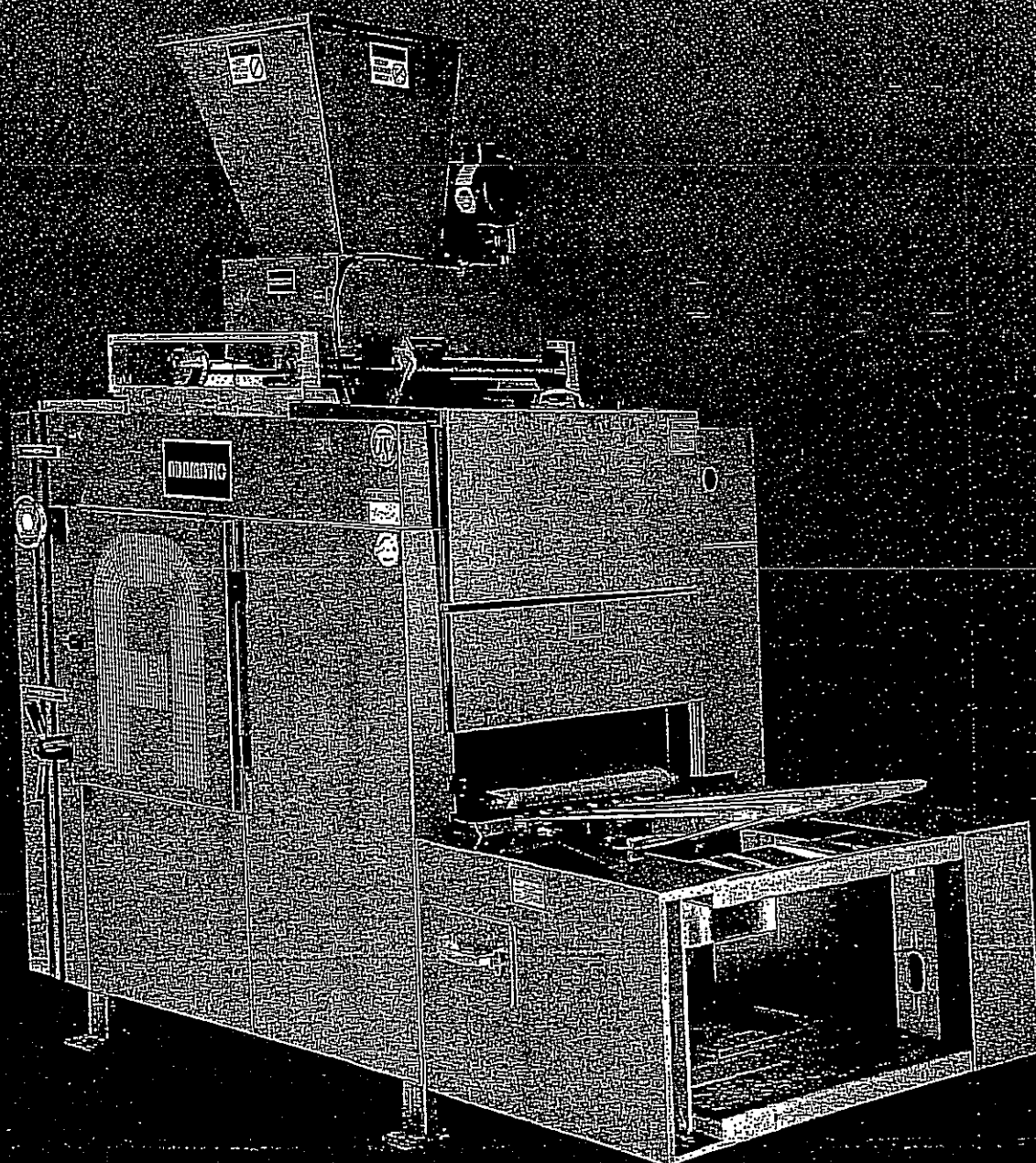


ADAMATIC

AGA

PART OF AGA FOODSERVICE GROUP

VDR DIVIDER/ROUNDER



W A R N I N G !

ADAMATIC Maintenance and Sanitation

It is the responsibility of the Purchaser/Operator to maintain the equipment in clean and good working order. The machine should be CLEANED, GREASED AND OILED according to instruction DAILY, AFTER EACH OPERATION.

THE SAFETY COVERS ON THE MACHINE MUST REMAIN IN PLACE DURING THE OPERATION OF THE MACHINE. NEVER DISCONNECT SAFETY SWITCHES ON THE MACHINE. ALL POWER MUST BE TURNED "OFF" PRIOR TO THE REMOVAL OF SAFETY COVERS FOR CLEANING AND MAINTENANCE. NEVER PUT HANDS INTO RUNNING MACHINE.

PERSONNEL OPERATING THE MACHINE MUST BE INSTRUCTED BY THE PURCHASER IN THE PROPER CLEANING, MAINTENANCE AND SAFETY PROCEDURES.

FAILURE TO FOLLOW THESE INSTRUCTIONS MAY RESULT IN PERSONAL INJURY OR PROPERTY DAMAGE.



Part of AGA Bakery

VDR

INTRODUCTION

- 1.1 The following instructions have been carefully prepared to assist you in installing and operating the ADAMATIC Vision Divider Rounder (VDR). The drawings and diagrams shown illustrate the arrangement and installation for the equipment only. The information and suggestions have been prepared to assist you in obtaining the most satisfactory performance, and also to guide you in giving it the reasonable attention and care that any fine equipment deserves.
- 1.2 ADAMATIC recommends that the instruction and applicable safety precautions be fully understood by all personnel responsible for the Divider Rounder operation or maintenance.

WARNING!

Failure to follow the recommendations of this manual can result in potential hazards to personnel and property.



Part of AGA Bakery

GENERAL DESCRIPTION

- 2.1 The VDR Divider Rounder from ADAMATIC automatically portions dough to accurate scaling weights, rounds the dough into uniform shapes and moves the dough balls onto a conveyORIZED proofer.

<u>No. of Active Dividers</u>	<u>Output Range (Oz.)</u>
2 - Pocket	10 to 20 oz.
4 - Pocket	3 to 10 oz.
6 - Pocket	3 to 6 oz.

Variable speed control is adjustable from 25 to 50 RPM and has a digital readout.

2.2 Design features include:

- o No divider oil is required for any phase of operation.
- o Divider head slows down for accurate scaling
- o Rounding drum hesitates for drop into rounding drum
- o Covers and doors have electrical interlocks for safety
- o Optional seam control delivery belts are easy to adjust
- o Variable speed rounding and speed control

2.3 Durable commercial design includes:

- o Oversized sealed heavy duty bearings
- o Individual Wiring discharge belts
- o BISCC approved design
- o Simple weight adjustment
- o Easy to clean and maintain
- o Inner rounding drum has low-maintenance, sealed oil bath
- o UL listed electric controls

- 2.4 Hydraulic main piston drive assures accurate scaling and minimum dough punishment.



Part of AGA Bakery

- 2.5 Rounding drums with a range of insert diameters, selectable piston cross-section and easy length adjustment vary scaling weights.
- 2.6 Total stroke indicator with reset monitors batch production; digital rpm readout indicates cycle rate.
- 2.7 Dough feeder with motorized gate modulates infeed to hopper.
- 2.8 Flour duster with rate control and blanking inserts.
- 2.9 Controls combined with proofer when ordered with complete line.



Part of AGA Bakery

INSPECTION

- 3.1 Check the parts received with the shipping lists; report any shortages.
- 3.2 Immediately after unpacking the Divider Rounder, check for possible shipping damages. If this unit is found to be damaged after unpacking material, contact the carrier within 15 days of delivery.
- 3.3 Contact the Adamatic Service Department at (732) 544-8400.



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INSTALLATION

WARNING: Electrical and grounding connections must comply with applicable portions of the National Electrical Code and/or other local electrical codes.

WARNING: Disconnect electrical power supply at the fused disconnect switch and place a tag indicating that the circuit is being worked on.

- 4.1 Assure that the machine is level and stable in the final installed position.
- 4.2 Remove all covers and check for any obvious damage that may have occurred during transit. Report any concealed damage to the carrier within 15 days of delivery.
- 4.3 Wipe the working surfaces with a clean cloth to remove all traces of preservative which is applied by the manufacturer for protection during transit.
- 4.4 Turn the machine over by hand for one revolution to assure that all drives and mechanisms are free. This may be achieved by pulling in the appropriate direction on the main drive belt. Looking on the pulley end of motor shaft, rotate the pulley counterclockwise.
- 4.5 Before initial start-up, apply mineral oil to the main plunger, main plunger chamber, and divider pistons.
- 4.6 Prior to installation, test the electrical service to assure that it agrees with the specifications on the machine data plate.
- 4.7 Make electrical connections per the wiring diagram shipped inside the control box.
- 4.8 Installation by an ADAMATIC trained technician is recommended.
- 4.9 Check Hydraulic oil level if low fill tank up to sight glass.
- 5.0 Check oil levels in the gear box and inner rounding drum, if low, fill with appropriate oil.



Part of AGA Bakery

OPERATION

5.1 CAUTION: DO NOT REACH INTO RUNNING EQUIPMENT!

CAUTION: Guards, access doors and covers must be securely fastened before operating this equipment. Lock out power before removing guards, access doors and covers. Failure to follow these instructions may result in personal injury or property damage.

CAUTION: Contains moving parts. Keep clear. Disconnect power before servicing.

DANGER: Electrical Hazard. Authorized Personnel Only.

5.2 The Divider Rounder is equipped with interlock switches on the doors and covers which interrupt power to the machine when opened. Do not remove doors, covers or switches without disconnecting electrical power. If operation of the machine is required with safety covers removed, extreme caution must be observed.

5.3 ELECTRICAL CONTROLS

Stop (Red)
Proofer/Main Drive
Divider/Rounder

- Pull to Start. Push to Stop.
- Pull to Start. Push to Stop.
- Pull engages clutch to start divider and turns rounder motor on.
Push to Stop.

Chunker (Hopper Feed)
Manual Cycle (Black)
Proofer Timing (Black)

- Pull to Start. Push to Stop.
- Push and hold to cycle. Release to Stop.
- Push to pause Divider/Rounder; release to resume so product falls into proofer hoppers at the right moment in the cycle.



Part of AGA Bakery

INSTALLING THE ROUNDING DRUM

- 5.4 Turn the Main Power switch OFF. Open the access door. Press down on the release knob to release the moulding belt. Turn the release lever on the bearing support and rotate the bearing support out of the way. Loosen the handwheel by turning counterclockwise. Remove End Plate and Rounding Drum and replace with appropriate size. Retighten in reverse order: Handwheel, Bearing Support and Lever, and Moulding Belt Handle clockwise to tighten.



Part of AGA Bakery

ADJUSTMENTS

- 5.5 The Variable Speed Control adjusts the speed of the whole machine. Strokes Per Minute (rpm) is indicated by the digital readout on the control panel. Total Stroke indicator accumulates until reset.

The Weight Adjustment crank with dial indicator controls the piston stroke length and must be adjusted after scaling to maintain proper weights. Dial indicates approximate position for repeat production under similar conditions. Product must be weighted to verify pistons are filling consistently.

The Rounder Speed Control (on left side of the machine) may be adjusted as needed.

Flour Duster (also on the left side) may be adjusted as needed.

The Pressure Release Valve may be opened (turn ccw) to release hydraulic pressure when idling. Close valve (turn cw) when operating to pressurize hydraulic system.

- o Belt Height Adjustment (seam control).
- o Center Line Adjustment on discharge of finger belts (optional).



Part of AGA Bakery
CLEANING

- 5.6 It is the responsibility of the purchaser/operator to maintain the equipment in clean and good-working order. The machine should be cleaned, greased and oiled according to instruction daily or after each operation.

Before cleaning machine, make sure Main Power switch is **OFF**.

Cleaning should be done after each production run and may be required during the run.

Rounding Drum, Inner Rounding Drum Cover, Main Plunger and Divider Pistons must be disassembled and cleaned in a sink. Clean components using a cloth moistened in a solution of cold water and mild detergent.

Inner Rounding Drum Cover is removed after first removing the Rounding Drum. Loosen the Hand Wheel; remove end plate; and loosen two nuts with long arm wrench. Inner Rounding Drum Cover should pull loose. Reassemble in reverse order.

Main Plunger is removed by jogging to the correct position in the cycle. Then threaded hook device to pull the piston free with the threaded handle.

Scrape belts and blow-off with an air hose.

Make certain that all hard and glutinous deposits are completely removed to allow free action to the sliding components. When removing components from the machine, do not under any circumstances use undue force as serious distortion could result.

When reinstalling components, apply mineral oil to Main Plunger, Main Plunger Chamber and Divider Pistons.

**NEVER WASH DOWN MACHINE USING HOSE.
NEVER WASH PISTON & LINERS, PISTONS,
OR DRUMS IN HOT WATER.
IT IS RECOMMENDED TO SOAK THEM IN COOL WATER.**



Part of AGA Bakery

CHUNKER AUTOMATIC CONTROL SYSTEM OPERATING PROCEDURE

Suppose when the chunker automatic control system is being turned on, the dough is already loaded in the chunker.

To start the control system pull the special switch on the divider control panel. 5-CR relay energizes and closes two no contact, which is turn switch on chunker automatic control system. If at no time there is no dough in the hopper and the probe (sensor) is clean, NC contact touch switch is closed. Since the touch switch contact is closed, 2-TR time delay relay energizes and after certain time delay closes its contact in 503-507 circuit. (First time delay function), 6-CR relay energizes causing two of its NC contacts to close, which in 502-505 circuit turns on 1-TR time delay relay and in 506-504 circuit switch on chunker motor.

When chunker goes through one cycle, the limit switch 1-LS closes its NC contact in 502-504 circuit. After that 1-TR time delay relay opens its NC contact in 502-506 circuit (second time delay function).

At the end of the cycle 1-LS limit switch opens its NC contact in 502-504 circuit and stops motor.

For the next operation automatic control system waits for signal from the sensor, which means that the dough is in the hopper. At the same time, touch switch opens its NC contact and resets control system, however, the control system begins a new cycle just after the dough leaves the hopper, making the probe clean.

After the control system stops again, it waits for the reset signal from the probe and if no such signal is received after a certain period of time, it makes one more cycle, etc.

Chunker automatic control system would work similarly if the dough will be neither in the chunker nor in the hopper. The chunker automatic control system is protected from dough accidentally resetting the system more than one time during the cycle.



SAFETY TIPS

GENERAL SAFETY RULES

Please review the following safety procedures and practice them during your daily operation of equipment. Observe these general safety guidelines to secure a safer working environment for yourself and your fellow employees.

1. Equipment should not be operated with safety devices by-passed or guards removed.
2. Only qualified personnel should operate the machine.
3. Machines should not be started until all personnel are clear.
4. Service or maintenance procedures should never be performed on a machine in motion.
5. Most equipment requires a high voltage electrical system. To avoid shock or serious injury, only qualified personnel should perform maintenance on the electrical system.
6. All air, hydraulic and electric power must be OFF before servicing the machine.

OPERATING ZONE

An operating zone should be established around all machines. A brightly painted guard rail or warning stripe should define the zone. Only the operator or other authorized personnel should be within the operating zone when machine control circuits are energized or the machine is running.

No tools or other equipment should be kept within the operating zone.



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111 East Wacker Drive
Chicago, IL 60601
312/644-6610

Produced as part of BEMA's Safety Label Program.

ADAMATIC[®]

SAFETY PRECAUTIONS

The safety covers on the machine must remain in place during operation of the machine. Never disconnect safety switches on the machine. All power must be turned off prior to removal of safety covers for cleaning and maintenance.

Personnel operating the machine must be instructed by the purchaser in the proper cleaning, maintenance and safety procedures.

Failure to follow these instructions may result in personal injury or property damage.

NOTE: The following cautions are placed on the machine at the factory for the safety of operating personnel. Should any of these labels become missing or damaged, contact the ADAMATIC Service Department at (732) 544-8400 for replacements.

CAUTION: DO NOT REACH INTO RUNNING EQUIPMENT.

CAUTION: Guards, access doors and covers must be securely fastened before operating this equipment. Lock out power before removing guards, access doors and covers. Failure to follow these instructions may result in personal injury or property damage.

CAUTION: Contains moving parts. Keep clear. Disconnect power before servicing.

DANGER: ELECTRICAL HAZARD. AUTHORIZED PERSONNEL ONLY.



Part of AGA Bakery
MAINTENANCE

7.1 New Machine

- o After approximately 50 hours, check all nuts and screws for security. Any loose parts should be tightened.

7.2 Daily

- o Lubricate plungers and slides with edible oil.
- o Clean machine thoroughly after use.

- 7.3**
- o Lubricate all grease fittings with one shot from grease gun.
 - o Check timing of chain drive.
 - o Check oil level through site glass of hydraulic unit; add hydraulic oil if necessary.
 - o Lubricate all chain drives with SAE 30 motor oil or high quality machine oil. Sufficient access to the chains is available by removing machine side covers on drive side.

7.4 Monthly

- o The Rounding Drum Cover can be removed for cleaning. First remove the outer drum. Next unscrew the two hex nuts with long arm wrench and withdraw the Rounding Drum Cover. Never remove the core of the rounding drum; it has a sealed oil bath. Check oil level periodically and add oil if level is low.
- o Lubricate all grease fittings with one shot from grease gun.
- o Remove the main drive side cover and brush all chain drives with oil. Check the chain drives for correct tension and adjust the tensioner sprockets if necessary. Correct tension should allow flexing equal to 2% of the chain length between centers.
- o Lubricate with oil all pivot points and bushing bearings.
- o Grease Flour Duster connectors as required.
- o Check all nuts and bolts for tightness.



Part of AGA Bakery

Gearbox:

Note: See Component Tech Info (section 10) of this manual.

After the first 100 hours of operation, drain out initial oilflush out the gear case with an approved non-flammable, non-toxic solvent and refill. Thereafter, oil should be changed at least every 2500 operating hours or every 6 months - which ever occurs first. If unit is operating in extremely dirty or high/low temperature environments, change oil more often.

7.5 Hydraulic Unit

Recommended hydraulic fluid is Raylene O available through the Adamatic Service Department.

NOTE: Do not use edible oil or hydraulic brake fluid. Failure to use recommended oils or hydraulic voids warranty.

7.6 Troubleshooting

The following is a suggested list of procedures to assist bakery personnel in quickly solving common problems with the Adamatic VDR Divider Rounder. If, after attempting to remedy any given fault unsatisfactorily, contact the factory for assistance or recommendations at (732) 544-8400.



Part of AGA Bakery

FAULT	PROBABLE CAUSE	REMEDY
Hydraulic hose does not operate, or will not reach full pressure, and is not filling the measuring pockets at maximum pressure adjustments	- Bypass valve not tightened. - Leaking check valve - Leaking regulator not working - Low on oil	- Tighten - Dismantle, clean or replace - Dismantle, clean or replace - Check oil level
Hydraulic unit becomes soled and will not collapse	Pressure regulator is sticking	Dismantle and clean, or replace if necessary
Machine drive slips	- Clutch not operating properly - Inspect coupling on main shaft - Main Belt worn	- Dismantle and inspect - Replace - Replace
Hydraulic unit leaks through main seal	Worn or damaged seal	Replace seal
Motor stops	Electrical overload cut	Check machine on overloading and mechanical binding, reset.
Machine labors under load	Binding of main piston and/or measuring pistons and rounding head	Clean main piston, measuring pistons, and rounding head.
Uneven weight	Improper amount of dough in the dough feeder (chunker)	Check dough feeder operation and readjust dough level. NOTE: See if there is dough bridging in main Hopper
Machine will not start	Electrical circuit is not closed.	Check fuses, check limit switches in door and covers.



Part of AGA Bakery

FAULT	PROBABLE CAUSE	REMEDY
Dough "strings" from rotary dividing head.	- Lock screw of liner is not fastened. - Excessive wear between round head and hopper surface - Measuring piston does not fully come flush.	- Tighten correctly or re-adjust for clearance. - Make sure clearance between hopper and back block is .002".
Clutch makes excessive noises.	Uneven wear of friction surface.	Consult factory.
Uneven weights	- See under hydraulic unit - Machine requires cleaning - Out of time	- See under hydraulic unit - Stop machine and clean - Check Timing
Rounding section is not working	- Belt - Variable Speed Motor - Internal Problem	- Replace, re-adjust V-belt - Inspect electrical connections - Consult factory



Part of AGA Bakery

TROUBLE-SHOOTING GUIDE

LOW OR NO HYDRAULIC PRESSURE

- o Bypass valve not tightened.
- o Check valve not tightened.
- o Check valve may be leaking.
- o Low on hydraulic oil.
- o Leaking regulator, not working.

HYDRAULIC CYLINDER WILL NOT COMPRESS

- o Pressure regulator may be sticking. Dismantle and clean or replace.
- o Check hydraulic cylinder for damage. Repair or replace cylinder.

NOTE: If pressure regulator was filled with debris, change hydraulic oil.

MACHINE DRIVE SLIPS

- o Clutch not operating properly. Dismantle and inspect.
- o Replace clutch if necessary.
- o Inspect coupling on main shaft. Replace if necessary.
- o Main belt may be worn. Replace if necessary.

HYDRAULIC FLUID LEAKS

- o Find source of leak and repair.

NOTE: Dyes are available to add to the hydraulic oil to help spot leaks.

MOTOR STOPS

- o Check all doors and covers to make sure they are properly closed.
- o Check motor overloads in main panel. Reset and try again.
- o If motor is controlled by a frequency drive, check drive error codes.

MACHINE LABORS UNDER LOAD

- o Main ram and/or scaling pistons may be dirty. Remove and clean.
- o Outer rounding drum may not be installed properly. Inspect and re- install if needed.
- o If frequency drive unit is used, check torque settings. Adjust if necessary.
- o Check hydraulic pressure. Excessive pressure can cause the machine to labor.

NOTE: Regular scheduled cleanings are essential to proper machine operation.

A dirty main ram or scaling pistons can cause damage and excessive stress to the machine.



Part of AGA Bakery

POOR OR UNEVEN WEIGHTS

- o Check hopper for proper level of dough. Adjust sensor or photo eye as necessary.
- o Make sure all scaling pistons are clean and free moving.
- o Check for proper hydraulic pressure. Adjust as needed.
- o Make sure dough is proper temperature and consistency.
- o Check for bridging or sticking of dough in hopper. Clean and oil hopper.
- o Check for binding of main ram. Remove and clean ram and cavity if needed.
- o Check timing of main ram to piston liner.

NOTE: Periodic and regular cleaning of the pistons, ram, and ram cavity are essential to maintain good weights.

DAILY PREVENTIVE MAINTENANCE

- o Lubricate scaling pistons, ram, and ram cavity with edible oil.
- o Lubricate mechanical variable speed drive if used.
- o Clean machine thoroughly after use.

SOAK PISTON & LINERS, PISTONS, AND DRUMS IN COOL WATER, NOT HOT WATER, TO PREVENT WARPING.

- o Inspect belts for wear.

NOTE: If machine is used more than one shift per day, the above should be done at the end of each shift.

WEEKLY PREVENTIVE MAINTENANCE

- o Lubricate all grease fittings with one shot of grease.
- o Check timing of chain drive. (Refer to adjustment section)
- o Check hydraulic oil level through sight glass. Add if level is low.
- o Lubricate all chain drives with SAE 30 motor oil or high quality machine oil. Sufficient access to the chains is available by removing machine side covers on drive side.
- o Check rod end bearings on ram, hydraulic cylinder, and piston liner tie rod.
- o If mechanical variable speed pulley is used, run machine and adjust through speed range to keep unit free.



Part of AGA Bakery

MONTHLY PREVENTIVE MAINTENANCE

- o The Rounding Drum Cover can be removed for cleaning. First remove the outer drum. Then unscrew the two hex nuts with a long wrench and withdraw the Rounding Drum Cover. Never remove the core of the rounding drum, it has a sealed oil bath. Check oil level periodically and add oil if level is low.
- o Lubricate all grease fittings with one shot from grease gun.
- o Remove the main drive side cover and brush all chain drives with oil. Check the chain drives for correct tension, and adjust the tensioned sprockets if necessary. Correct tension should allow flexing equal to 2% of the chain length between centers.
- o Grease Flour Duster connectors if used.
- o Lubricate with oil all pivot points and busing bearings.
- o Check all nuts and bolts for tightness.
- o Clean shafts on main gearbox to prevent dirt from wearing out seals. Check oil level and make sure vent hole is not plugged. Check for leaks and play in shafts. Check and tighten coupling or sprocket setscrews.

LUBRICANTS

- o CHAINS - Lubricate chains with SAE 30 motor oil or high quality machine oil.
- o RAM & SCALING PISTONS - Use food grade mineral oil for all food contact surfaces.
- o HYDRAULIC SYSTEM - Use NON TOX hydraulic oil available from ADAMATIC.
- o DRIVE GEAR MOTOR - 140 W Gear Oil.
- o VARIABLE SPEED PULLEY - Lubriplate No 1200-2 or equivalent.
- o MAIN DRIVE GEARBOX - High quality 140 W Gear Oil.
- o GREASABLE BEARINGS/BUSHINGS - Refer to bearing manufacturer specifications.
- o ROUNDING DRUM OIL BATH - Use 90 W NON TOX gear oil.
- o CHUNKER GEAR MOTOR - 90 W gear oil;

MACHINE WILL NOT START

- o Make sure all doors and covers are closed properly.
- o Check main power source or breaker.
- o Check motor overloads in main panel.
- o If frequency drive is used, check for error codes.
- o If breakers or overloads trip on start-up, check for mechanical binding.



Part of AGA Bakery

DOUGH STRINGS FROM DIVIDING HEAD

- o Lock screws on piston liner not tight. Retighten screws.
- o Excessive wear between piston liner head and hopper surface.
- o Measuring pistons do not come flush with piston liner.

CLUTCH MAKES EXCESSIVE NOISE

- o Uneven wear of friction surfaces. Consult ADAMATIC.
- o Check for clutch tightness on shaft.
- o Check for proper voltage output to clutch.

ROUNDING SECTION IS NOT WORKING

- o Check rounding drive belt. Tension or replace as needed.
- o Machine needs cleaning. Excessive dough build-up can load the rounding unit.
- o Variable speed motor may have failed or drive may be defective.
- o Check motor overloads for rounding drive motor.
- o Internal problems. Check electrical connections and conditions. Consult ADAMATIC.

MACHINE PRODUCES EXCESSIVE FLATS

- o Rounding speed may be too high which can throw the dough portions from the rounding drum holes.
- o If flour duster is used, reduce the amount of flour deposited.
- o Check for proper alignment of outer rounding drum. Adjust as needed.

VDR

PREVENTATIVE MAINTENANCE

DAILY

1. LUBRICATE PLUNGERS AND SLIDES WITH EDIBLE OIL.
2. CLEAN MACHINE THOROUGHLY AFTER USE. (REMOVE MAIN PISTON, SCALING PISTONS, OUTER ROUNDING DRUM AND INNER ROUNDING DRUM.)

WARNING!

IF MACHINE IS STOPPED FOR MORE THAN 5 MINUTES, SPRAY EDIBLE OIL IN THE MAIN HOPPER AND SCALING PISTON AREA. TO PREVENT FREEZE UP DUE TO DRY DOUGH AND LET MACHINE RUN WITHOUT PRODUCTS FOR 3 MINUTES TO SPREAD OIL.

WEEKLY

1. CHECK ALL SAFETY SWITCHES AND INTERLOCKS FOR PROPER FUNCTION.
2. CHECK TIMING OF CHAIN DRIVE, AS PER TIMING CHART.
3. CHECK OIL LEVEL THROUGH SITE GLASS OF HYDRAULIC UNIT; ADD HYDRAULIC OIL IF NECESSARY.
4. LUBRICATE ALL CHAIN DRIVES WITH SAE#30 MOTOR OIL OR HIGH QUALITY MACHINE OIL. SUFFICIENT ACCESS TO THE CHAINS IS AVAILABLE BY REMOVING MACHINE SIDE COVERS ON DRIVE SIDE.

VDR

PREVENTATIVE MAINTENANCE

MONTHLY

1. REMOVE MAIN DRIVE SIDE COVER AND BRUSH ALL CHAIN DRIVES WITH OIL. CHECK THE CHAIN DRIVES FOR CORRECT TENSION AND ADJUST THE TENSIONER SPROCKETS IF NECESSARY. CORRECT TENSION SHOULD ALLOW FLEXING EQUAL TO 2% OF CHAIN LENGTH BETWEEN CENTERS.
2. CHECK AIR SYSTEM (F.R.L.)
3. LUBRICATE WITH OIL ALL PIVOT POINTS AND BRUSHING BEARINGS.
4. CHECK ALL NUTS AND BOLTS FOR TIGHTNESS.
5. CHECK BELT TENSION, ADJUST IF NEEDED.
6. CHANGE OIL IN BOTH GEAR BOXES.
7. CHECK OIL LEVEL IN ROUNDING DRUM.

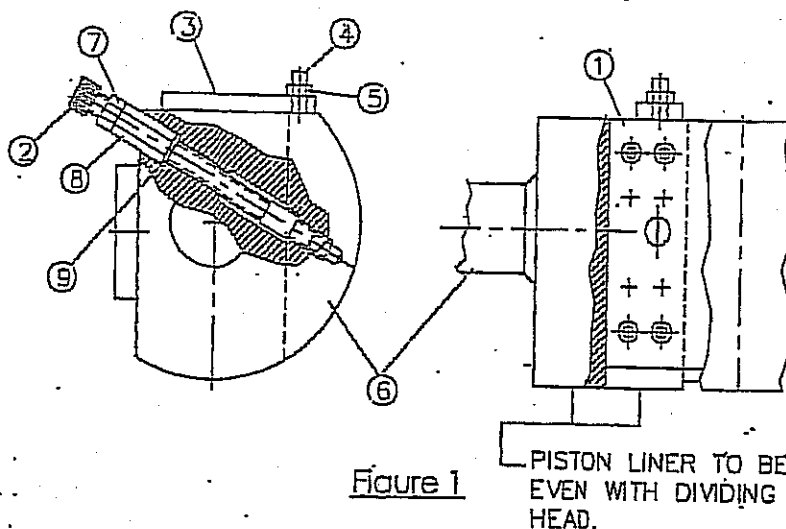
NOTE: NEVER REMOVE CORE OF ROUNDING DRUM; IT HAS A SEALED OIL BATH AND REQUIRES NO PERIODIC MAINTENANCE.

WARNING! ALWAYS REPLACE SAFETY GUARDS AND COVERS AND SECURE BEFORE OPERATING EQUIPMENT!

ADAMATIC SMART BOLTS - ADJUSTMENT PROCEDURE

Adamatic Smart Bolts are designed to facilitate even torquing of piston/liner mounting bolts. They eliminate the unknown element of operator strength in tightening the bolts and prevent the distortion of the piston liner due to over/under tightening.

When the piston/liner is shipped with a new machine, the Smart Bolts are preset at the factory and should not require adjustments under normal circumstances. The following refers to the method of installing and adjusting Smart Bolts when replacement is necessary.



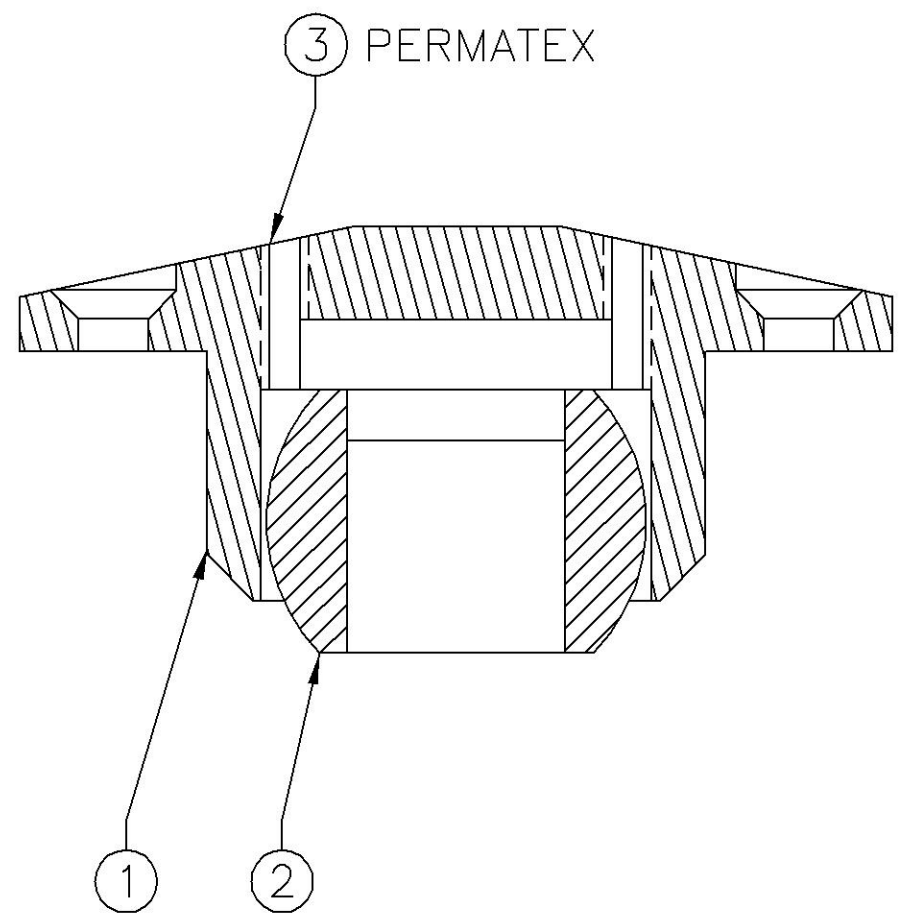
Insert the Smart Bolts into the holes in the piston liner. Gentle tapping with a rubber mallet may be required to fully insert the bolts.

a) Setting the liner in dividing head:

Place the dividing head in a vertical position by either jogging the main drive (NDR) or by placing the machine in the cleaning position (VDR).

WARNING: BEFORE PROCEEDING FURTHER, TURN OFF POWER AT MAIN DISCONNECT AND LOCKOUT ELECTRICAL PANEL.

- 1) Insert the liner (Item 1) into the dividing head cavity gently (Item 6). Do not drop the liner into the cavity, otherwise damage to the tabs and/or liner may occur.
- 2) Unlock the locking nut (Item 5) on all the tabs and adjust allen screw (Item #4) such that the radiused bottom of



S:\ACADDWGS\NDR

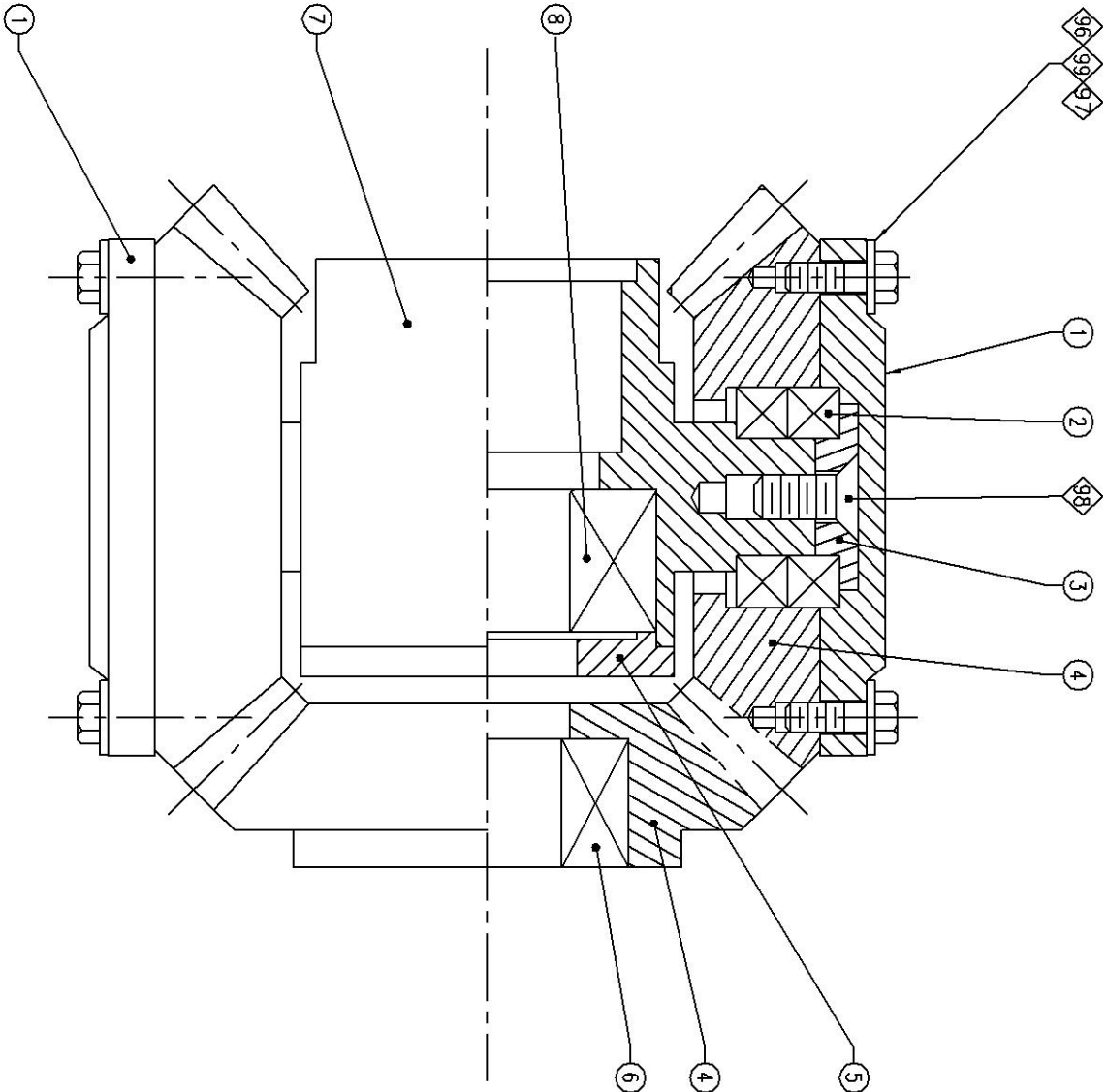
03	617296		SCREW, SET 10-32 x 0.500" LG.	2
02	614745		SPERICAL BEARING - SPHERCO COM 14, MORSE	1
01	B 610406-02		HOUSING, BEARING	1
POS.	PART NO.	R/M NO.	DESCRIPTION	QTY.

