

# Horizontal Resaw HR500

## Parts List

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<b>HR500E11S</b>	<b>rev. B4.00</b>
<b>(HR1-6E11S)</b>	<b>rev. B4.00</b>
<b>HR500E15S</b>	<b>rev. B4.00</b>
<b>(HR1-6E15S)</b>	<b>rev.B4.00</b>

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**Safety is our #1 concern!** Read and understand all safety information and instructions before operating, setting up or maintaining this machine.

*Form #1030*

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## SECTION 1 REPLACEMENT PARTS

### 1.1 How To Use The Parts List

- Go to the appropriate section and locate the part in the illustration.
- Use the number pointing to the part to locate the correct part number and description in the table.
- Parts shown indented under another part are included with that part.
- Parts marked with a diamond (◆) are only available in the assembly listed above the part.

See the sample table below. Sample Part #A01111 includes part F02222-2 and subassembly A03333. Subassembly A03333 includes part S04444-4 and subassembly K05555. The diamond (◆) indicates that S04444-4 is not available except in subassembly A03333. Subassembly K05555 includes parts M06666 and F07777-77. The diamond (◆) indicates M06666 is not available except in subassembly K05555.

1.1 Sample Assembly				
REF.	DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)	PART #	QTY	
	<b>SAMPLE ASSEMBLY, COMPLETE (INCLUDES ALL INDENTED PARTS BELOW)</b>	<b>A01111</b>	1	
1	Sample Part	<b>F02222-22</b>	1	
2	Sample Subassembly (Includes All Indented Parts Below)	<b>A03333</b>	1	
	Sample Part (◆ Indicates Part Is Only Available With A03333)	<b>S04444-4</b>	1	◆
3	Sample Subassembly (Includes All Indented Parts Below)	<b>K05555</b>	1	
	Sample Part (◆ Indicates Part Is Only Available With K05555)	<b>M06666</b>	2	◆
4	Sample Part	<b>F07777-77</b>	1	

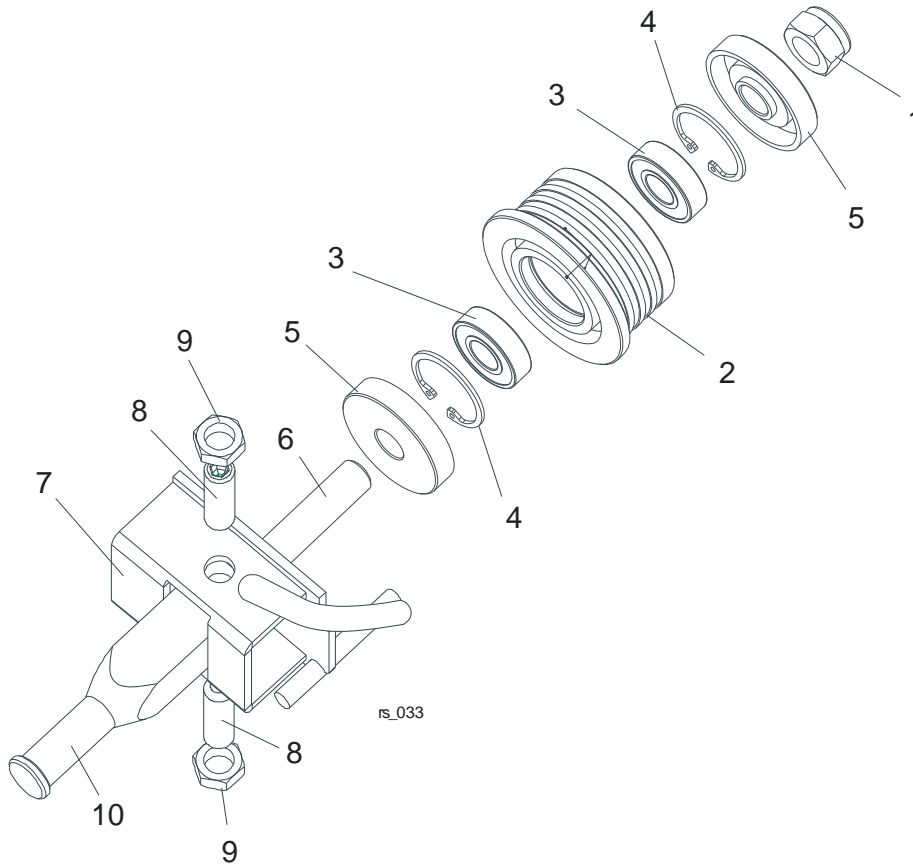
#### To Order Parts:

From Europe call your local distributor or our European Headquarters and Manufacturing Facility in Kolo, Nagórna 114 St, Poland at **+48-63-2626000** or **+48-3912-1319**. From the continental U.S., call at **1-800-448-7881**. Have your customer number, vehicle identification number, and part numbers ready when you call. From other international locations, contact the Wood-Mizer distributor in your area for parts.



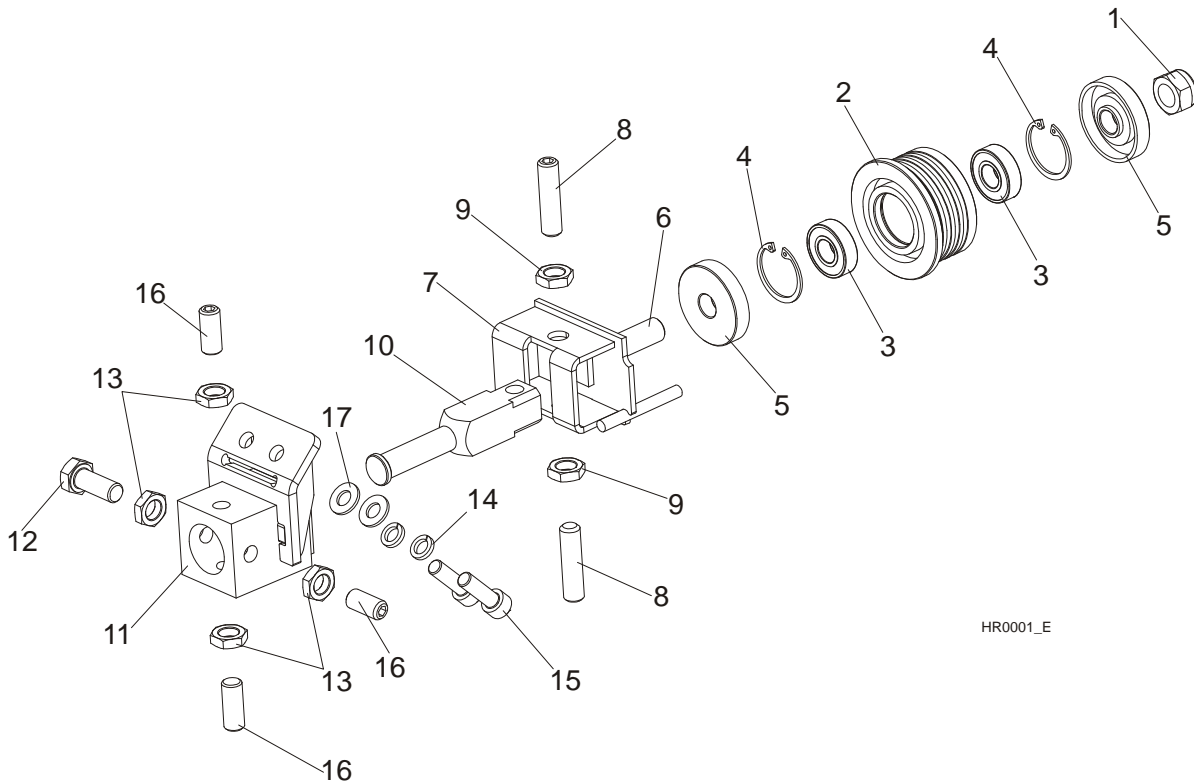
**CAUTION!** It is strongly recommended that only original spare parts be used.

**1.2 Blade Guide Assembly, Idle Side**



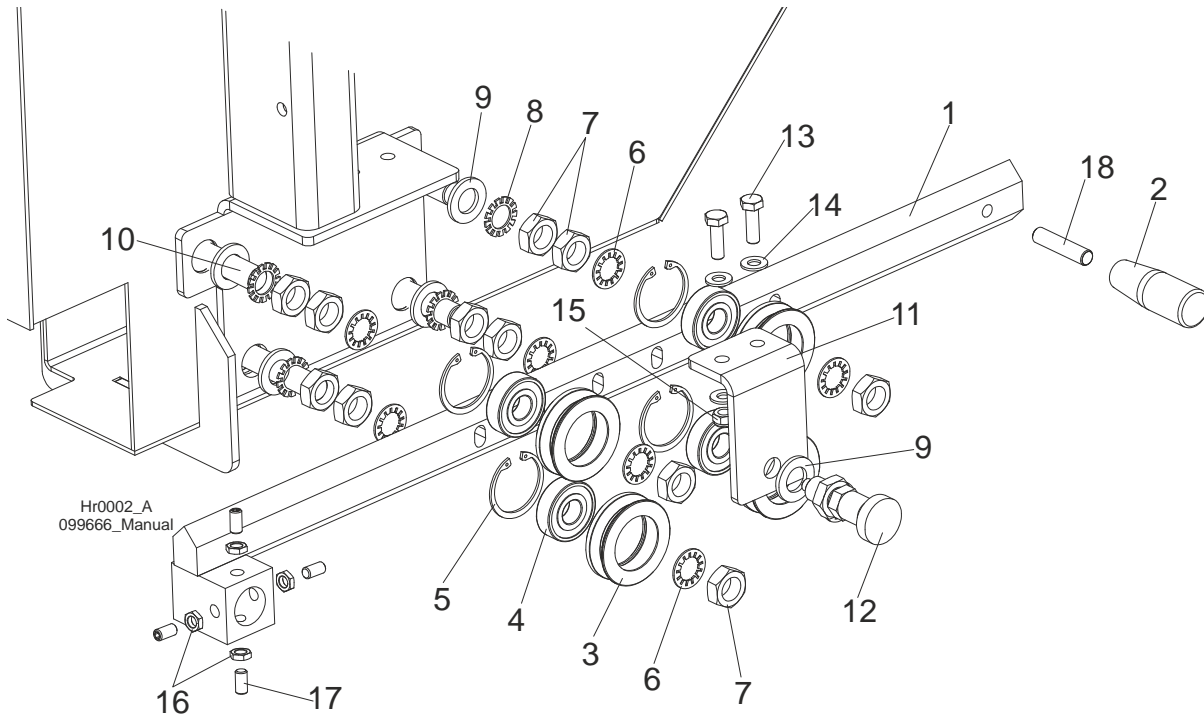
REF.	DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)	PART #	QTY	
	<b>BLADE GUIDE ASSEMBLY, HR IDLE SIDE</b>	<b>500500</b>	1	
	ROLLER, HR BLADE GUIDE NARROW W/BEARINGS	500499	1	
1	NUT, M12-8 HEX NYLON ZINC LOCK	F81034-2	1	
2	ROLLER, BLADE GUIDE NARROW	500098	1	◆
3	BEARING, 6001 2RSR NACHI	087893	2	
4	RING, W28 INSIDE RETAINING	F81090-9	2	
5	WASHER, ZINC-PLATED SPACER	087891-1	2	
6	SHAFT, BLADE GUIDE ROLLER ZINC-PLATED	087763-1	1	
7	BRACKET WELDMENT, IS BLADE GUIDE ZINC-PLATED	500497-1	1	
8	SCREW, M10X1X40 DIN913 STAINLESS STEEL SET	F81015-2	2	
9	NUT, M10X1-04-ST-A2 ISO 8675 THIN	F81033-10	2	
10	SHAFT, BLADE GUIDE MOUNT ZINC-PLATED	088255-1	1	

**1.3 Blade Guide Assembly, Drive Side**



REF.	DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)	PART #	QTY	
	<b>BLADE GUIDE ASSEMBLY, HR DRIVE SIDE</b>	<b>500501</b>	<b>1</b>	
	ROLLER, HR BLADE GUIDE NARROW W/BEARINGS	500499	1	
1	NUT, M12-8 HEX NYLON ZINC LOCK	F81034-2	1	
2	ROLLER, BLADE GUIDE NARROW	500098	1	◆
3	BEARING, 6001 2RSR NACHI	087893	2	
4	RING, W28 INSIDE RETAINING	F81090-9	2	
5	WASHER, ZINC-PLATED SPACER	087891-1	2	
6	SHAFT, BLADE GUIDE ROLLER ZINC-PLATED	087763-1	1	
7	BRACKET WELDMENT, DS BLADE GUIDE ZINC-PLATED	500498-1	1	
8	SCREW, M10X1X40 DIN913 STAINLESS STEEL SET	F81015-2	2	
9	NUT, M10X1-04-ST-A2 ISO 8675 THIN	F81033-10	2	
10	SHAFT, BLADE GUIDE MOUNT ZINC-PLATED	088255-1	1	
	<b>BLOCK, BLADE GUIDE MOUNT - COMPLETE</b>	<b>507316</b>	<b>1</b>	
11	BLOCK WELDMENT, BLADE GUIDE MOUNT	514887-1	1	
12	BOLT, M10X1X25 DIN 933 STAINLESS STEEL	F81003-28	1	
13	NUT, M10X1-04-ST-A2E ISO8675 THIN	F81033-10	4	
14	WASHER, 8.2 SPLIT LOCK ZINC	F81054-4	2	
15	SCREW, M8x25-8.8 HEX SOCKET HEAD CAP ZINC	F81002-21	2	
16	SCREW, M10X1X20 DIN 913 STAINLESS STEEL SET	F81015-1	3	
17	WASHER, 8.4 FLAT,ZINC	F81054-1	2	

1.4 Blade Guide Arm Assembly



Hr0002\_A  
099666\_Manual

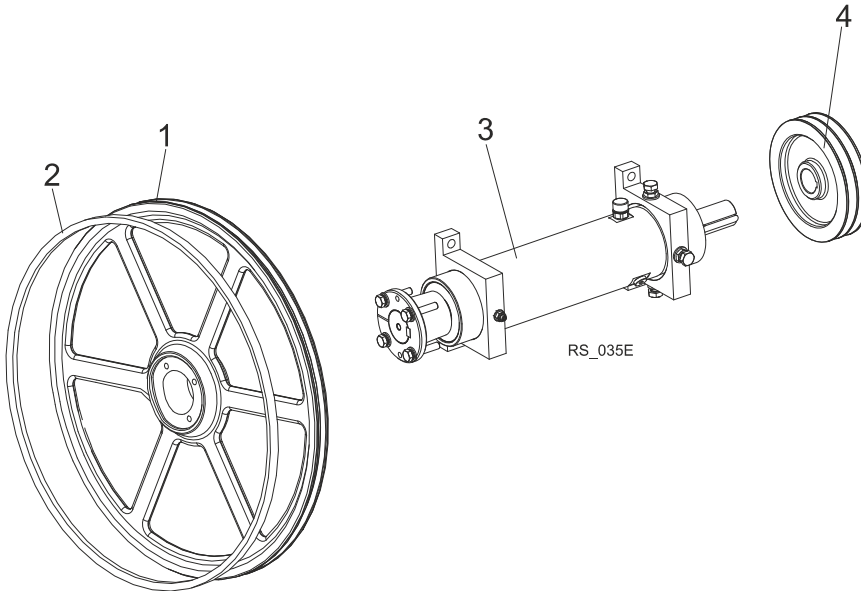
REF.	DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)	PART #	QTY
1	ARM, ADJUSTABLE ZINC-PLATED BLADE GUIDE	099075-1	1
2	HANDLE, M10 THREAD	089445	1
	ROLLER ASSEMBLY, V-GROOVE W/BEARING	093855	4
3	ROLLER, V-GROOVE ZINC-PLATED	093856-1	1
4	BEARING, 6203 2RSP6-5/8 CX	095087	1
5	RING, W40 INSIDE RETAINING	F81090-3	1
6	WASHER, 5/8" INTERNAL STAR	F05011-25	8
7	NUT, 5/8"-18 HEX ZINC	F05010-11	12
8	WASHER, 5/8" EXTERNAL STAR	F05011-26	4
9	WASHER, 17 FLAT ZINC	F81058-1	5
10	BOLT WELDMENT, ECCENTRIC	086508-1	4
11	BRACKET, DETENT PIN MOUNT	099077-1	1
12	PIN, 45308DNW DETENT	089939	1
13	BOLT, M8X25-8.8-B HEX HEAD FULL THREAD ZINC	F81002-5	2
14	WASHER, 8.4 FLAT ZINC	F81054-1	4
15	NUT, M8-8-B HEX NYLON ZINC LOCK	F81032-2	2
16	NUT, M10X1-04-ST-A2 ISO 8675 THIN	F81033-10	4
17	SCREW, M10X1X20 DIN913 STAINLESS STEEL SET	F81015-1	4
18	BOLT M10X35-8.8	F81003-9	1

# 1

## REPLACEMENT PARTS

### Blade Wheel Assembly, Drive Side

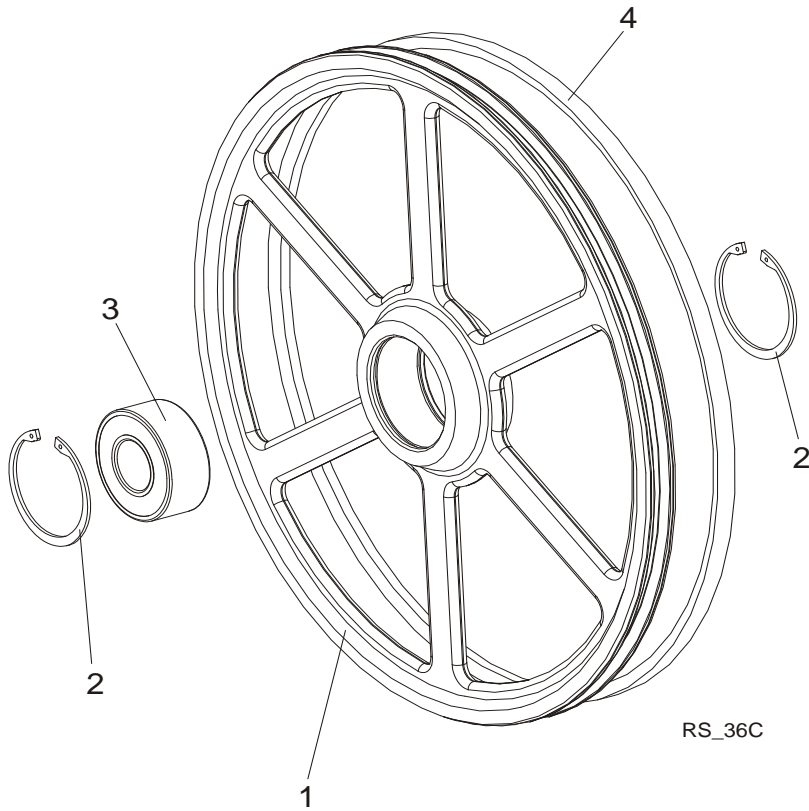
#### 1.5 Blade Wheel Assembly, Drive Side



REF.	DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)	PART #	QTY	
1	WHEEL, DRIVE SIDE BLADE	500100-1	1	
2	BELT, B72.5 BLADE WHEEL	017922-1	1	
3	SHAFT, HR500/HR700 RESAW PL DRIVE <a href="#">See Section 1.7</a>	525300	1	
4	PULLEY, SPB FI224X2/FI38 (F02312+T31124)	500177	1	
	PULLEY, SPB FI190X2/FI38 (F02347+T31124)	500569	1	

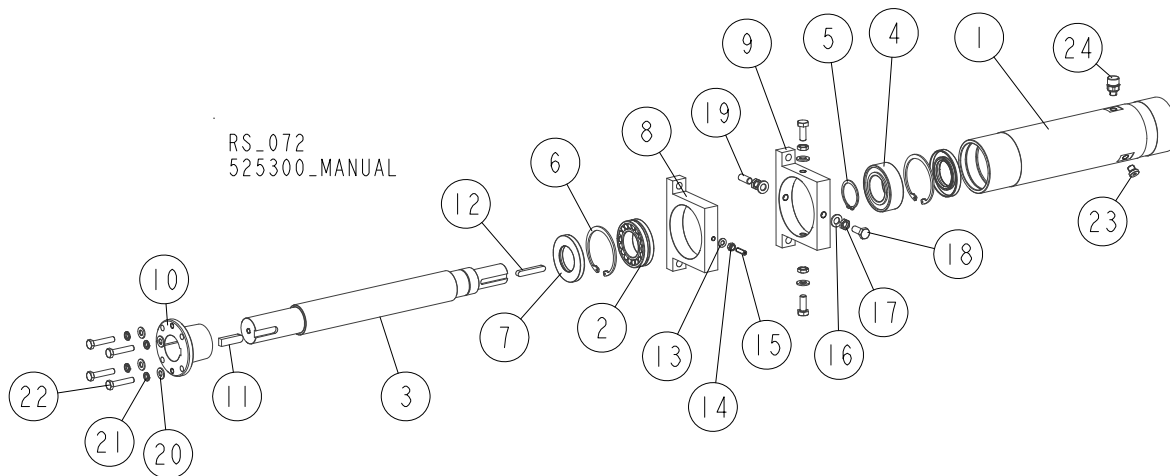


**1.6 Blade Wheel Assembly, Idle Side**



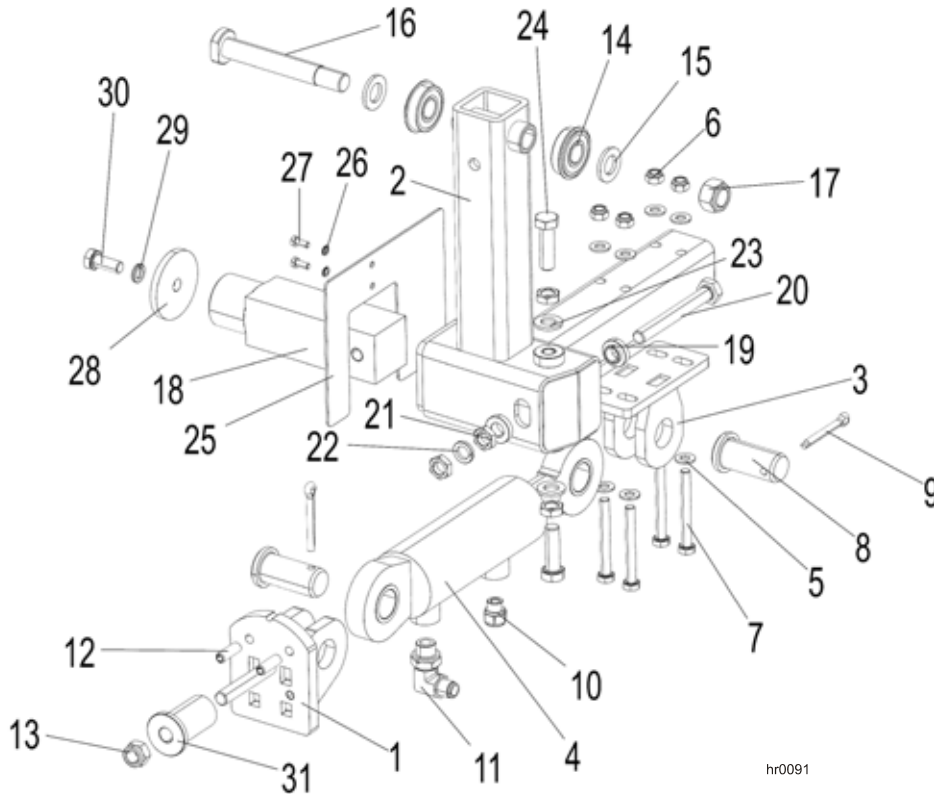
REF.	DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)	PART #	QTY
	<b>WHEEL, IDLE-SIDE BLADE - COMPLETE</b>	<b>088764</b>	<b>1</b>
1	Wheel, Idle-Side Blade	090810	1
2	Ring, W100 Inside Retaining	F81090-10	2
3	Bearing, 3309B.2RSR.TVH FAG	086428	1
4	<b>V-BELT, B72.5</b>	017922-1	1

## 1.7 Drive Shaft, HR500/HR700



REF.	DESCRIPTION (◆ Indicates Parts Available in Assemblies Only)	PART #	QTY
-	<b>SHAFT, HR500/HR700 RESAW PL DRIVE</b>	<b>525300</b>	<b>1</b>
1	BUSHING, DRIVE SHAFT ZINC-PLATED	525301-1	1
2	BEARING, 22210 E1 50X90X23 SPHERICAL ROLLER	520509	1
3	SHAFT, HR500/HR700 RESAW PL DRIVE	525302	1
4	BEARING, 3210A (SKF, FAG) ANGULAR CONTACT BALL	525280	1
5	RING, Z50 OUTSIDE RETAINING	F81090-28	1
6	RING, W90 INSIDE RETAINING	F81090-29	2
7	RING, AO50X90X10 SEALING	525279	2
8	BRACKET, DRIVE SHAFT ADJUSTMENT ZINC-PLATED	093255-1	1
9	BRACKET, DRIVE SHAFT BUSHING MOUNT ZINC-PLATED	094535-1	1
10	BUSHING, N50X109X70 SPLIT TAPER	521125	1
11	KEY, AB 14X9X50 PARALLEL	093266	1
12	KEY, A10X8X63 PARALLEL	088130	1
13	WASHER, 8.4 FLAT ZINC	F81054-1	1
14	NUT, M8-8-B HEX NYLON ZINC LOCK	F81032-2	1
15	SCREW, M8X25 DIN 913 A2-70 STAINLESS STEEL SET	F81014-3	1
16	WASHER, 13 FLAT ZINC	F81056-1	4
17	NUT, M12X1.25 DIN 439 A2-70 STAINLESS STEEL THIN	F81034-9	4
18	BOLT, M12X1.25X30 DIN933 A2-70 STAINLESS STEEL	F81004-44	3
19	SCREW, M12X1.25X30 DIN913 A2-70 SET	F81016-1	1
20	WASHER, 10.5 FLAT ZINC	F81055-1	4
21	WASHER, Z 10.2 SPLIT LOCK ZINC	F81055-2	4
22	BOLT, M10X50-8.8 HEX HEAD FULL THREAD ZINC	F81003-4	4
23	PLUG, GN 749-G1/4-A (ELESA+GANTER) THREADED	525282	1
24	PLUG, GN 882-G1/4-MS-M (ELESA+GANTER) BREATHER	525281	1

**1.8 Hydraulic Blade Tensioner Assembly**



hr0091

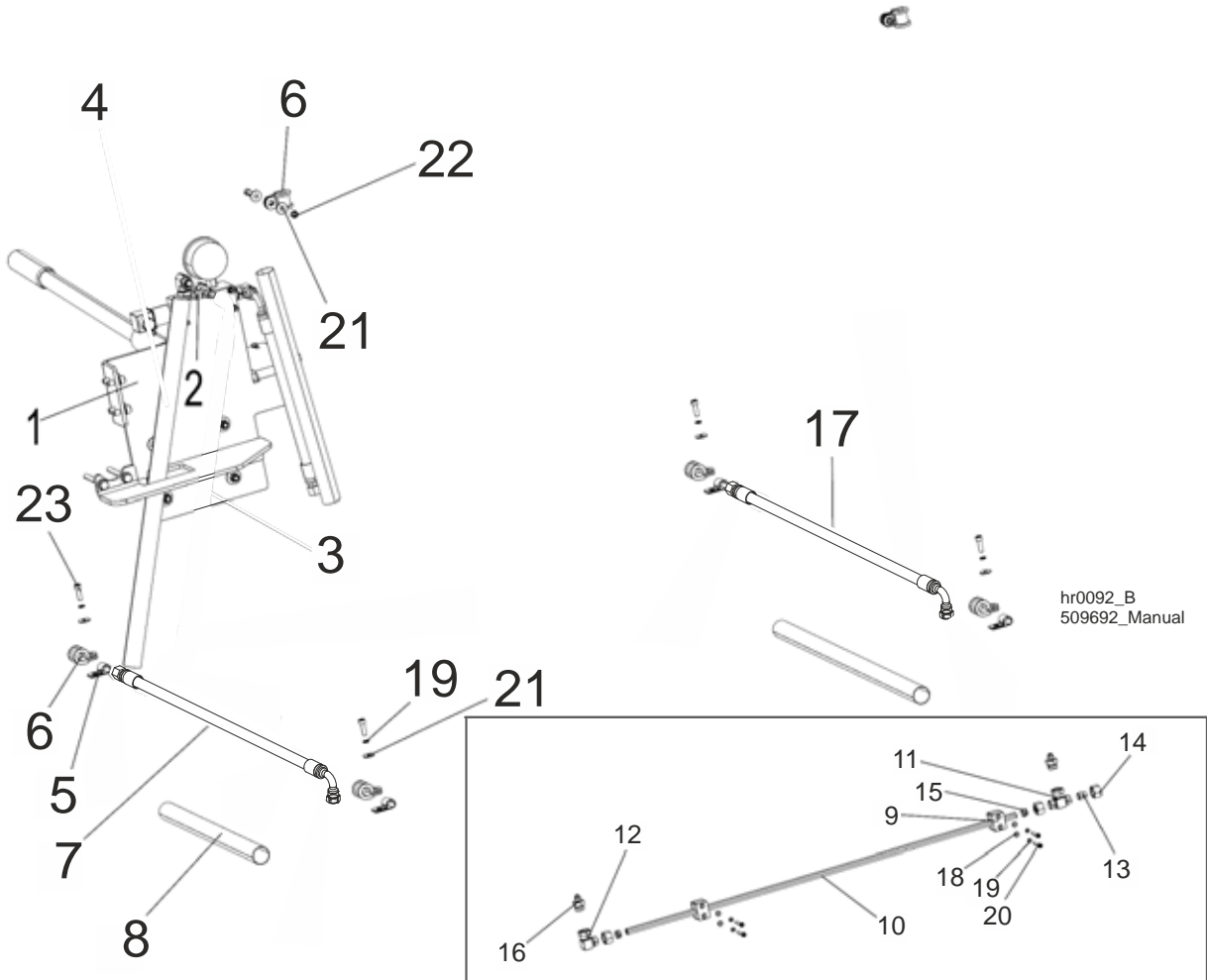
REF.	DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)	PART#	QTY
	<b>HR/SHS HYDRAULIC BLADE TENSIONER - COMPLETE</b>	<b>506750</b>	<b>1</b>
1	BRACKET, PISTON CYLINDER MOUNT	506751-1	1
2	ARM WELDMENT, TVS IDLE BLADE WHEEL (RIGHT-SIDE SAW HEAD)	504817-1	1
3	BRACKET, PISTON CYLINDER UPPER MOUNT	504819-1	1
4	CYLINDER, SJ2F-16-50/28/70 PISTON	504812	1
5	WASHER, 8.4 FLAT ZINC	F81054-1	8
6	NUT, M8 8 HEX NYLON ZINC LOCK	F81032-2	4
7	BOLT, M8x70-8.8 HEX HEAD ZINC	F81002-71	4
8	PIN	504824-1	2
9	PIN, S-Zn-6.3x45 COTTER	F81045-2	2
10	SILENCER, TYPE 2901-14-17	090794	1
11	FITTING, 90° - 3/8 BSP - 9/16 JIC ELBOW	096335	1
12	PIN, 8x26 ROLL ZINC	F81046-4	2
13	NUT, M12 8 HEX NYLON ZINC LOCK	F81034-2	1
14	BEARING, 6203-2RS NR. W/SNAP RING	086395	2
15	WASHER, 17 SPLIT LOCK ZINC	F81058-1	2
16	BOLT, ARM BEARING MOUNT	086404	1
17	NUT, M16-8 HEX NYLON ZINC LOCK	F81036-2	1
18	SHAFT, IDLE-SIDE BLADE WHEEL	088474	1

**1****REPLACEMENT PARTS***Hydraulic Blade Tensioner Assembly*

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19	WASHER, FLANGED ZINC-PLATED	086769-1	2	
20	BOLT, M12x1.25x100-8.8 HEX HEAD FULL THREAD ZINC	F81004-41	1	
21	NUT, M12X1.25-8 THIN ZINC	F81034-5	4	
22	WASHER, Z12.2 SPLIT LOCK ZINC	F81056-2	1	
23	WASHER, 13 FLAT ZINC	F81056-1	2	
24	BOLT, M12x1.25x40-8.8 HEX HEAD FULL THREAD ZINC	F81004-42	2	
25	GUARD, IDLE BLADE WHEEL ARM	088442-1	1	
26	WASHER, 5.1 SPLIT LOCK ZINC	F81052-2	2	
27	BOLT, M5X12 5.8 HEX HEAD FULL THREAD ZINC	F81000-5	2	
28	WASHER, IDLE BLADE WHEEL RETAINING	088957-1	1	
29	WASHER, Z 10.2 SPLIT LOCK ZINC	F81055-2	1	
30	BOLT, M10X25 8.8 HEX HEAD FULL THREAD	F81003-31	1	
31	BUSHING, 28.5 TO 13 REDUCER ZINC-PLATED	508708-1	1	

**1.9 Hydraulic Blade Tensioner**



REF.	DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)	PART #	QTY
	<b>HYDRAULIC BLADE TENSIONER FOR HR500-1 - COMPLETE</b>	<b>509691</b>	<b>1</b>
	HYDRAULIC PUMP ASSEMBLY, SHS/HR500/HR700	506733	1
	HOSE, PHD 2T3/8x0.43 90W9/16UNF-90W9/16UNF HYDRAULIC	506737	1
	GUARD, OBLIQUE HOSE	508714	1
	<b>HYDRAULIC BLADE TENSIONER FOR HR500-2 - COMPLETE</b>	<b>509692</b>	<b>1</b>
1	HYDRAULIC PUMP ASSEMBLY, SHS/HR500/HR700	506733 <sup>1</sup>	1
2	FEETING, BBA UNF 9/16" TEE W/NUT	509687	1
3	HOSE, PHD 2T3/8x0.43 90W9/16UNF-90W9/16UNF HYDRAULIC	506737	1
4	GUARD, OBLIQUE HOSE	508714	2
5	CLAMP, 1/2" EMT COATED	P07584	4
6	CLAMP, RSGU 1.15/20 METAL & RUBBER	509701	6
7	HOSE, PHD 2T3/8x2.85 90W9/16UNF-W9/16UNF HYDRAULIC	509718	1
8	GUARD, VERTICAL HOSE	508713	1
9	BLOCK, DN15 APP-L-15 PIPE BRACKET	509720	2

# 1

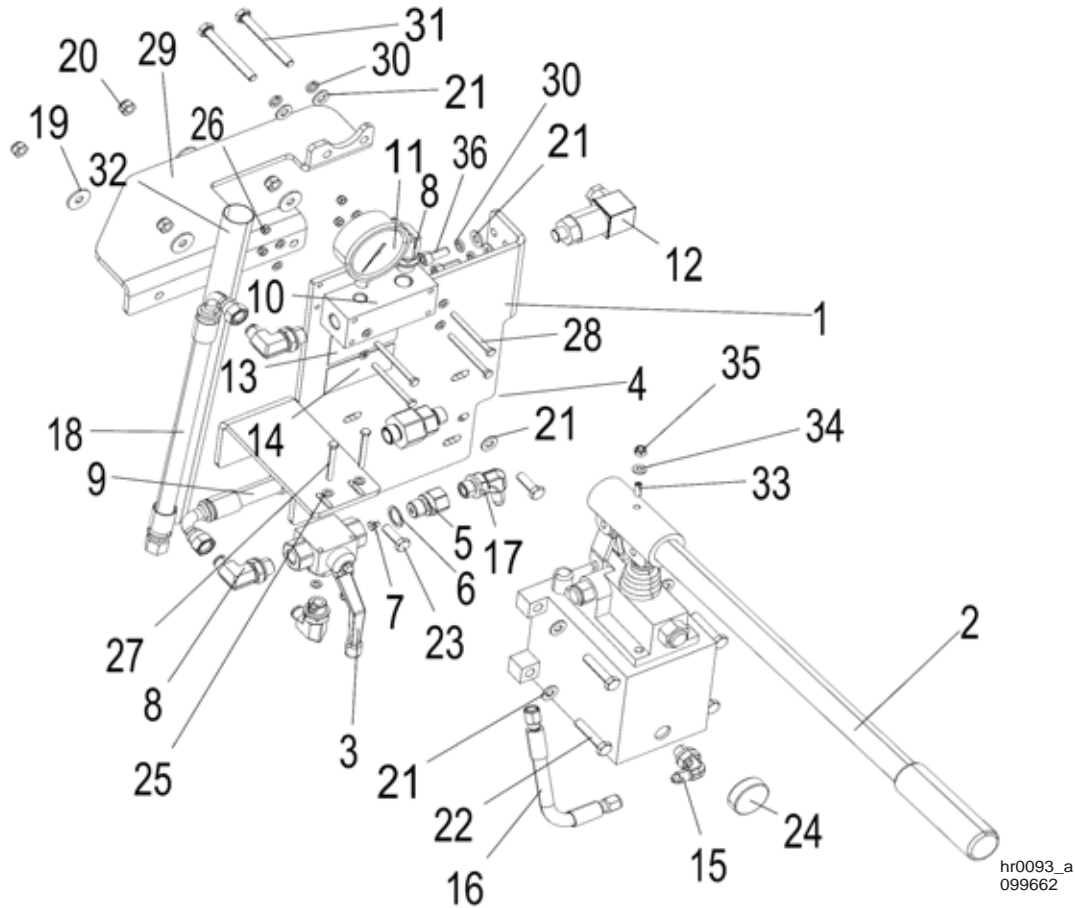
## REPLACEMENT PARTS

### Hydraulic Blade Tensioner

10	PIPE, L=1050.	509699	1	
11	FITTING, XEVT 15 L 22x1.5 TEE W/NUT	509688	1	
12	FITTING, XEVW 15 L 22x1.5 ELBOW W/NUT	509689	1	
13	CAP, DKL 22x1.5 15 L.	509698	1	
14	NUT, M 15 L M22x1.5	509690	3	
15	SLEEVE, DPR 15 L. PIPE CLINCH	509697	2	
16	FITTING, 9/16"-18 UNF - M22x1.5 ZINC-PLATED REDUCER	510446-1	2	
17	HOSE, PHD 2T3/8x2.85 90W9/16UNF-W9/16UNF HYDRAULIC	509719	1	
18	WASHER, 6.4 FLAT ZINC	F81053-1	4	
19	WASHER, Z 6.1 SPLIT LOCK ZINC	F81053-3	8	
20	SCREW, M6x35 8.8 HEX SOCKET HEAD CAP ZINC	F81001-23	4	
21	WASHER, 6.5 SPECIAL FLAT ZINC	F81053-11	8	
22	NUT, M6-8-B HEX NYLON ZINC LOCK	F81031-2	2	
23	SCREW, M6x20 8.8 HEX SOCKET HEAD CAP ZINC	F81001-22	6	
	<b>HYDRAULIC BLADE TENSIONER FOR HR500-3 - COMPLETE</b>	<b>509693</b>	<b>1</b>	
	HYDRAULIC BLADE TENSIONER FOR HR500-1 - COMPLETE	509691	1	
	HYDRAULIC BLADE TENSIONER FOR HR500-2 - COMPLETE	509692	1	
	<b>HYDRAULIC BLADE TENSIONER FOR HR500-4 - COMPLETE</b>	<b>509694</b>	<b>1</b>	
	HYDRAULIC BLADE TENSIONER FOR HR500-2 - COMPLETE	509692	2	
	<b>HYDRAULIC BLADE TENSIONER FOR HR500-5 - COMPLETE</b>	<b>509695</b>	<b>1</b>	
	HYDRAULIC BLADE TENSIONER FOR HR500-1 - COMPLETE	509691	1	
	HYDRAULIC BLADE TENSIONER FOR HR500-2 - COMPLETE	509692	2	
	<b>HYDRAULIC BLADE TENSIONER FOR HR500-6 - COMPLETE</b>	<b>509696</b>	<b>1</b>	
	HYDRAULIC BLADE TENSIONER FOR HR500-2 - COMPLETE	509692	3	

