

BUSKRO®

BK701 Vacuum Table Extension Manual

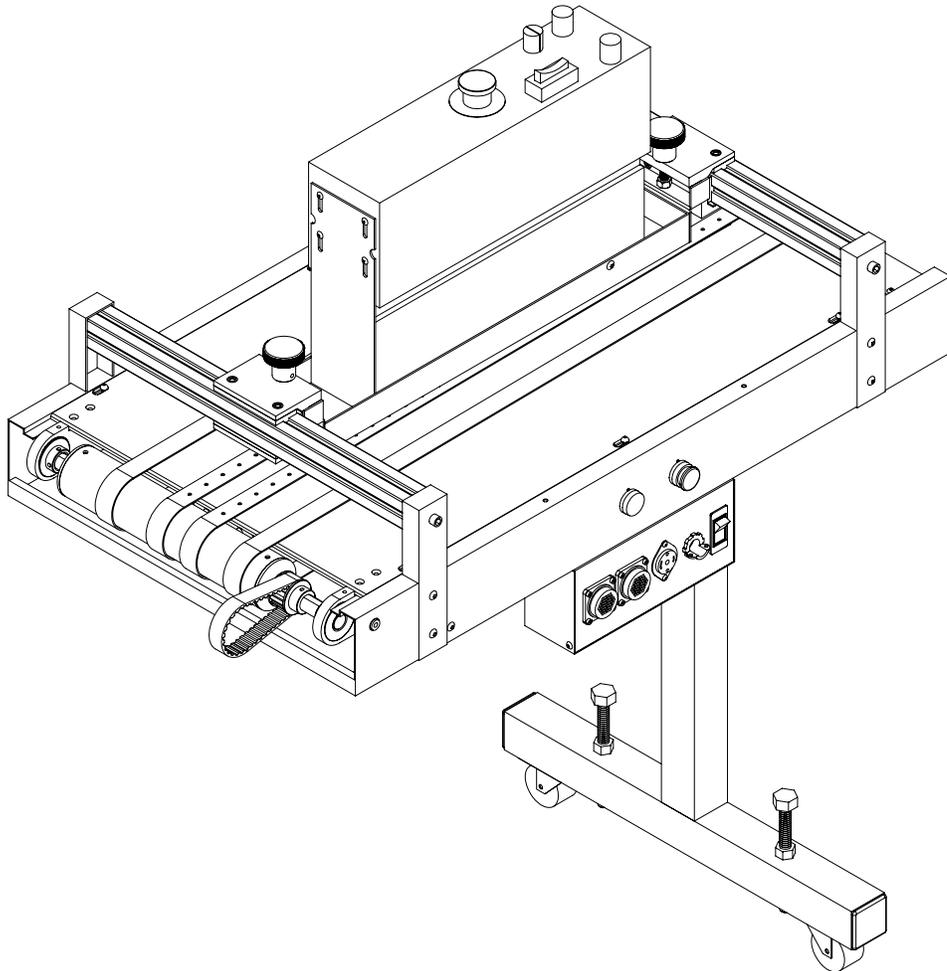


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Chapter

1

General Information

1.1 BK701 Base Specifications

1.1.1 Product Handling

Item	Specification	Specification
Minimum	3.0" x 5.0"	76 mm x 127 mm
Maximum	17.0" x 17.0"	432 mm x 432 mm
Thickness	As Base	As Base

1.1.2 Physical

Item	Specification	Specification
Overall Length	41.42"	1052 mm
Overall Height	34.32" to 39.82"	872 to 1011 mm
Tabletop Height	33" to 38.5"	838 to 978 mm
Overall Width	23.23"	590 mm
Tabletop Length	31.54"	801 mm
Overall Conveyor Length	36"	914 mm
Tabletop Width	19"	483 mm
Weight	81.4 lb	37 kg

1.1.3 Production Rate (depends on the Base)

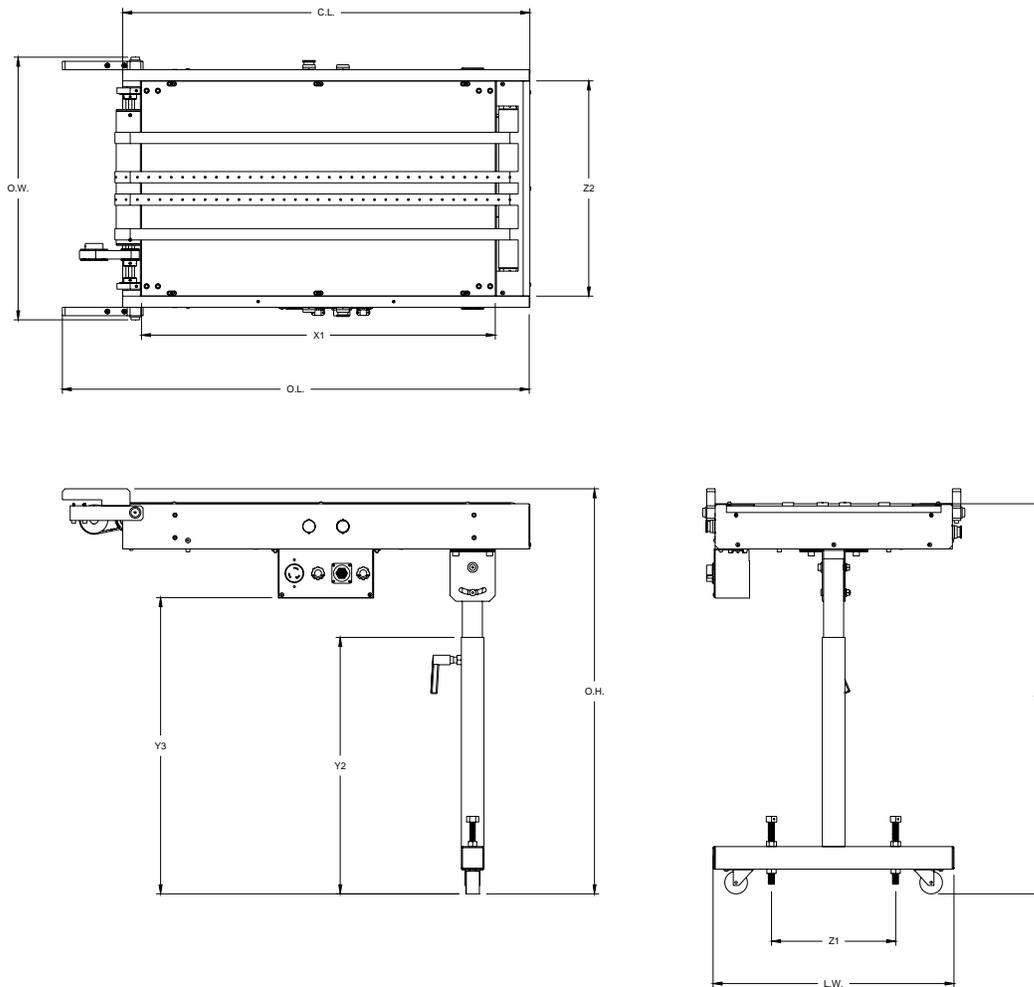
Item	Specification	Specification
Belt Speed	0 to 600 ft/min	0 to 3 m/s
Cycle Speed	0 to 30,000 pph	

1.1.4 Operator Controls

Item	Specification
Machine Pushbuttons	Start, Stop, Air Blower Switch

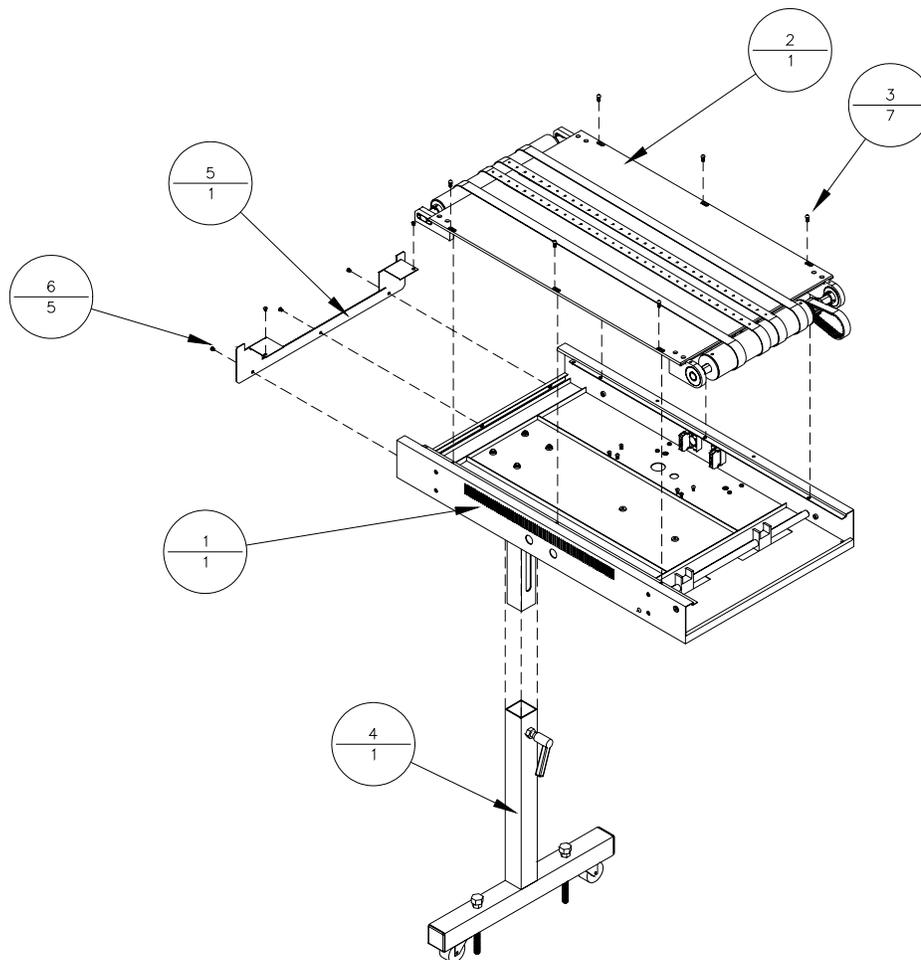
1.1.5 System Connectors

Item	Specification
Inline Remote	2 x 37 pin, 23-37 receptacle Amp #206306-1
Main Power Receptacle	2 pole, NEMA ML-2R, 15A, 125 V
Box Connectors	3/8" Cable (air blower power supply)

Table 1.1: *BK701 General Dimensions*

Symbol	Description	Dimensions	
O.W.	Overall Width	23.23"	590 mm
O.L.	Overall Length	41.42"	1052 mm
O.H.	Overall Height	34.32" to 39.82"	872 to 1011 mm
L.W.	Overall Leg Width	21.34"	542 mm
C.L.	Overall Conveyor Length	36"	914 mm
X1	Tabletop Length	31.54"	801 mm
Y1	Tabletop Height	33" to 38.50"	838 to 978 mm
Y2	Leg Height	22.69"	576 mm
Y3	Electrical Plate Height	26.20"	665 mm
Z1	Leveling Foot Width	11"	279 mm
Z2	Tabletop Width	19"	483 mm

1.2 BK701 Vacuum Table Extension, 3FT

Table 1.2: *BK701 Vacuum Table Extension, 3 FT*

Item	Part Number	Quantity	Description	Reference
1	9100324A	1	Chassis Assembly	
2	9100320A	1	Tabletop Assembly	
3	404530	7	Screw, BHCS 10-32 UNF x 1/2"	
4	9100484A	1	"T" Leg Assembly	
5	9100323	1	Rear Roller Cover	
6	404510	5	Screw, BHCS 10-32 UNF x 1/4"	

