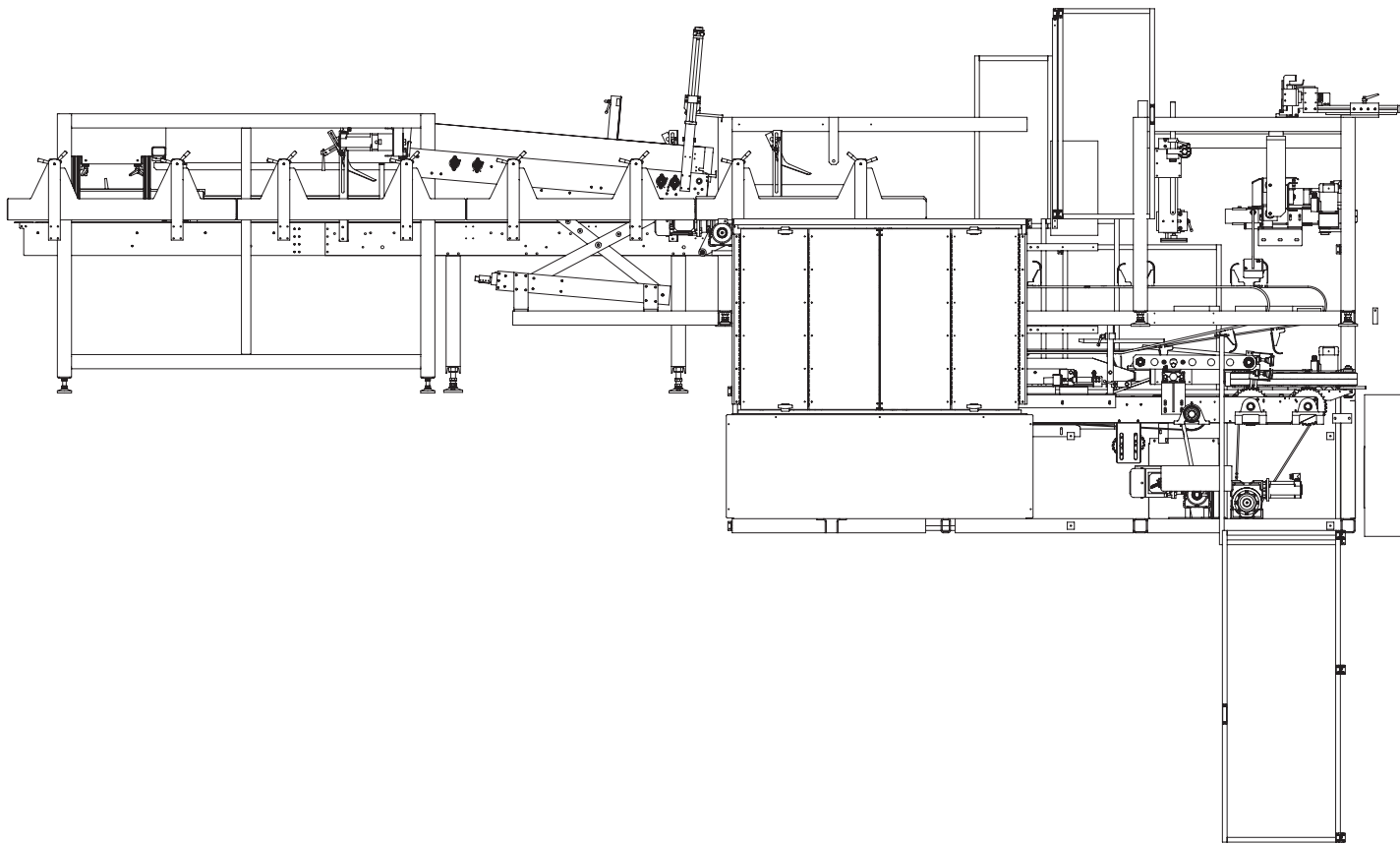
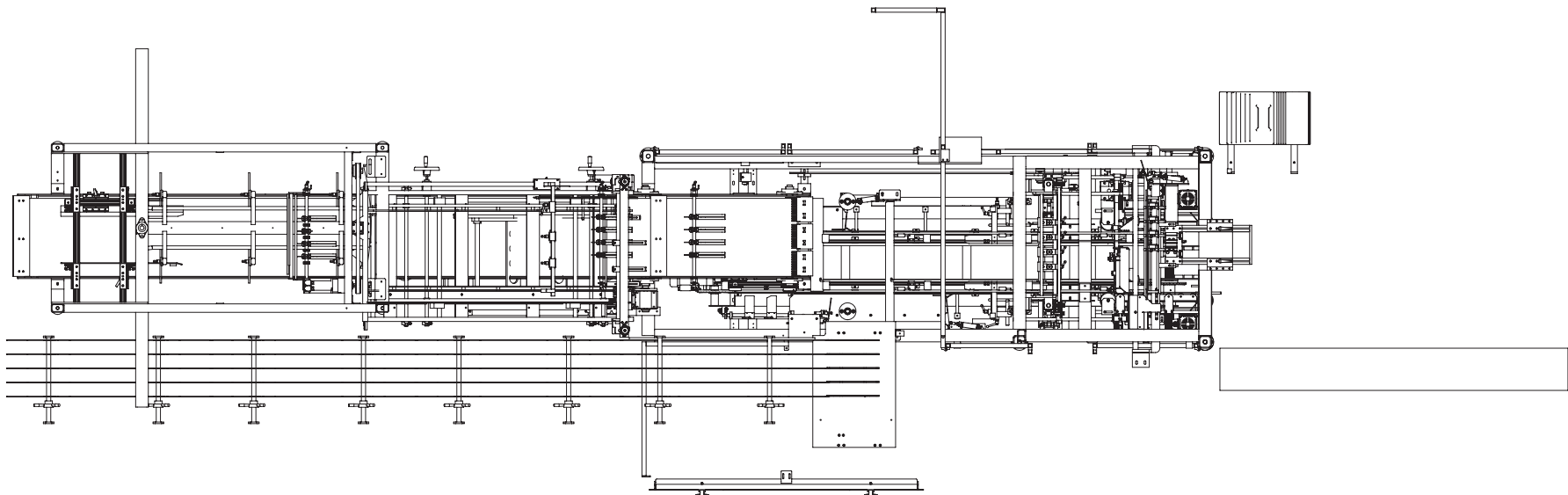




34	1	322564	ASSY, BRUSH
33	1	316367	WLDMT, PUSHER, 2.60 DIA 3 X 2, LH
32	1	311590-001	ASSY, CONV, SIDE, DISCHARGE
31	1	311590	ASSY, CONV, SIDE, DISCHARGE
30	1	311597	ASSY, GUARD, LH
29	1	316364	ASSY, GUIDE, FORM, TRAY
28	1	304445	ASSY, CHAIN DRIVE, LH MACHINE EL-2000, 460V
27	1	311589	ASSY, RAIL, SUPPORT, RH
26	1	311596	ASSY, FRAME, LH
25	1	232679-002	ASSY, BLANK, MAGAZINE, EL-2100, LH
24	1	316360	ASSY, STOP, 4 PRODUCT
23	1	316347	ASSY, CONV, DIVIDER
22	1	286909	ASSY, DETECT, PRODUCT, 4 LANES, 20" WIDE
21	1	316333	ASSY, DIVIDER, 48" ELEVATION
20	1	HMI 20X10X6	BOX, HMI, 20 X 10 X 6
19	1	219639-000A	
18	1	232796-001	ASSY, GATE, UP-STREAM, LH
17	1	300692	ASSY, GATE, DOWN-STREAM
16	2	286910	ASSY, DETECT, PRODUCT, 4 LANES, 20" WIDE
15	1	316341	ASSY, ARM, SERVO, A-B, LH
14	1	311601	ASSY, GUIDE, 4 LANE
13	1	316345-001	ASSY, CONV, INF, LH, SIDE TRANSFER
12	1	220456	ASSY, GLUE
11	1	297563	ASSY, POP-UP, RH, 2.047 DIA PROD
10	1	243431	ASST, SUPPORT, DEAD PLT
9	1	230241-002	ASSY, COMPRESSION, SIDE
8	1	230241-001	ASSY, COMPRESSION, SIDE
7	1	233678-002	ASSY, TUCKER, MINOR FLAP
6	1	233678-001	ASSY, TUCKER, MINOR FLAP
5	1	230236-002	ASSY, FLAP HOLD DOWN
4	1	230236-001	ASSY, FLAP HOLD DOWN
3	1	300710	ASSY, PICK AND PLACE, LH EL-2100
2	1	230844	ASSY, CHAIN, LUG
1	1	300695	ASSY, STEP BACK
ITM	QTY	PART NUM	DESCRIPTION

ARPAC

9511 WEST RIVER ST.
SCHILLER PARK, IL 60176

UNLESS OTHERWISE SPECIFIED
ALL DIMENSIONAL TOLERANCES:

FRACTIONS
TWO (2) DECIMALS
THREE (3) DECIMALS
ANGLES

± 1/64
± 0.010
± 0.005
± 0.5°

DRAWN: 7/6/2011

BY:

SCALE: 1:20

SIZE: D

FILENAME: 15269

DESCRIPTION:
ASSY, FINAL, EL-2121, LH, MACH

DRAWING NUMBER:
15269

Date: 3/28/2019

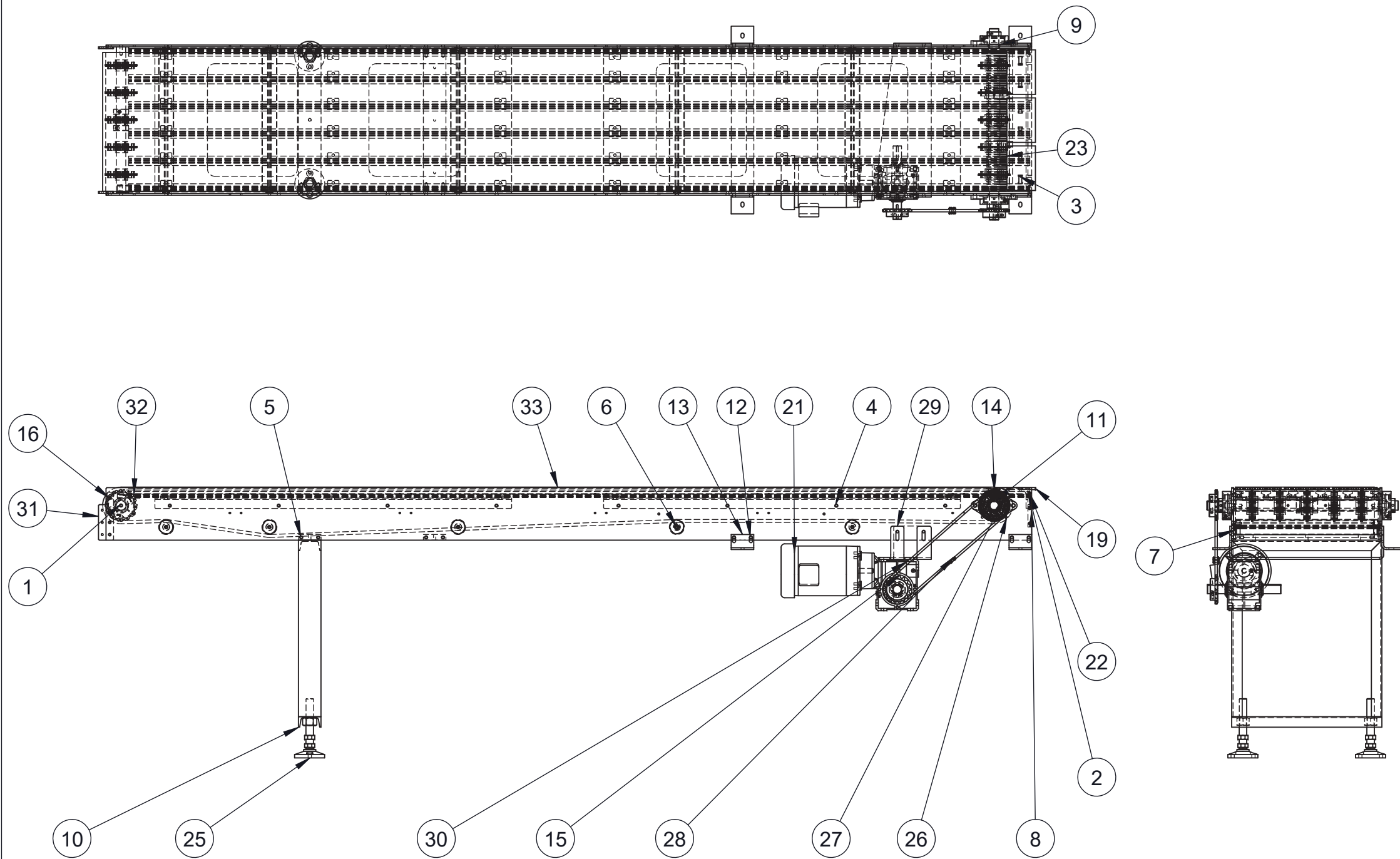
Time: 1:53:14PM

Arpac BOM

Parent Number: 15269 Parent Revision: B
Description: ASSY, FINAL, MACH, EL-2100, LH
Model: EL-2121

Assembly Part Number: 15269
Description: ASSY, FINAL, MACH, EL-2100, LH

Item	Qty	Arpac Part	Description
1	1.00	316345-001	ASSY, CONV, INF, LH
2	1.00	364273	ASSY, GUIDE, 6-LANE
3	1.00	364285	ASSY, CLAMP, STOP, 6 PRODUCT
4	1.00	364279	ASSY, STEP BACK, 6-LANE
5	1.00	316341	ASSY, RAM, SERVO, A-B
6	1.00	232796-001A	ASSY, GATE, UPSTREAM L.H. MACH NUMATIC CYL
7	1.00	300692	ASSY, GATE, DOWNSTREAM L.H. MACH
8	1.00	322449	ASSY, BLANK, TRAY, MAGAZINE, LH
9	1.00	311596	ASSY, FRAME, LH MACHINE
10	1.00	311589	ASSY, RAIL, SUPPORT, LH MACH
11	1.00	304445	ASSY, CHAIN DRIVE, LH MACHINE EL-2000, 460V
12	1.00	230844	ASSY, CHAIN, LUG
13	1.00	316364-001	ASSY, GUIDE, FORM, TRAY, LH
14	1.00	322571	ASSY, PICK AND PLACE, EL-2100, LH
15	1.00	306905-001	ASSY, HOLD DOWN, FLAP, RH
16	1.00	306905-002	ASSY, HOLD DOWN, FLAP, LH
17	1.00	233678-001B	ASSY, TUCKER, MINOR FLAP, RH NUMATIC
18	1.00	233678-002B	ASSY, TUCKER, MINOR FLAP, LH NUMATIC
19	1.00	230241-001B	ASSY, COMPRESSION, SIDE, RH
20	1.00	230241-002B	ASSY, COMPRESSION, SIDE, LH
21	1.00	311586	ASSY, GLUE, EL-2000, FREE STAND GLUE TANK
22	1.00	364286	ASSY, PNEUMATIC, MACONNECT, EL-2100
23	1.00	311597	ASSY, GUARD, LH
24	1.00	243431	ASSY, DEAD PLT SUPPORT, LH MACHINE
25	1.00	286910	ASSY, DETECT, PRODUCT, 4 LANES, 20" WIDE, HIGH PROD
26	1.00	219639-000A	ASSY, CENTRAL POINT LUBE BLOCK, NYLON
27	1.00	292546	GENERAL PARTS, EL-2000
28	1.00	364278	KIT, PARTS, CHANGE, 15269
29	1.00	323268	ASSY, PRODUCT DETECTOR, ACCUMULATION, ADJ
30	1.00	357410	ASSY, AGITATOR, 20"WIDE, 6 LANES, 230/460V
31	1.00	357171	ASSY, GUARD, AGITATOR, EL-2000



33	22	808414	BELT, ACETAL, BLUE, RAISED RIB, 18.5"W
32	1	801316	VALUGUIDE SPLICE SLEEVE VG-013-01
31	2	316352	PLT, NUT, CONNECTION
30	1	846471	GEARBOX, WORM, 15:1, 140TC FACE, QUILL FACE, DOUBLE SHAFT
29	1	296177	BKT, MTG, MOTOR, LH
28	1	800505	LINK, CONN, #50
27	1	800468	CHAIN, RLR, #50
26	2	839307	BRG, FLG, 1-1/4 ID, 2-BOLT STANDARD-DUTY
25	2	827619	LEVELER, ARTICULATING, 20000 # CAP, 1-8 STEM, 7.88 HIGH, CRS 4" BASE, 2 C'SUNK LAG HOLES, HEAVY LIP ON BASE
24	36	801359	CLAMP, RAIL, SINGLE, 1.5 LG, SS, ROUND HOLE
23	4	822399-002	RAIL, GUIDE, TEE, 1.25 W, SS, 10' LG
22	2	801292-003	RAIL, GUIDE, TEE, 1.0 X 0.38 L-SHAPE, 10' SS
21	1	803188	MOTOR, 1-1/2 HP, 208-230/460V, 60HZ, 3PH 145TC FRM. TEFC
20	2	810147	COLLAR, SHAFT, SET SCREW, 1-1/4, SS
19	3	802634	PLT, TRANSFER FINGER GREY, # 900
18	5	806043	SPKT, 12T, 1-1/2 SQ BORE, 4.1 PD, ACETAL
17	2	800335-027	RING, SNAP, EXTERNAL, 1-1/2 SHAFT
16	5	808417	SPKT, 12T, 1-1/4 DIA BORE, 4.1PD, MOLDED WHITE ACETAL
15	1	101833	SPKT, 50B18, MOD, 1.125 BORE
14	1	126947	SPKT, 50B19, MOD, 1.250 BORE
13	4	228334	BKT, MTG
12	1	142904	CROSS MEMBER BOTTOM
11	1	123750	INFEED DRIVE SHAFT
10	1	142899	LEG, SUPPORT
9	1	316346-001	PLT, SIDE, CONV
8	1	316346-002	PLT, SIDE, CONV
7	5	101814-079	RLR, IDL, CRS, 2.00, 18.75 L TUBE
6	5	142898	HEX, SHFT, ROLLER
5	2	123755	CROSS MEMBER, BOTTOM
4	2	238054	PLT, BED, CONV
3	1	142896	BRACKET, ANGLE
2	1	222914	PLT, END
1	1	123760	IDLER SHAFT, 19.50 LG

ITM	QTY	PART NUM	DESCRIPTION	
BILL OF MATERIALS				
		9511 WEST RIVER ST. SCHILLER PARK, IL 60176		
UNLESS OTHERWISE SPECIFIED ALL DIMENSIONAL TOLERANCES:		FRACTIONS TWO (2) DECIMALS THREE (3) DECIMALS ANGLES	± 1/64 ± 0.010 ± 0.005 ± 0.5°	
DRAWN: 11/02/2015		BY: JW	SCALE: 1:24	SIZE: B
		FILENAME: 316345		
DESCRIPTION: ASSY, CONV, INF				
			DRAWING NUMBER: 316345	

Arpac BOM

Parent Number: 15269 Parent Revision: B

Description: ASSY, FINAL, MACH, EL-2100, LH

Model: EL-2121

Assembly Part Number: 316345-001

Assembly Drawing Number: 316345

Description: ASSY, CONV, INF, LH

Quantity: 1.00

Item	Qty	Arpac Part	Description
1	1.00	123760	IDLER SHAFT, 19.50 LG
2	1.00	222914	PLATE, END
3	1.00	142896	BKT, ANGLE
4	2.00	238054	PLT, BED, CONV
5	2.00	123755	CROSS MEMBER, BOTTOM
6	5.00	142898	HEX, SHFT, ROLLER, 19 1/2
7	5.00	101814-079	RLR, IDL, CRS, 2.000, 18.750 LG
8	1.00	316346-002	PLT, SIDE, RH, INFEED
9	1.00	316346-001	PLT, SIDE,LH, INFEED
10	1.00	142899	LEG, SUPRT INFEED
11	1.00	123750	SHAFT, DRIVE, INFEED
12	1.00	142904	CROSS MEMBER BOTTOM
13	4.00	228334	BKT, MTG
14	1.00	126947	SPKT, 50B19, MOD, 1.250 BORE STL W/ KKY AND SSCR
15	1.00	101833	SPKT, 50B18, MOD, 1.125 BORE
16	5.00	808417	SPKT, 12T, 1-1/4 DIA BORE, 4.1PD, MOLDED WHITE ACETAL
17	2.00	800335-027	RING, SNAP, EXTERNAL, 1-1/2 SHAFT
18	5.00	806043	SPKT, 12T, 1-1/2 SQ BORE, 4.1 PD, ACETAL
19	3.00	802634	PLT, TRANSFER FINGER GREY, # 900
20	2.00	810147	COLLAR, SHAFT, SET SCREW, 1-1/4 SS
21	1.00	803188	Obsolete use P/N 854583 - MOTOR, 1-1/2 HP, 208-230/460V, 60HZ, 3PH 145TC
22	2.00	801292-003	RAIL, GUIDE, TEE, 1.0 X 0.38 L-SHAPE,10' SS
23	4.00	822399-002	RAIL, GUIDE, TEE, 1.25 W, SS, 10' LG
24	36.00	801359	CLAMP, RAIL, SINGLE, 1.5 LG, SS, ROUND HOLE
25	2.00	827619	LEVELER, ARTICULATING, 20000 # CAP, 1-8 STEM, 7.88 HIGH, CRS 4" DIA X 2"
26	2.00	839307	BRG, FLG, 1-1/4 ID, 2-BOLT STANDARD-DUTY
27	1.00	800468	CHAIN, RLR, #50
28	1.00	800505	LINK, CONN, #50
29	1.00	296177	BKT, MTG, MOTOR, LH
30	1.00	846471	GEARBOX, WORM, 15:1, 140TC FACE, QUILL FACE, DOUBLE SHAFT
31	2.00	316352	PLT, NUT, CONNECTION
32	1.00	801316	CLAMP, RAIL, SPLICE, 3 LG, SS
33	22.00	808414	BELT, ACETAL, BLUE, RAISED RIB, 18.5"W

