

# *Optimizer MF Printer & Kirk-Rudy KR725 Feeder*

## *Condensed Operating Instructions*

### **Start Up**

- 1) Move ink in and ink out tubing approximately 2" from previous setting
  - a) Tubing can be moved either way
- 2) Lock down the ink in and ink out pumps.
  - a) Do not pinch tubing under guides
- 3) Remove the bag from under the print cylinder
- 4) Pull out all of the E-stops
  - a) The E-stop on the Kirk Rudy acts as the main power switch
- 5) Turn on the main power for the DCP
- 6) Verify all air is on
- 7) Push the green POWER button on the Kirk Rudy feeder
- 8) After the touch screen on Kirk Rudy feeder has powered up (50 seconds), push the yellow RESET button
- 9) Turn Ink pump selector switch to AUTO
- 10) Push INK IN button
  - a) Ink in pump will run for approx. 7 minutes
- 11) Turn the speed control to 15 cpm
- 12) Hold the JOG button down for 20 seconds (the print cylinder will rotate at 15 cpm; after 20 seconds it will continue to rotate on its own)
- 13) After the ink in pump shuts off hit the STOP button (the print cylinder will return to it's home position)
- 14) Prepare stencil for initial run
  - a) Load stencil on film loading device
- 15) Set the side stop on the Kirk Rudy feeder so the bags are centered on the suction cups
- 16) Set guides on DCP magazine to match the bag size
- 17) Set guides on the re-stacker to ½" wider than DCP guides
- 18) Unload the old stencil

## *Optimizer MF Printer & Kirk-Rudy KR725 Feeder Condensed Operating Instructions*

- 19) Load the new stencil
- 20) Verify the Kirk Rudy feeder bypass switch is in the RUN position
- 21) Turn on the restacker
  - a) Set the counter to desired bundle size (dump count)
  - b) Verify the conveyor is running
  - c) Pull the re-stacker back into the run position (aligned with the DCP)
- 22) Push the START button on the Kirk Rudy feeder (green status light starts flashing)

### **Printing**

- 1) Verify that the re-stacker is in proper position
- 2) Load the Kirk Rudy feeder with bags
- 3) Run a sample to verify print position and message
- 4) Set counter to desired number for run
- 5) Push RUN button
- 6) While printing note print quality
- 7) If poor print – increase “bounce “ and/or decrease speed
  - a) Bounce not to exceed 1/8”
  - b) Check air pressure: 65 psi min.; 85psi max.
- 8) If offset noted
  - a) Decrease bounce and /or increase speed
- 9) Once a stack of bags has transferred to the pick off section on the Kirk Rudy feeder, push the INDEX button so the next stack will transfer to the feed section after the last bag is picked.
- 10) At end of run do the following:
  - a) Unload unused bags from the feeder
  - b) Load new stencil on film loading device
  - c) Unload the old stencil
  - d) Load new stencil
  - e) Go back to step 1 in this section

# *Optimizer MF Printer & Kirk-Rudy KR725 Feeder*

## *Condensed Operating Instructions*

### **Shut Down**

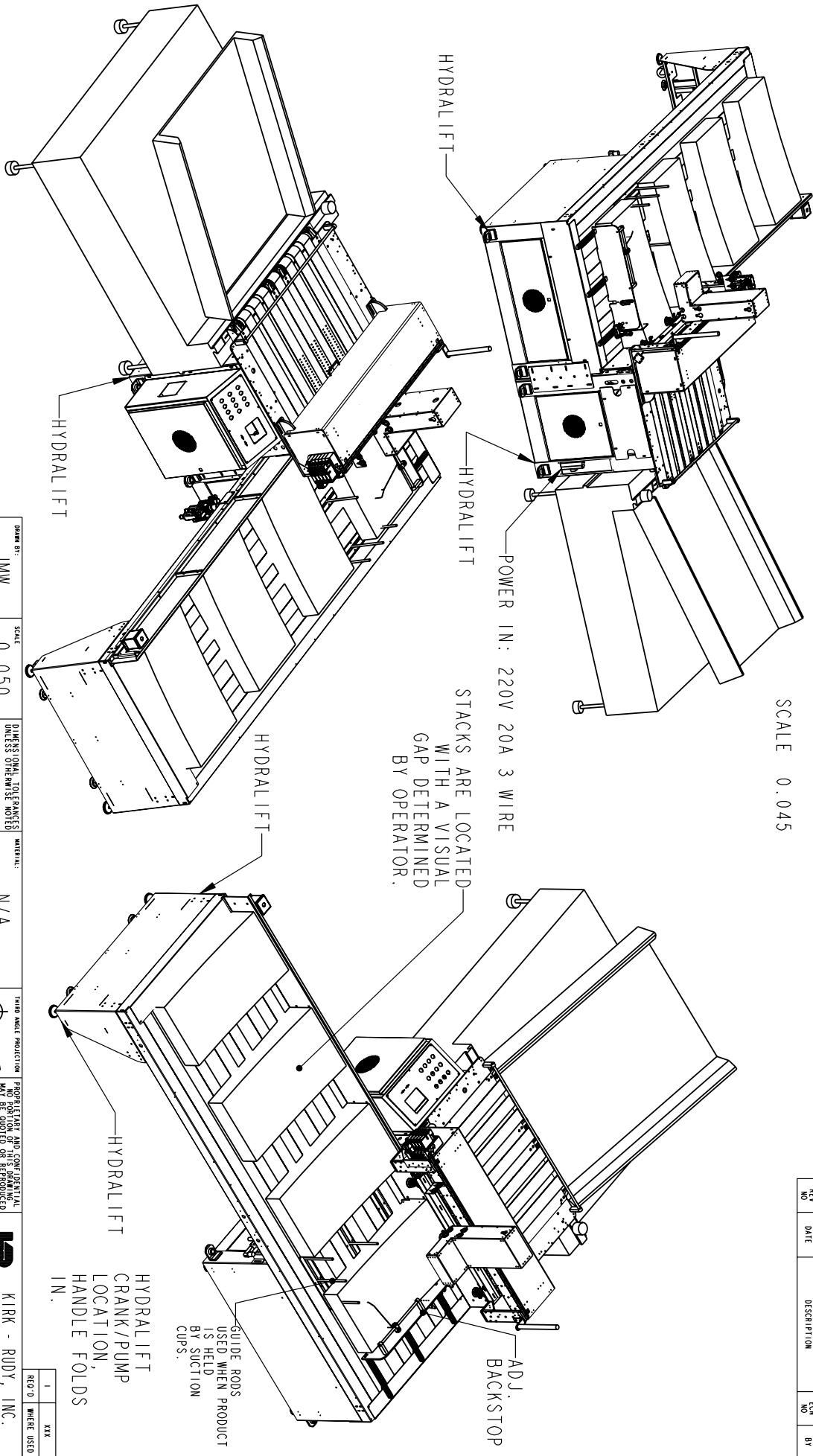
- 1) Turn off the re-stacker and return conveyer
- 2) Push the INK OUT button
  - a) Pump will run for approximately 6 minutes
- 3) Release the lock down on the INK IN pump
- 4) Blow off any dust
- 5) Place an old bag under the print cylinder
- 6) After the INK OUT pump stops, release the INK OUT pump lock down
- 7) Turn off main power
- 8) Push the E-stop on the Kirk Rudy feeder

# *Kirk-Rudy KR725 Bag Feeder Spare Parts List*

SPARE PARTS			
Part #	Description	Qty	Type
<b>Mechanical</b>			
112314	BELT, 3" X 68.75 HSW-5EB W/HOLES	3	WEAR
112315	BELT, 3" X 68.75 HSW-5EB	4	WEAR
545036-10	ASSY, PINCH ROLLER	1	WEAR
545036-09	ASSY, PINCH ROLLER	1	WEAR
550418-06	SS KNOCK DOWN GUIDE	1	WEAR
550418-07	SS KNOCK DOWN GUIDE	1	WEAR
191634	SUCTION CUP	3	WEAR
108936	BELT, TIMING 345L075	1	WEAR
112068	BELT, WHITE 3" X 81.375"	6	WEAR
<b>Electrical</b>			
208056-7	LP-CC 8 AMP FUSE	4	CRITICAL
208056-10	LP-CC 15 AMP FUSE	4	CRITICAL
208056-0	LP-CC 6/10 AMP FUSE	2	CRITICAL
208023	ABC 12 AMP FUSE	2	CRITICAL
208022	AGC 8 AMP FUSE	2	CRITICAL
202426-2	KBMM BOARD 230 VAC 90 V MOTOR	1	CRITICAL
202276	RH2B-ULC DC24V RELAY 24 VDC	1	CRITICAL
202272	RH2B-ULC AC120 RELAY 120 VAC	1	CRITICAL
202261-5	PHOTO EYE SM312LVQD	1	CRITICAL
191657	PROX SWITCH MRS-.087-XBL-12	1	CRITICAL
191635	PRESSURE SWITCH PIAB 331.16.068	1	CRITICAL

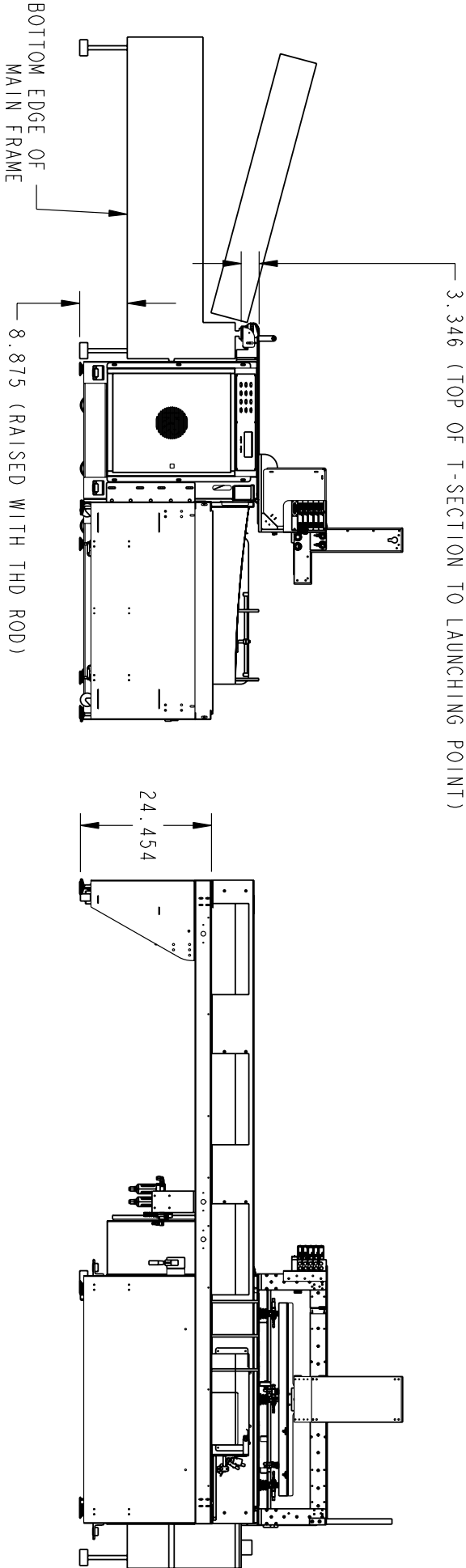
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NO			NO	