<sup>1</sup> [See Section 1.10](#)

**1.10 Hydraulic Pump Assembly**



REF.	DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)	PART #	QTY
	<b>HYDRAULIC PUMP ASSEMBLY, SHS/HR500/HR700</b>	<b>506733</b>	<b>1</b>
1	PLATE, MOUNTING	506734-1	1
2	PUMP, PMS12/TNK1 W/ONE-LITER TANK	092789	1
3	VALVE, GE5L G3/8" 3-WAY BALL	504803	1
4	VALVE, RHV12LREDA3C (HVR NW10MLED) CHECK	094559	1
	FITTING, G 3/8 W/NOZZLE	096849	1
5	FITTING, G3/8 ZINC-PLATED SPECIAL	096850-1	1
6	WASHER, 16 COPPER	F81058-3	1
7	NOZZLE, D092-O 1MM DIA. PROPANE&BUTANE	091007	1
8	FITTING, 90\$ - 3/8 BSP - 9/16 JIC ELBOW	096335	4
9	HYDRAULIC HOSE, 3/8' W/DKJ 90 DN10 9/16 UNF/DKOL DN10 M18x1.5 END FITTINGS	504831	1
10	BLOCK, MOUNTING	504829-1	1
11	GAUGE, 200 BAR (3000PSI) PRESSURE	505176	1
12	SWITCH, F4Z1/M3-20 BAR PRESSURE	504830	1
13	DECAL, PRESSURE VALUE SETTING	505348	1

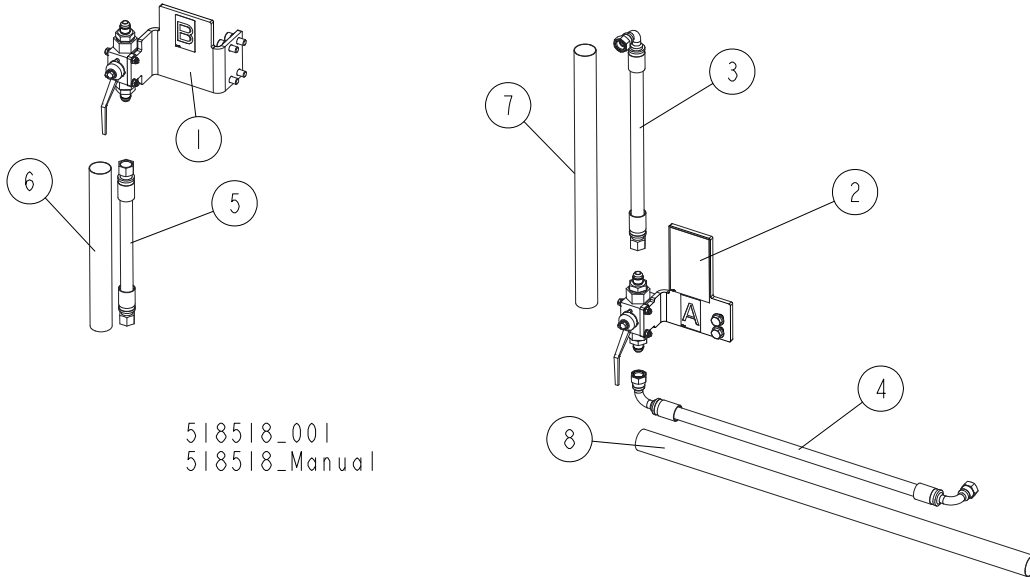
## 1

**REPLACEMENT PARTS***Hydraulic Pump Assembly*

14	DECAL, TVS BLADE TENSIONER HANDLE POSITION	505346	1	
15	FITTING, CA-204410-3 (W90HROKO4HJ) G1/4-JIC37.7/16-20 ELBOW	094562	1	
16	HOSE, 1/4 (0.19m) HYDRAULIC	505174	1	
17	FITTING, CA-204411-3 (W90HROKO6HJ04) G3/8-JIC37.7/16-20 ELBOW	094563	1	
18	HOSE, PHD 2T3/8x0.27 90W9/16UNF-W9/16UNF HYDRAULIC	506736	1	
19	WASHER, ISO 7093-1-8-200 HV-A2E	F81054-11	4	
20	NUT, M8 8 HEX NYLON ZINC LOCK	F81032-2	6	
21	WASHER, 8.4 FLAT ZINC	F81054-1	14	
22	BOLT, M8X40-8.8 HEX HEAD FULL THREAD ZINC	F81002-15	4	
23	BOLT, M8x25-8.8-B HEX HEAD FULL THREAD ZINC	F81002-5	2	
24	MAGNET, MW 38x12/N38 NEODYMIUM	500022	1	
25	WASHER, 5.3 FLAT ZINC	F81052-1	12	
26	NUT, M5-8-FE/ZN5 DIN985	F81030-2	6	
27	BOLT, M5x45 DIN933-A2-70 STAINLESS STEEL	F81000-22	2	
28	BOLT, M5X60 8.8 HEX HEAD ZINC	F81000-36	4	
29	BRACKET, SUPPORT	506732-1	1	
30	WASHER, 8.2 SPLIT LOCK ZINC	F81054-4	6	
31	BOLT, M8x75-8.8 HEX HEAD ZINC	F81002-91	2	
32	GUARD, VERTICAL HOSE	508713	1	
33	LATCH, GN 615.3-M6-KN BALL THREADED	096874	1	
34	WASHER, 6.4 FLAT ZINC	F81053-1	1	
35	NUT, M6-8-B HEX NYLON ZINC LOCK	F81031-2	1	
36	SCREW, M8x20-8.8 HEX SOCKET HEAD CAP ZINC	F81002-30	4	



### 1.11 Single Blade Tension Assembly



518518\_001  
518518\_Manual

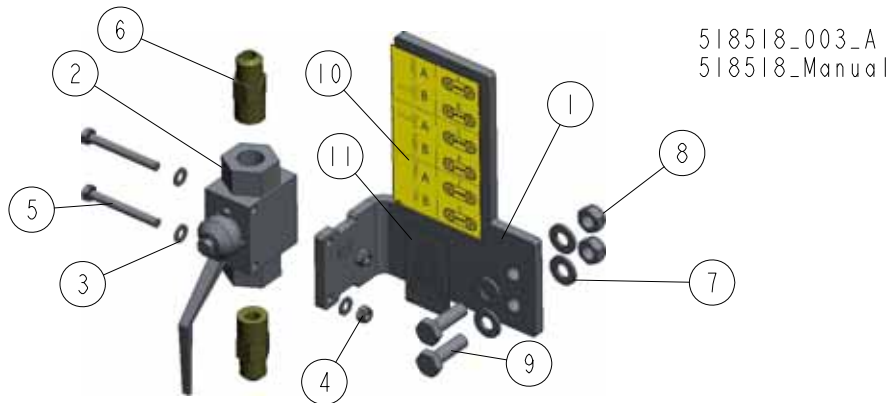
REF	DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)	PART #	QTY
	<b>SINGLE BLADE TENSION ASSEMBLY (HR500/700, USA)</b>	<b>518518</b>	<b>1</b>
1	VALVE, OIL FLOW CONTROL - COMPLETE (FOR SECOND SAW HEAD) <a href="#">See Section 1.13</a>	518515	1
2	VALVE, OIL FLOW CONTROL - COMPLETE (FOR FIRST SAW HEAD) <a href="#">See Section 1.12</a>	518516	1
3	HOSE, PHD 2T3/8X0.27 90W9/16UNF-W9/16UNF HYDRAULIC	506736	1
4	HOSE, PHD 2T3/8X0.43 90W9/16UNF-90W9/16UNF HYDRAULIC	506737	1
5	HOSE, PHD 2T3/8X0.45 W9/16UNF-W9/16UNF HYDRAULIC	518552	1
6	SLEEVE, VERTICAL HOSE PROTECTION	098489	1
7	SLEEVE, VERTICAL HOSE PROTECTION	508713	1
8	SLEEVE, OBLIQUE HOSE PROTECTION	508714	1

# 1

## REPLACEMENT PARTS

### Oil Flow Control Valve - for First Saw Head

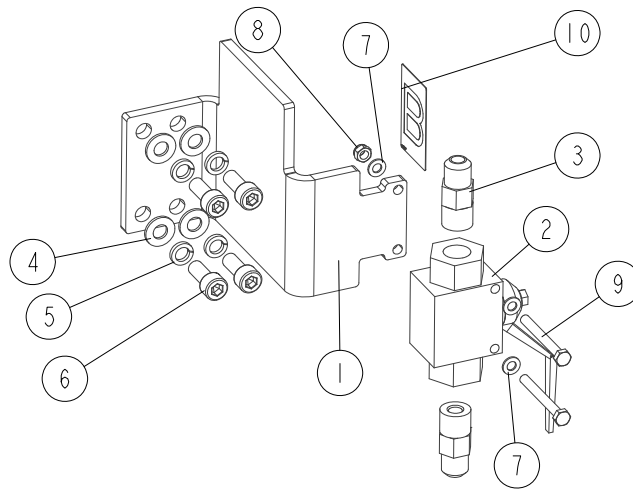
#### 1.12 Oil Flow Control Valve - for First Saw Head



REF.	DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)	PART #	QTY
	<b>VALVE, OIL FLOW CONTROL - COMPLETE (FOR FIRST SAW HEAD)</b>	<b>518516</b>	<b>1</b>
1	BRACKET, RSAP2V02FF 3/8G VALVE MOUNT	518517-1	1
2	VALVE, PN 500 RSAP2V02FF 3/8" G DN10 BALL	502056	1
3	WASHER, 5.3 FLAT ZINC	F81052-1	4
4	NUT, M5-8-FE/ZN5 DIN985	F81030-2	2
5	BOLT, M5x45 DIN933-A2-70 STAINLESS STEEL	F81000-22	2
6	FITTING, BSP-JIC 3/8"-9/16" STRAIGHT	091842	2
7	WASHER, 8.4 FLAT ZINC	F81054-1	4
8	NUT, M8 8 HEX NYLON ZINC LOCK	F81032-2	2
9	BOLT, M8x25-8.8-B HEX HEAD FULL THREAD ZINC	F81002-5	2
10	DECAL, SINGLE BLADE TENSION ASSEMBLY	518900 <sup>1</sup>	1
11	DECAL A, SINGLE BLADE TENSION ASSEMBLY	518901 <sup>1</sup>	1

<sup>1</sup> Decals belongs to 520500 decals kit.

**1.13 Oil Flow Control Valve - for Second Saw Head**



518518\_002\_A  
518518\_Manual

REF.	DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)	PART #	QTY
	<b>VALVE, OIL FLOW CONTROL - COMPLETE (FOR SECOND SAW HEAD)</b>	<b>518515</b>	<b>1</b>
1	BRACKET, RSAP2V02FF G3/8 VALVE MOUNT	518840-1	1
2	VALVE, PN 500 RSAP2V02FF 3/8" G DN10 BALL	502056	1
3	FITTING, BSP-JIC 3/8"-9/16" STRAIGHT	091842	2
4	WASHER, 8.4 FLAT ZINC	F81054-1	4
5	WASHER, 8.2 SPLIT LOCK ZINC	F81054-4	4
6	SCREW, M8x20-8.8 HEX SOCKET HEAD CAP ZINC	F81002-30	4
7	WASHER, 5.3 FLAT ZINC	F81052-1	4
8	NUT, M5-8-FE/ZN5 DIN985	F81030-2	2
9	BOLT, M5x45 DIN933-A2-70 STAINLESS STEEL	F81000-22	2
10	DECAL B, SINGLE BLADE TENSION ASSEMBLY	518902 <sup>1</sup>	1

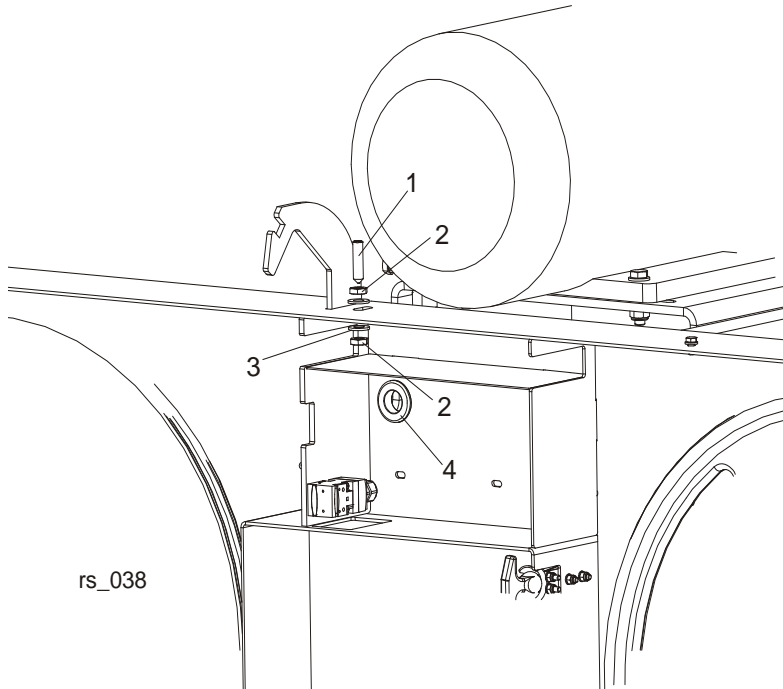
<sup>1</sup> Decal belongs to 520500 decals kit.

# 1

## REPLACEMENT PARTS

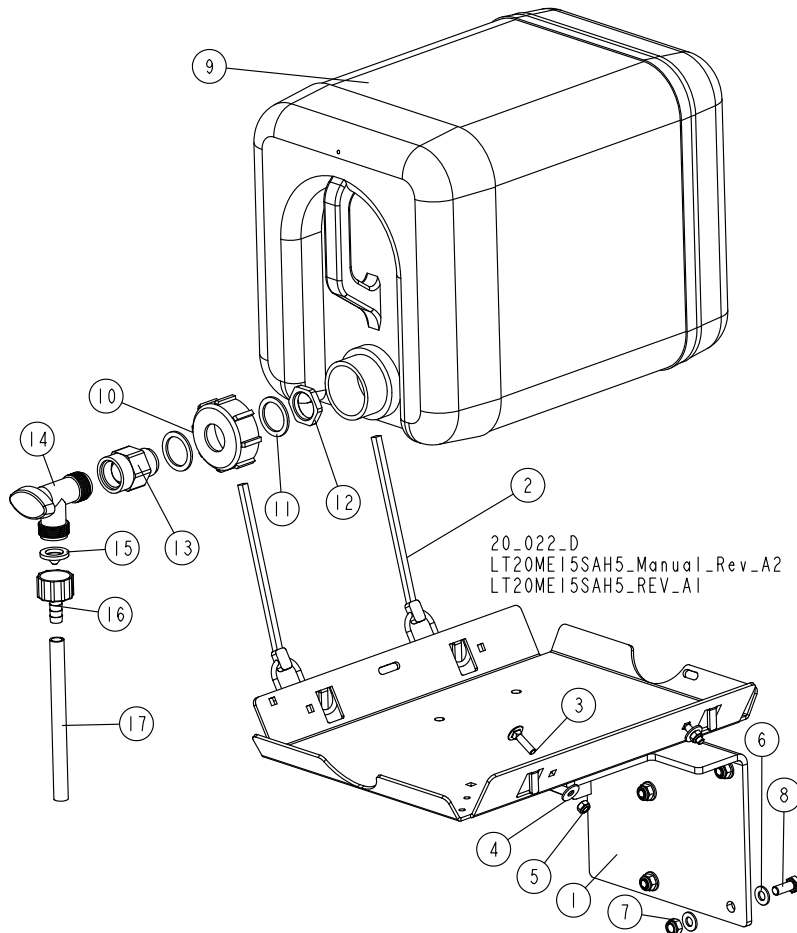
### Middle Throat Screw

#### 1.14 Middle Throat Screw



REF.	DESCRIPTION (◆ Indicates Parts Available in Assemblies Only)	PART #	QTY	
1	SCREW, M10X40-45H HEX SOCKET SET CONE POINT ZINC	F81003-61	1	
2	NUT, M10-8-B HEX ZINC	F81033-6	2	
3	WASHER, 10.5 FLAT ZINC	F81055-1	2	
4	GROMMET, 22 MM DIA. RUBBER	087400	1	

**1.15 Water Lube Assembly (Option)**



REF.	DESCRIPTION (◆ Indicates Parts Available in Assemblies Only)	PART #	QTY
	BOTTLE KIT, LT20 WATER LUBE	<b>091036</b>	<b>1</b>
1	TRAY WELDMENT, LT20 WATER LUBE	091033-1	1
2	STRAP, 20 RUBBER W/HOOK	P11668	2
3	BOLT, M6X25-8.8 CARRIAGE HEAD ZINC	F81001-20	2
4	WASHER, 6.5 SPECIAL FLAT ZINC	F81053-11	2
5	NUT, M6-8-B HEX NYLON ZINC LOCK	F81031-2	2
6	WASHER, 8.4 FLAT ZINC	F81054-1	8
7	NUT, M8-8-B HEX NYLON ZINC LOCK	F81032-2	4
8	BOLT, M8X20-8.8-B HEX HEAD FULL THREAD ZINC	F81002-4	4
	BOTTLE, WATER - COMPLETE	513864	1
	BOTTLE, WATER W/NUT	513865	1
9	BOTTLE, WATER	513866	1
10	NUT, WATER BOTTLE	513867	1
11	SEAL, 35X26X2 RUBBER	513869	2

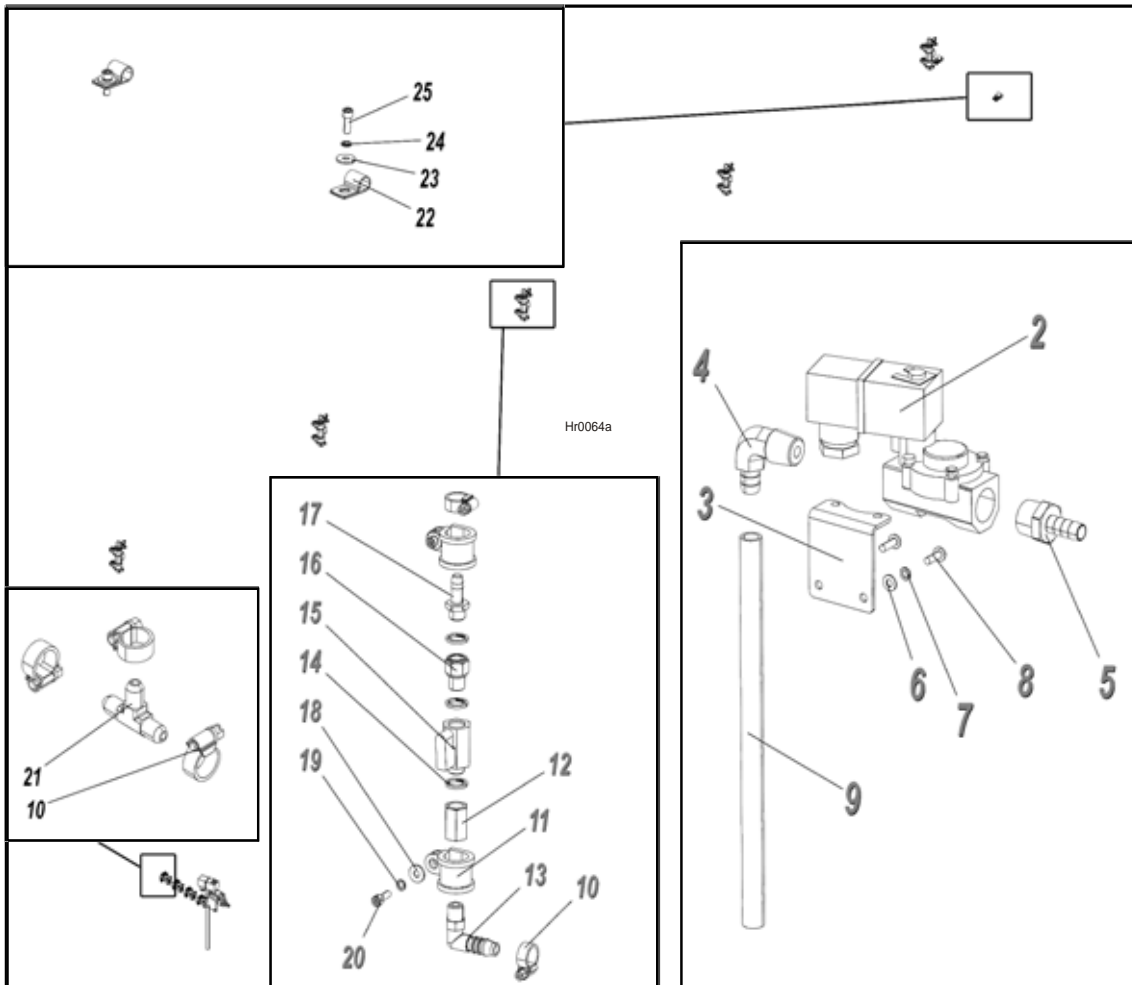
# 1

## REPLACEMENT PARTS

### Blade Lube System

REF.	DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)	PART #	QTY
12	NUT, 3/4 NPT GLAND	513868	1
13	FITTING, 3/4FPTX3/4MPT	014636	1
14	VALVE, 3/4 NPT ELBOW 3/4 MALE OUTLET PVC	014100	1
15	FILTER, WATER LUBE	016086	1
16	REDUCER, 5/8NPT/3/8BARB WATER LUBE	014113	1
17	TUBING, WATER LUBE	R01885	1

### 1.16 Blade Lube System



REF.	DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)	PART #	QTY
	KIT, HR500 BLADE LUBE SYSTEM - 1 HEAD	502688-1	1 / 0 / 0 / 0 / 0 / 0
	KIT, HR500 BLADE LUBE SYSTEM - 2 HEADS	502688-2	0 / 1 / 0 / 0 / 0 / 0
	KIT, HR500 BLADE LUBE SYSTEM - 3 HEADS	502688-3	0 / 0 / 1 / 0 / 0 / 0
	KIT, HR500 BLADE LUBE SYSTEM - 4 HEADS	502688-4	0 / 0 / 0 / 1 / 0 / 0
	KIT, HR500 BLADE LUBE SYSTEM - 5 HEADS	502688-5	0 / 0 / 0 / 0 / 1 / 0
	KIT, HR500 BLADE LUBE SYSTEM - 6 HEADS	502688-6	0 / 0 / 0 / 0 / 0 / 1
1	VALVE, BLADE LUBE SYSTEM SOLENOID - COMPLETE	509702	1 / 1 / 1 / 1 / 1 / 1

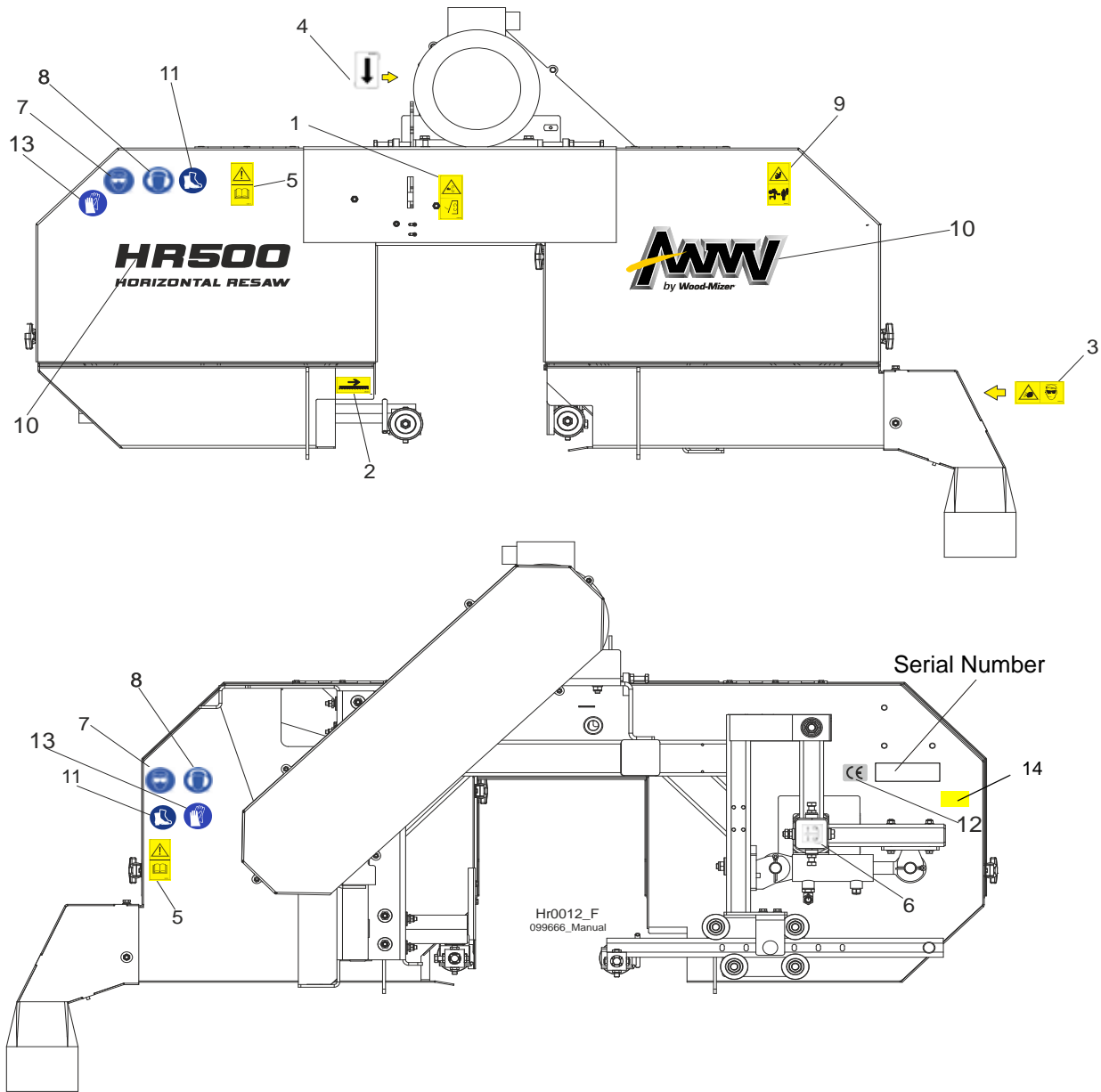
# REPLACEMENT PARTS

*Blade Lube System*

**1**

2	VALVE, ASCO SCE238A002 24V DC SOLENOID	510270	1	
3	BRACKET, SOLENOID VALVE ZINC-PLATED	092870-1	1	
4	FITTING, 1/2"NPT-3/8" BARB ELBOW	P12707	1	
5	FITTING, 1/2" HOSE	092356	1	
6	WASHER, 4.3 FLAT ZINC	F81051-2	2	
7	WASHER, Z 4.1 SPLIT LOCK ZINC	F81051-1	2	
8	SCREW, M4X12-5.8-B CROSS RECESSED PAN HEAD ZINC	F81011-43	2	
9	TUBING, 3/8" -1 HEAD	509704	1 / 0 / 0 / 0 / 0 / 0	
	TUBING, 3/8" - 2 HEADS	509705	0 / 1 / 0 / 0 / 0 / 0	
	TUBING, 3/8" - 3 HEADS	509706	0 / 0 / 1 / 0 / 0 / 0	
	TUBING, 3/8" - 4 HEADS	509707	0 / 0 / 0 / 1 / 0 / 0	
	TUBING, 3/8" - 5 HEADS	509708	0 / 0 / 0 / 0 / 1 / 0	
	TUBING, 3/8" - 6 HEADS	509709	0 / 0 / 0 / 0 / 0 / 1	
10	CLAMP, 12-20MM DIA. HOSE	F81080-3	3 / 8 / 13 / 18 / 23 / 28	
11	CLAMP, RSGU 1.20/20 W1 METAL & RUBBER	F81087-2	2 / 4 / 6 / 8 / 10 / 12	
12	SLEEVE, G1/4W/G1/4W 1823300001	090808	1 / 2 / 3 / 4 / 5 / 6	
13	FITTING, WES 10/R 1/4 ELBOW	088379	1 / 2 / 3 / 4 / 5 / 6	
14	SEAL, G1/4 866-014-000-0	090809	3 / 6 / 9 / 12 / 15 / 18	
15	VALVE, FP60.KIT 28 G1/4	088380	1 / 2 / 3 / 4 / 5 / 6	
16	ADAPTER, 2521 1/4-1/4 (CAMOZZI)	097704	1 / 2 / 3 / 4 / 5 / 6	
17	BUSHING, GT13/09 NR 13539	092783	1 / 2 / 3 / 4 / 5 / 6	
18	WASHER, 5.5 SPECIAL FLAT ZINC	F81052-3	2 / 4 / 6 / 8 / 10 / 12	
19	WASHER, 5.1 SPLIT LOCK	F81052-2	2 / 4 / 6 / 8 / 10 / 12	
20	SCREW, M5X16-8.8 HEX SOCKET HEAD CAP ZINC-PL.	F81000-25	2 / 4 / 6 / 8 / 10 / 12	
21	FITTING, 3/8 BARB TEE	015485	0 / 1 / 2 / 3 / 4 / 5	
22	CLAMP, 1/2" EMT COATED	P07584	2 / 0 / 2 / 0 / 2 / 0	
23	WASHER, 6.5 SPECIAL FLAT ZINC	F81053-11	2 / 0 / 2 / 0 / 2 / 0	
24	WASHER, Z 6.1 SPLIT LOCK	F81053-3	2 / 0 / 2 / 0 / 2 / 0	
25	SCREW, M6X16 8.8 HEX SOCKET HEAD CAP ZINC	F81001-21	2 / 0 / 2 / 0 / 2 / 0	

**1.17 HR Saw Head Warning Decals**



REF.	DESCRIPTION (◆ Indicates Parts Available in Assemblies Only)	PART #	QTY
	<b>DECAL KIT FOR HR1</b>	099821	1
1	DECAL, SAWMILL COVERS CAUTION	099220	1
2	DECAL, BLADE MOVEMENT DIRECTION (PICTOGRAM)	096321	1
3	DECAL, SAWDUST CHUTE WARNING (PICTOGRAM)	099222	1
4	DECAL, MOTOR ROTATION DIRECTION	S20097	1
5	DECAL, READ THE OPERATOR'S MANUAL (PICTOGRAM)	096317	2
6	DECAL, BLADE ALIGNMENT	P11789	1
7	DECAL, EYE PROTECTION WARNING (PICTOGRAM)	S12004G	2
8	DECAL, EAR PROTECTION WARNING (PICTOGRAM)	S12005G	2



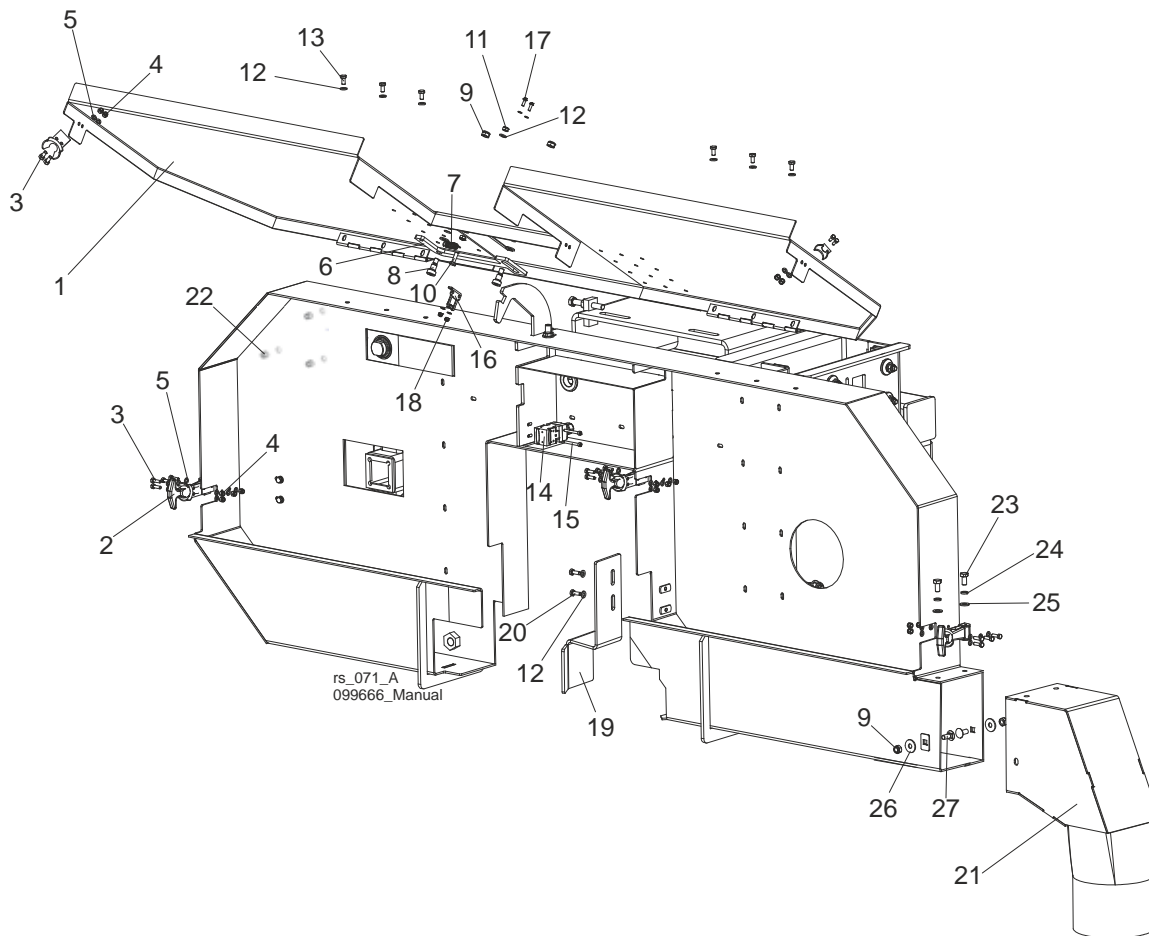
# REPLACEMENT PARTS

## *HR Saw Head Warning Decals*

1

9	DECAL, KEEP A SAFE DISTANCE AWAY (PICTOGRAM)	099221	1	
10	DECAL KIT, "HR" MACHINE NAME	099585	1	
11	DECAL, USE SAFETY BOOTS (PICTOGRAM)	501465	2	
12	DECAL, CE CERTIFIED SAWMILL (SMALL)	P85070	1	
13	DECAL, WEAR SAFETY GLOVES (PICTOGRAM)	512107	2	
	<b>DECAL KIT FOR HR2</b>	099822	1	
	DECAL KIT FOR HR1	099821	2	
	<b>DECAL KIT FOR HR3</b>	099823	1	
	DECAL KIT FOR HR1	099821	3	
	<b>DECAL KIT FOR HR4</b>	099824	1	
	DECAL KIT FOR HR1	099821	4	
	<b>DECAL KIT FOR HR5</b>	099825	1	
	DECAL KIT FOR HR1	099821	5	
	<b>DECAL KIT FOR HR6</b>	099826	1	
	DECAL KIT FOR HR1	099821	6	
14	<b>DECAL, BLADE TENSION INDICATOR ADJUSTMENT</b>	505348	1	