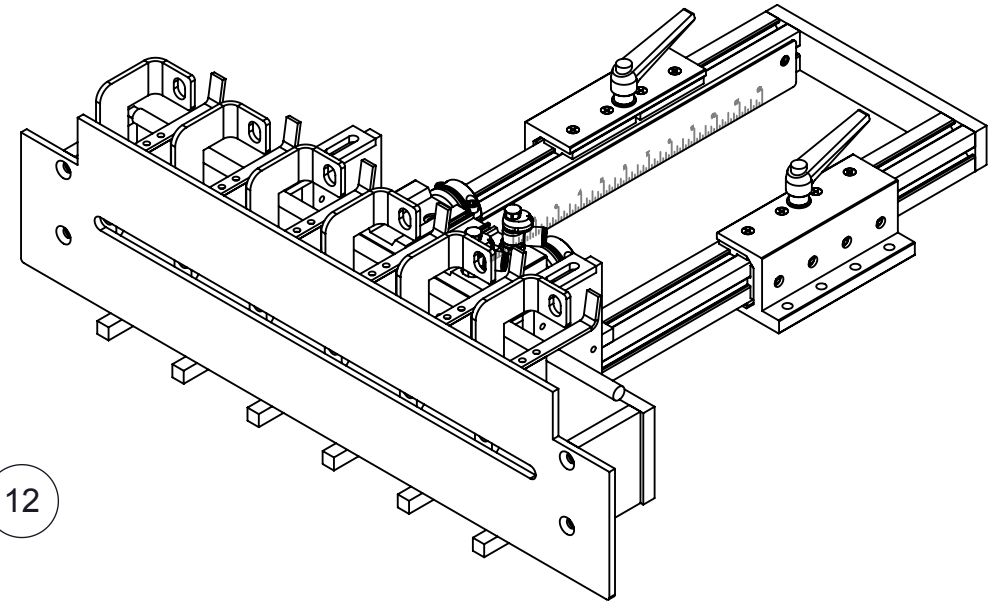
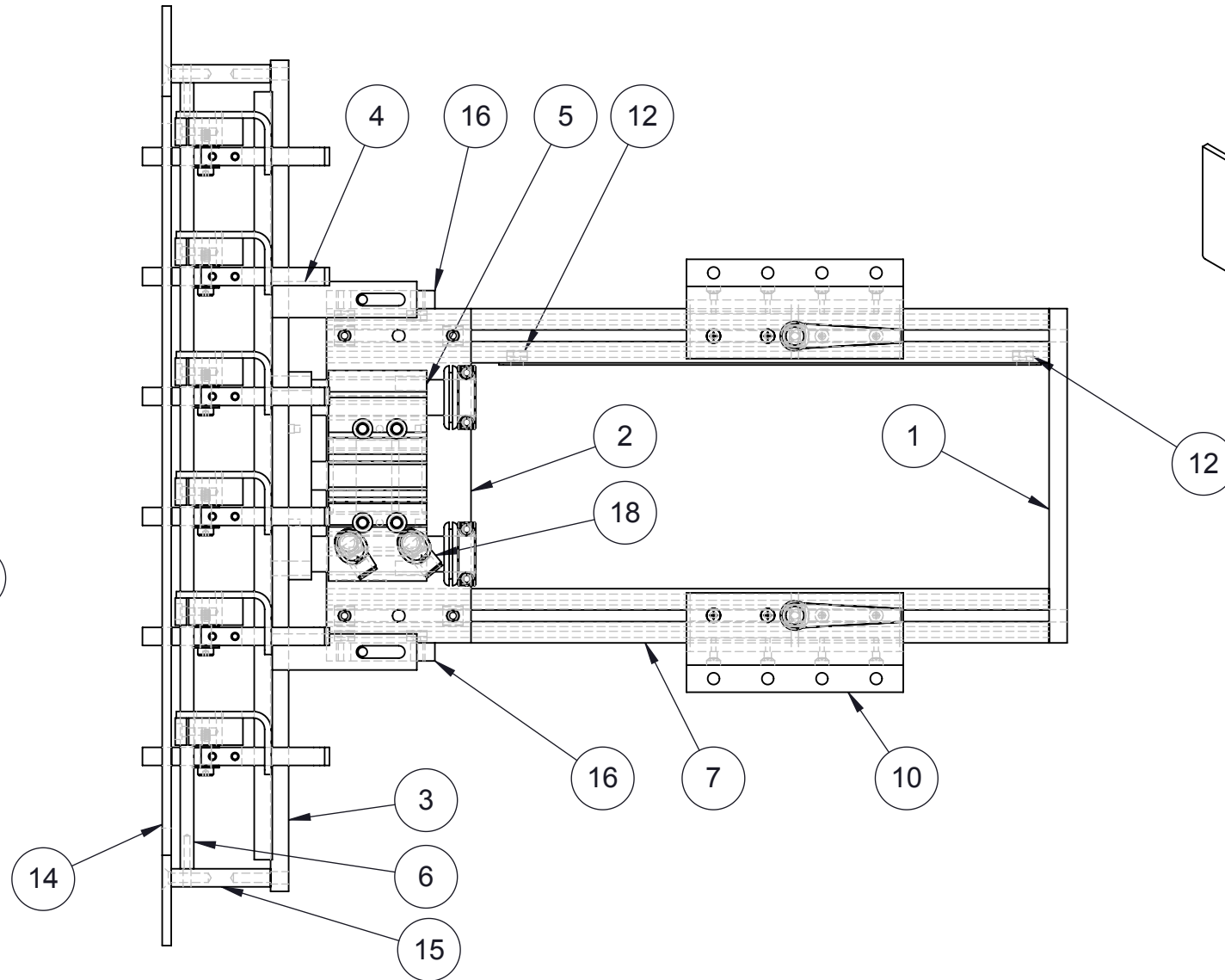
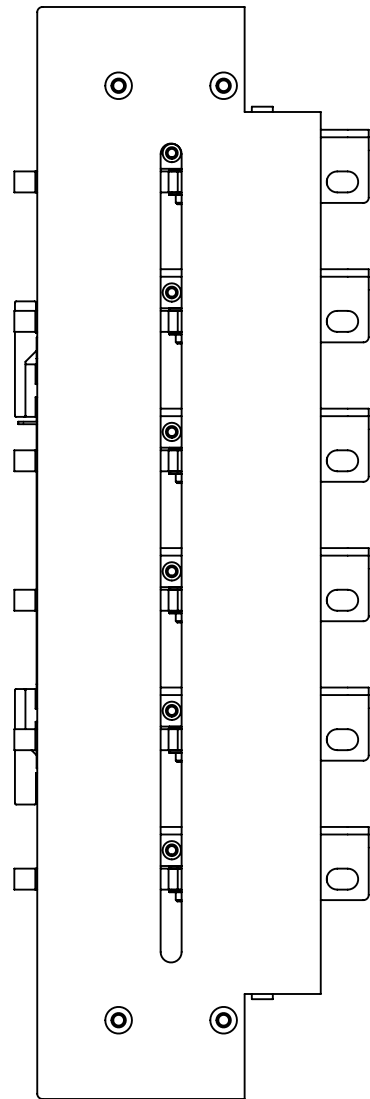
REV	DATE	BY	NOTE
REVISIONS			
SIZE B	SCALE 1:8	MATERIAL SEE BILL OF MATERIALS	DESCRIPTION ASSY, CLAMP, STOP, 6 PRODUCT
3RD ANGLE 	UNITS INCH		
TOLERANCES X/X: ±1/32 X.XX: ±.015 X.XXX: ±.005 ANGLES: ±1°		FINISH NONE	NUMBER 364285

Arpac BOM

Parent Number: 15269 Parent Revision: B
Description: ASSY, FINAL, MACH, EL-2100, LH
Model: EL-2121

Assembly Part Number: 364285
Assembly Drawing Number: 364285
Description: ASSY, CLAMP, STOP, 6 PRODUCT
Quantity: 1.00

Item	Qty	Arpac Part	Description
1	1.00	243312-001B	ASSY, ADJ., CAN STOP, LH EL2000
2	6.00	364284	ASSY, CLAMP, STOP, PRODUCT, 2 X 5-1/2



ITEM 18 NOT SHOWN

18	2	822126-001	VALVE, CONTROL, FLOW, 3/8 OD PUSH-ON 1/4 NPT, NUMERIC INDICATOR
17	6	300784	ASSY, FINGER DETECTOR
16	2	300694	PLT, MNT, STOP, FINGER & GATE
15	2	300693	BAR, MTG, STEP BACK
14	1	300696	PLT, STOP, BACK, STEP
13	2	822051	GROMMET, 1" ID, 1.75 OD, 3/8 THICK
12	12	809939	T-NUT, 5/16-18, 15 SERIES, SLIDE IN, BLACK ZINC
11	2	816449	HANDLE, LINEAR BEARING BRAKE
10	2	816026	BRG, LINEAR, FLANGED FOR 1515 EXT
9	1	215775-001	SCALE, R TO L
8	2	800568	COLLAR, SHAFT, CLAMP, 2-PIECE, 1 ID x 1 3/4 OD
7	2	809015-007	EXTRUSION, 1515 SERIES 20" LENGTH
6	2	242943	SHAFT, MTG, FINGER
5	1	816448	THRUSTER, LINEAR, 50MM BORE, 25MM STROKE BALL BRG
4	1	233434	BKT, FINGER POSITION
3	1	216201	PLT, BACK, STEP
2	1	188769	PLT, MNT, CYL STEP BACK
1	1	188768	PLT, CONNECT EXTRUSIONS
ITM	QTY	PART NUM	DESCRIPTION

BILL OF MATERIALS

ARPAC 9511 WEST RIVER ST.
SCHILLER PARK, IL 60176

UNLESS OTHERWISE SPECIFIED:
ALL DIMENSIONAL TOLERANCES:

FRACTIONS	± 1/64
TWO (2) DECIMALS	± 0.010
THREE (3) DECIMALS	± 0.005
ANGLES	± 0.5°

DRAWN: 3/27/2019	BY: SRA	SCALE: 0.21875:1	SIZE: B
------------------	---------	------------------	---------

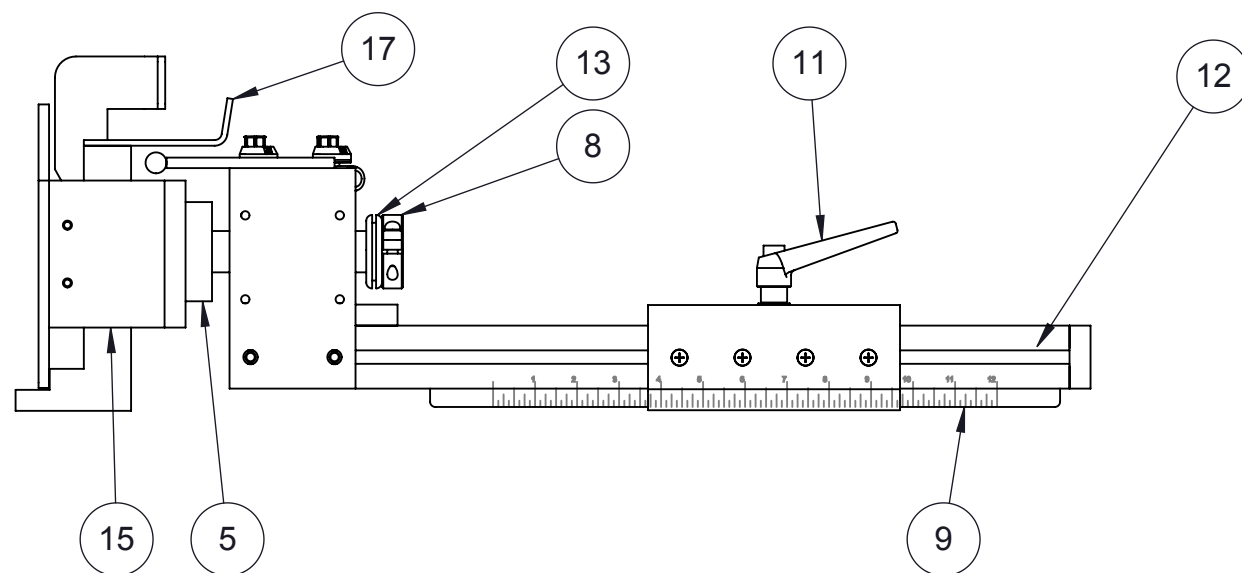
RELEASED:	FILENAME: 364279	APPROVED BY:
-----------	------------------	--------------

DESCRIPTION: ASSY, STEP BACK, 6-LANE

3

DRAWING NUMBER:
364279

364279 AS SHOWN
364279-001 OPPOSITE



Arpac BOM

Parent Number: 15269 Parent Revision: B

Description: ASSY, FINAL, MACH, EL-2100, LH

Model: EL-2121

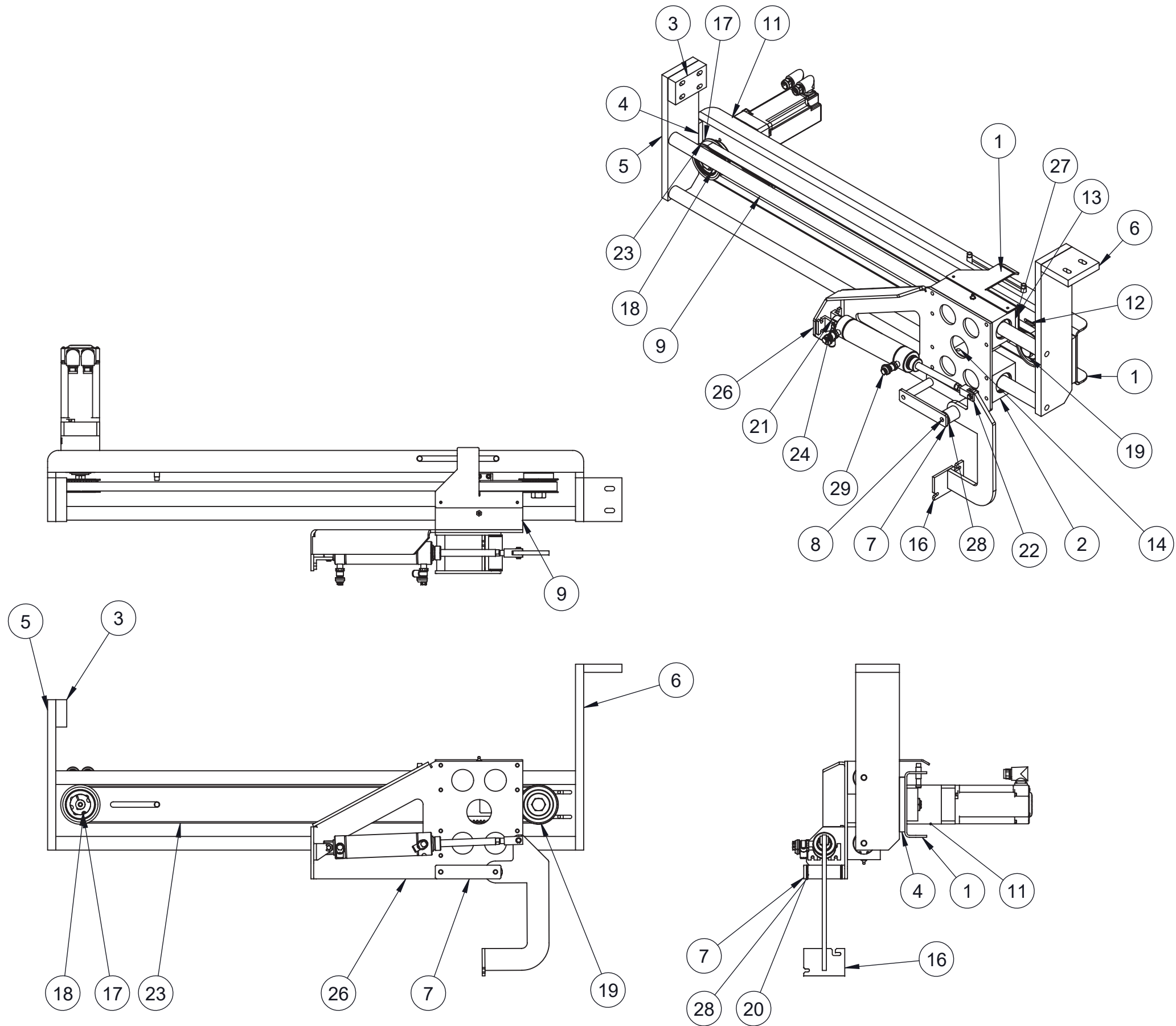
Assembly Part Number: 364279

Assembly Drawing Number: 364279

Description: ASSY, STEP BACK, 6-LANE

Quantity: 1.00

Item	Qty	Arpac Part	Description
1	1.00	188768	PLT, CONNECT EXTRUSION TS25, STD
2	1.00	188769	PLT, MNT, CYL STEP BACK TS25, STD
3	1.00	216201	PLT, STEP BACK
4	1.00	233434	WLDMT, BKT, FINGER POSITION
5	1.00	816448	THRUSTER, LINEAR, 50MM BORE, 25MM STROKE BALL BRG
6	2.00	242943	SHAFT, MTG, FINGER
7	2.00	809015-007	EXTRUSION, 1515 SERIES 20" LENGTH
8	2.00	800568	COLLAR, SHAFT, CLAMP, 2-PIECE, 1 ID x 1 3/4 OD
9	1.00	215775-001	SCALE, R TO L
10	2.00	816026	BRG, LINEAR, FLANGED FOR 1515 EXT
11	2.00	816449	HANDLE, LINEAR BEARING BRAKE
12	12.00	809939	T-NUT, 5/16-18, 15 SERIES, SLIDE IN, BLACK ZINC
13	2.00	822051	GROMMET, 1 ID, 1.75 OD, 3/8 THK, 1-3/8 DIA HOLE, 3/32 THK PANEL
14	1.00	300696	PLT, STOP, BACK, STEP
15	2.00	300693	BAR, MTG, BACK, STEP
16	2.00	300694	PLT, MNT, FINGER & GATE
17	6.00	300784	ASSY, FINGER DETECTOR
18	2.00	822126-001	VALVE, CONTROL, FLOW, W/SEALANT, 3/8 OD PUSH-ON 1/4 NPT, NUMERIC INDICATO



29	2	822126-001	VALVE, CONTROL, FLOW, 3/8 OD PUSH-ON 1/4 NPT, NUMERIC INDICATOR
28	2	807258	WSHR, OILITE, 0.753 X 1.250 X 1/16 THK
27	1	304441	ASSY, BLK, BUSH, SHAFT, 1-1/4", 8" LG,
26	1	311587	WLDMNT, BKT, MTG, CYL, LH
25	1	304440-001	FLAG, PROX, RAM, LH
24	1	825507	BKT, PVT, SET-(1LEFT AND 1RIGHT BKT) FOR 2 & 2.5 BORE
23	1	823124	BELT, TIMING, 8MM P, 21MM W, 2400MM LG, POLY CHAIN
22	1	816543	CLVS, ROD, 1/2-20, 1 3/4" - 2" BORE
21	1	822607	CYL, AIR, 2 BORE, 5" STROKE, REAR PIVOT, 3/8 BUSH, DOUBLE CUSHION, MAGNET
20	2	800381	BUSH, OILITE, FLG, 0.751 X 0.877 X 1, 1 OD X 1/8 THK FLG
19	1	806349	SPKT, 32T, 8MM P, 21MM W, IDLER, 7720 SERIES
18	1	823427	BUSHING
17	1	823123	PULLEY, TIMING, 32T, 8MM P, 21MM W, 1210 BUSHING REQUIRED
16	1	316365	WLDMT, ARM, PUSHER
15	1	231210	PLATE, CLAMPING
14	1	231211	PLT, MNT, BELT CLAMP
13	1	231231	BLOCK, TENSIONER, TAPPED
12	1	231266	PLT, MTG, TENSIONER
11	1	839117	GEARBOX, 10:1
10	1	839096	MOTOR, SERVO, 37 IN-LB, 5000 RPM 460VAC KEYED/MULTI-TURN ABSOL. HIGH RES.
9	2	137693-002	SHAFT, SLIDE PUSHER, 47 17/32
8	2	189950	SHAFT, PIVOT
7	2	300810	PLT, SUPPORT, SHAFT
6	1	259650	WLDMNT, BKT
5	1	259649	PLT, MTG, SHAFT, SLIDE, PUSHER
4	2	235322	SPACER, MTG, CHANNEL
3	1	309151	BLK, SPACER
2	1	231163	ASSY, BLK, BUSH, SHAFT, 1-1/4", 8" LG,
1	1	297587	CHANNEL, MTG, SERVO
ITM	QTY	PART NUM	DESCRIPTION

BILL OF MATERIALS			
ARPAC		9511 WEST RIVER ST. SCHILLER PARK, IL 60176	
UNLESS OTHERWISE SPECIFIED ALL DIMENSIONAL TOLERANCES:		FRACTIONS TWO (2) DECIMALS THREE (3) DECIMALS ANGLES	± 1/64 ± 0.010 ± 0.005 ± 0.5°
DRAWN:	10/28/15	BY: JW	SCALE: 1:10
		FILENAME: 316341	SIZE: B
DESCRIPTION: ASSY, ARM, SERVO, A-B, LH			
DRAWING NUMBER:			316341

Arpac BOM

Parent Number: 15269 Parent Revision: B

Description: ASSY, FINAL, MACH, EL-2100, LH

Model: EL-2121

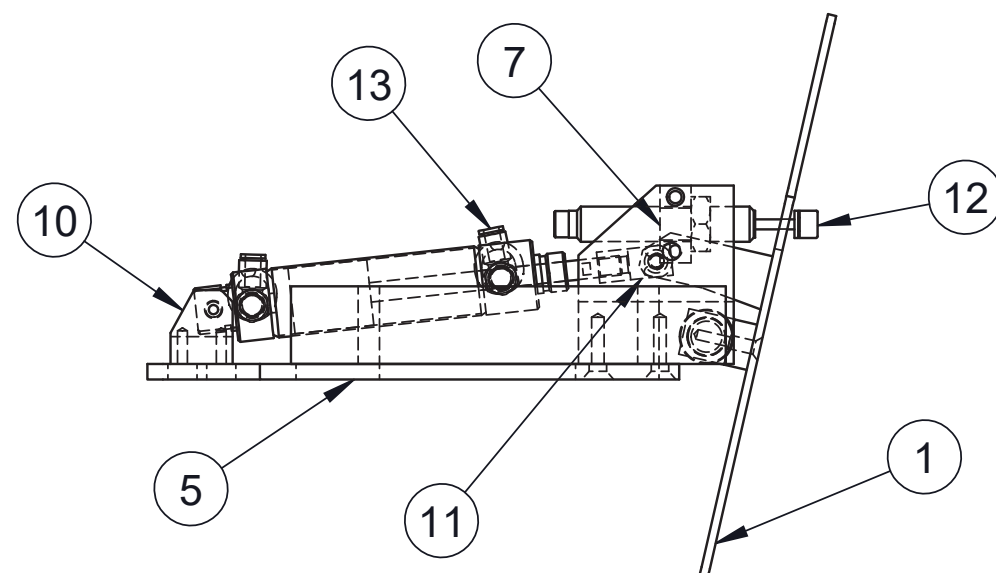
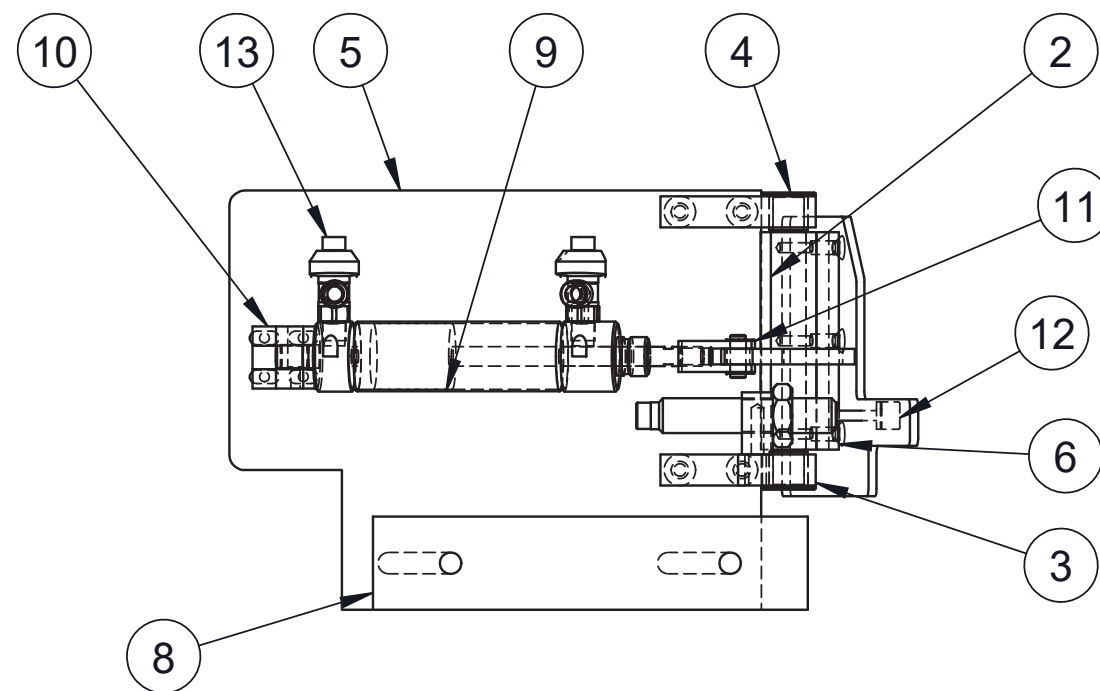
Assembly Part Number: 316341

Assembly Drawing Number: 316341

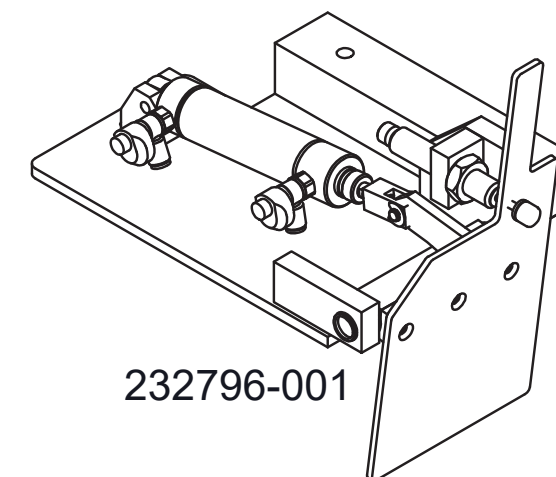
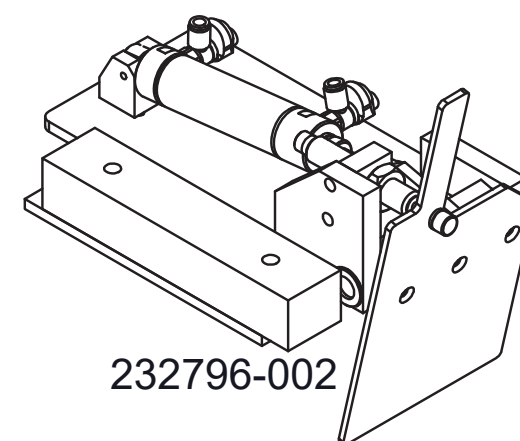
Description: ASSY, RAM, SERVO, A-B

Quantity: 1.00

Item	Qty	Arpac Part	Description
1	1.00	297587	CHANNEL, MTG, SERVO
2	1.00	231163	ASSY, BLK, BUSH, SHAFT, 1-1/4", 8" LG,
3	1.00	309151	BLK, SPACER
4	2.00	235322	SPACER, MTG, CHANNEL
5	1.00	259649	PLT, MTG, SHAFT
6	1.00	259650	WLDMNT, BKT, LH
7	2.00	300810	PLT, SUPPORT, SHAFT
8	2.00	189950	SHAFT, PIVOT
9	2.00	137693-002	SHAFT, SLIDE, PUSHER 47 17/32 LG
10	1.00	839096	MOTOR, SERVO, 37 IN-LB, 5000 RPM 460VAC KEYED/MULTI-TURN ABSOL. HIGH RES.
11	1.00	839117	GEARBOX, 10:1
12	1.00	231266	PLT, MTG, TENSIONER
13	1.00	231231	BLOCK, TENSIONER, TAPPED
14	1.00	231211	PLT, MNT, BELT CLAMP
15	1.00	231210	PLATE, CLAMPING
16	1.00	316365	WLDMT, ARM, PLT, PUSHER, LH
17	1.00	823123	PULLEY, TIMING, 32T, 8MM P, 21MM W, 1210 BUSHING REQUIRED,
18	1.00	823427	BUSHING
19	1.00	806349	SPKT, 32T, 8MM P, 21MM W, IDLER, 7720 SERIES
20	2.00	800381	BUSH, OILITE, FLG, 0.751 X 0.877 X 1, 1 OD X 1/8 THK FLG
21	1.00	822607	OBSOLETE USE 855085, CYL, AIR, 2 BORE, 5" STROKE, REAR PIVOT, 3/8 BUSH, D
22	1.00	816543	CLVS, ROD, 1/2-20, 1 3/4" - 2" BORE
23	1.00	823124	BELT, TIMING, 8MM P, 21MM W, 2400MM LG, POLY CHAIN
24	1.00	825507	BKT, PVT, SET-(1LEFT AND 1RIGHT BKT) FOR 2 & 2.5 BORE
25	1.00	304440-001	FLAG, PROX, RAM, LH
26	1.00	311587	WLDMNT, BKT, MTG, CYL, LH
27	1.00	304441	ASSY, BLK, BUSH, SHAFT, 1-1/4", 8" LG,
28	2.00	807258	WSHR, OILITE, 0.753 X 1.250 X 1/16 THK
29	2.00	822126-001	VALVE, CONTROL, FLOW, W/SEALANT, 3/8 OD PUSH-ON 1/4 NPT, NUMERIC INDICATO



