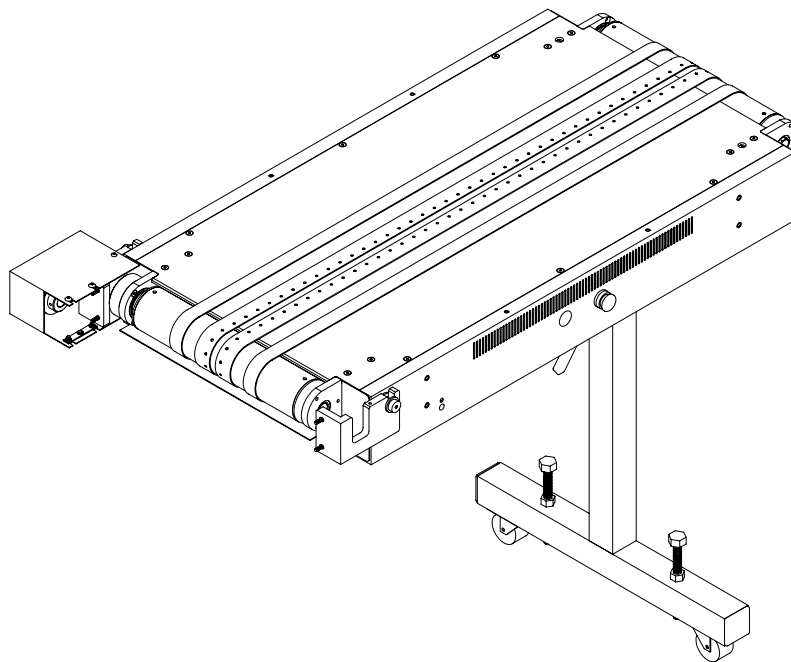
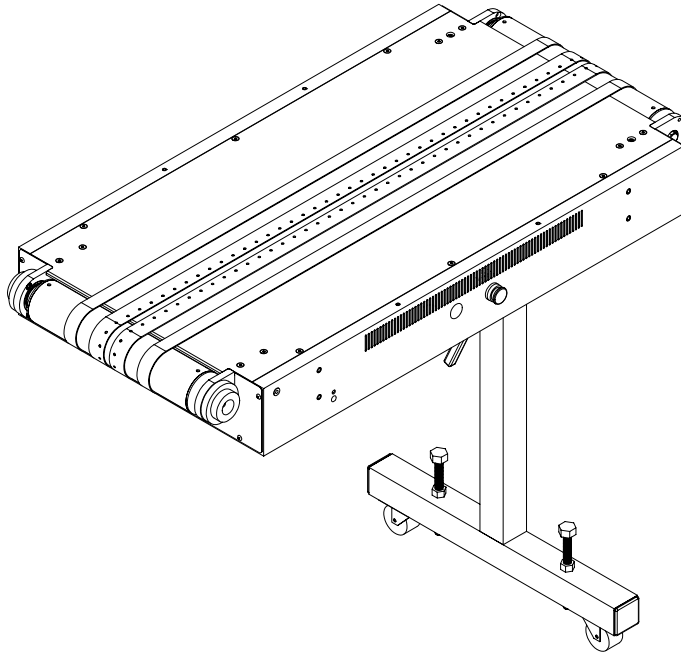


BUSKRO®

BK703 Extension Table



BK703 Vacuum Extension Table User's Guide

Published by:

Buskro Ltd.

1738 Orangebrook Court, Unit #1

Pickering, ON, L1W 3G8

Canada

Tel.: (905) 839-6018

Fax: (905) 839-6023

All Rights Reserved. No part of this book may be used or reproduced in any form or by any means, electronic or mechanical, or stored in a database or retrieval system, without prior written permission of Buskro Ltd. except in case of brief quotations embodied in critical articles or reviews. Making copies of any part of this book for any purpose other than your own personal use is a violation of copyright laws.

Copyright © 2004, Buskro Ltd.

First Edition, 2004

Printed in Canada

This manual is sold as is, without warranty of any kind, either express or implied, respecting the contents of this manual, including but not limited to implied warranties for the manual's quality, performance, merchantability, or fitness for any particular purpose. Neither Buskro Ltd. nor its dealers or distributors shall be liable to the purchaser nor any other person or entity with respect to any liability, loss, or damage caused or alleged to be caused directly or indirectly by this manual.

Manual History

Version	Date	Description	ECO No.
1.0	12-Aug-02	Manual Released as 9101799	
2.0	9-Dec-04	Integration with a BK-761B inline base.	646

- 1.0 General Information1-0**
 - 1.1 Description 1-1**
 - 1.2 Specifications..... 1-1**
 - 1.3 System Drawings..... 1-2**
- 2.0 Installation and Setup2-0**
 - 2.1 Integration with a BK7IB 2-1**
 - 2.2 Belt Adjustment 2-6**
 - 2.2.1 Belt Position..... 2-6
 - 2.2.2 Belt Tension 2-7
- 3.0 Accessories3-0**
 - 3.1 Attaching Heaters or Dryers 3-1**

Appendix A – Assembly Drawings

Appendix B – Electrical Drawings

1.1 Description

The Buskro BK703 vacuum extension table is a secondary transport table used in conjunction with other transport bases such as the BK7IB and the BK76IB inline base. Note that there are two different vacuum extension tables available: the BK703-7IB is the extension table made for the BK7IB inline base and the other, BK703-76IB, for the BK76IB inline base. Both vacuum extension tables feature vacuum equipped belts to assist in product transport (to hold the mail pieces to the belts) as well as adjustable outer belts to accommodate different mail piece sizes. The main function of the tables is to support secondary equipment such as heaters and dryers to improve the dry times for printed material.

In order to drive the BK703-7IB, a power take-off unit was designed to transmit the mechanical drive from a Buskro transport base to the BK703. For the BK703-76IB inline base, this is not required. Although it is possible to attach a separate blower to the BK703, the primary base supplies the vacuum on the standard model.

1.2 Specifications

Product Handling		
Minimum	3.0" x 5.0"	76 x 127 mm
Maximum	17.0" x 17.0"	432 x 432 mm
Thickness	Depends on base and secondary equipment.	
Physical		
Weight (Approximate)	85 lb	38.6 kg
Production Speed		
Belt Speed	Depends on primary base.	
Cycle Speed	Depends on primary base.	
Operator Controls		
Machine Pushbuttons	Stop	

1.3 System Drawings

Figure 1-1: *BK703-71B Overall Dimensions*

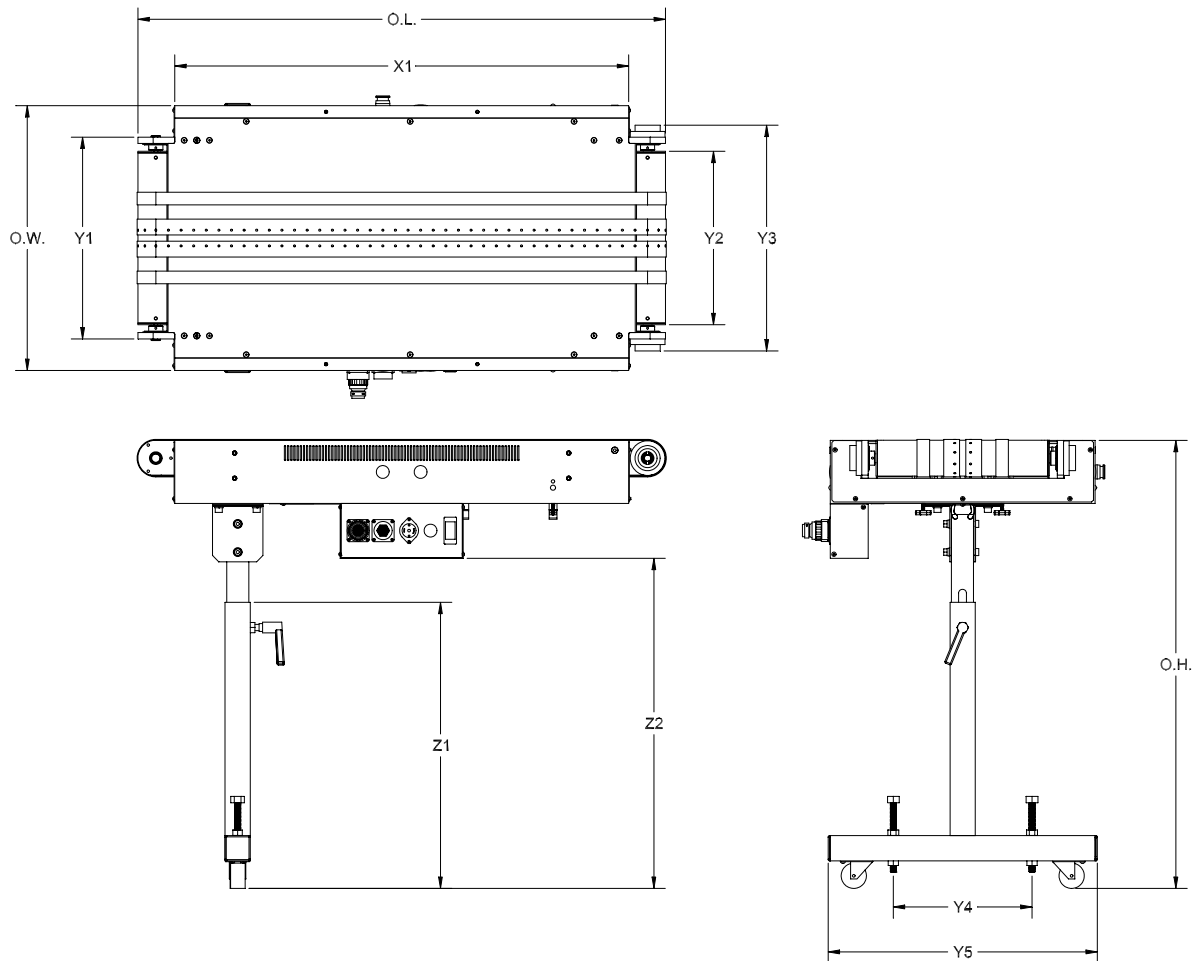
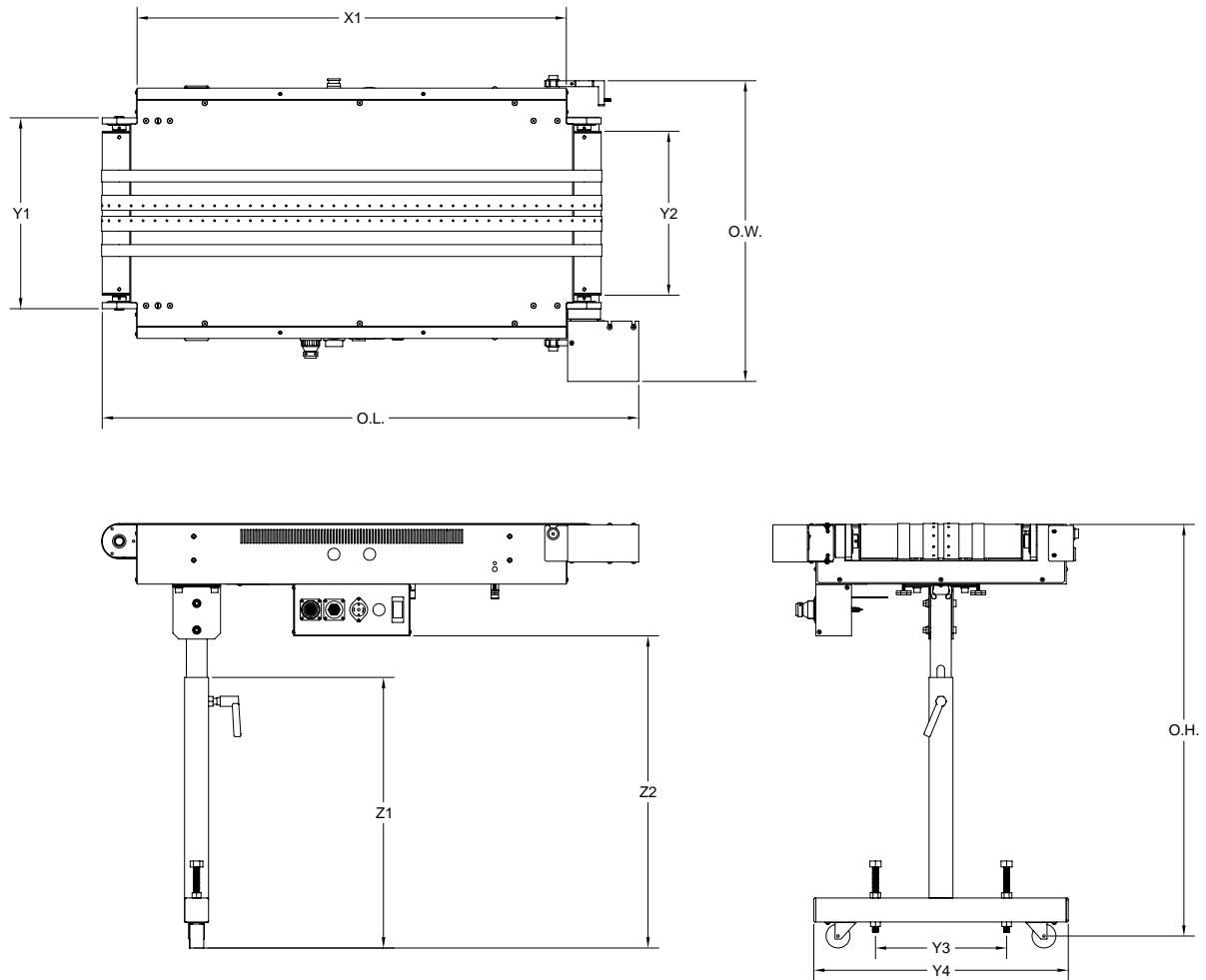
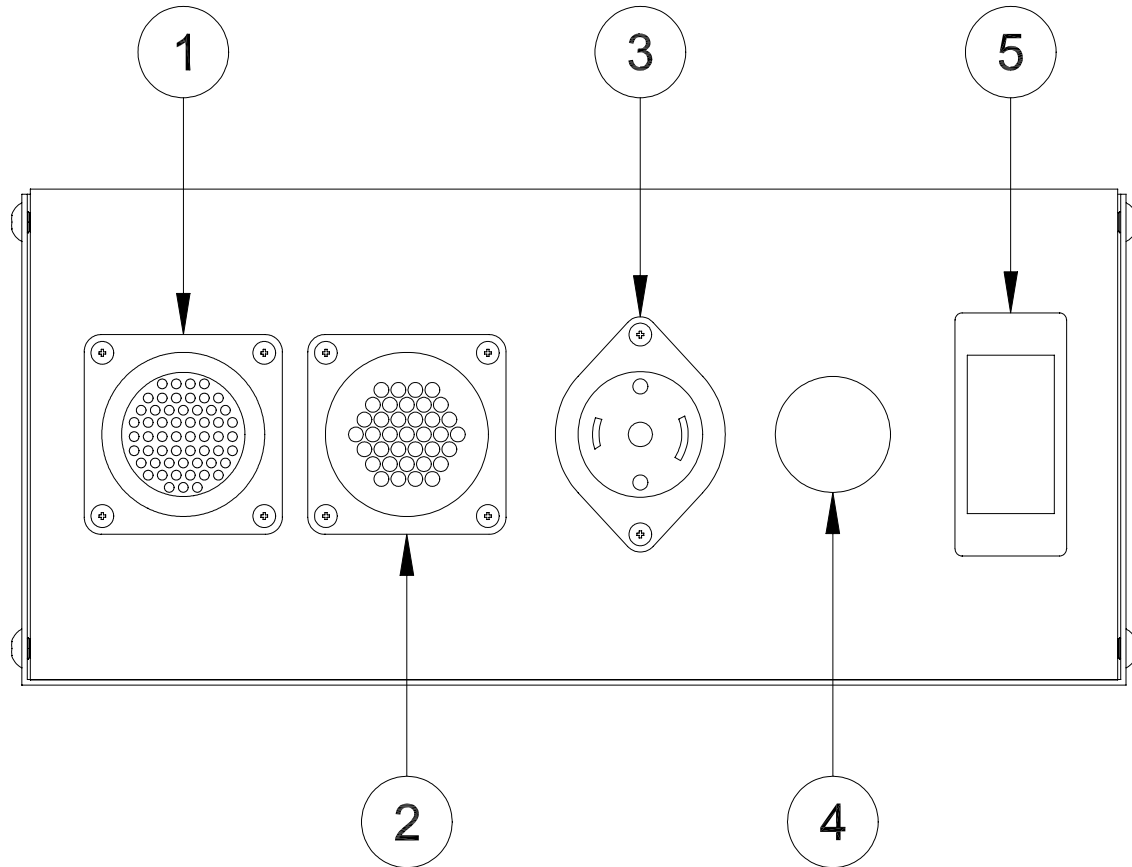


Table 1-1: *BK703-71B Overall Dimensions*

Symbol	Description	Dimensions	
O.W.	Overall Width	21.00"	534 mm
O.L.	Overall Length	42.00"	1067 mm
O.H.	Overall Height	33.00 to 38.50"	838 to 978 mm
X1	Chassis Length	36.00"	915 mm
Y1	Roller Mounting Distance	16.00"	407 mm
Y2	Roller Length	13.75"	349 mm
Y3	BK703 Mounting Width	17.90"	455 mm
Y4	Leveling Foot Offset	11.00"	280 mm
Y5	Overall Leg Width	21.34"	542 mm
Z1	Leg Height	22.69"	576 mm
Z2	Electrical Box Height	23.65" to 29.15"	601 to 741 mm

Figure 1-2: *BK703-761B Overall Dimensions*Table 1-2: *BK703-761B Overall Dimensions*

Symbol	Description	Dimensions	
O.W.	Overall Width	25.21"	640 mm
O.L.	Overall Length	45.00"	1143 mm
O.H.	Overall Height	33.00 to 38.50"	838 to 978 mm
X1	Chassis Length	36.00"	915 mm
Y1	Roller Mounting Distance	16.00"	407 mm
Y2	Roller Length	13.75"	349 mm
Y3	Leveling Foot Offset	11.00"	280 mm
Y4	Overall Leg Width	21.34"	542 mm
Z1	Leg Height	22.69"	576 mm
Z2	Electrical Box Height	23.65" to 29.15"	601 to 741 mm

Figure 1-3: *BK703 Electrical Box*Table 1-3: *BK703 Electrical Box*

Item	Description
1	Connection for Downstream equipment (Use included jumper plug if nothing downstream).
2	Connection for Upstream equipment.
3	Heater Interlock for Heater/Dryer.
4	Used only when a separate blower is attached (115 VAC).
5	Used only when a separate blower is attached (On/Off switch for Blower).

2.1 Integration with a BK7IB

In order to use a BK703 with a Buskro BK7IB Inline base, a BK715 power take-off unit is required. The BK715 consists of the power take-off which transfers drive from the BK7IB to the BK703, the locking mechanism that supports and secures the BK703, the lower gap assembly which provides access to the base vacuum, and a number of covers. In order to install a BK703 to a BK7IB, the following instructions should be followed (reference drawings in Appendix A):

1. Remove the drive side outfeed roller cover on the BK7IB (9100780).
2. Remove the shaft encoder from the BK7IB drive shaft.
3. Attach the locking mechanism (9100760A or LA) to the base. Keep the mounting screws loose.
4. Secure one of the coupling hubs (reference drawing 9100755A) to the BK7IB drive shaft and attach the coupling insert.
5. Attach the power take-off (9100755A or 9100755LA) to the base in the orientation shown in Figure 2-1. Once the coupling is engaged, rotate the assembly 90 degrees into its final position. Keep the mounting screws loose.
6. Attach the power takeoff cross bar (9101978) as shown in BK715-7IB. This is used on models manufactured after September 2002.
7. Attach the lower gap assembly (9101411A) but keep the mounting screws loose. Route the vacuum tubing into the base and attach the tee (Figure 2-2). Attach the 4" long vacuum tubing to the blower and the tee. The tubing from the Inline tabletop should go into the remaining tee opening.
8. Square up the power take-off and tighten the mounting screws holding the unit to the base. Ensure that the centerline of the inline drive shaft is in line with the centerline of the power take-off (i.e. the centerline of the coupling hubs should not be offset with each other or look angled).
9. Square up the locking mechanism assembly and tighten the mounting screws holding the unit to the base.

10. Secure the encoder to the power take-off drive shaft. Secure the encoder cable to the lower gap assembly using a tie wrap and a tie wrap mount (there should be a 10-32 nut on the lower gap cover for mounting).
11. Tighten the mounting screws on the lower gap assembly.
12. Turn the locking screw in the locking mechanism counter-clockwise until the tip of the screw is no longer visible from directly above. Pull the power take-off knob until the drive shaft is no longer visible from directly above.
13. Drop the BK703 into the support blocks of the power take-off and locking mechanism.
14. Engage the power take-off by turning and pushing in the power take-off knob (Figure 2-3) simultaneously. Do not attempt to force an engagement. Secure the drive shaft in this position by tightening the setscrew.
15. Tighten the locking screw on the locking mechanism by turning the screw clockwise. Once the screw makes initial contact, a quarter turn should be sufficient to secure the extension table.
16. Secure the vacuum line from the BK703 to the junction on the lower gap cover.
17. Add the remaining covers as shown in BK715-7IB and BK715-7IBL.
18. Enable the downstream toggle switch on the Base Interface Board of the BK7IB (reference the BK7IB manual).