Chapter

2

Options

2.1 BK701-460 Vacuum Table Extension, 3FT

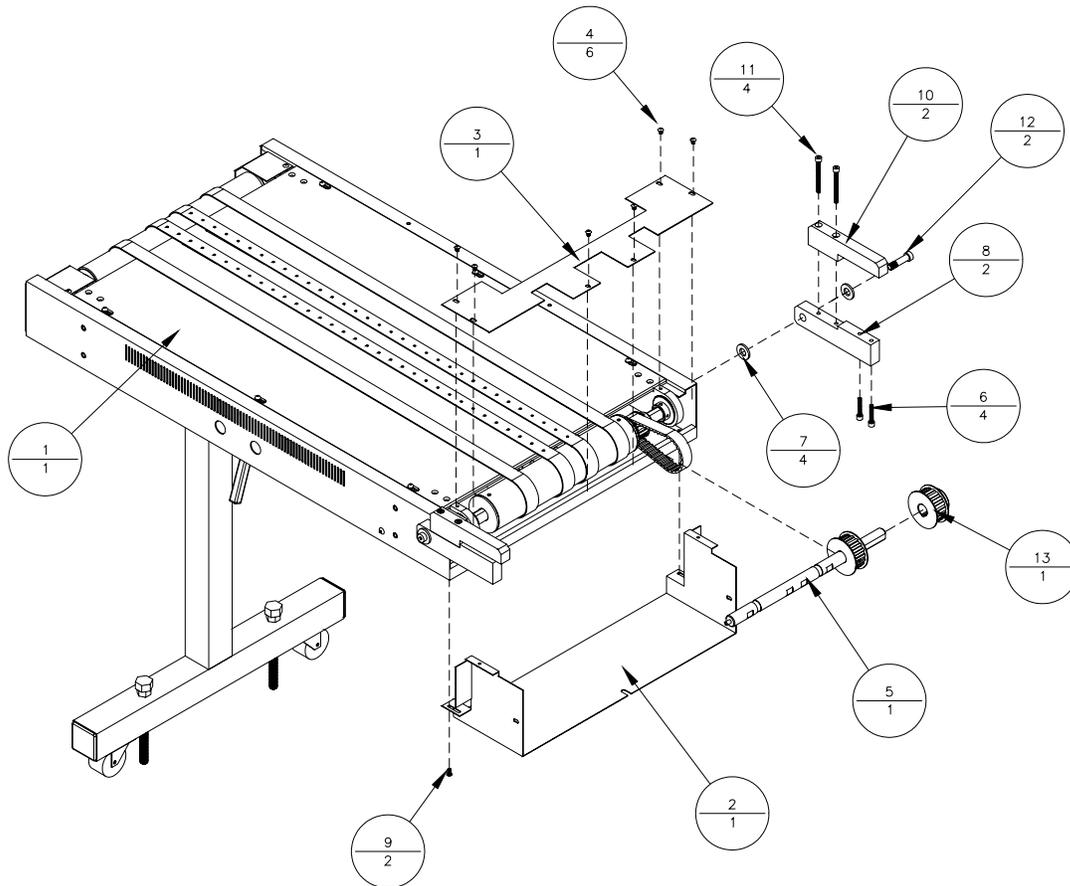


Table 2.1: BK701-460 Vacuum Table Extension

Item	Part Number	Quantity	Description	Reference
1	BK701	1	Vacuum Table Extension	
2	9100835	1	Lower Gap Cover (BK460/BK701)	
3	9100834	1	Gap Cover (BK460/BK701)	
4	404510	6	Screw, BHCS 10-32 UNF x 1/4"	
5	9100836A	1	Driveshaft Assembly (BK460/BK701)	
6	405275	4	Screw, SHCS 1/4-20 UNC x 1 1/4"	
7	440030	4	Washer, 1/2" I.D.	
8	9100939	2	Mounting Arm, (BK460/BK701)	
9	404520	2	Screw, BHCS 10-32 UNF x 3/8"	
10	9100805	2	Tabletop Mounting Arm Clamp	
11	405287	4	Screw, SHCS 1/4-20 UNC x 2 1/2"	
12	417170	2	Shoulder Bolt, 1/2" x 1" (3/8-16)	
13	116301	1	Pulley, 18LB075 x 3/4	

2.1.1 BK701-460 Installation Instructions

Note: Refer to the diagram and Table 2.1 on page 2-1 for the items listed below.

1. Remove the outfeed roller cover from the BK460 base.
2. Replace the existing drive shaft with the new drive shaft (Item 5) and attach all rollers as before. Note that the new drive shaft is longer than the original one.
3. Mount the supplied pulley onto the end of the drive shaft, with the flange toward the rollers.
4. Carefully mount the timing belt on the pulley. Mount the lower gap cover (Item 2) to make sure there is enough clearance but do not yet tighten the mounting screws. Install both clamps (Item 10), but do not tighten the mounting screws.
5. Adjust the positions of the rollers on the base unit, the front conveyor roller on the extension table and both pulleys to make sure the belt runs true and tighten all set screws. Move the clamps to their proper positions.
6. Adjust the tension of the timing belt by the tightening the six screws on top of the conveyor tabletop and by pushing the conveyor toward the base machine.
7. Tighten the four screws (Item 6, two on each side) at the bottom of the clamps once they are in the correct position.
8. Tighten the four screws holding the lower gap cover in place.
9. Install the upper gap cover (Item 3) and tighten the six mounting screws (Item 4).
10. Make sure no rotating parts touch any stationary parts and the mouse cord is pulled through the cutout at the center of the lower gap cover.
11. Do the wiring according to schematic and instructions for the BK460.

2.2 BK701-660 Vacuum Table Extension, 3FT

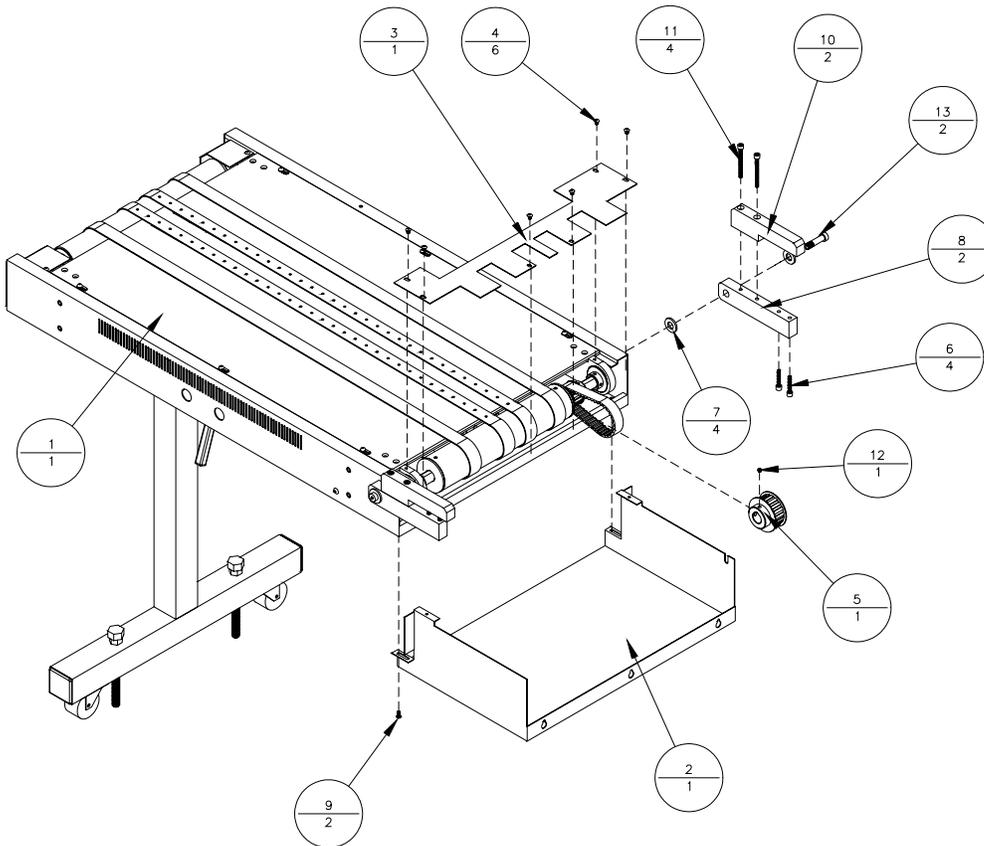


Table 2.2: *BK701-660 Vacuum Table Extension, 3 FT*

Item	Part Number	Quantity	Description	Reference
1	BK701	1	Vacuum Table Extension	
2	9100800	1	Lower Gap Cover (BK660/BK701)	-use 3 existing screws
3	9100681	1	Gap Cover (BK660/BK701)	
4	404510	6	Screw, BHCS 10-32 UNF x 1/4"	
5	116301	1	Pulley, 18LB075 x 3/4	(*)
6	405275	4	Screw, SHCS 1/4-20 UNC x 1 1/4"	
7	440030	4	Washer, 1/2" I.D.	
8	9100680	2	Mounting Arm	
9	404520	2	Screw, BHCS 10-32 UNF x 3/8"	
10	9100805	2	Tabletop Mounting Arm Clamp	
11	405287	4	Screw, SHCS 1/4-20 UNC x 2 1/2"	
12	404807	1	Screw, SHSS 10-32 UNF x 3/16"	-replaced set screw
13	417170	2	Shoulder Bolt, 1/2" x 1" (3/8-16)	

* attached onto Base outfit shaft

2.2.1 BK701-660 Installation Instructions

Note: Refer to the diagram and Table 2.2 on page 2-3 for the items listed below.

1. Remove the outfeed roller cover from the BK660 (640) base.
2. Remove the encoder from the end of the existing drive shaft.
3. Replace the setscrew on the encoder with the 3/16" set screw provided.
Note that shorter setscrew provides enough clearance for the pulley which will be attached over the end of drive shaft.
4. Loosen the first roller and move it toward other rollers.
5. Attach the pulley (Item 5) with the flange toward rollers and move it toward the loose rollers as much as possible.
6. Carefully mount the timing belt on the pulley and make sure there is enough clearance for the lower gap cover (Item 2). Mount the gap cover using three of the mounting screws previously used for the original outfeed roller cover and tighten the screws very lightly to allow for adjustment once the extension is attached. These screws will not be accessible any more once the extension unit is attached. Mount both clamps (Item 10).
7. Re-install the encoder at its appropriate location and tighten the setscrew.
8. Slide the pulley (Item 5) over the setscrew of the encoder, as close as possible to the encoder. The pulley will be moved away from the encoder again during the next step and the encoder's setscrew will then be exposed.
9. Adjust the positions of the pulley and the rollers on the base unit, and the front conveyor roller and pulley on the extension table to make sure the belt runs true and tighten all set screws. Move the clamps to their proper positions.
10. Adjust the tension of the timing belt by the tightening the six screws on top of the conveyor tabletop and by pushing the conveyor toward the base machine.
11. Tighten the four screws (Item 6, two on each side) from the bottom of the clamps once they are in the correct position.
12. Fasten the lower gap cover to the table extension unit with two screws (Item 9) and tighten. The other three screws holding the cover to the base unit cannot be tightened.
13. Install the upper gap cover (Item 3).
14. Make sure no rotating parts touch any stationary parts and the mouse cord is pulled through the cutout at the right upper corner (on Item 2 close to Item 5 in the drawing) of the lower gap cover.
15. Do the wiring according to schematic and instructions for the BK660.

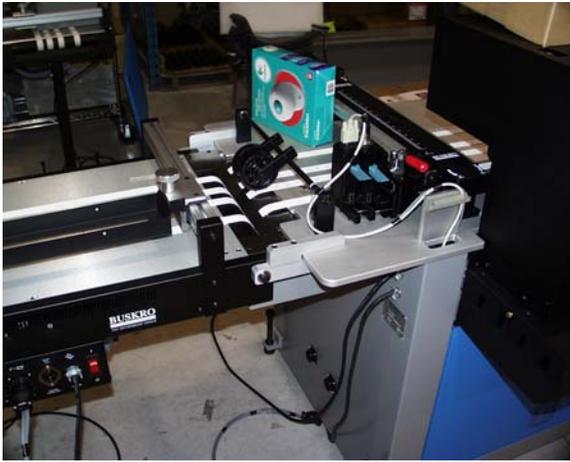


Figure 1: Extension Table attached to the base.

Figure 2: Positions of the pulleys, roller and encoder when moved before proper belt installation.