232796-002 AS SHOWN
232796-001 OPPOSITE



13	2	825362-001	VALVE, CONTROL, FLOW, 1/8 NPT X 1/4 TUBE 90DEG, NUMERIC INDICATOR, MTR OUT
12	1	847799	SHOCK, 9/16-18 THRD, .63 S, W/ BUTTON (PM25 IC + BUTTON + JAM NUT)
11	1	816269	CLVS, ROD 5/16-24
10	1	230839-001	BKT, PIVOT, CYL RH
9	1	816418	CYL, AIR, 1 1/16 BORE, 2 STRK, RND PVT BUSH, DBL ACT, W/CUSHION
8	1	214331	SPACER, GATE
7	1	214329	BRACKET, SHOCK ABS.
6	1	197425	SPACER, MNT, GATE
5	1	232797-001	BKT, GATE, MTG, UPSTREAM RH
4	1	197424	BRG, SHAFT
3	1	214327	BLOCK, BRG, TOP
2	1	197423	SHAFT, GATE
1	1	230498-002	GATE, UPSTREAM
ITM	QTY	PART NUM	DESCRIPTION

BILL OF MATERIALS

ARPAC

9511 WEST RIVER ST.
SCHILLER PARK, IL 60176

UNLESS OTHERWISE SPECIFIED
ALL DIMENSIONAL TOLERANCES:
FRACTIONS ± 1/64
TWO (2) DECIMALS ± 0.010
THREE (3) DECIMALS ± 0.005
ANGLES ± 0.5°

DRAWN: 5/6/2005 BY: HHG SCALE: 1:4 SIZE: A

RELEASED: 5/6/2005 FILENAME: 232796 APPROVED BY: HHG

DESCRIPTION: ASSY, GATE, UP-STREAM

3

DRAWING NUMBER:
232796

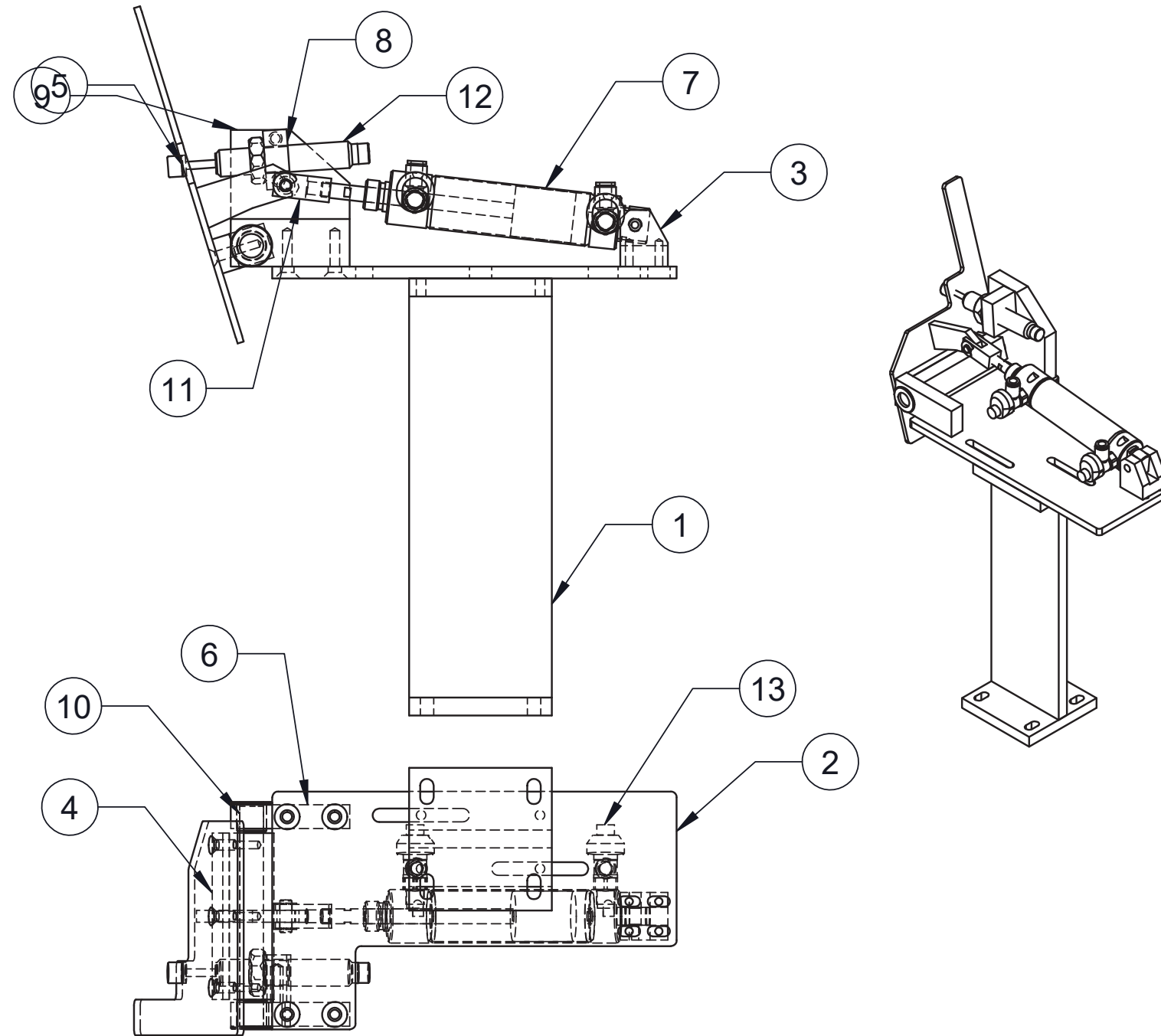
FINISH- NONE

Arpac BOM

Parent Number: 15269 Parent Revision: B
Description: ASSY, FINAL, MACH, EL-2100, LH
Model: EL-2121

Assembly Part Number: 232796-001A
Assembly Drawing Number: 232796
Description: ASSY, GATE, UPSTREAM L.H. MACH NUMATIC CYL
Quantity: 1.00

Item	Qty	Arpac Part	Description
1	1.00	230498-001	GATE, UP-STREAM, LH MACHINE
2	1.00	197423	SHAFT, GATE
3	1.00	214327	BLOCK, BRG, SHAFT GATE, TOP
4	1.00	197424	BLOCK, BRG, BOTTOM
5	1.00	232797-002	BKT, GATE, MTG, RH MACH UP STREAM
6	1.00	197425	SPACER, MNT GATE
7	1.00	214329	BKT, SHOCK ABS.
8	1.00	214331	SPACER, MTG, GATE
9	1.00	816418	OBS USE 854762, CYL, AIR, 1 1/16 BORE, 2 STRK, RND PVT BUSH, DBL ACT, W/C
10	1.00	230839-002	BKT, PIVOT, CYL RH
11	1.00	816269	OBSOLETE USE 839340, CLVS, ROD 5/16-24
12	1.00	847799	SHOCK, 9/16-18 THRD, .63 S, W/ BUTTON (PM25 IC + BUTTON + JAM NUT)
13	2.00	825362-001	VALVE, CONTROL, FLOW, 1/8 NPT X 1/4 TUBE 90DEG, NUMERIC INDICATOR, MTR OU



300692 AS SHOWN
300692-001 OPPOSITE

FINISH-NONE

13	2	825362-001	VALVE, CONTROL, FLOW, 1/8 NPT X 1/4 TUBE 90DEG, NUMERIC INDICATOR, MTR OUT
12	1	847799	SHOCK, 9/16-18 THRD, .63 S, W/ BUTTON (PM25 IC + BUTTON + JAM NUT)
11	1	816269	CLVS, ROD 5/16-24
10	1	197423	SHAFT, GATE
9	1	214327	BLOCK, BRG, TOP
8	1	214329	BRACKET, SHOCK ABS.
7	1	816418	CYL, AIR, 1 1/16 BORE, 2 STRK, RND PVT BUSH, DBL ACT, W/CUSHION
6	1	197424	BRG, SHAFT
5	1	230522-001	GATE, UPSTREAM, LH
4	1	197425	SPACER, MNT, GATE
3	1	230839-001	BKT, PIVOT, CYL RH
2	1	230835	BKT, MTG, GATE
1	1	300691	BRACKET, MTG, GATE
ITM	QTY	PART NUM	DESCRIPTION

BILL OF MATERIALS

ARPAC

9511 WEST RIVER ST.
SCHILLER PARK, IL 60176

UNLESS OTHERWISE SPECIFIED
ALL DIMENSIONAL TOLERANCES:
FRACTIONS ± 1/64
TWO (2) DECIMALS ± 0.010
THREE (3) DECIMALS ± 0.005
ANGLES ± 0.5°

DRAWN: 12/30/2004 BY: HHG SCALE: 0.25:1 SIZE: A

RELEASED: FILENAME: 300692 APPROVED BY: HHG

DESCRIPTION: ASSY, GATE, DOWN-STREAM



DRAWING NUMBER:
300692

Arpac BOM

Parent Number: 15269 Parent Revision: B
Description: ASSY, FINAL, MACH, EL-2100, LH
Model: EL-2121

Assembly Part Number: 300692
Assembly Drawing Number: 300692
Description: ASSY, GATE, DOWNSTREAM L.H. MACH
Quantity: 1.00

Item	Qty	Arpac Part	Description
1	1.00	300691	BKT, GATE, MTG
2	1.00	230835	BKT, GATE MTG, LH MACH DOWNSTREAM,
3	1.00	230839-001	BKT, PIVOT, CYL LH
4	1.00	197425	SPACER, MNT GATE
5	1.00	230522-001	GATE, DOWN STREAM LH MACH
6	1.00	197424	BLOCK, BRG, BOTTOM
7	1.00	816418	OBS USE 854762, CYL, AIR, 1 1/16 BORE, 2 STRK, RND PVT BUSH, DBL ACT, W/C
8	1.00	214329	BKT, SHOCK ABS.
9	1.00	214327	BLOCK, BRG, SHAFT GATE, TOP
10	1.00	197423	SHAFT, GATE
11	1.00	816269	OBSOLETE USE 839340, CLVS, ROD 5/16-24
12	1.00	847799	SHOCK, 9/16-18 THRD, .63 S, W/ BUTTON (PM25 IC + BUTTON + JAM NUT)
13	2.00	825362-001	VALVE, CONTROL, FLOW, 1/8 NPT X 1/4 TUBE 90DEG, NUMERIC INDICATOR, MTR OU

Arpac BOM

Parent Number: 15269 Parent Revision: B
 Description: ASSY, FINAL, MACH, EL-2100, LH
 Model: EL-2121

Assembly Part Number: 322449

Assembly Drawing Number: 322449

Description: ASSY, BLANK, TRAY, MAGAZINE, LH

Quantity: 1.00

Item	Qty	Arpac Part	Description
1	1.00	119857	NUT, ADJ, SQ
2	4.00	102341-000A	NUT, ADJ, ACME, 3/4-6
3	1.00	138328	SPKT, IDLER, SLIDING
4	4.00	119856	BLK, GUIDE, SIDE TS-25
5	2.00	224118	PLT, MTG, ADJ, MAGAZINE
6	2.00	224119	ARM, ADJ, MAGAZINE
7	2.00	224120	ARM, ADJ, MAGAZINE
8	8.00	224121	BLK, GUIDE, ADJ, MAGAZINE
9	1.00	224122-000A	XBAR, ADJ, MAGAZINE
10	1.00	224123-002	ROD, SS, 1.000, TAPPED, 1/2-13, 19.500LG
11	1.00	224123	ROD, SS, 1.000, TAPPED, 1/2-13, 21.063LG
12	1.00	224123-001	ROD, SS, 1.000, TAPPED, 1/2-13, 18.000LG
13	1.00	224124-001	BKT, MTG, SIDE, MAGAZINE, RH
14	1.00	224124-002	BKT, MTG, SIDE, MAGAZINE, LH
15	1.00	224125-001	BKT, MTG, SIDE, MAGAZINE, RH
16	2.00	819440-001	HANDWHEEL, 6 DIA, W/REVOLVING HANDLE 1/2 BORE
17	1.00	224125-002	BKT, MTG, SIDE, MAGAZINE, LH
18	1.00	244360-001	CHANNEL, SIDE RH
19	1.00	244360-002	CHANNEL, SIDE LH
20	3.00	132990	BKT, MTG, TAIL
21	1.00	132987	BLK, BUSH, SHAFT, 1.000, 6" LG. CP-25
22	1.00	132989	BKT, MTG CP-25 BLANK MAGAZINE
23	1.00	219681	SUPPORT, BLANK, VERT. LH
24	1.00	138801-002	BLANK, SUPPORT/HORIZONTAL, BLANK MAGAZINE
25	1.00	132945	ARM, SUPPORT BLANK
26	3.00	138327	SHAFT, IDLER
27	1.00	138329	SPKT, 40B18, MOD FOR OILITE BUSH, STEEL
28	1.00	123794	WLDMT, SPKT, WELDMENT
29	1.00	135716	SHAFT, DRIVE "A" 32 7/8"
30	2.00	123796	BLOCK, BRG., ADJ., HORIZ.
31	1.00	132988	SHFT, SLIDE CP-25
32	2.00	132385	SHAFT, ADJ, HORIZ, DRIVEN 33" LG
33	1.00	132386	SHAFT, ADJ, HORIZ, DRIVE, 36 3/8" LG
34	1.00	132387	SHAFT, ADJ, HORIZ, 36 3/8" LG
35	1.00	132983	BAR, GUIDE, ADJ. EL-2000
36	1.00	132982	BAR, GUIDE, ADJ, SPKT CP-25, L.H. MACH
37	4.00	123805	SPACER, FORK
38	2.00	132985	GUIDE, CHAIN
39	14.00	123807	SPACER, GUIDE, CHAIN, RH
40	1.00	132984	ANGLE, MTG, RAIL, CHN CP-25, L.H MACH
41	1.00	238401-001	GUIDE, BLANK, SHORT, LH MACH
42	2.00	800335-019	RING, SNAP, INTERNAL, 1-1/4 BORE,
43	1.00	238400-001	GUIDE, BLANK, LONG, LH EL-2000 BLANK MAGAZINE
44	4.00	224140	CROSSBAR

Arpac BOM

Parent Number: 15269 Parent Revision: B
 Description: ASSY, FINAL, MACH, EL-2100, LH
 Model: EL-2121

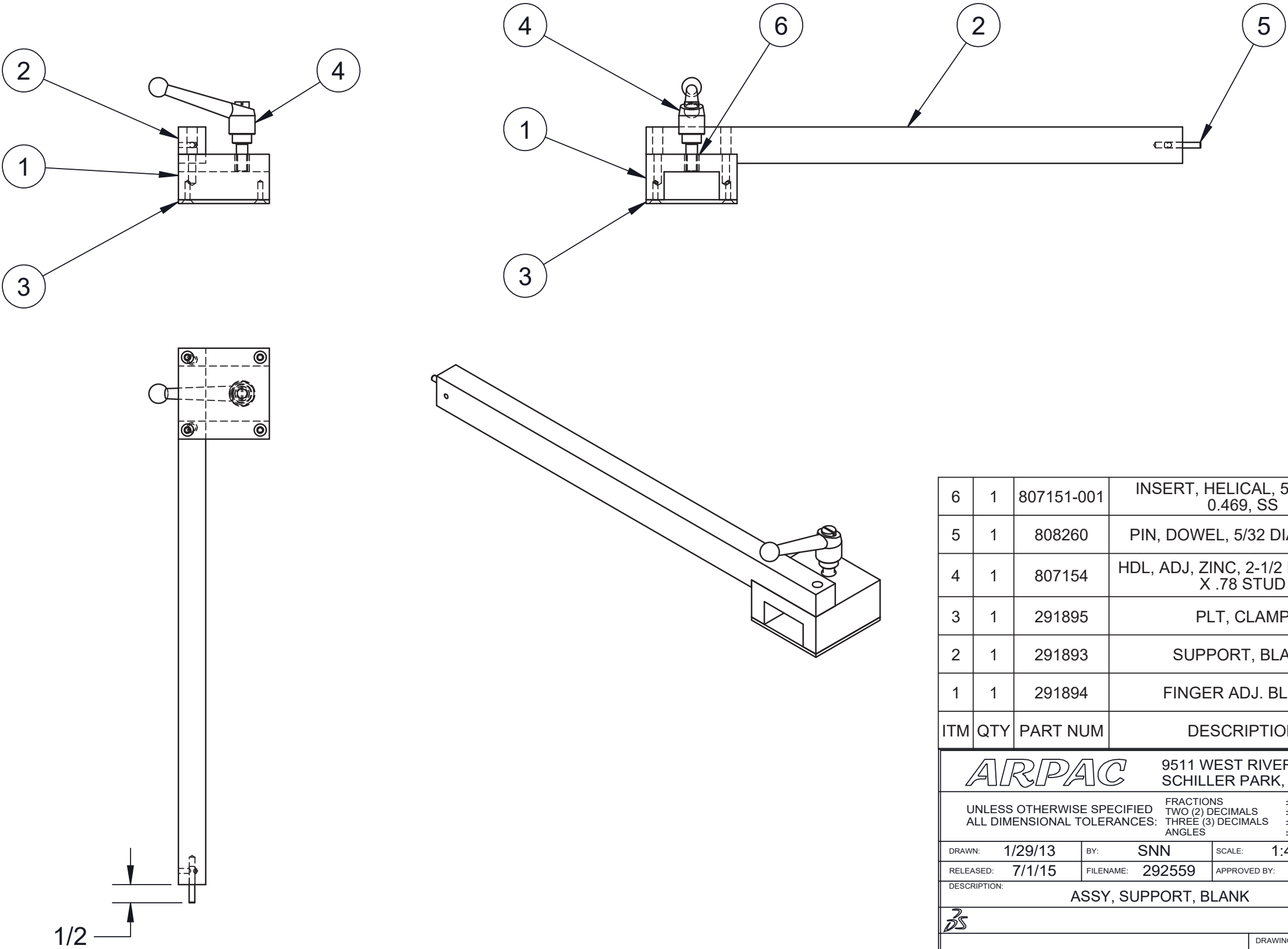
Assembly Part Number: 322449

Assembly Drawing Number: 322449

Description: ASSY, BLANK, TRAY, MAGAZINE, LH

Quantity: 1.00

Item	Qty	Arpac Part	Description
45	1.00	226283	SHAFT, PIVOT, 19 7/16 LG
46	10.00	807110	BUSH, OILITE, 1.0010 X 1.2520 X 3/4 LG,
47	2.00	132991	BAR, VERTICAL CP-25 BLANK MAGAZINE
48	1.00	227002	CROSSBAR, TOP
49	1.00	227000	PLATE, BEARING
50	2.00	227012	NUT, ADJ, VERT 3/4-6 ACME
51	2.00	322448	PLATE, NUT
52	1.00	123821	SHAFT, TOP 29 3/4" LG
53	2.00	132389	BKT, CLAMP
54	4.00	123823	FINGER, BLANK
55	1.00	218190	SHAFT, THREAD, VERT.
56	1.00	218698	SHAFT, THREAD, VERT.
57	1.00	132993	WLDMT, ARM, CYL
58	1.00	123830	WASHER, RETAINING
59	1.00	132997	SPACER, MNT, BKT, CYL
60	1.00	132996	BKT, MNT, CYL
61	1.00	101912	SPKT, 40B18, MOD, 0.750 BORE
62	1.00	224127	ROD, TAKE-UP, ARM, MAGAZINE
63	4.00	126068	RETAINER, BLANK
64	1.00	126071	BKT, REST, BLANK
65	1.00	126072	BKT, REST, BLANK
66	1.00	126073	FORK TAPPED
67	2.00	126074	FORK CLEARANCE HOLE
68	1.00	126076	FORK TAPPED FOR BLANK REST
69	1.00	224126-001	ANGLE, MTG, SIDE, MAGAZINE, RH
70	1.00	224126-002	ANGLE, MTG, SIDE, MAGAZINE, LH
71	1.00	808304	COLLAR, SHAFT, CLAMP, 1-PIECE, 1/2, S/A 850735
72	2.00	808253	COUNTER, POSITION, 1/2 ID
73	1.00	800442	WSHR, OILITE, 0.510 X 1.000 X 1/8 THK
74	2.00	808260	PIN, DOWEL, 5/32 DIA X 1 LG,
75	1.00	227006	BKT, PROX
76	2.00	306773	BRG, FLG, 3/4 ID, 3-BOLT MOD.
77	10.00	827118	BRG, FLG, 1/2 ID, 2 BOLT, 2.50 MTG HOLES
78	2.00	808214	BUSH, OILITE, 0.5025 X 0.7530 X 1 LG
79	6.00	125227	SPKT, 35B17, MOD, 0.500 BORE, W/KEYWAY, SET SCR
80	3.00	808257	ROD, ADJ, 1/2 DIA X 5 LG, 5/16-18 TAPPED THREAD, SS
81	4.00	800446	WSHR, OILITE, 0.507 X 0.750 X 1/16 THK,
82	1.00	801931	OBSOLETE USE 855086, CYL, AIR, 1-1/4 BORE, 1/2 STROKE, AL SQUAREHEAD, CL
83	1.00	808259	CLUTCH, ROLLER, DC 3/4 ID X 1 OD X 5/8 LG. (NOM.)
84	1.00	808258	RING, INNER 1/2 ID X 3/4 OD X 3/4 LG. (NOM.)
85	1.00	220240	FLAG, PROX, BLANK MAGAZINE, 6" LG
86	1.00	101092-003	(SEE COMMENTS) ASSY, BLK, BUSH, SHAFT, 1
87	1.00	224128	BAR, ADJ, TAKE-UP, ARM, MAGAZINE, 18 LG
88	2.00	224129	ROD, END, BAR, TAKE-UP



REVISIONS			
RV	DATE	BY	DESCRIPTION
A	7/1/2015	SRA	ADDED ITEM 6 HELICAL INSERT

6	1	807151-001	INSERT, HELICAL, 5/16-18 X 0.469, SS
5	1	808260	PIN, DOWEL, 5/32 DIA X 1 LG,
4	1	807154	HDL, ADJ, ZINC, 2-1/2 LG 5/16-18 X .78 STUD
3	1	291895	PLT, CLAMP
2	1	291893	SUPPORT, BLANK
1	1	291894	FINGER ADJ. BLOCK
ITM	QTY	PART NUM	DESCRIPTION

ARPAC		9511 WEST RIVER ST. SCHILLER PARK, IL 60176	
UNLESS OTHERWISE SPECIFIED		FRACTIONS	± 1/64
ALL DIMENSIONAL TOLERANCES:		TWO (2) DECIMALS	± 0.010
		THREE (3) DECIMALS	± 0.005
		ANGLES	± 0.5°
DRAWN:	1/29/13	BY:	SNN
RELEASED:	7/1/15	SCALE:	1:4
DESCRIPTION:		APPROVED BY:	SRA
		ASSY, SUPPORT, BLANK	
		DRAWING NUMBER: 292559	

Arpac BOM

Parent Number: 15269 Parent Revision: B
 Description: ASSY, FINAL, MACH, EL-2100, LH
 Model: EL-2121

