



CDR-170 & CDR-250

Compact Bread Moulder OPERATIONS MANUAL



SOMERSET INDUSTRIES

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NOTICE !! READ CAREFULLY ALL INSTRUCTIONS BEFORE YOU START!!

UNCRATING AND SETUP

Cut off the Fastener wrapped around the machine and the base. Lift the machine straight up of the wooden base. Install the machine in its final position or temporarily secure it to a solid surface. Wipe off any dirt that may have accumulated during shipping. (Use a soft cloth) Check the nameplate for correct voltage and frequency. Plug the machine to the proper power source that matches the nameplate requirements. Press the power switch "ON" and check for proper operation of the machine.

!! WARNING !!

- **NEVER OPERATE THE MACHINE WITHOUT GUARDS IN PLACE**
- **KEEP YOUR HANDS AWAY FROM CHUTE**
- **DO NOT CLEAN THE MACHINE WHILE CONNECTED TO ELECTRICAL SUPPLY**
- **WATCH YOUR HANDS AND FINGERS**
- **EMERGENCY STOP SHOULD ONLY BE USED FOR EMERGENCIES**

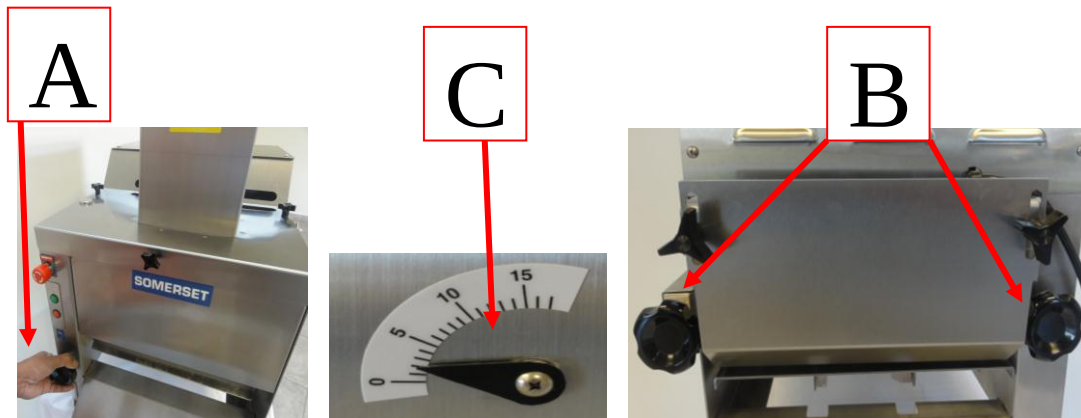
NOTE: The machine will not operate when the safety covers, or conveyor pan are removed

MACHINE PREPARATION

This moulder will mould bread products from 1 oz. to 55 oz. and length up to 15". It creates various sizes depending upon the weight of the dough ball, and the height and size of the pressure plate.

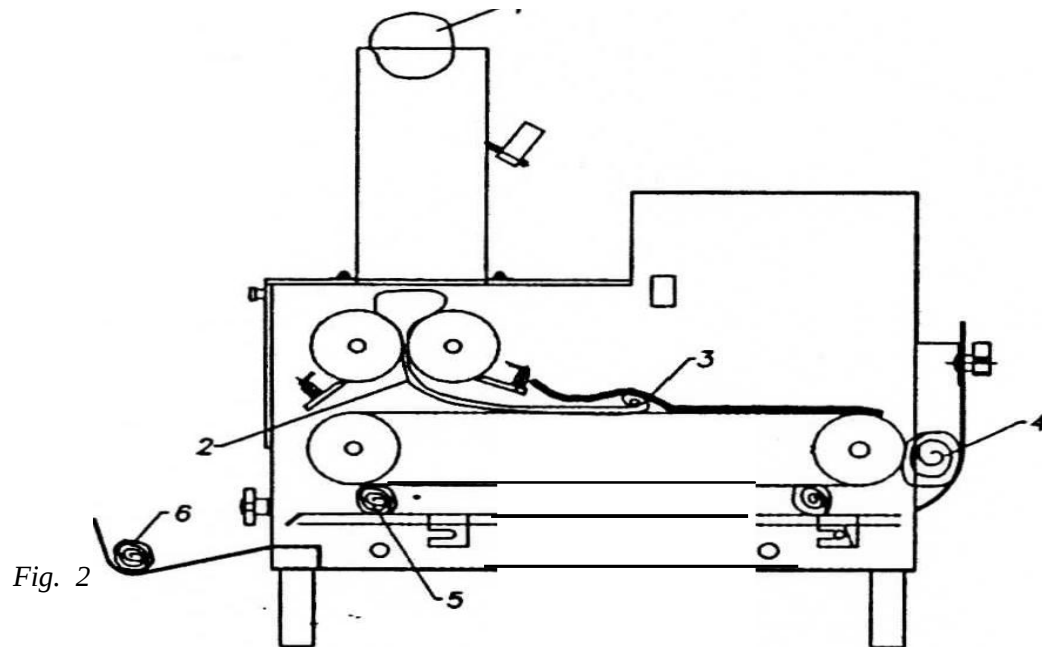
Note: For tighter moulded pieces, side plates are available which are installed at the bottom of the unit on each side of the pressure plate.

The height of pressure plate is controlled by knob "A" and indicated by dial "C".
Note: Before adjusting knob "A", loosen knob(s) "B" so the deflector plate is always on top of the pressure plate, and fasten knob(s) "B" when final position is determined.
The rollers are easily adjusted to any thickness of crust you may need from paper thin to $\frac{3}{4}$ "



THEORY OF OPERATION Fig. 2.