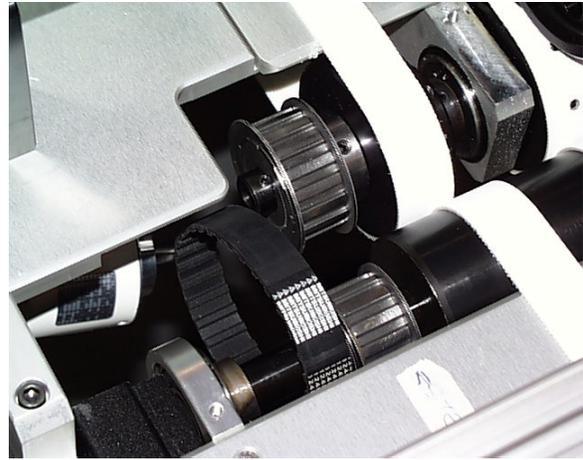
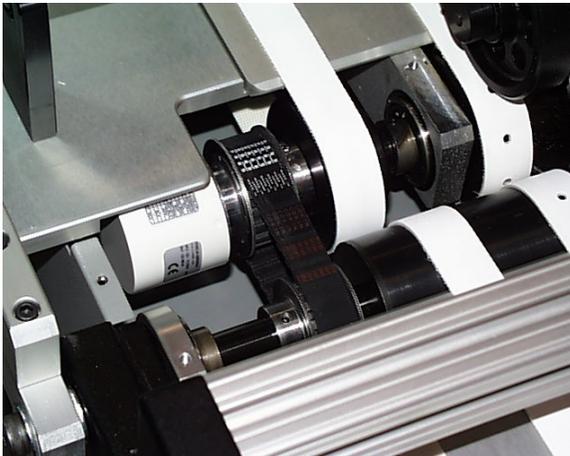


Figure 3: Positions of the pulleys, roller and encoder after the belt was properly installed.



Chapter

3

Field Upgrade Kits

3.1 BK702-400 Vacuum Table Extension, 3FT

a) Air Blower included

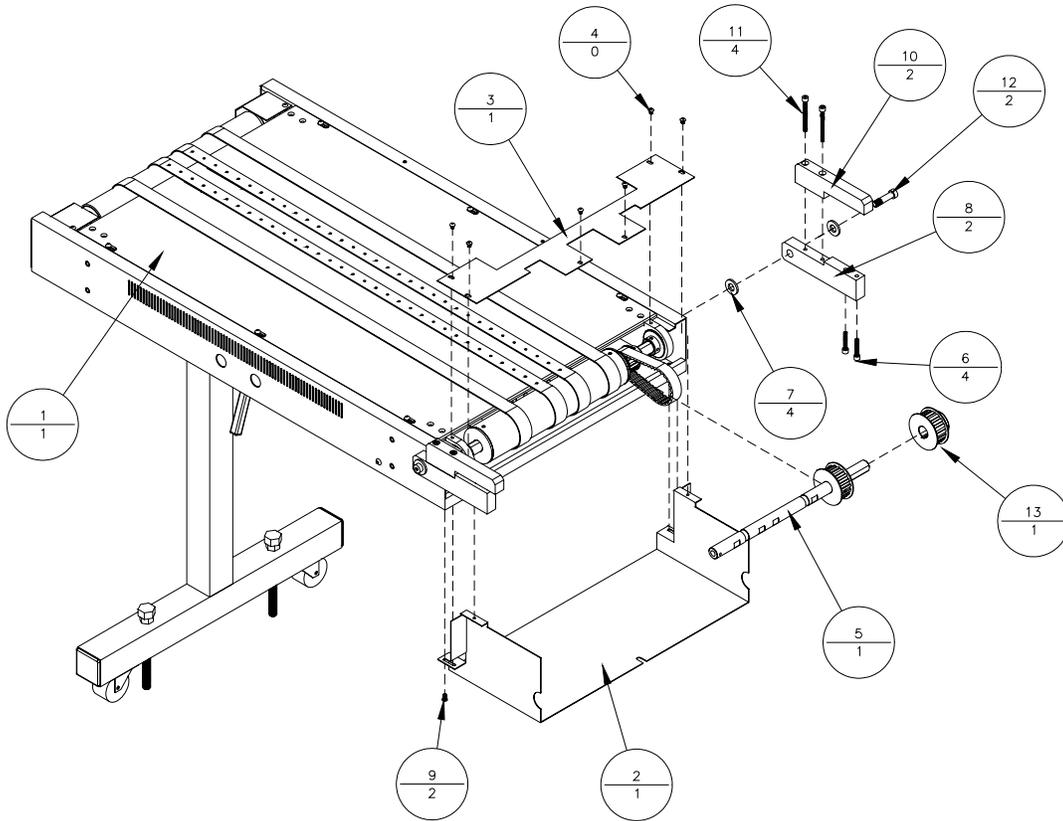


Table 3.1: BK702-400 Vacuum Table Extension, 3 FT

Item	Part Number	Quantity	Description	Reference
1	BK701	1	Vacuum Table Extension	
2	9100838	1	Lower Gap Cover (BK400/BK701)	
3	9100837	1	Gap Cover (BK400/BK701)	
4	404510	6	Screw, BHCS 10-32 UNF x 1/4"	
5	9100802A	1	Drive shaft Assembly (BK400/BK701)	
6	405275	4	Screw, SHCS 1/4-20 UNC x 1 1/4"	
7	440030	4	Washer, 1/2" I.D.	
8	9100865	2	Mounting Arm, (BK400/BK701)	
9	404520	2	Screw, BHCS 10-32 UNF x 3/8"	
10	9100805	2	Tabletop Mounting Arm Clamp	
11	405287	4	Screw, SHCS 1/4-20 UNC x 2 1/2"	
12	417170	2	Shoulder Bolt, 1/2" x 1" (3/8-16)	
13	116301	1	Pulley, 18LB075 x 3/4	

3.1.a) Air Blower

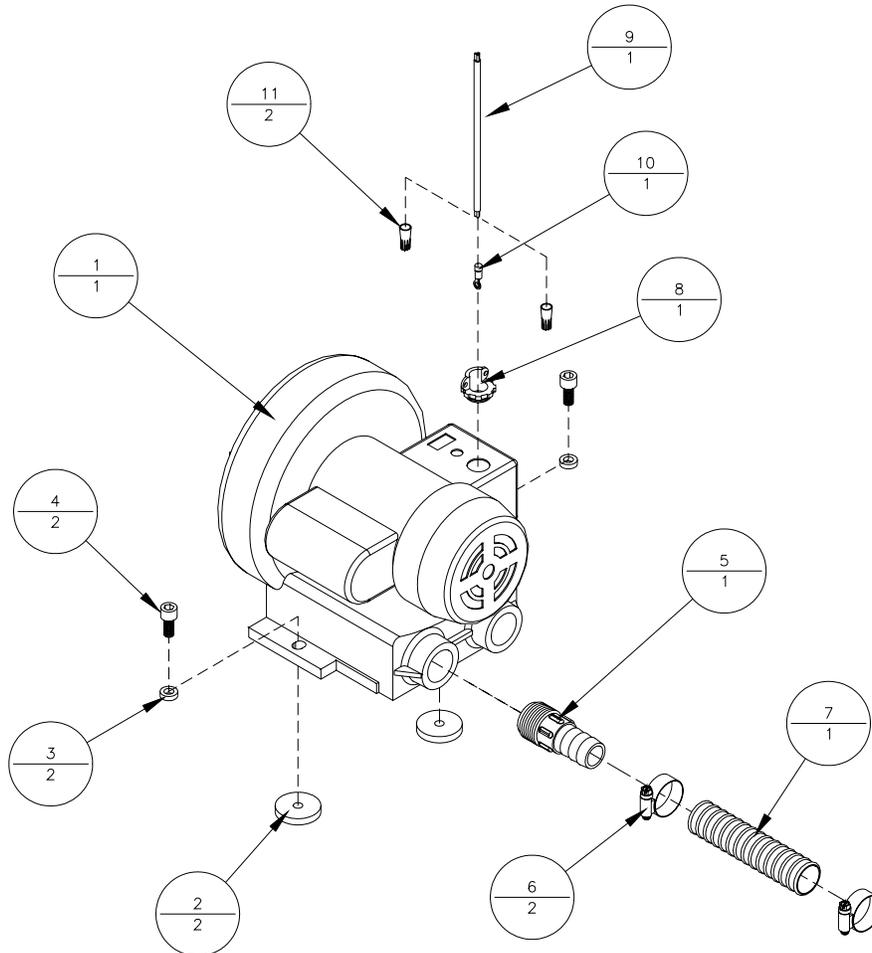
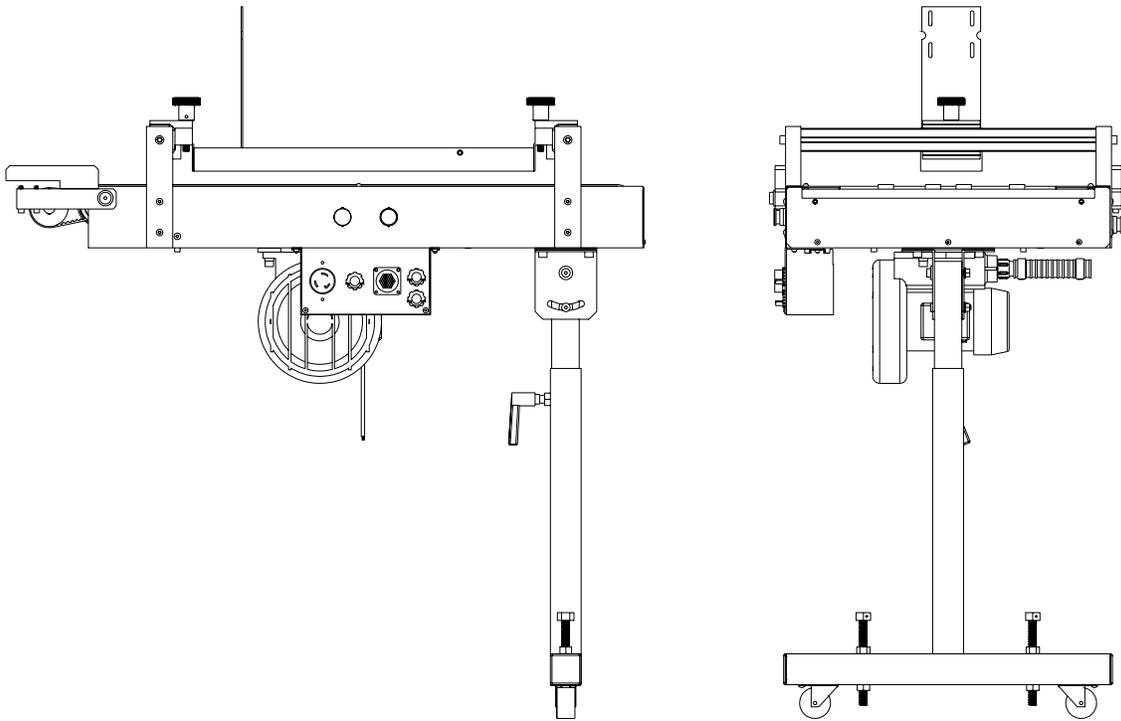


Table 3.1.a: Air Blower

Item	Part Number	Quantity	Description	Reference
1	801104	1	Regenerative Blower	
2	440511	2	Rubber Washer, 5/16" x 1 1/2" x 1/4"	
3	439015	2	Lock washer, 5/16" I.D.	
4	406250	2	Screw, SHCS 5/16-18 UNC x 3/4"	
5	802111	1	Hose Barb, 1" x 1", Plastic	
6	444004	2	Hose Clamp, Gear Type, 9-16" – 1 1/4"	
7	802601	1	Vacuum Tubing, Grey PVC, 1" (36" LG)	
8	615131	1	Box Connector, 3/8", Cable	
9	606034	1	Cable, #16-3, SJOW-A (72" LG)	
10	609111	1	Ring Tongue Terminal	
11	609101	2	Marett, Orange, 14-22	

The air blower is attached to the bottom of conveyor as shown:



3.1.1 BK702-400 Installation Instructions

Note: Refer to the diagram and Table 3.1 on page 3-1 for the items listed below.