BILL OF MATERIALS

MACHINING TOLERANCES			SCALE	FULL	VDR, NDR	
FRACTIONAL:	X/X	±1/64"	DSN BY	JME	BEARING HOUSING ASSEMBLY	
DECIMAL:	X.X	±0.025"	DWN BY	JME		
	X.XX	±0.015"	DATE	3/13/92		
	X.XXX	±0.005"	CHK			
ANGULAR:	X°	±0.5°			ADAMATIC 607 INDUSTRIAL WAY WEST, EATONTOWN, NJ 07724	
BREAK SHARP CORNERS						
REMOVE ALL BURRS						
MACHINED SURFACES 63 RMS						
RL	DATE				SHEET SIZE A	DRAWING NO. 610535-01
						SHEET: 1/1

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99	615027		WASHER, FLAT 0.250 ZP	08
98	612909		SCREW, RH HXSQC 3/8-16 x 0.875" FULL THD.	02
97	610000		SCREW HAND 1/4-20" x 0.750" LG	08
96	614880		WASHER LOCK 0.250" ID ZP	08



MFG COPY

CUSTOMER: GEN MILLS CANADA

PURCH ORDER NO: _____

SHOP ORDER NO.: M# _____

EDP ORDER NO.: M# 992100

EQUIP. USED ON: _____

QUANTITY: _____

DATE RELEASED: 3/2/06

MAKE _____ BUY _____

S:\ACADD\WCS\NDR\...

08	690735		BALL BEARING #9207-SBK ZZ	01
07	610406-01		AXEL, STUB HOUSING	01
06	614128		LOCK RING RFN 7012-IN 1.25 BORE, RINGFEEDER	01
05	610251-02		END CAP	01
04	691382		GEAR, BEVEL ASSEMBLY (3 IN SET)	01
03	612659		DISC CLAMP	02
02	612915		BALL BEARING #9005 2RS	04
01	792268		CRANK PLATE MOLDING UNIT LONG STROKE	02
POS.	PART NO.	R/M NO.	DESCRIPTION	QTY.

BILL OF MATERIALS			VDR, NDR	
SCALE	FULL			
DSN BY	JME			
DMN BY	JME			
DATE	3/3/92			
CHK				

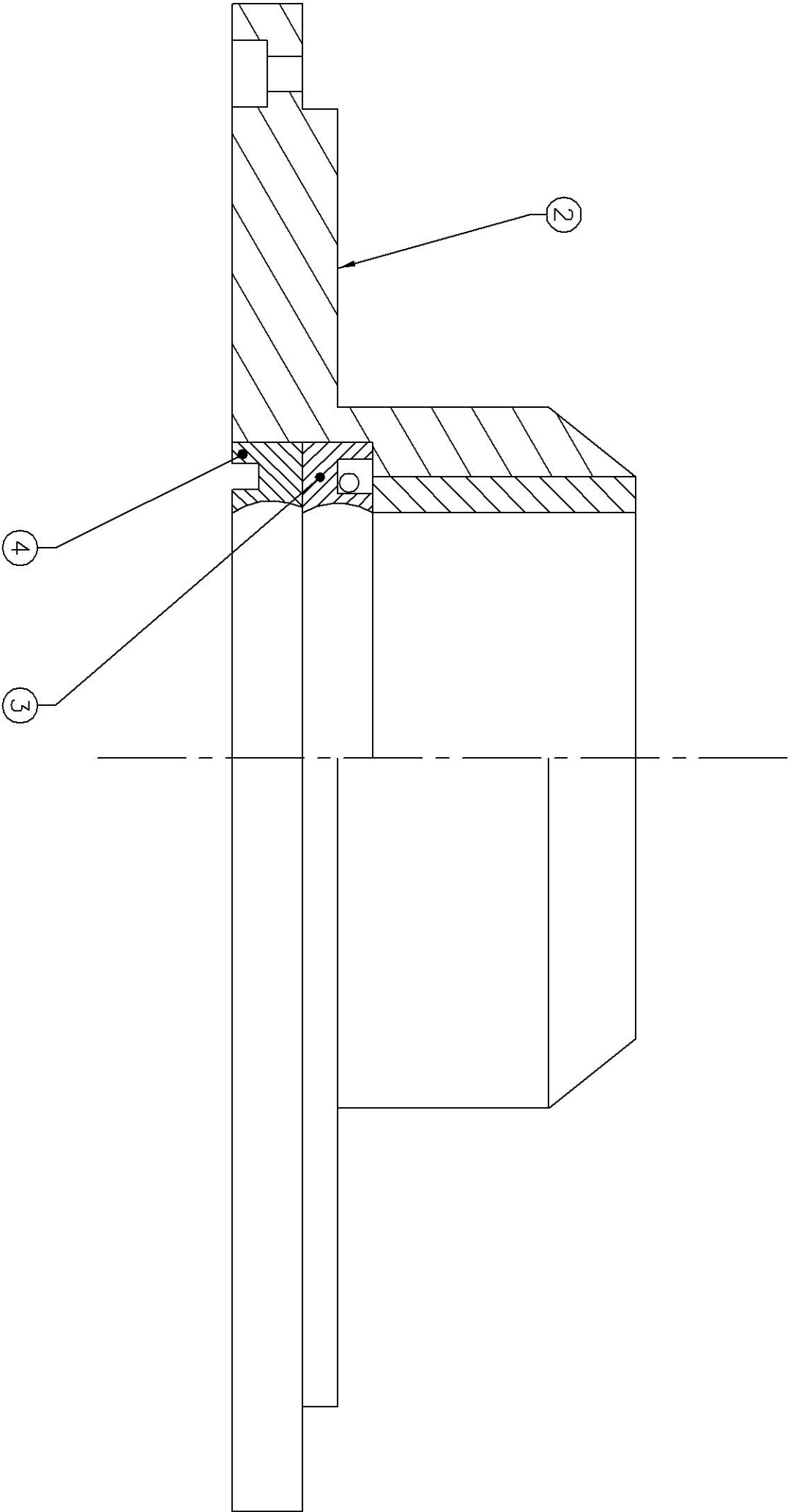
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◇ = **HARDWARE**
○ = **PARTS**

MACHINING TOLERANCES			
FRACTIONAL:	X/X	±1/64"	
DECIMAL:	X.X	±0.025"	
	X.XX	±0.015"	
	X.XXX	±0.005"	
ANGULAR:	X°	±0.5°	
BREAK SHARP CORNERS			
REMOVE ALL BURRS			
MACHINED SURFACES 63 RMS			
RL	DATE		
A	12/3/99		

607 INDUSTRIAL WAY WEST, EATONTOWN, NJ 07724		SHEET 92E	DRAWING NO. 61053502
ADAMATIC		C	SHEET: 1/1

AXEL STUB HOUSING
ASSEMBLY LONG STROKE



04	690973		SEAL, OIL 0350 17323	01
03	690731		OIL SEAL J.M.CLIPPER #0350-12565 LDS	01
02	610378-02		HOUSING, BEARING, INNER	01
01				
POS.	PART NO.	R/M NO.	DESCRIPTION	QTY.

BILL OF MATERIALS

		SCALE	FULL	VDR, NDR
--	--	-------	------	----------

MACHINING TOLERANCES
FRACTIONAL: X/X ±1/64"
DECIMAL: X.X ±0.025"

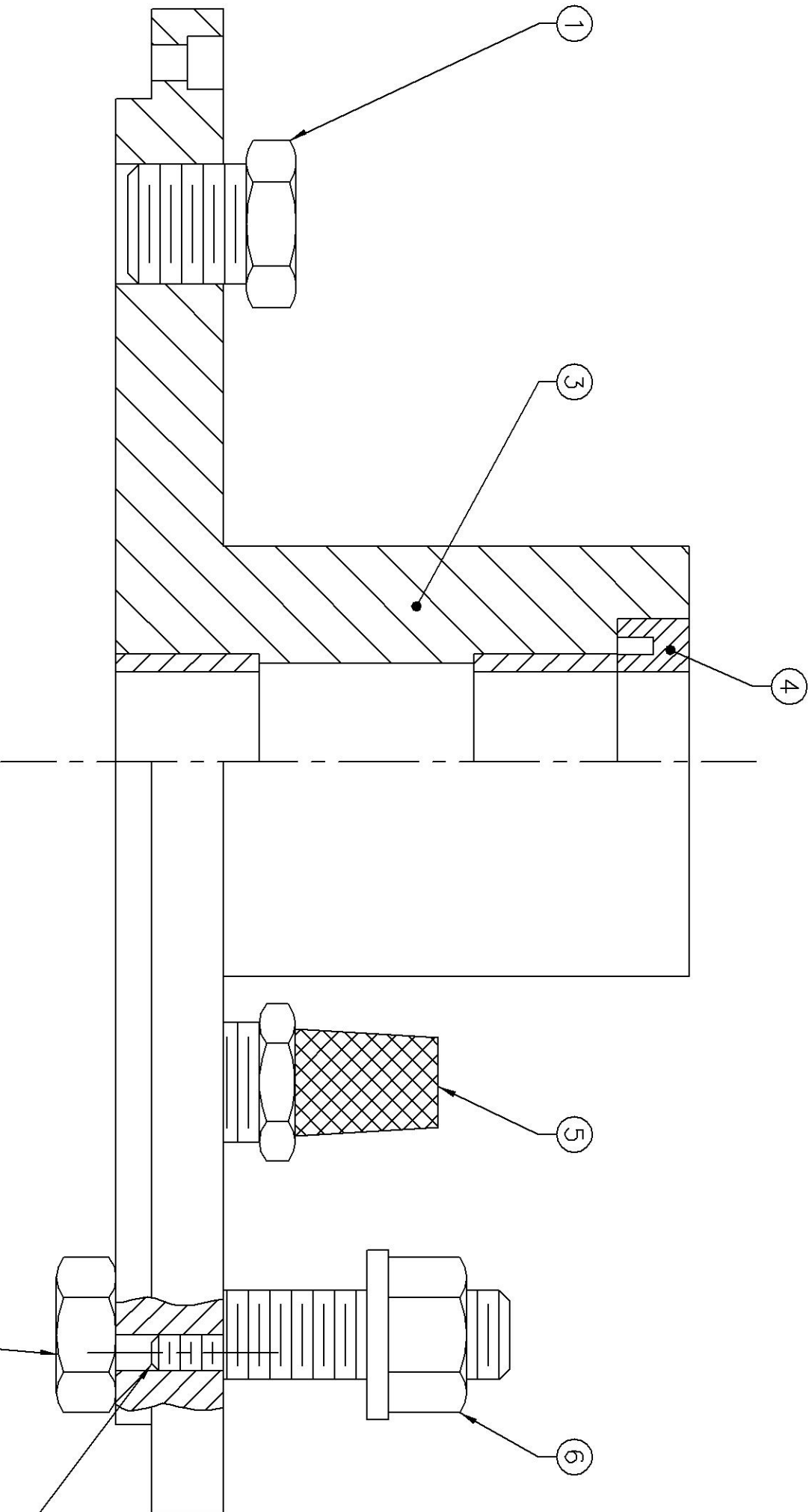
ANGULAR: X° ±0.5°
BREAK SHARP CORNERS
REMOVE ALL BURRS

MACHINED SURFACES 6.3 RMS

RL	DATE	607 INDUSTRIAL WAY WEST, EATONTOWN, NJ 07724	SHEET SIZE B	DRAWING NO. 610535-03
----	------	--	-----------------	--------------------------

S:\ACAD\DWGS\NDR

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MFG COPY

CUSTOMER: GEN MILLS OK.

PURCH ORDER NO:

SHOP ORDER NO.: M#

EDP ORDER NO.: M# 992100

EQUIP. USED ON:

QUANTITY: 1

DATE RELEASED: 6/5/06

MAKE _____ BUY _____

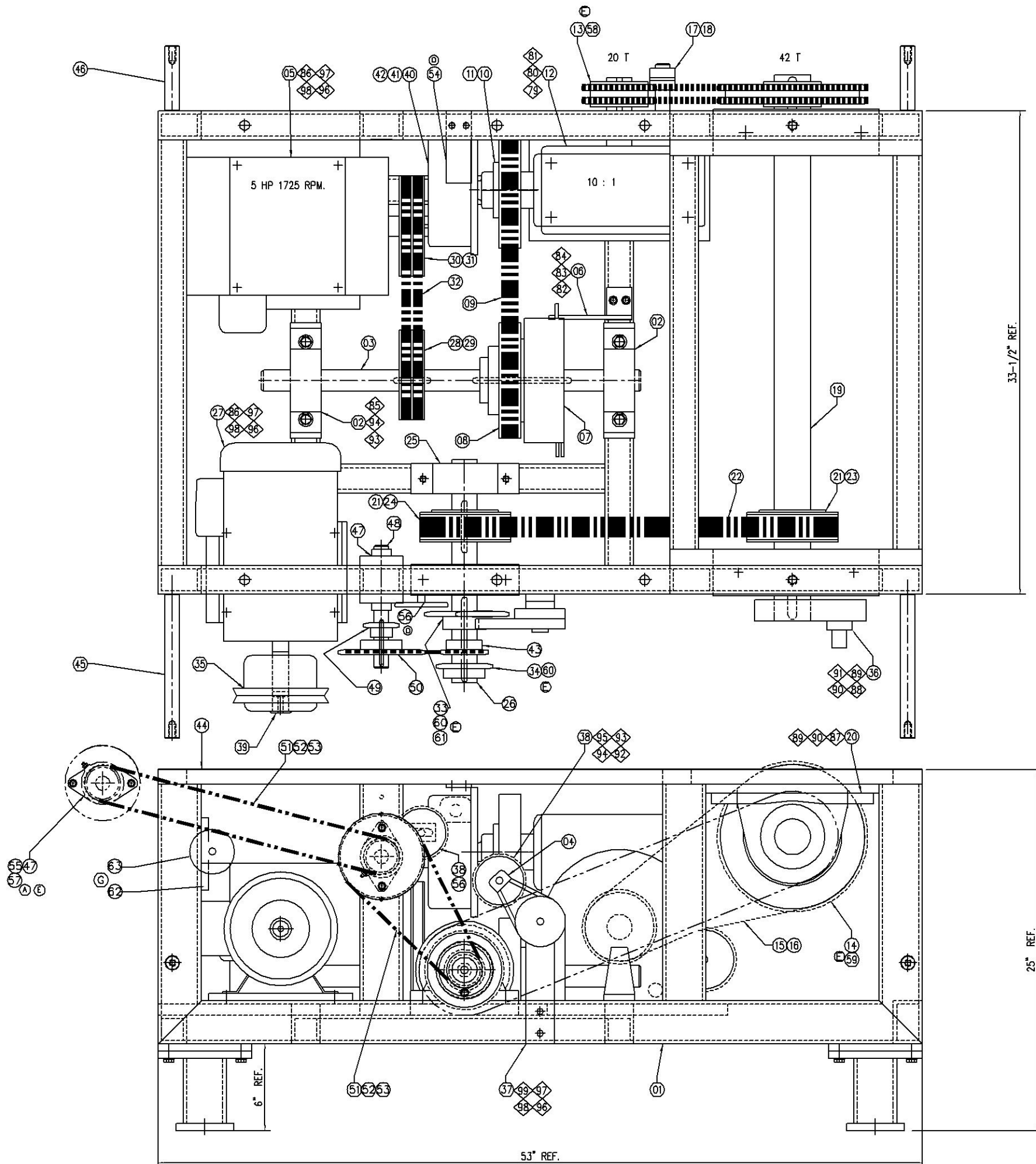
10	691075	SCREW HX HD 5/8-11 x 3" GR5 ZP	02
09		PERMATEX NO. 2 SEALANT	AR
08	684743	SCREW, SET HXSOC 1/4-20 x 0.500 CP	01
07			
06	617275	NUT FLAT FLANGE 5/8-11 GR5 ZP	02
05	684558	BREATHER 1/2" NPT MUFTLER AIR P04	01
04	690730	OIL SEAL J.M.CLIPPER 0125-14904 LDS	01
03	C 61037801	HOUSING, BEARING, OUTER	01
01	691493	PLUG, HXHD 1/2" NPT BRASS	01
POS.	PART NO.	R/M NO. DESCRIPTION	QTY.

BILL OF MATERIALS

MACHINING TOLERANCES				VDR, NDR				
FRACTIONAL:	X/X	±1/64"		SCALE	FULL	OUTER BEARING HOUSING ASSEMBLY		
DECIMAL:	X.X	±0.025"		DSN BY	JME			
	X.XX	±0.015"		DWN BY	T.D.			
	X.XXX	±0.005"		DATE	3/13/92			
				CHK				
ANGULAR:	X°	±0.5°		ADAMATIC				
BREAK SHARP CORNERS								
REMOVE ALL BURRS								
MACHINED SURFACES 63 RMS								
RL	DATE	607 INDUSTRIAL WAY WEST, EATONTOWN, NJ 07724						
				B		SHEET SIZE	DRAWING NO.	
						610535-04		
						SHEET: 1/1		

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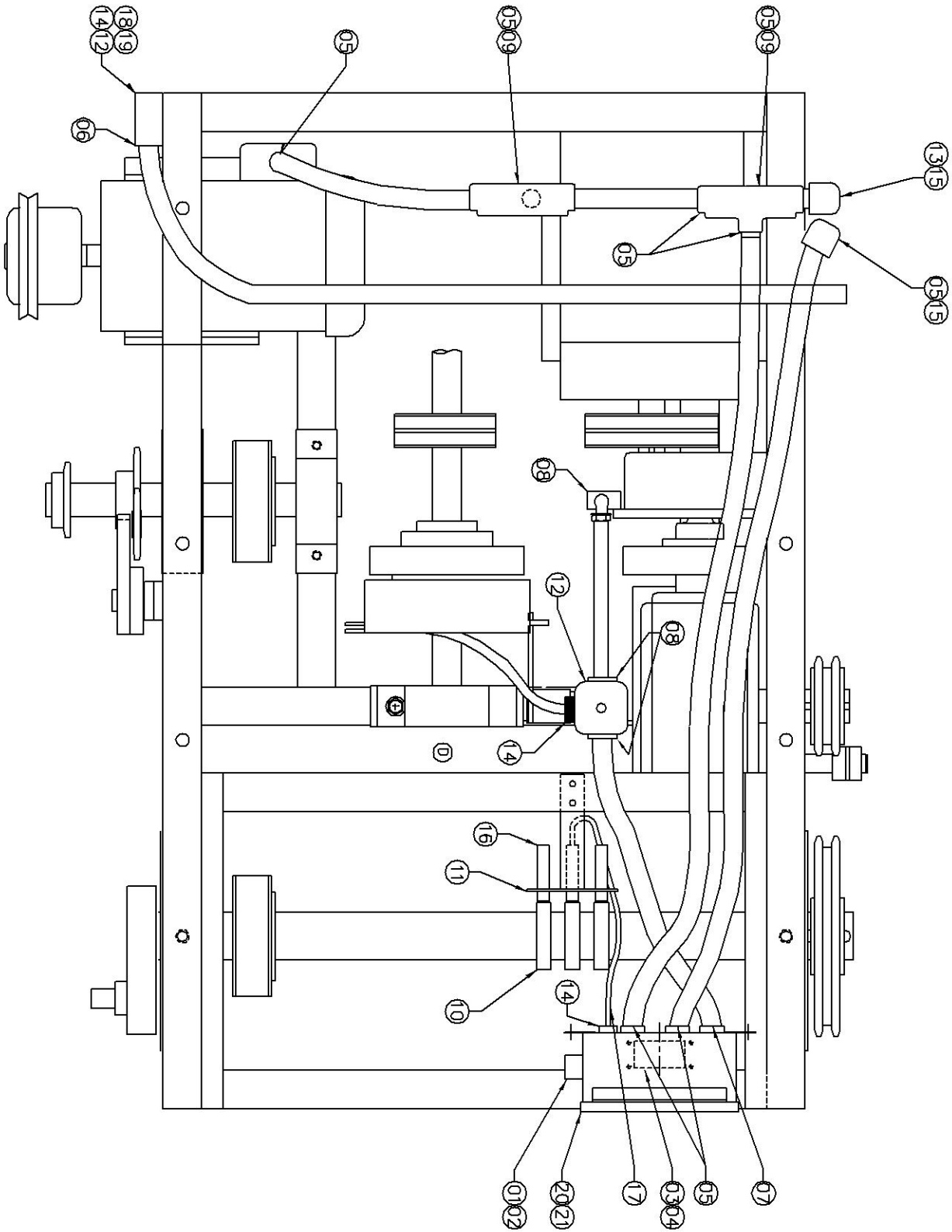
S:\ACAD\DWGS\NDR



S:\ACADDWGS\VDR\79207801

◇ = HARDWARE
○ = PARTS

MACHINING TOLERANCES		H 9/28/00		SCALE 1:4		BILL OF MATERIALS		VDR	
FRACTIONAL:	X/X ±1/64"	G 7/20/00	DSN BY	T. WIK	BASE DRIVE ASSEMBLY CONSTANT SPEED				
DECIMAL:	X.X ±0.025"	F 2-8-00	DWN BY	T. DEVITO					
	X.XX ±0.015"	E 8-20-99	DATE	4/31/95					
	X.XXX ±0.005"	D 8/17/98	CHK	WK					
ANGULAR:	X° ±0.5°	C 7/15/96			ADAMATIC				
BREAK SHARP CORNERS		B 2/29/96							
REMOVE ALL BURRS		A 9/21/95							
MACHINED SURFACES 63 RMS		RL DATE							
						SHEET NO.		DRAWING NO.	
						D		79207801	
								SHEET: 1/1	



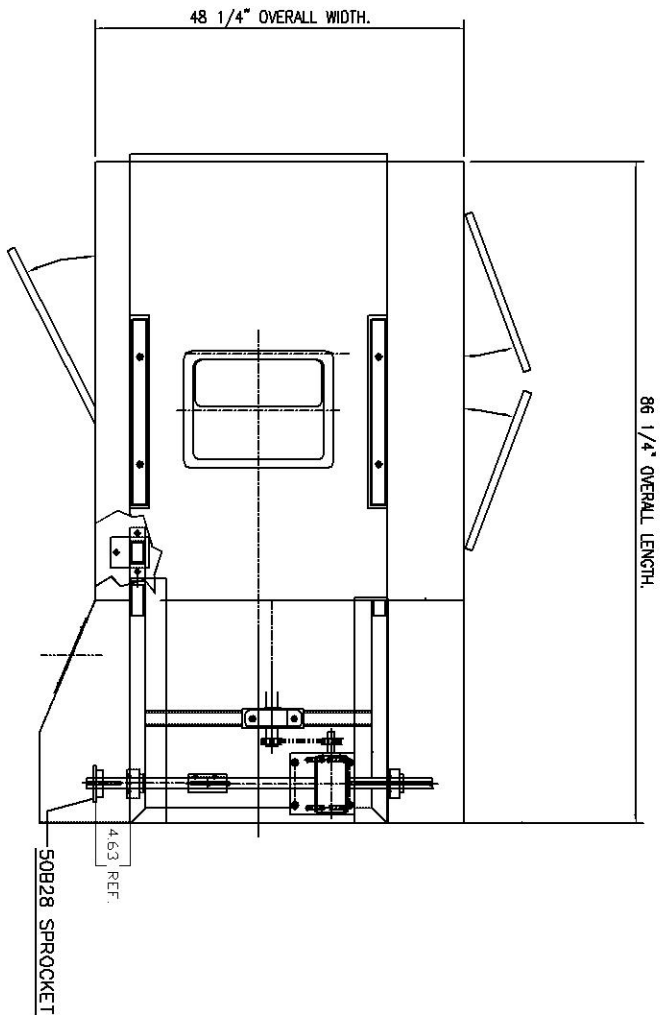
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USED FOR ANY OTHER PROJECT
WITHOUT THE WRITTEN PERMISSION
OF ADAMATIC, AN MCA COMPANY.

MACHINING TOLERANCES				SCALE				ELECTRICAL ASSEMBLY			
FRAC/DECIMAL	N/X	E/64"		OSN BY	N	SP/ENCE		VDR			
	X.X	±0.025"		DATE	T	DE/UTO		SHEET 3/2			
	X.XXX	±0.015"						DRAWING NO. 79207802			
	X.XXX	±0.005"		D	10/4/99			SHEET 1/1			
ANGLER:	X"	±0.5°		C	8/18/99						
BREAK SHARP CORNERS				B	4/16/97						
REMOVE ALL BURRS				A	7/12/96						
MACHINED SURFACES 63 RMS				FILE	DATE						
607 INDUSTRIAL WAY WEST, EASTON TOWN, NJ 07724											

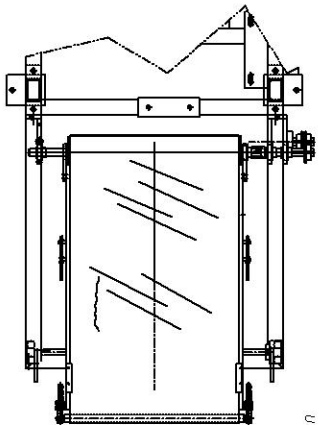
POS.	PART NO.	E/AI NO.	DESCRIPTION	QTY.
23				
22	690865		HOLE PLUGS	02
21	C 794435		ELECTRICAL BOX (REWORK P/N 692016)	01
19	688085		CONNECTOR CORD	01
18	616174		CONNECTOR LQ TIGHT STRAIGHT	01
17	793585		CABLE CONNECTOR 2 W/TER	01
16	793408		SENSOR PROXIMITY SHIELDED	01
15	616911		ELBOW CND PL 3/4"	02
14	660251		CONNECTOR CORD STR. 187--250	03
13	616318		BUSHING REDUCING 3/4" TO 1/2"	01
12	555154		BOX JUNCTION STRONG 143	02
11	B 793943		SENSOR BRACKET FOR	01
10	B 793944		CAM SWITCH FOR	02
09	793253		CONDUIT BODY 3/4" TYPE 1	02
08	616375		CONNECTOR LQ TIGHT 90 DEGR 3/8" x 1/4" MUB	03
07	669595		CONNECTOR LQ TIGHT 45 DEGR 3/8"	01
06	613248		CONNECTOR LQ TIGHT 90 1/2"	01
05	613497		CONNECTOR LQ TIGHT STR 3/4"	10
04	616917		BASE PNL MTC W/COVER H-B1040	01
03	616926		CONNECTOR PLUG H-B105 W/SCREW	01
02	694403		BASE MTC PANEL W/DRL LOCKING LEVER	01
01			CONNECTOR PLUG H-B246 # 101960	01

S:\ACAD\DWGS\VDR\79207802

DRIVE SIDE



VIEW AT "A"
PROOFER DRIVE SECTION



MACHINE ASSEMBLY AND OPTIONS

MAIN DRIVE ASSEMBLY

	79207801	BASE DRIVE ASSEMBLY CONSTANT SPEED
	79207802	ELECTRICAL ASSEMBLY BASE DRIVE
	793438	INNER DRIVE OPERATORS SIDE
	793437	OUTER DRIVE ASSEMBLY
	793436	INNER DRIVE ASSEMBLY
	793439	OUTER DRIVE OPERATORS SIDE
	793717	HYDRAULIC ASSEMBLY
	797081	COVER ASSEMBLY SS
	79343901	ELECTRICAL ASSEMBLY OPERATORS SIDE
	79343701	ELECTRICAL ASSEMBLY DRIVE SIDE
	79680601	SHOCK ABSORBERS ASSY
	796810	ANGLE SUPPORT

PROOFER DRIVE

	79354407M27	PROOFER DRIVE ASSEMBLY (MARKED PRINT)

FLATTENING ROLLER

	79501710	FLATTENING ROLLER ASSEMBLY (TOP DRIVE)
--	----------	--

CONVEYORS ASSEMBLY

	79577001M27	CONVEYOR ASSEMBLY REMOVABLE FLAT BELT SPECIAL (MARKED PRINT)
REF.	(79573207M27)	CONVEYOR #2 ASSEMBLY W/TAKE UP, REMOVABLE

SPECIAL ITEMS

3 PCS	79661403	SMART BOLT ASSY 6"
9 PCS	79661403	SMART BOLT ASSY 6"
2 PCS	794227	RAL DOUGH FILLER SECTION(USED WHEN CHAIKNER IS NOT SUPPLIED)

PISTONS

	79240050	6 PKT, 2 X 1 3/4" PISTON Ø 3-1/8" C TO C
*	79240004	2 PKT 5" x 2" PISTON Ø 8.75" C TO C
*	79240003	4 PKT, 2" x 2.5" PISTON Ø 4.25" C TO C
*	79240023	6 PKT 1 3/4" DIA ROUND PISTON Ø 3-1/8" C TO C

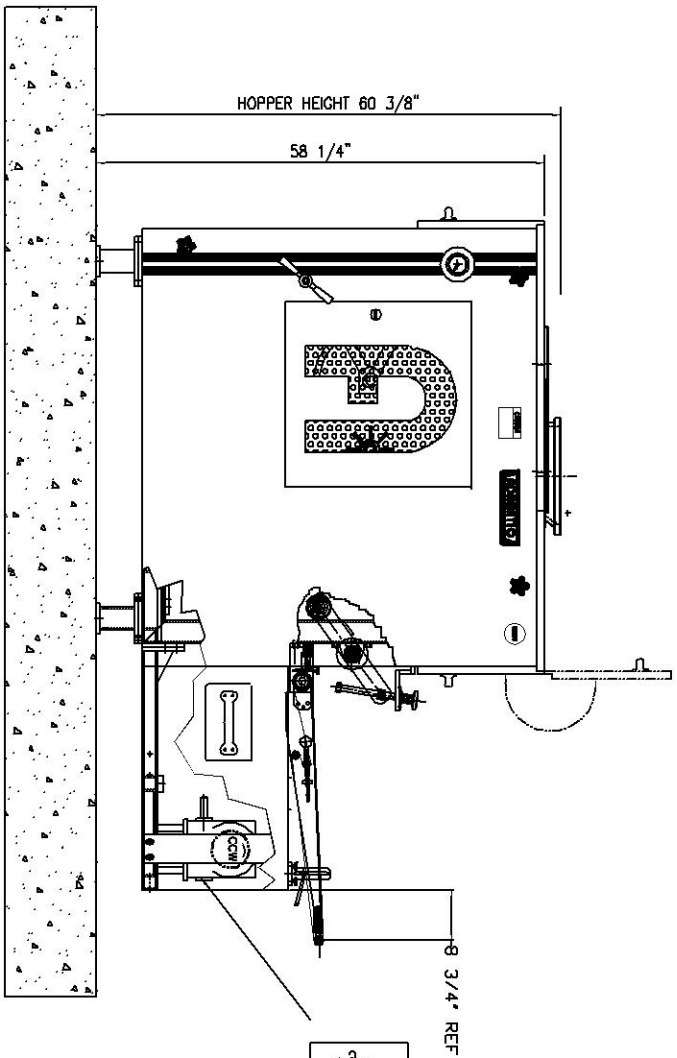
SOLID DRUM.

	79254931	6 PKT, SOLID DRUM W/SLOTTED HOLES x 1 1/2" THK. x 3 1/8" C TO C
*	79254910	6 PKT, SOLID DRUM W/ 2 3/4" HOLES x 1" THK. x 3 1/8" C TO C
*	79254938	6 PKT, SOLID DRUM W/ 2 3/4" HOLES x 1 1/8" THK. x 3 1/8" C TO C
*	79254922	4 PKT, SOLID DRUM W/ 3 3/8" HOLES x 1 1/2" THK. x 4 1/4" C TO C
*	79254904	2 PKT, SOLID DRUM W/SLOTTED HOLES 7"x3.5" SLOT ON O.D. 6"x3" SLOT ON I.D. x 1 1/2" THK x 8 3/4" C TO C

VOLTAGE

	7981101R	ELECTRICAL PANEL 208-220V / 60Hz. / 3ph. -SEE DWG 7981101R, R05
	794377	SUPPORT BRACKET FOR ELECTRICAL PANEL

* THESE PISTONS , DRUMS AND SMARTS BOLTS ORDERED ON A SEPARATE P.O. 313170 NOT INCLUDED ON BOM FOR 79225118

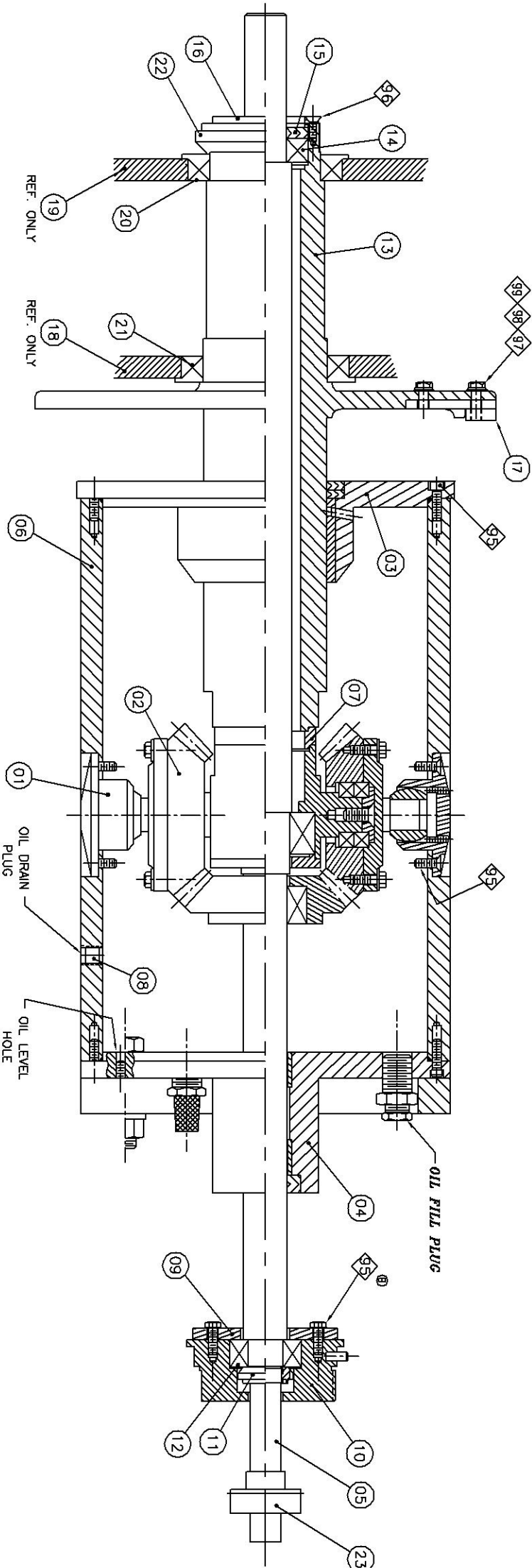
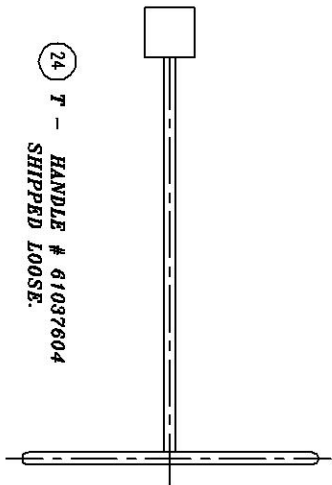


DRIVE DIRECTION, VIEWED FROM OPERATORS SIDE.

