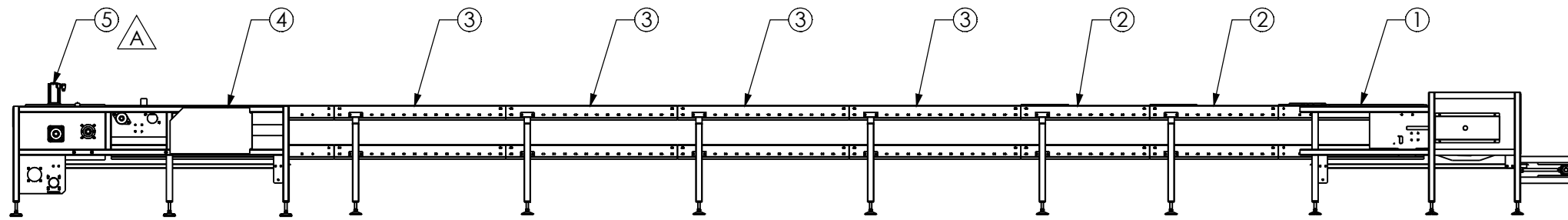
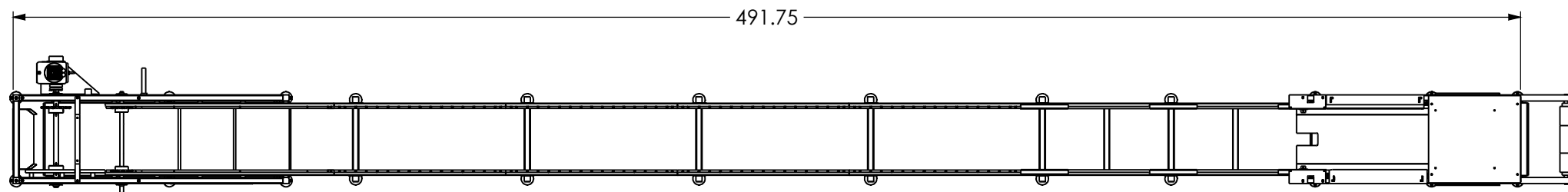
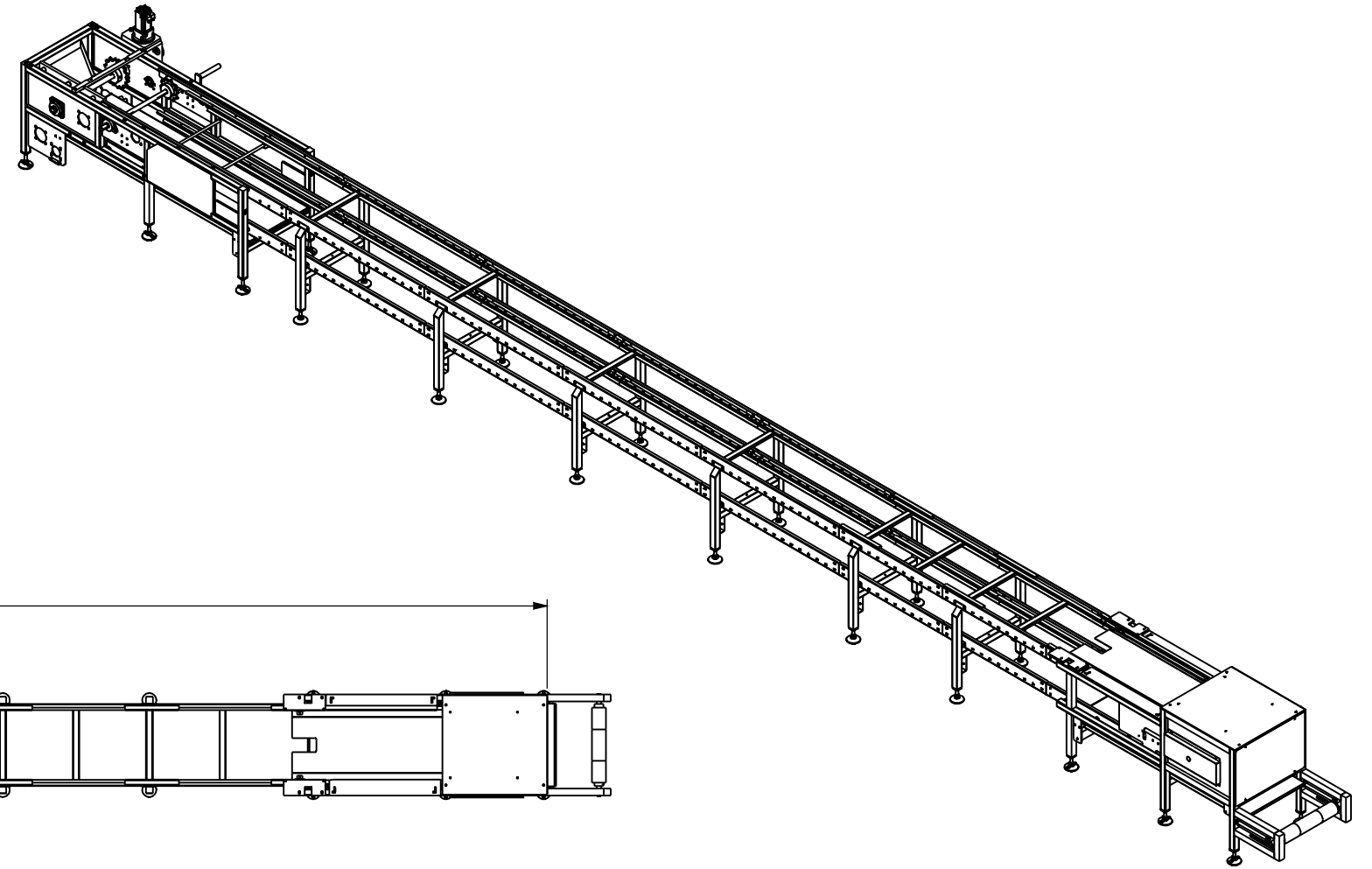


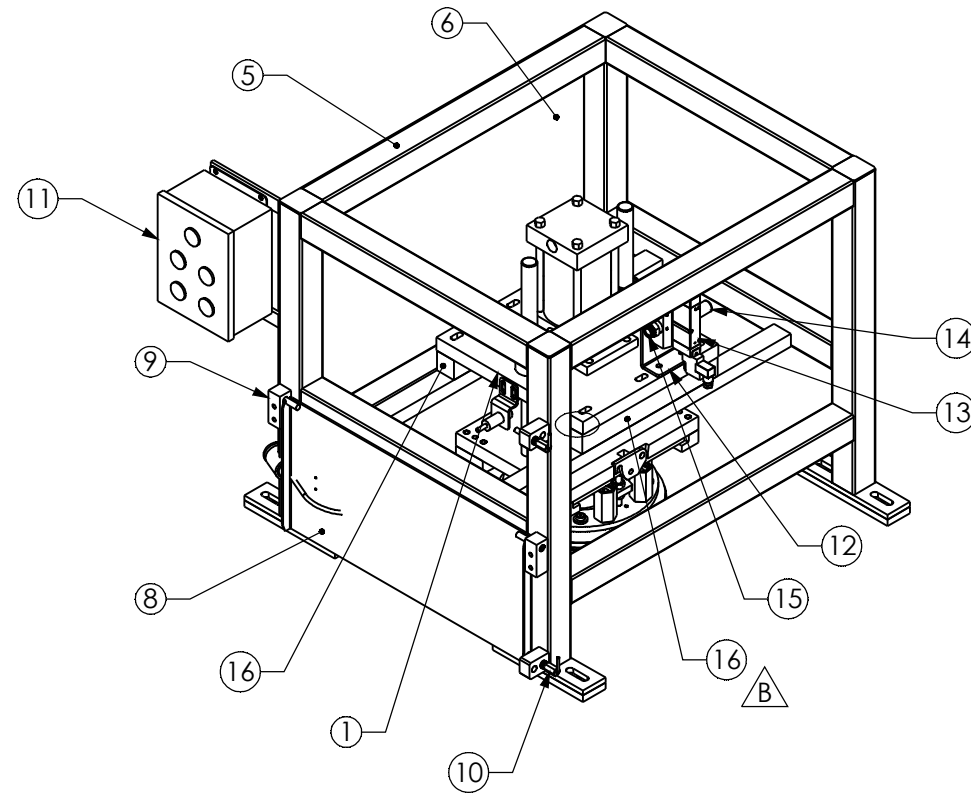
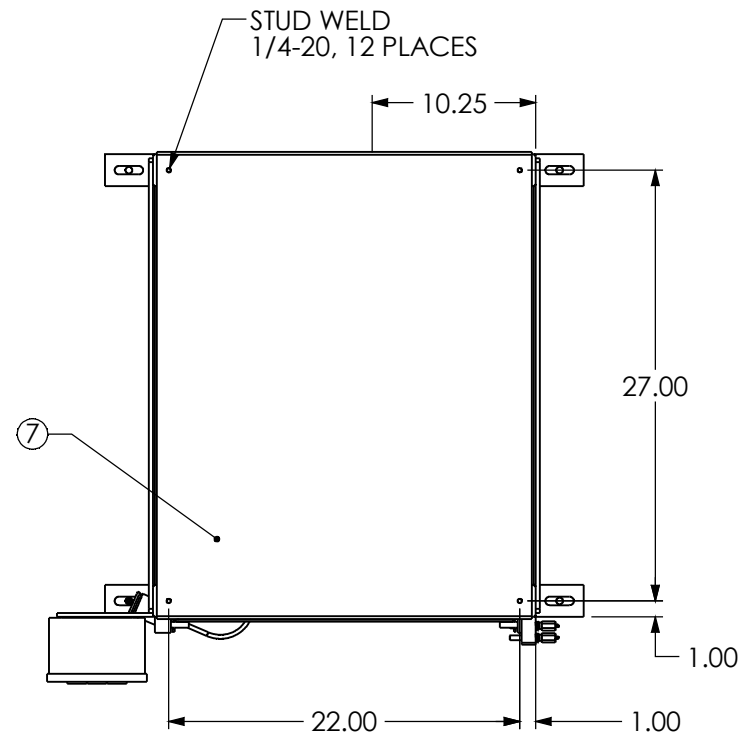
ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	AT-60024001	ASSEMBLY, FRAME, AFT, SERIES 45	1
2	AT60242-42	FRAME EXTENSION ASSEMBLY, 42", W/O SCRAP RETURN	2
3	AT60242-56	FRAME EXTENSION ASSEMBLY, 56", W/O SCRAP RETURN	4
4	150897	FRAME, FORWARD ASSEMBLY	1
5	151064	SERVO DRIVE, NE	1



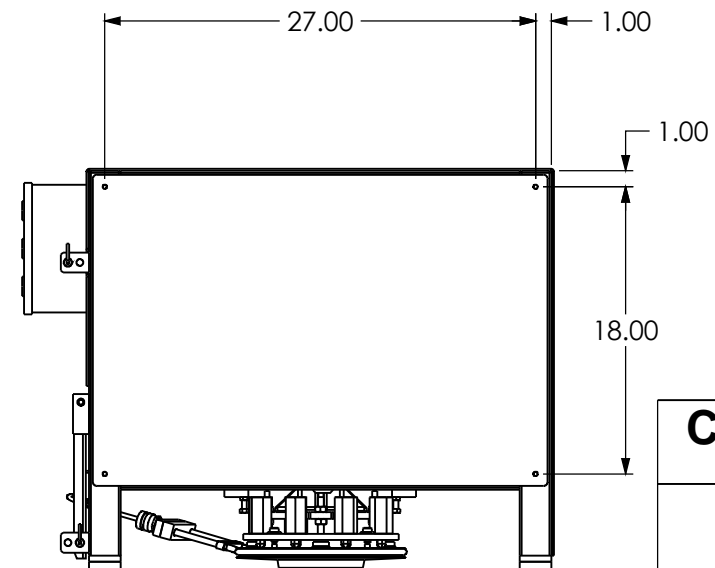
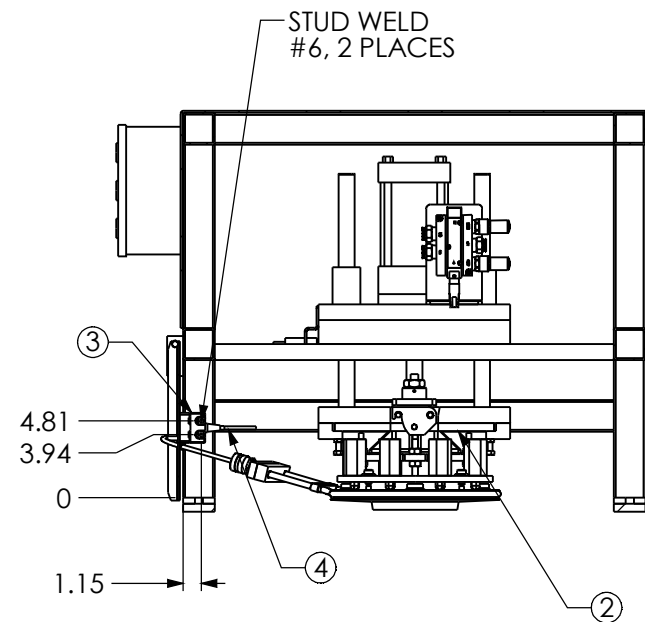
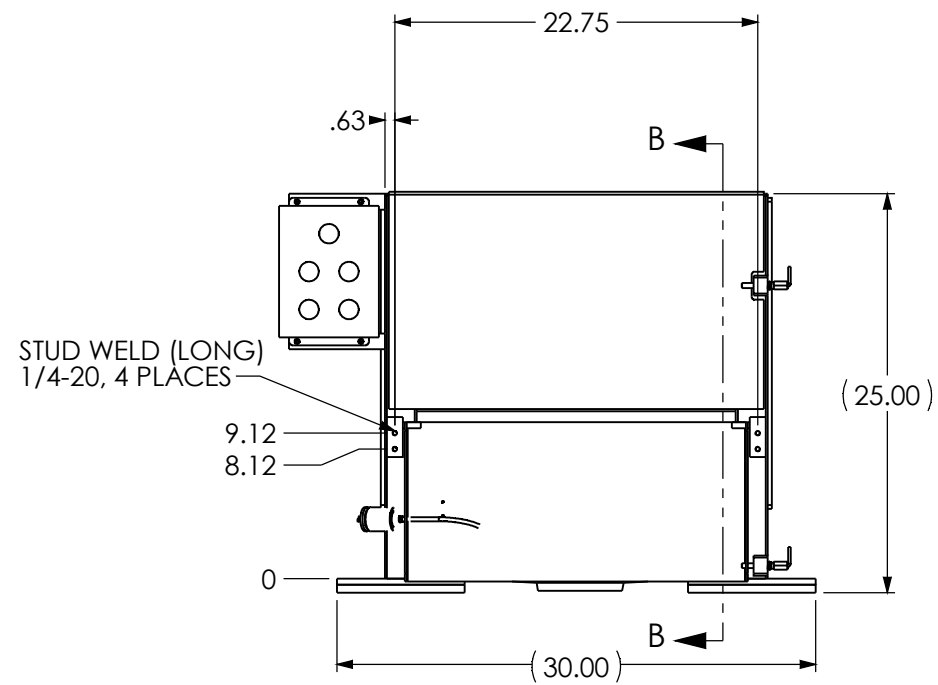
COLBORNE FOOTBOTICS, LLC LAKE FOREST, IL 60045	
DO NOT SCALE DRAWING MACHINING TOLERANCES UNLESS SPECIFIED: FRACTION ± 1/64 ANGLES ± 1° DECIMALS .XXX ---- ± .005 .XX ---- ± .010	
STOCK SIZE:	SEE B.O.M.
MATERIAL:	SEE B.O.M.
FINISH:	SEE B.O.M.
PATT NO:	ASSY NO: 141479
DESIGNED BY: LMG	TITLE: CONVEYOR, MAIN, NEW ENGLAND
DRAWN BY:	DRAWING NO: B-150778
CHECKED BY:	DATE: 6/25/2014
Sheet 1 of 1	

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A	DCR-2014-233-LMG, 8/5/2014, SERVO DRIVE SHOWN
REV.	DESCRIPTION



ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	113366	ASSEMBLY, PRESS HEAD CARRIAGE	1
2	113391	PLATE, TOOL HOLDER, 9 PLATE	1
3	133394	SWITCH, SAFETY, NON-CONTACT	1
4	133492	CORDSET, 8 PIN DCMICRO QD	1
5	150784	TRIMMER FRAME WELDMENT	1
6	150789	GUARD, TRIMMER FOR/AFT, PC	2
7	150796	GUARD, TRIMMER, TOP	1
8	150797	TRIMMER, DOOR	1
9	150798	BLOCK, HINGE	2
10	150799	SPRING PLUNGER, L-HANDLE	2
11	AX8306	SIMMERSTAT CONTROL BOX AND ELECTRICAL SCHEMATIC	1
12	139970	BRACKET, SOLENOID	1
13	139704	VALVE, SOLENOID, SINGLE, 24VDC	1
14	139968	SILENCER, 0.50" NPT	2
15	125089	1/2 NPT X 1/2 TUBE, KQ2H13-37S	3
16	151388	SPACER, TRIMMER	2



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LAKE FOREST, IL 60045

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DECIMALS .XXX ---- ± .005 .XX ---- ± .010

STOCK SIZE: SEE B.O.M.

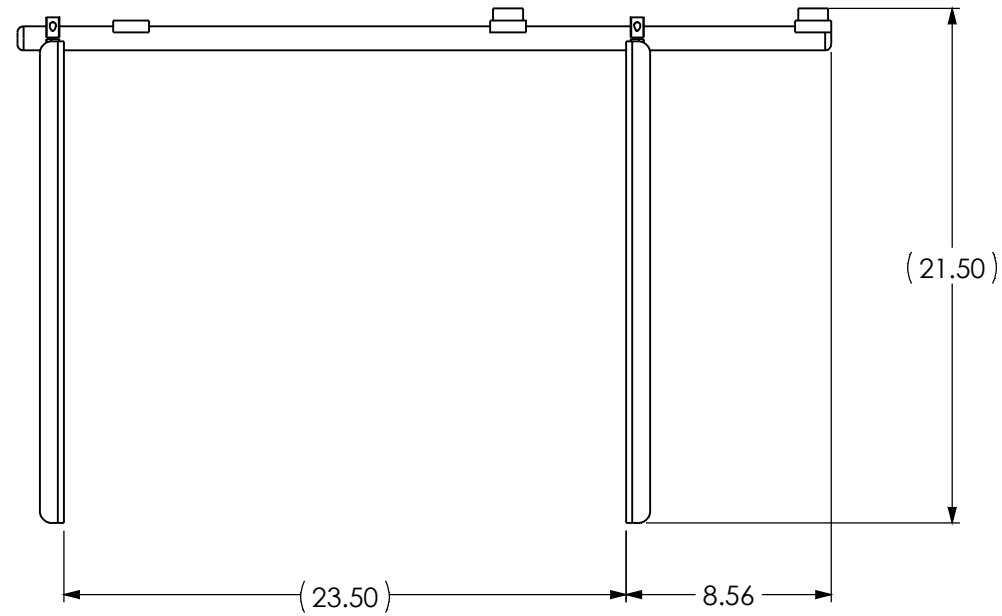
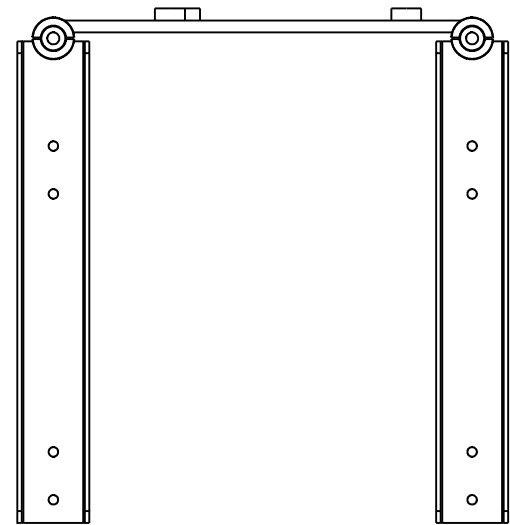
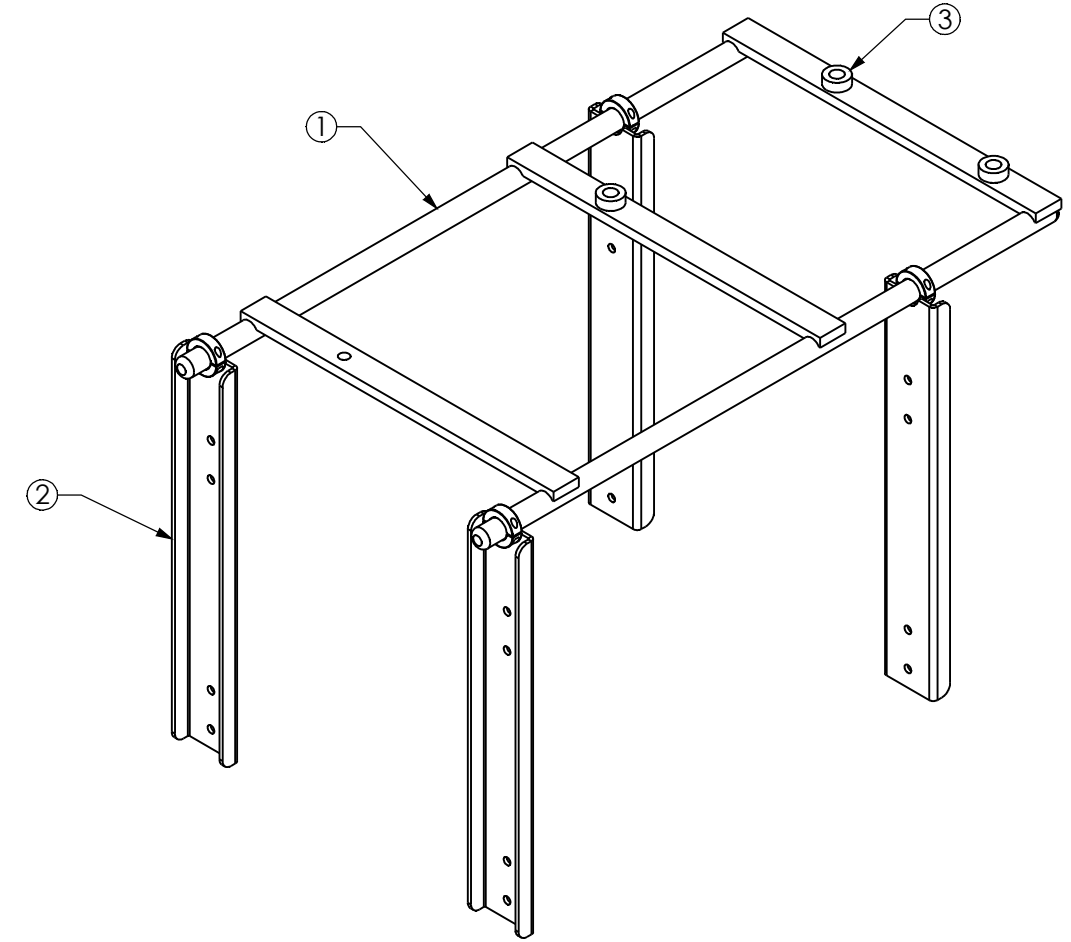
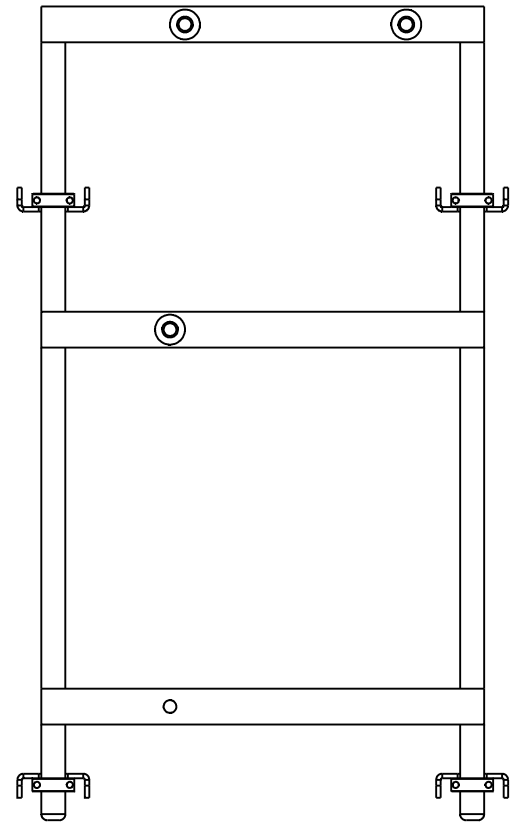
MATERIAL: SEE B.O.M.	FINISH:
PATT NO:	ASSY NO: 141479
DESIGNED BY: LMG	TITLE: TRIMMER VERTICAL ASSEMBLY
DRAWN BY:	DRAWING NO: B-150783
CHECKED BY:	DATE: 7/2/2014

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REV.	DESCRIPTION
B	DCR-2014-288-LMG, 9/25/2014, RELOCATED VALVE (DONE), AND ADDED 1.5" SPACERS FOR TRIMMER HEIGHT
A	DCR-2014-267-LMG, 8/25/2014, ADDED VALVE AND FITTINGS TO TRIMMER ASSEMBLY

ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	150805	WELDMENT, SHEETER	1
2	150806	SIDE SUPPORT	4
3	150807	SPACER	3



