



Linium 611

Parts Manual



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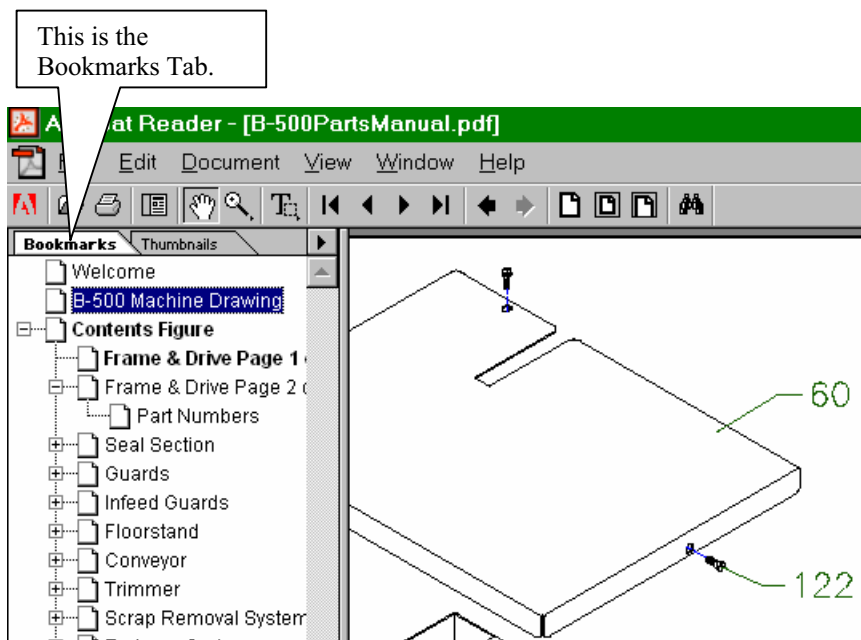
How to use Acrobat Reader with Electronic Parts Manuals

The Purpose of this guide is to help you understand the Electronic Parts Manuals.

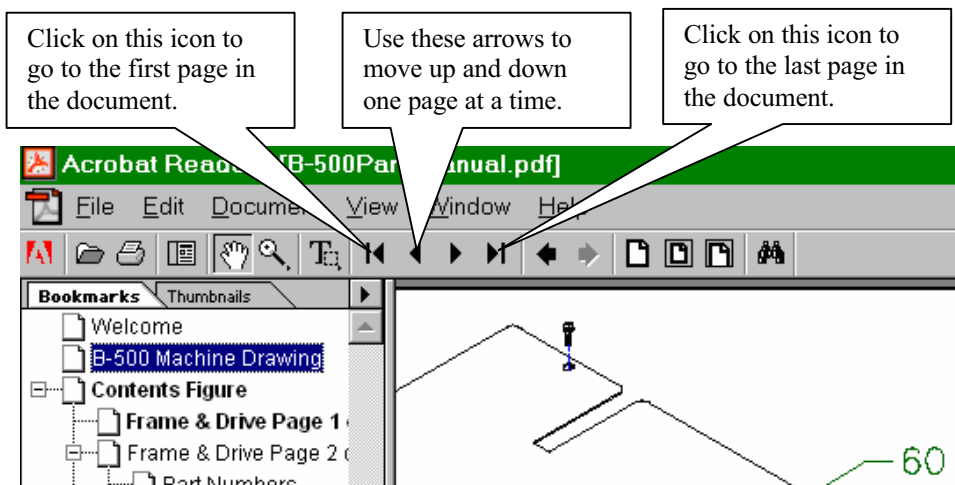
Note: This file contains reference drawings to aid in the identification of parts. When ordering replacement parts ALWAYS use part numbers found in your Customer Bill of Material.

Viewing Pages in a Document:

Viewing different areas of a PDF file can be done several different ways. One way is by simply using the page up or page down keys on your keyboard. Another is by using the Bookmarks Tab as shown below. Selecting a bookmark will open the pages that bookmark represents. A bookmark with a plus mark next to it indicates that there is another bookmark below it. Open the next level by clicking on the plus sign, and then select the desired page for viewing.



Another way to page through the document is by using the arrows on the toolbar.

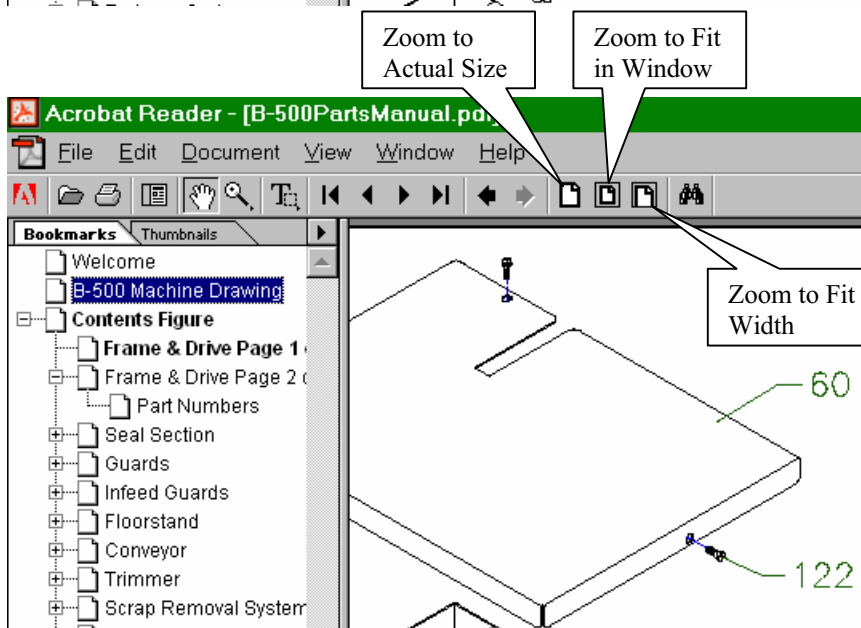
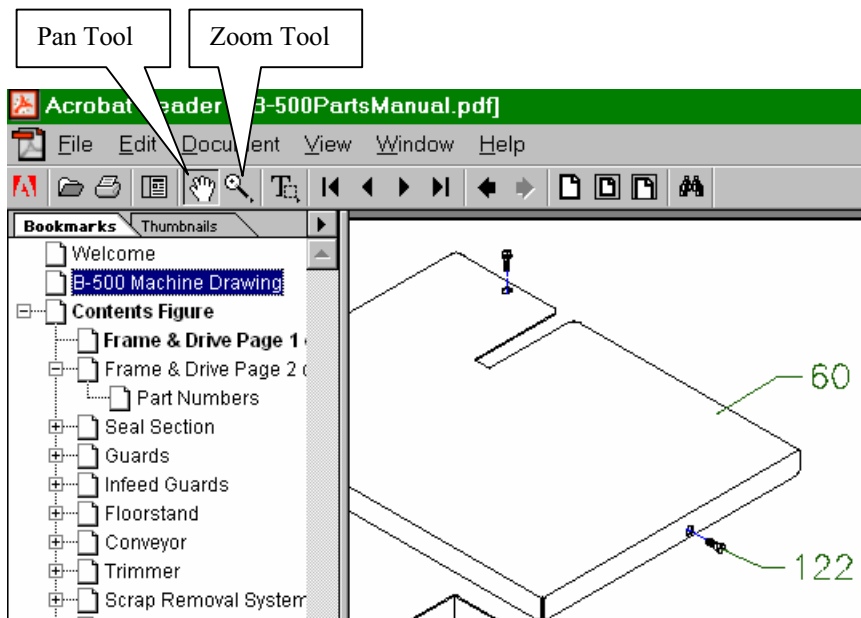


How to use Acrobat Reader with Electronic Parts Manuals

Using the Zoom and Pan Tools:

Clicking on the Zoom tool will activate that tool. This tool can be used several different ways. Notice that there is a plus sign in the magnifying glass portion of the tool. By simply clicking in the document it becomes magnified. If you hold down the Ctrl Key a (-) sign appears in the magnifying glass. Keep holding the Ctrl key when clicking in the document. The document now zooms in reverse.

Once you have the document zoomed into an area; you might want to just view something nearby. You can do this by using the Pan Tool. Select the pan tool and a hand will appear as your selection tool. Click on an area of the drawing and hold the mouse button down then drag in the direction you'd like the document to move. The same magnification remains but you have moved the document to view another area. You can continue to pan anywhere you'd like in the document pane. By combining the zoom and pan tools, you can view areas of a document very easily. Other options for viewing documents are shown below. These three Icons can be used to help view a drawing after you have used the Zoom and Pan Tools and want to see the whole page.

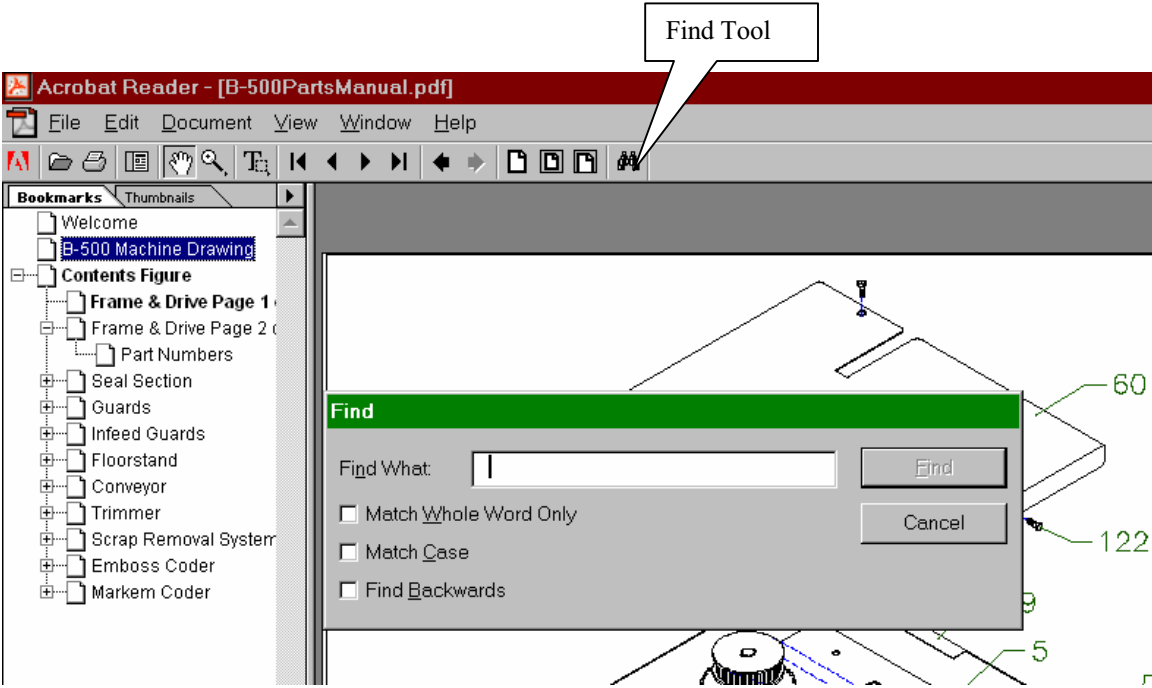


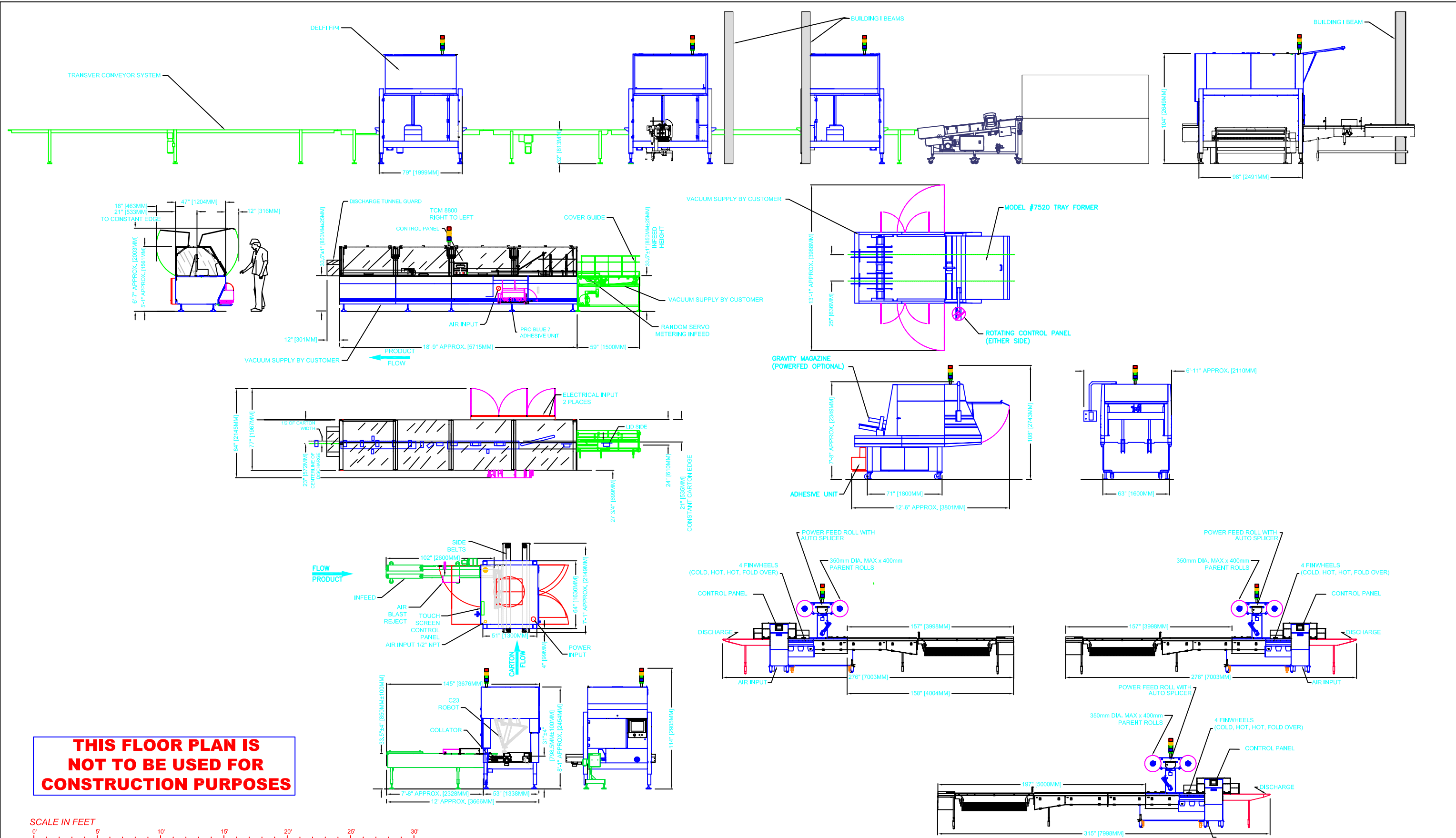
How to use Acrobat Reader with Electronic Parts Manuals

Using the Find Tools:

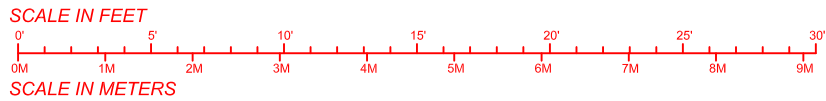
The find tool can be used to help you find a document or item based on a key word or part number. When you click on the Find tool a dialogue box will appear. Enter the text you'd like to find in the text box then select from the options below for your search criteria. If you choose not to use any of the options below, the search will find any words that match the string of text you entered. For example, if you type in *bearing* then hit enter, the find command will find the next place in the document that *bearing* comes up. The search might actually find the word *bearings*, even though you searched on the word bearing. By clicking on the Match Whole Word Only option, the search will only find that whole word in the document. If you click on the Find button again, the dialogue box will appear again with the last word you searched for in the text box and the Find button will now appear as "Find again". You can continue to select "find again" until it no longer finds that word in the document.

This tool will not find text that has been put into the document as Graphics text.





THIS FLOOR PLAN IS NOT TO BE USED FOR CONSTRUCTION PURPOSES



CUSTOMER ACCEPTANCE SIGNATURE BLOCK:			
SIGNATURE:		DATE:	
PRINTED NAME:		DATE OF REVISION	CHANGED BY

THE INFORMATION ON THIS DRAWING IS PRELIMINARY AND IS SUBJECT TO CHANGE.
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CONFIDENTIAL
FLOOR PLAN CREATED FOR:
KRAFT FOODS INC.
MACHINE ORDER
BOSCH Dobby Inc.

DRAWN BY: ANTONE ERICKSON	DATE: 14NOV07
ENG APPROVAL: D.LUTZ	FOR SCALE SEE BOTTOM LEFT CORNER OF DRAWING
SALES APPROVAL: D.LUTZ	DWG SIZE:
CC: 118 83 SHEET: 4 OF 5	MC: 307
331.057486	REVISION LEVEL:
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1	XXX	XX	XX
REVISION LEVEL	DESCRIPTION OF REVISION	DATE OF REVISION	CHANGED BY

Material	C307	05	0010	Alt.	Usage 3
	Linium 6X1 Rotary Horizontal Wrapper			Valid	09/26/2007
Reqd qty	1.000	EA	Base quant	1.000	EA
Sales ord.	129850		Item	000150	

Lv	Item	Component no.	Description	Quant	Un
1	0001		KRAFT FOODS INC. NEW ULM PLT.		
1	0002		07-27756		
1	0003		40-105-03 Linium 611 Wrapper		
1	0004		Electrical Specs -460-60-3-8403W-15FLA-10LMA-22KA INTERRUPT CAPACITY. 2KA SCCR		
1	0005		Mechanical Engineer Bryan Grass		
1	0006		Electrical Engineer Dennis Neck/Rod Cain		
1	0010		Additional Requirements:		
1	0011		SICK Bar Code Scanner		
1	0012		Four Light Stack w/Horn		
1	0025	431.063136	WIRING DIAGRAM LINIUM 611	1.000	EA
1	0026	731.063131	SOFTWARE LINIUM 611 CLX	1.000	EA
1	0027	731.063132	SOFTWARE LINIUM 611 PANELVIEW PLUS	1.000	EA
1	0030	C PRP WRAPPER	PRODUCT RELATED PARTS - WRAPPER	1.000	EA
1	0090	500000	MANUAL	2.000	EA
1	0105	131.026392	05 ASSY-MAIN FRAME LR	1.000	EA
1	0115	131.021899	01 KIT-FRAME W/O EXTRA ENCLOSURE LR	1.000	EA
1	0120	131.016492	02 KIT-FRAME PNEUMATICS	1.000	EA
1	0130	131.029819	01 KIT-SHIPING	1.000	EA
1	0135	131.043661	01 KIT-LEVELING PEGS-890 TO 960MM	1.000	EA
1	0400	131.022984	ASSY-120 CUTT HD LR PRE ASSEMBLY	1.000	EA
1	0420	131.026377	05 ASSY-GUARDS-CUTT HEAD-PV1000 800T-LR	1.000	EA
1	0425	131.043609	ASSY-GUARD-LOWER-DISCHARGE W/ TRANS-	1.000	EA
1	0426	131.035877	KIT TRANSFORMER MOUNTING	1.000	EA
1	0500	131.022988	02 ASSY-4 FINWHEEL LR PRE-ASSEMBLY	1.000	EA
1	0510	131.001475	02 KIT-FINWHEEL-COVERS-STANDARD-CHKRD	1.000	EA
1	0515	131.023116	01 KIT-FINWHEEL GUARDS LR	1.000	EA
1	0535	131.023109	KIT FINWHL DECKS 120MM LR	1.000	EA
1	0600	131.047174	01 ASSY-BACKSTAND 600MM SST LR	1.000	EA
1	0610	131.029612	01 ASSY-PFR EYE SPLICER 600MM LR	1.000	EA
1	0615	131.001827	02 KIT-HIGH SPEED POWER FEED ROLL DRIVE	1.000	EA
1	0620	531.003737	03 PLATE-REGISTRATION &/OR MFG SPLICE E	1.000	EA
1	0625	131.001747	03 KIT-BKSTD COLD SEAL SPLCR DECKS 600M	1.000	EA
1	0630	131.063153	KIT BACKSTAND 9840 MNT W/SICK SCANNE	1.000	EA
1	0635		***SPECIAL LIGHT TOWER (CHECK B.O.M.)		
1	0650	131.016764	KIT-NO FILM HOIST USDA	1.000	EA
1	0700	131.025540	03 ASSY-DISCHARGE CNVR W/ REJECT 1200mm	1.000	EA
1	0700		***ADDS/DELETES EXSIST		
1	0710	131.021186	01 KIT-DISCHARGE GUARD TOP	1.000	EA
1	0715	131.021190	KIT-PLATE DISCHARGE END	2.000	EA
1	0720	131.023481	01 KIT-DISCH GUARDS 1200 LR-REJECT TOWA	1.000	EA
1	0725	131.025560	KIT-DISCHARGE MOUNTING	1.000	EA
1	0800	131.058928	01 KIT MAIN PANEL PRE-ASSY LR 07	1.000	EA
1	0800		ADDS AND DELETES IN 131.058928		
1	0805	131.062538	KIT 440-480V SPECIAL	1.000	EA
1	0810	131.062537	KIT OPER INTERFACE PV1000+ SPECIAL	1.000	EA
1	0815	131.016089	05 KIT-POWER FEED ROLL ELECT (CTRLLGX)	1.000	EA
1	0835	131.002403	01 KIT-REGISTRATION EYE ELECT	1.000	EA

1	0836	131.050707		KIT MANUFACTURE SPLICE EYE-GREEN	1.000	EA
1	0840	131.063184		KIT REJECT 12 CONDUCTOR CLX	1.000	EA
1	0850	131.002415	03	KIT-SPLICER EYES	1.000	EA
1	0860	604234		NAMEPLATES ENGRAVED	1.000	EA
1	0861	604235	01	LABEL, FUSE LIST	1.000	EA
1	0862	470604		LIGHT BLUE STACKABLE 24V	1.000	EA
1	0863	470606		ALARM SOUND STACKABLE 24V	1.000	EA
1	0864	479968		RELAY SPDT MECH 6 AMPS 24VDC COIL	2.000	EA
1	0865	631.031810		ENCL MOUNT CONNECTOR, ETHERNET,120V	1.000	EA
1	0866	031.036191		RJ-45 3' CABLE BLUE	1.000	EA
1	0867	423159		ELECTRICAL INTERLOCK	1.000	EA
1	0868	131.020020	01	KIT-ROBOT/INFEED ELECTRICAL	1.000	EA
1	0869	631.035631		VFD POWERFLEX 40 1HP 240V	1.000	EA
1	0870	491312		ETHERNET/IP ADAPTER	1.000	EA
1	0871	631.035633		COVER- POWERFLEX B FRAME DNET CARD	1.000	EA
1	0872	8-110-622-763		BARCODE SCANNER-SICK	1.000	EA
1	0873	8-110-622-764		SCANNER CLONING MODULE	1.000	EA
1	0874	8-110-622-765		SCANNER U MOUNTING BRACKET	1.000	EA
1	0875	8-110-622-766		SCANNER CABLE	1.000	EA
1	0876	351767	01	DISCONNECT SWITCH	1.000	EA
1	0877	031.036191		RJ-45 3' CABLE BLUE	1.000	EA
1	0878	603749		PUSHBUTTON ILLUM N4X BLUE 24V EXT HE	1.000	EA
1	0879	417750		NAMEPLATE RESET NEMA 4	1.000	EA
1	0880	475476	01	CONTROL LOGIX ETHERNET/IP MODULE	1.000	EA

Material	C307	05 0010	Alt.	Usage 3
	Linium 6X1 Rotary Horizontal Wrapper			Valid
				09/26/2007
Reqd qty	1.000 EA	Base quant	1.000 EA	
Sales ord.	129850	Item	000150	

Lv	Item	Component no.	Description	Quant	Un
1	0000	C_PRP_WRAPPER	PRODUCT RELATED PARTS - WRAPPER		
2	0005	331.063584	FILM LAYOUT KRAFT NEW ULM	1.000	EA
2	0200	131.017543	ASSY-FORMER MOUNT	1.000	EA
2	0210	131.045366	ASSY FORMER 40W X 24H X 18DEG	1.000	EA
2	0220	131.062683	ASSY CHAIN GUIDES RECV LR	1.000	EA
2	0225	131.028146	KIT-FILM SPLITTER SHORT DROP OFF	1.000	EA
2	0440	131.002280	02 KIT-CRIMPER MTG ADJUSTING SCREW	2.000	EA
2	0441	386882	04 CRIMPER-KNIFE-120 DIA X 180 LG HORZ	2.000	EA
2	0442	386883	04 CRIMPER-ANVIL-120 DIA X 180 LG HORZ	2.000	EA
2	0443	367077	04 KNIFE 7" ZIG-ZAG BIAS ADJUSTABLE	2.000	EA
2	0444	082-17811	21 ANVIL .182WD.968HX7.12L ADJUSTABLE	2.000	EA
2	0447	235238	07 ELEMENT-HEAT 230V 300W .375 7.00	8.000	EA
2	0450	408610	SPACER-PRODUCT-2UP	2.000	EA
2	0455	131.025122	KIT-CRIMPER WIRE GUARDS 1-UP/2-UP	2.000	EA
2	0670	531.001816	02 DECAL-FILM THREADING	1.000	EA

Former Assembly	Product Description				Wrapping Material							
Number	Description	Height	Width	Length	Film Type	"A"	"B"	"C"	"D"	"E"	"F"	"G"
131.045366	SOUTH BEACH DIET CEREAL BAR	19mm	36mm	95mm	COLD SEAL	152mm	140mm	10mm	"	"	"	"

NOTE 1: Maximum film roll diameter to be 350.00mm(13.78").
Film roll core diameter to be 70.0mm(2.76") - 76.2mm(3.0").

NOTE 2: Eye spot should be opaque when clear wrapping material is used with no printing in area between spots. If opaque wrapping material is used, eye spot color should contrast with background color between spots. White should be avoided unless black is used for contrasting color. Eye spot can be printed on either side of film as indicated.

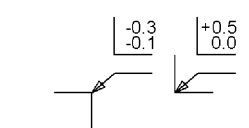
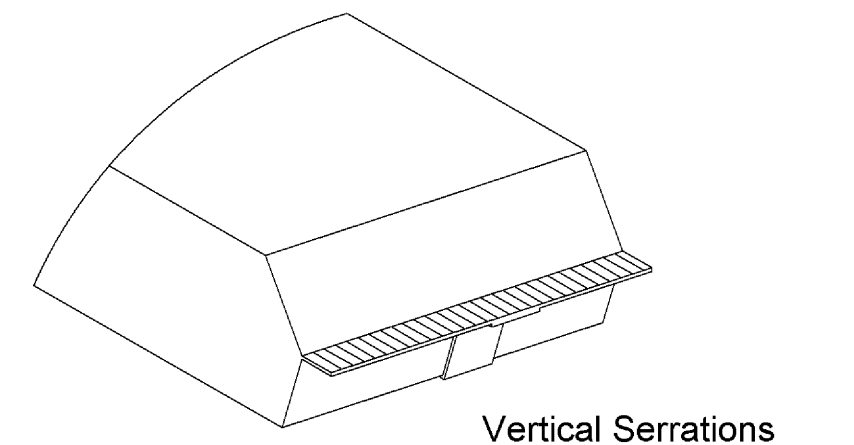
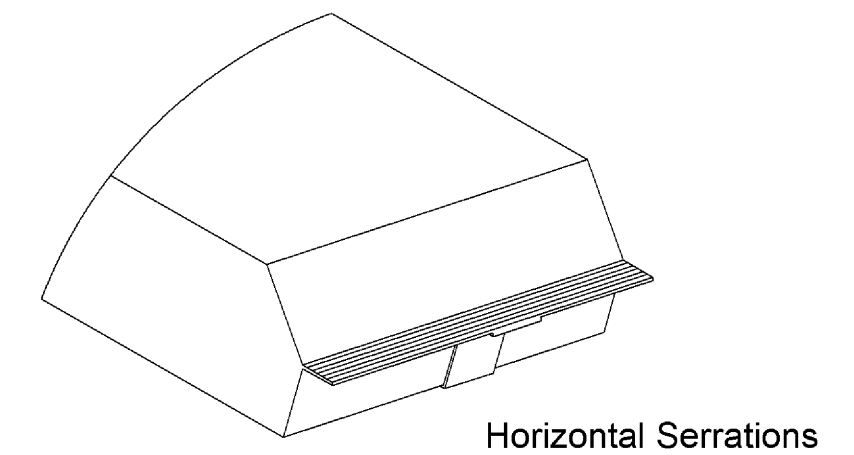
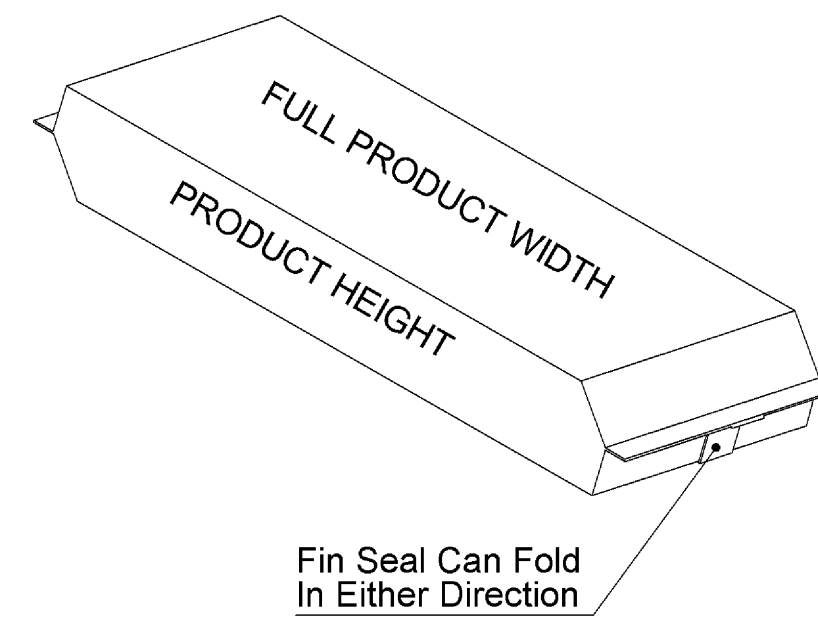
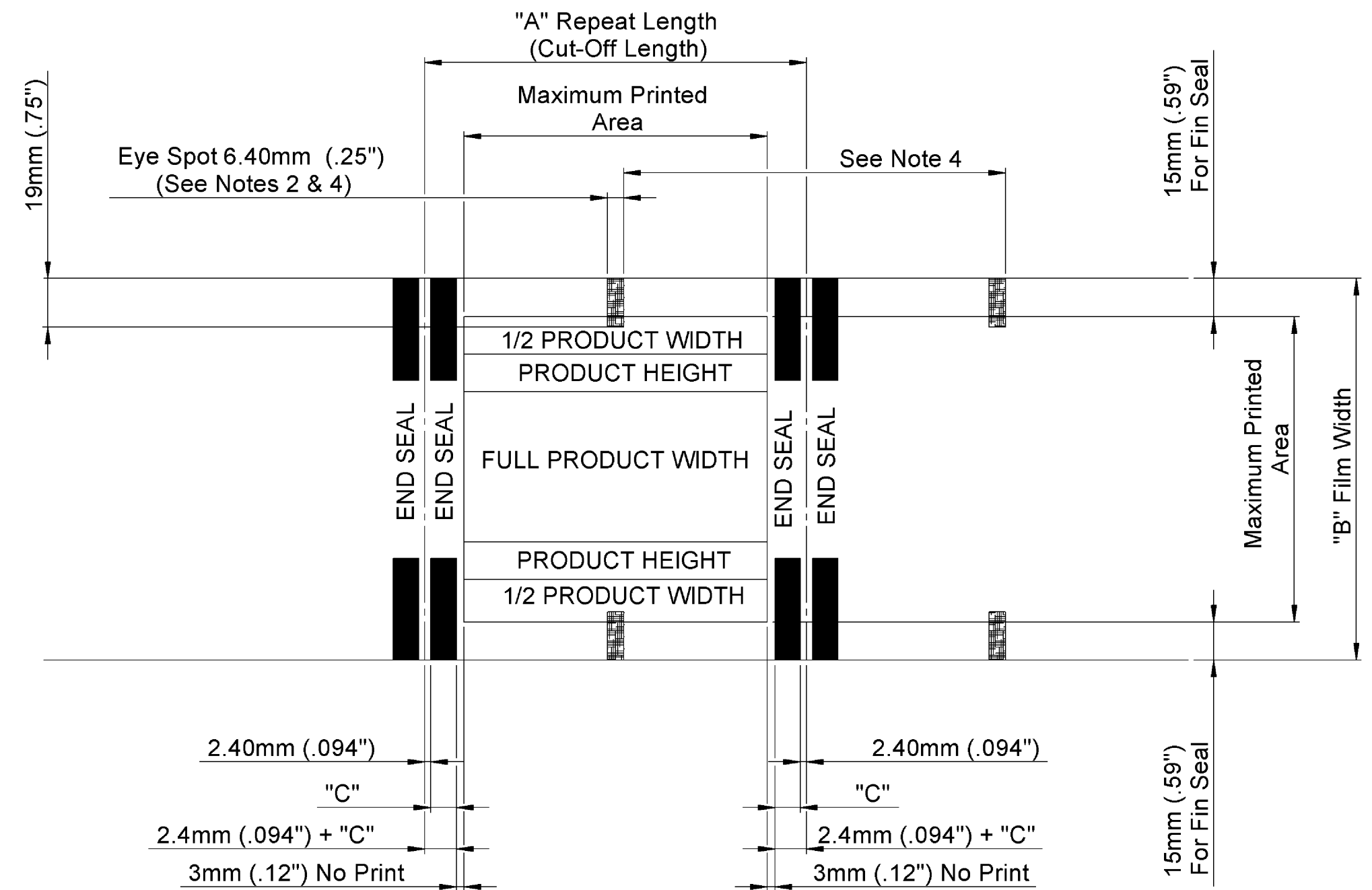
NOTE 3: If foil film is used: CONSULT Doboy Inc. for eye spot color.

NOTE 4: The recommended repeat distance between two eye spots must not exceed +/-0.78mm(0.03").

NOTE 5: Care should be taken when configuring print area on the bottom of package. If the print can not be covered by the finseal area, reduce print area by 15.0mm(0.59") on the side which the finseal folds.

The wrapping material type, width, and repeat length contained in this drawing are based on sample product sent to Doboy Inc. and/or product information provided by the customer and are preliminary estimates only.

Doboy Inc. does not assume liability for the cost of wrapping materials or related printing expenses incurred by the customer. It is recommended sample wrapping material be tested on the machine in the customers plant under varying conditions before ordering in quantity.



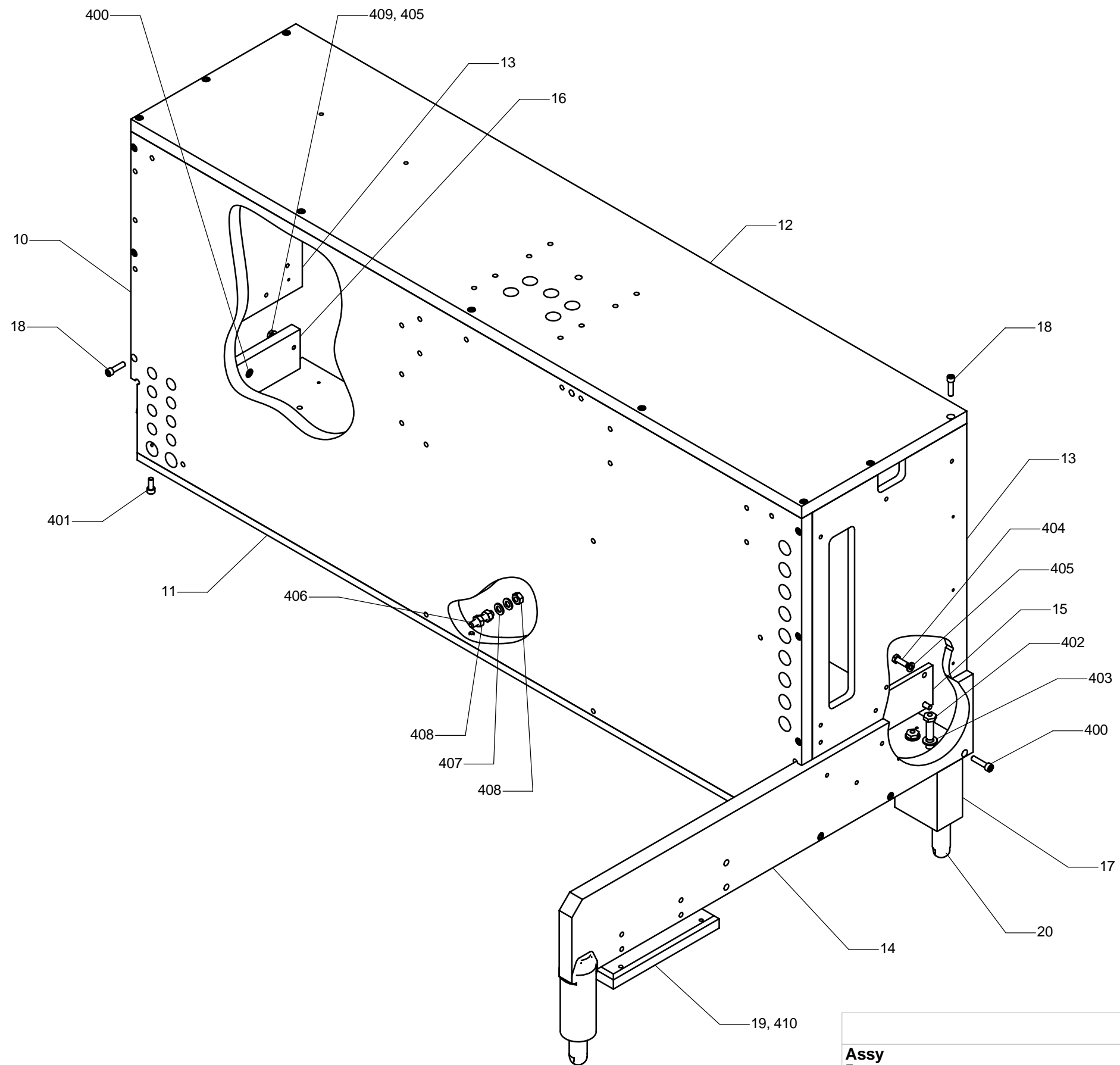
N9

Pos.	Qty.	Shape	Norm	Material	Proposed Measurement	Remarks
1	1	-	-	-	-	
Sales Order 129850					Drawn by: Bryan Grass	Date: 10 Nov 2007
					Approved by: Bryan Grass	Scale: 1:2
Film Layout Kraft New Ulm					Checked by: Barb Hemauer	Size: A2
					Sheet: 1/1	M-Type: -
					331.063584	Rev.: 0
BOSCH		Doboy Inc.		© Copyright Doboy Inc.	Based on SIG Pack International Design Standards	

Qty.	Index	Description	Date	ECN No.	Changed by

Material	C307	05	0010	Alt.	Usage 3
	Linium 6X1 Rotary Horizontal Wrapper				Valid
					09/26/2007
Reqd qty		1.000	EA	Base quant	1.000 EA
Sales ord.	129850			Item	000150

Lv	Item	Component no.	Description	Quant	Un
1	0000	131.026392	ASSY-MAIN FRAME LR		
2	0001	231.013620			
2	0010	531.026394	PLATE FRAME FRONT LR	1.000	EA
2	0011	531.021161	PLATE FRAME BOTTOM LR	1.000	EA
2	0012	531.026393	02 PLATE-FRAME TOP LR	1.000	EA
2	0013	531.015394	PLATE FRAME IN FEED	2.000	EA
2	0014	531.015395	05 BAR FRAME LEG	1.000	EA
2	0015	531.015396	PLATE LEG ATTACHMENT	1.000	EA
2	0016	531.015397	02 PLATE-CUTTING HEAD ATTACHMENT	1.000	EA
2	0017	531.018851	01 BLOCK FRAME FOOT	1.000	EA
2	0018	531.002598	03 SCREW-SOC CAP M8 X 30 STL MODIFIED	18.000	EA
2	0019	531.015405	02 BLOCK SPACER CASTER	1.000	EA
2	0400	397031	SCREW-SOC CAP M8 X 35 SST	5.000	EA
2	0401	379441	SCREW-SOC CAP M8 X 20 SST	8.000	EA
2	0402	397013	SCREW-HEX-HD M12 X 40 SST	2.000	EA
2	0403	397069	WASHER-FLAT 13 X 24 X 2.5 SST	2.000	EA
2	0404	310110	SCREW-HEX HD M8 X 25 SST	6.000	EA
2	0405	309393	01 WASHER-FLAT 8.4 X 16 X 1.6 SST	8.000	EA
2	0406	413860	SCREW-SET M10 X 50 SST	6.000	EA
2	0407	397080	WASHER-FLAT 10.5 X 20 X 2 SST	12.000	EA
2	0408	310177	NUT-HEX FULL M10 SST	18.000	EA
2	0409	310145	SCREW-HEX HD M8 X 50 SST	2.000	EA
2	0410	412893	SCREW-SOC CAP M10 X 30 SST	2.000	EA

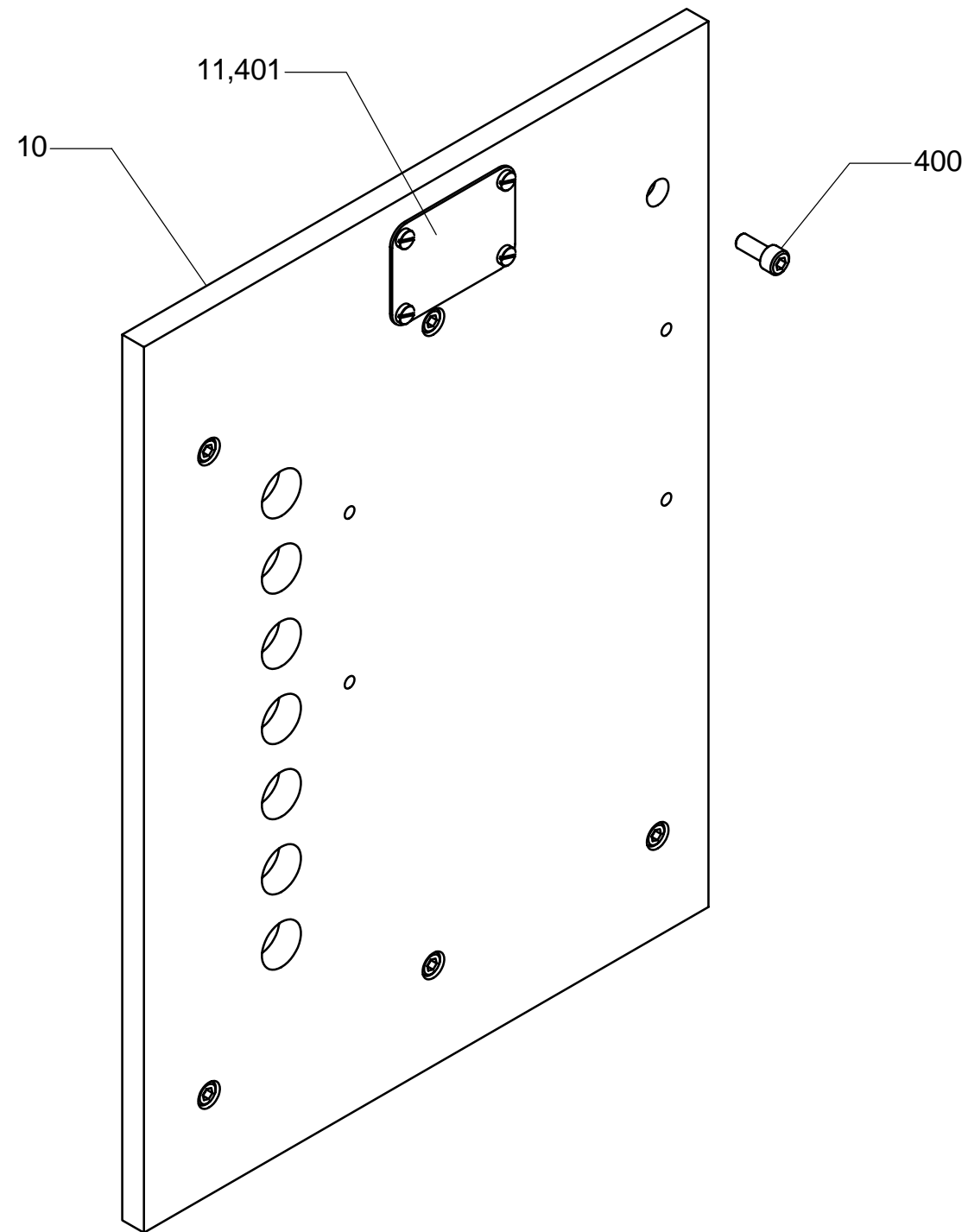


Assy Frame	Drawn by: Roger Hefty	Date: 24 Apr 2001
	Approved by: Roger Hefty	Scale: 1:5
	Checked by: Barb Hemauer	Size: A2
	Sheet: 1/1	M-Type: 307
231.013620		Rev.: 1
BOSCH	Doboy Inc.	© Copyright Doboy Inc. Based on SIG Pack International Design Standards

Qty.	Index	Description	Date	ECN No.	Changed by
0	1	Update Drawing per B/M ECN 169172	27 Dec 02	169174	DWL

Material	C307	05 0010	Alt.	Usage 3
	Linium 6X1 Rotary Horizontal Wrapper			Valid 09/26/2007
Reqd qty	1.000 EA	Base quant	1.000 EA	
Sales ord.	129850	Item	000150	

Lv	Item	Component no.	Description	Quant	Un
1	0000	131.021899	KIT-FRAME W/O EXTRA ENCLOSURE LR		
2	0001	231.013619	DWG-KIT FRAME W/O TRANS.	1.000	EA
2	0010	531.021163	03 PLATE FRAME INFEED LR	1.000	EA
2	0011	531.025924	COVER AIR LINE CHANNEL	1.000	EA
2	0400	952696	SCREW-SOC-CAP M8 X 20 STL	6.000	EA
2	0401	310095	SCREW-PAN SLOT M5 X 10 SST	4.000	EA

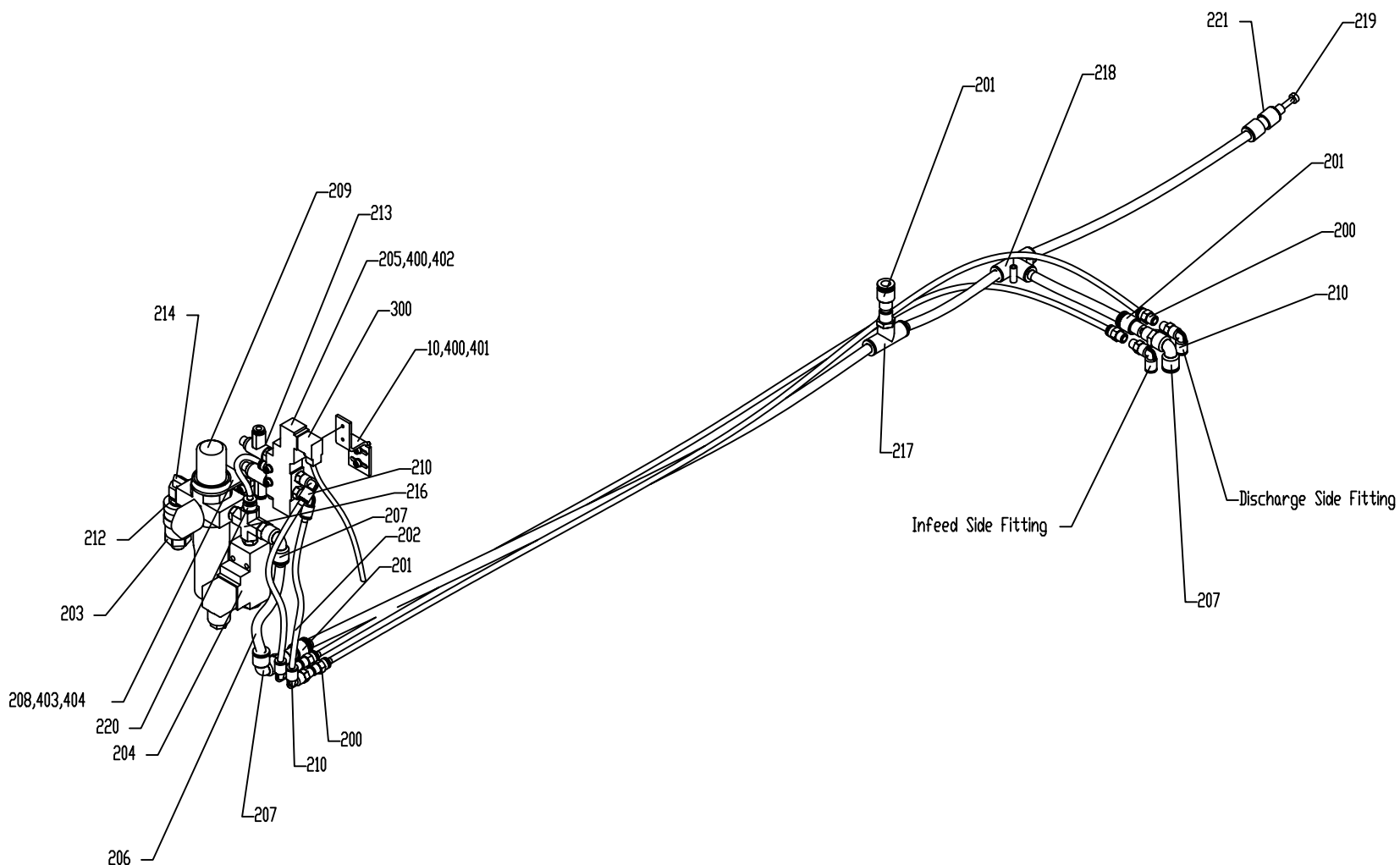


Opposite Hand #131.021899		Drawn by: Roger Hefty	Date: 06 Jun 2001
Kit Frame W/O Extra Enclosure		Approved by: Roger Hefty	Scale: 1:3
		Checked by: Barb Hemauer	Size: A3
		Sheet: 1/1	M-Type: 307
		231.013619	Rev.: 1
BOSCH	Doboy Inc.	© Copyright Doboy Inc.	Based on SIG Pack International Design Standards

0	1	Add item 11 and 401	15 Dec 04	179009	BKM
Qty.	Index	Description	Date	ECN No.	Changed by

Material	C307	05 0010	Alt.	Usage 3
	Linium 6X1 Rotary Horizontal Wrapper			Valid
				09/26/2007
Reqd qty	1.000 EA	Base quant	1.000 EA	
Sales ord.	129850	Item	000150	

Lv	Item	Component no.	Description	Quant	Un
1	0000	131.016492	KIT-FRAME PNEUMATICS		
2	0001	231.016492	ASSY KIT FRAME PNEUMATICS		
2	0003	431.016492	-SCHEMATIC-600 LINIUM PNEUM		
2	0010	531.002526	04 BRKT VALVE	1.000	EA
2	0200	370695	01 CONNECTOR-STRAIGHT MALE R1/8 TO 6mm	5.000	EA
2	0201	031.000525	CONNECTOR-STRAIGHT MALE R1/4 TO 10mm	3.000	EA
2	0202	370719	PA TUBE (NYLON) PNEUMATIC 6mm OD	3.000	M
2	0203	031.000520	COUPLING-QUICK SOCKET	1.000	EA
2	0204	407108	SWITCH-PRESSURE 180 PSI 250V	1.000	EA
2	0205	031.000528	VALVE PNEUMATIC	1.000	EA
2	0206	370720	PA TUBE (NYLON) PNEUMATIC 10mm OD	1.500	M
2	0207	031.000521	CONNECTOR-ELBOW MALE R1/4 TO 10mm TU	3.000	EA
2	0208	031.000323	BRACKET-REGULATOR MTG	1.000	EA
2	0209	031.000519	REGULATOR W/FILTER G1/4	1.000	EA
2	0210	432287	CONNECTOR-ELBOW MALE R1/8 TO 6mm TUB	6.000	EA
2	0212	031.001523	COUPLING-PLUG KS-1/4-S	1.000	EA
2	0213	432407	01 VALVE-FLOW CONTROL G1/8	2.000	EA
2	0214	379775	ELBOW-90° 1/4 BRASS	1.000	EA
2	0215	450487	PIPE-NIPPLE 1/4 BSPT	2.000	EA
2	0216	031.002798	PIPE CROSS G1/4	1.000	EA
2	0217	031.006663	CONNECTOR-TEE MALE R1/4 TO 10mm TUBE	1.000	EA
2	0218	031.002799	CONNECTOR-TEE 10mm TUBE	1.000	EA
2	0219	408336	PLUG 10MM PUSH IN	1.000	EA
2	0220	031.000526	CONNECTOR-STRAIGHT MALE R1/4 TO 6mm	1.000	EA
2	0221	370701	STRAIGHT-UNION 10MM	1.000	EA
2	0300	031.000529	CABLE, SOCKET MOLDED W/LED	1.000	EA
2	0400	401118	WASHER-FLAT 4.3 X 9 X .8 SST	4.000	EA
2	0401	401213	SCREW-SOC CAP M4 X 16 SST	2.000	EA
2	0402	031.004462	SCREW-SOC CAP M4 X 25 SST	2.000	EA
2	0403	401228	WASHER-FLAT 5.3 X 10 X 1 SST	2.000	EA
2	0404	310093	SCREW-SOC-CAP M5 X 16 SST	2.000	EA

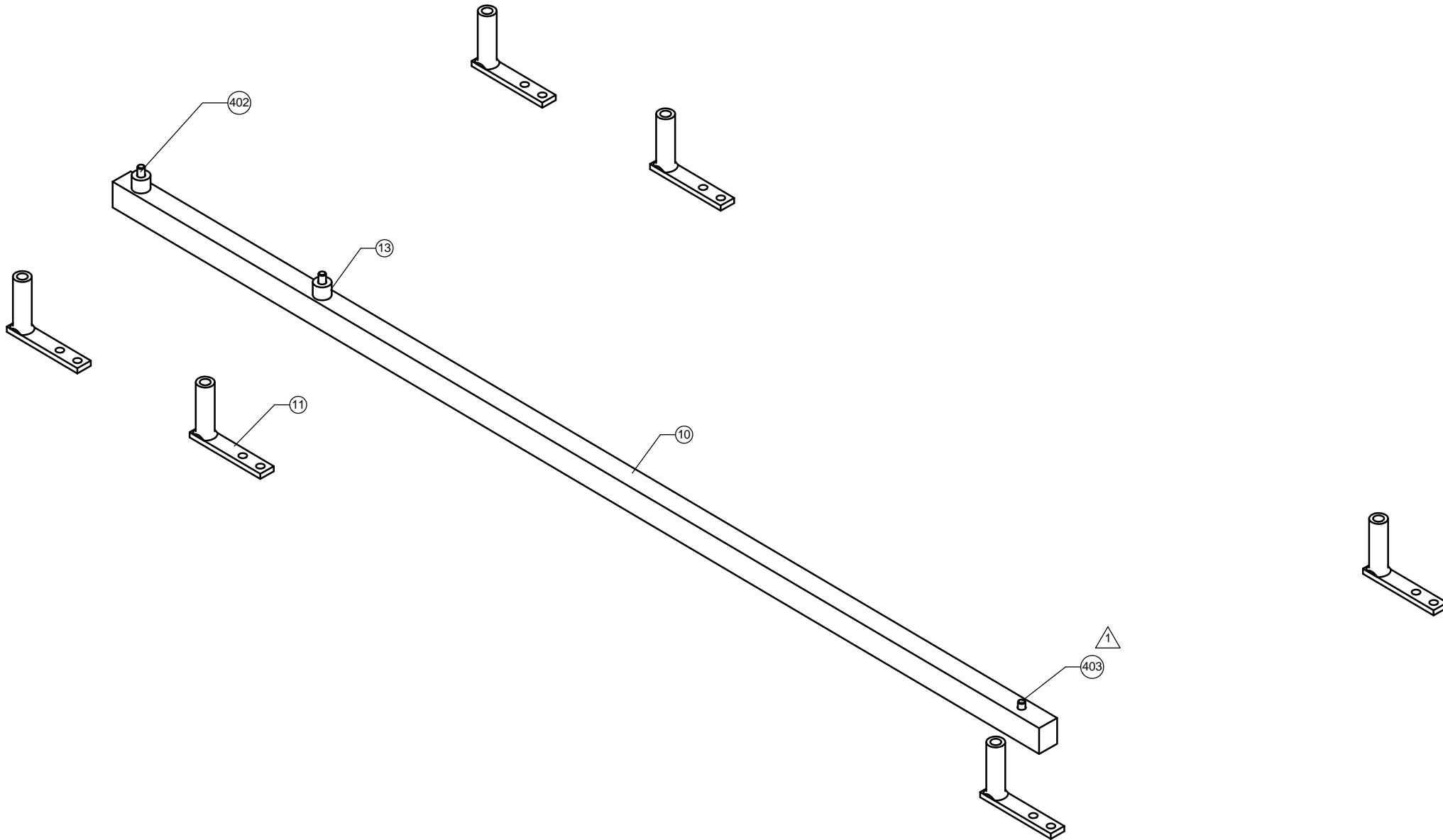


1	1	Updated Drawing to Match B/M Ecn 168440	10 Jan 03	169366	DWL
Qty.	Index	Description	Date	ECN No.	Changed by

Kit Frame Pneumatics	Drawn by	Steve Larson	Date:	23 May 2001	
	Approved by	Steve Larson	Scale:	1:4	
	Checked by	Barb Henauer	Size:	A3	
		Sheet:	1/1	M-Type:	307
	231.016492			Rev.:	1
BOSCH	Doboy Inc.	Copyright Doboy Inc.	Based on Sigpack International Design Standards		

Material	C307	05 0010	Alt.	Usage 3
	Linium 6X1 Rotary Horizontal Wrapper			Valid 09/26/2007
Reqd qty	1.000 EA	Base quant	1.000 EA	
Sales ord.	129850	Item	000150	

Lv	Item	Component no.	Description	Quant	Un
1	0000	131.029819	KIT-SHIPPING		
2	0010	531.029818	LIFTING BAR	1.000	EA
2	0011	531.011231	03 FOOT SHIPPING	6.000	EA
2	0013	531.029817	SPACER LIFTING BAR	2.000	EA
2	0402	407559	PF ALLEN CYL M12x80/30	2.000	EA
2	0403	407558	SCREW-SOC CAP M12 X 50 SST	1.000	EA



Qty.	Index	Description	Date	ECN No.	Changed by
1	1	Added Item 403	19 May 05	182475	DWL

KIT SHIPPING		Drawn by: Diana Marschall	Date: 24 Mar 2003
		Approved by: Diana Marschall	Scale: 1:4
		Checked by: Barb Hemauer	Size: A2
		Sheet: 1/1	M-Type: 307
		231.029819	
		Rev.: 1	
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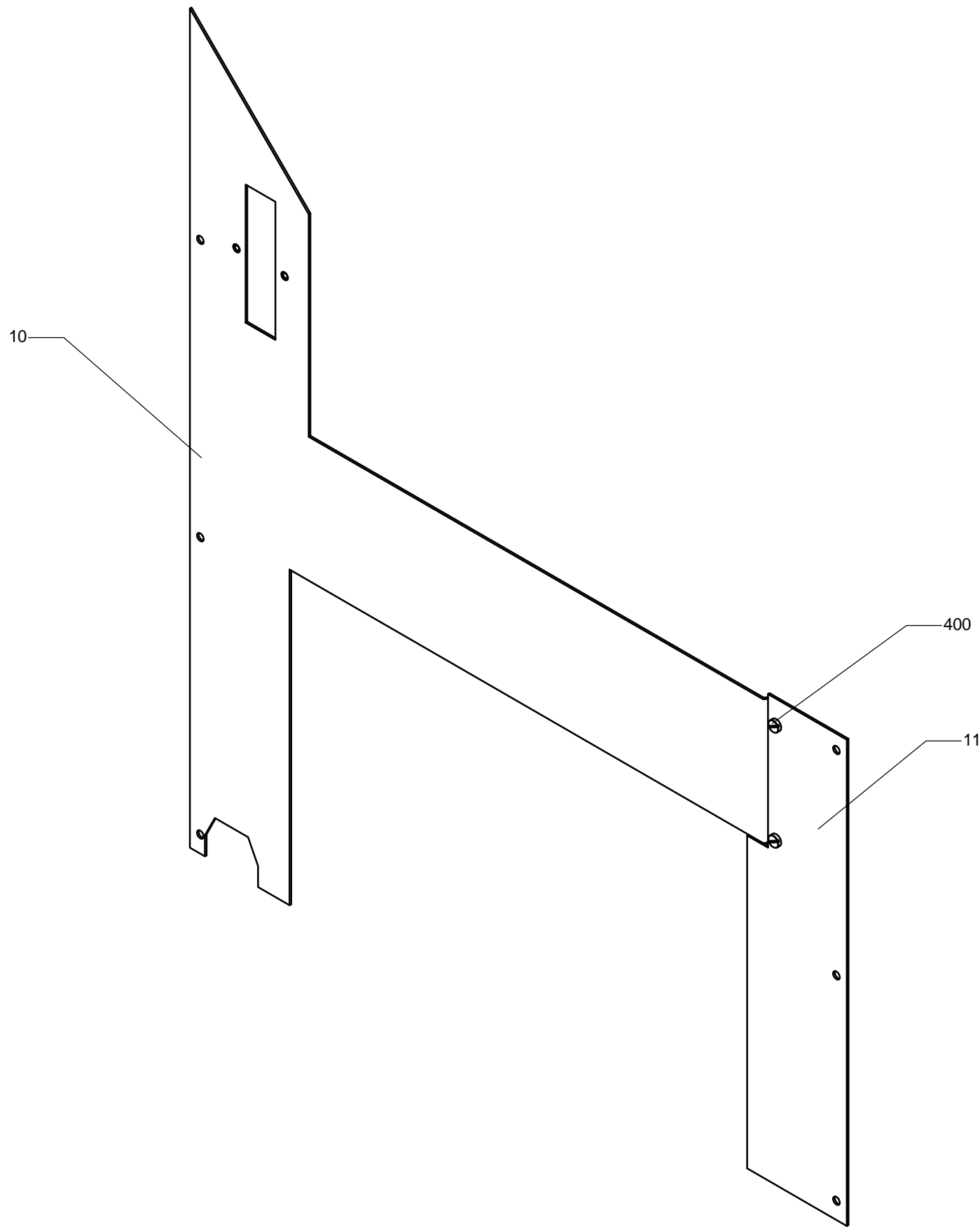
Material	C307	05 0010	Alt.	Usage 3
	Linium 6X1 Rotary Horizontal Wrapper			Valid 09/26/2007
Reqd qty	1.000 EA	Base quant	1.000 EA	
Sales ord.	129850	Item	000150	

Lv	Item	Component no.	Description	Quant	Un
1	0000	131.022984	ASSY-120 CUTT HD LR PRE ASSEMBLY		
2	0001	131.021184	04 ASSY-CUTTING HEAD FRAME 370 CL LR	1.000	EA
2	0002	131.016871	07 ASSY-CUTTING HEAD-600	1.000	EA
2	0003	531.016888	SHAFT-CUTTING HEAD UPPER-1UP-2UP	1.000	EA
2	0004	531.019640	01 SHAFT-CUTTING HEAD LOWER-1UP-2UP	1.000	EA
2	0005	131.018741	KIT-WEDGE 120 DIA	1.000	EA
2	0006	131.015990	01 KIT - CUTT.HD ELEC. 600	1.000	EA

Material	C307	05 0010	Alt.	Usage 3
	Linium 6X1 Rotary Horizontal Wrapper			Valid
				09/26/2007
Reqd qty	1.000 EA	Base quant	1.000 EA	
Sales ord.	129850	Item	000150	

Lv	Item	Component no.	Description	Quant	Un
1	0000	131.026377	ASSY-GUARDS-CUTT HEAD-PV1000 800T-LR		
2	0010	131.018850	ASSY-GUARD DOOR	1.000	EA
2	0011	531.021890	04 DOOR CUTTING HEAD LR	1.000	EA
2	0012	531.021889	01 DOOR CUTTING HEAD SMALL LR	1.000	EA
2	0013	531.028675	01 GUARD LOWER PANEL	1.000	EA
2	0014	531.026204	02 PANEL UPPER-PV1000-800T SWITCHES LR	1.000	EA
2	0015	531.026228	GUSSET UPPER CUTTING HEAD L-R	1.000	EA
2	0016	531.026226	GUARD REAR CUTTING HEAD DOOR LR	1.000	EA
2	0017	531.018162	BRACKET PANEL	4.000	EA
2	0018	531.021893	GUARD-LOWER DISCHARGE LR		
2	0019	531.018168	01 BRACKET SWITCH	1.000	EA
2	0020	531.018169	01 GUARD PLATE CUTTING HEAD	2.000	EA
2	0021	531.018176	04 GUARD FINWHEEL LOWER	1.000	EA
2	0022	531.020019	01 SCREW-PANEL	2.000	EA
2	0023	531.018845	GUARD BACK OPERATOR SIDE	1.000	EA
2	0024	531.026224	01 BRACKET SWITCH PLATE	1.000	EA
2	0025	531.026210	02 PLATE-REAR PANEL	1.000	EA
2	0026	531.018435	ARM	1.000	EA
2	0027	531.001316	01 BLOCK-SWITCH MOUNT	1.000	EA
2	0028	531.008761	BLOCK SWITCH ATTACHMENT	1.000	EA
2	0029	531.019658	DECAL-CUTTING HEAD ADJUSTMENT	1.000	EA
2	0030	531.018170	02 GUARD BACK CUTTING HEAD	1.000	EA
2	0033	531.001317	01 PLATE-NUT SWITCH	1.000	EA
2	0034	531.013659	DECAL CRIMPER GAP ADJUST	2.000	EA
2	0035	531.026639	PLATE-COVER SLOT	2.000	EA
2	0036	531.029387	PLATE-COVER SLOT	1.000	EA
2	0037	531.029386	01 COVER-WEDGE ADJUST	1.000	EA
2	0038	531.026638	COVER-WEDGE ADJUST	1.000	EA
2	0039	531.026636	COVER-BOTTOM CUTTING HEAD	1.000	EA
2	0040	531.026637	COVER-BOTTOM CUTTING HEAD	1.000	EA
2	0200	031.001526	LATCH-LIFT & TURN W/KEY	1.000	EA
2	0201	031.018181	HANDLE	1.000	EA
2	0204	031.000321	GASKET-DOOR	10.000	FT
2	0400	379473	SCREW-PAN SLOT M6 X 10 SST	29.000	EA
2	0401	379749	WASHER-FLAT 6.4 X 12 X 1.6 SST	24.000	EA
2	0402	310102	SCREW-HEX HD M6 X 12 SST	22.000	EA
2	0403	318903	SCREW-SOC CAP M6 X 35 SST	2.000	EA
2	0404	401118	WASHER-FLAT 4.3 X 9 X .8 SST	4.000	EA
2	0405	407551	SCREW-HEX HD M4 X 10 SST	4.000	EA
2	0406	401228	WASHER-FLAT 5.3 X 10 X 1 SST	2.000	EA
2	0407	422010	SCREW-HEX HD M5 X 10 SST	2.000	EA
2	0408	401168	SCREW-FLAT SOC M4 X 6 SST	2.000	EA

Material	C307	05 0010	Alt.	Usage 3	
	Linium 6X1 Rotary Horizontal Wrapper			Valid 09/26/2007	
Reqd qty	1.000 EA	Base quant	1.000 EA		
Sales ord.	129850	Item	000150		
Lv	Item	Component no.	Description	Quant	Un
1	0000	131.043609	ASSY-GUARD-LOWER-DISCHARGE W/ TRANS-LR		
2	0001	231.043609	DWG-GUARD-LOWER-DISCH W/ TRANS-LR	1.000	EA
2	0010	531.034321	GUARD LOWER DISCHARGE W/ TRANS LR	1.000	EA
2	0011	531.034325	GUARD LOWER DISCHARGE	1.000	EA
2	0400	379473	SCREW-PAN SLOT M6 X 10 SST	2.000	EA

