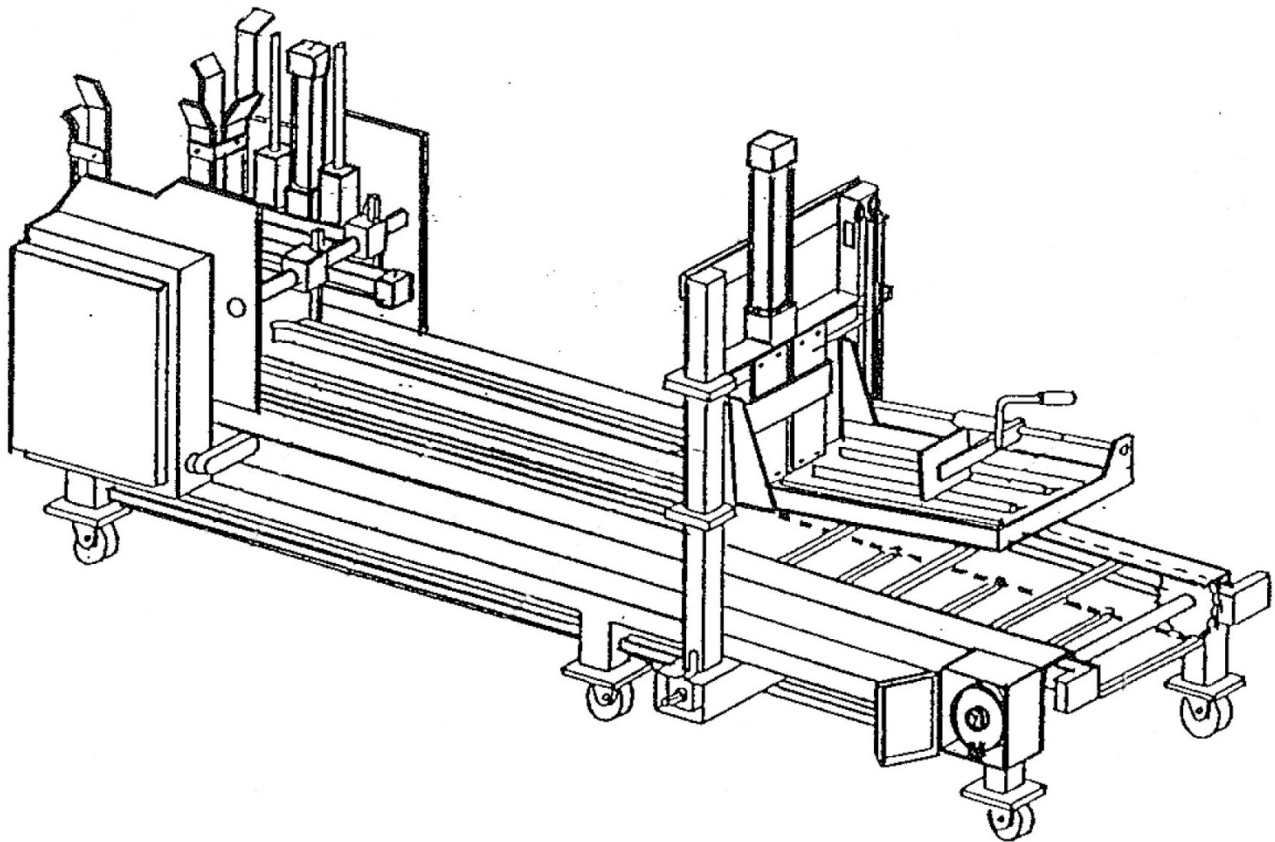


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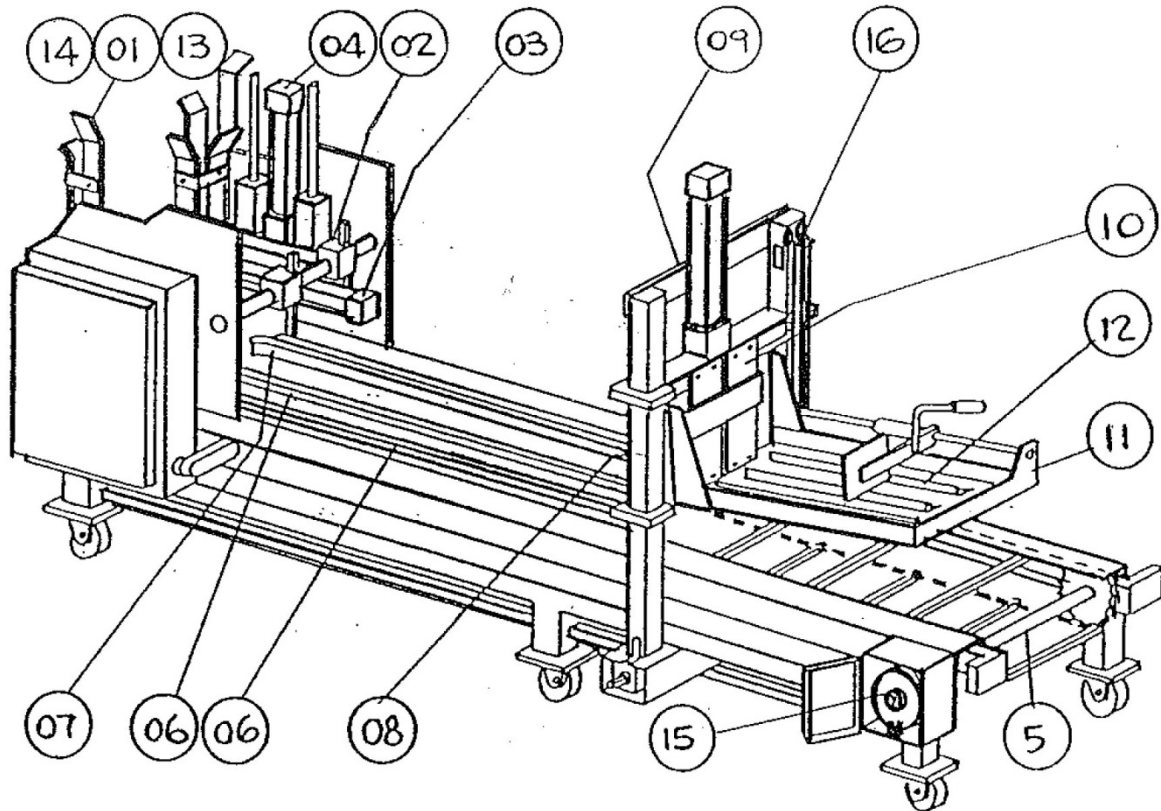


U6/2 PARTITION ASSEMBLER





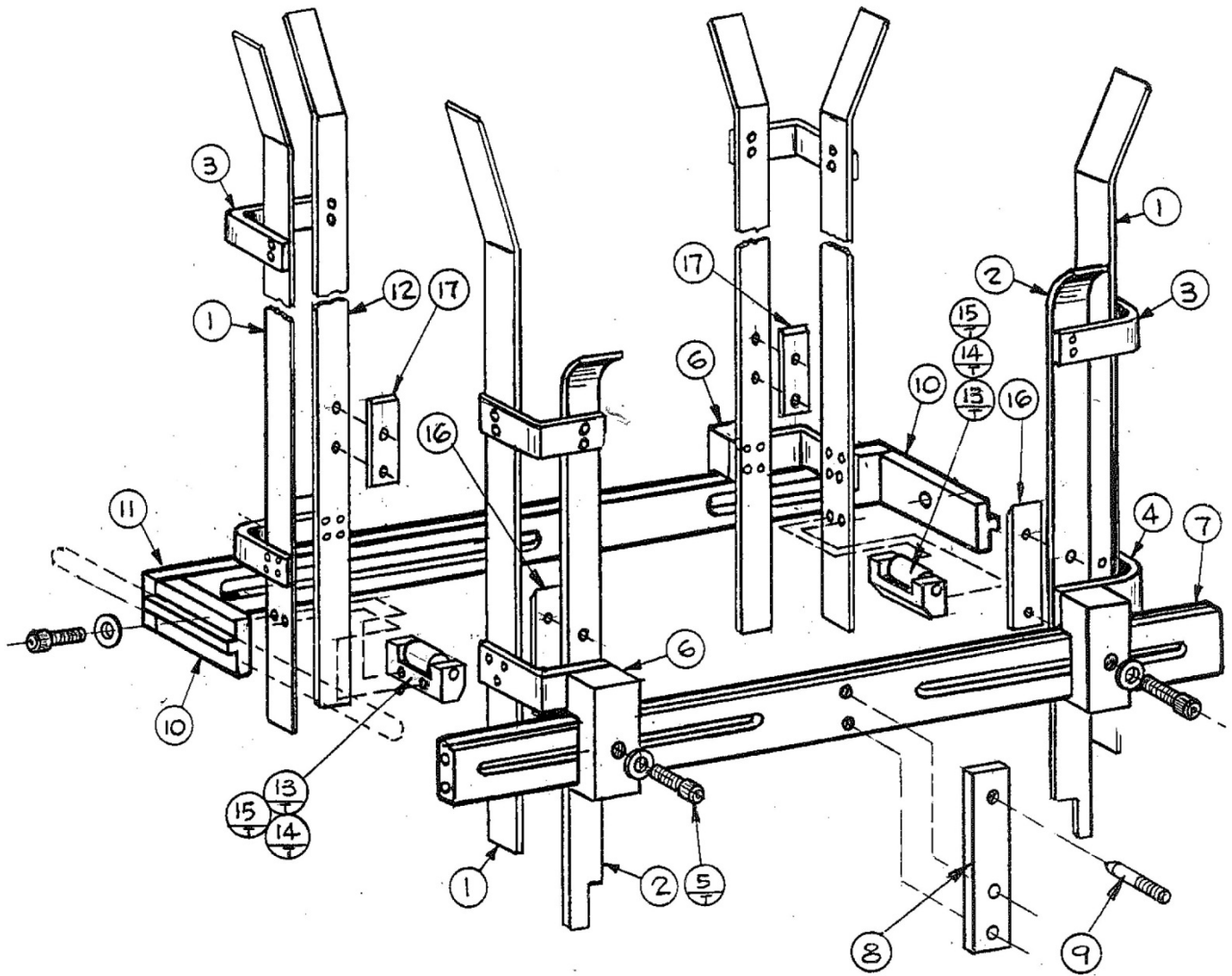
MACHINE SECTION/PARTS INDEX



U6-2HS01	Magazine Assembly	U6-2HS09	Station #4 Assembly (Rear)
U6-2HS02	Forming Rails Assembly	U6-2HS10	Station #4 Assembly (Front)
U6-2HS03	Feed Assembly	U6-2HS11	Station #4 Magazine/Table Assembly
U6-2HS04	Forming Assembly	U6-2HS12	Magazine Table Hardware Assembly
U6-2HS05	Flight Bar Conveyor (Standard/High Speed) Assem.	U6-2HS13	Vacuum Pump Assembly
U6-2HS06	Lower Guide Rail Assembly	U6-2HS14	Vacuum Pick Arm Assembly
U6-2HS07	Upper Guide Rail Assembly	U6-2HS15	Program Wheel Assembly
U6-2HS08	Spring Finger Components Assembly	U6-2HS16	Counterweight Assembly