Note: Do not over-tighten the locking screw on the locking mechanism. Once the screw makes initial contact with the BK703, a quarter turn should be sufficient to secure the extension table. This can affect the level of vibration and print quality.

The power take-off and locking mechanism must be square with one another otherwise it can cause a misalignment in the drive. This will cause increased vibration and make it more difficult to engage/disengage the power take-off.

Figure 2-1: *Power Take-Off Installation*

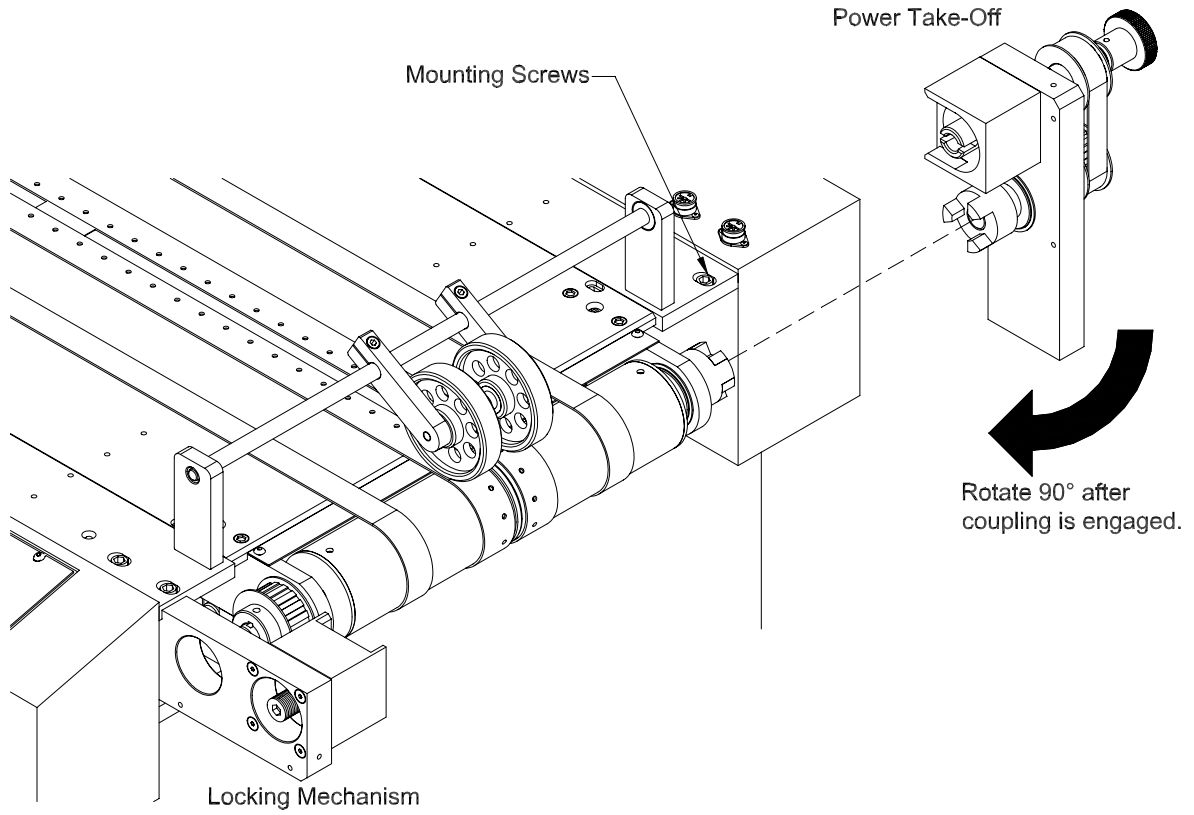


Figure 2-2: *Vacuum Tubing Routing*

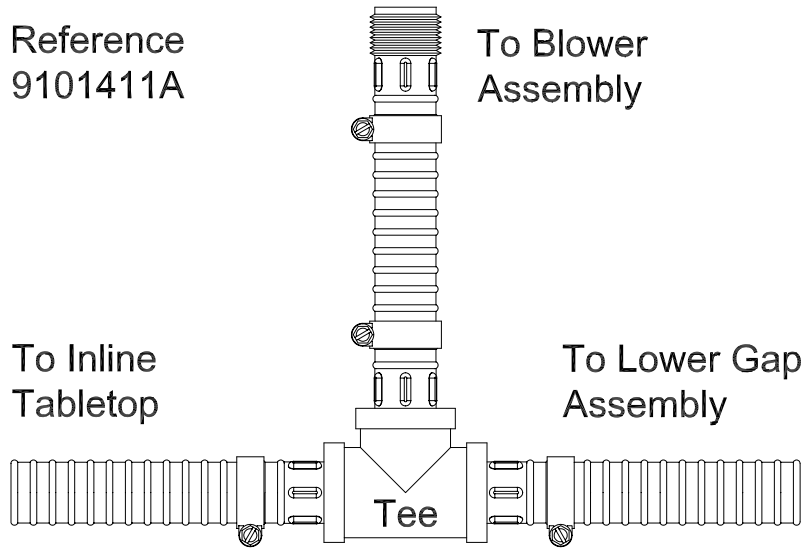
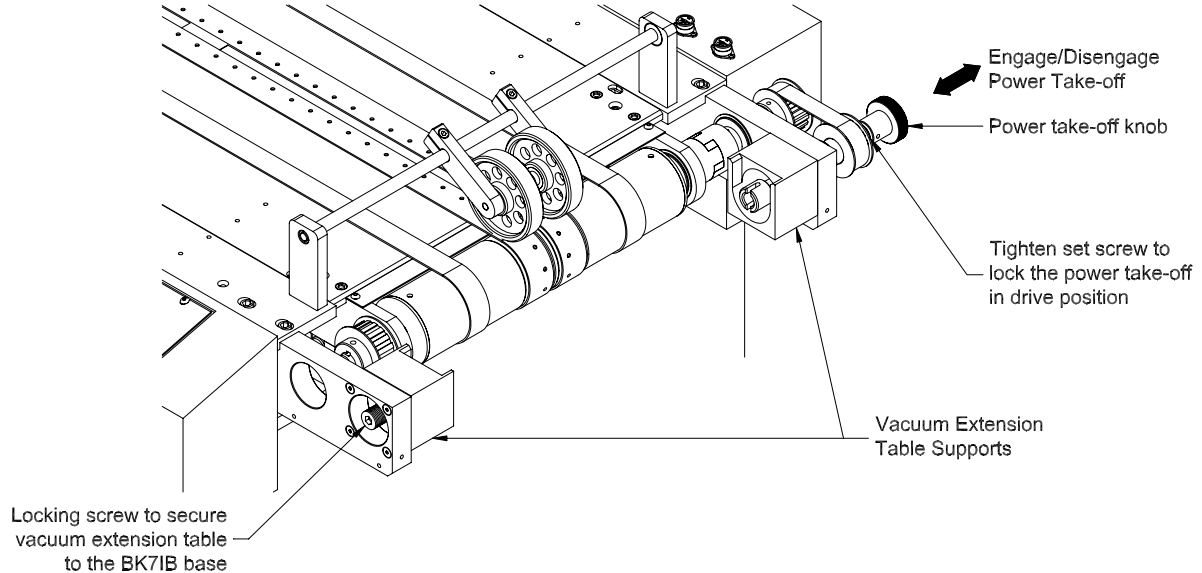


Figure 2-3: *Power Take-Off Unit installed (Covers not shown)*

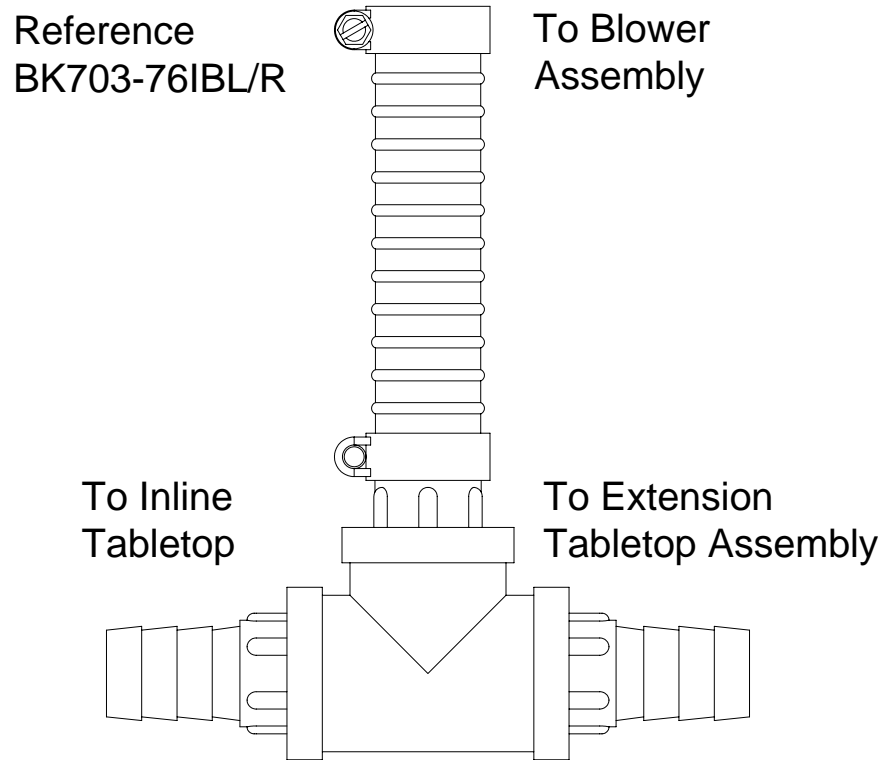
2.2 Integration with a BK761B

In order to install a BK703 to a BK761B, the following instructions should be followed (reference drawings in Appendix A):

1. First attach the two plastic caps onto the rails of the inline base. Then, attach the two mounting brackets (9102737 and 9102738) over the two plastic caps.
2. Route the 80" vacuum tubing into the base and attach it to the tee (Figure 2-4). Attach the 4" long vacuum tubing to the blower and the tee. The tubing from the Inline tabletop should go into the remaining tee opening. This tee assembly should then be placed inside the base cabinet.
3. Drop the BK703-761B's shoulder bolts (9102787) into the mounting brackets of the base assembly and secure it.
4. First pull the timing belt (120352) over the two pulleys (116213). Ensure that the pulleys are facing in the proper directions as shown in the reference drawings. Then place the two pulleys on the shafts of the inline base and the extension table at the same time. Secure it with the woodruff key (430250). Now pull the timing belt over the two pulleys.

5. Now add the cover over the pulleys. The cover must be attached to the mounting bracket first before it is attached to the rails of the inline base. Use the T-Nuts along with the proper screws to accomplish this.

Figure 2-4: *Vacuum Tubing Routing*



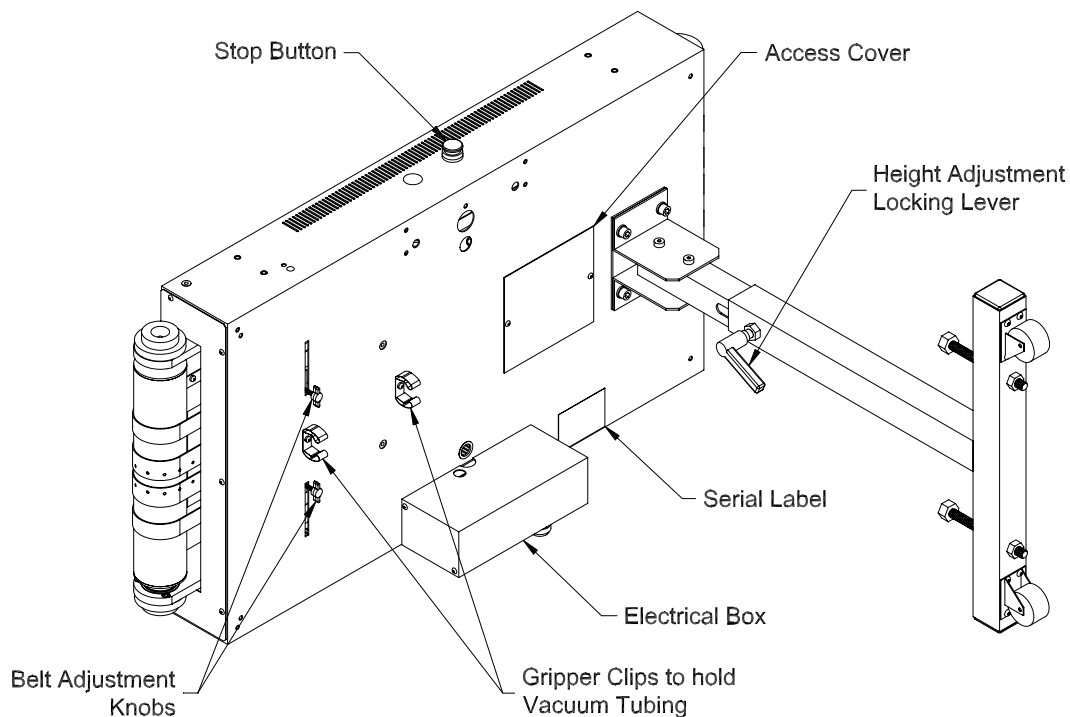
2.3 Belt Adjustment

2.3.1 Belt Position

In order to accommodate different size mail pieces, the BK703 is equipped with adjustable outer belts. This is done by using adjustable belt guides located inside the tabletop. In order to reposition the outer belts, the following instructions can be referenced:

1. Turn the belt adjustment knob shown in Figure 2-5 counter-clockwise (viewed from the bottom of the tabletop) until the belt guide is free to move.
2. Begin running the transport base at a slow speed. For the BK703-7IB, the power take-off must be engaged in order for the BK703 transport belts to move.
3. Using the belt adjustment knob, slowly move the belt guide in the direction desired. This will reposition the outer belt.
4. Turn the belt adjustment knob clockwise until the belt guide is locked in place.

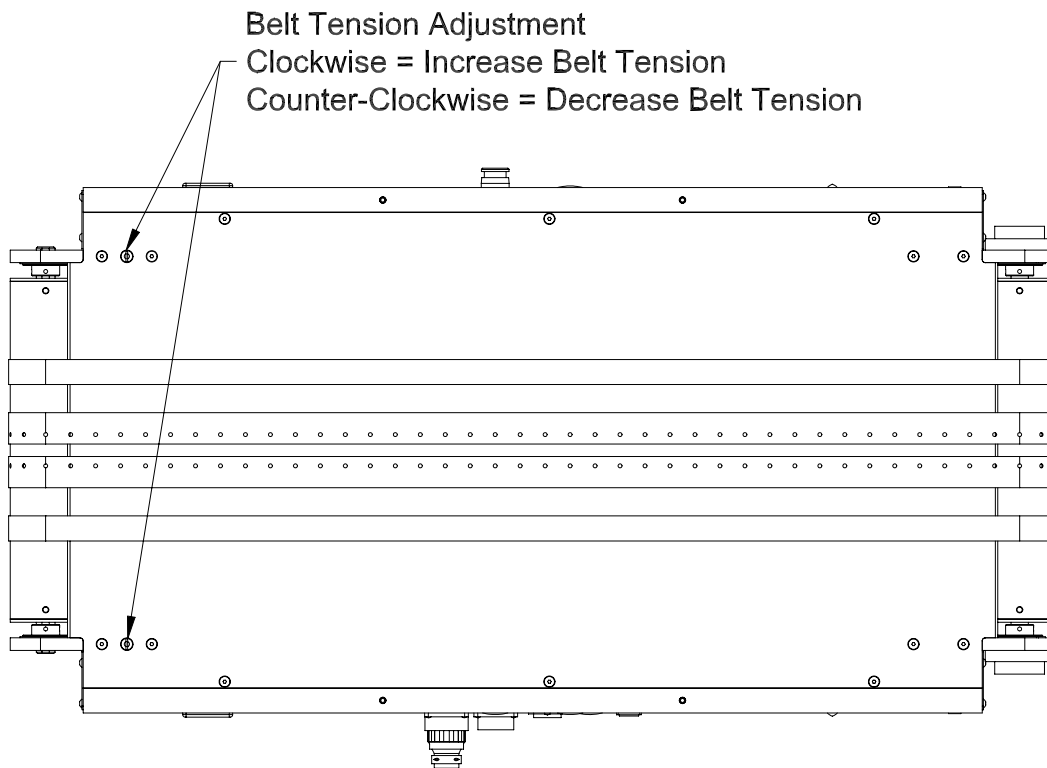
Figure 2-5: *Vacuum Extension Table Bottom View*



2.3.2 Belt Tension

In order to adjust the belt tension, a take-up roller is installed in all BK703 extension tables. The position of the take-up roller can be controlled by turning two tensioning screws located on the tabletop (Figure 2-6). A clockwise rotation will result in an increase in belt tension while a counter-clockwise rotation will result in a decrease in belt tension.

Figure 2-6: *Belt Tension Adjustment*



Note: When adjusting the tension of the belts, it is important to turn both tensioning screws an equal number of rotations. If this is not done, it is possible to cause the belts to skew in one direction.

3.1 Attaching Heaters or Dryers

The BK703 extension table was designed to support either a Research or IAMSCO dryer. Since the mounting requirements are different, two different mounting assemblies are available. This is summarized in Table 3-1. In addition, Figure 3-2 and Figure 3-3 show how the dryers are mounted for the Research and IAMSCO dryers respectively.

Note: For the BK703-761B table, please ensure the dryers are specified with a 12VDC relay.

Table 3-1: *Heater/Dryer Mounting Kits*

Heater/Dryer	Mounting Equipment (Buskro P/N)
Research Dryer 4540-10	9100476A
IAMSCO 3000	9100475A

In order to connect the Heater/Dryer to the Heater Interlock on the BK703 electrical box, a NEMA #ML-2P interlock plug is required. This will mate with the NEMA #ML-2R receptacle on the electrical box. This can be seen in Figure 3-1.

