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# Extension Table User's Guide

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## 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
3.0	09-Oct-09	Redesign of the Power Take-off for the BK71B-2	

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**Appendix A – Assembly Drawings**

**Appendix B – Electrical Drawings**



## 1.1 Description

The Buskro BK703 extension table is a secondary transport table used in conjunction with other transport bases such as the BK7IB and the BK76IB inline base. It is equipped with vacuum belts to assist in product transport (to hold the print pieces to the belts) as well as adjustable outer belts to accommodate different piece sizes. The main function of the extension table is to support secondary equipment such as dryers to improve the dry times for printed material.

The extension table is directly driven by the transport base it is attached to. Since the BK7IB and the BK76IB are different in design, the method of transferring drive is also different. As a result, there are different models of the extension table depending on the transport base used.

## 1.2 Specifications

<b>Product Handling</b>		
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.	
<b>Physical</b>		
Weight (Approximate)	85 lb	38.6 kg
<b>Production Speed</b>		
Belt Speed	Depends on primary base.	
Cycle Speed	Depends on primary base.	
<b>Operator Controls</b>		
Machine Pushbuttons	Stop	

### 1.3 System Drawings

Figure 1-1: Extension Table Overall Dimensions (For BK71B)

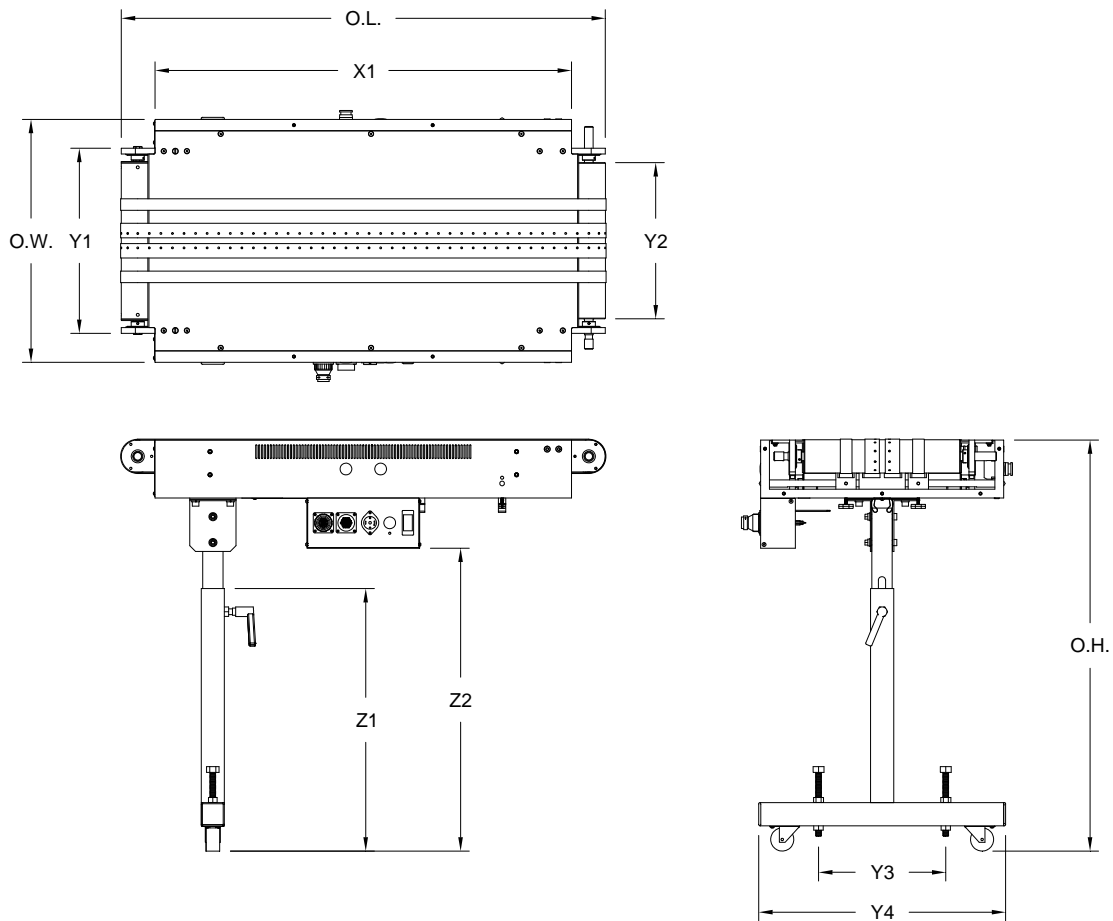


Table 1-1: Extension Table Overall Dimensions (For BK71B)

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	13.50"	343 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 1-2: Extension Table Overall Dimensions (For BK761B)

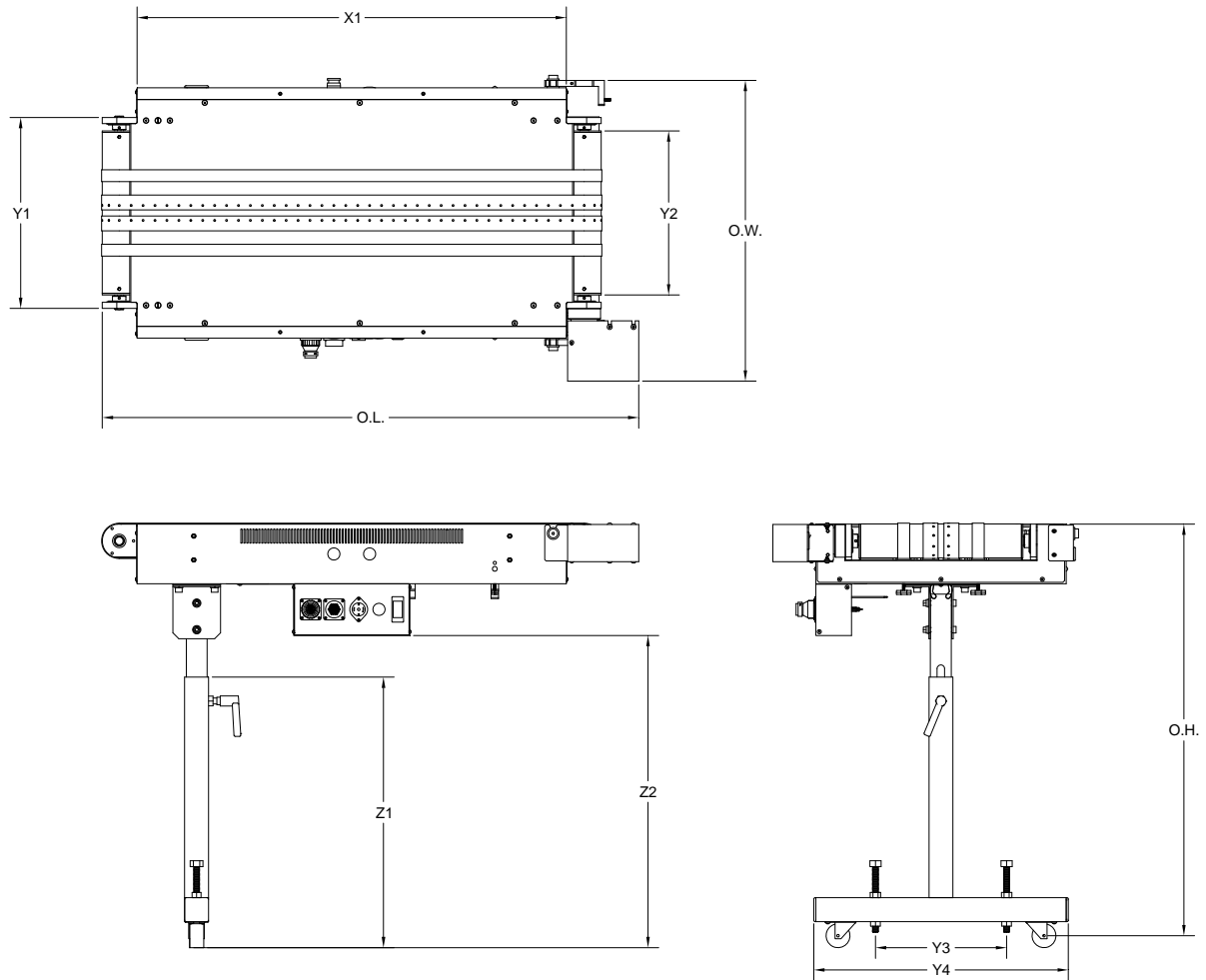
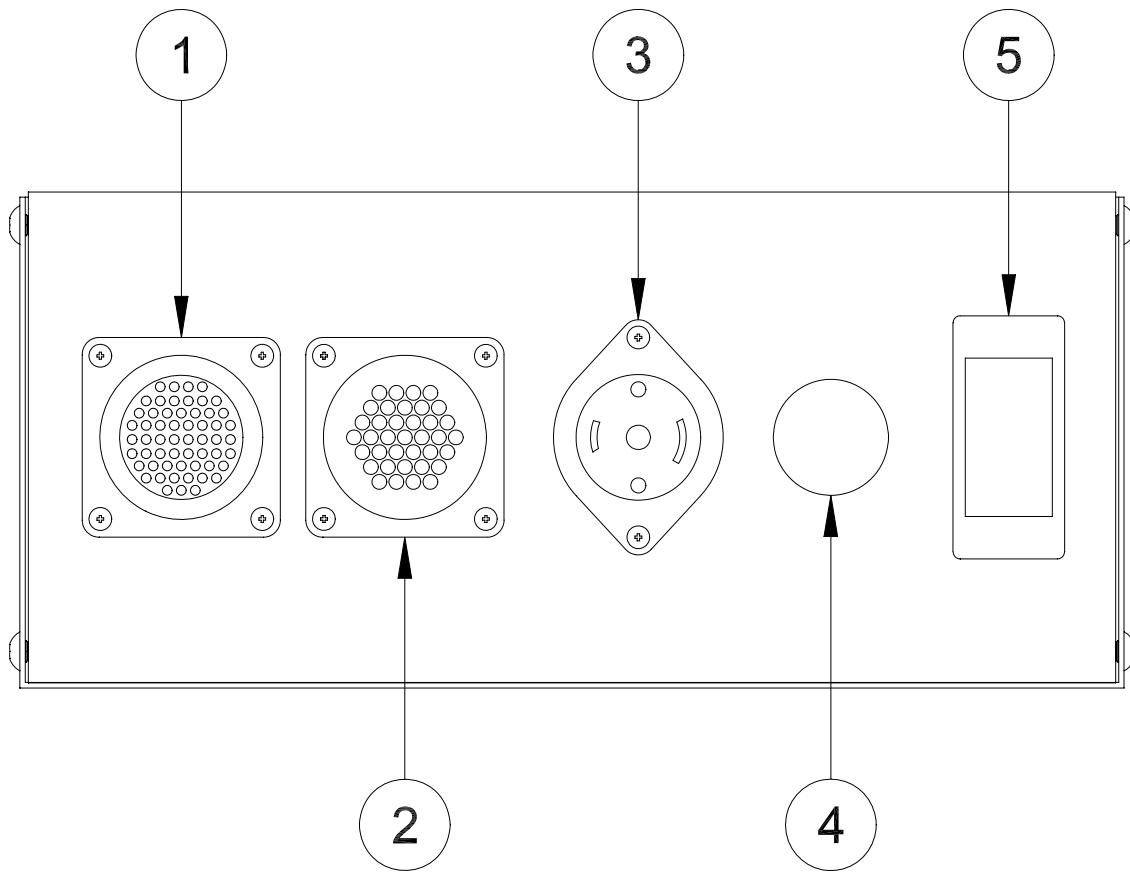


Table 1-2: Extension Table Overall Dimensions (For BK761B)

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: Extension Table Connections*



*Table 1-3: Extension Table Connections*

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.
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 BK7IB Inline base, refer to the following steps and reference the drawings in Appendix A:

1. Remove the drive side outfeed roller cover on the BK7IB (P/N 9100780).
2. Attach the Power Take Off unit (BK715RMV for right direction flow or BK715LMV for left direction flow) with the extension table to the front and rear tabletops of the BK7IB (reference BK703-7IBR-2 and BK703-7IBL-2). Ensure everything is square.
3. Attach the vacuum tube from the lower gap cover assembly (9104656A) to the vacuum column on the BK7IB. Ensure that the vacuum tube from the Extension Table is connected to the lower gap cover assembly.
4. Configure the Base Control Board in the BK7IB to work with a downstream unit (reference the BK7IB manual).

**Note:** In cases where a new BK703 is used on an earlier model of BK7IB (as opposed to the current BK7IB-2), order UBK-703-7IBL-2 (Left direction flow) or UBK-703-7IBR-2 (Right direction flow). In addition to including the extension table and power take-off, it will also include a replacement one-piece roller for the BK7IB which is required to connect the extension table to the transport base.