K:\ACADDWGS\VDR\CUSTOMER\79225118

	SCALE	1:16
	DSN BY	R.M.
	DWN BY	T-RAO
	DATE	11/79/12
	CHK	
JJ CASSONE BAKERY		
VDR 4/6 MAIN ASSEMBLY		
ADAMATIC		SHEET 79225118
607 INDUSTRIAL WAY WEST, EATONTOWN, NJ 07724		SHEET: 1/1

99	6106442		SCREW HH40 CAP 1/4-20" X 3/4"	02
98	619027		WASHER FLAT SAE 0.250" ID 2"	02
97	614680		WASHER LOCK 0.250" ID 2"	02
96	613662		SCREW FH HXSOC 10-24" X 0.500"	03
95	690733		SCREW HXSOC 1/4-20" X 0.750" SS	16
94	620085		SCREW HXSOC 1/4-20" X 3"	16



S:\ACADDWGS\VDR\792389

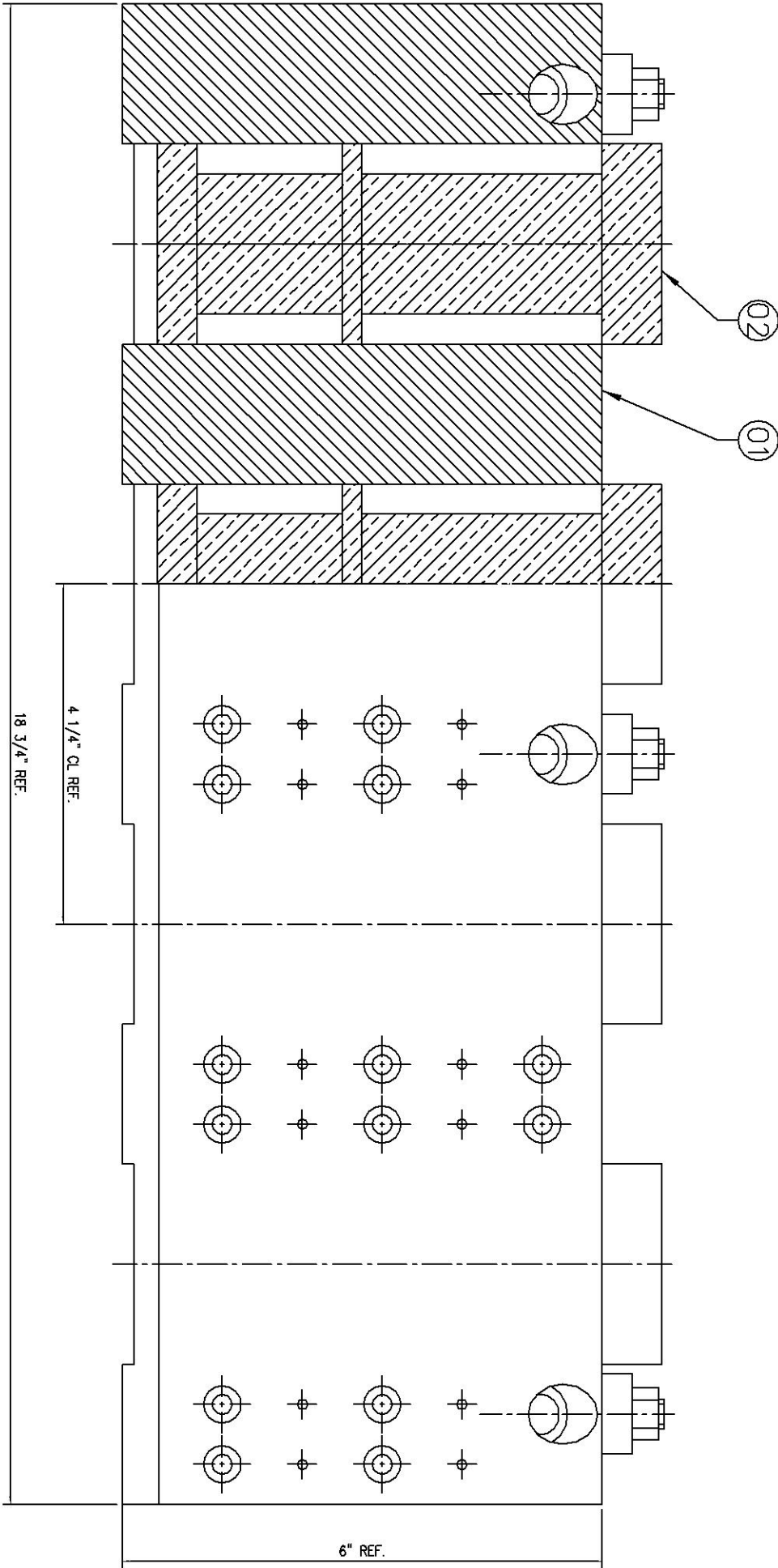
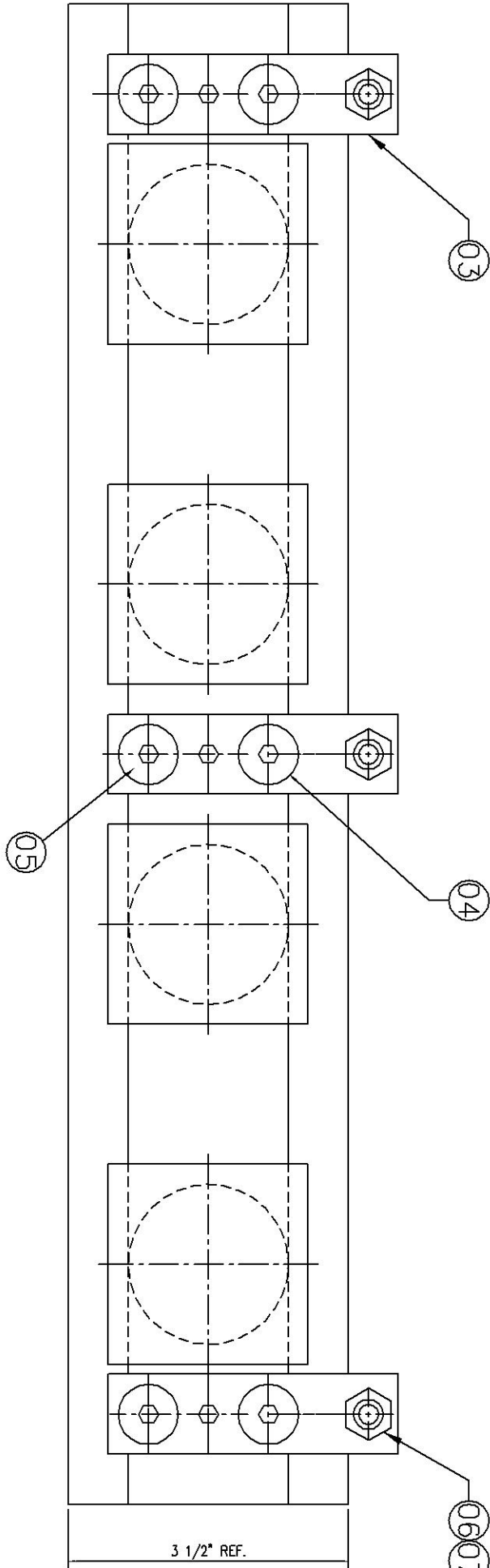
24	61037604		T HANDLE, VDR	01
23	690734		BEARING WC - 514	01
22	612803		NUT BEARING BH 16	01
21	612807		BALL BEARING 4773JB W/SHIELD DE.CO	01
20	612901		BALL BEARING #6016-2RS-NR RHP	01
19			PLATE DRIVE SDE OUTER & 7922502 REF ONLY	
18			PLATE DRIVE SDE INNER #7922501 REF ONLY	
17	618504		KEY BELMONT	01
16	610368-03		RNG. BEARING HOLDING	01
15	690732		SEAL, OL 62mm x 30mm x 7mm	01
14	614723		BEARING BALL #6205-58K Z2	01
13	610442		HUB, ROUNDING UNIT	01
12	686157		BEARING BALL #6205-58K Z2	01
11	686156		NUT, BEARING BH05	01
10	618900		HOUSING, BEARING END	01
09	618902		PLATE RETAINING	01
08	691289		PLUG, RUSH PIPE 1/4" NPT	01
07	610291-03		SPACER	01
06	610366		HOUSING, ROUNDING DRIVE	01
05	690764		SHAFT, ROUNDING UNIT ADR	01
04	610335-04		HOUSING ASSEMBLY, OUTER BEARING	01
03	610335-03		HOUSING ASSEMBLY, INNER BEARING	01
02	610335-02		HOUSING ASSEMBLY, AXEL STUB	01
01	610335-01		HOUSING ASSEMBLY, BEARING	02

◇ = HARDWARE
○ = PARTS

- NOTE: 1. ASSEMBLE ITEM #06 AND ITEM #04 SO THAT ITEM #08 IS 180° FROM FILL PLUG IN ITEM #04 ASS'Y.
① 2. PREFERRED LUBRICANT IS 90W NON TOX GEAR OIL (FOOD GRADE).
3. AFTER ASSEMBLY, ROTATE DRUM AND CHECK FOR FREE MOVEMENT.

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MACHINING TOLERANCES		SCALE	1:2	VDR	
FUNCTIONAL:	X/X ±1/64"	DSN BY	WK	ASSEMBLY, ROUNDING UNIT	
DEQUAL:	X/X ±0.025"	DWN BY	JME		
	X/X ±0.015"	DATE	3/26/93		
	X/X ±0.005"	CHK			
ANGULAR:	X ±0.5°			ADAMATIC	
BREAK SHARP CORNERS	B 3/16Z/93				
REMOVE ALL BURRS	C 3/15/93				
	A 11/21/94				
MACHINED SURFACES 63 RMS	RL DATE			SHEET 792389	
				D	
607 INDUSTRIAL WAY WEST, EXETER, NH 07724				SHEET 1 of 1	



MFG COPY

CUSTOMER: JU CASSONE

PURCH ORDER NO.:

SHOP ORDER NO.:M#

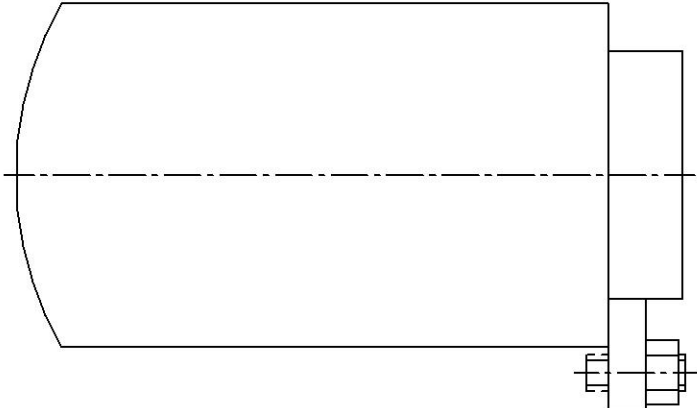
EDP ORDER NO.:M# 204760

EQP USED ON: VDR

QUANTITY: 1

DATE RELEASED: 3/30/06

MAKE BUY



07	617216		SOREN SET HNSOC 3/8-24 x 1.000" L.G.	03
06	612288		NUT, HEX 3/8-24	03
05	613642		SOREN, RH HNSOC 3/8-16 x .750" L.G.	03
04	612809		SOREN, RH HNSOC 3/8-16 x .875" L.G.	03
03	79239716		BRACKET, ADJUSTMENT W=1"	03
02	79239804		PISTON 2.000 x 2.500"	04
01	79239803		LINER, 4PKT 2.000" x 2.500" 4.250" CL.	01
ITM.	PART NO.	E/AI NO.	DESCRIPTION	QTY.

MACHINING TOLERANCES

FRACTIONAL: X/X ±1/64"

DECIMAL: X.XX ±0.025"

ANGULAR: ° ±0.5°

BREAK SHARP CORNERS

REMOVE ALL BURS

MACHINED SURFACES 63 RMS

SCALE: 1:1

DSN BY: JME

DATE: 6/6/93

CHK:

PISTON & LINER ASSY

2" X 2 1/2", 4PKT.

ADAMATIC

1

6081333

COMPANY

SHEET: 17/

DRAWING NO: 79240003

A

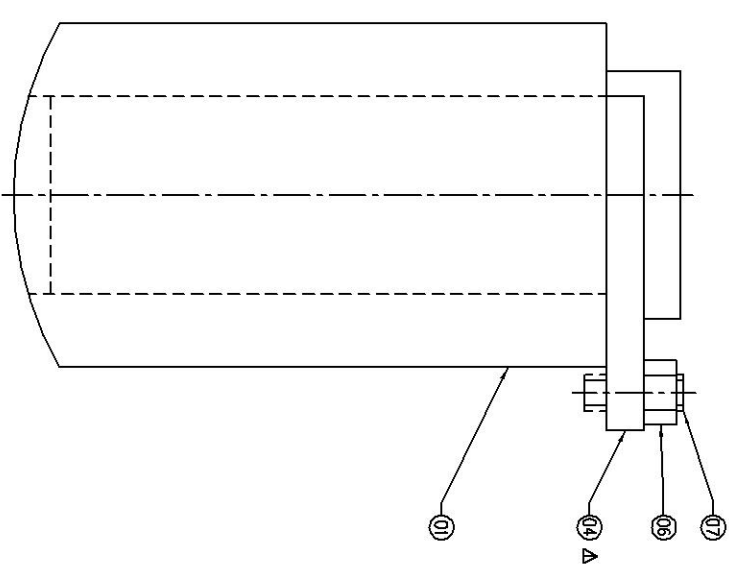
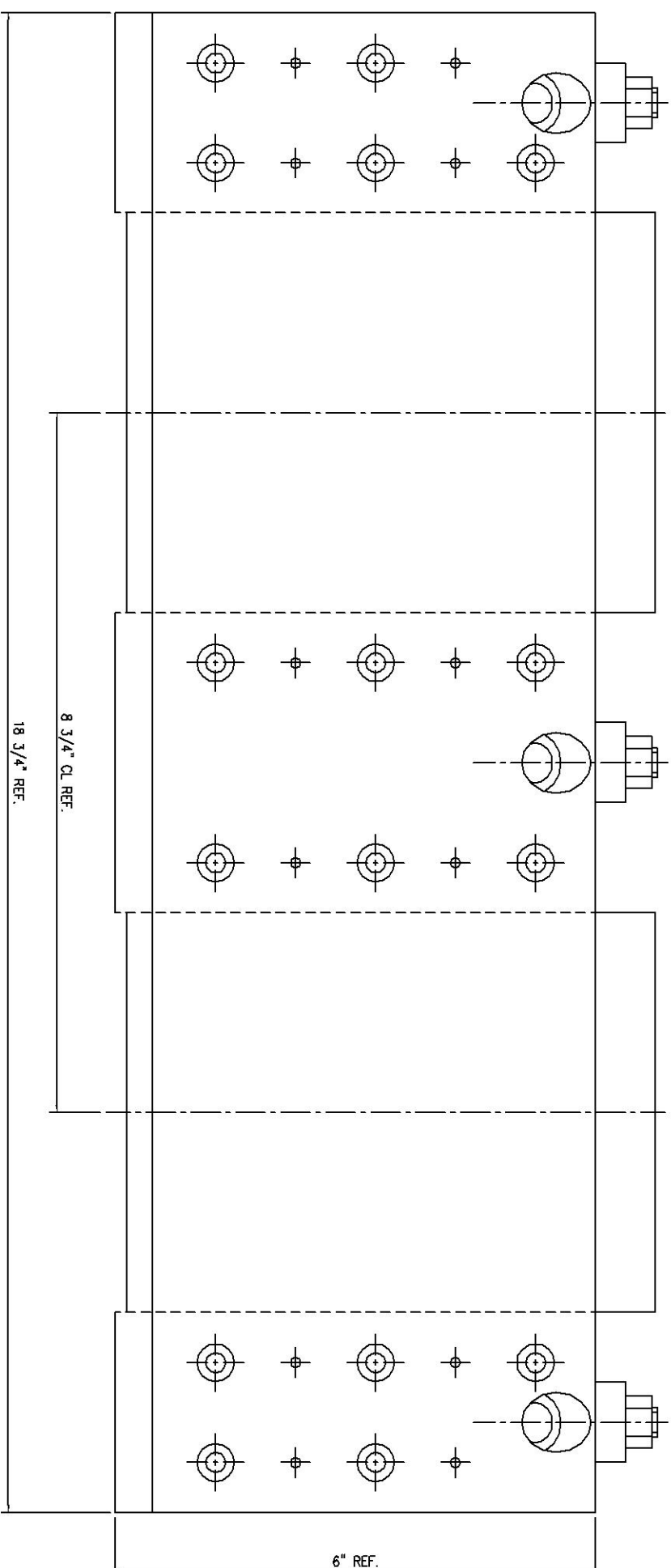
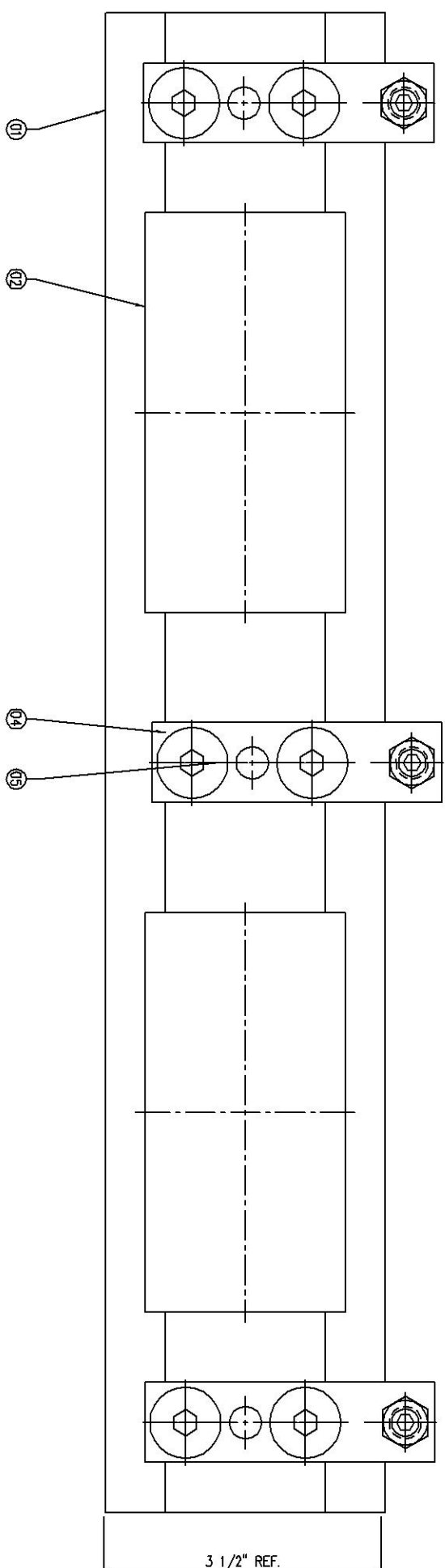
5/10/00

DATE

607 INDUSTRIAL WAY

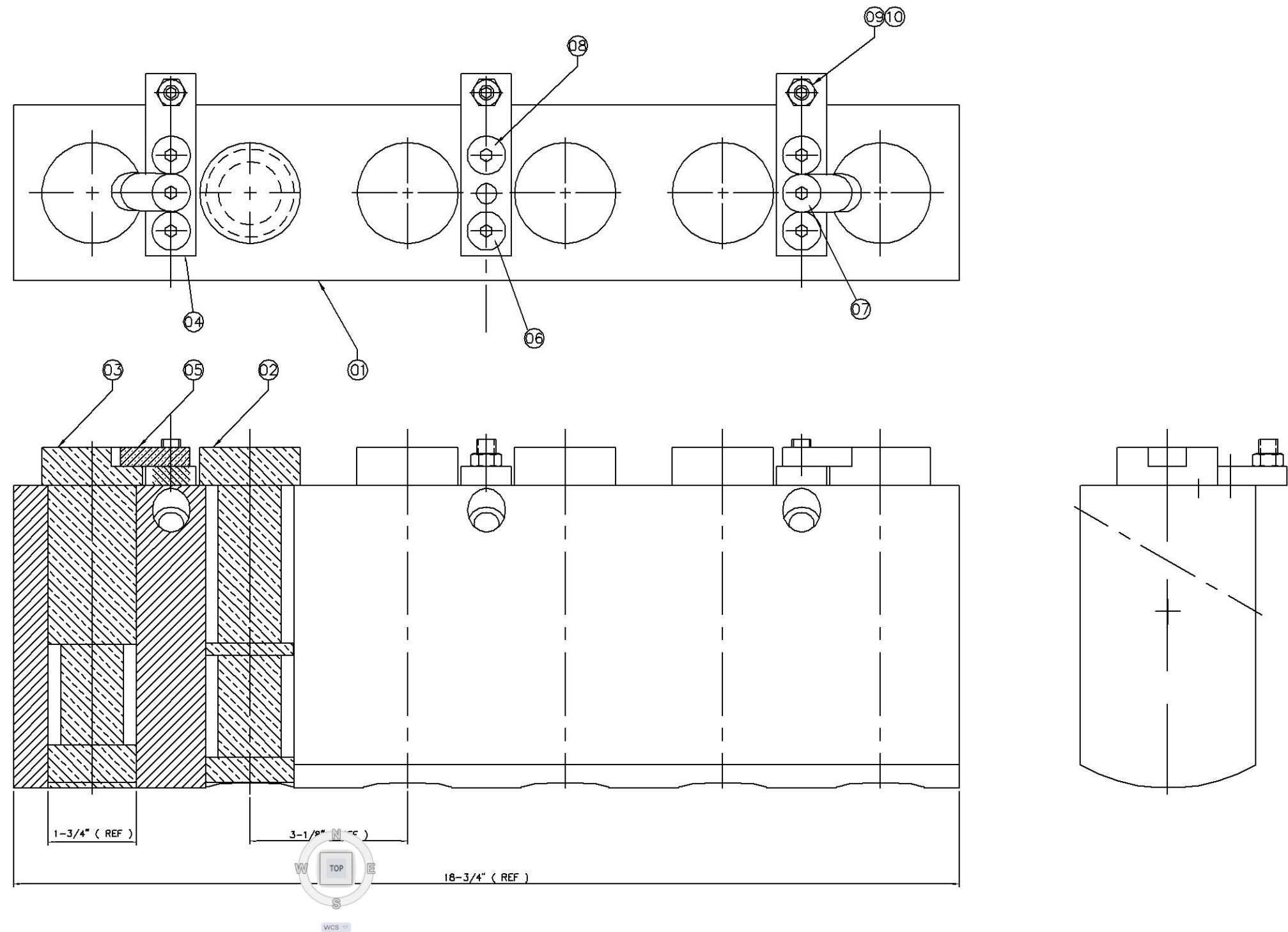
WEST, EATONTOWN, NJ 07724

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ITEM	DESCRIPTION	QTY	UNIT
01	PISTON 2.000 x 5.000"	02	
02	UNER, 2PKT, 2.000" x 5.000" x 7.500" Q.	01	
03		01	
04		03	
05		03	
06		03	
07		03	

MACHINING TOLERANCES		SCALE		1:1		WDR	
RACTIONAL	X/X	1/64"	DRN BY	JAE	PISTON & LINER ASSY 2PKT 8 3/4" CL		
DECIMAL	X/X	±0.025"	DMN BY	JAE			
	X.XXX	±0.015"	DATE	6/8/83			
	X.XXX	±0.005"	CHK				
ANVILS:							
BREAK SHARP CORNERS							
REMOVE ALL BURS							
MACHINED SURFACES ±.005							
	RL	DATE					
	1	5/15/12					
ADAMATIC		SHEET	DRAWING NO.				
		SIZE	79240004				
		D	SHEET: 1/1				
607 INDUSTRIAL WAY WEST, FORT MONROE, NJ 07074							



OPTIONS

- 1 : NO BLOCKOFFS
THIS ASSEMBLY COMES COMPLETE WITH (6X) #2 PISTON
OMIT ITEMS # 3, 5 & 7
- 2 : WITH (2) END BLOCKOFFS
THIS ASSEMBLY COMES COMPLETE WITH (6X) #2 PISTON
AND (2X) #3 BLOCKOFF PISTON.
INCLUDE ITEMS # 5 & 7
- 3 : WITH (1) END BLOCKOFF
THIS ASSEMBLY COMES COMPLETE WITH (6X) #2 PISTON
AND (1X) #3 BLOCKOFF PISTON.
INCLUDE ITEMS # 5 (1X) & 7 (1X)

NOTE: REF. TO DWG #79240048 FOR "OLD STYLE"

S:\ACADDWGS\VDR\P&L\6PKT\...

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TO MAKE NECESSARY CHANGES.

MACHINING TOLERANCES
FRACTIONAL: X/X ±1/64"
DECIMAL: X.X ±0.025"
X.XX ±0.015"
X.XXX ±0.005"
ANGULAR: X° ±0.5°
BREAK SHARP CORNERS
REMOVE ALL BURRS
MACHINED SURFACES 6.3 RMS

AS OF MARCH 1999
#79239704 WAS REPLACED

POS.	PART NO.	R/M NO.	DESCRIPTION	QTY.
10	617276		SCREW SET HEX 3/8-24" X 1.000"	03
09	612288		NUT HEX 3/8-24"	03
08	612909		SCREW FH HXSOC 3/8-16" X .875"	03
07	686612		SCREW FH HXSOC 3/8-16" X 1.250"	02
06	613642		SCREW FH HXSOC 3/8-16" X .750"	03
05	79268118		BRACKET ADJUSTMENT	02
04	79239716		BRACKET ADJUSTMENT 1" WIDE	03
03	79239825		PISTON 1.750" BLOCKOFF SOLID	02
02	79239808		PISTON 1.750" SOLID FLAT FACE	06
01	79239901		LINER 6 PKT 1-3/4" X 3.125" C/L	01
BILL OF MATERIALS				
SCALE			1:1	VDR
DSN BY			T. DEVITO	PISTON & LINER ASSY 6 PKT 3-1/8" C/L
DWN BY			T. DEVITO	
DATE			5/21/97	
CHK				
A 4/1/99				
RL			DATE	
ADAMATIC			607 INDUSTRIAL WAY WEST, EATONTOWN, NJ 07724	
SHEET			SIZE	D
DRAWING NO.			79240023	
SHEET:			1/1	

MFG COPY

CUSTOMER:_____

PURCH ORDER NO.:_____

SHOP ORDER NO.:M#_____

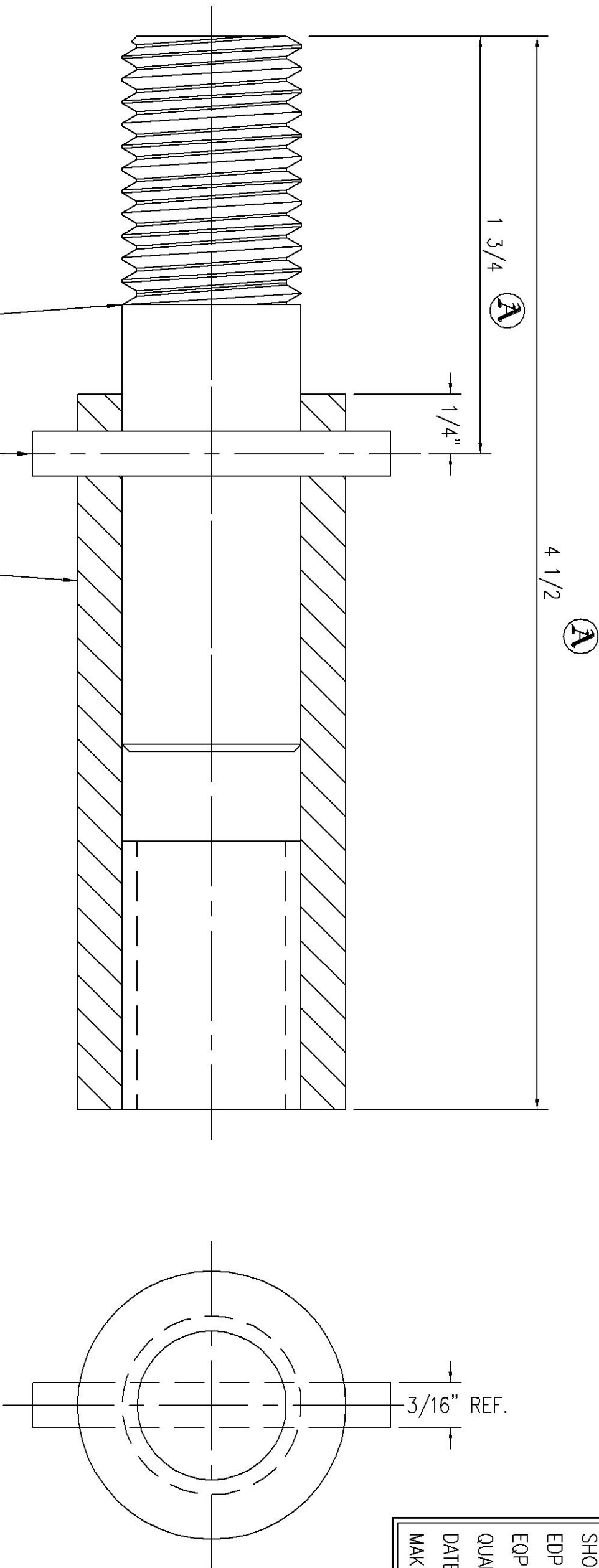
EDP ORDER NO.:_____

EQP USED ON:_____

QUANTITY:_____

DATE RELEASED:6/16/06_____

MAKE_____BUY_____



03	610587		PIN, DOWEL 3/16" Ø x 1.500"	BRASS	01
02	792541-02		SLEEVE, CONNECTING		01
01	792541-01		PIN, CONNECTING		01
POS.	PART NO.	R/M NO.	DESCRIPTION		QTY.

BILL OF MATERIALS

	SCALE	2:1	VDR		
--	-------	-----	-----	--	--

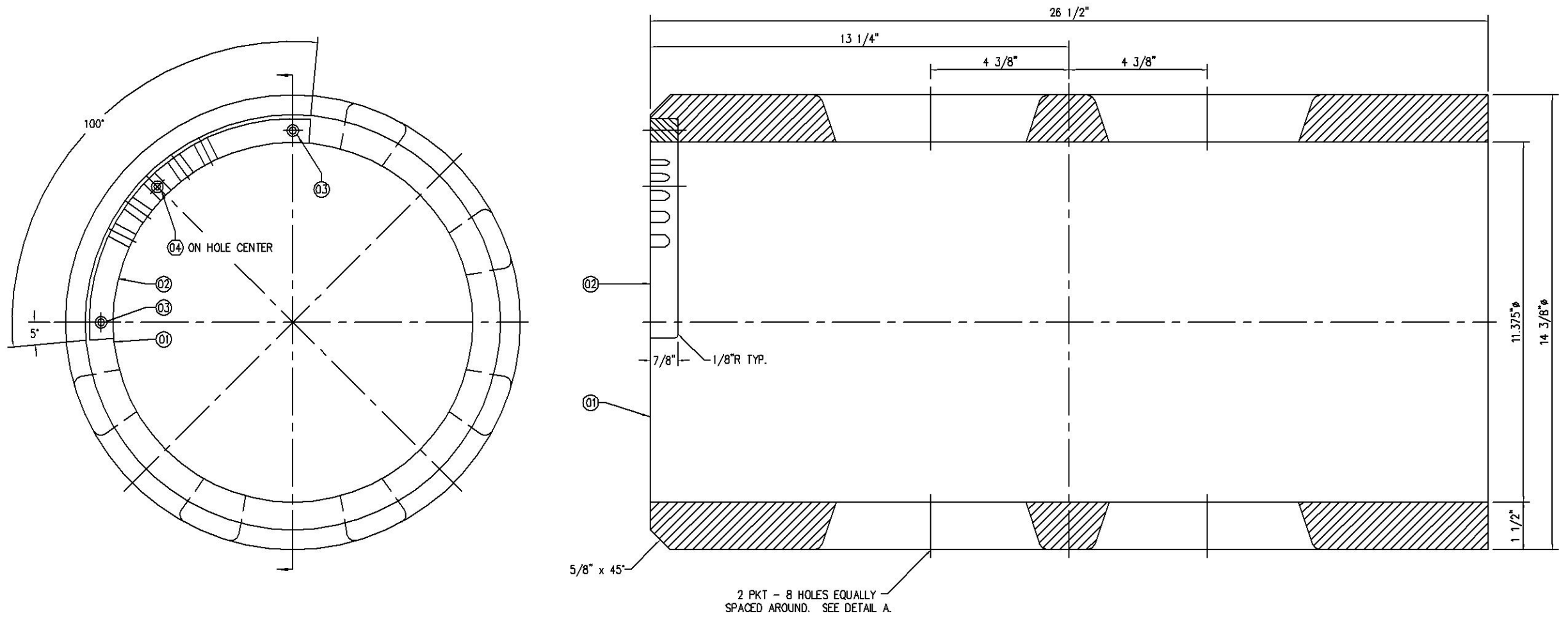
	DSN BY	JME	SHEAR PIN ASSEMBLY		
	DWN BY	JME			
	DATE	4/22/93			
	CHK				

MACHINING TOLERANCES		
FRACTIONAL:	X/X	±1/64"
DECIMAL:	X.X	±0.025"
	X.XX	±0.015"
	X.XXX	±0.005"
ANGULAR:	X°	±0.5°
BREAK SHARP CORNERS		
REMOVE ALL BURRS		
MACHINED SURFACES 63 RMS		

RL	DATE	9/12/97	ADAMATIC		
607 INDUSTRIAL WAY WEST, EATONTOWN, NJ 07724			SHEET SIZE	DRAWING NO.	
			B	792541	
			SHEET:	1/1	

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S:\ACADDWGS\VDR\792541

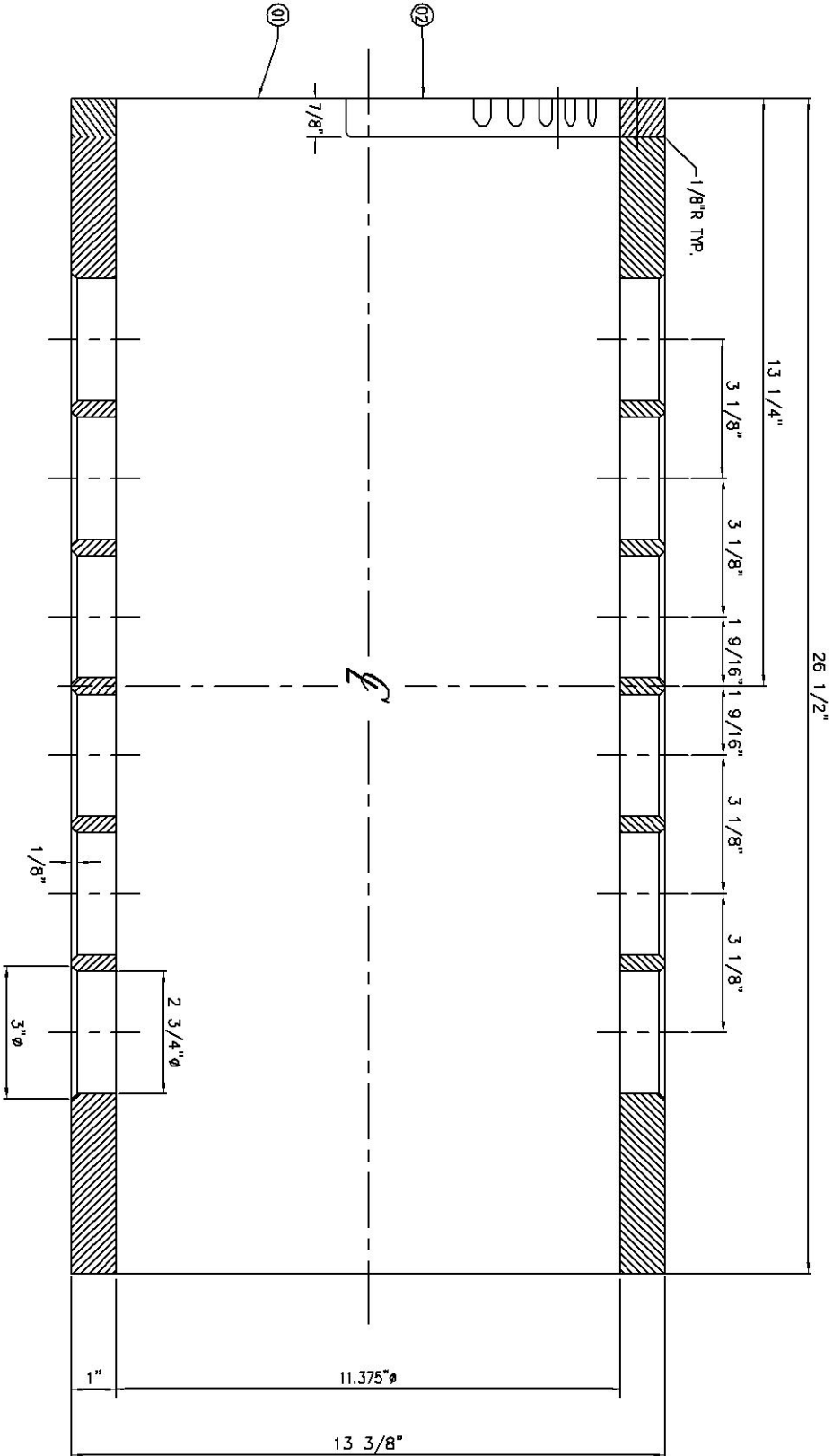
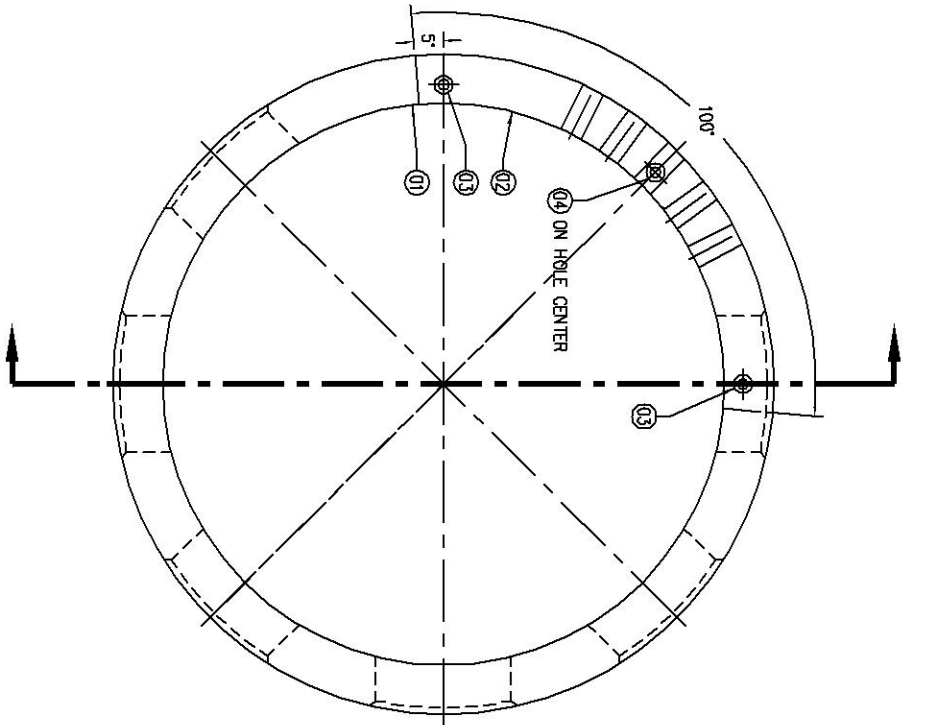


S:\ACADDWGS\VDR\DRUMS\2PKT\

04	617253		SCREW, HXSQC #10-24 x 1.000" LG.	01
03	612954		SCREW, FH SLOT #10-32 x 1.500" LG.	02
02	624960		INSERT, ROUNDING DRUM	01
01	624987		DRUM BLANK 11.375" I.D. x 1.500" WALL x 26.500" LG.	01
POS.	PART NO.	R/W NO.	DESCRIPTION	QTY.

