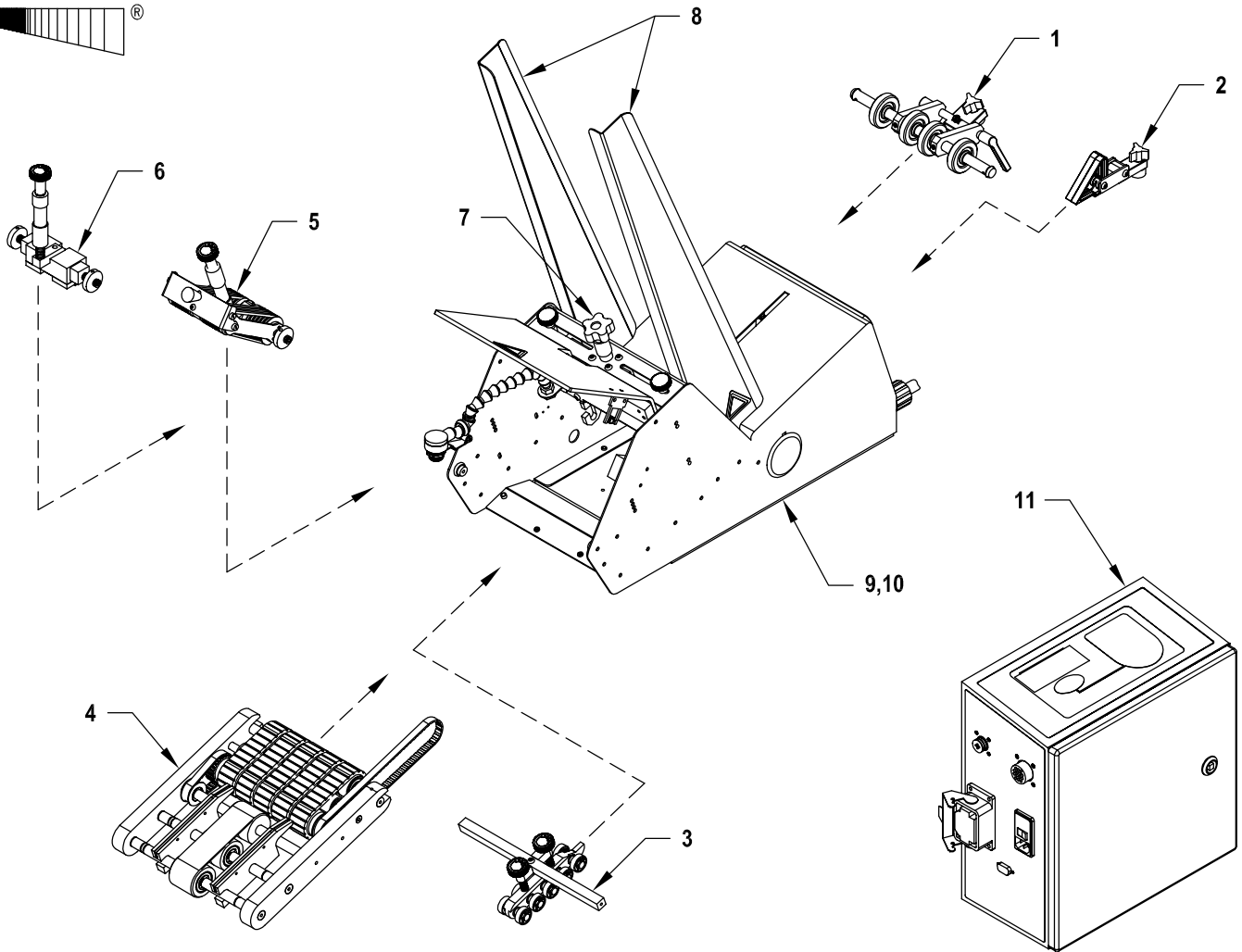


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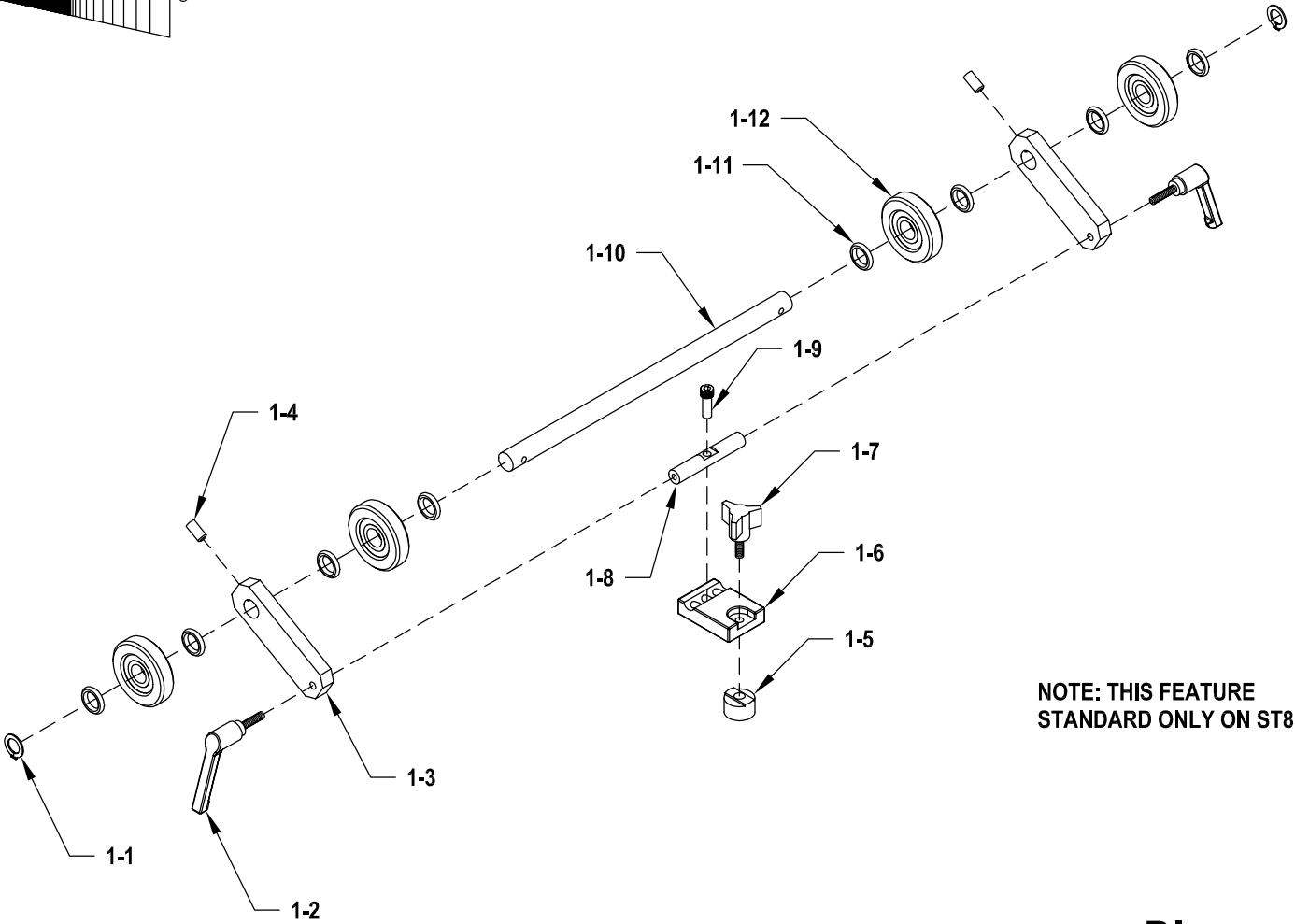
ST550 / ST850

ST550 / ST850

1: ARTICULATING ROLLER WEDGE ASSEMBLY #63311340

NOTE: THIS FEATURE STANDARD ONLY ON ST850

<u>DIAGRAM NUMBER</u>	<u>QTY</u>	<u>DESCRIPTION</u>	<u>PART NUMBER</u>
1-1	2	Ring Grip 1/2 Waldes	00001115
1-2	2	Lever Adjustment 10-32 X .75	43555098
1-3	2	Bracket Roller Wedge Pivot	44633024
1-4	2	Screw Socket Set 1/4-20 X 1/2" LG	00002327
1-5	1	T-Nut Round	44633016
1-6	1	Wedge Block	44633014
1-7	1	Knob 3 Lobe 10-32 X 5/8	44633033
1-8	1	Roller Wedge Shaft	44633010
1-9	1	SHCS 10-32 X 5/8" LG	00002320
1-10	1	Shaft Idler	23560147
1-11	8	O Ring 7/16	44340017
1-12	4	Bearing Ball R8	23500094
	4	Wedge Roller Wheel	44340012