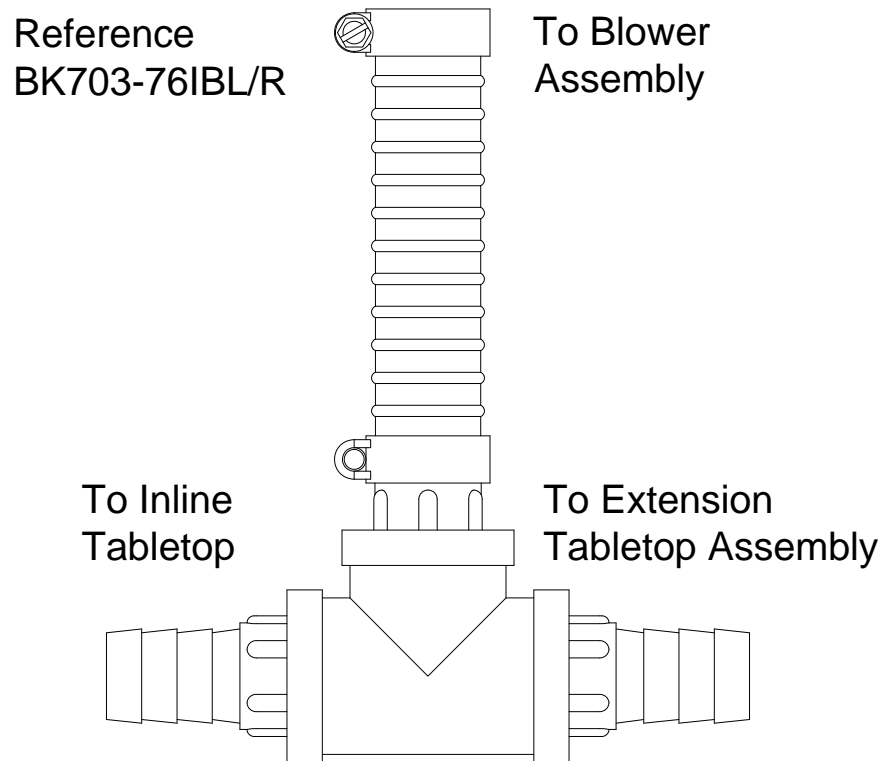
## 2.2 Integration with a BK76IB

In order to install a BK703 to a BK76IB, 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 2-1). 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 BK703-76IB'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 2-1: Vacuum Tubing Routing*



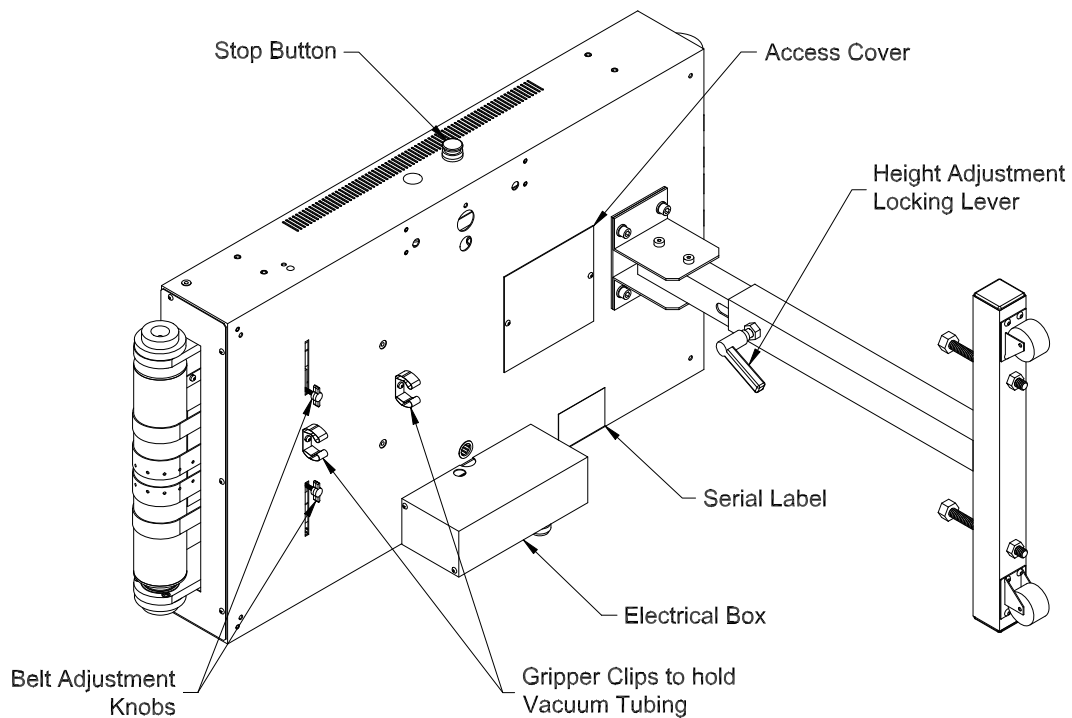
## 2.3 Belt Adjustment

### 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 2-2 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.
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.

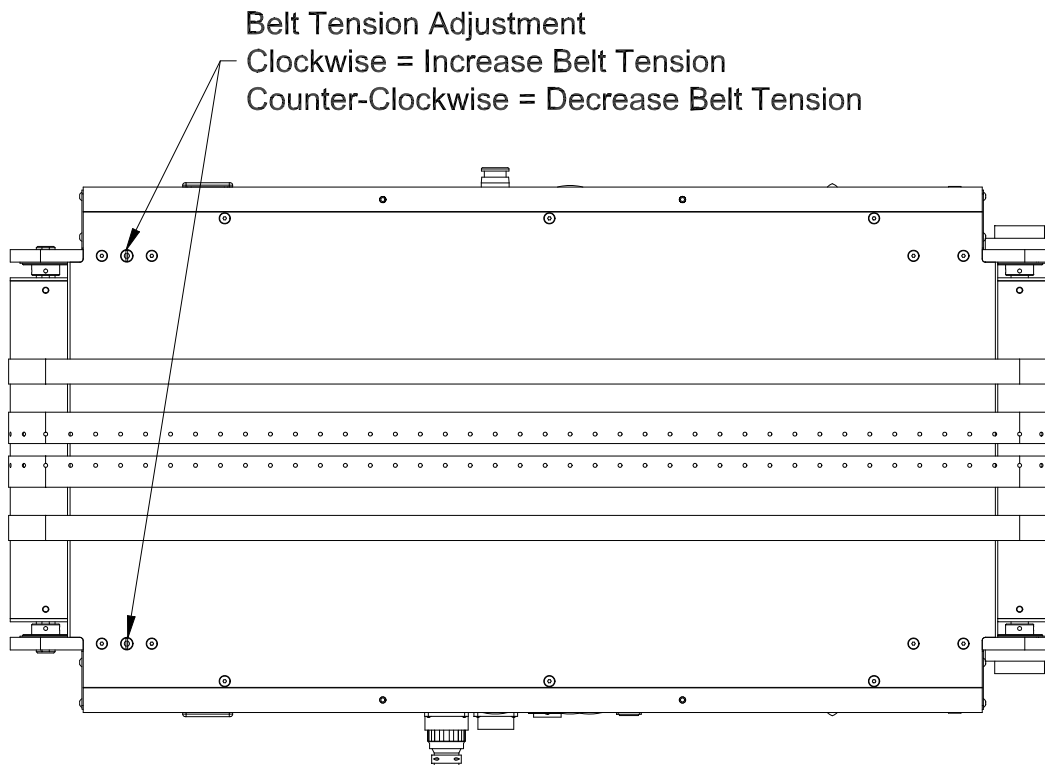
*Figure 2-2: Vacuum Extension Table Bottom View*



### 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 2-3). 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 2-3: Belt Tension Adjustment*

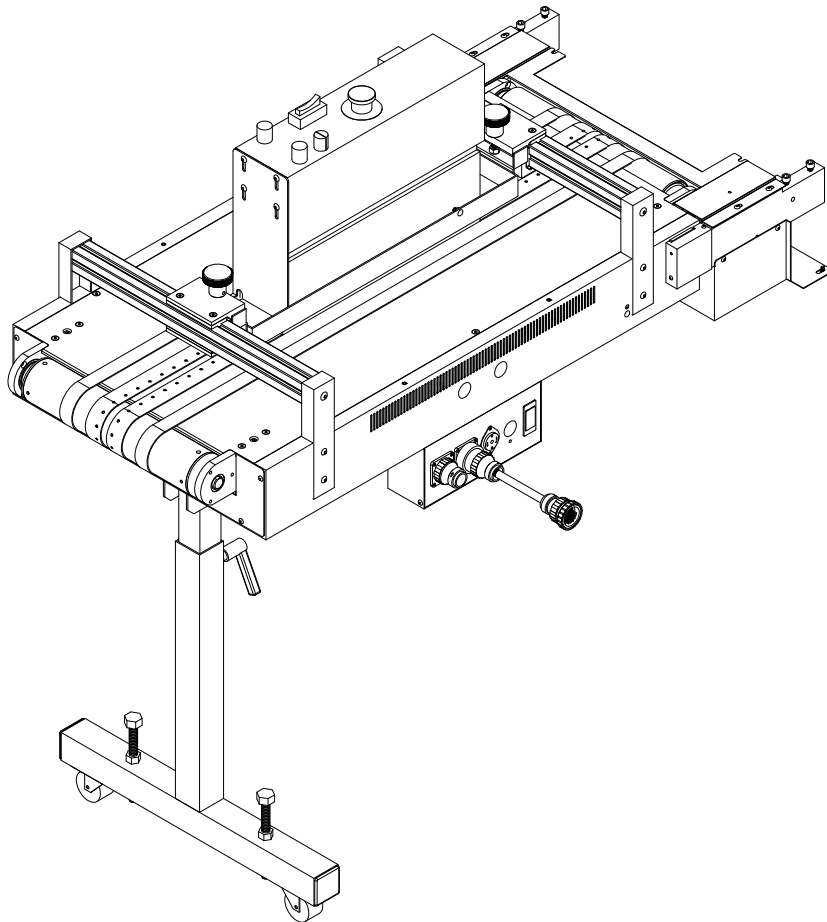


**Note:** When adjusting the tension of the belts, it is important to turn both tensioning screws an equal number of rotations. If this is not done, it is possible to cause the belts to skew in one direction.

## 2.4 Attaching Heaters / Dryers

The BK703 extension table was designed to support the BK5060 dryer. In order to attach the dryer to the extension table, order BK710-HTR2 (see Appendix A) and the BK5060 heater. The dryer must also be connected to the Interlock receptacle on the extension table (Item 3 in Figure 1-3) using a NEMA #ML-2P plug. The Universal Interconnect Cable (BK-CAB-UNI) is connected to the downstream connector of the transport base.

*Figure 2-4: Extension Table with Dryer*



**Note:** Order the corresponding BK5060 dryer for the transport base the extension table is connected to. The original BK7IB requires Part Number BK5060-120VAC while the new BK7IB-2 and the BK76IB require Part Number BK5060-12VDC.

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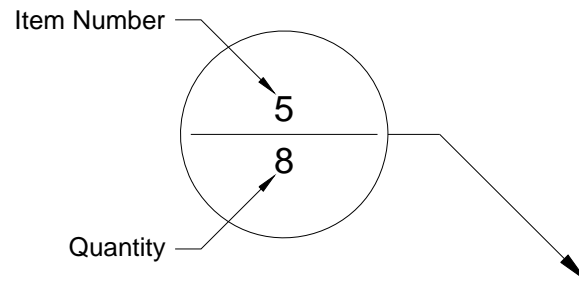
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## Balloon Annotation and Parts Listing



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:

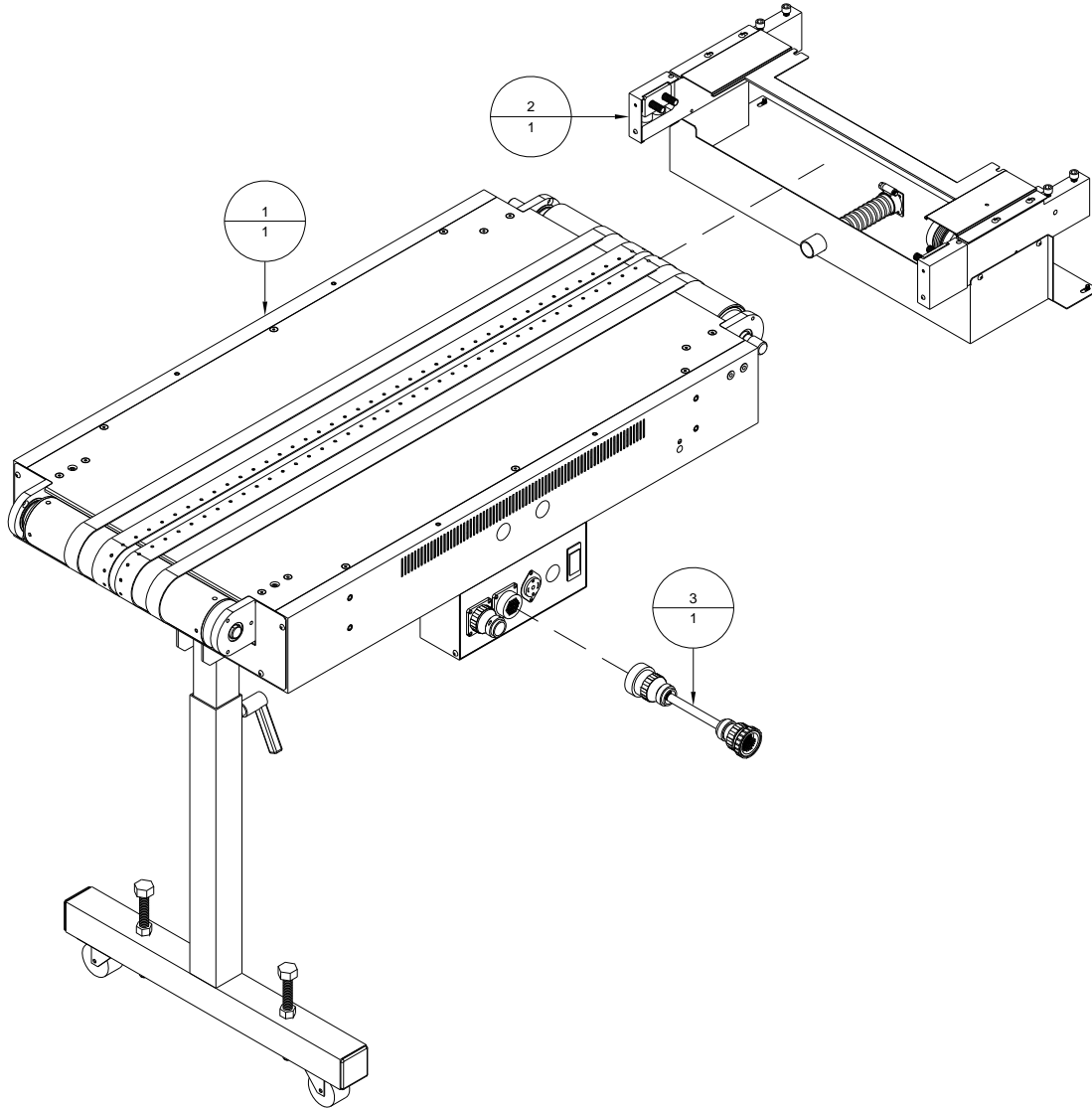
This column contains a brief description of the part.

