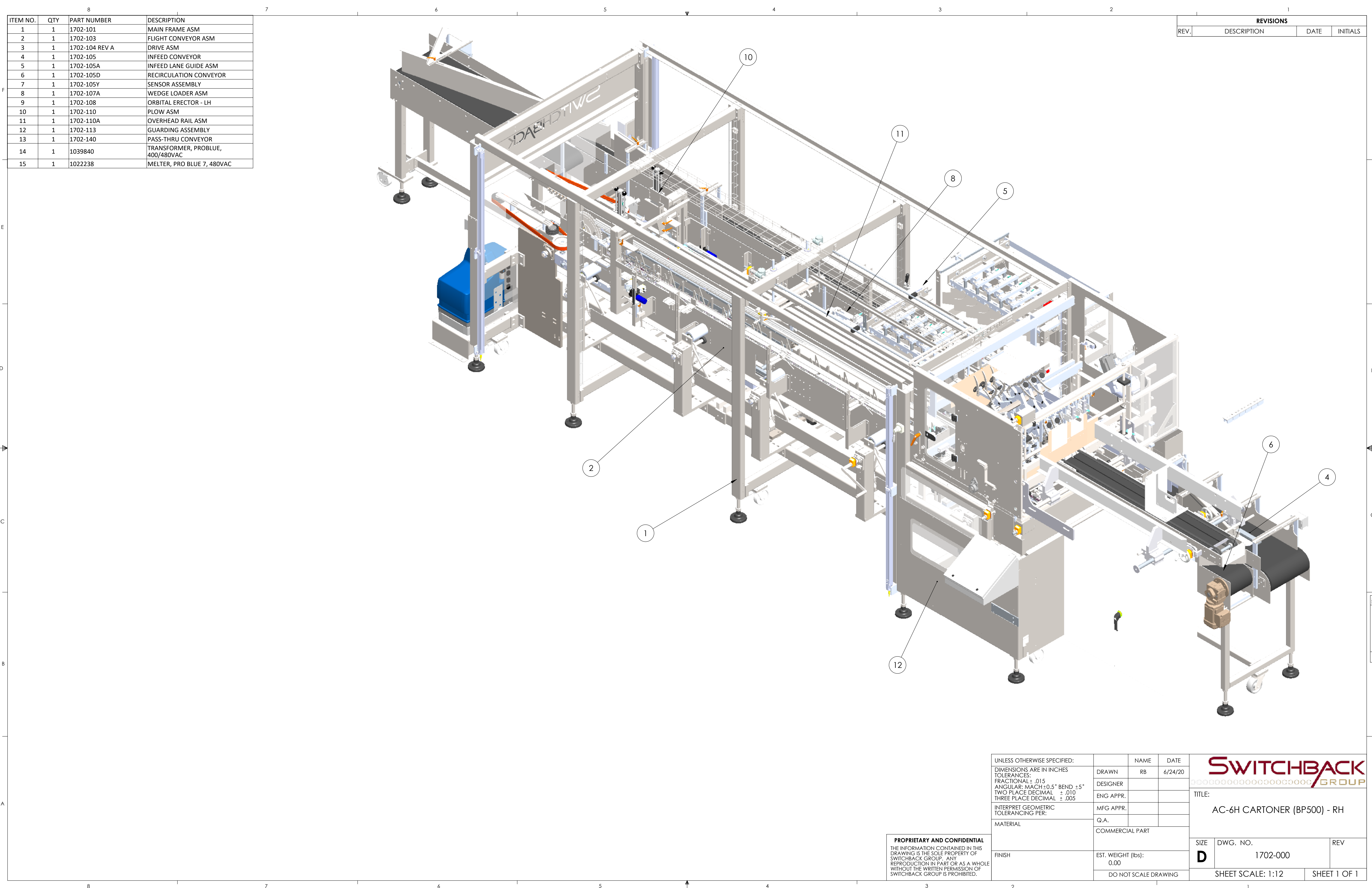




| ITEM NO. | QTY | PART NUMBER    | DESCRIPTION                      |
|----------|-----|----------------|----------------------------------|
| 1        | 1   | 1702-101       | MAIN FRAME ASM                   |
| 2        | 1   | 1702-103       | FLIGHT CONVEYOR ASM              |
| 3        | 1   | 1702-104 REV A | DRIVE ASM                        |
| 4        | 1   | 1702-105       | INFEED CONVEYOR                  |
| 5        | 1   | 1702-105A      | INFEED LANE GUIDE ASM            |
| 6        | 1   | 1702-105D      | RECIRCULATION CONVEYOR           |
| 7        | 1   | 1702-105Y      | SENSOR ASSEMBLY                  |
| 8        | 1   | 1702-107A      | WEDGE LOADER ASM                 |
| 9        | 1   | 1702-108       | ORBITAL ERECTOR - LH             |
| 10       | 1   | 1702-110       | PLOW ASM                         |
| 11       | 1   | 1702-110A      | OVERHEAD RAIL ASM                |
| 12       | 1   | 1702-113       | GUARDING ASSEMBLY                |
| 13       | 1   | 1702-140       | PASS-THRU CONVEYOR               |
| 14       | 1   | 1039840        | TRANSFORMER, PROBLUE, 400/480VAC |
| 15       | 1   | 1022238        | MELTER, PRO BLUE 7, 480VAC       |

| REVISIONS |             |      |          |
|-----------|-------------|------|----------|
| REV.      | DESCRIPTION | DATE | INITIALS |

|                                                                                                                                                                                                                                                 |                 |                      |         |
|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-----------------|----------------------|---------|
| UNLESS OTHERWISE SPECIFIED:<br>DIMENSIONS ARE IN INCHES<br>TOLERANCES:<br>FRACTIONAL: ± .015<br>ANGULAR: MACH ± 0.5° BEND ± 5°<br>TWO PLACE DECIMAL ± .010<br>THREE PLACE DECIMAL ± .005<br>INTERPRET GEOMETRIC<br>TOLERANCING PER:<br>MATERIAL | DRAWN           | NAME                 | DATE    |
|                                                                                                                                                                                                                                                 | DESIGNER        | RB                   | 6/24/20 |
|                                                                                                                                                                                                                                                 | ENG APPR.       |                      |         |
|                                                                                                                                                                                                                                                 | MFG APPR.       |                      |         |
| FINISH                                                                                                                                                                                                                                          | Q.A.            |                      |         |
|                                                                                                                                                                                                                                                 | COMMERCIAL PART |                      |         |
|                                                                                                                                                                                                                                                 |                 | EST. WEIGHT (lbs):   |         |
|                                                                                                                                                                                                                                                 |                 | 0.00                 |         |
|                                                                                                                                                                                                                                                 |                 | DO NOT SCALE DRAWING |         |

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|                                                                                                                                                                                                                                                                     |                 |                      |      |         |
|---------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-----------------|----------------------|------|---------|
| <div>UNLESS OTHERWISE SPECIFIED:<br/>DIMENSIONS ARE IN INCHES<br/>TOLERANCES:<br/>FRACTIONAL: ± .015<br/>ANGULAR: MACH ± 0.5° BEND ± 5°<br/>TWO PLACE DECIMAL ± .010<br/>THREE PLACE DECIMAL ± .005<br/>INTERPRET GEOMETRIC<br/>TOLERANCING PER:<br/>MATERIAL</div> | DRAWN           |                      | NAME | DATE    |
|                                                                                                                                                                                                                                                                     | DESIGNER        |                      | RB   | 6/24/20 |
|                                                                                                                                                                                                                                                                     | ENG APPR.       |                      |      |         |
|                                                                                                                                                                                                                                                                     | MFG APPR.       |                      |      |         |
| FINISH                                                                                                                                                                                                                                                              | Q.A.            |                      |      |         |
|                                                                                                                                                                                                                                                                     | COMMERCIAL PART |                      |      |         |
|                                                                                                                                                                                                                                                                     |                 | EST. WEIGHT (lbs):   |      |         |
|                                                                                                                                                                                                                                                                     |                 | 0.00                 |      |         |
|                                                                                                                                                                                                                                                                     |                 | DO NOT SCALE DRAWING |      |         |

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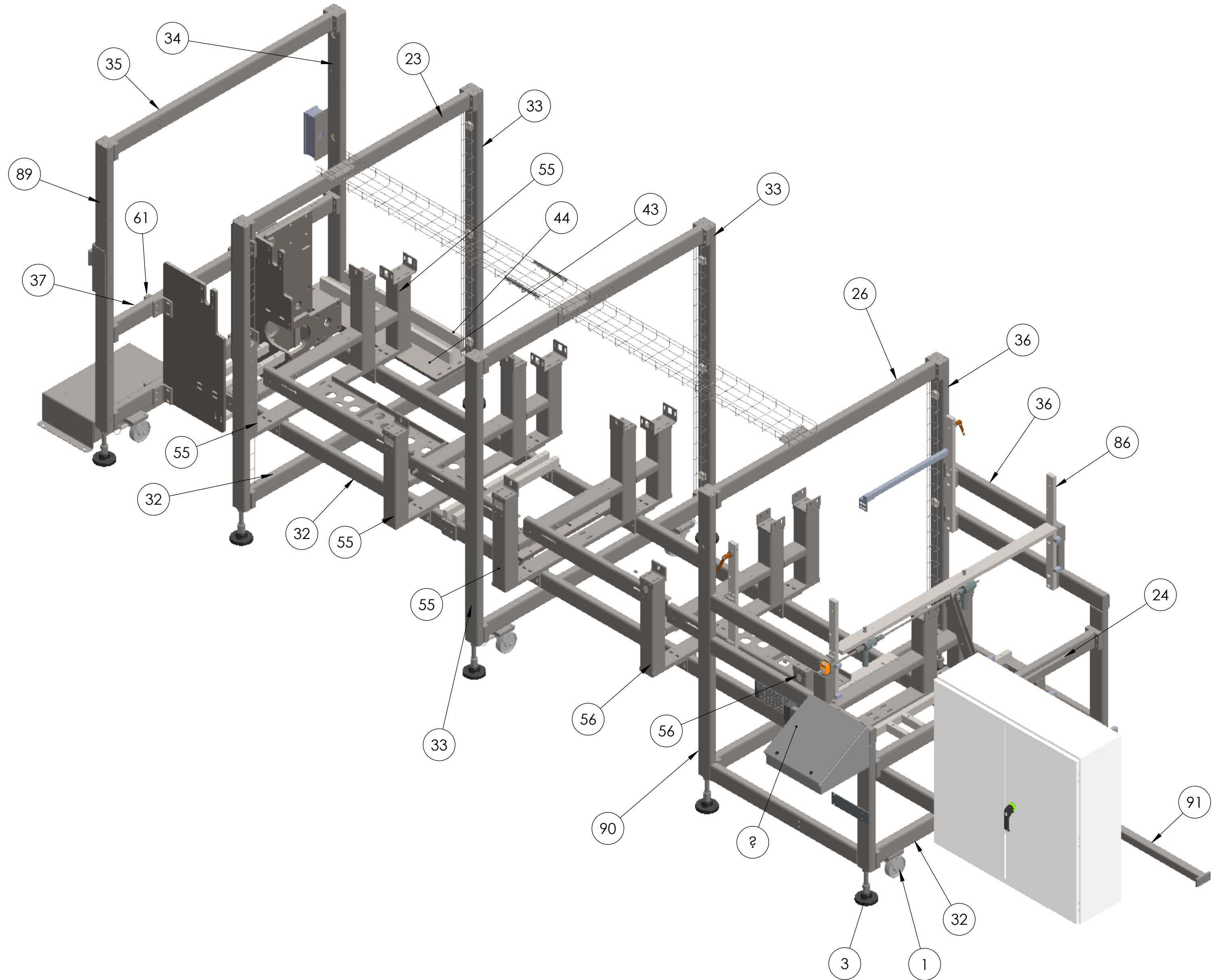
SWITCHBACK GROUP

TITLE:  
AC-6H CARTONER (BP500) - RH

|                   |          |              |
|-------------------|----------|--------------|
| SIZE              | DWG. NO. | REV          |
| D                 | 1702-000 |              |
| SHEET SCALE: 1:12 |          | SHEET 1 OF 1 |

| ITEM NO. | QTY | PART NUMBER               | DESCRIPTION                                                       |
|----------|-----|---------------------------|-------------------------------------------------------------------|
| 1        | 6   | 30305T393                 | SWIVEL CASTER WITH LOCK, 5" WHEEL DIAMETER, 6 1/2" OVERALL HEIGHT |
| 2        | 2   | 60655K732                 | ADJUSTABLE HANDLE, 1/2"-13 X 1-1/4" STUD                          |
| 3        | 10  | 60985K69                  | LEVELING MOUNT, 5" DIA.                                           |
| 4        | 1   | 6338K417                  | FLANGED SLEEVE BEARING, 1/2" BORE, 5/8" OD, 3/8" LG               |
| 5        | 7   | 90642A361                 | T-SLOT NUT, 5/16-18, SS                                           |
| 6        | 2   | 91847A520                 | 1/2"-13 HEX THIN NUT                                              |
| 7        | 4   | 92196A537                 | 1/4"-20 X 1/2" LG SHCS                                            |
| 8        | 1   | 92383A749                 | SLOTTED SPRING PIN                                                |
| 9        | 1   | 92510A807                 | SPACER, 1" LG, FOR 5/16" SCREW, 3/4" OD                           |
| 10       | 3   | CLX-8-8-SS                | SINGLE PIECE RIGID SHAFT COUPLING, 1/2" BORE                      |
| 11       | 20  | 94804A038                 | HEX NUT, 1"-8                                                     |
| 12       | 1   | OP7-A-10-DX-F3_4-R-D1_2   | POSITION INDICATOR, ORANGE, WITH 3/4" TO 1/2"" REDUCER            |
| 13       | 1   | V1-G-BK10M-PVC-U          | M12 CABLE, STRAIGHT, 10M LG, 4-PIN                                |
| 14       | 2   | WJ513S-004_50-STDX-STDX-X | 1 TON SCREW JACK, INVERTED, THREADED END, 4-1/2" RISE             |
| 15       | 1   | WTB9-3P3461               | PHOTOELECTRIC PROXIMITY SWITCH, 4 PIN, M12                        |
| 16       | 1   | MD-01-6249-00             | ATTACHMENT BLOCK                                                  |
| 17       | 1   | MD-01-6250-00             | ATTACHMENT BLOCK A                                                |
| 18       | 3   | MD-01-6254-00             | CABLE TRAY BRACKET A                                              |
| 19       | 3   | MD-01-6255-00             | CABLE TRAY CLAMP PLATE                                            |
| 20       | 12  | MD-01-6256-00             | CABLE TRAY MOUNT BLOCK                                            |
| 21       | 1   | MD-01-6258-00             | ERECTOR ADJ SCREW SHAFT                                           |
| 22       | 1   | MD-01-6264-00             | ERECTOR SCREW SHAFT                                               |
| 23       | 1   | MD-01-6267-00             | FRAME CROSSBAR A                                                  |
| 24       | 1   | MD-01-6268-00             | FRAME CROSSBAR B                                                  |
| 25       | 1   | MD-01-6270-00             | FRAME CROSSBAR D                                                  |
| 26       | 1   | MD-01-6271-00             | FRAME CROSSBAR E                                                  |
| 27       | 4   | MD-01-6283-00             | GUARD MOUNT BLOCK                                                 |
| 28       | 1   | MD-01-6313-00             | SHAFT SLEEVE - 1/2                                                |
| 29       | 1   | MD-01-6327-00             | CABLE TRAY - TOP                                                  |
| 30       | 4   | MD-01-6328-00             | CABLE TRAY - SIDE                                                 |
| 31       | 1   | MD-01-6361-00             | ROTARY SUPPORT BAR                                                |
| 32       | 1   | MD-01-6564-00 REV A       | MAIN FRAME                                                        |
| 33       | 4   | MD-01-6565-00             | FRAME UPRIGHT A                                                   |
| 34       | 1   | MD-01-6568-00 REV A       | FRAME UPRIGHT C2                                                  |
| 35       | 1   | MD-01-6569-00 REV A       | FRAME CROSSBAR F1                                                 |
| 36       | 1   | MD-01-6570-00 REV B       | FRAME UPRIGHT D                                                   |
| 37       | 1   | MD-01-6571-00 REV A       | FRAME CROSSBAR C1                                                 |
| 38       | 1   | MD-01-6572-00             | ADJ CHAIN TENSIONER SHAFT                                         |
| 39       | 1   | MD-01-6577-00             | MANIFOLD MOUNTING PLATE                                           |
| 40       | 2   | MD-01-6585-00             | ENCODER MOUNT BAR A                                               |
| 41       | 1   | MD-01-6586-00             | MOUNT PLATE A                                                     |
| 42       | 1   | MD-01-6588-00             | MOUNT PLATE B                                                     |
| 43       | 1   | MD-01-6590-00 REV A       | MOTOR MOUNT PLATE A                                               |
| 44       | 1   | MD-01-6591-00             | MAIN DRIVE MOTOR MOUNT                                            |
| 45       | 1   | MD-01-6592-00             | MAIN DRIVE MOTOR MOUNT A                                          |
| 46       | 1   | MD-01-6594-00             | MOUNT PLATE C                                                     |
| 47       | 4   | MD-01-6595-00             | GEARBOX MOUNT J                                                   |
| 48       | 1   | MD-01-6597-00             | ATTACHMENT ANGLE A                                                |
| 49       | 1   | MD-01-6598-00             | PLATE STIFFENER A                                                 |
| 50       | 4   | MD-01-6599-00             | PLATE MOUNT A                                                     |
| 51       | 1   | MD-01-6600-00             | MAIN GEARBOX PLATE                                                |
| 52       | 1   | MD-01-6601-00             | LOWER PLATE STIFFENER                                             |
| 53       | 1   | MD-01-6602-00             | FRAME ATTACHMENT BLOCK A                                          |
| 54       | 8   | MD-01-6608-00             | SUPPORT SHAFT MOUNT A                                             |
| 55       | 3   | MD-01-6610-00 REV B       | MAIN SUPPORT A1                                                   |
| 56       | 2   | MD-01-6613-00 REV B       | MAIN SUPPORT B1                                                   |
| 57       | 3   | MD-01-6614-00             | CONVEYOR ATTACHMENT BRACKET A                                     |
| 58       | 4   | MD-01-6615-00             | CONVEYOR ATTACHMENT BRACKET B                                     |
| 59       | 1   | MD-01-6618-00 REV A       | GEARBOX MOUNT K                                                   |
| 60       | 1   | MD-01-6620-00             | BEARING MOUNT 101C                                                |
| 61       | 7   | MD-01-6621-00             | ATTACHMENT NUT BAR                                                |
| 62       | 2   | MD-01-6622-00             | FRAME ATTACHMENT AA                                               |
| 63       | 1   | MD-01-6623-00             | BEARING MOUNT 101D                                                |
| 64       | 8   | MD-01-6624-00             | ATTACHMENT NUT BAR A                                              |
| 65       | 2   | MD-01-6625-00             | GEARBOX CROSSBAR B                                                |
| 66       | 2   | MD-01-6626-00             | GEARBOX CROSSBAR C                                                |
| 67       | 1   | MD-01-6629-00             | CROSSBAR ATTACHMENT A                                             |
| 68       | 2   | MD-01-6630-00             | FRAME ATTACHMENT AB                                               |
| 69       | 14  | MD-01-6631-00             | FRAME ATTACHMENT AC                                               |
| 70       | 12  | MD-01-6632-00             | ATTACHMENT NUT BAR B                                              |
| 71       | 1   | MD-01-6633-00             | ATTACHMENT NUT BAR C                                              |
| 72       | 1   | MD-01-6634-00             | ATTACHMENT NUT BAR D                                              |
| 73       | 4   | MD-01-6635-00             | ATTACHMENT NUT BAR E                                              |
| 74       | 4   | MD-01-6636-00             | ATTACHMENT NUT BAR F                                              |
| 75       | 1   | MD-01-6641-00             | CROSSBAR A                                                        |

| ITEM NO. | QTY | PART NUMBER         | DESCRIPTION                |
|----------|-----|---------------------|----------------------------|
| 76       | 1   | MD-01-6642-00       | CROSSBAR B                 |
| 77       | 1   | MD-01-6643-00       | CROSSBAR C                 |
| 78       | 1   | MD-01-6644-00       | CROSSBAR D                 |
| 79       | 1   | MD-01-6645-00       | MELTER STAND               |
| 80       | 5   | MD-01-6649-00       | ATTACHMENT NUT BAR G       |
| 81       | 2   | MD-01-6651-00       | GEARBOX CROSSBAR E         |
| 82       | 1   | MD-01-6657-00 REV A | CROSSBAR E                 |
| 83       | 2   | MD-01-6825-00       | GEARBOX SUPPORT NUT BAR    |
| 84       | 1   | MD-01-6828-00       | NUT PLATE                  |
| 85       | 2   | MD-01-7090-00 REV A | ERECTOR GUIDE UPRIGHT A    |
| 86       | 2   | MD-01-7091-00 REV B | ERECTOR GUIDE UPRIGHT B    |
| 87       | 1   | MD-01-7092-00       | POSITION INDICATOR PLATE   |
| 88       | 2   | MD-01-7093-00       | CROSSBAR SUPPORT PLATE     |
| 89       | 1   | MD-01-7356-00       | FRAME UPRIGHT C1           |
| 90       | 1   | MD-01-7357-00 REV B | FRAME UPRIGHT B            |
| 91       | 1   | MD-01-7359-00       | OUTBOUND LEG               |
| 92       | 1   | MD-01-7486-00       | FILTER/REGULATOR MOUNT     |
| 93       | 1   | MD-02-5229-01       | PE MOUNT, CONV. HIGH LEVEL |
| 94       | 2   | MD-02-5507-00       | PB BOX MTG BRACKET         |
| 95       | 1   | MD-02-5683-00       | BRACKET, ENCLOSURE         |
| 96       | 10  | MD-05-7719-00       | FOOT STUD                  |
| 97       | 4   | MD-08-5516-00       | ERECTOR LOCKDOWN SPACER    |
| 98       | 1   | MD-10-7374-01       | UPRIGHT SUPPORT            |
| 99       | 1   | MD-10-7375-02       | UPRIGHT SUPPORT BRACKET    |
| 100      | 2   | MD-02-5753-00       | CROSSBAR, CABINET MOUNT    |
| 101      | 3   | MD-02-5754-00       | CABINET MOUNTING BAR       |

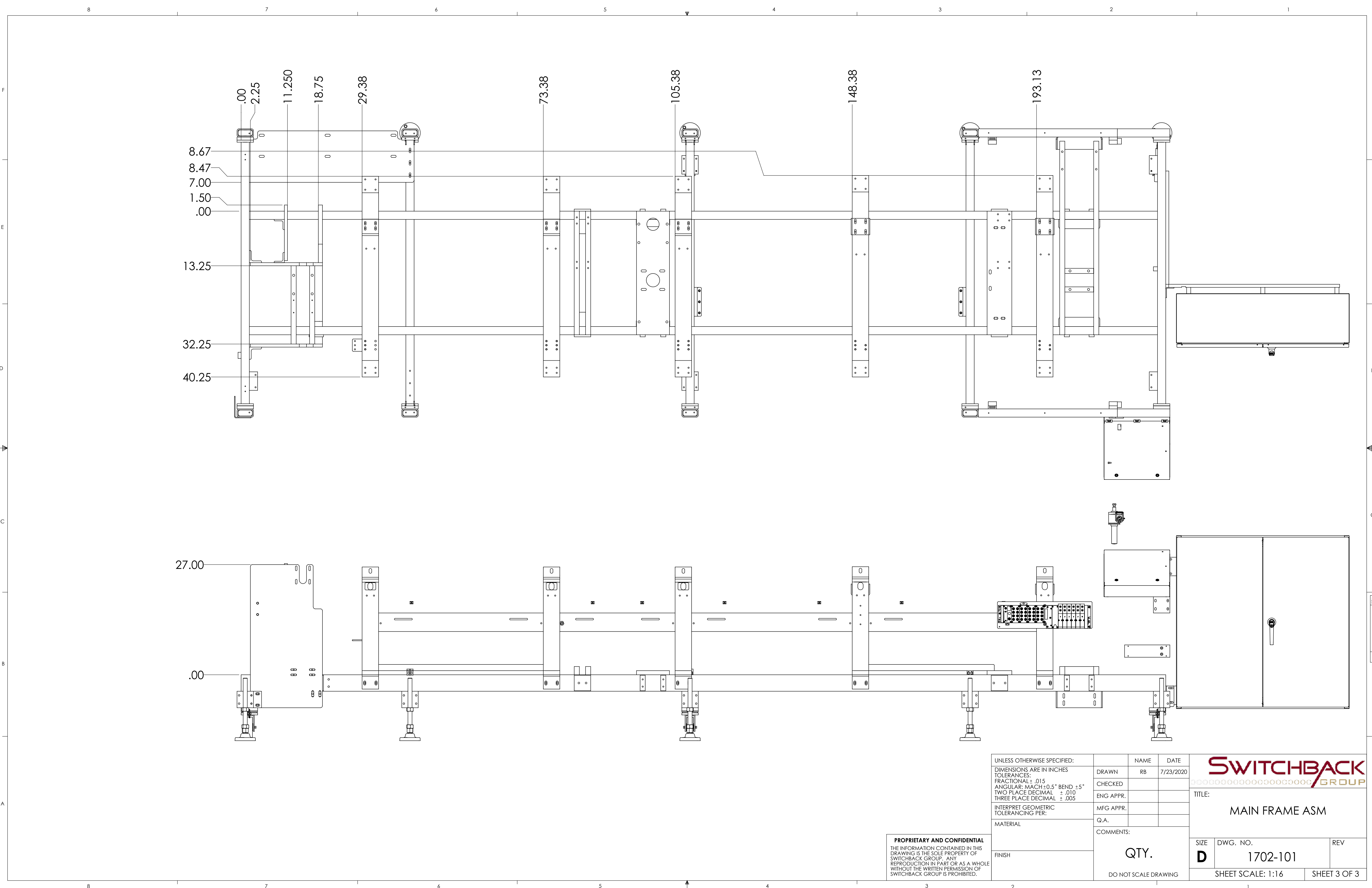


NOTES:  
1. USE STAINLESS STEEL HARDWARE UNLESS OTHERWISE SPECIFIED.

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|                                                                                                                                                                                                                                            |  |                               |                   |                                                                       |                      |
|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--|-------------------------------|-------------------|-----------------------------------------------------------------------|----------------------|
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| FINISH                                                                                                                                                                                                                                     |  | DESIGNER                      |                   |                                                                       |                      |
|                                                                                                                                                                                                                                            |  | ENG APPR.                     |                   |                                                                       |                      |
|                                                                                                                                                                                                                                            |  | MFG APPR.                     |                   |                                                                       |                      |
|                                                                                                                                                                                                                                            |  | Q.A.                          |                   |                                                                       |                      |
|                                                                                                                                                                                                                                            |  | COMMERCIAL PART               |                   |                                                                       |                      |
|                                                                                                                                                                                                                                            |  | EST. WEIGHT (lbs):<br>4108.50 |                   | SIZE<br><b>D</b>                                                      | DWG. NO.<br>1702-101 |
|                                                                                                                                                                                                                                            |  | DO NOT SCALE DRAWING          |                   | REV                                                                   |                      |
|                                                                                                                                                                                                                                            |  |                               |                   | SHEET SCALE: 1:16                                                     |                      |
|                                                                                                                                                                                                                                            |  |                               |                   | SHEET 1 OF 3                                                          |                      |





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|                                      |                     |
|--------------------------------------|---------------------|
| UNLESS OTHERWISE SPECIFIED:          |                     |
| DIMENSIONS ARE IN INCHES             |                     |
| TOLERANCES:                          |                     |
| FRACTIONAL                           | ± .015              |
| ANGULAR                              | MACH ±0.5° BEND ±5° |
| TWO PLACE DECIMAL                    | ± .010              |
| THREE PLACE DECIMAL                  | ± .005              |
| INTERPRET GEOMETRIC TOLERANCING PER: |                     |
| MATERIAL                             |                     |
| FINISH                               |                     |

|                      |      |           |
|----------------------|------|-----------|
|                      | NAME | DATE      |
| DRAWN                | RB   | 7/23/2020 |
| CHECKED              |      |           |
| ENG APPR.            |      |           |
| MFG APPR.            |      |           |
| Q.A.                 |      |           |
| COMMENTS:            |      |           |
| QTY.                 |      |           |
| DO NOT SCALE DRAWING |      |           |

|                         |          |              |
|-------------------------|----------|--------------|
| <b>SWITCHBACK GROUP</b> |          |              |
| TITLE:                  |          |              |
| MAIN FRAME ASM          |          |              |
| SIZE                    | DWG. NO. | REV          |
| <b>D</b>                | 1702-101 |              |
| SHEET SCALE: 1:16       |          | SHEET 3 OF 3 |

ITEM NO.

QTY

PART NUMBER

DESCRIPTION

1

56

VG-016-01

RAIL CLIP

2

52

vg-018-02-com

3

4

VG-018-04-com

RAIL CLIP

4

1

0226-0400-RH-1in-1in

RH GEARBOX, 1:1, 2X 1" BORE

5

1

0227-0400-LH-1in-1in

LH GEARBOX, 1:1

6

8

1630 DC

3/4" ID X 1-5/8" OD BALL BEARING

7

2

2AK61H

2-GROOVE SHEAVE

8

4

32885K553

SPRAY NOZZLE, FULL 60 deg CONE, 1/4" NPT MALE

9

16

40BB17H

NO 40 IDLER SPROCKET, 17T, 5/8" BORE

10

2

40BS16 X .75

NO. 40, FINISHED BORE SPROCKET

11

16

4648K14

BALL BEARING, 3/8" BORE, FOOD GRADE PERMANENT LUBE, 7/8" OD, 9/32" WIDE

12

2

50785K114

3/8" NPT PIPE PLUG, HEX DRIVE

13

2

5469K103

MANIFOLD, 2X 3/8" NPT INLETS, 2X 1/4" NPT OUTLETS

14

2

5906K533

THRUST BEARING, 3/8" ID, 1/8" THK, 3/4" OD

15

2

5931K75

FLANGE MOUNTED LINEAR BEARING, 3/8" DIA., SS

16

16

6391K171

SLEEVE BEARING, 3/8" BORE, 1/4" LG, 1/2" OD

17

5

6655K39

PLASTIC THRUST BALL BEARING, 3/4" ID, 1-1/4" OD

18

8

90642A361

T-SLOT NUT, 5/16-18, SS

19

2

91847A520

1/2"-13 HEX THIN NUT

20

8

92196A142

5/16-18 SHCS, 4" LG., SS

21

2

92210A148

FHSCS, #6-32 X 1/2" LG., 18-8 SS

22

1

92383A749

SLOTTED SPRING PIN

23

6

92510A804

SPACER, 5/16 ID x 3/4 OD x 3/4 LG

24

4

92510A808

SPACER, 3/8" BORE, 1" LG, 3/4" OD

25

16

92949A622

3/8"-16 X 3/4" LG BHCS, FULL THRD

26

5

CL-12-SS

1-PC CLAMP SHAFT COLLAR, 3/4" BORE

27

2

H x 1 Bushing

"H" SPLIT TAPER BUSHING

28

1

OP7-A-10-DX-F3\_4-R

POSITION INDICATOR, TOP VIEW

29

10

RJUI-03-24

SELF-ALIGNING LINEAR PLAIN BEARING, 1-1/2" BORE

30

2

S24LW

CAM FOLLOWER, 3/4" OD

31

2

SC-16-SS

1-PC SET SCREW SHAFT COLLAR, 1" BORE

32

4

SP-16-SS

2-PC SHAFT COLLAR, 1" BORE

33

5

SSBSRFB 204-12

3-BOLT FLANGE BEARING, 3/4" BORE

34

4

VG-013-03

RAIL SPLICE CLAMP

35

2

VG-SSECG-#60A-10

EXTENDED CHAIN GUIDE RAIL, #60 CHAIN, 10FT LG

36

1

1496-103 ADJ CHAIN A

SB ADJ CHAIN, NO. 40, NICKEL PLATED

37

1

1496-103 ADJ CHAIN B

SB ADJ CHAIN, NO. 40, NICKEL PLATED

38

1

1496-103 ADJ CHAIN C

SB ADJ CHAIN, NO. 40, NICKEL PLATED

39

1

1496-103 ADJ CHAIN D

SB ADJ CHAIN, NO. 40, NICKEL PLATED

40

13

1702-103A

AC-6H FLIGHT CHAIN ASM

41

1

1702-103B

4-CAN WIDE CARTON SUPPORT (STD)

42

1

1702-103C

4-CAN WIDE CARTON SUPPORT (SLEEK)

43

16

MD-01-6572-00

ADJ CHAIN TENSIONER SHAFT

44

1

MD-01-6576-00

POSITION INDICATOR PLATE A1

45

5

MD-01-6640-00

COVER PLATE A

46

5

MD-01-6903-00

COVER WASHER

47

5

MD-01-7432-00

SPROCKET SPACER

48

4

MD-03-0041-09

SPROCKET INSIDE CLAMP PLT

49

5

MD-03-0059-00

STRONGBACK NUT

50

2

MD-03-0072-02

FLIGHT DONUT

ITEM NO.

QTY

PART NUMBER

DESCRIPTION

51

3

MD-03-5254-00

ADJ. STRONGBACK SPROCKET

52

1

MD-03-5288-02

ADJUSTING HANDLE, 3/4" BORE

53

2

MD-03-5676-00 REV B

FLIGHT DRIVE SPROCKET

54

2

MD-03-5677-00

FLIGHT CHAIN GUIDE A

55

2

MD-03-5678-00

FLIGHT CHAIN GUIDE B

56

8

MD-03-5681-00

IDLER PIN

57

4

MD-03-5682-00

IDLER PIN

58

2

MD-03-5691-00

TIE BRACKET B

59

2

MD-03-5699-00

PULLEY SHAFT

60

4

MD-03-5702-00

BELT MOUNT STIFFENER

61

2

MD-03-5728-00

FLIGHT CHAIN GUIDE C

62

2

MD-03-5823-00

BELT DISCHARGE BRACKET

63

1

MD-03-5838-00

FLIGHT SHAFT

64

2

MD-03-5839-00 REV A

HUB CONTROL BAR A

65

2

MD-03-5840-00

DISCHARGE BELT

66

1

MD-03-5841-00

DISCHARGE BELT DRIVE SHAFT

67

2

MD-03-5842-01

BELT BACK-UP, EXTENDED

68

2

MD-03-5845-00

DISCHARGE ROLLER MOUNT A

69

4

MD-03-5846-00

BEARING TUBE

70

5

MD-03-5847-00

STRONGBACK SHAFT MOUNT

71

3

MD-03-5848-00

CONVEYOR SUPPORT SHAFT C

72

4

MD-03-5849-00

FLIGHT ADJUSTMENT SCREW A

73

1

MD-03-5850-00

FLIGHT ADJUSTMENT SCREW B

74

2

MD-03-5851-00 REV C

HUB CONTROL BAR B

75

2

MD-03-5852-00

CONVEYOR SUPPORT SHAFT B

76

1

MD-03-5853-00 REV A

BEARING TUBE A

77

2

MD-03-5856-00

CARTON DISCHARGE BLOCK A

78

2

MD-03-5857-00

SPACER DONUT

79

2

MD-03-5858-00

DISCHARGE PULLEY SPACER, SHORT

80

4

MD-03-5859-00

DISCHARGE PULLEY SUPPORT BLOCK

81

2

MD-03-5860-00

DISCHARGE PULLEY MTG PLATE

82

1

MD-03-5861-00

DISCHARGE GUIDE TIP

83

2

MD-03-5862-00

SHAFT SUPPORT

84

2

MD-03-5863-00

CARTON SUPPORT SLIDE SHAFT

85

1

MD-03-5986-00

CARTON DISCHARGE PLATE A

86

1

MD-03-5987-00

CARTON DISCHARGE PLATE B

87

2

MD-03-6056-00

SPROCKET INSIDE CLAMP PLT

88

1

MD-03-6172-00 REV A

MODIFIED SHAFT COLLAR

89

1

MD-03-6173-00 REV B

DISCHARGE GUIDE MOUNT

90

4

MD-03-6204-00

FLIGHT CHAIN TRACK

91

2

MD-03-6205-00

FLIGHT CHAIN TRACK

92

56

MD-03-6207-00

TRACK CLIP SPACER

93

2

MD-03-6208-00

DRIVE SPROCKET

94

2

MD-03-6211-00

FLIGHT HUB ASSEMBLY, FIXED

95

2

MD-03-6212-00

SPROCKET INSIDE CLAMP PLT

96

2

MD-03-6213-00

FLIGHT CONV. FRAME TOP A

97

2

MD-03-6214-00

FLIGHT CONV. FRAME TOP

98

2

MD-03-6215-00

FLIGHT CONV FRAME END A.

99

2

MD-03-6216-00 REV A

FLIGHT IDLER

100

2

MD-03-6217-00

FLIGHT IDLER

101

2

MD-03-6219-00

FLIGHT CHAIN TRACK

102

1

MD-03-6220-00 REV A

STRONGBACK 2B

103

1

MD-03-6221-00

STRONGBACK 4A

104

1

MD-03-6222-00 REV B

STRONGBACK 5A

105

1

MD-03-6223-00 REV A

STRONGBACK A

106

1

MD-03-6224-00 REV A

DISCHARGE BELT MOUNT - LH

107

1

MD-03-6225-00 REV A

DISCHARGE BELT MOUNT - RH

108

1

MD-03-6226-00

MOUNT STIFFENER A

109

1

MD-03-6227-00

MOUNT STIFFENER B

110

1

MD-03-6266-00

ZERO POINT PLATE

111

2

MD-03-6350-00

CARTON SUPPORT UPRIGHT A

112

1

MD-03-6352-00

CHAIN GUIDE MOUNT FRONT, TOP

113

1

MD-03-6353-00

CHAIN GUIDE MOUNT REAR, TOP

114

1

MD-03-6354-00

CHAIN GUIDE MOUNT FRONT, BOTTOM

115

1

MD-03-6355-00

CHAIN GUIDE MOUNT REAR, BOTTOM

116

1

MD-03-6356-00

CHAIN GUIDE MOUNT FRONT, TOP

117

1

MD-03-6357-00

CHAIN GUIDE MOUNT REAR, TOP

118

1

MD-03-6358-00

CHAIN GUIDE MOUNT FRONT, BOTTOM

119

1

MD-03-6359-00

CHAIN GUIDE MOUNT REAR, BOTTOM

120

4

MD-07-6410-00

TENSION SCREW

121

4

MD-10-0095-01

DISCHARGE PULLEY COVER

122

4

MD-10-0117-00

DISCHARGE IDLER PULLEY

123

2

MD-10-0125-03

DISCHARGE PULLEY SPACER

11

86

107

109

66

108

71

72

73

51

52

75

72

10

55

91

NOTES:

1. USE STAINLESS STEEL HARDWARE UNLESS OTHERWISE SPECIFIED.

2. CARTON CENTER SUPPORTS NOT SHOWN.

UNLESS OTHERWISE SPECIFIED:

DIMENSIONS ARE IN INCHES

TOLERANCES:

FRACTIONAL ± .015

ANGULAR: MACH±0.5° BEND ±5°

TWO PLACE DECIMAL ± .010

THREE PLACE DECIMAL ± .005

INTERPRET GEOMETRIC TOLERANCING PER:

MATERIAL

FINISH

PROPRIETARY AND CONFIDENTIAL

THE INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF SWITCHBACK GROUP. ANY REPRODUCTION IN PART OR AS A WHOLE WITHOUT THE WRITTEN PERMISSION OF SWITCHBACK GROUP IS PROHIBITED.

NAME

DATE

DRAWN

DESIGNER

ENG APPR.

MFG APPR.

Q.A.

EST. WEIGHT (lbs):

DO NOT SCALE DRAWING

REVISIONS

REV.

DESCRIPTION

DATE

INITIALS

SIZE

DWG. NO.

REV

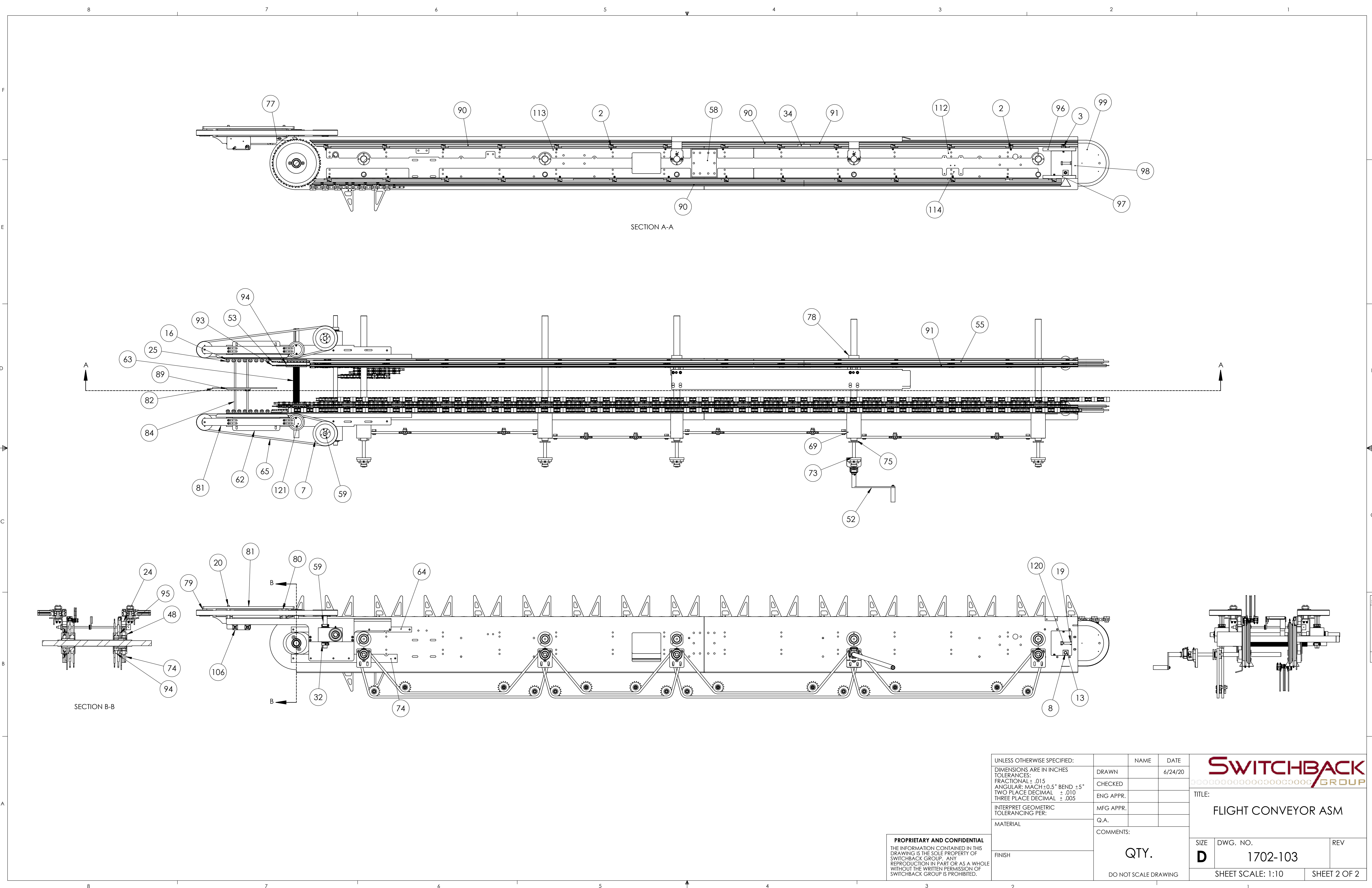
SHEET SCALE: 1:10

SHEET 1 OF 2

SWITCHBACK GROUP

TITLE:

FLIGHT CONVEYOR ASM



SECTION A-A

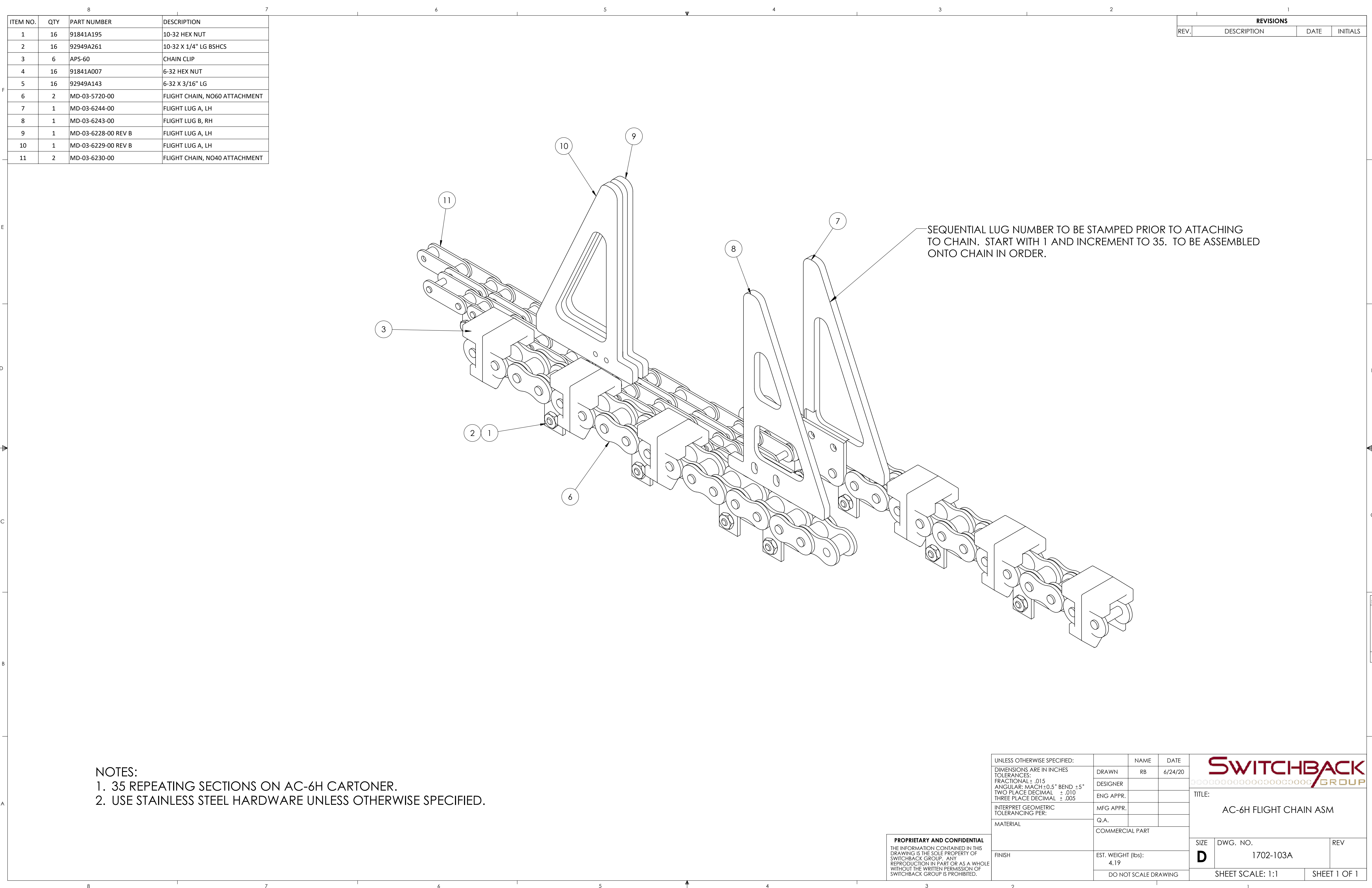
SECTION B-B

**PROPRIETARY AND CONFIDENTIAL**  
THE INFORMATION CONTAINED IN THIS  
DRAWING IS THE SOLE PROPERTY OF  
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WITHOUT THE WRITTEN PERMISSION OF  
SWITCHBACK GROUP IS PROHIBITED.

|                                                                                                                                                                                                                                                          |                      |      |         |
|----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|----------------------|------|---------|
| UNLESS OTHERWISE SPECIFIED:<br>DIMENSIONS ARE IN INCHES<br>TOLERANCES:<br>FRACTIONAL ± .015<br>ANGULAR: MACH ± 0.5° BEND ± 5°<br>TWO PLACE DECIMAL ± .010<br>THREE PLACE DECIMAL ± .005<br>INTERPRET GEOMETRIC<br>TOLERANCING PER:<br>MATERIAL<br>FINISH |                      | NAME | DATE    |
|                                                                                                                                                                                                                                                          | DRAWN                |      | 6/24/20 |
|                                                                                                                                                                                                                                                          | CHECKED              |      |         |
|                                                                                                                                                                                                                                                          | ENG APPR.            |      |         |
|                                                                                                                                                                                                                                                          | MFG APPR.            |      |         |
|                                                                                                                                                                                                                                                          | Q.A.                 |      |         |
|                                                                                                                                                                                                                                                          | COMMENTS:            |      |         |
|                                                                                                                                                                                                                                                          | QTY.                 |      |         |
|                                                                                                                                                                                                                                                          | DO NOT SCALE DRAWING |      |         |

|                               |                      |              |
|-------------------------------|----------------------|--------------|
| <b>SWITCHBACK</b><br>GROUP    |                      |              |
| TITLE:<br>FLIGHT CONVEYOR ASM |                      |              |
| SIZE<br><b>D</b>              | DWG. NO.<br>1702-103 | REV          |
| SHEET SCALE: 1:10             |                      | SHEET 2 OF 2 |

REV  
D 1702-103



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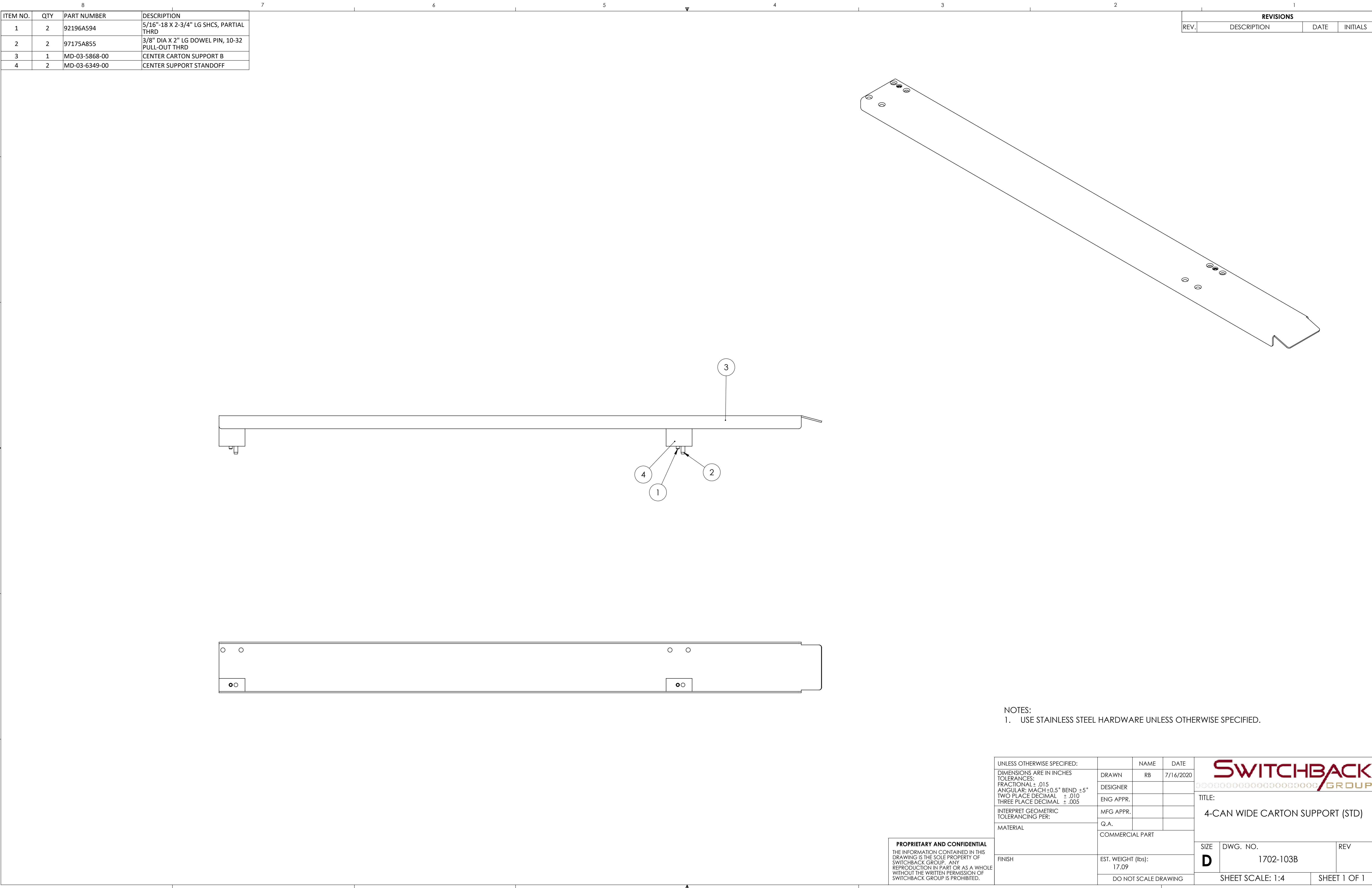
| ITEM NO. | QTY | PART NUMBER         | DESCRIPTION                   |
|----------|-----|---------------------|-------------------------------|
| 1        | 16  | 91841A195           | 10-32 HEX NUT                 |
| 2        | 16  | 92949A261           | 10-32 X 1/4" LG BSHCS         |
| 3        | 6   | APS-60              | CHAIN CLIP                    |
| 4        | 16  | 91841A007           | 6-32 HEX NUT                  |
| 5        | 16  | 92949A143           | 6-32 X 3/16" LG               |
| 6        | 2   | MD-03-5720-00       | FLIGHT CHAIN, NO60 ATTACHMENT |
| 7        | 1   | MD-03-6244-00       | FLIGHT LUG A, LH              |
| 8        | 1   | MD-03-6243-00       | FLIGHT LUG B, RH              |
| 9        | 1   | MD-03-6228-00 REV B | FLIGHT LUG A, LH              |
| 10       | 1   | MD-03-6229-00 REV B | FLIGHT LUG A, LH              |
| 11       | 2   | MD-03-6230-00       | FLIGHT CHAIN, NO40 ATTACHMENT |

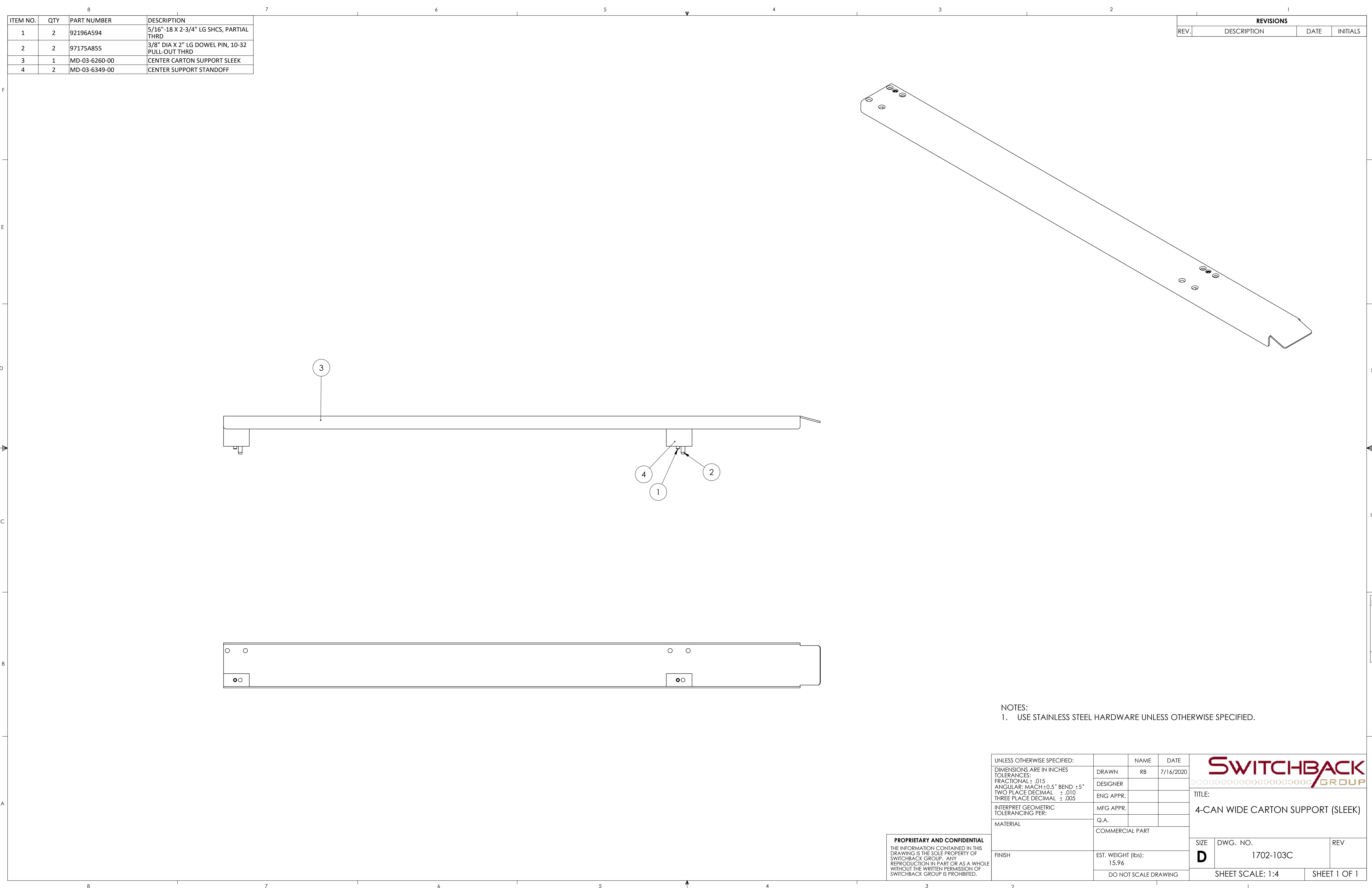
| REVISIONS |             |      |          |
|-----------|-------------|------|----------|
| REV.      | DESCRIPTION | DATE | INITIALS |

- NOTES:
- 35 REPEATING SECTIONS ON AC-6H CARTONER.
  - USE STAINLESS STEEL HARDWARE UNLESS OTHERWISE SPECIFIED.