1. Mount the air blower to the underside of the chassis.
2. Pull the end of the hose through the opening of the chassis.
3. Lift the tabletop and attach the hose with ring to the hose fitting previously installed at the side of the vacuum tray.
4. Replace the tabletop, but do not tighten the six screws.
5. Remove the outfeed roller cover from the BK400 base by removing the four 10-32 UNF button head screws.
6. Replace the existing drive shaft with the one supplied as shown in figure 3.1 (Item 5) and re-install all rollers. (Note that new drive shaft is longer than the original one.)
7. Mount the supplied pulley at the end of drive shaft, with its flange facing towards the rollers.
8. Carefully mount the timing belt on the pulley. Mount the lower gap cover (Item 2) to make sure there is enough clearance but do not yet tighten the mounting screws. Install both clamps (Item 10), but do not tighten the mounting screws.
9. Adjust the front conveyor roller on the table extension and both pulley positions to ensure that the belt runs true. Once the appropriate locations are found, tighten all setscrews to secure the rollers and pulleys in place.
10. Adjust the tension in the timing belt by pushing the conveyor toward the base machine and tightening the six screws at the top of the conveyor tabletop.
11. Move the clamps (Item 10) to their correct position and tighten the four screws (Item 6) at the bottom of the clamps.
12. Tighten the four screws holding the lower gap cover in place.
13. Install the upper gap cover.
14. Ensure that none of the rotational parts interfere with any of the stationary parts and that the mouse cord passes through the cutout in the lower gap cover.

3.2 BK702-460 Vacuum Table Extension, 3FT (picture shown in 2.1)

a) Air Blower included (described in 3.1.a)

3.2.1 BK702-460 Installation Instructions

1. Attach Air blower onto bottom side of the chassis.
2. Pull the end of the hose thru the opening of the chassis.
3. Lift the tabletop and attach hose with ring onto hose fitting mounted previously onto side of the vacuum tray.
4. Replace the tabletop but do not tighten the six tabletop screws.
5. Remove the outfeed roller cover from the BK460 base
6. Replace existing drive shaft with provided drive shaft and attach all rollers as before.
Note that new drive shaft is longer than the original one.
7. Mount the supplied pulley onto the end of the drive shaft, with the flange toward the rollers.
8. Carefully mount the timing belt on the pulley. Mount the lower gap cover (Item 2) to make sure there is enough clearance but do not yet tighten the mounting screws. Install both clamps (Item 10), but do not tighten the mounting screws.
9. Adjust the positions of the rollers, front conveyor roller and both pulleys to get optimal belt running, tighten up all set screws, find optimal positions for the clamps.
10. Adjust the positions of the rollers on the base unit, the front conveyor roller on the extension table and both pulleys to make sure the belt runs true and tighten all set screws. Move the clamps to their proper positions.
11. Tighten the four screws (Item 6, two on each side) at the bottom of the clamps once they are in the correct position.
12. Tighten the four screws holding the lower gap cover in place.
13. Install the upper gap cover (Item 3) and tighten the six mounting screws (Item 4).
14. Make sure no rotating parts touch any stationary parts and the mouse cord is pulled through the cutout at the center of the lower gap cover.
15. Do the wiring according to schematic and instructions for the BK460.

3.3 BK702-600 Vacuum Table Extension, 3FT

a) Air Blower included (described in 3.1.a)

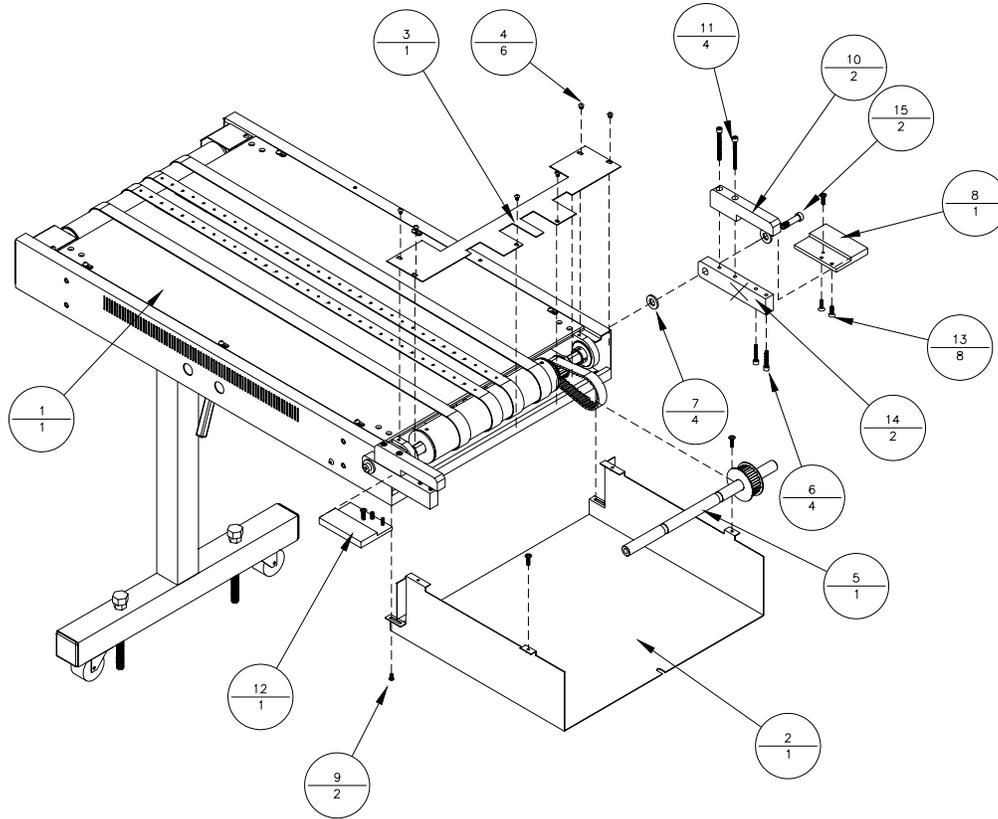


Table 2.3: *BK701-600 Vacuum Table Extension, 3 FT*

Item	Part Number	Quantity	Description	Reference
1	BK701	1	Vacuum Table Extension	
2	9100848	1	Lower Gap Cover (BK600/BK701)	
3	9100844	1	Gap Cover (BK600/BK701)	
4	404510	6	Screw, BHCS 10-32 UNF x 1/4"	
5	9100847A	1	Driveshaft Assembly (BK600/BK701)	
6	405275	4	Screw, SHCS 1/4-20 UNC x 1 1/4"	
7	440030	4	Washer, 1/2" I.D.	
8	9100843	1	Right Mounting Inlet	
9	404520	2	Screw, BHCS 10-32 UNF x 3/8"	
10	9100805	2	Tabletop Mounting Arm Clamp	
11	405287	4	Screw, SHCS 1/4-20 UNC x 2 1/2"	
12	9100866	1	Left Mounting Inlet	
13	404040	8	Screw, FHCS 10-32 UNF x 5/8"	
14	9100680	2	Mounting Arm, (BK600/BK701)	
15	417170	2	Shoulder Bolt, 1/2" x 1" (3/8-16)	

3.3.1 BK702-600 Installation Instructions

Note: Refer to the diagram and Table 3.3 on page 3-6 for the items listed below.

1. Mount the air blower to the underside of the chassis.
2. Pull the end of the hose through the opening of the chassis.
3. Lift the tabletop and attach the hose with ring to the hose fitting previously installed at the side of the vacuum tray.
4. Replace the tabletop, but do not tighten the six screws.
5. Remove the outfeed roller cover from the BK600 base by removing the four 10-32 UNF button head screws.
6. Replace the existing drive shaft with the one supplied as shown in figure 3.3 (Item 5) and re-install all rollers. (Note that new drive shaft is longer than the original one.)
7. Mount the supplied pulley at the end of drive shaft, with its flange facing towards the rollers.
8. Carefully mount the timing belt on the pulley. Mount the lower gap cover (Item 2) to make sure there is enough clearance but do not yet tighten the mounting screws. Install both clamps (Item 10), but do not tighten the mounting screws.
9. Mount left and right mounting inlets in the same locations as the outfeed roller assembly. Use longer flathead screws, as provided. Attach both clamps onto the mounting inlets.
10. Adjust the front conveyor roller on the table extension and both pulley positions to ensure that the belt runs true. Once the appropriate locations are found, tighten all setscrews to secure the rollers and pulleys in place.
11. Adjust the tension in the timing belt by pushing the conveyor toward the base machine and tightening the six screws at the top of the conveyor tabletop.
12. Move the clamps (Item 10) to their correct position and tighten the four screws (Item 6) at the bottom of the clamps.
13. Tighten the four screws holding the lower gap cover in place.
14. Install upper gap cover.
15. Ensure that none of the rotational parts interfere with any of the stationary parts and that the mouse cord passes through the cutout in the lower gap cover.

3.4 BK702-660 Vacuum Table Extension, 3ft. (Picture shown in 2.2)

a) Air Blower included (described in 3.1.a)

3.4.1 BK702-660 Installation Instructions

Note: *Refer to the diagram and Table 2.2 on page 2-3 for the items listed below.*

1. Mount the air blower to the underside of the chassis.
2. Pull the end of the hose thru the opening of the chassis.
3. Lift the tabletop and attach the hose with ring to the hose fitting previously installed at the side of the vacuum tray.
4. Replace the tabletop, but do not tighten the six screws.
5. Remove the outfeed roller cover from the BK660 (640) base.
6. Remove the encoder from the end of the existing drive shaft.
7. Replace the setscrew on the encoder with the 3/16" set screw provided.
Note that shorter setscrew provides enough clearance for the pulley which will be attached over the end of drive shaft.
8. Loosen the first roller and move it toward other rollers.
9. Attach the pulley (Item 5) with the flange toward the end and move it toward the loose rollers as much as possible.
10. Carefully mount the timing belt on the pulley and make sure there is enough clearance for the lower gap cover (Item 2). Mount the gap cover using three of the mounting screws previously used for the original outfeed roller cover and tighten the screws very lightly to allow for adjustment once the extension is attached. These screws will not be accessible any more once the extension unit is attached. Mount both clamps (Item 10).
11. Re-install the encoder at its appropriate location and tighten the setscrew.
12. Slide the pulley (Item 5) over the setscrew of the encoder, as close as possible to the encoder. The pulley will be moved away from the encoder again during the next step and the encoder's setscrew will then be exposed.
13. Adjust the positions of the pulley and the rollers on the base unit, and the front conveyor roller and pulley on the extension table to make sure the belt runs true and tighten all set screws. Move the clamps to their proper positions.
14. Adjust the tension of the timing belt by the tightening the six screws on top of the conveyor tabletop and by pushing the conveyor toward the base machine.
15. Tighten the four screws (Item 6, two on each side) from the bottom of the clamps once they are in the correct position.
16. Fasten the lower gap cover to the table extension unit with two screws (Item 9) and tighten. The other three screws holding the cover to the base unit cannot be tightened.

17. Install the upper gap cover (Item 3).
18. Make sure no rotating parts touch any stationary parts and the mouse cord is pulled through the cutout at the right upper corner (on Item 2 close to Item 5 in the drawing) of the lower gap cover.
19. Do the wiring according to schematic and instructions for the BK660.

