

Sure-Feed
Engineering Inc

STAND ALONE ***TURNOVER***

6 x 9 INSERTER

Parts Manual



SURE-FEED ENGINEERING

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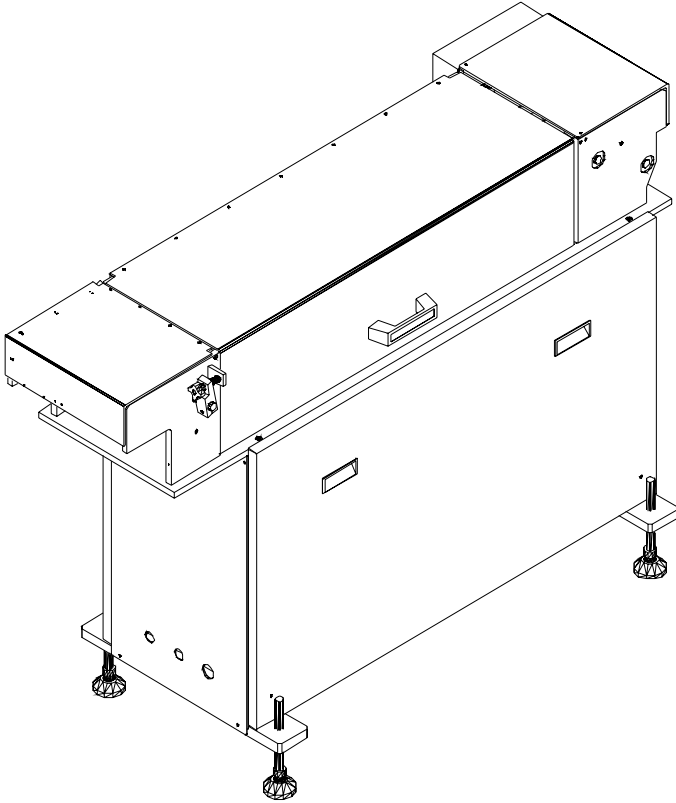
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TURNOVER

6 X 9

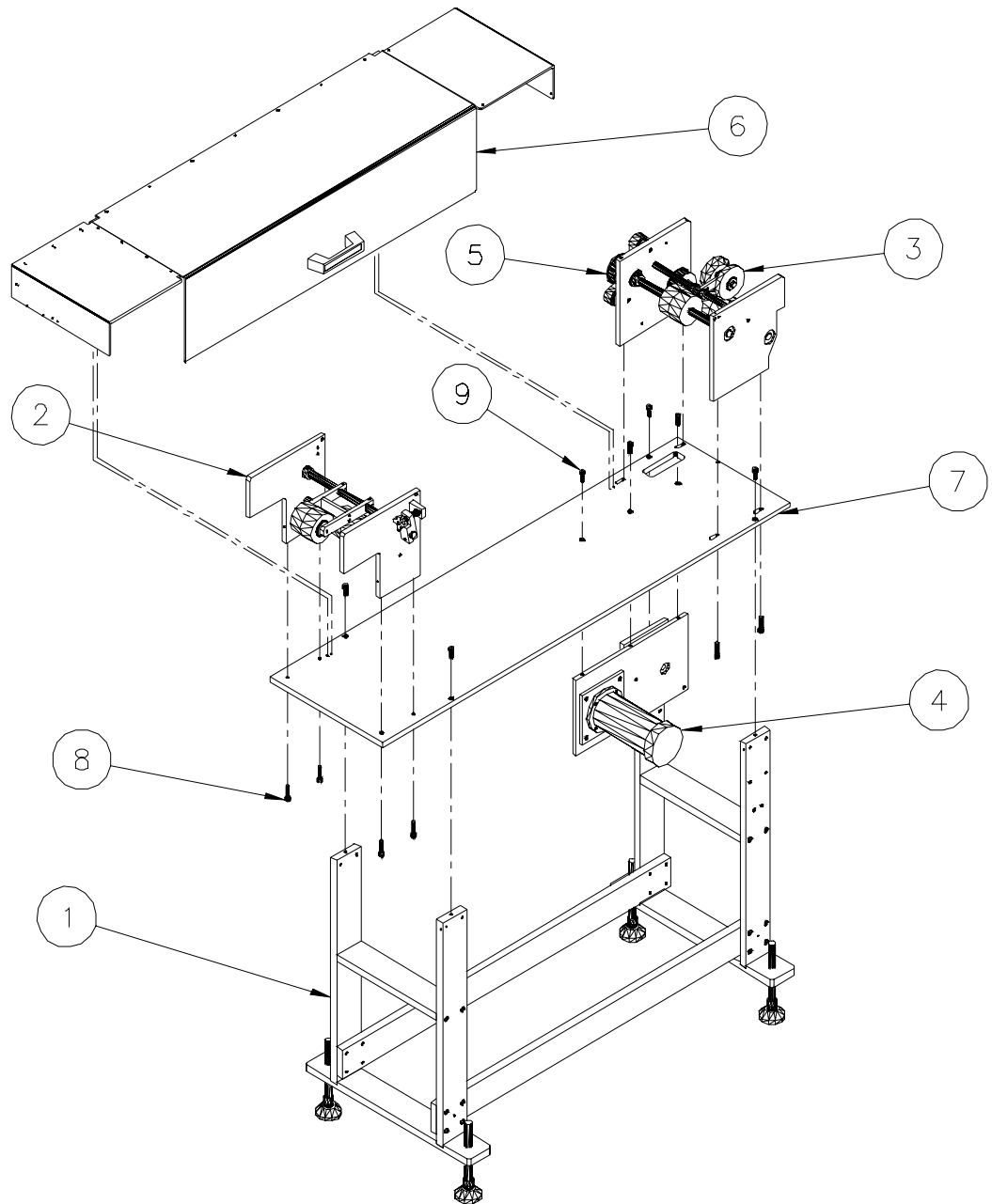


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TURNOVER ASSEMBLY (Fig. 5-1)