SCALE 0.045



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CHECKED BY:	DATE: 23-Feb-12	IN:	OUT:	IN:	OUT:	HEAT TREAT: N/A	FINISH: N/A	MOD: SA952	TITLE: ASSY, BAG FEEDER	KIRK - RUDY, INC. WOODSTOCK, GEORGIA	
TRACED BY:	MASTER	DO NOT SCALE - WORK TO DIMENSIONS ONLY						SHEET NO: 1 OF 4		DRAWING # SA952	

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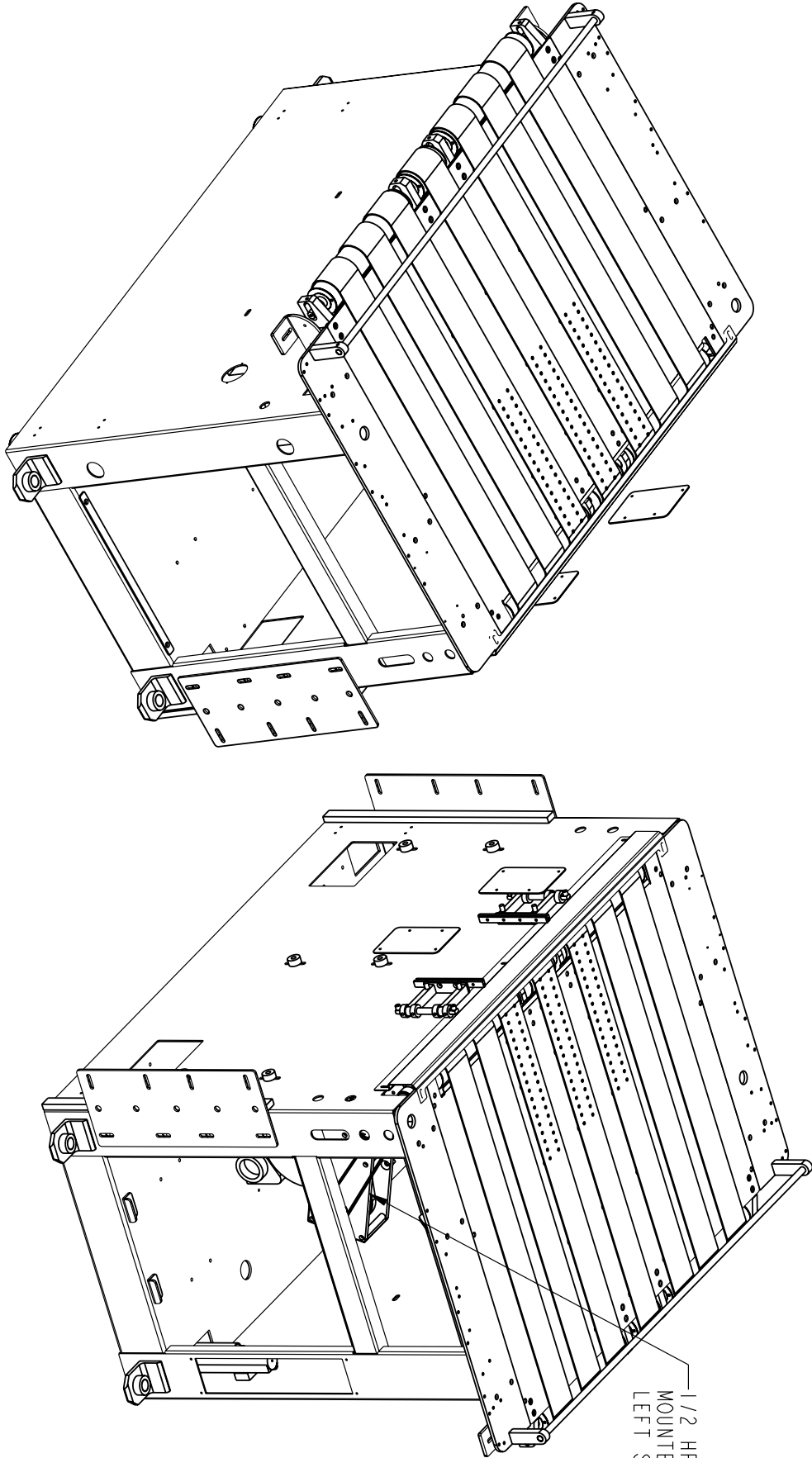


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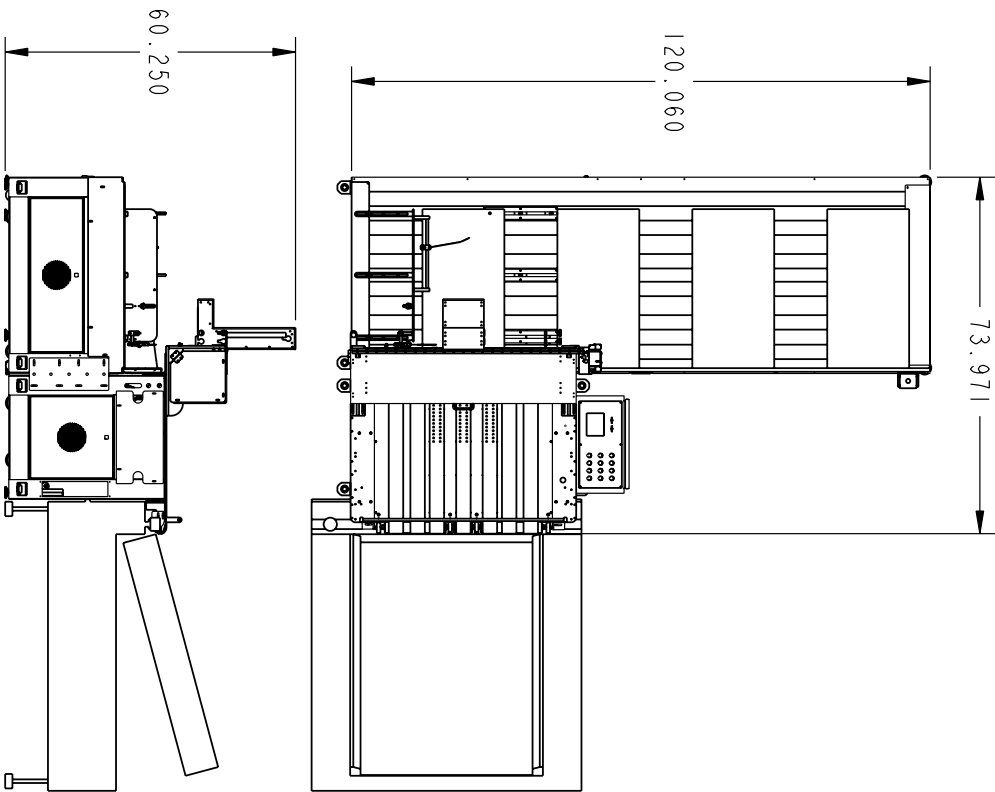
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CHECKED BY:	DATE: 05-Mar-12	FINISH: N/A	WHAT TREAT: N/A	MODEL: SA952	TITLE: ASSY, BAG FEEDER
TRACED BY:	MASTER	DO NOT SCALE - WORK TO DIMENSIONS ONLY	N/A	SHEET NO: 30F4	DRAWING # SA952