Chapter

4

Accessories

4.1 BK710-HTR Mounting Kit (Research Inc. Model #4540-10)

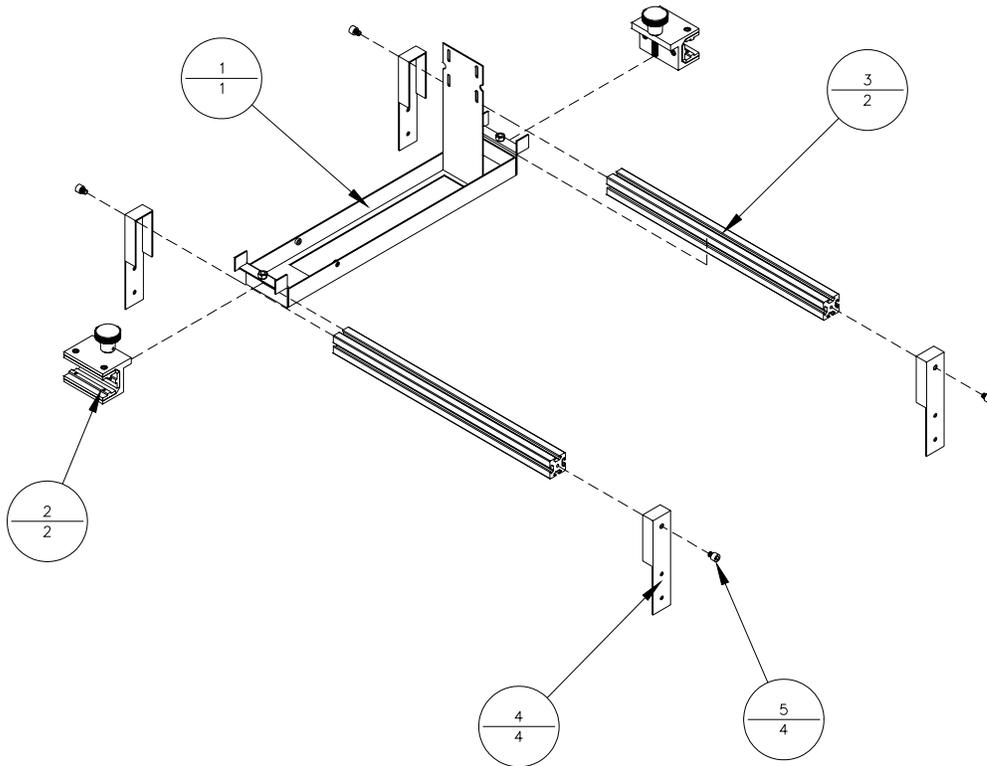


Table 4.1: *Mounting Kit Assembly - Research*

Item	Part Number	Quantity	Description	Reference
1	9100489A	1	Heater Support Tray	
2	9100691A	2	Mounting Bracket Assembly	
3	9100476	2	Lateral Heater Support	
4	9100475	4	Vertical Heater Support	
5	406220	4	Screw, SHCS, 5/16-18 UNC x 3/8"	

4.1.1 Mounting BK710-HTR (Dryer not included)

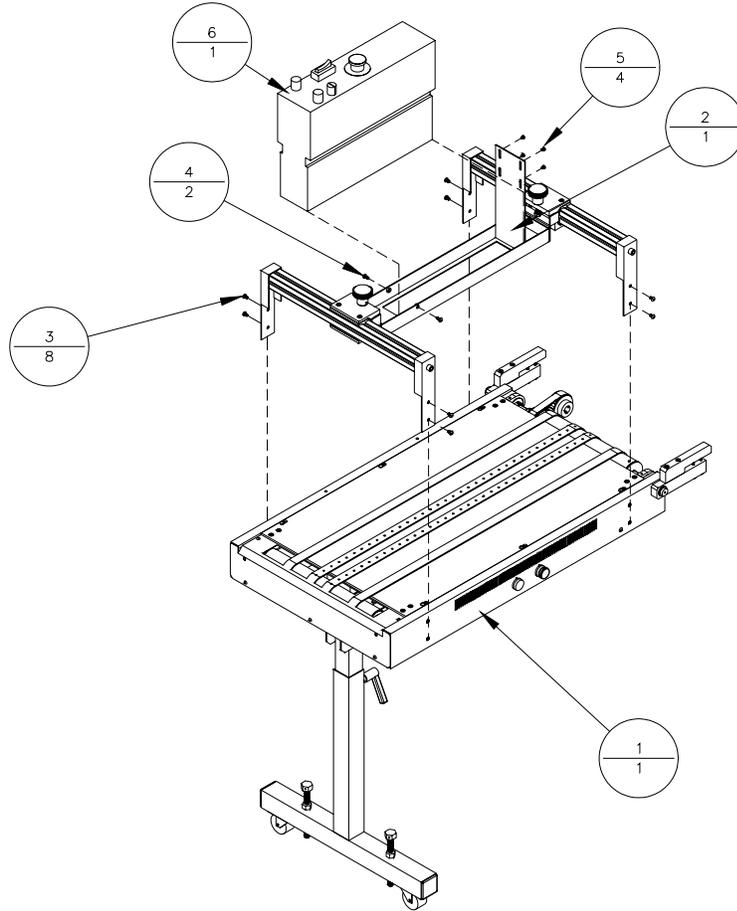


Table 4.1.1: Heater Table Assembly

Item	Part Number	Quantity	Description	Reference
1	BK701	1	Vacuum Table Extension	
2	9100476A	1	Mounting Kit - Research	
3	405520	8	Screw, BHCS 1/4-20 UNC x 3/8"	
4	405530	2	Screw, BHCS 1/4-20 UNC x 1/2"	
5	404510	4	Screw, BHCS 10-32 UNF x 1/4"	
6	Heater	1	"Research #4540-10"	m=13 kg (28.6 lb)

Table a: Physical Specifications

Item	Specification	Specification
Overall Height	47.5" - 48.5" (42" w/o heater)	1207- 1232 mm (1067 mm)
Weight	57 kg (44 w/o heater)	125.4 lb (96.8 lb)

4.2 BK710-HTI Mounting Kit (IAMSCO Model #3000)

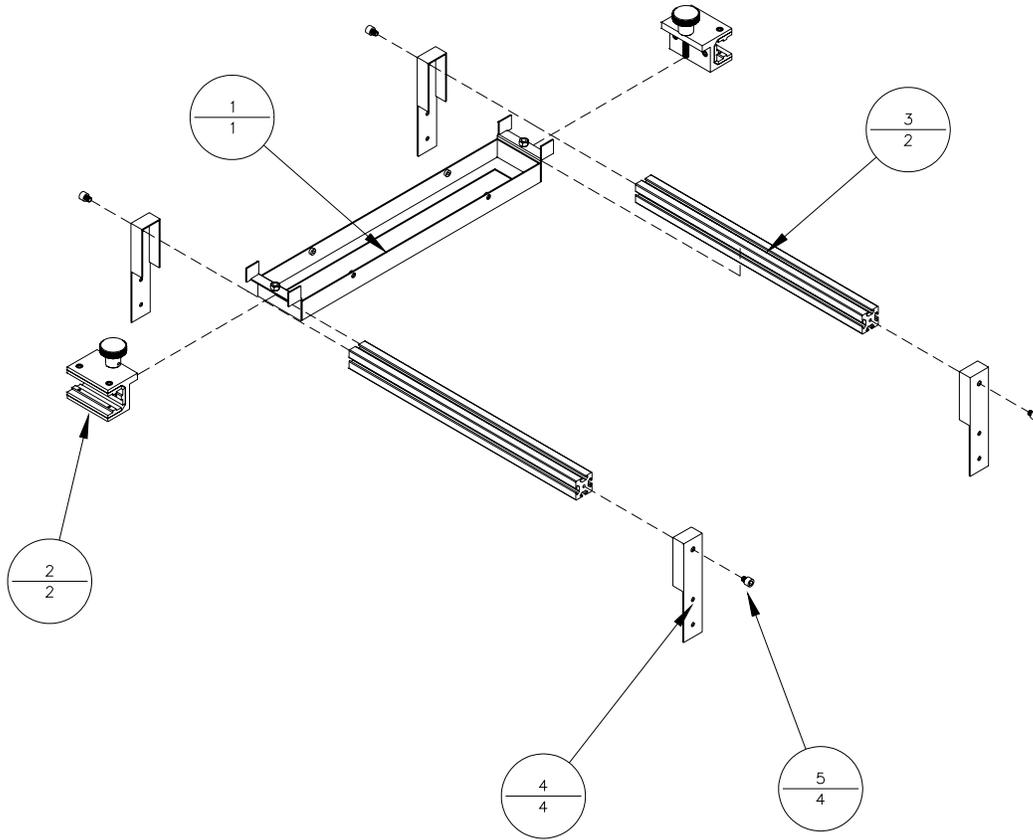


Table 4.2: Mounting Kit Assembly - IAMSCO

Item	Part Number	Quantity	Description	Reference
1	9100488A	1	Heater Support Tray - IAMSCO	
2	9100691A	2	Mounting Bracket Assembly	
3	9100476	2	Lateral Heater Support	
4	9100475	4	Vertical Heater Support	
5	406220	4	Screw, SHCS, 5/16-18 UNC x 3/8"	

4.2.1 Mounting BK710-HTI (Dryer not included)

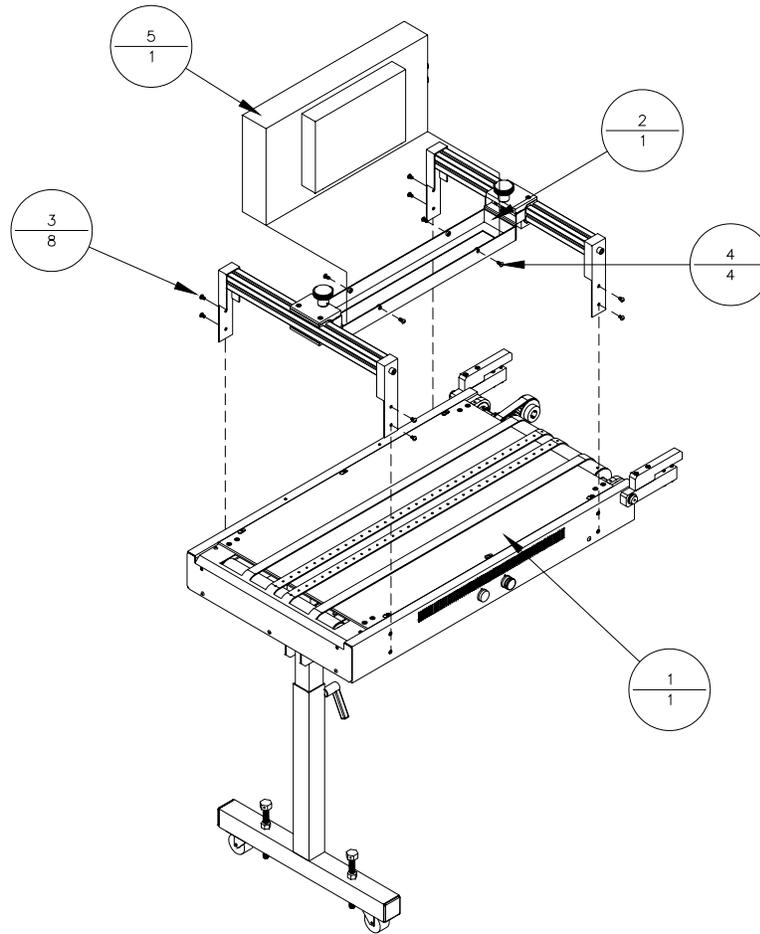


Table 4.2.1: *Heater Table Assembly*

Item	Part Number	Quantity	Description	Reference
1	BK701	1	Vacuum Table Extension	
2	9100475A	1	Mounting Kit - IAMSCO	
3	405520	8	Screw, BHCS 1/4-20 UNC x 3/8"	
4	405530	4	Screw, BHCS 1/4-20 UNC x 1/2"	
5	Heater	1	"IAMSCO #3000"	m=13 kg (28.6 lb)

Table b: *Physical Specifications*

Item	Specification	Specification
Overall Height	46.5" – 47.5" (42" w/o heater)	1181 - 1207 mm (1067 mm)
Weight	57 kg (44 kg w/o heater)	125.4 lb (96.8 lb)