MAGAZINE ASSEMBLY

U6-2HS01



WAYNE
AUTOMATION CORPORATION

U-6

PARTITION ASSEMBLER

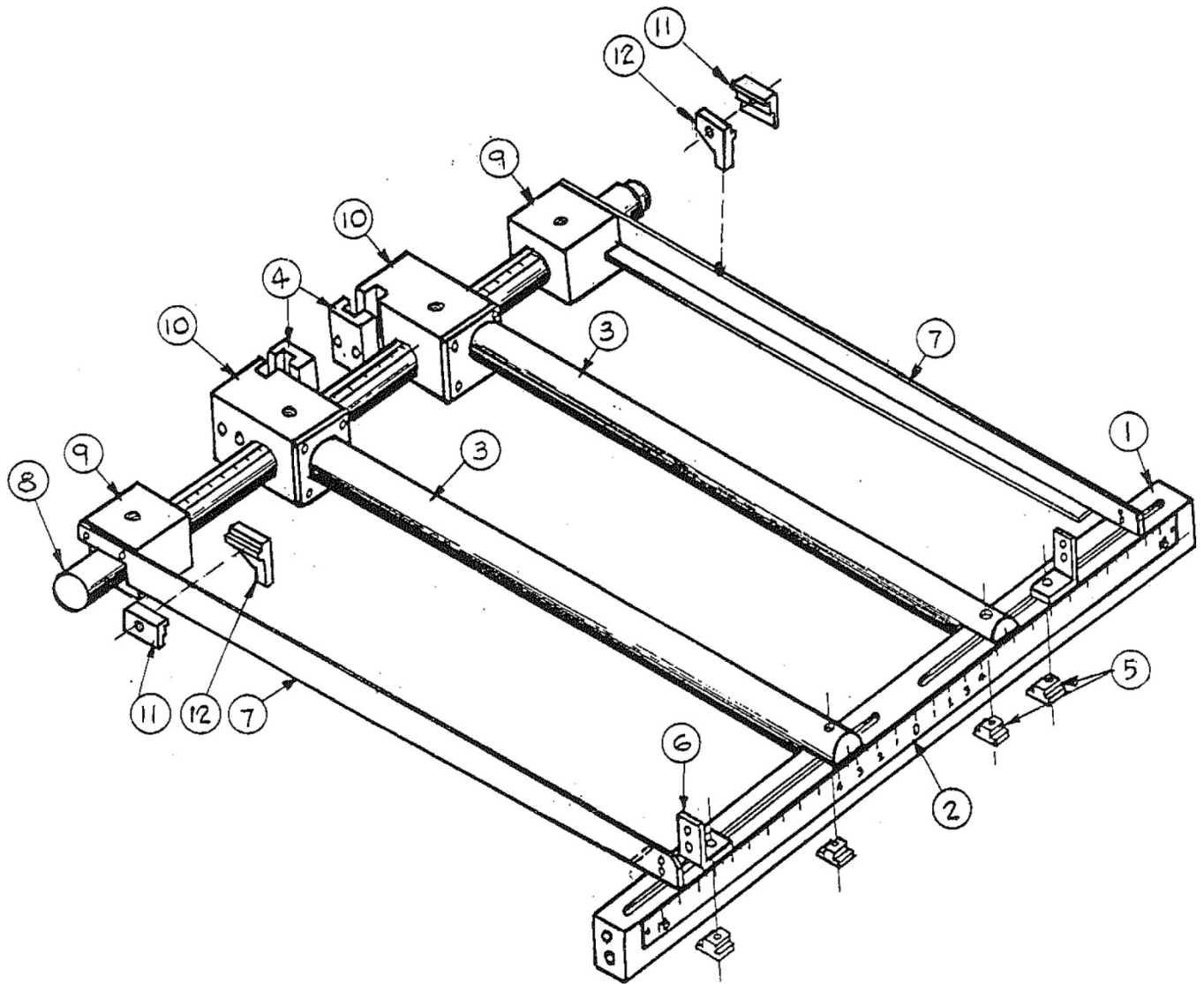
U6-2HS01

Magazine Assembly

ITEM #	DESCRIPTION	DRAWING	M2M #	QTY
U6-2HS0100	Magazine Assembly			
U6-2HS0101	Magazine Side Guide	D1167-209A		4
U6-2HS0102	Rear Magazine Guide	D1167-209A		2
U6-2HS0103	Upper Clip	D1167-208		4
U6-2HS0104	Lower Clip	D1167-208		4
U6-2HS0105	Socket Head Cap Screw/Washer			8
U6-2HS0106	Front Slide	D1167-208		4
U6-2HS0107	Rear Side Bracket	D1167-208		1
U6-2HS0108	Hold Up Screw Mounting Bracket	D1167-218		2
U6-2HS0109	Hold Up Screw	D1167-218		2
U6-2HS0110	"T" Slide	D1167-208		2
U6-2HS0111	Front Slide Bracket	D1167-208		1
U6-2HS0112	Front Magazine Guide	D1167-209A		2
U6-2HS0113	Roller Support	D1167-218		4
U6-2HS0114	Roller	D1167-218	37081	4
U6-2HS0115	Shaft	D1167-218	37082	4
U6-2HS0116	Step Plate x 6-1/2"	D1167-218		2
U6-2HS0117	Step Plate x 3-1/2"	D1167-218		2

FORMING RAILS ASSEMBLY

U6-2HS02



U-6

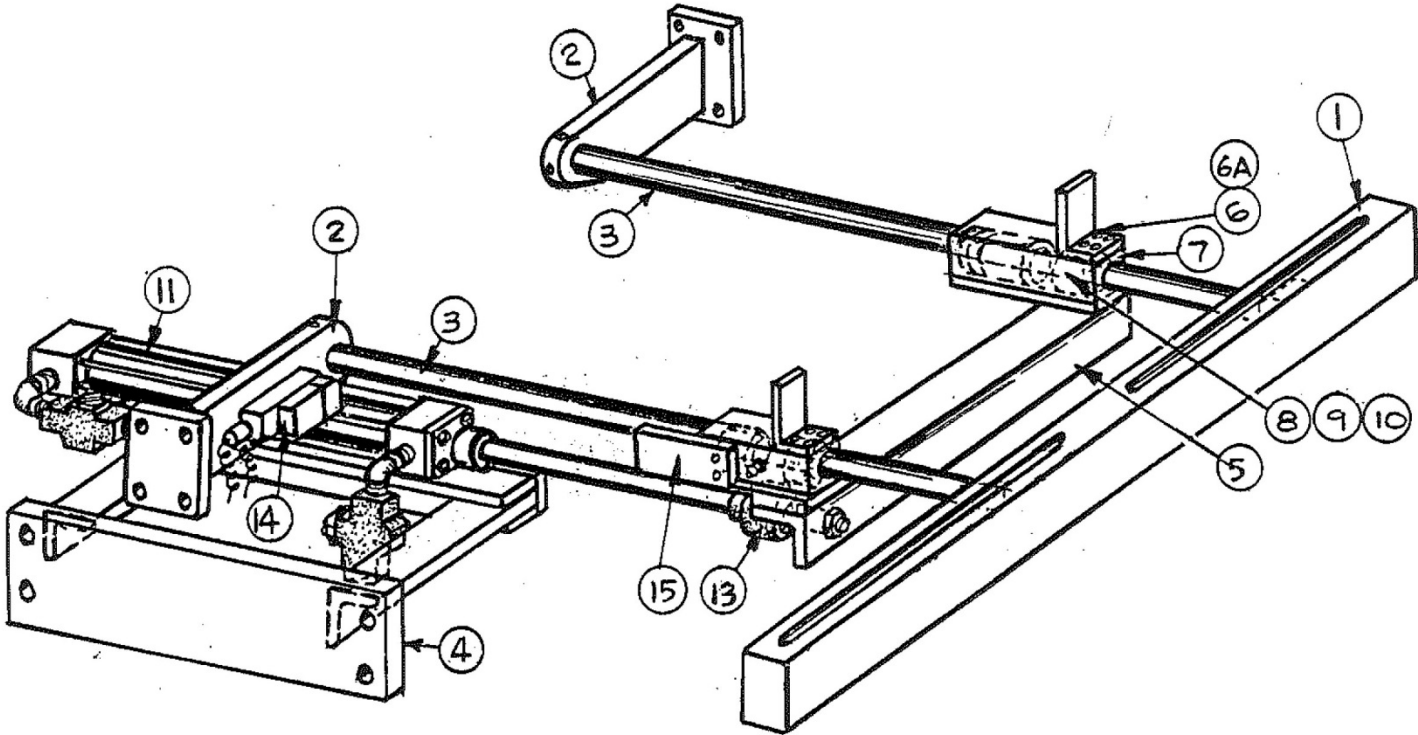
PARTITION ASSEMBLER

U6-2HS02

Forming Rails

ITEM #	DESCRIPTION	DRAWING	M2M #	QTY
U6-2HS0200	Forming Rails			
U6-2HS0201	Rear Cross Member	D1167-208		1
U6-2HS0202	Scale 18"-0-18"			1
U6-2HS0202A	Roll Bar for Chip Board			ref
U6-2HS0203	Roll Bar	D1167-210A		2
U6-2HS0204	Guide Clamp	D1167-210A		2
U6-2HS0205	Reid "T" Nut	TB18	21303	4
U6-2HS0206	Side Rail Mount	D1167-219		2
U6-2HS0207	Side Rail	D1167-219		2
U6-2HS0208	Bearing Slide	D1167-208		1
U6-2HS0209	Angle Slide Bearing	D1167-210A		2
U6-2HS0210	Forming Bar Bearing Block	D1167-210A		2
U6-2HS0211	Paper Stop Clamp		15783	2
U6-2HS0212	Paper Stop		15782	2