KIRK - RUDY, INC.  
WOODSTOCK, GEORGIA

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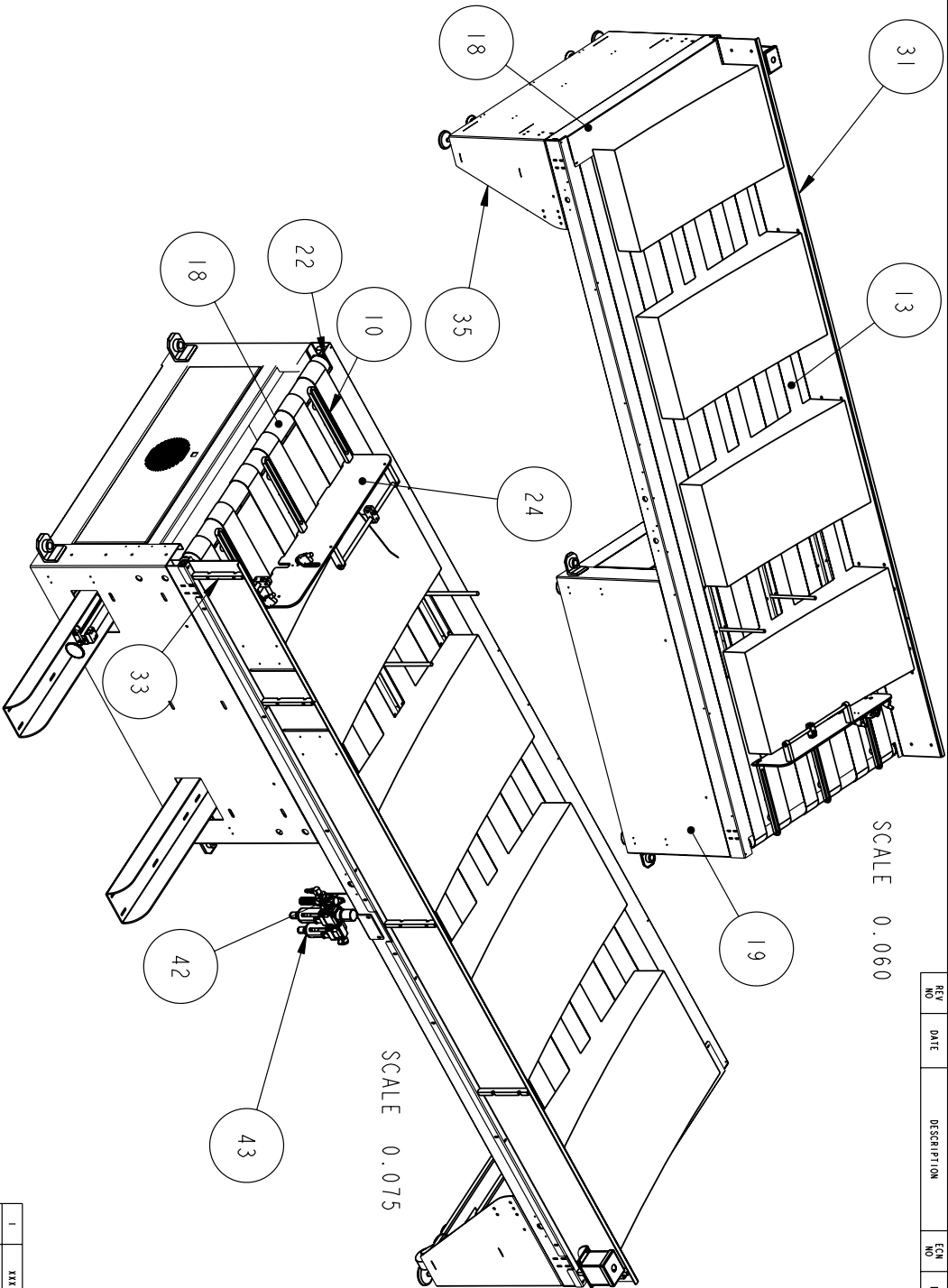
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CHECKED BY:	DATE: 06-Mar-12	FINISH: N/A	WHAT TREAT: N/A	REMOVE ALL BURRS AND OTHERWISE NOTED	MOD: SA952	TITLE: ASSY, BAG FEEDER
TRACED BY:	MASTER	DO NOT SCALE - WORK TO DIMENSIONS ONLY	N/A	SHEET NO: 40F4	SA952	DRAWING # SA952

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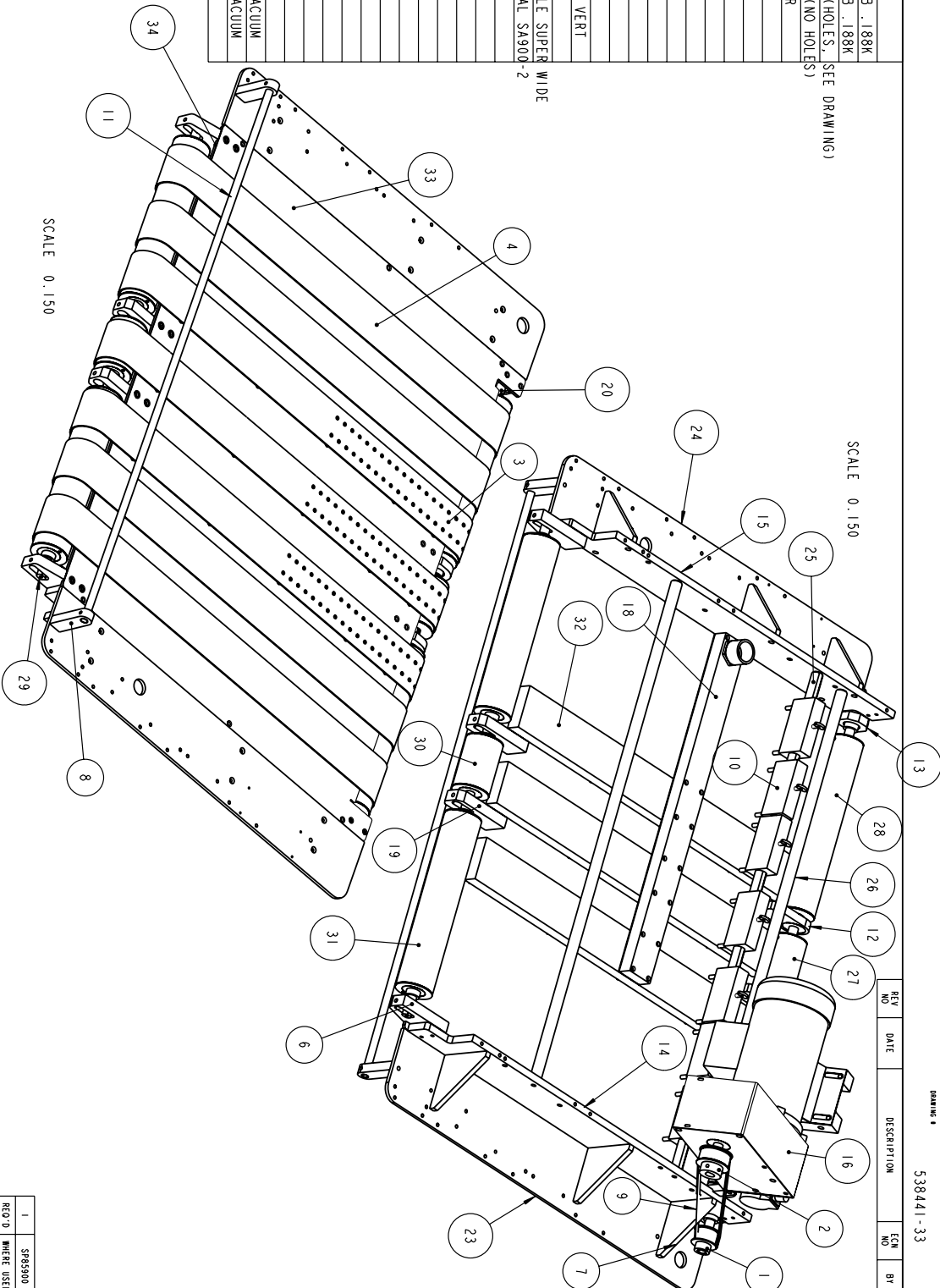
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1	103804	BEARING, HUB .625
2	110232	SPKRT, 35815 .625H .188K
3	190634	FOOT, MOUNTING
4	191653	CYLINDER, B1MBA M-129-DPNT
5	500331	HUB, ROLLER
6	500191	POST, SIDEGUIDE
7	500836	HUB
8	501816	TAKEUP BAR
9	501901	TAKEUP BAR
10	501906	BAR, SUPPORT
11	508593	CLAMP
12	102205-3	COLLAR
13	112068-2	BELT, WHITE 3" X 241.375"
14	200265-1	ELECTRICAL SWITCH BOX, 1 HOLE
15	202261-5	BEAMSWITCH, RETROREFLECTIVE
16	500330-1	HUB, ROLLER
17	500787-49	SHAFT-SIDE GUIDE ADJ.
18	500835-38	ROLLER, BELT IDLER WIDE
19	501210-50	WIDMNT, CONV. LEG - SA952
20	501811-20	SHAFT, TAKEUP
21	501812-1	LEG, LEVELING
22	501820-15	SHAFT, KR314 DRIVE SA910
23	501907-14	SHAFT, ROLLER
24	501914-2	PLATE, BACKSTOP SA952
25	501914-4A	ASSY, XXX
26	508996-4	BRACKET, PHOTOCELL
27	508996-NEXT	BRACKET, PHOTOCELL
28	530363-06	SUPPORT, LOWER CYLINDERS
29	530363-07	MOUNT, RAIL CYLINDERS
30	530363-14	MOUNT, RAIL CYLINDERS LONG
31	530414-06	BACKSTOP, SS SIDE
32	530414-09	MOUNT, PUSH BUTTON
33	530417-02	SUPPORT, BACKSTOP
34	530575-25	WELDMENT, CONVEYOR OUTFD GUARD
35	530965-26	WELDMENT, CONVEYOR LEG
36	530973-14	WELDMENT, COVER INFEED
37	535209-01	BLOCK, CLAMP BOTTOM
38	535209-02	BLOCK, CLAMP TOP
39	536665-20	PLATE, SUPPORT
40	546701-18	CONVEYOR TOP, SA952
41	546701-18A	WELDMENT, CONVEYOR TOP
42	546859-08	MOUNT, AIR ASY
43	547201-02	ASSY, AIR REGULATOR
44	553277-02	SHAFT, GLUE MOUNT
45	14	RHNO12 NUT, HEX 3/8
46	4	SA952-PRODMATERIALW-33L



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CHECKED BY:	DATE: 06-Mar-12		1/4"	1/8"	3/16"	HEAT TREAT: N/A		MOD: SA952		TITLE: ASSY, CONVEYOR SA952	KIRK - RUDY, INC. WOODSTOCK, GEORGIA	
TRACED BY:	MASTER		REMOVE ALL DIMENSIONS AND FINISHED DIMENSIONS ARE TO DIMENSIONS ONLY			FINISH: N/A		SHEET NO: 10F1		DRAWING # 530354-05		