NOTE: THIS FEATURE
STANDARD ONLY ON ST850

ST550 / ST850

Diagram 1
Articulating Roller Wedge
Assembly #63311340

ST550 / ST850

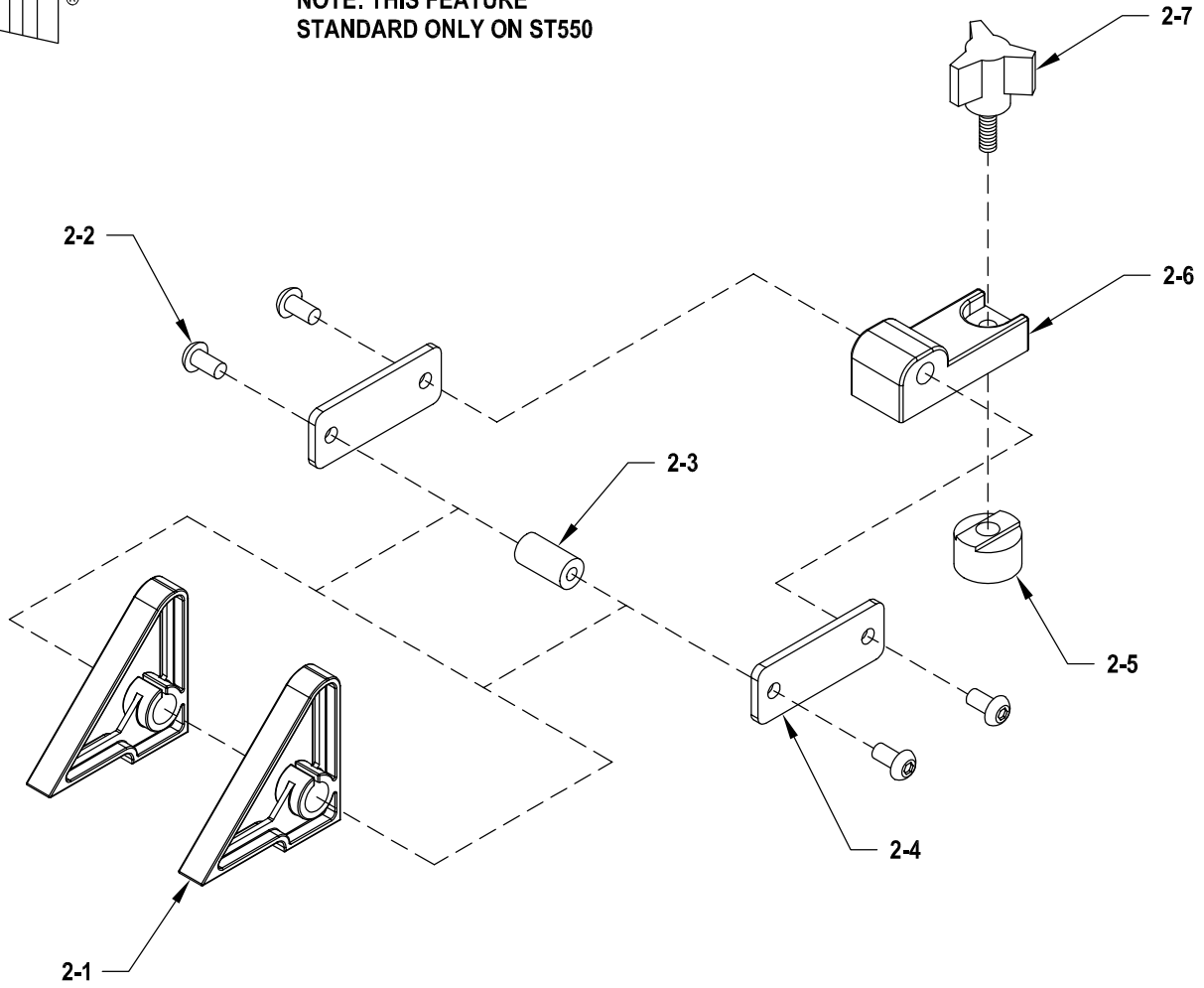
2: EXTENDED NARROW WEDGE ASSEMBLY #63311212

NOTE: THIS FEATURE STANDARD ONLY ON ST550

<u>DIAGRAM NUMBER</u>	<u>QTY</u>	<u>DESCRIPTION</u>	<u>PART NUMBER</u>
2-1	2	Wedge Material Support	33560212
2-2	4	BHCS 10-32 X 3/8	00002305
2-3	1	Shaft, Belt Tensioner 3/8	43555077
2-4	2	Bracket Extension Narrow Wedge	44633022
2-5	1	T-Nut Round	44633016
2-6	1	Block Hold Down Wedge	44633021
2-7	1	Knob 3 Lobe 10-32 X 5/8	44633033



NOTE: THIS FEATURE
STANDARD ONLY ON ST550



ST550 / ST850

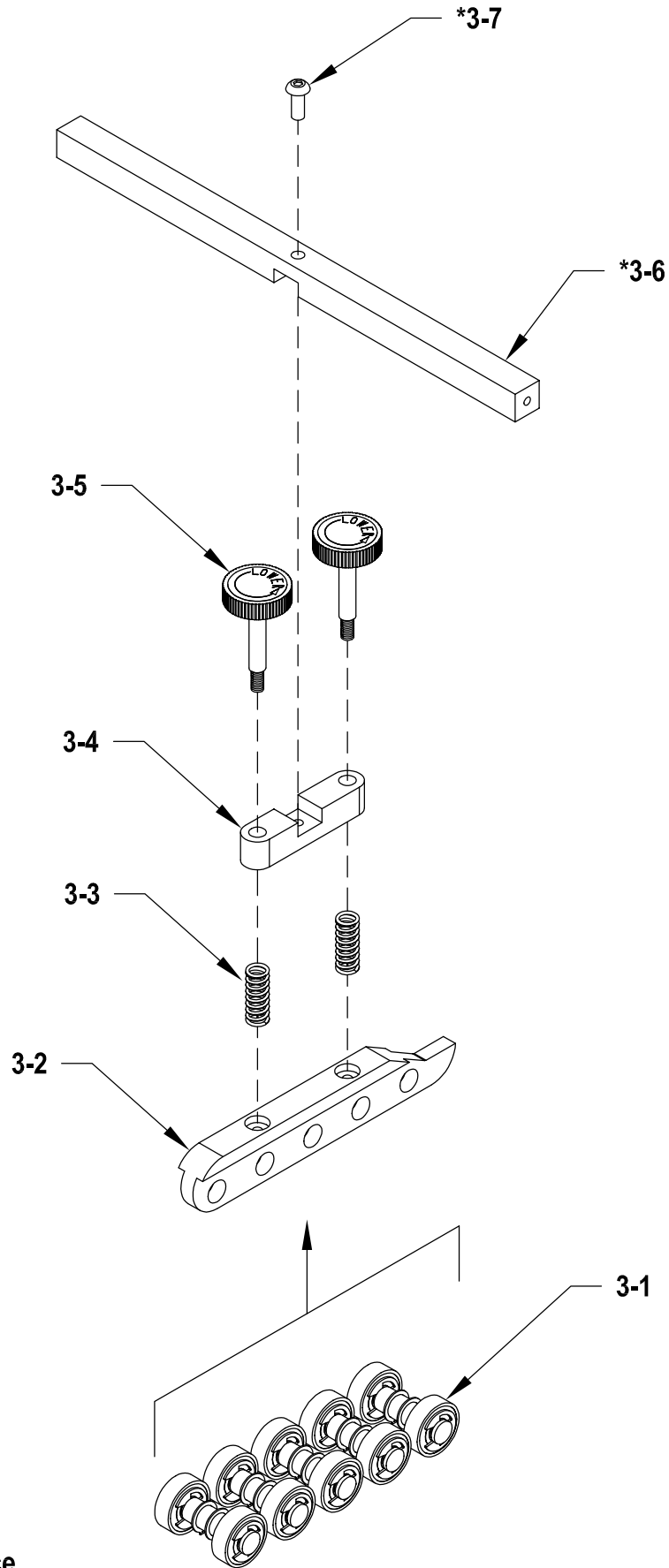
Diagram 2
Extended Narrow Wedge
Assembly #63311212

ST 550 / ST850

3: 5 AXLE HOLD DOWN ASSEMBLY #43511310

<u>DIAGRAM NUMBER</u>	<u>QTY</u>	<u>DESCRIPTION</u>	<u>PART NUMBER</u>
3-1	5	Bearing Holder Shaft	43560008
	10	Bearing Ball R6	23500095
	10	Ring Grip 3/8 Waldes	00001110
	20	Clip E 3/8 Waldes	00001150
3-2	1	Holder Bearing 5 Axle	43560310
3-3	2	Spring Compression	23560083
3-4	1	Bar Hold Down Adjustment	23560086
3-5	2	Hold Down Knob Assembly	23511077
*3-6	1	Bar Cross Support	33560215 (550) 23560215 (850)
*3-7	1	BHCS 10-32 X 1/2" LG	00002334

*Part exists in diagram for reference only and is not included with this assembly. Must be ordered separately.