FEED ASSEMBLY
U6-2HS03



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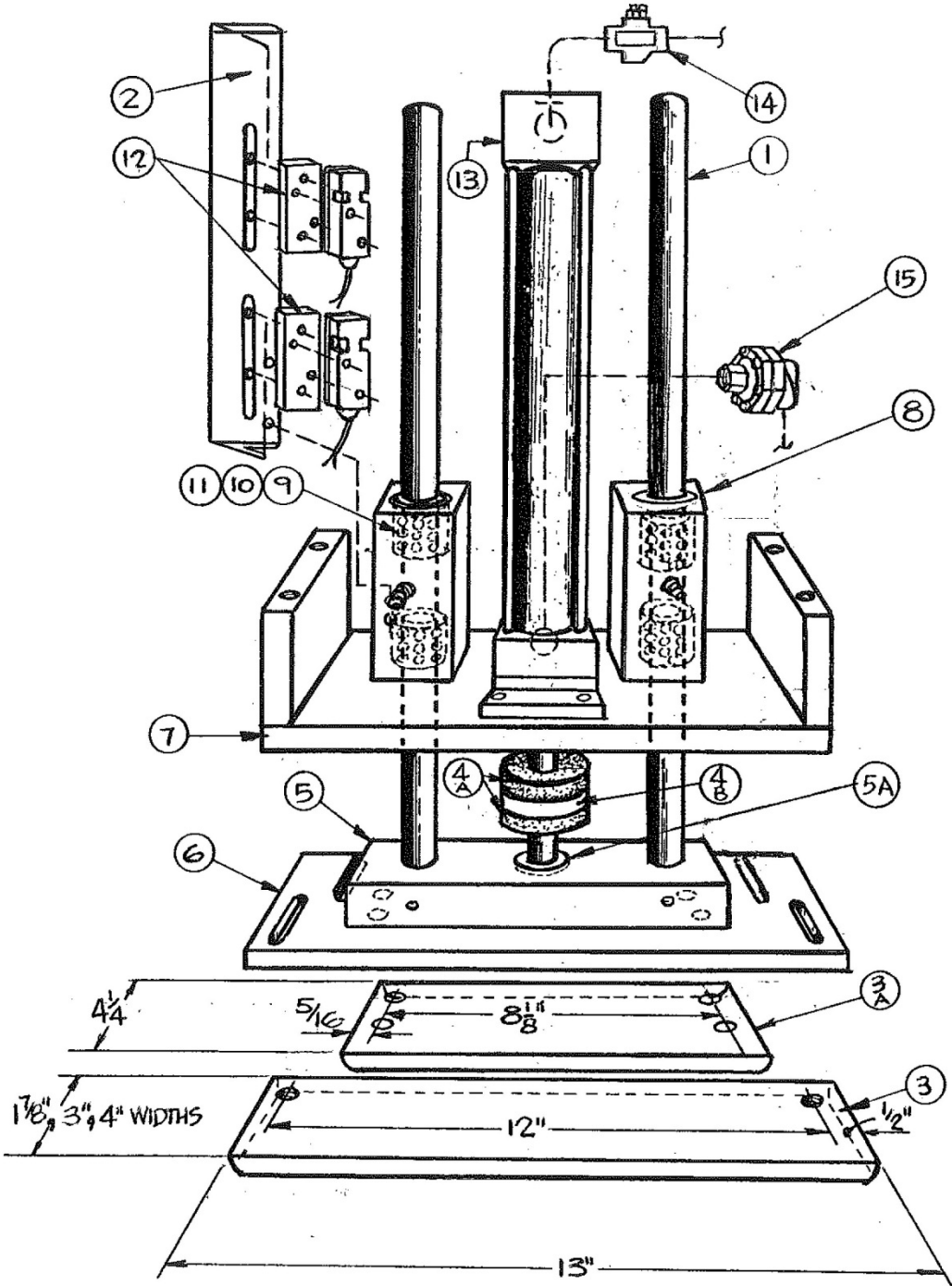
PARTITION ASSEMBLER

U6-2HS03

Feed Assembly

ITEM #	DESCRIPTION	DRAWING	M2M #	QTY
U6-2HS0300	Feed Assembly			
U6-2HS0301	Rear Cross Member	D1167-208		1
U6-2HS0302	Shaft Mounting Bracket	D1167-208A		2
U6-2HS0303	Thomson Shaft 1" x 27-3/8"	D1167-208		2
U6-2HS0304	Feed Cylinder Mount Weldment	D1167-208A		1
U6-2HS0305	Bearing Carriage	D1167-208A		1
U6-2HS0306	Standard Pusher	D1167-219		2
U6-2HS0306A	Alternate Pusher	D1167-219		2
U6-2HS0307	Transporter Bearing Housing (w/ Items #8-#10)	D1167-210A	52940	2
U6-2HS0308	Thomson Ball Bushing	A162536		4
U6-2HS0309	Thomson Seal	S1000		4
U6-2HS0310	Tru Arc Retainer Ring	N5000-156		4
U6-2HS0311	Hennells Cylinder 2" x 18"	HW47		1
U6-2HS0312	Numatic Flow Control	3FC2		2
U6-2HS0313	Piab Rod Coupler (was LC-1-12)	AG750		1
U6-2HS0314	Efector Proximity Switch	IME-2015-BFBOA		1
U6-2HS0315	Proximity Switch Flag Plate		17411	1

FORMING ASSEMBLY
U6-2HS04



U-6

PARTITION ASSEMBLER

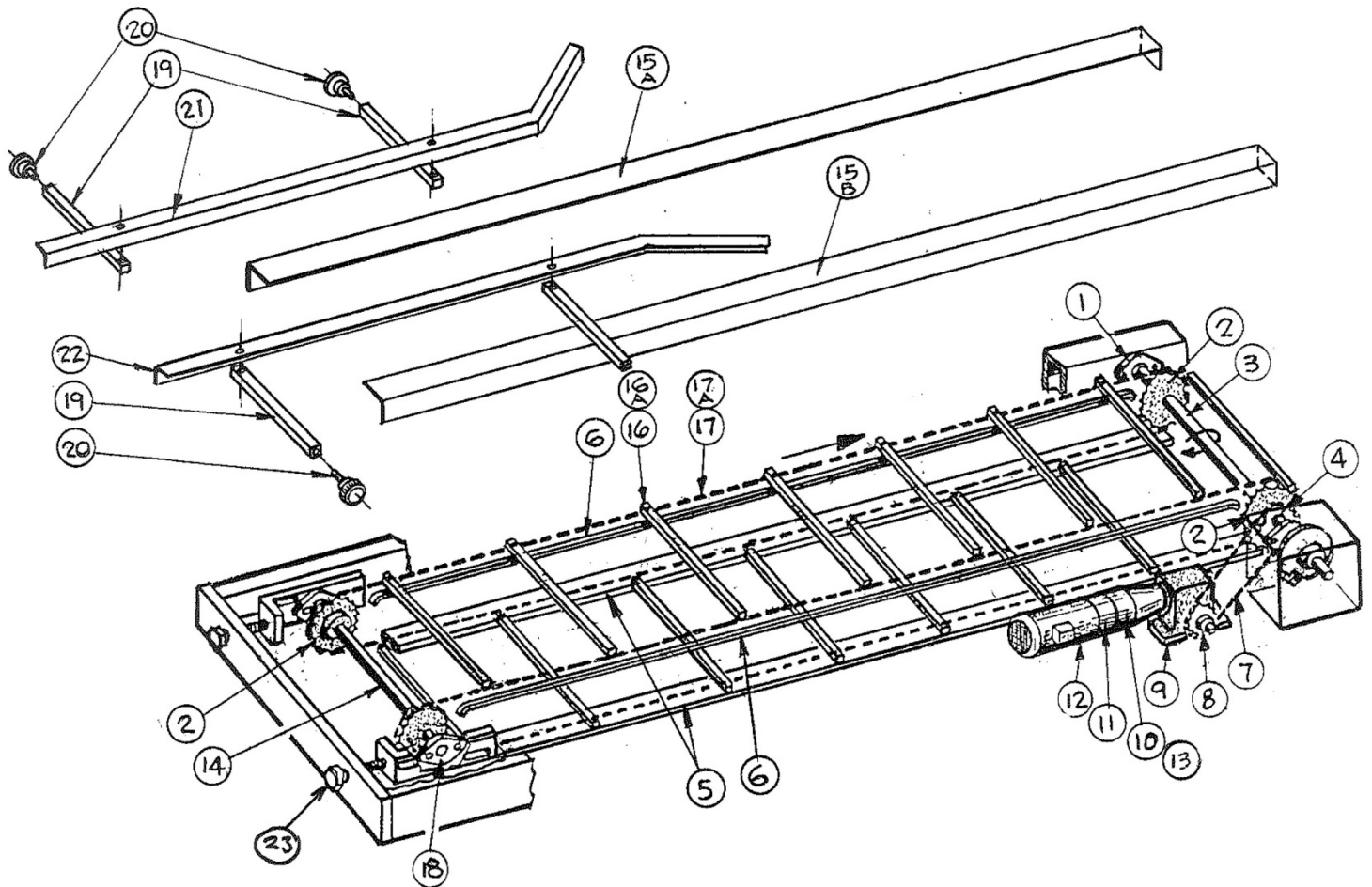
U6-2HS04

Forming Assembly

ITEM #	DESCRIPTION	DRAWING	M2M #	QTY
U6-2HS0400	Forming Assembly			
U6-2HS0401	Thomson Shaft 1" x 35"	D1167-208		2
U6-2HS0402	Proximity Switch Mounting Angle	D1167-501		1
U6-2HS0403	"U" Forming Plate 1/2" x 2" x 13 (std)	D1167-209A		3pcs
U6-2HS0403b	"U" Forming Plate 1/2" x 3" x 13 (std)	D1167-209A		ref
U6-2HS0403c	"U" Forming Plate 1/2" x 4" x 13 (std)	D1167-209A		ref
U6-2HS0403A	"U" Forming Plate 1/2" x 4-1/4" x 8-3/4" (high speed)	D1167-221		1
U6-2HS0404A	URC 1/2" x 1" x 2-3/8" (70 duro)		05006D	2
U6-2HS0404B	URC 1/2" x 1" x 2-3/8" (40 duro)		05481D	1
U6-2HS0405	Rod End Forming Block/Tie Bar	D1167-209A		1
U6-2HS0405A	Boston Thrust Washer	#18860		1
U6-2HS0406	Bottom Plate (std speed only)	D1167-209A		1
U6-2HS0407	Cylinder Mounting Block	D1167-209A		1
U6-2HS0407A	Spacer Plate	D1167-209A		2
U6-2HS0408	Bearing Housing Assembly	D1167-209A		2
U6-2HS0409	Thomson Ball Bushing	A162536		4
U6-2HS0410	Thomson Seal	S1000		4
U6-2HS0411	Tru Arc Retainer Ring	N5000-156		4
U6-2HS0412	Proximity Switch Mount/Spacer	D1167-501		2
U6-2HS0413	Hennells Cylinder 2" x 20"	HW4		1
U6-2HS0414	Numatic Flow Control	3FC2		1
U6-2HS0415	Parker Valve	OR75B		1