**PROPRIETARY AND CONFIDENTIAL**  
THE INFORMATION CONTAINED IN THIS  
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WITHOUT THE WRITTEN PERMISSION OF  
SWITCHBACK GROUP IS PROHIBITED.

|                                                                                                                                                            |  |                            |    |                  |  |                                                                                       |  |
|------------------------------------------------------------------------------------------------------------------------------------------------------------|--|----------------------------|----|------------------|--|---------------------------------------------------------------------------------------|--|
| UNLESS OTHERWISE SPECIFIED:                                                                                                                                |  | NAME                       |    | DATE             |  |  |  |
| DIMENSIONS ARE IN INCHES<br>TOLERANCES:<br>FRACTIONAL ± .015<br>ANGULAR: MACH±0.5° BEND ±5°<br>TWO PLACE DECIMAL    ± .010<br>THREE PLACE DECIMAL   ± .005 |  | DRAWN                      | RB | 6/24/20          |  | TITLE:<br><br>AC-6H FLIGHT CHAIN ASM                                                  |  |
|                                                                                                                                                            |  | DESIGNER                   |    |                  |  |                                                                                       |  |
|                                                                                                                                                            |  | ENG APPR.                  |    |                  |  |                                                                                       |  |
|                                                                                                                                                            |  | MFG APPR.                  |    |                  |  |                                                                                       |  |
|                                                                                                                                                            |  | Q.A.                       |    |                  |  |                                                                                       |  |
| MATERIAL                                                                                                                                                   |  | COMMERCIAL PART            |    |                  |  | SIZE<br><b>D</b><br><br>DWG. NO.<br>1702-103A<br><br>REV                              |  |
| FINISH                                                                                                                                                     |  | EST. WEIGHT (lbs):<br>4.19 |    | SHEET SCALE: 1:1 |  |                                                                                       |  |
|                                                                                                                                                            |  | DO NOT SCALE DRAWING       |    |                  |  |                                                                                       |  |





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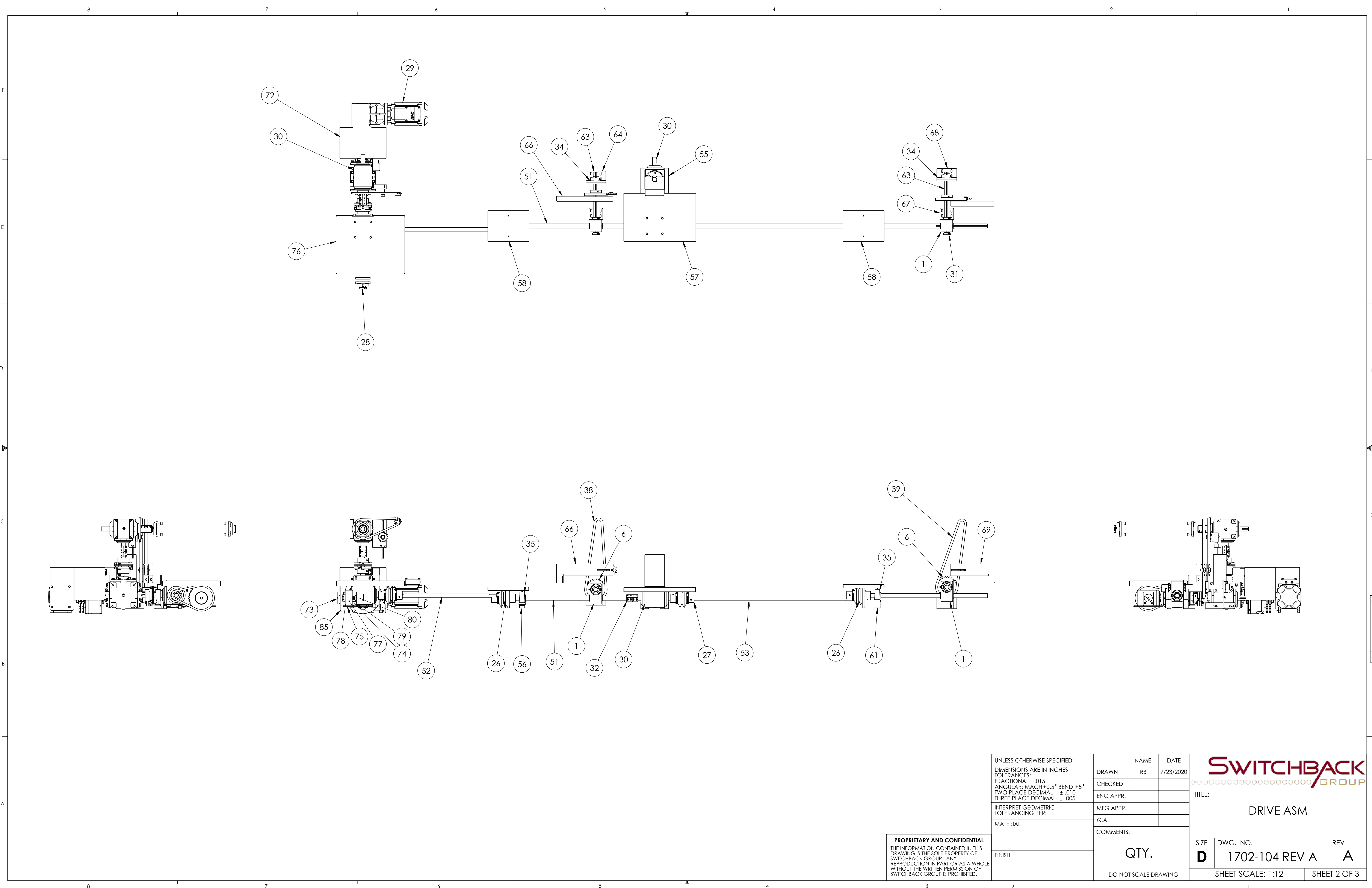
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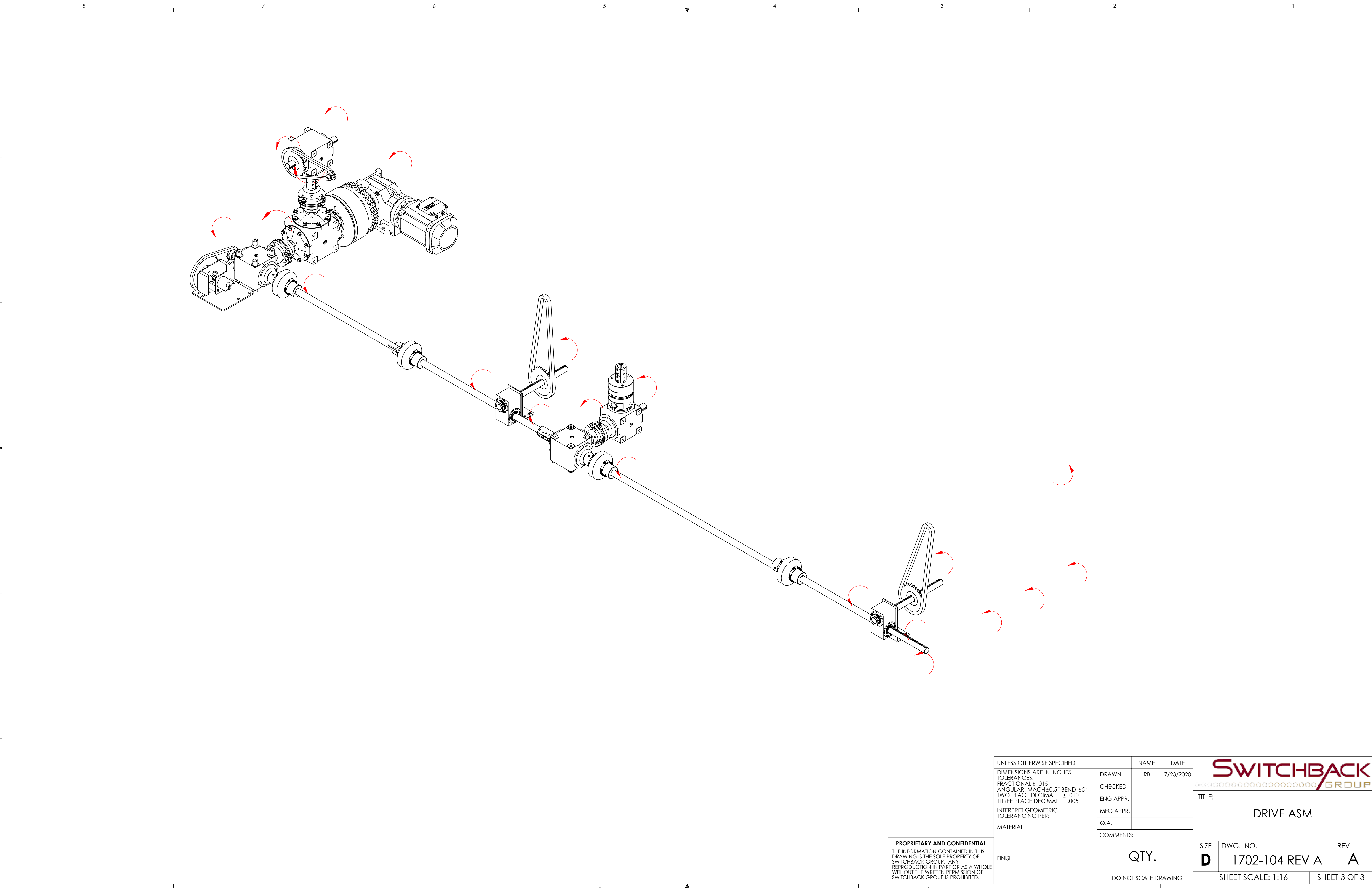
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**PROPRIETARY AND CONFIDENTIAL**  
THE INFORMATION CONTAINED IN THIS  
DRAWING IS THE SOLE PROPERTY OF  
SWITCHBACK GROUP. ANY  
REPRODUCTION IN PART OR AS A WHOLE  
WITHOUT THE WRITTEN PERMISSION OF  
SWITCHBACK GROUP IS PROHIBITED.

|                                                                                                                                                                                                         |  |                                  |              |
|---------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--|----------------------------------|--------------|
| UNLESS OTHERWISE SPECIFIED:                                                                                                                                                                             |  | NAME                             | DATE         |
| DIMENSIONS ARE IN INCHES<br>TOLERANCES:<br>FRACTIONAL ± .015<br>ANGULAR: MACH ± 0.5° BEND ± 5°<br>TWO PLACE DECIMAL ± .010<br>THREE PLACE DECIMAL ± .005<br><br>INTERPRET GEOMETRIC<br>TOLERANCING PER: |  | DRAWN                            | RB 7/23/2020 |
|                                                                                                                                                                                                         |  | CHECKED                          |              |
|                                                                                                                                                                                                         |  | ENG APPR.                        |              |
|                                                                                                                                                                                                         |  | MFG APPR.                        |              |
|                                                                                                                                                                                                         |  | Q.A.                             |              |
| MATERIAL                                                                                                                                                                                                |  | COMMENTS:                        |              |
|                                                                                                                                                                                                         |  |                                  |              |
| FINISH                                                                                                                                                                                                  |  | QTY.<br><br>DO NOT SCALE DRAWING |              |
|                                                                                                                                                                                                         |  |                                  |              |

|                         |                |          |              |
|-------------------------|----------------|----------|--------------|
| <b>SWITCHBACK GROUP</b> |                |          |              |
| TITLE:                  |                |          |              |
| DRIVE ASM               |                |          |              |
| SIZE                    | DWG. NO.       | REV      |              |
| <b>D</b>                | 1702-104 REV A | <b>A</b> |              |
| SHEET SCALE: 1:12       |                |          | SHEET 2 OF 3 |



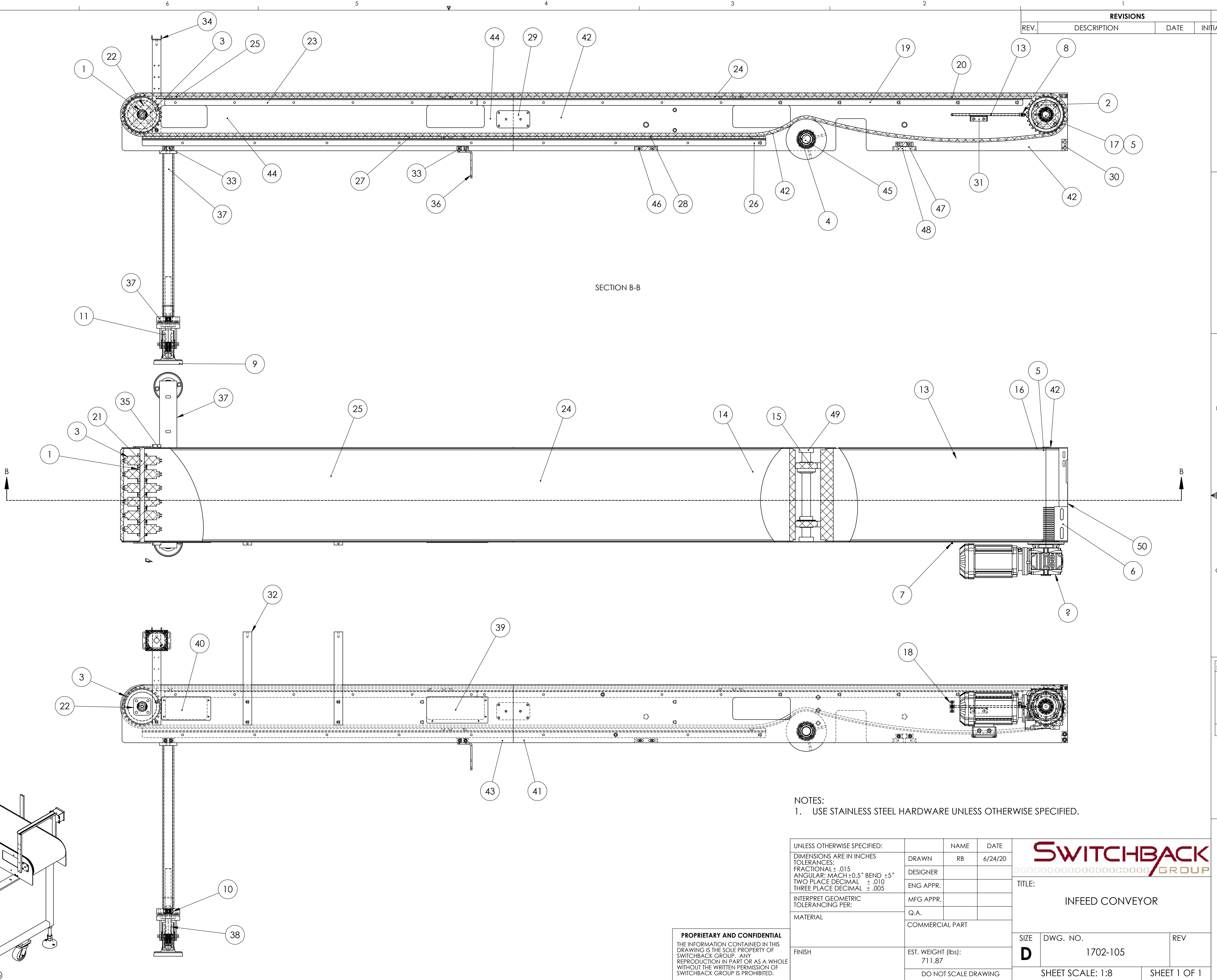
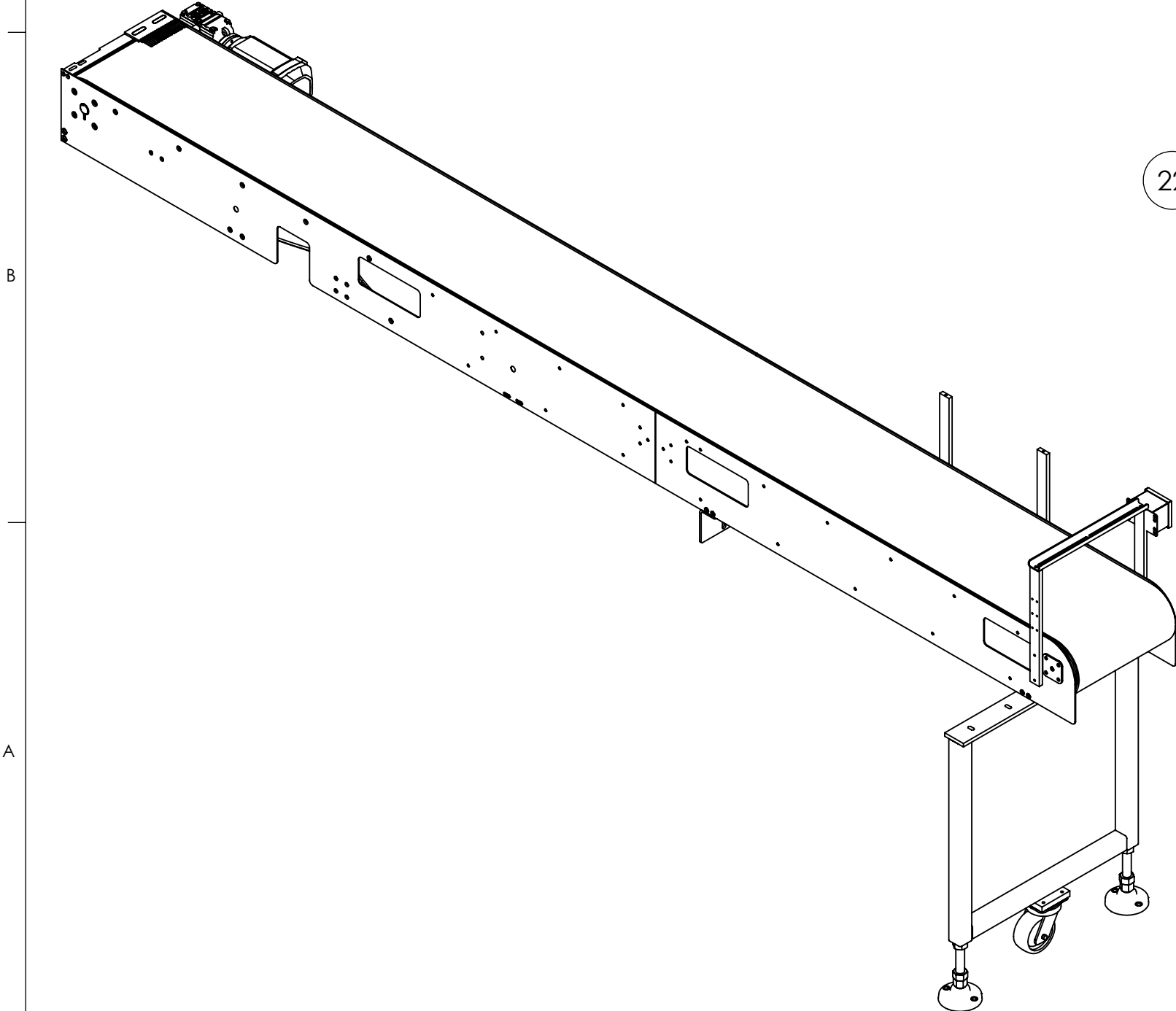
**PROPRIETARY AND CONFIDENTIAL**  
THE INFORMATION CONTAINED IN THIS  
DRAWING IS THE SOLE PROPERTY OF  
SWITCHBACK GROUP. ANY  
REPRODUCTION IN PART OR AS A WHOLE  
WITHOUT THE WRITTEN PERMISSION OF  
SWITCHBACK GROUP IS PROHIBITED.

|                                      |  |                      |      |
|--------------------------------------|--|----------------------|------|
| UNLESS OTHERWISE SPECIFIED:          |  | NAME                 | DATE |
| DIMENSIONS ARE IN INCHES             |  | DRAWN                | RB   |
| TOLERANCES:                          |  | CHECKED              |      |
| FRACTIONAL ± .015                    |  | ENG APPR.            |      |
| ANGULAR: MACH ± 0.5° BEND ± 5°       |  | MFG APPR.            |      |
| TWO PLACE DECIMAL ± .010             |  | Q.A.                 |      |
| THREE PLACE DECIMAL ± .005           |  | COMMENTS:            |      |
| INTERPRET GEOMETRIC TOLERANCING PER: |  | QTY.                 |      |
| MATERIAL                             |  | DO NOT SCALE DRAWING |      |
| FINISH                               |  |                      |      |

|                   |                |     |              |
|-------------------|----------------|-----|--------------|
| TITLE:            |                |     |              |
| DRIVE ASM         |                |     |              |
| SIZE              | DWG. NO.       | REV |              |
| D                 | 1702-104 REV A | A   |              |
| SHEET SCALE: 1:16 |                |     | SHEET 3 OF 3 |



| ITEM NO. | QTY | PART NUMBER                 | DESCRIPTION                                                                               |
|----------|-----|-----------------------------|-------------------------------------------------------------------------------------------|
| 1        | 12  | ENSP45-16-A                 | THIN LINE SPLIT SHAFT COLLAR, 1" BORE, .394 WIDE                                          |
| 2        | 6   | KU8500-28T-1-1_4 KEYED BORE | 8500 SERIES SPROCKET, 28T, 1-1/4" KEYED BORE                                              |
| 3        | 6   | KU8500-28T-1IN IDLER BORE   | 8500 SERIES SPROCKET, 28T, 1" ROUND BORE, THERMOPLASTIC                                   |
| 4        | 2   | SSER 208-24                 | BEARING INSERT, 1-1/2" BORE, CORROSION RESISTANT                                          |
| 5        | 1   | SUCTF 206-20                | 4-BOLT FLANGE BEARING, 1-1/4" BORE                                                        |
| 6        | 1   | 10131490                    | TRANSFER COMB KIT, 4.5" LG                                                                |
| 7        | 1   | 1293K11                     | GREASE FITTING, 1/8" NPT MALE, CHECK BALL                                                 |
| 8        | 1   | 9006T31                     | GREASE FITTING ADAPTER, 1/4"-28 MALE TO 1/8 NPT FEMALE                                    |
| 9        | 2   | 60985K69                    | LEVELING MOUNT, 5" DIA.                                                                   |
| 10       | 4   | 94804A038                   | HEX NUT, 1"-8                                                                             |
| 11       | 1   | 22455T21                    | HIGH-CAPACITY GLADIATOR SWIVEL CASTER, 5" dia WHEEL, 6-1/2" OVERALL HEIGHT, 1500lb CAP    |
| 12       | 1   | SAF47DRN80M4_DH 90X         | GEARMOTOR, 1HP, 75 RPM OUT, 460 VAC, M1, 1.25 SS HOLLOW SHAFT, 160mm FLANGE, SIDE A, 90/X |
| 13       | 1   | 1702-105 GREASE HOSE        | GREASE HOSE, 36" LG, 1/8" NPT MALE ENDS                                                   |
| 14       | 1   | 1702-105 INFEED BELT        | SERIES 8507, 16" WD, 336" LG, HP                                                          |
| 15       | 2   | MD-05-6936-00 REV A         | IDLER WHEEL, 7 IN.                                                                        |
| 16       | 1   | MD-05-7595-00               | FOUR BOLT BEARING SPACER                                                                  |
| 17       | 1   | MD-05-7596-00               | INFEED DRIVE SHAFT                                                                        |
| 18       | 1   | MD-05-7597-00               | GREASE BLOCK                                                                              |
| 19       | 1   | MD-05-7598-00               | INFEED BED SUPPORT A                                                                      |
| 20       | 1   | MD-05-7599-00               | INFEED BED A                                                                              |
| 21       | 1   | MD-05-7600-00               | INFEED IDLER SHAFT                                                                        |
| 22       | 2   | MD-05-7601-00               | INFEED IDLER MOUNT                                                                        |
| 23       | 1   | MD-05-7602-00               | INFEED BED SUPPORT B                                                                      |
| 24       | 1   | MD-05-7603-00               | INFEED BED B                                                                              |
| 25       | 1   | MD-05-7604-00               | INFEED BED C                                                                              |
| 26       | 1   | MD-05-7606-00               | INFEED BED SUPPORT C                                                                      |
| 27       | 1   | MD-05-7607-00               | INFEED BED D                                                                              |
| 28       | 1   | MD-05-7608-00               | INFEED BED E                                                                              |
| 29       | 2   | MD-05-7609-00               | INFEED SPLICE PLATE                                                                       |
| 30       | 1   | MD-05-7610-00               | SUPPORT BAR 105A                                                                          |
| 31       | 1   | MD-05-7611-00               | CROSS BRACE 105A                                                                          |
| 32       | 3   | MD-05-7612-00               | LANE GUIDE SUPPORT UPRIGHT B                                                              |
| 33       | 2   | MD-05-7616-00               | INFEED LOWER CROSSBAR                                                                     |
| 34       | 1   | MD-05-7631-00               | LANE GUIDE SUPPORT D                                                                      |
| 35       | 1   | MD-05-7683-00               | LANE GUIDE SUPPORT UPRIGHT B                                                              |
| 36       | 1   | MD-05-7717-00               | INFEED MOUNT BRACKET                                                                      |
| 37       | 1   | MD-05-7718-00 REV A         | OUTBOUND LEG                                                                              |
| 38       | 2   | MD-05-7719-00               | FOOT STUD                                                                                 |
| 39       | 1   | MD-05-7721-00               | PORTHOLE COVER A                                                                          |
| 40       | 1   | MD-05-7722-00               | PORTHOLE COVER B                                                                          |
| 41       | 1   | MD-05-7769-00               | INFEED PANEL A - RH                                                                       |
| 42       | 1   | MD-05-7770-00               | INFEED PANEL B - RH                                                                       |
| 43       | 1   | MD-05-7771-00               | INFEED PANEL C                                                                            |
| 44       | 1   | MD-05-7772-00               | INFEED PANEL D - RH                                                                       |
| 45       | 1   | MD-05-8047-00               | RETURN ROLLER SHAFT                                                                       |
| 46       | 1   | MD-05-8048-00               | INFEED LOWER CROSSBAR B                                                                   |
| 47       | 1   | MD-05-8049-00               | INFEED LOWER CROSSBAR A                                                                   |
| 48       | 1   | MD-05-8050-00               | CONVEYOR ADJ CROSSBAR                                                                     |
| 49       | 2   | MD-05-8051-00               | SHAFT SUPPORT BLOCK                                                                       |
| 50       | 1   | MD-05-10302-00 REV A        | DISCHARGE CROSS                                                                           |



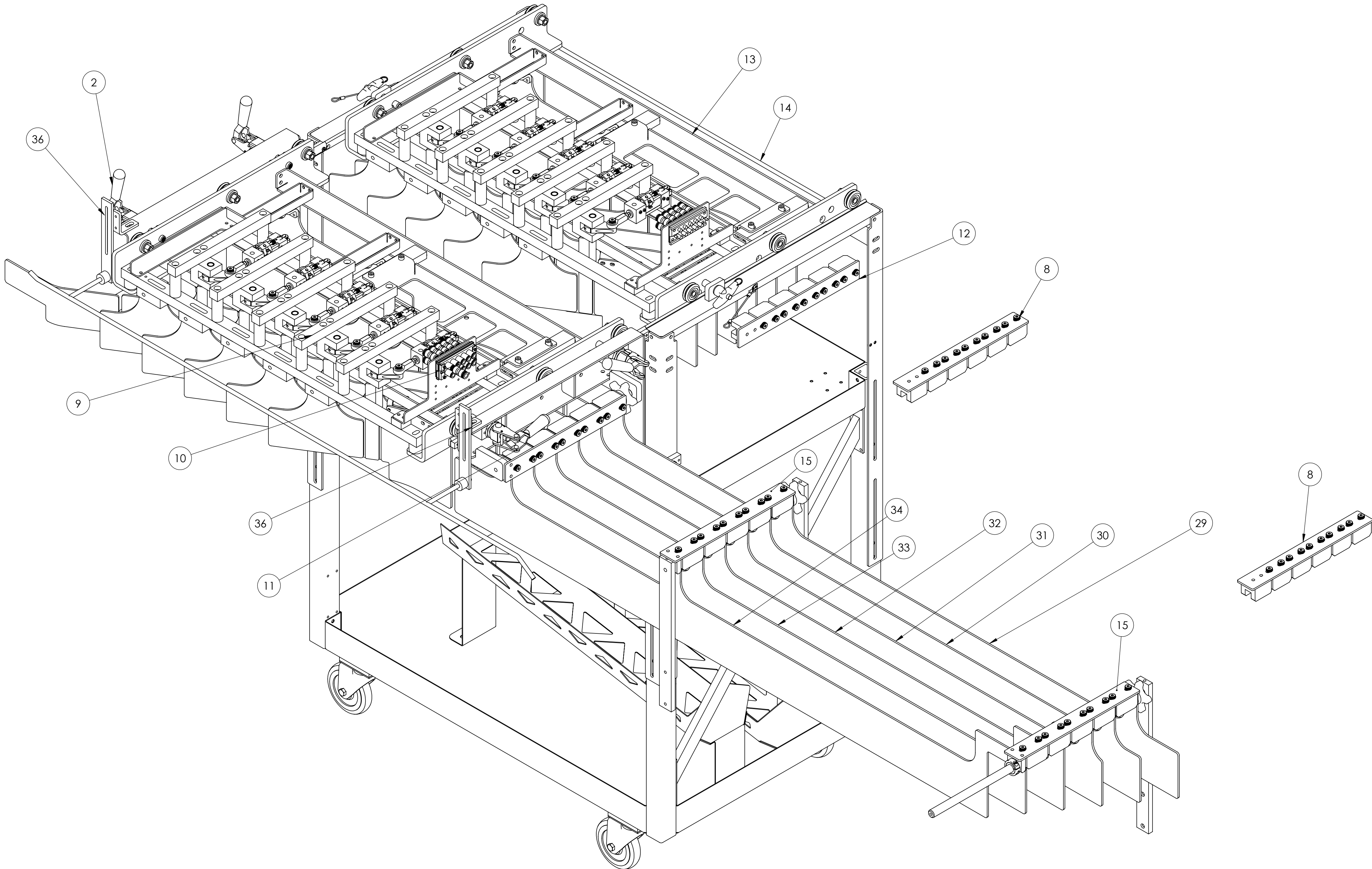
NOTES:  
1. USE STAINLESS STEEL HARDWARE UNLESS OTHERWISE SPECIFIED.

|                                                                                                                                                       |  |                              |      |                                        |                               |              |     |
|-------------------------------------------------------------------------------------------------------------------------------------------------------|--|------------------------------|------|----------------------------------------|-------------------------------|--------------|-----|
| UNLESS OTHERWISE SPECIFIED:                                                                                                                           |  | NAME                         | DATE | <div>SWITCHBACK</div> <div>GROUP</div> |                               |              |     |
| DIMENSIONS ARE IN INCHES<br>TOLERANCES:<br>FRACTIONAL ± .015<br>ANGULAR: MACH±0.5° BEND ±5°<br>TWO PLACE DECIMAL ± .010<br>THREE PLACE DECIMAL ± .005 |  | DRAWN                        | RB   |                                        |                               | 6/24/20      |     |
| INTERPRET GEOMETRIC<br>TOLERANCING PER:                                                                                                               |  | DESIGNER                     |      |                                        |                               |              |     |
| MATERIAL                                                                                                                                              |  | ENG APPR.                    |      |                                        |                               |              |     |
|                                                                                                                                                       |  | MFG APPR.                    |      |                                        | TITLE:<br><br>INFEED CONVEYOR |              |     |
|                                                                                                                                                       |  | Q.A.                         |      |                                        |                               |              |     |
|                                                                                                                                                       |  | COMMERCIAL PART              |      |                                        |                               |              |     |
| FINISH                                                                                                                                                |  | EST. WEIGHT (lbs):<br>711.87 |      | SIZE<br><b>D</b>                       | DWG. NO.<br>1702-105          |              | REV |
|                                                                                                                                                       |  | DO NOT SCALE DRAWING         |      | SHEET SCALE: 1:8                       |                               | SHEET 1 OF 1 |     |

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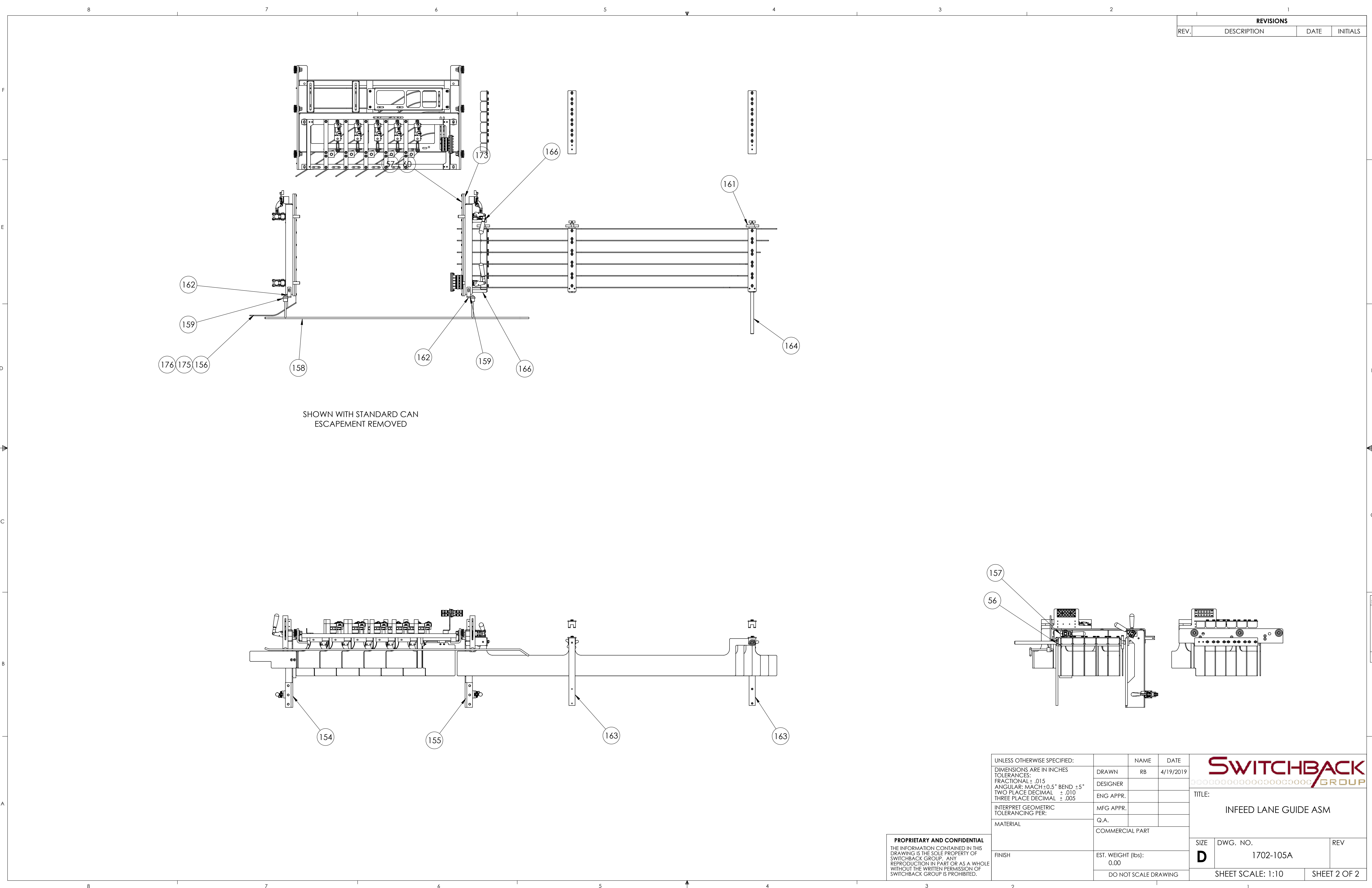
| ITEM NO. | QTY. | PART NUMBER          | DESCRIPTION                                 |
|----------|------|----------------------|---------------------------------------------|
| 1        | 1    | PG3_8-5_16           | PUSH TO CONNECT 3/8-5/16                    |
| 2        | 4    | 5093A76              | PUSH/PULL TOGGLE CLAMP, 700 LB., 18-8 SS    |
| 3        | 1    | 6438K55              | THREADED SHAFT COLLAR, 3/4-10, 303 SS       |
| 4        | 18   | 93615A415            | 1/4"-20 X 3/4" LG LOW-PROFILE SHCS, 18-8 SS |
| 5        | 2    | Destaco_331_SS.prt   | PULL ACTION SS CLAMP                        |
| 6        | 1    | KDM10S-08            | MULTI-CONNECTOR, SOCKET SIDE, 10 X 8mm TUBE |
| 7        | 2    | T3SS-2475-9          | V-TRACK, SIZE 3, 24.75" LG., 420 STAINLESS  |
| 8        | 2    | 1702-105AA           | GUIDE SPACER ASSEMBLY, SLEEK                |
| 9        | 1    | 1702-105B            | LOAD ZONE ESCAPEMENT, STD CANS              |
| 10       | 1    | 1702-105E            | PASS-THRU LANE GUIDE ASM                    |
| 11       | 1    | 1702-105M            | GUIDE SPACER ASSEMBLY, STANDARD             |
| 12       | 1    | 1702-105N            | GUIDE SPACER ASSEMBLY, SLEEK                |
| 13       | 1    | 1702-105Q            | LOAD ZONE ESCAPEMENT, SLEEK CANS            |
| 14       | 1    | 1702-105R            | CART, CHANGE PARTS                          |
| 15       | 2    | 1702-105Z            | GUIDE SPACER ASSEMBLY, STANDARD             |
| 16       | 1    | MD-05-10304-00       | CARRAGE MNT DS                              |
| 17       | 1    | MD-05-10305-00       | CARRAGE MNT DS                              |
| 18       | 1    | MD-05-10308-00 REV A | FIXED END GUIDE                             |
| 19       | 4    | MD-05-10465-00       | TOGGLE MNT                                  |
| 20       | 1    | MD-05-10553-00       | TOP FLAP UP PLOW                            |
| 21       | 2    | MD-05-10554-00       | TOP FLAP UP PLOW MOUNT                      |
| 22       | 2    | MD-05-10926-00       | SPACER                                      |
| 23       | 3    | MD-05-7990-00        | LANE CLAMP KNOB                             |
| 24       | 2    | MD-05-8328-00        | SUPPORT CLIP                                |
| 25       | 3    | MD-05-8657-00        | UPRIGHT                                     |
| 26       | 1    | MD-05-8658-00        | THREADED ROD LONG                           |
| 27       | 2    | MD-05-8659-00        | THREADED ROD SHORT                          |
| 28       | 2    | MD-05-8660-00        | CROSS MOUNT                                 |
| 29       | 1    | MD-05-8661-00 REV A  | GUIDE #1                                    |
| 30       | 1    | MD-05-8662-00 REV A  | GUIDE #2                                    |
| 31       | 1    | MD-05-8663-00 REV A  | GUIDE #3                                    |
| 32       | 1    | MD-05-8664-00 REV A  | GUIDE #4                                    |
| 33       | 1    | MD-05-8665-00 REV A  | GUIDE #5                                    |
| 34       | 1    | MD-05-8666-00 REV A  | GUIDE #6                                    |
| 35       | 2    | MD-05-8678-01        | V-TRACK SUPPORT                             |
| 36       | 2    | MD-05-8680-00 REV A  | NUT PLATE                                   |
| 37       | 1    | MD-05-8684-00        | VERT MNT BLOCK                              |
| 38       | 1    | MD-05-8685-00 REV A  | HORZ MNT BLOCK                              |
| 39       | 2    | MD-05-9645-00        | DESTACO BOLT PAD                            |



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|--------------------------------------|----------------------|------|---------|
| UNLESS OTHERWISE SPECIFIED:          |                      | NAME | DATE    |
| DIMENSIONS ARE IN INCHES             | DRAWN                | RB   | 6/24/20 |
| TOLERANCES:                          | DESIGNER             |      |         |
| FRACTIONAL ± .015                    | ENG APPR.            |      |         |
| ANGULAR: MACH ± 0.5° BEND ± 5°       | MFG APPR.            |      |         |
| TWO PLACE DECIMAL ± .010             | Q.A.                 |      |         |
| THREE PLACE DECIMAL ± .005           | COMMERCIAL PART      |      |         |
| INTERPRET GEOMETRIC TOLERANCING PER: |                      |      |         |
| MATERIAL                             |                      |      |         |
| FINISH                               | EST. WEIGHT (lbs):   |      |         |
|                                      | 0.00                 |      |         |
|                                      | DO NOT SCALE DRAWING |      |         |

|                         |           |              |
|-------------------------|-----------|--------------|
| <b>SWITCHBACK GROUP</b> |           |              |
| TITLE:                  |           |              |
| INFEED LANE GUIDE ASM   |           |              |
| SIZE                    | DWG. NO.  | REV          |
| <b>D</b>                | 1702-105A |              |
| SHEET SCALE: 1:5        |           | SHEET 1 OF 2 |



| REVISIONS |             |      |          |
|-----------|-------------|------|----------|
| REV.      | DESCRIPTION | DATE | INITIALS |

SHOWN WITH STANDARD CAN  
ESCAPEMENT REMOVED

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| UNLESS OTHERWISE SPECIFIED:                                                                                                                                                                         |                            | NAME | DATE      |
| DIMENSIONS ARE IN INCHES<br>TOLERANCES:<br>FRACTIONAL ± .015<br>ANGULAR: MACH ± 0.5° BEND ± 5°<br>TWO PLACE DECIMAL ± .010<br>THREE PLACE DECIMAL ± .005<br>INTERPRET GEOMETRIC<br>TOLERANCING PER: | DRAWN                      | RB   | 4/19/2019 |
|                                                                                                                                                                                                     | DESIGNER                   |      |           |
|                                                                                                                                                                                                     | ENG APPR.                  |      |           |
|                                                                                                                                                                                                     | MFG APPR.                  |      |           |
|                                                                                                                                                                                                     | Q.A.                       |      |           |
| MATERIAL                                                                                                                                                                                            | COMMERCIAL PART            |      |           |
| FINISH                                                                                                                                                                                              | EST. WEIGHT (lbs):<br>0.00 |      |           |
|                                                                                                                                                                                                     | DO NOT SCALE DRAWING       |      |           |



