



Yeaman

VERTICAL CARTONER
MANUAL

CUSTOMER: Paket Corporation

MODEL: CVA-E3-750

SERIAL #384



Yeaman

28495 N BALLARD DR.

LAKE FOREST, IL

60045

847-758-0500

CONFIDENTIAL INFORMATION

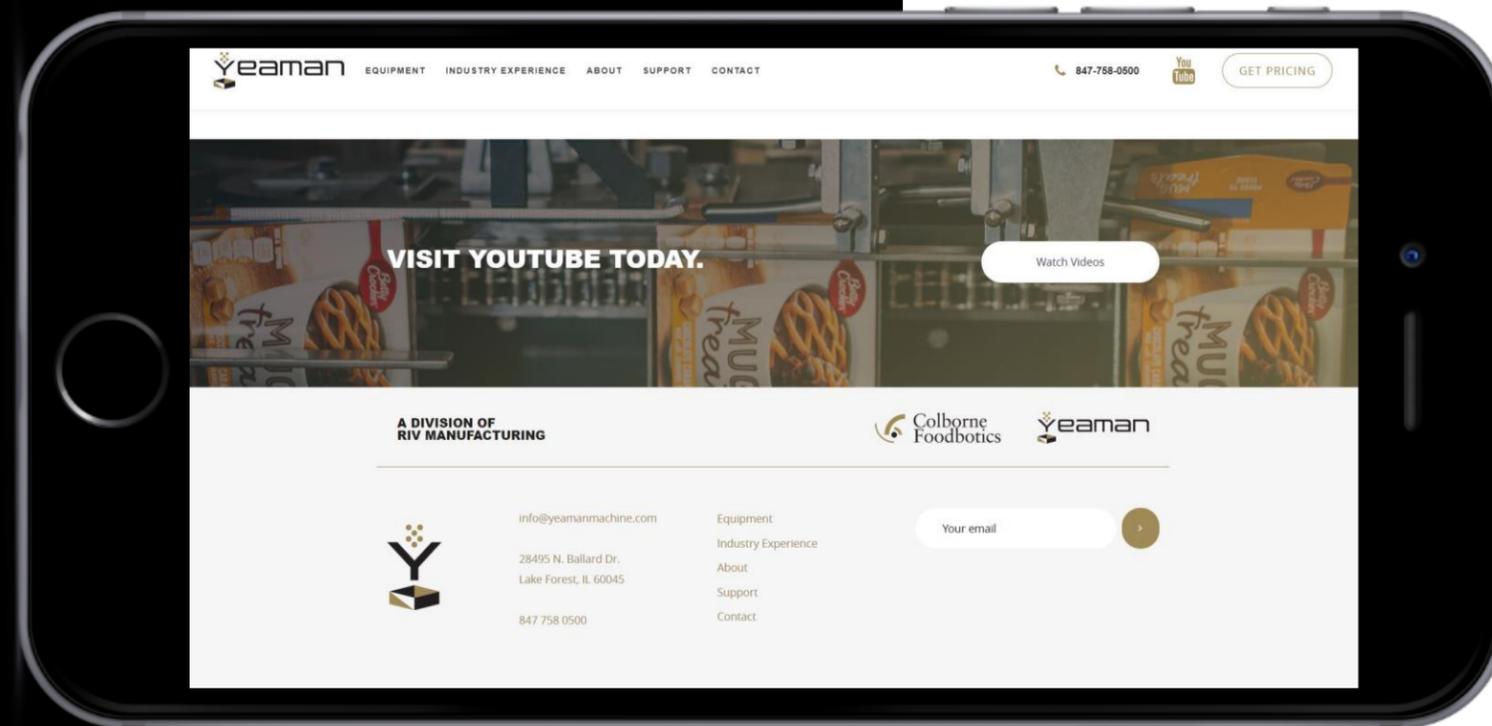
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CONTACT US FOR SALES & REMOTE SUPPORT

The following information is provided to ensure proper and expedient service of your machinery. When contacting Yeaman for service or parts, always have the Machine Model(s) and Serial Number(s) available. Please direct inquiries to the appropriate departments.



SPARE PARTS & REMOTE SUPPORT

SUPPORT@YEAMANMACHINE.COM

847.758.0500



SALES

SALES@YEAMANMACHINE.COM

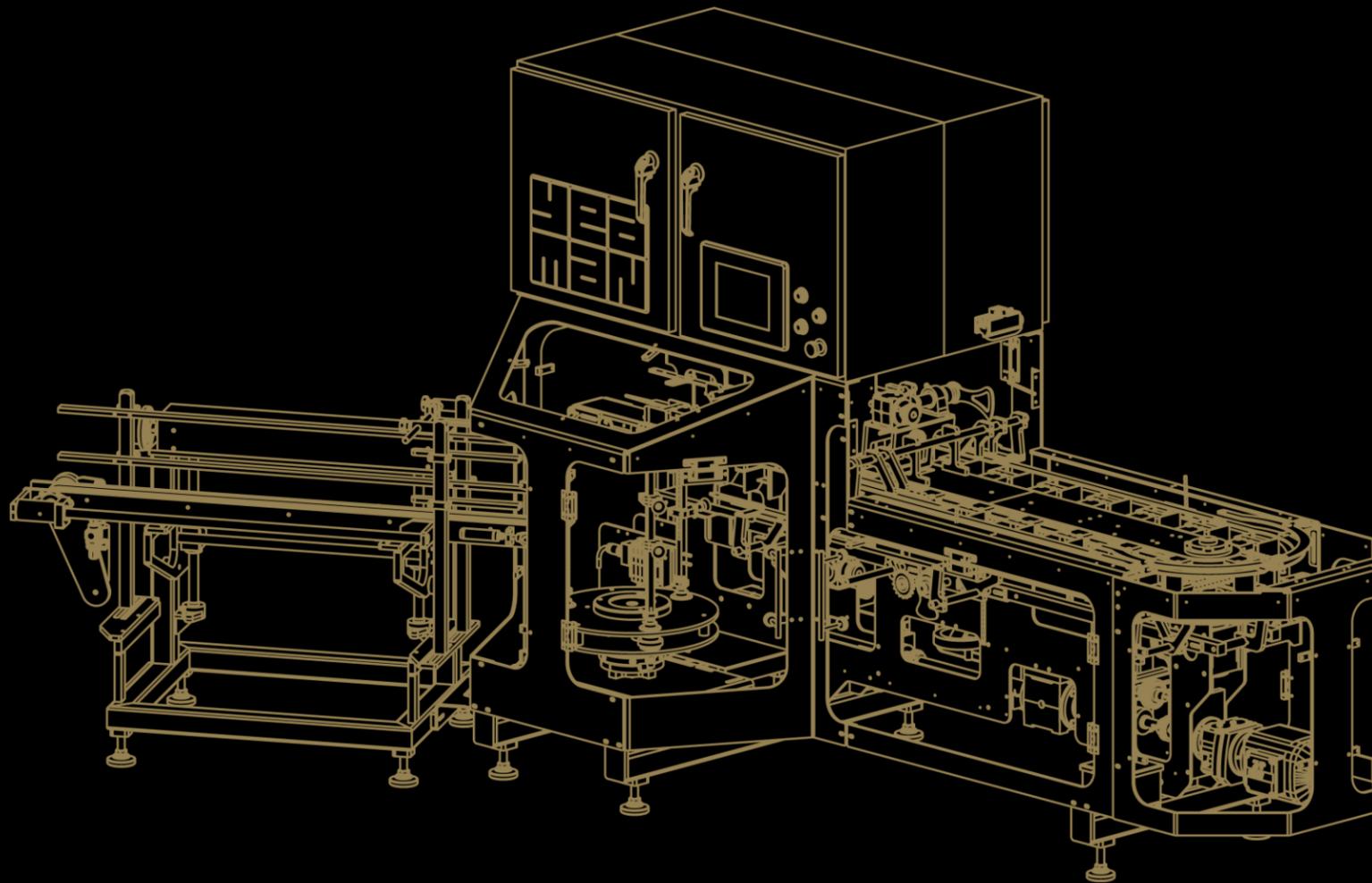
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MACHINE SPECIFICATION



MECHANICAL SPECIFICATION



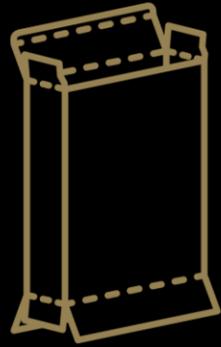
15" dia. x 120 deg. x 2 Head Rotary with Sleeve Pre-erector
Sleeve Bottom Closer (2 Stations)
5" Pitch Intermittent Motion Tilt Tray Conveyor
Sleeve Top Closer (1 Station)
Sleeve Ejector and Discharge Chute
Servo Main Drive to Run Intermittent Motion for Sleeve Application and Continuous Motion for Cartoning Applications. (Does Not Apply to Tilt Tray Conveyor)
One Set of (32) Custom Machined Sleeve Carrier Pockets
One Set of (72) Tilt Trays

ELECTRICAL SPECIFICATION



240 Volt or 480 Volt 3 Phase 60 Hz Main Voltage
110 Volt 1 Phase 60 Hz Accessory Voltage
24 VDC Control Voltage
Wired to NEMA 12X Standards (Splash-proof)
Powder Coated NEMA 12 Main Electrical Enclosure
Allen Bradley MicroLogix Control
Color Touch Screen
VFD Motor Controllers
Electronically Interlocked Barrier Guard Door System
Lockable Lever Type Fused Disconnect / Panel Mounted
Panel Mounted Circuit Breakers
Encoder Direct Coupled to Line Shaft

CUSTOMER PACKAGE SPECIFICATION



- **Container Size:** 1.625" x 1.5625" x 6"
• (Length of Opening x Width
• of Opening x Depth of Carton)
- **Container Style:** Tuck-Tuck Carton
- **Contents:** 2 ct 1 fl oz Tubes (Same)
- **Rate:** Variable to 40 cpm

-
- **Container Size:** 2.25" x 1.375" x 7.938"
• (Length of Opening x Width
• of Opening x Depth of Carton)
 - **Container Style:** Plastic oval shaped sleeve Fold in closures top & bottom
 - **Contents:** 1 ct 2 fl oz Tube
 - **Rate:** Variable to 40 cpm

PROJECT DESCRIPTION

Model: # 384 Paket Corp. CVA-E3-750

Vertical Cartoner, up to 40cpm, Intermittent Motion Operation

• Steel Base Frame with Satin Black Powder Coat Finish.

Stainless steel, Nickel plated, or Hard Coat Anodized Product Contact Surfaces.

Barrier Type Guarding Fixed and Hinged Polycarbonate Panels.

Inline Gearmotor Main Drive.

Main Drive Gears Totally Enclosed and Lubricated. Solitary Line Shaft design, Directly Coupled to the Main Drive Gearbox with Electronic Safety Protection.

Continuous Carton (Sleeve) Carrier Chain with Oil Impregnated Carton (Sleeve) Carrier Slides.

Fixed Top Carton Score Line Height.

Variable Carton (Sleeve) Height Capable Via Integrated Crank Type Carriage Adjustment.

4' Carton (Sleeve) Magazine Feeder

Fixed Carton (Sleeve) Control Guides Where Possible Minimizing Change Over and Producing Consistent Carton (Sleeve) Quality.

Standard Powered Inline (Side to Side) Carton (Sleeve) Discharge Conveyor.

Screen Adjustable Machine Rate Control with Rate

Indicator

Screen Adjustable Carton Magazine Feed Controls

Individual Screen Enable Selector Switches for Machine Features

Screen Adjustable 2 Channel Glue Pattern controls Test Screen to Individually test electric solenoids and motors

Screen Selectable Run & Jog Functions

Memory Screen Capable of Selecting up to 10 Program Configurations

Tower Lights with Audible Alarm

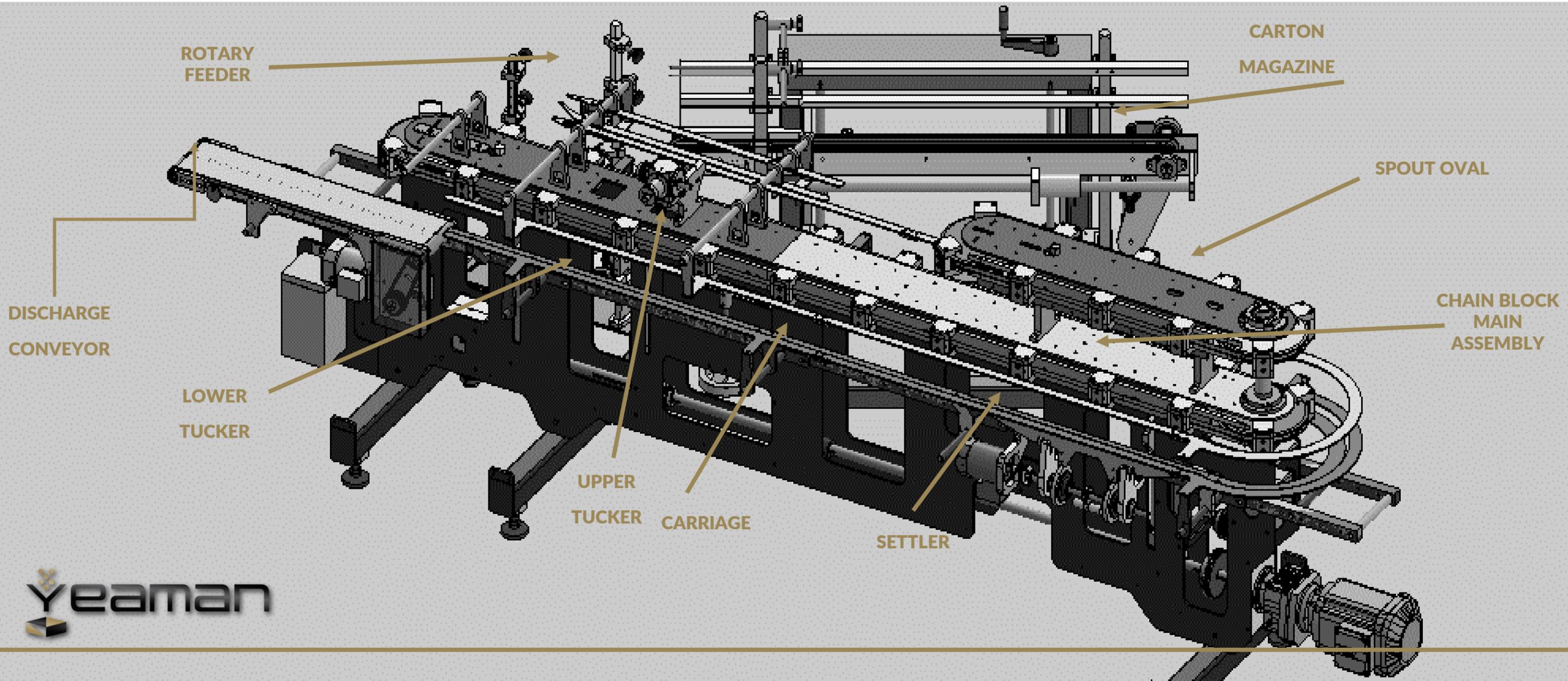
Flashing Red: Machine Not Reset / Fault Flashing

Yellow: Machine Reset / Ready Solid Green: Machine Running

Alarm: Machine Starting

OPERATION DESCRIPTION

Our base vertical hand-load cartoner machine operation takes flat, side seamed sleeves (cartons) one by one from a vertical sleeve (carton) magazine feeder. Each sleeve (carton) is placed by a vacuum powered rotary sleeve (carton) feeder into a sleeve (carton) "pocket" mounted to a carousal conveyor. Next, the sleeve (carton) bottom flaps are folded closed and sealed, employing a variety of closure styles. The sleeves (cartons) are then brought to the load area. Product is transferred to a tilt tray from the customer's conveyor. The trays travel to the load area of the machine where they pass through a cam which tilts them up at a pre-determined angle. This causes the product to slide out of the tray into the open sleeve (carton). After the load area, the top flaps are plowed closed, and then the finished sleeve (carton) is discharged from the machine.



SAFETY



MACHINE START UP AND SHUTDOWN

Your Yeaman machine encompasses electric, electronic, and/or pneumatic systems to perform each of its operations. Please follow this start up and shutdown sequence to protect your personnel from injuries and the machine from damage



STARTING YOUR MACHINE

To turn on your Yeaman machine:

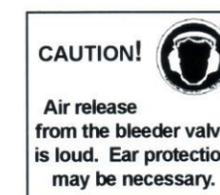
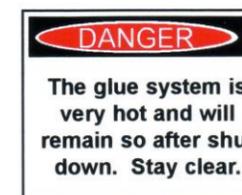
1. Secure all electrical and pneumatic connections.
2. Verify proper carton loading.
3. Close all safety doors, guards, panels, and interlocks.
4. Close and lock all doors on the Electrical Boxes.
5. Clear all personnel from the machine area.
6. Open the Main Air Supply Shutoff Valve.
7. Turn On the Main Disconnect Switch on the Electrical Box.
8. Wait for the program to completely load.



MACHINE SHUTDOWN

To shut down your Yeaman machine:

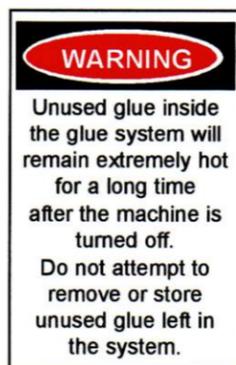
1. Clear all personnel from the machine area.
2. Keep all safety doors, guards, panels, and interlocks closed and in place.
3. Turn Off the Main Disconnect Switch located on the side of the Main Electrical Box.



VERTICAL CARTONER SAFETY

GENERAL

- All personnel involved with this machine must be thoroughly familiar with its operation. Ignorance of machine functions and safeguards leads to accidents.
- Before operating this equipment, read and understand **ALL** warning markings, labels, notices, and manuals.
- This machine has been provided with protective interlocks which prevent it from running with the Main Electrical Box door, or the Main Disconnect Switch Box, in an open position. Serious injury may result if interlocks have been bypassed or tampered with.
- Before operating the machine, understand the purpose and operation of each switch. In addition, know how to stop the machine from running.
- Press the red *Emergency Stop* button, located in three locations on the machine. This will immediately stop the machine from running.
- If the *Emergency Stop* button fails to stop the machine, turn **OFF** Main Disconnect.
- NEVER reach inside the guard area. Under certain conditions, it is possible for the machine to not be running and then to start running unexpectedly. NEVER place your hand between moving parts while the machine is cycling.
- Keep arms, hands, fingers, hanging clothing, jewelry (such as rings, bracelets, and watches), etc. away from moving parts on scale, filler, and/or case packer model machines. Likewise, loose clothing such as ties and long sleeves must be avoided when working around any machine. These items may be caught in the machine and cause serious injury to the wearer.
- To avoid slipping, keep the immediate area around the machine clean. Discard broken cases and spilled product immediately. To avoid the hazard of electric shock, always clean up any water that may have spilled. If water is used in the area of the machine, use extra caution.
- Be sure you have proper exhaust equipment and wear a protective mask to filter dust from the air. Before handling any potentially dangerous products, make certain you are protected. Wear a protective mask, gloves, and/or safety glasses as required. If you have any questions whether such equipment is adequate, contact your plant safety engineer.
- Exercise Caution near doors, linkages, etc. to avoid being pinched.
- If you have any additional questions, or if you are not sure on any procedure, contact your plant safety engineer and/or your shift supervisor.



ELECTRICAL

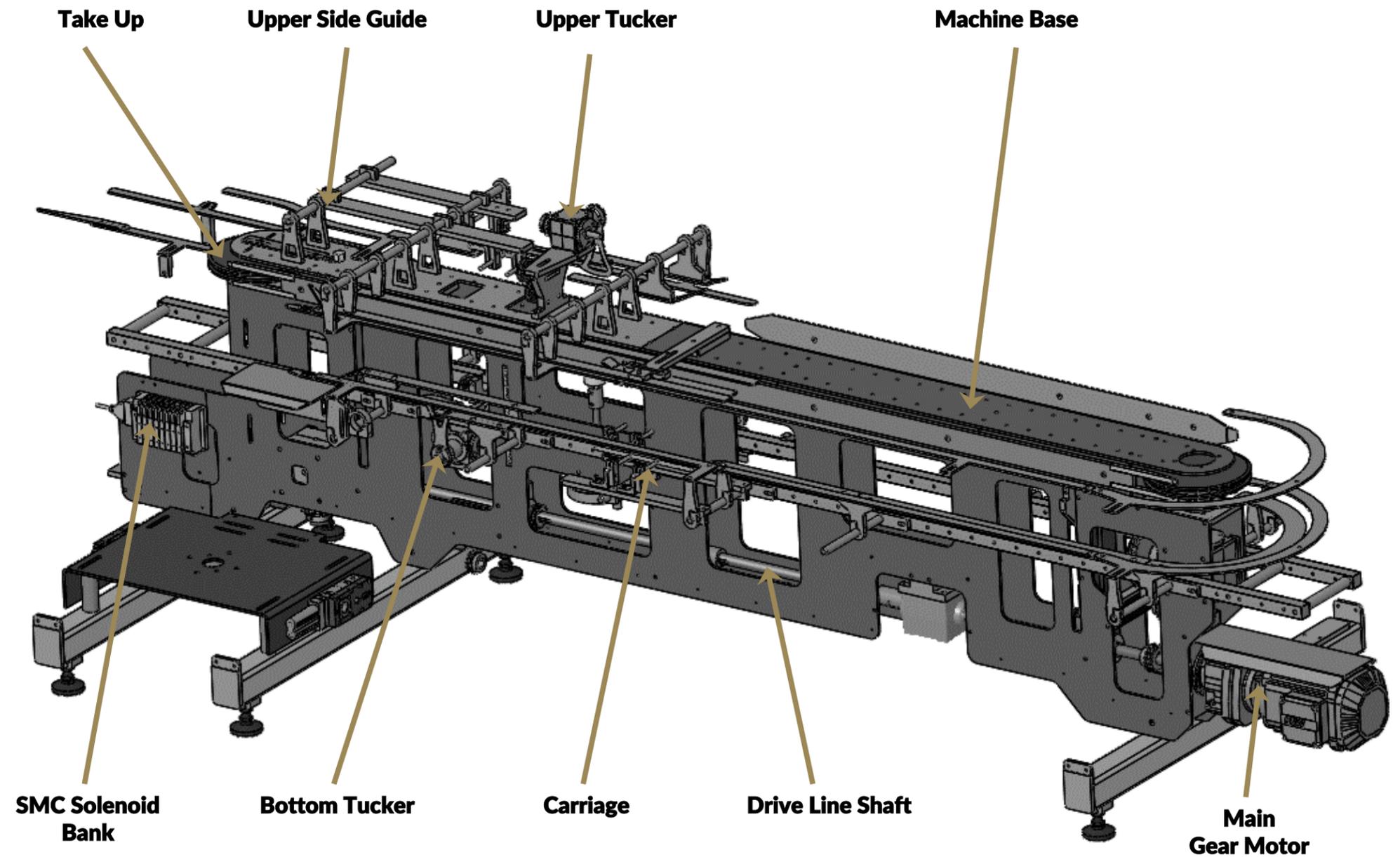
- Only trained qualified personnel should be allowed inside the Main Electrical Box (control cabinet). The control panel door(s) should only be open when absolutely necessary to check the electrical equipment or wiring.
- Before starting production or even turning **ON** the machinery, read and understand all warning markings, notices, and safety switches.
- All electrical/electronic troubleshooting and repair should be undertaken only by personnel who are properly trained and are known to have adequate knowledge and skill in this area.
- Assume at all times that power is **ON** and treat all conditions as if they are live. This practice develops a caution that may help prevent accidents.
- Pull down the Main Disconnect Switch to the **OFF** position and Lockout or install a “*hold-off*” tag. A switch in the **OFF** position with a lock is positive protection from someone accidentally turning the power **ON** while you are working.
- Make certain you have opened the circuit by checking with the proper test equipment.
- When troubleshooting “live” equipment, the necessary precautions must be taken as follows:
 - a. Make certain your tools and body are kept clear of electrical ground including the machine frame.
 - b. Be especially cautious in damp areas.
 - c. Be alert and work without any outside distractions.
- Before applying power or restarting any equipment, it must be established that all persons are clear and away from machine grounds.
- All covers on junction boxes **must** be closed and latched before leaving the machine.
- If you have any additional questions, or if you are not sure on any procedure, contact your plant engineer and/or your shift supervisor.

CLEANING

- Before beginning any hands-on cleaning of the machine, turn OFF and LOCKOUT the Main Disconnect Switch and the Main Air Supply Shutoff Valve.
- Keep the area around the machine clean and dry by removing broken bags, spilled product, and water right away. A moist floor can be dangerous and should be dried before operating any machine.
- If caustic or toxic products are being packaged, be sure you have proper exhaust equipment and are wearing a protective mask to filter out dust from the air. Before whether such equipment is adequate, contact your plant safety engineer.
- If you have any additional questions, or if you are not sure on any procedure, contact your plant safety engineer and/or shift supervisor.

MACHINE BASE

•Machine base consist of precision steel frame with powder coat finish, Carton Carrier Chain and machine main drive line shaft.



Troubleshooting for Carton Magazine

Problem: The chain is not advancing properly after the set number of cartons.

Solution: Check the Air Cylinder on the Drive Chains to be sure that it is operating properly.

Problem: Cartons are not advancing in a smooth and controlled motion.

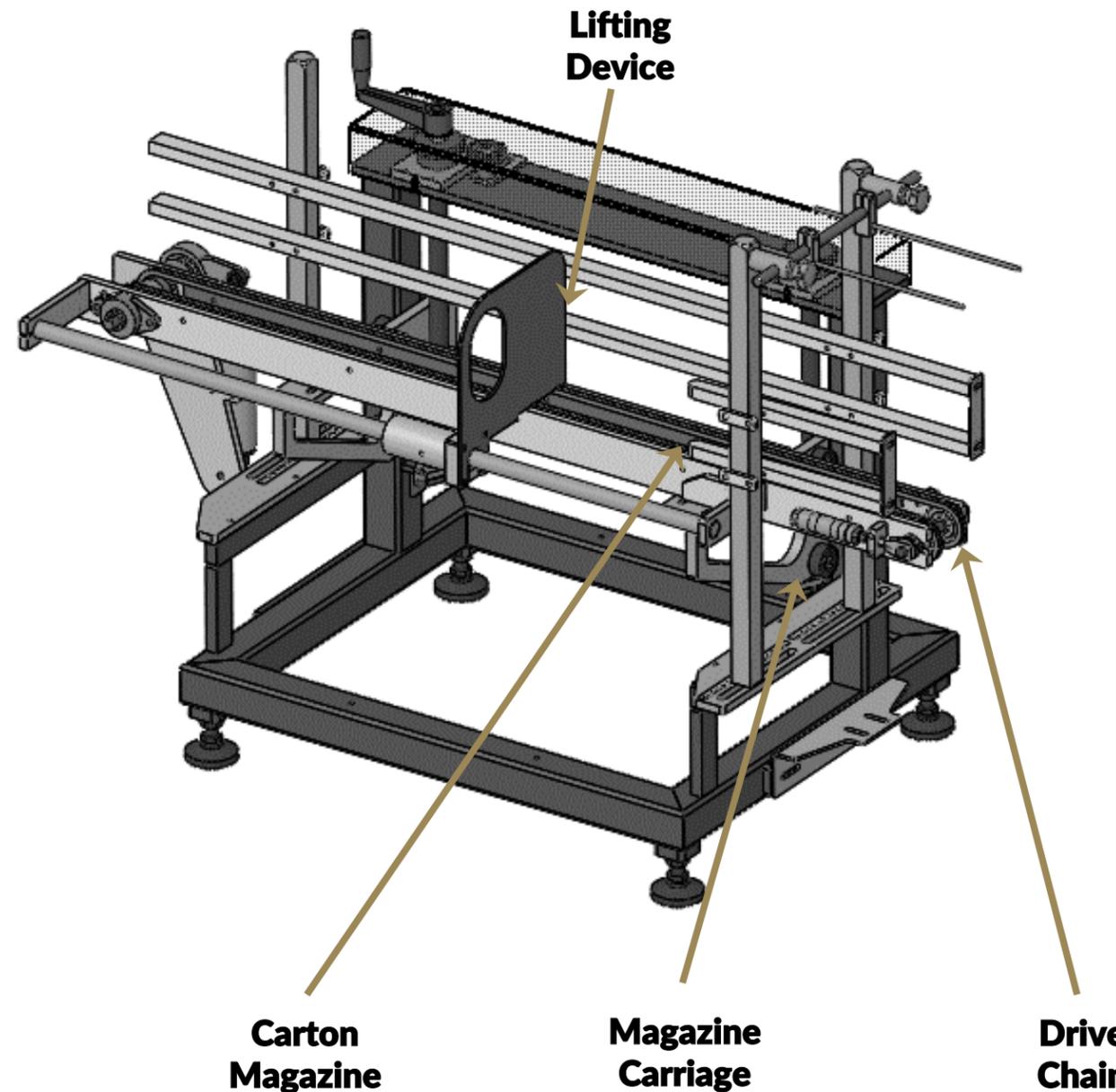
Solution: Check the tension of the Back Pressure Plate Drive Chain to make sure that there is enough slack and that it is not tightened too tightly.

Problem: Cartons are falling out of the end of the magazine feed.

Solution: Adjust the stop plates to hold 1/8" of the carton on each side.

CARTON MAGAZINE

•The function of the Carton Magazine is to store and supply cartons to the Rotary Feeder. The cartons are supplied at a rate that is a function of machine speed. The faster the machine speed, the faster the carton supply rate. The cartons are supplied by advancing the carton back pressure plate which is pushed forward by chains driven by the magazine clutch. The feed up rate of the carton magazine can be adjusted through the Panel View, please refer to the *Operator Interface* section of this manual for specific instructions. Adjustment level of cartons should be set up manually Up and Down with Lifting Device.



CAUTION

Avoid **Pinch Points** along the *Back Pressure Plate Drive Chain*. Keep arms, hands, and fingers clear of the chain while operating the machine.

ROTARY FEEDER

1. The function of the Rotary Feeder (Figure 1) is to pick cartons from the Carton Magazine, and erect them in the carton carrier pocket.

2. If there is a significant change in the carton height, it might be necessary to adjust the height of the lower suction cup arm on the 3 heads for the Rotary Carton Feeder. The height should be set so the upper cup attaches to the carton just below the top score line. The lower cup should be placed low enough to allow stability, but it does not need to be near the lower score line.

3. Use scale for the level adjustment.

Troubleshooting for Rotary Carton Feeder

Problem: There is no suction at the suction cup.

Solution:

A: Check to insure that the vacuum pump is on.

B: Check to insure that all pneumatic hoses are connected correctly.

C: Check vacuum, minimum should be 16 in. Hg. Vacuum at the cup

D: Check to insure that pressure regulators are not turned off.

Problem: The carton is not placing properly into the carton carrier pocket.

Solution:

A: Check to insure that the rotary carton feeder is set up properly as explained in the set up sheet at the end of this section.

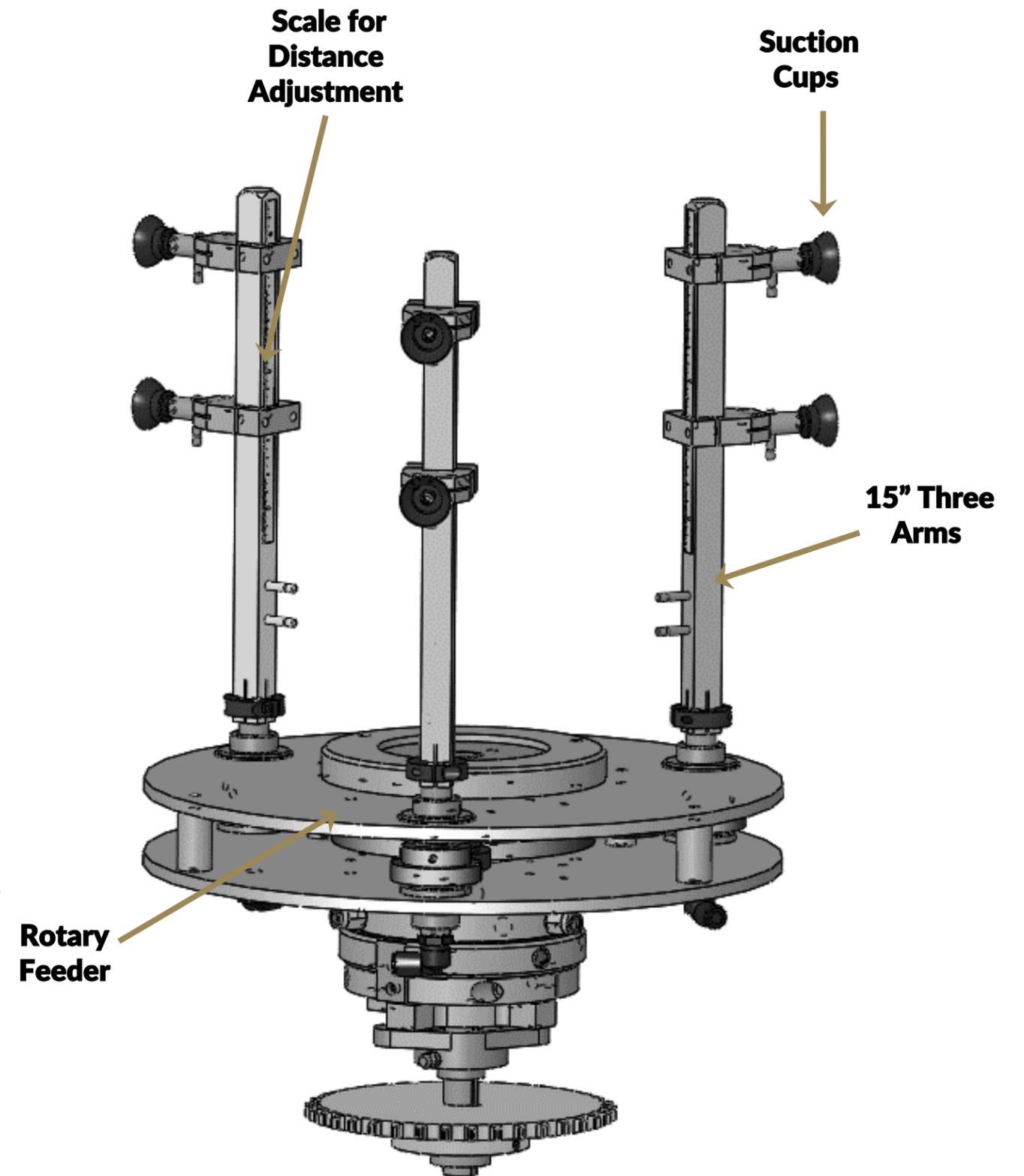
B: Check to insure that carton does not have light scores, broken flaps, or the carton is warped.

C. Check suction cups, make sure surfaces are clean, no tears

Problem: Cartons are not being picked off because of low suction cup vacuum.

Solution:

Check to make sure that the Carton Release Blow-Off pressure is not greater than 10 psi.



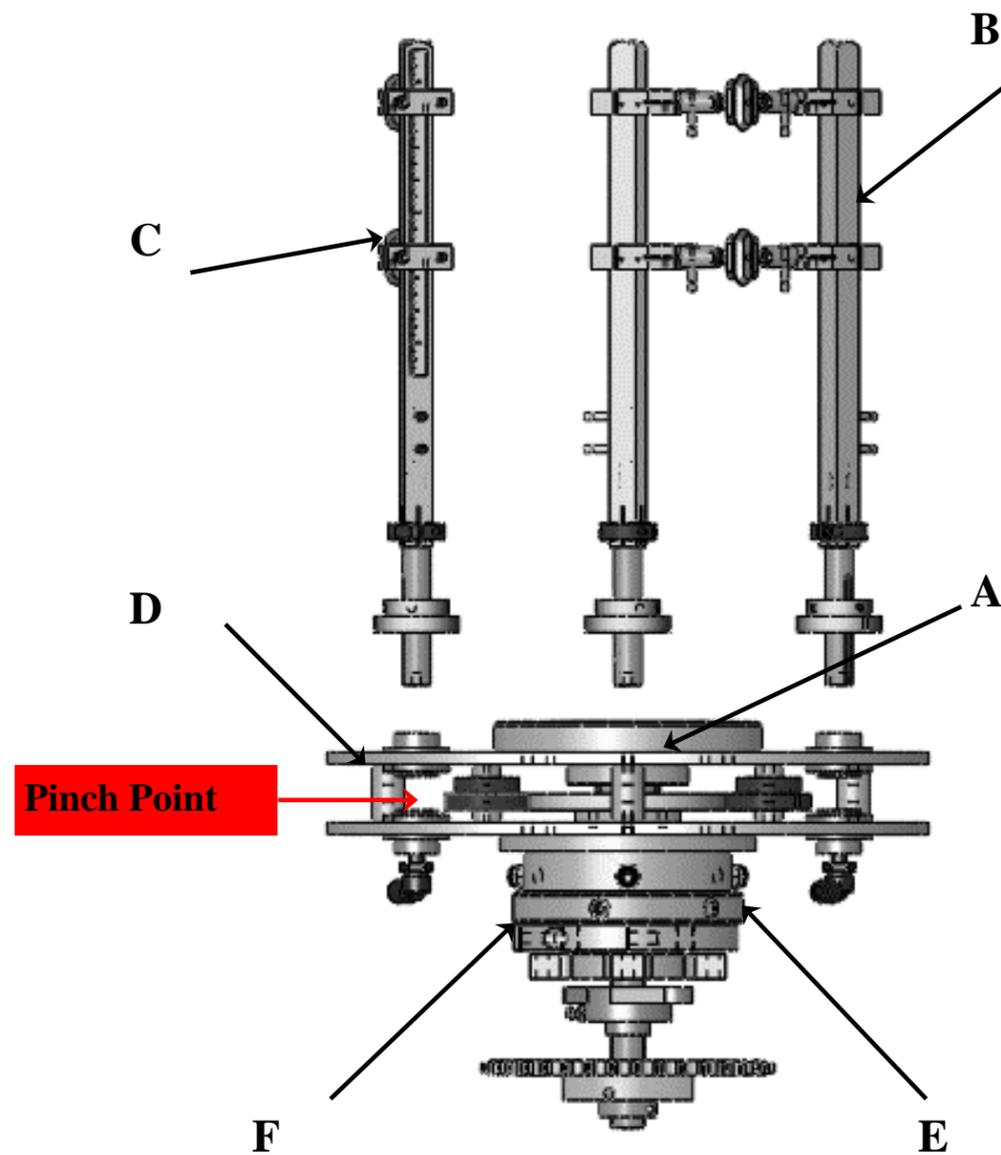
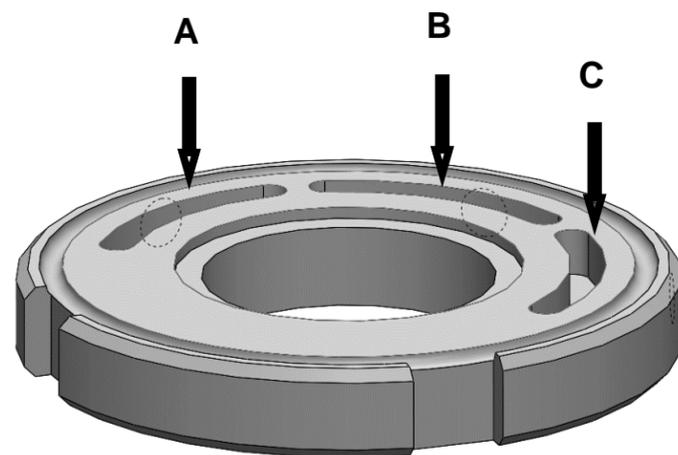
ROTARY FEEDER SUB-COMPONENTS

ROTARY CARTON FEEDER (RIGHT)

- A. Hub Clamp Plate
- B. Rotary Arm
- C. Suction Cup
- D. Rotary Table
- E. Vacuum Valve
- F. Valve Retainer Plate

Vacuum Valve (below)

- A. Carton "Pick Off" Vacuum
- B. Carton "Carry Over" Vacuum
- C. Carton Release Blow-Off



Vacuum Pressure

The Vacuum Valve has three crescent shaped slots cut into it which allow the pick off, carry over, and blow off operation of the rotary carton feeder. This plastic valve, as shown in Figure 3, has three air lines attached at different points. The first opening, for the carton "pick off" vacuum, can be adjusted with the Carton Pick Off Pressure Regulator. The middle opening, for the carton "carry over" vacuum, is a continuous vacuum for carrying a carton and is controlled by the Carton Carry Over Pressure Regulator. The third opening, for the carton release blow off, is a continuous exhaust controlled by the Carton Blow Off Pressure Regulator.

ROTARY FEEDER TIMING CALIBRATION

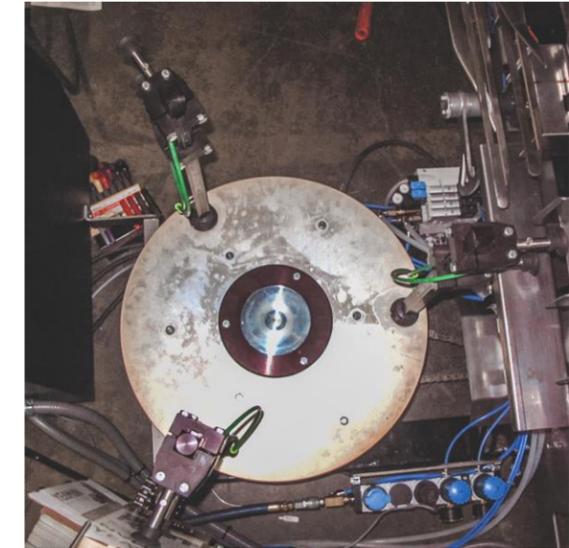
- 1.) Place the cartoner in Manual mode and jog a carton block so that it is centered between the two notches in the top plate as shown in the figure to the right.



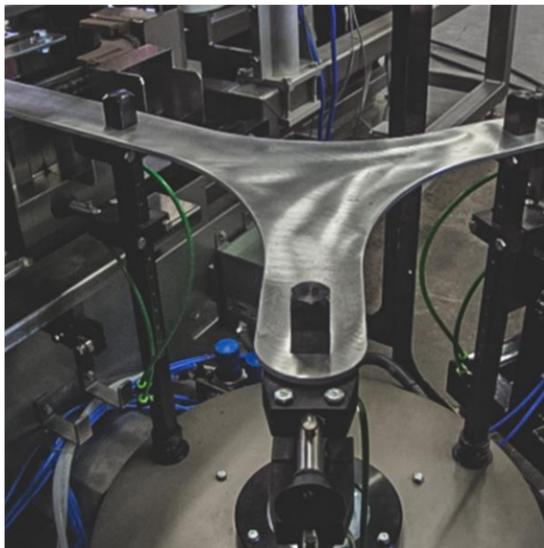
2.) Loosen four screws on main hub.



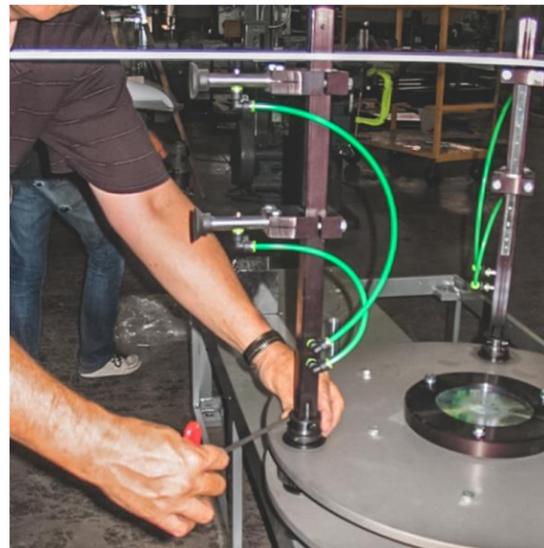
3.) Loosen locking collar on each suction cup post.



4.) Manually turn the rotary unit until all heads are facing outward as shown



5.) Place locking key over the three rotary arms and locator pin on the cartoner frame as shown



6.) Re-tighten locking collar on each suction cup post.

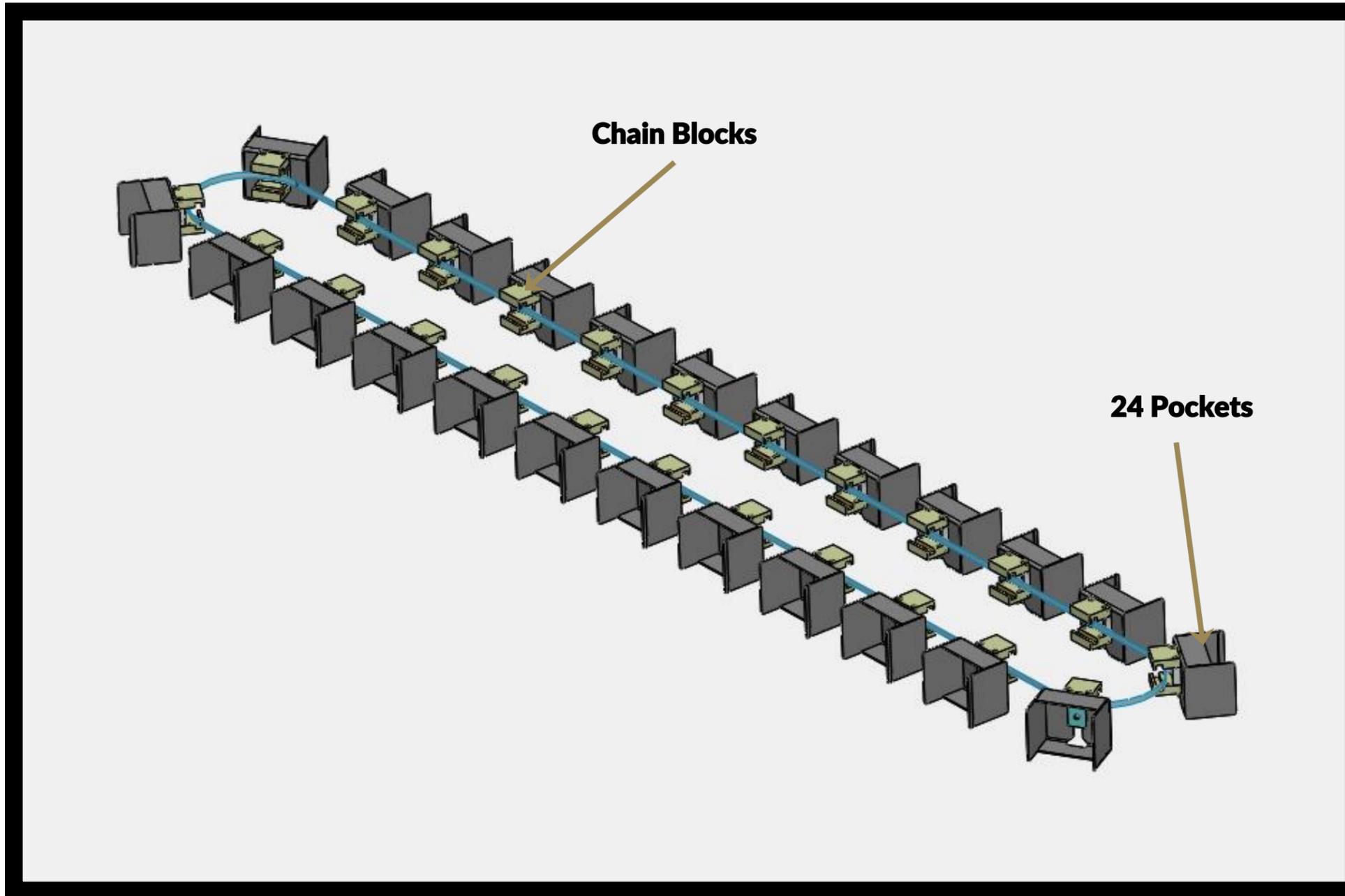


7.) Re-tighten four screws on main hub

- 8.) Remove alignment tool and the rotary now ready to start running packages

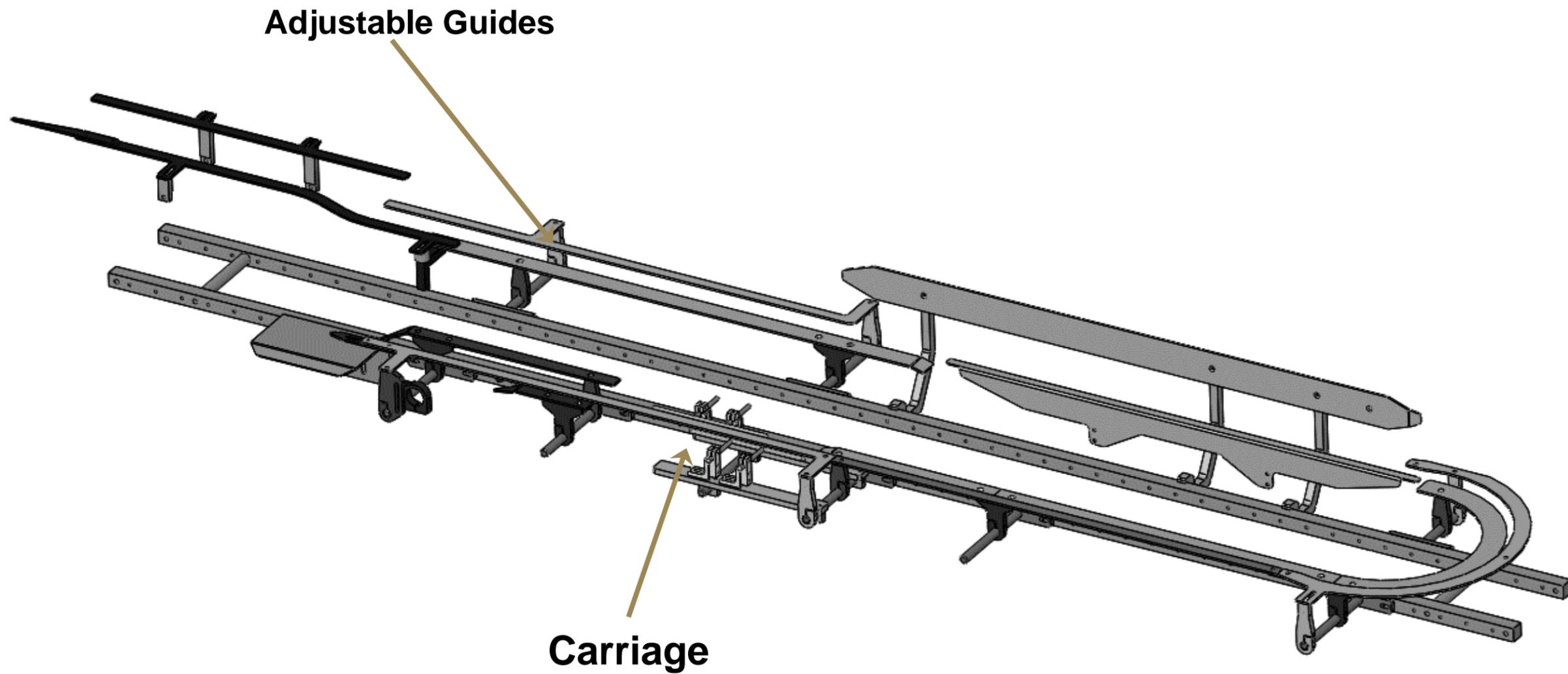
POCKET CARRIER CHAIN

- Continuous motion system that carries the erected cartons in a fixed carton pockets for further Tilt Conveyor loading.



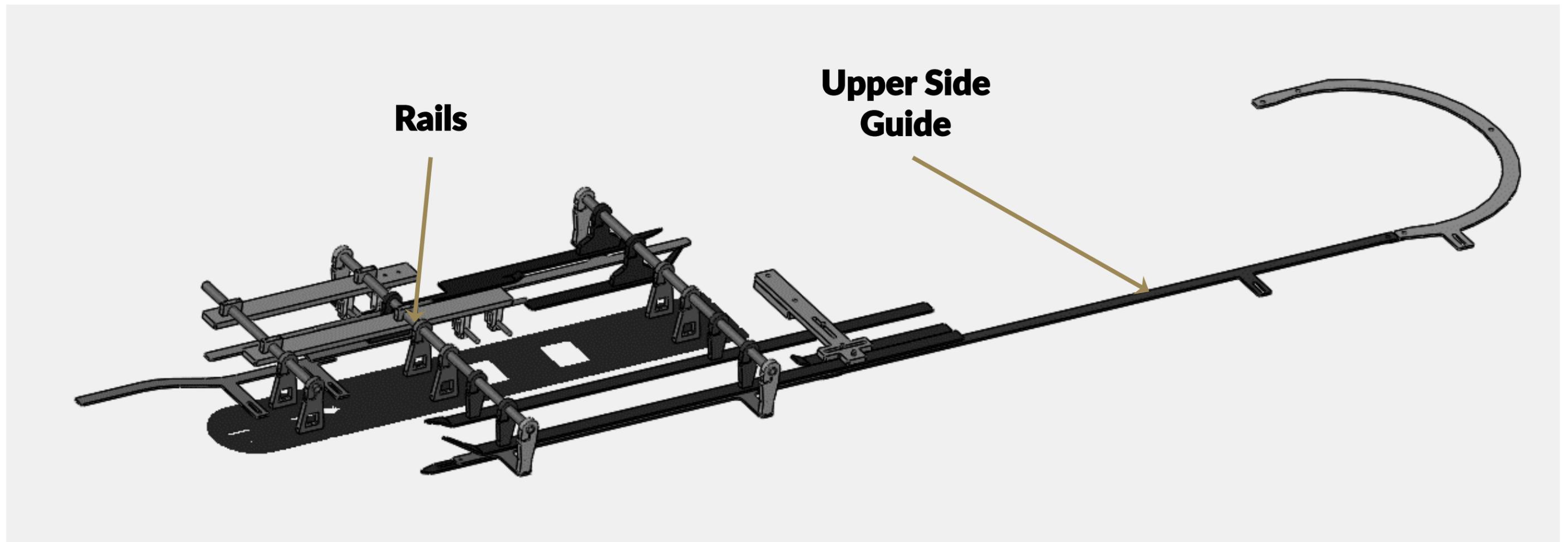
CARRIAGE

- Support structure with adjustable height is used to support bottom closing plows and tucker, settling rail, lower section of outer carton side guide. System has adjustable guide plates.



UPPER SIDE GUIDE

- Set of rails used to guide cartons and fold upper carton flaps and compression top of carton.

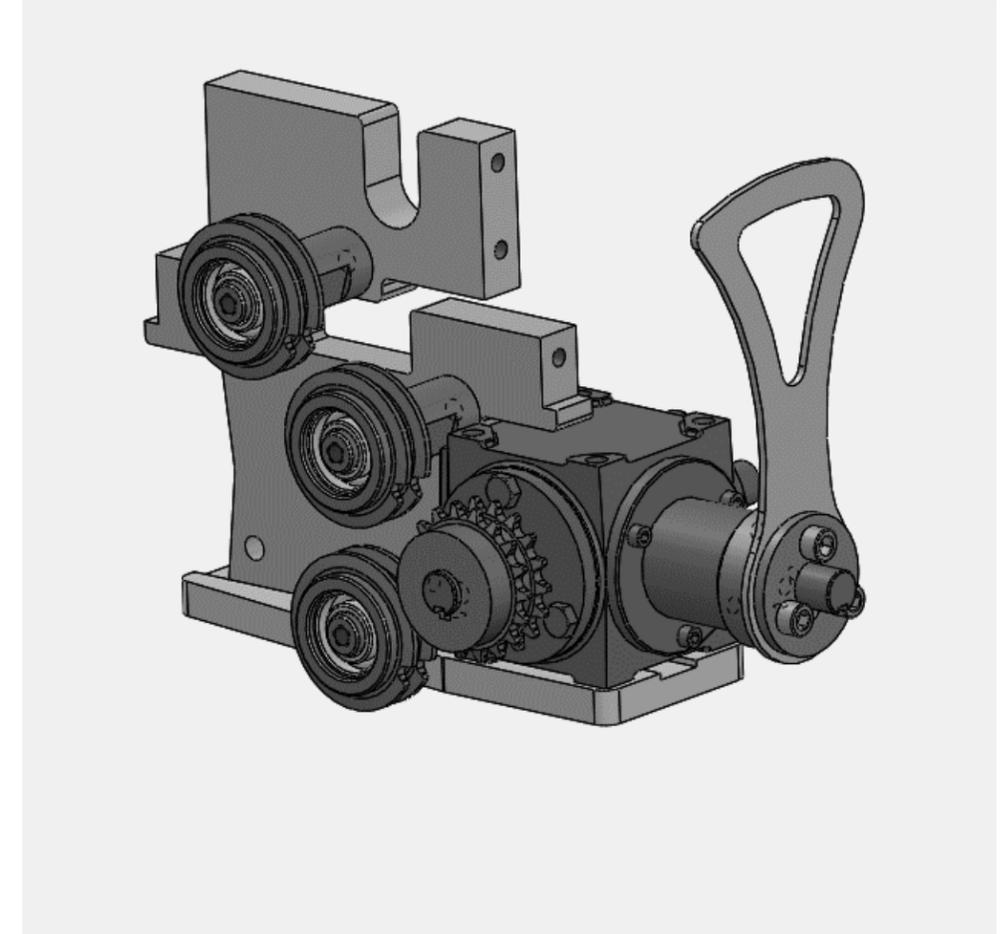


TUCKERS

- Tuckers are used to close minor flaps prior product loading, as well as to close minor bottom and top flaps in a carton closing sequence.



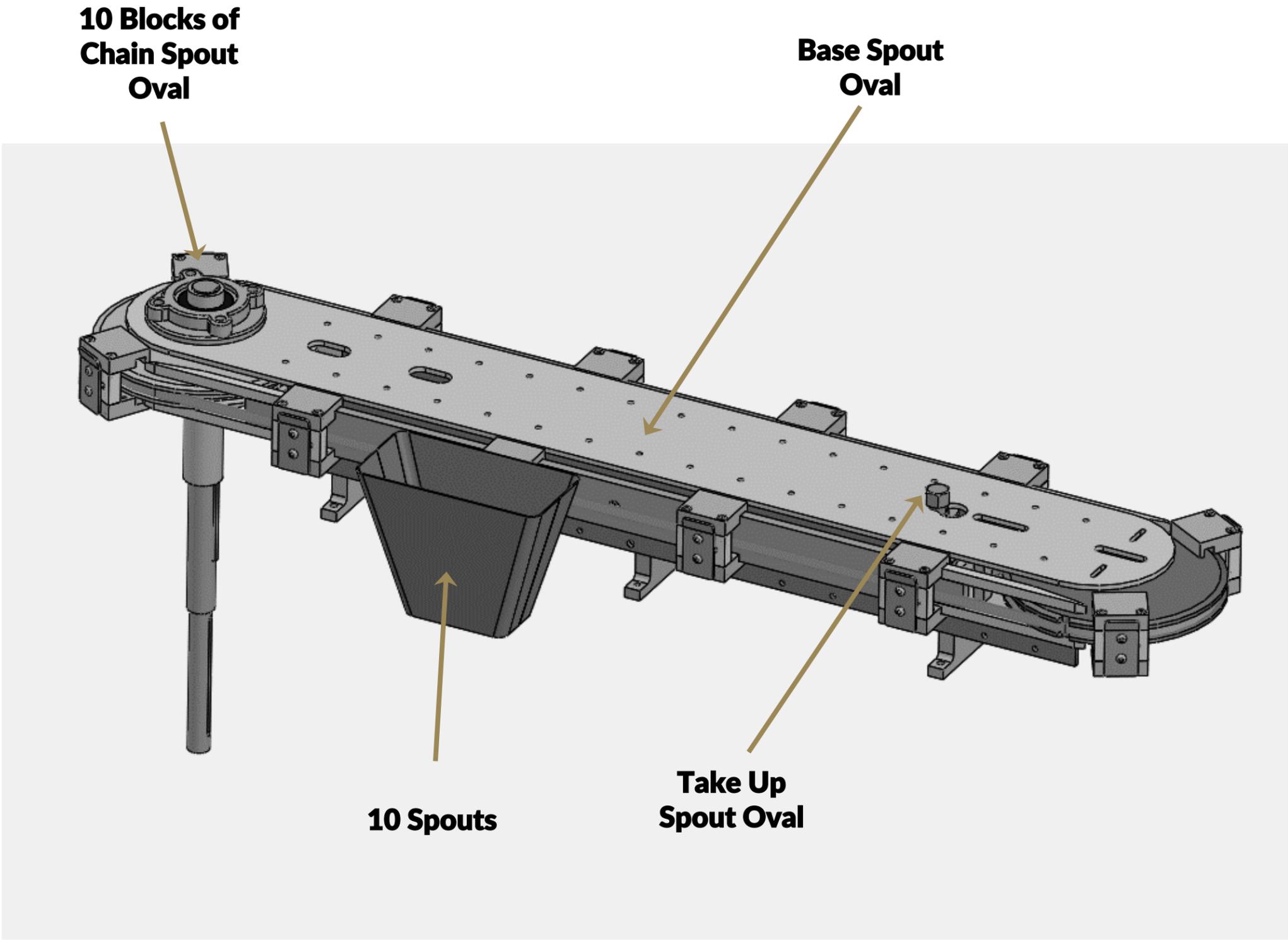
**UPPER
TUCKER**



**BOTTOM
TUCKER**

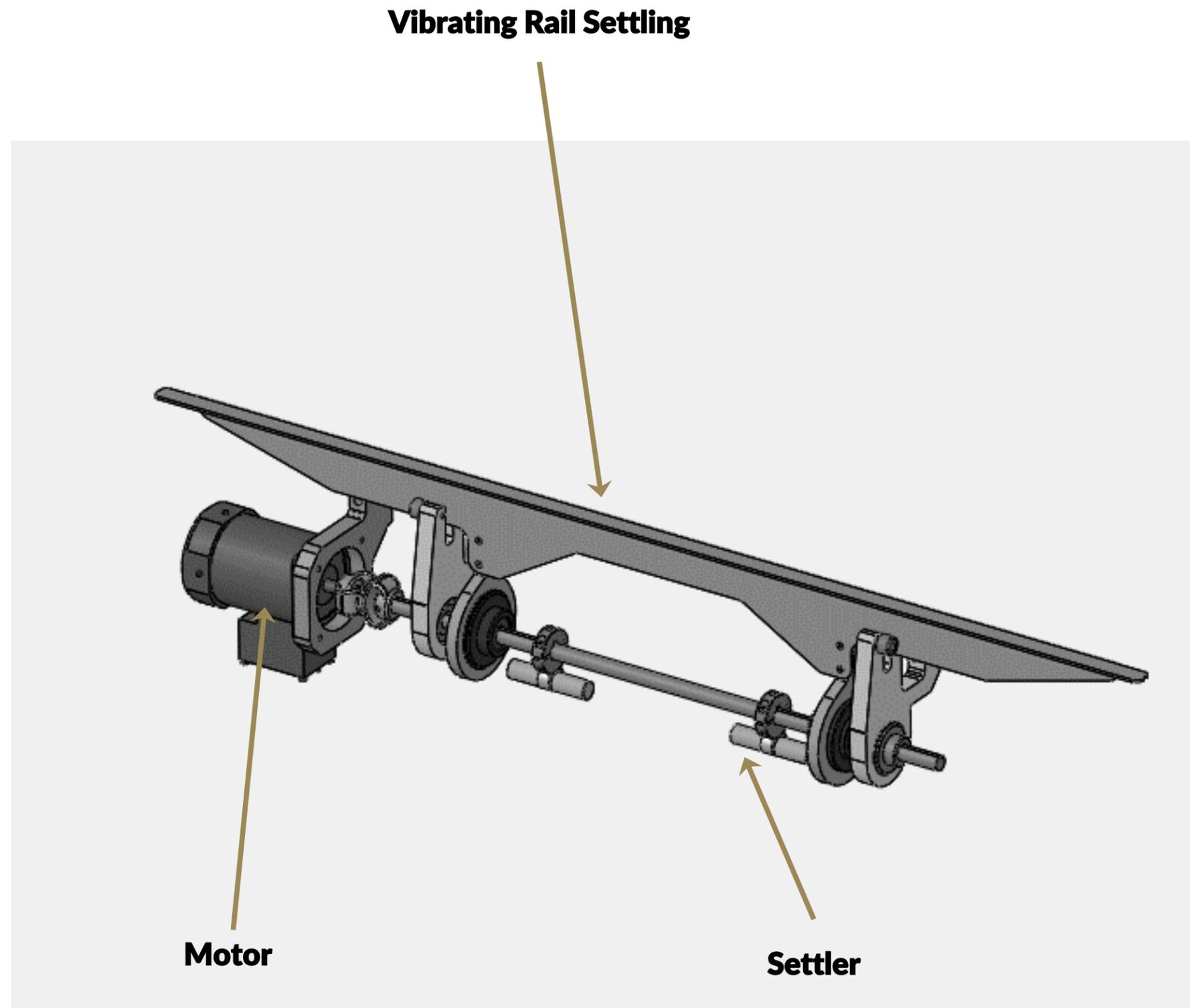
SPOUT OVAL

- Continuous motion system that carries a fixed spouts for further product loading from Tilt Conveyor to the cartons.



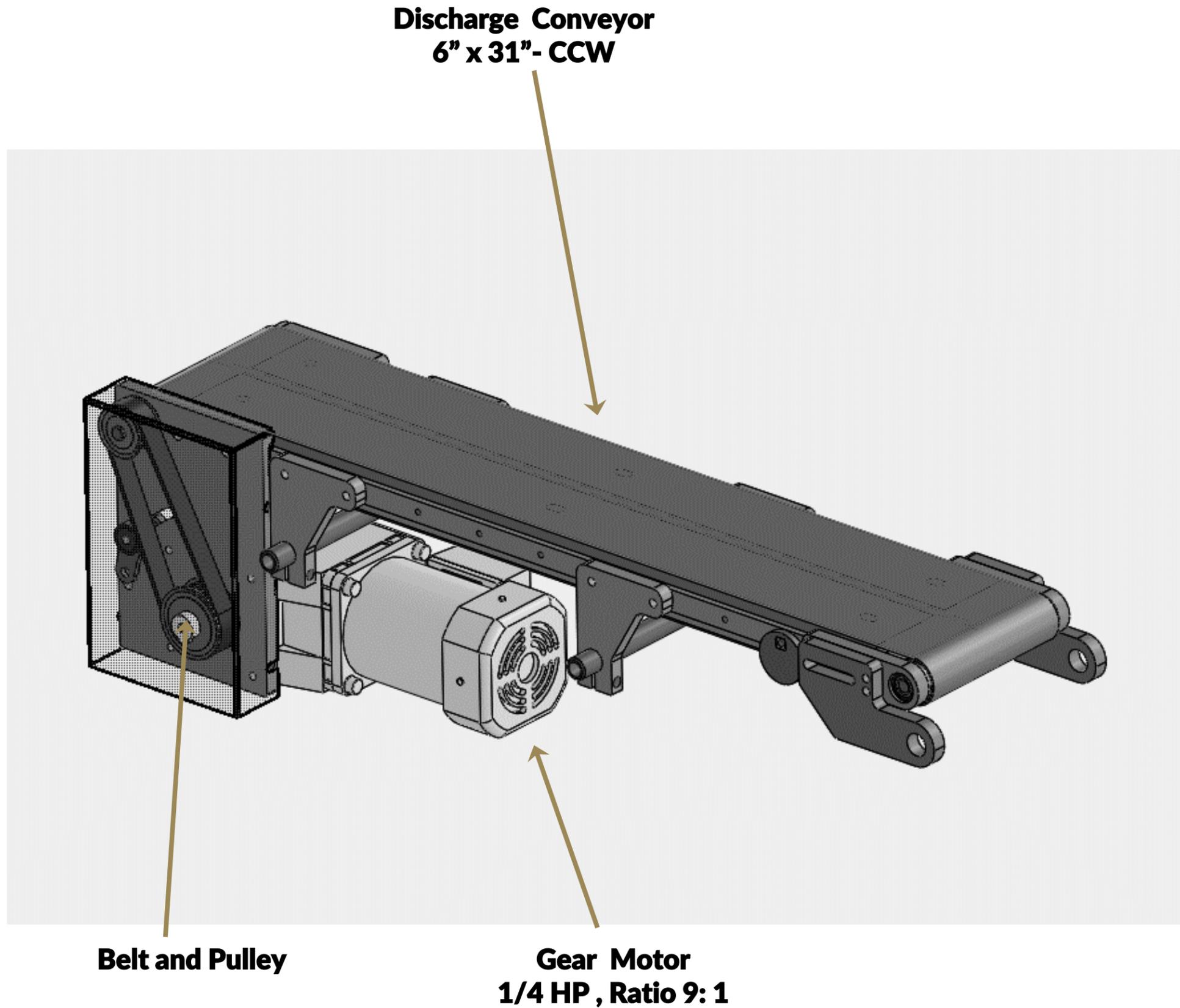
SETTLER

- Tuckers are used to close minor flaps prior product loading, as well as to close minor bottom and top flaps in a carton closing sequence.



DISCHARGE CONVEYOR

- Discharge conveyor transportation products out from machine and send to other conveyor.



VERTICAL CARTONER MACHINE MAINTENANCE



MACHINE LUBRICATION

The lubrication of all power transmission components, bearings, and drive trains is very crucial to machine performance and machine life. The periodic maintenance of the case packer should be done on a monthly basis. The lubrication schedule for pertaining to the type of component will be described below.

Flange and Pillow Block Bearings:

All flange and pillow block bearings should be lubricated with a grease gun every three weeks.

Use the following food-grade grease (or similar): Bel-Ray NO-TOX HDGREASE #2

Cone Drive Gear reducers:

Series B units and Series S Servo Gearheads are factory filled with a high quality synthetic lubricant. They are "Lubricated for Life" and require no periodic maintenance.

Bevel Gear Boxes:

All bevel gear boxes should be lubed with HUB CITY LUBRICANT P/N GL-90/EP5 OR EQUIVALENT. Oil should be changed every 2500 hours of operation or every six months, whichever ever comes.

SEW Eurodrive Gearmotor:

Inspect oil levels and oil quantity at regular intervals.

Change oil at 10,000 operating hours or 2 years.

Clean and repack greased bearings at 10,000 operating hours.

•Note: If you use synthetic lubricants, you can effectively increase the maintenance cycle to 4 years.

Drive Chains:

At an interval of every two weeks the chains should be checked for proper tensioning and lubricated. Use any type of chain oil. For a USDA machine, use a food grade oil such as Crisco.

Base Machine (Main Drive)

Sprocket teeth should be inspected for wear after the first 24 hours, 100 hours and 500 hours of the machine operation. After that period, check sprockets periodically. If one side of the sprocket teeth has been worn badly, that indicates improper alignment. When this occurs, replace the sprocket and correct sprocket alignment. Any sprocket with broken teeth or teeth that have been worn out need to be replaced.

Periodically check condition of ball bearings and replace if necessary.

Carton Magazine

The drive system utilizes a pneumatic cylinder that will simply be replaced when it wears out.

The two chains that drives the pusher plate can be lubed, but should be lubed very lightly.

Rotary Feeder

Daily / Per Shift Maintenance

Clean and inspect suction cups. Keeping the inner surface of the suction cups clean will insure a good adhesion between the suction cup and the carton face. Inspect suction cups for cracks both on the inside surface and at the base of the cup where the cup meets the stem. If cracks from drying are found on the inside surface of any of the suction cups, replace the entire set of cups. If a crack is found behind the cup where the cup meets the stem, replace that suction cup. When more than one suction cup is cracked at the stem, this is usually an indication that the Case Magazine is set to close to the Rotary Feeder.

Bi- Weekly Maintenance

Replace all suction cups, make sure all hoses are securely fastened, and all fasteners are tight.

Periodically check condition of bearings and replace if necessary.

6 Months Maintenance

Remove the guard ring around the gear housing, inspect the gears and add a spot of grease to each of the outer most gears. Replace guard ring.

12 Months Maintenance

Replace bearings and vacuum valve.

VERTICAL CARTONER MACHINE MAINTENANCE

CONTINUED...



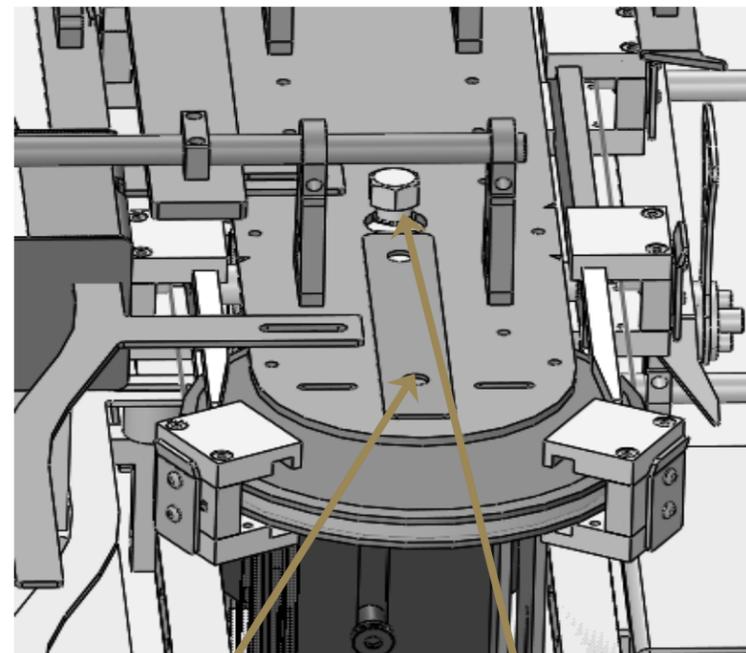
Carton Carrier Chain

At an interval of every 2 weeks the carton carrier chain should be checked for proper tensioning and lubricated. Use any type of chain oil. For a USDA machine, use a food grade oil such as Crisco. Also, care should be taken to make sure that the pins that mount the carrier slide to the chain are always in place and not missing.

Take-Up Screw

Over time, the chains will stretch during the "Break In" period. To compensate for the slack in the Carton Carrier Chain, you will need to turn the Take Up Screw clockwise to take up the excess slack in the chain. If the chains are over tightened, you will need to turn the Take Up Screw counterclockwise to allow the appropriate amount of slack for the machine to run properly.

The Take Up Screw is located at the Idler End of the Carton Carrier Chain Assembly. Simply loosen the two locking nuts on the clamp plate and turn the take-up screw clockwise till the chain is appropriately tensioned. The take-up uses a cam arrangement to simply and evenly move the top and bottom sprocket out to maintain proper sprocket alignment.



**Locking
Nuts**

**Take-up
Screw**

Tuckers

Periodically check condition of bearings on tuckers and replace if necessary.

Carton Discharge Conveyor

For complete detailed information on maintenance and troubleshooting, refer to the Dorner manuals attached in Appendices.

Air Filter

Replace the element every 2 years or when the pressure drops becomes 0.1 MPa, whichever comes first, to prevent damage to the element.

Air Lubricator

Replenish the lubricant after releasing the inlet pressure. Lubrication cannot take place under a pressurized condition.

Check the dripping amount once a day. Drip failure can cause damage to the components that need lubrication.

Air Regulator

When using the regulator with backflow mechanism between a solenoid valve and an actuator, check the pressure gauge periodically. Sudden pressure fluctuations may shorten the durability of the pressure gauge. A digital pressure gauge is recommended for such situation or as deemed necessary.

ELECTRICAL CONTROLS & OPERATION



HMI USER NAVIGATION

This bank of buttons will be the navigation bank on all HMI control screens. It will always be found at the bottom of your HMI panel



MAIN

Operators control screen. Speed, duration, cycle mode, and machine rate can be modified here.



RECIPE

Standard and saved machine settings can be modified here



CARTONER DRIVES

Cartoner manual settings and servo reset can be found here.



TILT DRIVE

Tilt Tray Drive manual settings and servo reset can be found here.



SETTINGS

Solenoid controls bank. Modules can be enabled/disabled and timing can be modified



PLC I/O

Input and Outputs



ALARM HISTORY

History of alarms, servo faults, and machine errors.



SINGLE CYCLE MODE

Each press of the machine start buttons will signal the machine to index one station at a time.



CONTINUOUS CYCLE MODE

One press of the machine start button will signal the machine to index continuously at full run speed



DRY CYCLE MODE

This will engage all pick and place and product loading modules on the machine. This mode is intended for empty package erecting or troubleshooting.



CARTON FEED ENABLE

This mode will engage or disengage loading of packages from magazine to rotary pick and place.



MAIN RESET

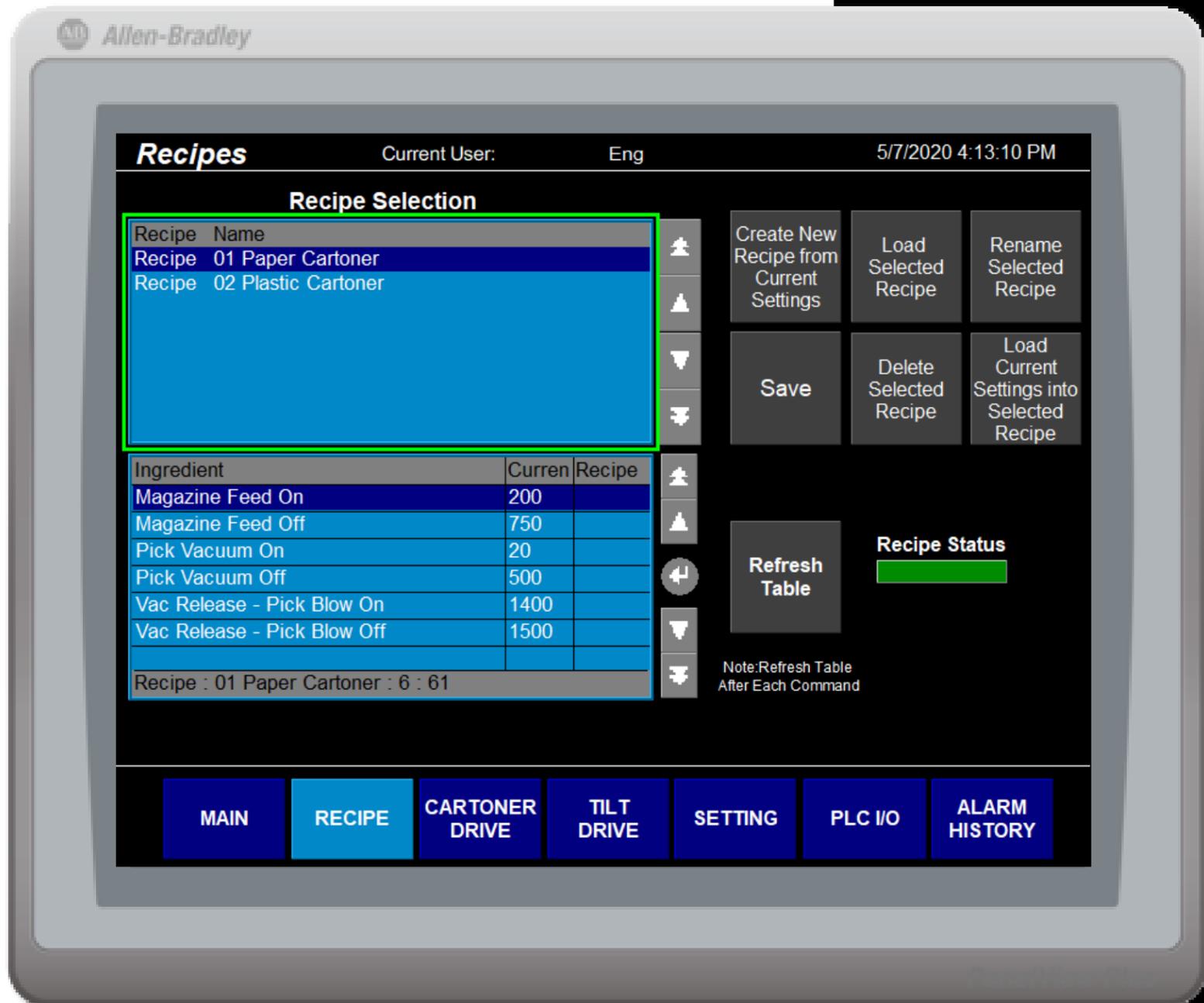
If the machine were to have a fault or a safety error a alarm will be triggered. In order to return to operation mode the fault will have to be cleared with this command.



MAIN

Welcome to your operator's interface. Here you can switch between cycle modes. You can also view cycle times, statistics, and clear out any machine faults.





RECIPE

This screen allows various recipe management functions. You can navigate thru the recipes using up and down arrows, load, delete, rename etc. "Current Settings" refers to current values of the recipe settings. These values might be different than the values in the current recipe.



