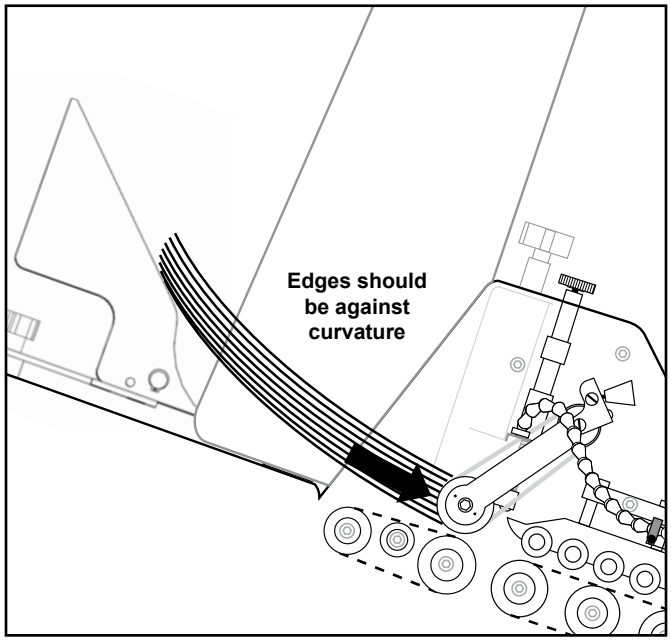
NOTE

Preshingling prevents multiple sheets from jamming under the gate assembly at start-up.

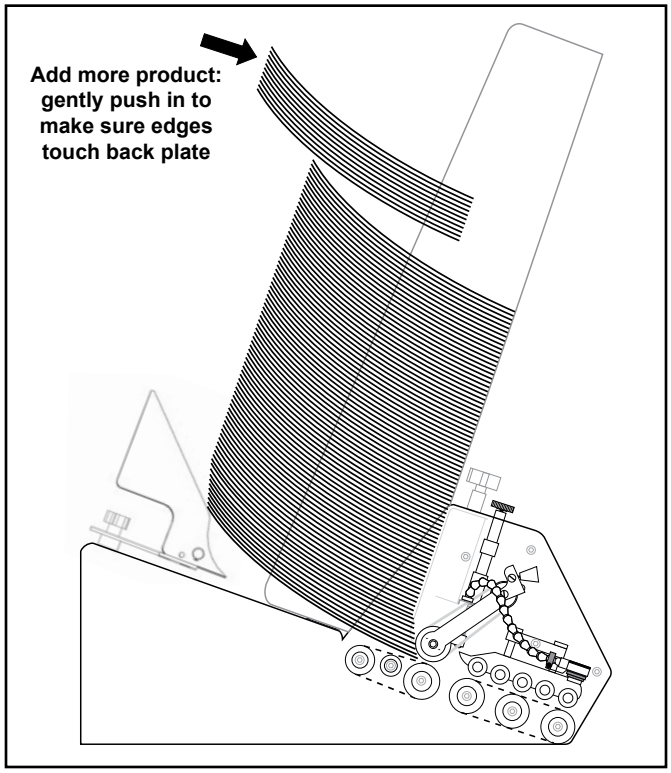
TIP

Stack height affects the downward pressure on the feed belts. Greater downward pressure can increase the chances for misfeeds or double feeds.

1. Preshingle a small stack of material and load in hopper with one end of the stack resting against the gate assembly, and the other end resting on the back wedge.
2. Gradually add more product to the hopper. As stack height will have a preferred minimum and maximum, you will have to experiment to determine the effective range of height.
3. As you add product, tap each handful of product with your hand to make sure it rests evenly against the back plate.



Placing Product Against Gate Assembly



Adding More Product to Fill Hopper

4 Operational Troubleshooting

This table is intended to provide you with quick solutions to the more common day-to-day problems you may encounter. For additional troubleshooting information, refer to the Technical Troubleshooting section.

Problem	Cause	Solution
No AC power to feeder	1. On/Off switch in "Off" (or "O" position).	Move switch to "On" (or "_" position).
	2. Power cord loose or not plugged into outlet (or AC power source).	Check and secure power cord at AC outlet.
	3. Female end of power cable loose or not plugged into AC power inlet at rear of feeder.	Check and secure cord at AC power inlet at rear of machine.
Feeding doubles	1. Gate assembly improperly adjusted (possibly more than one sheet thickness).	Review gate adjustment procedure.
	2. Back wedge improperly adjusted.	Review back wedge adjustment procedure.
	3. Worn O-rings (or angled edge).	Rotate O-rings (or replace angled edge). If wear is excessive, consult with a qualified technician.
	4. Material interlocking.	Check material and source.
	5. Static buildup.	Check material and source.
Feed belts are operating, but material not feeding	1. Material stack height is too low when stack height is down, resulting in reduction of down pressure.	Review material loading procedure.
	2. Binding in side guides.	Adjust side guides farther apart to allow freedom of movement between sheets.
	3. Slippery feed belts.	Consult with a qualified technician.
	4. Sheet adhesion or interlocking between the bottom and next sheet.	Review material loading procedure and back wedge adjustment procedure.
	5. Gate assembly may be down too tight.	Review gate assembly adjustment procedure.
	6. Too much weight in hopper.	Remove material from stack. Test again.

Operational Troubleshooting (continued)

Problem	Cause	Solution
Feed belt(s) not tracking on rollers	1. Excessive weight in hopper. 2. Excessive down pressure on gate assembly. 3. Off-centered product from center point of machine. 4. Belt wear.	Reduce weight. Test again. Rotate gate adjustment 1/8 turn to increase gap and manually test. Review gate assembly adjustment procedure. Review side guide setting procedure. Review gate assembly adjustment procedure. Also review inspection and care procedures. If wear is excessive, consult with a qualified technician.
Jamming occurs during operation	1. Improperly adjustment in one or more of the following areas: A. Gate assembly. B. Back wedge. C. Top roller hold-down assembly. D. Discharge alignment rails.	1. Turn the Power switch to "Off" by pressing the circle (O). 2. Remove jammed material from feeder. While doing so, try to determine the cause of the jam. 3. Verify each adjustment by reviewing the "Preparing for Operation" section of the manual.
Material skewing	1. Back wedge not aligned properly. 2. Excessive gate pressure on one side.	Review back wedge adjustment procedure. Review gate assembly adjustment procedure.

5 Inspection and Care

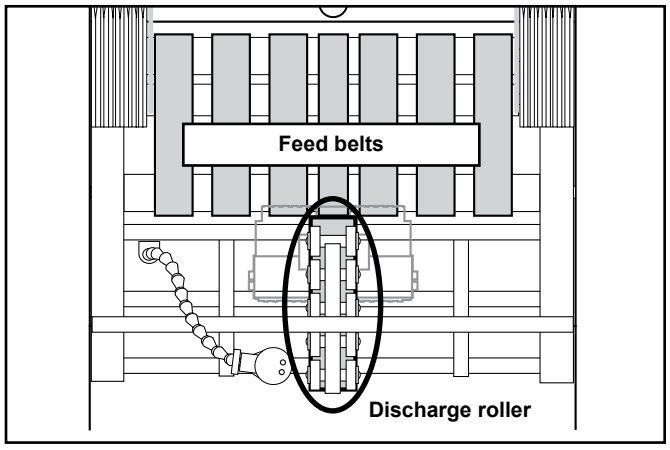
When performing initial adjustments prior to operation, always make sure you turn Off the main power switch, open the discharge safety shield (to disengage the interlock), and disconnect feeder from the electrical power source. Failure to do so can expose you to a potential start-up and moving parts which can cause serious injury.

Do not attempt to make any adjustments while the machine is running. Failure to do so can expose you to moving parts which can cause serious injury. Do not wear loose clothing when operating the feeder. Avoid making adjustments with loose or unsecured parts. This can potentially damage parts.

Please read this Section to learn how to:

- Visually inspect your machine to detect part problems which may require adjustment or replacement.
- Periodically care for your machine to prevent any operational problems.

Visual Inspection

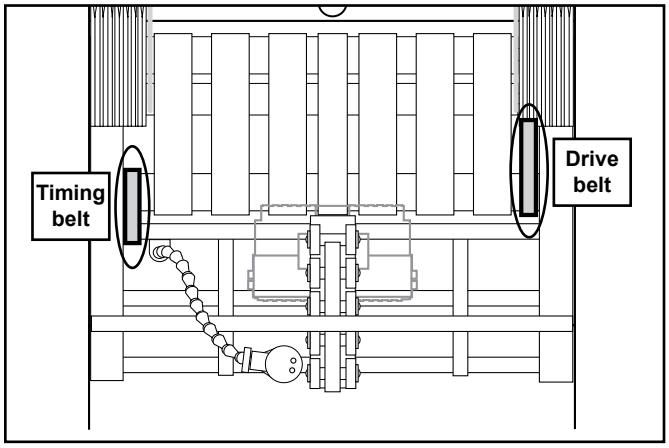


Checking for Feed and Discharge Belt Wear

Check for visual signs of:

- Walking. Replace as required.
- Cracking. Replace as required.
- Thinning. Replace as required.

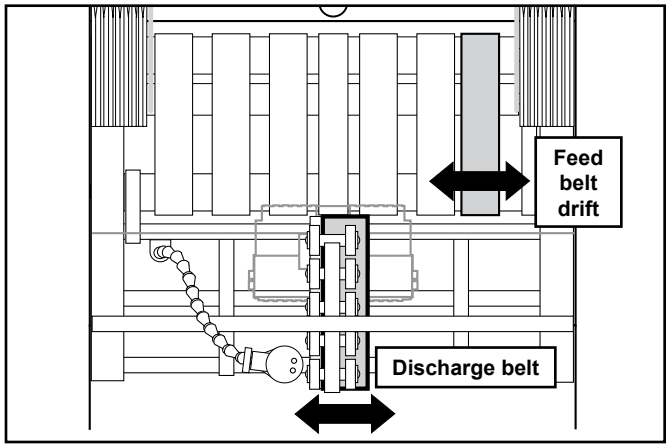
Visual Inspection (continued)



Checking for Timing and Drive Belt Wear

Check for visual signs of:

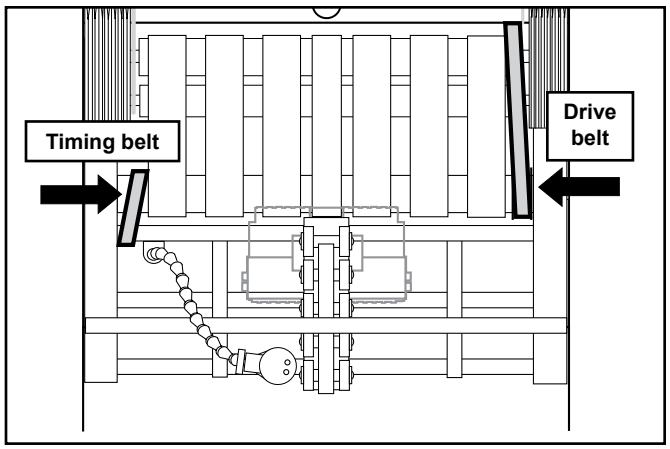
- Fraying. Replace as required.
- Missing teeth. Replace as required.
- Cracking. Replace as required.



Ensuring Proper Feed and Discharge Belt Tracking

Check for visual sign of:

- Stretching.
- Improper roller adjustment.



Ensuring Proper Timing and Drive Belt Tracking

Check for visual signs of:

- Misaligned timing pulleys.

Visual Inspection (continued)

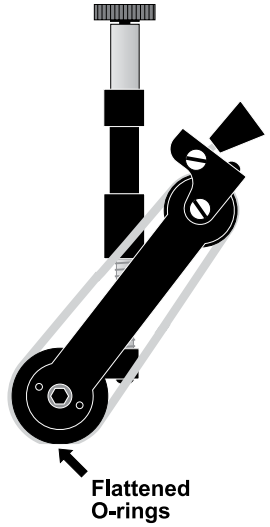
Checking for Gate Assembly Wear

Check for visual signs of wear:

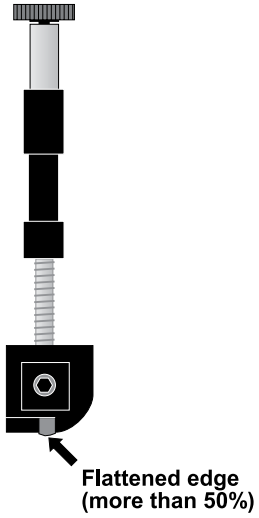
- Bar gate: Bar material begins to flatten excessively.
- Standard O-ring or advancing O-ring (if applicable): Flat areas along the O-rings.
- Powered Rotating Gate: Flat Rollers.

See “Preventive Care” to follow.

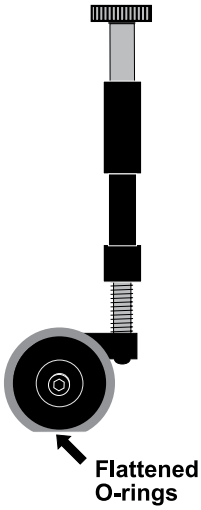
Advancing O-Ring Gate



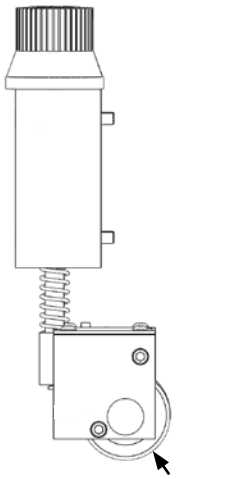
Optional Bar Gate II



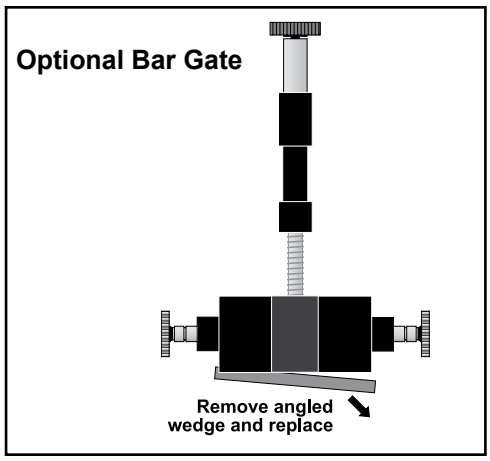
Optional Standard O-Ring Gate



Powered Rotating Gate



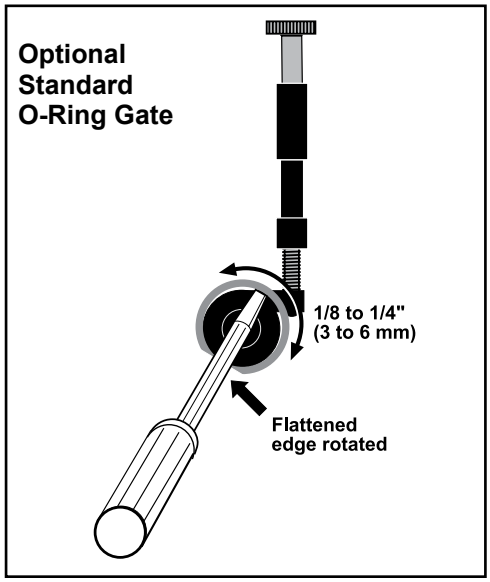
Visual Inspection (continued)



Replacing Worn Bar Material

To replace a worn bar material:

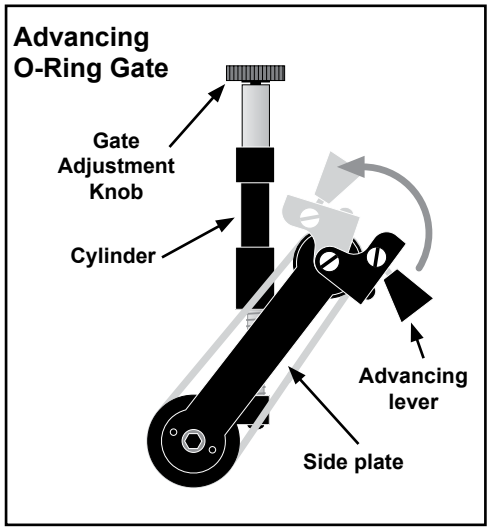
1. Turn Off feeder and remove power cord from outlet.
2. Remove gate assembly from gate plate.
3. Remove plate (two screws).
4. Use a pliers to grip and remove bar material.
5. Install new bar material by inserting one end and then pushing in until centered. *Do not grip bar material with pliers as this may cause damage to the edge.*
6. Reinstall clamp (two screws).
7. Reinstall gate assembly and restore power.



Standard O-Ring Gate: Adjusting Worn O-Rings

To adjust worn O-rings on standard O-ring gate:

1. Turn Off feeder and remove power cord from outlet.
2. Remove gate assembly from gate plate.
3. Insert a screwdriver in slot on top of gate assembly and rotate screwdriver clockwise or counterclockwise 360° to move worn area of O-ring about 1/8 to 1/4 in. (3 to 6 mm).
4. Remove screwdriver and repeat for each ring.
5. Reinstall gate assembly and restore power.



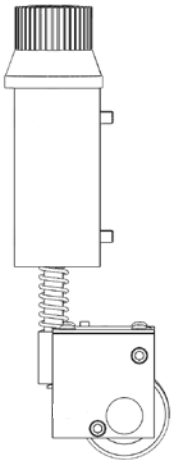
Advancing O-Ring Gate: Adjusting Worn O-Rings

To adjust worn O-rings on advancing O-ring gate:

1. Turn Off feeder and remove power cord from outlet.
2. Remove gate assembly from gate plate.
3. Lower advancing lever away from gate adjustment knob.
4. Rotate O-rings by grasping advance knob and pushing toward gate cylinder about 1/8 to 1/4 in. (3 to 6 mm).
5. Lower advancing lever to resting position away from gate adjustment knob.
6. Reinstall gate assembly and restore power.

Visual Inspection (continued)

Powered Rotating Gate



Powered Rotating Gate: Replacing Worn Rollers

To replace worn rollers on Powered Rotating gate:

1. Turn Off feeder and remove power cord from outlet.
2. Disconnect power cable from assembly.
3. Remove gate assembly from gate plate.
4. Disassemble lower housing where rollers are located.
5. Remove, replace and reassemble.
6. Reinstall gate assembly and restore power.

Preventive Care

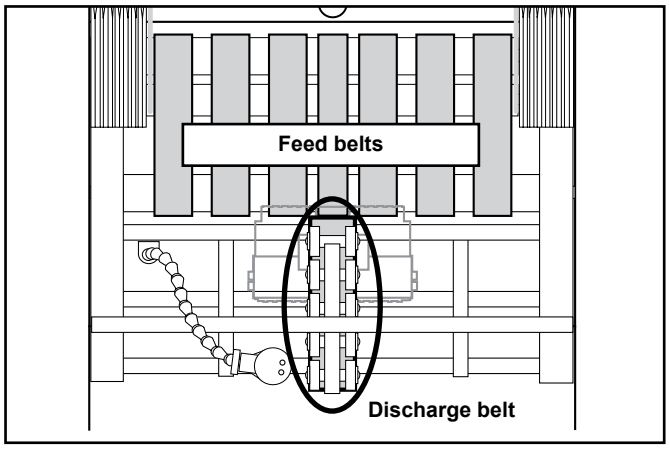
Use only isopropyl alcohol (98% concentration). Other solvents will cause belts to wear prematurely, and even total breakdown of material.

Do not use any solvents or cleaning agents when cleaning the keypad or display. This will result in surface damage. Do not spray any cleaning solutions directly on the keypad or display surfaces, as this could lead to faulty performance.

Cleaning Feed and Discharge Belts

To clean feed and discharge belts:

1. Turn Off feeder and remove power cord from outlet.
2. Remove gate assembly from gate plate for easier access to belts.
3. Apply a small amount of isopropyl alcohol to a soft cloth.
4. Use your hand to move the discharge belt, start with one feed belt at a time and carefully press the moistened area of the cloth to the belt. As you rotate the belt, use moderate pressure to wipe across the belt, making sure to wipe in direction of grooves also. After several rotations of the belt, repeat for each belt.
5. Taking a dry portion of the cloth, go back to the first feed belt cleaned and use moderate pressure against the belt for several revolutions to ensure the belt is dried. Repeat for each belt.
6. Repeat steps 3 through 5 for the discharge belt also.
7. Reinstall gate assembly and restore power.



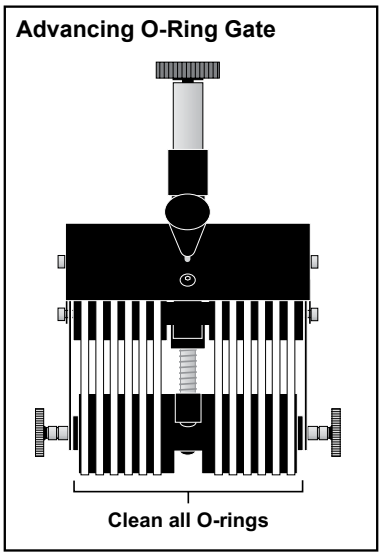
Preventive Care (continued)

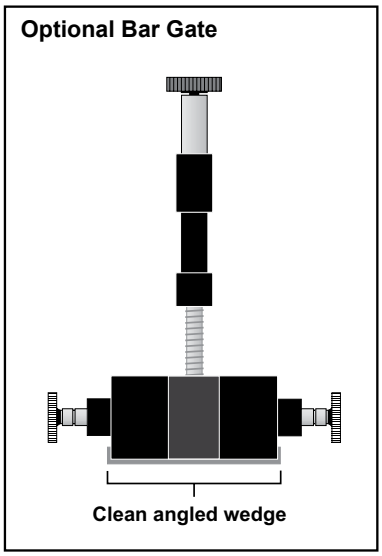
Cleaning Gate Assembly

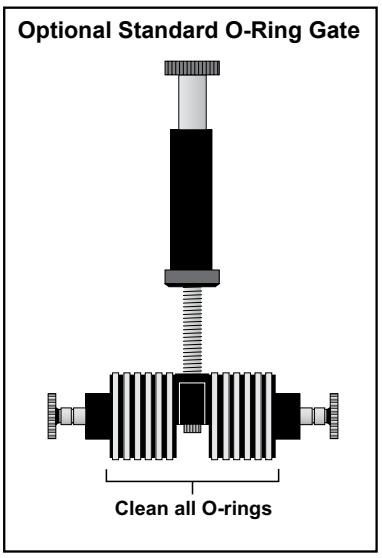
Use only isopropyl alcohol (98% concentration). Do not use any other types of solvents. They will cause premature wear of the belts, or even total breakdown of the material.

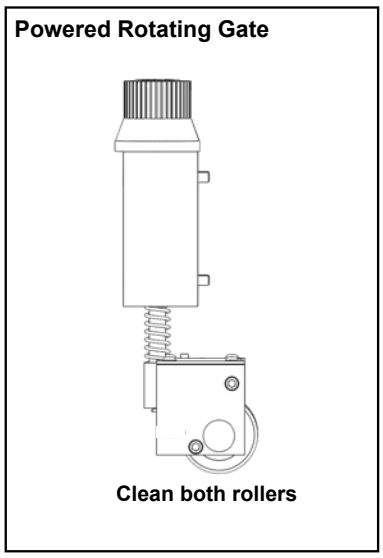
To clean gate assemblies:

1. Turn Off feeder and remove power cord from outlet.
2. Remove gate assembly from gate plate.
3. Apply a small amount of isopropyl alcohol to a soft cloth.
4. Wipe across bar material (or O-rings if applicable), first in one direction, then the other.
5. Taking a dry portion of the cloth, go back and wipe all surfaces to ensure they are dried.
6. Reinstall gate assembly and restore power.









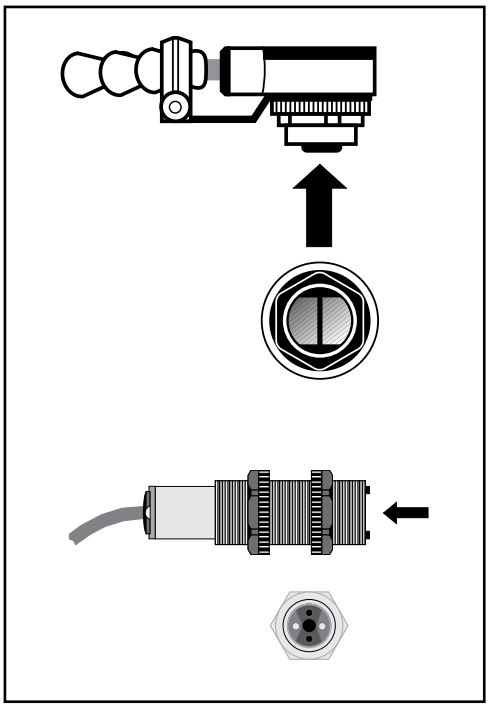
Preventive Care (continued)

Cleaning Photo Sensors

To clean the photo sensor lenses:

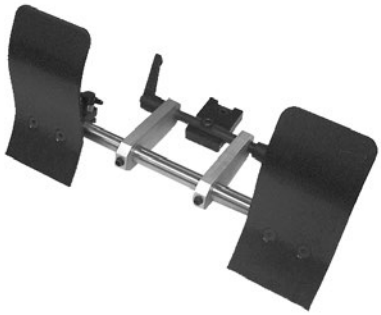
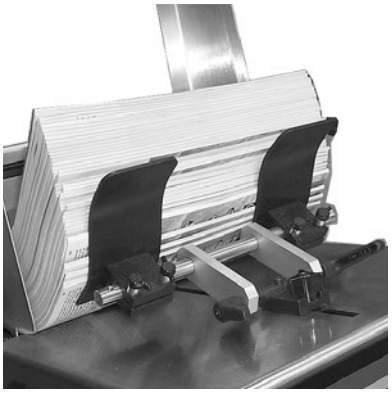
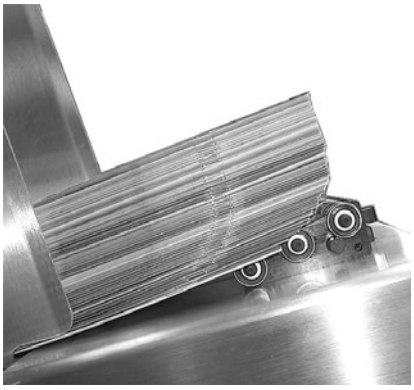
1. Turn Off feeder and remove power cord from outlet.
2. Open the discharge safety shield (to access sheet-detect sensor).
3. Using a soft, dry cloth, wipe across the face of each lens.
4. Repeat step 3 above for flight-detect sensor.
5. Recheck the adjustments of both photo sensors to make sure they are still in alignment to the targets.
6. Close discharge safety shield and restore power.

Do not use any solvents or cleaning agents when cleaning the photo sensor lenses. This can result in surface damage and eventual faulty performance.

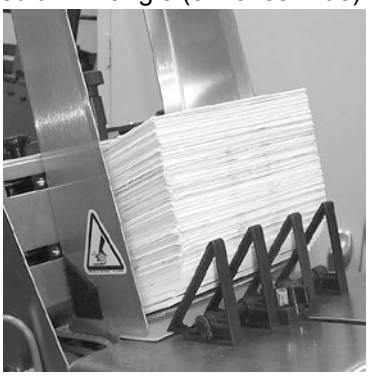
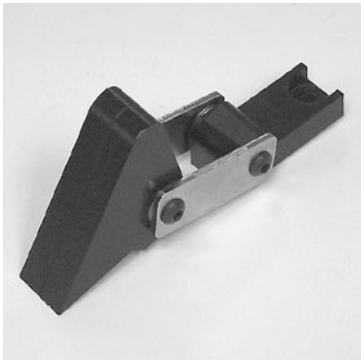
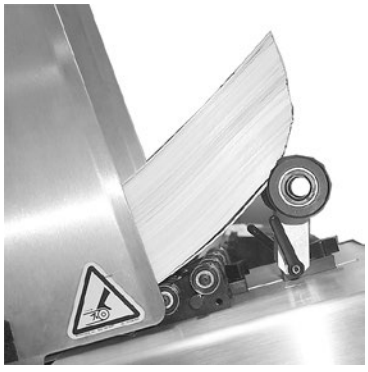


6 Wedge Applications

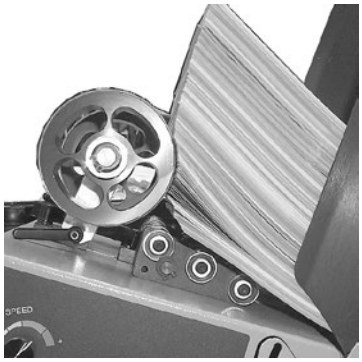
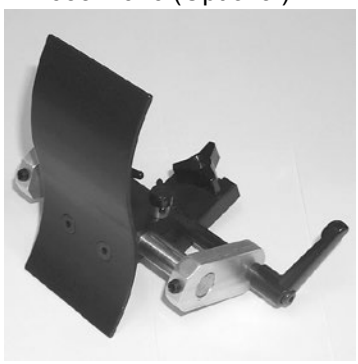
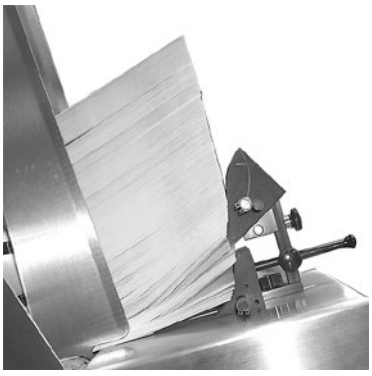
There is a variety of wedges that may be utilized for feeding various materials of differing properties. A wedge may be used either alone or in combination with another wedge depending upon the size and/or properties of the material that is being fed. The following will help to identify which wedge to use for a specific material.

Part Number	Description/Setup Example	Material Usage
63311214 (Standard) 	Large Triangle (5 inches wide) 	Light to medium weight products from 3 to 6 inches in length (longer if used with Low Profile wedge) such as Z-fold and C-fold letters, business reply cards, payment booklets, and tagboard.
63311025 (Standard) 	Double "S" 	Light to heavy weight products from 4 to 14 inches in length such as large envelopes, flat sheets, card stock and folded products.
63311050 (Standard) 	Low Profile 	Medium to heavy weight products from 8 to 14 inches in length such as magazines, flat sheets, and other flexible products greater than 8 inches. Most often used with Double S, Articulating, Large Articulating, or Large Triangle wedge, but may be used alone as shown in the photo.

Wedge Applications (continued)

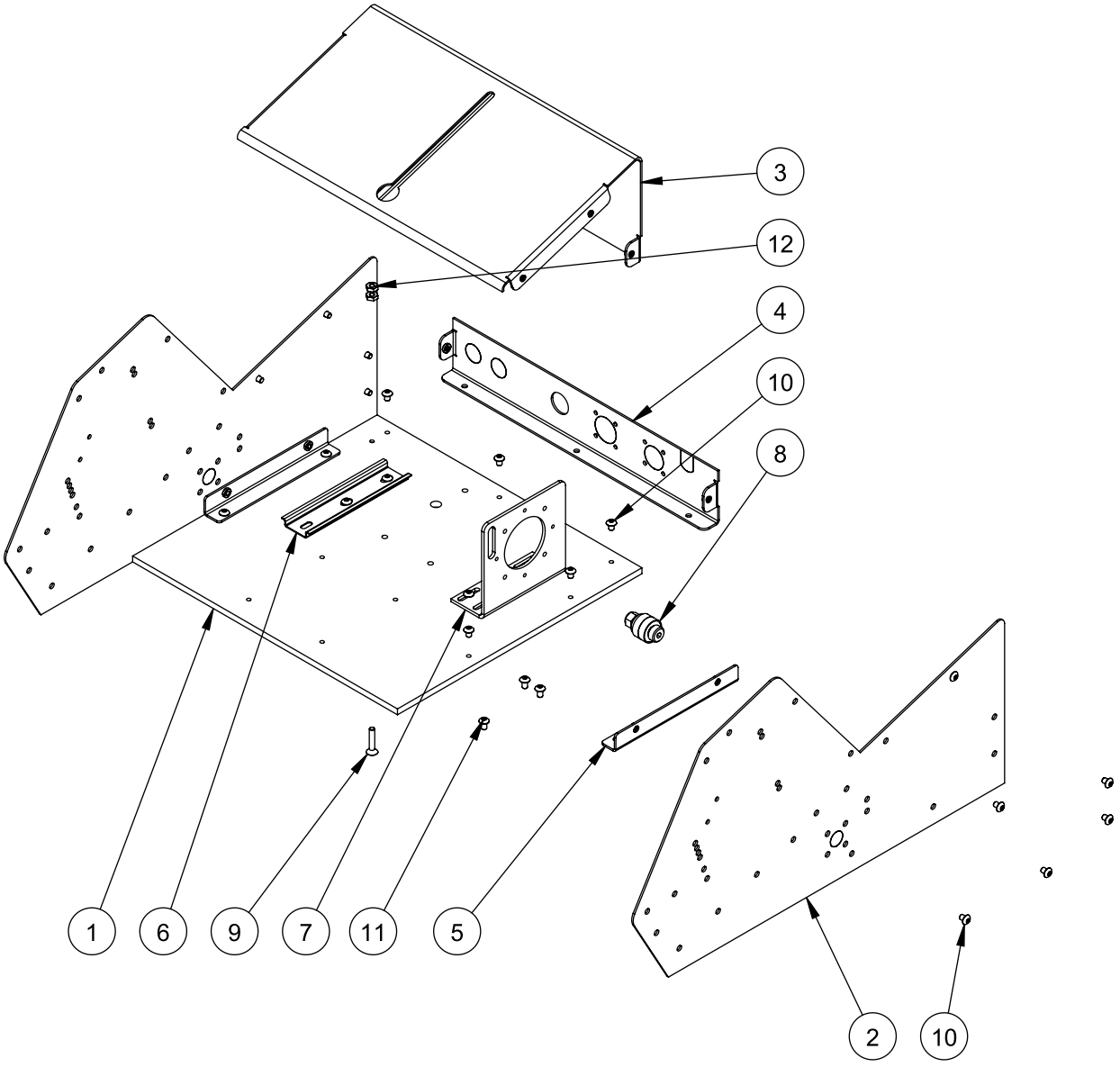
Part Number	Description/Setup Example	Material Usage
63311017 (Optional) 	Small Triangle (4 inches wide) 	Light to medium weight products from 3 to 6 inches in length such as Z-fold and C-fold letters, business reply cards, and small booklets.
63311710 (Optional) 	Medium Triangle (5 inches wide) 	Light to medium weight products from 3 to 6 inches in length such as Z-fold and C-fold letters, business reply cards, and booklets.
63311212 (Optional) 	Extended Narrow 	Light to medium weight, small narrow products from 3 to 6 inches in length such as multifold leaflets, credit cards, business cards, trading cards, and coupons.
63311340 (Optional) 	Articulating Roller 	Light to heavy weight products from 6 to 14 inches in length such as envelopes, chipboard, corrugated, and heavy flat sheets.