Figure 3-1: *Heater Interlock Cable*

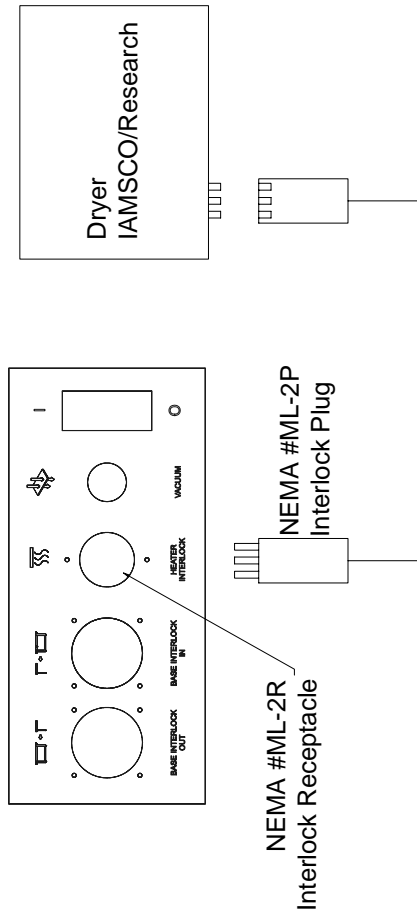


Table 3-2: *Mounting for Research Dryer 4540-10*

Item	Part Number	Quantity	Description	Reference
1	404510	4	Screw, BHCS, 10-32 UNF x 1/4"	
2	405520	8	Screw, BHCS, 1/4-20 UNC x 3/8"	
3	405530	2	Screw, BHCS, 1/4-20 UNC x 1/2"	
4	9100476A	1	Mounting Kit – Research Dryer	
5	BK703	1	Vacuum Extension Table	
6	-	1	Research Dryer (4540-10)	

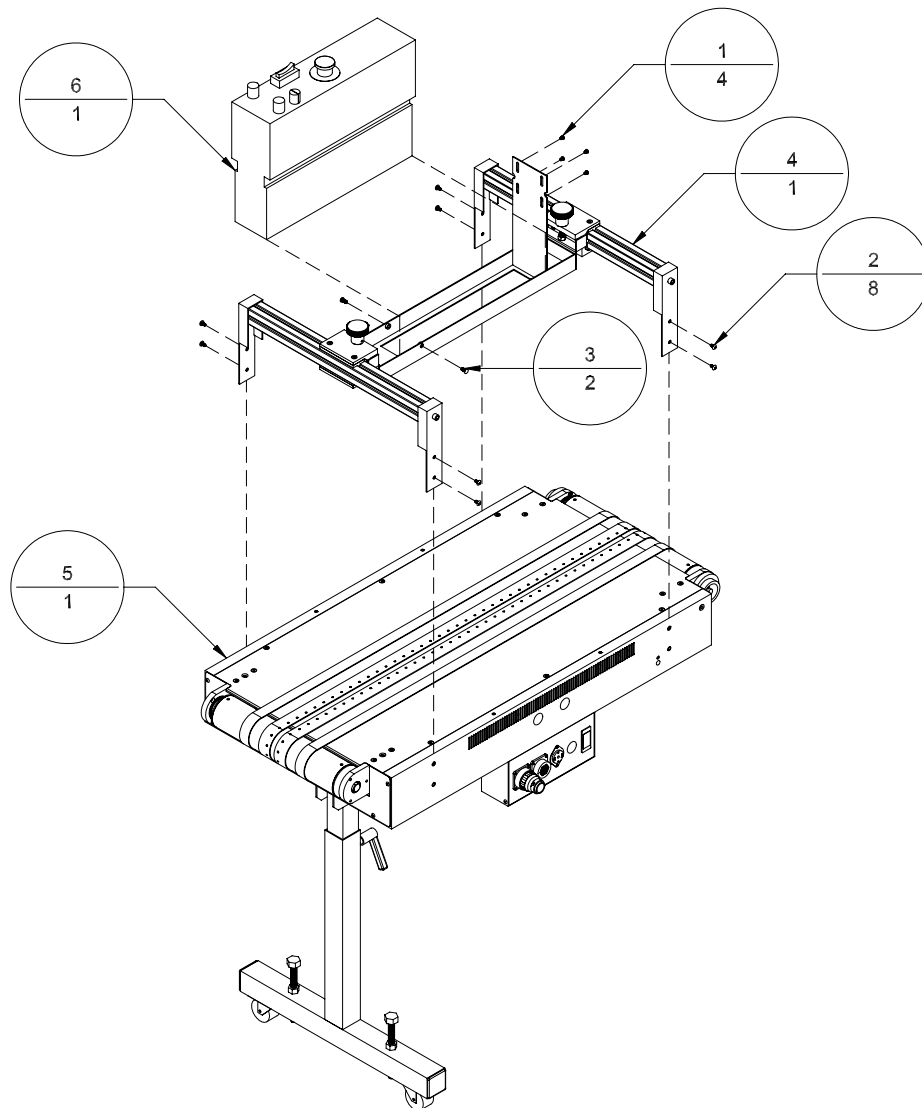
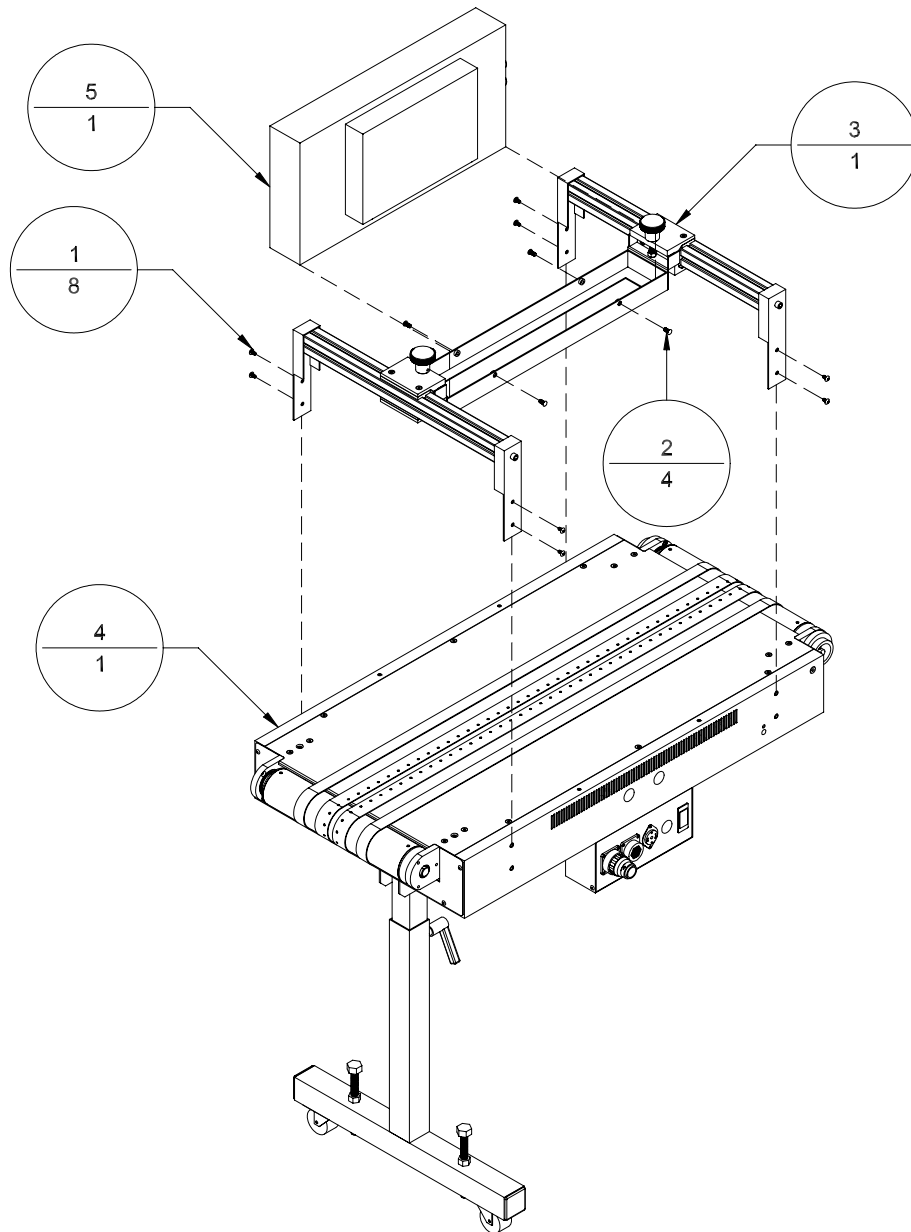
Figure 3-2: *Mounting for Research Dryer 4540-10*

Table 3-3: *Mounting for IAMSCO Dryer 3000*

Item	Part Number	Quantity	Description	Reference
1	405520	8	Screw, BHCS, 1/4-20 UNC x 3/8"	
2	405530	4	Screw, BHCS, 1/4-20 UNC x 1/2"	
3	9100475A	1	Mounting Kit – IAMSCO	
4	BK703	1	Vacuum Extension Table	
5	-	1	IAMSCO #3000	

Figure 3-3: *Mounting for IAMSCO Dryer 3000*

Assembly Drawings

Appendix A

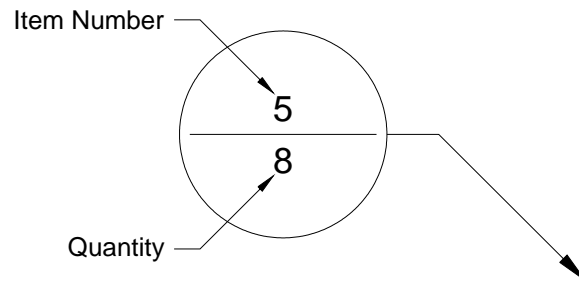
List of Tables

Table A-1: Vacuum Extension Table - BK7IB (BK703-7IB).....	A-1
Table A-2: Vacuum Extension Table - BK7IB Left (BK703-7IBL).....	A-2
Table A-3: Vacuum Extension Table, BK76IB, Left (BK703-76IBL).....	A-3
Table A-4: Vacuum Extension Table, BK76IB, Right (BK703-76IBR).....	A-5
Table A-5: Vacuum Extension Table (BK703).....	A-7
Table A-6: Vacuum Extension Table - Left (BK703L).....	A-8
Table A-7: Power Take Off Unit – BK703/BK7IB (BK715-7IB).....	A-9
Table A-8: Power Take Off – BK703/BK7IB Left (BK715-7IBL).....	A-10
Table A-9: Bridge Assembly – IAMSCO (9100475A).....	A-11
Table A-10: Bridge Assembly – Research (9100476A).....	A-12
Table A-11: T-Leg Assembly (9100484A).....	A-13
Table A-12: Power Take Off (9100755A).....	A-14
Table A-13: Power Take Off – Left (9100755LA).....	A-15
Table A-14: Power Take Off Locking Mechanism (9100760A).....	A-16
Table A-15: Locking Mechanism – Left (9100760LA).....	A-17
Table A-16: Electrical Bracket Assembly (BK703) (9100854A).....	A-18
Table A-17: Take-Up Roller Assembly (9101038A).....	A-20
Table A-18: Vacuum Extension Tabletop Assembly (9101400A).....	A-21
Table A-19: Vacuum Tabletop Assembly - Left (9101400LA).....	A-23
Table A-20: Vacuum Chassis Assembly (9101409A).....	A-25
Table A-21: Lower Gap Assembly – BK703/BK7IB (9101411A).....	A-27
Table A-22: Plug, Jumper, 23-57 (9102055A).....	A-28
Table A-23: Universal Interconnect Cable (9102083A).....	A-29
Table A-24: Tabletop, Extension Assembly, Left (9102282LA).....	A-30
Table A-25: Tabletop, Extension Assembly, Right (9102282RA).....	A-32

List of Figures

Figure A-1: Vacuum Extension Table - BK7IB (BK703-7IB).....	A-1
Figure A-2: Vacuum Extension Table - BK7IB (BK703-7IBL)	A-2
Figure A-3: Vacuum Extension Table, BK76IB, Left (BK703-76IBL)	A-4
Figure A-4: Vacuum Extension Table, BK76IB, Right (BK703-76IBR).....	A-6
Figure A-5: Vacuum Extension Table (BK703).....	A-7
Figure A-6: Vacuum Extension Table – Left (BK703L).....	A-8
Figure A-7: Power Take Off Unit – BK703/BK7IB (BK715-7IB)	A-9
Figure A-8: Power Take Off – BK703/BK7IB Left (BK715-7IBL)	A-10
Figure A-9: Bridge Assembly – IAMSCO (9100475A).....	A-11
Figure A-10: Bridge Assembly – Research (9100476A).....	A-12
Figure A-11: T-Leg Assembly (9100484A)	A-13
Figure A-12: Power Take Off (9100755A).....	A-14
Figure A-13: Power Take Off - Left (9100755LA)	A-15
Figure A-14: Power Take Off Locking Mechanism (9100760A).....	A-16
Figure A-15: Locking Mechanism – Left (9100760LA)	A-17
Figure A-16: Electrical Bracket Assembly (BK703) (9100854A)	A-19
Figure A-17: Take-Up Roller Assembly (9101038A).....	A-20
Figure A-18: Vacuum Extension Tabletop Assembly (9101400A).....	A-22
Figure A-19: Vacuum Tabletop Assembly - Left (9101400LA)	A-24
Figure A-20: Vacuum Chassis Assembly (9101409A).....	A-26
Figure A-21: Lower Gap Assembly – BK703/BK7IB (9101411A)	A-27
Figure A-22: Plug, Jumper, 23-57 (9102055A).....	A-28
Figure A-23: Universal Interconnect Cable (9102083A)	A-29
Figure A-24: Tabletop, Extension Assembly, Left (9102282LA)	A-31
Figure A-25: Tabletop, Extension Assembly, Right (9102282RA).....	A-33

Balloon Annotation and Parts Listing



Item	Part Number	Quantity	Description	Reference
1				
2				

The following is a description of how to interpret the information in this section:

Item:

This column indicates the item number used for each unique part in an assembly drawing. It is matched with the top number in the balloon pointing at the associated part.

Part Number:

This column represents the Buskro part number.

Quantity:

This represents the total number of a given part in an assembly. It is matched with the bottom number in the balloon pointing at the associated part.

Description:

This column contains a brief description of the part.

Reference:

This column indicates the page location for sub-assemblies.

Table A-1: *Vacuum Extension Table - BK71B (BK703-71B)*

Item	Part Number	Quantity	Description	Reference
1	9102083A	1	Universal Interconnect Cable	Page A-29
2	BK703	1	Vacuum Extension Table	Page A-7
3	BK715-71B	1	Power Take Off Unit (BK703/BK71B)	Page A-9

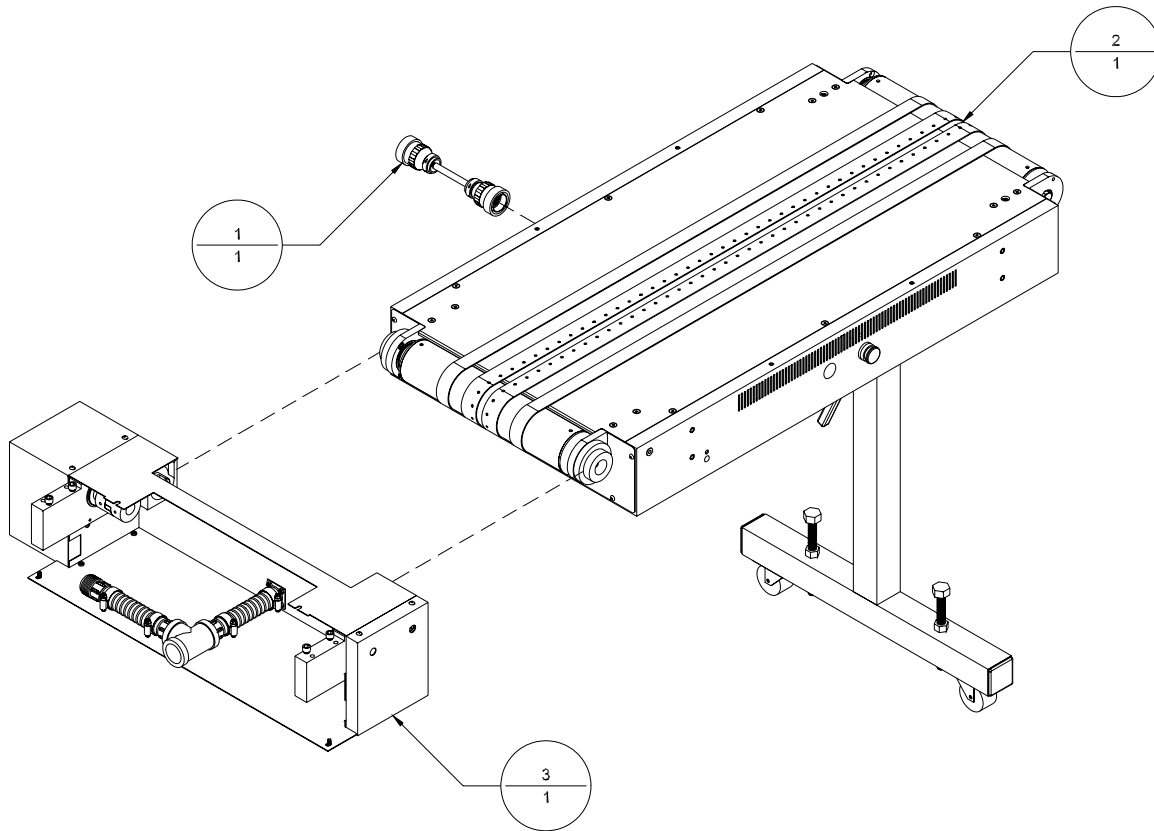
Figure A-1: *Vacuum Extension Table - BK71B (BK703-71B)*

Table A-2: *Vacuum Extension Table - BK7IB Left (BK703-7IBL)*

Item	Part Number	Quantity	Description	Reference
1	9102083A	1	Universal Interconnect Cable	Page A-29
2	BK703L	1	Vacuum Extension Table (Left)	Page A-8
3	BK715-7IBL	1	Power Take Off Unit (BK703/BK7IB Left)	Page A-9

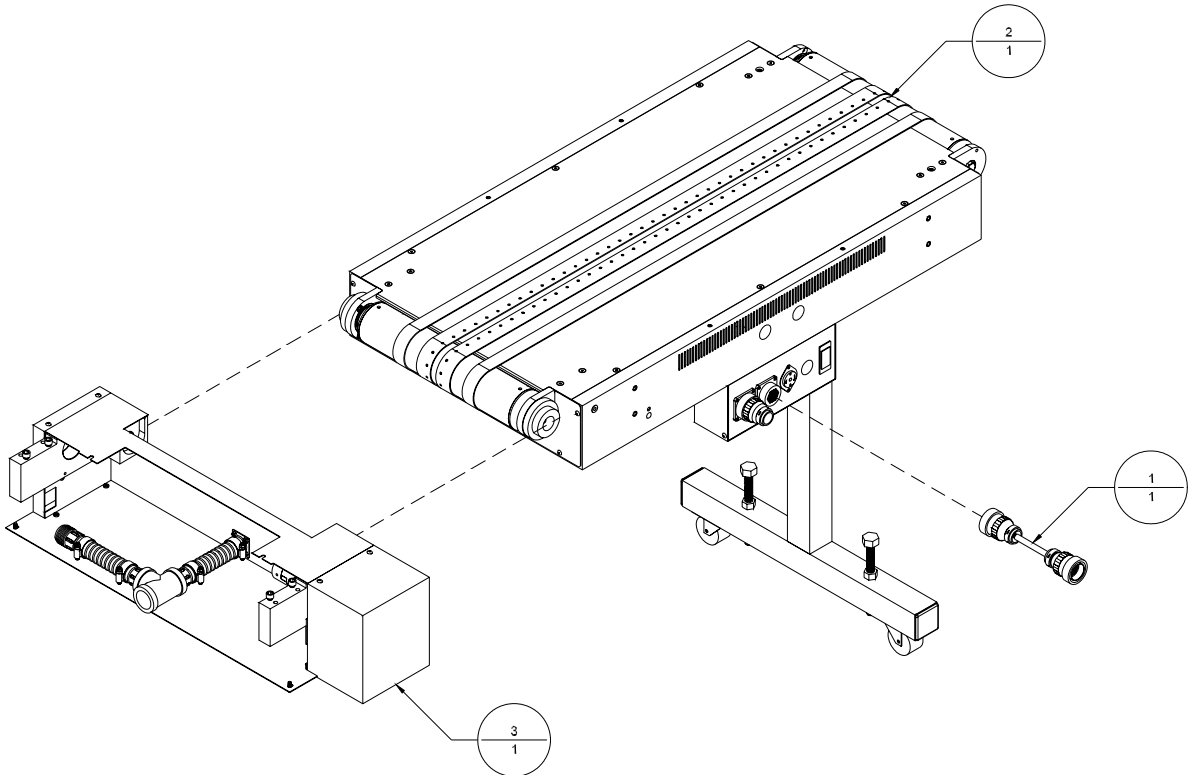
Figure A-2: *Vacuum Extension Table - BK7IB (BK703-7IBL)*

Table A-3: *Vacuum Extension Table, BK761B, Left (BK703-761BL)*

Item	Part Number	Quantity	Description	Reference
1	116213	2	Pulley, 16LF075 x 3/4	
2	120352	1	Timing Belt, 124L075	
3	404030	6	Screw, FHCS, 10-32 UNF x 1/2"	
4	404510	16	Screw, BHCS, 10-32 UNF x 1/4"	
5	404520	4	Screw, BHCS, 10-32 UNF x 3/8"	
6	405250	4	Screw, SHCS, 1/4-20 UNC x 3/4"	
7	405520	4	Screw, BHCS, 1/4-20 UNC x 3/8"	
8	430250	2	Woodruff Key, #606, 3/16 x 3/4	
9	439009	4	Lockwasher, No. 10	
10	440030	4	Washer, 1/2" ID	
11	444004	2	Clamp, Hose, Gear Type, 9/16 x 1 1/4"	
12	603121	1	Switch, Red Mushroom Push Button	
13	603125	1	Switch Locking Collar	
14	603127	1	Block, N.C. Contact, Red	
15	615026	1	Flexible Grommet Edging (2.75" Long)	
16	615100	3	Adhesive Backed Tie Mount	
17	615140	3	Lashing Tie	
18	615425	3	Hole Plug, 7/8"	
19	802111	3	Hose Barb, 1" x 1", Plastic	
20	802601	1	Tubing, Vacuum, Grey PVC, 80" Long	
21	9100361	2	T-Nut, 1/4-20 Triple	
22	9100826	1	Tee, Female, 1" NPT	
23	9100854A	1	Electrical Bracket Assembly (BK703)	Page A-18
24	9100860	1	Electrical Bracket Cover	
25	9101409A	1	Vacuum Chassis Assembly	Page A-25
26	9101410	1	Vacuum Table End cover	
27	9101627	1	Buskro Serial Number Label	
28	9102083A	1	Universal Interconnect Cable	Page A-29
29	9102282LA	1	Tabletop, Extension Assembly, Left	Page A-30
30	9102737	1	Bracket, Extension Table Mount, Front	
31	9102738	1	Bracket, Extension Table Mount, Rear	
32	9102787	2	Shoulder Bolt, 1/2" x 5/8", (3/8" – 16)	
33	9102797	1	Cover, Extension Table Pulley	
34	9103397	1	Cover, Vacuum Table End, Safety	

Figure A-3: Vacuum Extension Table, BK761B, Left (BK703-761BL)