RECIPE STATUS

Recipe status will change between saving or loading a particular recipe. When the status is red it will be in the process of modifying its current state. Once green you are ready to operate or perform the next function.



SAVE

With the recipe you have highlighted in the recipe selection window whatever settings you are currently using will be saved to selected recipe



CREATE NEW RECIPE FROM CURRENT SETTINGS

Take the current recipe settings that you have modified and create a new recipe. This is useful for additional product lines or minor differences in packaging or product.



DELETE SELECTED RECIPE

Delete selected recipe in recipe selection screen. Once recipe has been deleted there is no way to recovery or retrieve from trash.



RENAME SELECTED RECIPE

Rename the recipe that is currently highlighted in recipe selection window.



SYSTEM DWELL

Modifying system dwell will adjust the overall operating speed of the machine. This modifies the amount of time the machine waits while each station performs their task.. Recommended speed to maintain 40CPM is 950 MS



SERVO RESET

In event of main servo fault that cannot be cleared by standard reset this will reset the servo itself. When resetting the servo be sure to re-home machine after to ensure proper function.



MANUAL RUN

Manual run will change your machine to indexing at a percentage of rotation rather than completing an entire index. This is good for checking clearances between assembly's to avoid a crash



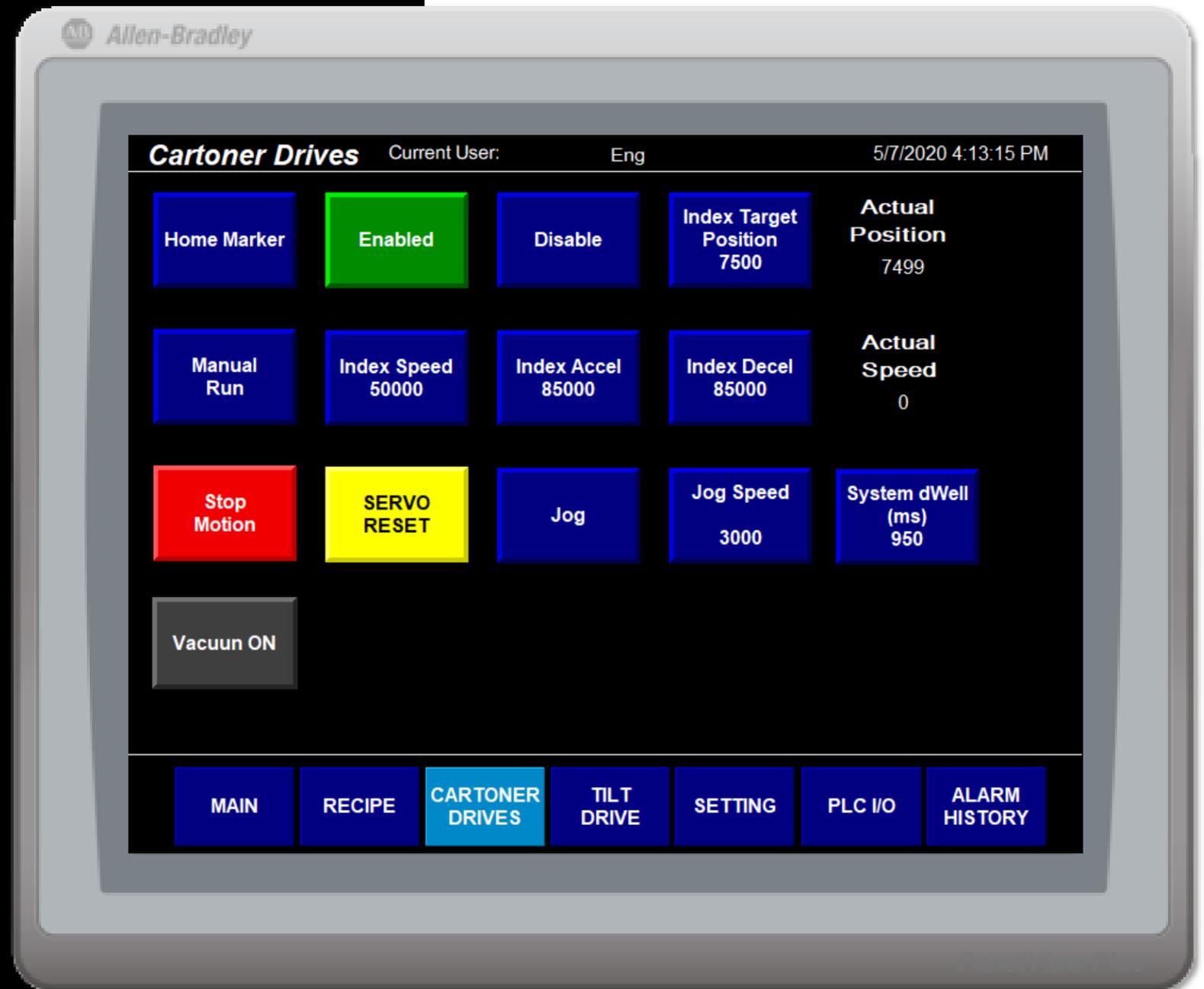
JOG SPEED

Jog speed can be changed here depending on speed required while troubleshooting or doing maintenance..



JOG

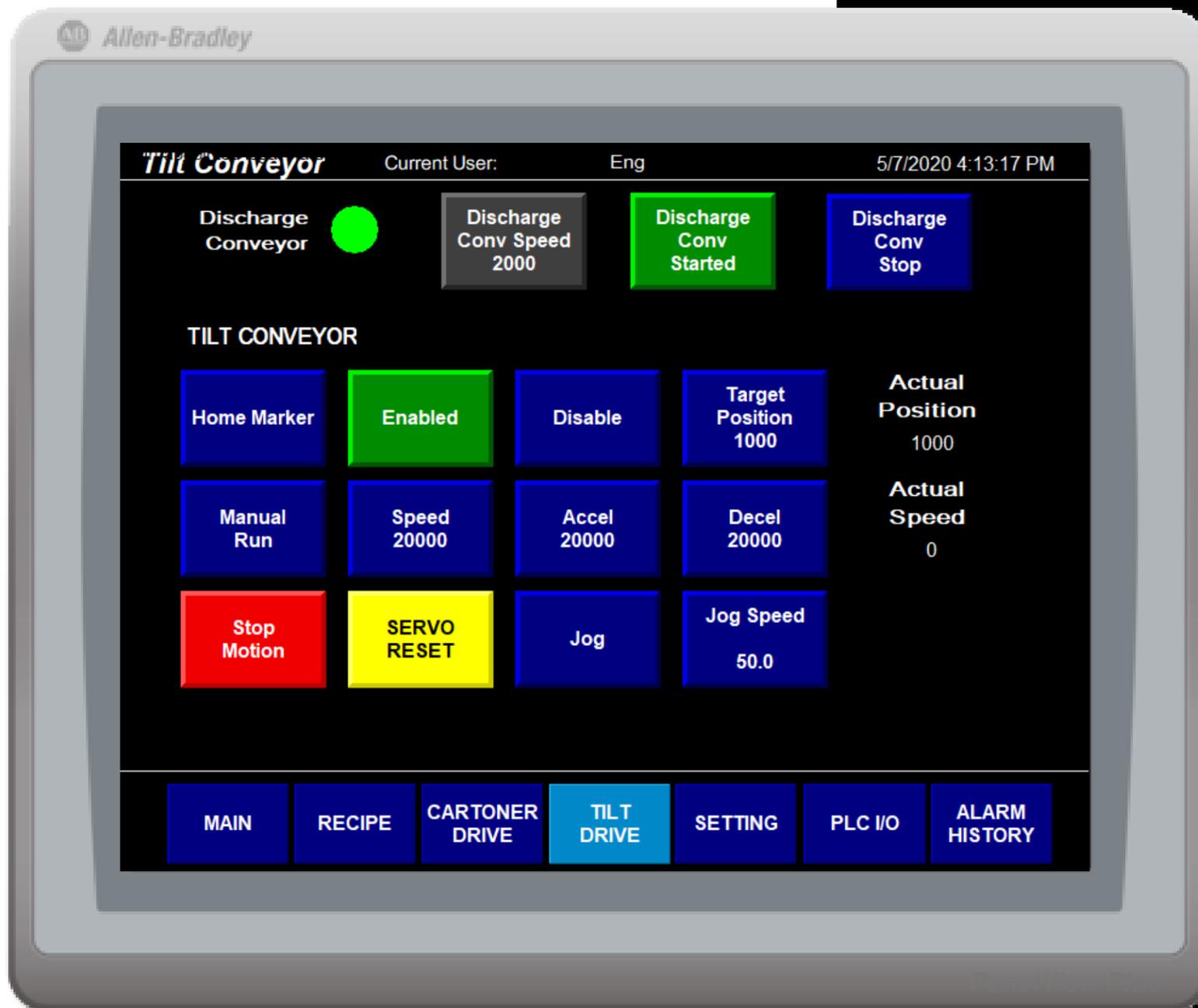
Jog will signal the servo to begin its rotation. This serves the same function as the green start button on electrical panels.



CARTONER DRIVE

Cartoner main drive controls and statistics can be viewed here. If the machine needs to be re-homed back to factory settings, jogged, or reset the servo from catastrophic fault this is the place to do it.





TILT DRIVE

Tilt Tray main drive controls and statistics can be viewed here. If the machine needs to be re-homed back to factory settings, jogged, or reset the servo from catastrophic fault this is the place to do it.



SYSTEM DWELL

Modifying system dwell will adjust the overall operating speed of the machine. This modifies the amount of time the machine waits while each station performs their task.. Recommended speed to maintain 40CPM is 950 MS



SERVO RESET

In event of main servo fault that cannot be cleared by standard reset this will reset the servo itself. When resetting the servo be sure to re-home machine after to ensure proper function.



MANUAL RUN

Manual run will change your machine to indexing at a percentage of rotation rather than completing an entire index. This is good for checking clearances between assembly's to avoid a crash



JOG SPEED

Jog speed can be changed here depending on speed required while troubleshooting or doing maintenance..



JOG

Jog will signal the servo to begin its rotation. This serves the same function as the green start button on electrical panels.



BANK 1 TIMER

Select bank 1 timer to adjust the on and off timing settings of all solenoids in bank 1. The bank 1 solenoid assembly is the left solenoid bank on the operators side of the machine.



BANK 2 TIMER

Select bank 2 timer to adjust the on and off timing settings of all solenoids in bank 1. The bank 2 solenoid assembly is the right solenoid bank on the operators side of the machine.



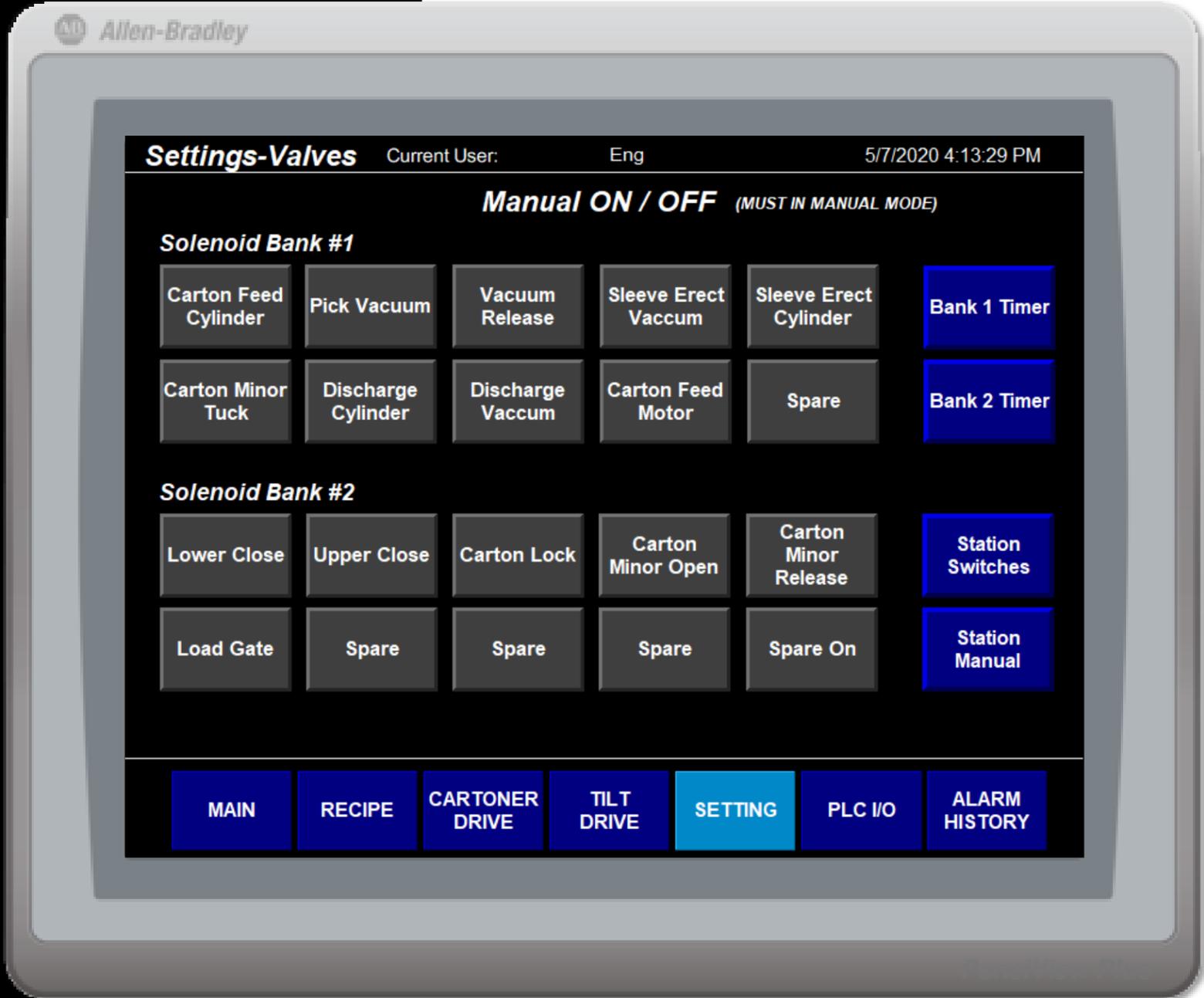
STATION SWITCHES

In the station switches panel you can modify what solenoids are enabled or disabled in your recipe



STATION MANUAL

Station manual is there if you need to fire an individual solenoid while the machine is not in cycling mode. This is good for troubleshoot individual stations of the machine.



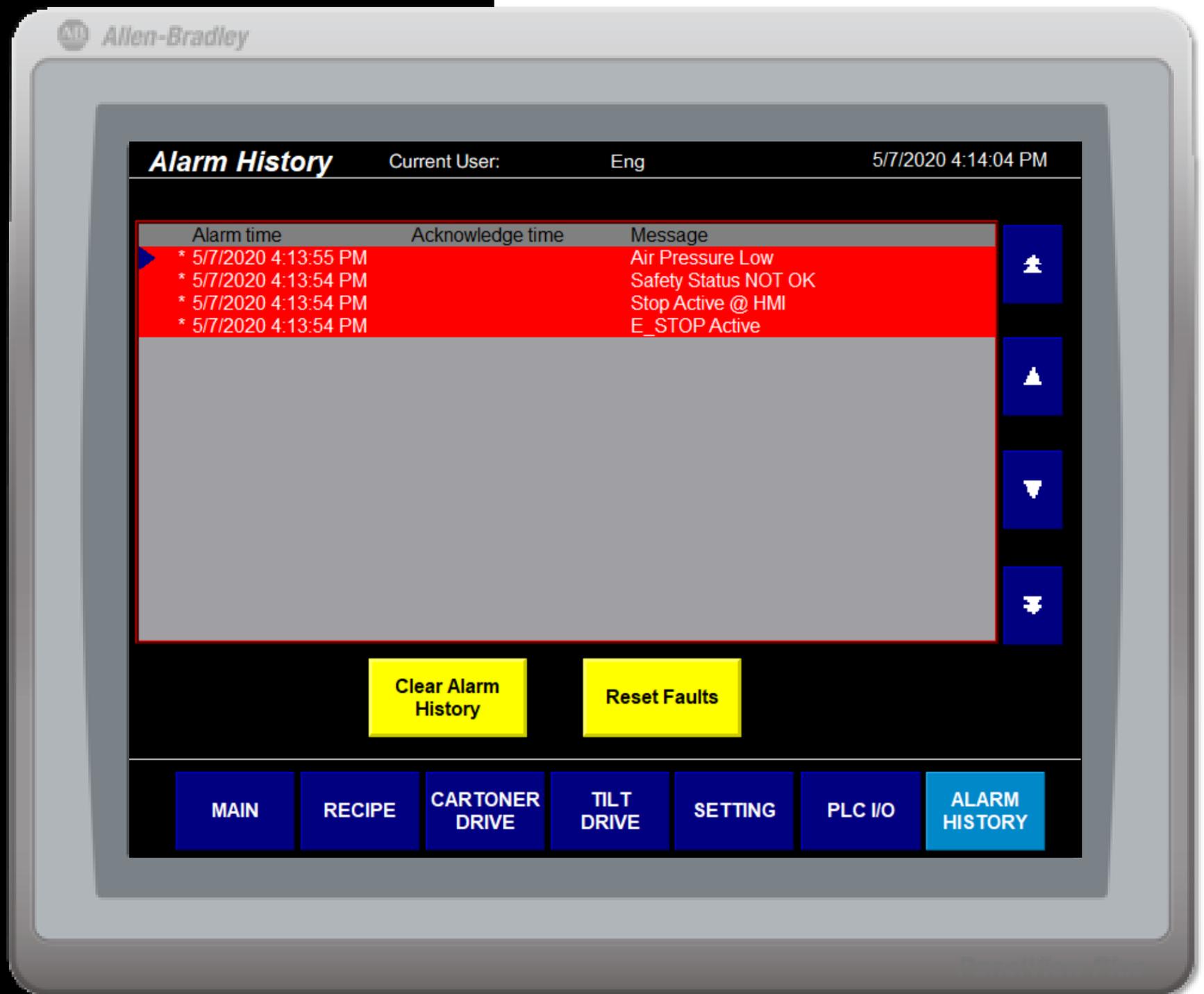
SETTINGS

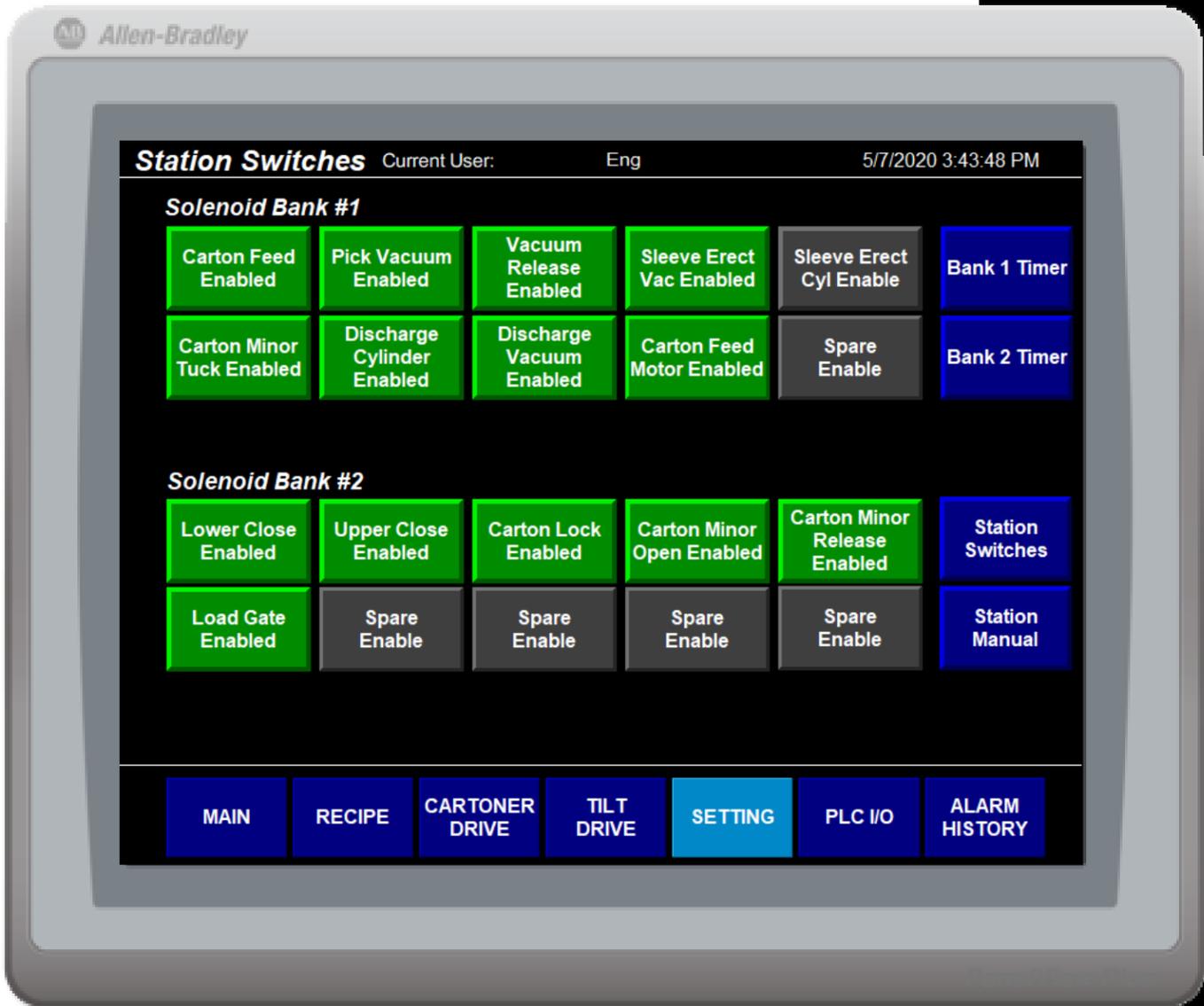
Your machine operates off of two solenoid banks. The timing of when and how long each air solenoid will be fired can be modified here. They can also be enabled or disabled here.



ALARM HISTORY

The purpose of the alarm history page is to review any faults that have occurred in recent history. They will be store here until you have cleared the alarm history. You can also reset the faults at this page. This preforms the same soft fault reset as the orange buttons located on your electrical panels.

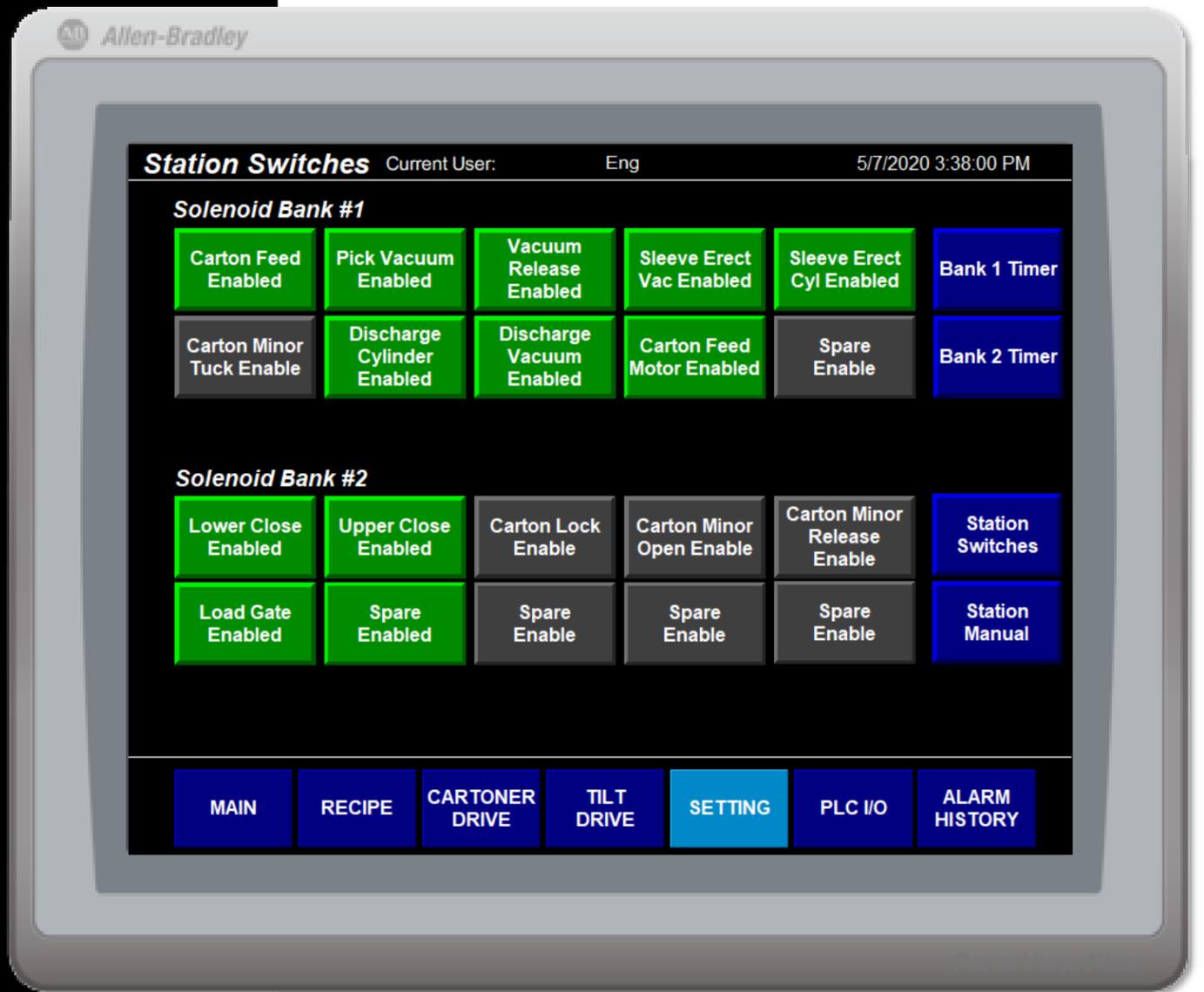
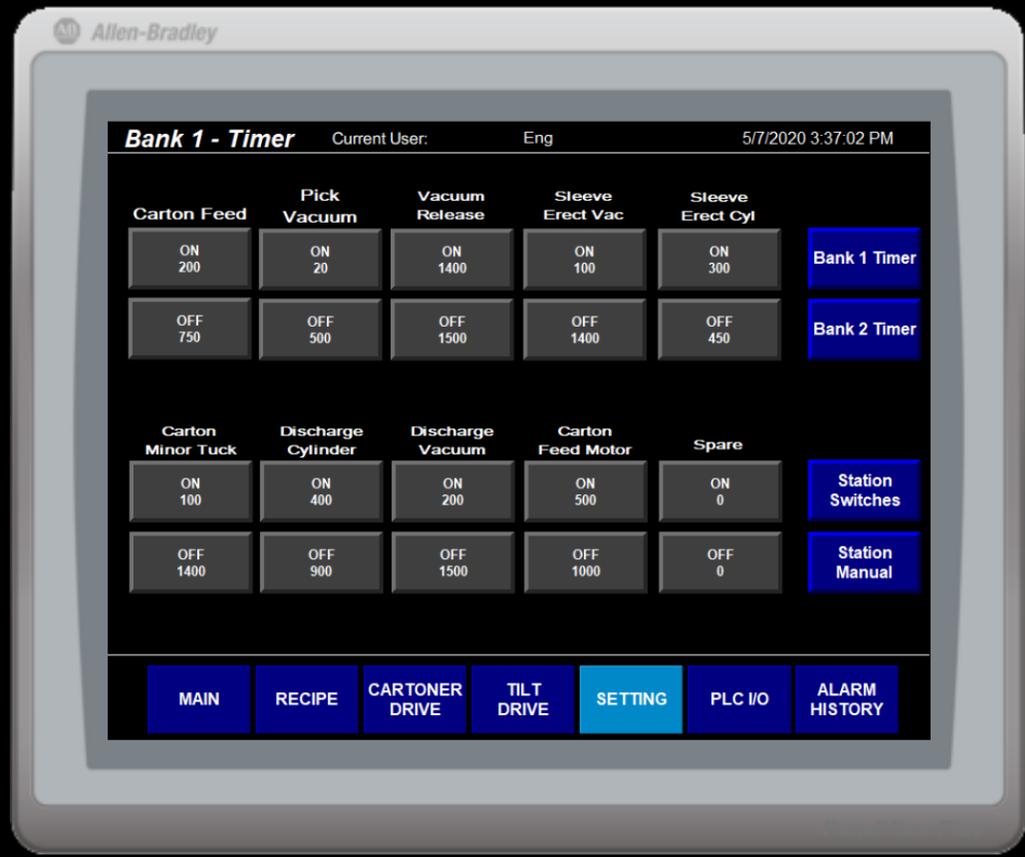




GROVE CARTON

Settings and enabled modules needed for operation of Grove cardboard carton as shipped 5/15/2020





MEDELA PLASTIC SLEEVE

Settings and enabled modules needed for operation of Medela plastic sleeve package as shipped 5/15/2020



CHANGE OVER PROCEDURE



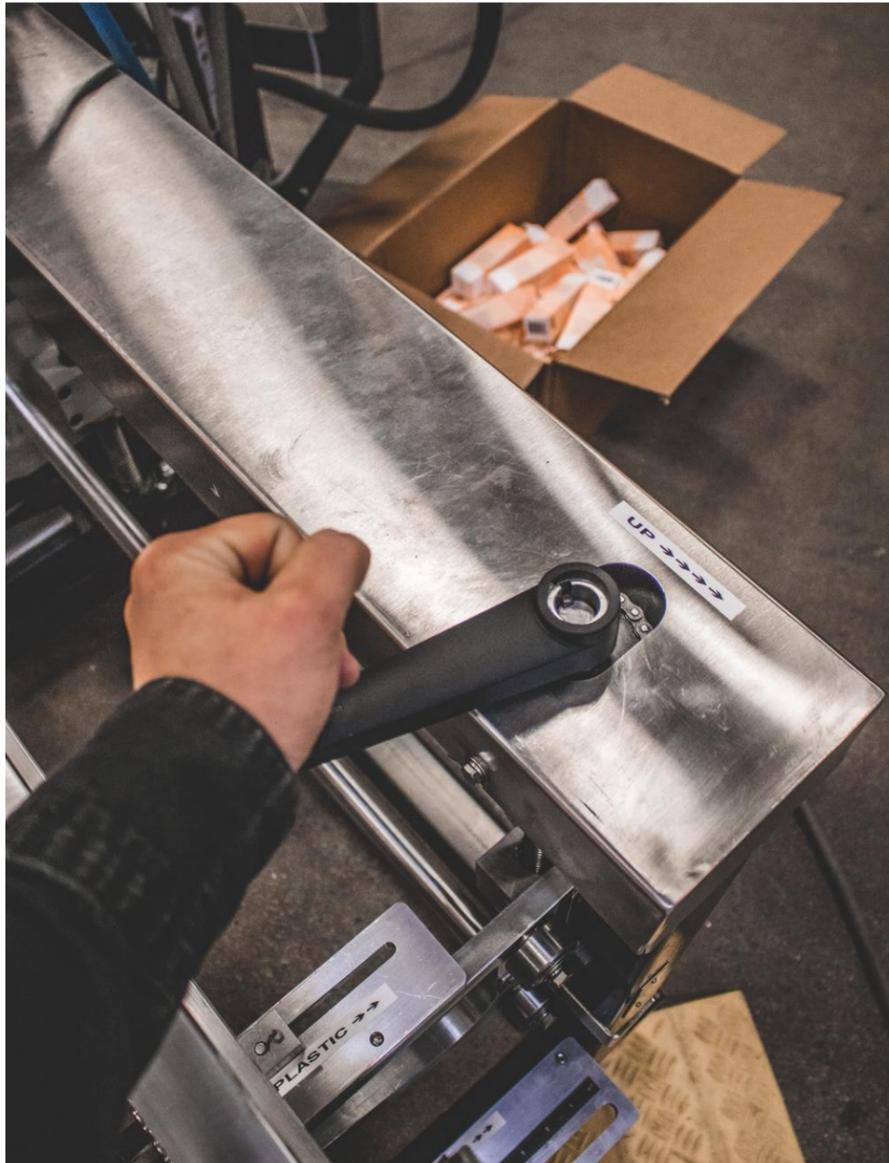
CHANGE CARRIER POCKETS

Your machine is equipped with 32 carrier pockets for each product line. These carrier pockets will have to be swapped between package styles. The pockets lift right off your carrier chain mounting plate and can be replaced with the appropriate pocket for the chosen product line. The best area to swap your carrier pockets can be done is in the extension end load area. Once all the pockets that you can reach have been replaced, simply index the machine half a rotation to replace the remaining pockets.



ADJUST CARRIAGE

Your machine is equipped with two height adjustment points. These two adjustment points will modify the elevation of the score line of your package. The carriage adjustment handle is located in the center of your machine frame. Refer to the directional arrows to move in the up or down direction. A scale with two reference lines are marked besides the adjustable handle. Adjust height to the carriage the appropriate marker for the product line you are using.



1

•Your package magazine has three points of adjustment that need to be addressed when changing between product lines. First adjustment is height. Like the carriage the height can be adjusted by turning the handle located on the top right the of the assembly. Refer to adjustment marker on the side of the magazine frame. Two adjustment markers have been scribed for recommended factory settings.



2

•The second adjustment point is the chain track position. This can be moved by loosening the bolts under the slotted mounting bracket of the chain. Slot stops have been included and set to factory adjustment settings. Slide the chain rail against the appropriate slot stop for each product line.



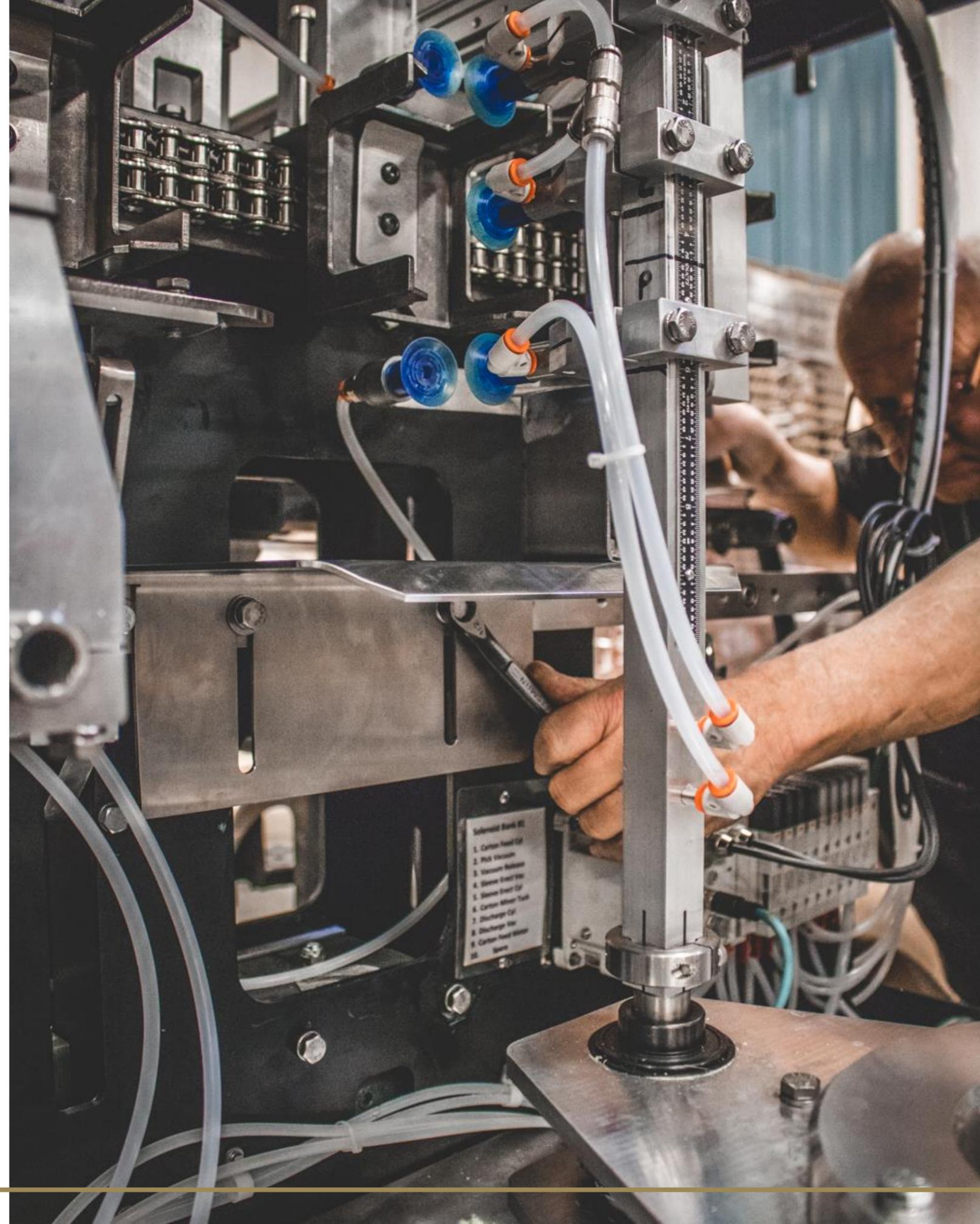
3

•The third and final adjustment point is located at the bottom portion of the product magazine. Four bolts hold the main guides together on the lowest slot plate. Slot stops have been included and set to factory adjustment settings. Slide the chain rail against the appropriate slot stop for each product line.



ROTARY PICK & PLACE

- Adjust height of suction cup hold Assembly's on rotary pick and place arms. Factory settings for both product styles are seen above.
- Add carton pre-break skid plate in carton place station. Add pre-break skid plate at lowest point of adjustment as pictured.
- Turn off Air valve disengaging the plastic sleeve erecting cylinder when running cartons and turn back on when running the plastic sleeve product line.

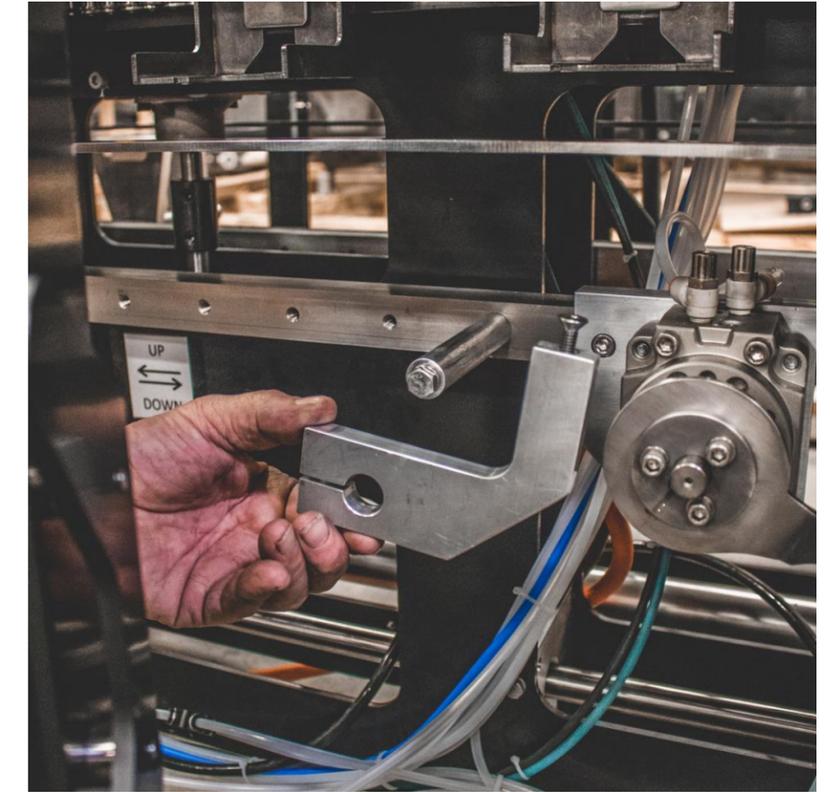
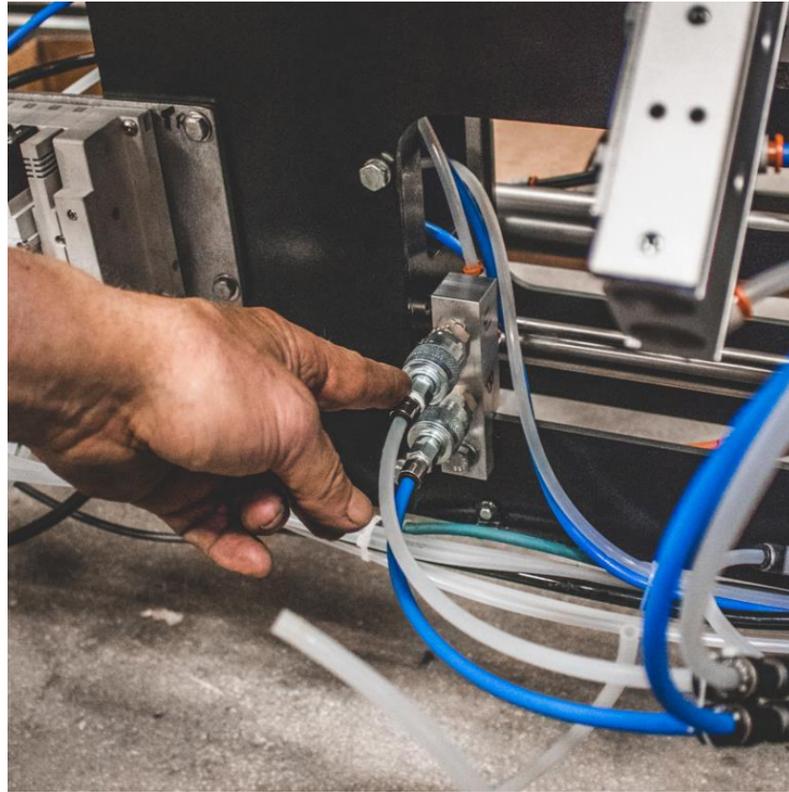




PRE-BREAK ASSEMBLY

The pre-break cylinder assembly is only used on the Medela Plastic sleeve product line but will interfere with proper function of the cardboard carton product line. Loosen the assembly mounting clamp - rotate 180 degree's - and pull towards the outside of machine until it is out of the rotary pick and place's range of travel. Once positioned in ideal location tighten mounting screw.

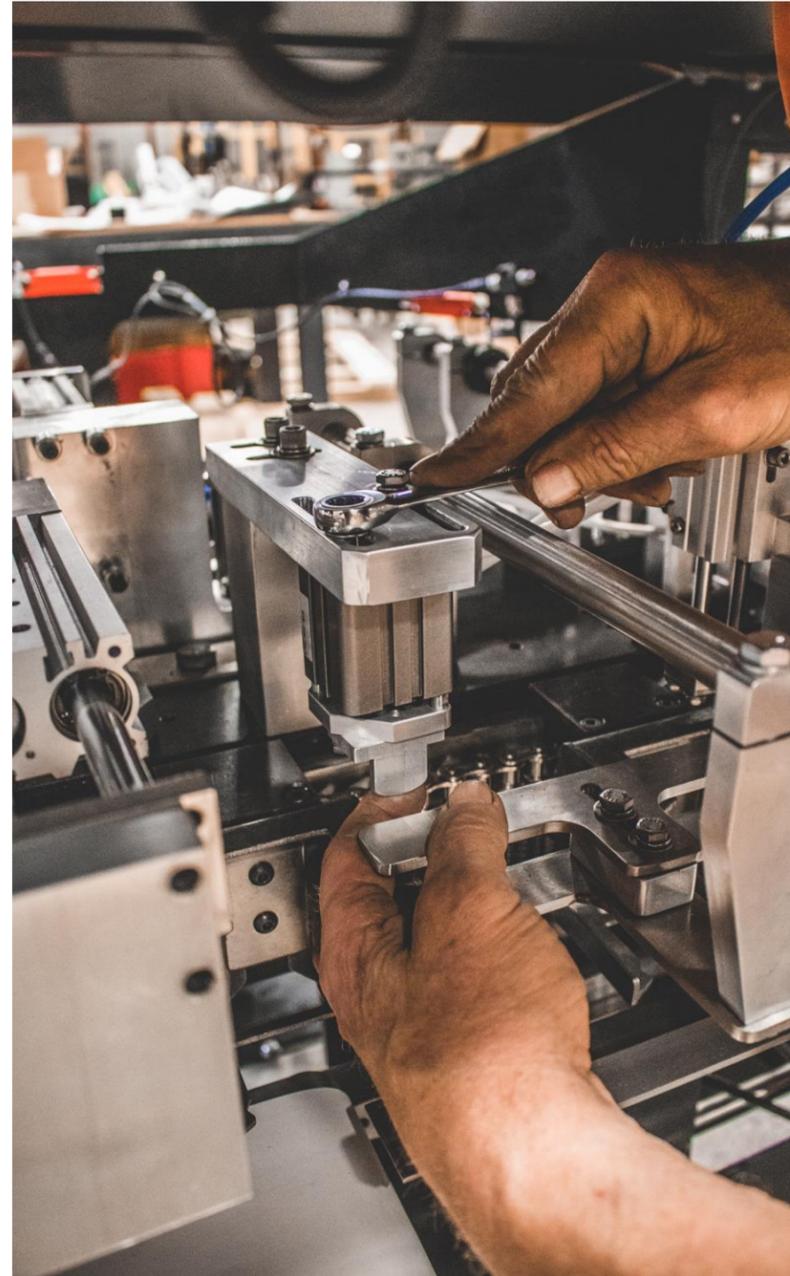
BOTTOM CLOSING MODULE



- Your machine is equipped with two closing modules. Top and bottom. Both modules will have to swapped for each product line. The bottom closing module can be removed by taking out the two bolts on each carriage rail clamp. This will be a total of four bolts. Set these bolts and mating clamps aside. They will be used to secure the opposing closing module. Once the bolts are removed you must disconnect the two air hoses that power the module. Once you air hoses are disconnected you can remove the entire assembly.
- Replace the bottom closing module with the appropriate module for the product line you are running. Set the module on the two carriage rails and press firmly so it against the main rear carriage rail. Use the four bolts you have set aside to adhere the bottom clamps to the module and tighten until clamps are secure.
- If you are running the cardboard carton product line an additional skid plate will need to be added after the bottom closing module is secure. Flip up carriage clamp and leave clamp bolt loose. Add skid plate required and bolt to clamp. Once in the level and upright position tighten clamp bolt until secure.

TOP CLOSING MODULE

The top closing module can be adjusted and removed with just two bolts. Loosen the top bolts on the top of the assembly to remove and replace with appropriate module. There is room for adjustment in the mounting holes. When all other adjustments have been made to the machine index an empty package through the machine and ensure that the top closing section is aligned properly with carton or plastic sleeve. Adjust as needed



TUCK LOCK

Top tuck lock assembly will be used with the cardboard carton but adjusted out of the way to avoid abstractions with plastic sleeve. When using cardboard carton adjust tuck lock cylinder assembly to set adjustment point.

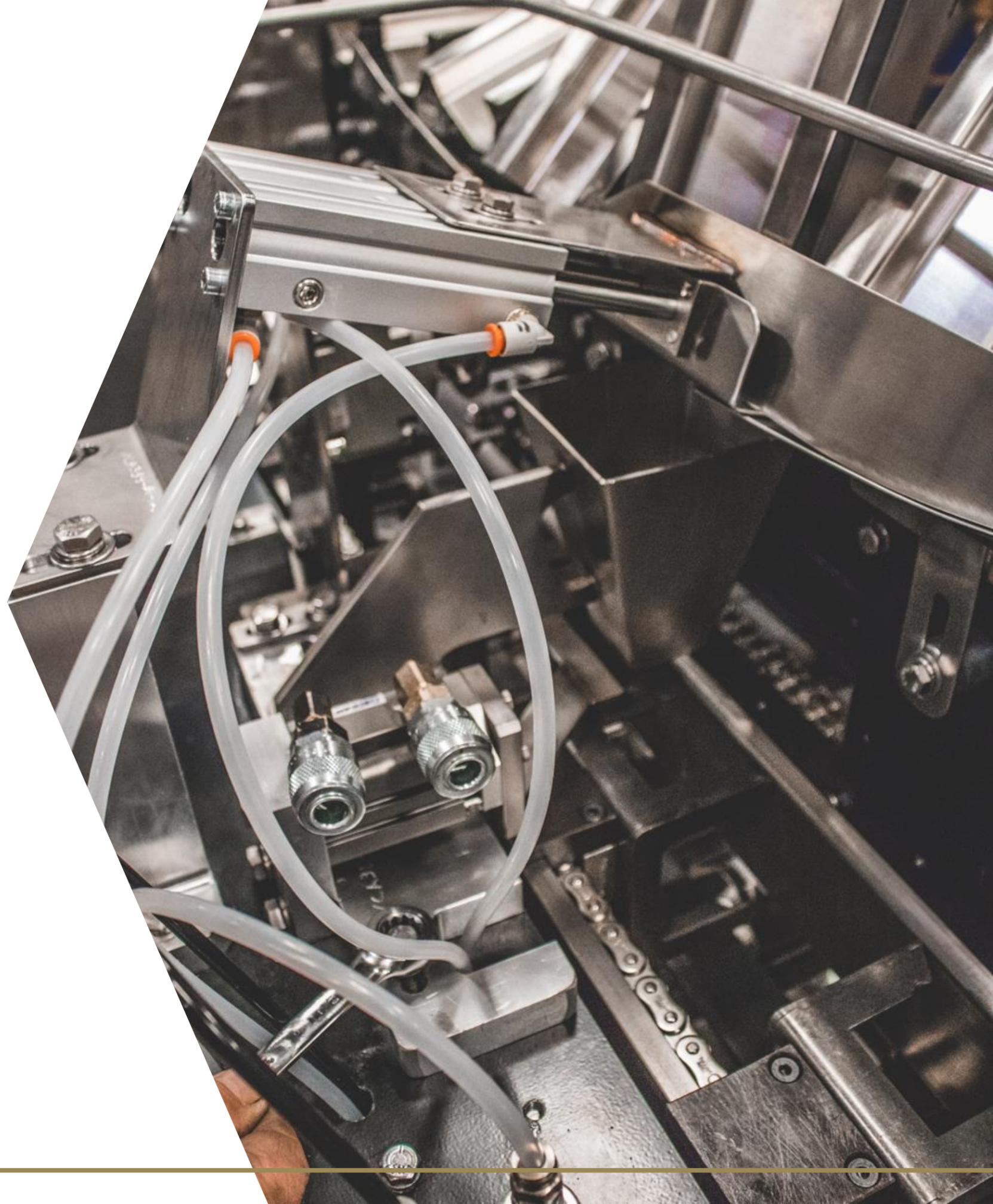


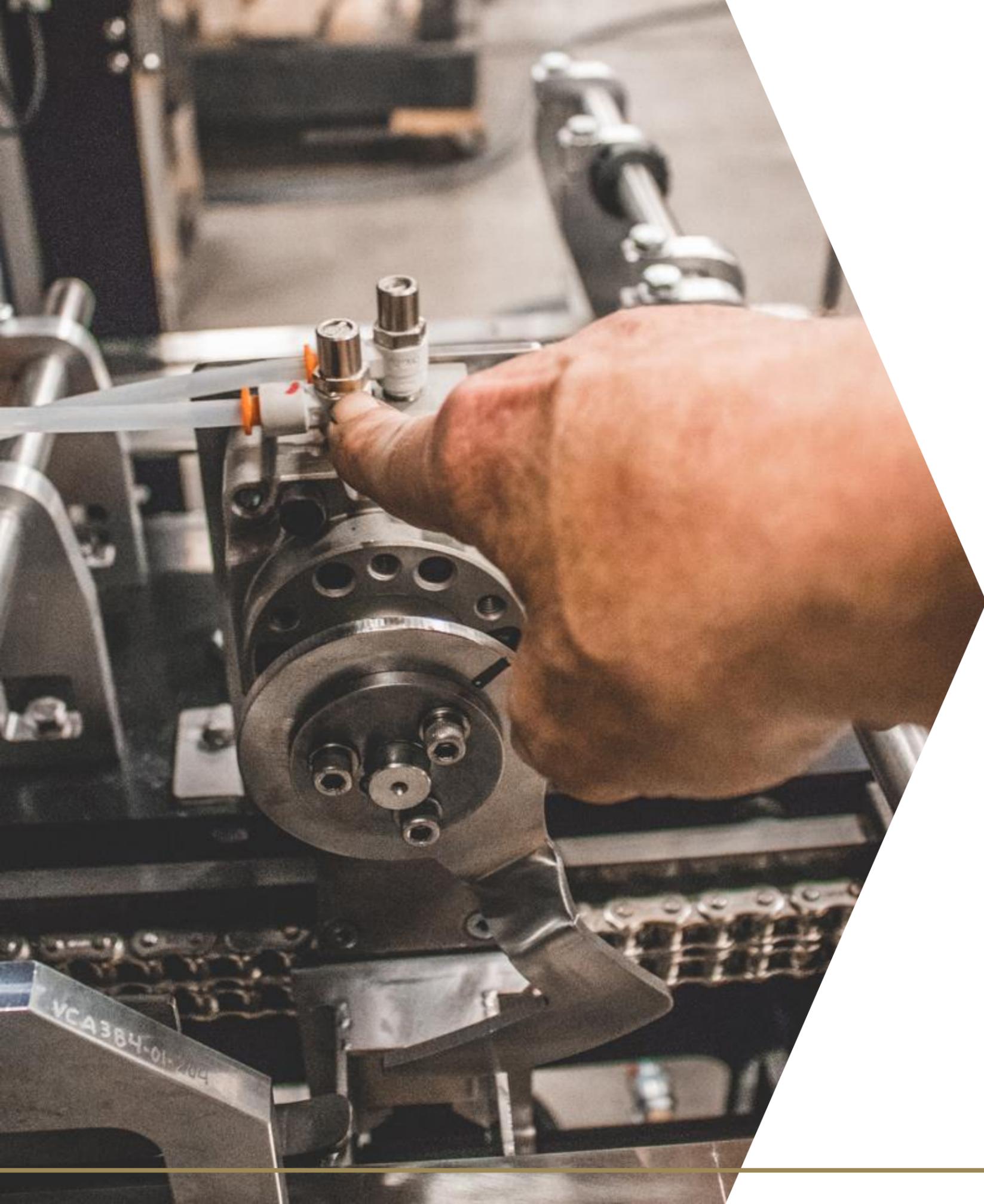
ADJUST SKID PLATES

Your machine is equipped with two different skid plate options. Each with a set location that can be simply loosened and slid into place up against the collar shown. These skid plates should require little to no fine adjustments if no modification to machine or product have been done. Loosen clamp bolt and slide opposing skid plate assembly out of the range of use and slide in the appropriate skid plate for use with the current product line.

PRODUCT FILL ASSEMBLY

Each product line requires a different spout opening to accommodate each package opening. The spout assembly comes on and off with just two bolts and mounting holes are slotted for minor adjustments. Remove current spout assembly and replace with the appropriate assembly. Hand the package you are going to run. Place firmly in carrier pocket at an open station before the fill station. Single Index your machine until the package has arrived at product fill station. Ensure that the product fill spout is aligned and on center with package. Once spout is aligned tighten down mounting bolts.





TUCKER ADJUSTMENT

The three tucker assemblies will be electronically enabled for the cardboard carton product line and disabled for the plastic sleeve product line. Though the tuckers will not move for the plastic sleeve to eliminate any obstructions it is standard practice to reverse the two air hoses on the tuckers when changing over. This changes the tucker blade from a normally closed position to a now normally open position. Doing this will create no need for fine adjustments of the tucker blades.

Recipes

Current User:

Eng

5/7/2020 4:13:10 PM

Recipe Selection

Recipe Name
Recipe 01 Paper Cartoner
Recipe 02 Plastic Cartoner



Create New Recipe from Current Settings

Load Selected Recipe

Rename Selected Recipe

Save

Delete Selected Recipe

Load Current Settings into Selected Recipe

Ingredient	Current	Recipe
Magazine Feed On	200	
Magazine Feed Off	750	
Pick Vacuum On	20	
Pick Vacuum Off	500	
Vac Release - Pick Blow On	1400	
Vac Release - Pick Blow Off	1500	

Recipe : 01 Paper Cartoner : 6 : 61



Refresh Table

Recipe Status



Note: Refresh Table After Each Command

MAIN

RECIPE

CARTONER DRIVE

TILT DRIVE

SETTING

PLC I/O

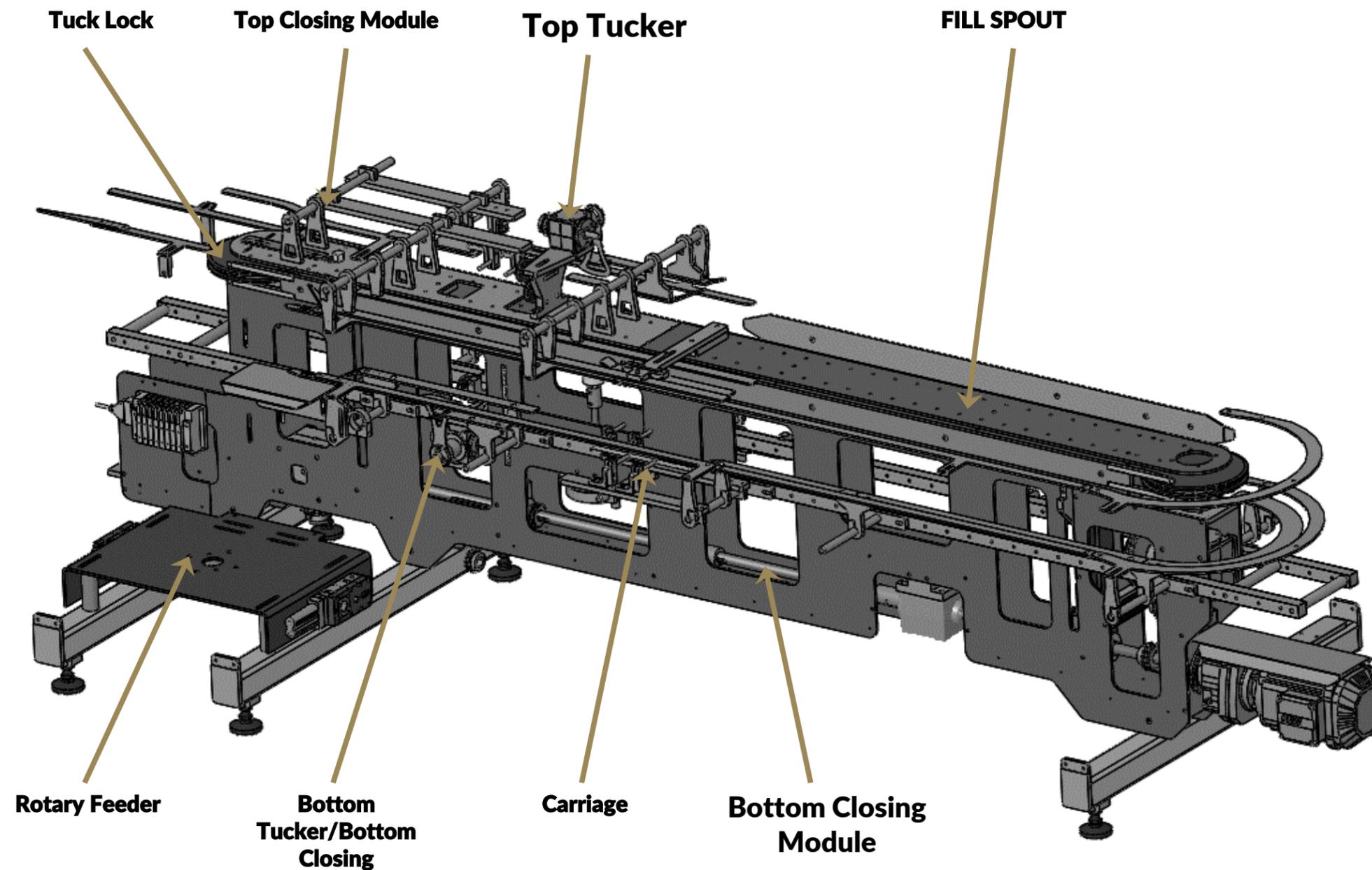
ALARM HISTORY

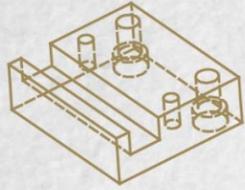
CHANGE HMI RECIPE

On your digital control panel navigate to the "Recipe" page. You can find this on your lower navigation bar. Once at the recipes page find the most recent saved recipe for the product line you are trying to run. Select the proper recipe and press the load button. Check to see that the recipe status bar is green. Once recipe has been loaded successfully you may now return to the operator's main screen.

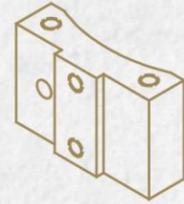
CHECK ADJUSTMENT POINTS

After all modules have been swapped and adjustments have been made to accommodate the chosen product line you are able to run. It is recommended that switching to single index and closely watching the performance of each station. Poor performance at any station will affect the performance of the following station. TIP. If you are having poor performance right away in both the top and bottom closing stations it is recommended to check and adjust carriage height before adjusting individual closing sections. Adjust carriage at a quarter to a half turn at a time and inspect if performance improves. A out of adjustment carriage is the easiest culprit for poor performance





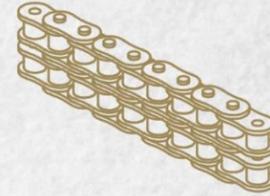
Part #: 09005384
 Description: Carrier Slide Block
 Where Used: Cartoner Carrier Chain



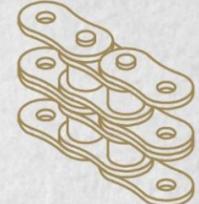
Part #: 09008384
 Description: Carrier Block
 Where Used: Cartoner Carrier Chain



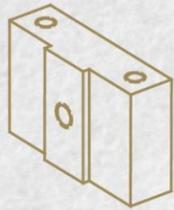
Part #: VCA384-99-001
 Description: Carton Carrier Pocket
 Where Used: Cartoner Carrier Chain



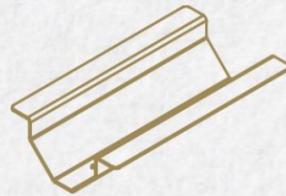
Part #: YMP000-05-101
 Description: Chain Section 5.625"
 Where Used: Cartoner Carrier Chain



Part #: YMP000-05-102
 Description: Chain Section 1.875"
 Where Used: Cartoner & Tilt Tray Carrier Chain



Part #: TTA00A-04-001
 Description: Tilt Tray Carrier Block
 Where Used: Tilt Tray Carrier Chain



Part #: TTA384-99-001
 Description: Tilt Tray
 Where Used: Cartoner Carrier Chain

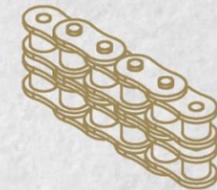


**VERTICAL CARTONER
 RECOMMENDED
 SPARE PARTS**

**TO ORDER
 VISIT:
YEAMANMACHINE.COM/SUPPORT**



Part #: VCA384-99-002
 Description: Plastic Sleeve Carrier Pocket
 Where Used: Cartoner Carrier Chain



Part #: YMP000-05-104
 Description: Chain Section 3.125"
 Where Used: Tilt Tray Carrier Chain



Part #: YMP000-04-130
 Description: 1-1/2" Roton Screw
 Where Used: Cartoner & Magazine Lift Assy



Part #: 164000
 Description: Timing Belt
 Where Used: Discharge Conveyor



Part #: YMP000-05-100
 Description: Chain Pin
 Where Used: Cartoner & Tilt Tray Carrier Chain



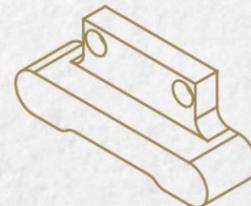
Part #: 163998
 Description: Conveyor Belt
 Where Used: Discharge Conveyor



Part #: 163996
 Description: Plastic Bushing
 Where Used: Tilt Tray Conveyor



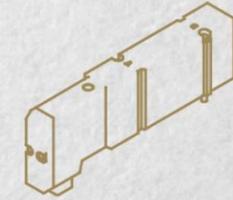
Part #: 163993
 Description: Shoulder Bolt
 Where Used: Cartoner Carrier Chain



Part #: TTA00A-04-002
 Description: Carrier Slide Block
 Where Used: Tilt Tray Conveyor Chain



Part #: 163928
 Description: Carrier Slide Block
 Where Used: Cartoner Carrier Chain



Part #: 105409
 Description: 24V Single Solenoid
 Where Used: Cartoner Carrier Chain



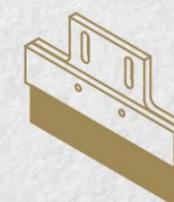
Part #: 164014
 Description: Carrier Slide Block
 Where Used: Cartoner Carrier Chain



Part #: 163995
 Description: Rubber Dampener
 Where Used: Tilt Tray Conveyor



Part #: 165127
 Description: Suction Cup
 Where Used: Rotary Feeder & Sleeve Erector



Part #: VCA384-99-143
 Description: Product Sweep Brush
 Where Used: Product Spout - Plastic Sleeve



Part #: 164087
 Description: One Way Bearing
 Where Used: Magazine

BILLS OF MATERIALS



**MECHANICAL
BILLS OF
MATERIALS**



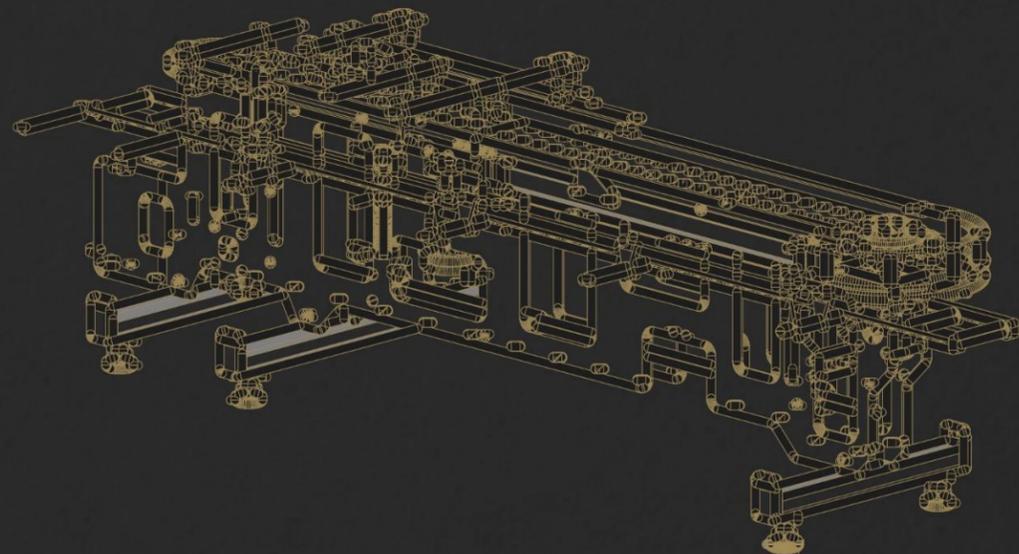
**RECOMMENDED
SPARE
PARTS**



**ELECTRICAL
BILLS OF
MATERIALS**

Disclosure: Provided that YMT's personnel have supervised the installation of, and provided start up assistance for, YMT's products, YMT warrants that new product(s) manufactured by YMT (and all parts thereof) shall be free from defects in material and workmanship under normal use and service for a period of six (6) months from the date of original installation, based on a single shift usage. This limited warranty may be voided, at YMT's sole option, if YMT determines that there has been misuse, neglect, or damage to the product(s) from lack of or improper maintenance or repairs. YMT's sole obligation under this limited warranty shall be limited to repairing or replacing, F.O.B. YMT's factory in Lake Forest, Illinois, any parts of a product(s) which prove to be defective within the warranty period and which YMT has determined to be defective in material or workmanship. YMT makes no warranty with respect to component parts or equipment not manufactured by YMT and which have been sold to YMT. Purchaser shall look exclusively to the original manufacturer of such component parts or equipment for any warranty, but YMT makes no representation as to assignability of any such warranty to Purchaser.

ITEM NO.	PART NUMBER	DESCRIPTION	QTY.	ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	01002384	TAKE UP ASSEMBLY	1	41	01499384	CARRIAGE RAIL	2
2	01801384	CARRIAGE	1	42	01351384	CARRIAGE SUPPORT BAR	4
3	01010384	UPPER SIDE GUIDE	1	43	01930384	SPROCKET	1
4	01038384	BASE FRAME SIDEPLATE WELDMNT	2	44	01334384	GEARBOX MOUNT PLATE	1
5	01037384	EXTENSION END CHAIN RAIL WELDM	2	45	01370384	SPOUT OVAL DRIVE SHAFT	1
6	01034384	LEG #1 - WELDMNT	2	46	01076384	STEEL RULES SCALE	1
7	01003384	LIFT ASSEMBLY	1	47	109972	BEARING, 2-BOLT FLANGE, 1.00" BORE	3
8	01006384	TAKE UP END LIFT ASSEMBLY	1	48	164035	MITER GEAR BOXES MB-16	1
9	01036384	TAKE UP END CHAIN RAIL WELDMEN	2	49	164034	HAND WHEEL AL 6DIA	1
10	01035384	LEG-EXTENSION SIDE - WELDMNT	1	50	164033	OIL-IMPREGNATED BRONZE BEARING	1
11	01033384	MAIN DRIVE TAKE-UP WELDMNT	1	51	164011	FLANGE CARTRIDGE UNIT	1
12	01031384	SENSOR FLAG WLDMNT	1	52	164024	HOLLOW BORE BEVEL GEAR 175 3/1	1
13	01032384	TAKE UP SPROCKET - WELDMNT	1	53	164032	COLLAR SHAFT 1.0" DIA 1-PC	1
14	01352384	ROTARY MOUNTING PLATE	1	54	164031	TWO-PIECE COLLAR	1
15	01454384	TOP PLATE	1	55	164036	IDLER SPROCKETS FOR ANSI #60 R	1
16	163727	SWIVEL FOOT PAD	6	56	01702384	CHAIN TAKEUP IDLER ASSY	1
17	01338384	TIE PLATE	2				
18	01461384	EXTENSION END TOP PLATE	1				
19	01355384	CROSS PLATE	1				
20	01341384	MTG PLATE	4				
21	01337384	CHAIN RAIL SPACER	14				
22	01349384	EXSTENTION FRAME SUPPORT	1				
23	01346384	VERTICAL DRIVE MTG PLATE	1				
24	01364384	BRACKET	1				
25	01336384	MAIN SHAFT	1				
26	164022	GEAR DRIVES 150 1:1 ST. A OR B	1				
27	01333384	GEAR SPACER	4				
28	164037	RIGID COUPLING	2				
29	01339384	GEAR CON. SHAFT	1				
30	01931384	SPROCKET	1				
31	164020	SCC - SET SCREW COUPLING	4				
32	01331384	COUPLING	1				
33	01335384	GEARBOX MOUNT PLATE	1				
34	01342384	MTG PLATE FOR HANDLE	1				
35	01332384	EXT. HANDWHEEL SHAFT	1				
36	01340384	MTG PLATE	1				
37	01347384	TAKE-UP MTG PLATE	1				
38	01344384	GEAR SPACER	4				
39	01359384	GEAR SHAFT	1				
40	01365384	EXSTENTION END DRIVE SHAFT	1				



DESIGNED BY:	TK	LINEAR	ANGULAR
DRAWN BY:	DA	X ± 0.020	X ± 2°
DATE:	2/3/2020	.XX ± 0.010	X ± 1°
		.XXX ± 0.005	.XX ± 0° 30'
MATERIAL: SEE BOM			
STOCK SIZE:			
STOCK NUMBER:		FINISH:	
UNLESS OTHERWISE SPECIFIED: BREAK ALL SHARP CORNERS, REMOVE ALL BURRS, AND STAMP OR ETCH PART NO. ON SURFACE			

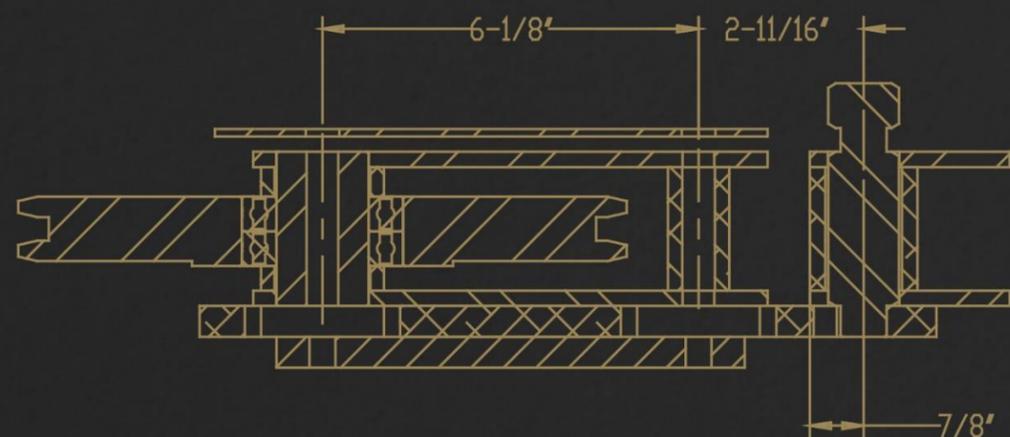
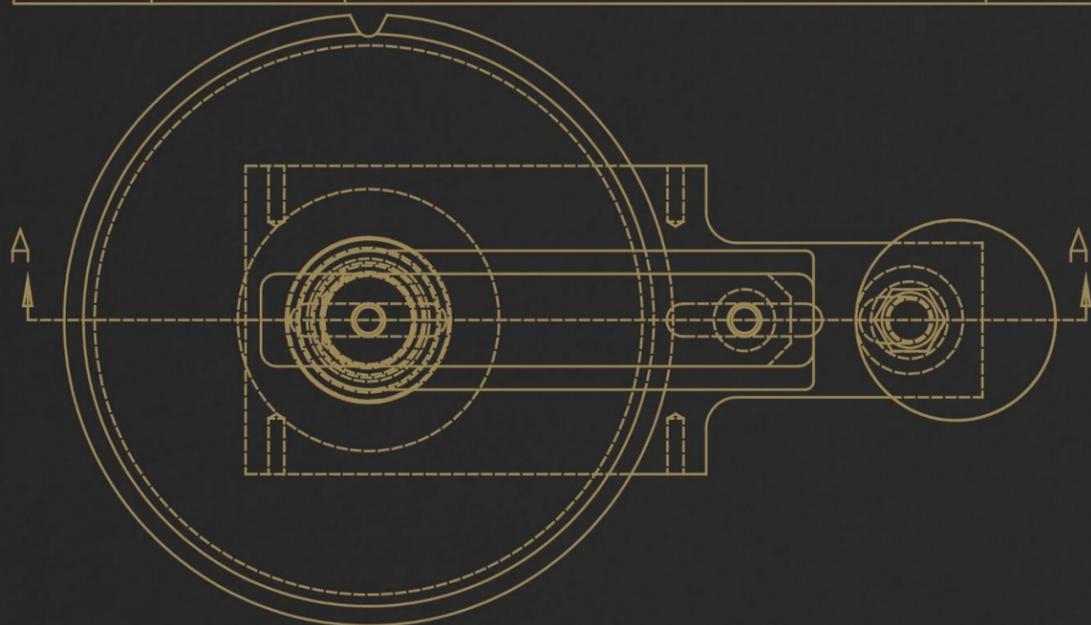
Yeaman

PART NUMBER: 01001384

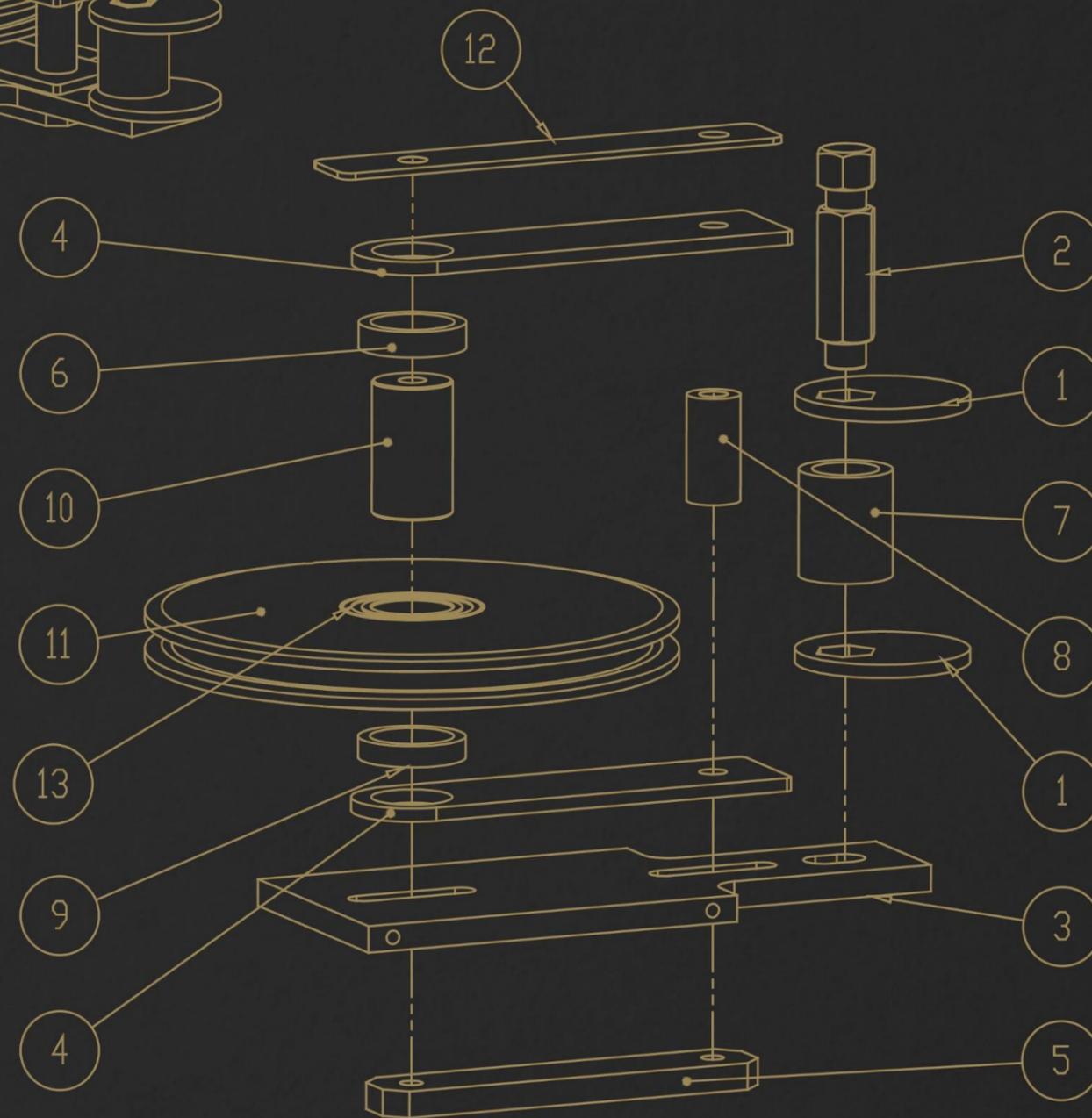
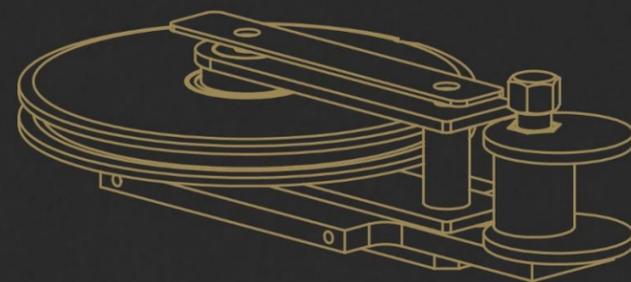
DESCRIPTION: BASE ASSEMBLY

SHEET SIZED: SCALE: 1:15 Sheet 1 OF 3

ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	01601384	TENSIONING CAM	2
2	01602384	KEY	1
3	01603384	SPROCKET SUPPORT PLATE	1
4	01604384	SPROCKET PUSH PLATE	2
5	01605384	TAPPED PLATE	1
6	01606384	TAKE UP SPACER - TOP	1
7	01608384	SPACER	1
8	01611384	SPACER	1
9	01607384	TAKE UP SPACER - BOTTOM	1
10	01609384	SPROCKET SHAFT	1
11	01092384	SPROCKET	1
12	01610384	TAKE-UP COVER	1
13	113411	TILT CONVEYOR A	2