Appendix

A

Mechanical Drawings

A-1 Chassis Assembly

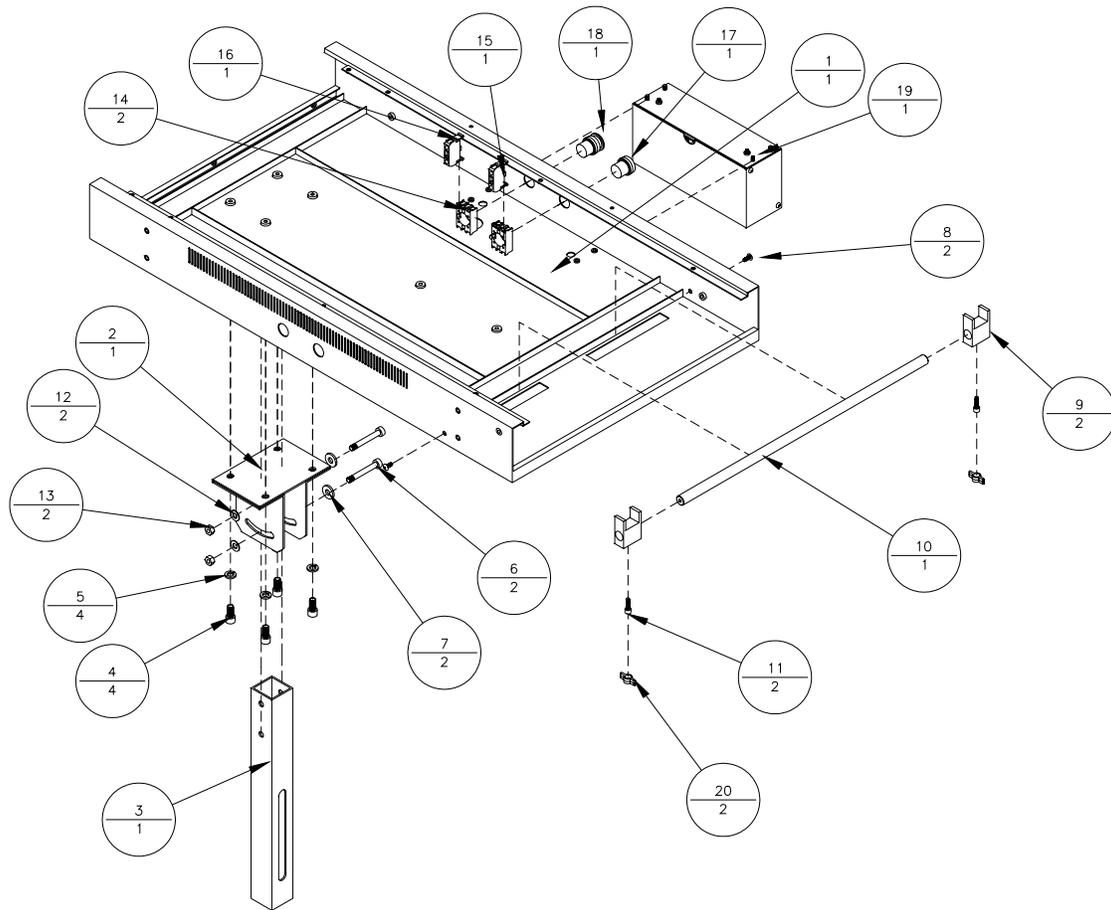


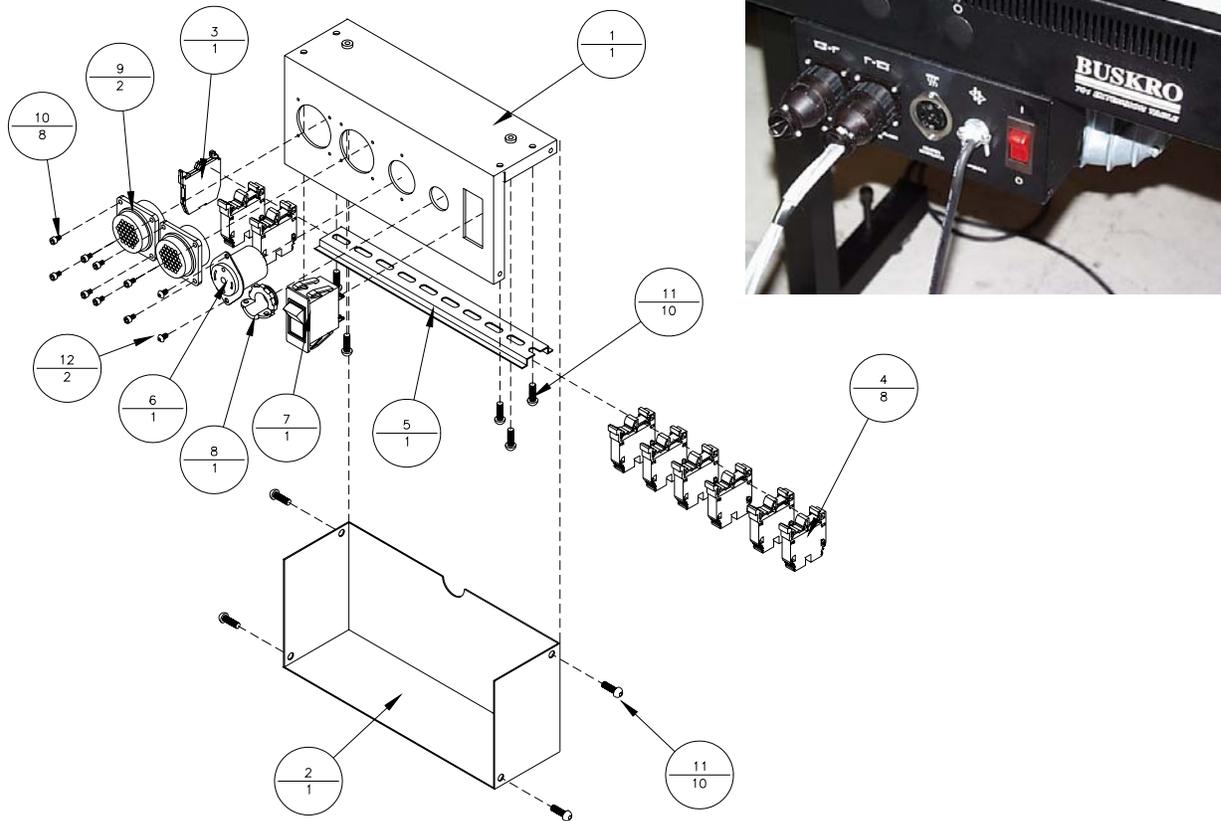
Table A-1: Chassis Assembly

Item	Part Number	Quantity	Description	Reference
1	9100324	1	Main Chassis Assembly	
2	9100330	1	Support Bracket	
3	9100329	1	Support Leg, Inner Tube	
4	407250	4	Screw, SHCS 3/8-16 UNC x 3/4"	
5	439020	4	Lockwasher, 3/8" I.D.	
6	416185	2	Shoulder Bolt, 3/8 x 2" (5/16-18)	
7	440020	2	Washer, 3/8" I.D.	
8	405530	2	Screw, BHCS 1/4-20 UNC x 1/2"	
9	330161	2	Belt Alignment Guide, 1"	
10	9100357	1	Belt Alignment Shaft	
11	405250	2	Screw, SHCS 1/4-20 UNC x 3/4"	
12	404015	2	Washer, 5/16" I.D.	

Chassis Assembly (continues):

Item	Part Number	Quantity	Description	Reference
13	420015	2	Nut, 5/16-18 UNC	
14	603125	4	Switch Locking Collar	
15	603126	2	N.O. Contact Block	
16	603127	2	N.C. Contact Block	
17	603120	2	Green Push Button Switch	
18	603121	2	Red Mushroom Push Button Switch	
19	9100860A	1	Electrical Bracket Assembly	
20	438505	2	Tee Knob, Black Plastic, 1/4" Screw	

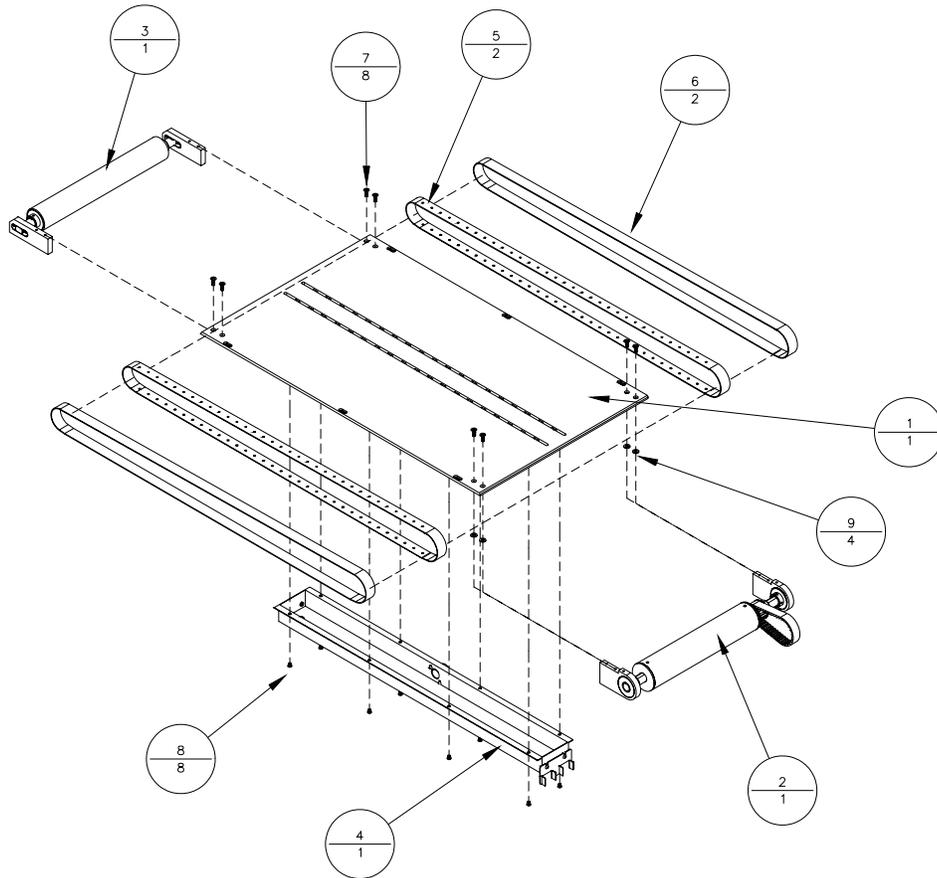
A-2 Electrical Bracket Assembly

Table A-2: *Electrical Bracket Assembly*

Item	Part Number	Quantity	Description	Reference
1	9100854	1	"L" Bracket	
2	9100860	1	"L" Bracket Cover	
3	615017	1	Terminal EK2.5/35, Ground	
4	615003	6	Terminal Block, M10/10, Grey, 7.5 A	
5	615021	1	"T" Rail, 8"	
6	9100868	1	Flanged Receptacle, 125 VAC	
7	603415	1	Circuit Breaker Switch	
8	615131	1	Box Connector, 3/8" Cable	
9	614135	2	Inline Connector	
10	402210	8	Screw, SHCS, 6-32 UNC x 1/4"	
11	404520	10	Screw, BHCS, 10-32 UNF x 3/8"	
12	402510	2	Screw, BHCS, 6-32 UNC x 1/4"	

Note: This assembly is applicable to both sides of the chassis.

A-3 Tabletop Assembly

Table A-3: *Tabletop Assembly*

Item	Part Number	Quantity	Description	Reference
1	9100320	1	Tabletop	
2	9100678A	1	Front Roller Assembly	
3	9100316A	1	Rear Roller Assembly	
4	9100321A	1	Vacuum Tray Assembly	
5	9100306	2	Belt, Vacuum, Heat Resistant	
6	9100307	2	Belt, Transport, Heat Resistant	
7	404030	8	Screw, FHCS 10-32 UNF x 1/2", SS	
8	404510	8	Screw, BHCS 10-32 UNF x 1/4"	
9	440008	4	Washer, #10 I.D.	