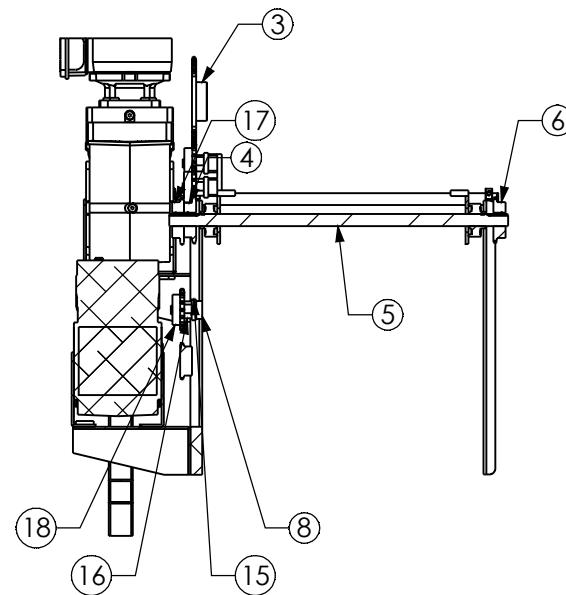
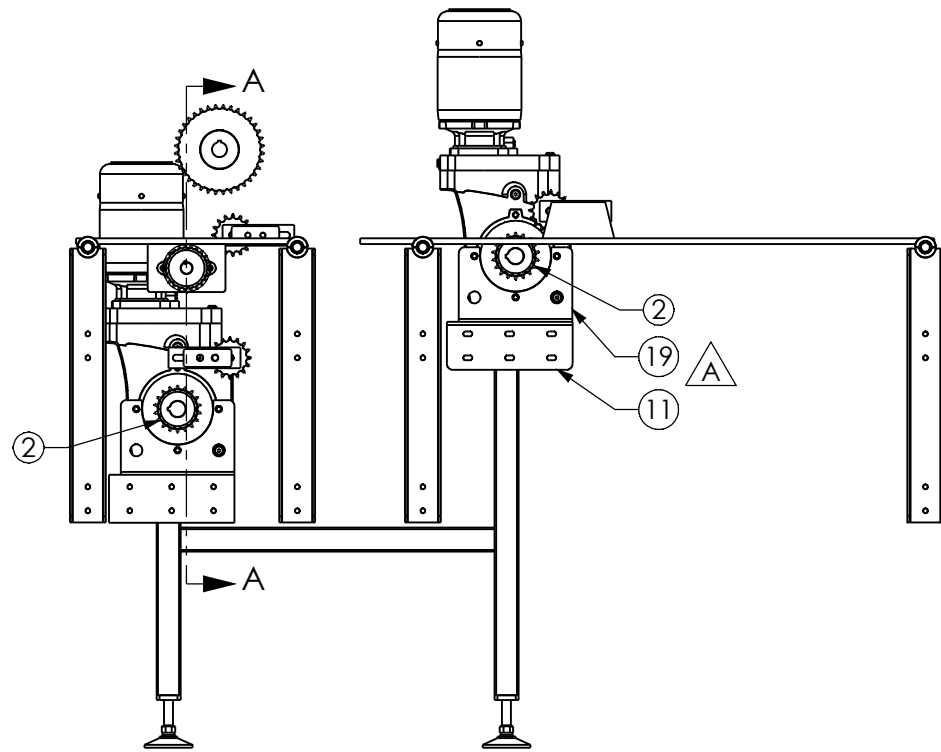
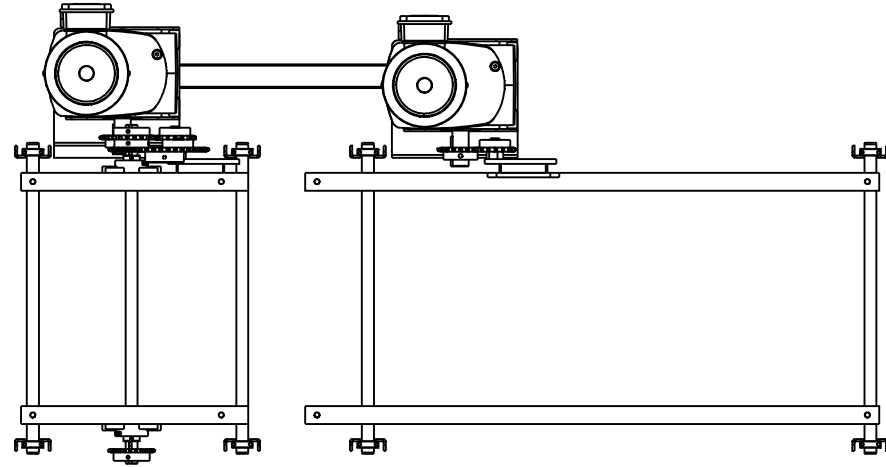
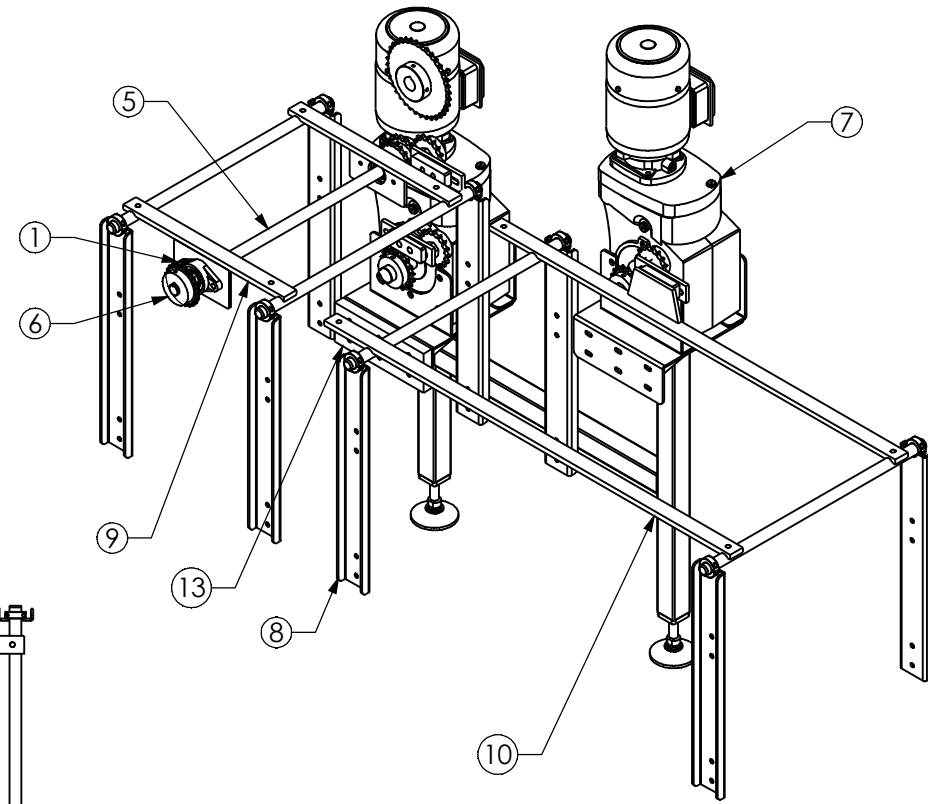
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DECIMALS .XXX ---- $\pm .005$.XX ---- $\pm .010$

STOCK SIZE: SEE B.O.M.	
MATERIAL: SEE B.O.M.	FINISH: SEE B.O.M.
PATT NO:	ASSY NO: 141479
DESIGNED BY: LMG	TITLE: MOUNT, 9-PLATE SHEETER ON M45
DRAWN BY:	DRAWING NO: B-150804
CHECKED BY:	DATE: 7/2/2014

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REV.	DESCRIPTION



SECTION A-A

ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	109972	BEARING, 2-BOLT FLANGE, 1.00" BORE	2
2	113573	SPROCKET, 50B18, 1.38" BORE	2
3	118078	SPROCKET, 50B 36, 1.25" BORE	1
4	141628	SPROCKET, 50B18, 1.25" BORE W/ KEYWAY	1
5	141728	JACKSHAFT	1
6	141736	SPROCKET, 40B23, 1.00" BORE W/ KEYWAY	1
7	150822	GEARMOTOR, 52.64 RATIO	2
8	150852	SIDE SUPPORT	8
9	150890	WELDMENT, FINISHING SHEETER	1
10	150891	WELDMENT, PRIMARY SHEETER	1
11	150892	BRACKET, GEARBOX	2
12	150893	SPACER	2
13	150894	SPACER, GEARBOX BRACKET	1
14	150895	SPACER, CHAIN TENSIONER	1
15	AS30244	BAR, IDLER SPROCKET ADJUSTMENT	2
16	CX130-65	STUD, SPROCKET & TENSION ARM	2
17	CX00203045	HUB SPR. KEYED 5/8P. 3/8W	1
18	CX00210001	SPROCKET ASSY, 50B16	2
19	151261	BRACKET, GEARBOX	4
20	151264	ASSEMBLY, LEG, MOTOR SUPPORT	1

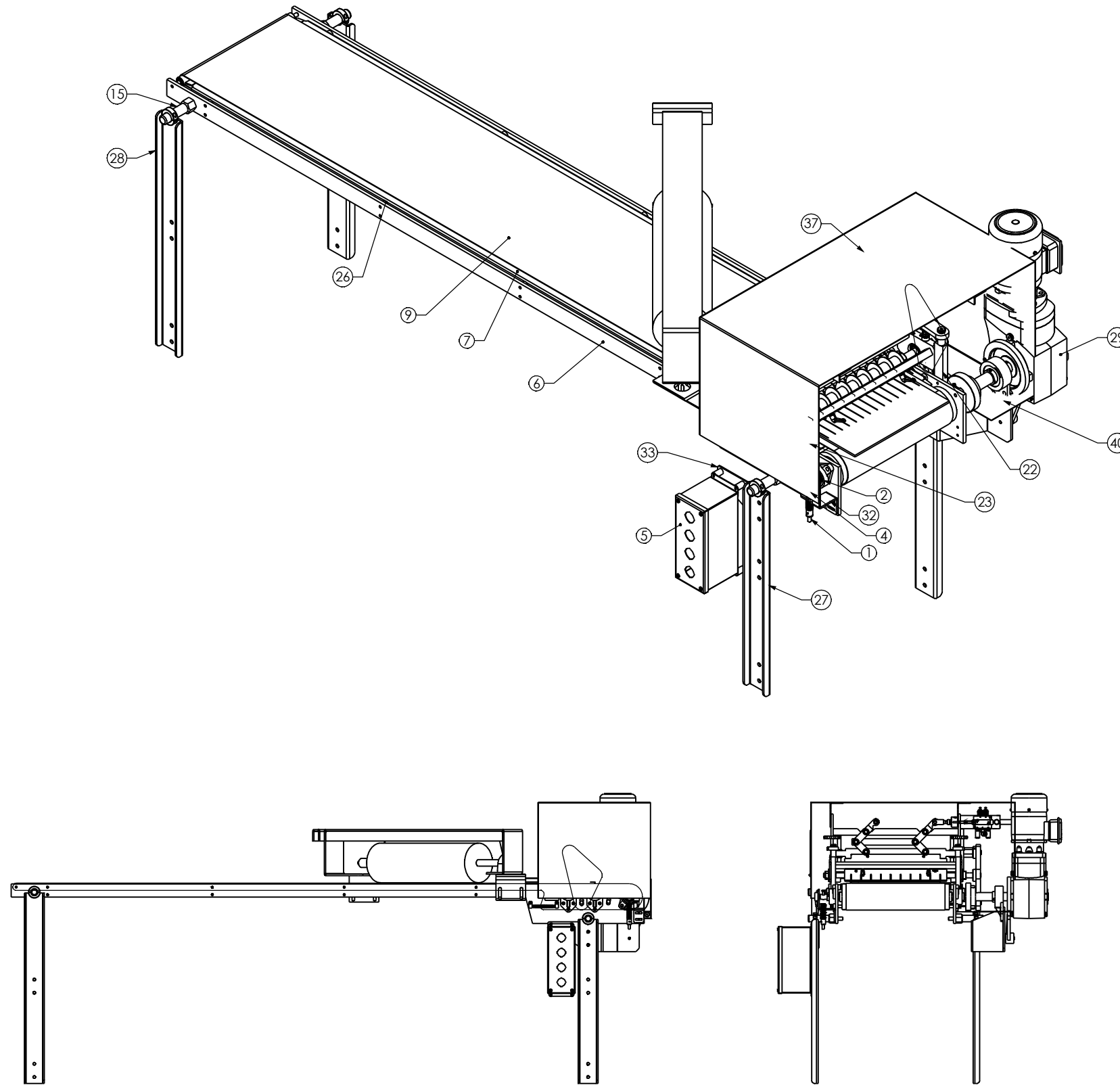
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DECIMALS .XXX---± .005 .XX---± .010

STOCK SIZE: SEE B.O.M.	
MATERIAL: SEE B.O.M.	FINISH: SEE B.O.M.
PATT NO:	ASSY NO: 141479
DESIGNED BY: LMG	TITLE: MOUNT, S76 SHEETER ON M45
CHECKED BY:	DRAWING NO: B-150811
DATE: 7/3/2014	Sheet 1 of 2

B	DCR-2014-272-LMG, 8/28/2014, ADDED LEG TO SUPPORT GEARMOTORS
A	DCR-2014-269-LMG, 8/26/2014, ADDED 4x 151261 BRACKET FOR MOUNTING GEARBOX, GEARBOXES ARRIVED WITHOUT TAPPED MOUNTING HOLES
REV.	DESCRIPTION

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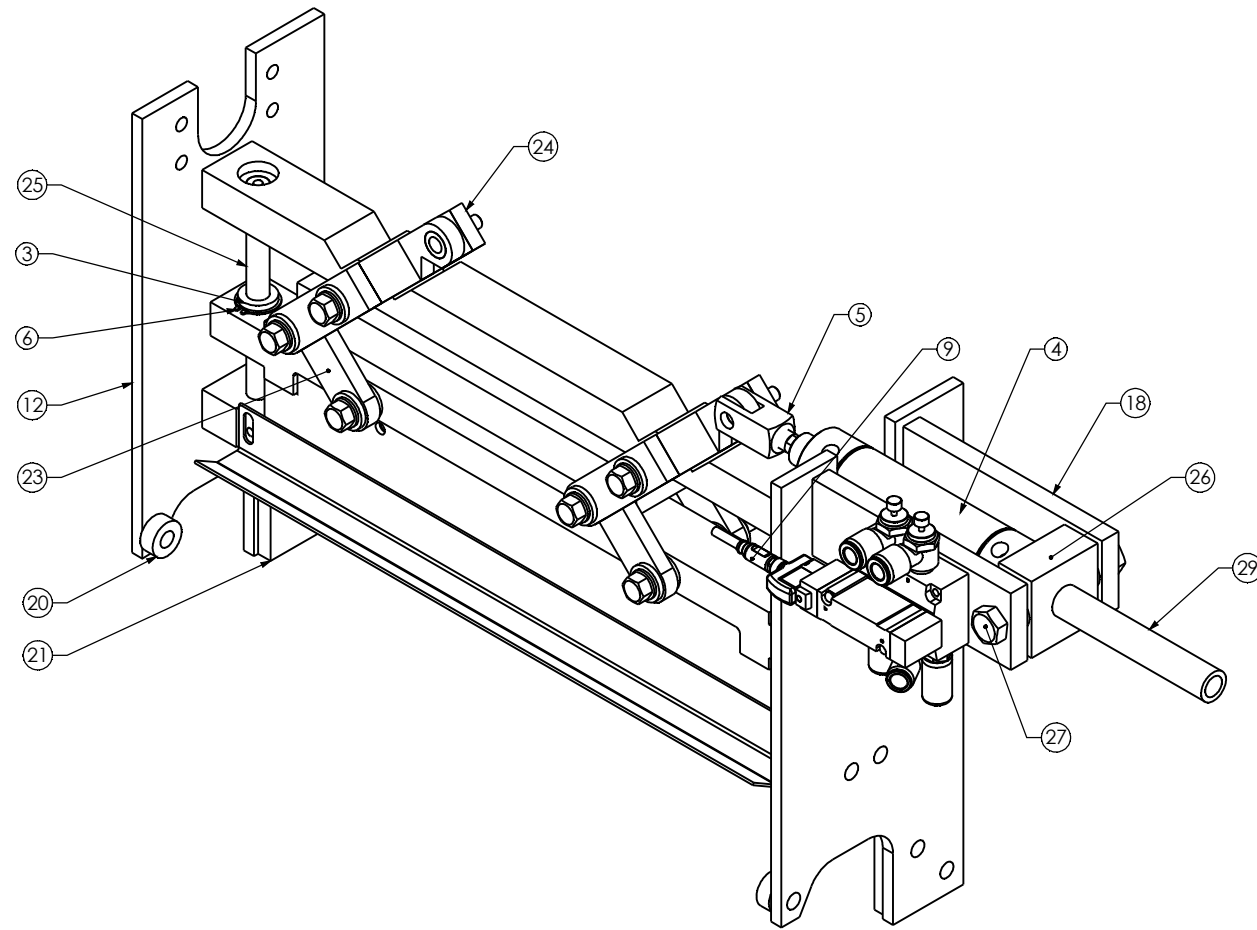
ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	104990	PROXIMITY SWITCH	1
2	109965	BEARING, 2-BOLT FLANGE, 0.75" BORE	2
3	114509	BEARING, 3-BOLT, 0.75" BORE	4
4	150209	ENCODER, INCREMENTAL MAGNETIC, IP69K	1
5	150590	4 BUTTON JUNCTION BOX MOUNTING	1
6	150935	CONVEYOR SIDEWALL	2
7	150936	BED, CONVEYOR	1
8	150937	SHAFT, DRIVE, LATTICE STRIP	1
9	150938	BELT, 15" WIDE, 197" LONG	1
10	150939	ASS'Y - IDLER ROLLER, 1.00" DIA. x 16.26"	2
11	150941	ASS'Y - IDLER ROLLER, 1.00" DIA. x 16.26"	1
12	150945	ROLLER, DRIVE	1
13	150946	ROLLER, SUPPORT	2
14	150948	SHAFT, SUPPORT ROLLER	2
15	150949	STUD, SUPPORT	4
16	150952	GEAR, 16DP, 64 TH, 1.25" BORE, 20 PA, 0.75" FW	1
17	150953	GEAR, 16DP, 40 TH, 0.75" BORE, 20 PA, 0.75" FW	2
18	150954	GEAR, 16DP, 40 TH, 0.88" IDLE, 20 PA, 0.75" FW	2
19	150955	STUD, SPROCKET & TENSION ARM	1
20	150956	STUD, SPROCKET & TENSION ARM	1
21	150957	STUD, SPROCKET & TENSION ARM	1
22	150958	TRACK, RH	1
23	150959	TRACK, LH	1
24	150963	SPROCKET, DRIVING, 22TH	1
25	150964	SPROCKET, IDLE, 22 TH	1
26	150966	SPACER, CONVEYOR BED	10
27	150967	SIDE SUPPORT	2
28	150968	SIDE SUPPORT	2
29	150969	GEARMOTOR, 1.25" HOLLOW BORE, 46.64:1, TORQUE ARM	1
30	150970	BRACKET, TORQUE ARM	1
31	150971	CROSSBAR, FRAME	4
32	150972	BRACKET, ENCODER	1
33	150973	BRACKET, PUSH BUTTONS	1
34	150974	NUT, TEE, IDLER ADJUSTMENT	1
35	150975	HOUSING, IDLER SLIDE ADJ.	1
36	150976	BELT TENSIONER, THREADED	2
37	150977	ASSEMBLY, GUILLOTINE, 15.50"	1
38	150988	BELT, EAGLE YELLOW 640mm, HELICAL TOOTH DRIVE	1
39	501035	BOLT, HEX, 0.25"-20x1.25", 18-8 SS	1
40	CX00100045	BEARING, 1.25", 3-BOLT FLANGE	1
41	151296	GUARD SLIDE MOUNT	2
42	151297	GUARD, SLITTER CONVEYOR	1
43	TX56660-mod	POWERED FLOUR REMOVAL SYSTEM	1
44	151417	ROLLOVER PRESSURE ASSEMBLY	2

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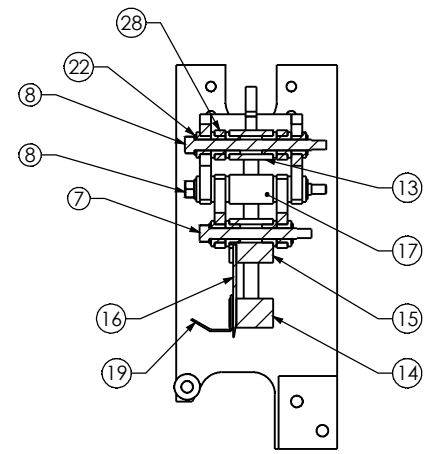
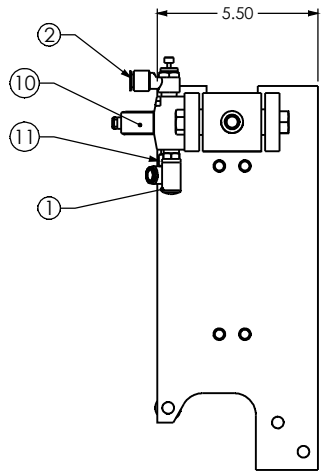
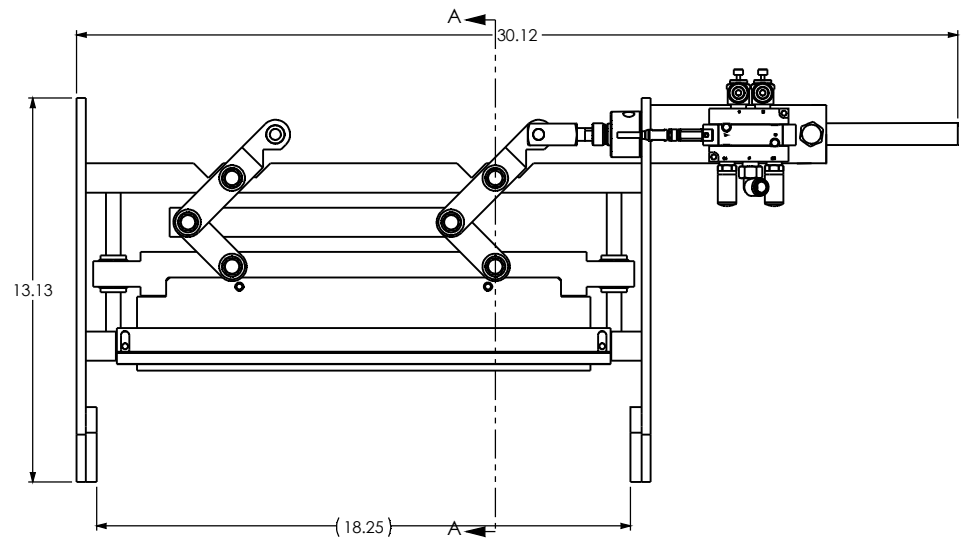
STOCK SIZE: SEE B.O.M.
 MATERIAL: SEE B.O.M. FINISH: SEE B.O.M.
 PART NO: ASSEMBLY NO:
 DESIGNED BY: LMG TITLE: ASSEMBLY, LATTICE STRIP CONV.
 DRAWN BY: DRAWING NO: C-150932
 CHECKED BY: DATE: 7/17/2014

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REV.	DESCRIPTION
A	DCR-2014-292-LMG, 10/10/2014, PRESSURE ARM ASSEMBLIES 141417 ADDED TO MAINTAIN CONTACT BETWEEN ROLLOVER CUTTER AND BELT



ITEM NO.	PART NUMBER	DESCRIPTION	Default Qty.
1	104365	SILENCER, 0.25" NPT	2
2	106811	FITTING, FLOW CONTROL VALVE, 0.25" NPTx0.38", ELBOW	2
3	107332	BEARING, LINEAR	2
4	107335	CYLINDER, 1.50" BORE, 3.00" STROKE (BIMBA 173-DXDE)	1
5	107336	CLEVIS	1
6	107337	RING, RETAINING 0.88" SHAFT	4
7	110477	SCREW, SS, SHOULDER, 0.38"x3.00"(0.31"x0.50")	2
8	110478	SCREW, SS, SHOULDER, 0.38"x4.00"(0.31"x0.50")	4
9	139231	CORDSET, 3P FEMALE, STRAIGHT, M8, W/ 3m PVC-OB, MURR	1
10	141620	VALVE, SOLENOID, SINGLE, 24VDC, 0.25" NPTF, M8	1
11	141621	FITTING, ELBOW, SWIVEL, 0.38" TUBE x 0.25" NPT	1
12	150978	SIDE PLATES, GUILLOTINE	2
13	150979	CROSS BAR & BRG. ASS'Y.	1
14	150980	CROSS MEMBER - LOWER	1
15	150981	BLADE HOLDER & BRG. ASS'Y.	1
16	150982	BLADE - GUILLOTINE, 15.50"	1
17	150983	PENDULUM, CROSSMEMBER	1
18	150984	STAND-OFF, CYLINDER MOUNT	2
19	150985	SCRAPER - GUILLOTINE BLADE	1
20	150986	SPACER	2
21	150987	SPACER BLOCK	2
22	501212	WASHER, FLAT, 0.31", SS	12
23	ED52022-B	LINK & BRG. ASS'Y. - SHORT	4
24	ED52023-B	YOKE & BRG. ASS'Y.	2
25	ED52024	GUIDE ROD	2
26	ED-52031-A	PIVOT BLOCK & BRNG. ASSEMBLY	1
27	ED-52032	PIVOT BOLT, CYL.	2
28	ED-52036-A	SPACER AND BRG. ASS'Y.	4
29	ED-52038	GUARD, CYLINDER ROD	1