Wedge Applications (continued)

Part Number	Description/Setup Example	Material Usage
63311350 (Optional) 	Large Articulating Roller 	Light to heavy weight products from 6 to 17 inches in length such as large envelopes, flat sheets, card stock, and corrugated.
63311026 (Optional) 	Single "S" 	Light to heavy weight products from 4 to 14 inches in length such as envelopes, card stock, and folded products.
63311968 (Optional) 	Combination 	Light to heavy weight products such as envelopes, card stock, booklets, and folded leaflets.
63311214 and 63311050 	Triangle and Low Profile (Combined) 	Medium to heavy weight products from 8 to 14 inches in length such as magazines, flat sheets, and other flexible products greater than 8 inches.

7 Mechanical Components

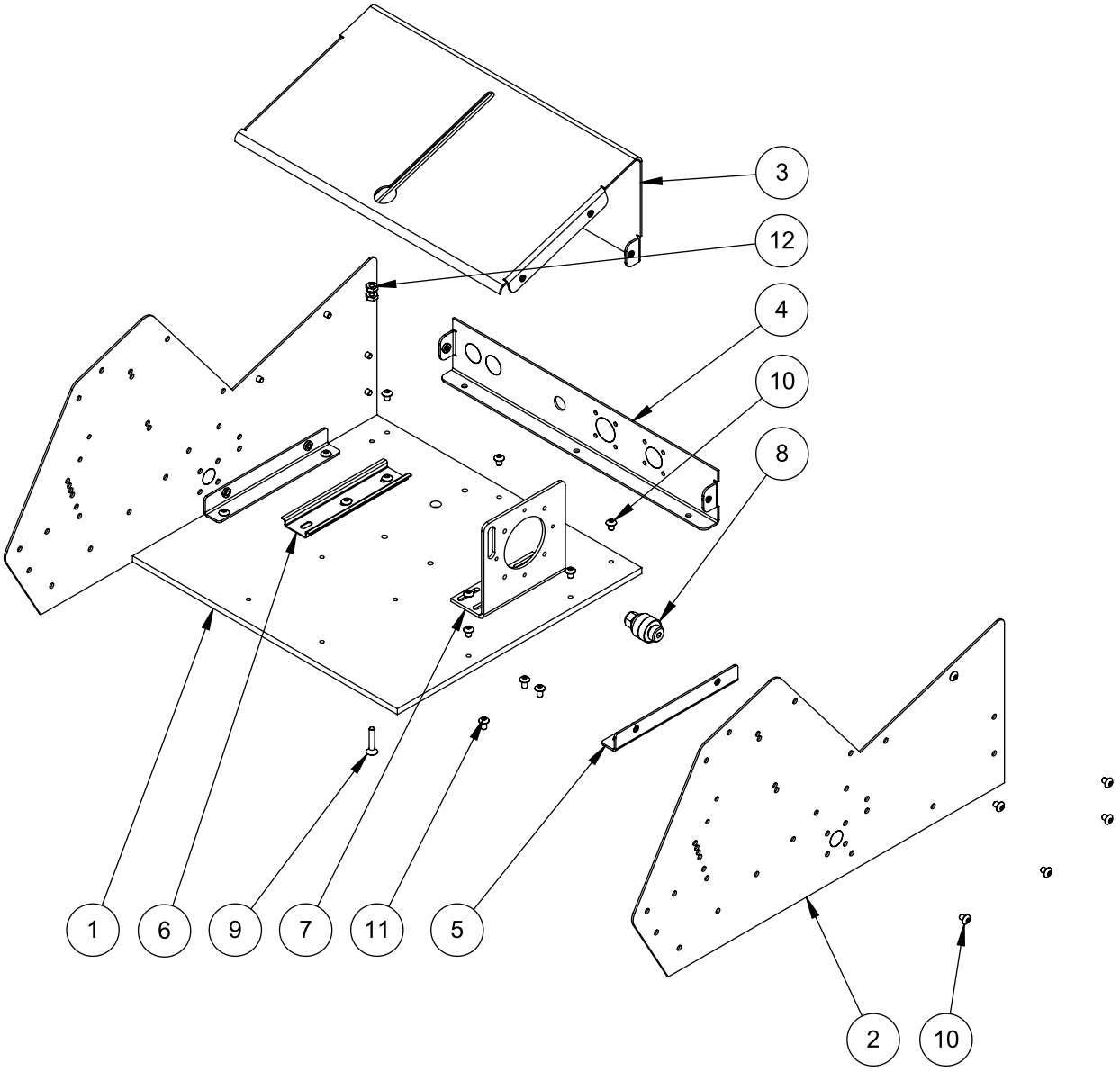
BASE AND PAINTED SIDE PLATES
Assembly # : 311-1518



BASE AND PAINTED SIDE PLATES
Assembly # : 311-1518

ITEM	QTY.	PART NUMBER	DESCRIPTION
1	1	904690	TF-1250/3700 BASE
2	2	904706	TF PAINTED SIDE
3	1	904692	TF-1250 TOP COVER
4	1	904693	TF-1250 BACK COVER
5	2	904694	TF SIDE BRACKET
6	1	595-0003	5.00” LONG RAIL.SLDPRT
7	1	904705	SERVO MOTOR MOUNT
8	1	311-1494	ASSY BELT TENSIONER
9	1	102916B06	FHCSS SST 10-32 X 1.00
10	21	102957B01	BHCS SST 10-32 X .25
11	4	102957B11	BHCSS SST 10-32 X .31
12	2	600623B04	10-32 KEP NUT

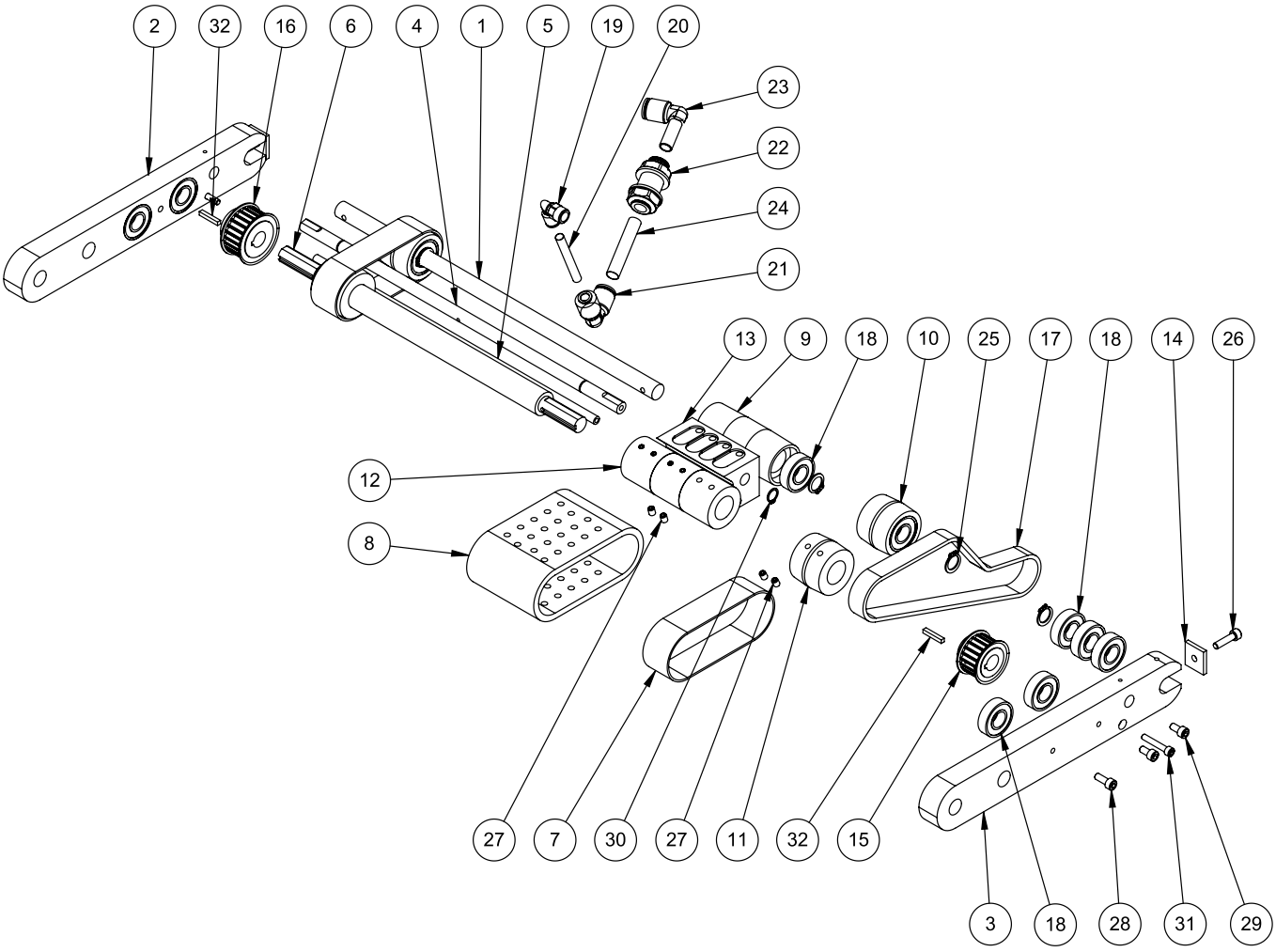
BASE AND STAINLESS STEEL SIDE PLATES
Assembly # : 311-1449



BASE AND STAINLESS STEEL SIDE PLATES
Assembly # : 311-1449

ITEM	QTY.	PART NUMBER	DESCRIPTION
1	1	904690	TF-1250/3700 BASE
2	2	904691	TF SIDE
3	1	904692	TF-1250 TOP COVER
4	1	904693	TF-1250 BACK COVER
5	2	904694	TF SIDE BRACKET
6	1	595-0003	5.00” LONG RAIL.SLDPRT
7	1	904705	SERVO MOTOR MOUNT
8	1	311-1494	ASSY BELT TENSIONER
9	1	102916B06	FHCSS SST 10-32 X 1.00
10	21	102957B01	BHCS SST 10-32 X .25
11	4	102957B11	BHCSS SST 10-32 X .31
12	2	600623B04	10-32 KEP NUT

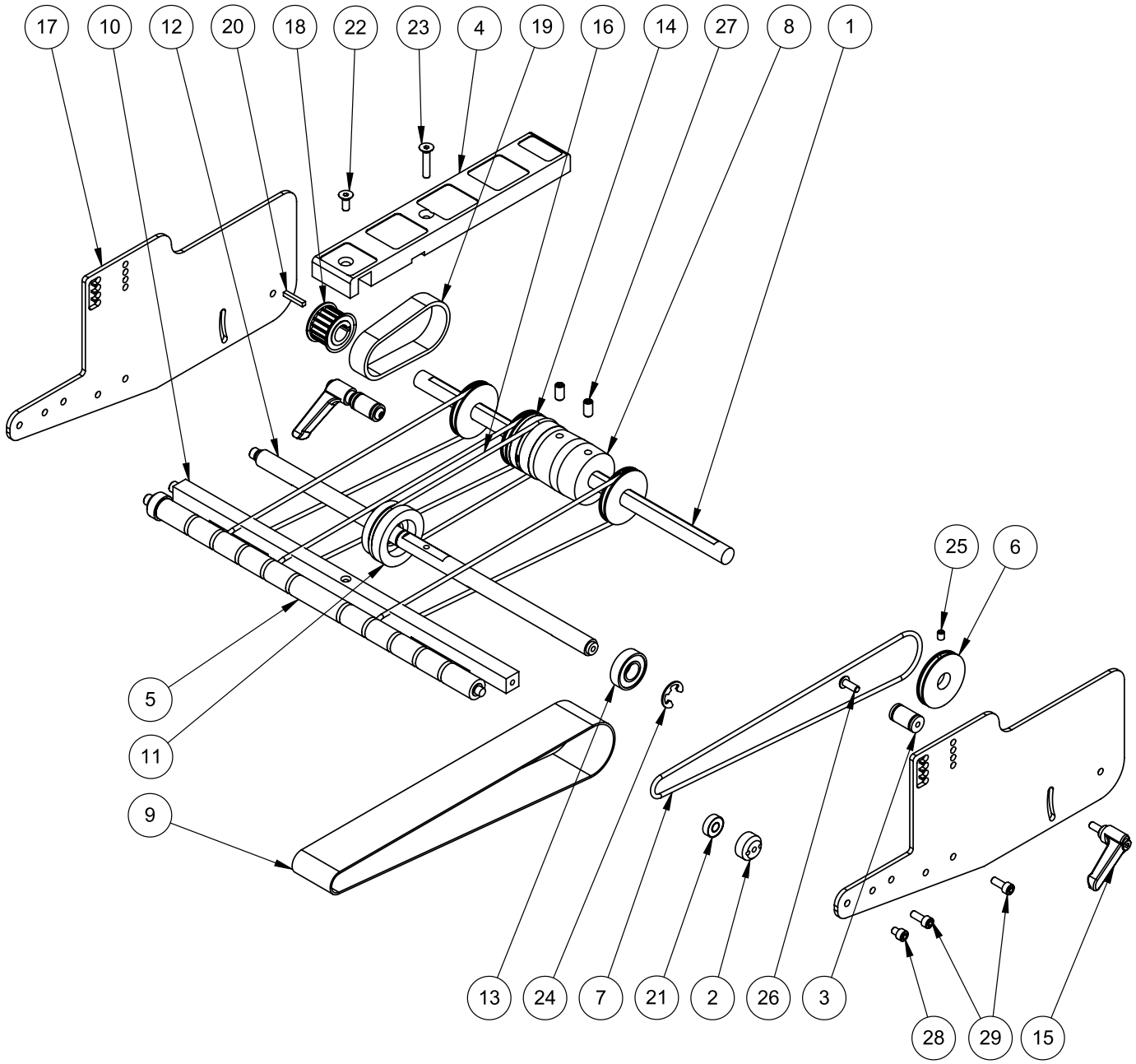
WIDE BELT VACUUM ASSIST CARRIAGE - 1250
Assembly # : 311-1488



WIDE BELT VACUUM ASSIST CARRIAGE - 1250
Assembly # : 311-1488

ITEM	QTY.	PART NUMBER	DESCRIPTION
1	1	43555147	IDLER SHAFT
2	1	23560202	RIGHT SIDE
3	1	23560203	LEFT SIDE CARRIAGE
4	1	44841056	VACUUM CARRIAGE SHAFT
5	1	901296	SHAFT, VACUUM BLOCK
6	1	904825	DRIVE SHAFT SERVO DRIVE
7	2	904853	FEED BELT POLY
8	1	44947037	VACUUM BELT
9	1	44947041	TUBE DRIVEN
10	2	904855	CROWN DRIVEN ROLLER
11	2	904854	ROLLER CROWN DRIVE
12	3	23560206	ROLLER, FLAT DRIVE
13	1	901040	MANIFOLD
14	2	44485004	VAC BELT TENSION
15	1	904833	PULLEY 20T X 5MM PT X .5 BORE
16	1	904827	PULLEY 24T X 5MM PT X .5 BORE
17	1	904852	BELT TIMING HTD-5M 85 TEETH
18	9	23500094	BEARING BALL R8 .500 BORE
19	1	51476007	ELBOW. MALE
20	1.62”	51476004	1/4” TUBE VACUUM
21	1	51476006	ELBOW, UNEQUAL UNION
22	1	51476005	BULKHEAD UNION
23	1	51476008	PLUG IN ELBOW
24	10.0”	44450088	POLYETHYLENE TUBING
25	7	904707	SNAP RING EXTERNAL SSTL .50
26	2	102937B05	SHCSS SST 10-32 X .75
27	10	103011B03	SSSCPPT SST 10-32 X .25
28	2	102937B03	SHCSS SST 10-32 X .50
29	4	102937B02	SHCSS SST 10-32 X .38
30	2	11315344RC	SNAP RING EXTERNAL SST .38
31	2	102934B07	SHCS SST 8-32 X 1.00
32	2	103654B03	KEY SQ. SSTL .13 X .75

EXTENDED, ADJUSTABLE DISCHARGE - 1250
Assembly # : 311-1452

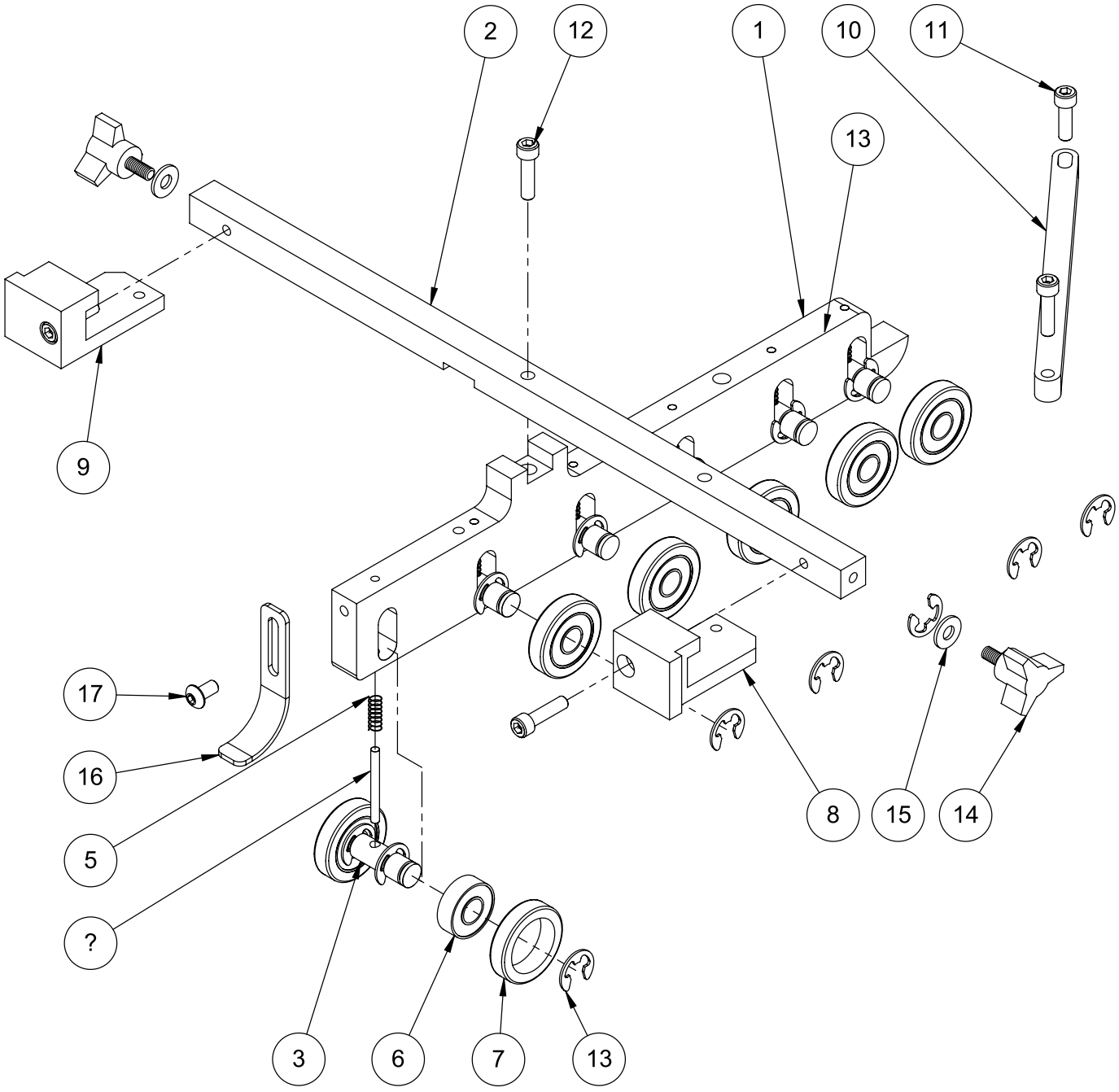


EXTENDED, ADJUSTABLE DISCHARGE - 1250
Assembly # : 311-1452

ITEM	QTY.	PART NUMBER	DESCRIPTION
1	1	904841	SHAFT DISCHARGE
2	2	44846050	HOLDER, R4 BEARING
3	2	44852098	BELT TENSION SHAFT
4	1	51330007	BLOCK, HOLD DOWN SUPPORT
5	1	51330010	SHAFT, LOWER
6	4	51330014	PULLEY, O-RING
7	4	51330012	BELT, O-RING
8	1	23560106	1-5/8 CROWN PULLEY W\SET SCREW
9	1	51330001	BELT, DISCHARGE
10	1	51330013	BAR, HOLD DOWN SUPPORT
11	1	51385006	DRIVEN ROLLER
12	1	51385009	SHAFT, SUPPORT
13	2	23500094	BEARING BALL R8 .500 BORE
14	1	51438003	DRIVE ROLLER
15	2	43555097	RATCHET HANDLE 10-32 X .50
16	1	51438020	BELT, O-RING
17	2	51330002	SIDE PLATE EXTENSION
18	1	904904	PULLEY 17T X 5MM PT X .5 BORE
19	1	904856	BELT TIMING HTD-5M 40 TEETH
20	1	103654B03	KEY SQ. SSTL .13 X .75
21	2	44582021	BEARING, BALL R4 .25 BORE
22	1	102637B03	FHCS BLACK OXIDE 10-32 X .50
23	1	102637B06	FHCS BLACK OXIDE 10-32 X 1.00
24	2	904512	E-CLIP, SSTL FOR 1/2 SHAFT
25	6	103011B03	SSSCPPT SST 10-32 X .25
26	2	102708B03	BHCSS SST 10-32 X .50
27	2	103012B07	SSSCPPT ¼-20 X .50 SSTL
28	2	102937B01	SHCSS SST 10-32 X .25
29	4	102937B03	SHCSS SST 10-32 X .50

HOLD DOWN FOR EXTENDED DISCHARGE - 1250

Assembly # : 14380008

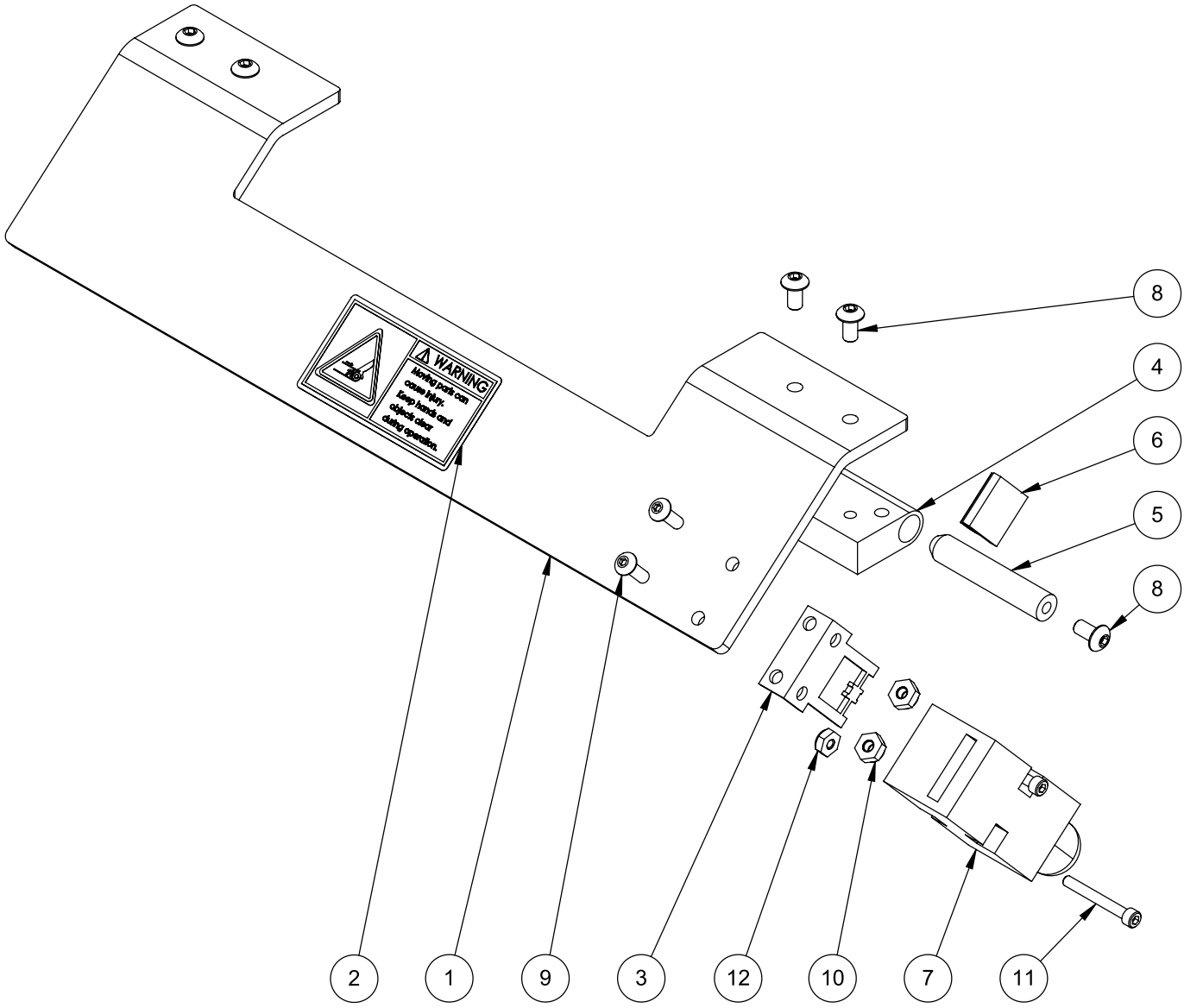


HOLD DOWN FOR EXTENDED DISCHARGE - 1250
Assembly # : 14380008

ITEM	QTY.	PART NUMBER	DESCRIPTION
1	1	51330006	BLOCK, HOLD DOWN
2	1	51385032	BAR, HOLD DOWN
3	6	51277052	SHAFT, HOLD DOWN
4	6	51312003	PIN, SPRING 1/8 IN
5	6	51328001	SPRING, HOLD DOWN
6	12	23500095	BEARING BALL R6 .375 BORE
7	12	51277087	COLLAR, DISCH ROLLER
8	1	51438018	BLOCK, LH HOLD DOWN
9	1	51438019	BLOCK, RH HOLD DOWN
10	1	902209	SUPPORT, HOLD DOWN
11	1	102688B04	SHCS BLACK OXIDE 10-32 X .63
12	4	102688B05	SHCS BLACK OXIDE 10-32 X .75
13	24	104308B04	E-TYPE, STEEL CLIP FOR 3/8 SHAFT
14	2	23500092	KNOB, 10-32 X 1/2” LG STUD 3 LOBE
15	2	103240B04	FLAT WASHER ZINC STEEL #10
16	1	903266	HOLDOWN PAPER DEFLECTOR
17	1	102957B02	BHCS SST 10-32 X .38

GUARD ASSEMBLY FOR EXTENDED DISCHARGE - 1250

Assembly # : 311-1512



GUARD ASSEMBLY FOR EXTENDED DISCHARGE - 1250
Assembly # : 311-1512

ITEM	QTY.	PART NUMBER	DESCRIPTION
1	1	44803001	COVER PROTECTIVE TOP
2	1	53500609	LABEL, WARN INJURY 2.7 X 1.4
3	1	44649010	KEY, SAFETY INTERLOCK
4	2	44909023	BLOCK, HINGE COVER
5	2	44640011	SHAFT, MTG, COVER
6	1	23500079	MOUNT, CABLE ADHESIVE C TYPE
7	1	64911009	ASSY, SWITCH SAFETY INTERLOCK
8	6	102957B02	BHCS SST 10-32 X .38
9	2	102955B03	BHCS SST 8-32 X .50
10	2	116691B03	HEX NUT NY-LOK SST 8-32
11	2	102932B26	SHCS SST 6-32 X 1.13
12	2	112156B02	HEX NUT NY-LOK ZP 6-32

SHORT STANDARD DISCHARGE - 1250
Assembly # : 311-1539

COMING SOON

SHORT STANDARD DISCHARGE - 1250
Assembly # : 311-1539

COMING SOON

HOLD DOWN FOR SHORT STANDARD DISCHARGE - 1250
Assembly # : 311-1454

COMING SOON

HOLD DOWN FOR SHORT STANDARD DISCHARGE - 1250
Assembly # : 311-1454

COMING SOON

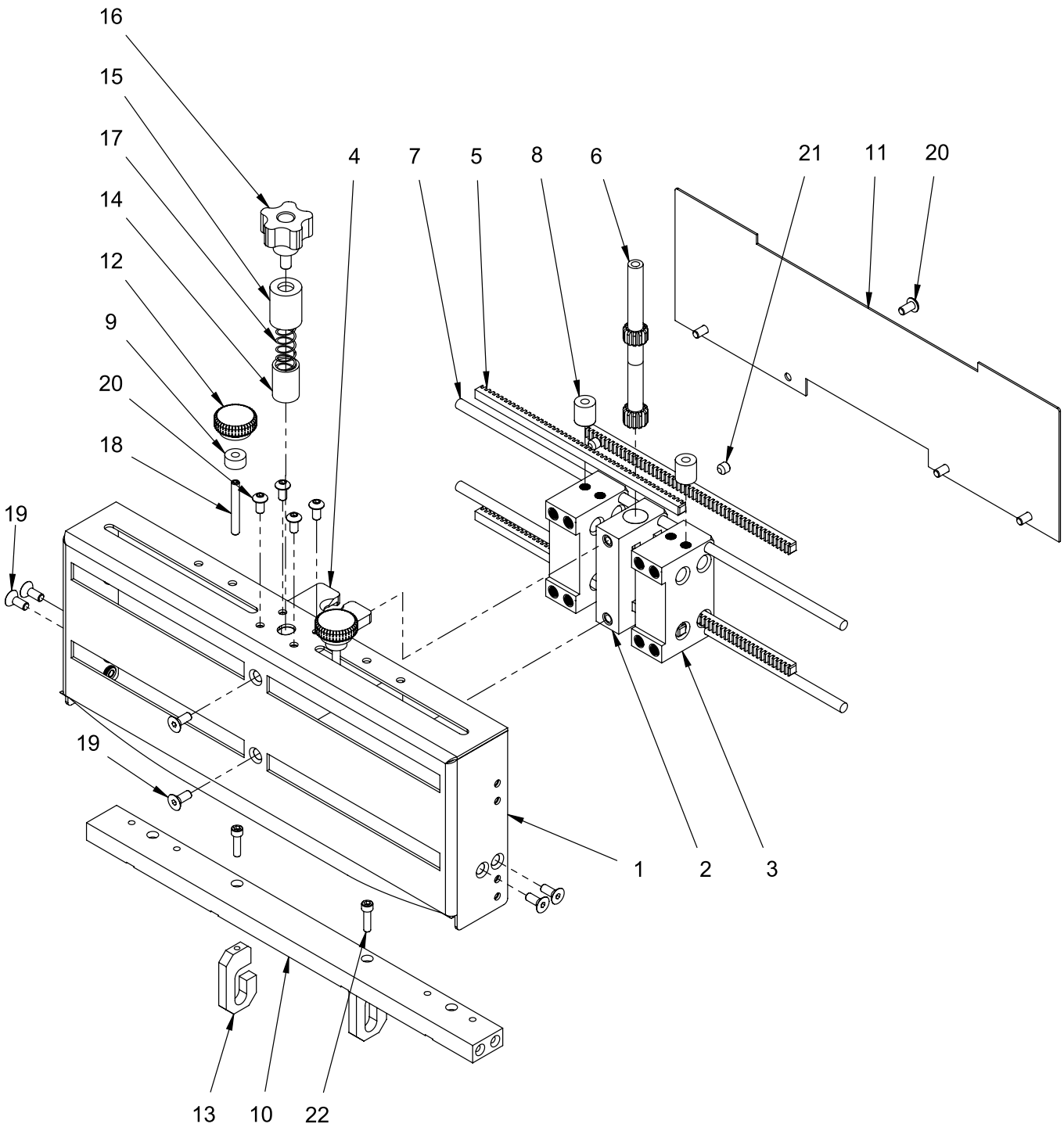
GUARD ASSEMBLY FOR SHORT STANDARD DISCHARGE - 1250
Assembly # : 311-1455

COMING SOON

GUARD ASSEMBLY FOR SHORT STANDARD DISCHARGE - 1250
Assembly # : 311-1455

COMING SOON

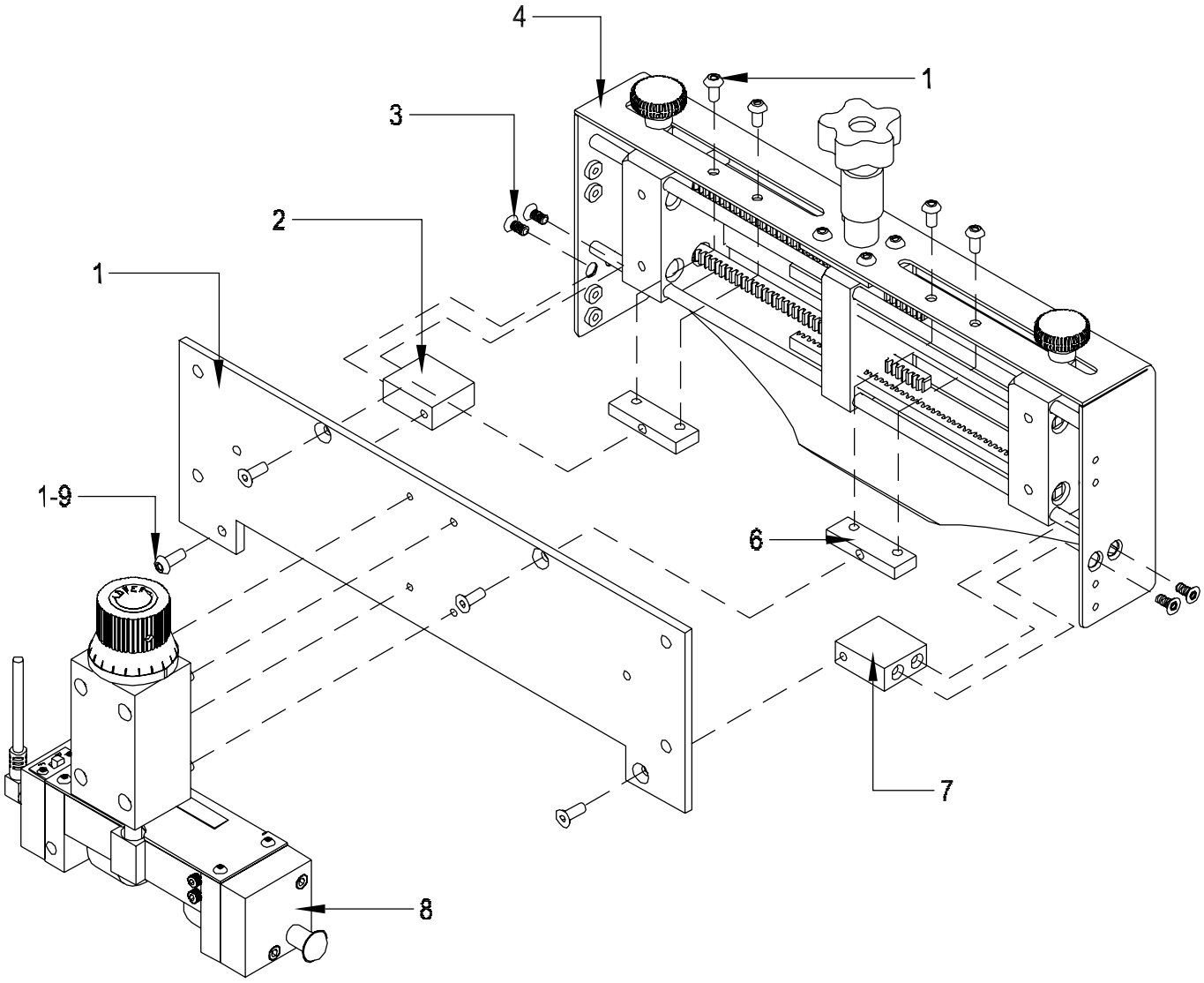
HOPPER - ONE KNOB - CURVED STANDARD (12”)
Assembly # : 64011004