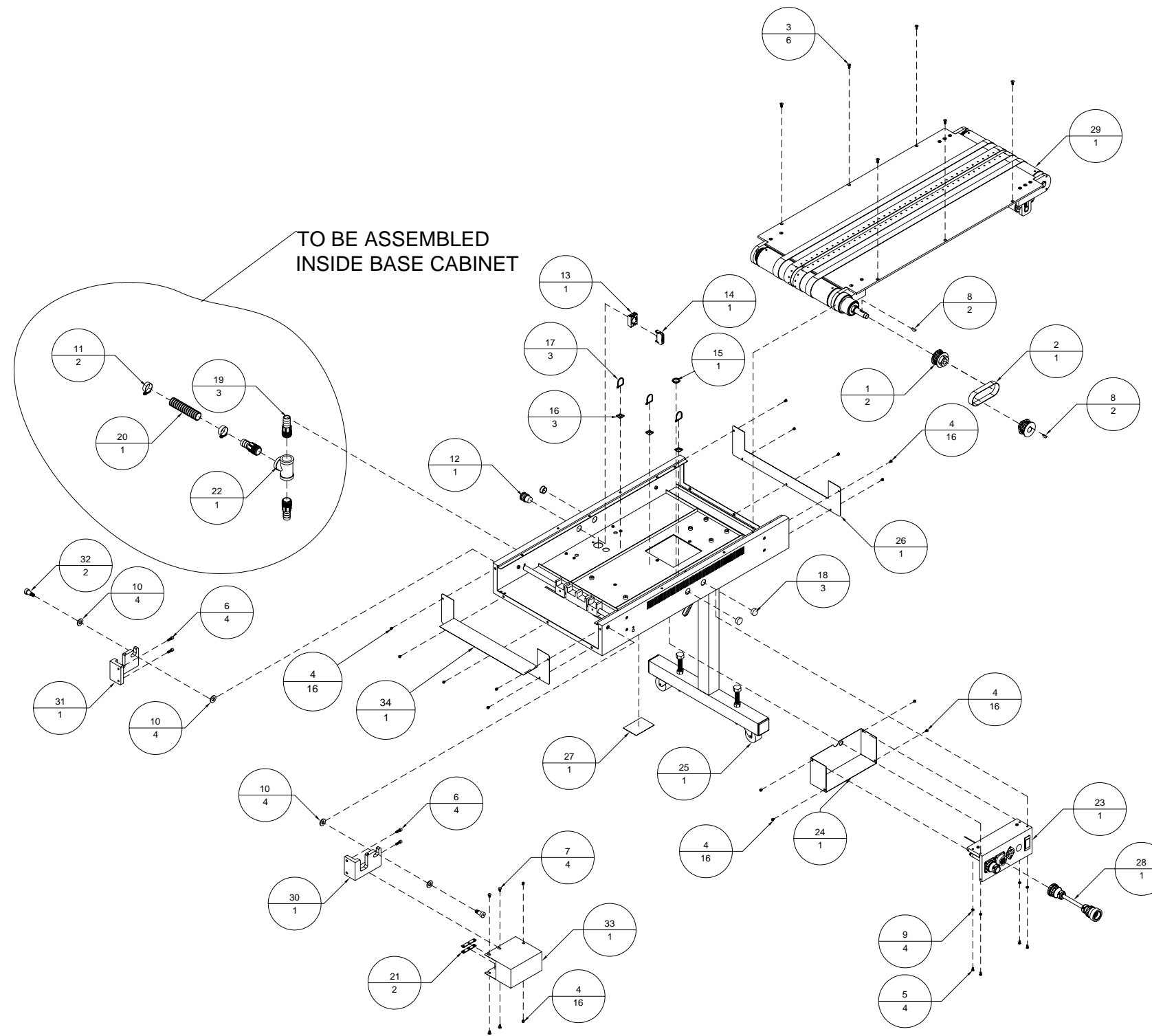


Table A-4: *Vacuum Extension Table, BK761B, Right (BK703-761BR)*

Item	Part Number	Quantity	Description	Reference
1	116213	2	Pulley, 16LF075 x 3/4	
2	120352	1	Timing Belt, 124L075	
3	404030	6	Screw, FHCS, 10-32 UNF x 1/2"	
4	404510	16	Screw, BHCS, 10-32 UNF x 1/4"	
5	404520	4	Screw, BHCS, 10-32 UNF x 3/8"	
6	405250	4	Screw, SHCS, 1/4-20 UNC x 3/4"	
7	405520	4	Screw, BHCS, 1/4-20 UNC x 3/8"	
8	430250	2	Woodruff Key, #606, 3/16 x 3/4	
9	439009	4	Lockwasher, No. 10	
10	440030	4	Washer, 1/2" ID	
11	444004	2	Clamp, Hose, Gear Type, 9/16 x 1 1/4"	
12	603121	1	Switch, Red Mushroom Push Button	
13	603125	1	Switch Locking Collar	
14	603127	1	Block, N.C. Contact, Red	
15	615026	1	Flexible Grommet Edging (2.75" Long)	
16	615100	3	Adhesive Backed Tie Mount	
17	615140	3	Lashing Tie	
18	615425	3	Hole Plug, 7/8"	
19	802111	3	Hose Barb, 1" x 1", Plastic	
20	802601	1	Tubing, Vacuum, Grey PVC, 80" Long	
21	9100361	2	T-Nut, 1/4-20 Triple	
22	9100826	1	Tee, Female, 1" NPT	
23	9100854A	1	Electrical Bracket Assembly (BK703)	Page A-18
24	9100860	1	Electrical Bracket Cover	
25	9101409A	1	Vacuum Chassis Assembly	Page A-25
26	9101410	1	Vacuum Table End cover	
27	9101627	1	Buskro Serial Number Label	
28	9102083A	1	Universal Interconnect Cable	Page A-29
29	9102282RA	1	Tabletop, Extension Assembly, Right	Page A-32
30	9102737	1	Bracket, Extension Table Mount, Front	
31	9102738	1	Bracket, Extension Table Mount, Rear	
32	9102787	2	Shoulder Bolt, 1/2" x 5/8", (3/8" – 16)	
33	9102797	1	Cover, Extension Table Pulley	
34	9103397	1	Cover, Vacuum Table End, Safety	

Figure A-4: Vacuum Extension Table, BK761B, Right (BK703-761BR)

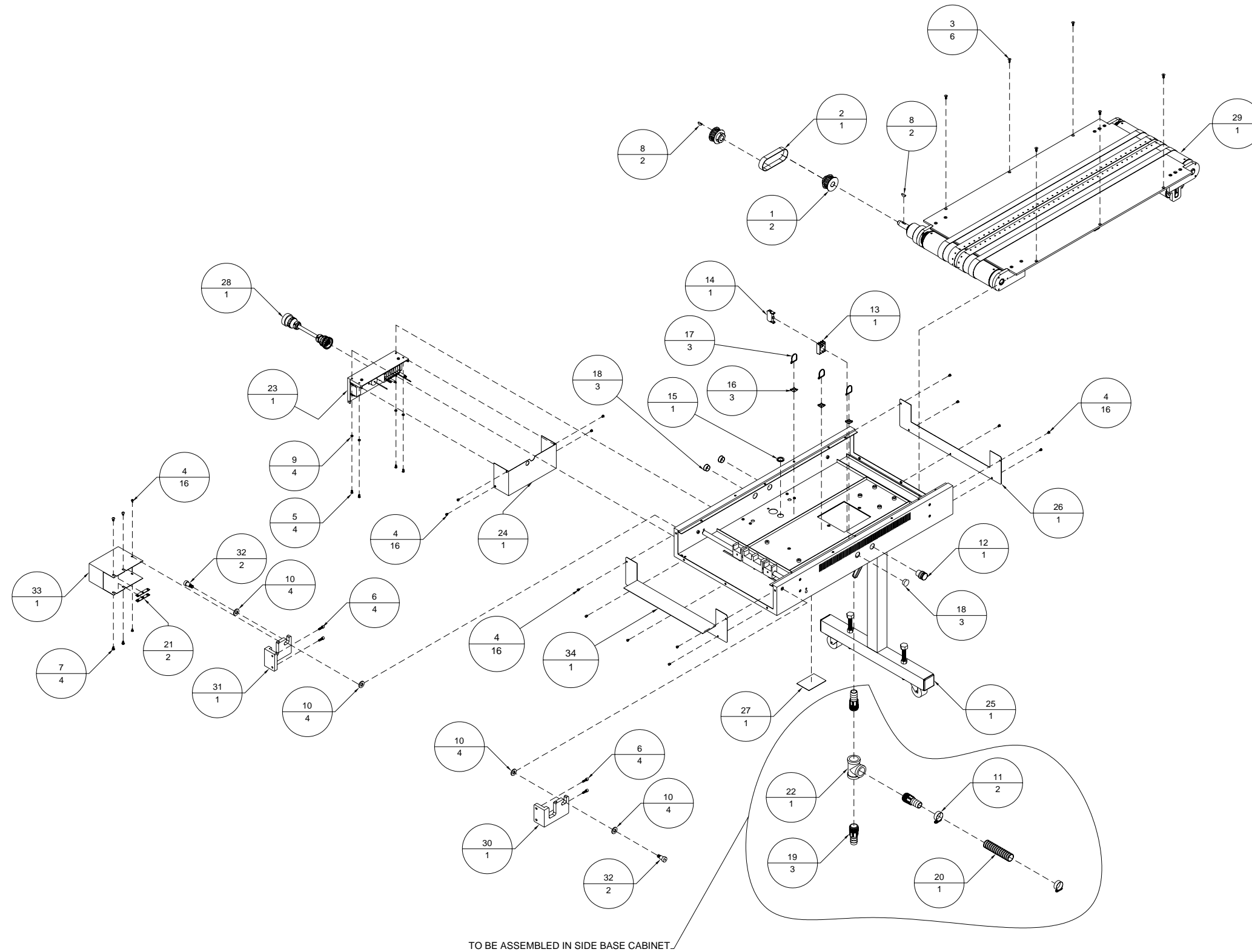


Table A-5: *Vacuum Extension Table (BK703)*

Item	Part Number	Quantity	Description	Reference
1	404030	6	Screw, FHCS, 10-32 UNF x 1/2"	
2	404510	14	Screw, BHCS, 10-32 UNF x 1/4"	
3	404520	4	Screw, BHCS, 10-32 UNF x 3/8"	
4	439009	4	Lockwasher, No. 10	
5	603121	1	Switch, Red Mushroom Push Button	
6	603125	1	Switch Locking Collar	
7	603127	1	Block, N.C. Contact	
8	615026	2.75"	Flexible Grommet Edging	
9	615100	3	Adhesive Backed Tie Mount	
10	615140	3	Lashing Tie	
11	615425	3	Hole Plug, 7/8" I.D.	
12	9100854A	1	Electrical Bracket Assembly	Page A-18
13	9100860	1	Electrical Bracket Cover	
14	9101400A	1	Vacuum Extension Tabletop Assembly	Page A-21
15	9101409A	1	Vacuum Chassis Assembly	Page A-25
16	9101410	2	Vacuum Table End Cover	
17	9101627	1	Buskro Serial Number Label	

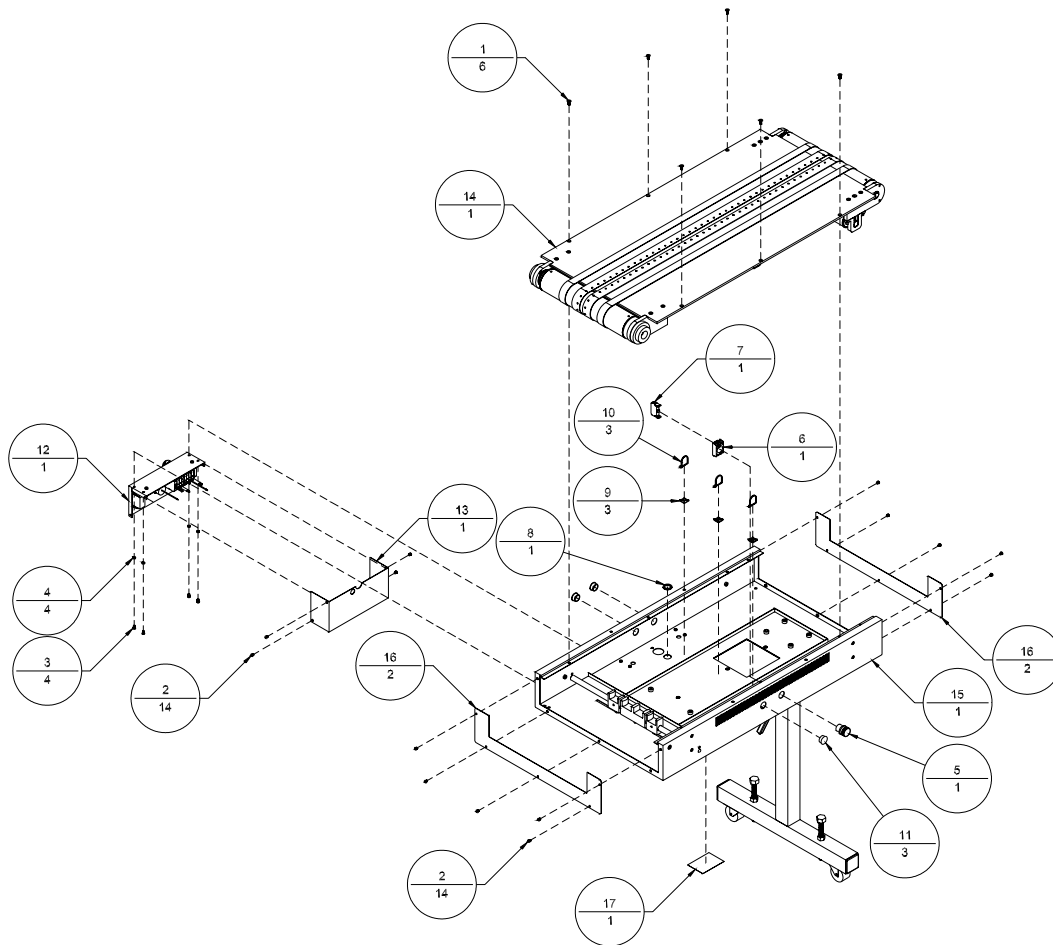
Figure A-5: *Vacuum Extension Table (BK703)*

Table A-6: *Vacuum Extension Table - Left (BK703L)*

Item	Part Number	Quantity	Description	Reference
1	404030	6	Screw, FHCS, 10-32 UNF x 1/2"	
2	404510	14	Screw, BHCS, 10-32 UNF x 1/4"	
3	404520	4	Screw, BHCS, 10-32 UNF x 3/8"	
4	439009	4	Lockwasher, No. 10	
5	603121	1	Switch, Red Mushroom Push Button	
6	603125	1	Switch Locking Collar	
7	603127	1	Block, N.C. Contact	
8	615026	2.75"	Flexible Grommet Edging	
9	615100	3	Adhesive Backed Tie Mount	
10	615140	3	Lashing Tie	
11	615425	3	Hole Plug, 7/8" I.D.	
12	9100854A	1	Electrical Bracket Assembly	Page A-18
13	9100860	1	Electrical Bracket Cover	
14	9101400LA	1	Vacuum Tabletop Assembly (Left)	Page A-23
15	9101409A	1	Vacuum Chassis Assembly	Page A-25
16	9101410	2	Vacuum Table End Cover	
17	9101627	1	Buskro Serial Number Label	

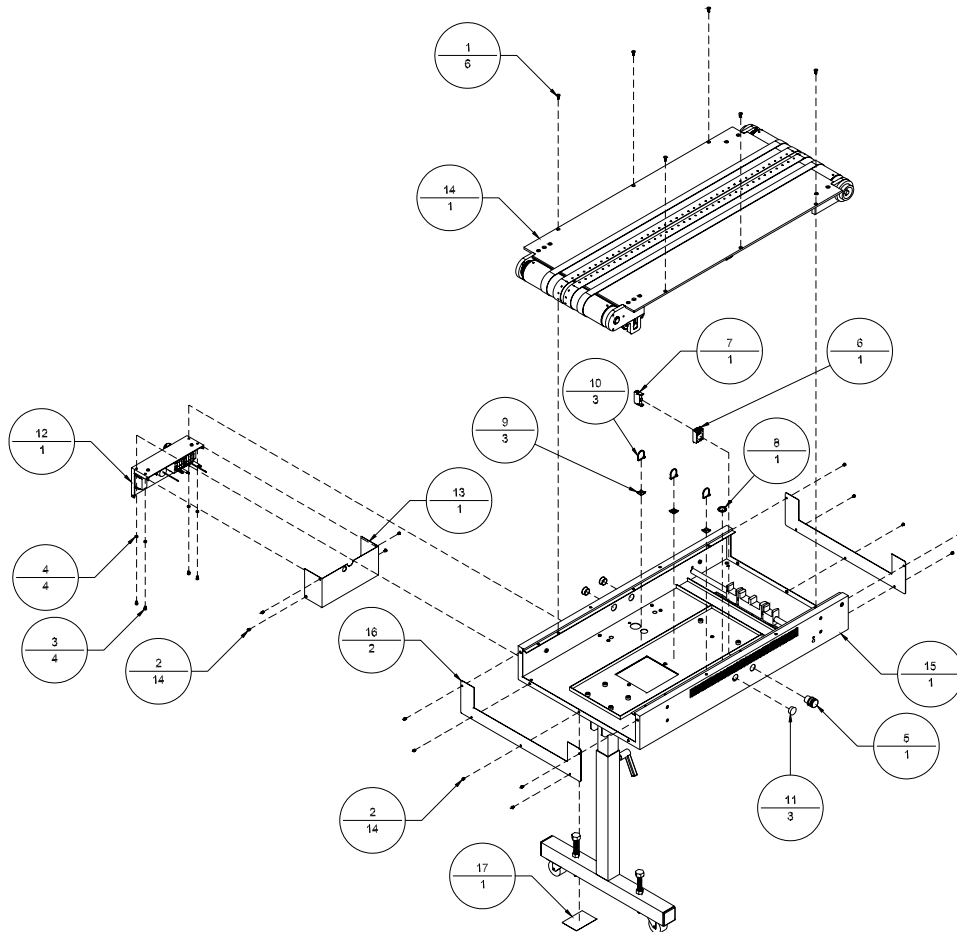
Figure A-6: *Vacuum Extension Table – Left (BK703L)*

Table A-7: *Power Take Off Unit – BK703/BK71B (BK715-71B)*

Item	Part Number	Quantity	Description	Reference
1	404050	4	Screw, FHCS, 10-32 UNF x 3/4"	
2	404510	14	Screw, BHCS, 10-32 UNF x 1/4"	
3	404520	2	Screw, BHCS, 10-32 UNF x 3/8"	
4	9100755A	1	Power Take Off	Page A-14
5	9100760A	1	Power Take Off Locking Mechanism	Page A-16
6	9101411A	1	Lower Gap Assembly (BK703/BK71B)	Page A-27
7	9101412	1	Upper Gap Cover (BK703/BK71B)	
8	9101413	1	Power Take Off Cover	
9	9101420	1	Front Power Take Off Cover	
10	9101978	1	Power Takeoff Cross Bar	

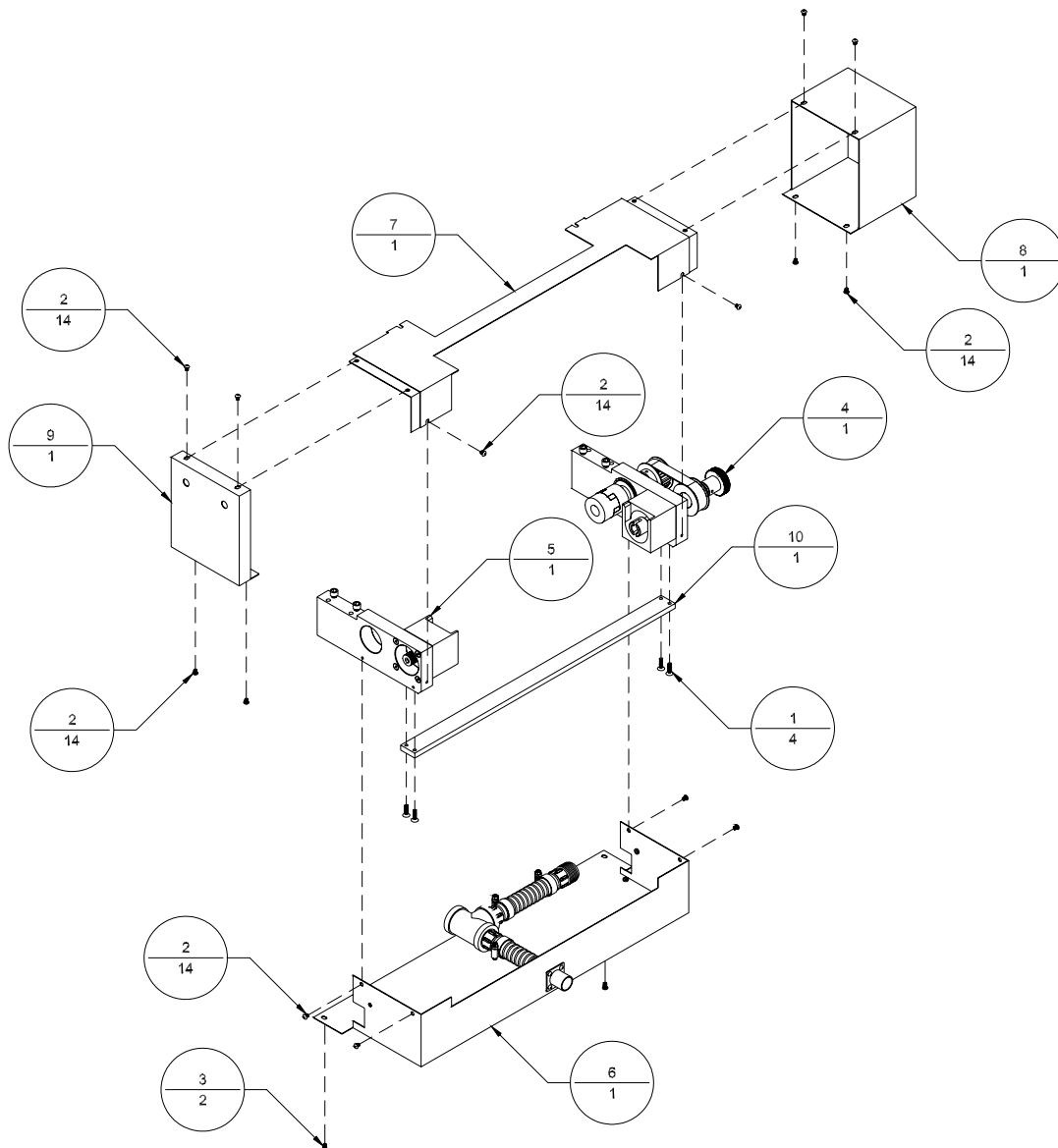
Figure A-7: *Power Take Off Unit – BK703/BK71B (BK715-71B)*