### Reference:

This column indicates the page location for sub-assemblies.

*Table A-1: BK703-7IBR-2 - Extension Table, For BK7IB-2 Right*

Item	Part Number	Quantity	Description	Reference
1	BK703	1	Vacuum Extension Table, Right	Page A-7
2	BK715RMV	1	Power Take Off Unit, BK703/BK7IB, Right	Page A-11
3	BK-CAB-UNI	1	Cable, Universal Interconnect	

*Figure A-1: BK703-7IBR-2 - Extension Table, For BK7IB-2 Right*

*Table A-2: BK703-7IBL-2 - Extension Table, For BK7IB-2 Left*

Item	Part Number	Quantity	Description	Reference
1	BK703L	1	Vacuum Extension Table, Left	Page A-8
2	BK715LMV	1	Power Take Off Unit, BK703/BK7IB, Left	Page A-10
3	BK-CAB-UNI	1	Cable, Universal Interconnect	

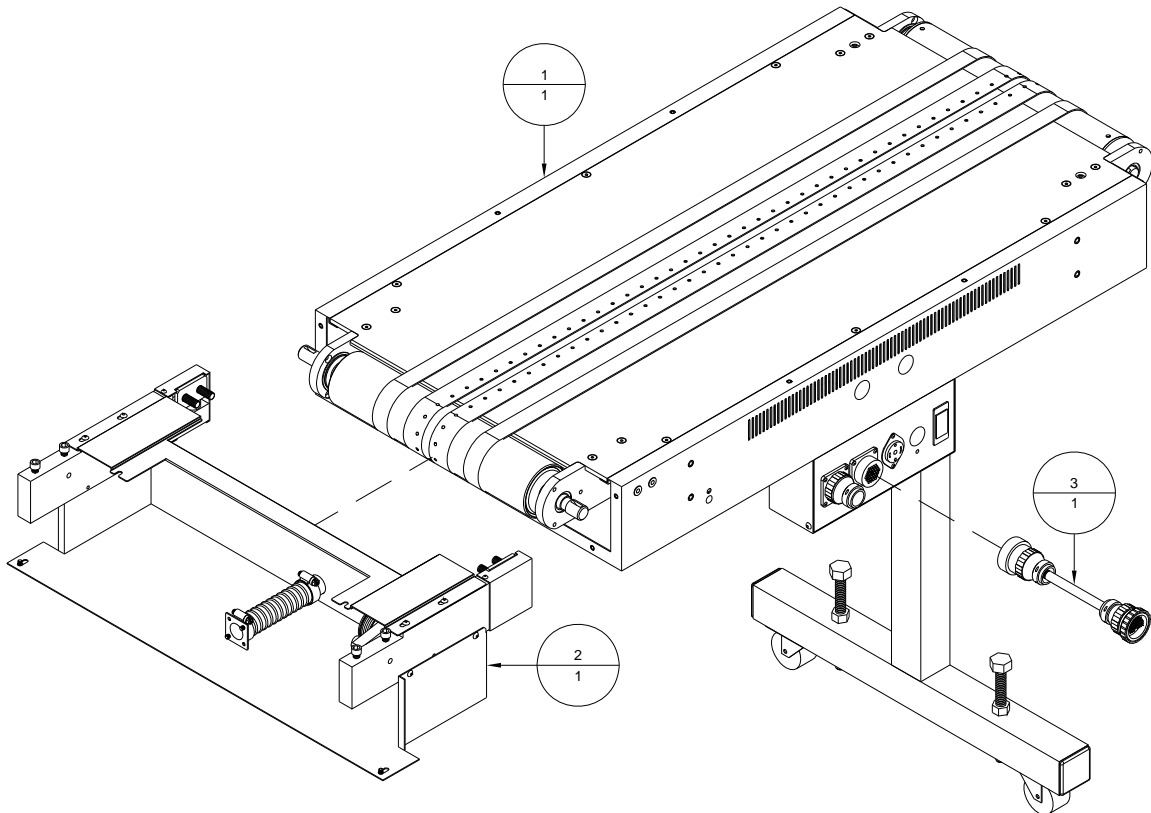
*Figure A-2: BK703-7IBL-2 - Extension Table, For BK7IB-2 Left*

Table A-3: BK703-76IBL - Vacuum Extension Table, BK76IB, Left

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-14
24	9100860	1	Electrical Bracket Cover	
25	9101409A	1	Vacuum Chassis Assembly	Page A-19
26	9101410	1	Vacuum Table End cover	
27	9101627	1	Buskro Serial Number Label	
28	BK-CAB-UNI	1	Universal Interconnect Cable	
29	9102282LA	1	Tabletop, Extension Assembly, Left	Page A-22
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: BK703-76IBL - Vacuum Extension Table, BK761B, Left

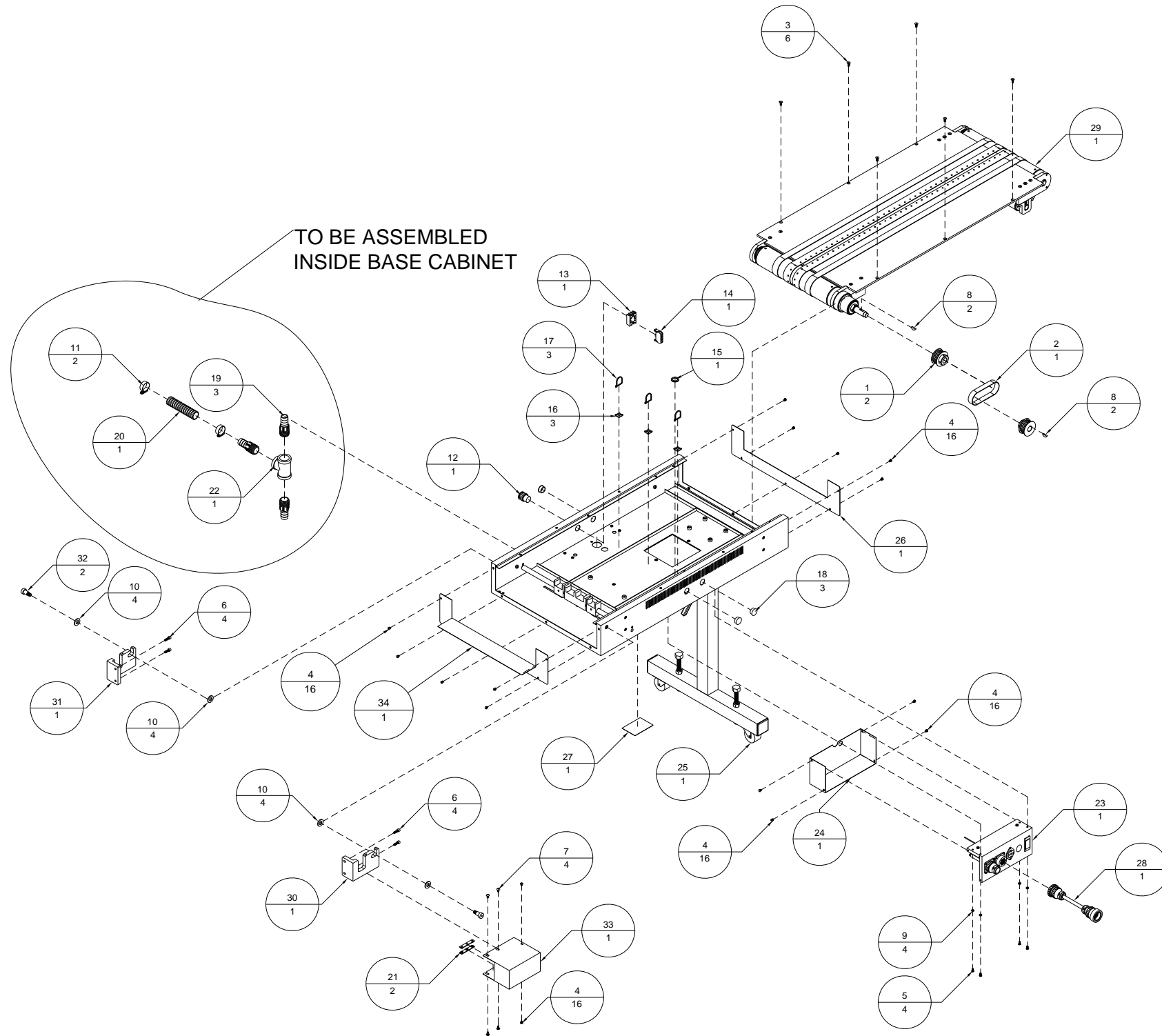


Table A-4: BK703-76IBR - Vacuum Extension Table, BK76IB, Right

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-14
24	9100860	1	Electrical Bracket Cover	
25	9101409A	1	Vacuum Chassis Assembly	Page A-19
26	9101410	1	Vacuum Table End cover	
27	9101627	1	Buskro Serial Number Label	
28	BK-CAB-UNI	1	Universal Interconnect Cable	
29	9102282RA	1	Tabletop, Extension Assembly, Right	Page A-24
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: BK703-76IBR - Vacuum Extension Table, BK761B, Right

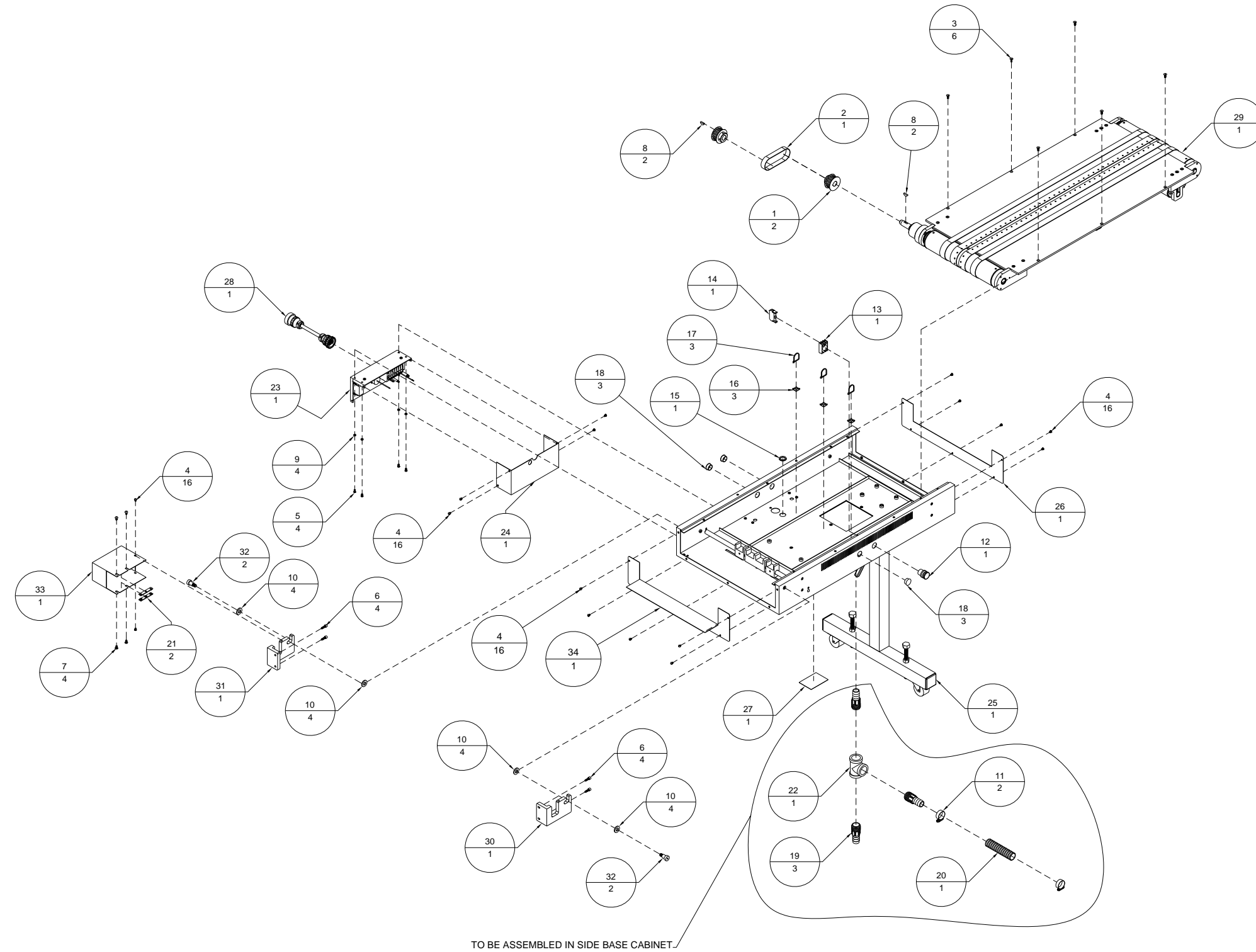


Table A-5: BK703 - Vacuum Extension Table, Right

Item	Part Number	Quantity	Description	Reference
1	404030	6	Screw, FHCS, 10-32 UNF x 1/2"	
2	404510	9	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-14
13	9100860	1	Electrical Bracket Cover	
14	9101400A	1	Vacuum Extension Tabletop Assembly	Page A-17
15	9101409A	1	Vacuum Chassis Assembly	Page A-19
16	9101410	1	Vacuum Table End Cover	
17	9101627	1	Buskro Serial Number Label	