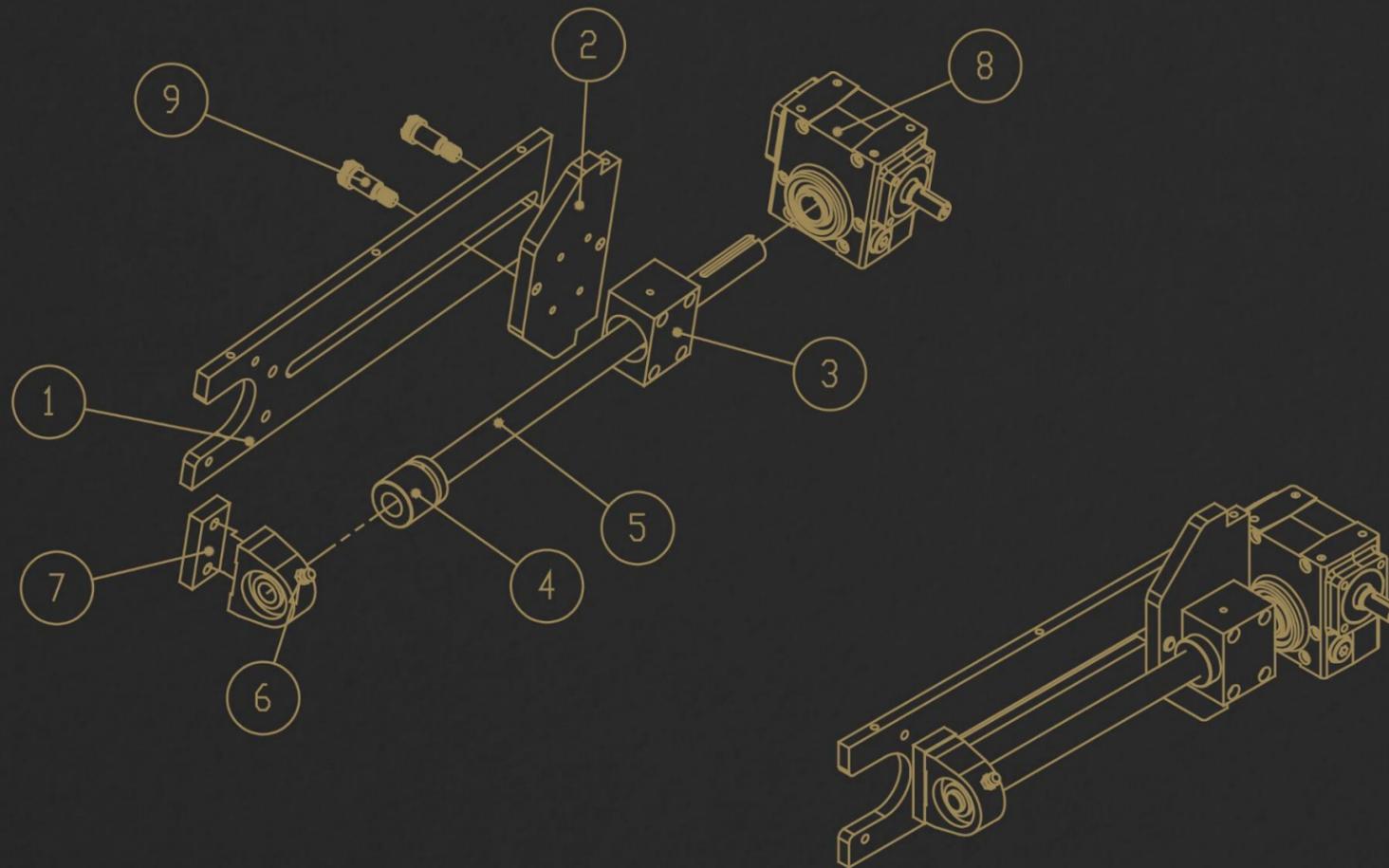


SECTION A-A

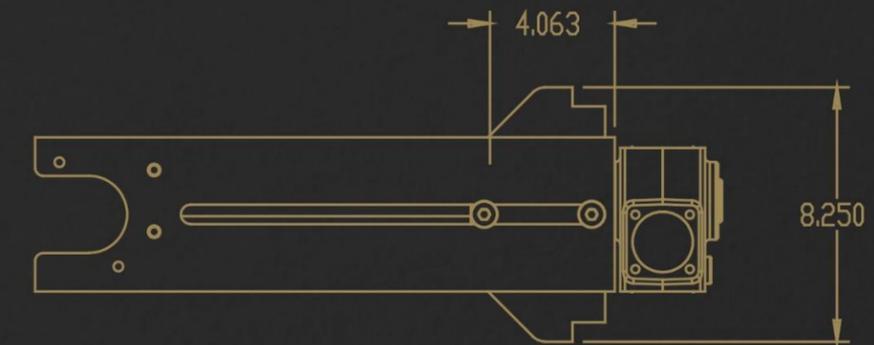
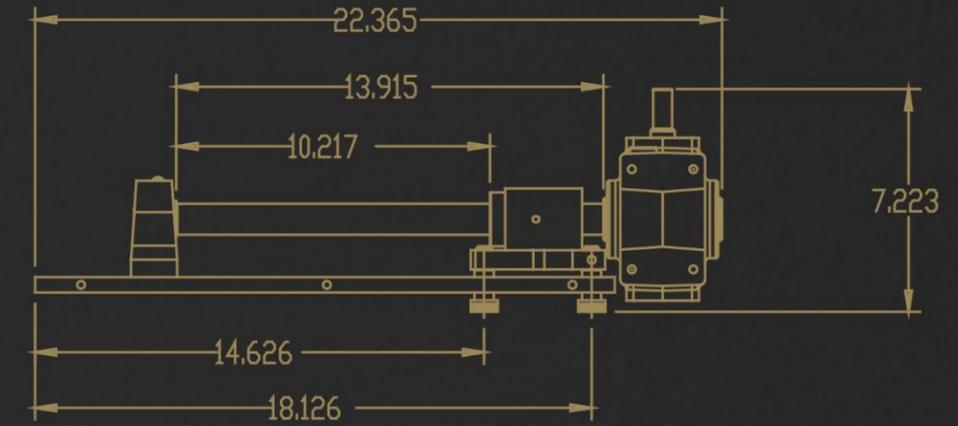


DESIGNED BY:	LINEAR .X ± 0.020 .XX ± 0.010 .XXX ± 0.005	ANGULAR X ± 2° .X ± 1° .XX ± 0° 30'	
DRAWN BY: MC	<small>THE USE OR DUPLICATION OF THIS DOCUMENT OR ITS CONTENTS WITHOUT THE EXPRESSED WRITTEN CONSENT OF COLBORNE FRODBOTICS, LLC IS STRICTLY PROHIBITED.</small>		
DATE:	MATERIAL:	PART NUMBER:	01002384
	STOCK SIZE:	DESCRIPTION:	TAKE UP ASSEMBLY
	STOCK NUMBER:	FINISH:	
<small>UNLESS OTHERWISE SPECIFIED, BREAK ALL SHARP CORNERS, REMOVE ALL BURRS, AND STAMP OR ETCH PART NO. ON SURFACE.</small>			SHEET SIZE: SCALE: 1:3 Sheet1 OF 1

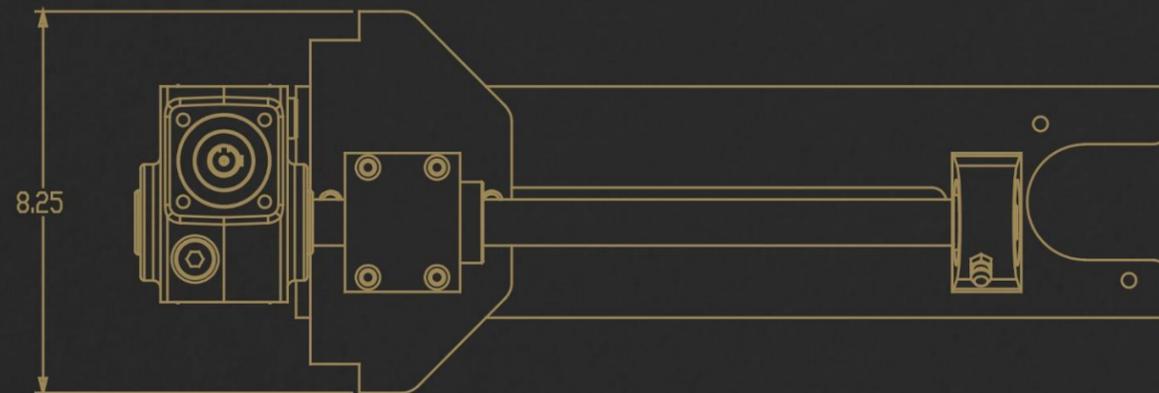
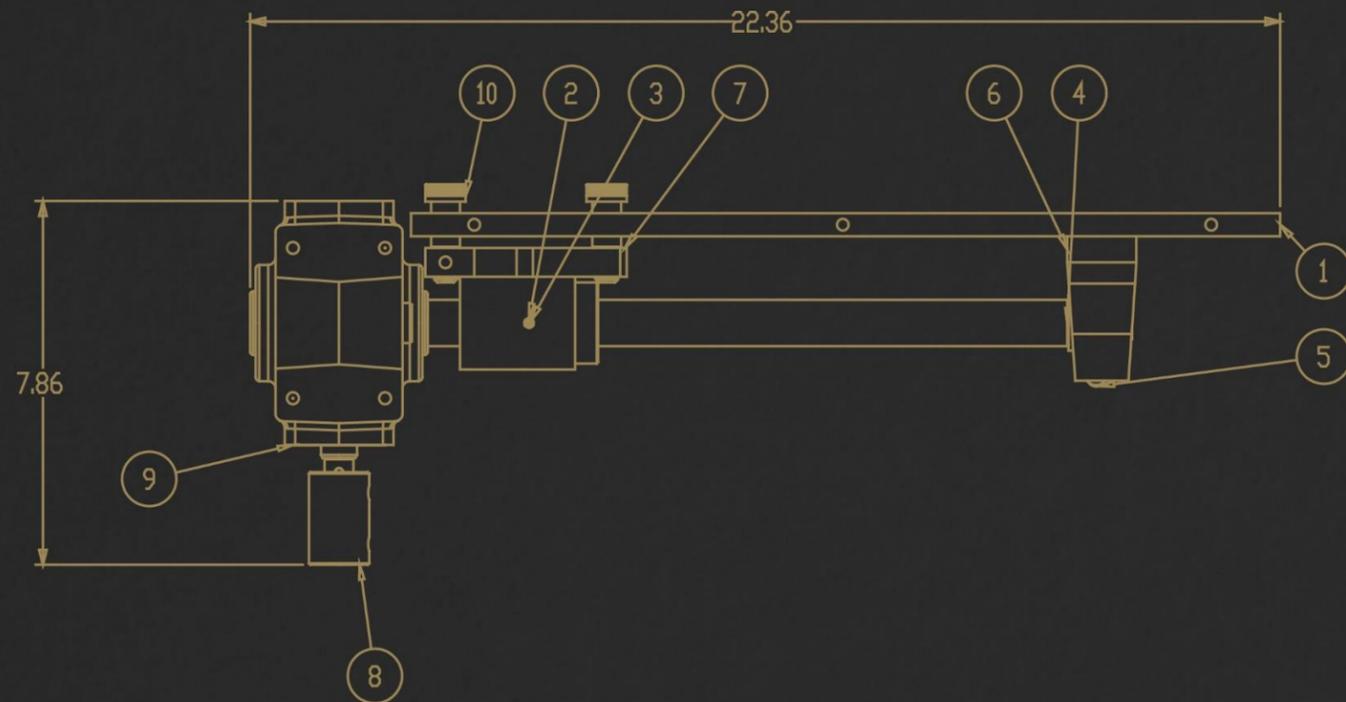
ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	01716384	SUPPORT	1
2	01714384	LIFT MOUNT	1
3	YMP000-04-131	ACME NUT RETAINER	1
4	YMP000-04-130	THREADED NUT 1-5	1
5	01776384	LIFT SCREW 1-5	1
6	164017	TAPPED BASE PILLOW BLOCK	1
7	01713384	BEARING SPACER	1
8	164018	SERIES B SINGLE REDUCTION UNIT	1
9	164019	SHOULDER SCREW	2



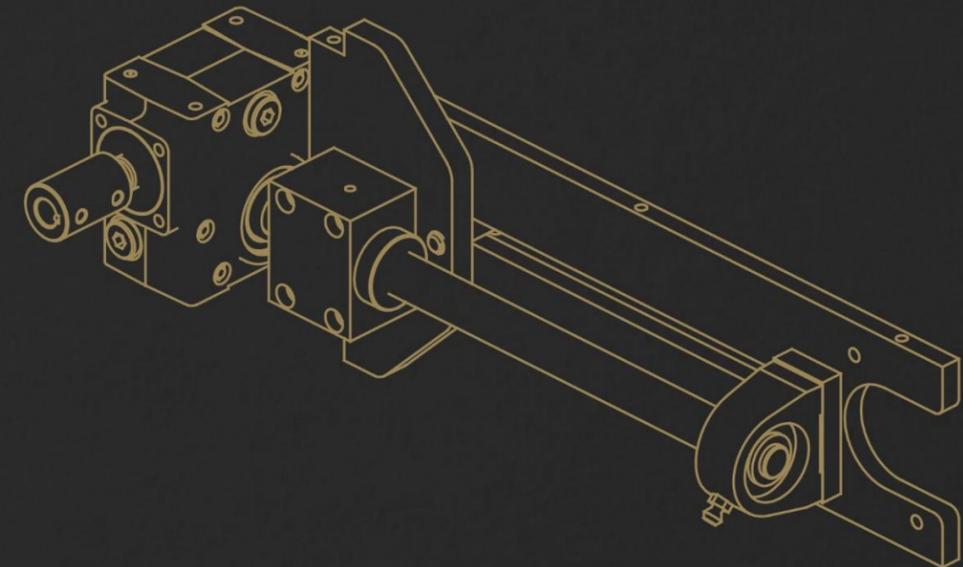
WEIGHT: 36.821 Lbs



DESIGNED BY:	LINEAR X ± 0.020 .XX ± 0.010 .XXX ± 0.005	ANGULAR X ± 2° .X ± 1° .XX ± 0° 30'	
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DATE:			
MATERIAL:	PART NUMBER:		01003384
STOCK SIZE:	DESCRIPTION:		LIFT ASSEMBLY
STOCK NUMBER:	FINISH:	SHEET SIZE:	SCALE: 1/6
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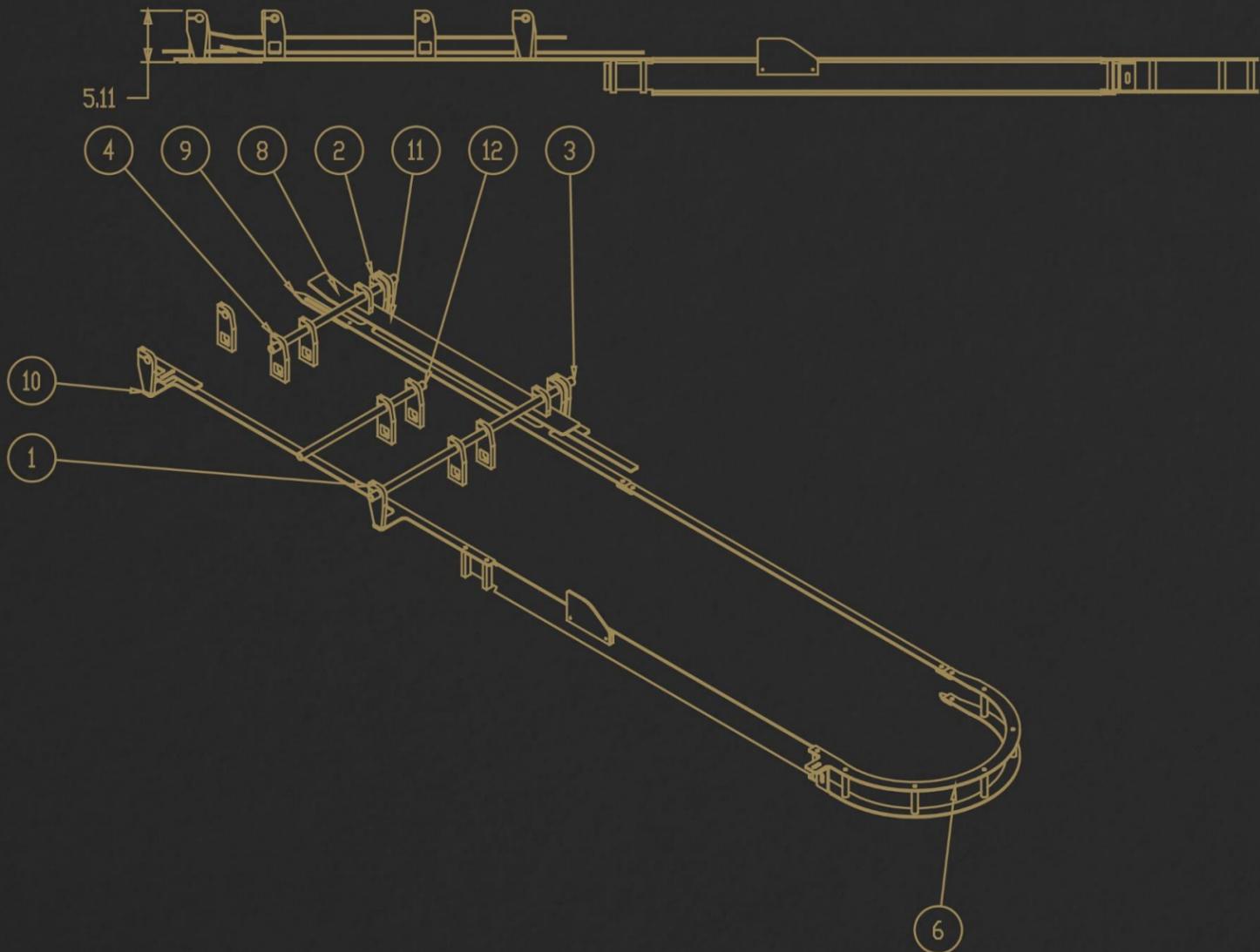


ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	01716384	SUPPORT	1
2	YMP000-04-131	ACME NUT RETAINER	1
3	YMP000-04-130	THREADED NUT 1-5	1
4	01776384	LIFT SCREW 1-5	1
5	164017	TAPPED BASE PILLOW BLOCK	1
6	01713384	BEARING SPACER	1
7	01714384	LIFT MOUNT	1
8	164020	SCC - SET SCREW COUPLING	1
9	164018	SERIES B SINGLE REDUCTION UNIT	1
10	164019	SHOULDER SCREW	2



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DRAWN BY: DD	<small>THE USE OR DUPLICATION OF THIS DOCUMENT OR ITS CONTENTS WITHOUT THE EXPRESSED WRITTEN CONSENT OF COLBORNE FOODBOTICS, LLC IS STRICTLY PROHIBITED.</small>		
DATE:			
MATERIAL:	PART NUMBER:		01006384
STOCK SIZE:	DESCRIPTION:		TAKE UP END LIFT ASSEMBLY
STOCK NUMBER:	FINISH:	SHEET SIZE:	SCALE: 1/4
<small>UNLESS OTHERWISE SPECIFIED, BREAK ALL SHARP CORNERS, REMOVE ALL BURRS, AND STAMP OR ETCH PART NO. ON SURFACE.</small>		Sheet1 OF 1	

REV.	DESCRIPTION
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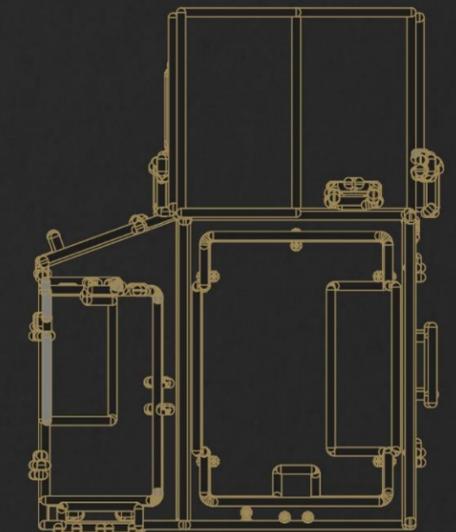
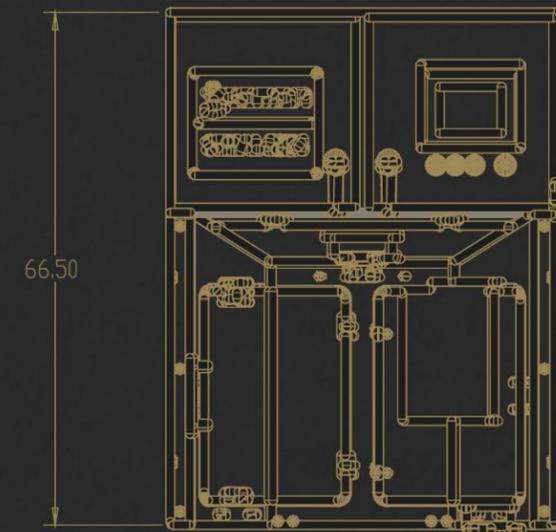
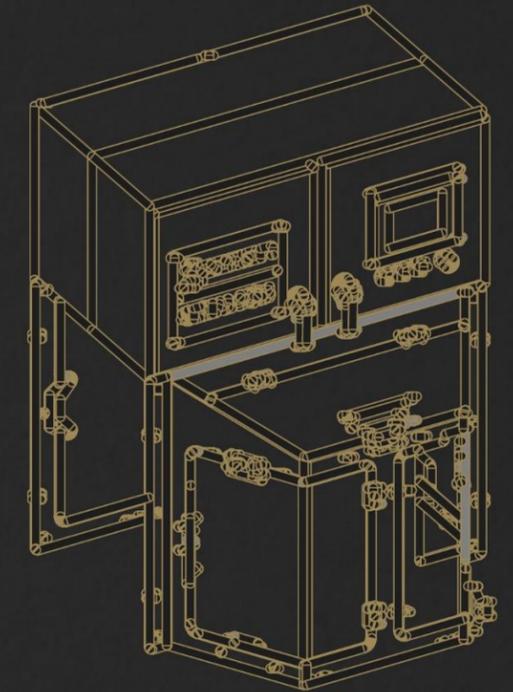
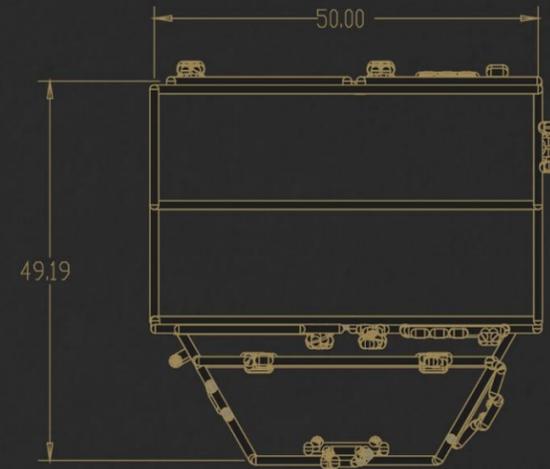
ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	01484384	CLAMP FLAIR	4
2	01483384	CLAMP FLAIR	2
3	01485384	TUBE 0.75OD 0.5ID	1
4	01488384	CLAMP FLAIR	7
5	01951384	SIDE GUIDE E3 LOAD AREA	1
6	VCA384-01-126	RETURN RING TOP	1
7	01813384	SIDE GUIDE JOINING BRACKET	2
8	01487384	FLARE PLATE-IN SIDE-UPPER	1
9	01593384	RAIL CARTON SETUP	1
10	01954384	UPPER SIDE GUIDE SET UP SIDE	1
11	01592384	UPPER SIDE GUIDE SET UP SIDE	1
12	VCA384-01-219	TUBE 0.75OD 0.5ID	3
13	VCA384-01-125	RETURN RING	1
14	VCA384-01-101		5
15	VCA384-01-124	ANGLE	1
16	VCA384-01-103	SIDE RAIL	1
17	VCA384-01-127	RAIL CARTON SETUP	1
18	VCA384-01-136	FLARE PLATE-IN SIDE-UPPER ASSY	1
19	VCA384-01-139		1
20	VCA384-01-140		1
21	VCA384-01-165	UPPER FLAP RET SPACER	1
22	VCA384-01-166	UPPER FLAP RETAINER	1

DESIGNED BY: TK	LINEAR .X ± 0.020 .XX ± 0.010 .XXX ± 0.005	ANGULAR X ± 2° .X ± 1° .XX ± 0° 30'
DRAWN BY: DA	THE USE OR DUPLICATION OF THIS DOCUMENT OR ITS CONTENTS WITHOUT THE EXPRESSED WRITTEN CONSENT OF COLBORNE FIDBOTICS, LLC IS STRICTLY PROHIBITED.	
DATE: 12/7/2019	MATERIAL: SEE BOM	PART NUMBER: 01010384
	STOCK SIZE:	DESCRIPTION: UPPER SIDE GUIDE
	STOCK NUMBER:	FINISH:
	UNLESS OTHERWISE SPECIFIED, BREAK ALL SHARP CORNERS, REMOVE ALL BURRS, AND STAMP OR ETCH PART NO. ON SURFACE.	

SHEET SIZE: 11x17
 SCALE: 1/16
 Sheet1 OF 1

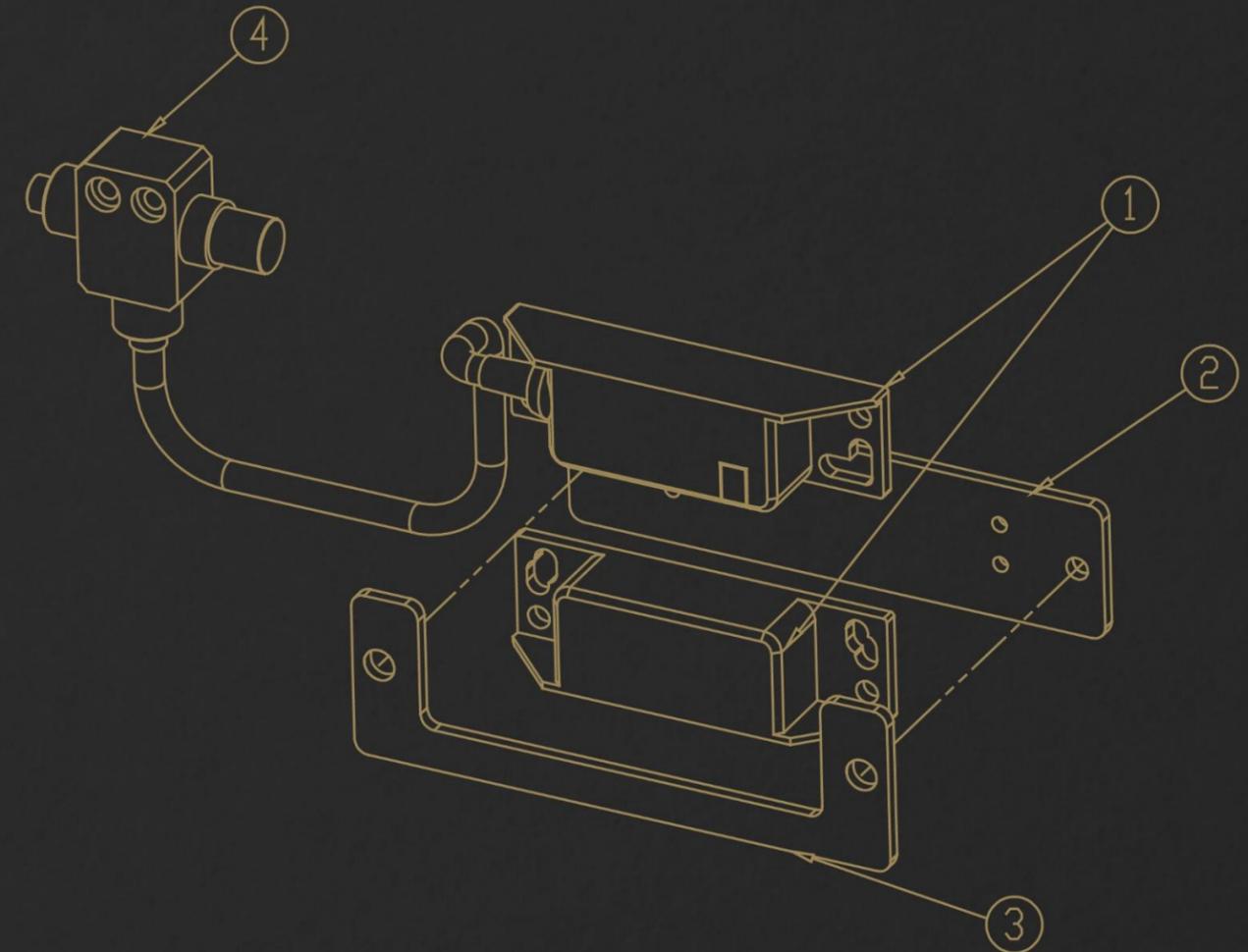
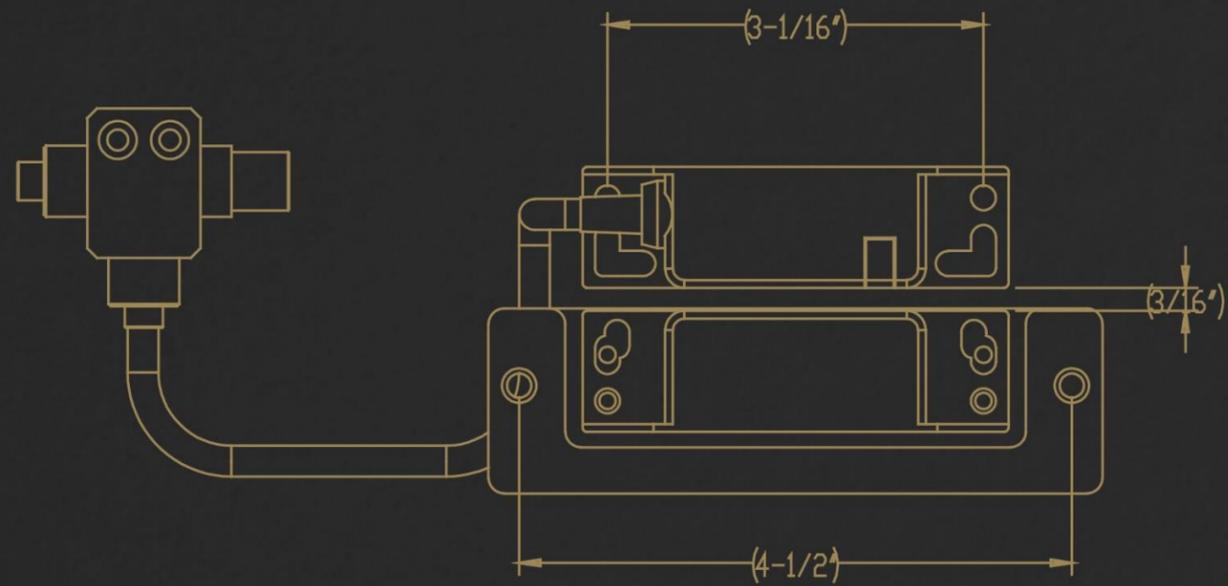
REV.	DESCRIPTION
A	REVISED LOCATION OF CLAMPS AND RODS-ML-02.06.2020

ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	02052384	GUARDING TIE-IN BRKT	1
2	02153384	LEXAN MAGAZINE WINDOW	1
3	02013384	MTG BRACKET	1
4	02111384	LEXAN MTG BRACKET	7
5	02151384	LEXAN ANGLE DOOR	1
6	02006384	DOOR SENSOR MAGNET ASSY.	2
7	02010384	HANDLE DOOR ASSEMBLY	2
8	02007384	HINGE MTG	6
9	02100384	GUARD - ROTARY FEEDER	1
10	02101384	GUARD DISCHARGE	1
11	02102000	GUARD MAIN ACCESS	1
12	02103384	COVER ROTARY FEEDER	1
13	02150384	GUARD WINDOW - ROTARY	1
14	02023384	WINDOW HAND LOAD	1
15	02025384	LEXAN DISCHARGE COVER	1
16	02008384	DOOR SENSOR MAGNET ASSY.	1
17	02210384	BRACKET CORNER SUPPORT	2
18	02005384	HINGE SPACER	2
19	164046	CONTROL ENCL, HMI YEAMAN	1
20	164045	CONTROL ENCL, HI-VOLTAGE	1
21	164039	PULL HANDLE	1
22	118991	HINGE - LH	3
23	118990	HINGE - RH	3
24	YMP000-97-101	C-BOX BACK PLATE	1
25	VCA384-02-170	YEAMAN SERIAL PLATE 384	1
26	YMP000-97-102	E-PORT ADPATER PLATE	1
27	YMP000-97-103	MONITOR ADAPER BACKET	1



DESIGNED BY: SK	LINEAR .X ± 0.020 .XX ± 0.010 .XXX ± 0.005	ANGULAR X ± 2° .X ± 1° .XX ± 0° 30'	
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DATE: 12/10/2019			
MATERIAL:	PART NUMBER: 02004384		
STOCK SIZE:	DESCRIPTION: CW GUARDING		
STOCK NUMBER:	FINISH:	SHEET SIZE	SCALE: 1/24
<small>UNLESS OTHERWISE SPECIFIED, BREAK ALL SHARP CORNERS, REMOVE ALL BURRS, AND STAMP OR ETCH PART NO. ON SURFACE</small>		Sheet1	OF 2

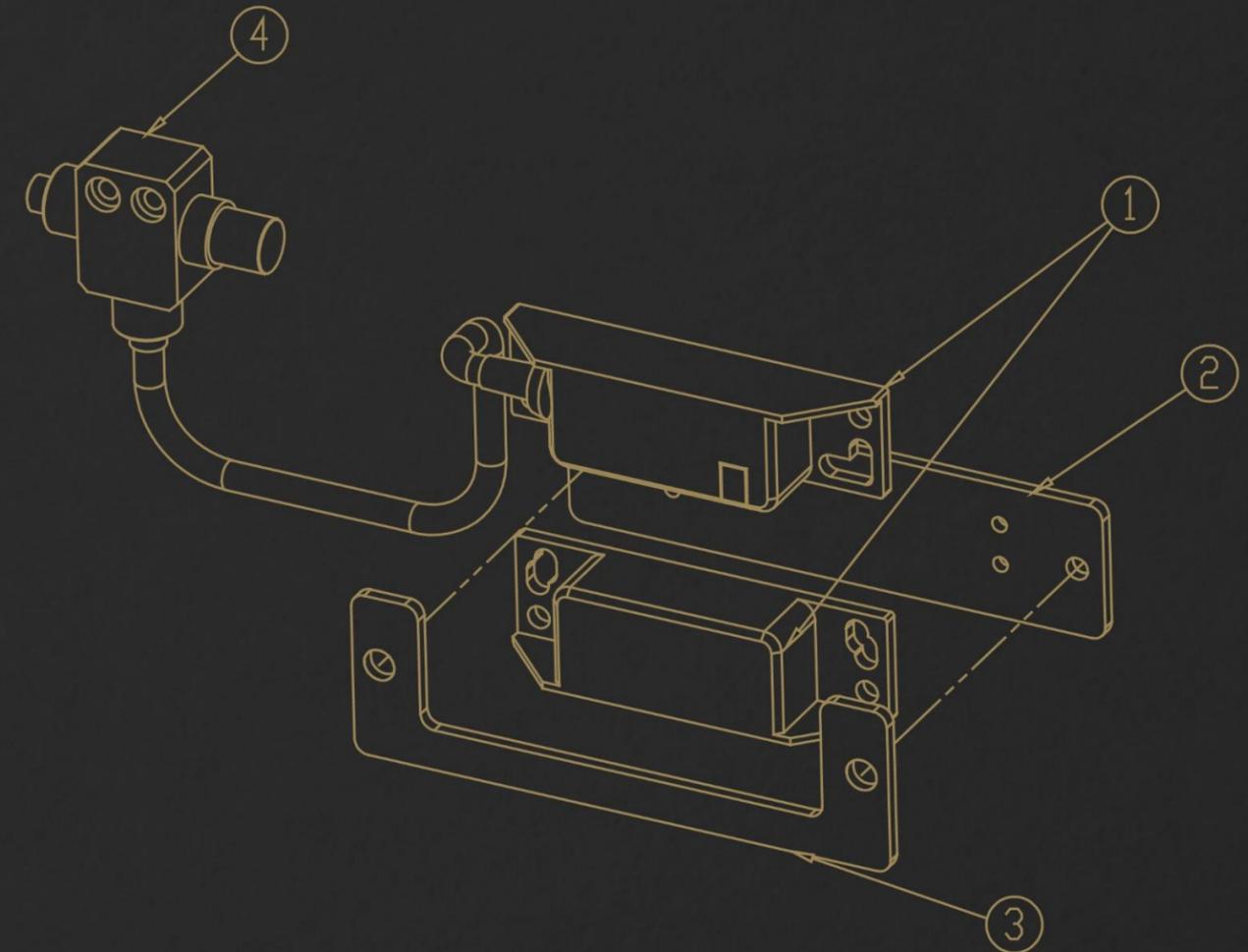
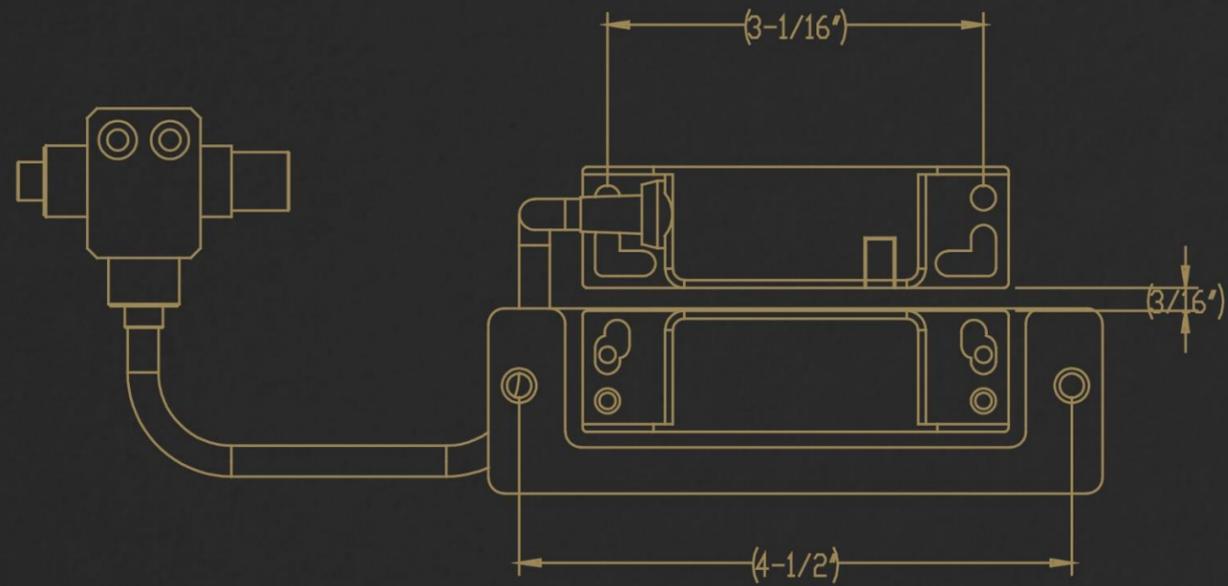
ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	162738	SAFETY SWITCH - SENA GUARD	1
2	02001384	SENA GUARD MTG BACKPLATE	1
3	02002384	MTG PLATE LEXAN SAFETY SWITCH	1
4	162739	TEE DC MICRO	1



WEIGHT: 0.550 Lbs

DESIGNED BY:	LINEAR X ± 0.020 .XX ± 0.010 .XXX ± 0.005	ANGULAR X ± 2° .X ± 1° .XX ± 0° 30'	
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DATE:	PART NUMBER: 02006384		
DATE:	12/10/2019	DESCRIPTION: DOOR SENSOR MAGNET ASSY.	
MATERIAL:	STOCK SIZE:		SHEET SIZE:
STOCK NUMBER:	FINISH:	SCALE: 2:3	
UNLESS OTHERWISE SPECIFIED: BREAK ALL SHARP CORNERS, REMOVE ALL BURRS, AND STAMP OR ETCH PART NO. ON SURFACE.			Sheet 1 OF 1

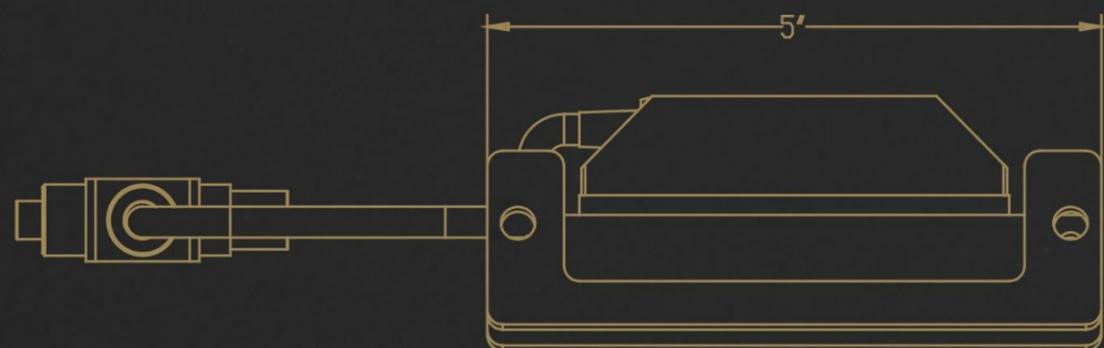
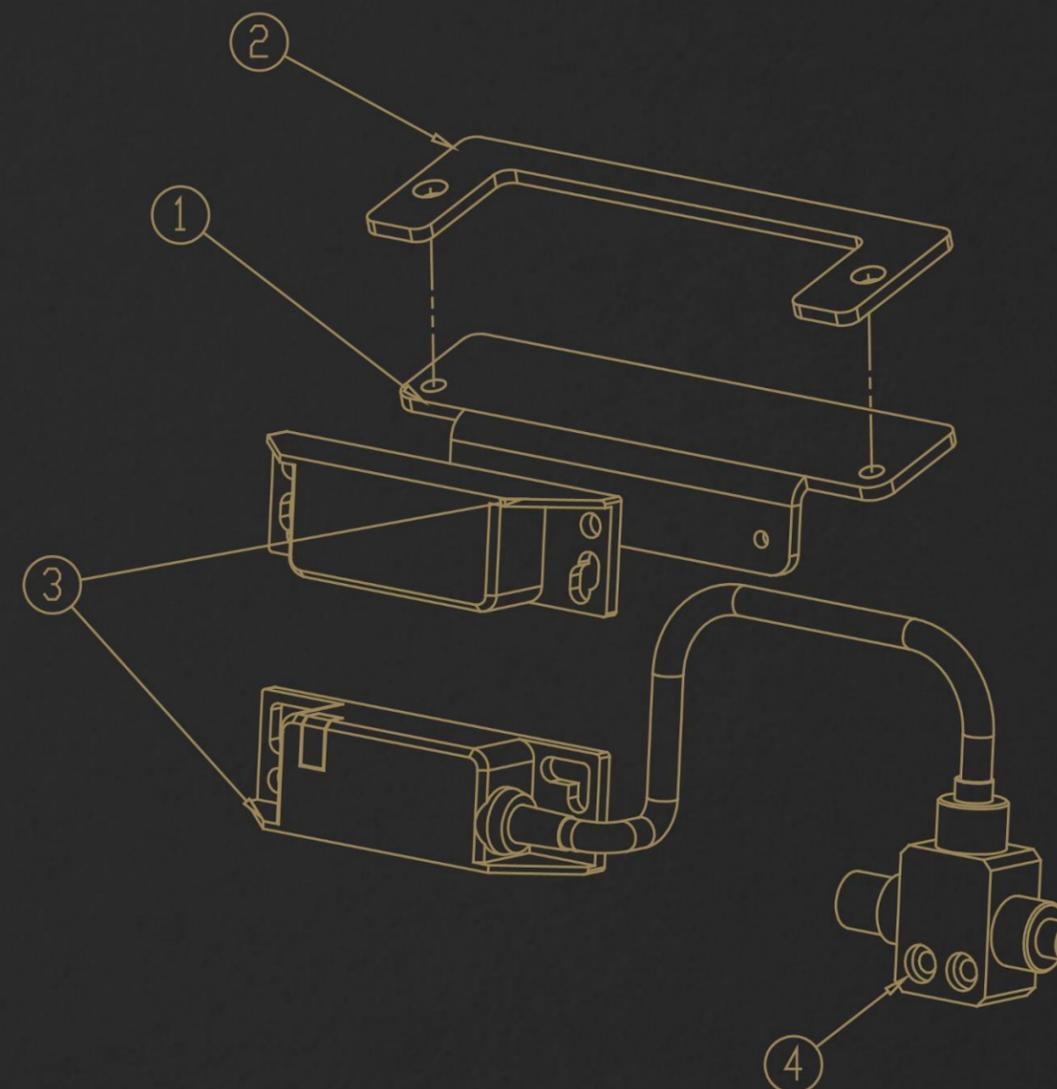
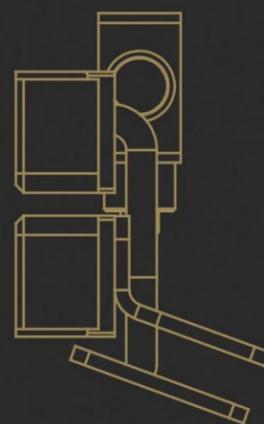
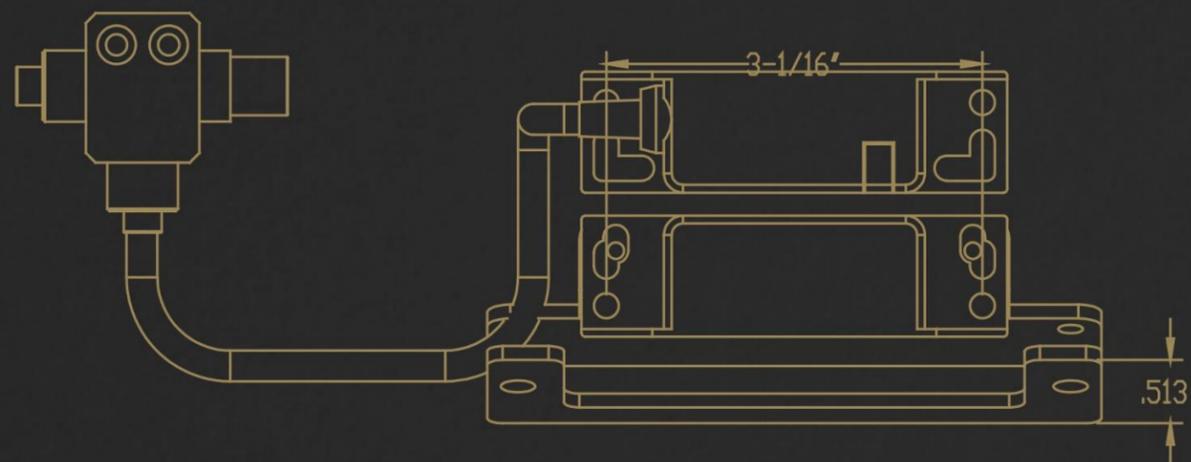
ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	162738	SAFETY SWITCH - SENA GUARD	1
2	02001384	SENA GUARD MTG BACKPLATE	1
3	02002384	MTG PLATE LEXAN SAFETY SWITCH	1
4	162739	TEE DC MICRO	1



WEIGHT: 0.550 Lbs

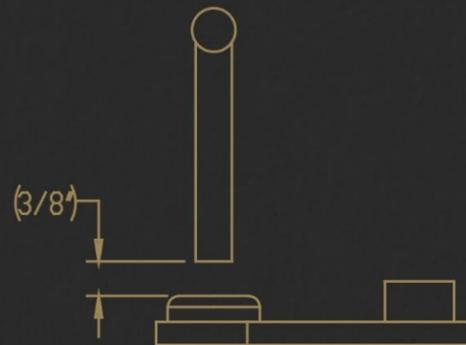
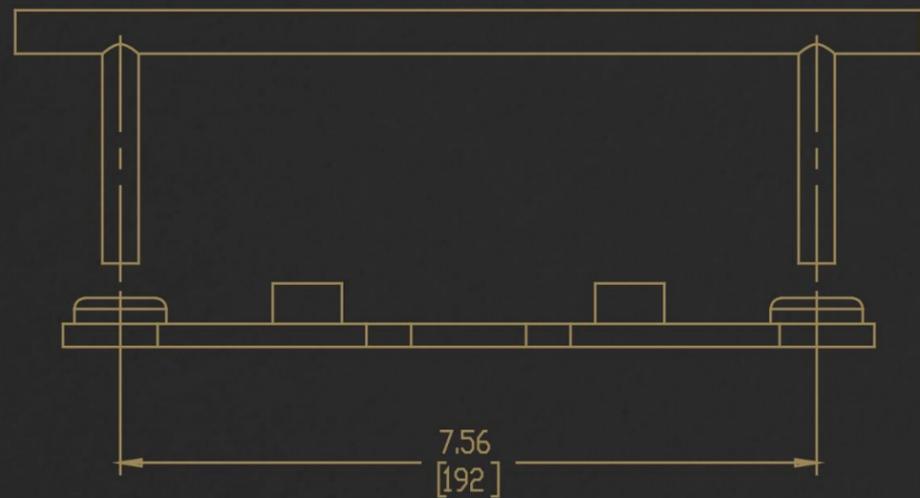
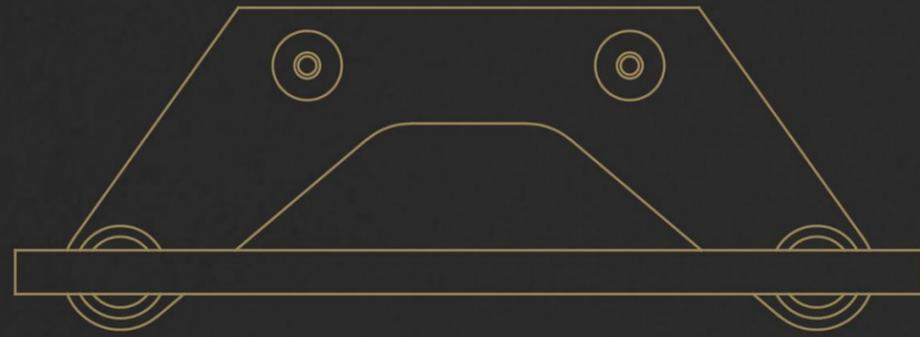
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DATE:	PART NUMBER: 02006384		
DATE:	12/10/2019	DESCRIPTION: DOOR SENSOR MAGNET ASSY.	
MATERIAL:	STOCK SIZE:		SHEET SIZE:
STOCK NUMBER:	FINISH:	SCALE: 2:3	
UNLESS OTHERWISE SPECIFIED: BREAK ALL SHARP CORNERS, REMOVE ALL BURRS, AND STAMP OR ETCH PART NO. ON SURFACE.			Sheet 1 OF 1

ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	02014384	MTG BRACKET - ANGLE	1
2	02002384	MTG PLATE LEXAN SAFETY SWITCH	1
3	162738	SAFETY SWITCH - SENA GUARD	1
4	162739	TEE DC MICRO	1

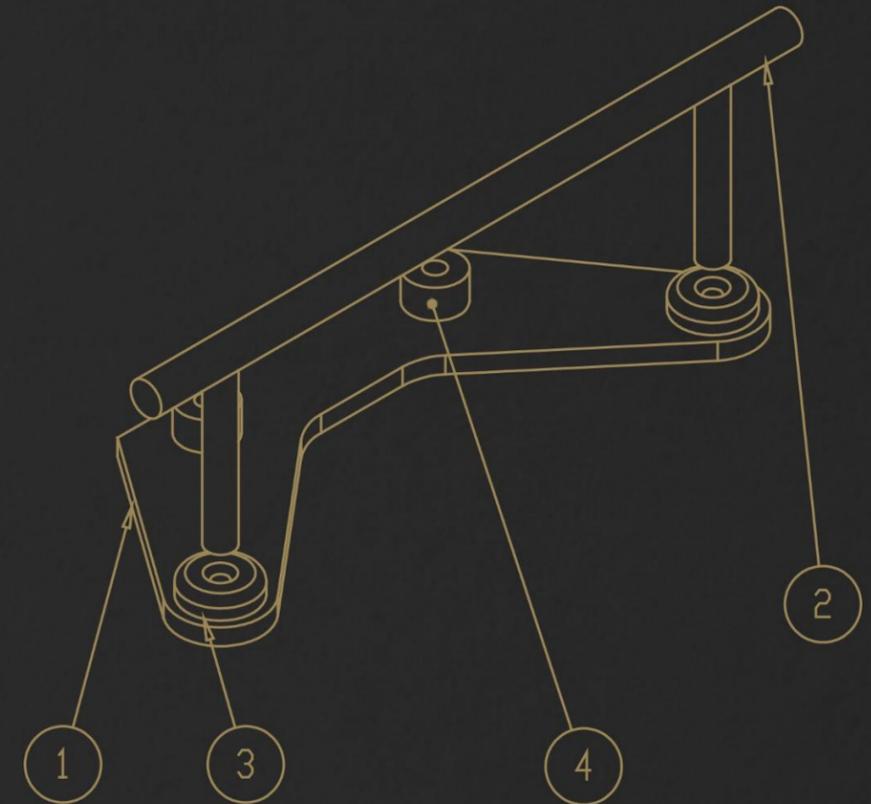


WEIGHT: 0.628 Lbs

DESIGNED BY:	LINEAR X ± 0.020 .XX ± 0.010 .XXX ± 0.005	ANGULAR X ± 2° .X ± 1° .XX ± 0° 30'	
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DATE: 12/10/2019			PART NUMBER: 02008384
MATERIAL:			DESCRIPTION: DOOR SENSOR MAGNET ASSY.
STOCK SIZE:			SHEET SIZE
STOCK NUMBER:	FINISH:	SCALE: 2:3	
<small>UNLESS OTHERWISE SPECIFIED, BREAK ALL SHARP CORNERS, REMOVE ALL BURRS, AND STAMP OR ETCH PART NO. ON SURFACE.</small>			Sheet 1 OF 1

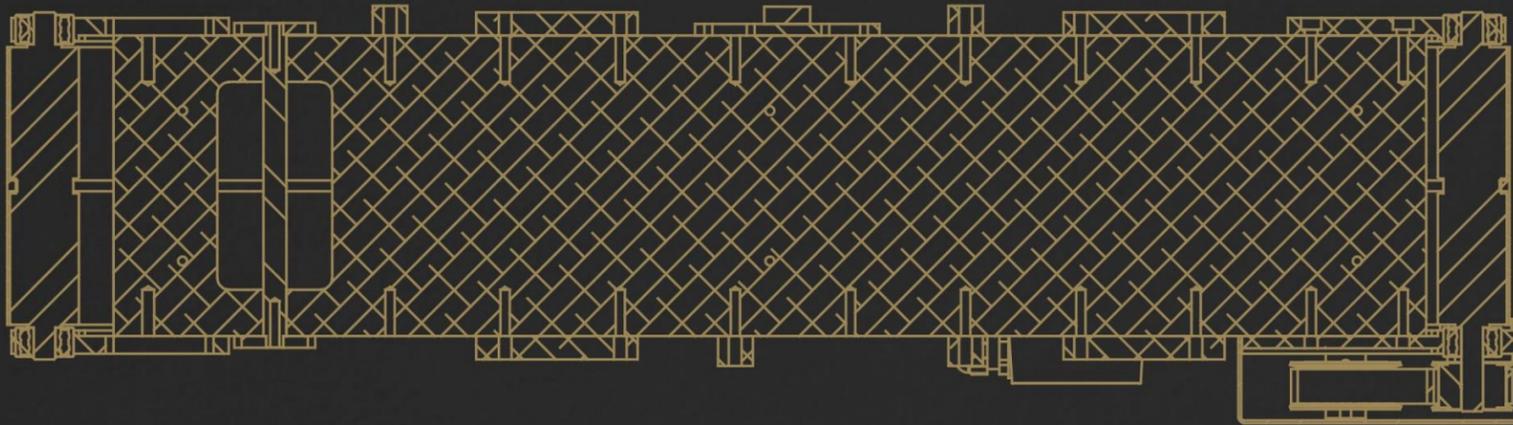


ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	02058384	MAGNET HOLDER	1
2	164039	PULL HANDLE	1
3	163967	CAP MAGNET NEODYMIUM 1IN	2
4	02059384	LATCH SPACER	2



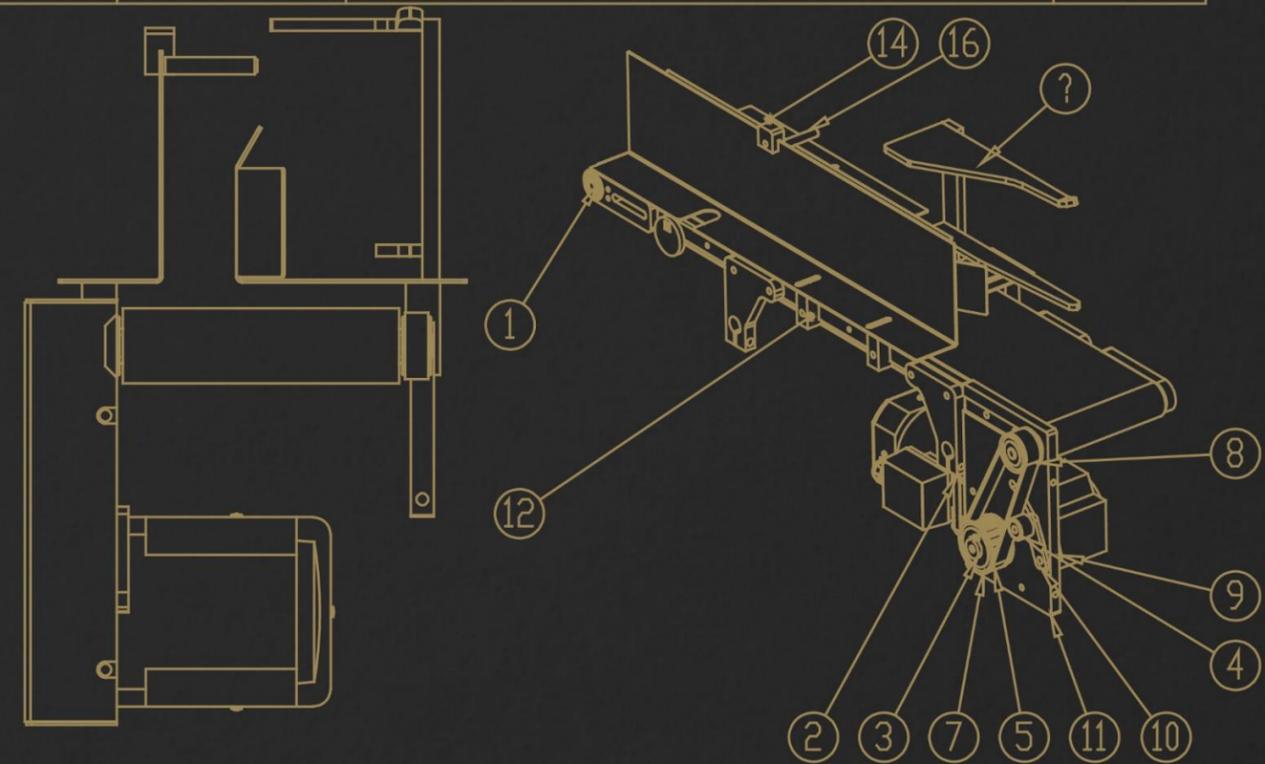
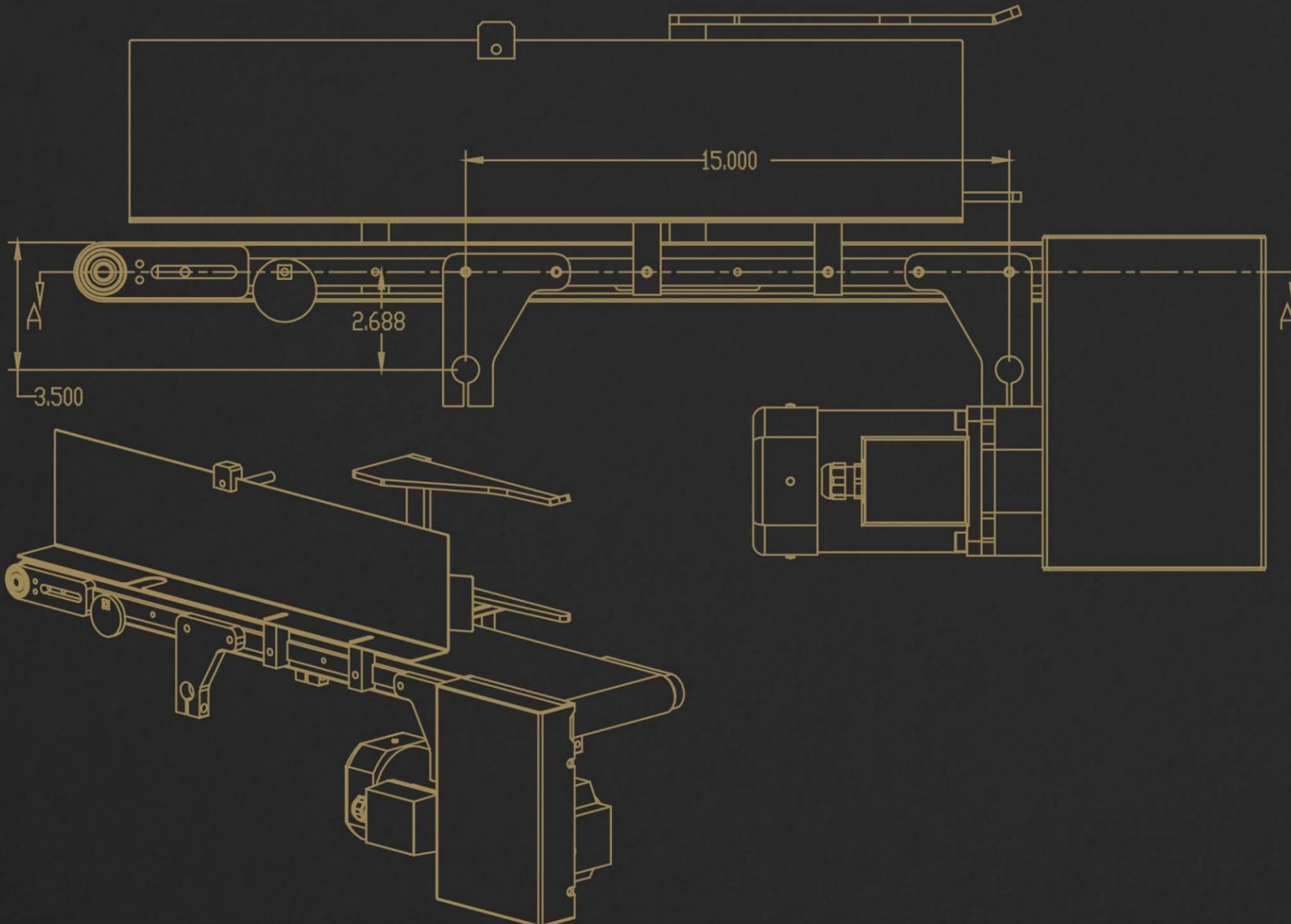
WEIGHT: 1.4 Lbs

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DATE:			
DATE:	12/10/2019		PART NUMBER:
MATERIAL:			02010384
STOCK SIZE:			DESCRIPTION:
STOCK NUMBER:		FINISH:	HANDLE DOOR ASSEMBLY
<small>UNLESS OTHERWISE SPECIFIED, BREAK ALL SHARP CORNERS, REMOVE ALL BURRS, AND STAMP OR ETCH PART NO. ON SURFACE</small>			SHEET SIZE:
			SCALE: 1/2
			Sheet1 OF 1



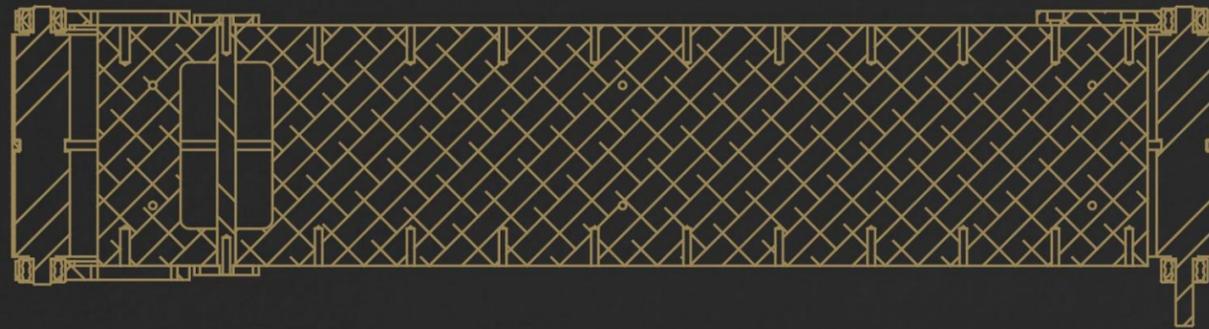
SECTION A-A

ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	08002384	DISCHARGE CONV ASSY	1
2	08007384	MTG PRACKET MOTOR END	4
3	163999	GEAR MOTOR ,RATIO 9:1,1/4 HP	1
4	164001	BEARING, CAM FOLLOWER, 1.00"	1
5	164000	TIMING BELT	1
6	08015384	BELT GUARD	1
7	08011384	GEARMOTOR BELT PULLEY	1
8	08012384	GEARBELT PULLEY	1
9	08032384	TENSIONER BRKT - OUTSIDE	1
10	08031384	TENSIONER BRACKET - INSIDE	1
11	08138384	MOTOR MOUNTING PLATE	1
12	VCA384-01-241	GUIDE PLATE MTG BRKT	4
13	VCA384-01-242	DISCHRG CONVEY SIDE L	1
14	VCA384-01-243	DISCHRG CONVEY SIDE R	1
15	VCA384-01-143	CARTON GUIDE OFF	1
16	VCA384-01-244	TRIP BAR CLAMP ON	1

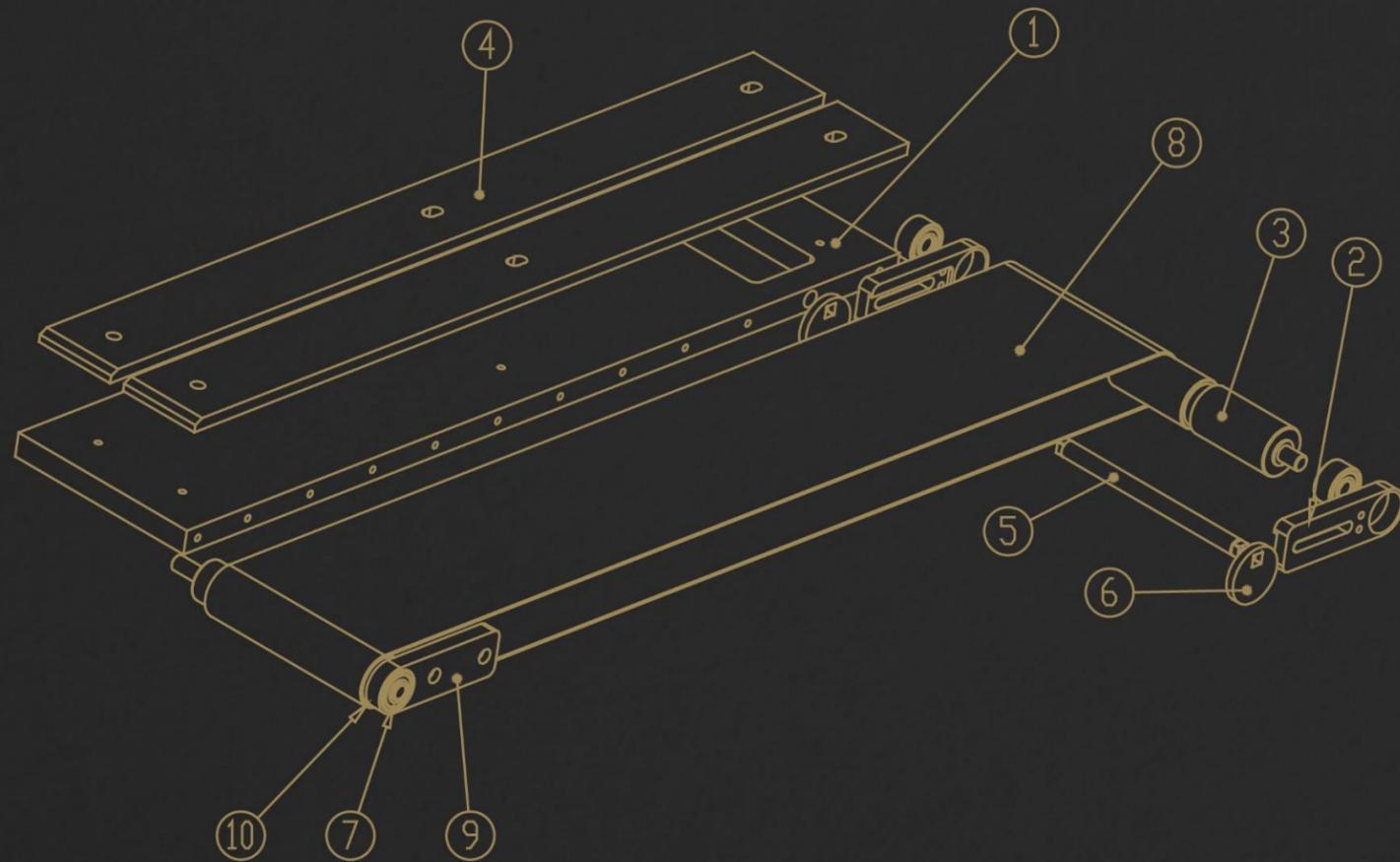


DESIGNED BY: DA	LINEAR .X ± 0.020 .XX ± 0.010 .XXX ± 0.005	ANGULAR X ± 2° .X ± 1° .XX ± 0° 30'
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DATE: 12/6/2019	MATERIAL: SEE BOM	PART NUMBER: 08001384
	STOCK SIZE:	DESCRIPTION: DISCHARGE CONVEYOR
	STOCK NUMBER:	SHEET SIZE
	FINISH:	SCALE: 1/4
UNLESS OTHERWISE SPECIFIED, BREAK ALL SHARP CORNERS, REMOVE ALL BURRS, AND STAMP OR ETCH PART NO. ON SURFACE.		Sheet 1 OF 1



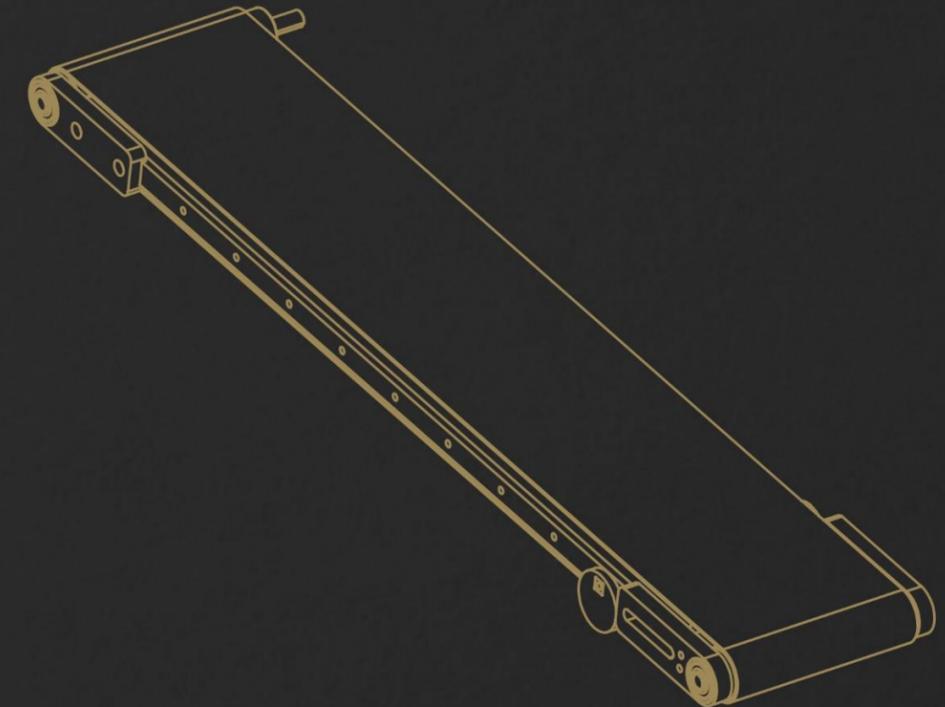


SECTION A-A



WEIGHT: 18.9 Lbs

ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	08036384	CONVEYOR MAIN PLATE	1
2	08027384	IDLER PULLEY BEARING BLOCK	2
3	08030384	IDLER PULLEY	1
4	08038384	CONVEYOR BELT SUPPORT	2
5	08033384	BELT TENSIONER SHAFT	1
6	08039384	ECCENTRIC BELT TENSIONER	2
7	163928	DBL ROW BEARING 12MMID X 32MM OD	4
8	163998	FLAT BELT 6' WIDE X 66.7' LG	1
9	08028384	DRIVE PULLEY BEARING BLOCK	1
10	08029384	CONVEYOR DRIVE PULLEY	1



DESIGNED BY: ML	LINEAR X ± 0.020 .XX ± 0.010 .XXX ± 0.005	ANGULAR X ± 2° .X ± 1° .XX ± 0° 30'
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DATE: 12/5/2019		
MATERIAL:	SEE BOM	
STOCK SIZE:		
STOCK NUMBER:	FINISH:	
UNLESS OTHERWISE SPECIFIED, BREAK ALL SHARP CORNERS, REMOVE ALL BURRS, AND STAMP OR ETCH PART NO. ON SURFACE.		