FLIGHT BAR CONVEYOR (STANDARD/HIGH-SPEED) ASSEMBLY

U6-2HS05



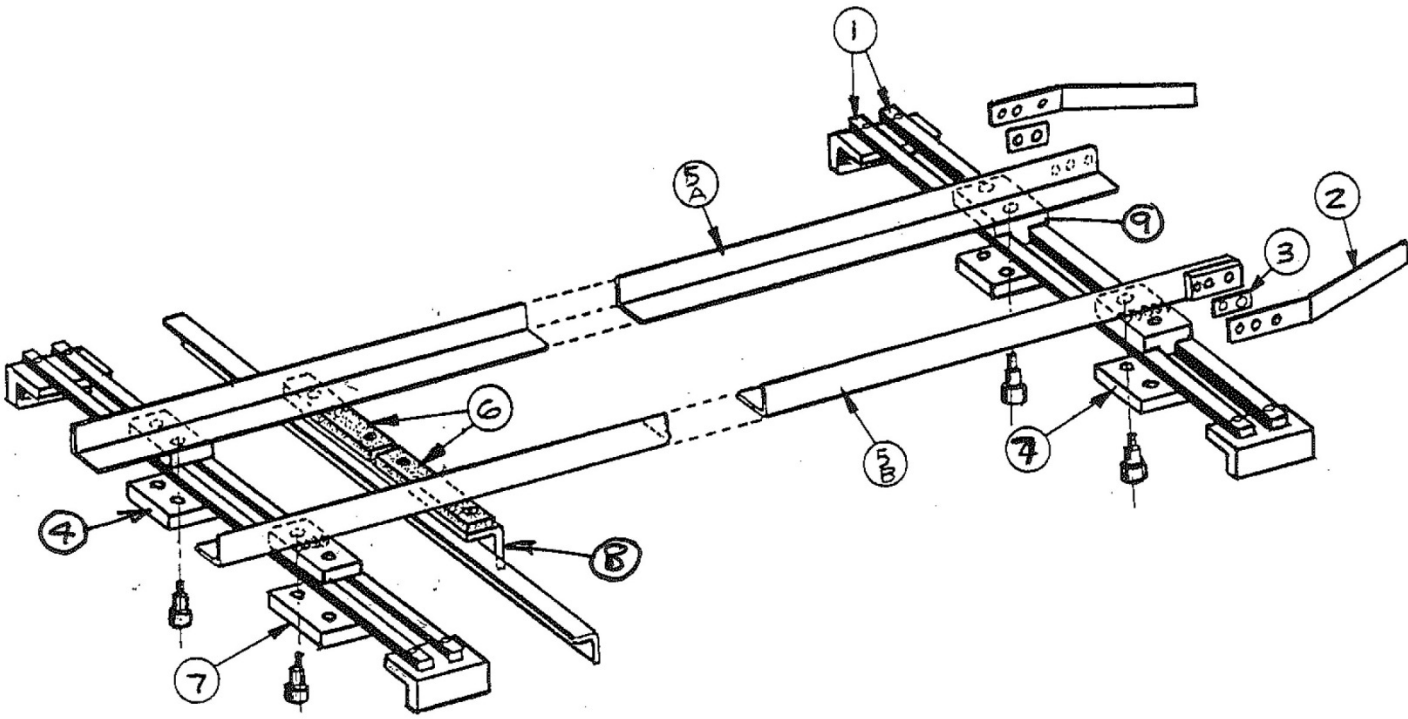
U-6

PARTITION ASSEMBLER
Flight Bar Conveyor (Standard/High-speed)

U6-2HS05

ITEM #	DESCRIPTION	DRAWING	M2M #	QTY
U6-2HS0500	Flight Bar Conveyor (Standard/High-speed)			
U6-2HS0501	McGill Bearing	MFB 1-3/16"		2
U6-2HS0502	Headshaft Sprocket (60B32	17244	1pr
U6-2HS0502A	Tailshaft Sprocket		17245	1
U6-2HS0502B	Tailshaft Sprocket		17246	1
U6-2HS0503	Headshaft	D1052-633		1
U6-2HS0504	Headshaft Driven Sprocket	50B32	17228	1
U6-2HS0505	Pobco Conveyor Chain Return Supports x 129-1/2" long	GRA-1036-C5	21373	2
U6-2HS0506	Flight Bar/Conveyor Support	D1167-102		2
U6-2HS0507	Chain x 60"	RC50	31223	1
U6-2HS0508	Browning Drive Sprocket	50P22	19473	1
U6-2HS0508a	Browning Taper Bushing	P1 x 1-1/4"	19461	1
U6-2HS0509	Winsmith Gearbox 30:1	926CDT	20579	1
U6-2HS0510	Horton Clutch	MDU-625	20406	1
U6-2HS0511	Horton Brake	MBU-875	20407	1
U6-2HS0512	Leeson Motor 2hp/1750rpm/56C	#110451	20404	1
U6-2HS0513A	Browning Coupling Jaw	CHJS5H	47648	2
U6-2HS0513B	Browning Coupling Insert	JS5U	47649	1
U6-2HS0513C	Browning Taper Bushing	H x 7/8"	20399	1
U6-2HS0513D	Browning Taper Bushing	H x 1"	19228	1
U6-2HS0514	Tailshaft	D1052-633		1
U6-2HS0515A	Flight Conveyor Guard (std hand)		15757A	1
U6-2HS0515B	Flight Conveyor Guard (opp hand)		15757B	1
U6-2HS0516	Flight Bar (std speed conv.)			11
U6-2HS0516A	Flight Bar (high speed conv.)			22
U6-2HS0517	RC60 Chain x 264" (std speed) (w/ W/22 attachments on 24" cer		15688	2
U6-2HS0517A	RC60 Chain x 264" (std speed) (w/ W/22 attachments on 12" cer		15689	2
U6-2HS0518	McGill Bearing	FC2-25-1-7/16	21299	2
U6-2HS0519	Adjustment Bar	D1167-401		4
U6-2HS0520	Reid Knob	DK-11		4
U6-2HS0521	Guide Rail	D1167-401		1
U6-2HS0522	Guide Rail	D1167-401		1
U6-2HS0523	Take-up Screw x 11"			2

LOWER GUIDE RAIL ASSEMBLY
U6-2HS06



U-6

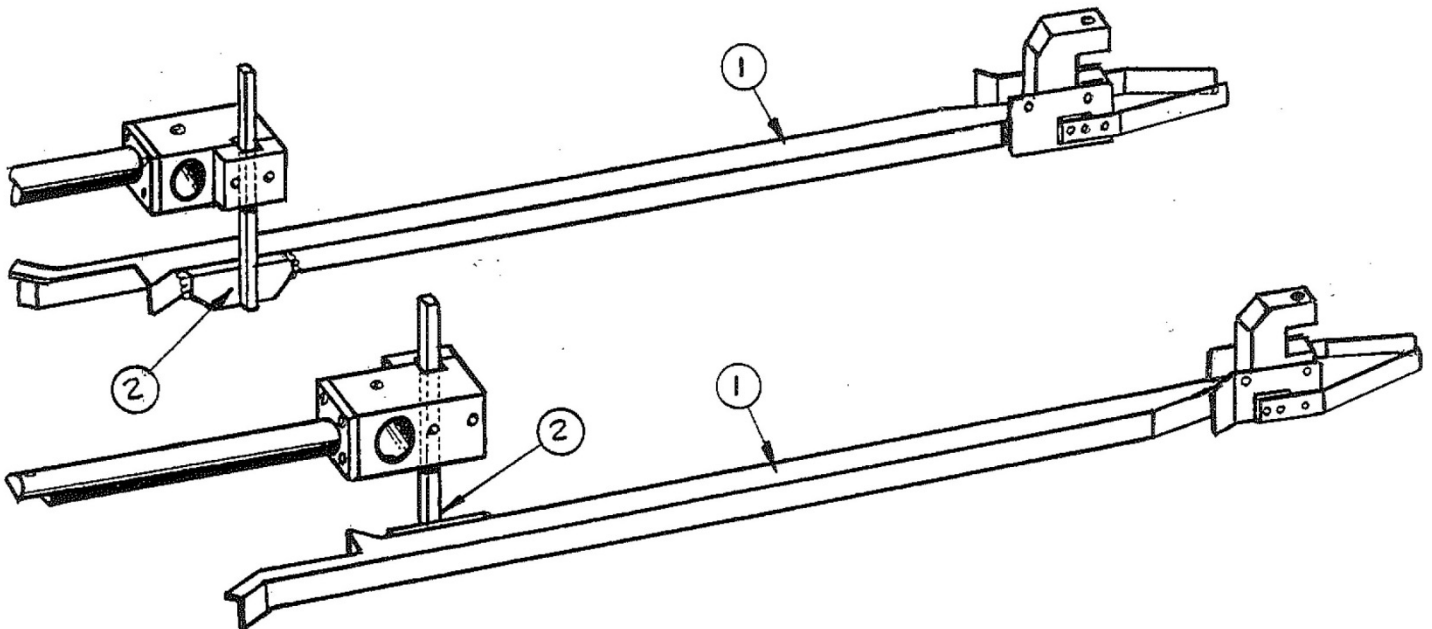
PARTITION ASSEMBLER
Lower Guide Rail Assembly

U6-2HS06

ITEM #	DESCRIPTION	DRAWING	M2M #	QTY
U6-2HS0600	Lower Guide Rail Assembly			
U6-2HS0601	Support Bar	D1167-319A		4
U6-2HS0602	Spring Finger	D1004-601		2
U6-2HS0603	Spacer	D1004-601		2
U6-2HS0604	Free Floating Nut Bar	D1167-319A		2
U6-2HS0605	Lower Runner (shown)	D1167-319		1
U6-2HS0605A	Lower Runner (opp hand)	D1167-319		1
U6-2HS0606	Shock/Rubber Pad	D1167-102A		2
U6-2HS0607	Free Floating Nut Bar	D1167-319A		4
U6-2HS0608	Track Support	D1167-102A		1
U6-2HS0609	T-Nut	D1167-319A		2