Dough balls enter into shoot (1), sheeted through the rollers (2) and curled by the curling chain (3). The curled piece is transferred on top of the pressure plate through deflector (4), where is moulded (5) and exits on the discharge tray (6) as a moulded piece of dough.



OPERATION

Scale dough and round up into dough balls. Let these rest for 15-20 minutes. DO NOT Use Too Much Dusting Flour. When ready to mould, pick up dough ball and drop into dough hopper of the moulder, making sure that the bottom of the dough piece, as it was resting on the bench, is facing you as it is dropped into the moulder.

This will help mould the dough piece tighter and give you a very good moulded loaf. The individual dough pieces are fed to the machine from the stainless steel hopper.

Product uniformity is dependent on feeding all dough pieces to the center of the machine in the exact same manner.

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SANITATION

When opening access doors for cleaning or adjustments place switch in "OFF" position and disconnect power. By removing both doors, the curling chain, and the scrapers, the whole machine is exposed and ready to be cleaned. Remove each scraper from its mounting pins by pushing scraper downward. Unhook both springs by lifting scraper up and remove it. Clean the rolls with dry cloth (never use water). Wipe rollers with lightly oiled cloth (use vegetable oil). Wash, dry and apply a thin film of vegetable oil on the edge of the scraper that touches the roller.



The side of the moulding chamber pan also serves as a catch pan to collect excess flour between the conveyor belt. **It** is removed by removing the thumb screws and pulling it away from the machine.



CAUTION! When replacing, make sure the pan is pushed all the way forward to the original position.

The pressure plate is removable for cleaning from the back-side of the machine. Simply lift up and pull the plate out. When it is reinstalled, care should be taken to see that it is installed perfectly straight and all the way forward.

!! CAUTION !!

**THIS MACHINE IS MAINTENANCE FREE.
NEVER USE OIL OR GREASE ON ANY OF THE MECHANICAL PARTS OF
THE MACHINE.
ALL MECHANICAL PARTS ARE PERMANENT SELF LUBRICATED.**

The conveyor belt is removable for cleaning or replacement. Loosen belt (through knobs "A"), remove belt rod "B". When installing the belt, follow the reverse directions.

CAUTION! Verify that the belt is installed the same way as removed, the outside side of the belt, facing the unit.

Correct belt tracking and tensions are necessary for longer machine life. Adjust the belt tension by turning the two adjusting knobs at the rear of the unit.

Adjust equally on both sides to increase tension. Excessive tension may cause tracking problems.

Back Deflector Plate can be removed for cleaning; when installing back on machine, make sure curved section is On Top of pressure plate.

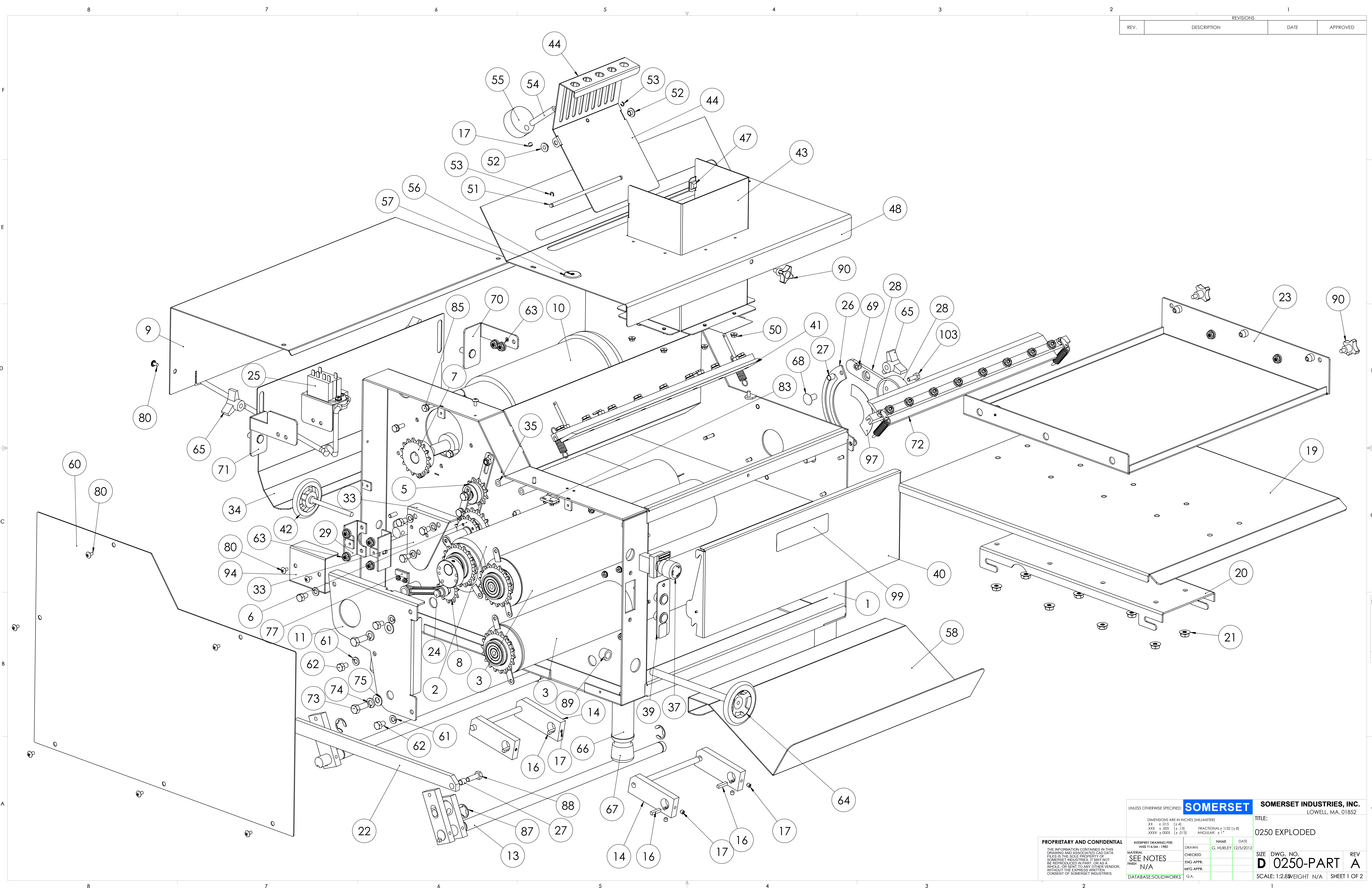


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REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED

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INTERPRET DRAWING PER: AND 11/4/2011-1982	DRAWN: G. HURLEY	NAME	DATE
MATERIAL SEE NOTES	CHECKED		
FINISH N/A	ENG APPR.		
DATABASE:SOLIDWORKS	MFG APPR.		
	G.A.		

SOMERSET

SOMERSET INDUSTRIES, INC.
LOWELL, MA, 01852

TITLE:
0250 EXPLODED

SIZE DWG. NO.
D 0250-PART A

SCALE: 1:2.89/WEIGHT N/A SHEET 1 OF 2

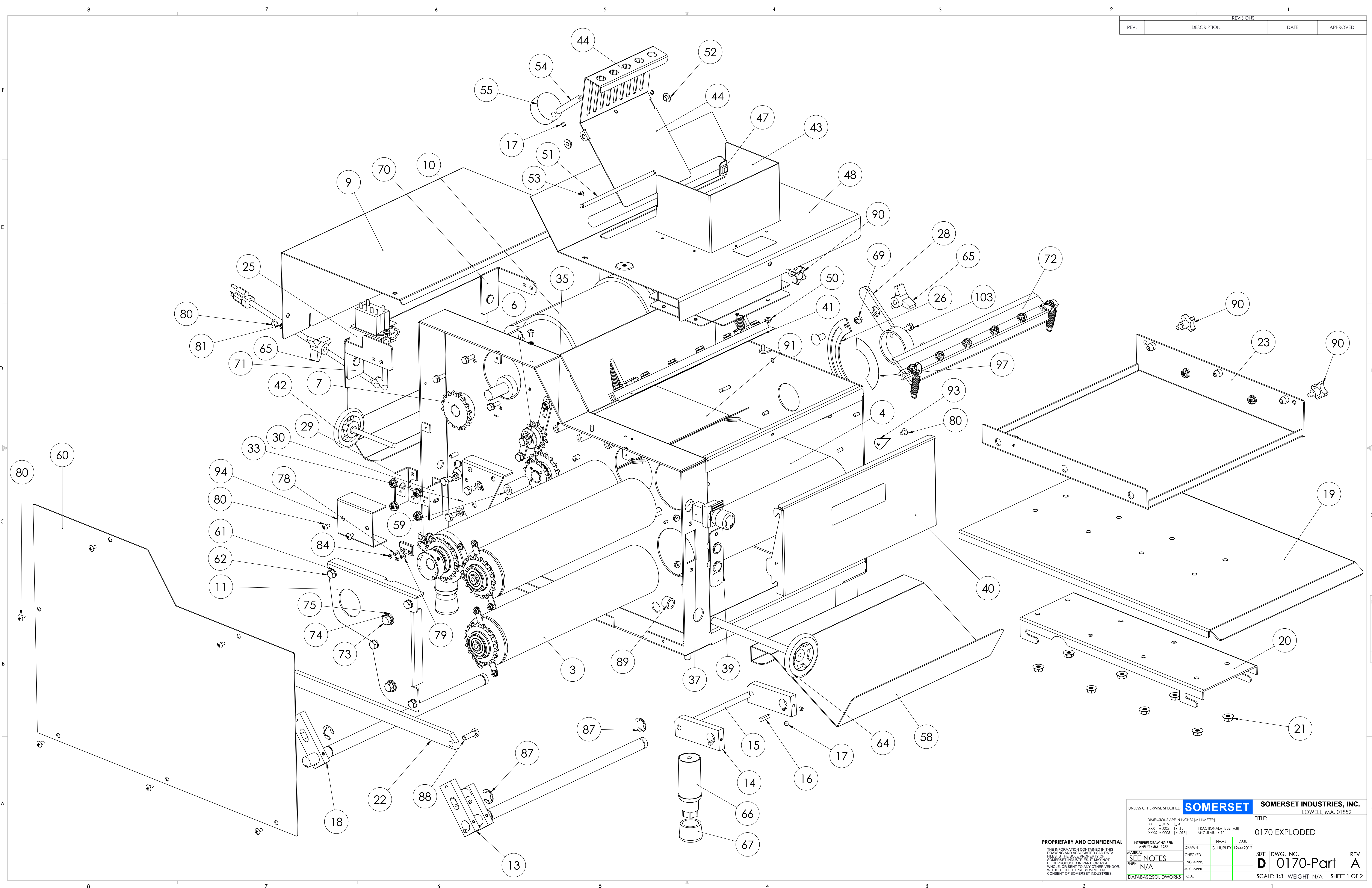
ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	0250-010	FRAME, 0250	1
	0170-012	HOUSING, 0170 LHS	1
	0170-055	STUD, PLATE	3
	0170-036	FILLER PLATE, 012	1
	0500-015	LOCATOR HSG #10	3
F	3010-212	PEM, FHS-440-6	6
	3010-205	PEM, FHS-832-6	6
	3010-204	PEM, FHS-0518-8	13
	3010-206	PEM, FHS 420-12	4
	3010-203	PEM, FHS-207-8	4
	3010-201	PEM, YC3-16144	2
	4000-233	SPACER, HEX 0.5 X 1.0	4
	3000-409	SCREW, 3/8-16X1 HEXHD SS	2
	0170-011	BASE, RHS	1
	3000-409	SCREW, 3/8-16X1 HEXHD SS	2
	3010-206	PEM, FHS 420-12	8
	3010-201	PEM, YC3-16144	2
E	3010-203	PEM, FHS-207-8	4
	0500-015	LOCATOR HSG #10	2
	2000-015	LOCATOR PLATE	1
	0250-022	CHANNEL, FRONT	1
	0250-015	CHANNEL, UPPER SUPPORT	1
	0250-016	CHANNEL, REAR, CUTOUT	1
	0250-013	PARTITION, MOTOR	1
	0250-021	ADJUSTING BRACKET, SIDE PLATE	1
2	2100-400	ROLL ASM UPPER	1
	2000-407	SHAFT, UPPER AND LOWER	1
	2000-457	ROLL SYNTHETIC/PIPE 20"	1
	2000-403	PIPE ROLL 21.110	1
D	2000-451	ROLL ETF 00039TIVAR 20.125	1
	4000-100	BEARING, R12RS ROLL	2
	2000-412	SPROCKET 41B18H ROLL	1
	2100-318	DISC TOP COMPLETE 2100	1
	2100-320	DISC, TOP	1
	2000-023	BRACKET, DISK	2
	3010-302	PIN, 21S 187-125	3
	3000-225	WASHER, NYLATRON 1.50	2
	2000-411	ECCENTRIC, UNIVERSAL	2
3	2000-402	ROLL ASM MIDDLE UHMW 20"	2
	2000-408	SHAFT, MIDDLE 20	1
	2000-457	ROLL SYNTHETIC/PIPE 20"	1
	2000-403	PIPE ROLL 21.110	1
C	2000-451	ROLL ETF 00039TIVAR 20.125	1
	4000-100	BEARING, R12RS ROLL	2
	2000-412	SPROCKET 41B18H ROLL	1
	2000-316	DISC MIDDLE COMPLETE	1
	2000-319	DISC, MIDDLE	1
	2000-023	BRACKET, DISK	2
	3010-302	PIN, 21S 187-125	1
4	4000-250 belt	BELT, CONVEYOR	1
5	0400-300	TENSION ASSY.	1
	4000-011	SPACER .50ID X .78OD X .123 PL	1
	2000-431	SHAFT,ALIGNMENT, IDLER SUPPORT	2
	3000-102	WASHER, LOCK SPLIT 5/16	2
	3000-406	SCREW, 5/16-18 X 3/4 HEXHD GR8	2
B	0400-051	PLATE, TENSION	1
	0400-055	PLATE, TENSION SUPPORT	1
	4000-521	SPROCKET 41B11 W/ BUSHING	1
	4000-501	SPROCKET 41B11H TAKEUP	1
	4000-551	BUSHING 08DU14 GARLOCK	1
	4000-509	SPROCKET, 41B14/41B18	1
	4000-505	SPROCKET 41B18	1
	4000-507	SPROCKET, 41B14	1
	4000-556	BUSHING, 12DU14 GARLOCK	1
	3010-300	PIN, 21S 187-075	4
7	4000-502	SPROCKET 41B16H X 3/4 W/ KEY	1
8	2000-430	SPROCKET 41B11H IDLER	1