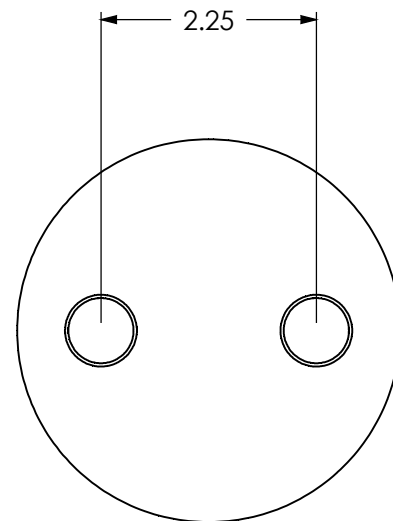
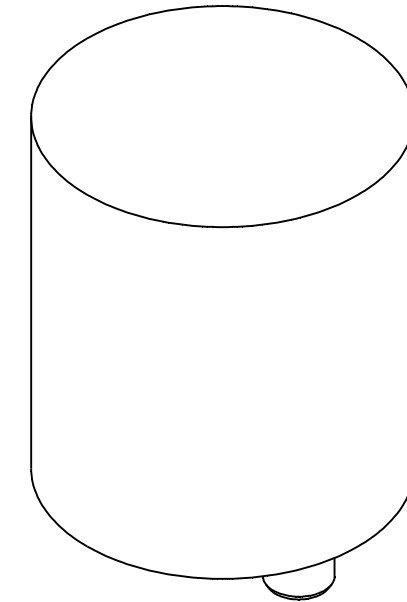
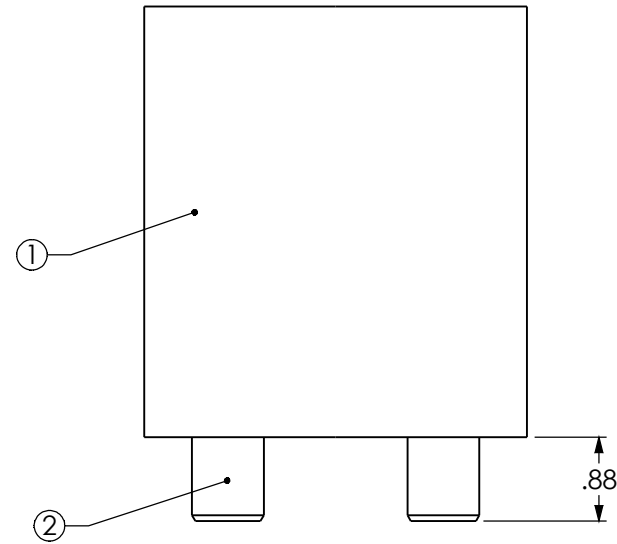
SECTION A-A

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STOCK SIZE: SEE B.O.M.
 MATERIAL: SEE B.O.M. FINISH: SEE B.O.M.
 PART NO: ASSEMBLY NO:
 DESIGNED BY: TITLE: ASSEMBLY, GUILLOTINE, 15.50"
 DRAWN BY: LMG
 CHECKED BY: DRAWING NO: C-150977
 DATE: 7/21/2014

ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	151021	LIFT POST, 4" DIA	1
2	501920	PIN, DOWEL, 0.75"x2.00", SS	2



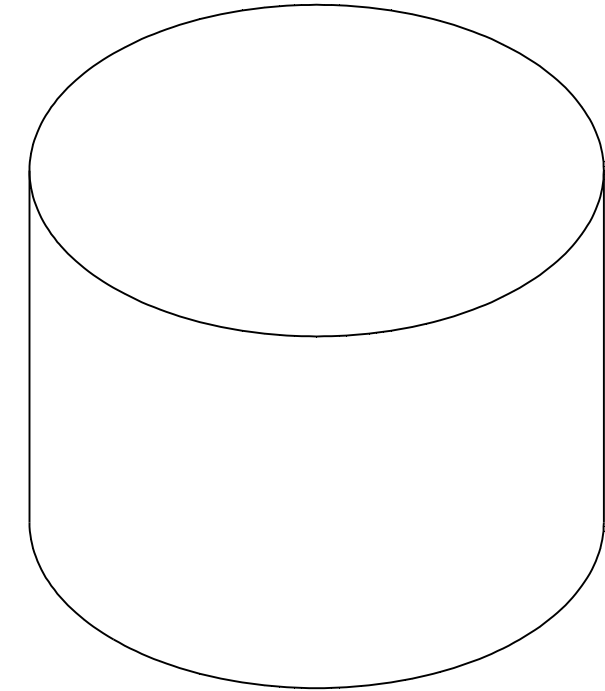
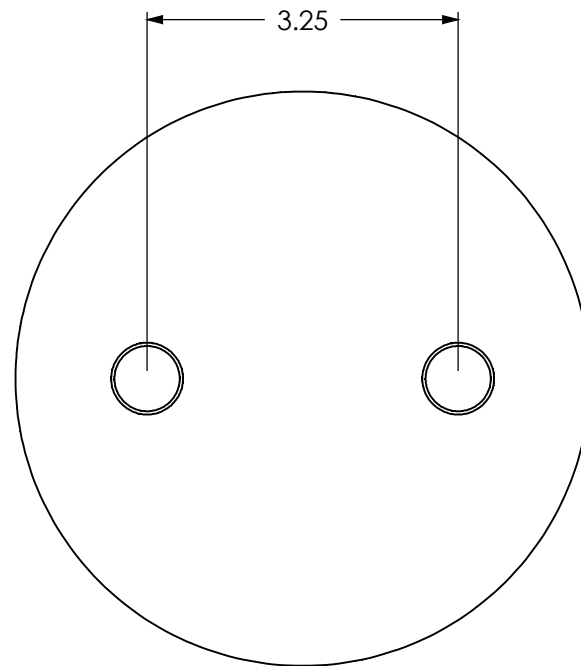
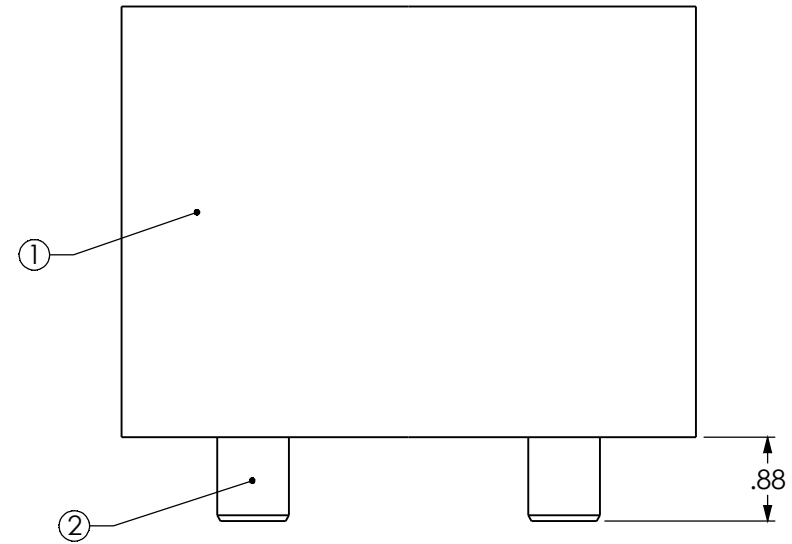
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STOCK SIZE: SEE B.O.M.	
MATERIAL: SEE B.O.M.	FINISH:
PATT NO:	ASSY NO: 150933
DESIGNED BY: LMG	TITLE: LIFT POST ASS'Y, 4" DIA
DRAWN BY:	DRAWING NO: B-151020
CHECKED BY:	DATE: 7/29/2014

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NOTE:
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MARKED (STAMPED OR ETCHED)
ON SURFACE AS SHOWN.

REV.	DESCRIPTION

ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	151023	LIFT POST, 6" DIA	1
2	501920	PIN, DOWEL, 0.75"x2.00", SS	2



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LAKE FOREST, IL 60045

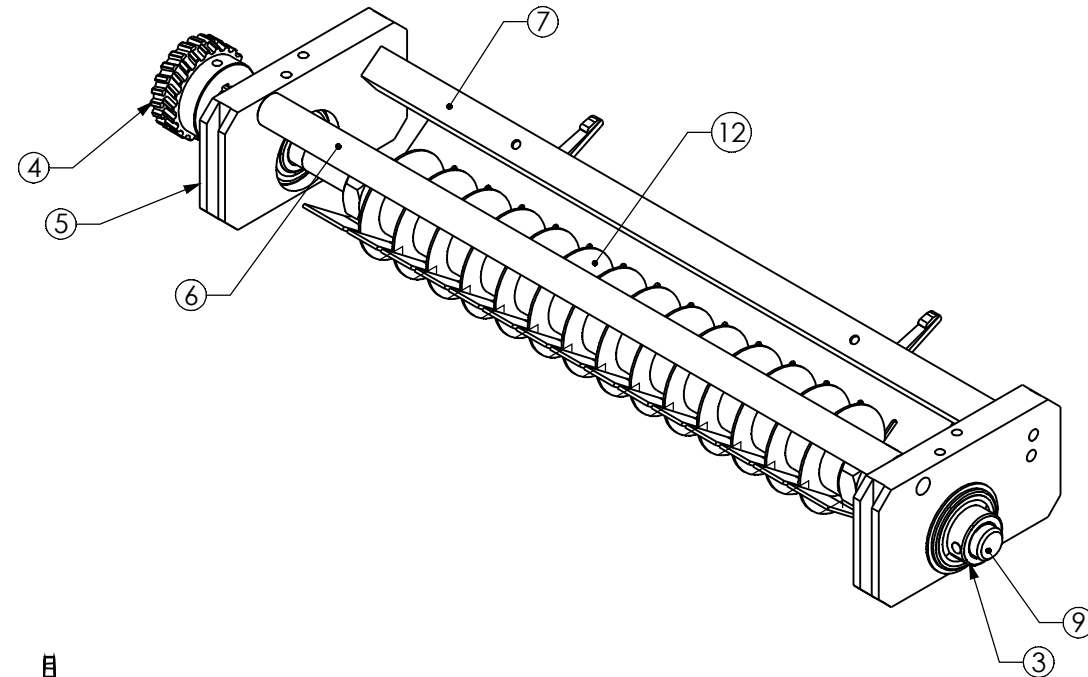
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 DECIMALS .XXX---- $\pm .005$.XX---- $\pm .010$

STOCK SIZE: SEE B.O.M.

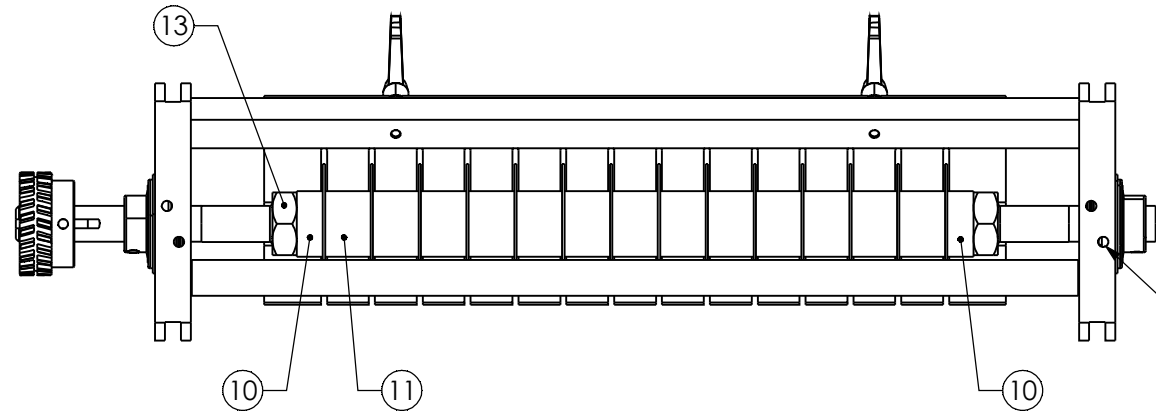
MATERIAL:	SEE B.O.M.	FINISH:	
PATT NO:		ASSY NO:	150933
DESIGNED BY:	LMG	TITLE:	LIFT POST ASS'Y, 6" DIA
DRAWN BY:		DRAWING NO:	B-151022
CHECKED BY:		DATE:	7/29/2014

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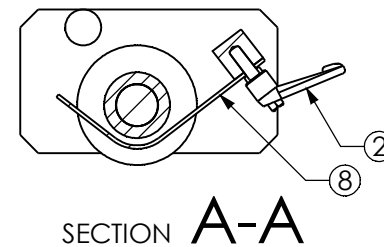
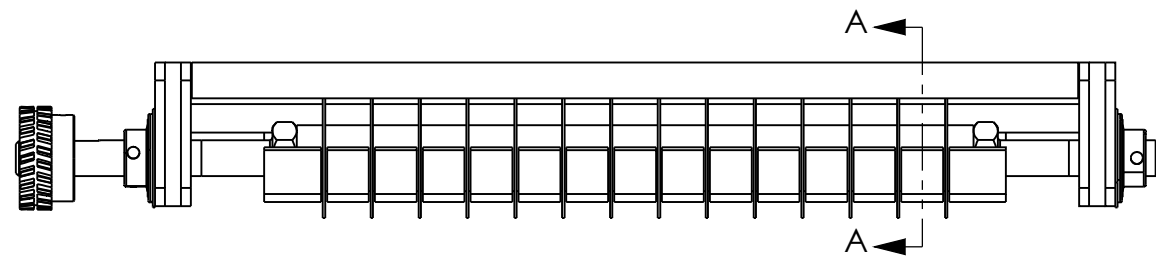
NOTE:
 PART NO. TO BE PERMANENTLY
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 ON SURFACE AS SHOWN.



ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	114808	PIN, DOWEL, 0.25"x0.75", SS	2
2	133867	HANDLE, ADJUSTABLE, 0.25"-20, SS	2
3	138671	BEARING, BALL, INSERT, .75"	2
4	150965	SPROCKET, DRIVEN, 22TH	1
5	151030	BLOCK, SLIDE	2
6	151034	CROSSBAR	1
7	151035	CROSSBAR, COMB	1
8	151037	COMB, 1.0" PITCH	1
9	151039	STRIP CUTTING WHEEL SHAFT	1
10	151040	CUTTING WHEEL SPACER, END	2
11	151041	CUTTING WHEEL SPACER, 1.0"	13
12	151043	CUTTING WHEEL	14
13	501170	NUT, 0.88"-14, HEX JAM, SS	2



NOTE:
INSTALL GREASE ZERK IN OUTSIDE PORT
INSTALL SCREW ON INSIDE PORT



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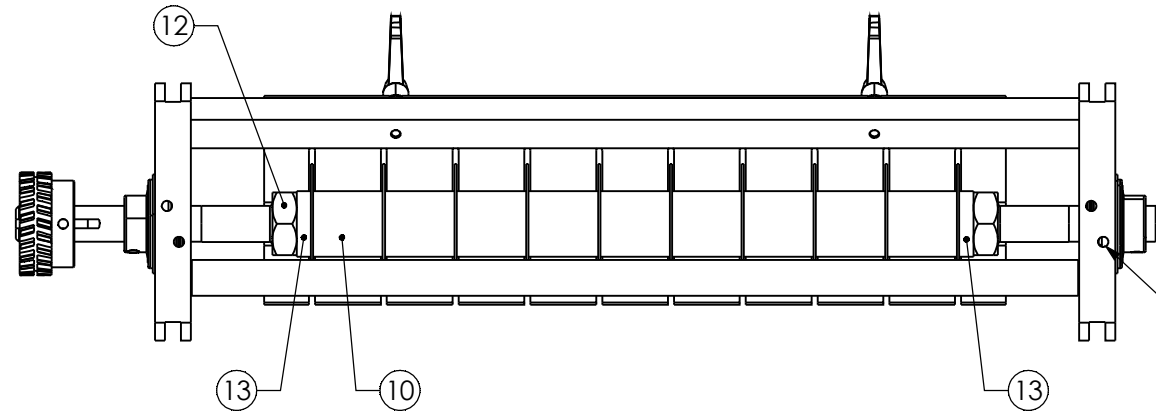
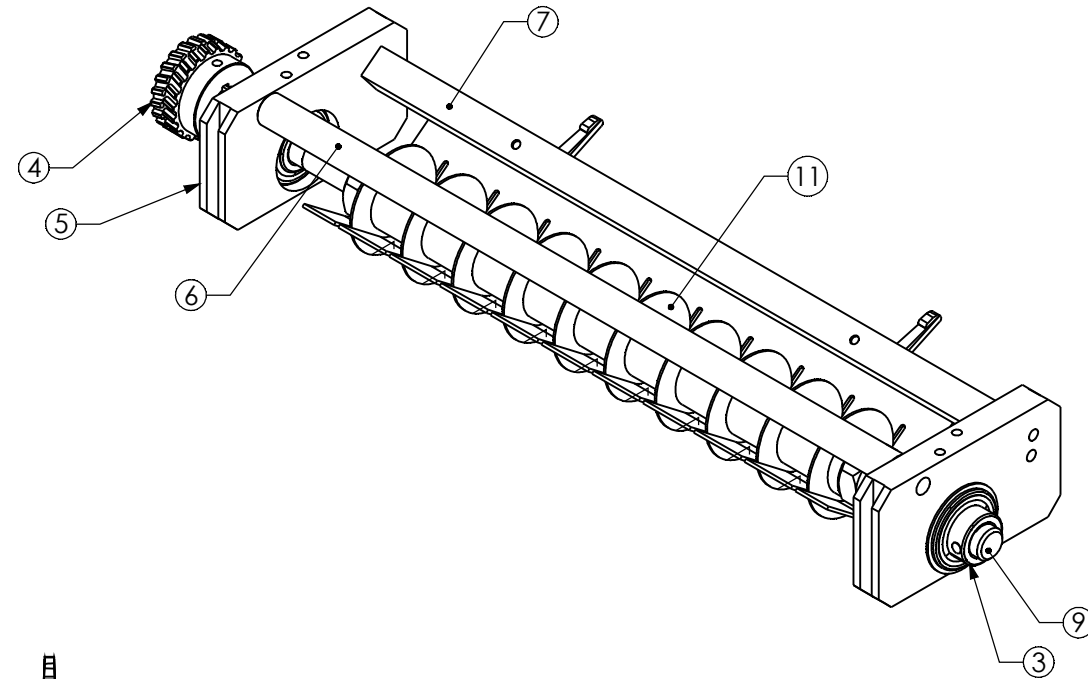
COLBORNE FOOTBOTICS, LLC

LAKE FOREST, IL 60045

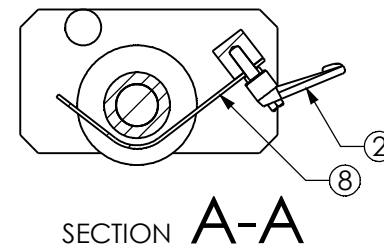
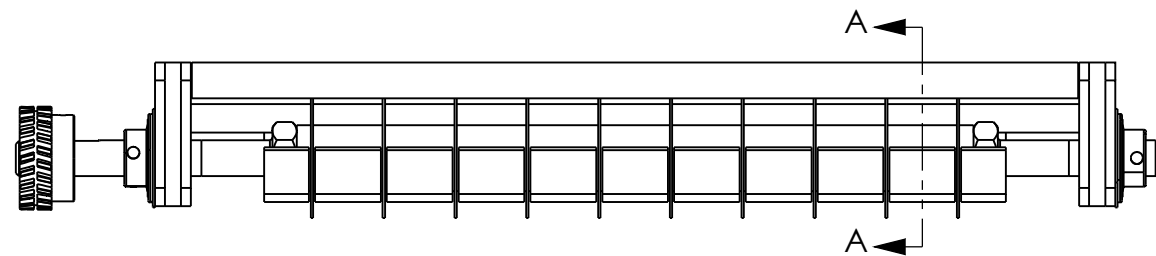
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DECIMALS .XXX----± .005 .XX----± .010

STOCK SIZE: SEE B.O.M.	
MATERIAL: SEE B.O.M.	FINISH: SEE B.O.M.
PATT NO:	ASSY NO: 150933
DESIGNED BY: LMG	TITLE: ROLLOVER CUTTER MODULE, 1.0" PITCH
DRAWN BY:	DRAWING NO: B-151028
CHECKED BY:	DATE: 7/30/2014

REV.	DESCRIPTION



NOTE:
INSTALL GREASE ZERK IN OUTSIDE PORT
INSTALL SCREW ON INSIDE PORT



ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	114808	PIN, DOWEL, 0.25"x0.75", SS	2
2	133867	HANDLE, ADJUSTABLE, 0.25"-20, SS	2
3	138671	BEARING, BALL, INSERT, .75"	2
4	150965	SPROCKET, DRIVEN, 22TH	1
5	151030	BLOCK, SLIDE	2
6	151034	CROSSBAR	1
7	151035	CROSSBAR, COMB	1
8	151038	COMB, 1.5" PITCH	1
9	151039	STRIP CUTTING WHEEL SHAFT	1
10	151042	CUTTING WHEEL SPACER, 1.5"	9
11	151043	CUTTING WHEEL	10
12	501170	NUT, 0.88"-14, HEX JAM, SS	2
13	AL-30813	LATTICE TOPPER CUTTING WHEEL SPACER	2

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LAKE FOREST, IL 60045

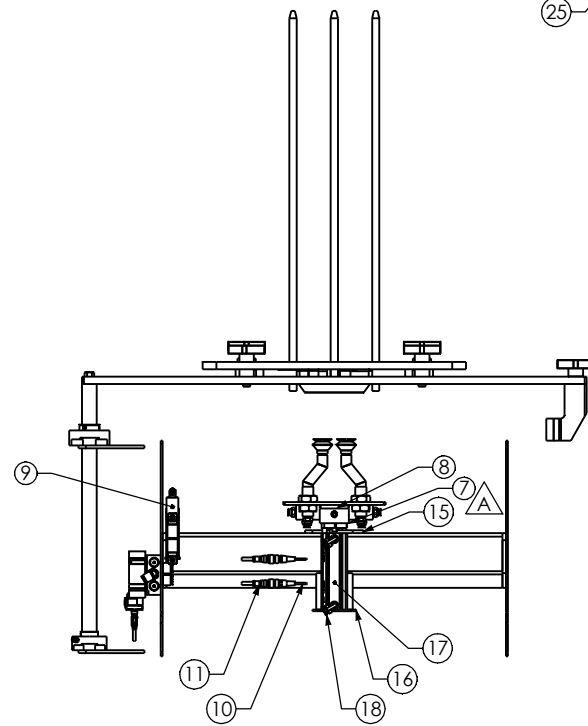
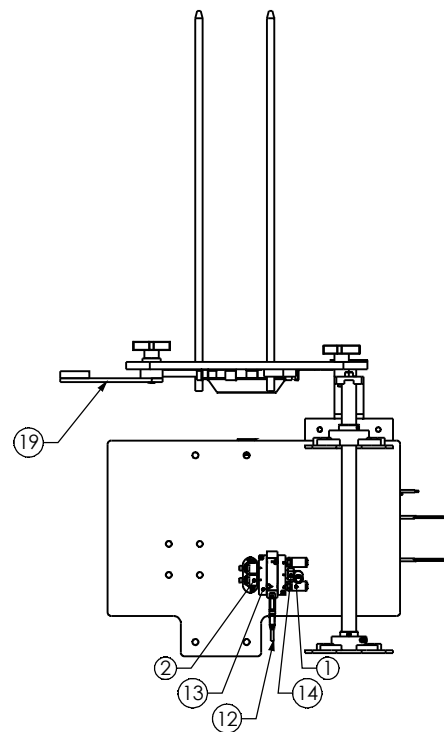
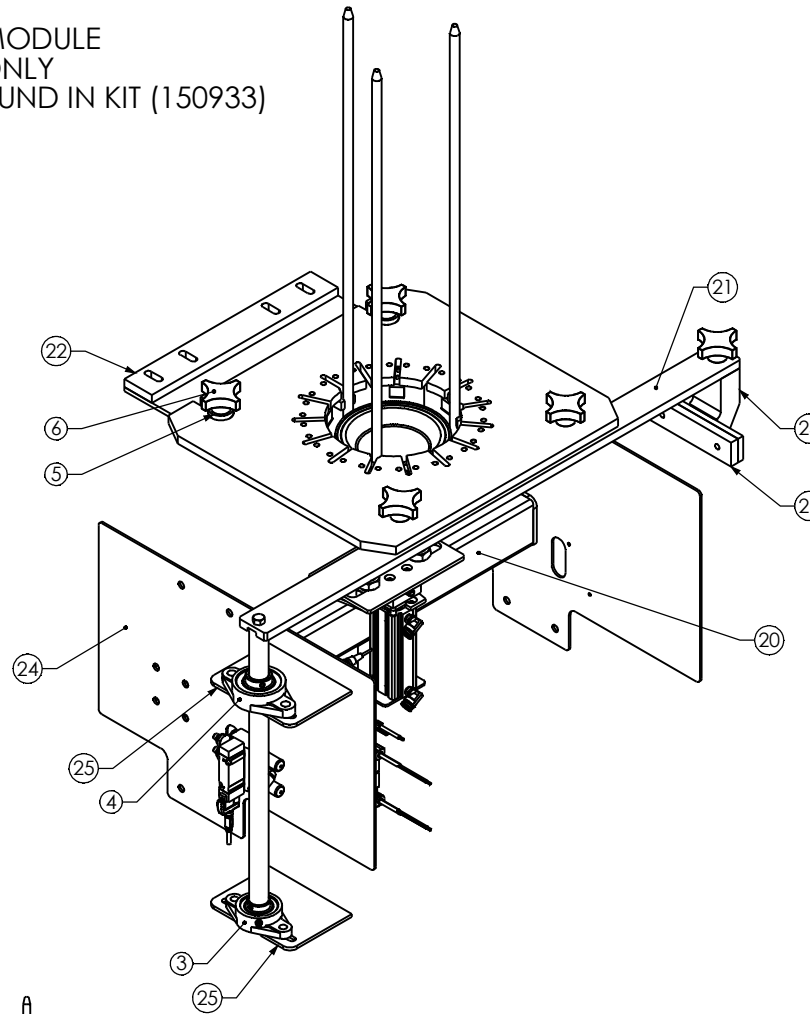
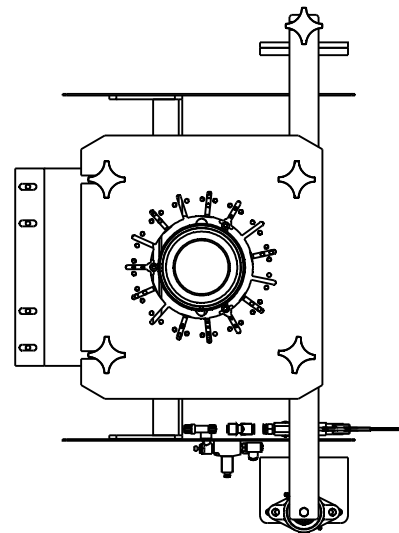
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DECIMALS .XXX----± .005 .XX----± .010