## 1.18 Blade Housing Cover



REF.	DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)	PART #	QTY
1	COVER WELDMENT, RESAW BLADE HOUSING	093251-1	1
2	LATCH, FLEXIBLE DRAW	014829	3
3	BOLT, M5X16-5.8 HEX HEAD FULL THREAD ZINC	F81000-51	12
4	NUT, M5-8-FE/ZN5 DIN 985	F81030-2	12
5	WASHER, 5.3 FLAT ZINC	F81052-1	24
6	PAWL, LOCKING	090643-1	1
7	SPRING, 1.6X12X38 EXTENSION	092208	1
8	BOLT, 10/M8X12-12.9 ISO-7379 SHOULDER	F81003-62	2
9	NUT, M8-8-B HEX NYLON ZINC LOCK	F81032-2	4
10	BOLT, M6X20-8.8 HEX HEAD FULL THREAD ZINC	F81001-2	1
11	NUT, M6-8-B HEX NYLON ZINC LOCK	F81031-2	2
12	WASHER, 6.4 FLAT ZINC	F81053-1	10
13	BOLT, M6X12-8.8 HEX HEAD FULL THREAD ZINC	F81001-7	6
14	SWITCH, AZ17-11ZRK SAFETY	094232	1
15	SCREW, M4X35 -8.8 HEX SOCKET HEAD CAP ZINC	F81011-34	2
16	KEY, AZ17/170-B5 SAFETY SWITCH	094422	1
17	SCREW, M4X12-5.8-B CROSS RECESSED PAN HEAD ZINC	F81011-43	2

# REPLACEMENT PARTS

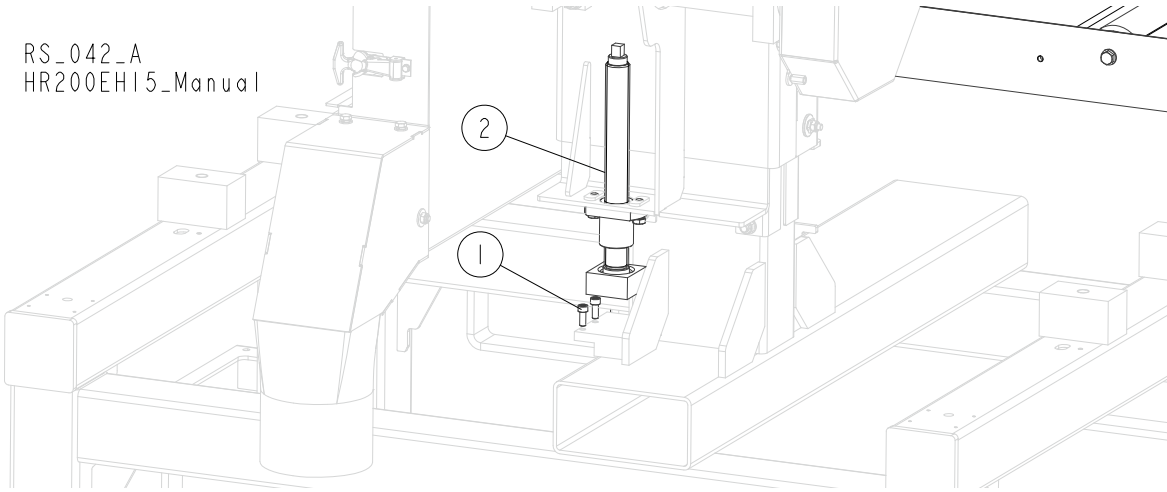
## *Blade Housing Cover*

1

18	NUT, M4-B HEX NYLON ZINC LOCK	F81029-1	2	
19	GUARD, BLADE GUIDE ROLLER	516925-1	1	
20	BOLT, M6X16 8.8 HEX HEAD FULL THREAD ZINC	F81001-15	2	
21	CHUTE, RESAW SAWDUST	094059-1	1	
22	PLUG, SR1086-9.5	096846	3	
23	BOLT, M8X16-8.8-B HEX HEAD FULL THREAD ZINC	F81002-20	2	
24	WASHER, 8.2 SPLIT LOCK ZINC	F81054-4	2	
25	WASHER, 8.4 FLAT,ZINC	F81054-1	2	
26	WASHER, 8.5 FLAT ZINC	F81054-11	2	
27	BOLT, M8 X 20 CARRIAGE HEAD ZINC	F81002-11	2	

**1.19 Manual Up/Down System Screws**

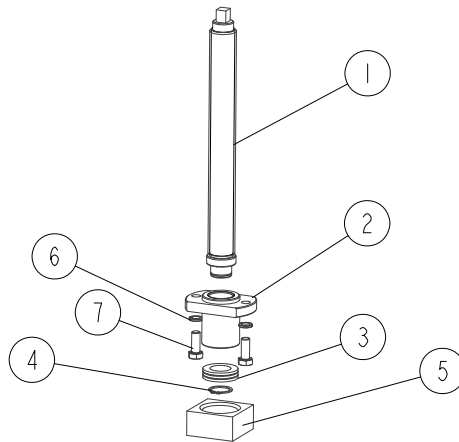
RS\_042\_A  
HR200EH15\_Manual



REF.	DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)	PART #	QTY
1	SCREW, M8X20-8.8 HEX SOCKET HEAD CAP ZINC	F81002-30	2
2	UP/DOWN SYSTEM, HR500-1/SHR MANUAL COMPLETE <a href="#">See Section 1.20</a>	517306	1

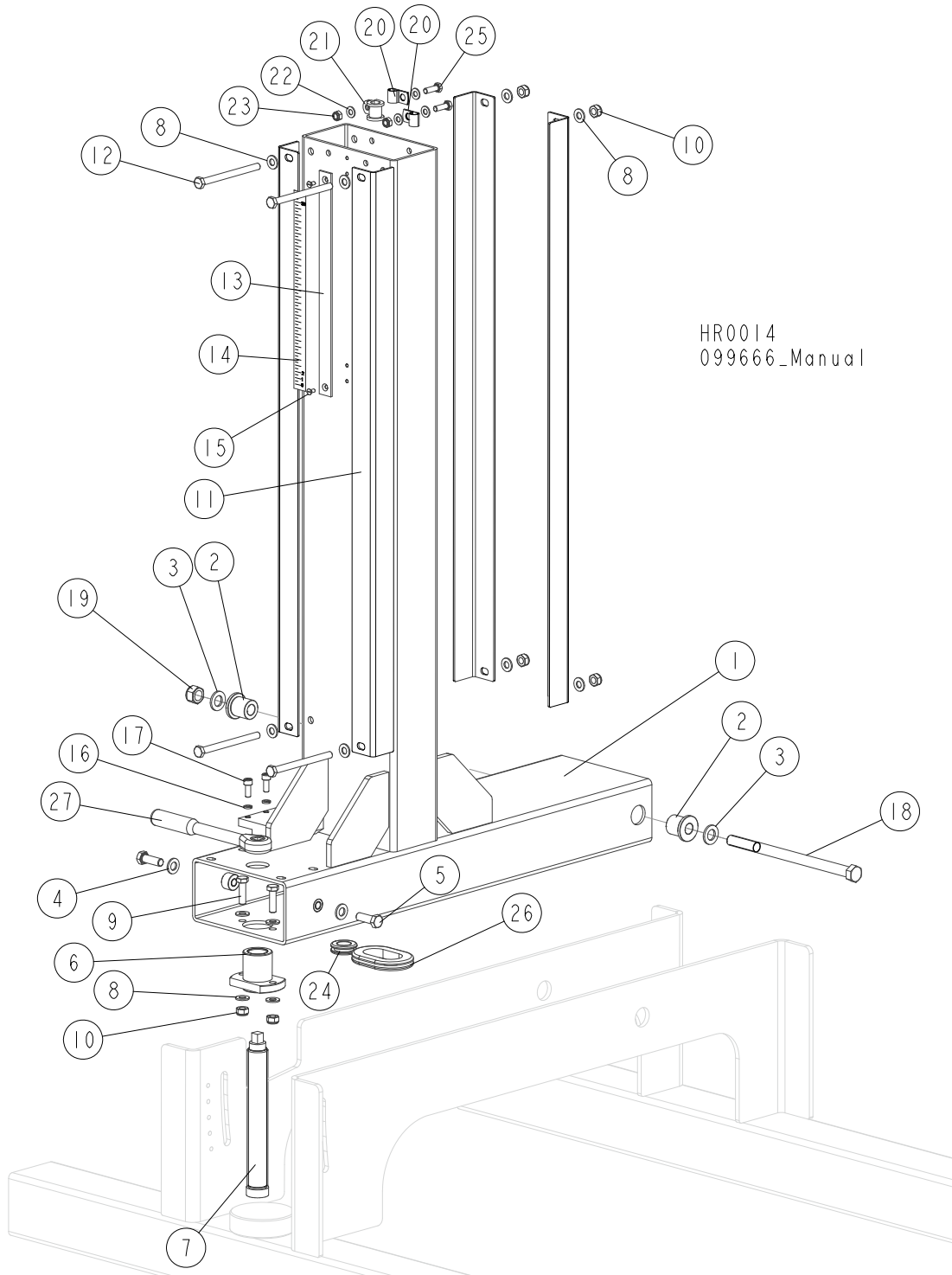
**1.20 Manual Up/Down System**

517306\_001  
HR200EH15\_Manual



REF.	DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)	PART #	QTY
	<b>UP/DOWN SYSTEM, HR500-1/SHR MANUAL COMPLETE</b>	<b>517306</b>	<b>1</b>
1	SCREW, ACME UP/DOWN ZINC-PLATED	093263-1	1
2	NUT, ACME SCREW FLANGED ZINC-PLATED	093264-1	1
3	BEARING, 51105 THRUST	088033	1
4	RING, 25Z OUTSIDE RETAINING	F81090-22	1
5	BLOCK, ACME SCREW REST ZINC-PLATED	093265-1	1
6	WASHER, Z 10.2 SPLIT LOCK ZINC	F81055-2	2
7	BOLT, M10X25 8.8 HEX HEAD FULL THREAD	F81003-31	2

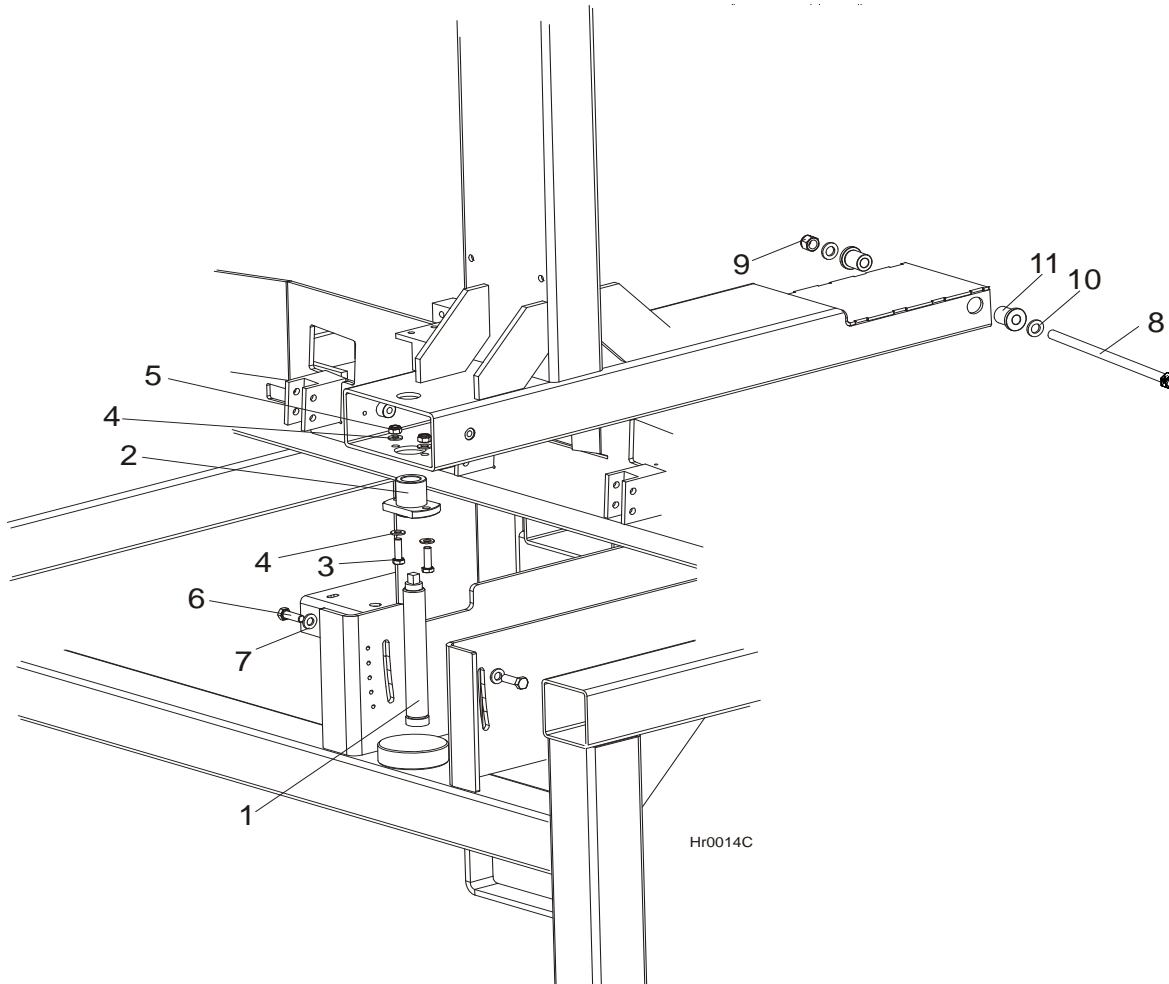
1.21 Mast



REF.	DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)	PART #	QTY
	<b>MAST, 2HR COMPLETE</b>	<b>099444</b>	<b>1</b>
1	MAST WELDMENT, RESAW	093504-1	1

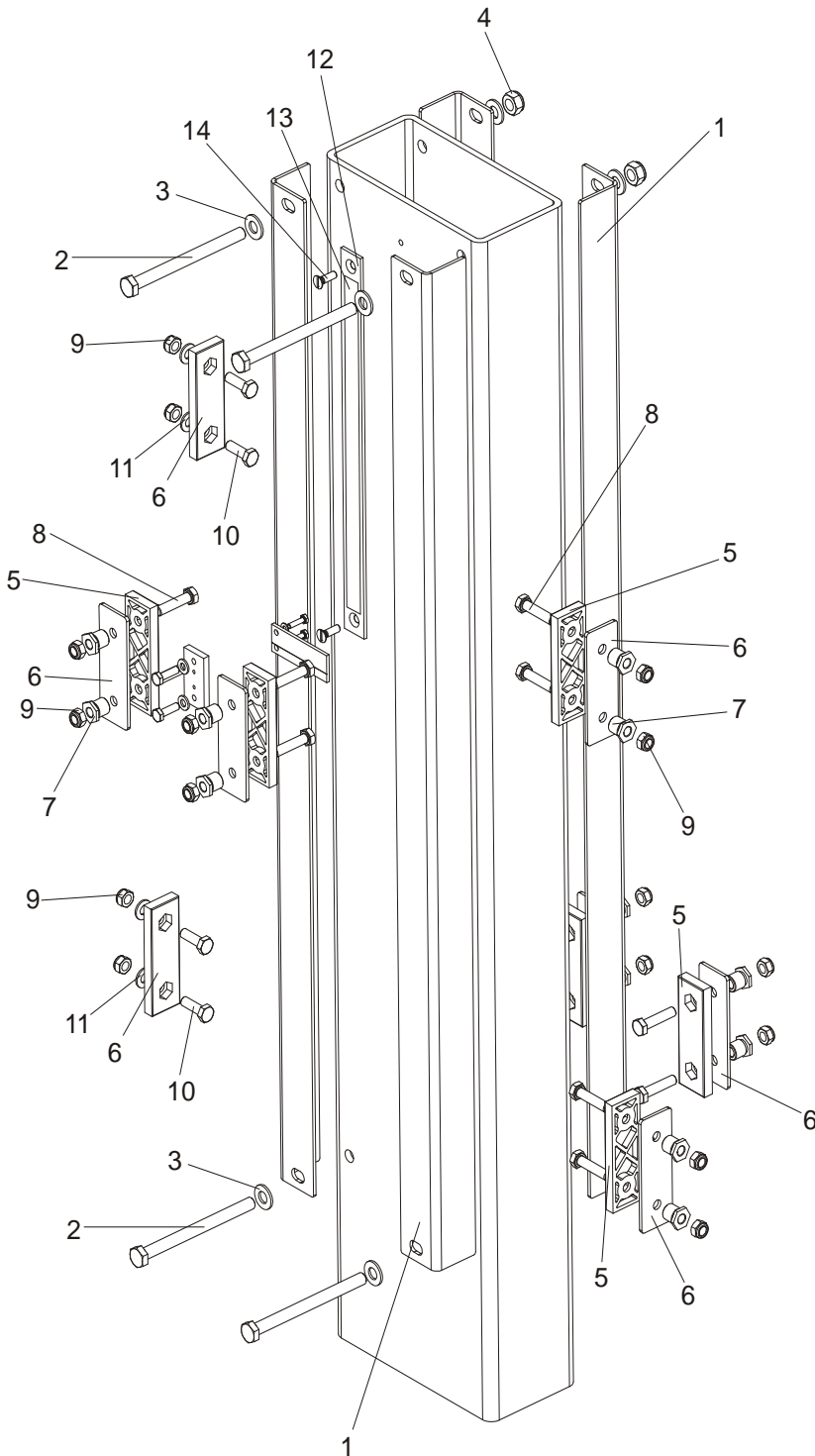
REF.	DESCRIPTION (◆ Indicates Parts Available in Assemblies Only)	PART #	QTY
2	BUSHING, MOUNTING ZINC-PLATED	093507-1	2
3	WASHER, 17 SPLIT LOCK ZINC	F81058-1	2
4	WASHER, 13 FLAT ZINC	F81056-1	2
5	BOLT, M12X35 8.8 HEX HEAD FULL THREAD ZINC	F81004-24	2
6	NUT, ACME SCREW FLANGED ZINC-PLATED	093264-1	1
7	SCREW, ACME (MAST TILT ADJUSTMENT)	093509-1	1
8	WASHER, 10.5 FLAT ZINC	F81055-1	12
9	BOLT, M10X35 8.8 HEX HEAD FULL THREAD ZINC	F81003-17	2
10	NUT, M10-8-B HEX NYLON ZINC LOCK	F81033-1	6
11	ANGLE, VERTICAL MAST TUBE	093890	4
12	BOLT, M10x125 8.8 HEX HEAD ZINC	F81003-18	4
	<b>SCALE, RESAW BLADE HEIGHT - COMPLETE</b>	<b>094820</b>	<b>1</b>
13	BAR, RESAW SCALE	094818	1
14	SCALE, 0-30 CM METRIC	094819	1
15	SCREW, M5X12- 5.8-B SLOTTED COUNTERSUNK HEAD ZINC	F81000-15	2
16	WASHER, 8.2 SPLIT LOCK ZINC	F81054-4	2
17	SCREW, M8x20-8.8 HEX SOCKET HEAD CAP ZINC	F81002-30	2
18	BOLT, ISO4014 M16x260-8.8-A2E HEX HEAD	F81006-47	1
19	NUT, M16-8 HEX NYLON ZINC LOCK	F81036-2	1
20	CLAMP, 1/2" EMT COATED	P07584	2
21	CLIP, RSGU 1.15/20 PIPE RETAINING	509701	1
22	WASHER, 8.4 FLAT ZINC	F81054-1	4
23	NUT, M8 8 HEX NYLON ZINC LOCK	F81032-2	2
24	GROMMET, 22 MM DIA. RUBBER	087400	2
25	BOLT, M8x25-8.8-B HEX HEAD FULL THREAD ZINC	F81002-5	2
26	GROMMET, RUBBER	089532	2
27	<b>WRENCH, LT20 BLADE TENSION</b>	091620	1

**1.22 Mast Tilt Adjustment Screw**



REF.	DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)	PART #	QTY
1	SCREW, MAST TILT ADJUSTMENT ACME	093509-1	1
2	NUT, ACME SCREW FLANGED ZINC-PLATED	093264-1	1
3	BOLT, M10X35-8.8 HEX HEAD FULL THREAD ZINC	F81003-17	2
4	WASHER, 10.5 FLAT ZINC	F81055-1	4
5	NUT, M10-8-B HEX NYLON ZINC LOCK	F81033-1	2
6	BOLT, M12X35-8.8 HEX HEAD FULL THREAD ZINC	F81004-24	2
7	WASHER, 13 FLAT ZINC	F81056-1	2
8	BOLT, ISO 4014 M16X260-8.8-A2E HEX HEAD	F81006-47	1
9	NUT, M16-8 HEX NYLON ZINC LOCK	F81036-2	2
10	WASHER, 17 SPLIT LOCK ZINC	F81058-1	2
11	BUSHING, MOUNTING	093507	2

**1.23 Vertical Mast Slide Pads**

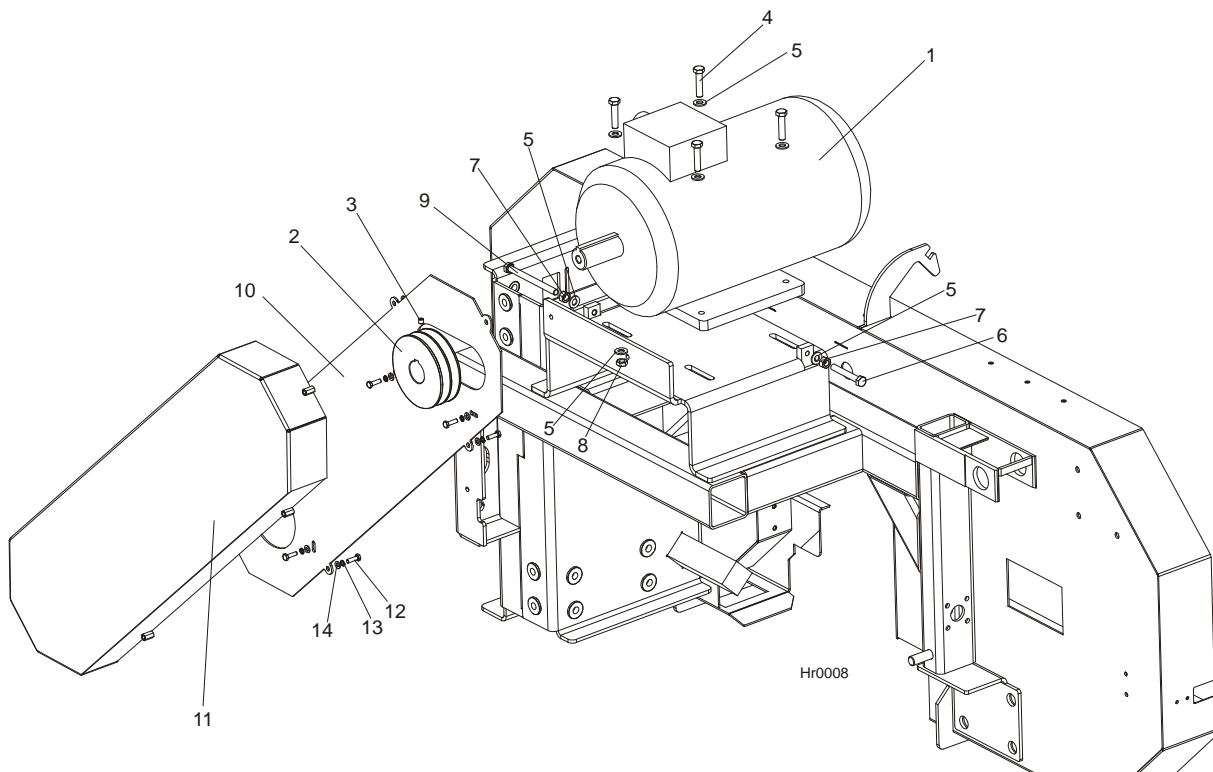


REF.	DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)	PART #	QTY
1	ANGLE, VERTICAL MAST TUBE	093890	4
2	BOLT, M10X125-8.8 HEX HEAD ZINC	F81003-18	4
3	WASHER, 10.5 FLAT ZINC	F81055-1	8



4	NUT, M10-8-B HEX NYLON ZINC LOCK	F81033-1	4	
5	PAD, DELRIN UP/DOWN SLIDE	M04096	8	
6	PLATE, SLIDE PAD MOUNTING	093246-1	6	
7	NUT, SLIDE PAD ADJUSTMENT ZINC-PLATED	086683-1	12	
8	BOLT, M8X35-8.8 HEX HEAD FULL THREAD ZINC	F81002-13	12	
9	NUT, M8-8-B HEX NYLON ZINC LOCK	F81032-2	16	
10	BOLT, M8X25-8.8-B HEX HEAD FULL THREAD ZINC	F81002-5	4	
11	WASHER, 8.4 FLAT ZINC	F81054-1	4	
	SCALE, RESAW BLADE HEIGHT-COMPLETE	094820	1	
12	Bar, Resaw Blade Height Scale	094818	1	
13	Scale, 0-30 cm Resaw Metric	094819	1	
14	SCREW, M5X12- 5.8-B SLOTTED COUNTERSUNK HEAD ZINC	F81000-15	2	

**1.24 Motor Assembly**



REF.	DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)	PART #	QTY	
1	MOTOR, 7.5kW Sg132M-4B - HM	094996	1	
	MOTOR, 11kW Sg132M-4PC - HM	093219	1	
2	PULLEY, SPB $\Phi$ 100X2/ $\Phi$ 38 (F02312+T31079)	500176 <sup>1</sup>	1	
	PULLEY, SPB $\Phi$ 125X2/ $\Phi$ 38 (F02320+F31109)	500570 <sup>2</sup>	1	
3	SCREW, M8X8-33H HEX SOCKET FLAT POINT ZINC SET	F81014-1	1	
4	BOLT, M10X45-8.8 HEX HEAD FULL THREAD ZINC	F81003-3	4	
5	WASHER, 10.5 FLAT ZINC	F81055-1	10	

# 1

## REPLACEMENT PARTS

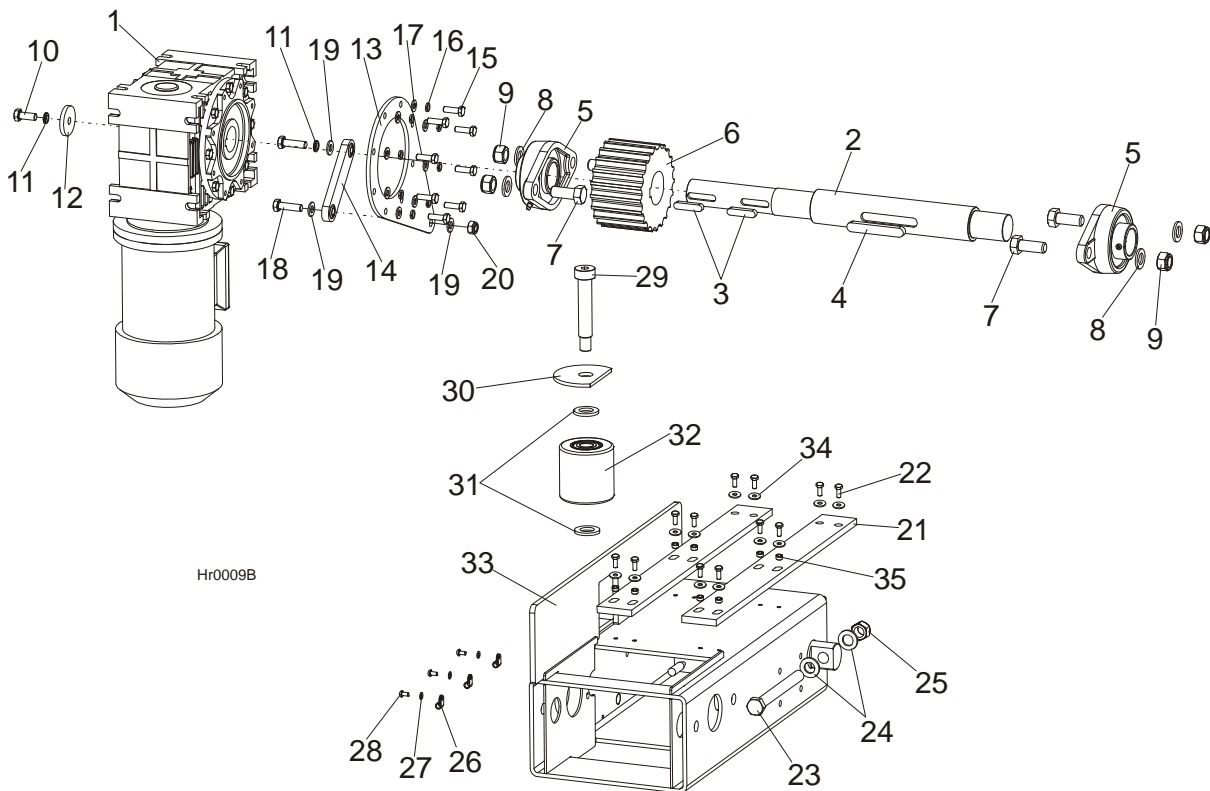
### Feed Chain Drive & Tensioner

6	BOLT, M10X70-8.8 HEX HEAD FULL THREAD ZINC	F81003-20	1	
7	NUT, M10-8-B HEX ZINC	F81033-3	2	
8	NUT, M10-8-B HEX NYLON ZINC LOCK	F81033-1	4	
9	BOLT, M10X120 8.8 HEX HEAD FULL THREAD ZINC	F81003-47	1	
10	COVER, DRIVE BELT GUARD PAINTED	093259-1	1	
11	GUARD WELDMENT, RESAW DRIVE BELT PAINTED	093262-1	1	
12	BOLT, M6X20-8.8 HEX HEAD FULL THREAD ZINC	F81001-2	10	
13	WASHER, Z 6.1 SPLIT LOCK ZINC	F81053-3	10	
14	WASHER, 6.4 FLAT ZINC	F81053-1	10	
	BELT, 2BXF71 MOTOR DRIVE	036163	1	
	BELT, 2BX70 11kW MOTOR DRIVE (E15)	P04857-2	1	

<sup>1</sup> Pulley #500176 with pulley # 500177 and belt # 036163 are standard equipment and allow the user to reach the blade linear speed of 20.5 m/s. To reach the blade linear speed of 24.2 m/s, use pulley # 500569 with belt # P04857-2 instead of pulley #500177.

<sup>2</sup> Pulley #500570 with pulley #500569 allow the user to reach the blade linear speed of 30.3 m/s. Use drive belt #P04857-2.

## 1.25 Feed Chain Drive & Tensioner



REF.	DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)	PART #	QTY	
	DRIVE ASSEMBLY, HR FEED CHAIN	099377	1	
	DRIVE ASSEMBLY, HR PLATE LINK CHAIN	099069	1	
1	MOTOREDUCER, MR-80/42/1.1-1400/V6	099070	1	
	MOTOR, 1.1kW 1400 r.p.m.	086530	1	
	REDUCER, MR-80/42	083879	1	
2	SHAFT, HR CHAIN DRIVE ZINC-PLATED	099335-1	1	

# REPLACEMENT PARTS

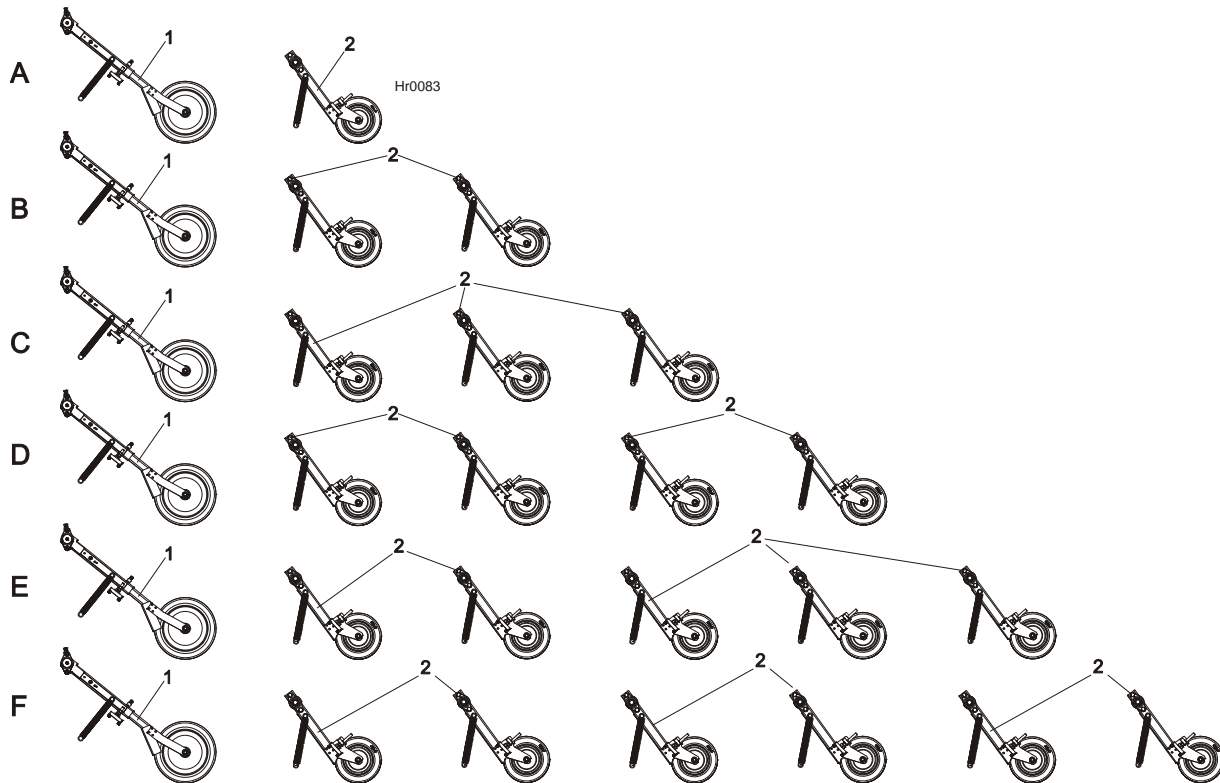
## Feed Chain Drive & Tensioner

1

3	KEY, A10x8x45 PARALLEL	091312	2	
4	KEY, A14X9X90 PARALLEL	099424	1	
5	BEARING, UCFL208 W/HOUSING	099423	2	
6	SPROCKET, KZN800/21-40 A=80,B=40	099079	1	
7	BOLT, M16x40-8.8 HEX HEAD FULL THREAD ZINC	F81006-13	4	
8	WASHER, 17 FLAT ZINC	F81058-1	4	
9	NUT, M16-8 HEX NYLON ZINC LOCK	F81036-2	4	
10	BOLT, M10x25-8.8 HEX HEAD FULL THREAD ZINC	F81003-11	1	
11	WASHER, 10.2 SPLIT LOCK ZINC	F81055-2	2	
12	WASHER, LT15 DRIVE WHEEL ZINC-PLATED	086286-1	1	
13	PLATE, RA80 MOTOREDCER SUPPORT	099425-1	1	
14	LINK, SBPL 10104 PIVOTAL	097700	1	
15	BOLT, M8x25-8.8-B HEX HEAD FULL THREAD ZINC	F81002-5	8	
16	WASHER, 8.2 SPLIT LOCK ZINC	F81054-4	8	
17	WASHER, 8.4 FLAT ZINC	F81054-1	8	
18	BOLT, M10x35-8.8 HEX HEAD FULL THREAD ZINC	F81003-17	2	
19	WASHER, 10.5 FLAT ZINC	F81055-1	2	
20	NUT, M10-8-B HEX NYLON ZINC LOCK	F81033-1	1	
21	PAD, FEED TRACK (MEDIUM)	099376	2	
22	BOLT, M6x16 8.8 HEX HEAD FULL THREAD ZINC	F81001-15	12	
23	BOLT, M16x160-8.8 HEX HEAD ZINC	F81006-20	2	
24	WASHER, 17 FLAT ZINC	F81058-1	4	
25	NUT, M16-8 HEX NYLON ZINC LOCK	F81036-2	2	
26	CLAMP, RSGU 1.10/12 W1 METAL & RUBBER	086861	3	
27	WASHER, 5.3 FLAT ZINC	F81052-1	3	
28	SCREW, H M5x10 8.8 CROSS RECESSED PAN HEAD ZINC	F81000-13	3	
29	BOLT, 20/M16X90 12.9 ISO7379 SHOULDER	F81006-30 <sup>1</sup>	1	
30	PLATE, GUIDE ROLLER COVER ZINC-PLATED	099441-1 <sup>1</sup>	1	
31	WASHER, 21 FLAT ZINC	F81059-2 <sup>1</sup>	2	
32	ROLLER, R-80-80 (ZABI) GUIDE	099429 <sup>1</sup>	1	
33	MOUNT WELDMENT, HR CHAIN DRIVE	099378-1	1	
34	WASHER, 6.5 SPECIAL FLAT ZINC	F81053-11	12	
35	BUSHING, 6.2X10X5 SPACER ZINC-PLATED	503674-1	8	

<sup>1</sup> The quantities of rollers and their mounting hardware are: HR1/2 - 12 pcs, HR3/4 - 20 pcs, HR5/6 - 28 pcs.