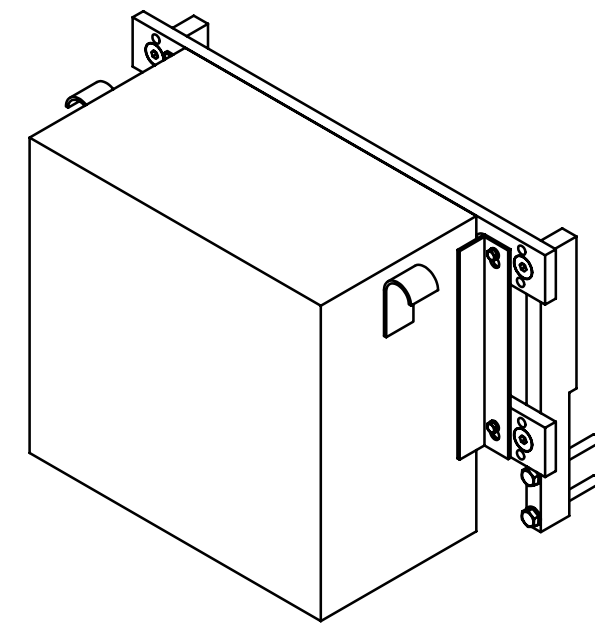
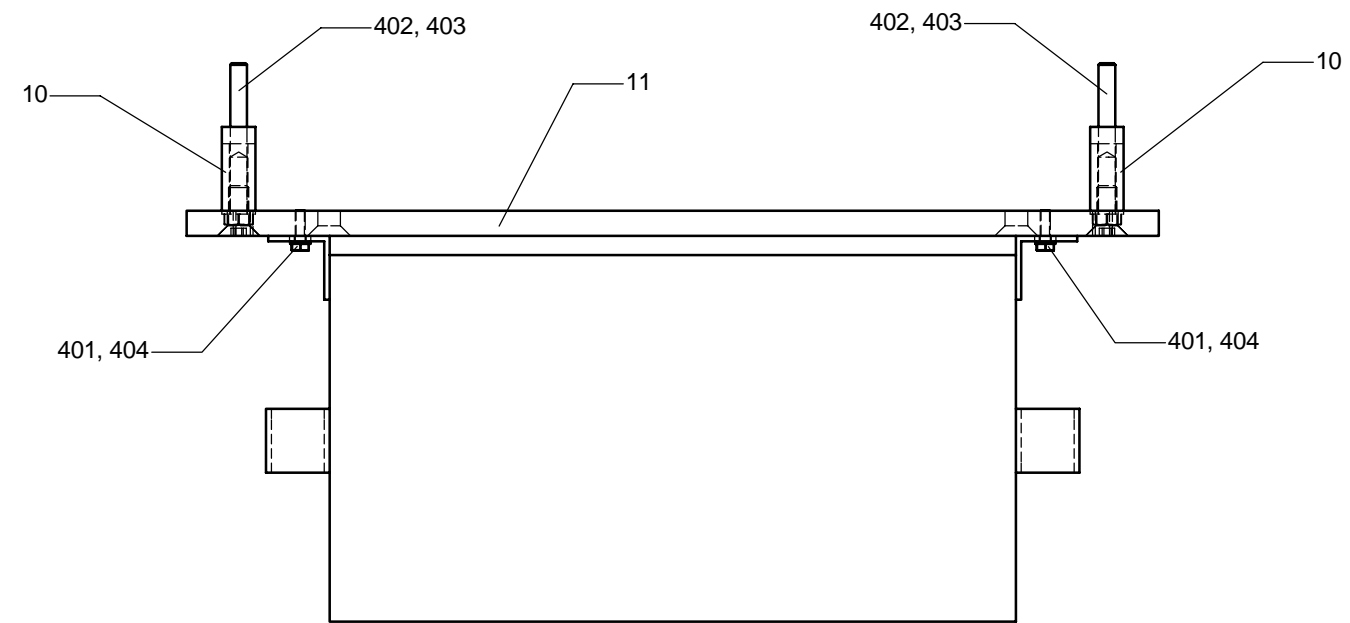
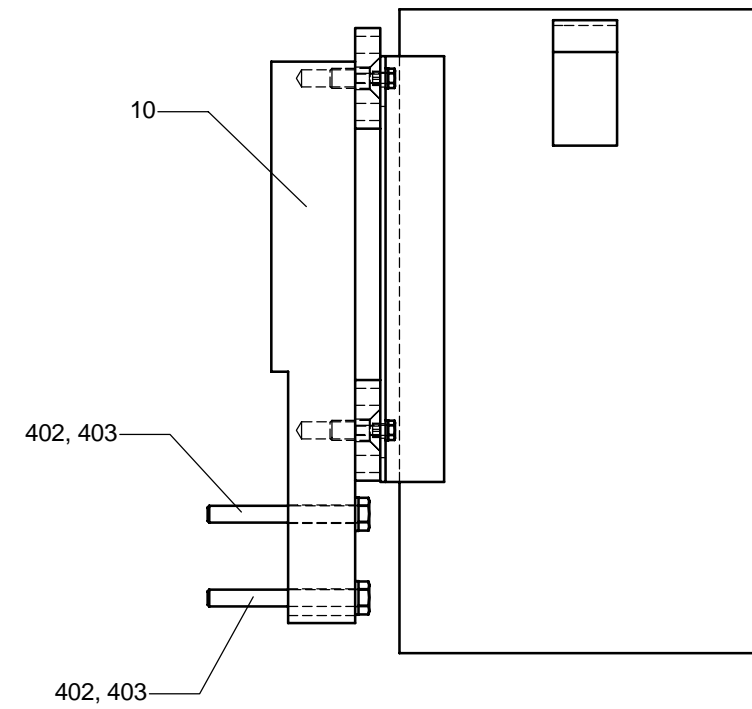
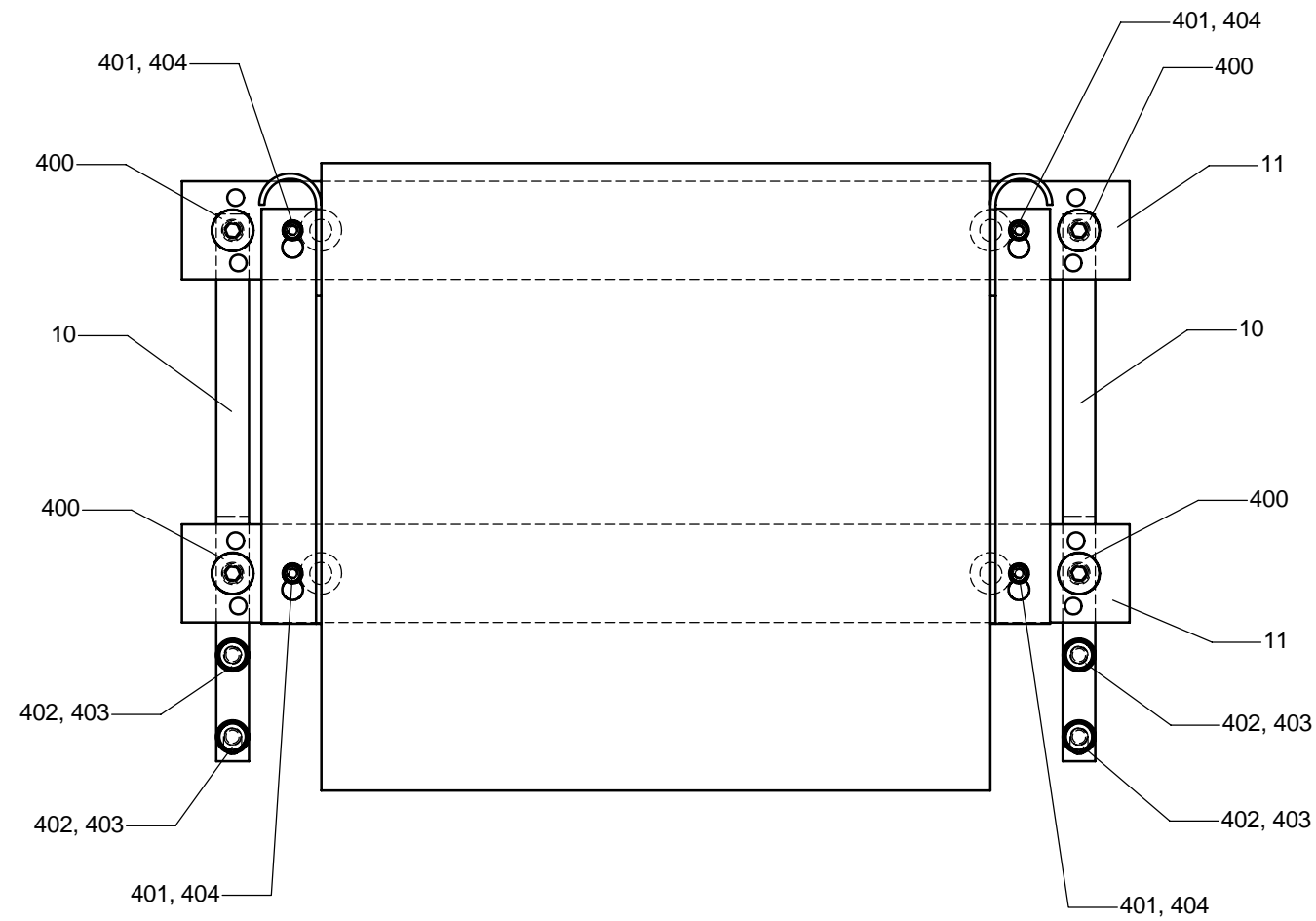


Opposite Hand #131.043608		Drawn by: Bryan Mueller	Date: 8 Nov 2004
		Approved by: Bryan Mueller	Scale: 1:3
Assy Guard-Lower-Discharge w/ Trans-LR		Checked by: Barb Hemauer	Size: A2
		Sheet: 1/1	M-Type: 307
		231.043609	Rev.: 0
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Qty.	Index	Description	Date	ECN No.	Changed by
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Material	C307	05	0010	Alt.	Usage 3
	Linium 6X1 Rotary Horizontal Wrapper				Valid 09/26/2007
Reqd qty	1.000	EA	Base quant	1.000	EA
Sales ord.	129850		Item	000150	

Lv	Item	Component no.	Description	Quant	Un
1	0000	131.035877	KIT TRANSFORMER MOUNTING		
2	0001	231.035877	DWG-TRANSFORMER MOUNTING	1.000	EA
2	0010	531.035878	PLATE TRANSFORMER ATTACHMENT	2.000	EA
2	0011	531.035879	01 PLATE TRANSFORMER ATTACHMENT	2.000	EA
2	0400	031.011893	SCREW-SOCKET-FLAT-HEAD M12 X 30 SST	4.000	EA
2	0401	310098	SCREW-HEX HD M6 X 20 SST	4.000	EA
2	0402	397080	WASHER-FLAT 10.5 X 20 X 2 SST	4.000	EA
2	0403	408257	SCREW-HEX-HD M10 X 90 STL	4.000	EA
2	0404	379749	WASHER-FLAT 6.4 X 12 X 1.6 SST	4.000	EA



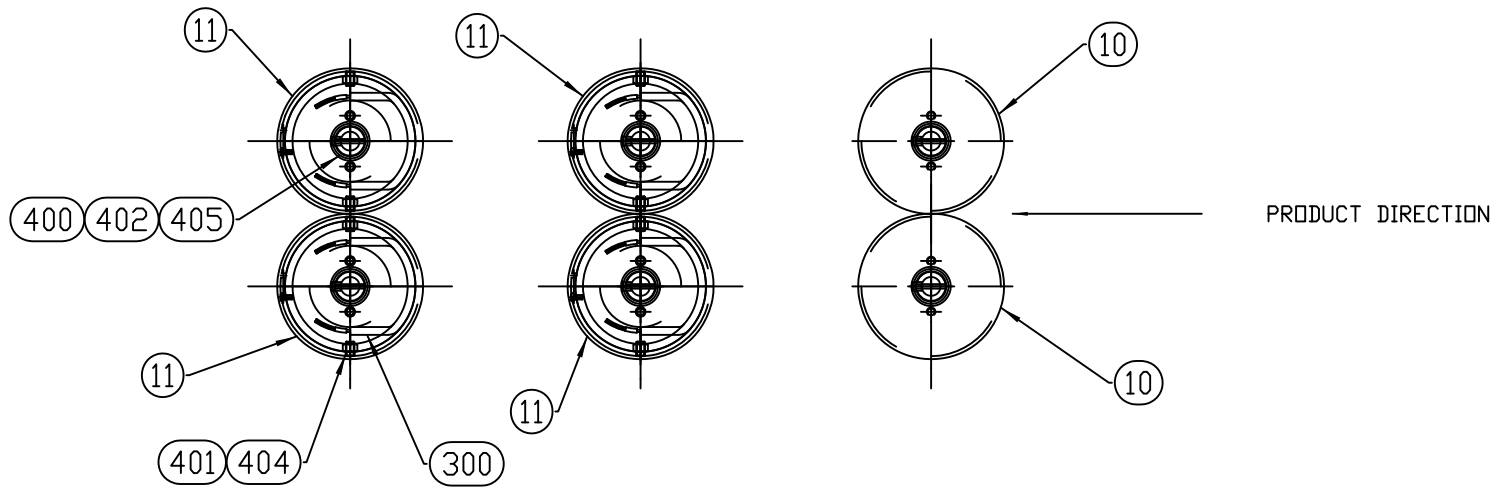
Assy Transformer Mounting		Drawn by: R. L. Hefty	Date: 3 Feb 2004
		Approved by: R. L. Hefty	Scale: 1:3
		Checked by: Barb Hemauer	Size: A2
		Sheet: 1/1	M-Type: 307
		231.035877	
		Rev.: 0	
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Qty.	Index	Description	Date	ECN No.	Changed by

Material	C307	05 0010	Alt.	Usage 3	
	Linium 6X1 Rotary Horizontal Wrapper			Valid 09/26/2007	
Reqd qty	1.000 EA	Base quant	1.000 EA		
Sales ord.	129850	Item	000150		
Lv	Item	Component no.	Description	Quant	Un
1	0000	131.022988	ASSY-4 FINWHEEL LR PRE-ASSEMBLY		
2	0001	131.026620	01 ASSY-FINWHEELS LR	1.000	EA
2	0002	131.015993	01 KIT-FINWHEEL ELECT.	1.000	EA
2	0004	131.024255	01 KIT-2ND HEATED FIN ELECT	1.000	EA

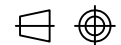
Material	C307	05	0010	Alt.	Usage 3
	Linium 6X1 Rotary Horizontal Wrapper				Valid
					09/26/2007
Reqd qty		1.000	EA	Base quant	1.000 EA
Sales ord.	129850			Item	000150

Lv	Item	Component no.	Description	Quant	Un
1	0000	131.001475	KIT-FINWHEEL-COVERS-STANDARD-CHKRD		
2	0001	231.001475	01 DWG-KIT FIN COVER STD CHECKERED	1.000	EA
2	0002	331.001475	02 LAYOUT-KIT FIN COVER STD CHECKERED	1.000	EA
2	0010	531.000157	03 FINWHEEL-COLD STANDARD CHECKERED	2.000	EA
2	0011	531.000158	04 FINWHEEL-HOT STANDARD CHECKERED	4.000	EA
2	0300	031.000180	01 ELEMENT-FINWHEEL HEAT	4.000	EA
2	0400	397383	KEY-6 X 6 X 12 SST	6.000	EA
2	0401	318898	NUT-HEX FULL M6 SST	8.000	EA
2	0402	031.000190	SCREW-BUTTON HD M12 X 20 SST	6.000	EA
2	0403	432319	SCREW-PAN-SLOT M3 X 6 SST	2.000	EA
2	0404	310164	SCREW-SET M6 X 10 SST	8.000	EA
2	0405	397069	WASHER-FLAT 13 X 24 X 2.5 SST	6.000	EA



Qty.	Index	Description	Date	E.C.N. No.	Changed by
1	1	Updated Parts, M6x10 Set Screw Was M6x20	8Apr99	104399	TCA

1	1				-
Pos.	Qty.	Shape	Material / Werkstoff	Proposed Measurement	Remarks
				Drawn by: J J Helm	Date: 14 Oct 98
				Approved by: Terry Anderson	Scale: 1 : 3
				Checked by:	Size: A3
				-	-
				231.001475	Rev.: 0
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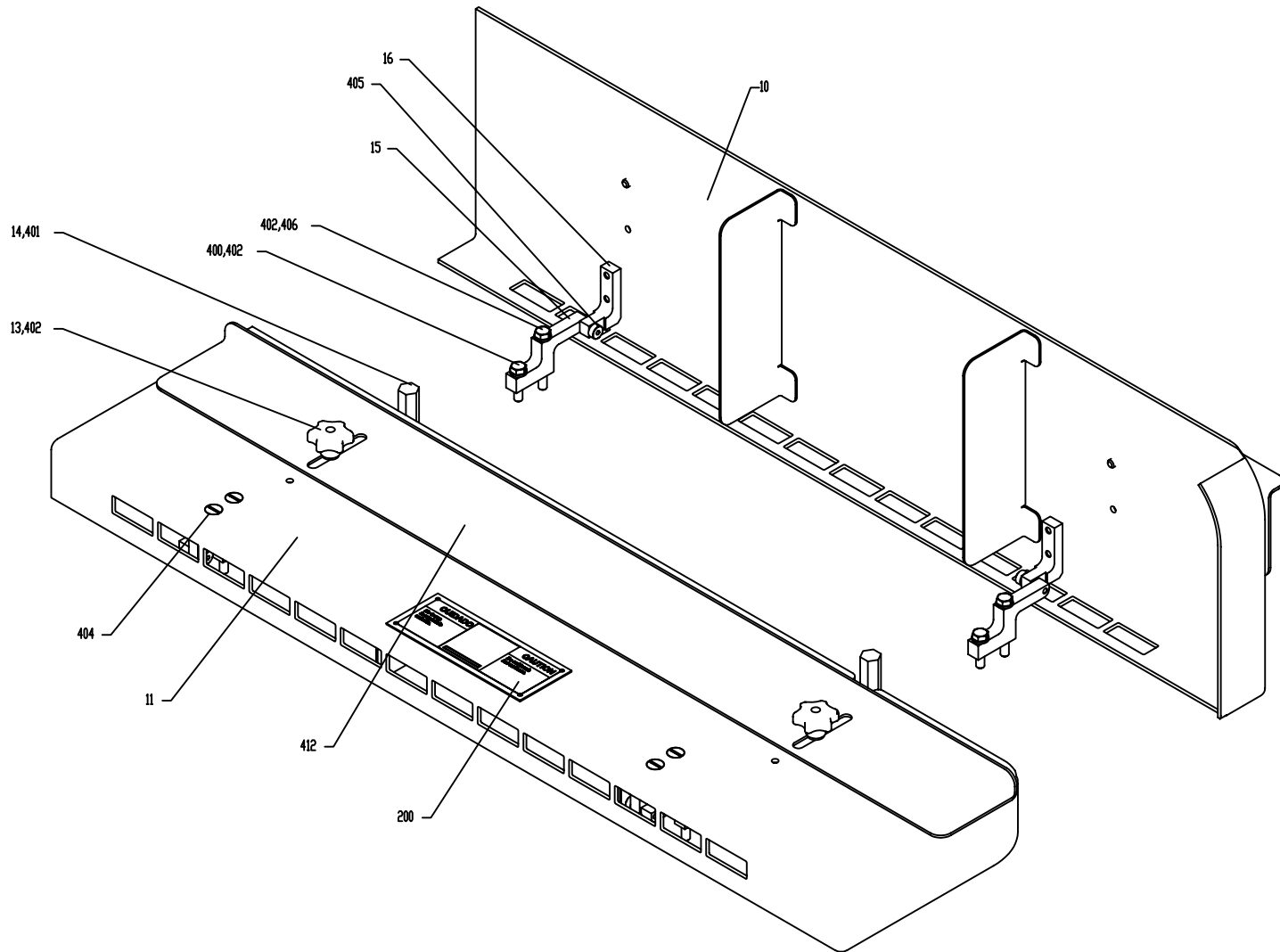


Material	C307	05	0010	Alt.	Usage 3
	Linium 6X1 Rotary Horizontal Wrapper				Valid
					09/26/2007
Reqd qty		1.000	EA	Base quant	1.000 EA
Sales ord.	129850			Item	000150

Lv	Item	Component no.	Description	Quant	Un
1	0000	131.023116	KIT-FINWHEEL GUARDS LR		
2	0013	531.023108	GUARD-FINWHEEL TOP LR	1.000	EA
2	0014	531.018973	02 PLATE-TOP LR	1.000	EA
2	0015	531.015558	PLATE-NUT GUARD	2.000	EA
2	0016	531.015557	PLATE NUT SWITCH	1.000	EA
2	0017	531.018975	01 BLOCK SPACER HINGE	2.000	EA
2	0018	531.018976	BLOCK SPACER SWITCH	1.000	EA
2	0019	531.018968	01 GUARD END	1.000	EA
2	0020	531.018970	COVER BOTTOM	1.000	EA
2	0021	531.018967	GUARD-BOTTOM LR	1.000	EA
2	0022	531.018963	02 GUARD-AUXILIARY DRIVE LR	1.000	EA
2	0024	531.018994	BLOCK HINGE STOP	2.000	EA
2	0025	531.018961	PLATE-FRONT LR	1.000	EA
2	0200	031.013336	HINGE-DOOR DIE CAST ZINC	2.000	EA
2	0304	440579	INTERLOCK SWITCH		
2	0400	379749	WASHER-FLAT 6.4 X 12 X 1.6 SST	16.000	EA
2	0401	310102	SCREW-HEX HD M6 X 12 SST	16.000	EA
2	0405	422076	SCREW-FLAT SLOT M6 X 10 SST	2.000	EA
2	0406	330832	SCREW-FLAT SOC M6 X 10 SST	4.000	EA
2	0407	310086	SCREW-FLAT SOC M4 X 10 SST	2.000	EA
2	0408	398355	SCREW-FLAT SOC M6 X 20 SST	4.000	EA
2	0409	421926	SCREW-PAN-SLOT M6 X 16 SST	4.000	EA
2	0410	397024	SCREW-SOC CAP M4 X 10 SST	2.000	EA
2	0411	397016	SCREW-SOC CAP M4 X 20 SST	2.000	EA
2	0412	401118	WASHER-FLAT 4.3 X 9 X .8 SST	4.000	EA
2	0413	311208	NUT-HEX NYLOCK FULL M4 SST	2.000	EA
2	0414	397005	SCREW-HEX HD M4 X 16 SST	2.000	EA
2	0415	379473	SCREW-PAN SLOT M6 X 10 SST	10.000	EA

Material	C307	05	0010	Alt.	Usage 3
	Linium 6X1 Rotary Horizontal Wrapper			Valid	09/26/2007
Reqd qty		1.000	EA	Base quant	1.000 EA
Sales ord.	129850			Item	000150

Lv	Item	Component no.	Description	Quant	Un
1	0000	131.023109	KIT FINWHL DECKS 120MM LR		
2	0001	231.018995	ASSY KIT - FINWHL DECK 120MM		
2	0010	531.023110	01 DECKPLATE-FINWHEEL DR LR	1.000	EA
2	0011	531.023111	01 DECKPLATE-FINWHEEL OP LR	1.000	EA
2	0012	531.018734	GUIDE PRODUCT	2.000	EA
2	0013	375068	03 KNOB-M6 x 10 STUD STL	4.000	EA
2	0014	531.000178	01 STANDOFF-FINWHEEL DECKPLATE	4.000	EA
2	0015	531.001536	01 BLOCK-HINGE	4.000	EA
2	0016	531.001537	02 HINGE-FINWHEEL DECK	4.000	EA
2	0200	199696	02 DECAL CAU DO NOT TOUCH HOT SUR	1.000	EA
2	0400	388079	SCREW-HEX HD M6 X 25 SST	4.000	EA
2	0401	397059	SCREW-SET M8 X 20 SST	4.000	EA
2	0402	379749	WASHER-FLAT 6.4 X 12 X 1.6 SST	12.000	EA
2	0404	422076	SCREW-FLAT SLOT M6 X 10 SST	8.000	EA
2	0405	397050	SCREW-SHOULDER 6/M5 X 10 SST	4.000	EA
2	0407	406357	SCREW-HEX HD M6 X 45 SST	4.000	EA



Qty.	Index	Description	Date	EDN No.	Changed by
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Kit Finwheel Decks 120mm RL		Drawn by	Steve Larson	Date	31 May 2001
		Approved by	Steve Larson	Scale	A2
		Checked by	Barb Henauer	Size	A2
		Sheet	1/1	It-Type	307
		231.018995		Rev:	0
BOSCH	Doboy	© Copyright	Based on SIS Pack International Design Standards		

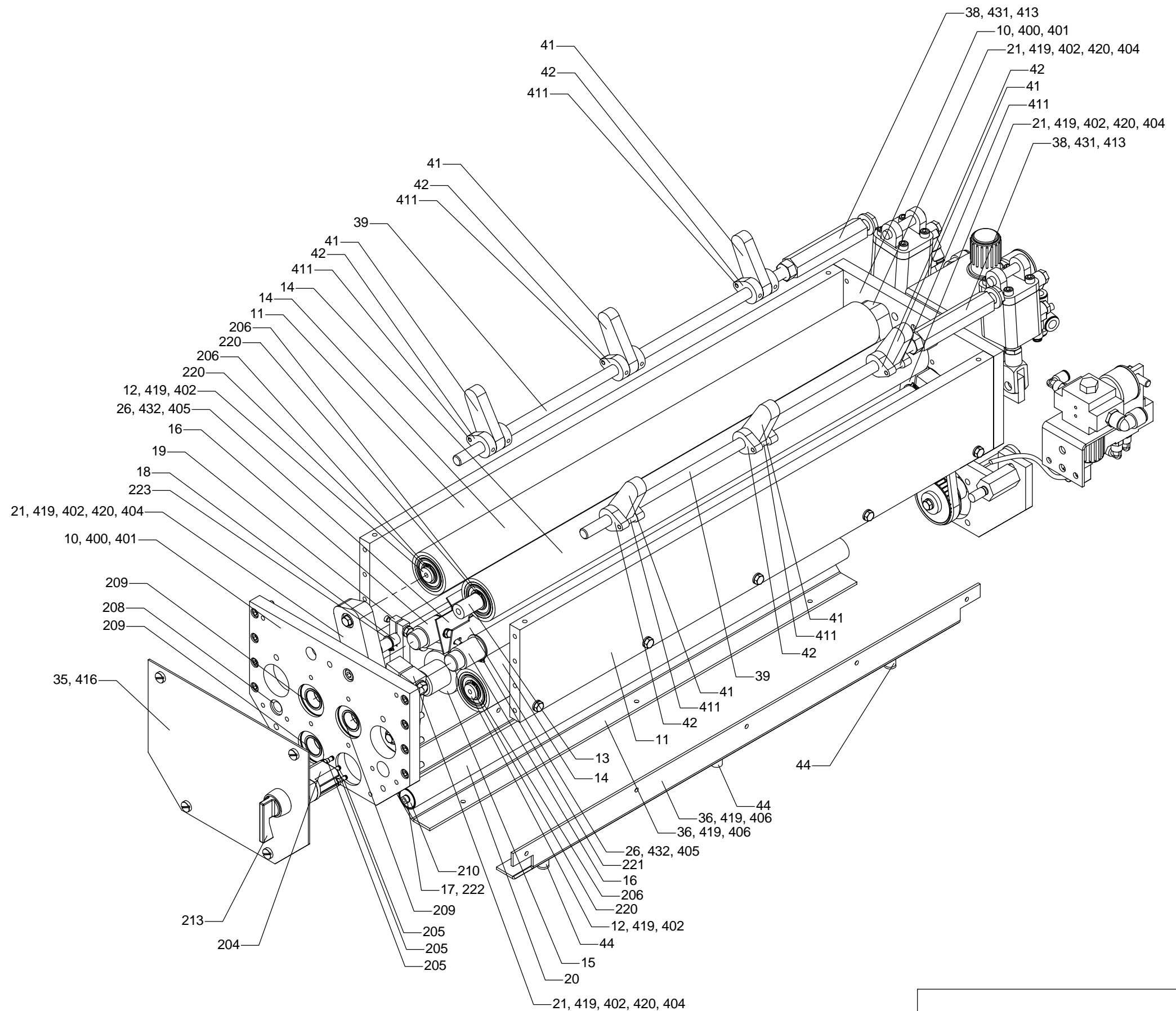
Material	C307	05 0010	Alt.	Usage 3
	Linium 6X1 Rotary Horizontal Wrapper			Valid
				09/26/2007
Reqd qty	1.000 EA	Base quant	1.000 EA	
Sales ord.	129850	Item	000150	

Lv	Item	Component no.	Description	Quant	Un
1	0000	131.047174	ASSY-BACKSTAND 600MM SST LR		
2	0003	431.016492	-SCHEMATIC-600 LINIUM PNEUM		
2	0010	131.007080	WELDMENT-BACKSTAND FRAME EXTENDED SS	1.000	EA
2	0011	531.007014	04 PLATE BEARING	2.000	EA
2	0012	531.007013	02 MOUNT BRAKE CYLINDER	2.000	EA
2	0013	531.000106	03 ARM BRAKE ROLLER	2.000	EA
2	0014	531.016477	SHAFT BRAKE	2.000	EA
2	0015	531.000108	01 CLAMP BRAKE	4.000	EA
2	0016	531.000109	01 ARM BRAKE CYLINDER	2.000	EA
2	0017	531.000112	01 SHAFT BRAKE HOLDER	2.000	EA
2	0018	531.023124	03 SHAFT-FILM ROLL 600 LR	2.000	EA
2	0019	531.023125	SHAFT-ROLL ADJUST	2.000	EA
2	0020	531.000115	01 STOP ROLL ADJUST	2.000	EA
2	0021	531.016226	BLOCK PLATE MOUNT	2.000	EA
2	0022	531.017142	PLATE-ROLL ADJUST	2.000	EA
2	0023	531.007079	02 SHAFT BRAKE ROLLER	2.000	EA
2	0025	531.000935	04 SHAFT PIVOT ARM 600	2.000	EA
2	0026	531.001607	04 ARM PIVOT	1.000	EA
2	0027	531.000123	04 PLATE-PIVOT ARM	1.000	EA
2	0028	531.000246	02 CLAMP PIVOT ARM	3.000	EA
2	0029	531.000247	01 PLATE ROLLER ADJUST	2.000	EA
2	0030	531.000126	01 STUD CLAMP	1.000	EA
2	0031	531.000131	01 BELT BRAKE	2.000	EA
2	0032	531.000132	03 MOUNT REGULATOR	1.000	EA
2	0033	531.007084	01 COVER VERTICAL	1.000	EA
2	0034	531.007012	02 COVER HORIZONTAL	1.000	EA
2	0035	531.000139	02 SPACER ROD END	2.000	EA
2	0036	531.000937	02 ROLLER FILM 600	4.000	EA
2	0037	531.006884	03 COVER END	2.000	EA
2	0038	131.007015	ASSY BKSTD FILM ROLL CHUCK	4.000	EA
2	0039	327713	03 WASHER-ENTRANCE ROLL 1.1X1.3X.9	8.000	EA
2	0040	364212	01 KNOB MOLDED PARENT ROLL	2.000	EA
2	0041	531.029567	DECAL PIVOT ARM L-R	1.000	EA
2	0042	531.008554	02 COVER PIVOT ARM MOUNT HOLES SST	1.000	EA
2	0043	531.002228	02 DECAL PIVOT ARM SCALE	1.000	EA
2	0044	531.002229	02 DECAL PIVOT ARM SCALE	1.000	EA
2	0048	531.008555	02 MOUNT POWER FEED ROLL CYLINDER	2.000	EA
2	0049	531.016218	01 PLUG AIR CYLINDER	2.000	EA
2	0050	531.017141	COLLAR-TENSION-FILM ROLL SHAFT	2.000	EA
2	0051	531.027314	PLATE BEARING	2.000	EA
2	0200	031.000137	CYLINDER AIR	2.000	EA
2	0201	031.010042	REG. LOW PRESSURE W/GAUGE 2 PC	1.000	EA
2	0202	432287	CONNECTOR-ELBOW MALE R1/8 TO 6mm TUB	2.000	EA
2	0203	031.017143	SPRING COMPRESSION	2.000	EA
2	0204	031.010155	01 BEARING-RADIAL BALL 12x37x12	2.000	EA
2	0206	031.016476	BEARING-RADIAL BALL 30x62x20 SELF AL	2.000	EA
2	0207	031.016475	BEARING-RADIAL BALL 40x80x23 SELF AL	2.000	EA
2	0208	370623	SWIVEL-HEAD	2.000	EA



2	0209	365794		CLEVIS W/PIN	2.000	EA
2	0210	521-62613	02	BEARING-NEEDLE ROLLER 24 X 32 X 20	8.000	EA
2	0211	370719		PA TUBE (NYLON) PNEUMATIC 6mm OD	2.000	M
2	0212	031.000521		CONNECTOR-ELBOW MALE R1/4 TO 10mm TU	1.000	EA
2	0213	370720		PA TUBE (NYLON) PNEUMATIC 10mm OD	2.000	M
2	0214	521-56206	03	BEARING-RADIAL BALL 30x62X16	2.000	EA
2	0215	370610		BEARING-RADIAL BALL 40x80x18	2.000	EA
2	0216	031.006389		RING-RTNG-INT 37HSG 1.5THK SST	2.000	EA
2	0217	397373		RING-RTNG EXT 30MM SHAFT DIA SST	4.000	EA
2	0218	282193	01	RING-RETAINING EXTERNAL 24mm SST	8.000	EA
2	0219	427358		LEVER-ADJUSTABLE M12x1.75 BLIND	3.000	EA
2	0220	432286		CONNECTOR-ELBOW MALE R1/4 TO 6mm TUB	1.000	EA
2	0221	393482	01	UNION-Y 6mm OD TUBE	1.000	EA
2	0222	031.027723		SPRING-COMP	2.000	EA
2	0400	031.000326		SCREW-SHOULDER 12/M10 X 20 SST	1.000	EA
2	0401	379749		WASHER-FLAT 6.4 X 12 X 1.6 SST	16.000	EA
2	0402	309393	01	WASHER-FLAT 8.4 X 16 X 1.6 SST	47.000	EA
2	0403	397080		WASHER-FLAT 10.5 X 20 X 2 SST	8.000	EA
2	0404	397058		SCREW-SET M6 X 8 SST	1.000	EA
2	0405	379473		SCREW-PAN SLOT M6 X 10 SST	14.000	EA
2	0406	419471		SCREW-HEX-HD MACH WASH M6 X 12 SST	4.000	EA
2	0407	407802		WASHER-FLAT THK 8.4 X 21 X 4 SST	12.000	EA
2	0408	310143		SCREW-HEX HD M8 X 12 SST	5.000	EA
2	0409	310110		SCREW-HEX HD M8 X 25 SST	14.000	EA
2	0410	310144		SCREW-HEX HD M8 X 30 SST	12.000	EA
2	0411	430377		SCREW-HEX HD M8 X 35 SST	20.000	EA
2	0413	310151		SCREW-HEX HD M10 X 40 SST	4.000	EA
2	0416	318898		NUT-HEX FULL M6 SST	8.000	EA
2	0418	310106		SCREW-HEX HD M6 X 10 SST	4.000	EA
2	0419	310176		NUT-HEX FULL M12 SST	2.000	EA
2	0420	310096		SCREW-FLAT SOC M5 X 10 SST	2.000	EA
2	0421	310114		SCREW-HEX HD M8 X 16 SST	8.000	EA
2	0422	378658	01	SCREW-SHOULDER 8/M6 X 20 SST	2.000	EA
2	0424	362992		SCREW-PAN-STEEL M4 X 35 STL	4.000	EA
2	0425	483503		NUT-HEX JAM M12 SST	2.000	EA
2	0426	397069		WASHER-FLAT 13 X 24 X 2.5 SST	2.000	EA
2	0427	388080		NUT-HEX-FULL-FINE M10 SST	2.000	EA
2	0428	397080		WASHER-FLAT 10.5 X 20 X 2 SST	4.000	EA

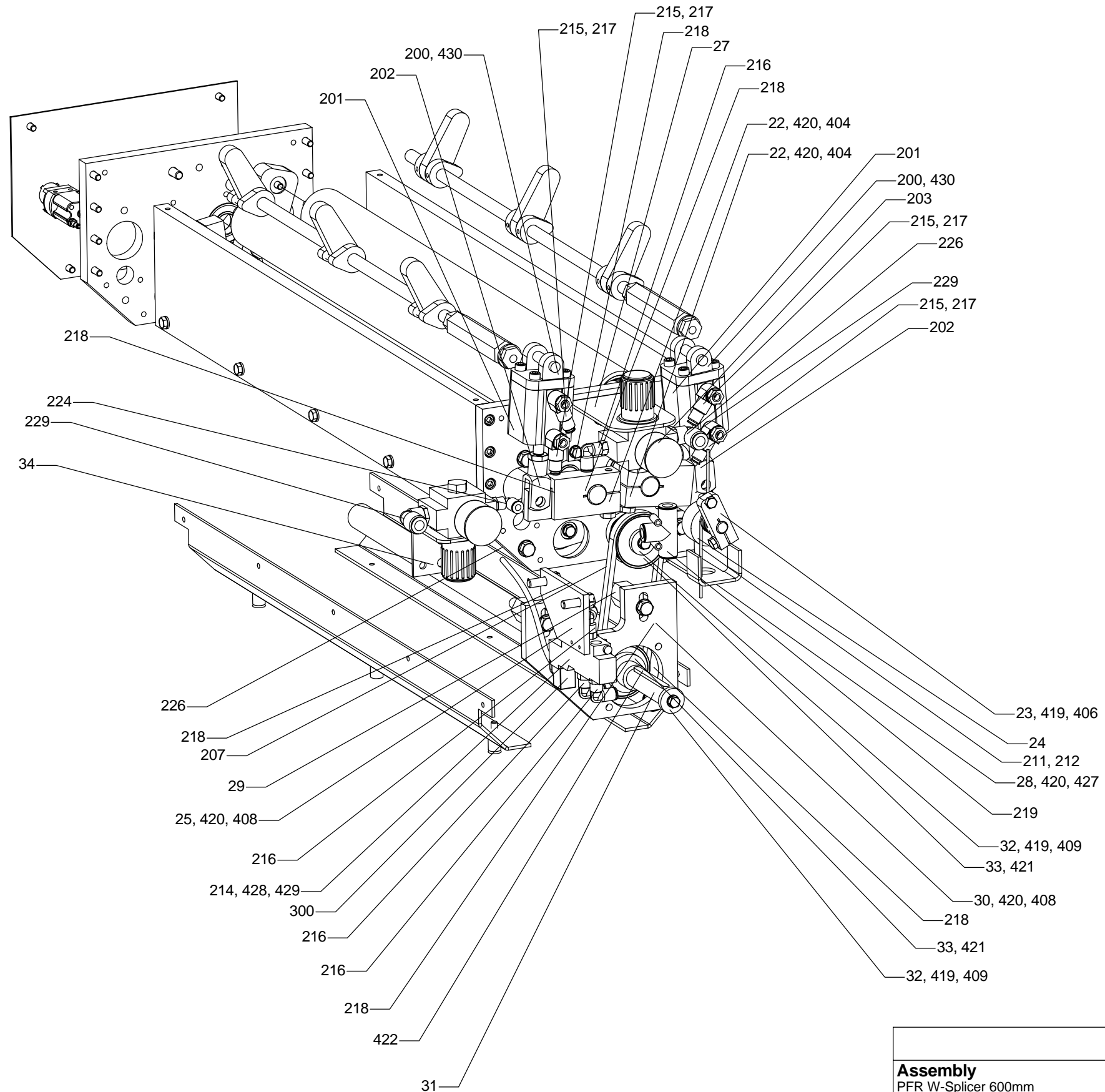
Material	C307	05 0010	Alt.	Usage 3
	Linium 6X1 Rotary Horizontal Wrapper			Valid
				09/26/2007
Reqd qty	1.000 EA	Base quant	1.000 EA	
Sales ord.	129850	Item	000150	

Lv	Item	Component no.	Description	Quant	Un
1	0000	131.029612	ASSY-PFR EYE SPLICER 600MM LR		
2	0001	231.029610	Assy Dwg-PFR W-Splicer 600mm		
2	0010	131.029610	03 ASSY-PFR W/SPLICER 600mm	1.000	EA
2	0012	531.000934	02 SHAFT FILM ROLLER 600	4.000	EA
2	0013	531.000937	02 ROLLER FILM 600	4.000	EA
2	0014	327713	03 WASHER-ENTRANCE ROLL 1.1X1.3X.9	8.000	EA
2	0015	531.000956	04 BRKT MNT SPLICE EYE 600	2.000	EA
2	0201	521-62613	02 BEARING-NEEDLE ROLLER 24 X 32 X 20	8.000	EA
2	0202	282193	01 RING-RETAINING EXTERNAL 24mm SST	8.000	EA
2	0401	412893	SCREW-SOC CAP M10 X 30 SST	2.000	EA
2	0403	397080	WASHER-FLAT 10.5 X 20 X 2 SST	2.000	EA
2	0404	397010	SCREW-HEX HD M10 X 45 SST	2.000	EA
2	0405	309393	01 WASHER-FLAT 8.4 X 16 X 1.6 SST	4.000	EA
2	0406	430377	SCREW-HEX HD M8 X 35 SST	4.000	EA



Qty.	Index	Description	Date	ECN No.	Changed by
-	3	Item 211 306379 Was 216723	27 Apr 04	176015	SRL
-	2	Updated per ECN	21 Aug 03	172285	DWL
-	1	Updated per ECN	4 Aug 03	172082	DWL

Assembly PFR W-Splicer 600mm		Drawn by: Kirk Bryan	Date: 21 Jun 2002
		Approved by: Kirk Bryan	Scale: 1:3
 		Checked by: Barb Hemauer	Size: A2
		Sheet: 1/2	M-Type: 225
		231.029610	Rev.: 3
		© Copyright Doboy Inc.	Based on SIG Pack International Design Standards



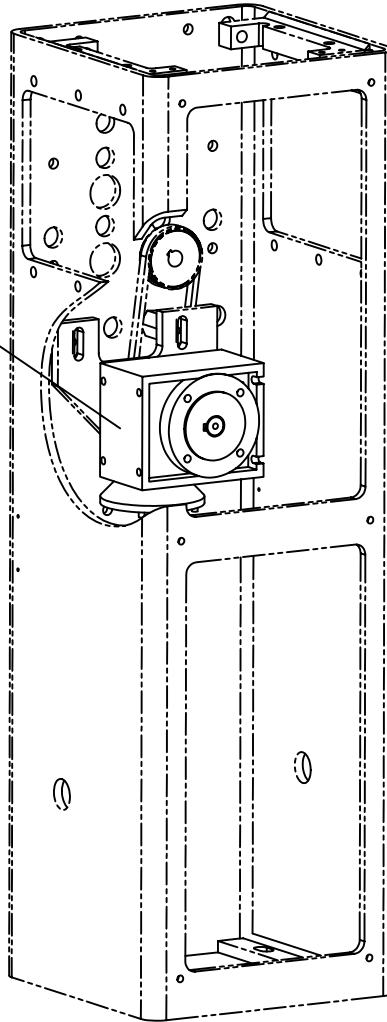
Qty.	Index	Description	Date	ECN No.	Changed by
-	3	Item 211 306379 Was 216723	27 Apr 04	176015	SRL
-	2	Updated per ECN	21 Aug 03	172285	DWL
-	1	Updated per ECN	4 Aug 03	172082	DWL

Assembly PFR W-Splicer 600mm		Drawn by: Kirk Bryan	Date: 21 Jun 2002
		Approved by: Kirk Bryan	Scale: 1:3
BOSCH		Checked by: Barb Hemauer	Size: A2
		Sheet: 2/2	M-Type: 225
Doboy Inc.		231.029610	
		Rev.: 3	
© Copyright Doboy Inc.		Based on SIG Pack International Design Standards	

Material	C307	05	0010	Alt.	Usage 3
	Linium 6X1 Rotary Horizontal Wrapper			Valid	09/26/2007
Reqd qty		1.000	EA	Base quant	1.000 EA
Sales ord.	129850			Item	000150

Lv	Item	Component no.	Description	Quant	Un
1	0000	131.001827	KIT-HIGH SPEED POWER FEED ROLL DRIVE		
2	0000	131.001826 :	KIT-LOW SPEED POWER FEED R		
2	0001	231.001827	Kit Backstand High Speed Power Feed	1.000	EA
2	0006	431.001827	SCHEMATIC DR BKSTD HIGH SPEED PFR	1.000	EA
2	0200	031.001819	REDUCER MOTOVARIO NMRV-040-7.5:1	1.000	EA
2	0400	310098	SCREW-HEX HD M6 X 20 SST	4.000	EA
2	0401	379749	WASHER-FLAT 6.4 X 12 X 1.6 SST	4.000	EA

200, 400, 401

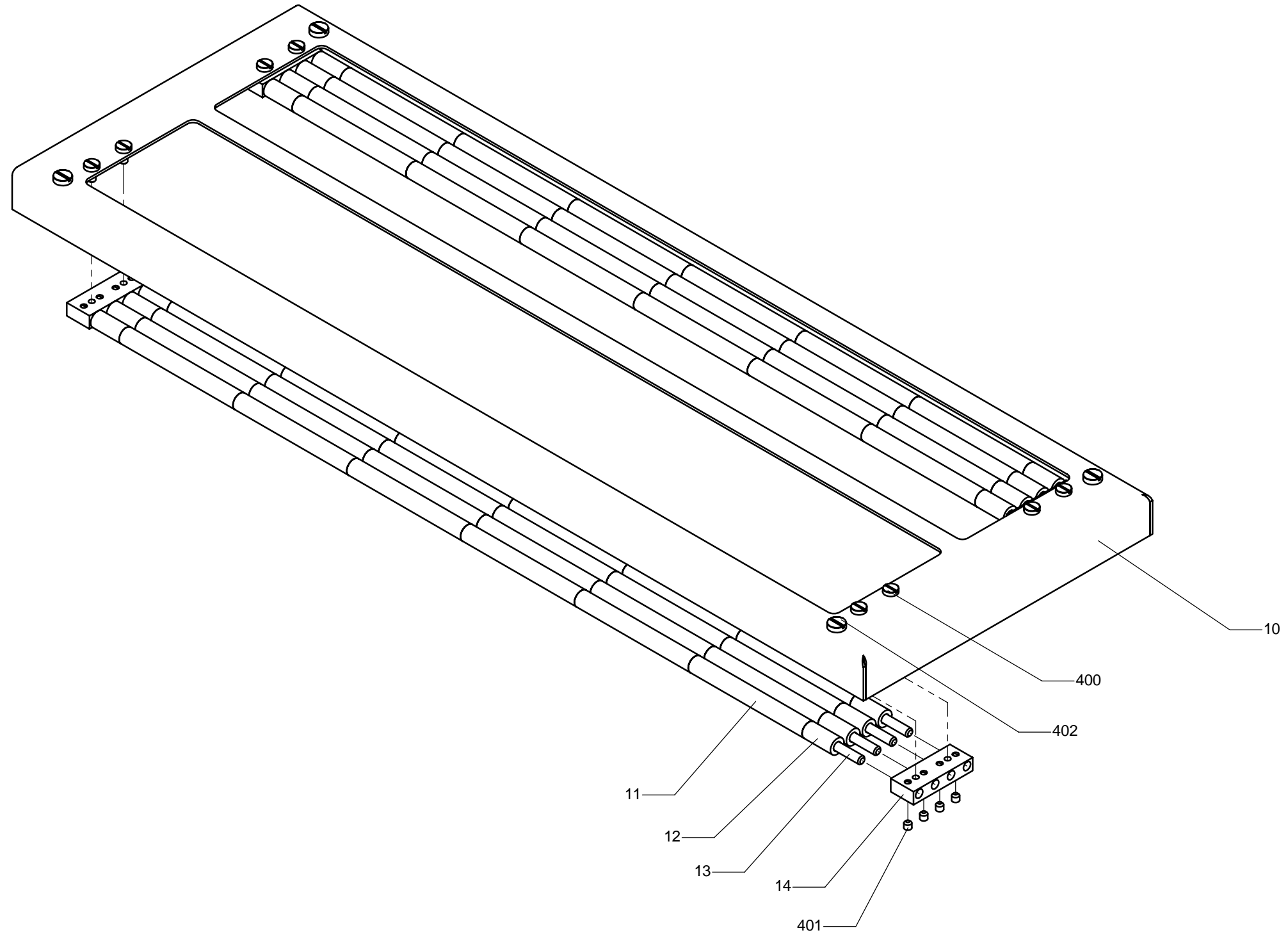


		Drawn by	Jonathan Ditto	Date	03 Dec 2001
		Approved by	John Melsner	Scale	1:3
KIT Backstand HIGH SPEED POWER FEED ROLL		Checked by	Barb Henauer	Size	A2
			Sheet 1/1	H-Type	225
		231.001827		Rev:	0
BOSCH		Doboy Inc.		© Copyright Doboy Inc.	Based on Siemens International Design Standards

Qty.	Index	Description	Date	EDN No.	Changed by
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Material	C307	05 0010	Alt.	Usage 3
	Linium 6X1 Rotary Horizontal Wrapper			Valid
				09/26/2007
Reqd qty		1.000 EA	Base quant	1.000 EA
Sales ord.	129850		Item	000150

Lv	Item	Component no.	Description	Quant	Un
1	0000	131.001747	KIT-BKSTD COLD SEAL SPLCR DECKS 600MM		
2	0001	231.001747	DWG-BKSTD COLD SEAL SPLCR DECKS 600M	1.000	EA
2	0010	531.000976	05 DECK COLD SEAL PFR 600	1.000	EA
2	0011	531.000972	01 ROLLER COLD SEAL LONG	48.000	EA
2	0012	531.000973	01 ROLLER COLD SEAL SHORT	16.000	EA
2	0013	531.000977	01 SHAFT COLD SEAL ROLLER 600	8.000	EA
2	0014	531.000975	02 BLOCK COLD SEAL ROLLER MOUNT	4.000	EA
2	0400	310095	SCREW-PAN SLOT M5 X 10 SST	8.000	EA
2	0401	397054	SCREW-SET M5 X 5 SST	16.000	EA
2	0402	379473	SCREW-PAN SLOT M6 X 10 SST	4.000	EA

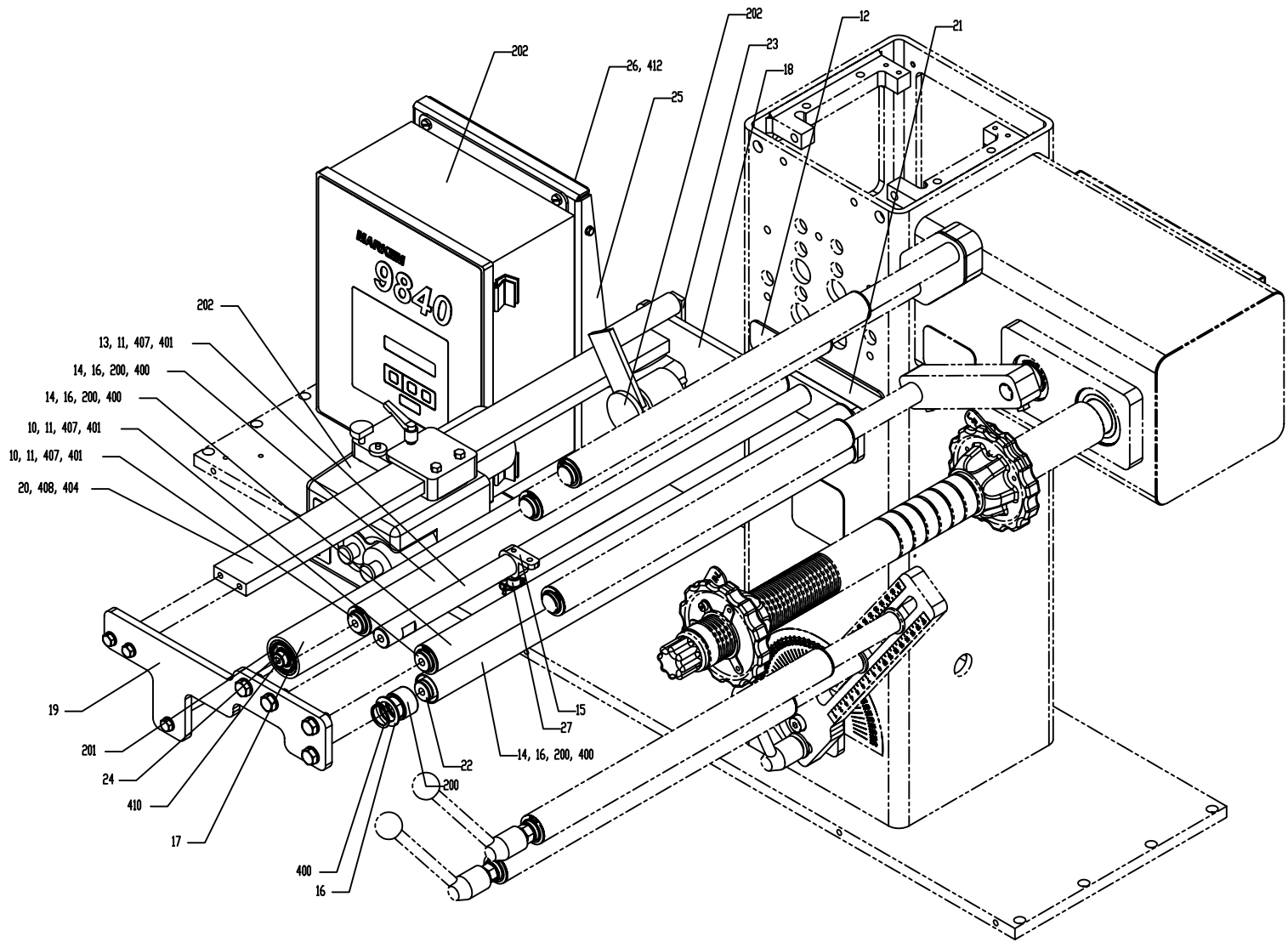


Qty.	Index	Description	Date	ECN No.	Changed by
0	3	Update per ECN	26 Dec 02	169161	DWL
0	2	Update per ECN	15 Dec 98	100530	OP
0	1	Update per ECN	21 Oct 98	83810	SAE

Assy Bkstd Cold Seal Splcr Decks 600mm		Drawn by: Bryan Mueller	Date: 28 Mar 2005
		Approved by: Bryan Mueller	Scale: 1:2
BOSCH		Checked by:	Size: A2
		Sheet: 1/1	M-Type: 225
Doboy Inc.		231.001747	
		Rev.: 3	
BOSCH		© Copyright Doboy Inc.	Based on SIG Pack International Design Standards

Material	C307	05 0010	Alt.	Usage 3
	Linium 6X1 Rotary Horizontal Wrapper			Valid
				09/26/2007
Reqd qty		1.000 EA	Base quant	1.000 EA
Sales ord.	129850		Item	000150

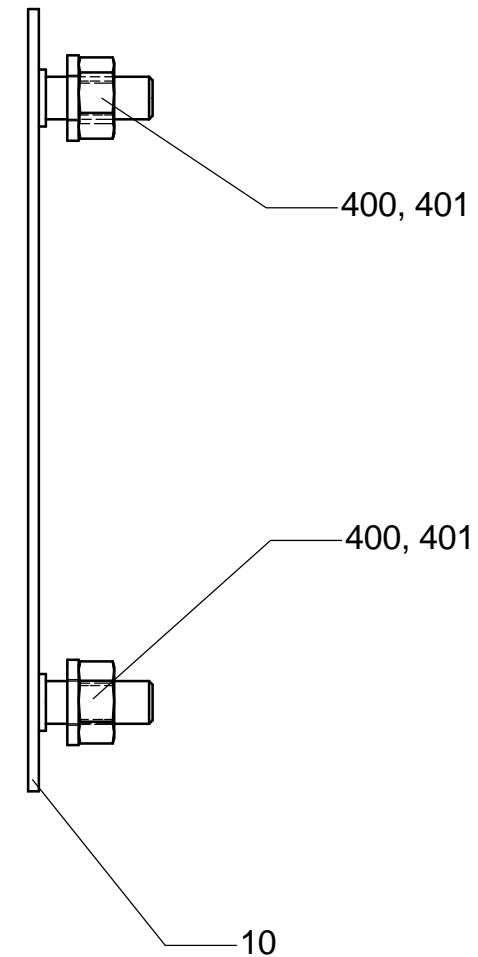
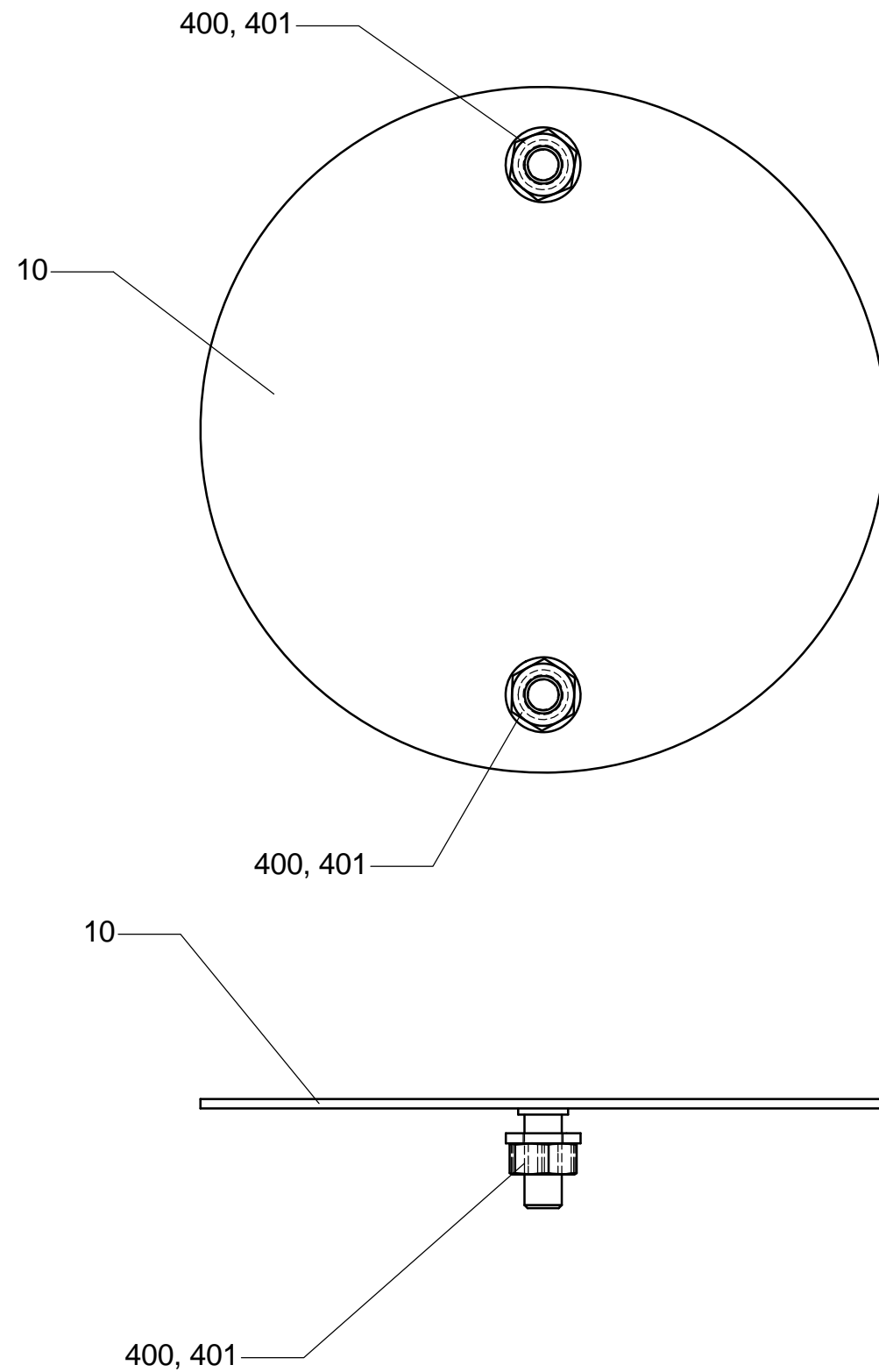
Lv	Item	Component no.	Description	Quant	Un
1	0000	131.063153	KIT BACKSTAND 9840 MNT W/SICK SCANNER		
2	0001	231.001748	DRAWING-KIT BACKSTAND CODER 600mm RL	1.000	EA
2	0010	531.000959	05 SHAFT FILM ROLLER CODER 600	2.000	EA
2	0011	531.000120	01 WASHER ROLLER SHAFT	3.000	EA
2	0012	531.000927	01 COVER LOWER HOLES	1.000	EA
2	0013	531.000960	04 SHAFT EYE MOUNT CODER 600	1.000	EA
2	0014	531.000937	02 ROLLER FILM 600	4.000	EA
2	0015	531.000142	01 MOUNT EYE	1.000	EA
2	0016	327713	03 WASHER-ENTRANCE ROLL 1.1X1.3X.9	8.000	EA
2	0017	531.000943	02 ROLLER FILM RUBBER COATED 650	1.000	EA
2	0018	531.062541	PLATE 9840 CODER MOUNT W/BAR SCANNER	1.000	EA
2	0019	531.063149	PLATE 9840 CODER MOUNT W/BAR SCANNER	1.000	EA
2	0020	531.000958	02 BAR BKSTD MOUNT CODER 600	1.000	EA
2	0021	531.000289	02 SPACER CODER MTG	1.000	EA
2	0022	531.000961	03 SHAFT FILM ROLLER CODER 600	2.000	EA
2	0023	531.000926	01 BRKT ENCODER MOUNT	1.000	EA
2	0024	531.000962	02 SHAFT BACKUP ROLLER CODER 600	1.000	EA
2	0025	531.002741	01 BRKT CODER BOX MOUNT	1.000	EA
2	0026	531.002742	03 COVER CODER BOX MOUNT BRKT	1.000	EA
2	0027	375068	03 KNOB-M6 x 10 STUD STL	1.000	EA
2	0028	531.063150	PLATE BAR CODE SCANNER BACK	1.000	EA
2	0029	531.063151	BRACKET CODER MOUNT	1.000	EA
2	0030	531.063152	BRACKET SICK BAR CODE SCANNER	1.000	EA
2	0031	531.048034	CLAMP-BRKT MOUNT	1.000	EA
2	0032	531.046341	ROD-SLIDE	2.000	EA
2	0033	531.048036	PLATE-ROD ATTACHMENT	2.000	EA
2	0034	531.025840	BLOCK BACKUP MOUNTING	4.000	EA
2	0200	521-62613	02 BEARING-NEEDLE ROLLER 24 X 32 X 20	8.000	EA
2	0201	370609	BEARING-RADIAL BALL 17 X 35 X 10	2.000	EA
2	0400	282193	01 RING-RETAINING EXTERNAL 24mm SST	5.000	EA
2	0401	310149	SCREW-HEX HD M10 X 25 SST	5.000	EA
2	0403	310144	SCREW-HEX HD M8 X 30 SST	2.000	EA
2	0404	310110	SCREW-HEX HD M8 X 25 SST	3.000	EA
2	0406	310098	SCREW-HEX HD M6 X 20 SST	2.000	EA
2	0407	397080	WASHER-FLAT 10.5 X 20 X 2 SST	4.000	EA
2	0408	309393	01 WASHER-FLAT 8.4 X 16 X 1.6 SST	7.000	EA
2	0409	379749	WASHER-FLAT 6.4 X 12 X 1.6 SST	4.000	EA
2	0410	397369	RING-RETAINING EXTERNAL 17mm SST	2.000	EA
2	0411	432072	SCREW-HEX HD M8 X 20 SST	2.000	EA
2	0412	422010	SCREW-HEX HD M5 X 10 SST	4.000	EA



Kit Backstand Coder 600mm		Drawn by Jon Otto	Date 11 Dec 2002
		Approved by Jon Otto	Scale 1:3
		Checked by Barb Henauer	Size A2
		Sheet 1/1	M-Type 225
		231.001748	Rev: 0
BOSCH	Doboy Inc.	© Copyright Doboy Inc.	Based on Spack International Design Standards

Qty.	Index	Description	Date	EDN No.	Changed by
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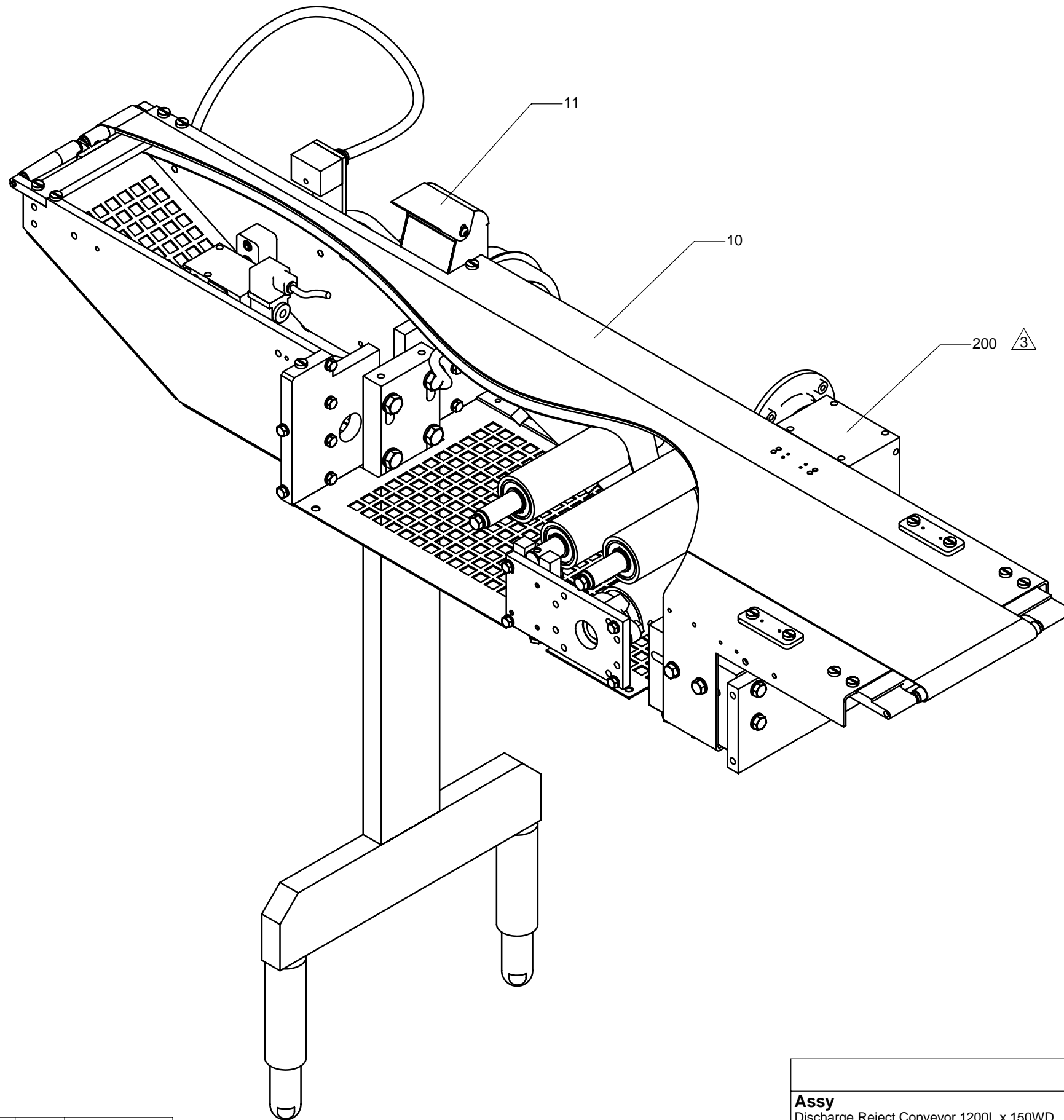
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Reqd qty	1.000 EA	Base quant	1.000 EA		
Sales ord.	129850	Item	000150		
Lv	Item	Component no.	Description	Quant	Un
1	0000	131.016764	KIT-NO FILM HOIST USDA		
2	0001	231.016764	DWG-NO FILM HOIST-USDA	1.000	EA
2	0010	531.008557	01 COVER FILM HOIST HOLES USDA	1.000	EA
2	0400	318898	NUT-HEX FULL M6 SST	2.000	EA
2	0401	379749	WASHER-FLAT 6.4 X 12 X 1.6 SST	2.000	EA