STOCK SIZE: SEE B.O.M.	
MATERIAL: SEE B.O.M.	FINISH: SEE B.O.M.
PATT NO:	ASSY NO: 150933
DESIGNED BY: LMG	TITLE: ROLLOVER CUTTER MODULE, 1.5" PITCH
DRAWN BY:	DRAWING NO: B-151029
CHECKED BY:	DATE: 7/30/2014
Sheet 1 of 1	

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REV.	DESCRIPTION

NOTE:
 MAGAZINE/VACUUM MODULE
 SHOWN FOR DISPLAY ONLY
 ALL CHANGE PARTS FOUND IN KIT (150933)



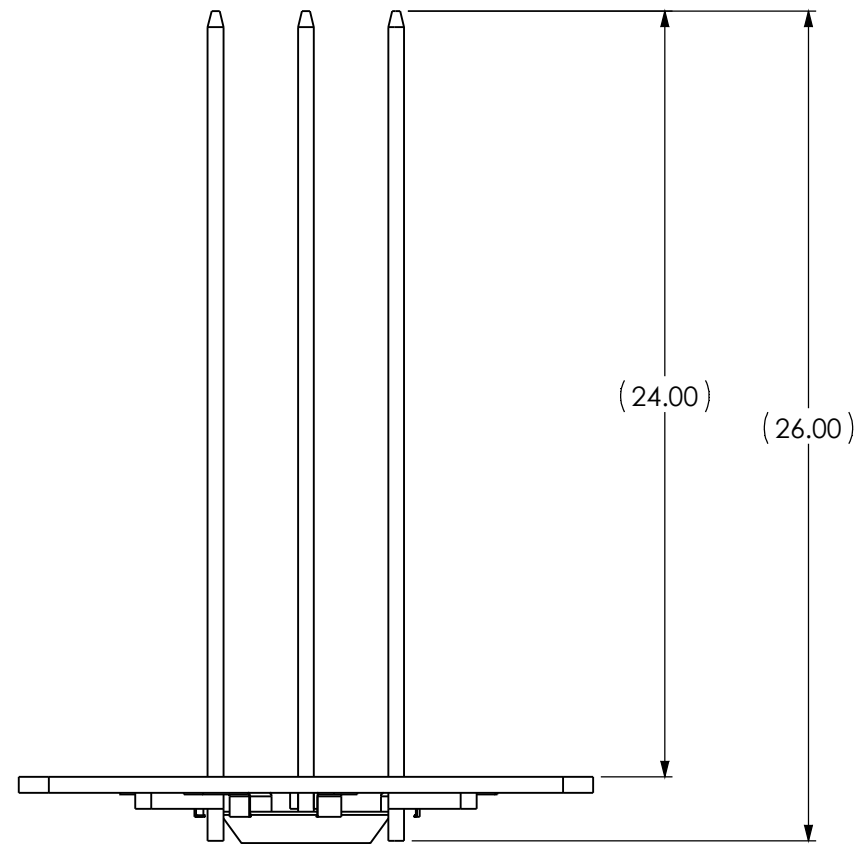
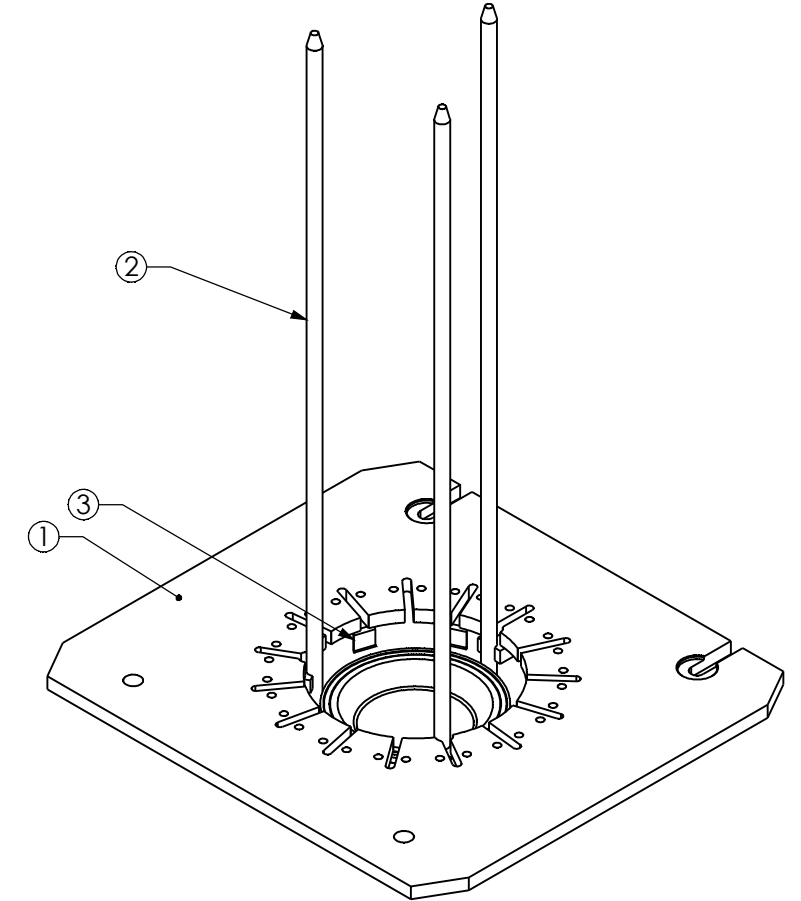
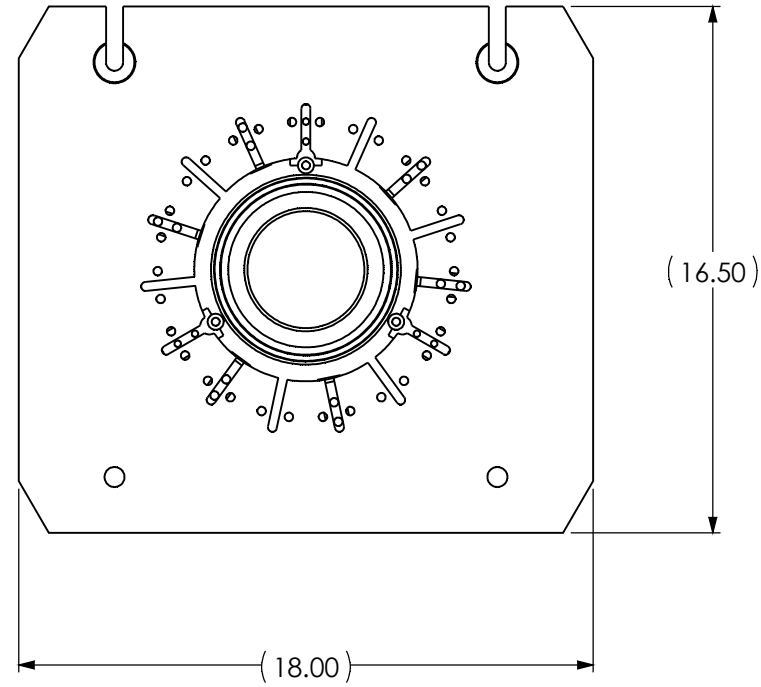
ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	104365	SILENCER, 0.25" NPT	2
2	106811	FITTING, FLOW CONTROL VALVE, 0.25" NPTx0.38", ELBOW	2
3	109965	BEARING, 2-BOLT FLANGE, 0.75" BORE	1
4	109972	BEARING, 2-BOLT FLANGE, 1.00" BORE	1
5	130593	WASHER	2
6	130640	ASSEMBLY, 1/2-13 KNOB SCREW	5
7	151239	BLOCK, YOKE	1
8	130828	PIN, QUICK RELEASE, 3/8 X 2.0	1
9	130933	ASSMEBL, VACUUM	1
10	130956	SWITCH, SOLID STATE, 4mm DIA. DIRECT MNT., PNP, .5m CABLE, M12 4-PIN CONNECTOR	2
11	139229	CORDSET, 4 PIN FEMALE, STRAIGHT, M12, W/ 5m PVC-OB, MURR	2
12	139231	CORDSET, 3P FEMALE, STRAIGHT, M8, W/ 3m PVC-OB, MURR	1
13	141620	VALVE, SOLENOID, SINGLE, 24VDC, 0.25" NPTF, M8	1
14	141621	FITTING, ELBOW, SWIVEL, 0.38" TUBE x 0.25" NPT	1
15	151016	CYLINDER BRACKET, TOP	1
16	151017	CYLINDER BRACKET, BOTTOM	1
17	151018	CYLINDER, 32mm BORE, 100mm STROKE, GUIDED	1
18	151027	FITTING, ELBOW, SWIVEL, SS, 0.38" TUBE x 0.13" NPT	2
19	151049	PLATE, MOUNT, DISCHARGE	1
20	151059	WELDMENT, DENESTER	1
21	151063	WELDMENT, MAGAZINE SUPPORT	1
22	151069	WELD BAR, MAG. BRACKET	1
23	151070	WELDMENT, CLAMP POST	1
24	151071	GUARD, REAR INNER	2
25	151072	WELDPLATE, BEARING	2
26	151073	WELDBAR, POST	1

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A	DCR-2014-262-LMG, 8/22/2014, REPLACED YOLK 130691 WITH 151239
REV.	DESCRIPTION

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LAKE FOREST, IL 60045	
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DECIMALS .XXX--- ± .005 .XX--- ± .010	
STOCK SIZE: SEE B.O.M.	
MATERIAL: SEE B.O.M.	FINISH: SEE B.O.M.
PART NO: 151072	ASSY NO: 141479
DESIGNED BY: LMG	TITLE: ASSEMBLY, DENESTER
DRAWN BY:	DRAWING NO: C-151045
CHECKED BY:	DATE: 7/31/2014
Sheet 1 of 2	

ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	151052	PLATE, FEEDER, 6" PAN	1
2	151074	WEDMENT, SUPPORT ROD	3
3	135991	PIN, STRIPPER	6



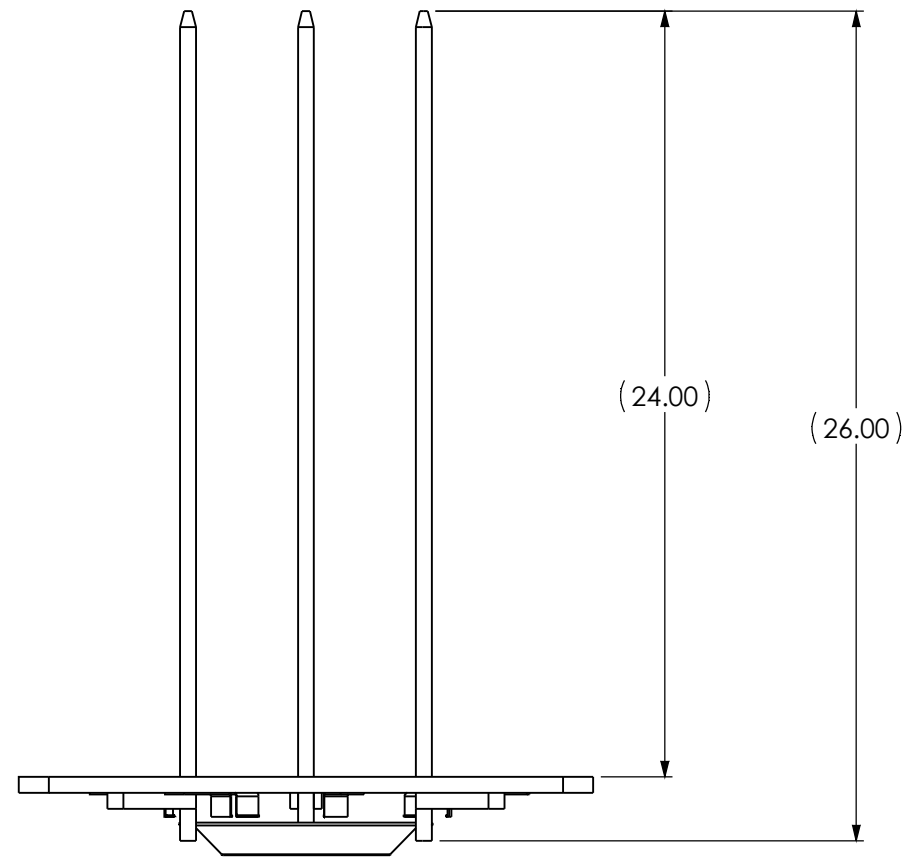
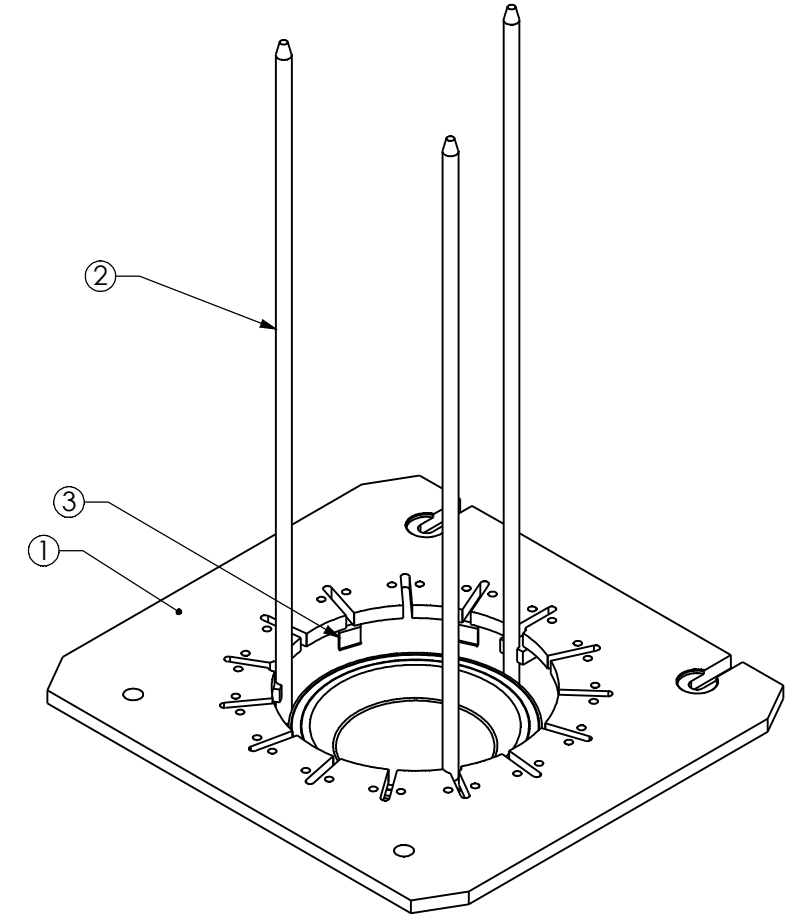
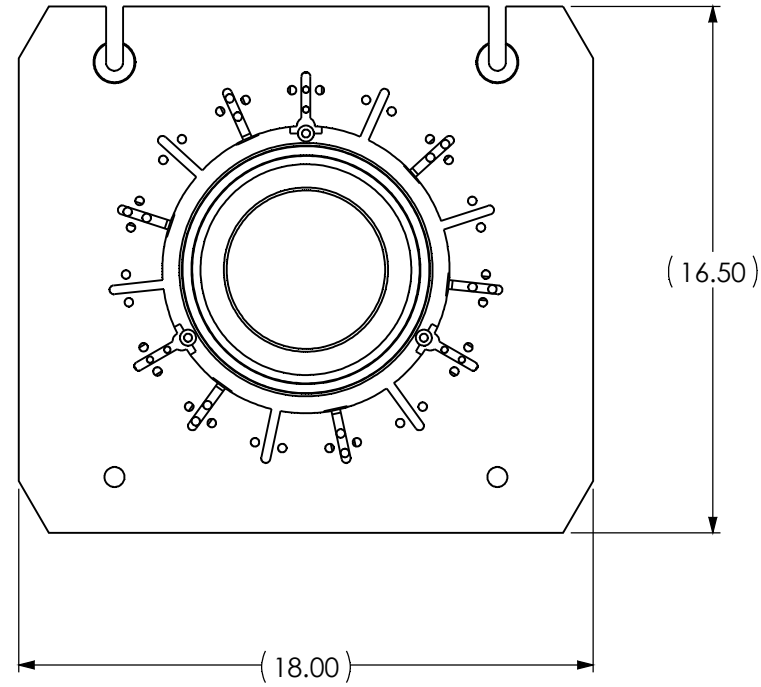
COLBORNE FOOTBOTICS, LLC
LAKE FOREST, IL 60045

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DECIMALS .XXX ---- ± .005 .XX ---- ± .010

STOCK SIZE: SEE B.O.M.	
MATERIAL: SEE B.O.M.	FINISH: SEE B.O.M.
PATT NO:	ASSY NO: 150933
DESIGNED BY: LMG	TITLE: ASSEMBLY, DISPENSER, 6" PAN
DRAWN BY:	DRAWING NO: B-151051
CHECKED BY:	DATE: 8/5/2014

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ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	151054	PLATE, FEEDER, 8" PAN	1
2	151074	WEDMENT, SUPPORT ROD	3
3	135991	PIN, STRIPPER	6



COLBORNE FOOTBOTICS, LLC

LAKE FOREST, IL 60045

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 DECIMALS .XXX ---- ± .005 .XX ---- ± .010

STOCK SIZE: SEE B.O.M.

MATERIAL: SEE B.O.M. FINISH: SEE B.O.M.

PATT NO: ASSY NO: 150933

DESIGNED BY: LMG TITLE: ASSEMBLY, DISPENSER, 8" PAN

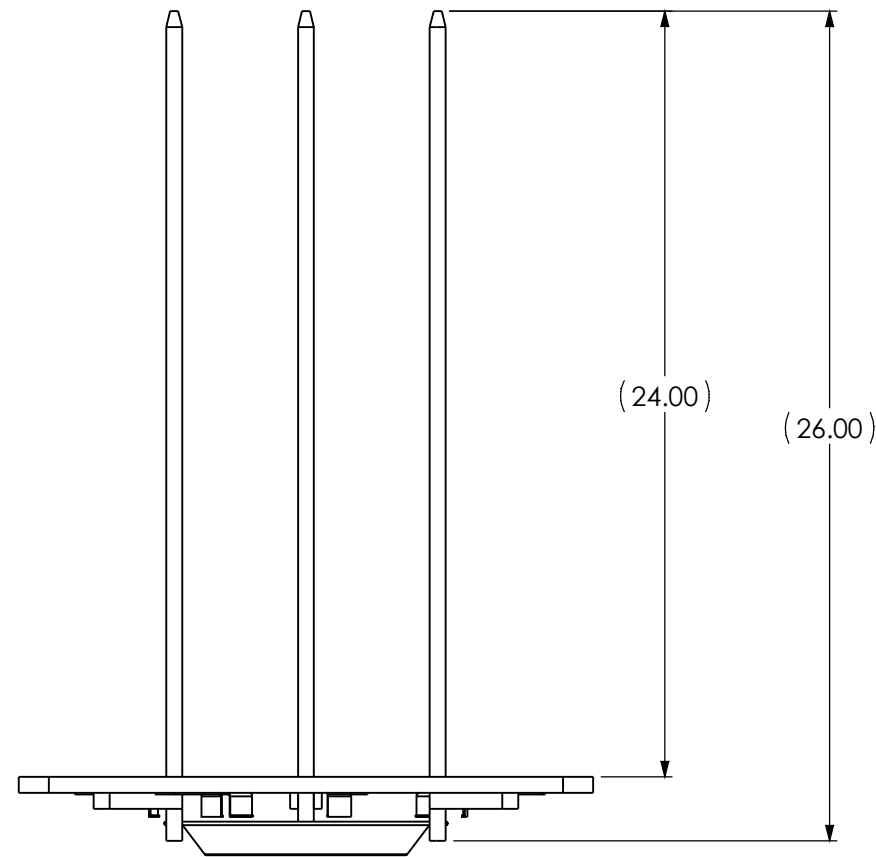
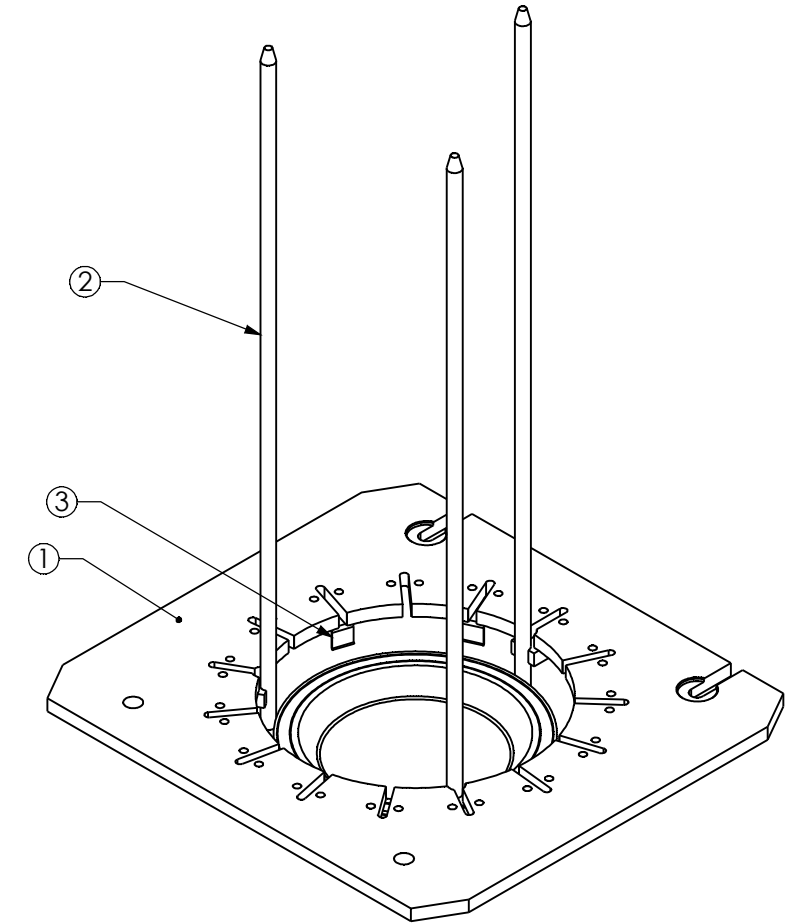
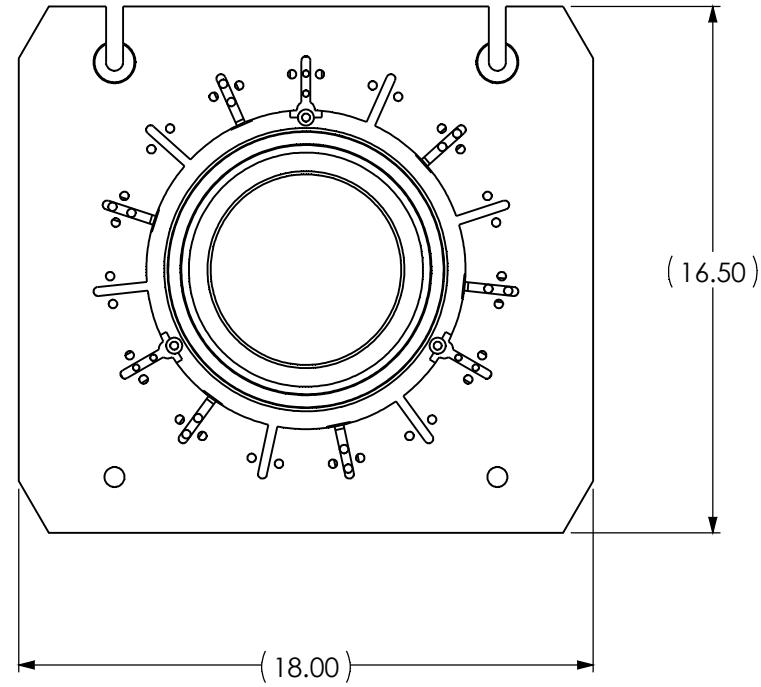
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DATE: 8/5/2014 Sheet 1 of 1

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REV.	DESCRIPTION

ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	151056	PLATE, FEEDER, 9" PAN	1
2	151074	WEDMENT, SUPPORT ROD	3
3	135991	PIN, STRIPPER	6