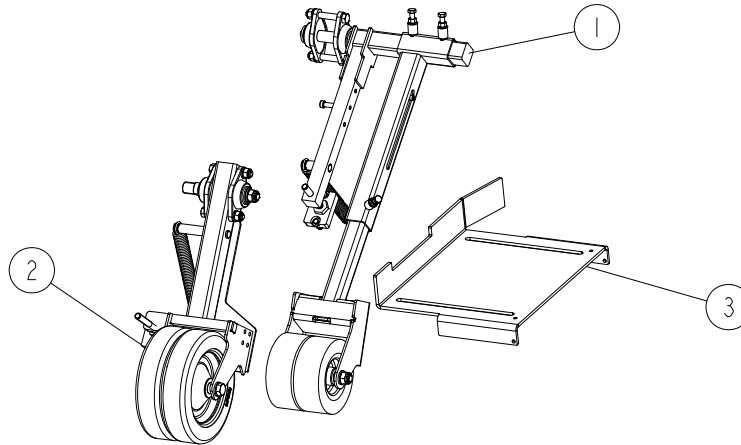
**1.26 Hold-Down Roller Kit, HR500 1-6 - Standard**



REF.	DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)	PART #	QTY
<b>A</b>	<b>ROLLER KIT, HR500-1 STANDARD HOLD-DOWN</b>	<b>506296</b>	<b>1</b>
1	ROLLER, 400 COMPLETE HOLD-DOWN	099347	1
2	ROLLER, 300 COMPLETE DUAL HOLD-DOWN	100344	1
<b>B</b>	<b>ROLLER KIT, HR500-2 STANDARD HOLD-DOWN</b>	<b>506297</b>	<b>1</b>
1	ROLLER, 400 COMPLETE HOLD-DOWN	099347	1
2	ROLLER, 300 COMPLETE DUAL HOLD-DOWN	100344	2
<b>C</b>	<b>ROLLER KIT, HR500-3 STANDARD HOLD-DOWN</b>	<b>506298</b>	<b>1</b>
1	ROLLER, 400 COMPLETE HOLD-DOWN	099347	1
2	ROLLER, 300 COMPLETE DUAL HOLD-DOWN	100344	3
<b>D</b>	<b>ROLLER KIT, HR500-4 STANDARD HOLD-DOWN</b>	<b>506299</b>	<b>1</b>
1	ROLLER, 400 COMPLETE HOLD-DOWN	099347	1
2	ROLLER, 300 COMPLETE DUAL HOLD-DOWN	100344	4
<b>E</b>	<b>ROLLER KIT, HR500-5 STANDARD HOLD-DOWN</b>	<b>506300</b>	<b>1</b>
1	ROLLER, 400 COMPLETE HOLD-DOWN	099347	1
2	ROLLER, 300 COMPLETE DUAL HOLD-DOWN	100344	5
<b>F</b>	<b>ROLLER KIT, HR500-6 STANDARD HOLD-DOWN</b>	<b>506301</b>	<b>1</b>
1	ROLLER, 400 COMPLETE HOLD-DOWN	099347	1
2	ROLLER, 300 COMPLETE DUAL HOLD-DOWN	100344	6

**1.27 Hold-Down Roller Kit, 200 HR500 1-6 (Option)**

520428\_001  
520428\_MANUAL



REF.	DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)	PART #	QTY
	<b>ROLLER KIT, HR500-1 STANDARD HOLD-DOWN</b>	<b>520428</b>	
1	ROLLER, HR500 200 FRONT HOLD-DOWN - COMPLETE <a href="#">See Section 1.29</a>	518554	1
2	ROLLER, 300 DUAL HOLD-DOWN - COMPLETE <a href="#">See Section 1.28</a>	100344	1
3	GUIDE, HR500 LOG	515196-1	1
	<b>ROLLER KIT, HR500-2 STANDARD HOLD-DOWN</b>	<b>520429</b>	
1	ROLLER, HR500 200 FRONT HOLD-DOWN - COMPLETE <a href="#">See Section 1.29</a>	518554	1
2	ROLLER, 300 DUAL HOLD-DOWN - COMPLETE <a href="#">See Section 1.28</a>	100344	2
3	GUIDE, HR500 LOG	515196-1	1
	<b>ROLLER KIT, HR500-3 STANDARD HOLD-DOWN</b>	<b>520430</b>	
1	ROLLER, HR500 200 FRONT HOLD-DOWN - COMPLETE <a href="#">See Section 1.29</a>	518554	1
2	ROLLER, 300 DUAL HOLD-DOWN - COMPLETE <a href="#">See Section 1.28</a>	100344	3
3	GUIDE, HR500 LOG	515196-1	1
	<b>ROLLER KIT, HR500-4 STANDARD HOLD-DOWN</b>	<b>520431</b>	
1	ROLLER, HR500 200 FRONT HOLD-DOWN - COMPLETE <a href="#">See Section 1.29</a>	518554	1
2	ROLLER, 300 DUAL HOLD-DOWN - COMPLETE <a href="#">See Section 1.28</a>	100344	4
3	GUIDE, HR500 LOG	515196-1	1
	<b>ROLLER KIT, HR500-5 STANDARD HOLD-DOWN</b>	<b>520432</b>	
1	ROLLER, HR500 200 FRONT HOLD-DOWN - COMPLETE <a href="#">See Section 1.29</a>	518554	1
2	ROLLER, 300 DUAL HOLD-DOWN - COMPLETE <a href="#">See Section 1.28</a>	100344	5
3	GUIDE, HR500 LOG	515196-1	1
	<b>ROLLER KIT, HR500-6 STANDARD HOLD-DOWN</b>	<b>520433</b>	
1	ROLLER, HR500 200 FRONT HOLD-DOWN - COMPLETE <a href="#">See Section 1.29</a>	518554	1
2	ROLLER, 300 DUAL HOLD-DOWN - COMPLETE <a href="#">See Section 1.28</a>	100344	6
3	GUIDE, HR500 LOG	515196-1	1

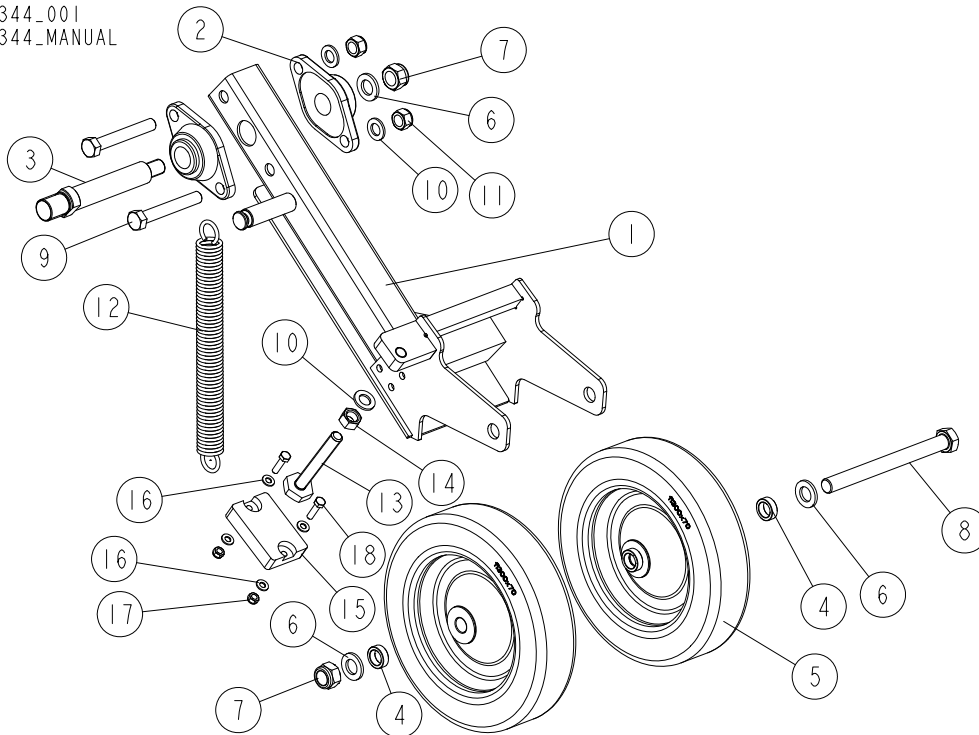
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## REPLACEMENT PARTS

### Front Dual Hold-Down Roller (300 mm)

#### 1.28 Front Dual Hold-Down Roller (300 mm)

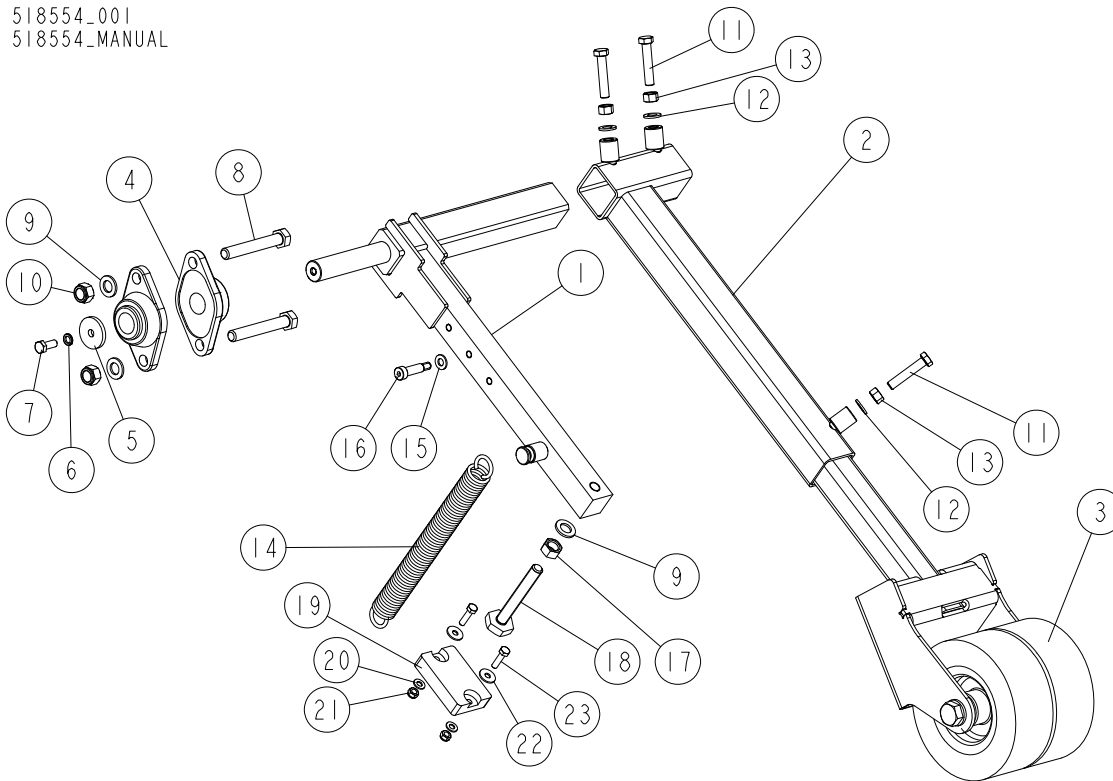
100344\_001  
100344\_MANUAL



REF.	DESCRIPTION (◆ Indicates Parts Available in Assemblies Only)	PART #	QTY
-	<b>ROLLER, 300 DUAL HOLD-DOWN - COMPLETE</b>	100344	1
1	ARM WELDMENT, 300 HOLD-DOWN ROLLER	100345-1	1
2	BEARING, UCFL 206 (CX)	090851	2
3	PIN, 300 ROLLER ARM PIVOT ZINC-PLATED	100477-1	1
4	BUSHING, 21/30-10 ZINC-PLATED	099351-1	3
5	WHEEL, 300X70 - 100L (ZABI) METAL & RUBBER	100349	2
6	WASHER, 21 FLAT ZINC	F81059-2	3
7	NUT, M20-8 DIN985 HEX NYLON ZINC LOCK	F81037-2	2
8	BOLT, M20X220-8.8 HEX HEAD FULL THREAD ZINC	F81007-4	1
9	BOLT, M16X110-8.8-B HEX HEAD ZINC	F81006-24	2
10	WASHER, 17 SPLIT LOCK ZINC	F81058-1	3
11	NUT, M16-8 HEX NYLON ZINC LOCK	F81036-2	2
12	SPRING, N4.5XN35X303	091863	1
13	BOLT, M16 HOLD-DOWN ROLLER ARM ZINC-PLATED	100426-1	1
14	NUT, M16-8 HEX ZINC	F81036-1	1
15	BUMPER, GRENE 70 3201 0010 RUBBER	094969	1
16	WASHER, 8.4 FLAT ZINC	F81054-1	4
17	NUT, M8-8-B HEX NYLON ZINC LOCK	F81032-2	2
18	BOLT, M8X30-8.8-B HEX HEAD FULL THREAD ZINC	F81002-2	2

**1.29 Front Dual Hold-Down Roller (200 mm)**

518554\_001  
 518554\_MANUAL



REF.	DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)	PART #	QTY
-	<b>ROLLER, HR500 FRONT HOLD-DOWN - COMPLETE (200 MM)</b>	518554	1
1	ARM, 400 HOLD-DOWN ROLLER PIVOT	099369-1	1
2	ARM, HOLD-DOWN ROLLER OUTSIDE	094960-1	1
3	ARM, 200 FRONT HOLD-DOWN ROLLER INSIDE - COMPLETE <a href="#">See Section 7.27</a>	518558	1
4	BEARING, UCFL 206 CX BALL	090851	2
5	WASHER, 10.5/45-6 ZINC-PLATED	086286-1	1
6	WASHER, Z 10.2 SPLIT LOCK ZINC	F81055-2	1
7	BOLT, M10X25 8.8 HEX HEAD FULL THREAD ZINC	F81003-11	1
8	BOLT, M16X110-8.8-B HEX HEAD ZINC	F81006-24	2
9	WASHER, 17 SPLIT LOCK ZINC	F81058-1	3
10	NUT, M16-8 HEX NYLON ZINC LOCK	F81036-2	2
11	BOLT, M12X60-8.8 HEX HEAD FULL THREAD ZINC	F81004-51	3
12	WASHER, 13 FLAT ZINC	F81056-1	3
13	NUT, M12-8-B HEX ZINC	F81034-1	3
14	SPRING, N4.5XN35X303	091863	1
15	WASHER, 10.5 FLAT ZINC	F81055-1	1
16	BOLT, 12/M10X35 12.9 ISO7379 SHOULDER (BOSSARD)	F81003-48	1
17	NUT, M16-8 HEX ZINC	F81036-1	1
18	BOLT, M16 HOLD-DOWN ROLLER ARM ZINC-PLATED	100426-1	1

**1****REPLACEMENT PARTS***Front Dual Hold-Down Roller (200 mm)*

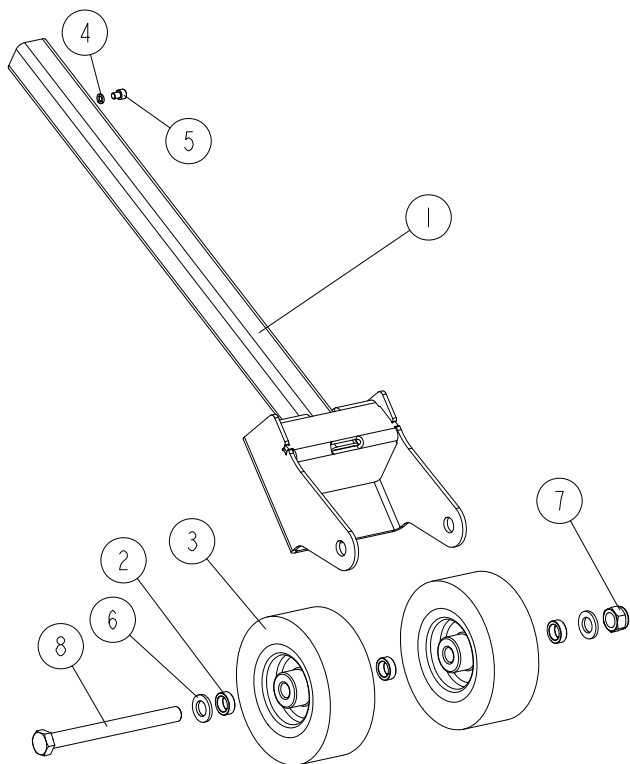
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REF.	DESCRIPTION (◆ Indicates Parts Available in Assemblies Only)	PART #	QTY	
19	BUMPER, GRENE 70 3201 0010 RUBBER	094969	1	
20	WASHER, 8.4 FLAT ZINC	F81054-1	2	
21	NUT, M8-8-B HEX NYLON ZINC LOCK	F81032-2	2	
22	WASHER, ISO 7093-1-8-200 HV-A2E	F81054-11	2	
23	BOLT, M8X30-8.8-B HEX HEAD FULL THREAD ZINC	F81002-2	2	



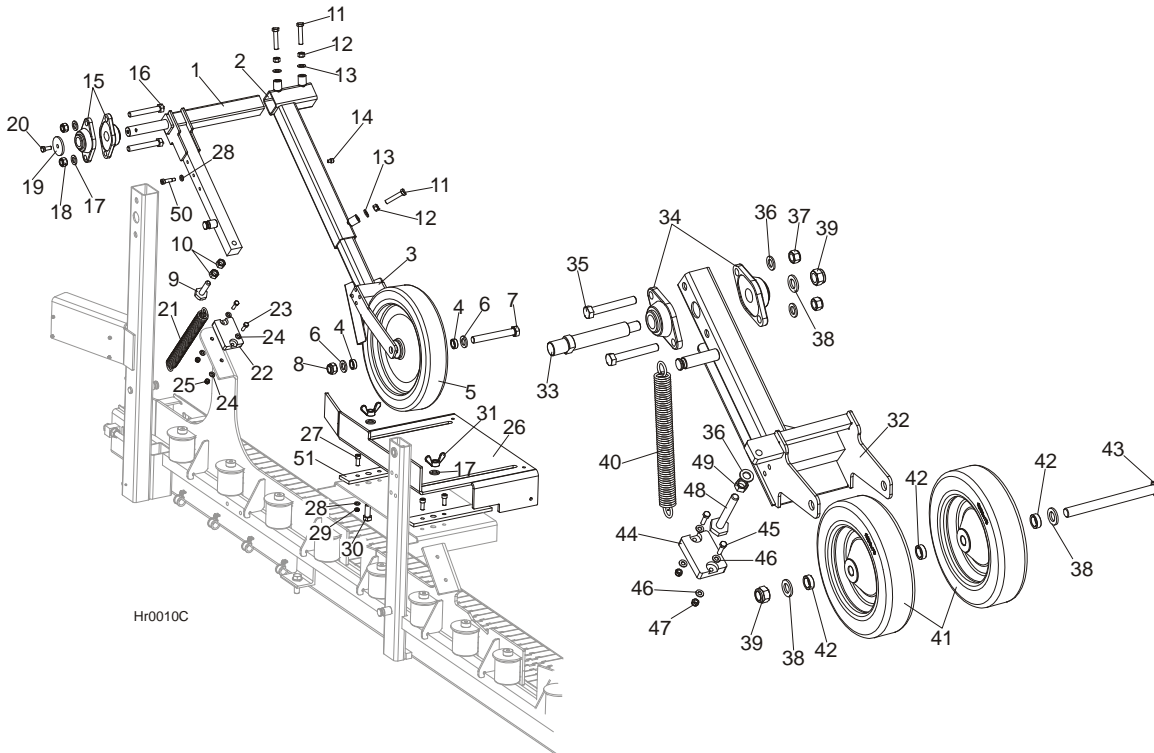
**1.30 Hold-Down Roller Inside Arm (200)**

518558\_001  
 518558\_MANUAL



REF.	DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)	PART #	QTY
-	<b>ARM, FRONT HOLD-DOWN ROLLER - COMPLETE INSIDE (200 MM)</b>	518558	1
1	ARM, 200 ROLLER INSIDE	528011-1	1
2	BUSHING, 21/30-10 ZINC-PLATED	099351-1	3
3	WHEEL, D=200 60NN METAL & RUBBER	099160	2
4	WASHER, 8.2 SPLIT LOCK ZINC	F81054-4	1
5	SCREW, M8X10-8.8 HEX SOCKET HEAD CAP ZINC	F81002-32	1
6	WASHER, 21 FLAT ZINC	F81059-2	2
7	NUT, M20-8 DIN985 HEX NYLON ZINC LOCK	F81037-2	1
8	BOLT, M20X220-8.8 HEX HEAD FULL THREAD ZINC	F81007-4	1

**1.31 Hold-Down Rollers & Log Guide**



REF.	DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)	PART #	QTY
	<b>ROLLER, 400 COMPLETE HOLD-DOWN</b>	099347	1
1	ARM, 400 HOLD-DOWN ROLLER PIVOT	099369-1	1
2	ARM, SHR-F HOLD-DOWN ROLLER OUTSIDE	094960-1	1
3	ARM, 400 HOLD-DOWN ROLLER INSIDE	099348-1	1
4	BUSHING, 21/30-12 ZINC-PLATED SPACER	516941-1	2
5	WHEEL,400 W/6304 BEARINGS	099334	1
6	WASHER, 21 FLAT ZINC	F81059-2	2
7	BOLT, M20x150 8.8 ISO 4017 ZINC-PLATED	F81007-3	1
8	NUT, M20-8-A HEX NYLON ZINC LOCK	F81037-2	1
	M16 BED RAIL ADJUSTMENT BOLT & 2 NUTS	093710	1
9	BOLT, M16 BED RAIL ADJUSTMENT	086809	1
10	NUT, M16-5-B HEX	F81036-5	2
11	BOLT, M12x60-8.8 HEX HEAD FULL THREAD ZINC	F81004-51	3
12	NUT, M12-8-B HEX ZINC	F81034-1	3
13	WASHER, 13 FLAT ZINC	F81056-1	3
14	SCREW, M8x10-8.8 HEX SOCKET HEAD CAP ZINC	F81002-32	1
15	BEARING, UCFL 206 CX BALL	090851	2
16	BOLT, M16x110-8.8 HEX HEAD ZINC	F81006-24	2
17	WASHER, 17 FLAT ZINC	F81058-1	4
18	NUT, M16-8 HEX NYLON ZINC LOCK	F81036-2	2
19	WASHER, IDLE BLADE WHEEL RETAINING ZINC-PLATED	086286-1	1
20	BOLT, M10x25-8.8 HEX HEAD FULL THREAD ZINC	F81003-11	1

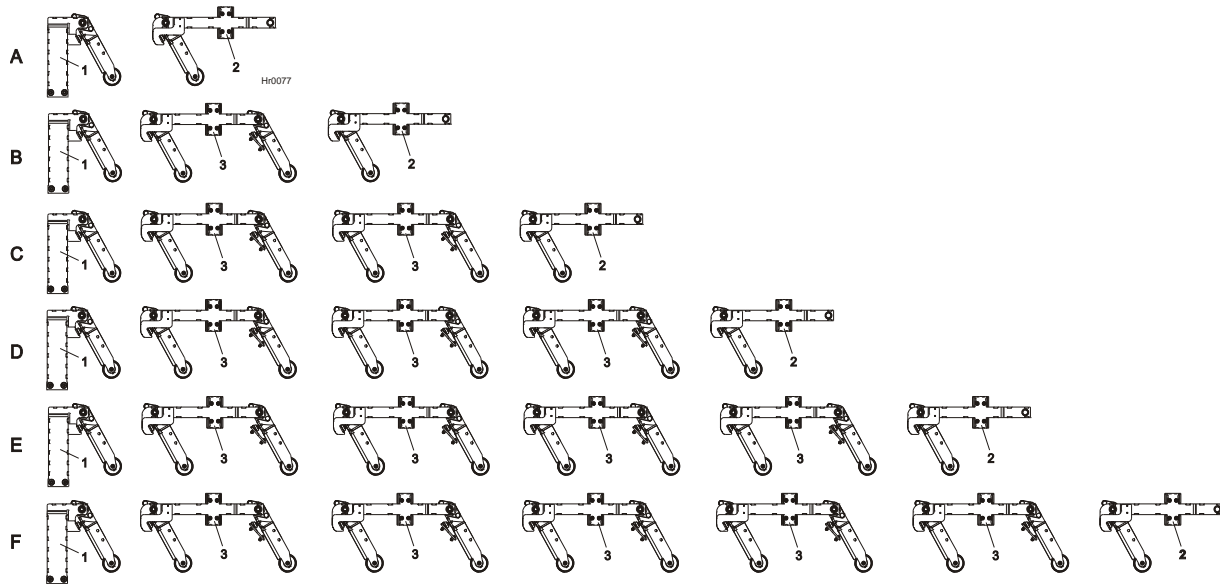
21	<b>SPRING, FI 4,5X FI 35X303</b>	091863	1	
22	<b>BUMPER, GRENE 70 3201 0010. SHR RUBBER</b>	094969	1	
23	<b>BOLT, M8X30-5.8 HEX HEAD FULL THREAD ZINC</b>	F81002-2	2	
24	<b>WASHER, 8.4 FLAT ZINC</b>	F81054-1	4	
25	<b>NUT, M8-8-B HEX NYLON ZINC LOCK</b>	F81032-2	2	
26	<b>GUIDE, LOG (FOR STANDARD ROLLERS)</b>	099442-1	1	
	<b>GUIDE, LOG (FOR OPTIONAL ROLLERS - <a href="#">See Section 1.32</a>)</b>	508129-1	1	
27	<b>SCREW, M10X40 8.8 HEX SOCKET HEAD CAP ZINC</b>	F81003-22	4	
28	<b>WASHER, 10.5 FLAT ZINC</b>	F81055-1	5	
29	<b>NUT, M10-8-B HEX NYLON ZINC LOCK</b>	F81033-1	4	
30	<b>BOLT, M16X40-8.8 HEX HEAD FULL THREAD ZINC</b>	F81006-13	2	
31	<b>NUT, M16 WING ZINC</b>	F81036-3	2	
	<b>ROLLER, 300 COMPLETE DUAL HOLD-DOWN</b>	100344	1	
32	ARM, 300 HOLD-DOWN ROLLER	100345-1	1	
33	PIN, 300 ROLLER PIVOT ZINC-PLATED	100477-1	1	
34	BEARING, UCFL 206 CX BALL	090851	2	
35	BOLT, M16x110-8.8 HEX HEAD ZINC	F81006-24	2	
36	WASHER, 17 FLAT ZINC	F81058-1	3	
37	NUT, M16-8 HEX NYLON ZINC LOCK	F81036-2	2	
38	WASHER, 21 FLAT ZINC	F81059-2	3	
39	NUT, M20-8-A HEX NYLON ZINC LOCK	F81037-2	2	
40	SPRING, FI 4.5X FI 35X303	091863	1	
41	WHEEL, 300x70 METAL & RUBBER	100349	2	
42	BUSHING, 21X30X10 ZINC-PLATED SPACER	099351-1	3	
43	BOLT, M20X220-8.8 HEX HEAD ZINC	F81007-4	1	
44	BUMPER, GRENE 70 3201 0010. SHR RUBBER	094969	1	
45	BOLT, M8x30-5.8 HEX HEAD FULL THREAD ZINC	F81002-2	2	
46	WASHER, 8.4 FLAT ZINC	F81054-1	4	
47	NUT, M8-8-B HEX NYLON ZINC LOCK	F81032-2	2	
48	BOLT, M16 HOLD-DOWN ROLLER ARM ZINC	100426-1	1	
49	NUT, M16-5.8 HEX ZINC	F81036-1	1	
50	<b>BOLT, 12/M10X35 12.9 ISO7379 SHOULDER</b>	F81003-48	1	
51	<b>WASHER, LOG GUIDE SLIDE</b>	099478	2	

# 1

## REPLACEMENT PARTS

101.6 Hold-Down Rollers for HR500 E11 / E15( 1-6 ) - OPTIONAL

### 1.32 101.6 Hold-Down Rollers for HR500 E11 / E15( 1-6 ) - OPTIONAL



REF.	DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)	PART #	QTY
<b>A</b>	<b>101.6 ROLLER KIT FOR HR500E11/E15-1</b>	<b>504954</b>	<b>1</b>
1	ROLLER, 101.6 COMPLETE FRONT HOLD-DOWN	504951	1
2	ROLLER, 101.6 COMPLETE REAR HOLD-DOWN	504960	1
	LOG GUIDE, PAINTED	508129-1	1
<b>B</b>	<b>101.6 ROLLER KIT FOR HR500E11/E15-2</b>	<b>504955</b>	<b>1</b>
1	ROLLER, 101.6 COMPLETE FRONT HOLD-DOWN	504951	1
2	ROLLER, 101.6 COMPLETE REAR HOLD-DOWN	504960	1
3	ROLLER KIT,101.6 COMPLETE HOLD-DOWN	504926	1
	LOG GUIDE, PAINTED	508129-1	1
<b>C</b>	<b>101.6 ROLLER KIT FOR HR500E11/E15-3</b>	<b>504956</b>	<b>1</b>
1	ROLLER, 101.6 COMPLETE FRONT HOLD-DOWN	504951	1
2	ROLLER, 101.6 COMPLETE REAR HOLD-DOWN	504960	1
3	ROLLER KIT,101.6 COMPLETE HOLD-DOWN	504926	2
	LOG GUIDE, PAINTED	508129-1	1
<b>D</b>	<b>101.6 ROLLER KIT FOR HR500E11/E15-4</b>	<b>504957</b>	<b>1</b>
1	ROLLER, 101.6 COMPLETE FRONT HOLD-DOWN	504951	1
2	ROLLER, 101.6 COMPLETE REAR HOLD-DOWN	504960	1
3	ROLLER KIT,101.6 COMPLETE HOLD-DOWN	504926	3
	LOG GUIDE, PAINTED	508129-1	1
<b>E</b>	<b>101.6 ROLLER KIT FOR HR500E11/E15-5</b>	<b>504958</b>	<b>1</b>
1	ROLLER, 101.6 COMPLETE FRONT HOLD-DOWN	504951	1
2	ROLLER, 101.6 COMPLETE REAR HOLD-DOWN	504960	1
3	ROLLER KIT,101.6 COMPLETE HOLD-DOWN	504926	4
	LOG GUIDE, PAINTED	508129-1	1
<b>F</b>	<b>101.6 ROLLER KIT FOR HR500E11/E15-6</b>	<b>504959</b>	<b>1</b>
1	ROLLER, 101.6 COMPLETE FRONT HOLD-DOWN	504951	1

## REPLACEMENT PARTS

### *101.6 Hold-Down Rollers for HR500 E11 / E15( 1-6 ) - OPTIONAL*

1

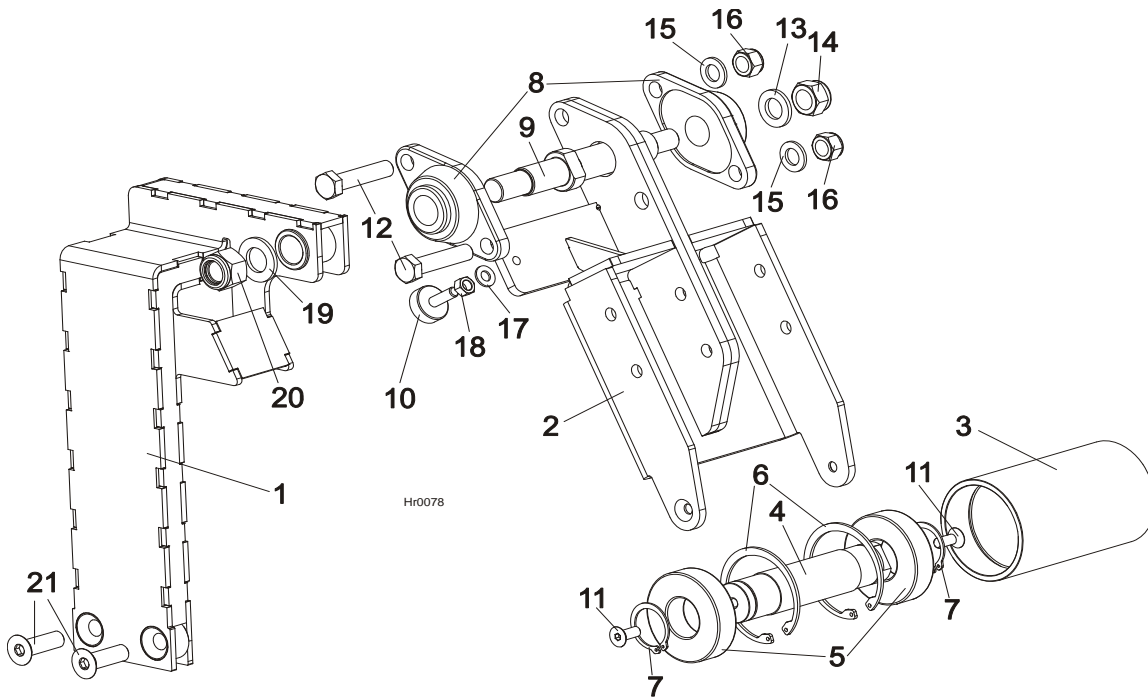
2	ROLLER, 101.6 COMPLETE REAR HOLD-DOWN	504960	1	
3	ROLLER KIT,101.6 COMPLETE HOLD-DOWN	504926	5	
	LOG GUIDE, PAINTED	508129-1	1	

# 1

## REPLACEMENT PARTS

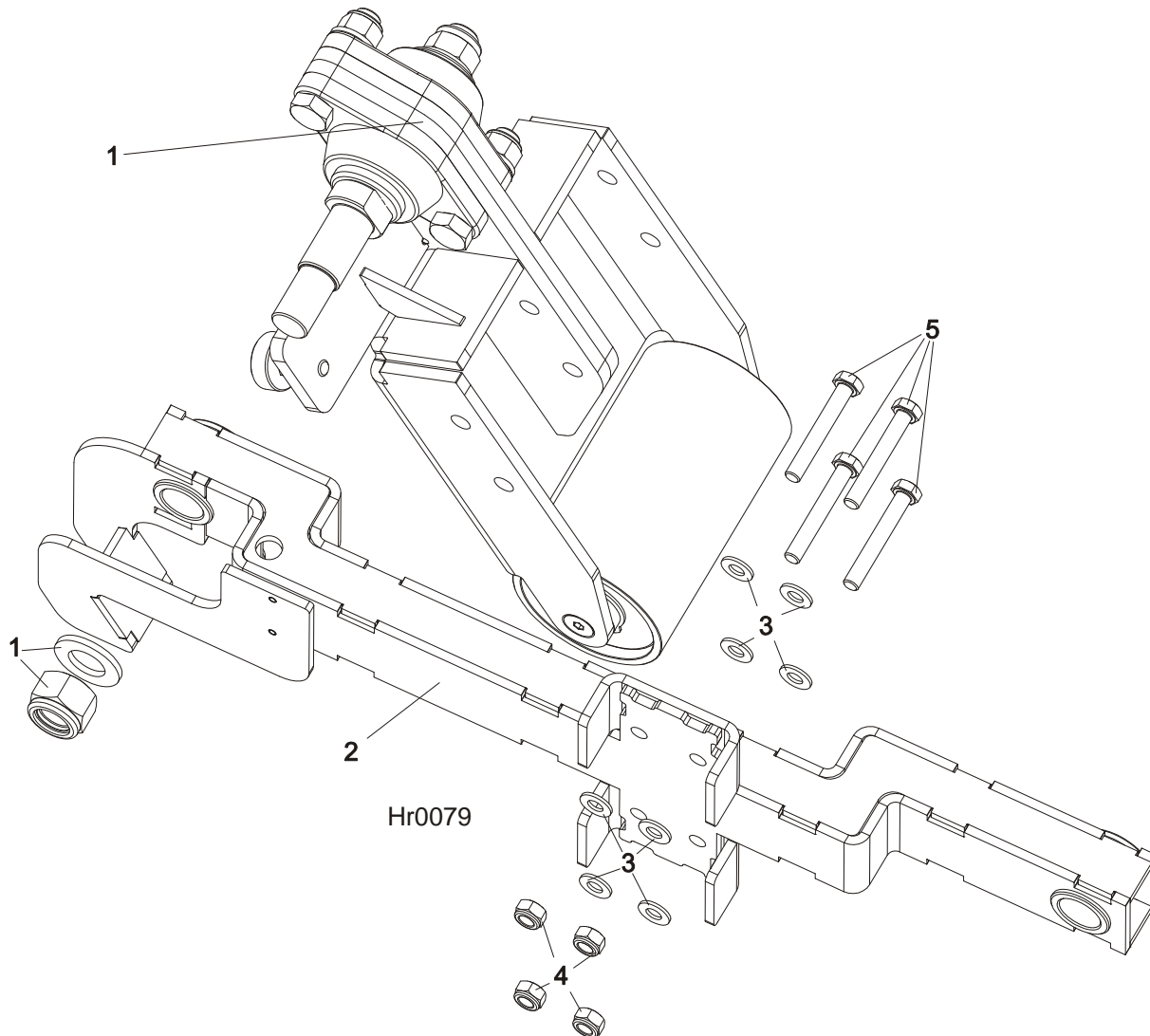
### 101.6 Front Hold-Down Roller - OPTIONAL

### 1.33 101.6 Front Hold-Down Roller - OPTIONAL



REF.	DESCRIPTION (◆ Indicates Parts Available in Assemblies Only)	PART #	QTY
	<b>ROLLER, 101.6 COMPLETE FRONT HOLD-DOWN</b>	<b>504951</b>	<b>1</b>
1	MOUNT WLDMT, 101.6 FRONT HOLD-DOWN ROLLER	504944-1	1
	ROLLER, 101.6 HOLD-DOWN W/ MOUNTING BRACKET - COMPLETE	504933	1
2	BRACKET, 101.6 HOLD-DOWN ROLLER MOUNTING	504927-1	1
	ROLLER, 101.6 X 170 COMPLETE HOLD-DOWN	504930	1
3	TUBE, HOLD-DOWN ROLLER ZINC-PLATED	504931-1	1
4	SHAFT, HOLD-DOWN ROLLER ZINC-PLATED	504932-1	1
5	BEARING, 6308 2RS CX	504268	2
6	RING, W90 INSIDE RETAINING	F81090-29	2
7	RING, Z40 OUTSIDE RETAINING	F81090-33	2
8	BEARING, UCFL 206 CX-WM1000 W/HOUSING	090851	2
9	SHAFT, 101.6 ROLLER MOUNTING BRACKET ZINC-PL	504938-1	1
10	FOOT, M10 ADJUSTABLE BASE	092839	1
11	SCREW, M10x25-10.9 DIN7991 FLAT SOCKET HEAD CAP ZINC	F81003-82	2
12	BOLT, M16x70 -8.8 HEX HEAD ZINC	F81006-16	2
13	WASHER, 21 FLAT ZINC	F81059-2	1
14	NUT, M20-8-A HEX NYLON ZINC LOCK	F81037-2	1
15	WASHER, 17 FLAT ZINC	F81058-1	2
16	NUT, M16-8 HEX NYLON ZINC LOCK	F81036-2	2
17	WASHER, 10.5 FLAT ZINC	F81055-1	1
18	NUT, M10-8-B HEX ZINC	F81033-3	1
19	WASHER, 25 FLAT ZINC	F81061-3	1
20	NUT, M24-8-A HEX NYLON ZINC LOCK	F81039-8	1
21	SCREW, M16x50-10.9 DIN7991, BN1422 FLAT SOCKET HEAD CAP ZINC	F81006-42	2