A-4 "T" Leg Assembly

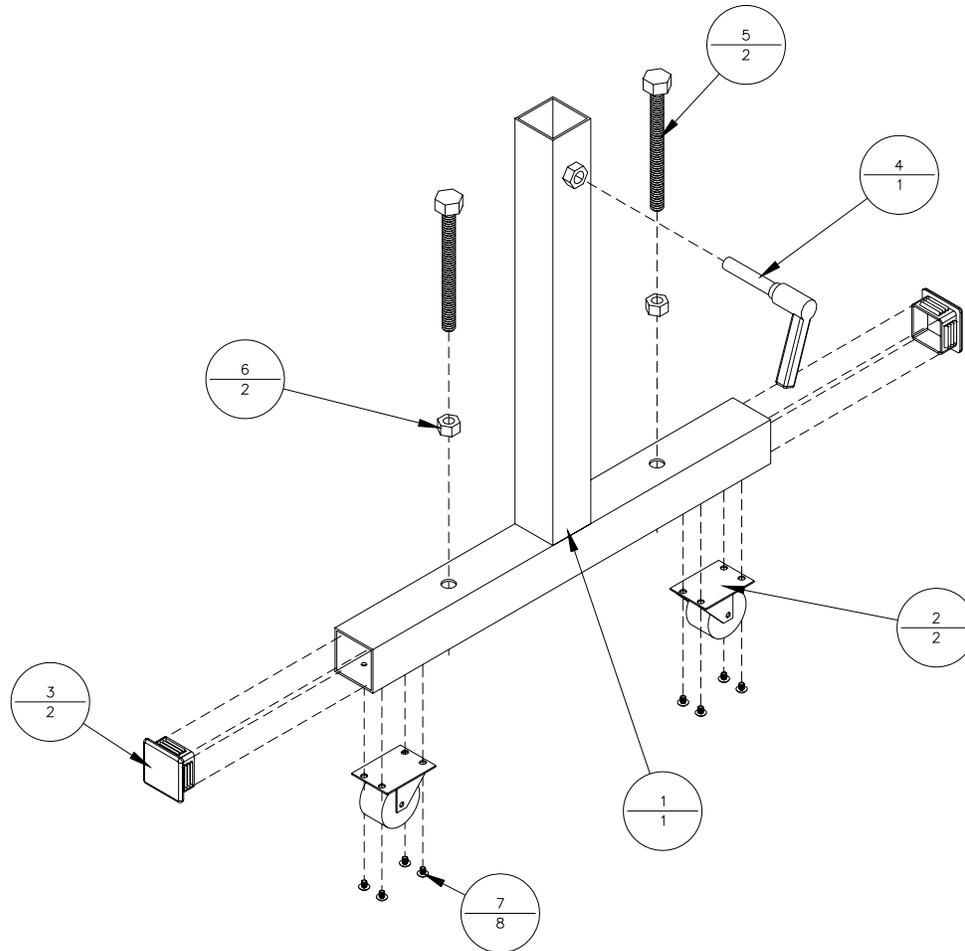
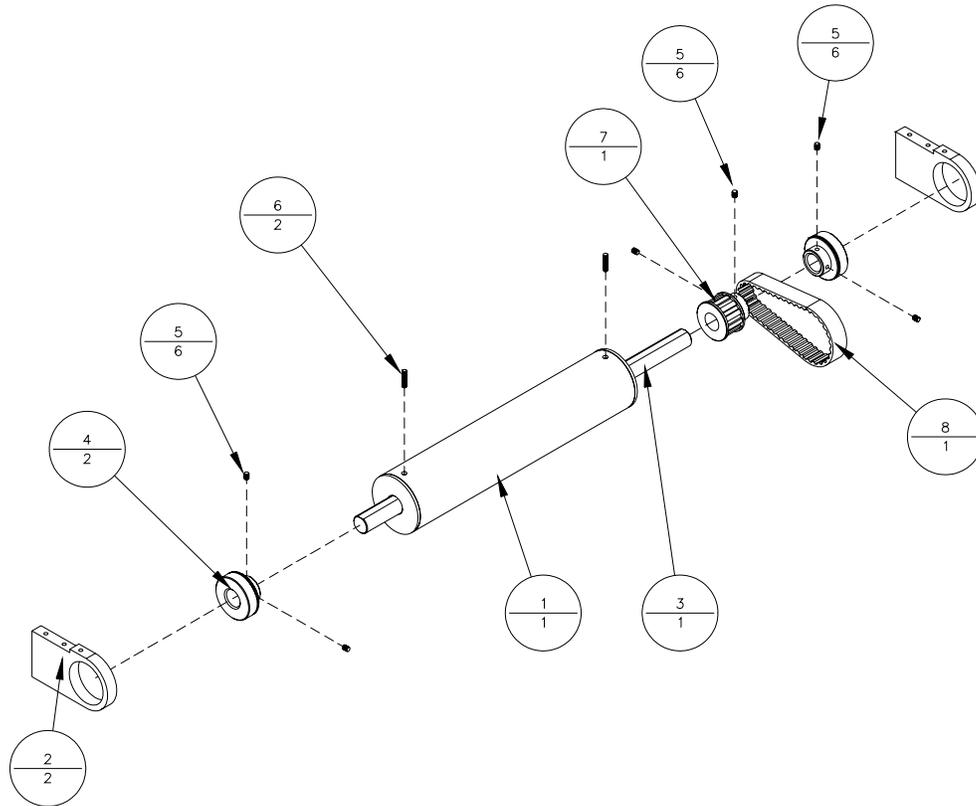


Table A-4: "T" Leg Assembly

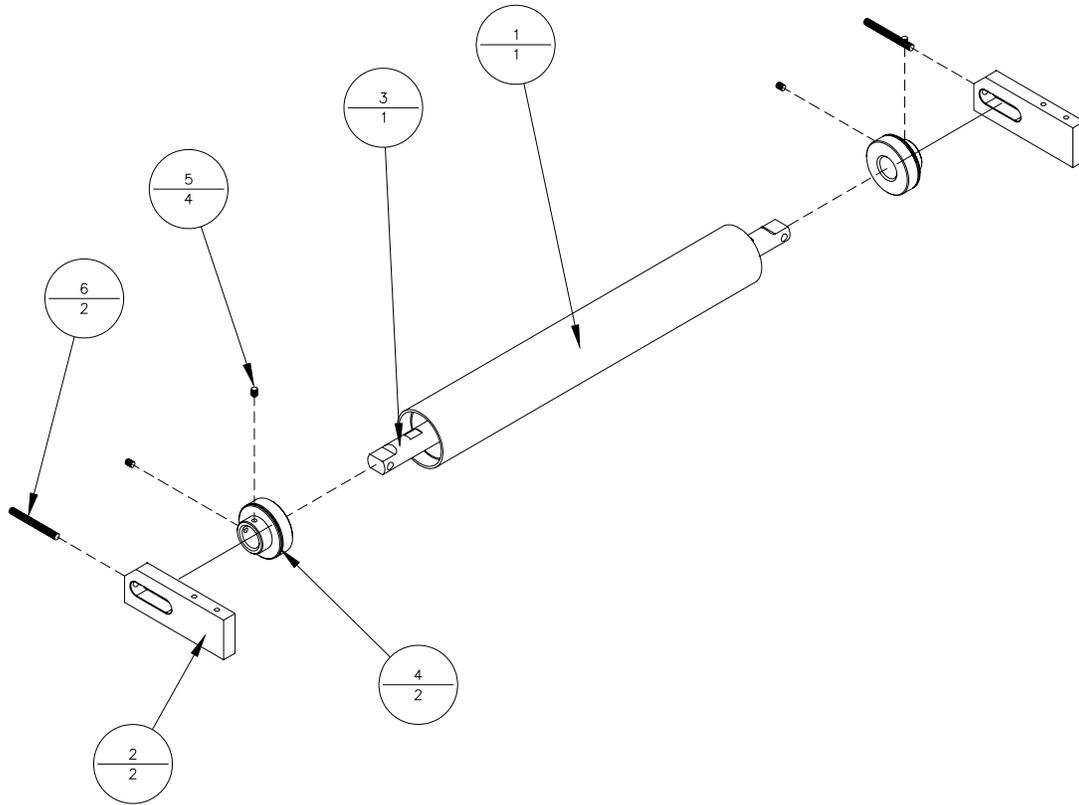
Item	Part Number	Quantity	Description	Reference
1	9100327A	1	Support Leg Assembly	
2	9100484	2	Caster, 2"	
3	9100493	2	Endcap, 2"	
4	9100486	1	Lever Handle, 1/2 UNC x 2 1/2"	
5	343150	2	Mounting Leg	
6	420030	2	Nut, 1/2-13 UNC	
7	405510	8	Screw, BHCS 1/4-20 UNC x 1/4"	

A-5 Front Roller Assembly

Table A-5: *Front Roller Assembly*

Item	Part Number	Quantity	Description	Reference
1	9100352A	1	Front Roller	
2	9100678	2	Front Mounting Block	
3	9100319	1	Drive Shaft	
4	500055	2	Bearing, UBR204-12S	
5	404810	6	Screw, SHSS 10-32 UNF x 1/4"	
6	405850	2	Screw, SHSS 1/4-20 UNC x 3/4"	
7	9100808	1	Pulley, 14LF075 x 3/4"	
8	120352	1	Timing Belt, 124L075	

A-6 Rear Roller Assembly

Table A-6: *Rear Roller Assembly*

Item	Part Number	Quantity	Description	Reference
1	9100316	1	Rear Roller, 2.0" dia.	
2	9100679	2	Rear Mounting Block	
3	9100318	1	Transport Roller Shaft	
4	500055	2	Bearing, UBR204-12S	
5	404810	4	Screw, SHSS 10-32 UNF x 1/4"	
6	405885	2	Screw, SHSS 1/4-20 UNC x 2"	