		Drawn by: Corey Monson	Date: 3 Dec 2001
		Approved by: John Meisner	Scale: 1:1
		Checked by: Barb Hemauer	Size: A3
		Sheet: 1/1	M-Type: 307
		231.016764	Rev.: 0
BOSCH	Doboy Inc.	© Copyright Doboy Inc.	Based on SIG Pack International Design Standards

Qty.	Index	Description	Date	ECN No.	Changed by
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Material	C307	05 0010	Alt.	Usage 3	
	Linium 6X1 Rotary Horizontal Wrapper			Valid	
				09/26/2007	
Reqd qty	1.000 EA	Base quant	1.000 EA		
Sales ord.	129850	Item	000150		
Lv	Item	Component no.	Description	Quant	Un
1	0000	131.025540	ASSY-DISCHARGE CNVR W/ REJECT 1200mm		
2	0001	231.025540	Assy Drawing Discharge Reject Conveyor 1200L x 150W		
2	0010	131.027740	02 KIT-FRAME 1200 DISCH	1.000	EA
2	0010	***ADDS/DELETES EXSIST			
2	0011	131.049511	01 KIT-DISCHARGE AIR REJECT	1.000	EA
2	0200	031.002479	GEAR-REDUCER NMRV040 5:1 RATIO	1.000	EA

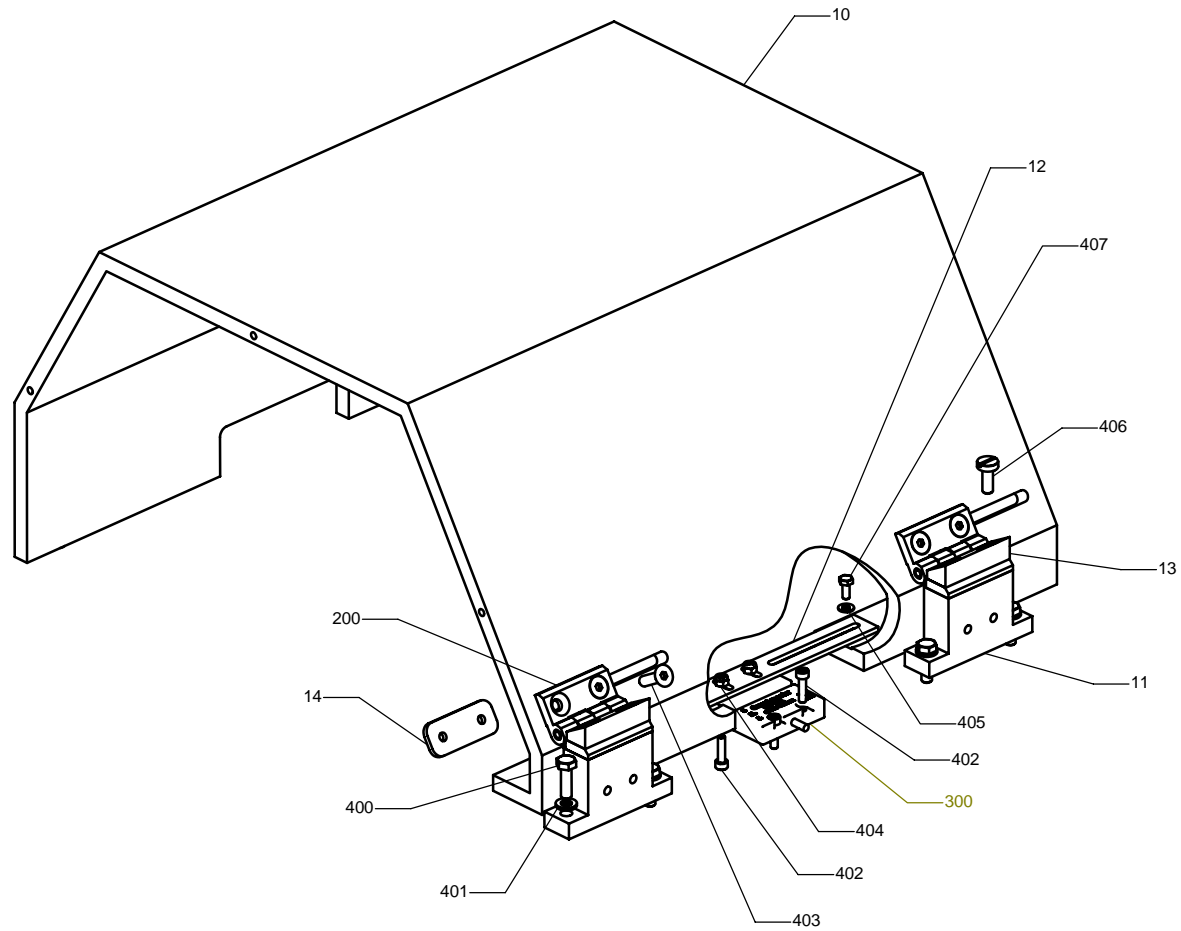


Qty.	Index	Description	Date	ECN No.	Changed by
0	4	Change reject kit	21 Dec 05	185710	BKM
1	3	Update per bom & add item 200	21 Jul 04	177049	BKM
2	2	Added item 37 and 211	18 Aug 03	172274	BKG
1	1	Added Item 41 & Related Hardware	18 Jan 03	169450	DWL

Assy Discharge Reject Conveyor 1200L x 150WD		Drawn by: Jon Otto	Date: 20 Jul 2002
		Approved by: Jon Otto	Scale: 1:3
BOSCH Doboy Inc.		Checked by: Barb Hemauer	Size: A2
		Sheet: 1/1	M-Type: 307
		231.025540	Rev.: 4
		© Copyright Doboy Inc.	Based on Sigpack International Design Standards

Material	C307	05	0010	Alt.	Usage 3
	Linium 6X1 Rotary Horizontal Wrapper				Valid
					09/26/2007
Reqd qty		1.000	EA	Base quant	1.000 EA
Sales ord.	129850			Item	000150

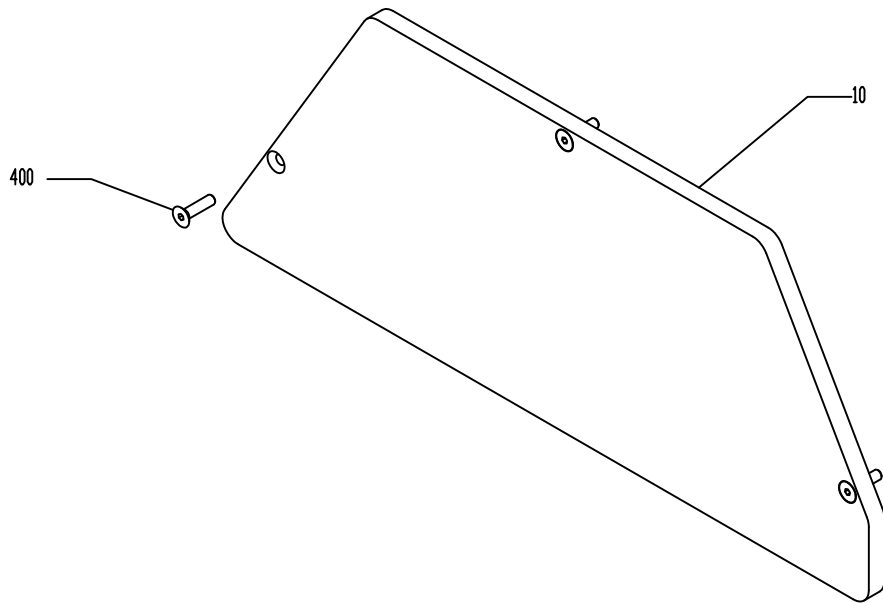
Lv	Item	Component no.	Description	Quant	Un
1	0000	131.021186	KIT-DISCHARGE GUARD TOP		
2	0001	231.021186	KIT DISCHARGE GUARD TOP	1.000	EA
2	0010	531.021895	01 GUARD DISCHARGE TOP	1.000	EA
2	0011	531.021896	01 BRACKET GUARD ATTACHMENT	2.000	EA
2	0012	531.021897	01 PLATE SENSOR ATTACHMENT	1.000	EA
2	0013	531.018994	BLOCK HINGE STOP	2.000	EA
2	0014	531.015558	PLATE-NUT GUARD	2.000	EA
2	0200	031.013336	HINGE-DOOR DIE CAST ZINC	2.000	EA
2	0300	479833	INTERLOCK SWITCH		
2	0400	310098	SCREW-HEX HD M6 X 20 SST	4.000	EA
2	0401	379749	WASHER-FLAT 6.4 X 12 X 1.6 SST	4.000	EA
2	0402	401213	SCREW-SOC CAP M4 X 16 SST	4.000	EA
2	0403	398355	SCREW-FLAT SOC M6 X 20 SST	4.000	EA
2	0404	311208	NUT-HEX NYLOCK FULL M4 SST	2.000	EA
2	0405	401118	WASHER-FLAT 4.3 X 9 X .8 SST	2.000	EA
2	0406	421926	SCREW-PAN-SLOT M6 X 16 SST	4.000	EA
2	0407	407551	SCREW-HEX HD M4 X 10 SST	2.000	EA



Kit Discharge Guard Top	Drawn by: Roger Hefty	Date: 11 Apr 2002
	Approved by: Roger Hefty	Scale: 1:2
	Checked by: Barb Hemauer	Size: A2
	Sheet: 1/1	M-Type: 307
231.021186		Rev.: 0
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		Based on SIG Pack International Design Standards

Qty.	Index	Description	Date	ECN No.	Changed by

Material	C307	05 0010	Alt.	Usage 3	
	Linium 6X1 Rotary Horizontal Wrapper			Valid 09/26/2007	
Reqd qty	1.000 EA	Base quant	1.000 EA		
Sales ord.	129850	Item	000150		
Lv	Item	Component no.	Description	Quant	Un
1	0000	131.021190	KIT-PLATE DISCHARGE END		
2	0001	231.021190			
2	0010	531.021898	PLATE DISCHARGE GUARD END	2.000	EA
2	0400	318900	SCREW-FLAT SOC M5 X 20 SST	8.000	EA



		Drawn by:	Roger Hefty	Date:	03 May 2002
		Approved by:	Roger Hefty	Scale:	1:2
Kit Plate Discharge End		Checked by:	Barb Hemauer	Size:	A3
				#-Type:	307
		231.021190		Rev.:	0
BOSCH		Doboy Inc.		© Copyright Doboy Inc.	Based on Sigpack International Design Standards

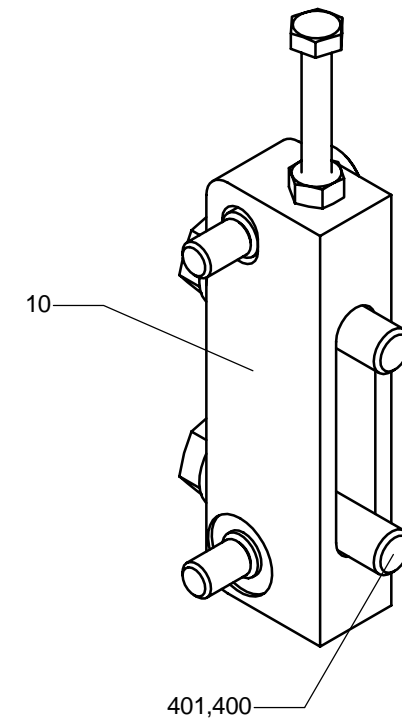
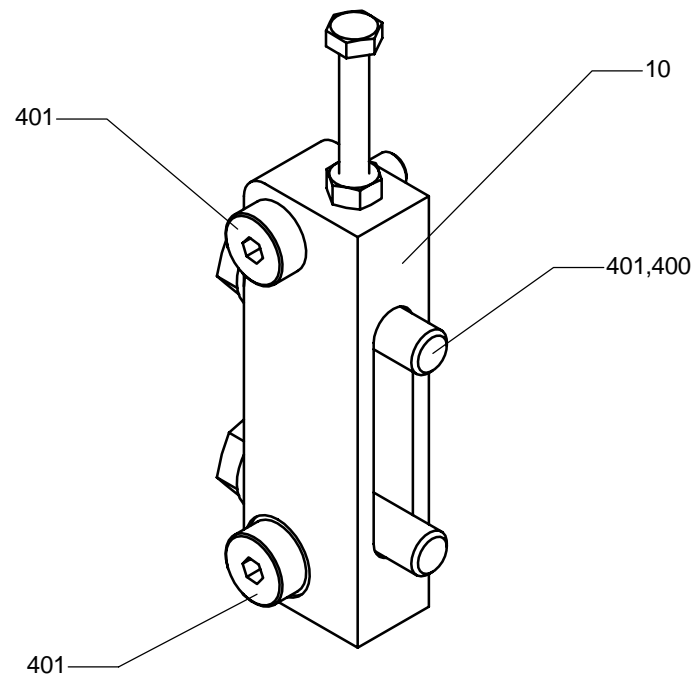
Qty.	Index	Description	Date	ECN No.	Changed by

Material	C307	05	0010	Alt.	Usage 3
	Linium 6X1 Rotary Horizontal Wrapper			Valid	09/26/2007
Reqd qty		1.000	EA	Base quant	1.000 EA
Sales ord.	129850			Item	000150

Lv	Item	Component no.	Description	Quant	Un
1	0000	131.023481	KIT-DISCH GUARDS 1200 LR-REJECT TOWARD		
2	0010	531.025553	CHUTE REJECT LR	1.000	EA
2	0011	531.014392	DECK BLOWER SIDE	1.000	EA
2	0012	531.025884	GUARD-DISCHARGE REAR LR	1.000	EA
2	0013	531.025559	GUARD DISCHARGE FRONT LR	1.000	EA
2	0015	531.024493	BRACE GUARD FRONT	2.000	EA
2	0016	531.024494	BRACKET GUARD ATTACHMENT LR	1.000	EA
2	0017	531.002460	01 STANDOFF AIR NOZZLE DECK	2.000	EA
2	0400	379473	SCREW-PAN SLOT M6 X 10 SST	4.000	EA
2	0401	397007	SCREW-HEX HD M5 X 8 SST	8.000	EA
2	0402	401228	WASHER-FLAT 5.3 X 10 X 1 SST	8.000	EA
2	0403	442519	SCREW-PAN-SLOTTED M8 X 20 SST	2.000	EA
2	0404	310098	SCREW-HEX HD M6 X 20 SST	4.000	EA
2	0405	379749	WASHER-FLAT 6.4 X 12 X 1.6 SST	4.000	EA

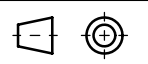
Material	C307	05 0010	Alt.	Usage 3
	Linium 6X1 Rotary Horizontal Wrapper			Valid 09/26/2007
Reqd qty	1.000 EA	Base quant	1.000 EA	
Sales ord.	129850	Item	000150	

Lv	Item	Component no.	Description	Quant	Un
1	0000	131.025560	KIT-DISCHARGE MOUNTING		
2	0001	231.025560	KIT-DISCHARGE-MOUNTING	1.000	EA
2	0010	531.000061	02 BRKT CNVR MNT	2.000	EA
2	0400	397080	WASHER-FLAT 10.5 X 20 X 2 SST	4.000	EA
2	0401	397010	SCREW-HEX HD M10 X 45 SST	4.000	EA
2	0402	310170	SCREW-SHOULDER 10/M8 X 20 SST	4.000	EA



Qty.	Index	Description	Date	ECN No.	Changed by
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Kit Mounting Discharge		Drawn by: Jon Otto	Date: 8 Aug 2002
		Approved by: Jon Otto	Scale: 1:1
		Checked by: Barb Hemauer	Size: A2
		Sheet: 1/1	M-Type: 225
		231.025560	
		Rev.: 0	
BOSCH	Doboy Inc.	© Copyright Doboy Inc.	Based on SIG Pack International Design Standards



Material	C307	05 0010	Alt.	Usage 3
	Linium 6X1 Rotary Horizontal Wrapper			Valid
				09/26/2007
Reqd qty		1.000 EA	Base quant	1.000 EA
Sales ord.	129850		Item	00010

Lv	Item	Component no.	Description	Quant	Un
1	0000	131.058928	KIT MAIN PANEL PRE-ASSY LR 07		
2	0300	131.058927	03 KIT MAIN BASIC (CLX) L-R 07	1.000	EA
2	0300	ADDS AND DELETES IN 131.058927			
2	0301	131.056549	KIT CONTROLOGIX LINIUM 61X 07	1.000	EA
2	0301	CHANGES IN 131.056549 KIT CONTROLOGIX LINIUM 61X 07			
2	0303	WAS CIRCUIT BREAKER 183341 QTY 1			
2	0304	497549	LABEL DANGER ARC FLASH	1.000	EA

Material	C307	05 0010	Alt.	Usage 3
	Linium 6X1 Rotary Horizontal Wrapper			Valid
				09/26/2007
Reqd qty		1.000 EA	Base quant	1.000 EA
Sales ord.	129850		Item	000150

Lv	Item	Component no.	Description	Quant	Un
1	0000	131.062538	KIT 440-480V SPECIAL		
2	0300	631.048184	CIRCUIT BREAKER 15AMP	1.000	EA
2	0301	631.048185	01 DIN RAIL ADAPTER FOR 140U CB	1.000	EA
2	0302	8-110-622-367	CB 140U COVER	1.000	EA
2	0303	262821	02 TRANSFORMER 9 KVA	1.000	EA
2	0304	440559	CONNECTOR-STRAIN RELIEF PG-16	1.000	EA
2	0305	497549	LABEL DANGER ARC FLASH	1.000	EA

Material	C307	05 0010	Alt.	Usage 3
	Linium 6X1 Rotary Horizontal Wrapper			Valid
				09/26/2007
Reqd qty		1.000 EA	Base quant	1.000 EA
Sales ord.	129850		Item	000150

Lv	Item	Component no.	Description	Quant	Un
1	0000	131.062537	KIT OPER INTERFACE PV1000+ SPECIAL		
2	0001	631.035057	TOUCHSCREEN PANELVIEW PLUS 1000 ENET	1.000	EA
2	0002	347722	SWITCH PUSHBUTTON ILLUM A-B N4X RED	1.000	EA
2	0003	439405	NAMEPLATE-YELLOW RING	1.000	EA
2	0004	347717	SWITCH PUSHBUTTON A-B NEMA 4X GREEN	1.000	EA
2	0005	514862	01 NAMEPLATE-START	1.000	EA
2	0006	347718	SWITCH PUSHBUTTON A-B NEMA 4X RED	1.000	EA
2	0007	514860	02 NAMEPLATE,STOP	1.000	EA

Material	C307	05 0010	Alt.	Usage 3	
	Linium 6X1 Rotary Horizontal Wrapper			Valid 09/26/2007	
Reqd qty	1.000 EA	Base quant	1.000 EA		
Sales ord.	129850	Item	000150		
Lv	Item	Component no.	Description	Quant	Un
1	0000	131.016089	KIT-POWER FEED ROLL ELECT (CTRLLGX)		
2	0301	8-110-621-328	02 ASSY- MOTOR/CABLE ASSEMBLY	1.000	EA
2	0304	474389	SENSOR-PROXIMITY INDUCTIVE18mm DEVIC	1.000	EA
2	0306	404635	02 CABLE-FEMALE 4COND #16 15' LONG	1.000	EA

Material	C307	05 0010	Alt.	Usage 3
	Linium 6X1 Rotary Horizontal Wrapper			Valid 09/26/2007
Reqd qty	1.000 EA	Base quant	1.000 EA	
Sales ord.	129850	Item	000150	

Lv	Item	Component no.	Description	Quant	Un
1	0000	131.002403	KIT-REGISTRATION EYE ELECT		
2	0300	440528	EYE-PHOTOELECTRIC	1.000	EA
2	0301	440529	01 CABLE-FIBER OPTIC DUPLEX	1.000	EA
2	0302	379508	STRAIN RELIEF PG21 NYLON 13-18MM	1.000	EA
2	0303	440561	MULTI HOLE SEAL INSERT	1.000	EA
2	0304	402781	PLUG-HOLE PG 21 THREADED	1.000	EA

Material	C307	05 0010	Alt.	Usage 3
	Linium 6X1 Rotary Horizontal Wrapper			Valid
				09/26/2007
Reqd qty	1.000 EA	Base quant	1.000 EA	
Sales ord.	129850	Item	000150	

Lv	Item	Component no.	Description	Quant	Un
1	0000	131.063184	KIT REJECT 12 CONDUCTOR CLX		
2	0300	474497	01 MOTOR SERVO AC 26IN/LB 5000RPM 230V	1.000	EA
2	0301	631.024368	SERVO AMPLIFIER 2KW SERCOS	1.000	EA
2	0302	476679	01 MP MOTOR POWER CABLE	1.000	EA
2	0303	476692	01 INTERFACE BREAKOUT	1.000	EA
2	0304	476693	FEEDBACK BREAKOUT	1.000	EA
2	0305	276732	01 SOURCES, INFRARED EMITTER	1.000	EA
2	0306	276733	01 PHOTO EYE, RECEIVER	1.000	EA
2	0307	283039	02 CABLE-QUICK DISCONNECT DC 15' 90 DEG	2.000	EA
2	0308	491622	TERM BLOCK 4 WIRE	2.000	EA
2	0309	491628	GROUND TERM BLOCK 2 WIRE	1.000	EA
2	0310	491623	END PLATE FOR 4 WIRE	1.000	EA
2	0311	491629	END PLATE GROUND TB 2 WIRE	1.000	EA
2	0312	441839	BLOWER SQUIRREL CAGE	1.000	EA
2	0313	398040	PANEL	1.000	EA
2	0314	245023	05 BOX-JUNCTION, 6 X 4 X 3	1.000	EA
2	0315	440591	03 CABLE 12PIN FEMALE	1.000	EA
2	0316	440590	02 RECEPTACLE 12PIN MALE	1.000	EA
2	0317	440561	MULTI HOLE SEAL INSERT	1.000	EA
2	0318	403013	STRAIN RELIEF 9MM TO 16MM STRAIGHT	1.000	EA
2	0319	379507	01 STRAIN-RELIEF NYLON PG13.5 5-9MM	1.000	EA
2	0320	491632	TERMINAL BLOCK RETAINER	1.000	EA
2	0321	292414	FUSE LAMP MDA	1.000	EA
2	0322	292415	FUSE BLOCK-12 AMPS, 300 VOLT	1.000	EA
2	0323	476680	01 MP MOTOR FEEDBACK CABLE	1.000	EA
2	0324	631.024259	1 METER SERCOS CABLE	1.000	EA
2	0325	292416	01 END BARRIER FOR FUSE BLOCK	1.000	EA

Material	C307	05 0010	Alt.	Usage 3
	Linium 6X1 Rotary Horizontal Wrapper			Valid
				09/26/2007
Reqd qty		1.000 EA	Base quant	1.000 EA
Sales ord.	129850		Item	000150

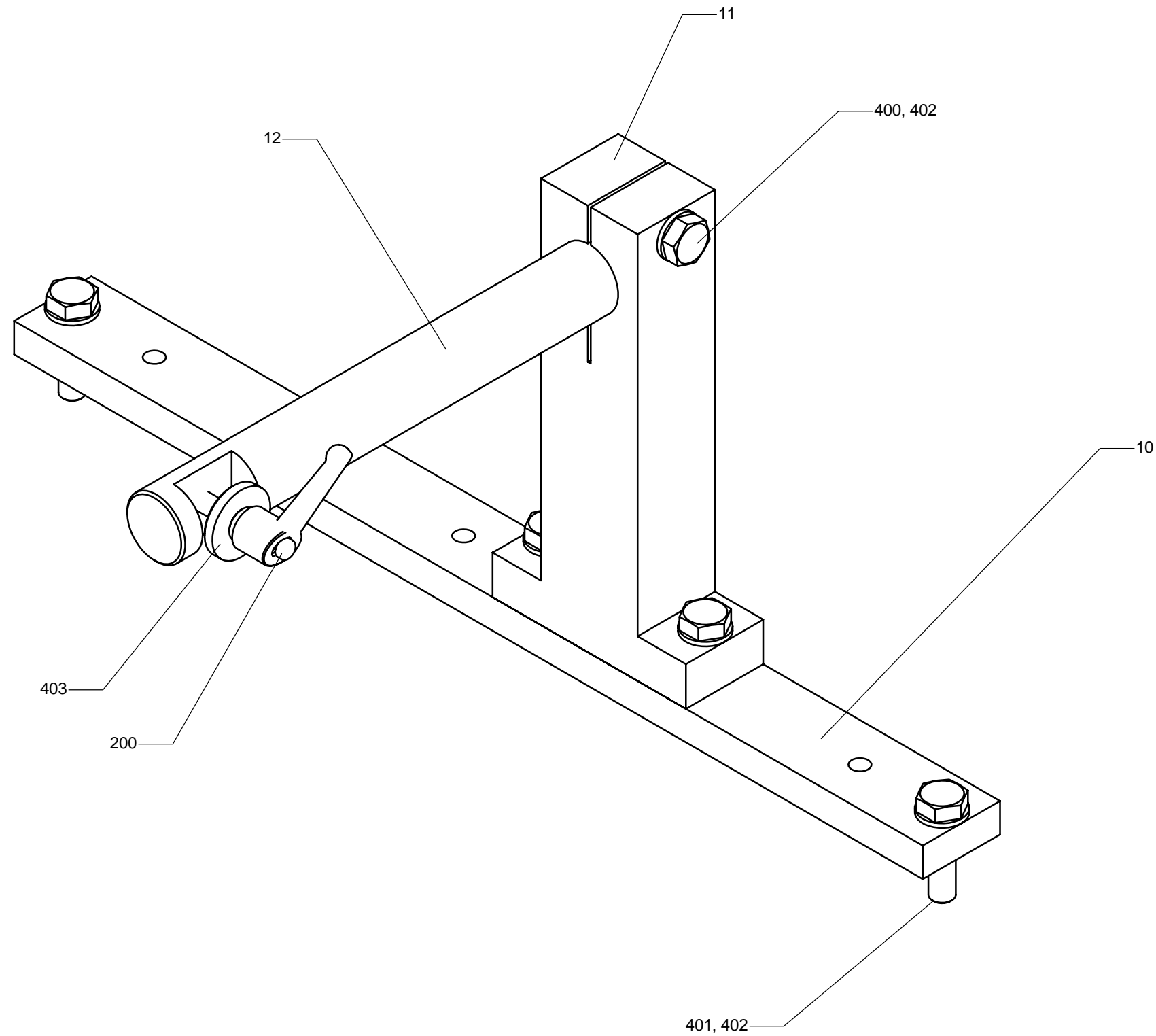
Lv	Item	Component no.	Description	Quant	Un
1	0000	131.002415	KIT-SPLICER EYES		
2	0300	371279	02 EYE, REFLEX FILM SENSING	2.000	EA
2	0301	379515	REFLECTOR	2.000	EA
2	0302	402155	01 CABLE-5 CONDUCTOR 15'	2.000	EA

Material	C307	05	0010	Alt.	Usage 3
	Linium 6X1 Rotary Horizontal Wrapper				Valid
					09/26/2007
Reqd qty		1.000	EA	Base quant	1.000 EA
Sales ord.	129850			Item	000150

Lv	Item	Component no.	Description	Quant	Un
1	0000	131.020020	KIT-ROBOT/INFEED ELECTRICAL		
2	0010	531.023374	ENCLOSURE-ELECTRICAL	1.000	EA
2	0040	019.042635	CONNECTOR BULKHEAD 24 POSITION	1.000	EA
2	0050	019.042920	24 PIN FEMALE INSERT WITH TB'S	1.000	EA
2	0060	440548	SENSOR PROXIMITY N.O. PNP	1.000	EA
2	0070	031.029481	ENCODER 3000 PPR 5IN 5OUT	1.000	EA
2	0080	389306	01 CABLE 25 CONDUCTOR 22 GAUGE(NO SUB)	30.000	FT
2	0090	644-32221	05 CABLE SHIELDED #22 (NO SUBS)	30.000	FT
2	0091	379507	01 STRAIN-RELIEF NYLON PG13.5 5-9MM	1.000	EA
2	0092	373531	RELAY-BASE MINI A-B	1.000	EA
2	0093	373530	RELAY-DPDT 24 VDC MINI A-B	1.000	EA
2	0094	784-80010	03 RECTIFIER	1.000	EA

Material	C307	05 0010	Alt.	Usage 3
	Linium 6X1 Rotary Horizontal Wrapper			Valid
				09/26/2007
Reqd qty		1.000 EA	Base quant	1.000 EA
Sales ord.	129850		Item	000150

Lv	Item	Component no.	Description	Quant	Un
2	0000	131.017543	ASSY-FORMER MOUNT		
3	0001	231.017543	DWG-FORMER MOUNT	1.000	EA
3	0002	331.017543	LAYOUT-ASSY-FORMER MOUNT	1.000	EA
3	0010	531.017450	03 PLATE-FORMER POST MTG	1.000	EA
3	0011	531.017451	BASE-FORMER MTG	1.000	EA
3	0012	531.017539	STEM-FORMER SUPPORT	1.000	EA
3	0200	364197	HANDLE-ADJUSTABLE M8x30 STL	1.000	EA
3	0400	310152	SCREW-HEX HD M10 X 50 SST	1.000	EA
3	0401	310151	SCREW-HEX HD M10 X 40 SST	4.000	EA
3	0402	397080	WASHER-FLAT 10.5 X 20 X 2 SST	5.000	EA
3	0403	406296	WASHER-BACKUP-FORMER MOUNT	1.000	EA



Single former mount		Drawn by: Travis Mikula	Date: 14 Sep 2001
		Approved by: Travis Mikula	Scale: 1:1.25
Assy Former Mount		Checked by: Barb Hemauer	Size: A2
		Sheet: 1/1	M-Type: 307
		231.017543	Rev.: 0
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Qty.	Index	Description	Date	ECN No.	Changed by
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Material	C307	05 0010	Alt.	Usage 3
	Linium 6X1 Rotary Horizontal Wrapper			Valid
				09/26/2007
Reqd qty		1.000 EA	Base quant	1.000 EA
Sales ord.	129850		Item	000150

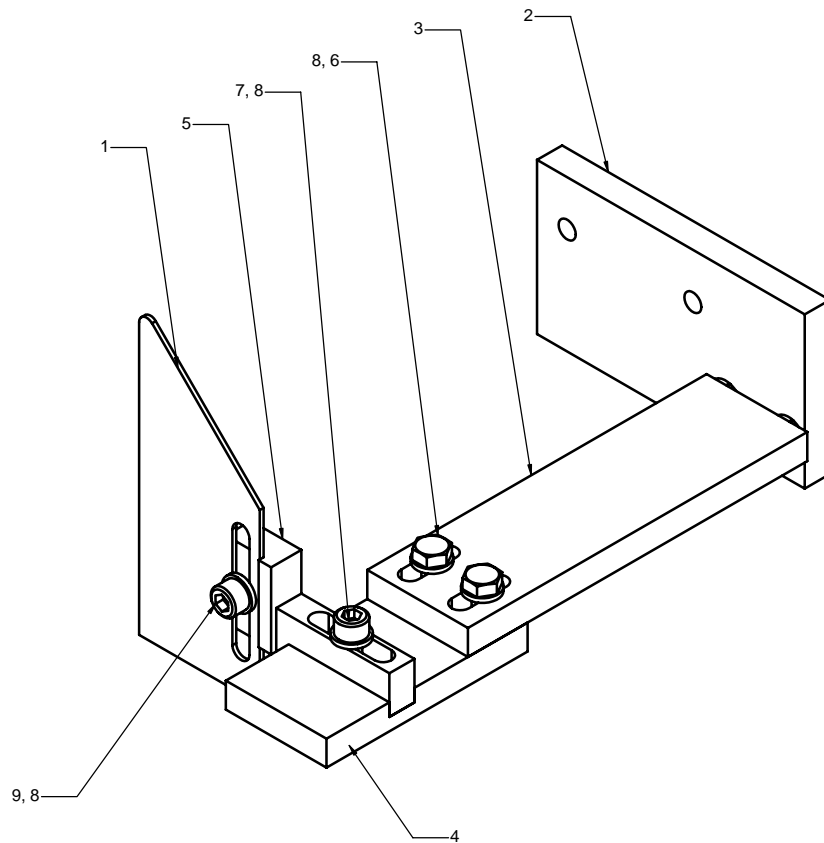
Lv	Item	Component no.	Description	Quant	Un
2	0000	131.045366	ASSY FORMER 40W X 24H X 18DEG		
3	0010	531.002937	04 BRKT L FORMER SUPPORT	1.000	EA
3	0016	531.032258	MOUNT-FORMER-40mm WD	1.000	EA
3	0020	531.000395	01 STOP FORMER SUPPORT	1.000	EA
3	0021	531.000396	01 STOP FORMER SUPPORT	1.000	EA
3	0022	531.045357	WING FORMER 40W X 24H X 18DEG	1.000	EA
3	0023	531.045358	WING FORMER 40W X 24H X 18DEG	1.000	EA
3	0400	433420	SCREW-FLAT SLOT M6 X 25 SST	2.000	EA
3	0401	310106	SCREW-HEX HD M6 X 10 SST	6.000	EA
3	0403	310144	SCREW-HEX HD M8 X 30 SST	4.000	EA
3	0405	379749	WASHER-FLAT 6.4 X 12 X 1.6 SST	6.000	EA
3	0406	309393	01 WASHER-FLAT 8.4 X 16 X 1.6 SST	4.000	EA

Material	C307	05 0010	Alt.	Usage 3
	Linium 6X1 Rotary Horizontal Wrapper			Valid 09/26/2007
Reqd qty	1.000 EA	Base quant	1.000 EA	
Sales ord.	129850	Item	000150	

Lv	Item	Component no.	Description	Quant	Un
2	0000	131.062683	ASSY CHAIN GUIDES RECV LR		
3	0010	531.063076	GUIDE CHAIN RECV CNVR DR LR	1.000	EA
3	0011	531.063077	GUIDE CHAIN RECV CNVR OP LR	1.000	EA
3	0012	531.028345	01 GUIDE PRODUCT RECV CNVR 25mm	2.000	EA
3	0013	531.033703	GUIDE FRONT ADJUSTABLE	1.000	EA
3	0014	531.033704	GUIDE FRONT ADJUSTABLE	1.000	EA
3	0015	531.009488	01 CLAMP FRONT ADJUSTABLE GUIDES	2.000	EA
3	0016	531.004073	02 SPACER PRODUCT GUIDE 25MM H	4.000	EA
3	0200	375068	03 KNOB-M6 x 10 STUD STL	8.000	EA
3	0400	379749	WASHER-FLAT 6.4 X 12 X 1.6 SST	8.000	EA

Material	C307	05 0010	Alt.	Usage 3
	Linium 6X1 Rotary Horizontal Wrapper			Valid 09/26/2007
Reqd qty	1.000 EA	Base quant	1.000 EA	
Sales ord.	129850	Item	000150	

Lv	Item	Component no.	Description	Quant	Un
2	0000	131.028146	KIT-FILM SPLITTER SHORT DROP OFF		
3	0001	531.002624	01 BLADE FILM SPLITTER	1.000	EA
3	0002	531.018758	01 MOUNT AIR EVACUATION, SPLITTER	1.000	EA
3	0003	531.018759	BAR AIR EVACUATION, SPLITTER	1.000	EA
3	0004	531.026845	PLATE SPLITTER HORIZONTAL	1.000	EA
3	0005	531.028145	01 BAR SPLITTER VERTICAL ADJUST	1.000	EA
3	0006	310098	SCREW-HEX HD M6 X 20 SST	2.000	EA
3	0007	310104	SCREW-SOC CAP M6 X 20 SST	1.000	EA
3	0008	379749	WASHER-FLAT 6.4 X 12 X 1.6 SST	4.000	EA
3	0009	397029	SCREW-SOC CAP M6 X 12 SST	1.000	EA



		Drawn by: Bryan Grass	Date: 21 Oct 2002
		Approved by: Bryan Grass	Scale: 1:1
Kit Film Splitter Short DropOff		Checked by: Barb Hemauer	Size: A2
		Sheet: 1/1	M-Type: 307
		231.028146	Rev.: 0
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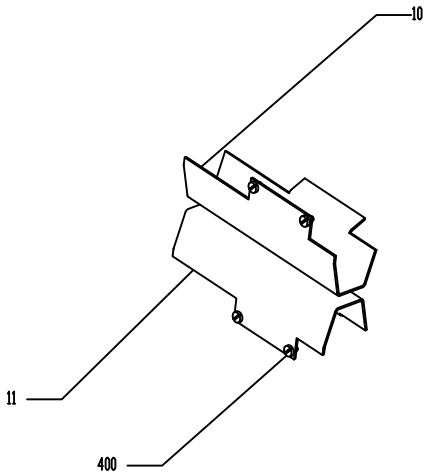
Qty.	Index	Description	Date	ECN No.	Changed by
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Material	C307	05 0010	Alt.	Usage 3
	Linium 6X1 Rotary Horizontal Wrapper			Valid 09/26/2007
Reqd qty	1.000 EA	Base quant	1.000 EA	
Sales ord.	129850	Item	000150	

Lv	Item	Component no.	Description	Quant	Un
2	0000	131.002280	KIT-CRIMPER MTG ADJUSTING SCREW		
3	0010	375065	PIN-ALIGNMENT-CRIMPER	8.000	EA
3	0400	310164	SCREW-SET M6 X 10 SST	28.000	EA
3	0401	310115	SCREW-SOC CAP M8 X 25 SST	8.000	EA
3	0402	309393	01 WASHER-FLAT 8.4 X 16 X 1.6 SST	8.000	EA
3	0403	379463	01 SCREW-PAN HD M3 X 6 BRASS	4.000	EA

Material	C307	05 0010	Alt.	Usage 3
	Linium 6X1 Rotary Horizontal Wrapper			Valid
				09/26/2007
Reqd qty		1.000 EA	Base quant	1.000 EA
Sales ord.	129850		Item	000150

Lv	Item	Component no.	Description	Quant	Un
2	0000	131.025122	KIT-CRIMPER WIRE GUARDS 1-UP/2-UP		
3	0000	120 DIA 180 LG ADJ SCR			
3	0001	231.025122	DWG-KIT CRIMPER WIRE GUARDS		
3	0010	531.018991	GUARD CRIMPER WIRE	2.000	EA
3	0011	531.018992	GUARD CRIMPER WIRE	2.000	EA
3	0400	397043	SCREW-PAN SLOT M4 X 6 SST	8.000	EA



Kit Crimper Wire Guards 1-Up/2-Up	Drawn by	Steve Larson	Date	06 May 2002
	Approved by	Steve Larson	Scale	1:25
	Checked by	Barb Henauer	Size	A3
			#-Type	307
		231.025122	Rev.:	0
BOSCH	Doboy Inc.	© Copyright Doboy Inc.	Based on Sigpack International Design Standards	

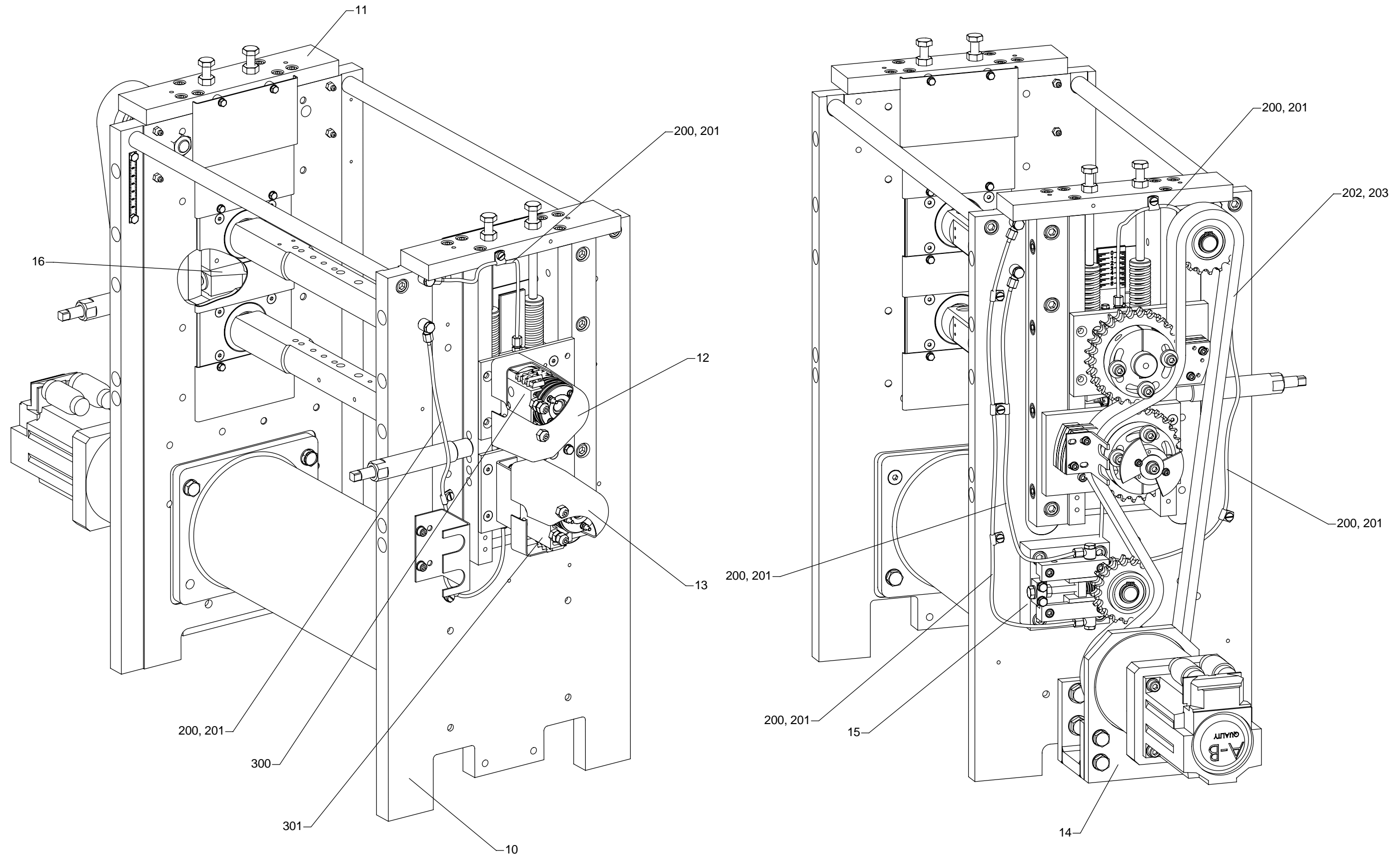
Qty.	Index	Description	Date	EDN No.	Changed by
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Material	C307	05	0010	Alt.	Usage 3
	Linium 6X1 Rotary Horizontal Wrapper				Valid
					09/26/2007
Reqd qty		1.000	EA	Base quant	1.000 EA
Sales ord.	129850			Item	000150

Lv	Item	Component no.	Description	Quant	Un
2	0000	131.021184	ASSY-CUTTING HEAD FRAME 370 CL LR		
3	0011	531.018851	01 BLOCK FRAME FOOT	2.000	EA
3	0012	531.016863	04 LEG CUTTING HEAD	1.000	EA
3	0013	531.016864	08 LEG CUTTING HEAD	1.000	EA
3	0014	531.021176	02 PLATE SIDE LR	1.000	EA
3	0015	531.021174	02 PLATE SIDE LR	1.000	EA
3	0016	531.021175	01 PLATE SIDE REAR LR	1.000	EA
3	0017	531.021177	PLATE SIDE REAR LR	1.000	EA
3	0018	531.015456	03 BLOCK FRAME CUTTING HEAD MOUNT	2.000	EA
3	0019	531.015458	CLAMP PLATE	2.000	EA
3	0020	531.015463	02 PLATE PAD	2.000	EA
3	0021	531.016862	01 BLOCK FRAME CUTTING HD	2.000	EA
3	0022	531.016865	PLATE TOP	1.000	EA
3	0023	531.016867	PLATE END	1.000	EA
3	0024	531.016868	PLATE CUTTING HEAD BOTTOM	1.000	EA
3	0025	531.018148	BLOCK PLATE	3.000	EA
3	0026	531.018155	03 PLATE CUTTING HEAD SUPPORT	1.000	EA
3	0028	531.018157	02 CLAMP CUTTING HEAD FRAME	2.000	EA
3	0029	531.021179	GUSSET FRAME LR	1.000	EA
3	0030	531.021178	PLATE BRACKET TOP DRIVE SIDE LR	1.000	EA
3	0032	131.013680	KIT CUTTING HEAD LIFT	1.000	EA
3	0400	531.002598	03 SCREW-SOC CAP M8 X 30 STL MODIFIED	5.000	EA
3	0401	397030	SCREW-SOC CAP M8 X 30 SST	4.000	EA
3	0402	395341	SCREW-SOC CAP M8 X 16 SST	4.000	EA
3	0403	407559	PF ALLEN CYL M12x80/30	16.000	EA
3	0404	397033	SCREW-SOC CAP M8 X 45 SST	16.000	EA
3	0405	031.004463	SCREW-SOC-HEAD M10 X 35 SST	14.000	EA
3	0406	407556	SCREW-SOC-CAP M12 X 40 SST	4.000	EA
3	0407	397031	SCREW-SOC CAP M8 X 35 SST	6.000	EA
3	0408	422038	WASHER-FLAT THK 13 X 30 X 6 SST	4.000	EA
3	0409	407574	SCREW-HEX-HD M12 X 45 SST	4.000	EA
3	0410	401444	SCREW-BUTTON-HD M6 X 12 SST	6.000	EA
3	0411	031.023477	SCREW-FLAT-SOC M10 x 50 SST	4.000	EA
3	0412	397080	WASHER-FLAT 10.5 X 20 X 2 SST	6.000	EA
3	0413	310148	SCREW-HEX HD M10 X 30 SST	6.000	EA
3	0414	309393	01 WASHER-FLAT 8.4 X 16 X 1.6 SST	8.000	EA
3	0415	310114	SCREW-HEX HD M8 X 16 SST	2.000	EA
3	0416	310150	SCREW-SOC CAP M10 X 20 SST	3.000	EA
3	0417	310144	SCREW-HEX HD M8 X 30 SST	6.000	EA
3	0418	031.006382	SCREW-SOC CAP M10 X 50 SST	2.000	EA

Material	C307	05 0010	Alt.	Usage 3
	Linium 6X1 Rotary Horizontal Wrapper			Valid
				09/26/2007
Reqd qty		1.000 EA	Base quant	1.000 EA
Sales ord.	129850		Item	000150

Lv	Item	Component no.	Description	Quant	Un
2	0000	131.016871	ASSY-CUTTING HEAD-600		
3	0001	231.016871			
3	0010	131.026870	02 KIT CUTTING FRAME	1.000	EA
3	0011	131.028677	KIT SHAFT TENSION CUTTING HEAD	1.000	EA
3	0012	131.026871	KIT CUTTING UPPER SHAFT	1.000	EA
3	0013	131.026872	KIT CUTTING LOWER SHAFT	1.000	EA
3	0014	131.026868	ASSY CUTTING HEAD MOTOR	1.000	EA
3	0015	131.026869	02 KIT CUTTING HEAD CHAIN TIGHTENER	1.000	EA
3	0016	131.018741	Kit Wedge 120 Dia.		
3	0016	131.018742	Kit Wedge 150 Dia.		
3	0016	131.018743	Kit Wedge 180 Dia.		
3	0016	131.018744	Kit Wedge 210 Dia.		
3	0200	031.018490	PA TUBE (NYLON) 4 X 1 MM	5.000	M
3	0201	031.018491	INSERT NYLON TUBE	12.000	EA
3	0202	031.013602	CHAIN ROLLER LAMBDA DOUBLE .50PITCH	56.500	IN
3	0203	031.013603	CHAIN CONN LINK	1.000	EA
3	0300	396187	01 KIT BRUSH HOLDER 4 RING METRIC CW	1.000	EA
3	0301	391710	03 KIT BRUSH HOLDER 4 RING METRIC	1.000	EA



Qty.	Index	Description	Date	ECN No.	Changed by
1	6	Added washers behind chain guides, changed large assembly to subassemblies	29 Jan 03	168863	JDM
0	5	Changed wedge from screw to washer and nut	31 Oct 02	168383	JDM
0	4	Replaced grease zerks inch to metric, added 1.0 inch to chain, added and changed hardware quantity	31 Oct 02	168146	DWL
0	3	No changes made to bill and drawing	30 Oct 02	162863	DM
0	2	No changes made to bill and drawing	30 Oct 02	160053	DM
0	1	No changes made to bill and drawing	30 Oct 02	160044	DM



Assembly
Cutting Head RL

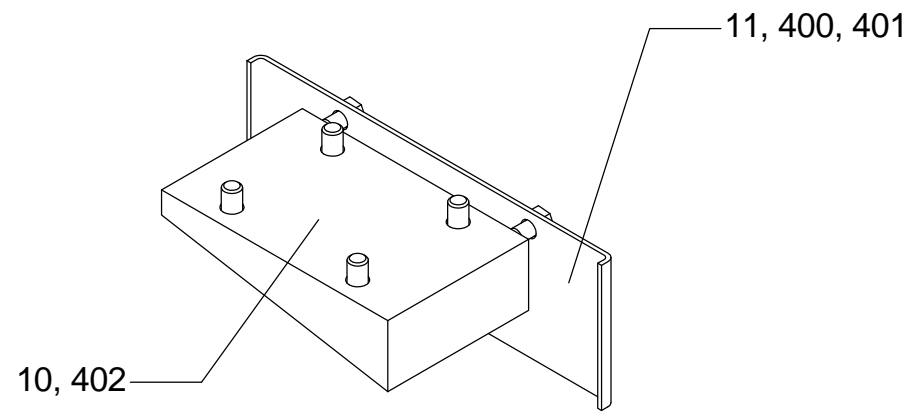
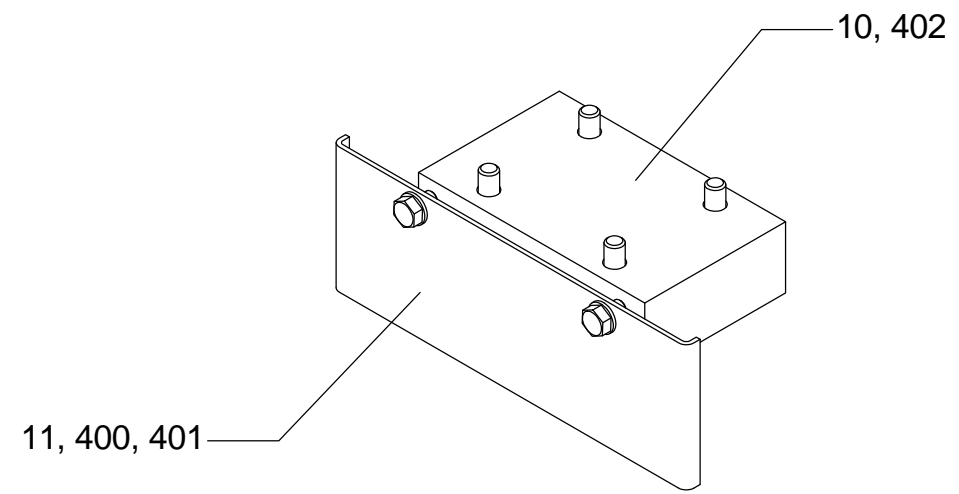
BOSCH

Doboy Inc.

Drawn by:	Mike Felling	Date:	26 Apr 2001
Approved by:	Mike Felling	Scale:	1:3
Checked by:		Size:	A2
	Sheet: 1/1	M-Type:	307
231.016871		Rev.: 6	
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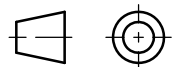
Material	C307	05 0010	Alt.	Usage 3
	Linium 6X1 Rotary Horizontal Wrapper			Valid 09/26/2007
Reqd qty	1.000 EA	Base quant	1.000 EA	
Sales ord.	129850	Item	000150	

Lv	Item	Component no.	Description	Quant	Un
2	0000	131.018741	KIT-WEDGE 120 DIA		
3	0001	231.018741	DWG-WEDGE-120 DIA	1.000	EA
3	0010	531.016882	WEDGE STATIONARY 120MM	2.000	EA
3	0011	531.018244	PLATE COVER CUTTING HEAD	2.000	EA
3	0400	397007	SCREW-HEX HD M5 X 8 SST	4.000	EA
3	0401	401228	WASHER-FLAT 5.3 X 10 X 1 SST	4.000	EA
3	0402	397029	SCREW-SOC CAP M6 X 12 SST	8.000	EA



		Drawn by: Roger Hefty	Date: 06 Jun 2002
		Approved by: Roger Hefty	Scale: 1:2
Kit Wedge-120 Dia		Checked by:	Size: A3
		Sheet: 1/1	M-Type: 307
		231.018741	Rev.: 0
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Qty.	Index	Description	Date	ECN No.	Changed by
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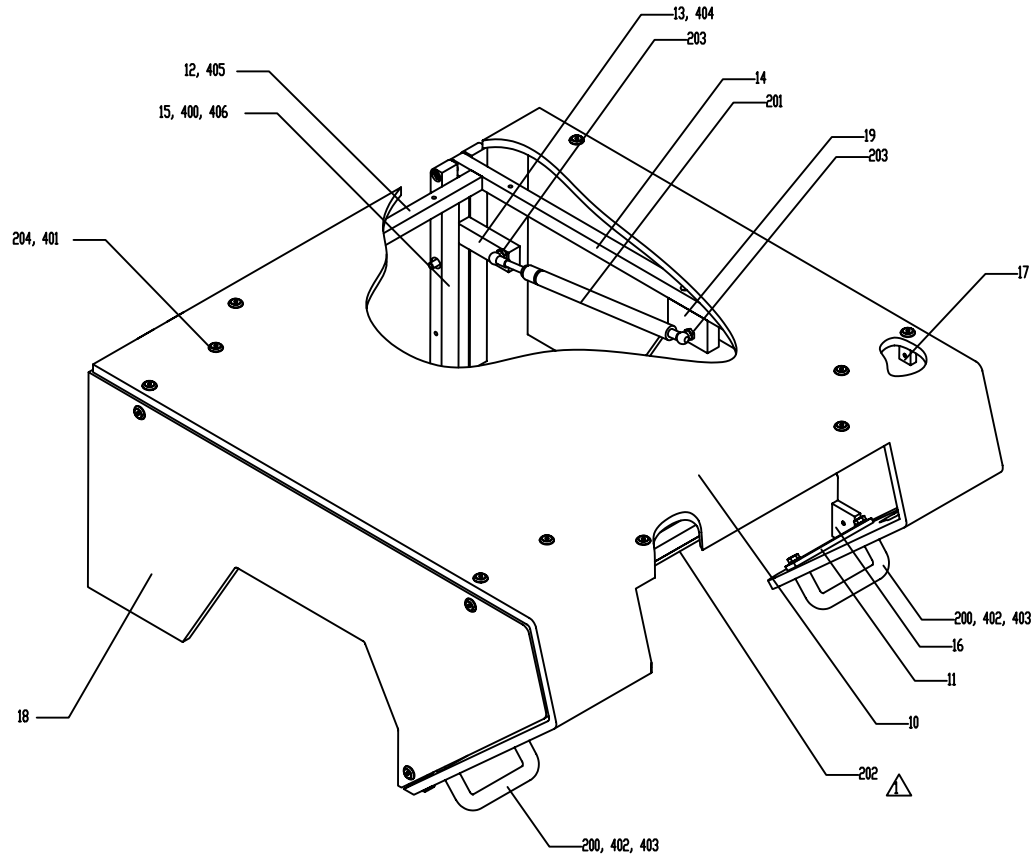


Material	C307	05 0010	Alt.	Usage 3
	Linium 6X1 Rotary Horizontal Wrapper			Valid
				09/26/2007
Reqd qty		1.000 EA	Base quant	1.000 EA
Sales ord.	129850		Item	000150

Lv	Item	Component no.	Description	Quant	Un
2	0000	131.015990	KIT - CUTT.HD ELEC. 600		
3	0300	181015	07 BLOCK-TERMINAL 4-PLACE	2.000	EA
3	0301	253787	05 COVER-TERMINAL 4-PLACE	2.000	EA
3	0302	318912	SCREW-PAN HEAD M4 X 25 SST	4.000	EA
3	0303	318913	SCREW-PAN HEAD M4 X 16 SST	4.000	EA
3	0304	300897	03 CONNECTOR MALE 5 PIN	1.000	EA
3	0305	440552	02 RECEPTACLE FEMALE 5PIN	1.000	EA
3	0306	031.018109	MOTOR SERVO SC 42IN/LB 5000RPM	1.000	EA
3	0307	261682	05 THERMOCOUPLE 24"	2.000	EA
3	0308	440548	SENSOR PROXIMITY N.O. PNP	1.000	EA

Material	C307	05	0010	Alt.	Usage 3
	Linium 6X1 Rotary Horizontal Wrapper				Valid
					09/26/2007
Reqd qty		1.000	EA	Base quant	1.000 EA
Sales ord.	129850			Item	000150

Lv	Item	Component no.	Description	Quant	Un
2	0000	131.018850	ASSY-GUARD DOOR		
3	0010	531.015837	03 GUARD DOOR	1.000	EA
3	0011	531.003579	01 PLATE SUPPORT HANDLE	2.000	EA
3	0012	531.015841	BRACE DOOR SIDE	2.000	EA
3	0013	531.018166	BLOCK DOOR	2.000	EA
3	0014	531.018167	02 BLOCK PIVOT	2.000	EA
3	0015	531.018174	02 BLOCK DOOR PIVOT	2.000	EA
3	0016	531.019794	BLOCK GUARD LOWER	2.000	EA
3	0017	531.019793	BLOCK GUARD	4.000	EA
3	0018	531.019487	PLATE END	2.000	EA
3	0019	531.018173	BLOCK ARM DOOR	2.000	EA
3	0200	031.003578	01 PULL-HANDLE	2.000	EA
3	0201	992-30030	SPRING GAS 90	2.000	EA
3	0202	031.000321	GASKET-DOOR	2.000	FT
3	0203	370694	STUD-BALL METRIC STL	4.000	EA
3	0204	031.021194	WASHER FINISHING 6.4 X 18 X 3.3 STL	20.000	EA
3	0400	031.021191	BEARING - SLEEVE FLANGED	4.000	EA
3	0401	310099	SCREW-FLAT SOC M6 X 25 SST	20.000	EA
3	0402	309393	01 WASHER-FLAT 8.4 X 16 X 1.6 SST	4.000	EA
3	0403	430377	SCREW-HEX HD M8 X 35 SST	4.000	EA
3	0404	310115	SCREW-SOC CAP M8 X 25 SST	2.000	EA
3	0405	310108	SCREW-SOC CAP M6 X 25 SST	4.000	EA
3	0406	407586	SCREW-SOC CAP M8 X 70 SST	6.000	EA



1	1	Add 03L000321 (450mm), Remove 03L019177 (2)	15 Oct 02	168324	RLH
Index		Description	Date	EDM No.	Changed by

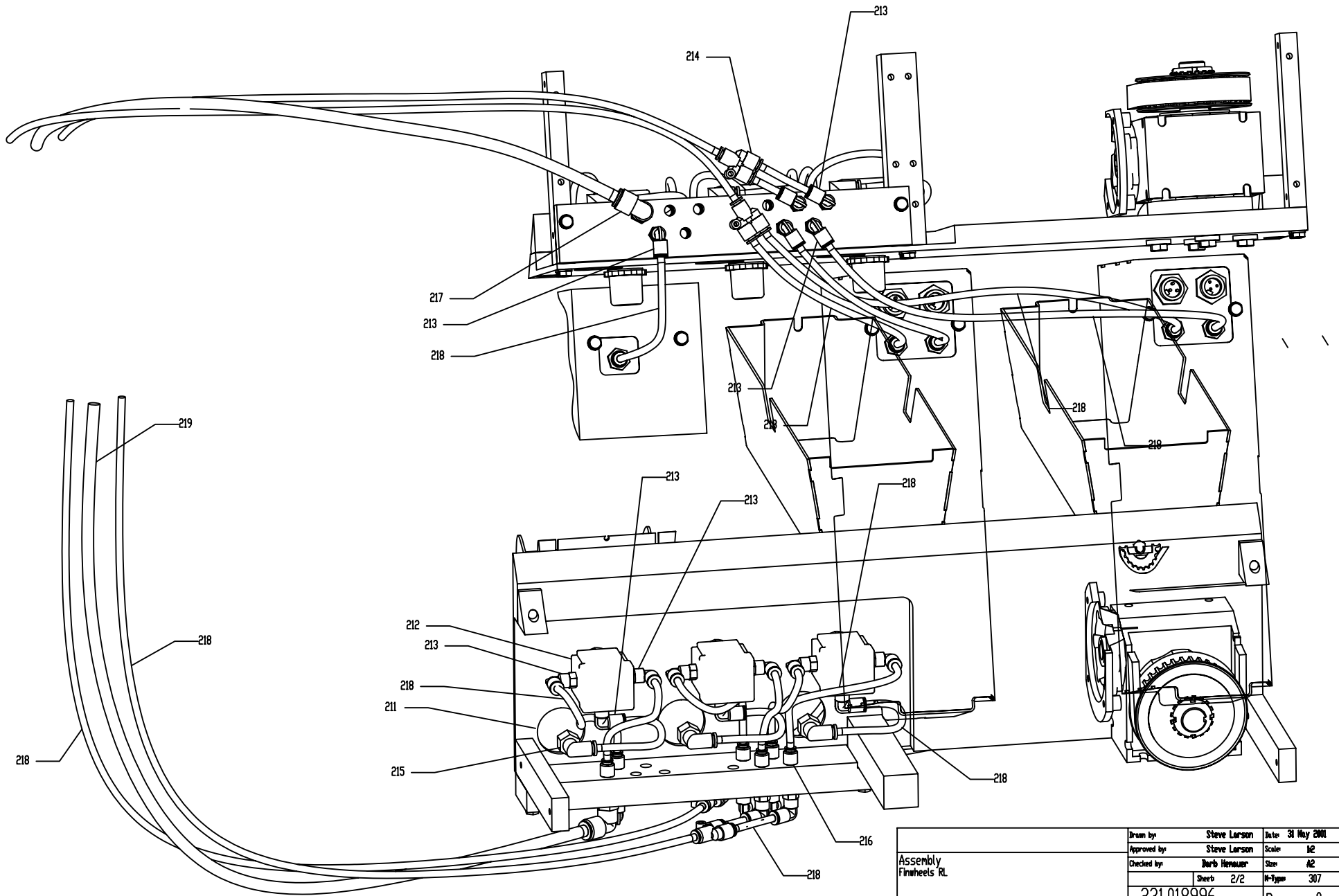
		Drawn by	Mike Felling	Date	15 Feb 2001
		Approved by	Mike Felling	Scale	1:1
		Checked by	Barb Henauer	Size	A2
				W-Type	307
		231.018850		Rev:	1
Doboy Inc.		© Copyright Doboy Inc.	Based on Sigmat International Design Standards		

Material	C307	05 0010	Alt.	Usage 3
	Linium 6X1 Rotary Horizontal Wrapper			Valid
				09/26/2007
Reqd qty	1.000	EA	Base quant	1.000 EA
Sales ord.	129850		Item	000150


Lv	Item	Component no.	Description	Quant	Un
2	0000	131.026620	ASSY-FINWHEELS LR		
3	0003	431.016492	-SCHEMATIC-600 LINIUM PNEUM		
3	0010	131.008930	05 ASSY FINWHEEL CAST HOT	2.000	EA
3	0011	131.008931	05 ASSY FINWHEEL CAST COLD	1.000	EA
3	0012	531.023105	01 PLATE-FINWHEEL MOUNTING LR	1.000	EA
3	0013	531.018950	02 PLATE, SUPPORT FINWHEEL	2.000	EA
3	0014	531.016499	PLATE AUX FINWHEEL MTG	1.000	EA
3	0015	531.018728	BAR, DECKPLATE FRAME	1.000	EA
3	0016	531.018935	PLATE, HORIZONTAL ADJUST	1.000	EA
3	0017	531.018936	SHAFT-AUXILLARY FINWHEEL SUPPORT	2.000	EA
3	0018	531.018933	BLOCK, AUX FINWHEEL-FIXED	1.000	EA
3	0019	531.018932	BLOCK, AUX FIN PIVOT	1.000	EA
3	0020	531.018934	01 SHAFT, AUXILLIARY FINWHEEL	2.000	EA
3	0021	531.018955	SPACER, SHAFT	2.000	EA
3	0022	531.000155	02 FINWHEEL-AUXILLARY FEMALE	1.000	EA
3	0023	531.000156	02 FINWHEEL-AUXILLARY MALE	1.000	EA
3	0024	531.014960	GEAR MOD 3 20T NYLON 6	2.000	EA
3	0025	531.016494	GEAR, IDLER MOD3 22T	1.000	EA
3	0027	531.016495	PLATE, IDLER GEAR	1.000	EA
3	0028	531.016496	SHAFT IDLER GEAR	1.000	EA
3	0029	531.016497	PLATE, IDLER GEAR	1.000	EA
3	0030	531.016498	SPACER, SHAFT BEARING	2.000	EA
3	0031	531.018938	PULLEY, TIMING HTD 5M24X15	1.000	EA
3	0032	531.018984	WASHER PULLEY	1.000	EA
3	0033	531.018941	PULLEY HTD 5M20X15	1.000	EA
3	0034	531.023128	BLOCK-AUXILLARY DRIVE LR	1.000	EA
3	0035	531.018948	STUD, IDLER MOUNTING	1.000	EA
3	0036	531.018949	SHAFT IDLER AUX	1.000	EA
3	0037	531.018951	PULLEY, TIMING HTD 8M22X20	1.000	EA
3	0038	531.001254	02 SPACER RIDER BAR	3.000	EA
3	0039	531.018943	SPACER - GEARBOX MTG	1.000	EA
3	0040	531.018942	REWORK-GEAR REDUCER NMRV 040 5:1 RAT	1.000	EA
3	0041	531.018946	SHAFT, GEARBOX	1.000	EA
3	0042	531.018945	PULLEY, TIMING HTD 8M36X20	1.000	EA
3	0043	531.018944	SHAFT, IDLER MOUNTING	2.000	EA
3	0044	531.018726	01 BAR, FINWHEEL ADJUST	1.000	EA
3	0045	531.012738	SPACER	3.000	EA
3	0046	531.018985	01 GEAR MODULE 3 20T NYLON 6	1.000	EA
3	0047	531.018986	01 KEY GEAR	1.000	EA
3	0048	531.018983	SHAFT COUPLING GEAR BOX	1.000	EA
3	0049	531.018989	REWORK GEAR BOX RIGHT ANGLE 1:1	1.000	EA
3	0050	531.018993	SPACER BAR FINWHEEL ADJUST	2.000	EA
3	0051	531.018964	BAR GUARD MOUNT	1.000	EA
3	0052	531.018965	BAR GUARD MOUNT	1.000	EA
3	0053	531.018969	BAR GUARD MOUNT	1.000	EA
3	0054	531.018971	01 PLATE PNEUMATICS	1.000	EA
3	0055	531.023106	PLATE-AUXILIARY FINWHEEL ATTACHMENT	1.000	EA
3	0056	424974	SCREW ADJ M8	1.000	EA