UPPER GUIDE RAIL ASSEMBLY

U6-2HS07



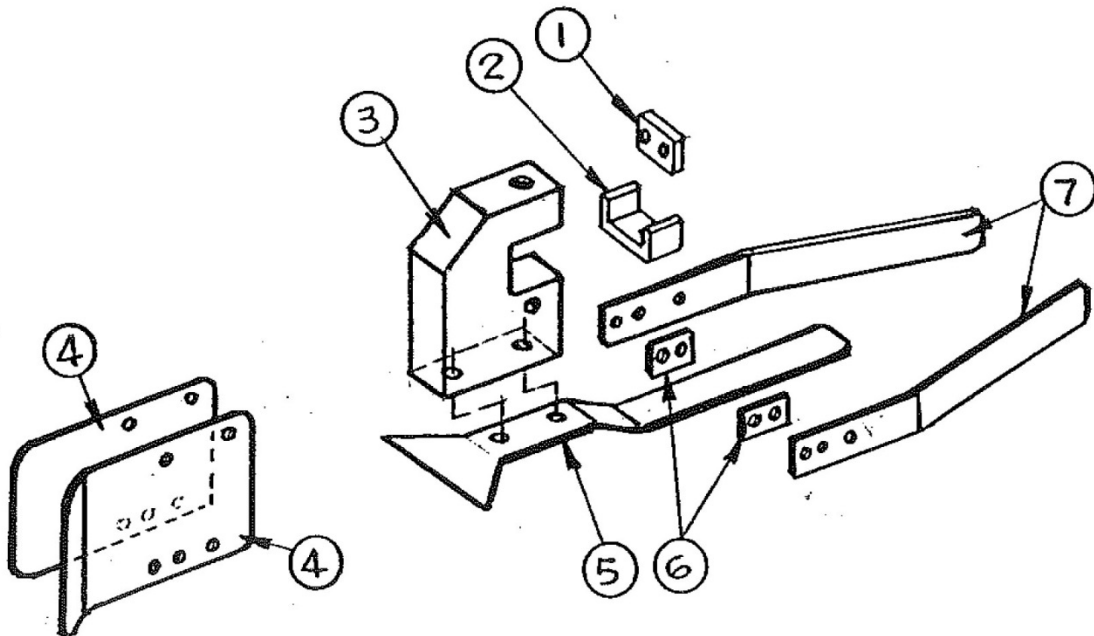
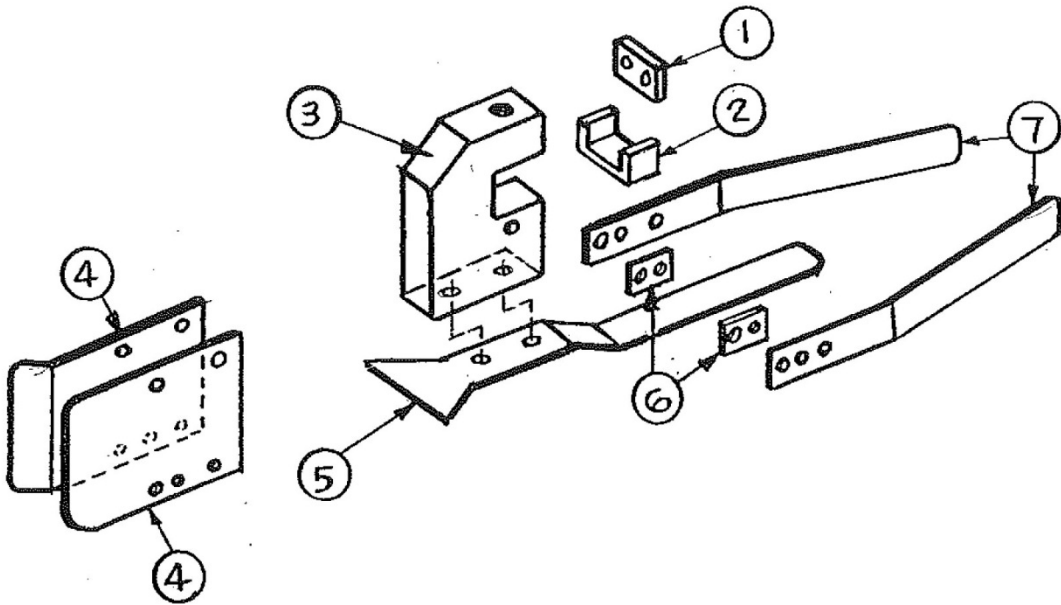
U-6

PARTITION ASSEMBLER
Upper Guide Rail Assembly

U6-2HS07

ITEM #	DESCRIPTION	DRAWING	M2M #	QTY
U6-2HS0700	Upper Guide Rail Assembly			
	Standard Speed 17-3/8" long			
	High Speed 20 5/8" long			
U6-2HS0701	Upper Guide Track (w/ Item #2) (shown)	D1167-319A		1pr
U6-2HS0701B	Upper Guide Track (w/ Item #2) (opp)	D1167-319A		ref
U6-2HS0701C	Upper Guide Track (w/ Item #2) (U8 mach.)			ref
U6-2HS0701D	Upper Guide Track (w/ Item #2) (U8 mach.)			ref
U6-2HS0702	Upper Guide Support	D1167-210A		2

SPRING FINGER COMPONENTS ASSEMBLY
U6-2HS08

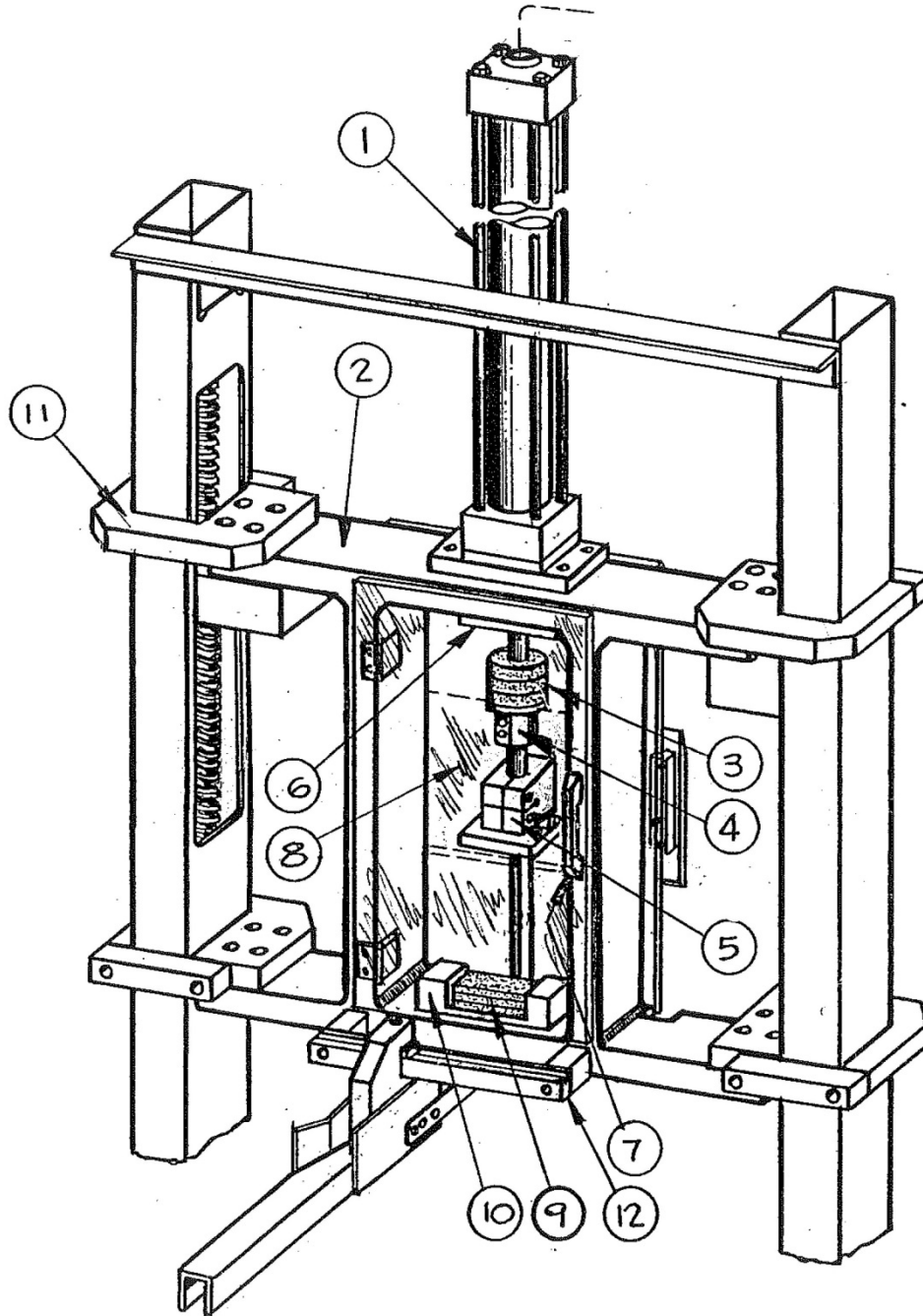


PARTITION ASSEMBLER
Spring Finger Components

ITEM #	DESCRIPTION	DRAWING	M2M #	QTY
U6-2HS0800	Spring Finger Components			
U6-2HS0801	Guide Clamp Retainer	D1167-319A		2
U6-2HS0802	Finger Guide Clamp Slide	D1167-319A		2
U6-2HS0803	Guide Clamp	D1167-319A		2
U6-2HS0804A	Finger Guide Plate (right bend)	D1167-319A		2
U6-2HS0804B	Finger Guide Plate (left bend)	D1167-319A		2
U6-2HS0805	Guide Finger	D1167-319A-101A		2
U6-2HS0806	Spring Finger Spacer	A1004-601		4
U6-2HS0807	Spring Finger	A1004-601		4

STATION #4 ASSEMBLY (REAR VIEW)

U6-2HS09



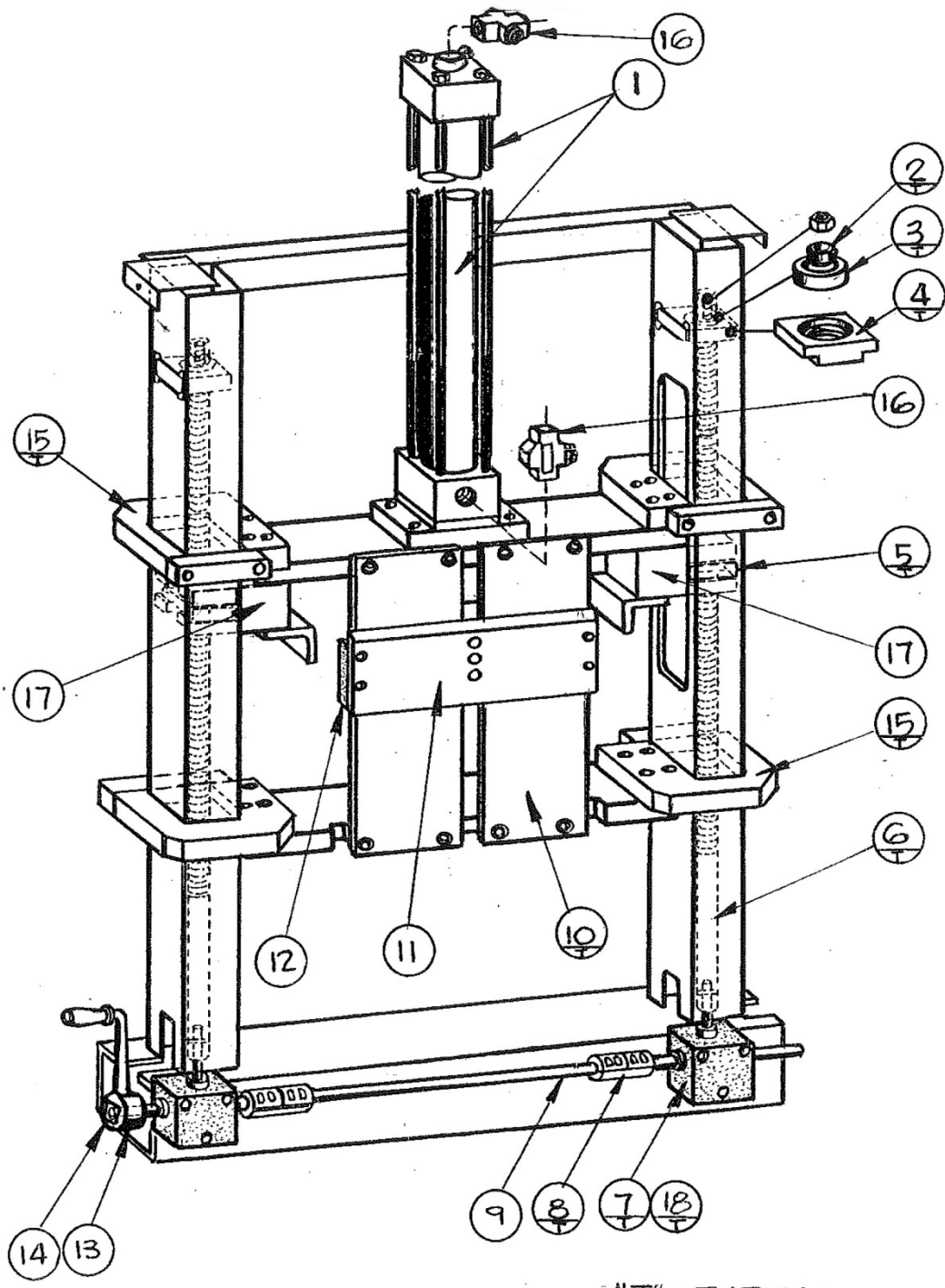
U-6

PARTITION ASSEMBLER
Station #4 Assembly (Rear View)