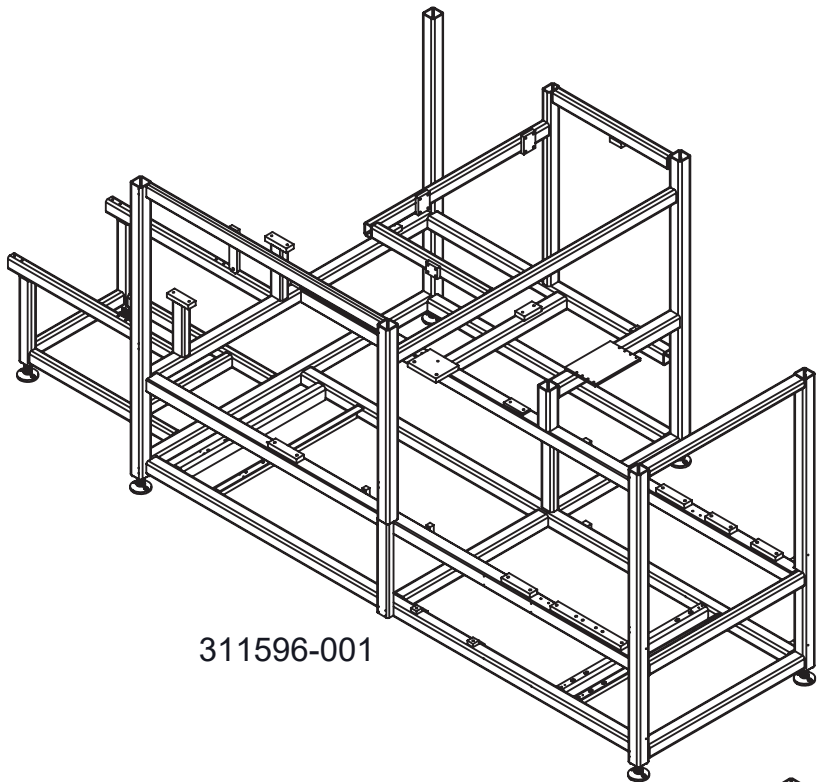
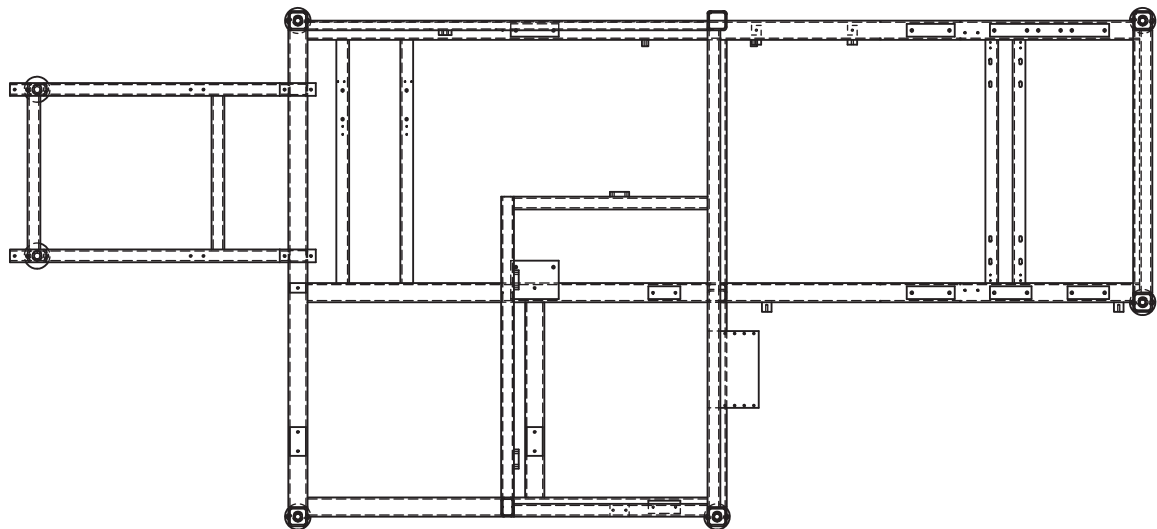
Assembly Part Number: 322449

Assembly Drawing Number: 322449

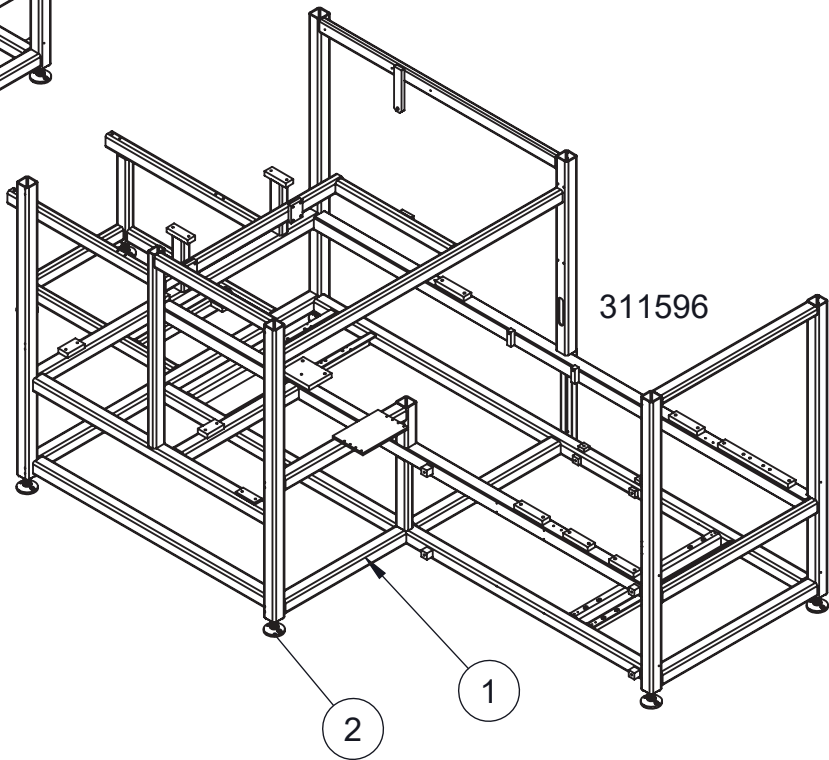
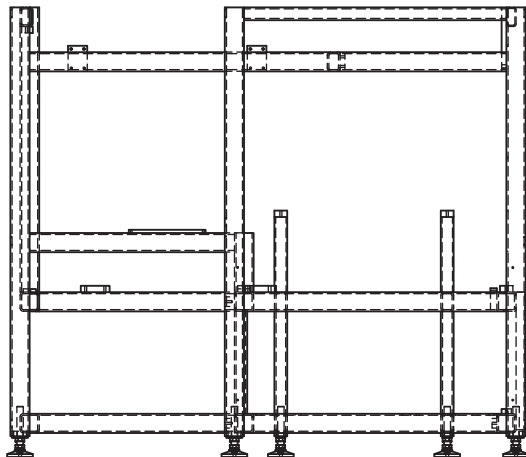
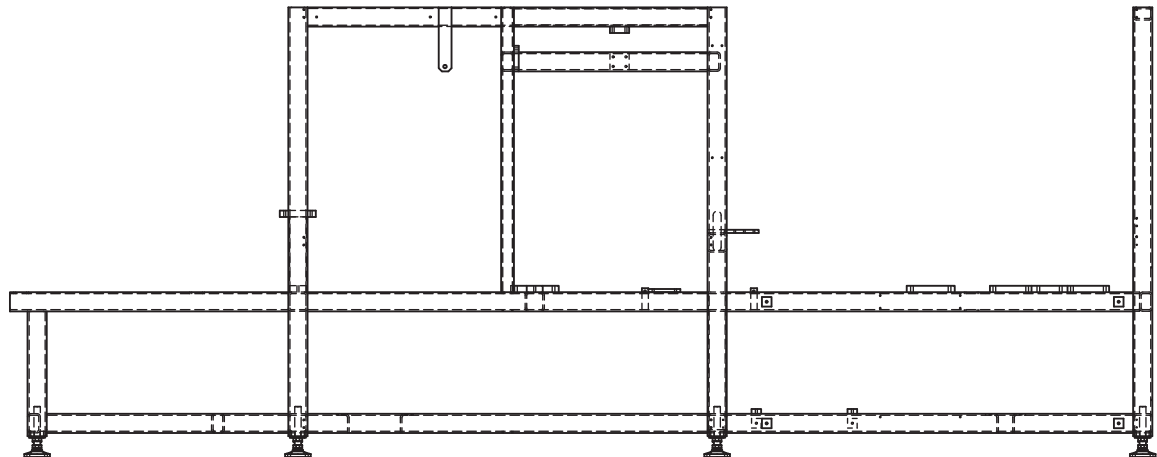
Description: ASSY, BLANK, TRAY, MAGAZINE, LH

Quantity: 1.00

Item	Qty	Arpac Part	Description
89	1.00	822652	COUNTER, POSITION, 5/8 BORE, 0.01 RES CLOCKWISE ROTATION
90	1.00	133000	GUARD, CYL, LH CP-25
91	1.00	219257	GUARD, FRONT 33" LG
92	2.00	132398	BLK, ADJ, FINGER
93	2.00	132399	FINGER, BLANK, A=10.44
94	1.00	132400	FINGER, BLANK, FIXED
95	2.00	132401	SHOE, ADJ
96	2.00	808027	HDL, ADJ, ZINC, 2-1/2 LG 5/16-18 X .59 STUD
97	1.00	822743	CPLG, 5/8 X 5/8 X 1.5 OD X 2.25 LG 4-BOLT CLAMP
98	20.00	800459	CHAIN, RLR, #35, RLR RVT
99	2.00	800660	COLLAR, SHAFT, CLAMP, 1-PIECE, 1"-8, THREADED ID, STAINLESS STEEL
100	32.00	800462	CHN, RLR, #40, RLR RVT
101	10.00	800600	COLLAR, SHAFT, CLAMP, 1-PIECE, 1
102	1.00	810131	BUSH, OILITE, FLG, 1.003 X 1.254 X 1 1/2 OD X 1/8 THK FLG
103	1.00	810133	WSHR, OILITE, 1.012 X 1.750 X 1/8 THK
104	1.00	808597	BUSH, OILITE, 1.003 X 1.254 X 1-1/2
105	1.00	800385	BUSH, OILITE, 0.7520 X 1.0040 X 1/2 LG
106	1.00	807903	BUSH, OILITE, FLG, 0.502 X 0.753 X 7/8 1 OD X 1/8 THK FLG
107	2.00	806082	PIN, CLEVIS, DETACHABLE 1.25 BORE
108	1.00	806081	CLVS, ROD FOR 1-1/4 BORE CYL,
109	1.00	142871	TENSIONER, UPPER CHAIN
110	1.00	226918	ADAPTER, WRENCH
111	1.00	227001	PLATE, BEARING & COUNTER
114	1.00	836881	COUNTER, POSITION, 1/2 ID, COUNTERCLOCKWISE INCREMENT
115	2.00	222285	BKT, SIDE HOLDER
116	1.00	222284-001	HOLDER, SIDE, BLANK, RH
117	1.00	222284-002	HOLDER, SIDE, BLANK, LH
118	1.00	238402	PLT, STIFF 16.5 LG
119	1.00	238403	PLT, STIFF 18 LG
120	1.00	237856	BKT, PE, MINI
121	4.00	256149	TAKE-UP, CHAIN
122	1.00	292559	ASSY, SUPPORT, BLANK
123	1.00	833000	BRG, THRUST, 5/8 ID X 1 11/32 OD X 9/16, SHIELDED
124	1.00	849688	KNOB, STEEL KNURLED-RIM, W/SET SCREW



311596-001



311596

2	7	827619	LEVELER, ARTICULATING, 20000 # CAP, 1-8 STEM, 7.88 HIGH, CRS 4" BASE, 2 C'SUNK LAG HOLES, HEAVY LIP ON BASE
1	1	311595	WLDMT, FRAME, MAIN, LH
ITM	QTY	PART NUM	DESCRIPTION

BILL OF MATERIALS



9511 WEST RIVER ST.
SCHILLER PARK, IL 60176

UNLESS OTHERWISE SPECIFIED
ALL DIMENSIONAL TOLERANCES:

FRACTIONS
TWO (2) DECIMALS ± 1/64
THREE (3) DECIMALS ± 0.010
ANGLES ± 0.005
± 0.5°

DRAWN: 7/16/12 BY: SCALE: 1:30 SIZE: B

FILENAME: 311596

DESCRIPTION: ASSY, FRAME, EL-2100

3

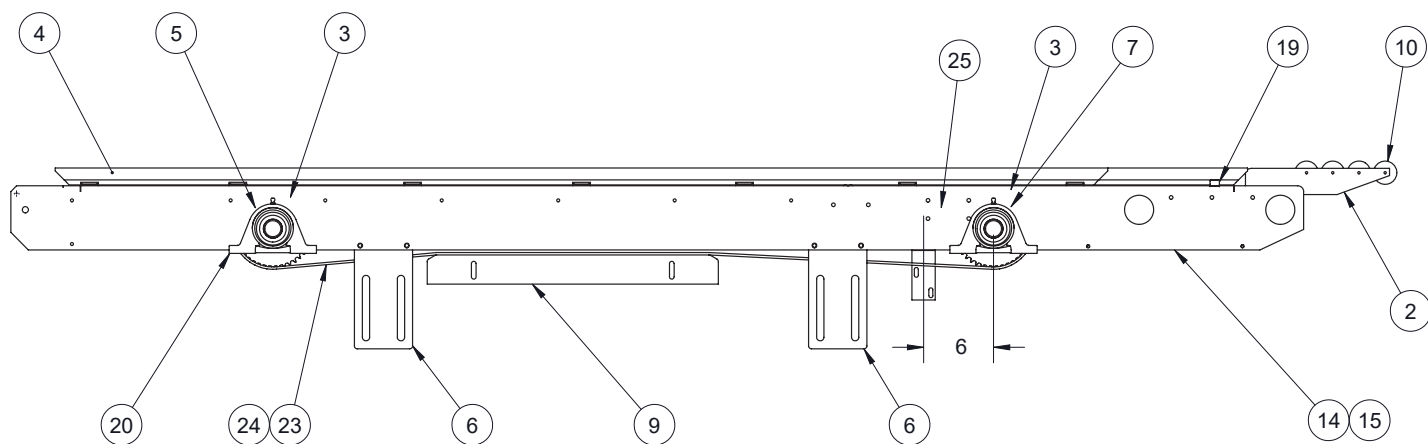
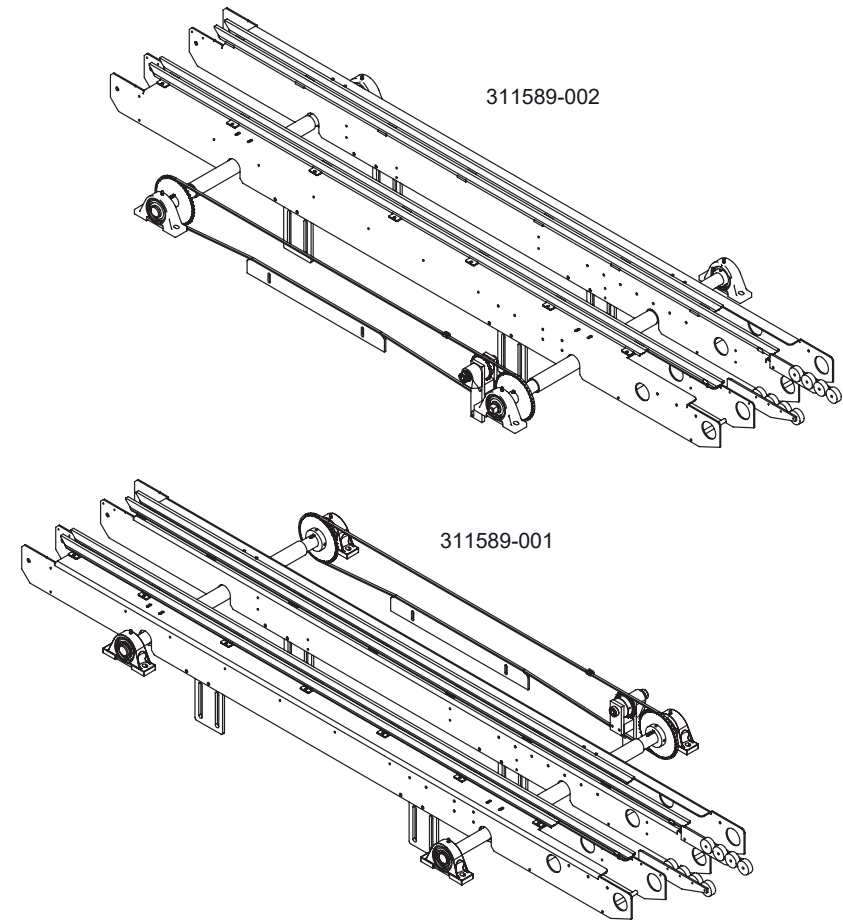
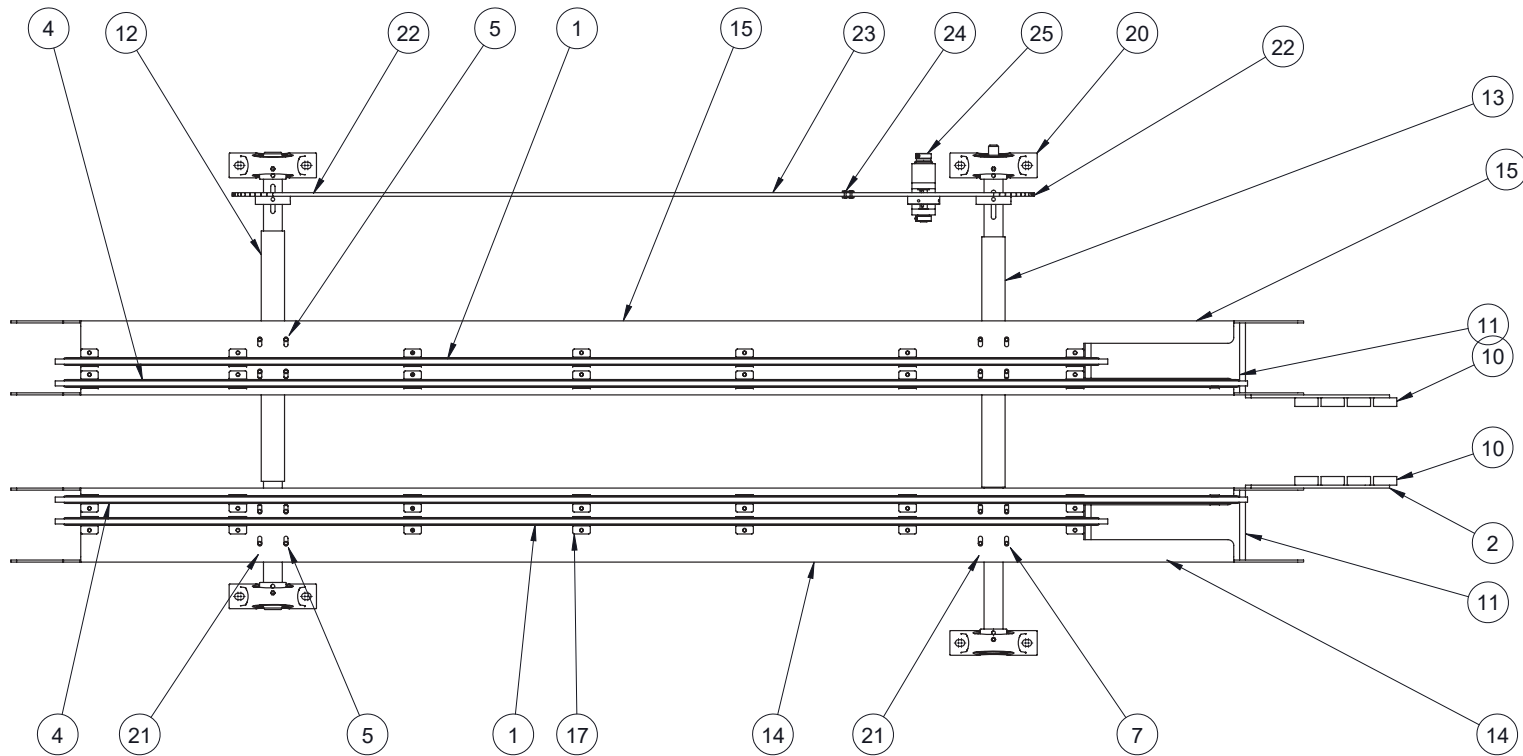
DRAWING NUMBER:
311596

Arpac BOM

Parent Number: 15269 Parent Revision: B
Description: ASSY, FINAL, MACH, EL-2100, LH
Model: EL-2121

Assembly Part Number: 311596
Assembly Drawing Number: 311596
Description: ASSY, FRAME, LH MACHINE
Quantity: 1.00

Item	Qty	Arpac Part	Description
1	1.00	311595	WLDMT, FRAME, MAIN, EL-2100, LH
2	7.00	827619	LEVELER, ARTICULATING, 20000 # CAP, 1-8 STEM, 7.88 HIGH, CRS 4" DIA X 2"



25	1	227062	ASSY, COUNTER
24	1	800502	LINK, CONN, #40,
23	12	800462	CHAIN, RLR, #40, RLR RVT,
22	2	135705	SPKT, 40B42, MOD, 1.625 BORE
21	4	809964	COLLAR, SHAFT, SET SCREW, 1-5/8
20	4	809961	BRG, PILLOW BLK, 1-5/8 ID STANDARD SERIES
19	2	801315	CLIP, RAIL, SELFTIGHTENING, 1/4 STUD X 0.66 LG, SS, LIGHT DUTY
18	1	802411	WRENCH (NOT SHOW)
17	28	801359	CLAMP, RAIL, SINGLE, 1.5 LG, SS, ROUND HOLE
15	1	311588-001	RAIL, INDEX CONV., LH
14	1	311588	RAIL, INDEX CONV., RH
13	1	215081	SCREW, ADJ, REAR
12	1	215065	SCREW, ADJ, FRONT
11	4	191224	SPACER, RAIL
10	8	139121	ROLLER, TRANSFER
9	1	138447	SUPPORT, GUIDE CHAIN
7	2	137181	BLK, FIXED, RAIL ADJ
6	4	230245	BKT, MNT, TENSIONER
5	2	132486	BLK, THREAD, RAIL ADJ
4	2	122102-100	CHAIN GUIDE, #60 (LONG)
3	4	230232	SPACER, RAIL
2	2	230229	PLT. TRANSFER
1	2	122101-100	CHAIN GUIDE, #60 (SHORT)

ITM	QTY	PART NUM	DESCRIPTION	
BILL OF MATERIALS				
ARPAC			9511 WEST RIVER ST. SCHILLER PARK, IL 60176	
UNLESS OTHERWISE SPECIFIED ALL DIMENSIONAL TOLERANCES:			FRACTIONS ± 1/64 TWO (2) DECIMALS ± 0.010 THREE (3) DECIMALS ± 0.005 ANGLES ± 0.5°	
DRAWN: 04/03/2006		BY: HHG	SCALE: 0.09375:1	SIZE: C
RELEASED: 04/03/2006		FILENAME: 311589	APPROVED BY: HHG	
DESCRIPTION: ASSY, RAIL, SUPPORT				
			DRAWING NUMBER: 311589	

Arpac BOM

Parent Number: 15269 Parent Revision: B

Description: ASSY, FINAL, MACH, EL-2100, LH

Model: EL-2121

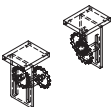
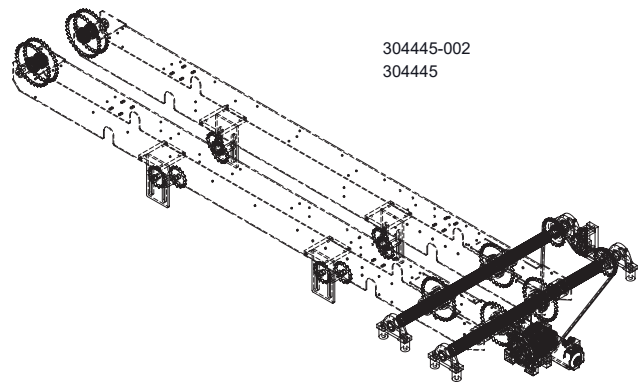
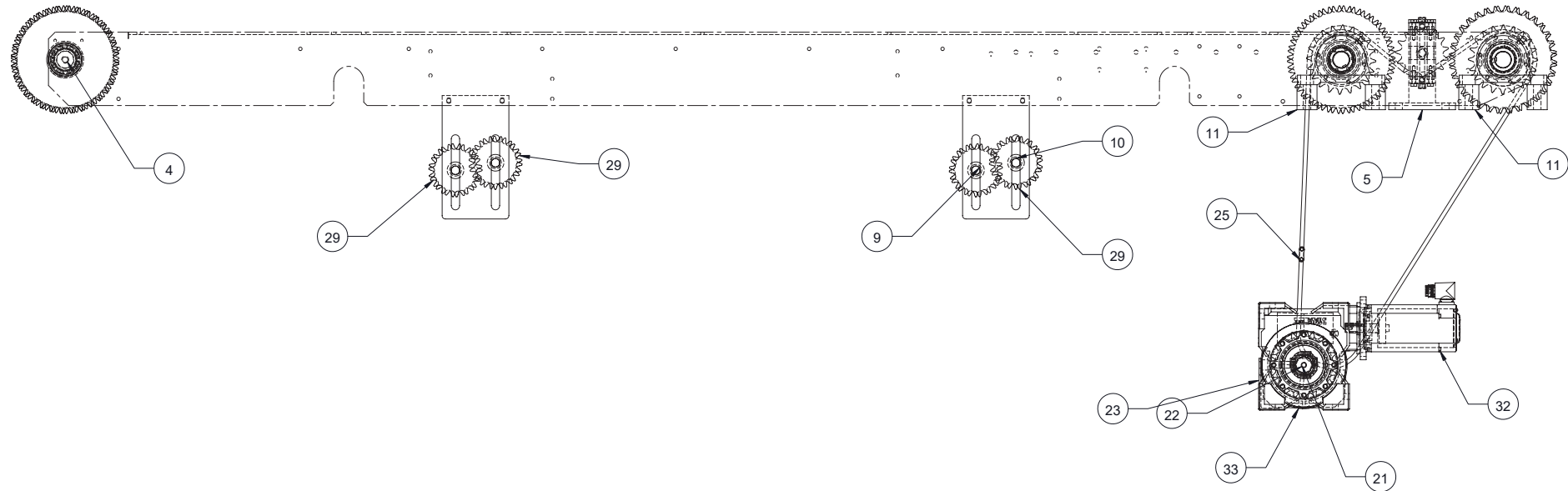
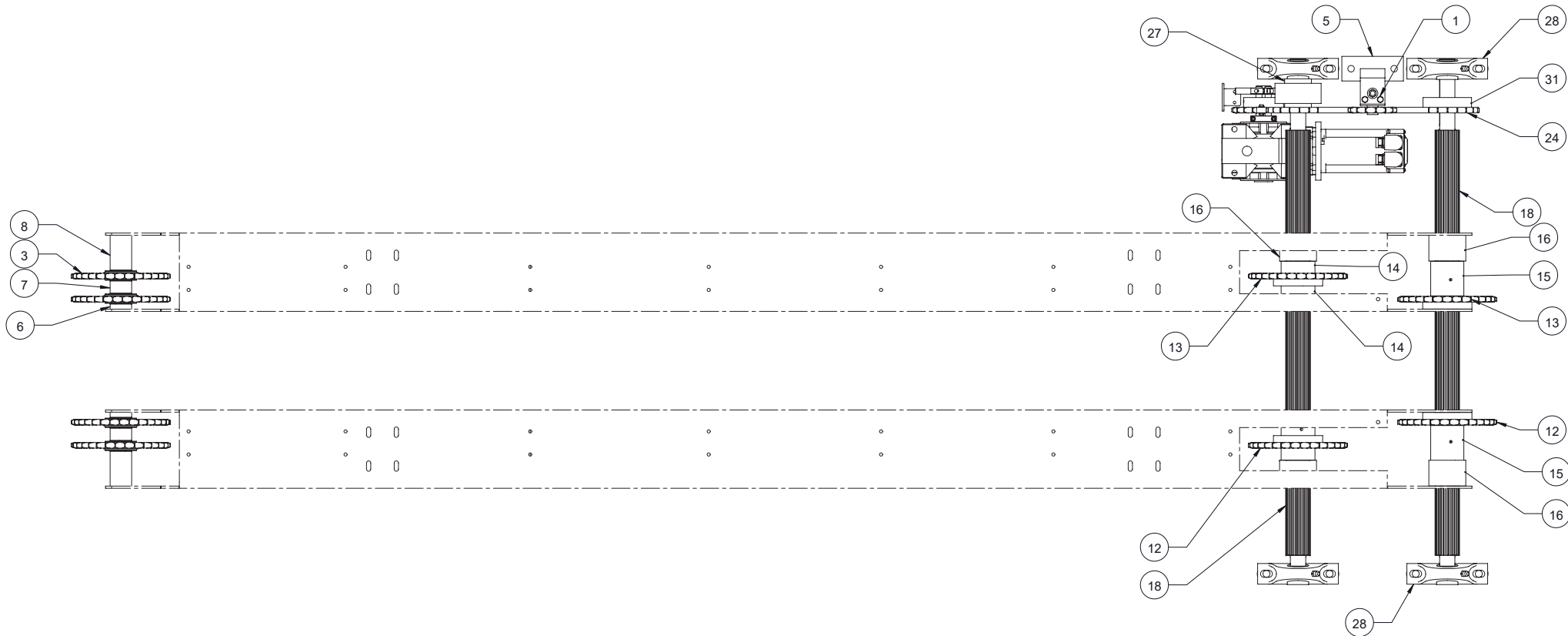
Assembly Part Number: 311589