ITEM	PART NO.	QTY.	DESCRIPTION
1	(SEE FIG. 5-2)	1	FRAME, TURNOVER
2	(SEE FIG. 5-3)	1	INFEED ASSEMBLY
3	(SEE FIG. 5-4)	1	DISCHARGE ASSEMBLY
4	(SEE FIG. 5-5)	1	MOTOR / MOTOR MOUNT ASSEMBLY
5	(SEE FIG. 5-6)	1	DRIVE ASSEMBLY
6	(SEE FIG. 5-7)	1	COVERS ASSEMBLY
7	20001-001	1	PLATE, DECK
8		8	SCREW, SKT HD, 5/16-18 X 1-1/4
9		7	SCREW, SKT HD, 5/16-18 X 3/4
10	99000-038	1	BELT, TURNOVER, 91.645 (NOT SHOWN)
11	99000-039	1	BELT, TURNOVER, 111.601 (NOT SHOWN)

FIG. 5-1



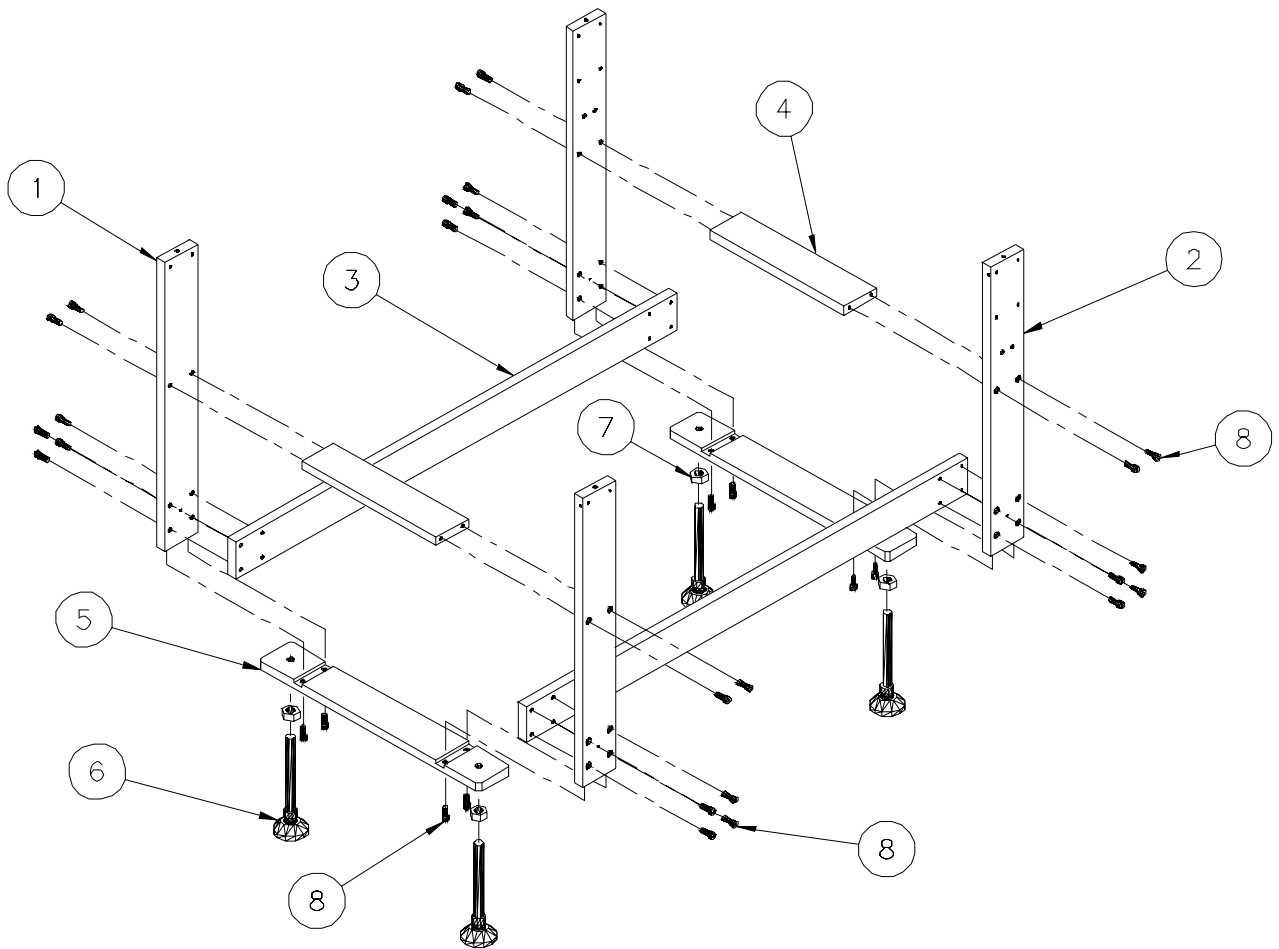
NOTE: ITEM 10, TURNOVER BELT (91.645) NOT SHOWN
ITEM 11, TURNOVER BELT (111.601) NOT SHOWN