*Part exists in diagram for reference only and is not included with this assembly. Must be ordered separately.

ST550 / ST850

Diagram 3

5 Axle Hold Down
Assembly #43511310

ST550 / ST850

4: GROOVED GUM RUBBER CARRIAGE #71011162 (550) #70011162 (850)

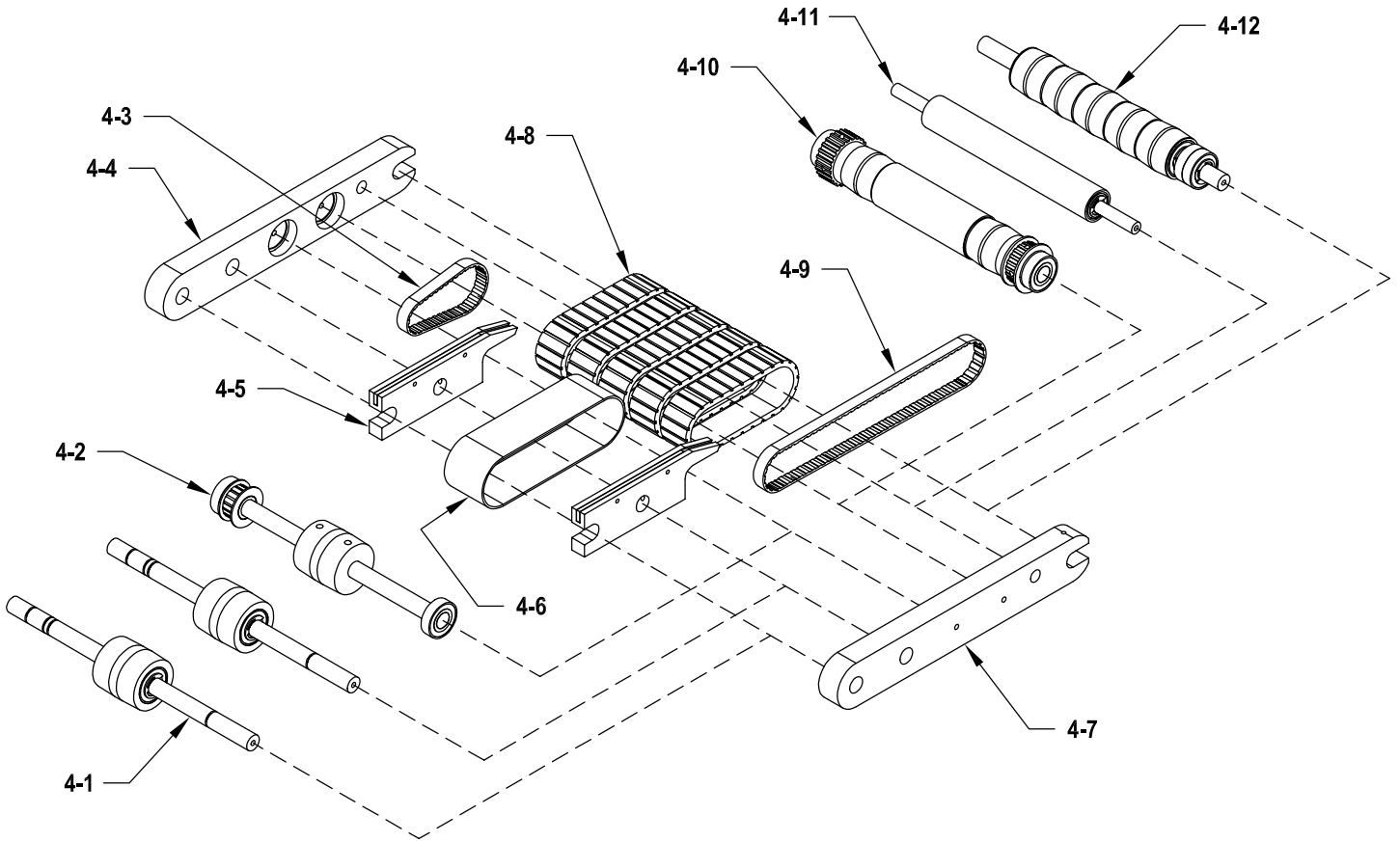
<u>DIAGRAM NUMBER</u>	<u>QTY</u>	<u>DESCRIPTION</u>	<u>P/N 550</u>	<u>P/N 850</u>
4-1	2	Shaft, Idler	33560047	23560047
	2	Roller Crown Driven with Bearings	→	23511105
	4	Clip E 1/2 Waldes	→	00001155
4-2	1	Shaft Drive 1/2 SS	33560211	23560211
	1	Drive Crown Pulley	→	23560106
	1	Pulley, Timing 16XL037 .500 KDFA	→	43560097
	2	Screw Socket Set 10-32 X 1/8" LG	→	00003352
	2	Screw Socket Set 1/4-20 1/2" LG	→	00002327
	2	Bearing Ball R8	→	23500094
	1	Woodruff Key 1/8 X 3/8	→	00003351
	1			
4-3	1	Belt, Timing 78XL037	→	23560078
4-4	1	Holder Right Hand Carriage	→	23560202
4-5	2	Rail, Material Support Slide	→	23560082
	2	Slide, Anti Dive	→	44970006
	4	Screw Socket Set 8-32 X 1/4" LG	→	00002203
4-6	1	Belt Discharge Clear 1.5 Wide	→	23560088
4-7	1	Holder Left Hand Carriage	→	23560203
4-8	3 (550)	Belt, Feed Tan Gum 24G Liner 1W X 9L	→	23500162
	5 (850)			
4-9	1	Belt, Timing 170XL037	→	43500096
4-10	1	Shaft Drive	44710012	44700016
	1	Pulley, Timing 24XL037 .500KA	→	43560098
	1	Pulley, Timing 20XL037 .500KDFA	→	23500097
	2	Bearing Ball R8	→	23500094
	2	Clip E 1/2 Waldes	→	00001155
	2	Key Woodruff 1/8 X 3/8	→	00003351
	1	Screw Socket Set 10-32 X 1/4" LG	→	00002216
	3	Screw Socket Set 10-32 X 5/16" LG	→	00002217

Grooved gum rubber carriage continued on next page....

ST550 / ST850

4: GROOVED GUM RUBBER CARRIAGE

<u>DIAGRAM NUMBER</u>	<u>QTY</u>	<u>DESCRIPTION</u>	<u>P/N 550</u>	<u>P/N 850</u>
4-11	1	Shaft Belt Support Bearing	33560040	23500040
	1	Tube Belt Support	23500270	44700002
	2	Bearing Ball R6	→	23500095
	2	Clip E 3/8 Waldes	→	00001150
4-12	1	Shaft Idler	33560047	23560047
	1	Tube Driven	44710003	44700001
	4	Bearing Ball R8	→	23500094
	1	Grip Ring, 1/2 Shaft	00001115	
	2 (550)	Clip E 1/2 Waldes	→	00001155
	4 (850)			



ST550 / ST850

Diagram 4
Grooved Gum Rubber
Carriage
Assy #71011162 (550)
Assy #70011162 (850)

ST550 / ST850

5: ADVANCING O RING GATE w/HORIZON ADJUST ASSEMBLY #87211001

NOTE: THIS FEATURE STANDARD ONLY ON ST850

<u>DIAGRAM NUMBER</u>	<u>QTY</u>	<u>DESCRIPTION</u>	<u>PART NUMBER</u>
5-1	1	Handle Studded 10-32 X 1/2	44657007
5-2	1	BHCS 8-32 X 1/2" LG	00002302
5-3	1	Spacer Belt Indexer .312 X .375	44657010
5-4	2	Screw Shoulder 8-32 Slotted	00003320
5-5	2	Screw Shoulder 8-32 X 1/8	00003321
5-6	1	Belt Indexer Bracket	44657005
5-7	1	Pinch Roll Cam	44657003
5-8	1	Belt Indexer Shaft	44657008
	2	O Ring Take Up Roller	44657002
	1	Belt Indexer Center Hub	44657009
	2	Clip E 1/2 Waldes	00001155
	2	Screw Socket Set 8-32 X 5/16" LG	00002211
5-9	2	Roller	44872003
	2	Adjustment Screw	44872005
	2	SHSS 10-32 X 3/8" LG Nylon Tip	44872007
5-10	12	O Ring Advancing Gate SDO	44657006
5-11	2	Side Plate Adjust	44872002
5-12	4	Pin Roll 1/8 X 1/2	00001161
5-13	1	BHCS 10-32 X 1" LG	00002340
5-14	1	Gate Cylinder w/Horizon (Not Sold Individually)	44872004
5-15	1	BHCS 10-32 X 1/2" LG	00002334
5-16	1	Mount Gate Lift Shaft	15000001
5-17	1	Shaft Gate Lift	23560084
	1	Spring Gate Compression	23500083

Advancing o ring gate continued on next page....