Assembly Drawing Number: 311589

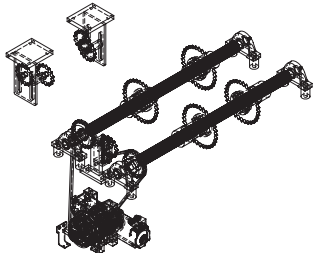
Description: ASSY, RAIL, SUPPORT, LH MACH

Quantity: 1.00

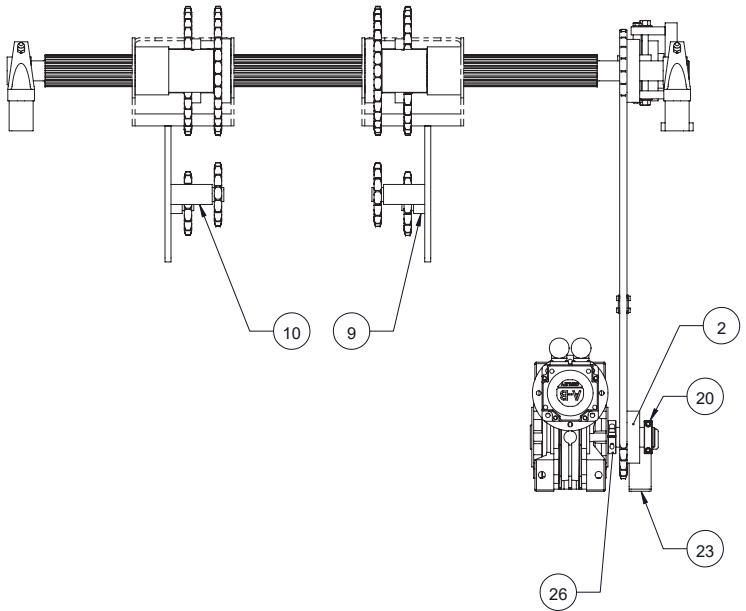
Item	Qty	Arpac Part	Description
1	2.00	122101-100B	GUIDE, #60 CHAIN, SHORT
2	2.00	230229	PLT, TRANSFER EL-2000
3	4.00	230232	SPACER, RAIL
4	2.00	122102-100B	GUIDE, #60 CHAIN, LONG
5	2.00	132486	BLK, THREAD, RAIL ADJ
6	4.00	230245	WLDMT, BKT, MNT, TENSIONER
7	2.00	137181	BLK, FIXED, RAIL ADJ
9	1.00	138447	SUPPORT, CHAIN, GUIDE, 25 LG TS-25 STD
10	8.00	139121	ROLLER TRANSFER
11	4.00	191224	SPACER, RAIL
12	1.00	215065	SCREW, ADJ, FRONT
13	1.00	215081	SCREW, ADJ, REAR
14	1.00	311588	RAIL, INDEX CONV, RH
15	1.00	311588-001	RAIL, INDEX CONV, LH
17	32.00	801359	CLAMP, RAIL, SINGLE, 1.5 LG, SS, ROUND HOLE
18	1.00	802411	WRENCH, RATCHET 7/8 SQ X 16-1/2 LG
19	4.00	801315	CLIP, RAIL, SELF TIGHTENING, 1/4 STUD X 0.66 LG, SS, LIGHT DUTY
20	4.00	809961	BRG, PILLOW BLK, 1-5/8 ID STANDARD SERIES
21	4.00	809964	COLLAR, SHAFT, SET SCREW, 1 5/8
22	2.00	135705	SPKT, 40B42, MOD, 1.625 BORE
23	12.00	800462	CHN, RLR, #40, RLR RVT
24	1.00	800502	CHN, LINK, CONN, #40
25	1.00	227062	ASSY, COUNTER



304445-001



ASSY NO.	304445-001	304445-003
ASSY NO.	304445	304445-002
ITEM 32	839096	819882-003
VOLTAGE	460V	230V



REVISIONS			
RV	DATE	BY	DESCRIPTION
A	10/29/2015	JW	ADD TABLE TO SHOW BOM W/ VOLTAGE

33	1	848066	GEARBOX, WORM, , MODEL 70, RATIO 40:1, 1-1/4 HOLLOW SHAFT
32	1	SEE TABLE	MOTOR, SERVO, 3/4 IN-LB, 5000 RPM KEYED/MULTI-TURN ABSOL. HIGH RES.
31	1	823423	SPKT, 60BTB20H REQUIRE 2012 BUSHING
30	1	808765	BUSH, TAPER, 1-1/4 BORE X 1-1/4 LG, FOR METRIC SPROCKET 30 TEETH
29	9	808463	SPKT, 60BB15H, IDLER, 5/8 ID, HARDENED
28	4	807444	BRG, PILLOW BLK, 1-1/4 ID
27	1	800610	CPLG, PHASE-LOCK 1-1/4 BORE
26	1	800594	COLLAR, SHAFT, CLAMP, 2-PIECE, 1-1/4
25	1	800516	LINK, CONN. #60, COATED
24	1	800486	CHAIN, RLR, #60
23	1	305246	BKT, PROX, FLAG
22	1	304449	WASHER, STOP
21	1	304448	SHAFT, DRIVE
20	1	304446	FLAG, PROX
18	2	214311	SHAFT, SPLINE
17	1	193095	SPKT, 60A20, MOD, 1.250 BORE
16	4	191213	SPACER, DRV SHFT
15	2	191212	CARRIER, DRV SPKT, TRAILING CHAIN
14	2	191211	CARRIER, DRV SPKT, LEADING CHAIN
13	2	191210	SPROCKET, 60A32, DRIVE, ADJ
12	2	191209	SPROCKET, 60A32, DRIVE
11	8	188012	SPACER, BRG, DRIVE SHAFT
10	4	139617-002	SPACER, TENSIONER
9	4	139617-001	SPACER, TENSIONER
8	2	139615-003	SPACER, IDL SHFT
7	2	139615-002	SPACER, IDL SHFT
6	2	139615-001	SPACER, IDL SHFT
5	1	132925	WLDMT, BKT, MTG, TAKEUP
4	2	122244	SHFT, IDL
3	4	122106	SPKT, 60A32, MOD, 2.562 BORE
2	1	112736	SPKT, 60B20, MOD, 1.250 BORE
1	1	101965	ASSY, SLIDE, TAKE-UP, CHAIN, 2.250, STD
ITM	QTY	PART NUM	DESCRIPTION

BILL OF MATERIALS			
		9511 WEST RIVER ST. SCHILLER PARK, IL 60176	
UNLESS OTHERWISE SPECIFIED ALL DIMENSIONAL TOLERANCES:		FRACTIONS TWO (2) DECIMALS THREE (3) DECIMALS ANGLES	± 1/64 ± 0.010 ± 0.005 ± 0.005
DRAWN:	6/30/11	BY:	SCALE: 1:6 SIZE: D
FILENAME:		304445	
DESCRIPTION: ASSY, CHAIN DRIVE, EL-2000, AMD=21,			
			DRAWING NUMBER: 304445

Arpac BOM

Parent Number: 15269 Parent Revision: B

Description: ASSY, FINAL, MACH, EL-2100, LH

Model: EL-2121

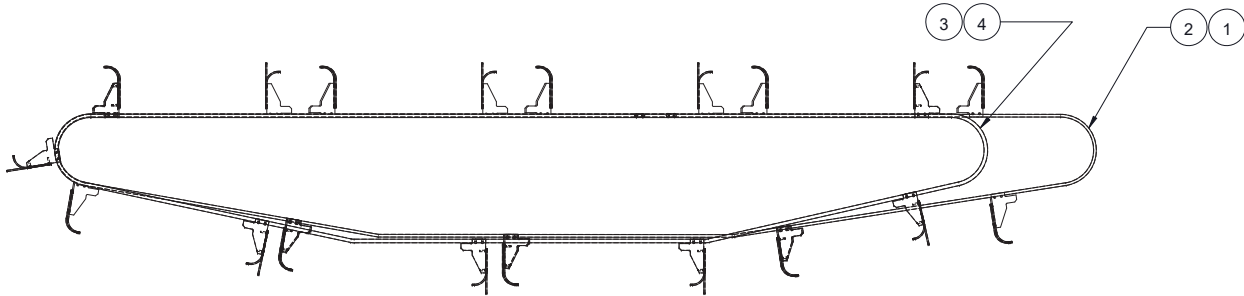
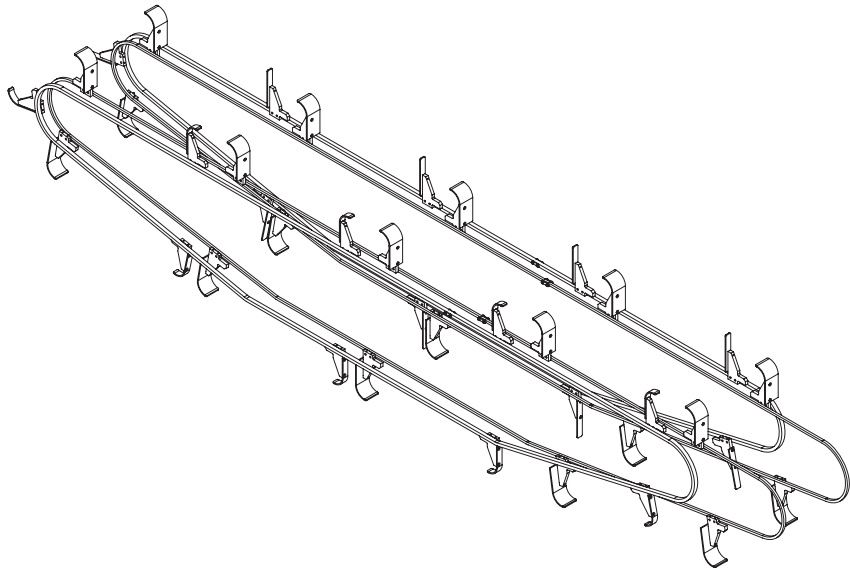
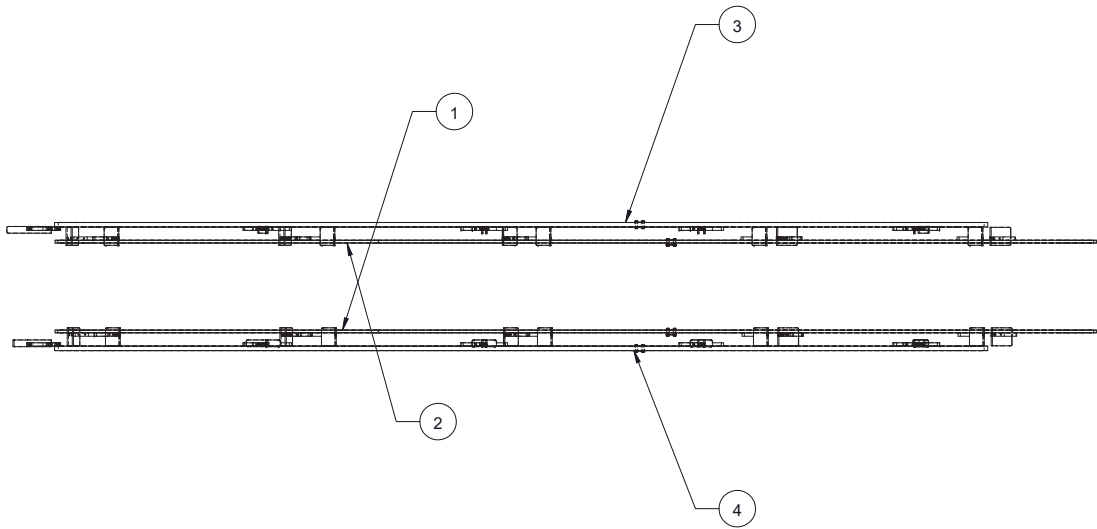
Assembly Part Number: 304445

Assembly Drawing Number: 304445

Description: ASSY, CHAIN DRIVE, LH MACHINE EL-2000, 460V

Quantity: 1.00

Item	Qty	Arpac Part	Description
1	1.00	101965	ASSY, SLIDE, TAKE-UP, CHAIN, 2.250, STD,
2	1.00	112736	SPKT, 60B20, MOD, 1.250 BORE
3	4.00	122106	SPKT, 60A32, MOD, 2.562 BORE
4	2.00	122244	SHAFT, IDL, 1.25 D X 6 L, 1/2-13 (2)
5	1.00	132925	WLDMT, BKT, TAKE UP
6	2.00	139615-001	SPACER, IDL SHFT
7	2.00	139615-002	SPACER, IDL SHFT
8	2.00	139615-003	SPACER, IDL SHFT
9	4.00	139617-001	SPACER, TENSSION SPKT
10	4.00	139617-002	SPACER, TENSSION SPKT
11	8.00	188012	SPACER, BRG, DRIVE SHAFT
12	2.00	191209	SPKT, 60A32, MOD, 2.753 BORE
13	2.00	191210	SPKT, 60A32, MOD, 2.753 BORE, ADJ
14	2.00	191211	CARRIER, DRV SPKT, LEADING CHAIN
15	2.00	191212	CARRIER, DRV SPKT, TRAILING CHAIN
16	4.00	191213	SPACER, CHAIN DRV
17	1.00	193095	SPKT, 60A20, MOD, 1.313 BORE, SPECIAL FOR PHASE ADJ
18	1.00	214311	SHAFT, SPLINE, 42 5/8 LG, TS-25
19	1.00	214312	SHAFT, SPLINE, ADJ, 43 1/4 LG, TS-25
20	1.00	304446	WLDMT, FLAG, PROX
21	1.00	304448	SHAFT, DRIVE
22	1.00	304449	WASHER, STOP
23	1.00	305246	BKT, PROX, FLAG
24	1.00	800486	CHAIN, RLR, #60
25	1.00	800516	LINK, CONN, #60,
26	1.00	800594	COLLAR, SHAFT, CLAMP, 2-PIECE, 1-1/4
27	1.00	800610	CPLG, PHASE-LOCK 1-1/4 BORE
28	4.00	807444	BRG, PILLOW BLK, 1-1/4 ID
29	9.00	808463	SPKT, 60BB15H, IDLER, 5/8 ID, HARDENED
30	1.00	808765	BUSH, TAPER, 1-1/4 BORE X 1-1/4 LG, FOR METRIC SPROCKET 30 TEETH
31	1.00	823423	SPKT, 60BTB20H REQUIRE 2012 BUSHING
32	1.00	839096	MOTOR, SERVO, 37 IN-LB, 5000 RPM 460VAC KEYED/MULTI-TURN ABSOL. HIGH RES.
33	1.00	848066	GEARBOX, WORM, , MODEL 70, RATIO 40:1, 1-1/4 HOLLOW SHAFT, W/ADAPTER PLA



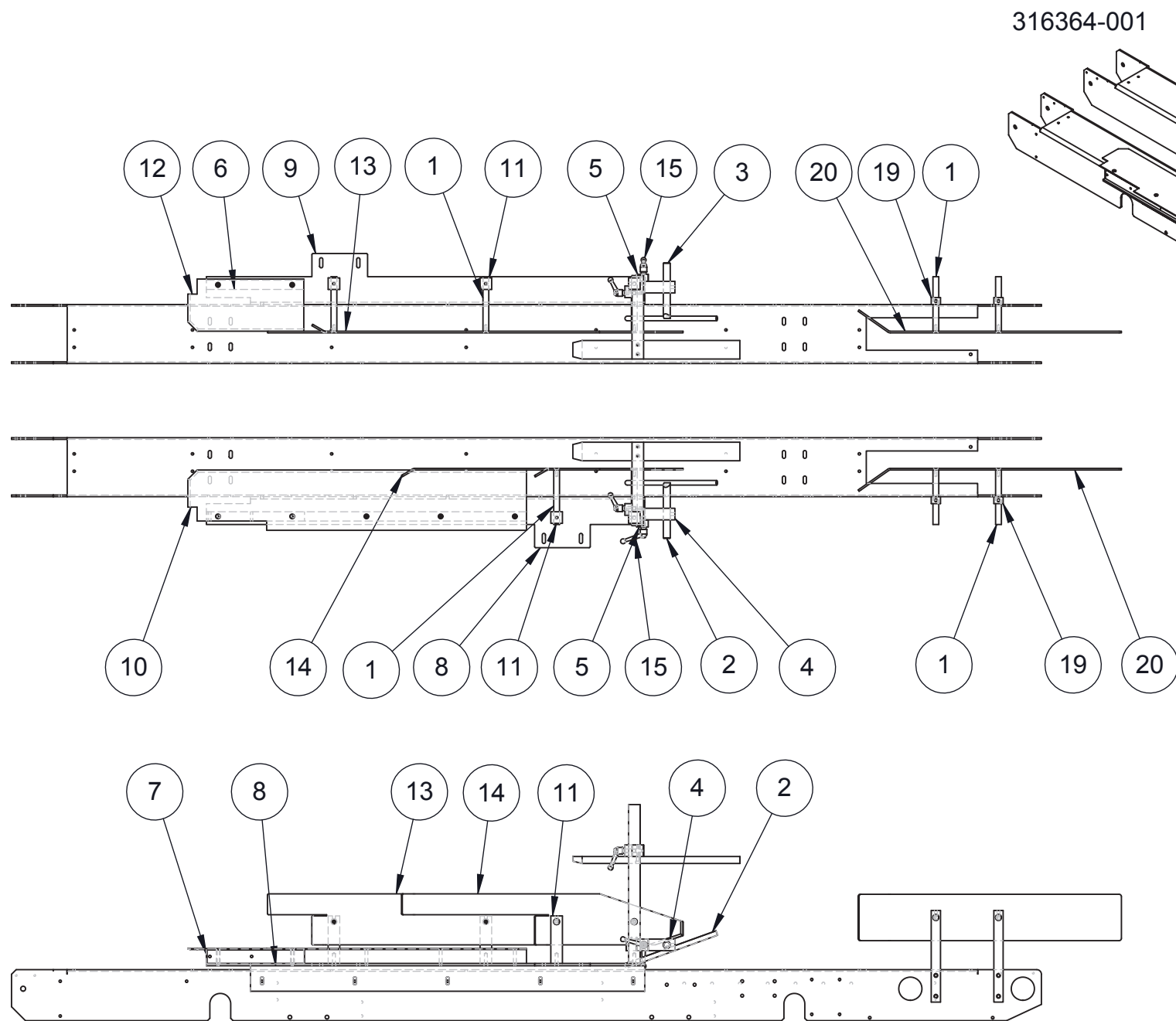
4	1	141291-001	ASSY, FLIGHT, LEADING, RH
3	1	141291-002	ASSY, FLIGHT, LEADING, LH
2	1	230434-002	ASSY, FLIGHT, TRAILING, LH
1	1	230434-001	ASSY, FLIGHT, TRAILING, RH
ITM	QTY	PART NUM	DESCRIPTION
BILL OF MATERIALS			
ARPAC		9511 WEST RIVER ST. SCHILLER PARK, IL 60176	
UNLESS OTHERWISE SPECIFIED		FRACTIONS	± 1/64
ALL DIMENSIONAL TOLERANCES:		TWO (2) DECIMALS	± 0.010
		THREE (3) DECIMALS	± 0.005
		ANGLES	± 0.5°
DRAWN:	7/5/11	BY: HG	SCALE: 0.09375:1 SIZE: D
RELEASED:	3/14/14	FILENAME: 230844	APPROVED BY: SRA
DESCRIPTION: ASSY, CHAIN, LUG			
DRAFTER: [Signature]			DRAWING NUMBER: 230844

Arpac BOM

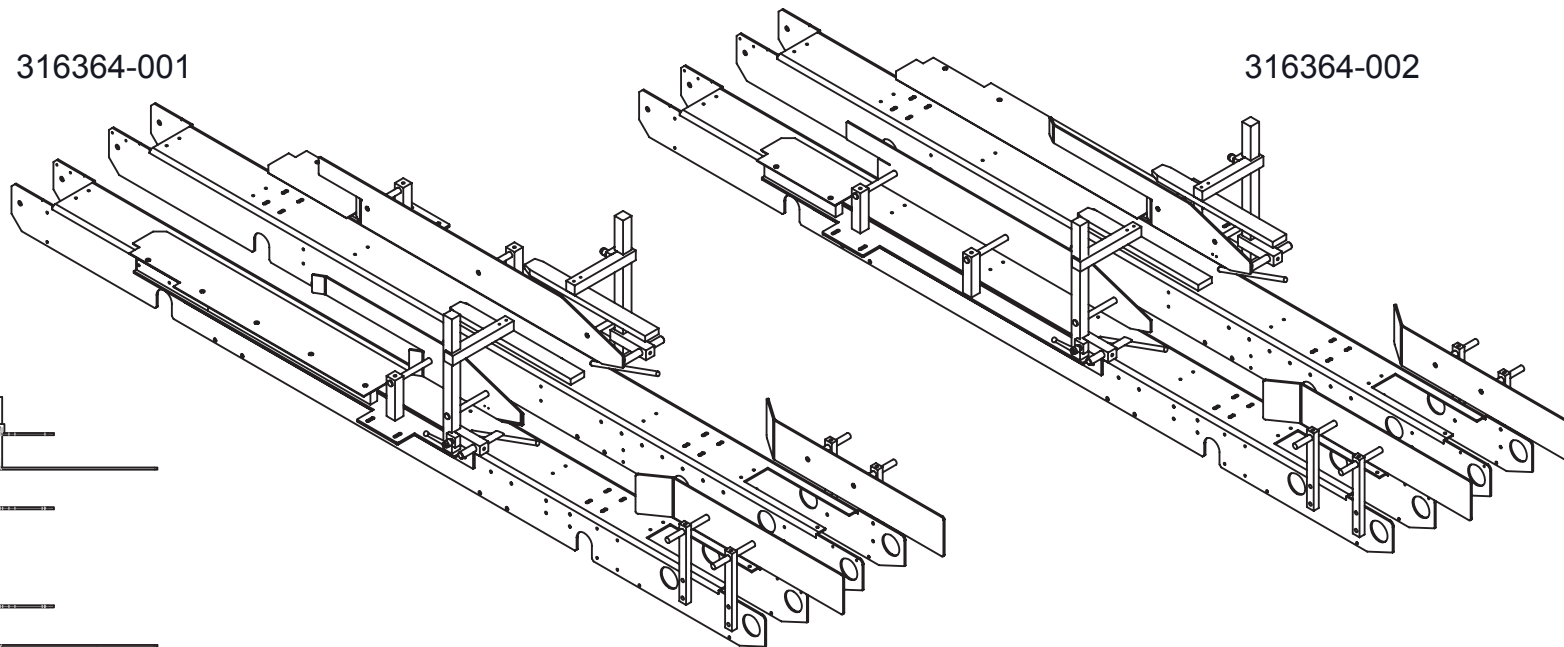
Parent Number: 15269 Parent Revision: B
Description: ASSY, FINAL, MACH, EL-2100, LH
Model: EL-2121

Assembly Part Number: 230844
Assembly Drawing Number: 230844
Description: ASSY, CHAIN, LUG
Quantity: 1.00