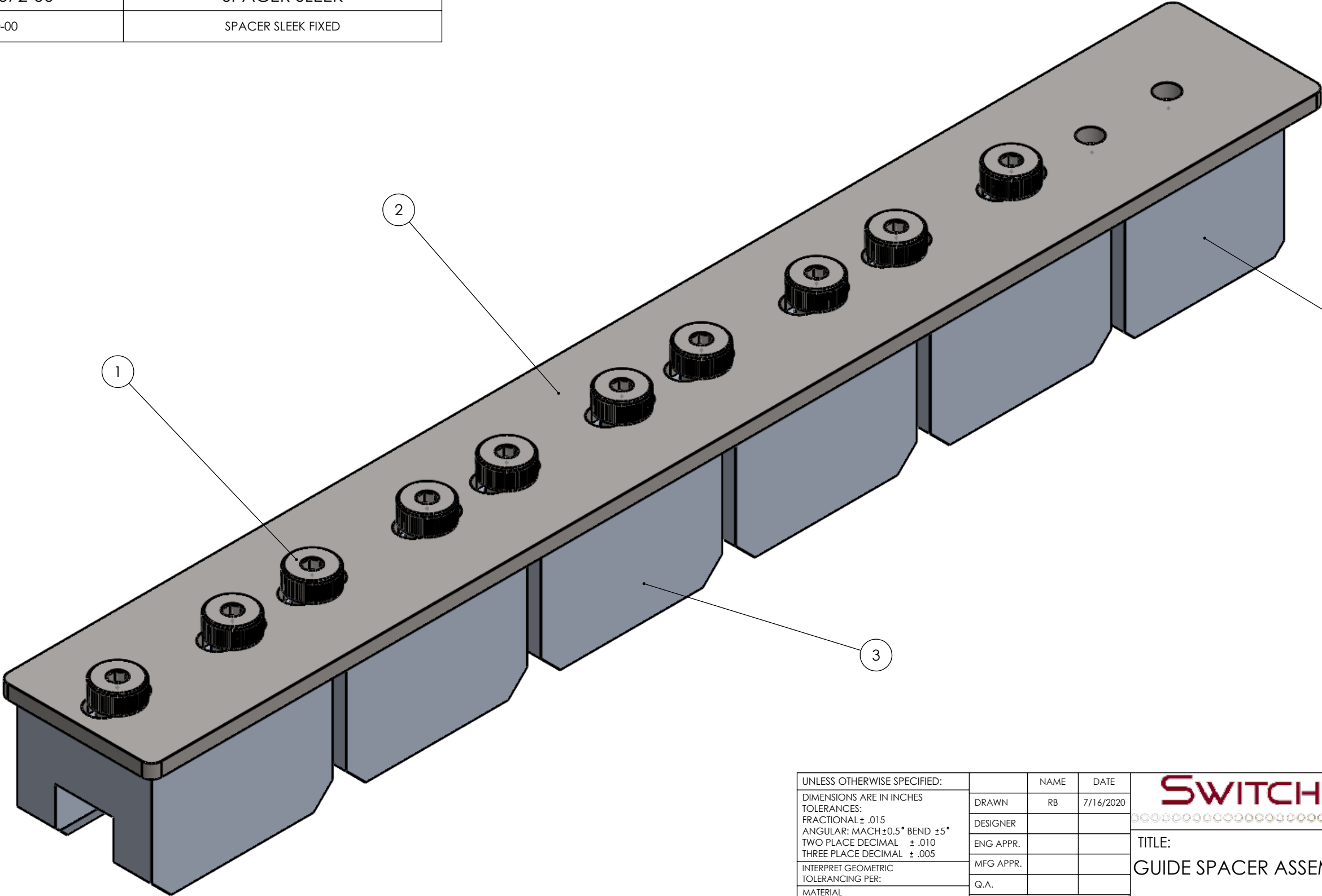
TITLE:

INFEEED LANE GUIDE ASM

|                   |           |              |
|-------------------|-----------|--------------|
| SIZE              | DWG. NO.  | REV          |
| <b>D</b>          | 1702-105A |              |
| SHEET SCALE: 1:10 |           | SHEET 2 OF 2 |

| ITEM NO. | QTY. | PART NUMBER    | DESCRIPTION                                               |
|----------|------|----------------|-----------------------------------------------------------|
| 1        | 10   | 90298A172      | SHOULDER BOLT, 3/8" DIA X 5/16" LG., 5/16-18 THD. 18-8 SS |
| 2        | 1    | MD-05-8668-00  | SPACER PLATE SLEEK                                        |
| 3        | 5    | MD-05-8672-00  | SPACER SLEEK                                              |
| 4        | 1    | MD-05-10980-00 | SPACER SLEEK FIXED                                        |

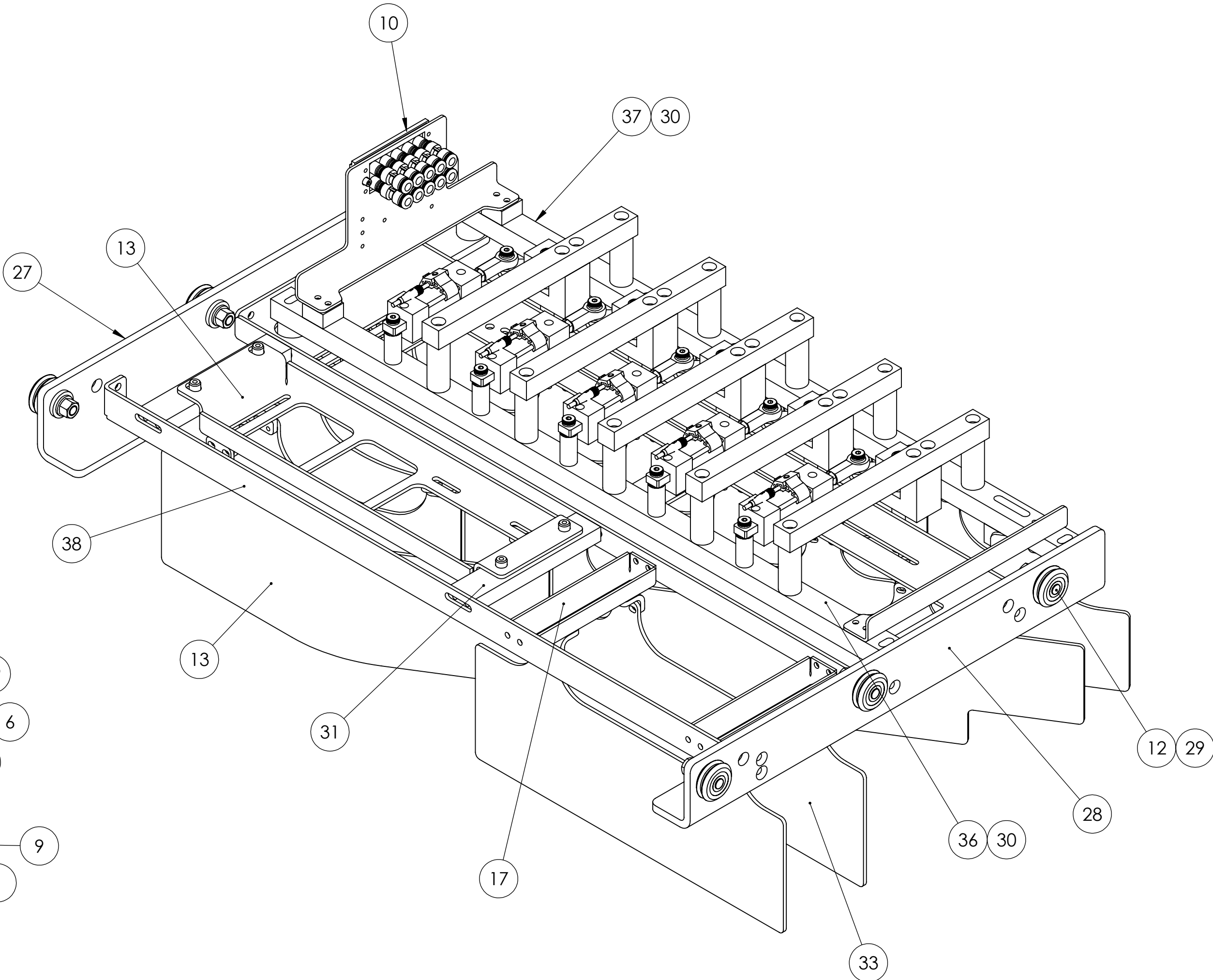
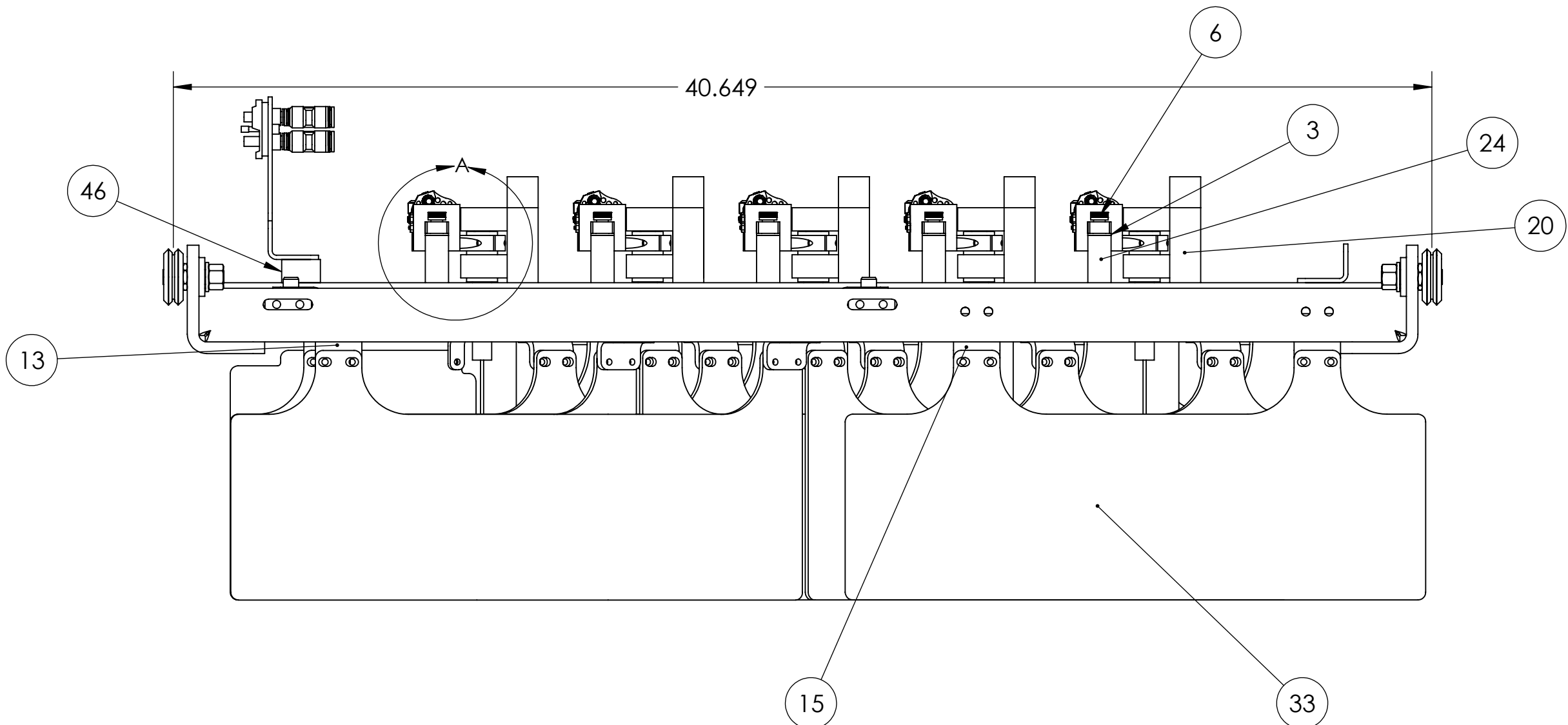
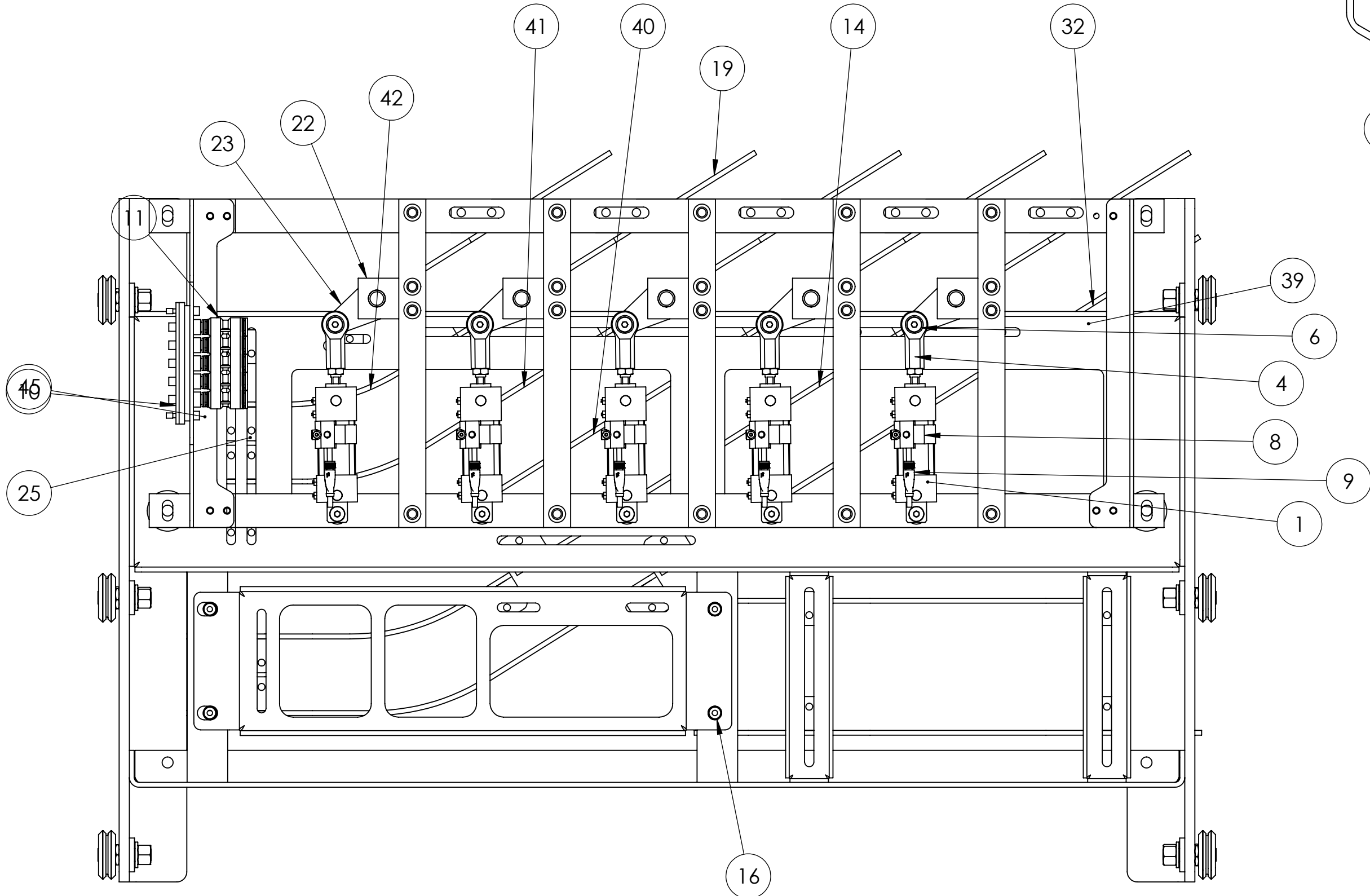
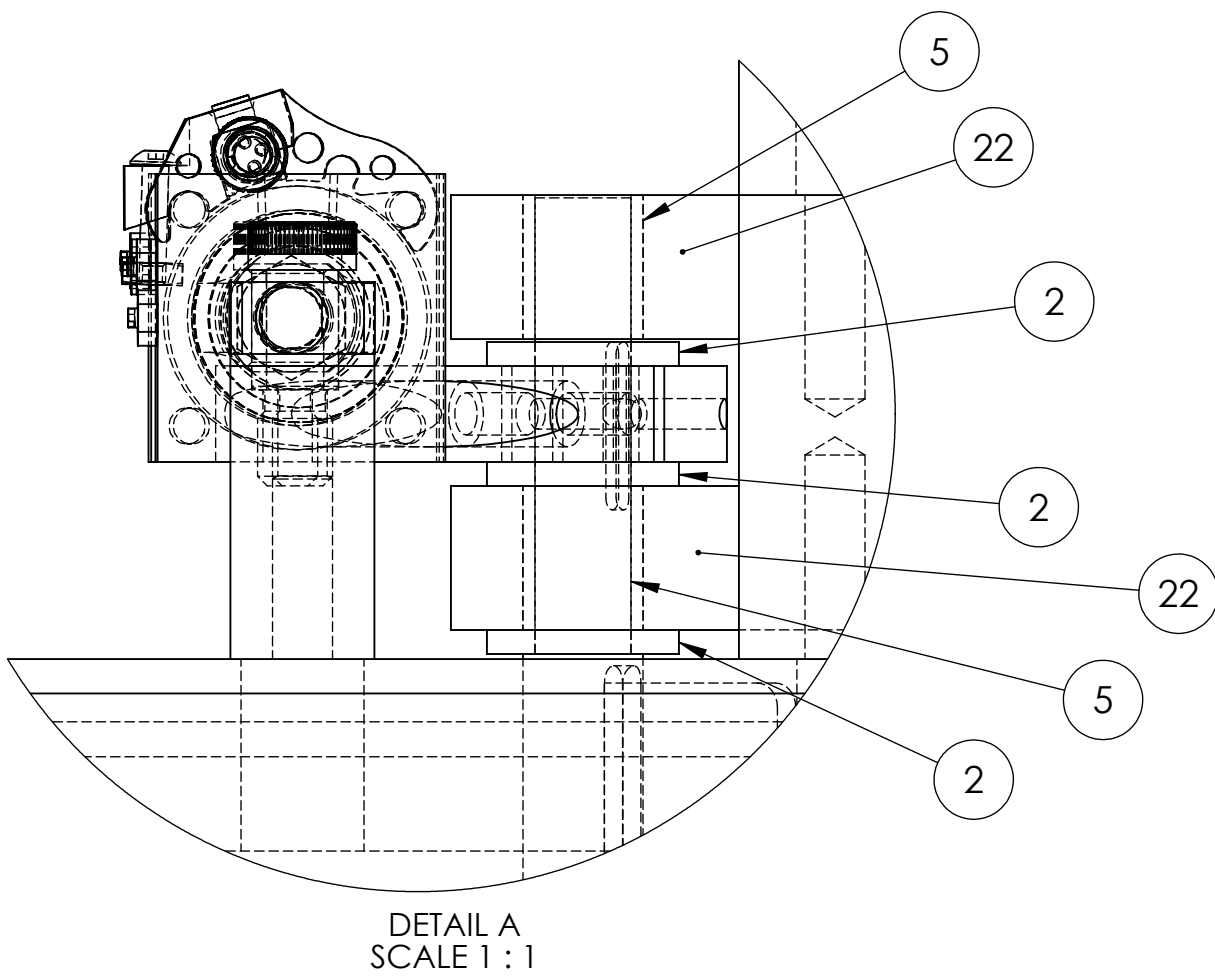
| REVISIONS |             |      |          |
|-----------|-------------|------|----------|
| REV.      | DESCRIPTION | DATE | INITIALS |



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|                                                                                                                                                        |  | DESIGNER                    |  |      |  |                             |  |                                        |  |              |  |
|                                                                                                                                                        |  | ENG APPR.                   |  |      |  |                             |  |                                        |  |              |  |
|                                                                                                                                                        |  | MFG APPR.                   |  |      |  |                             |  |                                        |  |              |  |
| INTERPRET GEOMETRIC<br>TOLERANCING PER:                                                                                                                |  | Q.A.                        |  |      |  |                             |  | TITLE:<br>GUIDE SPACER ASSEMBLY, SLEEK |  |              |  |
| MATERIAL                                                                                                                                               |  |                             |  |      |  |                             |  |                                        |  |              |  |
|                                                                                                                                                        |  | COMMERCIAL PART             |  |      |  |                             |  |                                        |  |              |  |
| FINISH                                                                                                                                                 |  | EST. WEIGHT (lbs):<br>4.479 |  |      |  | SIZE<br><b>B</b>            |  | DWG. NO.<br>1702-105AA                 |  | REV          |  |
|                                                                                                                                                        |  | DO NOT SCALE DRAWING        |  |      |  | SHEET SCALE: 1:1            |  |                                        |  | SHEET 1 OF 1 |  |

| ITEM NO. | QTY | PART NUMBER         | DESCRIPTION                                                                          |
|----------|-----|---------------------|--------------------------------------------------------------------------------------|
| 1        | 5   | AVP-1-1_8x1-P-D-E   | PENU CYL, 1-1/8" BORE, 1" STROKE, REAR PIVOT MOUNT, FLOW CTRLS, CUSHIONS, MAG PISTON |
| 2        | 15  | 5906K514            | THRUST WASHER, 1/2" ID X 1" OD X 1/8" LG                                             |
| 3        | 5   | 5906K511            | THRUST WASHER, 3/8" ID X 3/4" OD X 1/16" LG                                          |
| 4        | 5   | 59915K484           | ROD END, 3/8"-24 THRD, 3/8" BORE                                                     |
| 5        | 10  | 6391K214            | SLEEVE BEARING, 1/2" BORE, 3/4" LG, 5/8" OD                                          |
| 6        | 10  | 90298A621           | Ø3/8" X 5/8" LG SHOULDER SCREW, 5/16"-18 THRD                                        |
| 7        | 5   | 17524-2             | SOLID STATE SWITCH, PNP, M8 QD                                                       |
| 8        | 5   | 17000-33-5          | SWITCH BRACKET, 1-1/8" BORE                                                          |
| 9        | 5   | V3-GM-BK10M-PVC-U   | M8 CABLE, 3-PIN, STRAIGHT, 10M LG                                                    |
| 10       | 1   | KDM10P-08           | MULTI-CONNECTOR, PLUG SIDE, 10 X 8mm TUBE                                            |
| 11       | 10  | PG3_8-5_16          | PUSH TO CONNECT 3/8-5/16                                                             |
| 12       | 6   | SWAC3SSX            | STUDDED V-GROOVE GUIDE WHEEL, SIZE 3, STAINLESS                                      |
| 13       | 1   | 1702-105C           | CARTONING LANE GUIDE ASM, STD.                                                       |
| 14       | 1   | MD-05-7621-00       | LANE GUIDE 05                                                                        |
| 15       | 6   | MD-05-7629-00       | LANE GUIDE BRACKET A                                                                 |
| 16       | 4   | MD-05-7649-00       | ALINGMENT PIN A                                                                      |
| 17       | 2   | MD-05-7650-00       | LANE GUIDE SUPPORT E                                                                 |
| 18       | 5   | MD-05-7660-00       | LANE GUIDE MOUNT A                                                                   |
| 19       | 5   | MD-05-7661-00 REV B | LANE GUIDE 01                                                                        |
| 20       | 10  | MD-05-7664-00       | CROSSBAR UPRIGHT A                                                                   |
| 21       | 5   | MD-05-7665-00       | UPPER CROSSBAR A                                                                     |
| 22       | 5   | MD-05-7666-00       | LANE GATE BEARING BLOCK                                                              |
| 23       | 5   | MD-05-7667-00       | INDEXING FLAG LINK                                                                   |
| 24       | 5   | MD-05-7668-00       | CYLINDER PIVOT BLOCK                                                                 |
| 25       | 4   | MD-05-7673-00       | LANE GUIDE BRACKET K                                                                 |
| 26       | 5   | MD-05-7707-00       | INDEXING FLAG WELDMENT                                                               |
| 27       | 1   | MD-05-8698-00 REV A | ANGLE                                                                                |
| 28       | 1   | MD-05-8699-00 REV A | ANGLE                                                                                |
| 29       | 6   | MD-05-8700-01       | ROLLER SPACER                                                                        |
| 30       | 4   | MD-05-8702-00       | SPACER                                                                               |
| 31       | 2   | MD-05-8703-00       | CROSS BAR                                                                            |
| 32       | 1   | MD-05-8704-00       | GUIDE 1D FIXED                                                                       |
| 33       | 2   | MD-05-8705-00       | GUIDE PASS THRU                                                                      |
| 34       | 5   | MD-05-10309-00      | LANE GUIDE BRACKET                                                                   |
| 35       | 1   | MD-05-10310-00      | LANE GUIDE BRACKET                                                                   |
| 36       | 1   | MD-05-10311-00      | BAR CYLINDER MNT STD                                                                 |
| 37       | 1   | MD-05-10312-00      | BAR GUIDE MNT STD                                                                    |
| 38       | 1   | MD-05-10313-00      | SUPPORT ANGLE                                                                        |
| 39       | 1   | MD-05-10314-00      | GUIDE MNT PLATE                                                                      |
| 40       | 1   | MD-05-10315-00      | GUIDE 3 STD                                                                          |
| 41       | 1   | MD-05-10316-00      | GUIDE 4 STD                                                                          |
| 42       | 1   | MD-05-10317-00      | GUIDE 5 STD                                                                          |
| 43       | 1   | MD-05-10318-00      | GUIDE 6 STD                                                                          |
| 44       | 1   | MD-05-10331-00      | BRACE MOD                                                                            |
| 45       | 1   | MD-05-10866-00      | ESCAPEMENT HANDLE                                                                    |
| 46       | 2   | MD-05-10464-00      | SPACER MULTI CONNECTOR                                                               |



| REVISIONS |             |      |          |
|-----------|-------------|------|----------|
| REV.      | DESCRIPTION | DATE | INITIALS |

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| FINISH                                                                                                                                                                                                                                      | EST. WEIGHT (lbs):<br>0.00    | DO NOT SCALE DRAWING |           |           |      |                 |

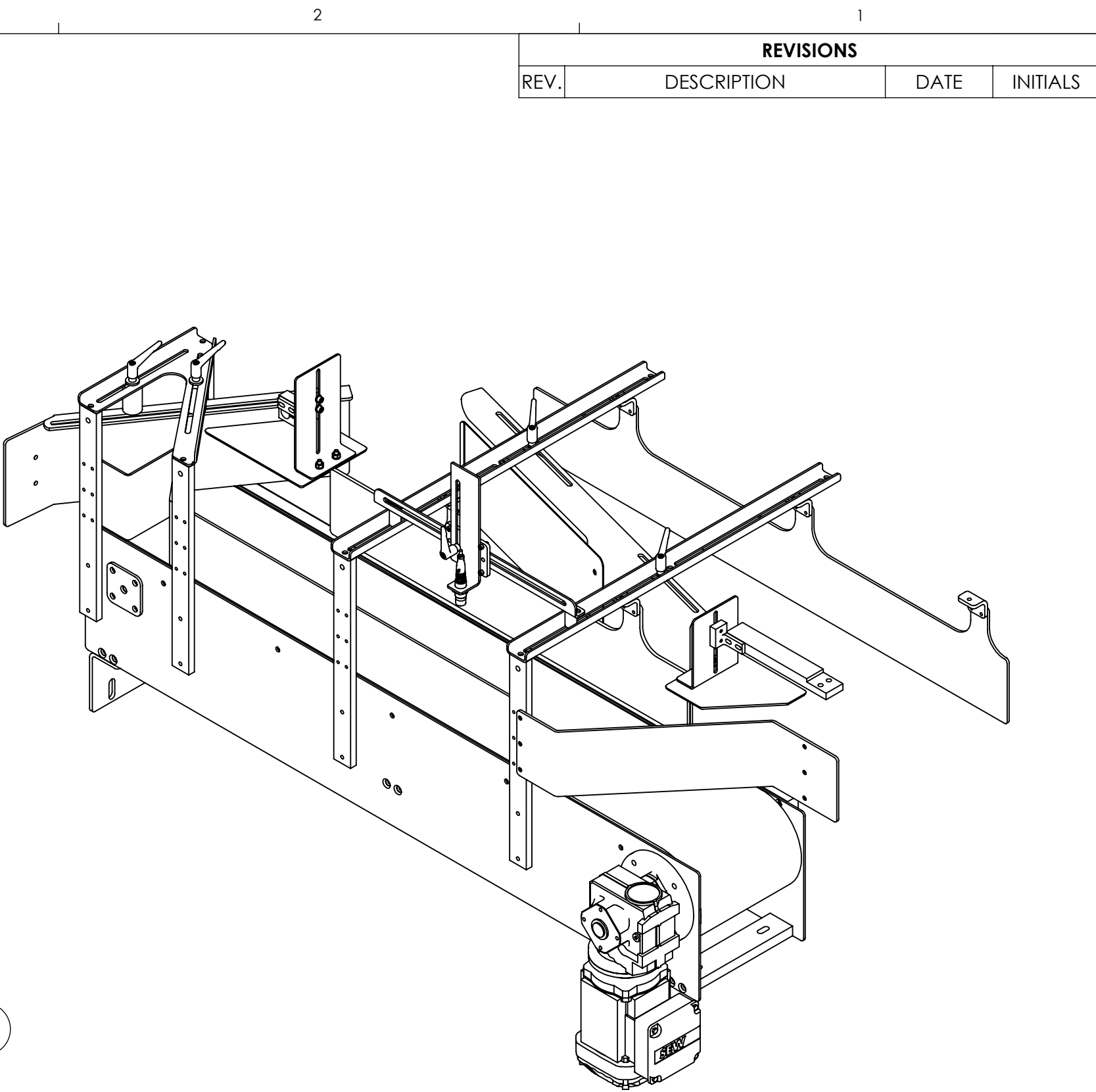
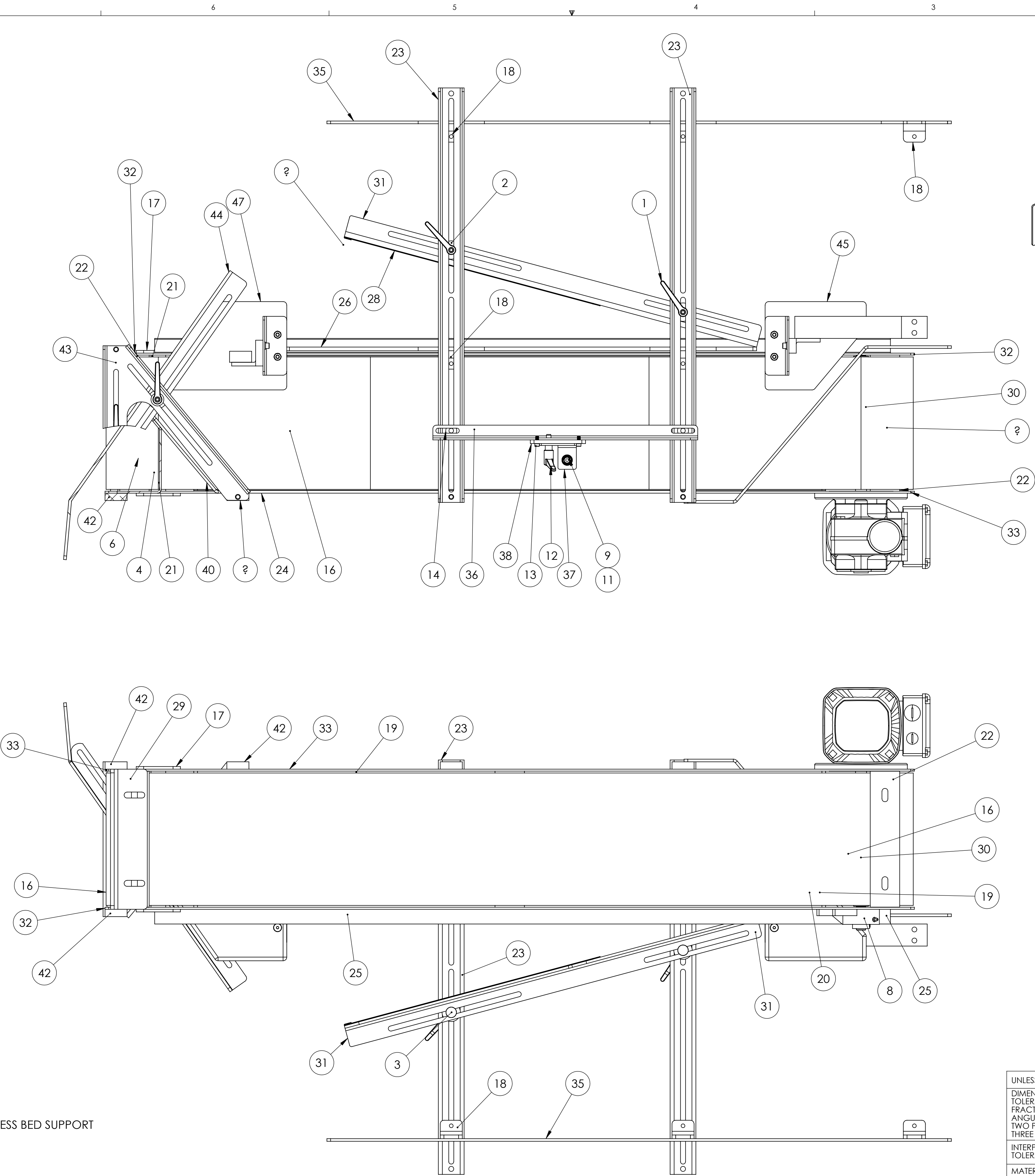


TITLE:  
**LOAD ZONE ESCAPEMENT, STD CANS**

|                  |                       |              |
|------------------|-----------------------|--------------|
| SIZE<br><b>D</b> | DWG. NO.<br>1702-105B | REV          |
| SHEET SCALE: 1:4 |                       | SHEET 1 OF 1 |



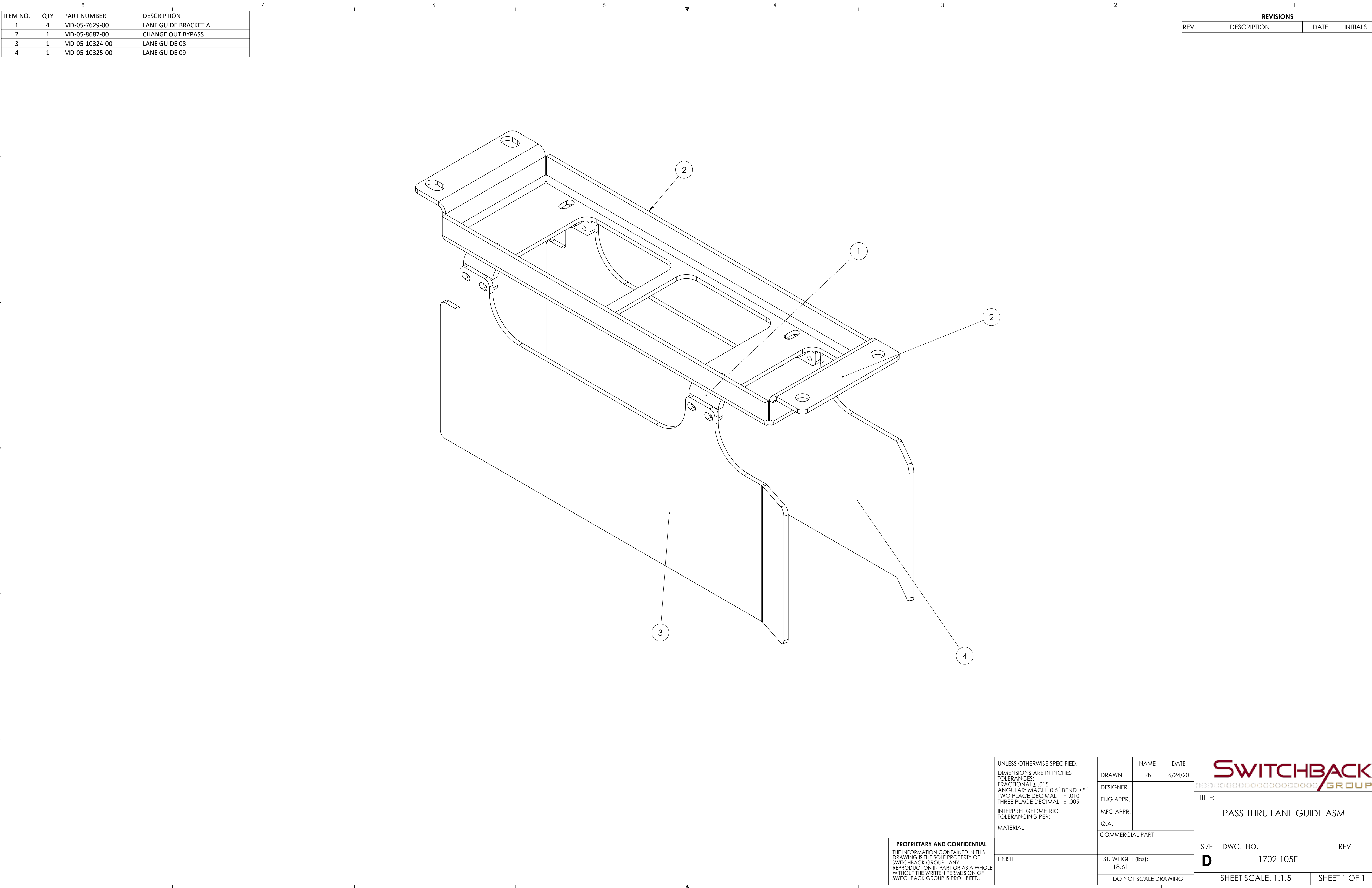
| ITEM NO. | QTY | PART NUMBER                                                         | DESCRIPTION                                                      |
|----------|-----|---------------------------------------------------------------------|------------------------------------------------------------------|
| 1        | 4   | 60655K755                                                           | 5/16"-18 X 3/8" DP, ADJUSTABLE HANDLE                            |
| 2        | 2   | 92141A033                                                           | WASHER, FOR 1/2" SCREW                                           |
| 3        | 2   | 92356A581                                                           | 5/16"-18 X 3/4" LG CARRIAGE BOLT, SQ. NECK                       |
| 4        | 6   | ENSP45-16-A                                                         | THIN LINE SPLIT SHAFT COLLAR, 1" BORE, .394 WIDE                 |
| 5        | 3   | KU8500-28T-11IN KEYED BORE                                          | 8500 SERIES SPROCKET, 28T, 1" KEYED BORE, THERMOPLASTIC          |
| 6        | 3   | KU8500-28T-11IN IDLER BORE                                          | 8500 SERIES SPROCKET, 28T, 1" ROUND BORE, THERMOPLASTIC          |
| 7        | 1   | SAF37DRN71M4_DH-480VAC-M2-77RPM-0.75 HOLLOW SHAFT-160MM-SIDE A-90-3 |                                                                  |
| 8        | 1   | SUCTFB 202-10                                                       | 3-BOLT FLANGE BEARING, 5/8" BORE                                 |
| 9        | 1   | V1-G-BKSM-PVC-U                                                     | M12 CABLE, STRAIGHT, 5M LG, 4-PIN                                |
| 10       | 6   | 98126A647                                                           | ROUND SHIM, .03" THK, 1/4" ID, 3/8" OD                           |
| 11       | 1   | IGS278                                                              | INDUCTIVE PROX SENSOR, 18mm, UNSHIELDED, K=1, 15mm SENSING RANGE |
| 12       | 1   | 60655K592                                                           | ADJUSTABLE HANDLE, 5/16"-18 X 3/4" LG STUD, ORANGE               |
| 13       | 4   | SHCS, 10-32 x .50, STAINLESS STEEL                                  | 10-32 X 1/2" LG SHCS                                             |
| 14       | 2   | 92511A106                                                           | SPACER, .32 ID x .75 OD x 1.25, ALUM                             |
| 15       | 2   | 98370A030                                                           | THICK FLAT WASHER FOR 3/8" SCREW                                 |
| 16       | 1   | 1702-105 RECIRC BELT                                                | SERIES 8506 MAT TOP CHAIN, 9" WD, 118" LG, HP                    |
| 17       | 2   | MD-05-7601-00                                                       | INFEED IDLER MOUNT                                               |
| 18       | 5   | MD-05-7637-00                                                       | LANE GUIDE BRACKET M                                             |
| 19       | 1   | MD-05-7678-00                                                       | INFEED BED SUPPORT D                                             |
| 20       | 1   | MD-05-7679-00                                                       | RECIRC BED A                                                     |
| 21       | 1   | MD-05-7681-00                                                       | RECIRC IDLER SHAFT                                               |
| 22       | 3   | MD-05-7682-00                                                       | RECIRC LOWER CROSSBAR                                            |
| 23       | 2   | MD-05-7685-00                                                       | LANE GUIDE SUPPORT F                                             |
| 24       | 1   | MD-05-7692-00                                                       | RECIRC OUTSIDE GUIDE                                             |
| 25       | 1   | MD-05-7694-00                                                       | RECIRC TRANSFER BAR                                              |
| 26       | 1   | MD-05-7695-00                                                       | RECIRC CENTER GUIDE                                              |
| 27       | 1   | MD-05-7697-00                                                       | SPRING DIVERTER A                                                |
| 28       | 1   | MD-05-7699-00                                                       | SPRING DIVERTER B                                                |
| 29       | 1   | MD-05-7720-00                                                       | RECIRC MOUNT BRACKET                                             |
| 30       | 1   | MD-05-7728-00                                                       | RECIRC DRIVE SHAFT                                               |
| 31       | 1   | MD-05-7796-00                                                       | MANUAL LANE DIVERTER - RH                                        |
| 32       | 1   | MD-05-7797-00                                                       | RECIRC FRAME PANEL A - RH                                        |
| 33       | 1   | MD-05-7798-00                                                       | RECIRC FRAME PANEL B - RH                                        |
| 34       | 1   | MD-05-7812-00                                                       | TRANSFER EXIT GUIDE                                              |
| 35       | 1   | MD-05-7815-00                                                       | LANE GUIDE 10                                                    |
| 36       | 1   | MD-05-7832-00                                                       | INFEED HIGH LEVEL MOUNT                                          |
| 37       | 1   | MD-05-8040-00                                                       | HI-LEVEL PROX BRACKET                                            |
| 38       | 1   | MD-05-8041-00                                                       | HI-LEVEL PROX BASE                                               |
| 39       | 1   | MD-05-8651-00                                                       | CORNER GUIDE BRACE                                               |
| 40       | 1   | MD-05-8652-00                                                       | CORNER GUIDE                                                     |
| 41       | 2   | MD-05-8653-00                                                       | GUIDE SPACER                                                     |
| 42       | 5   | MD-05-8656-00                                                       | UPRIGHT                                                          |
| 43       | 1   | MD-05-10327-00                                                      | GUIDE ADJ BRACKET                                                |
| 44       | 1   | MD-05-10328-00                                                      | SPLITTER                                                         |
| 45       | 1   | MD-05-11103-00                                                      | CAN HOLD DOWN ASSY                                               |
| 46       | 1   | MD-05-9917-00                                                       | SHAFT CLAMP SMALL GUIDE                                          |
| 47       | 1   | MD-05-10522-00                                                      | CAN HOLD DOWN ASSY                                               |



NOTES:  
1. .03" THICK SHIM IS LOCATED BETWEEN THE UHMW BED AND STAINLESS BED SUPPORT AT THE UNLOAD END.  
USE STAINLESS STEEL HARDWARE UNLESS OTHERWISE SPECIFIED.

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|                                                                                                                                                                                      |                              |      |         |                                                                          |  |
|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|------------------------------|------|---------|--------------------------------------------------------------------------|--|
| UNLESS OTHERWISE SPECIFIED:<br>DIMENSIONS ARE IN INCHES<br>TOLERANCES:<br>FRACTIONAL ± .015<br>ANGULAR: MACH±0.5° BEND ±5°<br>TWO PLACE DECIMAL ± .010<br>THREE PLACE DECIMAL ± .005 |                              | NAME | DATE    | <div>SWITCHBACK GROUP</div> <div>TITLE:<br/>RECIRCULATION CONVEYOR</div> |  |
| MATERIAL                                                                                                                                                                             | DRAWN                        | RB   | 6/24/20 |                                                                          |  |
| FINISH                                                                                                                                                                               | DESIGNER                     |      |         |                                                                          |  |
|                                                                                                                                                                                      | ENG APPR.                    |      |         |                                                                          |  |
|                                                                                                                                                                                      | MFG APPR.                    |      |         | SIZE DWG. NO. REV<br><b>D</b> 1702-105D                                  |  |
|                                                                                                                                                                                      | Q.A.                         |      |         |                                                                          |  |
|                                                                                                                                                                                      | COMMERCIAL PART              |      |         | SHEET SCALE: 1:4 SHEET 1 OF 1                                            |  |
|                                                                                                                                                                                      | EST. WEIGHT (lbs):<br>208.44 |      |         |                                                                          |  |
|                                                                                                                                                                                      | DO NOT SCALE DRAWING         |      |         |                                                                          |  |



| ITEM NO. | QTY | PART NUMBER    | DESCRIPTION          |
|----------|-----|----------------|----------------------|
| 1        | 4   | MD-05-7629-00  | LANE GUIDE BRACKET A |
| 2        | 1   | MD-05-8687-00  | CHANGE OUT BYPASS    |
| 3        | 1   | MD-05-10324-00 | LANE GUIDE 08        |
| 4        | 1   | MD-05-10325-00 | LANE GUIDE 09        |

| REVISIONS |             |      |          |
|-----------|-------------|------|----------|
| REV.      | DESCRIPTION | DATE | INITIALS |

|                                                                                                                                                                                                                                             |                    |      |         |
|---------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--------------------|------|---------|
| UNLESS OTHERWISE SPECIFIED:<br>DIMENSIONS ARE IN INCHES<br>TOLERANCES:<br>FRACTIONAL ± .015<br>ANGULAR: MACH±0.5° BEND ±5°<br>TWO PLACE DECIMAL ± .010<br>THREE PLACE DECIMAL ± .005<br>INTERPRET GEOMETRIC<br>TOLERANCING PER:<br>MATERIAL | DRAWN              | NAME | DATE    |
|                                                                                                                                                                                                                                             | DESIGNER           | RB   | 6/24/20 |
|                                                                                                                                                                                                                                             | ENG APPR.          |      |         |
|                                                                                                                                                                                                                                             | MFG APPR.          |      |         |
| FINISH                                                                                                                                                                                                                                      | Q.A.               |      |         |
|                                                                                                                                                                                                                                             | COMMERCIAL PART    |      |         |
|                                                                                                                                                                                                                                             | EST. WEIGHT (lbs): |      |         |

|        |                             |
|--------|-----------------------------|
|        |                             |
| FINISH | EST. WEIGHT (lbs):<br>18.61 |
|        | DO NOT SCALE DRAWING        |

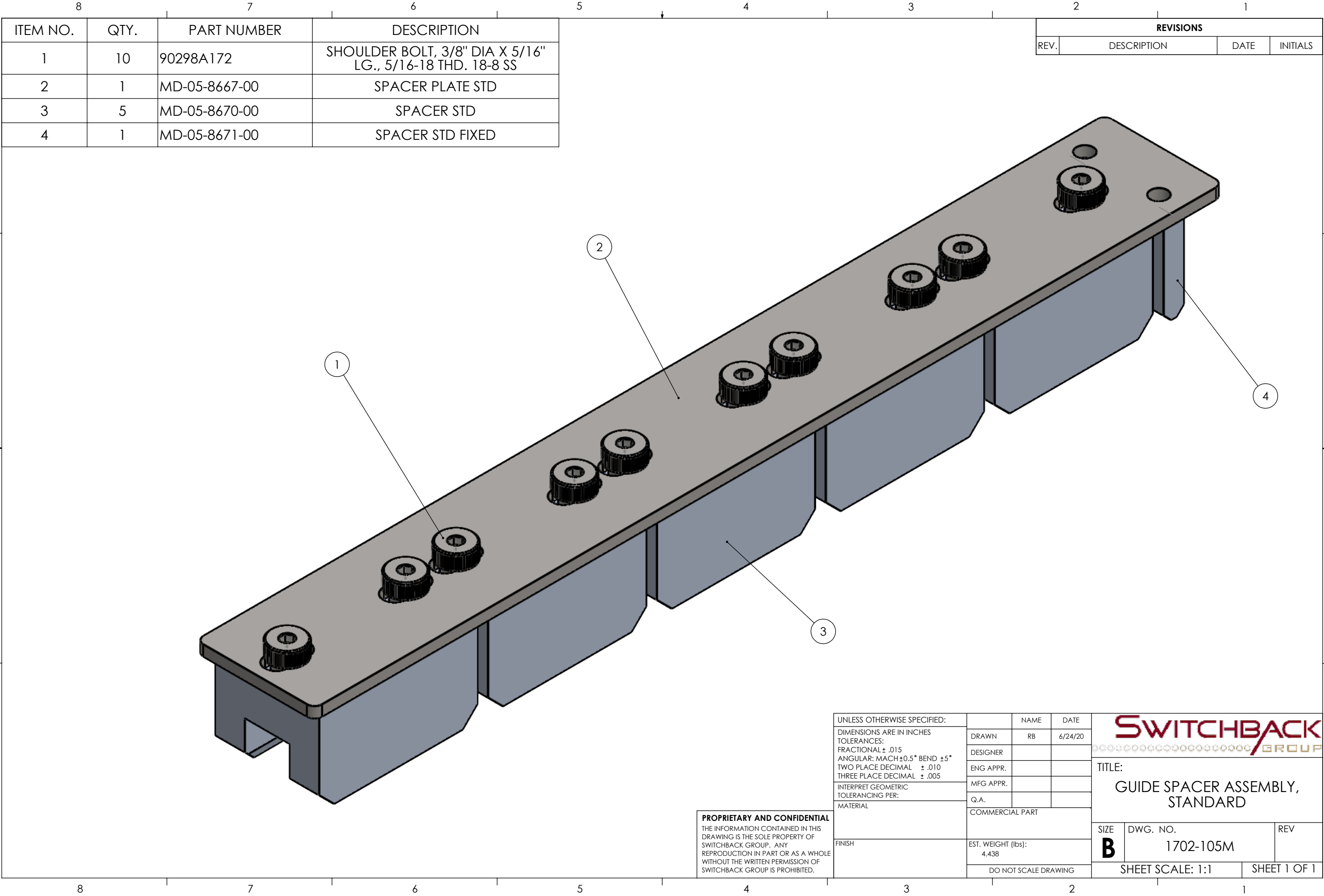
SWITCHBACK

GROUP

TITLE:  
PASS-THRU LANE GUIDE ASM

|                    |                       |              |
|--------------------|-----------------------|--------------|
| SIZE<br><b>D</b>   | DWG. NO.<br>1702-105E | REV          |
| SHEET SCALE: 1:1.5 |                       | SHEET 1 OF 1 |

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| ITEM NO. | QTY. | PART NUMBER   | DESCRIPTION                                               |
|----------|------|---------------|-----------------------------------------------------------|
| 1        | 10   | 90298A172     | SHOULDER BOLT, 3/8" DIA X 5/16" LG., 5/16-18 THD. 18-8 SS |
| 2        | 1    | MD-05-8667-00 | SPACER PLATE STD                                          |
| 3        | 5    | MD-05-8670-00 | SPACER STD                                                |
| 4        | 1    | MD-05-8671-00 | SPACER STD FIXED                                          |

| REVISIONS |             |      |          |
|-----------|-------------|------|----------|
| REV.      | DESCRIPTION | DATE | INITIALS |

|                                      |  |                      |      |
|--------------------------------------|--|----------------------|------|
| UNLESS OTHERWISE SPECIFIED:          |  | NAME                 | DATE |
| DIMENSIONS ARE IN INCHES             |  | DRAWN                | RB   |
| TOLERANCES:                          |  | DESIGNER             |      |
| FRACTIONAL ± .015                    |  | ENG APPR.            |      |
| ANGULAR: MACH ± 0.5° BEND ± 5°       |  | MFG APPR.            |      |
| TWO PLACE DECIMAL ± .010             |  | Q.A.                 |      |
| THREE PLACE DECIMAL ± .005           |  | COMMERCIAL PART      |      |
| INTERPRET GEOMETRIC TOLERANCING PER: |  | EST. WEIGHT (lbs):   |      |
| MATERIAL                             |  | 4.438                |      |
| FINISH                               |  | DO NOT SCALE DRAWING |      |
| SIZE                                 |  | DWG. NO.             | REV  |
| B                                    |  | 1702-105M            |      |
| SHEET SCALE: 1:1                     |  | SHEET 1 OF 1         |      |