HOPPER - ONE KNOB - CURVED STANDARD (12”)
Assembly # : 64011004

ITEM	QTY.	PART NUMBER	DESCRIPTION
1	1	44640004	PLATE, SOLID GATE
2	1	44646002	BLOCK, SIDE GUIDE
3	2	44646001	BLOCK, SIDE GUIDE ADJUSTING
4	1	44646004	BLOCK, ADJUSTMENT REFERENCE
5	4	44646010	RACK
6	1	44646005	SHAFT, PINION ADJUSTMENT
7	2	44646006	GUIDE, RAIL SIDE
8	2	44646015	SPACER, LOWER
9	2	44646016	SPACER .50 OD X .19 ID X .25 LG
10	1	44646003	BAR, LOWER GATE
11	1	44646012	COVER, GUIDE ADJUSTMENT
12	2	44681021	THUMB KNOB W/10-32 INSERT
13	2	15000007	GATE “J” HOOK
14	1	44646007	RETAINER, LOWER SPRING
15	1	44646008	RETAINER, UPPER SPRING
16	1	44646009	KNOB, 5 LOB ¼-20 X ½LG
17	1	44646013	SPRING, COMPRESSION
18	2	102732B13	SSSCPPT BLACK OXIDE 10-32 X 1.50
19	6	102916B03	FHCS SSTL 10-32 X .50
20	8	102957B02	BHCS SST 10-32 X .38
21	4	102733B03	SSSCPPT BLACK OXIDE ¼-20 X .25
22	2	102685B04	SHCS BLACK OXIDE 8-32 X .62

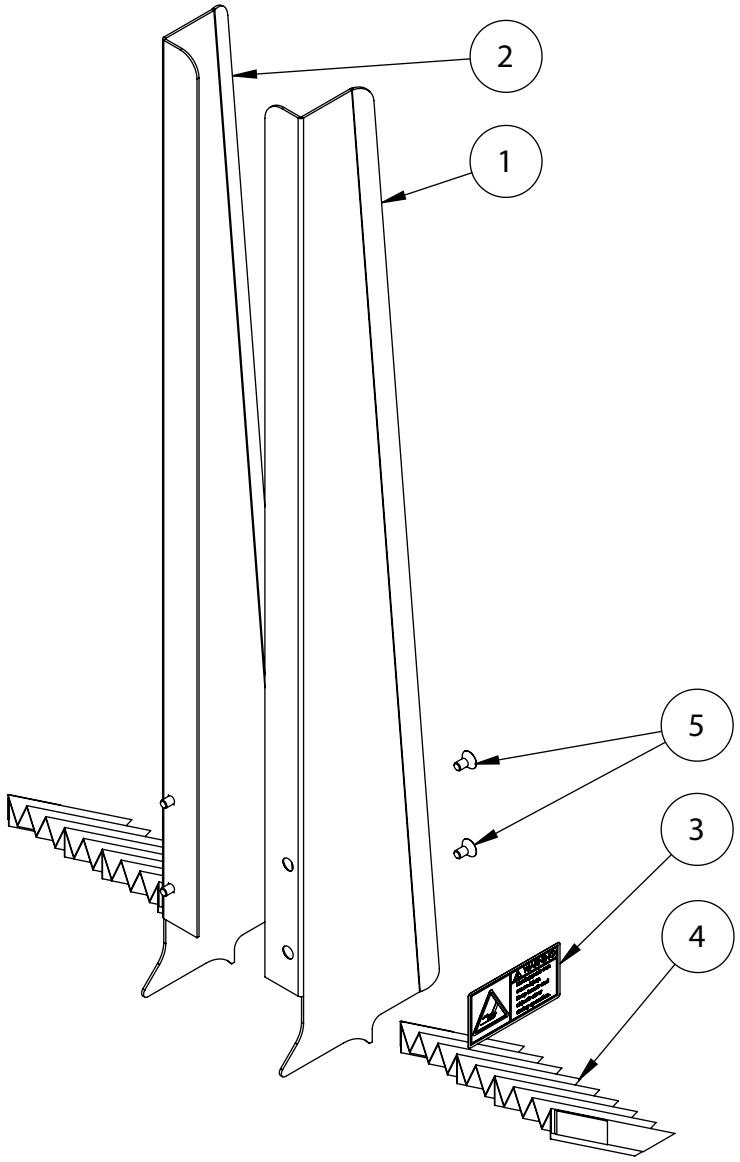
HOPPER - ONE KNOB - CURVED ROTATING GATE (12”)
Assembly # : 13261104



HOPPER - ONE KNOB - CURVED ROTATING GATE (12")
Assembly # : 13261104

ITEM	QTY.	PART NUMBER	DESCRIPTION
1	1	44640004	PLATE, SOLID GATE
2	1	44646002	BLOCK, SIDE GUIDE
3	2	44646001	BLOCK, SIDE GUIDE ADJUSTING
4	2	44646010	RACK
5	1	44646005	SHAFT, PINION ADJUSTMENT
6	2	44646006	GUIDE, RAIL SIDE
7	2	44646015	SPACER, LOWER
8	2	44646016	SPACER .50 OD X .19 ID X .25 LG
9	2	44681021	THUMB KNOB W/10-32 INSERT
10	1	44646007	RETAINER, LOWER SPRING
11	1	44646008	RETAINER, UPPER SPRING
12	1	44646009	KNOB, 5 LOB ¼-20 X ½LG
13	1	44646013	SPRING, COMPRESSION
14	1	44857005	BLOCK, ADJUSTMENT
15	1	51088001	PLATE, INTERFACE ST1250
16	2	51088003	BLOCK, SUPPORT
17	1	51088015	BLOCK, GATE SUPPORT
18	1	51088012	BLOCK, GATE SUPPORT
19	2	102732B12	SSSCPPT BLACK OXIDE 10-32 X 1.25
20	6	102916B02	FHCS SSTL 10-32 X .38
21	2	102733B03	SSSCPPT BLACK OXIDE ¼-20 X .25
22	3	102637B02	FHCS BLACK OXIDE 10-32 X .38

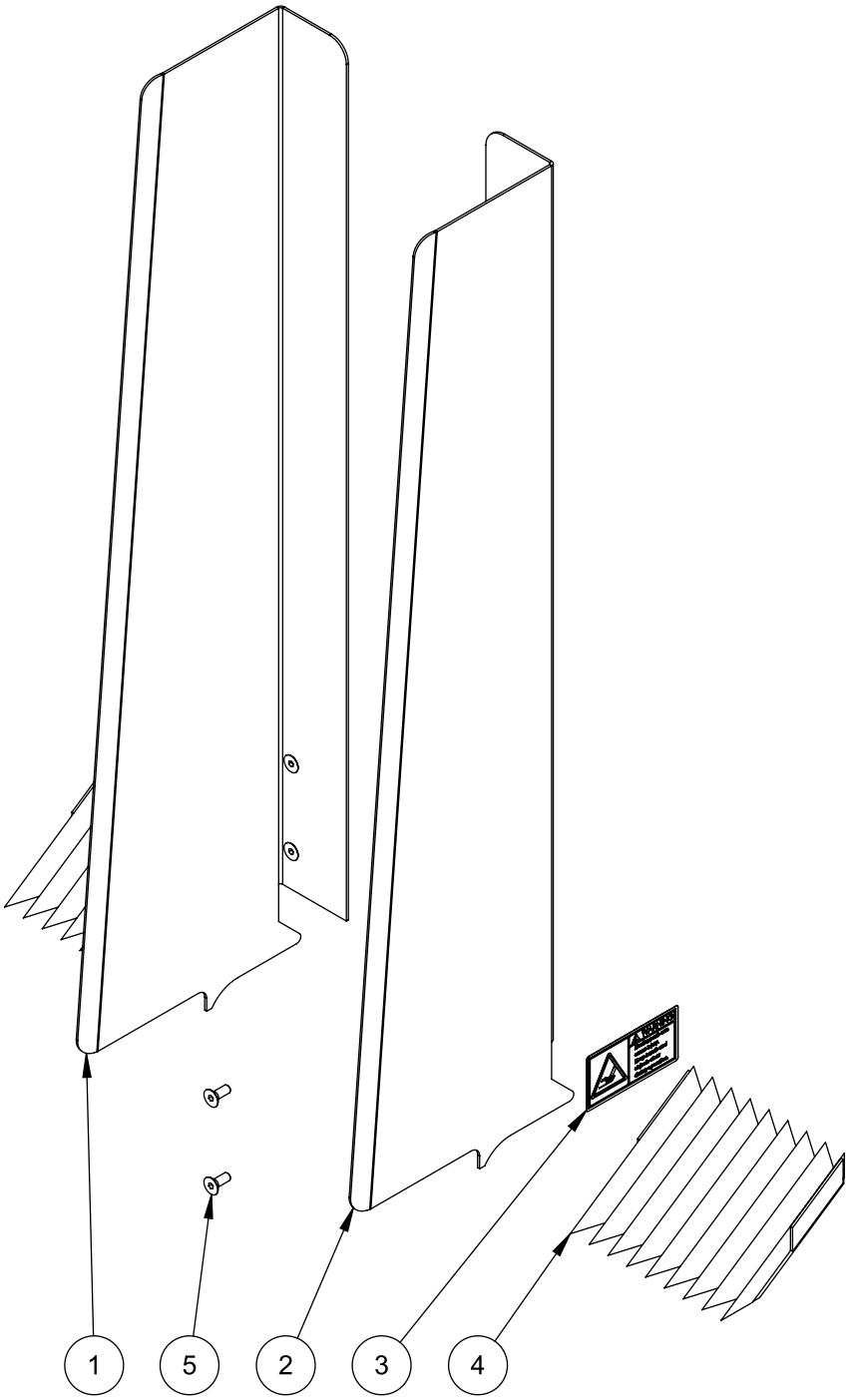
1424 STAINLESS STEEL SIDE GUIDE KIT CUR
Assembly # : 64011017



1424 STAINLESS STEEL SIDE GUIDE KIT CUR
Assembly # : 64011017

ITEM	QTY.	PART NUMBER	DESCRIPTION
1	1	44640017	SIDE GUIDE, NARROW
2	1	44640018	GUIDE RIGHT 1424
3	2	53500609	LABEL, WARN INJURY 2.7 X 1.4
4	2	44600001	GUARD, REAR ACCORDION
5	4	102916B02	FHCS SSTL 10-32 X .38

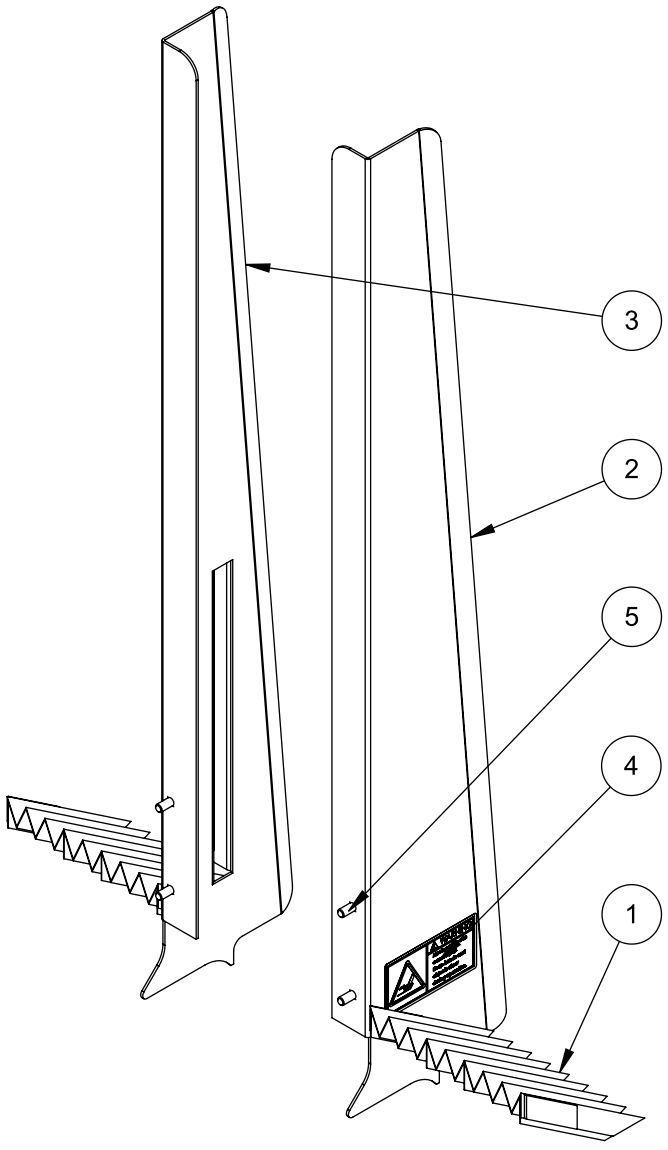
2624 STAINLESS STEEL SIDE GUIDE KIT CUR
Assembly # : 64011002



2624 STAINLESS STEEL SIDE GUIDE KIT CUR
Assembly # : 64011002

ITEM	QTY.	PART NUMBER	DESCRIPTION
1	1	44640002	STANDARD LEFT
2	1	44640003	STANDARD RIGHT
3	2	53500609	LABEL, WARN INJURY 2.7 X 1.4
4	2	44600001	GUARD, REAR ACCORDION
5	4	102916B03	FHCS SSTL 10-32 X .50

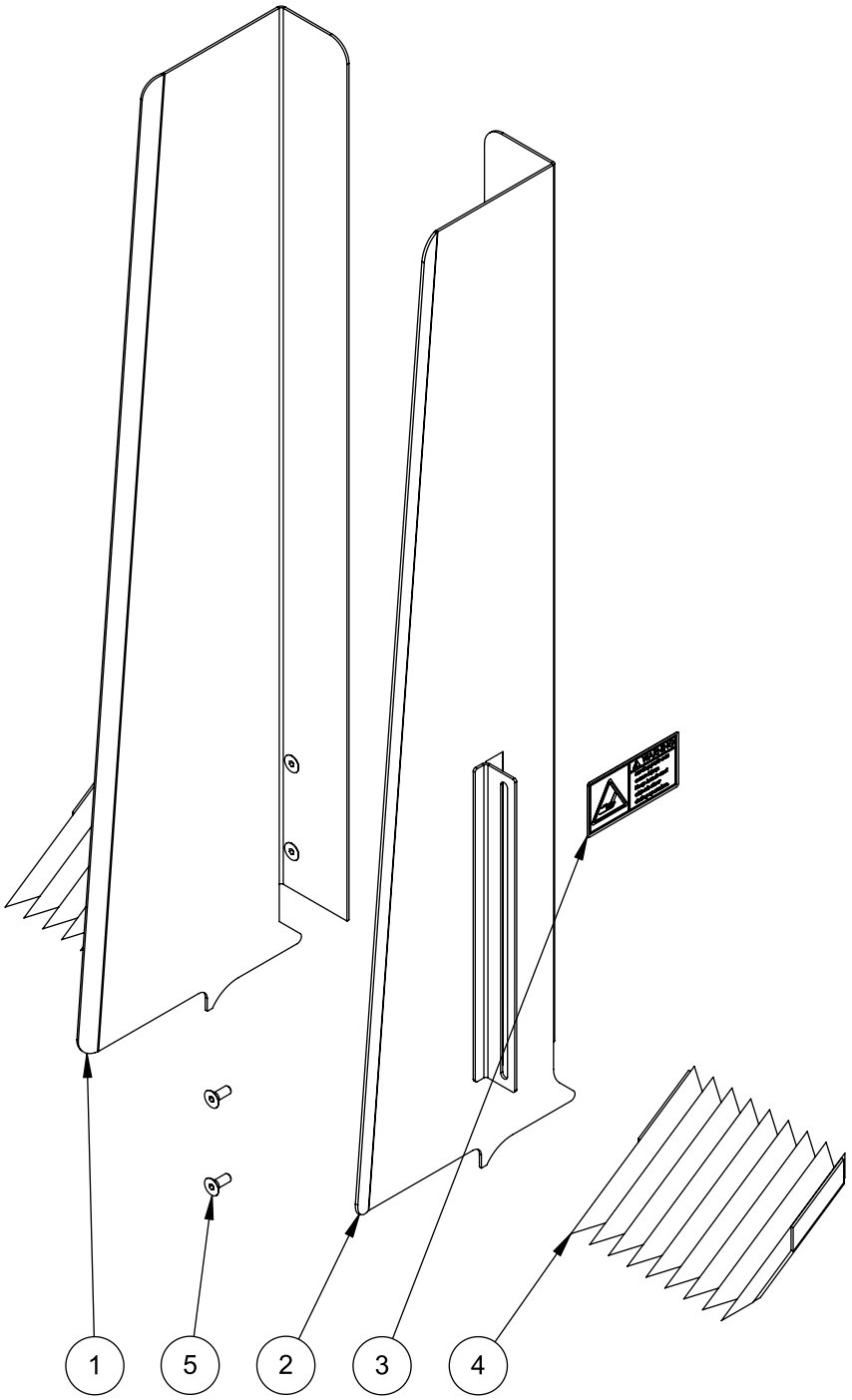
1424 STAINLESS STEEL SIDE GUIDE KIT FOR LOW STACK OPTION CUR
Assembly # : 311-1534



1424 STAINLESS STEEL SIDE GUIDE KIT FOR LOW STACK OPTION CUR
Assembly # : 311-1534

ITEM	QTY.	PART NUMBER	DESCRIPTION
1	2	44600001	GUARD, REAR ACCORDION
2	1	44640017	SIDE GUIDE, NARROW
3	1	44640022	SIDE GUIDE, LS NARROW RIGHT
4	2	53500609	LABEL, WARN INJURY 2.7 X 1.4
5	4	102916B03	FHCS SSTL 10-32 X .50

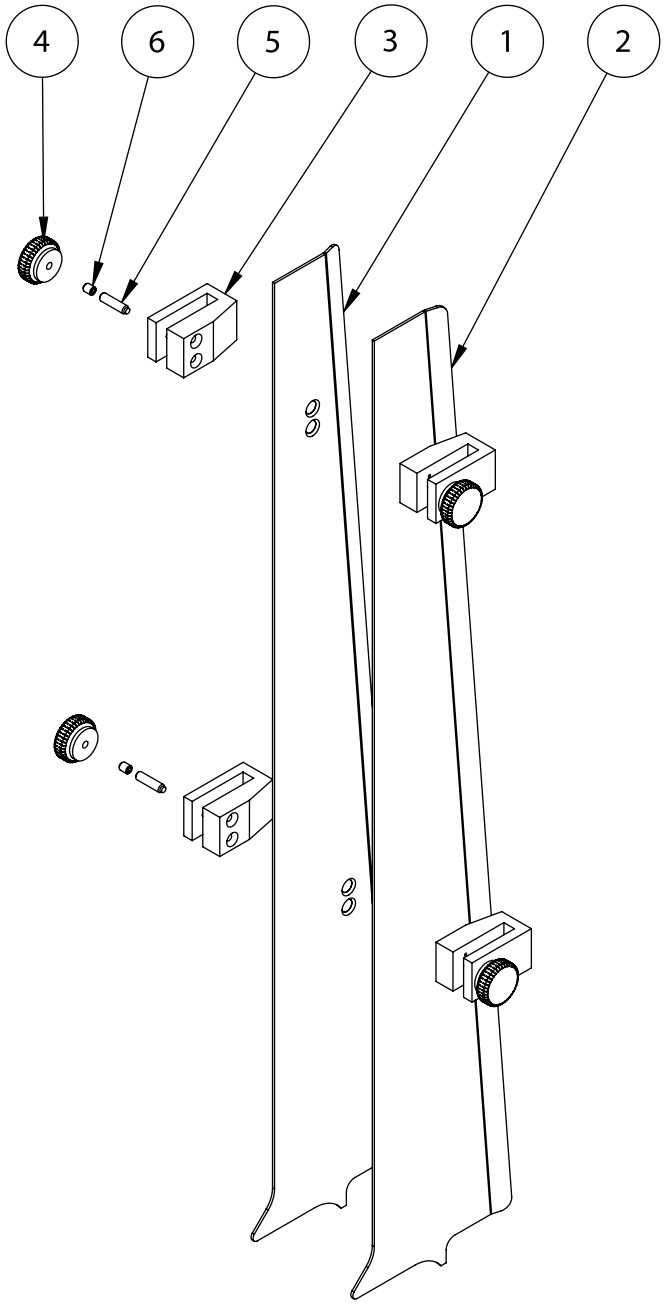
2624 STAINLESS STEEL SIDE GUIDE KIT FOR LOW STACK OPTION CUR
Assembly # : 311-1538



2624 STAINLESS STEEL SIDE GUIDE KIT FOR LOW STACK OPTION CUR
Assembly # : 311-1538

ITEM	QTY.	PART NUMBER	DESCRIPTION
1	1	44640002	STANDARD LEFT
2	1	44640020	SIDE GUIDE, RH LOW STACK
3	2	53500609	LABEL, WARN INJURY 2.7 X 1.4
4	2	44600001	GUARD, REAR ACCORDION
5	4	102916B03	FHCS SSTL 10-32 X .50

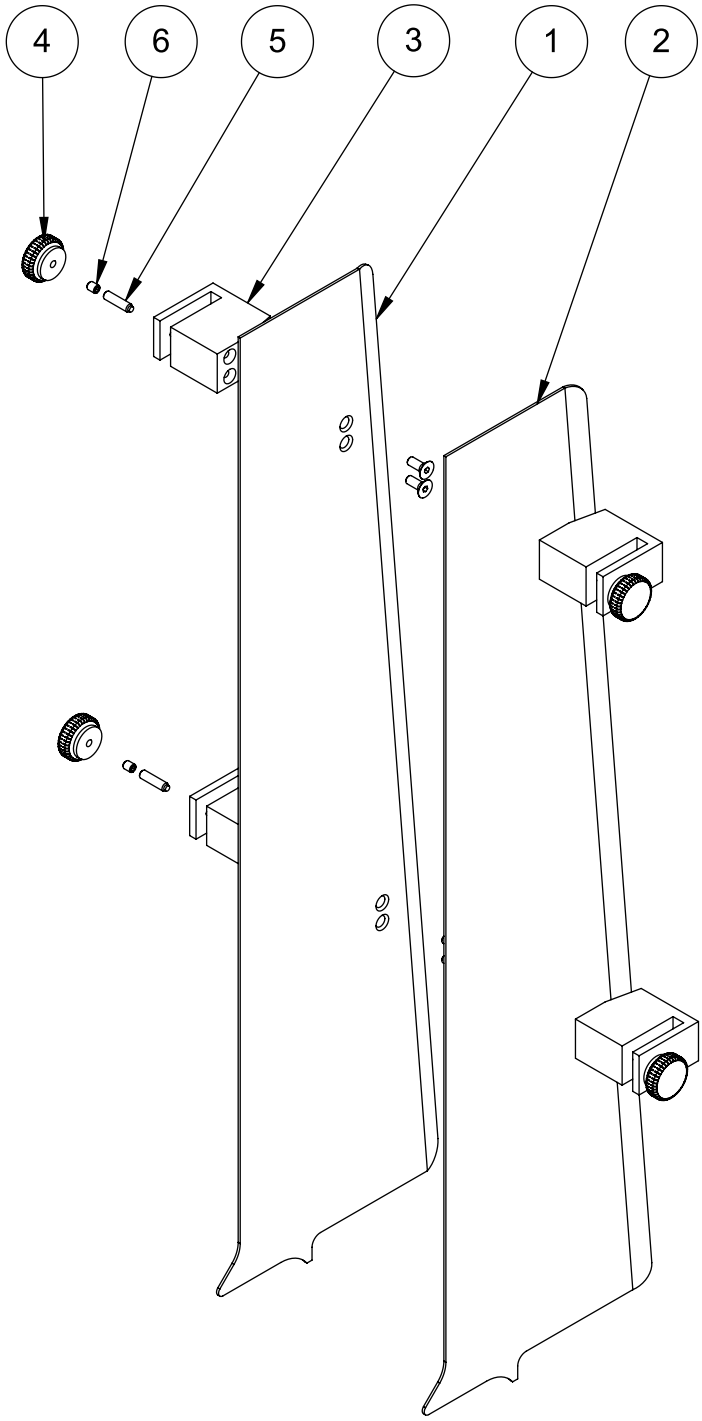
424 SIDE GUIDE NARROWING KIT CUR
Assembly # : 64011024



424 SIDE GUIDE NARROWING KIT CUR
Assembly # : 64011024

ITEM	QTY.	PART NUMBER	DESCRIPTION
1	1	44640026	SHALLOW RIGHT SIDE
2	1	44640025	SHALLOW LEFT SIDE
3	4	44640024	WIDE MOUNTING BLOCK
4	4	44681021	THUMB KNOB W/10-32 INSERT
5	4	44681020	SSSNYLTIP 10-32 X .75
6	4	102732B03	SSSCPPT BLACK OXIDE 10-32 X .25
7	8	102916B03	FHCS SSTL 10-32 X .50

624 SIDE GUIDE NARROWING KIT CUR
Assembly # : 64011023

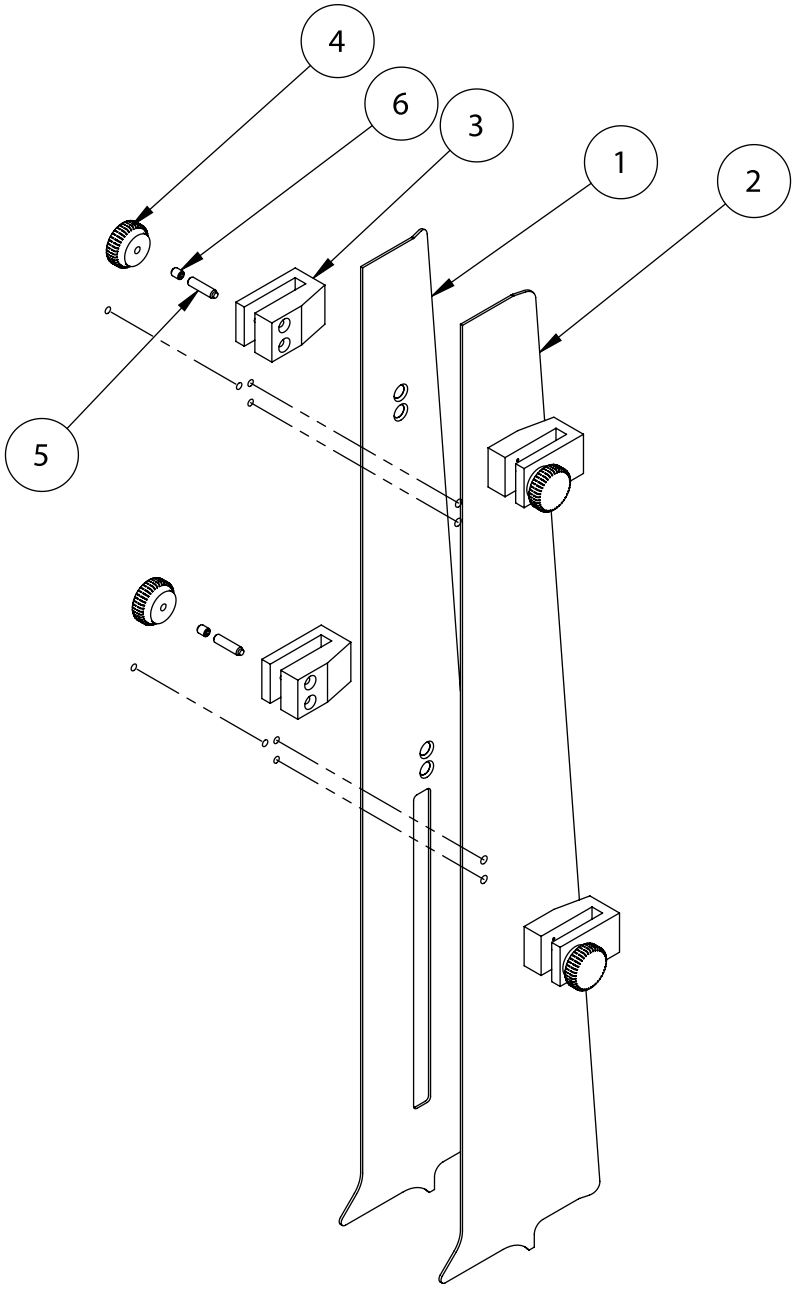


624 SIDE GUIDE NARROWING KIT CUR
Assembly # : 64011023

ITEM	QTY.	PART NUMBER	DESCRIPTION
1	1	44640027	GUIDE, RIGHT NARROWNG 624 SIDE
2	1	44640028	GUIDE, LEFT NARROWING 624 SIDE
3	4	44640023	WIDE MOUNTING BLOCK
4	4	44681021	THUMB KNOB W/10-32 INSERT
5	4	44681020	SSSNYLTIP 10-32 X .75
6	4	102732B03	SSSCPPT BLACK OXIDE 10-32 X .25
7	8	102916B03	FHCS SSTL 10-32 X .50

424 SIDE GUIDE NARROWING KIT FOR LOW STACK

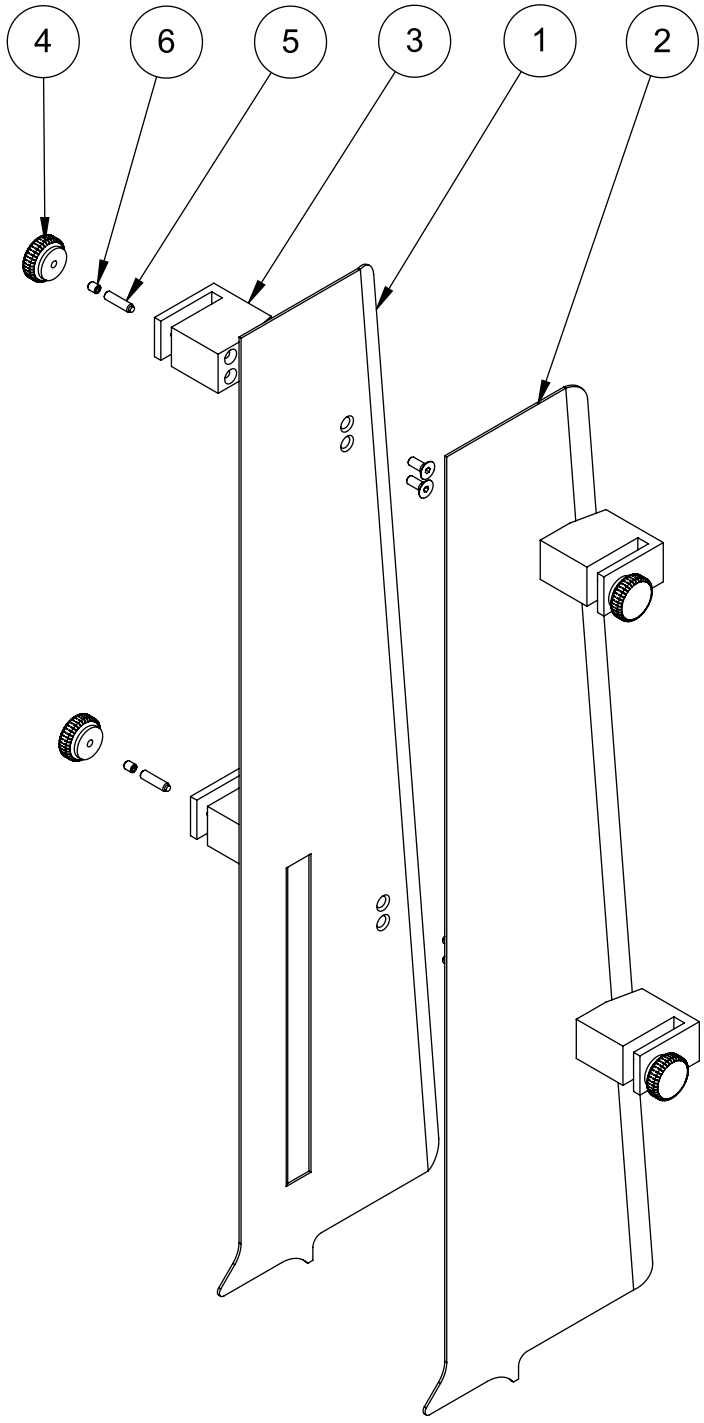
Assembly # : 311-0339



424 SIDE GUIDE NARROWING KIT FOR LOW STACK
Assembly # : 311-0339

ITEM	QTY.	PART NUMBER	DESCRIPTION
1	1	901229	SIDE GUIDE NARROW
2	1	44640025	SHALLOW LEFT SIDE
3	4	44640024	WIDE MOUNTING BLOCK
4	4	44681021	THUMB KNOB W/10-32 INSERT
5	4	44681020	SSSNYLTIP 10-32 X .75
6	4	102732B03	SSSCPPT 10-32 X .25
7	8	102916B03	FHCS SSTL 10-32 X .50