6		5	
ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
9	0250-301	LOUVER PANEL, MOTOR	1
10	5000-139	0400 MOTOR ASSEMBLY, BALDOR 3/4 HP	1
	5000-108	GEARMOTOR, BALDOR 3/4HP	1
11	0170-231	ECCENTRIC PLATE	1
12	0250-402	REAR ROLL ASSEMBLY	1
	0250-457	REAR ROLL ASSEMBLY, PRESSED	1
	0250-403	PIPE ROLL	1
	2000-451	ROLL ETF 00039TIVAR 20.125	1
	4000-100	BEARING, R12RS ROLL	2
	0250-408	SHAFT, ADJUSTING ROLL	1
13	0250-404	SHAFT ASSEMBLY, FRONT, PRESSURE PLATE	1
	0250-441	SHAFT, FRONT, PRESSURE PLATE	1
	0170-443	SUPPORT, ADJUSTING NUT	1
	0170-445	SHAFT LEVER, FRONT	1
	0170-445	SHAFT LEVER, FRONT	1
	0170-444	ADJUSTING NUT	1
	4000-531	KEY 3/16 X 7/8 SQ	2
	3000-338	SCREW, 1/4-20 X 1/4 SET HEX	2
14	0170-446	HOLDING ARM	4
15	0170-447	HOLDER, PLATE	2
16	4000-531	KEY 3/16 X 7/8 SQ	4
17	3000-338	SCREW, 1/4-20 X 1/4 SET HEX	13
18	0250-405	REAR SHAFT ASSY, PRESSURE PLATE	1
	0250-441	SHAFT, FRONT, PRESSURE PLATE	1
	0170-445	SHAFT LEVER, FRONT	1
	4000-531	KEY 3/16 X 7/8 SQ	1
	3000-338	SCREW, 1/4-20 X 1/4 SET HEX	1
19	0250-131	PRESSURE PLATE, 19.5IN	1
	3010-204	PEM, FHS-0518-8	10
20	0170-130	HOOK, PRESSURE PLATE	1
21	3000-305	NUT, FLANGE 5/16-18	9
22	0170-449	LINKAGE, PRESSURE PLATE	1
23	0250-019	SLIDING TRAY ASSEMBLY	1
	0250-018	PLATE, SLIDER	1
	4000-412	KNOB, DOCKER SECURING	2
	3000-303	NUT, FLANGE 1/4-20	2
	3010-500	RIVET, 1/8 X .375	1
	4000-150	MAGNET,SAFETY COVER	1
	0170-055	STUD, PLATE	3
	3010-204	PEM, FHS-0518-8	3
24	2100-428	ARM, IDLER	1
25	2000-632	RELAY 110 VAC	1
	2000-328	BRACKET, RELAY	1
	2000-328	BRACKET, RELAY	1
	3010-205	PEM, FHS-832-6	3
	5000-230	HARNESS, POWER MOLDED	1
	5000-150	RELAY, 120 VAC	1
	3000-416	SCREW, 8-32 X 1 PAN HD PH	1
	3000-300	NUT, FLANGE 8-32	3
26	2000-417	PLATE, ADJUST	1
27	2000-418	SPACER TUBING	4
28	2000-423	HANDLE, ROLL ADJUST	1
29	0170-024	BRACKET, TAKE UP LHS	1
	0500-015	LOCATOR HSG #10	1
30	0170-025	BRACKET, TAKE UP	2
	0500-015	LOCATOR HSG #10	1
31	0170-026	BRACKET, TAKE UP SUPPORT	1
	0500-015	LOCATOR HSG #10	1
32	0170-027	COVER, ADJUSTMENT	1
33	0170-037	PLATE, IDLER	1
34	0250-035	REVERSE PLATE	1
35	0170-431	SHAFT,ALIGNMENT, IDLER SUPPORT	2
36	2000-431	SHAFT,ALIGNMENT, IDLER SUPPORT	1
37	5000-226	E-STOP	1
38	5000-228	LABEL, E-STOP	1

ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
39	2000-629	SWITCH PLATE ASSY	1
	2000-330	PLATE, P.B. SWITCH	1
	2000-330	PLATE, P.B. SWITCH	1
	3010-205	PEM, FHS-832-6	2
	5000-202	SWITCH POWER RED	1
	5000-203	SWITCH POWER GREEN	1
40	0250-119.SLDDRW	Guard, front roll ASSY	1
	4000-150	MAGNET,SAFETY COVER	1
	3010-500	RIVET, 1/8 X .375	1
41	0250-502	SCRAPER,COMPLETE #2	1
	0250-520	SHAFT, SCRAPER #2 0250	1
	0250-510	SCRAPER #2, 0250	1
	3010-202	PEM, FHS-0420-16	8
	3000-303	NUT, FLANGE 1/4-20	8
	3010-100	STUD,SCRAPER 21/32 BENT	2
	4000-251	SPRING, SCRAPER	2
	3000-306	NUT, HEX 1/4-20	4
	3010-152	STUD, SCRAPER 2 1/2"	2
42	4000-401	KNOB,TAKE UP ADJUSTMENT	2
43	0170-122	CHUTE ASSEMBLY	1
	0170-061	CHUTE	1
	0170-060	FRONT PLATE, HOPPER	1
44	0170-062	SAFETY DOOR	1
45	3010-216	PEM, FHS-032-6	1
46	4000-301	BUMPER, 3M	2
47	5000-290	BUMPER, HOPPER	2
48	0250-121	COVER, TOP	1
49	3010-205	PEM, FHS-832-6	8
50	3000-300	NUT, FLANGE 8-32	16
51	0170-125	SHAFT, SAFETY DOOR	1
52	5000-289	MICRO PLASTICS 12SWS1018	2
53	3010-400	RING, RET TRUARC 5103-25	2
54	0170-440	SHAFT, COUNTERBALANCE	1
55	0170-433	COUNTER WEIGHT	1
56	3010-500	RIVET, 1/8 X .375	1
57	4000-150	MAGNET,SAFETY COVER	1
58	0250-304	DISCHARGE TRAY	1
59	0170-432	SHAFT TAKE UP SPROCKET	1
60	0170-302	COVER, SIDE	1
61	3000-102	WASHER, LOCK SPLIT 5/16	8
62	3000-405	SCREW, 5/16-18 X 1/2 HEXHD	8
63	3000-303	NUT, FLANGE 1/4-20	10
64	4000-404	ADJUSTING KNOB, PRESSURE PLATE	1
65	4000-400	KNOB, LOCKING	3
66	2000-415	LEG, ASM COMPLETE	4
	4000-200	INSERT, LEG ADJ	1
	2000-413	LEG, WELDMENT TUBE&PLUG	1
	2000-413A	LEG COLUMN	1
	2000-413B	INSERT, LEG MOUNTING	1
67	4000-300	LEG TIP RUBBER	4
68	3000-408	SCREW, 3/8-16 X 3/4 CARRIAGE BOLT	1
69	3000-302	NUT, ACORN 1/4-20	2
70	0170-028	BRACKET, REVERSING PLATE, LHS	1
	3010-219	PEM, HFH-0616-16ZI	1
71	0170-029	BRACKET, REVERSING PLATE, RHS	1
	3010-219	PEM, HFH-0616-16ZI	1
72	2000-501	SCRAPER,COMPLETE #2	1
	2000-521	SHAFT, SCRAPER #2 2000	1
	2000-511	SCRAPER #2	1
	3010-202	PEM, FHS-0420-16	8
	3000-303	NUT, FLANGE 1/4-20	8
	3010-100	STUD,SCRAPER 21/32 BENT	2
	4000-251	SPRING, SCRAPER	2
	3000-306	NUT, HEX 1/4-20	2
73	3000-409	SCREW, 3/8-16X1 HEXHD SS	4
74	3000-103	WASHER, LOCK SPLIT 3/8	4
75	3000-201	WASHER, FLAT 3/8	4
76	5000-276	BUSHING, 90 STR REL HEYCO1320	1

ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
77	2000-631	SWITCH ELECTRONIC COMPLETE	1
	5000-225	SWITCH, ELECTRONIC	1
78	3000-104	WASHER, LOCK SPLIT #4	6
79	3000-204	WASHER, FLAT #4	6
80	3000-402	SCREW, 10-32 X 3/8 TRUSS PH SS	15
81	3000-101	WASHER LOCK #10 INT TOOTH	14
82	3000-468	NUT, NYLON INSERT, 5/16-18	2
83	5000-225	SWITCH, ELECTRONIC	2
84	3000-309	NUT, HEX 4-40	6
85	3000-417	SCREW, 1/4-28 X 3/4 HEXHD	4
86	3000-106	WASHER, LOCK SPLIT 1/4	4
87	4000-325	E-CLIP MCMASTER # 97431A360	4
88	3000-414	SCREW, 5/16-18 X 1 HEXHD	2
89	0170-473	collar, pressure plate adjusting	1
90	4000-413	KNOB, 3/8" long	5
91	4000-381	CHAIN, CURLING	1
92	3010-450	RING, CHAIN SECURING	2
93	0170-017	Indicator, pressure plate	1
94	0170-063	COVER, TENSION ADJUSTMENT	1
95	4000-365	CHAIN, DRIVEN, 41 RIV 70 INCL CL	1
96	4000-366	CHAIN, DRIVE, 41 RIV 46 INCL CL	1
97	5000-315	LABEL, CW INDICATOR GRADUATED	2
98	5000-313	LABEL, "KEEP FINGERS..."	1
99	5000-312	LABEL, "SOMERSET" 3"	1
100	5000-314	LABEL, "DO NOT OPERATE..."	1
101	5000-317	LABEL, NSF	1
102	5000-311	LABEL, ETL	1
103	3000-404	SCREW, 1/4-20 X 3/4 HEXHD	2
104	0170-127	PRESSURE PLATE ASSY, 10.5IN	1
	0170-132	PRESSURE PLATE 10.5IN	1
	3010-204	PEM, FHS-0518-8	8
	0170-130	HOOK, PRESSURE PLATE	1
	3000-305	NUT, FLANGE 5/16-18	8
105	0170-128	PRESSURE PLATE ASSY, 6.5IN	1
	0170-133	PRESSURE PLATE 6.5IN	1
	3010-204	PEM, FHS-0518-8	8
	0170-130	HOOK, PRESSURE PLATE	1
	3000-305	NUT, FLANGE 5/16-18	8
106	0170-234	GUIDE PLATE ASSY, LHS	1
	0170-233	GUIDE PLATE, LHS	1
	0170-023	BRACKET, SIDE PLATE	1
	3010-206	PEM, FHS 420-12	2
	3000-303	NUT, FLANGE 1/4-20	2
107	0170-236	GUIDE PLATE ASSY, RHS	1
	0170-235	GUIDE PLAT, RHS	1
	0170-023	BRACKET, SIDE PLATE	1
	3010-206	PEM, FHS 420-12	2
	3000-303	NUT, FLANGE 1/4-20	2
108	0170-120	CHUTE, STANDARD (SA)	1
	0170-122	CHUTE ASSEMBLY	1
	0170-061	CHUTE	1
	0170-060	FRONT PLATE, HOPPER	1
	0250-121	COVER, TOP	1
	3010-205	PEM, FHS-832-6	8
	0170-062	SAFETY DOOR	1
	3000-300	NUT, FLANGE 8-32	8
	0170-125	SHAFT, SAFETY DOOR	1
	5000-289	MICRO PLASTICS 12SWS1018	2
	3010-400	RING, RET TRUARC 5103-25	2
	0170-440	SHAFT, COUNTERBALANCE	1
	0170-433	COUNTER WEIGHT	1
	3000-338	SCREW, 1/4-20 X 1/4 SET HEX	1
	3010-500	RIVET, 1/8 X .375	1
	4000-150	MAGNET,SAFETY COVER	1
	5000-290	BUMPER, HOPPER	2
	4000-301	BUMPER, 3M	1

UNLESS OTHERWISE SPECIFIED:		SOMERSET		SOMERSET INDUSTRIES, INC.	
DIMENSIONS ARE IN INCHES (MILLIMETER) XXX ± .015 (± .4) XXXX ± .005 (± .13) XXXXX ± .0005 (± .013)		FRACTIONAL ± 1/32 (± .8) ANGULAR: ± 1°		TITLE: 0250 EXPLODED	
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MATERIAL: FINISH: SEE NOTES N/A		DRAWN: G. HURLEY CHECKED: ENG APPR: MFG APPR: G.A.		SIZE DWG. NO. D 0250-PART A	
DATABASE: SOLIDWORKS				SCALE: 1:2.89 WEIGHT N/A SHEET 2 OF 2	



REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED

UNLESS OTHERWISE SPECIFIED: **SOMERSET** **SOMERSET INDUSTRIES, INC.**
LOWELL, MA. 01852

TITLE:
0170 EXPLODED

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INTERPRET DRAWING PER: AND 11/4/2012	DRAWN: G. HURLEY	NAME	DATE
MATERIAL SEE NOTES	CHECKED		
FINISH N/A	ENG APPR.		
DATABASE:SOLIDWORKS	MFG APPR.		
	G.A.		