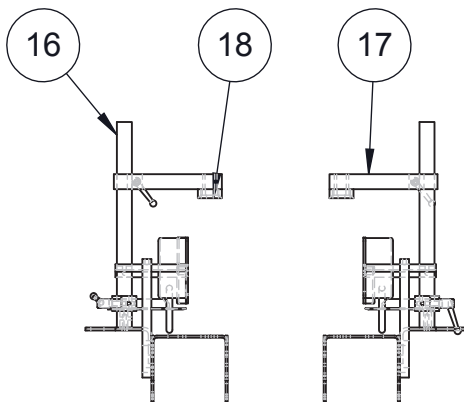
Item	Qty	Arpac Part	Description
1	1.00	230434-001	ASSY, FLIGHT, TRAILING, RH
2	1.00	230434-002	ASSY, FLIGHT, TRAILING, LH
3	1.00	141291-002	ASSY, FLIGHT, LEADING, LH
4	1.00	141291-001	ASSY, FLIGHT, LEADING, RH
5	152.00	900077	AL FLAT 3/8 X 3, 6061-T6511
6	250.00	plating	PLATING FOR PARTS
7	254.00	903575	SS SHEET 10GA, 304, #2B FINISH



316364-001



316364-002



20	2	243944	GUIDE, EXIT
19	4	243947	BKT, MTG, GUIDE, EXIT
18	2	322537	TOP GUIDE
17	2	322536	BAR, MTG, TOP GUIDE
16	2	235763	POST, MTG, GUIDE, TALL
15	4	806464	HDL, ADJ, ZINC, 2-1/2 LG 3/8-16 X 1.18 STUD
14	1	292547-001	GUIDE, PRODUCT, LOAD SIDE, LH
13	1	292129-001	GUIDE, SIDE, TRAY, LH
12	1	243950-001	GUIDE, FLAP HOLD DOWN, OPP. LOAD, LH
11	3	235764	POST, MTG, GUIDE
10	1	233497-001	GUIDE, FLAP HOLD DOWN, LOAD SIDE, LH
9	1	228296-001	BKT, MTG, TUCKER, LOAD, OPP, LH
8	1	228293-001	BKT, MTG, TUCKER, LOAD, SIDE, LH
7	1	197440	BAR, SPACER, GUIDE, LOAD SIDE
6	2	197436	BAR, SPACER
5	4	132969	CLAMP, SLIDE GUIDE
4	2	132968	CLAMP, MNT BAR GUIDE
3	1	132958-002	PLOUGH, MAJOR, FLAP
2	1	132958-001	PLOUGH, MAJOR, FLAP
1	9	122222-001	ROD, MTG, GUIDE
ITM	QTY	PART NUM	DESCRIPTION

BILL OF MATERIALS

ARPAC

9511 WEST RIVER ST.
SCHILLER PARK, IL 60176

UNLESS OTHERWISE SPECIFIED:
ALL DIMENSIONAL TOLERANCES:

FRACTIONS
TWO (2) DECIMALS ± 1/64
THREE (3) DECIMALS ± 0.010
ANGLES ± 0.5°

DRAWN: 11/05/15 BY: JW SCALE: 1:16 SIZE: B

RELEASED: 11/05/15 FILENAME: 316364 APPROVED BY: JW

DESCRIPTION: ASSY, GUIDE, FORM, TRAY



DRAWING NUMBER:

316364

P/N	316364-001	316364-002
ITEM 8	228293-001	228293-002
ITEM 9	228296-001	228296-002
ITEM 10	233497-001	233497-002
ITEM 12	243950-001	243950-002
ITEM 13	292129-001	292129-002
ITEM 14	292547-001	292547-002

Arpac BOM

Parent Number: 15269 Parent Revision: B

Description: ASSY, FINAL, MACH, EL-2100, LH

Model: EL-2121

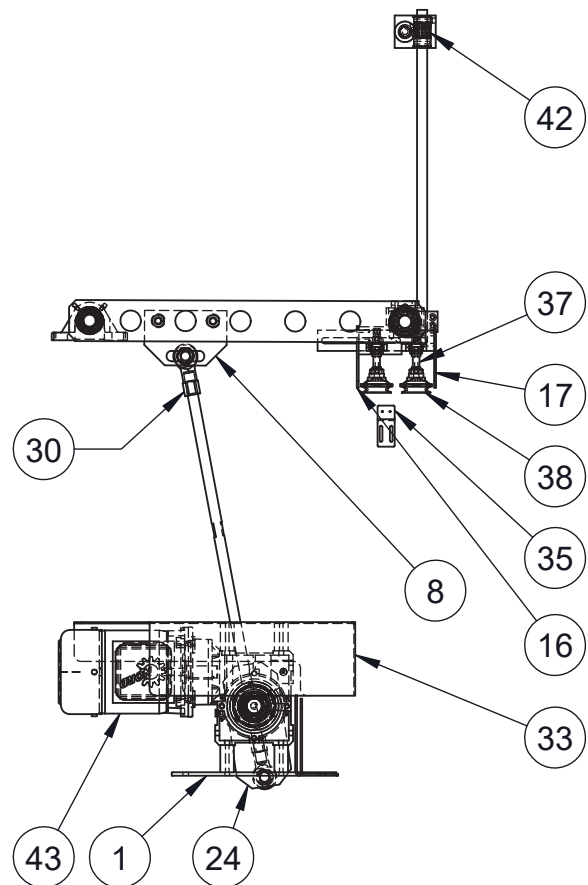
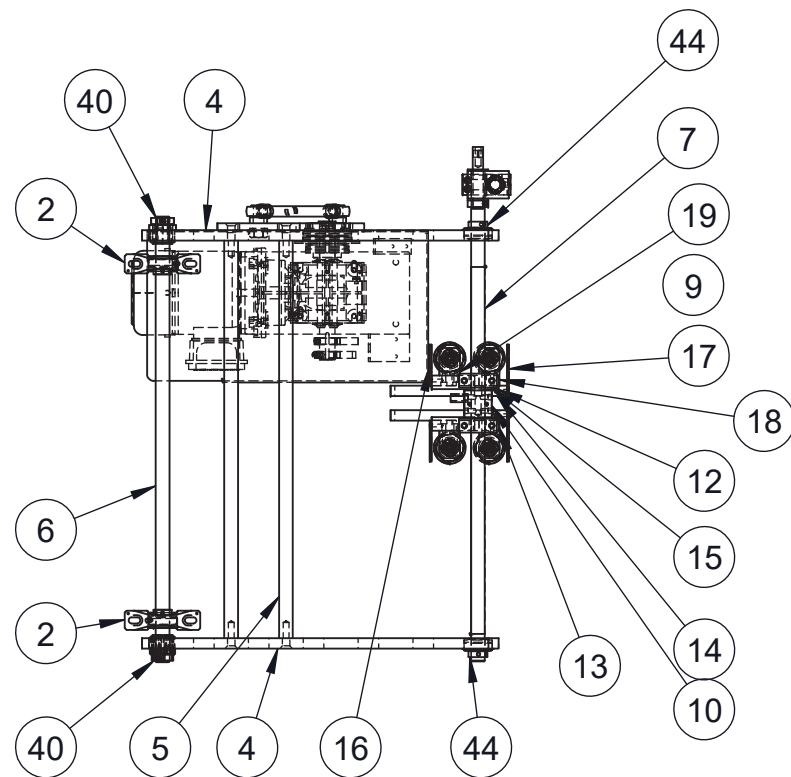
Assembly Part Number: 316364-001

Assembly Drawing Number: 316364

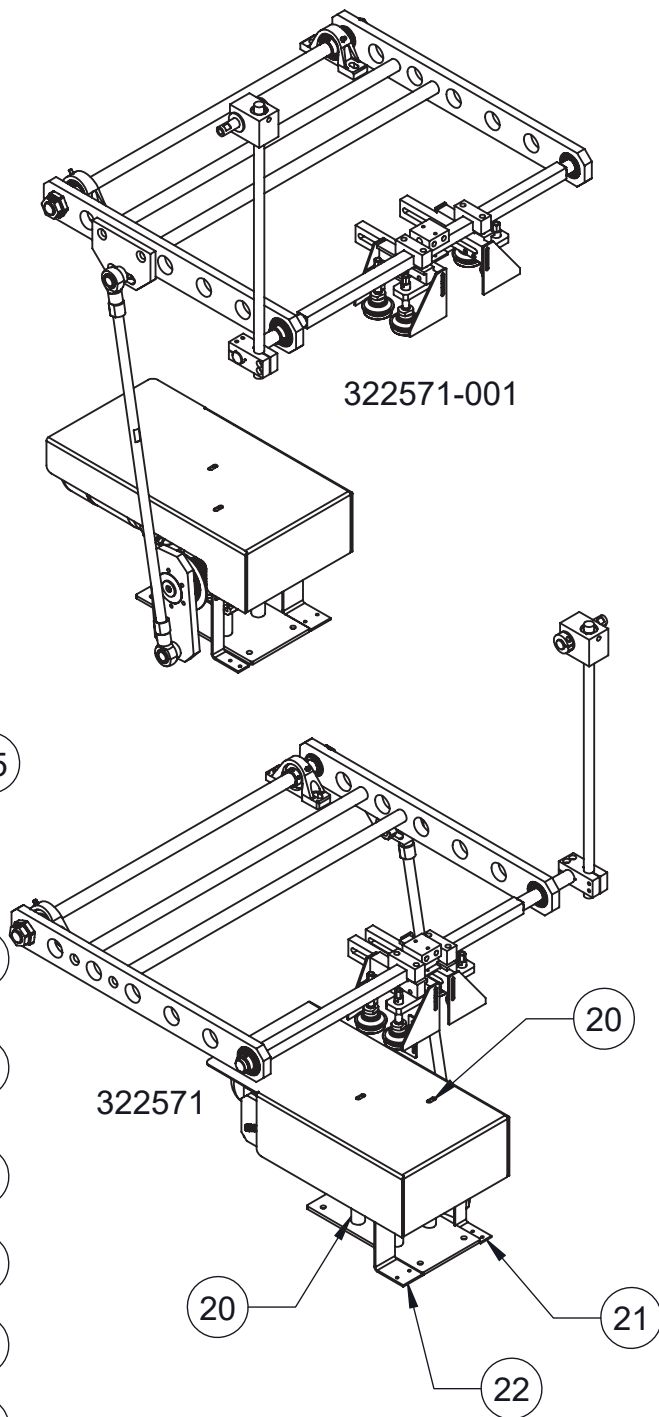
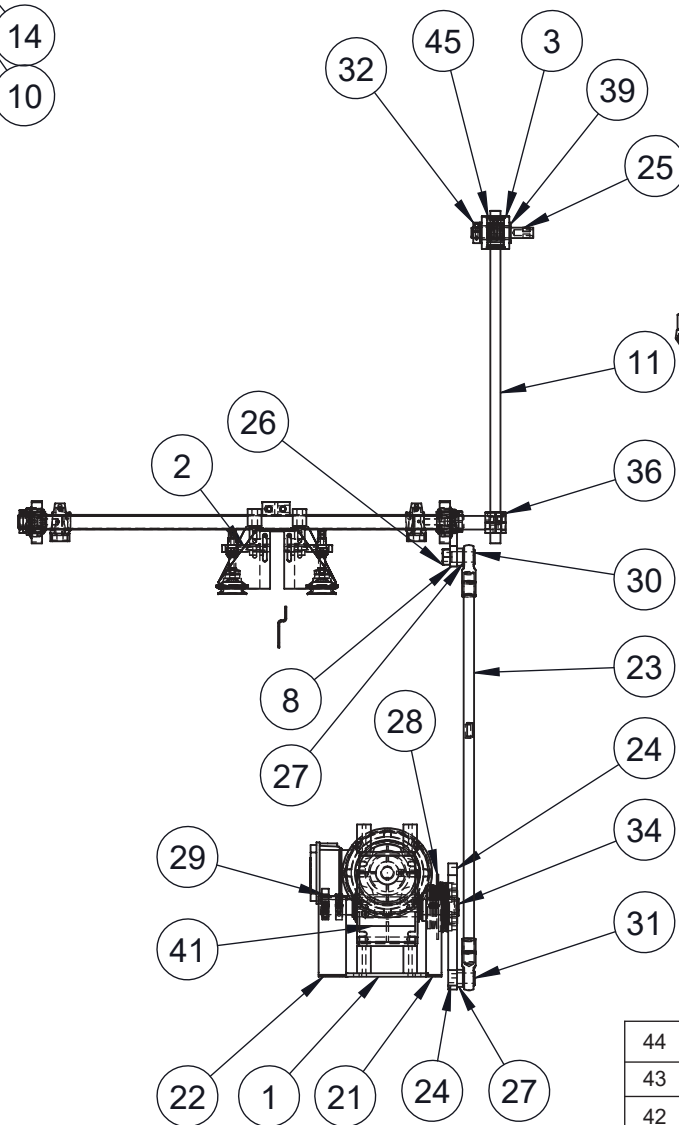
Description: ASSY, GUIDE, FORM, TRAY, LH

Quantity: 1.00

Item	Qty	Arpac Part	Description
1	9.00	122222-001	ROD, MTG, GUIDE, 5.875 LG
2	1.00	132958-001	PLOUGH, MAJOR, FLAP, RH
3	1.00	132958-002	PLOUGH, MAJOR, FLAP, LH
4	2.00	132968	CLAMP, MNT, GUIDE
5	4.00	132969	CLAMP, SLIDE GUIDE
6	1.00	197436	BAR, SPACER
7	1.00	197440	BAR, SPACER, GUIDE, LOAD SIDE
8	1.00	228293-001	BKT, MTG, TUCKER, LOAD, SIDE, LH
9	1.00	228296-001	BKT, MTG, TUCKER, LOAD, OPP, LH, MACH,
10	1.00	233497-001	GUIDE, FLAP HOLD DOWN, LOAD SIDE LH MACH
11	3.00	235764	POST, MTG, GUIDE
12	1.00	243950-001	GUIDE, FLAP HOLD DOWN, OPP. LOAD SIDE LH MACH
13	1.00	292129-001	GUIDE, SIDE, TRAY, LH
14	1.00	292547-001	GUIDE, PRODUCT, LOAD SIDE, LH
15	4.00	806464	HDL, ADJ, ZINC, 2-1/2 LG 3/8-16 X 1.18 STUD
16	2.00	235763	POST, MTG, GUIDE, TALL
17	2.00	322536	BAR, MTG, TOP GUIDE
18	2.00	322537	TOP GUIDE
19	4.00	243947	BKT, MTG, GUIDE, EXIT
20	2.00	243944	GUIDE, EXIT



322571 AS SHOWN
322571-001 OPPOSITE



ITEM 45 IS NOT SHOWN

44	2	802921	BRG, CART, 1 X 2.0472 X 1-3/8 LG, SEALED, SET SCREW ID, PRESS FIT OD
43	1	848037	MOTOR, 1 HP, 3 PH, 60HZ, 230/460VAC
42	1	226217	ASSY, BUSH, BRG, .75 SHAFT, SINGLE SUPER BALL BUSHING
41	1	846475	GEARBOX, WORM, 50:1, 56C FACE, DUAL, TYPE, DOUBLE SHAFT
ITM	QTY	PART NUM	DESCRIPTION

BILL OF MATERIALS

40	2	802938	BUSH, TRANTORQUE, 1 X 1-3/4 X 1-7/8, 7/8 LG EXPANDING OD
39	2	800382	BUSH, OILITE, FLG, 0.751 X 1.002 X 3/4, 1-1/2 OD X 1/8 THK FLG
38	4	808519	CUP, VACUUM, 52.5MM DIA, 1/8 FITTING
37	4	808421	COMPENSATOR, LEVEL, 1/8"
36	1	138425	CLAMP, PIVOT, UPPER STD, TS25
35	1	242599	BKT, PE, MINI
34	1	233878	STOP, TORQUE IMITER
33	1	303343-001	GUARD, MOTOR & GEARBOX, LH
32	1	807096	COLLAR, SHAFT, CLAMP, 1-PIECE, 3/4
31	1	808412-001	END, ROD, 0.75 X 2 7/8, .7500-16 THREAD FEMALE, LH TREAD
30	1	808412	END, ROD, 0.75 X 2 7/8, .7500-16 THREAD FEMALE
29	2	220361	FLAG, PROX
28	1	816968-001	LIMITER, TORQUE, SINGLE RESET OPTI SIZE2 1.125 BORE, STANDARD HUB
27	2	138331	SPACER, ECCENTRIC
26	1	132947	3/4-10 NUT HEX, SS
25	1	138427-001	SHAFT, PIVOT
24	1	216184	WHEEL, ECCENTRIC
23	1	193035-002	ROD, LINK
22	1	220806	BKT, PROX
21	1	220805	BKT, PROX
20	6	118369-001	SPACER, 1" DIA, 5/16-18 TAP, AL, 2" LONG
19	2	126144	BRACKET, CUP, SUCTION, SHORT
18	2	126143	BRACKER, CUP, SUCTION
17	2	188885	SUPPORT, ADJ, GUARD
16	2	188884	SUPPORT, ADJ, GUARD
15	2	139111	ADJUSTING, CLAMP
14	2	188747	ADJUSTING, SUPPORT
13	1	188748-001	PLATE, CLAMP, FIXED
12	1	188748	PLATE, CLAMP, FIXED
11	1	141736-005	SHAFT, THOMSON, .750
10	1	197415	MANIFOLD, 4 PORT X 1
9	1	212413	PLT, MTG, MANIFOLD
8	1	220803	PLT, MTG, LINK
7	1	226221	SHAFT, 1" SQ
6	1	132922	STIFFENER, CROSS, LOWER
5	2	132921	STIFFENER, CROSS
4	2	126137	FRAME, SIDE
3	1	226220	BLK, BSG, 0.750 SHFT, SINGLE
2	2	827114	BRG, BLK, PILLOW, 1 BORE, INTERMEDIATE DUTY
1	1	303341	PLT, MTG, MOTOR
ITM	QTY	PART NUM	DESCRIPTION

BILL OF MATERIALS

ARPAC		9511 WEST RIVER ST. SCHILLER PARK, IL 60176	
UNLESS OTHERWISE SPECIFIED: ALL DIMENSIONAL TOLERANCES:		FRACTIONS TWO (2) DECIMALS THREE (3) DECIMALS ANGLES	± 1/64 ± 0.010 ± 0.005 ± 0.5°
DRAWN:	2/6/12	BY:	HG
RELEASED:		FILENAME:	322571
DESCRIPTION:	ASSY, PICK AND PLACE, LH EL-2000		
		DRAWING NUMBER: 322571	

Arpac BOM

Parent Number: 15269 Parent Revision: B
 Description: ASSY, FINAL, MACH, EL-2100, LH
 Model: EL-2121

Assembly Part Number: 322571

Assembly Drawing Number: 322571

Description: ASSY, PICK AND PLACE, EL-2100, LH

Quantity: 1.00

Item	Qty	Arpac Part	Description
1	1.00	303341	PLT, MTG, GEARBOX
2	2.00	827114	BRG, BLK, PILLOW, 1 BORE, INTERMEDIATE DUTY
3	1.00	226220	BLK, BUSH, SHAFT, 0.750, 2-3/8" LG, SINGLE BALL BUSH
4	2.00	126137	FRAME,SIDE
5	2.00	132921	STIFFNER, CROSS
6	1.00	132922	STIFFNER, CROSS, LOWWER
7	1.00	226221	SHAFT, 1" SQ
8	1.00	220803	PLT, LINK, MTG
9	1.00	212413	PLT, MTG, MANIFOLD
10	1.00	197415	MANIFOLD 4 PORT X 1
11	1.00	141736-005	CRS SHAFT THOMSON 3/4, 24.250 LG
12	1.00	188748	PLT, CLAMP, FIXED
13	1.00	188748-001	PLT, CLAMP, FIXED
14	2.00	188747	BLOCK, ADJUSTING SUPPORT STD, TS25
15	2.00	139111	CLAMP, ADJUSTING
16	2.00	188884	GUARD, VACUUM CUP TS-25 STD
17	2.00	188885	GUARD, VACUUM CUP TS-25 STD
18	2.00	126143	BRACKET, CUP, SUCTION
19	2.00	126144	BRACKET,CUP, SUCTION, SHORT
20	6.00	118369-001	SPACER, 1" DIA, 5/16-18 TAP 2 LG, AL
21	1.00	220805	BKT, PROX
22	1.00	220806	BKT, PROX
23	1.00	193035-002	ROD, LINK, 27.50 LG
24	1.00	216184	WHEEL, ECCENTRIC
25	1.00	138427-001	SHAFT, PIVOT A=4.5
26	1.00	132947	HEX NUT
27	2.00	138331	SPACER, ECCENTRIC
28	1.00	816968-001	LIMITER, TORQUE, SINGLE RESET OPTI SIZE2 1.125 BORE, STANDARD HUB
29	2.00	220361	WLDMT, FLAG, PROX
30	1.00	808412	END, ROD, 0.75 X 2 7/8, .7500-16 THREAD FEMALE
31	1.00	808412-001	END, ROD, 0.75 X 2 7/8, .7500-16 THREAD FEMALE, LH TREAD
32	1.00	807096	COLLAR, SHAFT, CLAMP, 1-PIECE, 3/4, EXTREME CL8867
33	1.00	303343-001	WLDMNT, GUARD, MOTOR & GEARBOX, LH
34	1.00	233878	STOP, TORQUE LIMITER
35	1.00	242599	BKT, PE, MINI
36	1.00	138425	CLAMP, PIVOT, UPPER STD, TS25
37	4.00	808421	COMPENSATOR, LEVEL, 1/8"
38	4.00	808519	CUP, VACUUM, 52.5MM DIA, 1/8 FITTING
39	2.00	800382	BUSH, OILITE, FLG, 0.751 X 1.002 X 3/4, 1-1/2 OD X 1/8 THK FLG
40	2.00	802938	BUSH, TRANTORQUE, 1 X 1-3/4 X 1-7/8, 7/8 LG EXPANDING OD
41	1.00	846475	GEARBOX, WORM, 50:1, 56C FACE, DUAL, TYPE, DOUBLE SHAFT
42	1.00	226217-000A	ASSY, BUSH, BRG, .75 SHAFT, SINGLE SUPER BALL BUSHING
43	1.00	848037	MOTOR, 1 HP, 3 PH, 60HZ, 230/460VAC
44	2.00	802921	BRG, CART, 1 X 2.0472 X 1-3/8 LG, SEALED, SET SCREW ID, PRESS FIT OD

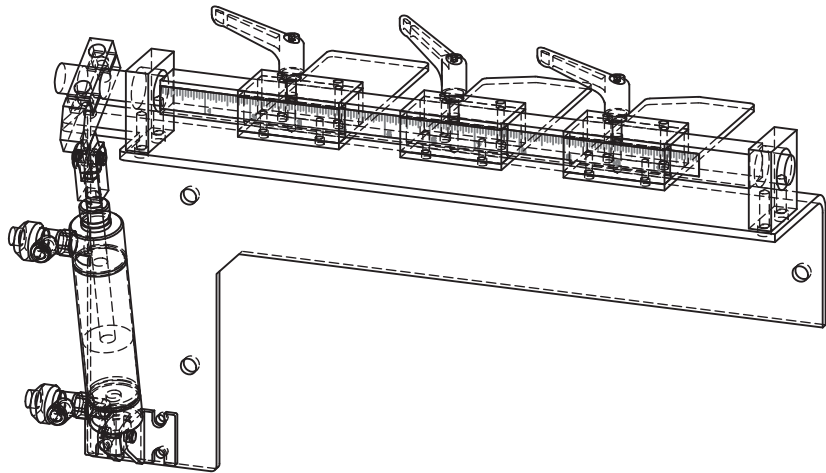
Arpac BOM

Parent Number: 15269 Parent Revision: B
Description: ASSY, FINAL, MACH, EL-2100, LH
Model: EL-2121