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TURNOVER (Fig. 5-2)
FRAME ASSEMBLY

ITEM	PART NO.	QTY.	DESCRIPTION
1	20010-002	2	LEG, INFEED, TURNOVER
2	20010-001	2	LEG, DISCHARGE, TURNOVER
3	20003-003	2	CROSSBAR, SIDE, TURNOVER
4	20003-002	2	CROSSBAR, UPPER, TURNOVER
5	20003-001	2	CROSSBAR, LOWER, TURNOVER
6	99010-001	4	FOOT, ADJUSTING
7		4	NUT, HEX, 5/8-11
8		32	SCREW, SKT HD, 5/16-18 X 1

FIG. 5-2



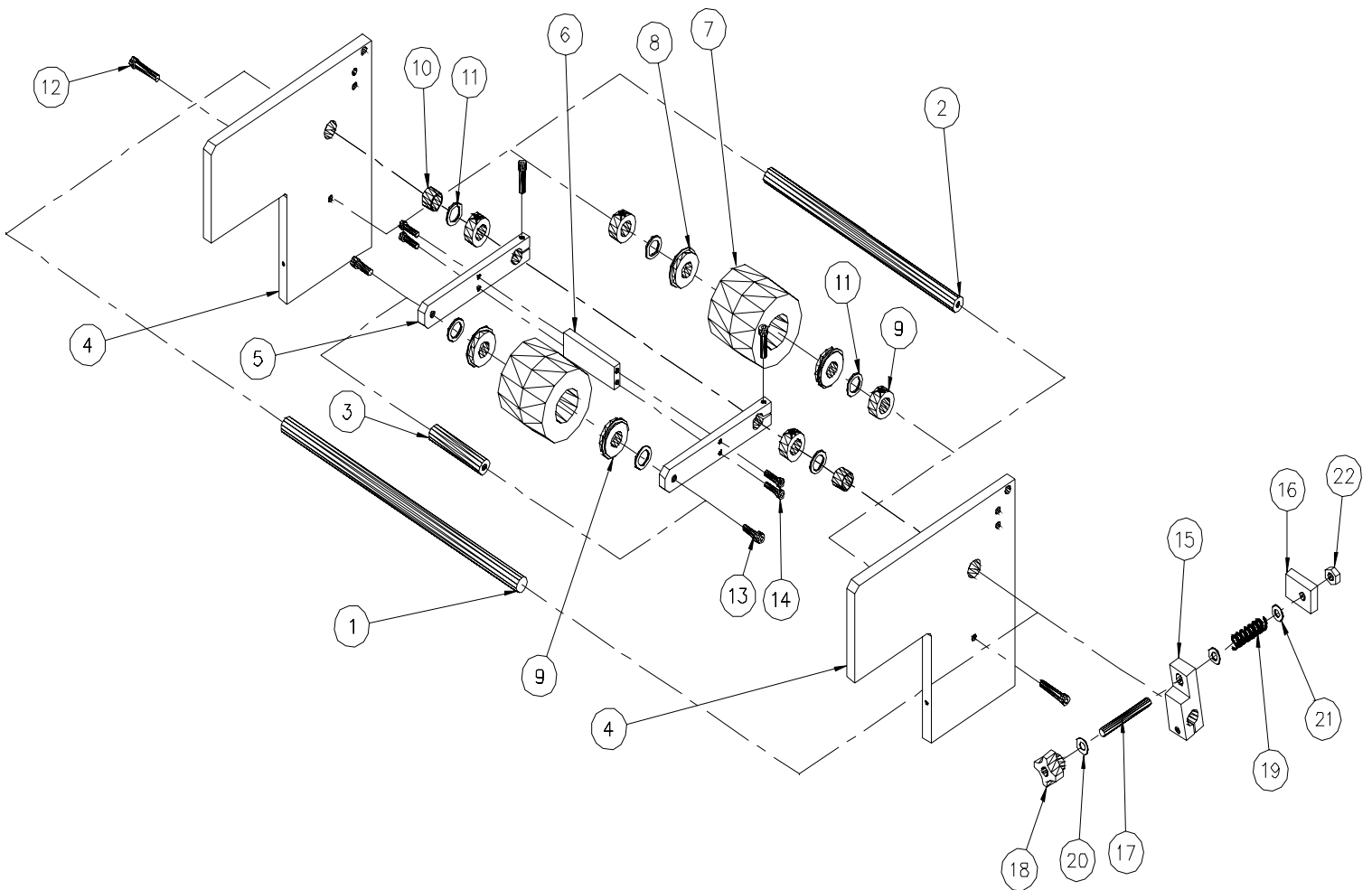
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TURNOVER (Fig. 5-3)
INFEED ASSEMBLY

ITEM	PART NO.	QTY.	DESCRIPTION
1	20004-003	1	SHAFT, IDLER PIVOT
2	20004-002	1	SHAFT, IDLER (LONG)
3	20004-001	1	SHAFT, IDLER (SHORT)
4	20000-001	2	SIDEPLATE, INFEED
5	20008-001	2	BAR, IDLER ROLLER MTG.
6	20012-002	1	SPACER, IDLER ROLLER
7	20006-001	2	ROLLER, CROWNED (IDLER)
8	99003-006	4	BEARING, SEALED, 5/8 X 1-3/8
9	99017-005	4	COLLAR, SET, 5/8
10	99003-029	2	BUSHING, 5/8 X 3/4 X 1/2
11	99003-021	6	WASHER, NYLON, 5/8 X 1/16
12		4	SCREW, SKT HD, 1/4-20 X 1
13		2	SCREW, SKT HD, 1/4-20 X 3/4
14		4	SCREW, SKT HD, 10-24 X 3/4
15	20007-002	1	BLOCK, SHAFT CLAMP
16	20007-001	1	BLOCK, SHAFT ADJUSTING
17	10004-028	1	STUD, SEPERATOR ADJUSTING
18	99004-001	1	KNOB, FEMALE, 5/16-24
19	10019-001	1	SPRING, SEPERATOR (ROTATING)
20	99003-015	1	WASHER, NYLON, 5/16 X 1/16
21		2	WASHER, FLAT, 5/16
22		1	NUT, HEX HD, 5/16-24