MACHINING TOLERANCES		SCALE	1:2	VDR	
FRACTIONAL:	X/X ±1/64"	DSN BY	JME	DRUM, ROUNDING SOLID 2pkt 10.0-14.0 oz.	
DECIMAL:	X.X ±0.025"	DWN BY	JME		
	X.XX ±0.015"	DATE	7/8/93		
	X.XXX ±0.005"	CHK			
ANGULAR:	X° ±0.5°	ADAMATIC A COMPANY		SHEET	DRAWING NO.
BREAK SHARP CORNERS				92C	79254904
REMOVE ALL BURRS				D	
MACHINED SURFACES 63 RMS					SHEET: 1/1
RL	DATE	607 INDUSTRIAL WAY WEST, EATONTOWN, NJ 07724			

DETAIL A



K:\adomatic\ocaddwgs\WDR\DRUMS\6PKT

04	617233	STEEL, HSSC. #10-24 x 1.000" LG.	01
01	612954	STEEL, FH SLOT #10-32 x 1.500" LG.	02
02	624860	INSERT, ROUNDING DRUM	01
01	624862	DRUM BLANK, 11.375" ID x 1.062" WALL x 26.500" LG.	01
POS.	PART NO.	E/AI NO.	DESCRIPTION

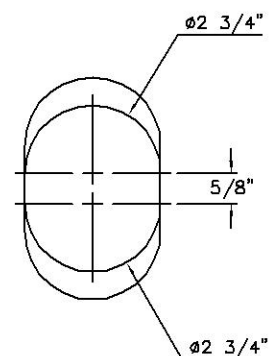
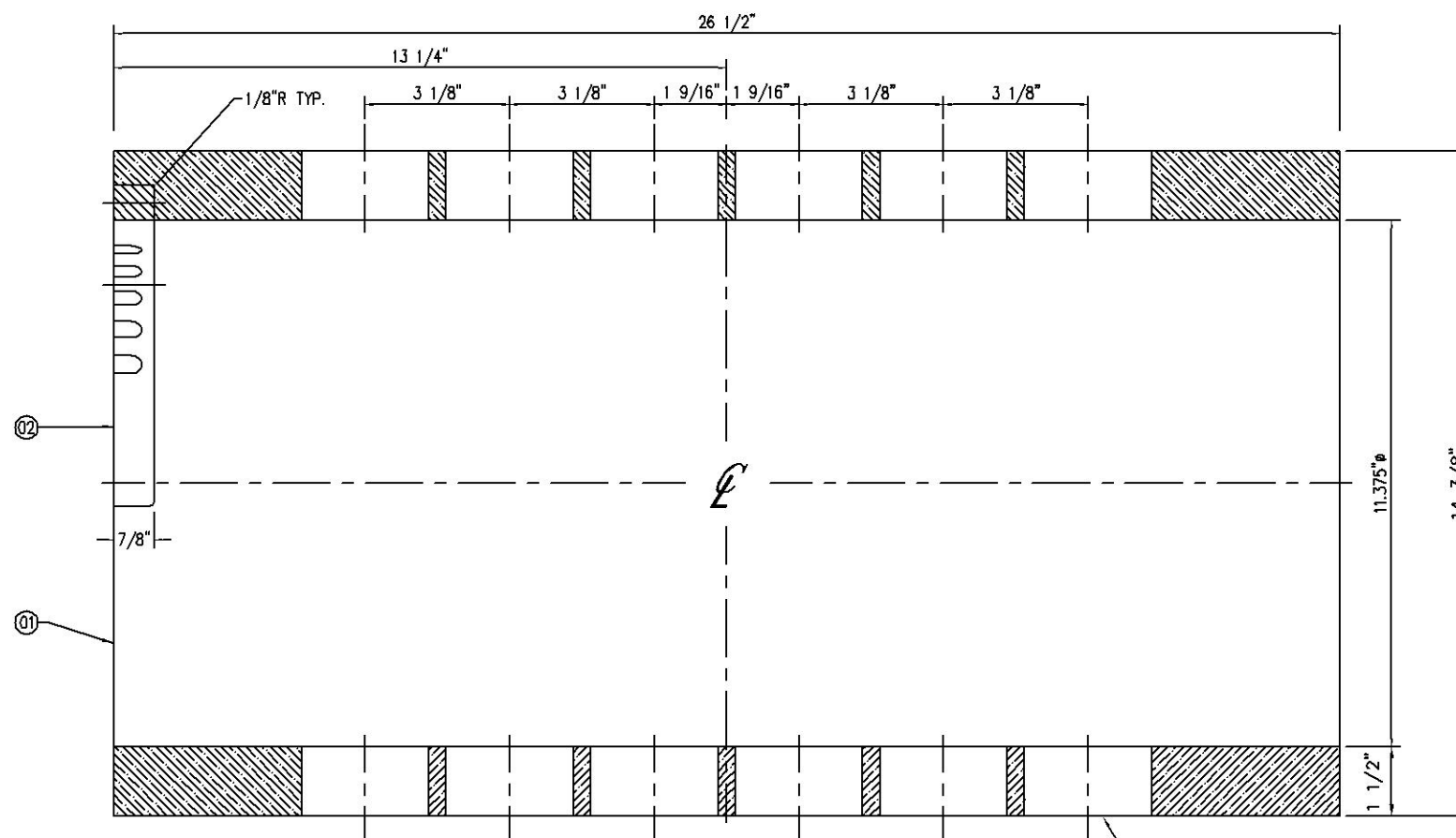
MACHINING TOLERANCES		SCALE	1:2	FOR	
FRACTIONAL:	N/A	±1/64"	DSN BY	T. DEWIT	DRUM, ROUNDING SOLID
DECIMAL:	X.X	±0.025"	DMN BY	T. DEWIT	6pkt 1.5-2.5 oz.
	X.XX	±0.015"	DATE	3/13/96	
	X.XXX	±0.005"	CHK		

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ANQUILER:		1" ±0.5"
BREAK SHARP CORNERS		
REMOVE ALL BURRS		
MACHINED SURFACES 63 RMS		
FILE	DATE	
1	01-24-12	

ADAMATIC
607 INDUSTRIAL WAY WEST, EASTONTOWN, NJ 07724

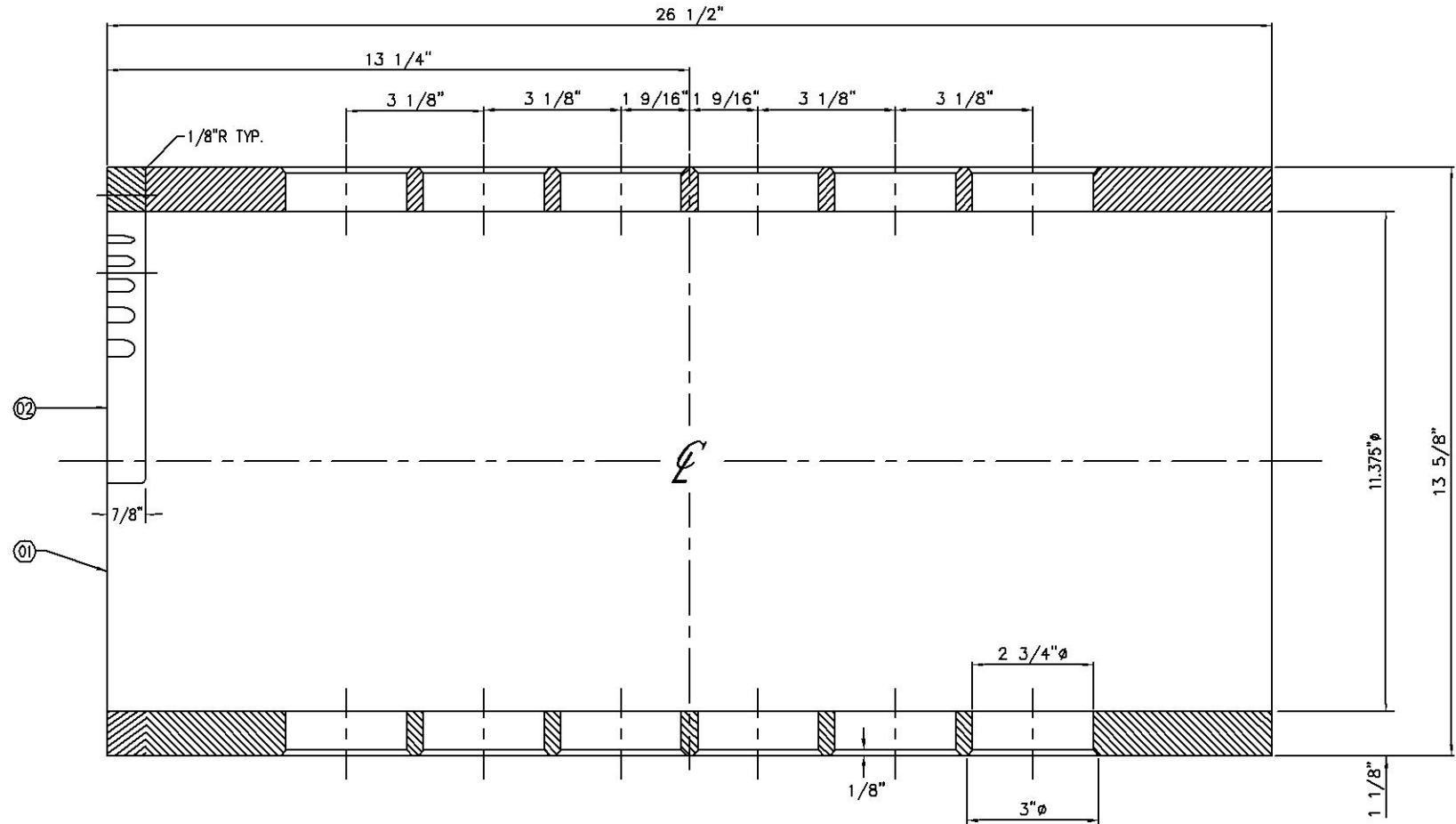
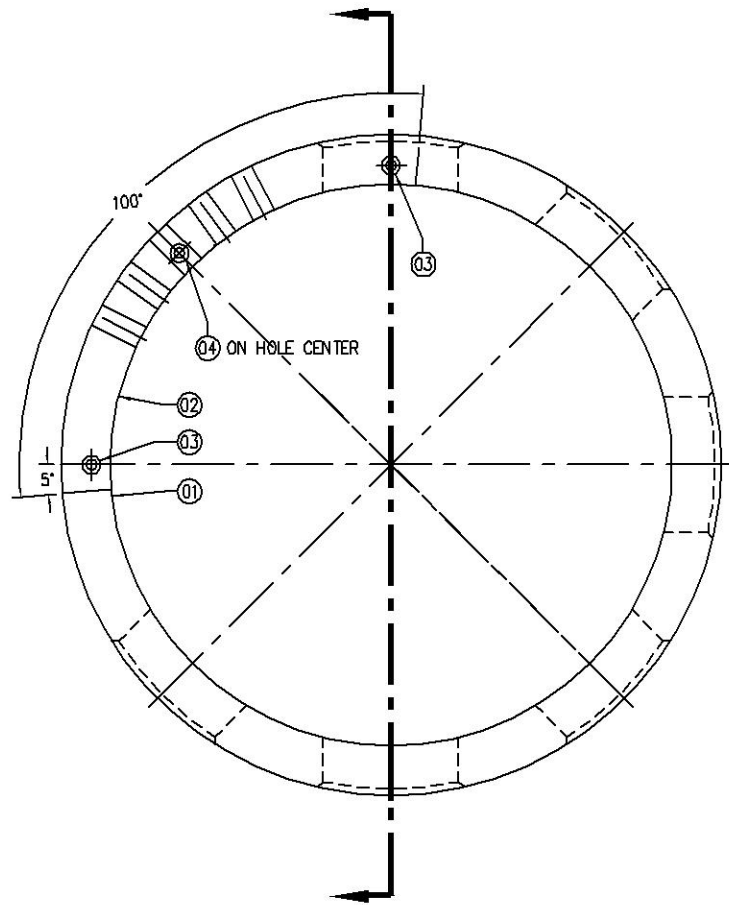
SHEET	DRAWING NO.
92E	79254910
D	
SHEET	1/1



DETAIL (A)

5.0 - 6.0 OZ RANGE.

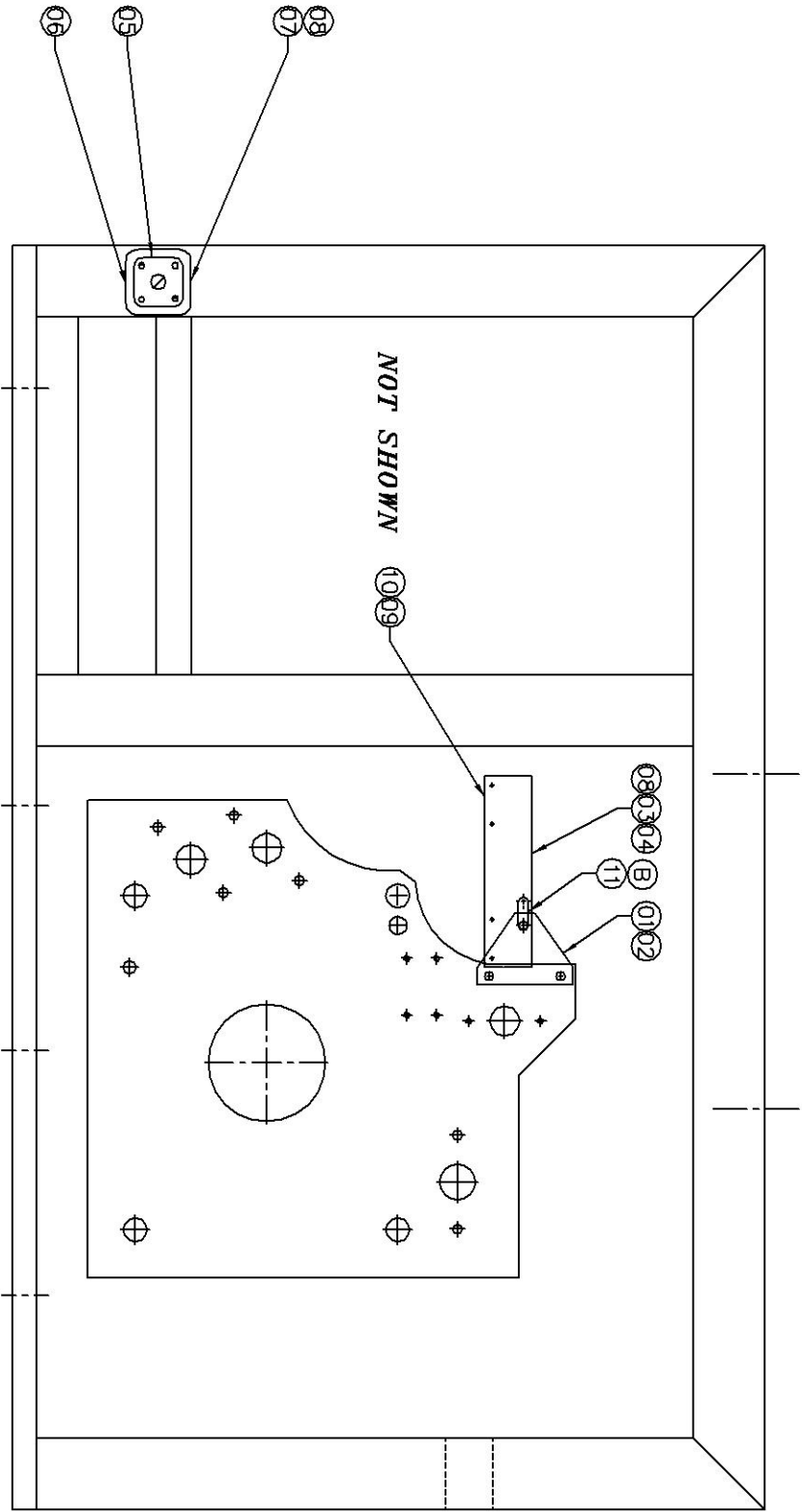
04	617253		SCREW, HXSQC #10-24 x 1.000" LG.	01
02	612954		SCREW, FH SLOT #10-32 x 1.500" LG.	02
03	624960		INSERT, ROUNDING DRUM	01
01	621385		DRUM VOR6 W/O HOLES, 11.375" ID x 1.625" WALL	01
POS.	PART NO.	R/M NO.	DESCRIPTION	QTY
BILL OF MATERIALS				
		SCALE 1:2	VOR	
DSN BY		T. DEWITO	DRUM, ROUNDING SOLID 6pkt 1-1/2" THICK	
DWN BY		T. DEWITO		
DATE		7/31/97		
CHK				
ADAMATIC			SHEET 9/32	DRAWING NO. 79254931
RL	DATE	607 INDUSTRIAL WAY WEST, EATONTOWN, NJ 07724	D	SHEET: 1/1



S:\ACADDWGS\VDR\DRUMS\6PKT\79254938

04	617253		SCREW, HXSOC #10-24 x 1.000" LG.	01
03	612954		SCREW, FH SLOT #10-32 x 1.500" LG.	02
02	624960		INSERT, ROUNDING DRUM	01
01	624986		DRUM BLANK 11.375" I.D. x 1 1/8" WALL x 26.500" LG.	01
POS.	PART NO.	R/M NO.	DESCRIPTION	QTY.

MACHINING TOLERANCES			SCALE		1:2		BILL OF MATERIALS		VDR		
FRACTIONAL:	X/X	±1/84"	DSN BY	T. DEVITO		DRUM, ROUNDING SOLID 6pkt 3 oz.					
DECIMAL:	X.X	±0.025"	DWN BY	K. CROHN							
	X.XX	±0.015"	DATE	3/11/98							
	X.XXX	±0.005"	CHK								
ANGULAR:	X°	±0.5°									
BREAK SHARP CORNERS							ADAMATIC A HOBART COMPANY				
REMOVE ALL BURRS											
MACHINED SURFACES 63 RMS											
RL			DATE		607 INDUSTRIAL WAY WEST, EATONTOWN, NJ 07724		SHEET SIZE D		DRAWING NO. 79254938 SHEET: 1/1		



S:\ACAD\DWG\VDRA\79343701

01	794092		SPACER, 3/4" OD, 7/16" ID, .375 LG	
02	794232		BRACKET KEY DOOR SWITCH	
03	79423001		SWITCH BRACKET DOOR, COP STEEL	
04	668065		CONNECTOR CORD	
05	616375		CONNECTOR TIGHT 90 DEGREE 3/8" X 1/4" M18	
06	616374		CONNECTOR LUG TIGHT STRAIGHT	
07	655154		STUNDO BOX, JUNCTION	
08	691935		SAFETY SWITCH DRIVE DOORS	
09	794185		BRACKET SWITCH DRIVE DOORS	
10	793794		SPACER BRACKET CAM DRIVE	
11	793793		BRACKET CAM DRIVE	

POS.	PART NO.	R/A/NO.	DESCRIPTION	QTY.
01	794092		SPACER, 3/4" OD, 7/16" ID, .375 LG	01
02	794232		BRACKET KEY DOOR SWITCH	02
03	79423001		SWITCH BRACKET DOOR, COP STEEL	03
04	668065		CONNECTOR CORD	01
05	616375		CONNECTOR TIGHT 90 DEGREE 3/8" X 1/4" M18	01
06	616374		CONNECTOR LUG TIGHT STRAIGHT	01
07	655154		STUNDO BOX, JUNCTION	01
08	691935		SAFETY SWITCH DRIVE DOORS	02
09	794185		BRACKET SWITCH DRIVE DOORS	01
10	793794		SPACER BRACKET CAM DRIVE	01
11	793793		BRACKET CAM DRIVE	1

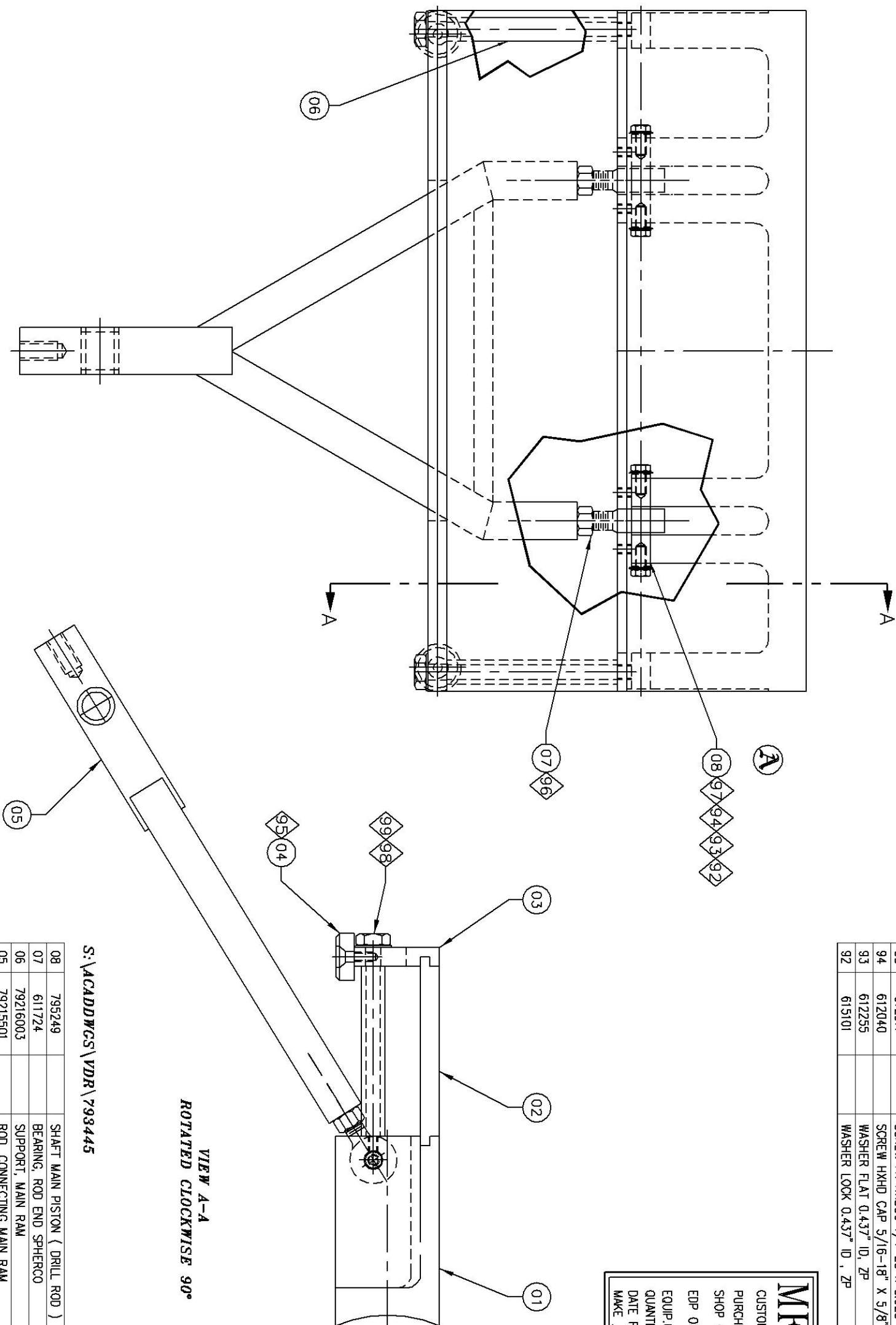
MACHINING TOLERANCES				SCALE				TITLE OF MATERIALS			
FRAC/INCH	N	±	1/64"	DRN BY	N	SPRNG	1:4	VDRA			
DECIMAL	XX	±	0.005"	DATE	12/04/95			DRIVE SIDE			
ANGULAR	X	±	0.5°	DATE	12/04/95			ELECTRICAL ASSEMBLY			
REMOVE ALL BURRS	XXX	±	0.005"	DATE	12/04/95			SHEET 79343701			
MACHINED SURFACES TO THIS	XXX	±	0.005"	DATE	12/04/95			SHEET 1/1			

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99	613886	SCREW HXHD CAP 3/8-16" X 5.500" LG	2
98	614078	WASHER LOCK 0.375" ID ZP	2
97	613147	SCREW SET HXSOC 1/4-20" X 0.500" LG	4
96	613947	NUT HX 1/2-20" GR5 ZP	2
95	612911	SCREW FH HXSOC 1/4-20 X 0.625" LG	2
94	612040	SCREW HXHD CAP 5/16-18" X 5/8" LG	04
93	612255	WASHER FLAT 0.437" ID, ZP	04
92	615101	WASHER LOCK 0.437" ID , ZP	04

MFG COPY

CUSTOMER: GOLD COAST BKY/
PURCH ORDER NO.: CAMPHONE
SHOP ORDER NO.: M#
EDP ORDER NO.: M# 992100
EQUIP. USED ON: _____
QUANTITY: _____
DATE RELEASED: 2/28/06
MAKE _____ BUY _____



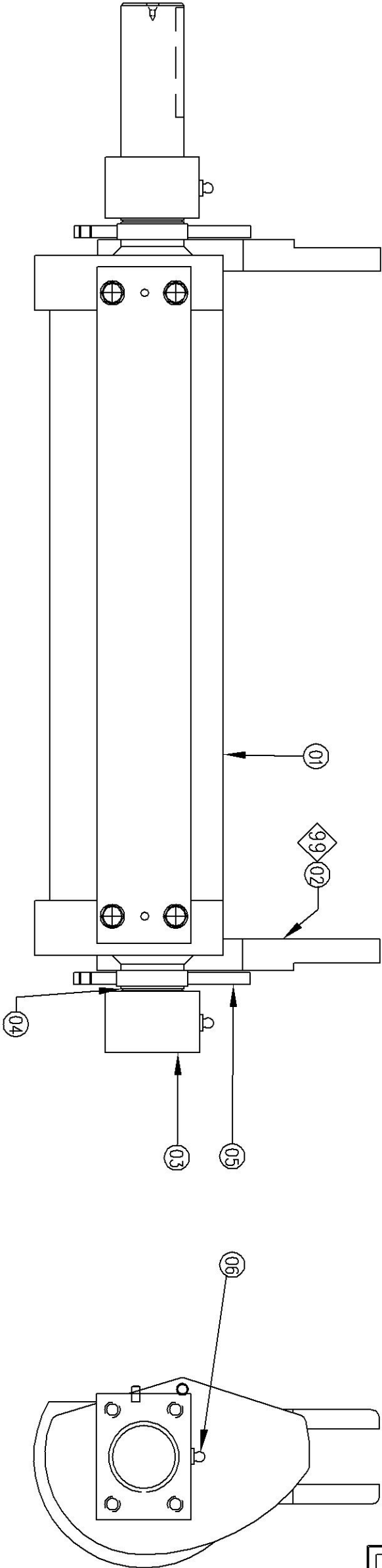
POS.	PART NO.	R/M NO.	DESCRIPTION	QTY.
08	795249		SHAFT MAIN PISTON (DRILL ROD)	2
07	611724		BEARING, ROD END SPHERCO	2
06	79216003		SUPPORT, MAIN RAM	2
05	79215501		ROD, CONNECTING MAIN RAM	1
04	692175		PIN, MAIN PISTON	2
03	79216002		BRACKET, MAIN RAM ADR	1
02	79216001		COVER, MAIN RAM ADR	1
01	792152		MAIN RAM	1
				1

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MACHINING TOLERANCES		SCALE	1-2	VDR
FRACTIONAL:	X/X	DSN BY	T. DEVITO	MAIN PISTON ASSEMBLY VDR
DECIMAL:	X.X	DWN BY	T. DEVITO	
	X.XX	DATE	4/11/94	
	X.XXX	CHK		
ANGULAR:	X° ±0.5°			
BREAK SHARP CORNERS				
REMOVE ALL BURS	A	7/8/96		
MACHINED SURFACES 63 RMS	RL	DATE		
			ADAMATIC	
607 INDUSTRIAL WAY WEST, EATONTOWN, NJ 07724			C	SHEET NO. DRAWING NO.
				793445
				SHEET: 1/1

MFG COPY

CUSTOMER: GOLD COAST BKY
PURCH ORDER NO: _____
SHOP ORDER NO.: M# _____
EDP ORDER NO.: M# 992100 _____
EQUIP. USED ON: _____
QUANTITY: _____
DATE RELEASED: 2/28/06 _____
MAKE _____ BUY _____



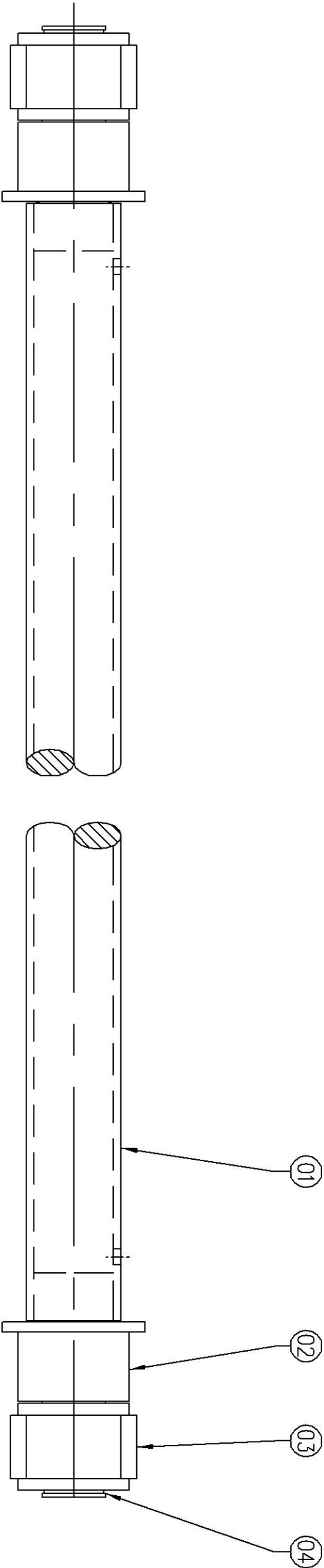
S:\ACAD\DWGS\VDH\793452

06	611078		CREASE FITTING 45 DEGREE	02
05	79215603		CAL. PISTON PUSHOUT	02
04	615713		RNG. RETAINING #3100-200	02
03	79215601		BLOCK, BEARING DIVING HEAD	02
02	79215602		GUIDE, PISTON PUSHOUT DIVING HEAD	02
01	792155		DIVING HEAD 4/6	01
POS.	PART NO.	R/W NO.	DESCRIPTION	QTY

MACHINING TOLERANCES			SCALE 1:2		FOR	
FRACTIONAL: X/X			DECIMAL: X.X	±1/64"	DIVIDING HEAD ASSEMBLY 4/6 POCKET	
ANGULAR: X°			DECIMAL: X.XX	±0.029°		
BREAK SHARP CORNERS			DATE 4/12/94	±0.015°		
REMOVE ALL BURRS			CHK	±0.005°	ADAMANTIC	
MACHINED SURFACES 63 RMS			DATE			
RL			DATE			
			607 INDUSTRIAL WAY WEST EASTONTOWN, NJ 07724		SHEET 793452	
					D	
					SHEET 1/1	

◇ = **HARDWARE**
○ = **PARTS**

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04	691403		RING, RETAINING, 1" #3100-100 EASTERN	02
03	691232		ROLLER GUIDE PISTON	02
02	61010502		GUIDE, PISTON STOP	02
01	79239301		SHAFT, PISTON STOP	01
POS.	PART NO.	R/M NO.	DESCRIPTION	QTY.

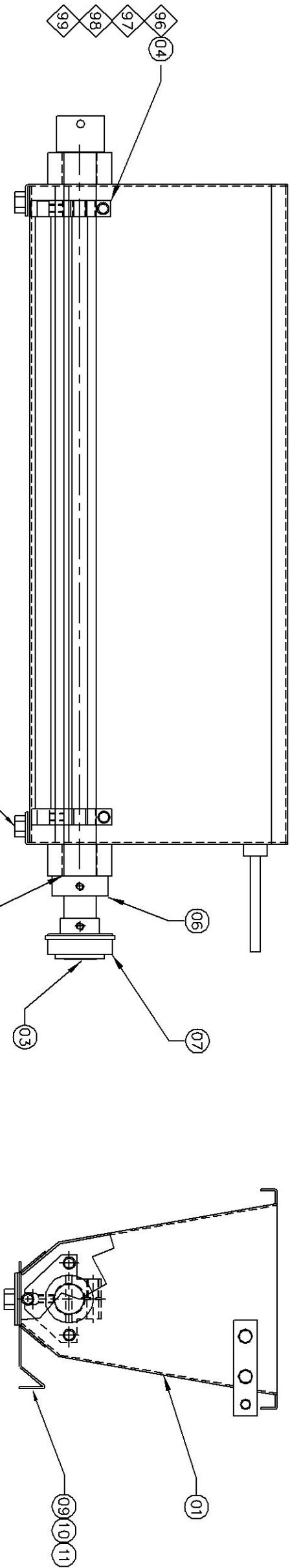
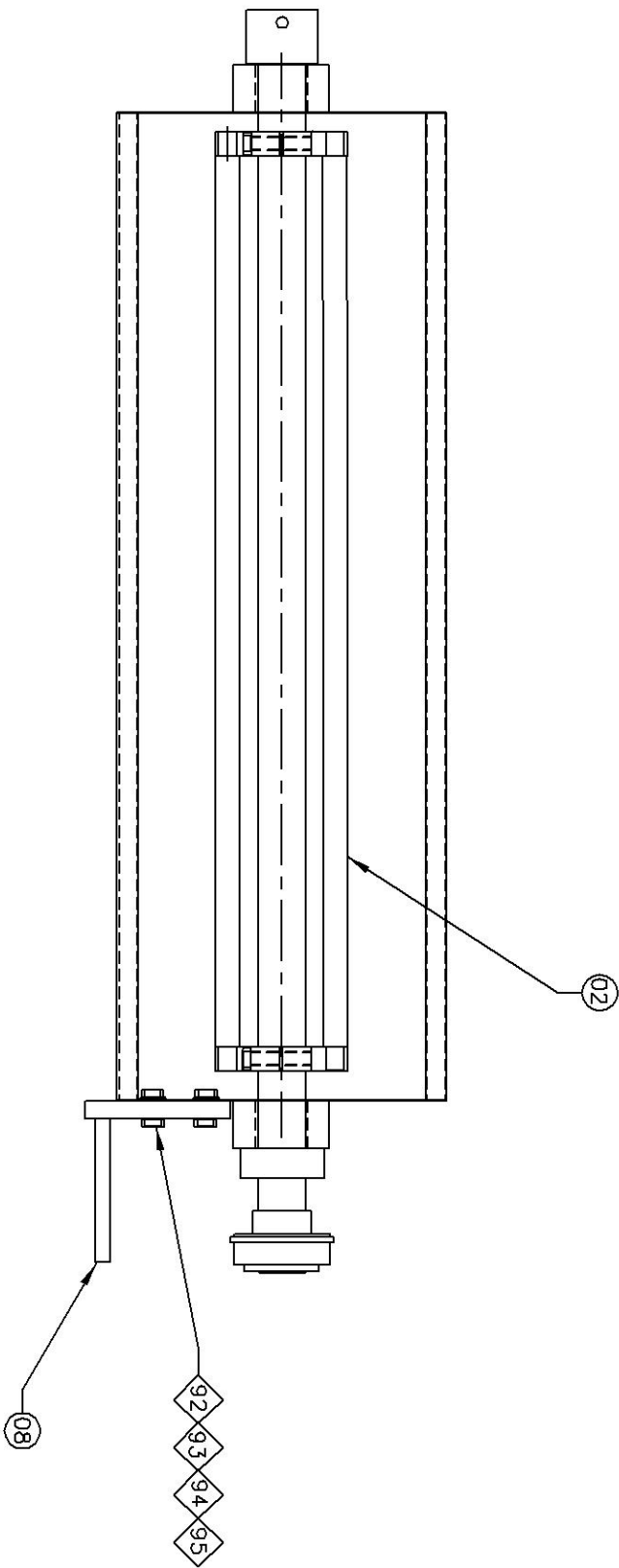
BILL OF MATERIALS

MACHINING TOLERANCES		SCALE	1:2	VDR
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FRACTIONAL:	X/X	±1/64"
DECIMAL:	X.X	±0.025"
	X.XX	±0.015"
	X.XXX	±0.005"
ANGULAR:	X°	±0.5°

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MACHINED SURFACES 6.3 RMS	
BREAK SHARP CORNERS REMOVE ALL BURRS	
RL	DATE
607 INDUSTRIAL WAY WEST, EATONTOWN, NJ 07724	
ADAMATIC	
SHEET SIZE	DRAWING NO.
B	793453
SHEET: 1/1	

99	612263			SCREW HARD CAP 3/8-16" X 1.500"			02
98	615028			WASHER FLAT SAE 0.315 ID 2P			02
97	614078			WASHER LOCK 0.315 ID 2P			02
96	612969			SCREW SET HSSOC 1/4-20" X 0.315"			02
95	613793			SCREW HARD CAP 1/4-20" X 0.975"			02
94	615027			WASHER FLAT SAE 0.250 ID 2P			02
93	614690			WASHER LOCK 0.250 ID 2P			02
92	606609			NUT ELASTIC STOP 1/4-20"			02



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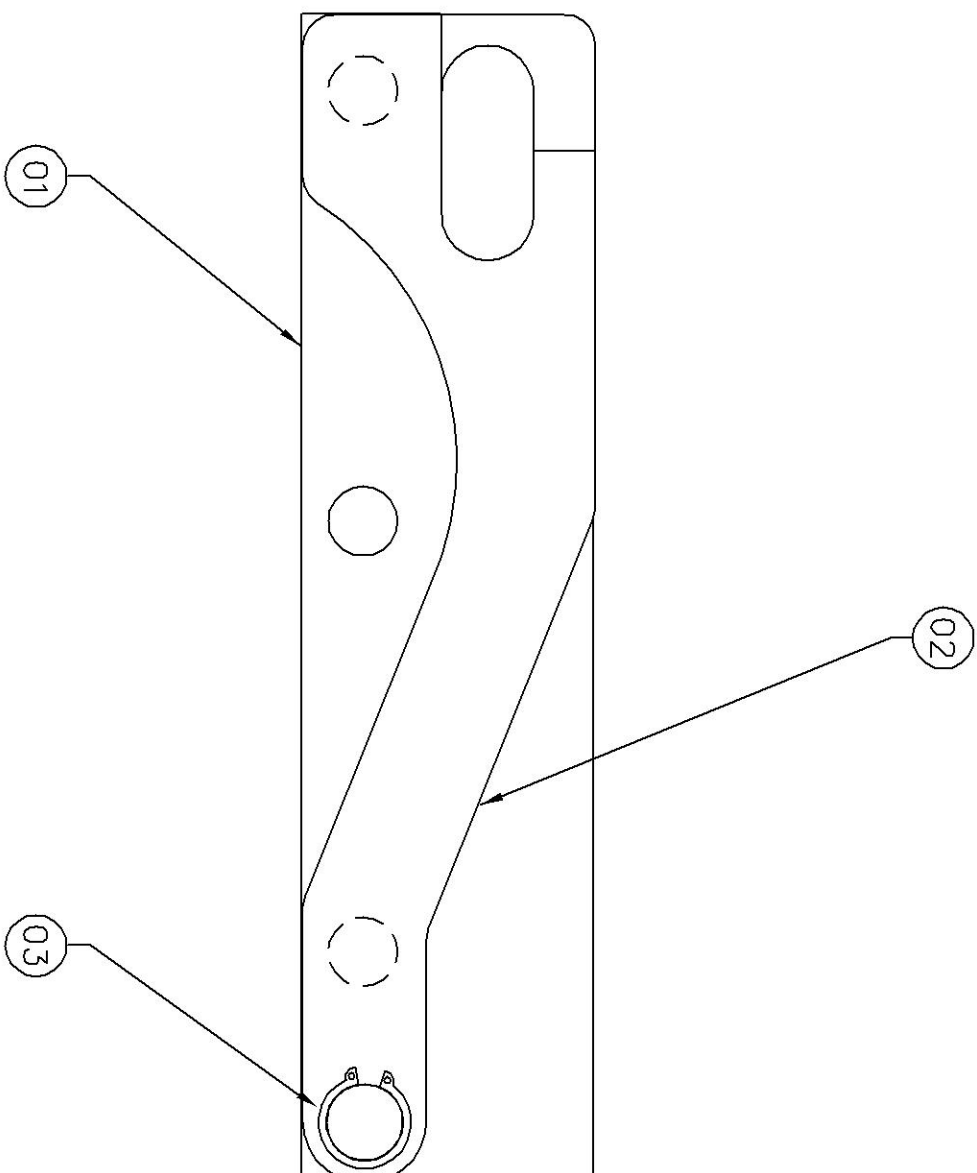
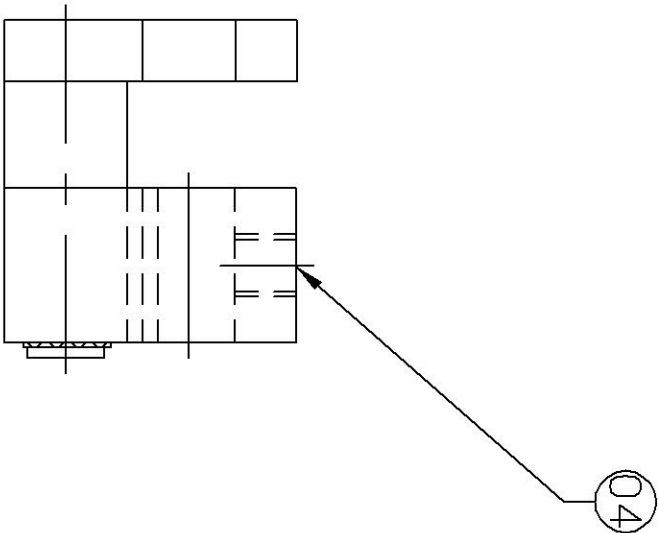
12	00664801			BALL RUNNER 3/8-16"			02
11	79237203			FLOUR DUSTER SIDE 2 PRT 8-3/4" O.			01
10	79237202			FLOUR DUSTER SIDE 4 PRT 4-1/4" O.			01
09	79237201			FLOUR DUSTER SIDE 6 PRT 3-1/8" O.			01
08	61043705			BRACKET FLOUR DUSTER W/O			01
07	628319			BEARING BALL W/ 516 1.00" ID			01
06	610622			COLLAR 1" ID			01
05	792269			BEARING NYLONER 16L16 - F			02
04	79237601			BRACKET FLOUR DUSTER			02
03	79237604			SHAFT FLOUR DUSTER			01
02	79237603			SHAFT CROSS FLOUR DUSTER A/B			03
01	79237502			FLOUR DUSTER MOUNT			01
POS.	PART NO.	E/AI NO.		DESCRIPTION			QTY.