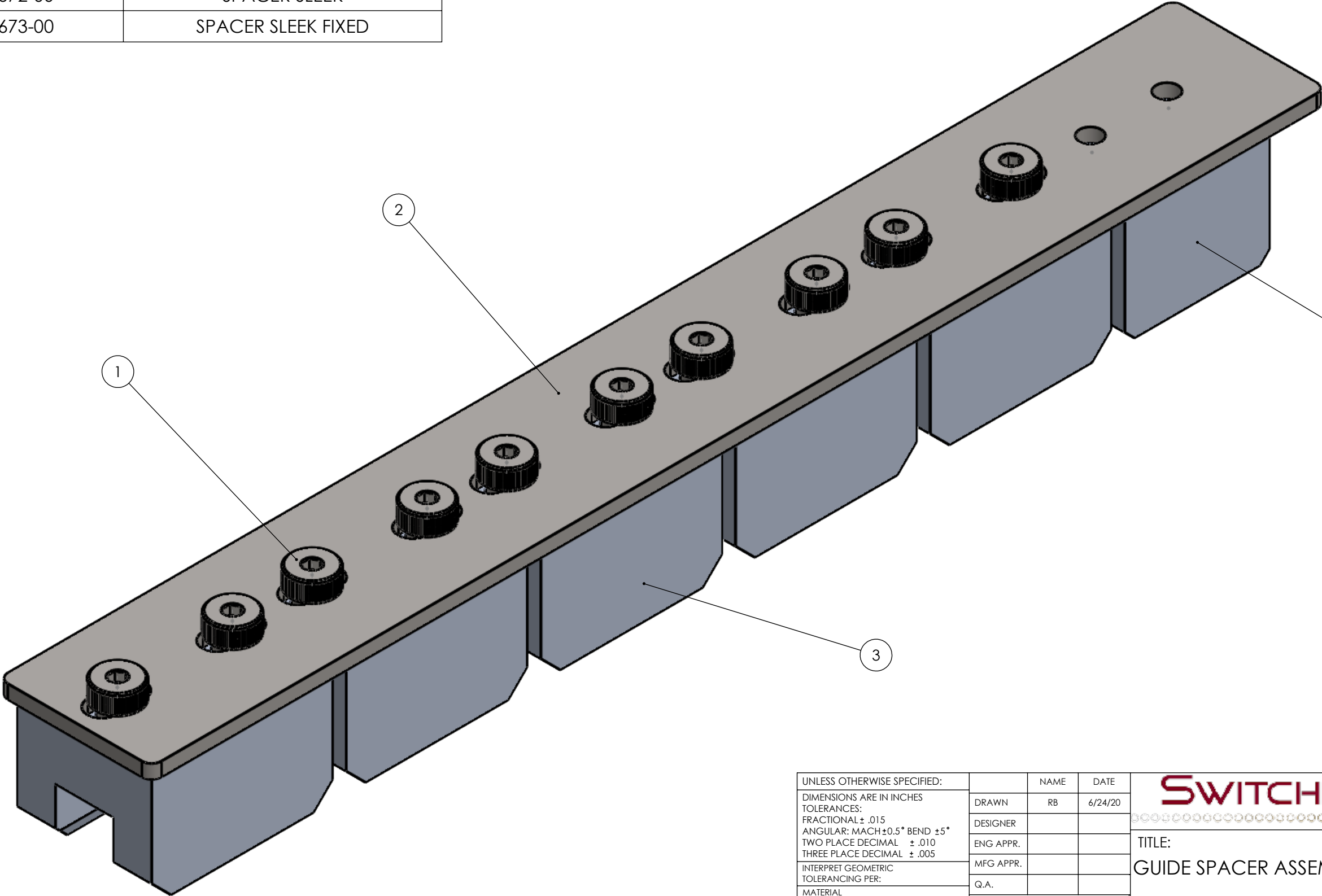
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TITLE:  
GUIDE SPACER ASSEMBLY,  
STANDARD

| ITEM NO. | QTY. | PART NUMBER   | DESCRIPTION                                               |
|----------|------|---------------|-----------------------------------------------------------|
| 1        | 10   | 90298A172     | SHOULDER BOLT, 3/8" DIA X 5/16" LG., 5/16-18 THD. 18-8 SS |
| 2        | 1    | MD-05-8668-00 | SPACER PLATE SLEEK                                        |
| 3        | 5    | MD-05-8672-00 | SPACER SLEEK                                              |
| 4        | 1    | MD-05-8673-00 | SPACER SLEEK FIXED                                        |

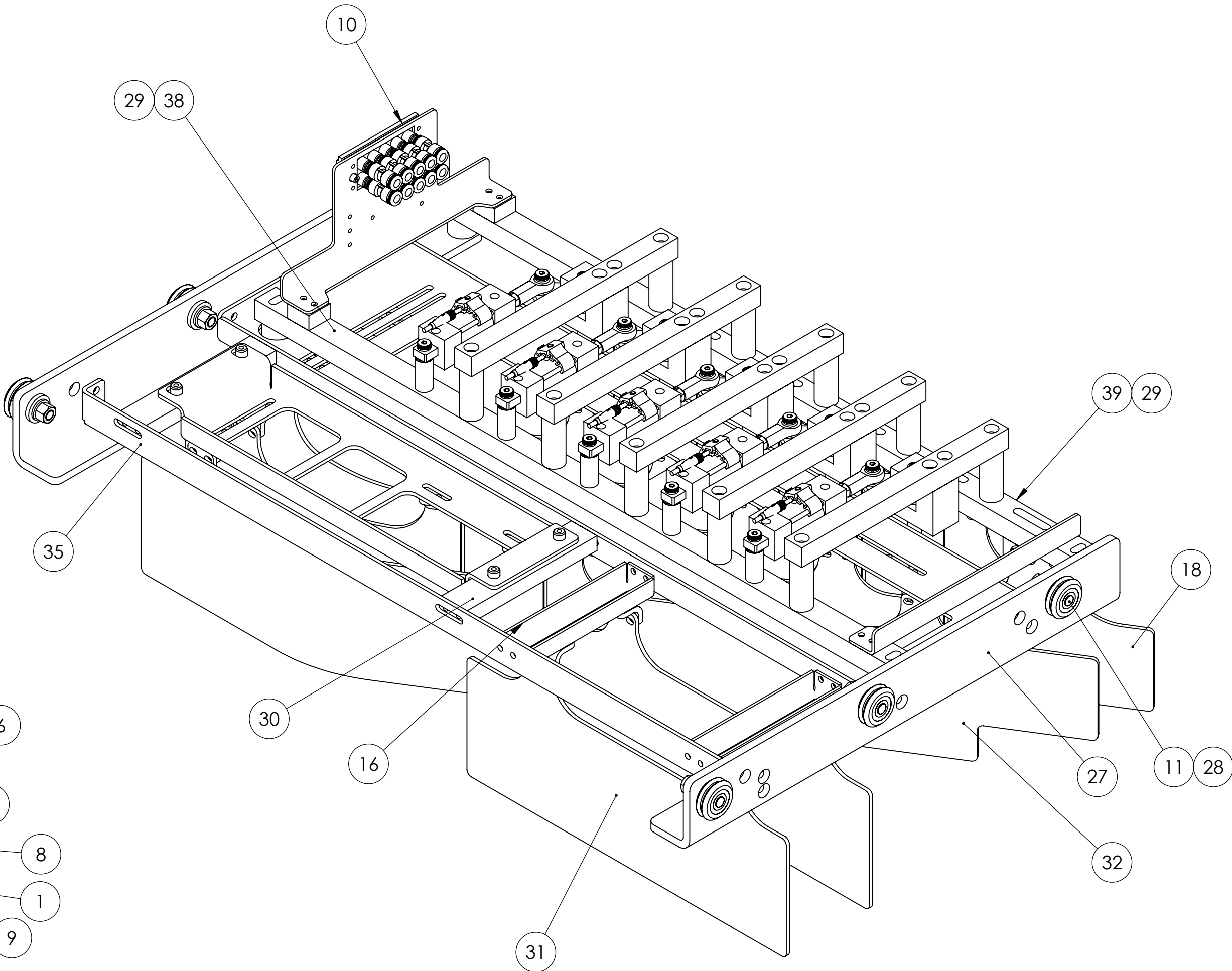
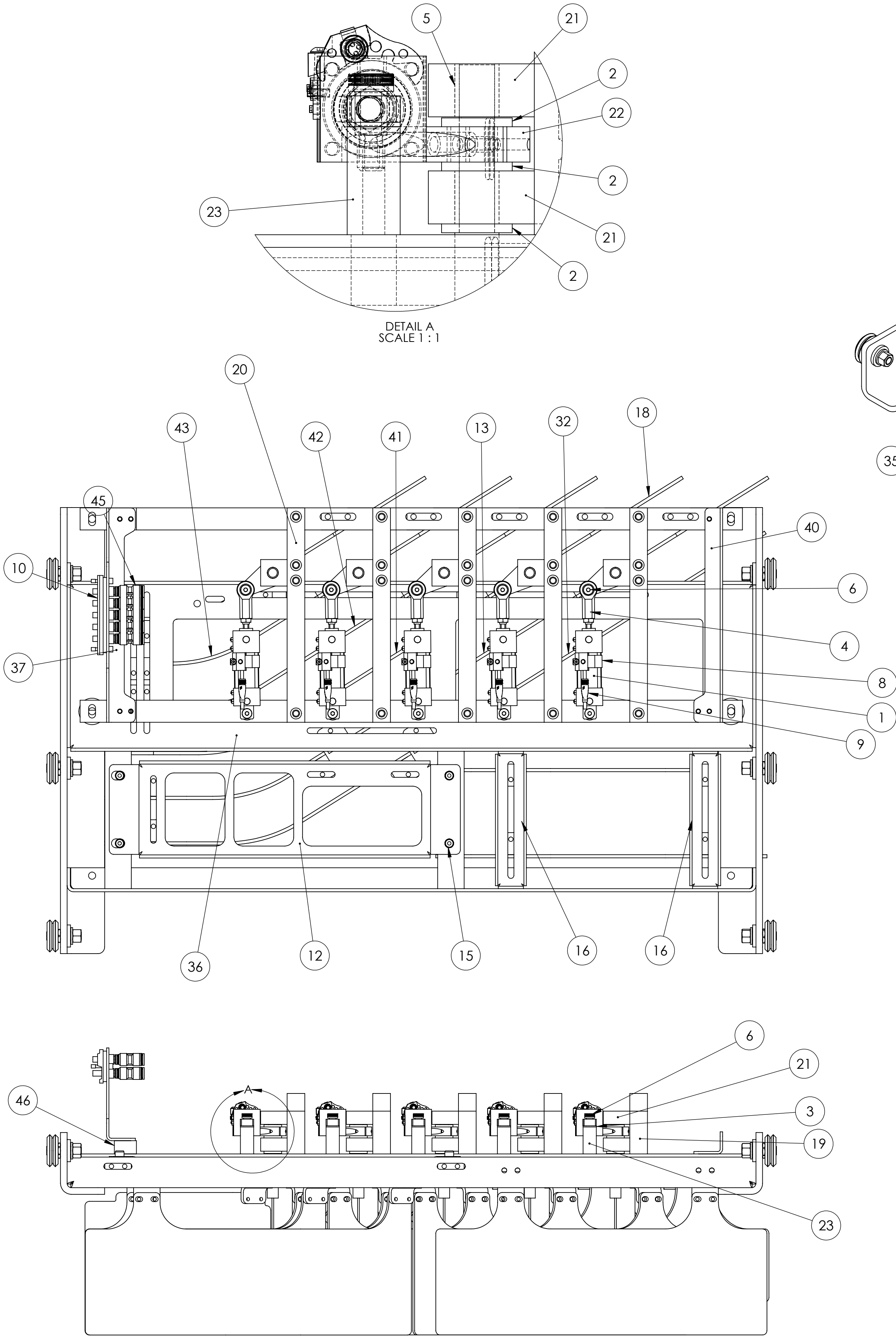
| REVISIONS |             |      |          |
|-----------|-------------|------|----------|
| REV.      | DESCRIPTION | DATE | INITIALS |



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|--------------------------------------|--|----------------------|------|--------------------------------------------------------------------------------|--|
| UNLESS OTHERWISE SPECIFIED:          |  | NAME                 | DATE | <div>SWITCHBACK GROUP</div> <div>TITLE:<br/>GUIDE SPACER ASSEMBLY, SLEEK</div> |  |
| DIMENSIONS ARE IN INCHES             |  | DRAWN                | RB   |                                                                                |  |
| TOLERANCES:                          |  | DESIGNER             |      |                                                                                |  |
| FRACTIONAL ± .015                    |  | ENG APPR.            |      |                                                                                |  |
| ANGULAR: MACH ±0.5° BEND ±5°         |  | MFG APPR.            |      |                                                                                |  |
| TWO PLACE DECIMAL ± .010             |  | Q.A.                 |      | SIZE                                                                           |  |
| THREE PLACE DECIMAL ± .005           |  | COMMERCIAL PART      |      | DWG. NO.                                                                       |  |
| INTERPRET GEOMETRIC TOLERANCING PER: |  | EST. WEIGHT (lbs):   |      | REV                                                                            |  |
| MATERIAL                             |  | 4.441                |      | 1702-105N                                                                      |  |
| FINISH                               |  | DO NOT SCALE DRAWING |      | SHEET SCALE: 1:1                                                               |  |
|                                      |  |                      |      | SHEET 1 OF 1                                                                   |  |

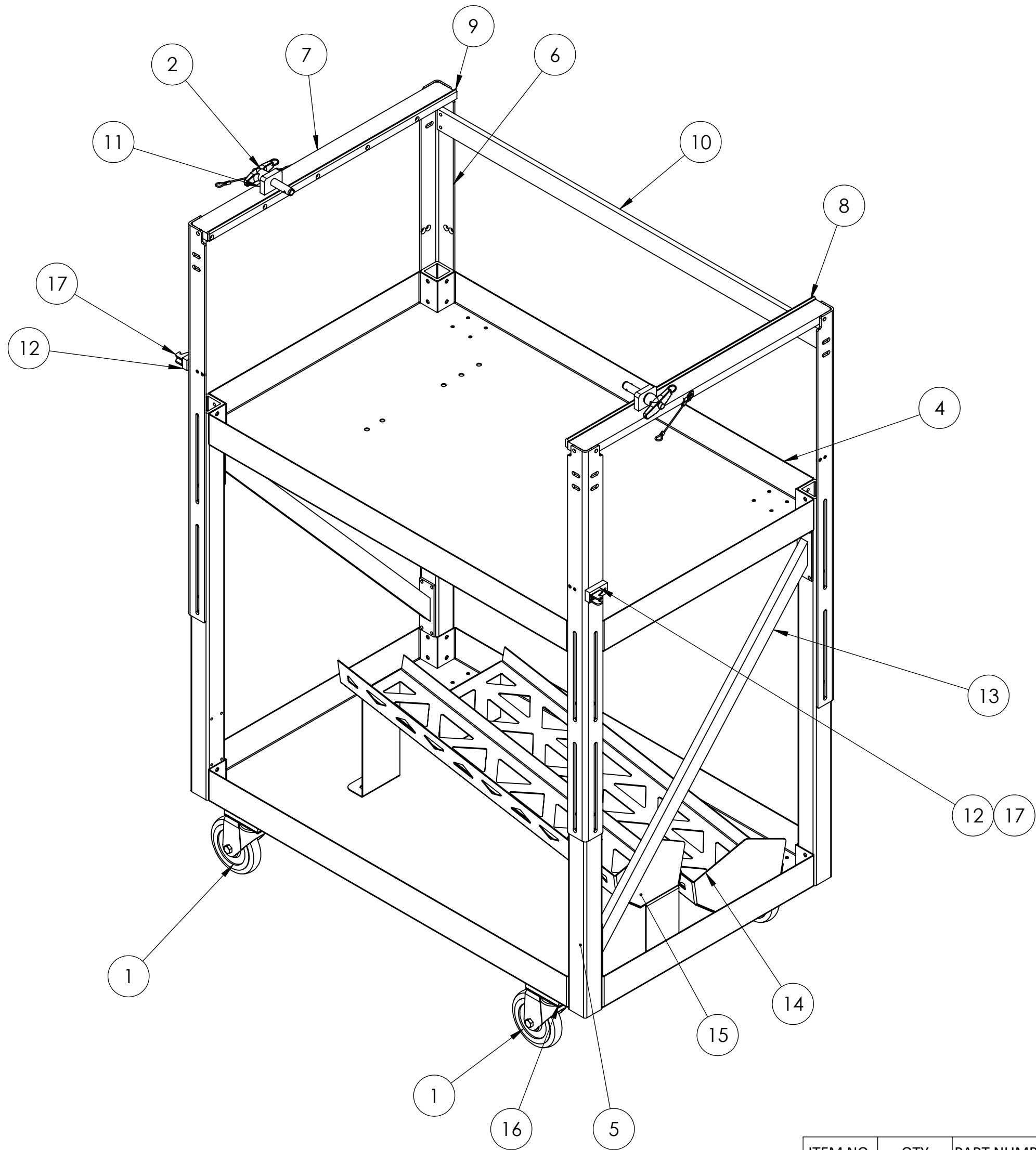
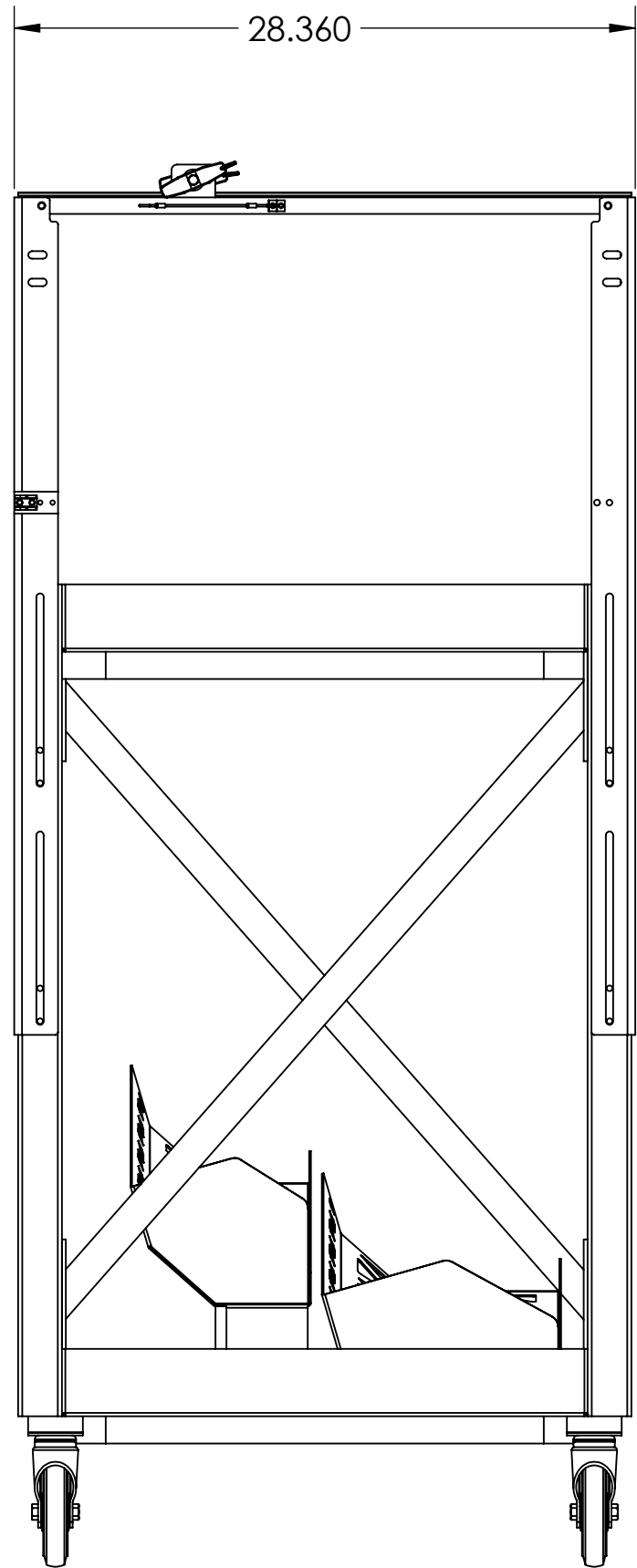
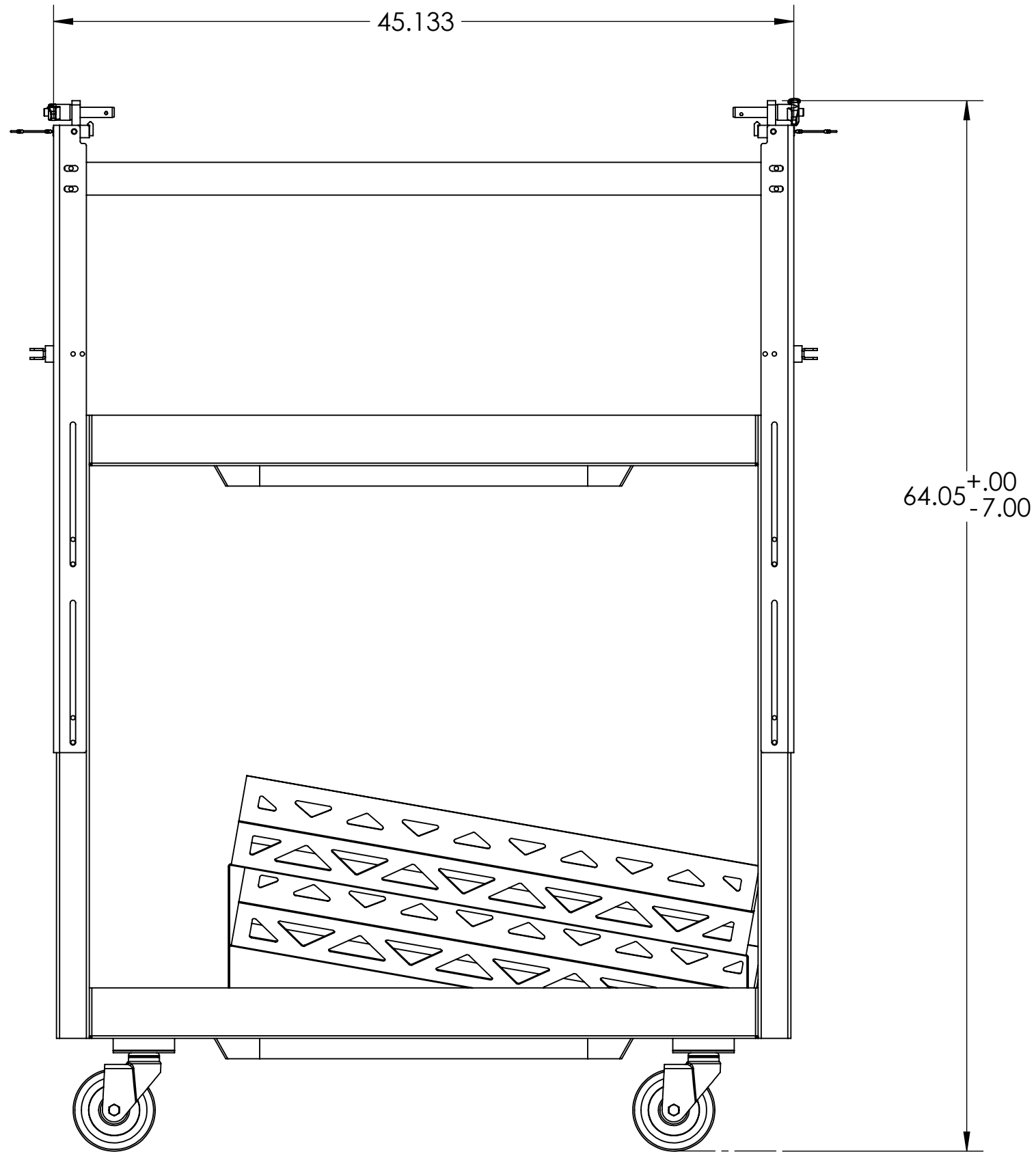
| ITEM NO. | QTY | PART NUMBER         | DESCRIPTION                                                                          |
|----------|-----|---------------------|--------------------------------------------------------------------------------------|
| 1        | 5   | AVP-1-1_8x1-P-D-E   | PENU CYL, 1-1/8" BORE, 1" STROKE, REAR PIVOT MOUNT, FLOW CTRLS, CUSHIONS, MAG PISTON |
| 2        | 15  | 5906K514            | THRUST WASHER, 1/2" ID X 1" OD X 1/8" LG                                             |
| 3        | 5   | 5906K511            | THRUST WASHER, 3/8" ID X 3/4" OD X 1/16" LG                                          |
| 4        | 5   | 59915K484           | ROD END, 3/8"-24 THRD, 3/8" BORE                                                     |
| 5        | 10  | 6391K214            | SLEEVE BEARING, 1/2" BORE, 3/4" LG, 5/8" OD                                          |
| 6        | 10  | 90298A621           | Ø3/8" X 5/8" LG SHOULDER SCREW, 5/16"-18 THRD                                        |
| 7        | 5   | 17524-2             | SOLID STATE SWITCH, PNP, M8 QD                                                       |
| 8        | 5   | 17000-33-5          | SWITCH BRACKET, 1-1/8" BORE                                                          |
| 9        | 5   | V3-GM-BK10M-PVC-U   | M8 CABLE, 3-PIN, STRAIGHT, 10M LG                                                    |
| 10       | 1   | KDM10P-08           | MULTI-CONNECTOR, PLUG SIDE, 10 X 8mm TUBE                                            |
| 11       | 6   | SWAC3SSX            | STUDDED V-GROOVE GUIDE WHEEL, SIZE 3, STAINLESS                                      |
| 12       | 1   | 1702-105S           | CARTONING LANE GUIDE ASM, SLEEK                                                      |
| 13       | 1   | MD-05-7621-00       | LANE GUIDE 05                                                                        |
| 14       | 6   | MD-05-7629-00       | LANE GUIDE BRACKET A                                                                 |
| 15       | 4   | MD-05-7649-00       | ALINGMENT PIN A                                                                      |
| 16       | 2   | MD-05-7650-00       | LANE GUIDE SUPPORT E                                                                 |
| 17       | 5   | MD-05-7660-00       | LANE GUIDE MOUNT A                                                                   |
| 18       | 5   | MD-05-7661-00 REV B | LANE GUIDE 01                                                                        |
| 19       | 10  | MD-05-7664-00       | CROSSBAR UPRIGHT A                                                                   |
| 20       | 5   | MD-05-7665-00       | UPPER CROSSBAR A                                                                     |
| 21       | 5   | MD-05-7666-00       | LANE GATE BEARING BLOCK                                                              |
| 22       | 5   | MD-05-7667-00       | INDEXING FLAG LINK                                                                   |
| 23       | 5   | MD-05-7668-00       | CYLINDER PIVOT BLOCK                                                                 |
| 24       | 3   | MD-05-7673-00       | LANE GUIDE BRACKET K                                                                 |
| 25       | 5   | MD-05-7707-00       | INDEXING FLAG WELDMENT                                                               |
| 26       | 1   | MD-05-8698-00 REV A | ANGLE                                                                                |
| 27       | 1   | MD-05-8699-00 REV A | ANGLE                                                                                |
| 28       | 6   | MD-05-8700-01       | ROLLER SPACER                                                                        |
| 29       | 4   | MD-05-8702-00       | SPACER                                                                               |
| 30       | 2   | MD-05-8703-00       | CROSS BAR                                                                            |
| 31       | 2   | MD-05-8705-00       | GUIDE PASS THRU                                                                      |
| 32       | 1   | MD-05-8704-00       | GUIDE 1D FIXED                                                                       |
| 33       | 1   | MD-05-8716-00       | BRACKET LONG                                                                         |
| 34       | 6   | MD-05-10309-00      | LANE GUIDE BRACKET                                                                   |
| 35       | 1   | MD-05-10313-00      | SUPPORT ANGLE                                                                        |
| 36       | 1   | MD-05-10314-00      | GUIDE MNT PLATE                                                                      |
| 37       | 1   | MD-05-10866-00      | ESCAPEMENT HANDLE                                                                    |
| 38       | 1   | MD-05-10329-00      | BAR CYLINDER MNT SLEEK                                                               |
| 39       | 1   | MD-05-10330-00      | BAR GUIDE MNT SLEEK                                                                  |
| 40       | 1   | MD-05-10331-00      | BRACE MOD                                                                            |
| 41       | 1   | MD-05-10332-00      | GUIDE 3 SLEEK                                                                        |
| 42       | 1   | MD-05-10333-00      | GUIDE 4 SLEEK                                                                        |
| 43       | 1   | MD-05-10334-00      | GUIDE 5 SLEEK                                                                        |
| 44       | 1   | MD-05-10335-00      | GUIDE 6 SLEEK                                                                        |
| 45       | 10  | PG3_8-5_16          | PUSH TO CONNECT 3/8-5/16                                                             |
| 46       | 2   | MD-05-10464-00      | SPACER MULTI CONNECTOR                                                               |



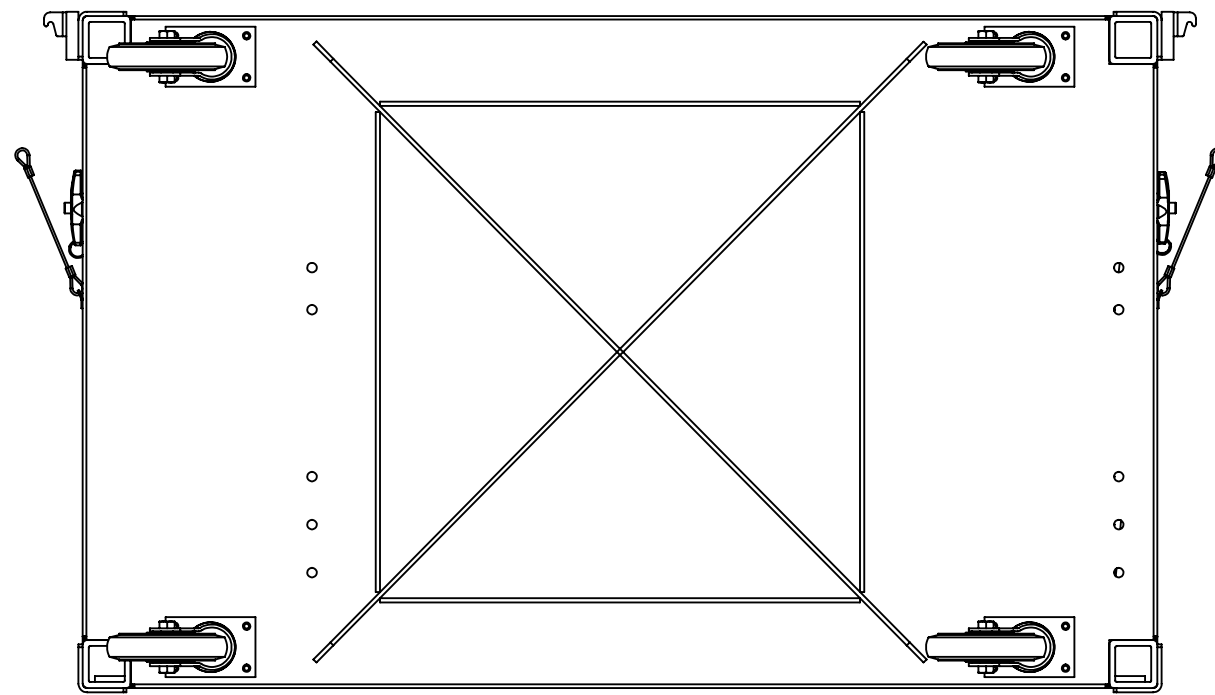
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|----------------------------------------------------------------------------------------------------------------------------------------------------------|----------------------------|------|---------|------------------------------------------------------------------------------------|-----------------------|-----|
| UNLESS OTHERWISE SPECIFIED:                                                                                                                              |                            | NAME | DATE    | <div>SWITCHBACK GROUP</div> <div>TITLE:<br/>LOAD ZONE ESCAPEMENT, SLEEK CANS</div> |                       |     |
| DIMENSIONS ARE IN INCHES<br>TOLERANCES:<br>FRACTIONAL ± .015<br>ANGULAR: MACH ± 0.5° BEND ± 5°<br>TWO PLACE DECIMAL ± .010<br>THREE PLACE DECIMAL ± .005 | DRAWN                      | RB   | 6/24/20 |                                                                                    |                       |     |
| INTERPRET GEOMETRIC<br>TOLERANCING PER:                                                                                                                  | DESIGNER                   |      |         |                                                                                    |                       |     |
| MATERIAL                                                                                                                                                 | ENG APPR.                  |      |         |                                                                                    |                       |     |
|                                                                                                                                                          | MFG APPR.                  |      |         | SIZE<br><b>D</b>                                                                   | DWG. NO.<br>1702-105Q | REV |
|                                                                                                                                                          | Q.A.                       |      |         |                                                                                    |                       |     |
|                                                                                                                                                          | COMMERCIAL PART            |      |         | SHEET SCALE: 1:4                                                                   |                       |     |
| FINISH                                                                                                                                                   | EST. WEIGHT (lbs):<br>0.00 |      |         |                                                                                    |                       |     |
|                                                                                                                                                          | DO NOT SCALE DRAWING       |      |         |                                                                                    |                       |     |

| REVISIONS |             |      |          |
|-----------|-------------|------|----------|
| REV.      | DESCRIPTION | DATE | INITIALS |



| ITEM NO. | QTY | PART NUMBER    | DESCRIPTION                                                     |
|----------|-----|----------------|-----------------------------------------------------------------|
| 1        | 4   | 2502T53        | SWIVEL WITH 5" DIAMETER GRAY POLYURETHANE WHEEL ON BALL BEARING |
| 2        | 2   | 90293A529      | 17-4 PH STAINLESS STEEL, 5/8" DIA, 2" USABLE LENGTH             |
| 3        | 2   | 90312A306      | LOOP-TO-TAB, UNCOATED, 3/64" DIA, 6" LENGTH                     |
| 4        | 2   | MD-05-10593-00 | SHELF WELDMENT                                                  |
| 5        | 4   | MD-05-9627-00  | CORNER POST                                                     |
| 6        | 4   | MD-05-10433-00 | UPPER POST, CHANGE CART                                         |
| 7        | 2   | MD-05-10597-00 | RAIL MOUNT                                                      |
| 8        | 1   | MD-05-10598-00 | V-WHEEL TRACK                                                   |
| 9        | 1   | MD-05-10599-00 | V-WHEEL TRACK                                                   |
| 10       | 1   | MD-05-9651-01  | BAR SUPPORT                                                     |
| 11       | 2   | MD-05-9652-00  | PIN BRACKET 2                                                   |
| 12       | 2   | MD-05-10434-00 | SPACER, DESTACO CLAMP                                           |
| 13       | 2   | MD-05-10596-00 | DIAGONAL BRACE WELDMENT                                         |
| 14       | 1   | MD-05-9654-00  | PUSHER WEDGE HOLDER                                             |
| 15       | 1   | MD-05-9653-00  | PUSHER WEDGE HOLDER                                             |
| 16       | 4   | MD-05-9643-00  | CASTER BOLT PAD                                                 |
| 17       | 2   | 331905         | CLAMP LATCH                                                     |



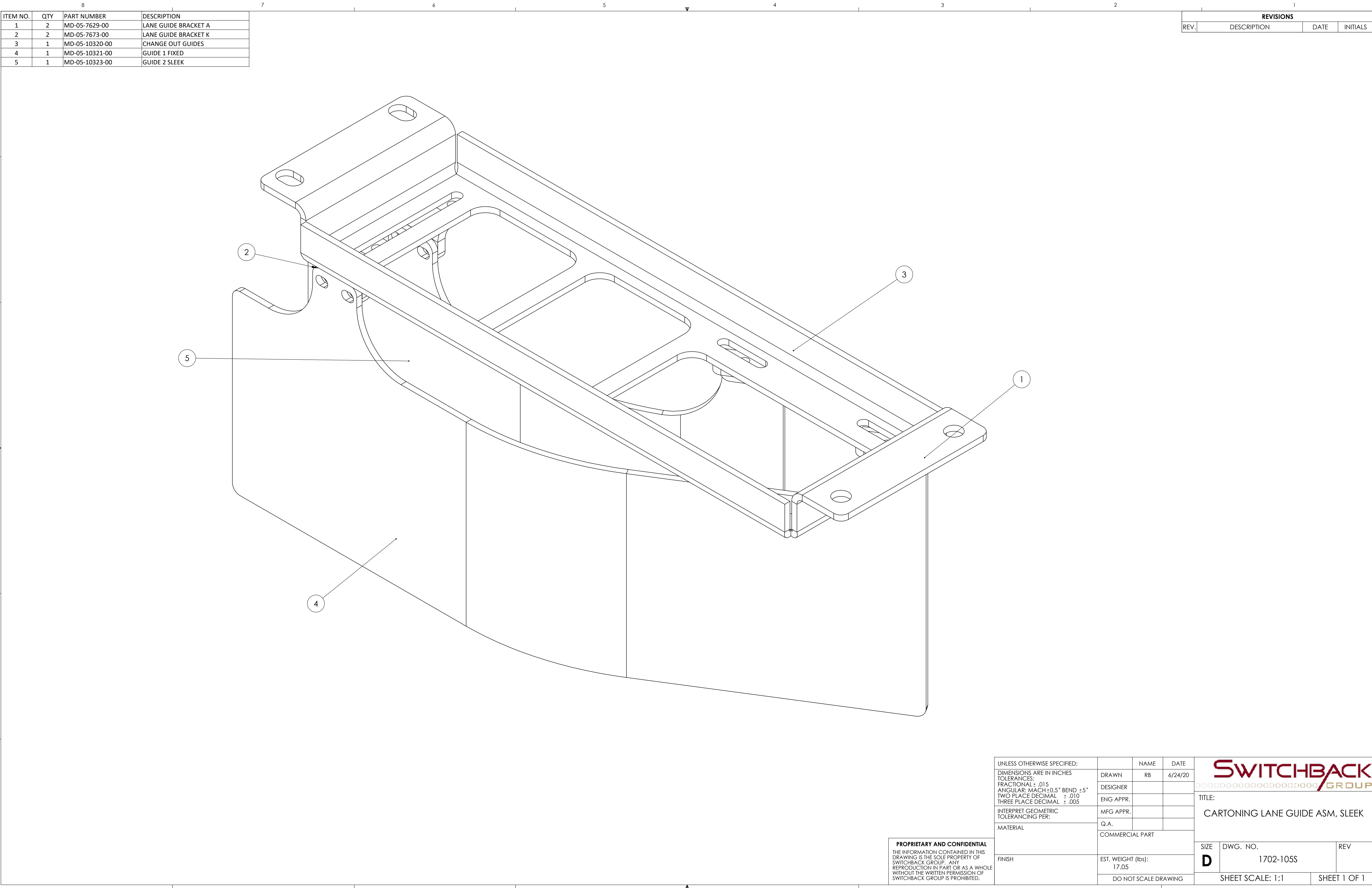
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|                                                                                                                                                                                                                                                       | DRAWN GR  | 6/24/20 |
|                                                                                                                                                                                                                                                       | DESIGNER  |         |
|                                                                                                                                                                                                                                                       | ENG APPR. |         |
|                                                                                                                                                                                                                                                       | MFG APPR. |         |
|                                                                                                                                                                                                                                                       | Q.A.      |         |
| COMMERCIAL PART                                                                                                                                                                                                                                       |           |         |
| EST. WEIGHT (lbs):                                                                                                                                                                                                                                    |           |         |
| DO NOT SCALE DRAWING                                                                                                                                                                                                                                  |           |         |



TITLE:  
**CART, CHANGE PARTS**

|                   |                       |              |
|-------------------|-----------------------|--------------|
| SIZE<br><b>D</b>  | DWG. NO.<br>1702-105R | REV          |
| SHEET SCALE: 1:12 |                       | SHEET 1 OF 1 |



| ITEM NO. | QTY | PART NUMBER    | DESCRIPTION          |
|----------|-----|----------------|----------------------|
| 1        | 2   | MD-05-7629-00  | LANE GUIDE BRACKET A |
| 2        | 2   | MD-05-7673-00  | LANE GUIDE BRACKET K |
| 3        | 1   | MD-05-10320-00 | CHANGE OUT GUIDES    |
| 4        | 1   | MD-05-10321-00 | GUIDE 1 FIXED        |
| 5        | 1   | MD-05-10323-00 | GUIDE 2 SLEEK        |

| REVISIONS |             |      |          |
|-----------|-------------|------|----------|
| REV.      | DESCRIPTION | DATE | INITIALS |

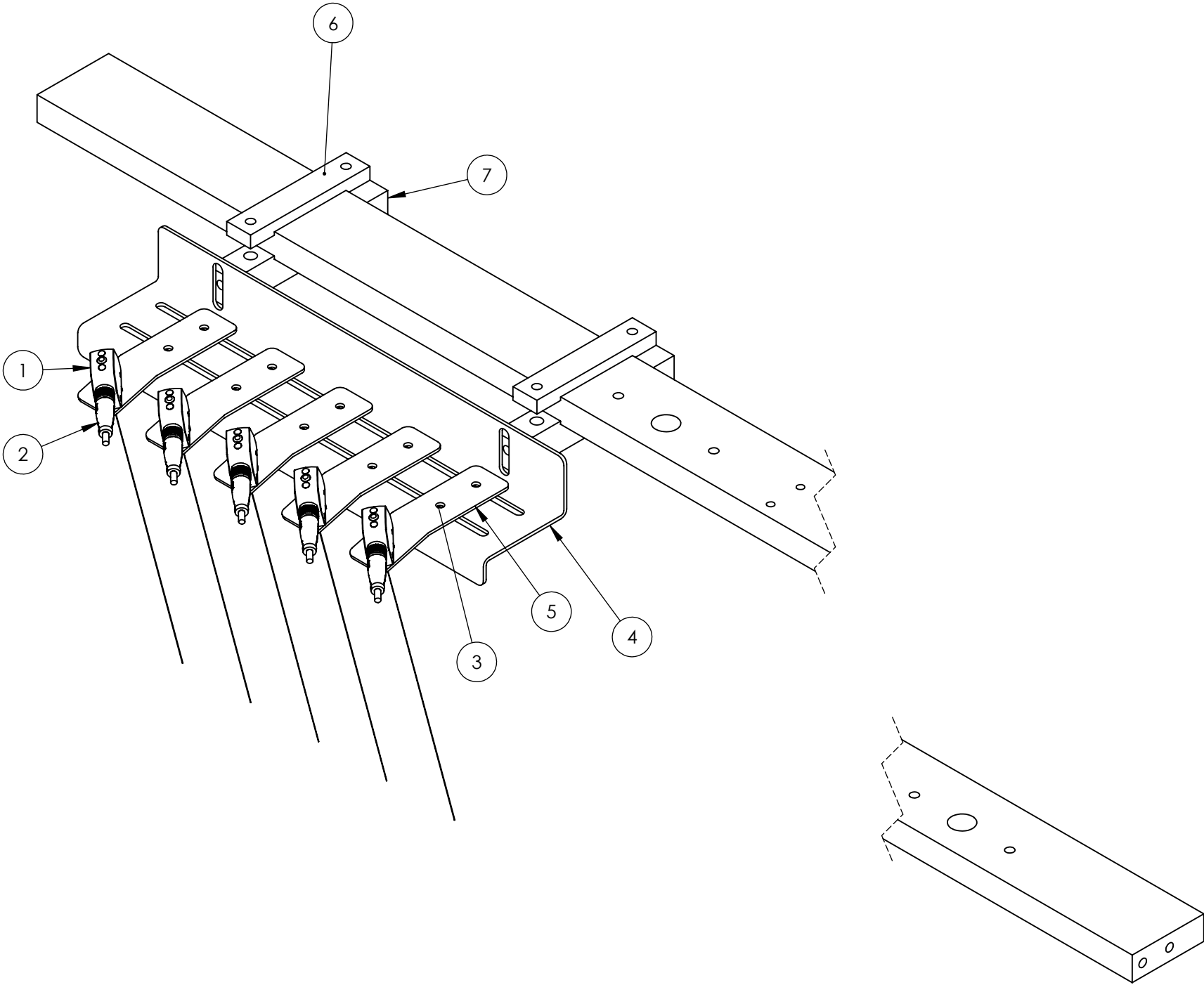
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|-------------------------------------------------------------------------------------------------------------------------------------------------------|-----------------------------|------|---------|
| UNLESS OTHERWISE SPECIFIED:                                                                                                                           |                             | NAME | DATE    |
| DIMENSIONS ARE IN INCHES<br>TOLERANCES:<br>FRACTIONAL ± .015<br>ANGULAR: MACH±0.5° BEND ±5°<br>TWO PLACE DECIMAL ± .010<br>THREE PLACE DECIMAL ± .005 | DRAWN                       | RB   | 6/24/20 |
|                                                                                                                                                       | DESIGNER                    |      |         |
|                                                                                                                                                       | ENG APPR.                   |      |         |
|                                                                                                                                                       | MFG APPR.                   |      |         |
| INTERPRET GEOMETRIC<br>TOLERANCING PER:                                                                                                               | Q.A.                        |      |         |
| MATERIAL                                                                                                                                              | COMMERCIAL PART             |      |         |
| FINISH                                                                                                                                                | EST. WEIGHT (lbs):<br>17.05 |      |         |
| DO NOT SCALE DRAWING                                                                                                                                  |                             |      |         |

TITLE:  
CARTONING LANE GUIDE ASM, SLEEK

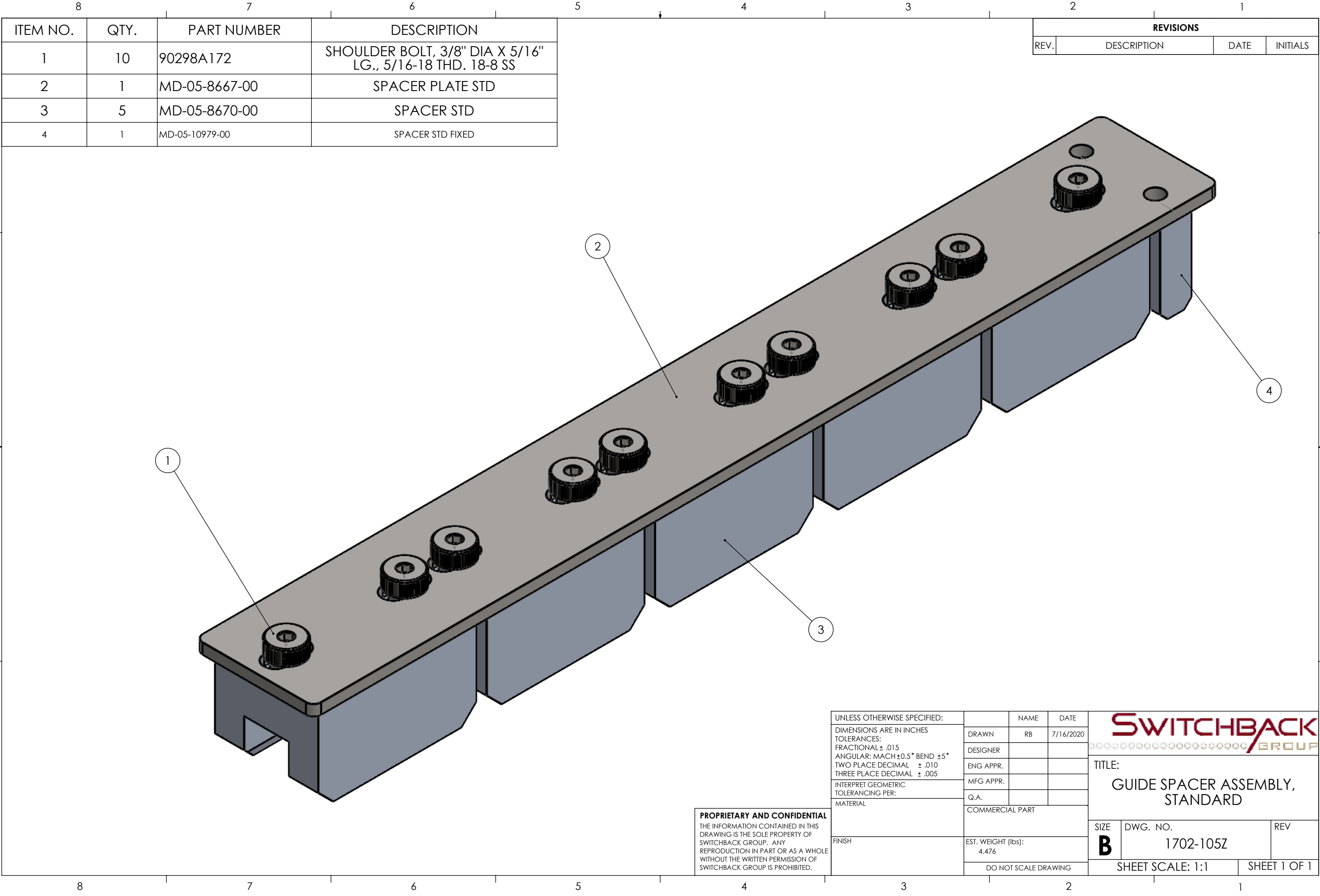
|                  |           |              |
|------------------|-----------|--------------|
| SIZE             | DWG. NO.  | REV          |
| <b>D</b>         | 1702-105S |              |
| SHEET SCALE: 1:1 |           | SHEET 1 OF 1 |

| ITEM NO. | QTY. | PART NUMBER      | DESCRIPTION                                  |
|----------|------|------------------|----------------------------------------------|
| 1        | 5    | Q4XTULAF-300-Q8  | LASER DISTANCE SENSOR, 300MM RANGE, 10-30VDC |
| 2        | 5    | V1-G-BK10M-PVC-U | M12 CABLE, STRAIGHT, 10M LG, 4-PIN           |
| 3        | 5    | MD-05-10505-00   | NUT BAR                                      |
| 4        | 1    | MD-05-10928-00   | SENSOR STRINGER                              |
| 5        | 5    | MD-05-10929-00   | SENSOR BRACKET                               |
| 6        | 2    | MD-05-10930-00   | MOUNT PLATE BLOCK                            |
| 7        | 2    | MD-05-10931-00   | MOUNT PLATE BLOCK                            |