3 0057 531.018978	01	COVER-GEARS LR	1.000	EA
3 0201 521-56002	02	BEARING-RADIAL BALL 15X32X9	8.000	EA
3 0202 031.000210		BEARING-RADIAL BALL 25x52x15	8.000	EA
3 0203 031.005245		BRG FLANGED SLEEVE 10MMx12MMx9M	2.000	EA
3 0204 531.021139		LOCK NUT M22x1	1.000	EA
3 0205 031.015543		LOCKWASHER MB044-22MM BORE	1.000	EA
3 0207 031.018952		BELT TIMING HTD 580-5M-15	1.000	EA
3 0208 031.018953		BELT TIMING HTD 2000-8M-20	1.000	EA
3 0209 184025		SPRING COMP .30 .045 .875	2.000	EA
3 0210 031.011300		BEARING-RADIAL BALL 20x32x7	1.000	EA
3 0211 031.000184		GAUGE-PRESSURE 0-10 BAR	3.000	EA
3 0212 031.009910	02	REGULATOR-PNEUMATIC 0.7BAR G1/8 PORT	3.000	EA
3 0213 432287		CONNECTOR-ELBOW MALE R1/8 TO 6mm TUB	14.000	EA
3 0214 393482	01	UNION-Y 6mm OD TUBE	2.000	EA
3 0215 432288		CONNECTOR-ELBOW FEM. R1/4 TO 6mm TUB	3.000	EA
3 0216 433094		CONNECTOR-STRAIGHT R1/8 TO 6mm TUBE	6.000	EA
3 0217 370705	01	MALE-ELBOW 10MM TO 1/8 G	1.000	EA
3 0218 370719		PA TUBE (NYLON) PNEUMATIC 6mm OD	6.000	M
3 0219 370720		PA TUBE (NYLON) PNEUMATIC 10mm OD	2.000	M
3 0400 407802		WASHER-FLAT THK 8.4 X 21 X 4 SST	5.000	EA
3 0401 422036		WASHER-FLAT THK 6.4 X 17 X 3 SST	2.000	EA
3 0402 407778		PIN-DOWEL 8 X 30 SST	2.000	EA
3 0403 422062		PIN-DOWEL 8 X 16 STL	2.000	EA
3 0404 031.018954		PIN-DOWEL 10 X 50 STL	1.000	EA
3 0405 382897	01	NUT-HEX JAM M8 SST	4.000	EA
3 0406 397009		SCREW-HEX HD M8 X 40 SST	4.000	EA
3 0407 031.018725		SCREW-SET M6 X 1.0 X 25 SST	6.000	EA
3 0408 310154		SCREW-SOC-CAP M10 X 25 SST	4.000	EA
3 0409 379441		SCREW-SOC CAP M8 X 20 SST	4.000	EA
3 0410 310144		SCREW-HEX HD M8 X 30 SST	2.000	EA
3 0411 309393	01	WASHER-FLAT 8.4 X 16 X 1.6 SST	8.000	EA
3 0412 310146		SCREW-FLAT SOC M8 X 16 SST	2.000	EA
3 0413 310110		SCREW-HEX HD M8 X 25 SST	1.000	EA
3 0414 397368		RING RTNG EXT 15MM SST	10.000	EA
3 0415 397054		SCREW-SET M5 X 5 SST	2.000	EA
3 0416 031.000188		KEY-5 X 5 X 18 SST	3.000	EA
3 0417 031.000310		SCREW-SLOTTED-PAN M5 X 25 SST	2.000	EA
3 0418 401228		WASHER-FLAT 5.3 X 10 X 1 SST	2.000	EA
3 0419 401059		NUT-HEX NYLOCK M5 SST	2.000	EA
3 0420 310106		SCREW-HEX HD M6 X 10 SST	4.000	EA
3 0421 310105		SCREW-SOC CAP M6 X 10 SST	1.000	EA
3 0422 397047		SCREW-PAN SLOT M5 X 6 SST	2.000	EA
3 0426 432072		SCREW-HEX HD M8 X 20 SST	1.000	EA
3 0427 407600		RING-RTNG EXT 25DIA 1.2THK SST	2.000	EA
3 0428 397390	01	KEY-6 X 6 X 36 SST	1.000	EA
3 0429 397382		KEY-5 X 5 X 22 SST	1.000	EA
3 0430 409969		SCREW-HEX HD M6 X 14 SST	1.000	EA
3 0431 397029		SCREW-SOC CAP M6 X 12 SST	4.000	EA
3 0432 430377		SCREW-HEX HD M8 X 35 SST	4.000	EA
3 0434 397387		KEY-6 X 6 X 70 SST	1.000	EA
3 0435 397384		KEY-6 X 6 X 25 SST	1.000	EA
3 0436 310107		SCREW-SOC CAP M6 X 16 SST	4.000	EA
3 0437 310114		SCREW-HEX HD M8 X 16 SST	4.000	EA
3 0438 397015		SCREW-HEX HD M6 X 35 SST	2.000	EA
3 0439 379749		WASHER-FLAT 6.4 X 12 X 1.6 SST	12.000	EA
3 0440 310099		SCREW-FLAT SOC M6 X 25 SST	2.000	EA
3 0441 309391		SCREW-HEX HD M6 X 16 SST	4.000	EA

3 0442 397080	WASHER-FLAT 10.5 X 20 X 2 SST	6.000	EA
3 0443 432071	SCREW-HEX HD M10 X 35 SST	6.000	EA
3 0444 310102	SCREW-HEX HD M6 X 12 SST	6.000	EA
3 0445 310103	SCREW-HEX HD M6 X 30 SST	4.000	EA
3 0446 395577	SCREW-FLAT SOC M8 X 20 SST	2.000	EA
3 0447 401236	WASHER-FLAT LARGE 6.4 X18 X 1.6 SST	1.000	EA



Qty.	Index	Description	Date	EDN No.	Changed by
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Assembly Finwheels RL	Drawn by	Steve Larson	Date	31 May 2001
	Approved by	Steve Larson	Scale	A2
	Checked by	Barb Henauer	Size	A2
		Sheet	2/2	W-Type
	231.018996		Rev.:	0
BOSCH	Doboy Inc.	© Copyright Doboy Inc.	Based on Sipac International Design Standards	

Material	C307	05 0010	Alt.	Usage 3
	Linium 6X1 Rotary Horizontal Wrapper			Valid
				09/26/2007
Reqd qty		1.000 EA	Base quant	1.000 EA
Sales ord.	129850		Item	000150

Lv	Item	Component no.	Description	Quant	Un
2	0000	131.015993	KIT-FINWHEEL ELECT.		
3	0300	631.024245	01 RECEPTACLE 3 PIN MALE	1.000	EA
3	0301	300896	03 CONNECTOR FEMALE 3 PIN	1.000	EA
3	0302	082-35038	14 THERMOCOUPLE	1.000	EA
3	0303	491620	TERM BLOCK 2 WIRE	10.000	EA
3	0304	491621	END PLATE FOR 2 WIRE	1.000	EA
3	0305	524495	04 LOCKNUT 0.50 STEEL CONDUIT	2.000	EA
3	0306	491628	GROUND TERM BLOCK 2 WIRE	1.000	EA
3	0307	491629	END PLATE GROUND TB 2 WIRE	1.000	EA
3	0308	474497	01 MOTOR SERVO AC 26IN/LB 5000RPM 230V	1.000	EA

Material	C307	05 0010	Alt.	Usage 3
	Linium 6X1 Rotary Horizontal Wrapper			Valid 09/26/2007
Reqd qty	1.000 EA	Base quant	1.000 EA	
Sales ord.	129850	Item	000150	

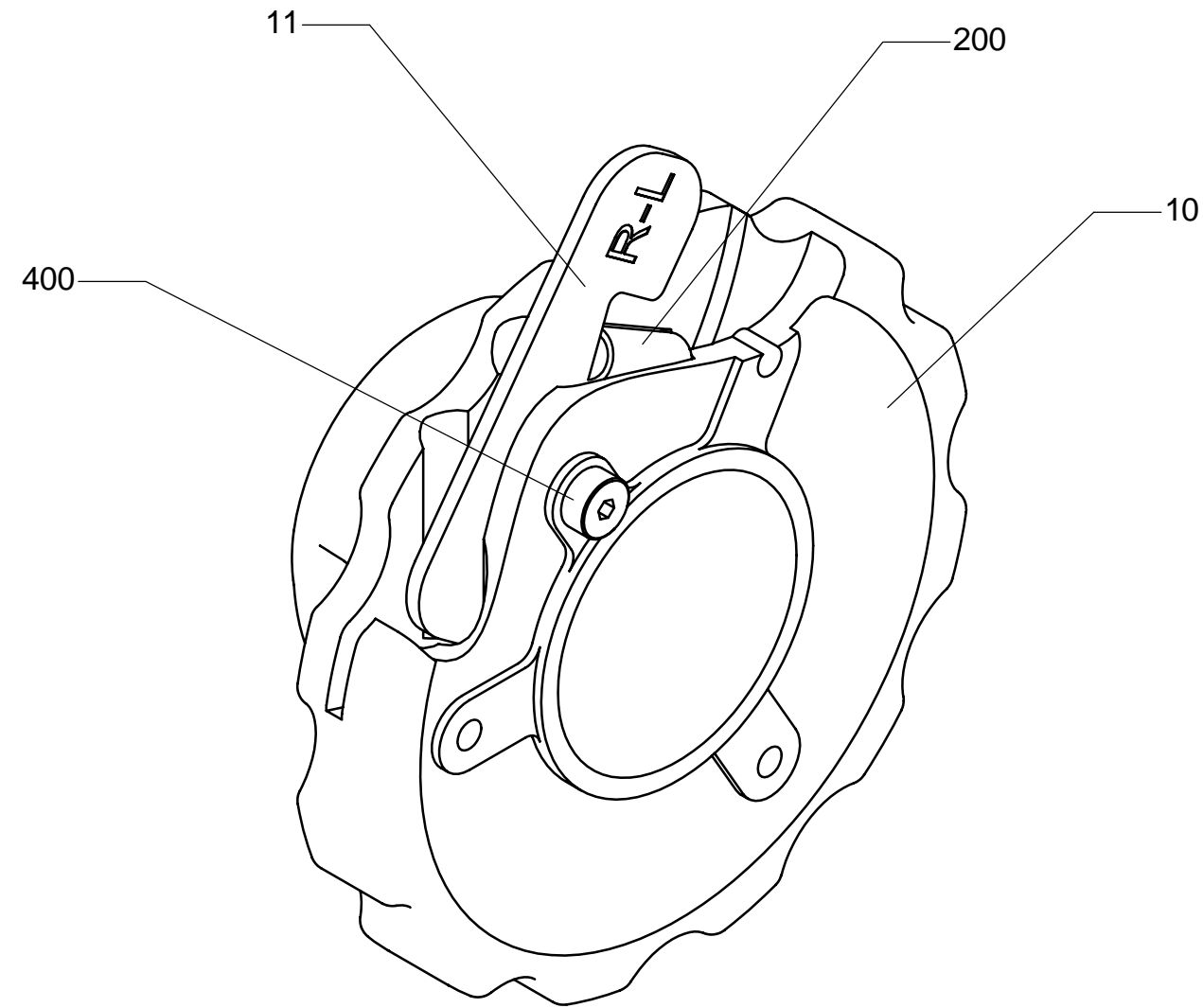
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2	0000	131.024255	KIT-2ND HEATED FIN ELECT		
3	0300	631.024245	01 RECEPTACLE 3 PIN MALE	1.000	EA
3	0301	300896	03 CONNECTOR FEMALE 3 PIN	1.000	EA
3	0302	082-35038	14 THERMOCOUPLE	1.000	EA
3	0303	491620	TERM BLOCK 2 WIRE	10.000	EA
3	0304	491621	END PLATE FOR 2 WIRE	1.000	EA
3	0305	524495	04 LOCKNUT 0.50 STEEL CONDUIT	2.000	EA
3	0306	491628	GROUND TERM BLOCK 2 WIRE	1.000	EA
3	0307	491629	END PLATE GROUND TB 2 WIRE	1.000	EA

Material	C307	05 0010	Alt.	Usage 3
	Linium 6X1 Rotary Horizontal Wrapper			Valid
				09/26/2007
Reqd qty	1.000	EA	Base quant	1.000 EA
Sales ord.	129850		Item	000150

Lv	Item	Component no.	Description	Quant	Un
2	0000	131.007080	WELDMENT-BACKSTAND FRAME EXTENDED SST		
3	0000	131.007009 :	WELDMENT FRAME BKSTD		
3	0001	231.007080	03 DWG WELDMENT FRAME BKSTD EXT	1.000	EA
3	0002	331.007080	02 LAYOUT WELDMENT FRAME BKSTD EXT	1.000	EA
3	0010	531.007083	05 SIDE PLATE VERTICAL	1.000	EA
3	0011	531.006887	03 PLATE HORIZONTAL LOWER	1.000	EA
3	0012	531.006888	04 TOP PLATE HORIZONTAL	1.000	EA
3	0013	531.007082	05 SIDE PLATE VERTICAL	1.000	EA
3	0014	531.006890	04 BASE PLATE BACKSTAND	1.000	EA
3	0015	531.006891	04 MOUNT PLATE BEARING	2.000	EA
3	0016	531.006885	01 FILLER REAR UPPER	3.000	EA
3	0017	531.007006	06 FRONT PLATE HORIZONTAL	1.000	EA
3	0018	531.007081	04 FRONT PLATE VERTICAL	1.000	EA
3	0019	531.006883	03 PLATE END	2.000	EA

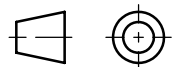
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	Linium 6X1 Rotary Horizontal Wrapper			Valid 09/26/2007
Reqd qty	1.000 EA	Base quant	1.000 EA	
Sales ord.	129850	Item	000150	

Lv	Item	Component no.	Description	Quant	Un
2	0000	131.007015	ASSY BKSTD FILM ROLL CHUCK		
3	0001	231.000147	DWG AY BKSTD FILM ROLL CHUCK	4.000	EA
3	0010	531.007017	01 CHUCK FILM ROLL	4.000	EA
3	0011	531.000149	03 LEVER CHUCK FILM ROLL	4.000	EA
3	0200	204016	02 SPRING COMP .360 .040 1.120	4.000	EA
3	0400	397050	SCREW-SHOULDER 6/M5 X 10 SST	4.000	EA



		Drawn by: Steve Larson	Date: 07 May 2001
		Approved by: Steve Larson	Scale: 1:1
Assembly Backstand Film Roll Chuck		Checked by: Barb Hemauer	Size: A3
		Sheet: 1/1	M-Type: 225
		231.000147	Rev.: 0
BOSCH	Doboy Inc.	© Copyright Doboy Inc.	Based on SIG Pack International Design Standards

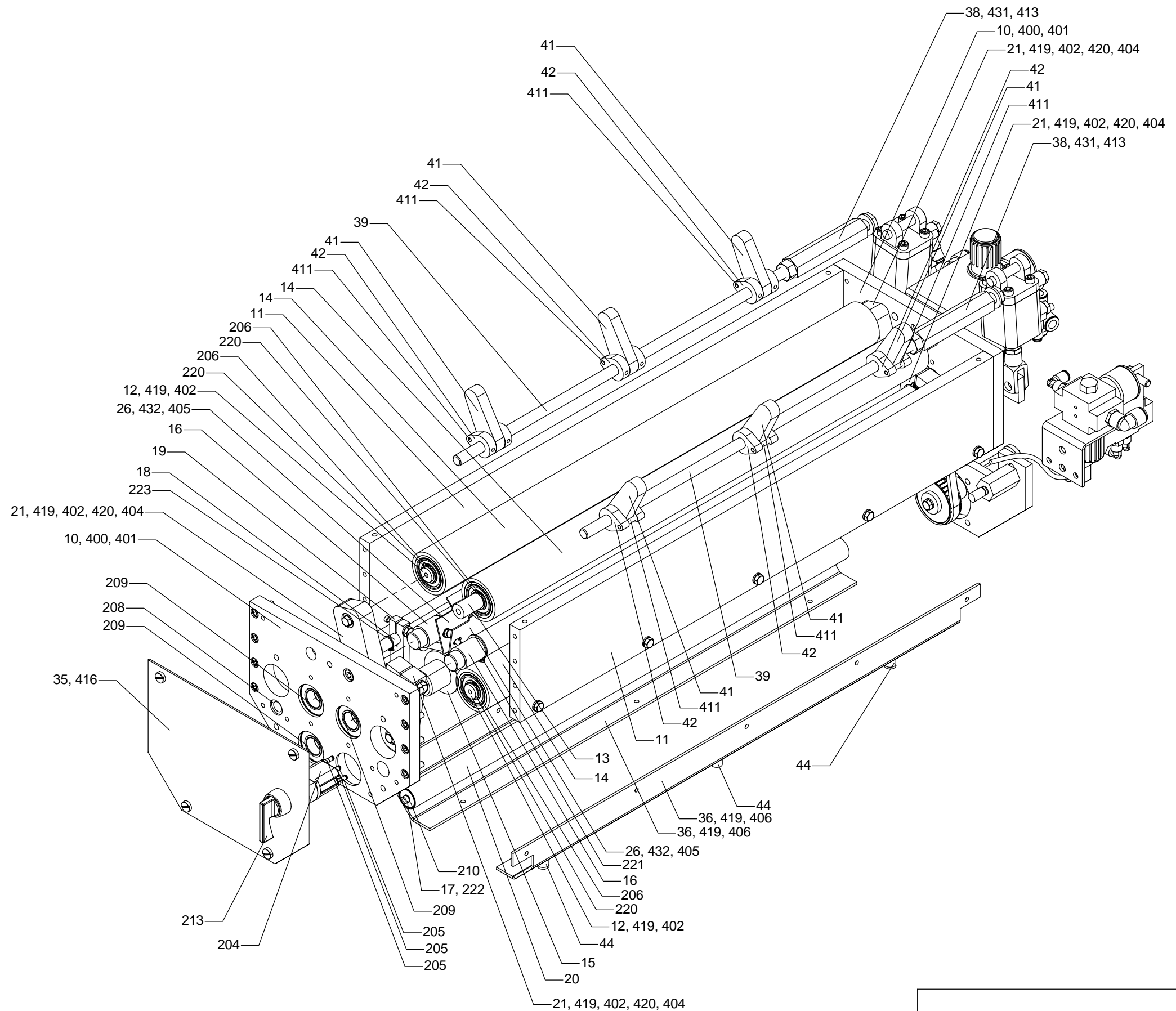
Qty.	Index	Description	Date	ECN No.	Changed by
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Material	C307	05 0010	Alt.	Usage 3
	Linium 6X1 Rotary Horizontal Wrapper			Valid
				09/26/2007
Reqd qty	1.000 EA	Base quant	1.000 EA	
Sales ord.	129850	Item	000150	

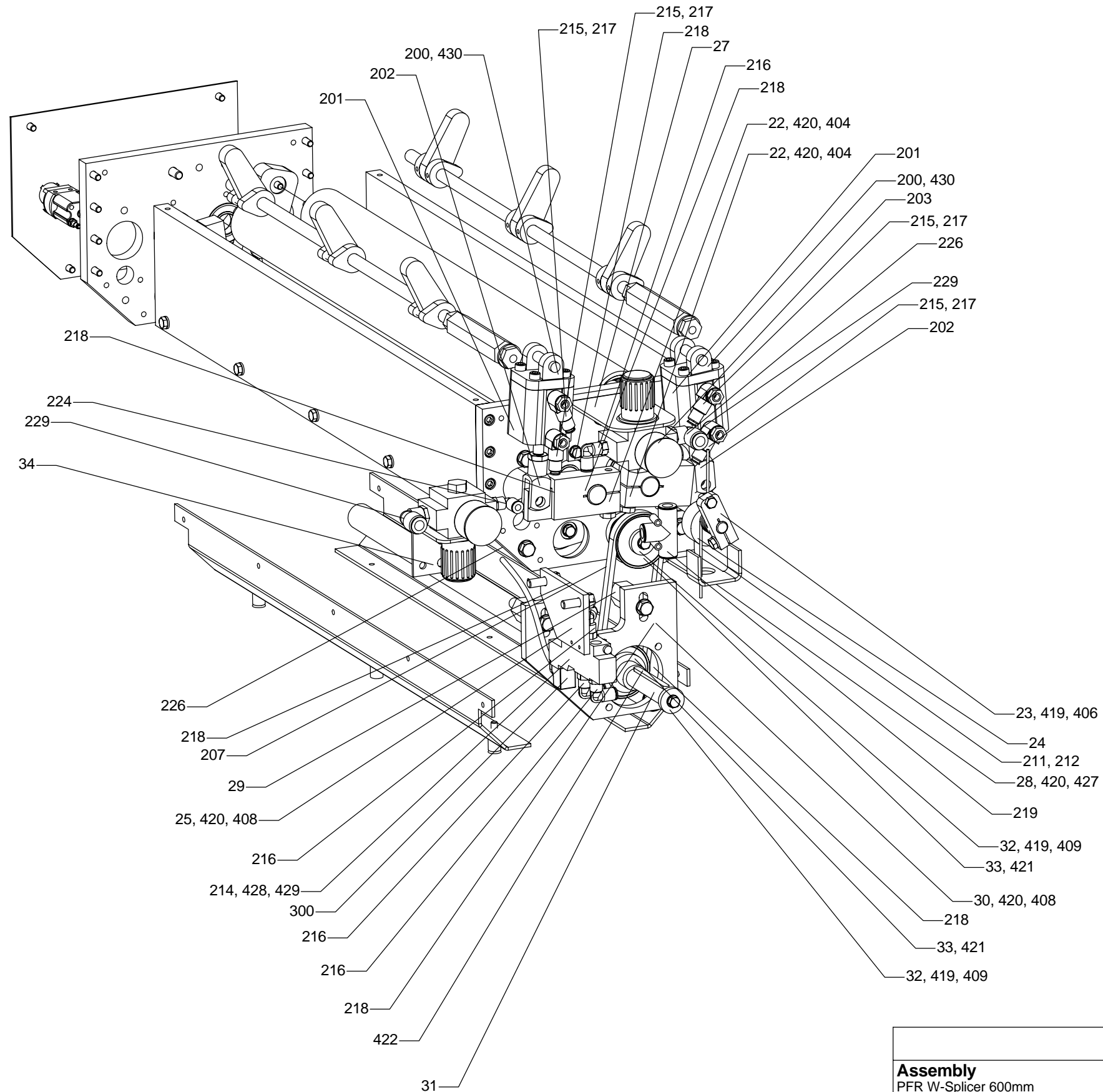
Lv	Item	Component no.	Description	Quant	Un
2	0000	131.029610	ASSY-PFR W/SPLICER 600mm		
3	0001	231.029610	Assy Dwg-PFR W-Splicer 600mm		
3	0002	431.001568	Pneumatic Schematic - Splicer		
3	0010	531.000251	02 PLATE PFR	2.000	EA
3	0011	531.000939	01 PLATE SPACER PFR 600	2.000	EA
3	0012	531.000944	01 SHAFT ROLLER PINCH 600	2.000	EA
3	0013	531.000953	01 SHAFT ROLLER BACKUP 600	1.000	EA
3	0014	531.000943	02 ROLLER FILM RUBBER COATED 650	3.000	EA
3	0015	531.000945	03 ROLLER FILM FEED 600	1.000	EA
3	0016	531.000946	02 SHAFT PIVOT PINCH ROLL 600	2.000	EA
3	0017	531.000947	02 SHAFT ROLLER TENSION 600	1.000	EA
3	0018	531.000948	02 SHAFT PIVOT TENSION ROLLER 600	1.000	EA
3	0019	531.000262	03 ARM	2.000	EA
3	0020	531.000949	01 ROLLER FILM TENSION DETECT 600	1.000	EA
3	0021	531.000264	03 ARM ROLLER PRESSURE	4.000	EA
3	0022	531.000265	01 ARM PIVOT PRESSURE ROLLER	2.000	EA
3	0023	531.000266	02 ARM SPRING TENSION	1.000	EA
3	0024	531.000267	01 CAM SENSOR TENSION	1.000	EA
3	0025	531.000299	01 SPACER SOLENOID SPLICER	1.000	EA
3	0026	531.000950	01 GUIDE FILM 600	2.000	EA
3	0027	531.001992	01 MOUNT SPLICER REGULATOR	1.000	EA
3	0028	531.000274	02 BRKT MOUNT ANALOG SENSOR	1.000	EA
3	0029	531.000275	01 STANDOFF GEARBOX MOUNT	2.000	EA
3	0030	531.000276	01 PLATE MNT GEARBOX PFR	1.000	EA
3	0031	531.000277	01 SHAFT GEARBOX PFR	1.000	EA
3	0032	531.001254	02 SPACER RIDER BAR	3.000	EA
3	0033	531.000279	03 PULLEY 32 5Mx9 HTD	2.000	EA
3	0034	531.000132	03 MOUNT REGULATOR	1.000	EA
3	0035	531.000280	01 COVER FRONT PFR	1.000	EA
3	0036	531.000968	04 COVER PFR SIDE 600	2.000	EA
3	0038	531.000954	01 SUPPORT SHAFT SWING ARM 600	2.000	EA
3	0039	531.000955	01 SHAFT SWING ARM 600	2.000	EA
3	0041	396647	01 ARM-SWING	6.000	EA
3	0042	400673	06 STOP-SWING ARM	12.000	EA
3	0044	531.003733	03 SPACER EYE BACKING	3.000	EA
3	0200	031.000269	MOUNT SWIVEL CYLINDER	2.000	EA
3	0201	031.000270	CYLINDER 32x10	2.000	EA
3	0202	031.000271	CLEVIS ROD	2.000	EA
3	0203	031.000138	PRESSURE REGULATOR W/GAUGE	2.000	EA
3	0204	031.000248	VALVE-5WAY-2POSITION	1.000	EA
3	0205	031.001504	CONNECTOR BARBED M5	3.000	EA
3	0206	370609	BEARING-RADIAL BALL 17 X 35 X 10	6.000	EA
3	0207	414439	TIMING BELT HTD 425-5M 9 WIDE	1.000	EA
3	0208	370615	BEARING FLANGE 12 X 18 X 16MM BRZE	2.000	EA
3	0209	950243	BEARING-RADIAL BALL 20 x 42 x 12	6.000	EA
3	0210	364181	01 BEARING-BALL 22MM OD 8MM B 7MM WD	2.000	EA
3	0211	306379	TORSION SPRING LH .869 .095	1.000	EA
3	0212	370599	BRG-SLEEVE-OILITE 12 X 15 X 16	1.000	EA

3	0213	407188		ACTUATOR-SELECTOR SWITCH	1.000	EA
3	0214	031.000528		VALVE PNEUMATIC	1.000	EA
3	0215	410224	01	VALVE-FLOW CONTROL G1/8	4.000	EA
3	0216	432287		CONNECTOR-ELBOW MALE R1/8 TO 6mm TUB	5.000	EA
3	0217	433094		CONNECTOR-STRAIGHT R1/8 TO 6mm TUBE	4.000	EA
3	0218	370719		PA TUBE (NYLON) PNEUMATIC 6mm OD	1.000	M
3	0219	031.002799		CONNECTOR-TEE 10mm TUBE	2.000	EA
3	0220	397369		RING-RETAINING EXTERNAL 17mm SST	6.000	EA
3	0221	407600		RING-RTNG EXT 25DIA 1.2THK SST	6.000	EA
3	0222	397366		RING-RTNG-EXT 8 DIA 0.8 THK SST	2.000	EA
3	0223	397367		RING-RETAINING EXTERNAL 12mm SST	4.000	EA
3	0226	370720		PA TUBE (NYLON) PNEUMATIC 10mm OD	1.000	M
3	0227	273234	02	TAPE DISPENSER SPLICER	1.000	EA
3	0228	273235		SPLICER TAPE	2.000	EA
3	0229	370705	01	MALE-ELBOW 10MM TO 1/8 G	2.000	EA
3	0300	031.000529		CABLE, SOCKET MOLDED W/LED	1.000	EA
3	0400	310104		SCREW-SOC CAP M6 X 20 SST	20.000	EA
3	0401	379441		SCREW-SOC CAP M8 X 20 SST	4.000	EA
3	0402	388079		SCREW-HEX HD M6 X 25 SST	6.000	EA
3	0403	397011		SCREW-HEX HD M5 X 16 SST	2.000	EA
3	0404	397009		SCREW-HEX HD M8 X 40 SST	7.000	EA
3	0405	397007		SCREW-HEX HD M5 X 8 SST	4.000	EA
3	0406	310098		SCREW-HEX HD M6 X 20 SST	17.000	EA
3	0407	310149		SCREW-HEX HD M10 X 25 SST	2.000	EA
3	0408	310110		SCREW-HEX HD M8 X 25 SST	7.000	EA
3	0409	309391		SCREW-HEX HD M6 X 16 SST	5.000	EA
3	0410	397058		SCREW-SET M6 X 8 SST	1.000	EA
3	0411	282195		PIN-DOWEL .188 X 1.00 SST	6.000	EA
3	0412	430377		SCREW-HEX HD M8 X 35 SST	2.000	EA
3	0413	953567		SCREW-HEX-HD M12 X 30 STL	2.000	EA
3	0414	310176		NUT-HEX FULL M12 SST	2.000	EA
3	0415	310114		SCREW-HEX HD M8 X 16 SST	1.000	EA
3	0416	379473		SCREW-PAN SLOT M6 X 10 SST	4.000	EA
3	0417	310177		NUT-HEX FULL M10 SST	2.000	EA
3	0418	352-11347-04	02	WASHER-FLAT .203 X .447 X .034 SST	6.000	EA
3	0419	379749		WASHER-FLAT 6.4 X 12 X 1.6 SST	35.000	EA
3	0420	309393	01	WASHER-FLAT 8.4 X 16 X 1.6 SST	7.000	EA
3	0421	031.000188		KEY-5 X 5 X 18 SST	2.000	EA
3	0422	397388		KEY-6 X 6 X 50 SST	1.000	EA
3	0423	410231		SCREW-HEX HD M8 X 70 SST	4.000	EA
3	0424	397063		NUT-HEX FULL M8 SST	4.000	EA
3	0425	388617		SCREW-SHOULDER 8/M6 X 25 SST	2.000	EA
3	0426	395576		SCREW-FLAT SOC M6 X 30 SST	3.000	EA
3	0427	310144		SCREW-HEX HD M8 X 30 SST	1.000	EA
3	0428	401118		WASHER-FLAT 4.3 X 9 X .8 SST	2.000	EA
3	0429	432916		SCREW-HEX HD M4 X 25 SST	2.000	EA
3	0430	310108		SCREW-SOC CAP M6 X 25 SST	8.000	EA
3	0431	397069		WASHER-FLAT 13 X 24 X 2.5 SST	2.000	EA
3	0432	401228		WASHER-FLAT 5.3 X 10 X 1 SST	4.000	EA



Qty.	Index	Description	Date	ECN No.	Changed by
-	3	Item 211 306379 Was 216723	27 Apr 04	176015	SRL
-	2	Updated per ECN	21 Aug 03	172285	DWL
-	1	Updated per ECN	4 Aug 03	172082	DWL

Assembly PFR W-Splicer 600mm		Drawn by: Kirk Bryan	Date: 21 Jun 2002
		Approved by: Kirk Bryan	Scale: 1:3
 		Checked by: Barb Hemauer	Size: A2
		Sheet: 1/2	M-Type: 225
		231.029610	Rev.: 3
		© Copyright Doboy Inc.	Based on SIG Pack International Design Standards



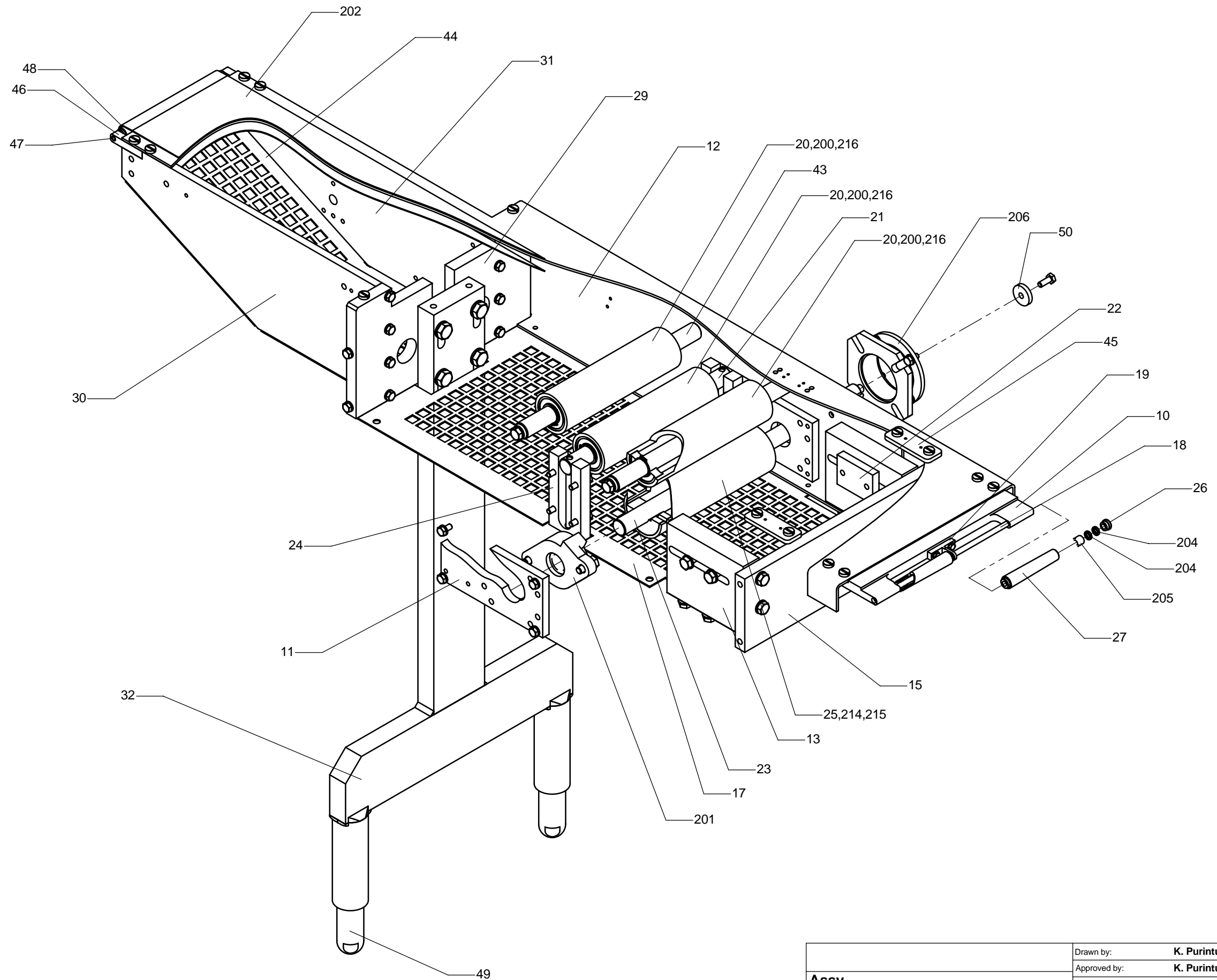
Qty.	Index	Description	Date	ECN No.	Changed by
-	3	Item 211 306379 Was 216723	27 Apr 04	176015	SRL
-	2	Updated per ECN	21 Aug 03	172285	DWL
-	1	Updated per ECN	4 Aug 03	172082	DWL

Assembly PFR W-Splicer 600mm		Drawn by: Kirk Bryan	Date: 21 Jun 2002
		Approved by: Kirk Bryan	Scale: 1:3
BOSCH		Checked by: Barb Hemauer	Size: A2
		Sheet: 2/2	M-Type: 225
Doboy Inc.		231.029610	
		Rev.: 3	
© Copyright Doboy Inc.		Based on SIG Pack International Design Standards	

Material	C307	05 0010	Alt.	Usage 3
	Linium 6X1 Rotary Horizontal Wrapper			Valid
				09/26/2007
Reqd qty	1.000 EA	Base quant	1.000 EA	
Sales ord.	129850	Item	000150	

Lv	Item	Component no.	Description	Quant	Un
2	0000	131.027740	KIT-FRAME 1200 DISCH		
3	0001	231.027740	ASSY-FRAME 1200 DISCH RL	1.000	EA
3	0002	331.027740	ASSY-FRAME 1200 DISCH LR	1.000	EA
3	0010	531.020152	BRACKET NOSE ROLLER	1.000	EA
3	0011	531.025874	PLATE-TAKE UP DRIVE	2.000	EA
3	0012	531.025556	02 FRAME-DISCHARGE REJECT 1200	1.000	EA
3	0013	531.000062	04 PLATE CNVR ADJ	2.000	EA
3	0015	531.000082	01 PLATE CNVR MNT	1.000	EA
3	0017	531.025875	GUARD-REJECT DISCHARGE BOTTOM	1.000	EA
3	0018	531.000084	02 SHAFT NOSE ROLLER	1.000	EA
3	0019	531.004397	02 SUPPORT CENTER	2.000	EA
3	0020	531.000085	01 ROLLER-DISCHARGE CONVEYOR IDLER	3.000	EA
3	0021	531.000086	01 SHAFT TAKE UP	1.000	EA
3	0022	531.000063	01 CLAMP CNVR MNT	2.000	EA
3	0023	531.000087	03 SHAFT DRIVE	1.000	EA
3	0024	531.000068	03 GUIDE TAKE UP	2.000	EA
3	0025	531.000088	03 ROLLER-DRIVE	1.000	EA
3	0026	350868	03 PLUG-NOSE-ROLLER	8.000	EA
3	0027	531.000089	02 ROLLER-NOSE	2.000	EA
3	0029	531.002240	PLATE DISCHARGE REJECT SPLICE	2.000	EA
3	0030	531.002241	03 PLATE DRIVE SIDE REJECT	1.000	EA
3	0031	531.002242	04 PLATE OPERATOR SIDE REJECT	1.000	EA
3	0032	531.025528	02 LEG DISCHARGE REJECT	1.000	EA
3	0043	531.002468	01 SHAFT IDLER ROLLER	2.000	EA
3	0044	531.002470	01 GUARD REJECT DISCHARGE BOTTOM	1.000	EA
3	0045	531.002472	01 PLATE EYE MOUNT	2.000	EA
3	0046	531.014729	BRACKET-REJECT-NOSE-ROLLER	1.000	EA
3	0047	531.002474	01 SHAFT REJECT NOSE ROLLER	1.000	EA
3	0048	531.002475	01 ROLLER REJECT NOSE	2.000	EA
3	0049	531.043662	01 PEG-LEVELING-USDA-890 TO 960	2.000	EA
3	0049	REPLACED 531.006379			
3	0050	531.001254	02 SPACER RIDER BAR	1.000	EA
3	0051	531.031959	01 NUT-LOCK PEG LEVELING	2.000	EA
3	0200	950243	BEARING-RADIAL BALL 20 x 42 x 12	6.000	EA
3	0201	031.000065	BEARING-2-BOLT FLANGE 20mm	1.000	EA
3	0202	031.025536	BELT-DISCHARGE 150 x 2738 FAB-2E	1.000	EA
3	0204	339705	01 SEAL-OIL 6x10x2	16.000	EA
3	0205	339704	01 BEARING-NEEDLE CAGED 6x10x9	8.000	EA
3	0206	031.000766	FLANGE-GEAR REDUCER NMRV040	1.000	EA
3	0214	397390	01 KEY-6 X 6 X 36 SST	1.000	EA
3	0215	370679	KEY-6 X 6 X 70 SST	1.000	EA
3	0216	397370	RING-RETAINING EXTERNAL 20 SST	8.000	EA
3	0217	397390	01 KEY-6 X 6 X 36 SST	1.000	EA
3	0400	401117	SCREW-HEX HD M4 X 8 SST	4.000	EA
3	0401	432321	SCREW-HEX HD M4 X 12 SST	4.000	EA
3	0402	310106	SCREW-HEX HD M6 X 10 SST	3.000	EA
3	0403	309391	SCREW-HEX HD M6 X 16 SST	2.000	EA
3	0404	310098	SCREW-HEX HD M6 X 20 SST	8.000	EA

3 0405 388079	SCREW-HEX HD M6 X 25 SST	16.000	EA
3 0406 422994	SCREW-FLAT SOC M6 X 40 SST	4.000	EA
3 0407 310114	SCREW-HEX HD M8 X 16 SST	4.000	EA
3 0408 432072	SCREW-HEX HD M8 X 20 SST	4.000	EA
3 0409 310110	SCREW-HEX HD M8 X 25 SST	2.000	EA
3 0410 310144	SCREW-HEX HD M8 X 30 SST	8.000	EA
3 0411 397009	SCREW-HEX HD M8 X 40 SST	4.000	EA
3 0412 391617	SCREW-HEX HD M8 X 100 SST	2.000	EA
3 0413 310151	SCREW-HEX HD M10 X 40 SST	4.000	EA
3 0414 397010	SCREW-HEX HD M10 X 45 SST	4.000	EA
3 0415 310155	SCREW-HEX HD M10 X 65 SST	2.000	EA
3 0416 310101	SCREW-SOC CAP M6 X 30 SST	1.000	EA
3 0417 310150	SCREW-SOC CAP M10 X 20 SST	2.000	EA
3 0418 309391	SCREW-HEX HD M6 X 16 SST	2.000	EA
3 0419 310112	SCREW-FLAT SOC M8 X 30 SST	7.000	EA
3 0420 412638	SCREW-BUTTON-HD M5 X 16 SST	1.000	EA
3 0421 414606	SCREW-CHEESE-HD M6 X 12 SST	20.000	EA
3 0422 031.000076	SCREW-SET M6 X 60 SST	2.000	EA
3 0423 310170	SCREW-SHOULDER 10/M8 X 20 SST	4.000	EA
3 0424 401118	WASHER-FLAT 4.3 X 9 X .8 SST	8.000	EA
3 0425 379749	WASHER-FLAT 6.4 X 12 X 1.6 SST	5.000	EA
3 0426 309393	01 WASHER-FLAT 8.4 X 16 X 1.6 SST	1.000	EA
3 0427 397080	WASHER-FLAT 10.5 X 20 X 2 SST	10.000	EA
3 0428 318898	NUT-HEX FULL M6 SST	3.000	EA
3 0429 309392	SCREW-HEX HD M6 X 8 SST	4.000	EA

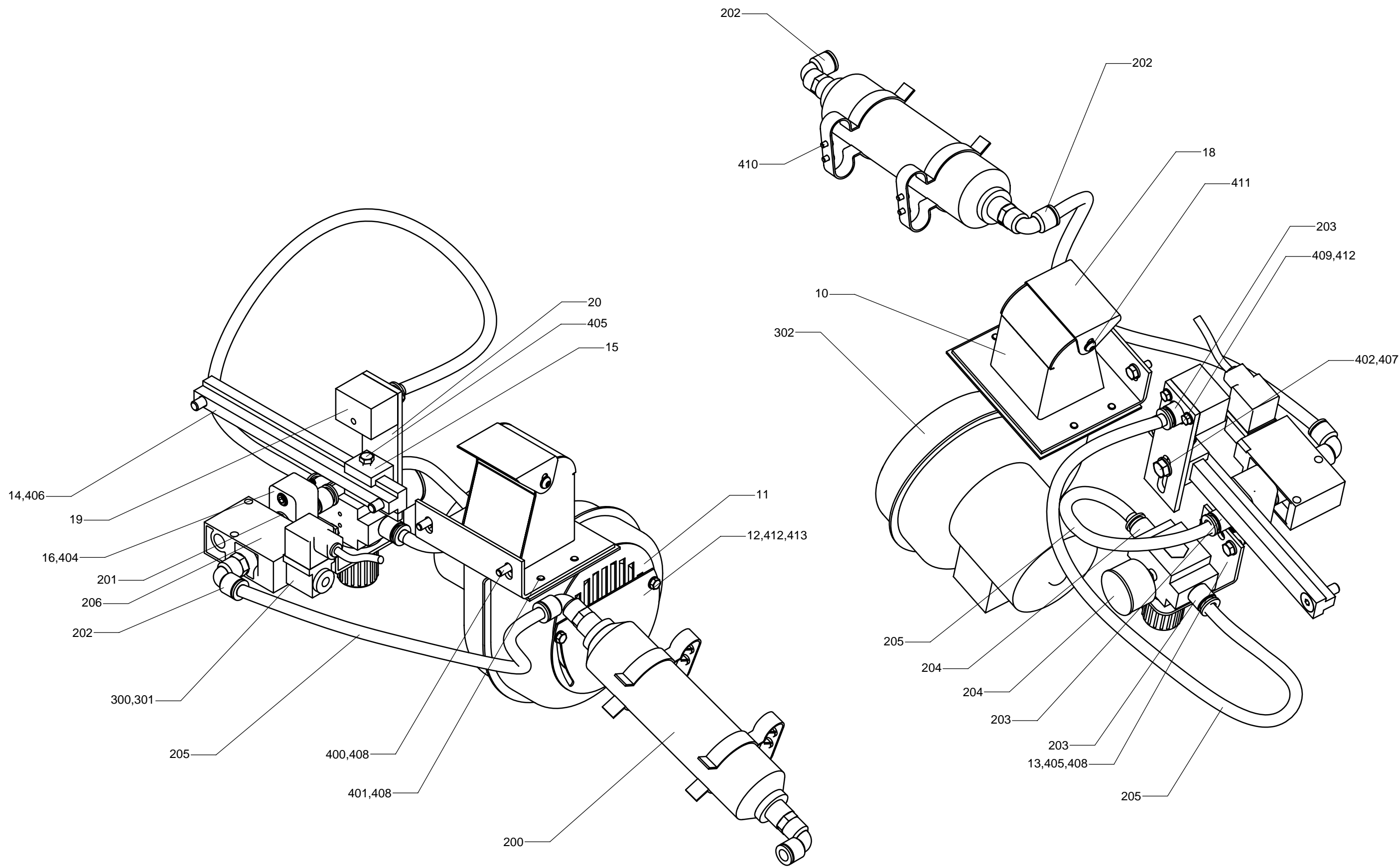


Qty.	Index	Description	Date	ECN No.	Changed by
0	2	Update per ecn	21 Jul 04	177046	BKM
0	1	Update per ecn	27 Mar 03	170633	KCP

Assy Frame 1200 Dischg RL 1200L x 150WD		Drawn by: K. Purintun	Date: 25 Nov 2002
		Approved by: K. Purintun	Scale: 1:3
BOSCH		Checked by: Barb Hemauer	Size: A2
		Sheet: 1/1	M-Type: 225
Doboy Inc.		231.027740	
		Rev.: 2	
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Material	C307	05 0010	Alt.	Usage 3
	Linium 6X1 Rotary Horizontal Wrapper			Valid
				09/26/2007
Reqd qty	1.000 EA	Base quant	1.000 EA	
Sales ord.	129850	Item	000150	

Lv	Item	Component no.	Description	Quant	Un
2	0000	131.049511	KIT-DISCHARGE AIR REJECT		
3	0001	231.049511	DWG-DISCHARGE AIR REJECT	1.000	EA
3	0010	531.011370	03 DUCT FAN MOUNTING	1.000	EA
3	0011	280301	05 GUARD-FAN	1.000	EA
3	0012	380275	01 COVER-EMPTY BLOW OFF	1.000	EA
3	0013	531.002202	01 BRKT REGULATOR MOUNT	1.000	EA
3	0014	531.002244	01 TRACK NOZZLE SLIDE	1.000	EA
3	0015	531.002245	02 BLOCK AIR NOZZLE SLIDE	1.000	EA
3	0016	531.002247	01 MANIFOLD SOLENOID MOUNT	1.000	EA
3	0018	531.028940	DEFLECTOR-AIR REJECT	1.000	EA
3	0019	531.048743	BLOCK AIR	1.000	EA
3	0020	531.049509	01 BRACKET AIR	1.000	EA
3	0200	432728	RESERVOIR G1/4	1.000	EA
3	0201	031.000445	NIPPLE-CONNECTOR HEX G1/4	1.000	EA
3	0202	031.000521	CONNECTOR-ELBOW MALE R1/4 TO 10mm TU	3.000	EA
3	0203	031.000525	CONNECTOR-STRAIGHT MALE R1/4 TO 10mm	4.000	EA
3	0204	031.010018	REGULATOR-PNEUMATIC .5-7BAR G1/4 W/G	1.000	EA
3	0205	370720	PA TUBE (NYLON) PNEUMATIC 10mm OD	2.000	M
3	0206	419479	VALVE-SOLENOID 3WAY 2POSITION	1.000	EA
3	0300	031.000723	CABLE-SOCKET MOULDED W/LED 24VDC	1.000	EA
3	0301	031.000724	COIL-SOLENOID 24VDC	1.000	EA
3	0302	USE BLOWER #441839			
3	0400	309391	SCREW-HEX HD M6 X 16 SST	2.000	EA
3	0401	309392	SCREW-HEX HD M6 X 8 SST	4.000	EA
3	0402	309393	01 WASHER-FLAT 8.4 X 16 X 1.6 SST	1.000	EA
3	0404	310101	SCREW-SOC CAP M6 X 30 SST	2.000	EA
3	0405	310106	SCREW-HEX HD M6 X 10 SST	3.000	EA
3	0406	310112	SCREW-FLAT SOC M8 X 30 SST	2.000	EA
3	0407	310114	SCREW-HEX HD M8 X 16 SST	1.000	EA
3	0408	379749	WASHER-FLAT 6.4 X 12 X 1.6 SST	9.000	EA
3	0409	397011	SCREW-HEX HD M5 X 16 SST	2.000	EA
3	0410	397043	SCREW-PAN SLOT M4 X 6 SST	4.000	EA
3	0411	401093	SCREW-BUTTON HD M5 X 8 SST	2.000	EA
3	0412	401228	WASHER-FLAT 5.3 X 10 X 1 SST	6.000	EA
3	0413	422010	SCREW-HEX HD M5 X 10 SST	2.000	EA



0	1	Updated Drawing to Match B/M	22 Feb 06	186339	D. Leschisin
Qty.	Index	Description	Date	ECN No.	Changed by

Similar to 131.026888		Drawn by: Bryan Mueller	Date: 21 Dec 2005
Kit Discharge Air Reject		Approved by: Bryan Mueller	Scale: 1:2
		Checked by:	Size: A2
		Sheet: 1/1	M-Type: 307
		231.049511	Rev.: 1
BOSCH	Doboy Inc.	© Copyright Doboy Inc.	Based on SIG Pack International Design Standards

Material	C307	05 0010	Alt.	Usage 3
	Linium 6X1 Rotary Horizontal Wrapper			Valid
				09/26/2007
Reqd qty	1.000 EA	Base quant	1.000 EA	
Sales ord.	129850	Item	000150	

Lv	Item	Component no.	Description	Quant	Un
2	0000	131.058927	KIT MAIN BASIC (CLX) L-R 07		
3	0301	631.023677	05 ELECT PANEL 600 SERIES CLX L-R	1.000	EA
3	0302	631.049190	POWER SUPPLY 5VDC 5A	1.000	EA
3	0303	DELETED 274170	CIRCUIT BREAKER OP. QTY 1		
3	0304	631.048204	POWER SUPPLY 24VDC 3.9A	1.000	EA
3	0305	255888	04 BAR GROUNDING	1.000	EA
3	0306	276734	02 CABLE-QUICK DISCONNECT DC 15' STRAIG	1.000	EA
3	0307	8-110-620-916	MONITOR SAFETY RELAY	1.000	EA
3	0308	631.050703	CONTACTOR 3NO 1NC	4.000	EA
3	0309	8-110-620-917	SAFETY EXPANSION OFF DELAY MONITOR	1.000	EA
3	0310	631.042799	01 SOLID STATE RELAY W/COVER & LED	4.000	EA
3	0311	292415	FUSE BLOCK-12 AMPS, 300 VOLT	20.000	EA
3	0312	282808	01 FUSE 10 AMP CERAMIC BODY	8.000	EA
3	0313	476677	MP MOTOR POWER CABLE	3.000	EA
3	0314	476692	01 INTERFACE BREAKOUT	3.000	EA
3	0315	476693	FEEDBACK BREAKOUT	3.000	EA
3	0316	479833	SWITCH-INTERLOCK 10M CABLE N.O AUX	6.000	EA
3	0317	491622	TERM BLOCK 4 WIRE	136.000	EA
3	0318	491623	END PLATE FOR 4 WIRE	3.000	EA
3	0319	491635	KIT SENSOR TERMINAL BLOCK	15.000	EA
3	0320	491632	TERMINAL BLOCK RETAINER	4.000	EA
3	0321	491627	END PLATE FOR SENSOR BLOCK	1.000	EA
3	0322	491623	END PLATE FOR 4 WIRE	3.000	EA
3	0323	491630	GROUND TERM BLOCK 4 WIRE	3.000	EA
3	0324	491631	END PLATE GRD TB 4 WIRE	1.000	EA
3	0325	379508	STRAIN RELIEF PG21 NYLON 13-18MM	5.000	EA
3	0326	440561	MULTI HOLE SEAL INSERT	5.000	EA
3	0327	402781	PLUG-HOLE PG 21 THREADED	11.000	EA
3	0328	440560	STRAIN RELIEF PG16 ENLARGED	3.000	EA
3	0329	440559	CONNECTOR-STRAIN RELIEF PG-16	8.000	EA
3	0330	440564	HOLE PLUG PG16 THREADED	5.000	EA
3	0331	631.026653	01 5PIN CABLE FEMALE 12'	1.000	EA
3	0332	631.027031	01 CABLE MALE 5PIN 12ft	1.000	EA
3	0333	283039	02 CABLE-QUICK DISCONNECT DC 15' 90 DEG	1.000	EA
3	0334	233672	CABLE 20 AWG 10 CONDUCTOR 300V	20.000	FT
3	0335	491633	JUMPER 10 PLACE	6.000	EA
3	0336	491649	TB MARKER 10mm 144 PER CARD	2.000	EA
3	0338	471657	CABLE DEVICENET COMM	20.000	FT
3	0339	292416	01 END BARRIER FOR FUSE BLOCK	1.000	EA
3	0340	284599	02 WIRING DUCT 1Wx3H W/COVER	9.000	FT
3	0341	283407	02 WIRING DUCT 2Wx3H W/COVER	8.000	FT
3	0342	327046	01 MOUNTING RAIL-DIN EN NS35/7,5	60.000	IN
3	0343	281968	FUSE 10A 250V MDA	4.000	EA
3	0343	CHANGED QTY FROM 7 TO 4			
3	0350	281967	01 FUSE 5A CERAMIC 250V MDA	4.000	EA
3	0351	454334	01 STRAIN RELIEF NYLON PG29	2.000	EA
3	0352	491652	FUSE .375 AMP MDL TIME-DELAY	1.000	EA
3	0353	631.054375	TEMP CONTROL DUAL LOOP MODULE ETHERN	2.000	EA

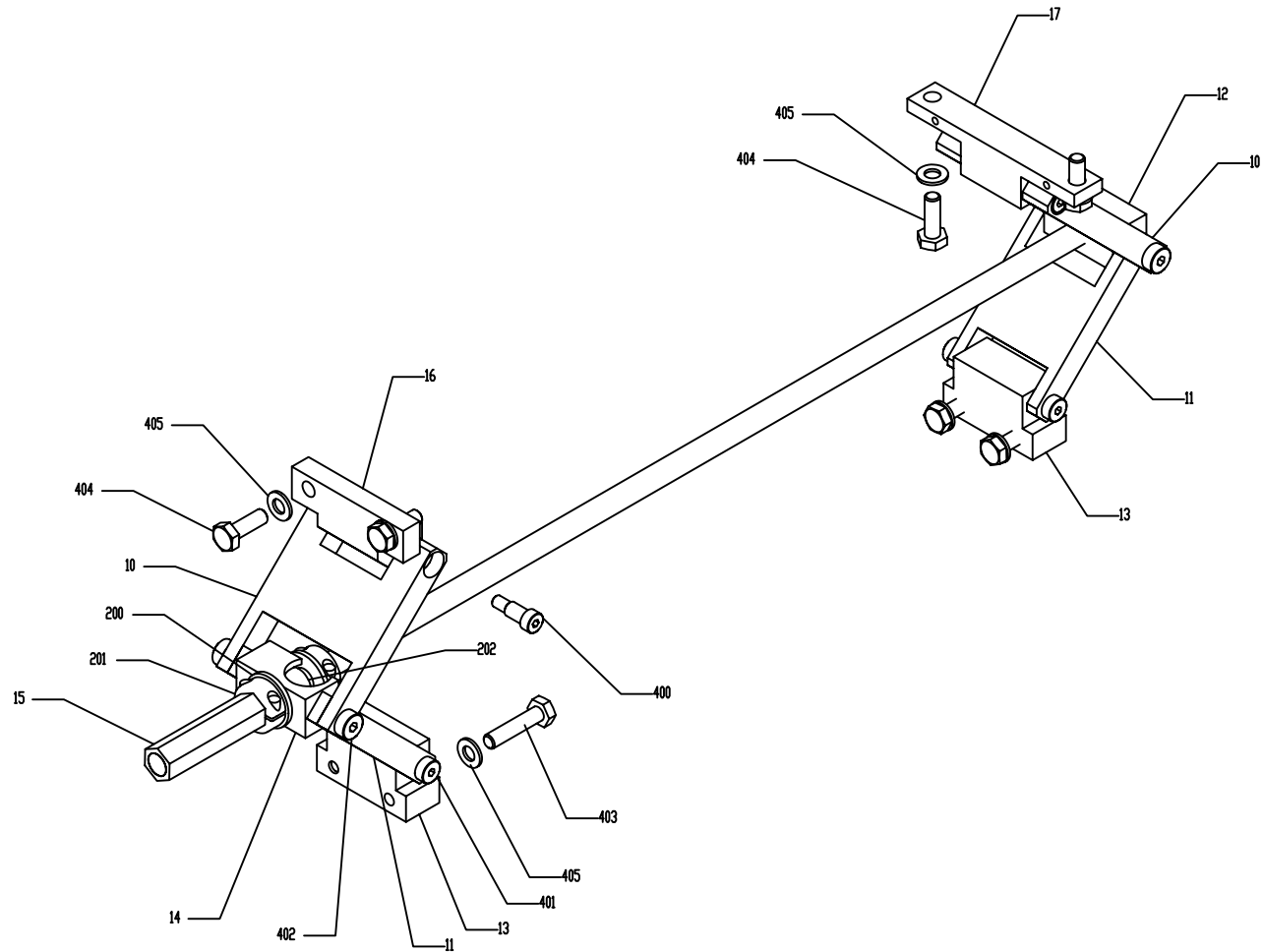
3 0354 619.0042646	CABLE CAT. 5E RJ45/RJ45 3 FT	2.000	EA
3 0355 631.024292	.3 METER SERCOS CABLE	2.000	EA
3 0356 631.024293	3 METER SERCOS CABLE	2.000	EA
3 0357 631.024368	SERVO AMPLIFIER 2KW SERCOS	3.000	EA
3 0358 631.024247	01 CABLE 3 PIN FEMALE	2.000	EA
3 0359 631.024246	01 CABLE 3 PIN MALE	2.000	EA
3 0360 476678	01 MP MOTOR FEEDBACK CABLE	3.000	EA
3 0361 479969	RELAY W/BASE 1NO SSR OUTPUT 24VDC IN	2.000	EA
3 0362 404635	02 CABLE-FEMALE 4COND #16 15' LONG	2.000	EA
3 0364	DELETED 395203 AC DRIVE 1HP A/B160 QTY 1		
3 0365	DELETED 468065 160DNET COMM MOD QTY 1		
3 0366 474388	CONNECTOR MICRO FEMALE	1.000	EA
3 0368 379510	01 LOCKNUT-NYLON PG 21	3.000	EA
3 0369 440565	LOCKING NUT PG16	4.000	EA
3 0370 631.030749	TRANSFORMER 2KVA 1 PH 240/240	1.000	EA
3 0371 631.039107	SINGLE OUTLET RAIL MOUNT	1.000	EA
3 0372 631.055755	WIRING DUCT 2Wx4H W/COVER	5.000	FT
3 0373 631.055514	FUSE 12A 250V MDA	3.000	EA
3 0373	ADDED ITEM 373		

Material	C307	05 0010	Alt.	Usage 3
	Linium 6X1 Rotary Horizontal Wrapper			Valid
				09/26/2007
Reqd qty	1.000	EA	Base quant	1.000 EA
Sales ord.	129850		Item	000150

Lv	Item	Component no.	Description	Quant	Un
2	0000	131.056549	KIT CONTROLOGIX LINIUM 61X 07		
3	0300	475473	RACK 13SLOT CONTROLOGIX	1.000	EA
3	0301	474183	16PT INPUT CONTROLOGIX	2.000	EA
3	0302	474184	16PT OUTPUT CONTROLOGIX	2.000	EA
3	0303	474181	POWER SUPPLY CONTROLOGIX	1.000	EA
3	0304	631.035636	01 CONTROLOGIX PROCESSOR 5561	1.000	EA
3	0305	631.024295	SERCOS INTERFACE CONTROLOGIX	1.000	EA
3	0306	631.050696	ANALOG 8 CHANNEL INPUT	1.000	EA
3	0306	WAS 475471	DEVICENET SCANNER CLX		
3	0307	473840	SLOT FILLER CONTROLOGIX	5.000	EA
3	0307	WAS	QUANTITY 6		
3	0308	474189	20 PIN SCREW CLAMP CONNECTOR	4.000	EA
3	0309	426646	VARISTOR MOV	1.000	EA
3	0310	631.064918	ETHERNET MANAGED SWITCH 8 PORTS	1.000	EA
3	0310	WAS 631.054376	RAIL SWITCH 8 PORT		
3	0311	475476	01 CONTROL LOGIX ETHERNET/IP MODULE	1.000	EA
3	0312	031.036191	RJ-45 3' CABLE BLUE	1.000	EA
3	0313	631.037008	RJ-45 20' CABLE BLUE	1.000	EA
3	0314	474190	36 PIN SCREW CLAMP CONNECTOR	1.000	EA

Material	C307	05	0010	Alt.	Usage 3
	Linium 6X1 Rotary Horizontal Wrapper				Valid 09/26/2007
Reqd qty	1.000	EA	Base quant	1.000	EA
Sales ord.	129850		Item	000150	

Lv	Item	Component no.	Description	Quant	Un
3	0000	131.013680	KIT CUTTING HEAD LIFT		
4	0001	231.013680			
4	0010	531.021146	02 BAR CUTTING HEAD LIFT	2.000	EA
4	0011	531.021147	01 BAR CUTTING HEAD LIFT	2.000	EA
4	0012	531.021148	01 NUT CUTTING HEAD LIFT	1.000	EA
4	0013	531.021149	01 BLOCK LIFT ATTACHMENT	2.000	EA
4	0014	531.021150	02 HINGE CUTTING HEAD LIFT	1.000	EA
4	0015	531.021151	01 SCREW CUTTING HEAD LIFT	1.000	EA
4	0016	531.021153	BLOCK LIFT ATTACHMENT	1.000	EA
4	0017	531.021154	01 BLOCK LIFT ATTACHMENT	1.000	EA
4	0200	992-01225	BRG BRONZE THRUST	2.000	EA
4	0201	031.018303	COLLAR-CLAMP 15x34x13 STL	2.000	EA
4	0202	410881	BUSHING D16/22X20	1.000	EA
4	0400	310166	SCREW-SHOULDER 10/M8 X 16 SST	4.000	EA
4	0401	395975	SCREW-SHOULDER 10/M8 X 10 SST	4.000	EA
4	0402	031.000326	SCREW-SHOULDER 12/M10 X 20 SST	4.000	EA
4	0403	397010	SCREW-HEX HD M10 X 45 SST	4.000	EA
4	0404	310148	SCREW-HEX HD M10 X 30 SST	4.000	EA
4	0405	397080	WASHER-FLAT 10.5 X 20 X 2 SST	8.000	EA

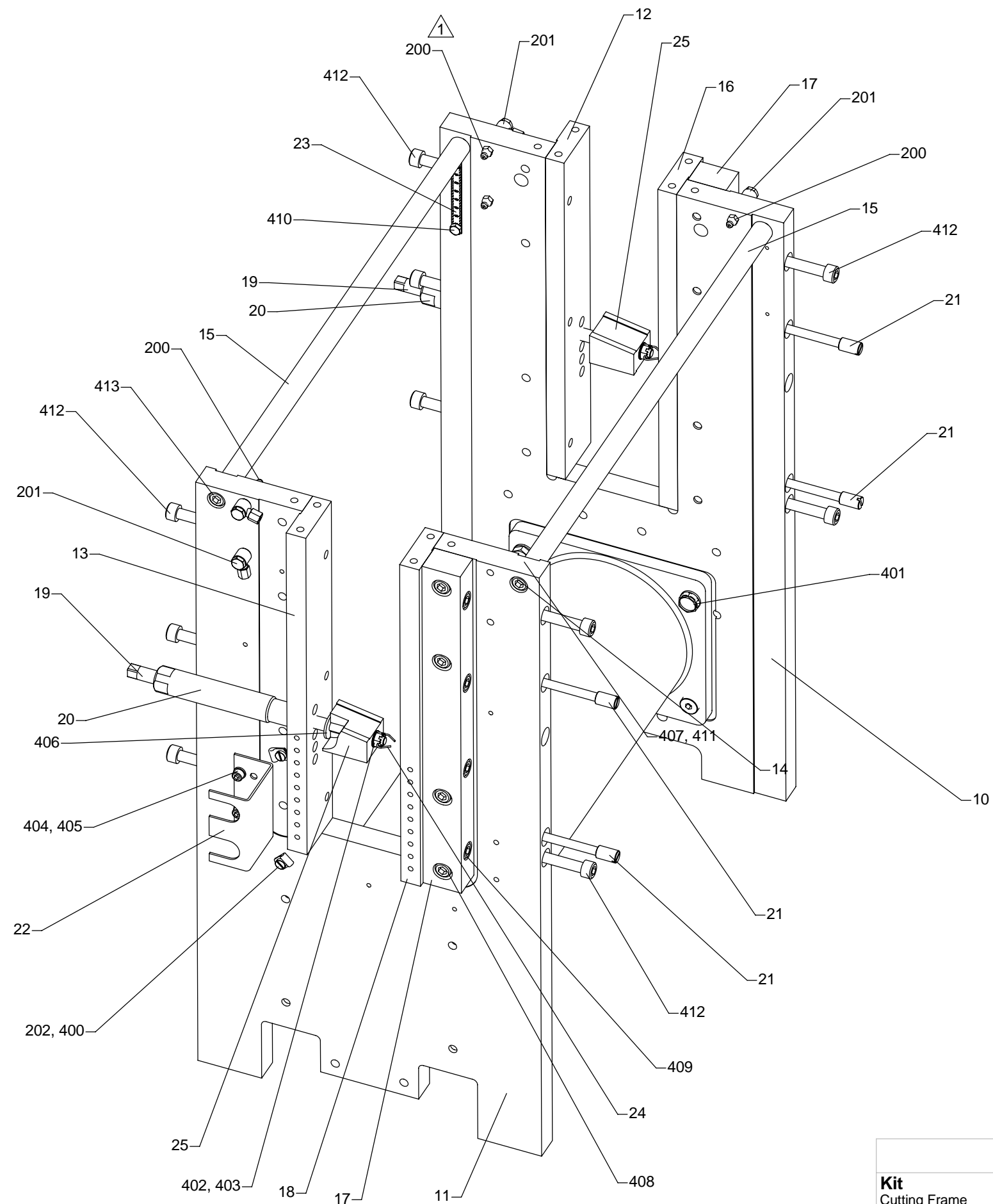


		Drawn by	Roger Hefty	Date	12 Nov 2001
		Approved by	Roger Hefty	Scale	1:2
KIT		Checked by		Size	A2
Cutting Head Lift				W-Type	307
		231.013680		Rev:	0
BOSCH		Doboy Inc.		© Copyright Doboy Inc.	Based on Siemens International Design Standards

Qty.	Index	Description	Date	EDM No.	Changed by

Material	C307	05	0010	Alt.	Usage 3
	Linium 6X1 Rotary Horizontal Wrapper				Valid
					09/26/2007
Reqd qty		1.000	EA	Base quant	1.000 EA
Sales ord.	129850			Item	000150