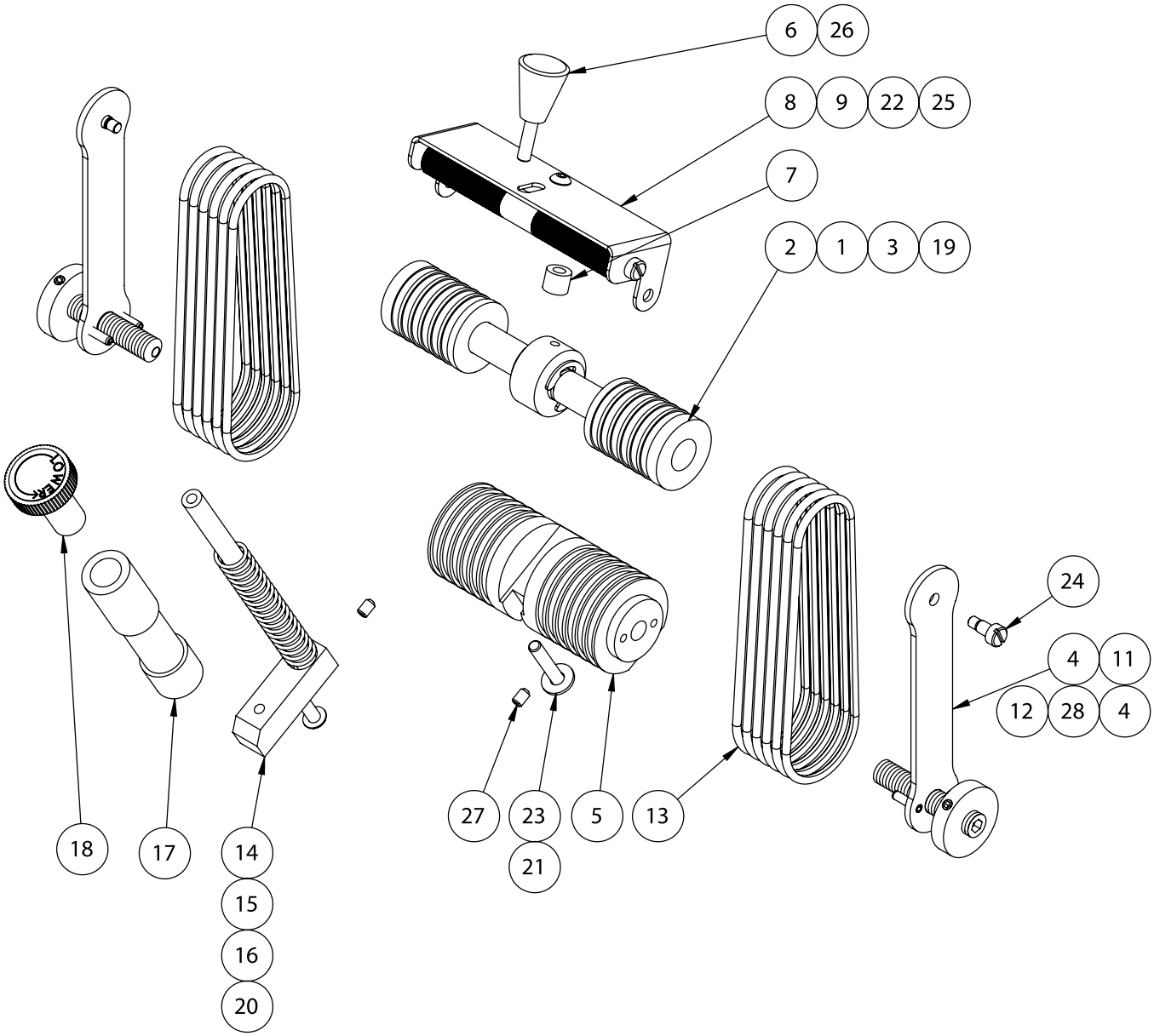
624 SIDE GUIDE NARROWING KIT FOR LOW STACK
Assembly # : 64011034



624 SIDE GUIDE NARROWING KIT FOR LOW STACK
Assembly # : 64011034

ITEM	QTY.	PART NUMBER	DESCRIPTION
1	1	44640034	OBS GUDE RH LOW STCK NAR 624
2	1	44640028	GUIDE, LEFT NARROWING 624 SIDE
3	4	44640023	WIDE MOUNTING BLOCK
4	4	44681021	THUMB KNOB W/10-32 INSERT
5	4	44681020	SSSNYLTIP 10-32 X .75
6	4	102732B03	SSSCPPT BLACK OXIDE 10-32 X .25
7	8	102916B03	FHCS SSTL 10-32 X .50

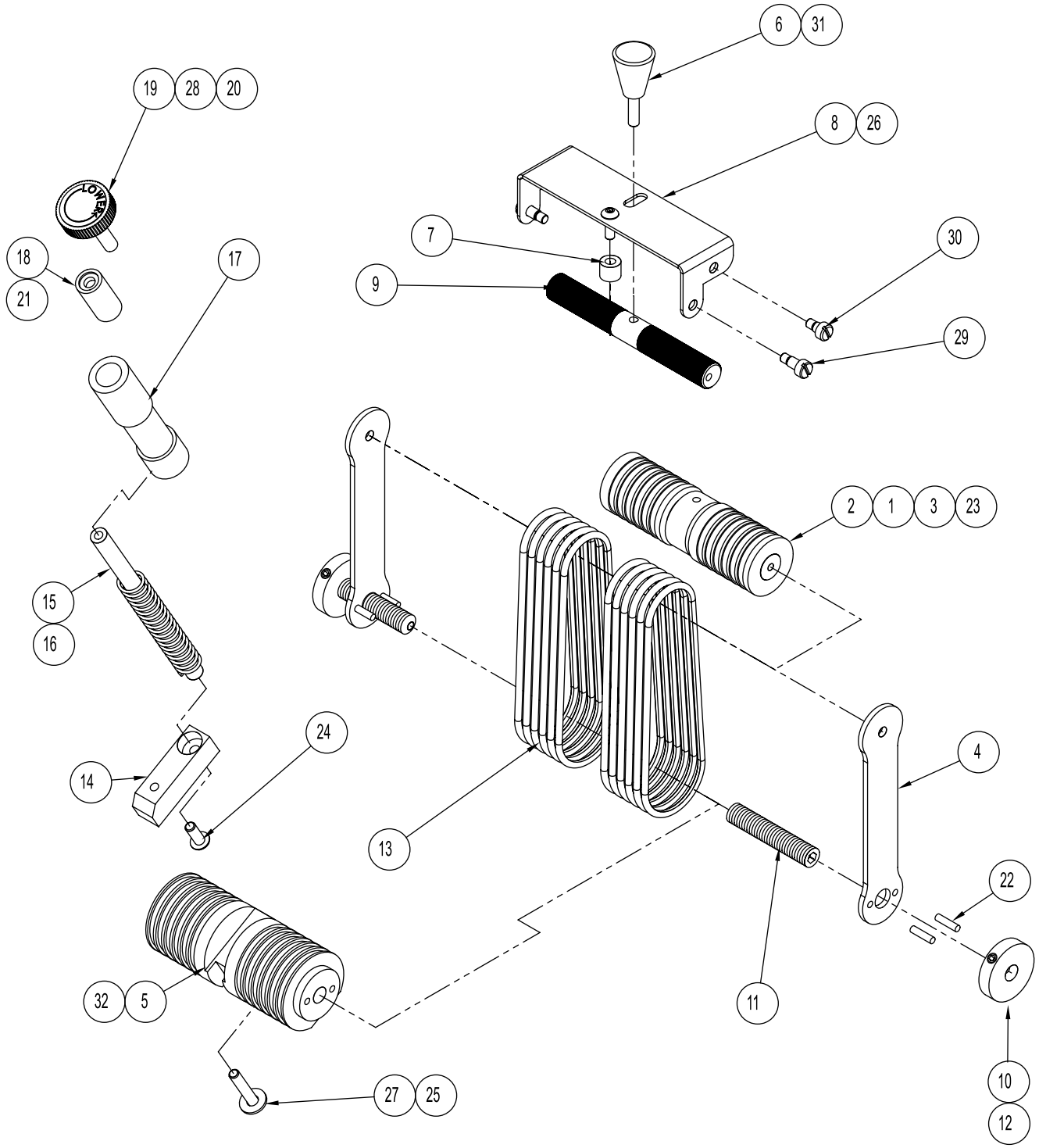
ADVANCING O-RING GATE (SDO)
Assembly # : 87211001



ADVANCING O-RING GATE (SDO)
Assembly # : 87211001

ITEM	QTY.	PART NUMBER	DESCRIPTION
1	1	44657008	BELT INDEXER SHAFT
2	2	44657002	O-RING TAKE UP ROLLER
3	1	44657009	BELT INDEXER
4	2	44872002	PLATE SIDE ADJUSTOR
5	1	44872004	CYLINDER, GATE
6	1	44657007	HANDLE STUDDED
7	1	44657010	BELT INDEXER SPACER
8	1	44657005	BELT INDEXER BRACKET
9	1	44657003	PINCH ROLL CAM
10	2	44872003	ROLLER
11	2	44872005	SCREW ADJUSTMENT
12	2	44872007	SSSNYLTIP 10-32 X .38
13	12	44657006	O-RING ADV ST
14	1	15000001	GATE LIFT SHAFT MOUNT
15	1	23560084	GATE LIFT SHAFT
16	1	23500083	GATE COMPRESSION SPRING
17	1	23500019	CATE SPRING
18	1	23511037	ASSY, KNB GAT CYLNDR ADJSTMNT
19	2	104308B02	E-TYPE, STEEL CLIP FOR 1/2 SHAFT
20	1	102708B03	BHCS BLACK OXIDE 10-32 X .50
21	1	102708B07	BHCS BLACK OXIDE 10-32 X 1.00
22	1	102706B03	BHCS BLACK OXIDE 8-32 X .50
23	1	103240B04	FLAT WASHER ZINC STEEL #10
24	2	600651A02	.19 X .25 SCREW, SHOULDER SLOTTED
25	2	600651A01	.19 X .13 SCREW, SHOULDER SLOTTED
26	1	102732B11	SSSCPPT BLACK OXIDE 10-32 X 1.00
27	2	102729B03	SSSCPPT 8-32 X .25
28	4	103229B07	SPRING PIN, 1/8 DIA X .50 STEEL

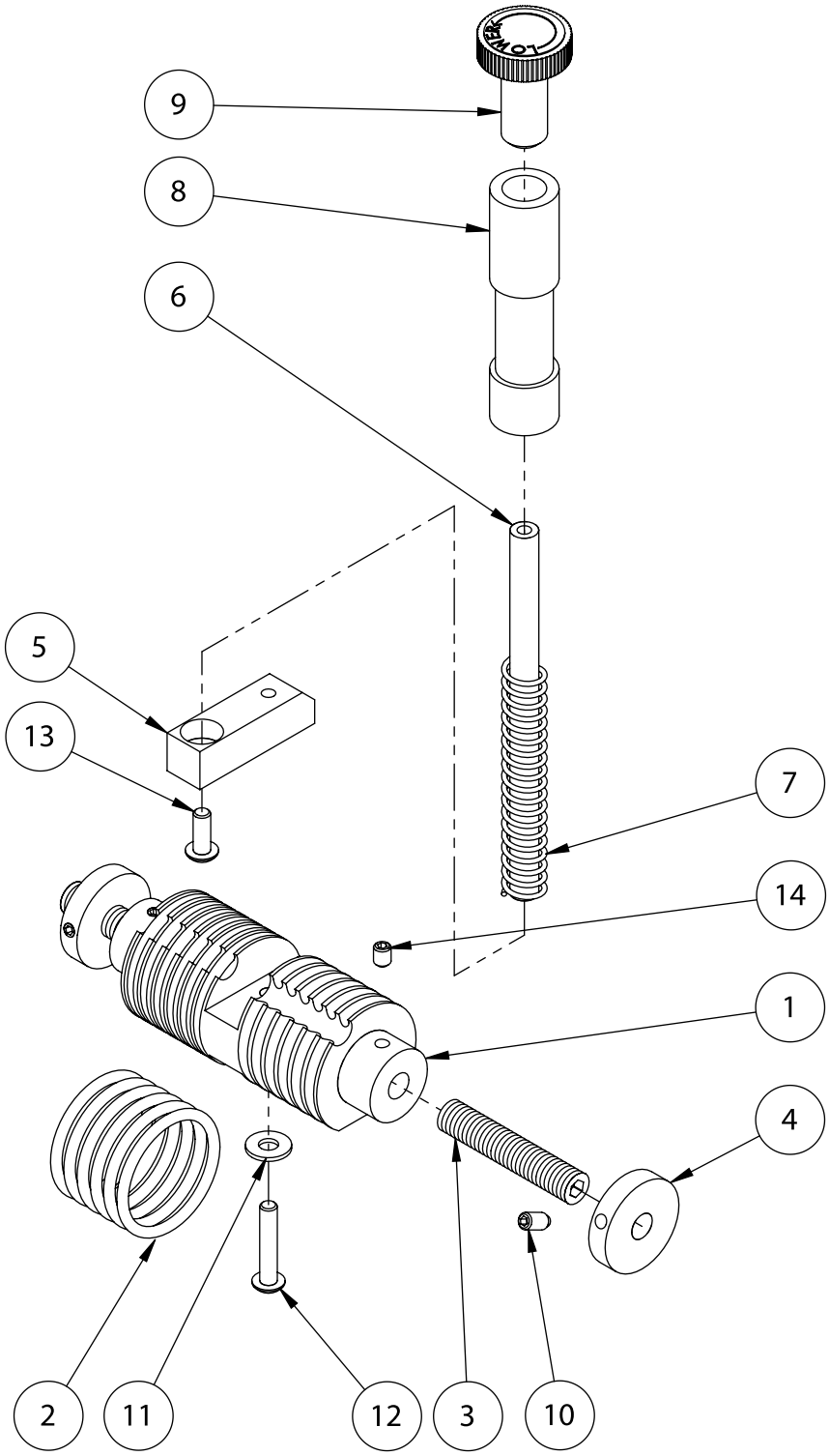
ADVANCING O-RING GATE (HDO)
Assembly # : 87211007



ADVANCING O-RING GATE (HDO)
Assembly # : 87211007

ITEM	QTY.	PART NUMBER	DESCRIPTION
1	1	44657008	BELT INDEXER SHAFT
2	2	44657002	O-RING TAKE UP ROLLER
3	1	44657009	BELT INDEXER
4	2	44872002	PLATE SIDE ADJUSTOR
5	1	44872004	CYLINDER, GATE
6	1	44657007	HANDLE STUDDED
7	1	44657010	BELT INDEXER SPACER
8	1	44657005	BELT INDEXER BRACKET
9	1	44657003	PINCH ROLL CAM
10	2	44872003	ROLLER
11	2	44872005	SCREW ADJUSTMENT
12	2	44872007	SHSS 10-32 X 3/8
13	12	44657011	ORING ADVANCING GATE HDO
14	1	15000001	GATE LIFT SHAFT MOUNT
15	1	23560084	GATE LIFT SHAFT
16	1	23500083	GATE COMPRESSION SPRING
17	1	23500019	CATE SPRING
18	1	23500037	ADJ KNOB SLEEVE
19	1	23500077	1” THUMB SCREW
20	1	23500084	GATE ADJUSTMENT
21	1	23500240	O RING, GATE SLEEVE
22	4	103229B07	ROLL PIN .125 X .50LG
23	2	104308B02	E-CLIP 1/2
24	1	102708B03	BHCS #10-32 X 1/2
25	1	102708B07	BHCS #10-32 X 1
26	1	102706B03	BHCS #8-32 X 1/2
27	1	103240B04	FW #10
28	1	102939B07	SHCS 1/4-28 X 1.00
29	2	600651A02	.19 X .25 SCREW, SHOULDER SLOTTED
30	2	600651A01	.19 X .13 SCREW, SHOULDER SLOTTED
31	1	102732B11	SET SCREW, #10-32 X 1
32	2	102729B03	SSSCPPT 8-32NC X .24

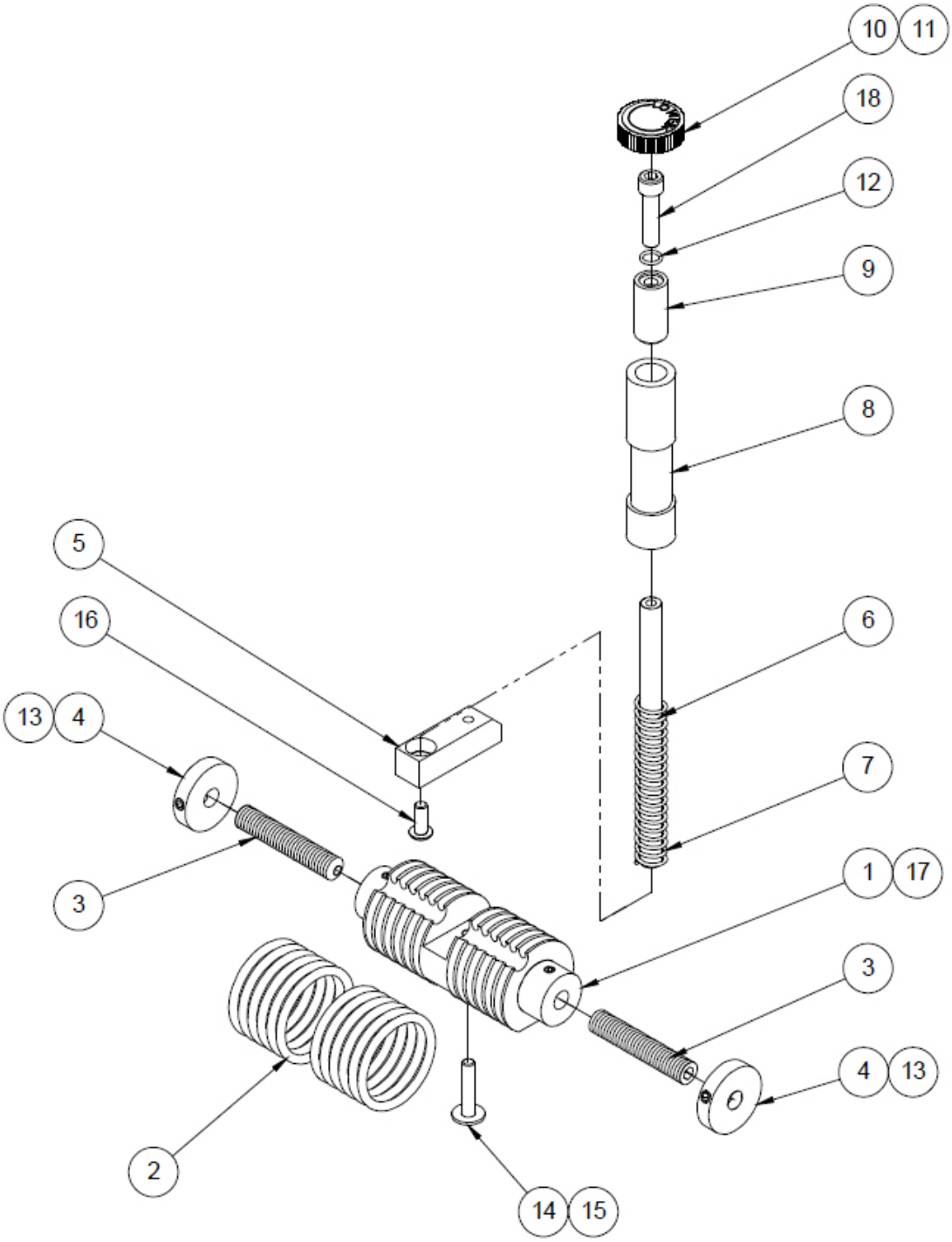
STANDARD O-RING GATE (SDO)
Assembly # : 13511872



STANDARD O-RING GATE (SDO)
Assembly # : 13511872

ITEM	QTY.	PART NUMBER	DESCRIPTION
1	1	51101001	GATE CYLINDER
2	12	23500089	O-RING, STANDARD GATE
3	2	44872005	SCREW ADJUSTMENT
4	2	44872003	ROLLER
5	1	15000001	GATE LIFT SHAFT MOUNT
6	1	23560084	GATE LIFT SHAFT
7	1	23500083	GATE COMPRESSION SPRING
8	1	23500019	CATE SPRING
9	1	23511037	ASSY, KNB GAT CYLNDR ADJSTMNT
10	2	44872007	SSSNYLTIP 10-32 X .38
11	1	103240B04	FLAT WASHER ZINC STEEL #10
12	1	102708B07	BHCS BLACK OXIDE 10-32 X 1.00
13	1	102708B03	BHCS BLACK OXIDE 10-32 X .50
14	2	102732B03	SSSCPPT BLACK OXIDE 10-32 X .25

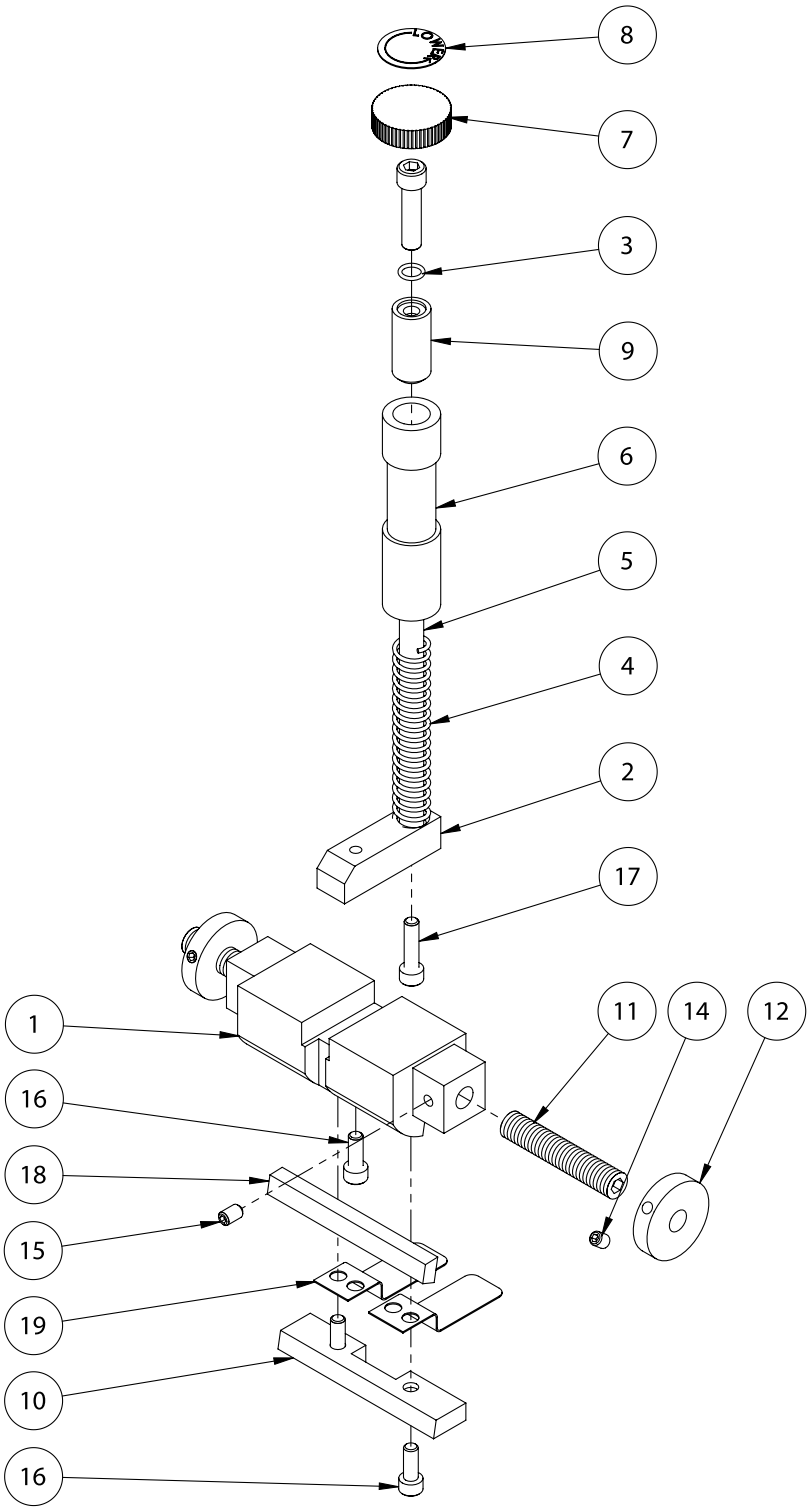
STANDARD O-RING GATE (HDO)
Assembly # : 13511104



STANDARD O-RING GATE (HDO)
Assembly # : 13511104

ITEM	QTY.	PART NUMBER	DESCRIPTION
1	1	51101001	GATE CYLINDER
2	12	23500104	O RING, STANDARD
3	2	44872005	SCREW ADJUSTMENT
4	2	44872003	ROLLER
5	1	15000001	GATE LIFT SHAFT MOUNT
6	1	23560084	GATE LIFT SHAFT
7	1	23500083	GATE COMPRESSION SPRING
8	1	23500019	CATE SPRING
9	1	23500037	ADJ KNOB SLEEVE
10	1	23500077	1” THUMB SCREW
11	1	23500084	GATE ADJUSTMENT
12	1	23500240	O RING, GATE SLEEVE
13	2	44872007	SHSS 10-32 X 3/8
14	1	103240B04	FW #10
15	1	102708B07	BHCS #10-32 X 1
16	1	102708B03	BHCS #10-32 X 1/2
17	2	102732B03	SSSCPPT #10-32 X 1/4
18	1	102939B07	SHCS 1/4-28 X 1.00

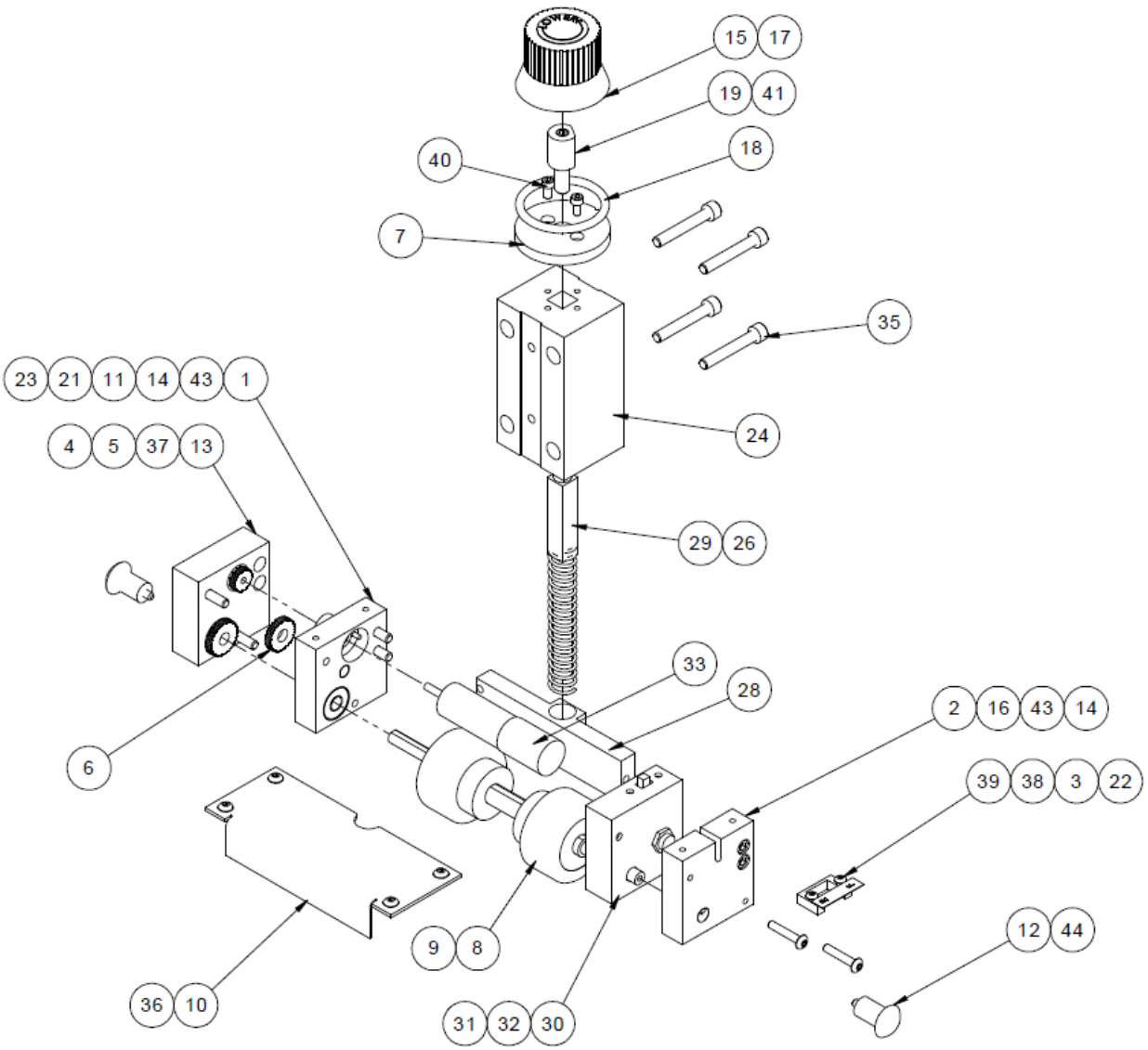
BAR GATE
Assembly # : 15011872



BAR GATE
Assembly # : 15011872

ITEM	QTY.	PART NUMBER	DESCRIPTION
1	1	44996008	CYLINDER, HORIZON BAR
2	1	15000001	GATE LIFT SHAFT MOUNT
3	1	23500240	O RING, GATE SLEEVE
4	1	23500083	GATE COMPRESSION SPRING
5	1	23560084	GATE LIFT SHAFT
6	1	23500019	CATE SPRING
7	1	23500077	1” THUMB SCREW
8	1	23500084	GATE ADJUSTMENT
9	1	23500037	ADJ KNOB SLEEVE
10	1	44500067	HOLDER, V BAR GATE BELT
11	2	44872005	SCREW ADJUSTMENT
12	2	44872003	ROLLER
13	1	102939B07	SHCS SS 1/4-28 X 1.00
14	2	102732B03	SSSCPPT 10-32 X .25
15	2	102732B04	SSSCPPT BLACK OXIDE 10-32 X .31
16	3	102688B03	SHCS BLACK OXIDE 10-32 X .50
17	1	102688B05	SHCS BLACK OXIDE 10-32 X .75
18	1	903125	V-BELTING EAGLE ORNGE 85
19	2	903449	STRAP, BAR GATE II

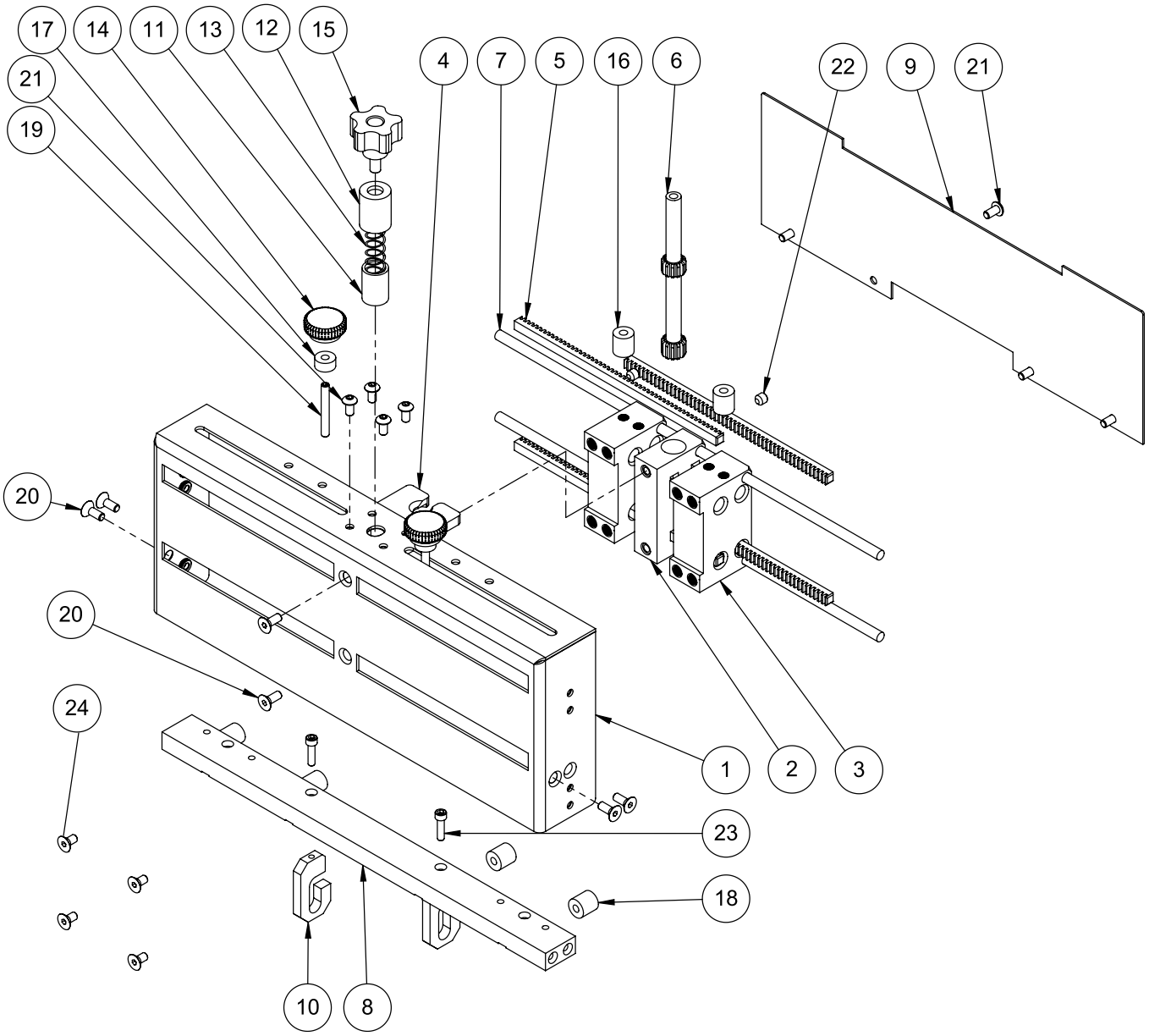
POWERED ROTATING GATE (SDO)
Assembly # : 13261101



POWERED ROTATING GATE (SDO)
Assembly # : 13261101

ITEM	QTY.	PART NUMBER	DESCRIPTION
1	1	51326007	ROLLER SUPPORT ARM
2	1	51326003	ROLLER SUPPORT ARM
3	1	44874028	SWITCH MOUNT
4	1	44874061	3MM SPUR GEAR 20T
5	1	44874062	6MM SPUR GEAR
6	1	44874063	SPUR GEAR 30T HUBLESS
7	1	51277082	MOUNTING FLANGE KNOB
8	2	51326001	ROLLER
9	1	51326002	ROLLER SHAFT
10	1	51326013	MOTOR COVER
11	1	51326012	BEARING INSERT
12	2	51326014	PUSH PULL KNOB
13	1	51326009	GEAR COVER
14	2	44582021	R4 BEARING
15	1	51277083	KNOB
16	1	44681019	10-32 BALL PLUNGER
17	1	23500084	GATE ADJUSTMENT
18	1	23500104	O RING, STANDARD
19	1	51277081	KNOB INSERT
20	1	13261102	ASSY, CABLE 3 POLE
21	1	51326011	PIN, DOWELL
22	1	51326016	SWITCH, POSITION INDICATOR
23	2	51326017	SCREW, SLOTTED HEAD
24	1	51277025	BLOCK, GATE SLEEVE
25	1	23500095	BEARING, BALL
26	1	23500083	GATE COMPRESSION SPRING
27	1	13261103	ASSY, INTERFACE POWER CABLE
28	1	51326004	MOUNT, GATE LIFT SHAFT