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REV D	WHERE USED

ITEM QTY	PART #	DESCRIPTION
1	108809	PULLEY, TIMING 12L075 .625B .188K
2	1	108818 PULLEY, TIMING 16L075 .625B .188K
3	1	112314 BELT, 3" X 68.75" HSW-5EB (HOLES, SEE DRAWING)
4	5	112315 BELT, 3" X 68.75" HSW-5EB (NO HOLES)
5	1	202492 ENCODER, ACCU-CODER 1000PPR
6	2	500716 BRACKET - BELT TAKE-UP
7	6	500721 GUSSET - TABLETOP SUPPORT
8	2	500791 POST, SIDEGUIDE
9	1	108936-44 BELT, TIMING 34S1075
10	7	500725-29A ASSY, BELT GUIDE 3"
11	1	500787-41 SHAFT-SIDE GUIDE ADJ.
12	2	500819-23A ASSY, BEARING BLOCK
13	2	500819-2A ASSY, BEARING LOCK
14	1	501201-46 FRAME, 219 RH - SA952
15	1	501202-12 FRAME, 219 LH - SA952
16	1	509000-8A ASSY, MTR/REDUCER SR 1/2HP VERT
17	1	530654-01 ASSY, MOTOR MTG BAR
18	1	530656-42 ASSY, VACUUM MANIFOLD TRIPLE SUPER WIDE
19	2	533975-05 BRACKET, BELT TAKEUP SPECIAL SA900-2
20	1	534181-40 SHAFT, FRONT ROLLER DRIVE
21	1	537691-01 BAR, ENCODER STUD MNT.
22	1	538341-01 STUD, ENCODER MOUNT
23	1	538576-01 TABLETOP, SIDE 219B RH
24	1	538576-02 TABLETOP, SIDE 219B LH
25	1	541310-06 SHAFT-BELT GUIDE
26	2	541310-07 SHAFT, SPACER FRAME
27	1	541316-09 ASSY, DRIVE ROLLER SHORT
28	2	541316-11 ASSY, DRIVE ROLLER SIDE
29	1	541325-07 SHAFT, IDLER OUTFEED ROLLER
30	1	556023-01 ASSY, IDLER ROLLER
31	2	556023-02 ASSY, IDLER ROLLER
32	3	SP30202 BLOCK, VACUUM
33	1	SP30201-15TABLETOP, 219 TRIPLE ROW VACUUM
34	1	SP30201-15TABLETOP, 219 TRIPLE ROW VACUUM
35	1	SP45241-10 PLATE, ENCODER MOUNT

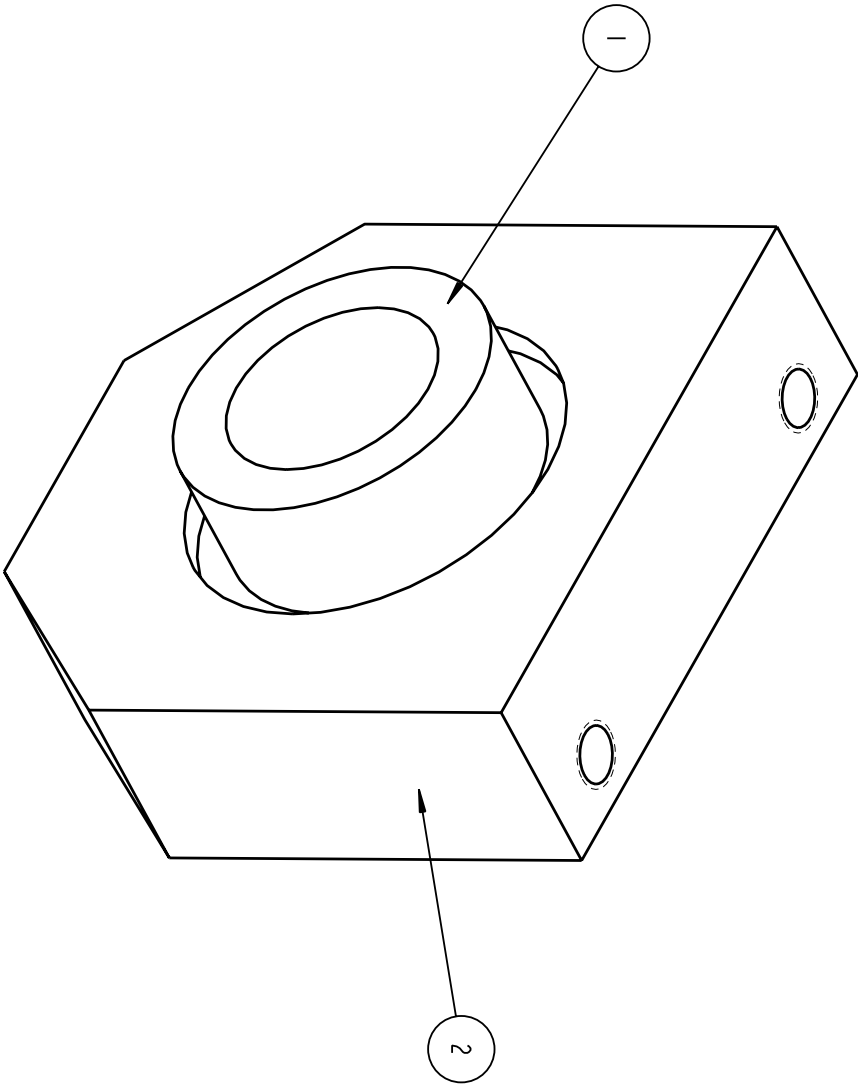


SCALE 0.150

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SHEET NO. 10F1		MOD. SA952		TITLE: ASSY, 219 STYLE OUTFEED - SA952		DRAWING # 538441-33		REV. NO. 1		DATE: 05-Mar-12		DESCRIPTION: ASSY, 219 STYLE OUTFEED - SA952	
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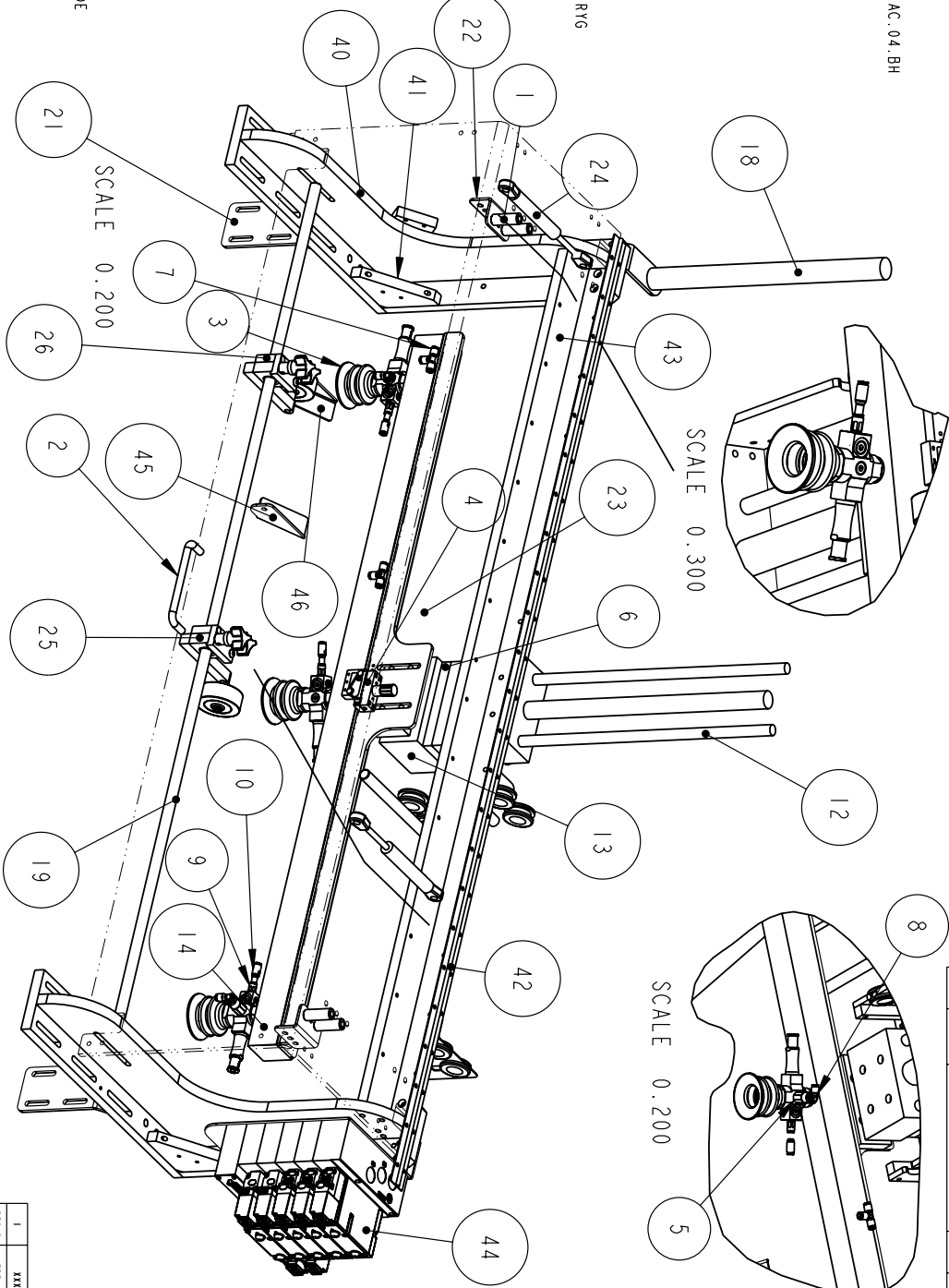
ITEM	QTY	PART #	DESCRIPTION
1	1	103804	BEARING, HUB .625
2	1	500819-2	BLOCK, BEARING

REV NO	DATE	DESCRIPTION	ECN NO	BY
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CHECKED BY:		DATE: 12-Apr-00		.XX .XIX .01 .005 .5 ANG.		HEAT TREAT: N/A		MODEL: 215		TITLE: ASSY, BEARING LOCK					
TRACED BY:		MASTER		REMOVE ALL BURS AND SHARP EDGES UNLESS OTHERWISE NOTED ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY		FINISH: N/A		SHEET NO. 1 OF 1		DRAWING #		500819-2A			