A-7 Vacuum Tray Assembly

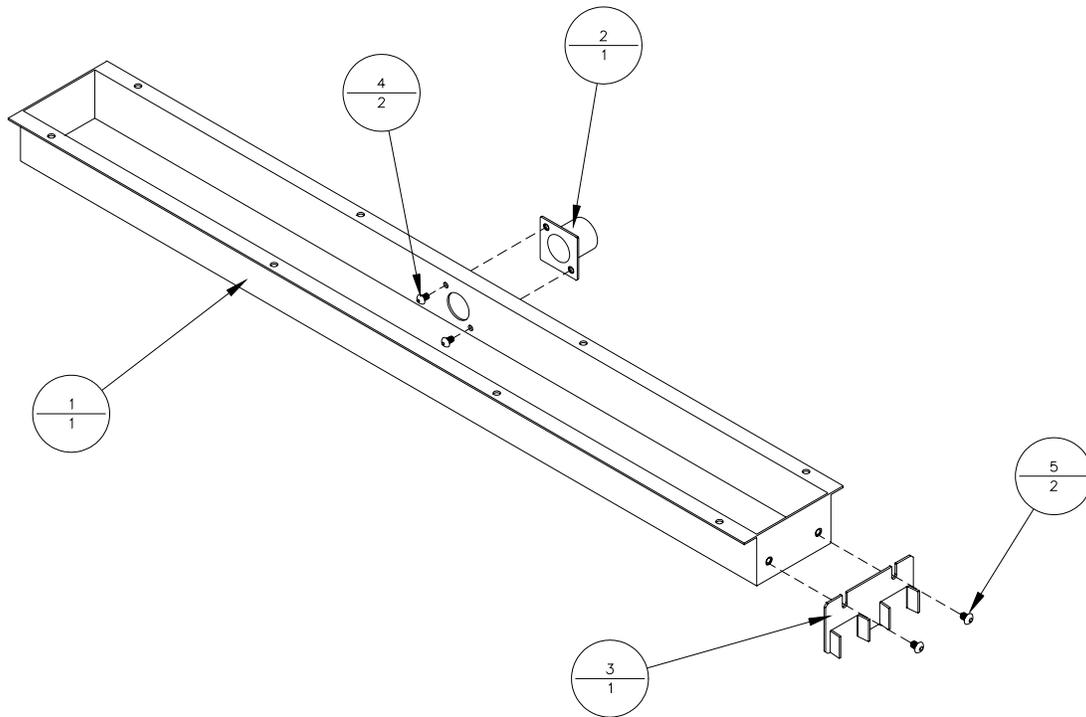


Table A-7: Vacuum Tray Assembly

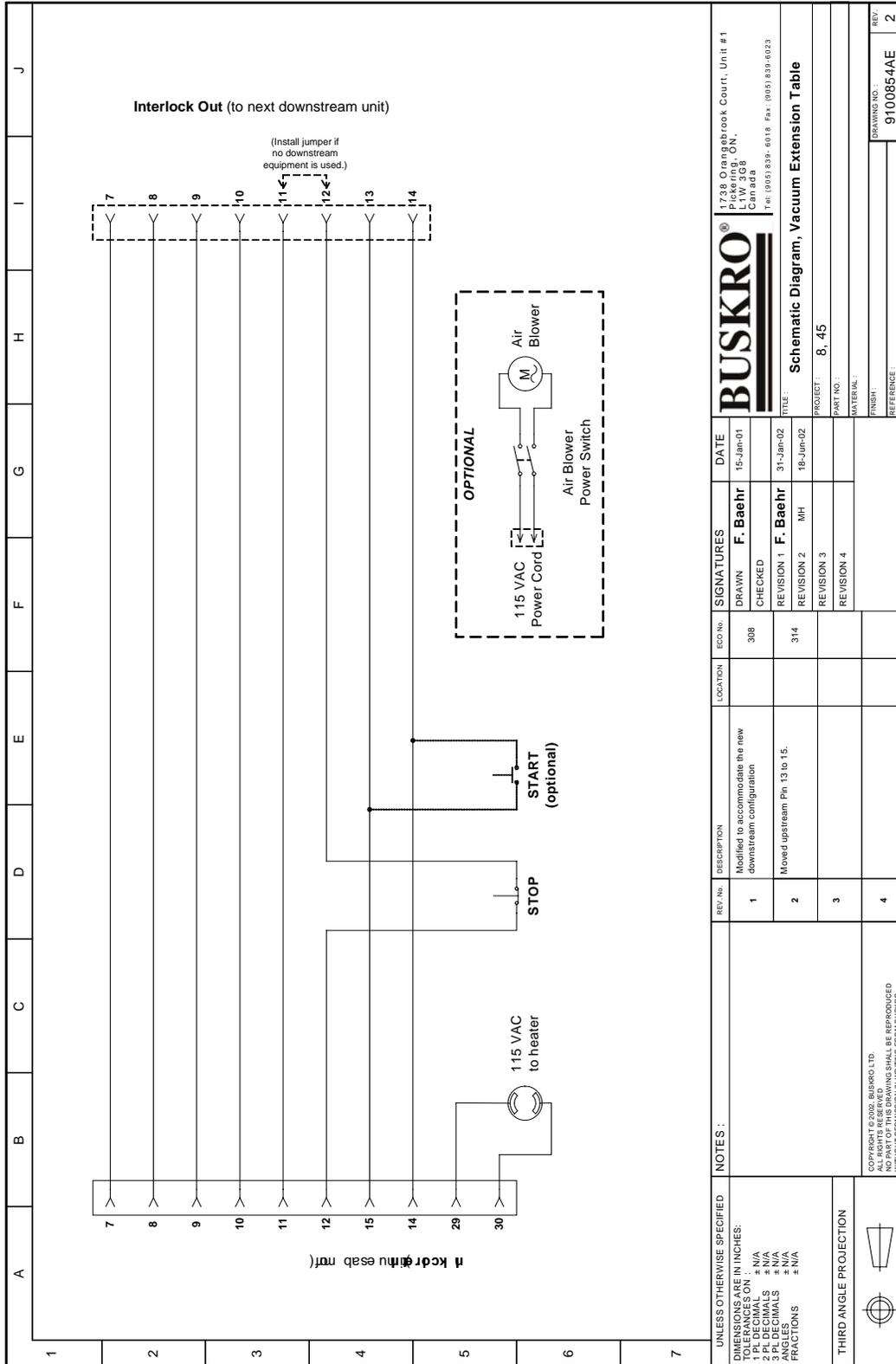
Item	Part Number	Quantity	Description	Reference
1	9100321	1	Vacuum Tray	
2	9100477	1	Vacuum Hose Flanged Fitting	
3	9100358	1	Belt Alignment Plate	
4	403510	2	Screw, BHCS 8-32 UNC x 1/4"	
5	404510	2	Screw, BHCS 10-32 UNF x 1/4"	

Appendix

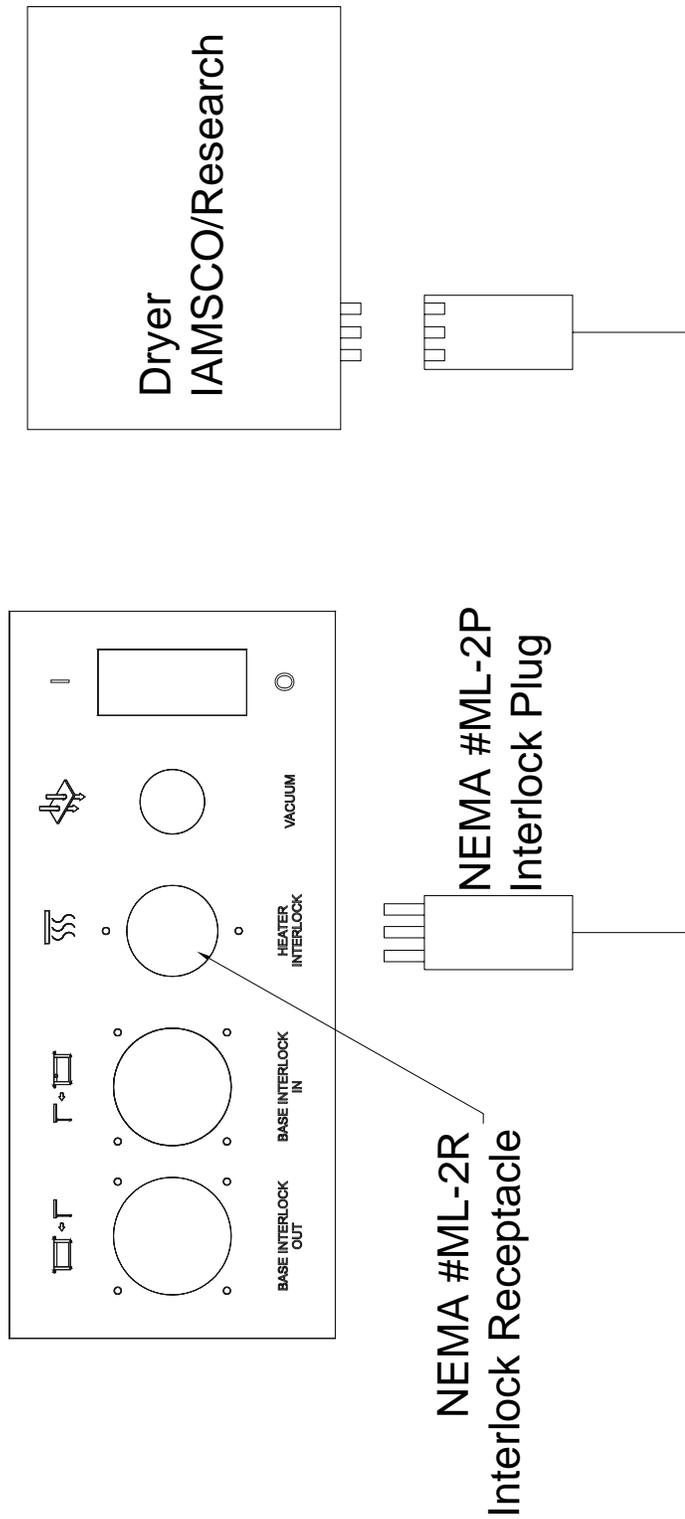
B

Electrical Schematics

B-1 BK701 Electrical Board Schematic



B-2 Interlocking 110 VAC



B-4 Electrical Schematic (BK701-660)

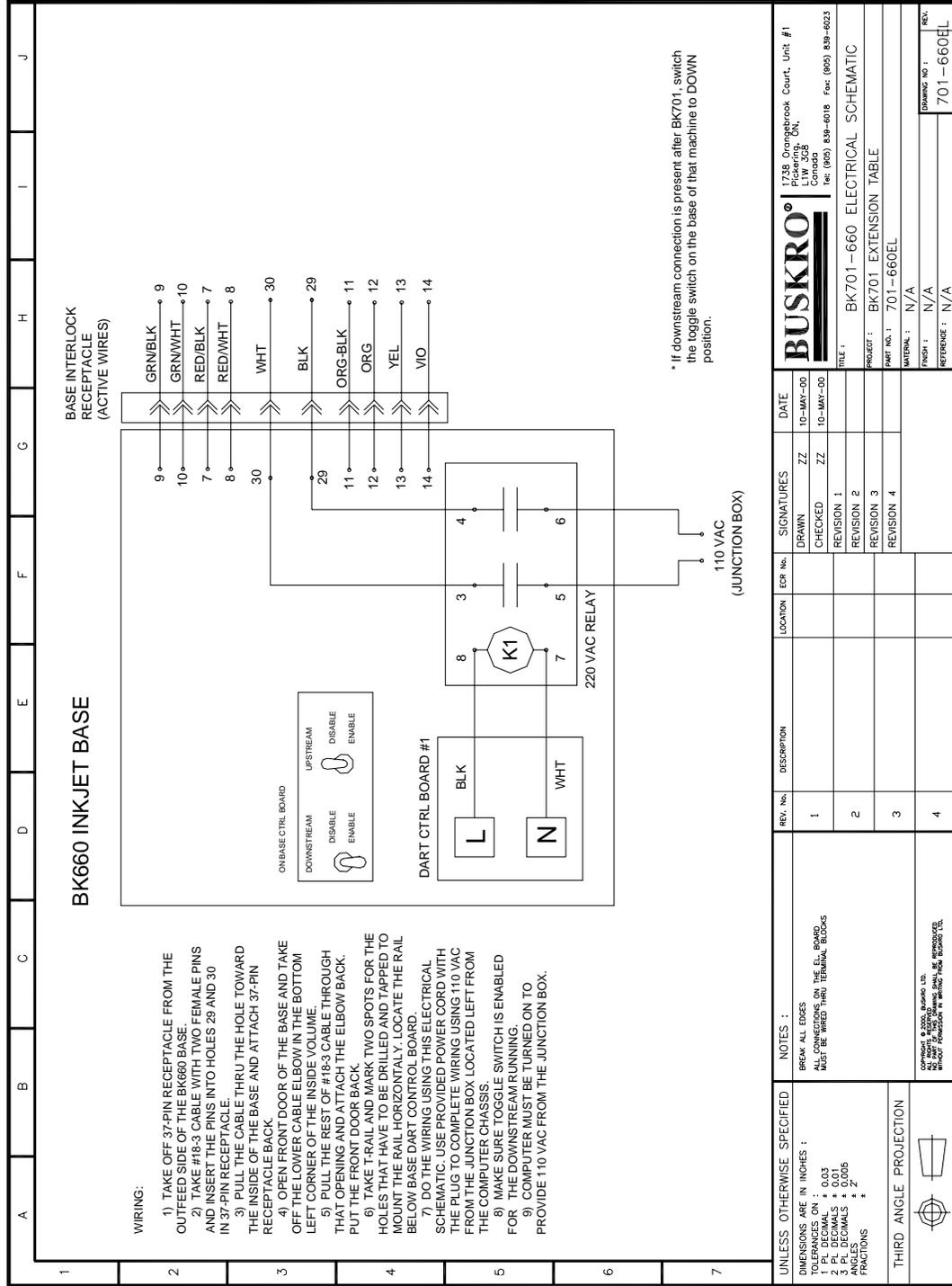




Figure 1: Detach 37-pin receptacle, as shown.

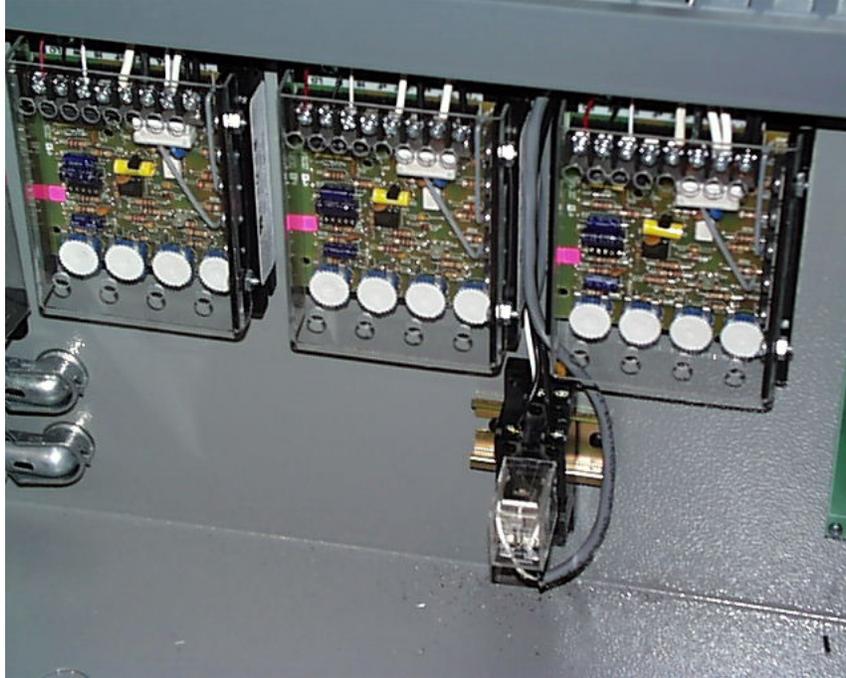


Figure 2: Attach T-rail and relay base.