MACHINING TOLERANCES				SCALE				FOR			
FRACTIONAL: N/A				1:2				WORK			
DECIMAL: X/X				DWN BY: T. DEWITT				FLOUR DUSTER ASSEMBLY			
DATE: 5/2/94				CHK:				SHEET: 9/2			
ANGULAR: X/XXX				BREAK SHARP CORNERS				DRAWING NO: 793524			
REMOVE ALL BURRS				MACHINED SURFACES 63 RMS				D			
FIL				DATE				SHEET: 1/1			

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◇ = **HARDWARE**

○ = **PARTS**



POS.	PART NO.	R/A NO.	DESCRIPTION	QTY.
04	684806		BALL PLUNGER 1/2-13 X .75" LG W-N	01
03	615716		RETAINING RING EXTERNAL 5/8" ID	01
02	79224501		GUIDE PISTON PUSHOUT	01
01	79224503		SUPPORT PISTON GUIDE DRIVE SIDE	01
				1

BILL OF MATERIALS

	SCALE	FULL	VDR
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[illegible]

OWN BY	T DEWITT
PISTON PUSHOUT ASSY	

DATE	TIME	DRIVER	CIDR
5/11/94	1:00	1:00	1:00

DATE	3/11/34
NAME	

DRIVE SIDE

[illegible]

DOMOTIC

UKRAINING NO.

SHEET SIZE

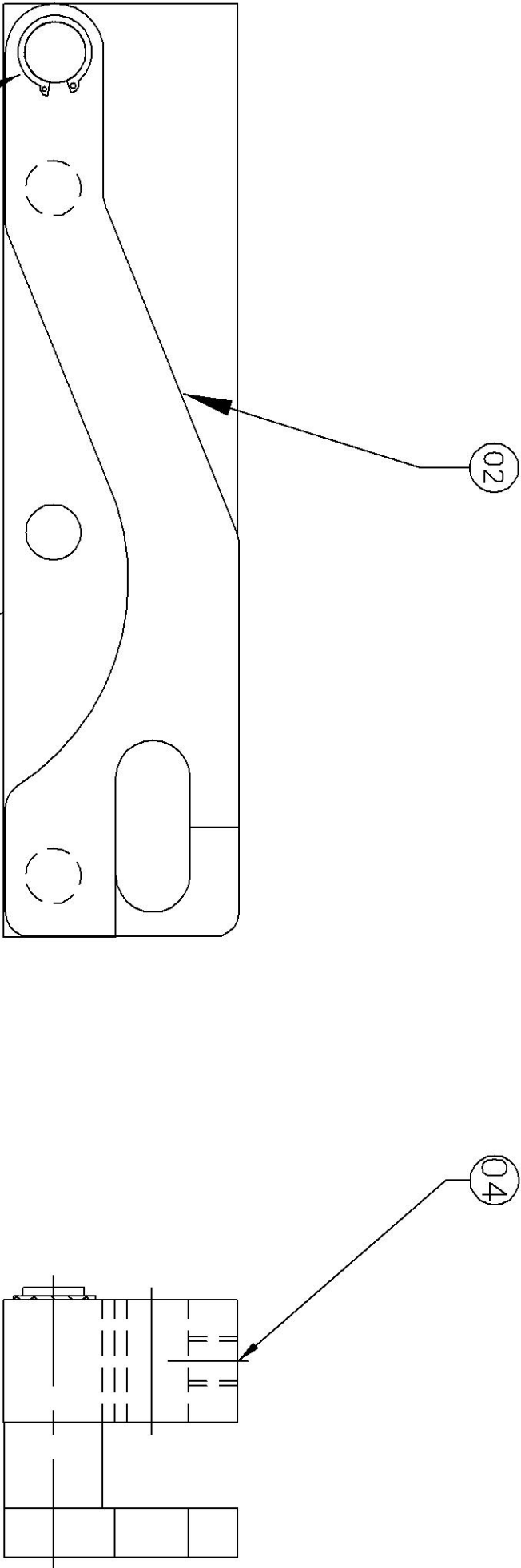
		JUL	793534
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[illegible]

RL	DATE	607 INDUSTRIAL WAY WEST, EATONTOWN, NJ 07724	✓	SHEET: 1/1
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S:\ACADDWGS\VDR\793534

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04	684800		BALL PLUNGER 1/2-13 X .75 LG W-7N		01
03	615716		RETAINING RING EXTERNAL 5/8" ID		01
02	79224901		GUIDE PISTON PUSHOUT		01
01	79224504		SUPPORT PISTON GUIDE OPERATORS SIDE		01
POS.	PART NO.	R/A NO.	DESCRIPTION		QTY.

BILL OF MATERIALS

VOR

PISTON PUSHOUT ASSY
OPERATORS SIDE

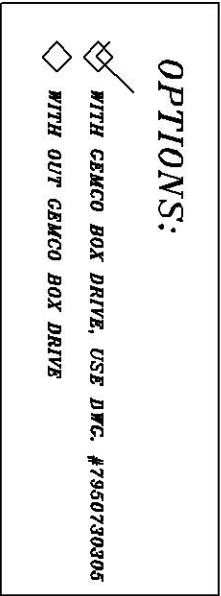
MACHINING TOLERANCES				SCALE		FULL		VOR	
FRACTIONAL:	X/X	±1/64"		DSN BY	W.K.				
DECIMAL:	X.X	±0.025"		DWN BY	T. DEWTO				
	X.XX	±0.015"		DATE	5/11/94				
	X.XXX	±0.005"		CHK					
ANGULAR:	X°	±0.5°							
BREAK SHARP CORNERS									
REMOVE ALL BURRS									
MACHINED SURFACES 63 RMS									
RL	DATE								

ADAMATIC
607 INDUSTRIAL WAY WEST, EATONTOWN, NJ 07724

SHEET	DRAWING NO.
SIZE	793535
C	SHEET: 1/1

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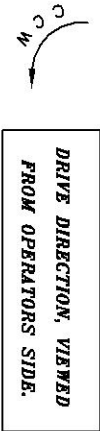
S:\ACADDMGS\VDR\793535



1) AT FINAL ASSEMBLY OF #12 COUPLING, DRILL
1/16" DIMPLE INTO #11 SHAFT FOR SET SCREW
USE BLUE LOCITITE #242

2) FILL GEAR BOX WITH PROPER OIL

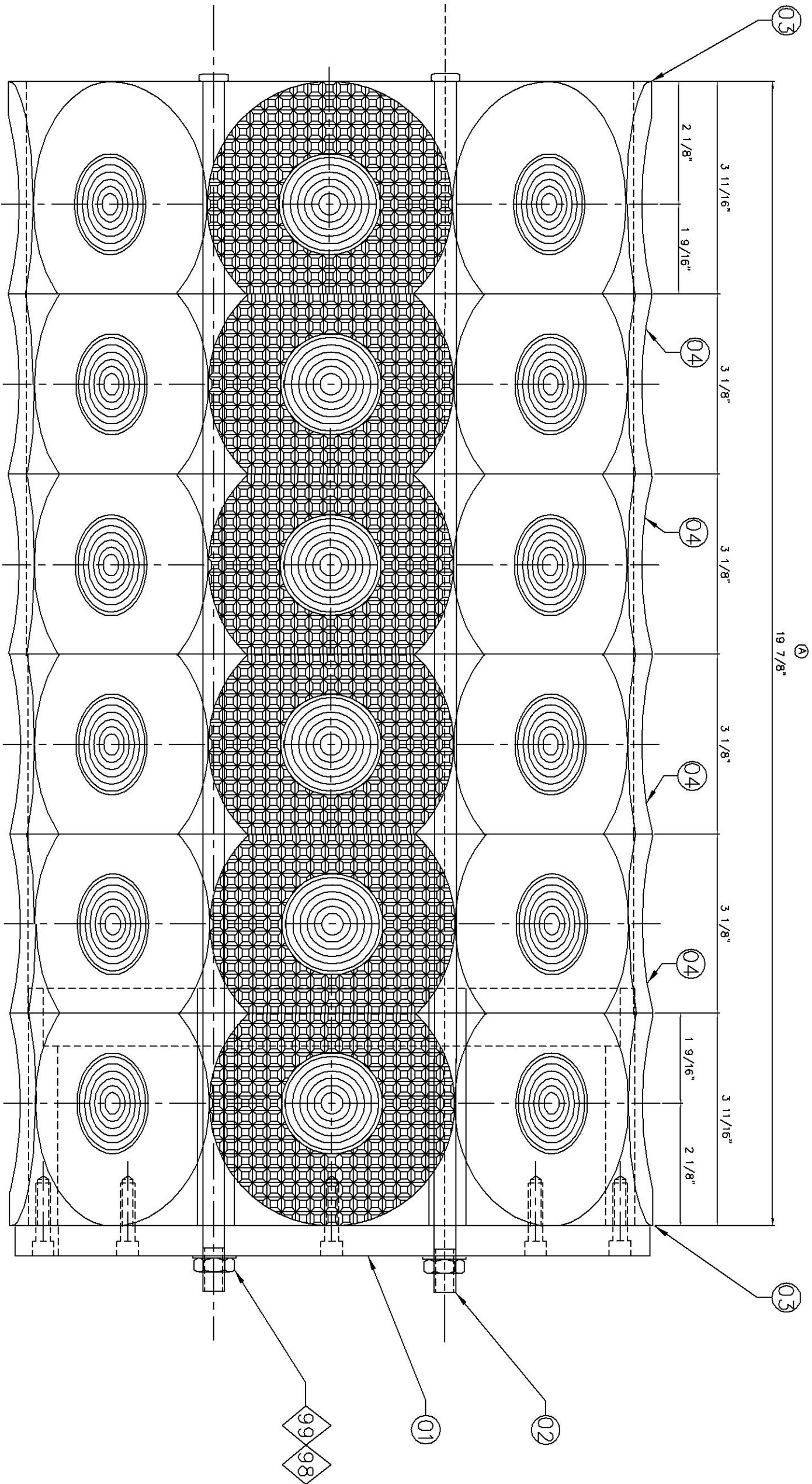
3) MODEL SHOWN IS CCM ROTATION



K:\ACADDWG\MRKDP\J1 CASSONE_2012\...

18		(REF)	ASSEMBLY	CONVEYOR # 2	(1)
17	79238208		DUST PAN CONVEYOR # 2		1
16	79238205		BRACKET DUST PAN		02
15	79238203		DUST PAN CONVEYOR # 2		01
14	79238204		DUST PAN CONVEYOR # 2		01
13	691433		INSERT NEOPRENE L 110		02
12	690688		COUPLING LOVEJOY L 110 1.500" BORE		02
11	79254401		SHAFT PROOFER DRIVE		01
10	61919302		REDUCER ASSEMBLY SPECIAL # 321 RATIO 20-1		02
09	686138		BEARING SFT 22 1.375" BORE		01
08	79254403		PLATE MOUNTING PROOFER DRIVE		01
07	792279		SH BUSHING 1.300" BORE		01
06	614681		HANDLE ALUM NRS500		01
05	792546		PULLEY TIMING 21H100 7/8" BORE		01
04	686586		PULLEY TIMING BELT #20H100		01
03	79254404		SPACER CEARBOX 3-3/8" LG		04
02	79254402		BRACKET SIDE PROOFER DRIVE		02
01	792543		FRAME WELDMENT PROOFER DRIVE		01
PART NO.		R/M NO.	DESCRIPTION		
QTY					

SCALE	1 : 8	MSDN (YDR)
DSN BY	RM	
DWN BY	T-GM	
DATE	10/6/12	
CHK		
ADAMATIC 607 INDUSTRIAL WAY WEST, EATONTOWN, NJ 07724 C		PROOFER DRIVE ASSEMBLY SHEET NO. DRAWING NO.
PL	DATE	SHEET SIZE 79354407M27
		SHEET: 1/1



S:\ACADDWCS\VDR\DRUMS\INNER\793574

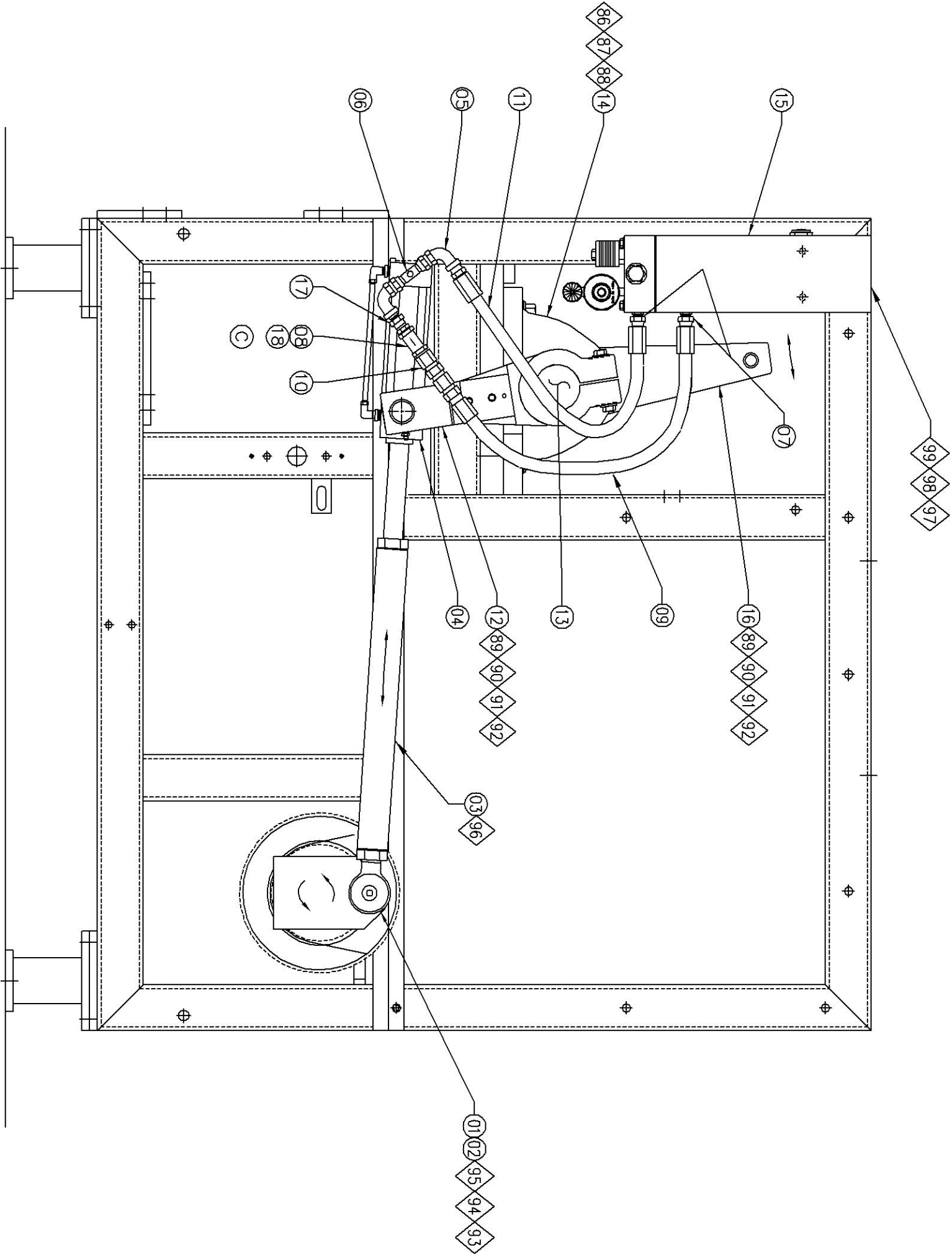
04	69083404	SEGMENT RING INNER ROUNDING DRUM 3.150"	04
03	69083403	SEGMENT RING INNER ROUNDING DRUM 3.718"	02
02	79357405	ROOT SEGMENT MOUNT INNER ROUNDING DRUM	04
01	79357401	INNER ROUNDING DRUM SUB - ASSEMBLY	01
POS.	PART NO.	E/AI NO.	DESCRIPTION
QTY.			

MACHINING TOLERANCES			FOR		
FRACTIONAL:	N/X	E/16"	INNER ROUNDING DRUM VDR		
DECIMAL:	X.X	±0.025"			
	X.XX	±0.015"			
	X.XXX	±0.005"	ADAMATIC		
ANGULAR:	X°	±0.5°			
BREAK SHARP CORNERS					
REMOVE ALL BURRS			D		
MACHINED SURFACES 63 RMS					
FILE	DATE				
	A 5/21/98		793574		
607 INDUSTRIAL WAY WEST, EASTONTOWN, NJ 07724					

○ = PARTS
◇ = HARDWARE

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ANY MEANS, ELECTRONIC OR MECHANICAL,
INCLUDING PHOTOCOPYING, RECORDING,
OR BY ANY INFORMATION STORAGE AND
RETRIEVAL SYSTEM. WE RESERVE THE RIGHT
TO MAKE NECESSARY CHANGES.

99	61376		SCREEN HMD CAP 5/16-18 X 23750" LONG	02
98	615028		WASHER FLAT SAE 0.312" ID ZP	02
97	614075		WASHER LOCK 0.312" ID ZP	02
96	B 797046		(REWORK #14482) NUT JAM HK 1.25-12 ZP	02
95	612284		SCREEN HMD CAP 3/8-16" X 1.250" LONG	02
94	615029		WASHER FLAT SAE 0.315" ID ZP	01
93	614078		WASHER LOCK 0.315" ID ZP	01
92	613122		SCREEN HMD CAP 1/2-13 X 1.750" LONG	02
91	615030		WASHER FLAT SAE 0.300" ID ZP	02
90	613673		WASHER LOCK 0.300" ID ZP	04
89	612153		NUT HK 1/2-13 QNS ZP	04
88	792356		SCREEN HMD CAP 7/8-9 X 3.00" QNS ZP	04
87	795532		WASHER FLAT SAE 0.875" ID ZP	04
86	792357		WASHER LOCK 0.875" ID ZP	04



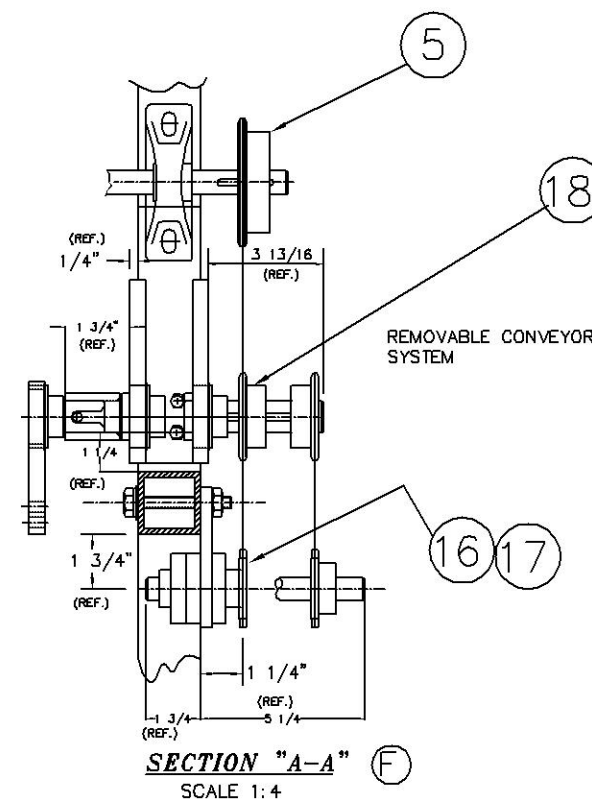
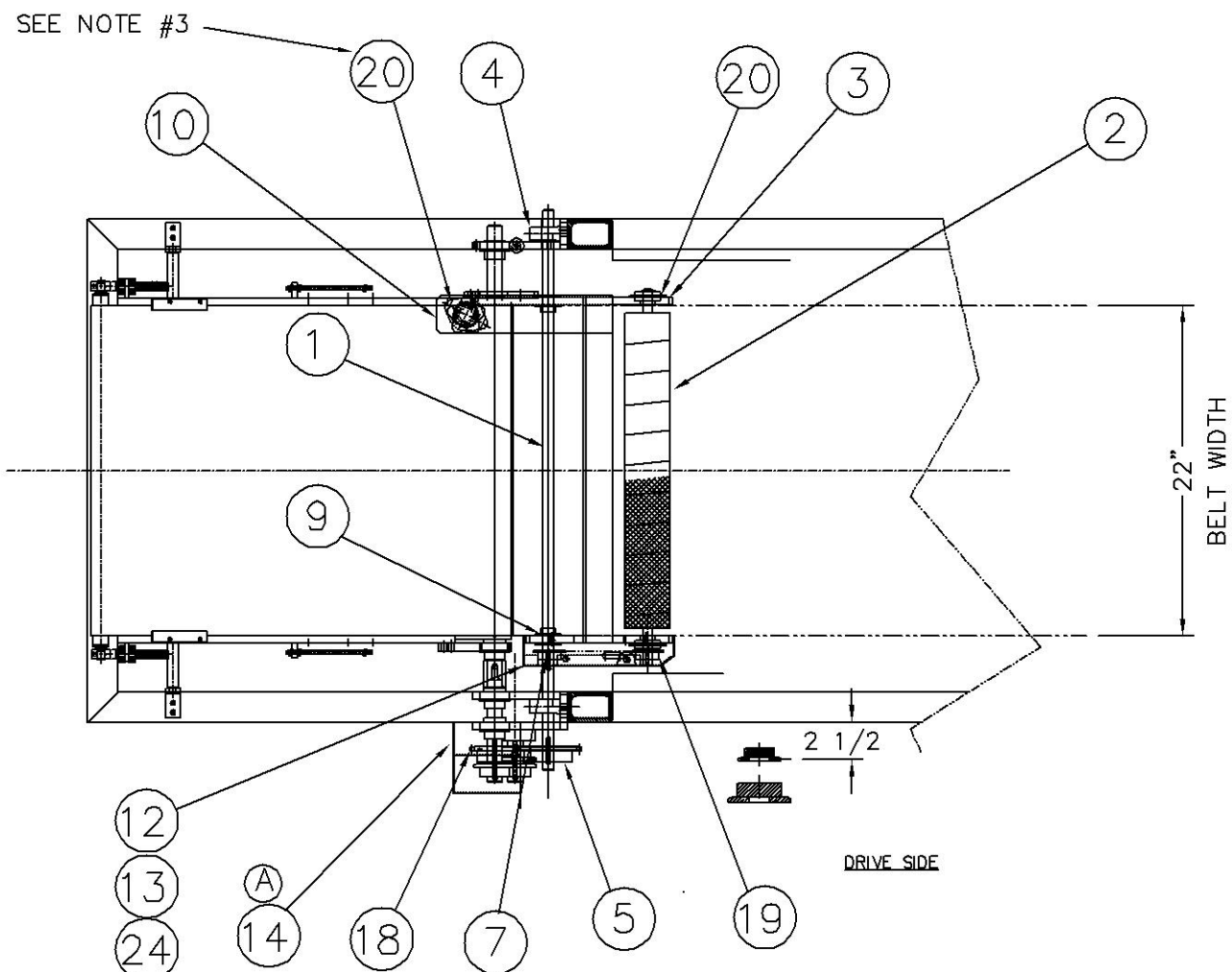
NOTES.
FILL WITH BEL-RAY RAYLENE AW #0 HYDRAULIC FLUID.
TO CENTER LINE OF SIGHT GAGE. (1 GALLON REF.)

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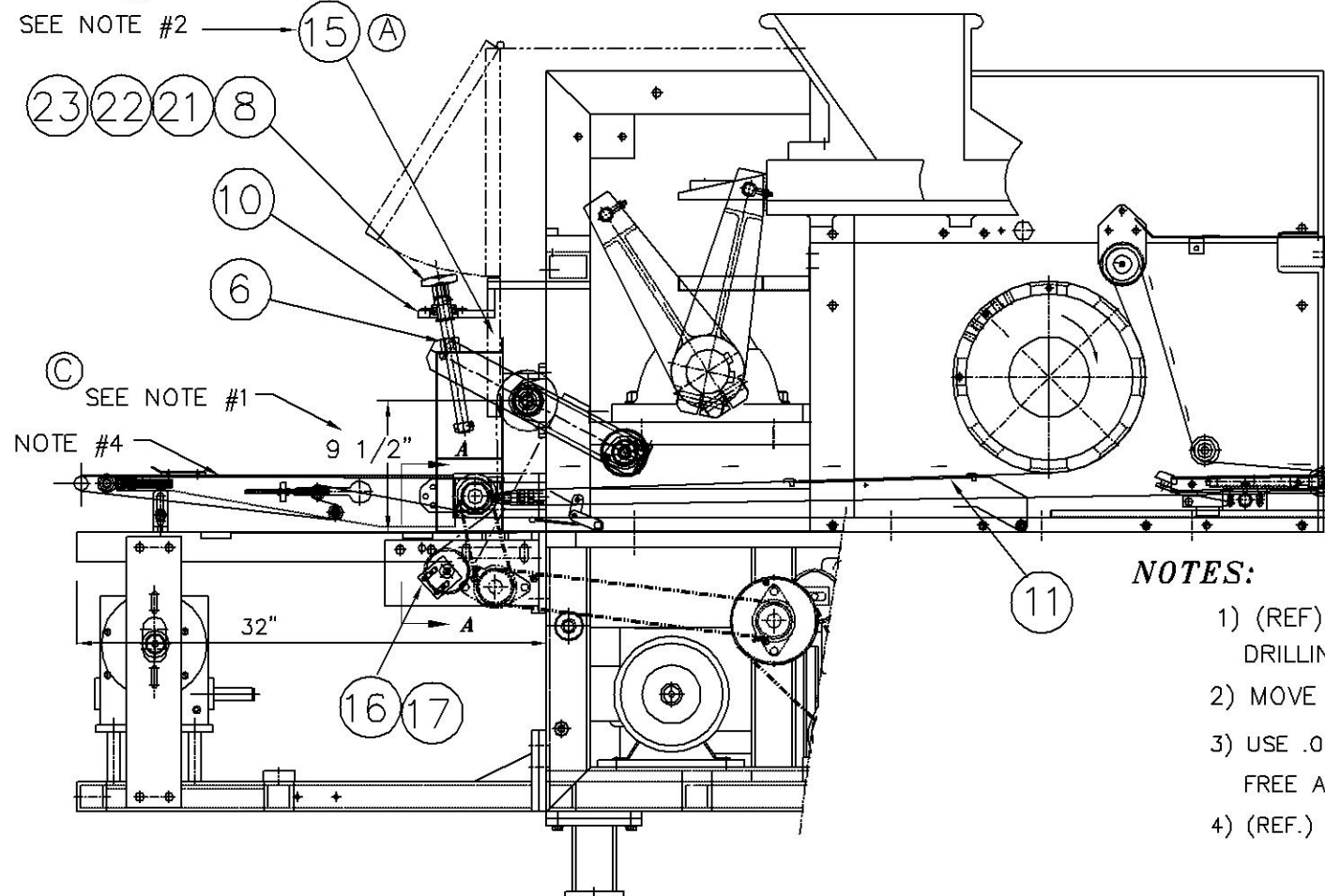
MACHINING TOLERANCES				SCALE				VDR			
FRACTIONAL:	N/A	±1/64"		OSN BY	T	DEV'D		HYDRAULIC ASSEMBLY VDR			
DECIMAL:	X.X	±0.025"		OWN BY	T	DEV'D					
	X.XX	±0.015"		DATE	6/22/94	CHK					
	X.XXX	±0.005"						ADAMATIC			
ANGULAR:	X°	±0.5°		C	10/09/02						
BREAK SHARP CORNERS				B	9/22/00						
REMOVE ALL BURS				A	11/26/94			SHEET 17/			
MACHINED SURFACES 63 RMS				RL	DATE						
607 INDUSTRIAL WAY WEST, EATONTOWN, NJ 07724				D				SHEET: 17/			

S:\ACAD\DWGCS\VDR\793717

18	795404		ORING .085 X 1.116" (PARKER # 3-308)	01
17	691237		ADAPTER	01
16	7921201		PIVOT ARM UPPER	01
15	793346		HYDRAULIC UNIT ASSEMBLY	01
14	792257		BEARING PULOE BLOCK 300" HP - 48	02
13	79214801		SHAFT PIVOT ARM	01
12	79214702		PIVOT ARM LOWER	01
11	691250		HYD HOSE ASSEMBLY FEMALE JC - FEMALE -JC	01
10	691236		COUPLING FEMALE -8 - FEMALE -8	01
09	691153		HYD HOSE ASSEMBLY 28" LONG 1/2" JC (F) X SAE-8 (M)	01
08	690964		INLINE CHECK VALVE HYD.	02
07	691249		ADAPTER MALE 1/2" NPT X MALE JC	01
06	690962		TIE BRANCH STRAIGHT THREAD - PARKER	02
05	690963		ELBOW 90° NUT	02
04	793587		CYLINDER HYDRAULIC REWORK - HEAVY DUTY MTH HH	01
03	792262		CONNECTING ROD PIVOT ARM	01
02	79226101		WASHER, CRANK	01
01	613056		BEARING, ROD END TIE-16N SEAL MASTER	01
POS.	PART NO.	R/A	NO.	QTY.
BILL OF MATERIALS				



REF: - FOR DRIVE AND CONVEYOR
INFORMATION SEE ASSY (# 79577007 M.P.)



NOTES:

- 1) (REF) CHECK @ ASSY BEFORE DRILLING HOLES FOR BEARINGS
- 2) MOVE INTERLOCK SW TO DRV SIDE
- 3) USE .015 SHIMS BETWEEN FLANGES TO FREE ANGULAR MOTION AFTER MOUNTING BEARING.
- 4) (REF.) #2 CONVEYOR FINGER BELT (# 79510618)

MFG COPY

CUSTOMER: HIGHLAND BKY

PURCH ORDER NO.:

SHOP ORDER NO.:

EDP ORDER NO.: 198700

EQP USED ON: VDR

QUANTITY: 1

DATE RELEASED: 7/12/06

MAKE: BUY:

MACHINING TOLERANCES			
FRACTIONAL:	X/X	±1/64"	
DECIMAL:	X.X	±0.025"	
	X.XX	±0.015"	
	X.XXX	±0.005"	
	X"	±0.5"	
ANGULAR:	X°		
BREAK SHARP CORNERS			
REMOVE ALL BURRS			
MACHINED SURFACES 63 RMS			

MACHINING TOLERANCES			
FRACTIONAL:	X/X	±1/64"	
DECIMAL:	X.X	±0.025"	
	X.XX	±0.015"	
	X.XXX	±0.005"	
	X"	±0.5"	
ANGULAR:	X°		
BREAK SHARP CORNERS			
REMOVE ALL BURRS			
MACHINED SURFACES 63 RMS			

MACHINING TOLERANCES			
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	X.XX	±0.015"	
	X.XXX	±0.005"	
	X"	±0.5"	
ANGULAR:	X°		
BREAK SHARP CORNERS			
REMOVE ALL BURRS			
MACHINED SURFACES 63 RMS			

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BREAK SHARP CORNERS			
REMOVE ALL BURRS			
MACHINED SURFACES 63 RMS			

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REMOVE ALL BURRS			
MACHINED SURFACES 63 RMS			

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MACHINED SURFACES 63 RMS			

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MACHINED SURFACES 63 RMS			

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MACHINED SURFACES 63 RMS			

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	X.XXX	±0.005"	
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REMOVE ALL BURRS			
MACHINED SURFACES 63 RMS			

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	X.XXX	±0.005"	
	X"	±0.5"	
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BREAK SHARP CORNERS			
REMOVE ALL BURRS			
MACHINED SURFACES 63 RMS			

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REMOVE ALL BURRS			
MACHINED SURFACES 63 RMS			

MACHINING TOLERANCES			
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	X.XX	±0.015"	
	X.XXX	±0.005"	
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REMOVE ALL BURRS			
MACHINED SURFACES 63 RMS			

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	X.XX	±0.015"	
	X.XXX	±0.005"	
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REMOVE ALL BURRS			
MACHINED SURFACES 63 RMS			

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	X.XXX	±0.005"	
	X"	±0.5"	
ANGULAR:	X°		
BREAK SHARP CORNERS			
REMOVE ALL BURRS			
MACHINED SURFACES 63 RMS			

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	X.XXX	±0.005"	
	X"	±0.5"	
ANGULAR:	X°		
BREAK SHARP CORNERS			
REMOVE ALL BURRS			
MACHINED SURFACES 63 RMS			

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FRACTIONAL:	X/X	±1/64"	
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	X.XXX	±0.005"	
	X"	±0.5"	
ANGULAR:	X°		
BREAK SHARP CORNERS			
REMOVE ALL BURRS			
MACHINED SURFACES 63 RMS			

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MACHINED SURFACES 63 RMS			

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	X.XXX	±0.005"	
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ANGULAR:	X°		
BREAK SHARP CORNERS			
REMOVE ALL BURRS			
MACHINED SURFACES 63 RMS			

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FRACTIONAL:	X/X	±1/64"	
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	X.XX	±0.015"	
	X.XXX	±0.005"	
	X"	±0.5"	
ANGULAR:	X°		
BREAK SHARP CORNERS			
REMOVE ALL BURRS			
MACHINED SURFACES 63 RMS			

MACHINING TOLERANCES			
FRACTIONAL:	X/X	±1/64"	
DECIMAL:	X.X	±0.025"	
	X.XX	±0.015"	
	X.XXX	±0.005"	
	X"	±0.5"	
ANGULAR:	X°		
BREAK SHARP CORNERS			
REMOVE ALL BURRS			
MACHINED SURFACES 63 RMS			

MACHINING TOLERANCES			
FRACTIONAL:	X/X	±1/64"	
DECIMAL:	X.X	±0.025"	
	X.XX	±0.015"	
	X.XXX	±0.005"	
	X"	±0.5"	
ANGULAR:	X°		
BREAK SHARP CORNERS			
REMOVE ALL BURRS			
MACHINED SURFACES 63 RMS			

MACHINING TOLERANCES			
FRACTIONAL:	X/X	±1/64"	
DECIMAL:	X.X	±0.025"	
	X.XX	±0.015"	
	X.XXX	±0.005"	
	X"	±0.5"	
ANGULAR:	X°		
BREAK SHARP CORNERS			
REMOVE ALL BURRS			
MACHINED SURFACES 63 RMS			