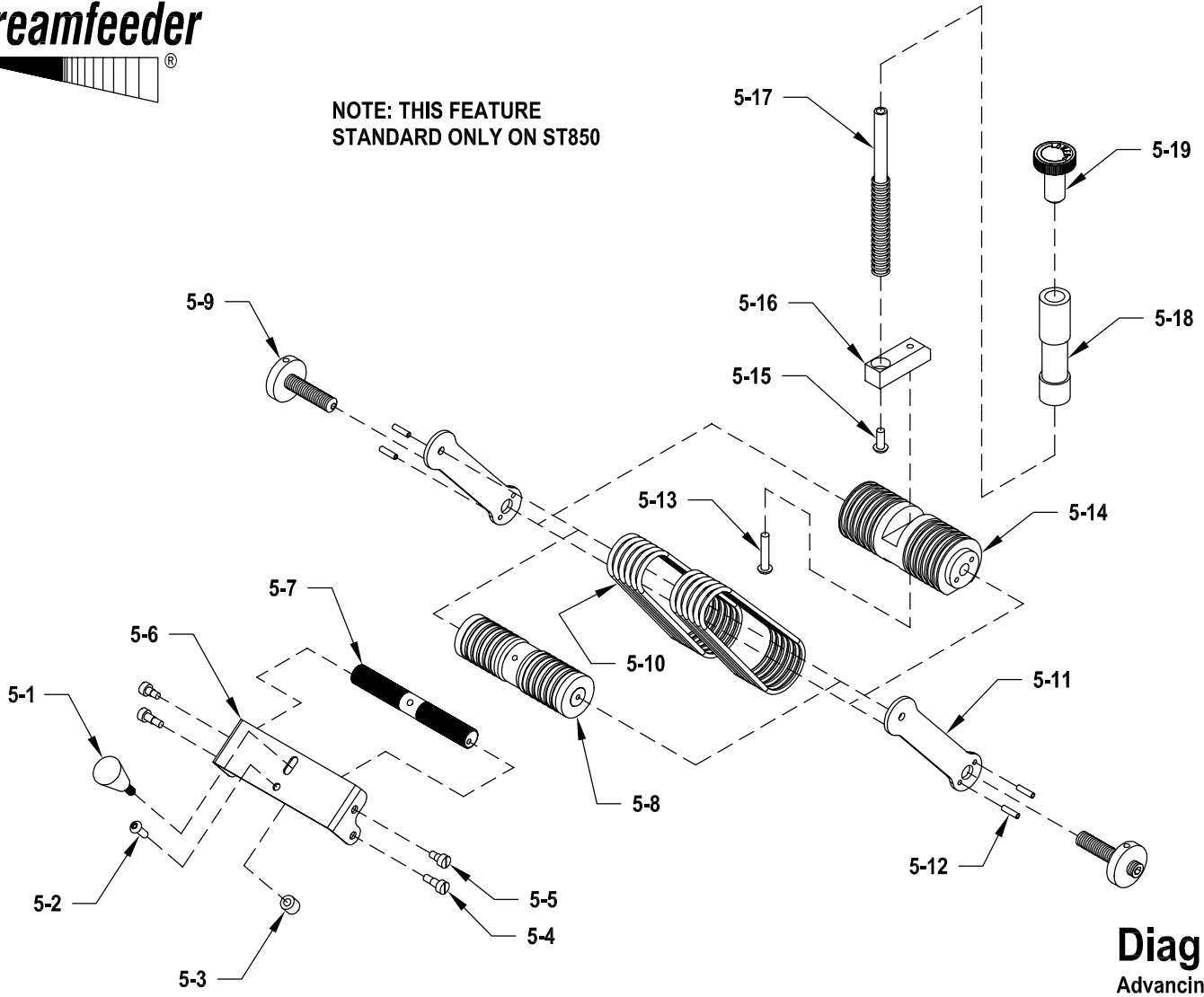
ST550 / ST850

5: ADVANCING O RING GATE w/HORIZON ADJUST

<u>DIAGRAM NUMBER</u>	<u>QTY</u>	<u>DESCRIPTION</u>	<u>PART NUMBER</u>
5-18	1	Cylinder Gate Spring Tension	23500019
5-19	1	Adjustment Knob Assembly for Gate	23511037



NOTE: THIS FEATURE
STANDARD ONLY ON ST850



ST550 / ST850

Diagram 5
Advancing O Ring Gate
w/Horizon Adjust
Assembly #87211001

ST550 / ST850

6: BAR GATE II w/HORIZON ADJUST & URETHANE INSERT ASSEMBLY #15011872

NOTE: THIS FEATURE STANDARD ONLY ON ST550

<u>DIAGRAM NUMBER</u>	<u>QTY</u>	<u>DESCRIPTION</u>	<u>PART NUMBER</u>
6-1	2	SHCS 10-32 X 1/2" LG	00002315
6-2	1	V-Bar Gate Belting Holder	44500067
6-3	1	V Belting, 3/8 X 3 Inch Orange Urethane	44500054
6-4	1	SHCS 10-32 X 1" LG	00002335
6-5	2	Adjustment Screw	44872005
6-6	2	Roller	44872003
	2	Screw Socket Set 10-32 X 3/8" LG Nylon Tip	44872007
6-7	1	BHCS 10-32 X 1/2" LG	00002334
6-8	1	Mount Gate Lift Shaft	15000001
6-9	1	Bar Gate II Cylinder Horizon	44996008
	2	Screw Socket Set 10-32 X 1/4" LG Cup Point	00002216
6-10	1	Shaft Gate Lift	23560084
	1	Spring Gate Compression	23500083
6-11	1	Cylinder Gate Spring Tension	23500019
6-12	1	Adjustment Knob Assembly for Gate	23511037