Table A-8: *Power Take Off – BK703/BK71B Left (BK715-71BL)*

Item	Part Number	Quantity	Description	Reference
1	404050	4	Screw, FHCS, 10-32 UNF x 3/4"	
2	404510	14	Screw, BHCS, 10-32 UNF x 1/4"	
3	404520	2	Screw, BHCS, 10-32 UNF x 3/8"	
4	9100755LA	1	Power Take Off (Left)	Page A-15
5	9100760LA	1	Locking Mechanism (Left)	Page A-17
6	9101411A	1	Lower Gap Assembly (BK703/BK71B)	Page A-27
7	9101412	1	Upper Gap Cover (BK703/BK71B)	
8	9101413	1	Power Take Off Cover	
9	9101420	1	Front Power Take Off Cover	
10	9101978	1	Power Takeoff Cross Bar	

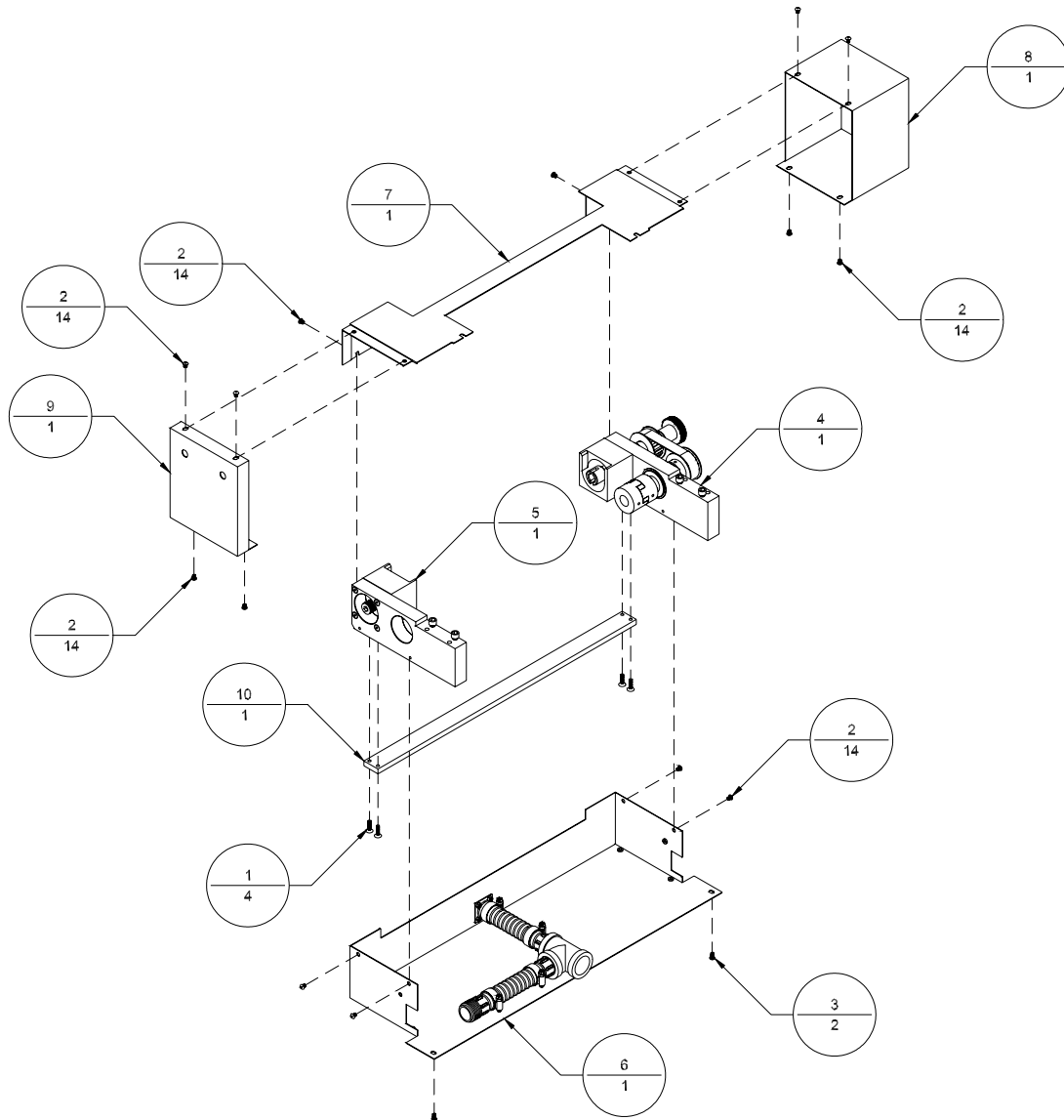
Figure A-8: *Power Take Off – BK703/BK71B Left (BK715-71BL)*

Table A-9: *Bridge Assembly – IAMSCO (9100475A)*

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

Figure A-9: *Bridge Assembly – IAMSCO (9100475A)*

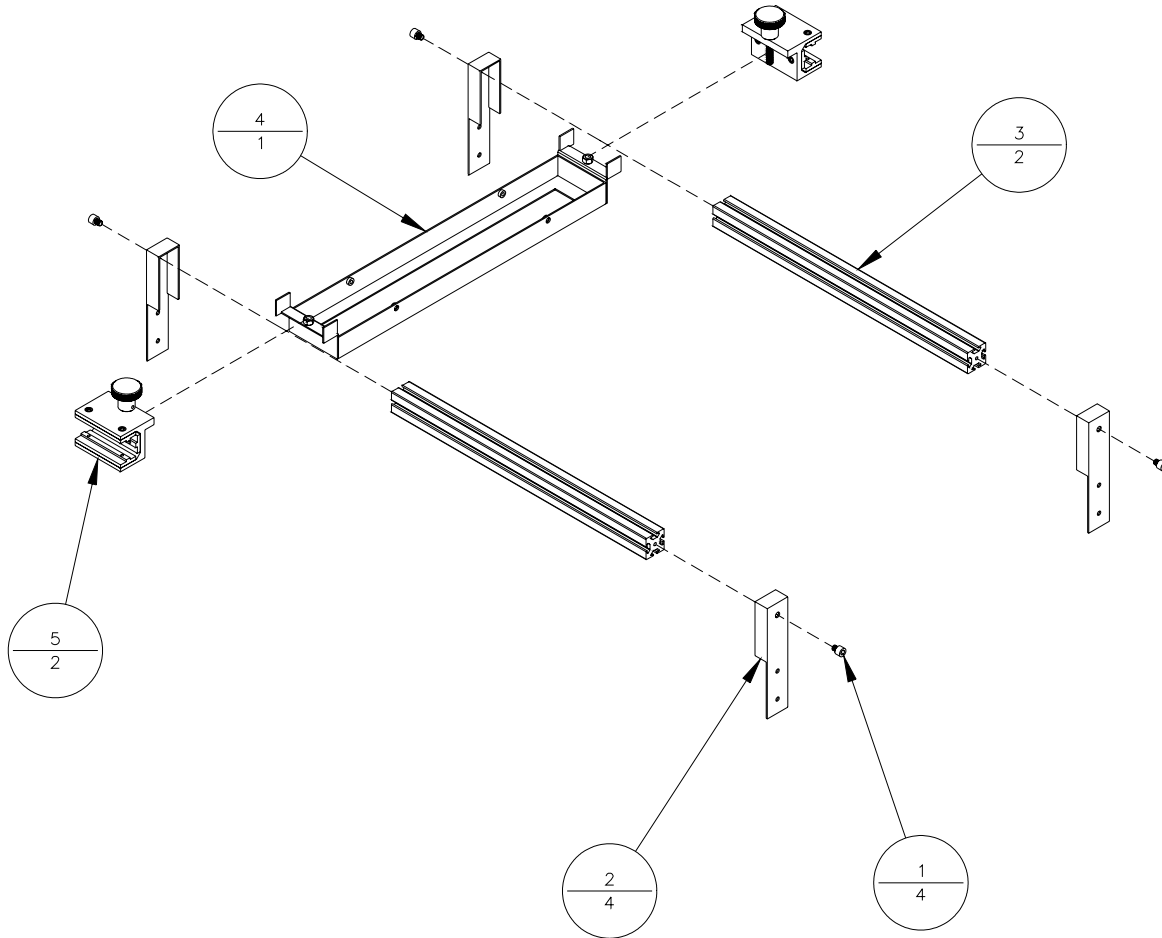


Table A-10: *Bridge Assembly – Research (9100476A)*

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

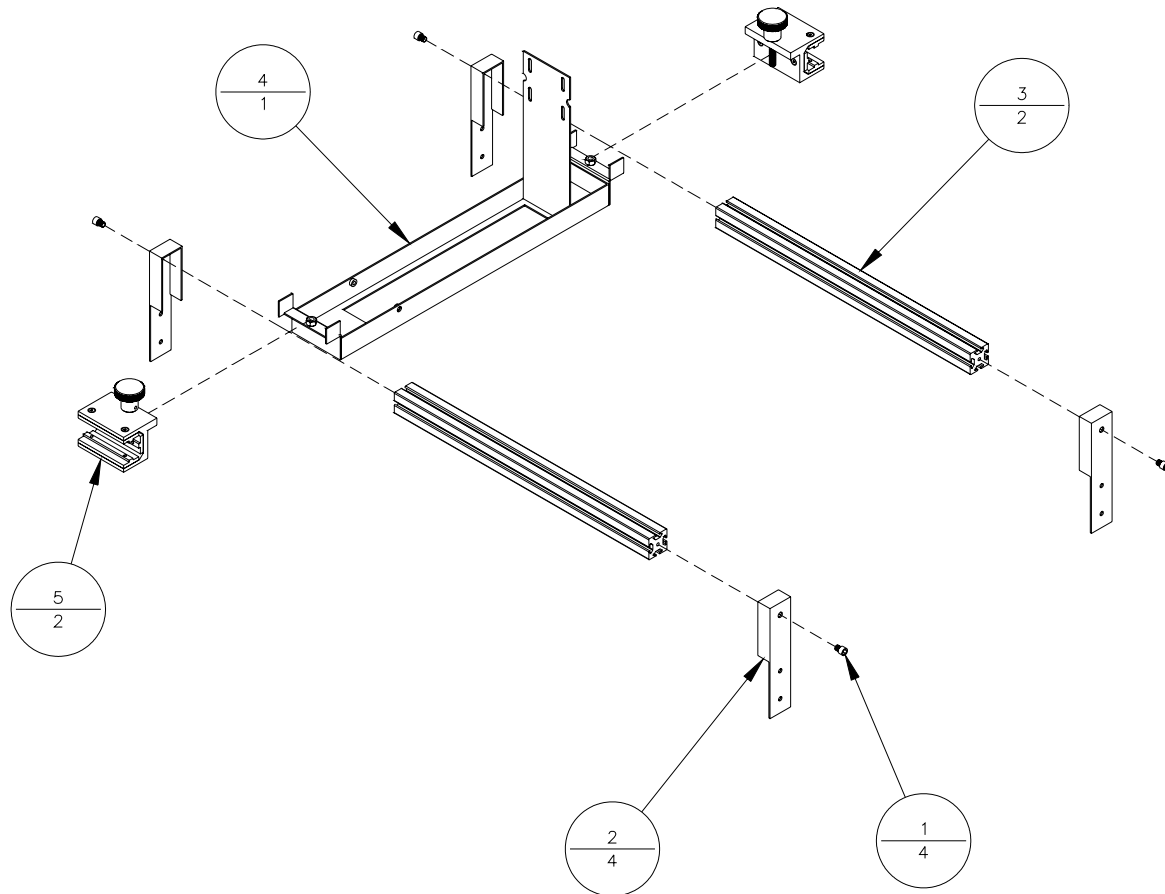
Figure A-10: *Bridge Assembly – Research (9100476A)*

Table A-11: *T-Leg Assembly (9100484A)*

Item	Part Number	Quantity	Description	Reference
1	343150	2	Mounting Leg	
2	343151	2	Nut, 1/2-13 UNC, Black	
3	405510	8	Screw, BHCS, 1/4-20 UNC x 1/4"	
4	9100327A	1	Support Leg	
5	9100484	2	Caster, 2"	
6	9100486	1	Lever Handle, 1/2-13 UNC x 2-1/2"	
7	9100493	2	Endcap, 2"	

Figure A-11: *T-Leg Assembly (9100484A)*

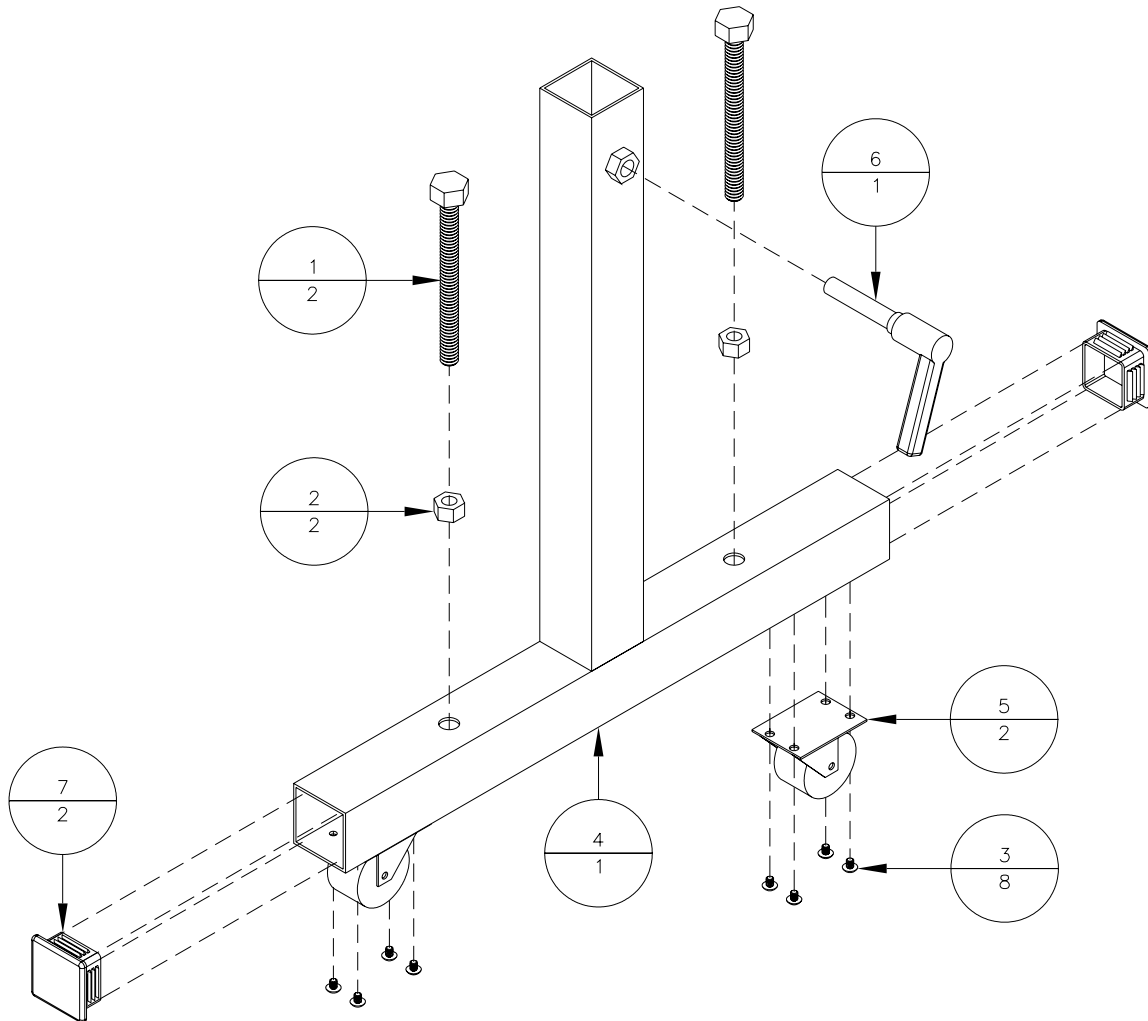


Table A-12: Power Take Off (9100755A)

Item	Part Number	Quantity	Description	Reference
1	116213	1	Pulley, 16LF075 X 3/4"	
2	116216	1	Pulley, 16LF075 x 1"	
3	120352	1	Timing Belt, 124L075	
4	404080	4	Screw, FHCS, 10-32 UNF x 1 1/2"	
5	404810	2	Screw, SHSS, 10-32 UNF x 1/4"	
6	406250	2	Screw, SHCS, 5/16-18 UNC x 3/4"	
7	430250	1	Woodruff Key, #606, 3/16 X 3/4	
8	436300	1	Spring Pin, 3/16" Dia. X 1 3/4" Long	
9	438007H	1	Upper Roller Knob	
10	500055	2	Bearing, UBR-204-12S, 3/4" ID	
11	500075	2	Bearing, UBR205-16S, 1" I.D.	
12	9100755	1	Power Takeoff Bracket	
13	9100756	1	Power Takeoff Drive Shaft	
14	9100759	1	Power Takeoff Support	
15	9101035	2	Coupling Hub, 1-3/4 DIA x 2-1/8 x 3/4" I.D.	
16	9101036	1	Coupling Insert, 3/4" I.D.	
17	9103665A	1	Power TakeOff Disconnect Assembly	

Figure A-12: Power Take Off (9100755A)