1.34 101.6 Rear Hold-Down Roller - OPTIONAL



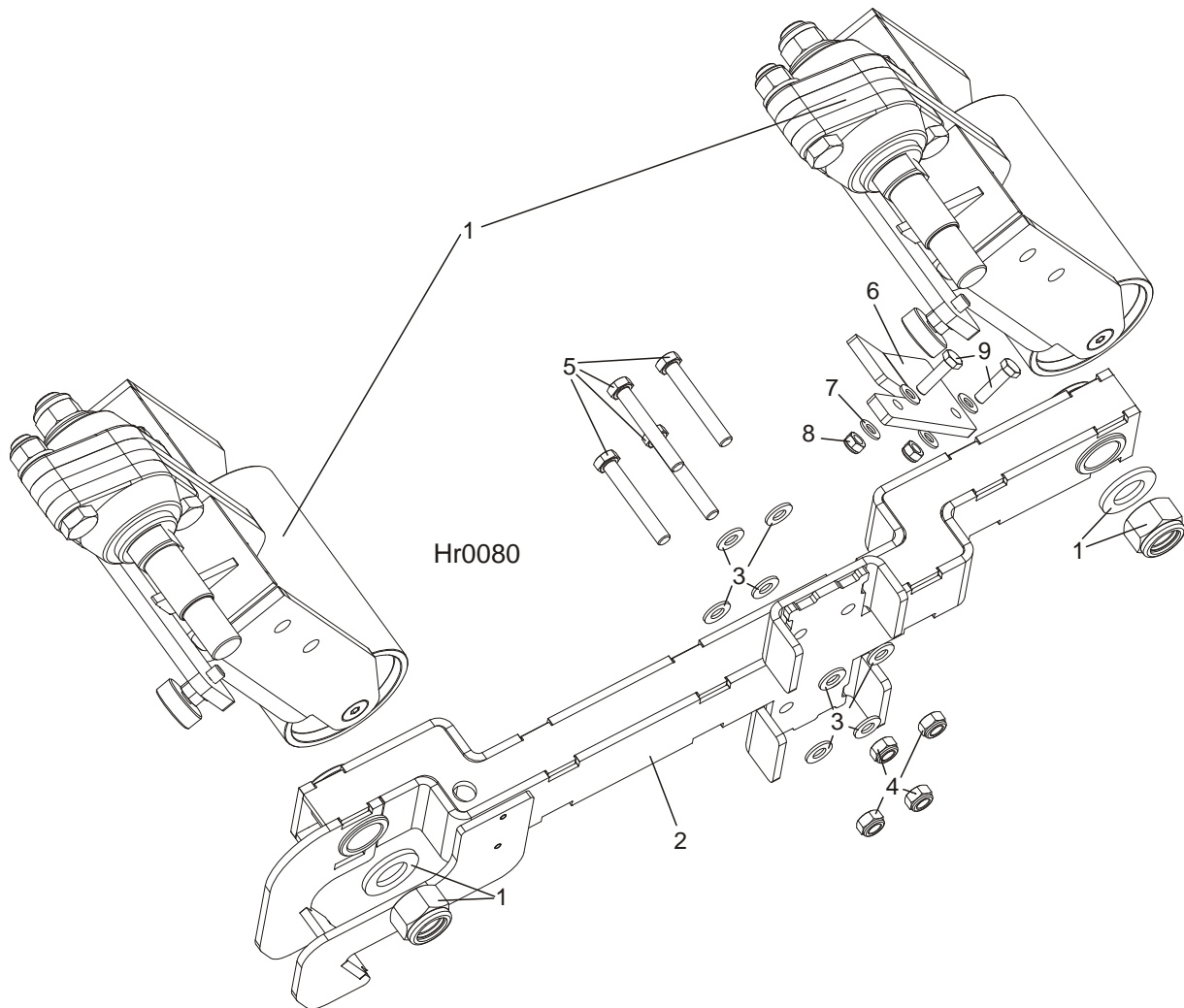
REF.	DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)	PART #	QTY
	<b>ROLLER, 101.6 REAR HOLD-DOWN - COMPLETE</b>	<b>504960</b>	<b>1</b>
1	ROLLER, 101.6 HOLD-DOWN W/ MOUNTING BRACKET - COMPLETE <a href="#">See Section 1.33</a>	504933	1
2	MOUNT WELDMENT, 101.6 HOLD-DOWN ROLLER	504934-1	1
3	WASHER, 10.5 FLAT ZINC	F81055-1	8
4	NUT, M10-8-B HEX NYLON ZINC LOCK	F81033-1	4
5	BOLT, M10x70-8.8 HEX HEAD FULL THREAD ZINC	F81003-20	4

# 1

## REPLACEMENT PARTS

### 101.6 Hold-Down Roller Kit - OPTIONAL

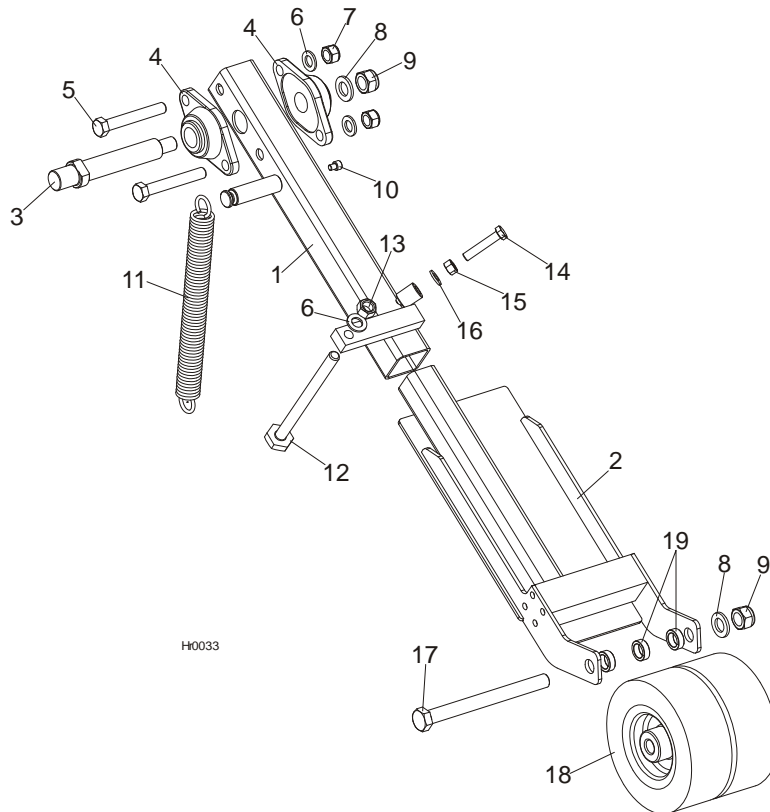
#### 1.35 101.6 Hold-Down Roller Kit - OPTIONAL



REF.	DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)	PART #	QTY
	<b>ROLLER KIT, 101.6 COMPLETE</b>	<b>504926</b>	<b>1</b>
1	ROLLER, 101.6 HOLD-DOWN W/ MOUNTING BRACKET - COMPLETE <a href="#">See Section 1.33</a>	504933	2
2	MOUNT WELDMENT, 101.6 HOLD-DOWN ROLLER	504934-1	1
3	WASHER, 10.5 FLAT ZINC	F81055-1	8
4	NUT, M10-8-B HEX NYLON ZINC LOCK	F81033-1	4
5	BOLT, M10x70-8.8 HEX HEAD FULL THREAD ZINC	F81003-20	4
6	PLATE, FOOT ADDITIONAL STOP	504942-1	1
7	WASHER, 8.4 FLAT ZINC	F81054-1	4
8	NUT, M8-8-B HEX NYLON ZINC LOCK	F81032-2	2
9	BOLT, M8x30-8.8-B HEX HEAD FULL THREAD ZINC	F81002-7	2



**1.36 Adjustable Hold-Down Roller (Option)**



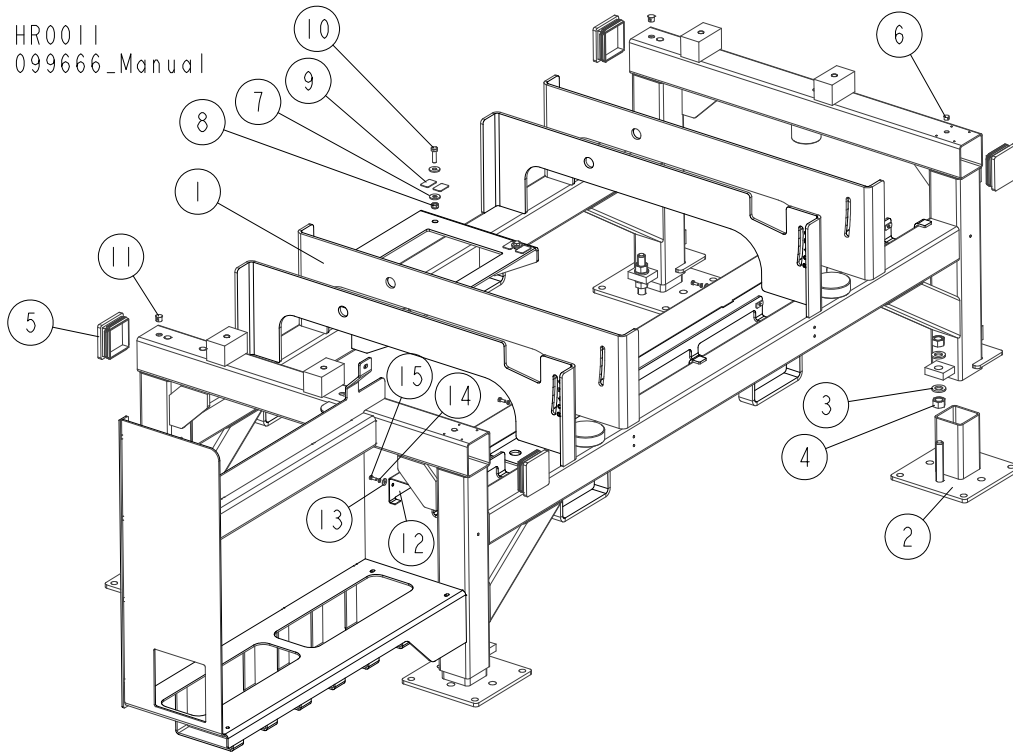
REF.	DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)	PART #	QTY
	<b>ROLLER, HR ADJUSTABLE HOLD-DOWN</b>	<b>100758</b>	<b>1</b>
1	ARM, 200 ADJUSTABLE HOLD-DOWN ROLLER	100587-1	1
2	ARM, 200 HOLD-DOWN ROLLER OUTRIGGER	100592-1	1
3	PIN, 300 ROLLER PIVOT ZINC-PLATED	100477-1	1
4	BEARING, UCFL 206 CX BALL	090851	2
5	BOLT, M16x110-8.8 HEX HEAD ZINC	F81006-24	2
6	WASHER, 17 FLAT ZINC	F81058-1	3
7	NUT, M16-8 HEX NYLON ZINC LOCK	F81036-2	2
8	WASHER, 21 FLAT ZINC	F81059-2	2
9	NUT, M20-8-A HEX NYLON ZINC LOCK	F81037-2	2
10	SCREW, M8x10-8.8 HEX SOCKET HEAD CAP ZINC	F81002-32	1
11	SPRING, FI 4.5X FI 35X303	091863	1
12	BOLT, M16 HOLD-DOWN ROLLER ARM ZINC	100591-1	1
13	NUT, M16-5.8 HEX ZINC	F81036-1	1
14	BOLT, M12x60-8.8 HEX HEAD FULL THREAD ZINC	F81004-51	1
15	NUT, M12-8-B HEX ZINC	F81034-1	1
16	WASHER, 13 FLAT ZINC	F81056-1	1
17	BOLT, M20X220-8.8 HEX HEAD ZINC	F81007-4	1
18	WHEEL, D=200mm 60NN METAL & RUBBER	099160	2

**1****REPLACEMENT PARTS***Adjustable Hold-Down Roller (Option)*

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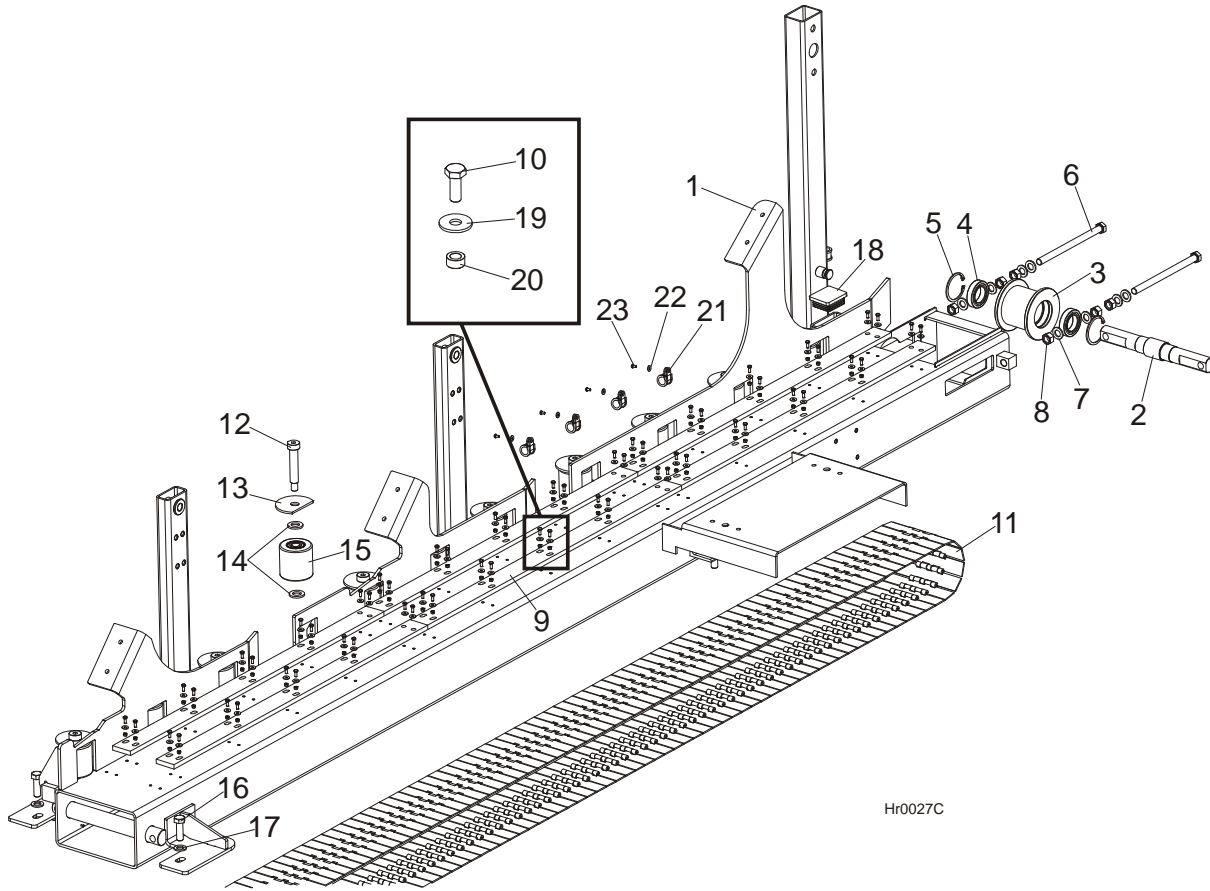
19	BUSHING, 21X30X10 ZINC-PLATED SPACER	099351-1	3	
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1.37 Main Module Base



REF.	DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)	PART #	QTY
	<b>BASE, HR2 MAIN MODULE - COMPLETE</b>	<b>099023</b>	<b>1</b>
1	FRAME, 2HR MAIN MODULE BASE	099024-1	1
2	FOOT, LEG ADJUSTABLE	099547-1	4
3	WASHER, 21 FLAT ZINC	F81059-2	8
4	NUT, M20-8 HEX ZINC	F81037-1	8
5	CAP, 100x100 #199200 SQUARE	090694	4
6	CAP, DP 812 HEJMAN 12.7 DIA. HOLE	086773	2
7	WASHER, 10.5 SPECIAL FLAT ZINC	F81055-6	8
8	NUT, M10-8-B HEX NYLON ZINC LOCK	F81033-1	4
9	WASHER, CORK	502881	8
10	BOLT, M10X35 8.8 HEX HEAD FULL THREAD ZINC	F81003-17	4
11	PLUG, 1086 DIA. 15.9x6.4 DOMED BLANKING (MOSS466856)	511829	6
	<b>COVER, CABLE/HOSE - COMPLETE</b>	<b>515182</b>	<b>1</b>
12	COVER, CABLE/HOSE	515183-1	1
13	WASHER, 6.5 SPECIAL FLAT ZINC	F81053-11	4
14	WASHER, Z 6.1 SPLIT LOCK ZINC	F81053-3	4
15	BOLT, M6X16-8.8 HEX HEAD FULL THREAD ZINC	F81001-15	4

**1.38 Main Module Feed Track**

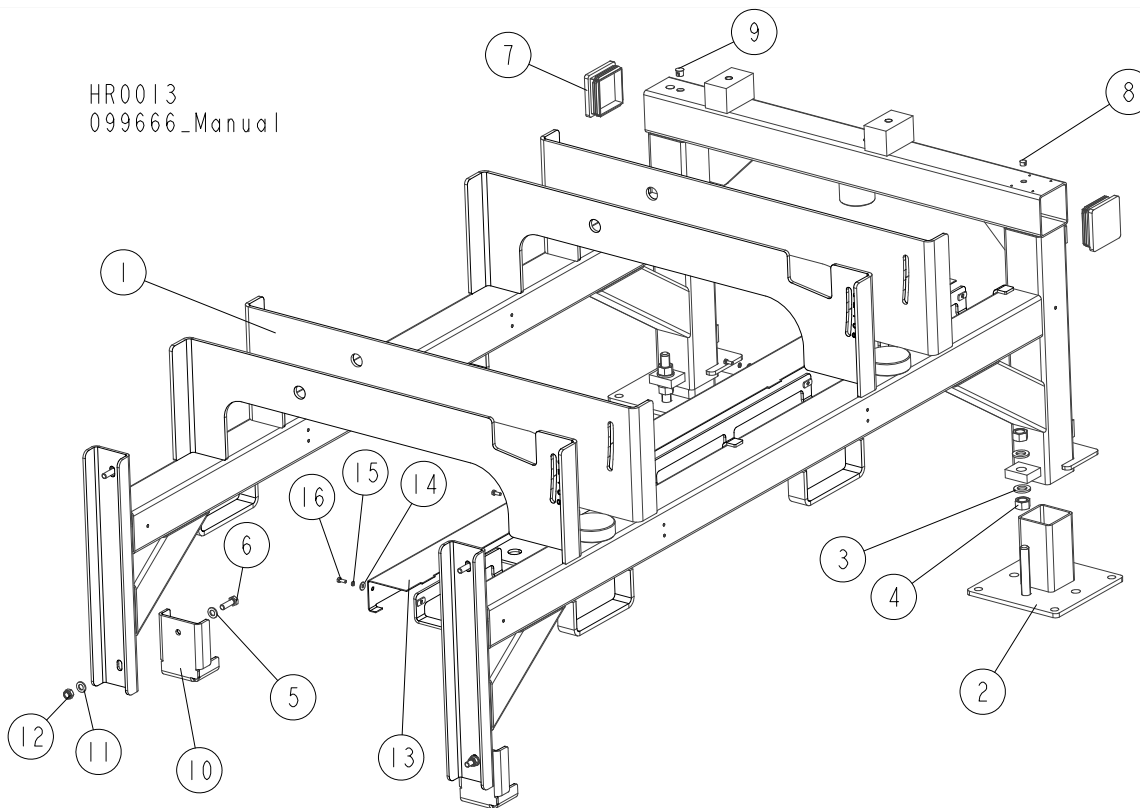


REF.	DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)	PART #	QTY
	<b>MAIN MODULE FEED TRACK - COMPLETE</b>	<b>099039</b>	<b>1</b>
1	TRACK, HR2 MAIN MODULE FEED	099040-1	1
	PULLEY, CHAIN TENSION - COMPLETE	099340	1
2	SHAFT, CHAIN TENSION PULLEY ZINC-PLATED	099337-1	1
3	PULLEY, CHAIN TENSION ZINC-PLATED	099336-1	1
4	BEARING, 6008 2RS FLT	086259	2
5	RING, W68 INSIDE RETAINING	F81090-16	2
6	BOLT, M16X240-8.8-A2 FULL THREAD	F81006-29	2
7	WASHER, 17 FLAT ZINC	F81058-1	8
8	NUT, M16-5.8 HEX ZINC	F81036-1	6
9	PAD, RESAW FEED TRACK	092080	6
10	BOLT, M6x16 8.8 HEX HEAD FULL THREAD ZINC	F81001-15	60
11	CHAIN, ACCATE S802K750 204-LINK	099080	1
	CHAIN, ACCATE S802K750 116-LINK	099344 <sup>1</sup>	1/2
12	BOLT, 20/M16X90 12.9 ISO7379 SHOULDER	F81006-30	11
13	COVER, SIDE ROLLER ZINC-PLATED	099441-1	11
14	WASHER, 21 FLAT ZINC	F81059-2	22
15	ROLLER, R-80-80 (ZABI) SIDE	099429	11

16	BOLT, M16x50-8.8 HEX HEAD FULL THREAD ZINC	F81006-7	4	
17	WASHER, 17 FLAT ZINC	F81058-1	4	
18	CAP, HR FRAME	089644	1	
19	WASHER, 6.5 SPECIAL FLAT ZINC	F81053-11	60	
20	BUSHING, 6.2X10X5 ZINC-PLATED SPACER	503674-1	48	
21	CLAMP, RSGU 1.20/20 W1 METAL & RUBBER	F81087-2	7	
22	WASHER, 5.5 SPECIAL FLAT ZINC	F81052-3	7	
23	SCREW, H M5x10 8.8 CROSS RECESSED PAN HEAD ZINC	F81000-13	7	

<sup>1</sup> Used only on HR3/4 (1 pcs) and on HR5/6 (2 pcs) as the 099080 chain extension.

### 1.39 Additional Module Base



REF.	DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)	PART #	QTY	
	<b>COMPLETE ADDITIONAL MODULE BASE</b>	<b>099031</b> <sup>1</sup>	<b>1/2</b>	
1	FRAME, 2HR ADDITIONAL MODULE BASE	099032-1	1	
2	FOOT, ADJUSTABLE LEG	099547-1	2	
3	WASHER, 21 FLAT ZINC	F81059-2	4	
4	NUT, M20-8 HEX ZINC	F81037-1	4	
5	WASHER, 13 FLAT ZINC	F81056-1	4	
6	BOLT, M12X40-8.8 HEX HEAD FULL THREAD ZINC	F81004-4	4	
7	CAP, 100x100 #199200 SQUARE	090694	2	
8	CAP, DP 500 HEJMAN 12.7 DIA. HOLE (#2643)	086773	1	
9	PLUG, 1086 DIA. 15.9x6.4 DOMED BLANKING (MOSS466856)	511829	3	

# 1

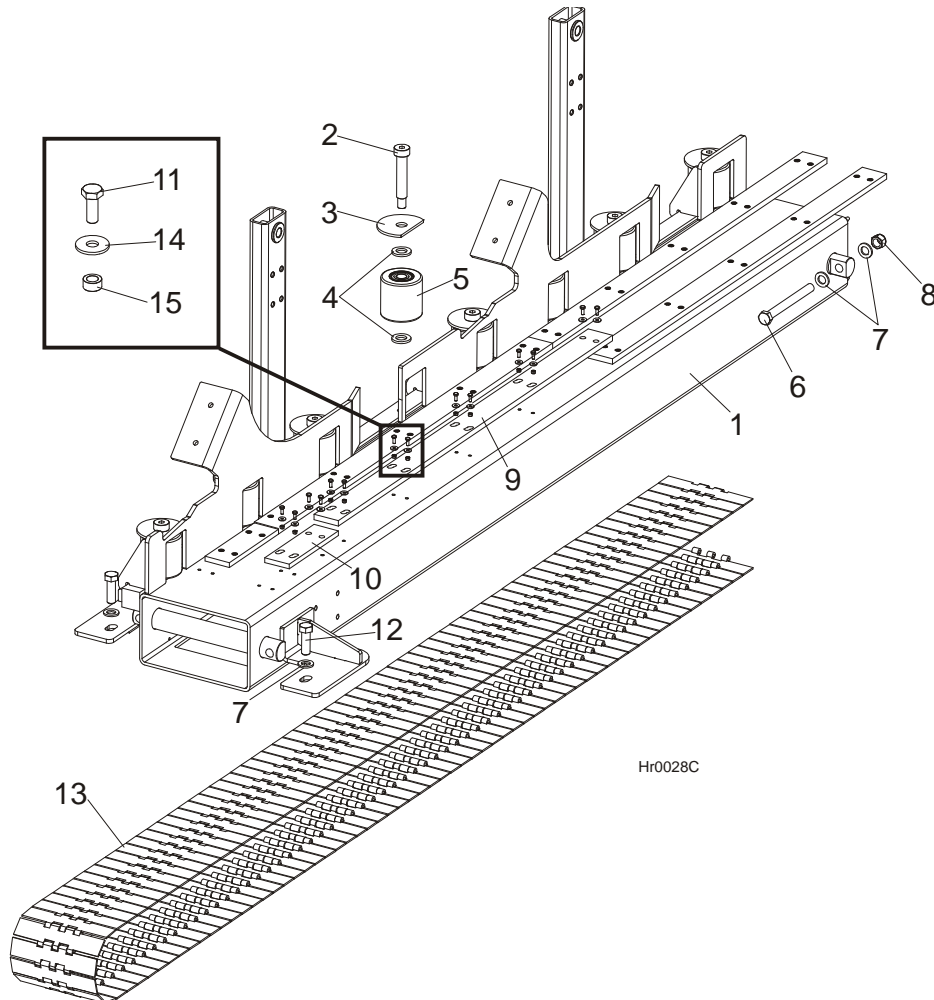
## REPLACEMENT PARTS

### *Additional Module Base*

REF.	DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)	PART #	QTY	
	<b>BRACKET, ADDITIONAL MODULE TRANSPORT - COMPLETE</b>	<b>514728</b>	<b>2</b>	
10	BRACKET, TRANSPORT	514726-1	1	
11	WASHER, 13 FLAT ZINC	F81056-1	1	
12	NUT, M12-8 HEX NYLON ZINC LOCK	F81034-2	1	
	<b>COVER, CABLE/HOSE - COMPLETE</b>	<b>515182</b>	<b>1</b>	
13	COVER, CABLE/HOSE	515183-1	1	
14	WASHER, 6.5 SPECIAL FLAT ZINC	F81053-11	4	
15	WASHER, Z 6.1 SPLIT LOCK ZINC	F81053-3	4	
16	BOLT, M6X16-8.8 HEX HEAD FULL THREAD ZINC	F81001-15	4	

<sup>1</sup> Used on HR3/4 - 1 piece and on HR5/6 - 2 pcs

**1.40 Additional Module Feed Track**



REF.	DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)	PART #	QTY
	<b>ADDITIONAL MODULE FEED TRACK - COMPLETE</b>	099440	1
1	TRACK, HR2 FEED	099372-1	1
2	BOLT, 20/M16X90 12.9 ISO7379 SHOULDER	F81006-30	8
3	COVER, SIDE ROLLER ZINC-PLATED	099441-1	8
4	WASHER, 21 FLAT ZINC	F81059-2	16
5	ROLLER, R-80-80 (ZABI) SIDE	099429	8
6	BOLT, M16x160-8.8 HEX HEAD ZINC	F81006-20	2
7	WASHER, 17 FLAT ZINC	F81058-1	6
8	NUT, M16-8 HEX NYLON ZINC LOCK	F81036-2	2
9	PAD, RESAW FEED TRACK	092080	4
10	PAD, FEED TRACK SHORT	099430	2
11	BOLT, M6x16 8.8 HEX HEAD FULL THREAD ZINC	F81001-15	48
12	BOLT, M16x50-8.8 HEX HEAD FULL THREAD ZINC	F81006-7	2
13	CHAIN, ACCATE 116-LINK	099344	1

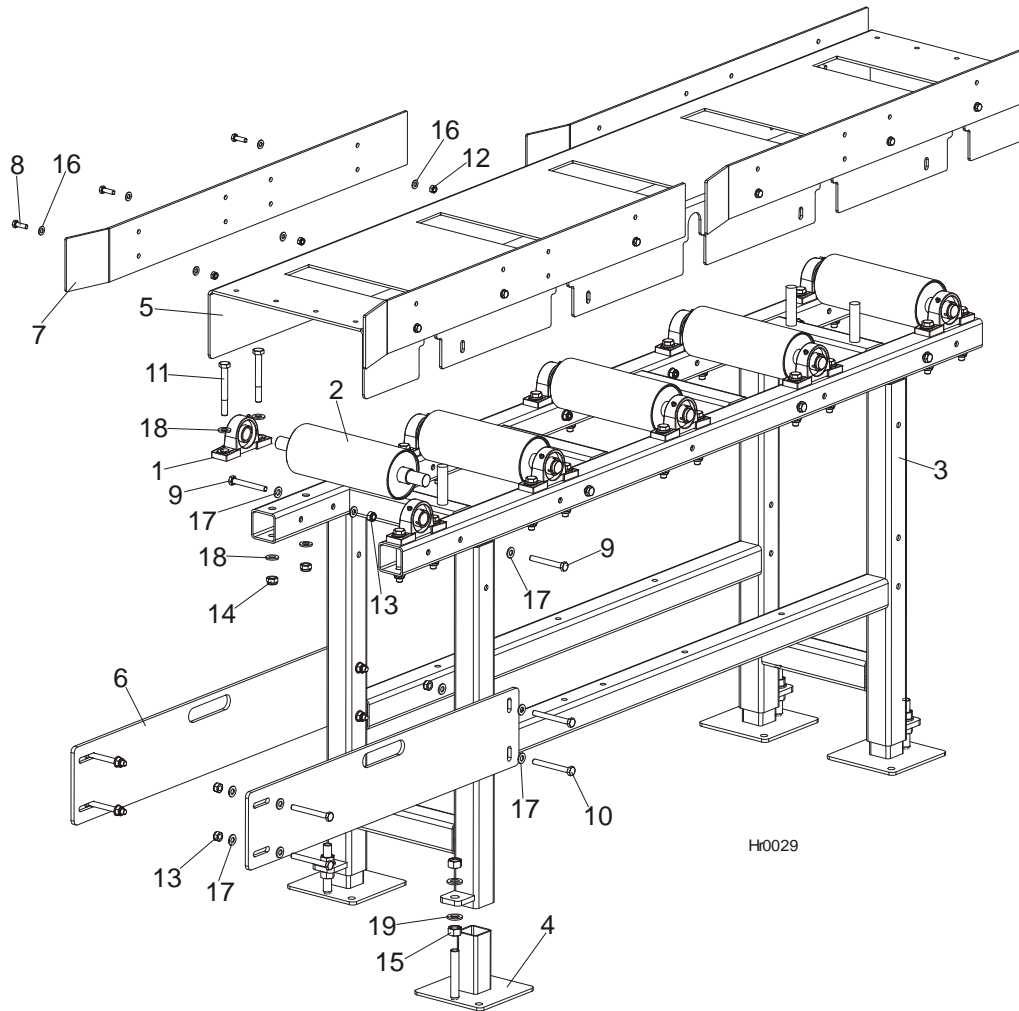
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## REPLACEMENT PARTS

### Idle Roller Table, SLPIRT

14	WASHER, 6.5 SPECIAL FLAT ZINC	F81053-11	48	
15	BUSHING, 6.2X10X5 ZINC-PLATED SPACER	503674-1	36	

### 1.41 Idle Roller Table, SLPIRT



REF.	DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)	PART #	QTY	
	<b>HR IDLE ROLLER TABLE</b>	<b>SLPIRT</b>	<b>1</b>	
	IDLE RETURN TABLE - COMPLETE	099659	1	
1	BEARING, UCP 205 CX W/HOUSING	088468	10	
2	ROLLER, SVS FEED	098140-1	5	
3	FRAME, SVS INFEED & OUTFEED TABLE	099168-1	1	
4	FOOT ASSEMBLY, TABLE LEG	099281-1	4	
5	PLATE, RETURN TABLE TOP	099686-1	1	
6	PLATE, RETURN TABLE CONNECTION	099687-1	2	
7	PLATE, GUIDE	099688-1	4	
8	BOLT, M8x25-8.8-B HEX HEAD FULL THREAD ZINC	F81002-5	12	



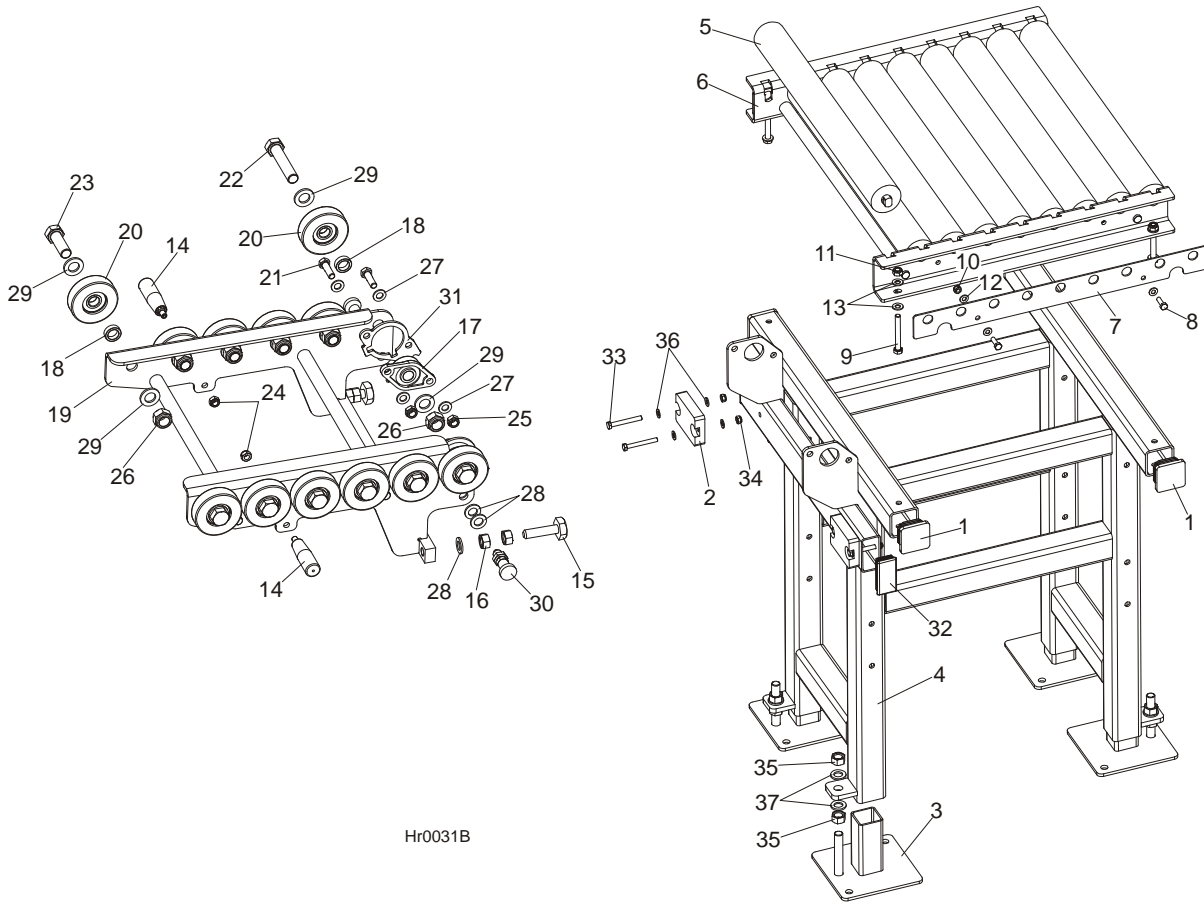
## REPLACEMENT PARTS

*Idle Roller Table, SLPIRT*

1

9	BOLT, M10x80-8.8 HEX HEAD ZINC	F81003-50	9	
10	BOLT, M10x90 -8.8-B HEX HEAD ZINC	F81003-66	8	
11	BOLT, M12x100-8.8 HEX HEAD ZINC	F81004-3	20	
12	NUT, M8-8-B HEX NYLON ZINC LOCK	F81032-2	12	
13	NUT, M10-8-B HEX NYLON ZINC LOCK	F81033-1	17	
14	NUT, M12-8 HEX NYLON ZINC LOCK	F81034-2	20	
15	NUT, M16-5.8 HEX ZINC	F81036-1	8	
16	WASHER, 8.4 FLAT ZINC	F81054-1	23	
17	WASHER, 10.5 FLAT ZINC	F81055-1	34	
18	WASHER, 13 FLAT ZINC	F81056-1	40	
19	WASHER, 17 FLAT ZINC	F81058-1	8	