NOTE: THIS FEATURE
STANDARD ONLY ON ST550

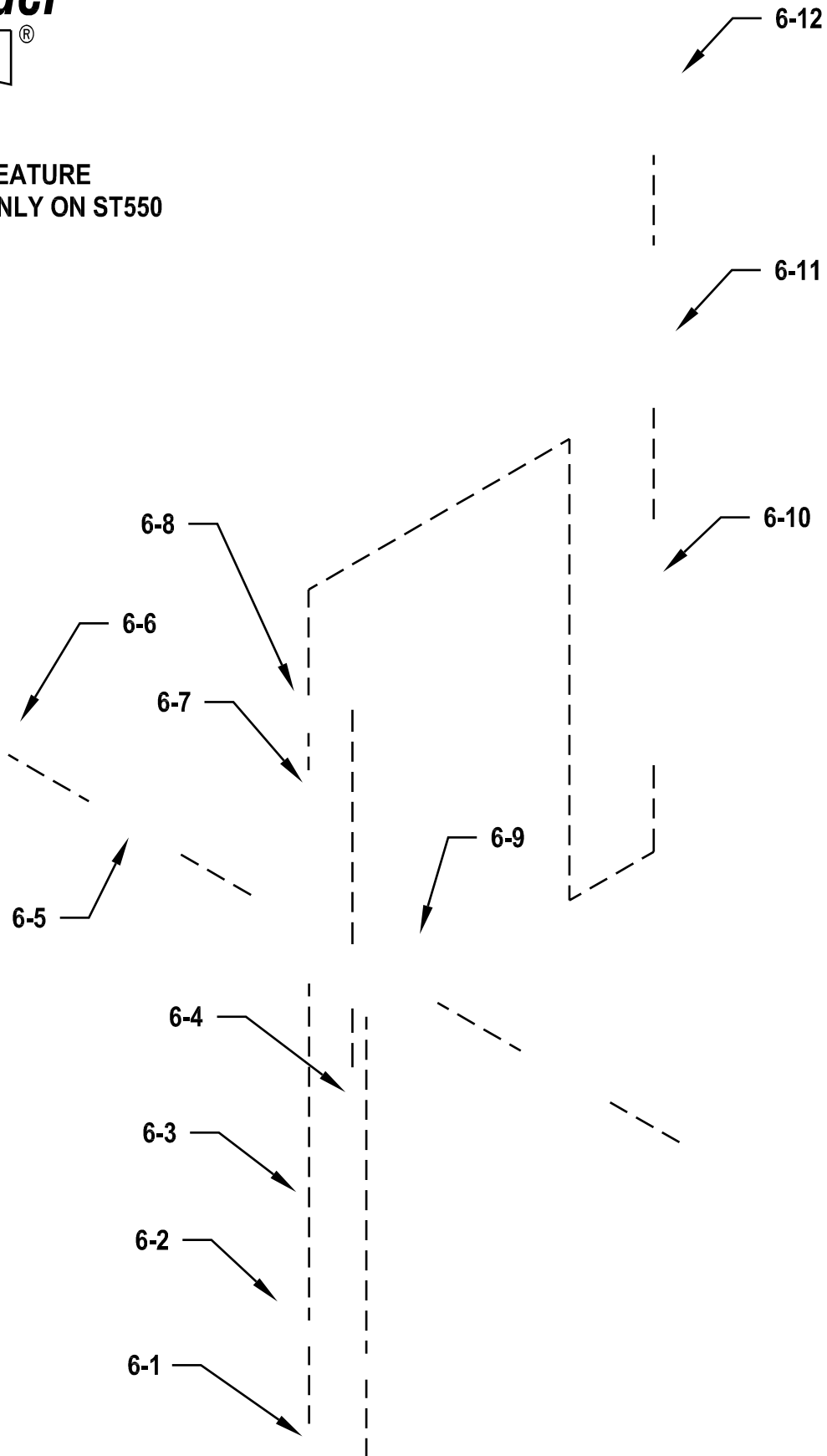


Diagram 6

cn Adjust

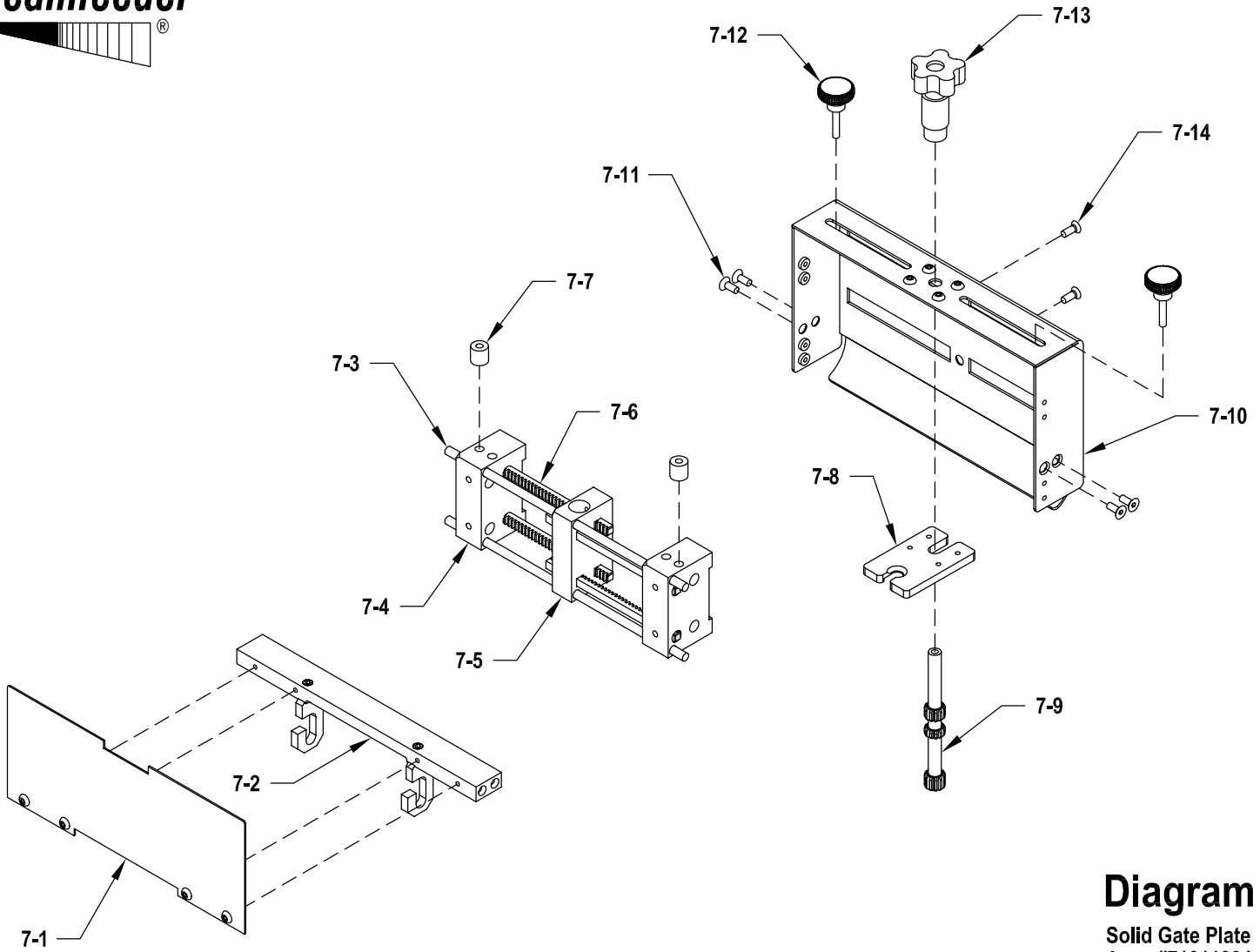
ST550 / ST850

Assembly #15011872

ST550 / ST850

7: SOLID GATE PLATE #71011004 (550) #70011004 (850)

<u>DIAGRAM NUMBER</u>	<u>QTY</u>	<u>DESCRIPTION</u>	<u>P/N 550</u>	<u>P/N 850</u>
7-1	1	Cover Side Guide Adjustment	44710011	44700014
	4(850)	BHCS 10-32 X 3/8" LG	→	00002805
	2(550)			
7-2	1	Bar Lower Gate Support	44710008	44700011
	2	Hook Gate J	→	15000007
	2	SHCS 8-32 X 5/8" LG	→	00002215
7-3	2	Rail Side Guide Support	44710009	44700012
7-4	2	Side Guide Adjustment Block	→	44646001
	4	Screw Socket Set 1/4-20 X 1/4" LG	→	00002205
7-5	1	Guide Stationary Block Side	→	44646002
7-6	4	Rack	44710010	44700013
7-7	2	Spacer Lower	→	44646015
7-8	1	Block Adjustment Reference	→	44646004
	4	BHCS 10-32 X 3/8" LG	→	00002805
7-9	1	Shaft Pinion Adjustment	→	44646005
7-10	1	Solid Gate Plate	44710002	44700005
7-11	4	Screw Flat Head 10-32 X 3/8" LG	→	00002234
7-12	2	Knob Plastic 10-32	→	44681021
	2	Screw Socket Set 10-32 X 1-1/2" LG	→	00003313
	2	Spacer Upper	→	44646016
7-13	1	Knob 5 Lobe	→	44646009
	1	Spring Retainer Upper	→	44646008
	1	Spring Retainer Lower	→	44646007
	1	Spring Compression	→	44646013
7-14	2	Screw Flat Head 10-32 X 1/2" LG	→	00002830