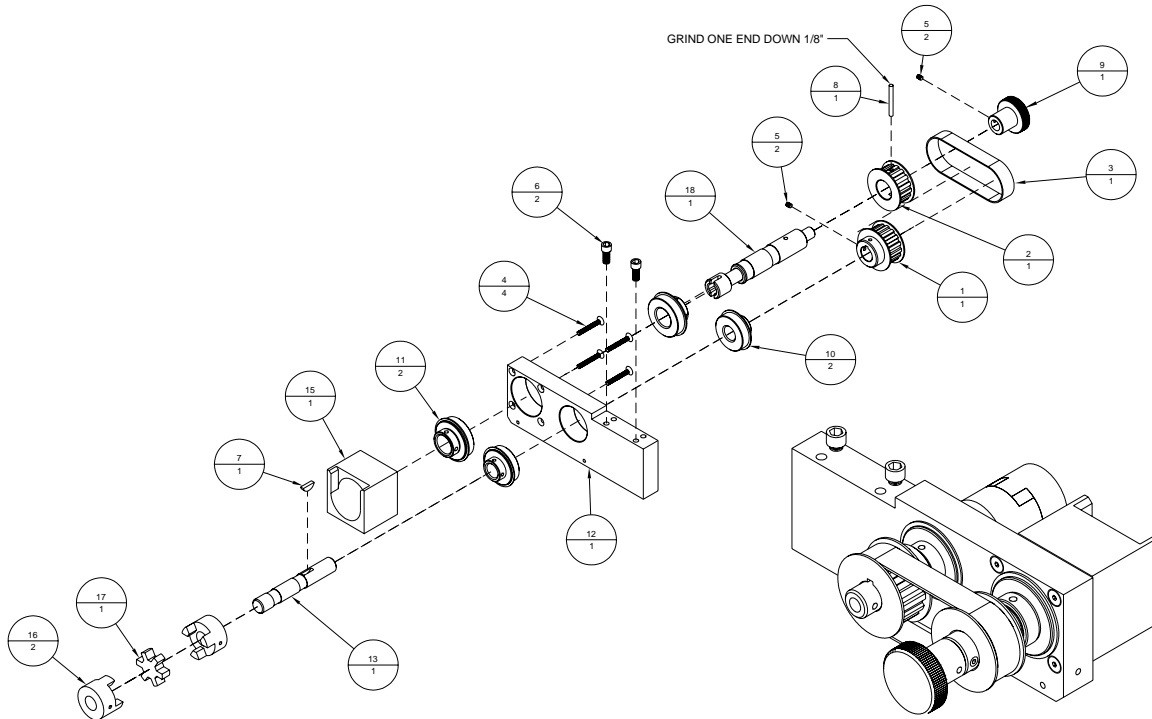


Table A-13: *Power Take Off – Left (9100755LA)*

Item	Part Number	Quantity	Description	Reference
1	116213	1	Pulley, 16LF075 X 3/4"	
2	116216	1	Pulley, 16LF075 x 1"	
3	120352	1	Timing Belt, 124L075	
4	404080	4	Screw, FHCS, 10-32 UNF x 1 1/2"	
5	404810	2	Screw, SHSS, 10-32 UNF x 1/4"	
6	406250	2	Screw, SHCS, 5/16-18 UNC x 3/4"	
7	430250	1	Woodruff Key, #606, 3/16 X 3/4	
8	436300	1	Spring Pin, 3/16" Dia. X 1 3/4" Long	
9	438007H	1	Upper Roller Knob	
10	500055	2	Bearing, UBR-204-12S, 3/4" ID	
11	500075	2	Bearing, UBR205-16S, 1" I.D.	
12	9100755	1	Power Takeoff Bracket	
13	9100756	1	Power Takeoff Drive Shaft	
14	9100759	1	Power Takeoff Support	
15	9101035	2	Coupling Hub, 1-3/4 DIA x 2-1/8 x 3/4" I.D.	
16	9101036	1	Coupling Insert, 3/4" I.D.	
17	9103665A	1	Power TakeOff Disconnect Assembly	

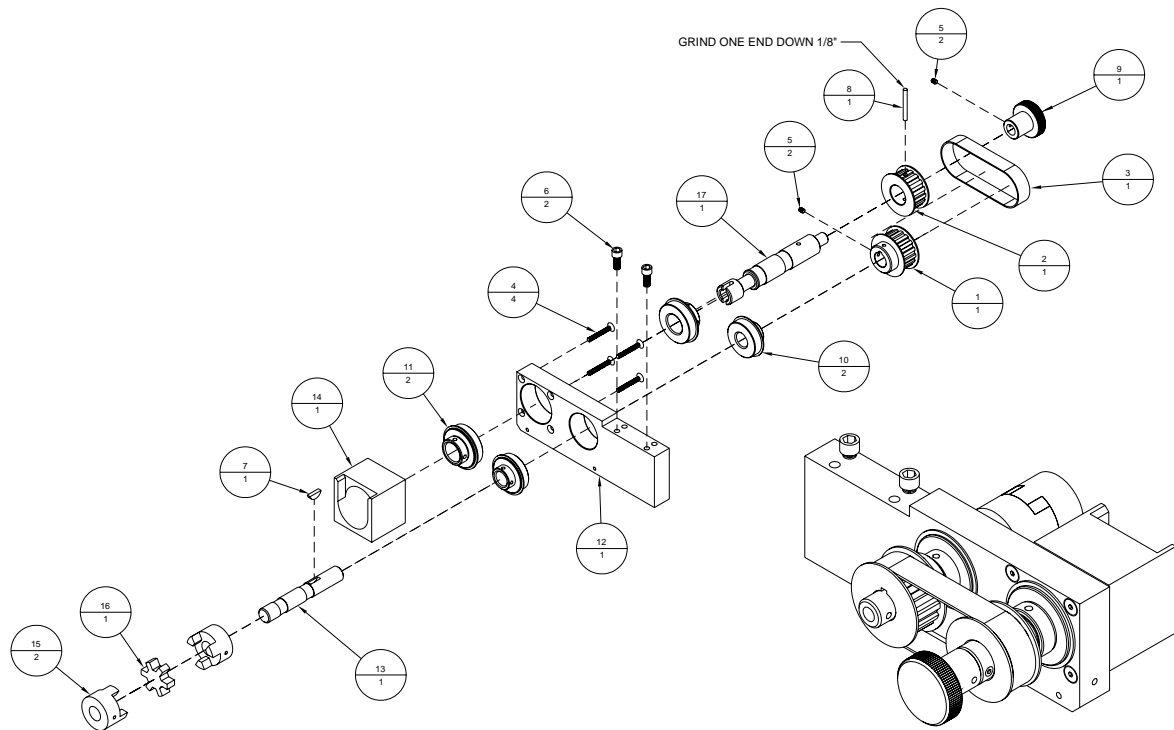
Figure A-13: *Power Take Off - Left (9100755LA)*

Table A-14: *Power Take Off Locking Mechanism (9100760A)*

Item	Part Number	Quantity	Description	Reference
1	404080	4	Screw, FHCS, 10-32 UNF x 1 1/2"	
2	406250	2	Screw, SHCS, 5/16-18 UNC x 3/4"	
3	9100755	1	Power Take Off Bracket	
4	9100760	1	Power Take Off Locking Support	
5	9100781	1	Locking Screw, 3/4-10 UNC	

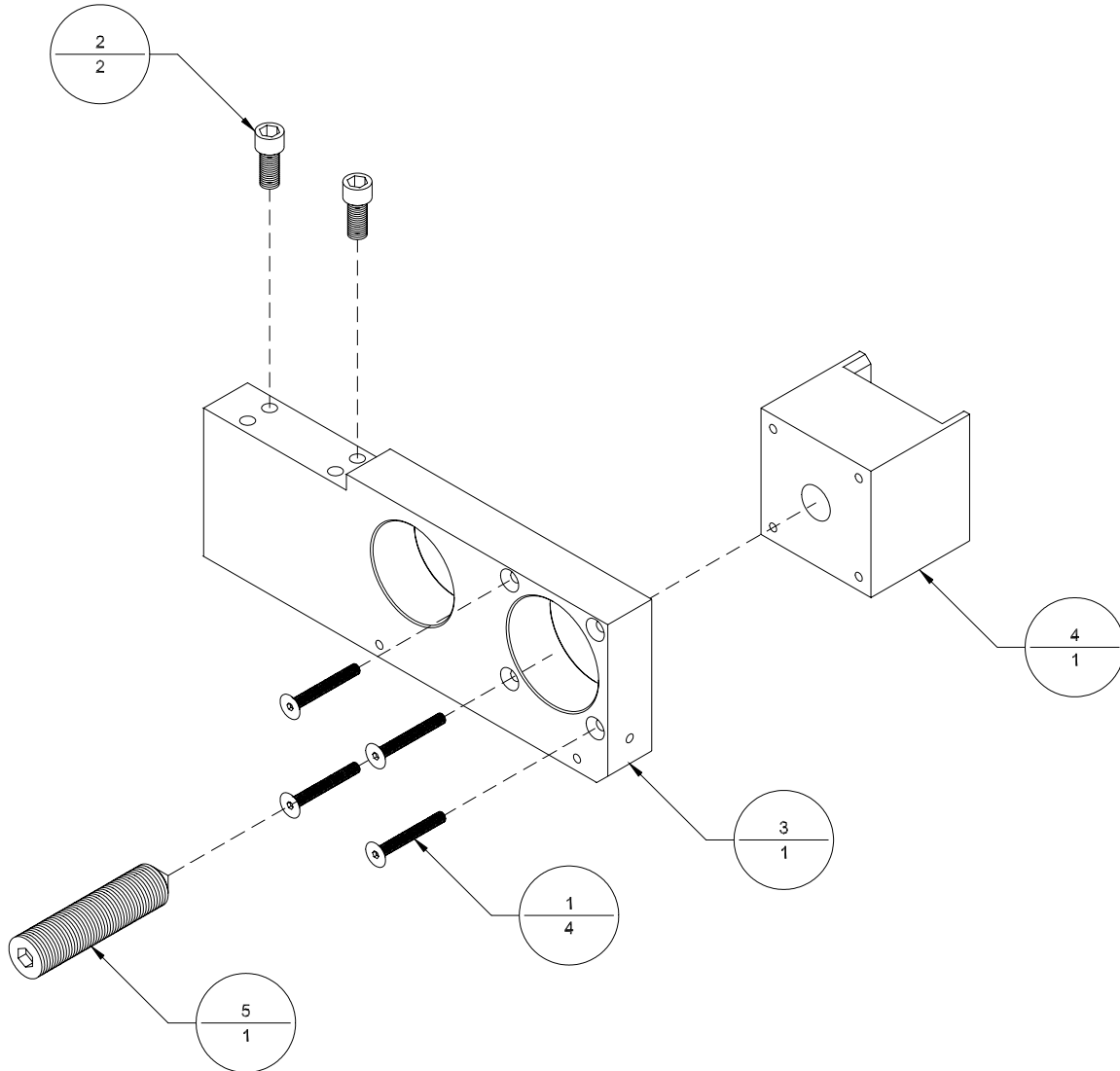
Figure A-14: *Power Take Off Locking Mechanism (9100760A)*

Table A-15: *Locking Mechanism – Left (9100760LA)*

Item	Part Number	Quantity	Description	Reference
1	404080	4	Screw, FHCS, 10-32 UNF x 1 1/2"	
2	406250	2	Screw, SHCS, 5/16-18 UNC x 3/4"	
3	9100755	1	Power Take Off Bracket	
4	9100760	1	Power Take Off Locking Support	
5	9100781	1	Locking Screw, 3/4-10 UNC	

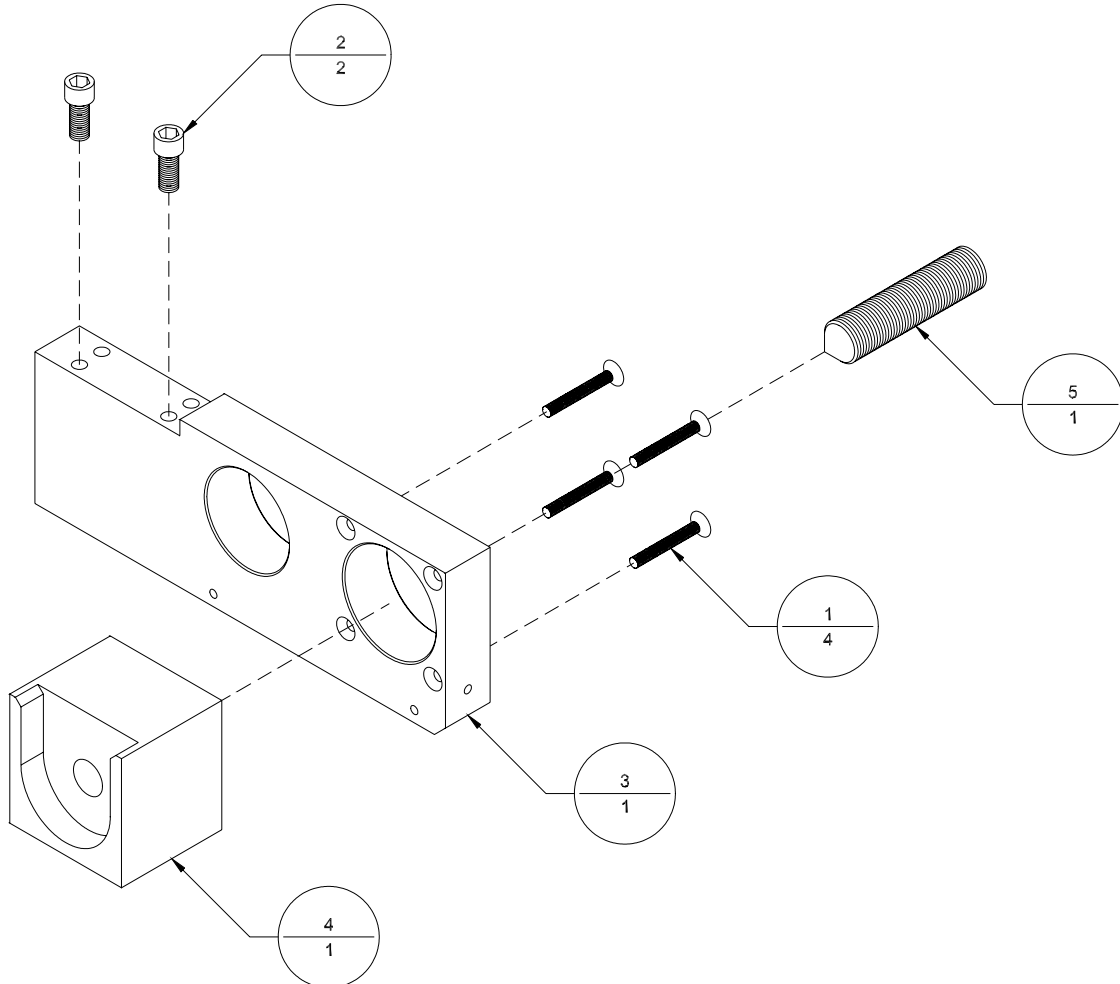
Figure A-15: *Locking Mechanism – Left (9100760LA)*

Table A-16: *Electrical Bracket Assembly (BK703) (9100854A)*

Item	Part Number	Quantity	Description	Reference
1	401310	10	Screw, PHMS, 4-40 UNC x 1/4"	
2	404510	2	Screw, BHCS, 10-32 UNF x 1/4"	
3	606014	57"	Cable, #22-4 Shielded	
4	606016	14"	Cable, #22-15, Shielded	
5	606018	5"	Cable, #22-10, Shielded	
6	606020	6"	Wire, #18, Black, Hookup	
7	606023	6"	Wire, #18, Green, Hookup	
8	606029	6"	Wire, #18, White, Hookup	
9	614108	8	Contact, Female, 24-20 AWG, Yellow	
10	614123	2	Contact, Female, 18-16 AWG, Blue	
11	614135	1	Receptacle, Female, 23-37	
12	615003	7	Terminal Block, M10/10, Grey, 10mm 7.5A	
13	615012	1	End Section, FEM6, Grey, 2.5mm	
14	615016	1	End Stop, BAM, 9.1mm	
15	615018	1	Ground Block, M10/10.P, Green & Yellow	
16	615021	1	T Rail, DIN (8" Long)	
17	615425	1	Hole Plug, 7/8"	
18	9100785	8	Contact, Female, 24-20 AWG, Size 20 DF	
19	9100854	1	Bracket, Extension Table Electrical	
20	9100868	1	Receptacle, 125 VAC	
21	9101520	1	Plug, Rectangular, Switch 3120-F Series	
22	9101647	1	Keying Plug, Series 1	
23	9102054	1	Receptacle, Female, 23-57	
24	9102055A	1	Plug, Jumper, 23-57	Page A-27

Figure A-16: *Electrical Bracket Assembly (BK703) (9100854A)*

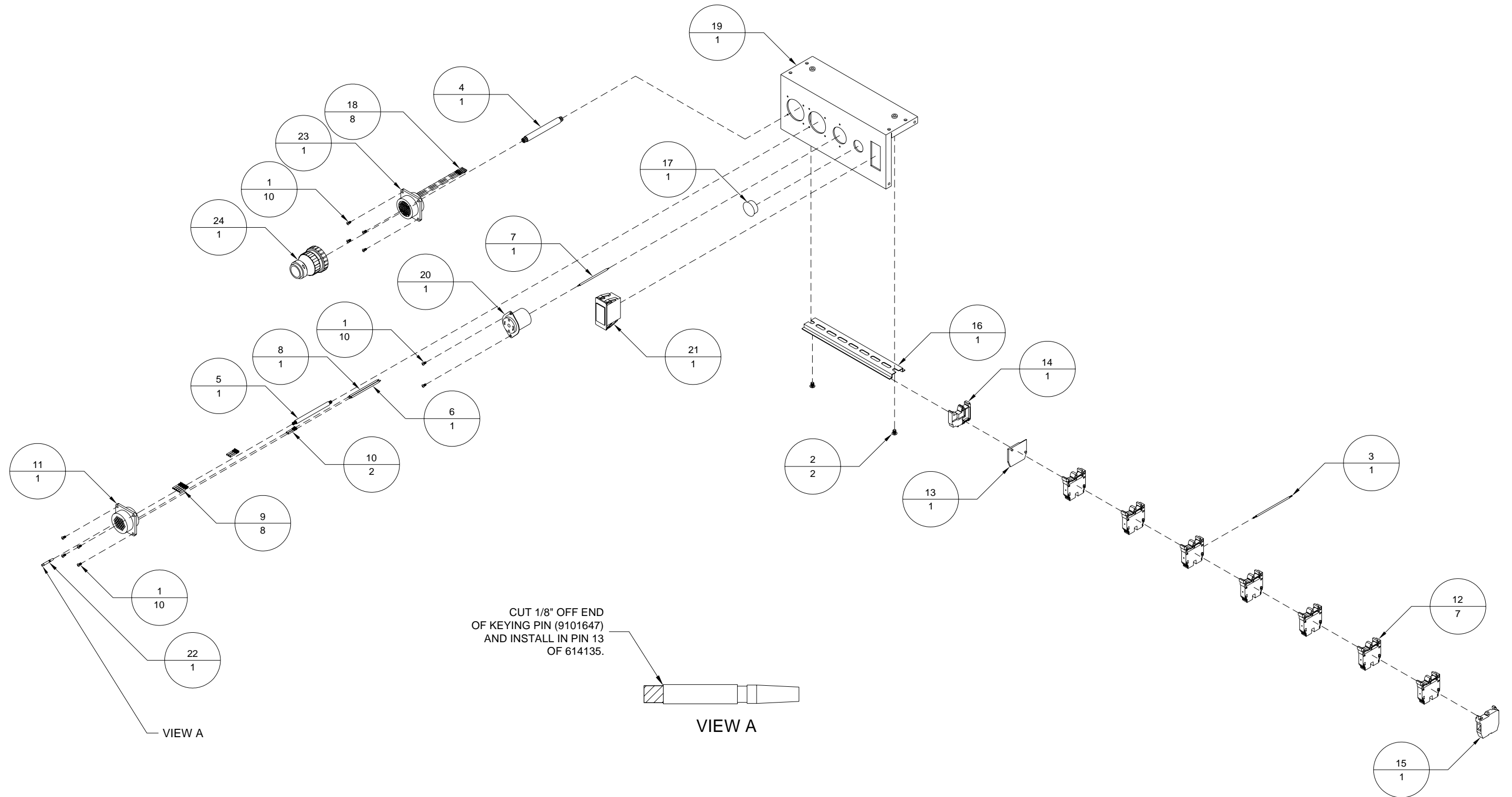


Table A-17: *Take-Up Roller Assembly (9101038A)*

Item	Part Number	Quantity	Description	Reference
1	500055	2	Bearing, UBR-204-12S, 3/4" ID	
2	9100316	1	Transport Roller	
3	9101038	1	Take-Up Shaft	

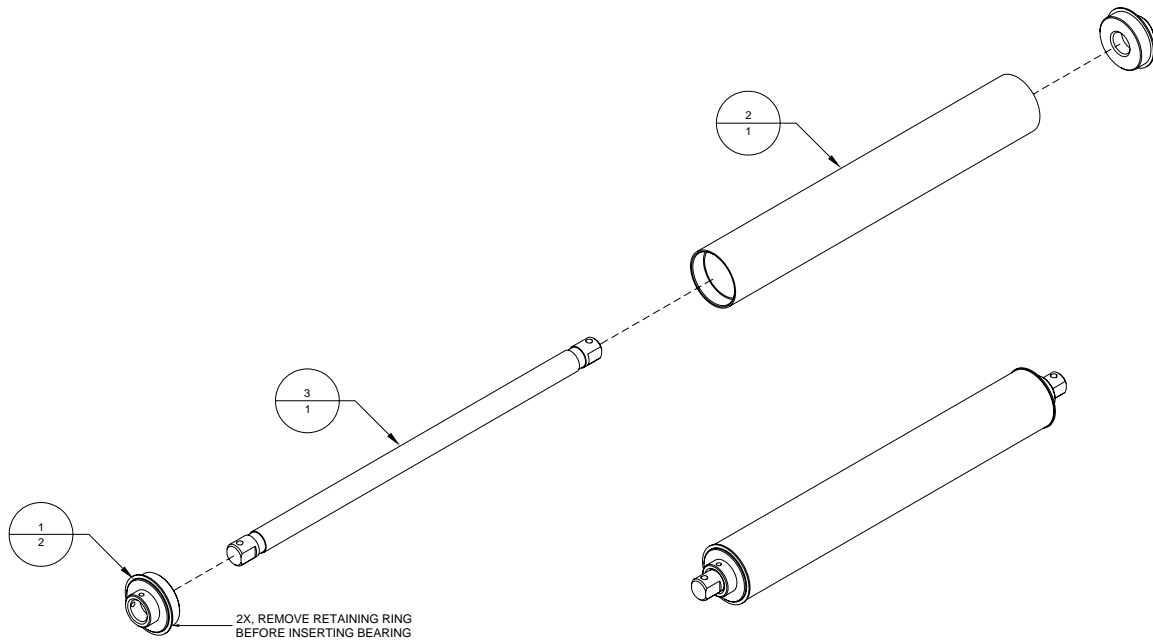
Figure A-17: *Take-Up Roller Assembly (9101038A)*