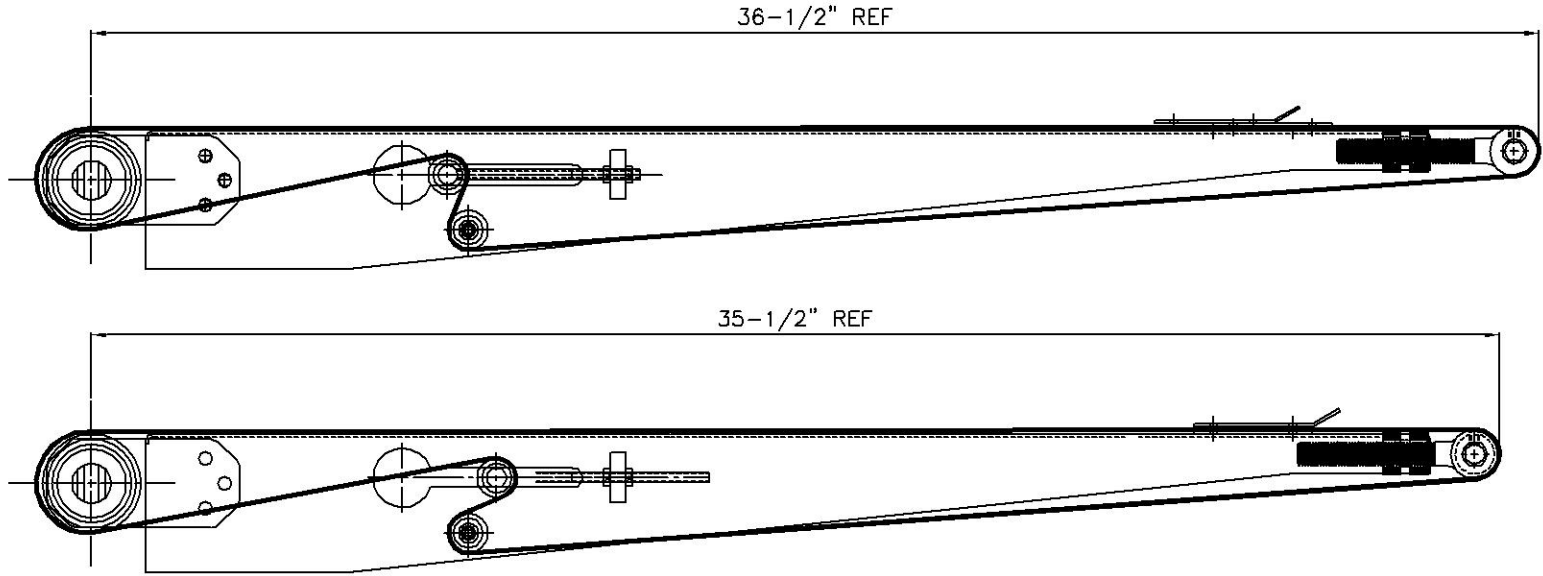
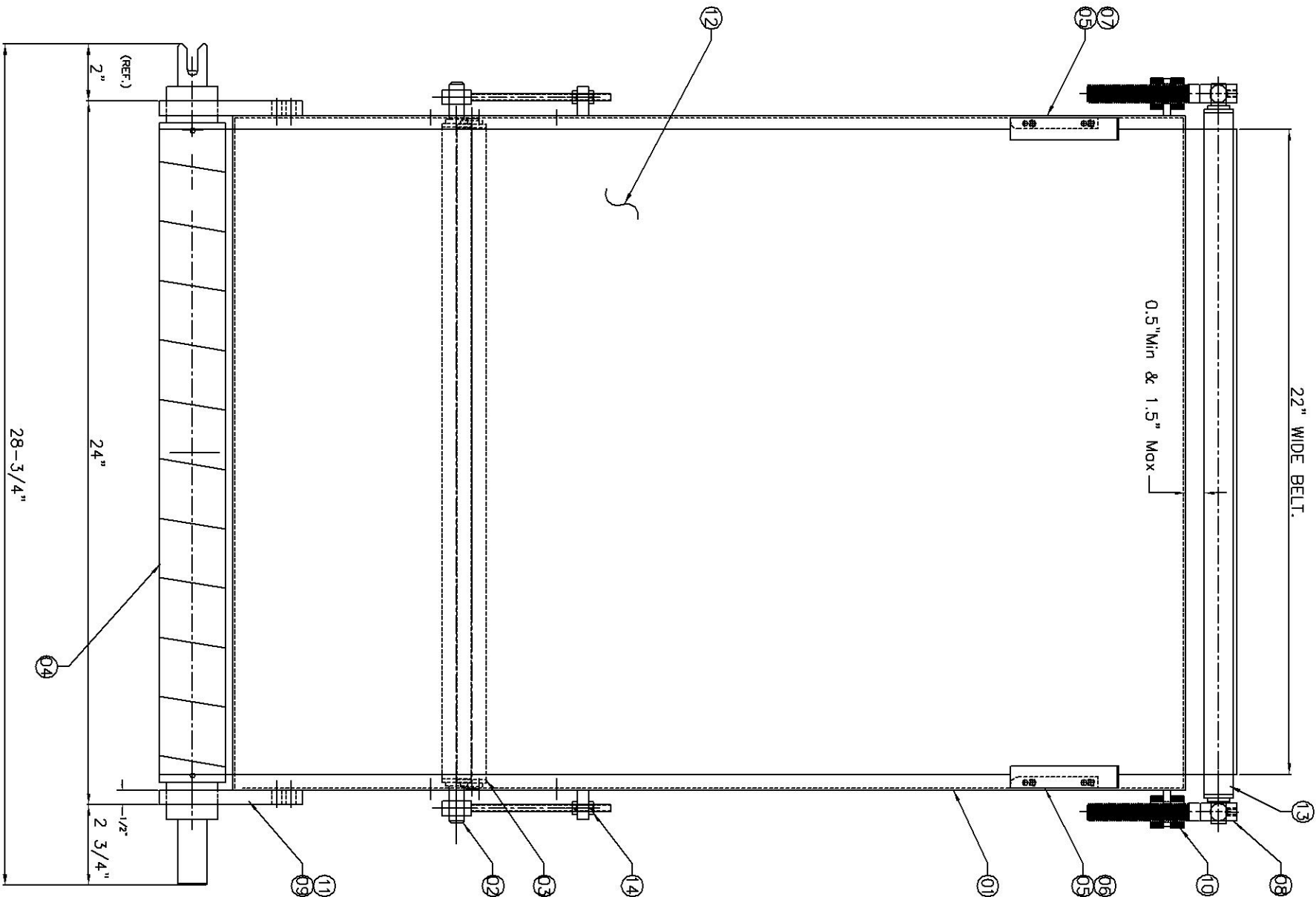
MACHINING TOLERANCES			
FRACTIONAL:	X/X	±1/64"	
DECIMAL:	X.X	±0.025"	
	X.XX	±0.015"	
	X.XXX	±0.005"	
	X"	±0.5"	
ANGULAR:	X°		
BREAK SHARP CORNERS			
REMOVE ALL BURRS			
MACHINED SURFACES 63 RMS			

MACHINING TOLERANCES			
FRACTIONAL:	X/X	±1/64"	
DECIMAL:	X.X	±0.025"	
	X.XX	±0.015"	
	X.XXX	±0.005"	
	X"	±0.5"	
ANGULAR:	X°		
BREAK SHARP CORNERS			
REMOVE ALL BURRS			
MACHINED SURFACES 63 RMS			

MACHINING TOLERANCES			
FRACTIONAL:	X/X	±1/64"	
DECIMAL:	X.X	±0.025"	
	X.XX	±0.015"	
	X.XXX	±0.005"	
	X"	±0.5"	
ANGULAR:	X°		
BREAK SHARP CORNERS			
REMOVE ALL BURRS			
MACHINED SURFACES 63 RMS			

MACHINING TOLERANCES			
FRACTIONAL:	X/X	±1/64"	
DECIMAL:	X.X	±0.025"	
	X.XX	±0.015"	
	X.XXX	±0.005"	
	X"	±0.5"	
ANGULAR:	X°		
BREAK SHARP CORNERS			
REMOVE ALL BURRS			
MACHINED SURFACES 63 RMS			

MACHINING TOLERANCES		
FRACTIONAL:	X/X	±1/64
DECIMAL:	X.X	±0.02
	X.XX	±0.01
	X.XXX	±0.005
ANGULAR:	X°	±0.5°
BREAK SHARP CORNERS		
REMOVE ALL BURRS		
MACHINED SURFACES 63 RMS		



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14	61796503		TAKE UP SHAFT ROD 3/8-16	02
13	79239604		IDLER ROLLER ASSEMBLY	01
12	79254222		BELT ENDLESS 22" W X 81" LG	01
11	7958996		BEARING BALL BR-16T (1")	02
10	613143		NUT KNURED KNS	04
09	79589702		BRAKET ROLLER (NEW STYLE BEARING)	02
08	61796502		MOUNT ROLLER SHAFT	02
07	612800		UPPER GUIDE PLATE RH	01
06	612801		UPPER GUIDE PLATE LH	01
05	613178		LOWER GUIDE PLATE	02
04	79572101		ROLLER DRIVE ASSEMBLY 2 1/4 DIA W/LAGGING	01
03	795730		IDLER ROLLER ASSEMBLY	01
02	79572301		TAKE-UP ROLLER ASSEMBLY	01
01	79572007M27		FRAME WELDMENT # 02 CONVEYOR	01
POS.	PART NO.	R/A NO.	DESCRIPTION	QTY.

BILL OF MATERIALS		
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MACHINING TOLERANCES		WOR	
FRACTIONAL:	X/X	±1/64"	
DECIMAL:	X.X	±0.025"	
	X.XX	±0.015"	
	X.XXX	±0.005"	
ANGULAR:	X°	±0.5°	
BREAK SHARP CORNERS			
REMOVE ALL BURRS			
MACHINED SURFACES 63 RMS			

ADAMATIC

607 INDUSTRIAL WAY WEST, EATONTOWN, NJ 07724

CONVEYOR # 2

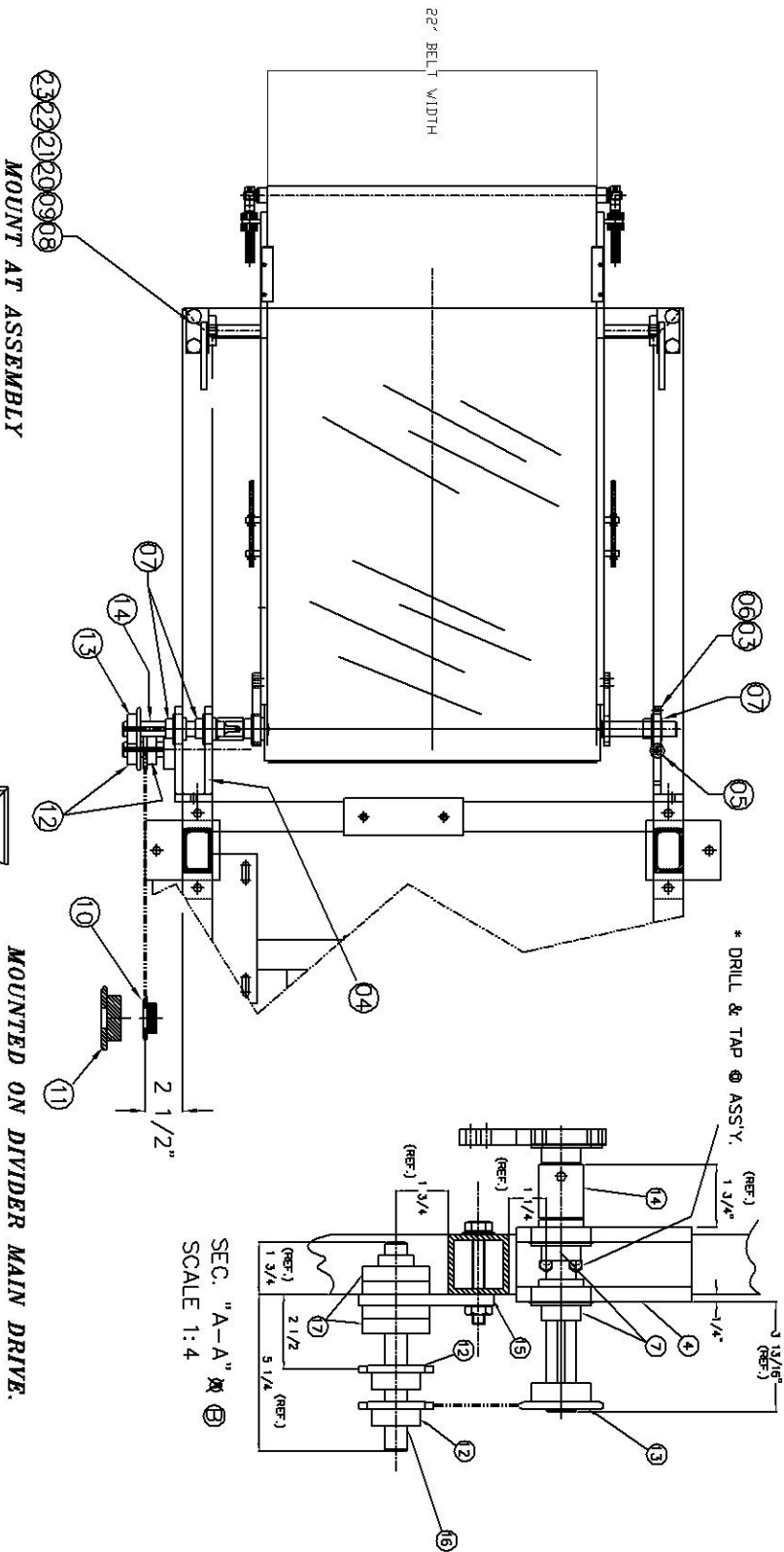
WITH TAKE-UP

SHEET 1

DRAWING NO. 79573207M27

D

SHEET: 1/1

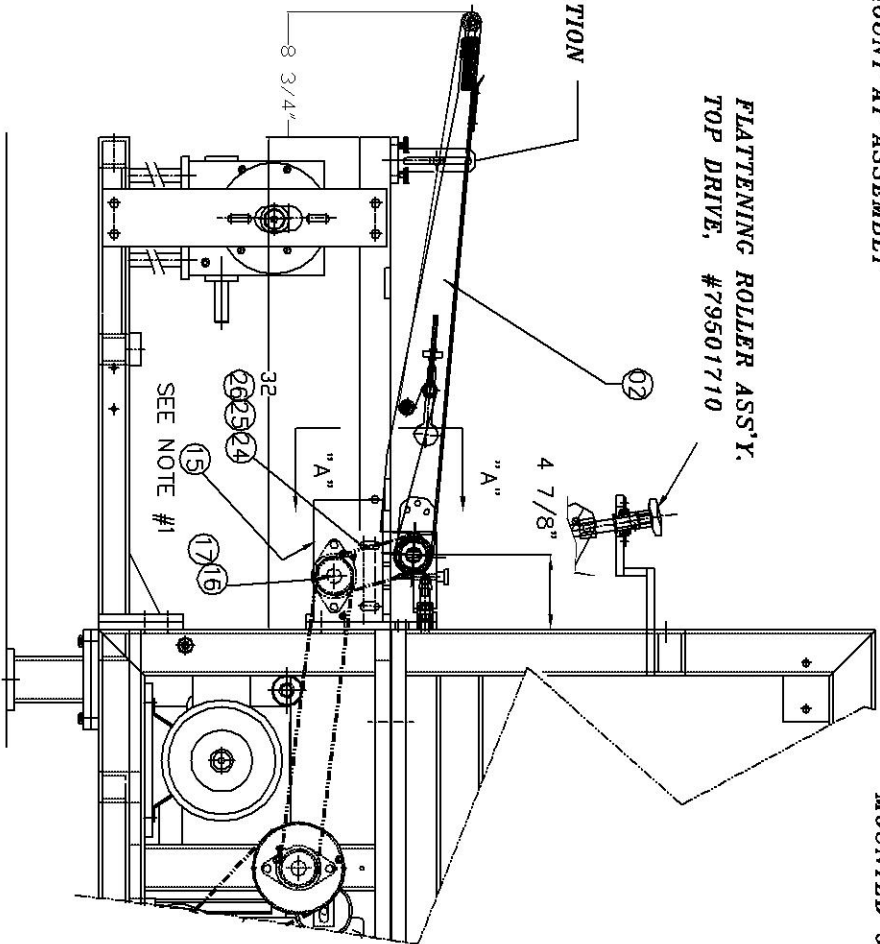


23221200908
MOUNT AT ASSEMBLY

MOUNTED ON DIVIDER MAIN DRIVE.

FLATTENING ROLLER ASS'Y.
TOP DRIVE, #79501710

SEE ENGINEERING FOR LOCATION



MARKED PRINT

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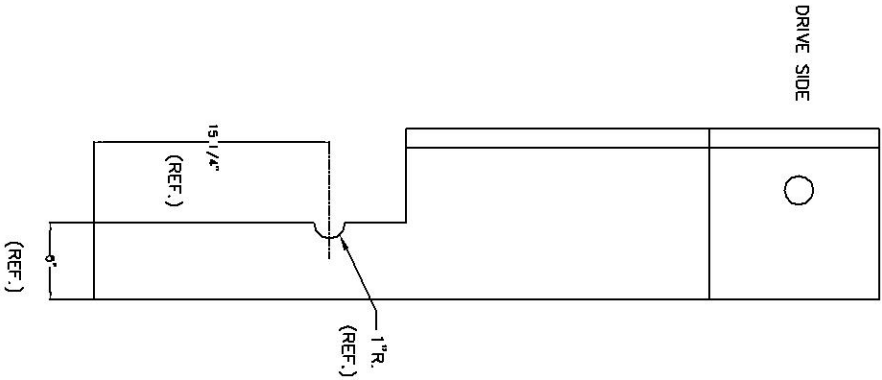
MACHINING TOLERANCES		
FRACTIONAL:	X/X	±1/64"
DECIMAL:	X.X	±0.025"
	X.XX	±0.015"
	X.XXX	±0.005"
ANGULAR:	X°	±0.5°
	BREAK SHARP CORNERS	
	REMOVE ALL BURRS	
	MACHINED SURFACES 63 RMS	

POS.	PART NO.	R/A NO.	DESCRIPTION	QTY.
26	610484		LINK CHAIN OFFSET ANSI 40	02
25	684677		LINK CHAIN CONNECTION ANSI 40	02
24	610483		CHAIN SINGLE STRAND # 40 STD	65"
23	68434801		HANDLE ADJUSTABLE	2
22	614075		WASHER LOCK 5/16	2
21	612264		WASHER FLAT 5/16	2
20	627415		KNOB, REWORK (SKA-7) 5/16-18	2
19				
18				
17	615177		FLANGE BEARING SFT-12, .750" Ø SHAFT	2
16	796438		JACK SHAFT .750" Ø	1
15	79643701		BRACKET SUPPORT	1
14	61074022		COUPLING, DRIVE SHAFT 1" Ø	1
13	684517		SPROCKET 40B14, 1.00" BORE W/ KW & SS	1
12	796441		SPROCKET 40B14, .750" BORE W/ KW & SS	2
11	612364		SPROCKET 40B30, 1.00" BORE W/ KW & SS	1
10	689999		SPROCKET 40B20, 1.00" BORE W/ KW & SS	1
09	79239612		SHAFT HEIGHT ADJUSTMENT	1
08	79239611		BRACKET HEIGHT ADJUSTMENT	2
07	795898		BEARING BALL BR-16T (1" SHAFT)	3
06	610497		LINK CHAIN CONNECTION # 50	1
05	613119		KNOB 5/16-18 THD	1
04	79573501		BRACKET CONVEYOR MOUNT DRIVE SIDE	1
03	79573401		BRACKET CONVEYOR MOUNT OPER. SIDE	1
02	79573207M27		CONVEYOR ASS'Y FLAT BELT W/ TAKE-UP, Z" ROLLER	1
01				

SCALE	1:8	VDR
DSN BY	RLM	
DMW BY	T-RAO	
DATE	09/27/12	
CHK		

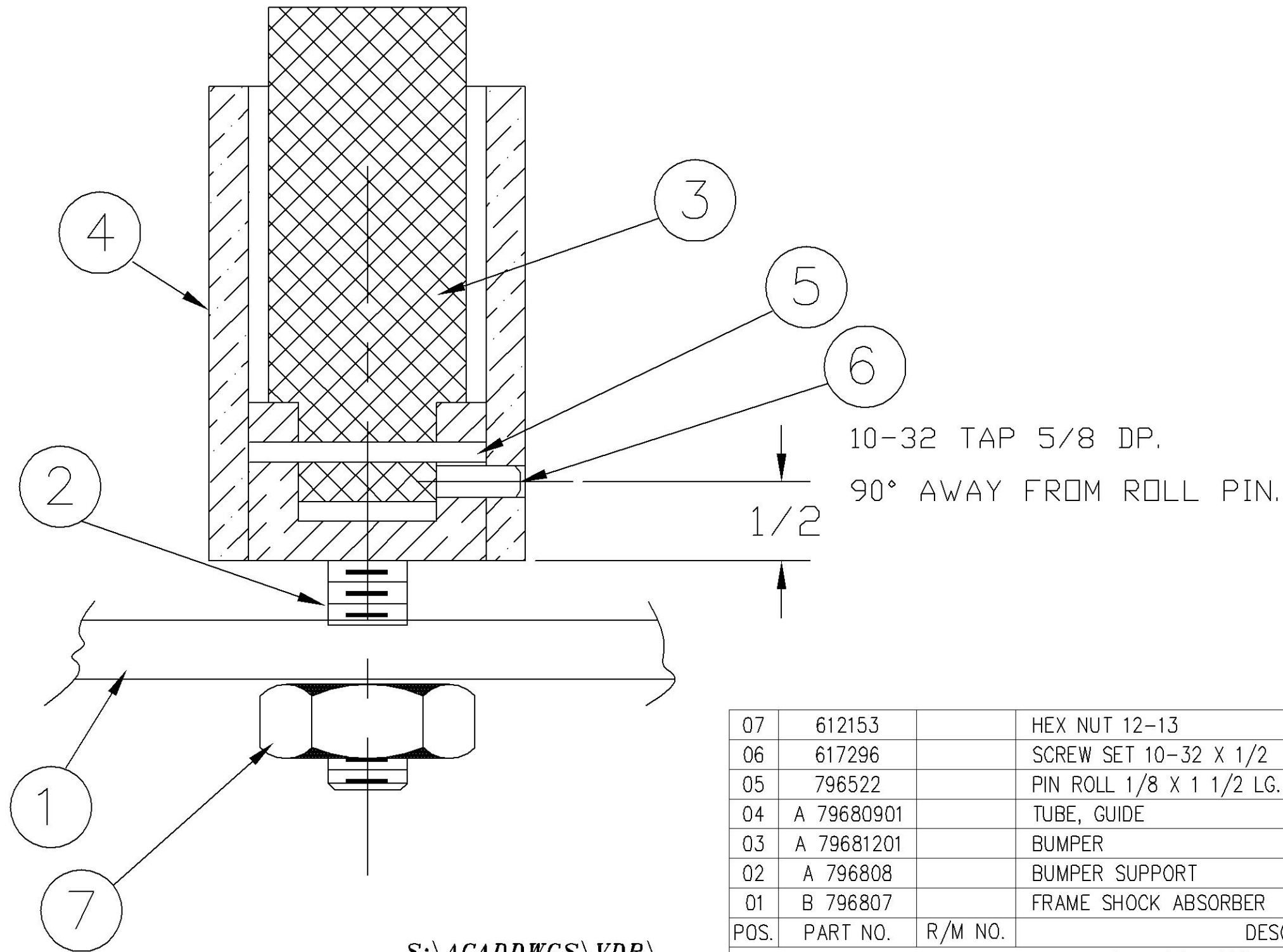
CONVEYOR ASSEMBLY FLAT BELT	SHEET 9ZE	DRAWING NO. 79577001M27
ADAMATIC	C	SHEET: 1/1

607 INDUSTRIAL WAY WEST, EATONTOWN, NJ 07724



NOTE:
REWORK COVERS TO DIM. SHOWN
TO CLEAR JACK SHAFT.
(REF. TO COVER DWG.#793641)

K:\ACAD\DWGS\MRKDP\PRINT\JJ Cassone_2012\...



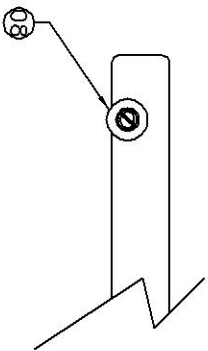
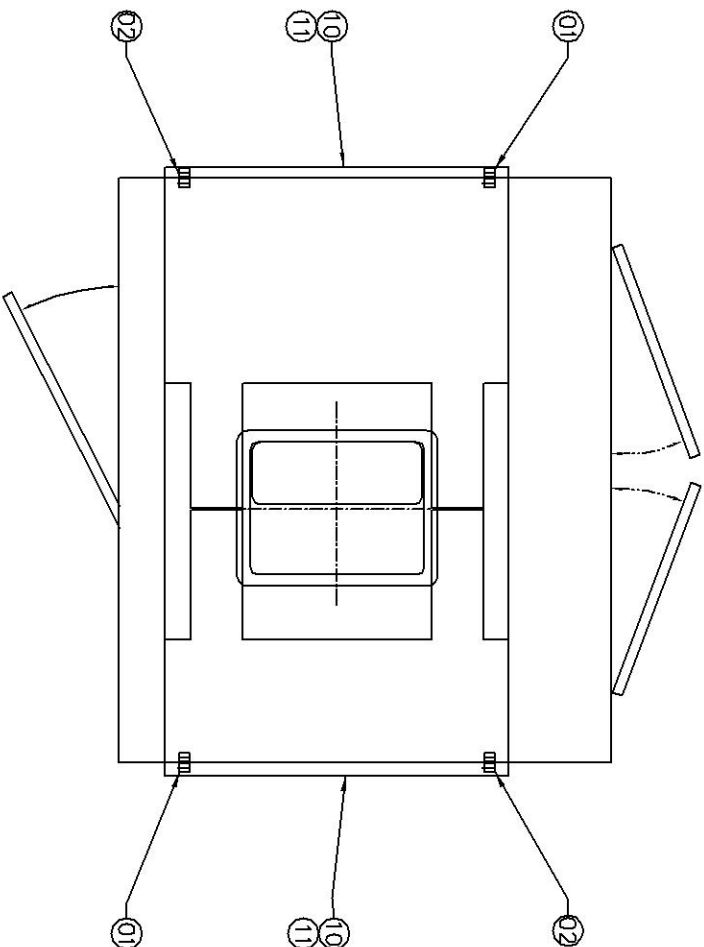
07	612153		HEX NUT 12-13	1
06	617296		SCREW SET 10-32 X 1/2	1
05	796522		PIN ROLL 1/8 X 1 1/2 LG.	1
04	A 79680901		TUBE, GUIDE	1
03	A 79681201		BUMPER	1
02	A 796808		BUMPER SUPPORT	1
01	B 796807		FRAME SHOCK ABSORBER	1
POS.	PART NO.	R/M NO.	DESCRIPTION	QTY.

S:\ACADDWGS\VDR\

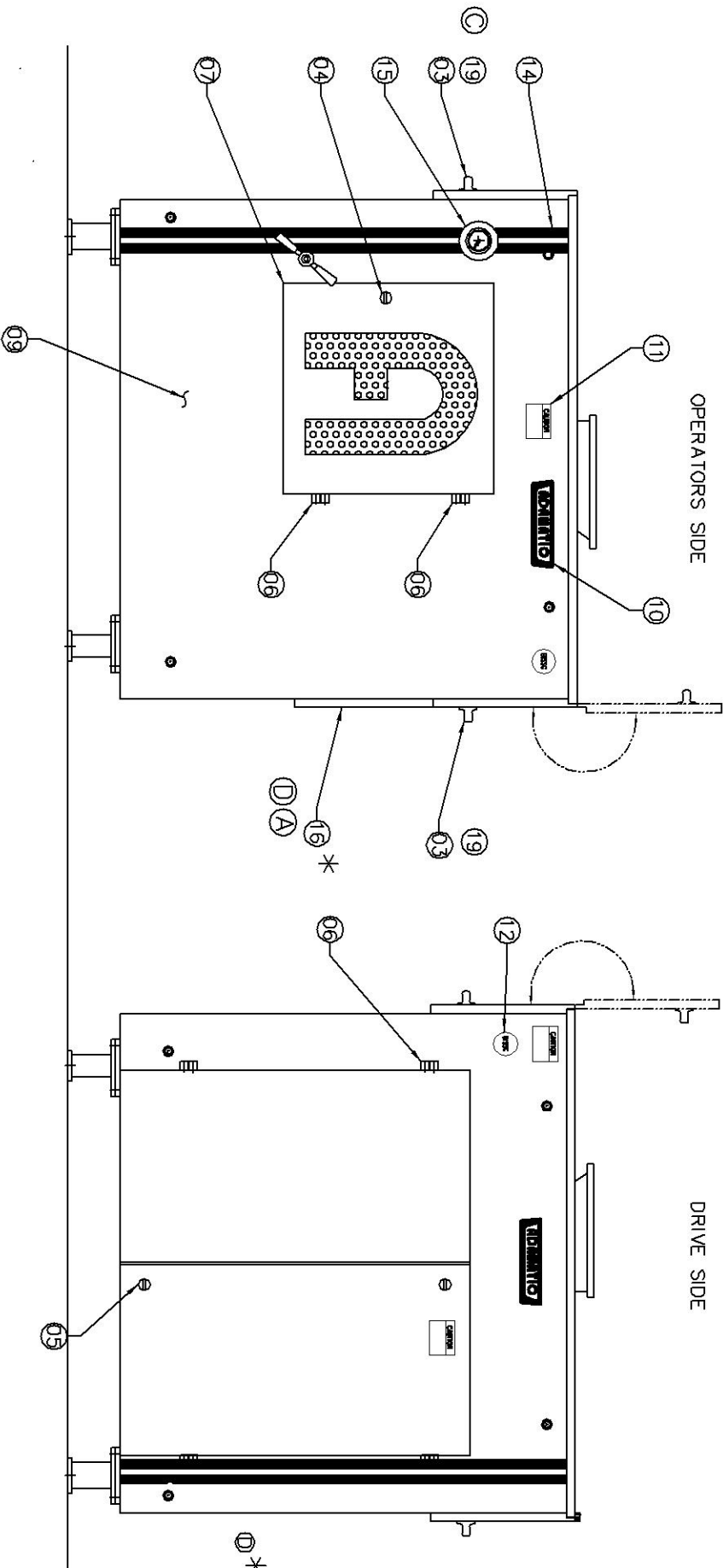
MACHINING TOLERANCES		
FRACTIONAL:	X/X	±1/64"
DECIMAL:	X.X	±0.025"
	X.XX	±0.015"
	X.XXX	±0.005"
ANGULAR:	X°	±0.5°
BREAK SHARP CORNERS		
REMOVE ALL BURRS		
MACHINED SURFACES 63 RMS		

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BILL OF MATERIALS						
		SCALE	FULL	VDR		
		DSN BY		SHOCK ABSORBER ASS'Y.		
		DWN BY	M.A.			
		DATE	8-11-04			
		CHK				
		ADAMATIC 607 INDUSTRIAL WAY WEST, EATONTOWN, NJ 07724			SHEET SIZE	DRAWING NO.
					A	79680601
						SHEET: 1/1
RL	DATE					



WHEEL TRACK , TOP COVERS.
18 19 TRACKS – NOT SHOWN



* VDR'S W/FLATTENING ROLLERS SEE
FLATTENING ROLLER ASSY. FOR COVER NO.

S:\ACAD\DWGS\VDR\...

19	794006	(REF.)	LATCH, COVER (NOT SHOWN) SEE ASSY # 793437, ITEM 25	(02)
18	79364149		COVER TRACK, OPERATOR SIDE (NOT SHOWN)	01
17	79364143		COVER TRACK, DRIVE SIDE (NOT SHOWN)	01
16	796596		COVER – FRONT VDR SAFETY COVERS	01
15	691483		HANDLE WEIGHT ADJUSTMENT	01
14	691453		TAPE BLUE 2-STRIPS , 120" LONG	01
13	617231		NUT ACORN 1/2-13"	08
12	690989		LABEL BISSC CERTIFIED	02
11	691452		LABEL CAUTION	04
10	690437		NAME PLATE	04
09	793641		COVERS VDR COMPLETE SET	01
08	794002		WHEEL SS TOP COVER	04
07	79253706		COVER INNER DOOR	01
06	794000		HINGE IN-LINE	06
05	794005		LATCH ACCESS DOORS	02
04	793989		LATCH DOOR OPERATORS SIDE	01
03	614681		HANDLE ALUM IN65000	02
02	794001		HINGE DOOR OFFSET	02
01	793788		OFFSET HINGE	02
POS.	PART NO.	R/A NO.	DESCRIPTION	QTY.

BILL OF MATERIALS

SCALE	1:12	VDR
DSN BY	T. DEMIO	COVER
DWN BY	T. DEMIO	ASSEMBLY
DATE	12/10/95	
CHK		

ADAMATIC

607 INDUSTRIAL WAY WEST, EATONTOWN, NJ 07724

ROBART COMPANY

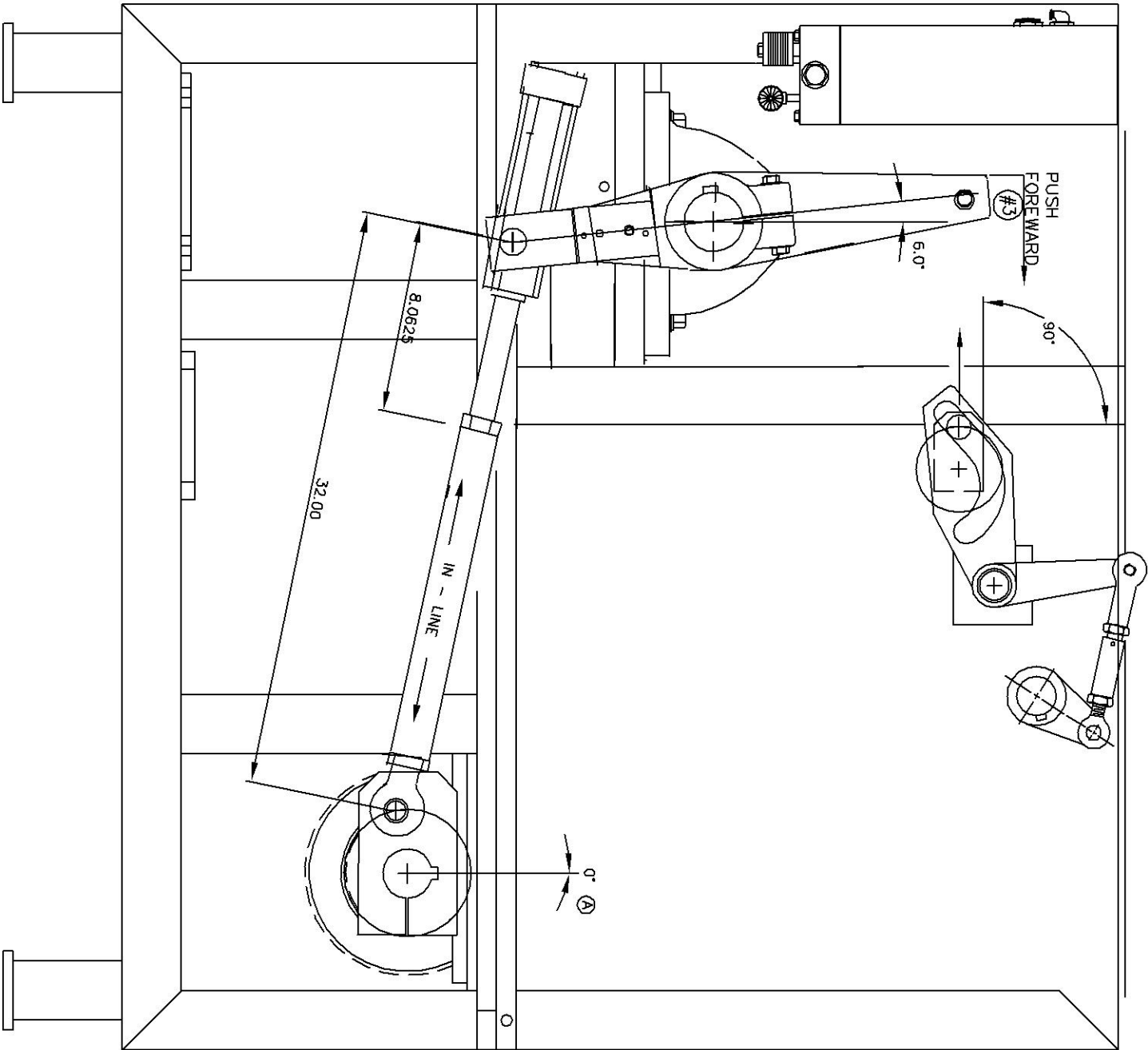
C

DRAWING NO. 797051

SHEET 1/1

COVERS SHOWN ARE FOR A STANDARD VDR.
PROOFER DRIVE IS OPTIONAL FOR THIS
MACHINE AND NOT INCLUDED IN THIS ASSEMBLY.