U6-2HS09

ITEM #	DESCRIPTION	DRAWING	M2M #	QTY
U6-2HS0900	Station #4 Assembly (Rear View)			
U6-2HS0901	Hennells Cylinder 2" x 19"	HW1	15721	1
U6-2HS0902	Grid "H" Weldment	D1167-314	64694	1
U6-2HS0903	URC 3-3/8" x 1" (70 duro)		05006A	3
U6-2HS0904	URC Clamp	D1167-319		1
U6-2HS0905	Gib Block (specify U6 or U8)	D1167-319		1
U6-2HS0906	URC Plate	D1167-319		1
U6-2HS0907	Southco Door Pull			1
U6-2HS0908	Safet Door 16-1/2" x 21-3/4" x 3/8"		17426	1
U6-2HS0909	Urethane Cushion 2" x 7" x 1/2"	D1167-319	31258	3
U6-2HS0910	Urethane Cushion Holder	55322		1
U6-2HS0911	Clamp	D1167-318		4
U6-2HS0912	Finger Guide Bar (Adjustable)		21363	1
U6-2HS0913	Finger Guide Spacer			2

STATION #4 ASSEMBLY (FRONT VIEW)
U6-2HS10



"T" = TYPICAL



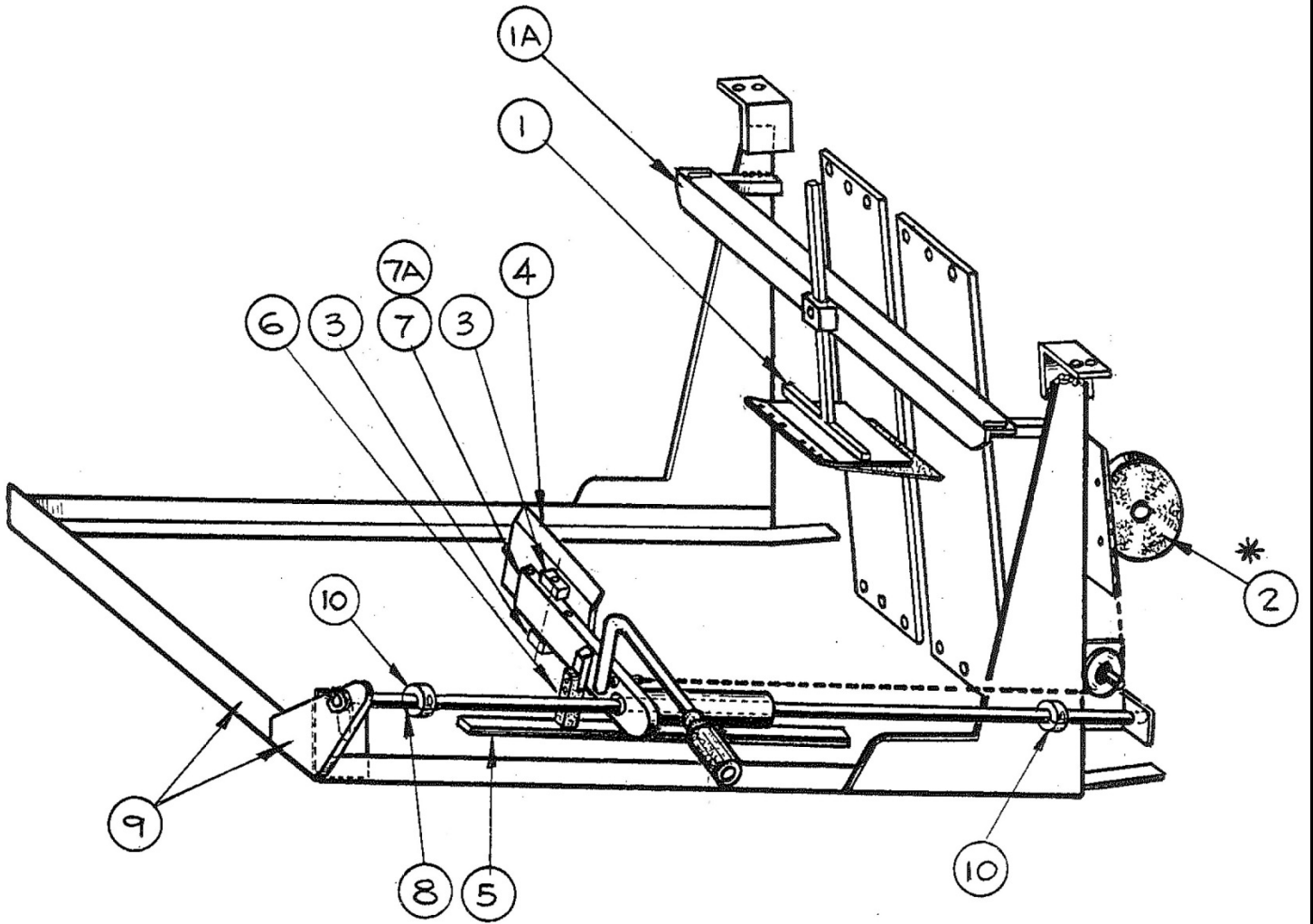
U-6

PARTITION ASSEMBLER
Station #4 Assembly (Front View)

U6-2HS10

ITEM #	DESCRIPTION	DRAWING	M2M #	QTY
U6-2HS1000	Station #4 Assembly (Front View)			
U6-2HS1001	Hennells Cylinder 2" x 19"	HW1	15721	1
U6-2HS1002	Timkin Bearing Cone	#09078		2
U6-2HS1003	Timkin Bearing Cup	#09195		2
U6-2HS1004	Upper Retaining Block	D1167-318		2
U6-2HS1005	Acme Elevating Nut 1-3/8"-5 RH	D1167-318		2
U6-2HS1006	Acme Elevating Screw 1-3/8"-5 RH x 52-1/2"	D1167-312A		2
U6-2HS1007	Hub City Gear Box			2
U6-2HS1008	Ruland Coupling			2
U6-2HS1009	Gear Box Shaft	D1167-318		1
U6-2HS1010	Grid Plate Blank (save old plate for drilling templa	D1167-315A		1pr
U6-2HS1011	Blade (specify size and flute)			1
U6-2HS1012	Side Keeper	A-1004-01	58133	2
U6-2HS1013	Reid Crank Handle x 8"	CH-8		1
U6-2HS1014	Crank Adapter	D1167-312A		1
U6-2HS1015	Clamp	D1167-318		4
U6-2HS1016	Numatic Flow Control			2
U6-2HS1017	Nut Block	D1167-318		2
U6-2HS1018	Gear Box Shim	D1167-318		2
	Grid Weldment (w/ Item #10)			
Blades:	.080 Universal Pin		15933	
	.125 "c"		15935	
	.185 DW (bent out)		15936	