Lv	Item	Component no.	Description	Quant	Un
3	0000	131.026870	KIT CUTTING FRAME		
4	0010	531.016872	05 PLATE CUTTING HEAD DRIVE SIDE	1.000	EA
4	0011	531.016873	03 PLATE CUTTING HEAD OPER SIDE	1.000	EA
4	0012	531.016886	01 BRACKET VERTICAL	1.000	EA
4	0013	531.016891	01 SUPPORT VERTICAL	1.000	EA
4	0014	531.016878	03 BRACE TUBE	1.000	EA
4	0015	531.016876	SHAFT TOP CUTTING HEAD	2.000	EA
4	0016	531.019796	02 BRACKET VERTICAL	1.000	EA
4	0017	531.019798	BRACKET BRACE	2.000	EA
4	0018	531.019795	02 BRACKET VERTICAL	1.000	EA
4	0019	531.026215	SCREW WEDGE ADJUST	2.000	EA
4	0020	531.018046	LOCK ADJUST SCREW	2.000	EA
4	0021	531.019659	SCREW M12	4.000	EA
4	0023	531.000028	02 SCALE 0-70MM	1.000	EA
4	0024	531.018764	PIN LOCK	2.000	EA
4	0025	531.026214	WEDGE ADJUSTABLE	2.000	EA
4	0200	031.016318	FTG GREASE STR M8 X 1	6.000	EA
4	0201	031.016316	FITTING-COMPRESSION ELBOW M8X4MM TUB	6.000	EA
4	0202	206234	03 CLAMP CABLE 0.125 PLASTIC YEL	8.000	EA
4	0400	310095	SCREW-PAN SLOT M5 X 10 SST	7.000	EA
4	0401	031.018092	SCREW SHOULDER 12/M10 X 12SST	4.000	EA
4	0402	031.018763	NUT M8 CASTLE	2.000	EA
4	0403	117618	01 WASHER SHIM .375 X .625 X .015 STL	6.000	EA
4	0406	397070	WASHER-FLAT 8.4 X 24 X 2 SST	2.000	EA
4	0407	397080	WASHER-FLAT 10.5 X 20 X 2 SST	4.000	EA
4	0408	407582	SCREW-SOC CAP M10 X 40 SST	8.000	EA
4	0409	408312	SCREW-SOC-HD-CAP M10 X 35 STL	8.000	EA
4	0410	409969	SCREW-HEX HD M6 X 14 SST	2.000	EA
4	0411	432071	SCREW-HEX HD M10 X 35 SST	4.000	EA
4	0412	434327	SCREW-SOC-HD-CAP M10 X 65 STL	10.000	EA
4	0413	412893	SCREW-SOC CAP M10 X 30 SST	4.000	EA

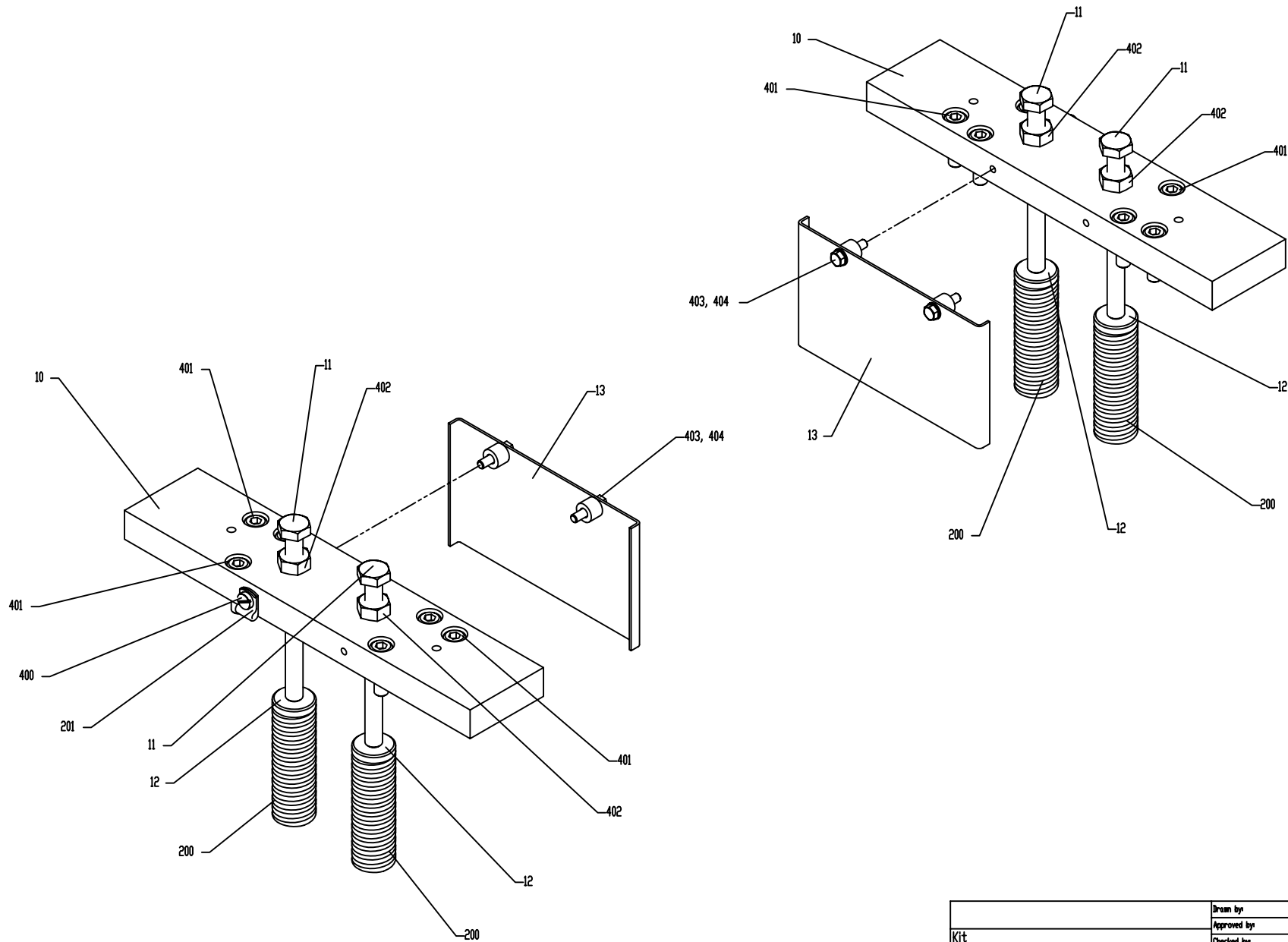


1	1	Updated Drawing to Match B/M	15 Nov 06	189649	DLeschisin
Qty.	Index	Description	Date	ECN No.	Changed by

Kit Cutting Frame	Drawn by:	Roger Hefty	Date:	16 Jan 2003
	Approved by:	John Meisner	Scale:	1:3
	Checked by:	Barb Hemauer	Size:	A2
		Sheet: 1/1	M-Type:	323
231.026870		Rev.: 1		
BOSCH	Doboy Inc.	© Copyright Doboy Inc.	Based on SIG Pack International Design Standards	

Material	C307	05	0010	Alt.	Usage 3
	Linium 6X1 Rotary Horizontal Wrapper				Valid
					09/26/2007
Reqd qty		1.000	EA	Base quant	1.000 EA
Sales ord.	129850			Item	000150

Lv	Item	Component no.	Description	Quant	Un
3	0000	131.028677	KIT SHAFT TENSION CUTTING HEAD		
4	0010	531.018053	01 BLOCK TOP SUPPORT	2.000	EA
4	0011	531.018052	01 SCREW ADJUST SPRING	4.000	EA
4	0012	531.018054	BUTTON SPRING	4.000	EA
4	0013	531.018492	PLATE COVER CUTTING HEAD	2.000	EA
4	0200	128130	02 SPRING DIE 1.00 .250 3.00	4.000	EA
4	0201	206234	03 CLAMP CABLE 0.125 PLASTIC YEL	2.000	EA
4	0400	310095	SCREW-PAN SLOT M5 X 10 SST	2.000	EA
4	0401	310115	SCREW-SOC CAP M8 X 25 SST	12.000	EA
4	0402	310177	NUT-HEX FULL M10 SST	4.000	EA
4	0403	318906	SCREW-HEX HD M5 X 20 SST	4.000	EA
4	0404	401228	WASHER-FLAT 5.3 X 10 X 1 SST	4.000	EA

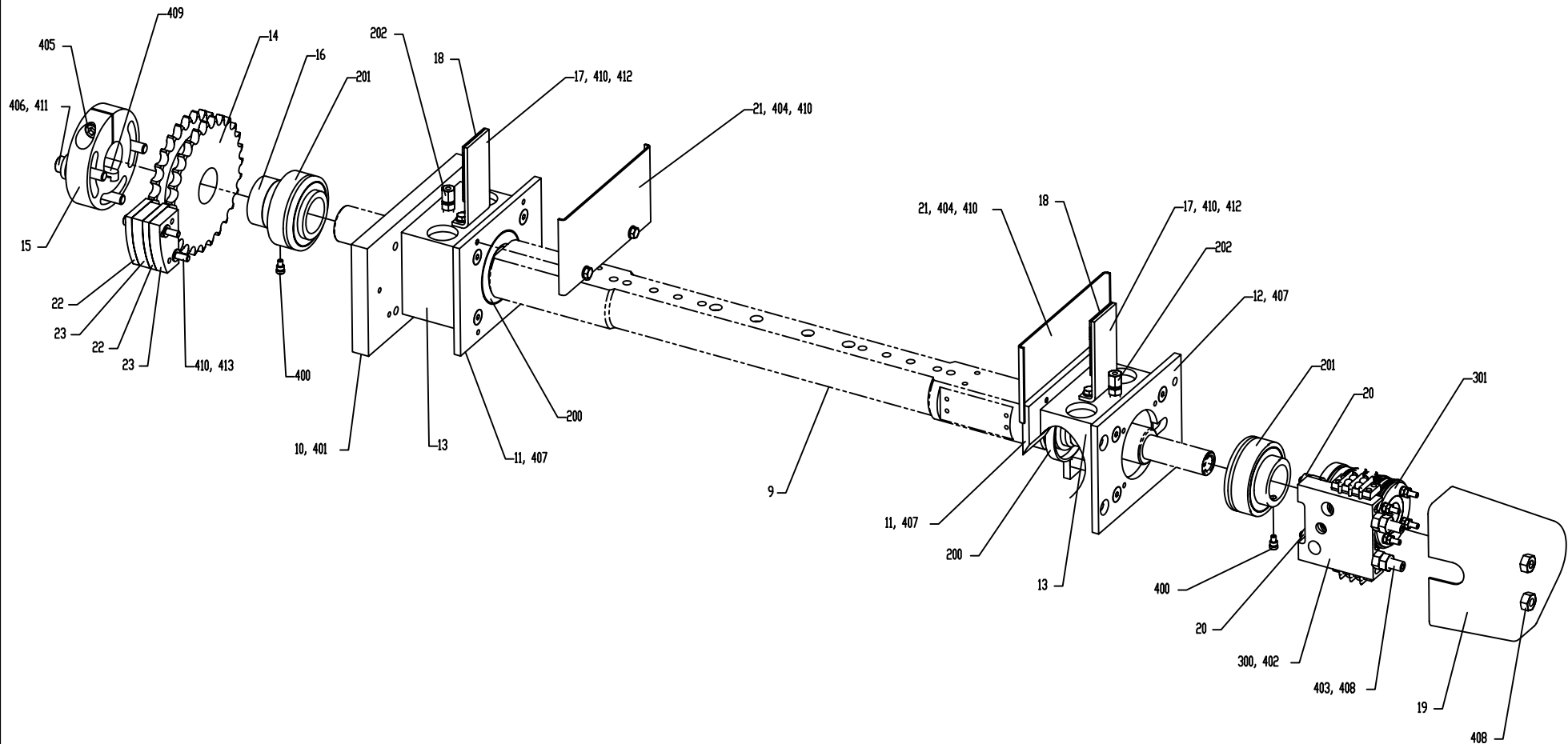


Qty.	Index	Description	Date	EDN No.	Changed by
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Drawn by		Roger Hefty	Date		22 Jun 2003	
Approved by		John Nelsner	Scale		1:1.5	
Checked by			Size		A2	
		Sheet	1/1	H-Type		
		231.028677			Rev:	0
BOSCH		Doboy Inc.		© Copyright Doboy Inc.		
		Based on Siemack International Design Standards				

Material	C307	05 0010	Alt.	Usage 3
	Linium 6X1 Rotary Horizontal Wrapper			Valid
				09/26/2007
Reqd qty	1.000 EA	Base quant	1.000 EA	
Sales ord.	129850	Item	000150	

Lv	Item	Component no.	Description	Quant	Un
3	0000	131.026871	KIT CUTTING UPPER SHAFT		
4	0009	531.016888	Shaft Cutting Head Upper		
4	0010	531.016890	01 PLATE BRG RETAINER DRIVE SIDE	1.000	EA
4	0011	531.016879	01 PLATE BEARING RETAINER INNER	2.000	EA
4	0012	531.016892	01 PLATE BRG RETAINER OPER SIDE	1.000	EA
4	0013	531.016881	HOUSING BEARING UPPER	2.000	EA
4	0014	531.016851	SPROCKET 27T #40	1.000	EA
4	0015	531.011648	COLLAR - ADJUSTABLE	1.000	EA
4	0016	531.018243	SPACER DRIVE SPRKT	1.000	EA
4	0017	531.018246	MOUNT INDICATOR	2.000	EA
4	0018	229080	02 LABEL SPRING PRESSURE	2.000	EA
4	0019	391537	COVER SLIP RING	1.000	EA
4	0020	531.019904	SPACER BRUSH HOLDER	2.000	EA
4	0021	531.018245	PLATE COVER CUTTING HEAD	2.000	EA
4	0022	531.011652	02 GUIDE CUTTING HEAD CHAIN	2.000	EA
4	0023	531.011653	GUIDE CUTTING HEAD CHAIN	2.000	EA
4	0200	031.018496	SEAL - BEARING HMS4 34mm X 60mm X	2.000	EA
4	0201	031.016884	BEARING -RADIAL BALL ER 30mm X 62mm	2.000	EA
4	0202	031.016315	FTG-COMPRESSION STRT	2.000	EA
4	0300	391710	KIT BRUSH HOLDER 4 RING METRIC		
4	0300	396187	KIT BRUSH HOLDER 4 RING METRIC CW		
4	0301	391709	04 ASSY COLLECTOR 4 RING METRIC	1.000	EA
4	0400	031.016885	SCREW-SOC. HD. - DOG PT. M6 X 9	2.000	EA
4	0401	310099	SCREW-FLAT SOC M6 X 25 SST	4.000	EA
4	0402	318906	SCREW-HEX HD M5 X 20 SST	2.000	EA
4	0403	379458	SCREW-SET M8 X 40 SST	2.000	EA
4	0404	397007	SCREW-HEX HD M5 X 8 SST	4.000	EA
4	0405	397030	SCREW-SOC CAP M8 X 30 SST	1.000	EA
4	0406	397031	SCREW-SOC CAP M8 X 35 SST	3.000	EA
4	0407	397038	SCREW-FLAT SOC M6 X 16 SST	12.000	EA
4	0408	397063	NUT-HEX FULL M8 SST	6.000	EA
4	0409	397386	SST KEY 8MM X 7MM 25MM LG	1.000	EA
4	0410	401228	WASHER-FLAT 5.3 X 10 X 1 SST	12.000	EA
4	0411	407802	WASHER-FLAT THK 8.4 X 21 X 4 SST	3.000	EA
4	0412	422010	SCREW-HEX HD M5 X 10 SST	4.000	EA
4	0413	425332	SOCKET-HD-CAP M5 X 45 SST	2.000	EA

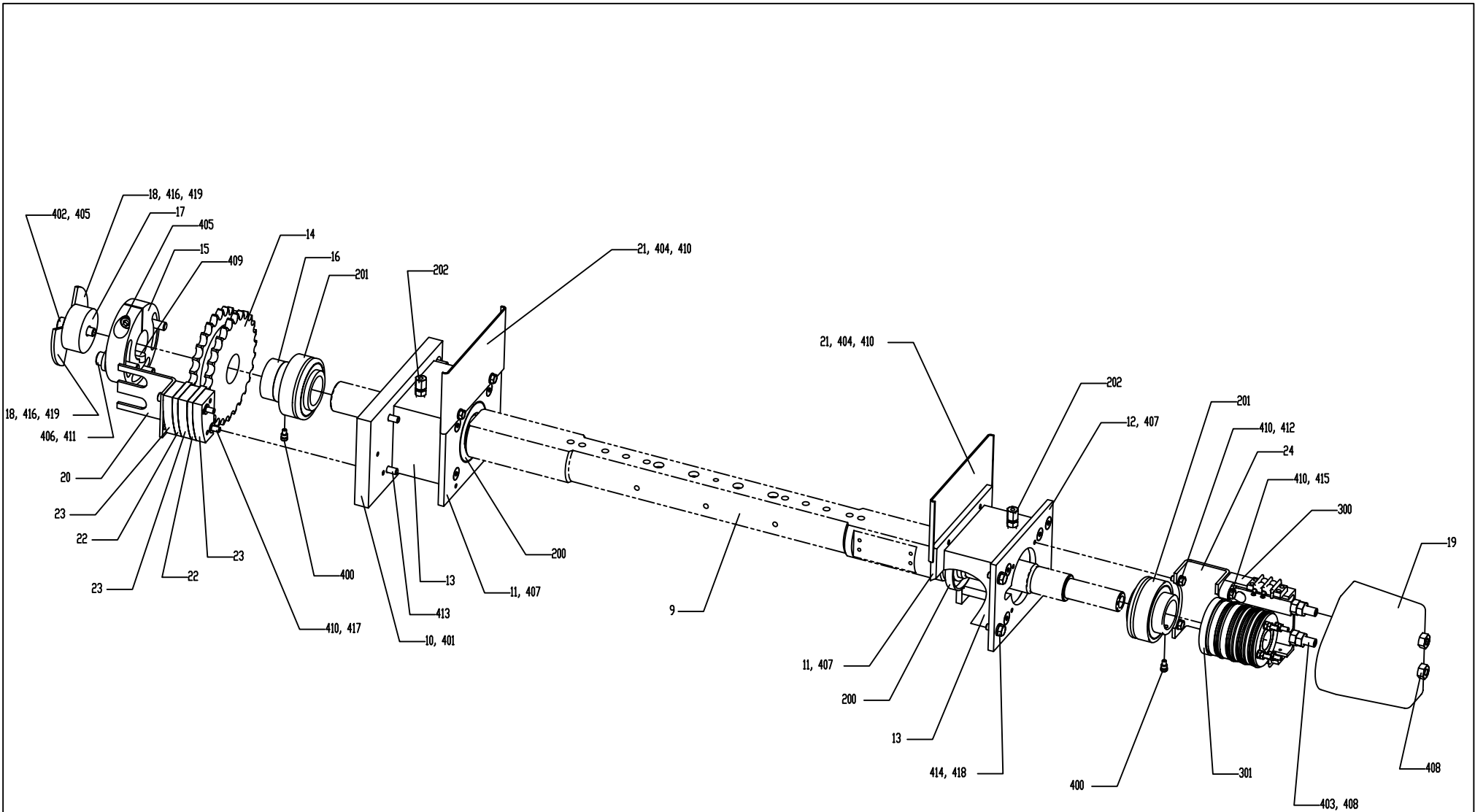


Qty.	Index	Description	Date	EDN No.	Changed by
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Cutting Upper Shaft	Drawn by	Roger Hefty	Date	16 Jun 2003
	Approved by	John Nelsner	Scale	1:2.25
	Checked by		Sheet	1/1
			H-Type	307
	231.026871		Rev:	0
BOSCH	Doboy Inc.	© Copyright Doboy Inc.	Based on Sigack International Design Standards	 

Material	C307	05	0010	Alt.	Usage 3
	Linium 6X1 Rotary Horizontal Wrapper				Valid
					09/26/2007
Reqd qty		1.000	EA	Base quant	1.000 EA
Sales ord.	129850			Item	000150

Lv	Item	Component no.	Description	Quant	Un
3	0000	131.026872	KIT CUTTING LOWER SHAFT		
4	0009	531.019640	Shaft Cutting Head Lower		
4	0010	531.016890	01 PLATE BRG RETAINER DRIVE SIDE	1.000	EA
4	0011	531.016879	01 PLATE BEARING RETAINER INNER	2.000	EA
4	0012	531.016892	01 PLATE BRG RETAINER OPER SIDE	1.000	EA
4	0013	531.016880	HOUSING BEARING LOWER	2.000	EA
4	0014	531.016851	SPROCKET 27T #40	1.000	EA
4	0015	531.011648	COLLAR - ADJUSTABLE	1.000	EA
4	0016	531.018243	SPACER DRIVE SPRKT	1.000	EA
4	0017	531.000364	03 HUB CUTT HD FLAG	1.000	EA
4	0018	531.002796	01 FLAG CUTT HD 90o	2.000	EA
4	0018	531.002797	01 FLAG CUTT HD 180o	1.000	EA
4	0019	391537	COVER SLIP RING	1.000	EA
4	0020	531.018494	BRKT PROX MTG	1.000	EA
4	0021	531.018245	PLATE COVER CUTTING HEAD	2.000	EA
4	0022	531.011652	02 GUIDE CUTTING HEAD CHAIN	2.000	EA
4	0023	531.011653	GUIDE CUTTING HEAD CHAIN	3.000	EA
4	0024	531.019639	BRACKET COLLECTOR RING ATTACHMENT	1.000	EA
4	0200	031.018496	SEAL - BEARING HMS4 34mm X 60mm X	2.000	EA
4	0201	031.016884	BEARING -RADIAL BALL ER 30mm X 62mm	2.000	EA
4	0202	031.016315	FTG-COMPRESSION STRT	2.000	EA
4	0300	391710	KIT BRUSH HOLDER 4 RING METRIC		
4	0300	396187	KIT BRUSH HOLDER 4 RING METRIC CW		
4	0301	391709	04 ASSY COLLECTOR 4 RING METRIC	1.000	EA
4	0400	031.016885	SCREW-SOC. HD. - DOG PT. M6 X 9	2.000	EA
4	0401	310099	SCREW-FLAT SOC M6 X 25 SST	6.000	EA
4	0402	309393	01 WASHER-FLAT 8.4 X 16 X 1.6 SST	1.000	EA
4	0403	379458	SCREW-SET M8 X 40 SST	2.000	EA
4	0404	397007	SCREW-HEX HD M5 X 8 SST	4.000	EA
4	0405	397030	SCREW-SOC CAP M8 X 30 SST	2.000	EA
4	0406	397031	SCREW-SOC CAP M8 X 35 SST	3.000	EA
4	0407	397038	SCREW-FLAT SOC M6 X 16 SST	14.000	EA
4	0408	397063	NUT-HEX FULL M8 SST	6.000	EA
4	0409	397386	SST KEY 8MM X 7MM 25MM LG	1.000	EA
4	0410	401228	WASHER-FLAT 5.3 X 10 X 1 SST	12.000	EA
4	0411	407802	WASHER-FLAT THK 8.4 X 21 X 4 SST	3.000	EA
4	0412	422010	SCREW-HEX HD M5 X 10 SST	2.000	EA
4	0413	310108	SCREW-SOC CAP M6 X 25 SST	2.000	EA
4	0414	379749	WASHER-FLAT 6.4 X 12 X 1.6 SST	2.000	EA
4	0415	397011	SCREW-HEX HD M5 X 16 SST	2.000	EA
4	0416	397024	SCREW-SOC CAP M4 X 10 SST	2.000	EA
4	0417	408416	SCREW-SOC CAP M5 X 55 STL	2.000	EA
4	0418	409969	SCREW-HEX HD M6 X 14 SST	2.000	EA
4	0419	401118	WASHER-FLAT 4.3 X 9 X .8 SST	2.000	EA

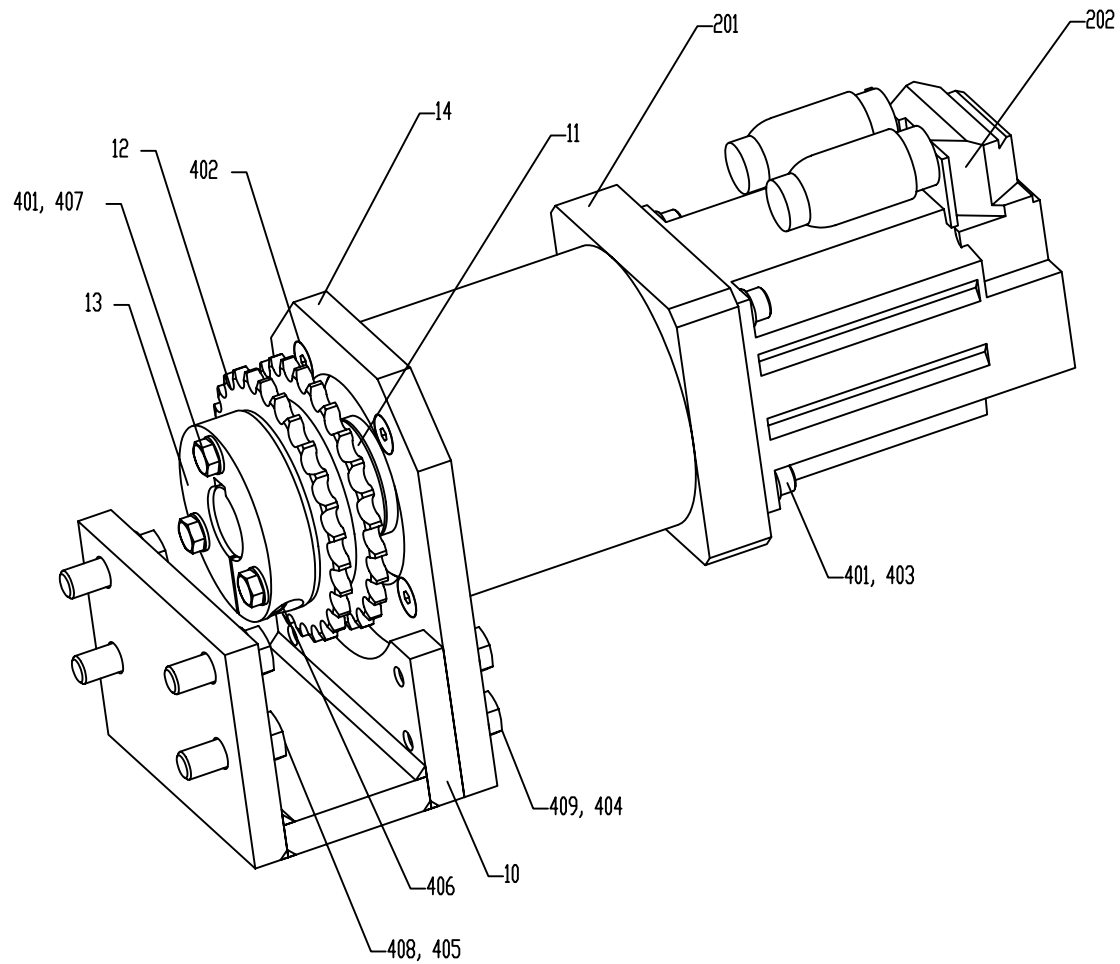


Cutting Lower Shaft	Drawn by	Roger Hefty	Date	16 Jun 2003
	Approved by	John Nelsner	Scale	1:2.5
	Checked by		Size	A2
		Sheet 1/1	H-Type	307
	231.026872		Rev:	0
BOSCH	Doboy Inc.		© Copyright Doboy Inc.	Based on Sigack International Design Standards

Qty.	Index	Description	Date	EDN No.	Changed by
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Material	C307	05	0010	Alt.	Usage 3
	Linium 6X1 Rotary Horizontal Wrapper				Valid
					09/26/2007
Reqd qty		1.000	EA	Base quant	1.000 EA
Sales ord.	129850			Item	000150

Lv	Item	Component no.	Description	Quant	Un
3	0000	131.026868	ASSY CUTTING HEAD MOTOR		
4	0001	231.026868	- Assy Cutting Head Motor		
4	0010	531.019654	02 BRACKET MOTOR ATTACHMENT	1.000	EA
4	0011	531.018154	SPACER DRIVE SPRKT	1.000	EA
4	0012	531.018151	SPROCKET 27T #40	1.000	EA
4	0013	531.018153	01 HUB DRIVE SPROCKET	1.000	EA
4	0014	531.019653	01 PLATE MOTOR ATTACHMENT	1.000	EA
4	0201	031.018150	GEAR-REDUCER INLINE LP120 15:1 RATIO	1.000	EA
4	0202	031.018109	MTR SERVO SC 42IN/LB 5000RPM		
4	0401	309393	01 WASHER-FLAT 8.4 X 16 X 1.6 SST	7.000	EA
4	0402	310112	SCREW-FLAT SOC M8 X 30 SST	4.000	EA
4	0403	310115	SCREW-SOC CAP M8 X 25 SST	4.000	EA
4	0404	310148	SCREW-HEX HD M10 X 30 SST	4.000	EA
4	0405	318909	SCREW-HEX HD M12 X 35 SST	4.000	EA
4	0406	379441	SCREW-SOC CAP M8 X 20 SST	1.000	EA
4	0407	397009	SCREW-HEX HD M8 X 40 SST	3.000	EA
4	0408	397069	WASHER-FLAT 13 X 24 X 2.5 SST	4.000	EA
4	0409	397080	WASHER-FLAT 10.5 X 20 X 2 SST	4.000	EA



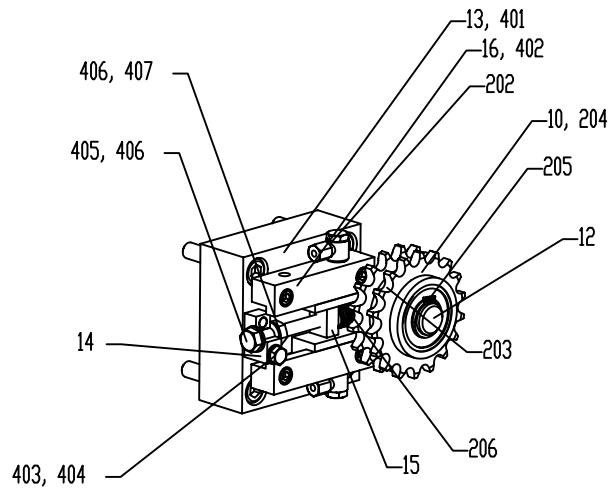
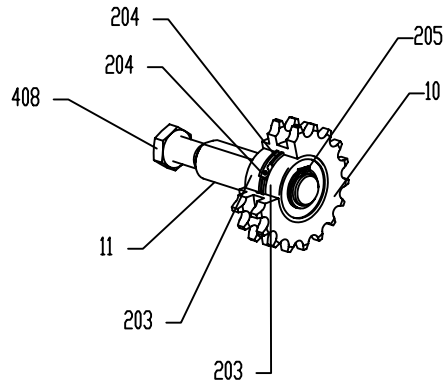
	Drawn by: John Meisner	Date: 14 Jan 2003
	Approved by: John Meisner	Scale: 1:2
Cutting Head Motor	Checked by: Gary Cummings	Size: A3
	Sheet: 1/1	M-Type: 307
Cabeza Motor	231.026868	Rev.: 0
BOSCH	Doboy Inc.	© Copyright Doboy Inc. Based on Sigpack International Design Standards

Qty.	Index	Description	Date	ECN No.	Changed by
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Material	C307	05 0010	Alt.	Usage 3
	Linium 6X1 Rotary Horizontal Wrapper			Valid 09/26/2007
Reqd qty	1.000 EA	Base quant	1.000 EA	
Sales ord.	129850	Item	000150	

Lv	Item	Component no.	Description	Quant	Un
3	0000	131.026869	KIT CUTTING HEAD CHAIN TIGHTENER		
4	0001	231.026869	KIT CUTTING HEAD CHAIN TIGHTENER	1.000	EA
4	0010	531.016853	SPROCKET IDLER 18 TOOTH #40	2.000	EA
4	0011	531.018144	01 SHAFT IDLER SPROCKET	1.000	EA
4	0012	531.013652	03 BRACKET - TENSIONER	1.000	EA
4	0013	531.018147	BLOCK TENSIONER MOUNT DR	1.000	EA
4	0014	531.011647	02 BRACKET - ADJUSTING SCREW	1.000	EA
4	0015	531.013654	NUT - CHAIN - ADJUST	1.000	EA
4	0016	531.016314	02 GUIDE IDLER BRACKET	2.000	EA
4	0202	031.016316	FITTING-COMPRESSION ELBOW M8X4MM TUB	2.000	EA
4	0203	950243	BEARING-RADIAL BALL 20 x 42 x 12	4.000	EA
4	0204	397376	RING-RTNG-INT 42HSG 1.75THK SST	4.000	EA
4	0205	397370	RING-RETAINING EXTERNAL 20 SST	2.000	EA
4	0206	031.018434	SPRING .625 - 11/32 - 2.00 - YELLOW	1.000	EA
4	0401	031.006382	SCREW-SOC CAP M10 X 50 SST	4.000	EA
4	0402	310108	SCREW-SOC CAP M6 X 25 SST	4.000	EA
4	0403	379749	WASHER-FLAT 6.4 X 12 X 1.6 SST	2.000	EA
4	0404	310103	SCREW-HEX HD M6 X 30 SST	2.000	EA
4	0405	395955	SCREW-HEX HD M8 X 90 SST	1.000	EA
4	0406	309393	01 WASHER-FLAT 8.4 X 16 X 1.6 SST	2.000	EA
4	0407	397063	NUT-HEX FULL M8 SST	1.000	EA
4	0408	031.000042	NUT-HEX JAM M16 SST	1.000	EA



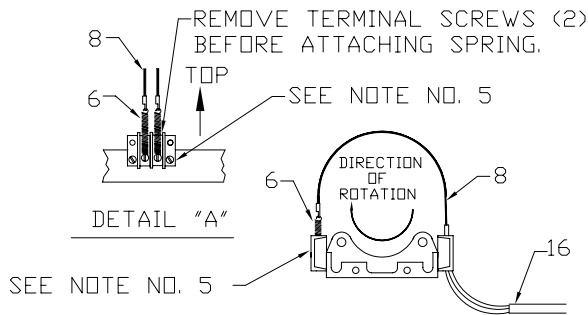
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Qty.	Index	Description	Date	ECN No.	Changed by

		Drawn by: John Meisner	Date: 14 Jan 2003
		Approved by: John Meisner	Scale: 1:3
Cutting Chain Tightener		Checked by: Gary Cummings	Size: A3
		Sheet: 1/1	M-Type: 307
		231.026869	Rev.: 1
BOSCH	Doboy Inc.	© Copyright Doboy Inc.	Based on Sigpack International Design Standards

Material	C307	05 0010	Alt.	Usage 3
	Linium 6X1 Rotary Horizontal Wrapper			Valid
				09/26/2007
Reqd qty	1.000 EA	Base quant	1.000 EA	
Sales ord.	129850	Item	000150	

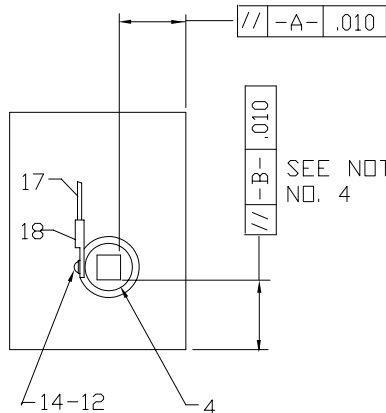
Lv	Item	Component no.	Description	Quant	Un
3	0000	396187	KIT BRUSH HOLDER 4 RING METRIC CW		
4	0000	173360	- reference drawing		
4	0001	550-00083	01 CAP, BRUSH HOLDER	2.000	EA
4	0002	549-06222	05 BRUSHES-CARBON .18X.18X11	2.000	EA
4	0003	898-14002	TERMINAL BLOCK 2 PLACE	2.000	EA
4	0004	550-00573	04 BRUSH HOLDERS 573	2.000	EA
4	0005	391680	BRUSH HOLDER METRIC	1.000	EA
4	0006	082-39032	03 SPRING EXT .187 .013 .500 MW	2.000	EA
4	0008	082-40465	02 ASSY, SILVER BRAID	2.000	EA
4	0011	952887	SCREW-SET M5 X 10 STL	2.000	EA
4	0012	352-47598-34	02 WASHER-STARLOCINT #4 STL	4.000	EA
4	0013	390081	SCREW-PAN-SLOT M3 X 10 STL	4.000	EA
4	0014	117519	03 SCREW-PAN-MACH #4-40 .125LG STL	2.000	EA
4	0015	952678	SCREW-SOC-CAP M5 X 16 STL	2.000	EA
4	0016	966-80622	06 WIRE, THERMOCOUPLE 24 GA.	4.000	FT
4	0017	532112	WIRE #16 MTW STRANDED BLACK	6.000	FT
4	0018	898-00616	02 TERMINAL-RING TONGUE	2.000	EA

CLASS CODE 14734



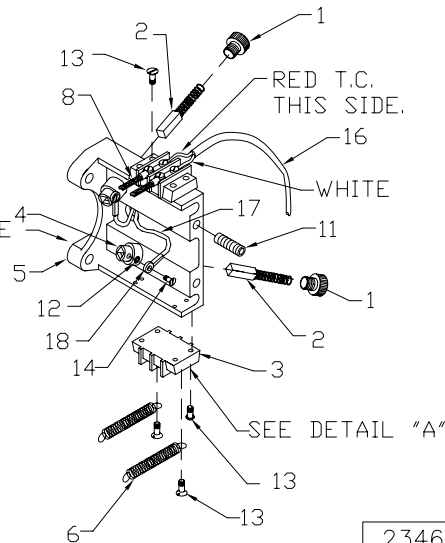
INSTALLATION NOTES

1. CORRECT INSTALLATION WILL ALLOW SPRING TO BE STRETCHED BY THE FRICTION OF THE BRAID ON THE COLLECTOR RING
2. THERMOCOUPLE WIRE IS TERMINATED ON THE OPPOSITE TERMINAL BLOCK THAN THE SPRING.
3. SEE DETAIL "A"
4. ITEM NO. 7 (2) AND NO. 15 USED TO MOUNT HOLDER TO MACHINE.
5. MOUNT TERM. BLK. TO BRUSH HOLDER USING BOTTOM HOLE ON TERM. BLK. TO TOP HOLE ON BRUSH HOLDER, USING ITEM NO. 13 (2) TYPICAL BOTH SIDES.



NOTE

1. AFTER TIGHTENING SCREW 14 FILE FLUSH TO ALLOW CLEARANCE FOR BRUSH.
2. DO NOT USE TERMINAL ENDS ON THERMOCOUPLE WIRE.

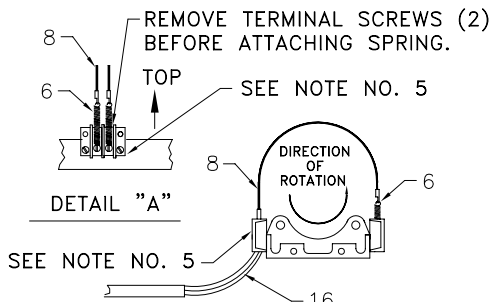


234608

UNLESS OTHERWISE SPECIFIED		Doboy		E		REVISED & REDRAWN		3-19-91		23933		MPO		MPO	
DEBURR & REMOVE ALL SHARP EDGES & CORNERS BY .004 TO .016		Doboy Packaging Machinery Inc. New Bedford, MA 04517		DRAWN		MIKE O'HARE		SYN		DESCRIPTION		DATE		E.C.N. BY APP. BY	
DIMENSIONS ARE IN INCHES UNLESS SHOWN OTHERWISE		CHECKED		B HEMAUER		APPROV.		ORV LUEHMAN		NAME		KIT BRUSH HOLDER		FIRST MACHINE CODE	
1 PLACE DEC # 1		2 PLACE DEC # .01		3 PLACE DEC # .010		ANGLES & T		SCALE NONE		DATE 3-19-91		030		C	
When filed in, this contains CONFIDENTIAL and PROPRIETARY INFORMATION of Doboy Packaging Machinery Inc.		MATERIAL		SEE B/M		FINISH PER ENGR. SPEC. #						234608			

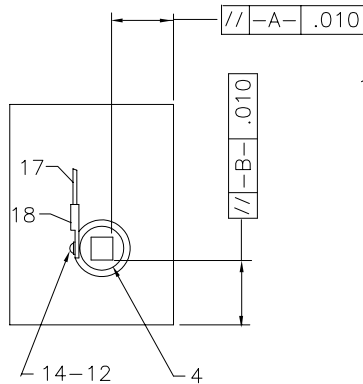
Material	C307	05 0010	Alt.	Usage 3
	Linium 6X1 Rotary Horizontal Wrapper			Valid 09/26/2007
Reqd qty	1.000 EA	Base quant	1.000 EA	
Sales ord.	129850	Item	000150	

Lv	Item	Component no.	Description	Quant	Un
3	0000	391710	KIT BRUSH HOLDER 4 RING METRIC		
4	0001	550-00083	01 CAP, BRUSH HOLDER	2.000	EA
4	0002	549-06222	05 BRUSHES-CARBON .18X.18X11	2.000	EA
4	0003	898-14002	TERMINAL BLOCK 2 PLACE	2.000	EA
4	0004	550-00573	04 BRUSH HOLDERS 573	2.000	EA
4	0005	391680	BRUSH HOLDER METRIC	1.000	EA
4	0006	082-39032	03 SPRING EXT .187 .013 .500 MW	2.000	EA
4	0008	082-40465	02 ASSY, SILVER BRAID	2.000	EA
4	0011	952887	SCREW-SET M5 X 10 STL	2.000	EA
4	0012	352-47598-34	02 WASHER-STARLOCINT #4 STL	4.000	EA
4	0013	390081	SCREW-PAN-SLOT M3 X 10 STL	4.000	EA
4	0014	117519	03 SCREW-PAN-MACH #4-40 .125LG STL	2.000	EA
4	0015	310093	SCREW-SOC-CAP M5 X 16 SST	2.000	EA
4	0016	966-80622	06 WIRE, THERMOCOUPLE 24 GA.	4.000	FT
4	0017	532112	WIRE #16 MTW STRANDED BLACK	6.000	FT
4	0018	898-00616	02 TERMINAL-RING TONGUE	2.000	EA



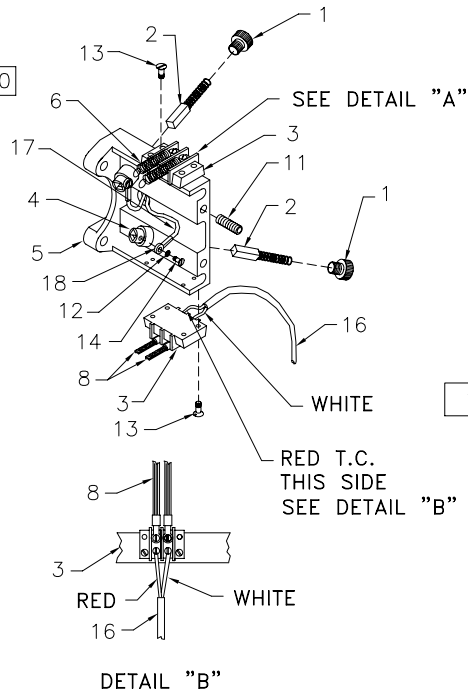
INSTALLATION NOTES

1. CORRECT INSTALLATION WILL ALLOW SPRING TO BE STRETCHED BY THE FRICTION OF THE BRAID ON THE COLLECTOR RING
2. THERMOCOUPLE WIRE IS TERMINATED ON THE OPPOSITE TERMINAL BLOCK THAN THE SPRING.
3. SEE DETAIL "A"
4. ITEM NO. 15 (2) USED TO MOUNT HOLDER TO MACHINE.
5. MOUNT TERM. BLK TO BRUSH HOLDER USING BOTTOM HOLE ON TERM. BLK. TO TOP HOLE ON BRUSH HOLDER, USING ITEM NO. 13 (2) TYPICAL BOTH SIDES.



NOTE

1. AFTER TIGHTENING SCREW 14 FILE FLUSH TO ALLOW CLEARANCE FOR BRUSH.
2. DO NOT USE TERMINAL ENDS ON THERMOCOUPLE WIRE.

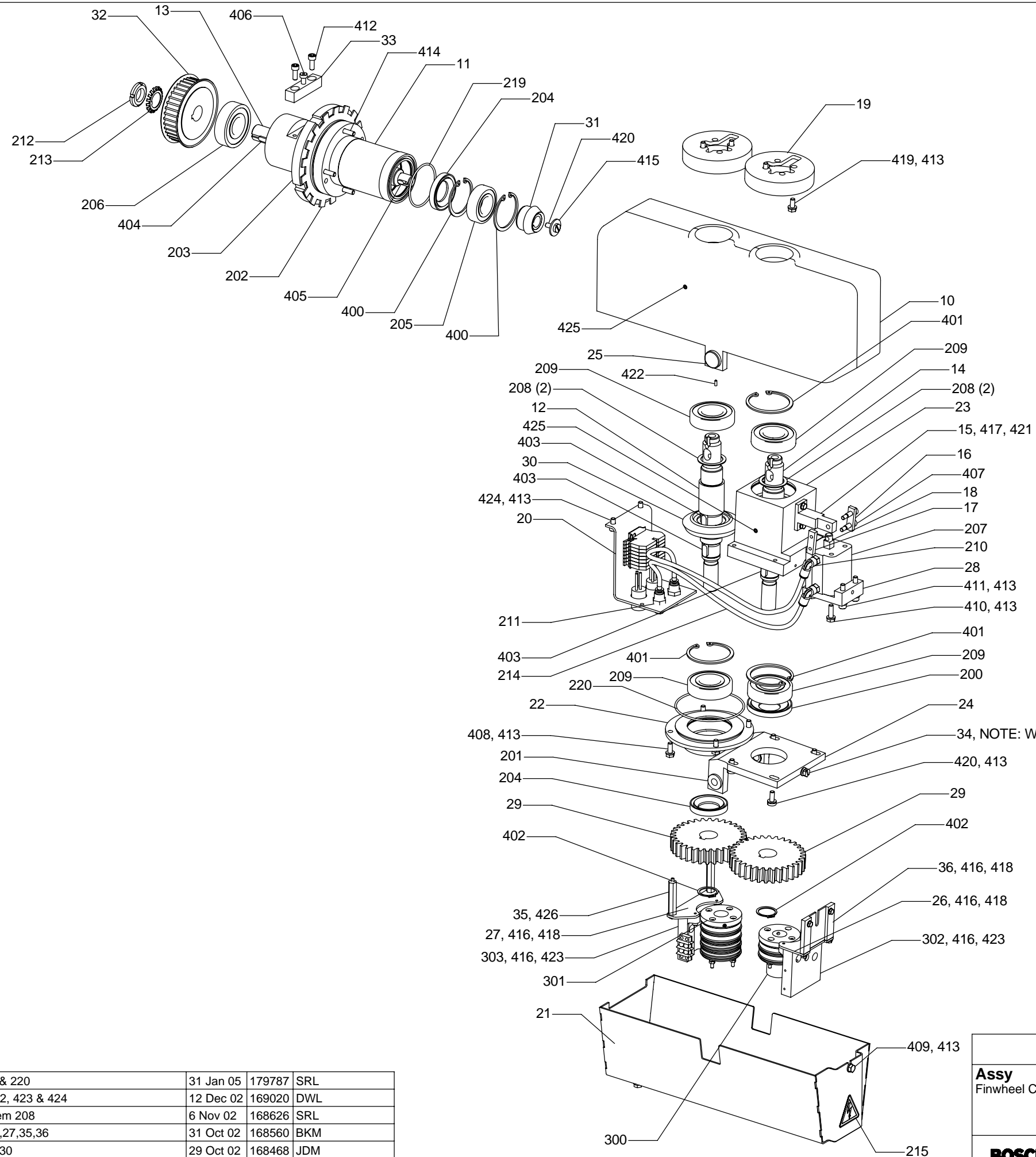


UNLESS OTHERWISE SPECIFIED		Doboy		L	REVISED PER ECN	3-4-94	57566	MPO	BH
DEBURR & REMOVE ALL SHARP EDGES & CORNERS BY .004 TO .016		Doboy Packaging Machinery Inc. New Richmond, WI 54017		I	REFILM	10-15-91	29502	BJ	RLM
DRAWN MIKE O'HARE		SYM	DESCRIPTION	DATE	E.C.N.	BY	APP. BY		
DIMENSIONS ARE IN INCHES UNLESS OTHERWISE SPECIFIED		CHECKED ORV LUEHMAN		NAME		FIRST MACHINE CODE		DWG. SIZE	
1 PLACE DEC & 1	2 PLACE DEC & .01	APPLY'D. ORV LUEHMAN		KIT BRUSH HOLDER		030		C	
ANGLES & 1"	3 PLACE DEC & .001	SCALE	NONE	DATE	10-15-91				
When filed in, this contains CONFIDENTIAL and PROPRIETARY INFORMATION of Doboy Packaging Machinery Inc.		MATERIAL		SEE B/M					
		FINISH PER ENGR. SPEC. #		136547					

Material	C307	05	0010	Alt.	Usage 3
	Linium 6X1 Rotary Horizontal Wrapper				Valid
					09/26/2007
Reqd qty		1.000	EA	Base quant	1.000 EA
Sales ord.	129850			Item	000150

Lv	Item	Component no.	Description	Quant	Un
3	0000	131.008930	ASSY FINWHEEL CAST HOT		
4	0001	231.008930			
4	0010	531.015400	01 HOUSING FINWHEEL	2.000	EA
4	0011	531.015556	05 TUBE FINWHEEL PIVOT	2.000	EA
4	0012	531.028182	01 SHAFT-FINWHEEL FIXED	2.000	EA
4	0013	531.018715	01 SHAFT FINWHEEL DRIVE	2.000	EA
4	0014	531.018716	02 SHAFT FINWHEEL PIVOT	2.000	EA
4	0015	531.018721	01 BLOCK PIVOT ATTACHMENT	2.000	EA
4	0016	531.018722	01 LINK AIR CYLINDER	2.000	EA
4	0017	531.018723	01 LINK AIR CYLINDER TAPPED	2.000	EA
4	0018	531.018724	01 LINK PIVOT	2.000	EA
4	0019	531.008768	01 SHIELD HEAT	4.000	EA
4	0020	531.008769	BRACKET ELECTRICAL ATTACHMENT	2.000	EA
4	0021	531.008766	03 GUARD FINWHEEL COLLECTOR RING HOT	2.000	EA
4	0022	531.013625	01 CAP GEAR ENCLOSURE	2.000	EA
4	0023	531.013626	01 BLOCK BEARING PIVOT	2.000	EA
4	0024	531.026230	BLOCK FINWHEEL PIVOT	2.000	EA
4	0025	531.026231	01 STUD PIVOT	4.000	EA
4	0026	531.028322	PLATE-MOUNT-BRUSH HOLDER	2.000	EA
4	0027	531.028321	PLATE-MOUNT-BRUSH HOLDER	2.000	EA
4	0028	531.013631	BLOCK CYLINDER ATTACHMENT	2.000	EA
4	0029	531.014957	GEAR MOD 3 33T NYLON 6	4.000	EA
4	0030	531.028183	GEAR-BEVEL	2.000	EA
4	0031	531.018711	02 GEAR-BEVEL	2.000	EA
4	0032	531.018945	PULLEY, TIMING HTD 8M36X20	2.000	EA
4	0033	531.018727	01 BLOCK FINWHEEL ADJUST	2.000	EA
4	0034	531.021193	01 SCREW MODIFIED	2.000	EA
4	0035	531.028320	STAND-OFF	4.000	EA
4	0036	531.028323	PLATE-MOUNT-HOLDER PLATE	2.000	EA
4	0200	031.008770	SEAL-SHAFT 30 x 62 x 7 CRS	2.000	EA
4	0201	031.026229	BEARING-FLANGE 10 X 16 X 16	4.000	EA
4	0202	031.013647	LOCKWASHER-105 x 145 x 1.8	2.000	EA
4	0203	531.021140	LOCK NUT M105x2	2.000	EA
4	0204	031.015549	SEAL SHAFT 30 x 52 x 8 CRS	4.000	EA
4	0205	031.000210	BEARING-RADIAL BALL 25x52x15	2.000	EA
4	0206	031.018713	BEARING-RADIAL BALL 25x62x17	2.000	EA
4	0207	031.018718	AIR-CYLINDER 32mm BORE 15mm STROKE	2.000	EA
4	0208	320048	WASHER-WAVE 1.201 X 1.543 X .017	8.000	EA
4	0209	352035	02 BEARING-RADIAL BALL 30x62x16 HI-TEMP	8.000	EA
4	0210	432287	CONNECTOR-ELBOW MALE R1/8 TO 6mm TUB	4.000	EA
4	0211	031.001414	CONNECTOR-BULKHEAD 6MM TUBE	4.000	EA
4	0212	531.021139	LOCK NUT M22x1	2.000	EA
4	0213	031.015543	LOCKWASHER MB044-22MM BORE	2.000	EA
4	0214	370719	PA TUBE (NYLON) PNEUMATIC 6mm OD	2.000	M
4	0215	379793	DECAL-ELECTRICAL HAZARD	2.000	EA
4	0219	031.041633	O-RING (NB-70) 58x2.5	2.000	EA
4	0220	031.041634	01 O-RING (NB-70) 90x2.5	2.000	EA
4	0300	391707	04 ASSY COLLECTOR 2 RING METRIC	2.000	EA

4	0301	391709	04	ASSY COLLECTOR 4 RING METRIC	2.000	EA
4	0302	391708	02	KIT BRUSH HOLDER 2 RING METRIC	2.000	EA
4	0303	391710	03	KIT BRUSH HOLDER 4 RING METRIC	2.000	EA
4	0400	407596		CIRCLIP 52 X 2 SST	4.000	EA
4	0401	407597		RING-RTNG-INT 62HSG 2.0THK SST	6.000	EA
4	0402	407600		RING-RTNG EXT 25DIA 1.2THK SST	4.000	EA
4	0403	031.000189		KEY-8 X 7 X 18 SST	6.000	EA
4	0404	397384		KEY-6 X 6 X 25 SST	2.000	EA
4	0405	418744		KEY-5 X 5 X 10 SST	2.000	EA
4	0406	397050		SCREW-SHOULDER 6/M5 X 10 SST	2.000	EA
4	0407	452135		SCREW-SHOULDER 6/M5 X16 SST	4.000	EA
4	0408	309391		SCREW-HEX HD M6 X 16 SST	8.000	EA
4	0409	309392		SCREW-HEX HD M6 X 8 SST	6.000	EA
4	0410	310098		SCREW-HEX HD M6 X 20 SST	8.000	EA
4	0411	310101		SCREW-SOC CAP M6 X 30 SST	4.000	EA
4	0412	310107		SCREW-SOC CAP M6 X 16 SST	4.000	EA
4	0413	379749		WASHER-FLAT 6.4 X 12 X 1.6 SST	46.000	EA
4	0414	397018		SCREW-SOC CAP M6 X 50 SST	8.000	EA
4	0415	397070		WASHER-FLAT 8.4 X 24 X 2 SST	2.000	EA
4	0416	401118		WASHER-FLAT 4.3 X 9 X .8 SST	20.000	EA
4	0417	401228		WASHER-FLAT 5.3 X 10 X 1 SST	4.000	EA
4	0418	407551		SCREW-HEX HD M4 X 10 SST	12.000	EA
4	0419	409969		SCREW-HEX HD M6 X 14 SST	8.000	EA
4	0420	421926		SCREW-PAN-SLOT M6 X 16 SST	10.000	EA
4	0421	422010		SCREW-HEX HD M5 X 10 SST	4.000	EA
4	0422	031.027322		SCREW-SET M3 X 8MM LG . SST	4.000	EA
4	0423	397025		SCREW-SOC CAP M4 X 12 SST	8.000	EA
4	0424	397029		SCREW-SOC CAP M6 X 12 SST	4.000	EA
4	0425	952893		SCREW-SET M6 X 10 STL	8.000	EA
4	0426	400208		SCREW-SET M4 X 12 SST	4.000	EA



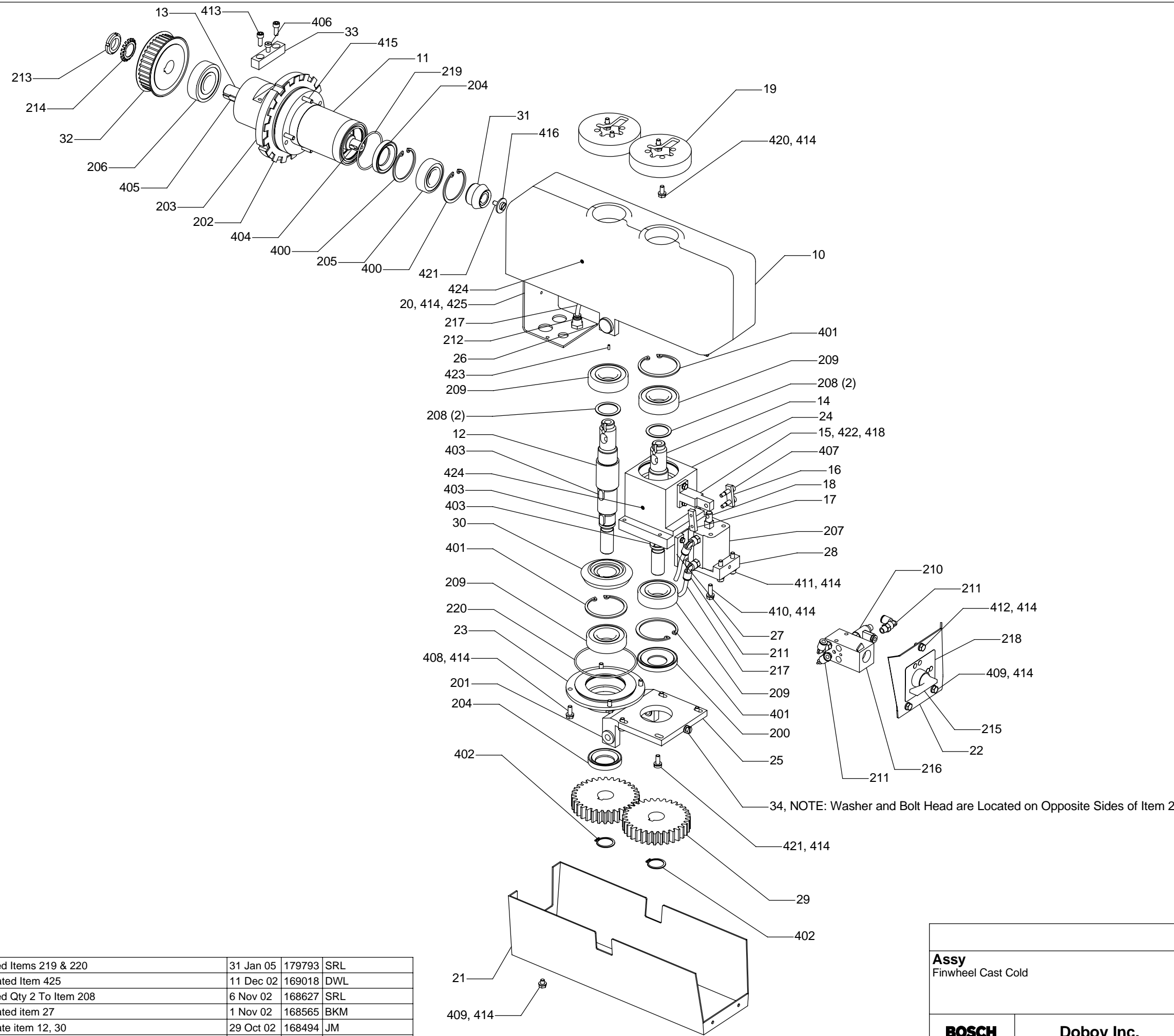
Qty.	Index	Description	Date	ECN No.	Changed by
0	5	Added Items 219 & 220	31 Jan 05	179787	SRL
0	4	Updated Items 422, 423 & 424	12 Dec 02	169020	DWL
0	3	Added Qty 2 to Item 208	6 Nov 02	168626	SRL
0	2	Updated items 26,27,35,36	31 Oct 02	168560	BKM
0	1	Update items 12, 30	29 Oct 02	168468	JDM

Assy Finwheel Cast Hot		Drawn by: Roger Hefty	Date: 01 Nov 2002
		Approved by: Roger Hefty	Scale: 1:4
BOSCH		Checked by: Barb Hemauer	Size: A2
		Sheet: 1/1	M-Type: 307
SIG Doboy Inc.		231.008930	
		Rev.: 5	
© Copyright SIG Doboy Inc.		Based on SIG Pack International Design Standards	

Material	C307	05 0010	Alt.	Usage 3
	Linium 6X1 Rotary Horizontal Wrapper			Valid
				09/26/2007
Reqd qty		1.000 EA	Base quant	1.000 EA
Sales ord.	129850		Item	000150

Lv	Item	Component no.	Description	Quant	Un
3	0000	131.008931	ASSY FINWHEEL CAST COLD		
4	0001	231.008931			
4	0010	531.015400	01 HOUSING FINWHEEL	1.000	EA
4	0011	531.015556	05 TUBE FINWHEEL PIVOT	1.000	EA
4	0012	531.028182	01 SHAFT-FINWHEEL FIXED	1.000	EA
4	0013	531.018715	01 SHAFT FINWHEEL DRIVE	1.000	EA
4	0014	531.018716	02 SHAFT FINWHEEL PIVOT	1.000	EA
4	0015	531.018721	01 BLOCK PIVOT ATTACHMENT	1.000	EA
4	0016	531.018722	01 LINK AIR CYLINDER	1.000	EA
4	0017	531.018723	01 LINK AIR CYLINDER TAPPED	1.000	EA
4	0018	531.018724	01 LINK PIVOT	1.000	EA
4	0019	531.008768	01 SHIELD HEAT	2.000	EA
4	0020	531.008769	BRACKET ELECTRICAL ATTACHMENT	1.000	EA
4	0021	531.008767	01 GUARD FINWHEEL COLLECTOR RING	1.000	EA
4	0022	531.008763	PLATE VALVE ATTACHMENT	1.000	EA
4	0023	531.013625	01 CAP GEAR ENCLOSURE	1.000	EA
4	0024	531.013626	01 BLOCK BEARING PIVOT	1.000	EA
4	0025	531.026230	BLOCK FINWHEEL PIVOT	1.000	EA
4	0026	531.026231	01 STUD PIVOT	2.000	EA
4	0027	531.028323	PLATE-MOUNT-HOLDER PLATE	1.000	EA
4	0028	531.013631	BLOCK CYLINDER ATTACHMENT	1.000	EA
4	0029	531.014957	GEAR MOD 3 33T NYLON 6	2.000	EA
4	0030	531.028183	GEAR-BEVEL	1.000	EA
4	0031	531.018711	02 GEAR-BEVEL	1.000	EA
4	0032	531.018945	PULLEY, TIMING HTD 8M36X20	1.000	EA
4	0033	531.018727	01 BLOCK FINWHEEL ADJUST	1.000	EA
4	0034	531.021193	01 SCREW MODIFIED	1.000	EA
4	0200	031.008770	SEAL-SHAFT 30 x 62 x 7 CRS	1.000	EA
4	0201	031.026229	BEARING-FLANGE 10 X 16 X 16	2.000	EA
4	0202	031.013647	LOCKWASHER-105 x 145 x 1.8	1.000	EA
4	0203	531.021140	LOCK NUT M105x2	1.000	EA
4	0204	031.015549	SEAL SHAFT 30 x 52 x 8 CRS	2.000	EA
4	0205	031.000210	BEARING-RADIAL BALL 25x52x15	1.000	EA
4	0206	031.018713	BEARING-RADIAL BALL 25x62x17	1.000	EA
4	0207	031.018718	AIR-CYLINDER 32mm BORE 15mm STROKE	1.000	EA
4	0208	320048	WASHER-WAVE 1.201 X 1.543 X .017	4.000	EA
4	0209	352035	02 BEARING-RADIAL BALL 30x62x16 HI-TEMP	4.000	EA
4	0210	432407	01 VALVE-FLOW CONTROL G1/8	1.000	EA
4	0211	432287	CONNECTOR-ELBOW MALE R1/8 TO 6mm TUB	5.000	EA
4	0212	031.001414	CONNECTOR-BULKHEAD 6MM TUBE	1.000	EA
4	0213	531.021139	LOCK NUT M22x1	1.000	EA
4	0214	031.015543	LOCKWASHER MB044-22MM BORE	1.000	EA
4	0215	407188	ACTUATOR-SELECTOR SWITCH	1.000	EA
4	0216	031.018717	VALVE-4 WAY 2 POSITION	1.000	EA
4	0217	370719	PA TUBE (NYLON) PNEUMATIC 6mm OD	1.000	M
4	0218	031.003721	02 DECAL COLD FINWHEEL ICONS	1.000	EA
4	0219	031.041633	O-RING (NB-70) 58x2.5	1.000	EA
4	0220	031.041634	01 O-RING (NB-70) 90x2.5	1.000	EA

4	0400	407596	CIRCLIP 52 X 2 SST	2.000	EA
4	0401	407597	RING-RTNG-INT 62HSG 2.0THK SST	3.000	EA
4	0402	407600	RING-RTNG EXT 25DIA 1.2THK SST	2.000	EA
4	0403	031.000189	KEY-8 X 7 X 18 SST	3.000	EA
4	0404	418744	KEY-5 X 5 X 10 SST	1.000	EA
4	0405	397384	KEY-6 X 6 X 25 SST	1.000	EA
4	0406	397050	SCREW-SHOULDER 6/M5 X 10 SST	1.000	EA
4	0407	452135	SCREW-SHOULDER 6/M5 X16 SST	2.000	EA
4	0408	309391	SCREW-HEX HD M6 X 16 SST	4.000	EA
4	0409	309392	SCREW-HEX HD M6 X 8 SST	4.000	EA
4	0410	310098	SCREW-HEX HD M6 X 20 SST	4.000	EA
4	0411	310101	SCREW-SOC CAP M6 X 30 SST	2.000	EA
4	0412	310102	SCREW-HEX HD M6 X 12 SST	1.000	EA
4	0413	310107	SCREW-SOC CAP M6 X 16 SST	2.000	EA
4	0414	379749	WASHER-FLAT 6.4 X 12 X 1.6 SST	25.000	EA
4	0415	397018	SCREW-SOC CAP M6 X 50 SST	4.000	EA
4	0416	397070	WASHER-FLAT 8.4 X 24 X 2 SST	1.000	EA
4	0417	401118	WASHER-FLAT 4.3 X 9 X .8 SST	2.000	EA
4	0418	401228	WASHER-FLAT 5.3 X 10 X 1 SST	2.000	EA
4	0419	407551	SCREW-HEX HD M4 X 10 SST	2.000	EA
4	0420	409969	SCREW-HEX HD M6 X 14 SST	4.000	EA
4	0421	421926	SCREW-PAN-SLOT M6 X 16 SST	5.000	EA
4	0422	422010	SCREW-HEX HD M5 X 10 SST	2.000	EA
4	0423	031.027322	SCREW-SET M3 X 8MM LG . SST	2.000	EA
4	0424	952893	SCREW-SET M6 X 10 STL	4.000	EA
4	0425	397029	SCREW-SOC CAP M6 X 12 SST	2.000	EA



Qty.	Index	Description	Date	ECN No.	Changed by
0	5	Added Items 219 & 220	31 Jan 05	179793	SRL
0	4	Updated Item 425	11 Dec 02	169018	DWL
0	3	Added Qty 2 To Item 208	6 Nov 02	168627	SRL
0	2	Updated item 27	1 Nov 02	168565	BKM
0	1	Update item 12, 30	29 Oct 02	168494	JM

Assy Finwheel Cast Cold		Drawn by: Roger Hefty	Date: 01 Nov 2002
		Approved by: Roger Hefty	Scale: 1:4
BOSCH		Checked by: Barb Hemauer	Size: A2
		Sheet: 1/1	M-Type: 307
Doboy Inc.		231.008931	
		Rev.: 5	
© Copyright Doboy Inc.		Based on SIG Pack International Design Standards	

Material	C307	05 0010	Alt.	Usage 3
	Linium 6X1 Rotary Horizontal Wrapper			Valid 09/26/2007
Reqd qty	1.000 EA	Base quant	1.000 EA	
Sales ord.	129850	Item	000150	

lv	Item	Component no.	Description	Quant	Un
3	0000	491635	KIT SENSOR TERMINAL BLOCK		
4	0001	491624	TERM BLOCK SENSOR BASE	15.000	EA
4	0002	491625	SENSOR DIST. BLOCK BLUE	15.000	EA
4	0003	491626	SENSOR DIST. BLOCK BROWN	15.000	EA

Material	C307	05 0010	Alt.	Usage 3
	Linium 6X1 Rotary Horizontal Wrapper			Valid 09/26/2007
Reqd qty	1.000 EA	Base quant	1.000 EA	
Sales ord.	129850	Item	000150	

Lv	Item	Component no.	Description	Quant	Un
4	0000	391709	ASSY COLLECTOR 4 RING METRIC		
5	0001	391702	03 COLLECTOR RING METRIC	2.000	EA
5	0002	305412	02 INSULATOR-COLLECTOR RING	4.000	EA
5	0003	391701	03 HUB COLLECTOR RING METRIC	1.000	EA
5	0004	391704	SCREW-CHEESE-HD M4 X 70 BRASS	4.000	EA
5	0005	391706	NUT-HEX HD M4 BRASS	8.000	EA
5	0006	397056	SCREW-SET M5 X 16 SST	1.000	EA
5	0007	352-47598-36	WASHER-STARLOCINT #8 STL	4.000	EA
5	0008	391711	ASSY COLLECTOR RING METRIC	2.000	EA

Material	C307	05 0010	Alt.	Usage 3
	Linium 6X1 Rotary Horizontal Wrapper			Valid 09/26/2007
Reqd qty	1.000 EA	Base quant	1.000 EA	
Sales ord.	129850	Item	000150	

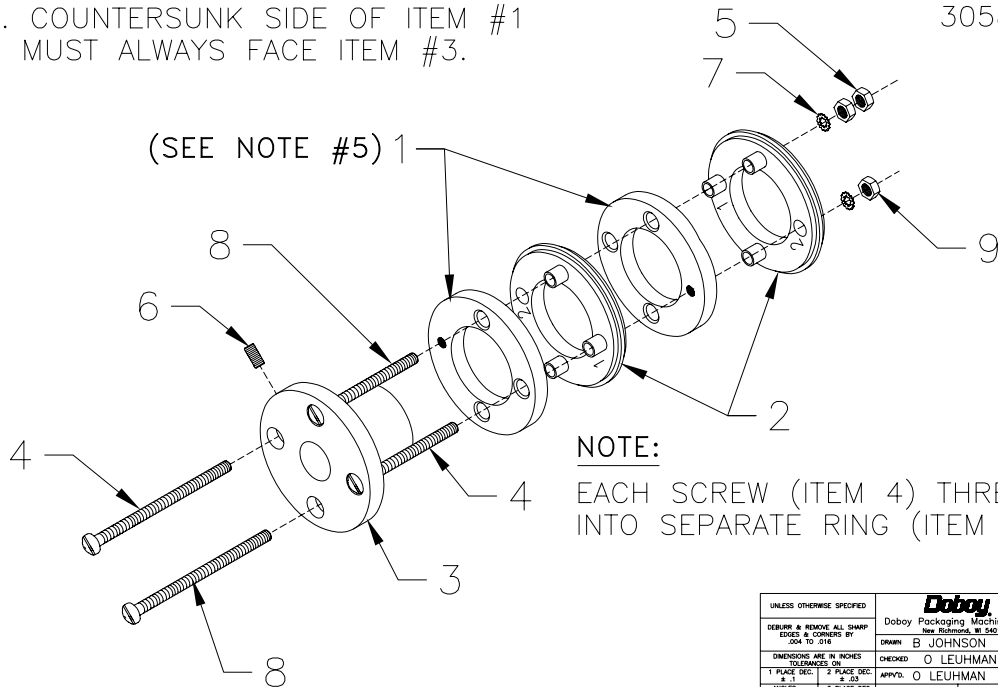
Lv	Item	Component no.	Description	Quant	Un
4	0000	391707	ASSY COLLECTOR 2 RING METRIC		
5	0001	391702	03 COLLECTOR RING METRIC	4.000	EA
5	0002	305413	03 HUB COLLECTOR RING	4.000	EA
5	0003	391701	03 HUB COLLECTOR RING METRIC	2.000	EA
5	0004	391705	SCREW-CHEESE-HD M4 X 40 BRASS	4.000	EA
5	0005	391706	NUT-HEX HD M4 BRASS	8.000	EA
5	0006	397056	SCREW-SET M5 X 16 SST	2.000	EA
5	0007	352-47598-36	WASHER-STARLOCINT #8 STL	8.000	EA
5	0008	379771	SCREW-PAN-SLOT M4 X 40 STL	4.000	EA
5	0009	952795	NUT-HEX-FULL M4 STL	4.000	EA

NOTES:

1. ALL RINGS MUST BE FREE OF METAL SHAVINGS.
2. HIPOT EACH COLLECTOR RING TO EVERY OTHER RING AT 1500VAC.
3. USE STAR WASHERS ONLY. (DO NOT USE FLAT WASHERS)
4. CHECK CONTINUITY BETWEEN COLLECTOR RING AND SCREW. MUST BE LESS THAN 1.0 OHM
5. COUNTERSUNK SIDE OF ITEM #1 MUST ALWAYS FACE ITEM #3.