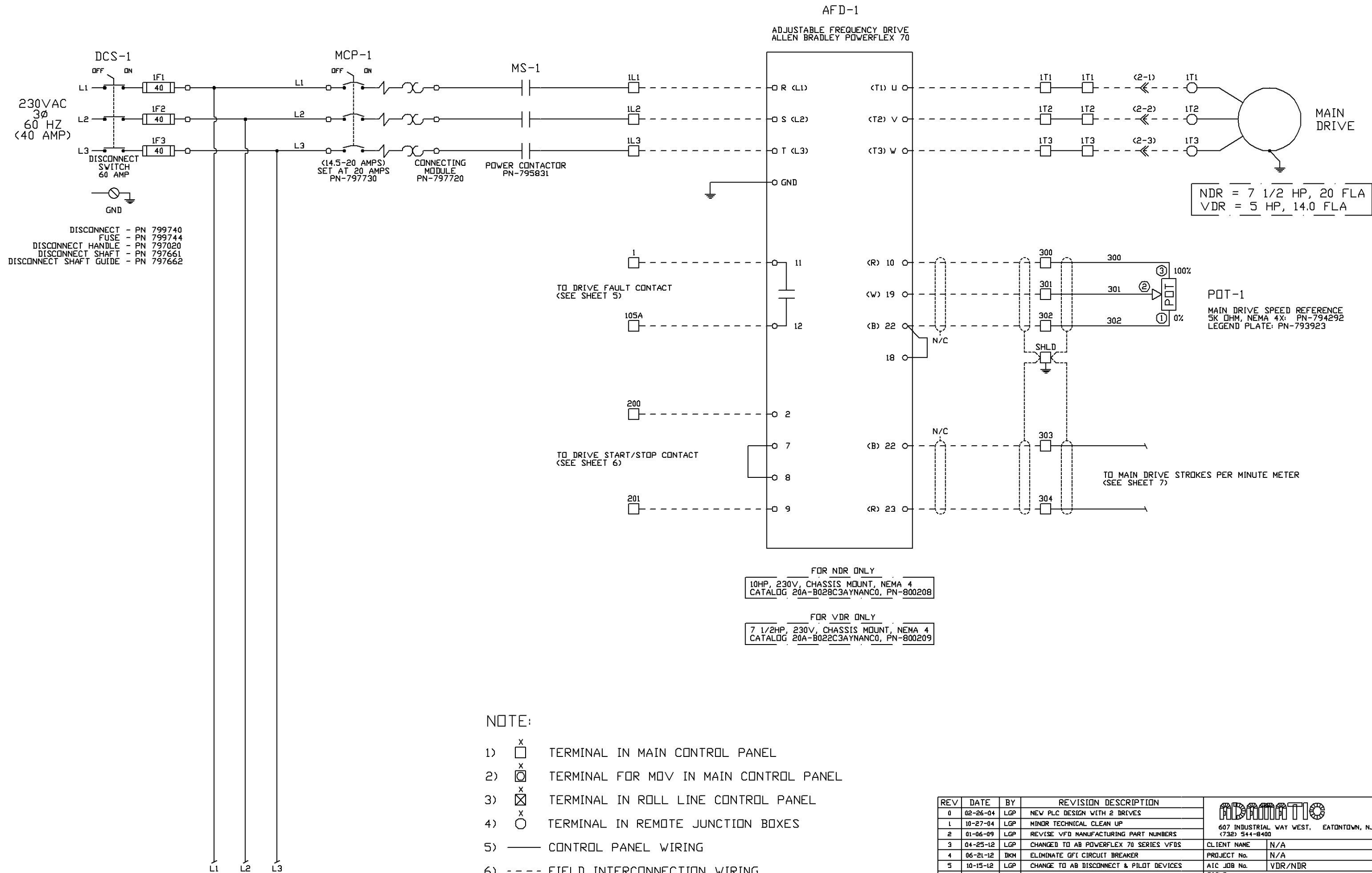
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— = DIRECTION
— = MOVEMENT

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ADAMATIC, AN AEA COMPANY, 607
INDUSTRIAL WAY, WEST EATONTOWN, NJ 07724
TEL: 201-941-1111 FAX: 201-941-1112
WWW.AEACORPORATION.COM

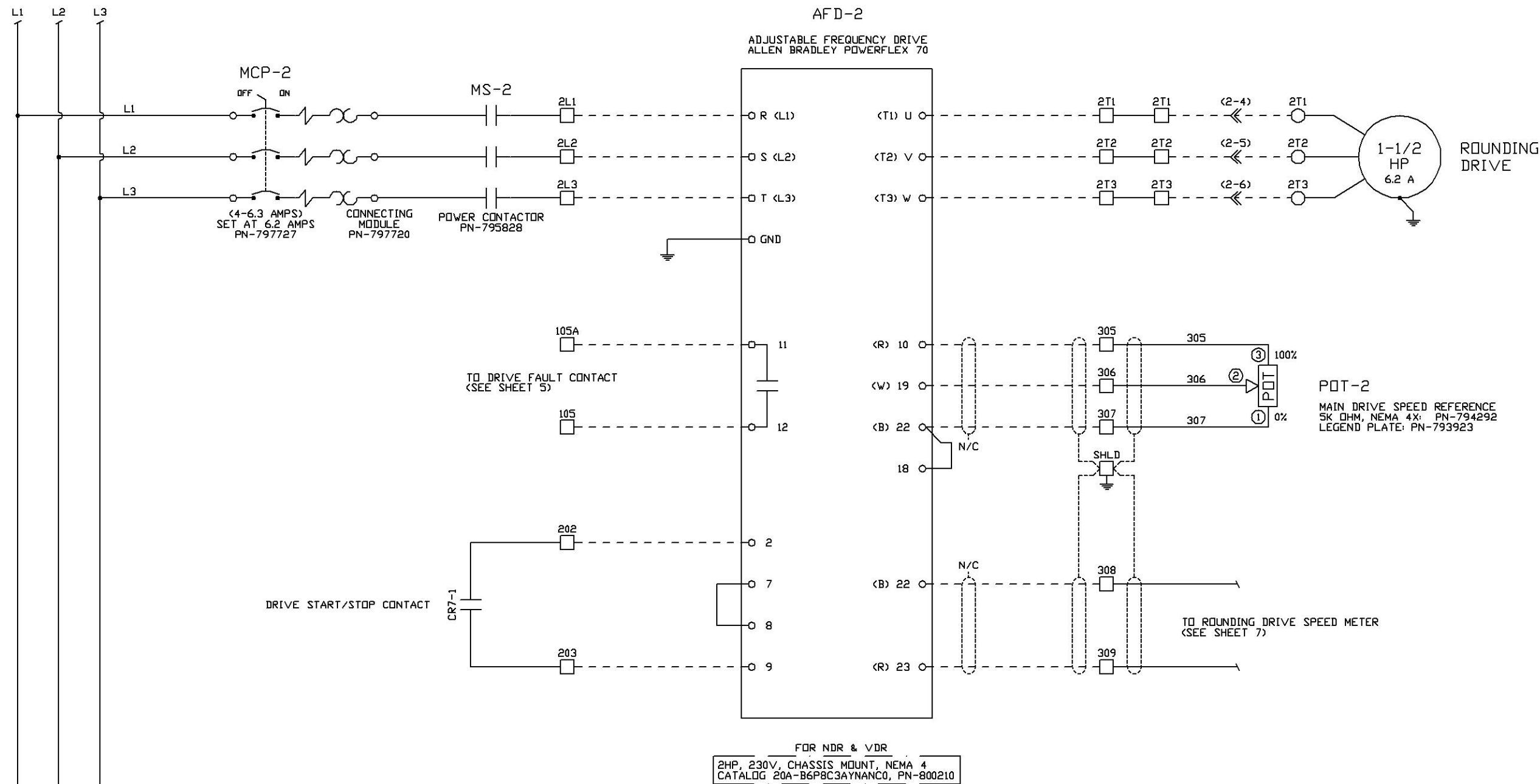
MACHINING TOLERANCES			SCALE 1-4			VDR	
FRACTIONAL	X/X	±1/64"	DSN BY	T. DEWITT	TIMING VDR		
DECIMAL	X.X	±0.025"	DMN BY	T. DEWITT			
	X.XX	±0.015"	DATE	9/14/94			
	X.XXX	±0.005"	CHK				
ANGULAR	X°	±0.5°				SHEET DRAWING NO. 92E	
	X'XX	±0.005°					
	X"XX	±0.005"					
	X'XX	±0.005°					
BREAK SHARP CORNERS			ADAMATIC				
REMOVE ALL BURS							
MACHINED SURFACES 63 RMS							
A 2-8-00			607 INDUSTRIAL WAY WEST EATONTOWN, NJ 07724				
DATE							
TEL							
DATE							
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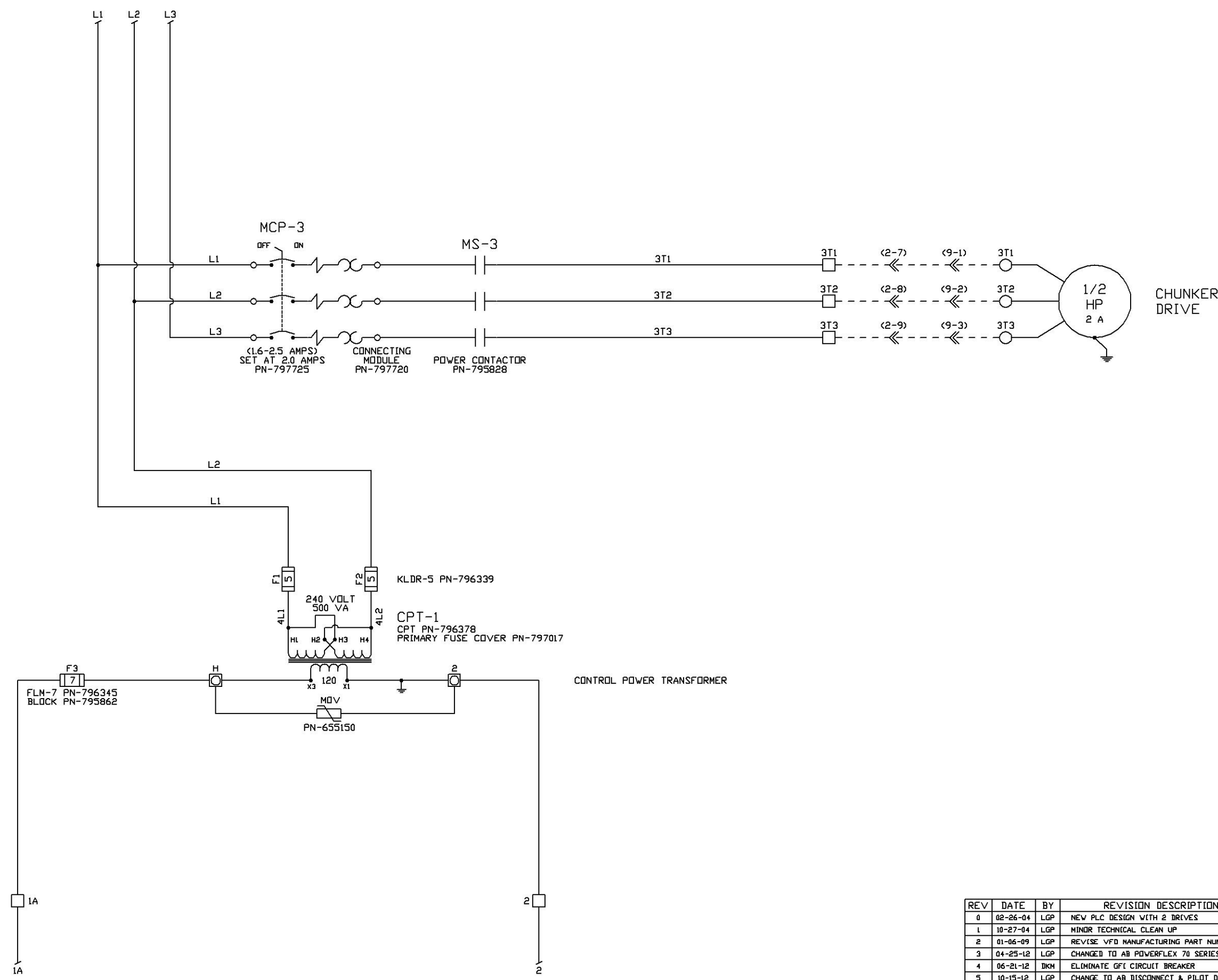
NOTE:

- 1)  TERMINAL IN MAIN CONTROL PANEL
- 2)  TERMINAL FOR MOV IN MAIN CONTROL PANEL
- 3)  TERMINAL IN ROLL LINE CONTROL PANEL
- 4)  TERMINAL IN REMOTE JUNCTION BOXES
- 5) ——— CONTROL PANEL WIRING
- 6) - - - - FIELD INTERCONNECTION WIRING
- 7) - - - - - SHIELDED WIRING

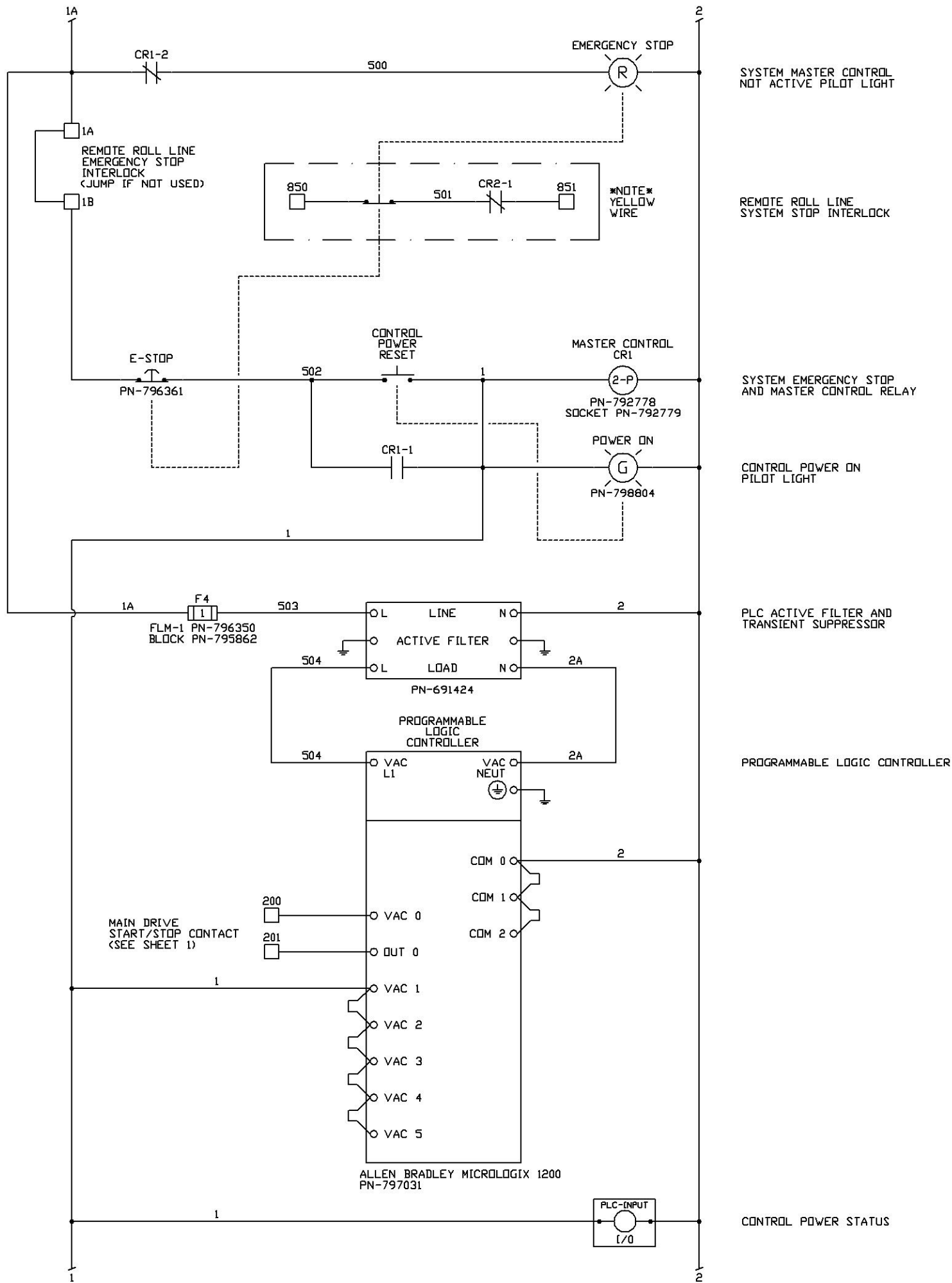
REV	DATE	BY	REVISION DESCRIPTION	 607 INDUSTRIAL WAY WEST, EATONTOWN, NJ 07724 (732) 544-8400	
0	02-26-04	LGP	NEW PLC DESIGN WITH 2 DRIVES		
1	10-27-04	LGP	MINOR TECHNICAL CLEAN UP	CLIENT NAME	N/A
2	01-06-09	LGP	REVISE VFD MANUFACTURING PART NUMBERS	PROJECT No.	N/A
3	04-25-12	LGP	CHANGED TO AB POWERFLEX 70 SERIES VFDs	AIC JOB No.	VDR/NDR
4	06-21-12	DKM	ELIMINATE GFI CIRCUIT BREAKER	TITLE 230 VAC - 2 DRIVE STANDARD VDR/NDR CONTROLLER (RIGHT) ELECTRICAL SCHEMATIC	
5	10-15-12	LGP	CHANGE TO AB DISCONNECT & PILOT DEVICES		
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				SCALE	NONE
				DRAWING No	79811101R
				SHEET	1/12
				REV	5



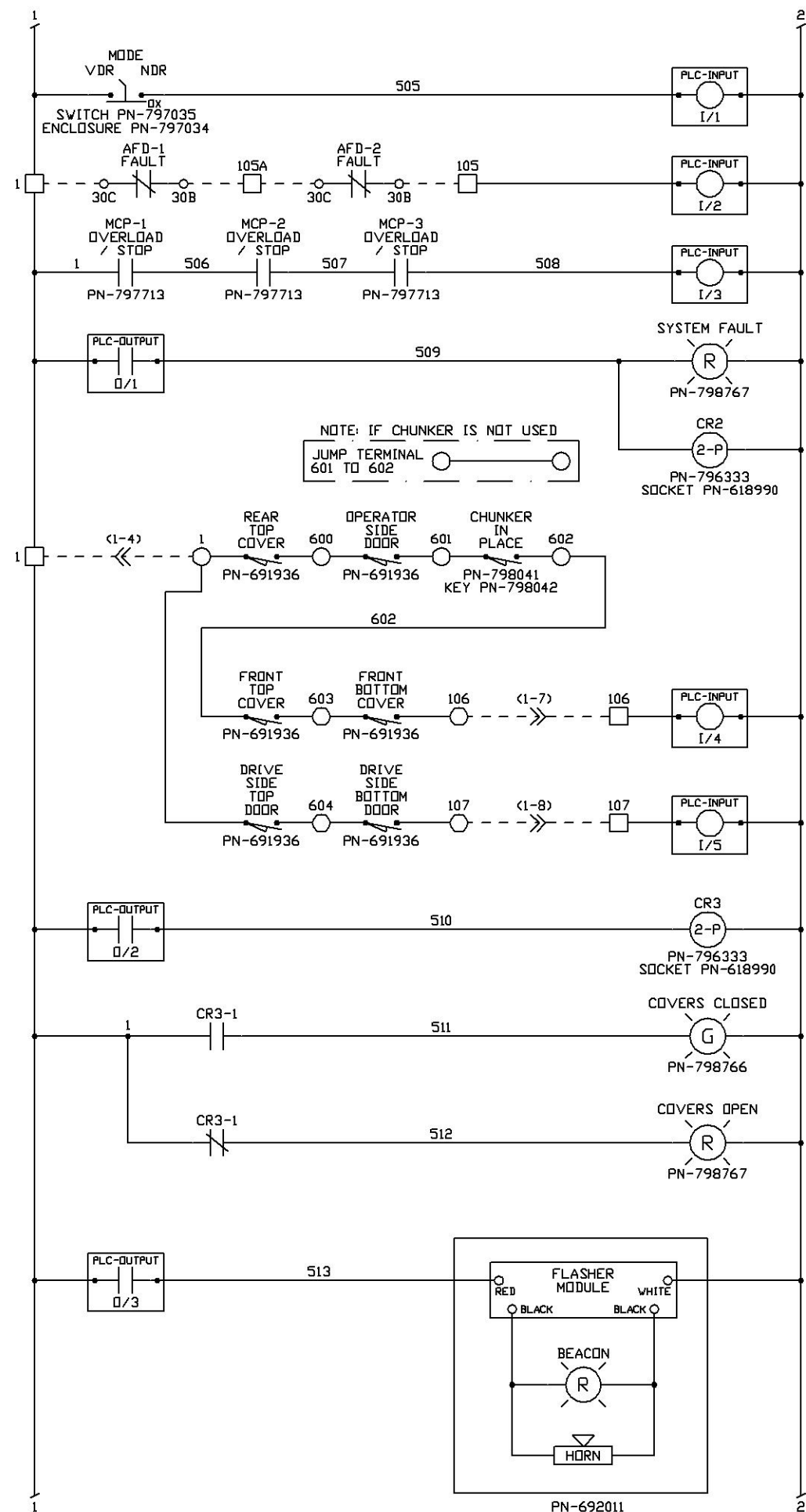
REV	DATE	BY	REVISION DESCRIPTION	 607 INDUSTRIAL WAY WEST, EATONTOWN, NJ 07724 (732) 544-8400	
0	02-26-04	LGP	NEW PLC DESIGN WITH 2 DRIVES		
1	10-27-04	LGP	MINOR TECHNICAL CLEAN UP	CLIENT NAME	N/A
2	01-06-09	LGP	REVISE VFD MANUFACTURING PART NUMBERS	PROJECT No.	N/A
3	04-25-12	LGP	CHANGED TO AB POWERFLEX 70 SERIES VFDs	AIC JOB No.	VDR/NDR
4	06-21-12	DKM	ELIMINATE GFI CIRCUIT BREAKER	TITLE	
5	10-15-12	LGP	CHANGE TO AB DISCONNECT & PILOT DEVICES	230 VAC - 2 DRIVE STANDARD VDR/NDR CONTROLLER (RIGHT) ELECTRICAL SCHEMATIC	
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				SCALE	NONE
				DRAWING No	79811101R
				SHEET	2/12
				REV	5



REV	DATE	BY	REVISION DESCRIPTION	ADAMATIO 607 INDUSTRIAL WAY WEST, EATONTOWN, NJ 07724 (732) 544-8400	
0	02-26-04	LGP	NEW PLC DESIGN WITH 2 DRIVES		
1	10-27-04	LGP	MINOR TECHNICAL CLEAN UP	CLIENT NAME	N/A
2	01-06-09	LGP	REVISE VFD MANUFACTURING PART NUMBERS	PROJECT No.	N/A
3	04-25-12	LGP	CHANGED TO AB POWERFLEX 70 SERIES VFDs	AIC JOB No.	VDR/NDR
4	06-21-12	DKM	ELIMINATE GFI CIRCUIT BREAKER	TITLE	
5	10-15-12	LGP	CHANGE TO AB DISCONNECT & PILOT DEVICES		
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				SCALE	NONE
				DRAWING No	79811101R
				SHEET	3/12
				REV	5



REV	DATE	BY	REVISION DESCRIPTION	ADAMATIO 607 INDUSTRIAL WAY WEST, EATONTOWN, NJ 07724 (732) 544-8400	
0	02-26-04	LGP	NEW PLC DESIGN WITH 2 DRIVES		
1	10-27-04	LGP	MINOR TECHNICAL CLEAN UP	CLIENT NAME	N/A
2	01-06-09	LGP	REVISE VFD MANUFACTURING PART NUMBERS	PROJECT No.	N/A
3	04-25-12	LGP	CHANGED TO AB POWERFLEX 70 SERIES VFDs	AIC JOB No.	VDR/NDR
4	06-21-12	DKM	ELIMINATE GFI CIRCUIT BREAKER	TITLE	
5	10-15-12	LGP	CHANGE TO AB DISCONNECT & PILOT DEVICES		
				230 VAC - 2 DRIVE STANDARD VDR/NDR CONTROLLER (RIGHT) ELECTRICAL SCHEMATIC	
DATE		SCALE	DRAWING No	SHEET	REV
02-26-2004		NONE	79811101R	4/12	5



VDR/NDR MODE
SELECTOR SWITCH

COMMON DRIVE FAULT

COMMON MOTOR CIRCUIT
CONTROLLER OVERLOAD / STOP

SYSTEM FAULT
PILOT LIGHT

SYSTEM FAULT
CONTROL RELAY

OPERATOR SIDE DOOR & COVER
INTERLOCK SAFETY SWITCHES

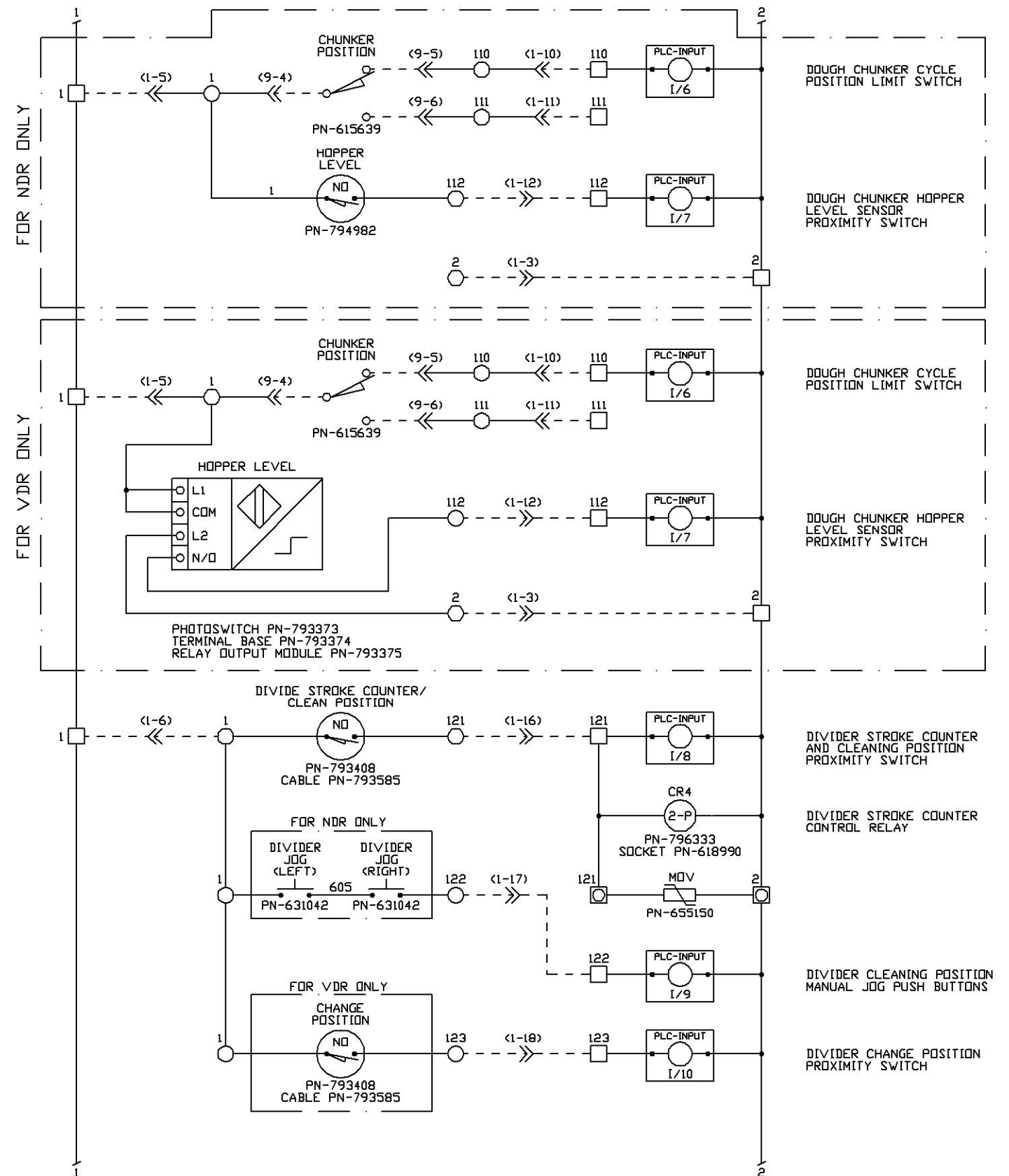
MAIN DRIVE DOOR
INTERLOCK SAFETY SWITCHES

DOORS AND GUARDS
STATUS CONTROL RELAY

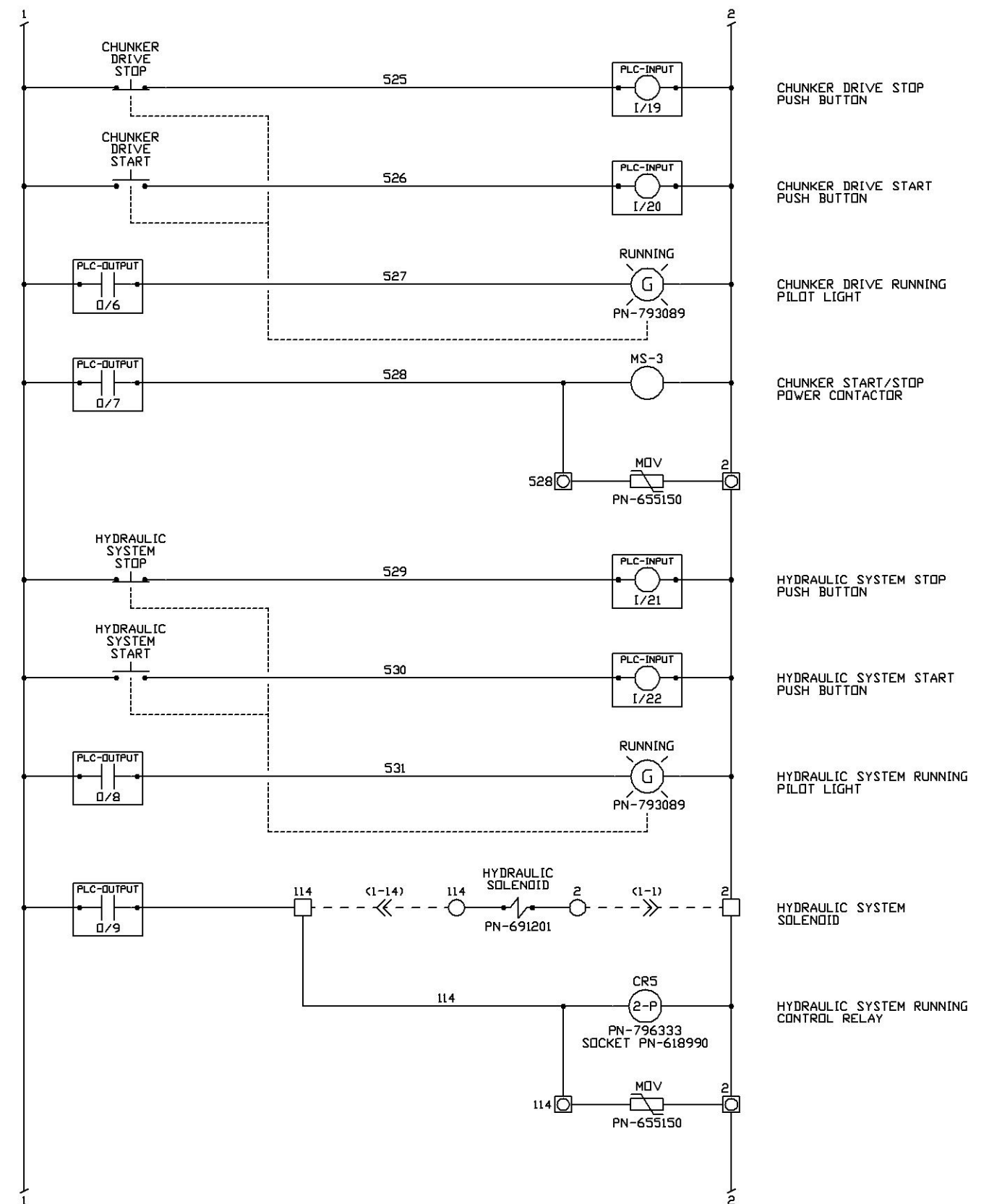
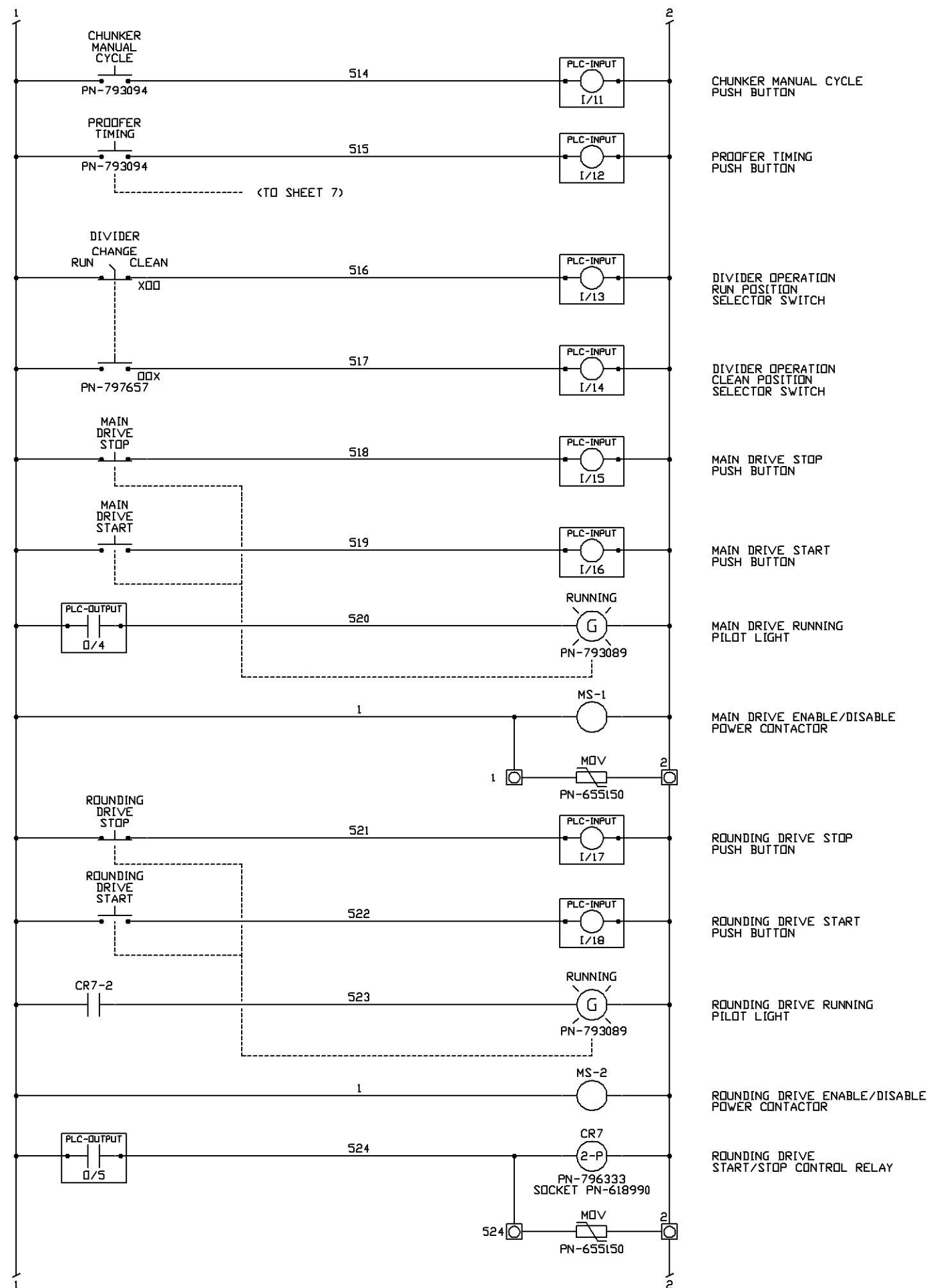
ALL DOORS AND GUARDS
IN POSITION
PILOT LIGHT

ALL DOORS AND GUARDS
NOT IN POSITION
PILOT LIGHT

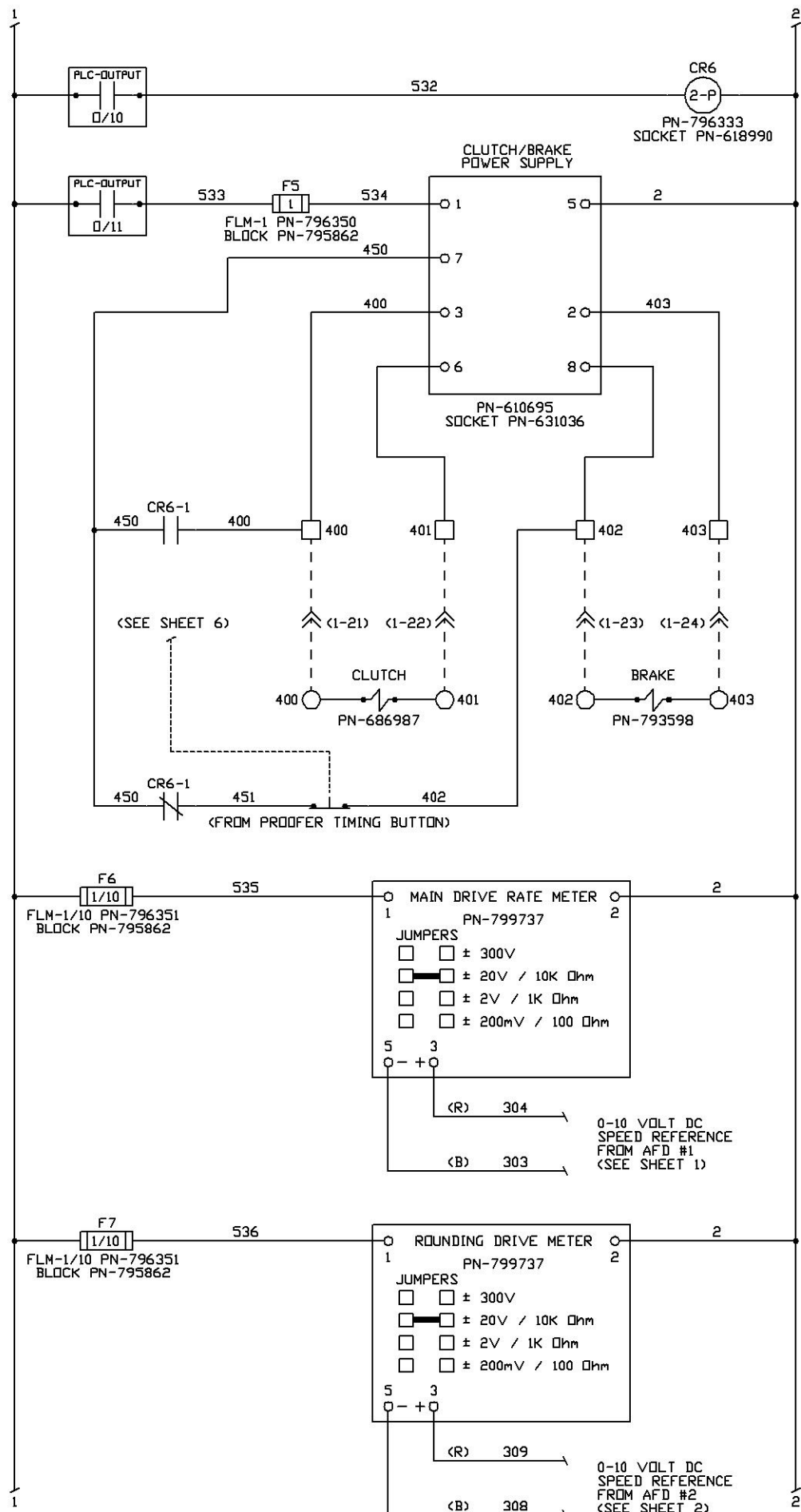
ALARM HORN/BEACON



REV	DATE	BY	REVISION DESCRIPTION	ADAMATIO	
0	02-26-04	LGP	NEW PLC DESIGN WITH 2 DRIVES	607 INDUSTRIAL WAY WEST, EATONTOWN, NJ 07724	
1	10-27-04	LGP	MINOR TECHNICAL CLEAN UP	(732) 544-8400	
2	01-06-09	LGP	REVISE VFD MANUFACTURING PART NUMBERS	CLIENT NAME	N/A
3	04-25-12	LGP	CHANGED TO AB POWERFLEX 70 SERIES VFDs	PROJECT No.	N/A
4	06-21-12	DKM	ELIMINATE GFI CIRCUIT BREAKER	A/C JOB No.	VDR/NDR
5	10-15-12	LGP	CHANGE TO AB DISCONNECT & PILOT DEVICES	TITLE	
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DATE		SCALE	DRAWING No.	SHEET	REV
02-26-2004		NONE	79811101R	5/12	5