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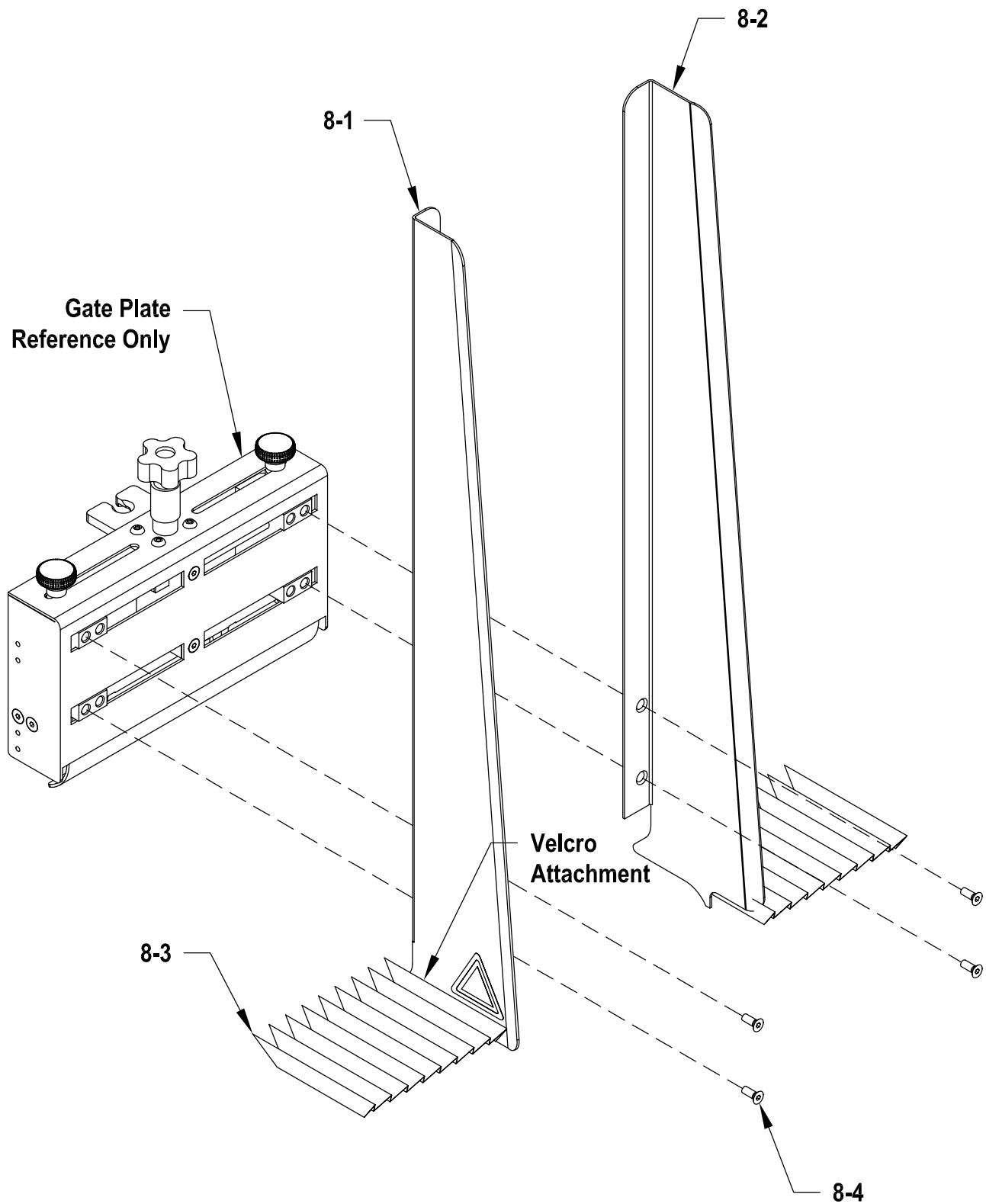
Diagram 7

Solid Gate Plate
Assy #71011004 (550)
Assy #70011004 (850)

ST550 / ST850

8: SIDE GUIDES & RELATED ITEMS

<u>DIAGRAM NUMBER</u>	<u>QTY</u>	<u>DESCRIPTION</u>	<u>PART NUMBER</u>
8-1	1	Side Guide Left 1424	44640017
	1	Label Warning Belt Pinch Point	44600005
8-2	1	Side Guide Right 1424	44640018
	1	Label Warning Belt Pinch Point	44600005
8-3	2	Guard Rear Accordion	44600001
8-4	4	Screw Flat Head 10-32 X 1/2" LG	00002830



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Diagram 8
Side Guides &
Related Items

ST550 / ST850

9: BASE - EXTERIOR

<u>DIAGRAM NUMBER</u>	<u>QTY</u>	<u>DESCRIPTION</u>	<u>P/N 550</u>	<u>P/N 850</u>
9-1	1	Cover, Top Protective	44710006	44700009
	1	Label, Roller Pinch Point Warning	→	44600004
	1	Key, Safety Interlock	→	44649010
9-2	2	Hinge, Top Cover Mount	→	44640012
9-3	1	Shell	44710001	44700004
9-4	2	Shaft, Top Cover Hinge Mount	→	44640011
9-5	1	Sheet Sensor Assembly	→	70011008
9-6	2	Bracket, Rubber Spacer	→	44640009
	2	O Ring, Support Cover	→	43555068
9-7	1	Safety Interlock Switch Assembly	→	70011007
9-8	1	Plug, 2 Inch Hole Cover	→	44500061
	1	Label, Belt Routing	→	44500071
9-9	1	Cover, Bottom Protective	44710007	44700010
9-10	1	Plate, Cover	44710016	44700023
9-11	1	Cable, 5 foot Interconnect	→	68311003
9-12	1	Graphic	44710017	44700024