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FIG. 5-3



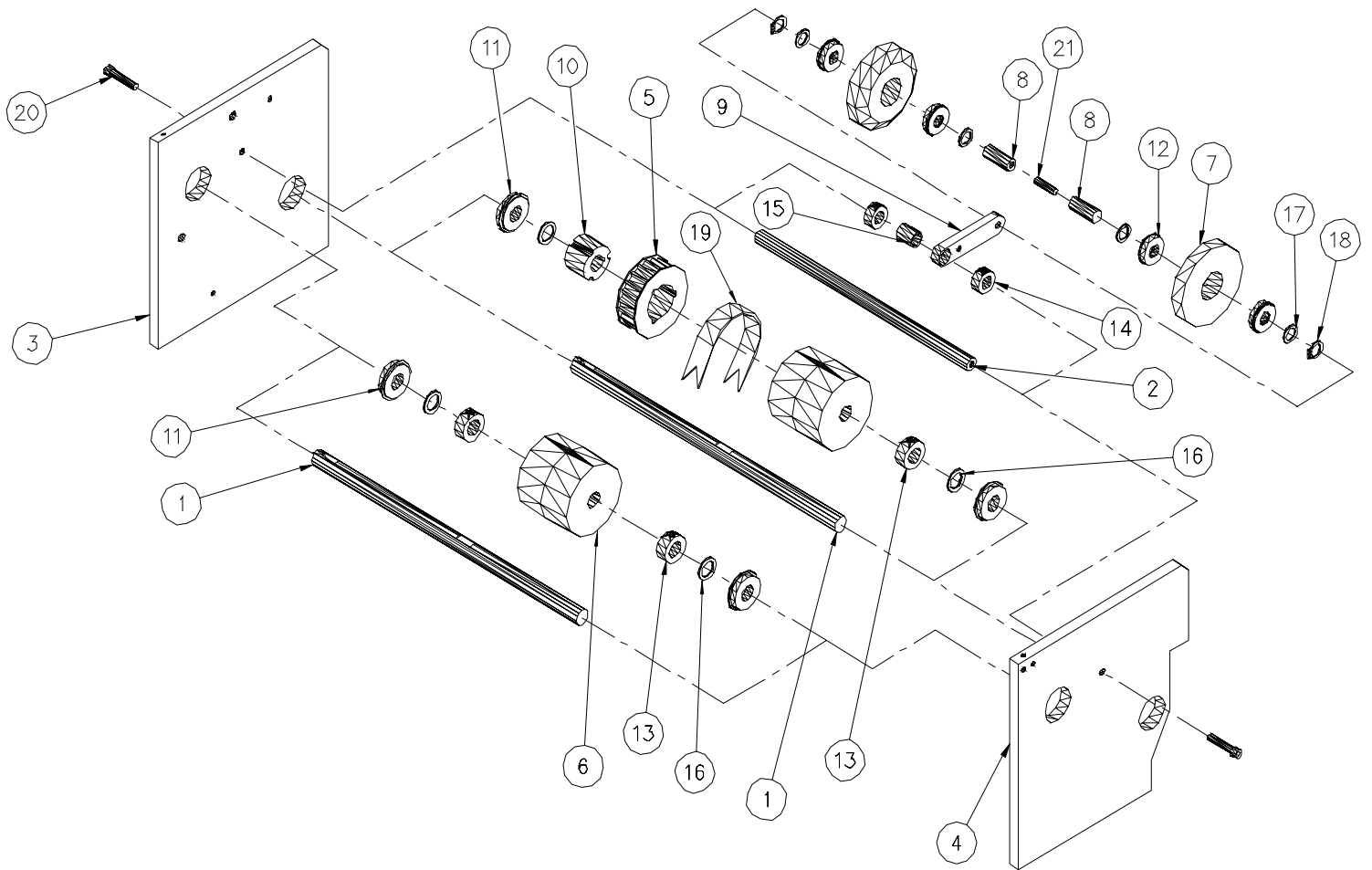
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TURNOVER (Fig. 5-4)
DISCHARGE ASSEMBLY

ITEM	PART NO.	QTY.	DESCRIPTION
1	20004-007	2	SHAFT, DRIVE
2	20004-004	1	SHAFT, NIP PIVOT
3	20000-003	1	SIDEPLATE, DISCHARGE, LH
4	20000-002	1	SIDEPLATE, DISCHARGE, RH
5	99002-035	1	PULLEY, TL22L075, 1008
6	20006-002	2	PULLEY, CROWNED (DRIVE)
7	20006-003	2	ROLLER, EXIT
8	20004-005	2	SHAFT, EXIT ROLLER
9	20008-002	1	BAR, EXIT, ROLLER MTG.
10	99017-019	1	BUSHING, TAPERLOCK 1008, 5/8 BORE
11	99003-006	4	BEARING, SEALED, 5/8 X 1-3/8
12	99003-007	4	BEARING, SEALED, 1/2 X 1-1/8
13	99017-005	3	COLLAR, SET, 5/8
14	99017-004	2	COLLAR, SET, 1/2
15	99003-038	1	BUSHING, 1/2 X 5/8 X 3/4
16	99003-021	4	WASHER, NYLON, 5/8 X 1/16
17	99003-018	4	WASHER, NYLON, 1/2 X 1/16
18	99022-004	2	SNAP RING, 1/2
19	99000-028	1	BELT, 255L075
20		2	SCREW, SKT HD, 1/4-20 X 1
21		1	SCREW, SET, 1/4-20 X 1