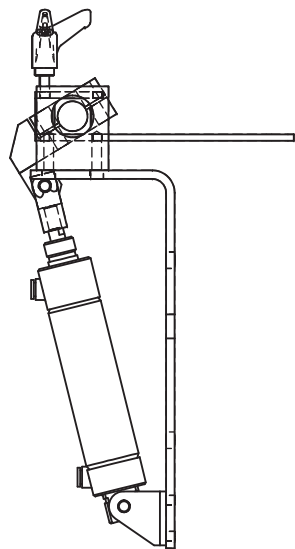
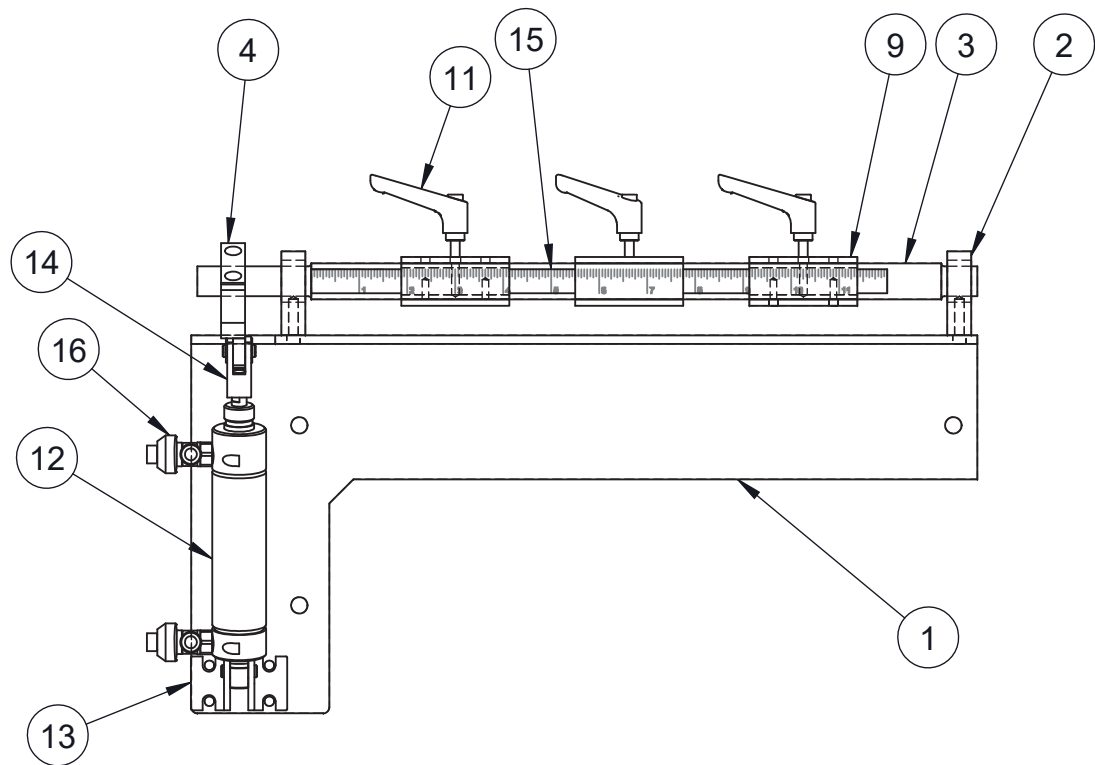
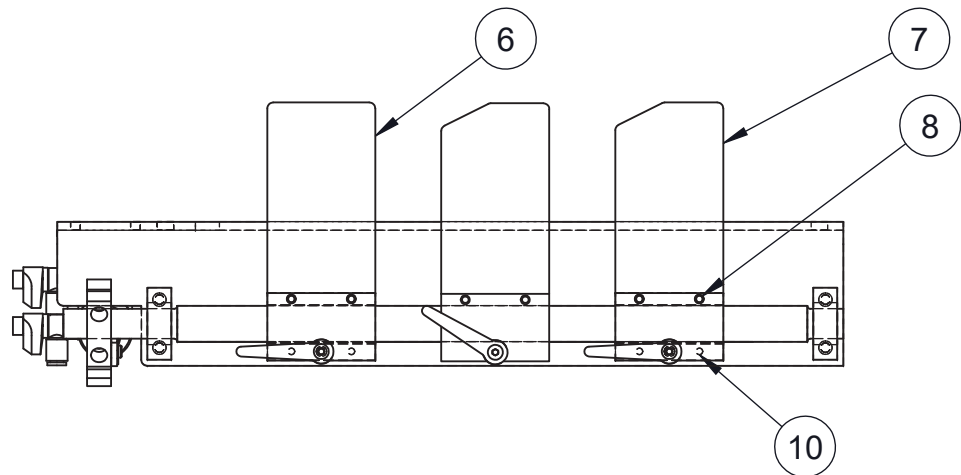
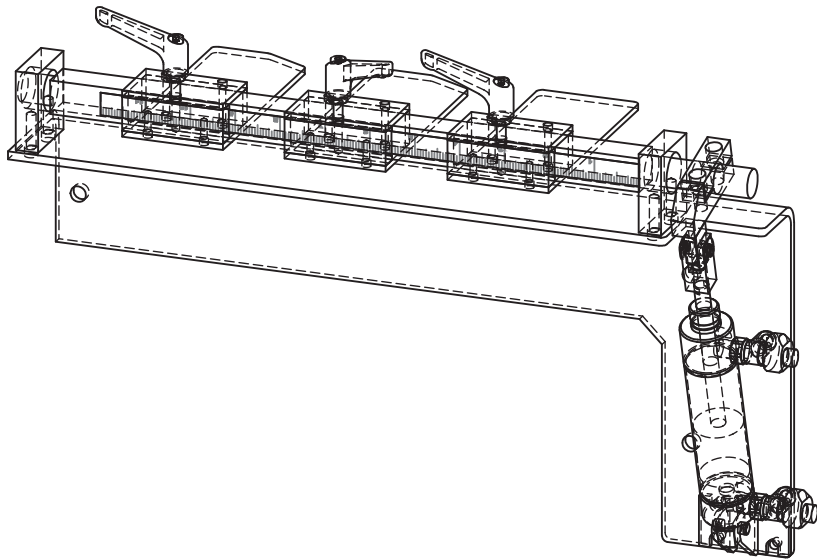
Assembly Part Number: 322571
Assembly Drawing Number: 322571
Description: ASSY, PICK AND PLACE, EL-2100, LH
Quantity: 1.00

Item	Qty	Arpac Part	Description
45	1.00	845899	PUMP, VACUUM, W/SILENCER, MULTI-PORT, 20" Hg MAX VAC

306905-001



306905-002
OPPOSITE



16	2	825362-001	VALVE, CONTROL, FLOW, 1/8 NPT X 1/4 TUBE 90DEG, NUMERIC INDICATOR, MTR OUT
15	1	809498	SCALE, ADHESIVE, 1/2W X 1FT LEFT TO RIGHT
14	1	816269	CLVS, ROD 5/16-24
13	1	816268	BKT, PVT, SET-(1LEFT AND 1RIGHT BKT)
12	1	816421	CYL, AIR, 1 1/16 BORE, 2 STRK, RND PVT MTG, DBL ACT, W/CUSHION
11	3	809458	HDL, ADJ, ZINC, 1 3/4 LG 10-32 X .47
10	3	133225	PLT, SIDE, FLAP HOLD
9	3	191233	PLT, CLAMP
8	3	133223	PLT, SIDE, FLAP HOLD
7	2	191235	PLT, FLAP HOLDING
6	1	300770	PLT, FLAP HOLDING
4	1	122124	CLAMP, SHAFT
3	1	132447	SHAFT, FLAP HOLDING
2	2	230238	BLK, BRG
1	1	230237-001	BKT, FLAP, HOLDDOWN
ITM	QTY	PART NUM	DESCRIPTION

BILL OF MATERIALS

ARPAC		9511 WEST RIVER ST. SCHILLER PARK, IL 60176	
UNLESS OTHERWISE SPECIFIED ALL DIMENSIONAL TOLERANCES:		FRACTIONS TWO (2) DECIMALS THREE (3) DECIMALS ANGLES	± 1/64 ± 0.010 ± 0.005 ± 0.5°
DRAWN:	8/25/15	BY:	MFitc
RELEASED:		FILENAME:	306905
DESCRIPTION:		SCALE:	1:4
		APPROVED BY:	SRA
		ASSY, HOLD DOWN, FLAP	
		DRAWING NUMBER:	
		306905	

Arpac BOM

Parent Number: 15269 Parent Revision: B

Description: ASSY, FINAL, MACH, EL-2100, LH

Model: EL-2121

Assembly Part Number: 306905-001

Assembly Drawing Number: 306905

Description: ASSY, HOLD DOWN, FLAP, RH

Quantity: 1.00

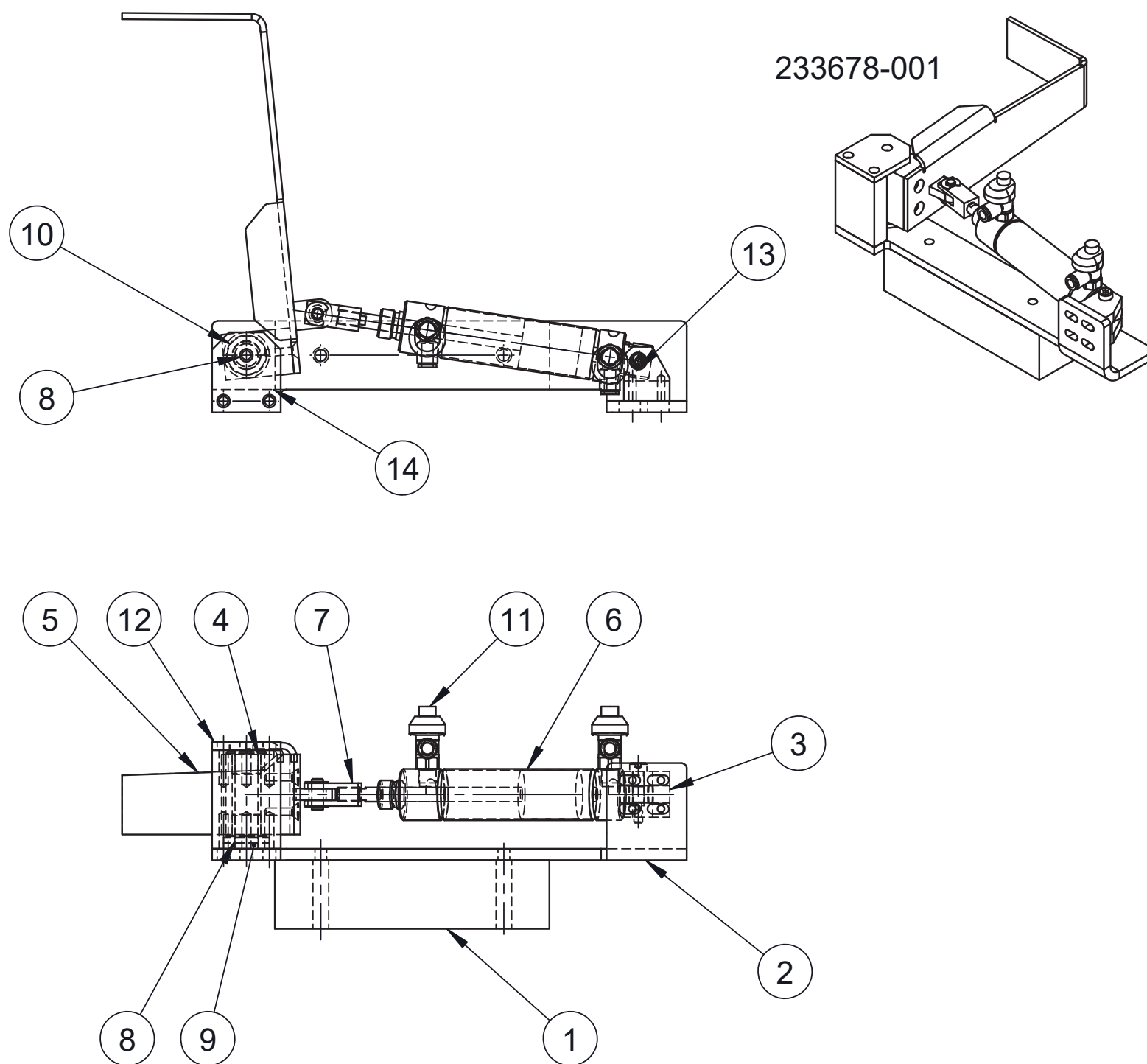
Item	Qty	Arpac Part	Description
1	1.00	230237-001	BKT, FLAP HOLDDOWN, RH
2	2.00	230238	BLK, BRG
3	1.00	132447	SHAFT, FLAP HOLDING
4	1.00	122124	CLAMP, SHAFT
6	1.00	300770	PLT, FLAP HOLDING, UP STREAM
7	2.00	191235-000A	PLT, FLAP HOLDING, DOWN STREAM
8	3.00	133223	PLT, SIDE FLAP HOLD
9	3.00	191233	PLT, CLAMP
10	3.00	133225	PLT, SIDE, FLAP HOLD
11	3.00	809458	HDL, ADJ, ZINC, 1 3/4 LG 10-32 X .47
12	1.00	816421	OBSOLETE USE 855057, CYL, AIR, 1 1/16 BORE, 2 STRK, RND PVT MTG, DBL ACT,
13	1.00	816268	OBSOLETE USE 839339, BKT, PVT, SET- (1LEFT AND 1RIGHT BKT)
14	1.00	816269	OBSOLETE USE 839340, CLVS, ROD 5/16-24
15	1.00	809498	RULE, ADHESIVE, 1/2W X 1FT LEFT TO RIGHT
16	2.00	825362-001	VALVE, CONTROL, FLOW, 1/8 NPT X 1/4 TUBE 90DEG, NUMERIC INDICATOR, MTR OU

Arpac BOM

Parent Number: 15269 Parent Revision: B
Description: ASSY, FINAL, MACH, EL-2100, LH
Model: EL-2121

Assembly Part Number: 306905-002
Assembly Drawing Number: 306905
Description: ASSY, HOLD DOWN, FLAP, LH
Quantity: 1.00

Item	Qty	Arpac Part	Description
1	1.00	230237-002	BKT, FLAP HOLDDOWN, LH
2	2.00	230238	BLK, BRG
3	1.00	132447	SHAFT, FLAP HOLDING
4	1.00	122124	CLAMP, SHAFT
6	1.00	300770	PLT, FLAP HOLDING, UP STREAM
7	2.00	191235-000A	PLT, FLAP HOLDING, DOWN STREAM
8	3.00	133223	PLT, SIDE FLAP HOLD
9	3.00	191233	PLT, CLAMP
10	3.00	133225	PLT, SIDE, FLAP HOLD
11	3.00	809458	HDL, ADJ, ZINC, 1 3/4 LG 10-32 X .47
12	1.00	816421	OBSOLETE USE 855057, CYL, AIR, 1 1/16 BORE, 2 STRK, RND PVT MTG, DBL ACT,
13	1.00	816268	OBSOLETE USE 839339, BKT, PVT, SET- (1LEFT AND 1RIGHT BKT)
14	1.00	816269	OBSOLETE USE 839340, CLVS, ROD 5/16-24
15	1.00	809498	RULE, ADHESIVE, 1/2W X 1FT LEFT TO RIGHT
16	2.00	825362-001	VALVE, CONTROL, FLOW, 1/8 NPT X 1/4 TUBE 90DEG, NUMERIC INDICATOR, MTR OU



233678-001

233678-002

14	1	232850	SPACER, PIVOT
13	1	800321-019	FSNR, BOLT, SHLDR, 1/4 DIA X 3/4 LG, SS
12	1	232851	PLT, TOP, PIVOT
11	2	825362-001	VALVE, CONTROL, FLOW, 1/8 NPT X 1/4 TUBE 90DEG, NUMERIC INDICATOR, MTR OUT
10	2	800394	BUSH, OILITE, FLG, 0.502 X 0.627 X 1/2, 7/8 OD X 1/16 THK FLG
9	2	800442	WSHR, OILITE, 0.510 X 1.000 X 1/8 THK
8	1	232852	SHAFT, PIVOT
7	1	816269	CLVS, ROD 5/16-24
6	1	816418	CYL, AIR, 1 1/16 BORE, 2 STRK, RND PVT BUSH, DBL ACT, W/CUSHION
5	1	223133-001	ARM, TUCKER
4	1	127489	BLK, ARM, MTG
3	1	230839-001	BKT, PIVOT, CYL RH
2	1	232853-001	BKT, TUCKER, RH
1	1	137182	SPACER, TUCKER
ITM	QTY	PART NUM	DESCRIPTION

BILL OF MATERIALS

ARPAC

9511 WEST RIVER ST.
SCHILLER PARK, IL 60176

UNLESS OTHERWISE SPECIFIED
ALL DIMENSIONAL TOLERANCES:
FRACTIONS ± 1/64
TWO (2) DECIMALS ± 0.010
THREE (3) DECIMALS ± 0.005
ANGLES ± 0.5°

DRAWN: 07/14/2005 BY: KKL SCALE: 0.25:1 SIZE: A

RELEASED: 07/14/2005 FILENAME: 233678 APPROVED BY: KKL

DESCRIPTION: ASSY, TUCKER, MINOR FLAP

KS

DRAWING NUMBER:
233678

PART NUMBER	MODE
233678-001	RH, AS SHOWN
233678-002	LH, OPPOSITE

FINISH- NONE

Arpac BOM

Parent Number: 15269 Parent Revision: B
Description: ASSY, FINAL, MACH, EL-2100, LH
Model: EL-2121

Assembly Part Number: 233678-001B
Assembly Drawing Number: 233678
Description: ASSY, TUCKER, MINOR FLAP, RH NUMATIC
Quantity: 1.00

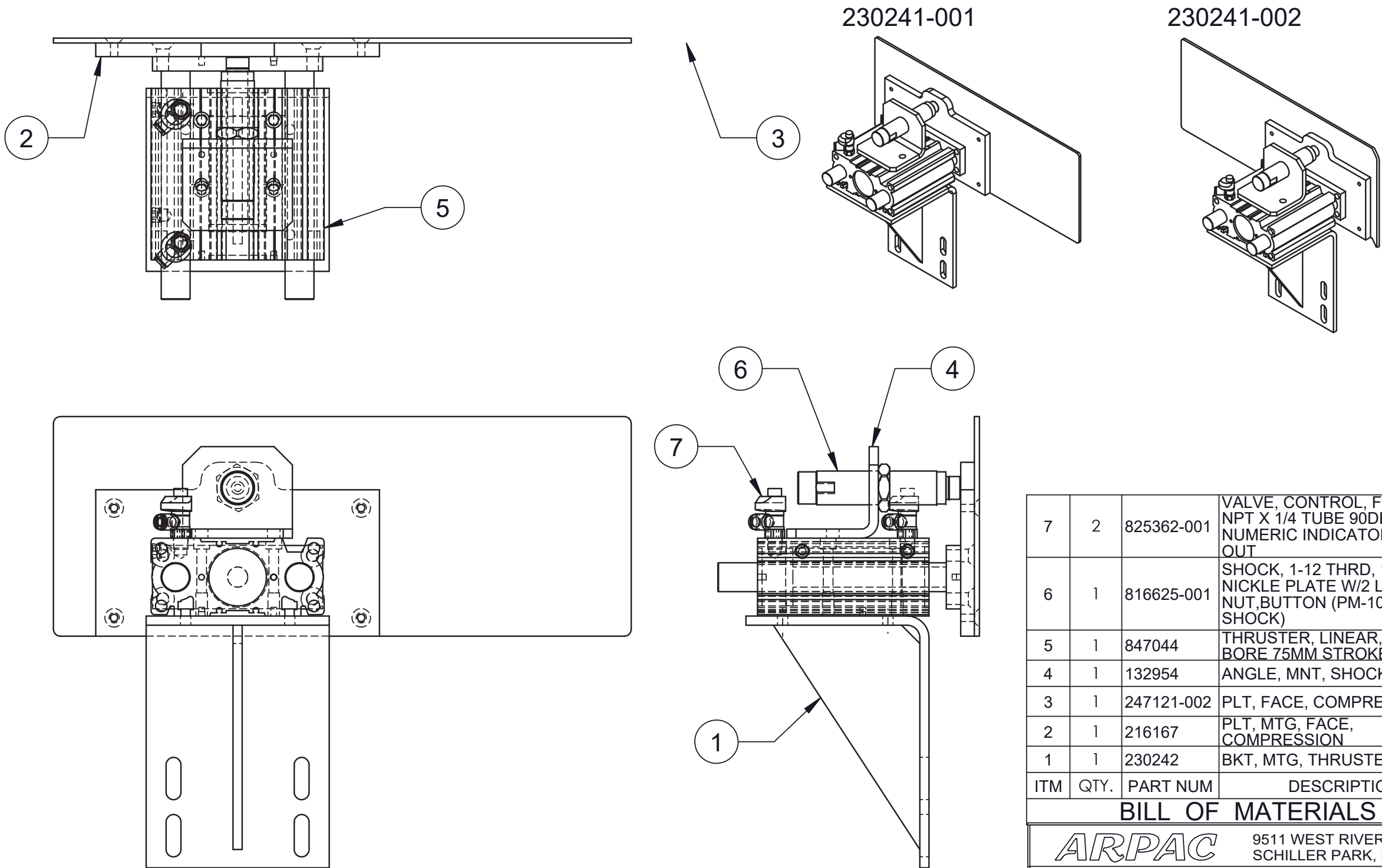
Item	Qty	Arpac Part	Description
1	1.00	137182	SPACER, TUCKER
2	1.00	232853-001	BKT, TUCKER, RH
3	1.00	230839-001	BKT, PIVOT, CYL LH
4	1.00	127489-000A	BLK, ARM, MTG TS25, STD
5	1.00	223133-001	WLDMT, ARM, TUCKER, RH EL-2000
6	1.00	816418	OBS USE 854762, CYL, AIR, 1 1/16 BORE, 2 STRK, RND PVT BUSH, DBL ACT, W/C
7	1.00	816269	OBSOLETE USE 839340, CLVS, ROD 5/16-24
8	1.00	232852	SHAFT, PIVOT
9	2.00	800442	WSHR, OILITE, 0.510 X 1.000 X 1/8 THK
10	2.00	800394	BUSH, OILITE, FLG, 0.502 X 0.627 X 1/2, 7/8 OD X 1/16 THK FLG
11	2.00	825362-001	VALVE, CONTROL, FLOW, 1/8 NPT X 1/4 TUBE 90DEG, NUMERIC INDICATOR, MTR OU
12	1.00	232851	PLT, TOP, PIVOT
13	1.00	800321-019	FSNR, BOLT, SHLDR, 1/4 DIA X 3/4 LG, SS
14	1.00	232850	SPACER, PIVOT

Arpac BOM

Parent Number: 15269 Parent Revision: B
Description: ASSY, FINAL, MACH, EL-2100, LH
Model: EL-2121

Assembly Part Number: 233678-002B
Assembly Drawing Number: 233678
Description: ASSY, TUCKER, MINOR FLAP, LH NUMATIC
Quantity: 1.00

Item	Qty	Arpac Part	Description
1	1.00	137182	SPACER, TUCKER
2	1.00	232853-002	BKT, TUCKER, LH
3	1.00	230839-002	BKT, PIVOT, CYL RH
4	1.00	127489-000A	BLK, ARM, MTG TS25, STD
5	1.00	223133-002	WLDMT, ARM, TUCKER, LH EL-2000
6	1.00	816418	OBS USE 854762, CYL, AIR, 1 1/16 BORE, 2 STRK, RND PVT BUSH, DBL ACT, W/C
7	1.00	816269	OBSOLETE USE 839340, CLVS, ROD 5/16-24
8	1.00	232852	SHAFT, PIVOT
9	2.00	800442	WSHR, OILITE, 0.510 X 1.000 X 1/8 THK
10	2.00	800394	BUSH, OILITE, FLG, 0.502 X 0.627 X 1/2, 7/8 OD X 1/16 THK FLG
11	2.00	825362-001	VALVE, CONTROL, FLOW, 1/8 NPT X 1/4 TUBE 90DEG, NUMERIC INDICATOR, MTR OU
12	1.00	232851	PLT, TOP, PIVOT
13	1.00	800321-019	F5NR, BOLT, SHLDR, 1/4 DIA X 3/4 LG, SS
14	1.00	232850	SPACER, PIVOT



7	2	825362-001	VALVE, CONTROL, FLOW, 1/8 NPT X 1/4 TUBE 90DEG, NUMERIC INDICATOR, MTR OUT
6	1	816625-001	SHOCK, 1-12 THRD, 1 STROKE, NICKLE PLATE W/2 LOCK NUT,BUTTON (PM-100-IF-1B SHOCK)
5	1	847044	THRUSTER, LINEAR, 40MM BORE 75MM STROKE
4	1	132954	ANGLE, MNT, SHOCK
3	1	247121-002	PLT, FACE, COMPRESSION,LH
2	1	216167	PLT, MTG, FACE, COMPRESSION
1	1	230242	BKT, MTG, THRUSTER
ITM	QTY.	PART NUM	DESCRIPTION

BILL OF MATERIALS

ARPAC		9511 WEST RIVER ST. SCHILLER PARK, IL 60176	
UNLESS OTHERWISE SPECIFIED ALL DIMENSIONAL TOLERANCES:		FRACTIONS TWO (2) DECIMALS THREE (3) DECIMALS ANGLES	± 1/64 ± 0.010 ± 0.005 ± 0.5°
DRAWN:	11/24/2004	BY:	HHG
RELEASED:		FILENAME:	230241
DESCRIPTION:	ASSY, COMPRESSION, SIDE		
		DRAWING NUMBER: 230241	

230241-002	LH, OPPOSITE
230241-001	RH, AS SHOWN
PART NUMBER	ORIENTATION

Arpac BOM

Parent Number: 15269 Parent Revision: B
Description: ASSY, FINAL, MACH, EL-2100, LH
Model: EL-2121

Assembly Part Number: 230241-001B
Assembly Drawing Number: 230241
Description: ASSY, COMPRESSION, SIDE, RH
Quantity: 1.00

Item	Qty	Arpac Part	Description
1	1.00	230242	BKT, MTG, THRUSTER, COMPRESION, SIDE
2	1.00	216167	PLT, MTG, FACE, COMPRESSION
3	1.00	247121-001	PLT, FACE, COMPRESSION, RH
4	1.00	132954	ANGLE, MNT SHOCK
5	1.00	847044	THRUSTER, LINEAR, 40MM BORE 75MM STROKE
6	1.00	816625-001	SHOCK, 1-12 THRD, 1 STROKE, NICKLE PLATE W/2 LOCK NUT,BUTTON (PM-100-IF-1
7	2.00	825362-001	VALVE, CONTROL, FLOW, 1/8 NPT X 1/4 TUBE 90DEG, NUMERIC INDICATOR, MTR OU

Arpac BOM

Parent Number: 15269 Parent Revision: B
Description: ASSY, FINAL, MACH, EL-2100, LH
Model: EL-2121

Assembly Part Number: 230241-002B

Assembly Drawing Number: 230241
Description: ASSY, COMPRESSION, SIDE, LH
Quantity: 1.00