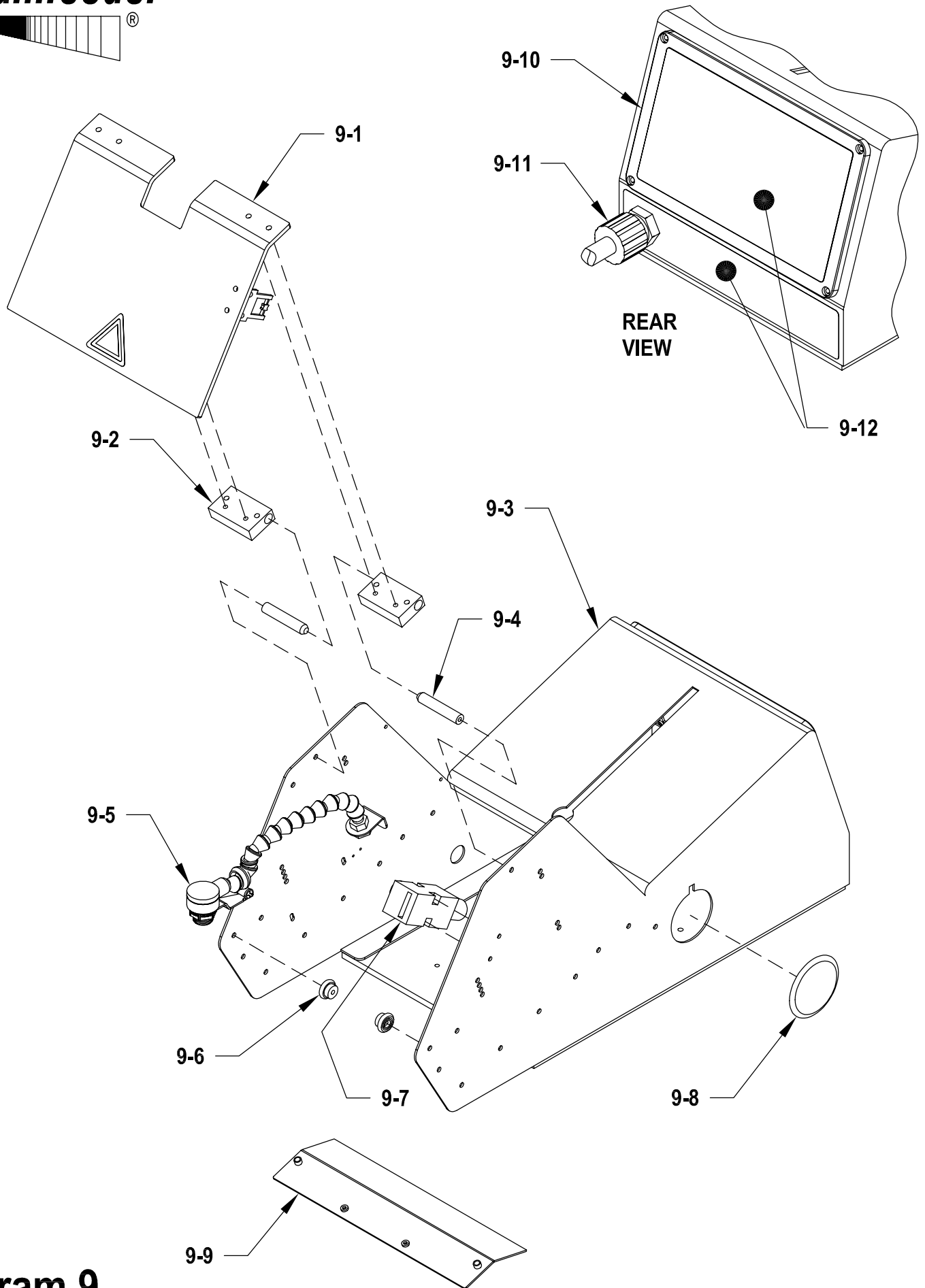


Diagram 9
Base - Exterior

ST550 / ST850

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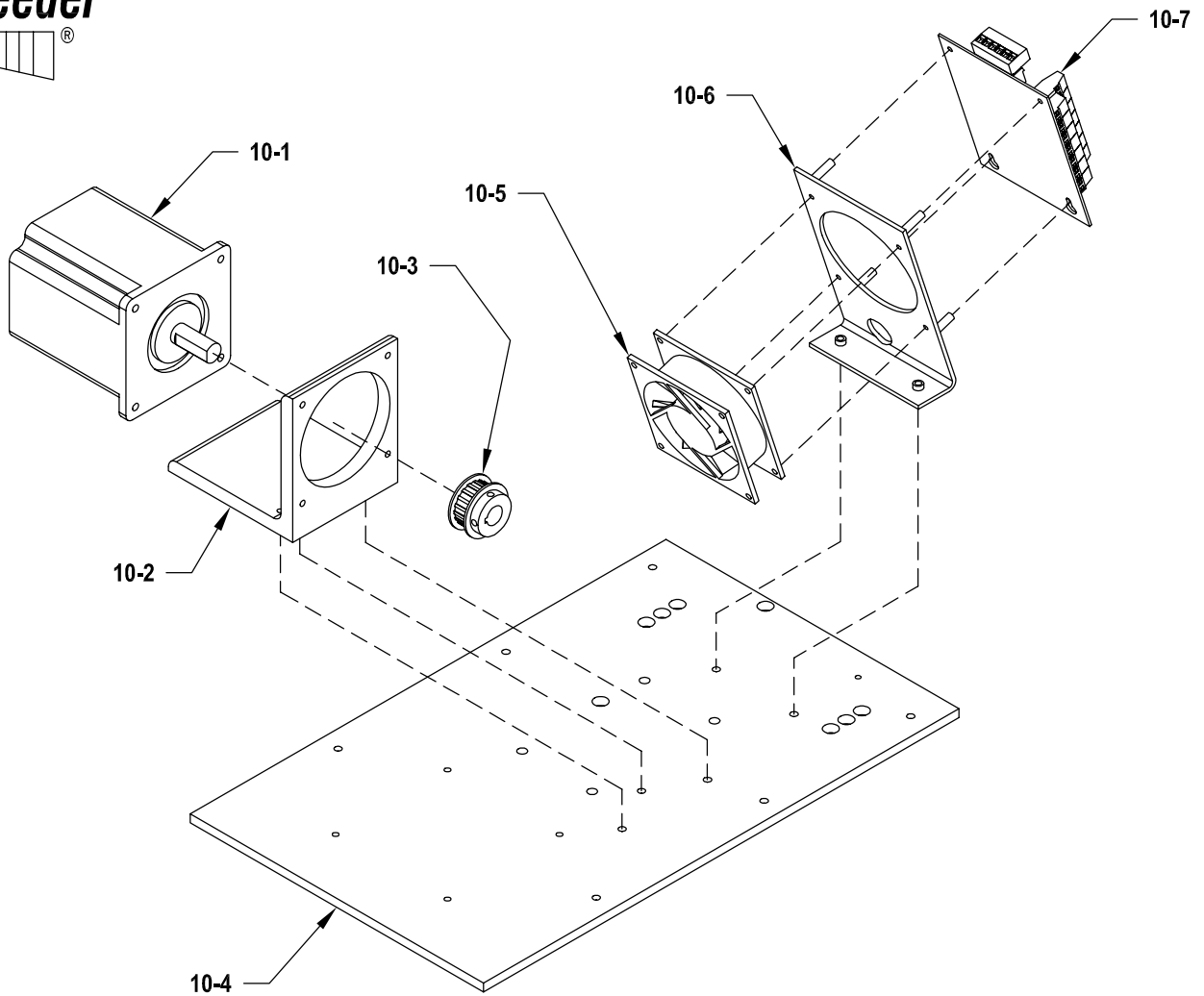
10: BASE - INTERIOR

<u>DIAGRAM NUMBER</u>	<u>QTY</u>	<u>DESCRIPTION</u>	<u>PART NUMBER</u>
10-1	1	Stepper Drive Motor Assembly	53511390
10-2	1	Motor Mount	44630011
10-3	1	Pulley, Timing 18XL037 .500KDFHA	44350053
	2	Screw Socket Set 10-32 X 1/8	00003352
	(spec. length)	Key Stock 1/8	44852080
10-4	1	Mounting Base	44710013 (550) 44700017 (850)
10-5	1	Fan Assembly	70011001
10-6	1	Bracket, Fan Mounting	44700018
10-7	1	I/O Distribution Board	44700021

BASE FEATURES – NOT SHOWN

<u>QTY</u>	<u>DESCRIPTION</u>	<u>PART NUMBER</u>
3	Mount, Cable Adhesive C Type	23500079
1	Belt Tensioner Assembly	23511290
1	Tie, Cable Black	435S0263
1	Power Cord (115V Models Only)	53511020
1	Power Cord & Allen Wrenches (230V Only)	53522210
1	Flight Sensor Assembly	63011038