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FIG. 5-4



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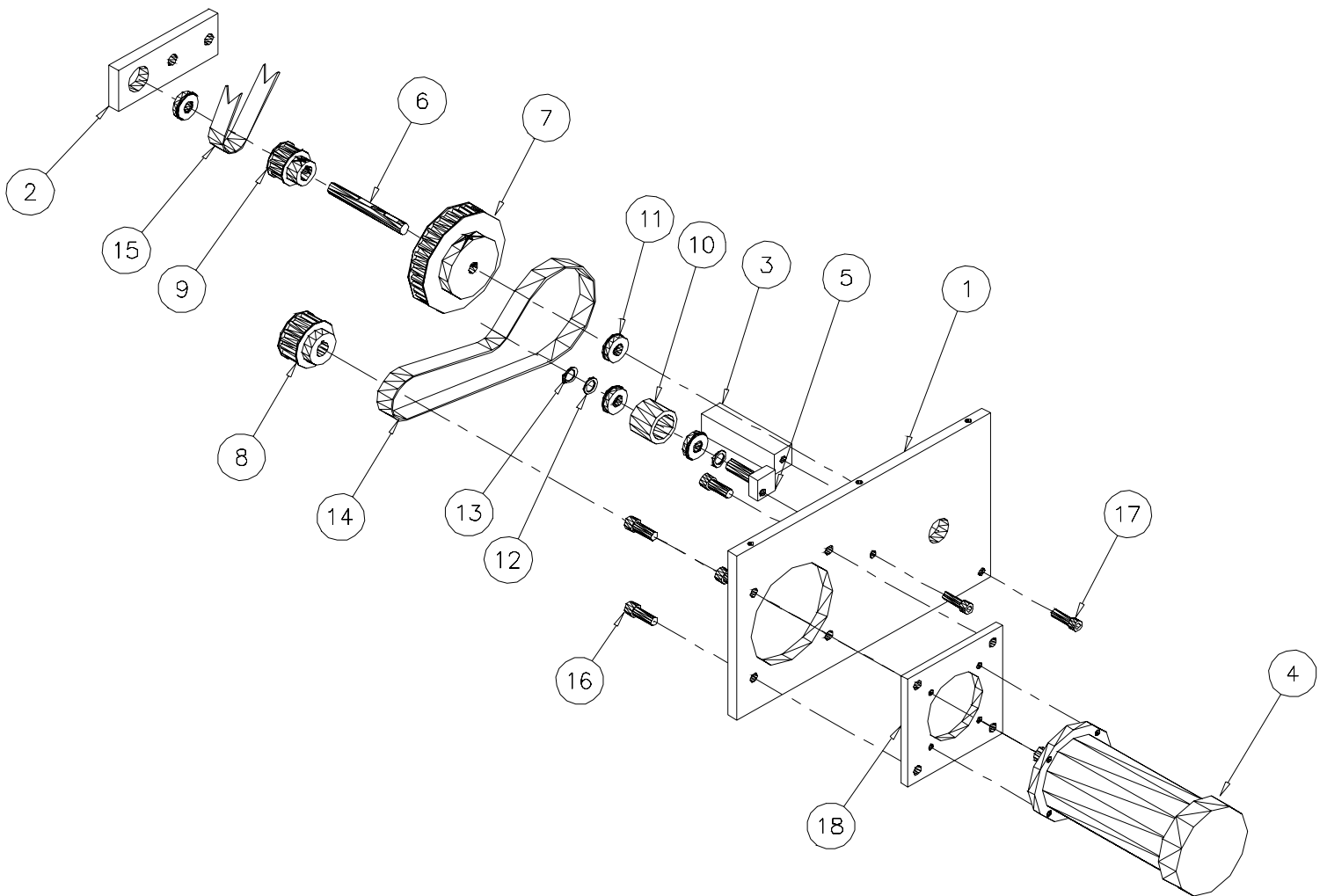
**TURNOVER (Fig. 5-5)
 MOTOR / MOTOR MOUNT ASSEMBLY**

ITEM	PART NO.	QTY.	DESCRIPTION
1	20011-001	1	PLATE, MOTOR MOUNT
2	20011-002	1	PLATE, INTERMEDIATE SHAFT
3	20012-004	1	STANDOFF, MOTOR SUPPORT
4	99001-019	1	DC MOTOR, 1/4 HP
(4)	(99001-004)	(1)	(AC MOTOR, 1/4 HP)
5	18004-022	1	TENSIONER, ECCENTRIC
6	20004-008	1	SHAFT, INTERMEDIATE
7	99002-019	1	PULLEY, 36L075, 1/2 BORE
8	99002-036	1	PULLEY, 16L075, 5/8 BORE
9	99002-018	1	PULLEY, 12L075, 1/2 BORE
10	18006-012	1	ROLLER, TENSIONER
11	99003-007	4	BEARING, SEALED W/ SNAP RING, 1/2 X 1-1/8
12	99003-018	2	WASHER, NYLON, 1/2 X 1/16
13	99022-004	1	SNAP RING, 1/2
14	90000-035	1	BELT, 270L075
15	90000-028	1	BELT, 255L075
16		4	SCREW, SKT HD, 3/8-16 X 1
17		2	SCREW, SKT HD, 5/16-18 X 1
18	20011-005	1	PLATE. MOTOR ADAPTOR