**1.42 Cross Roller Table, SLPCRT**



REF.	DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)	PART #	QTY
	<b>HR CROSS ROLLER TABLE</b>	<b>SLPCRT</b>	<b>1</b>
	COMPLETE CROSS RETURN TABLE	099648	1
1	CAP, 1540 DIA. OUTRIGGER LEG	089710	4
2	BUMPER, GRENE 70 3201 0010. SHR RUBBER	094969	2
3	FOOT ASSEMBLY, TABLE LEG	099281-1	4
4	FRAME WELDMENT, CROSS RETURN TABLE	099652-1	1
	TOP, 63.5X600 CROSS RETURN TABLE - COMPLETE	099656	1
5	ROLLER, 63.5/20X600/608/626 s=14 (EE15)	089044-1	9
6	BRACKET, 63.5X600 ROLLER MOUNTING	099649-1	1
7	PLATE, 63.5/20X600 ROLLER CLAMP	099650-1	2
8	BOLT, M8x25-8.8-B HEX HEAD FULL THREAD ZINC	F81002-5	4
9	BOLT, M10x80 -8.8 HEX HEAD ZINC	F81003-50	4
10	NUT, M8-8-B HEX NYLON ZINC LOCK	F81032-2	4
11	NUT, M10-8-B HEX NYLON ZINC LOCK	F81033-1	4
12	WASHER, 8.4 FLAT ZINC	F81054-1	8
13	WASHER, 10.5 FLAT ZINC	F81055-1	8
	ARM, OPENED W/RP-90 ROLLERS - COMPLETE	099679	1

**REPLACEMENT PARTS***Cross Roller Table, SLP CRT***1**

<b>14</b>	KNOB, PLASTIC CRANK HANDLE	086338	2	
	M16 BOLTS +2 NUTS	093710	2	
<b>15</b>	NUT, M16-5-B HEX	F81036-5	1	
<b>16</b>	BOLT, M16 BED RAIL ADJUSTMENT	086809	2	
<b>17</b>	BEARING, UCFL204 (COMPLEX) W/HOUSING	500060	2	
<b>18</b>	BUSHING, 21X30X10 ZINC-PLATED SPACER	099351-1	12	
<b>19</b>	ARM WELDMENT, OPENED	099680-1	1	
<b>20</b>	ROLLER, RP-90. 6304 POLYURETHANE	099689	12	
<b>21</b>	BOLT, M12x40-8.8 HEX HEAD ZINC	F81004-1	4	
<b>22</b>	BOLT, M20X100-8.8 HEX HEAD ZINC	F81007-6	2	
<b>23</b>	BOLT, M20X60-8.8 HEX HEAD ZINC	F81007-7	10	
<b>24</b>	NUT, M10-8-B HEX NYLON ZINC LOCK	F81033-1	2	
<b>25</b>	NUT, M12-8 HEX NYLON ZINC LOCK	F81034-2	4	
<b>26</b>	NUT, M20-8-A HEX NYLON ZINC LOCK	F81037-2	12	
<b>27</b>	WASHER, 13 FLAT ZINC	F81056-1	8	
<b>28</b>	WASHER, 17 FLAT ZINC	F81058-1	8	
<b>29</b>	WASHER, 21 FLAT ZINC	F81059-2	24	
<b>30</b>	PIN, 45308DNW DETENT	089939	2	
<b>31</b>	PLATE, OPENED ARM LOCK	503336-1	2	
<b>32</b>	CAP, 80x40 TUBE	099692	2	
<b>33</b>	BOLT, M8x65 8.8 HEX HEAD FULL THREAD ZINC	F81002-9	4	
<b>34</b>	NUT, M8-8-B HEX NYLON ZINC LOCK	F81032-2	4	
<b>35</b>	NUT, M16-5.8 HEX ZINC	F81036-1	8	
<b>36</b>	WASHER, 8.4 FLAT ZINC	F81054-1	8	
<b>37</b>	WASHER, 17 FLAT ZINC	F81058-1	8	

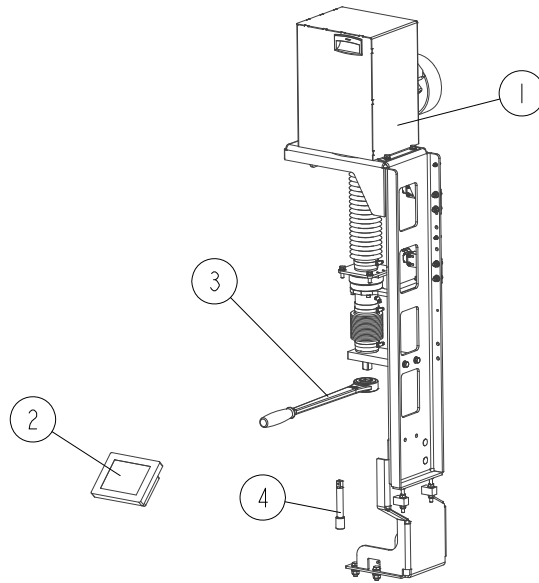
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## REPLACEMENT PARTS

Multisetwork (Option)

### 1.43 Multisetwork (Option)

511796\_001\_A  
511796\_Manual



REF.	DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)	PART #	QTY					
	<b>MULTISETWORK, HR500-1</b>	<b>511796</b>	x	-	-	-	-	-
	<b>MULTISETWORK, HR500-2</b>	<b>511797</b>	-	x	-	-	-	-
	<b>MULTISETWORK, HR500-3</b>	<b>511798</b>	-	-	x	-	-	-
	<b>MULTISETWORK, HR500-4</b>	<b>511799</b>	-	-	-	x	-	-
	<b>MULTISETWORK, HR500-5</b>	<b>511800</b>	-	-	-	-	x	-
	<b>MULTISETWORK, HR500-6</b>	<b>511801</b>	-	-	-	-	-	x
1	DRIVE ASSEMBLY, HR500 UP/DOWN - COMPLETE <a href="#">See Section 1.44</a>	515190	1	2	3	4	5	6
2	SCREEN, HMISTU855 TOUCH	508978	1	1	1	1	1	1
3	WRENCH, 3/4" RATCHET	507312	1	1	1	1	1	1
4	EXTENSION 1/2"x130	518549	1	1	1	1	1	1

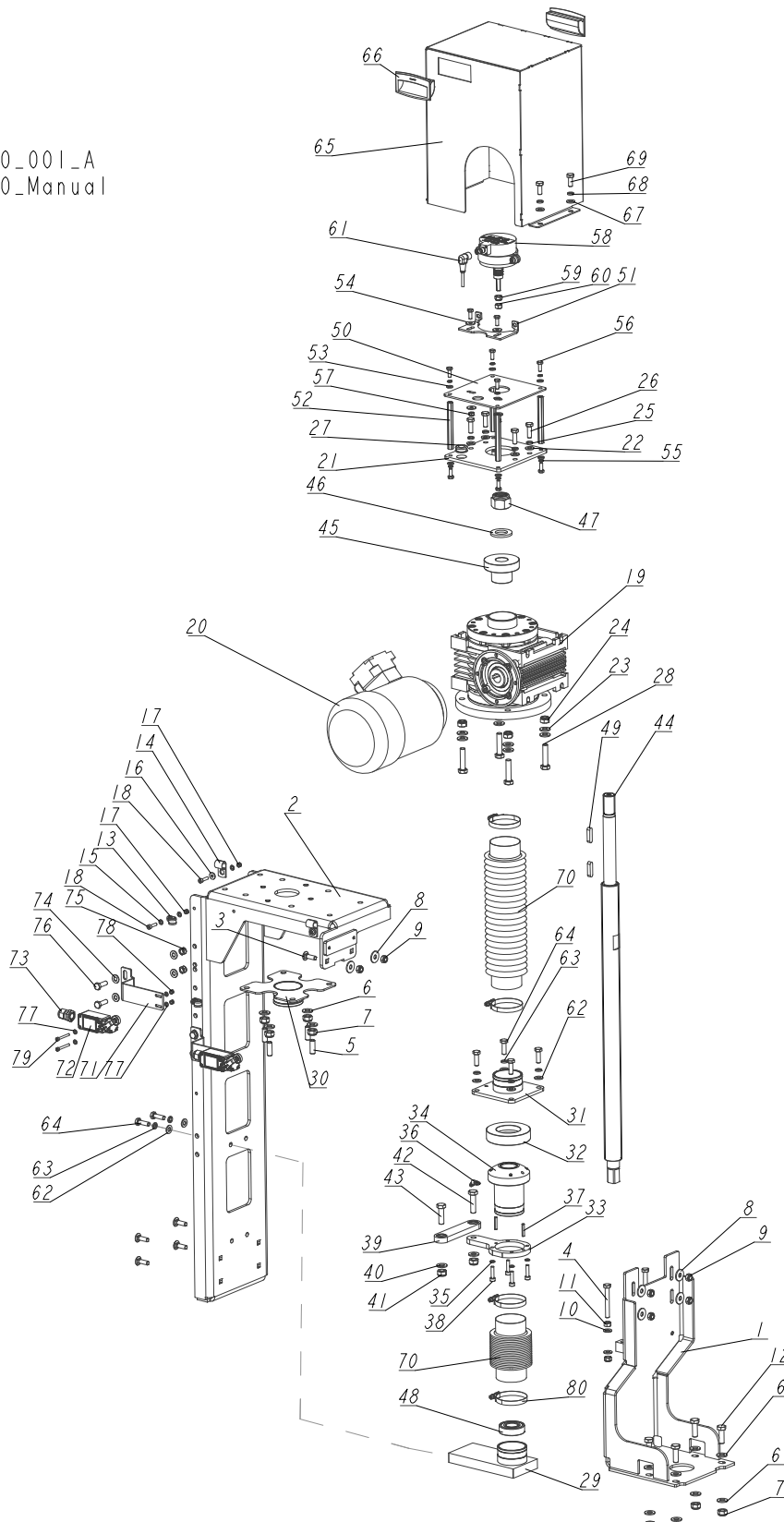
## 1.44 Up/Down Drive Assembly (Option)

# 1

## REPLACEMENT PARTS

Up/Down Drive Assembly (Option)

515190\_001\_A  
515190\_Manual



# REPLACEMENT PARTS

*Up/Down Drive Assembly (Option)*

1

REF.	DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)	PART #	QTY
	<b>DRIVE ASSEMBLY, HR500 UP/DOWN</b>	<b>515190</b>	<b>1</b>
	<b>BRACKET, HR500 UP/DOWN DRIVE MOUNT - COMPLETE</b>	<b>515189</b>	<b>1</b>
1	BRACKET, HR500 UP/DOWN DRIVE MOUNT - LOWER	515187-1	1
2	BRACKET, SHS/HR700 UP/DOWN DRIVE MOUNT - UPPER	515155-1	1
3	BOLT, M8X25-8.8 CARRIAGE HEAD ZINC	F81002-59	6
4	BOLT, M8X65 8.8 HEX HEAD FULL THREAD ZINC	F81002-9	2
5	SCREW, M10X30-33H-GEOMET HEX SOCKET SET W/FLAT POINT	F81003-35	4
6	WASHER, 10.5 FLAT ZINC	F81055-1	12
7	NUT, M10-8-B HEX NYLON ZINC LOCK	F81033-1	8
8	WASHER, ISO 7093-1-8-200 HV-A2E.	F81054-11	6
9	NUT, M8 8 HEX NYLON ZINC LOCK	F81032-2	8
10	WASHER, 8.4 FLAT ZINC	F81054-1	4
11	NUT, M8-8-B HEX ZINC	F81032-1	2
12	BOLT, M10X30 5.8 HEX HEAD FULL THREAD ZINC	F81003-2	4
13	CLAMP, RSGU 1.10/12W1 METAL & RUBBER	086861	2
14	CLAMP, 1/2" EMT COATED	P07584	2
15	WASHER, 5.3 FLAT ZINC	F81052-1	7
16	WASHER, 5.5 SPECIAL FLAT ZINC	F81052-3	2
17	NUT, M5-8-FE/ZN5 DIN985	F81030-2	4
18	SCREW, M5X20 8.8 HEX SOCKET HEAD CAP ZINC	F81000-72	4
	<b>REDUCER, MRP-63 SHS/HR700 UP/DOWN DRIVE - COMPLETE</b>	<b>515157</b>	<b>1</b>
	<b>REDUCER, MRP-63/16[0.75-1400-120/19]-WMI-[S3=60%]-B/SO/K2/B6</b>	<b>514932</b>	<b>1</b>
19	REDUCER, MRP-63/16 [120/19]SO/K2/B6	514933	1
20	MOTOR, SKH 80-4B2/3045 (N=0.75 kW, N=1380 r.p.m.) INDUCTION	514934	1
21	PLATE, ENCODER MOUNT	515149-1	1
22	WASHER, 8.4 FLAT ZINC	F81054-1	4
23	WASHER, 10.5 FLAT ZINC	F81055-1	8
24	NUT, M10-8-B HEX NYLON ZINC LOCK	F81033-1	4
25	WASHER, 8.2 SPLIT LOCK ZINC	F81054-4	4
26	BOLT, M8X25-8.8-B HEX HEAD FULL THREAD ZINC	F81002-5	4
27	GROMMET, 20/13 RUBBER	086188	1
28	BOLT, M10X45 HEX HEAD FULL THREAD ZINC	F81003-3	4
29	BRACKET, UP/DOWN SCREW BELLOWS - LOWER	514935-1	1
30	BRACKET, UP/DOWN SCREW BELLOWS - UPPER	514915-1	1
31	BRACKET, UP/DOWN SCREW BELLOWS - MIDDLE	514919-1	1
32	WASHER, 90X50X20 SPHERICAL ZINC-PLATED SEAT	514898-1	1
	<b>NUT, TR36X3 UP/DOWN SCREW - COMPLETE</b>	<b>515138</b>	<b>1</b>
33	PLATE, TR36X3 NUT ZINC-PLATED SEAT	515143-1	1
34	NUT, TR36X3 UP/DOWN SCREW	514899	1
35	WASHER, Z 6.1 SPLIT LOCK ZINC	F81053-3	4
36	FITTING, M6 PN/M-86003 GREASE	094213	1
37	PIN, 5X26 ROLL ZINC	F81044-2	2
38	SCREW, M6X25-8.8 HEX SOCKET HEAD CAP ZINC	F81001-41	4
39	LINK, SBPL 10104 PIVOTAL (COMPLEX)	097700	1

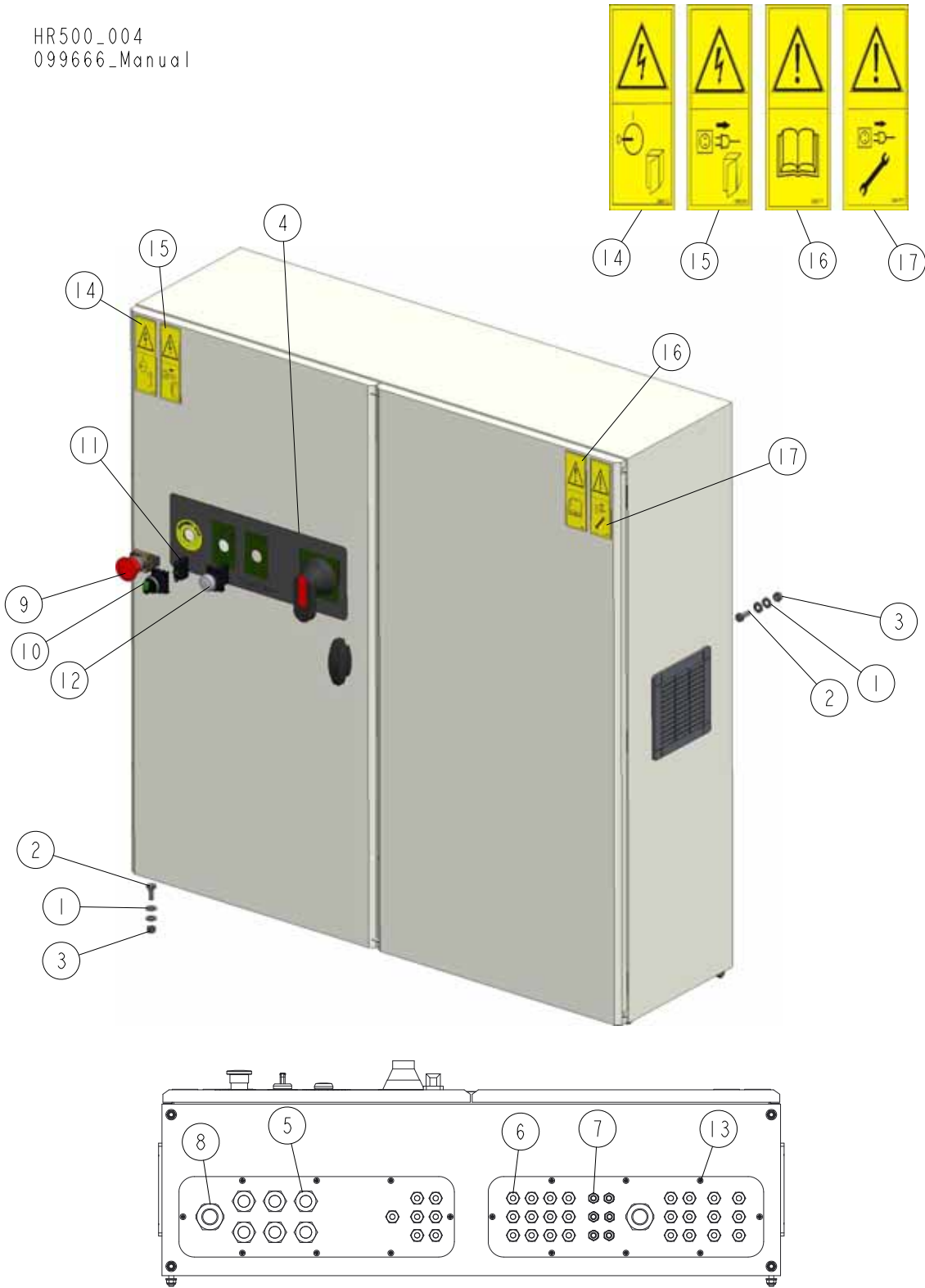
**REPLACEMENT PARTS***Up/Down Drive Assembly (Option)*

REF.	DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)	PART #	QTY
40	WASHER, 10.5 FLAT ZINC	F81055-1	2
41	NUT, M10-8-B HEX NYLON ZINC LOCK	F81033-1	2
42	BOLT, M10X40-8.8 HEX HEAD FULL THREAD ZINC	F81003-16	1
43	BOLT, M10X35 8.8 HEX HEAD FULL THREAD ZINC	F81003-17	1
44	BALLSCREW, TR36X3 HR500 ZINC-PLATED	515234-1	1
45	CAP, MRP-63 MOTOREDUCER ZINC-PLATED	515144-1	1
46	WASHER, 25 FLAT ZINC	F81061-3	1
47	NUT, M24X2 PN-EN ISO 7040 NYLON	F81039-10	1
48	BEARING, 6205 2RSR P6 (FAG,NSK,SKF) BALL	087353	1
49	KEY, A8X7X32 PARALLEL	088564	2
	<b>ENCODER ASSEMBLY, SHS/HR700</b>	<b>515147</b>	<b>1</b>
50	PLATE, ENCODER MOUNT	515148-1	1
51	BRACKET, ENCODER	507372-1	1
52	SPACER, M6X100- BN3319 (BOSSARD)	F81031-10	4
53	WASHER, 6.4 FLAT ZINC	F81053-1	8
54	WASHER, 6.5 SPECIAL FLAT ZINC	F81053-11	4
55	WASHER, Z 6.1 SPLIT LOCK ZINC	F81053-3	8
56	BOLT, M6X16-8.8 HEX HEAD FULL THREAD ZINC	F81001-15	10
57	NUT, M6-8-B HEX NYLON ZINC LOCK	F81031-2	2
58	ENCODER, 48 IMP./TURN 12V DC INCREMENTAL	510285	1
59	NUT, M8 8 HEX NYLON ZINC LOCK	F81032-2	1
60	NUT, M8-8-B HEX ZINC	F81032-1	1
61	CABLE, 5 M LIMIT SWITCH	087652	1
62	WASHER, 8.4 FLAT ZINC	F81054-1	6
63	WASHER, 8.2 SPLIT LOCK ZINC	F81054-4	6
64	BOLT, M8X25-8.8-B HEX HEAD FULL THREAD ZINC	F81002-5	6
	<b>GUARD, SHS/HR700 UP/DOWN DRIVE - COMPLETE</b>	<b>515151</b>	<b>1</b>
65	GUARD, SHS/HR700 UP/DOWN DRIVE	515152-1	1
66	HANDLE, EPR.90-PF-C1(261051-C1) SNAP-IN FLUSH PULL	100012	2
67	WASHER, 8.4 FLAT ZINC	F81054-1	4
68	WASHER, 8.2 SPLIT LOCK ZINC	F81054-4	4
69	BOLT, M8X20 8.8 HEX HEAD FULL THREAD ZINC	F81002-4	4
70	BELLOWS, 60/520 PROTECTIVE	514918	2
	<b>SWITCH ASSEMBLY, LIMIT</b>	<b>515141</b>	<b>2</b>
71	BRACKET, LIMIT SWITCH MOUNT	515142-1	1
72	SWITCH, GLCB01A1B LIMIT	100931	1
73	GLAND, DP9/H CABLE	F81096-2	1
74	WASHER, 8.4 FLAT ZINC	F81054-1	4
75	NUT, M8 8 HEX NYLON ZINC LOCK	F81032-2	2
76	BOLT, M8X25-8.8-B HEX HEAD FULL THREAD ZINC	F81002-5	2
77	WASHER, 4.3 FLAT ZINC	F81051-2	4
78	NUT, M4-8 HEX NYLON ZINC LOCK	F81029-1	2
79	SCREW, M4X35 8.8 HEX SOCKET HEAD CAP ZINC	F81011-34	2
80	CLAMP, 50-70 DIN 3017 WORM	F81095-6	4



**1.45 Electric Box**

HR500\_004  
099666\_Manual



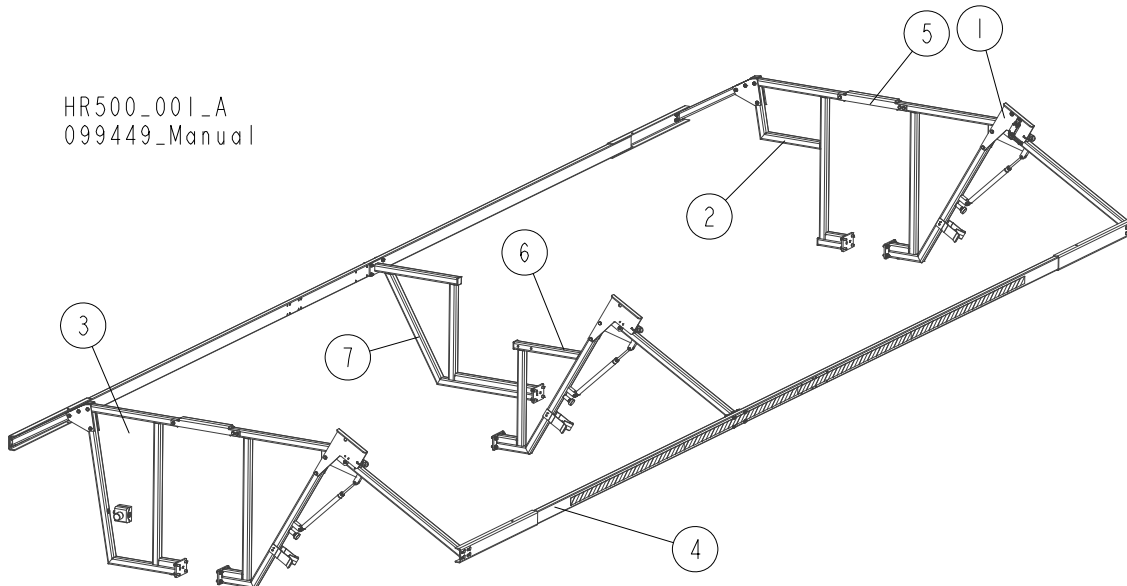
## 1

**REPLACEMENT PARTS***Electric Box*

REF.	DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)	PART #	QTY
1	WASHER, 8.4 FLAT ZINC	F81054-1	12
2	BOLT, M8X20 8.8 HEX HEAD FULL THREAD ZINC	F81002-4	6
3	NUT, M8 8 HEX NYLON ZINC LOCK	F81032-2	6
	<b>BOX, 1000X1000X300 HR500-6 ELECTRIC - COMPLETE</b>	515246	1
4	DECAL, 1000X1000X300 HR500/700 ELECTRIC BOX	515227	1
5	GLAND, DP21/H CABLE	F81096-3	6
6	GLAND, DP9/H CABLE	F81096-2	31
7	GLAND, DP 7/H CABLE	F81096-11	6
8	GLAND, PG29 CABLE	F81096-1	2
9	BUTTON, XB4 BS542 EMERGENCY STOP	086556	1
10	SWITCH, MOELLER 3-POSITION GREEN	091359	1
11	ELEMENT, M22 K10 MOELLER CONTACT	091362	1
12	LIGHT, 1SFA619402L5415 WHITE CONTROL	509129	1
13	BOLT, #10-24X1/2 PH	F05015-17	16
14	<b>HAZARDOUS VOLTAGE INSIDE THE ELECTRIC BOX (PICTOGRAM)</b>	096316	1
15	<b>DECAL, REMOVE THE PLUG BEFORE OPENING THE ELECTRIC BOX (PICTOGRAM)</b>	096319	1
16	<b>DECAL, READ THE OPERATOR'S MANUAL (PICTOGRAM)</b>	096317	1
17	<b>DECAL, DISCONNECT POWER SUPPLY BEFORE SERVICING (PICTOGRAM)</b>	098177	1

## SECTION 2 SIDE FENCE (CE VERSION ONLY)

### 2.1 Side Fence

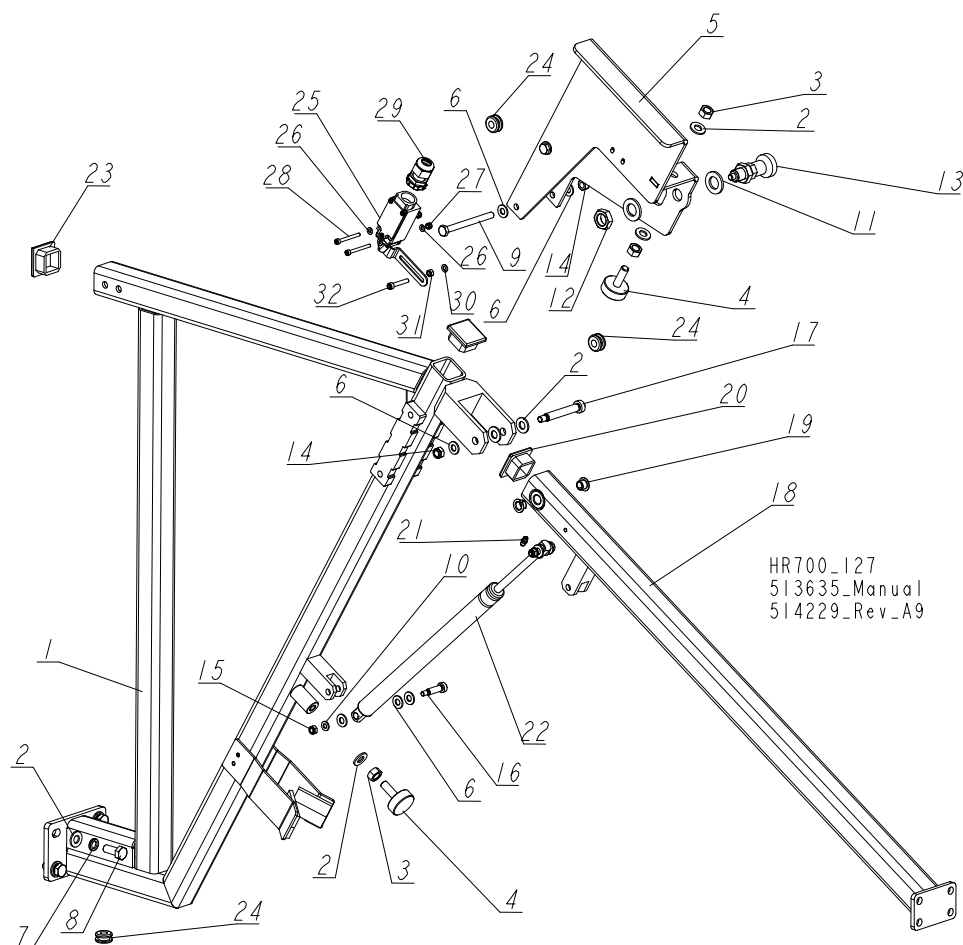


REF.	DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)	PART #	QTY
	<b>FENCE, HR500-1/HR500-2 SIDE - COMPLETE</b>	<b>099447</b>	<b>1/0/0</b>
	<b>FENCE, HR500-3/HR500-4 SIDE - COMPLETE</b>	<b>099448</b>	<b>0/1/0</b>
	<b>FENCE, HR500-5/HR500-6 SIDE - COMPLETE</b>	<b>099449</b>	<b>0/0/1</b>
1	BRACKET, MOVING SIDE FENCE SUPPORT - COMPLETE <a href="#">See Section 2.2</a>	514229	2
2	BRACKET, FIXED SIDE FENCE SUPPORT - COMPLETE <a href="#">See Section 2.3</a>	515211	1
3	BRACKET, FIXED SIDE FENCE SUPPORT - COMPLETE <a href="#">See Section 2.5</a>	514365	1
4	BARRIER, HR700-1/HR700-2 SIDE FENCE - COMPLETE <a href="#">See Section 2.6</a>	514367	2/0/0
	BARRIER, HR700-3/HR700-4 SIDE FENCE - COMPLETE <a href="#">See Section 2.6</a>	514366	0/2/0
	BARRIER, HR700-5/HR700-6 SIDE FENCE - COMPLETE <a href="#">See Section 2.6</a>	514215	0/0/2
5	BRACKET, CONNECTING - COMPLETE <a href="#">See Section 2.3</a>	099443	1
6	BRACKET, MOVING SIDE FENCE MIDDLE SUPPORT - COMPLETE <a href="#">See Section 2.5</a>	515197	0/0/1
7	BRACKET, FIXED SIDE FENCE MIDDLE SUPPORT - COMPLETE <a href="#">See Section 2.7</a>	515229	0/0/1

## 2 Side Fence (CE Version Only)

### Moving Side Fence Support Bracket

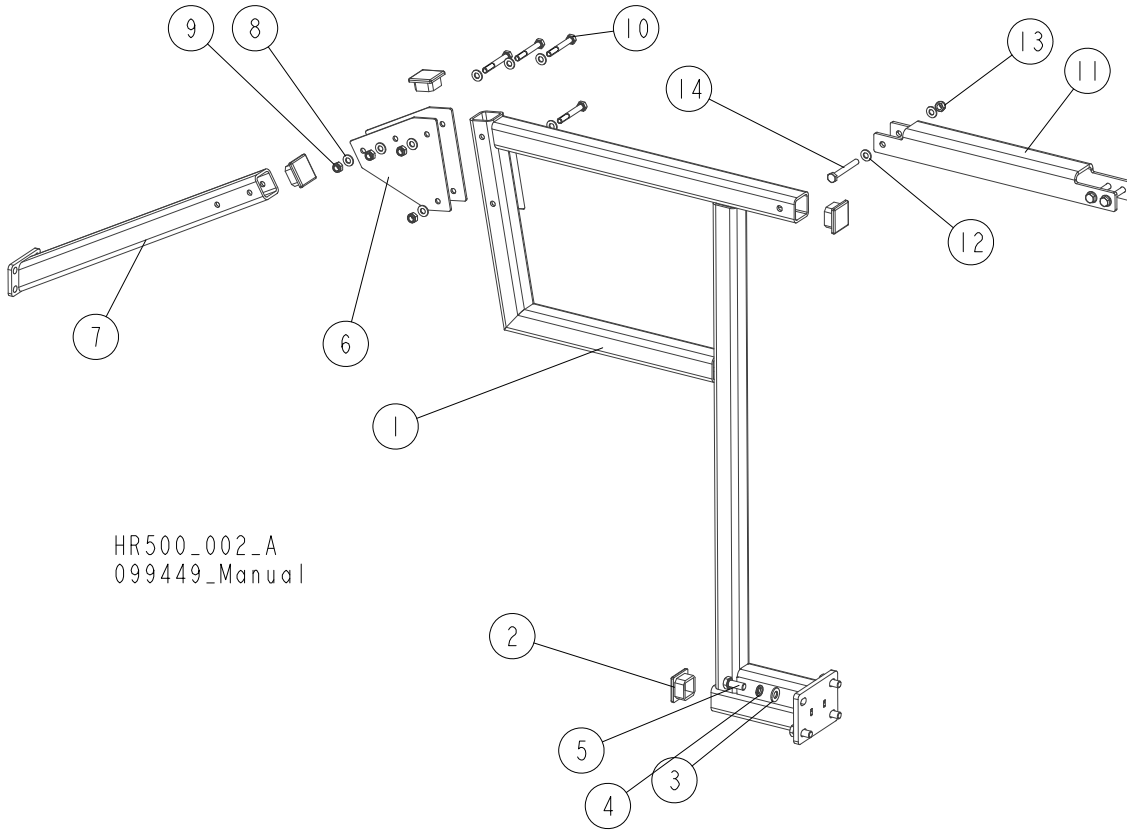
## 2.2 Moving Side Fence Support Bracket



REF.	DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)	PART #	QTY
	<b>BRACKET, MOVING SIDE FENCE SUPPORT - COMPLETE</b>	<b>514229</b>	<b>1</b>
1	BRACKET, MOVING SIDE FENCE SUPPORT	099450-1	1
2	WASHER, 10.5 FLAT ZINC	F81055-1	10
3	NUT, M10-8-B HEX ZINC	F81033-3	3
4	FOOT, M10	092839	2
5	BRACKET, LIMIT SWITCH MOUNT	099470-1	1
6	WASHER, 8.4 FLAT ZINC	F81054-1	11
7	WASHER, Z10.2 SPLIT LOCK ZINC	F81055-2	4
8	BOLT, M10X25 8.8 HEX HEAD FULL THREAD ZINC	F81003-11	4
9	BOLT, M8X90-8.8 HEX HEAD FULL THREAD ZINC	F81002-16	2
10	WASHER, 6.4 FLAT ZINC	F81053-1	2
11	WASHER, 17 SPLIT LOCK ZINC	F81058-1	2
12	NUT, M16X1.5-08-B THIN ZINC	F81036-6	1
13	PIN, 45308DNW DETENT	089939	1
14	NUT, M8-8-B HEX NYLON ZINC LOCK	F81032-2	3

REF.	DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)	PART #	QTY	
15	NUT, M6-8-B HEX NYLON ZINC LOCK	F81031-2	2	
16	BOLT, 8/M6X25-12.9 ISO 7379 SHOULDER	F81001-47	2	
17	BOLT, 10/M8X60-12.9 ISO7379/BN1359 BOSSARD SHOULDER	F81003-79	1	
	<b>ARM, SIDE FENCE MOVING - COMPLETE</b>	<b>099464</b>	<b>1</b>	
18	ARM, SIDE FENCE MOVING	099465-1	1	
19	BUSHING, TUF1 10x090 CX	099074	2	
20	CAP, 40X40X(3-4) MOSS TUBE END	097480	1	
21	FITTING, M6 PN/M-86002 GREASE	086280	1	
22	SPRING, MS10-1-1F-1F-1000-100-460 (EUROTECHNIKA) GAS	099446	1	
23	CAP, 40X40X(3-4) MOSS TUBE END	097480	2	
24	<b>GROMMET, 9.5 (3/8") ID RUBBER</b>	025248	3	
25	<b>SWITCH, XCSPL562 LIMIT</b>	534491	1	
26	<b>WASHER, 4.3 FLAT ZINC</b>	F81051-2	4	
27	<b>NUT, M4-8 HEX NYLON ZINC LOCK</b>	F81029-1	2	
28	<b>SCREW, M4X40 8.8 HEX SOCKET HEAD CAP ZINC</b>	F81011-37	2	
29	<b>GLAND, PG13.5 CABLE</b>	086524	1	
30	<b>WASHER, 5.3 FLAT ZINC</b>	F81052-1	1	
31	<b>NUT, M5-8 HEX ZINC</b>	F81030-1	1	
32	<b>SCREW, M5X30 5.8 HEX SOCKET HEAD CAP ZINC</b>	F81000-71	1	

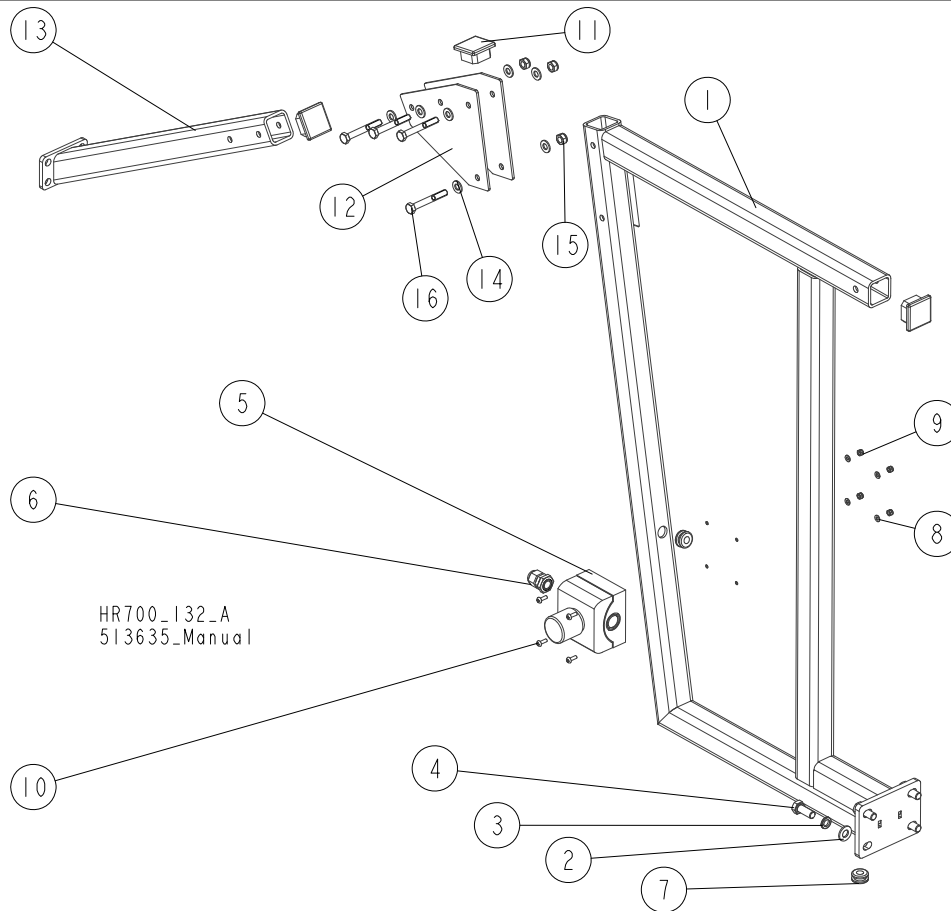
2.3 Fixed Side Fence Support Bracket & Connecting Bracket