ONE KNOB - STRAIGHT (12”)
Assembly # : 311-1533



ONE KNOB - STRAIGHT (12”)
Assembly # : 311-1533

ITEM	QTY.	PART NUMBER	DESCRIPTION
1	1	44909001	PLATE, GATE STR ST850
2	1	44646002	BLOCK, SIDE GUIDE
3	2	44646001	BLOCK, SIDE GUIDE ADJUSTING
4	1	44646004	BLOCK, ADJUSTMENT REFERENCE
5	4	44646010	RACK
6	1	44646005	SHAFT, PINION ADJUSTMENT
7	2	44646006	GUIDE, RAIL SIDE
8	1	44646003	BAR, LOWER GATE
9	1	44646012	COVER, GUIDE ADJUSTMENT
10	2	15000007	GATE “J” HOOK
11	1	44646007	RETAINER, LOWER SPRING
12	1	44646008	RETAINER, UPPER SPRING
13	1	44646013	SPRING, COMPRESSION
14	2	44681021	THUMB KNOB W/10-32 INSERT
15	1	44646009	KNOB, 5 LOB ¼-20 X ½LG
16	2	44646015	SPACER, LOWER
17	2	44646016	SPACER .50 OD X .19 ID X .25 LG
18	4	904745	SPACER .50 OD X .19 ID X .50 LG
19	2	102732B13	SSSCPPT BLACK OXIDE 10-32 X 1.50
20	6	102916B03	FHCS SSTL 10-32 X .50
21	8	102957B02	BHCS SST 10-32 X .38
22	4	102733B03	SSSCPPT BLACK OXIDE ¼-20 X .25
23	2	102685B04	SHCS BLACK OXIDE 8-32 X .62
24	4	102916B02	FHCS SSTL 10-32 X .38

ONE KNOB - STRAIGHT ROTATING GATE (12”)

Assembly # : TBD

COMING SOON

ONE KNOB - STRAIGHT ROTATING GATE (12”)
Assembly # : TBD

COMING SOON

SIDE GUIDE KIT 1424, STR PLATE
Assembly # : 311-1520

COMING SOON

SIDE GUIDE KIT 1424, STR PLATE
Assembly # : 311-1520

COMING SOON

SIDE GUIDE KIT 2624, STR PLATE
Assembly # : 311-1519

COMING SOON

SIDE GUIDE KIT 2624, STR PLATE
Assembly # : 311-1519

COMING SOON

SIDE GUIDE KIT 1424 FOR LOW STACK OPTION, STR PLATE
Assembly # : 311-1537

COMING SOON

SIDE GUIDE KIT 1424 FOR LOW STACK OPTION, STR PLATE
Assembly # : 311-1537

COMING SOON

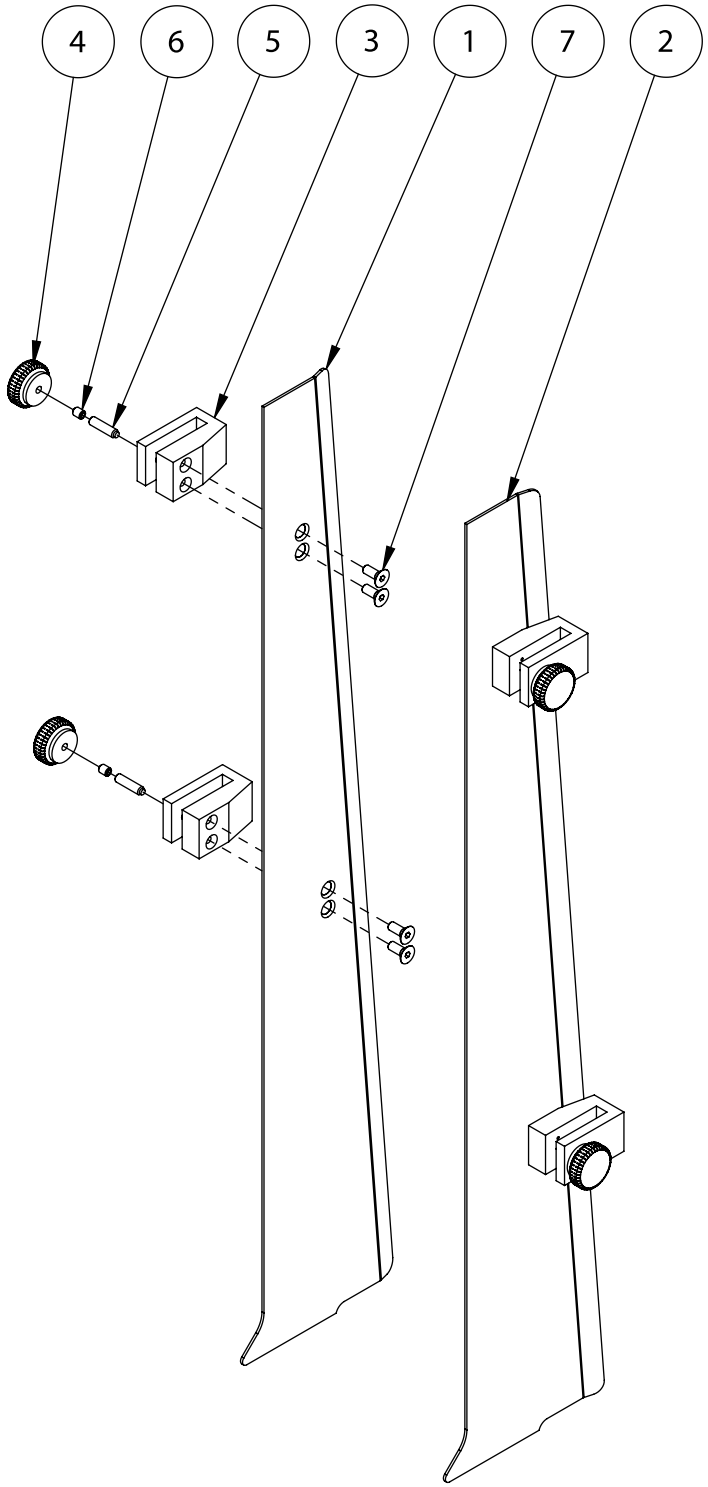
SIDE GUIDE KIT 2624 FOR LOW STACK OPTION, STR PLATE
Assembly # : TBD

COMING SOON

SIDE GUIDE KIT 2624 FOR LOW STACK OPTION, STR PLATE
Assembly # : TBD

COMING SOON

424 STR SIDE GUIDE NARROWING KIT
Assembly # : 311-1495



424 STR SIDE GUIDE NARROWING KIT
Assembly # : 311-1495

ITEM	QTY.	PART NUMBER	DESCRIPTION
1	1	904850	SIDE GUIDE NARRWNG ST.
2	1	904584	SHALLOW LEFT SIDE
3	4	44640024	WIDE MOUNTING BLOCK
4	4	44681021	THUMB KNOB W/10-32 INSERT
5	4	44681020	SSSNYLTIP 10-32 X .75
6	4	102732B03	SSSCPPT BLACK OXIDE 10-32 X .25
7	8	102916B03	FHCS SSTL 10-32 X .50

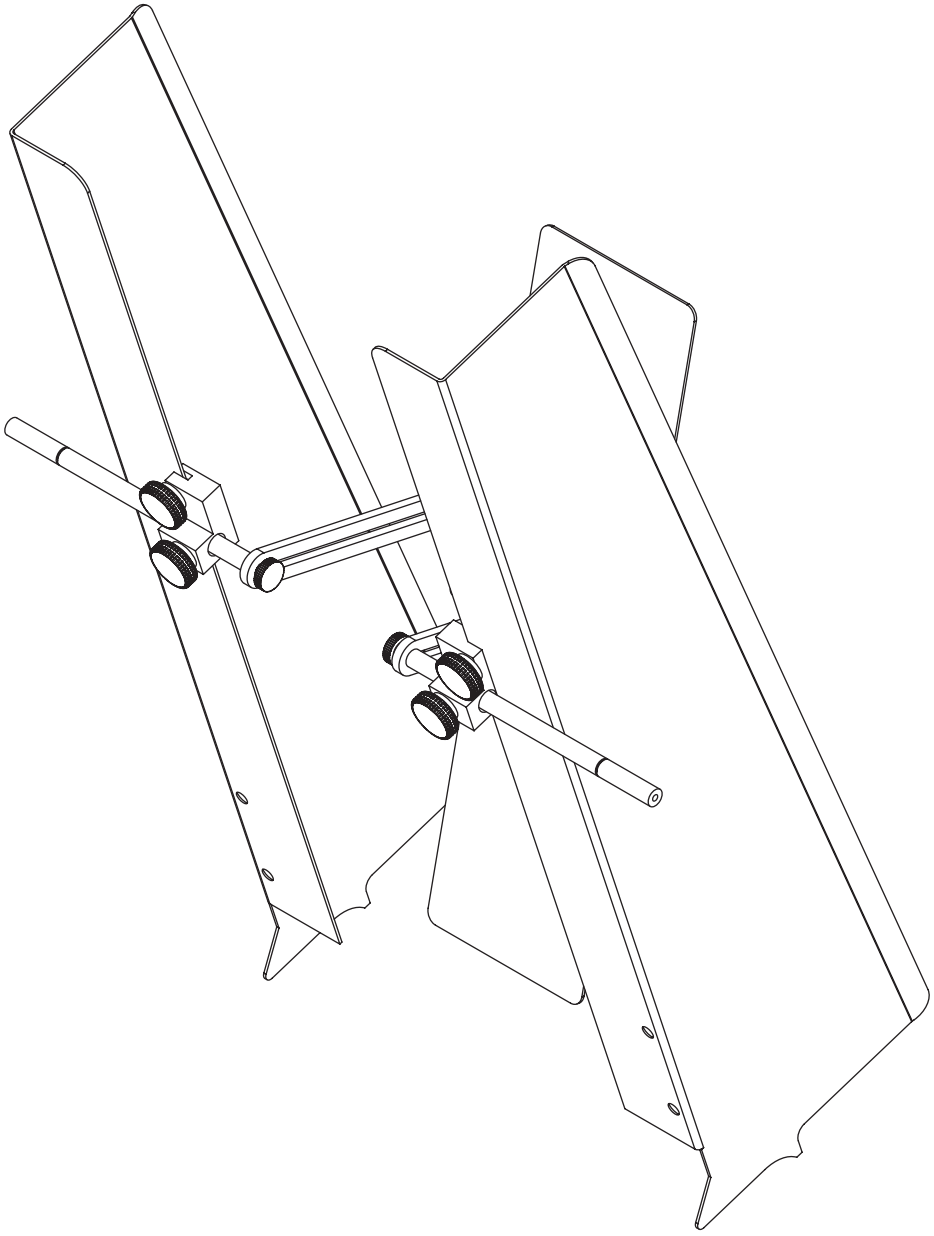
624 STR SIDE GUIDE NARROWING KIT
Assembly # : 311-1521

COMING SOON

624 STR SIDE GUIDE NARROWING KIT
Assembly # : 311-1521

COMING SOON

ADJUSTABLE PRE-GATE KIT
Assembly # : 63011806

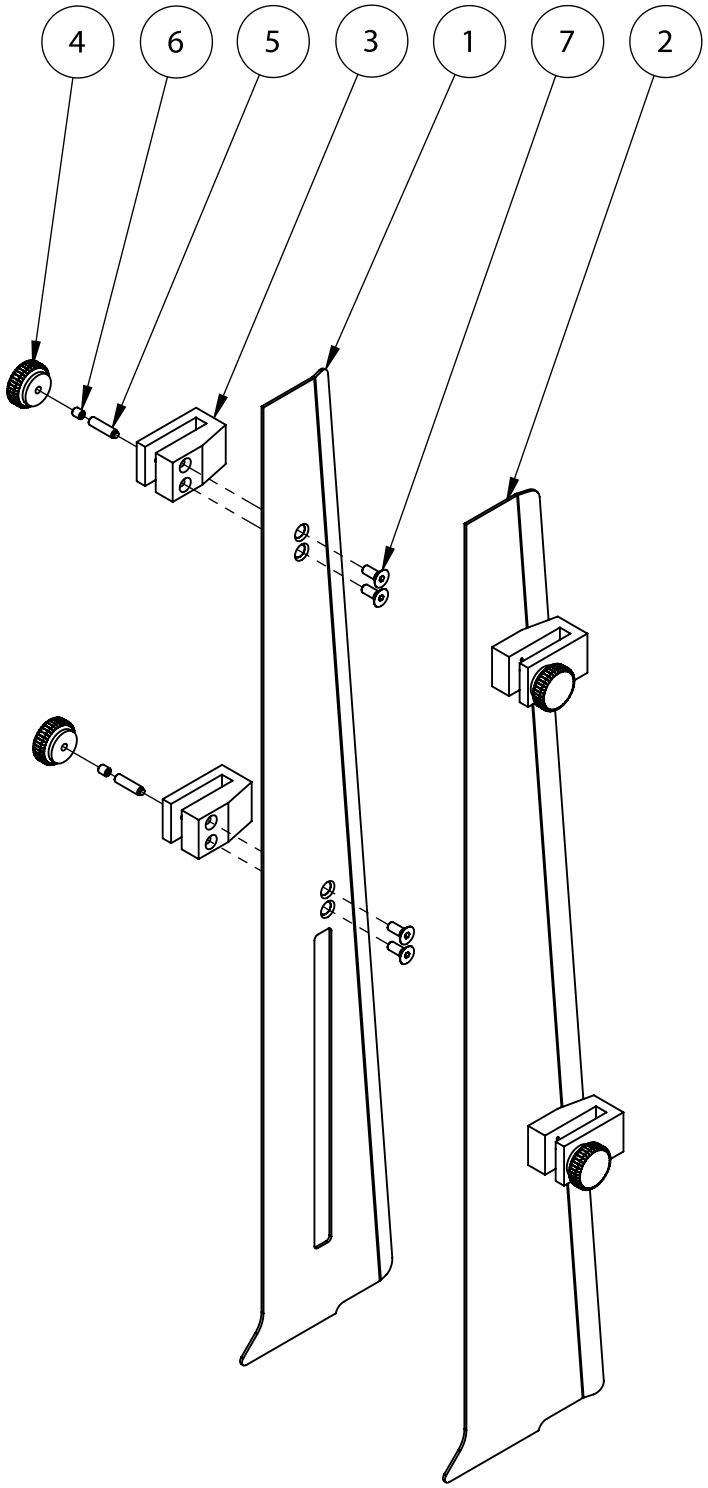


ADJUSTABLE PRE-GATE KIT
Assembly # : 63011806

COMING SOON

424 STR SIDE GUIDE NARROWING KIT FOR LOW STACK

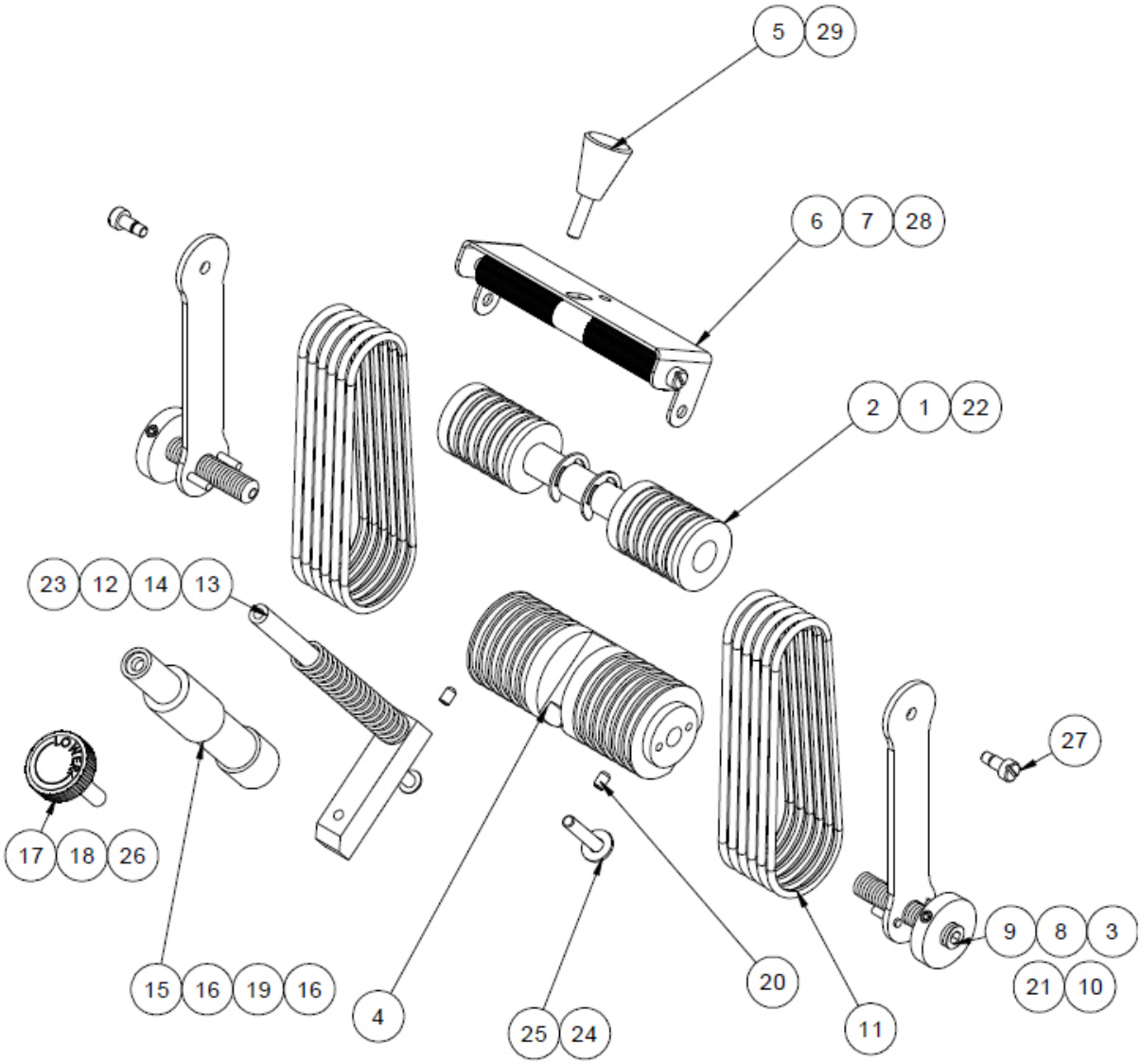
Assembly # : 311-1409



424 STR SIDE GUIDE NARROWING KIT FOR LOW STACK
Assembly # : 311-1409

ITEM	QTY.	PART NUMBER	DESCRIPTION
1	1	904585	SIDE GUIDE NARROW
2	1	904584	SHALLOW LEFT SIDE
3	4	44640024	WIDE MOUNTING BLOCK
4	4	44681021	THUMB KNOB W/10-32 INSERT
5	4	44681020	SSSNYLTIP 10-32 X .75
6	4	102732B03	SSSCPPT BLACK OXIDE 10-32 X .25
7	8	102916B03	FHCS SSTL 10-32 X .50

ADVANCING O-RING GATE STR (SDO)
Assembly # : 90911003



ADVANCING O-RING GATE STR (SDO)
Assembly # : 90911003

ITEM	QTY.	PART NUMBER	DESCRIPTION
1	1	44657008	BELT INDEXER SHAFT
2	2	44657002	O-RING TAKE UP ROLLER
3	2	44872002	PLATE SIDE ADJUSTOR
4	1	44872004	CYLINDER, GATE
5	1	44657007	HANDLE STUDDED
6	1	44657005	BELT INDEXER BRACKET
7	1	44657003	PINCH ROLL CAM
8	2	44872003	ROLLER
9	2	44872005	SCREW ADJUSTMENT
10	2	44872007	SSSNYLTIP10-32 X 3/8
11	12	44657006	O-RING ADV ST
12	1	44909004	GATE LIFT SHAFT MOUNT
13	1	23560084	GATE LIFT SHAFT
14	1	23500083	GATE COMPRESSION SPRING
15	1	23500019	CATE SPRING
16	1	23500037	ADJ KNOB SLEEVE
17	1	23500077	1” THUMB SCREW
18	1	23500084	GATE ADJUSTMENT
19	1	23500240	O RING, GATE SLEEVE
20	2	102729B03	SSSCPPT 8-32NC X .24
21	4	103229B07	ROLL PIN .125 X .50LG
22	2	104308B02	E CLIP, 1/2
23	1	102708B03	BHCS #10-32 X 1/2
24	1	102708B07	BHCS 10-32 X 1.00
25	1	103240B04	FW #10
26	1	102939B07	SHCS 1/4-28 X 1.00
27	2	600651A02	.19 X .25 SCREW, SHOULDER SLOTTED
28	2	600651A01	.19 X .13 SCREW, SHOULDER SLOTTED
29	1	102732B11	SSSCPPT #10-32 X 1.00

ADVANCING O-RING GATE STR (HDO)
Assembly # : 90911004

COMING SOON

ADVANCING O-RING GATE STR (HDO)
Assembly # : 90911004

COMING SOON

STANDARD O-RING GATE STR (SDO)
Assembly # : 90911005

COMING SOON

STANDARD O-RING GATE STR (SDO)
Assembly # : 90911005

COMING SOON

STANDARD O-RING GATE STR (HDO)
Assembly # : 90911006

COMING SOON

STANDARD O-RING GATE STR (HDO)
Assembly # : 90911006

COMING SOON

BAR GATE STR
Assembly # : 90911001

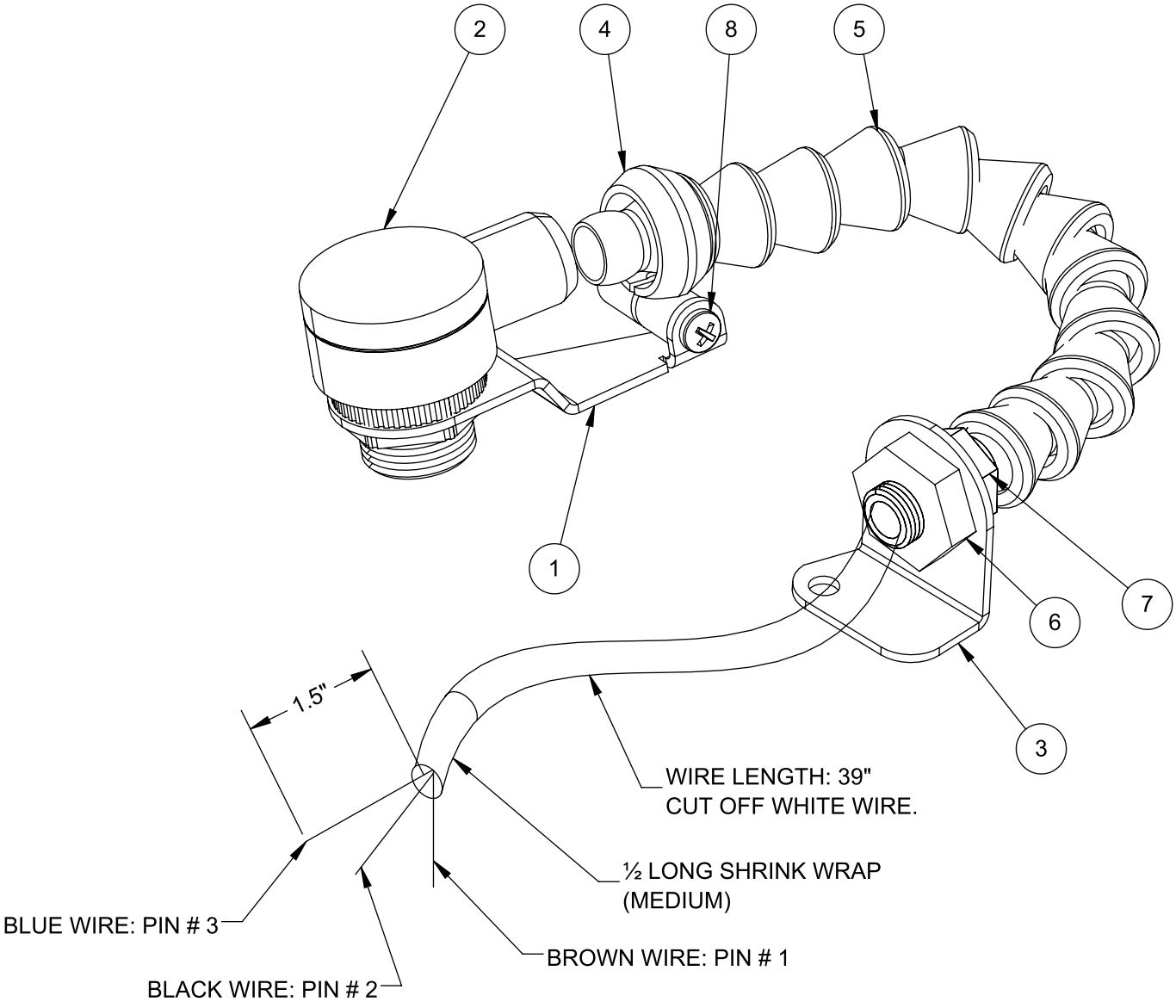
COMING SOON

BAR GATE STR
Assembly # : 90911001

COMING SOON

PNP DIFFUSE REFLECTIVE SHEET SENSOR ASSEMBLY (12”)

Assembly # : 13301101

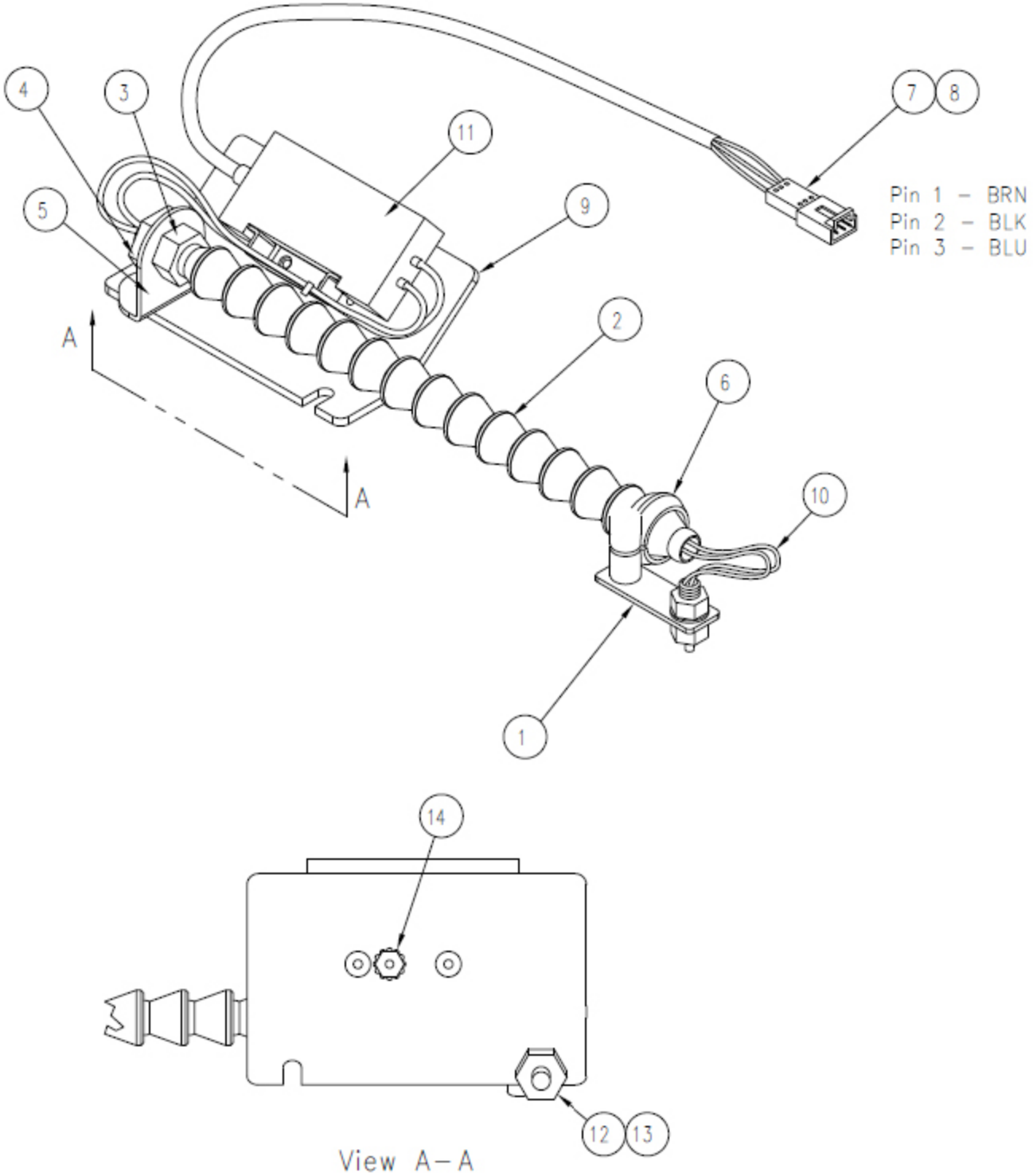


PNP DIFFUSE REFLECTIVE SHEET SENSOR ASSEMBLY (12”)
Assembly # : 13301101

ITEM	QTY.	PART NUMBER	DESCRIPTION
1	1	44640014	BRACKET, SENSOR STABILIZER
2	1	44649011	SENSOR, PNP DIFFUS
3	1	44640015	MOUNTING BRACKET
4	1	44640016	COLLAR, LOCLINE 1/4 MOUNTING
5	12	44608041	LOCLINE ADJUSTABLE 1/4
6	1	44608046	NUT, HEX 1/8 NPT
7	1	44608042	LOCKLINE NPT CONNECTOR 1/4 X 1/8
8	1	102760B09	PHMSPH #6-32 X .75
9	1	44649012	HOUSING, CONNECTOR 3 PIN
10	1	44649013	PIN, MALE CONNECTOR MOLEX

PNP FIBER OPTIC SHEET SENSOR ASSEMBLY (12”)

Assembly # : 63011082

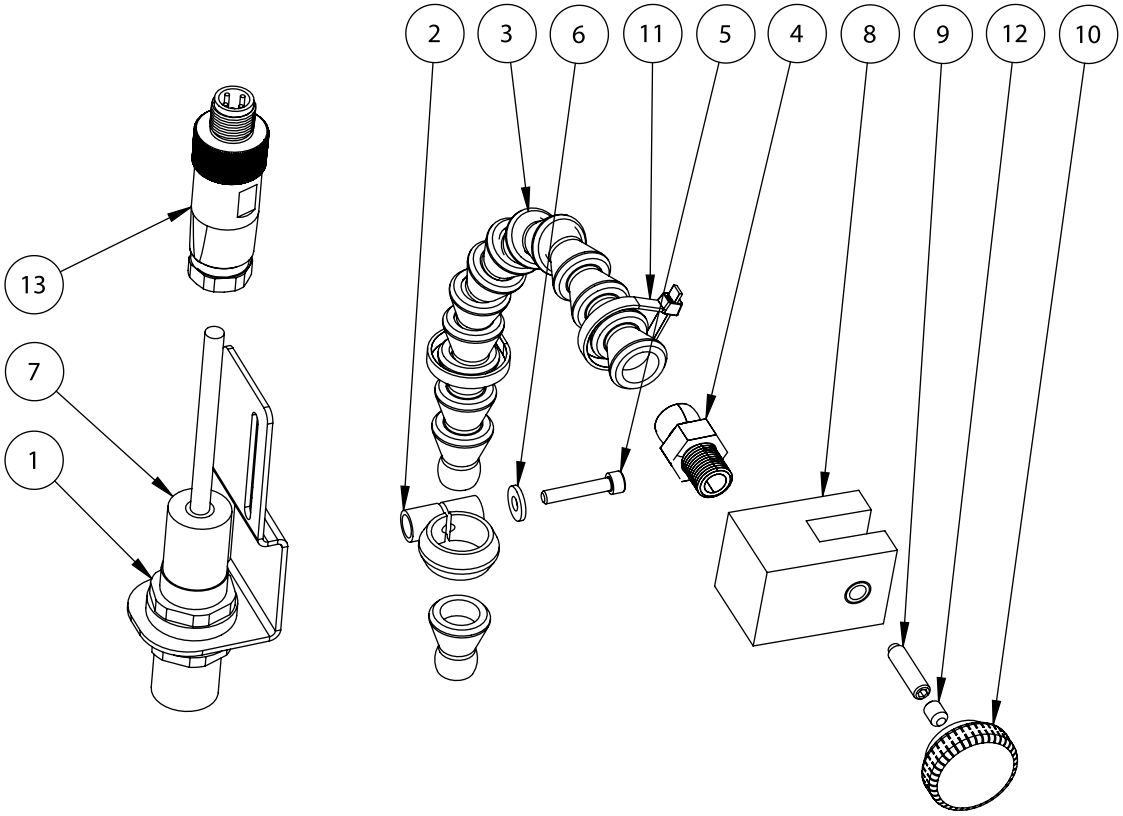


PNP FIBER OPTIC SHEET SENSOR ASSEMBLY (12”)
Assembly # : 63011082

ITEM	QTY.	PART NUMBER	DESCRIPTION
1	1	44450030	CLAMP MATERIAL SUPPORT
2	16	44608041	HOSE ADJ 1/4
3	1	44608042	LOCLINE NPT CONNECTOR
4	1	44608046	NUT HEX 1/8 NPT
5	1	44640015	SENSOR MOUNTING BRACKET
6	1	44640016	COLLAR, LOCLINE 1/4 MOUNT
7	1	44649012	CONNECTOR 3 PIN
8	3	44649013	CONNECTOR PIN
9	1	44723002	BRACKET SENSOR AMP
10	1	53500034	CABLE FIBER OPTIC
11	1	53500082	AMPLIFIER LONG DISTANCE
12	1	00002307	BHCS #10-32 X 5/16 LONG
13	1	00002106	NUT #10-32
14	1	00002120	KEPS NUT #6-32

PNP DIFFUSE REFLECTIVE TRIGGER SENSOR ASSEMBLY

Assembly # : 611-0393



PNP DIFFUSE REFLECTIVE TRIGGER SENSOR ASSEMBLY
Assembly # : 611-0393

ITEM	QTY.	PART NUMBER	DESCRIPTION
1	1	44846052	BRACKET SENSOR MOUNT
2	1	44640016	COLLAR, LOCLINE 1/4 MOUNTING
3	14	44608041	LOCLINE ADJUSTABLE 1/4
4	1	44608042	LOCKLINE NPT CONNECTOR 1/4 X 1/8
5	1	102683B05	SHCS BLACK OXIDE 6-32 X .75
6	1	103240B02	FLAT WASHER ZINC STEEL #6
7	1	53500038	SENSOR, EZ BEAM 50MM DIFFUSE REFLECTIVE
8	1	44699007	BLOCK BRUSH MOUNTING
9	1	44681020	SSSNYLTIP 10-32 X .75
10	1	44681021	THUMB KNOB W/10-32 INSERT
11	2	903121	TIE, CABLE BLACK UL 4IN
12	1	102732B03	SSSCPPT BLACK OXIDE 10-32 X .25
13	1	903387	CONNECTOR, FIELD WIREABLE, 4 PIN MALE