Figure A-5: BK703 - Vacuum Extension Table, Right

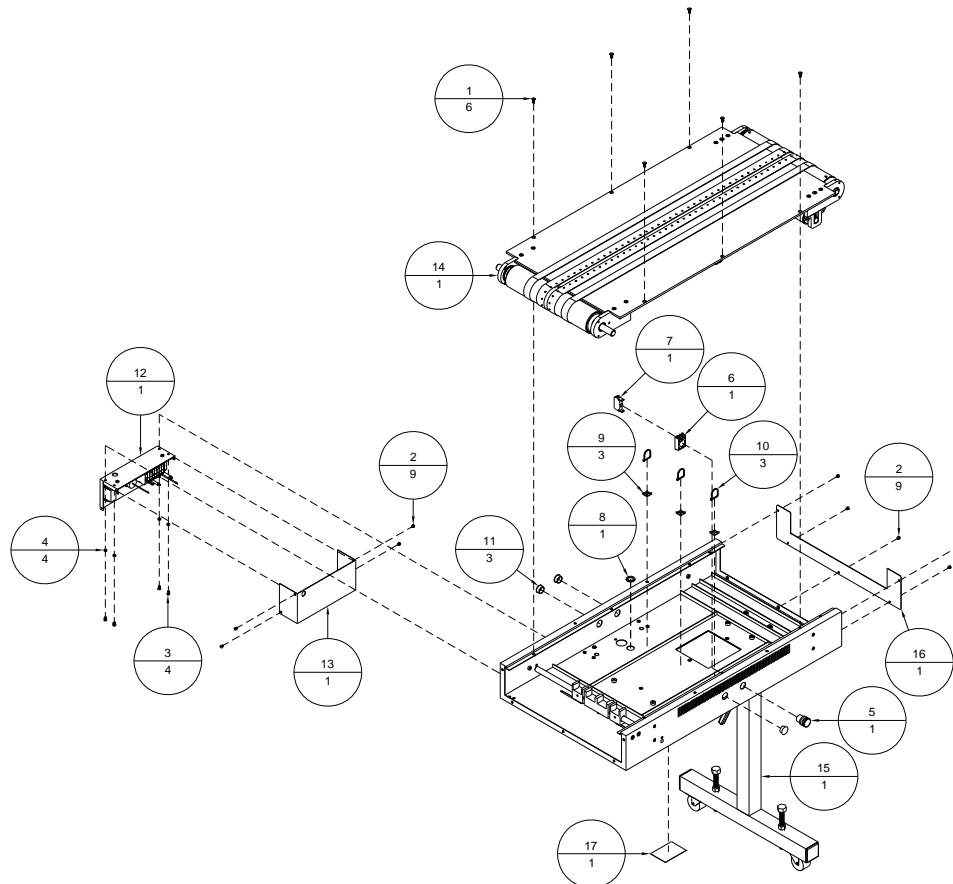




Table A-6: BK703L - Vacuum Extension Table, Left

Item	Part Number	Quantity	Description	Reference
1	404030	6	Screw, FHCS, 10-32 UNF x 1/2"	
2	404510	9	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-14
13	9100860	1	Electrical Bracket Cover	
14	9101400LA	1	Vacuum Tabletop Assembly (Left)	Page A-18
15	9101409A	1	Vacuum Chassis Assembly	Page A-19
16	9101410	1	Vacuum Table End Cover	
17	9101627	1	Buskro Serial Number Label	

Figure A-6: BK703L - Vacuum Extension Table, Left

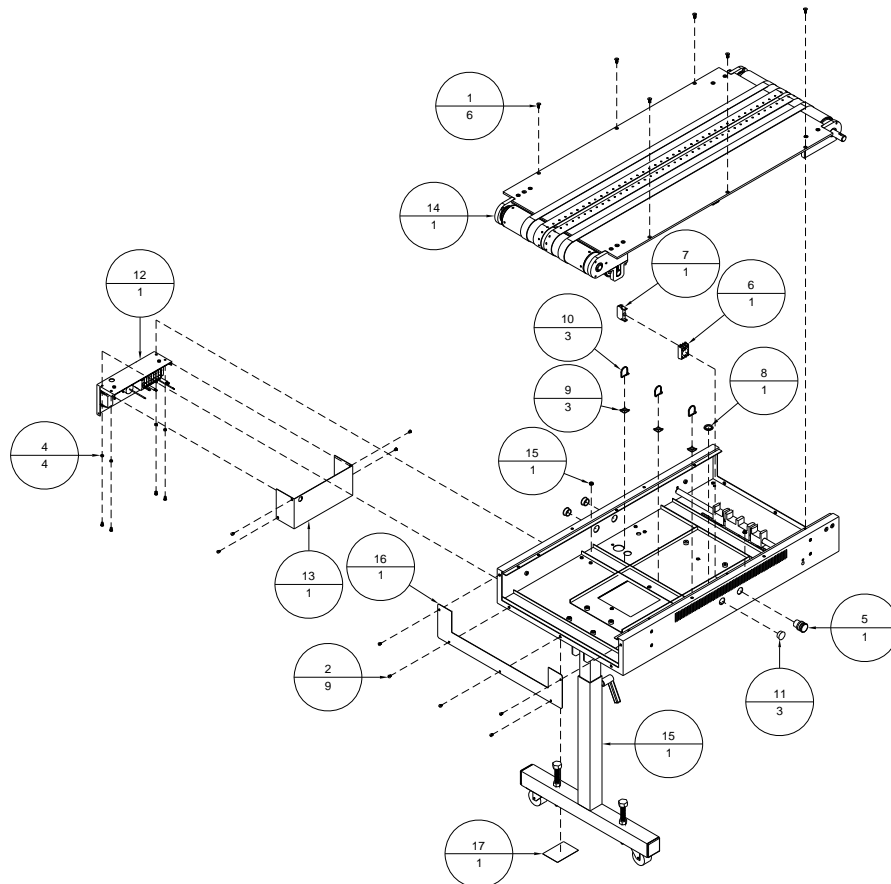
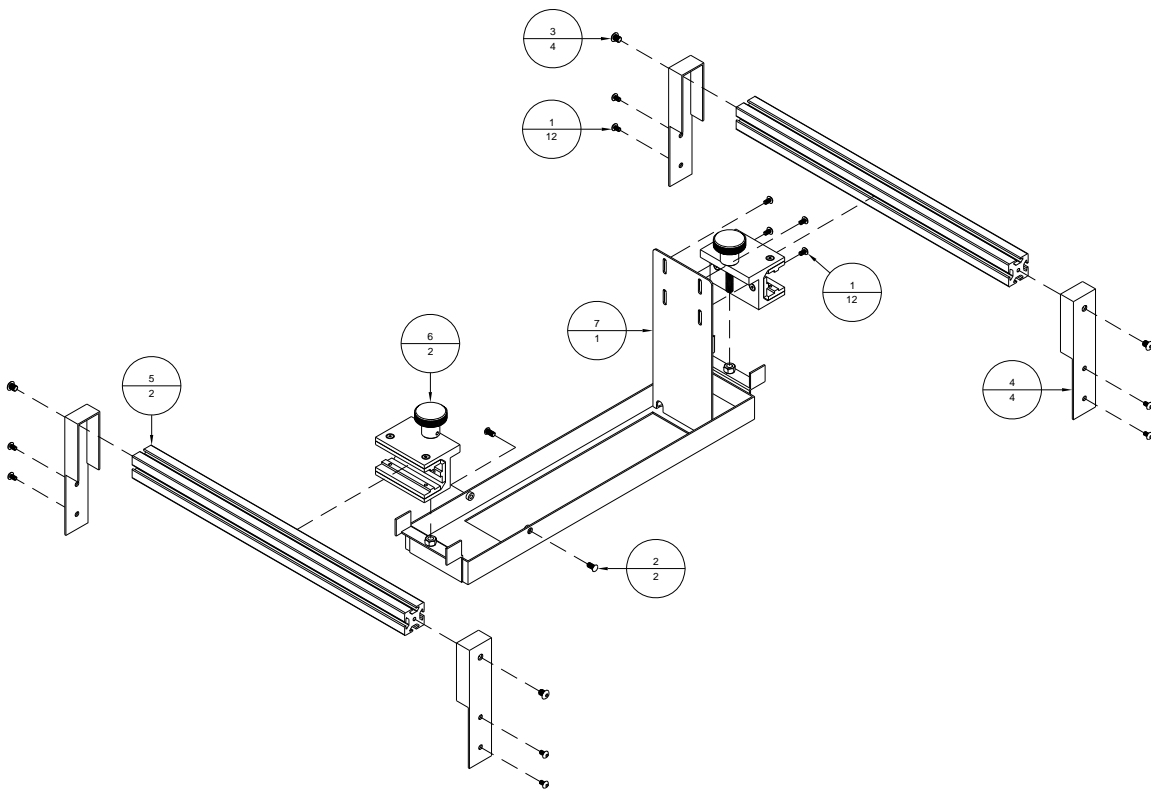


Table A-7: BK710-HTR2 - Heater Cradle, BK5060

Item	Part Number	Quantity	Description	Reference
1	405520	12	Screw, BHCS, 1/4-20 UNC x 3/8"	
2	405530	2	Screw, BHCS, 1/4-20 UNC x 1/2"	
3	406530	4	Screw, BHCS, 5/16-18 UNC x 1/2"	
4	9100475	4	Vertical Heater Support	
5	9100476	2	Lateral Heater Support	
6	9100691A	2	Mounting Bracket Assembly	Page A-13
7	9102429A	1	Dryer Tray, BK5060	

Figure A-7: BK710-HTR2 - Heater Cradle, BK5060



**Note:** Heater Cradle to be used with the BK5060 Heater.

Table A-8: BK715LMV - Power Take-Off Unit, BK703/BK71B, Left

Item	Part Number	Quantity	Description	Reference
1	402510	4	Screw, BHCS, 6-32 UNC x 1/4"	
2	404510	10	Screw, BHCS, 10-32 UNF x 1/4"	
3	405520	4	Screw, BHCS, 1/4-20 UNC x 3/8"	
4	406250	4	Screw, SHCS, 5/16-18 UNC x 3/4"	
5	407570	4	Screw, BHCS, 3/8-16 UNC x 1"	
6	9104570	1	Power Takeoff Bracket	
7	9104608	1	Upper Gap Cover	
8	9104629LA	1	Power Take-off Drive Assembly, Right	Page A-26
9	9104656A	1	Lower Gap Cover Assembly	Page A-28
10	9104803	4	Anti-Vibration Mount	
11	9104809	2	Mount, Anti-Vibration Bracket	
12	9104996	2	Cover, Vibration Mount / Power Take-off	

Figure A-8: BK715LMV - Power Take-Off Unit, BK703/BK71B, Left

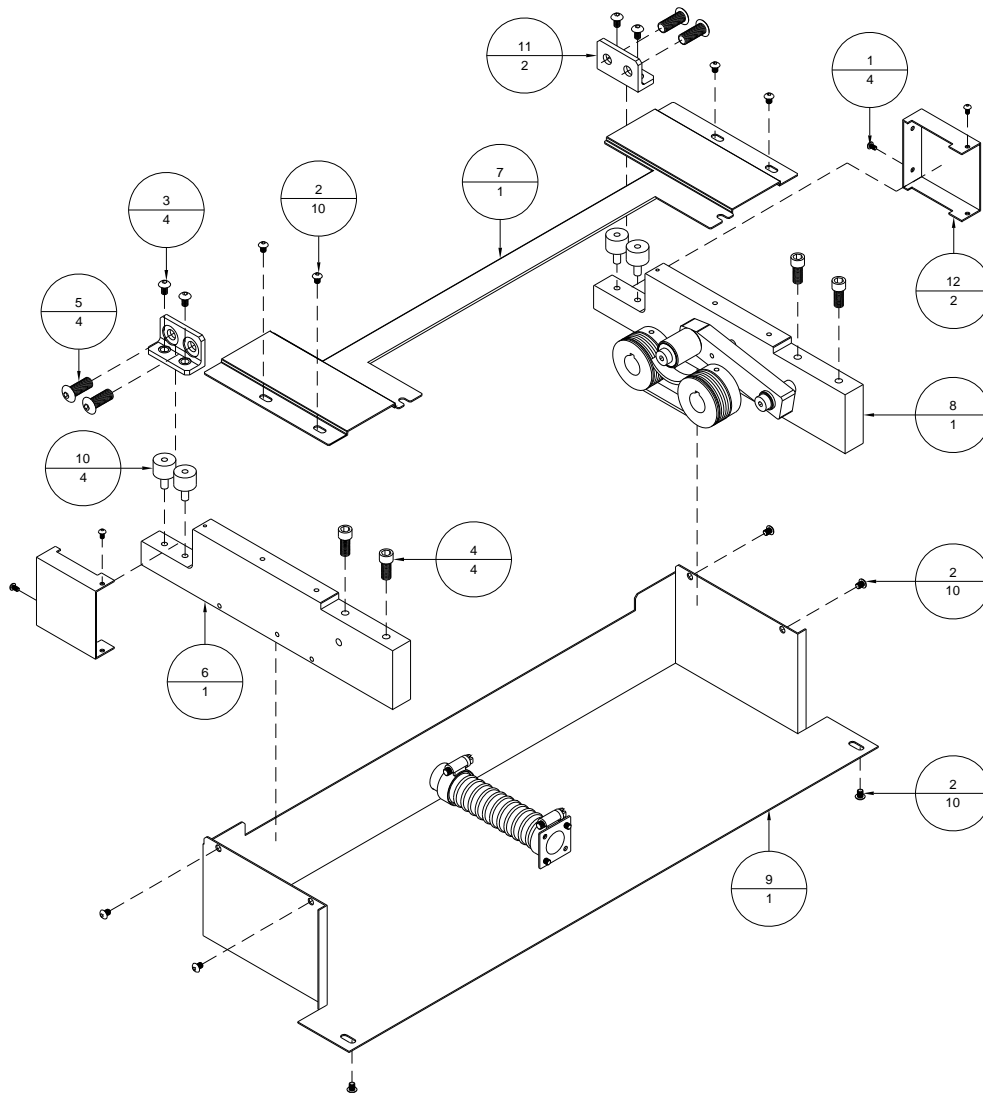


Table A-9: BK715RMV - Power Take-Off Unit, BK703/BK71B, Right

Item	Part Number	Quantity	Description	Reference
1	402510	4	Screw, BHCS, 6-32 UNC x 1/4"	
2	404510	10	Screw, BHCS, 10-32 UNF x 1/4"	
3	405520	4	Screw, BHCS, 1/4-20 UNC x 3/8"	
4	406250	4	Screw, SHCS, 5/16-18 UNC x 3/4"	
5	407570	4	Screw, BHCS, 3/8-16 UNC x 1"	
6	9104570	1	Power Takeoff Bracket	
7	9104608	1	Upper Gap Cover	
8	9104629RA	1	Power Take-off Drive Assembly, Right	Page A-27
9	9104656A	1	Lower Gap Cover Assembly	Page A-28
10	9104803	4	Anti-Vibration Mount	
11	9104809	2	Mount, Anti-Vibration Bracket	
12	9104996	2	Cover, Vibration Mount / Power Take-off	