STATION #4 MAGAZINE/TABLE ASSEMBLY
U6-2HS11



* DENOTES ORIGINAL DESIGN



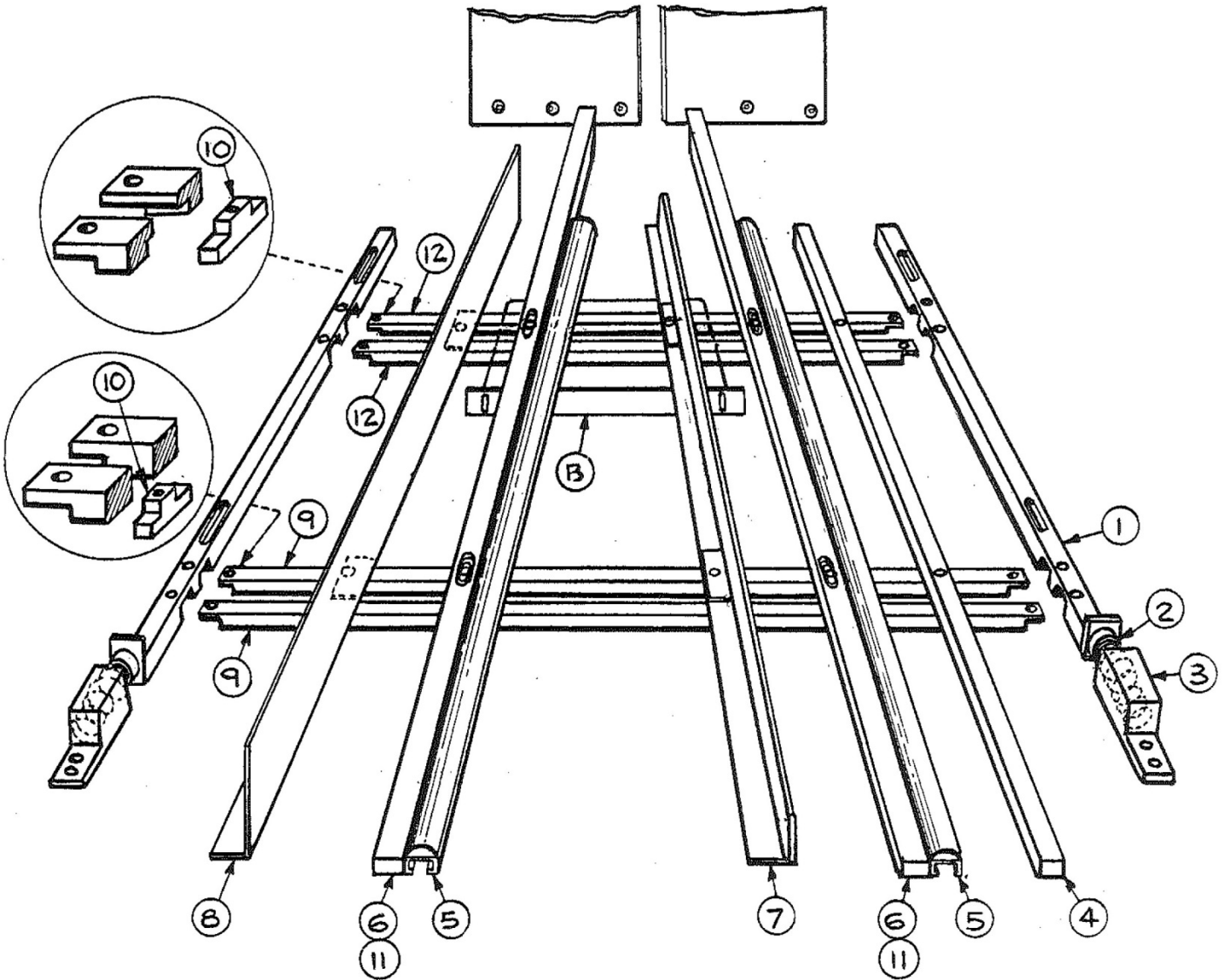
U-6

PARTITION ASSEMBLER
Station #4 Magazine/Table Assembly

U6-2HS11

ITEM #	DESCRIPTION	DRAWING	M2M #	QTY
U6-2HS1100	Station #4 Magazine/Table			
U6-2HS1101	Hold Down Weldment (w/ Pad)	D1167-316A		1
U6-2HS1101A	Hold Down Mount Crossmember			1
U6-2HS1102	Reel (obsolete)	T10-22P-RC		1
U6-2HS1103	Pivot Block	D1167-316A		2
U6-2HS1104	Pressure Plate	D1167-316A		1
U6-2HS1105	Runner	D1167-321		1
U6-2HS1106	Nylatron Bumper	D1167-321		1
U6-2HS1107	Pressure Arm Weldment	D1167-318		1
U6-2HS1107A	Boston Bearing	B1216-8		2
U6-2HS1108	Guide Rod	D1167-318		1
U6-2HS1109	Magazine/Table Weldment	D1167-327		1
U6-2HS1110	Boston Collar	2SC100		2
U6-2HS1111	Spacer	D1167-327		1

MAGAZINE TABLE HARDWARE ASSEMBLY
U6-2HS12



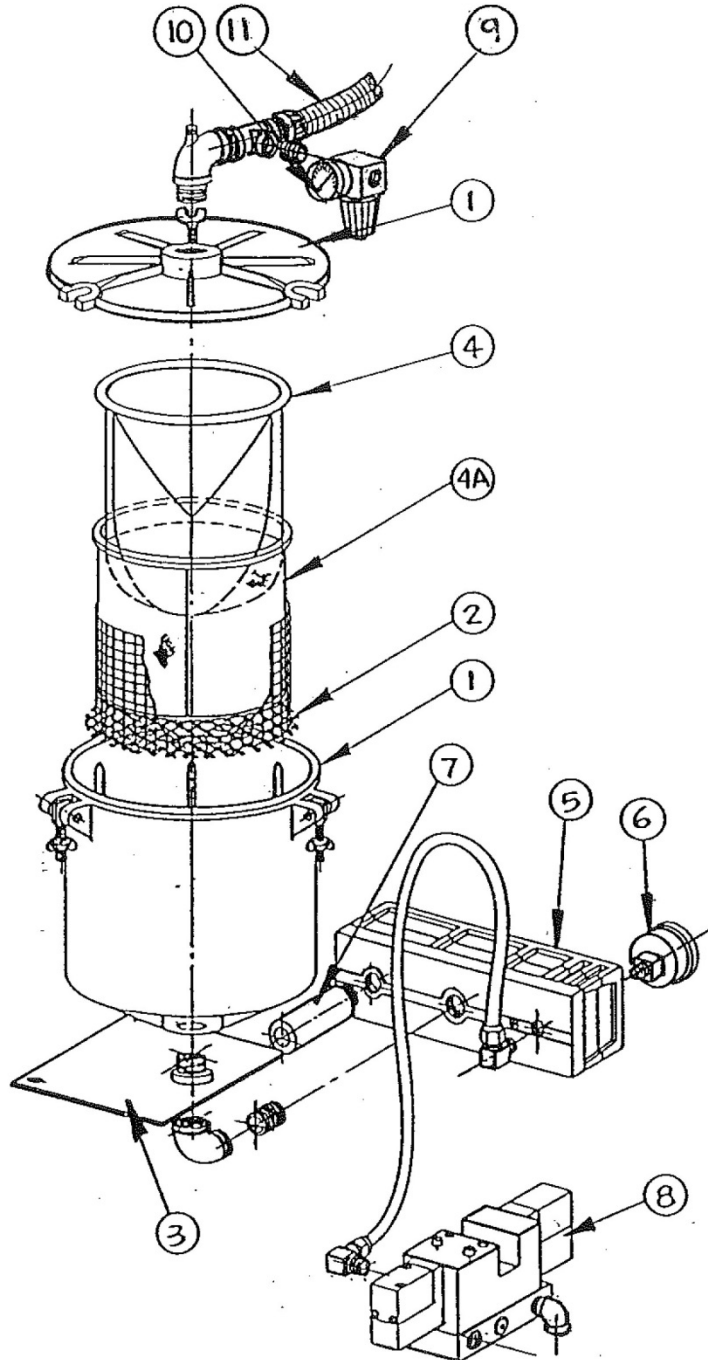
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PARTITION ASSEMBLER
Magazine Table Hardware

U6-2HS12

ITEM #	DESCRIPTION	DRAWING	M2M #	QTY
U6-2HS1200	Magazine Table Hardware			
U6-2HS1201	Side Bar	D1167-328	-3-8	2
U6-2HS1202	Jones Spring	#57	31117	2
U6-2HS1203	Spring Retainer	D1167-328	-3-12	2
U6-2HS1204	Runner	D1167-321	-4-44	1
U6-2HS1205	Pobco Wear Strip/Guide x 52"	GRA-1113C	OBS.	2
U6-2HS1206	Gate Bar	D1167-328	-3-11	2
U6-2HS1207	Partition Guide x 1-1/2" high	D1167-316A	53575A	1
U6-2HS1208	Partition Guide x 4" high	D1167-316A	53575B	1
U6-2HS1209	Rear Cross Bar	D1167-328	58070	2
U6-2HS1210	"T" Nut	D1167-328	-3-13	8
U6-2HS1211	Clamping Bar	D1167-318	-3-18	4
U6-2HS1212	Forward Cross Bar	D1167-328	58069	2
U6-2HS1213	Upper Guide Shoe		71173	1

VACUUM PUMP ASSEMBLY
U6-2HS13



U-6

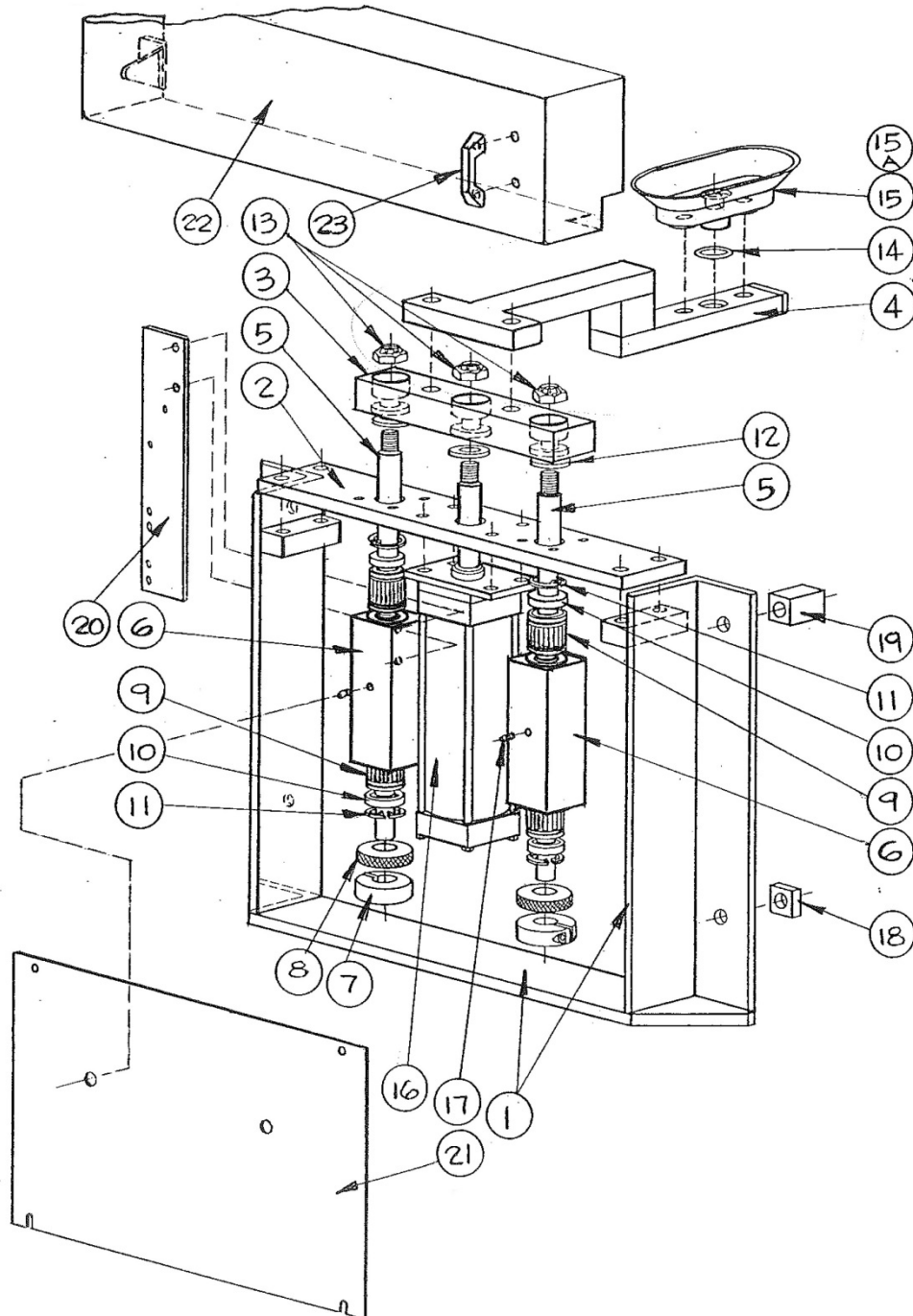
PARTITION ASSEMBLER
Vacuum Pump Assembly

U6-2HS13

ITEM #	DESCRIPTION	DRAWING	M2M #	QTY
U6-2HS1300	Vacuum Pump Assembly			
U6-2HS1301	Gast Filter Cannister			1
U6-2HS1302	Mesh Bottom Guard			1
U6-2HS1303	Vacuum Cannister Mount Plate			1
U6-2HS1304	Gast Paper Vacuum Bag	AV469		1
U6-2HS1305	Gast Cloth Vacuum Bag	AV463		1
U6-2HS1306	Piab Vacuum Pump	MLD100	24202	1
U6-2HS1307	Piab Vacuum Gage 0-100 Hg x 1/8"			1
U6-2HS1308	Mac Valve	111B-11CA		1
U6-2HS1309	Piab Muffler	PT #32.16.002		1
U6-2HS1310	Wika Vacuum Gage 0-30in. Hg x 2"	#111.10		1
U6-2HS1311	Vacuum Lines			ref