(*MACHINES MANUFACTURED BEFORE JAN. 11, 2002 USE AC DRIVE MOTOR)

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FIG. 5-5

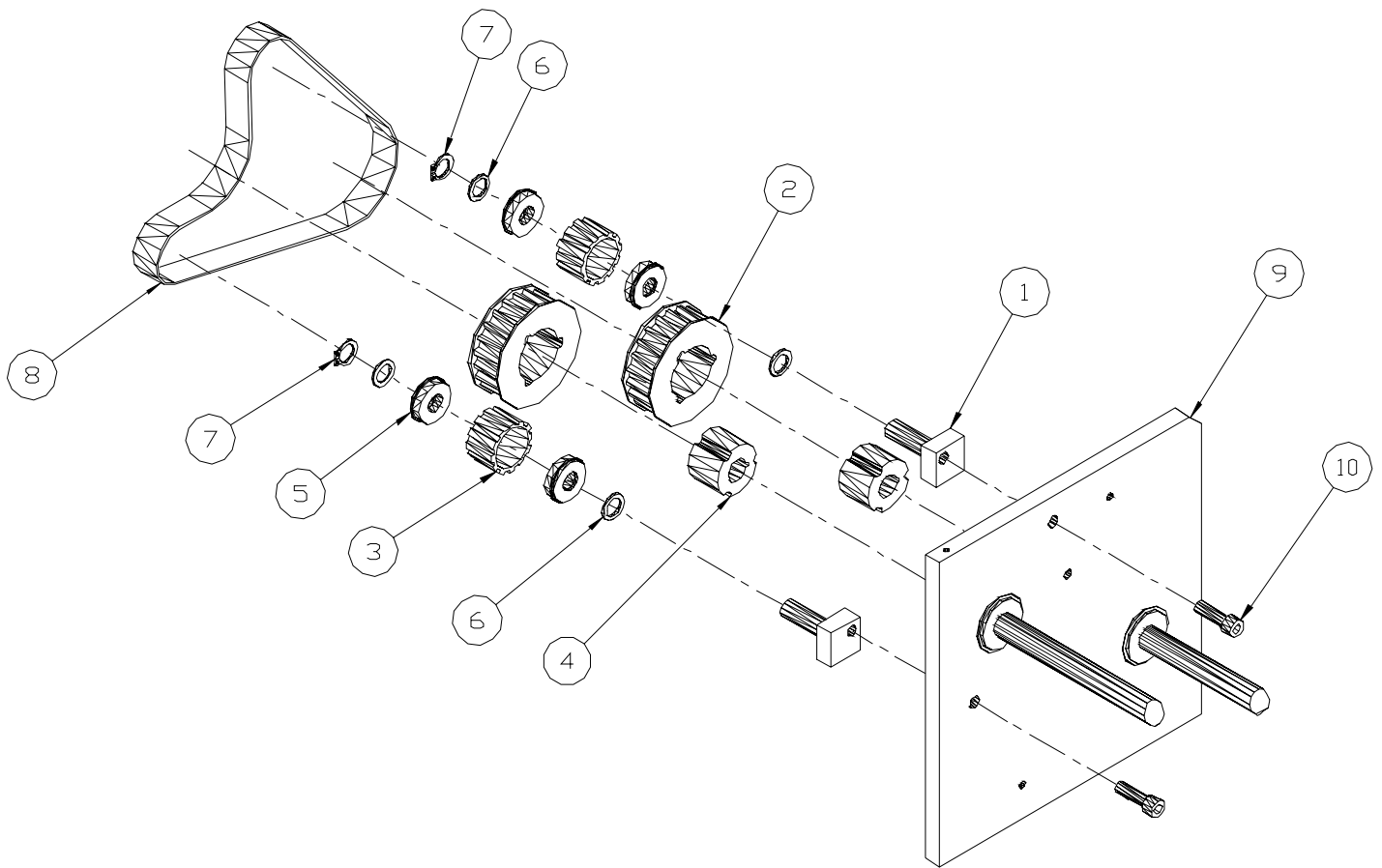


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TURNOVER (Fig. 5-6)
DRIVE ASSEMBLY

ITEM	PART NO.	QTY.	DESCRIPTION
1	18004-022	2	TENSIONER, ECCENTRIC
2	99002-035	2	PULLEY, TL22L075 1008
3	20006-004	2	PULLEY, IDLER, 12L075
4	99017-019	2	BUSHING, TAPERLOCK, 1008, 5/8 BORE
5	99003-007	4	BEARING, SEALED W/ SNAP RING, 1/2 X1-1/8
6	99003-018	4	WASHER, NYLON, 1/2 X 1/16
7	99022-004	2	SNAP RING, 1/2
8	99000-034	1	BELT, D240L075
9	20000-003	1	SIDEPLATE, DISCHARGE, LH (REF. ONLY)
10		2	SCREW, SKT HD, 5/16-18 X 1