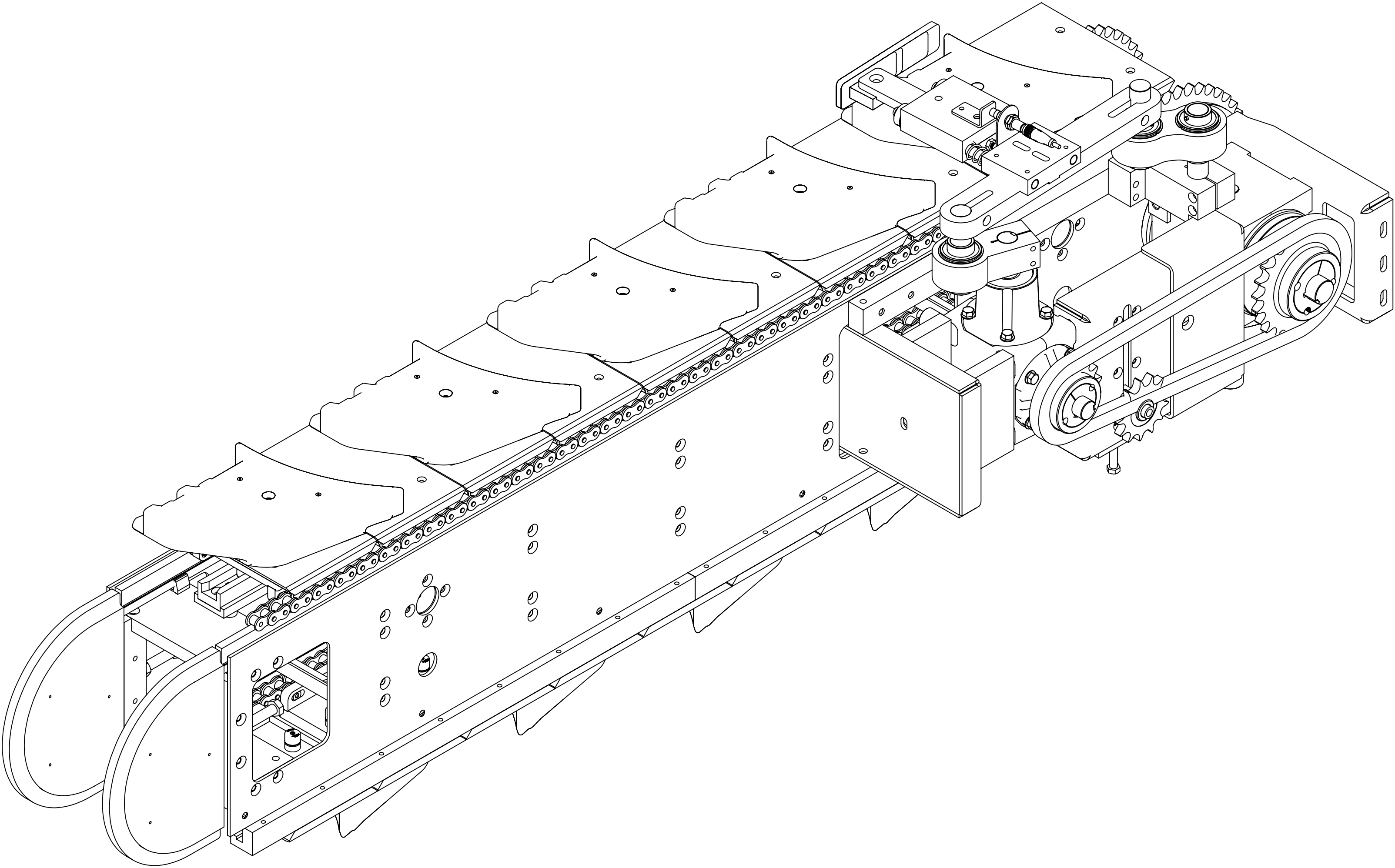


| REVISIONS |             |      |          |
|-----------|-------------|------|----------|
| REV.      | DESCRIPTION | DATE | INITIALS |

|                                                                                                                                                                                              |  |                      |          |
|----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--|----------------------|----------|
| UNLESS OTHERWISE SPECIFIED:                                                                                                                                                                  |  | NAME                 | DATE     |
| DIMENSIONS ARE IN INCHES                                                                                                                                                                     |  | DRAWN                | RB       |
| TOLERANCES:                                                                                                                                                                                  |  | DESIGNER             |          |
| FRACTIONAL ± .015                                                                                                                                                                            |  | ENG APPR.            |          |
| ANGULAR: MACH±0.5° BEND ±5°                                                                                                                                                                  |  | MFG APPR.            |          |
| TWO PLACE DECIMAL ± .010                                                                                                                                                                     |  | Q.A.                 |          |
| THREE PLACE DECIMAL ± .005                                                                                                                                                                   |  | COMMERCIAL PART      |          |
| INTERPRET GEOMETRIC TOLERANCING PER:                                                                                                                                                         |  | EST. WEIGHT (lbs):   |          |
| MATERIAL                                                                                                                                                                                     |  | 62.368               |          |
| FINISH                                                                                                                                                                                       |  | DO NOT SCALE DRAWING |          |
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|                                                                                                                                                                                              |  | SENSOR ASSEMBLY      |          |
|                                                                                                                                                                                              |  | SIZE                 | DWG. NO. |
| B                                                                                                                                                                                            |  | 1702-105Y            | REV      |
| SHEET SCALE: 1:4                                                                                                                                                                             |  | SHEET 1 OF 1         |          |



| ITEM NO. | QTY | PART NUMBER                     | DESCRIPTION                                             |
|----------|-----|---------------------------------|---------------------------------------------------------|
| 1        | 12  | VG-016-01                       | RAIL CLIP                                               |
| 2        | 1   | 57095K163                       | TAPER-LOCK BUSHING, 1610, 1" BORE                       |
| 3        | 1   | 60BB13H                         | IDLER SPROCKET, #60, 13 TOOTH, 5/8" BORE                |
| 4        | 1   | 60BTL16                         | NO. 60, B-TYPE SPROCKET, 16T, BORED FOR 1610 TAPER-LOCK |
| 5        | 1   | 60BTL24                         | NO. 60, B-TYPE SPROCKET, 24T, BORED FOR 2012 TAPER-LOCK |
| 6        | 6   | 7616 DLG                        | BALL BEARING, 1.00 ID, w/SNAP RING                      |
| 7        | 2   | 91847A520                       | 1/2"-13 HEX THIN NUT                                    |
| 8        | 6   | 92511A104                       | SPACER, 5/16" SCREW, 7/8" LG, 3/4" OD                   |
| 9        | 1   | 214-DE-2to1                     | MODEL 214 GEARBOX, TYPE DE, 2:1                         |
| 10       | 1   | 0220-74759                      | RIGHT ANGLE BEVEL GEARBOX, 1-1/4" THRU BORE, 1:1        |
| 11       | 1   | PL1-1_4 AS-SS                   | LOCKING COLLAR - 1 1/4" BORE, SS                        |
| 12       | 1   | SUCSF 206-20                    | 4-BOLT FLANGE BEARING, 1-1/4" BORE                      |
| 13       | 2   | 57095K185                       | 2012 TAPER LOCK BUSHING, 1-1/4" BORE                    |
| 14       | 1   | 60BTL48                         | NO. 60, B-TYPE SPROCKET, 48T, BORED FOR TAPER-LOCK      |
| 15       | 1   | CL-20-SS                        | 1-PC SPLIT SHAFT COLLAR                                 |
| 16       | 1   | 92240A640                       | 3/8"-16 X 4" LG HHCS, FULL THRD                         |
| 17       | 1   | 1702-107 FINAL PUSH DRIVE CHAIN | CAN PUSH DRIVE CHAIN, 52" LG, NO. 60                    |
| 18       | 1   | 1702-107B                       | WEDGE CHAIN ASSEMBLY                                    |
| 19       | 1   | 1702-107C                       | PUSHER W/OVERLOAD                                       |
| 20       | 1   | MD-07-6394-00                   | CAM TRACK                                               |
| 21       | 1   | MD-07-6395-00                   | CAM TRACK MOUNT                                         |
| 22       | 10  | MD-07-6400-00                   | GUIDE RAIL SUPPORT                                      |
| 23       | 2   | MD-07-6402-00                   | IDLER PIN                                               |
| 24       | 4   | MD-07-6403-00                   | IDLER PIN - LONG                                        |
| 25       | 2   | MD-07-6410-00                   | TENSION SCREW                                           |
| 26       | 2   | MD-07-6412-00                   | TENSIONER MOUNT BAR                                     |
| 27       | 2   | MD-07-6415-00                   | WEDGE CHAIN GUIDE                                       |
| 28       | 2   | MD-07-6419-00                   | WEDGE CONV TENSIONER BLOCK                              |
| 29       | 2   | MD-07-6420-00                   | WEDGE LOAD IDLER                                        |
| 30       | 1   | MD-07-6439-00                   | GEARBOX MOUNT PLATE - RH                                |
| 31       | 1   | MD-07-6442-00                   | WEDGE LOADER FRAME PANEL A1                             |
| 32       | 1   | MD-07-6443-00                   | WEDGE LOADER FRAME PANEL B1                             |
| 33       | 1   | MD-07-6516-00                   | FIXED PIVOT SHAFT                                       |
| 34       | 1   | MD-07-6518-00                   | WEDGE CONV DRIVE SHAFT                                  |
| 35       | 2   | MD-07-6520-00                   | FRAME SHAFT MOUNT                                       |
| 36       | 2   | MD-07-6521-00                   | STRONGBACK SHAFT MOUNT                                  |
| 37       | 1   | MD-07-6522-00                   | WEDGE CONV DRIVE SPROCKET                               |
| 38       | 1   | MD-07-6525-00                   | CHAIN RETURN GUIDE A                                    |
| 39       | 1   | MD-07-6526-00                   | CHANEEL RETURN GUIDE B                                  |
| 40       | 2   | MD-07-6527-00                   | CHANNEL RETURN GUIDE C                                  |
| 41       | 1   | MD-07-6528-00                   | SIDE PANEL STIFFENER B                                  |
| 42       | 1   | MD-07-6529-00                   | WEDGE CONV GEARBOX MOUNT                                |
| 43       | 1   | MD-07-6533-00                   | GEARBOX SECONDARY BRKT B                                |
| 44       | 2   | MD-07-6534-00                   | SPROCKET SPACER                                         |
| 45       | 1   | MD-07-6535-00                   | GEARBOX MOUNT NUT PLATE                                 |
| 46       | 1   | MD-07-6536-00                   | TENSION BACKUP PLATE                                    |
| 47       | 1   | MD-07-6537-00                   | TENSIONER SHAFT                                         |
| 48       | 1   | MD-07-6538-00                   | TENSIONER NUT BLOCK                                     |
| 49       | 1   | MD-07-6539-00                   | JACK BLOCK                                              |
| 50       | 1   | MD-07-6579-00                   | BEARING SPACER                                          |
| 51       | 1   | MD-07-6963-00                   | MOTION ARM                                              |
| 52       | 1   | MD-07-6964-00                   | PIVOT BEARING LINK                                      |
| 53       | 1   | MD-07-6965-00                   | MOTOR PLATE MNT                                         |
| 54       | 2   | MD-07-6976-00                   | GEARBOX SPACER                                          |
| 55       | 1   | MD-07-6977-00                   | FIXED PIVOT MOUNT                                       |
| 56       | 1   | MD-07-7104-00                   | GEARBOX SECONDARY BRKT-LH                               |
| 57       | 2   | MD-07-9254-00                   | FIX PIVOT MOUNT                                         |
| 58       | 1   | MD-07-9256-00                   | ROTATING LINK                                           |



NOTES:  
1. USE STAINLESS STEEL HARDWARE UNLESS OTHERWISE SPECIFIED.

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|                                      |                      |        |         |
|--------------------------------------|----------------------|--------|---------|
| UNLESS OTHERWISE SPECIFIED:          |                      | NAME   | DATE    |
| DIMENSIONS ARE IN INCHES             | DRAWN                | RB     | 6/24/20 |
| TOLERANCES:                          | DESIGNER             |        |         |
| FRACTIONAL ± .015                    | ENG APPR.            |        |         |
| ANGULAR: MACH±0.5° BEND ±5°          |                      |        |         |
| TWO PLACE DECIMAL ± .010             |                      |        |         |
| THREE PLACE DECIMAL ± .005           |                      |        |         |
| INTERPRET GEOMETRIC TOLERANCING PER: | MFG APPR.            |        |         |
| MATERIAL                             | Q.A.                 |        |         |
|                                      | COMMERCIAL PART      |        |         |
| FINISH                               | EST. WEIGHT (lbs):   | 465.70 |         |
|                                      | DO NOT SCALE DRAWING |        |         |

SWITCHBACK GROUP

TITLE:  
WEDGE LOADER ASM

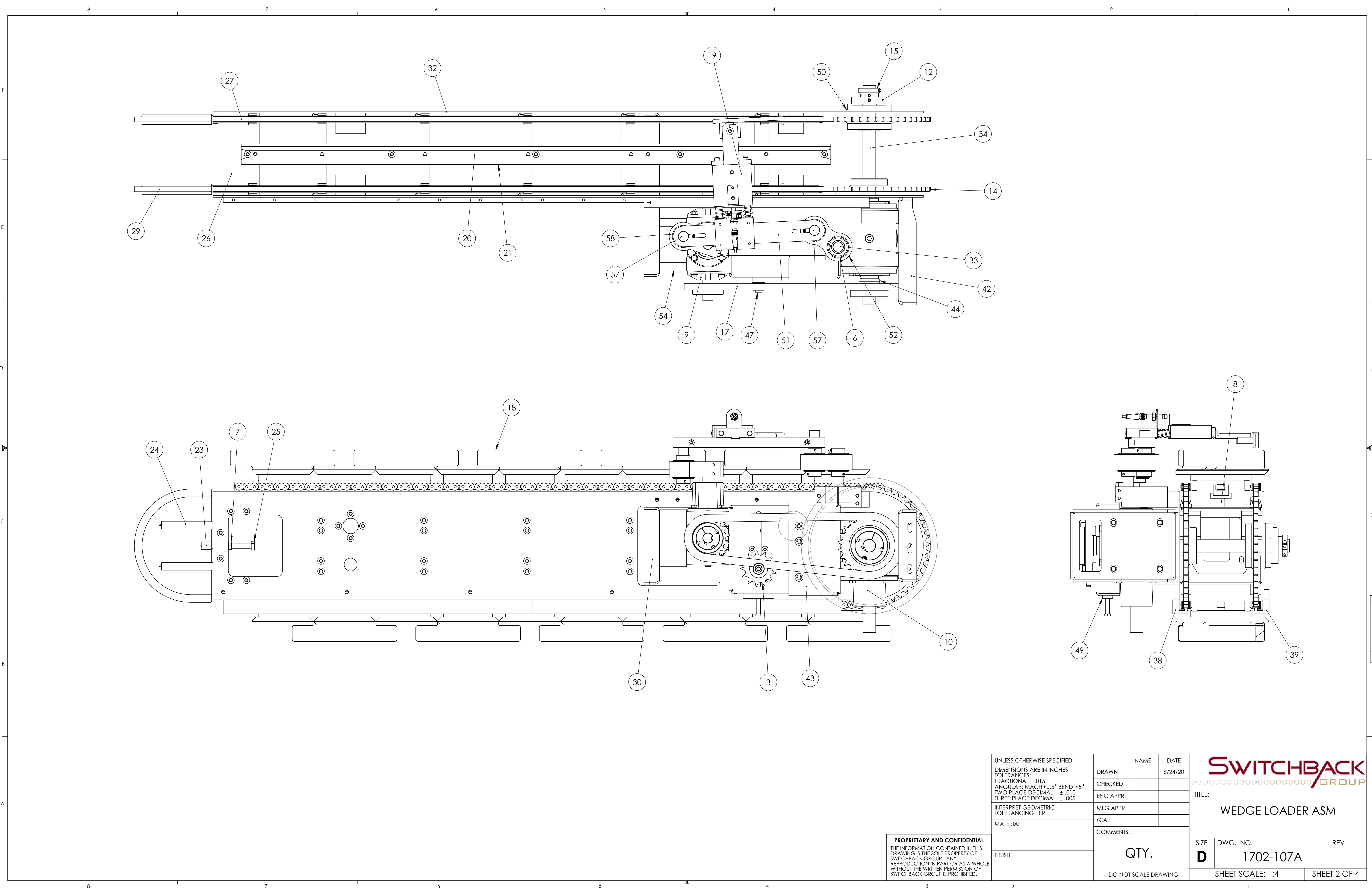
SIZE  
D

DWG. NO.  
1702-107A

REV

SHEET SCALE: 1:4

SHEET 1 OF 4

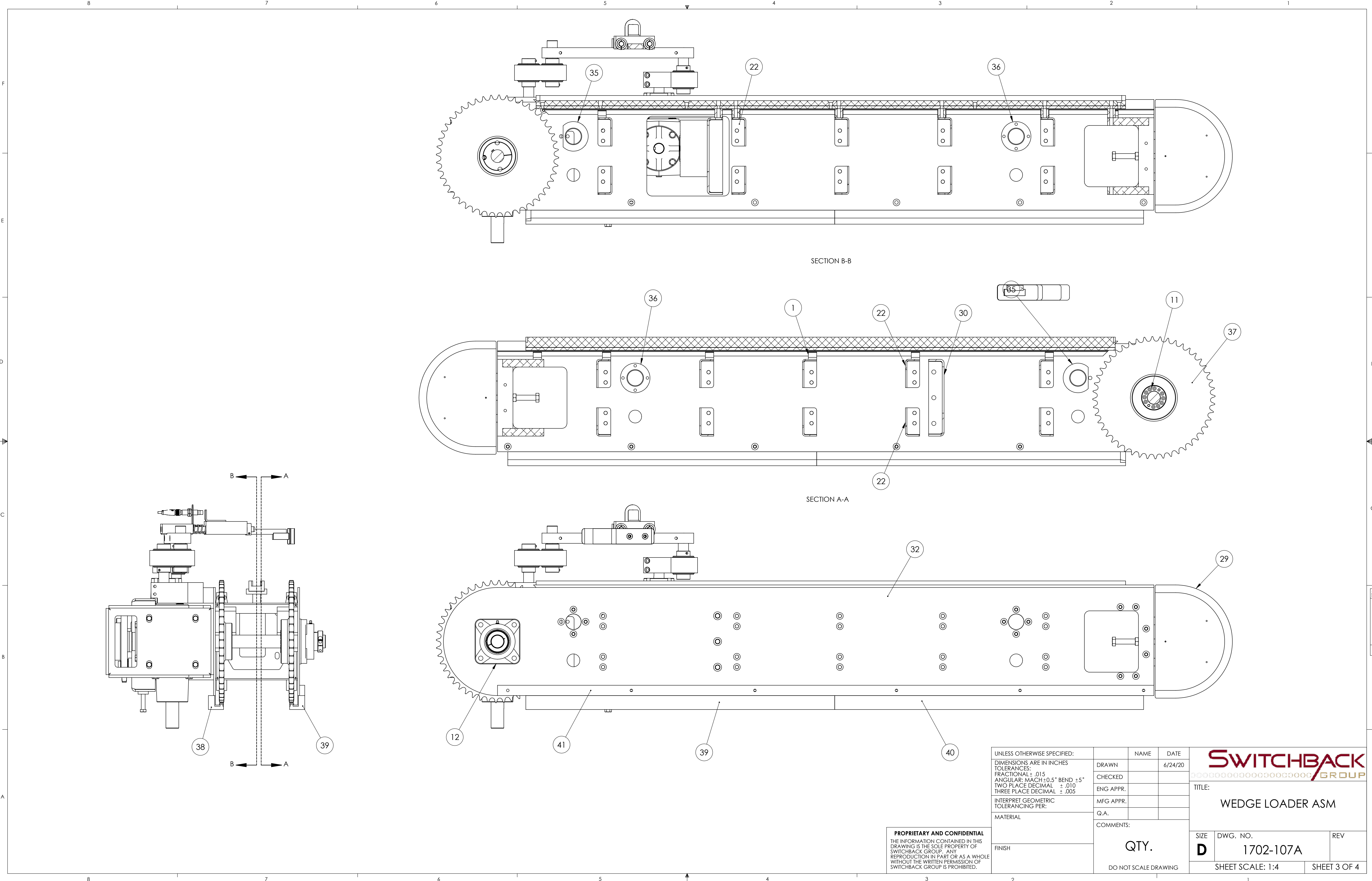


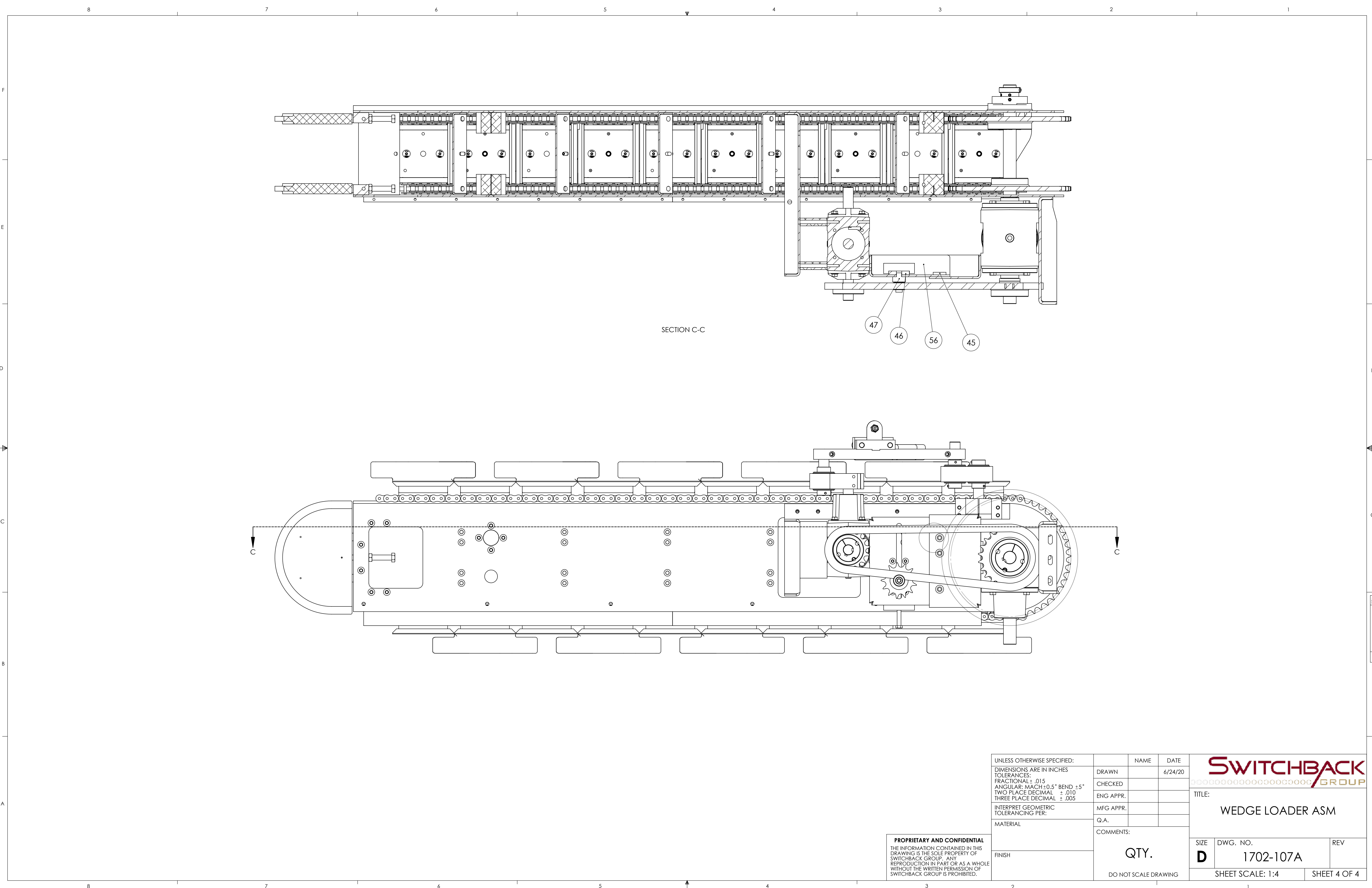
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|--------------------------------------|--|----------------------|-----------|
| UNLESS OTHERWISE SPECIFIED:          |  | NAME                 | DATE      |
| DIMENSIONS ARE IN INCHES             |  |                      |           |
| TOLERANCES:                          |  | DRAWN                | 6/24/20   |
| FRACTIONAL ± .015                    |  | CHECKED              |           |
| ANGULAR: MACH ± 0.5° BEND ± 5°       |  | ENG APPR.            |           |
| TWO PLACE DECIMAL ± .010             |  | MFG APPR.            |           |
| THREE PLACE DECIMAL ± .005           |  | Q.A.                 |           |
| INTERPRET GEOMETRIC TOLERANCING PER: |  | COMMENTS:            |           |
| MATERIAL                             |  | QTY.                 |           |
| FINISH                               |  | DO NOT SCALE DRAWING |           |
|                                      |  | SIZE                 | DWG. NO.  |
|                                      |  | <b>D</b>             | 1702-107A |
|                                      |  | REV                  |           |
|                                      |  | SHEET SCALE: 1:4     |           |
|                                      |  | SHEET 2 OF 4         |           |

**SWITCHBACK GROUP**

TITLE:  
**WEDGE LOADER ASM**





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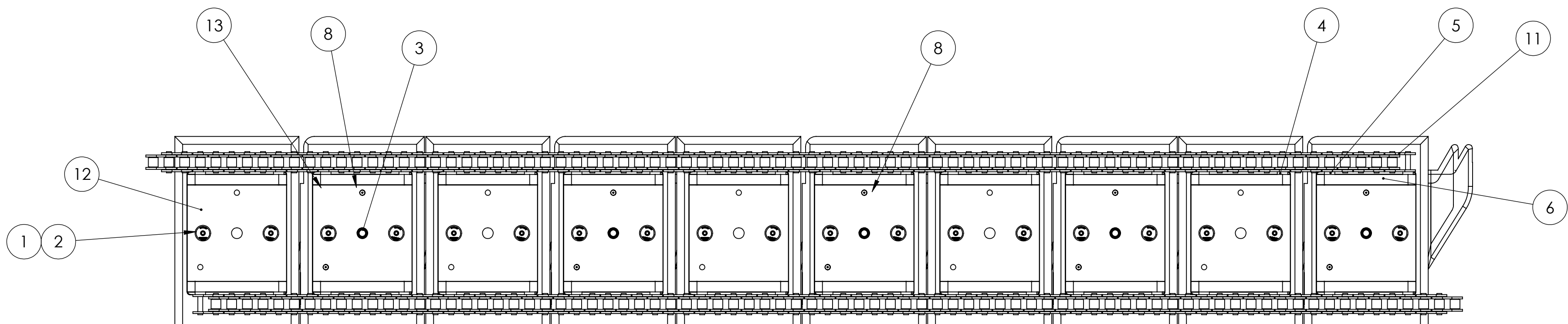
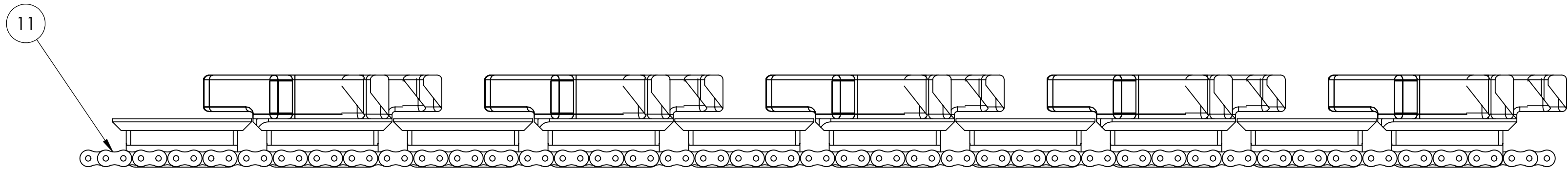
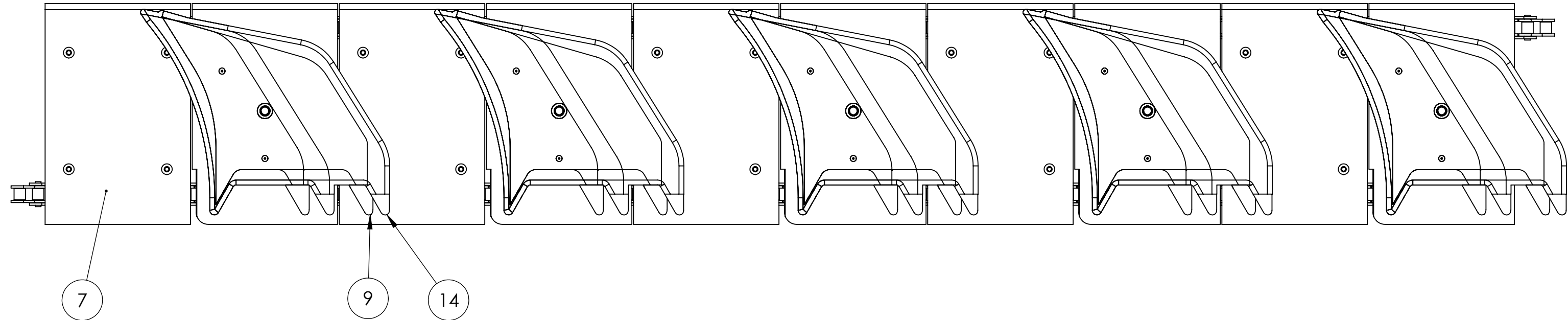
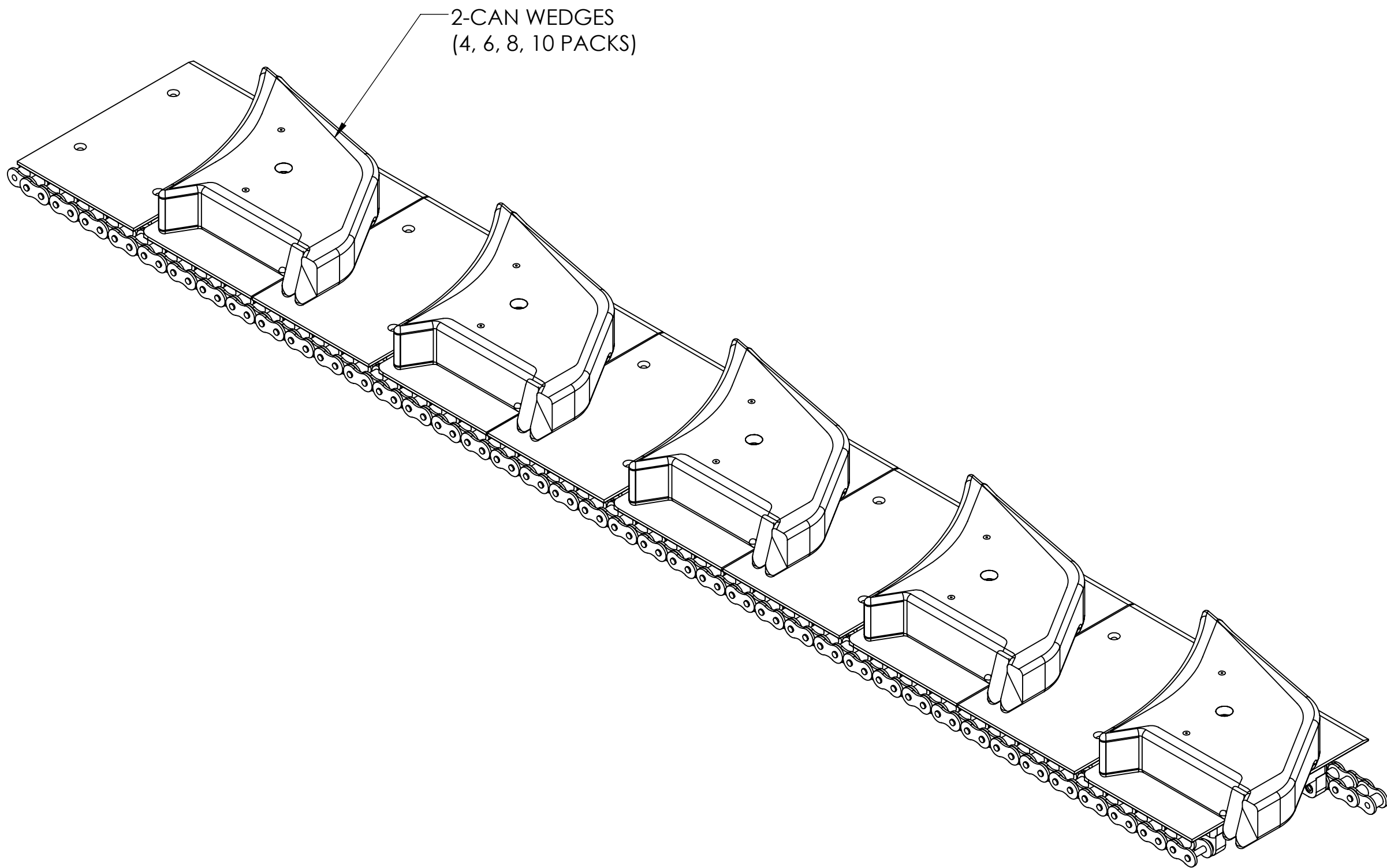
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|----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|----------------------|------|---------|
| UNLESS OTHERWISE SPECIFIED:<br>DIMENSIONS ARE IN INCHES<br>TOLERANCES:<br>FRACTIONAL ± .015<br>ANGULAR: MACH ± 0.5° BEND ± 5°<br>TWO PLACE DECIMAL ± .010<br>THREE PLACE DECIMAL ± .005<br>INTERPRET GEOMETRIC<br>TOLERANCING PER:<br>MATERIAL<br>FINISH |                      | NAME | DATE    |
|                                                                                                                                                                                                                                                          | DRAWN                |      | 6/24/20 |
|                                                                                                                                                                                                                                                          | CHECKED              |      |         |
|                                                                                                                                                                                                                                                          | ENG APPR.            |      |         |
|                                                                                                                                                                                                                                                          | MFG APPR.            |      |         |
|                                                                                                                                                                                                                                                          | Q.A.                 |      |         |
|                                                                                                                                                                                                                                                          | COMMENTS:            |      |         |
|                                                                                                                                                                                                                                                          | QTY.                 |      |         |
|                                                                                                                                                                                                                                                          | DO NOT SCALE DRAWING |      |         |

|                            |           |              |
|----------------------------|-----------|--------------|
| <b>SWITCHBACK</b><br>GROUP |           |              |
| TITLE:                     |           |              |
| WEDGE LOADER ASM           |           |              |
| SIZE                       | DWG. NO.  | REV          |
| <b>D</b>                   | 1702-107A |              |
| SHEET SCALE: 1:4           |           | SHEET 4 OF 4 |

REV  
1702-107A  
**D**

| ITEM NO. | QTY | PART NUMBER         | DESCRIPTION                                                  |
|----------|-----|---------------------|--------------------------------------------------------------|
| 1        | 56  | 92510A494           | SPACER, .380" ID, 3/4" OD, 5/16" LG                          |
| 2        | 56  | S24LW               | CAM FOLLOWER, 3/4" OD                                        |
| 3        | 14  | 91731A054           | THREAD INSERT, KEY-LOCKING, 3/8"-16ID THRD, 9/16"-12 OD THRD |
| 4        | 56  | 07-9220-00          | CHAIN PIN BUSHING                                            |
| 5        | 56  | 07-9221-00          | CHAIN PIN BUSHING, FLT                                       |
| 6        | 56  | 07-9222-00 REV A    | SHUTTLE PLATE MOUNT                                          |
| 7        | 14  | 07-9224-00 REV C    | SHUTTLE TOP PAD                                              |
| 8        | 28  | 07-9226-00          | LOCATING PIN                                                 |
| 9        | 14  | MD-07-7317-00       | 2-CT CAN WEDGE - RH                                          |
| 10       | 5   | MD-07-7318-00       | 3-CT CAN WEDGE - RH                                          |
| 11       | 2   | MD-07-6427-00       | WEDGE CHAIN, NO. 60 ATTACHMENT CHAIN                         |
| 12       | 28  | MD-07-6446-00       | SHUTTLE TOP A                                                |
| 13       | 14  | MD-07-6447-00 REV B | SHUTTLE TOP PAD A                                            |
| 14       | 5   | MD-07-7315-00       | 2-CT SLEEK CAN WEDGE - RH                                    |
| 15       | 5   | MD-07-7316-00       | 3-CT SLEEK CAN WEDGE - RH                                    |

| REVISIONS |             |      |          |
|-----------|-------------|------|----------|
| REV.      | DESCRIPTION | DATE | INITIALS |

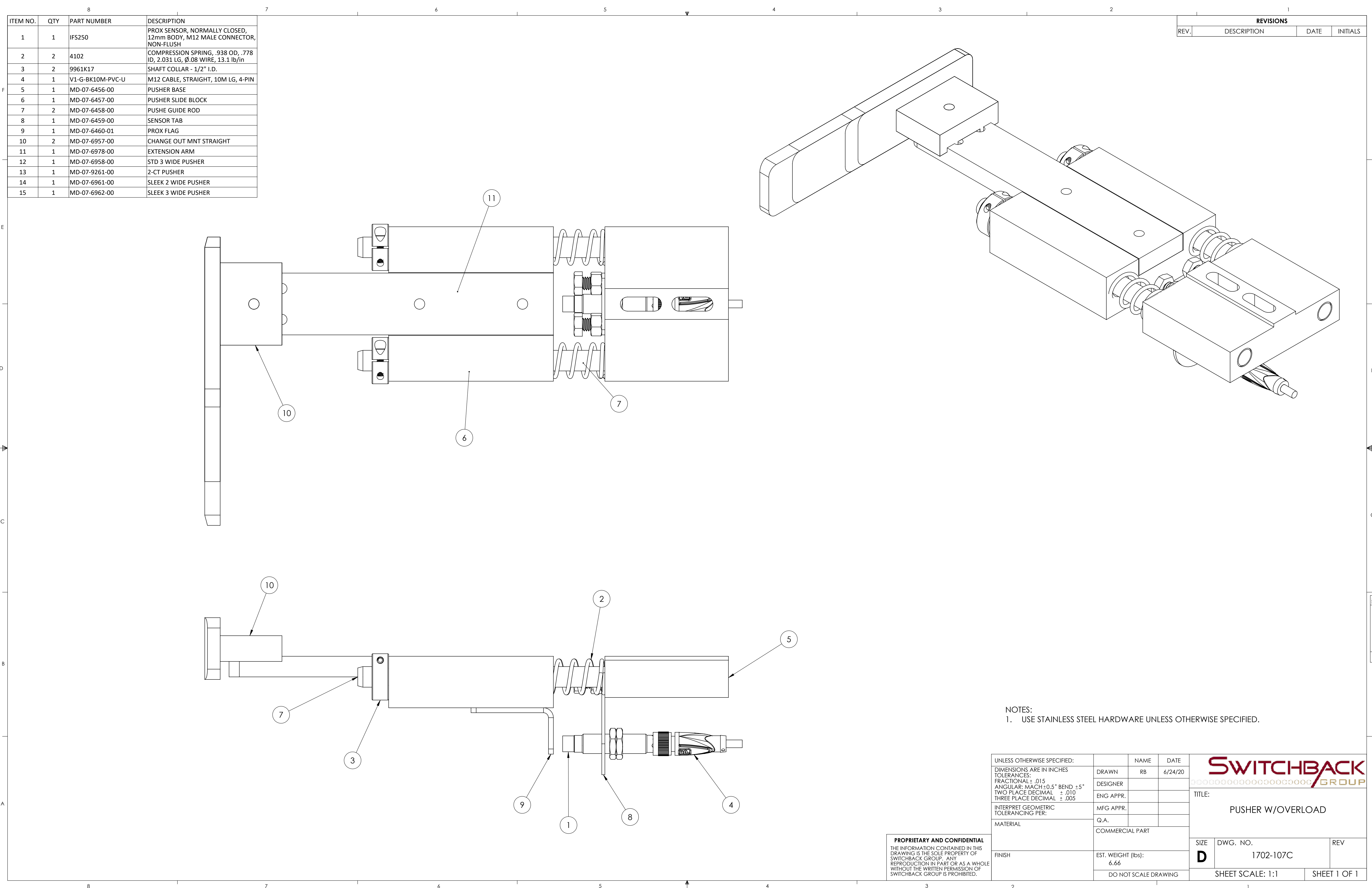


NOTES:

1. DO NOT PRE-ASSEMBLE WEDGES AND TOP PLATES.
2. INSTALL CHAIN ONTO CONVEYOR.
3. PLACE ONE(1) SHUTTLE PLATE MOUNT WITH INSERTS ON EACH CHAIN, ACROSS FROM EACH OTHER.
4. ATTACH ALUMINUM SHUTTLE TOP PLATE TO PLATE MOUNTS.
5. ATTACH APPROPRIATE DELRIN TOP PLATE TO EACH ALUMINUM TOP PLATE.
6. INSTALL WEDGE SIZE APPROPRIATE FOR START-UP.
7. USE STAINLESS STEEL HARDWARE UNLESS OTHERWISE SPECIFIED.

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|-------------------------------------------------------------------------------------------------------------------------------------------------------|--|-----------------------------------------|---------------------------------------------------------------------------------------|----------|------------------------------------|---------------------------------------------------------------------------------------|--|-----|-----------|
| UNLESS OTHERWISE SPECIFIED:                                                                                                                           |  | NAME                                    |                                                                                       | DATE     |                                    |  |  |     |           |
| DIMENSIONS ARE IN INCHES<br>TOLERANCES:<br>FRACTIONAL ± .015<br>ANGULAR: MACH±0.5° BEND ±5°<br>TWO PLACE DECIMAL ± .010<br>THREE PLACE DECIMAL ± .005 |  | DRAWN                                   | RB                                                                                    | 6/24/20  |                                    |                                                                                       |  |     |           |
| MATERIAL                                                                                                                                              |  | DESIGNER                                |  |          | TITLE:<br><br>WEDGE CHAIN ASSEMBLY |                                                                                       |  |     |           |
|                                                                                                                                                       |  | ENG APPR.                               |                                                                                       |          |                                    |                                                                                       |  |     |           |
|                                                                                                                                                       |  | INTERPRET GEOMETRIC<br>TOLERANCING PER: |                                                                                       |          |                                    |                                                                                       |  |     | ENG APPR. |
|                                                                                                                                                       |  | Q.A.                                    |                                                                                       |          |                                    |                                                                                       |  |     |           |
| FINISH                                                                                                                                                |  | COMMERCIAL PART                         |                                                                                       | SIZE     |                                    | DWG. NO.                                                                              |  | REV |           |
|                                                                                                                                                       |  | EST. WEIGHT (lbs):<br>96.98             |                                                                                       | <b>D</b> |                                    | 1702-107B                                                                             |  |     |           |
| DO NOT SCALE DRAWING                                                                                                                                  |  | SHEET SCALE: 1:4                        |                                                                                       |          |                                    |                                                                                       |  |     |           |



| ITEM NO. | QTY | PART NUMBER      | DESCRIPTION                                                            |
|----------|-----|------------------|------------------------------------------------------------------------|
| 1        | 1   | IFS250           | PROX SENSOR, NORMALLY CLOSED, 12mm BODY, M12 MALE CONNECTOR, NON-FLUSH |
| 2        | 2   | 4102             | COMPRESSION SPRING, .938 OD, .778 ID, 2.031 LG, Ø.08 WIRE, 13.1 lb/in  |
| 3        | 2   | 9961K17          | SHAFT COLLAR - 1/2" I.D.                                               |
| 4        | 1   | V1-G-BK10M-PVC-U | M12 CABLE, STRAIGHT, 10M LG, 4-PIN                                     |
| 5        | 1   | MD-07-6456-00    | PUSHER BASE                                                            |
| 6        | 1   | MD-07-6457-00    | PUSHER SLIDE BLOCK                                                     |
| 7        | 2   | MD-07-6458-00    | PUSHE GUIDE ROD                                                        |
| 8        | 1   | MD-07-6459-00    | SENSOR TAB                                                             |
| 9        | 1   | MD-07-6460-01    | PROX FLAG                                                              |
| 10       | 2   | MD-07-6957-00    | CHANGE OUT MNT STRAIGHT                                                |
| 11       | 1   | MD-07-6978-00    | EXTENSION ARM                                                          |
| 12       | 1   | MD-07-6958-00    | STD 3 WIDE PUSHER                                                      |
| 13       | 1   | MD-07-9261-00    | 2-CT PUSHER                                                            |
| 14       | 1   | MD-07-6961-00    | SLEEK 2 WIDE PUSHER                                                    |
| 15       | 1   | MD-07-6962-00    | SLEEK 3 WIDE PUSHER                                                    |

| REVISIONS |             |      |          |
|-----------|-------------|------|----------|
| REV.      | DESCRIPTION | DATE | INITIALS |

NOTES:  
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|--------------------------------------|----------------------|------|---------|
| UNLESS OTHERWISE SPECIFIED:          |                      | NAME | DATE    |
| DIMENSIONS ARE IN INCHES             | DRAWN                | RB   | 6/24/20 |
| TOLERANCES:                          | DESIGNER             |      |         |
| FRACTIONAL ± .015                    | ENG APPR.            |      |         |
| ANGULAR: MACH ±0.5° BEND ±5°         |                      |      |         |
| TWO PLACE DECIMAL ± .010             | MFG APPR.            |      |         |
| THREE PLACE DECIMAL ± .005           | Q.A.                 |      |         |
| INTERPRET GEOMETRIC TOLERANCING PER: | COMMERCIAL PART      |      |         |
| MATERIAL                             |                      |      |         |
| FINISH                               | EST. WEIGHT (lbs):   |      |         |
|                                      | 6.66                 |      |         |
|                                      | DO NOT SCALE DRAWING |      |         |

|                            |           |              |
|----------------------------|-----------|--------------|
| <b>SWITCHBACK</b><br>GROUP |           |              |
| TITLE:                     |           |              |
| PUSHER W/OVERLOAD          |           |              |
| SIZE                       | DWG. NO.  | REV          |
| <b>D</b>                   | 1702-107C |              |
| SHEET SCALE: 1:1           |           | SHEET 1 OF 1 |

| ITEM NO. |   |                              |  | QTY.                                                                            |  |  |  | PART NUMBER |   |                              |  | DESCRIPTION                                           |  |  |  |
|----------|---|------------------------------|--|---------------------------------------------------------------------------------|--|--|--|-------------|---|------------------------------|--|-------------------------------------------------------|--|--|--|
| 1        | 1 | 1610 X 32mm                  |  | TAPER LOCK BUSHING, 1610, 32mm BORE                                             |  |  |  | 2           | 1 | 1702-108 MAG LIFT CHAIN      |  | NO 40 CHAIN, NICKEL PLATED, 87.5" LG                  |  |  |  |
| 3        | 1 | 1702-108 MAG TOP GUIDE CHAIN |  | NO 40 CHAIN, NICKEL PLATED, 87.25" LG                                           |  |  |  | 4           | 1 | 2090-CFBM7DF-CEAA07          |  | 7M SPEEDTEC FEED BACK CABLE                           |  |  |  |
| 5        | 1 | 2090-CPBM7DF-16AA07          |  | 7M SPEEDTEC POWER CABLE W/ BRAKE WIRES                                          |  |  |  | 6           | 2 | 40BS12 X .625                |  | 40BS12 X 5/8" SPROCKET                                |  |  |  |
| 7        | 2 | 40BS14 X .75                 |  | 40BS14 X 3/4" SPROCKET                                                          |  |  |  | 8           | 1 | 4464K563                     |  | 3/8" NPT PIPE PLUG                                    |  |  |  |
| 9        | 2 | 4648K16                      |  | 5/8" BORE, FOOD GRADE BALL BEARING                                              |  |  |  | 10          | 1 | 5469K123                     |  | MANIFOLD, 3/8 NPT INLET, (4) 1/4 NPT OUTLETS          |  |  |  |
| 11       | 2 | 57095K136                    |  | TAPER-LOCK BUSHING, SIZE 1210, 1-1/4" BORE                                      |  |  |  | 12          | 1 | 5906K517                     |  | THRUST WASHER, 3/4" ID X 1-1/4" OD X 1/16" LG         |  |  |  |
| 13       | 4 | 5906K547                     |  | THRUST WASHER, 5/8 x 1-1/4 x 1/16                                               |  |  |  | 14          | 4 | 60655K592                    |  | ADJUSTABLE HANDLE, 5/16"-18 X 3/4" LG STUD, ORANGE    |  |  |  |
| 15       | 8 | 60655K622                    |  | 5/16"-18 X 2" STUD, ADJUSTABLE HANDLE                                           |  |  |  | 16          | 1 | 6338K427                     |  | FLANGE BEARING                                        |  |  |  |
| 17       | 1 | 6338K429                     |  | FLANGE BEARING, 3/4" BORE, 1/2" LG, 1/8" THK FLANGE                             |  |  |  | 18          | 1 | 6338K472                     |  | FLANGE BEARING, 3/4" BORE, 3/4" LG, 1/8" THK FLANGE   |  |  |  |
| 19       | 1 | 6338K473                     |  | FLANGE BEARING, 5/8" BORE, 5/8" LG, 1/8" THK FLANGE                             |  |  |  | 20          | 2 | 6391K203                     |  | 5/8" ID X 7/8" OD X 3/4" LG SLEEVE BEARING            |  |  |  |
| 21       | 2 | 6655K19                      |  | THRUST BEARING                                                                  |  |  |  | 22          | 2 | 6843K180                     |  | MITER GEAR, 20 TEETH, 10 PITCH                        |  |  |  |
| 23       | 2 | 6843K19                      |  | MITER GEAR, 20 deg PRES ANGLE, 3/4" KEYED BORE, 10 PITCH, 20T                   |  |  |  | 24          | 2 | 7095K47                      |  | Ø3/4" x 1" LG BRONZE BEARING                          |  |  |  |
| 25       | 1 | 90044A156                    |  | 3/8"-16 X 6" LG SHCS, FULL THRD, BLACK OXIDE                                    |  |  |  | 26          | 1 | 91259A796                    |  | SHOULDER BOLT, 5/8 DIA x 1.25 LG, 1/2-13 STUD         |  |  |  |
| 27       | 1 | 91259A800                    |  | 5/8" SHOULDER SCREW, 1-3/4" LG, 1/2-13 THRD                                     |  |  |  | 28          | 8 | 91847A515                    |  | 7/16"-20 THIN NUT                                     |  |  |  |
| 29       | 8 | 91847A545                    |  | 5/8"-18 HEX NUT, THIN                                                           |  |  |  | 30          | 8 | 92146A032                    |  | 7/16" PLIT LOCK WASHER                                |  |  |  |
| 31       | 8 | 92146A035                    |  | 5/8" SPLIT LOCK WASHER                                                          |  |  |  | 32          | 8 | 92320A265                    |  | SPACER, 5/8" BORE, 3/8" LG, 1" OD                     |  |  |  |
| 33       | 2 | 92383A749                    |  | SLOTTED SPRING PIN                                                              |  |  |  | 34          | 2 | 92510A489                    |  | SPACER, .32 ID x .75 OD, .25 THICK, ALUM              |  |  |  |
| 35       | 1 | 92620A639                    |  | 3/8"-16 x 4" HHCS, GR 8, FULL THRD                                              |  |  |  | 36          | 1 | 9368T174                     |  | SLEEVE BEARING, 5/8 ID x 3/4 OD, 5/8" LG              |  |  |  |
| 37       | 1 | 9368T31                      |  | SLEEVE BEARING, 5/8 ID x 3/4 OD, 1" LG                                          |  |  |  | 38          | 8 | 98125A445                    |  | WASHER, FOR 5/8" SCREW, OVERSIZED, .198-.223 THK      |  |  |  |
| 39       | 1 | ABR090-010-S2-P2 MPL-B320P   |  | RIGHT ANGLE PLANETARY GEARBOX, SIZE 090, 10:1, KEYED SHAFT, FOR MPL-B320P SERVO |  |  |  | 40          | 2 | B50-2.30.05AG                |  | B50-2 PIAB SUCTION CUP                                |  |  |  |
| 41       | 2 | C5-11-25-3                   |  | DOOR LATCH                                                                      |  |  |  | 42          | 2 | CL-10-SS                     |  | SS ONE-PIECE SHAFT COLLAR                             |  |  |  |
| 43       | 8 | H32LW                        |  | CAM FOLLOWER, 1" OD, HEAVY STUD                                                 |  |  |  | 44          | 1 | MPL-B320P-MJ74AA             |  | SERVO MOTOR, 460 VAC, W/ 24 VDC BRAKE                 |  |  |  |
| 45       | 2 | new 1702-108 DRIVE BELT A    |  | ERECTOR DRIVE BELT, 1000mm LG, 32mm W, EAGLE 8M                                 |  |  |  | 46          | 2 | 9826                         |  | OIL SEAL                                              |  |  |  |
| 47       | 1 | OP7-A-10-DX-F3_4-R           |  | POSITION INDICATOR, TOP VIEW                                                    |  |  |  | 48          | 1 | OP7-C-10-DX-F3_4-R-D5_8      |  | POSITION INDICATOR, ORANGE, WITH 3/4" TO 5/8" REDUCER |  |  |  |
| 49       | 1 | PC.F.121.S.EBX.F1P2.1X.P2.EK |  | VACUUM PUMP                                                                     |  |  |  | 50          | 3 | PC.F.421.S.EBX.F1P2.1X.P2.EK |  | VACUUM PUMP                                           |  |  |  |
| 51       | 8 | S32LWX                       |  | ECCENTRIC CAM FOLLOWER, 1" OD                                                   |  |  |  | 52          | 1 | SP-10-A                      |  | 2-PC SHAFT COLLAR, 5/8" BORE                          |  |  |  |
| 53       | 1 | SP-12-A                      |  | 2-PC SHAFT COLLAR, 3/4" BORE                                                    |  |  |  | 54          | 2 | SUCTFB 205-16                |  | CHEVRON BEARING, 1" BORE                              |  |  |  |
| 55       | 3 | V19-G-BK10M-PVC-U            |  | M12 CABLE, STRAIGHT, 10M LG, 8-PIN                                              |  |  |  | 56          | 4 | VG-635-BK                    |  | HINGE                                                 |  |  |  |
| 57       | 1 | 1702-108C                    |  | 3-HEAD ROTARY ERECTOR                                                           |  |  |  | 58          | 1 | MD-03-5223-00                |  | HANDLE STORAGE BRACKET                                |  |  |  |
| 59       | 1 | MD-03-5288-00                |  | ADJUSTING HANDLE, 3/4" BORE                                                     |  |  |  | 60          | 2 | MD-08-0138-05                |  | PRE-BREAK VACUUM ARM                                  |  |  |  |
| 61       | 1 | MD-08-5131-00 REV A          |  | SHAFT SLEEVE                                                                    |  |  |  |             |   |                              |  |                                                       |  |  |  |