HR500\_002\_A  
099449\_Manual

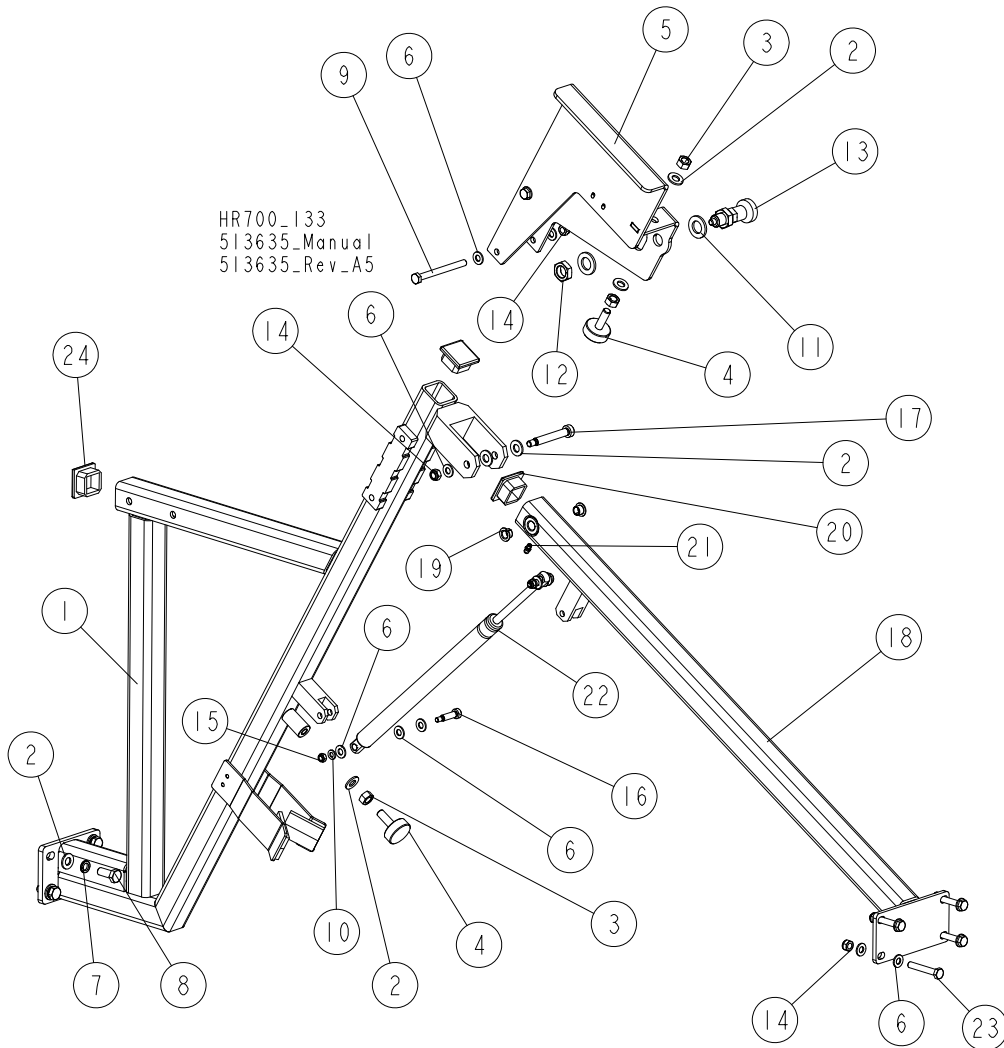
REF.	DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)	PART #	QTY
	<b>BRACKET, FIXED SIDE FENCE SUPPORT - COMPLETE</b>	<b>515211</b>	<b>1</b>
1	BRACKET, FIXED SIDE FENCE SUPPORT	515212-1	1
2	CAP, 40X40X(3-4) MOSS TUBE END	097480	3
3	WASHER, 10.5 FLAT ZINC	F81055-1	4
4	WASHER, Z 10.2 SPLIT LOCK ZINC	F81055-2	4
5	BOLT, M10X25 8.8 HEX HEAD FULL THREAD ZINC	F81003-11	4
6	PLATE, CONNECTING	099462-1	2
7	TUBE WELDMENT, SUPPORT BRACKET	518553-1	1
8	WASHER, 8.4 FLAT ZINC	F81054-1	8
9	NUT, M8-8-B HEX NYLON ZINC LOCK	F81032-2	4
10	BOLT, M8X60-8.8 HEX HEAD ZINC	F81002-54	4
	<b>BRACKET, CONNECTING - COMPLETE</b>	<b>099443</b>	<b>1</b>
11	BRACKET, CONNECTING	099476-1	1
12	WASHER, 8.4 FLAT ZINC	F81054-1	6
13	NUT, M8 8 HEX NYLON ZINC LOCK	F81032-2	3
14	BOLT, M8X65 8.8 HEX HEAD FULL THREAD ZINC	F81002-9	3

## 2.4 Fixed Side Fence Support Bracket



REF.	DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)	PART #	QTY
	<b>BRACKET, FIXED SIDE FENCE SUPPORT - COMPLETE</b>	<b>514365</b>	<b>1</b>
1	BRACKET, FIXED SIDE FENCE SUPPORT	099451-1	1
2	WASHER, 10.5 FLAT ZINC	F81055-1	4
3	WASHER, Z10.2 SPLIT LOCK ZINC	F81055-2	4
4	BOLT, M10X25 8.8 HEX HEAD FULL THREAD ZINC	F81003-11	4
5	BUTTON, M22-PV/KCO2 EMERGENCY STOP	094726	1
6	GLAND, DP9/H CABLE	F81096-2	1
7	GROMMET, 9.5 (3/8") ID RUBBER	025248	2
8	WASHER, 4.3 FLAT ZINC	F81051-2	4
9	NUT, M4-8 HEX NYLON ZINC LOCK	F81029-1	4
10	SCREW, M4X12-5.8-B CROSS RECESSED PAN HEAD ZINC	F81011-43	4
11	CAP, 40X40X(3-4) MOSS TUBE END	097480	2
12	PLATE, CONNECTING	099462-1	2
13	TUBE WELDMENT, SUPPORT BRACKET	518553-1	1
14	WASHER, 8.4 FLAT ZINC	F81054-1	8
15	NUT, M8-8-B HEX NYLON ZINC LOCK	F81032-2	4
16	BOLT, M8X60-8.8 HEX HEAD ZINC	F81002-54	4

2.5 Middle Support Bracket (Moving Side Fence)



REF.	DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)	PART #	QTY
	<b>BRACKET, MOVING SIDE FENCE MIDDLE SUPPORT - COMPLETE</b>	<b>515197</b>	<b>1</b>
1	BRACKET, MOVING SIDE FENCE MIDDLE SUPPORT	515198-1	1
2	WASHER, 10.5 FLAT ZINC	F81055-1	10
3	NUT, M10-8-B HEX ZINC	F81033-3	3
4	FOOT, M10	092839	2
5	BRACKET, LIMIT SWITCH MOUNT	099470-1	1
6	WASHER, 8.4 FLAT ZINC	F81054-1	19
7	WASHER, Z10.2 SPLIT LOCK ZINC	F81055-2	4
8	BOLT, M10X25 8.8 HEX HEAD FULL THREAD ZINC	F81003-11	4
9	BOLT, M8X90-8.8 HEX HEAD FULL THREAD ZINC	F81002-16	2
10	WASHER, 6.4 FLAT ZINC	F81053-1	2
11	WASHER, 17 SPLIT LOCK ZINC	F81058-1	2
12	NUT, M16X1.5-08-B THIN ZINC	F81036-6	1
13	PIN, 45308DNW DETENT	089939	1

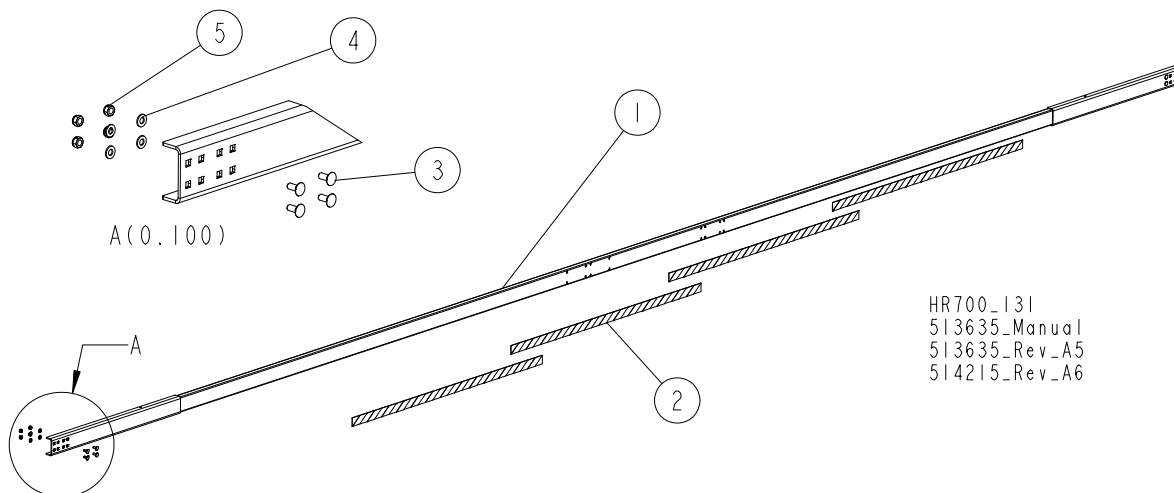


**Side Fence (CE Version Only)**  
*Middle Support Bracket (Moving Side Fence)*

**2**

REF.	DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)	PART #	QTY	
14	NUT, M8-8-B HEX NYLON ZINC LOCK	F81032-2	7	
15	NUT, M6-8-B HEX NYLON ZINC LOCK	F81031-2	2	
16	BOLT, 8/M6X25-12.9 ISO 7379 SHOULDER	F81001-47	2	
17	BOLT, 10/M8X60-12.9 ISO7379/BN1359 BOSSARD SHOULDER	F81003-79	1	
	<b>ARM, MIDDLE MOVING - COMPLETE</b>	<b>515204</b>	<b>1</b>	
18	ARM, MIDDLE MOVING	515205-1	1	
19	BUSHING, TUF1 10x090 CX	099074	2	
20	CAP, 40X40X(3-4) MOSS TUBE END	097480	1	
21	FITTING, M6 PN/M-86002 GREASE	086280	1	
22	SPRING, MS10-1-1F-1F-1000-100-460 (EUROTECHNIKA) GAS	099446	1	
23	BOLT, M8X50-8.8 HEX HEAD FULL THREAD ZINC	F81002-19	4	
24	CAP, 40X40X(3-4) MOSS TUBE END	097480	2	

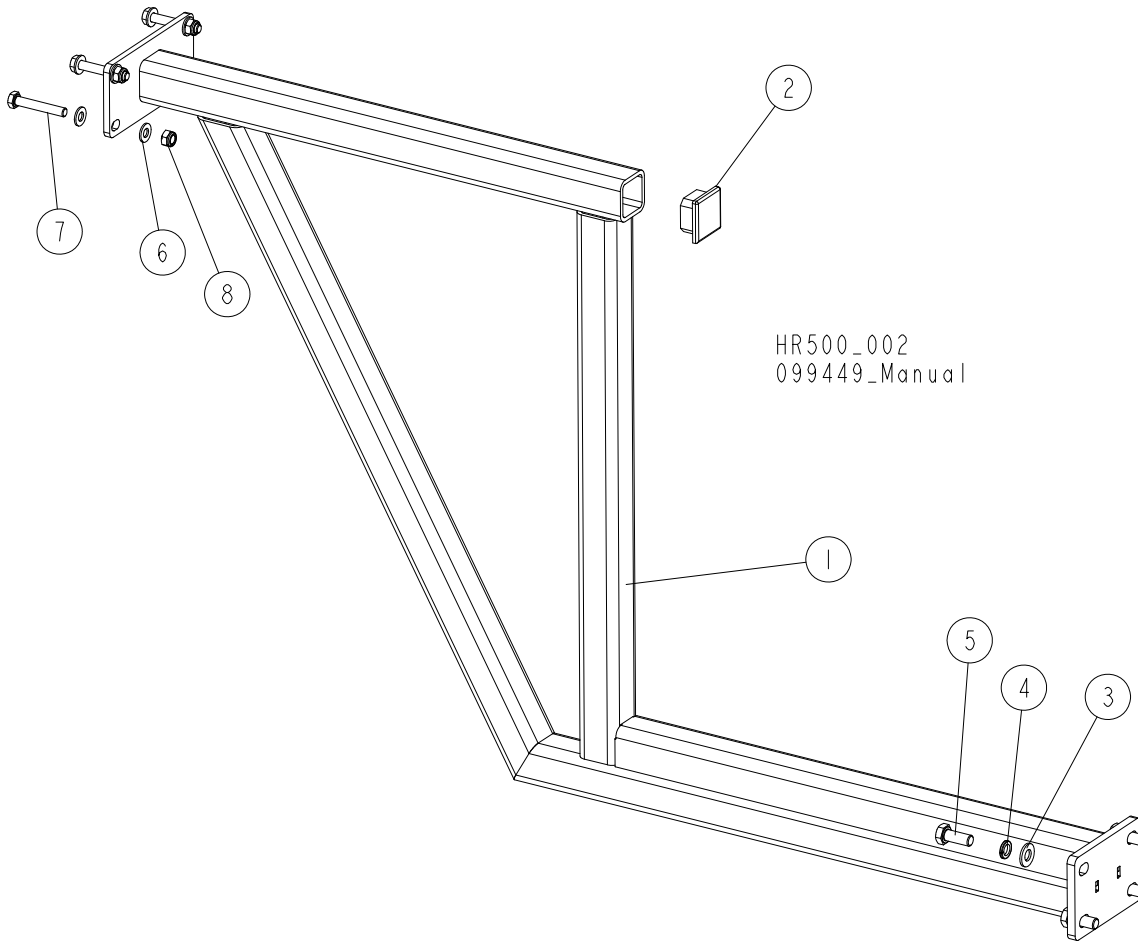
## 2.6 Side Fence Barriers



HR700\_131  
 513635\_Manual  
 513635\_Rev\_A5  
 514215\_Rev\_A6

REF.	DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)	PART #	QTY
	<b>BARRIER, HR700-1/HR700-2 SIDE FENCE - COMPLETE</b>	<b>514367</b>	<b>1/0/0</b>
	<b>BARRIER, HR700-3/HR700-4 SIDE FENCE - COMPLETE</b>	<b>514366</b>	<b>0/1/0</b>
	<b>BARRIER, HR700-5/HR700-6 SIDE FENCE - COMPLETE</b>	<b>514215</b>	<b>0/0/1</b>
1	BARRIER, HR700-1/HR700-2 SIDE FENCE	514359-1	1/0/0
	BARRIER, HR700-3/HR700-4 SIDE FENCE	514218-1	0/1/0
	BARRIER, HR700-5/HR700-6 SIDE FENCE	514216-1	0/0/1
2	DECAL, SAFETY WARNING (BLACK & YELLOW)	099368	1/2/4
3	BOLT, M8X20-8.8 CARRIAGE HEAD ZINC	F81002-11	8
4	WASHER, 8.4 FLAT ZINC	F81054-1	8
5	NUT, M8-8-B HEX NYLON ZINC LOCK	F81032-2	8

## 2.7 Middle Support Bracket (Fixed Side Fence)

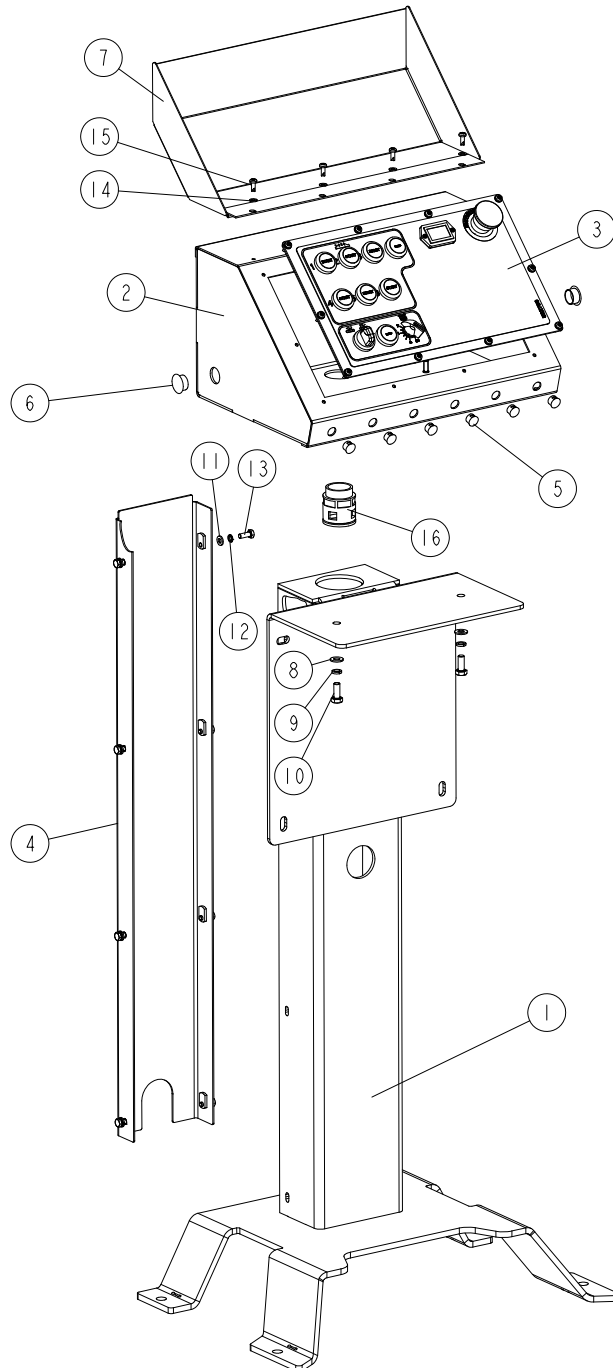


REF.	DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)	PART #	QTY
	<b>BRACKET, FIXED SIDE FENCE MIDDLE SUPPORT - COMPLETE</b>	<b>515229</b>	<b>1</b>
1	BRACKET, FIXED SIDE FENCE MIDDLE SUPPORT	515230-1	1
2	CAP, 40X40X(3-4) MOSS TUBE END	097480	1
3	WASHER, 10.5 FLAT ZINC	F81055-1	4
4	WASHER, Z 10.2 SPLIT LOCK ZINC	F81055-2	4
5	BOLT, M10X25 8.8 HEX HEAD FULL THREAD	F81003-31	4
6	WASHER, 8.4 FLAT ZINC	F81054-1	8
7	BOLT, M8X50-8.8 HEX HEAD FULL THREAD ZINC	F81002-19	4
8	NUT, M8-8-B HEX NYLON ZINC LOCK	F81032-2	4

## SECTION 3 CONTROL BOX

### 3.1 Control Box

522770\_001  
522770\_MANUAL



REF.	DESCRIPTION (* Indicates Parts Available in Assemblies Only )	PART NO.	QTY	
	BOX, HR500-1/700-1 CONTROL - COMPLETE	522760	1	
	BOX, HR500-2/700-2 CONTROL - COMPLETE	522762	1	
	BOX, HR500-3/700-3 CONTROL - COMPLETE	522764	1	

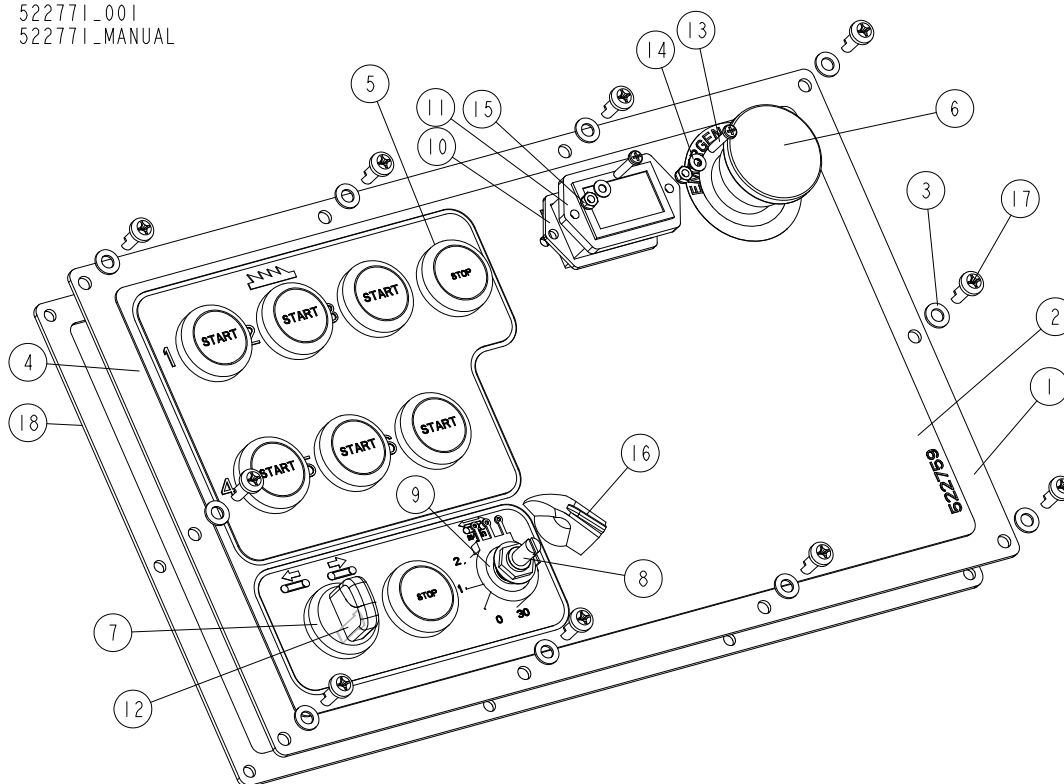
REF.	DESCRIPTION (* Indicates Parts Available in Assemblies Only )	PART NO.	QTY	
	<b>BOX, HR500-4/700-4 CONTROL - COMPLETE</b>	<b>522766</b>	<b>1</b>	
	<b>BOX, HR500-5/700-5 CONTROL - COMPLETE</b>	<b>522768</b>	<b>1</b>	
-	<b>BOX, HR500-6/700-6 CONTROL - COMPLETE</b>	<b>522770</b>	<b>1</b>	
1	PEDESTAL, CONTROL BOX	505555-1	1	
2	BOX WELDMENT	510061-1	1	
3	PANEL, HR500-6/700-6 FRONT CONTROL - COMPLETE <a href="#">See Section 3.2</a>	522771	1	
	PANEL, HR500-1/700-1 FRONT CONTROL - COMPLETE <a href="#">See Section 3.2</a>	522761		
	PANEL, HR500-2/700-2 FRONT CONTROL - COMPLETE <a href="#">See Section 3.2</a>	522763		
	PANEL, HR500-3/700-3 FRONT CONTROL - COMPLETE <a href="#">See Section 3.2</a>	522765		
	PANEL, HR500-4/700-4 FRONT CONTROL - COMPLETE <a href="#">See Section 3.2</a>	522767		
	PANEL, HR500-5/700-5 FRONT CONTROL - COMPLETE <a href="#">See Section 3.2</a>	522769		
4	PLATE, WM1000 PEDESTAL REAR	504499-1	1	
5	CAP, HEYMAN DP-812 12.7 HOLE	086773	6	
6	CAP, SR1086 22.2 HOLE	093544	2	
7	COVER, CONTROL BOX - COMPLETE	097135-1	1	
8	WASHER, 8.4 FLAT ZINC	F81054-1	2	
9	WASHER, 8.2 SPLIT LOCK ZINC	F81054-4	2	
10	BOLT, M8X20 8.8 HEX HEAD FULL THREAD ZINC	F81002-4	2	
11	WASHER, 6.4 FLAT ZINC	F81053-1	8	
12	WASHER, Z6.1 SPLIT LOCK ZINC	F81053-3	8	
13	BOLT, M6X16-8.8 HEX HEAD FULL THREAD ZINC	F81001-15	8	
14	WASHER, 5.3 FLAT ZINC	F81052-1	4	
15	BOLT, #10-24X1/2 PH PAN HEAD, TYPE 23	F05015-17	4	
16	GLAND, KCLICK-GP29 RILL 29 CONDUIT	086576	1	

# 3 Control Box

## Front Control Panel

### 3.2 Front Control Panel

522771\_001  
522771\_MANUAL



REF.	DESCRIPTION (* Indicates Parts Available in Assemblies Only )	PART NO.	QTY
	PANEL, HR500-1/700-1 FRONT CONTROL - COMPLETE	522761	1
	PANEL, HR500-2/700-2 FRONT CONTROL - COMPLETE	522763	1
	PANEL, HR500-3/700-3 FRONT CONTROL - COMPLETE	522765	1
	PANEL, HR500-4/700-4 FRONT CONTROL - COMPLETE	522767	1
	PANEL, HR500-5/700-5 FRONT CONTROL - COMPLETE	522769	1
-	PANEL, HR500-6/700-6 FRONT CONTROL - COMPLETE	522771	1
1	PANEL, HR500/700 FRONT CONTROL	521655-1	1
2	DECAL, HR500/700 CONTROL BOX	522759	1
3	WASHER, 5.3 FLAT ZINC	F81052-1	10
4	BUTTON, M22 24V GREEN ILLUMINATED START	090925	6
5	BUTTON, M22 RED STOP	090926	2
6	BUTTON, XB4 BS542 EMERGENCY STOP	086556	1
7	SWITCH, M22 3-POSITION GREEN ILLUMINATED	091359	1
8	POTENTIOMETER, 5K 53C35K	504389	1
9	WASHER, 1/2"X3/4"X 5/8" NYLON	P05251-1	1
10	GASKET, HOUR METER	093346	1
11	METER, HOUR (HOBBS-HONEYWELL)	093166	1
12	ADAPTER, M22-XC-Y CODING	092687	1
13	SCREW, M3X16 5.8-B CROSS RECESSED PAN HEAD ZINC	F81028-3	2
14	WASHER, 3.2 FLAT ZINC	F81050-2	2
15	NUT, M3-6 HEX NYLON ZINC LOCK	F81028-2	2
16	KNOB, SPEED CONTROL	P06257	1

REF.	DESCRIPTION (* Indicates Parts Available in Assemblies Only )	PART NO.	QTY	
17	BOLT, #10-24X1/2 PH	F05015-17	10	
18	GASKET, CONTROL BOX	097132	1	

# 4

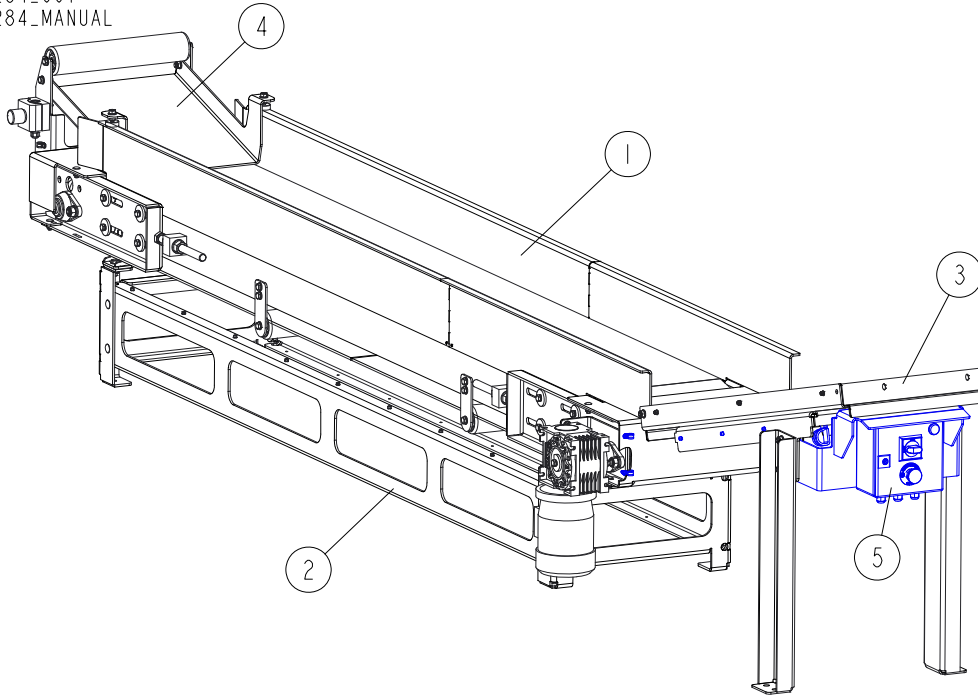
## Return Conveyors (Option)

Return Conveyor, HR500-1/HR700-1/HR500-2/HR700-2

### SECTION 4 RETURN CONVEYORS (OPTION)

#### 4.1 Return Conveyor, HR500-1/HR700-1/HR500-2/HR700-2

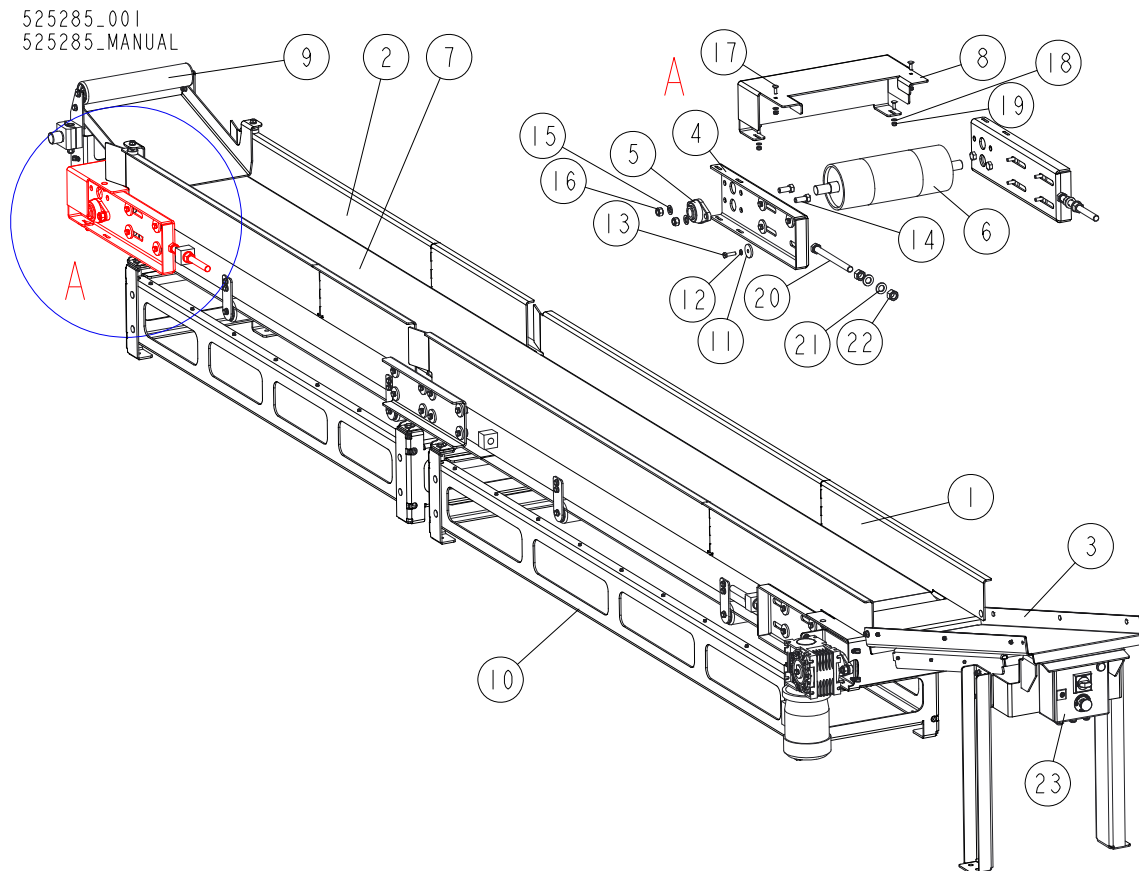
525284\_001  
525284\_MANUAL



REF.	DESCRIPTION (* indicates parts available in assemblies only)	PART NO.	QTY
-	RETURN CONVEYOR, HR500-1/HR700-1/HR500-2/HR700-2 - COMPLETE	525284	1
1	CONVEYOR, HR500/HR700 MAIN RETURN - COMPLETE <a href="#">See Section 4.5</a>	522740	1
2	BASE, MAIN RETURN CONVEYOR - COMPLETE <a href="#">See Section 4.7</a>	525298	1
3	TABLE, REAR INCLINE - COMPLETE <a href="#">See Section 4.8</a>	522741	1
4	ROLLER, FRONT - COMPLETE <a href="#">See Section 4.9</a>	522755	1
5	BOX, ELECTRIC <a href="#">See Section 4.10</a>	525316	1



## 4.2 Return Conveyor, HR500-3/HR700-3/HR500-4/HR700-4



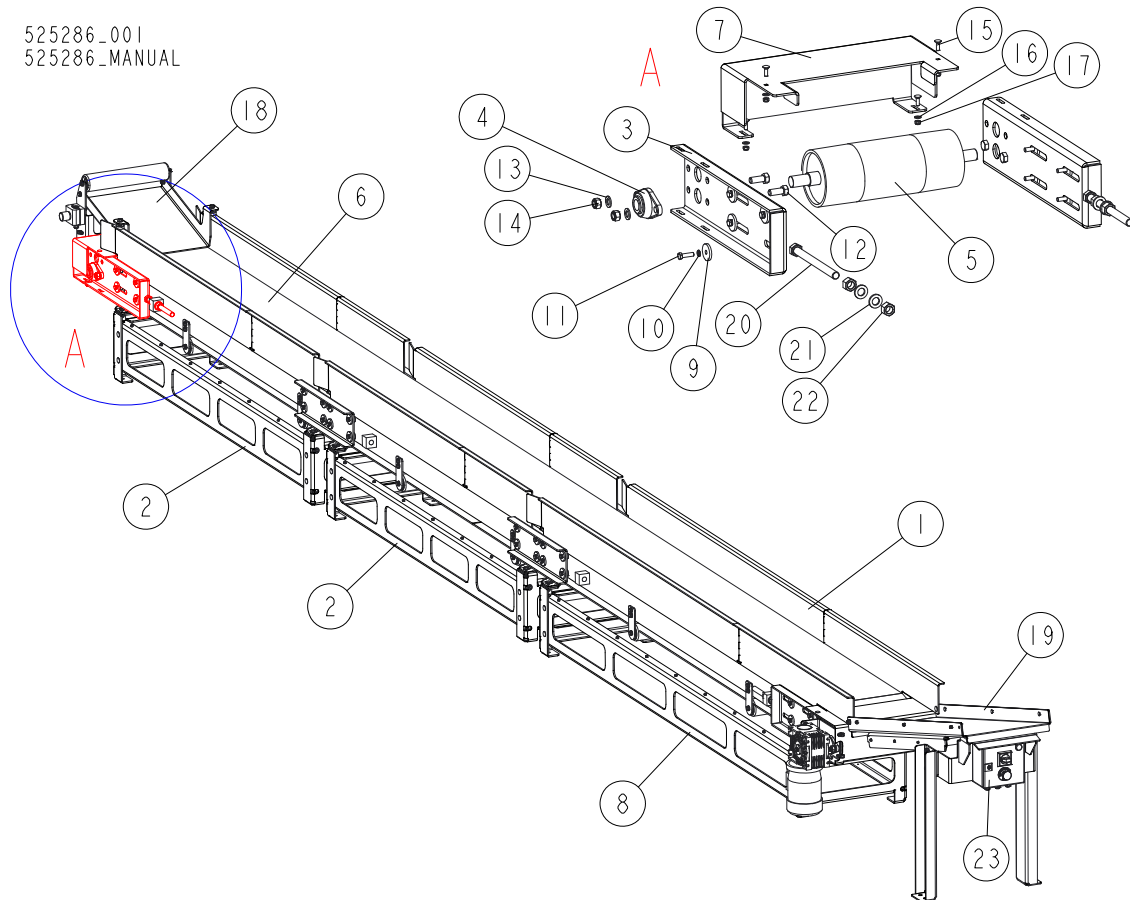
REF.	DESCRIPTION (* indicates parts available in assemblies only)	PART NO.	QTY
-	CONVEYOR, HR500-3/HR700-3/HR500-4/HR700-4 RETURN - COMPLETE	525285	1
1	CONVEYOR, HR500/HR700 MAIN RETURN <a href="#">See Section 4.6</a>	525295	1
2	EXTENSION, RETURN CONVEYOR TABLE - COMPLETE <a href="#">See Section 4.4</a>	525288	1
3	TABLE, REAR INCLINE - COMPLETE <a href="#">See Section 4.8</a>	522741	1
4	BRACKET, HR110/115 PULLEY MOUNT	504133-1	2
5	BEARING, UCFL 206 (CX) BALL	090851	2
6	PULLEY WELDMENT, HR110/115 IDLE SIDE	503776-1	1
7	BELT, L=11300 B=380	525296	1
8	GUARD, HR110/115 BELT RIGHT	504134-1	1
9	ROLLER, FRONT - COMPLETE <a href="#">See Section 4.9</a>	522755	1
10	BASE, MAIN RETURN CONVEYOR - COMPLETE <a href="#">See Section 4.7</a>	525298	1
11	WASHER, 10.5/45-6 ZINC-PLATED	086286-1	8
12	WASHER, Z 10.2 SPLIT LOCK ZINC	F81055-2	8
13	BOLT, M10X35 8.8 HEX HEAD FULL THREAD ZINC	F81003-17	8
14	BOLT, M16X40-8.8 HEX HEAD FULL THREAD ZINC	F81006-13	4
15	WASHER, 17 SPLIT LOCK ZINC	F81058-1	4
16	NUT, M16-8 HEX NYLON ZINC LOCK	F81036-2	4
17	BOLT, M8X25-8.8 CARRIAGE ZINC	F81002-59	4
18	WASHER, 8.4 FLAT ZINC	F81054-1	4
19	NUT, M8-8-B HEX NYLON ZINC LOCK	F81032-2	4
20	BOLT, M20X240-8.8 HEX HEAD FULL THREAD ZINC	F81007-1	2