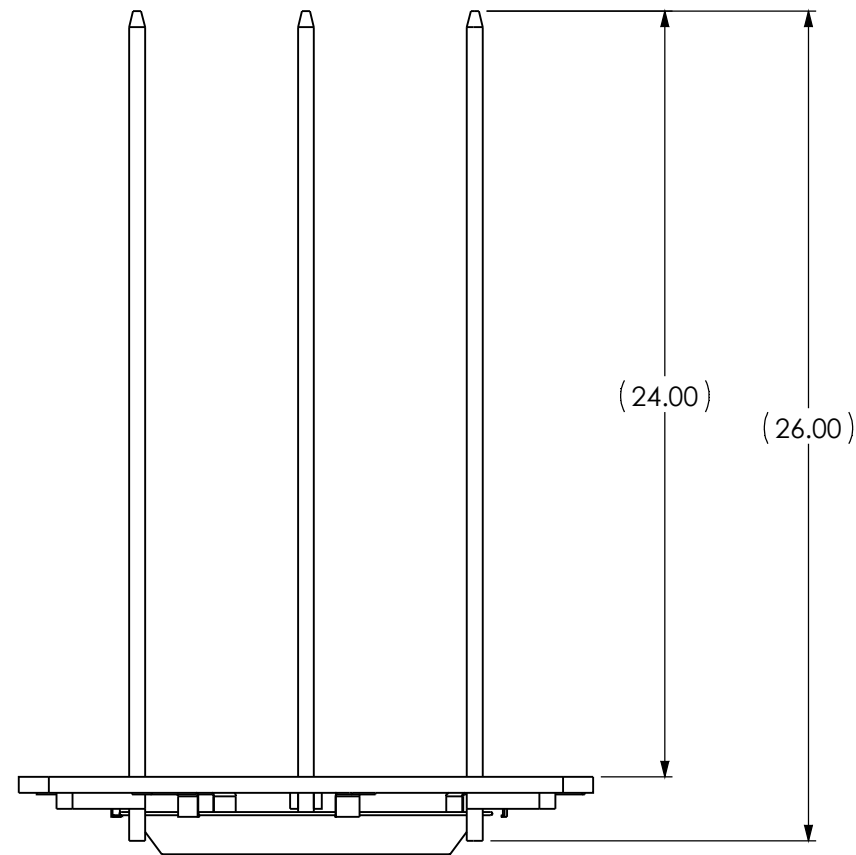
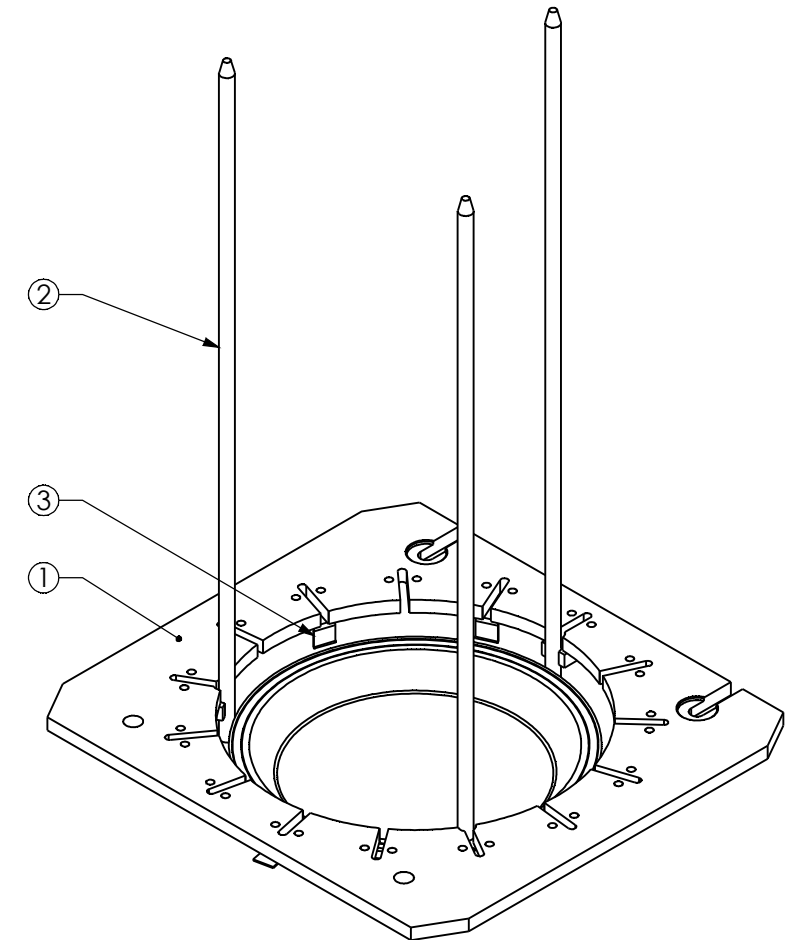
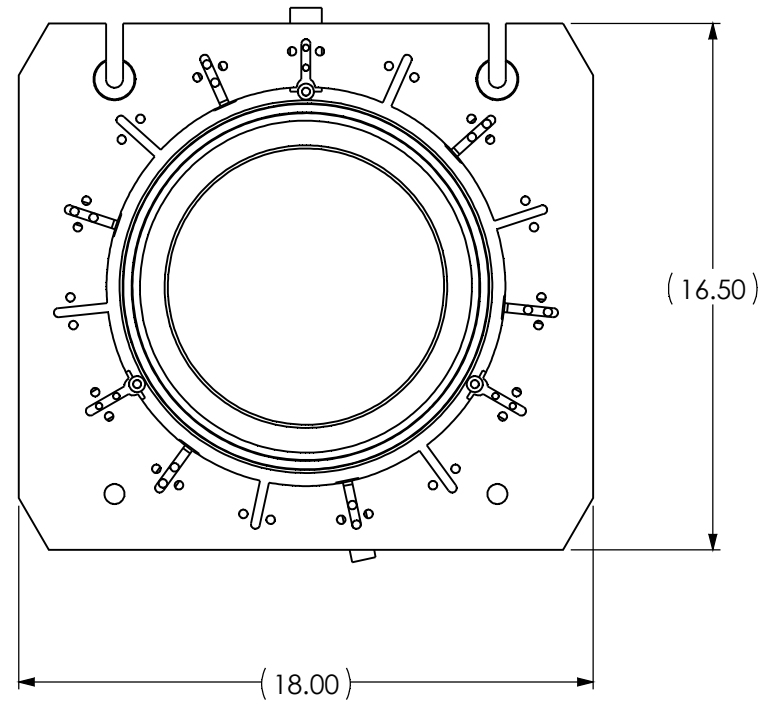
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LAKE FOREST, IL 60045

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DECIMALS .XXX ---- ± .005 .XX ---- ± .010

STOCK SIZE: SEE B.O.M.	
MATERIAL: SEE B.O.M.	FINISH: SEE B.O.M.
PATT NO:	ASSY NO: 150933
DESIGNED BY: LMG	TITLE: ASSEMBLY, DISPENSER, 9" PAN
DRAWN BY:	DRAWING NO: B-151055
CHECKED BY:	DATE: 8/5/2014

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ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	151058	PLATE, FEEDER, 12"	1
2	151074	WEDMENT, SUPPORT ROD	3
3	135991	PIN, STRIPPER	6



COLBORNE FOOTBOTICS, LLC

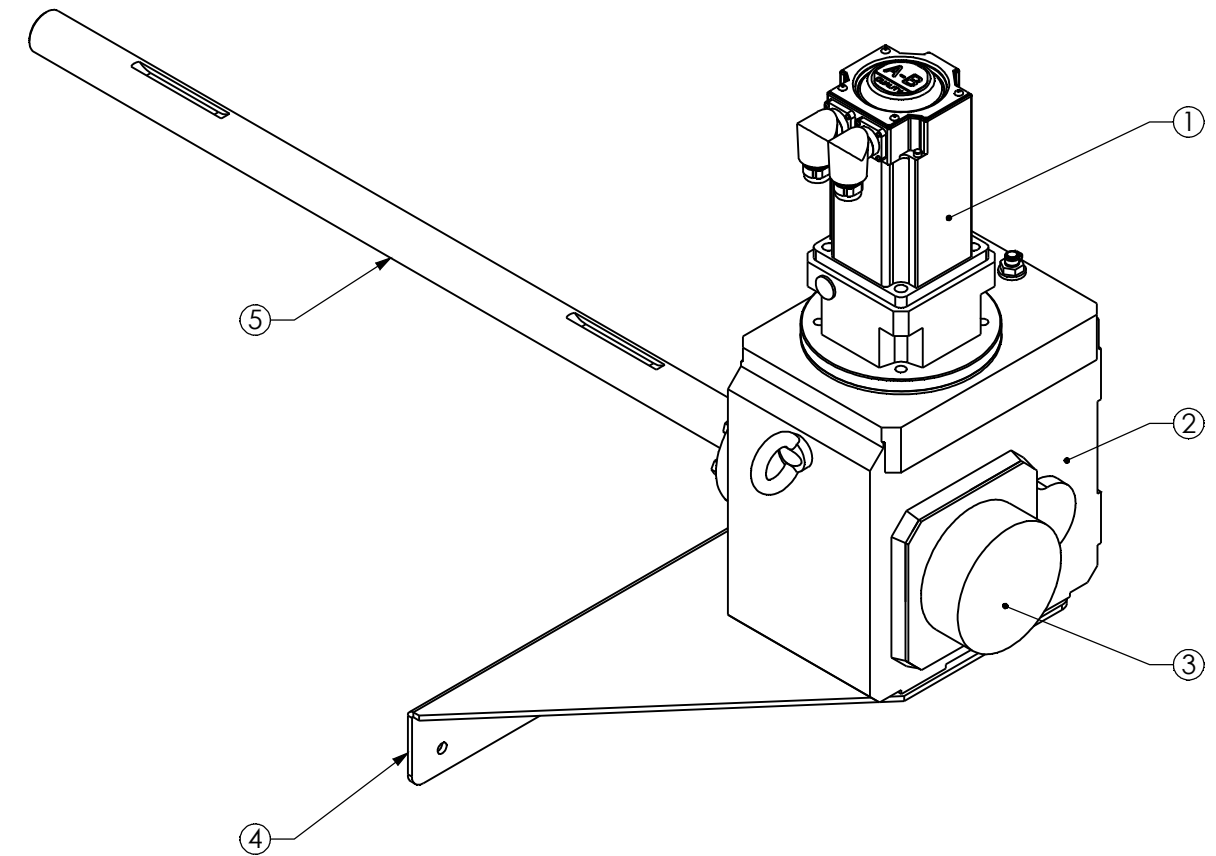
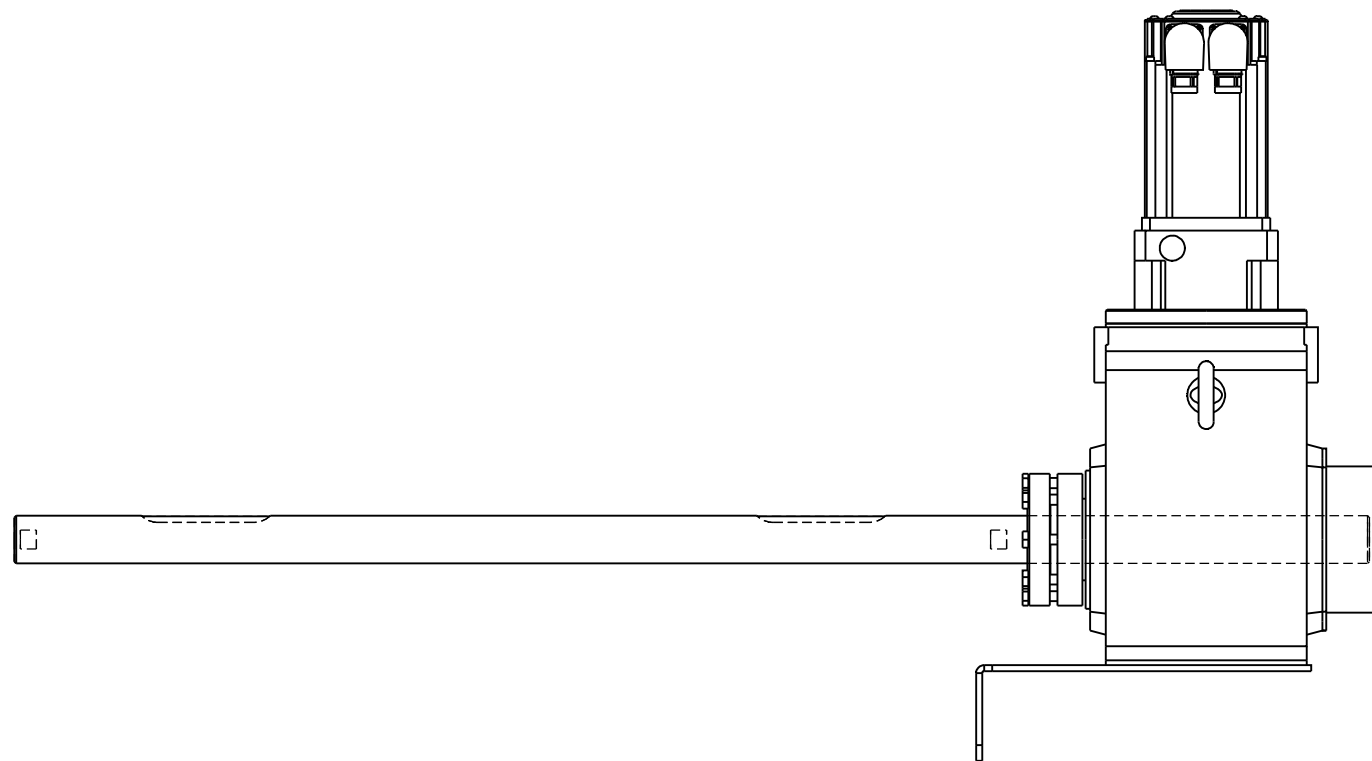
LAKE FOREST, IL 60045

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 DECIMALS .XXX ---- ± .005 .XX ---- ± .010

STOCK SIZE: SEE B.O.M.	
MATERIAL: SEE B.O.M.	FINISH: SEE B.O.M.
PATT NO:	ASSY NO: 150933
DESIGNED BY: LMG	TITLE: ASSEMBLY, DISPENSER, 12"
DRAWN BY:	DRAWING NO: B-151057
CHECKED BY:	DATE: 8/5/2014

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ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	121164	MOTOR, 58 lb-in, 5000 RPM	1
2	151065	REDUCER, 65.54:1	1
3	151066	BUSHING COVER	1
4	151067	BRACKET, NE SERVO	1
5	151068	SHAFT, CONVEYOR DRIVE, SERVO	1



COLBORNE FOOTBOTICS, LLC

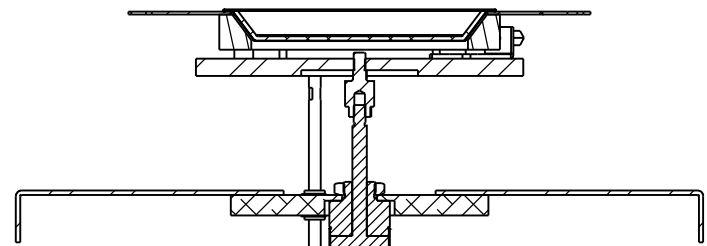
LAKE FOREST, IL 60045

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 DECIMALS .XXX----± .005 .XX----± .010

STOCK SIZE: SEE B.O.M.	
MATERIAL: SEE B.O.M.	FINISH: SEE B.O.M.
PATT NO:	ASSY NO: 141479
DESIGNED BY: LMG	TITLE: SERVO DRIVE, NE
DRAWN BY:	
CHECKED BY:	DRAWING NO: B-151064
DATE: 8/5/2014	Sheet 1 of 1

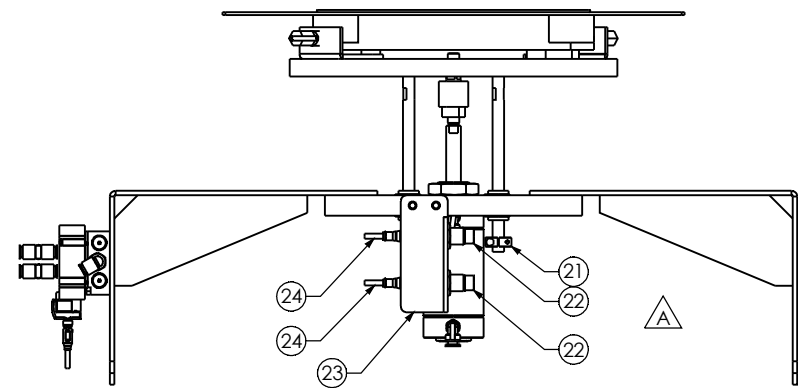
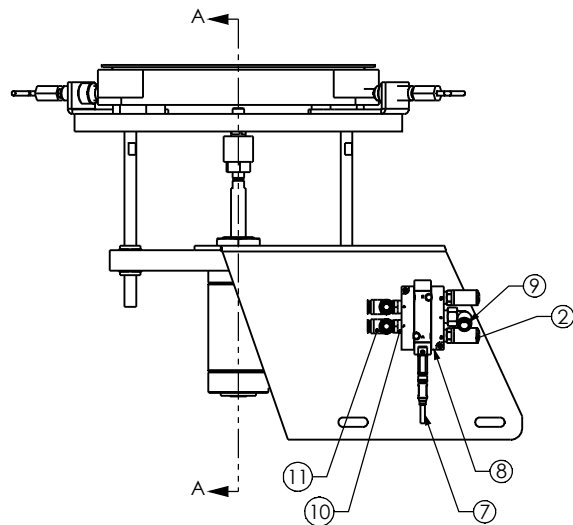
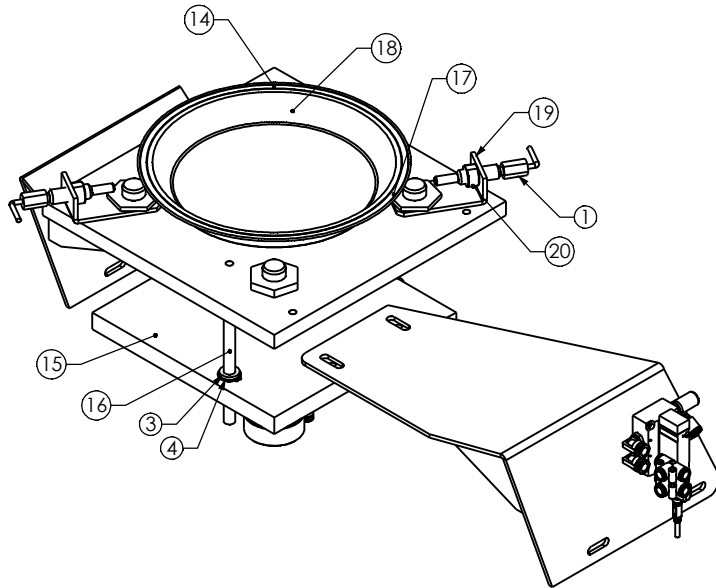
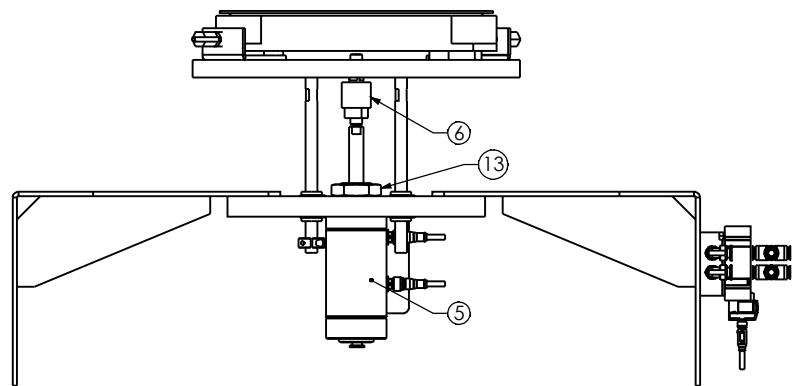
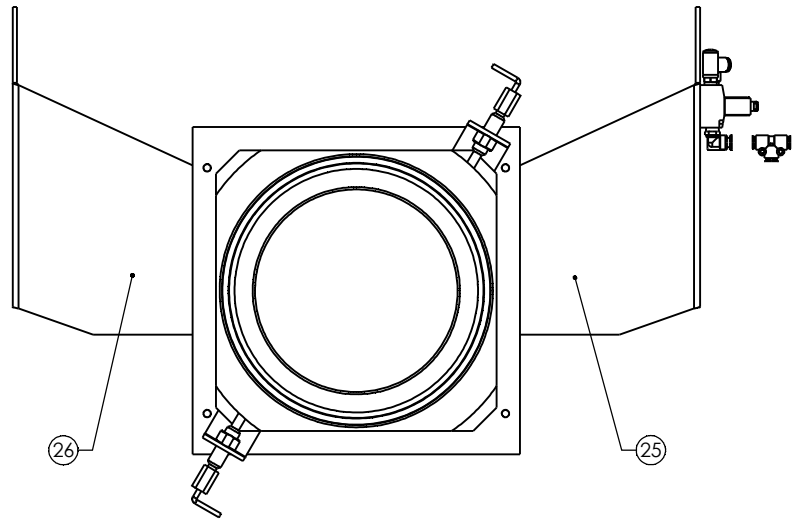
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REV.	DESCRIPTION



SECTION A-A

NOTE:
CUT OFF END OF CYLINDER
AT ASSEMBLY



ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	103548	PLUNGER, RETRACTABLE	2
2	104365	SILENCER, 0.25" NPT	2
3	107332	BEARING, LINEAR	2
4	107337	RING, RETAINING 0.88" SHAFT	4
5	110136	PISTON, 2.50" BORE, 2.00" STROKE, DOUBLE ACTING	1
6	110491	COUPLER, ALIGNMENT, NICKEL PLATED	1
7	139231	CORDSET, 3P FEMALE, STRAIGHT, M8, W/ 3m PVC-OB, MURR	1
8	141620	VALVE, SOLENOID, SINGLE, 24VDC, 0.25" NPT, M8	1
9	141621	FITTING, ELBOW, SWIVEL, 0.38" TUBE x 0.25" NPT	1
10	150583	FITTING, STRAIGHT, SS, 0.38" TUBE x 0.25" NPT	4
11	150588	FITTING, TEE, 0.38" TUBE	2
12	151207	FLOW CONTROL, INLINE, 0.38" TUBE	4
13	151208	NUT, 1.38"-12 (CYL MTG 2.50") SS	1
14	151211	PLATE, LIFT	1
15	151212	PLATE, CYLINDER	1
16	151213	ROD, TRIMMER BACKUP GUIDE	2
17	AT-61023-1	PIN, ALIGNING, 1.192"	2
18	AT-61023-2	PIN, ALIGNING, 1.379"	2
19	AT-61024	BRACKET, PLUNGER	2
20	AT-61025	NUT, PLUNGER, 1.00" x 0.62	2
21	101345	COLLAR, 0.50 BORE, 2-PIECES	1
22	138150	SENSOR, PROXIMITY, 18MM BODY, 12MM RANGE, 3-WIRE DC PNP, N.O., MICRO CONNECTOR	2
23	151243	BRACKET, BACKUP DETECTION	1
24	139229	CORDSET, 4 PIN FEMALE, STRAIGHT, M12, W/ 5m PVC-OB, MURR	2
25	151214	PLATE, SUPPORT, RH	1
26	151215	PLATE, SUPPORT, LH	1