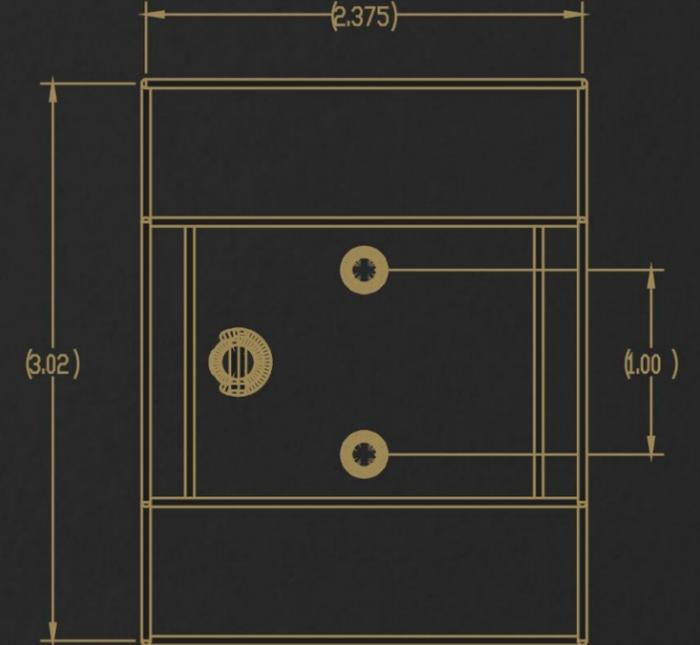
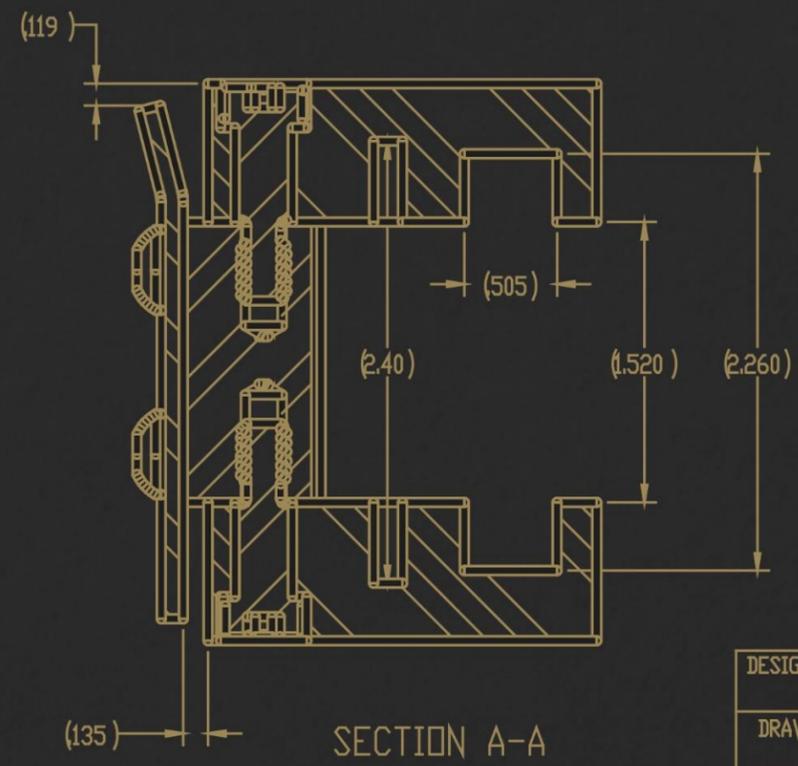
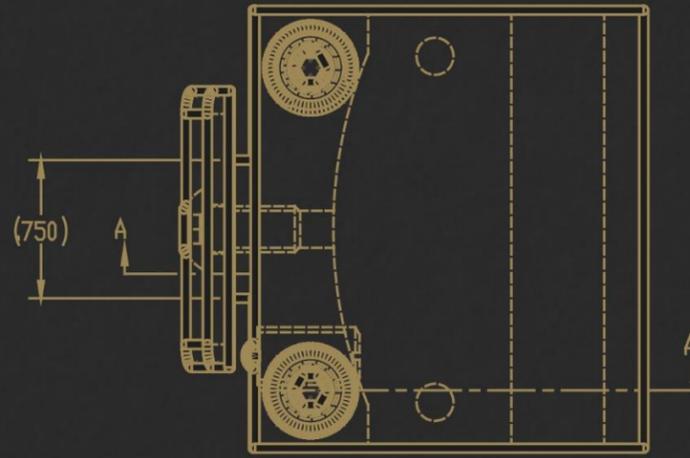
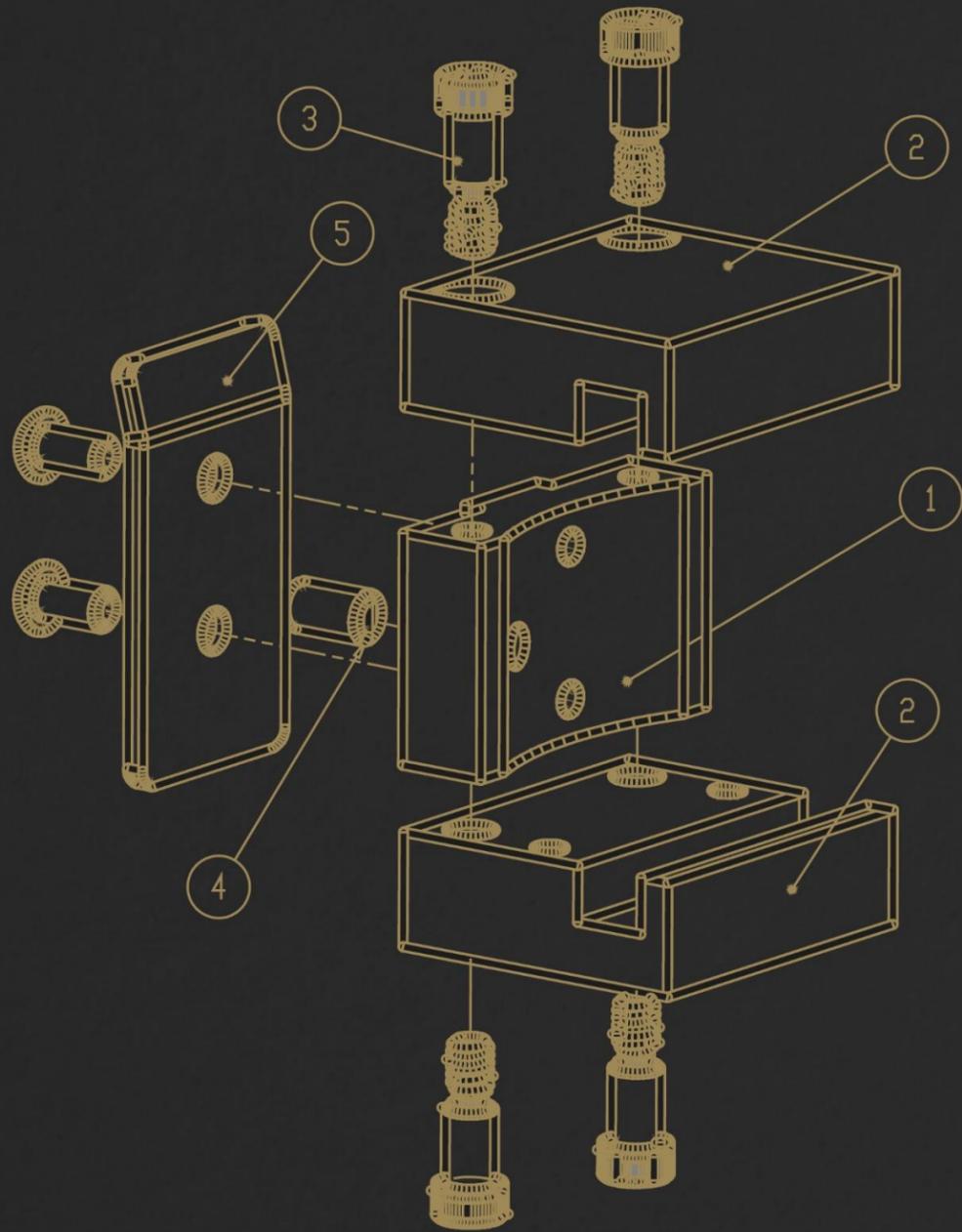
PART NUMBER: 08002384

DESCRIPTION: DISCHARGE CONV ASSY

SHEET SIZE: SCALE: 1/5 Sheet 1 OF 1

REVISIONS				
ZONE	REV.	DESCRIPTION	DATE	APPROVED

ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	09008384	"A" CARRIER MOUNT BLOCK	1
2	09005384	"A" CHAIN SLIDE BLOCK	2
3	163993	SH BOLT .31 X .50 ALLOY STEEL .25-20 THREAD	4
4	163994	CARRIER SPRING RETAINER - 5/16 Ball Plunger	1
5	09009384	"A" CARRIER RETAINER PLATE	1
6	163997	BHCS .25-20 X .50LG ALLY STL HEX DRIVE	2



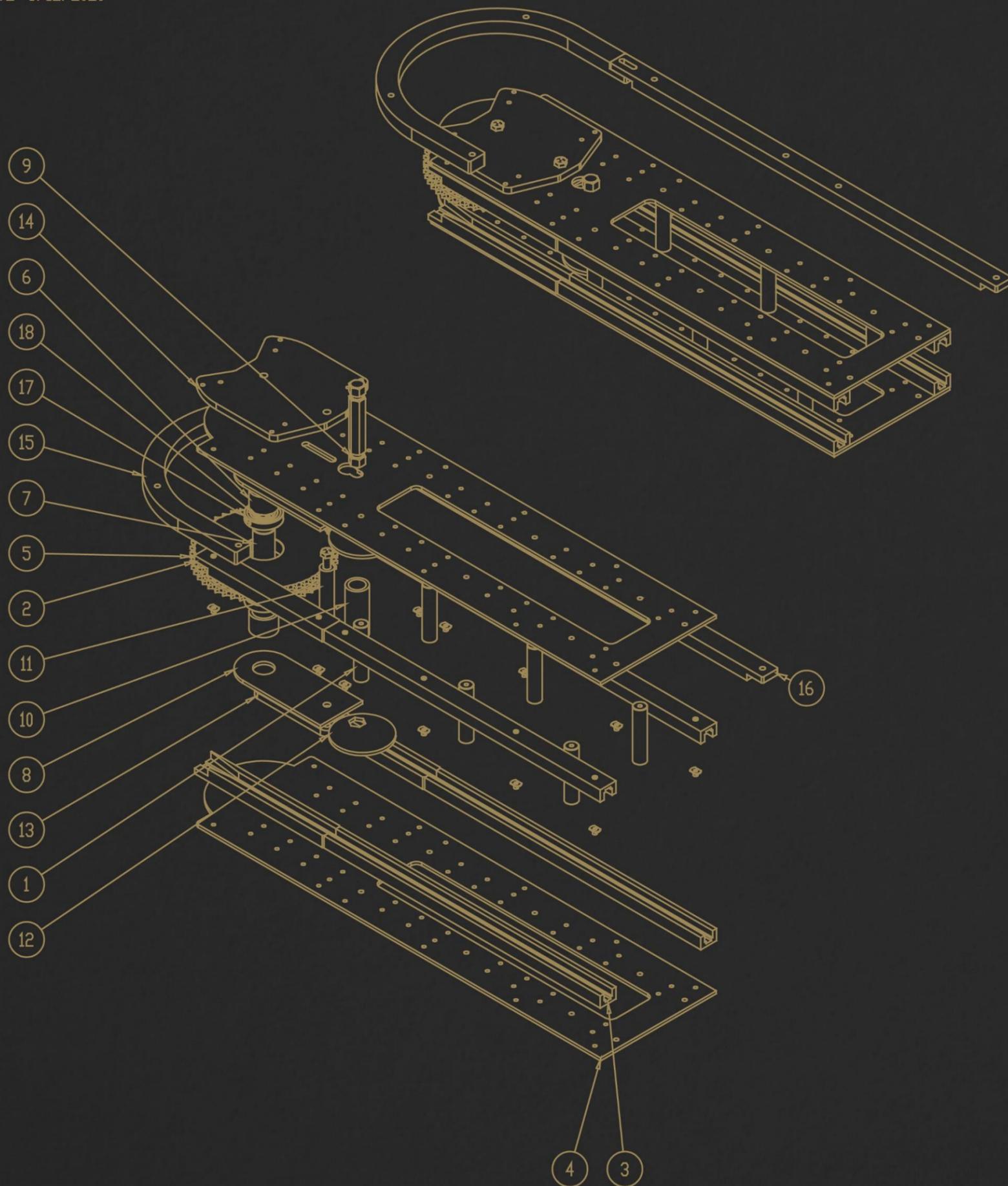
DESIGNED BY: SK	LINEAR .X ± 0.020 .XX ± 0.010 .XXX ± 0.005	ANGULAR X ± 2° X ± 1° .XX ± 0° 30'
DRAWN BY: TN	THE USE OR DUPLICATION OF THIS DOCUMENT OR ITS CONTENTS WITHOUT THE EXPRESSED WRITTEN CONSENT OF COLBORNE FIDUBROTICS, LLC IS STRICTLY PROHIBITED.	
DATE: 12/5/2019		
MATERIAL: SEE BOM		
STOCK SIZE:		
STOCK NUMBER:	FINISH:	
UNLESS OTHERWISE SPECIFIED: BREAK ALL SHARP CORNERS, REMOVE ALL BURRS, AND STAMP OR ETCH PART NO. ON SURFACE.		

Yeaman

PART NUMBER: 09010384

DESCRIPTION: A SLIDE BLOCK ASSEMBLY

SHEET SIZED: SCALE: 1:1 Sheet 1 OF 1



ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	TTA00A-02-003	A TILT CONVEYOR FRAME SPACER	6
2	TTA00A-02-004	A TILT CONVEYOR TRACK LEAD E	2
3	TTA00A-02-005	A TILT TRAY CHAIN TRACK	4
4	TTA00A-03-001	SIDE PLATE	2
5	TTA00A-03-002	SPROCKET	1
6	TTA00A-03-003	TAKE UP SPACER	2
7	TTA00A-03-004	SPROCKET SHAFT	1
8	TTA00A-03-005	TAKE UP PUSH PLATE	2
9	TTA00A-03-006	KEY	1
10	TTA00A-03-007	SPACER	1
11	TTA00A-03-008	SPACER	1
12	TTA00A-03-009	TENSIONING CAM	2
13	TTA00A-03-010	TAKE UP NUT PLATE	1
14	TTA00A-03-011	END RING MOUNTING PLATE	1
15	TTA00A-03-012	HOLD-UP CAM 1	1
16	TTA00A-03-013	CAM 01	1
17	113411	TILT CONVEYOR A	2
18	163987	TILT CONVEYOR A	2
19	164008	SLAB BASE	24
20	TTA00A-02-009	A TILT CONVEYOR TRACK LEAD E	2

DESIGNED BY:	LINEAR X ± 0.020 .XX ± 0.010 .XXX ± 0.005	ANGULAR X ± 2° .X ± 1° .XX ± 0° 30'
DRAWN BY:	THE USE OR DUPLICATION OF THIS DOCUMENT OR ITS CONTENTS WITHOUT THE EXPRESSED WRITTEN CONSENT OF COLBORNE FOODBOTICS, LLC IS STRICTLY PROHIBITED.	
DATE: 12/6/2019		
MATERIAL:		
STOCK SIZE:		
STOCK NUMBER:	FINISH:	
UNLESS OTHERWISE SPECIFIED, BREAK ALL SHARP CORNERS, REMOVE ALL BURRS, AND STAMP OR ETCH PART NO. ON SURFACE.		

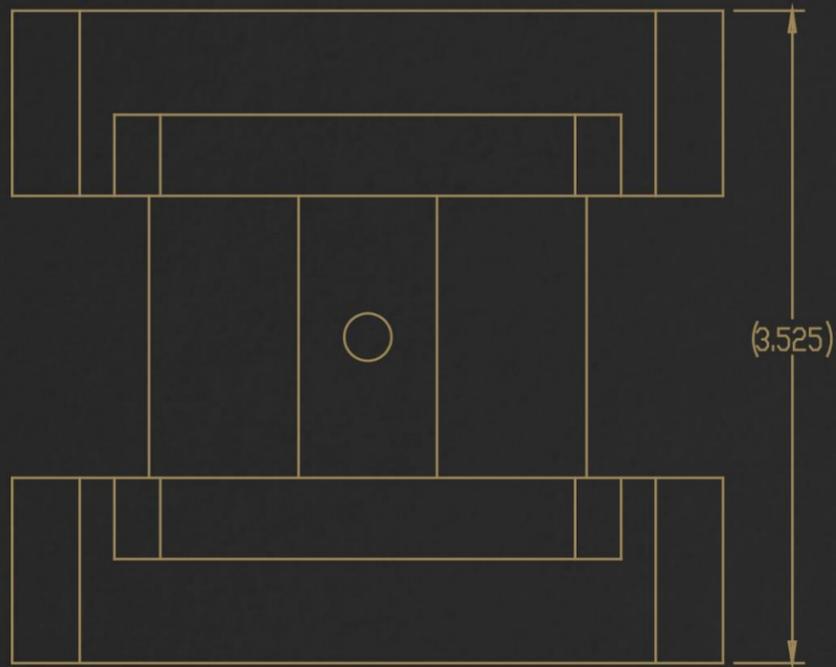


PART NUMBER: TTA00A-03-000

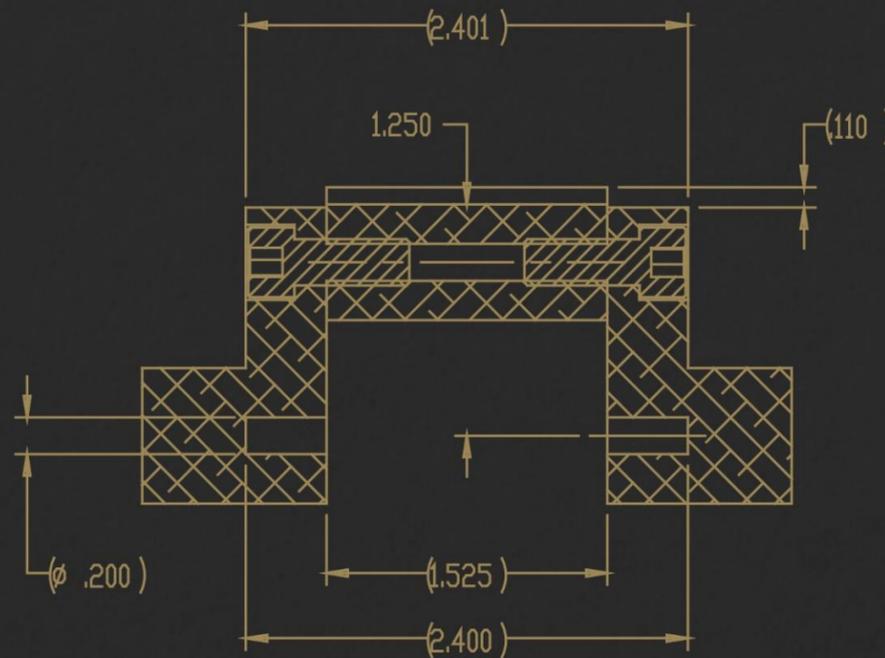
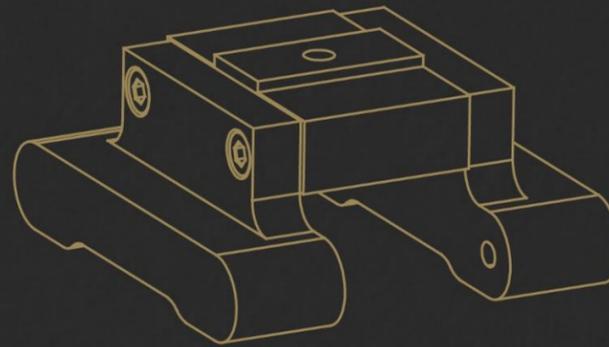
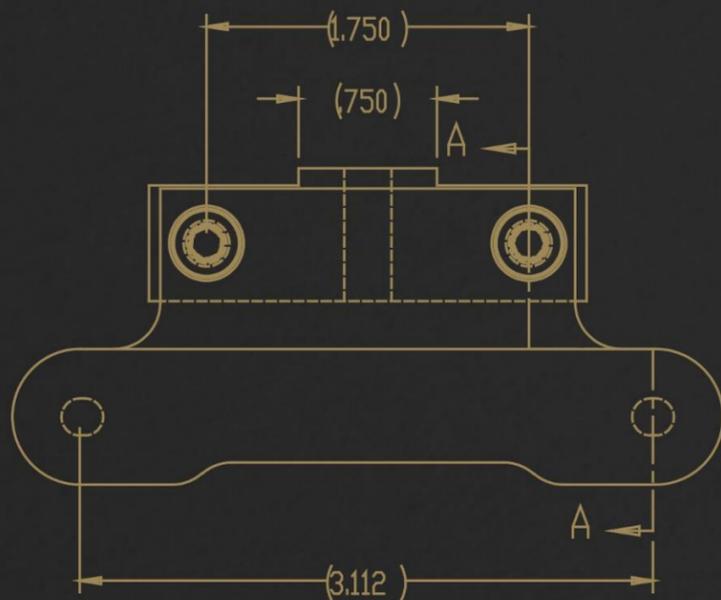
DESCRIPTION: A TILT CONVEYOR TAKE UP END

SHEET SIZE: SCALE: 1/8 Sheet 1 OF 1

REV.	DESCRIPTION



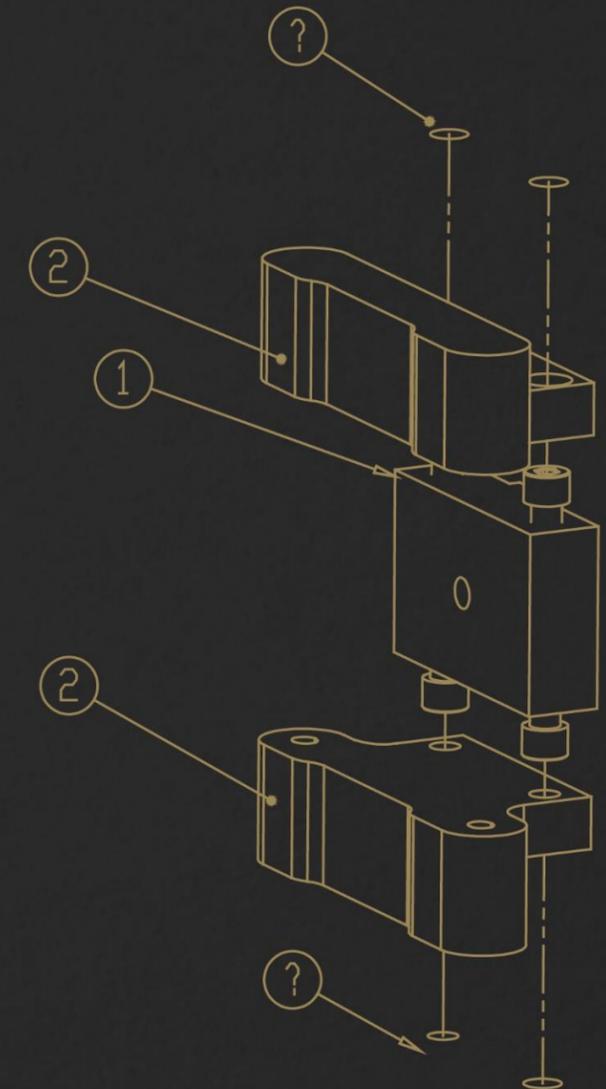
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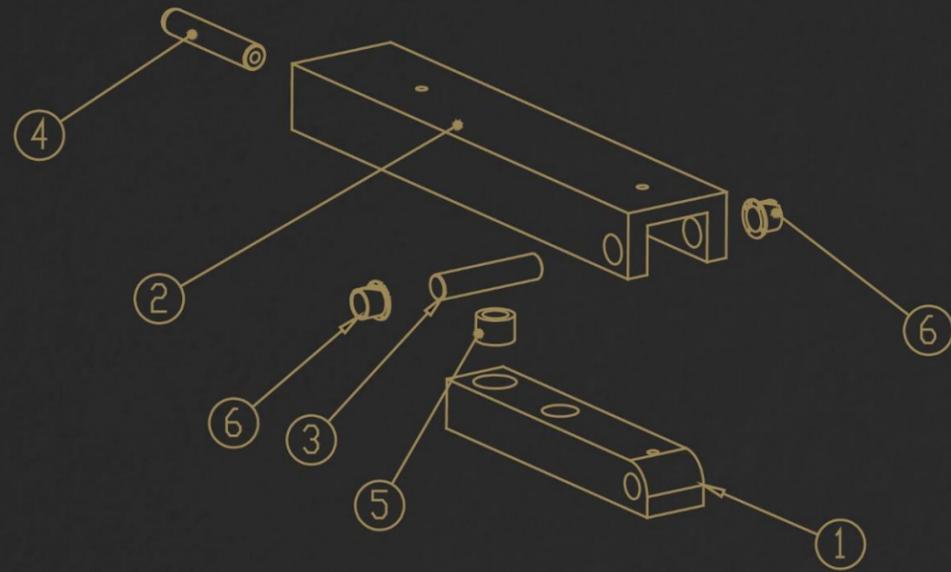
SECTION A-A

WEIGHT: 0.9 Lbs

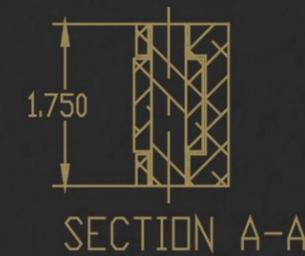
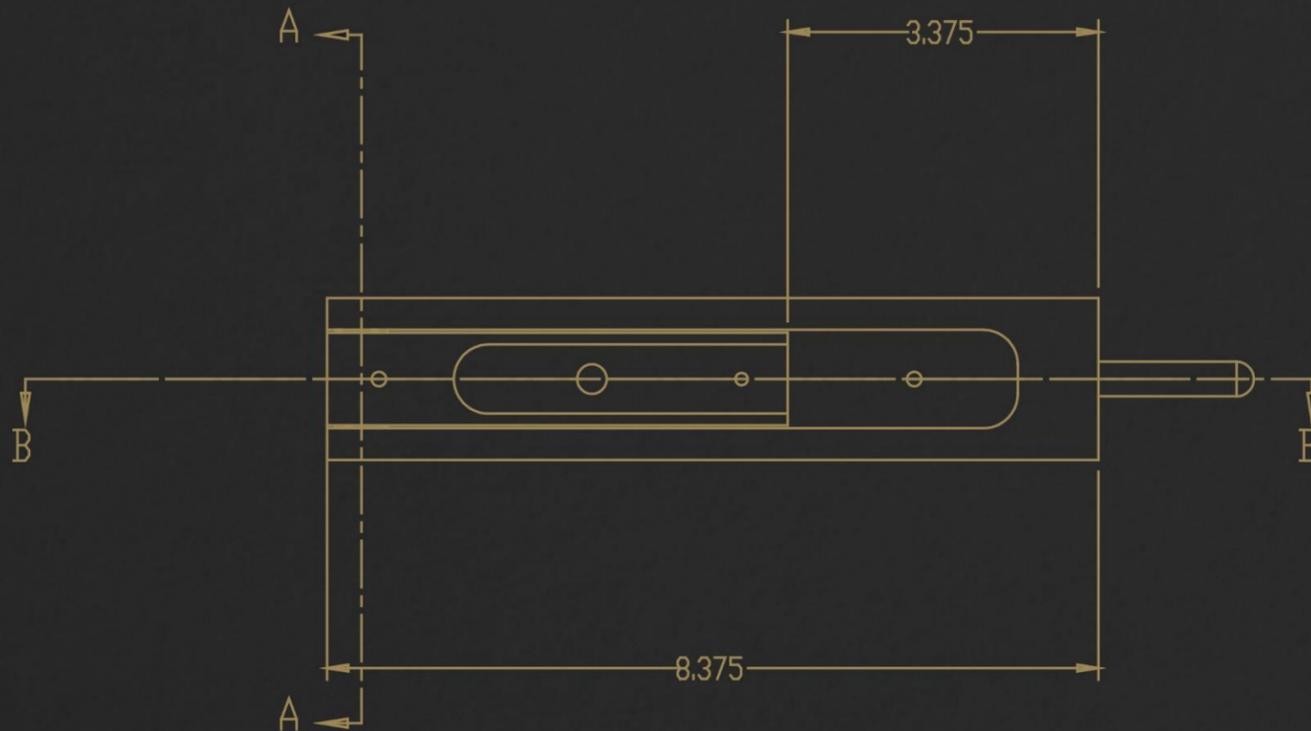
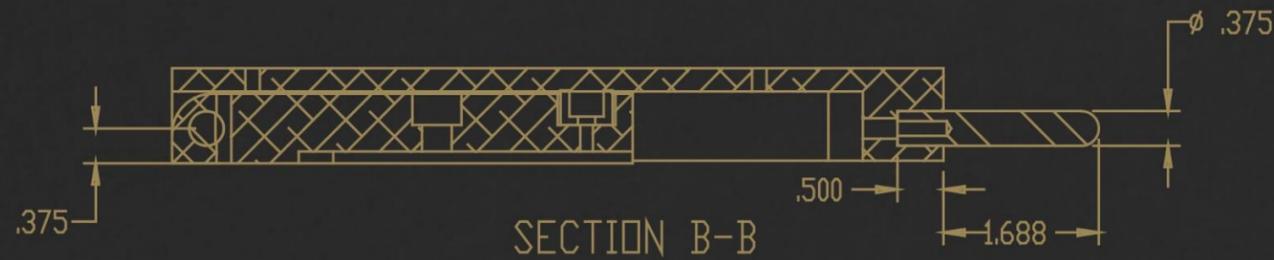
ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	TTA00A-04-001	A CARRIER BLOCK TILT	1
2	TTA00A-04-002	A SLIDE BLOCK TILT	2
3	501093		4



DESIGNED BY:	LINEAR X ± 0.020 .XX ± 0.010 .XXX ± 0.005	ANGULAR X ± 2° .X ± 1° .XX ± 0° 30'	
DRAWN BY:	<small>THE USE OR DUPLICATION OF THIS DOCUMENT OR ITS CONTENTS WITHOUT THE EXPRESSED WRITTEN CONSENT OF COLBORNE FRODOBOTICS, LLC IS STRICTLY PROHIBITED.</small>		
DATE: 1/3/2020			PART NUMBER: TTA00A-04-000
MATERIAL:			DESCRIPTION: A SLIDE BLOCK TILT CONVEYOR
STOCK SIZE:			SHEET SIZE
STOCK NUMBER:	FINISH:	SCALE: 1:1	
<small>UNLESS OTHERWISE SPECIFIED, BREAK ALL SHARP CORNERS, REMOVE ALL BURRS, AND STAMP OR ETCH PART NO. ON SURFACE</small>			Sheet1 OF 1



ITEM NO.	PART NUMBER	DESCRIPTION	FLAT/QT Y.
1	TTA00A-10-001	PIVOT BRACKET	1
2	TTA00A-10-002	BRACKET HOLD TILT TRAY	1
3	TTA00A-10-003	PIVOT PIN TILT TRAY	1
4	TTA00A-10-004	3/8 PIN TILT TRAY	1
5	163995	TILT CONVEYOR A	1
6	163996	BUSHING, FLANGED, 0.38" SHAFT,	2



DESIGNED BY:	LINEAR X ± 0.020 .XX ± 0.010 .XXX ± 0.005	ANGULAR X ± 2° .X ± 1° .XX ± 0° 30'
DRAWN BY:	THE USE OR DUPLICATION OF THIS DOCUMENT OR ITS CONTENTS WITHOUT THE EXPRESSED WRITTEN CONSENT OF COLBORNE FOODBOTICS, LLC IS STRICTLY PROHIBITED.	
DATE:	12/6/2019	
MATERIAL:	SEE BOM	
STOCK SIZE:		
STOCK NUMBER:	FINISH:	
UNLESS OTHERWISE SPECIFIED, BREAK ALL SHARP CORNERS, REMOVE ALL BURRS, AND STAMP OR ETCH PART NO. ON SURFACE.		

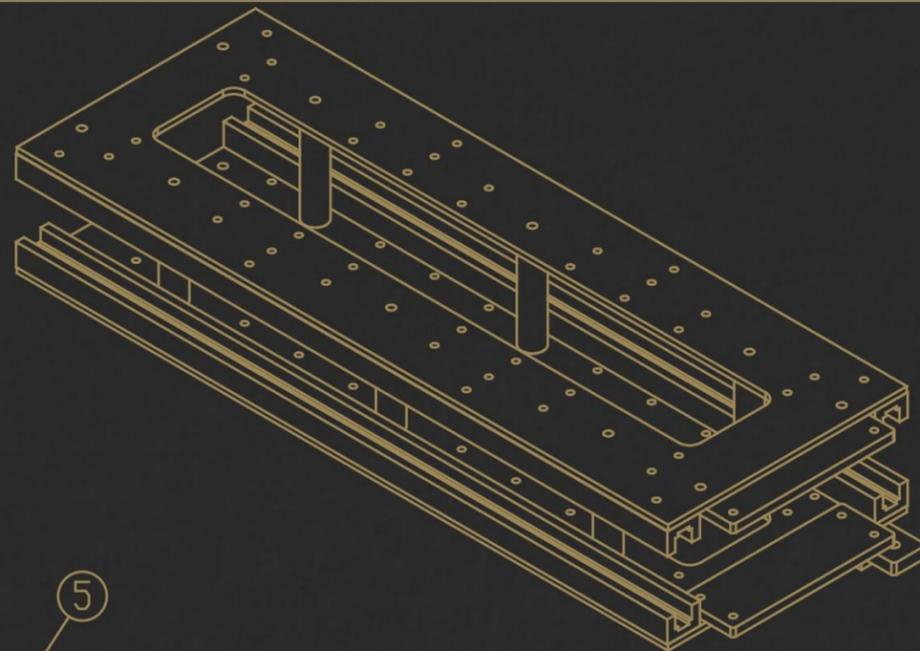
Yeaman

PART NUMBER: TTA00A-10-000

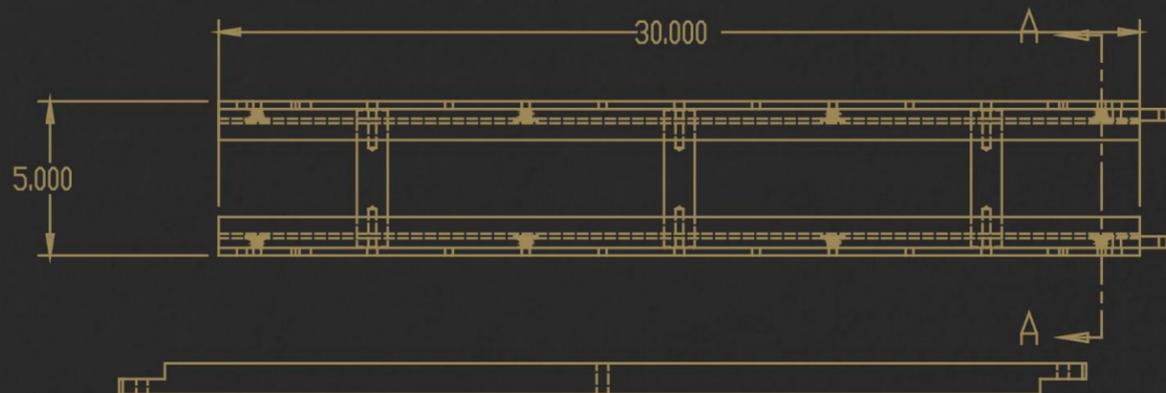
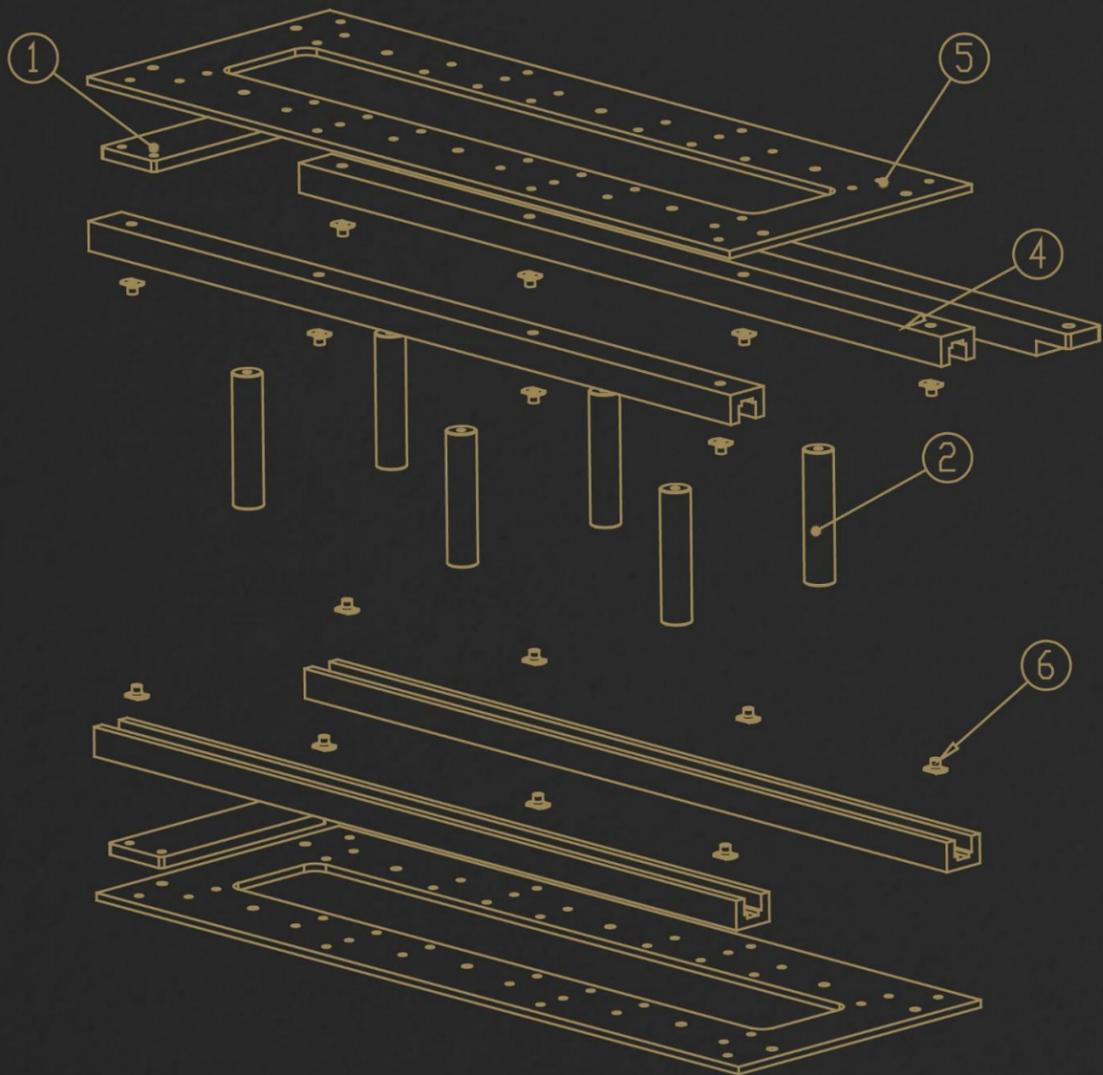
DESCRIPTION: TILT TRAY ASSEMBLY

SHEET SIZE: SCALE: 1/2 Sheet 1 OF 1

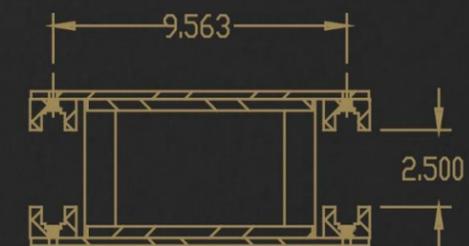
REV.	DESCRIPTION



ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	TTA00A-02-002	A TILT CONVEYOR CONNECTION P	2
2	TTA00A-02-003	A TILT CONVEYOR FRAME SPACER	6
3	TTA00A-02-008	CAM 02	1
4	TTA30A-01-001	EXTENTION CHAIN TRACK	4
5	TTA30A-01-002	A TILT CONVEYOR 30 EXTENSIO	2
6	164008	SLAB BASE	16



SECTION A-A



WEIGHT: 43.8 Lbs

DESIGNED BY:	LINEAR X ± 0.020 .XX ± 0.010 .XXX ± 0.005	ANGULAR X ± 2° .X ± 1° .XX ± 0° 30'
DRAWN BY:	THE USE OR DUPLICATION OF THIS DOCUMENT OR ITS CONTENTS WITHOUT THE EXPRESSED WRITTEN CONSENT OF COLBORNE FOODBOTICS, LLC IS STRICTLY PROHIBITED.	
DATE: 12/6/2019		
MATERIAL:		
STOCK SIZE:		
STOCK NUMBER:	FINISH:	
UNLESS OTHERWISE SPECIFIED, BREAK ALL SHARP CORNERS, REMOVE ALL BURRS, AND STAMP OR ETCH PART NO. ON SURFACE.		

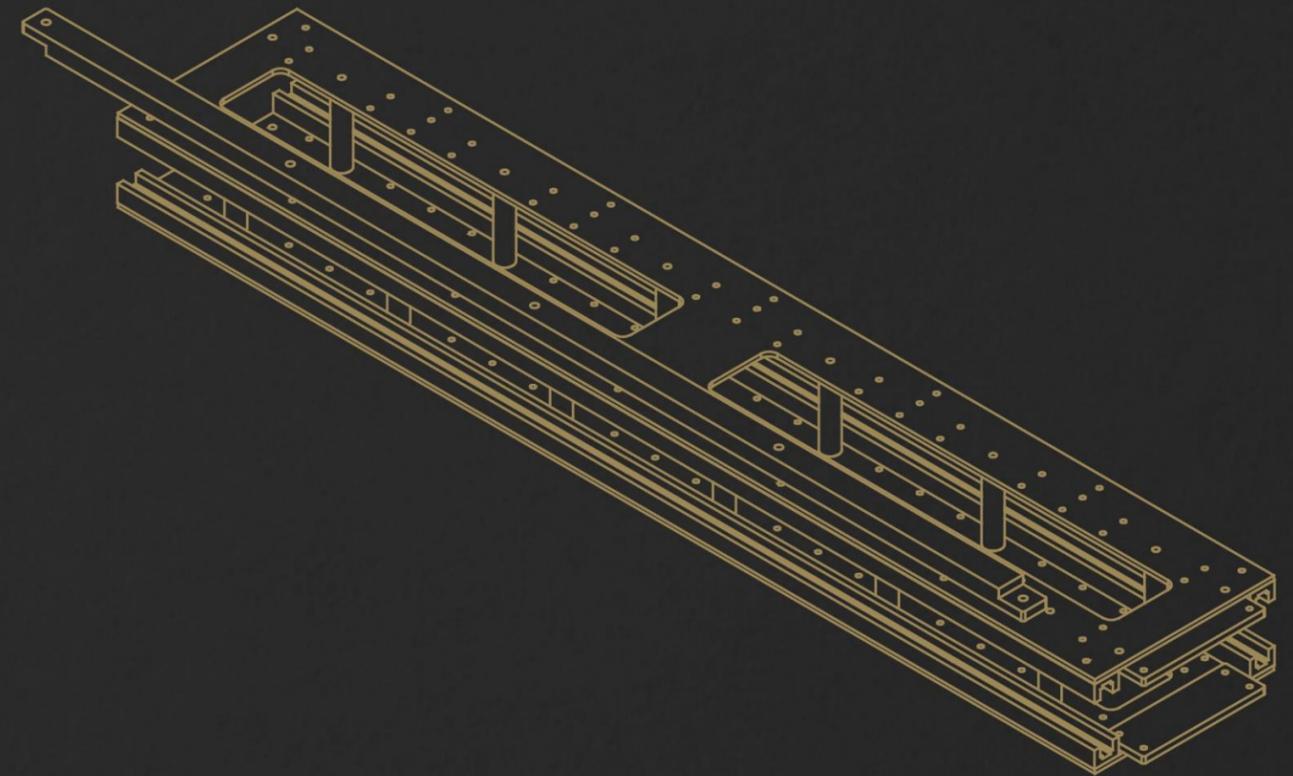
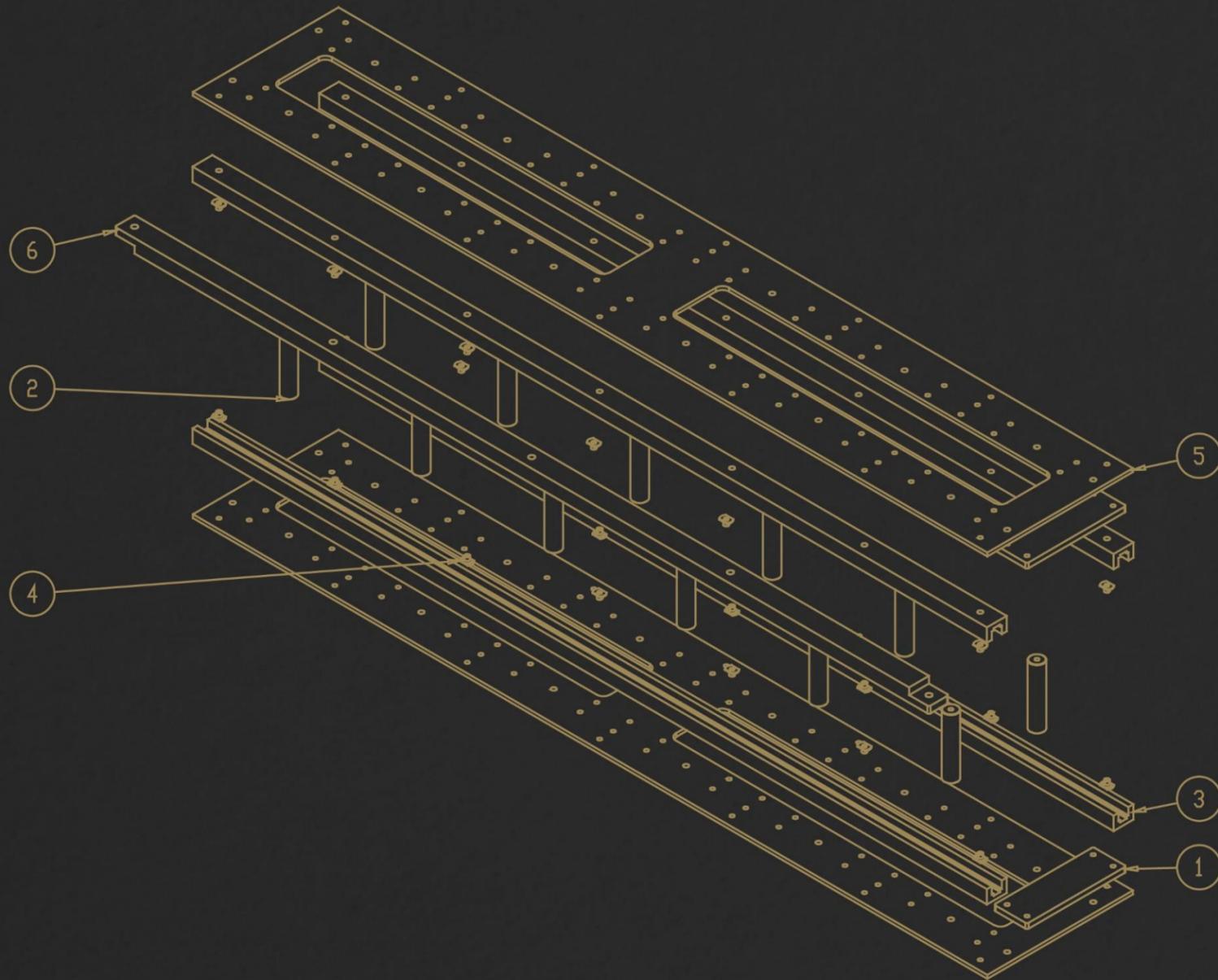


PART NUMBER: TTA30A-01-000
DESCRIPTION: A TILT CONVEYOR 30 EXTENSIO

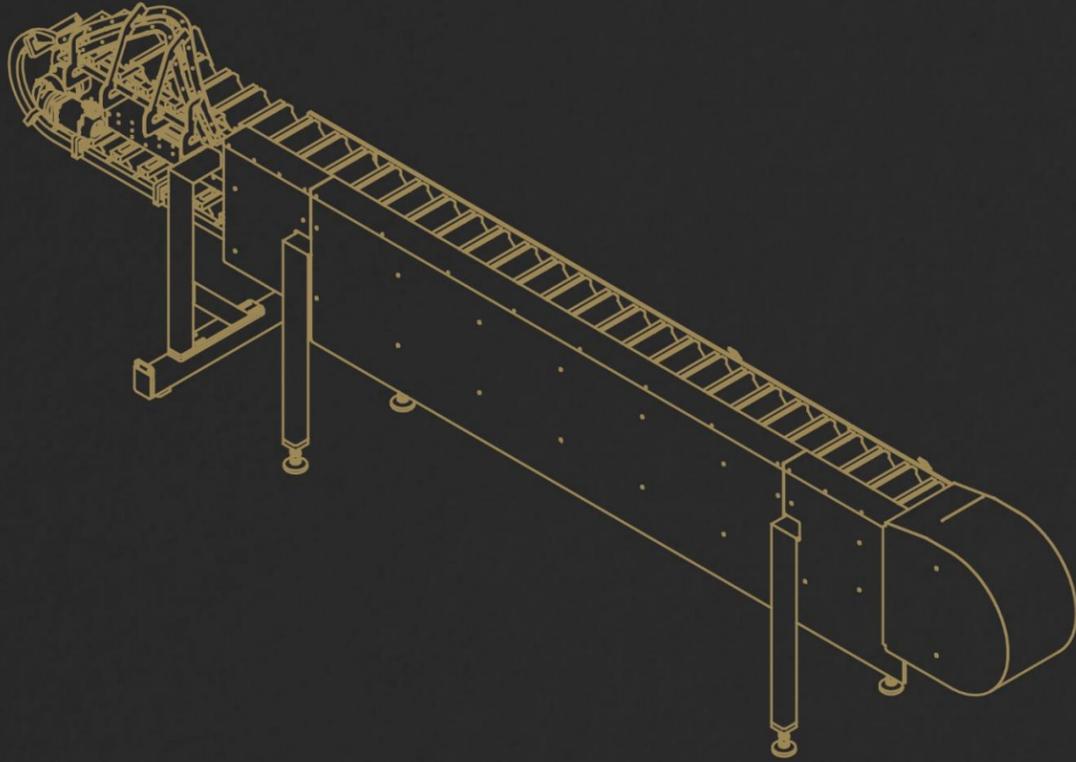
REV.	DESCRIPTION

SHEET SIZE: SCALE: 1/6 Sheet1 OF 1

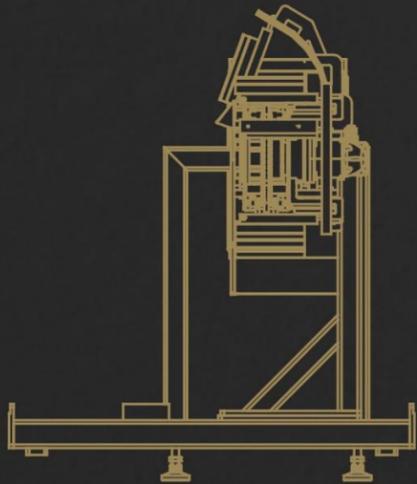
ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	TTA00A-02-002	A TILT CONVEYOR CONNECTION P	2
2	TTA00A-02-003	A TILT CONVEYOR FRAME SPACER	12
3	TTA60A-01-002	EXTENTION CHAIN TRACK	4
4	164008	SLAB BASE	28
5	TTA60A-01-001	A TILT CONVEYOR 60 EXTENSIO	2
6	TTA60A-01-003	CAM 02	1



DESIGNED BY:	LINEAR X ± 0.020 .XX ± 0.010 .XXX ± 0.005	ANGULAR X ± 2° .X ± 1° .XX ± 0° 30'	
DRAWN BY:	<small>THE USE OR DUPLICATION OF THIS DOCUMENT OR ITS CONTENTS WITHOUT THE EXPRESSED WRITTEN CONSENT OF COLBORNE FRODBOTICS, LLC IS STRICTLY PROHIBITED.</small>		
DATE: 12/6/2019			PART NUMBER: TTA60A-01-000
MATERIAL:			DESCRIPTION: A TILT CONVEYOR 30 EXTENSIO
STOCK SIZE:	STOCK NUMBER:	FINISH:	SHEET SIZE
<small>UNLESS OTHERWISE SPECIFIED, BREAK ALL SHARP CORNERS, REMOVE ALL BURRS, AND STAMP OR ETCH PART NO. ON SURFACE.</small>			SCALE: 1:8
REV.	DESCRIPTION	Sheet1 OF 1	

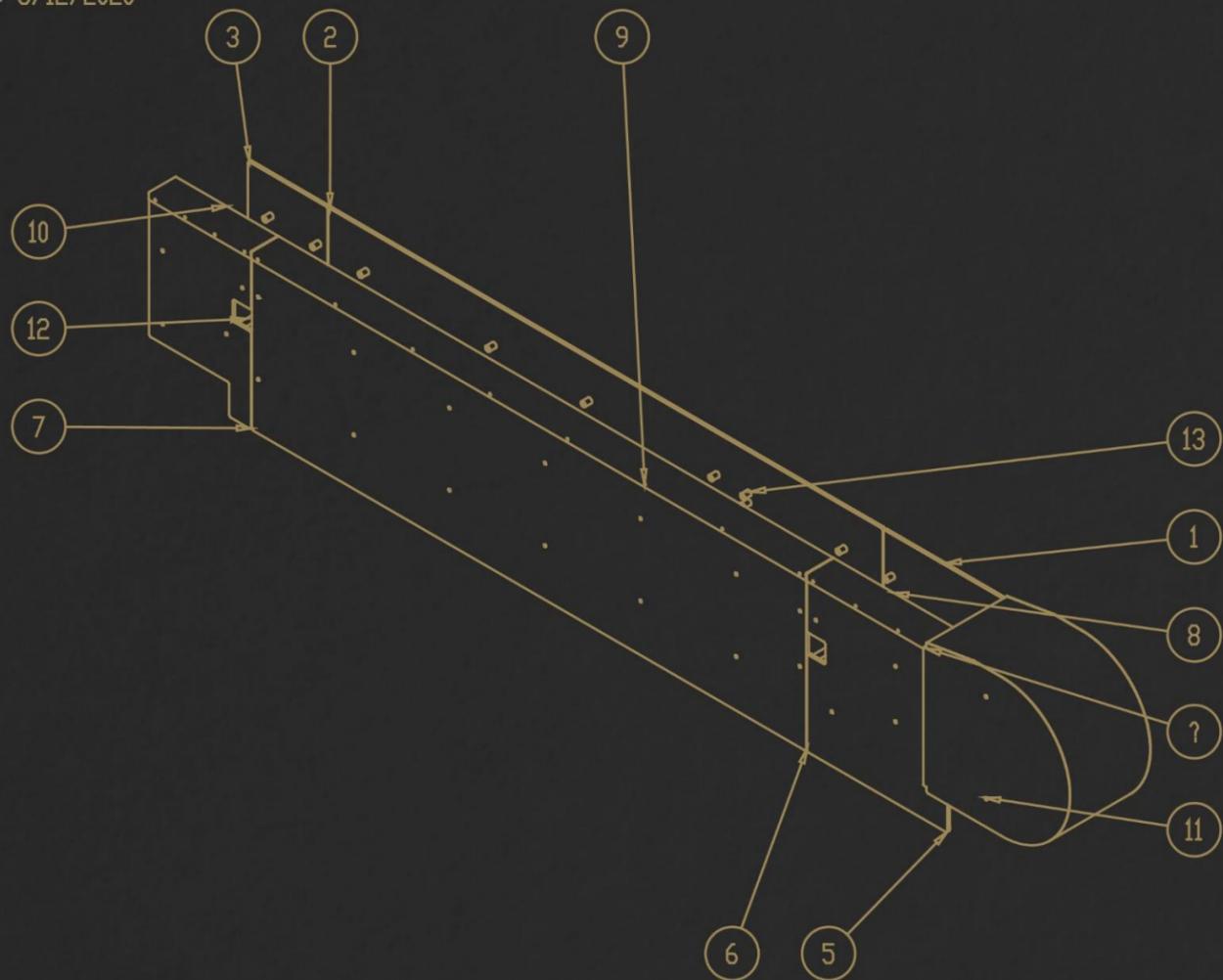


ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	TTA384-01-001	TILT CONVEYOR, BASE	1
2	TTA30A-01-000	A TILT CONVEYOR 30 EXTENSIO	1
3	TTA60A-01-000	A TILT CONVEYOR 30 EXTENSIO	1
4	TTA00A-10-000	TILT TRAY ASSEMBLY	72
5	TTA384-01-000	CHAIN TILT CARRIER ASSY	1
6	TTA384-00-001	CAM RAIL MTG BRKT 3	2
7	TTA384-00-002	CAM RAIL MTG BRKT 2	4
8	TTA384-00-003	CAM RAIL MTG BRKT 1	12
9	TTA384-05-000	CHAIN TILT CONV ASSY	1
10	TTA384-99-001	TILT TRAY POCKET	72
11	TTA384-01-011	TILT TRAY DRIVE ASSY	1
12	TTA384-01-150	TT CAM TRACK ASSY	1
13	VCA384-01-020	LEG KIT	1
14	TTA384-01-004	GUARD KIT	1
15	TTA384-01-124	BRACKET, PROX	2
16	VCA384-01-185	PRODUCT RETAINER EXIT	1
17	VCA384-01-186	PROD RETAINER ENTRANCE	1
18	TTA384-01-101	STANDOFF SPACER 1.00LG	4



DESIGNED BY: JAM	LINEAR .X ± 0.020 .XX ± 0.010 .XXX ± 0.005	ANGULAR X ± 2° X ± 1° .XX ± 0° 30'	
DRAWN BY: JAM	<small>THE USE OR DUPLICATION OF THIS DOCUMENT OR ITS CONTENTS WITHOUT THE EXPRESSED WRITTEN CONSENT OF COLBORNE FOODBOTICS, LLC IS STRICTLY PROHIBITED.</small>		
DATE: 1/3/2020	MATERIAL:	PART NUMBER: TTA384-00-000	
STOCK SIZE:	STOCK NUMBER:	FINISH:	DESCRIPTION: TILT CONVEYOR-384
<small>UNLESS OTHERWISE SPECIFIED BREAK ALL SHARP CORNERS, REMOVE ALL BURRS, AND STAMP OR ETCH PART NO. ON SURFACE</small>			SHEET SIZE: SCALE: 1/20 Sheet 1 OF 1

REV.	DESCRIPTION



ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	TTA384-01-103	TILT TRAY GUARD 1	1
2	TTA384-01-102	TILT TRAY GUARD 2	1
3	TTA384-01-104	TILT TRAY GUARD 3	1
4	TTA384-01-105	CHAIN GUARD COVER	1
5	TTA384-01-113	TILT TRAY GUARD 4	1
6	TTA384-01-112	TILT TRAY GUARD 5	1
7	TTA384-01-114	TILT TRAY GUARD 6	1
8	TTA384-01-109	TOP GUARD 4	1
9	TTA384-01-106	TOP GUARD 5	1
10	TTA384-01-110	TOP GUARD 5	1
11	TTA384-01-108	CHAIN GUARD MOUNT	2
12	TTA384-01-107	STANDOFF SPACER 5.62LG	14
13	TTA384-01-101	STANDOFF SPACER 1.00LG	23
14	TTA384-01-122	GUARD 5 WASHER	2
15	TTA384-01-123	GUARD 6 WASHER	1
16	TTA384-01-121	GUARD 4 WASHER	1
17	TTA384-01-115	STANDOFF SPACER 1.44LG	2

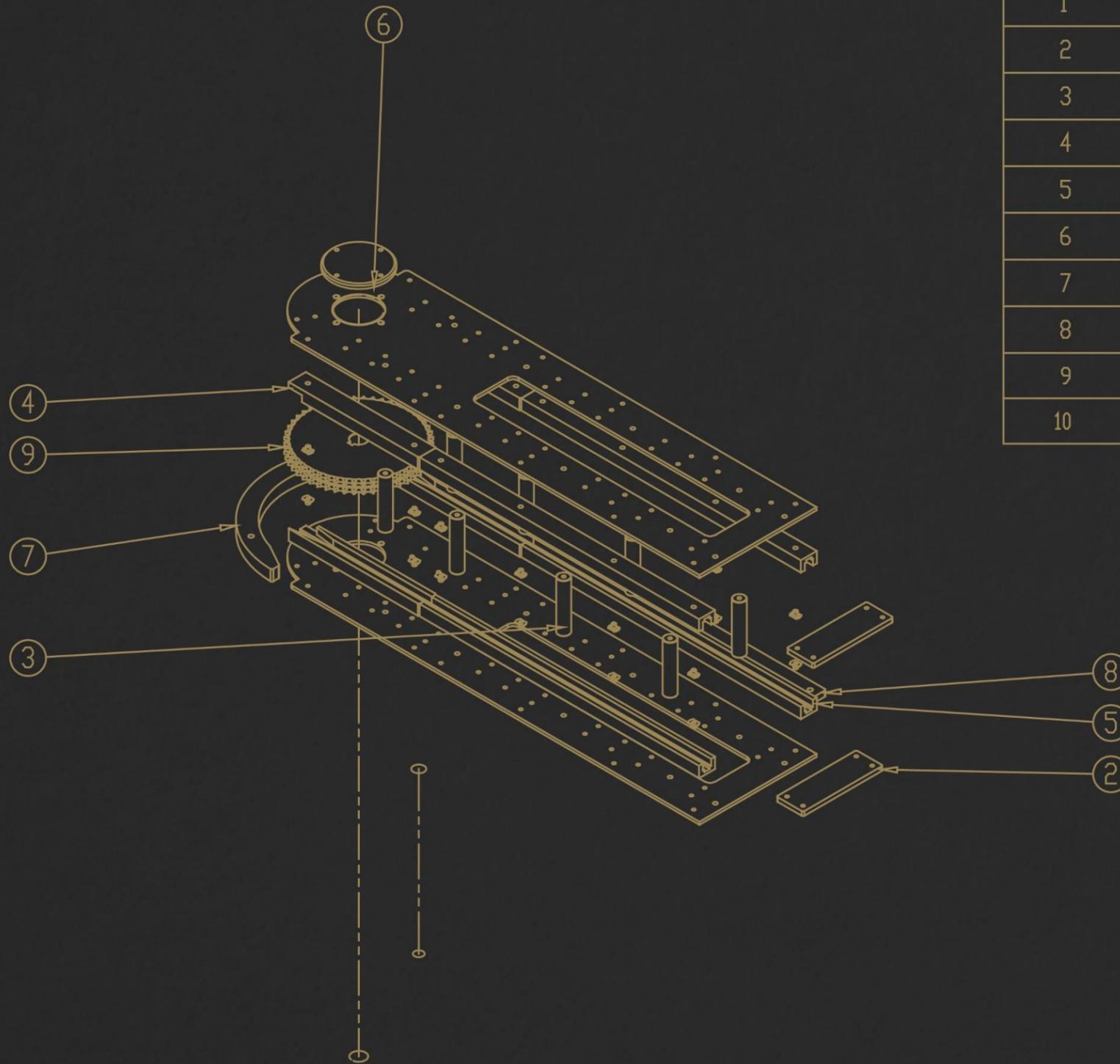


DESIGNED BY: ML	LINEAR .X ± 0.020 .XX ± 0.010 .XXX ± 0.005	ANGULAR X ± 2° X ± 1° .XX ± 0° 30'
DRAWN BY:	THE USE OR DUPLICATION OF THIS DOCUMENT OR ITS CONTENTS WITHOUT THE EXPRESSED WRITTEN CONSENT OF COLBORNE FRODBOTICS, LLC IS STRICTLY PROHIBITED.	
DATE: 3/13/2020		
MATERIAL:		
STOCK SIZE:		
STOCK NUMBER:	FINISH:	
UNLESS OTHERWISE SPECIFIED, BREAK ALL SHARP CORNERS, REMOVE ALL BURRS, AND STAMP OR ETCH PART NO. ON SURFACE.		

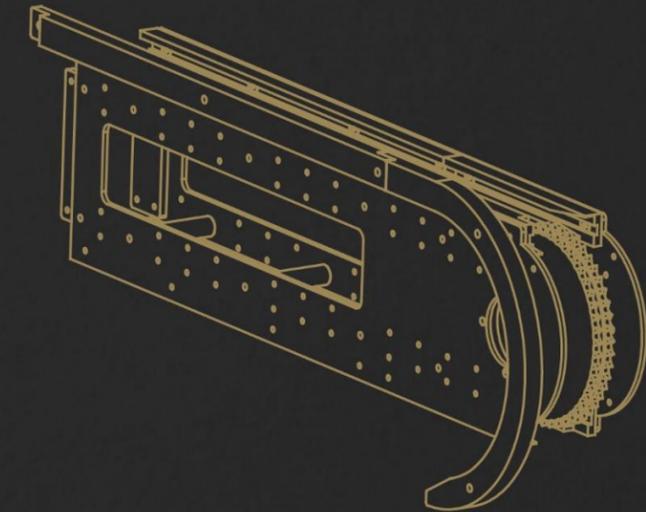


PART NUMBER:	TTA384-01-004	
DESCRIPTION:	GUARD KIT	
SHEET SIZE:	SCALE: 1:20	Sheet1 OF 1

REV.	DESCRIPTION



ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	TTA384-02-101	DRIVE END SIDE PLATE	2
2	TTA00A-02-002	A TILT CONVEYOR CONNECTION P	2
3	TTA00A-02-003	A TILT CONVEYOR FRAME SPACER	8
4	TTA00A-02-004	A TILT CONVEYOR TRACK LEAD E	4
5	TTA00A-02-005	A TILT TRAY CHAIN TRACK	4
6	TTA00A-02-006	BEARING NUT PLATE	1
7	TTA00A-02-007	HOLD-UP CAM 1	1
8	TTA00A-02-008	CAM 02	1
9	TTA384-02-102	SPROCKET, #D50B48, DOUBLE	1
10	164008	SLAB BASE	24



WEIGHT: 85.7 Lbs

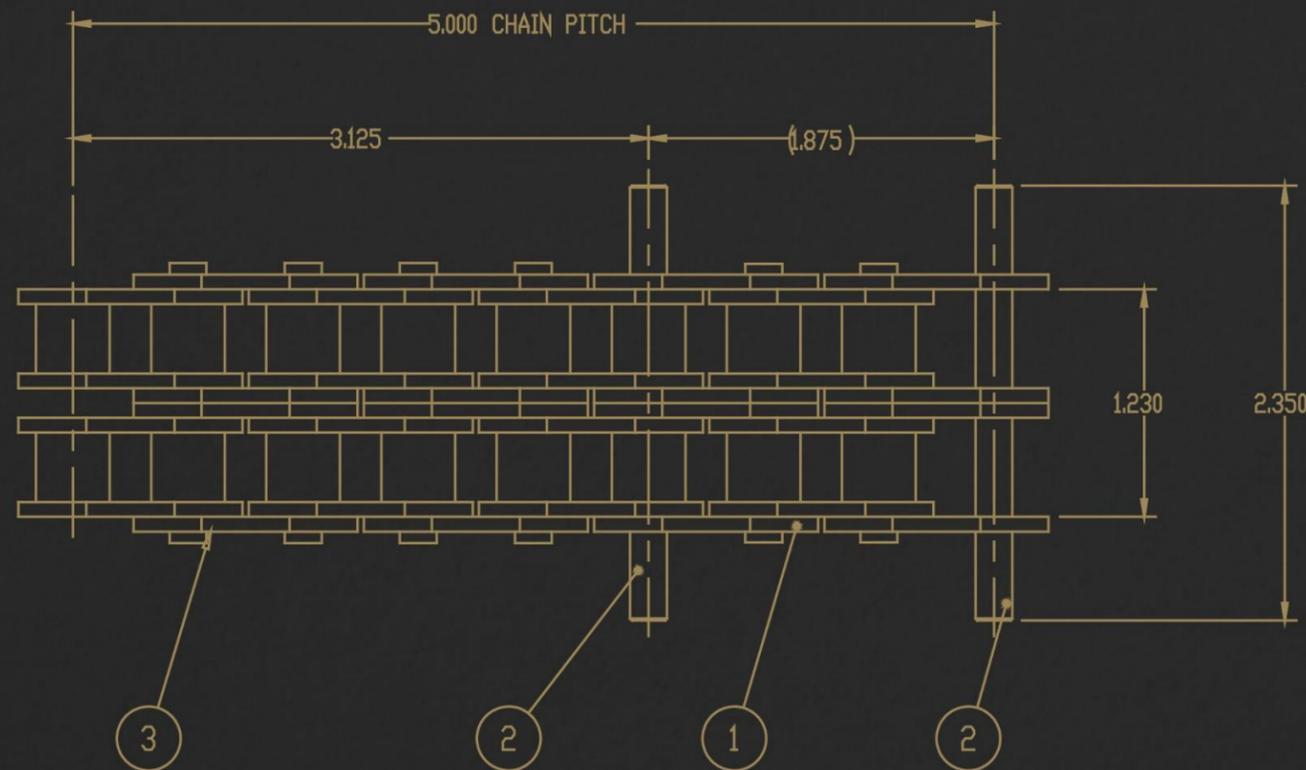
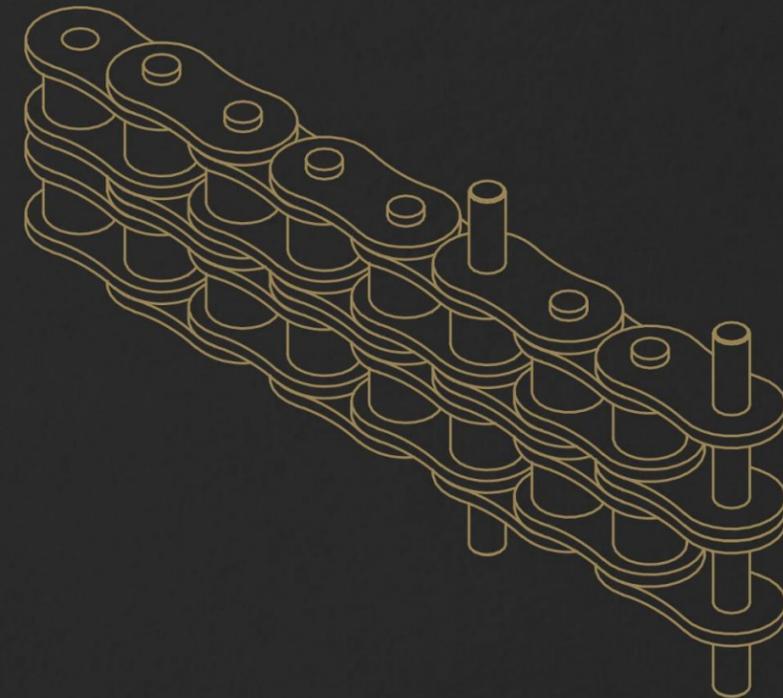
DESIGNED BY:	LINEAR X ± 0.020 .XX ± 0.010 .XXX ± 0.005	ANGULAR X ± 2° .X ± 1° .XX ± 0° 30'	
DRAWN BY:	<small>THE USE OR DUPLICATION OF THIS DOCUMENT OR ITS CONTENTS WITHOUT THE EXPRESSED WRITTEN CONSENT OF COLBORNE FOODBOTICS, LLC IS STRICTLY PROHIBITED.</small>		
DATE: 12/6/2019			
MATERIAL: SEE BOM	PART NUMBER: TTA384-02-000		
STOCK SIZE:	DESCRIPTION: TILT CONVEYOR DRIVE END		
STOCK NUMBER:	FINISH:	SHEET SIZE:	SCALE: 1:9
<small>UNLESS OTHERWISE SPECIFIED, BREAK ALL SHARP CORNERS, REMOVE ALL BURRS, AND STAMP OR ETCH PART NO. ON SURFACE.</small>		Sheet1 OF 1	

REV.	DESCRIPTION

ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	YMP000-05-102	CHAIN SECTION 1.875 IN DUAL STRAND #50 NP	72
2	YMP000-05-100	"A" CARRIER CHAIN PIN	144
3	YMP000-05-104	CHAIN SECT 3.125 IN DUAL STRAND #50 NP	72
4	164298	50-2 NP CONNECTING LINK	1



SECTION A-A
SCALE 1 : 12



DETAIL B
SCALE 1 : 1

MFG NOTES:

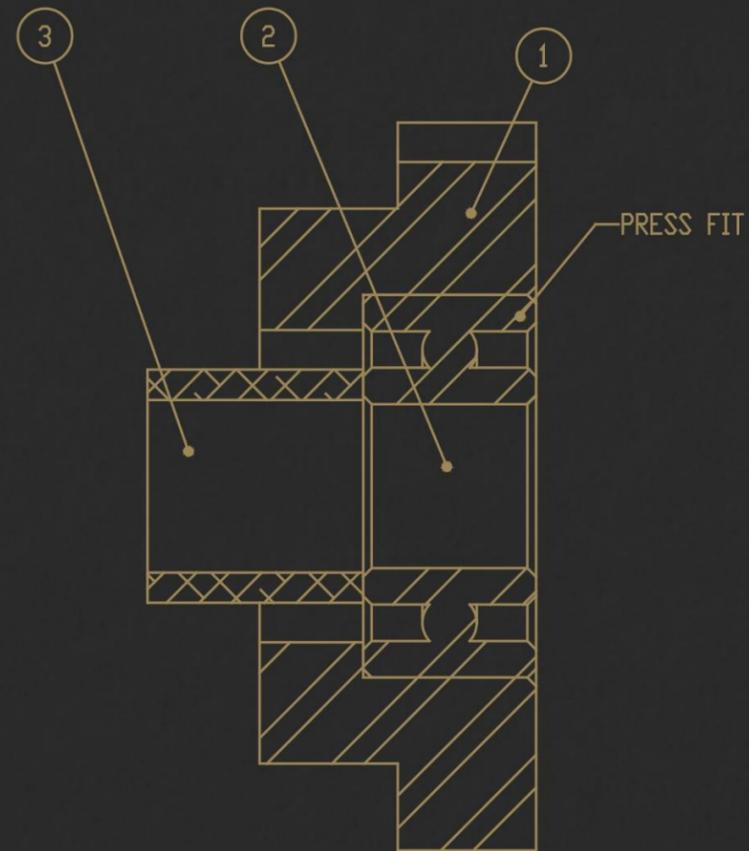
- 1) TSUBAKI CHAIN RS50-2NP
- 2) #50 DOUBLE STRAND NICKEL PLATED, 5/8 PITCH
- 3) CHAIN LENGTH 360.00" LG WITH SINGLE MASTER LINK IN 1.875" SECTION OF CHAIN

DESIGNED BY: JAM	LINEAR X ± 0.020 .XX ± 0.010 .XXX ± 0.005	ANGULAR X ± 2° .X ± 1' .XX ± 0° 30'
DRAWN BY: ML	THE USE OR DUPLICATION OF THIS DOCUMENT OR ITS CONTENTS WITHOUT THE EXPRESSED WRITTEN CONSENT OF COLBORNE FOODBOTICS, LLC IS STRICTLY PROHIBITED.	
DATE: 1/10/2020		
MATERIAL:	UNLESS OTHERWISE SPECIFIED, BREAK ALL SHARP CORNERS, REMOVE ALL BURRS, AND STAMP OR ETCH PART NO. ON SURFACE.	

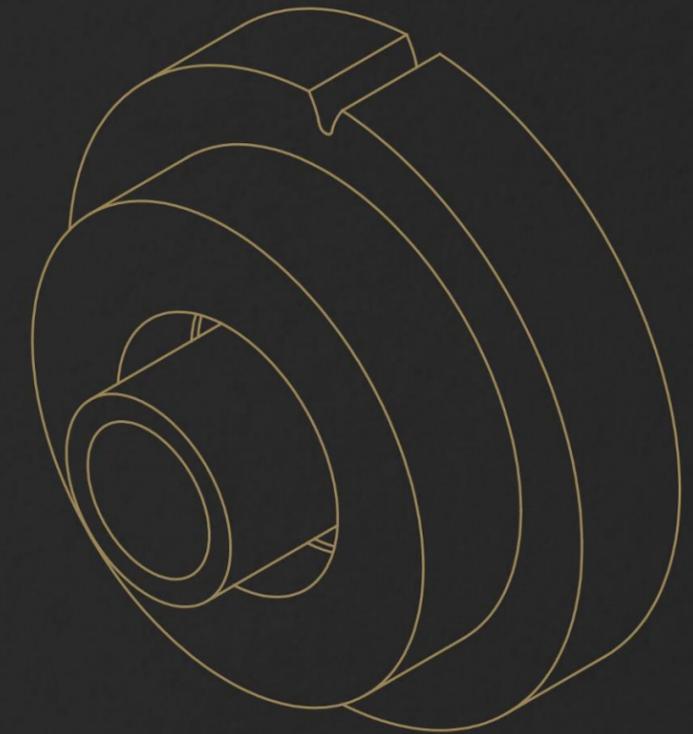


PART NUMBER: TTA384-05-000		
DESCRIPTION: CHAIN TILT CONV ASSY		
SHEET SIZE	SCALE: 1/16	Sheet 1 OF 1

ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	VCA00A-03-105	SPUR GEAR - 16 DP	1
2	164014	15MM BALL BEARING DOUBLE ROW	1
3	VCA00A-03-106	IDLER GEAR SPACER	1

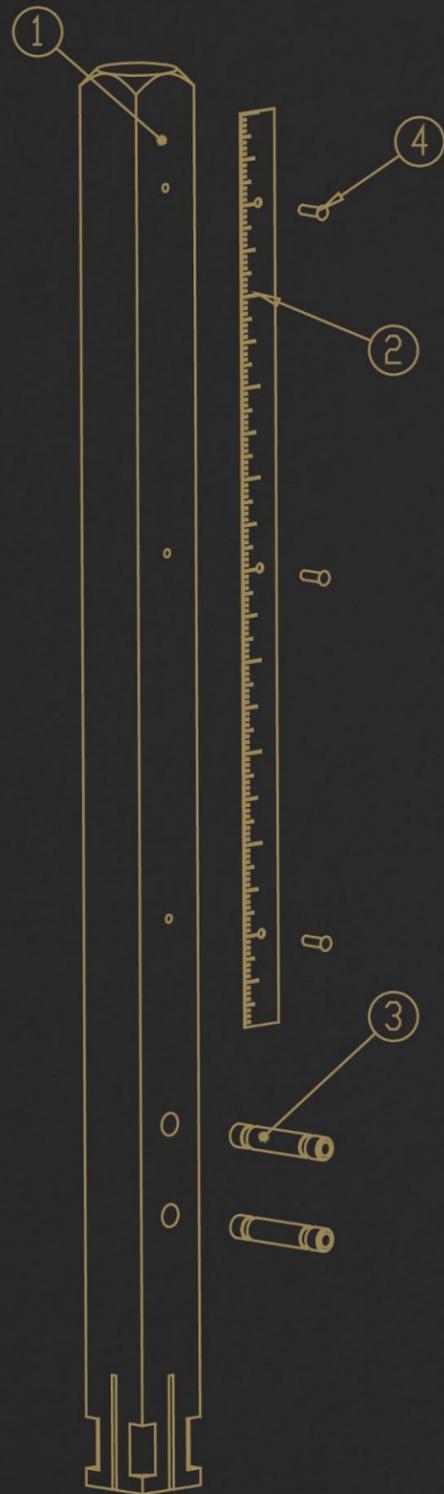


SECTION A-A



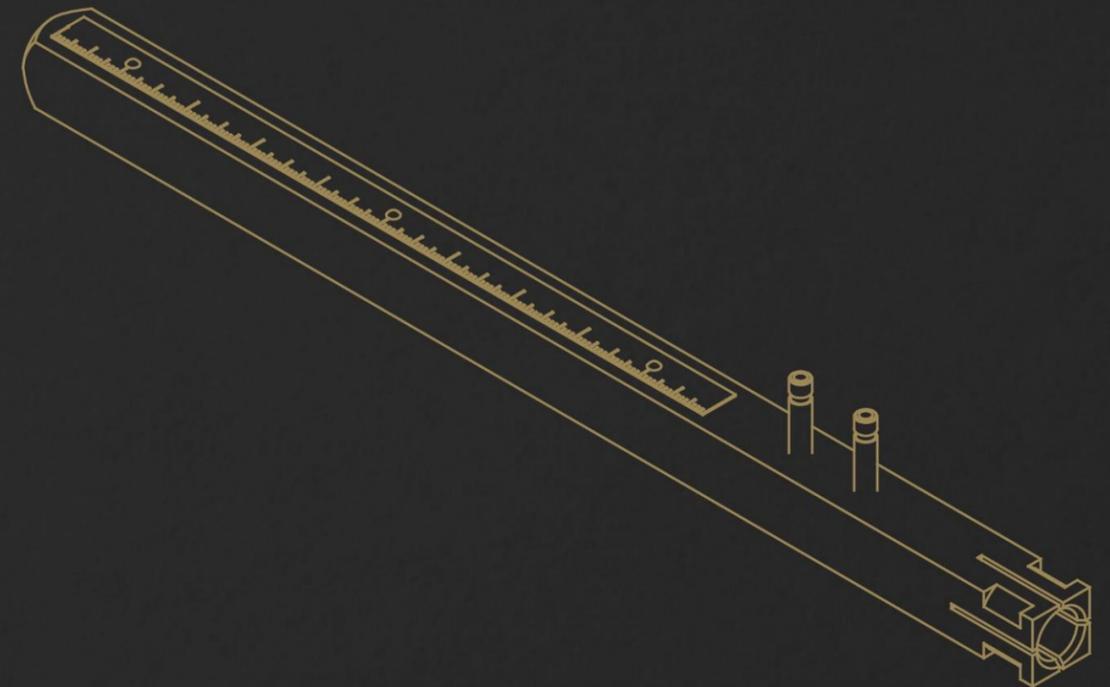
DESIGNED BY:	LINEAR X ± 0.020 .XX ± 0.010 .XXX ± 0.005	ANGULAR X ± 2° .X ± 1' .XX ± 0° 30'	
DRAWN BY: DD	<small>THE USE OR DUPLICATION OF THIS DOCUMENT OR ITS CONTENTS WITHOUT THE EXPRESSED WRITTEN CONSENT OF COLBORNE FOODBOTICS, LLC IS STRICTLY PROHIBITED.</small>		
DATE: 12/11/2019	MATERIAL:	STOCK SIZE:	PART NUMBER: VCA00A-03-104
	STOCK NUMBER:	FINISH:	DESCRIPTION: ROTARY GEAR ASSY
	<small>UNLESS OTHERWISE SPECIFIED, BREAK ALL SHARP CORNERS, REMOVE ALL BURRS, AND STAMP OR ETCH PART NO. ON SURFACE.</small>		SHEET SIZE: SCALE: 1.5:1 Sheet 1 OF 1

REV.	DESCRIPTION



ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	VCA00A-03-114	ARM SUCTION PIPE	1
2	VCA00A-03-115	STEEL RULES SCALE 10	1
3	164068	SUCTION PIPE STEM	2
4	163449	SCREW NAIL #2 X .31"LG SS	3

A



WEIGHT: 1.1 Lbs

REV.	DESCRIPTION	ML	DATE	DCR NO.
A	ADDED SCREW NAILS #2 X .31" LG SS18-8	ML	3/27/2020	

DESIGNED BY:	LINEAR X ± 0.020 .XX ± 0.010 .XXX ± 0.005	ANGULAR X ± 2° .X ± 1° .XX ± 0° 30'
DRAWN BY:	THE USE OR DUPLICATION OF THIS DOCUMENT OR ITS CONTENTS WITHOUT THE EXPRESSED WRITTEN CONSENT OF COLBORNE FIDBOTICS, LLC IS STRICTLY PROHIBITED.	
DATE:	12/15/2019	
MATERIAL:		
STOCK SIZE:		
STOCK NUMBER:	FINISH:	
UNLESS OTHERWISE SPECIFIED, BREAK ALL SHARP CORNERS, REMOVE ALL BURRS, AND STAMP OR ETCH PART NO. ON SURFACE.		