**4****Return Conveyors (Option)***Return Conveyor, HR500-3/HR700-3/HR500-4/HR700-4*

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REF.	DESCRIPTION (* indicates parts available in assemblies only)	PART NO.	QTY	
21	WASHER, 21 FLAT ZINC	F81059-2	4	
22	NUT, M20-8 HEX ZINC	F81037-1	4	
23	BOX, ELECTRIC <a href="#">See Section 4.10</a>	525316	1	

## 4.3 Return Conveyor, HR500-5/HR700-5/HR500-6/HR700-6



REF.	DESCRIPTION (* indicates parts available in assemblies only)	PART NO.	QTY
-	<b>RETURN CONVEYOR, HR500-5/HR700-5/HR500-6/HR700-6</b>	525286	1
1	CONVEYOR, HR500/HR700 MAIN RETURN <a href="#">See Section 4.6</a>	525295	1
2	EXTENSION, RETURN CONVEYOR TABLE - COMPLETE <a href="#">See Section 4.4</a>	525288	2
3	BRACKET, HR110/115 PULLEY MOUNT	504133-1	2
4	BEARING, UCFL 206 (CX) BALL	090851	2
5	PULLEY WELDMENT, HR110/115 IDLE SIDE	503776-1	1
6	BELT, L=15650 B=380	525297	1
7	GUARD, HR110/115 BELT RIGHT	504134-1	1
8	BASE, MAIN RETURN CONVEYOR - COMPLETE <a href="#">See Section 4.7</a>	525298	1
9	WASHER, 10.5/45-6 ZINC-PLATED	086286-1	8
10	WASHER, Z 10.2 SPLIT LOCK ZINC	F81055-2	8
11	BOLT, M10X35 8.8 HEX HEAD FULL THREAD ZINC	F81003-17	8
12	BOLT, M16X40-8.8 HEX HEAD FULL THREAD ZINC	F81006-13	4
13	WASHER, 17 SPLIT LOCK ZINC	F81058-1	4
14	NUT, M16-8 HEX NYLON ZINC LOCK	F81036-2	4
15	BOLT, M8X25-8.8 CARRIAGE ZINC	F81002-59	4
16	WASHER, 8.4 FLAT ZINC	F81054-1	4
17	NUT, M8-8-B HEX NYLON ZINC LOCK	F81032-2	4
18	ROLLER, FRONT - COMPLETE <a href="#">See Section 4.9</a>	522755	1
19	TABLE, REAR INCLINE - COMPLETE <a href="#">See Section 4.8</a>	522741	1

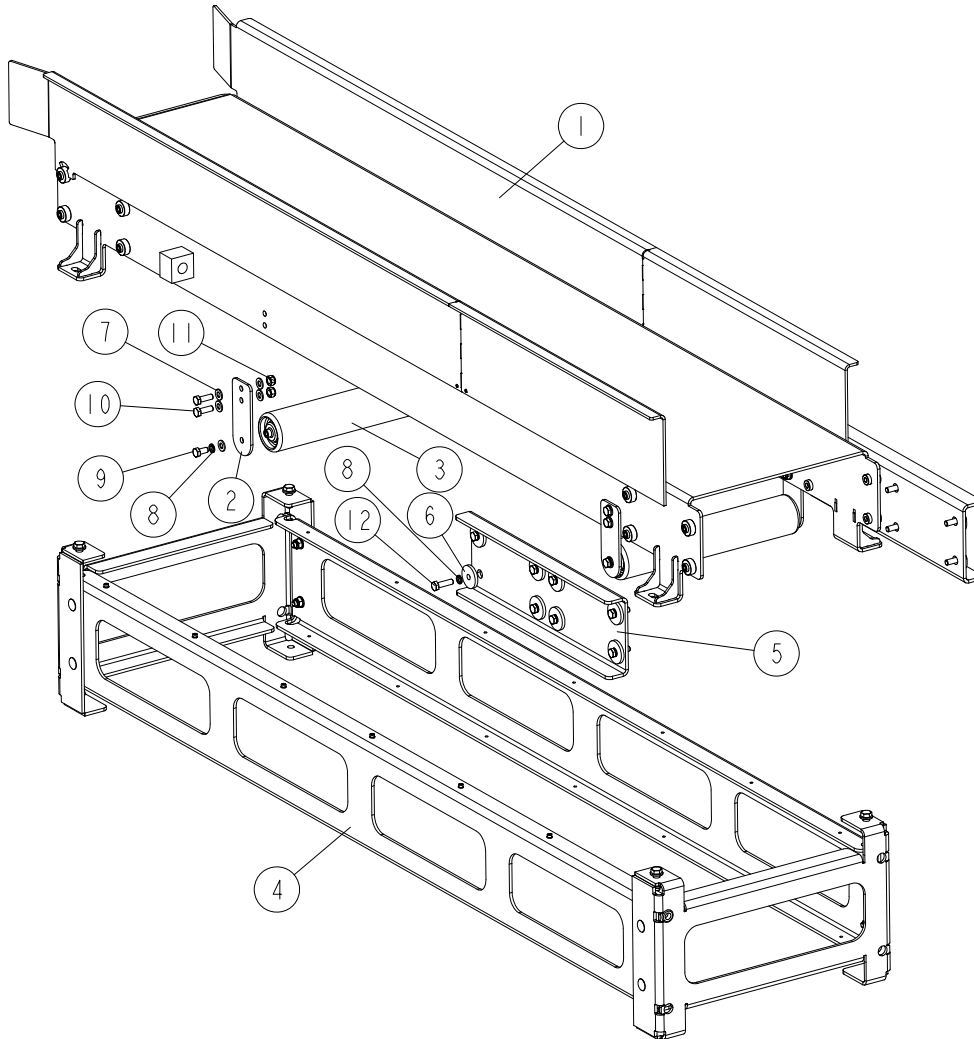
**4****Return Conveyors (Option)***Return Conveyor, HR500-5/HR700-5/HR500-6/HR700-6*

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REF.	DESCRIPTION (* indicates parts available in assemblies only)	PART NO.	QTY	
20	BOLT, M20X240-8.8 HEX HEAD FULL THREAD ZINC	F81007-1	2	
21	WASHER, 21 FLAT ZINC	F81059-2	4	
22	NUT, M20-8 HEX ZINC	F81037-1	4	
23	BOX, ELECTRIC <a href="#">See Section 4.10</a>	525316	1	

## 4.4 Return Conveyor Table Extension

525288-001  
525288-MANUAL



REF.	DESCRIPTION (* indicates parts available in assemblies only)	PART NO.	QTY
-	<b>EXTENSION, RETURN CONVEYOR TABLE - COMPLETE</b>	525288	1
1	EXTENSION, RETURN CONVEYOR	525289-1	1
2	PLATE, HR110/115 ROLLER MOUNT	503782-1	4
3	ROLLER, N76.1X400 W/M10 INTERNAL THREAD	093787	2
4	BASE, CONVEYOR TABLE EXTENSION - COMPLETE <a href="#">See Section 4.7</a>	525304	1
5	BRACKET, CONVEYOR TABLE ZINC-PLATED CONNECTION	525307-1	2
6	WASHER, 10.5/45-6 ZINC-PLATED	086286-1	16
7	WASHER, 10.5 FLAT ZINC	F81055-1	20
8	WASHER, Z 10.2 SPLIT LOCK ZINC	F81055-2	20
9	BOLT, M10X20-8.8 HEX HEAD FULL THREAD ZINC	F81003-1	4
10	BOLT, M10X30-8.8 HEX HEAD FULL THREAD ZINC	F81003-2	8
11	NUT, M10-8-BZ HEX NYLON ZINC LOCK	F81033-1	8
12	BOLT, M10X35 8.8 HEX HEAD FULL THREAD ZINC	F81003-17	16

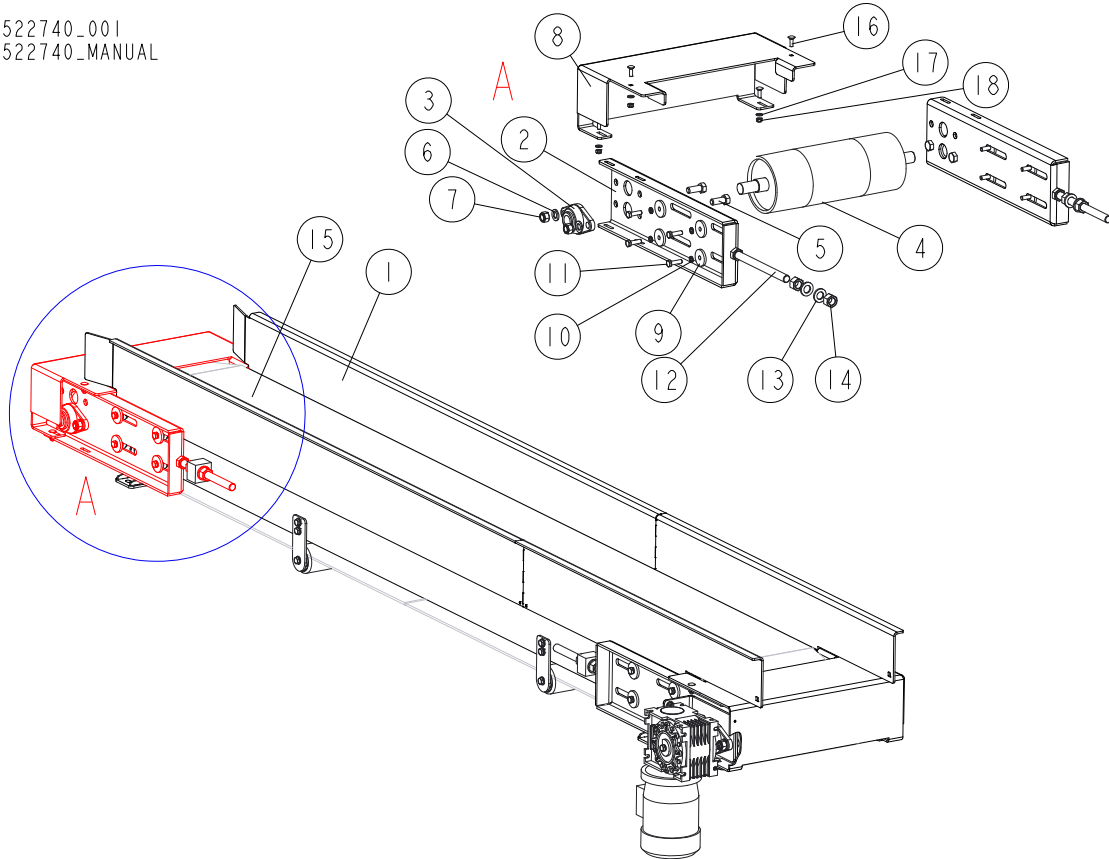
# 4

## Return Conveyors (Option)

### Main Return Conveyor

#### 4.5 Main Return Conveyor

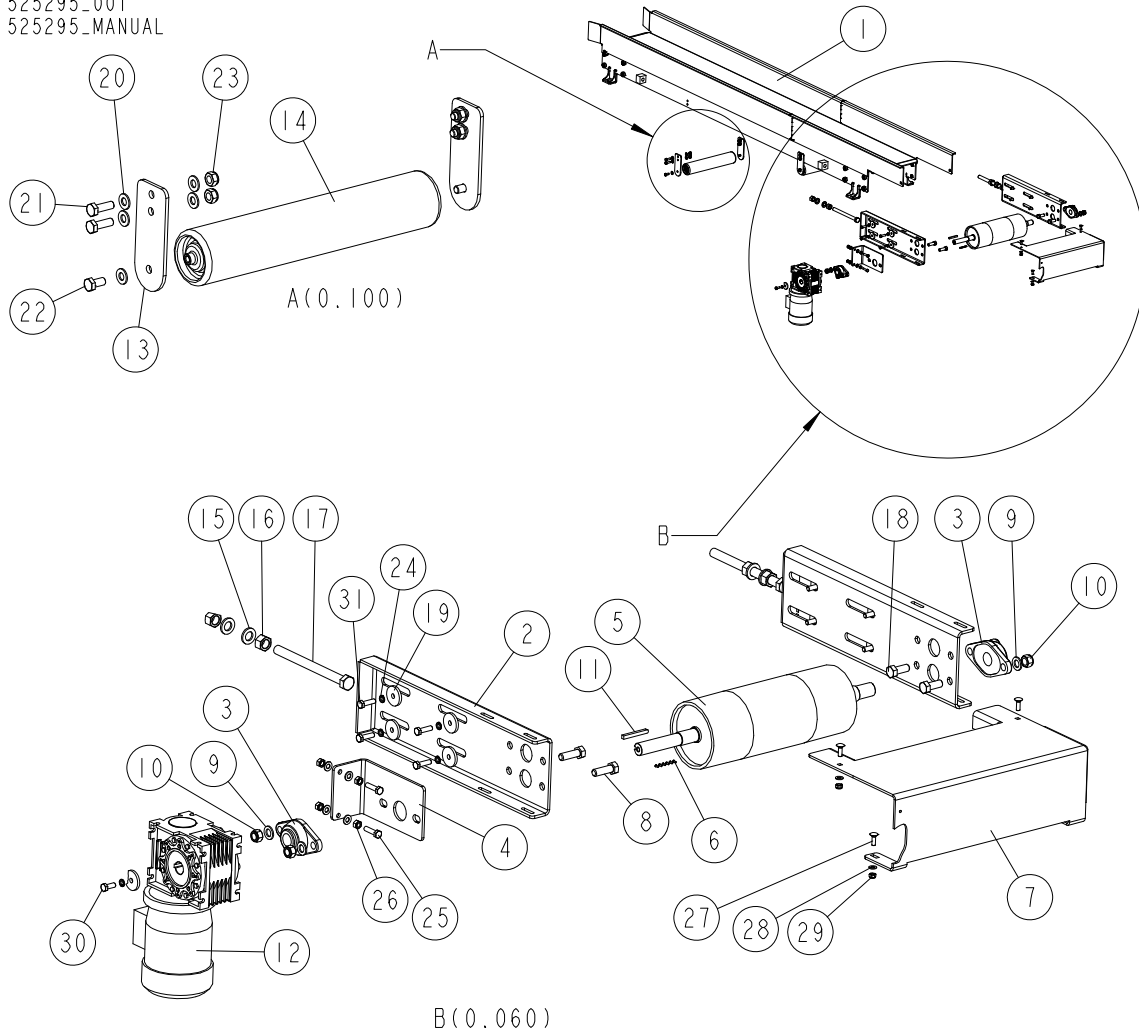
522740\_001  
522740\_MANUAL



REF.	DESCRIPTION (* indicates parts available in assemblies only)	PART NO.	QTY
-	CONVEYOR, HR500/HR700 MAIN RETURN - COMPLETE	522740	1
1	CONVEYOR, HR500/HR700 MAIN RETURN <a href="#">See Section 4.6</a>	525295	1
2	BRACKET, HR110/115 PULLEY MOUNT	504133-1	2
3	BEARING, UCFL 206 (CX) BALL	090851	2
4	PULLEY WELDMENT, HR110/115 IDLE SIDE	503776-1	1
5	BOLT, M16X40-8.8 HEX HEAD FULL THREAD ZINC	F81006-13	4
6	WASHER, 17 SPLIT LOCK ZINC	F81058-1	4
7	NUT, M16-8 HEX NYLON ZINC LOCK	F81036-2	4
8	GUARD, HR110/115 BELT RIGHT	504134-1	1
9	WASHER, 10.5/45-6 ZINC-PLATED	086286-1	8
10	WASHER, Z 10.2 SPLIT LOCK ZINC	F81055-2	8
11	BOLT, M10X35 8.8 HEX HEAD FULL THREAD ZINC	F81003-17	8
12	BOLT, M20X240-8.8 HEX HEAD FULL THREAD ZINC	F81007-1	2
13	WASHER, 21 FLAT ZINC	F81059-2	4
14	NUT, M20-8 HEX ZINC	F81037-1	4
15	BELT, L=6900 B=380	522752	1
16	BOLT, M8X25-8.8 CARRIAGE ZINC	F81002-59	4
17	WASHER, 8.4 FLAT ZINC	F81054-1	4
18	NUT, M8-8-B HEX NYLON ZINC LOCK	F81032-2	4

4.6 Main Return Conveyor

525295\_001  
525295\_MANUAL



REF.	DESCRIPTION (* indicates parts available in assemblies only)	PART NO.	QTY
-	<b>CONVEYOR, HR500/HR700 MAIN RETURN</b>	<b>525295</b>	<b>1</b>
1	TABLE, HR500/HR700 MAIN RETURN CONVEYOR	522737-1	1
2	BRACKET, HR110/115 PULLEY MOUNT	504133-1	2
3	BEARING, UCFL 206 (CX) BALL	090851	2
4	ARM, HR110/115 TORQUE	504856-1	1
-	PULLEY, DRIVE W/LAGGING	506519	1
5	PULLEY WELDMENT, HR110/115 DRIVE	503781-1	1
-	ADHESIVE, TEXCOL	090875	1
6	RIVET, P AL/FE 4X10 TUBULAR W/CORE	F81021-1	6
7	GUARD, HR BELT LEFT	504122-1	1
8	BOLT, M16X50-8.8 HEX HEAD FULL THREAD ZINC	F81006-7	2
9	WASHER, 17 SPLIT LOCK ZINC	F81058-1	4
10	NUT, M16-8 HEX NYLON ZINC LOCK	F81036-2	4
11	KEY, AB 8X7X70 PARALLEL	089231	1
12	MOTOREDUCER, MR-63/49/0.55-1400/F3/N+S/V6	505080	1
13	PLATE, HR110/115 ROLLER MOUNT	503782-1	4
14	ROLLER, N76.1X400 W/M10 INTERNAL THREAD	093787	2

## 4

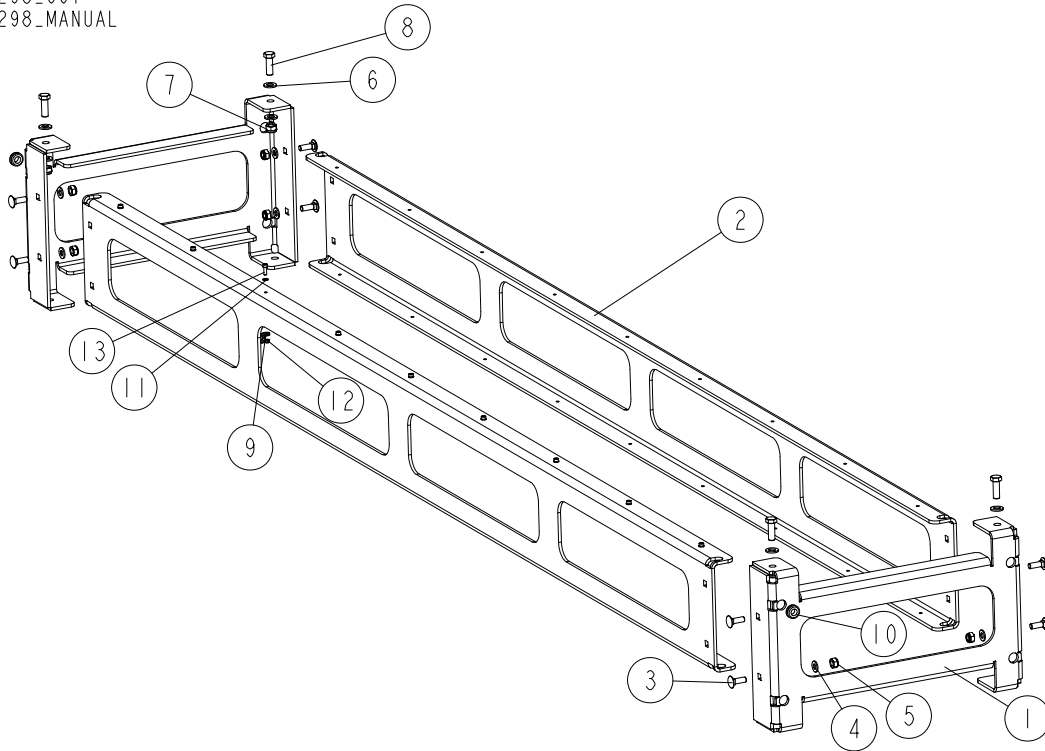
**Return Conveyors (Option)***Main Return Conveyor*

REF.	DESCRIPTION (* indicates parts available in assemblies only)	PART NO.	QTY	
15	WASHER, 21 FLAT ZINC	F81059-2	4	
16	NUT, M20-8 HEX ZINC	F81037-1	4	
17	BOLT, M20X240-8.8 HEX HEAD FULL THREAD ZINC	F81007-1	2	
18	BOLT, M16X40-8.8 HEX HEAD FULL THREAD ZINC	F81006-13	2	
19	WASHER, 10.5/45-6 ZINC-PLATED	086286-1	9	
20	WASHER, 10.5 FLAT ZINC	F81055-1	24	
21	BOLT, M10X30-8.8 HEX HEAD FULL THREAD ZINC	F81003-2	8	
22	BOLT, M10X20-8.8 HEX HEAD FULL THREAD ZINC	F81003-1	4	
23	NUT, M10-8-B HEX NYLON ZINC LOCK	F81033-1	8	
24	WASHER, Z 10.2 SPLIT LOCK ZINC	F81055-2	9	
25	BOLT, M10X40-8.8 HEX HEAD FULL THREAD ZINC	F81003-16	2	
26	NUT, M10 8 HEX ZINC	F81033-3	4	
27	BOLT, M8X25-8.8 CARRIAGE ZINC	F81002-59	4	
28	WASHER, 8.4 FLAT ZINC	F81054-1	4	
29	NUT, M8-8-B HEX NYLON ZINC LOCK	F81032-2	4	
30	BOLT, M10X25 8.8 HEX HEAD FULL THREAD ZINC	F81003-11	1	
31	BOLT, M10X35 8.8 HEX HEAD FULL THREAD ZINC	F81003-17	8	



## 4.7 Main Return Conveyor Base

525298\_001  
525298\_MANUAL



REF.	DESCRIPTION (* indicates parts available in assemblies only)	PART NO.	QTY	QTY
-	<b>BASE, MAIN RETURN CONVEYOR - COMPLETE</b>	525298	1	-
-	<b>BASE, MAIN RETURN CONVEYOR - COMPLETE</b>	525304	-	1
1	LEG, CONVEYOR BASE	525299-1	2	2
2	BEAM, LONG SIDE	525303-1	2	2
	BEAM, SHORT SIDE	525305-1	2	2
3	BOLT, M10X30-8.8 CARRIAGE ZINC	F81003-101	8	8
4	WASHER, 10.5 FLAT ZINC	F81055-1	8	8
5	NUT, M10-8-B HEX NYLON ZINC LOCK	F81033-1	8	8
6	WASHER, 13 FLAT ZINC	F81056-1	8	8
7	NUT, M12 8 HEX NYLON ZINC LOCK	F81034-2	4	4
8	BOLT, M12X35 8.8 HEX HEAD FULL THREAD ZINC	F81004-24	4	4
9	CLIP, RSGU 1.10/12W1 METAL & RUBBER RETAINING	086861	9	7
10	GROMMET, 20/13 RUBBER	086188	2	2
11	WASHER, 5.3 FLAT ZINC	F81052-1	9	7
12	NUT, M5-8 DIN985 ZINC-PLATED	F81030-2	9	7
13	SCREW, M5X16-8.8 HEX SOCKET HEAD CAP ZINC	F81000-25	9	7

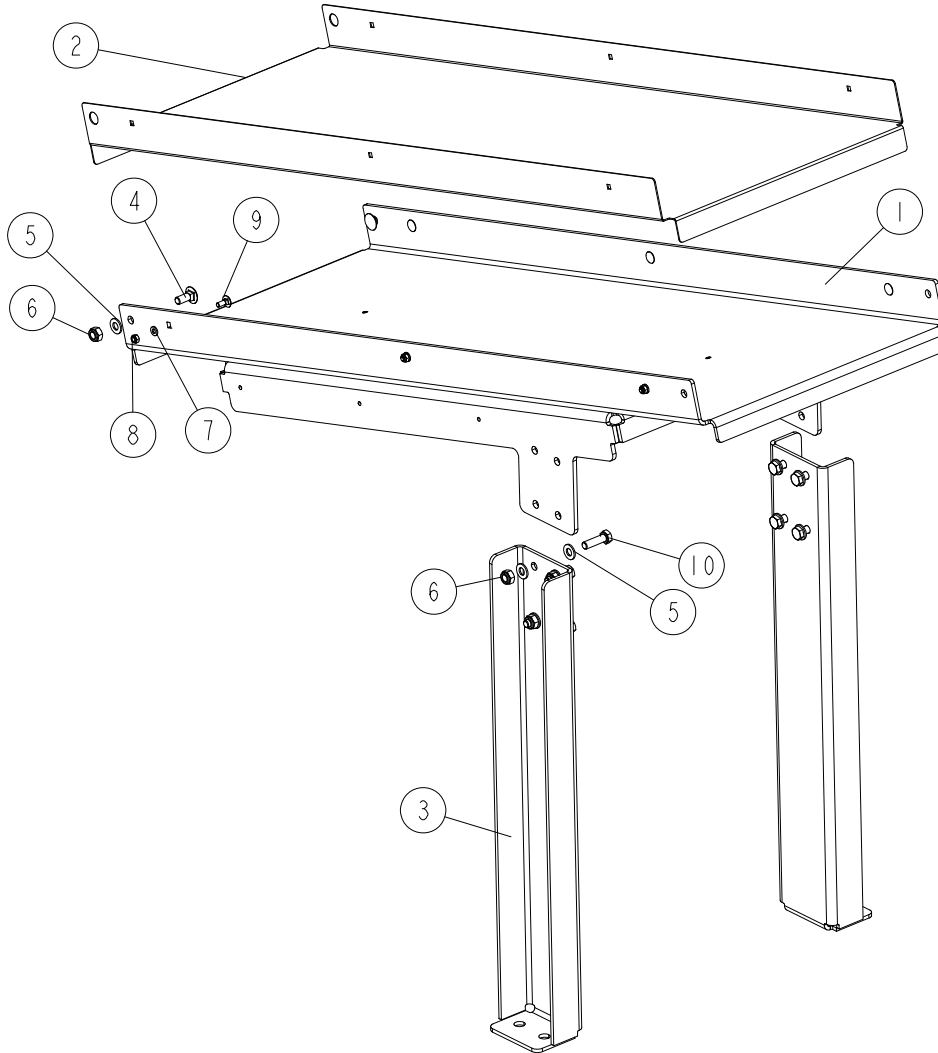
# 4

## Return Conveyors (Option)

### Rear Incline Table

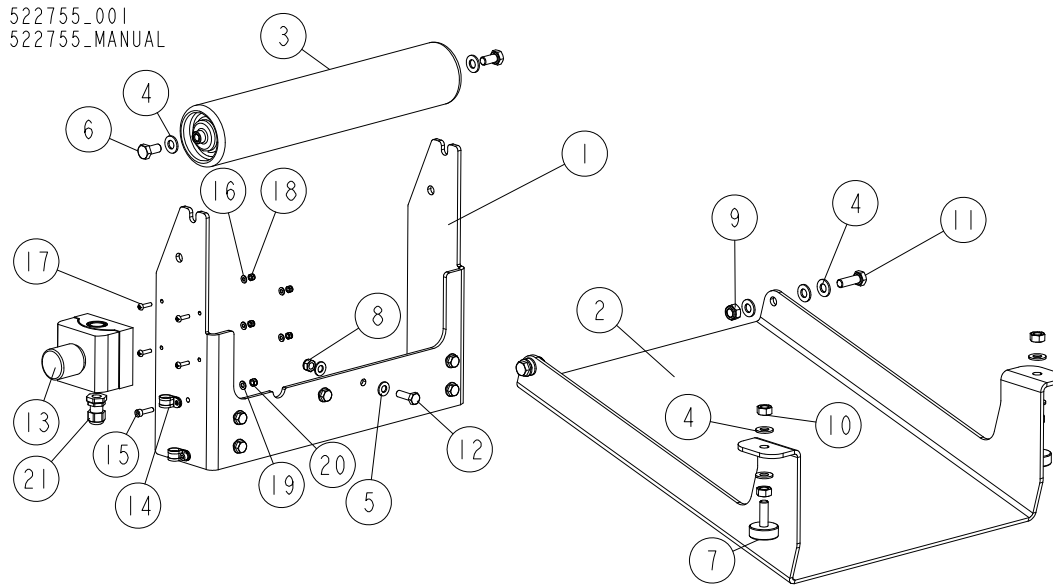
#### 4.8 Rear Incline Table

522741\_001  
522741\_MANUAL



REF.	DESCRIPTION (* indicates parts available in assemblies only)	PART NO.	QTY
-	<b>TABLE, REAR INCLINE - COMPLETE</b>	522741	1
1	PLATE, BASE	522742-1	1
2	PLATE, TOP SLIDE	522745	1
3	LEG, REAR INCLINE TABLE	522750-1	2
4	BOLT, M10X25-8.8 CARRIAGE ZINC	F81003-59	2
5	WASHER, 10.5 FLAT ZINC	F81055-1	18
6	NUT, M10-8-B HEX NYLON ZINC LOCK	F81033-1	10
7	WASHER, 6.4 FLAT ZINC	F81053-1	6
8	NUT, M6-8-B HEX NYLON ZINC LOCK	F81031-2	6
9	BOLT, M6X16-8.8 CARRIAGE ZINC	F81001-36	6
10	BOLT, M10X35 8.8 HEX HEAD FULL THREAD ZINC	F81003-17	8

4.9 Front Roller



522755\_001  
522755\_MANUAL

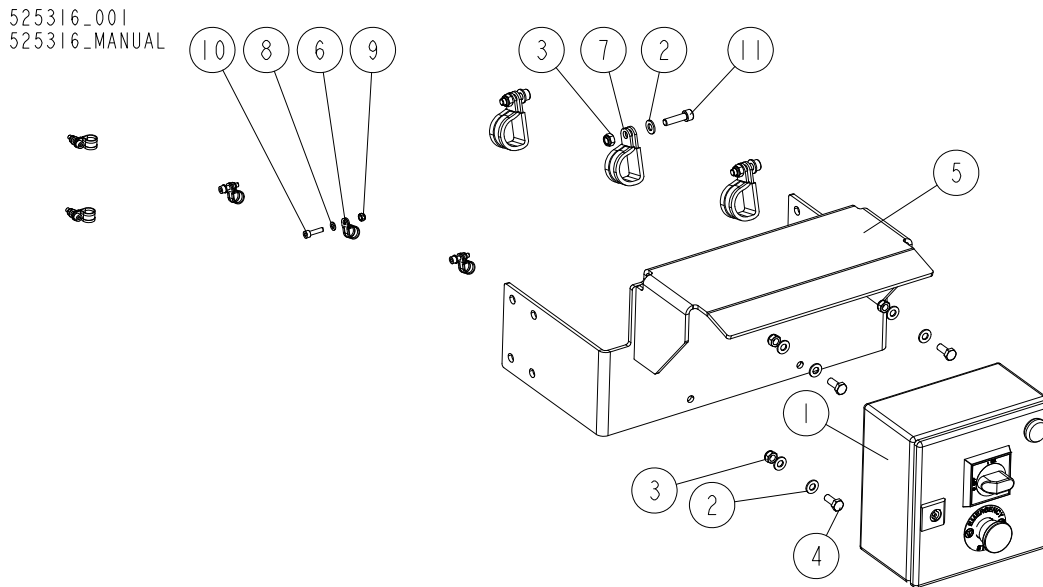
REF.	DESCRIPTION (* indicates parts available in assemblies only)	PART NO.	QTY
-	<b>ROLLER, FRONT - COMPLETE</b>	522755	1
1	BRACKET, FRONT ROLLER MOUNT	522756-1	1
2	PLATE, INCLINE	522757-1	1
3	ROLLER, N76.1X400 W/M10 INTERNAL THREAD	093787	1
4	WASHER, 10.5 FLAT ZINC	F81055-1	12
5	WASHER, 8.4 FLAT ZINC	F81054-1	12
6	BOLT, M10X20-8.8 HEX HEAD FULL THREAD ZINC	F81003-1	2
7	FOOT, M10	092839	2
8	NUT, M8-8-B HEX NYLON ZINC LOCK	F81032-2	6
9	NUT, M10-8-B HEX NYLON ZINC LOCK	F81033-1	2
10	NUT, M10 8 HEX ZINC	F81033-3	4
11	BOLT, M10X30-8.8 HEX HEAD FULL THREAD ZINC	F81003-2	2
12	BOLT, M8X25-8.8-B HEX HEAD FULL THREAD ZINC	F81002-5	6
13	SWITCH, M22-PV/KCO2 EMERGENCY STOP	094726	1
14	CLIP, RSGU 1.10/12W1 METAL & RUBBER RETAINING	086861	2
15	SCREW, M5X20 8.8 HEX SOCKET HEAD CAP ZINC	F81000-72	2
16	WASHER, 4.3 FLAT ZINC	F81051-2	4
17	SCREW, M4X16 5.8-B CROSS RECESSED PAN HEAD ZINC	F81011-42	4
18	NUT, M4-8 HEX NYLON ZINC LOCK	F81029-1	4
19	WASHER, 5.3 FLAT ZINC	F81052-1	2
20	NUT, M5-8 DIN985 ZINC-PLATED	F81030-2	2
21	GLAND, DP 9/H CABLE	F81096-2	1

# 4

## Return Conveyors (Option)

### Electric Box Assembly

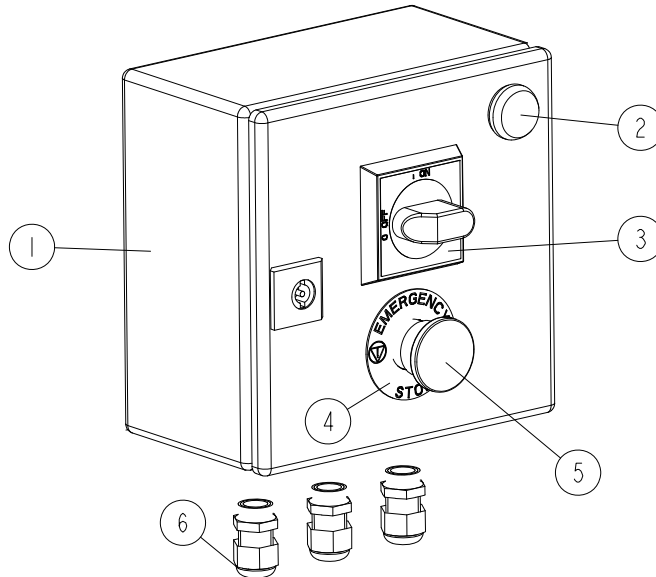
#### 4.10 Electric Box Assembly



REF.	DESCRIPTION (* indicates parts available in assemblies only)	PART NO.	QTY
-	<b>BOX, RETURN CONVEYOR ELECTRIC</b>	525316	1
1	BOX, (200X200X120) ELECTRIC - COMPLETE <a href="#">See Section 4.11</a>	527155	1
2	WASHER, 8.4 FLAT ZINC	F81054-1	11
3	NUT, M8-8-B HEX NYLON ZINC LOCK	F81032-2	7
4	BOLT, M8X20 8.8 HEX HEAD FULL THREAD ZINC	F81002-4	4
5	BRACKET, 200X200X120 ELECTRIC BOX MOUNT	525318-1	1
6	CLIP, RSGU 1.10/12W1 METAL & RUBBER RETAINING	086861	5
7	CLIP, RSGU 1.30/20 W1 METAL & RUBBER RETAINING	F81087-1	3
8	WASHER, 5.3 FLAT ZINC	F81052-1	5
9	NUT, M5-8 DIN985 ZINC-PLATED	F81030-2	5
10	SCREW, M5X20 8.8 HEX SOCKET HEAD CAP ZINC	F81000-72	5
11	SCREW, M8X30-8.8 HEX SOCKET HEAD CAP ZINC	F81002-31	3

### 4.11 Return Conveyor Electric Box

527155\_001  
527155\_MANUAL



REF.	DESCRIPTION (* indicates parts available in assemblies only)	PART NO.	QTY
-	<b>BOX, 200x200x120 ELECTRIC - COMPLETE</b>	527155 <sup>1</sup>	1
1	BOX, EB 1549500 (200X200X80) ELECTRIC	089802	1
2	LIGHT, 1SFA619402L5415 WHITE CONTROL	509129	1
3	HANDLE, OHB S2A1 ABB SWITCH	502312-1	1
4	WASHER, EMERGENCY STOP SWITCH	086561	1
5	SWITCH, XB4 BS542 EMERGENCY STOP	086556	1
6	GLAND, DW11/H CABLE	085388	3

<sup>1</sup> The remaining electric box components are included in the Electrical Components List provided with the electrical diagram.