FIG. 5-6

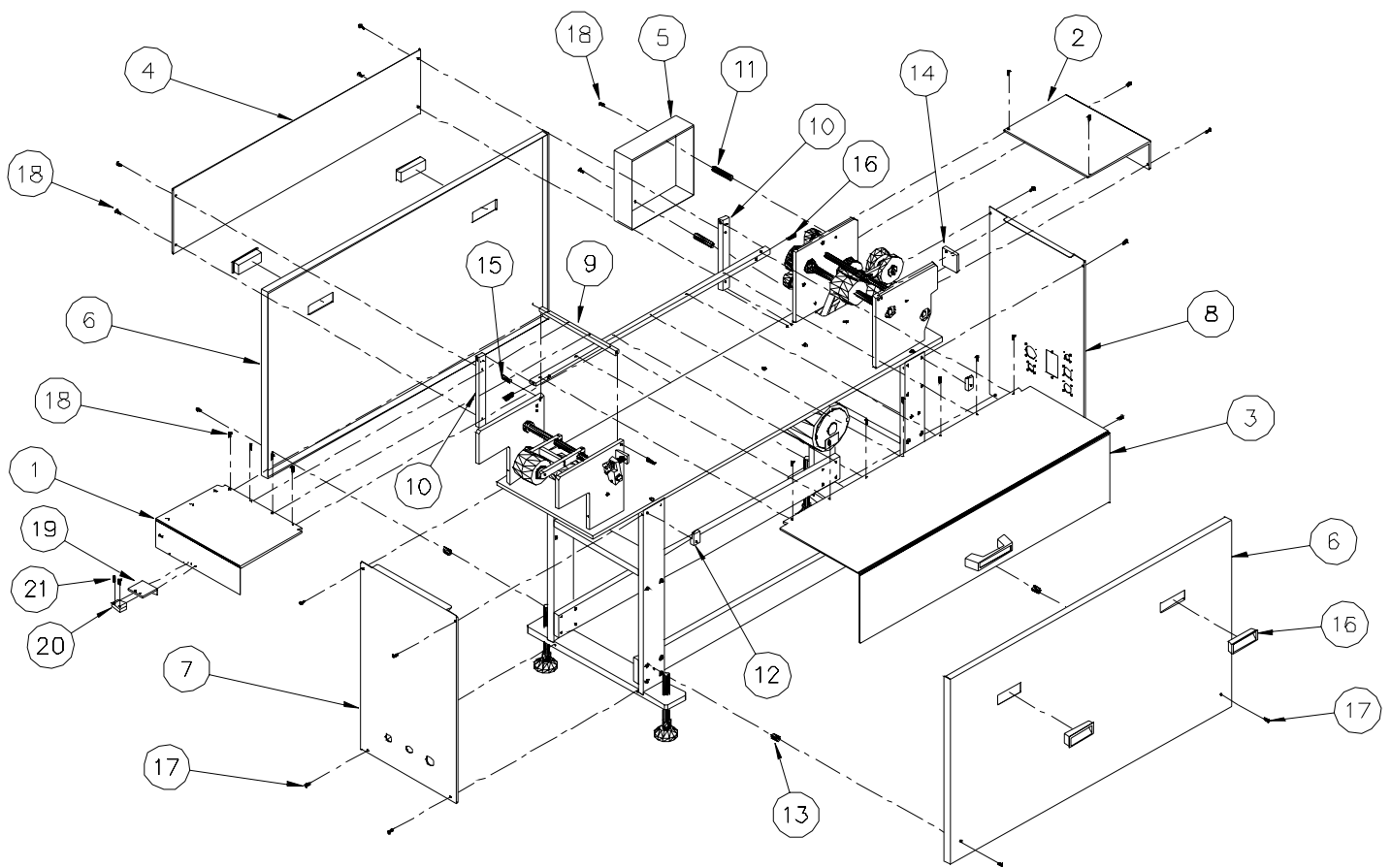


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TURNOVER (Fig. 5-7)
COVER ASSEMBLY

ITEM	PART NO.	QTY.	DESCRIPTION
1	20013-001	1	COVER, INFEED
2	20013-002	1	COVER, DISCHARGE
3	(SEE FIG. 5-9)	1	ASSEMBLY, CENTER COVER
4	20013-008	1	COVER, SIDE
5	20013-006	1	COVER, DRIVE
6	20013-003	2	COVER, SIDE GUARD
7	20013-004	1	COVER, END (INFEED)
8	20013-005	1	COVER, END (DISCHARGE)
9	20008-003	1	BAR, END COVER MTG.
10	20007-004	2	POST, COVER MTG.
11	20012-003	2	STANDOFF, DRIVE COVER
12	18007-042	4	BLOCK, SIDE GUARD COVER MTG.
13	18012-006	4	STANDOFF, SIDE GUARD COVER MTG.
14	20009-001	1	BRACKET, SWITCH MTG.
15	99006-024	4	PIN, STUD, 5/16-24 X 1-1/8
16	99012-002	4	HANDLE, SIDE GUARD COVER
17		12	SCREW, BUTTON HD, 10-24 X 1/2
18		21	SCREW, BUTTON HD, 8-32 X 1/2
19	99018-002	1	BRACKET, SENSOR MTG (TURNOVER)
20	98009-002	1	SENSOR, SENDER & RECIEVER, P & F THRU BEAM
21		2	SCREW, PAN HD, 6-32 X 1/4