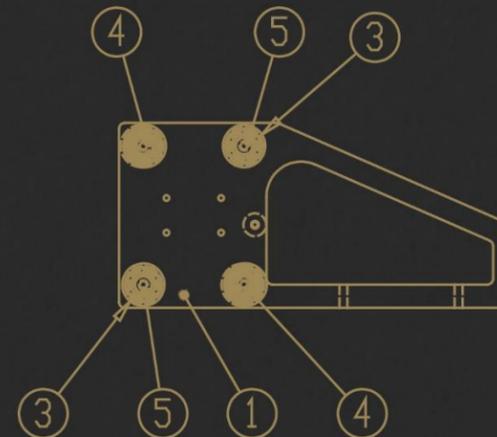
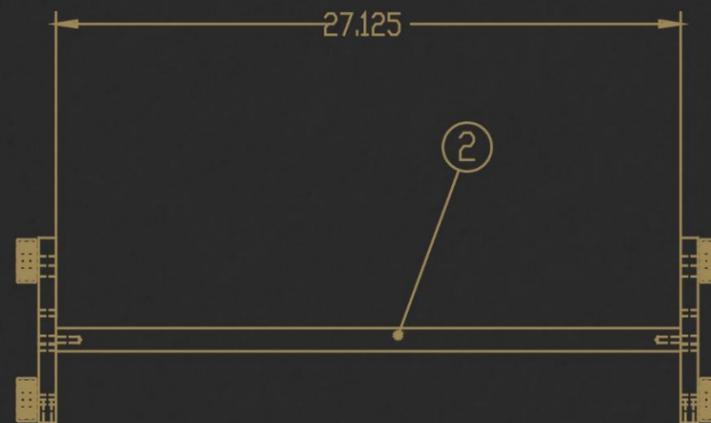
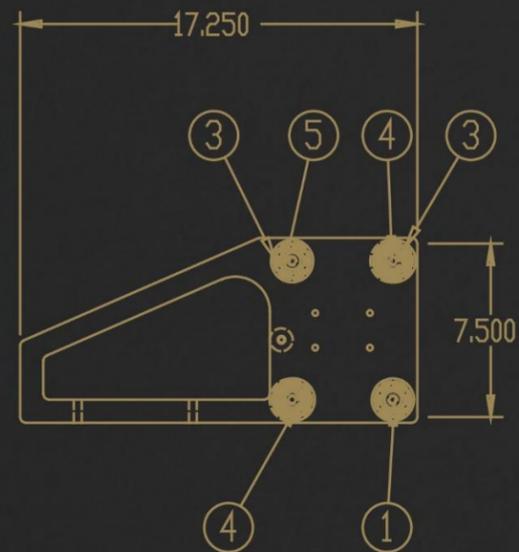
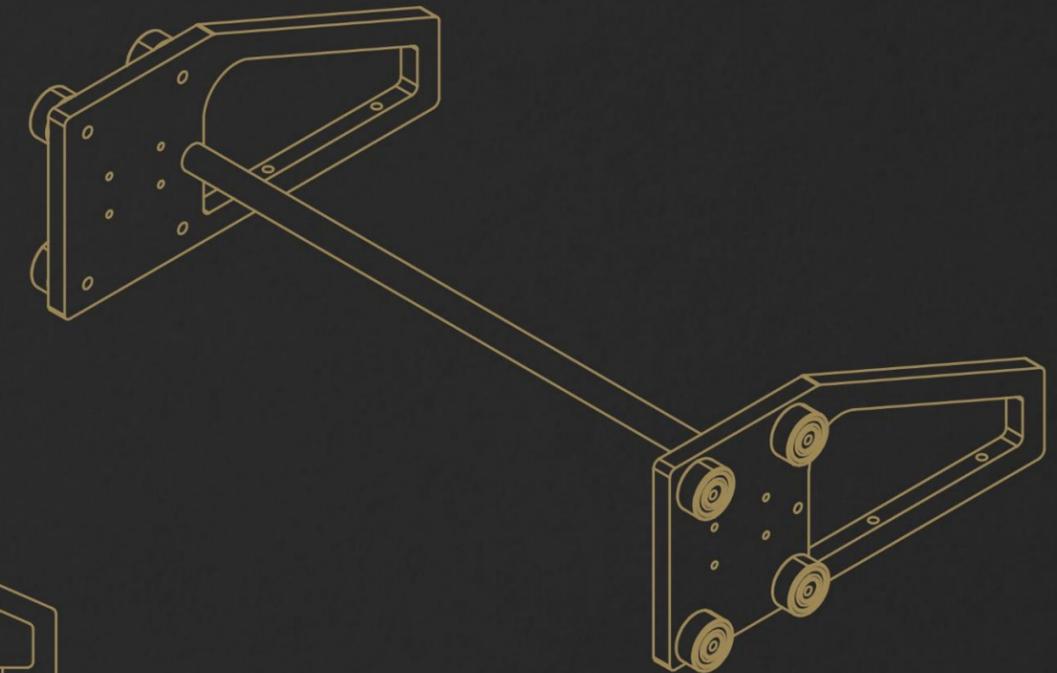


PART NUMBER: VCA00A-03-113

DESCRIPTION: ROD INFEED

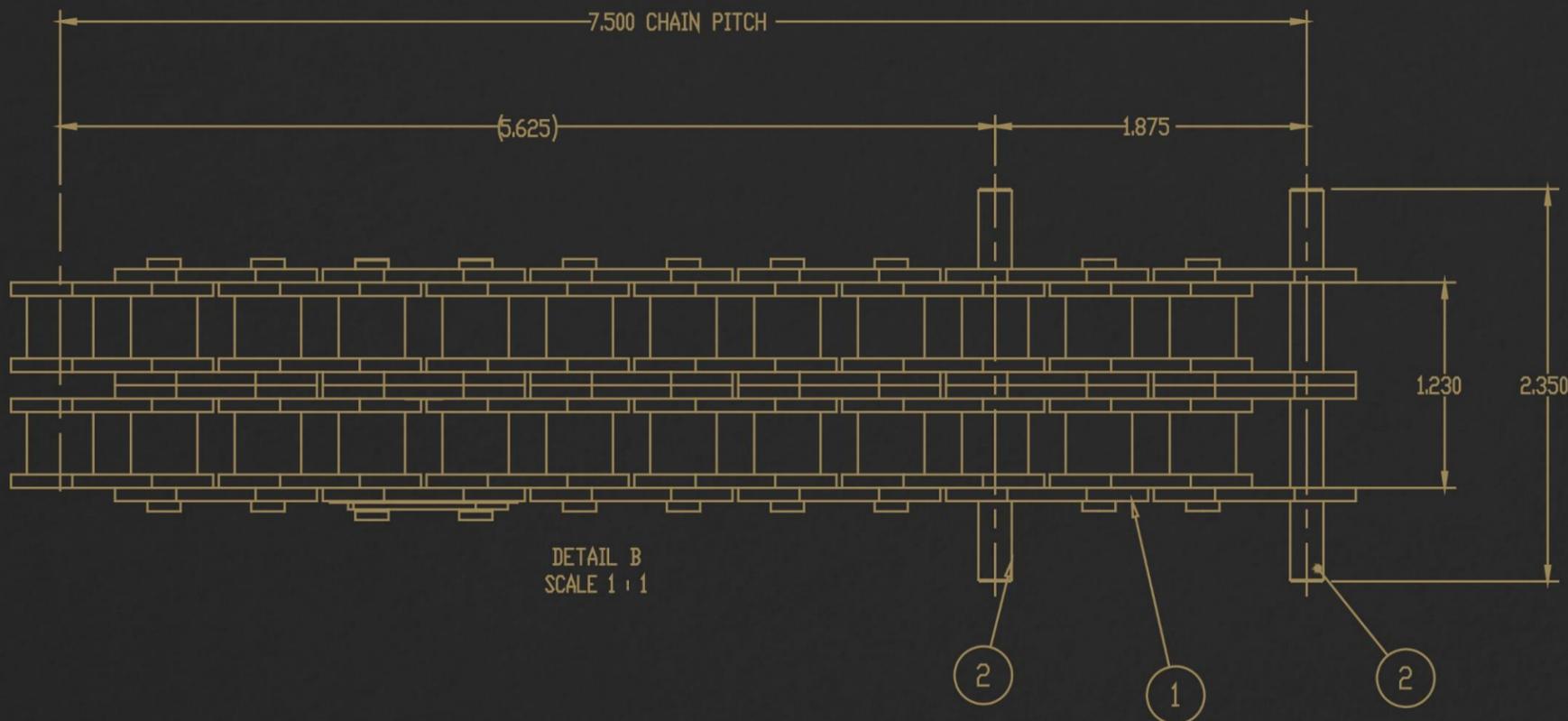
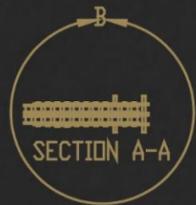
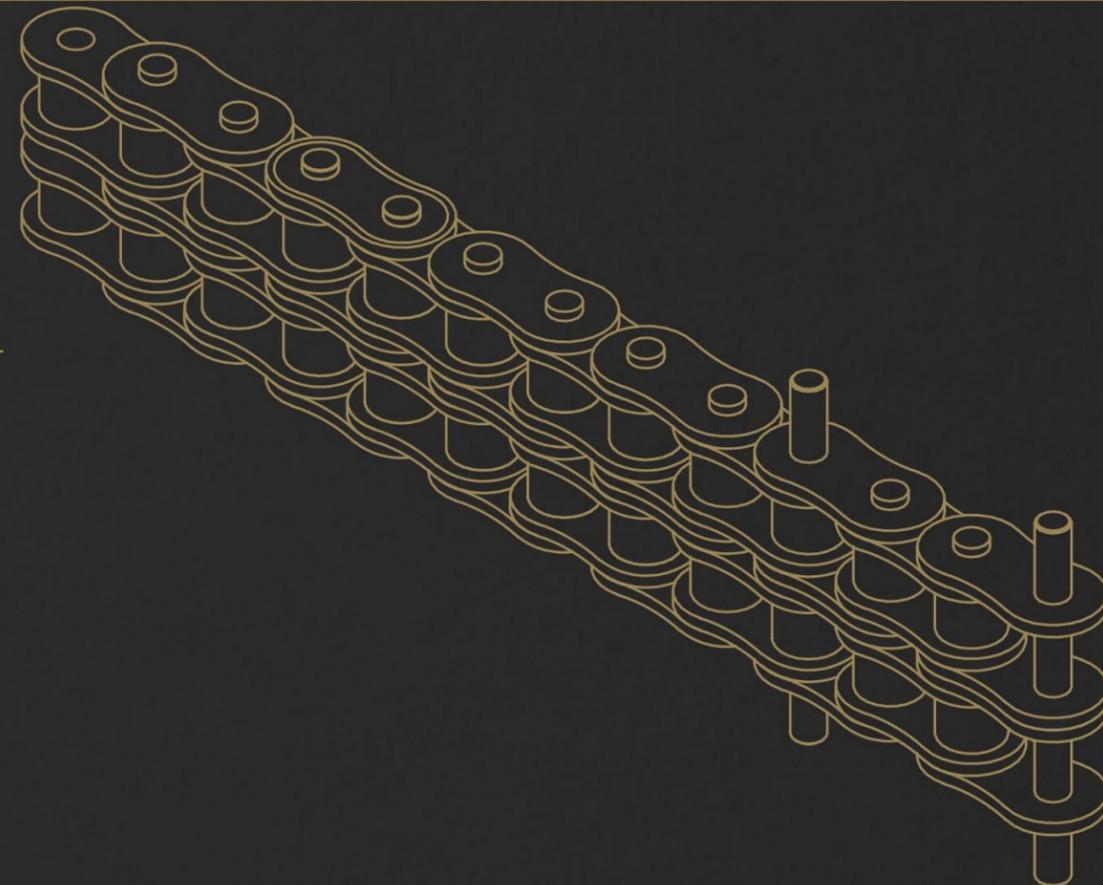
SHEET SIZE: SCALE: 1/2 Sheet 1 OF 1

ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	YMP000-04-100	RAIL MOUNT	2
2	VCA00A-04-110	TIE-BAR	1
3	163730	BEARING BALL 20MMID	8
4	YMP000-04-101	BEARING SHAFT - ECCENTRIC	4
5	YMP000-04-102	BEARING SHAFT	4



DESIGNED BY: DD	LINEAR X ± 0.020 .XX ± 0.010 .XXX ± 0.005	ANGULAR X ± 2° .X ± 1° .XX ± 0° 30'	
DRAWN BY: TN	<small>THE USE OR DUPLICATION OF THIS DOCUMENT OR ITS CONTENTS WITHOUT THE EXPRESSED WRITTEN CONSENT OF COLBORNE FOODBOTICS, LLC IS STRICTLY PROHIBITED.</small>		
DATE:			
MATERIAL:			PART NUMBER: VCA00A-04-109
STOCK SIZE:			DESCRIPTION: MAGAZINE CARRIAGE
STOCK NUMBER:	FINISH:		
<small>UNLESS OTHERWISE SPECIFIED, BREAK ALL SHARP CORNERS, REMOVE ALL BURRS, AND STAMP OR ETCH PART NO. ON SURFACE.</small>			SHEET SIZE: SCALE: 1/6 Sheet 1 OF 1

ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	YMP000-05-102	CHAIN SECTION 1.875 IN DUAL STRAND #50 NP	32
2	YMP000-05-100	"A" CARRIER CHAIN PIN	64
3	YMP000-05-101	CHAIN SECTION 5.625 IN DUAL STRAND #50 NP	32
4	164298	50-2 NP CONNECTING LINK	1



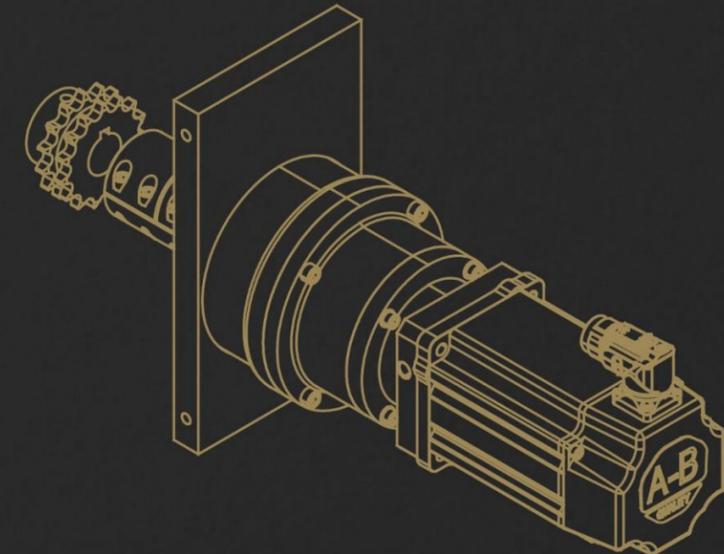
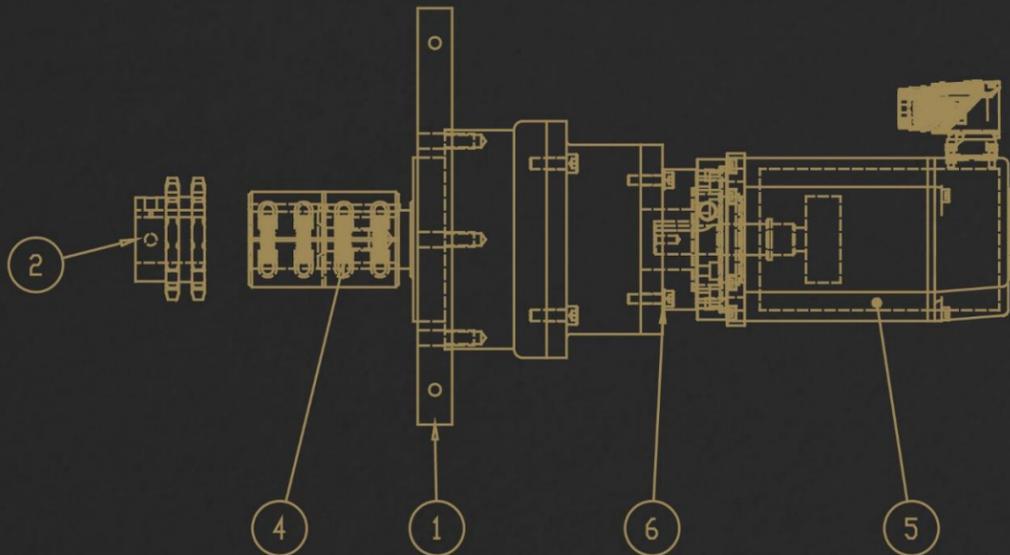
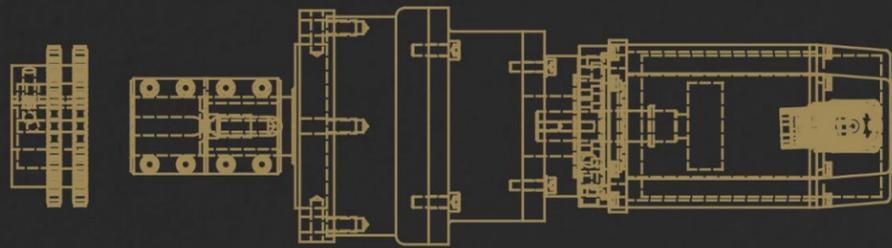
DETAIL B
SCALE 1 : 1

MFG NOTES:

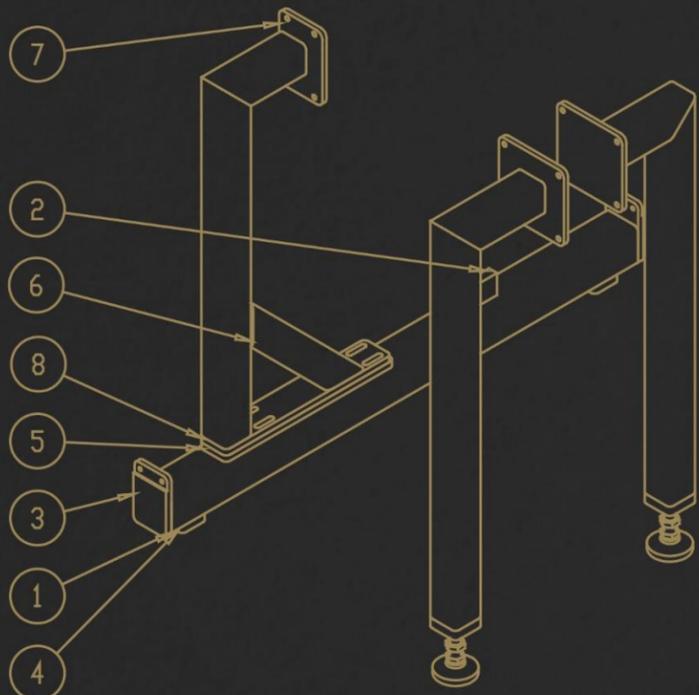
- 1) TSUBAKI CHAIN RS50-2NP
- 2) #50 DOUBLE STRAND NICKEL PLATED, 5/8 PITCH
- 3) CHAIN LENGTH 240.00" LG WITH SINGLE MASTER LINK IN 5.625" SECTION OF CHAIN

DESIGNED BY: ML	LINEAR .X ± 0.020 .XX ± 0.010 .XXX ± 0.005	ANGULAR X ± 2° .X ± 1' .XX ± 0° 30'	
DRAWN BY: ML	<small>THE USE OR DUPLICATION OF THIS DOCUMENT OR ITS CONTENTS WITHOUT THE EXPRESSED WRITTEN CONSENT OF COLBORNE FOODBOTICS, LLC IS STRICTLY PROHIBITED.</small>		
DATE: 1/10/2020	MATERIAL:		PART NUMBER: VCA00A-05-001
STOCK SIZE:		FINISH:	DESCRIPTION: CARTONER CHAIN ASSY
<small>UNLESS OTHERWISE SPECIFIED, BREAK ALL SHARP CORNERS, REMOVE ALL BURRS, AND STAMP OR ETCH PART NO. ON SURFACE</small>			SHEET SIZE: SCALE: 1/2 Sheet 1 OF 1

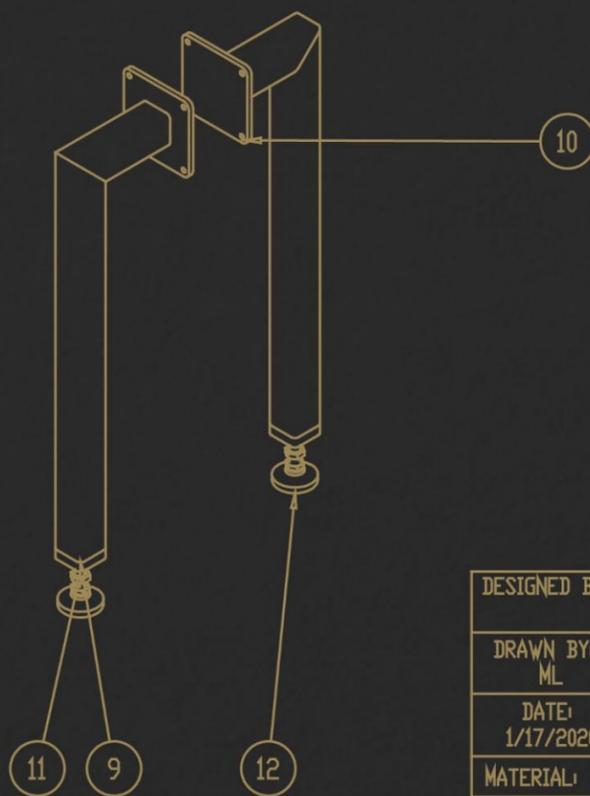
ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	VCA384-01-012	GEARBOX MOUNT PLATE	1
2	VCA384-01-016	GEAR #40 15T 1.00" BORE DUAL STRAND	1
3	VCA384-01-014	GEAR #40 20 TEETH 1.0 BORE	1
4	VCA384-01-015	COUPLING 32MM DIA TO 1.00 DIA RIGID 2-PC STEEL W/KEYWAYS	1
5	164194	SERVO MOTOR VPL 1.6KW 100MM BOLT CIRCLE 5000RPM 2 STACK W/ENCODER	1
6	164197	GEARBOX SERVO 20:1 32MM OUTPUT SHAFT	1



DESIGNED BY: ML	LINEAR .X ± 0.020 .XX ± 0.010 .XXX ± 0.005	ANGULAR X ± 2° .X ± 1° .XX ± 0° 30'	
DRAWN BY: ML	<small>THE USE OR DUPLICATION OF THIS DOCUMENT OR ITS CONTENTS WITHOUT THE EXPRESSED WRITTEN CONSENT OF COLBORNE FRODBOTICS, LLC IS STRICTLY PROHIBITED.</small>		
DATE: 1/16/2020	MATERIAL:		PART NUMBER: VCA384-01-011
	STOCK SIZE:		DESCRIPTION: VCA SERVO DRIVE ASSY
	STOCK NUMBER:	FINISH:	SHEET SIZE
	<small>UNLESS OTHERWISE SPECIFIED, BREAK ALL SHARP CORNERS, REMOVE ALL BURRS, AND STAMP OR ETCH PART NO. ON SURFACE.</small>		SCALE: 1:4
REV.	DESCRIPTION		Sheet1 OF 1



ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	VCA384-01-031	LEG TUBE #1	1
2	01225384	SIDE MOUNTING PLATE	1
3	01228384	LEGS END PLATE	2
4	01226384	FOOT PAD MOUNTING PLATE	2
5	VCA384-01-033	MOUNT PAD	1
6	VCA384-01-041	LEG SUPPORT WELDMNT	1
7	VCA384-01-043	MOUNT PAD	1
8	VCA384-01-042	BASE MOUNT PAD	1
9	VCA384-01-051	LEG TUBE WELDMNT	4
10	VCA384-01-052	MOUNT PAD	4
11	VCA384-01-053	FOOT MOUNT	4
12	163727	SWIVEL FOOT PAD	4



DESIGNED BY:	LINEAR X ± 0.020 .XX ± 0.010 .XXX ± 0.005	ANGULAR X ± 2° .X ± 1° .XX ± 0° 30'
DRAWN BY:	ML	
DATE:	1/17/2020	
<small>THE USE OR DUPLICATION OF THIS DOCUMENT OR ITS CONTENTS WITHOUT THE EXPRESSED WRITTEN CONSENT OF COLBORNE FRODBOTICS, LLC IS STRICTLY PROHIBITED.</small>		
MATERIAL:		
STOCK SIZE:		
STOCK NUMBER:	FINISH: MILL	
<small>UNLESS OTHERWISE SPECIFIED, BREAK ALL SHARP CORNERS, REMOVE ALL BURRS, AND STAMP OR ETCH PART NO. ON SURFACE.</small>		

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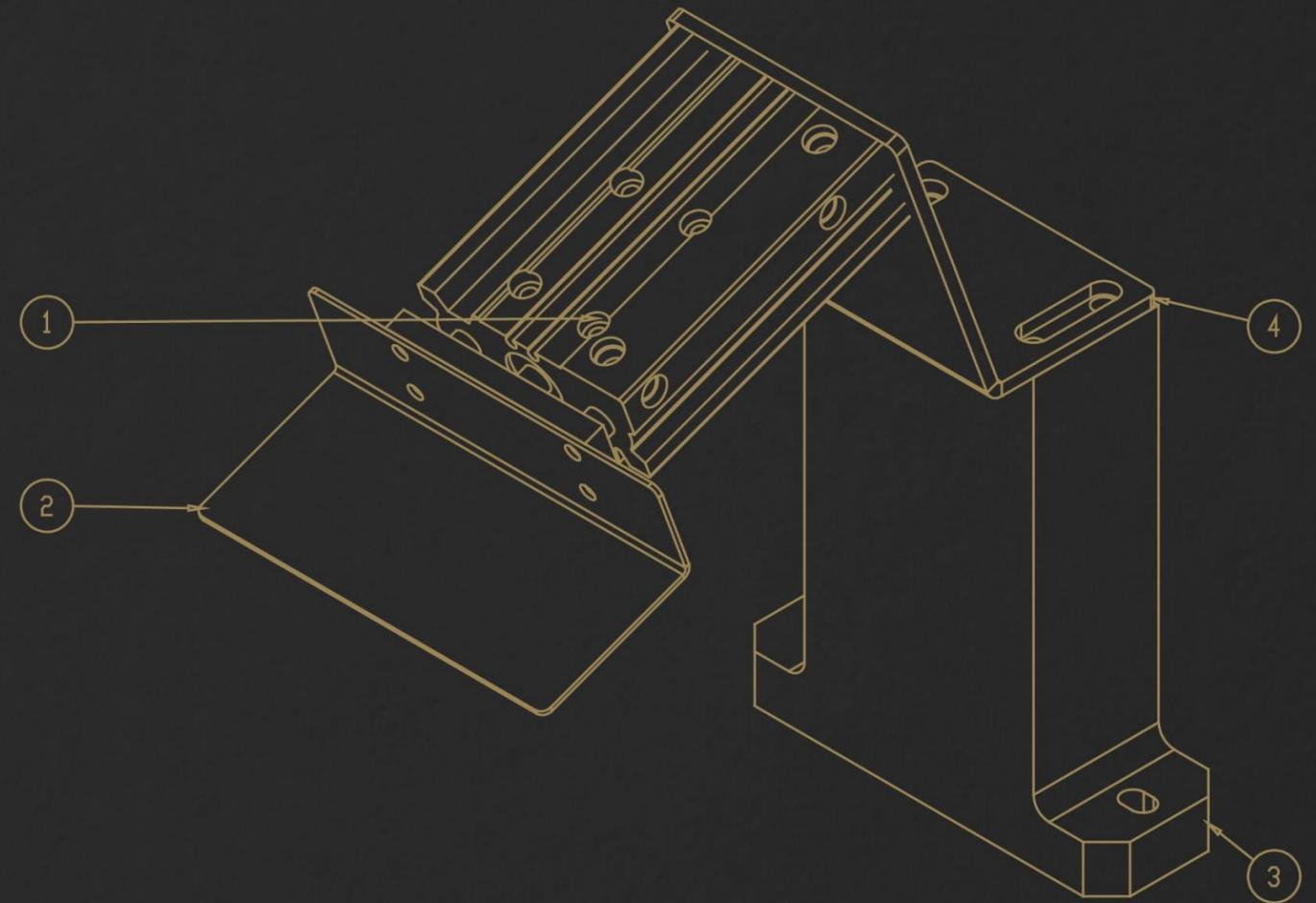
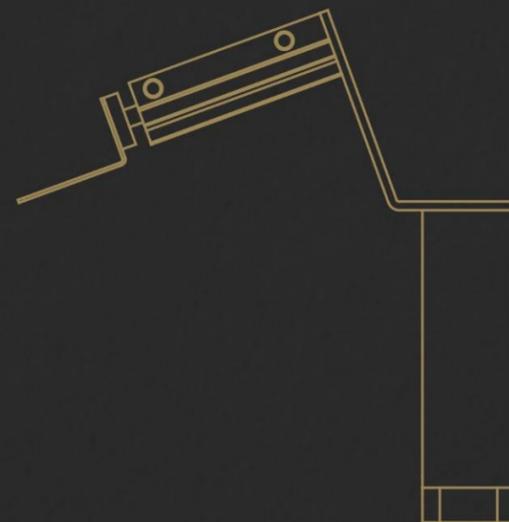
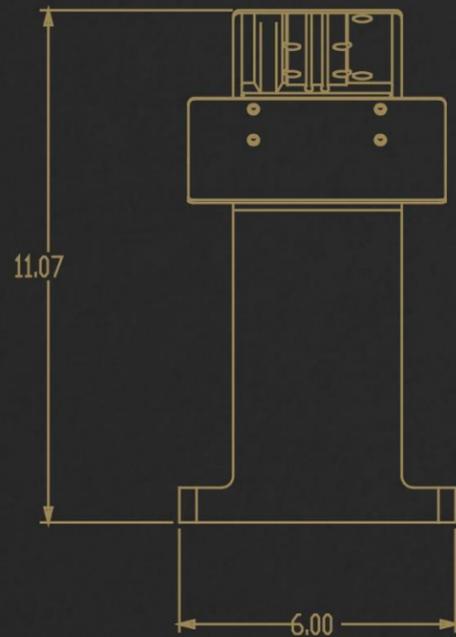
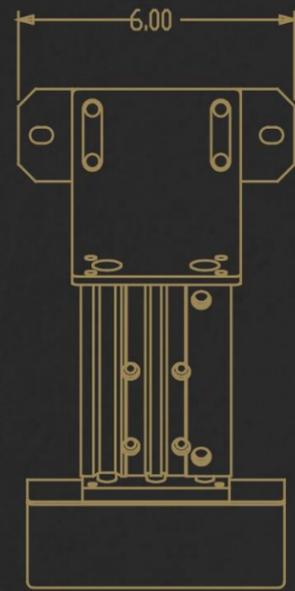
PART NUMBER: VCA384-01-020

DESCRIPTION: LEG KIT

SHEET SIZE: SCALE: 1/2 Sheet 1 OF 1

REV.	DESCRIPTION

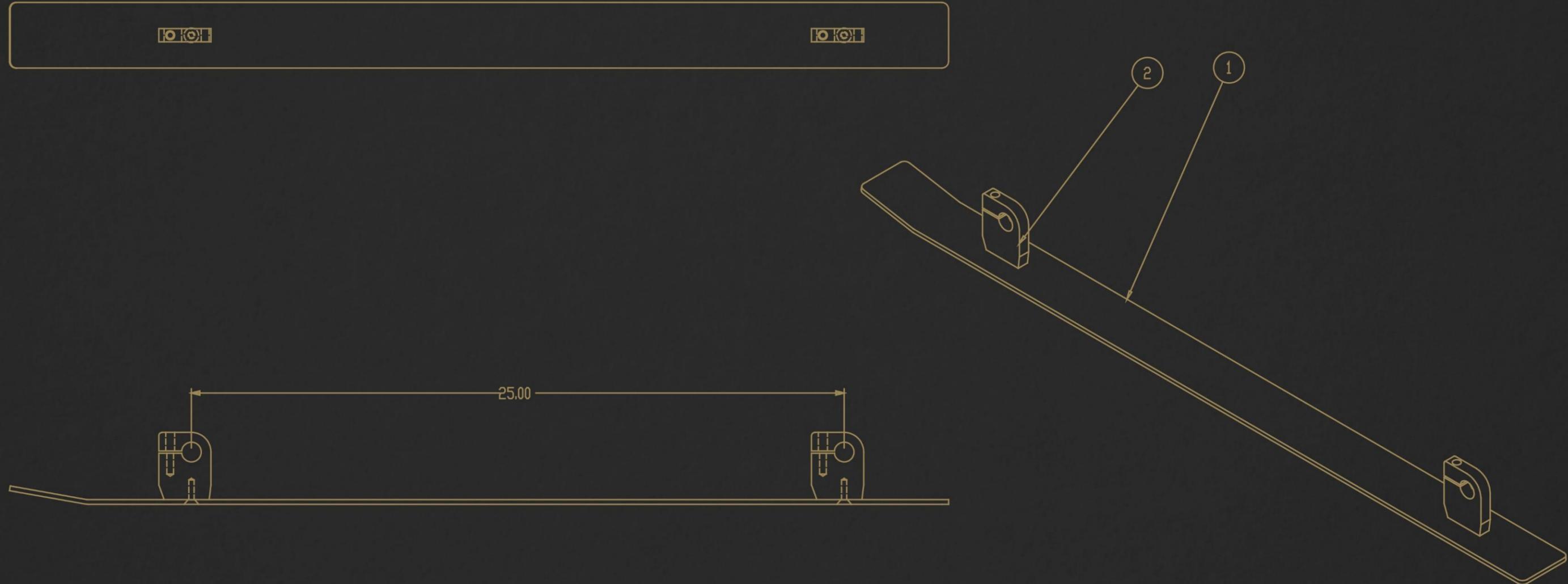
ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	164279	LINEAR GUIDED CYLINDER 20MM BORE X 50MM STROKE	1
2	VCA384-01-121	TRAY ESCAPEMENT GATE	1
3	VCA384-01-123	ESCAPEMENT MOUNT	1
4	VCA384-01-122	ESCAPEMENT BRACKET	1



DESIGNED BY: ML	LINEAR X ± 0.020 .XX ± 0.010 .XXX ± 0.005	ANGULAR X ± 2° .X ± 1° .XX ± 0° 30'	
DRAWN BY: ML	<small>THE USE OR DUPLICATION OF THIS DOCUMENT OR ITS CONTENTS WITHOUT THE EXPRESSED WRITTEN CONSENT OF COLBORNE FRODBOTICS, LLC IS STRICTLY PROHIBITED.</small>		
DATE: 1/29/2020	MATERIAL:		PART NUMBER: VCA384-01-120
	STOCK SIZE:		DESCRIPTION: ESCAPEMENT ASSY
	STOCK NUMBER:	FINISH:	SHEET SIZE
	<small>UNLESS OTHERWISE SPECIFIED, BREAK ALL SHARP CORNERS, REMOVE ALL BURRS, AND STAMP OR ETCH PART NO. ON SURFACE.</small>		SCALE: 1:4
			Sheet1 OF 1

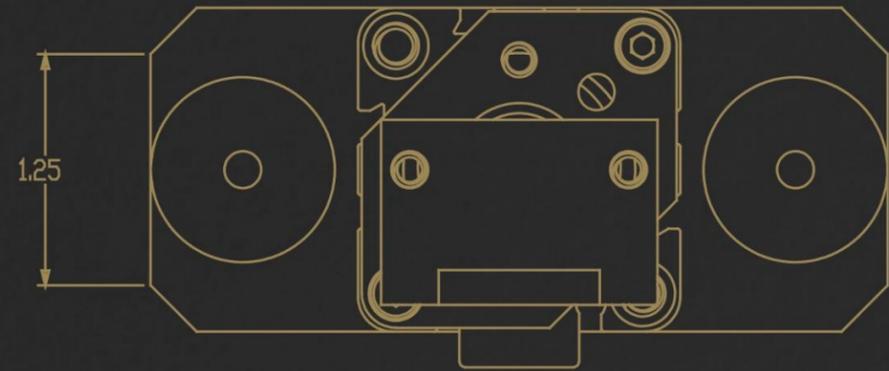
REV.	DESCRIPTION

ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	VCA384-01-137	FLARE PLATE-INFEED SIDE-UPPER-	1
2	VCA384-01-138	CLAMP FLAIR	2

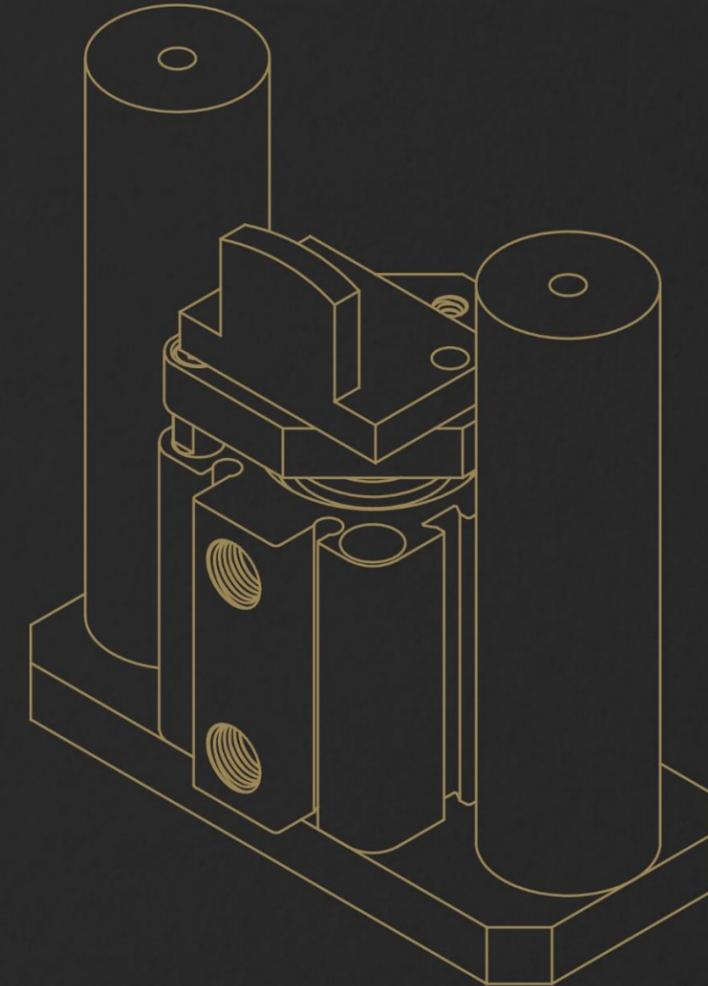
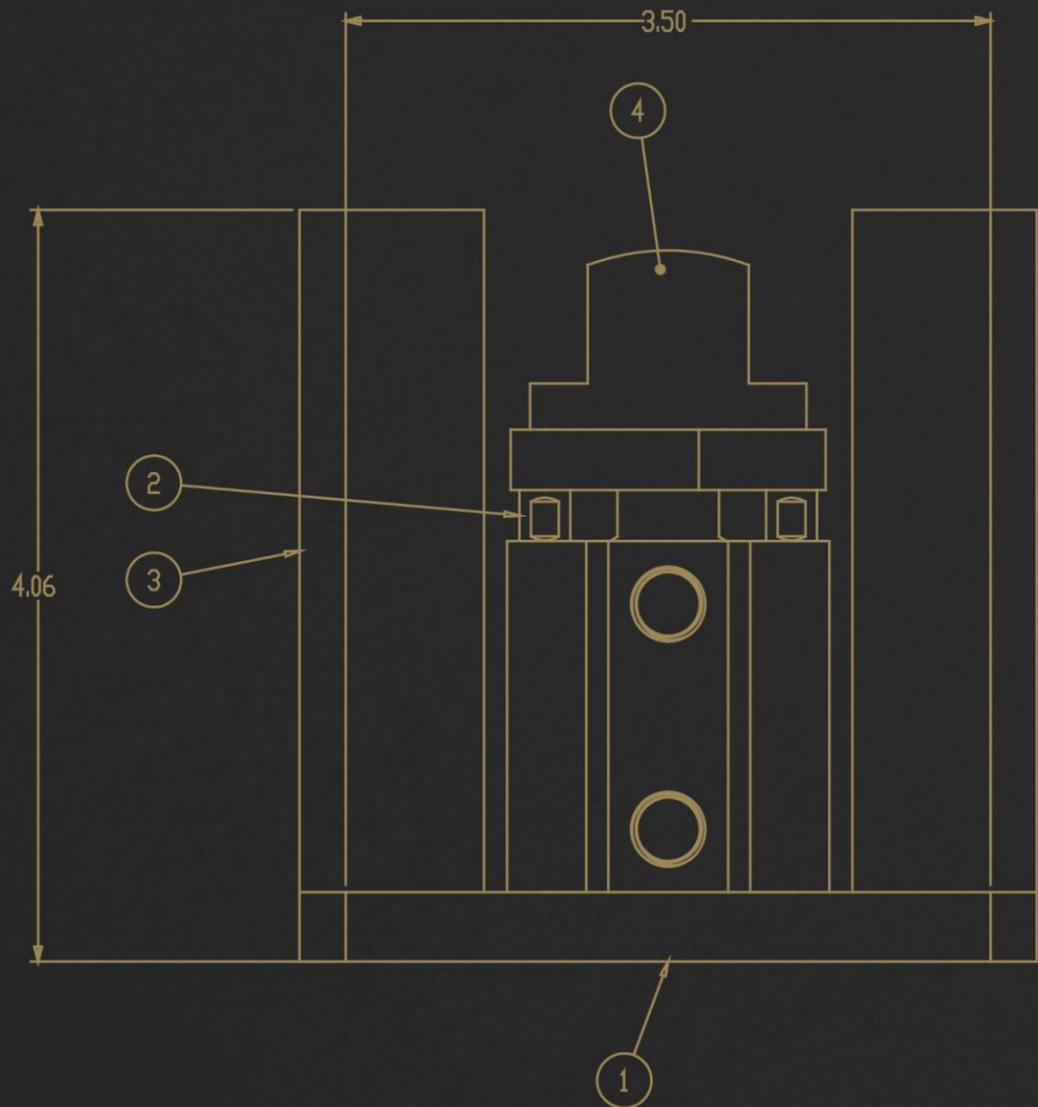


DESIGNED BY: ML	LINEAR X ± 0.020 .XX ± 0.010 .XXX ± 0.005	ANGULAR X ± 2° X ± 1° .XX ± 0° 30'	
DRAWN BY:	<small>THE USE OR DUPLICATION OF THIS DOCUMENT OR ITS CONTENTS WITHOUT THE EXPRESSED WRITTEN CONSENT OF COLBORNE FOODBOTICS, LLC IS STRICTLY PROHIBITED.</small>		
DATE: 4/2/2020	MATERIAL:		PART NUMBER: VCA384-01-136
STOCK SIZE:		DESCRIPTION: FLARE PLATE-IN SIDE-UPPER	
STOCK NUMBER:	FINISH:	SHEET SIZE	
<small>UNLESS OTHERWISE SPECIFIED, BREAK ALL SHARP CORNERS, REMOVE ALL BURRS, AND STAMP OR ETCH PART NO. ON SURFACE.</small>		SCALE: 1:4	Sheet1 OF 1

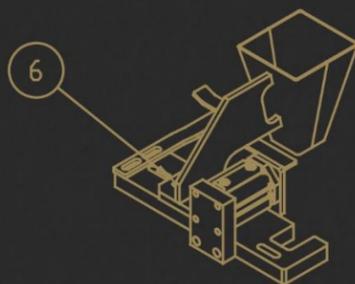
REV.	DESCRIPTION



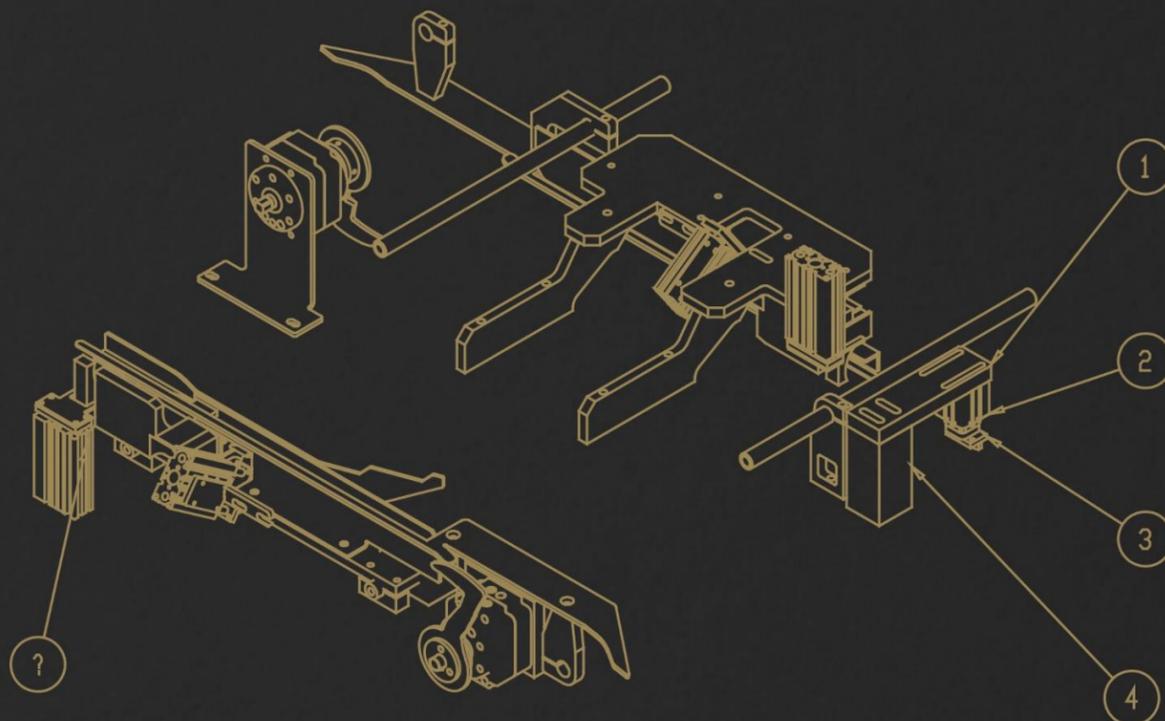
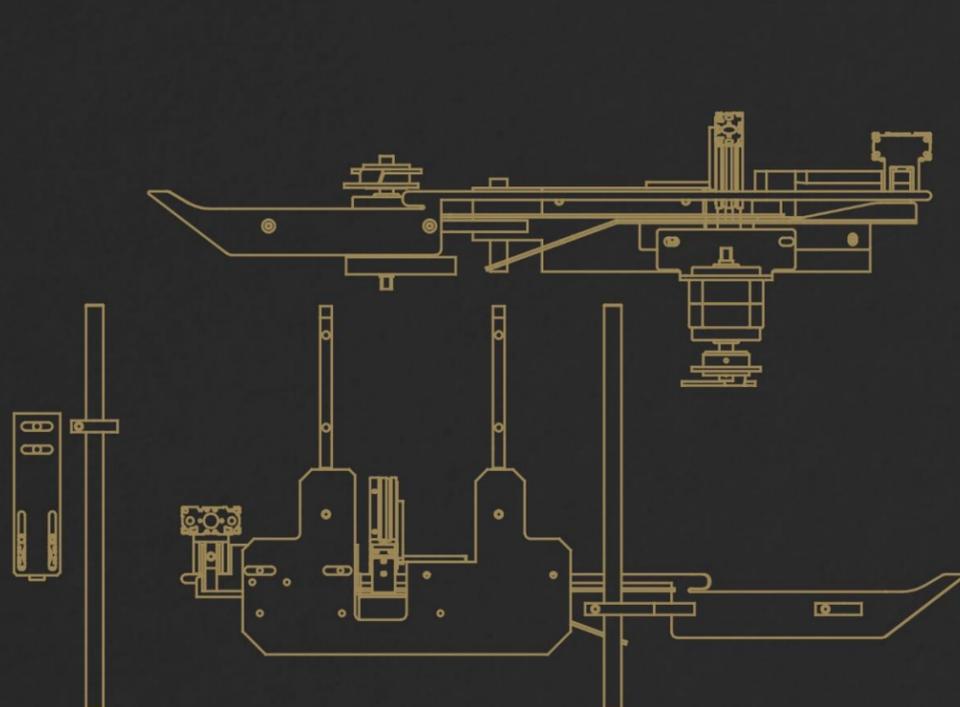
ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	VCA384-01-151	TUCK LOCK PLATE	1
2	164824	AIR CYL 1.25 BORE .50 STROKE	1
3	VCA384-01-152	STANDOFF TUCK LOCK	2
4	VCA384-01-153	TUCK LOCK TUCKER	1



DESIGNED BY: ML	LINEAR X ± 0.020 .XX ± 0.010 .XXX ± 0.005	ANGULAR X ± 2° .X ± 1° .XX ± 0° 30'	
DRAWN BY: ML	<small>THE USE OR DUPLICATION OF THIS DOCUMENT OR ITS CONTENTS WITHOUT THE EXPRESSED WRITTEN CONSENT OF COLBORNE FIDBOTICS, LLC IS STRICTLY PROHIBITED.</small>		
DATE: 3/17/2020	MATERIAL:		PART NUMBER: VCA384-01-150
	STOCK SIZE:		DESCRIPTION: TUCK LOCK ASSY
	STOCK NUMBER:	FINISH:	SHEET SIZE
	<small>UNLESS OTHERWISE SPECIFIED, BREAK ALL SHARP CORNERS, REMOVE ALL BURRS, AND STAMP OR ETCH PART NO. ON SURFACE.</small>		SCALE: 1:1
REV.	DESCRIPTION		Sheet1 OF 1

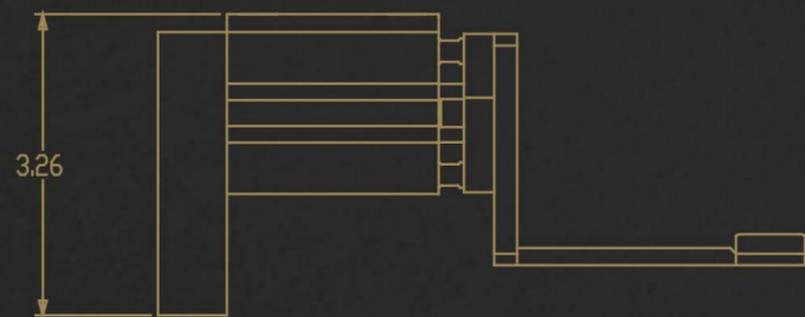
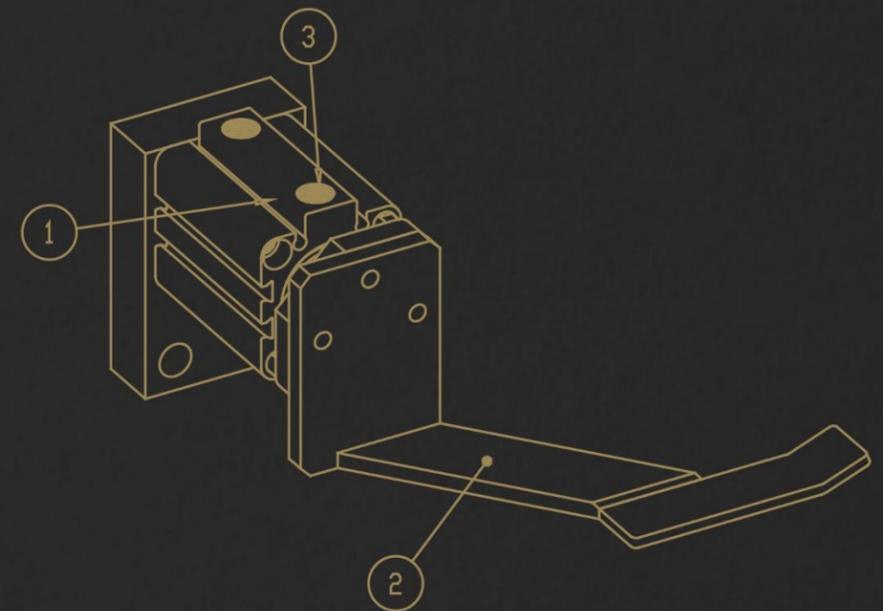
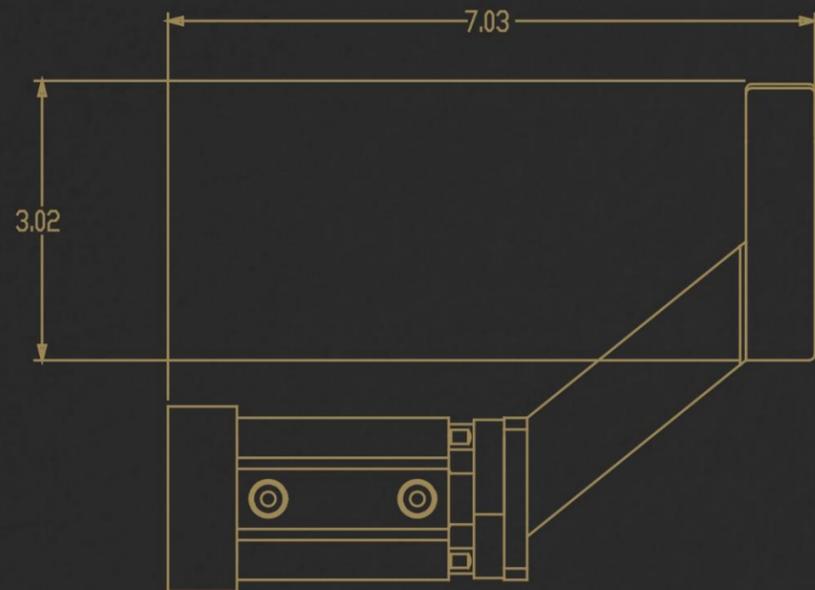


ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	VCA384-01-161	TUCK LOCK PLATE2	1
2	164824	AIR CYL 1.25 BORE .50 STROKE	1
3	VCA384-01-153	TUCK LOCK TUCKER	1
4	VCA384-01-162	TUCK PLATE MOUNT2	1
5	VCA384-01-190	CARTON CLOSING KIT	1
6	VCA384-99-010	CHUTE MOUNT ASSY	1

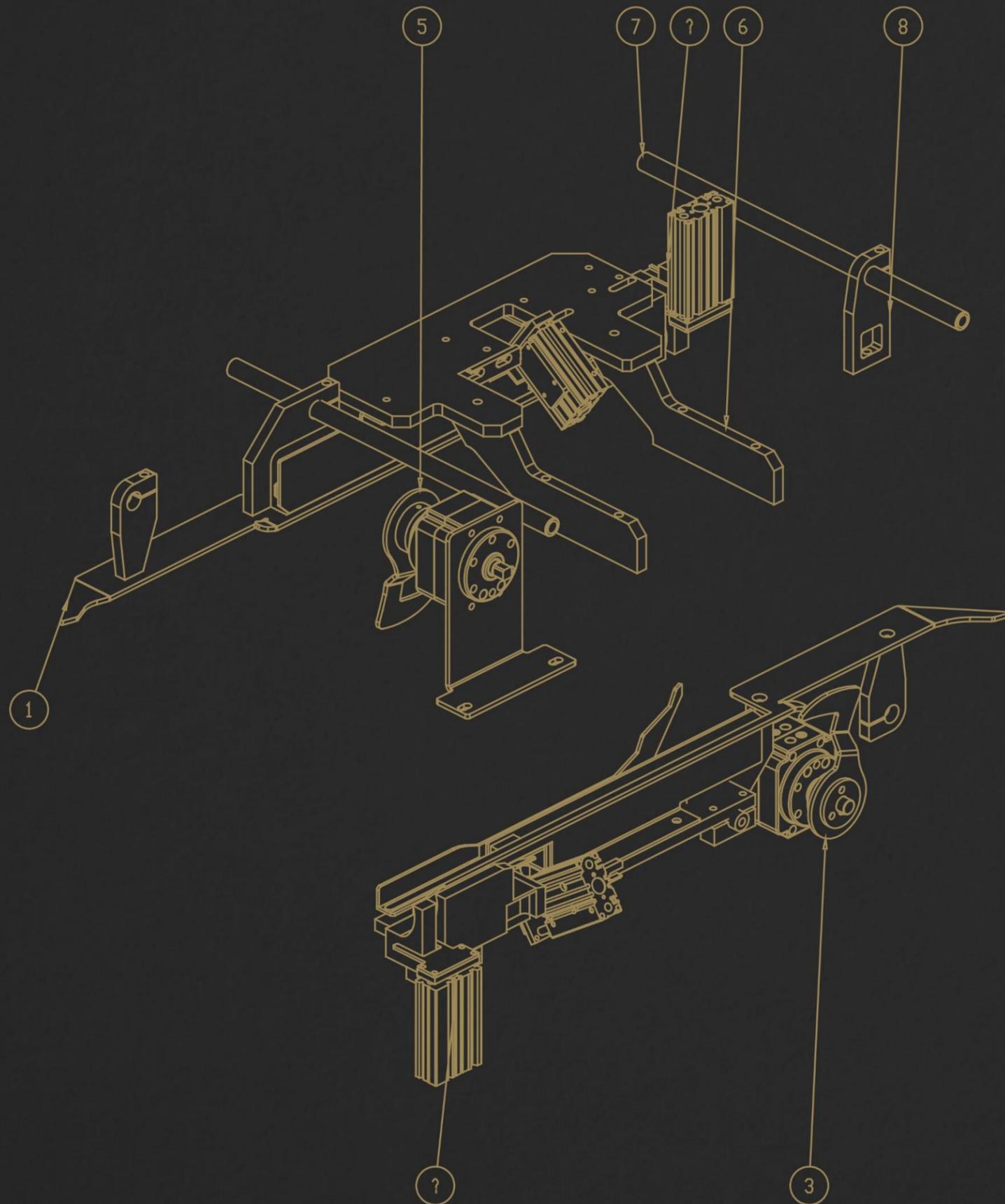


DESIGNED BY: ML	LINEAR X ± 0.020 .XX ± 0.010 .XXX ± 0.005	ANGULAR X ± 2° .X ± 1' .XX ± 0° 30'	
DRAWN BY: ML	<small>THE USE OR DUPLICATION OF THIS DOCUMENT OR ITS CONTENTS WITHOUT THE EXPRESSED WRITTEN CONSENT OF COLBORNE FLOWBOTICS, LLC IS STRICTLY PROHIBITED.</small>		
DATE: 3/17/2020	MATERIAL:		PART NUMBER: VCA384-01-160
	STOCK SIZE:		DESCRIPTION: TUCK LOCK ASSY
	STOCK NUMBER:	FINISH:	SHEET SIZE
	UNLESS OTHERWISE SPECIFIED, BREAK ALL SHARP CORNERS, REMOVE ALL BURRS, AND STAMP OR ETCH PART NO. ON SURFACE.		SCALE: 1/8
			Sheet1 OF 1

ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	VCA384-01-172	PLOW MOUNT BLOCK	1
2	VCA384-01-171	FLAP PLOW	1
3	164832	AIR CYL 1.25 BORE 1.00 STROKE NONROTATING	1



DESIGNED BY: ML	LINEAR .X ± 0.020 .XX ± 0.010 .XXX ± 0.005	ANGULAR X ± 2° X ± 1° .XX ± 0° 30'	
DRAWN BY:	<small>THE USE OR DUPLICATION OF THIS DOCUMENT OR ITS CONTENTS WITHOUT THE EXPRESSED WRITTEN CONSENT OF COLBORNE FRODBOTICS, LLC IS STRICTLY PROHIBITED.</small>		
DATE:			
MATERIAL:			PART NUMBER: VCA384-01-170
STOCK SIZE:			DESCRIPTION: LEAD FLAP PLOW
STOCK NUMBER:	FINISH:		
<small>UNLESS OTHERWISE SPECIFIED, BREAK ALL SHARP CORNERS, REMOVE ALL BURRS, AND STAMP OR ETCH PART NO. ON SURFACE.</small>			SHEET SIZE
REV.		DESCRIPTION	SCALE: 1/2
			Sheet1 OF 1



ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	VCA384-01-200	LOWER PLOUGH ASSY	2
2	VCA384-01-210	TRAILING PLOUGH ASSY	1
3	VCA384-75-001	LOWER CARTON TUCKER ASSY	1
4	VCA384-01-230	UPPER TRAILING PLOUGH ASSY	1
5	VCA384-75-002	LOWER CARTON TUCKER ASSY	1
6	VCA384-01-232	PLOUGH MOUNT ARM	2
7	VCA384-01-219	TUBE 0.75OD 0.5ID	2
8	01488384	CLAMP FLAIR	1

DESIGNED BY: ML	LINEAR .X ± 0.020 .XX ± 0.010 .XXX ± 0.005	ANGULAR X ± 2° .X ± 1° .XX ± 0° 30'
DRAWN BY:	THE USE OR DUPLICATION OF THIS DOCUMENT OR ITS CONTENTS WITHOUT THE EXPRESSED WRITTEN CONSENT OF COLBORNE FOODBOTICS, LLC IS STRICTLY PROHIBITED.	
DATE: 2/3/2020		
MATERIAL:		
STOCK SIZE:		
STOCK NUMBER:	FINISH:	
UNLESS OTHERWISE SPECIFIED, BREAK ALL SHARP CORNERS, REMOVE ALL BURRS, AND STAMP OR ETCH PART NO. ON SURFACE.		



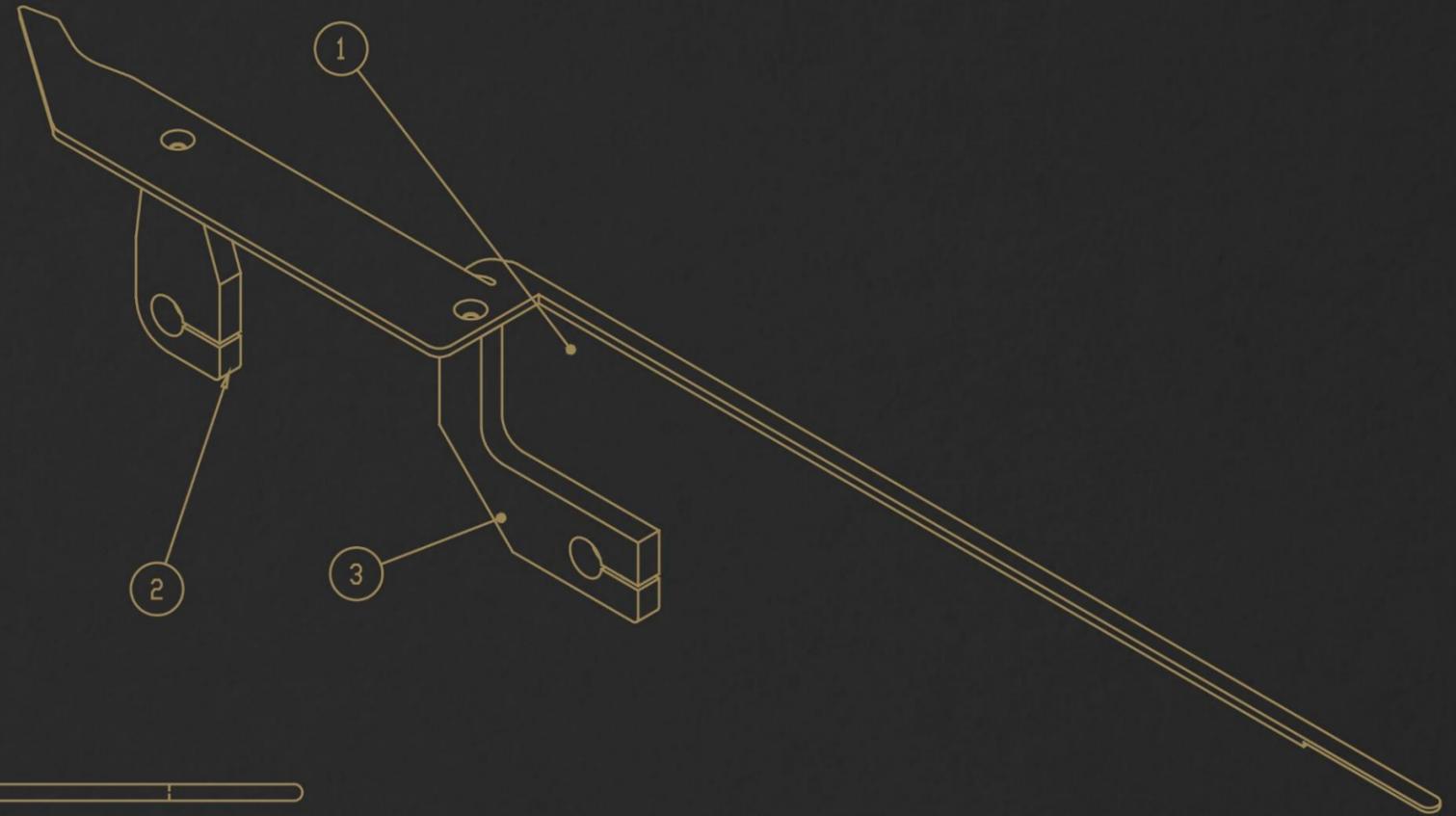
PART NUMBER: VCA384-01-190

DESCRIPTION: CARTON CLOSING KIT

SHEET SIZE: SCALE: 1/5 Sheet 1 OF 1

REV.	DESCRIPTION

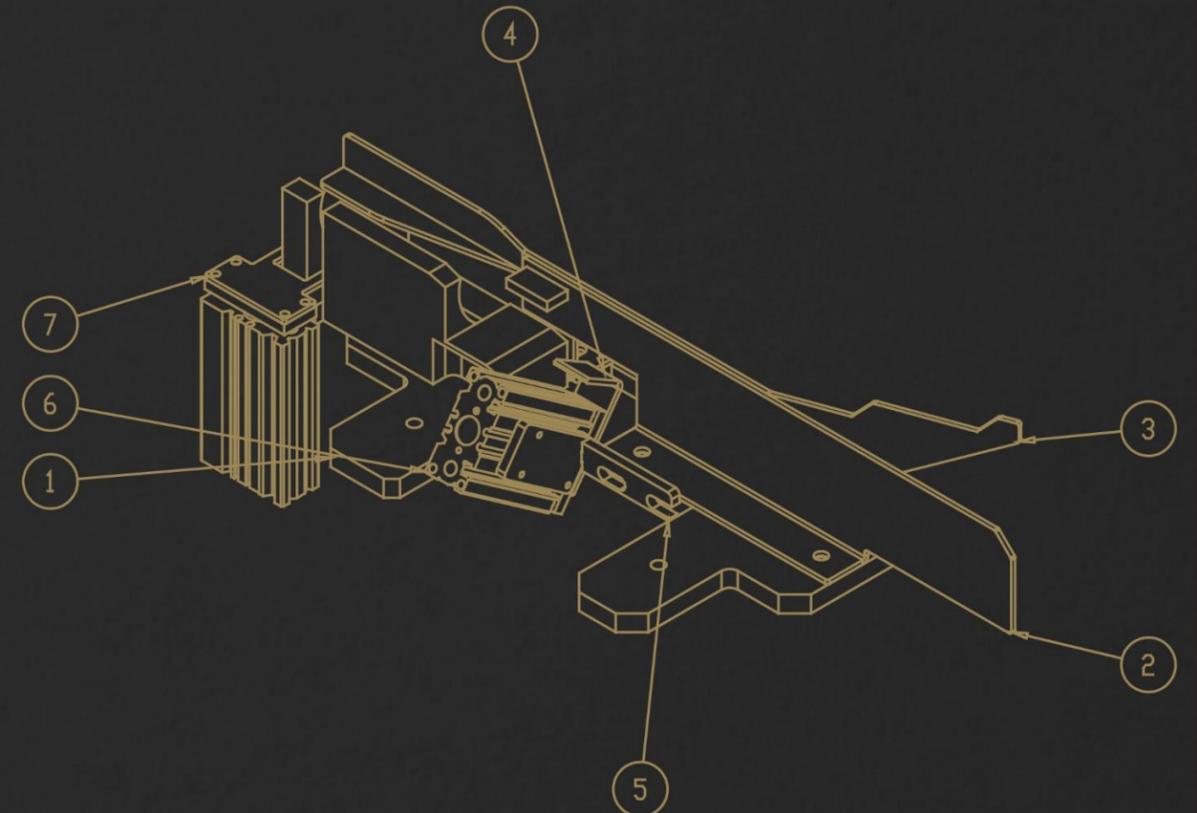
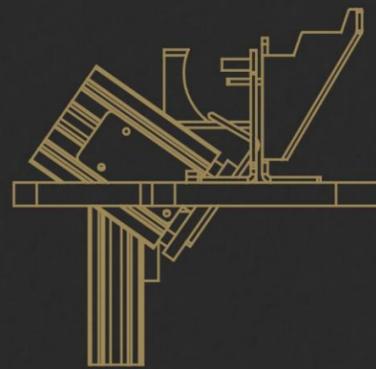
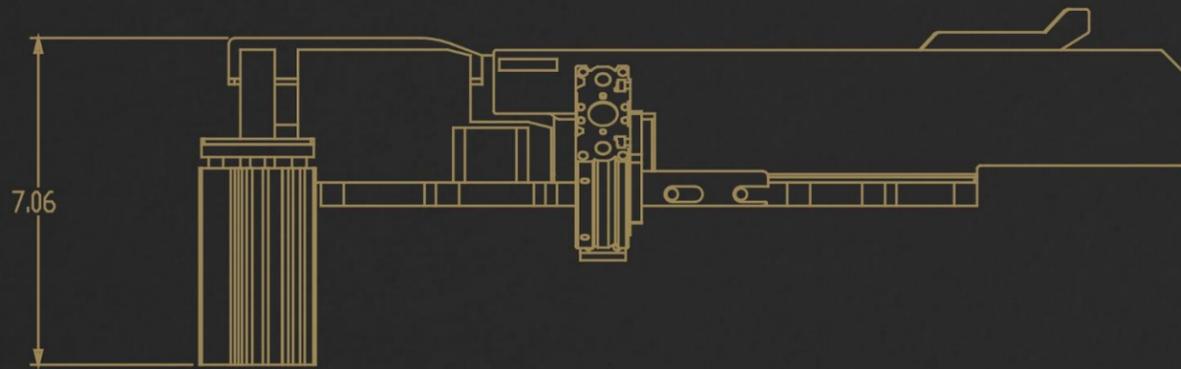
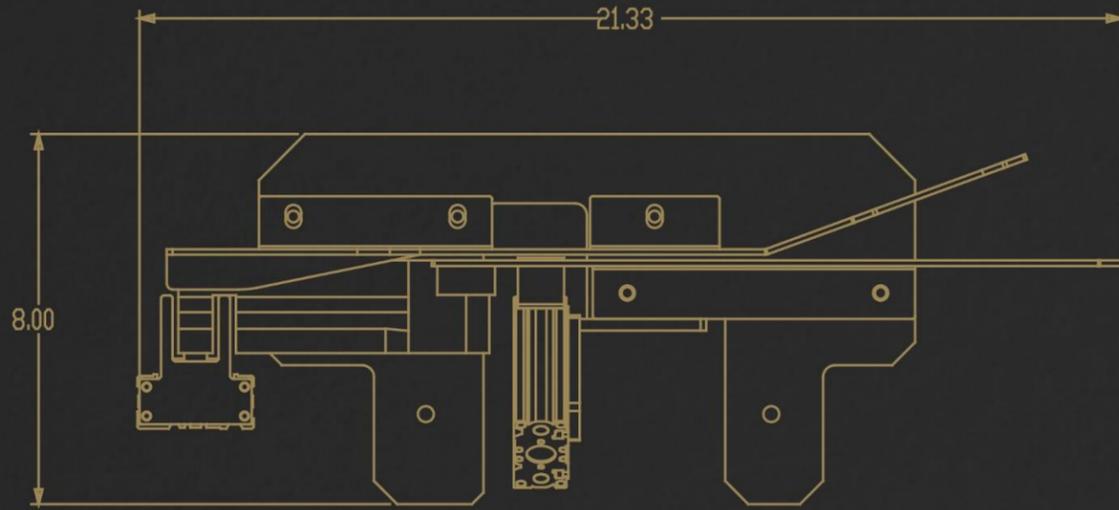
ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	VCA384-01-201	FLARE PLATE-INFEED	1
2	01483384	CLAMP FLAIR	1
3	VCA384-01-204	CLAMP FLAIR	1



DESIGNED BY: ML	LINEAR .X ± 0.020 .XX ± 0.010 .XXX ± 0.005	ANGULAR X ± 2° X ± 1° .XX ± 0° 30'	
DRAWN BY:	<small>THE USE OR DUPLICATION OF THIS DOCUMENT OR ITS CONTENTS WITHOUT THE EXPRESSED WRITTEN CONSENT OF COLBORNE FRODBOTICS, LLC IS STRICTLY PROHIBITED.</small>		
DATE: 1/31/2020	MATERIAL:		PART NUMBER: VCA384-01-200
STOCK SIZE:			DESCRIPTION: LEAD PLOUGH ASSY
STOCK NUMBER:		FINISH:	SHEET SIZE
<small>UNLESS OTHERWISE SPECIFIED, BREAK ALL SHARP CORNERS, REMOVE ALL BURRS, AND STAMP OR ETCH PART NO. ON SURFACE.</small>			SCALE: 1:3
			Sheet1 OF 1

REV.	DESCRIPTION

ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	VCA384-01-231	PLOUGH MOUNT PLATE	1
2	VCA384-01-213	TOOLING FRONT PLATE	1
3	VCA384-01-214	TOOLING BACK PLATE	1
4	VCA384-01-217	FLAP TOOL PLATE	1
5	VCA384-01-215	TOOL THUSTER MOUNT	1
6	164382	THRUSTER 16MM BORE X 25MM STROKE	1
7	VCA384-99-170	CARTON TUCK ASSY	1



DESIGNED BY: ML	LINEAR X ± 0.020 .XX ± 0.010 .XXX ± 0.005	ANGULAR X ± 2° X ± 1° .XX ± 0° 30'
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DATE: 2/3/2020		
MATERIAL:		
STOCK SIZE:		
STOCK NUMBER:	FINISH:	
UNLESS OTHERWISE SPECIFIED, BREAK ALL SHARP CORNERS, REMOVE ALL BURRS, AND STAMP OR ETCH PART NO. ON SURFACE.		