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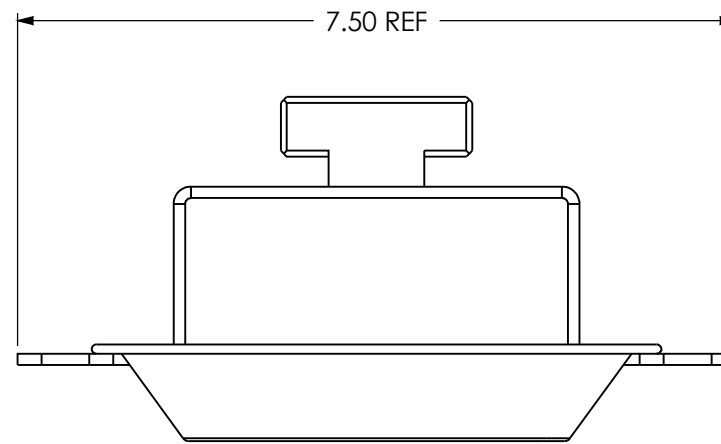
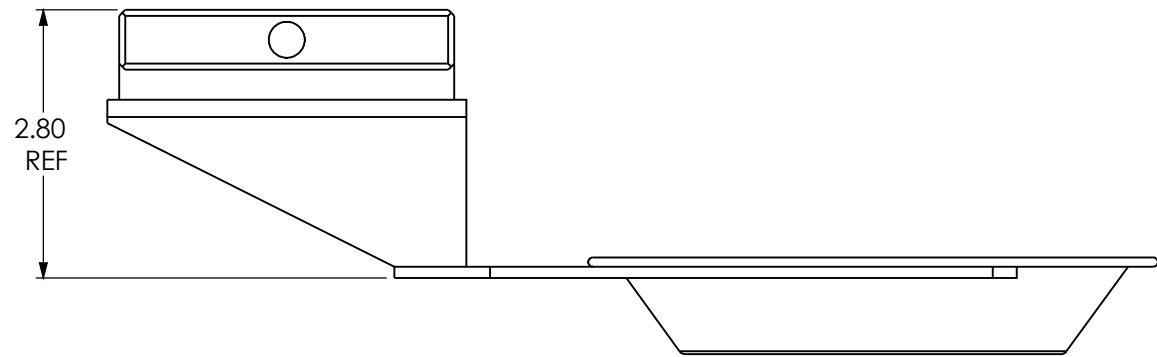
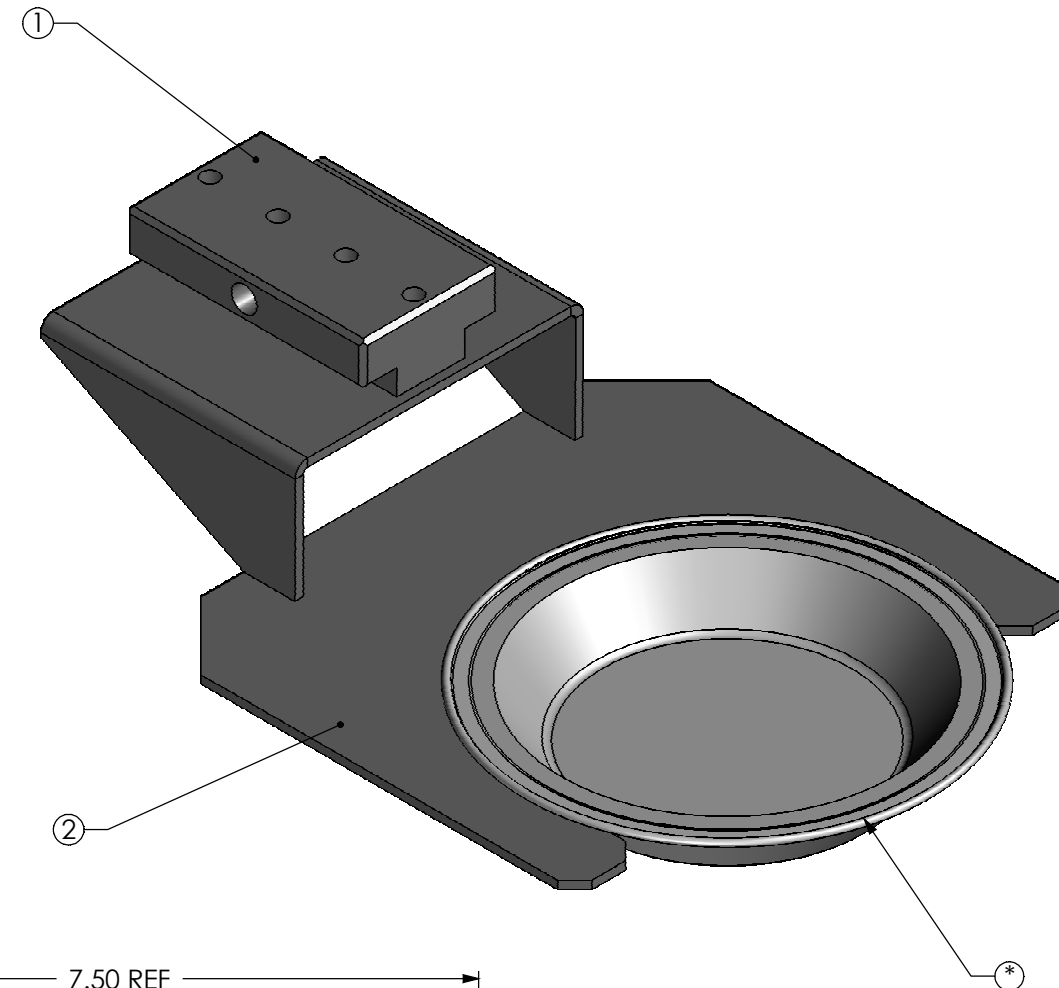
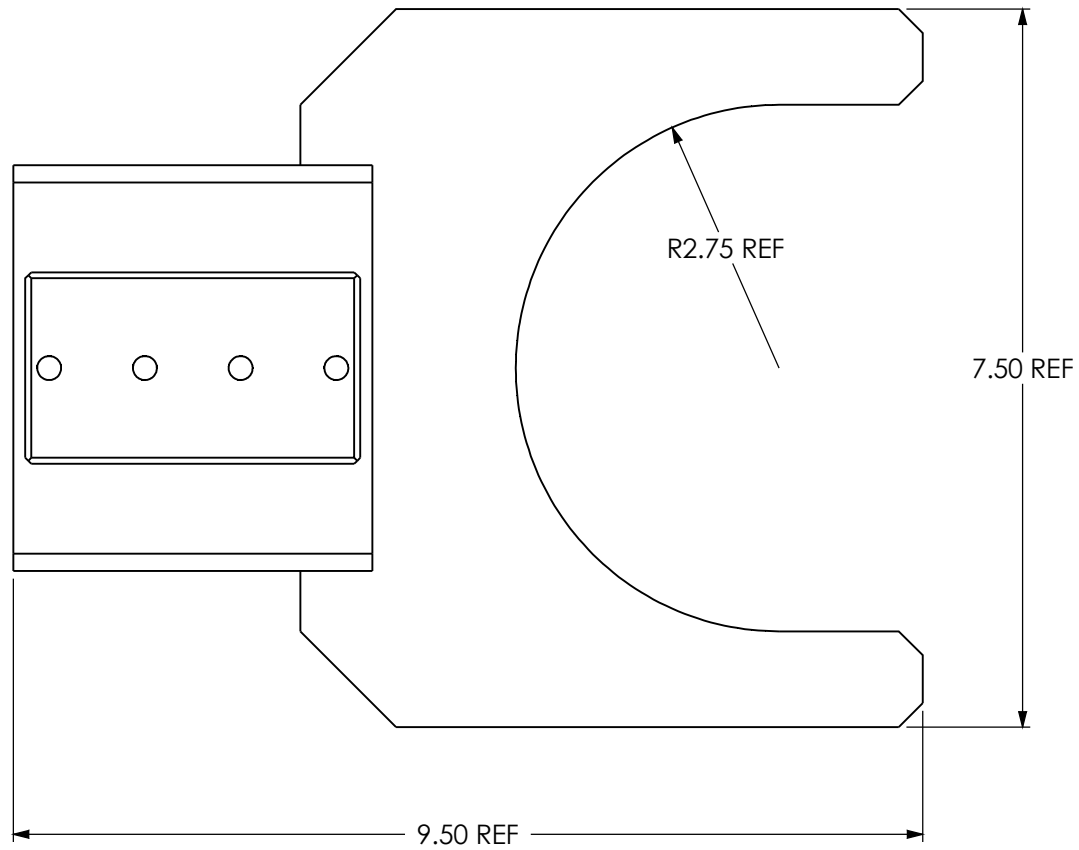
REV.	DESCRIPTION
A	DCR-2014-263-LMG, 8/22/2014, ADDED SENSORS TO DETECT POSITION (UP/DOWN)

COLBORNE FOOTBOTICS, LLC
LAKE FOREST, IL 60045
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DECIMALS .XXX ± .005 .XX ± .010

STOCK SIZE: SEE B.O.M.
MATERIAL: SEE B.O.M. FINISH: SEE B.O.M.
PART NO: 141479
DESIGNED BY: LMG TITLE: ASSEMBLY, TRIMMER BACKUP
DRAWN BY: DRAWING NO: C-151210
CHECKED BY: DATE: 8/20/2014

Sheet 1 of 1

ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	130711	KEY	1
2	151230	OFFLOAD, WELDMENT, 6" NEW ENGLAND	1



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LAKE FOREST, IL 60045

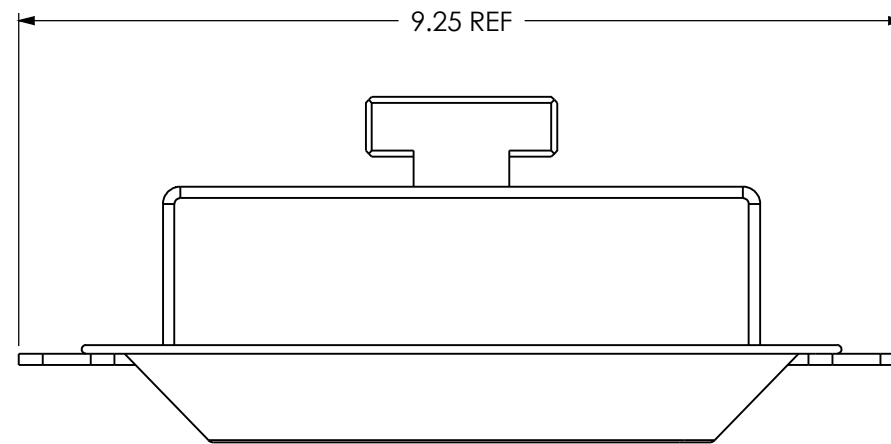
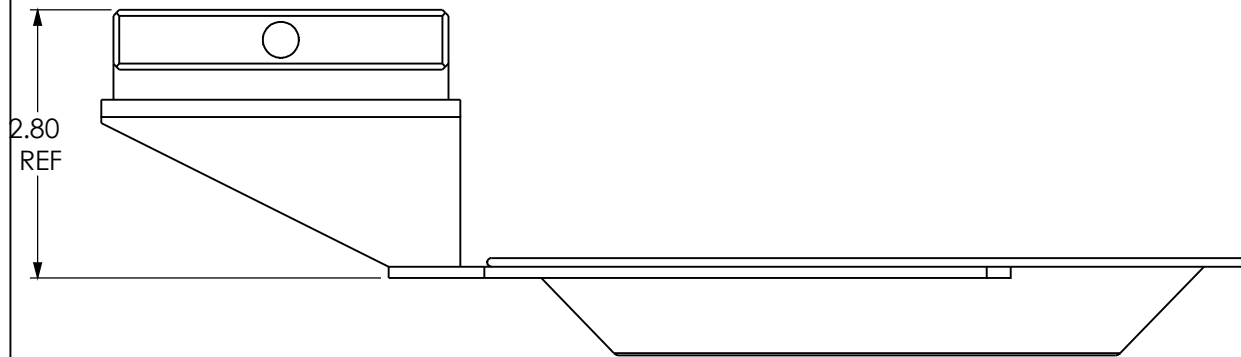
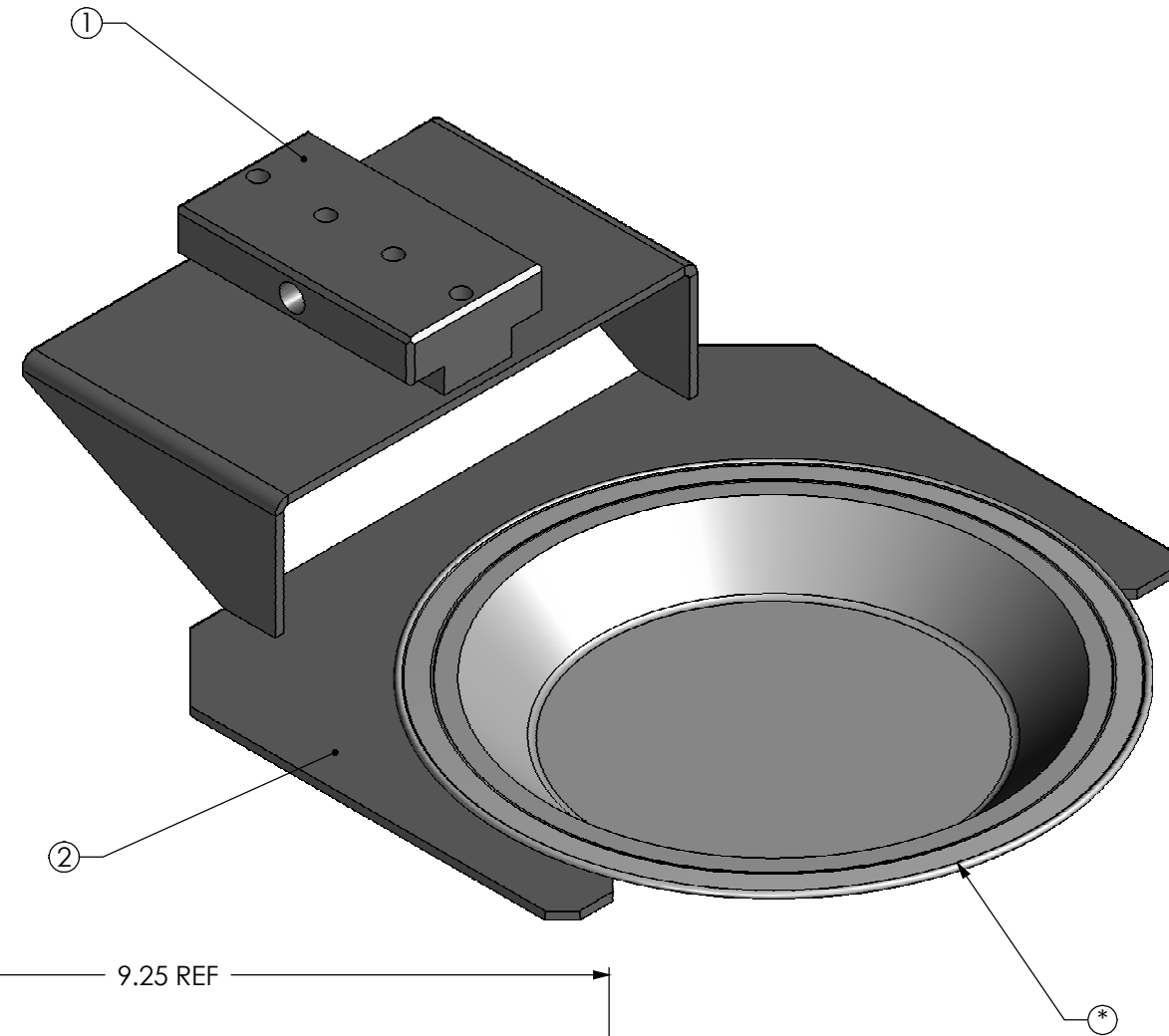
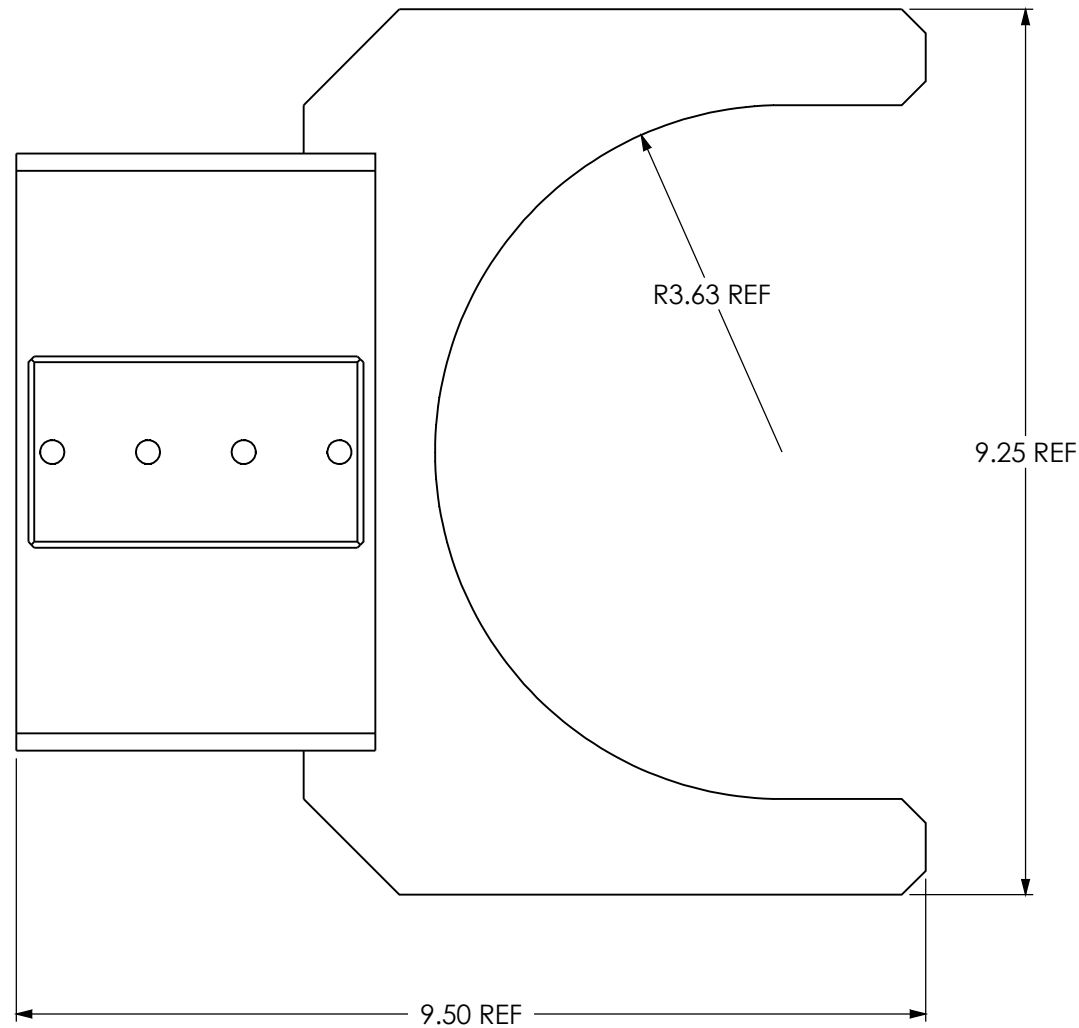
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DECIMALS .XXX----± .005 .XX----± .010

STOCK SIZE: SEE B.O.M.	
MATERIAL: SEE B.O.M.	FINISH: SEE B.O.M.
PATT NO:	ASSY NO: 150933
DESIGNED BY: LMG	TITLE: ASSEMBLY, TOOL, OFFLOAD, 6" NEW ENGLAND
DRAWN BY:	DRAWING NO: B-151229
CHECKED BY:	DATE: 8/21/2014

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REV.	DESCRIPTION

ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	130711	KEY	1
2	151232	OFFLOAD, WELDMENT, 8" NEW ENGLAND	1



COLBORNE FOOTBOTICS, LLC
LAKE FOREST, IL 60045

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MACHINING TOLERANCES UNLESS SPECIFIED:
FRACTION ± 1/64 ANGLES ± 1°
DECIMALS .XXX----± .005 .XX----± .010

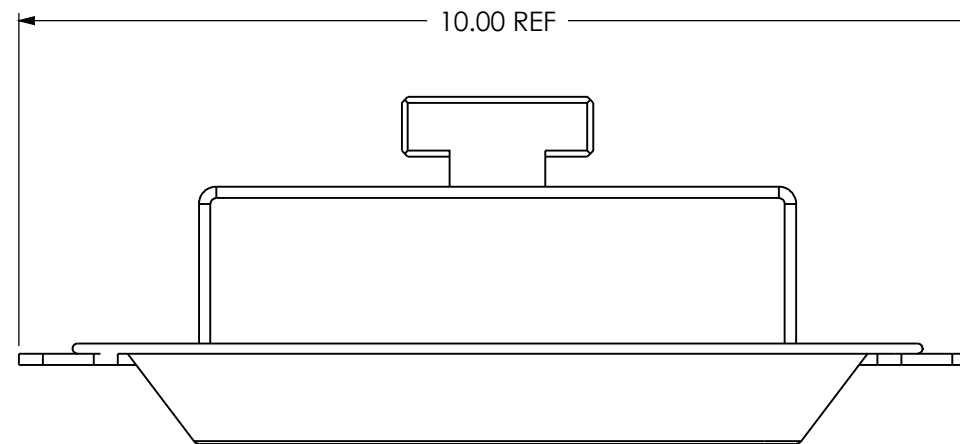
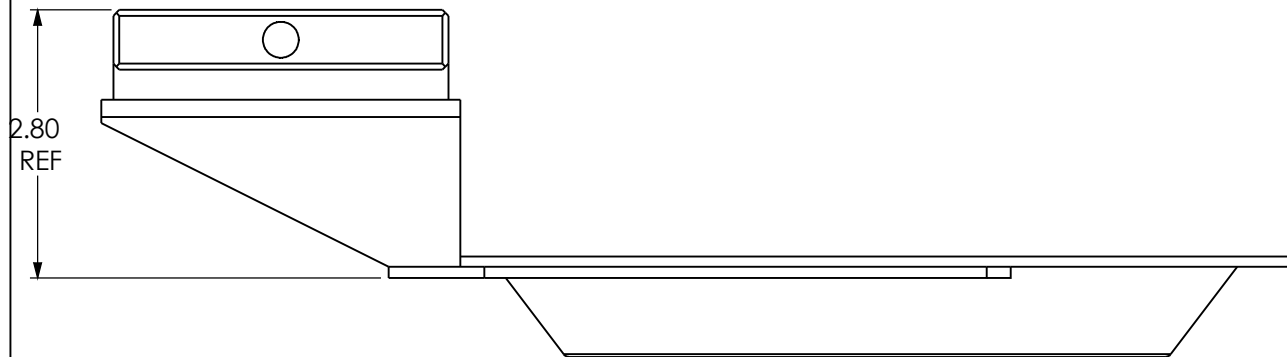
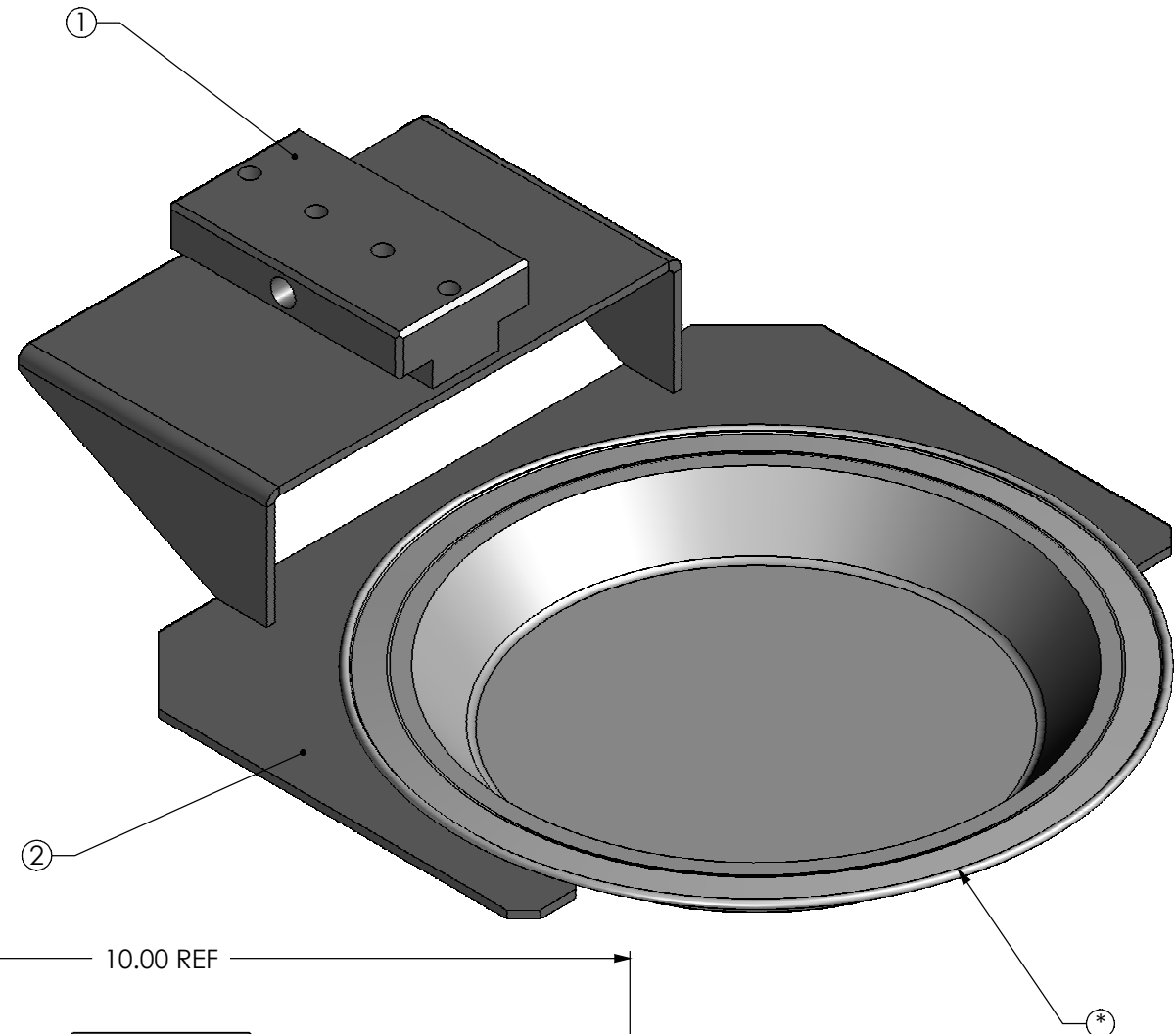
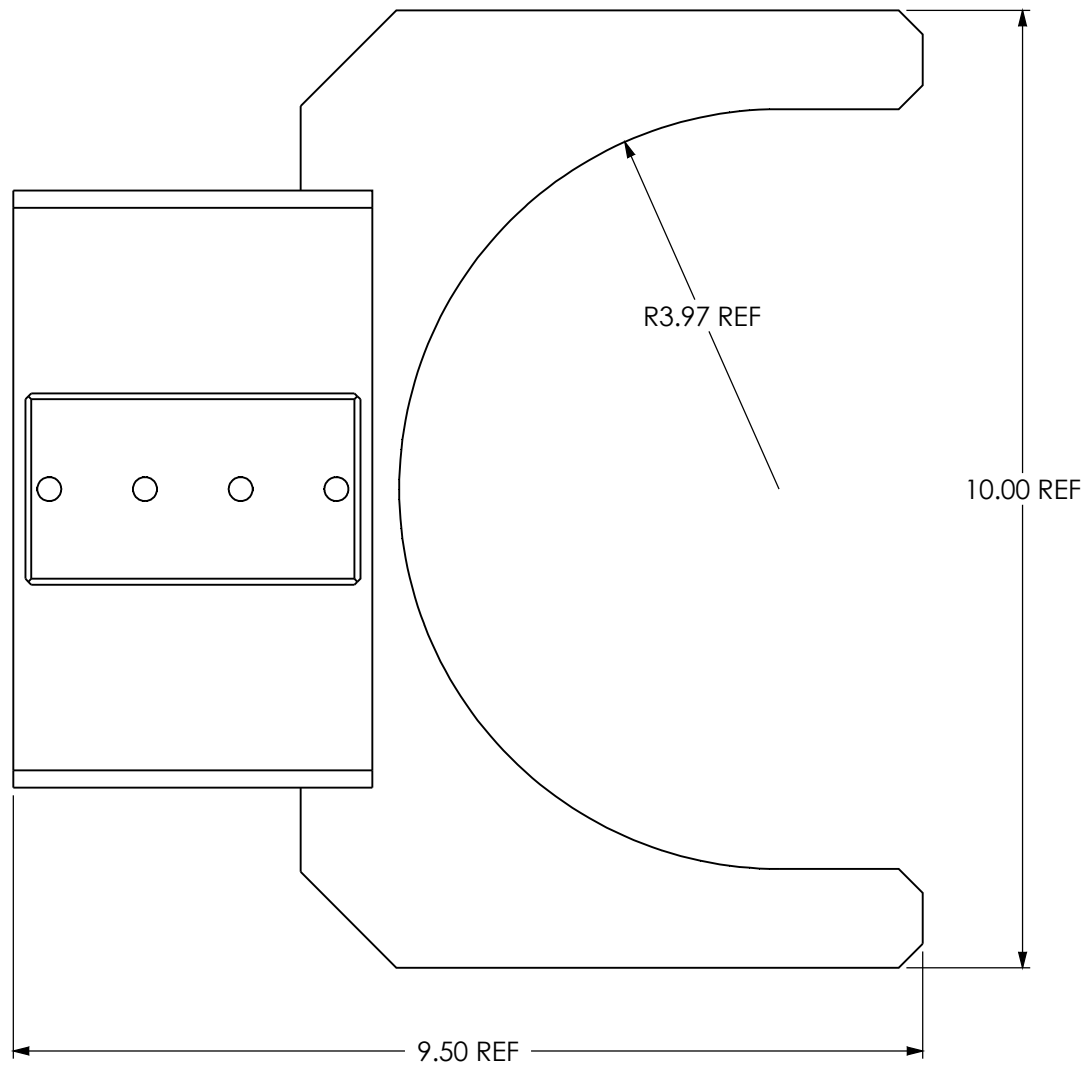
STOCK SIZE: SEE B.O.M.	
MATERIAL: SEE B.O.M.	FINISH: SEE B.O.M.
PATT NO:	ASSY NO: 150933
DESIGNED BY: LMG	TITLE: ASSEMBLY, TOOL, OFFLOAD, 8" NEW ENGLAND
DRAWN BY:	DRAWING NO: B-151231
CHECKED BY:	DATE: 8/21/2014

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NOTE:
PART NO. TO BE PERMANENTLY
MARKED (STAMPED OR ETCHED)
ON SURFACE AS SHOWN.