REF B/M'S:

305853	.625	DIA HUB BORE
305854	.750	DIA HUB BORE
305855	.734	DIA HUB BORE
305856	.750	DIA HUB BORE
305857	.710	DIA HUB BORE
305858	1.001	DIA HUB BORE



(SEE NOTE #5) 1

NOTE:

EACH SCREW (ITEM 4) THREADS INTO SEPARATE RING (ITEM 1)

305852

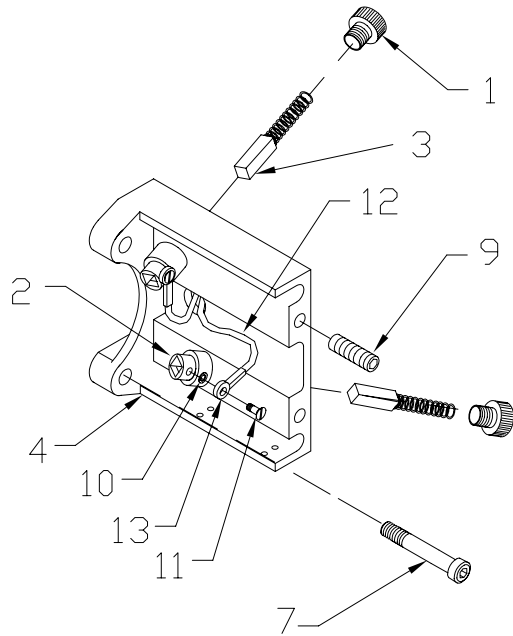
UNLESS OTHERWISE SPECIFIED		Doboy		D	ADDED NOTE 5 TO ITEM 1	2-3-98	21246	RCL	
DEBURR & REMOVE ALL SHARP EDGES & CORNERS BY .004 TO .016		Doboy Packaging Machinery Inc. New Richmond, WI 54027		C	ADDED NOTE 3 & 4	12-23-97	20459	RCL	LH
DIMENSIONS ARE IN INCHES TOLERANCES ON		DRAWN B JOHNSON		B	ADDED NOTE 1 & 2	6-15-91	REFILM	MPO	OL
1 PLACE DEC # .1		CHECKED O LEUHMANN		SYM	DESCRIPTION	DATE	E.C.N.	BY	APP. BY
2 PLACE DEC # .01		APPROV O LEUHMANN		NAME			DWG COLLECTOR RING		FIRST MACHINE CODE
3 PLACE DEC # .010		SCALE NONE		DATE 2-26-91			106		C
ANGLES 8° ± .1°		When filed in, this contains CONFIDENTIAL and PROPRIETARY INFORMATION of Doboy Packaging Machinery Inc.		MATERIAL SEE B/M			305852		
				FINISH PER ENGR.SPEC. #					

Material	C307	05 0010	Alt.	Usage 3
	Linium 6X1 Rotary Horizontal Wrapper			Valid 09/26/2007
Reqd qty	1.000 EA	Base quant	1.000 EA	
Sales ord.	129850	Item	000150	

Lv	Item	Component no.	Description	Quant	Un
4	0000	391708	KIT BRUSH HOLDER 2 RING METRIC		
5	0001	550-00083	01 CAP, BRUSH HOLDER	4.000	EA
5	0002	550-00573	04 BRUSH HOLDERS 573	4.000	EA
5	0003	549-06222	05 BRUSHES-CARBON .18X.18X11	4.000	EA
5	0004	391680	BRUSH HOLDER METRIC	2.000	EA
5	0007	310093	SCREW-SOC-CAP M5 X 16 SST	4.000	EA
5	0009	952887	SCREW-SET M5 X 10 STL	4.000	EA
5	0010	352-47598-34	02 WASHER-STARLOCINT #4 STL	4.000	EA
5	0011	117519	03 SCREW-PAN-MACH #4-40 .125LG STL	4.000	EA
5	0012	532112	WIRE #16 MTW STRANDED BLACK	12.000	FT
5	0013	898-00616	02 TERMINAL-RING TONGUE	4.000	EA

136546

CLASS CODE 14734



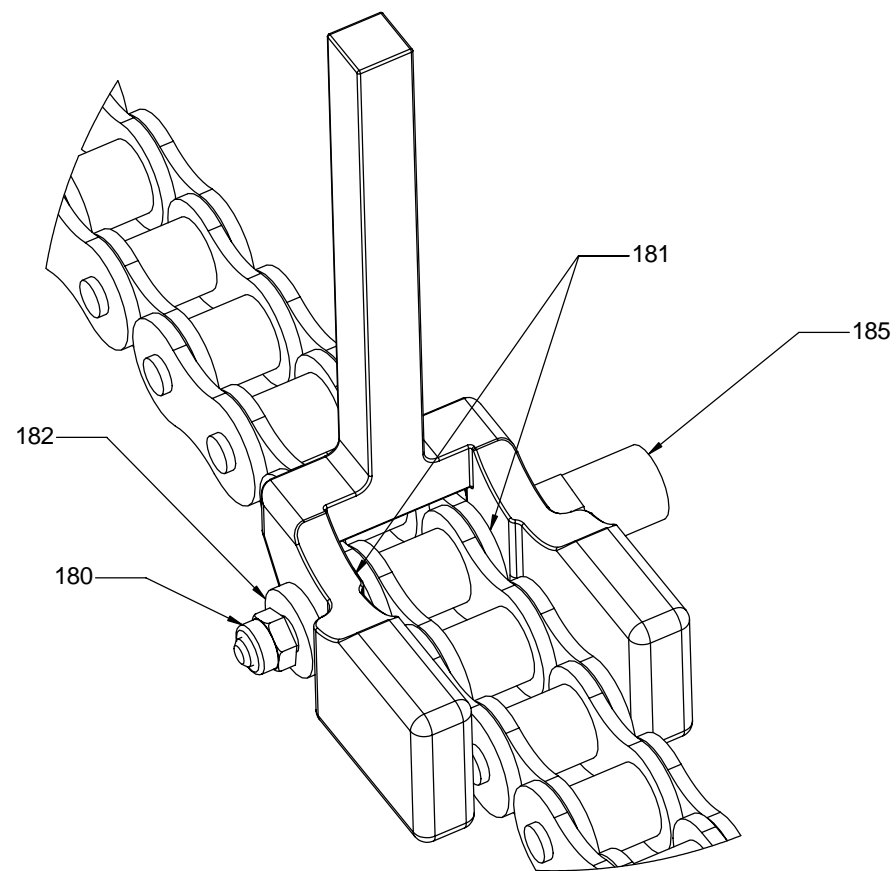
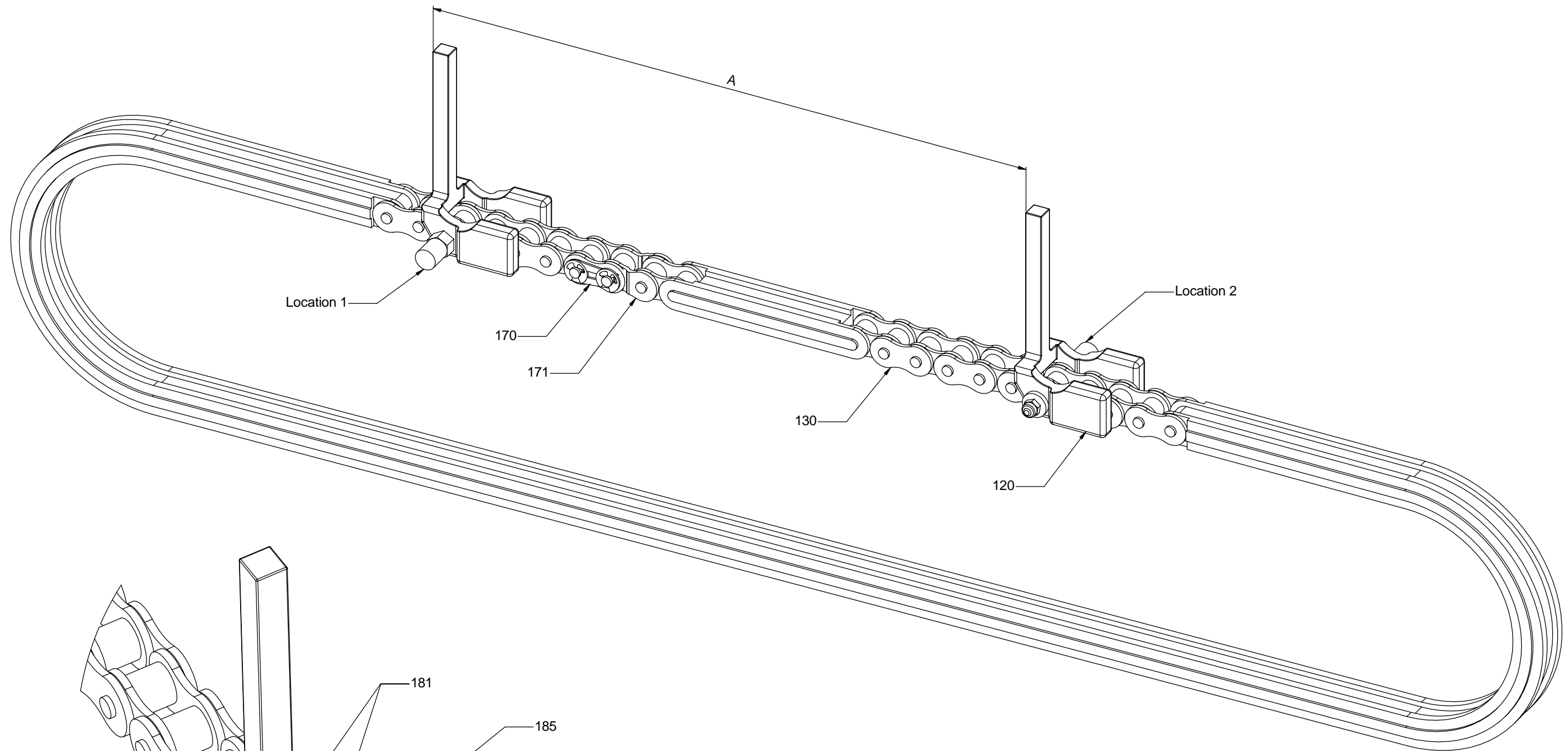
UNLESS OTHERWISE SPECIFIED		Doboy Doboy Packaging Machinery Inc. New Richmond, WI 54017							
DEBURR & REMOVE ALL SHARP EDGES & CORNERS BY .004 TO .016		DRAWN MIKE O'HARE		SYM	DESCRIPTION	DATE	E.C.N.	BY	APP. BY
DIMENSIONS ARE IN INCHES TOLERANCES ON		CHECKED J.H. PIEPER							
1 PLACE DEC. ± .1	2 PLACE DEC. ± .03	APPV'D. ORV LUEHMAN		NAME KIT BRUSH HOLDER 2 RING			FIRST MACHINE CODE 030	DWG. SIZE B	
ANGLES ± 1°	3 PLACE DEC. ± .010	SCALE NONE	DATE 3-11-91	MATERIAL SEE B/M			136546		
When filled in, this contains CONFIDENTIAL and PROPRIETARY INFORMATION of Doboy Packaging Machinery Inc.				FINISH PER ENGR.SPEC. #					

Material	C282	01	0010	Alt.	Usage 3
	Linium Infeed Conveyor			Valid	10/01/2007
Reqd qty	1.000	EA	Base quant	1.000	EA
Sales ord.	129850		Item	000340	

Lv	Item	Component no.	Description	Quant	Un
1	0001		KRAFT FOODS INC. NEW ULM PLT.		
1	0002		07-27773		
1	0003		Testing		
1	0004		Electrical Specification		
1	0005		Mechanical Engineer (M Rogers)		
1	0006		Electrical Engineer Dennis Neck/Rod Cain		
1	0007	431.063136	WIRING DIAGRAM LINIUM 611	1.000	EA
1	0019		Silicone Required		
1	0020	C_CHAIN_E	Infeed Chain Assembly	1.000	EA
1	0021	C282E	Linium Infeed Engineering Configurat	1.000	EA
1	0110	131.049241	02 ASSY-RECV CNVR-SST	1.000	EA
1	0120	131.034651	KIT-GUARDS DELFI RECV CNVR LR	1.000	EA
1	0125	131.042678	KIT-ENCODER DRIVE-DELFI INFEED	1.000	EA
1	0140	131.062454	ASSY INFD CNVR DELFI TAIL .4M SST	1.000	EA
1	0160	131.061144	ASSY-INFEED CNVR W/REJECT 1.5M LR SS	1.000	EA
1	0170	131.062822	KIT INFD SECT 1187MM	1.000	EA
1	0180	131.062455	ASSY INFD 2480 DELFI INSERT SST	1.000	EA
1	0260	531.000477	01 SPACER RIDER BAR	10.000	EA
1	0275	131.044500	ASSY-LEVELING PEG 880mm-950mm	4.000	EA
1	0280	131.033588	01 KIT-INFEED EYE MOUNT-OVERHEAD	2.000	EA
1	0285	131.059600	01 KIT-DISCH CNVR REJECT PNEUMATICS SST	1.000	EA
1	0290	531.062828	TIE BAR INFD SST	1.000	EA
1	0800	131.015991	KIT-STD INFD ELEC 6XX SERIES WRAPPER	1.000	EA
1	0801	131.026268	03 KIT ADDITIONAL INTERLOCK SWITCH	2.000	EA
1	0810	131.023138	KIT-OVERHEAD EYE	1.000	EA
1	0815	131.023139	KIT-NO PRODUCT NO PAPER	1.000	EA

Material	C282	01	0010	Alt.	Usage 3
	Linium Infeed Conveyor				Valid
					10/01/2007
Reqd qty	1.000	EA	Base quant	1.000	EA
Sales ord.	129850		Item	000340	

Lv	Item	Component no.	Description	Quant	Un
1	0000	C_CHAIN_E	Infeed Chain Assembly		
2	0001		KRAFT FOODS INC. NEW ULM PLT.		
2	0002	231.034823	- Drawing Chain W/Offset Link		
2	0010		Flight Length "A" = 5.5		
2	0010		Number of Flights = 81		
2	0014		Orientation ALL Prox Pins = Location 1 To the Left - Viewed from Behind Pusher		
2	0020		Spare Parts Section, Items 20 - 49		
2	0100		Assembled Chain Section		
2	0127	1604 5 6 1.	03 PUSHER 50H.	81.000	EA
2	0131	570-00450	04 CHAIN ROLLER HOLLOW PIN #40 SST	445.500	IN
2	0170	570-00451	02 CHAIN CONN LINK HOLLOW PIN #40 SST	1.000	EA
2	0171	570-00455	03 OFFSET-LINK #40 HOLLOW PIN SST	1.000	EA
2	0180	031.000405	Nut Hex Self Locking M3 SST		
2	0182	082-32966	Washer Flat .156 X .375 X .074 SST		
2	0185	531.000404	02 PIN PUSHER PROX	81.000	EA



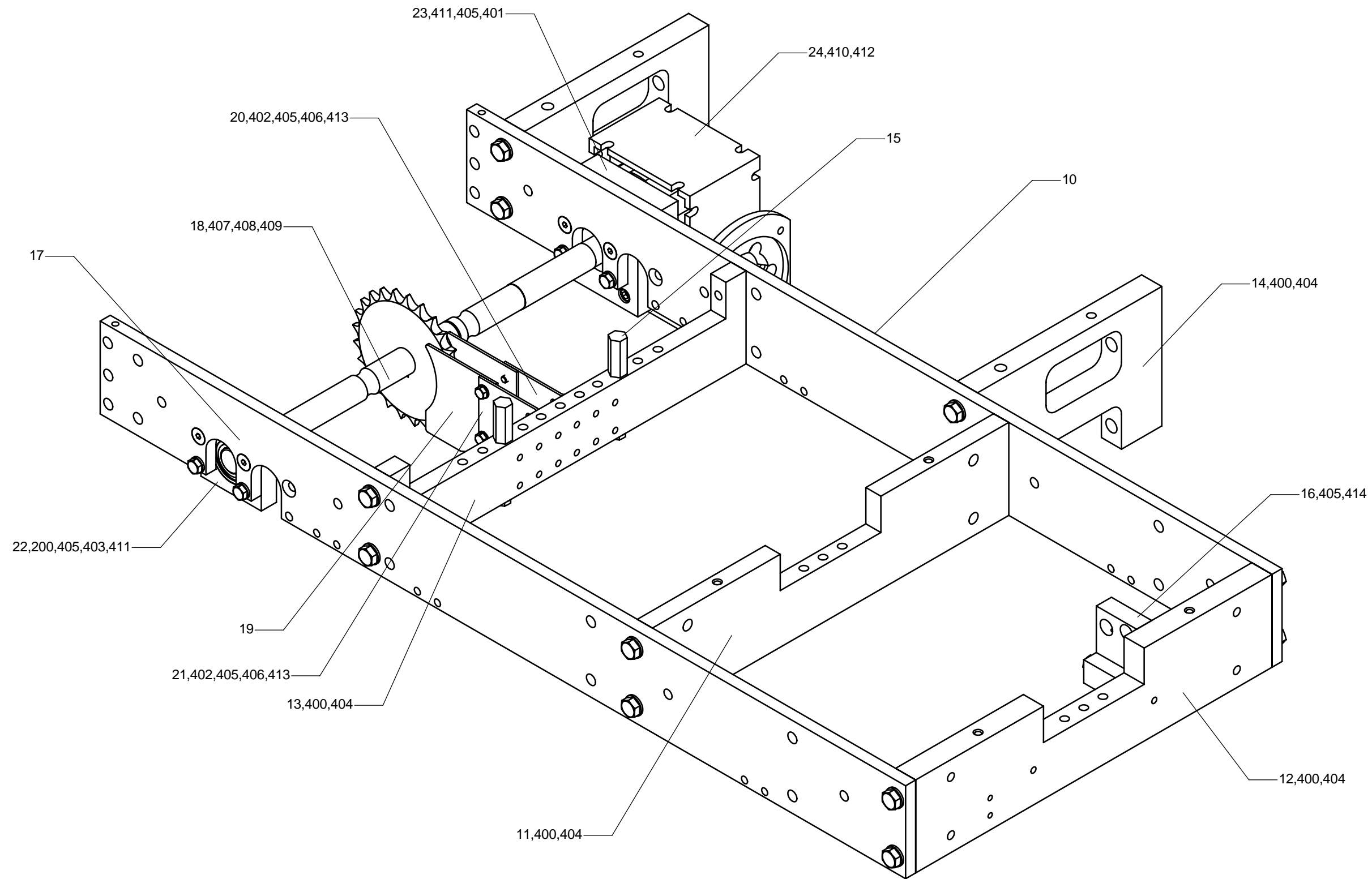
Assy Chain w/Offset Link Configured		Drawn by: Rick Gessler	Date: 23 Feb 2004
		Approved by: Rick Gessler	Scale: 1:1
		Checked by: Barb Hemauer	Size: A2
		Sheet: 1/1	M-Type: 282
		231.034823	Rev.: 0
BOSCH	Doboy Inc.	© Copyright Doboy Inc.	Based on SIG Pack International Design Standards

Qty.	Index	Description	Date	ECN No.	Changed by
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Material	C282	01	0010	Alt.	Usage 3
	Linium Infeed Conveyor			Valid	10/01/2007
Reqd qty		1.000 EA	Base quant		1.000 EA
Sales ord.	129850		Item	000340	
Lv	Item	Component no.	Description	Quant	Un
1	0000	C282E	Linium Infeed Engineering Configuration		
2	0010	131.061130	KIT-INFEED GUIDES & DECKS DELPHI TAI	1.000	EA
2	0015	131.062847	KIT INFD DECKS AND GUIDES W/REJ L-R	1.000	EA
2	0020	131.062841	KIT DECKS AND GUIDES 1187MM	1.000	EA
2	0035	131.020028	ASSY-RIDER BAR-200MM DROP-OFF	1.000	EA

Material	C282	01	0010	Alt.	Usage 3
	Linium Infeed Conveyor				Valid
					10/01/2007
Reqd qty		1.000	EA	Base quant	1.000 EA
Sales ord.	129850			Item	000340

Lv	Item	Component no.	Description	Quant	Un
1	0000	131.049241	ASSY-RECV CNVR-SST		
2	0001	231.049241	DRAWING ASSY REC CONV SST	1.000	EA
2	0010	531.049240	RAIL FRAME RECV CNVR SST	2.000	EA
2	0011	531.036220	SPACER - RAIL	1.000	EA
2	0012	531.036268	SPACER-RAIL-SPLICE-RECV CNVR-SST	1.000	EA
2	0013	531.036266	SPACER-RAIL-RECV CNVR-FRONT-SST	1.000	EA
2	0014	531.029129	PLATE-MTG-RECV CNVR-SST	2.000	EA
2	0015	531.011963	STANDOFF FORMER DECK	2.000	EA
2	0016	531.006310	02 BLOCK-PROX MOUNT SST	1.000	EA
2	0017	531.030882	05 SHAFT-DRIVE	1.000	EA
2	0018	531.017413	01 SPROCKET-DRIVE 40B25 20mm BORE SST	1.000	EA
2	0019	531.020025	02 GUARD-DRIVE SPROCKET	2.000	EA
2	0020	531.020026	01 MOUNT-GUARD-DRIVE SPROCKET	1.000	EA
2	0021	531.020027	MOUNT-GUARD-DRIVE SPROCKET	1.000	EA
2	0022	531.029132	BLOCK-BEARING-OP SIDE-SST	1.000	EA
2	0023	531.029636	BLOCK-GEARBOX MOUNT-SST	1.000	EA
2	0024	531.000811	01 REWORK-GEAR REDUCER NMRV040 10:1 RAT	1.000	EA
2	0200	031.056690	BEARING RADIAL BALL 20X37X9 SST	1.000	EA
2	0204	387948	01 KNOB REWORK	4.000	EA
2	0400	309393	01 WASHER-FLAT 8.4 X 16 X 1.6 SST	16.000	EA
2	0401	310098	SCREW-HEX HD M6 X 20 SST	2.000	EA
2	0402	310102	SCREW-HEX HD M6 X 12 SST	4.000	EA
2	0403	310103	SCREW-HEX HD M6 X 30 SST	2.000	EA
2	0404	310110	SCREW-HEX HD M8 X 25 SST	16.000	EA
2	0405	379749	WASHER-FLAT 6.4 X 12 X 1.6 SST	11.000	EA
2	0406	397007	SCREW-HEX HD M5 X 8 SST	4.000	EA
2	0407	397057	SCREW-SET M6 X 6 SST	2.000	EA
2	0408	397370	RING-RETAINING EXTERNAL 20 SST	1.000	EA
2	0409	397384	KEY-6 X 6 X 25 SST	1.000	EA
2	0410	397387	KEY-6 X 6 X 70 SST	1.000	EA
2	0411	398355	SCREW-FLAT SOC M6 X 20 SST	4.000	EA
2	0412	401085	RING-RTNG EXT 18DIA 1.2THK SST	1.000	EA
2	0413	401228	WASHER-FLAT 5.3 X 10 X 1 SST	4.000	EA
2	0414	422204	SCREW-HEX-HD M6 X 55 SST	1.000	EA
2	0415	431969	SCREW-HEX HD M6 X 60 SST	2.000	EA
2	0416	433416	SCREW-SOC CAP M6 X 45 SST	4.000	EA

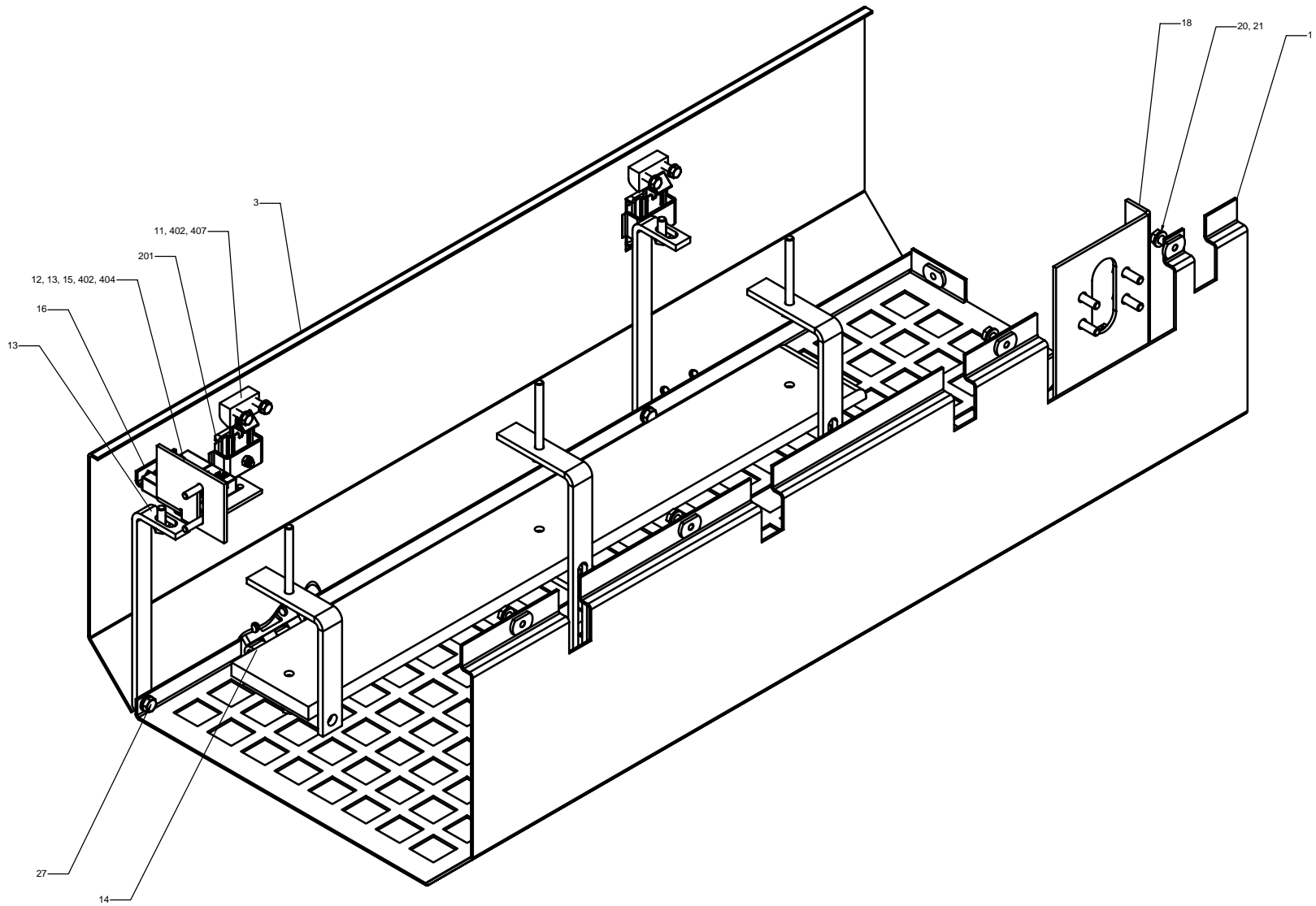


Similar to 231.033986		Drawn by: Mike Rogers	Date: 13 Oct 2005
		Approved by: Mike Rogers	Scale: 1:2
Assy Recieving Conveyor		Checked by: Barb Hemauer	Size: A2
		Sheet: 1/1	M-Type: 225
		231.049241	Rev.: 0
BOSCH	Doboy Inc.	© Copyright Doboy Inc.	Based on SIG Pack International Design Standards

Qty.	Index	Description	Date	ECN No.	Changed by
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Material	C282	01	0010	Alt.	Usage 3
	Linium Infeed Conveyor			Valid	10/01/2007
Reqd qty	1.000	EA	Base quant	1.000	EA
Sales ord.	129850		Item	000340	

Lv	Item	Component no.	Description	Quant	Un
1	0000	131.034651	KIT-GUARDS DELFI RECV CNVR LR		
2	0001	231.034650	KIT RECV CNVR GUARDS DELPHI RL	1.000	EA
2	0010	531.030734	03 GUARD-RECV CNVR DR SIDE LR	1.000	EA
2	0011	531.000815	01 STOP DOOR	2.000	EA
2	0012	531.001317	01 PLATE-NUT SWITCH	2.000	EA
2	0013	531.015558	PLATE-NUT GUARD	2.000	EA
2	0014	531.028590	01 BRACKET INTERLOCK DOOR	1.000	EA
2	0015	531.031003	02 BRACKET INTERLOCK FRAME	1.000	EA
2	0016	531.028129	BRACKET GUARD SUPPORT	2.000	EA
2	0017	531.028134	GUARD DOOR REC'V CNVR	1.000	EA
2	0018	531.030881	BRACKET ENCODER MOUNT REC'V CONVEYOR	1.000	EA
2	0019	531.028125	BRACKET RIDER BAR	1.000	EA
2	0020	531.028126	BRACKET RIDER BAR ADJ	2.000	EA
2	0021	531.028127	SUPPORT RIDER BAR	3.000	EA
2	0022	531.028129	BRACKET GUARD SUPPORT	2.000	EA
2	0023	531.020043	BAR-CHAIN RETURN-RECV CNVR	1.000	EA
2	0200	031.013336	HINGE-DOOR DIE CAST ZINC	2.000	EA
2	0201	031.001009	LATCH 5-PADDLE-100 SERIES	2.000	EA
2	0300	#479833	INTERLOCK SWITCH		
2	0400	309391	SCREW-HEX HD M6 X 16 SST	6.000	EA
2	0401	310106	SCREW-HEX HD M6 X 10 SST	2.000	EA
2	0402	318906	SCREW-HEX HD M5 X 20 SST	6.000	EA
2	0403	330832	SCREW-FLAT SOC M6 X 10 SST	8.000	EA
2	0404	379749	WASHER-FLAT 6.4 X 12 X 1.6 SST	8.000	EA
2	0405	397043	SCREW-PAN SLOT M4 X 6 SST	2.000	EA
2	0406	401213	SCREW-SOC CAP M4 X 16 SST	4.000	EA
2	0407	401228	WASHER-FLAT 5.3 X 10 X 1 SST	6.000	EA
2	0408	310098	SCREW-HEX HD M6 X 20 SST	4.000	EA



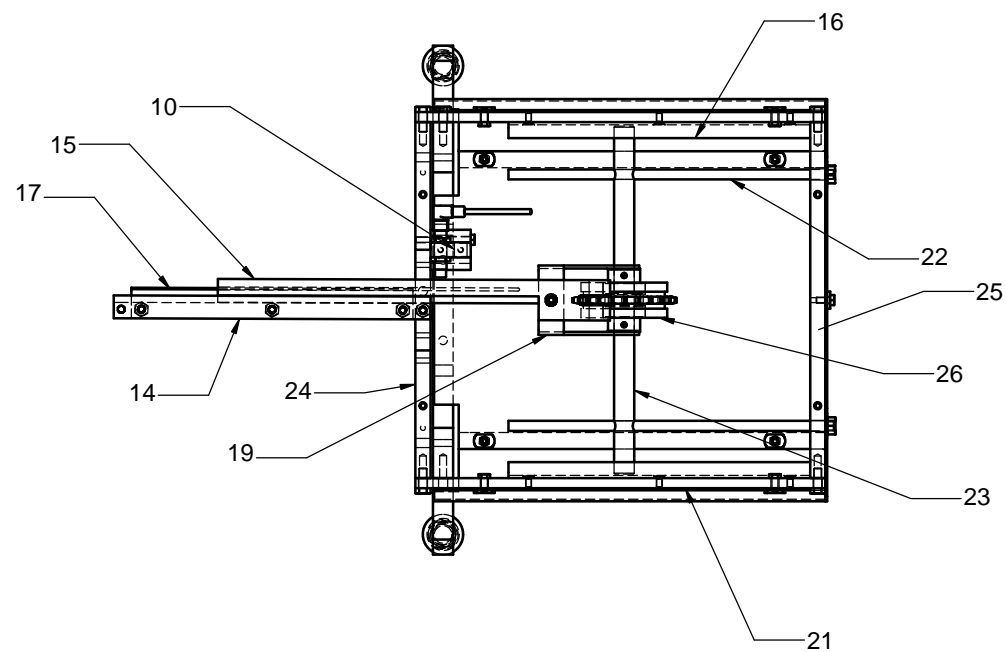
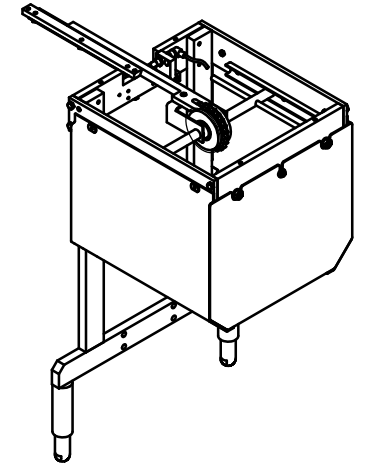
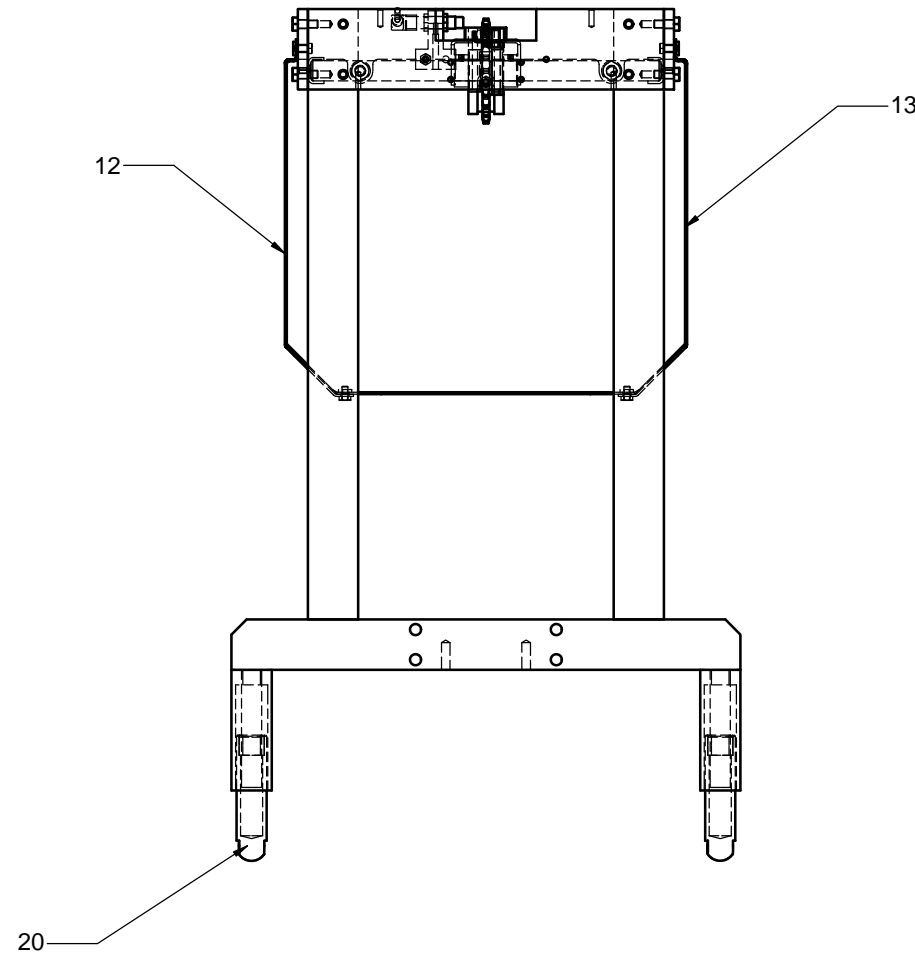
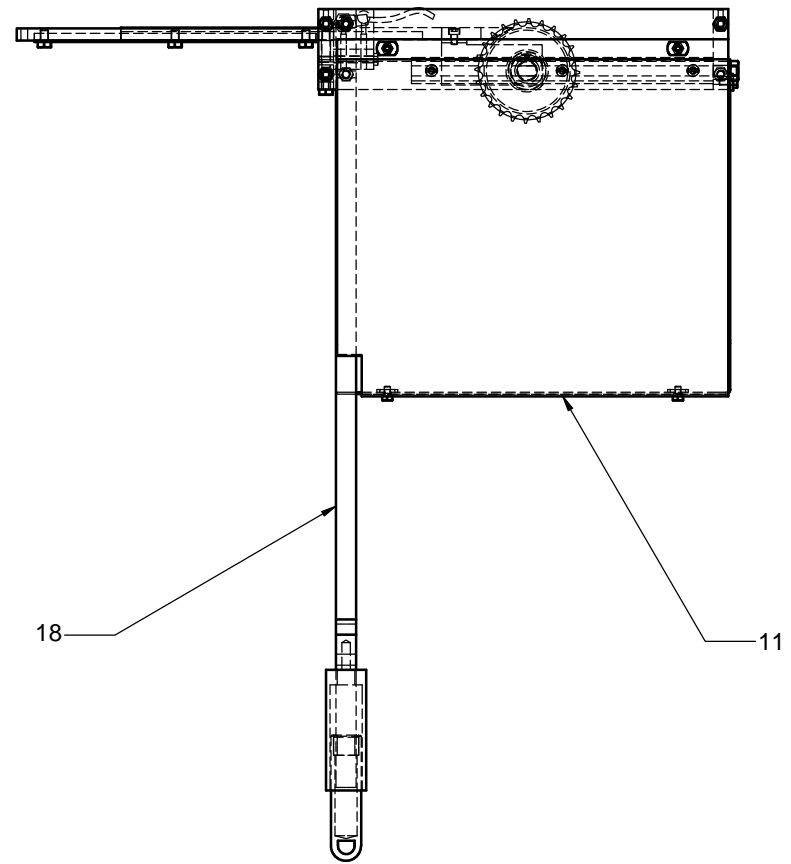
Drawn by: Bryan Grass		Date: 20 Mar 2003
Approved by: Bryan Grass		Scale: 1:1.5
Checked by:		Size: A1
Sheet: 1/1	M-Type: 307	
231.034650		Rev.: 0
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Qty	Index	Description	Date	ECN No.	Changed by

Material	C282	01	0010	Alt.	Usage 3	
	Linium Infeed Conveyor			Valid	10/01/2007	
Reqd qty		1.000	EA	Base quant	1.000 EA	
Sales ord.	129850			Item	000340	
Lv	Item	Component no.	Description		Quant	Un
1	0000	131.042678	KIT-ENCODER DRIVE-DELFI INFEEED			
2	0010	531.030199	01	PULLEY 5mm PITCH/50 TOOTH 20mm BORE	1.000	EA
2	0011	531.020415		PULLEY TIMING HTD 5M16x9 10mm BORE	1.000	EA
2	0012	531.028596		ENCODER FASTENING PLATE	1.000	EA
2	0200	414439		TIMING BELT HTD 425-5M 9 WIDE	1.000	EA

Material	C282	01	0010	Alt.	Usage 3
	Linium Infeed Conveyor				Valid
					10/01/2007
Reqd qty		1.000	EA	Base quant	1.000 EA
Sales ord.	129850			Item	000340

Lv	Item	Component no.	Description	Quant	Un
1	0000	131.062454	ASSY INFD CNVR DELFI TAIL .4M SST		
2	0010	531.006310	02 BLOCK-PROX MOUNT SST	1.000	EA
2	0011	531.061116	GUARD-TAKE-UP BOTTOM DELPHI .4M	1.000	EA
2	0012	531.061114	GUARD-TAKE-UP SIDE DELPHI .4M	1.000	EA
2	0013	531.061115	GUARD-TAKE-UP SIDE DELPHI .4M	1.000	EA
2	0014	531.000478	GUIDE CHAIN TRANSFER	1.000	EA
2	0015	531.003513	03 GUIDE CHAIN END	1.000	EA
2	0016	531.000488	02 GUIDE TAKEUP SHAFT	2.000	EA
2	0017	531.000479	01 GUIDE TRANSFER	1.000	EA
2	0018	531.062453	LEG INFEED CONV	1.000	EA
2	0019	531.003512	03 MOUNT RIDER BAR	1.000	EA
2	0020	531.006379	04 PEG-LEVELING USDA	2.000	EA
2	0021	531.061113	RAIL-INFEED CNVR DELPHI TAIL .4M SST	2.000	EA
2	0022	531.000487	01 SCREW-TAKEUP	2.000	EA
2	0023	531.004548	01 SHAFT WIDE TAIL SPROCKET	1.000	EA
2	0024	531.055946	SPACER DELPHI SPLICE SST	1.000	EA
2	0025	531.055947	SPACER RAIL END SST	1.000	EA
2	0026	531.000483	02 SPROCKET-TAIL 40C24	1.000	EA
2	0200	950243	BEARING-RADIAL BALL 20 x 42 x 12	2.000	EA
2	0300	#283039	Cable-Quick Disconnect		
2	0301	#440548	Sensor-Proximity		
2	0400	309327	SCREW-FLAT SLOT M6 X 12 SST	6.000	EA
2	0401	310106	SCREW-HEX HD M6 X 10 SST	4.000	EA
2	0402	409969	SCREW-HEX HD M6 X 14 SST	5.000	EA
2	0403	422204	SCREW-HEX-HD M6 X 55 SST	1.000	EA
2	0404	310143	SCREW-HEX HD M8 X 12 SST	3.000	EA
2	0405	432072	SCREW-HEX HD M8 X 20 SST	10.000	EA
2	0406	397009	SCREW-HEX HD M8 X 40 SST	2.000	EA
2	0407	397012	SCREW-HEX HD M8 X 60 SST	1.000	EA
2	0408	397054	SCREW-SET M5 X 5 SST	2.000	EA
2	0409	310105	SCREW-SOC CAP M6 X 10 SST	1.000	EA
2	0410	422036	WASHER-FLAT THK 6.4 X 17 X 3 SST	1.000	EA
2	0411	397080	WASHER-FLAT 10.5 X 20 X 2 SST	2.000	EA



Similar to 231.061112		Drawn by: Mike Rogers	Date: 19 Sep 2007
		Approved by: Mike Rogers	Scale: 1:5
Assy Infeed Cnvr Delfi Tail .4M SST		Checked by: Barb Hemauer	Size: A2
		Sheet: 1/1	M-Type: 282
		231.062454	Rev.: 0
BOSCH	Doboy Inc.	© Copyright Doboy Inc.	Based on SIG Pack International Design Standards

Qty.	Index	Description	Date	ECN No.	Changed by
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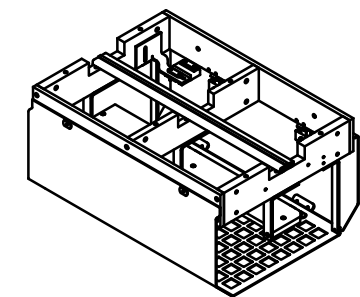
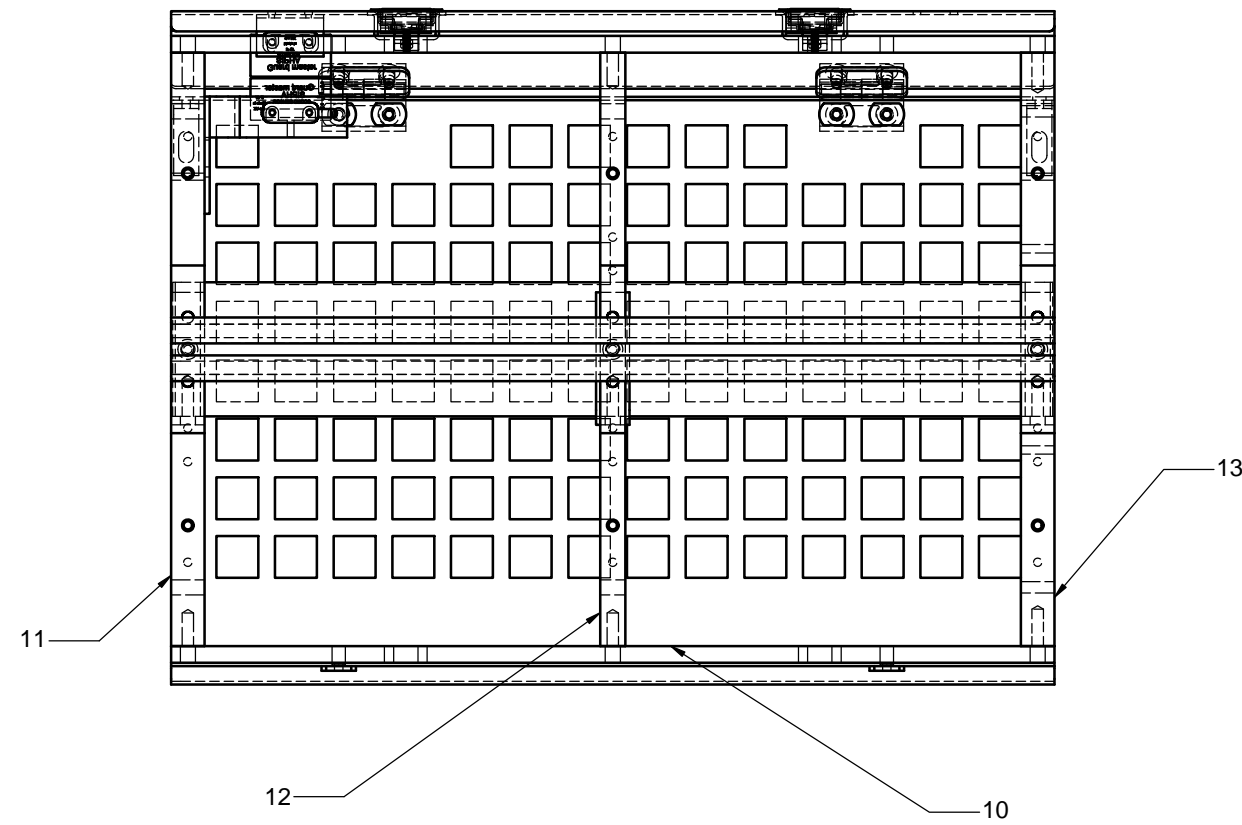
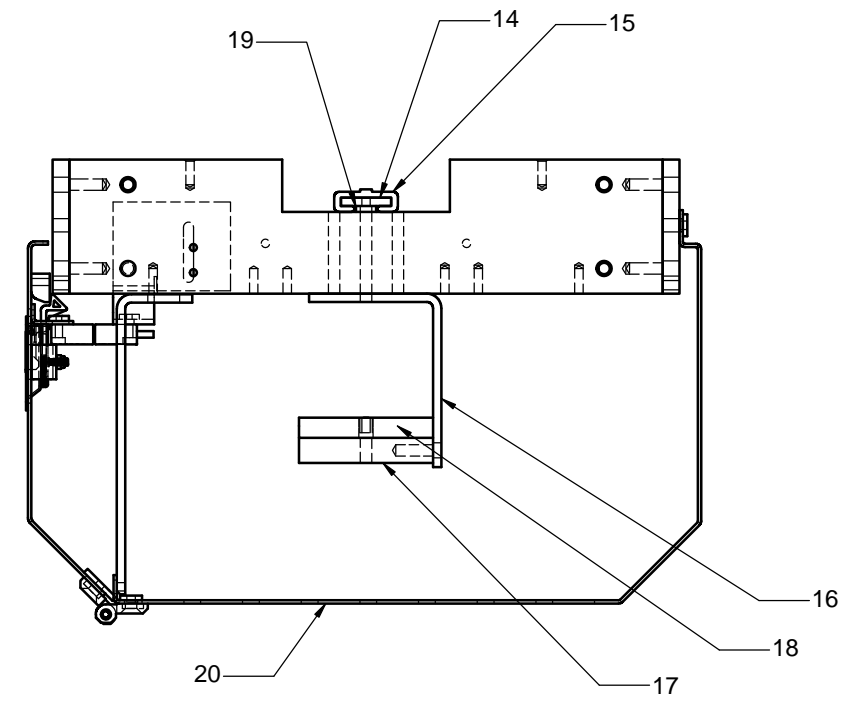
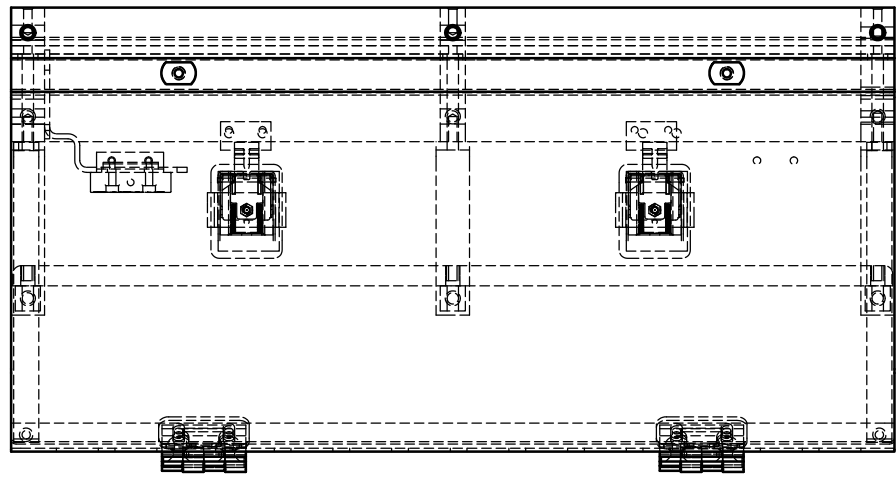
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	Linium Infeed Conveyor				Valid
					10/01/2007
Reqd qty		1.000	EA	Base quant	1.000 EA
Sales ord.	129850			Item	000340

Lv	Item	Component no.	Description	Quant	Un
1	0000	131.061144	ASSY-INFEED CNVR W/REJECT 1.5M LR SST		
2	0010	531.024226	BAR-CHAIN RIDER-1.5M	1.000	EA
2	0011	531.061104	BAR-UNIVERSAL MOUNTING RAIL 1481mm	1.000	EA
2	0012	531.051790	BLOCK-UNIVERSAL RAIL MOUNT	2.000	EA
2	0013	531.028129	BRACKET GUARD SUPPORT	1.000	EA
2	0014	531.028131	BRACKET-GUARD SUPPORT OFFSET LR	1.000	EA
2	0015	531.028130	BRACKET GUARD SUPPORT WIDE	1.000	EA
2	0016	531.028590	01 BRACKET INTERLOCK DOOR	1.000	EA
2	0017	531.028591	01 BRACKET-INTERLOCK FRAME LR	1.000	EA
2	0018	531.028125	BRACKET RIDER BAR	1.000	EA
2	0019	531.028126	BRACKET RIDER BAR ADJ	1.000	EA
2	0020	531.028128	BRACKET RIDER BAR SPLICE	1.000	EA
2	0021	531.051791	CLAMP-UNIVERSAL RAIL MOUNT SST	2.000	EA
2	0022	531.030710	CHUTE-INFEED REJECT	1.000	EA
2	0023	531.061133	GUARD-DELPHI INFEED REAR LR	1.000	EA
2	0024	531.061134	01 GUARD-DELPHI INFEED REJECT LR	1.000	EA
2	0025	531.028123	01 GUARD-DOOR INFEED DELPHI LR	1.000	EA
2	0026	531.031390	GUARD-FRONT-INFEED REJECT	1.000	EA
2	0027	531.031391	GUARD-FRONT-INFEED REJECT	1.000	EA
2	0028	531.028598	01 GUARD PLATE DELFI INFEED	1.000	EA
2	0029	531.061106	LEG-DELPHI INFEED SST	1.000	EA
2	0030	531.006379	04 PEG-LEVELING USDA	2.000	EA
2	0031	531.029024	PLATE MOUNT CONNECTOR BOX DELFI INFE	1.000	EA
2	0032	531.013335	01 PLATE-NUT GUARD	2.000	EA
2	0033	531.001317	01 PLATE-NUT SWITCH	2.000	EA
2	0034	531.059684	RAIL-INFEED REJECT BACK SST	1.000	EA
2	0035	531.059686	RAIL-INFEED REJECT FRONT SST	1.000	EA
2	0036	531.059687	RAIL-INFEED REJECT FRONT SST	1.000	EA
2	0037	531.028589	RIDER BAR RETURN	2.000	EA
2	0038	531.043909	SPACER-CROSS REJECT	1.000	EA
2	0039	531.036220	SPACER - RAIL	2.000	EA
2	0040	531.059683	01 SPACER-RAIL INFEED REJECT SST	2.000	EA
2	0041	531.059685	SPACER-RAIL INFEED REJECT CENTER SST	1.000	EA
2	0042	531.036219	SPACER - RAIL - SPLICE - INFEED	1.000	EA
2	0043	531.055951	SPACER RAIL SPLICE WIDE DELPHI SST	1.000	EA
2	0044	531.000477	01 SPACER RIDER BAR	5.000	EA
2	0045	531.000815	01 STOP DOOR	2.000	EA
2	0046	531.028127	SUPPORT RIDER BAR	4.000	EA
2	0047	531.055954	SUPPORT RIDER BAR 1.5M	1.000	EA
2	0200	031.029231	HINGE-SST	2.000	EA
2	0201	031.001009	LATCH 5-PADDLE-100 SERIES	2.000	EA
2	0300	#619.0201187	Connector-Bulkhead 24-Pin		
2	0301	#379508	Connector-Strain Relief PG-21		
2	0302	#531.023374	Enclosure-6x6x4		
2	0303	#379510	Locknut-PG-21		
2	0304	#479833	Switch-Interlock		
2	0400	309327	SCREW-FLAT SLOT M6 X 12 SST	8.000	EA
2	0401	395577	SCREW-FLAT SOC M8 X 20 SST	2.000	EA

2 0402 031.000353	SCREW-HEX HD M4 X 6 SST	2.000	EA
2 0403 318906	SCREW-HEX HD M5 X 20 SST	5.000	EA
2 0404 310106	SCREW-HEX HD M6 X 10 SST	16.000	EA
2 0405 409969	SCREW-HEX HD M6 X 14 SST	10.000	EA
2 0406 309391	SCREW-HEX HD M6 X 16 SST	2.000	EA
2 0407 310098	SCREW-HEX HD M6 X 20 SST	3.000	EA
2 0408 388079	SCREW-HEX HD M6 X 25 SST	4.000	EA
2 0409 431969	SCREW-HEX HD M6 X 60 SST	5.000	EA
2 0410 432072	SCREW-HEX HD M8 X 20 SST	28.000	EA
2 0411 397009	SCREW-HEX HD M8 X 40 SST	4.000	EA
2 0412 031.005514	SCREW-HEX HD M8 X 90 SST	4.000	EA
2 0413 401213	SCREW-SOC CAP M4 X 16 SST	4.000	EA
2 0414 310115	SCREW-SOC CAP M8 X 25 SST	4.000	EA
2 0415 401228	WASHER-FLAT 5.3 X 10 X 1 SST	1.000	EA
2 0416 422036	WASHER-FLAT THK 6.4 X 17 X 3 SST	3.000	EA
2 0417 407802	WASHER-FLAT THK 8.4 X 21 X 4 SST	1.000	EA

Material	C282	01	0010	Alt.	Usage 3
	Linium Infeed Conveyor			Valid	10/01/2007
Reqd qty	1.000	EA	Base quant	1.000	EA
Sales ord.	129850		Item	000340	

Lv	Item	Component no.	Description	Quant	Un
1	0000	131.062834	KIT INFEED SECTION 527MM		
2	0001	231.062834	DWG KIT INFD SECT 527MM	1.000	EA
2	0010	531.062460	RAIL IND SPECIAL 527MM SECT	2.000	EA
2	0011	531.036268	SPACER-RAIL-SPLICE-RECV CNVR-SST	1.000	EA
2	0012	531.036220	SPACER - RAIL	1.000	EA
2	0013	531.036219	SPACER - RAIL - SPLICE - INFEED	1.000	EA
2	0014	531.062830	RIDER BAR SUPPORT 527MM	1.000	EA
2	0015	531.062829	BAR CHAIN RIDER 527	1.000	EA
2	0016	531.028125	BRACKET RIDER BAR	5.000	EA
2	0017	531.028127	SUPPORT RIDER BAR	5.000	EA
2	0018	531.062843	RIDER BAR RETURN	1.000	EA
2	0019	531.000477	01 SPACER RIDER BAR	3.000	EA
2	0020	131.062833	KIT GUARDS 527MM SECTION	1.000	EA

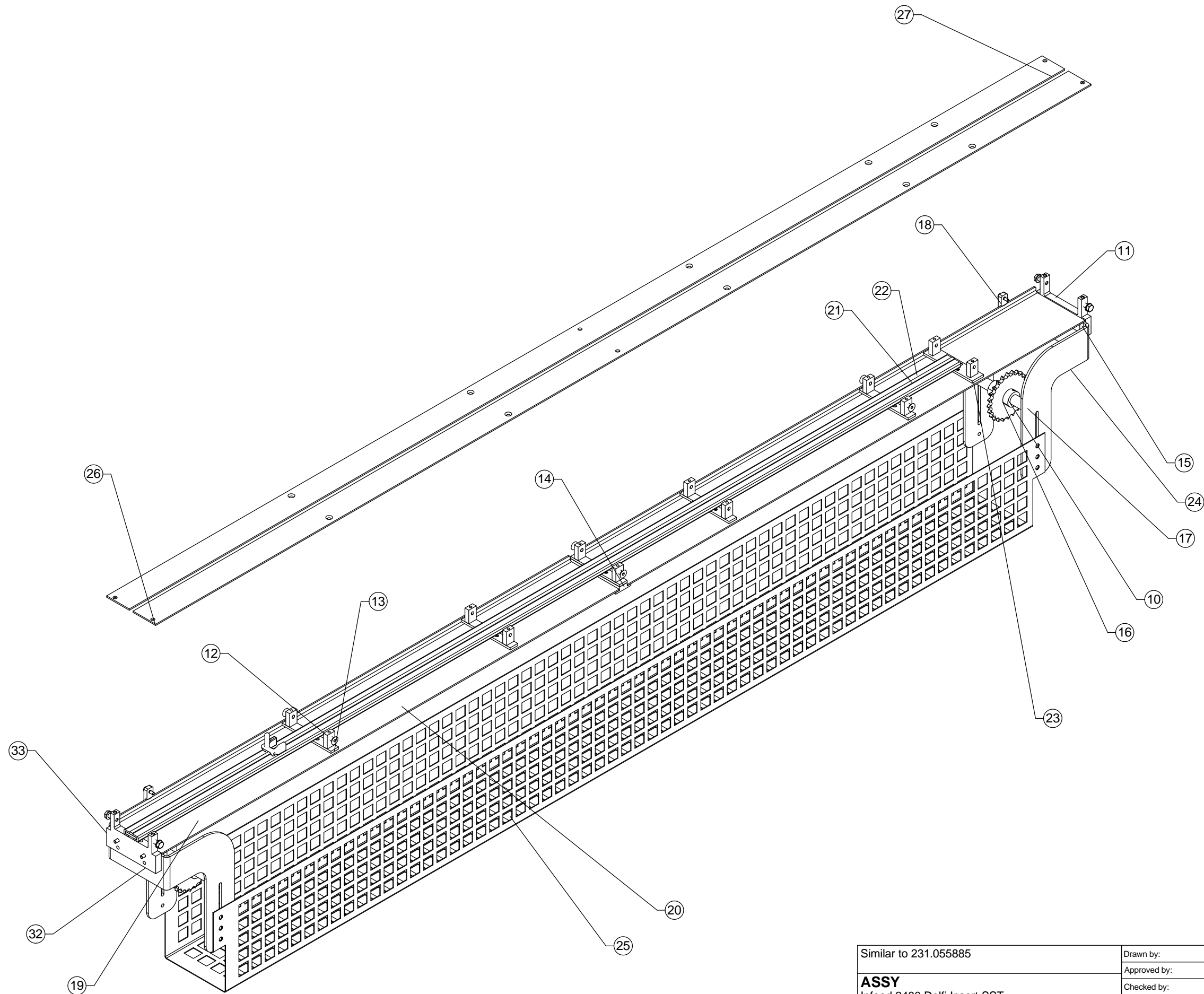


Kit Infeed Section 527mm		Drawn by: Mike Rogers	Date: 20 Sep 2007
		Approved by: Mike Rogers	Scale: 1:3
		Checked by: Barb Hemauer	Size: A2
		Sheet: 1/1	M-Type: 282
		231.062834	Rev.: 0
BOSCH	Doboy Inc.	© Copyright Doboy Inc.	Based on SIG Pack International Design Standards

Qty.	Index	Description	Date	ECN No.	Changed by
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Material	C282	01	0010	Alt.	Usage 3
	Linium Infeed Conveyor				Valid
					10/01/2007
Reqd qty		1.000 EA	Base quant		1.000 EA
Sales ord.	129850		Item	000340	

Lv	Item	Component no.	Description	Quant	Un
1	0000	131.062455	ASSY INFD 2480 DELFI INSERT SST		
2	0001	231.062455	DWG INFD 2480 DELFI INSERT SST	1.000	EA
2	0010	398348	COLLAR-SET 20 X 32 X 14 SST	4.000	EA
2	0011	531.055899	01 SUPPORT-RAIL SPLICE SST	1.000	EA
2	0012	531.055957	MOUNT-RIDER BAR SUPPORT SST	12.000	EA
2	0013	531.055958	SUPPORT-RIDER BAR CROSS SST	5.000	EA
2	0014	531.020365	01 SUPPORT TRAY MIDDLE	1.000	EA
2	0015	531.020366	01 SUPPORT TRAY END	2.000	EA
2	0016	531.055900	SPROCKET IDLER 40B24 X 32mm x 7 BORE	2.000	EA
2	0017	531.020394	SHAFT CHAIN IDLER	2.000	EA
2	0018	531.020425	LATCH TRAY	2.000	EA
2	0019	531.055886	RAIL INFEED WIDE DELFI SST	2.000	EA
2	0020	531.055884	TRAY CRUMB WIDE DELPHI	2.000	EA
2	0021	531.056092	RIDER BAR WIDE DELPHI MIDDLE	1.000	EA
2	0022	531.056091	01 SUPPORT RIDER BAR WIDE DELPHI	1.000	EA
2	0023	531.055956	SUPPORT-RIDER BAR WIDE SST	1.000	EA
2	0024	531.062458	BRACKET IDLER RETURN DELFI	2.000	EA
2	0025	531.055839	GUARD DELPHI UNDERSIDE WIDE	1.000	EA
2	0026	531.062456	DECK DELFI 2480 NARROW	1.000	EA
2	0027	531.062457	DECK DELFI 2480 NARROW	1.000	EA
2	0032	031.011300	BEARING-RADIAL BALL 20x32x7	4.000	EA
2	0033	531.056945	01 SUPPORT-RAIL SPLICE SST	1.000	EA
2	0034	531.000477	01 SPACER RIDER BAR	10.000	EA