ITEM/ITY	PART #	DESCRIPTION
1	102670	SPACER
2	190955	HANDLE
3	191631	ASSY. VACUUM GENERATOR - PIAB VG33010.AC.04.BH
4	1	SWITCH, VACUUM PIAB 31.16.068
5	3	CHECK VALVE, PIAB 1036
6	191656	TRANSITION PLATE, BIMBA TP109-T09PD
7	4	FITTING, LEGRIS 3104-04-00
8	5	191671 FITTING, LEGRIS 3199-04-10
9	3	191672 FITTING, LEGRIS 3101-04-19
10	3	191673 FITTING, LEGRIS 3166-04-06
11	1	190724-30 HINGE, COVER SA950
12	1	190747-1 BIMBA TE-0912-CDHM
13	1	190747-2 BIMBA TE-095-CDHM
14	1	191648-3 EXTRUSION, 80/20 1515-22
15	4	200513-5 GROMMET, RUBBER, 75ID1X.375ODX.56TH
16	4	200513-6 GROMMET, RUBBER, 75ID1X.380DX.38TH
17	2	201176-2 SWITCH, SAFETY INTERLOCK W/MAGNET
18	1	202284-14 TOWER SIGNAL, 3 LIGHT PATLITE MPS-302 RV6
19	1	500787-47 SHAFT-SIDE GUIDE ADJ. LONG
20	1	508594-3 POST, SENSOR
21	2	530242-04 SUPPORT, BAG FEEDER TO CABINET
22	2	530242-06 MOUNT, GAS SPRING
23	1	530242-24 SUCTION CUP MTG BAR - SA952 (TGA LONG)
24	2	532453-03 DATUM CURVE, GAS SPRING
25	1	545036-09 ASSY, SPRING ROLLER
26	1	545036-10 ASSY, SPRING ROLLER
27	2	546858-01 COVER, LEXAN SIDE
28	2	546858-03 COVER, LEXAN SIDE
29	1	546858-04 COVER, LEXAN BACK SIDE
30	1	546858-05 COVER, LEXAN FRONT VERTICAL
31	1	546858-06 COVER, LEXAN TOP LOWER SECTION
32	1	546858-07 COVER, LEXAN LOWER FRONT
33	1	546858-08 COVER, LEXAN TOP
34	1	546858-12 COVER, LEXAN HINGED BAG FEEDER SA952
35	2	546859-02 SUPPORT, MOUNT FOR LEXAN
36	1	546859-07 MOUNT, AIR REG. - VALVES
37	1	546859-14 MOUNT, VACUUM LINES NEW - SHORT
38	2	546860-01 FRAME, BASE BAG FEEDER
39	2	546860-03 FRAME, VERTICAL BAG FEEDER
40	2	546860-04 GUSSET, RH SUPPORT BAG FRAME
41	4	546860-08 GUSSET, SMALL SIDES
42	1	546860-14 MOUNT, LINEAR THRUSTERS BAG FEEDER
43	1	546860-15 FRAME, BACKING SUPPORT WIDE
44	1	546863-01 ASSY, VALVE GANG SA550
45	1	550418-06 PLOW, RH BAG FEEDER
46	1	550418-07 PLOW, RH BAG FEEDER

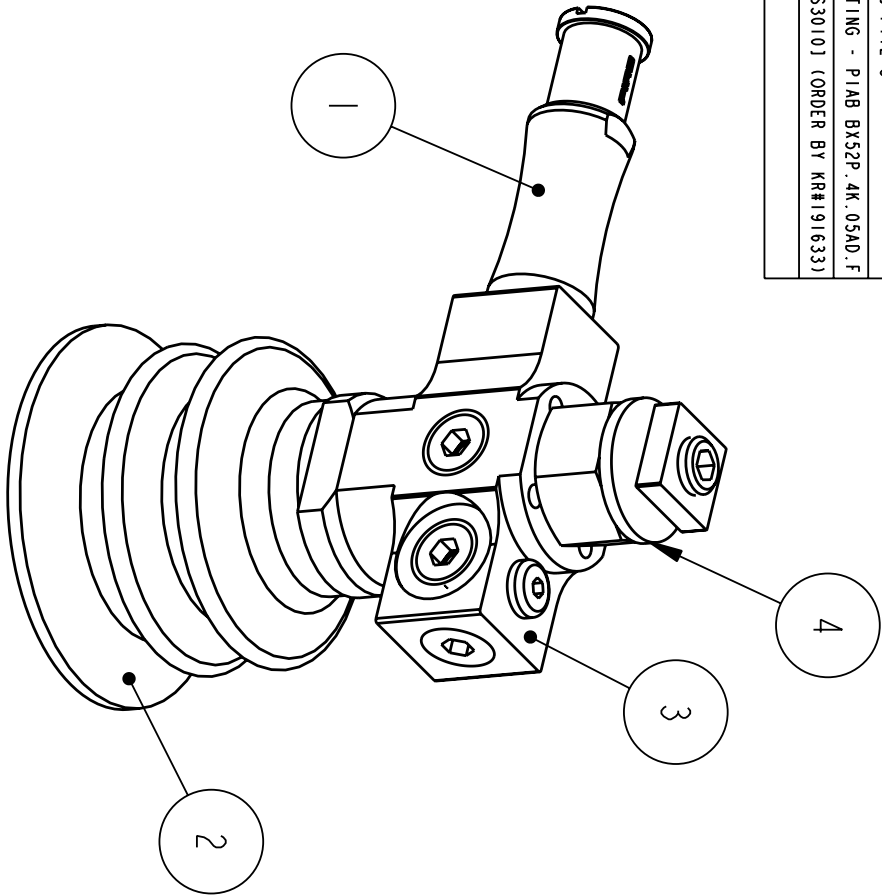


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CHECKED BY:		DATE 06-Mar-12		REMOVE ALL DIMENSIONS AND FINISHED DIMENSIONS ARE TO DIMENSIONS UNLESS OTHERWISE NOTED			HEAT TREAT: N/A		MOD: SA952		TITLE ASSY, BAG FEEDER PICK/PLACE		DRAWING # 546861-04	
TRACED BY:		MASTER		DO NOT SCALE - WORK TO DIMENSIONS ONLY			FINISH: N/A		SHEET NO. 10F1					

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ITEM	QTY	PART #	DESCRIPTION
1	1	191632	VACUUM CARTRIDGE, PIAB P112-3
2	1	191634	SUCTION CUP, WITH FITTING - PIAB BX52P.4K.05AD.F
3	1	191633A	VACUUM BODY, (PIAB VGS3010) (ORDER BY KR#191633)
4	1	PIAB-MOUNT	NG-8MM

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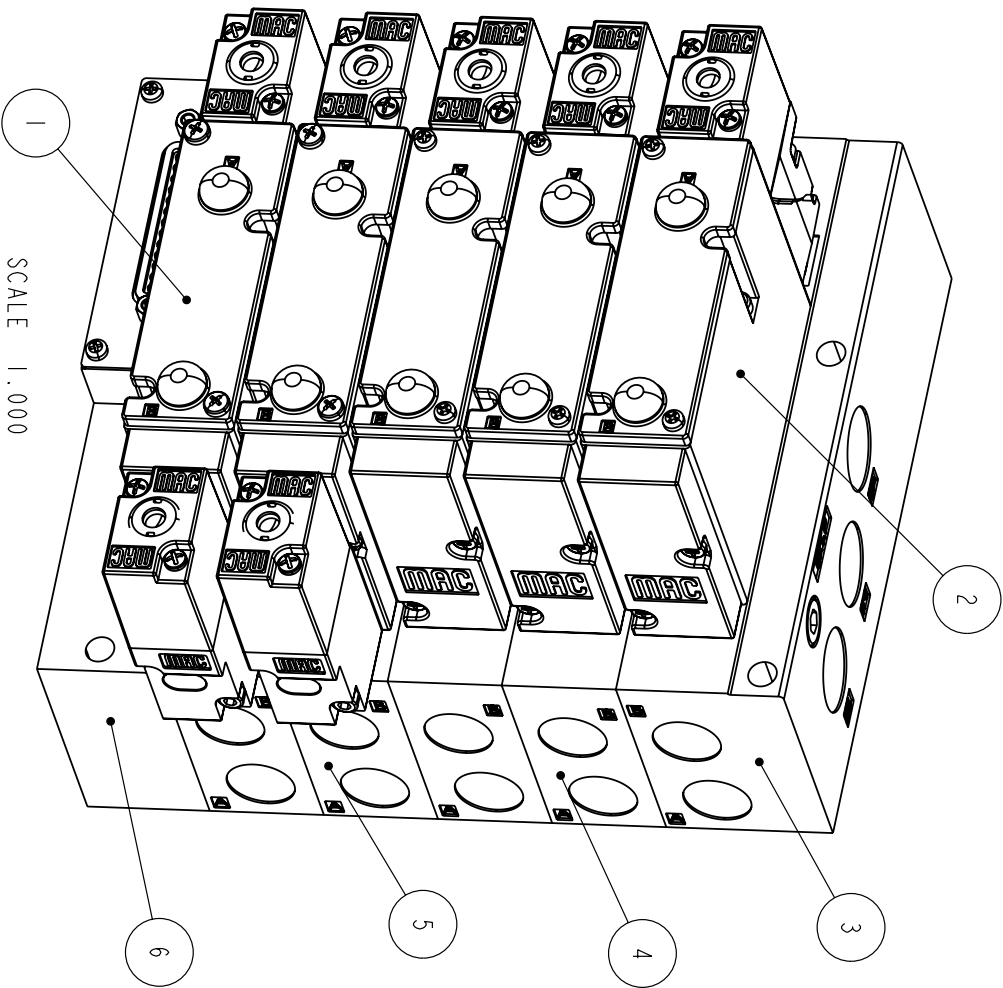


SCALE 1.000

DRAWN BY:	JMW	SCALE	0.500	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	.XX	.XXX	ANG.	MATERIAL:	N/A	THIRD ANGLE PROJECTION	PROPRIETARY AND CONFIDENTIAL NO PORTION OF THIS DRAWING MAY BE QUOTED OR REPRODUCED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC. WOODSTOCK, GA 30188 USA	KIRK - RUDY, INC. WOODSTOCK, GEORGIA	
CHECKED BY:		DATE	24-Oct-07	REMOVE ALL BURS AND SHARP EDGES UNLESS OTHERWISE NOTED	.01	.005	.5	HEAT TREAT:	N/A	MODEL:	SA550	TITLE:	ASSY, VACUUM GENERATOR - PIAB VGS3010.AC.04.BH
TRACED BY:		MASTER		ALL DIMENSIONS ARE FINISHED DIMENSIONS DO NOT SCALE - WORK TO DIMENSIONS ONLY				FINISH:	N/A	SHEET NO.	1 OF 1	DRAWING #	191631

1	XXX
REV'D	WHERE USED

ITEM QTY	PART #	DESCRIPTION
1	191660	MAC VALVE, MAC 92B-EAF-000-DM-DDAP-1DM
2	3	191661MAC VALVE, MAC 92B-AAF-000-DM-DDAP-1DM
3	1	191662MAC VALVE, MAC 92B-000-BL3-1705
4	2	191663MAC BASE, MAC 92B-000-BJ3-1705
5	2	191664MAC BASE, MAC 92B-000-BJ4-1705
6	1	191665MAC END PLATE, MAC M-92010-25-3-1705