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Diagram 10
Base - Interior

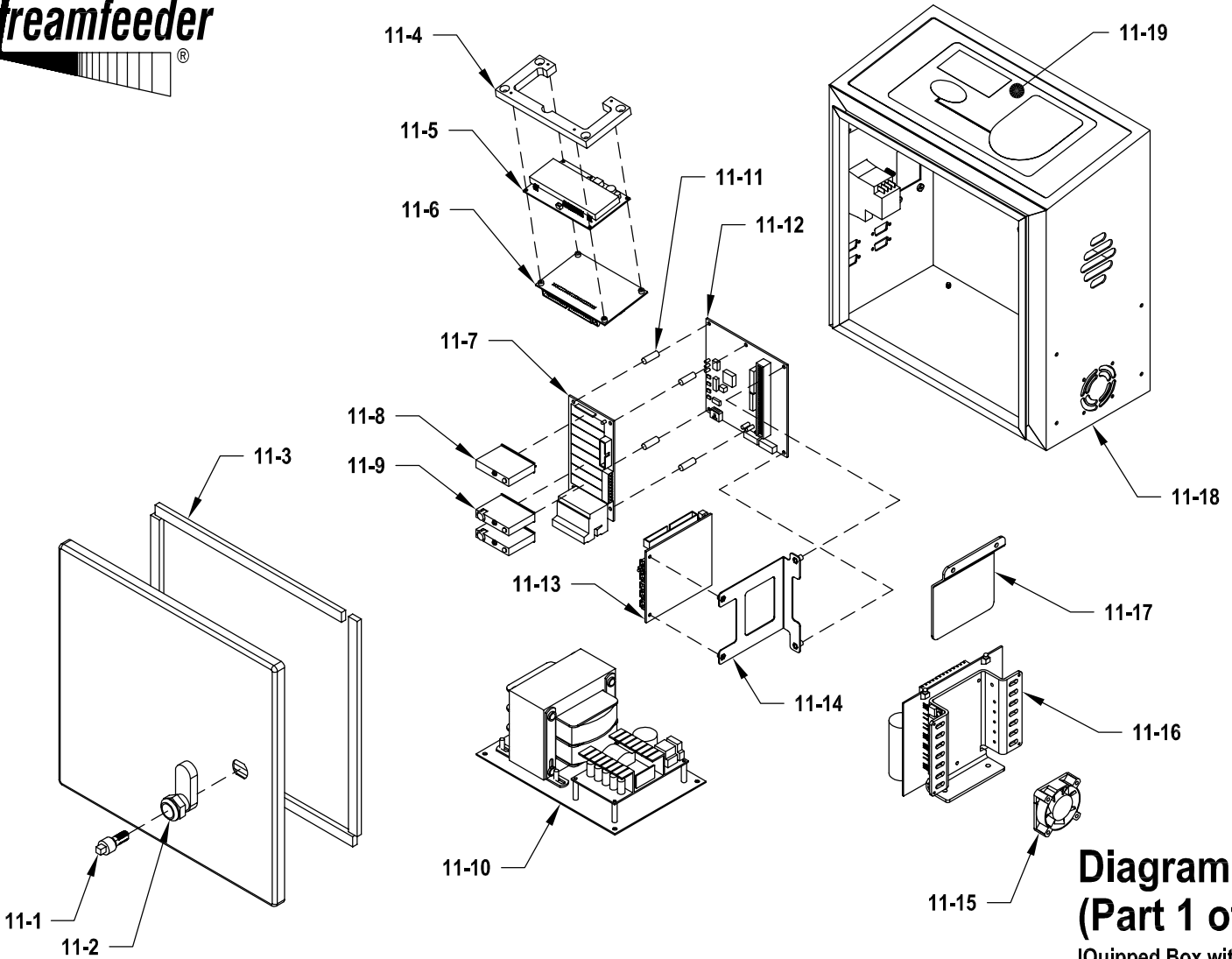
ST550 / ST850

11: IQIPPED BOX WITH I/O

BASE ASSEMBLY #68311001 I/O ASSEMBLY #68311014

<u>DIAGRAM NUMBER</u>	<u>QTY</u>	<u>DESCRIPTION</u>	<u>PART NUMBER</u>
11-1	1	Insert 7mm Square	44683022
11-2	1	Cam Latch Lock	44683021
11-3	44"	Gasket	44683028
11-4	1	Bracket Display Mounting	44683002
11-5	1	Display VFD w/Connector Header Pin	53511605
11-6	1	Board Keypad Decoder	53500605
*11-7	1	Board Relay I/O	44545026
*11-8	1	Relay Module DC Input 2.5-16VDC Hi Speed	44649115
*11-9	2	Relay Module DC Output 5-60 VDC 3A	44649112
11-10	1	Power Pack Transformer/DC Supply Assy IQ	68311002
*11-11	4	Spacer Standoff .75 X .25 Round Nylon	44675045
*11-12	1	Board Motherboard w/o Options	44649055
11-13	1	Board CPU w/ 96-Pin Connector	44649014
*9-14	1	Bracket Stabilizing PCB	44649125
11-15	1	Fan Assembly ST Box	68311008
11-16	1	Board Stepper Drive BLD 72-2	53500467
11-17	1	Plate Deflector	44683003
11-18	1	Box IQipped Control (Door Included)	44683001
11-19	1	Keypad ST Series IQipped	44683005

IQipped box with I/O continued on next page....



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**Diagram 11
(Part 1 of 2)**

IQuipped Box with I/O
Assy #68311001 (no I/O)
Assy #68311014 (with I/O)

ST550 / ST850

11: IQIPPED BOX WITH I/O

BASE ASSEMBLY #68311001 I/O ASSEMBLY #68311014

<u>DIAGRAM NUMBER</u>	<u>QTY</u>	<u>DESCRIPTION</u>	<u>PART NUMBER</u>
11-20	1	Harness Flight Trigger	64911005
*11-21	1	Harness I/O Internal 14 Pin	64911014
11-22	1	Harness Receptacle Interconnect IQ Box	68311009
11-23	1	Cable Communication DB9 Female IQ Box	44683027
	2	Jackscrew 4-40 Male-Female	53500512
11-24	1	Module AC Power Entry (w/o Fuses)	44649034
*11-25	1	Graphic Overlay With I/O	44683029
NOT SHOWN			
	16	Cable Tie Wrap	435SO263
	2	U-Bolt Square Bend 3 3/8	44360051
	1	Cable Ribbon Display	44649022
	**1	Connector T&B 96 Pin	44649031
	**1	Bracket Mounting CPU Board	44649038
	1	Plate Mounting IQipped Box	44683006
	2	Retainer Mounting IQipped Box	44683007
	1	Key 7mm Square	44683023
	**1	Overlay Graphic IQipped	44683024
	2	Fuse 3A 250V Slo-Blo GMD 5 X 20mm	53500006
	2	Terminal Ring	53500046
	11	Wire MTW 18 Ga Stranded Green/Yellow St	53500057
	1	Cable Ground Wire Assembly	63011007
	1	Harness Power Supply DC Outputs	64911006
	1	Harness Drive Control	64911007
	*1	Cable Ribbon Relay I/O	44649007
	*1	Cable External Systems 14 Pin	64911012
SOLD SEPARATELY			
	1	Eprom (Batch Count Model Only)	63511001
	1	Eprom (Batch Count Model Only)	63511002

*Denotes optional feature associated with I/O assembly #68311014

**Denotes part that was removed from standard configuration to accommodate I/O option

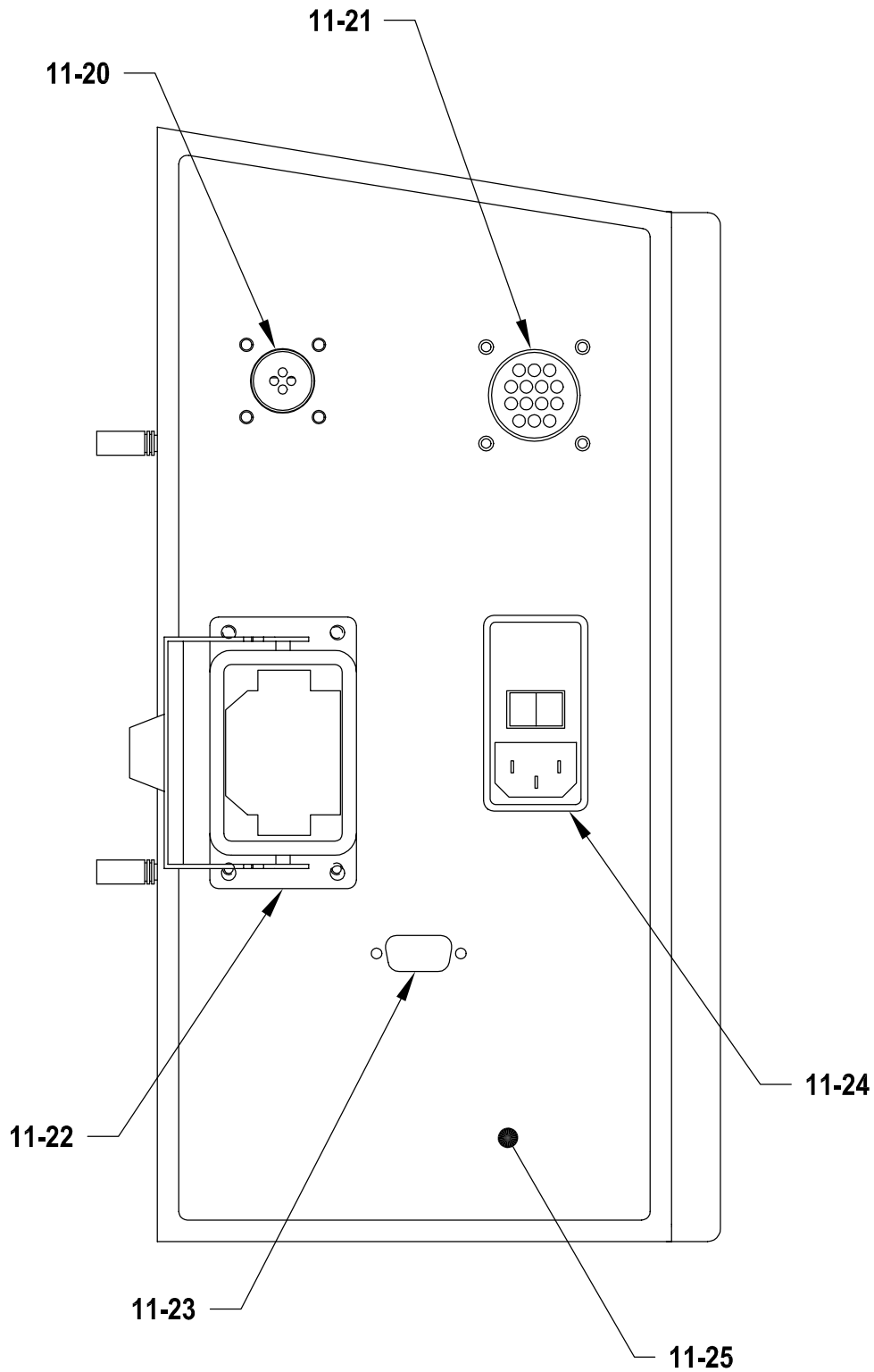


Diagram 11 (Part 2 of 2)

IQuipped Box with I/O
Assy #68311001 (no I/O)
Assy #68311014 (with I/O)

ST550 / ST850