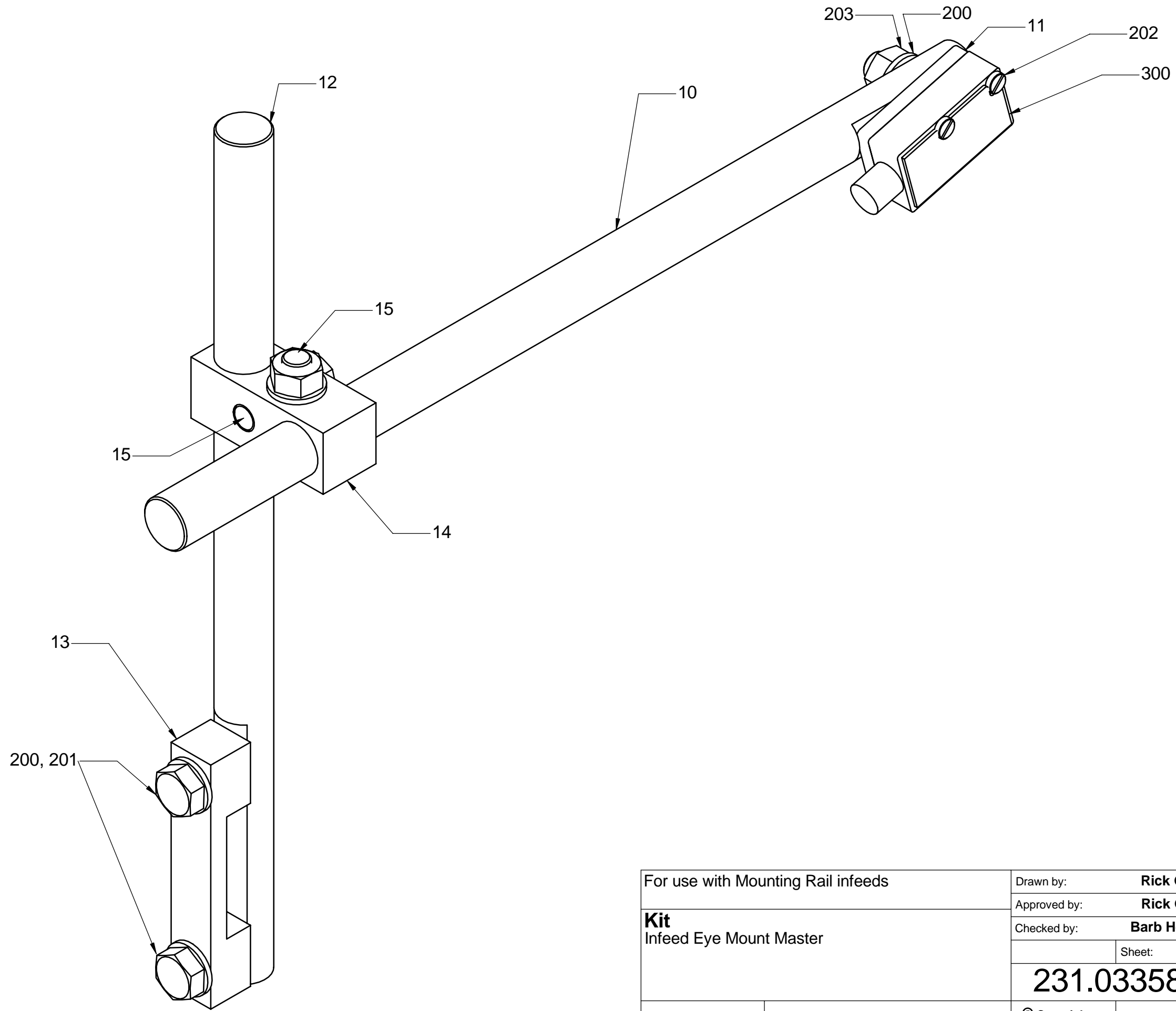


Similar to 231.055885		Drawn by: Mike Rogers	Date: 19 Sep 2007
ASSY Infeed 2480 Delfi Insert SST		Approved by: Mike Rogers	Scale: 1:5
		Checked by: Barb Hemauer	Size: A2
		Sheet: 1/1	M-Type: 307
		231.062455	Rev.: 0
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Qty.	Index	Description	Date	ECN No.	Changed by
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Material	C282	01	0010	Alt.	Usage 3
	Linium Infeed Conveyor				Valid 10/01/2007
Reqd qty	1.000	EA	Base quant	1.000	EA
Sales ord.	129850		Item	000340	

Lv	Item	Component no.	Description	Quant	Un
1	0000	131.033588	KIT-INFEED EYE MOUNT-OVERHEAD		
2	0001	231.033588	KIT INFEED EYE MOUNT MASTER	2.000	EA
2	0010	531.033583	01 SHAFT EYE MOUNT MASTER	2.000	EA
2	0011	531.033584	02 PLATE-EYE MOUNT	2.000	EA
2	0012	531.033589	UPRIGHT EYE MOUNT POST	2.000	EA
2	0013	531.033590	CLAMP MTG RAIL NARROW	2.000	EA
2	0014	531.033591	CROSS BLOCK EYE MOUNT MASTER	2.000	EA
2	0015	531.033592	CAM LOCK STUD MASTER	4.000	EA
2	0200	309393	01 WASHER-FLAT 8.4 X 16 X 1.6 SST	10.000	EA
2	0201	310110	SCREW-HEX HD M8 X 25 SST	4.000	EA
2	0202	397046	SCREW-PAN SLOT M3 X 16 SST	4.000	EA
2	0203	397063	NUT-HEX FULL M8 SST	6.000	EA
2	0300	477538	Photo Eye		



For use with Mounting Rail infeeds	Drawn by:	Rick Gessler	Date: 22 Aug 2003
	Approved by:	Rick Gessler	Scale: 1:1
Kit Infeed Eye Mount Master	Checked by:	Barb Hemauer	Size: A3
	Sheet:	1/1	M-Type: 282
	231.033588		Rev.: 0

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Qty.	Index	Description	Date	ECN No.	Changed by
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Material	C282	01	0010	Alt.	Usage 3
	Linium Infeed Conveyor			Valid	10/01/2007
Reqd qty	1.000	EA	Base quant	1.000	EA
Sales ord.	129850		Item	000340	

Lv	Item	Component no.	Description	Quant	Un
1	0000	131.059600	KIT-DISCH CNVR REJECT PNEUMATICS SST		
2	0010	531.059586	BRACKET-REJECT PNEUMATIC MOUNT SST	1.000	EA
2	0011	531.051791	CLAMP-UNIVERSAL RAIL MOUNT SST	2.000	EA
2	0200	031.008412	CONNECTOR-BRANCH TEE 1/4BSPP	1.000	EA
2	0201	398937	CONNECTOR-CLOSE NIPPLE 1/4BSPP	2.000	EA
2	0202	031.000339	CONNECTOR-ELBOW MALE M5 TO 6mm TUBE	1.000	EA
2	0203	432286	CONNECTOR-ELBOW MALE R1/4 TO 6mm TUB	1.000	EA
2	0204	031.000521	CONNECTOR-ELBOW MALE R1/4 TO 10mm TU	2.000	EA
2	0205	031.010018	REGULATOR-PNEUMATIC .5-7BAR G1/4 W/G	1.000	EA
2	0206	432728	RESERVOIR G1/4	1.000	EA
2	0207	031.009245	VALVE-SOLENOID 3/2 G1/4 AIR PILOT 24	1.000	EA
2	0301	031.011580	SOCKET-W/CABLE 5M 24 VOLT	1.000	EA
2	0400	407551	SCREW-HEX HD M4 X 10 SST	4.000	EA
2	0401	310144	SCREW-HEX HD M8 X 30 SST	4.000	EA

Material	C282	01	0010	Alt.	Usage 3
	Linium Infeed Conveyor			Valid	10/01/2007
Reqd qty		1.000	EA	Base quant	1.000 EA
Sales ord.	129850			Item	000340
Lv	Item	Component no.	Description		Quant Un
1	0000	131.015991	KIT-STD INFD ELEC 6XX SERIES WRAPPER		
2	0300	474497	01	MOTOR SERVO AC 26IN/LB 5000RPM 230V	1.000 EA
2	0301	440548		SENSOR PROXIMITY N.O. PNP	1.000 EA

Material	C282	01	0010	Alt.	Usage 3
	Linium Infeed Conveyor			Valid	10/01/2007
Reqd qty		1.000	EA	Base quant	1.000 EA
Sales ord.	129850			Item	000340
Lv	Item	Component no.	Description		Quant Un
1	0000	131.026268	KIT ADDITIONAL INTERLOCK SWITCH		
2	0300	479833	SWITCH-INTERLOCK 10M CABLE N.O AUX		2.000 EA
2	0303	631.032414	PLUG MALE 8 PIN SCREW TERMINALS		2.000 EA
2	0304	631.032415	PLUG FEMALE 8 PIN SCREW TERMINALS		2.000 EA

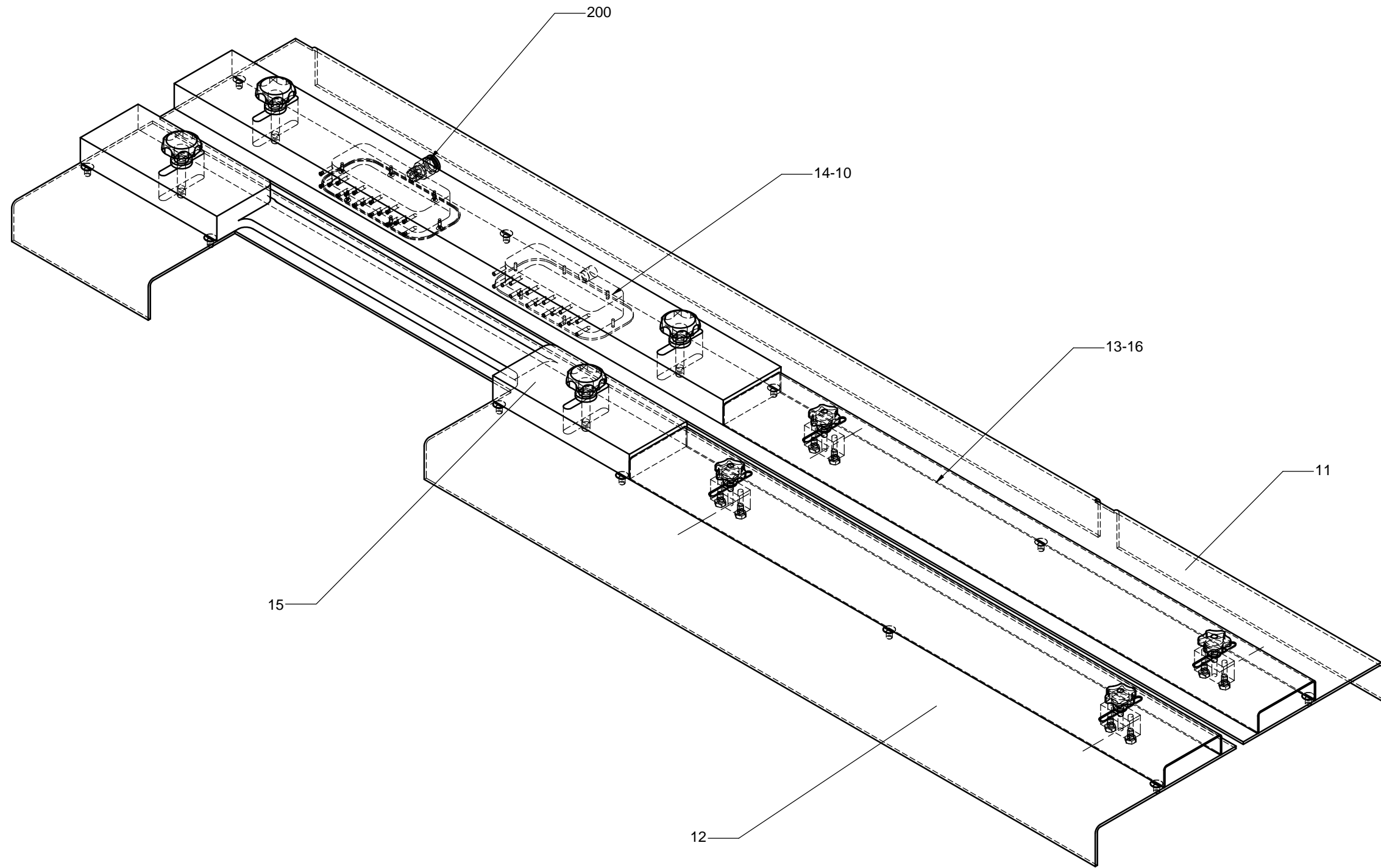
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	Linium Infeed Conveyor			Valid	10/01/2007	
Reqd qty		1.000	EA	Base quant	1.000 EA	
Sales ord.	129850			Item	000340	
Lv	Item	Component no.	Description		Quant	Un
1	0000	131.023138	KIT-OVERHEAD EYE			
2	0300	477538	PHOTO EYE, ADJUSTABLE OVERHEAD		1.000	EA
2	0301	276734	02 CABLE-QUICK DISCONNECT DC 15' STRAIG		1.000	EA

Material	C282	01	0010	Alt.	Usage 3
	Linium Infeed Conveyor			Valid	10/01/2007
Reqd qty		1.000	EA	Base quant	1.000 EA
Sales ord.	129850			Item	000340
Lv	Item	Component no.	Description		Quant Un
1	0000	131.023139	KIT-NO PRODUCT NO PAPER		
2	0300	477538	PHOTO EYE, ADJUSTABLE OVERHEAD		1.000 EA
2	0301	276734	02 CABLE-QUICK DISCONNECT DC 15' STRAIG		1.000 EA

Material	C282	01	0010	Alt.	Usage 3
	Linium Infeed Conveyor			Valid	10/01/2007
Reqd qty		1.000 EA	Base quant		1.000 EA
Sales ord.	129850		Item	000340	
Lv	Item	Component no.	Description	Quant	Un
2	0000	131.061130	KIT-INFEED GUIDES & DECKS DELPHI TAIL		
3	0010	531.061121	GUIDE-CHAIN INFEED DELPHI TAIL	1.000	EA
3	0011	531.061122	GUIDE-CHAIN INFEED DELPHI TAIL	1.000	EA
3	0012	531.061123	GUARD-INFEED TAIL SPROCKET	1.000	EA
3	0400	422076	SCREW-FLAT SLOT M6 X 10 SST	4.000	EA
3	0401	310106	SCREW-HEX HD M6 X 10 SST	4.000	EA

Material	C282	01	0010	Alt.	Usage 3
	Linium Infeed Conveyor				Valid
					10/01/2007
Reqd qty		1.000	EA	Base quant	1.000 EA
Sales ord.	129850			Item	000340

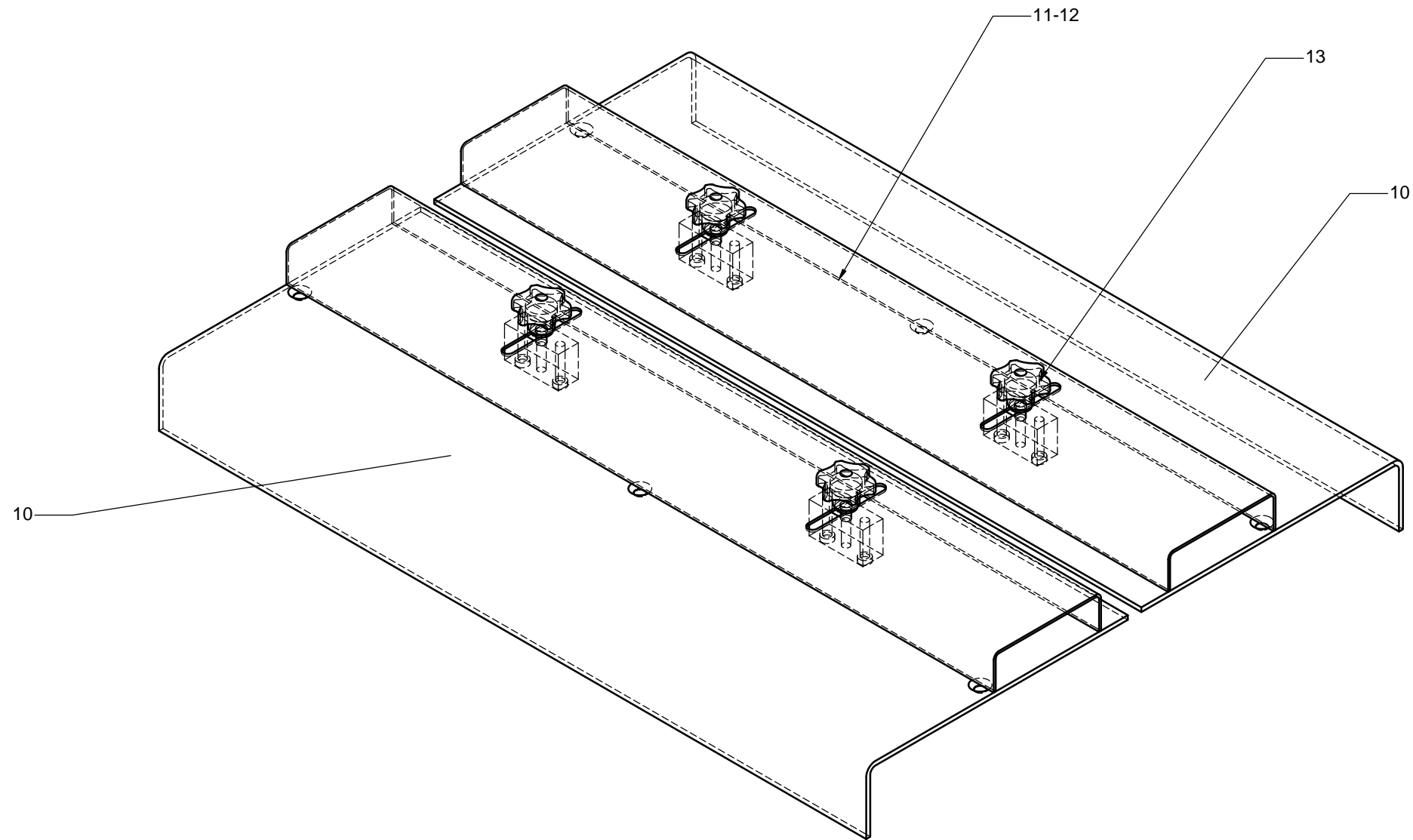
Lv	Item	Component no.	Description	Quant	Un
2	0000	131.062847	KIT INFD DECKS AND GUIDES W/REJ L-R		
3	0001	231.062838	DWG KIT DECKS AND GUIDES	1.000	EA
3	0010	531.059693	COVER-REJECT MANIFOLD	1.000	EA
3	0011	531.061136	GUIDE-CHAIN INFEED DR SIDE 1.5M RL	1.000	EA
3	0012	531.061135	GUIDE-CHAIN INFEED OP SIDE 1.5M LR	1.000	EA
3	0013	531.062836	GUIDE PRODUCT INFEED 25MM HI	2.000	EA
3	0014	531.059694	02 GUIDE-PRODUCT INFEED REJECT DR SIDE	1.000	EA
3	0015	531.059696	01 GUIDE-PRODUCT INFEED REJECT OP SIDE	1.000	EA
3	0016	531.047926	SPACER-PRODUCT GUIDE 23.5mm	4.000	EA
3	0200	031.000525	CONNECTOR-STRAIGHT MALE R1/4 TO 10mm	1.000	EA
3	0201	375068	03 KNOB-M6 x 10 STUD STL	4.000	EA
3	0202	031.059700	KNOB-M8 X 45 STUD STL	4.000	EA
3	0400	422201	SCREW-FLAT SLOT M3 X 8 SST	6.000	EA
3	0401	422076	SCREW-FLAT SLOT M6 X 10 SST	11.000	EA
3	0402	310106	SCREW-HEX HD M6 X 10 SST	8.000	EA
3	0403	431823	SCREW-SET M3 X 4 SST	17.000	EA
3	0404	379749	WASHER-FLAT 6.4 X 12 X 1.6 SST	4.000	EA
3	0405	407802	WASHER-FLAT THK 8.4 X 21 X 4 SST	4.000	EA



Similar to 231.061132		Drawn by: Mike Rogers	Date: 21 Sep 2007
		Approved by: Mike Rogers	Scale: 1:10
Kit Infeed Guides & Decks W/Reject RL		Checked by: Barb Hemauer	Size: A2
		Sheet: 1/1	M-Type: 282
		231.062838	Rev.: 0
BOSCH	Doboy Inc.	© Copyright Doboy Inc.	Based on SIG Pack International Design Standards

Qty.	Index	Description	Date	ECN No.	Changed by
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Material	C282	01	0010	Alt.	Usage 3
	Linium Infeed Conveyor			Valid	10/01/2007
Reqd qty		1.000	EA	Base quant	1.000 EA
Sales ord.	129850			Item	000340
Lv	Item	Component no.	Description	Quant	Un
2	0000	131.062846	KIT DECKS AND GUIDES 527MM		
3	0001	231.062846	DWG KIT DECKS AND GUIDES 527MM	1.000	EA
3	0010	531.062845	DECK INFD 527MM	2.000	EA
3	0011	531.062844	GUIDE PRODUCT INFEED 25MM HI	2.000	EA
3	0012	531.047926	SPACER-PRODUCT GUIDE 23.5mm	4.000	EA
3	0013	375068	03 KNOB-M6 x 10 STUD STL	4.000	EA



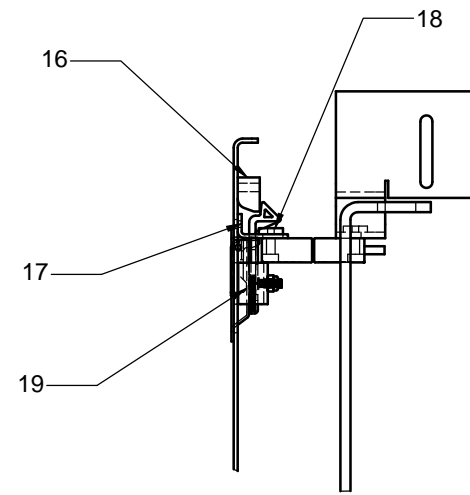
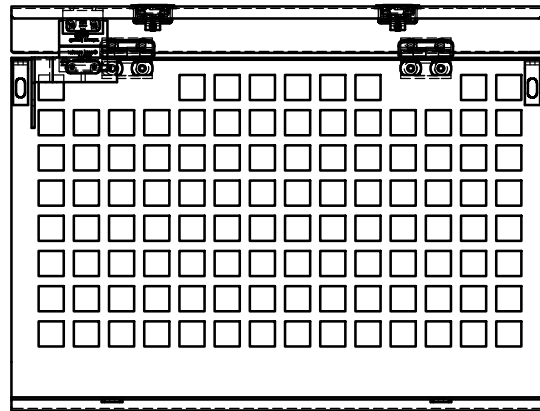
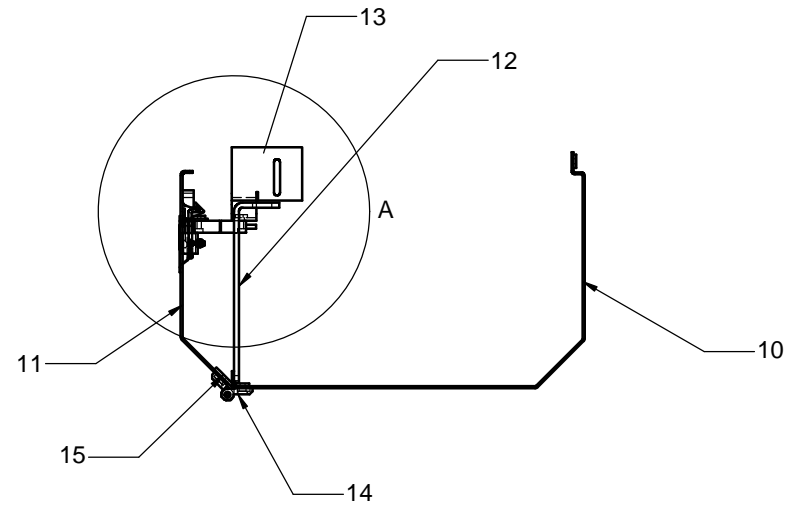
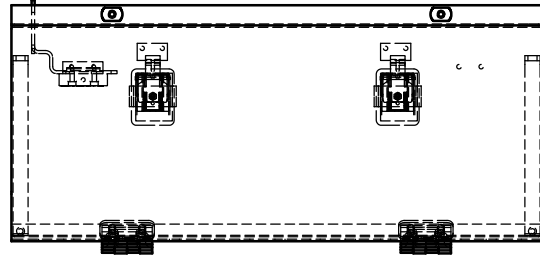
Similar to 231.062841		Drawn by: Mike Rogers	Date: 24 Sep 2007
Kit Decks and Guides 527mm Sect.		Approved by: Mike Rogers	Scale: 1:5
		Checked by: Barb Hemauer	Size: A2
		Sheet: 1/1	M-Type: 282
		231.062846	Rev.: 0
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Qty.	Index	Description	Date	ECN No.	Changed by

Material	C282	01	0010	Alt.	Usage 3	
	Linium Infeed Conveyor			Valid	10/01/2007	
Reqd qty		1.000	EA	Base quant	1.000 EA	
Sales ord.	129850			Item	000340	
Lv	Item	Component no.	Description		Quant	Un
2	0000	131.020028	ASSY-RIDER BAR-200MM DROP-OFF			
3	0001	231.020028	DRAWING-ASSY-RIDER BAR-200MM DROP-OF		1.000	EA
3	0010	531.020046	01	SUPPORT-RIDER BAR-200MM DROP OFF	1.000	EA
3	0011	531.020047	BAR-CHAIN RIDER-200mm DROP-OFF		1.000	EA
3	0400	309327	SCREW-FLAT SLOT M6 X 12 SST		1.000	EA

Material	C282	01	0010	Alt.	Usage 3
	Linium Infeed Conveyor				Valid 10/01/2007
Reqd qty	1.000	EA	Base quant	1.000	EA
Sales ord.	129850		Item	000340	

Lv	Item	Component no.	Description	Quant	Un
2	0000	131.062833	KIT GUARDS 527MM SECTION		
3	0001	231.062833	DWG KIT GUARDS 527MM SECTION	1.000	EA
3	0010	531.062831	GUARD INFD 527MM	1.000	EA
3	0011	531.062832	DOOR INFD 527MM	1.000	EA
3	0012	531.028129	BRACKET GUARD SUPPORT	2.000	EA
3	0013	531.030644	02 BRACKET INTERLOCK FRAME	1.000	EA
3	0014	031.029231	HINGE-SST	2.000	EA
3	0015	531.013335	01 PLATE-NUT GUARD	2.000	EA
3	0016	531.000815	01 STOP DOOR	2.000	EA
3	0017	531.028590	01 BRACKET INTERLOCK DOOR	1.000	EA
3	0018	531.001317	01 PLATE-NUT SWITCH	2.000	EA
3	0019	031.001009	LATCH 5-PADDLE-100 SERIES	2.000	EA



A (2 : 5)

Similar to 231.062827		Drawn by: Mike Rogers	Date: 20 Sep 2007
Kit Infd Guards 1187mm Section		Approved by: Mike Rogers	Scale: 1:5
		Checked by: Barb Hemauer	Size: A2
		Sheet: 1/1	M-Type: 282
		231.062833	Rev.: 0
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Qty.	Index	Description	Date	ECN No.	Changed by
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LINIUM MODEL 611 CONTROL LOGIX HORIZONTAL WRAPPER W/DELFI & PRESTO TIE-IN

					Date	03/12/2008	Customer or Machine	Doboy Inc.	Cover page		Function	00
					Name	Dennis Neck	611 Series	869 South Knowles Ave.		=307. 00	Type of Sheet	CP
					Checked	Rod Cain	Horizontal Wrapper	New Richmond, WI 54017		BOSCH	431.063136	1
Index	Description	Date	ECN#	Chg By								30

MACHINE FUNCTIONS	
INFORMATION	00
MAIN POWER	01
DC VOLTAGE SUPPLY	06
MAIN LOGIC UNIT	08
EMERGENCY STOP	17
GUARDS	18
METERING	24
CUTTING HEAD	25
FINWHEEL	26
INFEEED	27
DISCHARGE	28
POWERFEED ROLL	29
FEEDER	30
OPTIONS	31

TYPE OF SHEET	
COVER PAGE	CV
OVERVIEW	OV
LEGEND	LE
PANEL LAYOUT	PL
REFERENCE INFO.	RF
ELECTRICAL DIAGRAM	ED

SYMBOL	DESCRIPTION
ALM	ALARM
BCM	TEMPERATURE BASE CONTROL MODULE
CB	CIRCUIT BREAKER
CON	CONTACTOR
CR	RELAY
DR	MOTOR DRIVE
DS	DISCONNECT SWITCH
ENC	ENCODER
FU	FUSE
HTR	HEAT ELEMENT
LCM	TEMPERATURE LOOP CONTROL MODULE
LS	LIMIT SWITCH/GUARD INTERLOCK
LT	LIGHT
MNT	GUARD MONITOR
MSRDO	MONITOR SAFETY RELAY DELAYED OPEN
MOV	METAL OXIDE VARISTOR
MTR	MOTOR
PB	PUSH BUTTON
PBM	PUSH BUTTON MAINTAINED
PE	PHOTO ELECTRIC EYE
PROX	PROXIMITY SWITCH
PS	PRESSURE SWITCH
PWS	POWER SUPPLY
RECP	RECEPTACLE
SOL	SOLENOID
SS	SELECTOR SWITCH
SSK	SELECTOR SWITCH KEYED
T	TRANSFORMER
T/C	TEMPERATURE SENSOR
TR	TIMER

LINE REFERENCE =08/01.10 READS AS FOLLOWS:

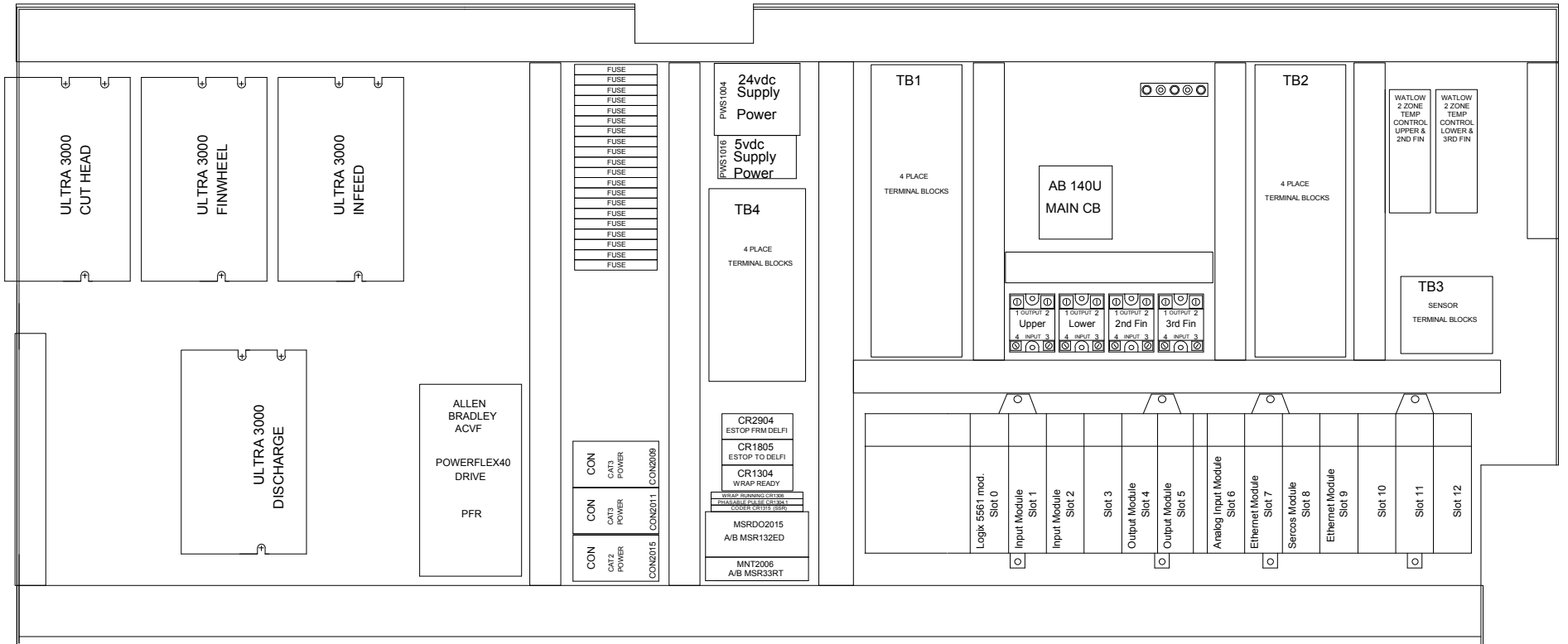
=08 IS FUNCTION 08

/01 IS PAGE 1 OF FUNCTION 08

.10 IS ROW 10 OF PAGE 1 OF FUNCTION 08

				Date	03/12/2008	Customer or Machine	Doboy Inc. 869 South Knowles Ave. New Richmond, WI 54017	Legend	=307. 00 BOSCH 431.063136	Function	00
			Name	Dennis Neck	611 Series	Type of Sheet				LE	
			Checked	Rod Cain	Horizontal Wrapper					3	
Index	Description	Date	ECN#	Chg By							30

MAIN ENCLOSURE PANEL



SHOWN FOR R-L MACHINE MIRROR FOR L-R.

					Date	03/12/2008	Customer or Machine	Doboy Inc.	Main Panel	=307. 00	Function	00
					Name	Dennis Neck	611 Series	869 South Knowles Ave.			Type of Sheet	PL
					Checked	Rod Cain	Horizontal Wrapper	New Richmond, WI 54017		BOSCH	431.063136	4
Index	Description	Date	ECN#	Chg By								30

(OPTIONAL AUXILIARY ENCLOSURE PANEL)

					Date	03/12/2008	Customer or Machine	Doboy Inc. 869 South Knowles Ave. New Richmond, WI 54017	Auxiliary Panel Layout	=307. 00 BOSCH	Function	00
				Name	Dennis Neck	611 Series	Type of Sheet				PL	
				Checked	Rod Cain	Horizontal Wrapper					5	
Index	Description	Date	ECN#	Chg By						431.063136		30

Operator Interface

Wire #	Wire color	Description
440	White	Reset light
441	Red	PWS
GND	Green	PWS
441	Grn/blk	Start
503	Blk/red	Stop
517	Grn/wht	Start
519	Blk/wht	Stop
557	Blue	Reset light
Spare	Blu/wht	
Spare	Blu/blk	
Spare	Blu/red	
516	Wht/red	E-Stop
441	Wht/blk	E-Stop
917	Orange	E-Stop
918	Org/blk	E-Stop
940	Org/red	Reset PB
Spare	Red/wht	
Spare	Red/blk	
Spare	Red/grn	
440	Black	PWS

Cable=389307

Cut Head Heater Cable

Wire #	Wire color
611	Black
612	Red
618	Orange
619	White
Spare	Green

Cable=440551
Recpt=300897

Cut Head Thermocouple Cable

Wire #	Wire color
628	Red
629	Black
630	Orange
631	White
Spare	Green

Cable=440553
Recpt=440552

2nd Finwheel Heater Cable

Wire #	Wire color
614	Black
616	White
Spare	Green

Cable=631.024247
Recpt=631.024245

2nd Finwheel Thermocouple Cable

Wire #	Wire color
671	White
672	Black
Spare	Green

Cable=631.024246
Recpt=300896

3rd Finwheel Heater Cable

Wire #	Wire color
621	Black
623	White
Spare	Green

Cable=631.024247
Recpt=631.024245

3rd Finwheel Thermocouple Cable

Wire #	Wire color
694	White
695	Black
Spare	Green

Cable=631.024246
Recpt=300896

PFR motor Cable

Wire #	Wire color
U 644	Black
V 645	White
W 646	Red
Gnd	Green

Cable=404635
Recpt=300895

Delphi Interface

Wire#	Wire Color
GND	Green
440	White
441	Red/Wht
441	Red
441	Red/Green
975	White/Red
976	Blue/Black
977	Grn/Blk/Wht
978	Orange
979	Wht/Red/Blk
980	Org/Grn
981	Black/White
982	Blu/Red
983	Wht/Blk
984	Blu/Wht
985	Grn/Wht
986	Blue
987	Blk/Red
988	Red/Blk/Wht
989	Red/Blk
990	Blk/Wht/Red
991	Org/Red

Tie back all spares.
25 cond = 389306

897	White
898	Black
SHLD	Shield

2 cond w/shld = 644-32221

Discharge Reject Cable

Wire #	Wire color	Description
440	White	24V Com
441	Blue	+24VDC
504	Red	Standby
528	Black	Uncut eye
570	Blk/wht	Reject sol
244	Grn/blk	Fan
225	Blu/blk	Fan
GND	Green	Ground
Spare	Org/blk	Spare
Spare	Red/blk	Spare
Spare	Orange	Spare
Spare	Wht/blk	Spare

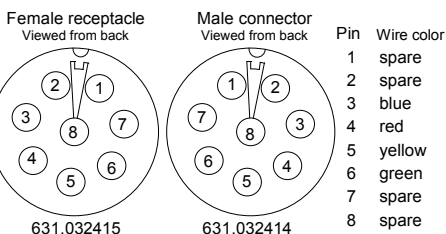
Cable=440591
Receptacle=440590

Device Net Cable

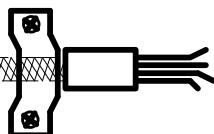
Wire #	Wire color
V-	Black
Chan I	Blue
Drain	Shld
Chan H	White
V+	Red

Cable=471657

6 wire door interlock connectors

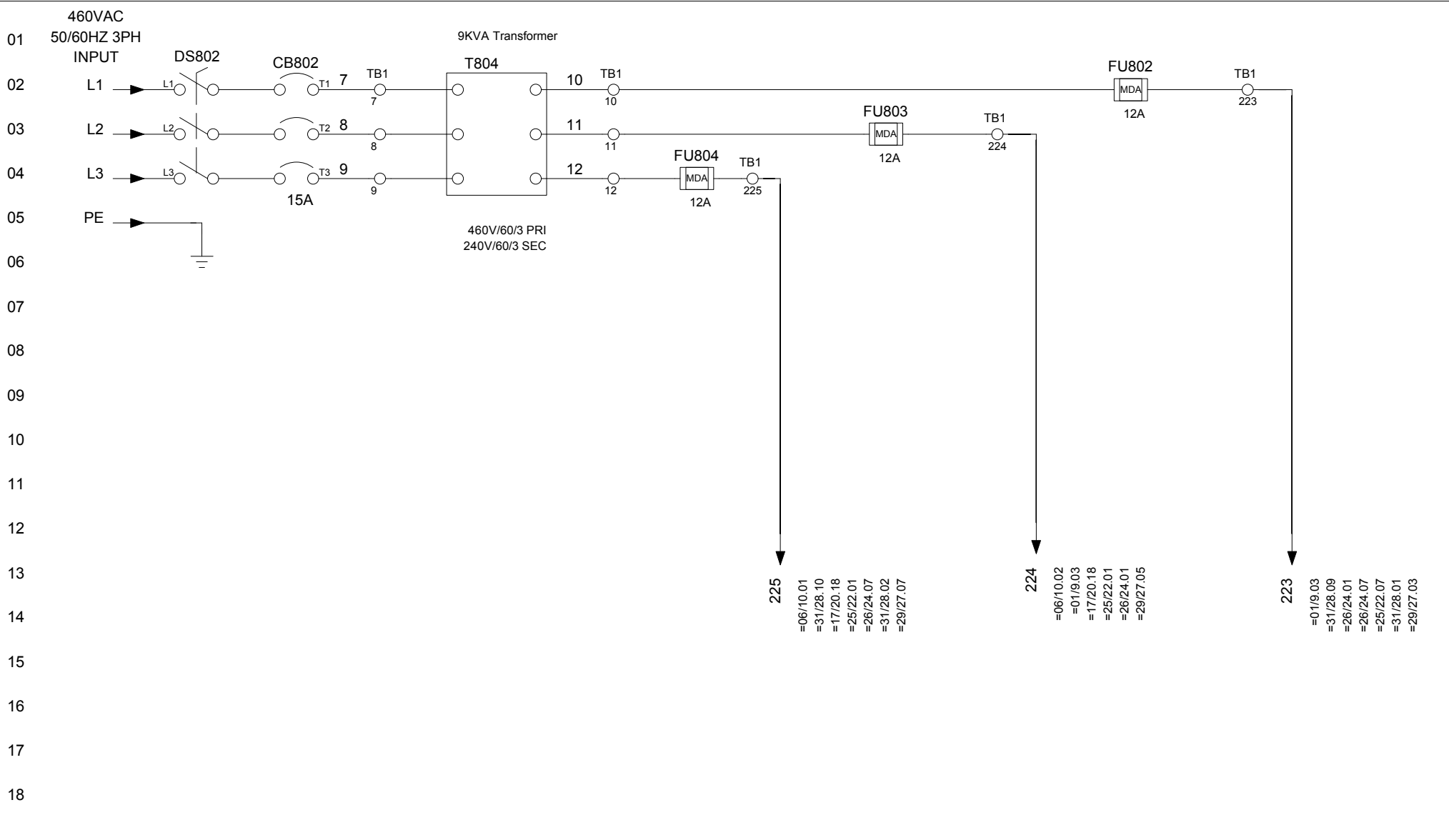


GROUND SERVO MOTOR SHIELDS WITH CLAMP PROVIDED ON AMPLIFIER.



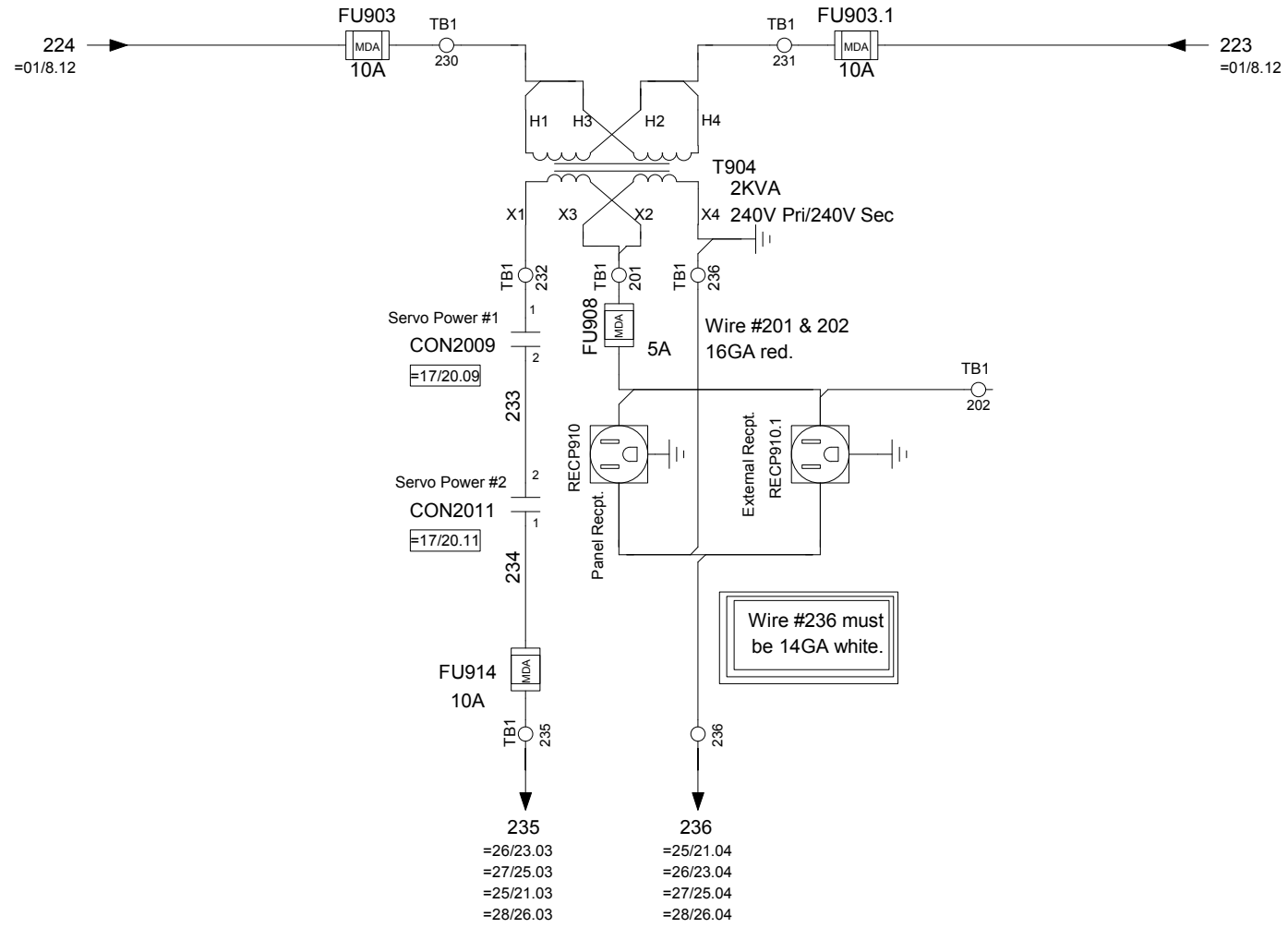
Date	03/12/2008	Customer or Machine	Doboy Inc.	Cable Reference	=307. 00	Function	00
Name	Dennis Neck		611 Series			Type of Sheet	RF
Checked	Rod Cain		Horizontal Wrapper				7
Index	Description	Date	ECN#	Chg By			30
						BOSCH	431.063136

869 South Knowles Ave.
New Richmond, WI 54017

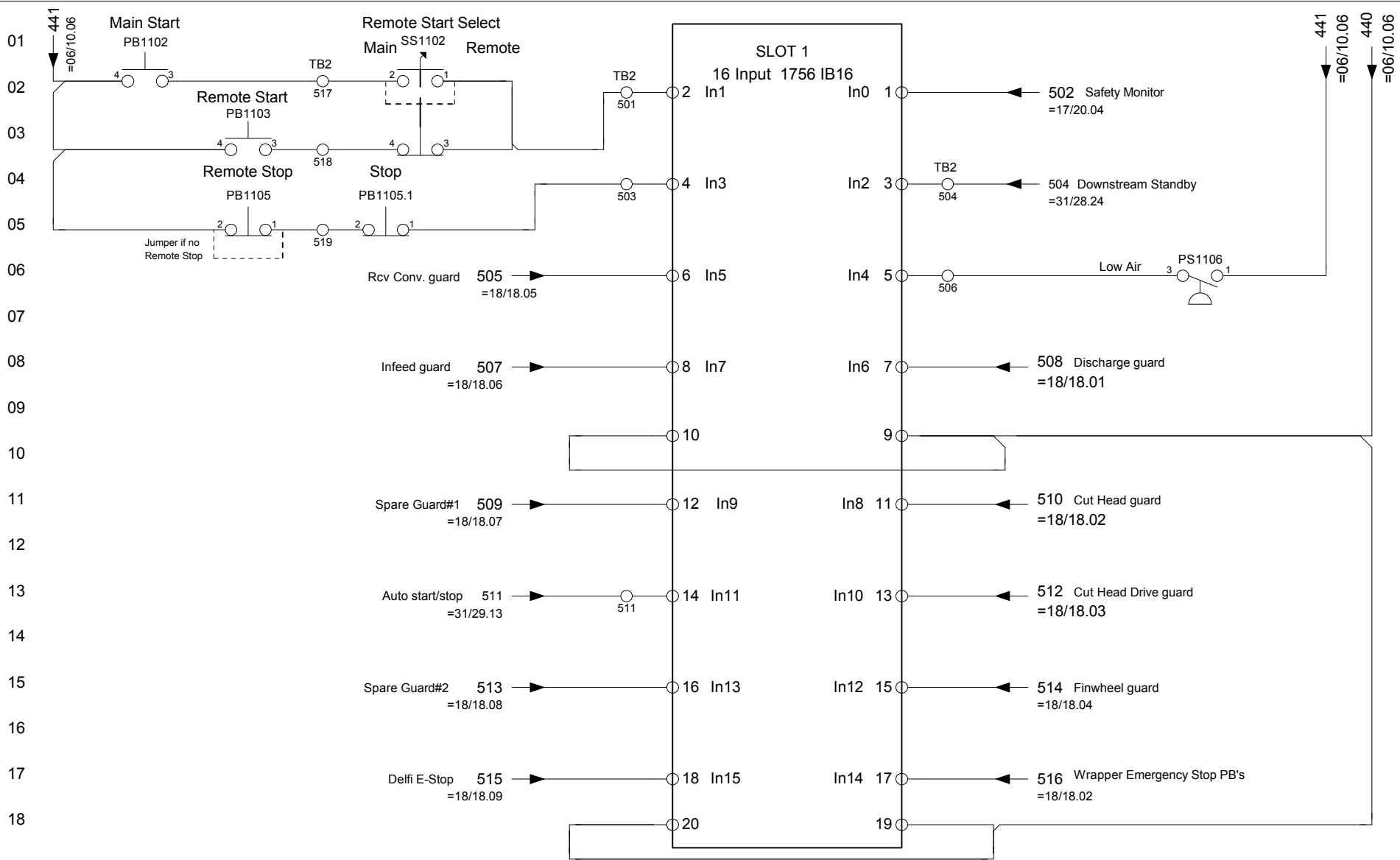


				Date	03/12/2008	Customer or Machine	Doboy Inc. 869 South Knowles Ave. New Richmond, WI 54017	Main Power	=307. 01 BOSCH 431.063136	Function	01
			Name	Dennis Neck	611 Series	Type of Sheet				ED	
			Checked	Rod Cain	Horizontal Wrapper					8	
Index	Description	Date	ECN#	Chg By							30

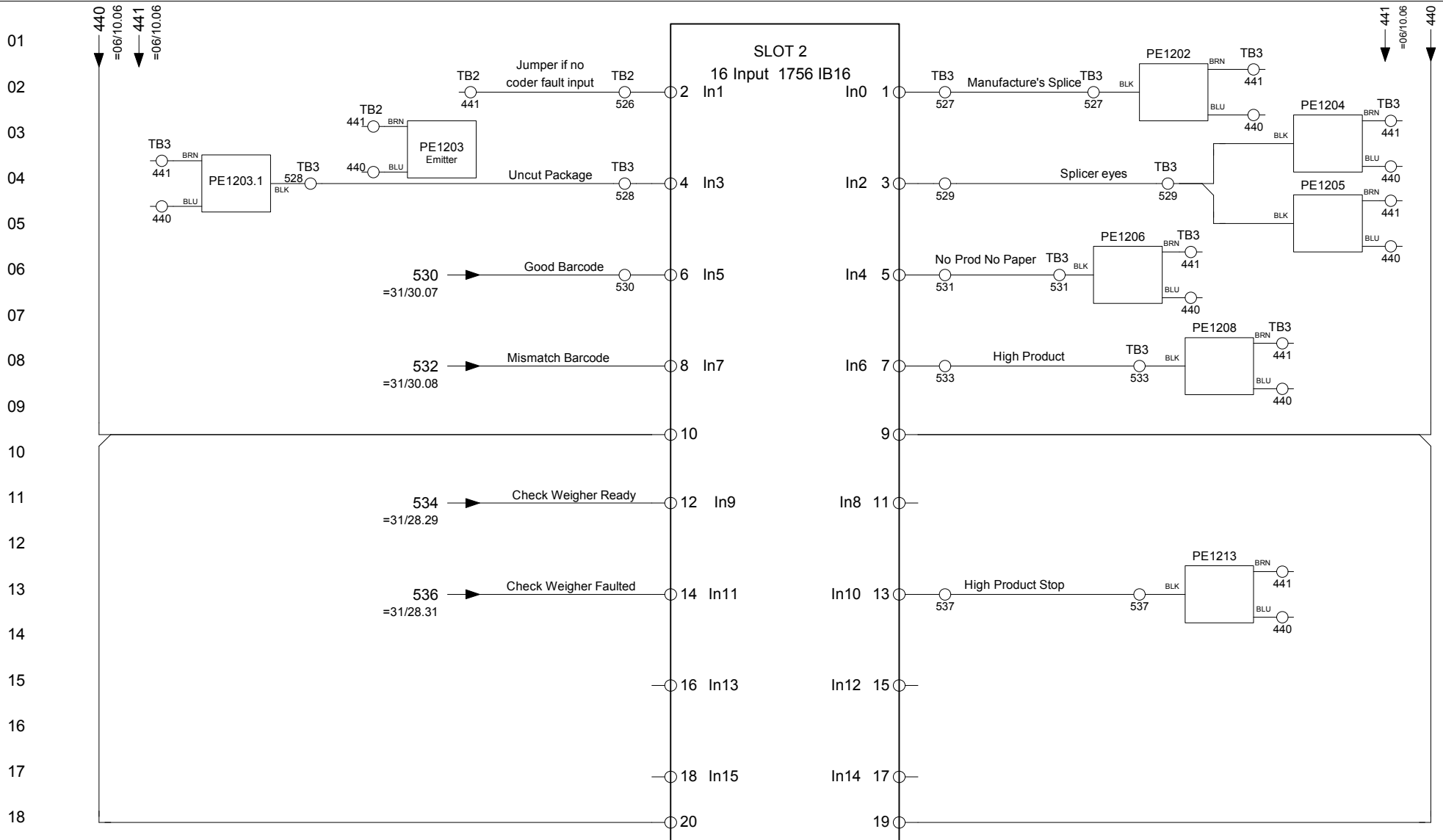
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				Date	03/12/2008	Customer or Machine	Doboy Inc.	Main Power	=307. 01	Function	01
				Name	Dennis Neck	611 Series	869 South Knowles Ave.			Type of Sheet	ED
				Checked	Rod Cain	Horizontal Wrapper	New Richmond, WI 54017		BOSCH		9
Index	Description	Date	ECN#	Chg By						431.063136	



		Date	03/12/2008	Customer or Machine		Doboy Inc. 869 South Knowles Ave. New Richmond, WI 54017	Main Logic Unit: Slot 1 Input Control Logix	=307. 08 BOSCH 431.063136		Function	08
		Name	Dennis Neck	611 Series Horizontal Wrapper						Type of Sheet	ED
		Checked	Rod Cain								
Index	Description	Date	ECN#	Chg By							30



				Date	03/12/2008	Customer or Machine	Doboy Inc.	Main Logic Unit:	=307. 08	Function	08
				Name	Dennis Neck	611 Series	869 South Knowles Ave.	Slot 2 Input		Type of Sheet	ED
				Checked	Rod Cain	Horizontal Wrapper	New Richmond, WI 54017	Control Logix	BOSCH		12
Index	Description	Date	ECN#	Chg By						431.063136	

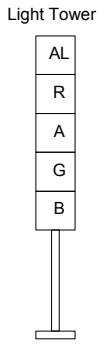
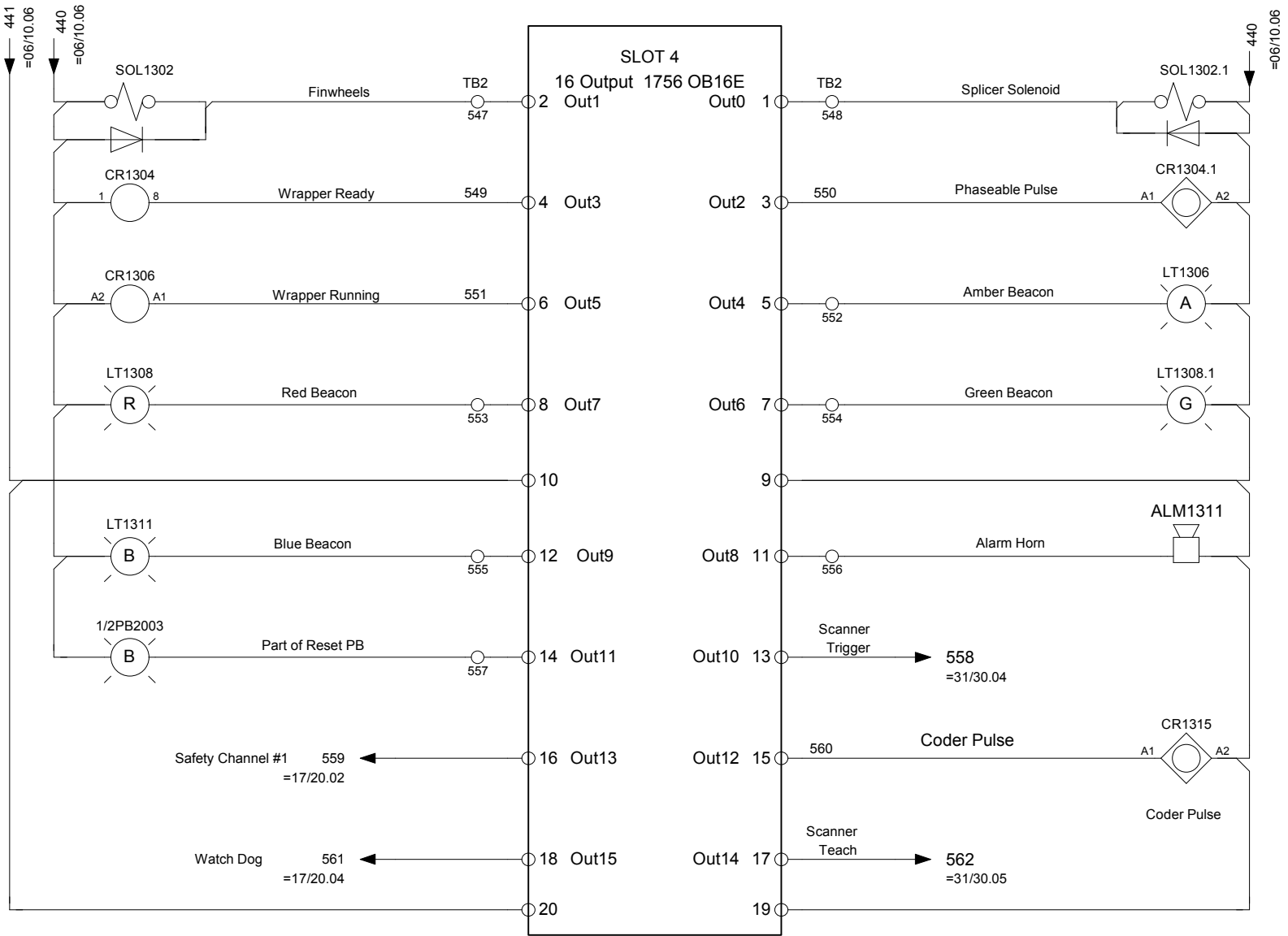
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NO | NC
=31/29.10

NO | NC
=31/28.22

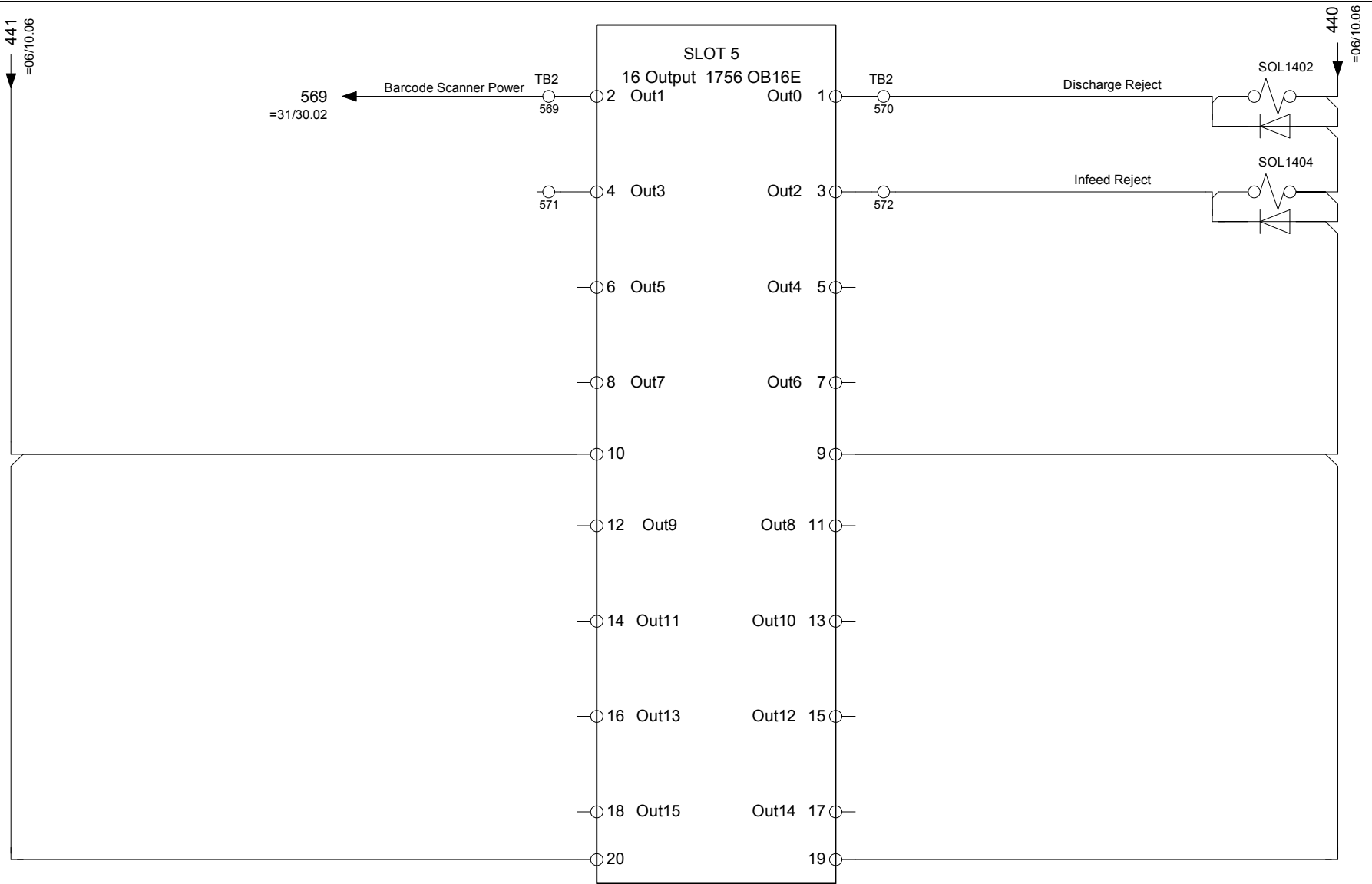
NO | NC

NO | NC
=31/28.04



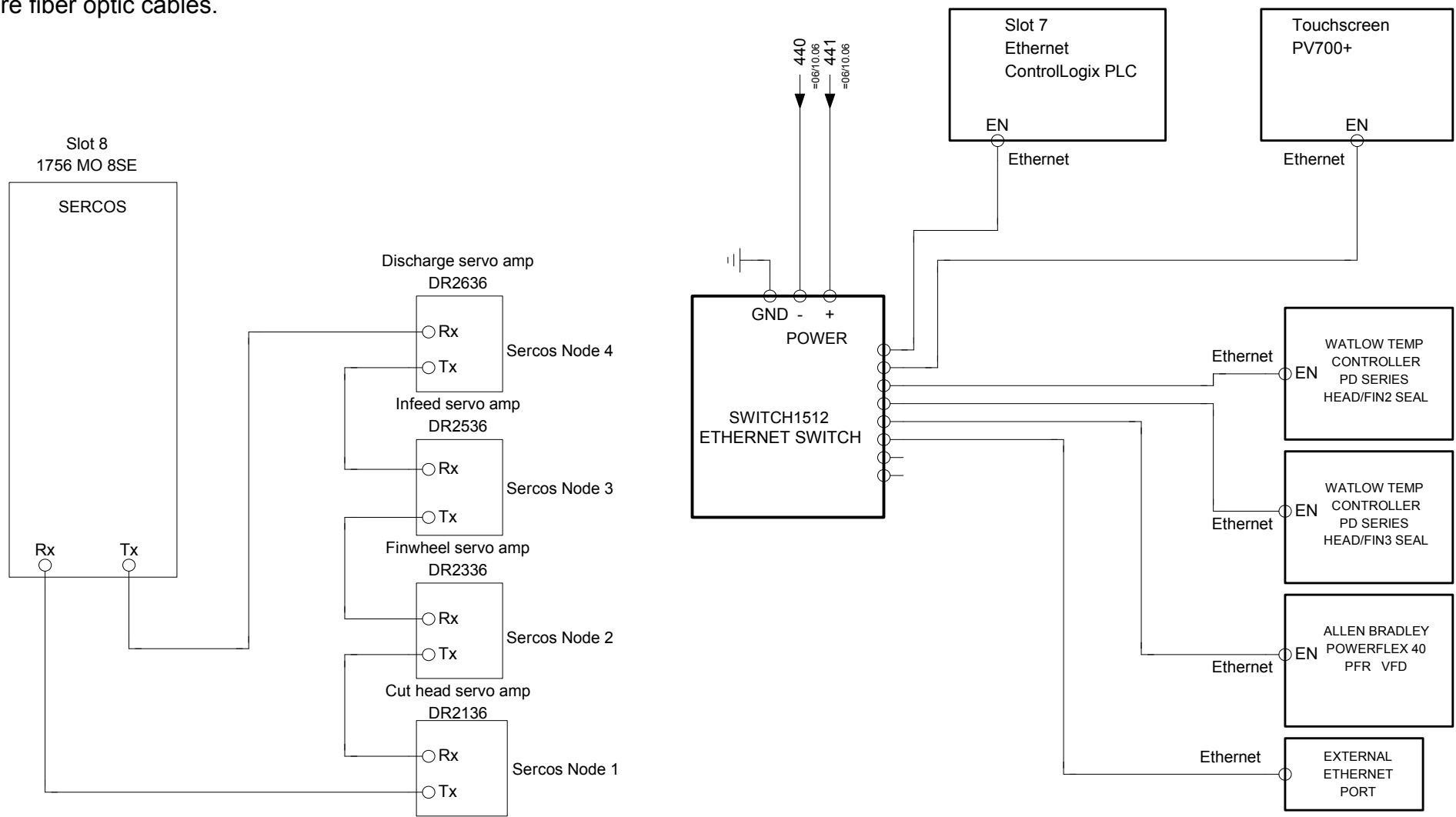
		Date	03/12/2008	Customer or Machine		Doboy Inc. 869 South Knowles Ave. New Richmond, WI 54017	Main Logic Unit: Slot 4 Output Control Logix	=307. 08	Function	08
		Name	Dennis Neck	611 Series					Type of Sheet	ED
		Checked	Rod Cain	Horizontal Wrapper						13
Index	Description	Date	ECN#	Chg By				BOSCH	431.063136	30

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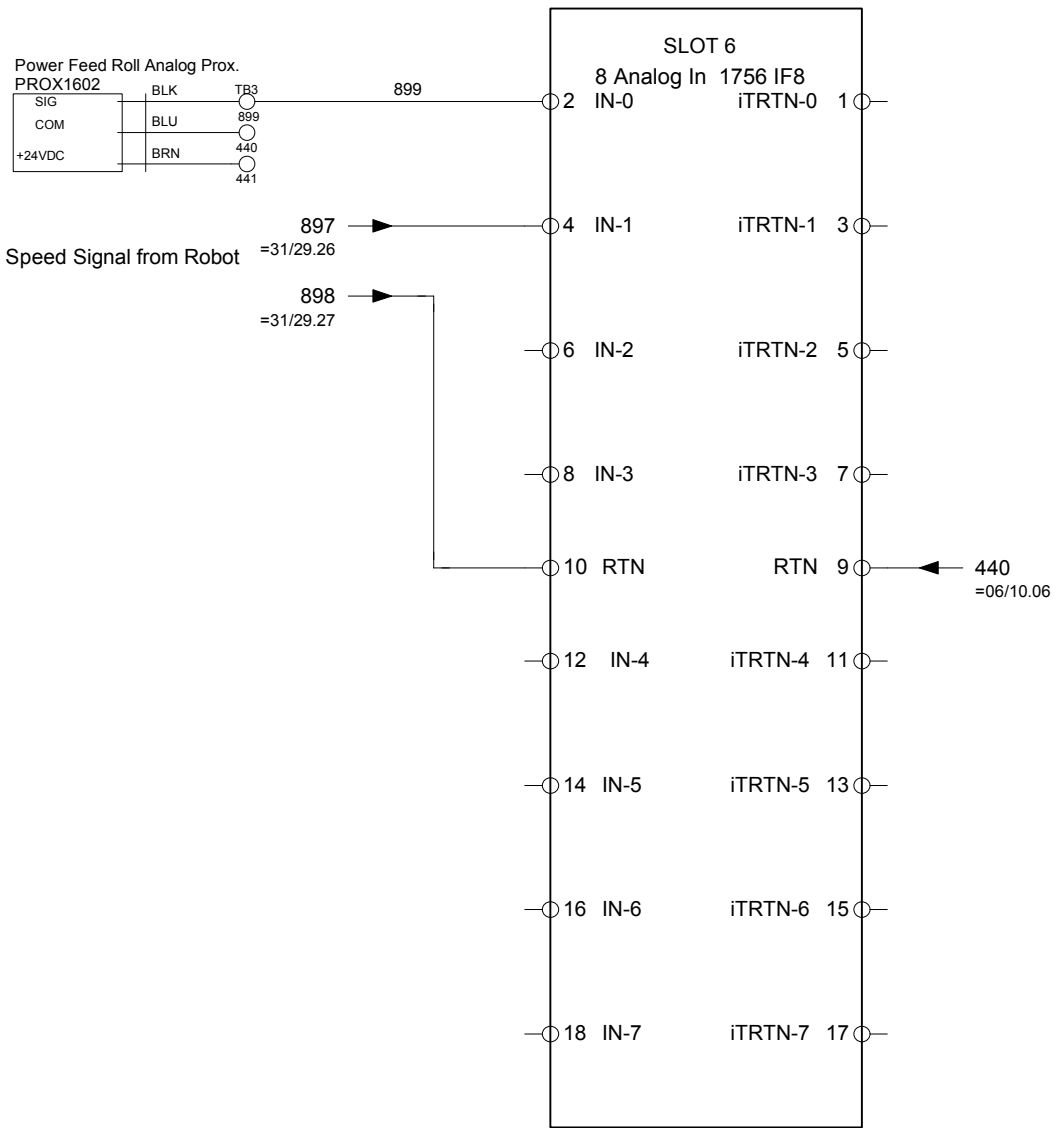
				Date	03/12/2008	Customer or Machine	Doboy Inc.	Main Logic Unit:	=307. 08	Function	08
				Name	Dennis Neck	611 Series	869 South Knowles Ave.	Slot 5 Output		Type of Sheet	ED
				Checked	Rod Cain	Horizontal Wrapper	New Richmond, WI 54017	Control Logix	BOSCH		14
Index	Description	Date	ECN#	Chg By						431.063136	