PNP RETROREFLECTIVE TRIGGER SENSOR ASSEMBLY
Assembly # : 611-0490

COMING SOON

PNP RETROREFLECTIVE TRIGGER SENSOR ASSEMBLY
Assembly # : 611-0490

COMING SOON

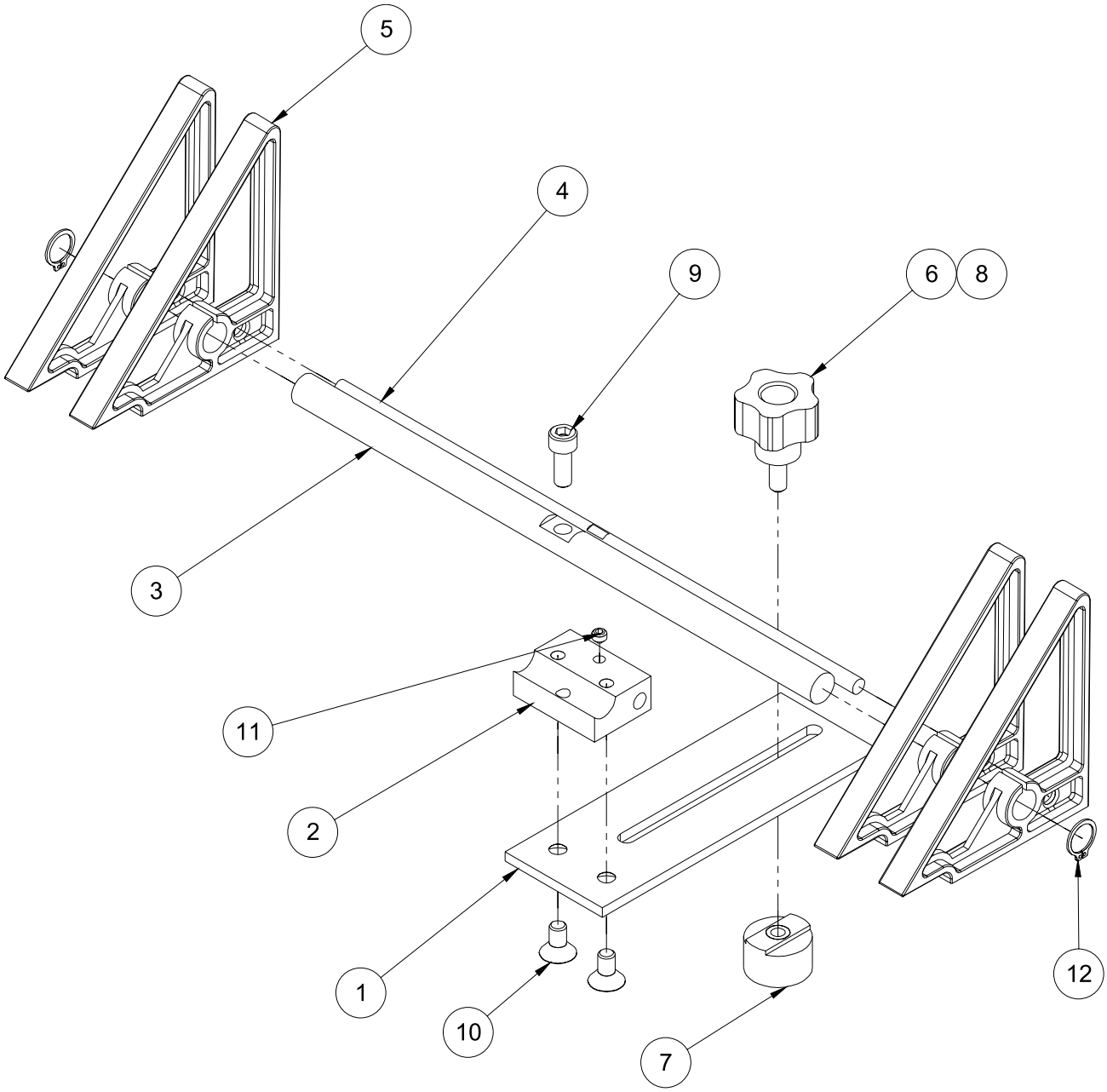
SENSORLESS TRIGGER CABLE ASSEMBLY
Assembly # : 611-0489

COMING SOON

SENSORLESS TRIGGER CABLE ASSEMBLY
Assembly # : 611-0489

COMING SOON

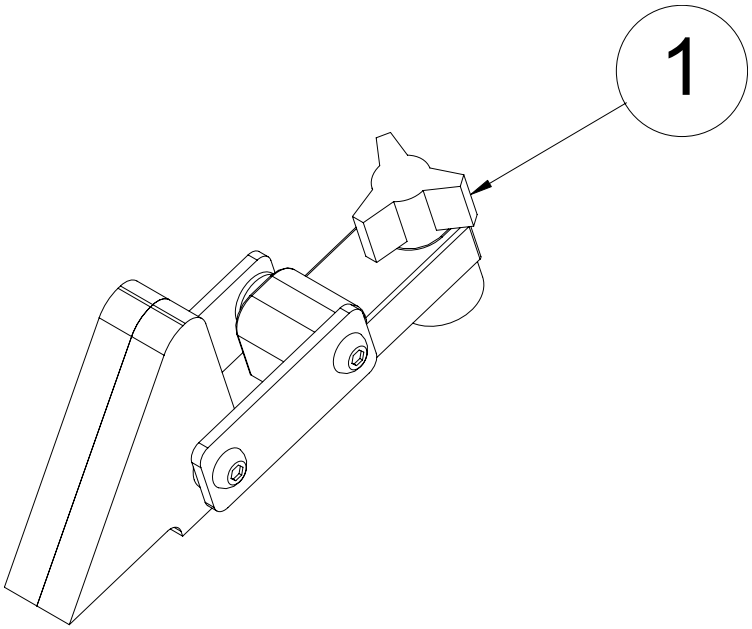
TRIANGLE 8” WEDGE
Assembly # : 17451105



TRIANGLE 8” WEDGE
Assembly # : 17451105

ITEM	QTY.	PART NUMBER	DESCRIPTION
0001	1	51745008	PLATE, WEDGE BASE
0002	1	51745062	BLOCK, WEDGE
0003	1	44633018	SHAFT, WEDGE GUIDE
0004	1	44759076	SHAFT, WEDGE SUPPORT
0005	4	43560212	WEDGE, MATERIAL SUPPORT
0006	1	44963102	KNOB, 5 LOBE
0007	1	44633016	T-NUT, ROUND

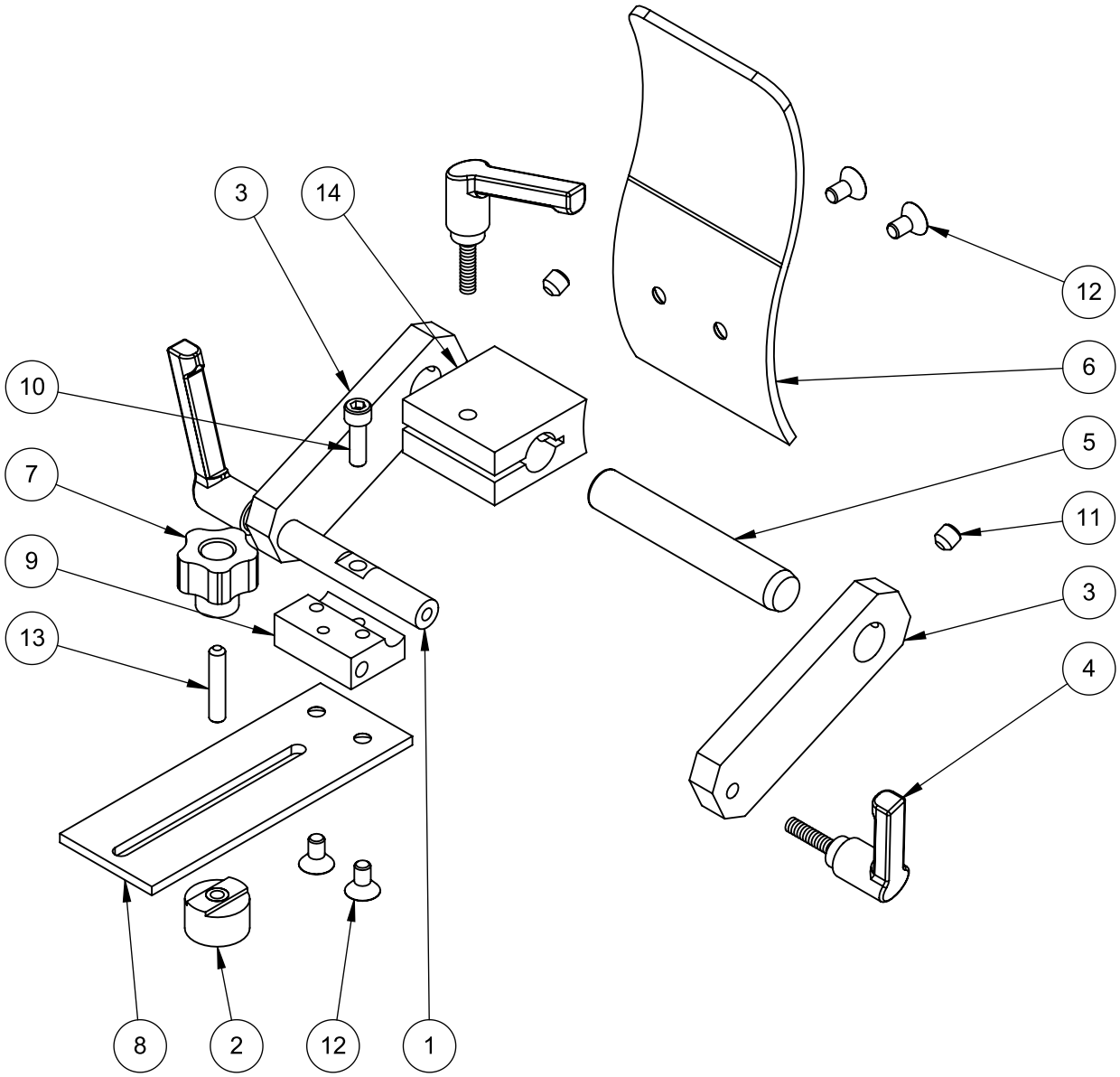
NARROW EXTENDED WEDGE
Assembly # : 63311212



NARROW EXTENDED WEDGE
Assembly # : 63311212

COMING SOON

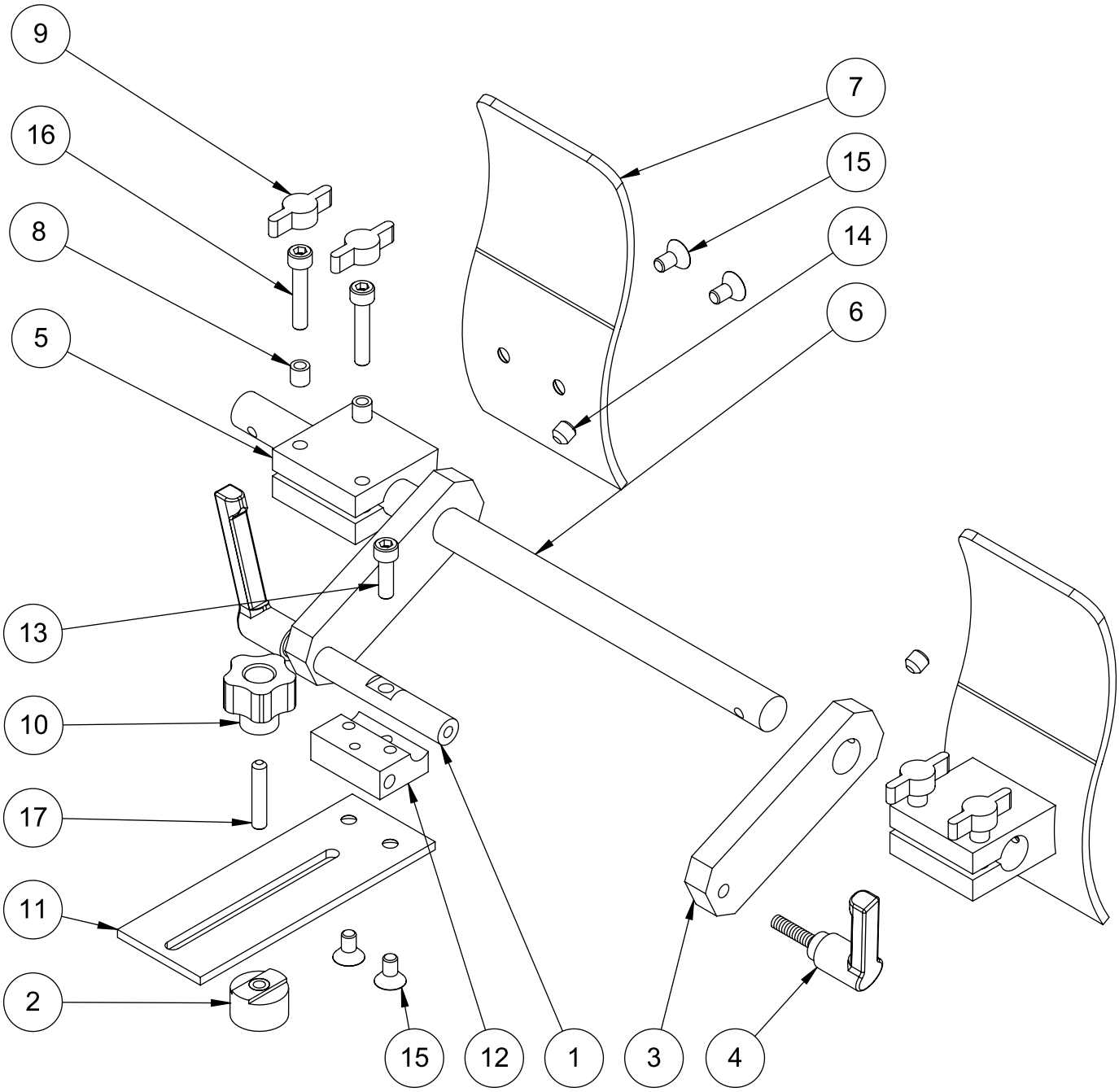
SINGLE S WEDGE
Assembly # : 311-1523



SINGLE S WEDGE
Assembly # : 311-1523

ITEM	QTY.	PART NUMBER	DESCRIPTION
1	1	44633010	ROLLER WEDGE SHAFT
2	1	44633016	ROUND T-NUT
3	2	44633024	ROLLER WEDGE
4	3	43555098	RATCHET HANDLE 10-32 X .75
5	1	110110B07	DOWEL PIN 1/2 X 3.00 SSTL
6	1	44633025	S WEDGE
7	1	44963102	KNOB, 5 LOBE WITH 10-32 THREADED INSERT
8	1	51745008	PLATE, WEDGE BASE
9	1	51745062	BLOCK, WEDGE
10	1	102688B04	SHCS BLACK OXIDE 10-32 X .63
11	2	102733B03	SSSCPPT BLACK OXIDE ¼-20 X .25
12	4	102637B02	FHCS BLACK OXIDE 10-32 X .38
13	1	102732B11	SSSCPPT BLACK OXIDE 10-32 X 1.00
14	1	51632110	S-WEDGE MOUNT BLOCK

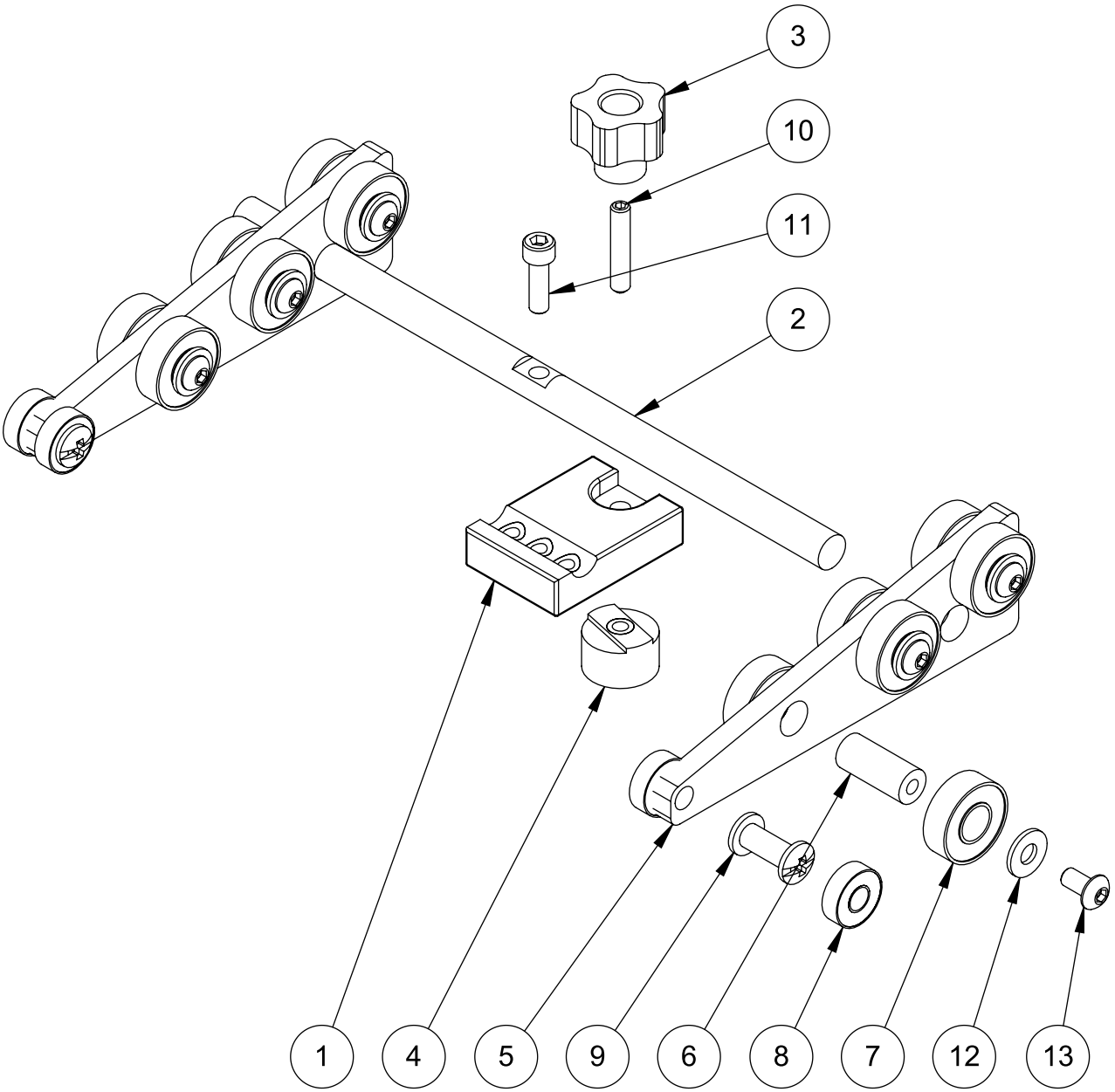
DOUBLE S - 8” WEDGE
Assembly # : 311-1468



DOUBLE S - 8” WEDGE
Assembly # : 311-1468

ITEM	QTY.	PART NUMBER	DESCRIPTION
1	1	44633010	ROLLER WEDGE SHAFT
2	1	44633016	ROUND T-NUT
3	2	44633024	ROLLER WEDGE
4	2	43555098	RATCHET HANDLE 10-32 X .75
5	2	44633026	BLOCK MOUNTING
6	1	23560147	SHAFT, IDLER
7	2	44633025	S WEDGE
8	4	903818	THREADED ROUND STANDOFF 10-32 X 1/4 LG.
9	4	23500076	WING KNOB
10	1	44963102	KNOB, 5 LOBE WITH 10-32 THREADED INSERT
11	1	51745008	PLATE, WEDGE BASE
12	1	51745062	BLOCK, WEDGE
13	1	102688B04	SHCS BLACK OXIDE 10-32 X .63
14	2	102733B03	SSSCPPT BLACK OXIDE ¼-20 X .25
15	6	102637B02	FHCS BLACK OXIDE 10-32 X .38
16	4	102688B07	SHCS BLACK OXIDE 10-32 X 1.00
17	1	102732B11	SSSCPPT BLACK OXIDE 10-32 X 1.00

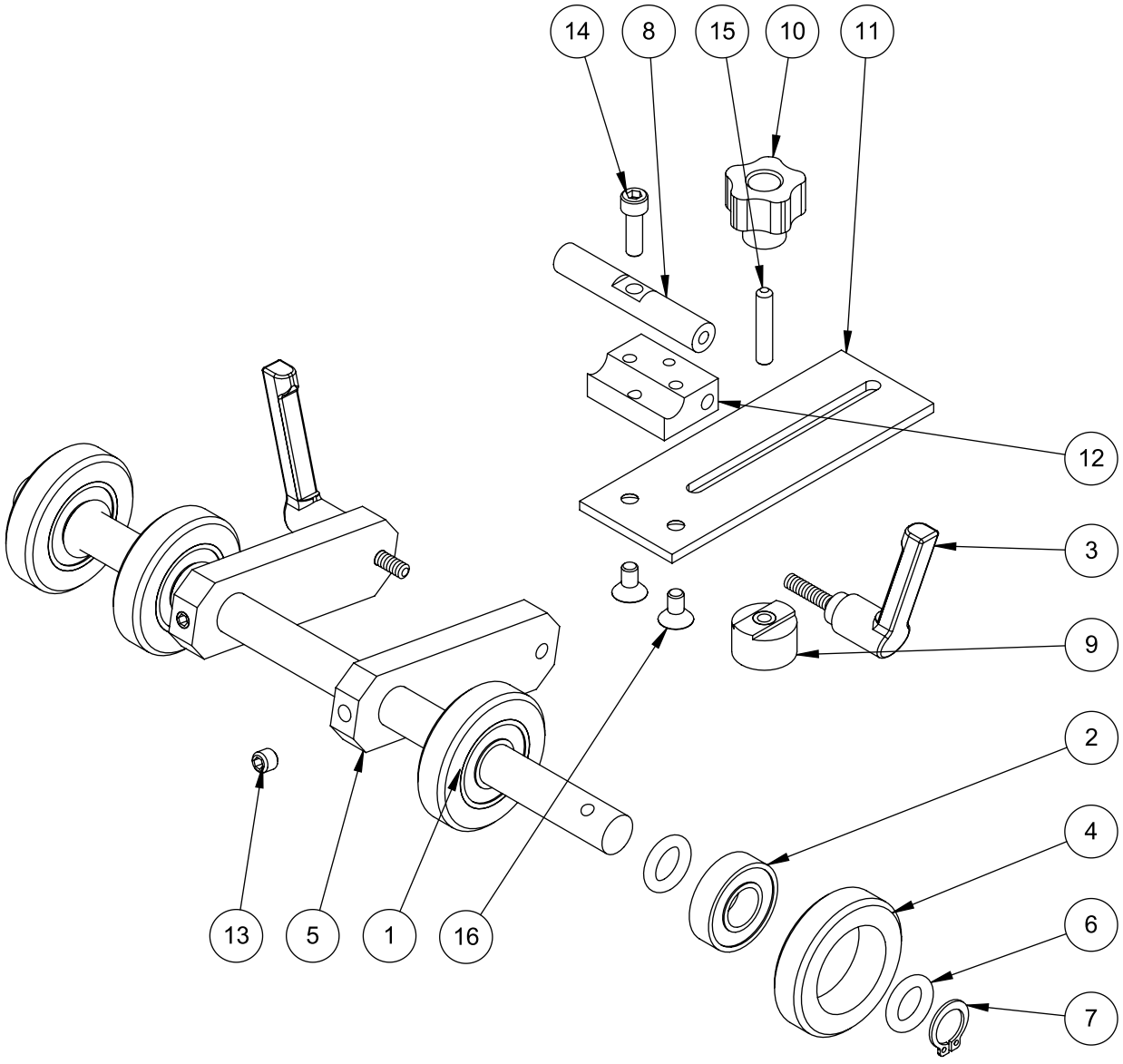
LOW PROFILE WITH R4 SUPPORT 8” WEDGE
Assembly # : 311-1242



LOW PROFILE WITH R4 SUPPORT 8” WEDGE
Assembly # : 311-1242

ITEM	QTY.	PART NUMBER	DESCRIPTION
1	1	44633014	WEDGE BLOCK
2	1	44633018	WEDGE GUIDE SHAFT
3	1	44963102	KNOB, 5 LOBE WITH 10-32 THREADED INSERT
4	1	44633016	ROUND T-NUT
5	2	904022	LOW PROFILE LONG WEDGE
6	6	33500020	BELT TENSION
7	12	23500095	BEARING BALL R6 .375 BORE
8	4	44582021	BEARING, BALL R4 .25 BORE
9	2	904023	BINDING POST 1/4 OD X 5/8 LG
10	1	102732B11	SSSCPPT BLACK OXIDE 10-32 X 1.00
11	1	102937B04	SHCSS SST 10-32 X .62
12	12	103240B04	FLAT WASHER ZINC STEEL #10
13	12	102957B02	BHCS SST 10-32 X .38

ARTICULATING ROLLER 9” WEDGE
Assembly # : 311-1524

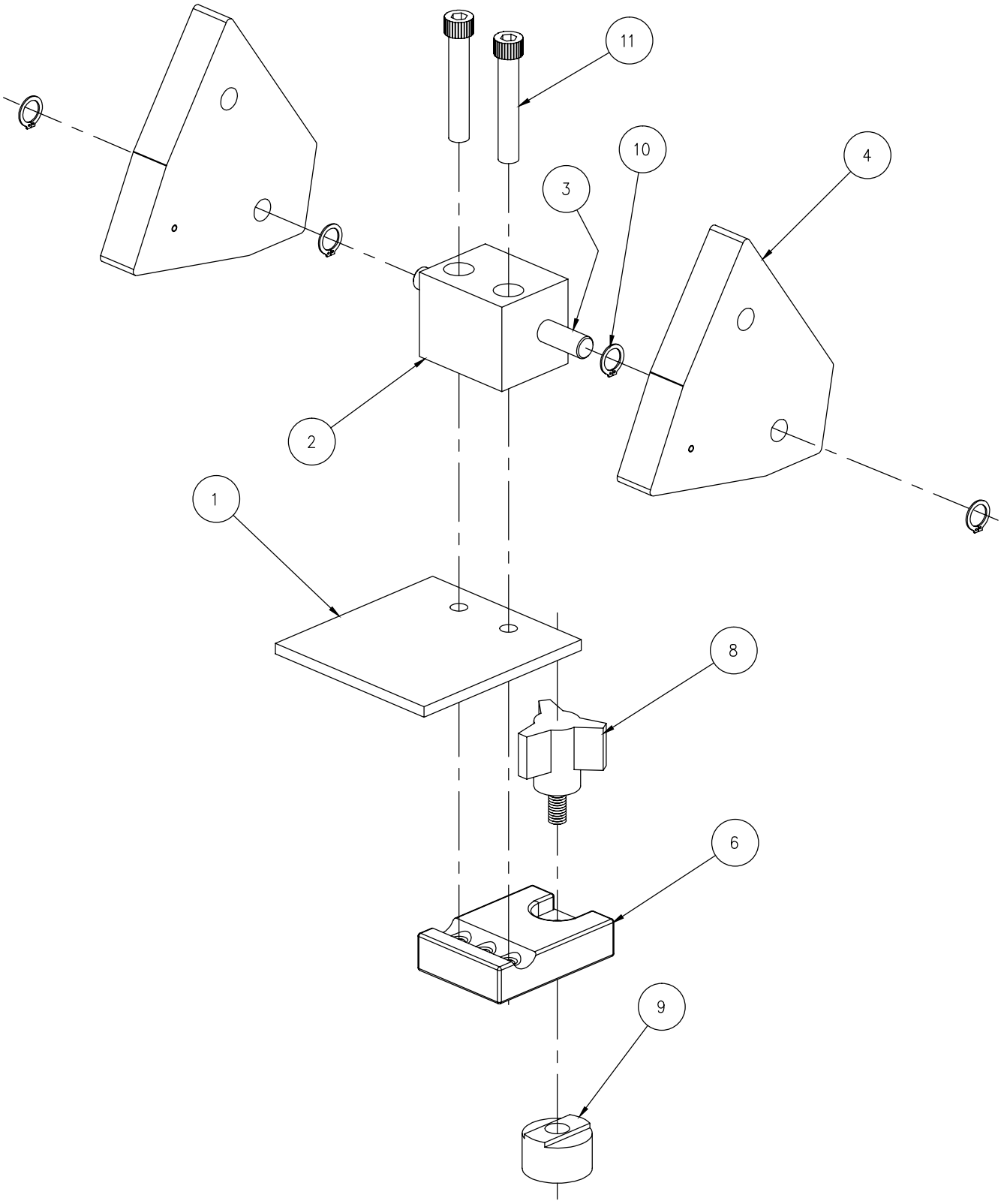


ARTICULATING ROLLER 9” WEDGE
Assembly # : 311-1524

ITEM	QTY.	PART NUMBER	DESCRIPTION
1	1	23560147	SHAFT, IDLER
2	4	23500094	BEARING BALL R8 .500 BORE
3	2	43555098	RATCHET HANDLE 10-32 X .75
4	4	44340012	ROLLER WEDGE WHEEL
5	2	44633024	ROLLER WEDGE
6	8	44340017	O-RING 7/16
7	2	103274B05	SNAP RING EXTERNAL STEEL .50
8	1	44633010	ROLLER WEDGE SHAFT
9	1	44633016	ROUND T-NUT
10	1	44963102	KNOB, 5 LOBE WITH 10-32 THREADED INSERT
11	1	51745008	PLATE, WEDGE BASE
12	1	51745062	BLOCK, WEDGE
13	2	102733B03	SSSCPPT BLACK OXIDE ¼-20 X .25
14	1	102688B04	SHCS BLACK OXIDE 10-32 X .63
15	1	102732B11	SSSCPPT BLACK OXIDE 10-32 X 1.00
16	2	102637B02	FHCS BLACK OXIDE 10-32 X .38

LOAD COMPENSATING 3” WEDGE

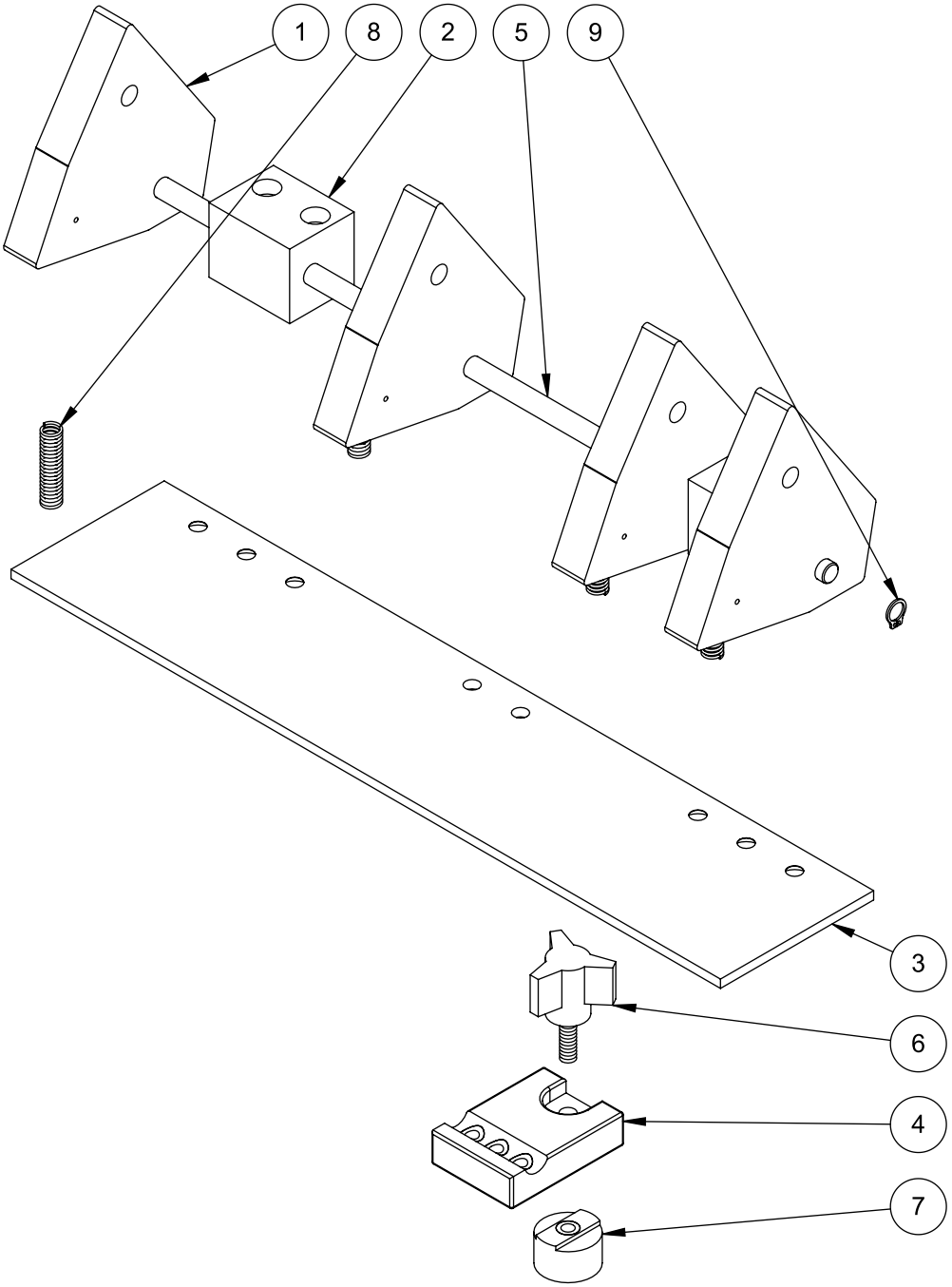
Assembly # : 63311130



LOAD COMPENSATING 3” WEDGE
Assembly # : 63311130

COMING SOON

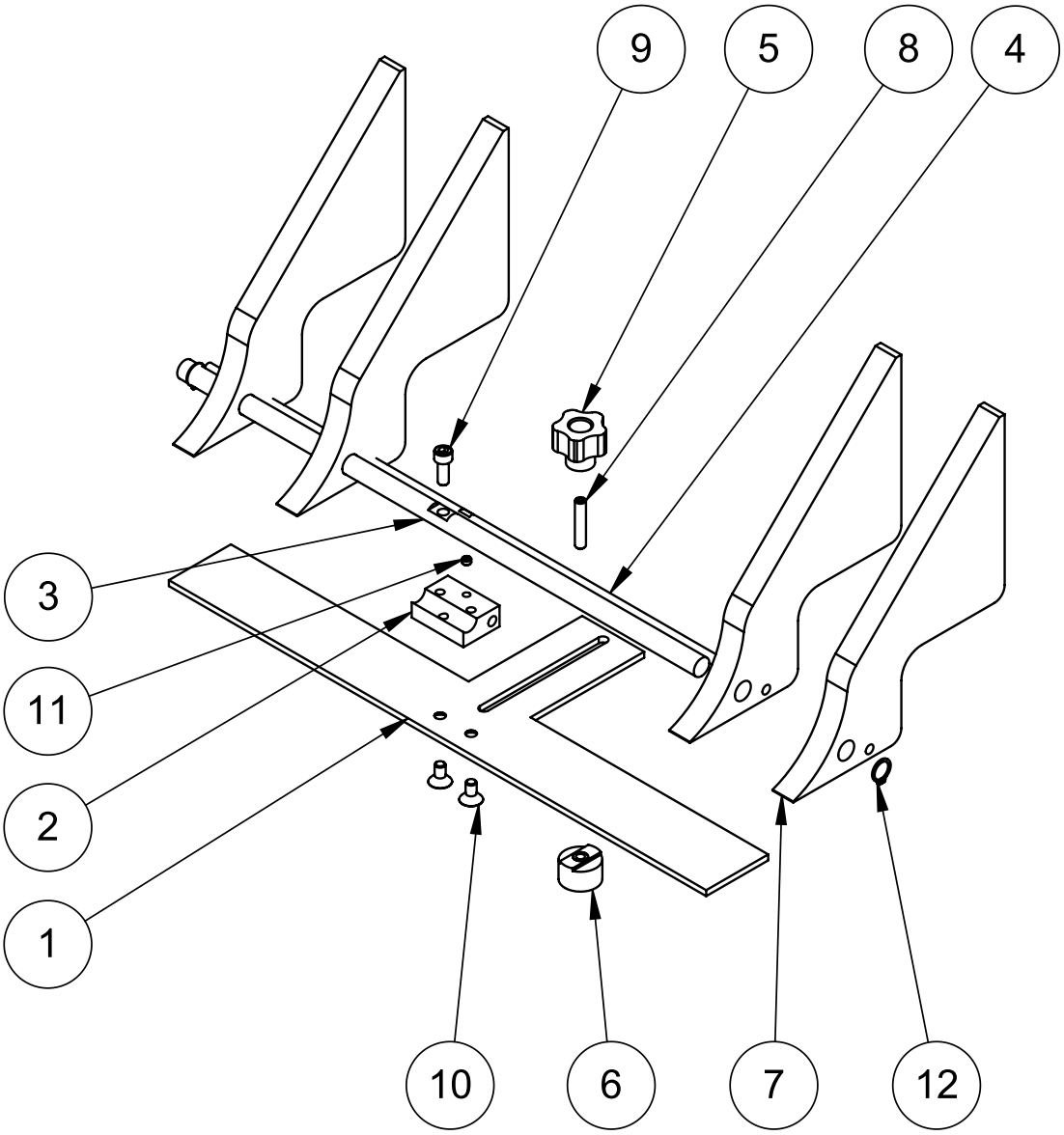
LOAD COMPENSATING 11” WEDGE
Assembly # : 311-1109