Table A-18: *Vacuum Extension Tabletop Assembly (9101400A)*

Item	Part Number	Quantity	Description	Reference
1	403510	2	Screw, BHCS, 8-32 UNC x ¼"	
2	404040	8	Screw, FHCS, 10-32 UNF x 5/8"	
3	404050	6	Screw, FHCS, 10-32 UNF x ¾"	
4	404510	10	Screw, BHCS, 10-32 UNF x ¼"	
5	405250	4	Screw, SHCS, ¼-20 UNC x ¾"	
6	405830	4	Screw, SHSS, ¼-20 UNC x ½"	
7	405997	2	Screw, RHMS, ¼-20 UNC x 4"	
8	436053	1	Spring Pin, 3/16 DIA x 1"	
9	439009	10	Lockwasher, No. 10	
10	439010	4	Lockwasher, ¼" I.D.	
11	444004	2	Hose Clamp, Gear Type, 9/16 – 1 ¼"	
12	500055	4	Bearing, UBR204-12S, ¾" I.D.	
13	802601	40"	Vacuum Tubing, Grey PVC, 1"	
14	9101031A	2	Inline Roller	
15	9101037	2	Take-Up Shaft Guide Block	
16	9101038A	1	Take-Up Roller Assembly	Page A-20
17	9101041	1	Inline Roller Shaft	
18	9101400	1	Vacuum Extension Tabletop	
19	9101401	2	Roller Mounting Block	
20	9101402	1	Auxiliary Device Support	
21	9101403	1	Auxiliary Device Locking Support	
22	9101404	1	Vacuum Table Drive Shaft	
23	9101405	2	Secondary Roller Mounting Block	
24	9101406	2	Vacuum Table Vacuum Belt	
25	9101407	2	Vacuum Table Transport Belt	
26	9101408	1	Vacuum Table Vacuum Column	
27	9101414	1	Vacuum Hose Flanged Fitting	

Figure A-18: Vacuum Extension Tabletop Assembly (9101400A)

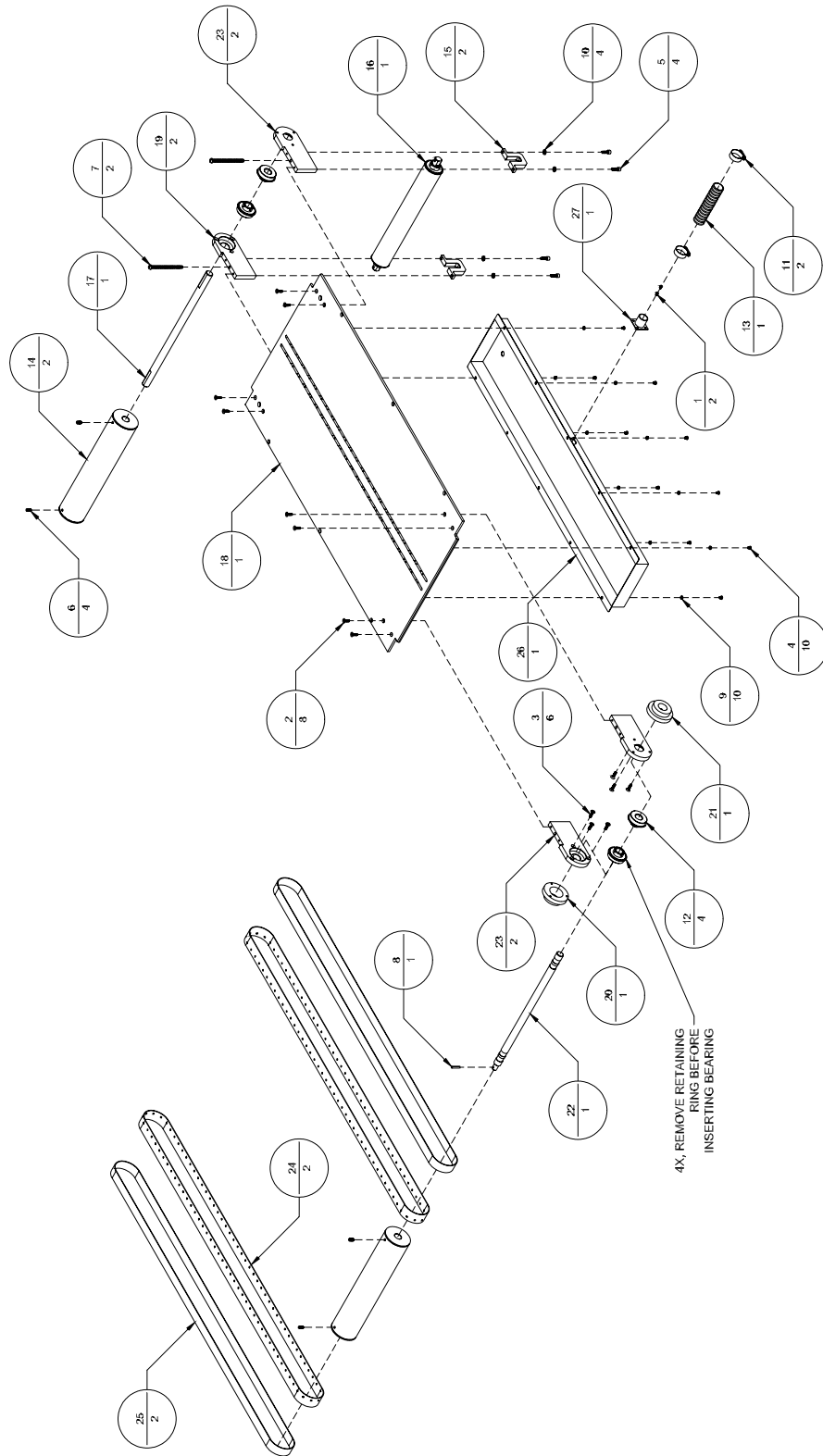


Table A-19: *Vacuum Tabletop Assembly - Left (9101400LA)*

Item	Part Number	Quantity	Description	Reference
1	403510	2	Screw, BHCS, 8-32 UNC x ¼"	
2	404040	8	Screw, FHCS, 10-32 UNF x 5/8"	
3	404050	6	Screw, FHCS, 10-32 UNF x ¾"	
4	404510	10	Screw, BHCS, 10-32 UNF x ¼"	
5	405250	4	Screw, SHCS, ¼-20 UNC x ¾"	
6	405830	4	Screw, SHSS, ¼-20 UNC x ½"	
7	405997	2	Screw, RHMS, ¼-20 UNC x 4"	
8	436053	1	Spring Pin, 3/16 DIA x 1"	
9	439009	10	Lockwasher, No. 10	
10	439010	4	Lockwasher, ¼" I.D.	
11	444004	2	Hose Clamp, Gear Type, 9/16 – 1 ¼"	
12	500055	4	Bearing, UBR204-12S, ¾" I.D.	
13	802601	40"	Vacuum Tubing, Grey PVC, 1"	
14	9101031A	2	Inline Roller	
15	9101037	2	Take-Up Shaft Guide Block	
16	9101038A	1	Take-Up Roller Assembly	Page A-20
17	9101041	1	Inline Roller Shaft	
18	9101400	1	Vacuum Extension Tabletop	
19	9101401	2	Roller Mounting Block	
20	9101402	1	Auxiliary Device Support	
21	9101403	1	Auxiliary Device Locking Support	
22	9101404	1	Vacuum Table Drive Shaft	
23	9101405	2	Secondary Roller Mounting Block	
24	9101406	2	Vacuum Table Vacuum Belt	
25	9101407	2	Vacuum Table Transport Belt	
26	9101408	1	Vacuum Table Vacuum Column	
27	9101414	1	Vacuum Hose Flanged Fitting	

Figure A-19: Vacuum Tabletop Assembly - Left (9101400LA)

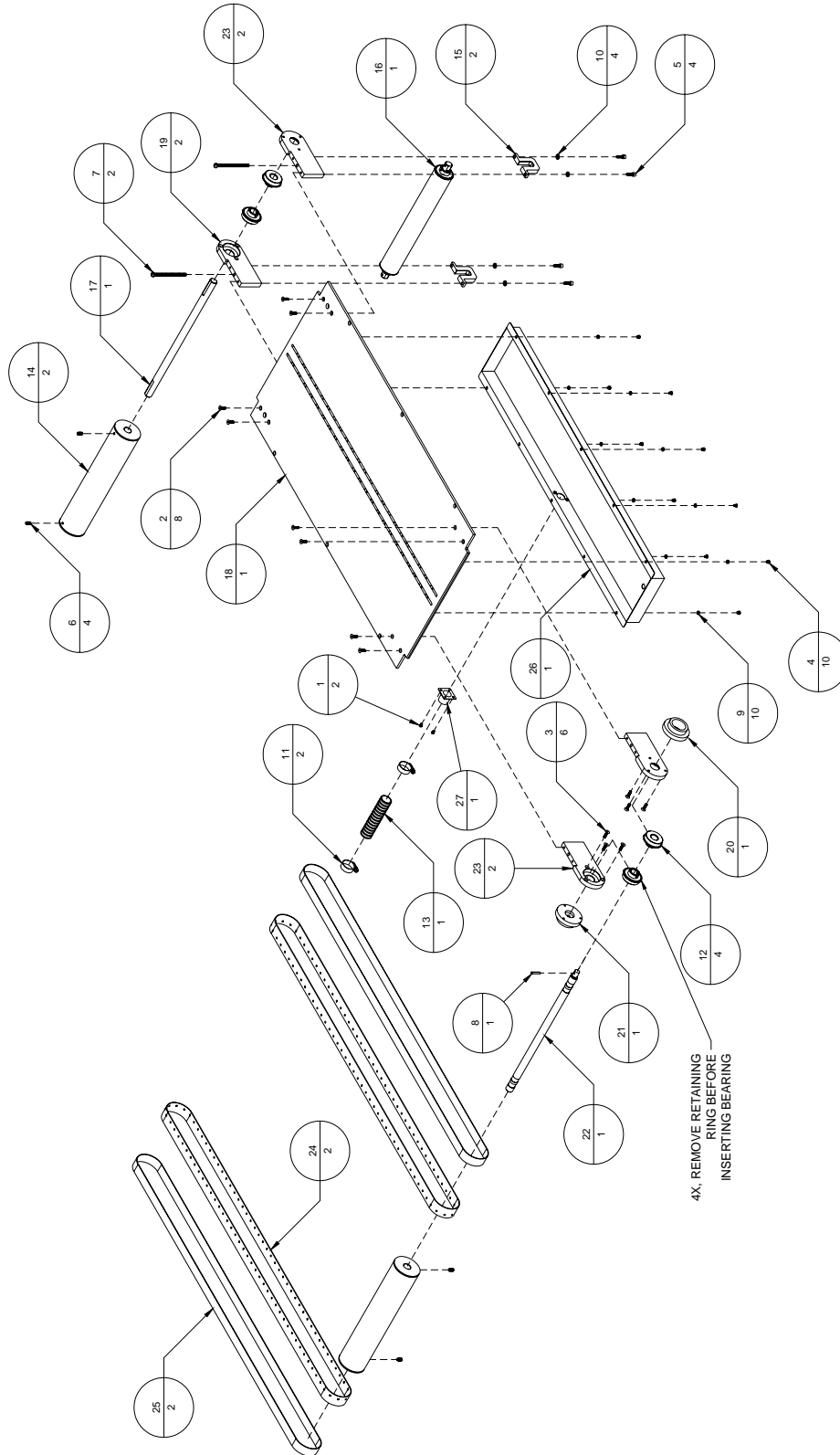


Table A-20: *Vacuum Chassis Assembly (9101409A)*

Item	Part Number	Quantity	Description	Reference
1	404075	1	Screw, FHCS, 10-32 UNF x 1 1/4"	
2	404510	4	Screw, BHCS, 10-32 UNF x 1/4"	
3	405280	2	Screw, SHCS, 1/4-20 UNC x 1 1/2"	
4	405530	2	Screw, BHCS, 1/4-20 UNC x 1/2"	
5	407250	4	Screw, SHCS, 3/8-16 UNC x 3/4"	
6	416185	2	Shoulder Bolt, 3/8" x 2", (5/16-18)	
7	420015	2	Nut, 5/16-18 UNC	
8	438505	2	Tee Knob, Black Plastic, 1/4" Screw	
9	439009	2	Lockwasher, No. 10	
10	439015	2	Lockwasher, 5/16 I.D.	
11	439020	4	Lockwasher, 3/8" I.D.	
12	440015	2	Washer, 5/16" ID	
13	9100329	1	Support Leg, Inner Tube	
14	9100330	1	Support Bracket	
15	9100357	1	Belt Alignment Shaft	
16	9100484A	1	"T" Leg Assembly	Page A-12
17	9100733	1	Inline Transport Belt Guide	
18	9100735	1	Offline Controller Side Cover	
19	9100971	2	Gripper Clip	
20	9101043	2	Belt Guide, Adjustable, 1"	
21	9101409	1	Vacuum Table Chassis	

Figure A-20: Vacuum Chassis Assembly (9101409A)

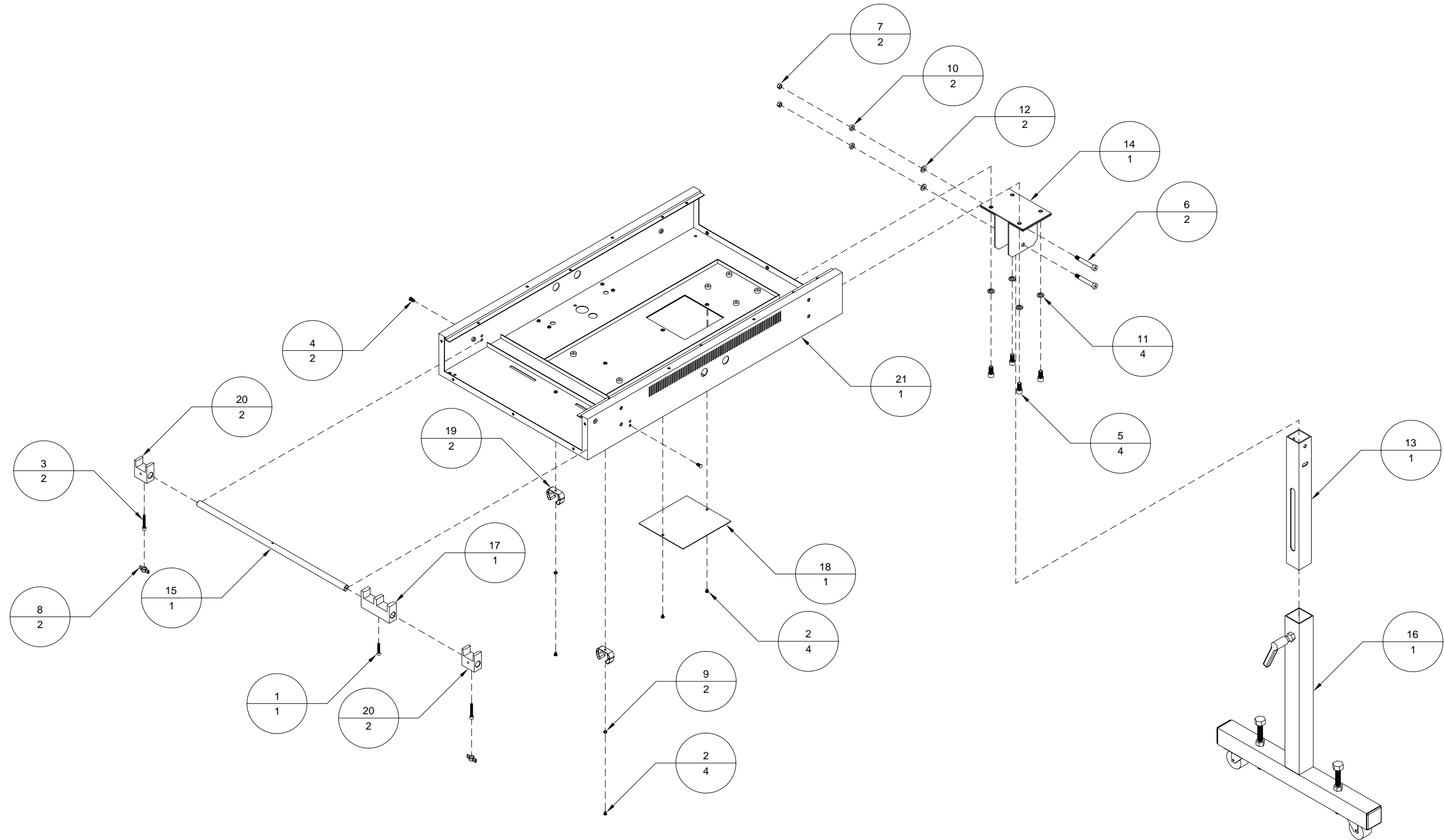


Table A-21: *Lower Gap Assembly – BK703/BK7IB (9101411A)*

Item	Part Number	Quantity	Description	Reference															
1	403520	4	Screw, BHCS, 8-32 UNC x 3/8"																
2	420007	4	Nut, 8-32 UNC																
3	444004	4	Hose Clamp, Gear Type, 9/16 – 1-1/4																
4	802111	3	Hose Barb, 1" x 1", Plastic																
5	802601	60"	Vacuum Tubing, Grey PVC, 1"																
6	802601	4"	Vacuum Tubing, Grey PVC, 1"		7	9100826	1	Tee, Female, 1" NPT		8	9101411	1	Lower Gap Cover (BK703/BK7IB)		9	9101414	2	Vacuum Hose Flanged Fitting	
7	9100826	1	Tee, Female, 1" NPT																
8	9101411	1	Lower Gap Cover (BK703/BK7IB)																
9	9101414	2	Vacuum Hose Flanged Fitting																

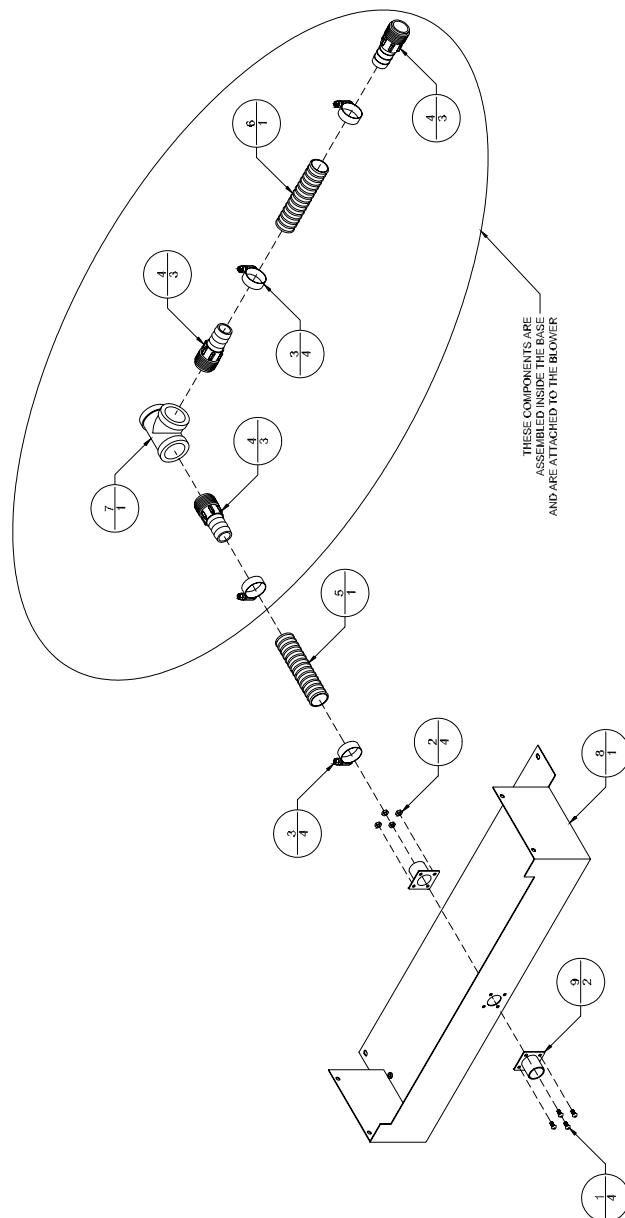
Figure A-21: *Lower Gap Assembly – BK703/BK7IB (9101411A)*

Table A-22: *Plug, Jumper, 23-57 (9102055A)*

Item	Part Number	Quantity	Description	Reference
1	606022	2"	Wire, #18. Red, Hookup	
2	614113	1	Cable Clamp	
3	9100784	2	Contact, Male, 24-20 AWG, Size 20 DF	
4	9102055	1	Plug, 23-57, Reverse Sex	