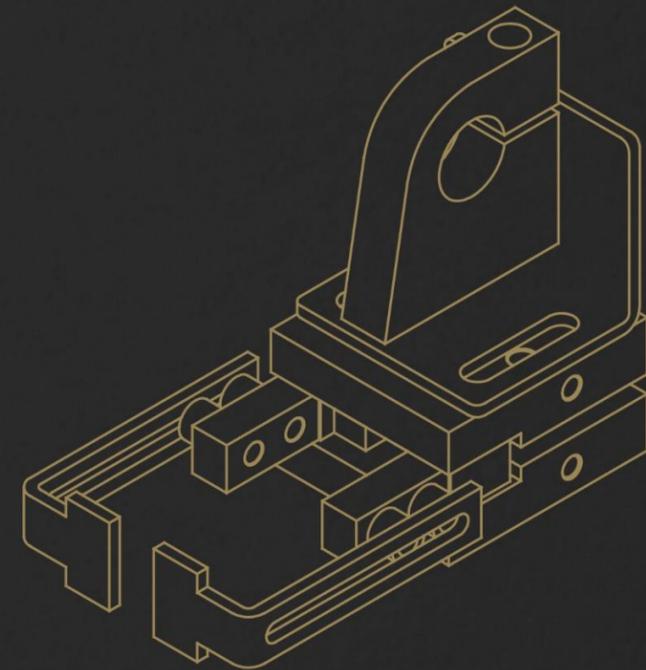
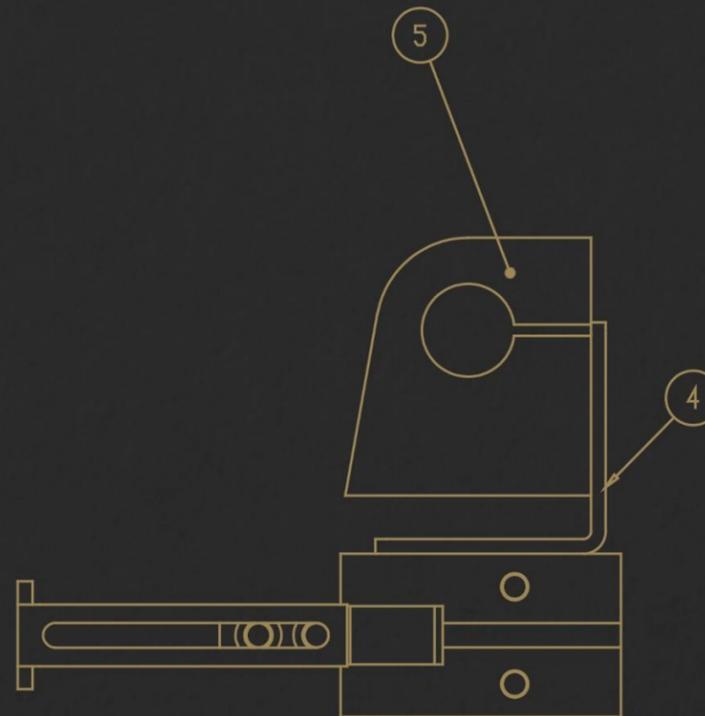
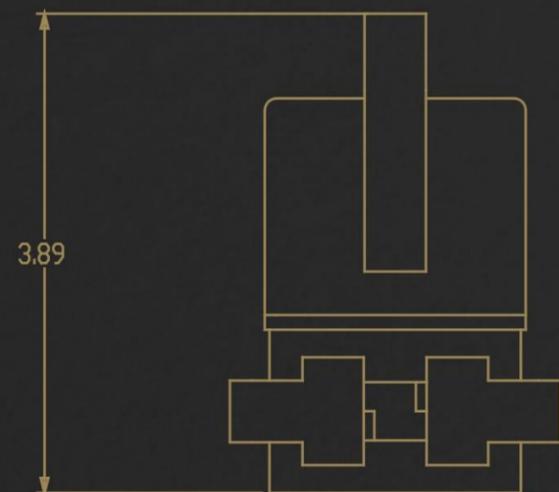
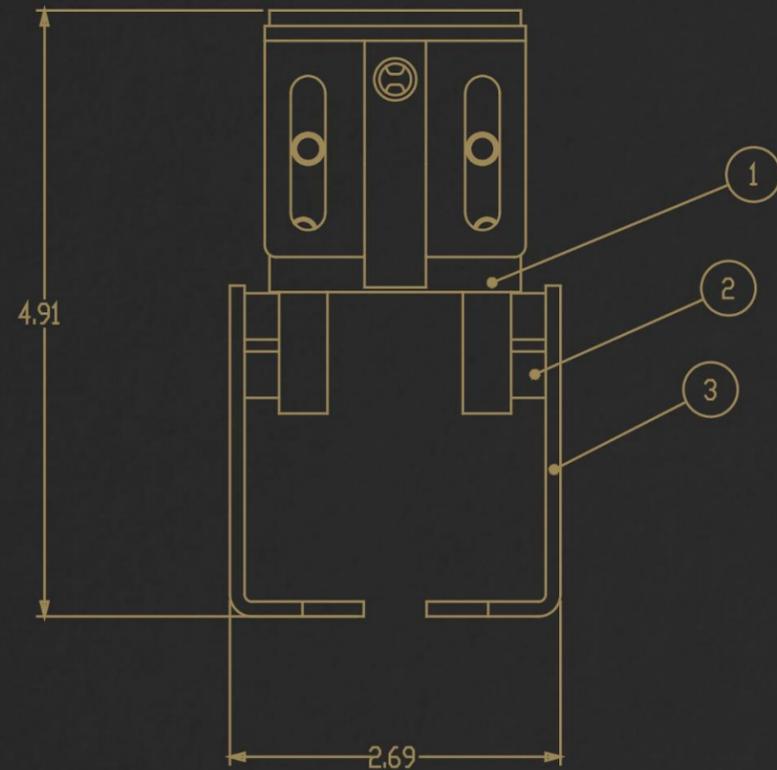
PART NUMBER: VCA384-01-230

DESCRIPTION: TRAILING PLOUGH ASSY

SHEET SIZE: SCALE: 1:4 Sheet1 OF 1

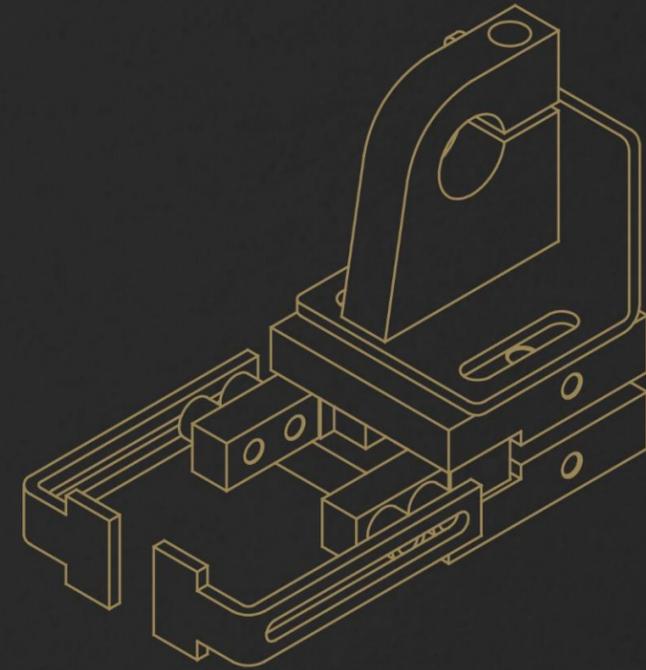
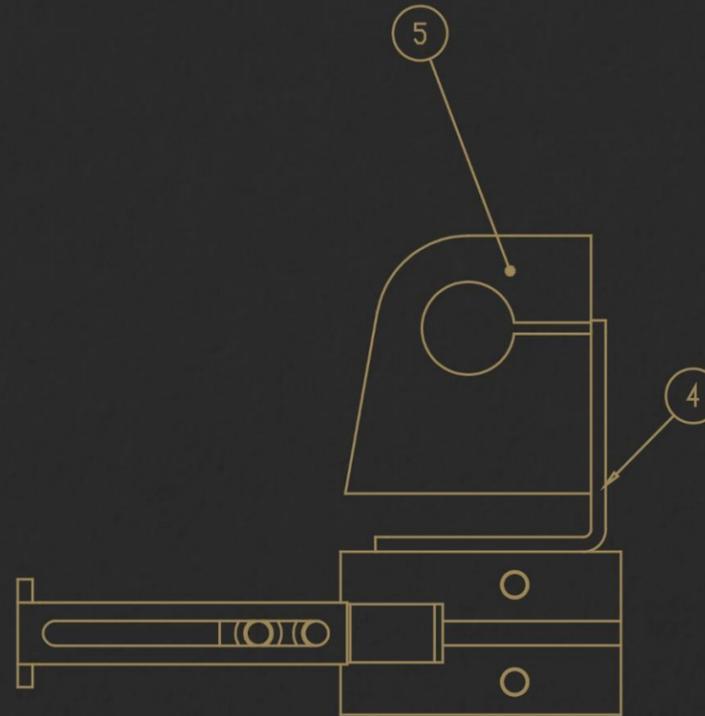
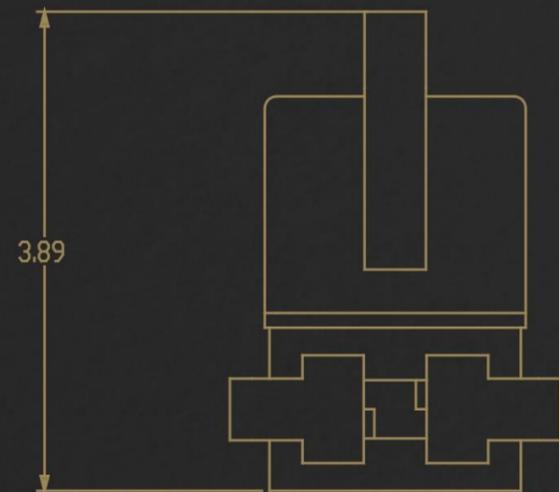
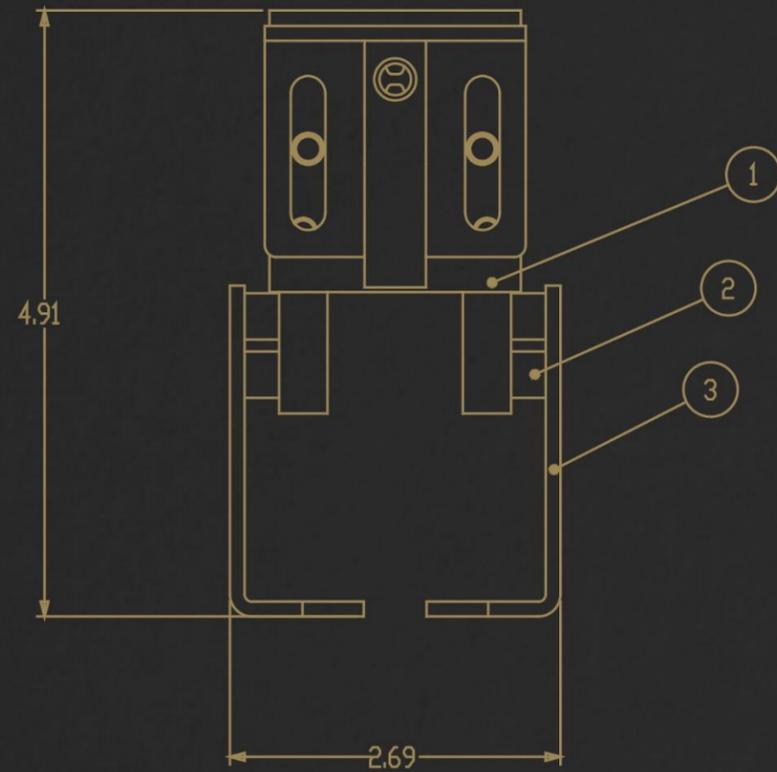
REV.	DESCRIPTION
A	REVISED FOIL -ML-04.15.20

ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	165270	ANGULAR GRIPPER 25MM BORE	1
2	VCA384-01-272	STANDOFF	4
3	VCA384-01-251	FINGER BRACKET	2
4	VCA384-01-273	L - BRACKET	1
5	VCA384-01-274	CLAMP FLAIR	1



DESIGNED BY:	LINEAR X ± 0.020 .XX ± 0.010 .XXX ± 0.005	ANGULAR X ± 2° X ± 1° .XX ± 0° 30'					
DRAWN BY: ML	<small>THE USE OR DUPLICATION OF THIS DOCUMENT OR ITS CONTENTS WITHOUT THE EXPRESSED WRITTEN CONSENT OF COLBORNE FRODBOTICS, LLC IS STRICTLY PROHIBITED.</small>						
DATE: 5/12/2020	MATERIAL:		PART NUMBER: VCA384-01-271				
STOCK SIZE:			DESCRIPTION: PRE BREAK ASSY				
STOCK NUMBER:		FINISH:	SHEET SIZE				
<small>UNLESS OTHERWISE SPECIFIED, BREAK ALL SHARP CORNERS, REMOVE ALL BURRS, AND STAMP OR ETCH PART NO. ON SURFACE.</small>			SCALE: 1:1.5				
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REV.	DESCRIPTION						

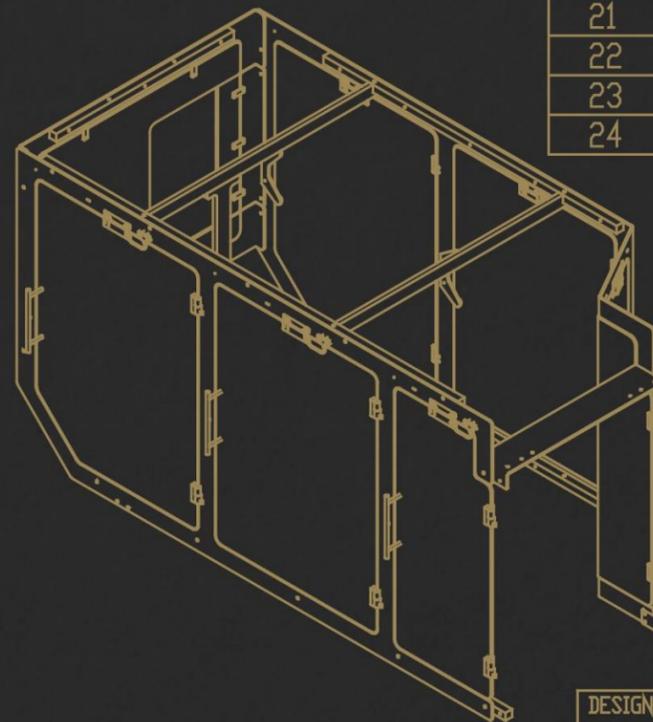
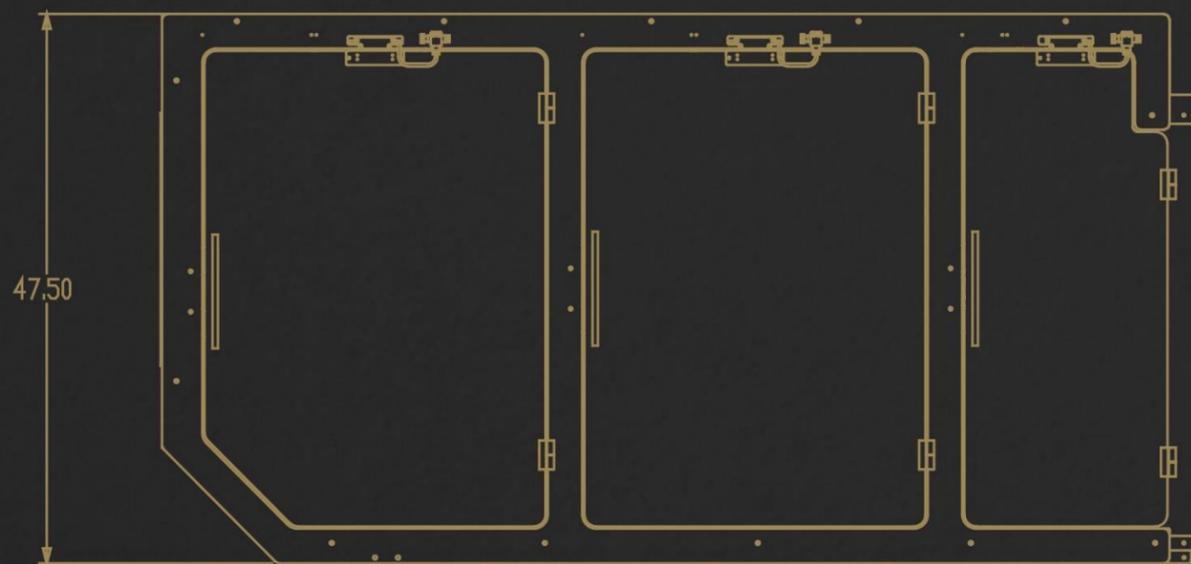
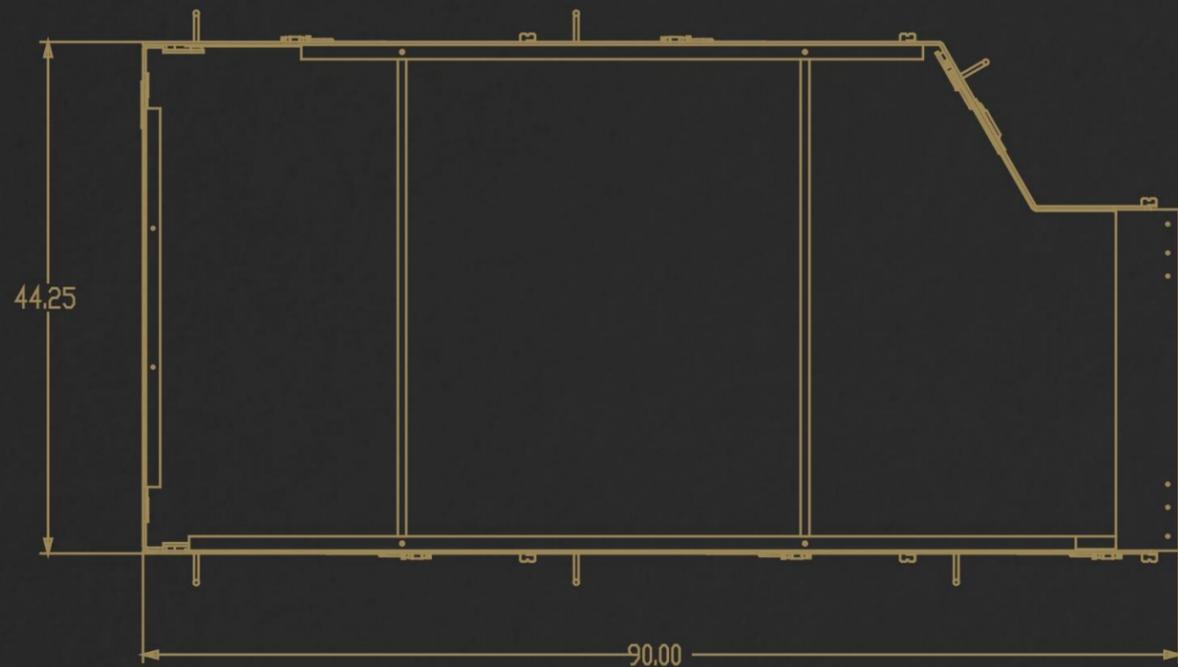
ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	165270	ANGULAR GRIPPER 25MM BORE	1
2	VCA384-01-272	STANDOFF	4
3	VCA384-01-251	FINGER BRACKET	2
4	VCA384-01-273	L - BRACKET	1
5	VCA384-01-274	CLAMP FLAIR	1



DESIGNED BY:	LINEAR .X ± 0.020 .XX ± 0.010 .XXX ± 0.005	ANGULAR X ± 2° .X ± 1° .XX ± 0° 30'	
DRAWN BY: ML	<small>THE USE OR DUPLICATION OF THIS DOCUMENT OR ITS CONTENTS WITHOUT THE EXPRESSED WRITTEN CONSENT OF COLBORNE FOODBOTICS, LLC IS STRICTLY PROHIBITED.</small>		
DATE: 5/12/2020	MATERIAL:		PART NUMBER: VCA384-01-271
STOCK SIZE:		FINISH:	DESCRIPTION: PRE BREAK ASSY
STOCK NUMBER:		<small>UNLESS OTHERWISE SPECIFIED, BREAK ALL SHARP CORNERS, REMOVE ALL BURRS, AND STAMP OR ETCH PART NO. ON SURFACE.</small>	
SHEET SIZE	SCALE: 1:1.5	Sheet1 OF 1	

REV.	DESCRIPTION

ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	VCA00A-02-139	GUARD - SIDE 02	1
2	VCA384-02-141	GUARD BACK	1
3	VCA00A-02-142	BOTTOM SUPPT. BAR	1
4	VCA00A-02-117	GUARD - UPPER TUCKER	1
5	02007384	HINGE MTG	12
6	VCA00A-02-104	DOOR SENSOR MAGNET ASSY.	6
7	VCA00A-02-107	HANDLE DOOR ASSEMBLY	6
8	VCA00A-02-144	WINDOW SIDE 1	2
9	VCA00A-02-145	WINDOW CORNER	2
10	VCA384-02-146	WINDOW BACK	1
11	02111384	LEXAN MTG BRACKET	8
12	VCA00A-02-150	BOTTOM SUPPT. BAR SHORT	2
13	VCA00A-02-151	SUPPORT BAR VERTICAL	1
14	VCA00A-02-152	BOTTOM SUPPT. BAR	1
15	VCA00A-02-153	GUARD FRAME TIE PLATE	1
16	VCA384-02-154	GUARD FRAME CENTER SUPPORT	1
17	VCA00A-02-155	GUARD FRAME CROSS BAR - 2	2
18	VCA00A-02-157	WINDOW SIDE 1	1
19	VCA384-02-140	GUARD SIDE	1
20	VCA384-02-156	WINDOW SIDE 3	1
21	118990	HINGE - RH	6
22	118991	HINGE - LH	6
23	VCA384-02-161	GUARD BACK	1
24	VCA384-02-166	WINDOW BACK	1



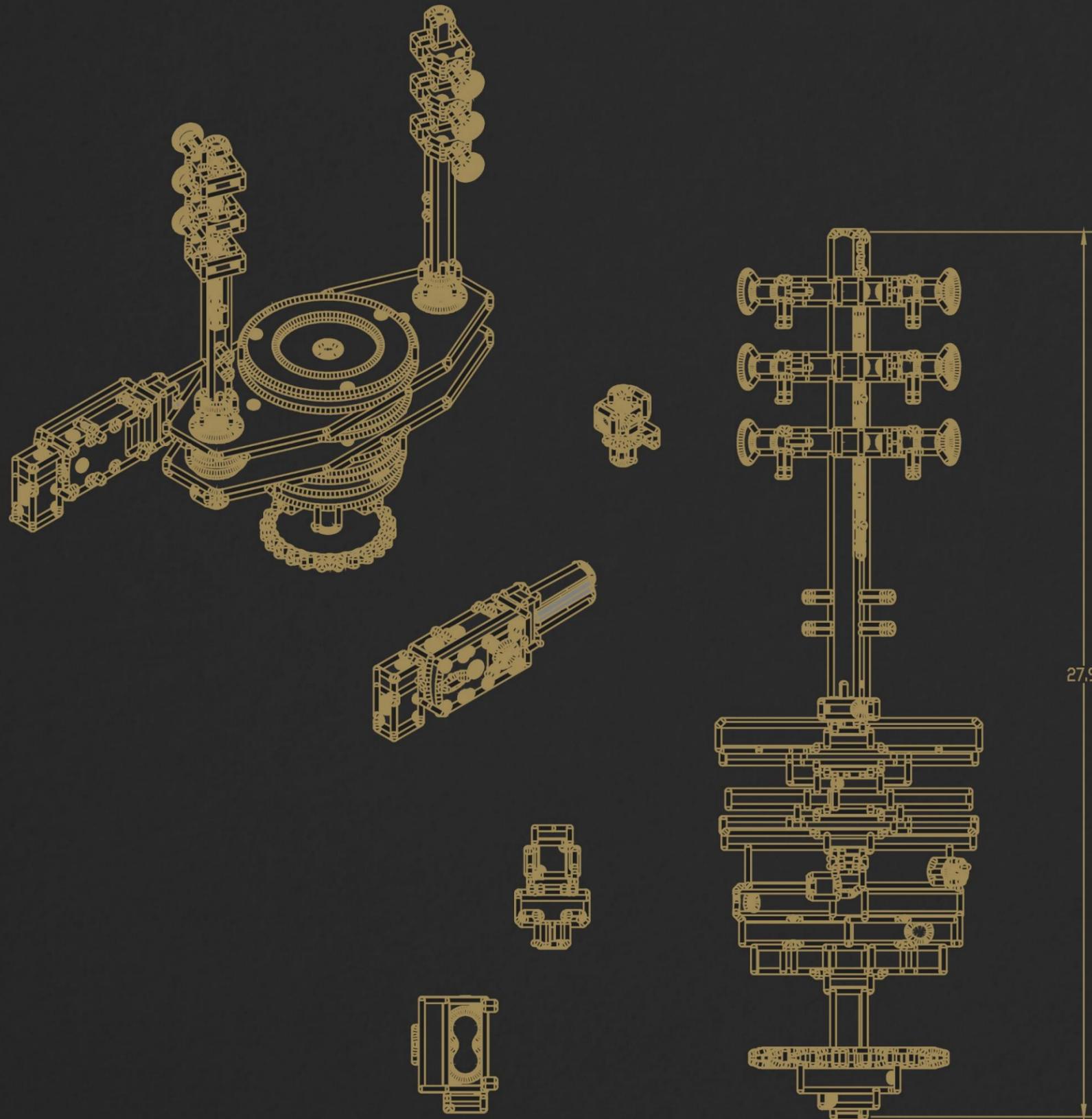
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DRAWN BY:	.X ± 0.020	X ± 2°
ML	.XX ± 0.010	.X ± 1°
DATE:	.XXX ± 0.005	.XX ± 0° 30'
1/15/2020	THE USE OR DUPLICATION OF THIS DOCUMENT OR ITS CONTENTS WITHOUT THE EXPRESSED WRITTEN CONSENT OF COLBORNE FOODBOTICS, LLC IS STRICTLY PROHIBITED.	



MATERIAL:	SEE BOM
STOCK SIZE:	
STOCK NUMBER:	FINISH:
UNLESS OTHERWISE SPECIFIED, BREAK ALL SHARP CORNERS, REMOVE ALL BURRS, AND STAMP OR ETCH PART NO. ON SURFACE.	

PART NUMBER:	VCA384-02-003	
DESCRIPTION:	BASE GUARD W/TILT CCW	
SHEET SIZE:	SCALE: 1/16	Sheet1 OF 1

REV.	DESCRIPTION



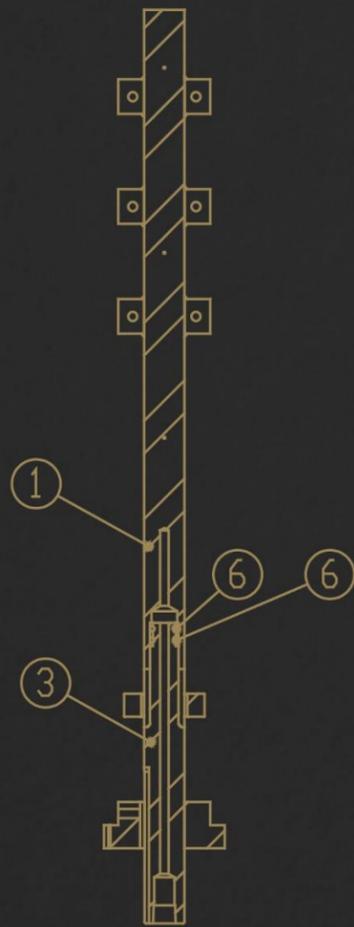
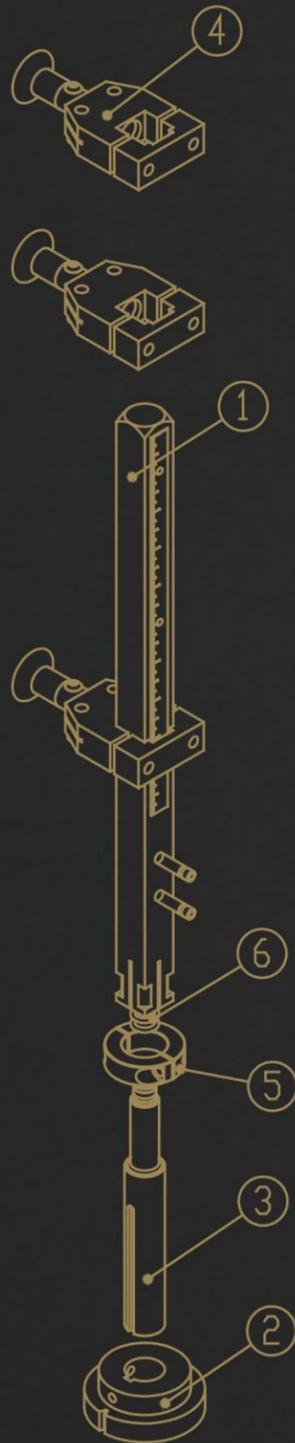
ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	VCA00A-03-129	HUB-STATIONARY	1
2	VCA00A-03-100	VACUUM BACKUP PLATE	1
3	VCA00A-03-131	ROTARY FEEDER 15 TWO HEAD	1
4	VCA00A-03-134	BEARING HUB	1
5	VCA00A-03-130	TOP & BOTTOM PLATE	2
6	164043	BEARING ER ".875"	4
7	VCA00A-03-104	ROTARY GEAR ASSY	2
8	VCA00A-03-107	STEPPED GEAR SHAFT	2
9	VCA00A-03-108	VALVE RETAINER PLATE	1
10	VCA00A-03-109	HUB-CLAMP PLATE	1
11	VCA00A-03-111	SPUR CHANGE GEAR - 16 DP	1
12	VCA384-03-112	PRODUCT INFEEED ASSY	2
13	VCA00A-03-124	TOP BEARING HUB	1
14	164055	BALL BEARING - CB	1
15	164056	BALL BEARING - RBI	1
16	164057	MALE CONNECTOR STRAIGHT UNION	3
17	164054	STEEL-BALL PLUNGERS	4
18	164058	ROTARY ONE-TOUCH FITTING 1/4NP	2
19	VCA00A-03-125	CENTRAL GEAR SPACER	1
20	164059	ONE-PIECE COLLAR	1
21	164025	BEARING INSERT ER	1
22	164063	BASIC EJECTOR	2
23	164062	NIPPLE HEX 3/8 NPT STRAIGHT	2
24	164060	PIPE FITTIN 3/4 X 3/8	2
25	164061	AIR PILOT VALVE	2
26	VCA00A-03-133	SPROCKET, 60B36 1 BORE	1
27	VCA00A-03-110	DRIVE SHAFT	1
28	164093	AR20 STYLE REGULATOR - 1/8	1

DESIGNED BY:	LINEAR	ANGULAR
DRAWN BY:	.X ± 0.020	X ± 2°
DD	.XX ± 0.010	.X ± 1°
DATE:	.XXX ± 0.005	.XX ± 0° 30'
12/17/2019	THE USE OR DUPLICATION OF THIS DOCUMENT OR ITS CONTENTS WITHOUT THE EXPRESSED WRITTEN CONSENT OF COLBORNE FOODBOTICS, LLC IS STRICTLY PROHIBITED.	
MATERIAL:	SEE BOM	
STOCK SIZE:		
STOCK NUMBER:	FINISH:	
UNLESS OTHERWISE SPECIFIED, BREAK ALL SHARP CORNERS, REMOVE ALL BURRS, AND STAMP OR ETCH PART NO. ON SURFACE.		

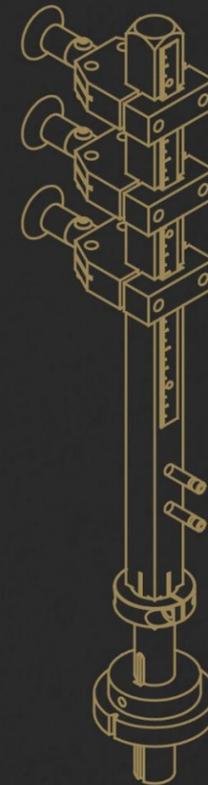
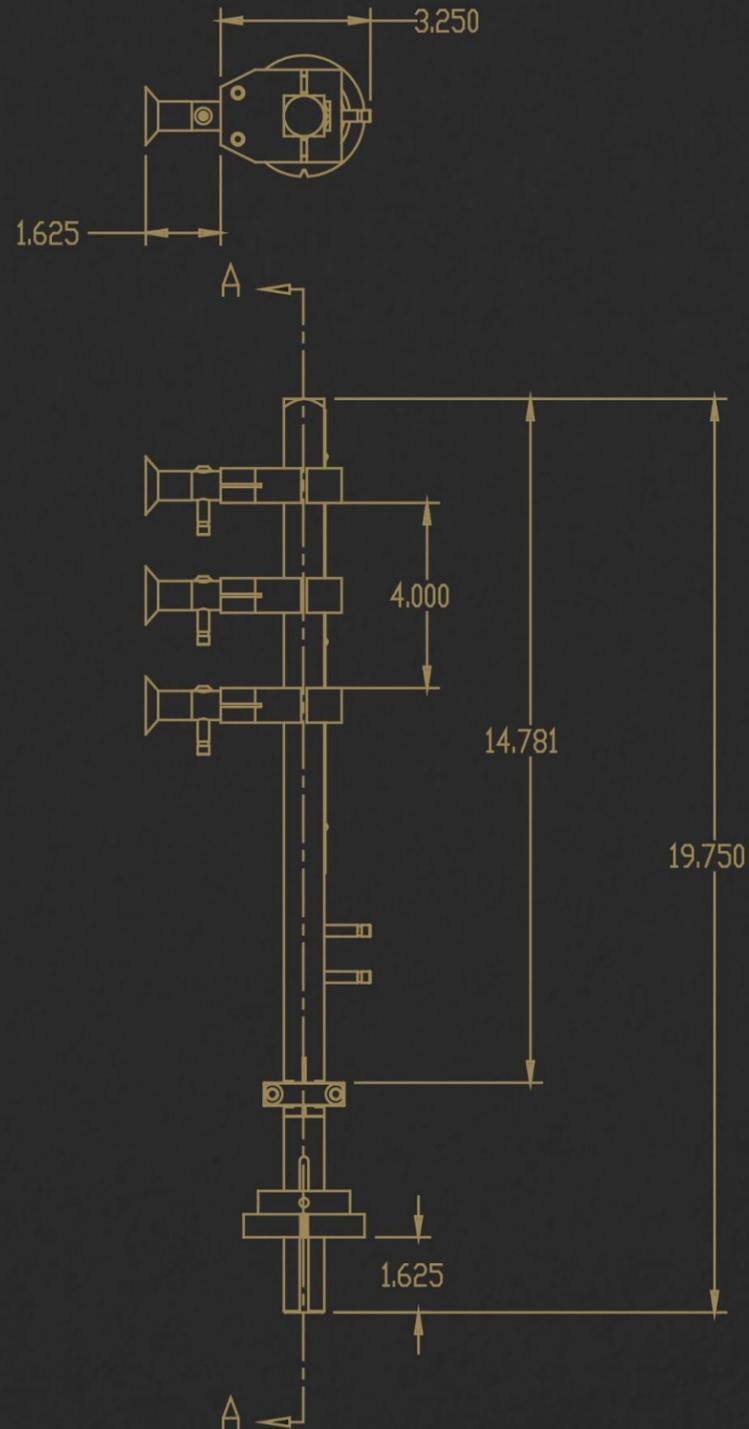


PART NUMBER: VCA384-03-002
 DESCRIPTION: ROTARY FEEDER 15 TWO HEAD

ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	VCA00A-03-113	ROD INFEED	1
2	VCA00A-03-116	SPUR GEAR - 16 DP	1
3	VCA00A-03-117	SHAFT-DRIVE, SUCTION CUP	1
4	VCA384-03-118	VACUUM CUP HOLDER	3
5	164065	TWO-PIECE COLLAR	1
6	164064	O-RINGS	2



SECTION A-A



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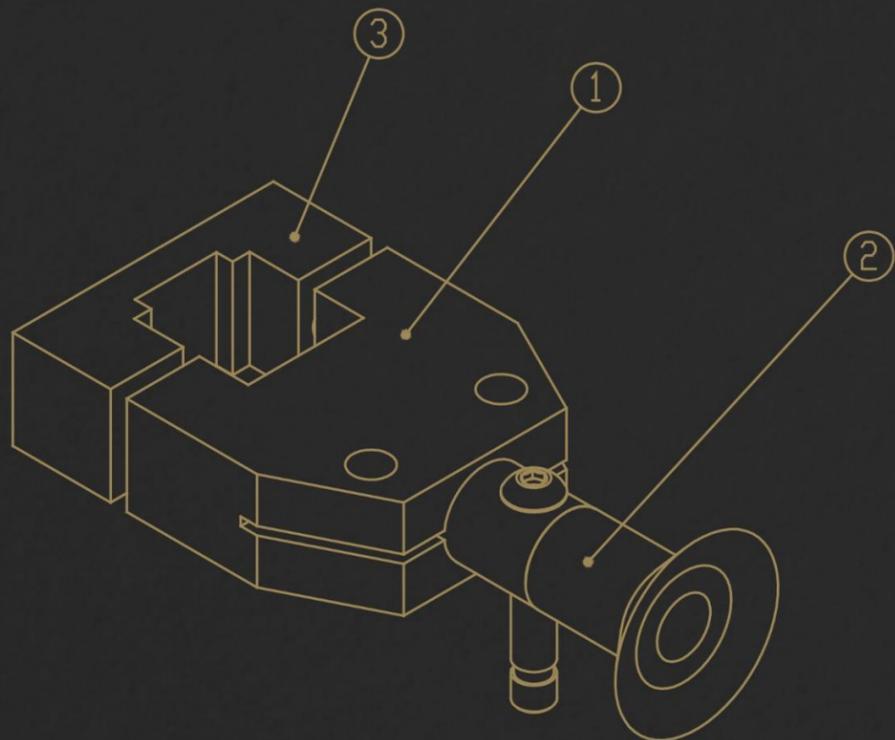
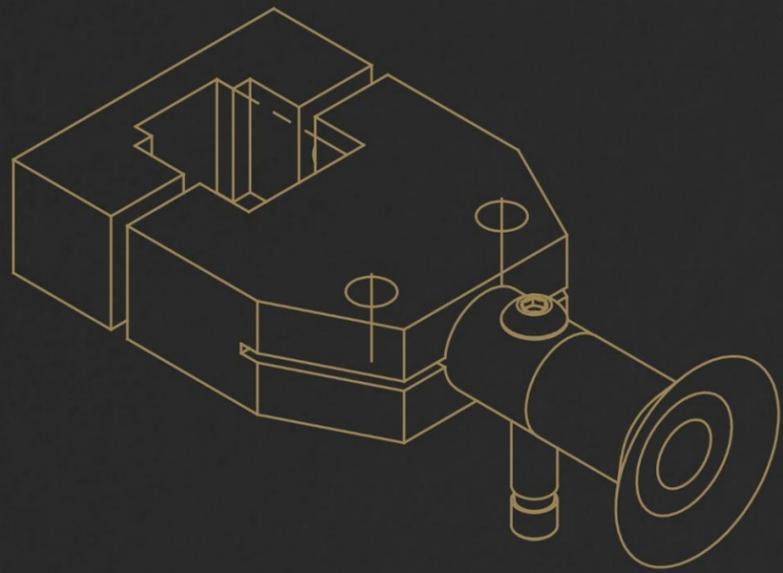


MATERIAL:	PART NUMBER:
STOCK SIZE:	VCA384-03-112
STOCK NUMBER:	DESCRIPTION:
FINISH:	PRODUCT INFEED ASSY
UNLESS OTHERWISE SPECIFIED, BREAK ALL SHARP CORNERS, REMOVE ALL BURRS, AND STAMP OR ETCH PART NO. ON SURFACE.	

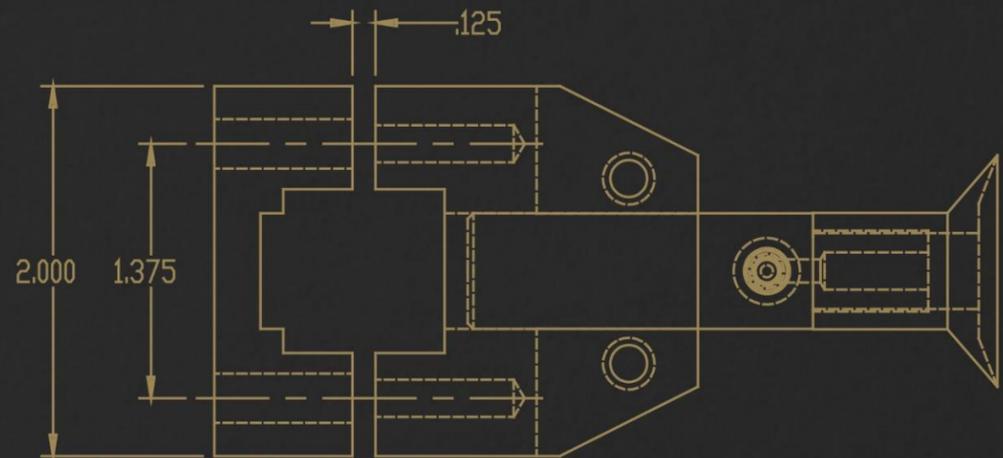
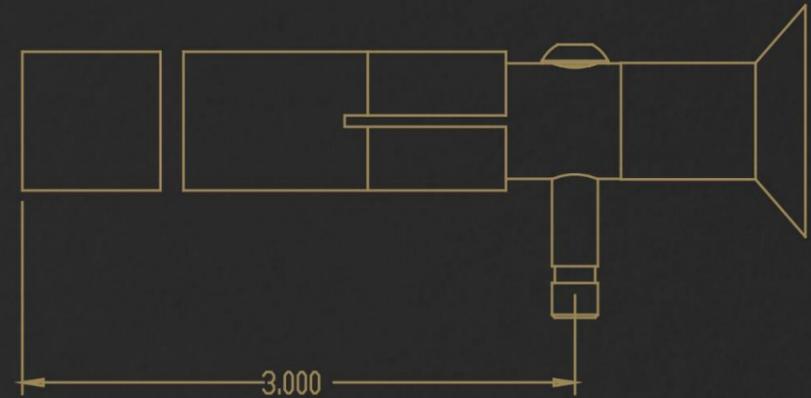
SHEET SIZE:	SCALE: 1:4	Sheet1 OF 1
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WEIGHT: 4.351 Lbs

REVISIONS				
ZONE	REV.	DESCRIPTION	DATE	APPROVED



ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	VCA00A-03-119	SUCTION PIPE HOLDER	1
2	VCA384-03-120	CUP HOLDER ASSY	1
3	VCA00A-03-123	CLAMP SUCTION CUP	1



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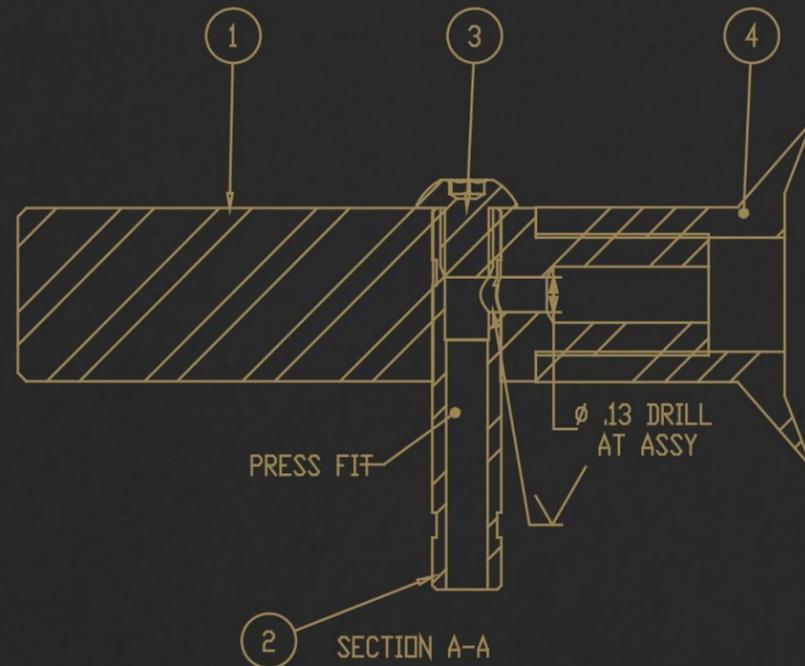
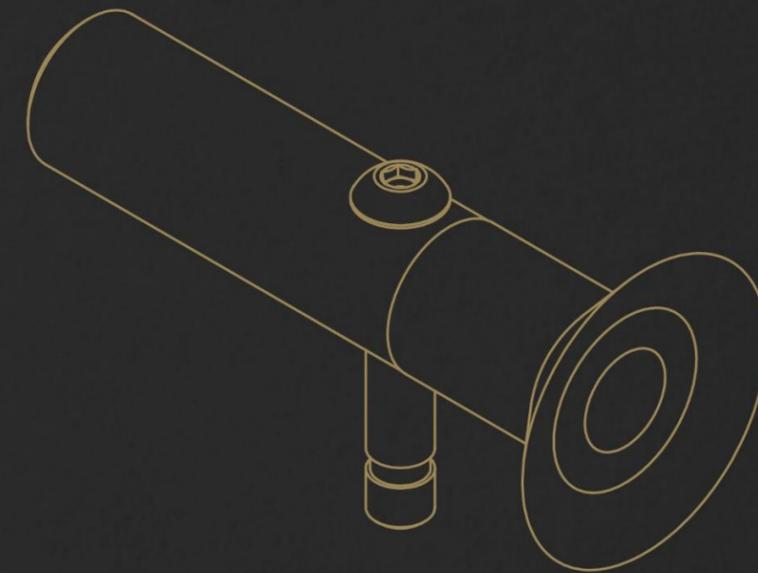
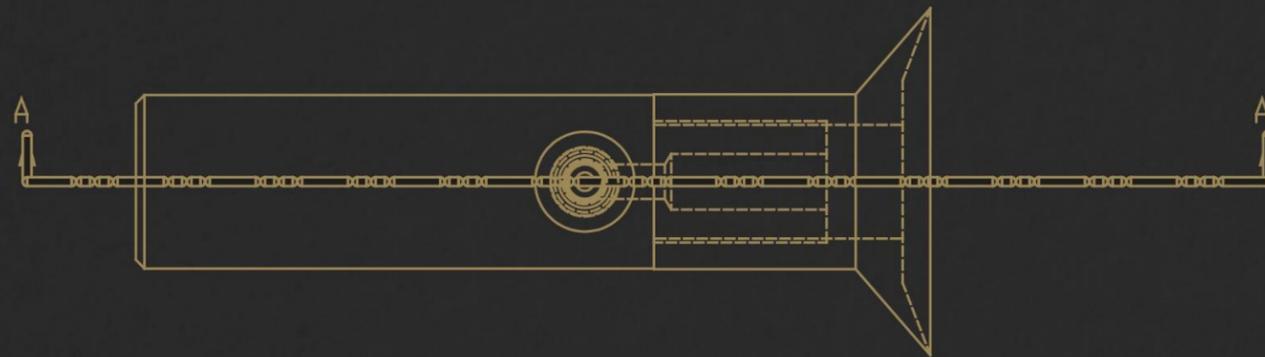


MATERIAL:	
STOCK SIZE:	
STOCK NUMBER:	FINISH:
UNLESS OTHERWISE SPECIFIED, BREAK ALL SHARP CORNERS, REMOVE ALL BURRS, AND STAMP OR ETCH PART NO. ON SURFACE.	

PART NUMBER:	VCA384-03-118
DESCRIPTION:	VACUUM CUP HOLDER
SHEET SIZE:	SCALE: 1:1
	Sheet1 OF 1

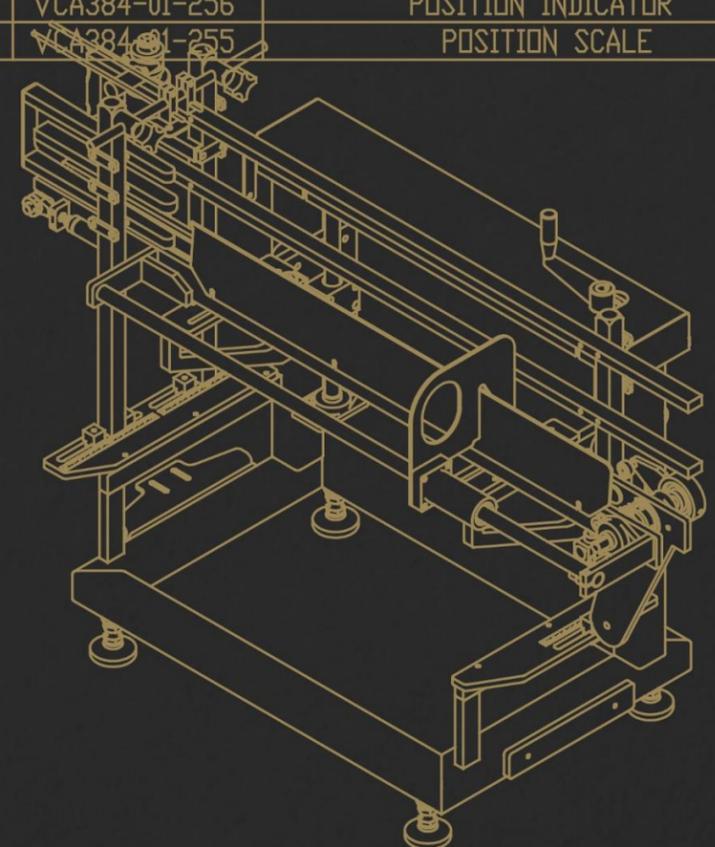
REVISIONS				
ZONE	REV.	DESCRIPTION	DATE	APPROVED

ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	VCA384-03-121	SUCTION PIPE COMPONENT	1
2	VCA00A-03-122	SUCTION PIPE STEM	1
3	164067	BUTTON HD SOC CAP SCREW, 10-32	1
4	165127	SUCTION CUP 1.25 X 1.00 X .41	1



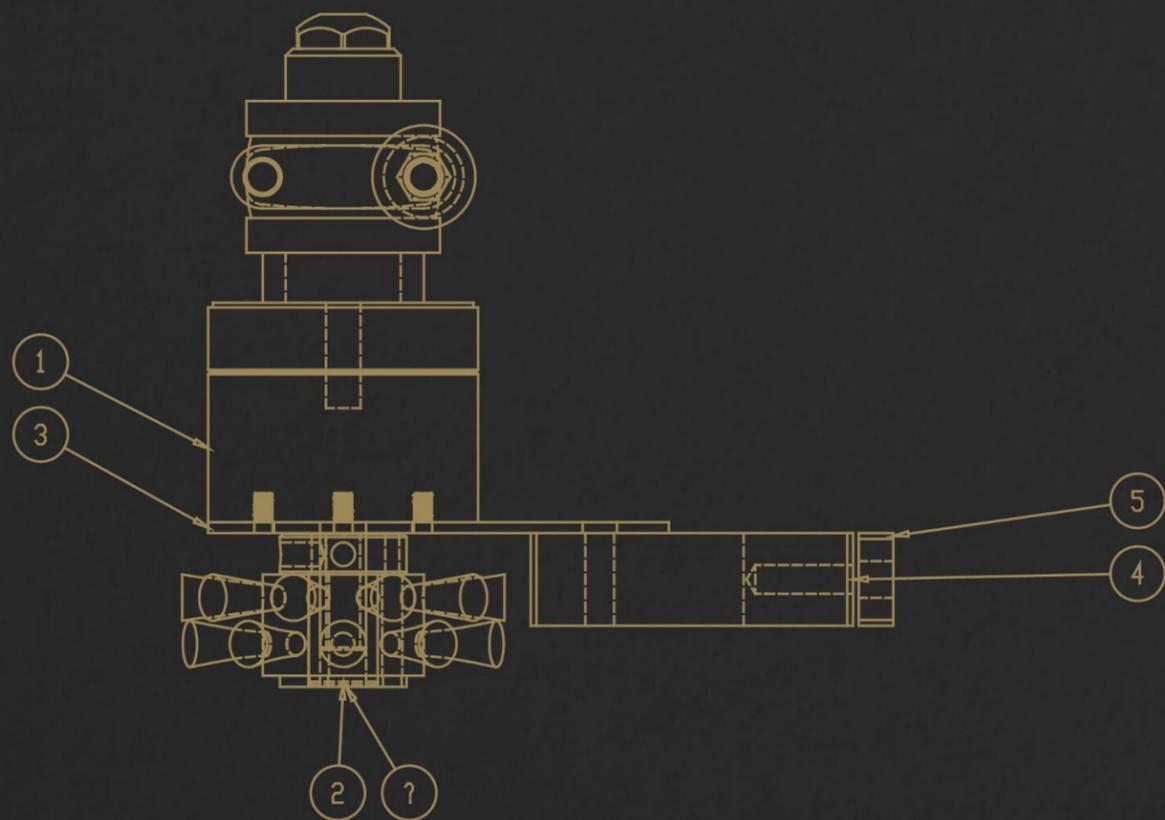
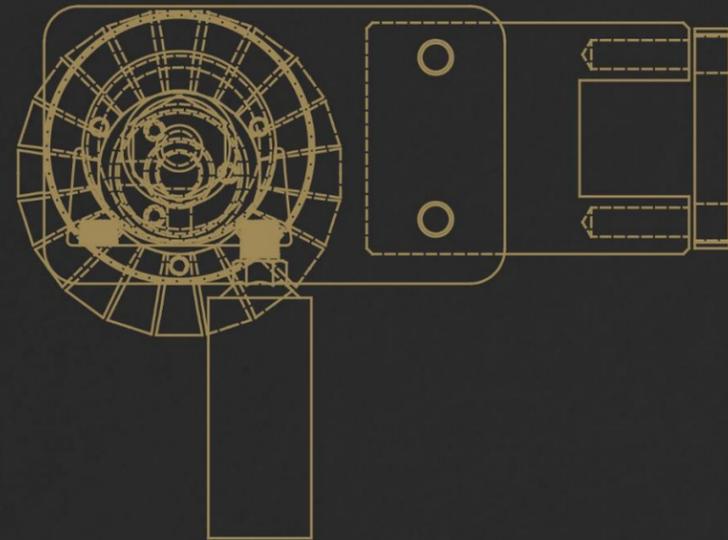
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DATE: 12/16/2019			PART NUMBER: VCA384-03-120
MATERIAL:			DESCRIPTION: CUP HOLDER ASSY
STOCK SIZE:	STOCK NUMBER:	FINISH:	SHEET SIZE
<small>UNLESS OTHERWISE SPECIFIED, BREAK ALL SHARP CORNERS, REMOVE ALL BURRS, AND STAMP OR ETCH PART NO. ON SURFACE</small>			SCALE: 1.5:1
REV.	DESCRIPTION	Sheet1 of 1	

ITEM NO.	PART NUMBER	DESCRIPTION	QTY.	ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	YMP000-04-109	END RAIL MOUNT	2	49	YMP000-04-135	STEEL RULES SCALE	3
2	VCA00A-04-102	TOMSON SHAFT Ø1 X 46.188	1	50	YMP000-04-136	SPROCKET	2
3	VCA00A-04-103	RAIL MOUNT	2	51	YMP000-04-137	IDLER TAKE-UP SPROCKET	1
4	VCA00A-04-104	CHAIN RAIL	2	52	164101	CHAIN RAIL SPACER	10
5	VCA00A-04-105	COVER FOR LIFTING DEVICE	1	53	VCA00A-04-100	MAIN FRAME 4	1
6	VCA384-04-306	SIDE CARTON RAIL	1	54	YMP000-04-125	TAKE UP HOLDER BRACKET	1
7	VCA00A-04-107	CHAIN RAIL MOUNT	1	55	VCA00A-04-111	MAGAZINE A CHAIN ASSY	2
8	VCA00A-04-108	CHAIN RAIL & CLUTCH MOUNT	1	56	VCA00A-04-112	MAG HEIGHT ADJ CHAIN	1
9	VCA00A-04-109	MAGAZINE CARRIAGE	1	57	YMP000-04-140	L-BRACKET MANIFOLD	1
10	164094	IDLER SPROCKETS FOR ANSI #35 R	2	58	164672	CONN LINK 35-2 CRS	1
11	164089	ROD END, FEMALE	1	59	VCA384-04-106	SIDE CARTON RAIL	1
12	164086	BEARING 2-BOLT FL .75 DIA	4	60	VCA384-99-024	HOLDING PLATE	1
13	164088	AIR CYLINDER	1	61	VCA384-99-030	PUSHER PLATE	1
14	164092	LINER BEARING PILLOW BLOCKS	1	62	VCA384-04-002	MOTOR BRUSH ASSY	1
15	164090	SS AIR CYLINDER NOSE-MOUNT, SP	2	63	VCA384-04-107	MAG CHAIN SPACER 1.25 LG	5
16	164091	TWO-PIECE COLLAR	2	64	VCA384-04-004	MAG ADJ STOP KIT	3
17	108938	PLASTIC KNOB - .63 DIA SHAFT	2	65	VCA384-01-196	MAG ADJ STANDOFF	2
18	164093	AR20 STYLE REGULATOR - 1/8	2	66	VCA384-04-224	END CARTON MID RAIL	1
19	163727	SWIVEL FOOT PAD	4	67	VCA384-01-256	POSITION INDICATOR	1
20	YMP000-04-139	HANDLE, CRANK, PLASTIC	1	68	VCA384-01-255	POSITION SCALE	1
21	164095	BALL BEARING	2				
22	164014	15MM BALL BEARING DOUBLE ROW	1				
23	164102	PIVOT MOUNT	1				
24	YMP000-04-106	DRIVE SHAFT	1				
25	VCA384-04-307	END CLAMP	7				
26	YMP000-04-138	MAGAZINE CLUTCH ASSEMBLY	1				
27	YMP000-04-111	LIFT SCREW 1-5	1				
28	YMP000-04-112	LIFT SCREW 1-5	1				
29	YMP000-04-113	FINGER CROSS SUPPORT	1				
30	YMP000-04-114	TAKE-UP PLATE	2				
31	YMP000-04-115	FINGER BRACKET	2				
32	YMP000-04-116	FINGER MOUNTS	2				
33	YMP000-04-117	TAKE-UP AIR CYLINDER MOUNT	2				
34	YMP000-04-118	PUSHER PLATE LIFT BLOCK	1				
35	YMP000-04-119	SIDE RAIL MOUNT	1				
36	YMP000-04-120	SMALL SIDE RAIL MOUNT	1				
37	YMP000-04-121	SIDE RAIL MOUNT	1				
38	VCA384-04-122	CARTON HOLD PLATE	2				
39	YMP000-04-123	MAGAZINE IDLER SHAFT	1				
40	VCA384-04-324	END CARTON RAIL	2				
41	YMP000-04-127	MTG PLATE FOR SPROCKETS	2				
42	YMP000-04-128	MAGAZINE TIE-IN BRKT	1				
43	YMP000-04-129	SPACER Ø1X .875	1				
44	YMP000-04-130	THREADED NUT 1-5	2				
45	YMP000-04-131	ACME NUT RETAINER	2				
46	YMP000-04-132	SLIDE SHAFT CLAMP BRKT	1				
47	YMP000-04-133	SLIDE SHAFT HOLDER BRKT	1				
48	YMP000-04-134	MULTIPLE STRAND SPROCKET	2				

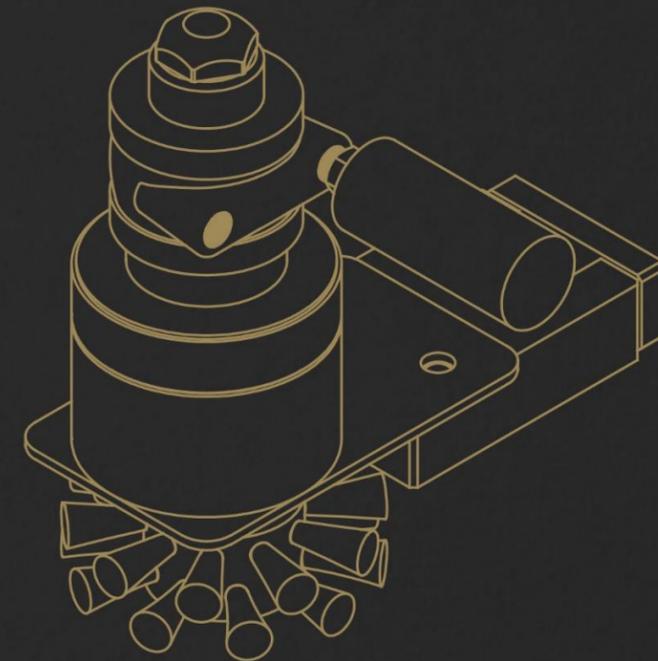


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DATE:			
MATERIAL:			PART NUMBER:
STOCK SIZE:			VCA384-04-001
STOCK NUMBER:	FINISH:	DESCRIPTION:	
		4 CARTON MAGAZINE - CW ASSEMB	
UNLESS OTHERWISE SPECIFIED, BREAK ALL SHARP CORNERS, REMOVE ALL BURRS, AND STAMP OR ETCH PART NO. ON SURFACE.		SHEET SIZE:	SCALE: 1/2
		Sheet1 OF 2	

REV.	DESCRIPTION



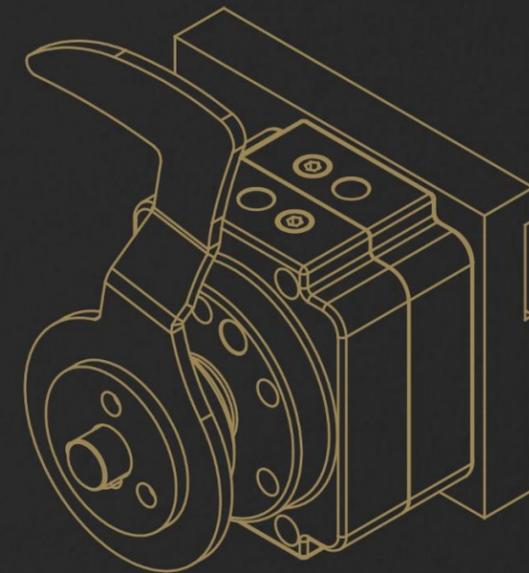
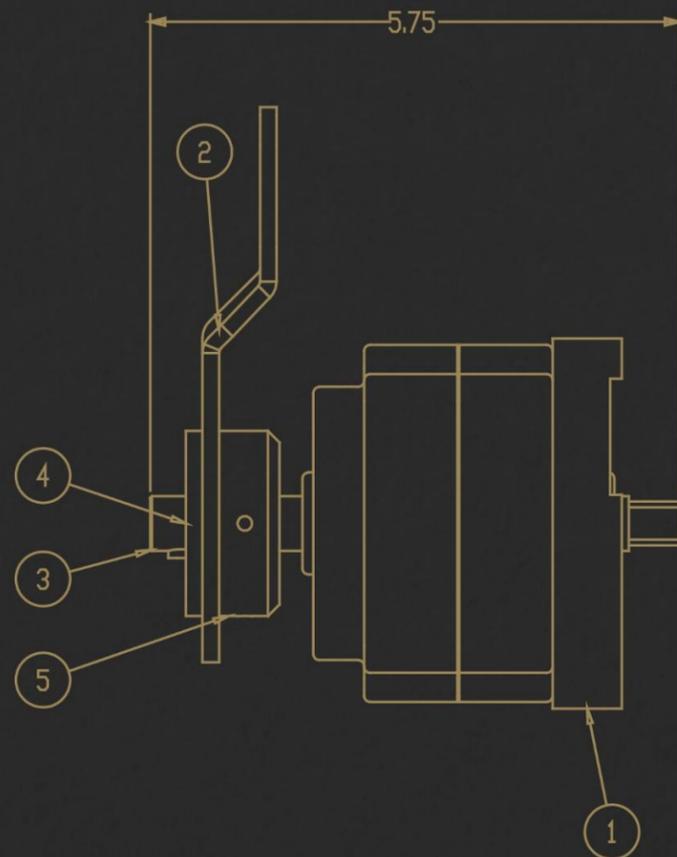
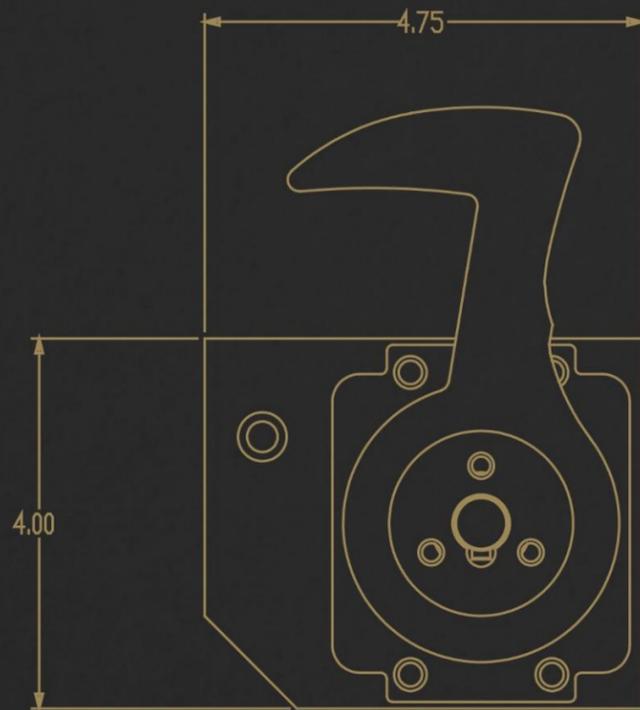
ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	164874	AIR MOTOR	1
2	VCA384-04-003	BRUSH HOLDER ASSY	1
3	VCA384-04-104	MOTOR MOUNT PLATE	1
4	VCA384-04-123	MOTOR MOUNT CLAMP	1
5	VCA384-04-124	CLAMP PLATE	1



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DATE: 3/24/2020	MATERIAL:		PART NUMBER: VCA384-04-002
	STOCK SIZE:		DESCRIPTION: MOTOR BRUSH ASSY
	STOCK NUMBER:	FINISH:	SHEET SIZE
<small>UNLESS OTHERWISE SPECIFIED, BREAK ALL SHARP CORNERS, REMOVE ALL BURRS, AND STAMP OR ETCH PART NO. ON SURFACE.</small>			SCALE: 1/2
REV.	DESCRIPTION		Sheet1 OF 1



ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	VCA384-75-104	LOWER TUCKER MOUNT	1
2	VCA384-75-103	TUCKER - CARTON	1
3	164300	ROTARY ACTUATOR 90DEG 63MM VANE STYLE RC PORTS	1
4	VCA384-75-101	HUB PLATE MNT CAP	1
5	VCA384-75-102	ADJUSTABLE HUB	1



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DATE: 1/30/2020		
MATERIAL:		
STOCK SIZE:		
STOCK NUMBER:	FINISH:	
UNLESS OTHERWISE SPECIFIED, BREAK ALL SHARP CORNERS, REMOVE ALL BURRS, AND STAMP OR ETCH PART NO. ON SURFACE.		

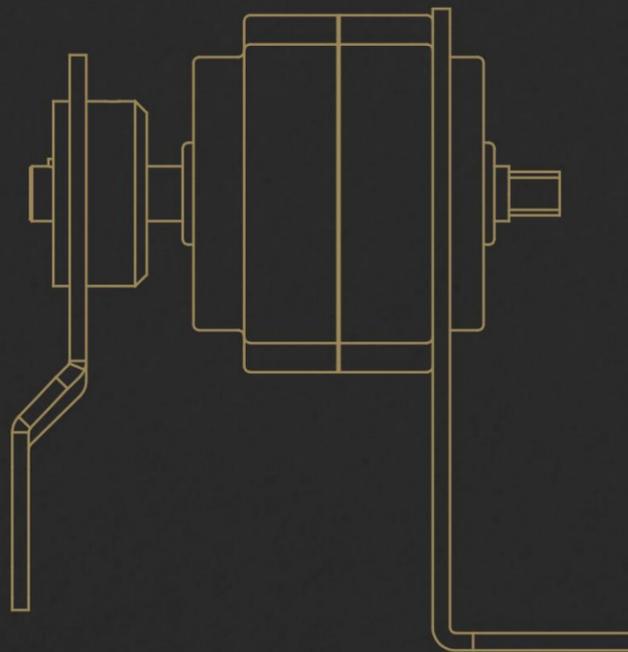
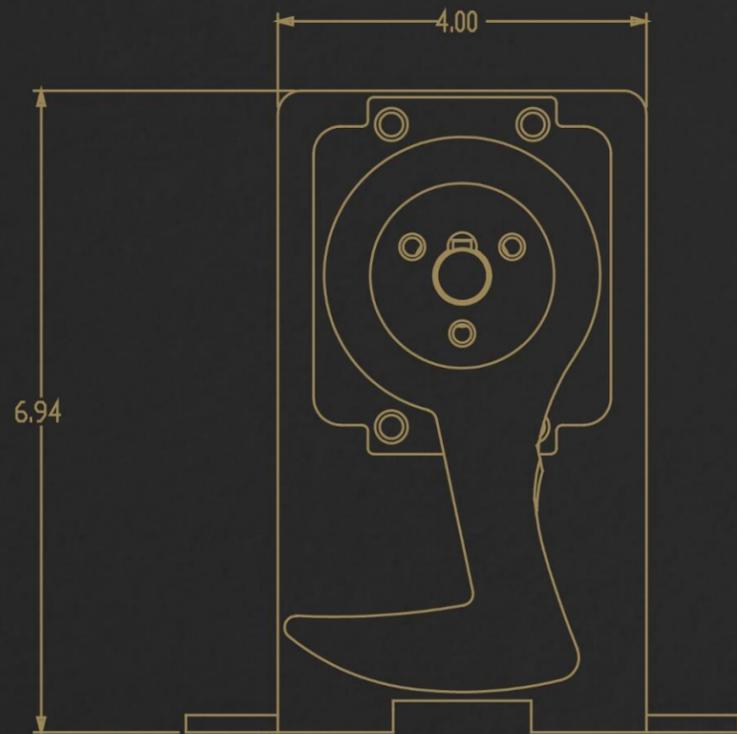
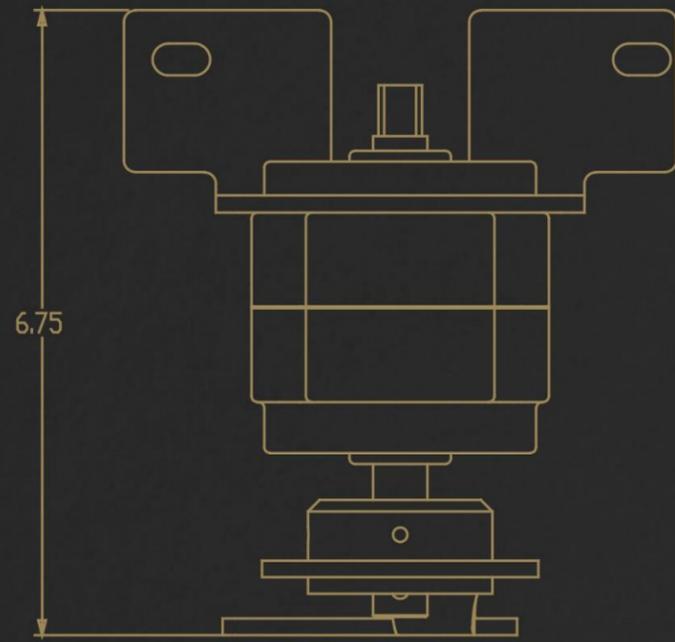
Yeaman

PART NUMBER: VCA384-75-001

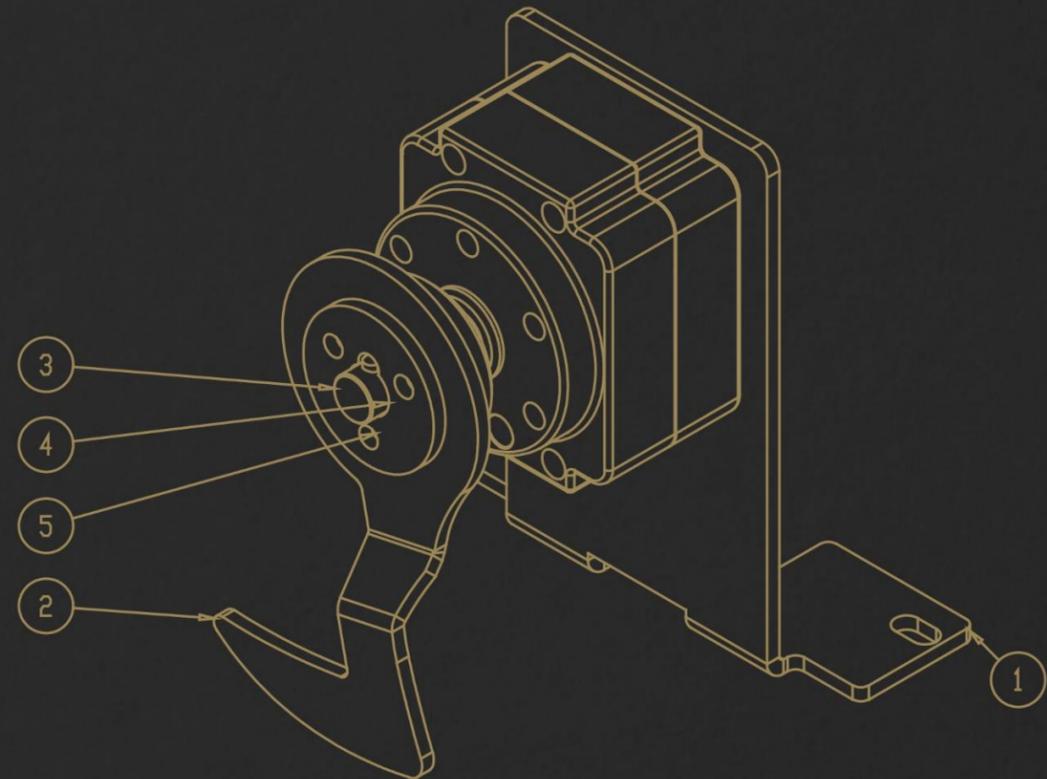
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SHEET SIZE: SCALE: 1/2 Sheet 1 OF 1

REV.	DESCRIPTION

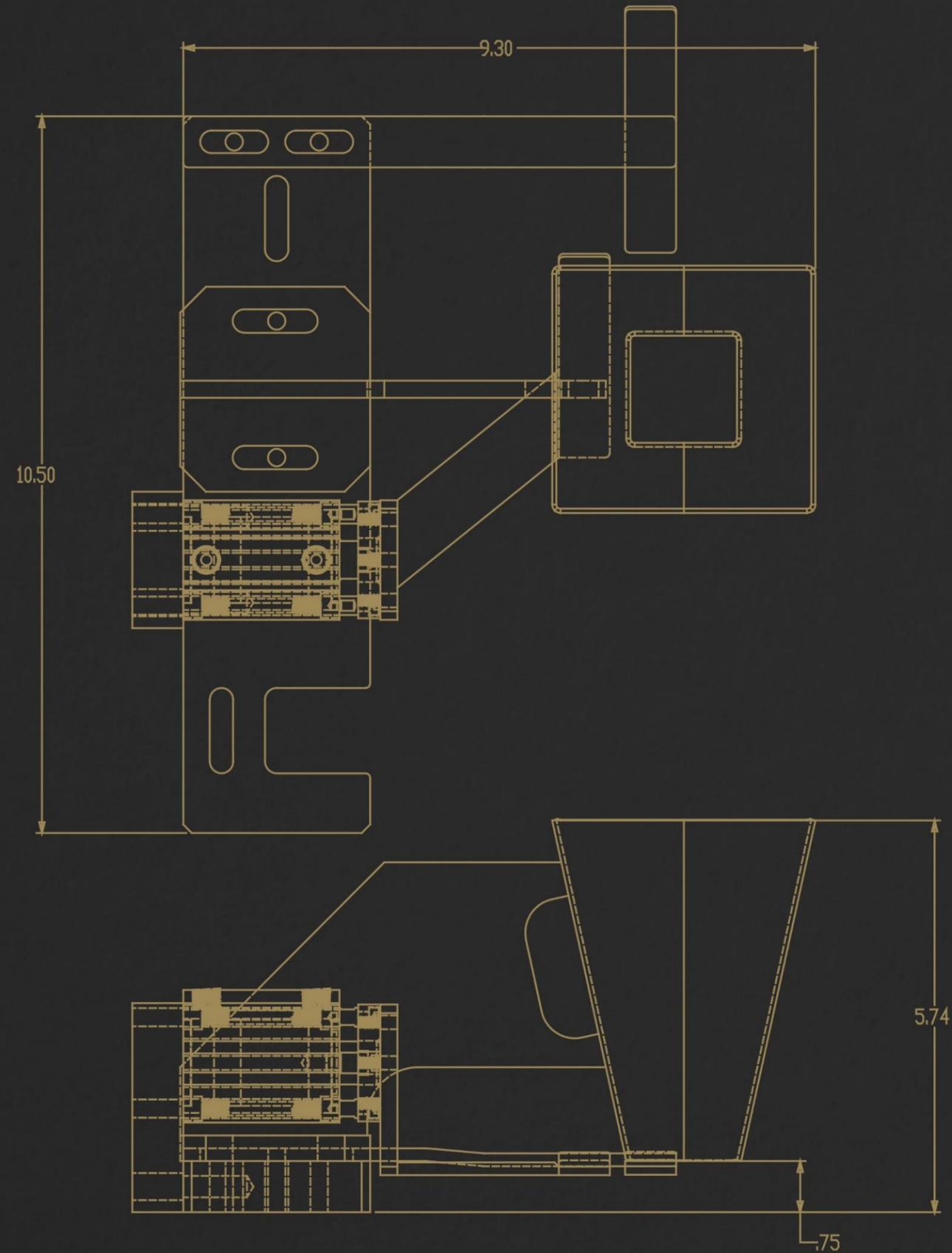


ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	VCA384-75-106	UPPER TUCKER MOUNT	1
2	VCA384-75-103	TUCKER - CARTON	1
3	164300	ROTARY ACTUATOR 90DEG 63MM VANE STYLE RC PORTS	1
4	VCA384-75-101	HUB PLATE MNT CAP	1
5	VCA384-75-102	ADJUSTABLE HUB	1

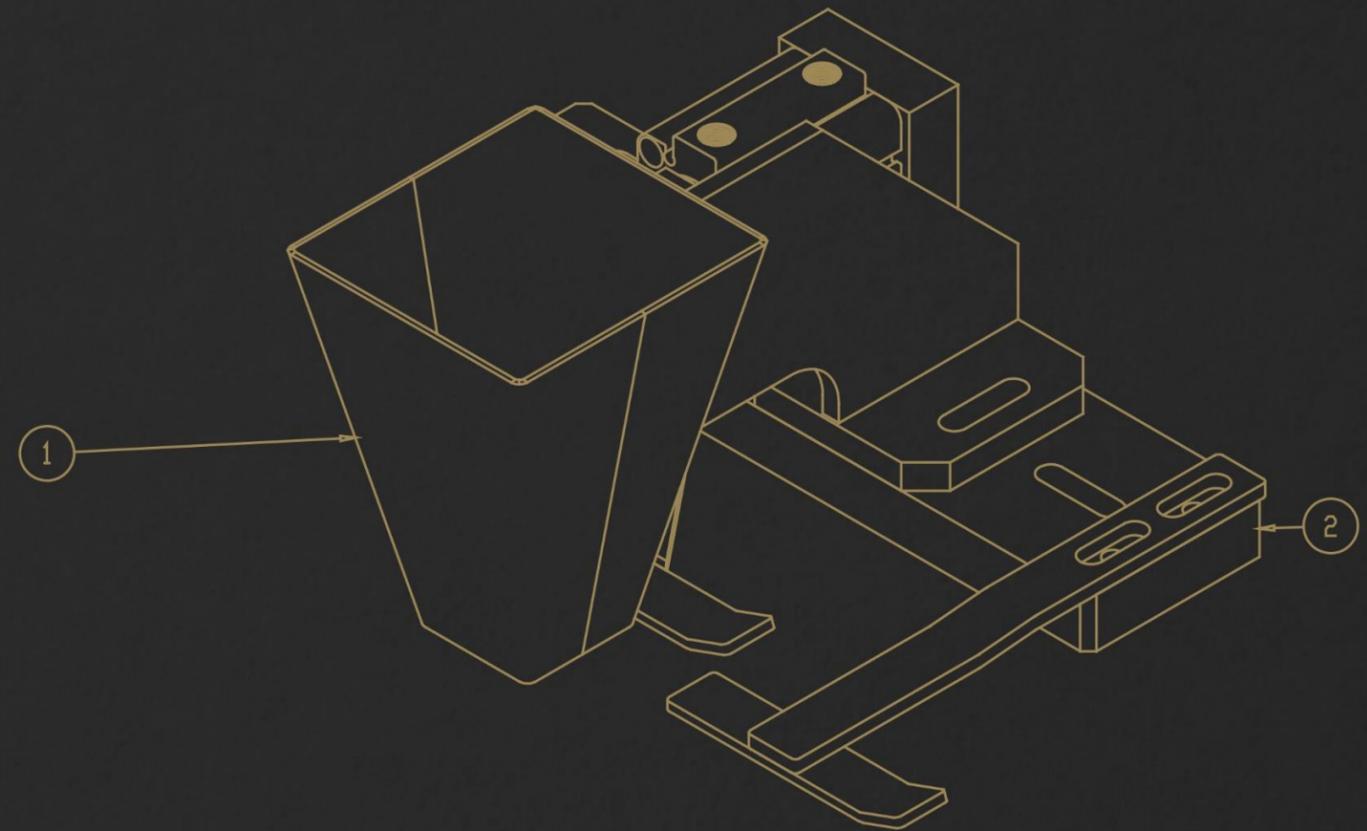


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DATE: 1/30/2020	MATERIAL:		PART NUMBER: VCA384-75-003
	STOCK SIZE:		DESCRIPTION: LOWER CARTON TUCKER ASSY
	STOCK NUMBER:	FINISH:	SHEET SIZE: SCALE: 1/2 Sheet1 OF 1
<small>UNLESS OTHERWISE SPECIFIED, BREAK ALL SHARP CORNERS, REMOVE ALL BURRS, AND STAMP OR ETCH PART NO. ON SURFACE</small>			

REV.	DESCRIPTION



ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	VCA384-99-011	CARTON DROP CHUTE	1
2	VCA384-01-175	CHUTE MOUNT	1
3	VCA384-01-170	LEAD FLAP PLOW	1
4	VCA384-01-173	CARTON PLOW1	1



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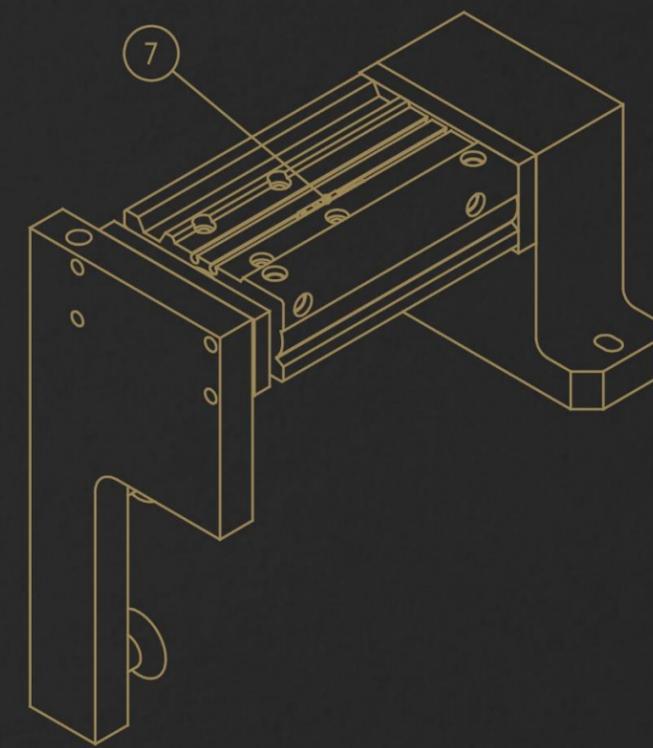
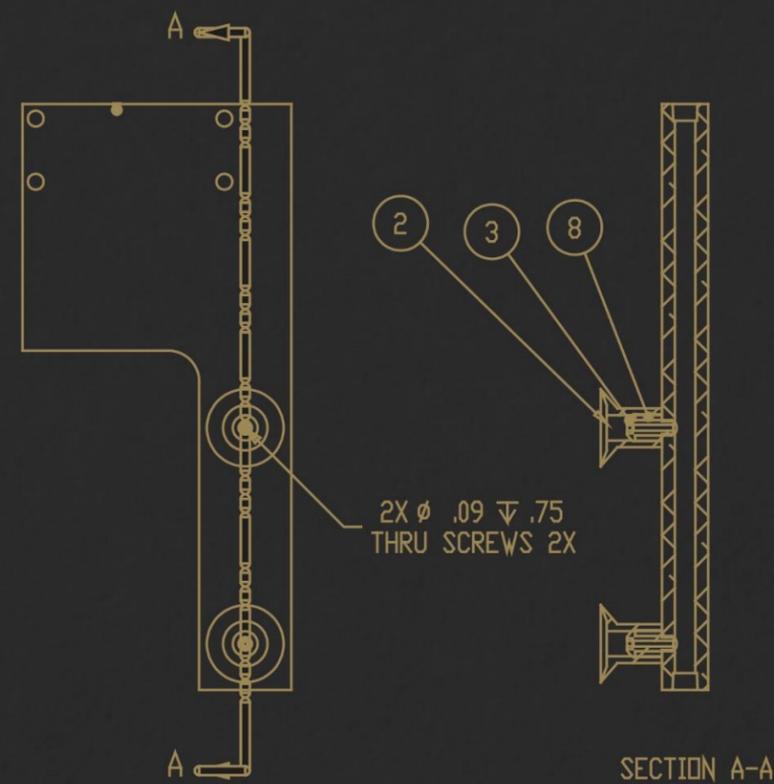
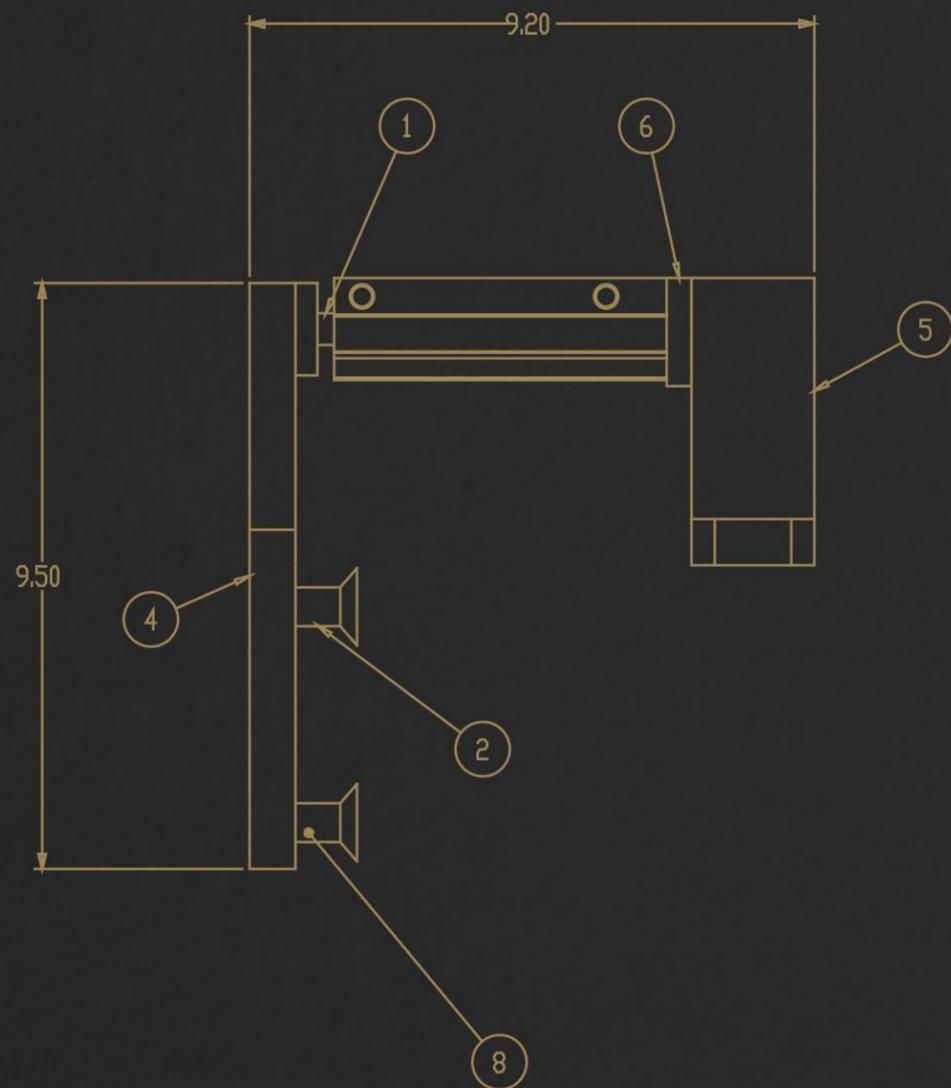


MATERIAL:	STOCK SIZE:	STOCK NUMBER:	FINISH:
UNLESS OTHERWISE SPECIFIED, BREAK ALL SHARP CORNERS, REMOVE ALL BURRS, AND STAMP OR ETCH PART NO. ON SURFACE.			