SIZE	DWG. NO.	REV
D	0170-Part	A
SCALE: 1:3	WEIGHT N/A	SHEET 1 OF 2

8				7				6				5				4				3				2				1			
ITEM NO.	PART NUMBER	DESCRIPTION		QTY.	ITEM NO.	PART NUMBER	DESCRIPTION		QTY.	ITEM NO.	PART NUMBER	DESCRIPTION		QTY.	ITEM NO.	PART NUMBER	DESCRIPTION		QTY.	ITEM NO.	PART NUMBER	DESCRIPTION		QTY.	ITEM NO.	PART NUMBER	DESCRIPTION		QTY.		
F	1	0170-010	FRAME, 0170		1		0170-403	PIPE ROLL		1		0170-060	FRONT PLATE, HOPPER		1		3010-204	PEM, FHS-0518-8		8		0170-130	HOOK, PRESSURE PLATE		1		0170-234	GUIDE PLATE ASSY, LHS		1	
		0170-012	HOUSING, 0170 LHS		1		1500-451	ROLL ETF 00039TIVAR 20.125		1		0170-062	SAFETY DOOR		1		0170-130	HOOK, PRESSURE PLATE		1		3000-305	NUT, FLANGE 5/16-18		8	106	0170-234	GUIDE PLATE ASSY, LHS		1	
		0170-055	STUD, PLATE		3		4000-100	BEARING, R12RS ROLL		2		3010-216	PEM, FHS-032-6		1		0170-233	GUIDE PLATE, LHS		1		0170-023	BRACKET, SIDE PLATE		1		0170-233	GUIDE PLAT, RHS		1	
		0170-036	FILLER PLATE, 012		1		0170-408	SHAFT, ADJUSTING ROLL		1		4000-301	BUMPER, 3M		1		0170-023	BRACKET, SIDE PLATE		1		3010-206	PEM, FHS 420-12		2	107	0170-236	GUIDE PLATE ASSY, RHS		1	
		0500-015	LOCATOR HSG #10		3	13	0170-404	SHAFT ASSEMBLY, FRONT, PRESSURE PLATE		1		5000-290	BUMPER, HOPPER		2		3000-303	NUT, FLANGE 1/4-20		2		0170-122	CHUTE ASSEMBLY		1		0170-235	GUIDE PLATE, RHS		1	
		3010-212	PEM, FHS-440-6		6		0170-441	SHAFT, FRONT, PRESSURE PLATE		1		0170-121	COVER, TOP		1		0170-061	CHUTE		1		3000-303	NUT, FLANGE 1/4-20		2		0170-023	BRACKET, SIDE PLATE		1	
		3010-205	PEM, FHS-832-6		6		0170-443	SUPPORT, ADJUSTING NUT		1		3010-205	PEM, FHS-832-6		8		0170-125	SHAFT, SAFETY DOOR		1		0170-120	CHUTE, STANDARD (SA)		1	108	0170-120	CHUTE, STANDARD (SA)		1	
		3010-204	PEM, FHS-0518-8		13		0170-445	SHAFT LEVER, FRONT		1		50	3000-300	NUT, FLANGE 8-32		16		5000-289	MICRO PLASTICS 12SWS1018		2		0170-122	CHUTE ASSEMBLY		1		3010-206	PEM, FHS 420-12		2
		3010-206	PEM, FHS 420-12		4		0170-445	SHAFT LEVER, FRONT		1		51	0170-125	SHAFT, SAFETY DOOR		1		3010-400	RING, RET TRUARC 5103-25		2		0170-060	FRONT PLATE, HOPPER		1		3000-303	NUT, FLANGE 1/4-20		2
		3010-203	PEM, FHS-207-8		4		0170-444	ADJUSTING NUT		1		52	5000-289	MICRO PLASTICS 12SWS1018		2		5000-289	MICRO PLASTICS 12SWS1018		2		0170-062	SAFETY DOOR		1		0170-440	SHAFT, COUNTERBALANCE		1
E		3010-201	PEM, YC3-16144		2		4000-531	KEY 3/16 X 7/8 SQ		2		53	3010-400	RING, RET TRUARC 5103-25		2		4000-200	INSERT, LEG ADJ		1		0170-433	COUNTER WEIGHT		1		0170-433	COUNTER WEIGHT		1
		4000-233	SPACER, HEX 0.5 X 1.0		4		3000-338	SCREW, 1/4-20 X 1/4 SET HEX		4		54	0170-440	SHAFT, COUNTERBALANCE		1		2000-413A	LEG COLUMN		1		3000-300	NUT, FLANGE 8-32		8		3010-500	RIVET, 1/8 X .375		1
		3000-409	SCREW, 3/8-16X1 HEXHD SS		2	14	0170-446	HOLDING ARM		4		55	0170-433	COUNTER WEIGHT		1		2000-413B	INSERT, LEG MOUNTING		1		0170-125	SHAFT, SAFETY DOOR		1		4000-150	MAGNET,SAFETY COVER		1
		0170-011	BASE, RHS		1	15	0170-447	HOLDER, PLATE		2		56	3010-500	RIVET, 1/8 X .375		1		4000-300	LEG TIP RUBBER		4		5000-289	MICRO PLASTICS 12SWS1018		2		5000-290	BUMPER, HOPPER		2
		3000-409	SCREW, 3/8-16X1 HEXHD SS		2	16	4000-531	KEY 3/16 X 7/8 SQ		4		57	4000-150	MAGNET,SAFETY COVER		1		4000-150	MAGNET,SAFETY COVER		1		3010-400	RING, RET TRUARC 5103-25		2		4000-301	BUMPER, 3M		1
		3010-206	PEM, FHS 420-12		8	17	3000-338	SCREW, 1/4-20 X 1/4 SET HEX		13		58	0170-304	DISCHARGE TRAY		1		5000-289	MICRO PLASTICS 12SWS1018		2		0170-440	SHAFT, COUNTERBALANCE		1					