REV.	DESCRIPTION

ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	130711	KEY	1
2	151234	OFFLOAD, WELDMENT, 9" NEW ENGLAND	1



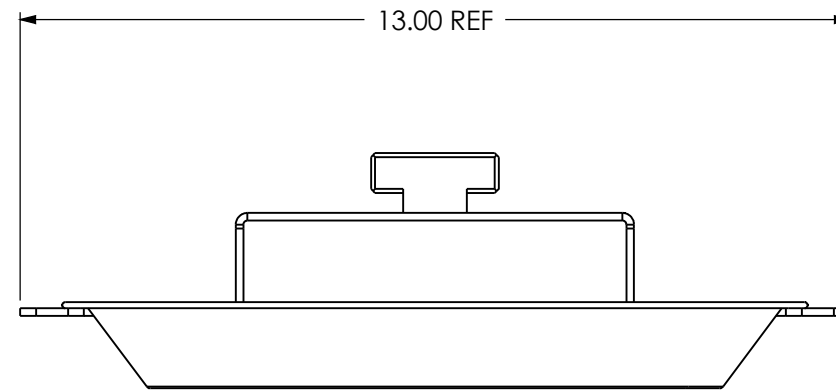
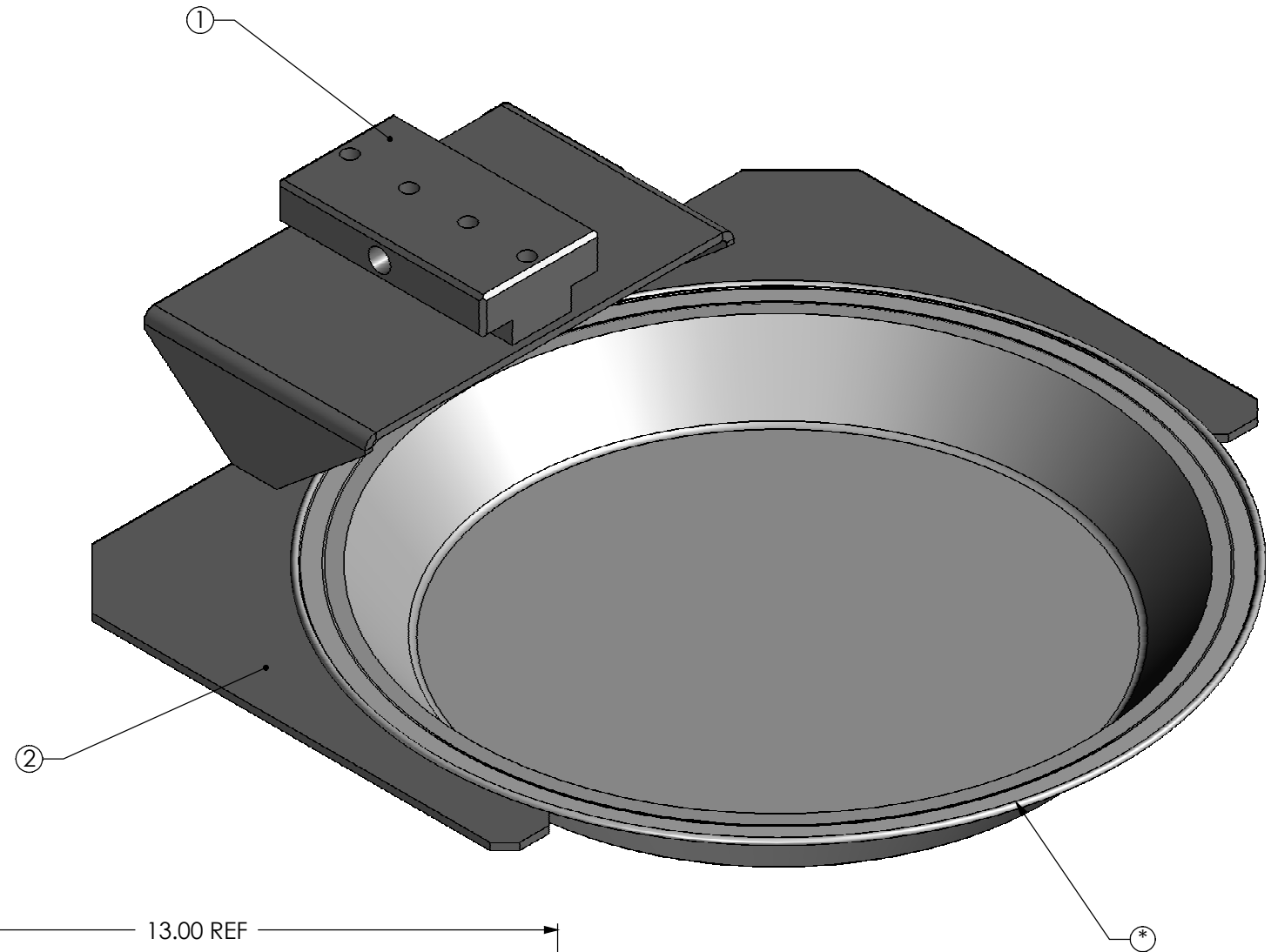
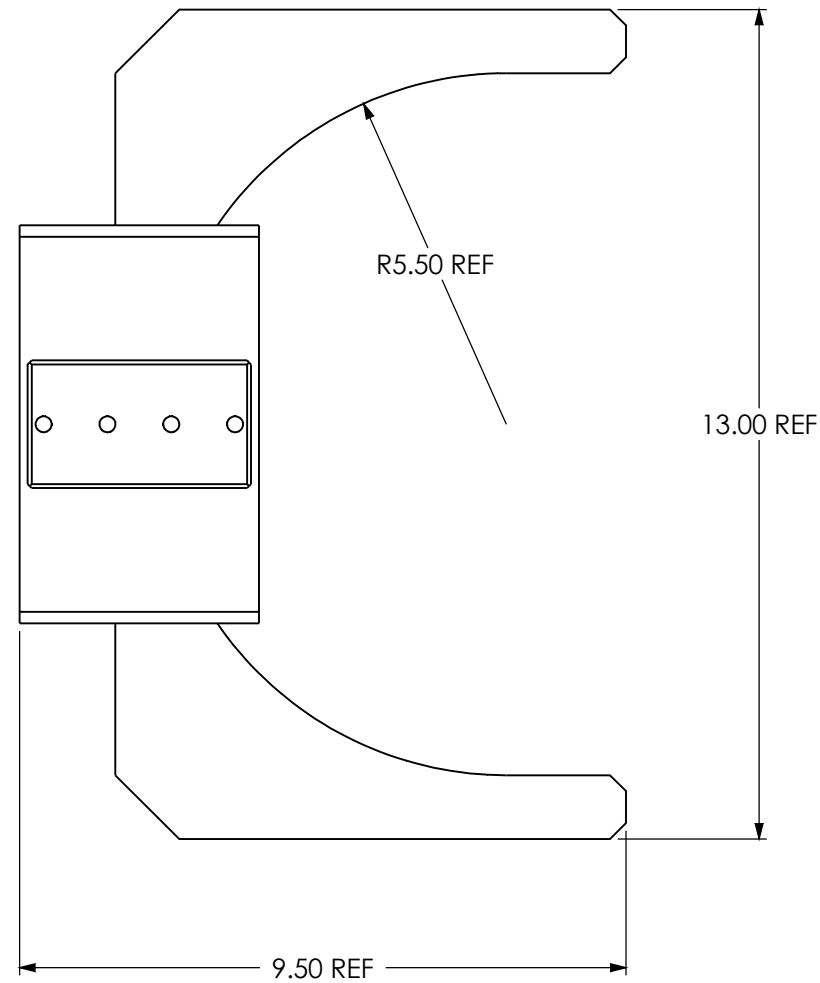
COLBORNE FOOTBOTICS, LLC LAKE FOREST, IL 60045	
DO NOT SCALE DRAWING MACHINING TOLERANCES UNLESS SPECIFIED: FRACTION ± 1/64 ANGLES ± 1° DECIMALS .XXX---± .005 .XX---± .010	
STOCK SIZE: SEE B.O.M.	
MATERIAL: SEE B.O.M.	FINISH: SEE B.O.M.
PATT NO:	ASSY NO: 150933
DESIGNED BY: LMG	TITLE: ASSEMBLY, TOOL, OFFLOAD, 9" NEW ENGLAND
DRAWN BY:	DRAWING NO: B-151233
CHECKED BY:	DATE: 8/21/2014
Sheet 1 of 1	

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ON SURFACE AS SHOWN.

REV.	DESCRIPTION

ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	130711	KEY	1
2	151236	OFFLOAD, WELDMENT, 12" NEW ENGLAND	1



COLBORNE FOOTBOTICS, LLC

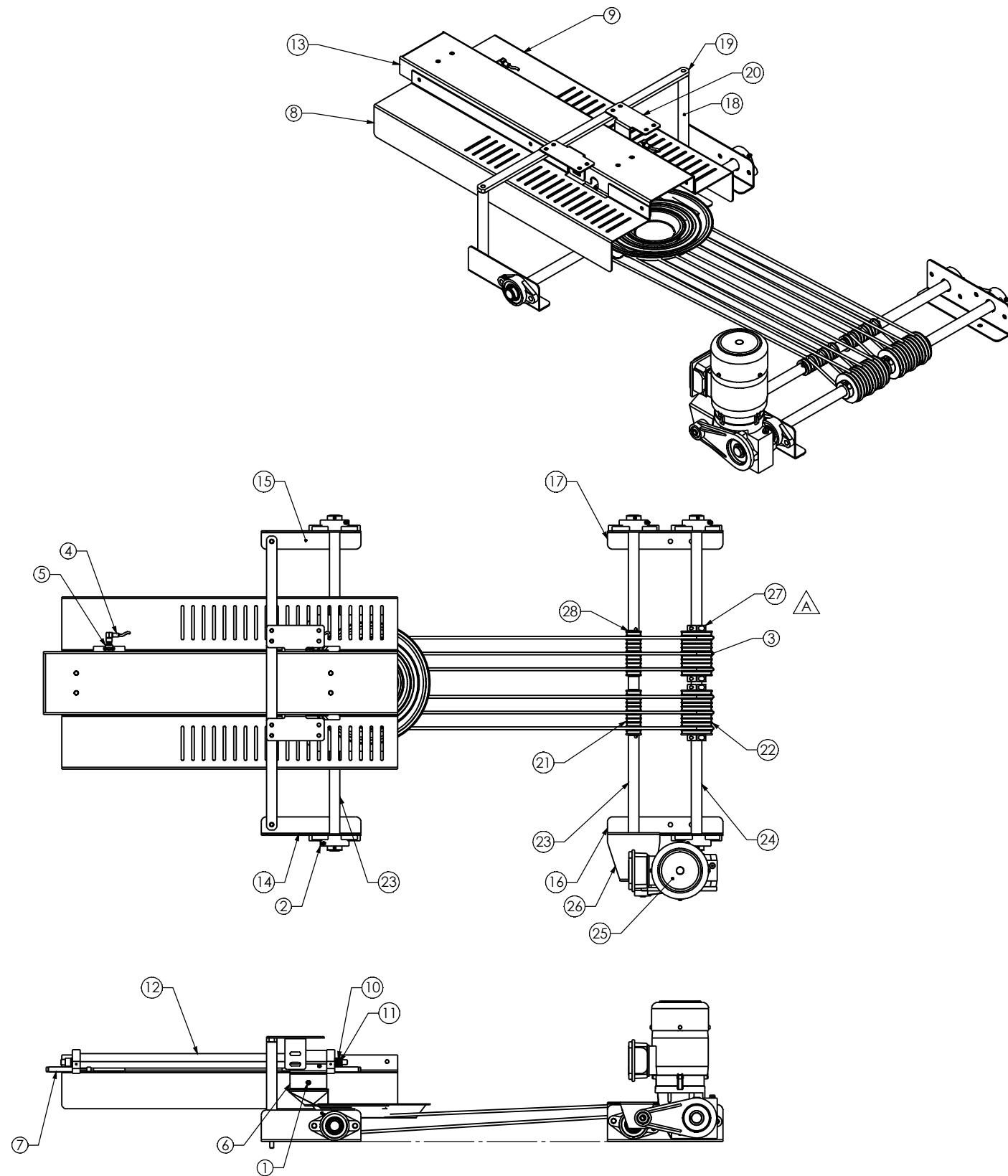
LAKE FOREST, IL 60045

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 DECIMALS .XXX----± .005 .XX----± .010

STOCK SIZE: SEE B.O.M.	
MATERIAL: SEE B.O.M.	FINISH: SEE B.O.M.
PATT NO:	ASSY NO: 150933
DESIGNED BY: LMG	TITLE: ASSEMBLY, TOOL, OFFLOAD, 12" NEW ENGLAND
DRAWN BY:	DRAWING NO: B-151235
CHECKED BY:	DATE: 8/21/2014

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REV.	DESCRIPTION



ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	108327	PIN, QUICK RELEASE, 0.375"x3.00" (SS)	1
2	109972	BEARING, 2-BOLT FLANGE, 1.00" BORE	6
3	114944	BELT, 0.25" ROUND	40 FT
4	116784	SENSOR CABLE	2
5	122131	SENSOR, QD MICRO	2
6	130710	BLOCK, KEY	1
7	130810	SHOCK ABSORBER	2
8	137120	GUARD, RH	1
9	137121	GUARD, LH	1
10	151024	FITTING, FLOW CONTROL, ELBOW, .25"NPT MALE X .25"NPT FEMALE, SS	2
11	151025	FITTING, STRAIGHT, .25"NPT X .25" TUBE, SS	2
12	151221	SLIDE, RODLESS, 1.06" BORE X 20.0" STROKE	1
13	151245	MOUNT, SLIDE	1
14	151246	BRACKET, BEARING, RH	1
15	151247	BRACKET, BEARING, LH	1
16	151248	BRACKET, DOUBLE BEARING, RH	1
17	151249	BRACKET, DOUBLE BEARING, LH	1
18	151250	POST, VERTICAL SUPPORT	2
19	151251	CROSSBAR, MOUNTING	1
20	151252	BRACKET, HANGER	2
21	151253	PULLEY, IDLE, 0.25" ROUND BELT	4
22	151254	PULLEY, DRIVE, 0.25" ROUND BELT	2
23	151255	SHAFT, IDLE	2
24	151256	SHAFT, DRIVE	1
25	151257	GEARMOTOR, 0.50 HP, 15:1, 480V 3PH	1
26	151258	BRACKET, TORQUE ARM	1
27	101353	COLLAR, 2-PIECES 1.00"	4
28	108919	RETAINING RING, Ø1.00" SHAFT	8

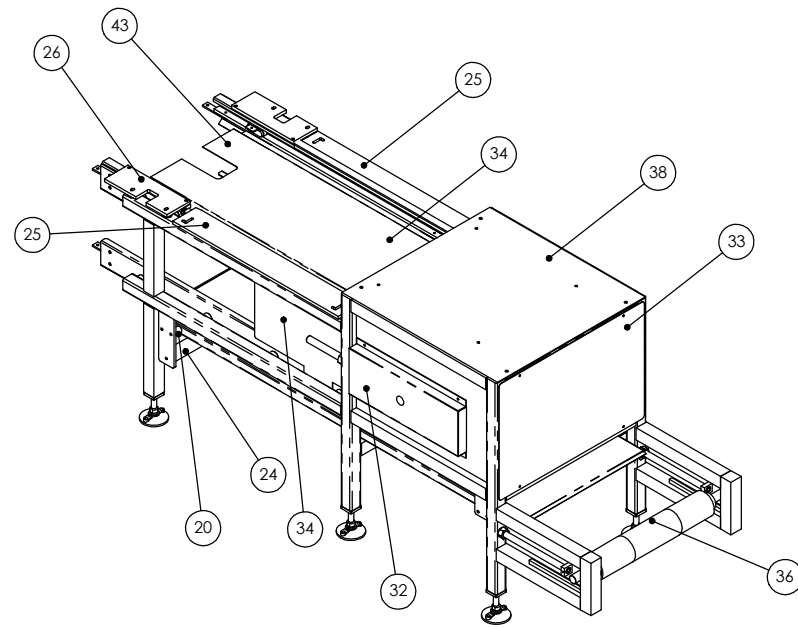
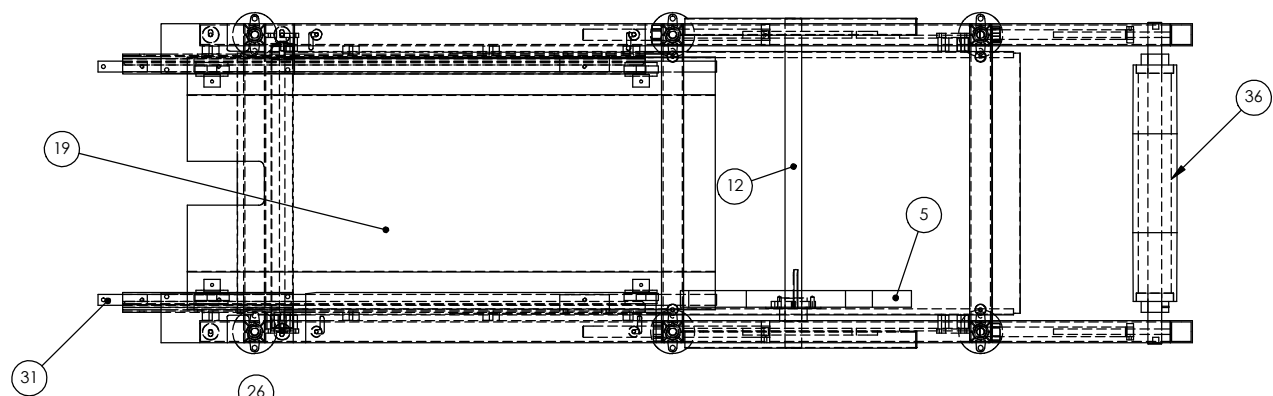
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A	DCR-2014-268-LMG, 8/25/2014, DOUBLED THE NUMBER OF ROLLERS, ADDED RETAINING FEATURES
REV.	DESCRIPTION

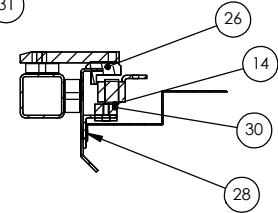
COLBORNE FOOTBOTICS, LLC
 LAKE FOREST, IL 60045
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 FRACTION ± 1/64 ANGLES ± 1°
 DECIMALS .XXX--- ± .005 .XX--- ± .010

STOCK SIZE: SEE B.O.M.
 MATERIAL: SEE B.O.M. FINISH: SEE B.O.M.
 PART NO: 141479
 DESIGNED BY: LMG TITLE: ASSEMBLY, OFFLOAD, SHORT STROKE
 DRAWN BY: DRAWING NO: C-151244
 CHECKED BY: DATE: 8/25/2014

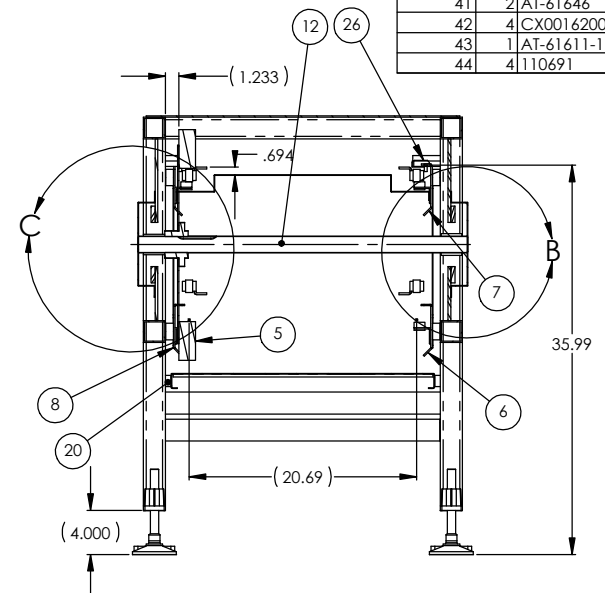
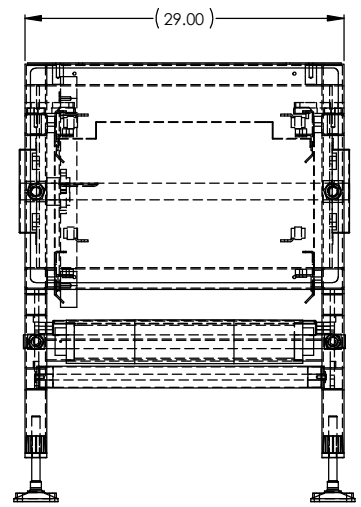
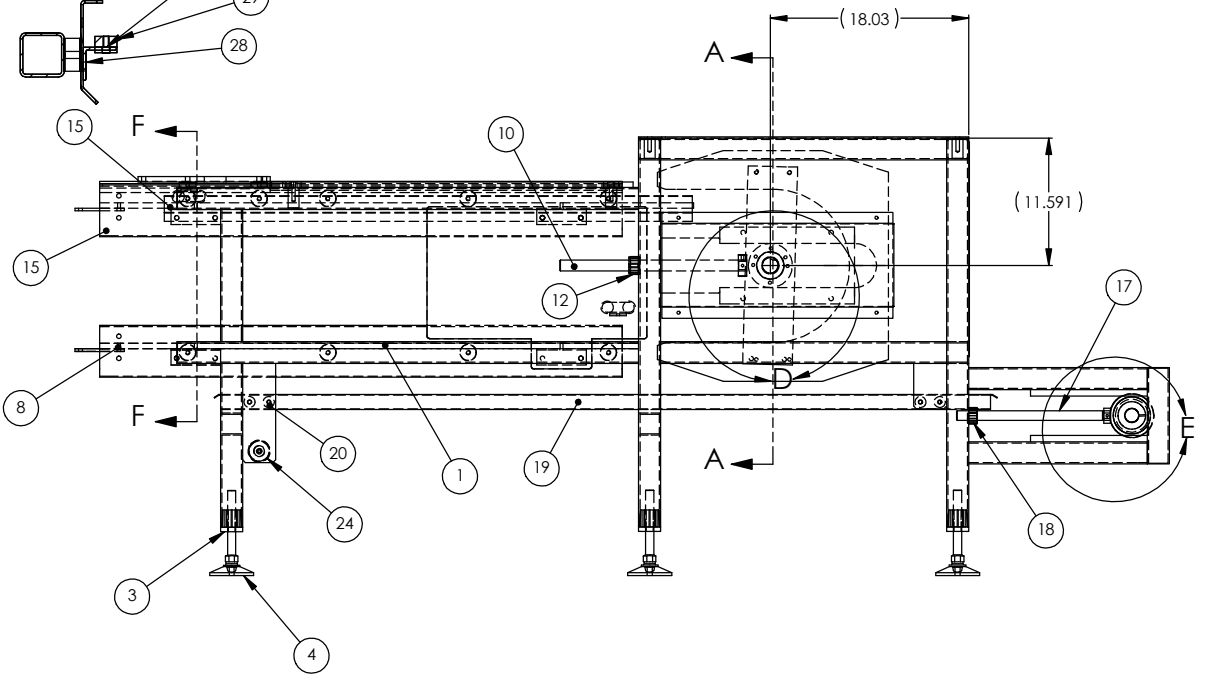
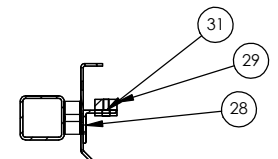
Sheet 1 of 1