PART NUMBER: VCA384-99-010
DESCRIPTION: CHUTE MOUNT ASSY
SHEET SIZE: SCALE: 1/2 Sheet1 OF 1

REV.	DESCRIPTION

ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	164231	THRUSTER 25MM X 75LG	1
2	165127	SUCTION CUP 1.25 X 1.00 X .41	2
3	123030	SCREW, BUTTON SOCKET HEAD, S.S., 1/4-20"x.63" LG.	2
4	VCA384-99-021	VACCUUM ARM	1
5	VCA384-99-022	DISCHARGE MOUNT	1
6	VCA384-99-023	SPACER	1
7	156430	AUTO SWITCH PNP .5M CORD M12 CONNECTOR	1
8	VCA384-03-200	SPACER VAC CUP	2



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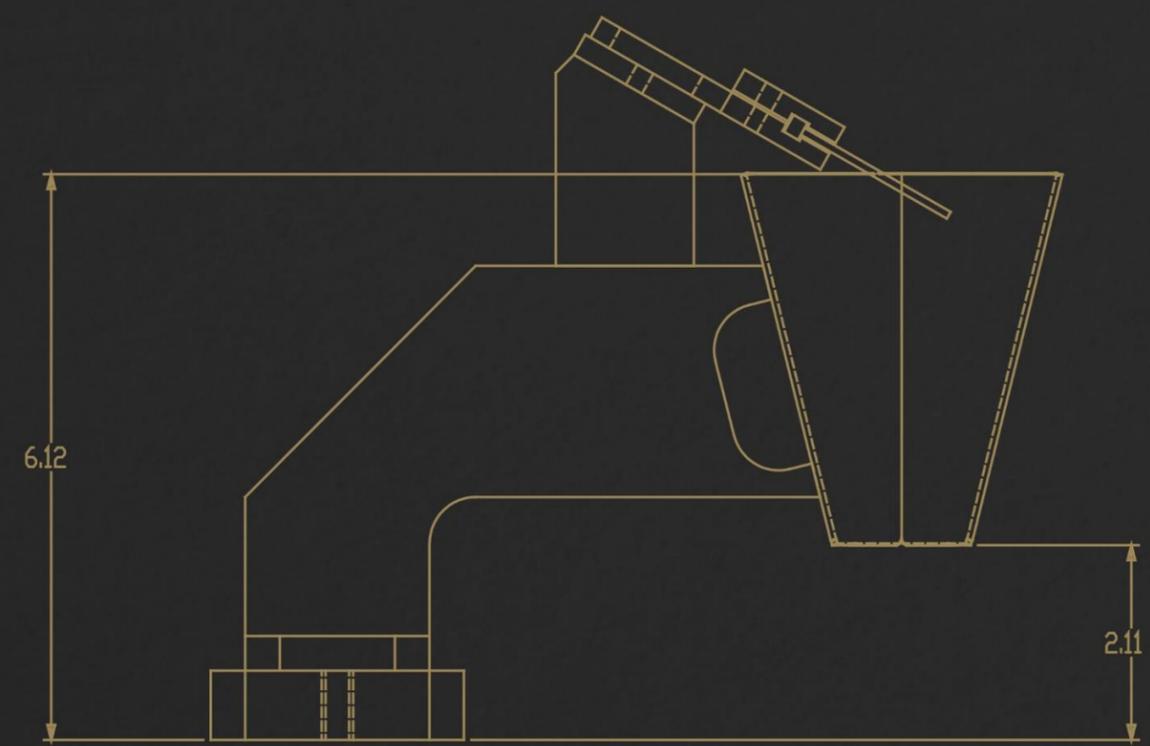
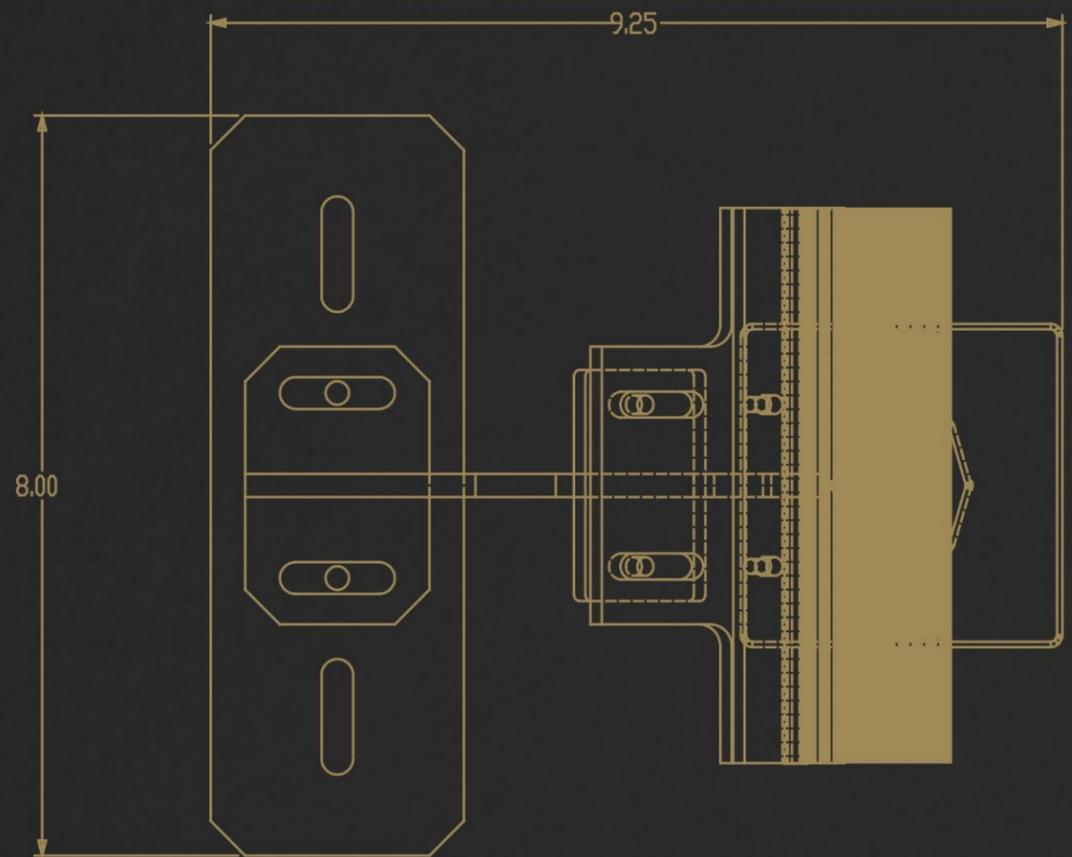
Yeaman

PART NUMBER: VCA384-99-020

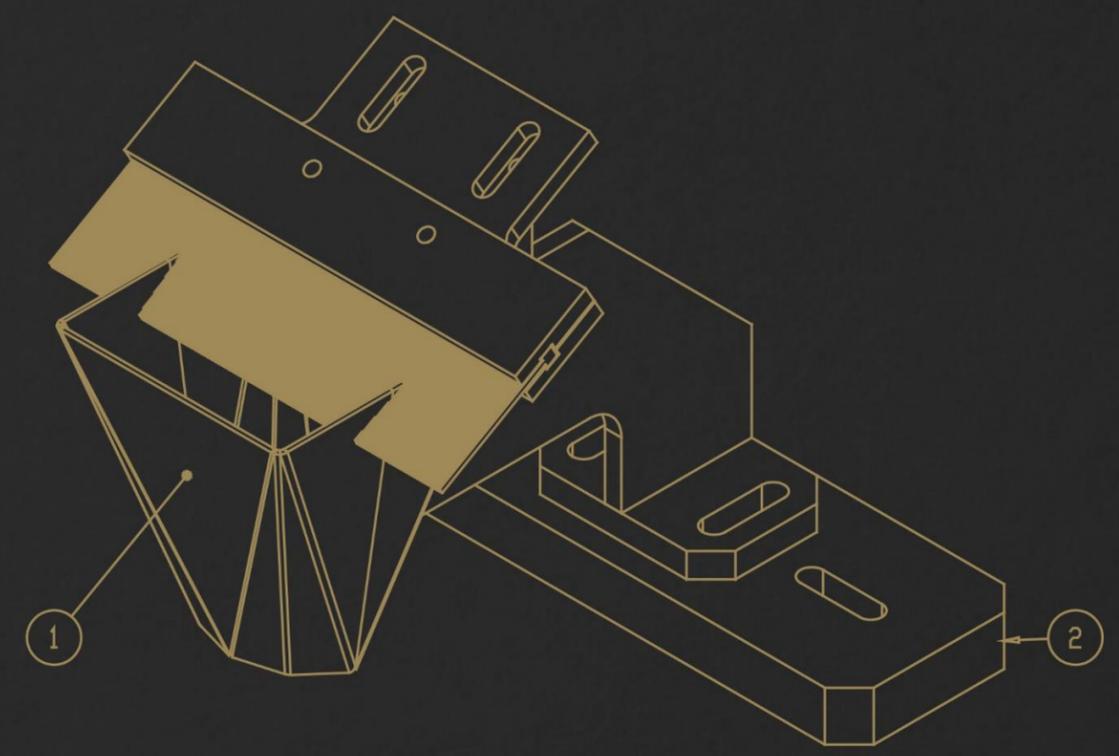
DESCRIPTION: DISCHARGE ASSY

SHEET SIZE: SCALE: 1:3 Sheet 1 OF 1

REV.	DESCRIPTION



ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	VCA384-99-111	CARTON DROP CHUTE	1
2	VCA384-99-012	CHUTE MOUNT	1
3	VCA384-99-140	BRUSH ASSY 1	1



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MATERIAL:		
STOCK SIZE:		
STOCK NUMBER:	FINISH:	
UNLESS OTHERWISE SPECIFIED, BREAK ALL SHARP CORNERS, REMOVE ALL BURRS, AND STAMP OR ETCH PART NO. ON SURFACE.		



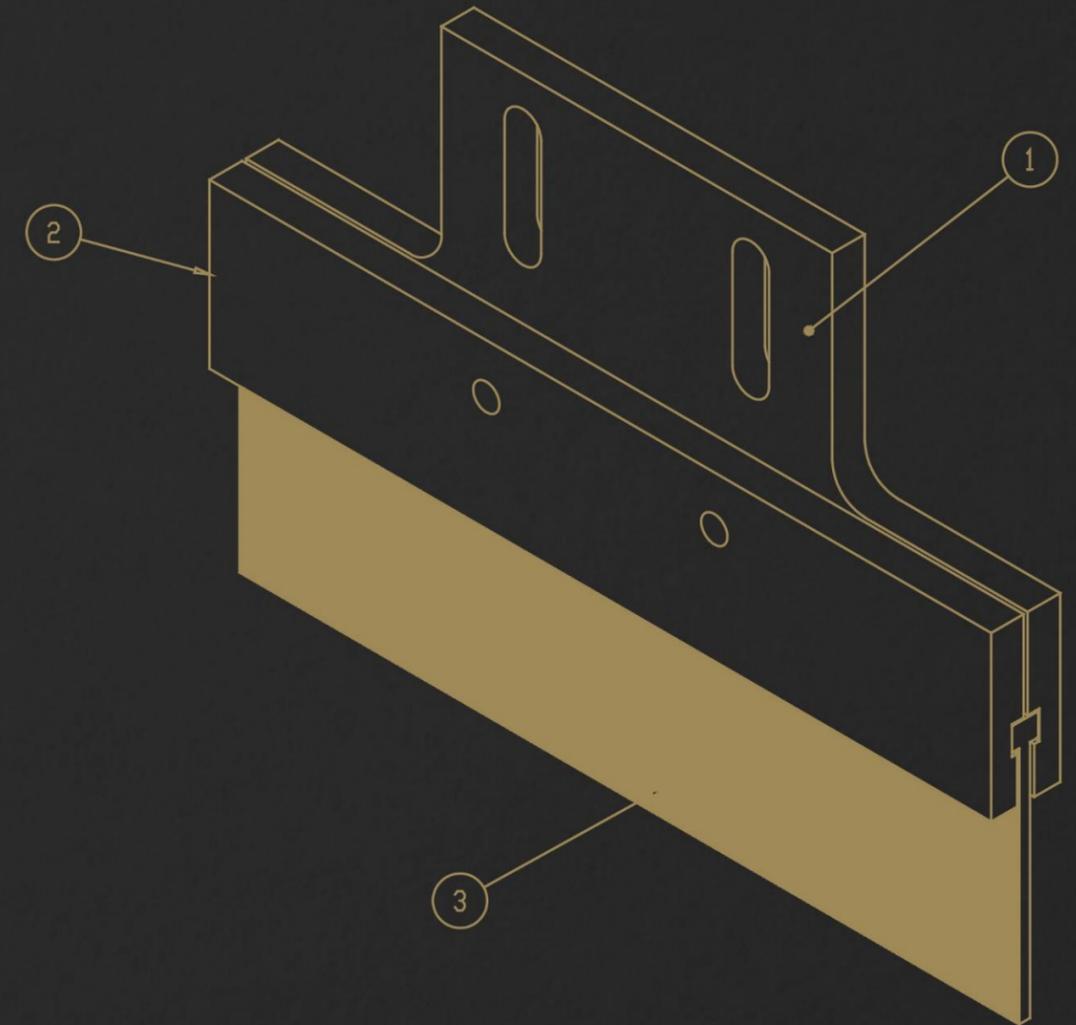
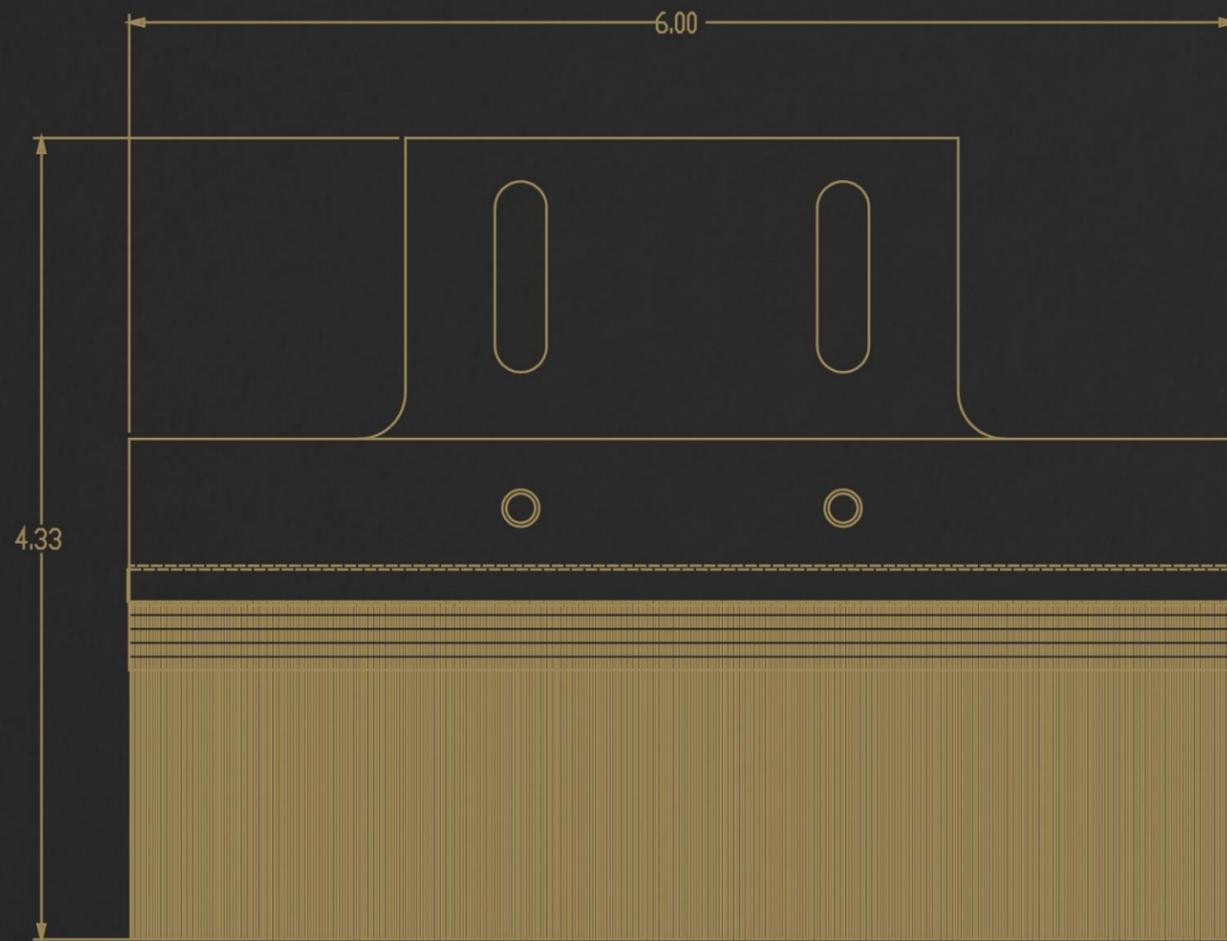
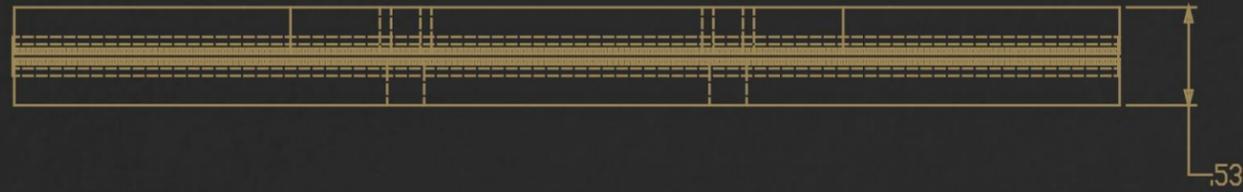
PART NUMBER: VCA384-99-110

DESCRIPTION: ESCAPEMENT CHUTE ASSY

SHEET SIZE: SCALE: 1/2 Sheet 1 OF 1

REV.	DESCRIPTION

ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	VCA384-99-141	BRUSH MTG PLATE	1
2	VCA384-99-142	BRUSH CLAMP	1
3	VCA384-99-143	BRUSH L-6'	1



DESIGNED BY: ML	LINEAR X ± 0.020 .XX ± 0.010 .XXX ± 0.005	ANGULAR X ± 2° .X ± 1° .XX ± 0° 30'
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DATE: 11/14/2019		
MATERIAL:		
STOCK SIZE:		
STOCK NUMBER:	FINISH:	
UNLESS OTHERWISE SPECIFIED, BREAK ALL SHARP CORNERS, REMOVE ALL BURRS, AND STAMP OR ETCH PART NO. ON SURFACE.		

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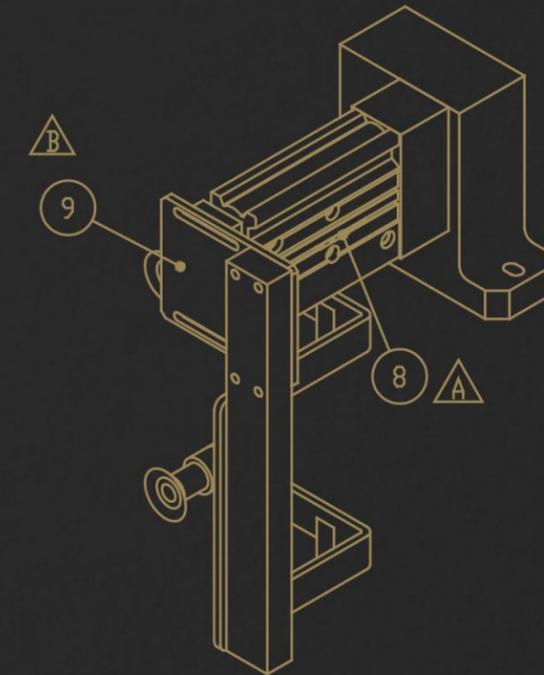
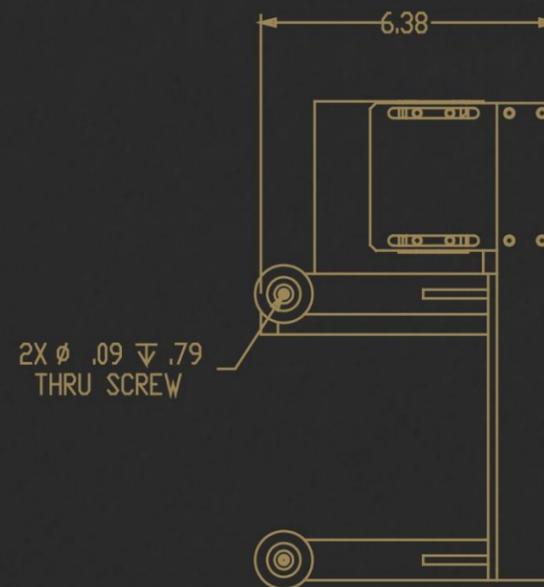
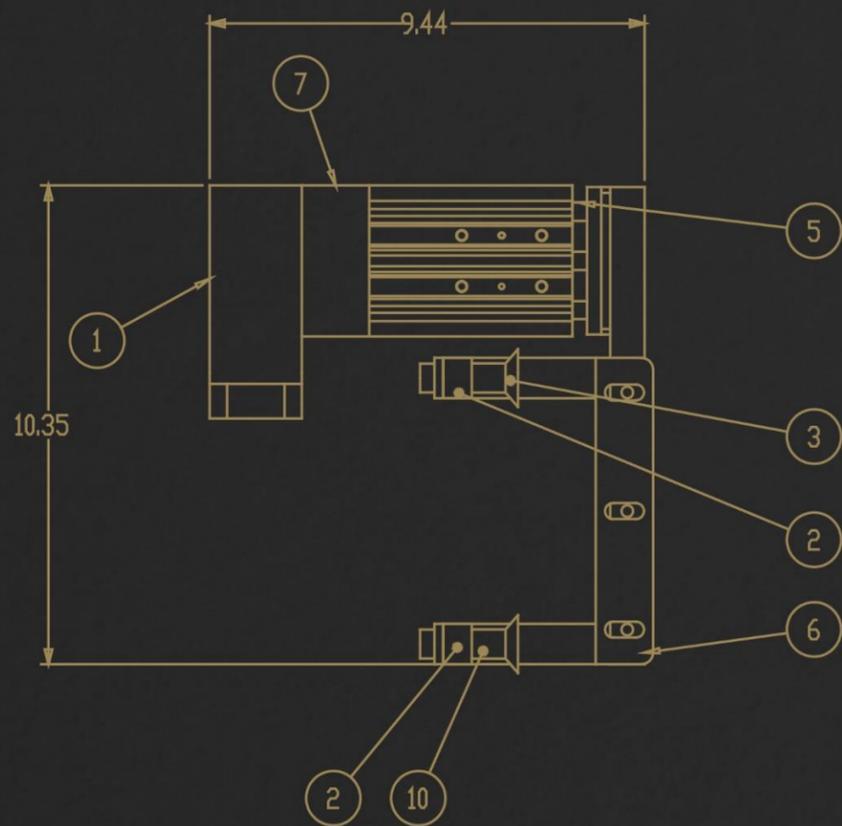
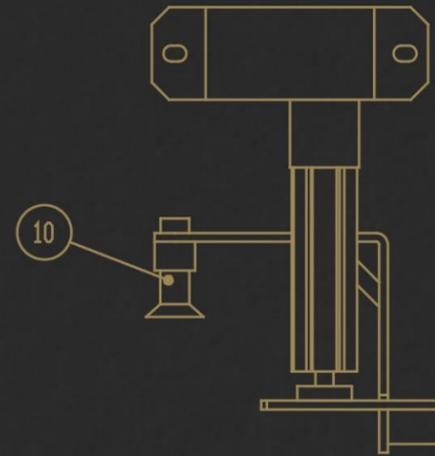
PART NUMBER: VCA384-99-140

DESCRIPTION: BRUSH ASSY 1

SHEET SIZE: SCALE: 1:1 Sheet 1 OF 1

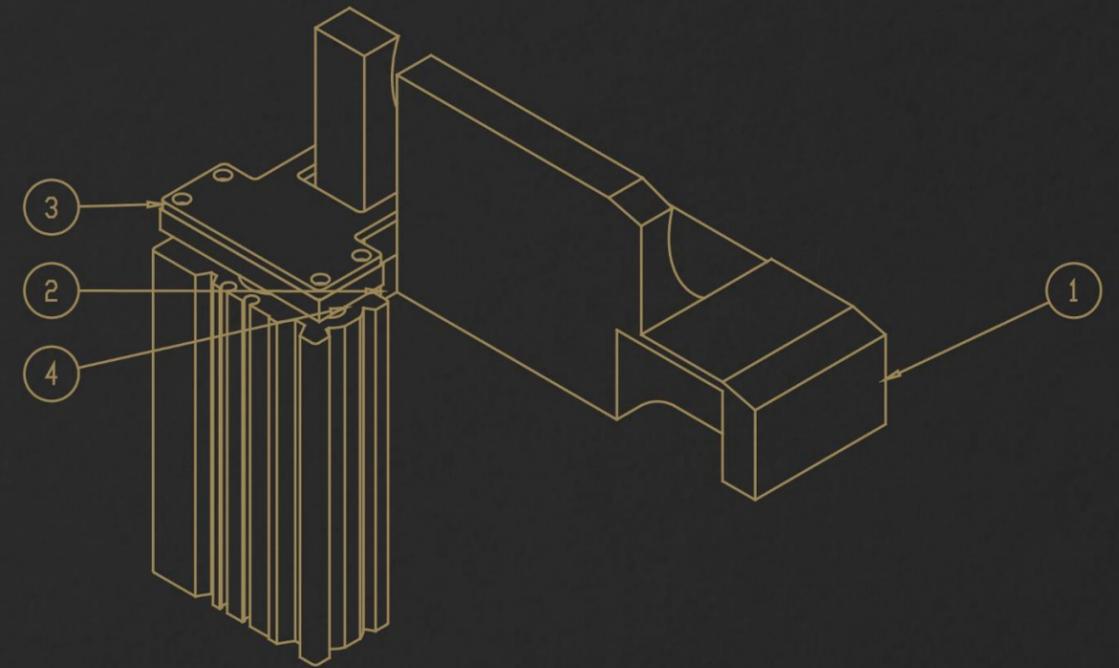
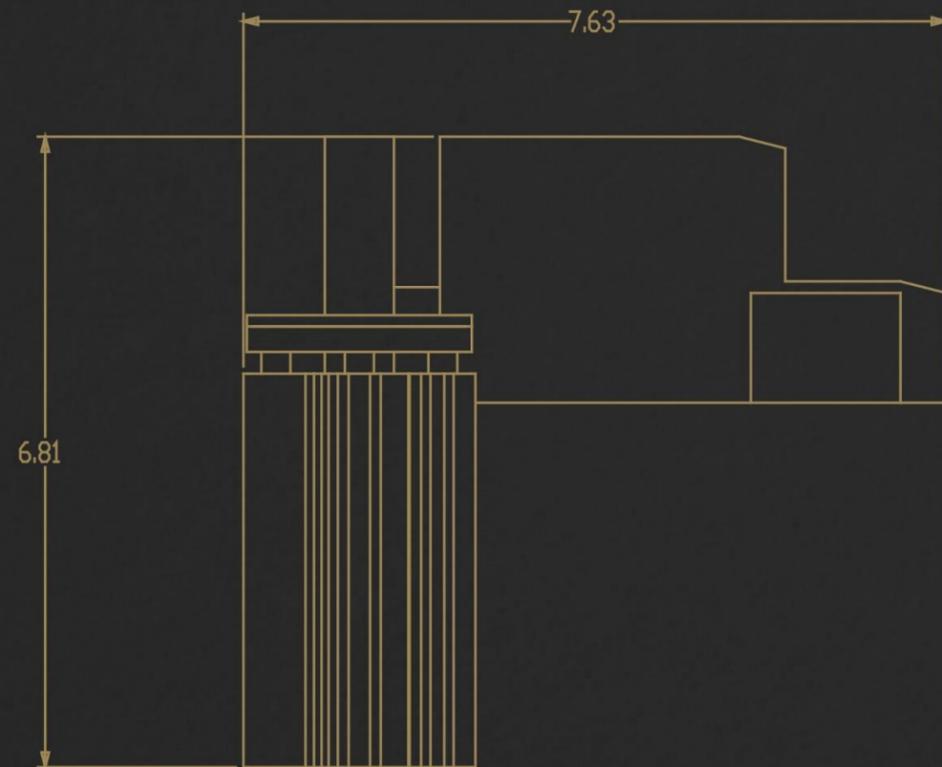
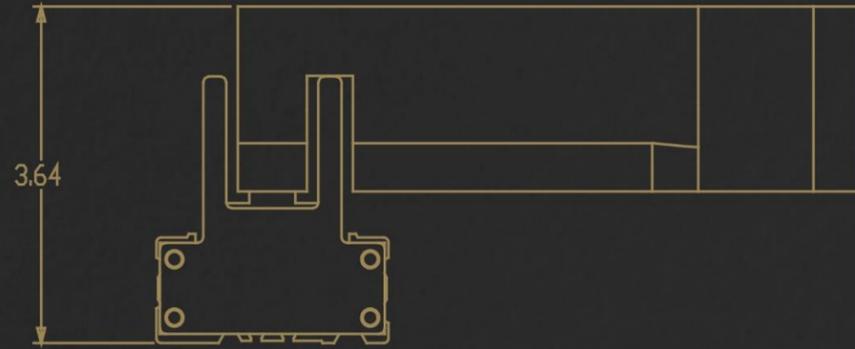
REV.	DESCRIPTION

ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	VCA384-99-132	DISCHARGE MOUNT	1
2	VCA384-99-131	DISCHARGE ARM CUP MOUNT	1
3	165127	SUCTION CUP 1.25 X 1.00 X .41	2
4	123030	SCREW, BUTTON SOCKET HEAD, S.S., 1/4-20"X.63" LG.	2
5	164279	LINEAR GUIDED CYLINDER 20MM BORE X 50MM STROKE	1
6	VCA384-99-133	DISCHARGE CUP ARM	1
7	VCA384-99-134	DISCHARGE ARM SPACER	1
8	156430	AUTO SWITCH PNP .5M CORD M12 CONNECTOR	1
9	VCA384-99-135	OFFSET PLATE OPENER	1
10	VCA384-03-200	SPACER VAC CUP	2



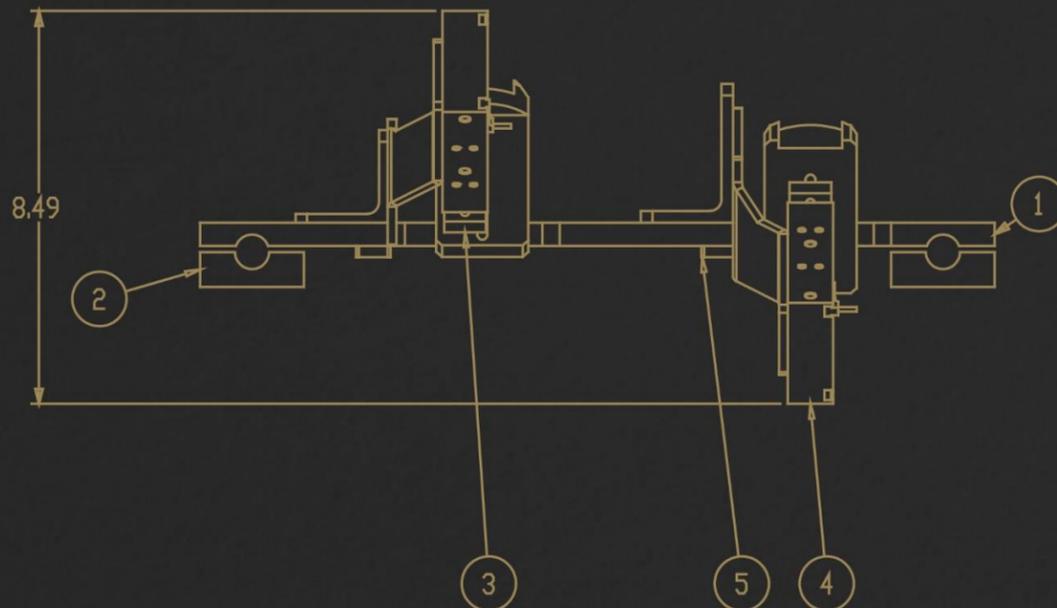
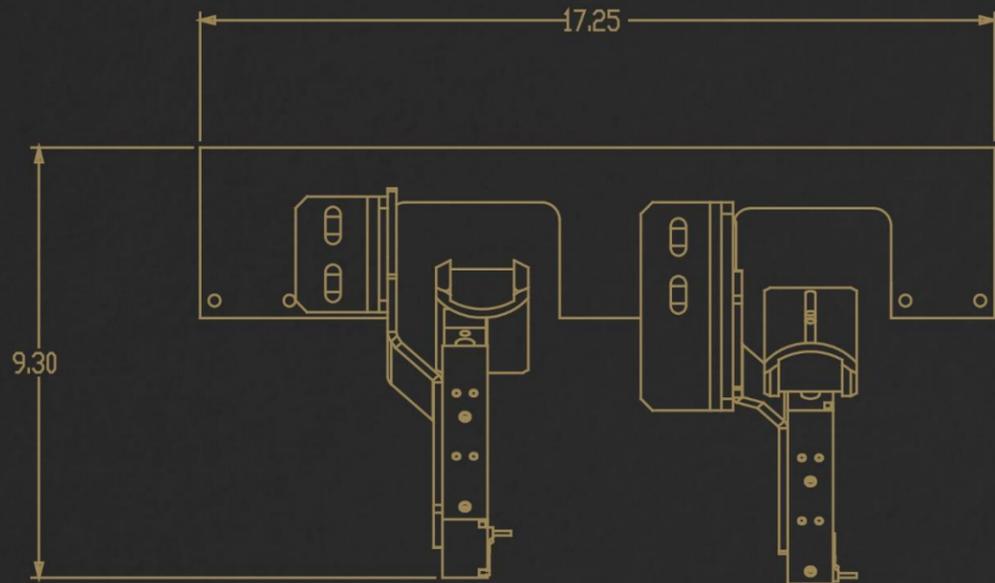
DESIGNED BY: ML	LINEAR X ± 0.020 .XX ± 0.010 .XXX ± 0.005	ANGULAR X ± 2° .X ± 1° .XX ± 0° 30'	
DRAWN BY:	<small>THE USE OR DUPLICATION OF THIS DOCUMENT OR ITS CONTENTS WITHOUT THE EXPRESSED WRITTEN CONSENT OF COLBORNE FOODBOTICS, LLC IS STRICTLY PROHIBITED.</small>		
DATE: 1/29/2020	MATERIAL:		PART NUMBER: VCA384-99-130
	STOCK SIZE:		DESCRIPTION: CARTON SETUP PLASTIC
	STOCK NUMBER:	FINISH:	SHEET SIZE
	UNLESS OTHERWISE SPECIFIED, BREAK ALL SHARP CORNERS, REMOVE ALL BURRS, AND STAMP OR ETCH PART NO. ON SURFACE.		SCALE: 1:4
REV.:	DESCRIPTION		Sheet1 OF 1

ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	VCA384-99-162	CARTON FOIL BLOCK	1
2	VCA384-99-163	FOIL AIR CYL MOUNT	1
3	VCA384-99-164	CARTON TUCKER	1
4	164381	THRUSTER 16MM BORE X 50MM STROKE	1

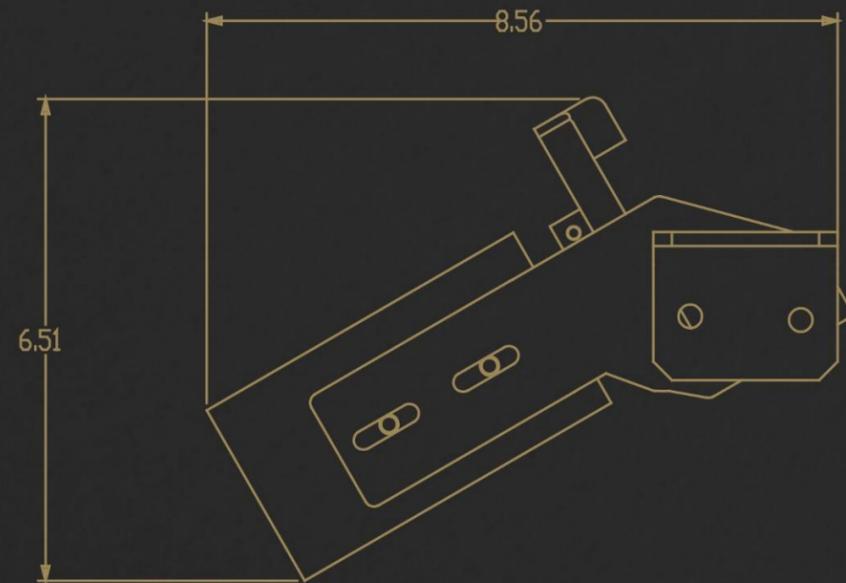
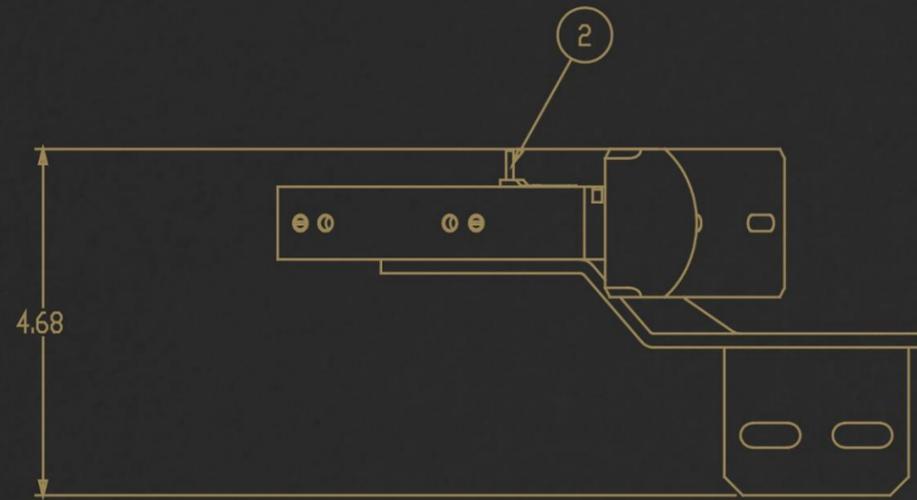


DESIGNED BY: ML	LINEAR .X ± 0.020 .XX ± 0.010 .XXX ± 0.005	ANGULAR X ± 2° .X ± 1° .XX ± 0° 30'	
DRAWN BY:	<small>THE USE OR DUPLICATION OF THIS DOCUMENT OR ITS CONTENTS WITHOUT THE EXPRESSED WRITTEN CONSENT OF COLBORNE FOODBOTICS, LLC IS STRICTLY PROHIBITED.</small>		
DATE: 4/14/2020			PART NUMBER: VCA384-99-170
MATERIAL:			DESCRIPTION: CARTON TUCK ASSY
STOCK SIZE:			SHEET SIZE
STOCK NUMBER:	FINISH:	SCALE: 1/2	
<small>UNLESS OTHERWISE SPECIFIED, BREAK ALL SHARP CORNERS, REMOVE ALL BURRS, AND STAMP OR ETCH PART NO. ON SURFACE.</small>			Sheet1 OF 1

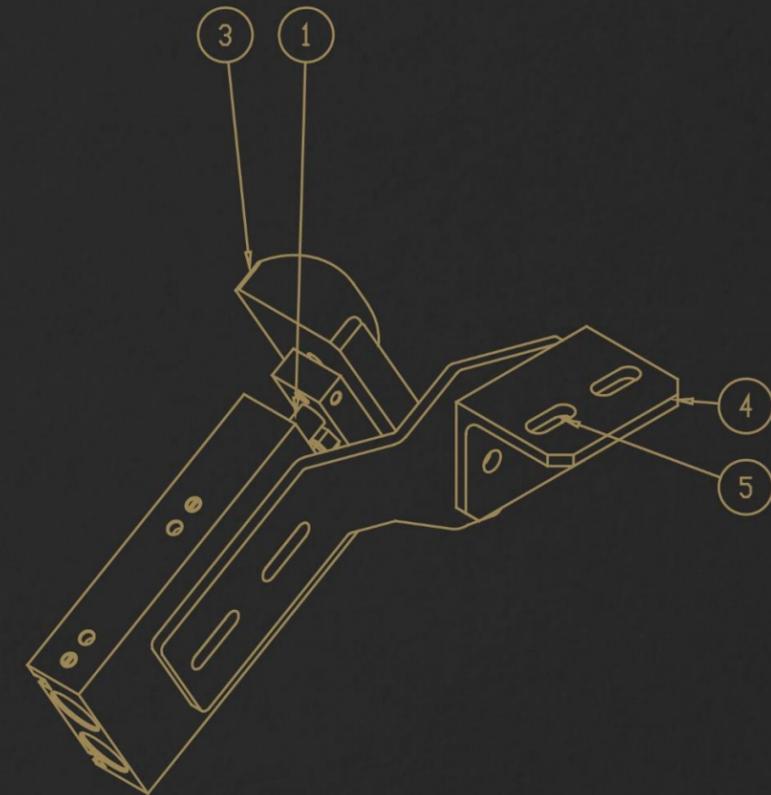
ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	VCA384-99-311	TOOL PLATE CHANGE	1
2	VCA384-01-212	TOO PLATE CLAMP	2
3	VCA384-99-315	PLASTIC PUSHER ASSY 2	1
4	VCA384-99-316	PLASTIC PUSHER ASSY 3	1
5	VCA384-01-163	NUT PLATE	2



DESIGNED BY: ML	LINEAR .X ± 0.020 .XX ± 0.010 .XXX ± 0.005	ANGULAR X ± 2° .X ± 1' .XX ± 0° 30'	
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DATE: 2/3/2020			PART NUMBER: VCA384-99-310
MATERIAL:			DESCRIPTION: BOTTOM CARTON CLOSER ASSY
STOCK SIZE:	STOCK NUMBER:	FINISH:	SHEET SIZE
<small>UNLESS OTHERWISE SPECIFIED, BREAK ALL SHARP CORNERS, REMOVE ALL BURRS, AND STAMP OR ETCH PART NO. ON SURFACE.</small>			SCALE: 1:4
REV.	DESCRIPTION		Sheet1 OF 1

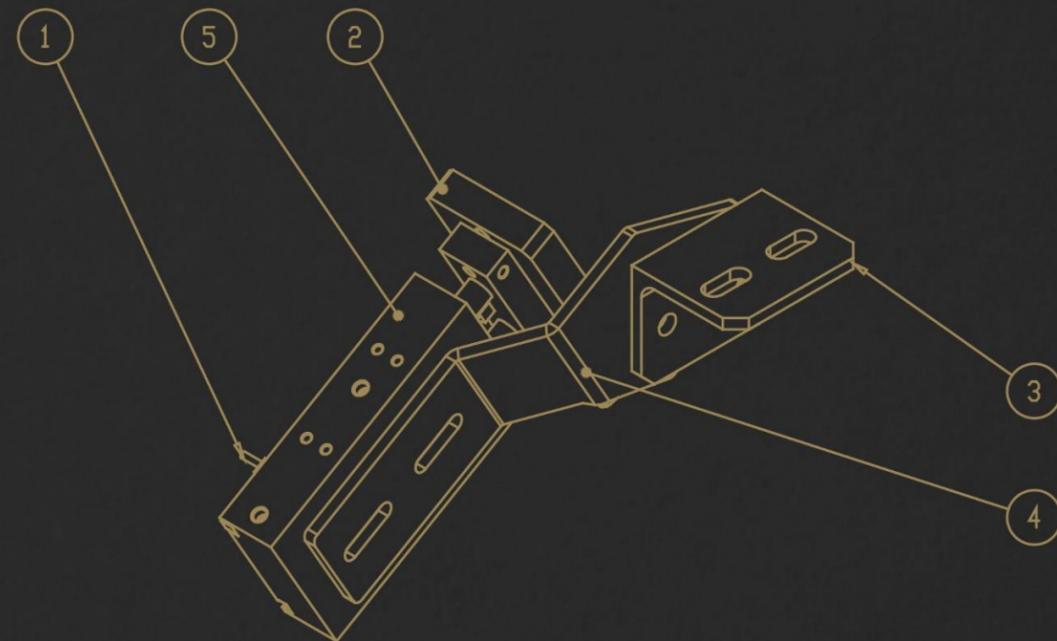
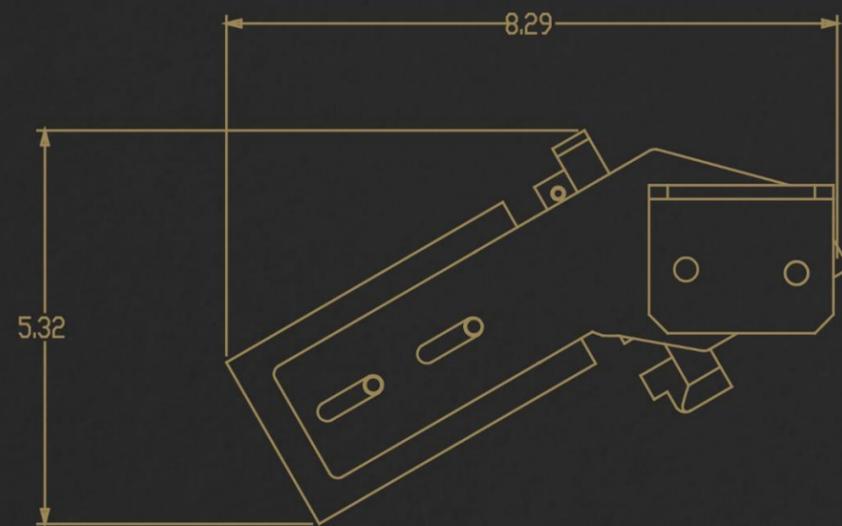
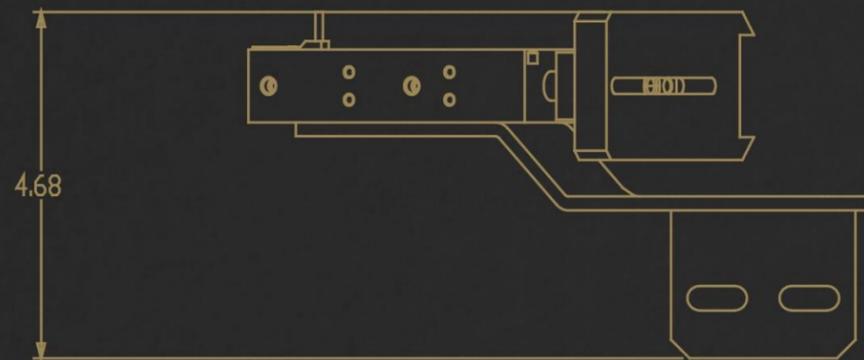


ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	164394	AIR CYL 20MM BORE X 50MM STROKE DUAL PISTON GUIDED	1
2	164395	CYLINDER SWITCH M12-4 PNP 3 WIRE 2-COLOR .5M CORD	1
3	VCA384-99-312	PLASTIC PUSHER TOOL	1
4	VCA384-99-332	CYL MOUNT BRACKET 2 X 2	1
5	VCA384-99-333	SLOTTED BRACKET 7.0 LG	1



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DATE: 2/5/2020	MATERIAL:		PART NUMBER: VCA384-99-314
STOCK SIZE:			DESCRIPTION: PLASTIC PUSHER ASSY 1
STOCK NUMBER:		FINISH:	SHEET SIZE
<small>UNLESS OTHERWISE SPECIFIED, BREAK ALL SHARP CORNERS, REMOVE ALL BURRS, AND STAMP OR ETCH PART NO. ON SURFACE.</small>			SCALE: 1:2.5
REV.	DESCRIPTION	Sheet 1 OF 1	

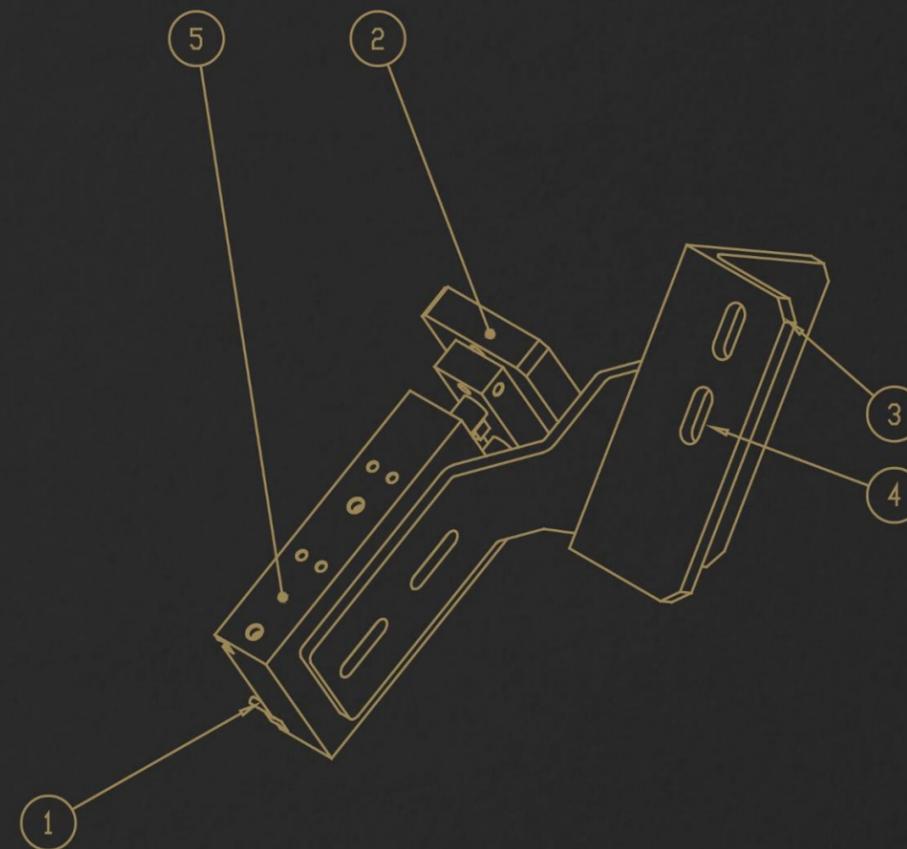
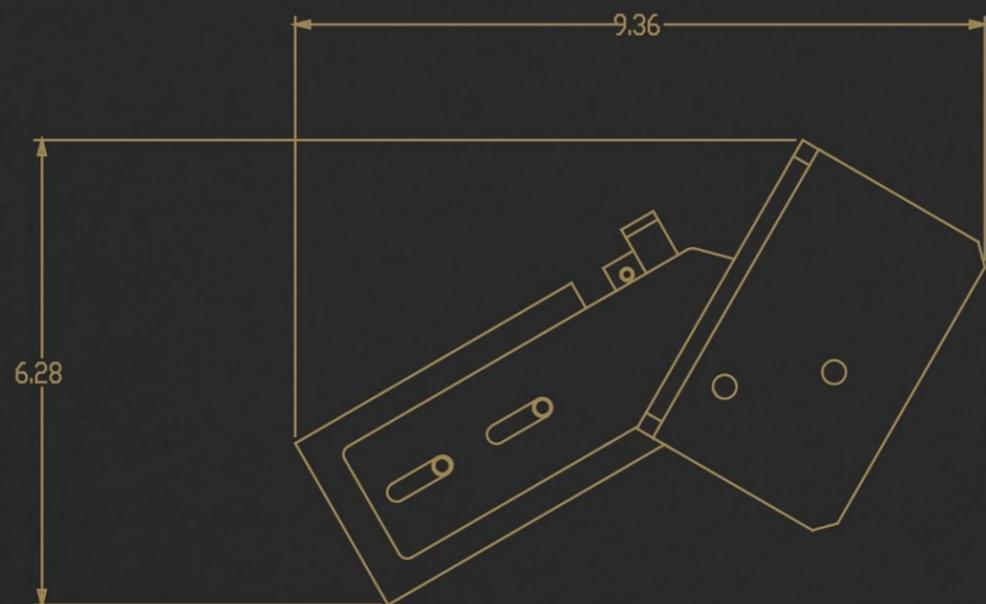
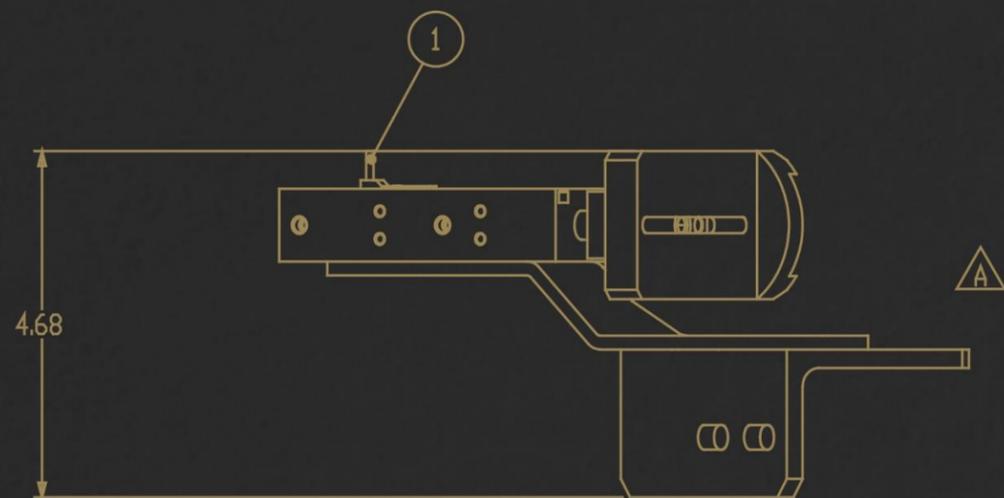
ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	164395	CYLINDER SWITCH M12-4 PNP 3 WIRE 2-COLOR .5M CORD	1
2	VCA384-99-317	PUSHER FRONT TOOL	1
3	VCA384-99-332	CYL MOUNT BRACKET 2 X 2	1
4	VCA384-99-334	SLOTTED BRACKET 7.5LG	1
^A 5	164893	THRUSTER 20MM BORE 40MM STROKE	1



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DRAWN BY:	<small>THE USE OR DUPLICATION OF THIS DOCUMENT OR ITS CONTENTS WITHOUT THE EXPRESSED WRITTEN CONSENT OF COLBORNE FRODBOTICS, LLC IS STRICTLY PROHIBITED.</small>		
DATE: 2/5/2020	MATERIAL:		PART NUMBER: VCA384-99-315
	STOCK SIZE:		DESCRIPTION: PLASTIC PUSHER ASSY 2
	STOCK NUMBER:	FINISH:	SHEET SIZE
	UNLESS OTHERWISE SPECIFIED, BREAK ALL SHARP CORNERS, REMOVE ALL BURRS, AND STAMP OR ETCH PART NO. ON SURFACE.		SCALE: 1:2.5
			Sheet 1 OF 1

A	REVISED TO 40MM STROKE CYLINDER -ML-03.25.20
REV.	DESCRIPTION

ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	164395	CYLINDER SWITCH M12-4 PNP 3 WIRE 2-COLOR .5M CORD	1
2	VCA384-99-318	PUSHER BACK TOOL	1
3	VCA384-99-336	CYL MOUNT BRACKET 2 X 3	1
4	VCA384-99-333	SLOTTED BRACKET 7.0 LG	1
5	164893	THRUSTER 20MM BORE 40MM STROKE	1



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DATE: 2/5/2020		

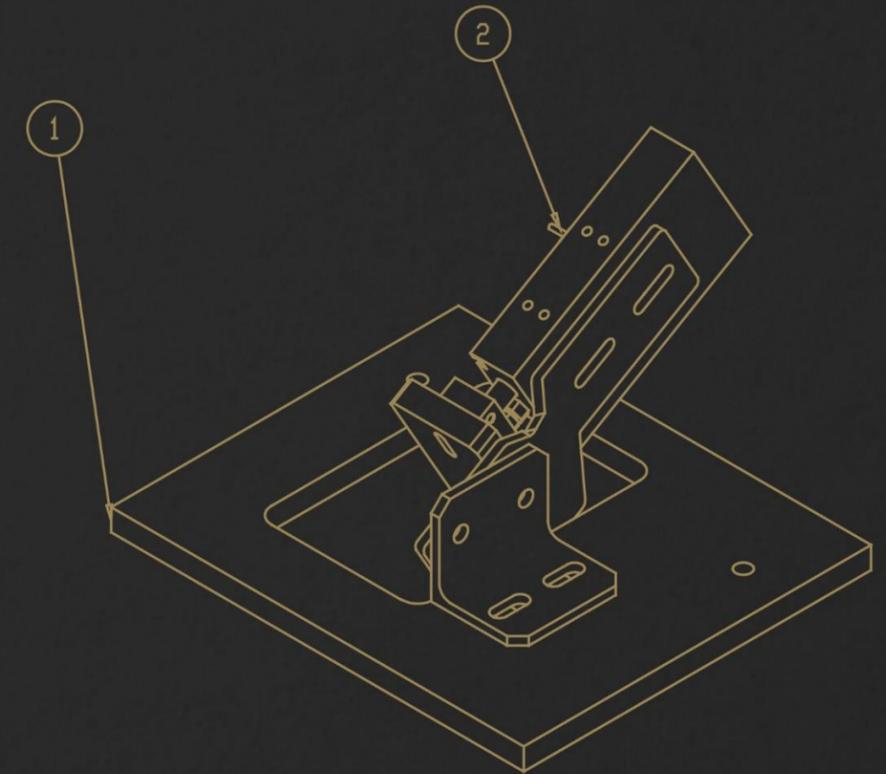
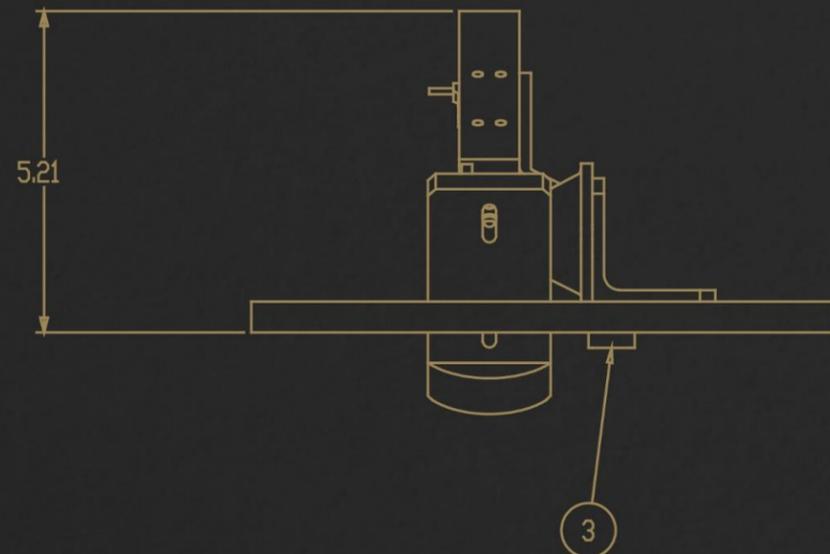
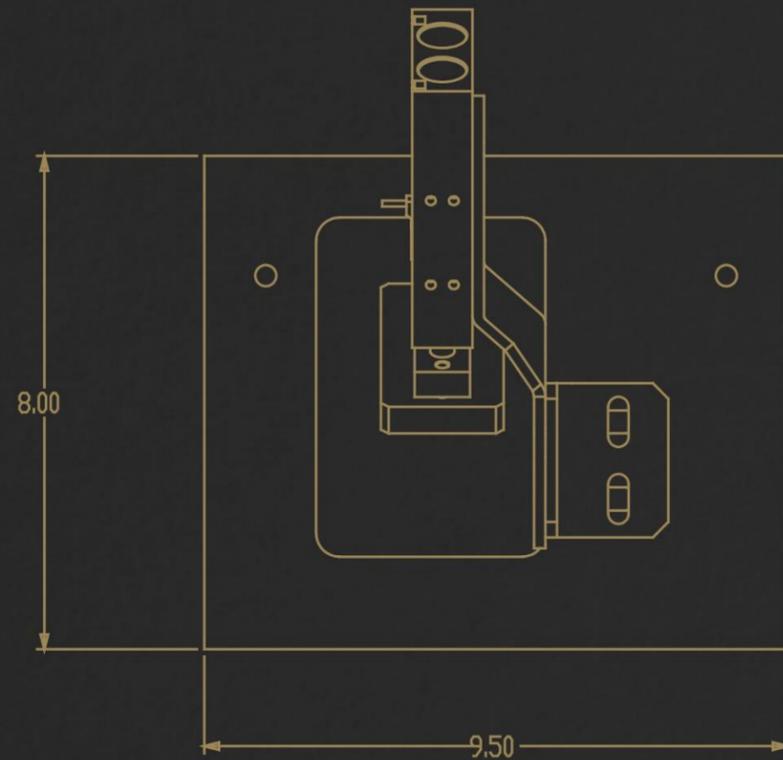


MATERIAL:	STOCK SIZE:
STOCK NUMBER:	FINISH:
UNLESS OTHERWISE SPECIFIED, BREAK ALL SHARP CORNERS, REMOVE ALL BURRS, AND STAMP OR ETCH PART NO. ON SURFACE.	

PART NUMBER: VCA384-99-316
DESCRIPTION: PLASTIC PUSHER ASSY 3
SHEET SIZE: SCALE: 1:2.5 Sheet1 OF 1

A	REVISED 40 MM STROKE CYLINDER -ML-03,25,20
REV.	DESCRIPTION

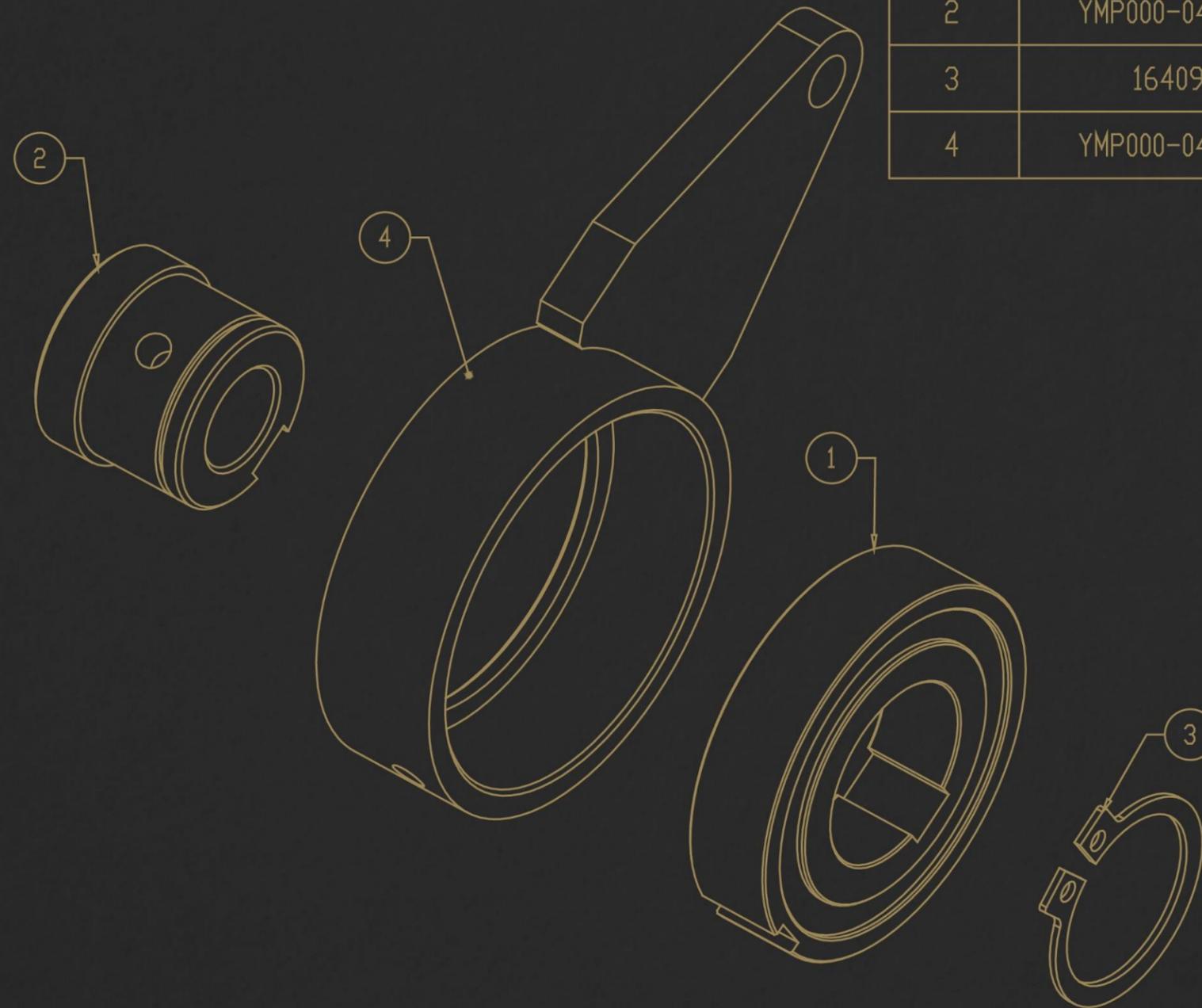
ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	VCA384-99-331	TOOL PLATE LOWER PLASTIC	1
2	VCA384-99-314	PLASTIC PUSHER ASSY 1	1
3	VCA384-01-163	NUT PLATE	1



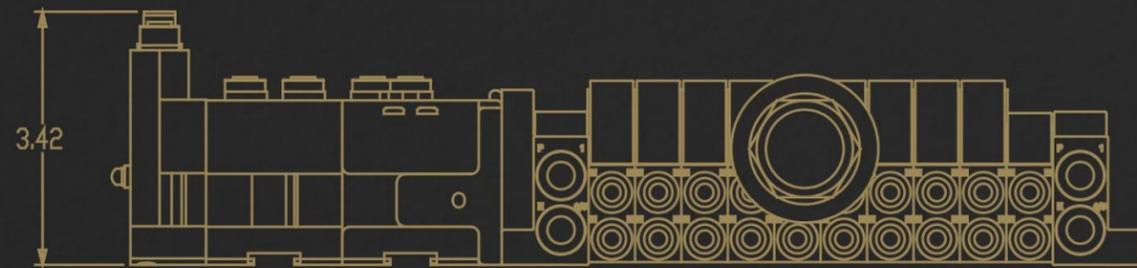
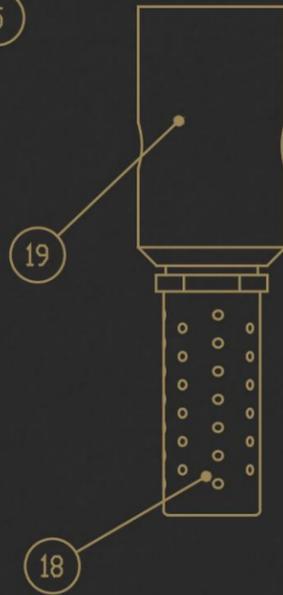
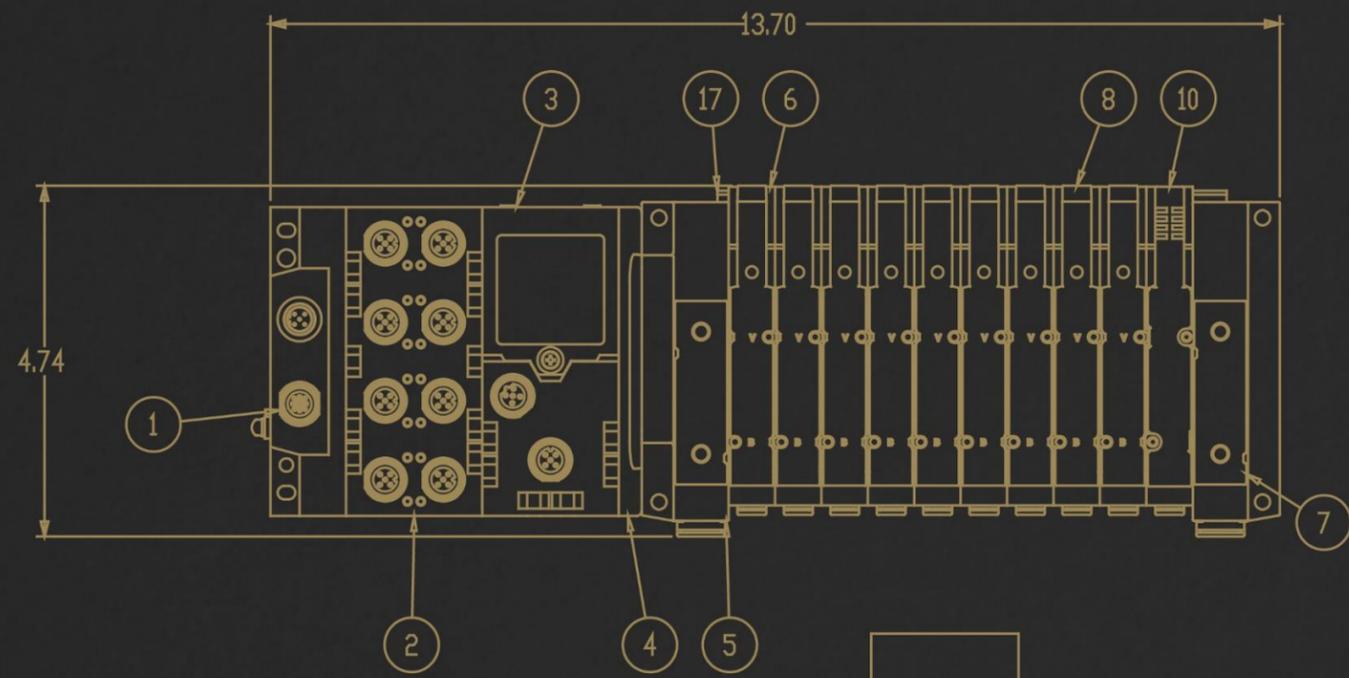
DESIGNED BY: ML	LINEAR .X ± 0.020 .XX ± 0.010 .XXX ± 0.005	ANGULAR X ± 2° .X ± 1° .XX ± 0° 30'	
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DATE: 2/5/2020	MATERIAL:		PART NUMBER: VCA384-99-330
STOCK SIZE:	FINISH:		DESCRIPTION: TOOL PLATE UPPER PLASTIC
STOCK NUMBER:	UNLESS OTHERWISE SPECIFIED, BREAK ALL SHARP CORNERS, REMOVE ALL BURRS, AND STAMP OR ETCH PART NO. ON SURFACE.		SHEET SIZE: SCALE: 1:3 Sheet1 OF 1

REV.	DESCRIPTION

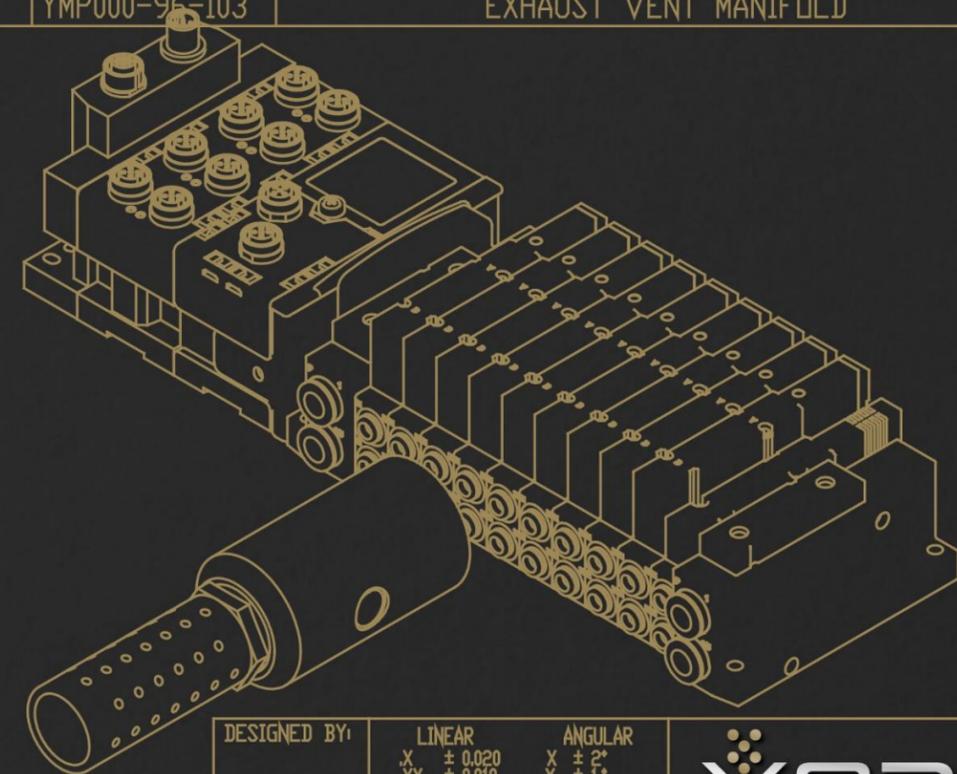
ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	164087	ONE-WAY BEARING	1
2	YMP000-04-110	BEARING BUSHING	1
3	164096	EXTERNAL RETAINING RING	1
4	YMP000-04-108	CLUTCH BEARING HOUSING	1



DESIGNED BY: DD	LINEAR X ± 0.020 .XX ± 0.010 .XXX ± 0.005	ANGULAR X ± 2° .X ± 1' .XX ± 0° 30'	
DRAWN BY: DD	<small>THE USE OR DUPLICATION OF THIS DOCUMENT OR ITS CONTENTS WITHOUT THE EXPRESSED WRITTEN CONSENT OF COLBORNE FRODOBOTICS, LLC IS STRICTLY PROHIBITED.</small>		
DATE: 12/28/2019	MATERIAL:		PART NUMBER: YMP000-04-138
STOCK SIZE:	FINISH:		DESCRIPTION: MAGAZINE CLUTCH ASSEMBLY
STOCK NUMBER:	UNLESS OTHERWISE SPECIFIED, BREAK ALL SHARP CORNERS, REMOVE ALL BURRS, AND STAMP OR ETCH PART NO. ON SURFACE		SHEET SIZE: SCALE: 1:1 Sheet 1 OF 1



ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	164206	END PLATE M12 - 5 PINS	1
2	164207	DIGITAL INPUT UNIT	1
3	164208	SI UNIT	1
4	164209	VALVE PLATE	1
5	164210	INPUT SIDE END PLATE	1
6	164211	VALVE BASE	10
7	164212	EXHAUST CAP	1
8	105409	VALVE, SINGLE SOLENOID, 24VDC, PLUG-IN STYLE, LIGHT & SURGE SUPPRESSOR	9
9	164214	VALVE PLATE BRACKET	1
10	104364	BLANKING PLATE	1
11	164217	SEAL CAP M12	1
12	164218	MARKER (1 SHEET, 88 PCS)	1
13	164219	FIELD WIREABLE CONNECTOR	1
14	164220	ETHERNET	1
15	164221	90* POWER CABLE	1
16	164659	ETHERNET CABLE TO SMC-5M	1
17	164215	TIE ROD 10 STATION	3
18	902010353	EXHAUST MUFFLER 1" MALE	1
19	YMP000-96-103	EXHAUST VENT MANIFOLD	1



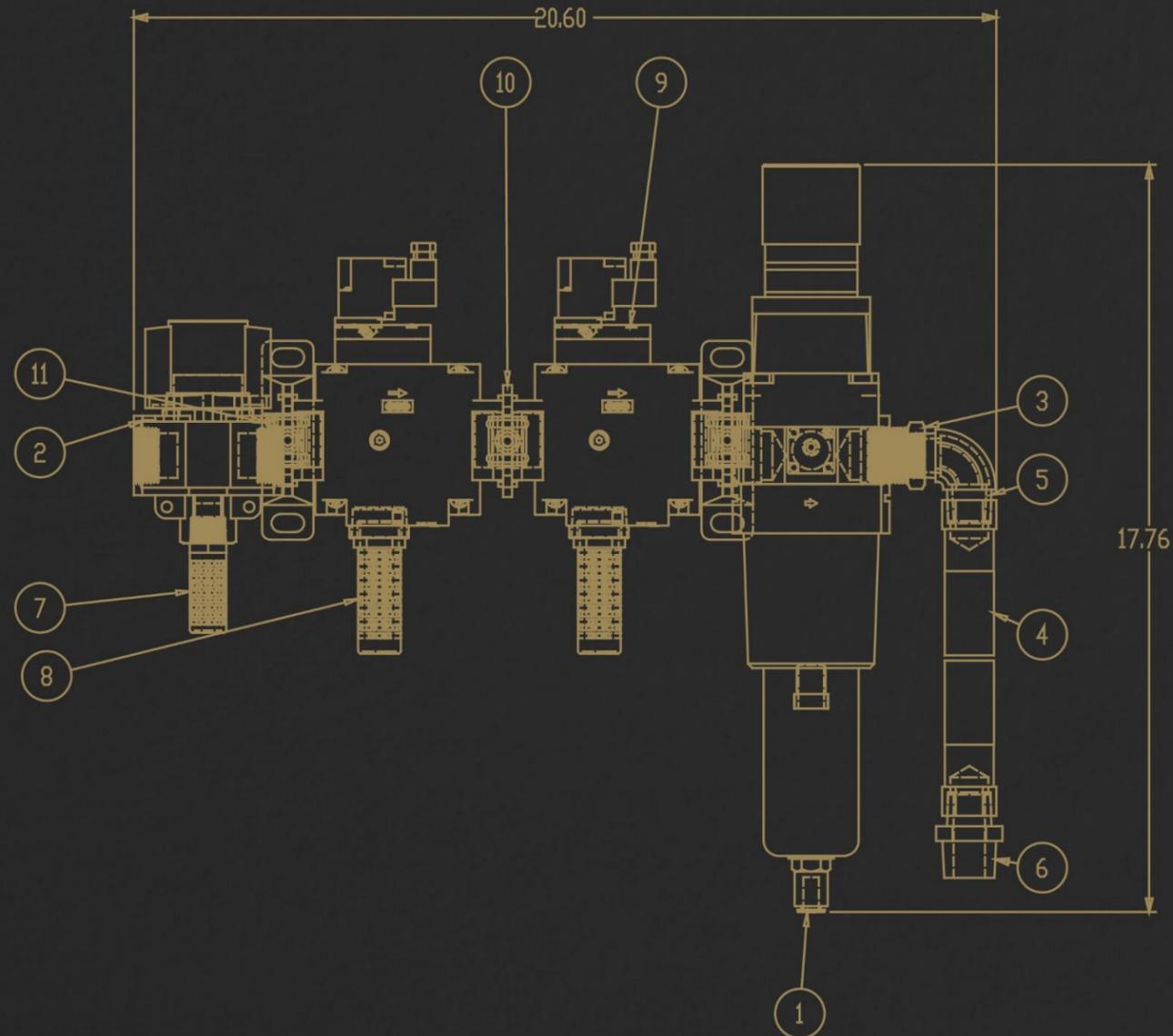
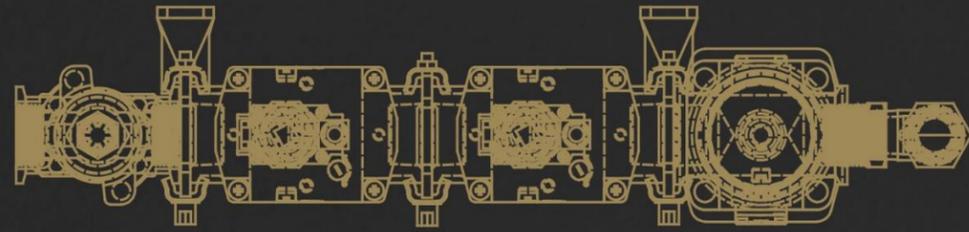
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DRAWN BY:	ML	
DATE:	1/15/2020	
MATERIAL:	UNLESS OTHERWISE SPECIFIED, BREAK ALL SHARP CORNERS, REMOVE ALL BURRS, AND STAMP OR ETCH PART NO. ON SURFACE.	
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STOCK NUMBER:	FINISH:	