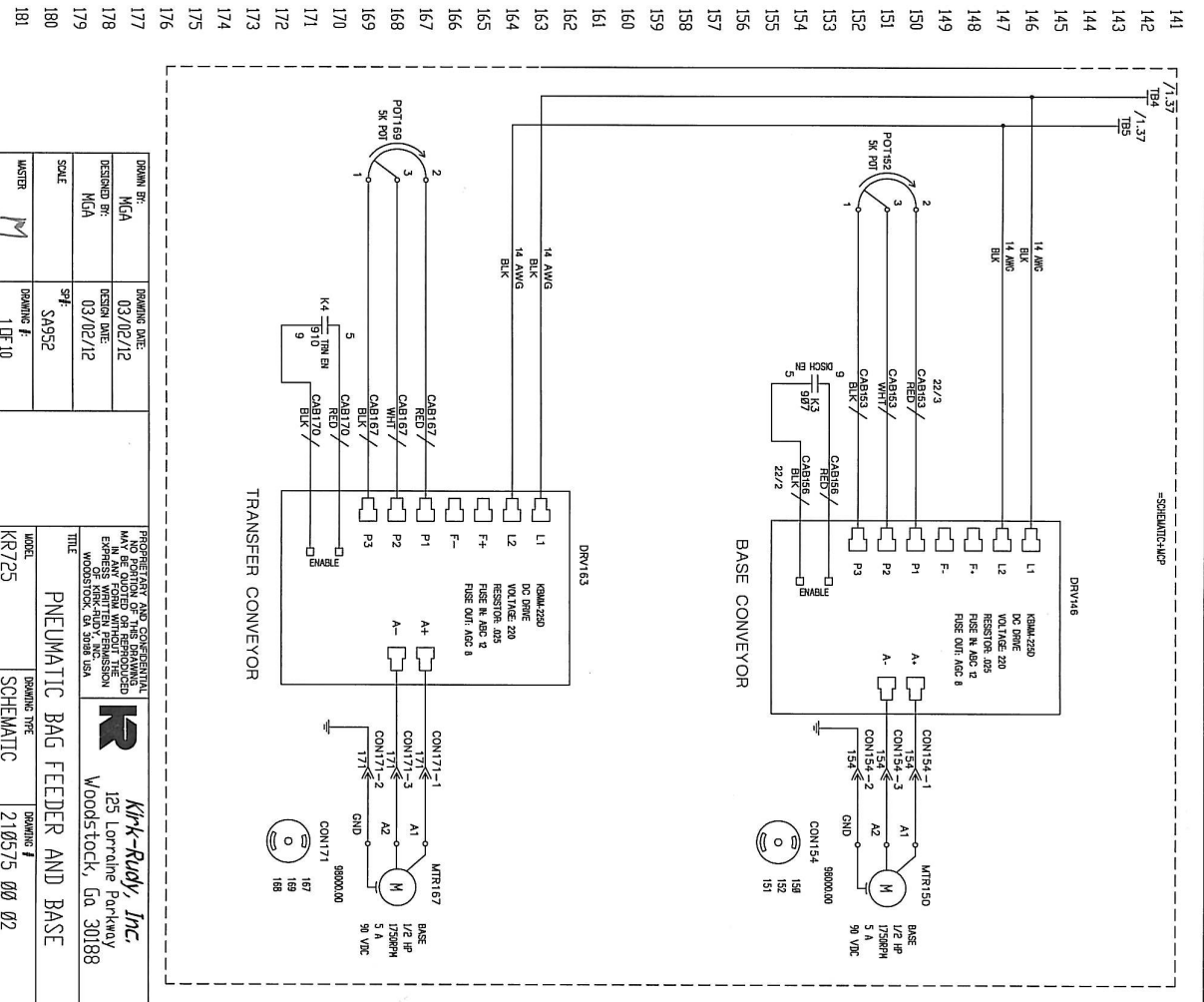
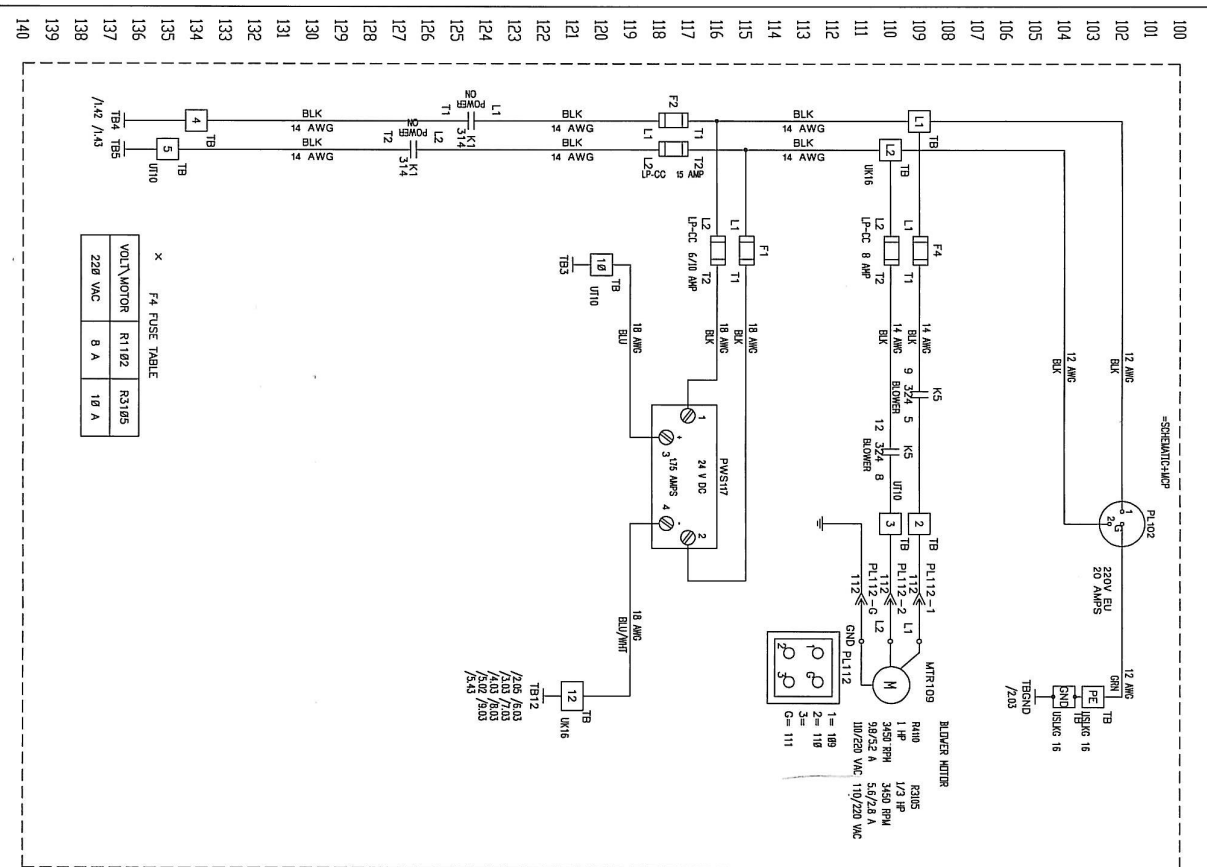


DESIGNED BY:	SCALE:	DIMENSIONAL TOLERANCES UNLESS OTHERWISE NOTED	MATERIAL:	THIRD ANGLE PROJECTION	PROPERTY AND CONFIDENTIALITY
JMW	0.500		N/A		NO PORTION OF THIS DRAWING MAY BE REPRODUCED OR TRANSMITTED IN ANY FORM WITHOUT THE EXPRESS WRITTEN PERMISSION OF KIRK - RUDY, INC.
CHECKED BY:	DATE:	REWORK ALL DIMENSIONS AND FINISHES UNLESS OTHERWISE NOTED	WHAT TREAT:	MOD:	TITLE:
	20-Nov-07		N/A	SA550	ASSY, VALVE GANG SA550
TRACED BY:	MASTER	DO NOT SCALE - WORK TO DIMENSIONS ONLY	FINISH:	SHEET NO.:	DRAWING #
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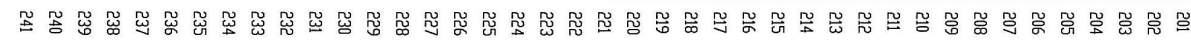