Figure A-9: BK715RMV - Power Take-Off Unit, BK703/BK71B, Right

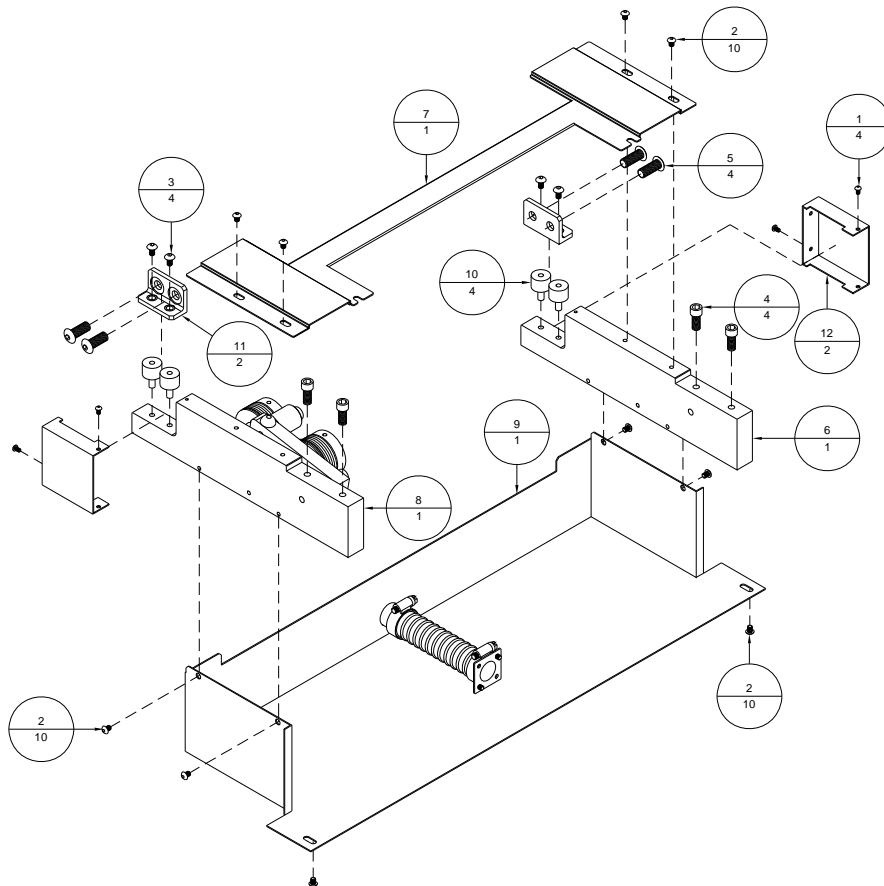


Table A-10: 9100484A - T-Leg Assembly

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-10: 9100484A - T-Leg Assembly

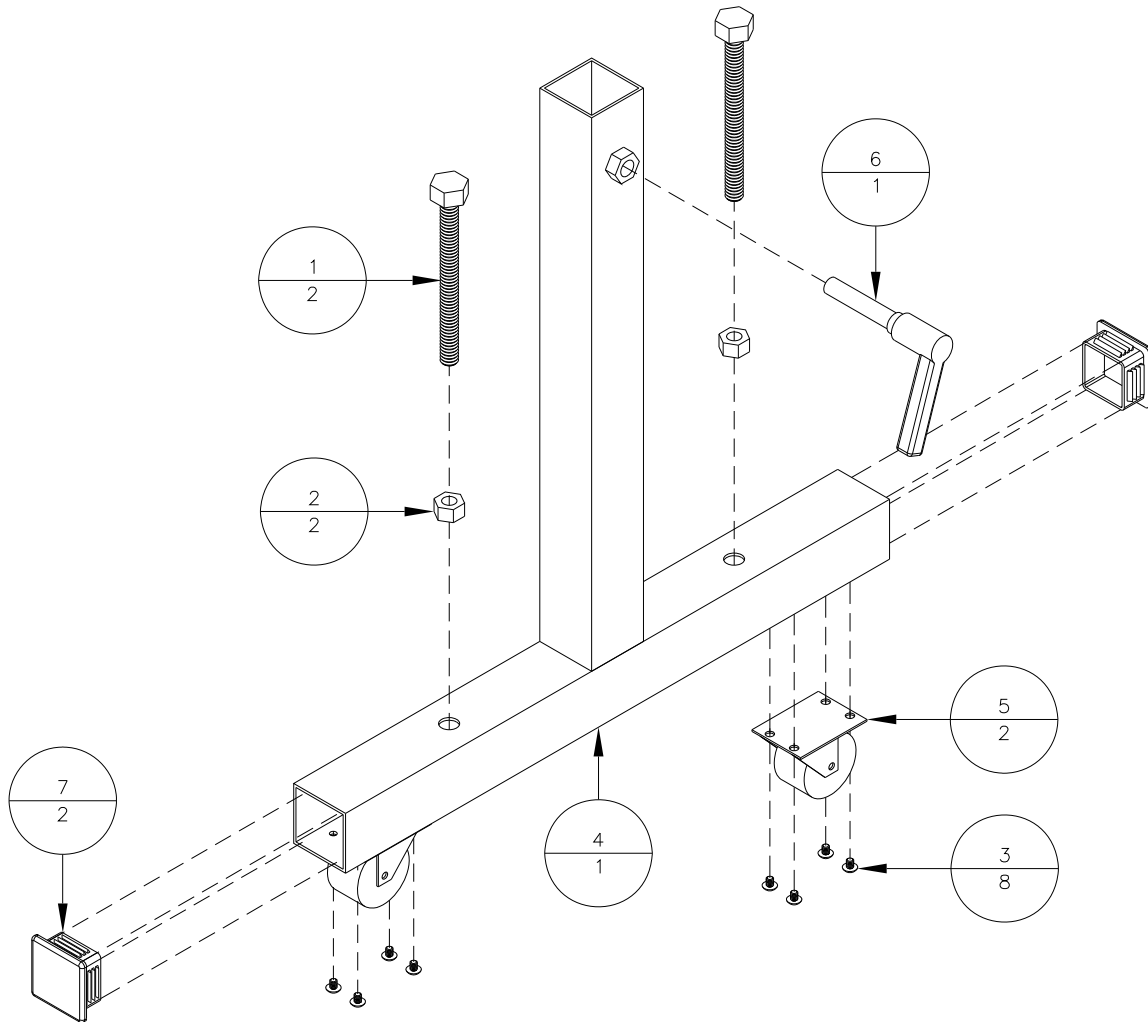


Table A-11: 9100691A – Mounting Bracket Assembly, Heater Cradle

Item	Part Number	Quantity	Description	Reference
1	404030	4	Screw, FHCS, 10-32 UNF x 1/2"	
2	404040	2	Screw, FHCS, 10-32 UNF x 5/8"	
3	404810	1	Screw, SHSS, 10-32 UNF x 1/4"	
4	407286	1	Screw, SHCS, 3/8-16 UNC x 2"	
5	438007H	1	Knob	
6	9100691	1	Rail Mounting Bracket	
7	9100790	3	Mount Slide	

Figure A-11: 9100691A – Mounting Bracket Assembly, Heater Cradle

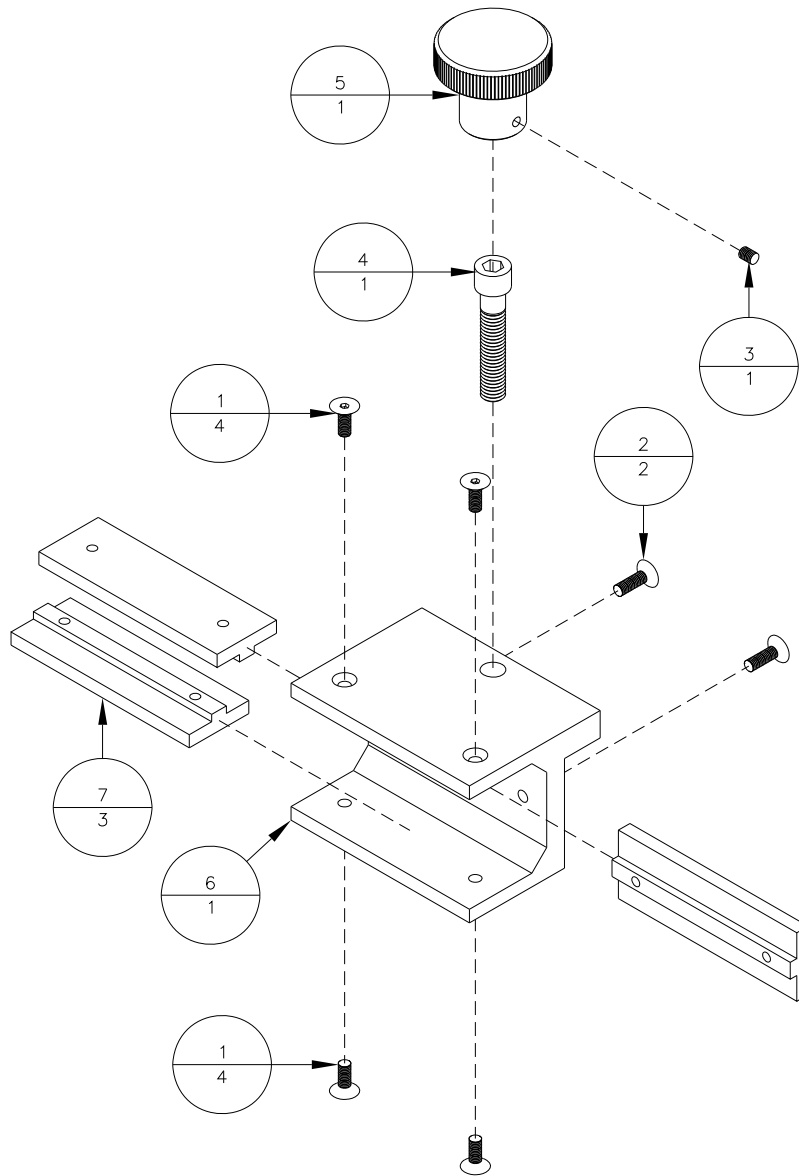
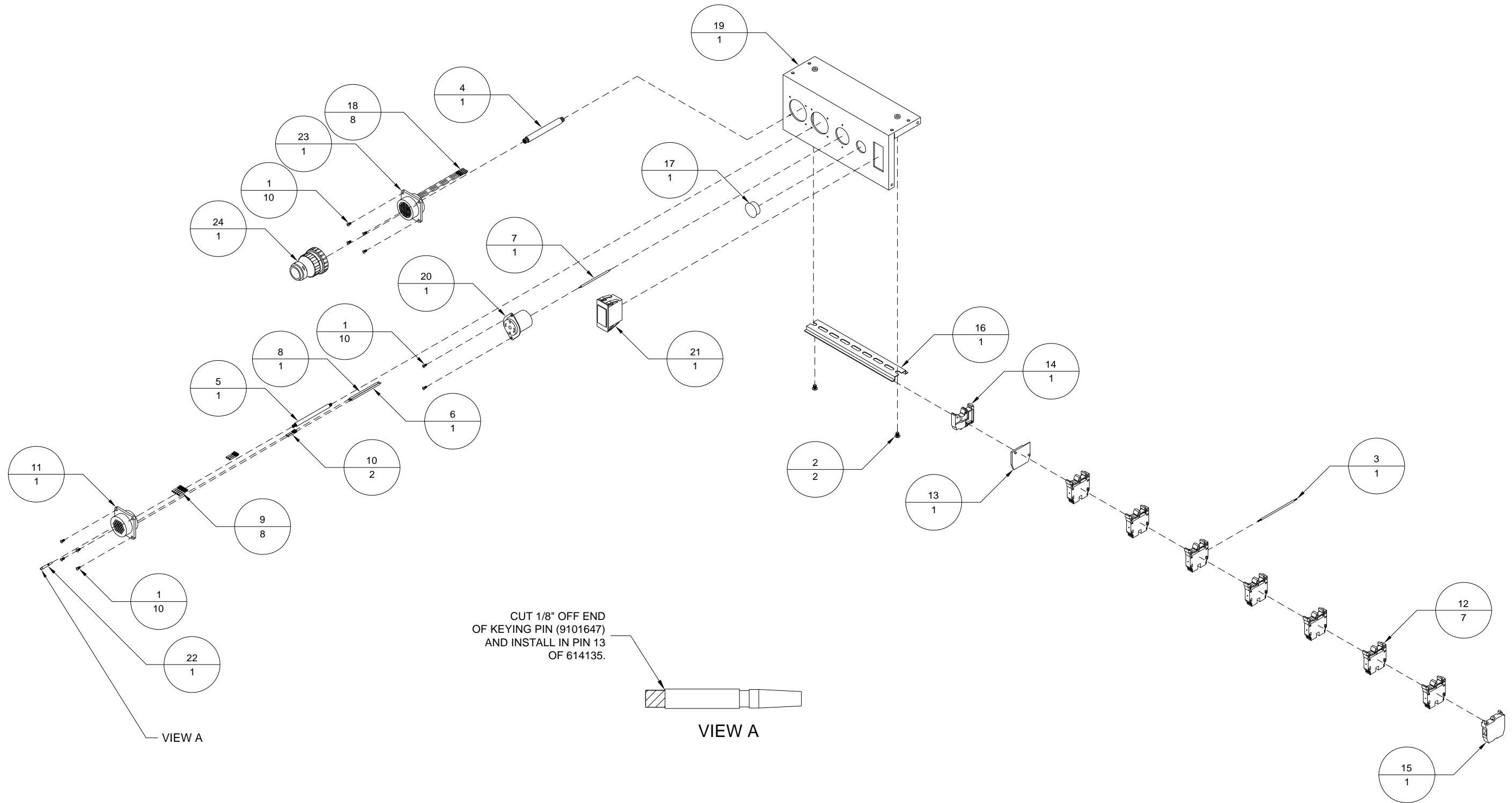