01 Shown connections
02 are fiber optic cables.



				Date	03/12/2008	Customer or Machine	Doboy Inc.	Main Logic Unit:	=307. 08	Function	08
				Name	Dennis Neck	611 Series	869 South Knowles Ave.	Sercos and Ethernet		Type of Sheet	ED
				Checked	Rod Cain	Horizontal Wrapper	New Richmond, WI 54017	Slots 7 & 8			15
Index	Description	Date	ECN#	Chg By					BOSCH	431.063136	30

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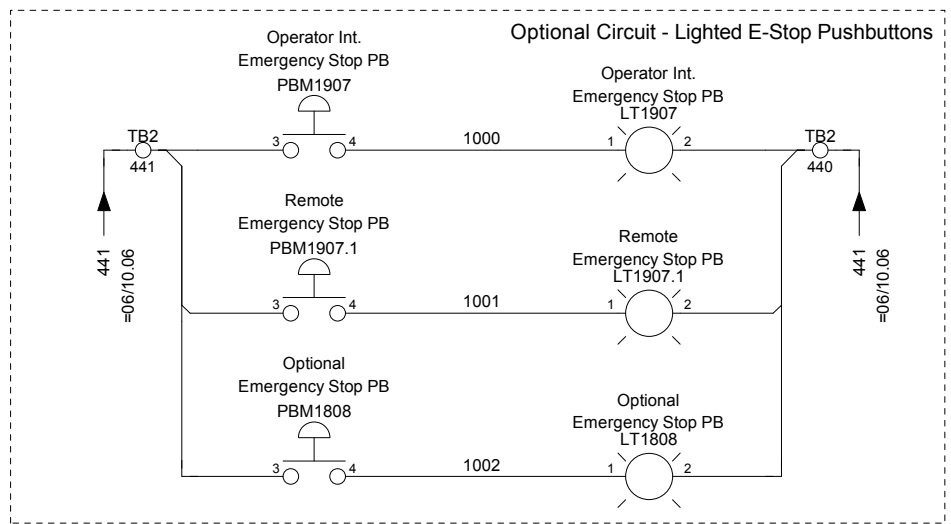
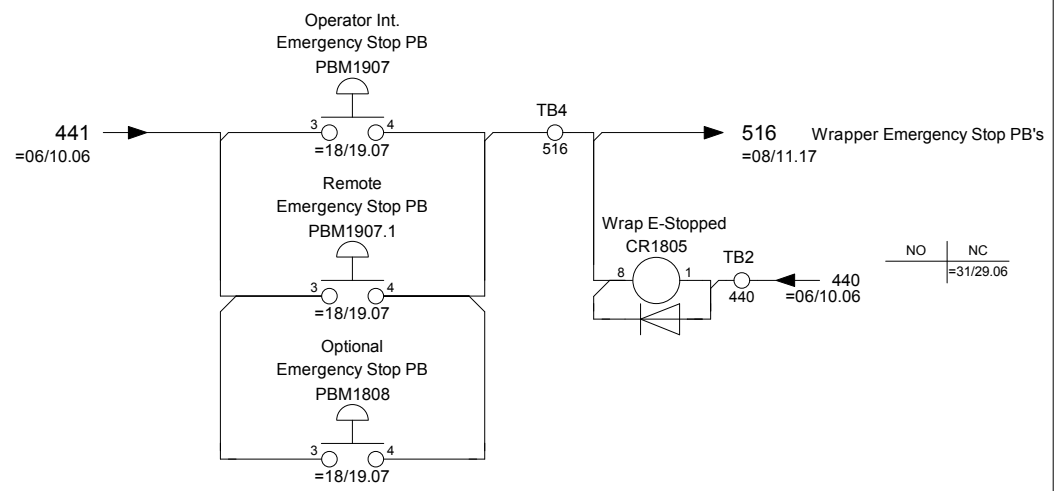
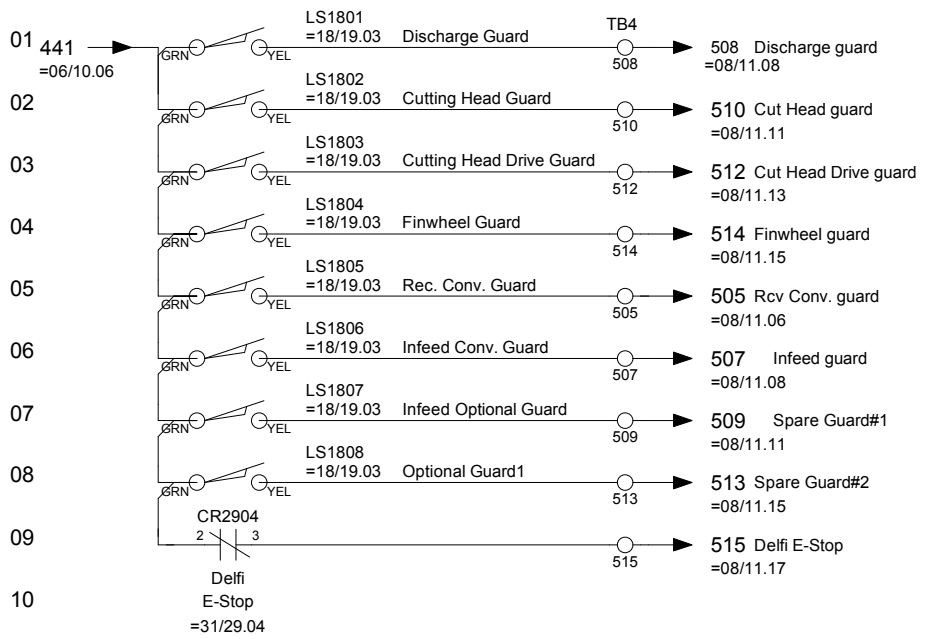


				Date	03/12/2008	Customer or Machine	Doboy Inc.	Main Logic Unit:	=307. 08	Function	08
				Name	Dennis Neck	611 Series	869 South Knowles Ave.	Analog Input		Type of Sheet	ED
				Checked	Rod Cain	Horizontal Wrapper	New Richmond, WI 54017	Slot 6	BOSCH		16
Index	Description	Date	ECN#	Chg By						431.063136	

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				Date	03/12/2008	Customer or Machine	Doboy Inc. 869 South Knowles Ave. New Richmond, WI 54017	Main Logic Unit: Blank	=307. 08 BOSCH	Function	08
			Name	Dennis Neck	611 Series	Type of Sheet				ED	
			Checked	Rod Cain	Horizontal Wrapper	17					
Index	Description	Date	ECN#	Chg By					431.063136	30	



Date	03/12/2008	Customer or Machine	Doboy Inc.	Guards & E-stop N.O.	Function	18
Name	Dennis Neck		611 Series		Type of Sheet	ED
Checked	Rod Cain		Horizontal Wrapper			
Index	Description	Date	ECN#	Chg By		

Doboy Inc.
869 South Knowles Ave.
New Richmond, WI 54017

=307. 18

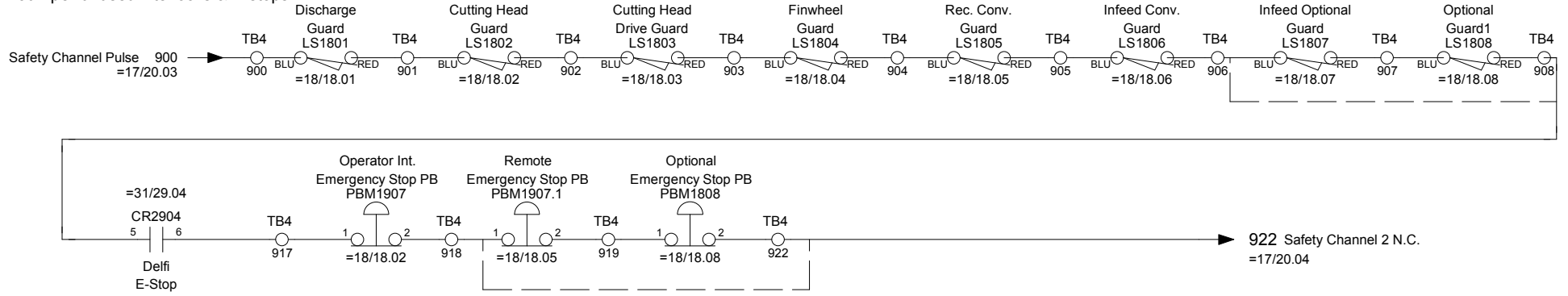
BOSCH

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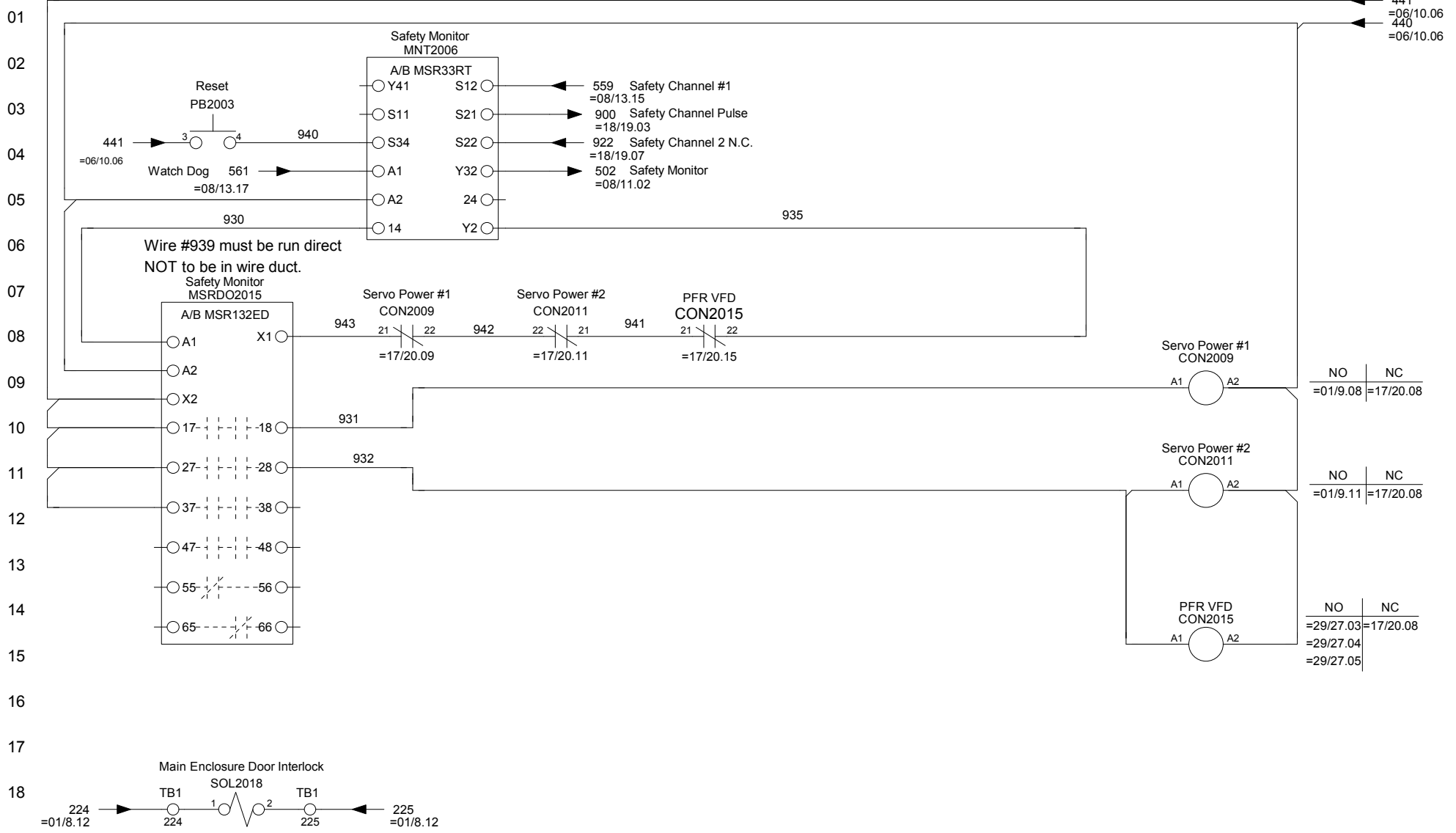
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NOTE:

- 01 Guard switches shown in guard closed state.
- 02 Estop Pushbuttons shown in the operator extended position.
- 03 Jumper unused interlocks & E-stops.

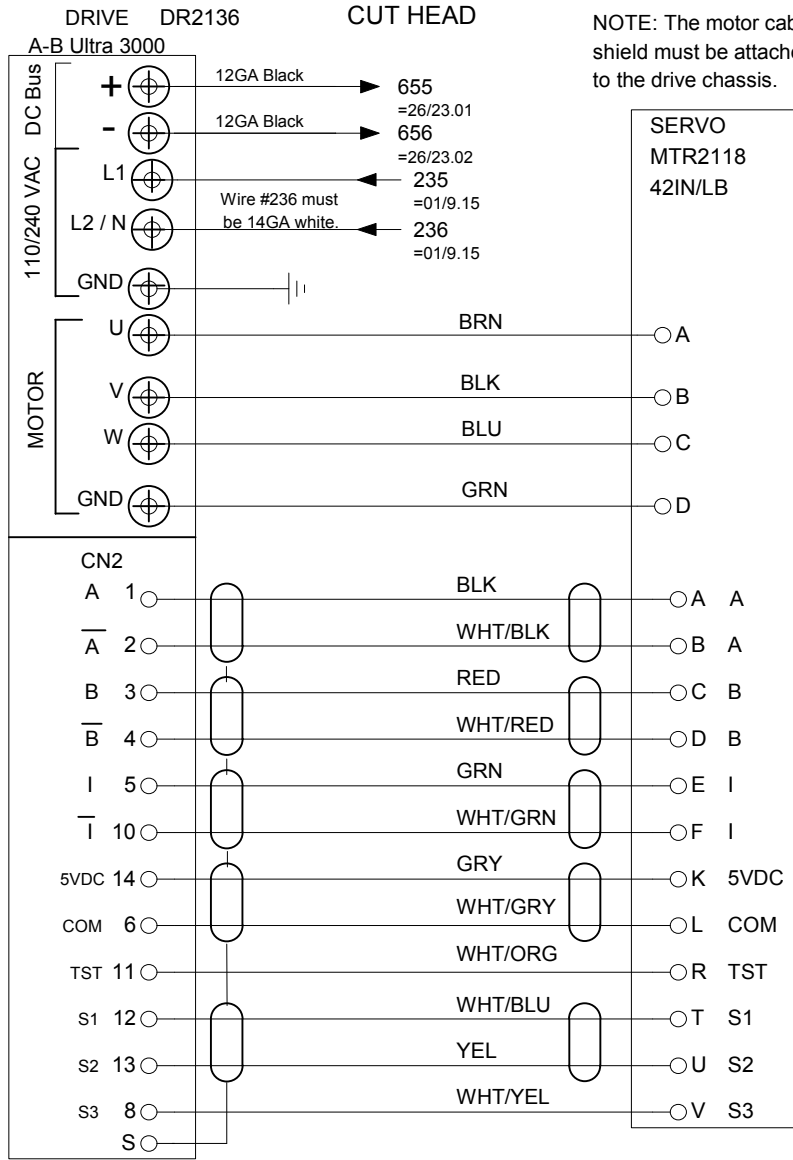


				Date	03/12/2008	Customer or Machine	Doboy Inc. 869 South Knowles Ave. New Richmond, WI 54017	Guards & E-stop N.C. =307. 18 BOSCH 431.063136	Function	18
			Name	Dennis Neck	611 Series	Type of Sheet			ED	
			Checked	Rod Cain	Horizontal Wrapper				19	
Index	Description	Date	ECN#	Chg By						30



					Date	03/12/2008	Customer or Machine	Doboy Inc.	Safety Monitor	=307. 17	Function	17
					Name	Dennis Neck	611 Series	869 South Knowles Ave.			Type of Sheet	ED
					Checked	Rod Cain	Horizontal Wrapper	New Richmond, WI 54017		BOSCH	431.063136	20
Index	Description	Date	ECN#	Chg By								30

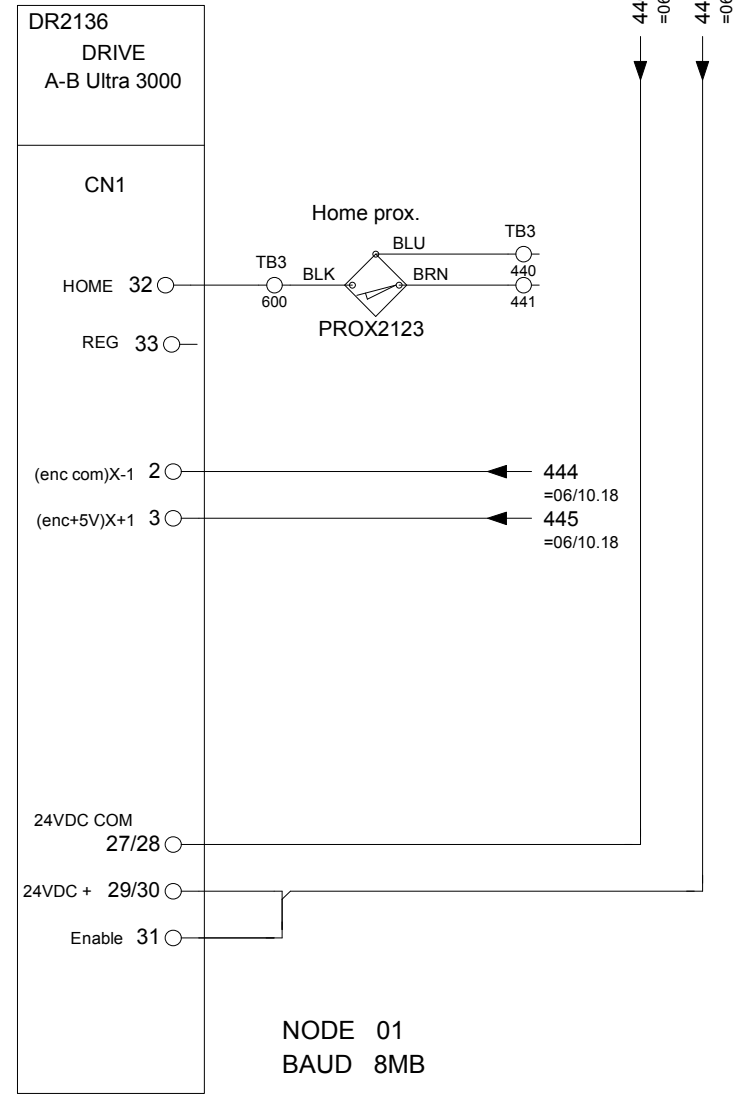
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NOTE: The motor cable shield must be attached to the drive chassis.

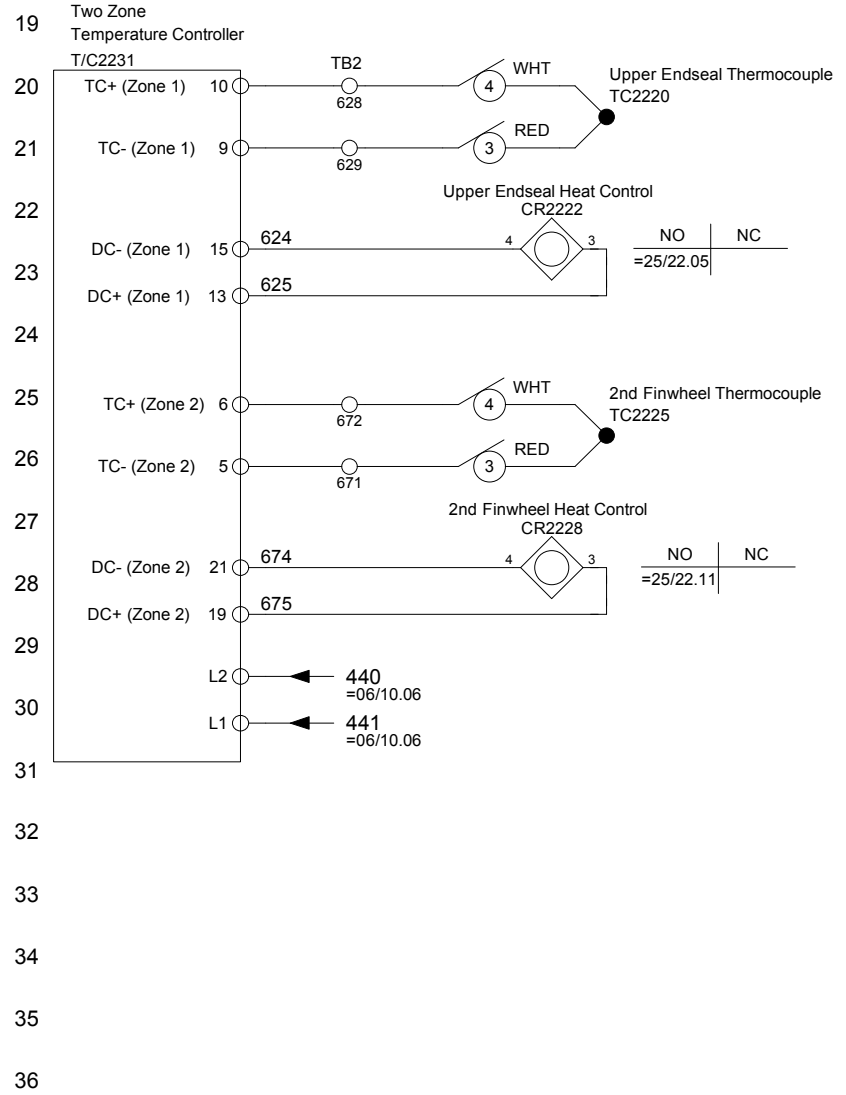
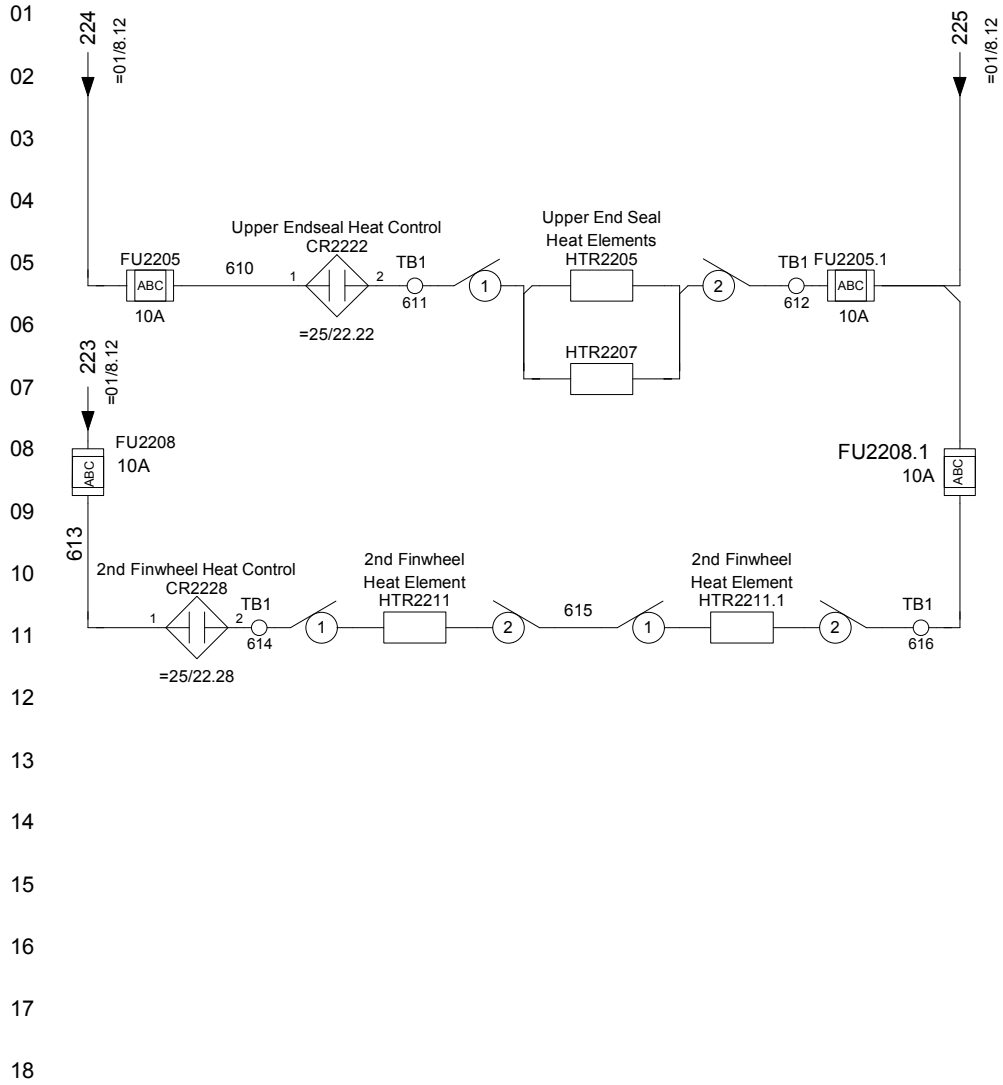
SERVO
MTR2118
42IN/LB

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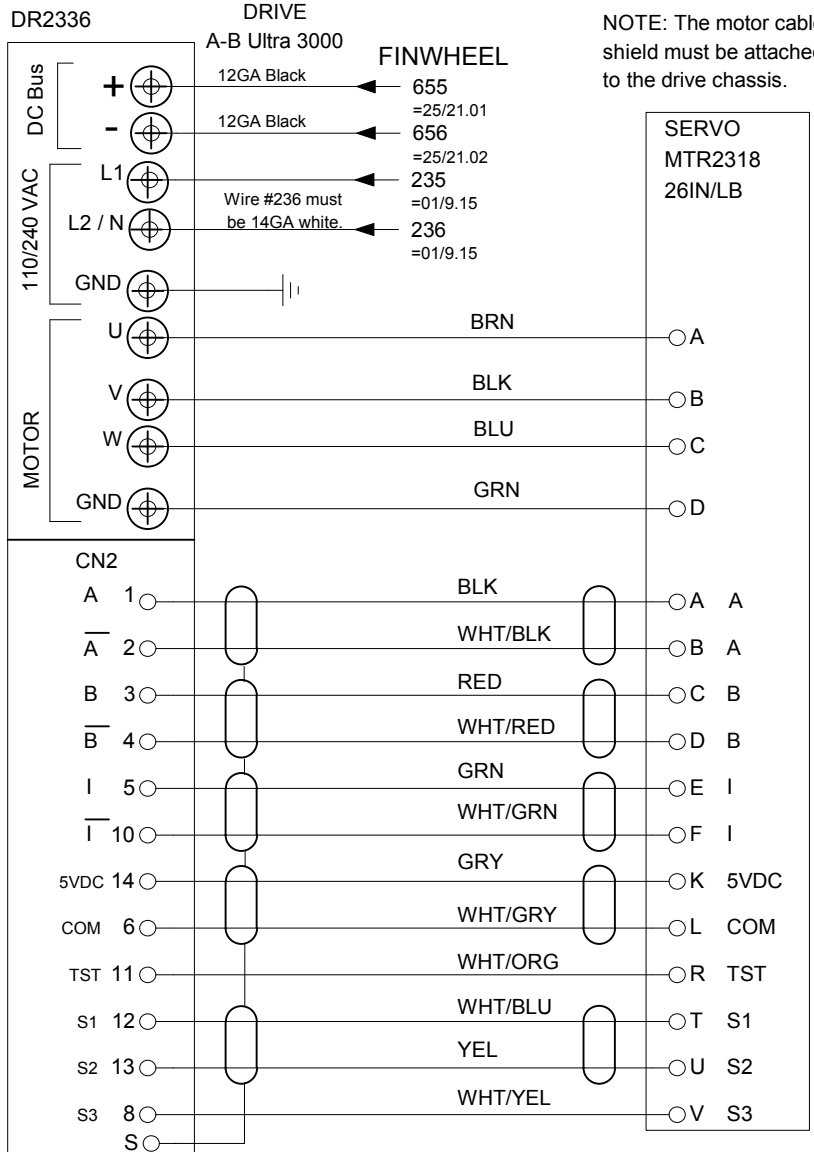
NODE 01
BAUD 8MB

		Date	03/12/2008	Customer or Machine		Doboy Inc. 869 South Knowles Ave. New Richmond, WI 54017	Cutthead: motor and control	=307. 25	Function	25
		Name	Dennis Neck	611 Series Horizontal Wrapper					Type of Sheet	ED
		Checked	Rod Cain							21
Index	Description	Date	ECN#	Chg By			BOSCH 431.063136		30	

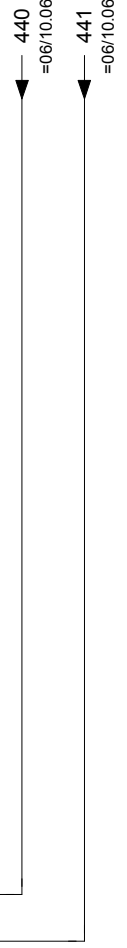
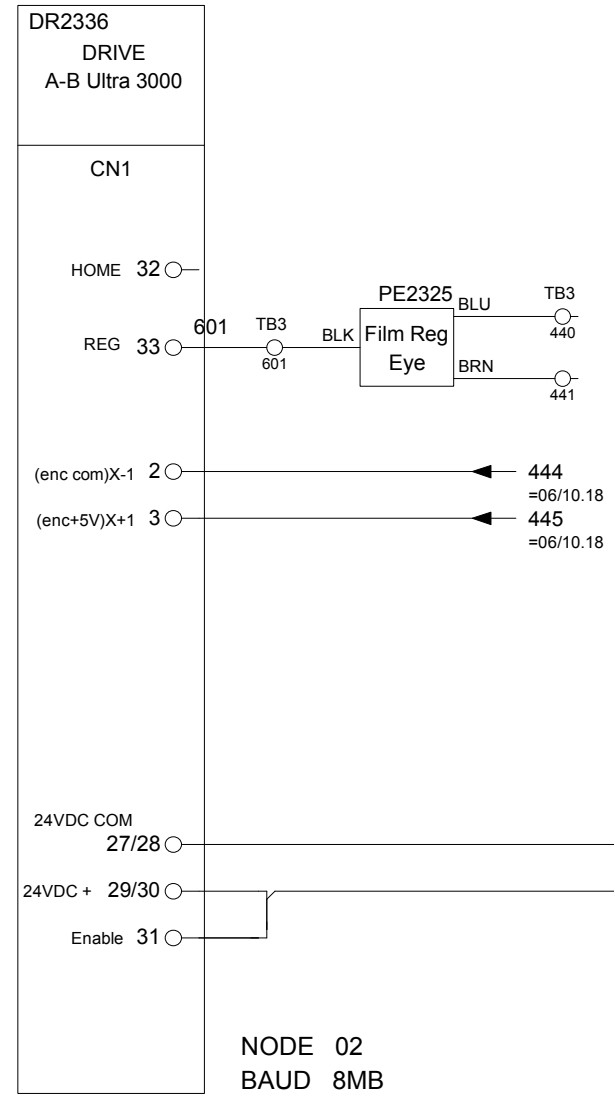


				Date	03/12/2008	Customer or Machine	Doboy Inc.	Upper crimper/ 2nd finwheel heat control	=307. 25 BOSCH 431.063136	Function	25
				Name	Dennis Neck	611 Series Horizontal Wrapper	869 South Knowles Ave. New Richmond, WI 54017	Type of Sheet		ED	
				Checked	Rod Cain						22
Index	Description	Date	ECN#	Chg By							30

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NODE 02
BAUD 8MB

Date	03/12/2008	Customer or Machine	611 Series Horizontal Wrapper	
Name	Dennis Neck			
Checked	Rod Cain			
Index	Description	Date	ECN#	Chg By

Doboy Inc.
869 South Knowles Ave.
New Richmond, WI 54017

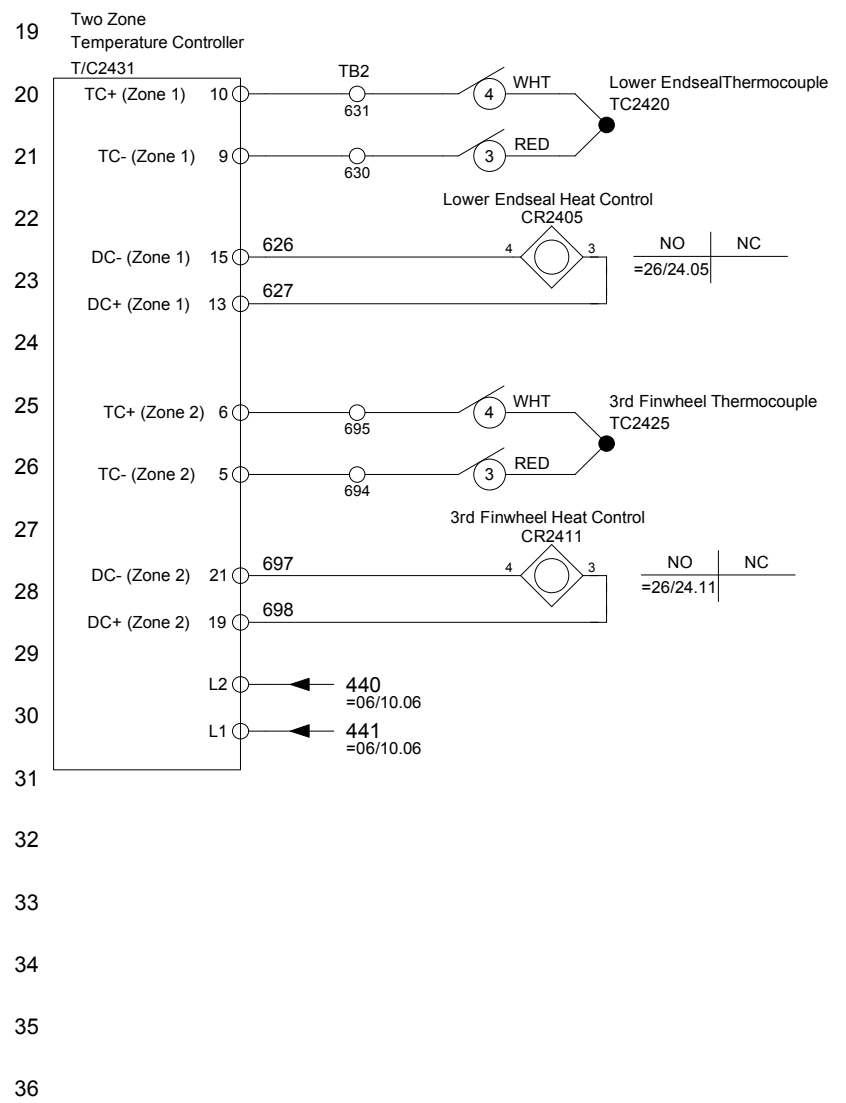
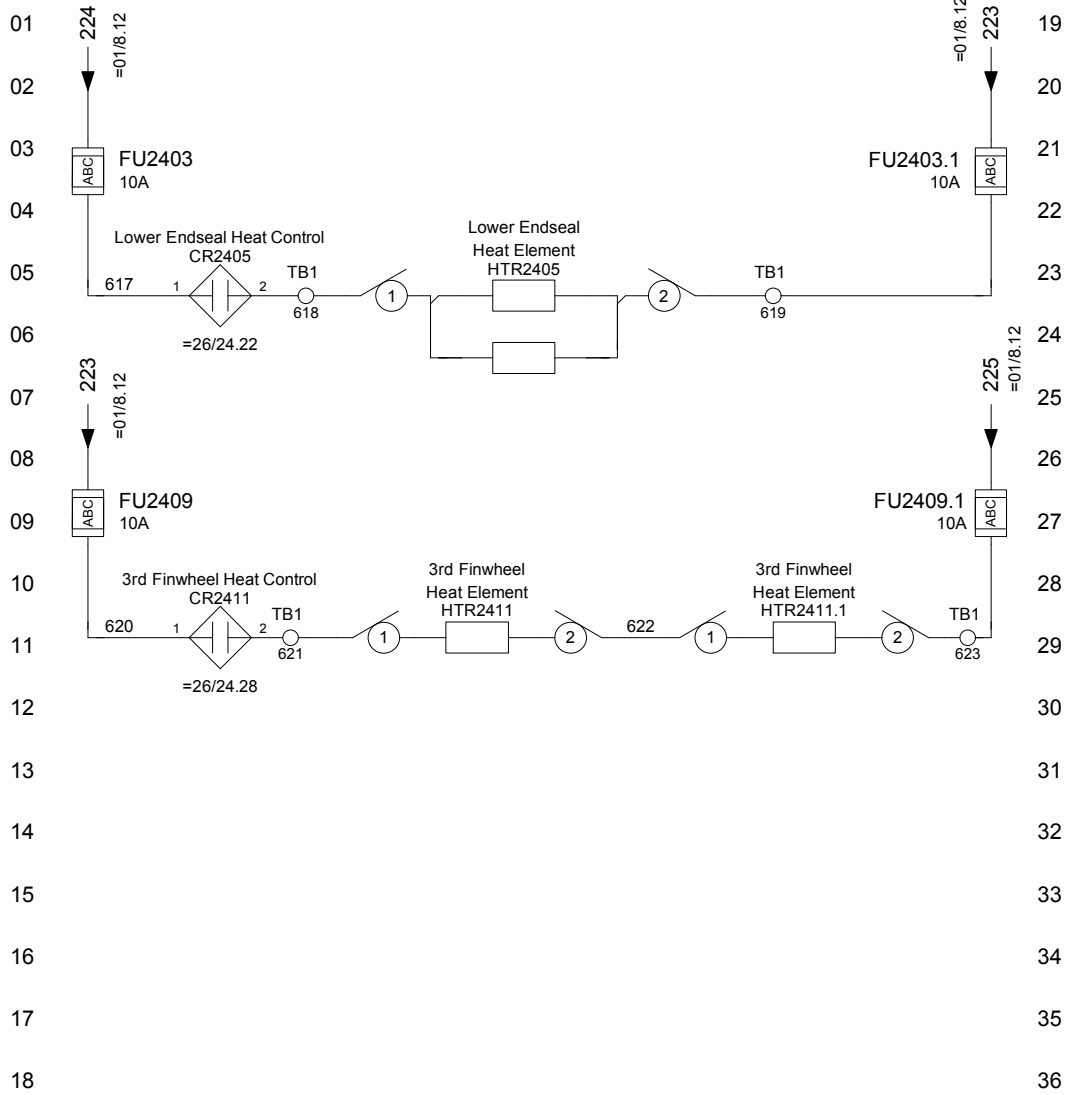
Finwheel:
motor and control

=307. 26

BOSCH

431.063136

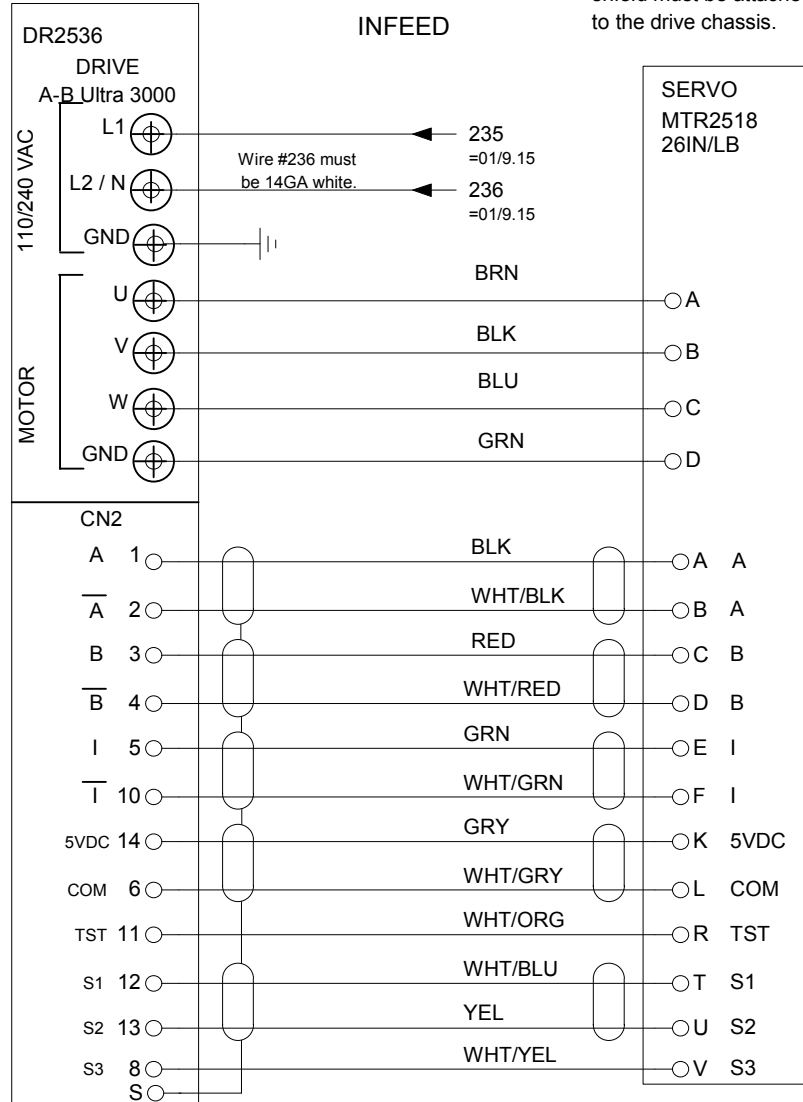
Function	26
Type of Sheet	ED
	23
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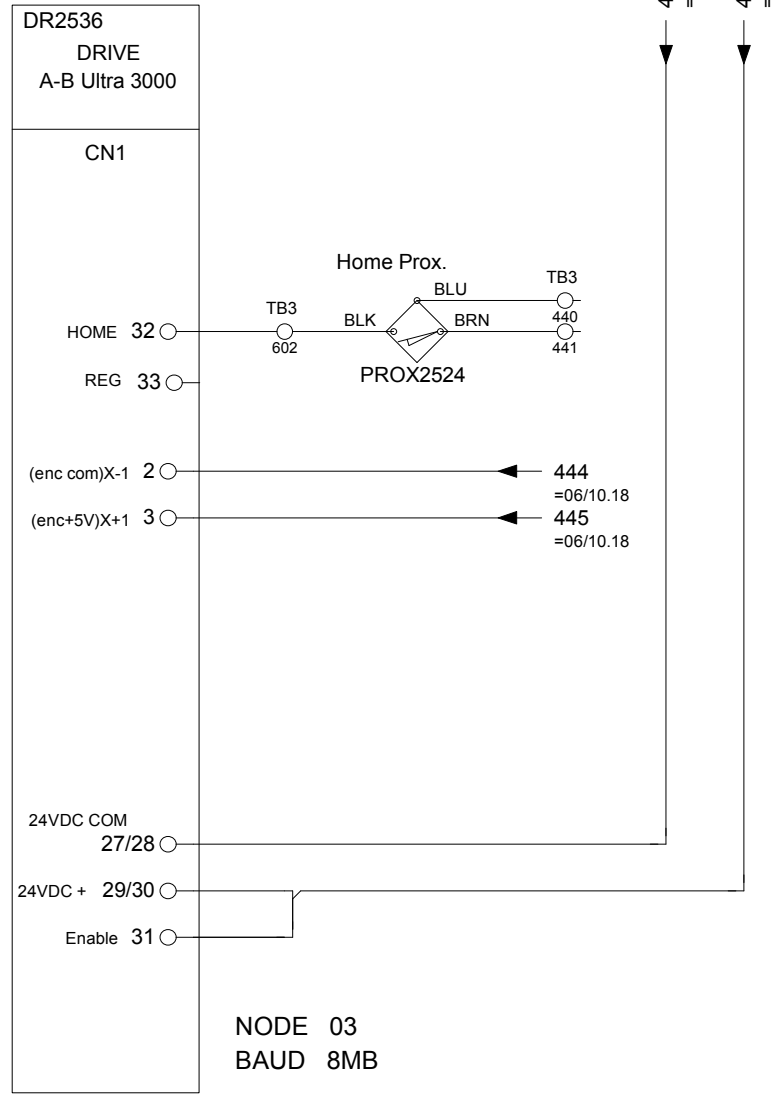
				Date	03/12/2008	Customer or Machine	Doboy Inc.	Lower crimper/ 3rd finwheel heat control	=307. 26	Function	26
				Name	Dennis Neck	611 Series Horizontal Wrapper	869 South Knowles Ave. New Richmond, WI 54017			Type of Sheet	ED
				Checked	Rod Cain				BOSCH		24
Index	Description	Date	ECN#	Chg By						431.063136	

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NOTE: The motor cable shield must be attached to the drive chassis.



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Index	Description	Date	ECN#	Chg By

Date	03/12/2008
Name	Dennis Neck
Checked	Rod Cain
Customer or Machine	611 Series Horizontal Wrapper

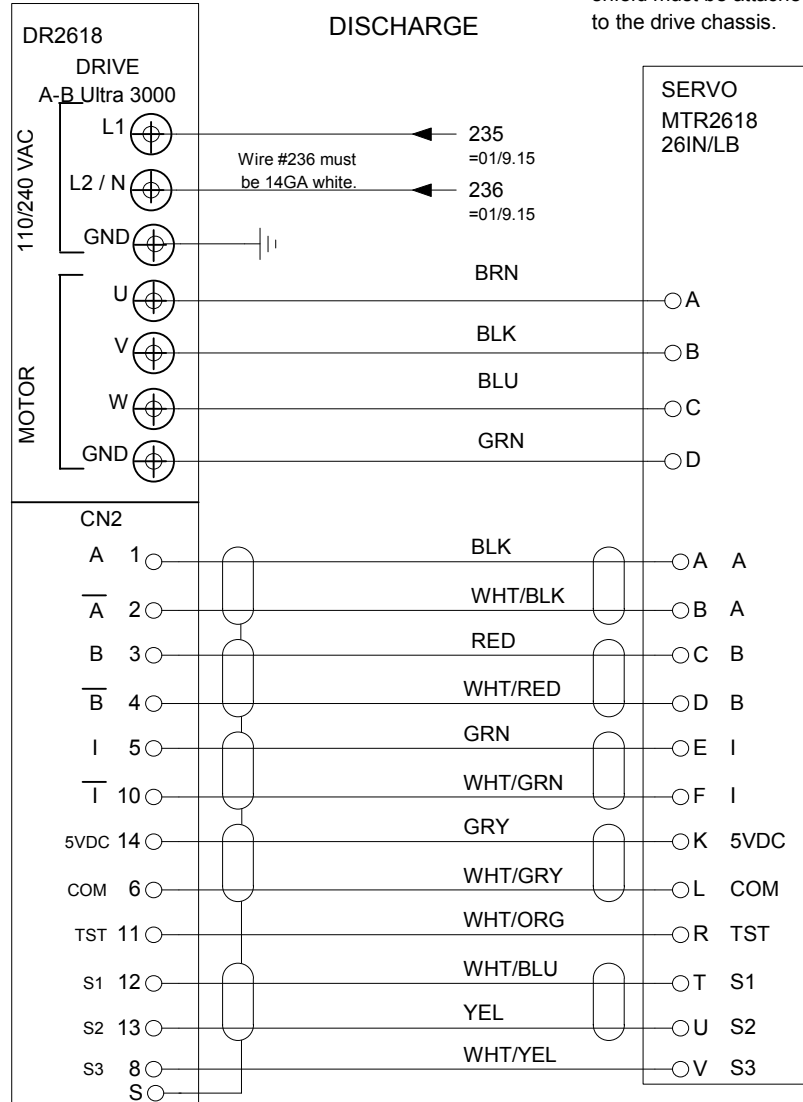
Doboy Inc.
869 South Knowles Ave.
New Richmond, WI 54017

Infeed:
motor and control

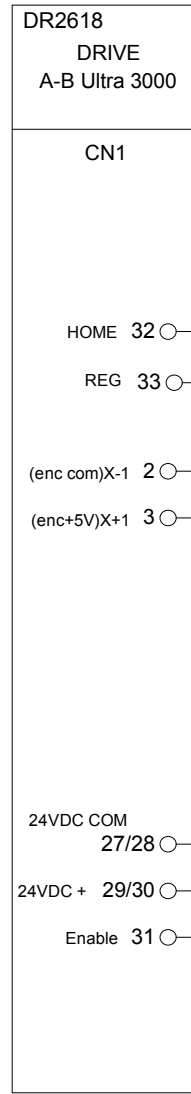
=307. 27	Function	27
	Type of Sheet	ED
BOSCH	431.063136	25
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NOTE: The motor cable shield must be attached to the drive chassis.



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NODE 04
BAUD 8MB



Index	Description	Date	ECN#	Chg By

Date	03/12/2008
Name	Dennis Neck
Checked	Rod Cain

Customer or Machine
611 Series
Horizontal Wrapper

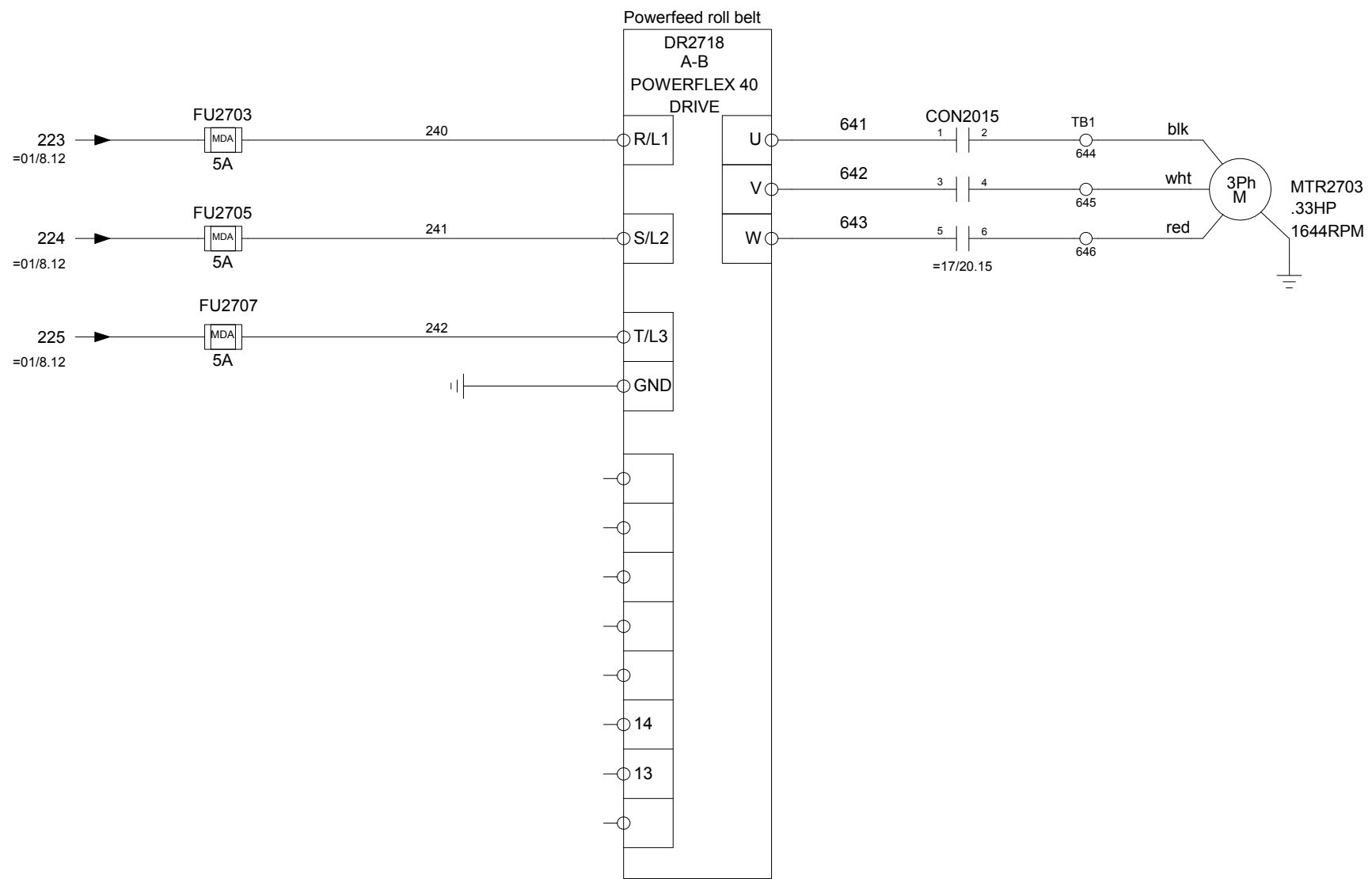
Doboy Inc.
869 South Knowles Ave.
New Richmond, WI 54017

Discharge:
motor and control

BOSCH	431.063136	Function	28
		Type of Sheet	ED
			26
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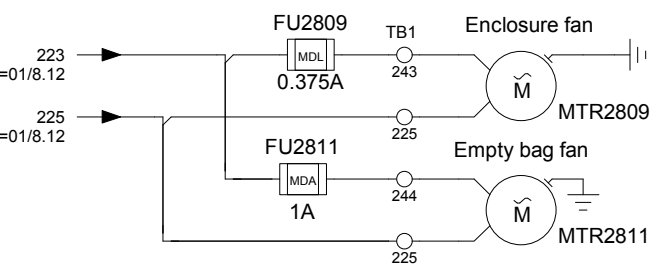
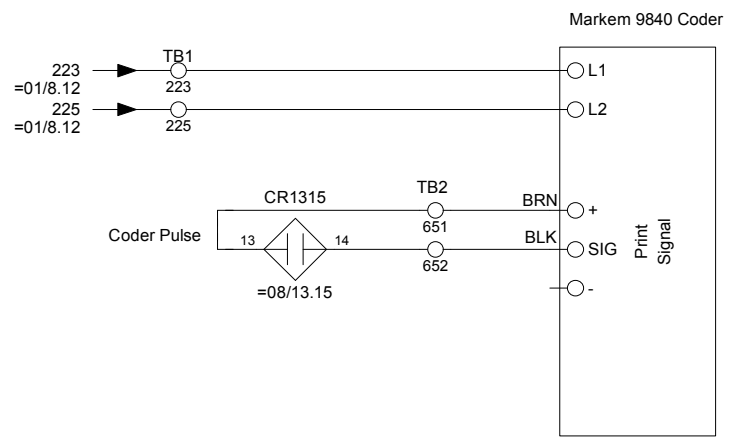
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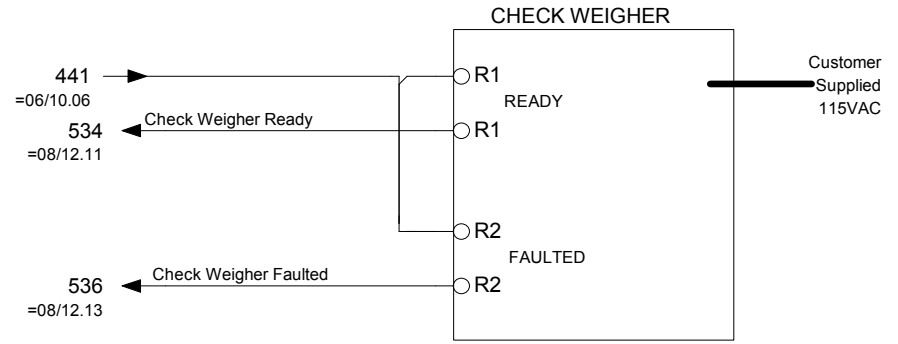
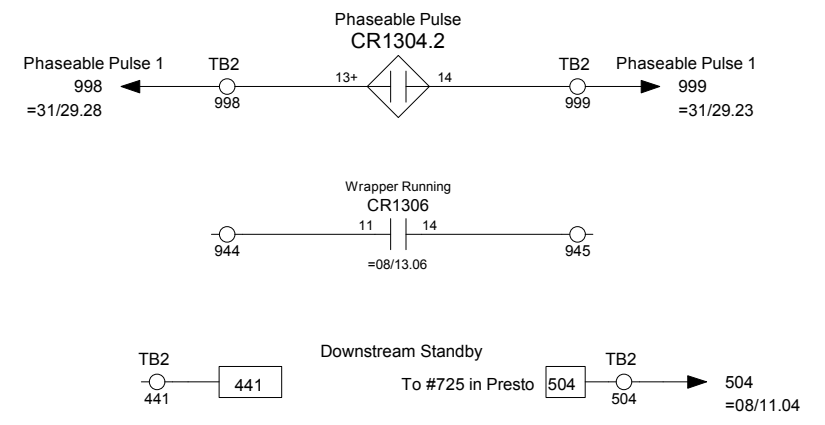


				Date	03/12/2008	Customer or Machine	Doboy Inc.	Powerfeed roll:	=307. 29	Function	29
				Name	Dennis Neck	611 Series	869 South Knowles Ave.	motor and control		Type of Sheet	ED
				Checked	Rod Cain	Horizontal Wrapper	New Richmond, WI 54017		BOSCH		27
Index	Description	Date	ECN#	Chg By						431.063136	

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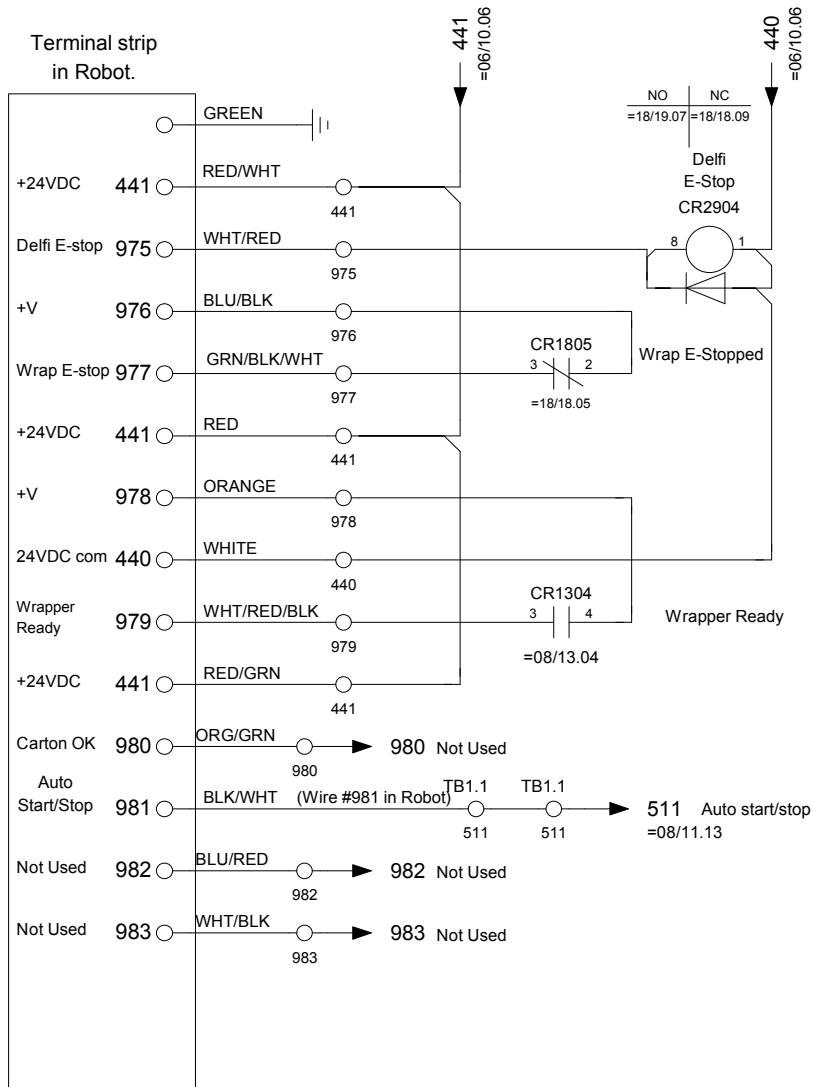


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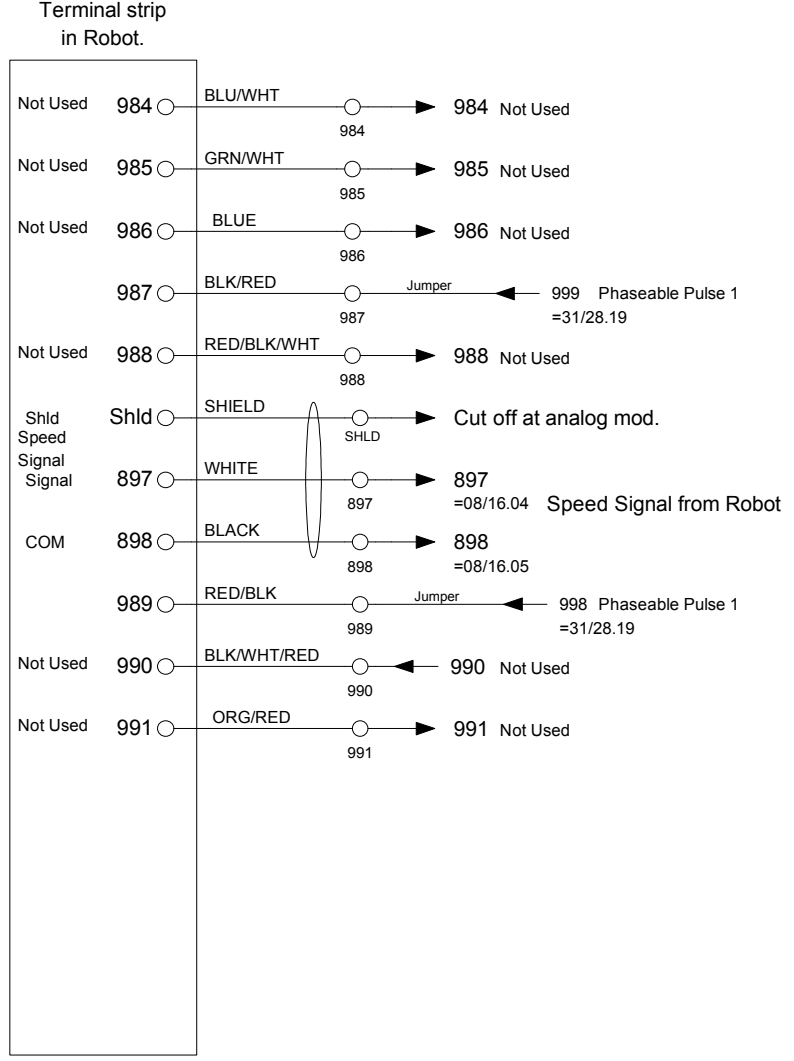


				Date	03/12/2008	Customer or Machine	Doboy Inc.	Options:	=307. 31	Function	31
				Name	Dennis Neck	611 Series	869 South Knowles Ave.	Coder, fan		Type of Sheet	ED
				Checked	Rod Cain	Horizontal Wrapper	New Richmond, WI 54017		BOSCH		28
Index	Description	Date	ECN#	Chg By						431.063136	

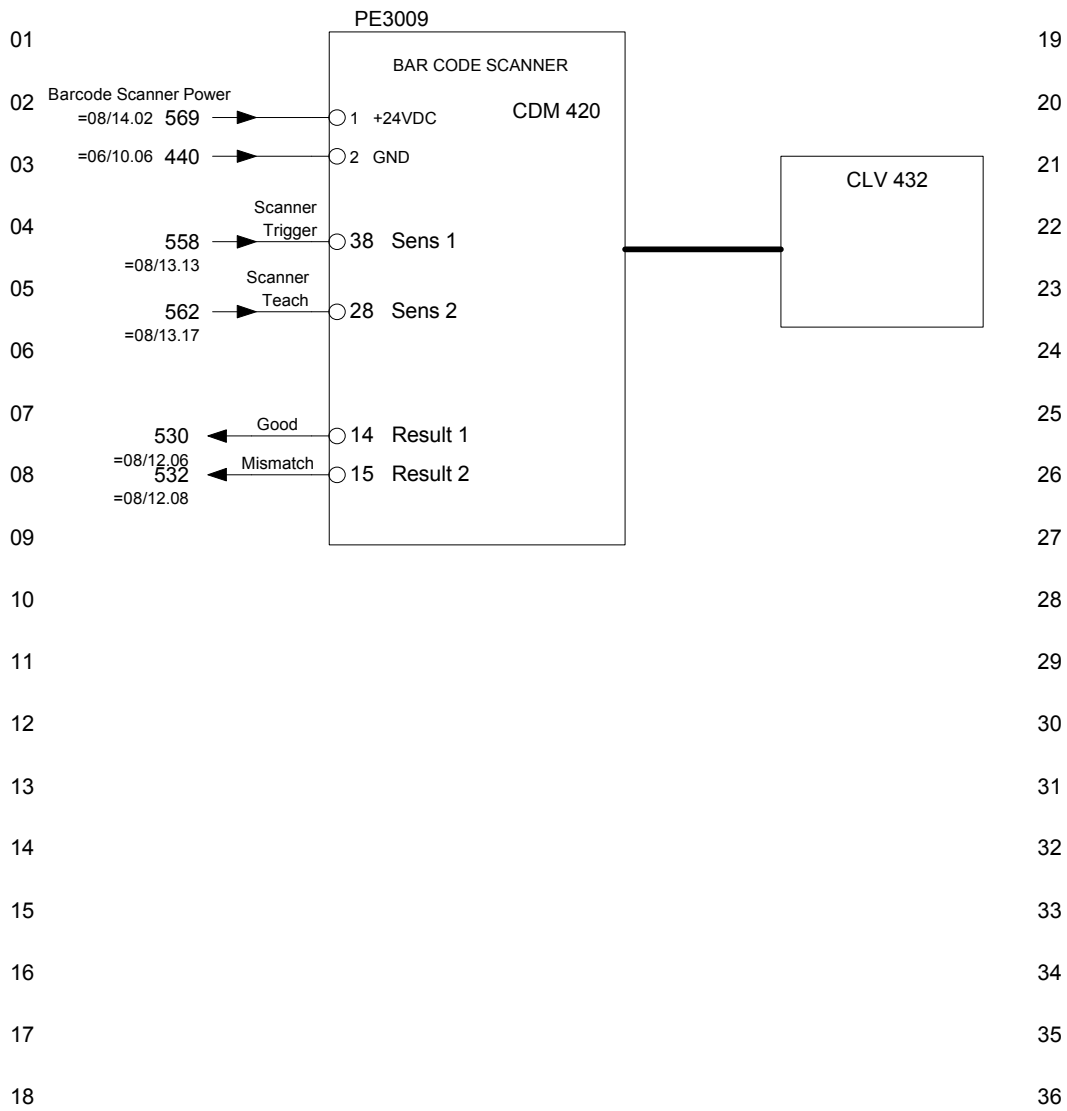
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		Date	03/12/2008	Customer or Machine		Doboy Inc. 869 South Knowles Ave. New Richmond, WI 54017	Options: Delfi Tie-in	=307. 31	Function	31
		Name	Dennis Neck	611 Series					Type of Sheet	ED
		Checked	Rod Cain	Horizontal Wrapper						29
Index	Description	Date	ECN#	Chg By				BOSCH	431.063136	30



				Date	03/12/2008	Customer or Machine	Doboy Inc. 869 South Knowles Ave. New Richmond, WI 54017	Options: Bar Code Scanner	=307. 31		Function	31
			Name	Dennis Neck	611 Series Horizontal Wrapper	Type of Sheet					ED	
			Checked	Rod Cain					BOSCH 431.063136		30	
Index	Description	Date	ECN#	Chg By						30		