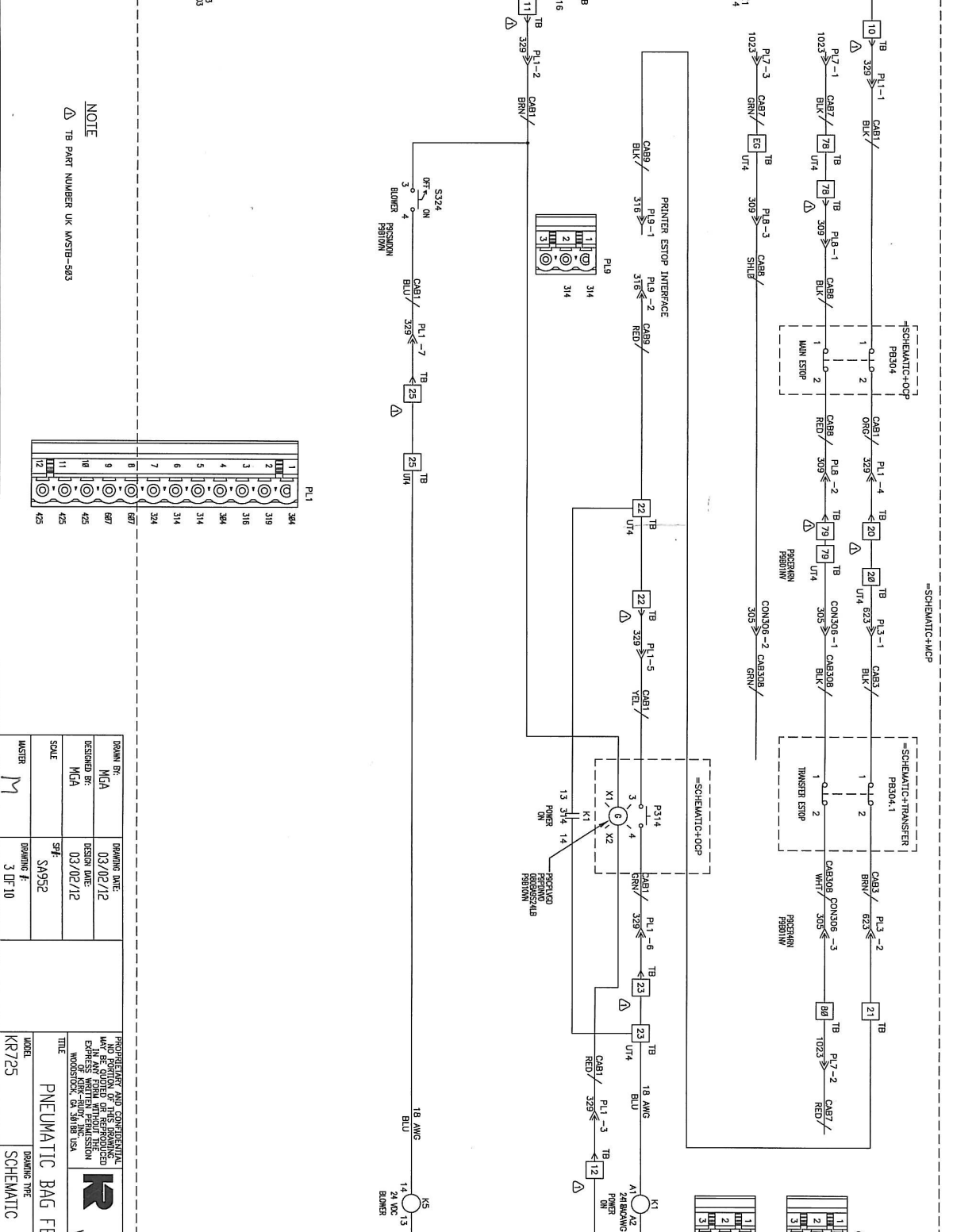


DESIGNED BY: MGA	DESIGNED DATE: 03/02/12	PROPERTY AND CONSENT MAY BE OBTAINED ON REQUESTED EXPRESS WRITTEN PERMISSION OF KIRK-RUDY, INC. OR WOODSTOCK, GA 30188
SCALE: S4952	DRAWING #: 1DF10	
MODEL: KR25	DRAWING TYPE: SCHEMATIC	DRAWING #: 210575 00 02

**Kirk-Rudy, Inc.**  
125 Lorraine Parkway  
Woodstock, Ga 30188



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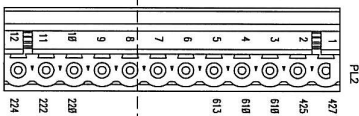
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DESIGNED BY:	DESIGN DATE:		
MCA	03/02/12		
SCALE:			
	5/8"		
MASTER:	DRAWING #		
M	3 OF 10		

NOCH	DRAWING TYPE	DRAWING #
KR725	SCHEMATIC	210575 00 02




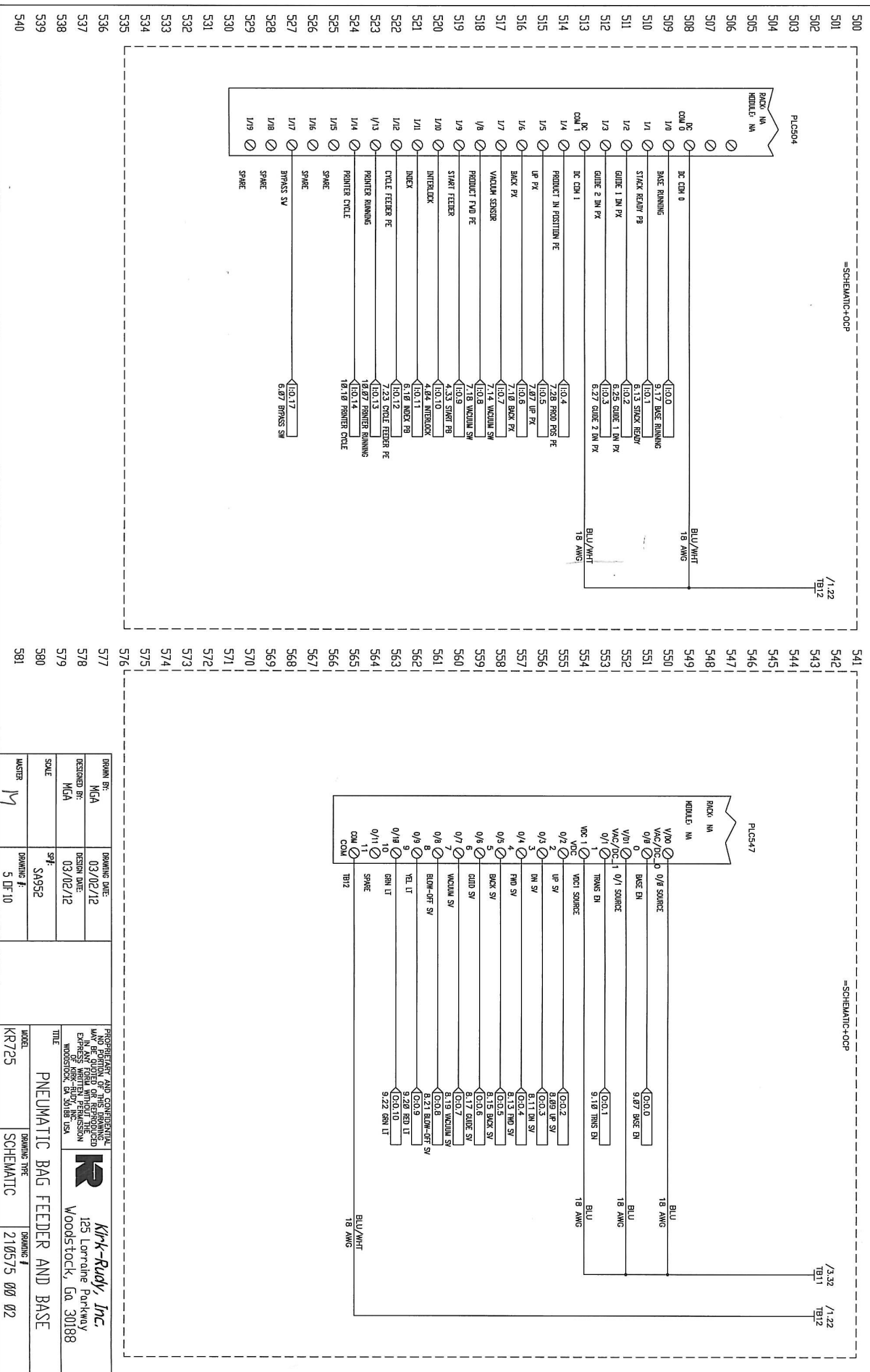
**Kirk-Ridley, Inc.**  
125 Lorraine Parkway  
Woodstock, Ga 30088

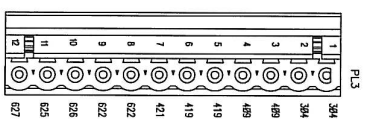
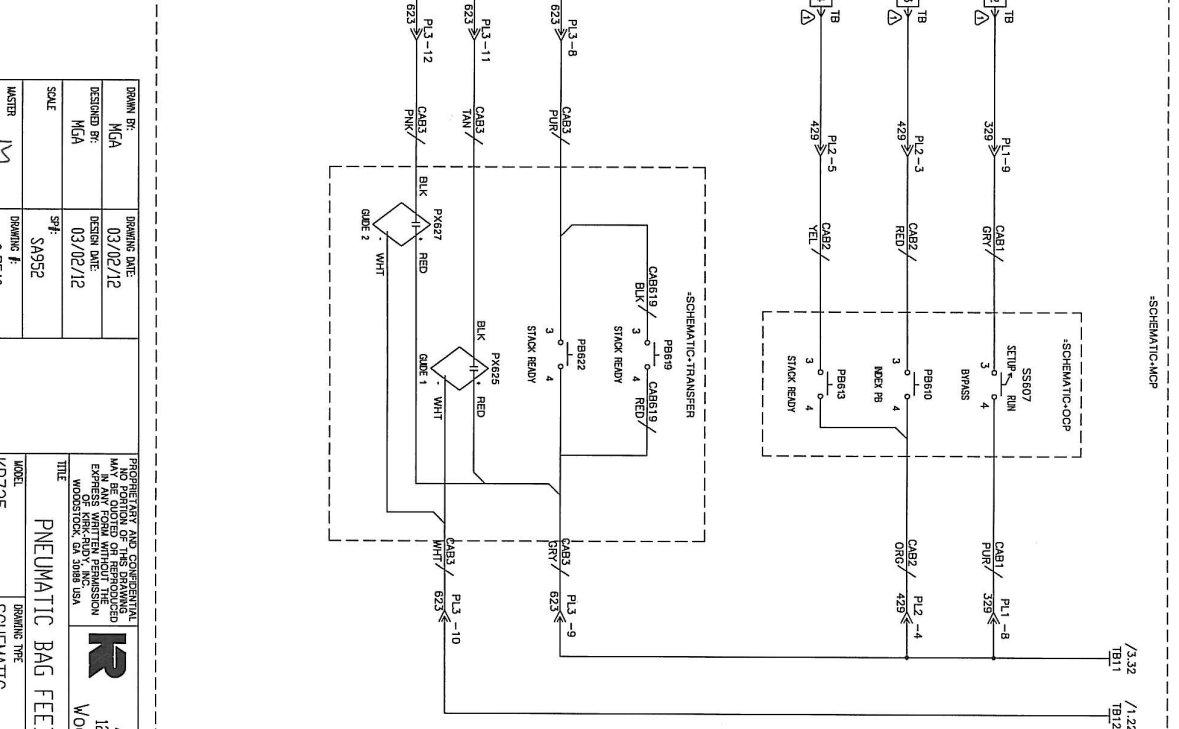
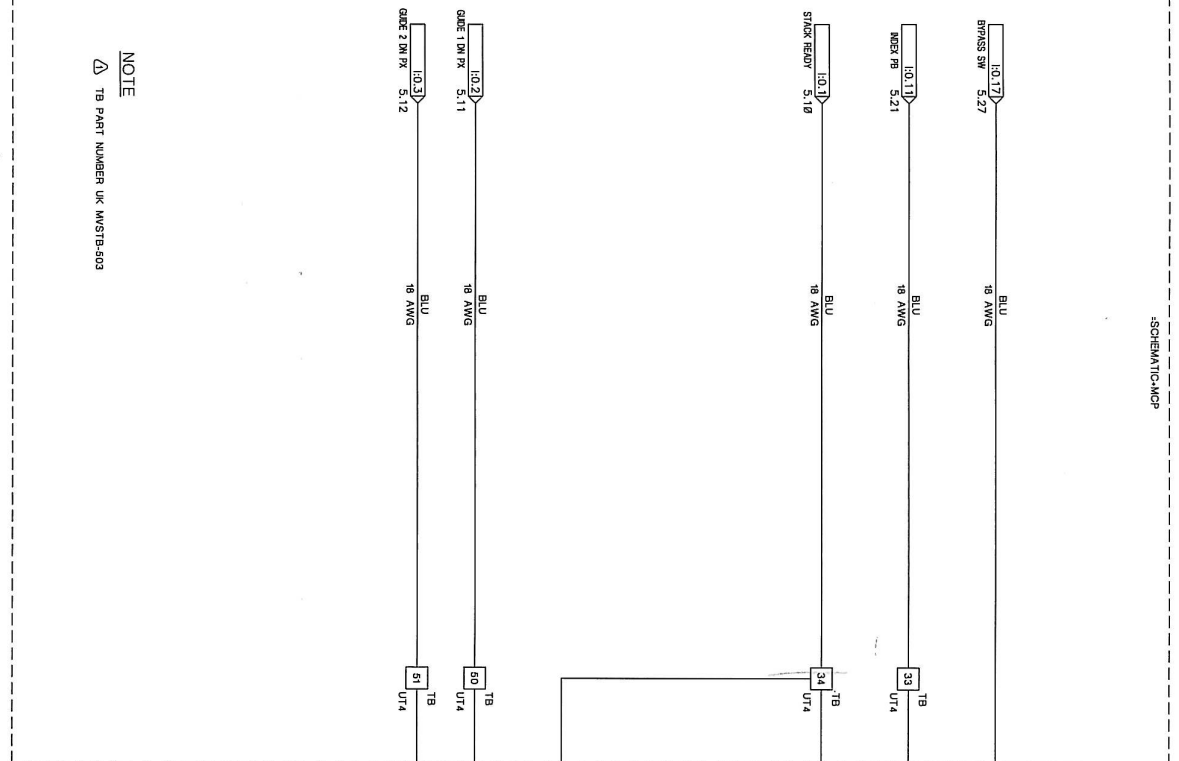
**PNEUMATIC BAG FEEDER AND BASE**