LOAD COMPENSATING 11” WEDGE
Assembly # : 311-1109

ITEM	QTY.	PART NUMBER	DESCRIPTION
1	4	23500130	WEDGE
2	2	44633012	WEDGE, SUPPRT BLOCK
3	1	903504	WEDGE, BASE COMPENSATING
4	1	44633014	WEDGE BLOCK
5	1	903505	SHAFT, RND .250 X 11.00
6	1	44633033	KNOB, 3 ARM
7	1	44633016	ROUND T-NUT
8	4	23500134	SPRING, CMPRS 1/4 X 1
9	4	103274B02	SNAP RING EXTERNAL STEEL .25

2-TIER TRIANGLE WEDGE
Assembly # : 311-1474



2-TIER TRIANGLE WEDGE
Assembly # : 311-1474

ITEM	QTY.	PART NUMBER	DESCRIPTION
1	1	904905	PLATE T WEDGE BASE
2	1	51745062	BLOCK, WEDGE
3	1	51631084	SHAFT, WEDGE GUIDE
4	1	51631097	SHAFT, WEDGE SUPPORT
5	1	44963102	KNOB, 5 LOBE WITH 10-32 THREADED INSERT
6	1	44633016	ROUND T-NUT
7	4	904760	CURVED WEDGE TALL
8	1	102732B11	SSSCPPT BLACK OXIDE 10-32 X 1.00
9	1	102688B03	SHCS BLACK OXIDE 10-32 X .50
10	2	102637B02	FHCS BLACK OXIDE 10-32 X .38
11	1	102729B01	SSSCPPT BLACK OXIDE 8-32 X .12
12	2	103274B04	SNAP RING EXTERNAL STEEL .38

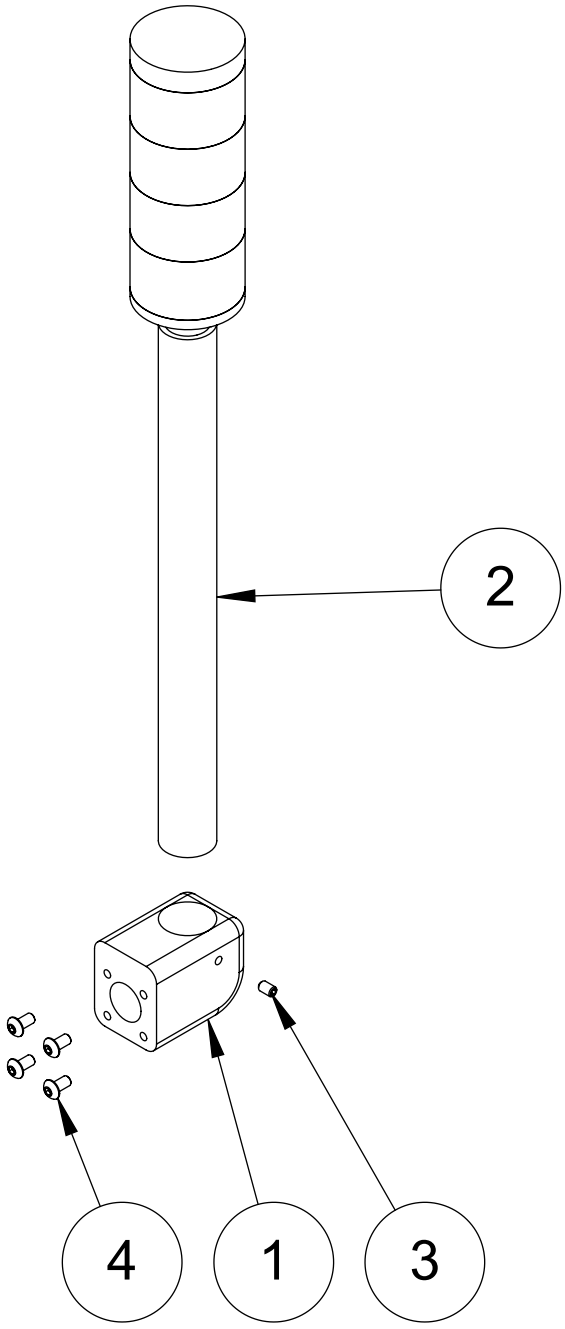
LOW STACK DETECT W/ TOWER LAMP 1250
Assembly # : 311-1535

COMING SOON

LOW STACK DETECT W/ TOWER LAMP 1250
Assembly # : 311-1535

COMING SOON

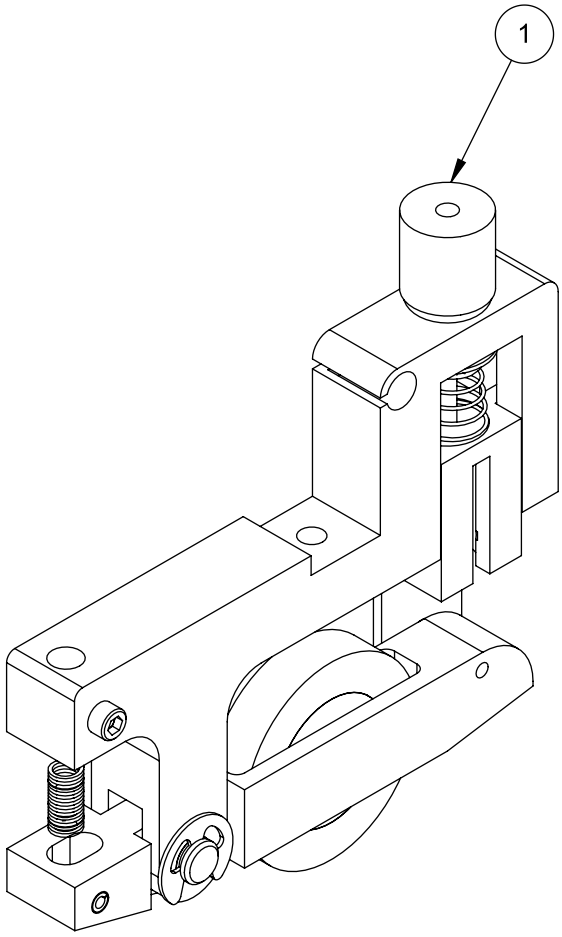
TOWER LAMP 1250
Assembly # : 611-0486



TOWER LAMP 1250
Assembly # : 611-0486

ITEM	QTY.	PART NUMBER	DESCRIPTION
1	1	44649039	BRACKET, TOWER LAMP
2	1	904961	TWR LMP UNASM R/A/G 24VDC LED
3	1	102732B04	SSSCPPT BLACK OXIDE 10-32 X .31
4	4	102708B02	BHCS BLACK OXIDE 10-32 X .38
5	12”	44649108	SHEATHING, WIRE #3 BLACK
6	30”	2007260-030	WIRE 22 GAUGE, WHITE/BLUE
7	30”	53500212	WIRE, HOOKUP 22GA STR. GREEN
8	30”	53500211	WIRE, HOOKUP 22GA STR YELLOW
9	30”	53500112	WIRE 22 GAUGE, RED

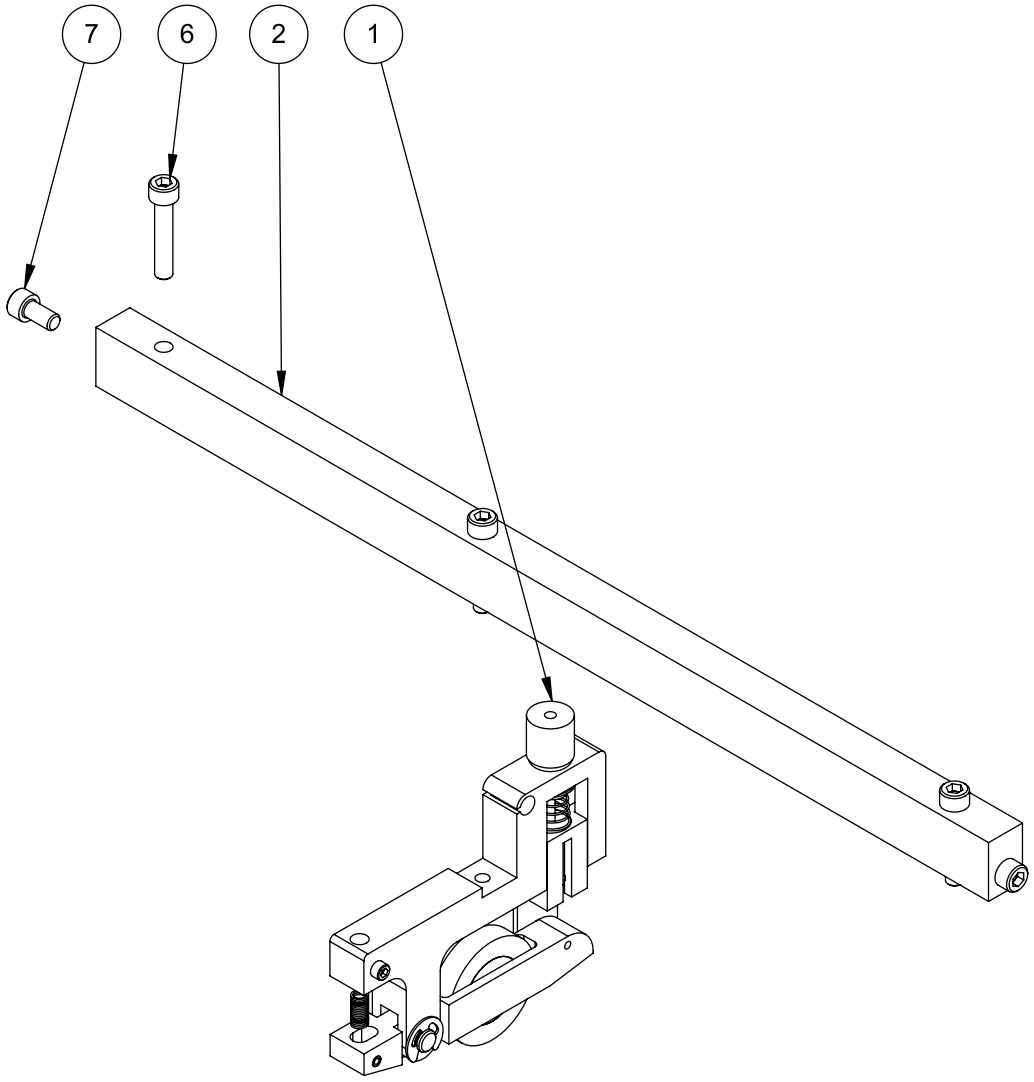
QUICKSET DOUBLE DETECT, SHORT DISCHARGE 1250
Assembly # : 311-1542



QUICKSET DOUBLE DETECT, SHORT DISCHARGE 1250
Assembly # : 311-1542

ITEM	QTY.	PART NUMBER	DESCRIPTION
1	1	14380009	ASSY, QUICKSET DD
2	1	14380005	ASSY, HARNESS QUICKSET DD
3	1	611-0094	ASSY, CBLEXTENQCKST
4	1	900459	MANUAL, QUICKSET DBLDETECT

QUICKSET DOUBLE DETECT, EXTENDED DISCHARGE 1250
Assembly # : 311-1472



QUICKSET DOUBLE DETECT, EXTENDED DISCHARGE 1250
Assembly # : 311-1472

ITEM	QTY.	PART NUMBER	DESCRIPTION
1	1	14380009	ASSY, QUICKSET DD
2	1	51438016	BAR, CROSS EXT DISCHARGE
3	1	14380005	ASSY, HARNESS QUICKSET DD
4	1	611-0094	ASSY, CBLEXTENQCKST
5	1	900459	MANUAL, QUICKSET DBLDETECT
6	3	102688B07	SHCS BLACK OXIDE 10-32 X 1.00
7	2	102937B02	SHCSS SST 10-32 X .38

SPEED FOLLOWING WITH ENCODER
Assembly # : 611-0487

COMING SOON

SPEED FOLLOWING WITH ENCODER
Assembly # : 611-0487

COMING SOON

BAR CODE VERIFICATION
Assembly # : 311-1167

COMING SOON

BAR CODE VERIFICATION
Assembly # : 311-1167

COMING SOON

14” VACUUM TRANSPORT 12” WIDE (WITHOUT PUMP)

Assembly # : TBD

COMING SOON

14” VACUUM TRANSPORT 12” WIDE (WITHOUT PUMP)

Assembly # : TBD

COMING SOON

VERTICAL DISCHARGE 12” WIDE
Assembly # : TBD

COMING SOON

VERTICAL DISCHARGE 12” WIDE
Assembly # : TBD

COMING SOON

PNEUMATIC DROPPER (12”)
Assembly # : TBD

COMING SOON

PNEUMATIC DROPPER (12”)
Assembly # : TBD

COMING SOON

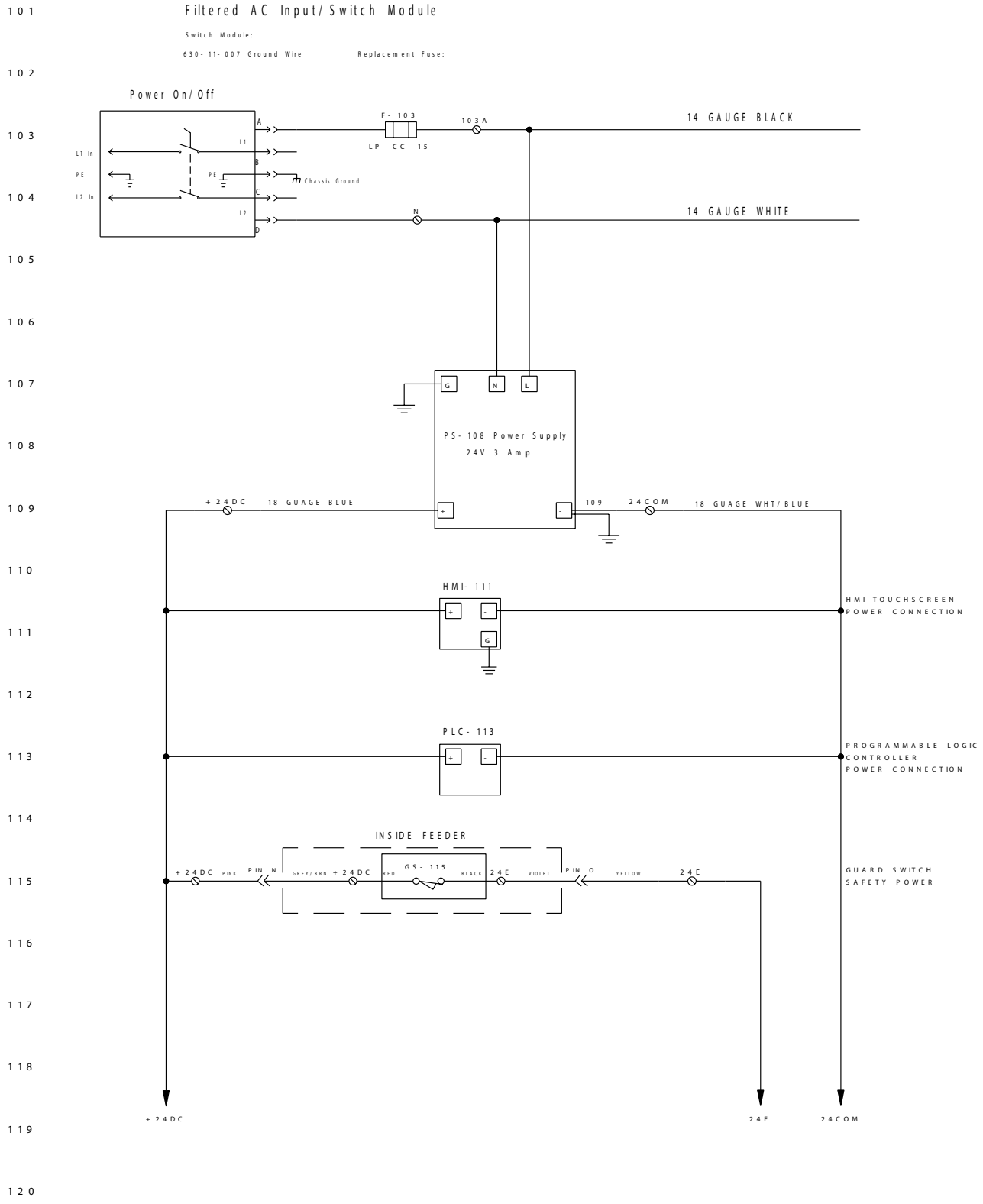
U-CARD FORMER (12”) - SERVO ONLY
Assembly # : TBD

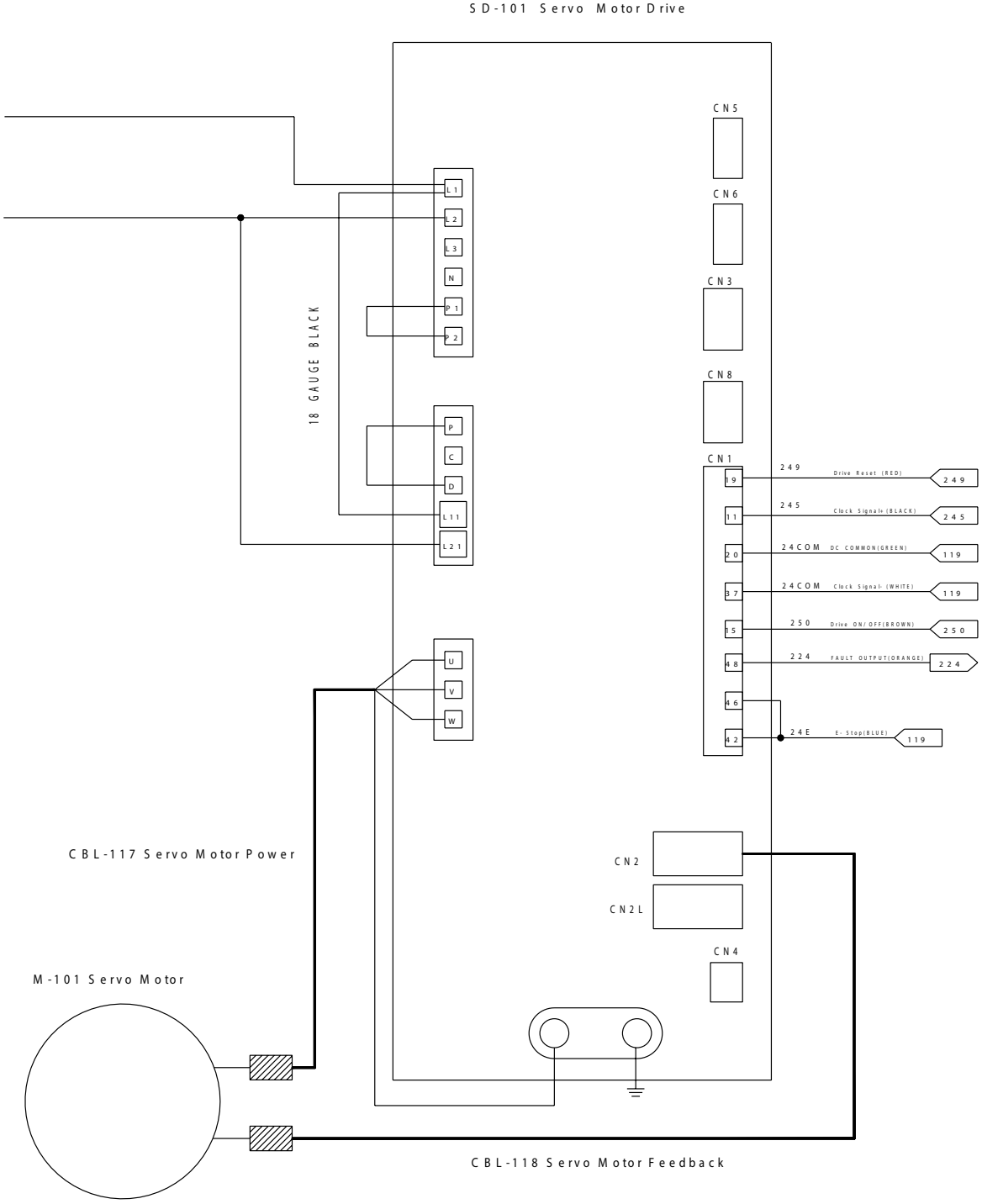
COMING SOON

U-CARD FORMER (12”) - SERVO ONLY
Assembly # : TBD

COMING SOON

8 Electrical Components

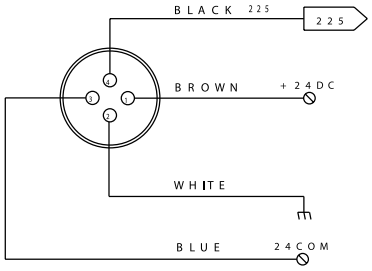



SD-101 Servo Motor Drive
CN5
CN6
CN3
CN8
CN1
CN2
CN2L
CN4
L1
L2
L3
N
P1
P2
P
C
D
L11
L21
U
V
W
18 GAUGE BLACK
249
Drive Reset (RED)
249
245
Clock Signal+ (BLACK)
245
24COM
DC COMMON(GREEN)
119
24COM
Clock Signal- (WHITE)
119
250
Drive ON/OFF(BROWN)
250
224
FAULT OUTPUT(ORANGE)
224
24E
E-Stop(BLUE)
119
19
11
20
37
15
48
46
42
CBL-117 Servo Motor Power
M-101 Servo Motor
CBL-118 Servo Motor Feedback

QD203

Encoder Connector

(Female pins)

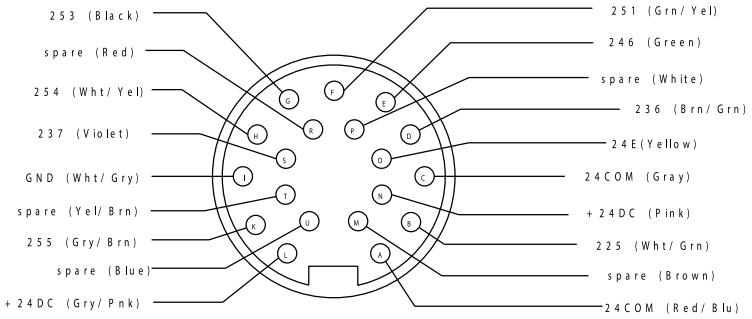


QD210F

Feeder I/O Connector

External View

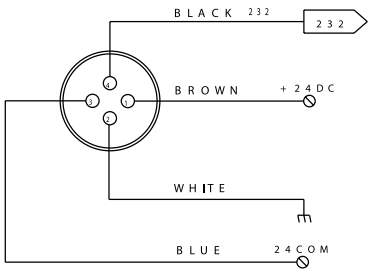
(Female pins)



QD215

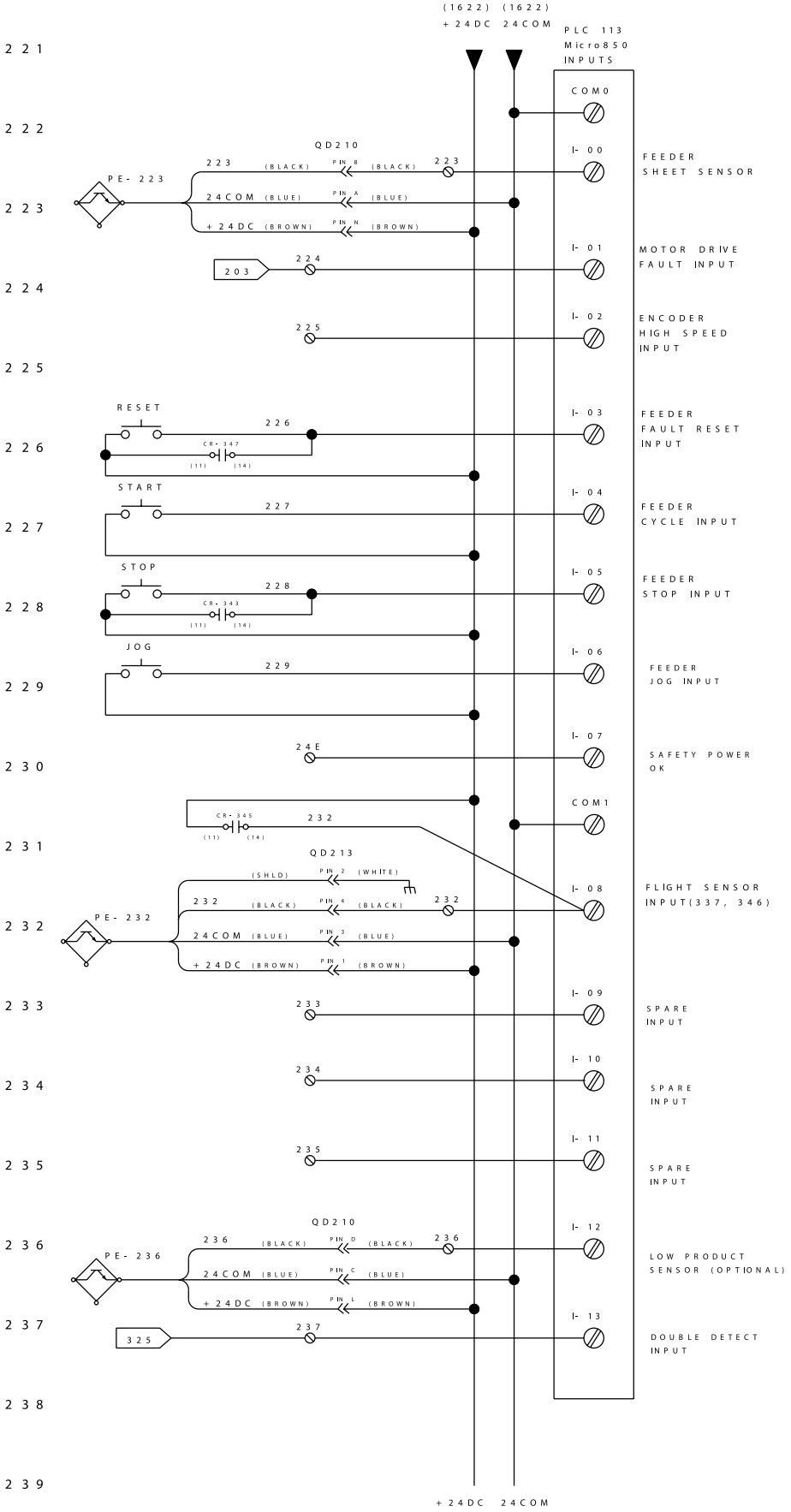
Local Flight Sensor Connector

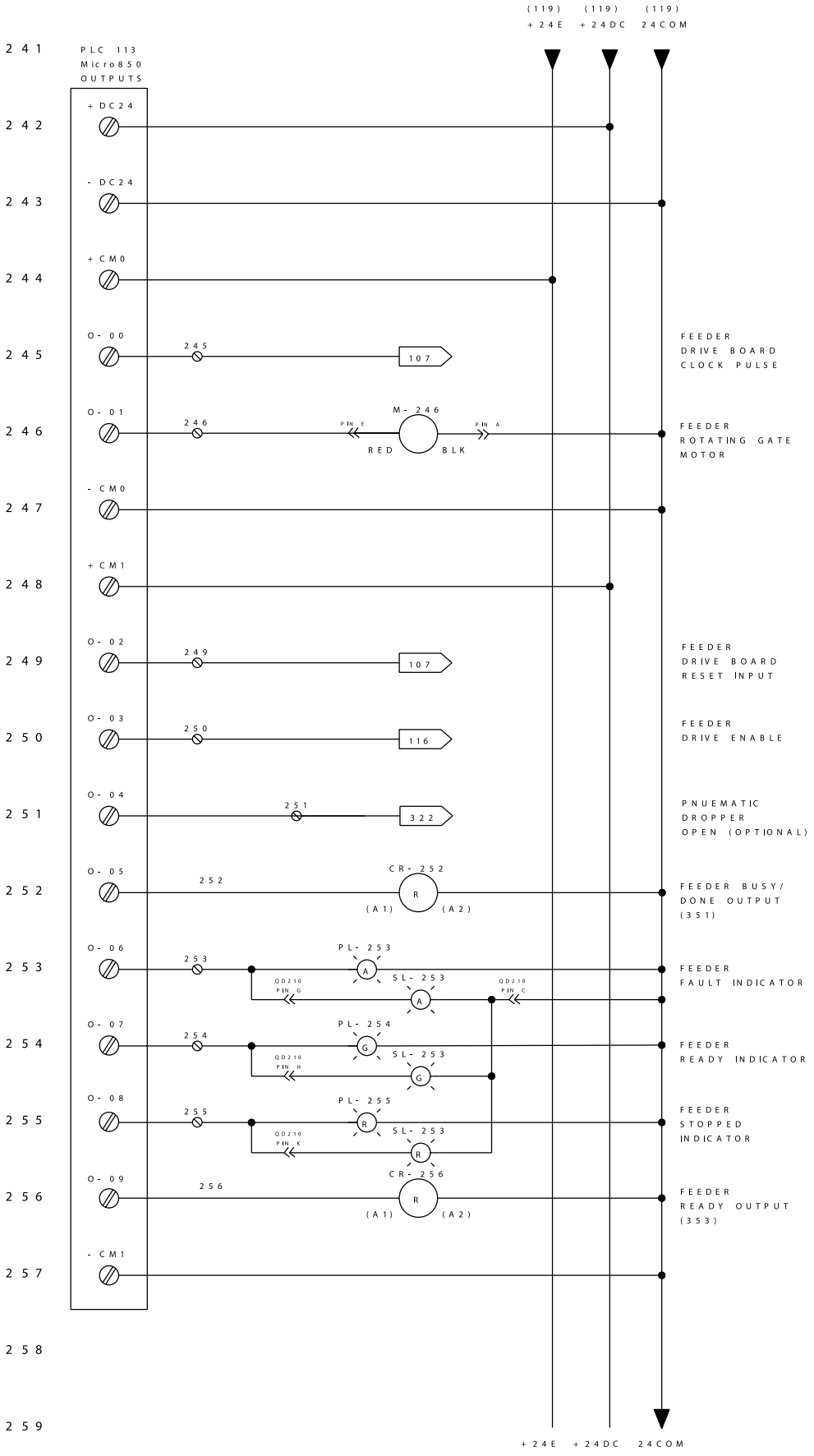
(Female pins)