Table A-12: 9100854A - Electrical Bracket Assembly

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-21

Figure A-12: 9100854A - Electrical Bracket Assembly





*Table A-13: 9101038A - Take-Up Roller Assembly*

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	

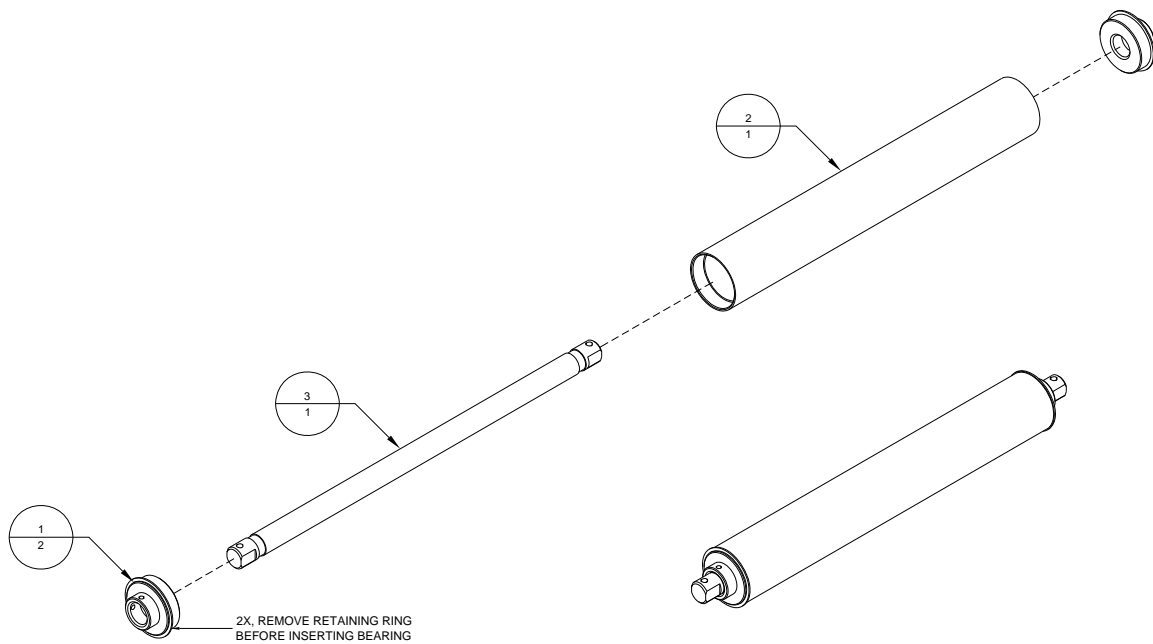
*Figure A-13: 9101038A - Take-Up Roller Assembly*

Table A-14: 9101400A - Vacuum Extension Tabletop Assembly, Right

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	404510	10	Screw, BHCS, 10-32 UNF x 1/4"	
4	405250	4	Screw, SHCS, 1/4-20 UNC x 3/4"	
5	405830	4	Screw, SHSS, 1/4-20 UNC x 1/2"	
6	405997	2	Screw, RHMS, 1/4-20 UNC x 4"	
7	439009	10	Lockwasher, No. 10	
8	439010	4	Lockwasher, 1/4" I.D.	
9	444004	2	Hose Clamp, Gear Type, 9/16 - 1 1/4	
10	500055	4	Bearing, UBR204-12S, 3/4" I.D.	
11	802601	40"	Vacuum Tubing, Grey PVC, 1"	
12	9101031A	1	Inline Roller	
13	9101037	2	Take-Up Shaft Guide Block	
14	9101038A	1	Take-Up Roller Assembly	Page A-16
15	9101041	1	Inline Roller Shaft	
16	9101400	1	Vacuum Extension Tabletop	
17	9101401	2	Roller Mounting Block	
18	9101405	2	Secondary Roller Mounting Block	
19	9101406	2	Vacuum Table Vacuum Belt	
20	9101407	2	Vacuum Table Transport Belt	
21	9101408	1	Vacuum Table Vacuum Column	
22	9101414	1	Vacuum Hose Flanged Fitting	
23	9104599	1	Inline Roller Tube	

Figure A-14: 9101400A - Vacuum Extension Tabletop Assembly, Right

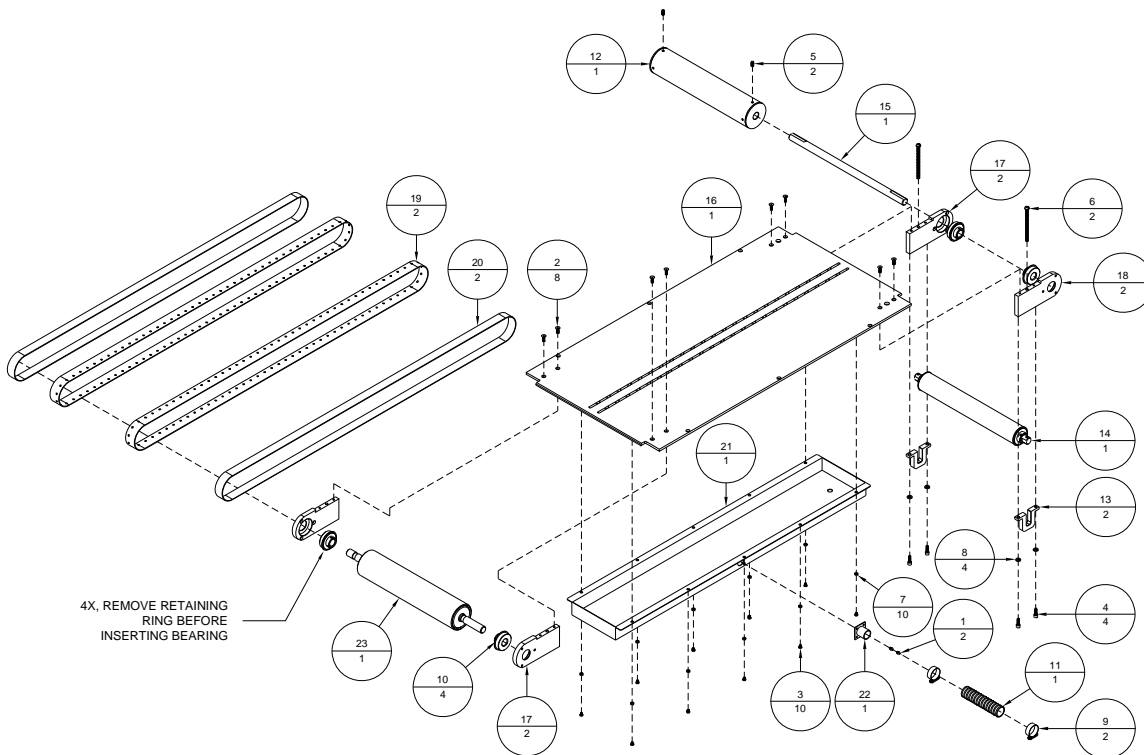


Table A-15: 9101400LA - Vacuum Tabletop Assembly, Left

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	404510	10	Screw, BHCS, 10-32 UNF x 1/4"	
4	405250	4	Screw, SHCS, 1/4-20 UNC x 3/4"	
5	405830	2	Screw, SHSS, 1/4-20 UNC x 1/2"	
6	405997	2	Screw, RHMS, 1/4-20 UNC x 4"	
7	439009	10	Lockwasher, No. 10	
8	439010	4	Lockwasher, 1/4" I.D.	
9	444004	2	Hose Clamp, Gear Type, 9/16 - 1 1/4	
10	500055	4	Bearing, UBR204-12S, 3/4" I.D.	
11	802601	40"	Vacuum Tubing, Grey PVC, 1"	
12	9101031A	2	Inline Roller	
13	9101037	2	Take-Up Shaft Guide Block	
14	9101038A	1	Take-Up Roller Assembly	Page A-16
15	9101041	1	Inline Roller Shaft	
16	9101400	1	Vacuum Extension Tabletop	
17	9101401	2	Roller Mounting Block	
18	9101405	2	Secondary Roller Mounting Block	
19	9101406	2	Vacuum Table Vacuum Belt	
20	9101407	2	Vacuum Table Transport Belt	
21	9101408	1	Vacuum Table Vacuum Column	
22	9101414	1	Vacuum Hose Flanged Fitting	
23	9104599	1	Inline Roller Tube	

Figure A-15: 9101400LA - Vacuum Tabletop Assembly, Left

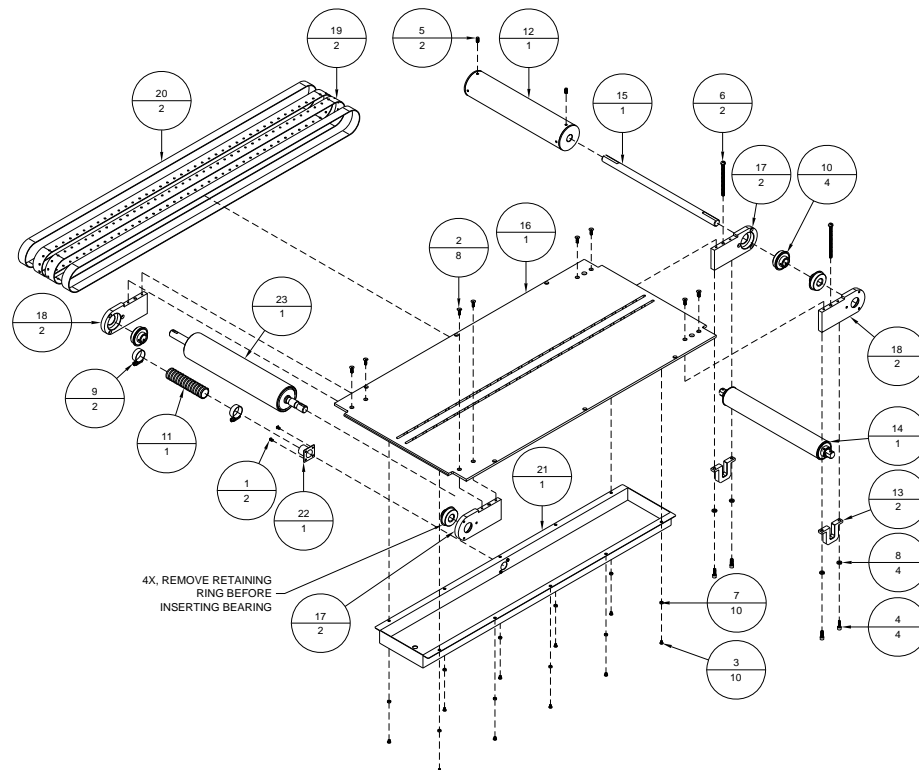


Table A-16: 9101409A - Vacuum Chassis Assembly

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	
22	9100978	2	Rubber Grommet, 3/8" ID	

Figure A-16: 9101409A - Vacuum Chassis Assembly

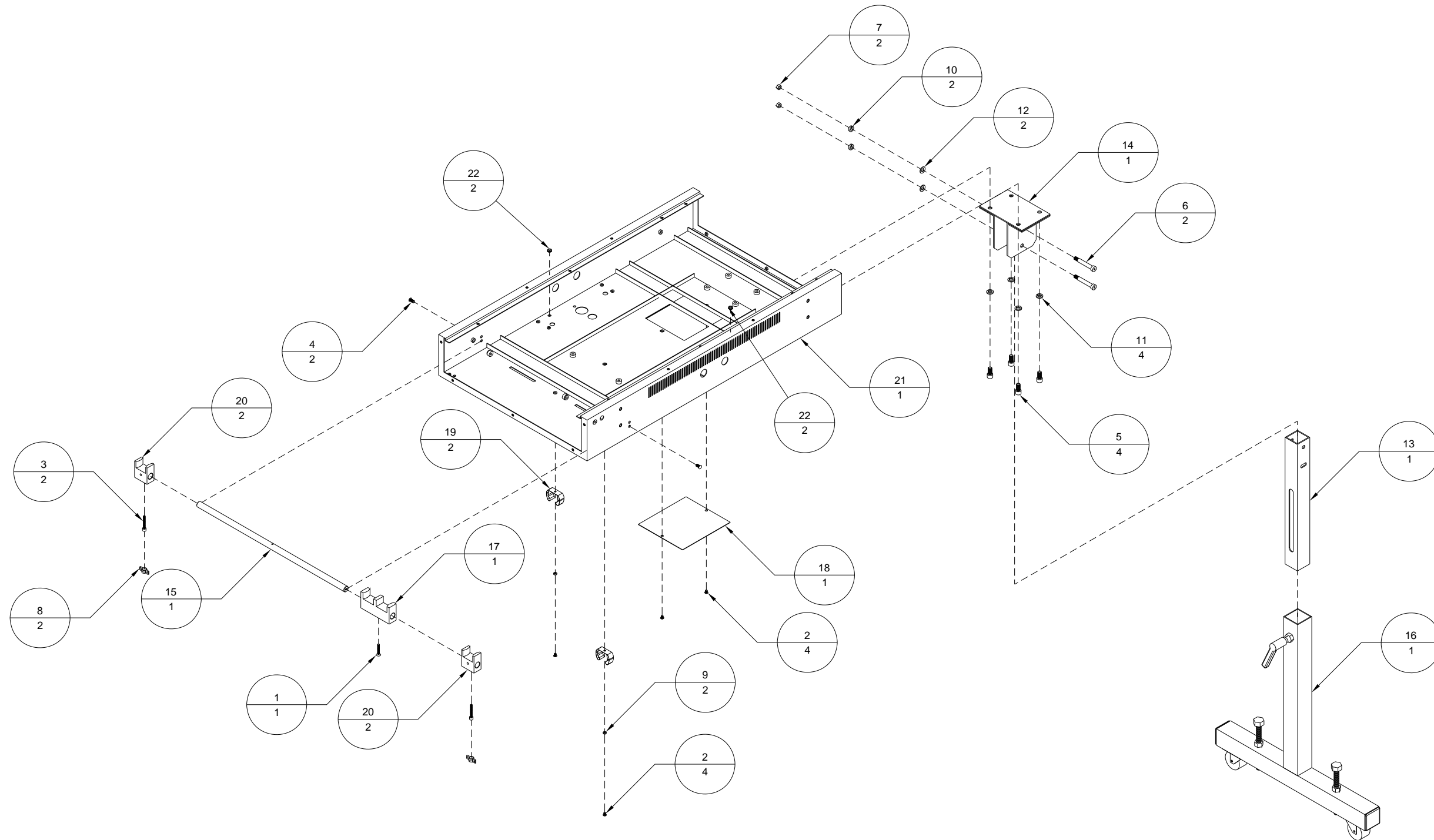


Table A-17: 9102055A - Plug, Jumper, 23-57

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-17: 9102055A - Plug, Jumper, 23-57