**NOTE**  
TB PART NUMBER UK MVSTB-503

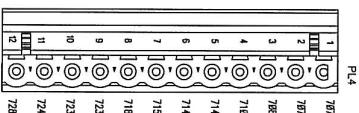
DRUM IN:	DRUM DATE:	<b>KIRK-RADY, Inc.</b> 125 Lorraine Parkway Woodstock, Ga. 30188
MCA	03/02/12	
DESIGNED BY:	DESIGN DATE:	
MCA	03/02/12	
SCALE	SP	
	SA952	
MASTER	DRUMING #	
M	4 OF 10	
PROPERTY AND CONFIDENTIAL ANY RE-QUOTING OR REPRODUCTION WITHOUT WRITTEN PERMISSION EXPRESSLY FORBIDDEN © KIRK-RADY, INC. WOODSTOCK, GA. 30188 USA		
TITLE		
PNEUMATIC BAG FEEDER AND BASE		
MODEL	DRUMING TYPE	DRUMING #
KR725	SCHEMATIC	210575 000 02






**NOTE**  
⚠ TB PART NUMBER UK MVSTB-503

DESIGNED BY:	MCA	DESIGN DATE:	03/02/12								
SCALE:	3/4"	BRIDGE #:	6 OF 10								
MASTER:	M										
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<b>TITLE</b> PNEUMATIC BAG FEEDER AND BASE		<b>PROPERTY AND COPYRIGHT</b> MAY BE LOANED OR REPRODUCED WITHOUT FEE BUT NOT FOR THE EXPANSION OF KIRK-RUDY, INC. WOODSTOCK, GA 30088 USA									
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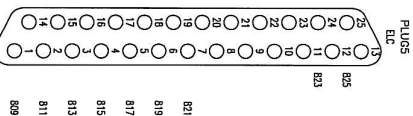
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DESIGNED BY:	MCA	DESIGN DATE:	03/02/12
SCALE:	5/8"	DRIVING #	SA952
MASTER:	M	DRIVING #	7 OF 10

PNEUMATIC AND CONCENTRIC HUBS ARE TO BE DRIVEN AND BE COATED WITH THE DRIVING FLUID. THE DRIVING FLUID IS IN A NEW FISH WITHOUT THE EXPANSION OF AIR-FLUID, INC. WOODSTOCK, GA 30088	 <b>Kry-Rudy, Inc.</b> 125 Lorraine Parkway Woodstock, Ga 30088
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PNEUMATIC BAG FEEDER AND BASE	
JUDICI KR725	DRIVING TYPE SCHEMATIC
DRIVING # 216575 00 02	



BRAND REF:	MCA	DATE DATE:	03/02/12
DESIGNED BY:	MCA	DESIGN DATE:	03/02/12
SCALE:	5/8"		
MASTER:	M	DRAWING #	8 OF 10

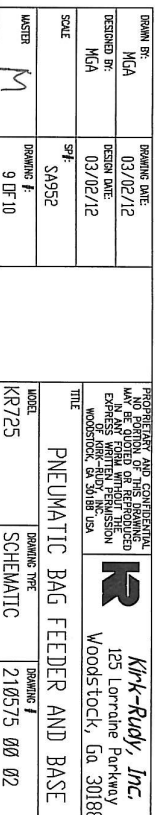
  

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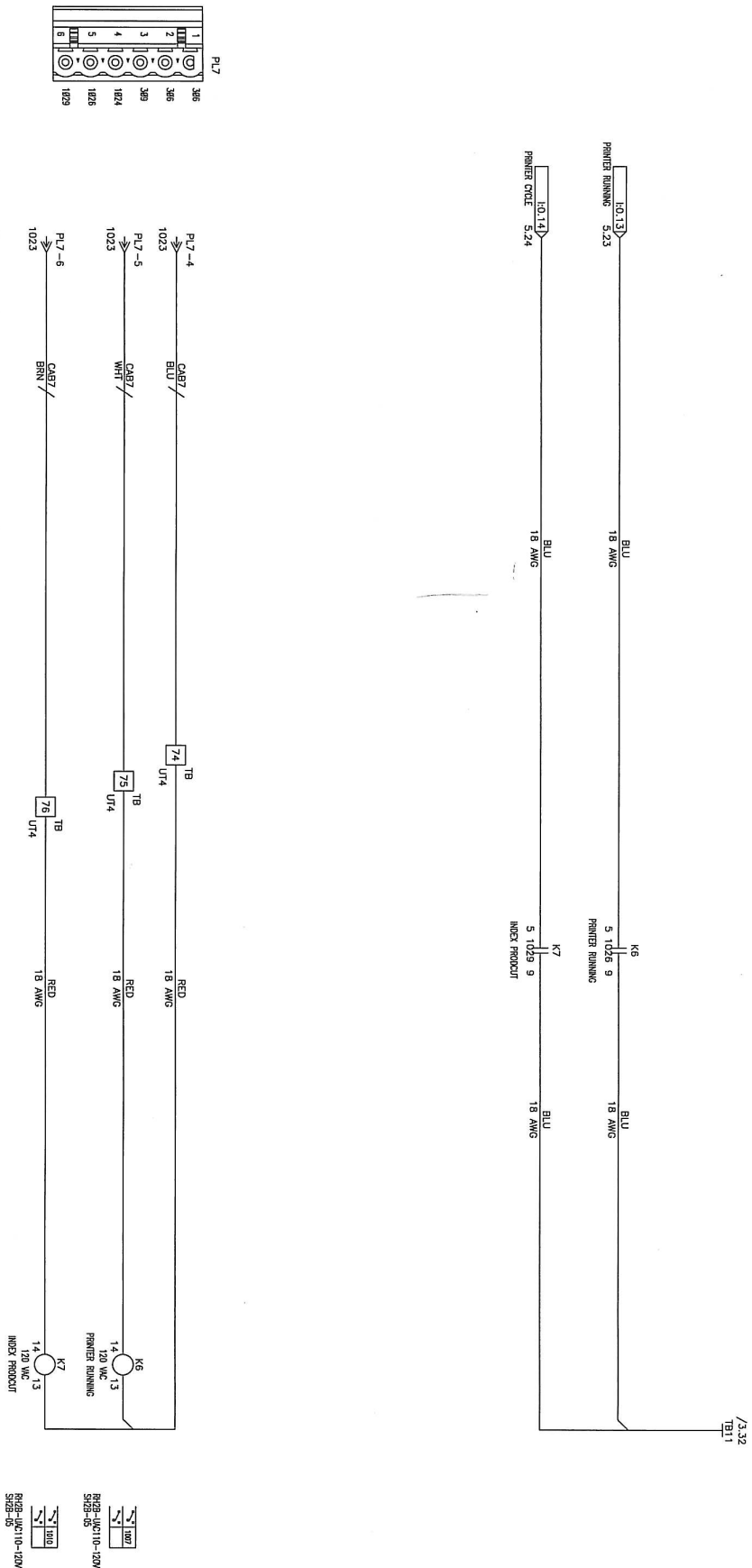
  

PNEUMATIC BAG FEEDER AND BASE		
MODEL KR725	DRAWING TYPE SCHEMATIC	DRAWING # 210575 00 02





=SCHEMATIC+MCP



DESIGNED BY: MGA	DESIGN DATE: 03/02/12	<div>FOR REFERENCE AND CONFORMANCE MAY BE QUOTED OR REPRODUCED EXCEPT BY WRITTEN PERMISSION WOODSTOCK, GA 30188 USA</div> <div> <b>Kirk-Rudy, Inc.</b> 125 Lorraine Parkway Woodstock, Ga 30188</div>	
SCALE M	SCALE S.A952		
MASTER	DRAWING # 10 DF 10		
		MODEL KR725	DRAWING # 210575 00 02