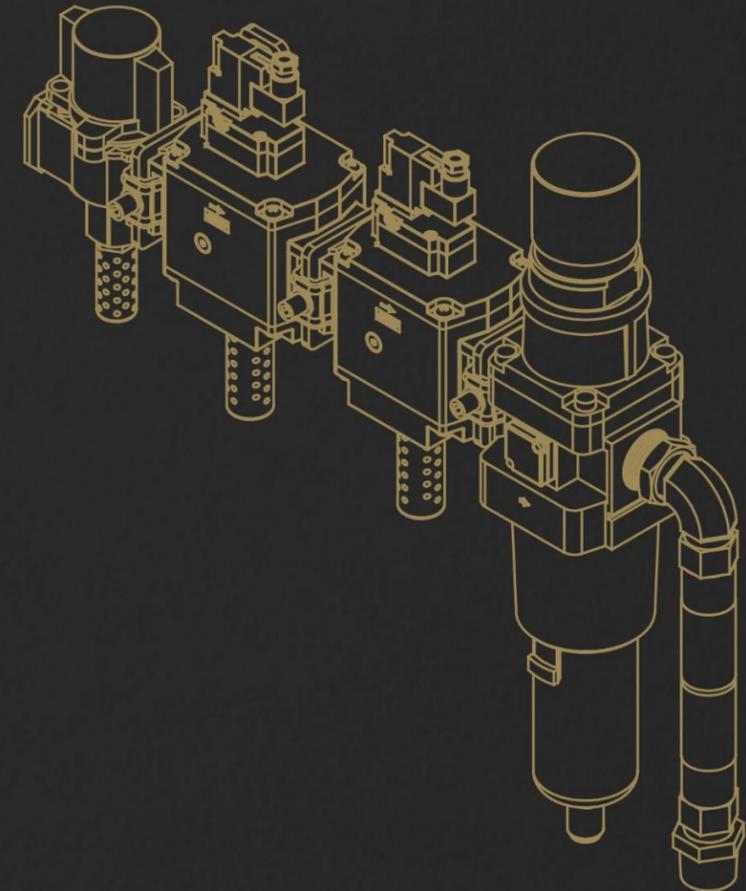
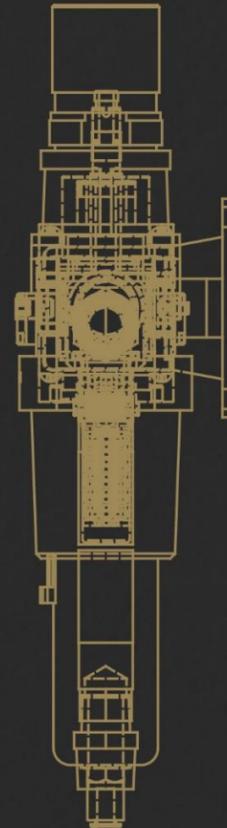
PART NUMBER: YMP000-96-001
DESCRIPTION: PNEUMATIC VALVE ASSY

SHEET SIZE: SCALE: 1:2.5 Sheet 1 OF 1

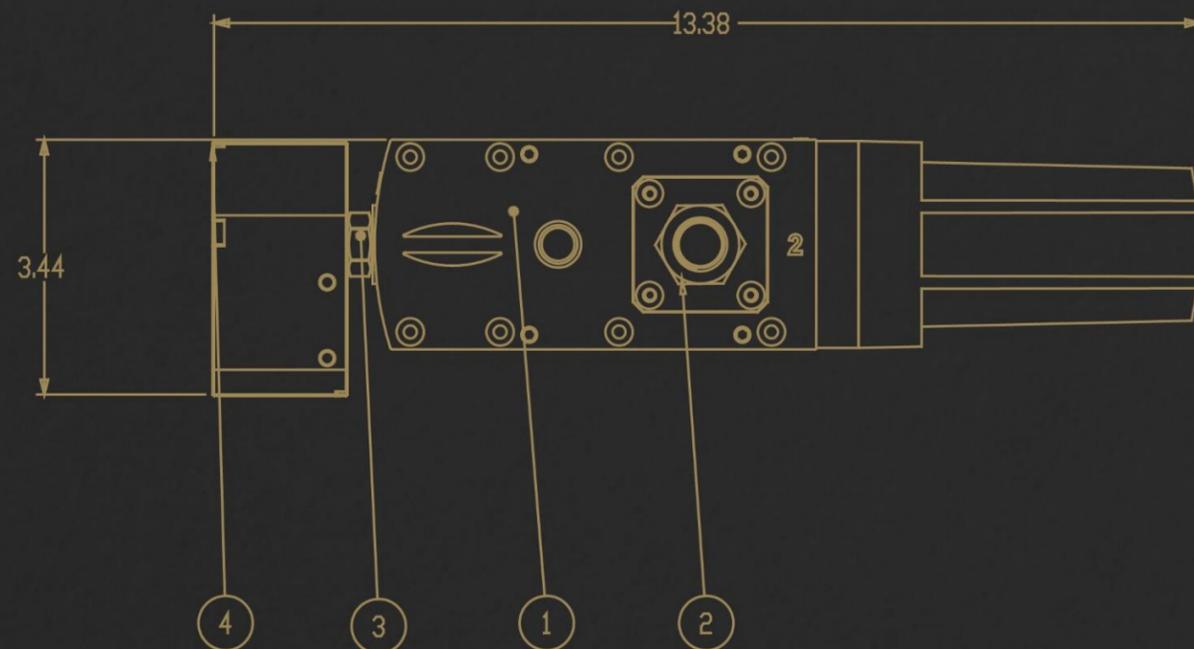
REV.	DESCRIPTION



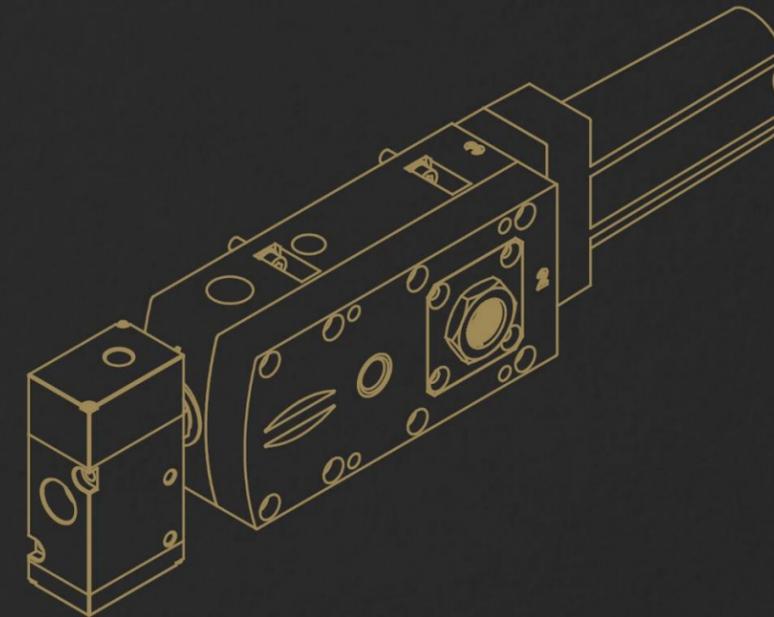
ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	164200	REGULATOR W FILTER/GAUGE	1
2	164201	SAFETY SHUT-OFF VALVE 1" NPT	1
3	164202	BUSHING ADAPTER, 1" NPTF MALE X 3/4" NPTF FEMALE	1
4	164203	AIR HOSE, 3/4 X 3/4 NPSM, 5 FT LONG	1
5	164204	90 DEGREE ELBOW, 3/4 NPTF MALE	1
6	164205	STRAIGHT REDUCER, 1" X 3/4" NPTF MALE	1
7	902009353	EXHAUST MUFFLER 1/2" MALE	1
8	164617	EXHAUST MUFFLER 0.75" MALE	2
9	164213	DUMP VALVE 1" MANIFOLD	2
10	164216	JOINER CLAMP AC50	1
11	164199	JOINER CLAMP W/BASE	2
12	162156	PRESSURE, SWITCH, DIGITAL,	1



DESIGNED BY: ML	LINEAR .X ± 0.020 .XX ± 0.010 .XXX ± 0.005	ANGULAR X ± 2° .X ± 1° .XX ± 0° 30'	
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DATE: 1/17/2020			PART NUMBER: YMP000-96-002
MATERIAL:			DESCRIPTION: 1" AIR REGULATOR ASSY
STOCK SIZE:	STOCK NUMBER:	FINISH:	SHEET SIZE
<small>UNLESS OTHERWISE SPECIFIED, BREAK ALL SHARP CORNERS, REMOVE ALL BURRS, AND STAMP OR ETCH PART NO. ON SURFACE.</small>			SCALE: 1:4
REV.	DESCRIPTION	Sheet 1 OF 1	



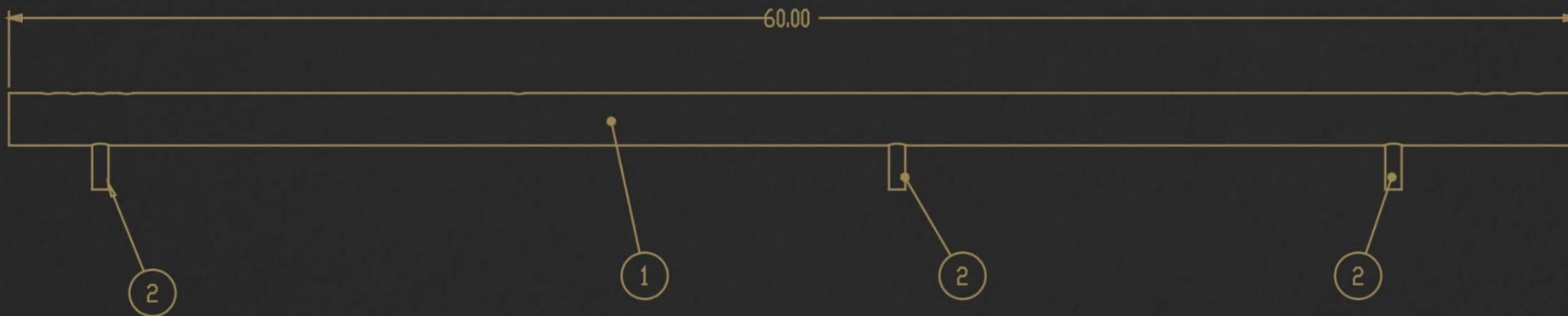
ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	164063	BASIC EJECTOR	1
2	164060	PIPE FITTING 3/4 X 3/8	1
3	164062	NIPPLE HEX 3/8 NPT STRAIGHT	1
4	164061	AIR PILOT VALVE	1



DESIGNED BY: ML	LINEAR .X ± 0.020 .XX ± 0.010 .XXX ± 0.005	ANGULAR X ± 2° .X ± 1° .XX ± 0° 30'	
DRAWN BY:	<small>THE USE OR DUPLICATION OF THIS DOCUMENT OR ITS CONTENTS WITHOUT THE EXPRESSED WRITTEN CONSENT OF COLBORNE FIDDIBOTICS, LLC IS STRICTLY PROHIBITED.</small>		
DATE: 1/30/2020	MATERIAL:		PART NUMBER: YMP000-96-003
	STOCK SIZE:		DESCRIPTION: VACUUM GENERATOR ASSY
	STOCK NUMBER:	FINISH:	
	<small>UNLESS OTHERWISE SPECIFIED, BREAK ALL SHARP CORNERS, REMOVE ALL BURRS, AND STAMP OR ETCH PART NO. ON SURFACE.</small>		SHEET SIZE: SCALE: 1:2.5 Sheet 1 OF 1

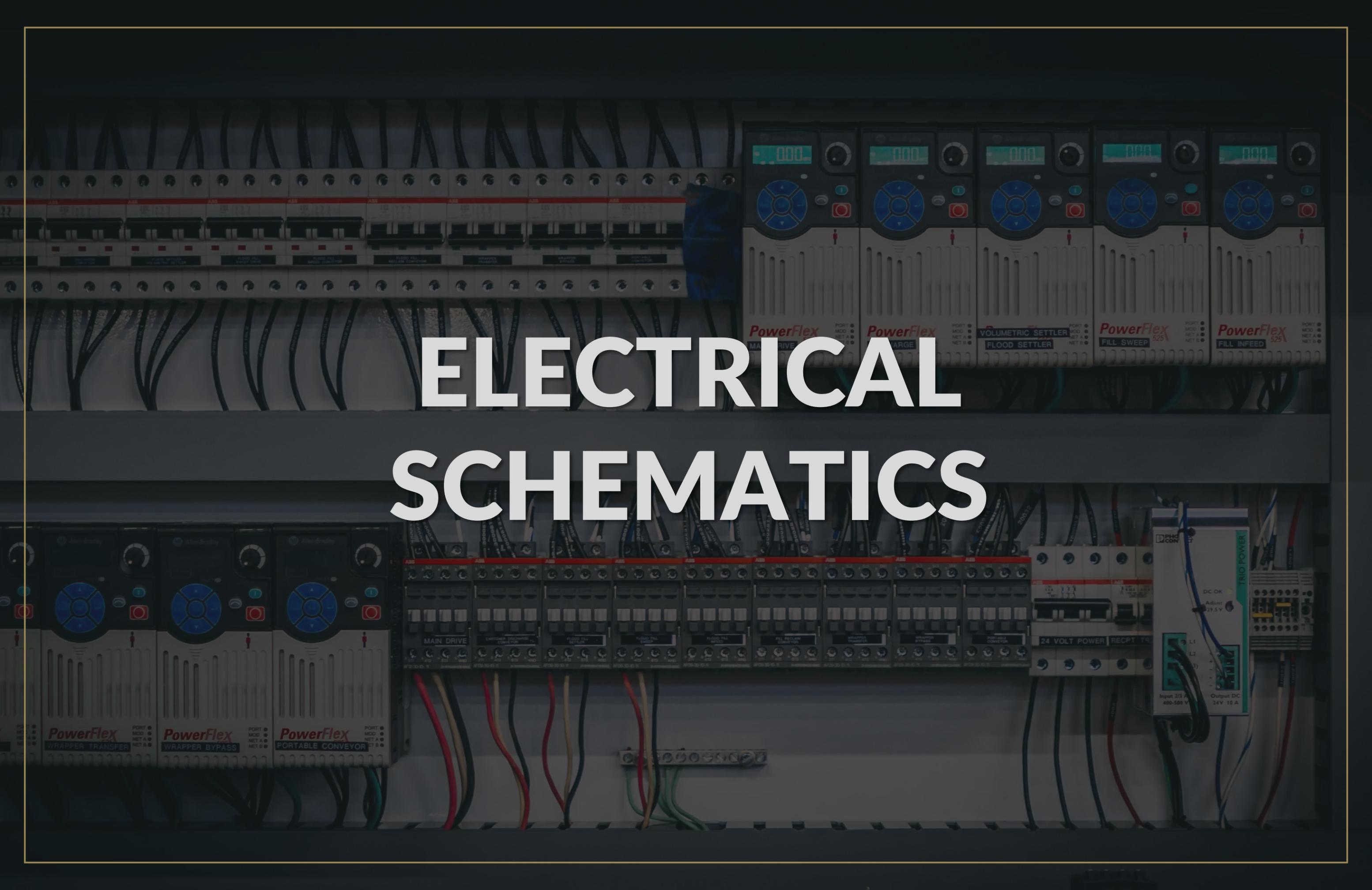
REV.	DESCRIPTION

ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	YMP000-96-101	AIR MANIFOLD TUBE	1
2	YMP000-96-102	STANDOFF MANIFOLD	3

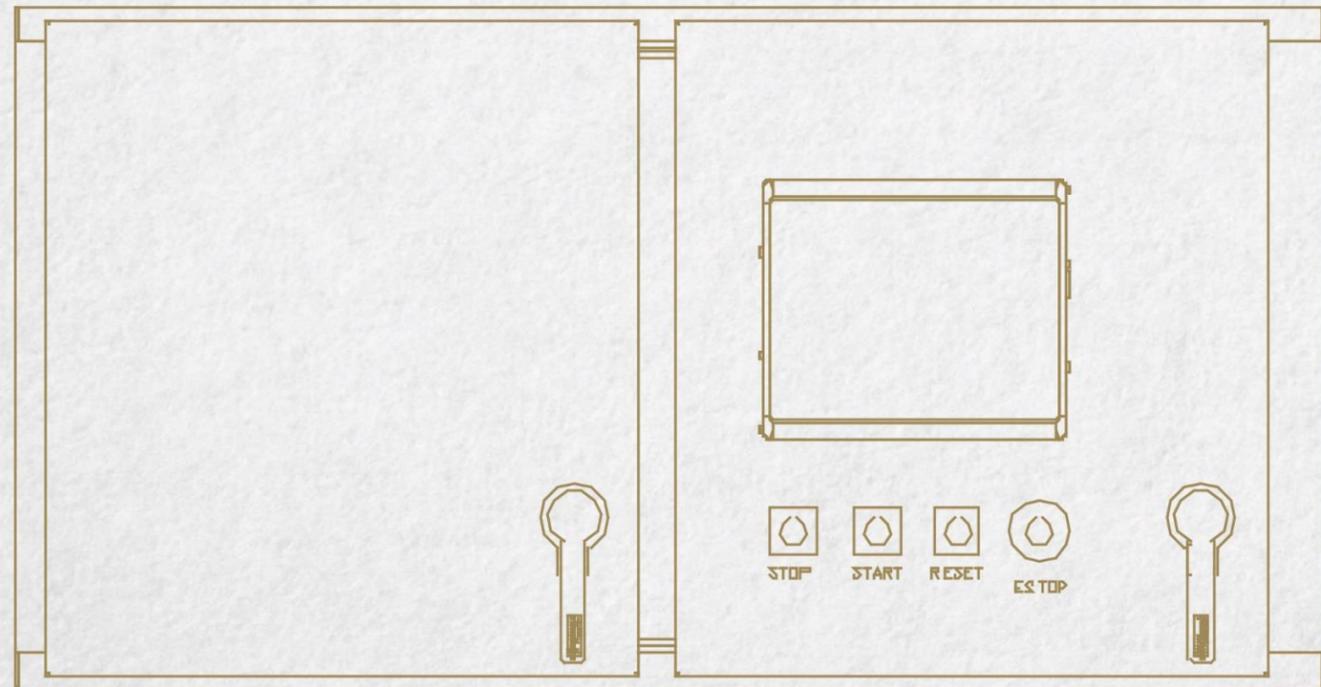
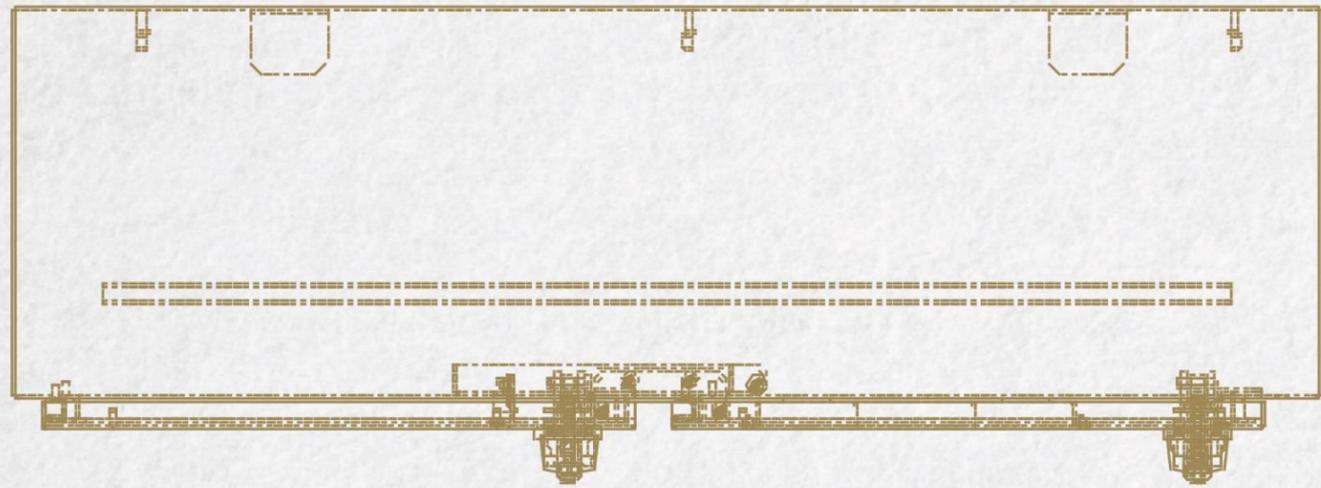


DESIGNED BY:	LINEAR X ± 0.020 .XX ± 0.010 .XXX ± 0.005	ANGULAR X ± 2° .X ± 1° .XX ± 0° 30'	
DRAWN BY: ML	<small>THE USE OR DUPLICATION OF THIS DOCUMENT OR ITS CONTENTS WITHOUT THE EXPRESSED WRITTEN CONSENT OF COLBORNE FIDBOTICS, LLC IS STRICTLY PROHIBITED.</small>		
DATE: 2/26/2020			
MATERIAL:			PART NUMBER: YMP000-96-004
STOCK SIZE:			DESCRIPTION: AIR MANIFOLD ASSY
STOCK NUMBER:	FINISH:		
<small>UNLESS OTHERWISE SPECIFIED, BREAK ALL SHARP CORNERS, REMOVE ALL BURRS, AND STAMP OR ETCH PART NO. ON SURFACE</small>			SHEET SIZE: 11x17
			SCALE: 1/6
			Sheet1 OF 1

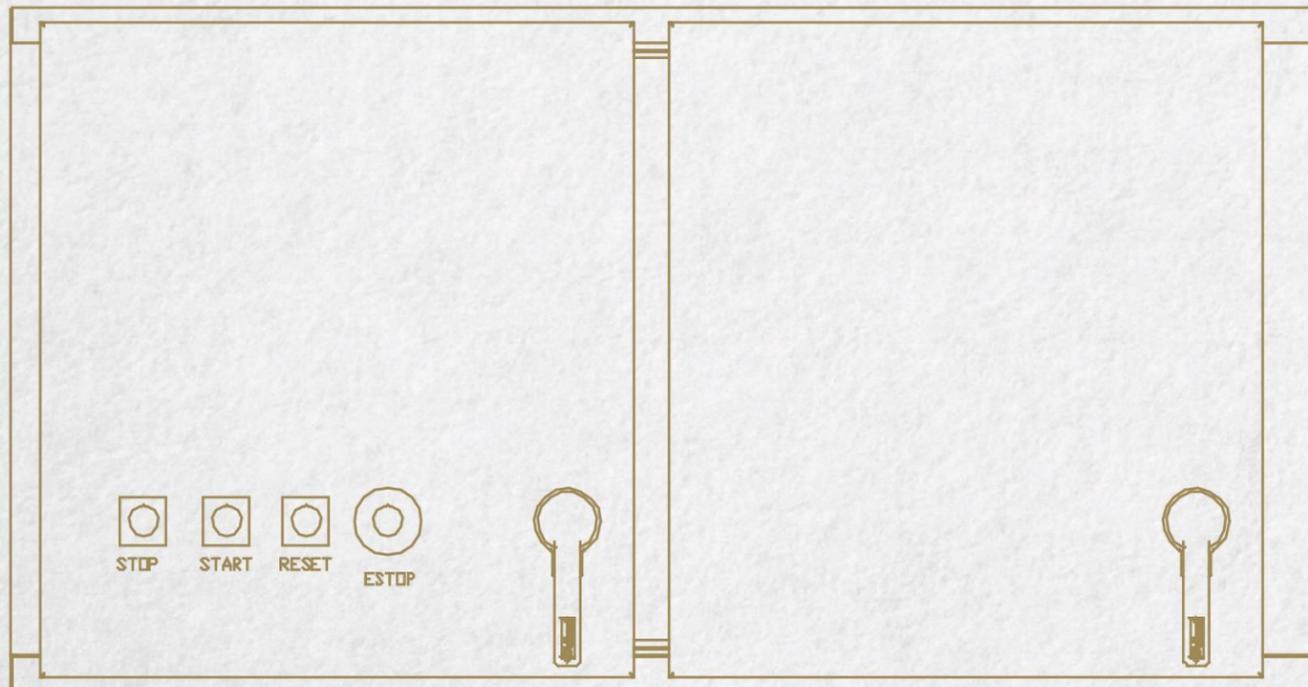
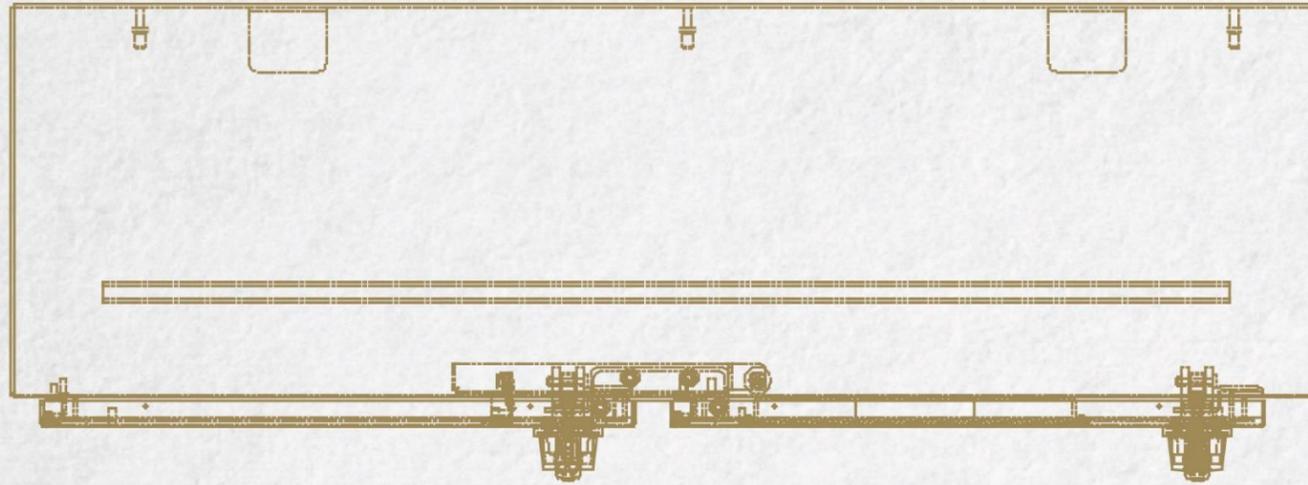
REV.	DESCRIPTION

The image shows a complex industrial electrical control panel. At the top, there are five Allen-Bradley PowerFlex drives, each with a digital display showing '0.00'. Below these are several terminal blocks with numerous wires connected. On the left side, there are three more PowerFlex drives labeled 'WRAPPER TRANSFER', 'WRAPPER BYPASS', and 'PORTABLE CONVEYOR'. In the center, there is a row of terminal blocks with labels like 'MAIN DRIVE', 'FLOOD SETTLER', and 'FILL SWEEP'. To the right, there is a '24 VOLT POWER RECP' terminal block and a 'TRIO POWER' DC power supply unit. The entire panel is densely packed with wires and components, typical of a large-scale industrial machine's control system.

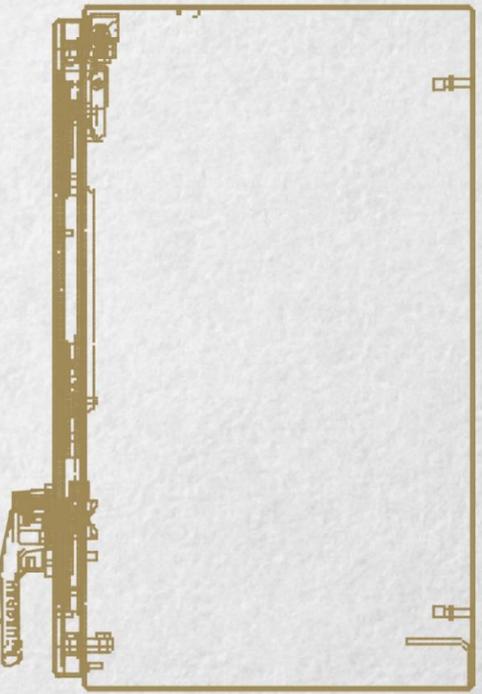
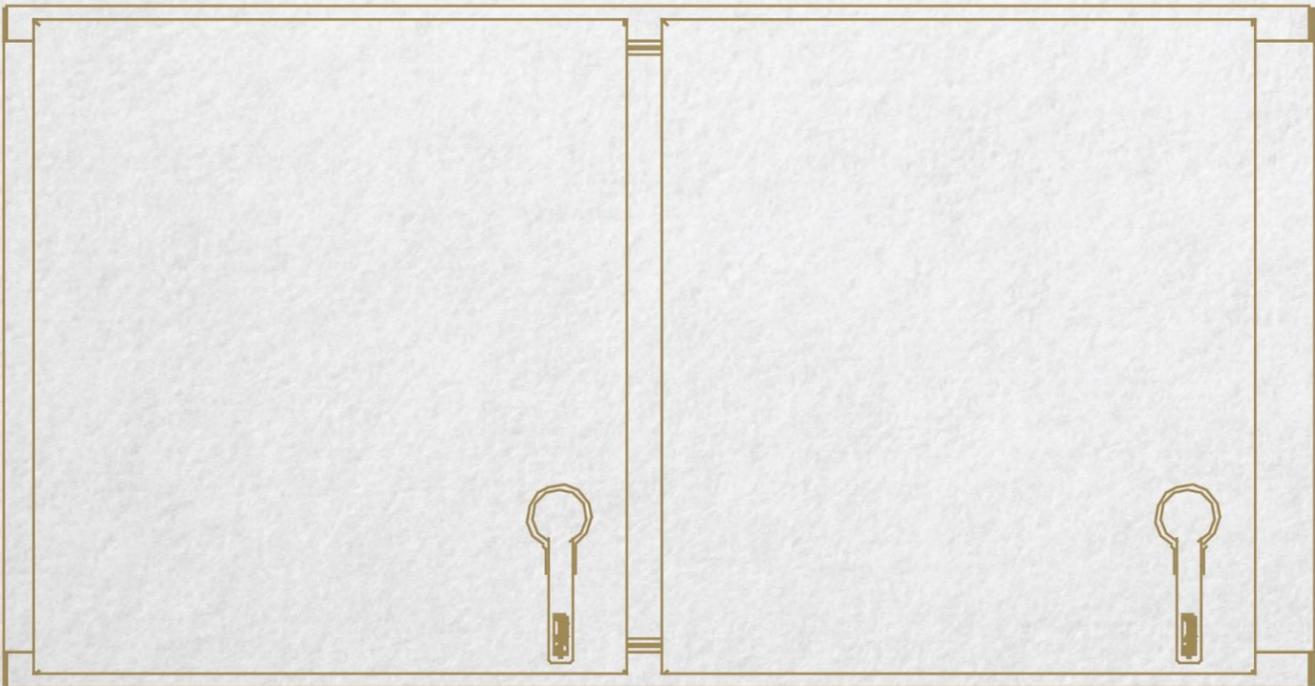
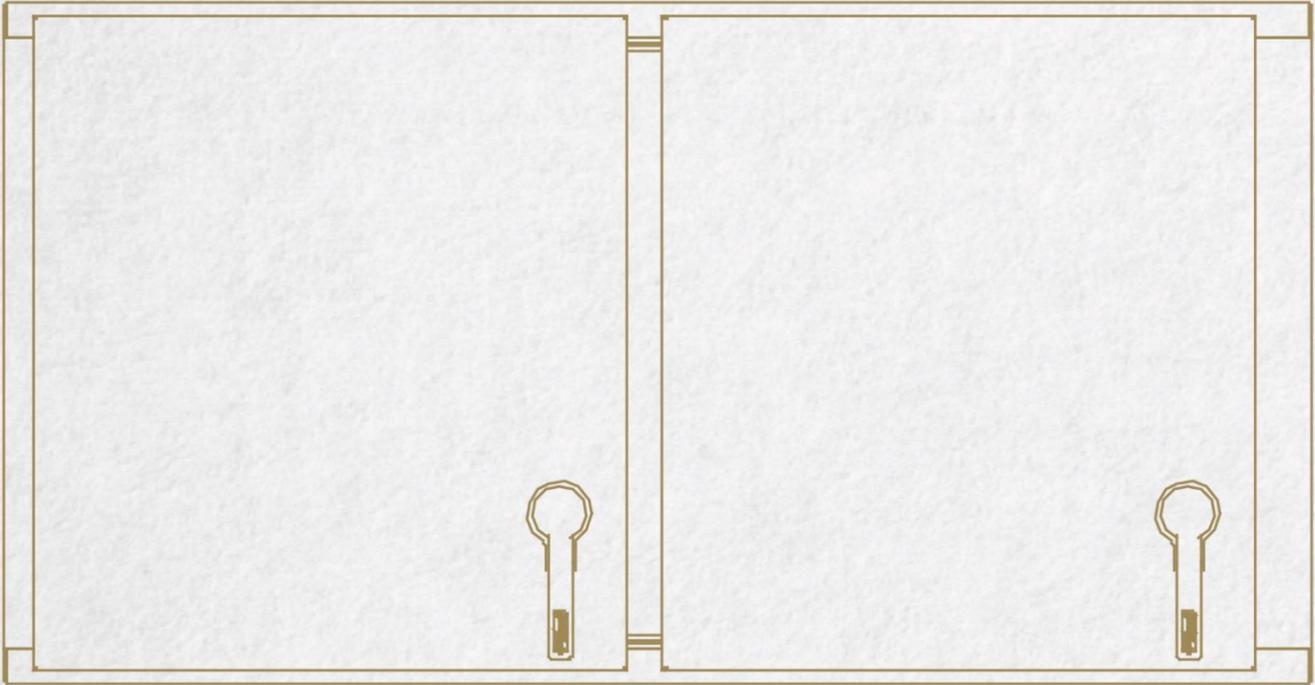
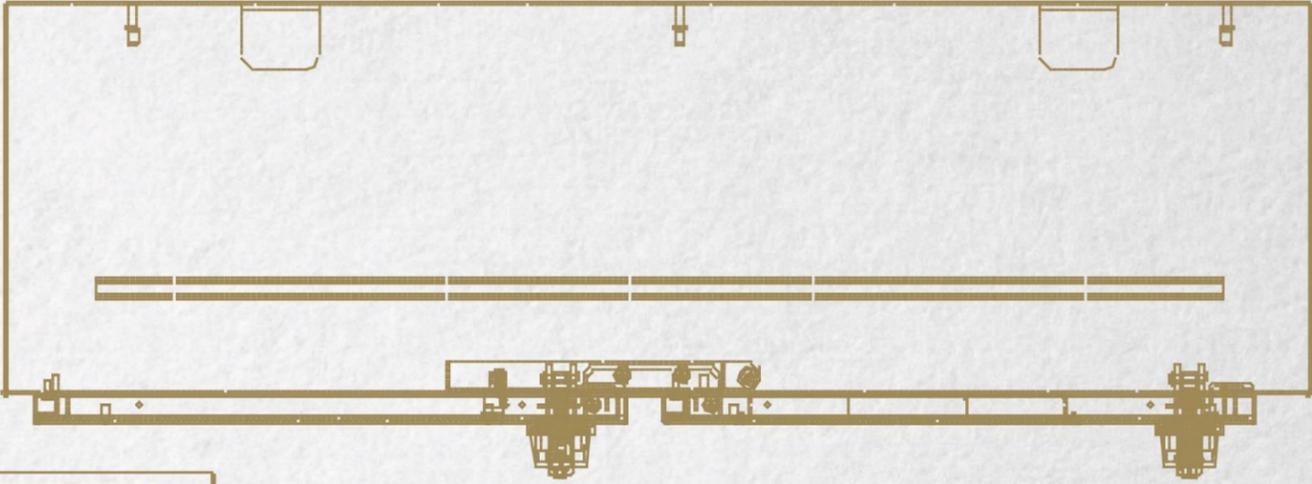
ELECTRICAL SCHEMATICS



COLBORNE FOOD BOT CO'S 284/85 N BALLARD DR LAKE FOREST, IL 60448	REVISED	DATE
	REV 01	01/08/2020
	PROJECT NO	VIAIRIA-10-008
DRAWING TITLE		SHEET NO
Main Enclosure		01/1



COLBORNE FOODBOTICS 28496 N BALLARZI DR. LAKE FOREST, IL 60043	REVISED	DESIGNED BY
	REV NO	DATE
	YCA304-04-000	01/08/2020
DATE	REV NO	
Main Enclosure		01/1



COLBORNE FOODBOTICS 8949E N. BALLARD DR. LAKE FOREST, IL 60149	REVISED BY	DATE
	BY	DATE
PART NO VC4284-01-001	DRAWN BY DI/DK/2005	
TITLE Main Enclosure	SHEET NO. 01/1	

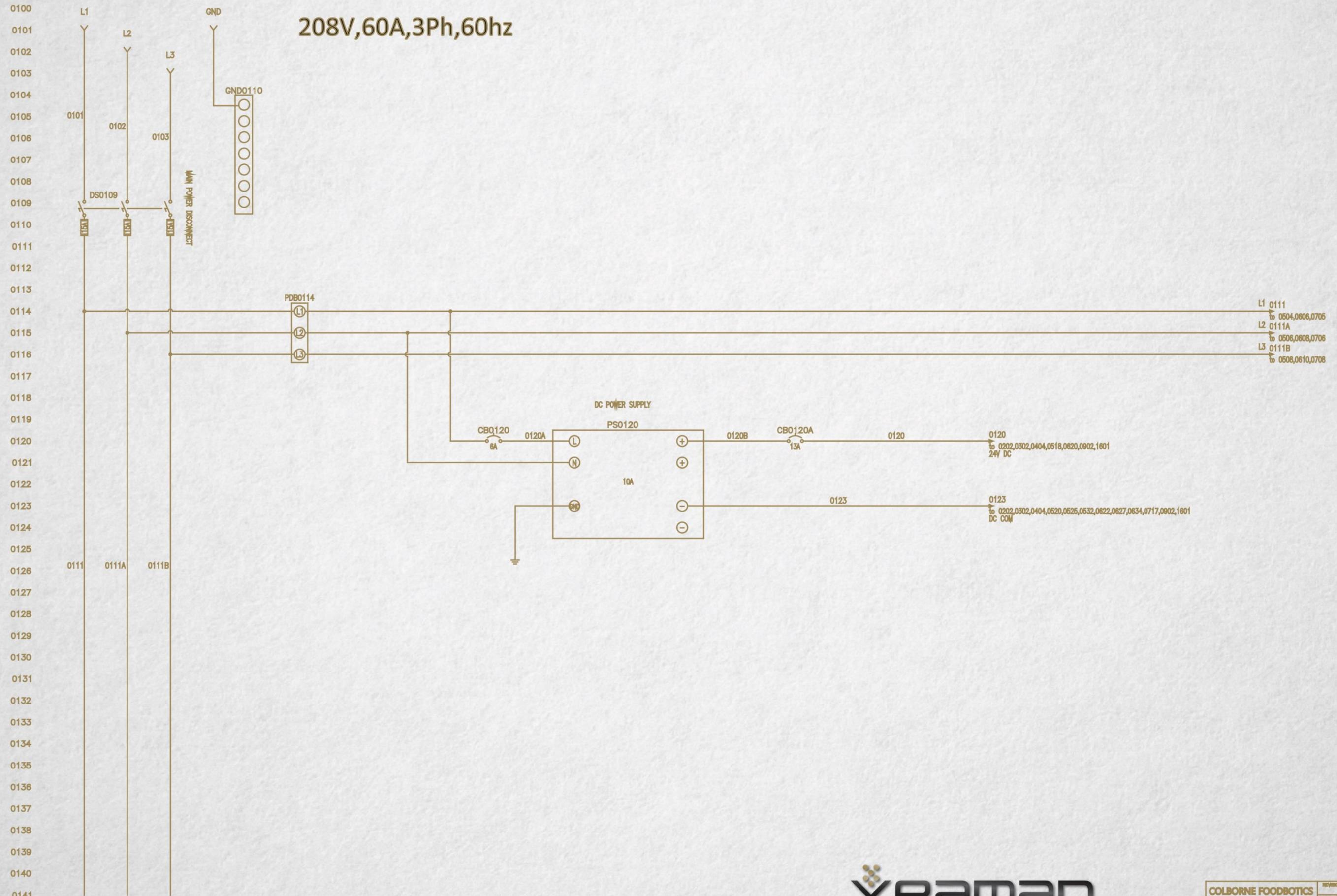
	A	B	C
1	FILENAME	SH	DWGDESC
2	VCA384-99-000-0000_Index	0	INDEX
3	VCA384-99-000-0100_Main Power	1	MAIN POWER
4	VCA384-99-000-0200_24V DC Power	2	24V DC POWER
5	VCA384-99-000-0300_Safety	3	SAFETY
6	VCA384-99-000-0400_SensaGuard	4	Sensor Guard
7	VCA384-99-000-0500_DR1_Cartoner	5	DR 1 - Cartoner Conveyor
8	VCA384-99-000-0600_DR2_Tilt	6	DR 2 - Tilt Conveyor
9	VCA384-99-000-0700_DR3_Discharge	7	DR 3 - Discharge Conveyor
10	VCA384-99-000-0800_Blank	8	Blank
11	VCA384-99-000-0900_PLC_Emb_IQ	9	PLC Embedded IQ
12	VCA384-99-000-1000_Blank	10	Blank
13	VCA384-99-000-1100_Sol_Bank_1	11	Solenoid Valve Bank 1
14	VCA384-99-000-1200_Sol_Bank_2	12	Solenoid Valve Bank 2
15	VCA384-99-000-1300_Blank	13	Blank
16	VCA384-99-000-1400_Blank	14	Blank
17	VCA384-99-000-1500_Blank	15	Blank
18	VCA384-99-000-1600_Ethernet_Switch	16	Ethernet Switch



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COLBORNE FOODBOTICS YEAMAN MACHINE 28405 N. BALLARD DR. LAKE FOREST, IL 60045	REVISION JOB NO VCA384-99-000	DRAWN BY DATE 01/08/2020
	DWG NO VCA384-99-000-0000	
	SHEET NO INDEX	SHEET NO 0 OF 16

208V, 60A, 3Ph, 60hz



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L1 0111
to 0504,0606,0705
L2 0111A
to 0506,0608,0706
L3 0111B
to 0508,0610,0708

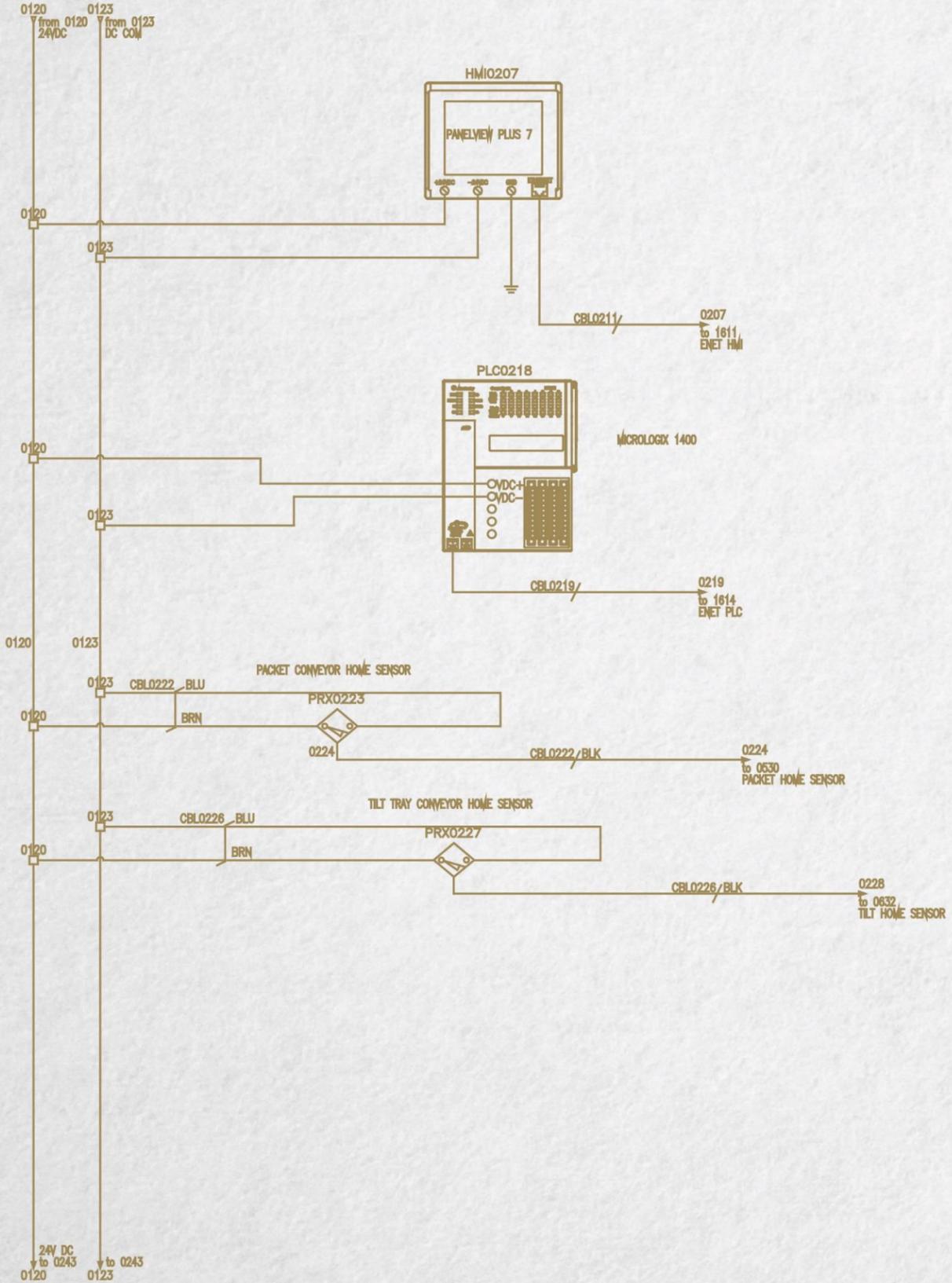
0120
to 0202,0302,0404,0518,0620,0902,1601
24V DC

0123
to 0202,0302,0404,0520,0525,0532,0622,0627,0634,0717,0902,1601
DC COM

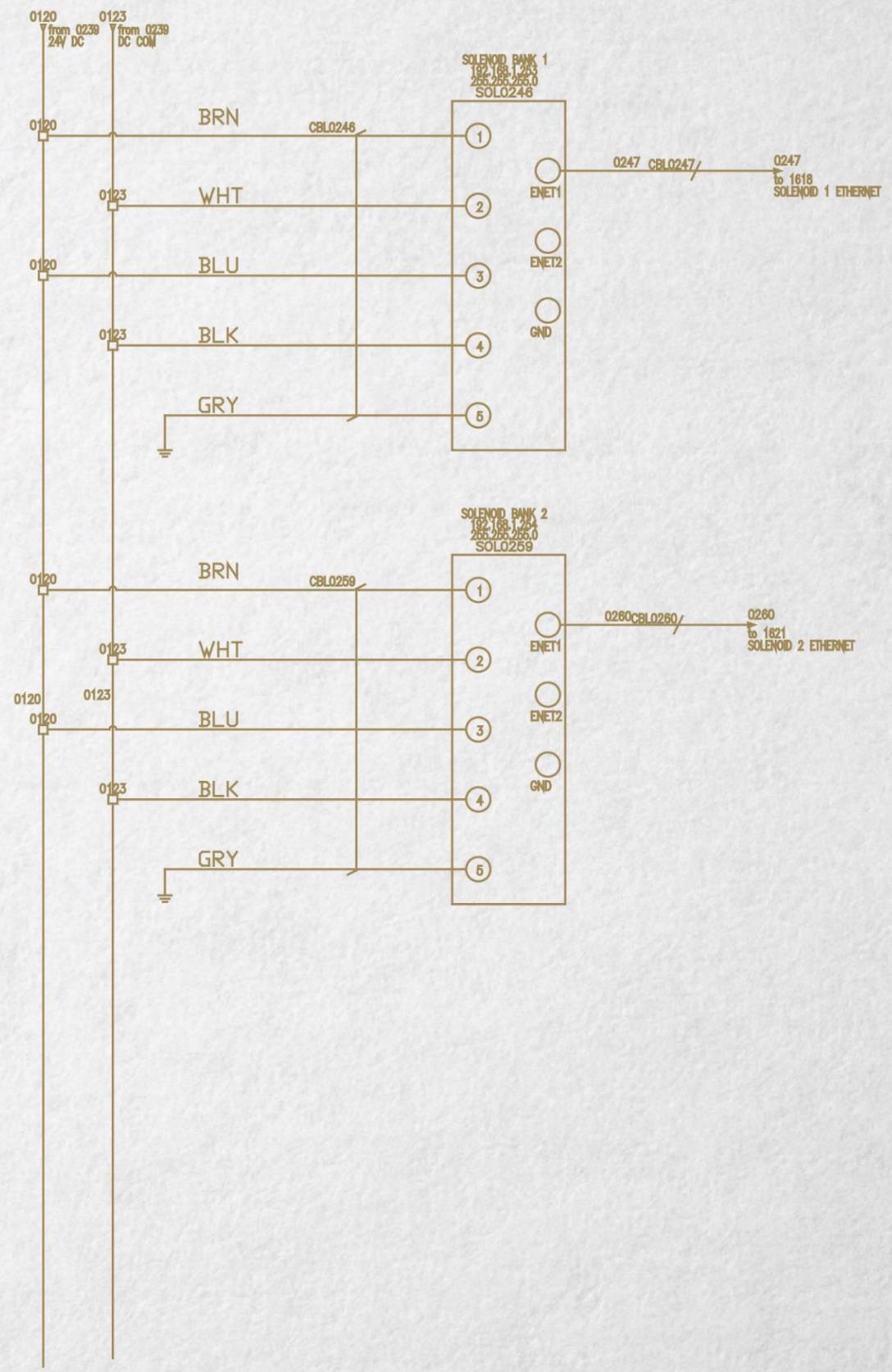


COLBORNE FOODBOTICS YEAMAN MACHINE 28465 N. BALLARD DR. LAKE FOREST, IL 60045	REVISION JOB NO VCA384-99-000	DRAWN BY CB
	DATE 01/06/2020	SHEET NO 1 OF 16
	VCA384-99-000-0100	

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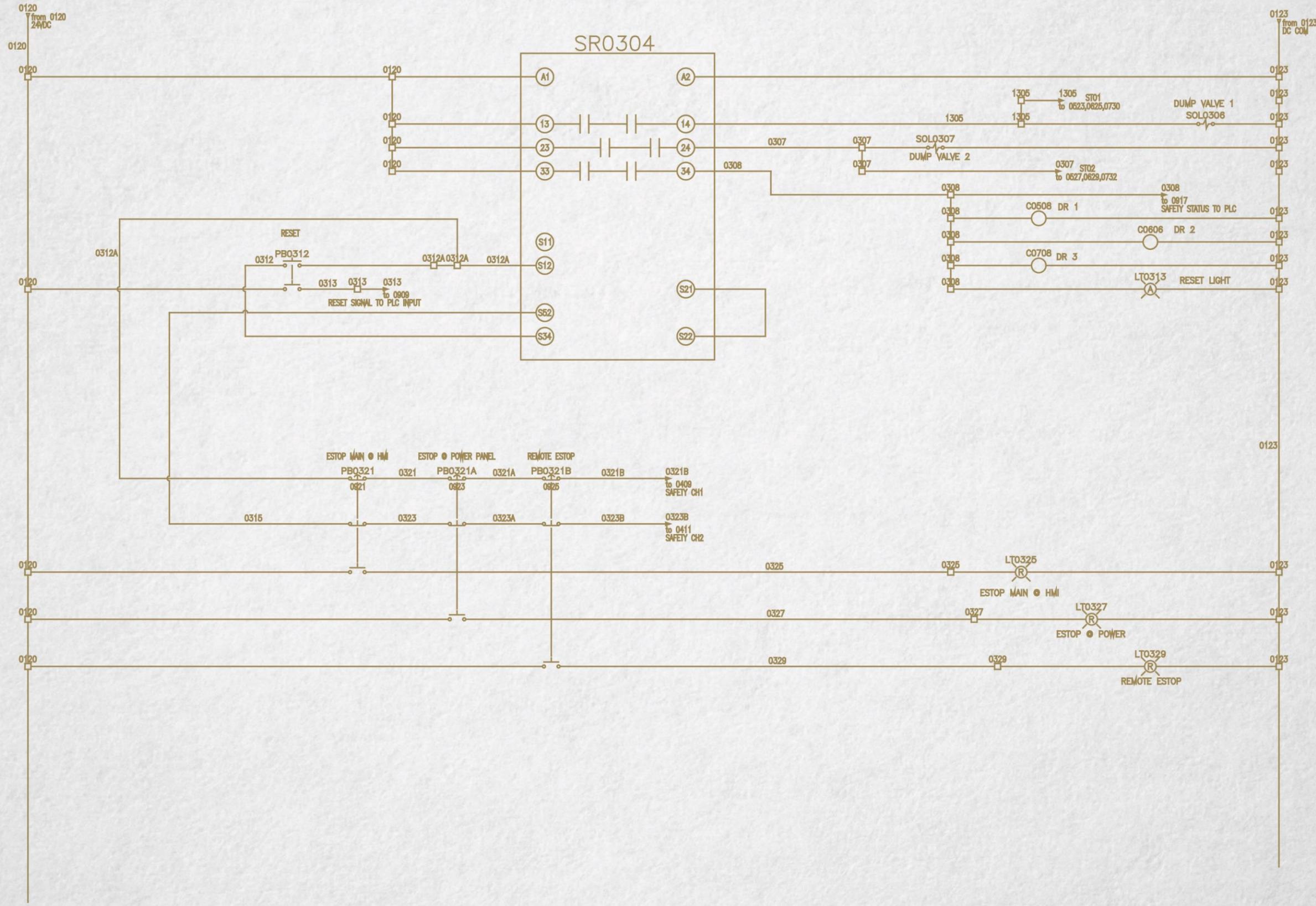
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COLBORNE FOODBOTICS YEAMAN MACHINE	REVISION	DRAWN BY
	JOB NO VCA384-99-000	DATE 01/08/2020
28405 N. BALLARD DR. LAKE FOREST, IL 60045	DWG NO VCA384-99-000-0200	
SHEET NO 24V DC POWER		SHEET NO 2 OF 16

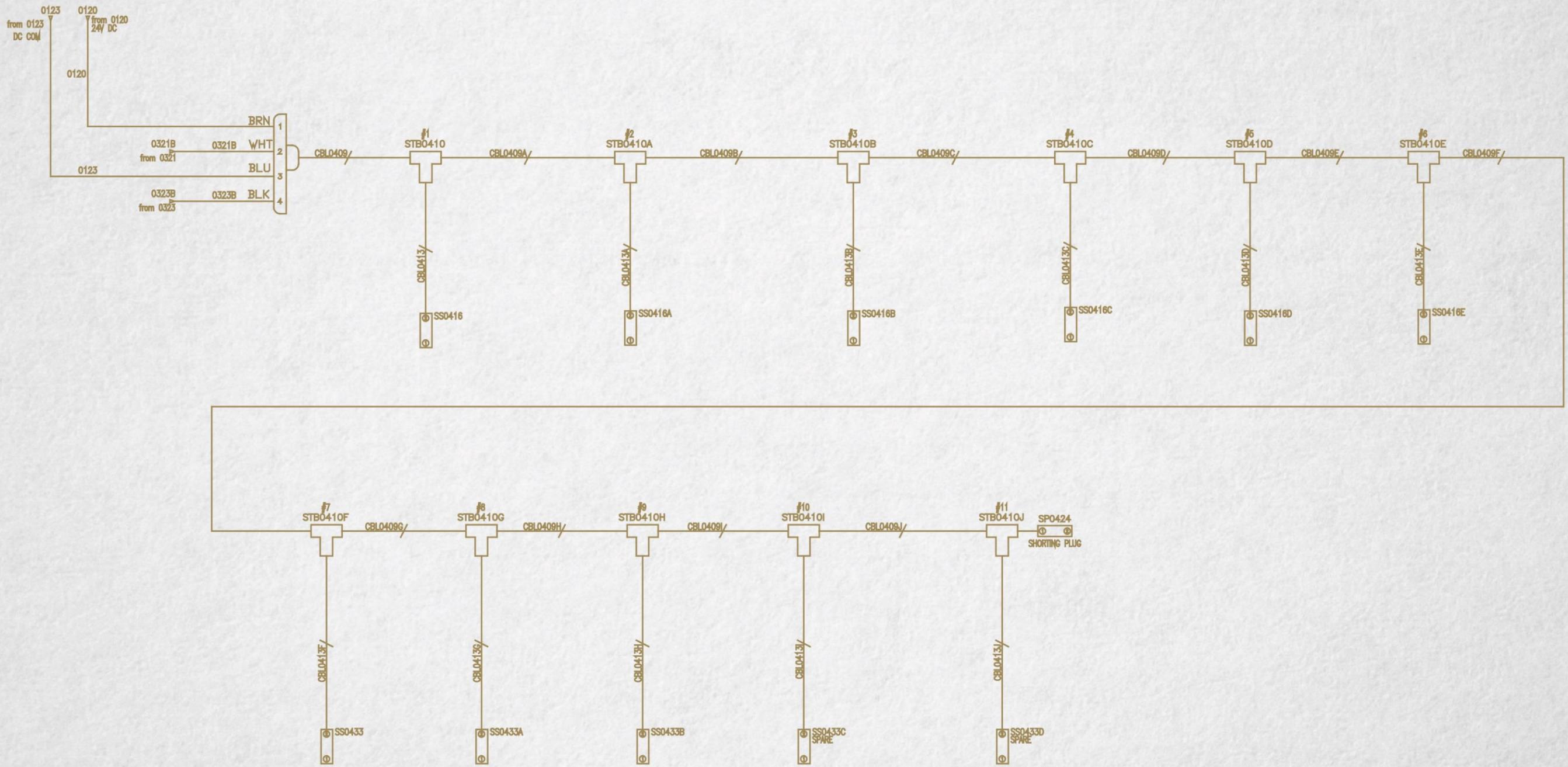
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COLBORNE FOODBOTICS YEAMAN MACHINE 28405 N. BALLARD DR. LAKE FOREST, IL 60045	REVISION	DESIGNED BY
	JOB NO. VCA384-99-000	DATE 01/08/2020
DRAW NO. VCA384-99-000-0300		
SAFETY		SHEET NO. 3 OF 16

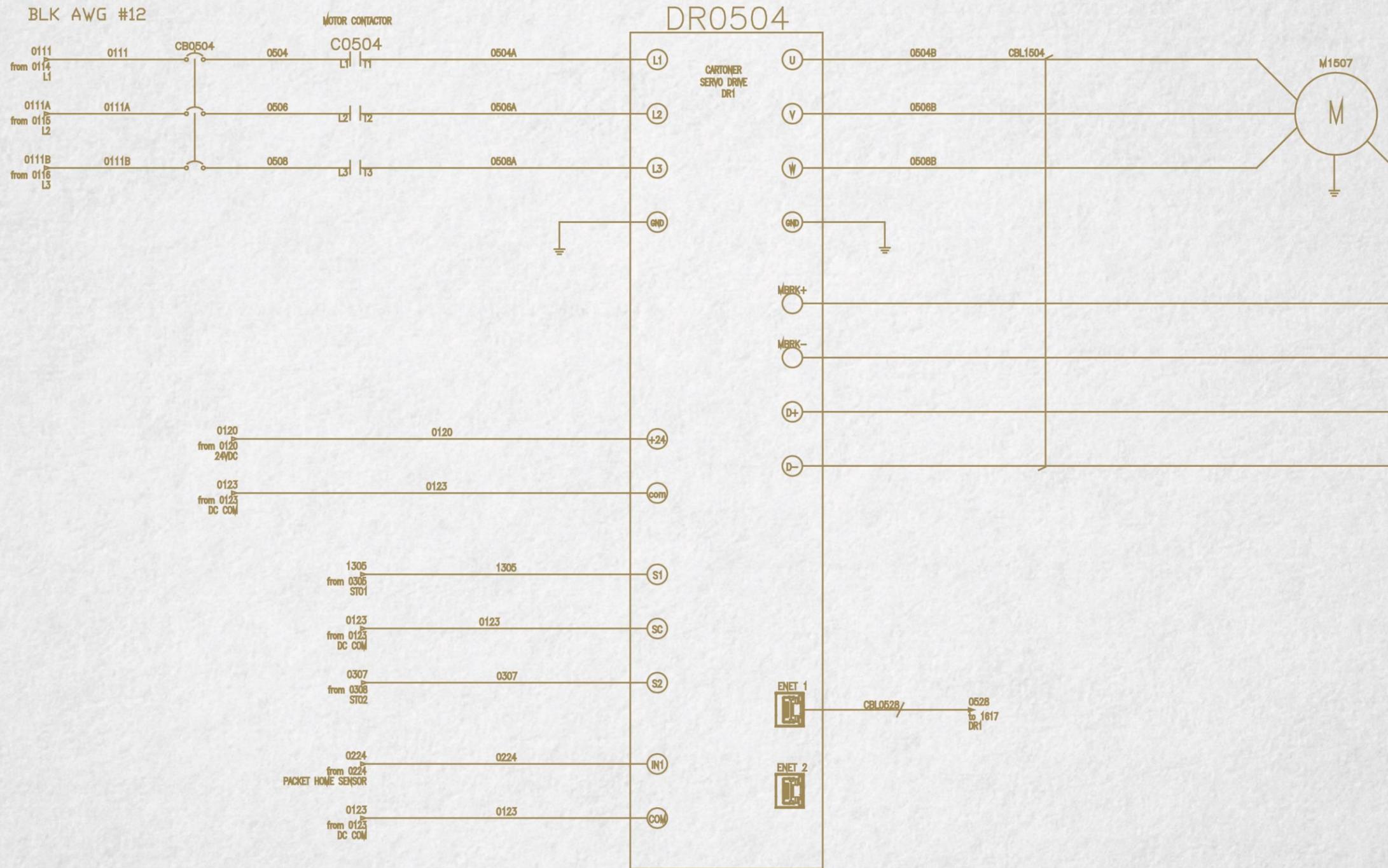
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COLBORNE FOODBOTICS		REVISION	DRAWN BY
YEAMAN MACHINE		JOB NO	DATE
28405 N. BALLARD DR. LAKE FOREST, IL 60045		VCA384-99-000	01/08/2020
DWG NO		VCA384-99-000-0400	
SHEET TITLE		SHEET NO	
Sensor Guard		4 OF 16	

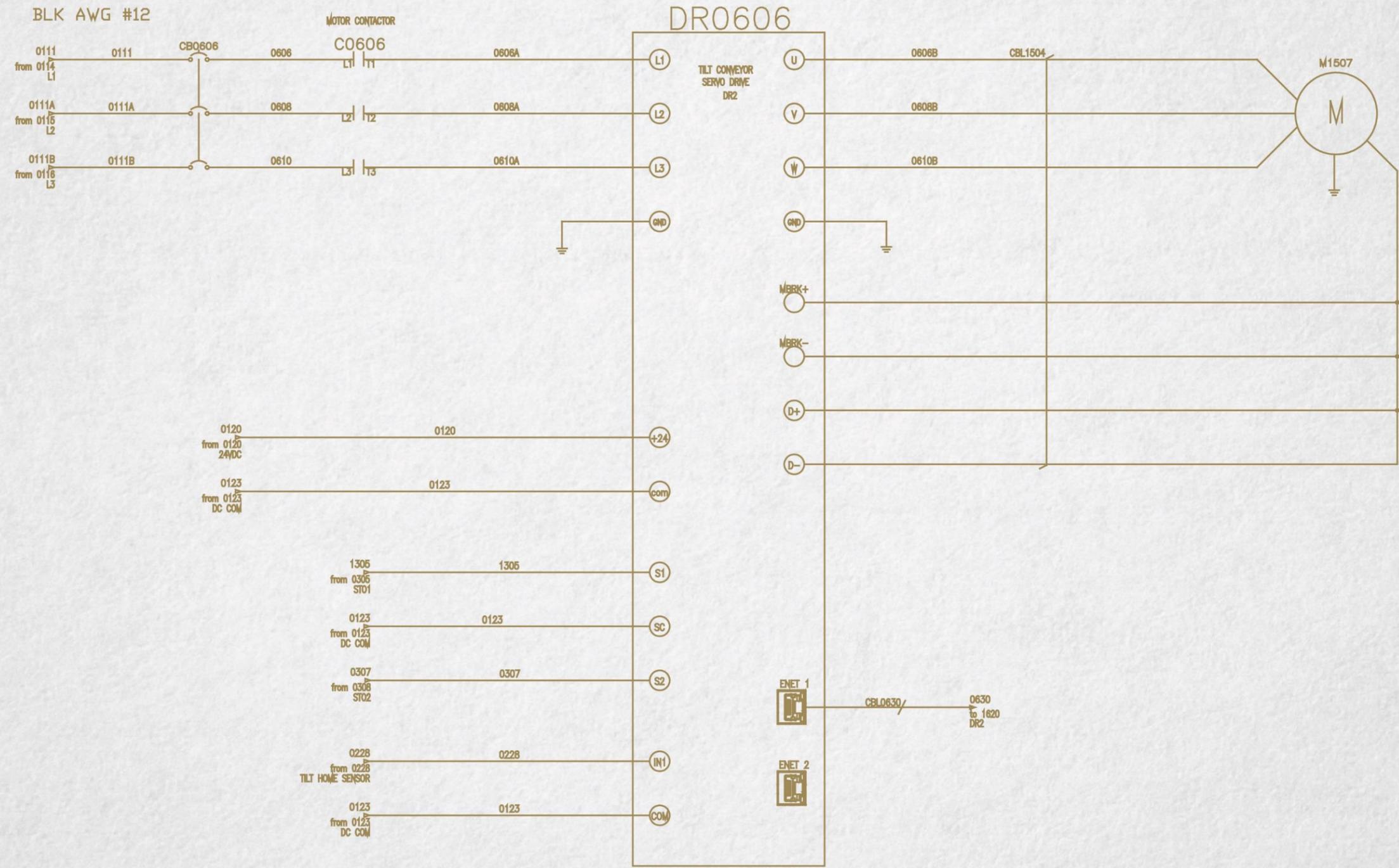
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COLBORNE FOODBOTICS YEAMAN MACHINE 28405 N. BALLARD DR. LAKE FOREST, IL 60045	REVISION JOB NO VCA384-99-000	DRAWN BY DATE 01/08/2020
	DWG NO VCA384-99-000-0500	
SHEET TITLE DR 1 - Cartoner Conveyor	SHEET NO 5 OF 16	

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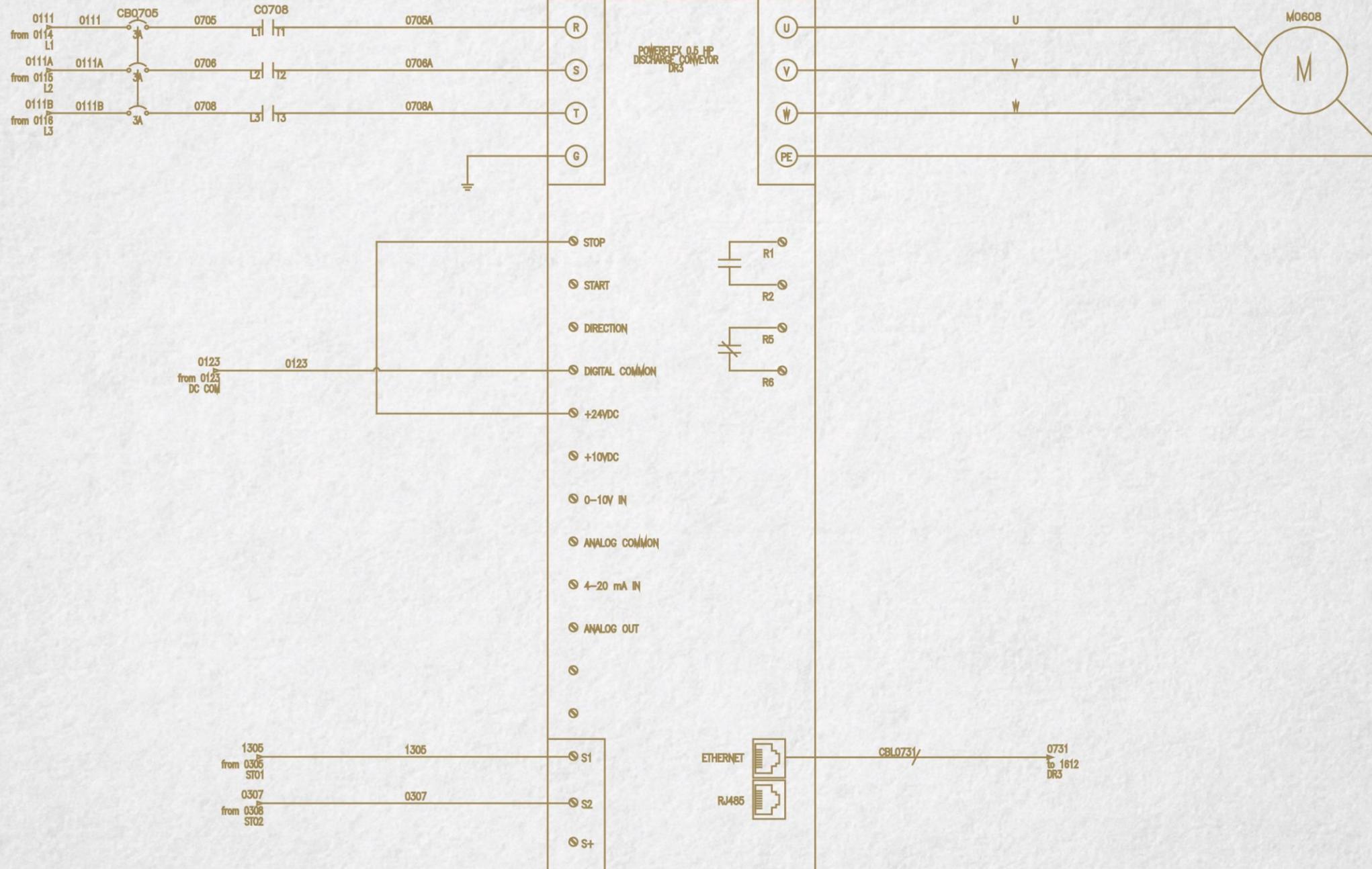
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COLBORNE FOODBOTICS YEAMAN MACHINE 28405 N. BALLARD DR. LAKE FOREST, IL 60045	REVISION JOB NO VCA384-99-000	DRAWN BY CW
	DATE 01/08/2020	Dwg No VCA384-99-000-0600
	SHEET NO DR 2 - Tilt Conveyor	SHEET NO 6 OF 16

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BLK AWG #14

DR0734

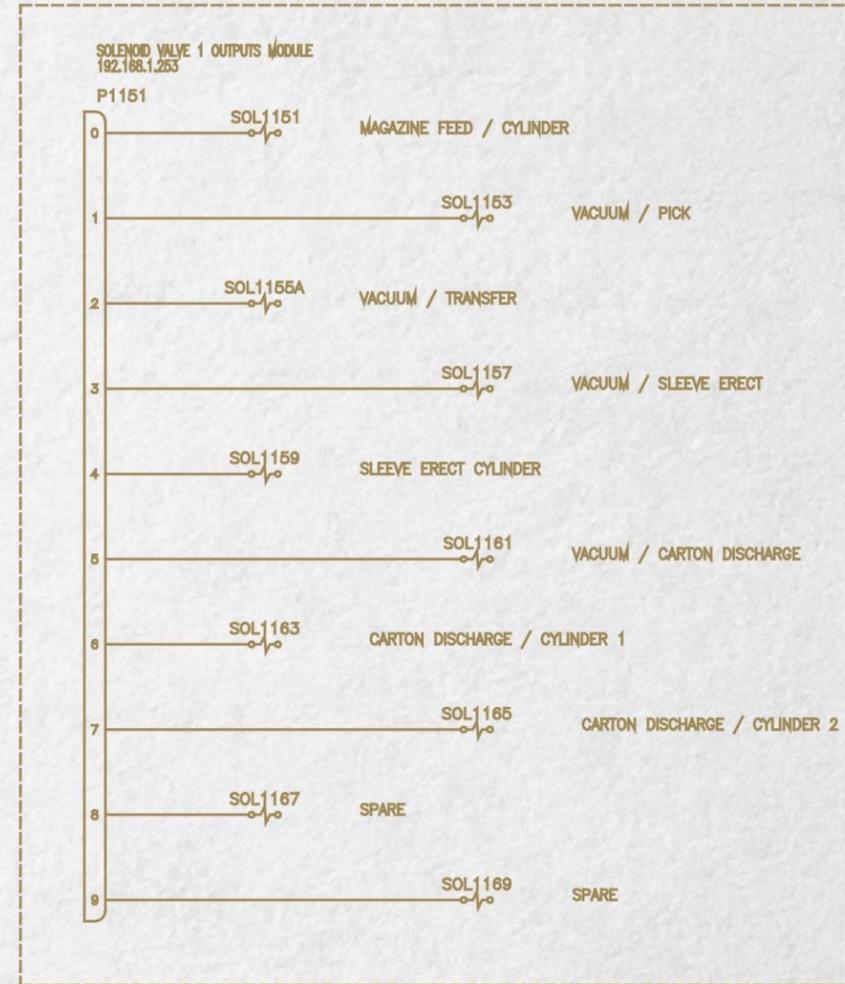


COLBORNE FOODBOTICS YEAMAN MACHINE 28405 N. BALLARD DR. LAKE FOREST, IL 60045	REVISION JOB NO VCA384-99-000	DRAWN BY DATE 01/08/2020
	Dwg No VCA384-99-000-0700	
Dwg Title DR 3 - Discharge Conveyor	Sheet No 7 OF 16	

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COLBORNE FOODBOTICS		REVISION	DRAWN BY
YEAMAN MACHINE		JOB NO	DATE
28405 N. BALLARD DR. LAKE FOREST, IL 60045		VCA384-99-000	01/08/2020
DIP NO		VCA384-99-000-1100	
DIP TITLE		SHEET NO	
Solenoid Valve Bank 1		11 OF 16	

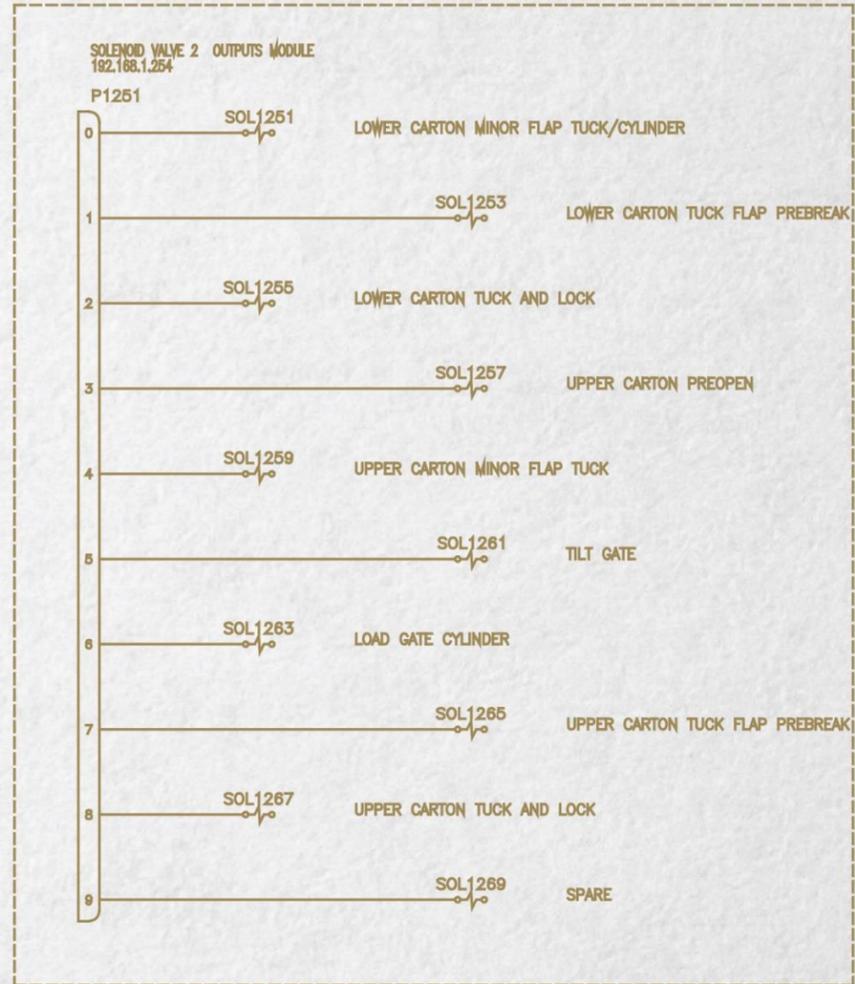
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SOLENOID VALVE BANK 2
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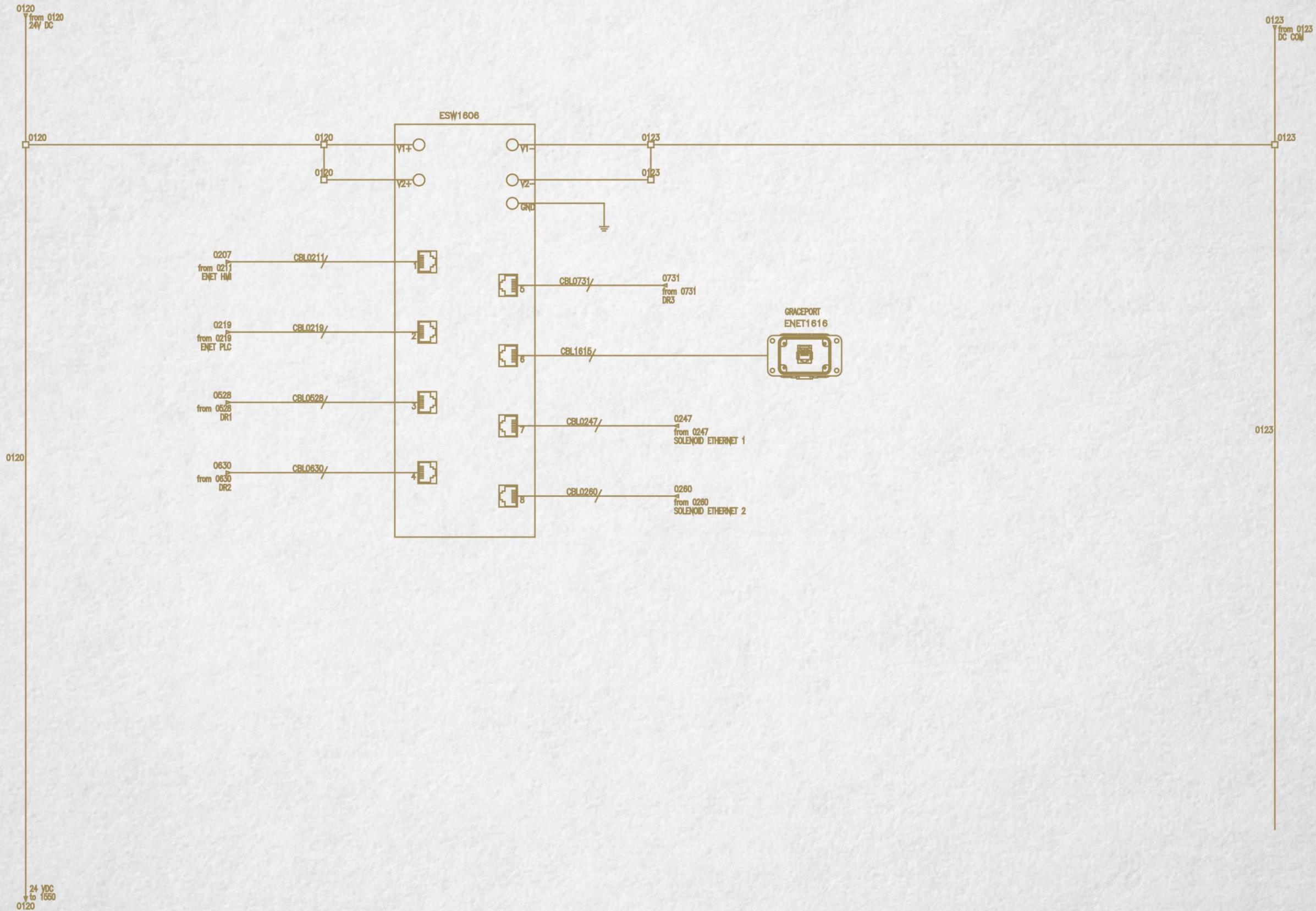
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COLBORNE FOODBOTICS		REVISION	DESIGNED BY
YEAMAN MACHINE		JOB NO	DATE
28405 N. BALLARD DR. LAKE FOREST, IL 60045		VCA384-99-000	01/08/2020
DTP NO		VCA384-99-000-1200	
SHEET TITLE		SHEET NO	
Solenoid Valve Bank 2		12 OF 16	

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COLBORNE FOODBOTICS YEAMAN MACHINE 28405 N. BALLARD DR. LAKE FOREST, IL 60045	REVISION JOB NO VCA384-99-000	DRAWN BY DATE 01/08/2020
	DTP NO VCA384-99-000-1600	
	SHEET NO 16 OF 16	

Ethernet Switch



SPARE PARTS & REMOTE SUPPORT

SUPPORT@YEAMANMACHINE.COM

847.758.0500



SALES

SALES@YEAMANMACHINE.COM

847.758.0500

THANK YOU