REV	DATE	BY	REVISION DESCRIPTION	ADAMATIC 607 INDUSTRIAL WAY WEST, EATONTOWN, NJ 07724 (732) 544-8400									
0	02-26-04	LGP	NEW PLC DESIGN WITH 2 DRIVES	CLIENT NAME	N/A								
1	10-27-04	LGP	MINOR TECHNICAL CLEAN UP	PROJECT No.	N/A								
2	01-06-09	LGP	REVISE VFD MANUFACTURING PART NUMBERS	A/C JOB No.	VDR/NDR								
3	04-25-12	LGP	CHANGED TO AB POWERFLEX 70 SERIES VFDs	TITLE									
4	06-21-12	DKM	ELIMINATE GFI CIRCUIT BREAKER	230 VAC - 2 DRIVE									
5	10-15-12	LGP	CHANGE TO AB DISCONNECT & PILOT DEVICES	STANDARD VDR/NDR CONTROLLER (RIGHT)									
				ELECTRICAL SCHEMATIC									
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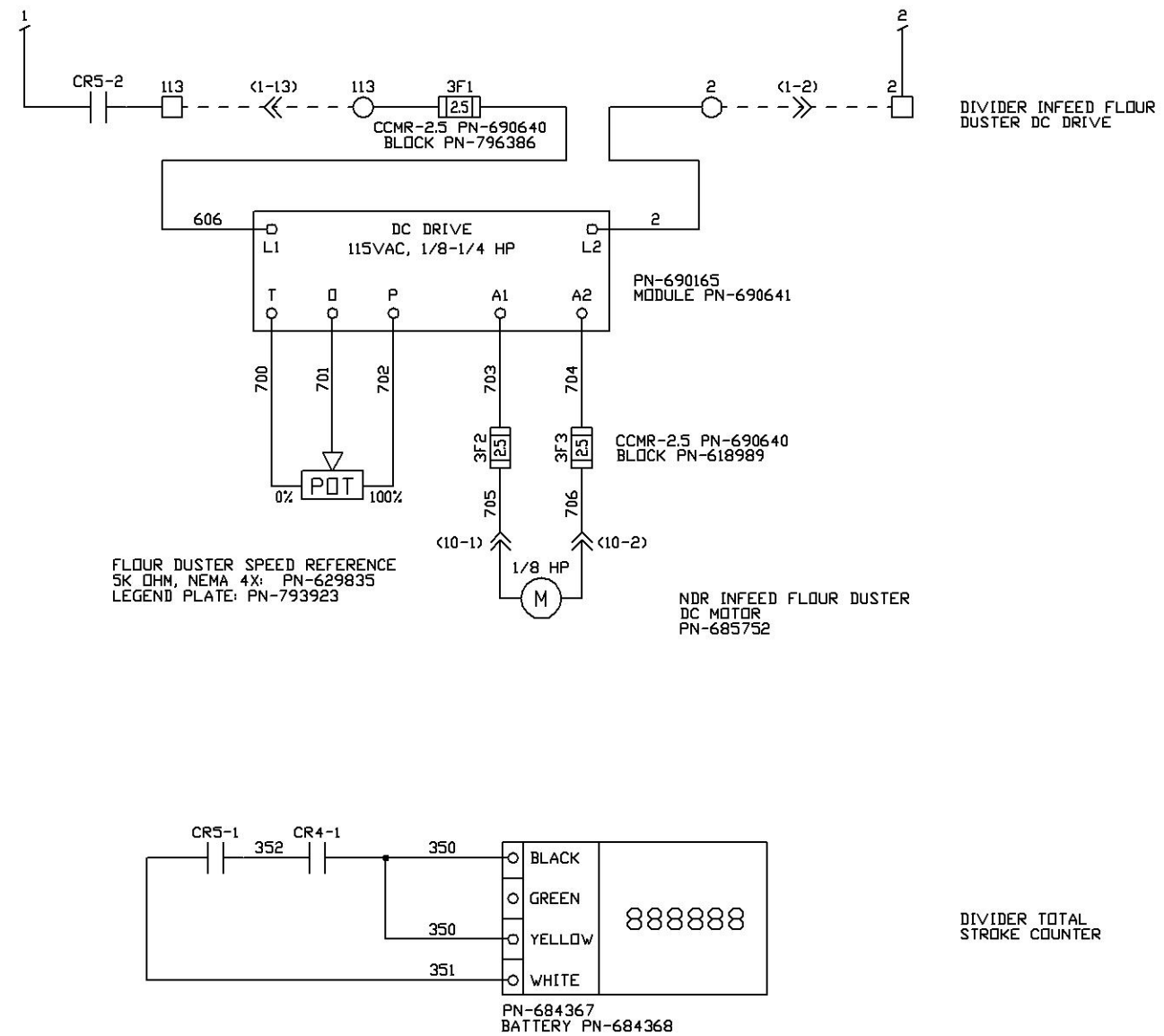
CLUTCH / BRAKE SELECTOR
CONTROL RELAY

CLUTCH / BRAKE
POWER SUPPLY

CLUTCH / BRAKE
SOLENOIDS

MAIN DRIVE RATE INDICATOR
(STROKES PER MINUTE)

ROUNDING DRIVE
SPEED INDICATOR (RPM)



DIVIDER INFEED FLOUR
DUSTER DC DRIVE

DIVIDER TOTAL
STROKE COUNTER

REV	DATE	BY	REVISION DESCRIPTION	 607 INDUSTRIAL WAY WEST, EATONTOWN, NJ 07724 (732) 544-8400	
0	02-26-04	LGP	NEW PLC DESIGN WITH 2 DRIVES		
1	10-27-04	LGP	MINOR TECHNICAL CLEAN UP	CLIENT NAME	N/A
2	01-06-09	LGP	REVISE VFD MANUFACTURING PART NUMBERS	PROJECT No.	N/A
3	04-25-12	LGP	CHANGED TO AB POWERFLEX 70 SERIES VFDs	AIC JOB No.	VDR/NDR
4	06-21-12	DKM	ELIMINATE GFI CIRCUIT BREAKER	TITLE 230 VAC - 2 DRIVE STANDARD VDR/NDR CONTROLLER (RIGHT) ELECTRICAL SCHEMATIC	
5	10-15-12	LGP	CHANGE TO AB DISCONNECT & PILOT DEVICES		
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				SCALE	NONE
				DRAWING No	79811101R
				SHEET	7/12
				REV	5

MAIN CONTROL PANEL

MAIN CONTROL PANEL TERMINAL BLOCK LAYOUT

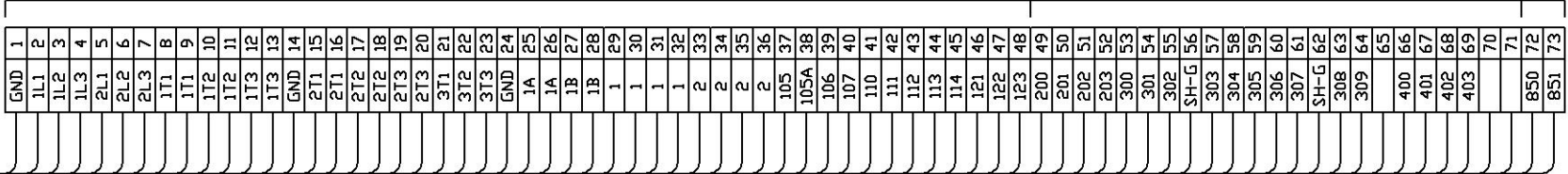
MOV TERMINAL BLOCK LAYOUT

GRAY
BLOCKS

BLUE
BLOCKS

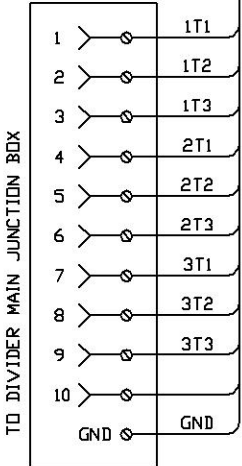
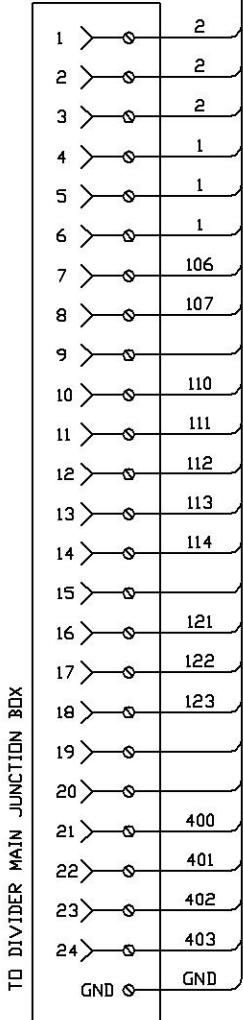
YELLOW
BLOCKS

GRAY
BLOCKS



PLUG #1
HOOD PN-684401
RECEPTACLE PN-684399
CONVERTER PN-690015
CORD CONNECTOR PN-690103

PLUG #2
HOOD PN-618920
RECEPTACLE PN-618923
CONVERTER PN-690012
CORD CONNECTOR PN-616387



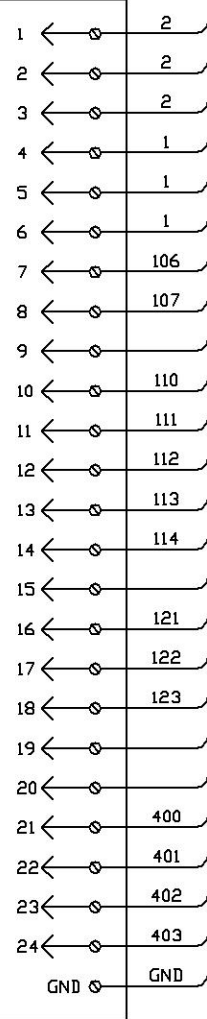
No.	COLOR
1	BLACK
2	RED
3	BLUE
4	ORANGE
5	YELLOW
6	BROWN
7	RED / BLACK
8	BLUE / BLACK
9	ORANGE / BLACK
10	YELLOW / BLACK
11	BROWN / BLACK
12	BLACK / RED

No.	COLOR
13	BLUE / RED
14	ORANGE / RED
15	YELLOW / RED
16	BROWN / RED
17	BLACK / BLUE
18	RED / BLUE
19	ORANGE / BLUE
20	YELLOW / BLUE
21	BROWN / BLUE
22	BLACK / ORANGE
23	RED / ORANGE
24	BLUE / ORANGE
25	YELLOW / ORANGE

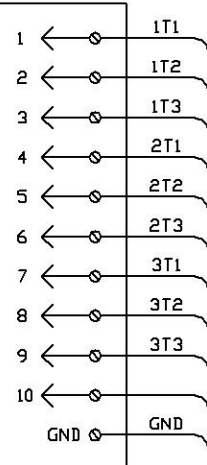
REV	DATE	BY	REVISION DESCRIPTION	ADAMATIO 607 INDUSTRIAL WAY WEST, EATONTOWN, NJ 07724 (732) 544-8400	
0	02-26-04	LGP	NEW PLC DESIGN WITH 2 DRIVES		
1	10-27-04	LGP	MINOR TECHNICAL CLEAN UP	CLIENT NAME	N/A
2	01-06-09	LGP	REVISE VFD MANUFACTURING PART NUMBERS	PROJECT No.	N/A
3	04-25-12	LGP	CHANGED TO AB POWERFLEX 70 SERIES VFDS	AIC JOB No.	VDR/NDR
4	06-21-12	DKM	ELIMINATE GFI CIRCUIT BREAKER	TITLE 230 VAC - 2 DRIVE STANDARD VDR/NDR CONTROLLER (RIGHT) ELECTRICAL SCHEMATIC	
5	10-15-12	LGP	CHANGE TO AB DISCONNECT & PILOT DEVICES		
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				SCALE	NONE
				DRAWING No	79811101R
				SHEET	8/12
				REV	5

DIVIDER MAIN JUNCTION BOX
ENCLOSURE PN-692016

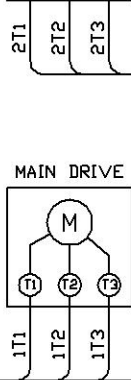
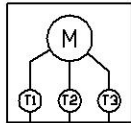
PLUG #1
BASE PN-684403
PLUG PN-684400



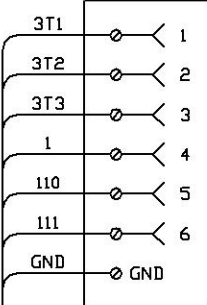
PLUG #2
BASE NO-618917
PLUG PN-618926



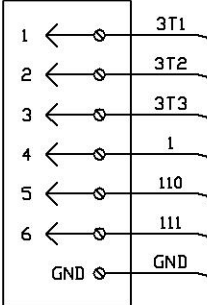
ROUNDING DRIVE



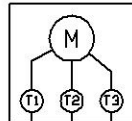
PLUG #9
BASE PN-792294
RECEPTACLE PN-618924



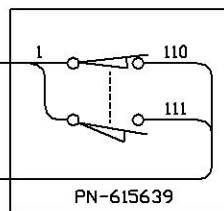
PLUG #9
HOOD PN-618921
PLUG PN-618927
CONVERTER PN-690011



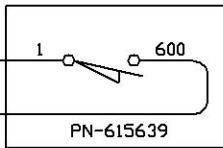
CHUNKER DRIVE



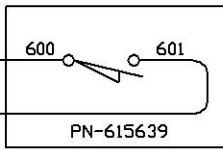
CHUNKER POSITION



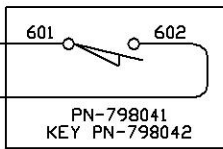
REAR TOP COVER



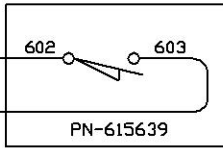
OPERATOR SIDE DOOR



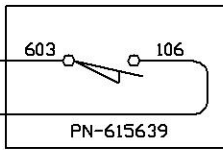
CHUNKER IN PLACE



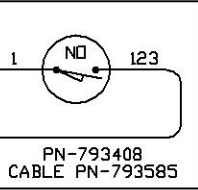
FRONT TOP COVER



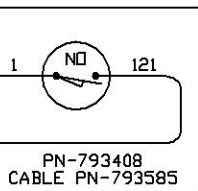
FRONT BOTTOM COVER



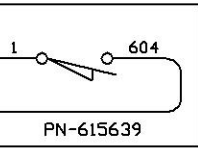
CHANGE POSITION



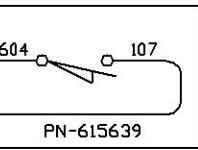
DIVIDER STROKE / POSITION



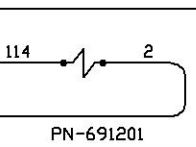
DRIVE SIDE TOP DOOR



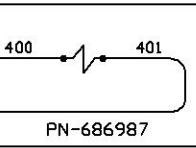
DRIVE SIDE BOTTOM DOOR



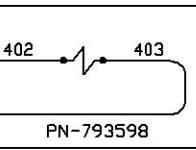
HYDRAULIC SYSTEM



MAIN DRIVE CLUTCH

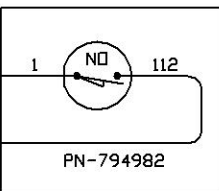


MAIN DRIVE BRAKE

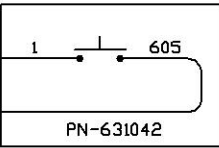


(INCLUDED WITH NDR ONLY)

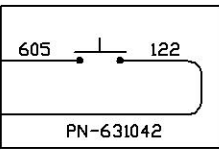
DOUGH HOPPER LEVEL



DIVIDER JOG (LEFT)



DIVIDER JOG (RIGHT)

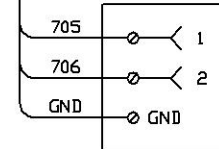


(INCLUDED WITH NDR ONLY)

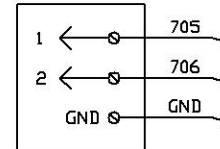
FLOUR DUSTER DC DRIVE



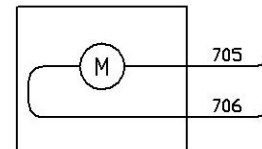
PLUG #10
RECEPTACLE PN-618879



PLUG #10
PLUG PN-618882



DIVIDER
INFEED
FLOUR DUSTER



(INCLUDED WITH VDR ONLY)

DOUGH HOPPER LEVEL

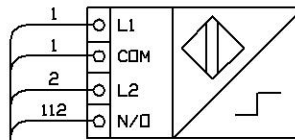


PHOTO SWITCH PN-793373
TERMINAL BASE PN-793374
RELAY OUTPUT MODULE PN-793375

REV	DATE	BY	REVISION DESCRIPTION
0	02-26-04	LGP	NEW PLC DESIGN WITH 2 DRIVES
1	10-27-04	LGP	MINOR TECHNICAL CLEAN UP
2	01-06-09	LGP	REVISE VFD MANUFACTURING PART NUMBERS
3	04-25-12	LGP	CHANGED TO AB POWERFLEX 70 SERIES VFDs
4	06-21-12	DKM	ELIMINATE GFI CIRCUIT BREAKER
5	10-15-12	LGP	CHANGE TO AB DISCONNECT & PILOT DEVICES

ADAMATIC

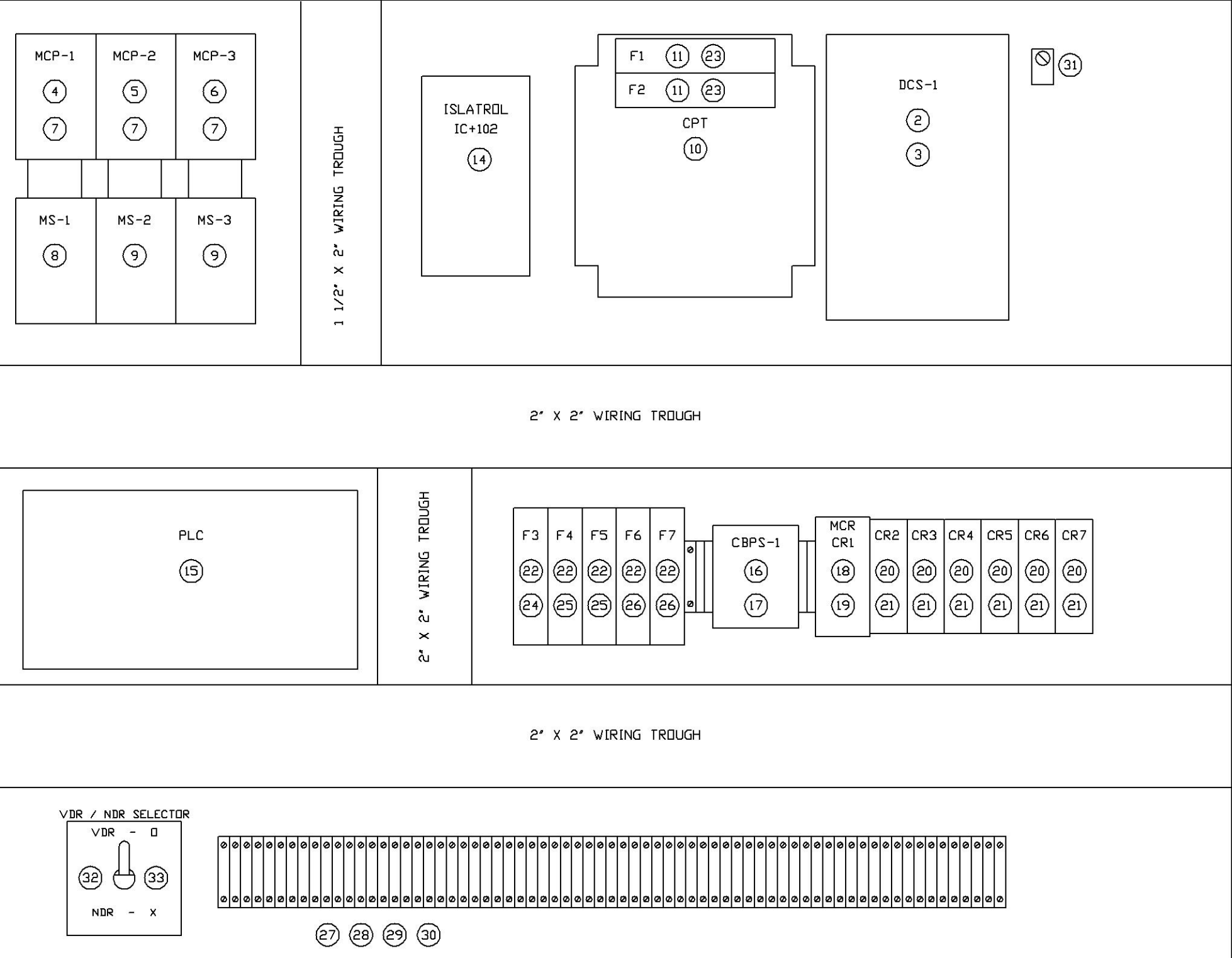
607 INDUSTRIAL WAY WEST, EATONTOWN, NJ 07724
(732) 544-8400

CLIENT NAME	N/A
PROJECT No.	N/A
A/C JOB No.	VDR/NDR

TITLE
230 VAC - 2 DRIVE
STANDARD VDR/NDR CONTROLLER (RIGHT)
ELECTRICAL SCHEMATIC

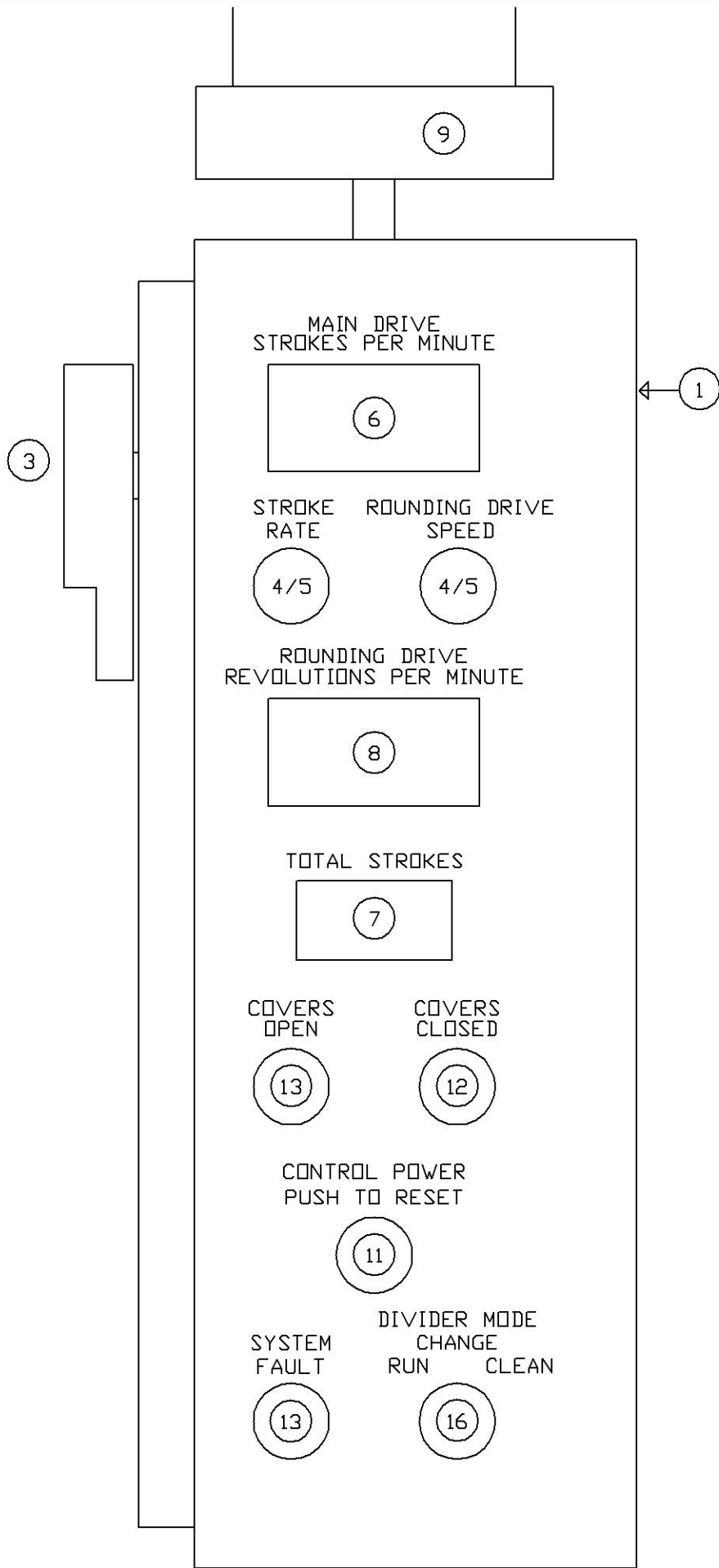
DATE	SCALE	DRAWING No	SHEET	REV
02-26-2004	NONE	79811101R	9/12	5

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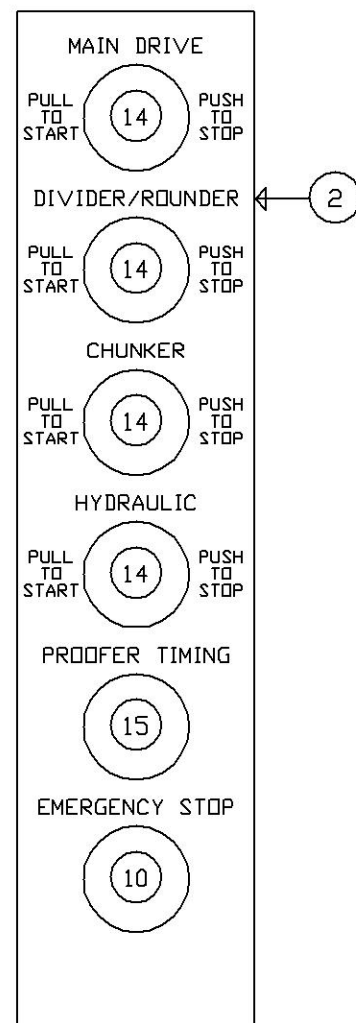


ITEM #	ADAMATIC PART #	ITEM DESCRIPTION
1	794904	MAIN CONTROL PANEL SUB-PANEL
2	799740 797661,797662	FUSED DISCONNECT SWITCH, SHAFT & HANDLE
3	799744	DISCONNECT FUSES
4	797730	MOTOR CIRCUIT PROTECTOR
5	797727	MOTOR CIRCUIT PROTECTOR
6	797725	MOTOR CIRCUIT PROTECTOR
7	797713	MOTOR CIRCUIT PROTECTOR AUX CONTACT
8	795831	3 PHASE POWER CONTACTOR
9	795828	3 PHASE POWER CONTACTOR
10	796378	CONTROL TRANSFORMER
11	797017	CONTROL TRANSFORMER FUSE COVER
14	691424	ISLATROL LINE FILTER
15	797031	PROGRAMMABLE LOGIC CONTROLLER
16	610695	CLUTCH BRAKE MODULE
17	631036	CLUTCH BRAKE MODULE SOCKET
18	792778	MASTER CONTROL RELAY #1
19	792779	MASTER CONTROL RELAY SOCKET
20	796333	2 POLE CONTROL RELAY
21	618990	2 POLE CONTROL RELAY SOCKET
22	795862	FUSE BLOCK
23	796339	FUSE KLDL-5
24	796345	FUSE FLM-7
25	796350	FUSE FLM-1
26	796351	FUSE FLM-1/10
27	797733	TERMINAL BLOCK - GRAY
28	797734	TERMINAL BLOCK - BLUE
29	797735	TERMINAL BLOCK - YELLOW
30	797736	TERMINAL BLOCK - GROUND
31	796171	GROUND LUG
32	797034	2\" X 2\" X 2\" ENCLOSURE
33	797035	2 POSITION SWITCH

REV	DATE	BY	REVISION DESCRIPTION	ADAMATIC 607 INDUSTRIAL WAY WEST, EATONTOWN, NJ 07724 (732) 544-8400				
0	02-26-04	LGP	NEW PLC DESIGN WITH 2 DRIVES	CLIENT NAME	N/A			
1	10-27-04	LGP	MINOR TECHNICAL CLEAN UP	PROJECT No.	N/A			
2	01-06-09	LGP	REVISE VFD MANUFACTURING PART NUMBERS	A/C JOB No.	VDR/NDR			
3	04-25-12	LGP	CHANGED TO AB POWERFLEX 70 SERIES VFDs	TITLE				
4	06-21-12	DKM	ELIMINATE GFI CIRCUIT BREAKER	230 VAC - 2 DRIVE STANDARD VDR/NDR CONTROLLER (RIGHT) ELECTRICAL SCHEMATIC				
5	10-15-12	LGP	CHANGE TO AB DISCONNECT & PILOT DEVICES					
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				02-26-2004	NONE	79811101R	10/12	5

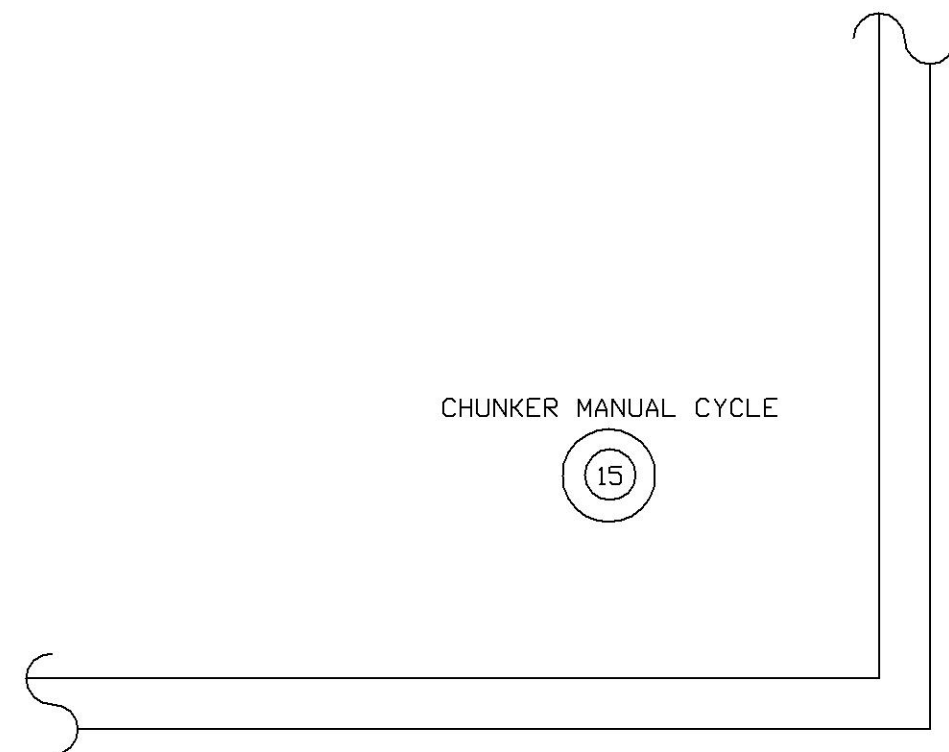


PANEL RIGHT SIDE



OPERATOR STATION

ITEM #	ADAMATIC PART #	ITEM DESCRIPTION
1	794904	MAIN CONTROL PANEL
2	794341	OPERATOR CONTROL STATION
3	797020	DISCONNECT SWITCH HANDLE
4	794292	POTENTIOMETER
5	793923	POTENTIOMETER LEGEND PLATE
6	799737	DIVIDER RATE METER
7	684367	DIVIDER TOTAL STROKE COUNTER
8	799737	ROUNDING SPEED METER
9	692011	HORN/BEACON
10	793091 & 798182	EMERGENCY STOP SWITCH
11	798804	GREEN LED PUSH BUTTON
12	798766	GREEN LED PILOT LIGHT
13	798767	RED LED PILOT LIGHT
14	793089	GREEN PUSH/PULL SWITCH/PILOT LIGHT
15	793094	BLACK PUSH BUTTON
16	797657	BLACK 3 POSITION SELECTOR SWITCH

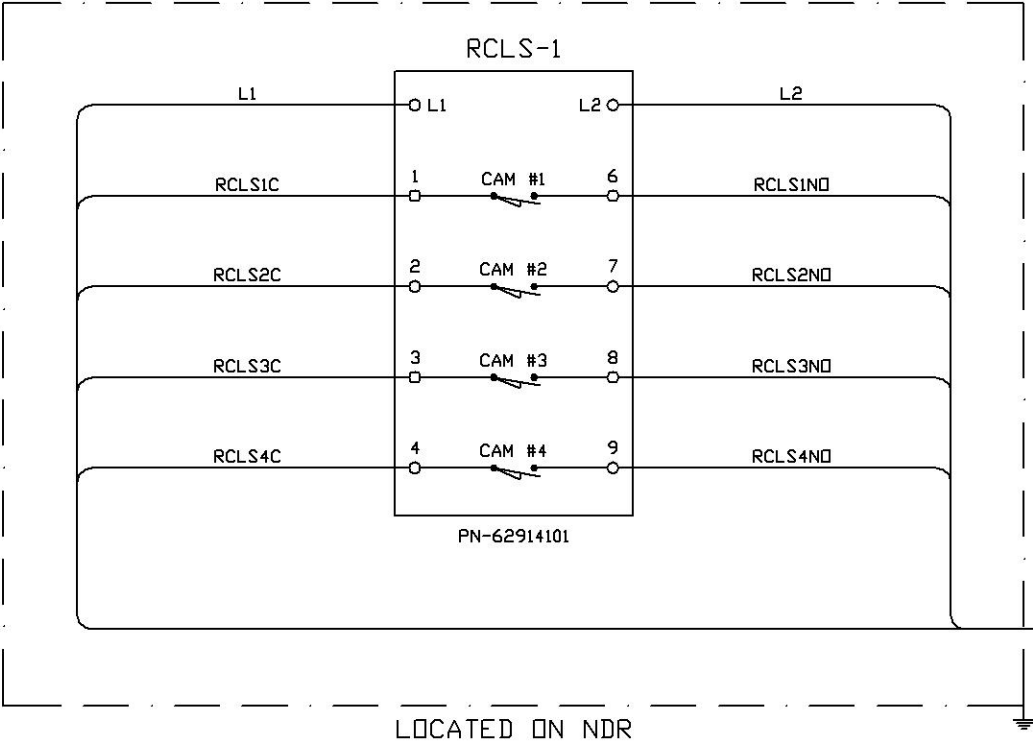


PANEL FRONT FACE LOWER RIGHT

REV	DATE	BY	REVISION DESCRIPTION	 607 INDUSTRIAL WAY WEST, EATONTOWN, NJ 07724 (732) 544-8400	
0	02-26-04	LGP	NEW PLC DESIGN WITH 2 DRIVES		
1	10-27-04	LGP	MINOR TECHNICAL CLEAN UP	CLIENT NAME	N/A
2	01-06-09	LGP	REVISE VFD MANUFACTURING PART NUMBERS	PROJECT No.	N/A
3	04-25-12	LGP	CHANGED TO AB POWERFLEX 70 SERIES VFDs	AIC JOB No.	VDR/NDR
4	06-21-12	DKM	ELIMINATE GFI CIRCUIT BREAKER	TITLE	
5	10-15-12	LGP	CHANGE TO AB DISCONNECT & PILOT DEVICES		
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DATE		SCALE	DRAWING No	SHEET	REV
02-26-2004		NONE	7981101R	11/12	5

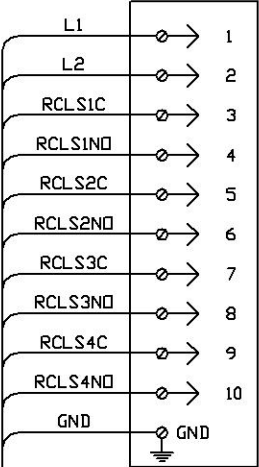
(OPTIONAL) ROTATING CAM LIMIT (IF REQUIRED)
SWITCHES BOX

ROTARY CAM LIMIT SWITCH
ELECTRO-CAM # EC-3004-10-ARD

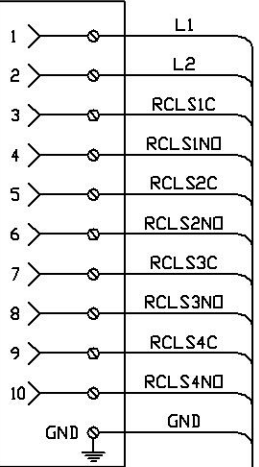


CAM # 1,2,3 AND 4 - MODULE RELAY OUTPUT
TYPE AC, N/O, PN-688339

PLUG #3
HOOD, CABLE COUPLER PN-799100
PLUG PN-618926
CONVERTOR PN-690012
CORD CONN. PN-685063



PLUG #3
HOOD, TOP ENTRY PN-799101
RECEPTACLE PN-618923
CONVERTER PN-690012
CORD CONN. PN-685063



TO CUSTOMER PROOFER/
CONVEYOR CONTROL SYSTEM

No.	COLOR
1	BLACK
2	RED
3	BLUE
4	ORANGE
5	YELLOW
6	BROWN
7	RED / BLACK
8	BLUE / BLACK
9	ORANGE / BLACK
10	YELLOW / BLACK
11	BROWN / BLACK
12	BLACK / RED

No.	COLOR
13	BLUE / RED
14	ORANGE / RED
15	YELLOW / RED
16	BROWN / RED
17	BLACK / BLUE
18	RED / BLUE
19	ORANGE / BLUE
20	YELLOW / BLUE
21	BROWN / BLUE
22	BLACK / ORANGE
23	RED / ORANGE
24	BLUE / ORANGE
25	YELLOW / ORANGE

REV	DATE	BY	REVISION DESCRIPTION	ADAMATIC 607 INDUSTRIAL WAY WEST, EATONTOWN, NJ 07724 (732) 544-8400						
0	N/A			CLIENT NAME		N/A				
1	N/A			PROJECT No.		N/A				
2	N/A			AIC JOB No.		VDR/NDR				
3	N/A			TITLE						
4	N/A			230 VAC - 2 DRIVE STANDARD VDR/NDR CONTROLLER (RIGHT) ELECTRICAL SCHEMATIC						
5	10-15-12	LGP	CHANGE TO AB DISCONNECT & PILOT DEVICES	DATE		02-26-2004	SCALE	DRAWING No	SHEET	REV
							NONE	79811101R	12/12	5
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