		3010-201	PEM, YC3-16144		2	18	0170-405	REAR SHAFT ASSY, PRESSURE PLATE		1		59	0170-432	SHAFT TAKE UP SPROCKET		1		3010-400	RING, RET TRUARC 5103-25		2		0170-433	COUNTER WEIGHT		1					
		3010-203	PEM, FHS-207-8		4		0170-441	SHAFT, FRONT, PRESSURE PLATE		1		60	0170-302	COVER, SIDE		1		0170-440	SHAFT, COUNTERBALANCE		1		3000-338	SCREW, 1/4-20 X 1/4 SET HEX		1					
		0500-015	LOCATOR HSG #10		2		0170-445	SHAFT LEVER, FRONT		1		61	3000-102	WASHER, LOCK SPLIT 5/16		8		0170-433	COUNTER WEIGHT		1		3010-500	RIVET, 1/8 X .375		1					
		2000-015	LOCATOR PLATE		1		4000-531	KEY 3/16 X 7/8 SQ		1		62	3000-405	SCREW, 5/16-18 X 1/2 HEXHD		8		3000-300	NUT, FLANGE 8-32		8		4000-150	MAGNET,SAFETY COVER		1					
		0170-022	CHANNEL, FRONT		1		3000-338	SCREW, 1/4-20 X 1/4 SET HEX		2		63	3000-303	NUT, FLANGE 1/4-20		10		5000-289	MICRO PLASTICS 12SWS1018		2		5000-290	BUMPER, HOPPER		2					
D		0170-015	CHANNEL, UPPER SUPPORT		1	19	0170-131	PRESSURE PLATE, 14.5IN		1		64	4000-404	ADJUSTING KNOB, PRESSURE PLATE		1		3010-500	RIVET, 1/8 X .375		1		4000-150	MAGNET,SAFETY COVER		1					
		0170-016	CHANNEL, REAR, CUTOUT		1		3010-204	PEM, FHS-0518-8		8		65	4000-400	KNOB, LOCKING		3		0170-440	SHAFT, COUNTERBALANCE		1		5000-289	MICRO PLASTICS 12SWS1018		2					
		0170-013	PARTITION, MOTOR		1	20	0170-130	HOOK, PRESSURE PLATE		1		66	2000-415	LEG, ASM COMPLETE		4		0170-433	COUNTER WEIGHT		1		3010-400	RING, RET TRUARC 5103-25		2					
		0170-021	ADJUSTING BRACKET, SIDE PLATE		1	21	3000-305	NUT, FLANGE 5/16-18		9			4000-200	INSERT, LEG ADJ		1		3000-303	NUT, FLANGE 1/4-20		6		0170-440	SHAFT, COUNTERBALANCE		1					
	2	1500-400	ROLL ASM UPPER		1	22	0170-449	LINKAGE, PRESSURE PLATE		1			2000-413A	LEG COLUMN		1		3000-306	NUT, HEX 1/4-20		2		0170-433	COUNTER WEIGHT		1					
		1550-407	SHAFT, UPPER AND LOWER		1	23	0170-019	SLIDING TRAY ASSEMBLY		1			2000-413B	INSERT, LEG MOUNTING		1		4000-251	SPRING, SCRAPER		2		3000-338	SCREW, 1/4-20 X 1/4 SET HEX		1					
		1500-450	ROLL SYNTHETIC/PIPE		1		0170-018	PLATE, SLIDER		1			4000-300	LEG TIP RUBBER		4		3010-500	RIVET, 1/8 X .375		1		4000-150	MAGNET,SAFETY COVER		1					
		1500-403	PIPE ROLL		1		4000-412	KNOB, DOCKER SECURING		2		67	4000-300	LEG TIP RUBBER		4		5000-289	MICRO PLASTICS 12SWS1018		2		5000-290	BUMPER, HOPPER		2					
		1500-451	ROLL ETF 00039TIVAR 20.125		1		3000-303	NUT, FLANGE 1/4-20		2		68	3000-408	SCREW, 3/8-16 X 3/4 CARRIAGE BOLT		1		3010-400	RING, RET TRUARC 5103-25		2		4000-150	MAGNET,SAFETY COVER		1					
		4000-100	BEARING, R12RS ROLL		2		3010-500	RIVET, 1/8 X .375		1		69	3000-302	NUT, ACORN 1/4-20		2		0170-440	SHAFT, COUNTERBALANCE		1		5000-289	MICRO PLASTICS 12SWS1018		2					
		2000-412	SPROCKET 41B18H ROLL		1		4000-150	MAGNET,SAFETY COVER		1		70	0170-028	BRACKET, REVERSING PLATE, LHS		1		3010-500	RIVET, 1/8 X .375		1		5000-290	BUMPER, HOPPER		2					
C		2100-318	DISC TOP COMPLETE 2100		1		0170-055	STUD, PLATE		3			3010-219	PEM, HFH-0616-16ZI		1		3010-500	RIVET, 1/8 X .375		1		5000-289	MICRO PLASTICS 12SWS1018		2					
		2100-320	DISC, TOP		1		3010-204	PEM, FHS-0518-8		3		71	0170-029	BRACKET, REVERSING PLATE, RHS		1		3010-500	RIVET, 1/8 X .375		1		5000-290	BUMPER, HOPPER		2					
		2000-023	BRACKET, DISK		2	24	2100-428	ARM, IDLER		1			3010-219	PEM, HFH-0616-16ZI		1		3010-500	RIVET, 1/8 X .375		1		5000-290	BUMPER, HOPPER		2					
		3010-302	PIN, 21S 187-125		3	25	2000-632	RELAY 110 VAC		1		72	0170-501	SCRAPER COMPLETE #1		1		3010-500	RIVET, 1/8 X .3												