FIG. 5-7

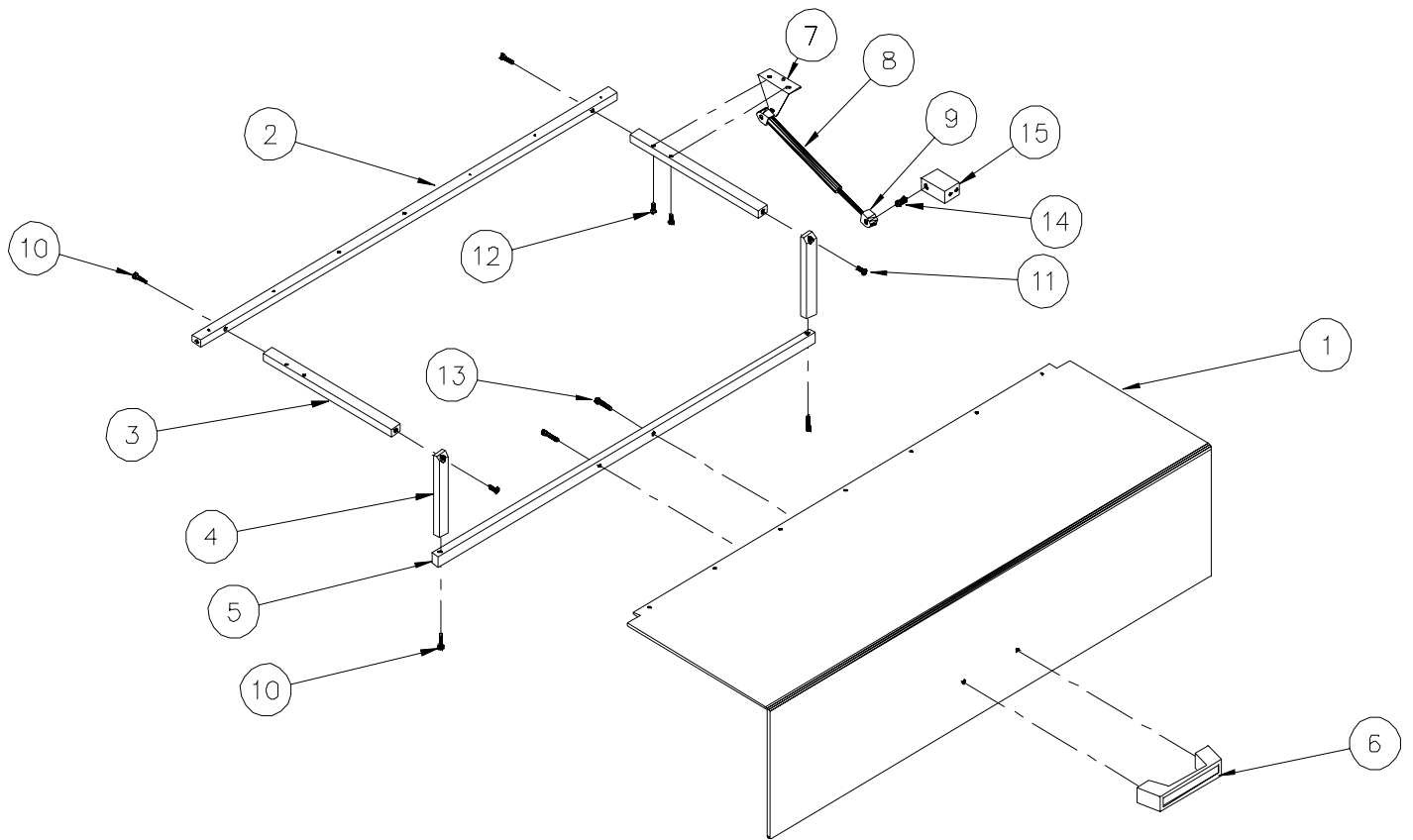


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TURNOVER - COVERS (Fig. 5-8)
CENTER COVER ASSEMBLY

ITEM	PART NO.	QTY.	DESCRIPTION
1	20013-007	1	COVER, CENTER
2	20008-004	1	BAR, COVER MTG.
3	20008-010	2	BAR, COVER SUPPORT (TOP)
4	20008-009	2	BAR, COVER SUPPORT (SIDE)
5	20008-006	1	BAR, COVER SUPPORT (HANDLE)
6	99012-001	1	HANDLE, CENTER COVER
7	99014-008	1	BALL STUD ANGLE BRACKET
8	99014-007	1	GAS SPRING
9	99014-005	2	BALL SOCKET END FITTING
10		4	SCREW, SKT HD, 1/4-20 X 3/4
11		2	SCREW, SKT HD, 1/4-20 X 1/2
12		2	SCREW, PAN HD, 10-24 X 1/2
13		2	SCREW, SKT HD, 1/4-20 X 1
14	99014-009	1	BALL STUD
15	20007-007	1	BLOCK, GAS SPRING MGT.

FIG. 5-8



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TURNOVER – ELECTRICAL ASSEMBLY (Fig. 5-9)

ITEM	PART NO.	QTY.	DESCRIPTION
1	20013-022	2	COVER, END, DISCHARGE
2	12013-001	1	ENCLOSURE, ELECTRICAL
3	120013-002	1	COVER, ELECTRICAL ENCLOSURE
4	98016-032	2	COVER PLATE, CONDUIT BOX
5	98006-007	1	SPEED POT, 5K
6	98000-001	1	SWITCH, ROCKER, ON/OFF
7	98015-001	1	STRAIN RELIEF, 1/2"
8	98015-023	7	FINISHING PLUG, PLASTIC, BLACK, 7/8 HOLE
9	98005-007	1	MOTOR CONTROLLER, 240 VAC
10	98007-001	1	POWER CORD (NOT SHOWN)
11	98015-009	4	CONNECTOR, ROMEX, 3/8"

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FIG. 5-9