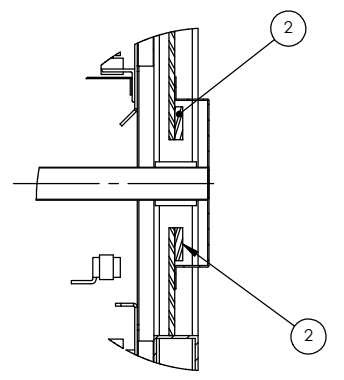
ITEM NO.	QTY.	PART NO.	DESCRIPTION
1	1	AT-60154	WELDMENT, AFT FRAME
2	4	AT-60162	PLATE, TAKE-UP GUIDE
3	6	104635	THREADED TUBE END, 3/4 - 10
4	6	108229	LEG LEVELER, 3/4-10
5	1	AT-60163	PLATE, WEAR
6	1	AT-60157	SUPPORT, RH, BOTTOM CONVEYOR
7	1	AT-60155	SUPPORT, RH, TOP CONVEYOR
8	1	AT-60158	SUPPORT, LH, BOTTOM CONVEYOR
9	2	2082B20	SPROCKET, NO 80, 48 TOOTH, 1.50 INCH BORE
10	2	AT-60170	THREADED ROD
11	1	AT-60172	BEARING, WEAR PLATE
12	1	AT-60173	SHAFT, MAIN IDLER
13	2	501183	HEX NUT, FULL, 1.0-8 UNC
14	4	?	CHAIN, 2082 CARRIER LINK
15	1	AT-60156	SUPPORT, LH, TOP CONVEYOR
17	2	DT-60177	ROD, THREADED
18	2	501498	NUT, 0.88"-14, HEX JAM, SS
19	1	AT-60189	SLIDER BED, AFT
20	8	C-145-76	SPACER, SLIDER BED
21	1	AT-60198	SHAFT, 1.25 DIA., ATF
22	2	AT-60166	ROD LOCK, ADJUSTABLE, ST-20
23	2	CP-38578	ROD LOCK, ADJUSTABLE, ST-24
24	1	AT-60203	ROLLER, SCRAP BELT SUPPORT
25	2	AT-60178	PLATE, GUIDE, TWO POSITION
26	2	AT-60176	GUIDE, CHAIN, PLASTIC
27	1	AT-60171	SUPPORT, WEAR PLATE
28	8	AT-60929	ANGLE, ATTACHMENT, SS
29	2	AT-60933	BAR, SUPPORT, AFT BOTTO
30	2	AT-60932	BAR, SUPPORT, AFT TOP
31	4	AT-60934	STRAP, CONNECTION, SS
32	2	AT-60955	GUARD, REAR TAKE-UP
33	1	AT-60954	GUARD, BACK CONVEYOR
34	2	AT-60956	GUARD, REAR INNER
35	2	109985	BEARING, TAKE-UP, 1.25" BORE
36	1	AT-60836	ROLLER, IDLER (SCRAP RETURN)
37	2	101260	BEARING, TAKE UP, 1.50"
38	1	AT-60794	PLATE, MOUNTING, FOR PAN DISP.
39	2	108494	COLLAR, 1.50", CLAMP
40	4	C-250-27	PAD MOUNTING, .38 - 16 TAP 304 SS
41	2	AT-61646	PLATE, CAM FOLLOWER
42	4	CX00162005	BEARING, CAM FOLLOWER, SEALED BEARING, 0.75" DIAMETER
43	1	AT-61611-1	SUPPORT, PAN DISPENSER
44	4	110691	REID, KNURLED KNOB, 1/4-20, SSKA-3



SECTION F
SCALE 1 : 4

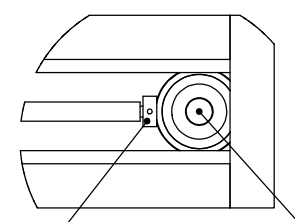


SECTION A-A

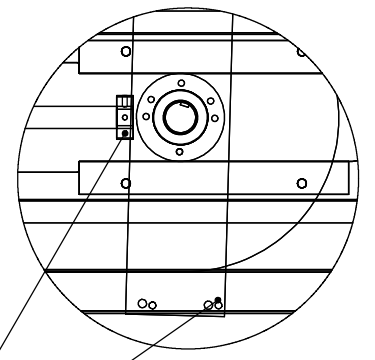


DETAIL B
SCALE 1 : 4

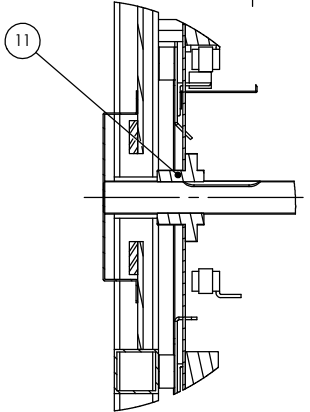
NOTES:
1. PART NO. TO BE PERMANENTLY MARKED (STAMPED OR ETCHED) ON SURFACE AS SHOWN.



DETAIL E
SCALE 1 : 4



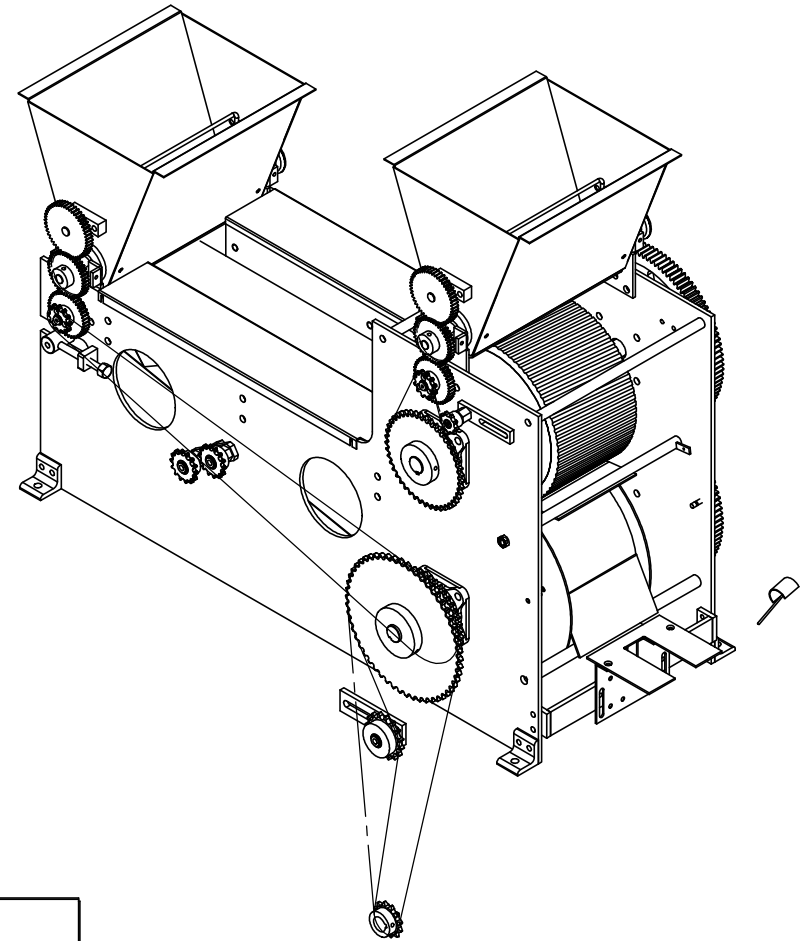
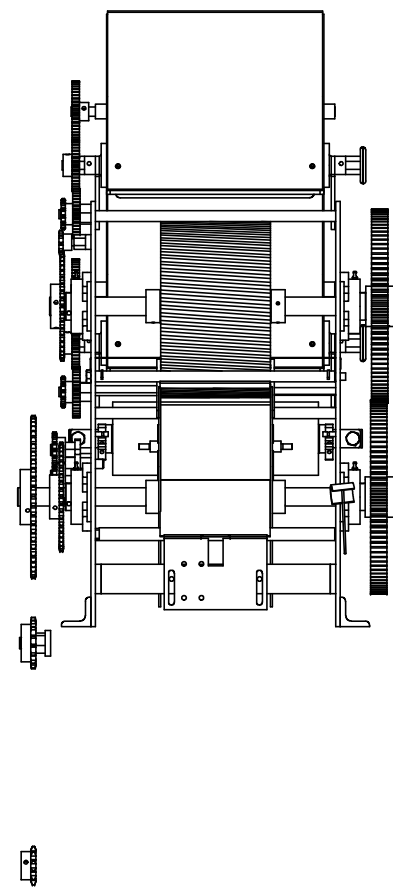
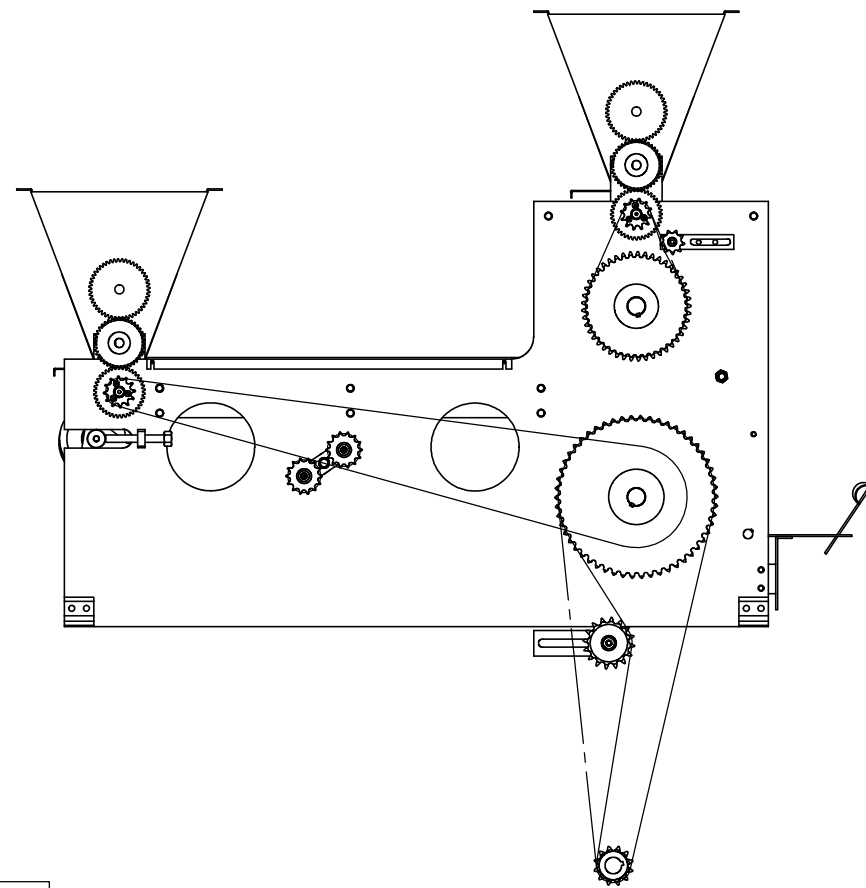
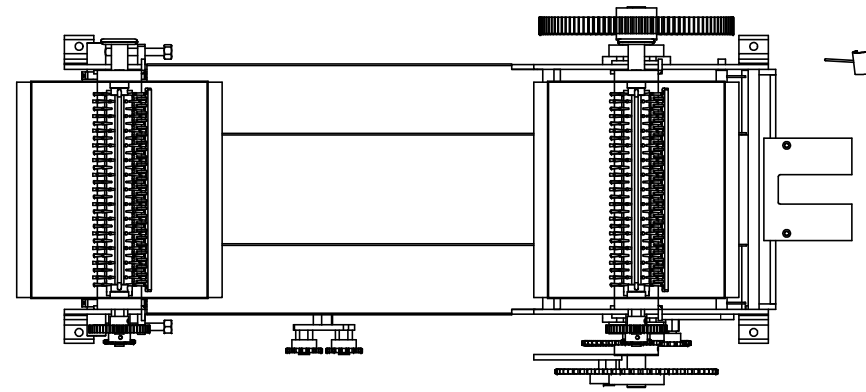
DETAIL D
SCALE 1 : 4



DETAIL C
SCALE 1 : 4

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REV	MODIFICATIONS	COLBORNE CORPORATION	
A	DCR # 2000124 CHANGE RAW MATERIAL FROM (060142 & 060843) TO (AT-60170 & DT-60177) ON DRAWING & BOM	GLENVIEW, ILL. 60025	
B	DCR# 2001190 ADD (110691 & AT60178) KM 8-30-01	DO NOT SCALE DRAWING	
		MACHINING TOLERANCES UNLESS SPECIFIED: FRACTION ± 1/64 ANGLES ± 1° DECIMALS .XXX... ± .005 .XX... ± .010	
		MATERIAL:	FINISH:
		DATE:	ASSY NO.:
		DRAWN BY:	TITLE:
		CHECKED BY:	ASSEMBLY, FRAME, AFT, SERIES 45
		SCALE:	DRAWING NO.:
		DATE:	D- AT-60024
			7-1-99



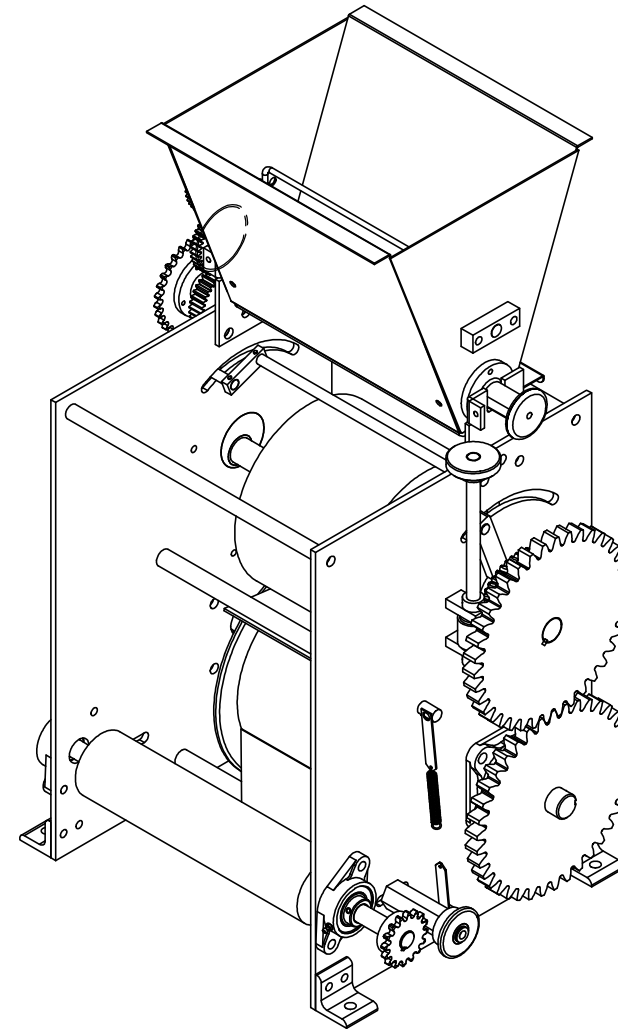
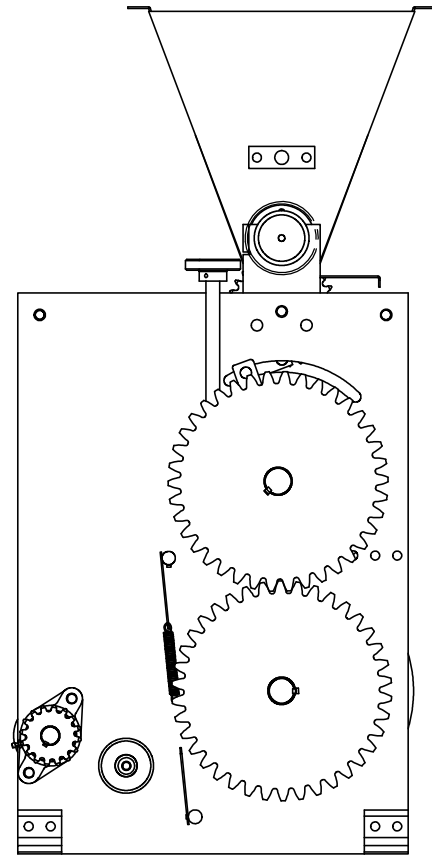
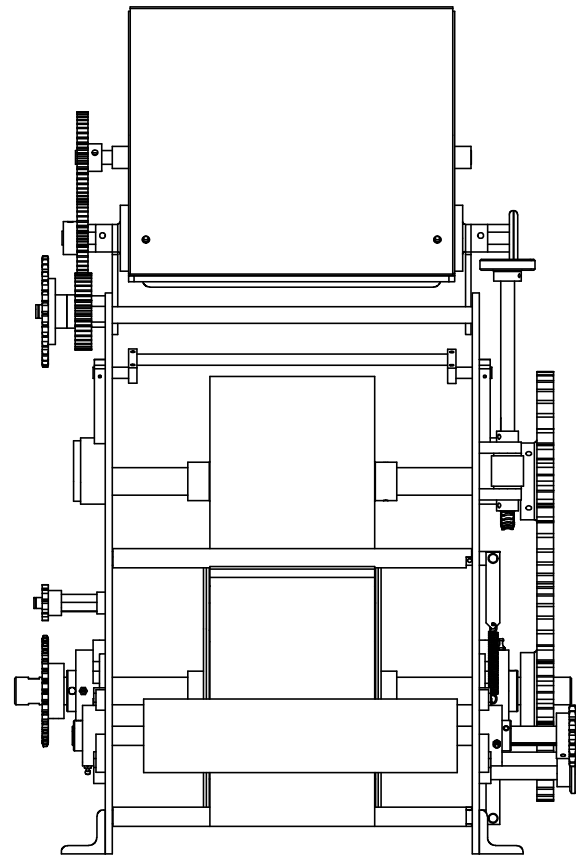
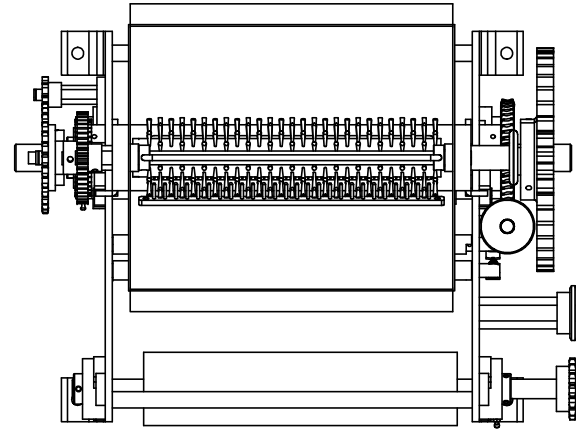
ITEM NO.	PART NUMBER	DESCRIPTION	Default/ QTY.
1	109986	BEARING, 4-BOLT FLANGE, 1.25" BORE	4
2	AS30244	BAR, IDLER SPROCKET ADJUSTMENT	1
3	C-118-6	SCREW, ADJUSTING, 0.50"-20x4.50" (SS)	2
4	CX130-97	SUD. SPROCKET & TENSION ARM	2
5	CX00203-24	HUB SPR. KEYED 5/8P. 3/8W	1
6	CX207-12	HUB SPR. KEYED 5/8P. 3/8W	2
7	CX00203036	HUB SPR. KEYED 5/8P. 3/8W	1
8	CX00210001	SPROCKET ASSY, 50B16	1
9	CX00214002	SPROCKET	2
10	CX00214006	HUB SPR. IDLER, 9 T. #40 (1/2"P. 5/16W)	1
11	DX01173	PIN, SPRING RETAINING	2
12	ED31097	DESCRIPTION	1
13	ED31099	ARM, SCRAPER	2
14	ED-31004	LUG, BELT ADJUSTING	2
15	SL36640-D	IDLER SHAFT	1
16	SL36644	DESCRIPTION	1
17	SL36770-01	BELT	1
18	SL36775	SHAFT STUB, FLOUR HOPPER	2
19	SL36776	SHAFT FOR FLANGED ROLLER	1
20	SL36777	SHAFT FOR FLUTED PRESS ROLLER	1
21	SL36778	STUD (CHAIN TENSION ASSY)	1
22	SL36779	ADJUSTING BAR	1
23	SL36830	.	2
24	SX160-65	STUD SPROCKET	1
25	TX1018-BB	BELT SUPPORT FEED CONVEYOR, 7.5	1
26	TX01145	.	1
27	TX28173B	GEAR & SPROCKET ASSEMBLY	2
28	TX28401-A	SIDE PLATE	1
29	TX28401-B	SIDE PLATE	1
30	TX28410	DESCRIPTION	2
31	TX28414-U	COVER L. H. - 7.5	1
32	TX28415-U	COVER L. H. - 7.5	1
33	TX28416	BRACKET, ANGLE	4
34	TX28417	PLATE SIDE R. H.	1
35	TX28418	PLATE SIDE L. H.	1
36	TX28438	PLATE, TOP	1
37	TX28439	BRACKET FOR SWITCH	1
38	TX28455	LEVER FOR MILROSWITCH	1
39	TX28544	.	1
40	TX28545	.	1
41	TX28571-B	TIE BAR	5
42	TX28580-S	STUD, GUIDE PLATE, 7.5	6
43	TX28581-S	SCRAPER LOWER 7.5	1
44	TX28584-B	SCRAPER SHAFT UPPER	1
45	TX28585-T	SCRAPER UPPER	1
46	TX28587-B	DESCRIPTION	1
47	TX28603	STUD ADJUSTMENT SPROCKET	1

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 DECIMALS .XXX... ± .005 .XX... ± .010

STOCK SIZE: SEE B.O.M.
 MATERIAL: SEE B.O.M. FINISH: SEE B.O.M.
 PART NO: SEE B.O.M. ASST NO:
 DESIGNED BY: TITLE
 DESIGNED BY: TITLE
 CHECKED BY: TITLE
 DATE: 6/8/2009 D- SL36770

Sheet 1 of 1



ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	SL36551	SIDE PLATE #2-SHEETER, RH	1
2	SL36552	SIDE PLATE #2-SHEETER, LH	1
3	SL36830	.	1
4	TX28525-B	ROD, STABILIZER FOR ECCENTRIC	1
5	SL36852	SHAFT FOR ECCENTRIC ROLLER	1
6	TX28524	.	1
7	TX28523	.	1
8	TX28541	GEAR FOR ECCENTRIC ADJUSTMENT	1
9	TX28526	GEAR, SPUR, STEEL, 14.5, 4DP, 38-T, 9.500 PD	2
10	TX28534-R	SCRAPER UPPER, 7.5	1
11	TX1065-3	SCRAPER SHAFT	2
12	SL36851-A	SHAFT FOR FLANGED ROLLER	1
13	109986	BEARING, 4-BOLT FLANGE, 1.25" BORE	2
14	CX207-14	SPROCKET, HUB #40, 30T	1
15	TX28434	DRIVE GEAR FLOUR HOPPER	1
16	SL36858	STUB SHAFT, FLOUR HOPPER	1
17	TX28433	SPROCKET #40A30, 1/2 PITCH, 30 TEETH	1
18	SL36779	ADJUSTING BAR	1
19	CX214-05	HUB SPROCKET IDLER	1
20	CX216-39	TIE BAR SPECER	2
21	TX28416	BRACKET, ANGLE	4
22	T-28228	BEARING, ECCENTRIC ADJUSTMENT WORM SHAFT	2
23	CX00103-04	THRUST BEARING	2
24	TX28539	DESCRIPTION	1
25	CX122-02	COLLAR	2
26	T-28231-A	KNOB, ECCENTRIC ADJUSTING	1
27	SL36854	SHAFT FOR FEED ROLLER	1
28	CX207-38	SPROCKET #40B16, 1/2 PITCH, 16 TEETH	1
29	SL37124	.	1
30	TX28535-R	SCRAPER LOWER, FINISHING ROLLER 7.5	1
31	SL36856	STRAP FOR SCRAPER SPRING	2
32	109962	2 BOLT FLANGE BEARING, 0.88Ø	2
33	102217	BOSTON GEAR H1066LH, WORM, L. H. 10 PITCH 14.5DEGR 5/8 BORE	1
34	CX-113-4	SPRING EXTENSION 7/16 OD, 2.875 COIL LENGTH .054 WIRE	1
35	SL36855	SUD, SPROCKET & TENSION ARM	1
36	CX135-45	IDLER STUD	1
37	CX-214-02	HUB, SPK, IDLER	1
38	TX28530	DESCRIPTION	1
39	TX28531C	.	1

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NOTE: PART NO. TO BE PERMANENTLY MARKED (STAMPED OR ETCHED) ON SURFACE AS SHOWN.

COLBORNE FOODBOTICS, LLC
 LAKE FOREST, IL 60045
DO NOT SCALE DRAWING
 MACHINING TOLERANCES UNLESS SPECIFIED:
 FRACTION ± 1/64 ANGLES ± 1°
 DECIMALS .XXX... ± .005 .XX... ± .010

STOCK SIZE: SEE B.O.M.
 MATERIAL: SEE B.O.M. PART NO.: SEE B.O.M.
 DESIGNED BY: TITLE: TITLE 2
 CHECKED BY: DATE: 6/8/2009
 D- SL36850