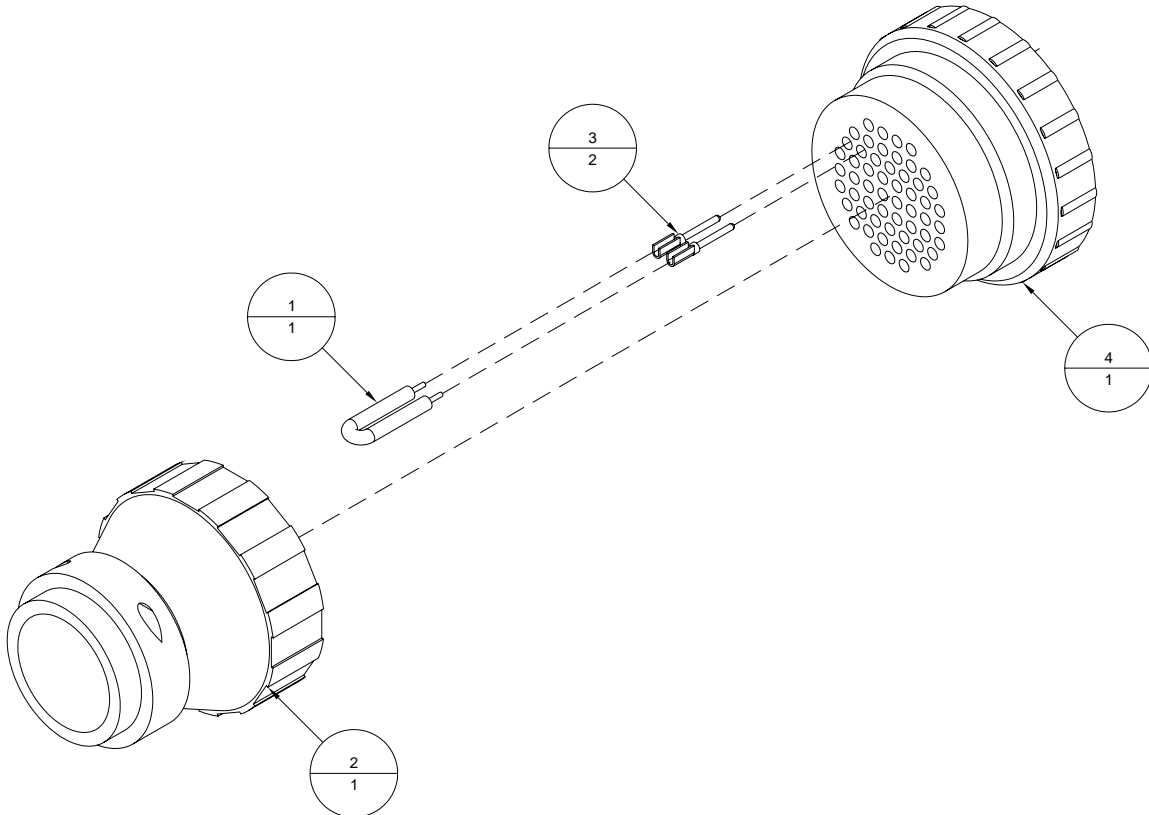
Figure A-22: *Plug, Jumper, 23-57 (9102055A)*

Table A-23: *Universal Interconnect Cable (9102083A)*

Item	Part Number	Quantity	Description	Reference
1	606206	1	Cable, #22-40	
2	614107	36	Contact, Male, 24-20 AWG, Yellow	
3	614113	2	Cable Clamp	
4	614136	1	Plug, 23-37, Reverse Sex	
5	9100784	36	Contact, Male, 24-20 AWG, Size 20 DF	
6	9102055	1	Plug, 23-57, Reverse Sex	

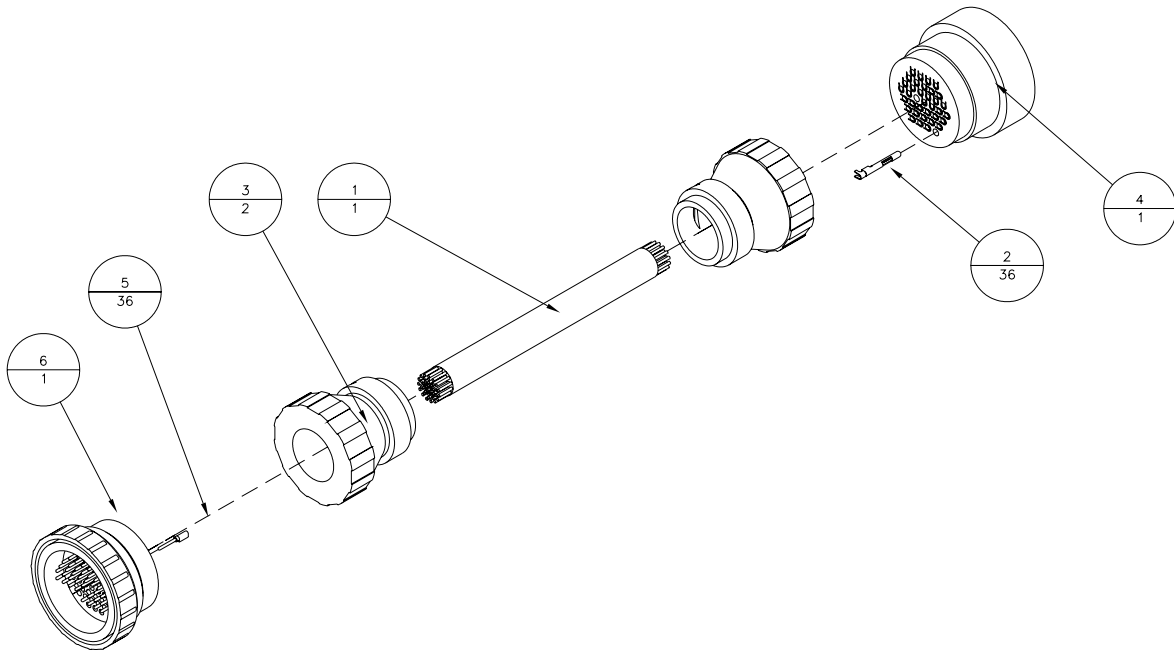
Figure A-23: *Universal Interconnect Cable (9102083A)*

Table A-24: *Tabletop, Extension Assembly, Left (9102282LA)*

Item	Part Number	Quantity	Description	Reference
1	403510	2	Screw, BHCS, 8-32 UNC x 1/4"	
2	404040	8	Screw, FHCS, 10-32 UNF x 5/8"	
3	404070	3	Screw, FHCS, 10-32 UNF x 1"	
4	404510	10	Screw, BHCS, 10-32 UNF x 1/4"	
5	405250	4	Screw, SHCS, 1/4-20 UNC x 3/4"	
6	405830	4	Screw, SHSS, 1/4-20 UNC x 1/2"	
7	405997	2	Screw, RHMS, 1/4-20 UNC x 4"	
8	439009	10	Lockwasher, No. 10	
9	439010	4	Lockwasher, 1/4" I.D.	
10	444004	2	Clamp, Hose, Gear Type, 9/16 x 1 1/4"	
11	500055	5	Bearing, UBR-204-12S, 3/4" ID	
12	802601	40"	Tubing, Vacuum, Grey PVC	
13	9101031A	2	Inline Roller	
14	9101037	2	Take-Up Shaft Guide Block	
15	9101038A	1	Take-Up Roller Assembly	Page A-20
16	9101041	1	Inline Roller Shaft	
17	9101400	1	Vacuum Extension Tabletop	
18	9101401	2	Roller Mounting Block	
19	9101405	2	Secondary Roller Mounting Block	
20	9101406	2	Vacuum Table Vacuum Belt	
21	9101407	2	Vacuum Table Transport Belt	
22	9101408	1	Vacuum Table Vacuum Column	
23	9101414	1	Vacuum Hose Flanged Fitting	
24	9102282	1	Shaft, 0.75" OD x 21" Lg.	
25	9102771	1	Mounting Block, Extension Table Shaft	

Figure A-24: *Tabletop, Extension Assembly, Left (9102282LA)*

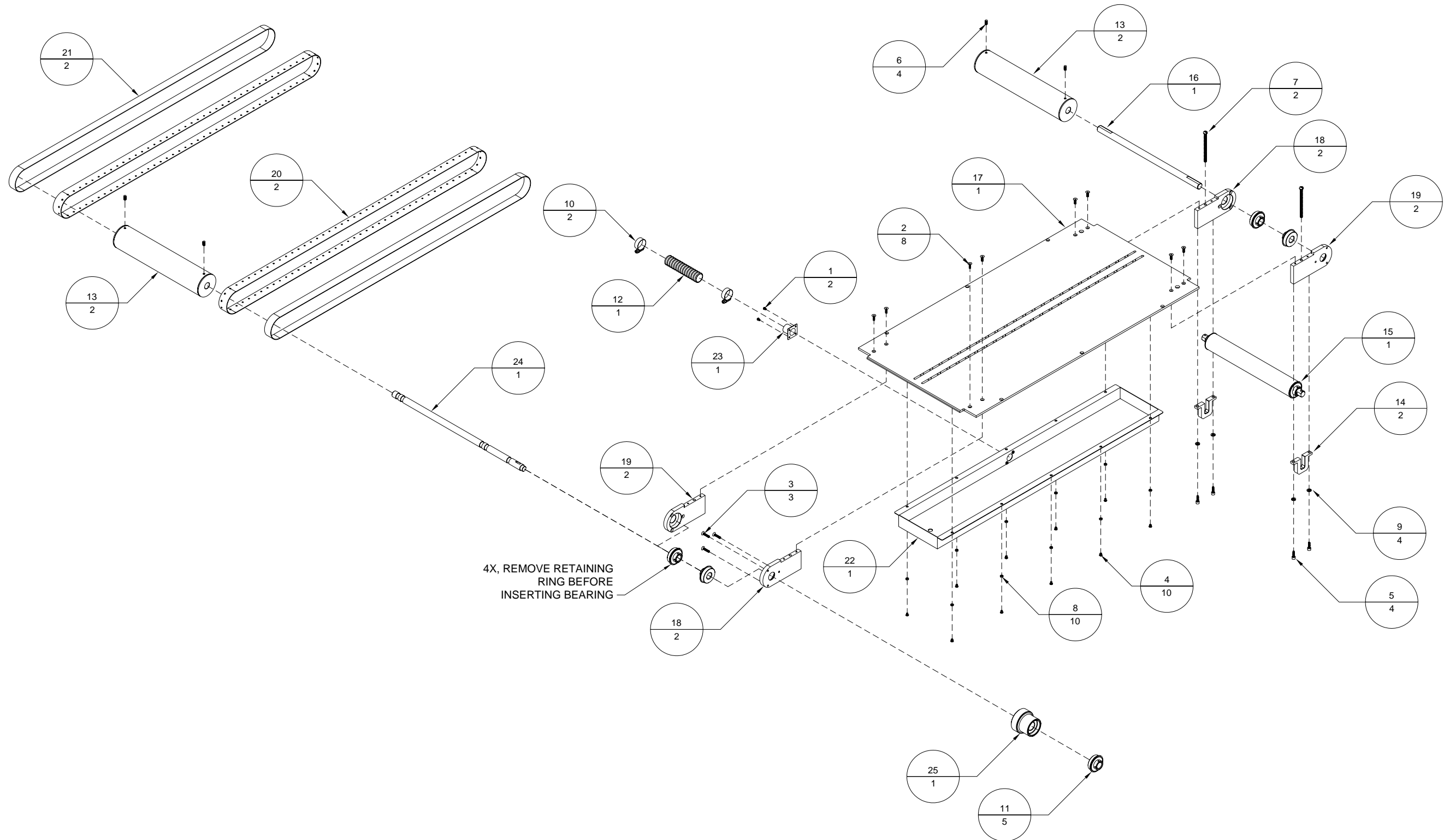
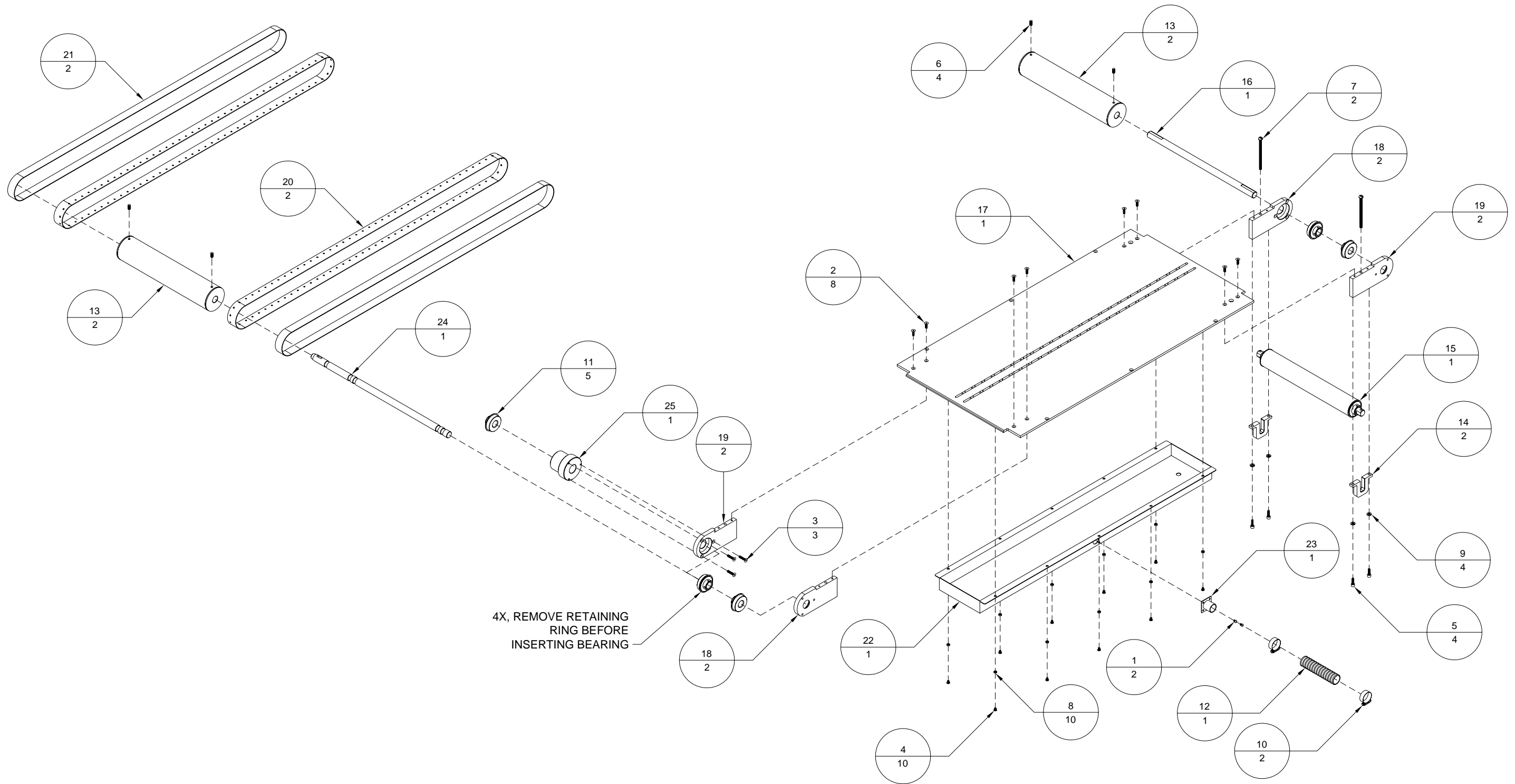


Table A-25: *Tabletop, Extension Assembly, Right (9102282RA)*

Item	Part Number	Quantity	Description	Reference
1	403510	2	Screw, BHCS, 8-32 UNC x 1/4"	
2	404040	8	Screw, FHCS, 10-32 UNF x 5/8"	
3	404070	3	Screw, FHCS, 10-32 UNF x 1"	
4	404510	10	Screw, BHCS, 10-32 UNF x 1/4"	
5	405250	4	Screw, SHCS, 1/4-20 UNC x 3/4"	
6	405830	4	Screw, SHSS, 1/4-20 UNC x 1/2"	
7	405997	2	Screw, RHMS, 1/4-20 UNC x 4"	
8	439009	10	Lockwasher, No. 10	
9	439010	4	Lockwasher, 1/4" I.D.	
10	444004	2	Clamp, Hose, Gear Type, 9/16 x 1 1/4"	
11	500055	5	Bearing, UBR-204-12S, 3/4" ID	
12	802601	40"	Tubing, Vacuum, Grey PVC	
13	9101031A	2	Inline Roller	
14	9101037	2	Take-Up Shaft Guide Block	
15	9101038A	1	Take-Up Roller Assembly	Page A-20
16	9101041	1	Inline Roller Shaft	
17	9101400	1	Vacuum Extension Tabletop	
18	9101401	2	Roller Mounting Block	
19	9101405	2	Secondary Roller Mounting Block	
20	9101406	2	Vacuum Table Vacuum Belt	
21	9101407	2	Vacuum Table Transport Belt	
22	9101408	1	Vacuum Table Vacuum Column	
23	9101414	1	Vacuum Hose Flanged Fitting	
24	9102282	1	Shaft, 0.75" OD x 21" Lg.	
25	9102771	1	Mounting Block, Extension Table Shaft	

Figure A-25: *Tabletop, Extension Assembly, Right (9102282RA)*



List of Figures

Figure B-1: Extension Table Electrical Schematic (BK703)	B-1
Figure B-2: Extension Table Wiring Diagram (BK703)	B-2

Figure B-1: *Extension Table Electrical Schematic (BK703)*

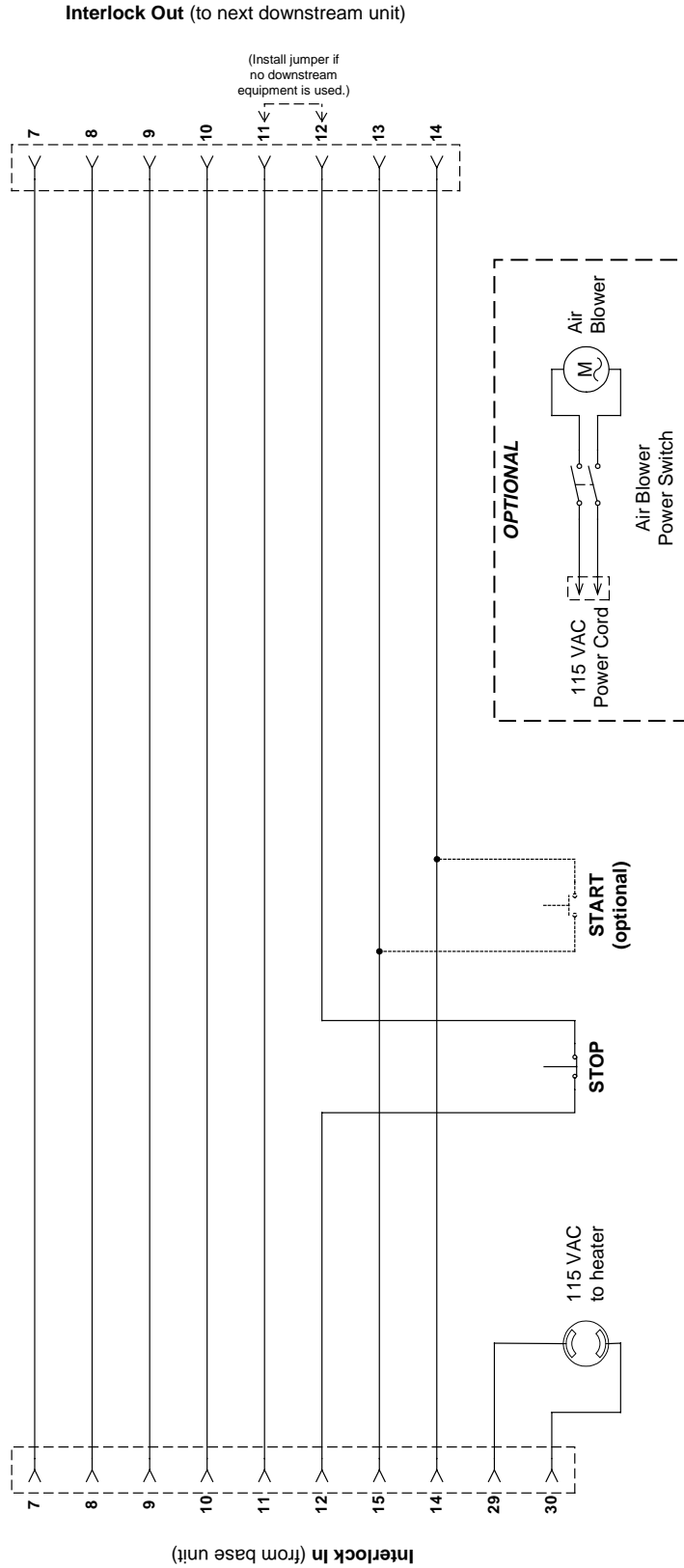


Figure B-2: *Extension Table Wiring Diagram (BK703)*