| REVISIONS |             |      |          |
|-----------|-------------|------|----------|
| REV.      | DESCRIPTION | DATE | INITIALS |

| ITEM NO. | QTY. | PART NUMBER         | DESCRIPTION                  |
|----------|------|---------------------|------------------------------|
| 62       | 1    | MD-08-5353-00       | ERECTOR PULLEY               |
| 63       | 1    | MD-08-5358-00       | MAIN ERECTOR DRIVE PULLEY    |
| 64       | 1    | MD-08-5362-00       | TENSIONER PULLEY             |
| 65       | 1    | MD-08-5363-00       | ERECTOR BELT TENSIONER A     |
| 66       | 1    | MD-08-5364-00       | ERECTOR BELT JACK BLOCK A    |
| 67       | 1    | MD-08-5378-00       | TENSIONER PULLEY             |
| 68       | 1    | MD-08-5530-00       | ERECTOR BELT JACK BLOCK B    |
| 69       | 1    | MD-08-5532-00       | ERECTOR DRIVE PULLEY         |
| 70       | 2    | MD-08-5593-00       | THRUST HOUSING               |
| 71       | 1    | MD-08-5594-00       | GEAR COVER A                 |
| 72       | 1    | MD-08-5595-00       | GEAR COVER B                 |
| 73       | 1    | MD-08-5598-00       | LIFT SCREW DRIVE SHAFT A     |
| 74       | 1    | MD-08-5599-00       | LIFT SCREW DRIVE SHAFT B     |
| 75       | 1    | MD-08-5600-00 REV A | LOWER LIFT CROSSMEMBER       |
| 76       | 1    | MD-08-5601-00       | LOWER MAGAZINE LIFT SCREW A  |
| 77       | 1    | MD-08-5602-00       | LOWER MAGAZINE LIFT SCREW B  |
| 78       | 2    | MD-08-5603-00 REV A | OVERHEAD RAIL                |
| 79       | 1    | MD-08-5611-00       | SHAFT SUPPORT ANGLE          |
| 80       | 1    | MD-08-5612-00       | SHAFT SUPPORT ANGLE A        |
| 81       | 1    | MD-08-5613-00 REV A | SHAFT SUPPORT BLOCK          |
| 82       | 1    | MD-08-5614-00 REV A | SHAFT SUPPORT BLOCK A        |
| 83       | 1    | MD-08-5615-00       | UPPER CROSSMEMBER            |
| 84       | 1    | MD-08-5616-00       | UPPER LIFT CROSSMEMBER       |
| 85       | 1    | MD-08-5617-00       | UPPER LIFT SCREW A           |
| 86       | 2    | MD-08-5824-00       | POSITION RULE                |
| 87       | 2    | MD-08-5864-00       | PRE-BREAK VACUUM ARM MOUNT   |
| 88       | 2    | MD-08-5865-00       | PRE-BREAK ARM PLATE          |
| 89       | 3    | MD-08-5923-00       | CHAIN TENSIONER A            |
| 90       | 1    | MD-08-5988-00       | CROSSBAR, ERECTOR FRAME      |
| 91       | 1    | MD-08-6294-00       | ROTARY DRIVE SHAFT           |
| 92       | 1    | MD-08-6295-00       | ERECTOR BELT TENSIONER B     |
| 93       | 1    | MD-08-6296-00       | ROTARY MOUNT PLATE           |
| 94       | 2    | MD-08-6297-00       | ERECTOR SIDE BRACE           |
| 95       | 2    | MD-08-6298-00       | OVERHEAD ERECTOR RAIL MOUNT  |
| 96       | 1    | MD-08-6299-00       | ERECTOR SERVO MOUNT PLATE    |
| 97       | 1    | MD-08-6300-00       | LIFT BAR                     |
| 98       | 2    | MD-08-6301-00       | PRE-BREAK CROSSMEMBER        |
| 99       | 1    | MD-08-6302-00       | PRE-BREAK CROSSMEMBER        |
| 100      | 1    | MD-08-6303-00       | PRE-BREAK CROSSMEMBER        |
| 101      | 1    | MD-08-6304-00       | PRE-BREAK CROSSMEMBER        |
| 102      | 1    | MD-08-6305-00       | ROTARY GUARD WINDOW          |
| 103      | 2    | MD-08-6306-00       | ROTARY LIFT PLATE            |
| 104      | 1    | MD-08-6307-00       | VACUUM PUMP MOUNT PLATE      |
| 105      | 1    | MD-08-6308-00       | ROTARY FRAME A               |
| 106      | 1    | MD-08-6309-00       | ROTARY FRAME B               |
| 107      | 1    | MD-08-6310-00       | ERECTOR STIFFENER            |
| 108      | 4    | MD-08-6311-00       | ERECTOR STIFFENER            |
| 109      | 1    | MD-08-6312-00       | LIFT BAR                     |
| 110      | 2    | MD-08-6313-00       | LIFT BAR                     |
| 111      | 1    | MD-08-6318-00       | ERECTOR GUSSET               |
| 112      | 1    | MD-08-6319-00       | SEC. LOWER LIFT CROSSMEMBER  |
| 113      | 1    | MD-09-5365-00       | UPPER LIFT SCREW - SECONDARY |
| 114      | 2    | MD-09-6150-00       | BEARING COVER                |
| 115      | 1    | MD-09-7086-00       | MAIN MAGAZINE UPRIGHT        |
| 116      | 1    | MD-09-7087-00       | MAIN MAGAZINE UPRIGHT        |
| 117      | 1    | MD-09-7088-00       | MAIN MAGAZINE UPRIGHT        |
| 118      | 2    | MD-10-0764-00       | OVERHEAD RAIL SLIDE          |
| 119      | 2    | MD-10-0857-01 REV B | MOUNT CLAMP                  |
| 120      | 4    | MD-13-0180-02       | ROTARY HINGE SPACER          |
| 121      | 4    | MD-13-5650-00       | HINGE NUT BAR                |
| 122      | 2    | MD-13-7431-00       | DOOR SENSOR NUT PLATE        |
| 123      | 1    | MD-13-7504-00       | ROTARY DOOR                  |
| 124      | 1    | MD-13-7505-00       | ROTARY DOOR- RH              |

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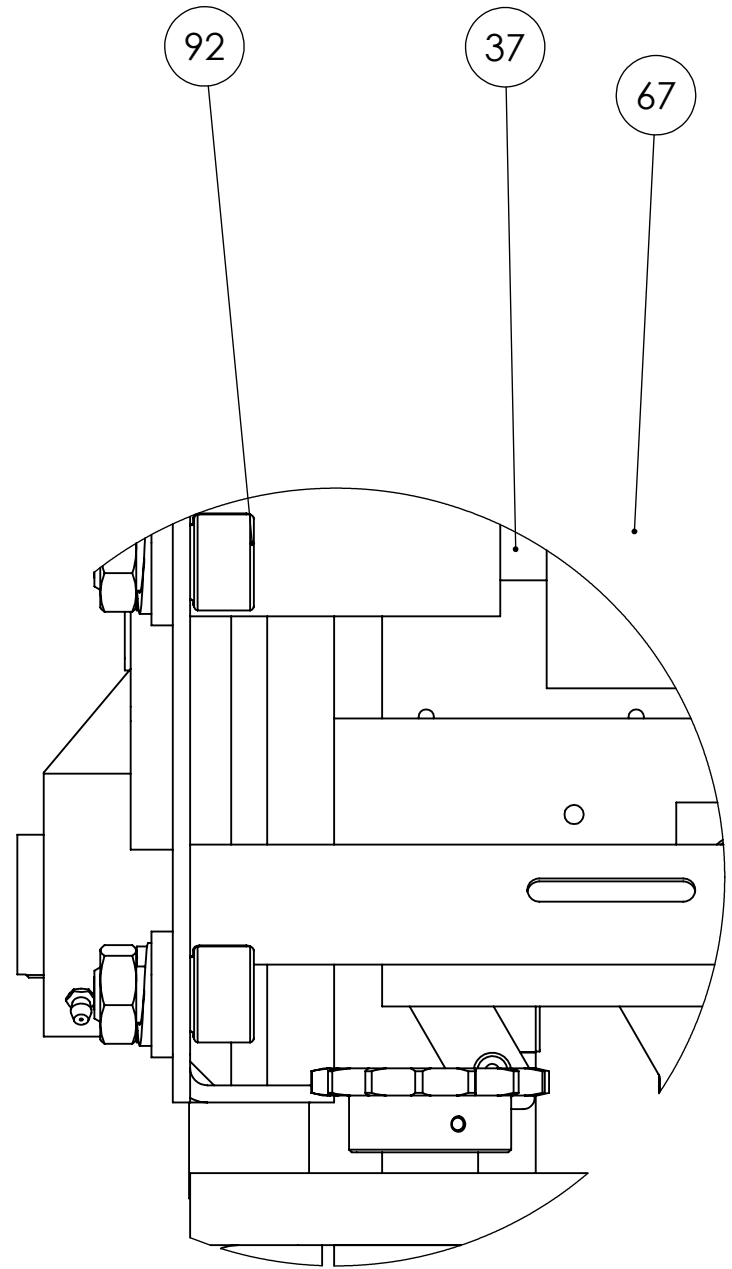
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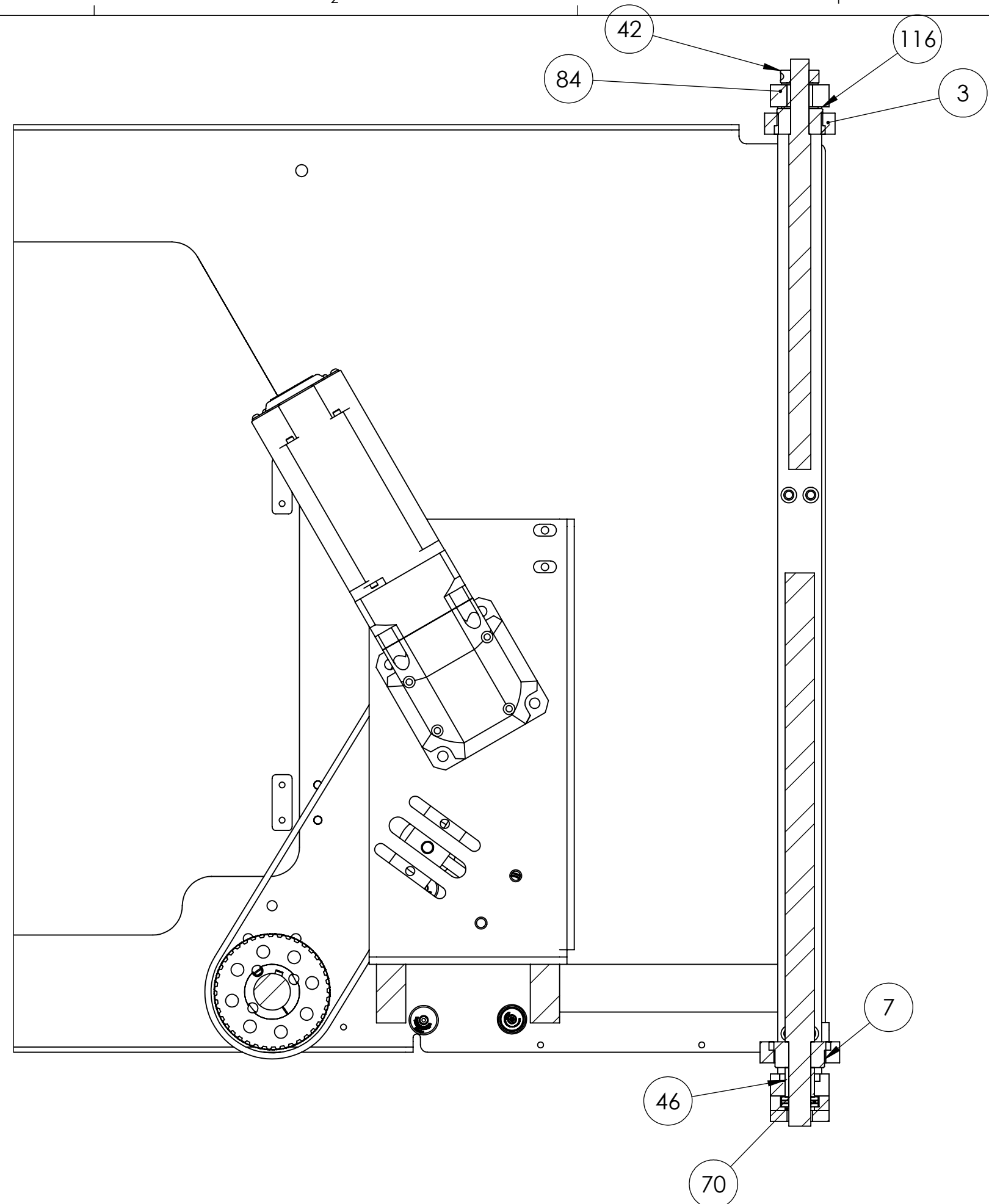
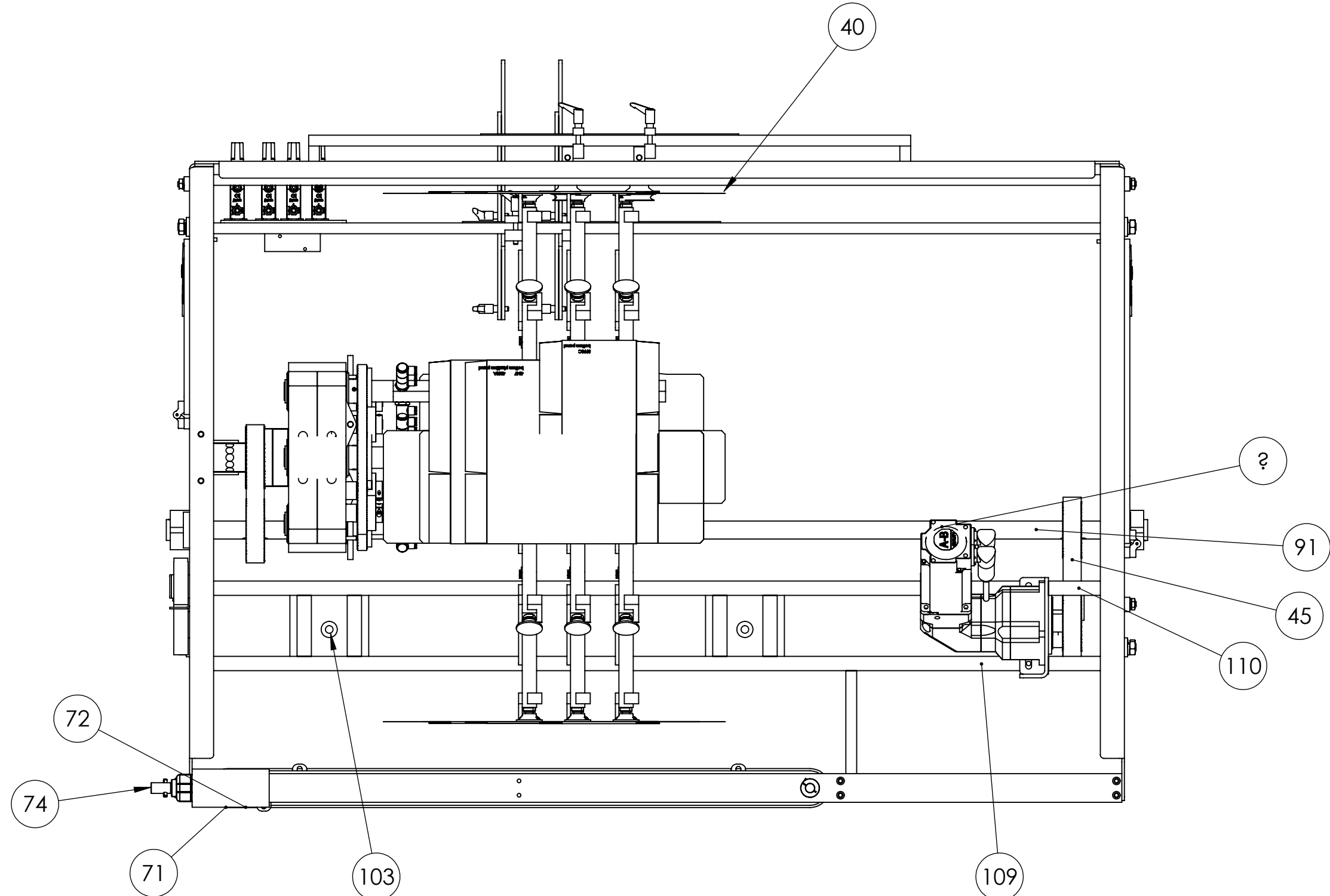
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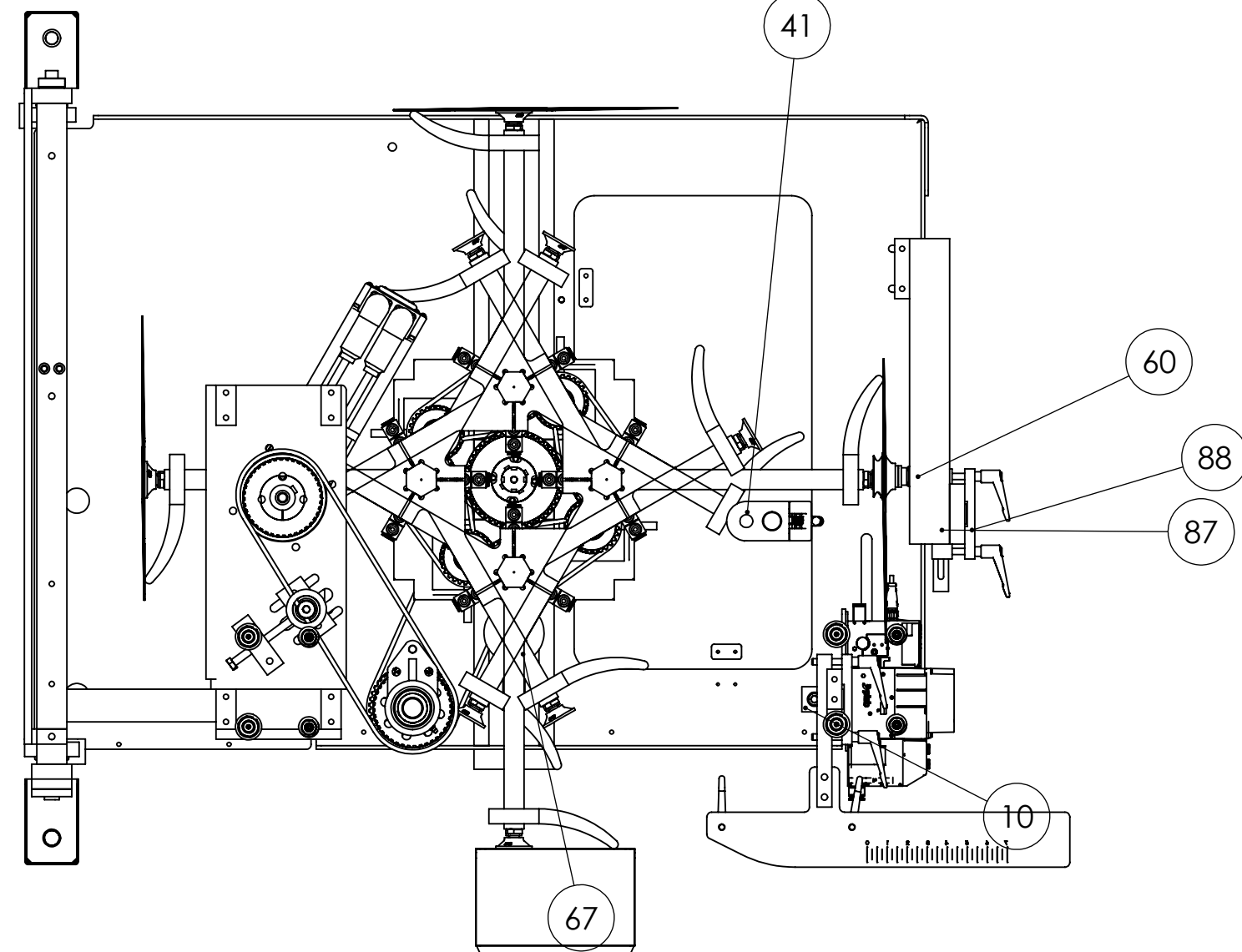
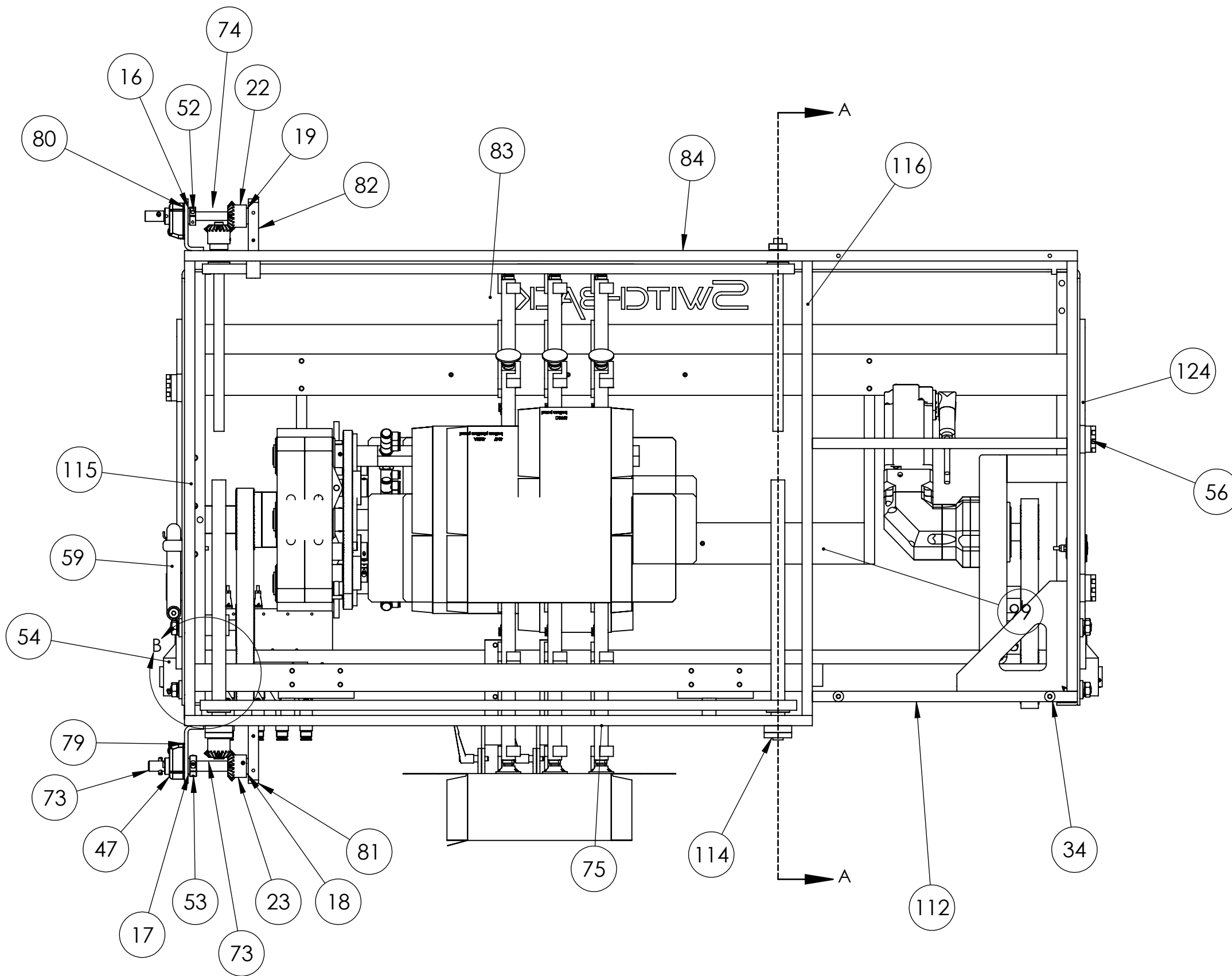
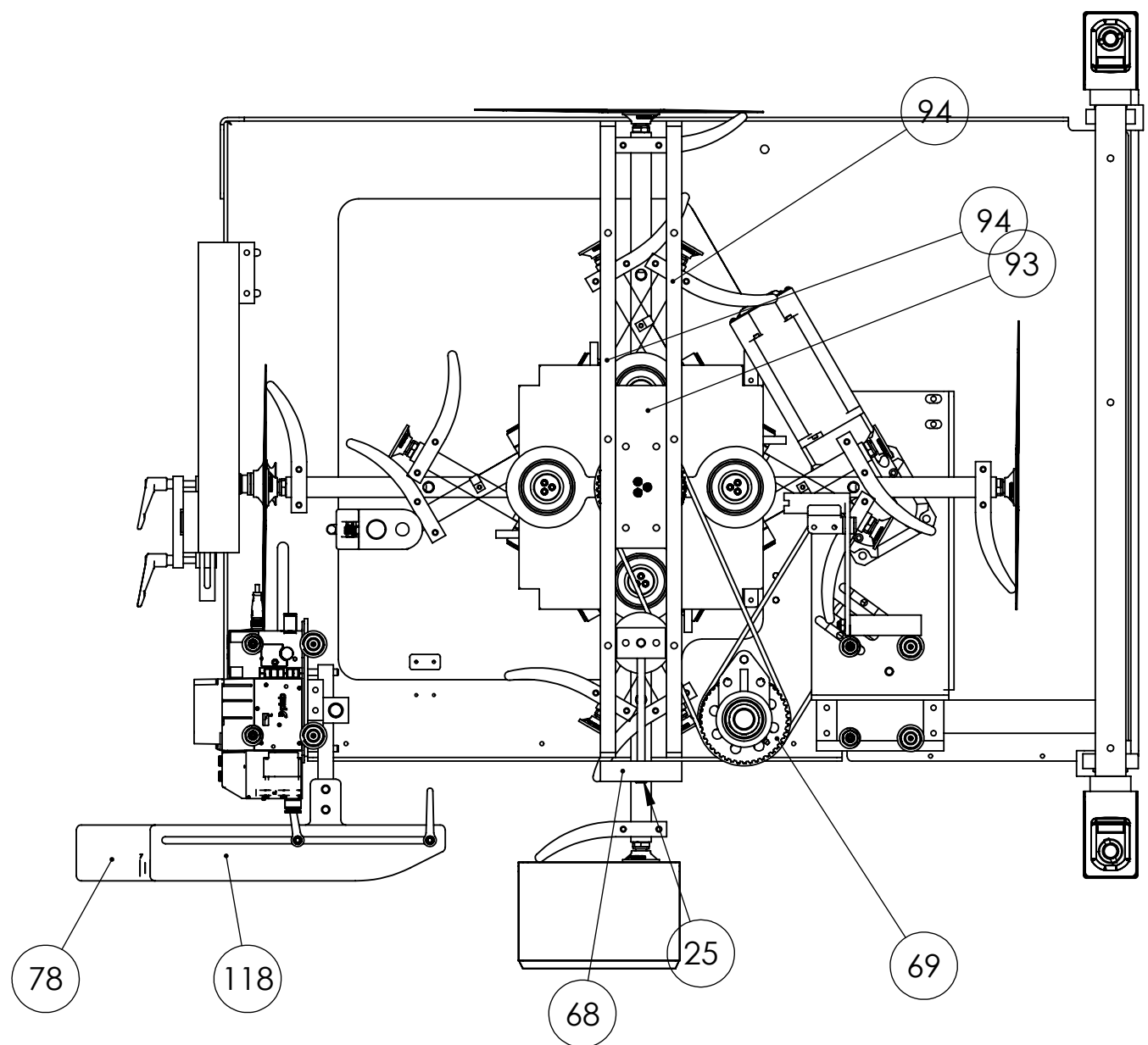
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DETAIL B  
SCALE 1:2



SECTION A-A  
SCALE 1:4



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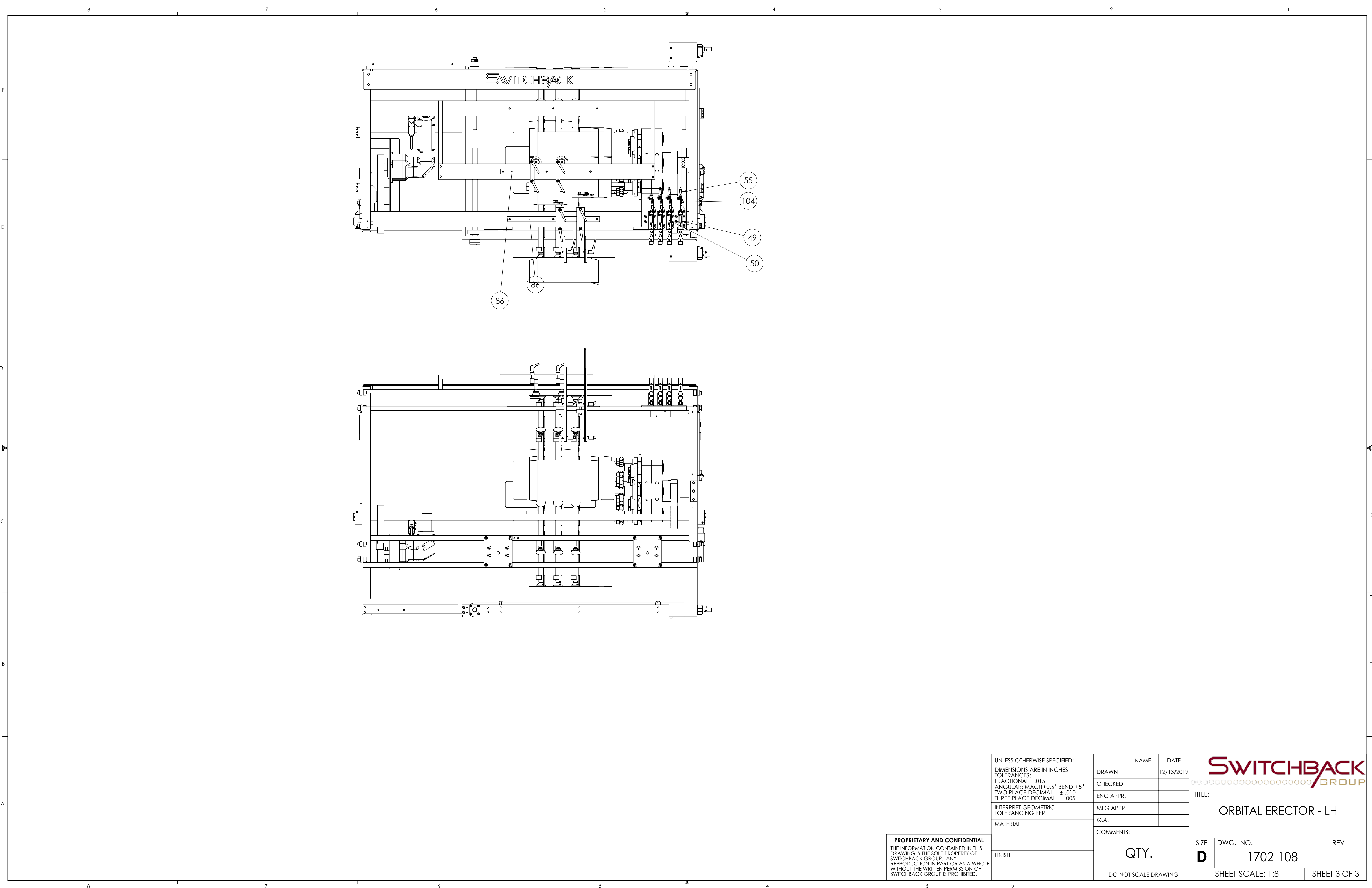
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| UNLESS OTHERWISE SPECIFIED:             | NAME      | DATE       |
| DIMENSIONS ARE IN INCHES                |           |            |
| TOLERANCES:                             |           |            |
| FRACTIONAL ± .015                       | DRAWN     | 12/13/2019 |
| ANGULAR: MACH ± 0.5° BEND ± 5°          | CHECKED   |            |
| TWO PLACE DECIMAL ± .010                | ENG APPR. |            |
| THREE PLACE DECIMAL ± .005              | MFG APPR. |            |
| INTERPRET GEOMETRIC<br>TOLERANCING PER: | Q.A.      |            |
| MATERIAL                                | COMMENTS: |            |

FINISH

QTY.

DO NOT SCALE DRAWING

|                                |                      |              |
|--------------------------------|----------------------|--------------|
| <b>SWITCHBACK GROUP</b>        |                      |              |
| TITLE:<br>ORBITAL ERECTOR - LH |                      |              |
| SIZE<br><b>D</b>               | DWG. NO.<br>1702-108 | REV          |
| SHEET SCALE: 1:8               |                      | SHEET 2 OF 3 |



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|-------------------------------------------------------------------------------------------------------------|----------------------|------|------------|
| UNLESS OTHERWISE SPECIFIED:                                                                                 |                      | NAME | DATE       |
| DIMENSIONS ARE IN INCHES<br>TOLERANCES:                                                                     | DRAWN                |      | 12/13/2019 |
| FRACTIONAL ± .015<br>ANGULAR: MACH±0.5° BEND ± 5°<br>TWO PLACE DECIMAL ± .010<br>THREE PLACE DECIMAL ± .005 | CHECKED              |      |            |
|                                                                                                             | ENG APPR.            |      |            |
| INTERPRET GEOMETRIC<br>TOLERANCING PER:                                                                     | MFG APPR.            |      |            |
|                                                                                                             | Q.A.                 |      |            |
| MATERIAL                                                                                                    | COMMENTS:            |      |            |
|                                                                                                             | QTY.                 |      |            |
| FINISH                                                                                                      |                      |      |            |
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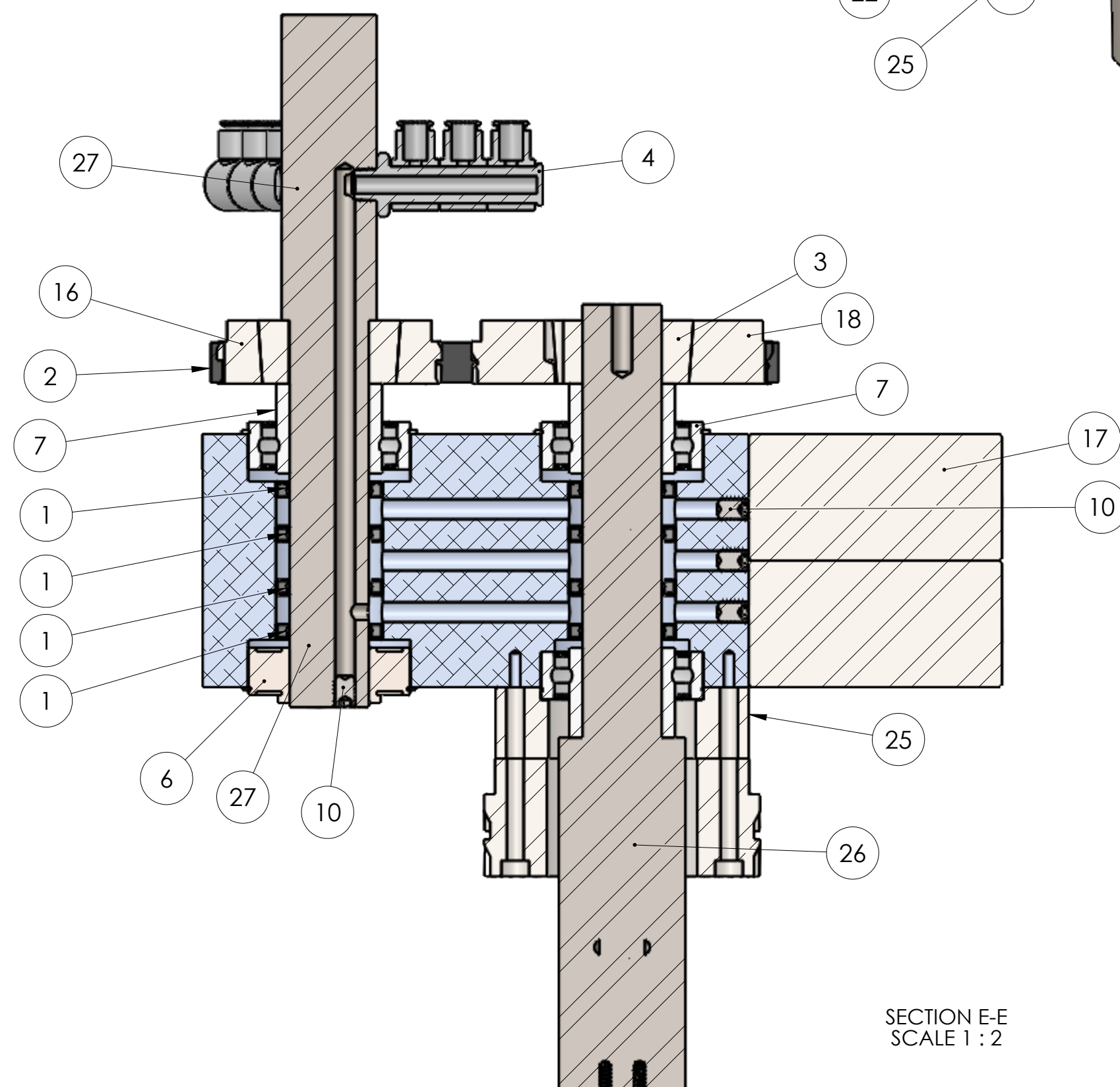
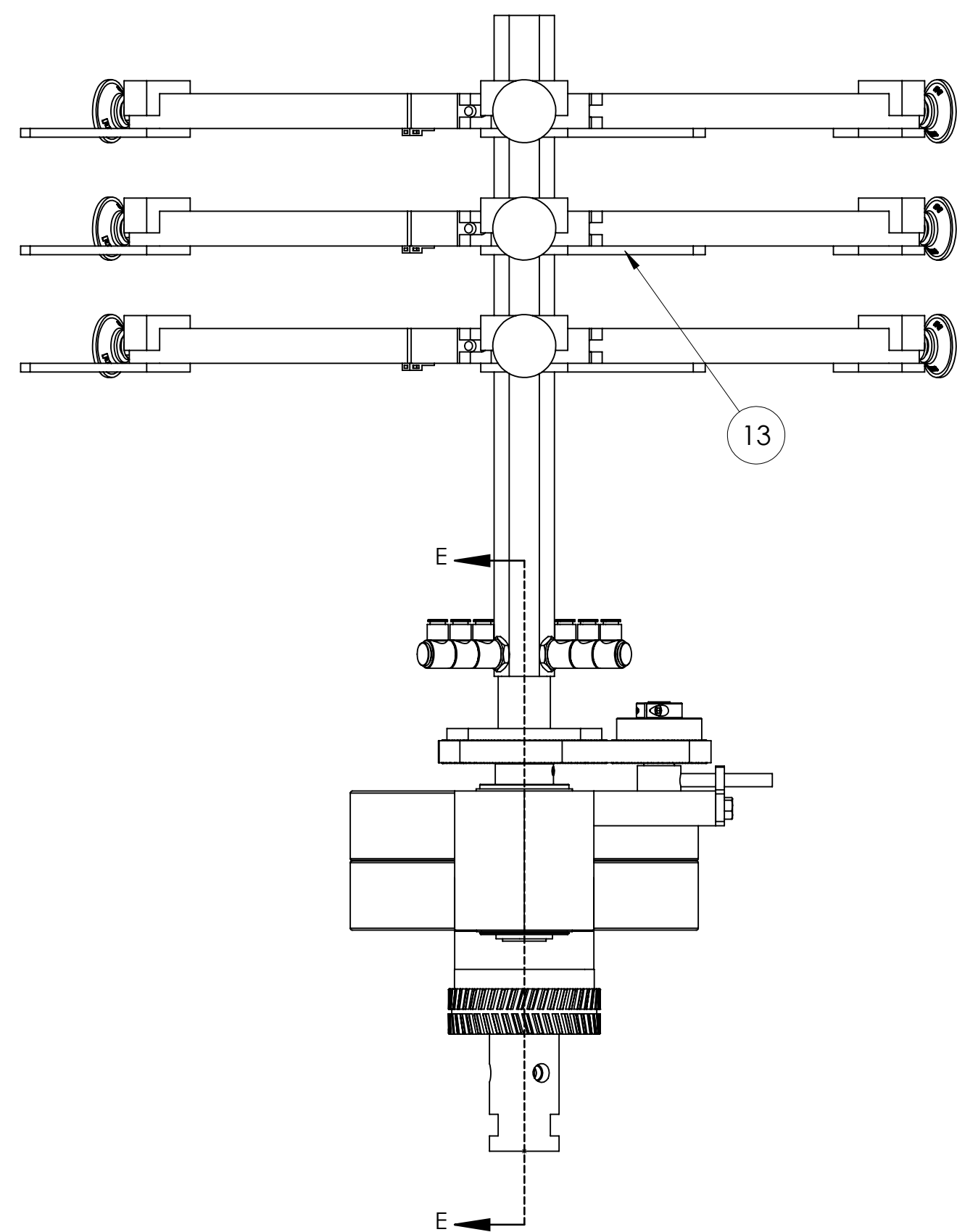
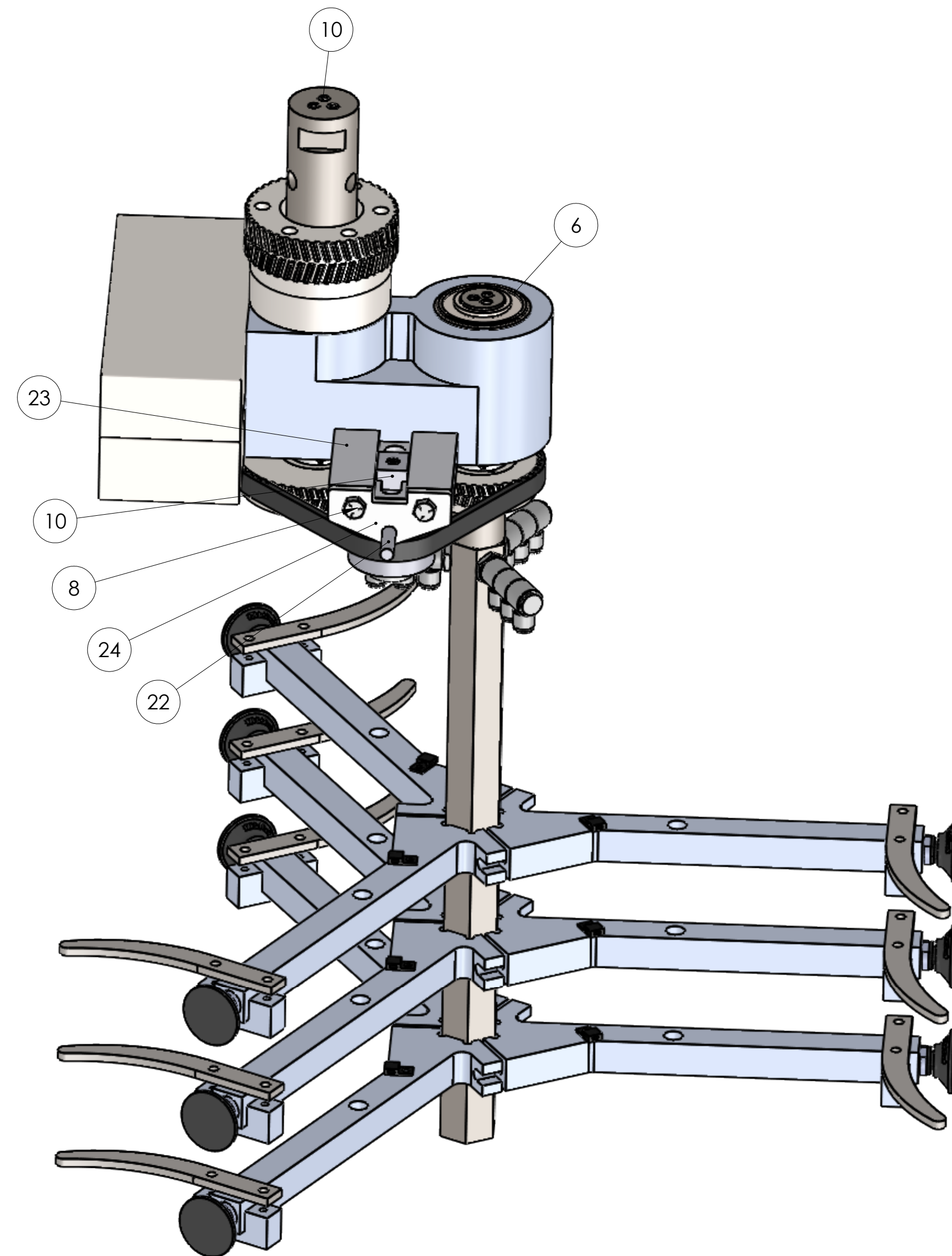
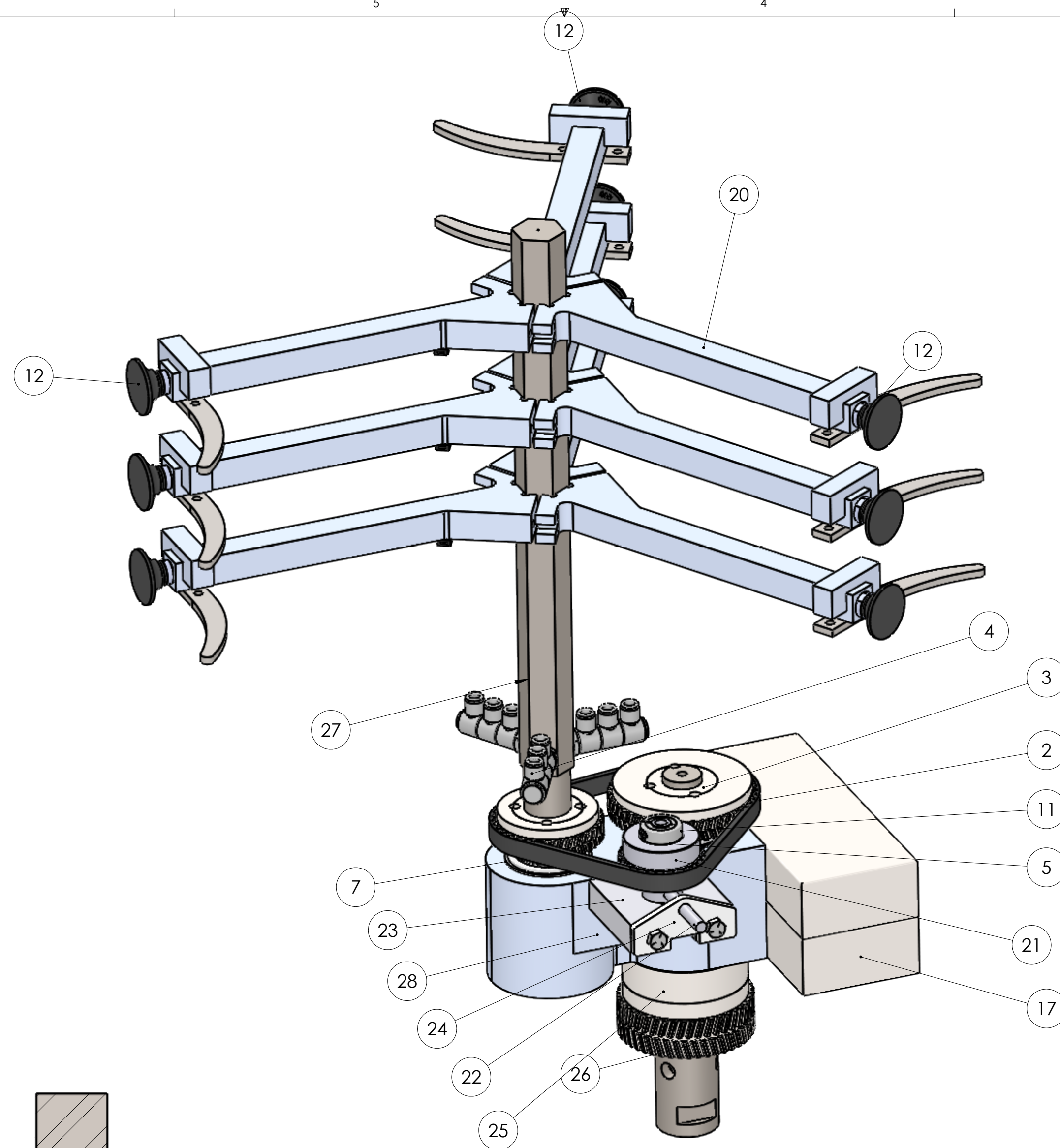
TITLE:

ORBITAL ERECTOR - LH

|                  |          |              |
|------------------|----------|--------------|
| SIZE             | DWG. NO. | REV          |
| <b>D</b>         | 1702-108 |              |
| SHEET SCALE: 1:8 |          | SHEET 3 OF 3 |

| 8        |     |                      | 7                                                         |
|----------|-----|----------------------|-----------------------------------------------------------|
| ITEM NO. | QTY | PART NUMBER          | DESCRIPTION                                               |
| 1        | 8   | 12337                | RADIAL SHAFT SEAL, 1.25" BORE, 1.687" OD                  |
| 2        | 1   | 1564-108 TIMING BELT | ERECTOR DRIVE BELT                                        |
| 3        | 2   | 1610 x 1.250         | TAPER LOCK BUSHING, 1610, 1-1/4" BORE                     |
| 4        | 3   | 5203K867             | PUSH-TO-CONNECT MANIFOLD, 1/4 NPT INLET, 3X Ø3/8" OUTLET  |
| 5        | 2   | 60355K705            | BALL BEARING, 5/8" BORE                                   |
| 6        | 1   | 7520 DLG             | BALL BEARING, 1.25 ID w/SNAP RING                         |
| 7        | 3   | 7620 DLG             | RADIAL BEARING, w/EXT. INNER RING, 1.250 ID               |
| 8        | 2   | 91247A642            | HEX HEAD SCREW - 4 1/2" LG., GRADE 5                      |
| 10       | 9   | 92311A619            | SET SCREW, 25/PACK                                        |
| 10       | 1   | 94750A595            | TEE SLOT NUT - 3/8-16                                     |
| 11       | 1   | 9961K19              | SHAFT COLLAR - 5/8" BORE                                  |
| 12       | 9   | B40.10.04AB          | Suction cup B40 Chloroprene, G1/4" male, with mesh filter |
| 13       | 8   | 7582K65              | CABLE TIE HOLDER                                          |
| 14       | 9   | MD-08-0135-03        | CARTON FORK                                               |
| 15       | 9   | MD-08-0136-02        | CARTON FORK MOUNT                                         |
| 16       | 1   | MD-08-5428-00        | PICK ARM PULLEY                                           |
| 17       | 2   | MD-08-5431-00        | ROTARY COUNTER WEIGHT                                     |
| 18       | 1   | MD-08-5434-00        | TIMING PULLEY, 8mm PITCH                                  |
| 19       | 1   | MD-08-5543-00        | ERECTOR DRIVEN PULLEY                                     |
| 20       | 9   | MD-08-5960-00        | PICK ARM                                                  |
| 21       | 1   | MD-08-5964-00        | MODIFIED TIMING PULLEY                                    |
| 22       | 1   | MD-08-5965-00        | IDLER PULLEY MOUNT                                        |
| 23       | 1   | MD-08-5966-00        | TENSIONER BLOCK                                           |
| 24       | 1   | MD-08-5972-00        | TENSIONER PLATE                                           |
| 25       | 1   | MD-08-6314-00        | ROTARY BLOCK SPROCKET SPACER                              |
| 26       | 1   | MD-08-6315-00        | ROTARY SPINDLE                                            |
| 27       | 1   | MD-08-6316-00        | ROTARY PICK ARM SHAFT                                     |
| 28       | 1   | MD-08-6317-00        | ROTARY BLOCK                                              |

| REVISIONS |             |      |          |
|-----------|-------------|------|----------|
| REV.      | DESCRIPTION | DATE | INITIALS |



SECTION E-E  
SCALE 1 : 2

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|----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|------------------------------|------|-----------|
| UNLESS OTHERWISE SPECIFIED:                                                                                                                                                            |                              | NAME | DATE      |
| DIMENSIONS ARE IN INCHES<br>TOLERANCES:<br>FRACTIONAL $\pm .015$<br>ANGULAR: MACH $\pm 0.5^\circ$ BEND $\pm 5^\circ$<br>TWO PLACE DECIMAL $\pm .010$<br>THREE PLACE DECIMAL $\pm .005$ | DRAWN                        | RB   | 8/21/2020 |
|                                                                                                                                                                                        | DESIGNER                     |      |           |
|                                                                                                                                                                                        | ENG APPR.                    |      |           |
| INTERPRET GEOMETRIC<br>TOLERANCING PER:                                                                                                                                                | MFG APPR.                    |      |           |
| MATERIAL                                                                                                                                                                               | COMMERCIAL PART              |      |           |
| FINISH                                                                                                                                                                                 | EST. WEIGHT (lbs):<br>108.44 |      |           |
|                                                                                                                                                                                        | DO NOT SCALE DRAWING         |      |           |



SWITCHBACK GROUP

TITLE: 3-HEAD ROTARY ERECTOR

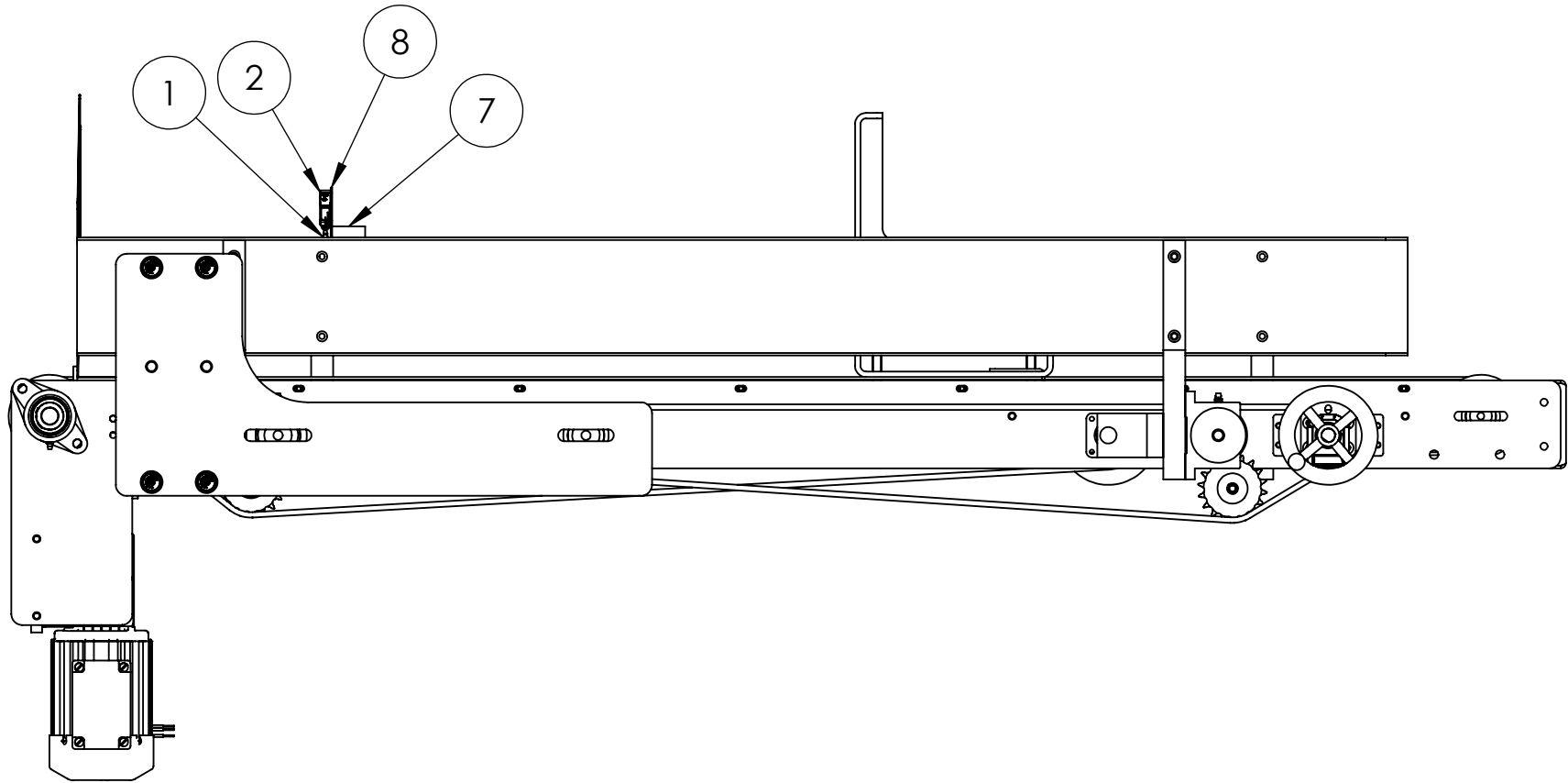
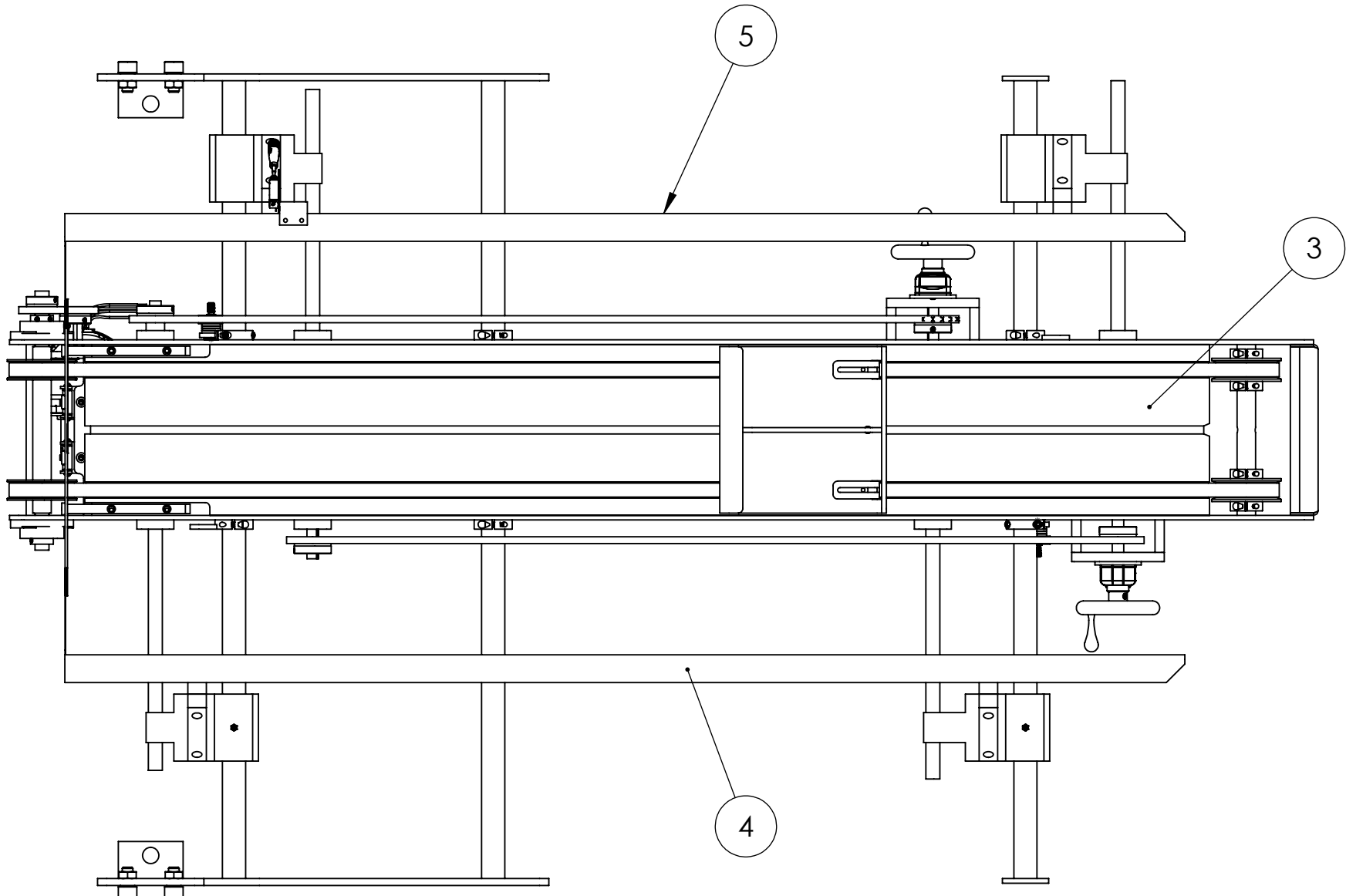
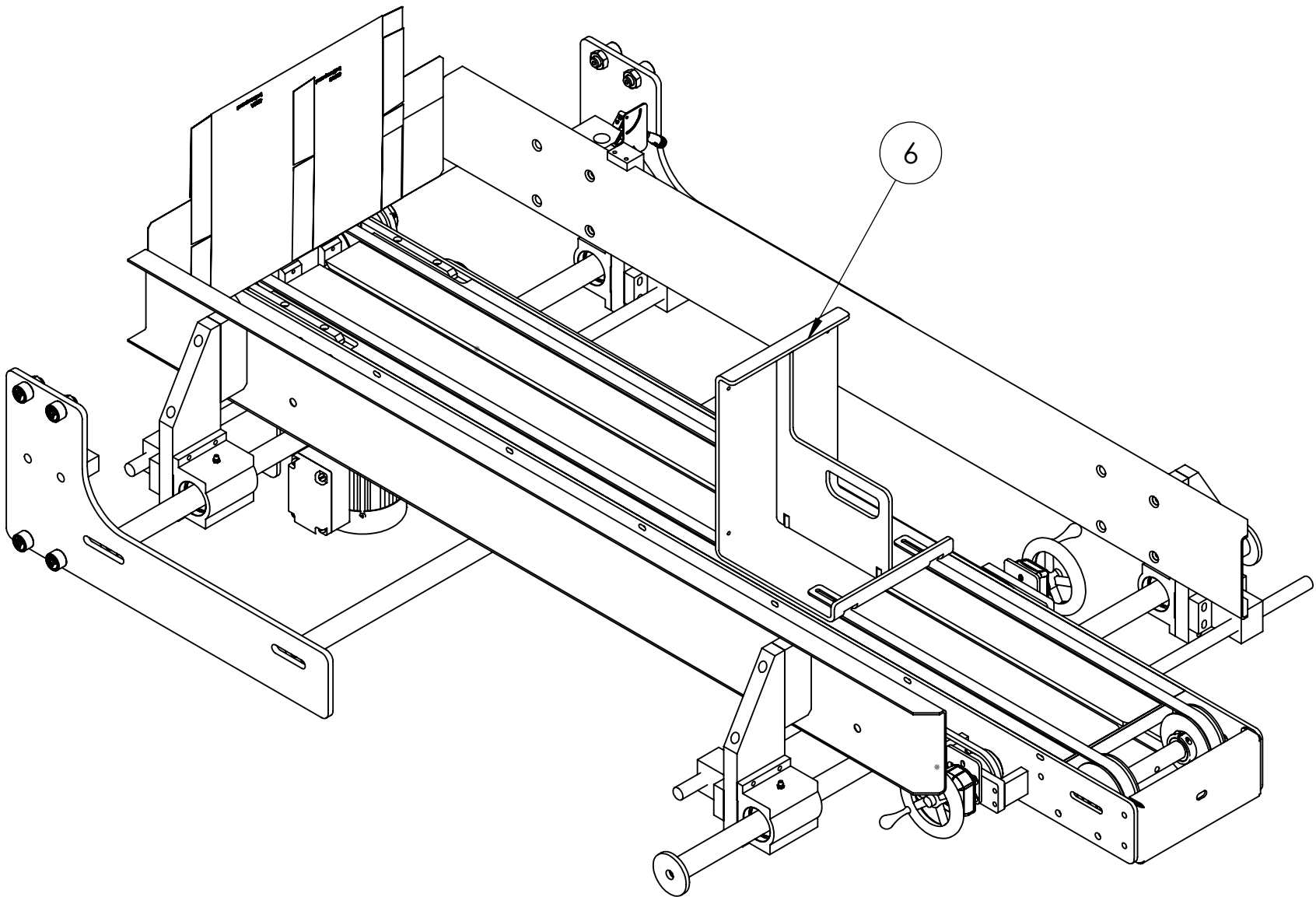
|          |           |     |
|----------|-----------|-----|
| SIZE     | DWG. NO.  | REV |
| <b>D</b> | 1702-108C |     |

SHEET SCALE: 1:3

SHEET 1 OF 1

| ITEM NO. | QTY. | PART NUMBER      | DESCRIPTION                                |
|----------|------|------------------|--------------------------------------------|
| 1        | 1    | V1-G-BK10M-PVC-U | M12 CABLE, STRAIGHT, 10M LG, 4-PIN         |
| 2        | 1    | WTB9-3P3461      | PHOTOELECTRIC PROXIMITY SWITCH, 4 PIN, M12 |
| 3        | 1    | 1702-109B        | MAGAZINE CONVEYOR BED                      |
| 4        | 1    | 1702-109C        | MAGAZINE SIDE GUIDE, LH                    |
| 5        | 1    | 1702-109D        | MAGAZINE SIDE GUIDE, RH                    |
| 6        | 1    | 1702-109F        | PRESURE PLATE                              |
| 7        | 1    | MD-09-6785-00    | SENSOR CLAMP                               |
| 8        | 1    | MD-09-6786-00    | PE SENSOR MOUNT                            |

| REVISIONS |             |      |          |
|-----------|-------------|------|----------|
| REV.      | DESCRIPTION | DATE | INITIALS |



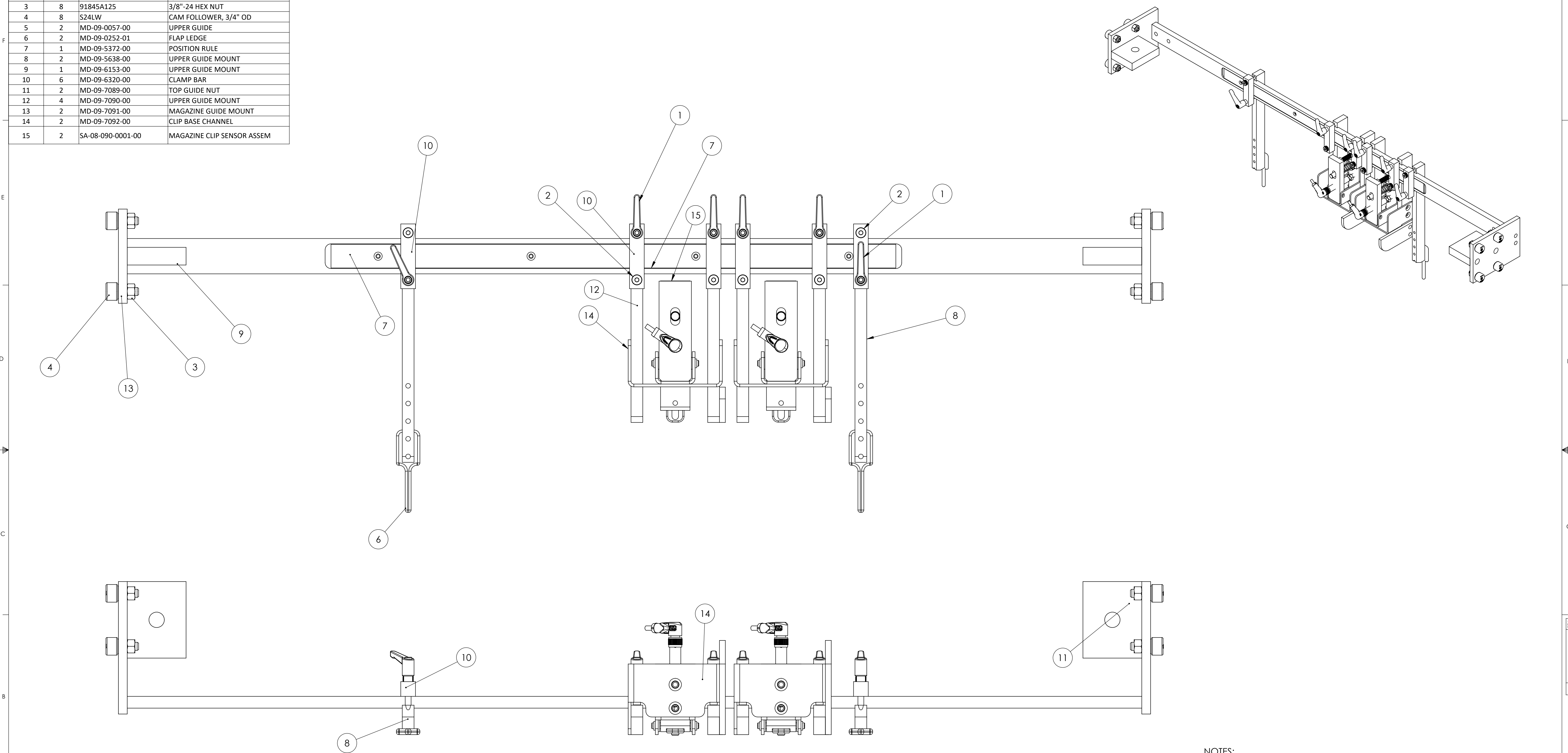
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| UNLESS OTHERWISE SPECIFIED:                                                                                                                              |                               | NAME | DATE      |
|----------------------------------------------------------------------------------------------------------------------------------------------------------|-------------------------------|------|-----------|
| DIMENSIONS ARE IN INCHES<br>TOLERANCES:<br>FRACTIONAL ± .015<br>ANGULAR: MACH ± 0.5° BEND ± 5°<br>TWO PLACE DECIMAL ± .010<br>THREE PLACE DECIMAL ± .005 | DRAWN                         | RB   | 8/21/2020 |
|                                                                                                                                                          | DESIGNER                      |      |           |
|                                                                                                                                                          | ENG APPR.                     |      |           |
|                                                                                                                                                          | MFG APPR.                     |      |           |
| INTERPRET GEOMETRIC TOLERANCING PER:                                                                                                                     | Q.A.                          |      |           |
| MATERIAL                                                                                                                                                 | COMMERCIAL PART               |      |           |
| FINISH                                                                                                                                                   | EST. WEIGHT (lbs):<br>291.024 |      |           |
|                                                                                                                                                          | DO NOT SCALE DRAWING          |      |           |

|                             |                      |              |  |
|-----------------------------|----------------------|--------------|--|
| <b>SWITCHBACK GROUP</b>     |                      |              |  |
| TITLE:<br>MAGAZINE ASSEMBLY |                      |              |  |
| SIZE<br><b>D</b>            | DWG. NO.<br>1702-109 | REV          |  |
| SHEET SCALE: 1:8            |                      | SHEET 1 OF 1 |  |

| ITEM NO. | QTY | PART NUMBER       | DESCRIPTION                                         |
|----------|-----|-------------------|-----------------------------------------------------|
| 1        | 6   | 60655K572         | ADJ HANDLE, 1/4"-20 THRD, 1-9/16" LG, ORANGE HANDLE |
| 2        | 6   | 90298A583         | 5/16" DIA X 1" LG SHOULD SCREW, 1/4"-20 THRD        |
| 3        | 8   | 91845A125         | 3/8"-24 HEX NUT                                     |
| 4        | 8   | S24LW             | CAM FOLLOWER, 3/4" OD                               |
| 5        | 2   | MD-09-0057-00     | UPPER GUIDE                                         |
| 6        | 2   | MD-09-0252-01     | FLAP EDGE                                           |
| 7        | 1   | MD-09-5372-00     | POSITION RULE                                       |
| 8        | 2   | MD-09-5638-00     | UPPER GUIDE MOUNT                                   |
| 9        | 1   | MD-09-6153-00     | UPPER GUIDE MOUNT                                   |
| 10       | 6   | MD-09-6320-00     | CLAMP BAR                                           |
| 11       | 2   | MD-09-7089-00     | TOP GUIDE NUT                                       |
| 12       | 4   | MD-09-7090-00     | UPPER GUIDE MOUNT                                   |
| 13       | 2   | MD-09-7091-00     | MAGAZINE GUIDE MOUNT                                |
| 14       | 2   | MD-09-7092-00     | CLIP BASE CHANNEL                                   |
| 15       | 2   | SA-08-090-0001-00 | MAGAZINE CLIP SENSOR ASSEM                          |

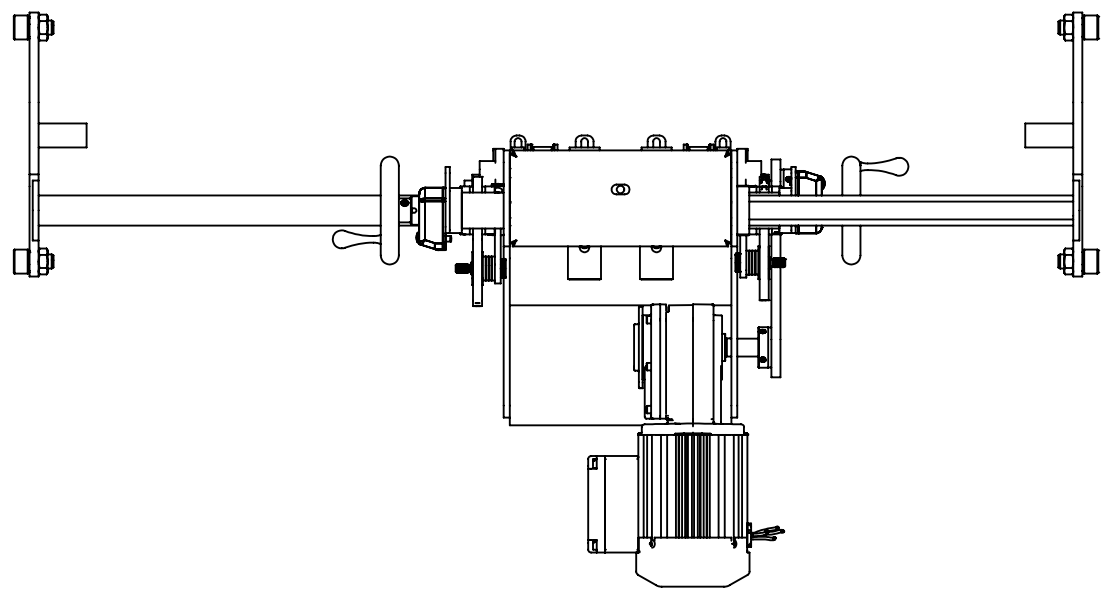
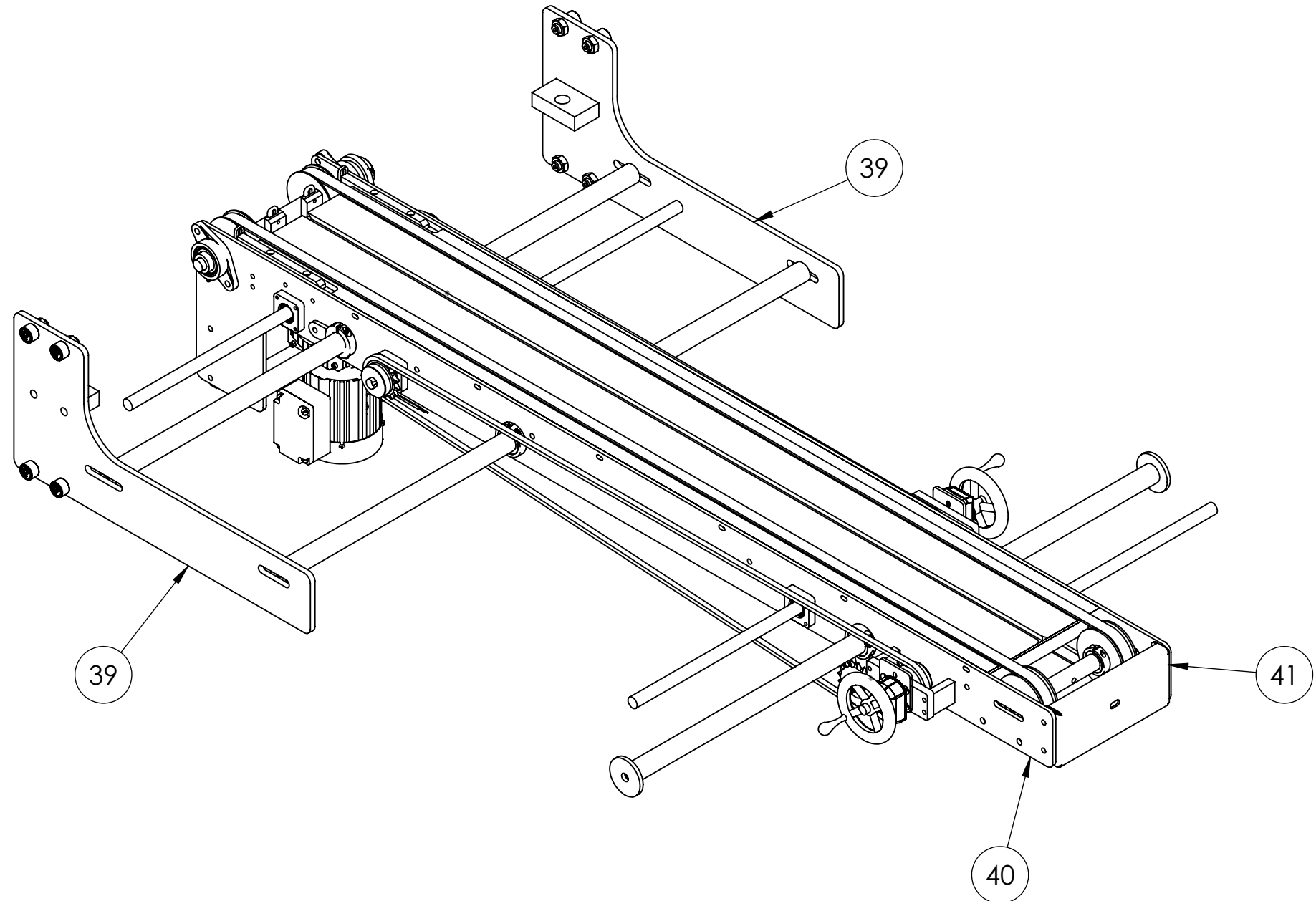
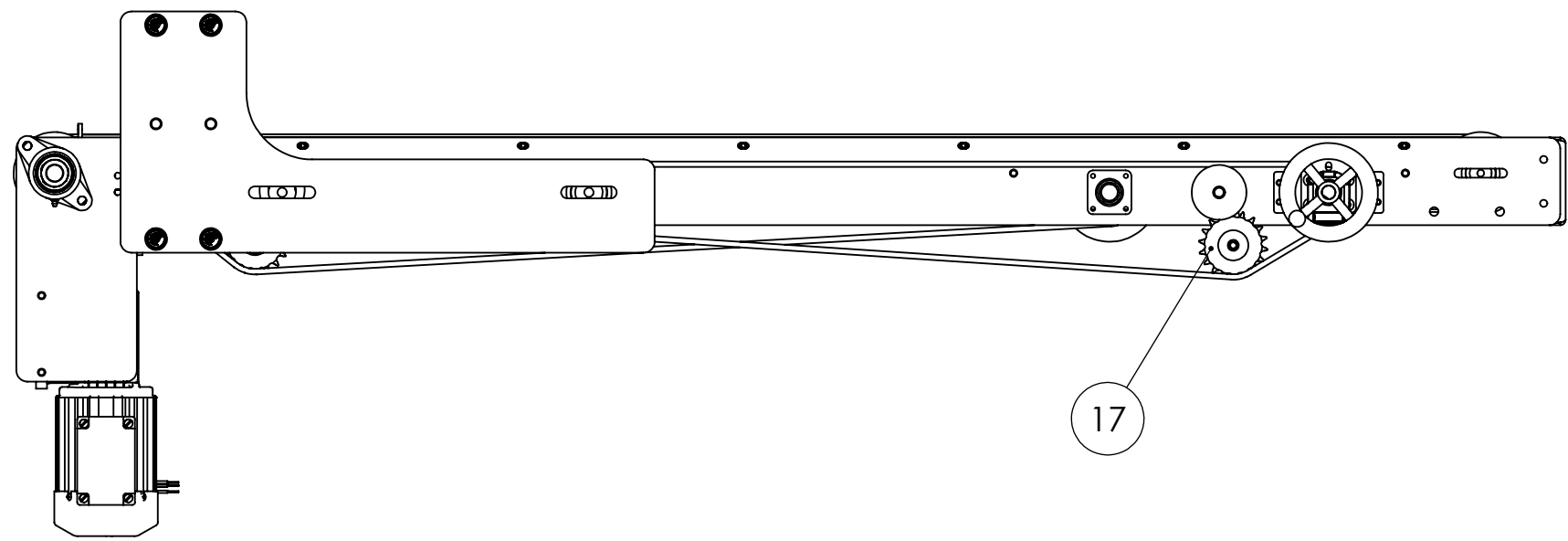
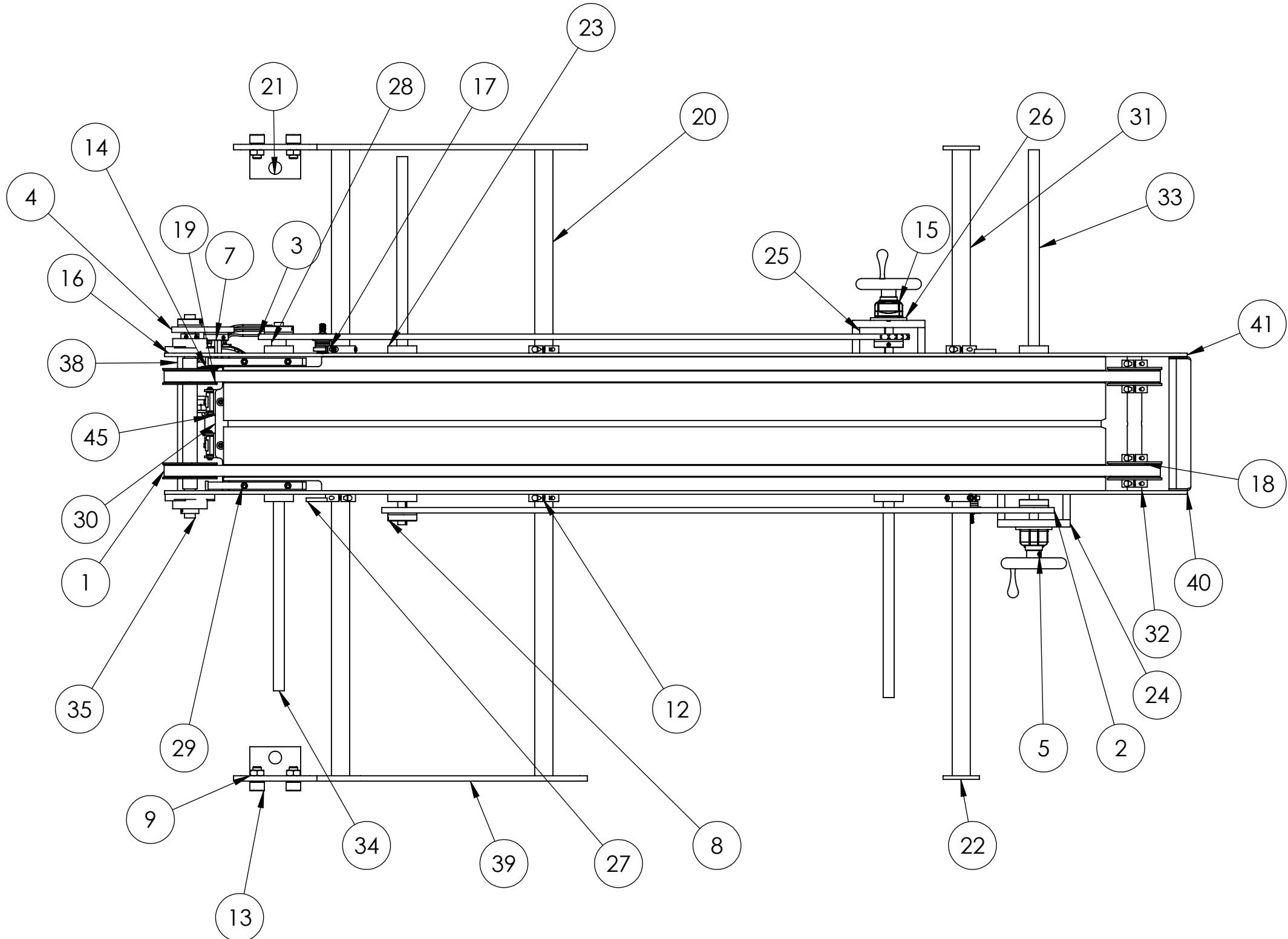
| REVISIONS |             |      |          |
|-----------|-------------|------|----------|
| REV.      | DESCRIPTION | DATE | INITIALS |



NOTES:  
1. USE STAINLESS STEEL HARDWARE UNLESS OTHERWISE SPECIFIED.

|                                                                                                                                                                                                                                                                    |                 |                             |           |                                                                                       |                                    |                  |                           |
|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-----------------|-----------------------------|-----------|---------------------------------------------------------------------------------------|------------------------------------|------------------|---------------------------|
| <p>UNLESS OTHERWISE SPECIFIED:</p> <p>DIMENSIONS ARE IN INCHES<br/>TOLERANCES:<br/>FRACTIONAL: .015<br/>ANGULAR: MACH±0.5° BEND ±5°<br/>TWO PLACE DECIMAL ±.010<br/>THREE PLACE DECIMAL ±.005</p> <p>INTERPRET GEOMETRIC<br/>TOLERANCING PER:</p> <p>MATERIAL</p>  |                 | NAME                        | DATE      |  |                                    |                  |                           |
|                                                                                                                                                                                                                                                                    |                 | DRAWN                       | RB        | 8/21/2020                                                                             | TITLE:<br><br>UPPER CARTON SUPPORT |                  |                           |
|                                                                                                                                                                                                                                                                    |                 | DESIGNER                    |           |                                                                                       |                                    |                  |                           |
|                                                                                                                                                                                                                                                                    |                 | ENG APPR.                   |           |                                                                                       |                                    |                  |                           |
|                                                                                                                                                                                                                                                                    |                 |                             | MFG APPR. |                                                                                       |                                    | SIZE<br><b>D</b> | DWG. NO.<br><br>1702-109A |
|                                                                                                                                                                                                                                                                    |                 | Q.A.                        |           |                                                                                       |                                    |                  |                           |
|                                                                                                                                                                                                                                                                    | COMMERCIAL PART |                             |           |                                                                                       |                                    |                  |                           |
| FINISH                                                                                                                                                                                                                                                             |                 | EST. WEIGHT (lbs):<br>17.32 |           | SHEET SCALE: 1:2                                                                      |                                    |                  |                           |
|                                                                                                                                                                                                                                                                    |                 | DO NOT SCALE DRAWING        |           |                                                                                       |                                    |                  |                           |
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| ITEM NO. |    | QTY.                      | PART NUMBER                                                  | DESCRIPTION |
|----------|----|---------------------------|--------------------------------------------------------------|-------------|
| 1        | 2  | 1564-109 belt             | PRODUCT ADVANCE BELT, H SERIES                               |             |
| 2        | 1  | 1702 - mag roller chain 2 | #40 ROLLER CHAIN - 96" LG., NICKEL PLATED                    |             |
| 3        | 1  | 1702 - mag roller chain   | #40 ROLLER CHAIN - 94" LG., NICKEL PLATED                    |             |
| 4        | 1  | 1702 MAG DRIVE CHAIN 2    | #40 ROLLER CHAIN - 21" LG., NICKEL PLATED                    |             |
| 5        | 2  | 6033K72                   | HAND WHEEL, 4-1/2" OD, 5/8" BORE, 5/16"-18 SET SCREW         |             |
| 6        | 8  | 60355K705                 | BALL BEARING, 5/8" BORE                                      |             |
| 7        | 2  | 6280K683                  | SPROCKET, 40B14, .75 FINISHED BORE                           |             |
| 8        | 4  | 6280K701                  | #40 SPROCKET - 16 TOOTH                                      |             |
| 9        | 8  | 94846A535                 | 5/8"-18 RH THRD JAM NUT, GR. 5                               |             |
| 10       | 12 | 99362A700                 | THREADED INSERT, 1/4-20 THD., .484" LG. (.339 MAX PRE-DRILL) |             |
| 11       | 4  | 9961K26                   | SHAFT COLLAR, 1-PC CLAMP ON, 1" BORE                         |             |
| 12       | 2  | 9961K31                   | SHAFT COLLAR, 1-1/4" 1-PC                                    |             |
| 13       | 8  | H32LW                     | CAM FOLLOWER, 1" OD, HEAVY STUD                              |             |
| 14       | 1  | N2636+0951+0917+0984-RH   | GEARMOTOR ASSEMBLY W/SHAFT AND COVER                         |             |
| 15       | 2  | OP7-D-10-DX-F3_4-R-D5_8   | POSITION INDICATOR                                           |             |
| 16       | 2  | UCFL 204-12               | FLANGE BEARING, 3/4" BORE                                    |             |
| 17       | 2  | 1702-109J                 | CHAIN TENSIONER                                              |             |
| 18       | 2  | MD-09-0018-02             | MAGAZINE DRIVEN PULLEY                                       |             |
| 19       | 2  | MD-09-0019-02             | MAGAZINE DRIVE PULLEY                                        |             |
| 20       | 2  | MD-09-6125-00             | MAIN CROSS SHAFT                                             |             |
| 21       | 2  | MD-09-6132-00             | MAIN LIFT NUT                                                |             |
| 22       | 2  | MD-09-6590-00             | SPACER                                                       |             |
| 23       | 6  | MD-09-6604-00             | BEARING BLOCK                                                |             |
| 24       | 2  | MD-09-6605-01             | BEARING BLOCK                                                |             |
| 25       | 4  | MD-09-6606-00             | BEARING MOUNT SPACER                                         |             |
| 26       | 2  | MD-09-6607-00             | INDICATOR MOUNT PLATE                                        |             |
| 27       | 2  | MD-09-6608-00             | ANTI-ROTATION COLLAR                                         |             |
| 28       | 1  | MD-09-6613-00             | SPACER                                                       |             |
| 29       | 2  | MD-09-7093-00             | BOTTOM CARTON GUIDE                                          |             |
| 30       | 1  | MD-09-7094-00             | CLIP BASE CHANNEL                                            |             |
| 31       | 1  | MD-09-7096-00             | VERTICAL SUPPORT                                             |             |
| 32       | 1  | MD-09-7097-00             | MAGAZINE IDLER SHAFT                                         |             |
| 33       | 2  | MD-09-7098-00             | SIDE GUIDE ADJ SCREW                                         |             |
| 34       | 2  | MD-09-7099-00             | SIDE GUIDE ADJ SCREW                                         |             |
| 35       | 1  | MD-09-7100-00             | MAGAZINE DRIVE SHAFT                                         |             |
| 36       | 4  | MD-09-7101-00             | BED SUPPORT BAR                                              |             |
| 37       | 4  | MD-09-7102-00             | BED SPACER                                                   |             |
| 38       | 1  | MD-09-7103-00             | MOTOR MOUNT PLATE                                            |             |
| 39       | 2  | MD-09-7104-00             | MAGAZINE SIDE MOUNT PLATE                                    |             |
| 40       | 1  | MD-09-7105-00             | MAGAZINE SIDE PANEL B                                        |             |
| 41       | 1  | MD-09-7106-00             | MAGAZINE SIDE PANEL A                                        |             |
| 42       | 1  | MD-09-7107-00             | MAGAZINE DECK                                                |             |
| 43       | 2  | MD-09-7112-00             | MAGAZINE SUPPORT BAR                                         |             |
| 44       | 1  | MD-09-7158-00             | MAGAZINE END CAP                                             |             |
| 45       | 2  | SA-08-090-0001-00         | MAGAZINE CLIP SENSOR ASSEM                                   |             |



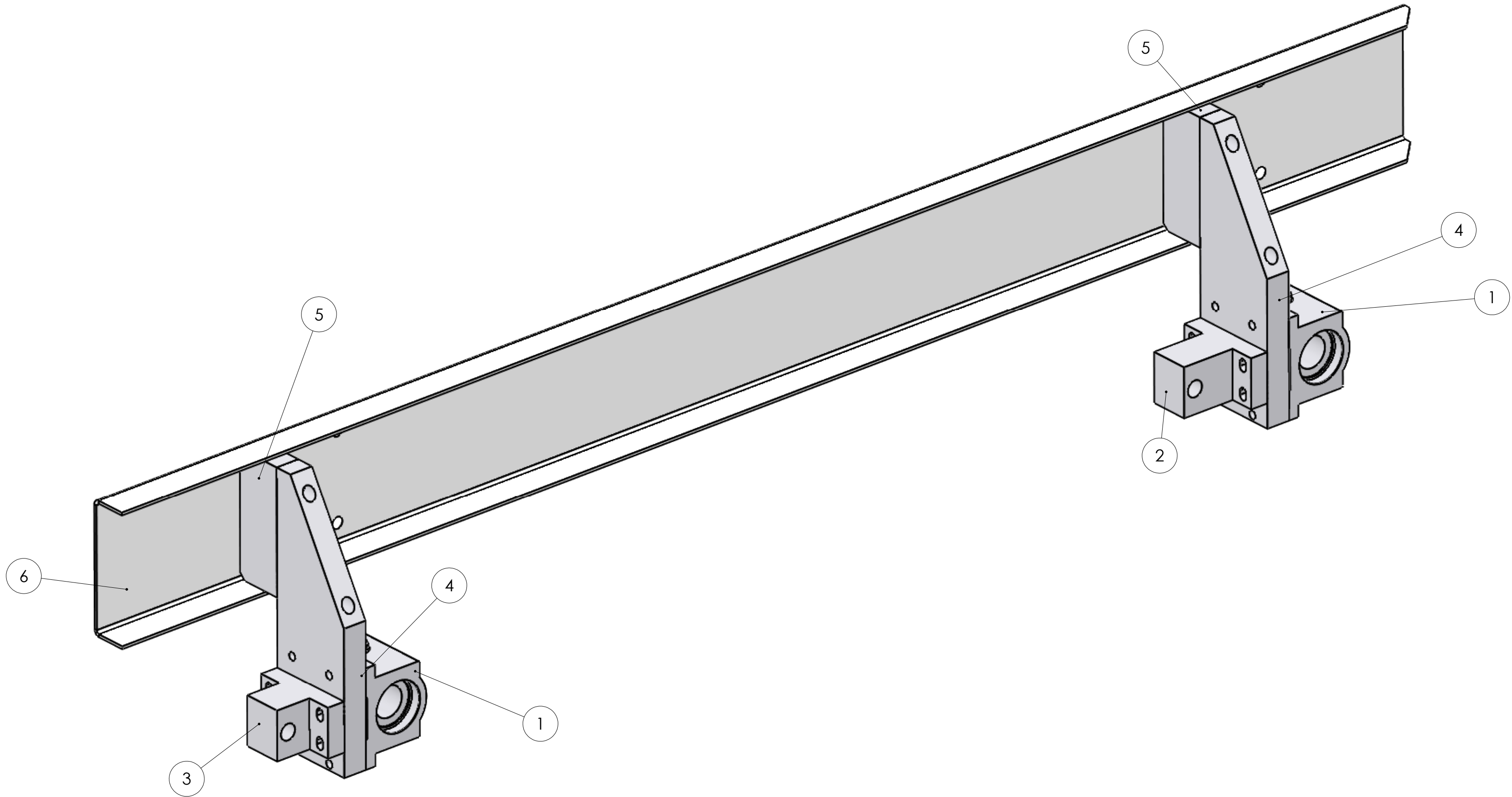
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|                                      |                      |      |           |
|--------------------------------------|----------------------|------|-----------|
| UNLESS OTHERWISE SPECIFIED:          |                      | NAME | DATE      |
| DIMENSIONS ARE IN INCHES             | DRAWN                | RB   | 8/17/2020 |
| TOLERANCES:                          | DESIGNER             |      |           |
| FRACTIONAL ± .015                    | ENG APPR.            |      |           |
| ANGULAR: MACH ± 0.5° BEND ± 5°       | MFG APPR.            |      |           |
| TWO PLACE DECIMAL ± .010             | Q.A.                 |      |           |
| THREE PLACE DECIMAL ± .005           | COMMERCIAL PART      |      |           |
| INTERPRET GEOMETRIC TOLERANCING PER: |                      |      |           |
| MATERIAL                             |                      |      |           |
| FINISH                               | EST. WEIGHT (lbs):   |      |           |
|                                      | 209.67               |      |           |
|                                      | DO NOT SCALE DRAWING |      |           |

|                         |           |              |
|-------------------------|-----------|--------------|
| <b>SWITCHBACK GROUP</b> |           |              |
| TITLE:                  |           |              |
| MAGAZINE CONVEYOR BED   |           |              |
| SIZE                    | DWG. NO.  | REV          |
| <b>D</b>                | 1702-109B |              |
| SHEET SCALE: 1:8        |           | SHEET 1 OF 1 |

| ITEM NO. | QTY | PART NUMBER   | DESCRIPTION             |
|----------|-----|---------------|-------------------------|
| 1        | 2   | MD-09-6576-00 | MODIFIED LINEAR BEARING |
| 2        | 1   | MD-09-6578-01 | SCREW BLOCK             |
| 3        | 1   | MD-09-6794-00 | SCREW BLOCK             |
| 4        | 2   | MD-09-7108-00 | SIDE COLUMN             |
| 5        | 2   | MD-09-7109-00 | SIDE GUIDE SPACER       |
| 6        | 1   | MD-09-7110-00 | MAGAZINE SIDE GUIDE     |

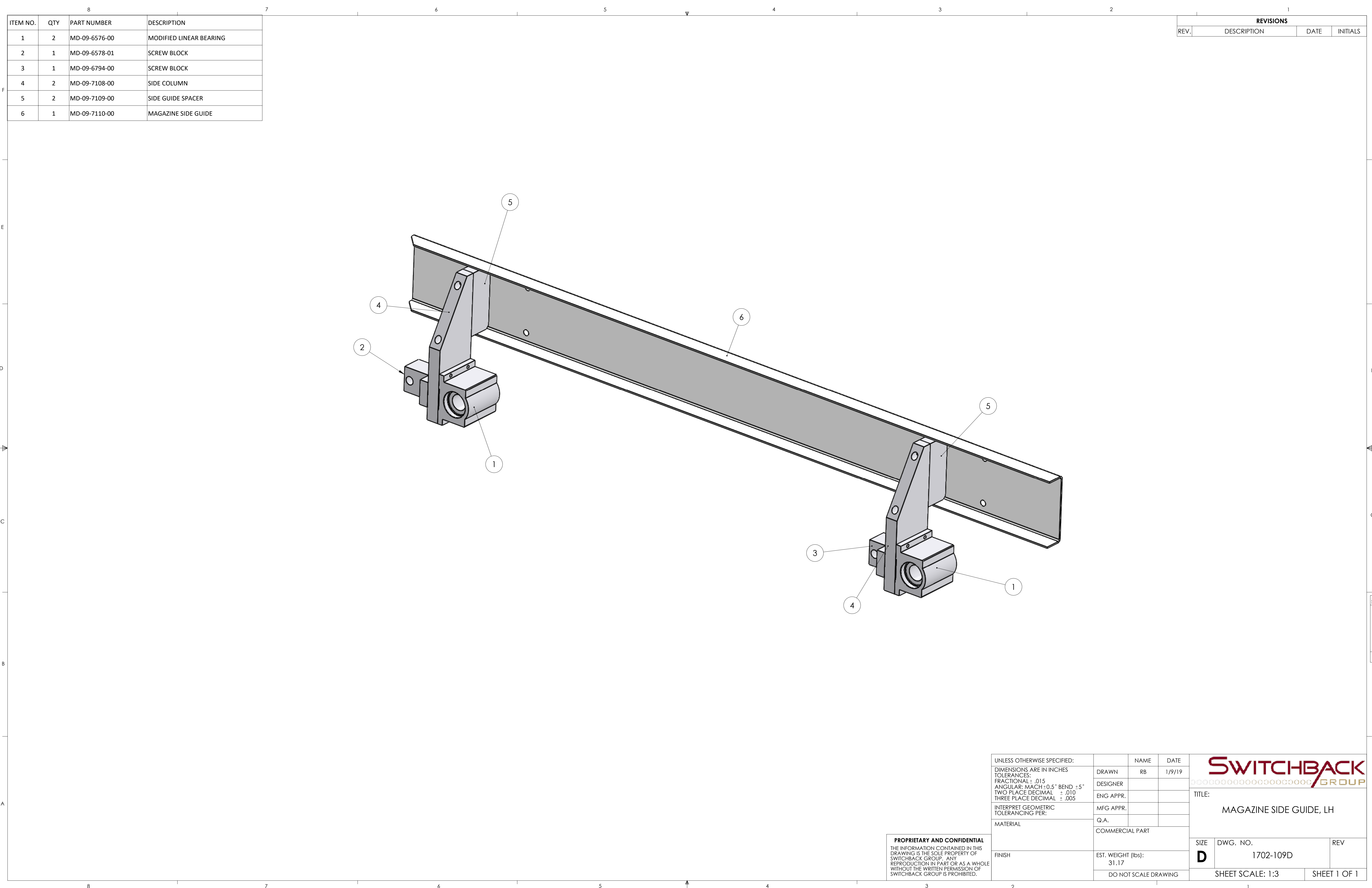
| REVISIONS |             |      |          |
|-----------|-------------|------|----------|
| REV.      | DESCRIPTION | DATE | INITIALS |



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|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--------------------|----------------------|-----------|
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|                                                                                                                                                                                                     | DESIGNER           |                      |           |
|                                                                                                                                                                                                     | ENG APPR.          |                      |           |
|                                                                                                                                                                                                     | MFG APPR.          |                      |           |
| MATERIAL                                                                                                                                                                                            | Q.A.               |                      |           |
|                                                                                                                                                                                                     | COMMERCIAL PART    |                      |           |
| FINISH                                                                                                                                                                                              | EST. WEIGHT (lbs): |                      |           |
|                                                                                                                                                                                                     | 31.17              |                      |           |
|                                                                                                                                                                                                     |                    | DO NOT SCALE DRAWING |           |

|                                   |                       |              |
|-----------------------------------|-----------------------|--------------|
| <b>SWITCHBACK</b><br>GROUP        |                       |              |
| TITLE:<br>MAGAZINE SIDE GUIDE, LH |                       |              |
| SIZE<br><b>D</b>                  | DWG. NO.<br>1702-109C | REV          |
| SHEET SCALE: 1:3                  |                       | SHEET 1 OF 1 |



F

E

D

C

B

A

F

E

D

C

B

A

| ITEM NO. | QTY | PART NUMBER   | DESCRIPTION             |
|----------|-----|---------------|-------------------------|
| 1        | 2   | MD-09-6576-00 | MODIFIED LINEAR BEARING |
| 2        | 1   | MD-09-6578-01 | SCREW BLOCK             |
| 3        | 1   | MD-09-6794-00 | SCREW BLOCK             |
| 4        | 2   | MD-09-7108-00 | SIDE COLUMN             |
| 5        | 2   | MD-09-7109-00 | SIDE GUIDE SPACER       |
| 6        | 1   | MD-09-7110-00 | MAGAZINE SIDE GUIDE     |

| REVISIONS |             |      |          |
|-----------|-------------|------|----------|
| REV.      | DESCRIPTION | DATE | INITIALS |

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|                                                                                                                                                          |                             |                                   |                       |
|----------------------------------------------------------------------------------------------------------------------------------------------------------|-----------------------------|-----------------------------------|-----------------------|
| UNLESS OTHERWISE SPECIFIED:                                                                                                                              |                             | NAME                              | DATE                  |
| DIMENSIONS ARE IN INCHES<br>TOLERANCES:<br>FRACTIONAL ± .015<br>ANGULAR: MACH ± 0.5° BEND ± 5°<br>TWO PLACE DECIMAL ± .010<br>THREE PLACE DECIMAL ± .005 | DRAWN                       | RB                                | 1/9/19                |
|                                                                                                                                                          | DESIGNER                    |                                   |                       |
|                                                                                                                                                          | ENG APPR.                   |                                   |                       |
|                                                                                                                                                          | MFG APPR.                   |                                   |                       |
| INTERPRET GEOMETRIC<br>TOLERANCING PER:                                                                                                                  | Q.A.                        |                                   |                       |
| MATERIAL                                                                                                                                                 | COMMERCIAL PART             |                                   |                       |
| FINISH                                                                                                                                                   | EST. WEIGHT (lbs):<br>31.17 |                                   |                       |
|                                                                                                                                                          |                             | DO NOT SCALE DRAWING              |                       |
|                                                                                                                                                          |                             | SIZE<br><b>D</b>                  | DWG. NO.<br>1702-109D |
|                                                                                                                                                          |                             | REV                               |                       |
|                                                                                                                                                          |                             | TITLE:<br>MAGAZINE SIDE GUIDE, LH |                       |
|                                                                                                                                                          |                             | SHEET SCALE: 1:3                  |                       |
|                                                                                                                                                          |                             | SHEET 1 OF 1                      |                       |

REV  
1702-109D  
**D**  
B



8

7

6

5

4

3

2

1

ITEM NO.