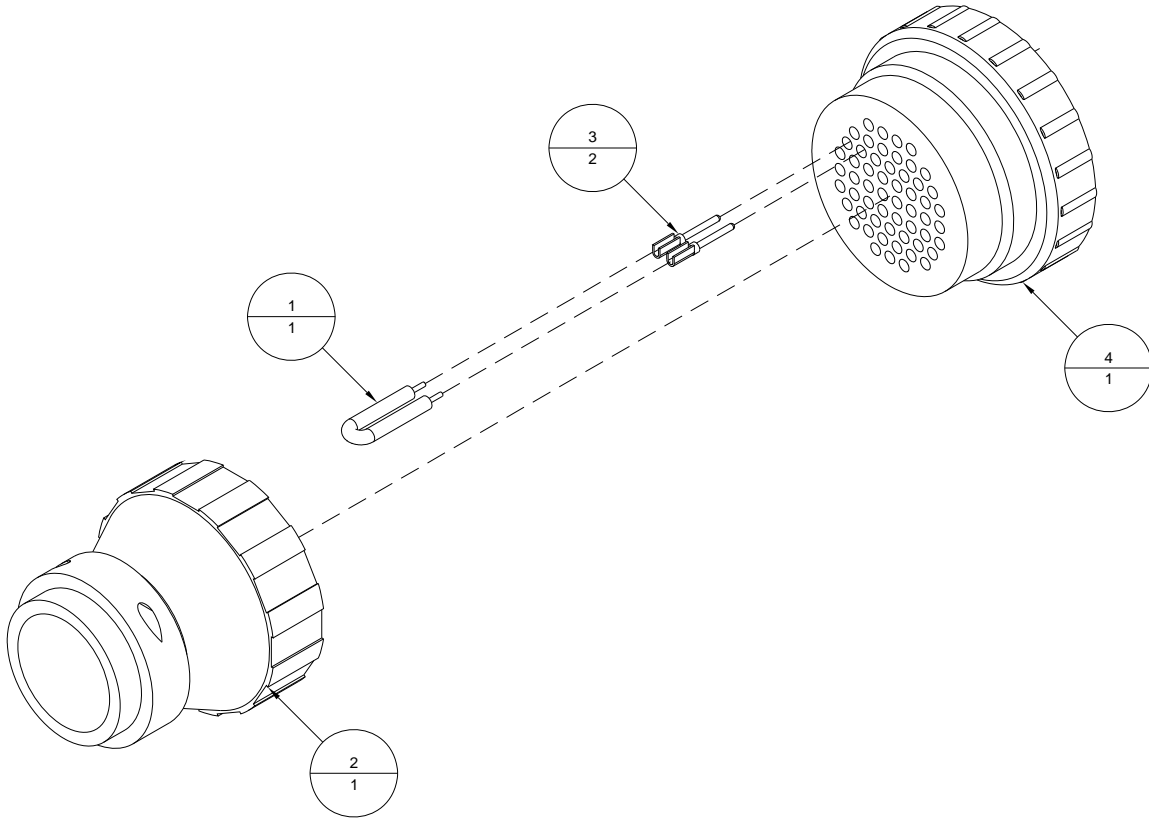


Table A-18: 9102282LA - Tabletop, Extension Assembly, Left

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-16
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-18: 9102282LA - Tabletop, Extension Assembly, Left

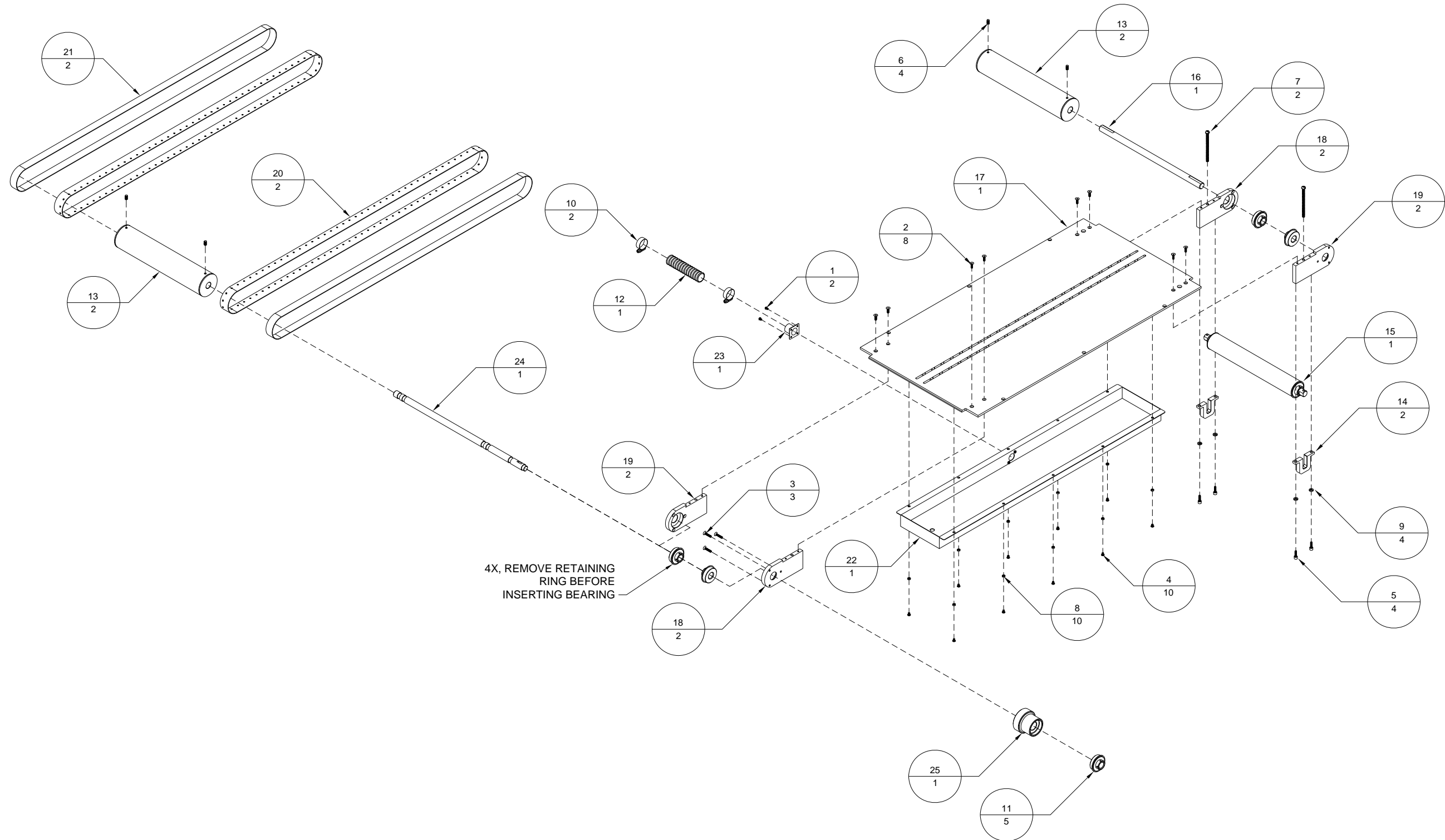




Table A-19: 9102282RA - Tabletop, Extension Assembly, Right

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-16
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-19: 9102282RA - Tabletop, Extension Assembly, Right

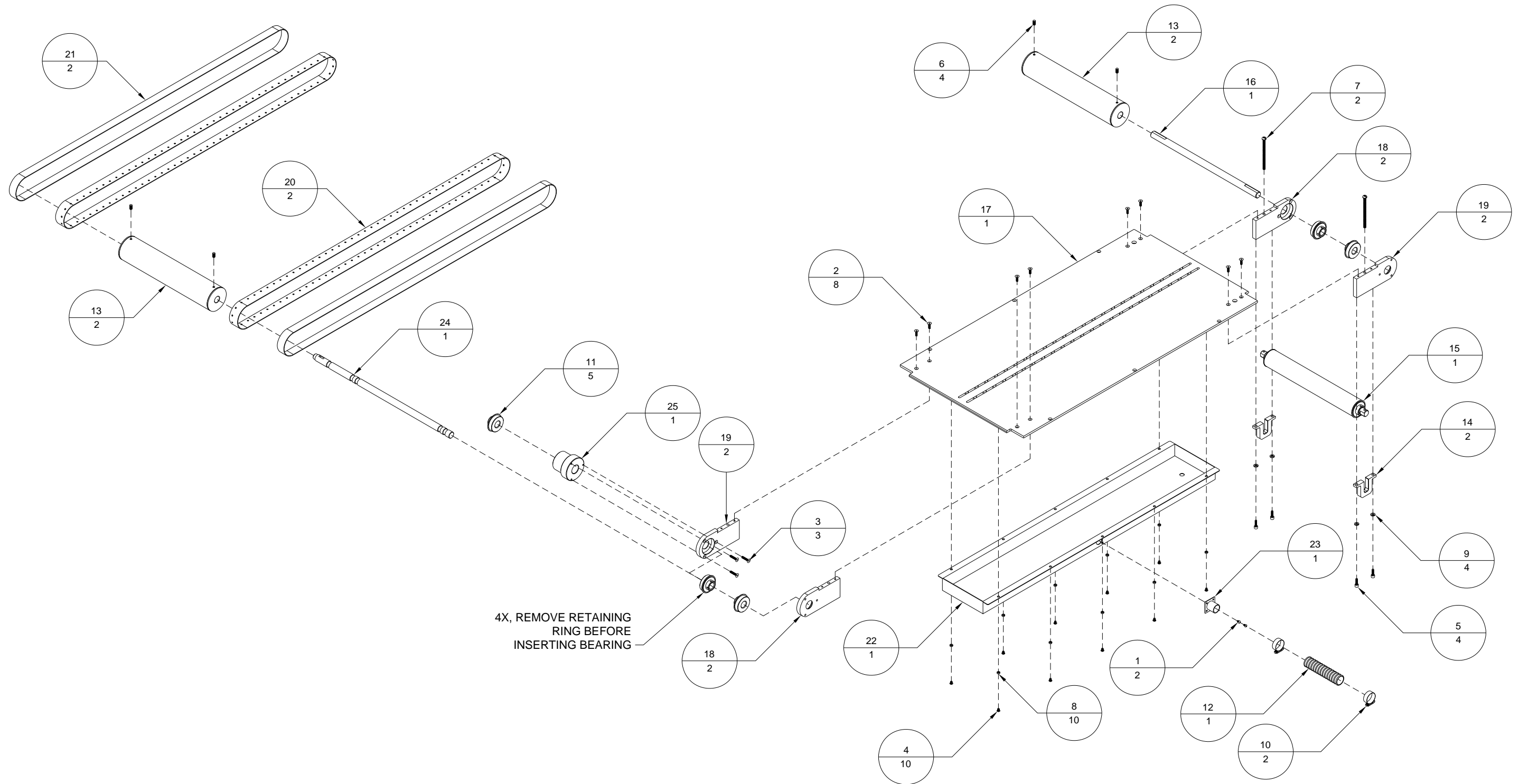


Table A-20: 9104629LA - Power Take-off Drive Assembly, Left

Item	Part Number	Quantity	Description	Reference
1	9104570	1	Power Takeoff Bracket	
2	9104607	2	Pulley, 1.9" OD, 3/4" ID	
3	9104650	1	Belt, Poly-V, 130J6	
4	9104658A	1	Tensioner, Power Take-off Assembly	Page A-29

Figure A-20: 9104629LA - Power Take-off Drive Assembly, Left

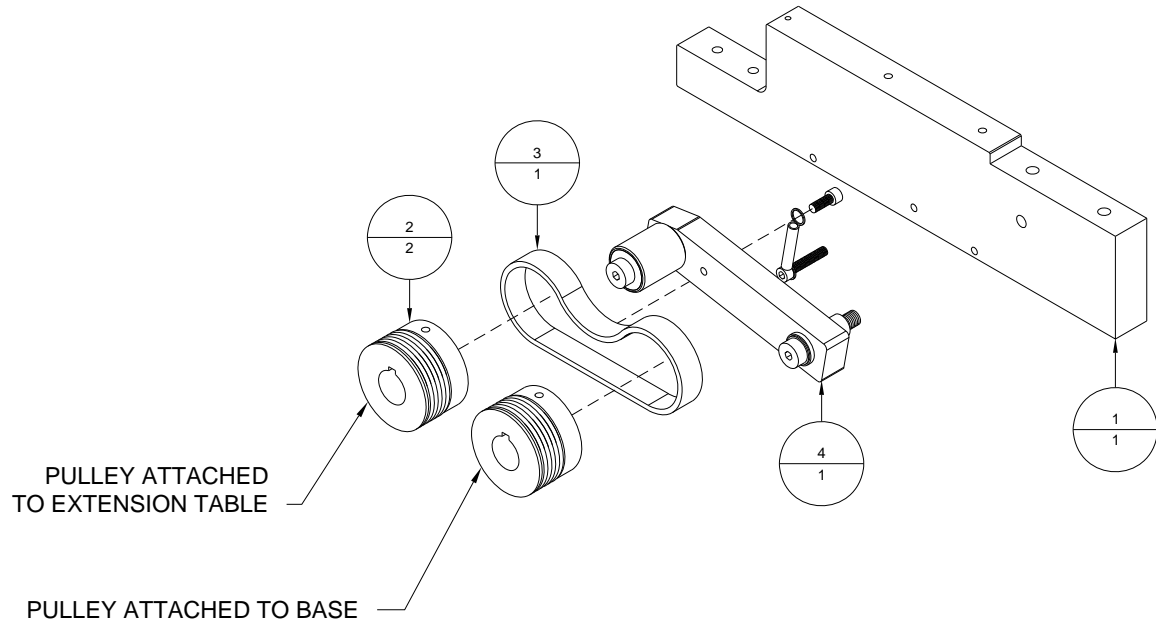


Table A-21: 9104629RA - Power Take-off Drive Assembly, Right

Item	Part Number	Quantity	Description	Reference
1	9104570	1	Power Takeoff Bracket	
2	9104607	2	Pulley, 1.9" OD, 3/4" ID	
3	9104650	1	Belt, Poly-V, 130J6	
4	9104658A	1	Tensioner, Power Take-off Assembly	Page A-29