VACUUM PICK ARM ASSEMBLY

U6-2HS14



U-6

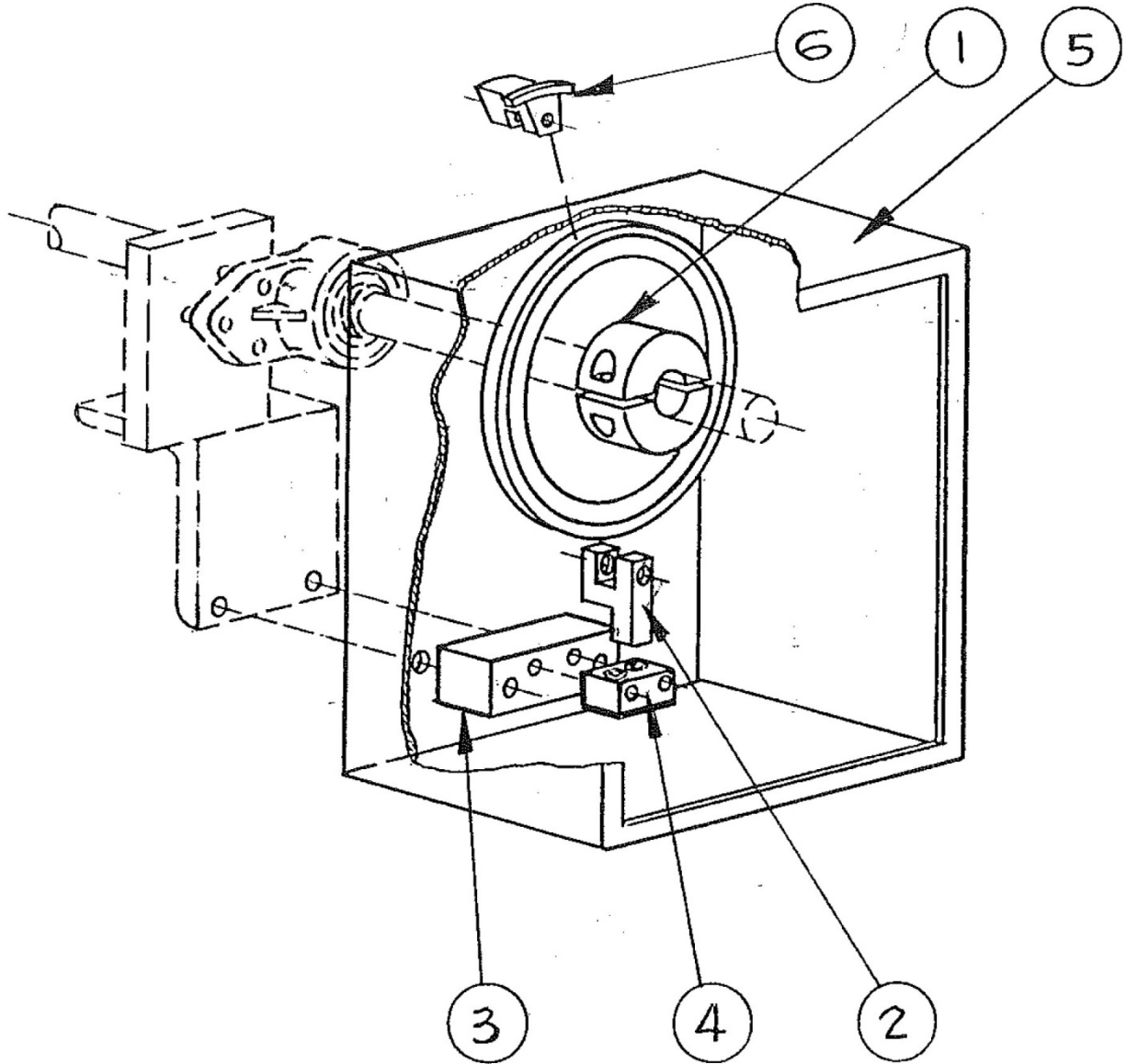
PARTITION ASSEMBLER
Vacuum Pick Arm Assembly

U6-2HS14

ITEM #	DESCRIPTION	DRAWING	M2M #	QTY
U6-2HS1400	Vacuum Pick Arm Assembly			
U6-2HS1401	Vacuum Pick Arm Frame Weldment	D1167-216		1
U6-2HS1402	Cylinder Plate	D1167-215		1
U6-2HS1403	Tie Bar	D1167-215		1
U6-2HS1404	Vacuum Arm Weldment	D1167-215		1
U6-2HS1405	Thomson Shaft 1" x 19-1/2"	D1167-215		2
U6-2HS1406	Bearing Housing Assembly (modified/tapped)	D4150-901		2
U6-2HS1407	Shaft Clamp	D1167-215		2
U6-2HS1408	URC 2-3/8" x 1" (70 duro)		05006D	2
U6-2HS1409	Thomson Bushing	A162536		4
U6-2HS1410	Thomson Seal	S-1000		4
U6-2HS1411	Tru Arc Retaining Ring	N5000-156		4
U6-2HS1412	Boston Thrust Washer	#18860		3
U6-2HS1413	Flex Lok Nut			3
U6-2HS1414	"O" Ring			1
U6-2HS1415	Vacuum Cup	OVC-25T		1
U6-2HS1415A	Vacuum Cup Spacer			1
U6-2HS1416	Hennells Cylinder 2" x 7-1/4"	HW30		1
U6-2HS1417	Lube Fitting	#1633		2
U6-2HS1418	Spacer x 1-3/4" long	D1167-215		2
U6-2HS1419	Spacer x 3-5/8" long	D1167-215		2
U6-2HS1420	Proximity Switch Support Plate	D1167-217		1
U6-2HS1421	Vacuum Arm Cylinder Guard	D1167-220		1
U6-2HS1422	Hinged Rear Guard	D1167-220		1
U6-2HS1423	Southco Handle	B8-43		1
U6-2HS1424	Vacuum Cup Spacer x 1"	B-11000		1

PROGRAM WHEEL ASSEMBLY

U6-2HS15



U-6

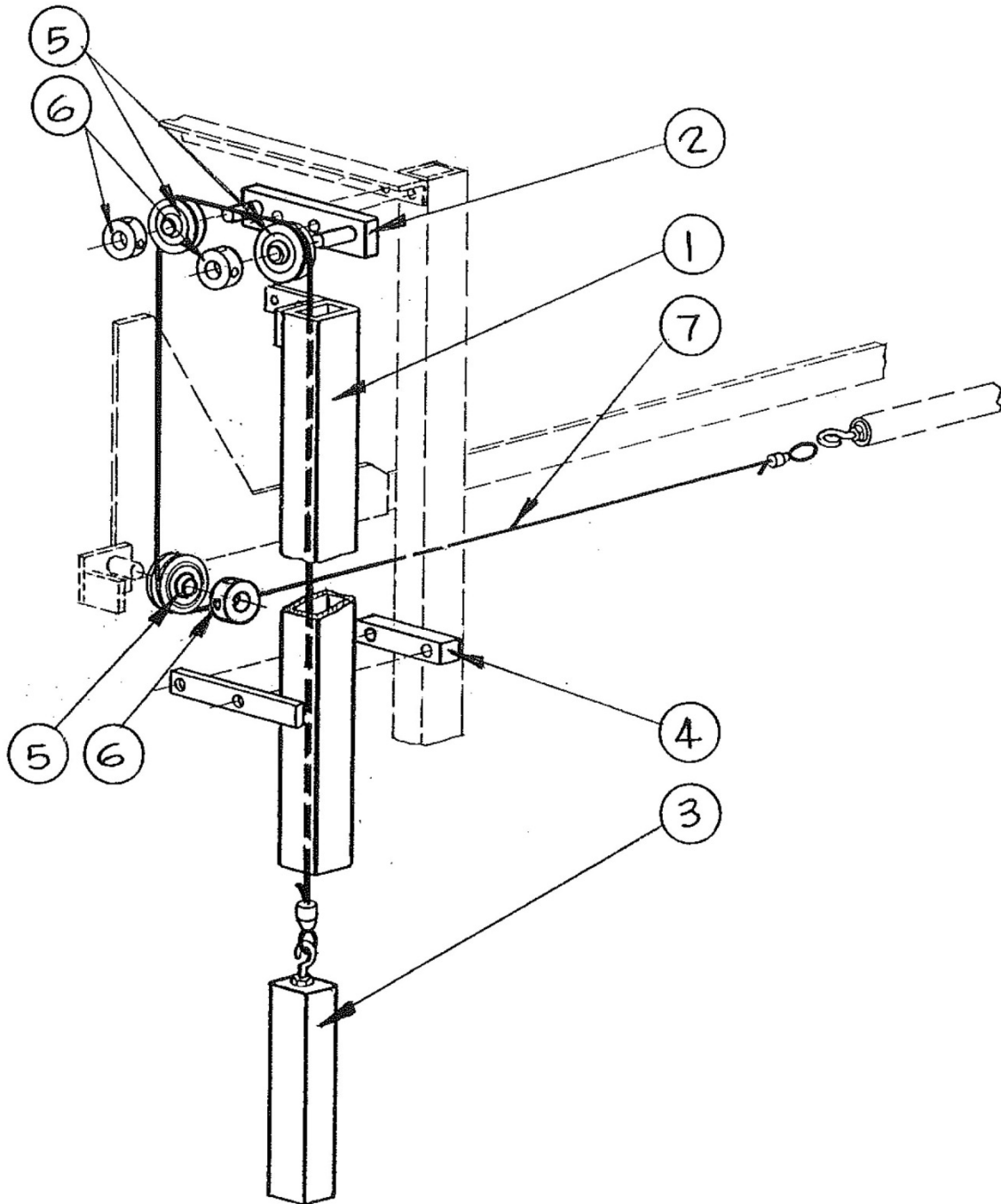
PARTITION ASSEMBLER
Program Wheel Assembly

U6-2HS15

ITEM #	DESCRIPTION	DRAWING	M2M #	QTY
U6-2HS1500	Program Wheel Assembly			
U6-2HS1501	Program Wheel Assembly	D1035-320A		1
U6-2HS1502	Program Wheel Flag		15629	1
U6-2HS1503	Switch Mounting Pad		15630	1
U6-2HS1504	Effector Switch	IND2004-DAROA		1
U6-2HS1505	Hoffman Enclosure (A12N106)			1
U6-2HS1506	Program Wheel Flag		15763	1

COUNTERWEIGHT ASSEMBLY

U6-2HS16



U-6

PARTITION ASSEMBLER
Counterweight Assembly

U6-2HS16

ITEM #	DESCRIPTION	DRAWING	M2M #	QTY
U6-2HS1600	Counterweight Assembly			
U6-2HS1601	Counterweight Guide Tube	D1167-601		1
U6-2HS1602	Pulley Mounting Bracket	D1167-601		1
U6-2HS1603	Counterweight	D1167-601		1
U6-2HS1604	Spacer	D1167-601		1
U6-2HS1605	Boston Cable Pulley	#2018		3
U6-2HS1606	Boston Collar	SC62		3