QTY

PART NUMBER

DESCRIPTION

1

2

SDC23X7-1\_4-PB-E-Q6-AR-AE

NOZZLE, DUAL 90 DEG., .016 ORIFICE  
GUIDED CYL, 1" BORE, 7-1/4" STROKE, MAG PISTON, FLOW CTRLS, SHOCK PADS, PLATED SHAFTS

2

1

0226-0400-RH-1in-1in

RH GEARBOX, 1:1, 2X 1" BORE

3

2

1011016

NOZZLE, SINGLE 90 DEG., .016 ORIFICE

4

2

8517930

DUAL SOLENOID GLUE GUN

5

8

92320A396

SPACER, 3/8" BORE, 1/4" LG, 3/4" OD

6

2

90642A359

T-SLOT NUT, 1/4-20

7

2

90298A578

1/4-20 shoulder bolt

8

2

60655K582

ADJUSTABLE HANDLE, 1/4"-20 X 1-3/4" STD

9

2

CYR-1-S

CAM YOKE ROLLER, SEALED, 1" ROLLER, 5/16" BORE

10

6

CL-16-A

SHAFT COLLAR, 1" BORE, AI

11

1

274794

REDI-FLEX HOSE, 5/16, 10 FT. LG.

12

1

274795

REDI-FLEX HOSE, 5/16, 12 FT. LG.

13

3

64835K692

ADJUSTABLE HANDLE, 5/16"-18 X 3/4" STUD, ORANGE

14

2

17000-32-5

SWITCH MOUNT KIT, 1.00 BORE

15

2

17524-2

SOLID STATE SWITCH, PNP, M8 QD

16

2

V3-GM-BK10M-PVC-U

M8 CABLE, 3-PIN, STRAIGHT, 10M LG

17

2

V1-G-BK10M-PVC-U

M12 CABLE, STRAIGHT, 10M LG, 4-PIN

18

2

WTB9-3P3461

PHOTOELECTRIC PROXIMITY SWITCH, 4 PIN, M12

19

1

0227-0400-LH-1in-1in

LH GEARBOX, 1:1

20

6

92510A795

SPACER, 3/8" ID, 3/4" OD, 3/8" LG

21

2

50B10F-1

NO 50, B-TYPE SPROCKET, 1" KEYED BORE, 10T

22

1

90298A617

SHOULDER SCREW, 3/8" DIA. SHLD X 3/8" LG., 5/16-18 THD, SS

23

3

5429T13

3/8" BORE THRUST BEARING, 1/16" THK, 3/4" OD, FOOD GRADE OIL

24

2

MS24585-C519

COMPRESSION SPRING, .850" OD, .063" WIRE DIA., 1.250" FREE LENGTH, SS

25

1

92384A058

QUICK-RELEASE PIN, 5/16" DIA, 2-1/2" LG

26

1

90298A591

SHOULDER SCREW, 5/16" DIA, 2" LG, 1/4"-20 THRD

27

2

92240A636

3/8"-16 X 3" LG HHCS, FULL THRD

28

6

91847A029

HEX JAM NUT, 1/4-20, 18-8 SS

29

8

92210A146

FHSCS, #6-32 X 3/8" LG., 18-8 SS

30

4

92311A425

CUP POINT SHSS, #10-32 X 1/4" LG. 18-8 SS

31

6

90298A581

SHOULDER SCREW, 5/16 DIA. X 3/4" LG., SS

32

2

95412A564

THREADED STUD, 1/4-20 X 6" LG. 18-8 SS

33

1

SUCTF 205-16

4-BOLT FLANGE BEARING, 1" BORE

34

2

MD-08-5157-00

CARTON ERECT PE BRACKET

35

1

MD-08-5158-00

CARTON ERECT PE POST

36

2

MD-08-5160-00

CARTON ERECT PE CLAMP

37

4

MD-10-0080-00

DISK CLAMP

38

4

MD-10-0130-09 REV A

FORWARD HORZ. TUCKER HUB

39

2

MD-10-5322-02

CROSS CLAMP

40

2

MD-10-5839-00

GUN ROD, 90

41

2

MD-10-5840-00

GUN ROD, STRAIGHT

42

2

MD-10-6241-00

GUN CLAMP

43

36

MD-10-6929-00

110 NUT BAR A

44

1

MD-10-6932-00

BOTTOM PLOW NOSE - LH

45

2

MD-10-6933-00

BOTTOM PLOW BRACKET

46

1

MD-10-6934-00 REV A

LOWER FLAP RETAINER

47

2

MD-10-6940-00

PLOW UPRIGHT A

48

4

MD-10-6941-00

MINOR FLAP PLOW BRACKET A.

49

1

MD-10-6943-00 REV A

LOWER MAJOR PLOW MOUNT C

50

1

MD-10-8095-00

UPPER FLAP PLOW A.

51

1

MD-10-6945-00

PLOW UPRIGHT A-1

52

2

MD-10-6946-02

BACK-UP COMPRESSION PLATE

53

2

MD-10-6947-00

110 NUT BAR C.

54

2

MD-10-6948-00

GUN MOUNT

55

2

MD-10-6949-00

LOWER MAJOR PLOW MOUNT D

56

6

MD-10-6950-00

110 NUT BAR D

57

1

MD-10-6951-00

LOWER MAJOR PLOW MOUNT E

58

1

MD-10-6952-00

MAJOR FLAP PLOW BRACKET A

59

1

MD-10-6953-00

GUN POSITION INDICATOR

60

1

MD-10-6954-00

GUN POSITION SCALE

61

1

MD-10-6955-00

GUN POSITION SCALE B

62

1

MD-10-6957-00

BACK-UP COMP MOUNT B

63

4

MD-10-6958-00

110 NUT BAR E

64

1

MD-10-6959-00

BACK-UP COMP MOUNT C

65

4

MD-10-6960-00

110 NUT BAR F

66

1

MD-10-6961-00

PLOW UPRIGHT B-1

67

1

MD-10-6962-00

GUN POSITION INDICATOR

68

1

MD-10-6963-00

MAJOR FLAP PLOW BRACKET A-1

69

1

MD-10-6965-00

LOWER MAJOR PLOW MOUNT F

ITEM NO.

QTY

PART NUMBER

DESCRIPTION

71

1

MD-10-6966-00

BOTTOM PLOW NOSE - LH

72

1

MD-10-6967-00 REV A

LOWER FLAP RETAINER

73

3

MD-10-6968-00 REV A

PLOW UPRIGHT B

74

1

MD-10-6970-00

MAJOR FLAP PLOW BRACKET B

75

1

MD-10-6972-00

MINOR FLAP PLOW BRACKET B

76

1

MD-10-6977-00

TUCKER DRIVE SHAFT A

77

2

MD-10-6979-00

TUCKER PIVOT SHAFT A.

78

1

MD-10-6984-00

NUT BAR 110A

79

1

MD-10-7030-00

LOWER MAJOR UP PLOW - RH

80

1

MD-10-7031-01

MINOR FLAP CLOSED PLOW B - RH

81

1

MD-10-7032-01

MINOR FLAP CLOSED PLOW - RH

82

1

MD-10-7033-00

MINOR FLAP CLOSED PLOW A - RH

83

1

MD-10-7037-00

UPPER FLAP PLOW C - RH

84

3

MD-10-7078-00

ROTARY FLAP TUCKER

85

2

MD-10-7162-00

BACK-UP COMP MOUNT A

86

1

MD-10-7167-00

LOWER MAJOR PLOW MOUNT A

87

1

MD-10-7168-00

LOWER MAJOR PLOW

88

2

MD-10-7169-00

PLOW UPRIGHT A

89

1

MD-10-7170-00

TOP FLAP SUPPORT RAIL A

90

1

MD-10-7171-00

GEARBOX MOUNT 110A

91

2

MD-10-7172-00

UPPER FLAP RAIL BRACKET A - RH

92

1

MD-10-7173-00

TUCKER DRIVE SHAFT B

93

2

MD-10-7174-00

BREAKER BAR EXTENSION

94

2

MD-10-7175-00

BREAKER BAR A

95

1

MD-10-7176-00

GEARBOX MOUNT 110B

96

1

MD-10-7177-00

CARTON ERECT PE MOUNT

97

1

MD-10-7178-00 REV A

UPRIGHT BRACE A

98

1

MD-10-7180-00

UPRIGHT BRACE B

99

1

MD-10-7181-00

UPPER FLAP PLOW D - RH

100

1

MD-10-7183-00

MITCH PLOW - RH

101

1

MD-10-7184-00

MITCH PLOW SPACER

102

1

MD-10-7185-00

PLOW NUT PLATE A

103

2

MD-10-7186-00

PLOW NUT PLATE B

104

1

MD-10-7187-00

PLOW MOUNT

105

1

MD-10-7188-00

PLOW MOUNT BLOCK

106

1

MD-10-7189-00

PLOW MOUNT BLOCK A

107

2

MD-10-7354-00

BACKUP COMPRESSION SPACER

112

2

MD-10-7380-00

SPRING CLAMP BLOCK

113

2

MD-10-7381-00 REV A

SPRING ADJUSTMENT BLOCK

114

2

MD-10-7382-00

MINOR FLAP SPRING

115

4

MD-10-7383-00

SPRING RETAINER

116

2

MD-10-7472-00 REV B

MOUNTING BAR

117

2

MD-10-8106-00

ADJUSTMENT BAR

118

2

MD-10-7474-00 REV A

PIVOT MOUNT

119

2

MD-10-7475-00 REV B

PIVOT BAR

120

2

MD-10-7476-00

SPRING BAR

121

1

MD-10-7525-00

ROTARY FLAP TUCKER

122

1

MD-10-7530-00

TUCKER ADD-ON

123

1

MD-10-7938-00

DISCHARGE OH MOUNT

124

1

MD-10-7939-00

OVERHEAD RAIL MOUNT A - LH

125

1

MD-10-7940-00 REV A

UPRIGHT CROSS BRACE

126

1

MD-10-8096-00

UPPER FLAP PLOW B

127

2

MD-10-7942-00

COMPRESSION PLOW

128

1

MD-10-7943-00

DISCHARGE OVERHEAD RAIL - RH

129

2

MD-10-7944-00

COMPRESSION MOUNT A

130

1

MD-10-7945-00

LOWER MAJOR DOWN PLOW

131

1

MD-10-7946-00

GEARBOX MOUNT 110B

132

2

MD-10-7947-00

GLUE UPRIGHT STIFFENER

133

1

MD-10-8097-00

TOP FLAP SUPPORT RAIL

134

1

MD-10-7340-00

UPPER FLAP RAIL BRKT A - LH

135

2

MD-10-8115-00

MAJOR FLAP SUPPORT BRKT - RH

136

1

MD-10-8114-00 REV A

MAJOR FLAP SUPPORT - RH

137

2

MD-10-8381-00

UPPER MAJOR PLOW

REV

DESCRIPTION

DATE

INITIALS

REV

1702-110

D

NOTES:

1. USE STAINLESS STEEL HARDWARE UNLESS OTHERWISE SPECIFIED.

UNLESS OTHERWISE SPECIFIED:

DIMENSIONS ARE IN INCHES

TOLERANCES:

FRACTIONAL ± .015

ANGULAR: MACH±0.5° BEND ±5°

TWO PLACE DECIMAL ± .010

THREE PLACE DECIMAL ± .005

INTERPRET GEOMETRIC TOLERANCING PER:

MATERIAL

FINISH

DRAWN

DESIGNER

ENG APPR.

MFG APPR.

Q.A.

COMMERCIAL PART

EST. WEIGHT (lbs):

DO NOT SCALE DRAWING

NAME

RB

DATE

6/24/20

TITLE:

PLOW ASM

SIZE

D

DWG. NO.

1702-110

REV

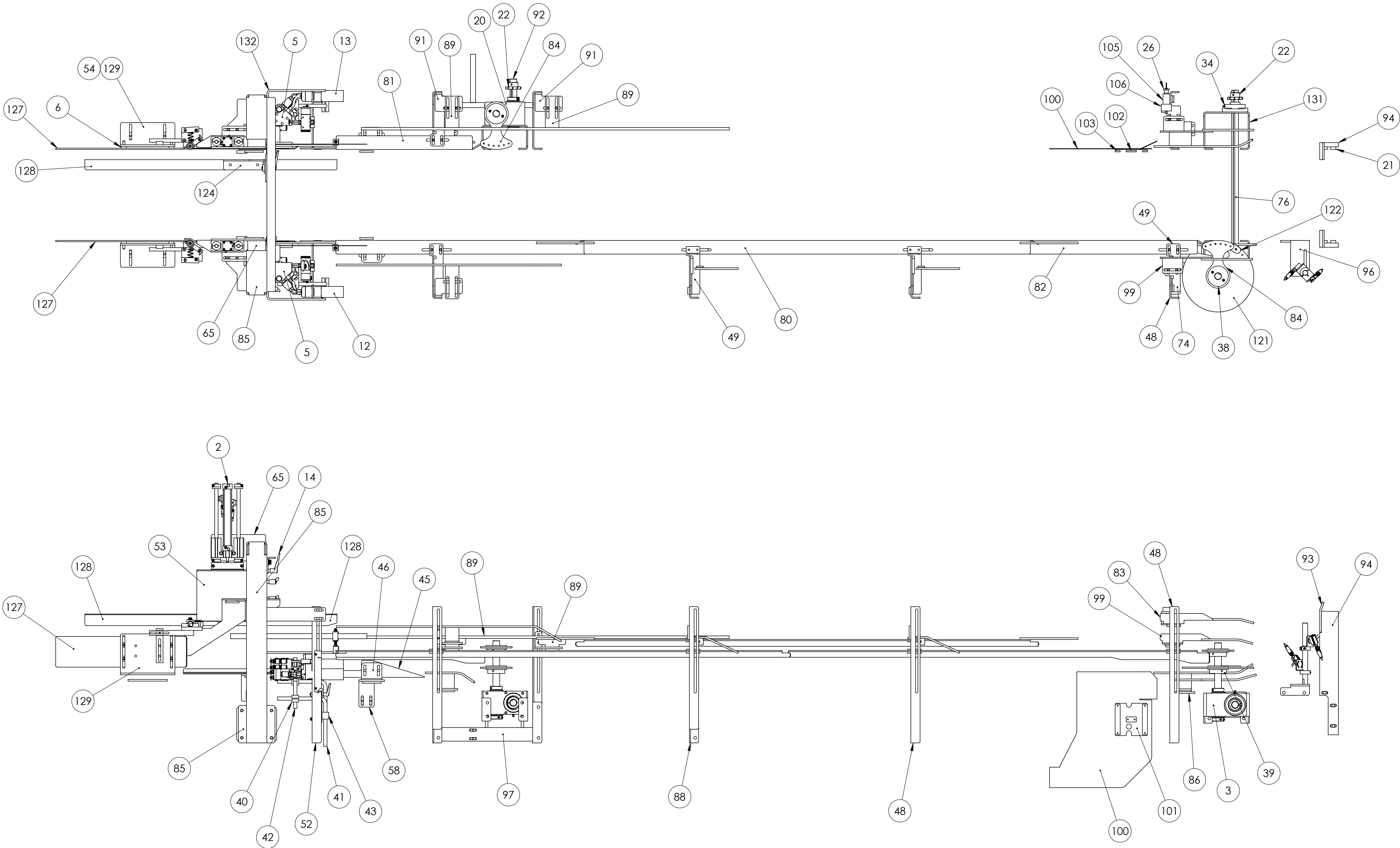
SHEET SCALE: 1:8

SHEET 1 OF 3

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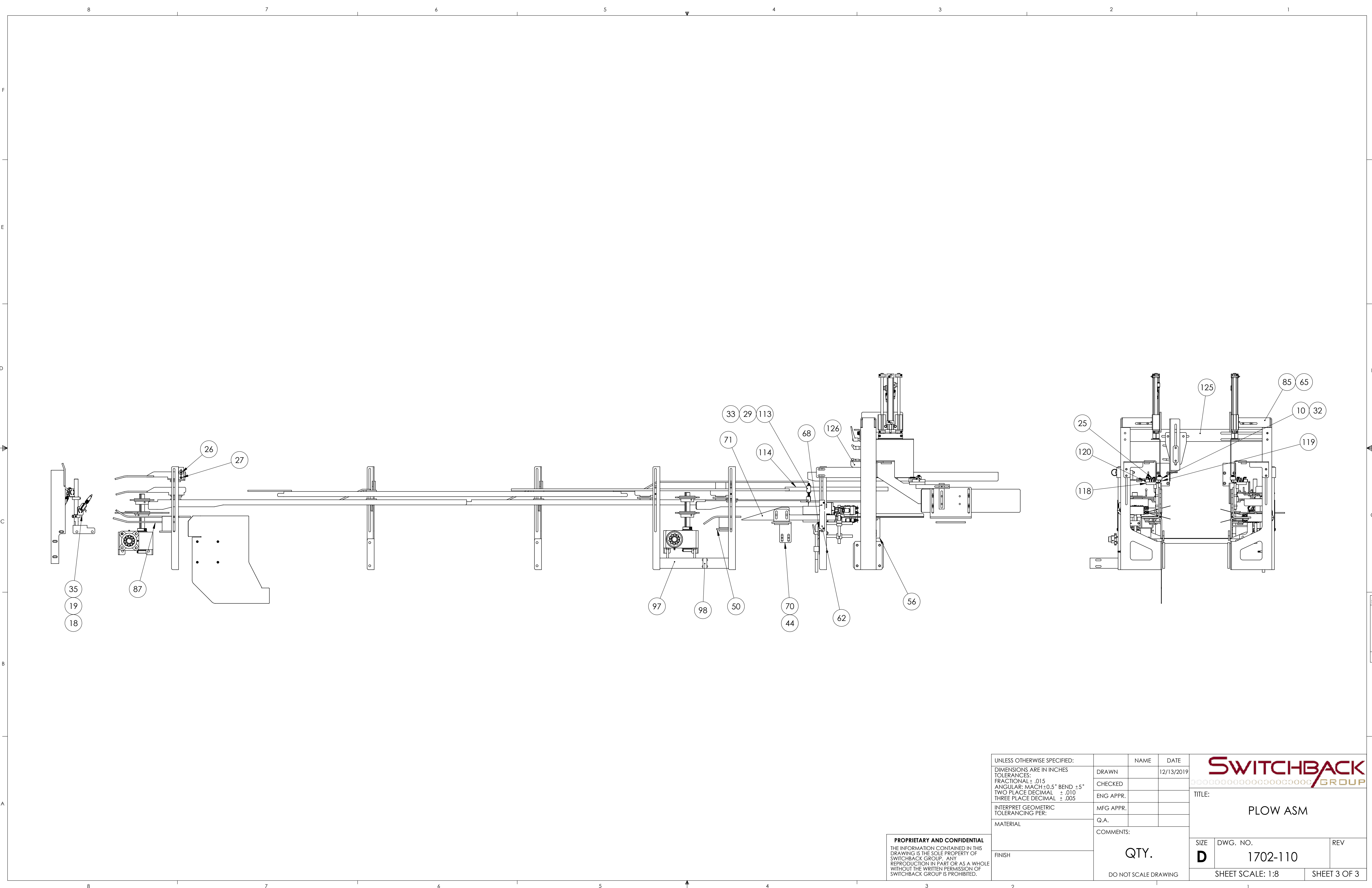
SWITCHBACK GROUP

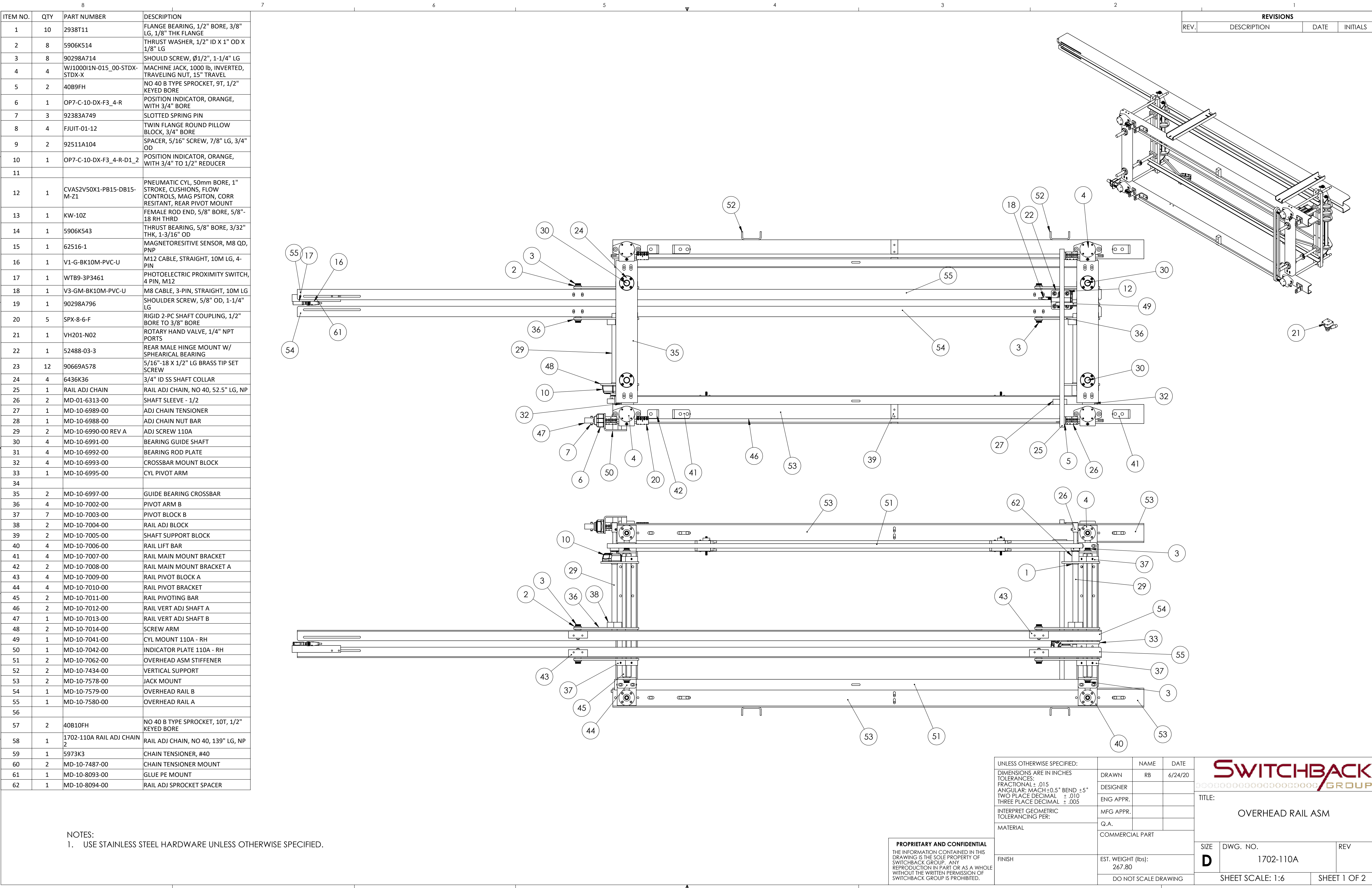


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|                                                                                                                                                                                                     |                      |            |      |
|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|----------------------|------------|------|
| UNLESS OTHERWISE SPECIFIED:                                                                                                                                                                         |                      | NAME       | DATE |
| DIMENSIONS ARE IN INCHES<br>TOLERANCES:<br>FRACTIONAL ± .015<br>ANGULAR: MACH ± 0.5° BEND ± 5°<br>TWO PLACE DECIMAL ± .010<br>THREE PLACE DECIMAL ± .005<br>INTERPRET GEOMETRIC<br>TOLERANCING PER: | DRAWN                | 12/13/2019 |      |
|                                                                                                                                                                                                     | CHECKED              |            |      |
|                                                                                                                                                                                                     | ENG APPR.            |            |      |
|                                                                                                                                                                                                     | MFG APPR.            |            |      |
|                                                                                                                                                                                                     | Q.A.                 |            |      |
| MATERIAL                                                                                                                                                                                            | COMMENTS:            |            |      |
| FINISH                                                                                                                                                                                              | QTY.                 |            |      |
|                                                                                                                                                                                                     | DO NOT SCALE DRAWING |            |      |

|                           |                             |              |
|---------------------------|-----------------------------|--------------|
| <b>SWITCHBACK GROUP</b>   |                             |              |
| TITLE:<br><b>PLOW ASM</b> |                             |              |
| SIZE<br><b>D</b>          | DWG. NO.<br><b>1702-110</b> | REV          |
| SHEET SCALE: 1:8          |                             | SHEET 2 OF 3 |





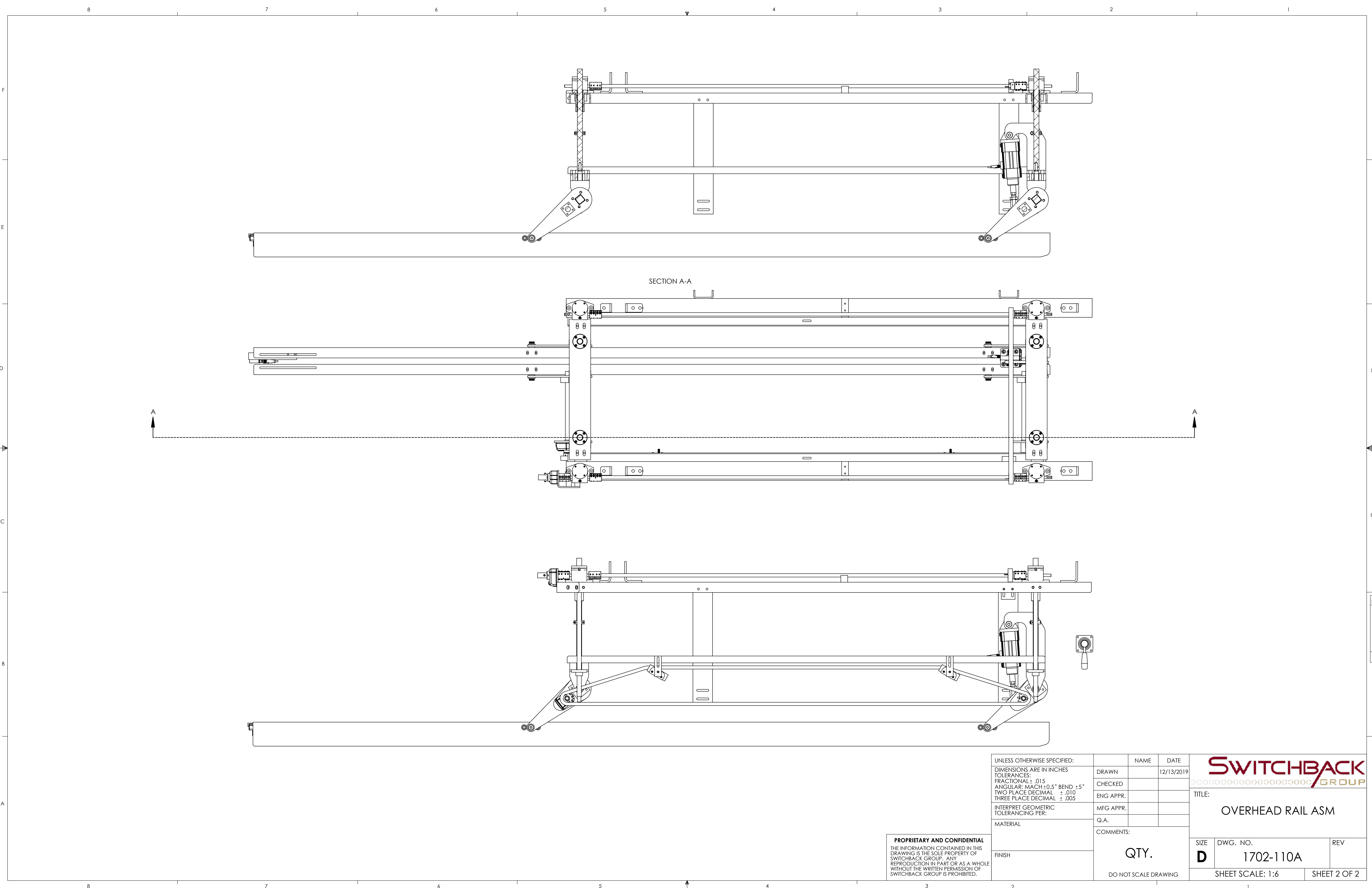
| ITEM NO. | QTY | PART NUMBER                  | DESCRIPTION                                                                                               |
|----------|-----|------------------------------|-----------------------------------------------------------------------------------------------------------|
| 1        | 10  | 2938T11                      | FLANGE BEARING, 1/2" BORE, 3/8" LG, 1/8" THK FLANGE                                                       |
| 2        | 8   | 5906K514                     | THRUST WASHER, 1/2" ID X 1" OD X 1/8" LG                                                                  |
| 3        | 8   | 90298A714                    | SHOULD SCREW, Ø1/2", 1-1/4" LG                                                                            |
| 4        | 4   | WJ1000I1N-015_00-STDX-STDX-X | MACHINE JACK, 1000 lb, INVERTED, TRAVELING NUT, 15" TRAVEL                                                |
| 5        | 2   | 40B9FH                       | NO 40 B TYPE SPROCKET, 9T, 1/2" KEYED BORE                                                                |
| 6        | 1   | OP7-C-10-DX-F3_4-R           | POSITION INDICATOR, ORANGE, WITH 3/4" BORE                                                                |
| 7        | 3   | 92383A749                    | SLOTTED SPRING PIN                                                                                        |
| 8        | 4   | FJUIT-01-12                  | TWIN FLANGE ROUND PILLOW BLOCK, 3/4" BORE                                                                 |
| 9        | 2   | 92511A104                    | SPACER, 5/16" SCREW, 7/8" LG, 3/4" OD                                                                     |
| 10       | 1   | OP7-C-10-DX-F3_4-R-D1_2      | POSITION INDICATOR, ORANGE, WITH 3/4" TO 1/2" REDUCER                                                     |
| 11       |     |                              |                                                                                                           |
| 12       | 1   | CVAS2V50X1-PB15-DB15-M-Z1    | PNEUMATIC CYL, 50mm BORE, 1" STROKE, CUSHIONS, FLOW CONTROLS, MAG PSITON, CORR RESITANT, REAR PIVOT MOUNT |
| 13       | 1   | KW-10Z                       | FEMALE ROD END, 5/8" BORE, 5/8"-18 RH THRD                                                                |
| 14       | 1   | 5906K543                     | THRUST BEARING, 5/8" BORE, 3/32" THK, 1-3/16" OD                                                          |
| 15       | 1   | 62516-1                      | MAGNETORESISTIVE SENSOR, M8 QD, PNP                                                                       |
| 16       | 1   | V1-G-BK10M-PVC-U             | M12 CABLE, STRAIGHT, 10M LG, 4-PIN                                                                        |
| 17       | 1   | WTB9-3P3461                  | PHOTOELECTRIC PROXIMITY SWITCH, 4 PIN, M12                                                                |
| 18       | 1   | V3-GM-BK10M-PVC-U            | M8 CABLE, 3-PIN, STRAIGHT, 10M LG                                                                         |
| 19       | 1   | 90298A796                    | SHOULDER SCREW, 5/8" OD, 1-1/4" LG                                                                        |
| 20       | 5   | SPX-8-6-F                    | RIGID 2-PC SHAFT COUPLING, 1/2" BORE TO 3/8" BORE                                                         |
| 21       | 1   | VH201-N02                    | ROTARY HAND VALVE, 1/4" NPT PORTS                                                                         |
| 22       | 1   | 52488-03-3                   | REAR MALE HINGE MOUNT W/ SPHERICAL BEARING                                                                |
| 23       | 12  | 90669A578                    | 5/16"-18 X 1/2" LG BRASS TIP SET SCREW                                                                    |
| 24       | 4   | 6436K36                      | 3/4" ID SS SHAFT COLLAR                                                                                   |
| 25       | 1   | RAIL ADJ CHAIN               | RAIL ADJ CHAIN, NO 40, 52.5" LG, NP                                                                       |
| 26       | 2   | MD-01-6313-00                | SHAFT SLEEVE - 1/2                                                                                        |
| 27       | 1   | MD-10-6989-00                | ADJ CHAIN TENSIONER                                                                                       |
| 28       | 1   | MD-10-6988-00                | ADJ CHAIN NUT BAR                                                                                         |
| 29       | 2   | MD-10-6990-00 REV A          | ADJ SCREW 110A                                                                                            |
| 30       | 4   | MD-10-6991-00                | BEARING GUIDE SHAFT                                                                                       |
| 31       | 4   | MD-10-6992-00                | BEARING ROD PLATE                                                                                         |
| 32       | 4   | MD-10-6993-00                | CROSSBAR MOUNT BLOCK                                                                                      |
| 33       | 1   | MD-10-6995-00                | CYL PIVOT ARM                                                                                             |
| 34       |     |                              |                                                                                                           |
| 35       | 2   | MD-10-6997-00                | GUIDE BEARING CROSSBAR                                                                                    |
| 36       | 4   | MD-10-7002-00                | PIVOT ARM B                                                                                               |
| 37       | 7   | MD-10-7003-00                | PIVOT BLOCK B                                                                                             |
| 38       | 2   | MD-10-7004-00                | RAIL ADJ BLOCK                                                                                            |
| 39       | 2   | MD-10-7005-00                | SHAFT SUPPORT BLOCK                                                                                       |
| 40       | 4   | MD-10-7006-00                | RAIL LIFT BAR                                                                                             |
| 41       | 4   | MD-10-7007-00                | RAIL MAIN MOUNT BRACKET                                                                                   |
| 42       | 2   | MD-10-7008-00                | RAIL MAIN MOUNT BRACKET A                                                                                 |
| 43       | 4   | MD-10-7009-00                | RAIL PIVOT BLOCK A                                                                                        |
| 44       | 4   | MD-10-7010-00                | RAIL PIVOT BRACKET                                                                                        |
| 45       | 2   | MD-10-7011-00                | RAIL PIVOTING BAR                                                                                         |
| 46       | 2   | MD-10-7012-00                | RAIL VERT ADJ SHAFT A                                                                                     |
| 47       | 1   | MD-10-7013-00                | RAIL VERT ADJ SHAFT B                                                                                     |
| 48       | 2   | MD-10-7014-00                | SCREW ARM                                                                                                 |
| 49       | 1   | MD-10-7041-00                | CYL MOUNT 110A - RH                                                                                       |
| 50       | 1   | MD-10-7042-00                | INDICATOR PLATE 110A - RH                                                                                 |
| 51       | 2   | MD-10-7062-00                | OVERHEAD ASM STIFFENER                                                                                    |
| 52       | 2   | MD-10-7434-00                | VERTICAL SUPPORT                                                                                          |
| 53       | 2   | MD-10-7578-00                | JACK MOUNT                                                                                                |
| 54       | 1   | MD-10-7579-00                | OVERHEAD RAIL B                                                                                           |
| 55       | 1   | MD-10-7580-00                | OVERHEAD RAIL A                                                                                           |
| 56       |     |                              |                                                                                                           |
| 57       | 2   | 40B10FH                      | NO 40 B TYPE SPROCKET, 10T, 1/2" KEYED BORE                                                               |
| 58       | 1   | 1702-110A RAIL ADJ CHAIN 2   | RAIL ADJ CHAIN, NO 40, 139" LG, NP                                                                        |
| 59       | 1   | 5973K3                       | CHAIN TENSIONER, #40                                                                                      |
| 60       | 2   | MD-10-7487-00                | CHAIN TENSIONER MOUNT                                                                                     |
| 61       | 1   | MD-10-8093-00                | GLUE PE MOUNT                                                                                             |
| 62       | 1   | MD-10-8094-00                | RAIL ADJ SPROCKET SPACER                                                                                  |

NOTES:  
1. USE STAINLESS STEEL HARDWARE UNLESS OTHERWISE SPECIFIED.

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|                                                                                                                                                                                                                                           |                              |            |                 |
|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|------------------------------|------------|-----------------|
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| FINISH                                                                                                                                                                                                                                    | EST. WEIGHT (lbs):<br>267.80 |            |                 |
|                                                                                                                                                                                                                                           | DO NOT SCALE DRAWING         |            |                 |

|                                 |                       |              |
|---------------------------------|-----------------------|--------------|
| <b>SWITCHBACK GROUP</b>         |                       |              |
| TITLE:<br><br>OVERHEAD RAIL ASM |                       |              |
| SIZE<br><b>D</b>                | DWG. NO.<br>1702-110A | REV          |
| SHEET SCALE: 1:6                |                       | SHEET 1 OF 2 |



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UNLESS OTHERWISE SPECIFIED:  
DIMENSIONS ARE IN INCHES  
TOLERANCES:  
FRACTIONAL  $\pm .015$   
ANGULAR: MACH  $\pm 0.5^\circ$  BEND  $\pm 5^\circ$   
TWO PLACE DECIMAL  $\pm .010$   
THREE PLACE DECIMAL  $\pm .005$   
INTERPRET GEOMETRIC  
TOLERANCING PER:  
MATERIAL  
FINISH

|                      |      |            |
|----------------------|------|------------|
|                      | NAME | DATE       |
| DRAWN                |      | 12/13/2019 |
| CHECKED              |      |            |
| ENG APPR.            |      |            |
| MFG APPR.            |      |            |
| Q.A.                 |      |            |
| COMMENTS:            |      |            |
| QTY.                 |      |            |
| DO NOT SCALE DRAWING |      |            |

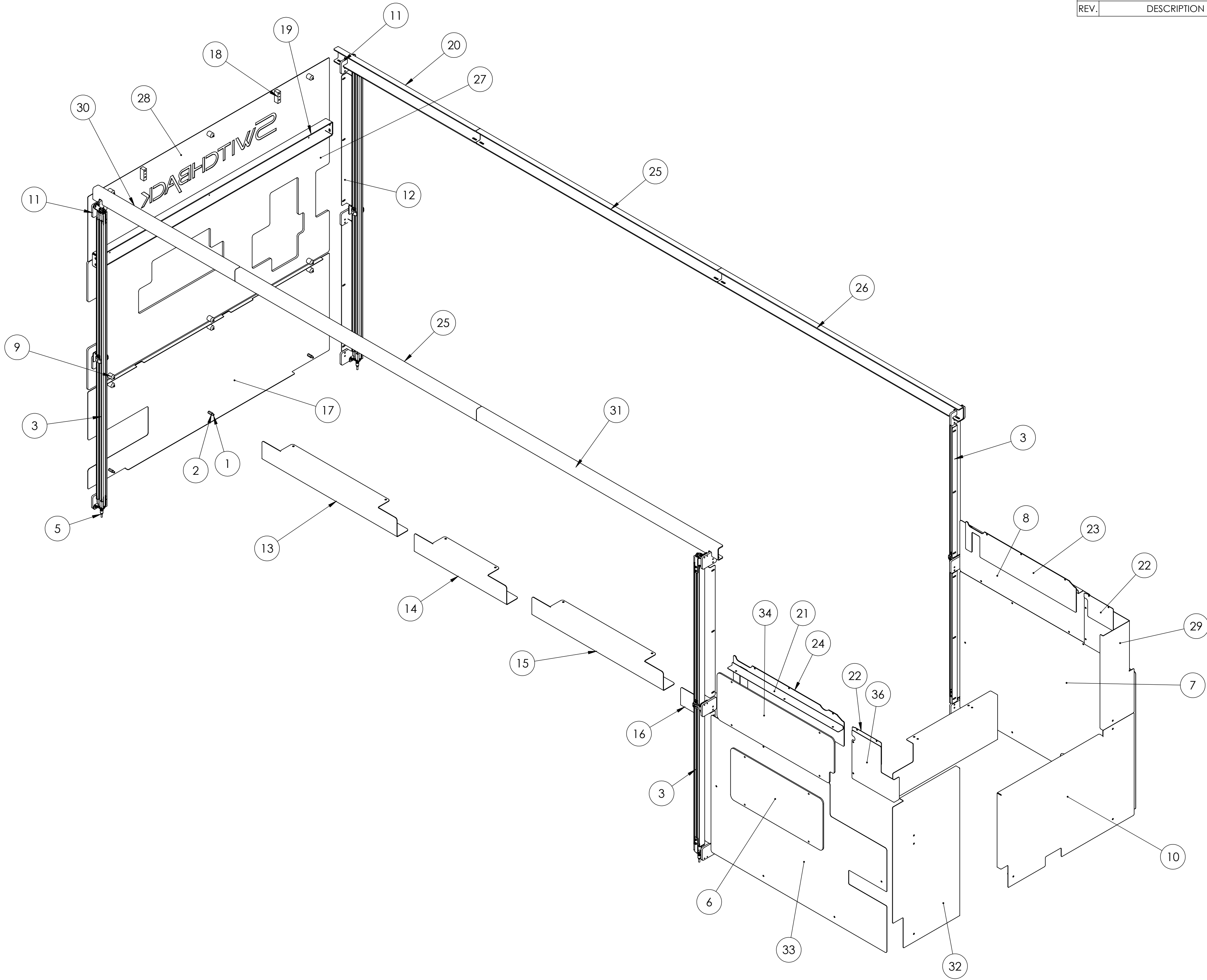


TITLE:

OVERHEAD RAIL ASM

|                  |           |              |
|------------------|-----------|--------------|
| SIZE             | DWG. NO.  | REV          |
| <b>D</b>         | 1702-110A |              |
| SHEET SCALE: 1:6 |           | SHEET 2 OF 2 |

| ITEM NO. | QTY. | PART NUMBER         | DESCRIPTION                                       |
|----------|------|---------------------|---------------------------------------------------|
| 1        | 16   | 95412A581           | STUD, 5/16"-18, 3/4" LG                           |
| 2        | 10   | 98434A110           | STANDOFF, 1" LG, 5/16"-18 TO 1/4"-20 FEMALE THRDS |
| 3        | 2    | SLLP23-1820BB       | LIGHT CURTAIN, 23MM RESOLUTION, 1820MM HT.        |
| 4        | 2    | QDE-825D            | FEMALE CONNECTOR, 8-PIN M12 QD, 8M LG             |
| 5        | 2    | QDE-850D            | FEMALE CONNECTOR, 8-PIN M12 QD, 15M LG            |
| 6        | 1    | MD-02-5493-00       | MANIFOLD COVER                                    |
| 7        | 1    | MD-13-6525-00       | GUARD PANEL A                                     |
| 8        | 1    | MD-13-6527-00       | GUARD PANEL C                                     |
| 9        | 9    | MD-13-6533-00       | GUARD SPACER 113A                                 |
| 10       | 1    | MD-13-6581-00 REV A | INFEED GUARD A - RH                               |
| 11       | 12   | MD-13-6791-00       | MOUNTING PLATE, LIGHT CURTAIN                     |
| 12       | 8    | MD-13-6792-00       | GAP COVER, LIGHT CURTAIN                          |
| 13       | 1    | MD-13-6794-00       | CHAIN COVER A                                     |
| 14       | 1    | MD-13-6795-00       | CHAIN COVER B                                     |
| 15       | 1    | MD-13-6796-00       | CHAIN COVER C                                     |
| 16       | 1    | MD-13-6797-00       | CHAIN COVER D                                     |
| 17       | 1    | MD-13-6804-00 REV B | DISCHARGE GUARD A                                 |
| 18       | 2    | MD-13-6807-00       | GUARD MOUNT                                       |
| 19       | 1    | MD-13-6806-00       | DISCHARGE GUARD CROSSBAR                          |
| 20       | 1    | MD-13-6818-00       | TOP RAIL                                          |
| 21       | 2    | MD-13-7099-00       | GUARD PANEL E                                     |
| 22       | 2    | MD-13-7101-00       | GUARD PANEL F                                     |
| 23       | 1    | MD-13-7103-00       | GUARD PANEL F                                     |
| 24       | 1    | MD-13-7116-00       | GUARD PANEL G                                     |
| 25       | 2    | MD-13-7232-00       | TOP RAIL                                          |
| 26       | 1    | MD-13-7233-00       | TOP RAIL                                          |
| 27       | 1    | MD-13-7223-00       | DISCHARGE WINDOW A                                |
| 28       | 1    | MD-13-7225-00       | DISCHARGE GUARD PANEL                             |
| 29       | 1    | MD-13-7226-00       | INFEED GUARD C - RH                               |
| 30       | 1    | MD-13-7229-00       | TOP RAIL                                          |
| 31       | 1    | MD-13-7230-00       | TOP RAIL                                          |
| 32       | 1    | MD-13-7324-00       | INFEED GUARD B - RH                               |
| 33       | 1    | MD-13-7460-00       | GUARD PANEL B                                     |
| 34       | 1    | MD-13-7461-00       | GUARD PANEL A                                     |
| 35       | 1    | MD-13-7507-00       | LOWER ERECTOR GUARD                               |
| 36       | 1    | MD-13-7508-00       | INFEED GUARD B-A                                  |



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|                                      |                      |      |         |
|--------------------------------------|----------------------|------|---------|
| UNLESS OTHERWISE SPECIFIED:          |                      | NAME | DATE    |
| DIMENSIONS ARE IN INCHES             | DRAWN                | RB   | 6/24/20 |
| TOLERANCES:                          | DESIGNER             |      |         |
| FRACTIONAL ± .015                    | ENG APPR.            |      |         |
| ANGULAR: MACH±0.5° BEND ±5°          | MFG APPR.            |      |         |
| TWO PLACE DECIMAL ± .010             | Q.A.                 |      |         |
| THREE PLACE DECIMAL ± .005           | COMMERCIAL PART      |      |         |
| INTERPRET GEOMETRIC TOLERANCING PER: |                      |      |         |
| MATERIAL                             |                      |      |         |
| FINISH                               | EST. WEIGHT (lbs):   |      |         |
|                                      | 416.57               |      |         |
|                                      | DO NOT SCALE DRAWING |      |         |

**SWITCHBACK**  
GROUP

TITLE:  
  
GUARDING ASSEMBLY

|                   |          |              |
|-------------------|----------|--------------|
| SIZE              | DWG. NO. | REV          |
| <b>D</b>          | 1702-113 |              |
| SHEET SCALE: 1:12 |          | SHEET 1 OF 1 |

[illegible]