Figure A-21: 9104629RA - Power Take-off Drive Assembly, Right

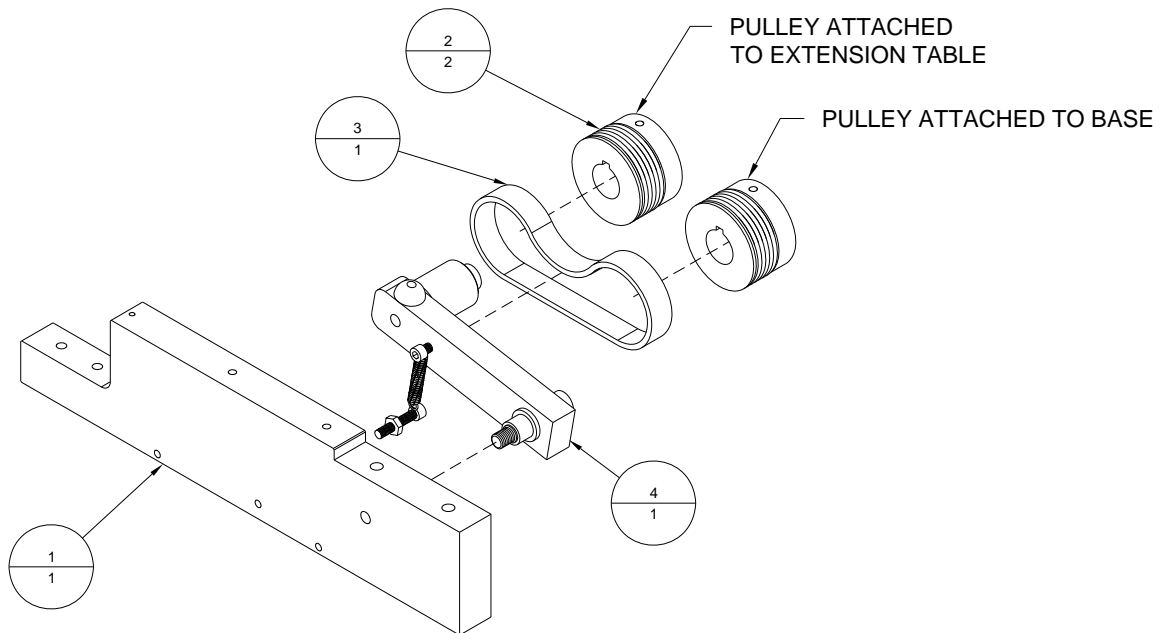


Table A-22: 9104656A - Lower Gap Cover Assembly

Item	Part Number	Quantity	Description	Reference
1	404510	2	Screw, BHCS, 10-32 UNF x 1/4"	
2	444004	2	Clamp, Hose, Gear Type, 9/16 x 1-1/4"	
3	802601	1	Tubing, Vacuum, Grey PVC	
4	9101414	1	Vacuum Hose Flanged Fitting	
5	9104656	1	Lower Gap Cover	

Figure A-22: 9104656A - Lower Gap Cover Assembly

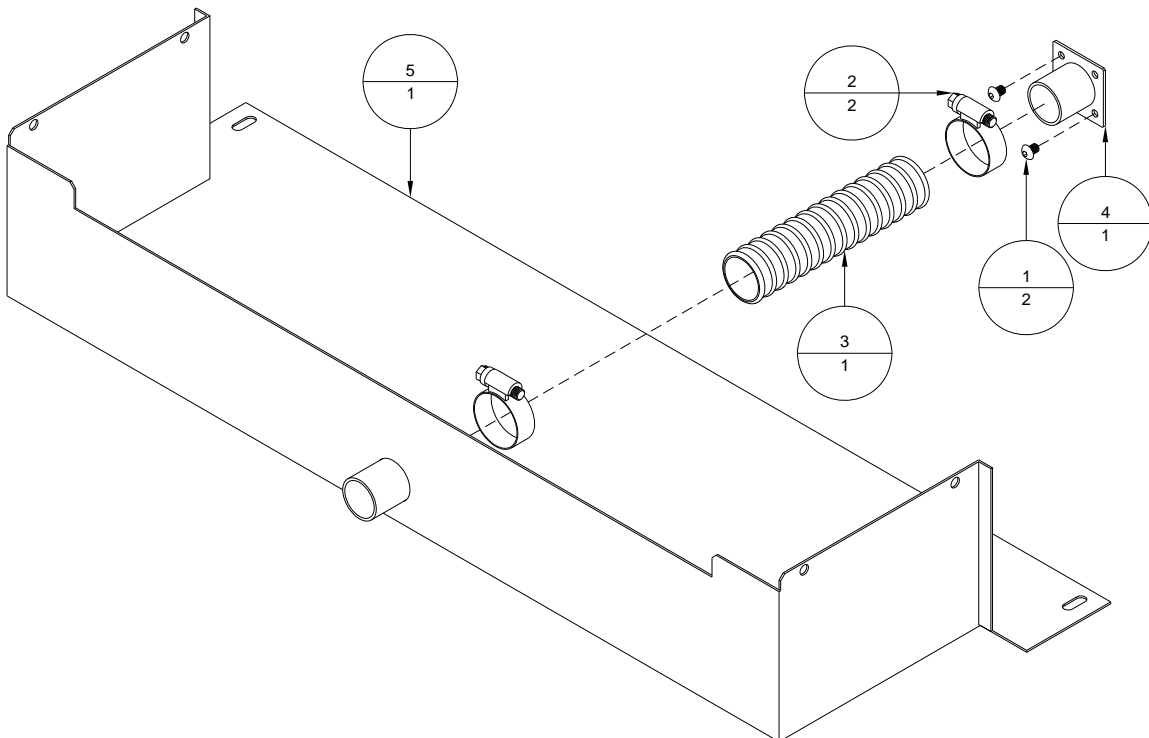
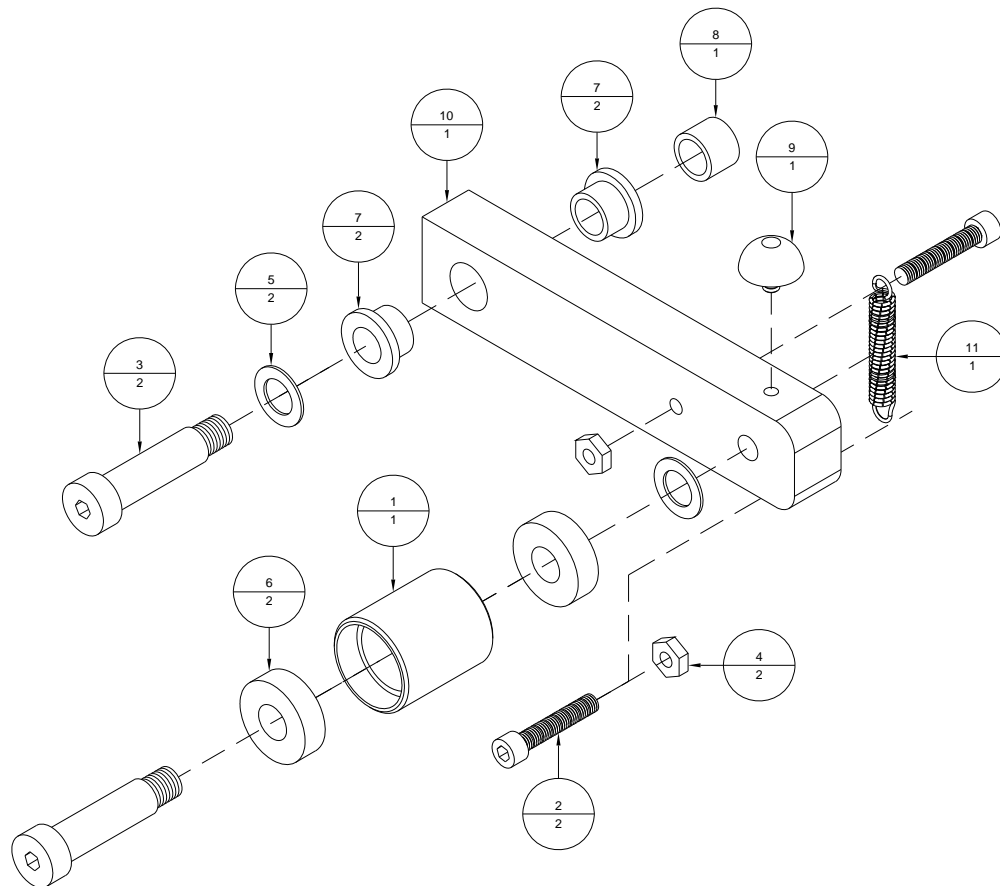


Table A-23: 9104658A - Tensioner, Power Take-off Assembly

Item	Part Number	Quantity	Description	Reference
1	106100	1	Belt Alignment Tube	
2	404270	2	Screw, SHCS, 10-32 UNF x 1"	
3	416175	2	Shoulder Bolt, 3/8" x 1-1/4" (5/16-18 UNC)	
4	420008	2	Nut, 10-32 UNF	
5	443830	2	Spacer Washer, 3/8 ID x 0.031" Thick	
6	500020	2	Bearing, R6, 3/8" ID	
7	505110	2	Bushing, Flange, 3/8" ID x 1/2" OD x 3/8" Lg.	
8	9103633	1	Bushing, Brass, 3/8" ID x 1/2" OD x 3/8" Lg.	
9	9103821	1	Bumper, Rubber, 8-32 x 1/4"	
10	9104601	1	Arm, Pivot	
11	9105216	1	Spring, Extension, 0.25" OD x 1.12" Lg.	

Figure A-23: 9104658A - Tensioner, Power Take-off Assembly



## 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)

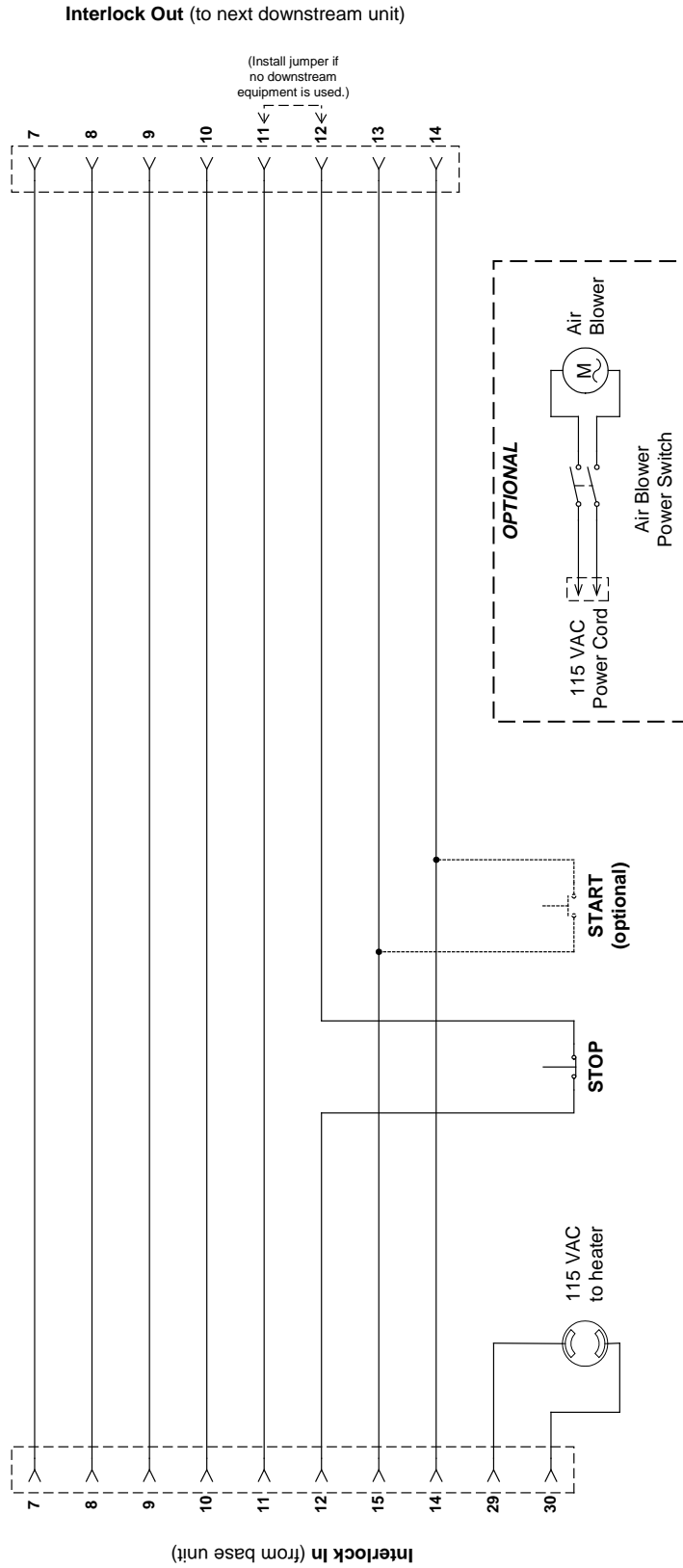




Figure B-2: Extension Table Wiring Diagram (BK703)