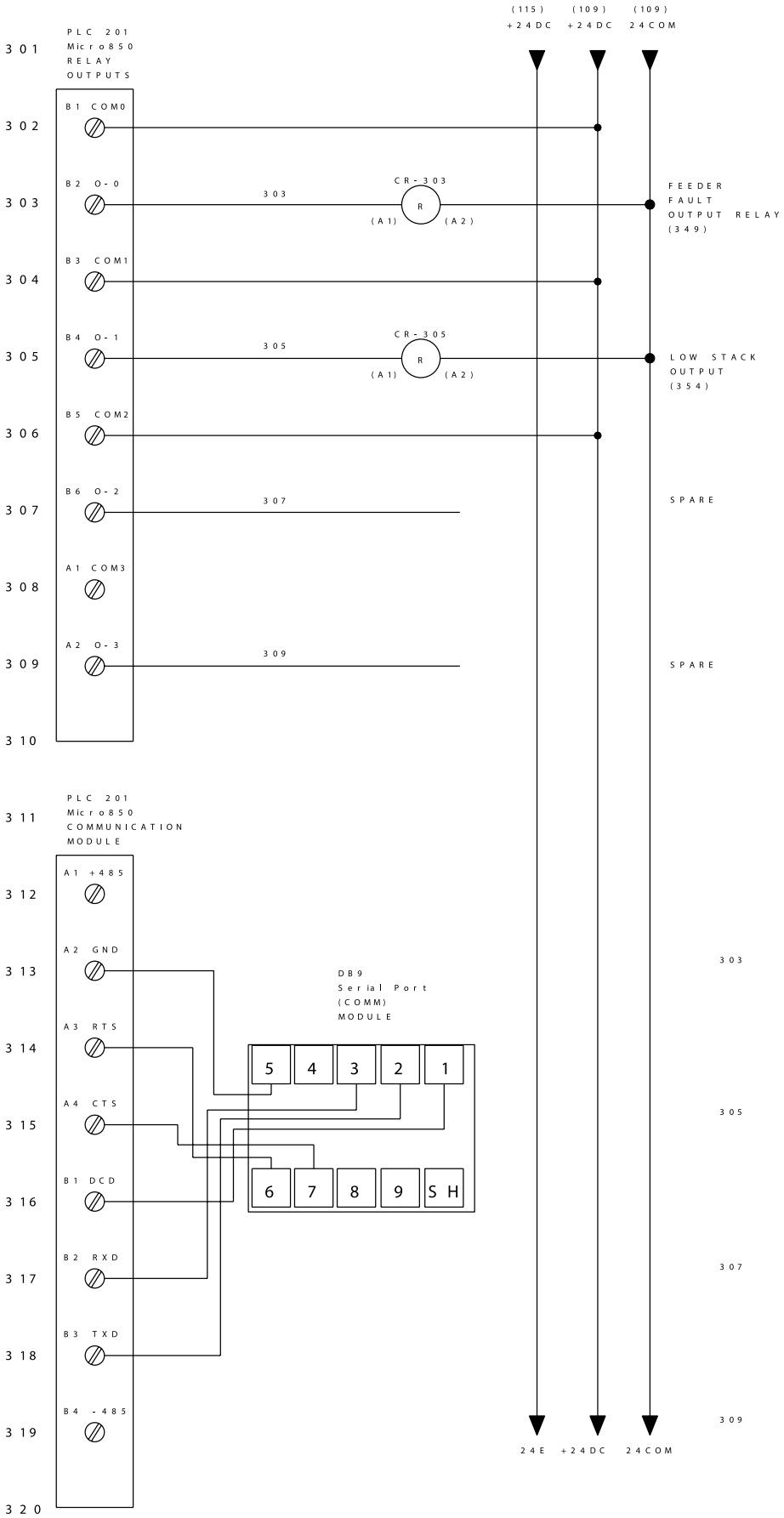


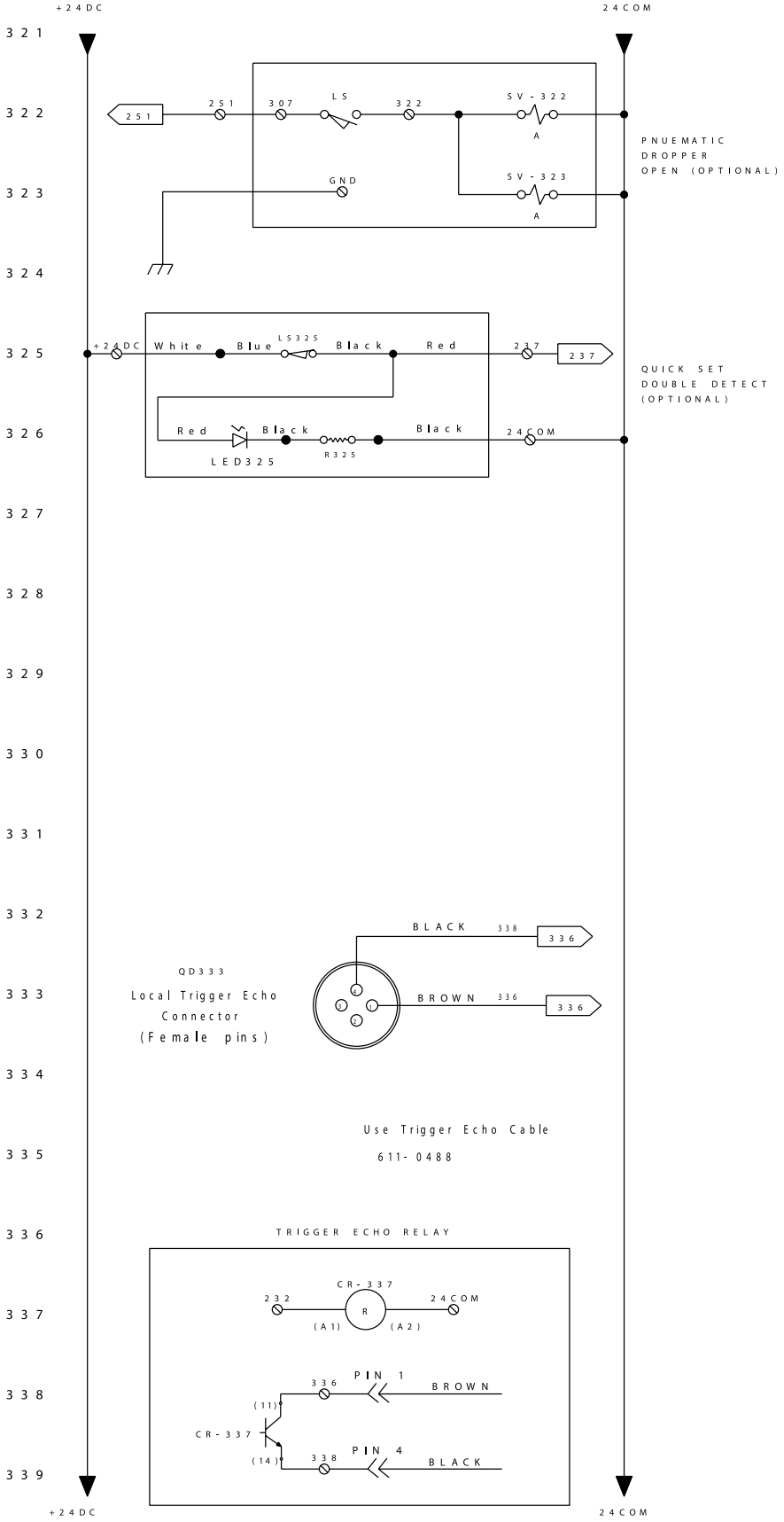
Use Flight Sensor

611-0393

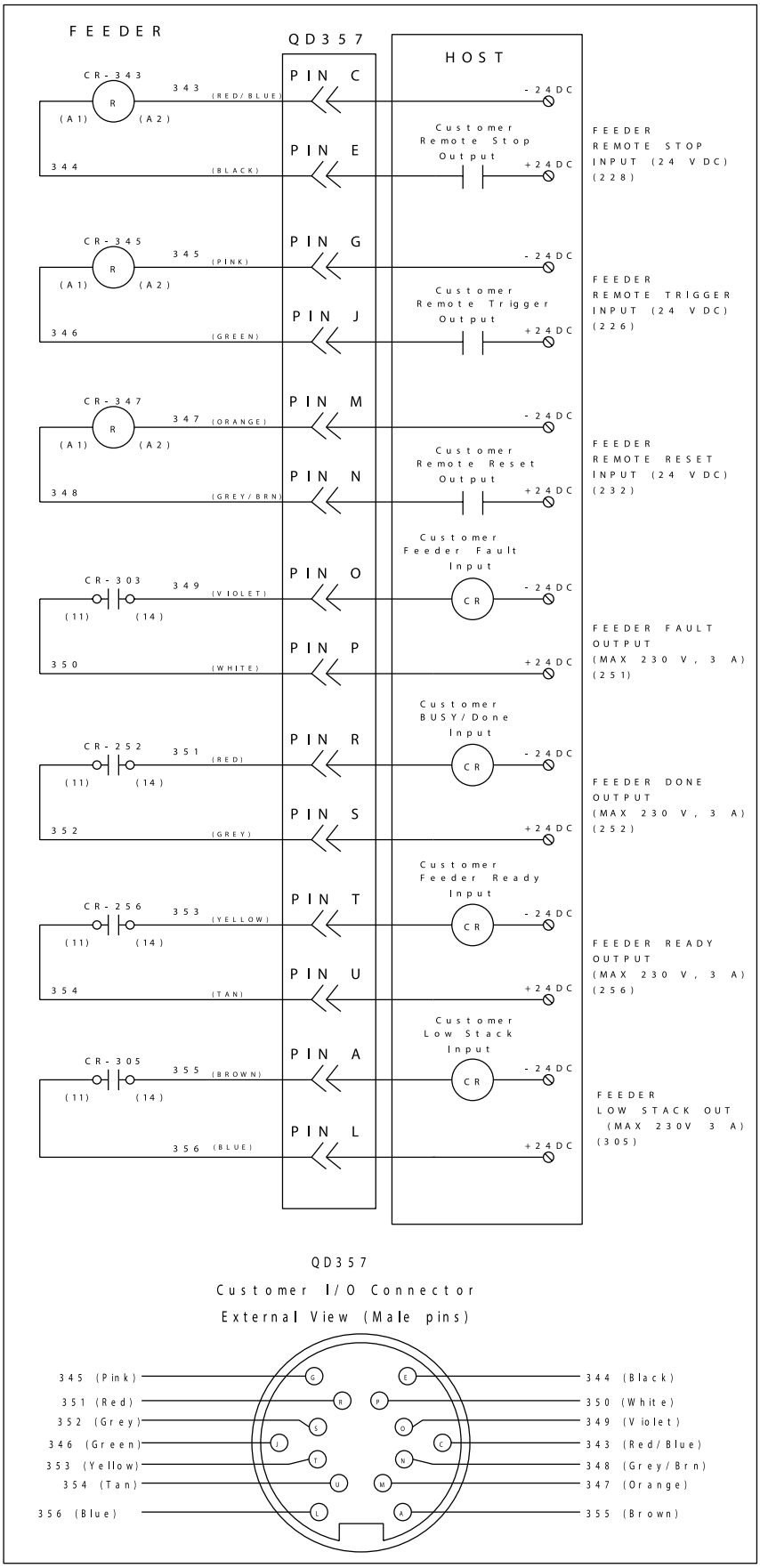

(1622) (1622)
+24DC 24COM
PLC 113
Micro850
INPUTS
COM0
I-00
FEEDER SHEET SENSOR
I-01
MOTOR DRIVE FAULT INPUT
I-02
ENCODER HIGH SPEED INPUT
I-03
FEEDER FAULT RESET INPUT
I-04
FEEDER CYCLE INPUT
I-05
FEEDER STOP INPUT
I-06
FEEDER JOG INPUT
I-07
SAFETY POWER OK
COM1
I-08
FLIGHT SENSOR INPUT(337, 346)
I-09
SPARE INPUT
I-10
SPARE INPUT
I-11
SPARE INPUT
I-12
LOW PRODUCT SENSOR (OPTIONAL)
I-13
DOUBLE DETECT INPUT
221
222
223
224
225
226
227
228
229
230
231
232
233
234
235
236
237
238
239
PE-223
PE-232
PE-236
QD210
QD213
223 (BLACK) PIN B (BLACK) 223
24COM (BLUE) PIN A (BLUE)
+24DC (BROWN) PIN N (BROWN)
203
224
225
RESET
226
CR-347
(11) (14)
START
227
STOP
228
CR-343
JOG
229
24E
CR-345
232
(SHLD) PIN 2 (WHITE)
232 (BLACK) PIN 4 (BLACK) 232
24COM (BLUE) PIN 3 (BLUE)
+24DC (BROWN) PIN 1 (BROWN)
233
234
235
236 (BLACK) PIN D (BLACK) 236
24COM (BLUE) PIN C (BLUE)
+24DC (BROWN) PIN L (BROWN)
237
325
+24DC 24COM


(119) +24E
(119) +24DC
(119) 24COM
241
PLC 113
Micro850
OUTPUTS
+DC24
242
-DC24
243
+CM0
244
O-00
245
245
107
FEEDER DRIVE BOARD CLOCK PULSE
O-01
246
246
M-246
PIN E
PIN A
RED
BLK
FEEDER ROTATING GATE MOTOR
-CM0
247
+CM1
248
O-02
249
249
107
FEEDER DRIVE BOARD RESET INPUT
O-03
250
250
116
FEEDER DRIVE ENABLE
O-04
251
251
322
PNUEMATIC DROPPER OPEN (OPTIONAL)
O-05
252
252
CR-252
R
(A1)
(A2)
FEEDER BUSY/ DONE OUTPUT (351)
O-06
253
253
PL-253
A
SL-253
A
QD210 PIN G
QD210 PIN C
FEEDER FAULT INDICATOR
O-07
254
254
PL-254
G
SL-253
G
QD210 PIN H
FEEDER READY INDICATOR
O-08
255
255
PL-255
R
SL-253
R
QD210 PIN K
FEEDER STOPPED INDICATOR
O-09
256
256
CR-256
R
(A1)
(A2)
FEEDER READY OUTPUT (353)
-CM1
257
258
259
+24E
+24DC
24COM


(115) +24DC
(109) +24DC
(109) 24COM
PLC 201
Micro850
RELAY
OUTPUTS
301
B1 COM0
302
B2 O-0
303
303
CR-303
R
(A1)
(A2)
FEEDER
FAULT
OUTPUT RELAY
(349)
B3 COM1
304
B4 O-1
305
305
CR-305
R
(A1)
(A2)
LOW STACK
OUTPUT
(354)
B5 COM2
306
B6 O-2
307
307
SPARE
A1 COM3
308
A2 O-3
309
309
SPARE
310
PLC 201
Micro850
COMMUNICATION
MODULE
311
A1 +485
312
A2 GND
313
A3 RTS
314
A4 CTS
315
B1 DCD
316
B2 RXD
317
B3 TXD
318
B4 -485
319
320
DB9
Serial Port
(COMM)
MODULE
5 4 3 2 1
6 7 8 9 S H
303
305
307
309
24E +24DC 24COM


+24DC
24COM
321
322
323
324
325
326
327
328
329
330
331
332
333
334
335
336
337
338
339
251
251
307
LS
322
SV-322
A
GND
SV-323
A
PNUEMATIC
DROPPER
OPEN (OPTIONAL)
+24DC
White
Blue
LS325
Black
Red
237
237
QUICK SET
DOUBLE DETECT
(OPTIONAL)
Red
Black
Black
24COM
LED325
R325
QD333
Local Trigger Echo
Connector
(Female pins)
BLACK
338
336
BROWN
336
336
Use Trigger Echo Cable
611-0488
TRIGGER ECHO RELAY
CR-337
232
24COM
R
(A1)
(A2)
336
PIN 1
BROWN
(11)
CR-337
(14)
338
PIN 4
BLACK
+24DC
24COM

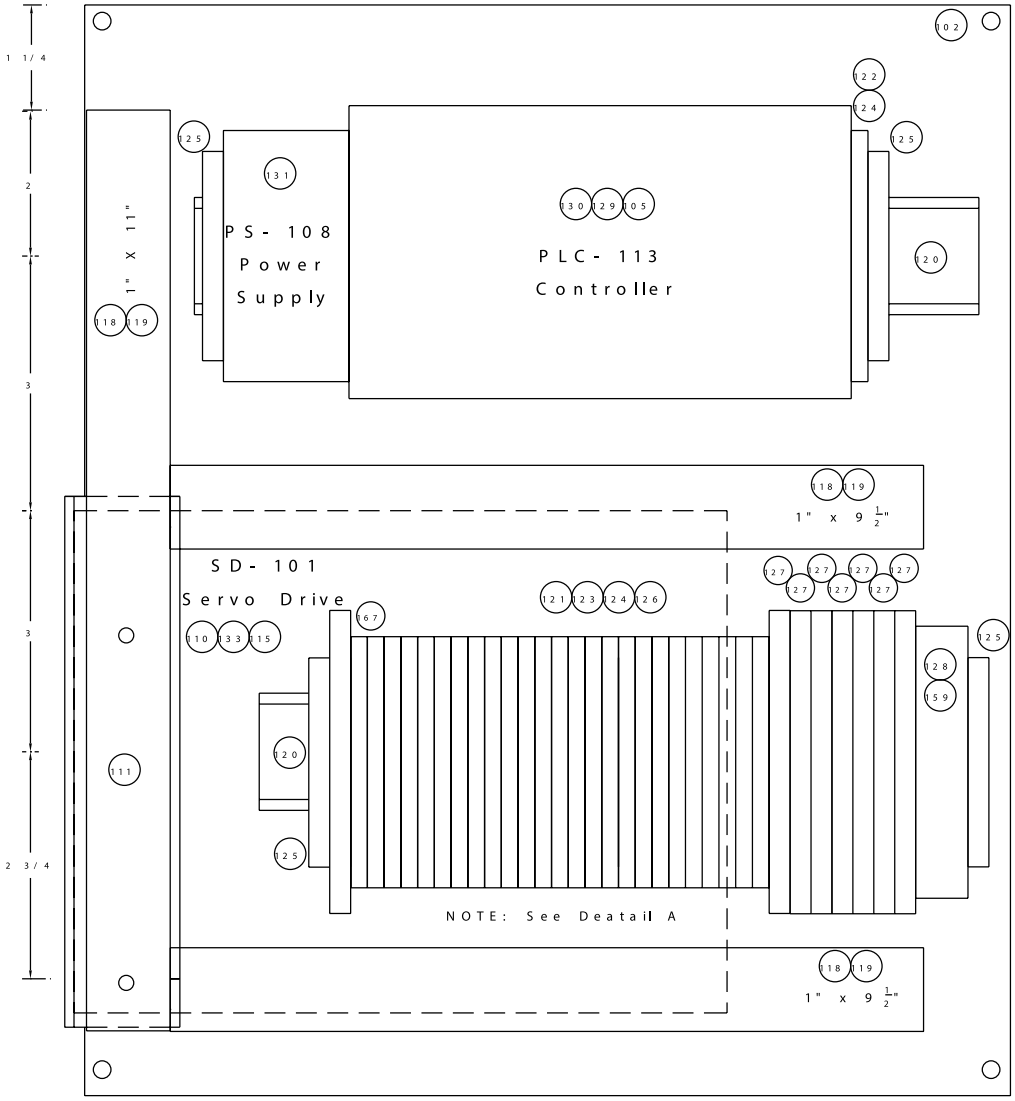
FEEDER I/O INTERFACE



QD357

Customer I/O Connector

External View (Male pins)



Deatail A

F- 107

CR- 252

CR- 256

CR- 303

CR- 305

CR- 343

CR- 345

CR- 347

103A

SEPERATOR 600660

N

N

SEPERATOR 600660

24COM

24COM

24COM

SEPERATOR 600660

+ 24DC

+ 24DC

+ 24DC

SEPERATOR 600660

24E

223

224

225

232

236

237

245

246

249

250

251

253

254

255

SPARE

SPARE

SEPERATOR 600660

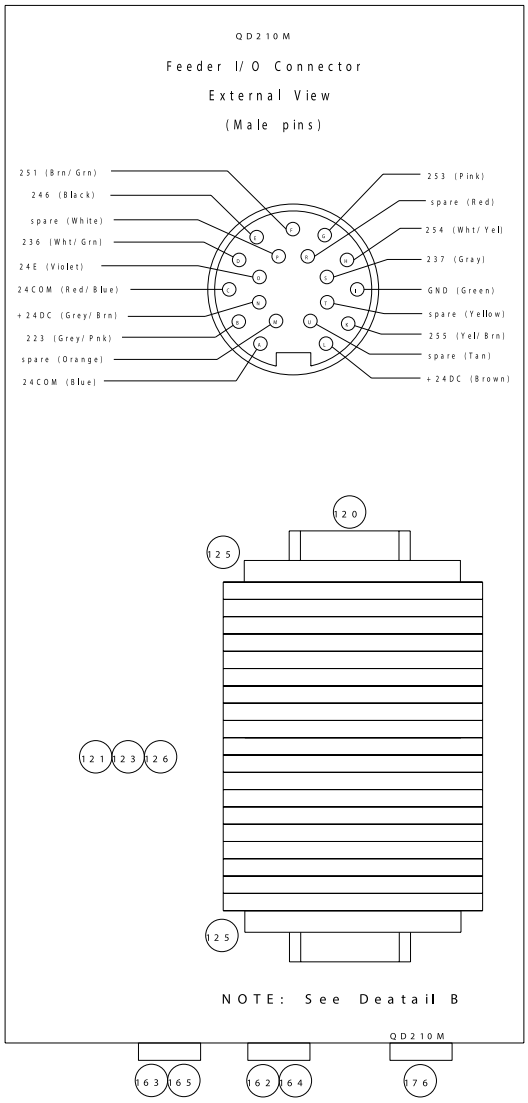
GND

GND

SEPERATOR 600660

CR- 337

FEEDER BASE PLATE



Deatail B

223

236

237

246

251

253

254

255

SPARE

SPARE

SPARE

SPARE

SPARE

24E

SEPERATOR 600660

+24DC

+24DC

SEPERATOR 600660

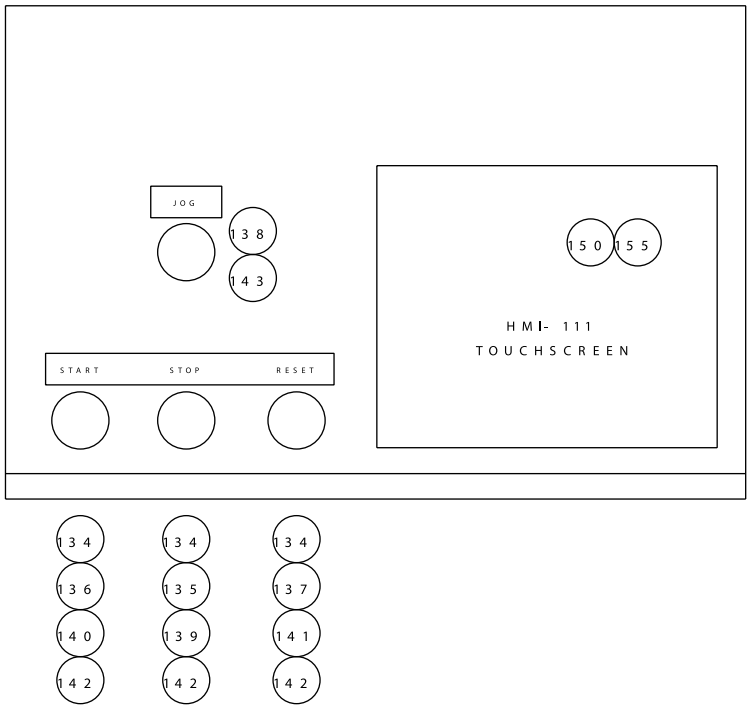
24COM

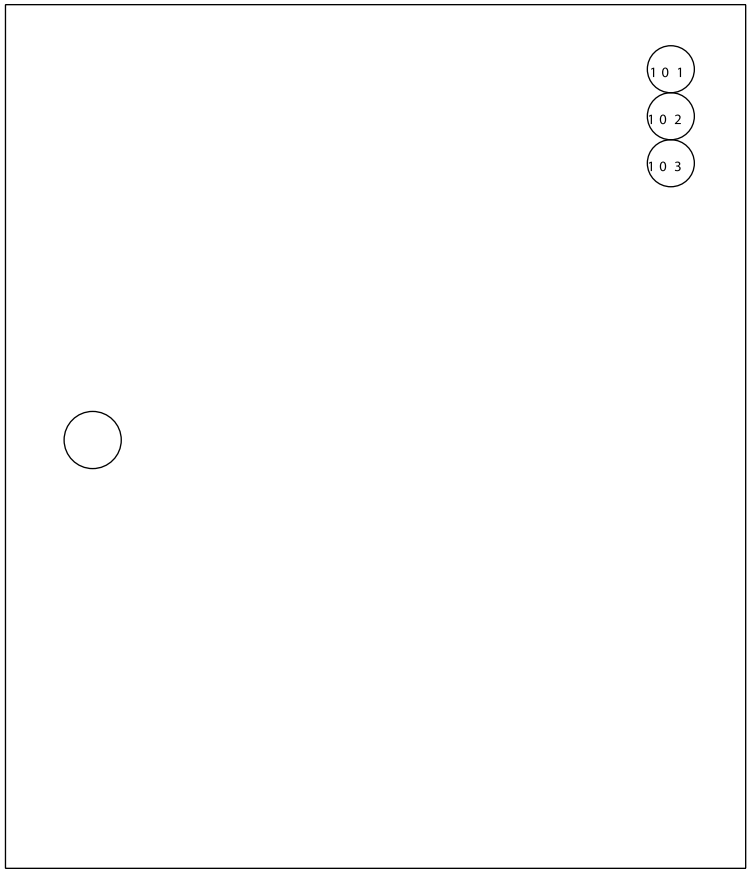
24COM

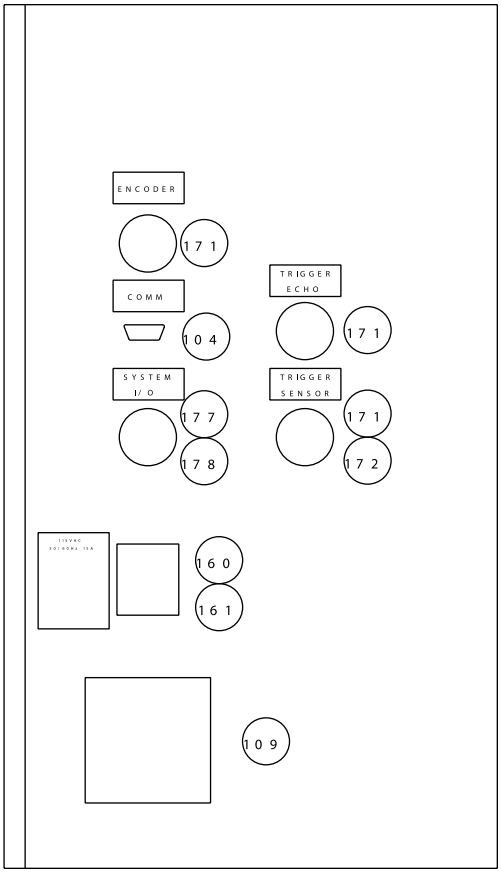
SEPERATOR 600660

GND

SEPERATOR 600660


JOG
138
143
150
155
HMI- 111
TOUCHSCREEN
START
STOP
RESET
134
136
140
142
134
135
139
142
134
137
141
142


101
102
103


ENCODER
171
COMM
104
TRIGGER
ECHO
171
SYSTEM
I/O
177
178
TRIGGER
SENSOR
171
172
160
161
109

I/O Cable Wiring

External I/O Cable Wiring Table

External I/O Cable - Part Number 903389

Pin #	Wire Color	Function	Device	Voltage
O	Violet	Fault Output	Dry Contact	Max 230V 3A
P	White	Fault Output	Dry Contact	Max 230V 3A
R	Red	Done Output	Dry Contact	Max 230V 3A
S	Grey	DoneOutput	Dry Contact	Max 230V 3A
T	Yellow	Ready Output	Dry Contact	Max 230V 3A
U	Tan	Ready Output	Dry Contact	Max 230V 3A
A	Brown	Low Stack Output	Dry Contact	Max 230V 3A
L	Blue	Low Stack Output	Dry Contact	Max 230V 3A
C	Red/Blue	Remote Stop Input (-)	Relay	+24VDC COM
E	Black	Remote Input (+)	Relay	+24VDC
G	Pink	External Trigger Input (-)	Relay	+24VDC COM
J	Green	External Trigger Input (+)	Relay	+24VDC
M	Orange	Remote Reset Input (-)	Relay	+24VDC COM
N	Grey/Brown	Remote Reset Input (+)	Relay	+24VDC

0101 904811 ENCLOSURE SSTL 350MMX300MMX200MM 1 EA
0102 904809 PANEL 350X300MM GALV ELECTRIC 1 EA
0103 904810 BRKT MOUNTING KIT (4) ENCL 1 EA
0104 904849 DB9 FEMALE PNL CONNECTOR 1 EA
0105 904848 SERIAL COM CARD AB 2080 PLC 1 EA
0109 201552 4 POS STRAIN RELIEF 1 EA
0110 904782 SERVO DRIVE 400WATT 120VAC 1 EA
0111 904777 SERVO DRIVE MOUNT BRACKET 1 EA
0115 904779 SERVO MOTOR 400 WATT 1 EA
0117 904831 PULLEY 18T X 5MM PT X 14MM BOR 1 EA
0118 51327036 1X1.5 PANDUIT 3 FT
0119 51327037 1 INCH PANDUIT COVER 3 FT
0120 595-0003 RAIL, DIN 35MMX7.5MM ZN 12 IN
0121 600659 TERMINAL, SPRING TRIPLE 44 EA
0122 600663 TERMINAL, GROUND QUAD 1 EA
0123 601027 TERMINAL BLOCK GRND 3 EA
0124 354050 TERMINAL, END BARRIER, GRAY 1 EA
0125 01990402RC END ANCHOR HD, STANDARD DIN RA 6 EA
0126 600660 BARRIER, END TERMINAL TRIPLE 10 EA
0127 197213 RELAY W/BASE SLIM SPDT 24V 7 EA
0128 138440A01 BLOCK FUSE MTG 30A 1 POLE CC 1 EA
0129 903345 MICRO 800 4 POINT RELAY OUTPUT 1 EA
0130 904807 PLC MICRO850 24 I/O 1 EA
0131 195327 POWER SUPPLY 24VDC 72W 1 EA
0133 904906 CABLE 50 PIN BUILT PER PRINT 1 EA
0134 196721 MOUNT 3-POSITION 3 EA
0135 51632102 BUTTON, ILLUMRD EXTEND PUSH 1 EA
0136 517390026 PUSHBUTTON, GREEN FLUSH 1 EA
0137 535500548 BUTTON, AMBRILLUMEXTNDED 22MM 1 EA
0138 51241011 BUTTON, BLACK PUSH (FLUSH) 1 EA
0139 517390021 MODULE, RED LED 1 EA
0140 517390022 MODULE, GREEN LED 1 EA
0141 51739024 MODULE, AMBER LED 1 EA
0142 196722 CONTACT BLOCK 1-NO 3 EA
0143 535500523 SWITCH, CONTACT BLOCK NO 1 EA
0150 903259 HMI 4" PV C400 COLOR COMP 0 EA
0155 206475 CABLE ENET 0.3M 300V RJ45/RJ45 1 EA
0159 124099A30 FUSE 15A LOW PEAK CC TD 1 EA
0160 904895 MODULE PWR ENTRY W/SWITCH 15A 1 EA
0161 904950 CORD 115V 15A 7.5FT 1 EA
0162 904872 CABLE FEEDBACK SERVO EXTENTION 1 EA
0163 904873 CABLE SERVO POWER EXTENTION 1 EA
0164 904794 CABLE SERVO FEEDBACK BULKHEAD 1 EA
0165 904795 CABLE SERVO POWER BULKHEAD 1 EA
0167 352788 RELAY, SOLID-STATE,SINGLE-POLE 1 EA
0171 903388 CONN,PNL MT.1/2 NPT 4PIN FEMAL 3 EA
0172 611-0393 ASSY, SENSOR FLIGHT 50MM 1 BM
0175 904847 CABLE PICOFAST 19PIN FEMALE 5M 1 EA
0176 904846 CONNECTOR PICOFAST 19PIN MALE 1 EA
0177 903389 CABLE PICOFAST 14 PIN FM 5 MTR 1 EA
0178 903390 CONN,PNL MT,1/2NPT,14PIN MALE 1 EA

0101 904811 ENCLOSURE SSTL 350MMX300MMX200MM 1 EA
0102 904809 PANEL 350X300MM GALV ELECTRIC 1 EA
0103 904810 BRKT MOUNTING KIT (4) ENCL 1 EA
0104 904849 DB9 FEMALE PNL CONNECTOR 1 EA
0105 904848 SERIAL COM CARD AB 2080 PLC 1 EA
0109 201552 4 POS STRAIN RELIEF 1 EA
0110 905029 SERVO DRIVE 400WATT 240VAC 1 EA
0111 904777 SERVO DRIVE MOUNT BRACKET 1 EA
0115 904779 SERVO MOTOR 400 WATT 1 EA
0117 904831 PULLEY 18T X 5MM PT X 14MM BOR 1 EA
0118 513270361X1.5 PANDUIT 3 FT
0119 513270371 INCH PANDUIT COVER 3 FT
0120 595-0003 RAIL, DIN 35MMX7.5MM ZN 12 IN
0121 600659 TERMINAL, SPRING TRIPLE 25 EA
0122 600663 TERMINAL, GROUND QUAD 2 EA
0123 601027 TERMINAL BLOCK GRND 3 EA
0124 354050 TERMINAL, END BARRIER, GRAY 1 EA
0125 01990402RC END ANCHOR HD, STANDARD DIN RA 4 EA
0126 600660 BARRIER, END TERMINAL TRIPLE 1 EA
0127 197213 RELAY W/BASE SLIM SPDT 24V 6 EA
0128 138440A01 BLOCK FUSE MTG 30A 1 POLE CC 1 EA
0129 903345 MICRO 800 4 POINT RELAY OUTPUT 1 EA
0130 904807 PLC MICRO850 24 I/O 1 EA
0131 195327 POWER SUPPLY 24VDC 72W 1 EA
0133 904906 CABLE 50 PIN BUILT PER PRINT 1 EA
0134 196721 MOUNT 3-POSITION 3 EA
0135 516321102 BUTTON, ILLUMRD EXTEND PUSH 1 EA
0136 517390026 PUSHBUTTON, GREEN FLUSH 1 EA
0137 535005483 BUTTON, AMBRILLUMEXTNDED 22MM 1 EA
0138 512410111 BUTTON, BLACK PUSH (FLUSH) 1 EA
0139 517390211 MODULE, RED LED 1 EA
0140 517390222 MODULE, GREEN LED 1 EA
0141 517390241 MODULE, AMBER LED 1 EA
0142 196722 CONTACT BLOCK 1-NO 3 EA
0143 535005233 SWITCH, CONTACT BLOCK NO 1 EA
0150 903259 HMI 4" PV C400 COLOR COMP 0 EA
0155 206475 CABLE ENET 0.3M 300V RJ45/RJ45 1 EA
0159 124099A30 FUSE 15A LOW PEAK CC TD 1 EA
0160 904895 MODULE PWR ENTRY W/SWITCH 15A 1 EA
0161 904950 CORD 115V 15A 7.5FT 1 EA
0162 904872 CABLE FEEDBACK SERVO EXTENTION 1 EA
0163 904873 CABLE SERVO POWER EXTENTION 1 EA
0164 904794 CABLE SERVO FEEDBACK BULKHEAD 1 EA
0165 904795 CABLE SERVO POWER BULKHEAD 1 EA
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0175 904847 CABLE PICOFAST 19PIN FEMALE 5M 1 EA
0176 904846 CONNECTOR PICOFAST 19PIN MALE 1 EA
0177 903389 CABLE PICOFAST 14 PIN FM 5 MTR 1 EA
0178 903390 CONN,PNL MT,1/2NPT,14PIN MALE 1 EA

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