Item	Qty	Arpac Part	Description
1	1.00	230242	BKT, MTG, THRUSTER, COMPRESION, SIDE
2	1.00	216167	PLT, MTG, FACE, COMPRESSION
3	1.00	247121-002	PLT, FACE, COMPRESSION, LH
4	1.00	132954	ANGLE, MNT SHOCK
5	1.00	847044	THRUSTER, LINEAR, 40MM BORE 75MM STROKE
6	1.00	816625-001	SHOCK, 1-12 THRD, 1 STROKE, NICKLE PLATE W/2 LOCK NUT,BUTTON (PM-100-IF-1
7	2.00	825362-001	VALVE, CONTROL, FLOW, 1/8 NPT X 1/4 TUBE 90DEG, NUMERIC INDICATOR, MTR OU

Arpac BOM

Parent Number: 15269 Parent Revision: B

Description: ASSY, FINAL, MACH, EL-2100, LH

Model: EL-2121

Assembly Part Number: 311586

Assembly Drawing Number: 311586

Description: ASSY, GLUE, EL-2000, FREE STAND GLUE TANK

Quantity: 1.00

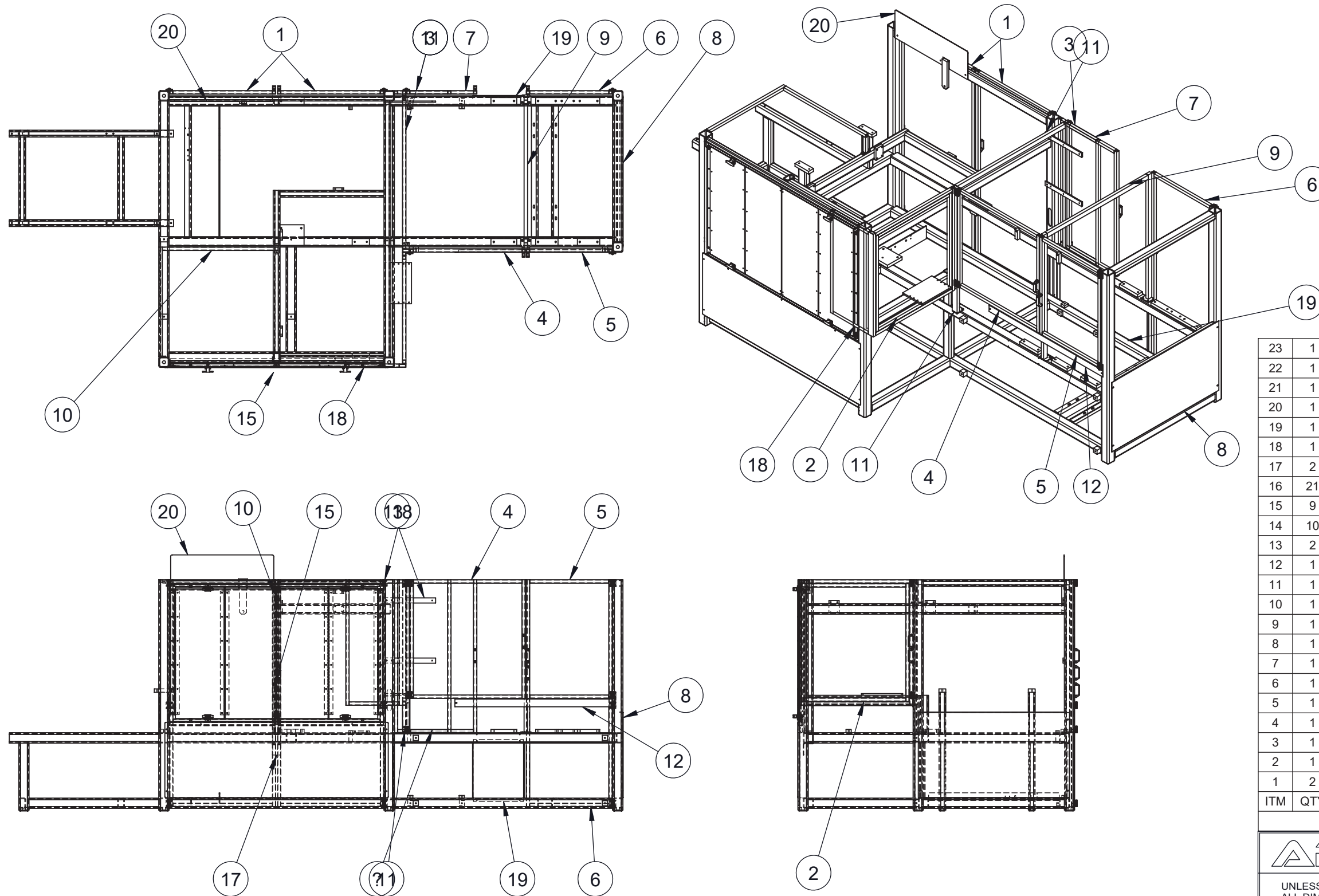
Item	Qty	Arpac Part	Description
1	2.00	133933-100	BLK, MTG, GLUE WASHDOWN
2	1.00	118254	FRAME, GLUE, EXTERNAL 3100, 3400
3	2.00	138349	POST, GLUE GUN 3/4 DIA X 8" LG
4	2.00	216179	WLDMT, BKT, MTG, GUN, GLUE
5	2.00	216180	ROD, GUN, GLUE
6	1.00	821931	MELTER, NORDSON PROBLUE-4, 2 HOSE
7	1.00	806119	HOSE, 8 FT 230 VAC AUTOMATIC
8	1.00	802512	HOSE, 6 FT 230 VAC
10	2.00	806776	GUN, GLUE H201T
11	2.00	806780	NUT, RETAINING
12	2.00	808674	NOZZLE 15DEG DUAL .016 ORIFICE
13	2.00	846253	VALVE, SOL, HIGH TEMP, 24VDC, 3-WAY NC, 1/8" NPT PORTS
14	4.00	802507	STRAP, HANGER HOSE
15	2.00	825485	FILTER, SATURN, INLINE, 45 DEGREE 100 MESH
16	2.00	846254	CABLE, SOL VALVE, B1 11MM DIN TO M12 CONNECTOR, 0.6M LG

Arpac BOM

Parent Number: 15269 Parent Revision: B
Description: ASSY, FINAL, MACH, EL-2100, LH
Model: EL-2121

Assembly Part Number: 364286
Assembly Drawing Number: 364286
Description: ASSY, PNEUMATIC, MACONNECT, EL-2100
Quantity: 1.00

Item	Qty	Arpac Part	Description
1	1.00	847720	ASSY, VALVE, 12-STATION, MACONNECT, 92 SERIES
3	1.00	850154	ASSY, FILTER, REGULATOR, SWITCH, DUMP, 3/4" NPT, CAT 1, L-R
4	2.00	846248	VALVE, SOL, 24VDC, 2POS SINGLE, M12 CONNECTOR, IP67, W/LT & SRG
5	1.00	846523	VALVE, EXHAUST, 3 WAY, SAFETY (DUMP VALVE), 24 VDC, DIN CONNECTOR
6	1.00	846061	REGULATOR, 3/8 NPT W/GUAGE
7	2.00	816683-001	SILENCER, EXHAUST, 3/8 NPT, FEM SUPER QUIET FLOW
8	1.00	186775	PLT, MTG, BANK, SOLENOID
9	2.00	233350	BKT, MANIFOLD, CROSS
10	4.00	135759	MANIFOLD 2 PORT X 2
11	1.00	135758	MANIFOLD 2 PORT X 4
12	1.00	846254	CABLE, SOL VALVE, B1 11MM DIN TO M12 CONNECTOR, 0.6M LG
13	2.00	816662	VALVE, SOL, 24VDC, 1/4 NPTF, LIGHT, MACO



23	1	311577	GUARD, BOTTOM
22	1	311585	ASSY, DOOR, BI-FOLD
21	1	827364	CLAMP, PANEL
20	1	264149	GUARD, PICK & PLACE
19	1	308209	PANEL, GUARD
18	1	243965	FRAME, GUARD, STEP BACK
17	2	256214	BKT, CATCH, DOOR
16	21	810174	HINGE, DOOR, POLYAMIDE, BLACK
15	9	806828	HANDLE, SMALL BLACK PLASTIC
14	10	837001	CATCH, DOOR, BALL STYLE
13	2	243967	PLT, ELECTRICAL BOX HOLDER
12	1	234449	GUARD
11	1	243977-001	FRAME, GUARD
10	1	316213-001	SUPPORT, GUARD, LH
9	1	243973	FRAME, GUARD
8	1	216173	GUARD, END
7	1	141604-054	FRAME, PANEL, GUARD
6	1	141604-053	FRAME, PANEL, GUARD
5	1	141604-052	FRAME, PANEL, GUARD
4	1	141604-051	FRAME, PANEL, GUARD
3	1	141604-050	FRAME, PANEL, GUARD
2	1	141604-049	FRAME, PANEL, GUARD
1	2	141604-048	FRAME, PANEL, GUARD
ITM	QTY	PART NUM	DESCRIPTION

BILL OF MATERIALS

ARPAC

9511 WEST RIVER ST.
SCHILLER PARK, IL 60176

UNLESS OTHERWISE SPECIFIED
ALL DIMENSIONAL TOLERANCES:

FRACTIONS
TWO (2) DECIMALS
THREE (3) DECIMALS
ANGLES

± 1/64
± 0.010
± 0.005
± 0.5°

DRAWN: 10/3/2014

BY: MC

SCALE: 1:32

SIZE: B

FILENAME: 311597

DESCRIPTION:

ASSY, GUARD

3

DRAWING NUMBER:

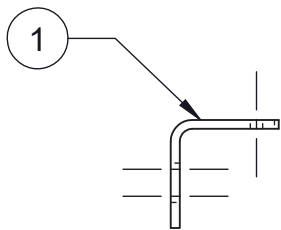
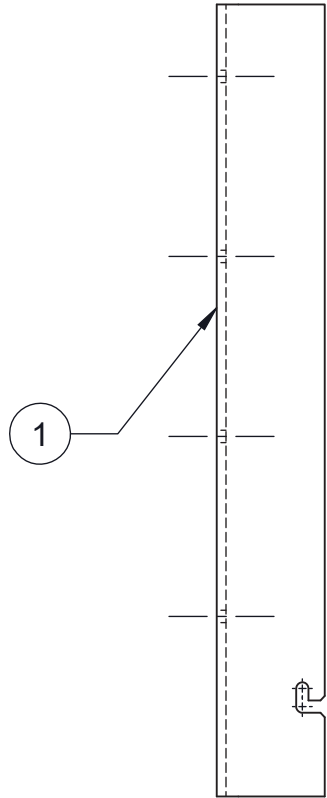
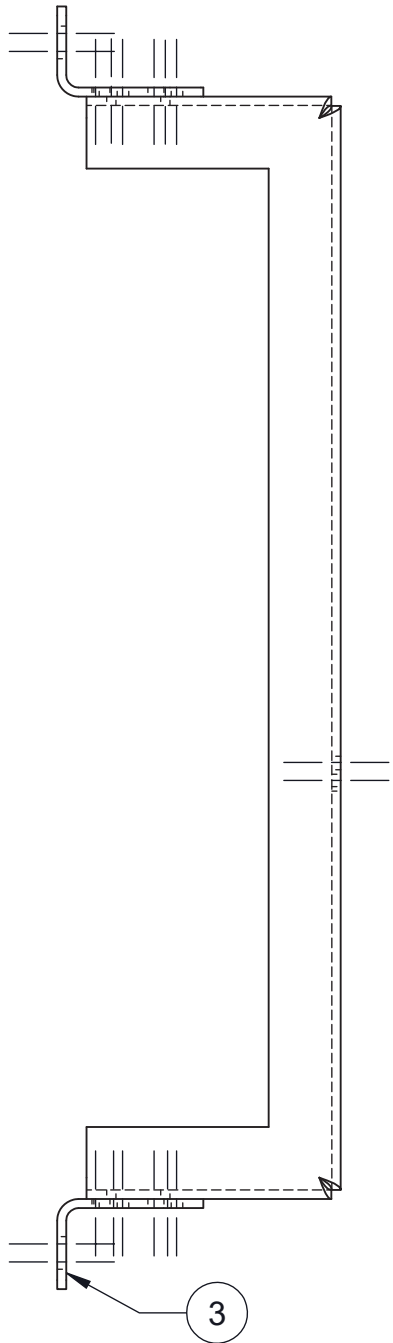
311597

Arpac BOM

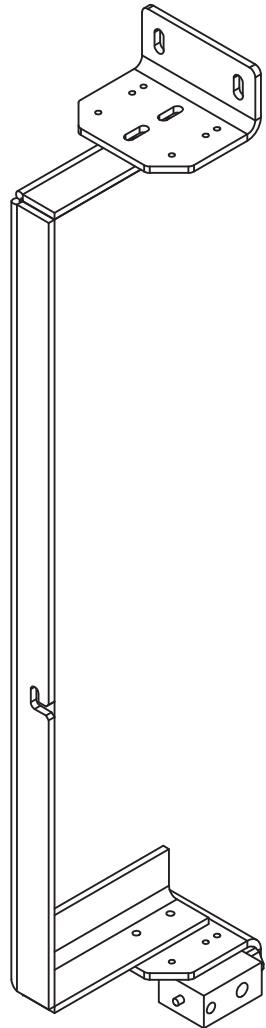
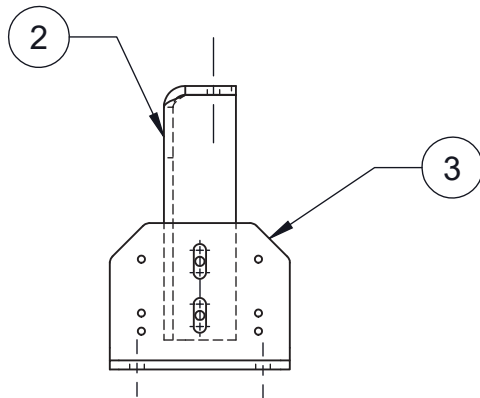
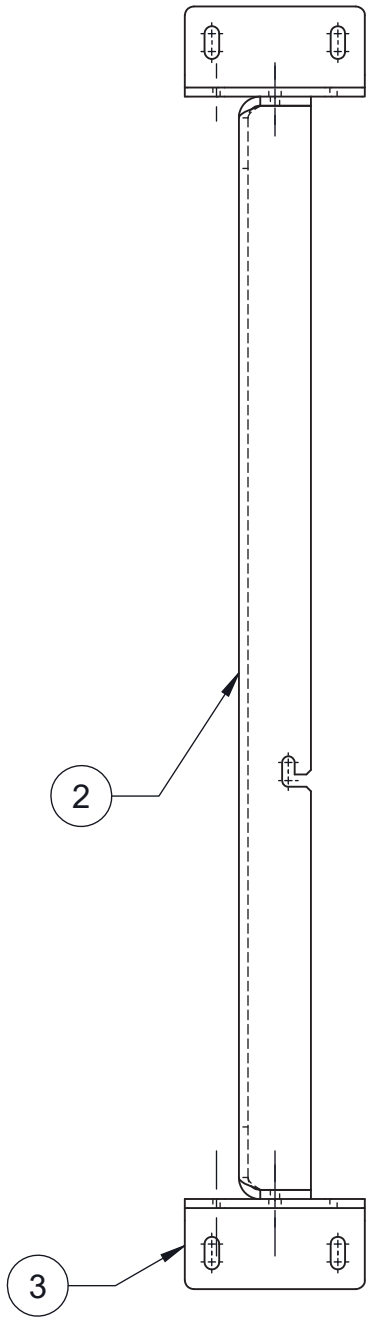
Parent Number: 15269 Parent Revision: B
 Description: ASSY, FINAL, MACH, EL-2100, LH
 Model: EL-2121

Assembly Part Number: 311597
 Assembly Drawing Number: 311597
 Description: ASSY, GUARD, LH
 Quantity: 1.00

Item	Qty	Arpac Part	Description
1	2.00	141604-048	FRAME, PANEL, GUARD 28 7/8 X 66
2	1.00	141604-049	FRAME, PANEL, GUARD 29 1/4 X 34 1/4
3	1.00	141604-050	FRAME, PANEL, GUARD 14 1/2 X 44 1/2
4	1.00	141604-051	FRAME, PANEL, GUARD 17 7/16 X 34 1/2
5	1.00	141604-052	FRAME, PANEL, GUARD 23 X 34 1/2
6	1.00	141604-053	FRAME, PANEL, GUARD 23 X 66
7	1.00	141604-054	FRAME, PANEL, GUARD 18 7/16 X 44 1/2
8	1.00	216173	GUARD, END
9	1.00	243973	FRAME, GUARD
10	1.00	316213-001	WLDMT, SUPPORT, GUARD LH
11	1.00	243977-001	FRAME, GUARD LH
12	1.00	234449	GUARD
13	2.00	243967	PLT, ELECTRICAL BOX HOLDER
14	10.00	837001	CATCH, DOOR, BALL STYLE
15	11.00	806828	HANDLE, SMALL BLACK PLASTIC
16	27.00	810174	HINGE, DOOR, POLYAMIDE, BLACK
17	2.00	256214	BKT, CATCH, DOOR
18	1.00	243965	FRAME, GUARD, STEP BACK
19	1.00	308209	PANEL, GUARD
20	1.00	264149	GUARD, PICK & PLACE
21	100.00	827364	CLAMP, PANEL
22	1.00	311585	ASSY, DOOR, BI-FOLD
23	1.00	311577	GUARD, BOTTOM



PART NUMBERS	
243431	LH, AS SHOWN
243431-001	RH, OPPOSITE



4	1	825527	VALVE, CHECK PILOT/MANUAL RELEASE, 1/4 NPT
3	2	228879	ANGLE, MTG, PLT, DEAD
2	1	228880-001	BKT, MTG, PLT, DEAD
1	1	215218	ANGLE, MTG, PLT, DEAD
ITM	QTY	PART NUM	DESCRIPTION

BILL OF MATERIALS

ARPAC		9511 WEST RIVER ST. SCHILLER PARK, IL 60176	
UNLESS OTHERWISE SPECIFIED ALL DIMENSIONAL TOLERANCES:		FRACTIONS TWO (2) DECIMALS THREE (3) DECIMALS ANGLES	± 1/64 ± 0.010 ± 0.005 ± 0.5°
DRAWN: 11/21/2008	BY: YYL	SCALE: 0.1875:1	SIZE: B
RELEASED: 11/21/2008	FILENAME: 243431	APPROVED BY: YYL	
DESCRIPTION: ASSY, SUPPORT, DEAD PLT			

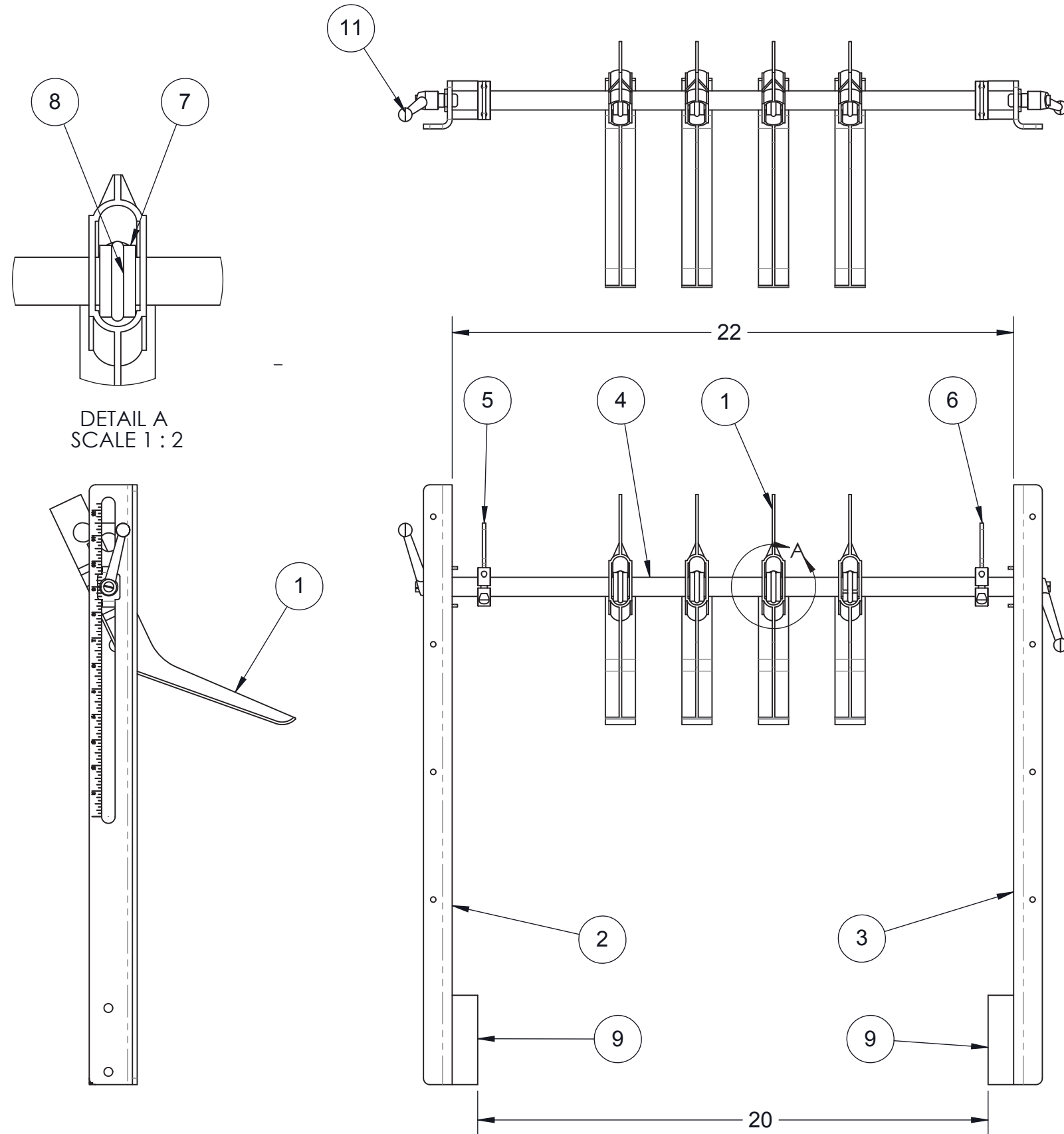
		DRAWING NUMBER:
		243431

Arpac BOM

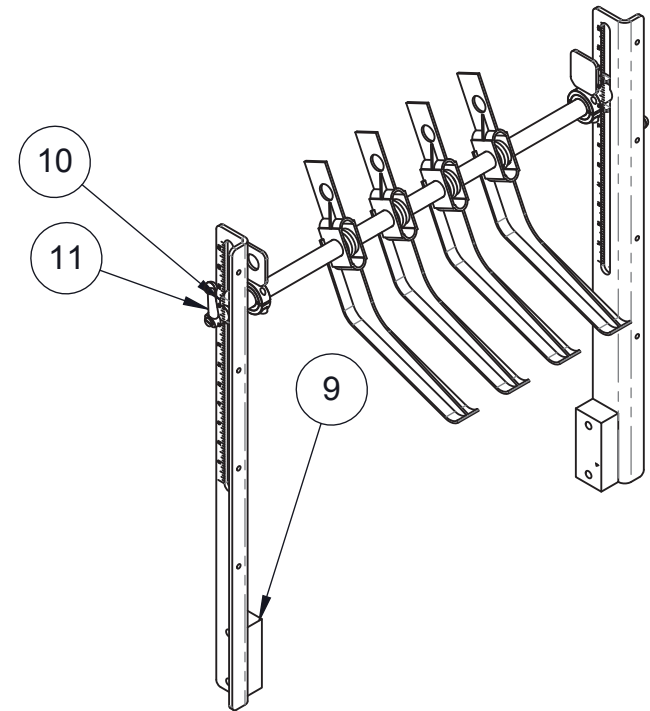
Parent Number: 15269 Parent Revision: B
Description: ASSY, FINAL, MACH, EL-2100, LH
Model: EL-2121

Assembly Part Number: 243431
Assembly Drawing Number: 243431
Description: ASSY, DEAD PLT SUPPORT, LH MACHINE
Quantity: 1.00

Item	Qty	Arpac Part	Description
1	1.00	215218	ANGLE, MTG, PLT, DEAD, LH MACH
2	1.00	228880-001	BKT, MTG, PLT, DEAD, LH
3	2.00	228879	ANGLE, MTG, PLT, DEAD
4	1.00	825527	VALVE, CHECK PILOT/MANUAL RELEASE, 1/4 NPT



REVISIONS			
RV	DATE	BY	DESCRIPTION
A	4/25/2017	SRA	ITEM 1 WAS 841336



11	2	808969	HDL, ADJ, SS, 2.56 LG 5/16-18 X .59 STUD
10	2	286907	INDICATOR
9	2	216906	SPACER
8	4	842149	SPRING, EXTENSION
7	4	283414	COLLAR, LOCATOR, FINGER
6	1	238514	WLDMT, BKT, MTG, P.E. REFLECTOR
5	1	225647	WLDMT, BKT, MTG, P.E.
4	1	214781-004	SHAFT, MTG, DETECTOR
3	1	286911-001	POST MTG DETECTOR
2	1	286911	POST MTG DETECTOR
1	4	848956	LEVER, W/INSERT, DETECT, PRODUCT
ITM	QTY	PART NUM	DESCRIPTION

BILL OF MATERIALS

ARPAC		9511 WEST RIVER ST. SCHILLER PARK, IL 60176	
UNLESS OTHERWISE SPECIFIED ALL DIMENSIONAL TOLERANCES:		FRACTIONS TWO (2) DECIMALS THREE (3) DECIMALS ANGLES	± 1/64 ± 0.010 ± 0.005 ± 0.5°
DRAWN: 2/21/2013	BY: SRA	SCALE: 1:8	SIZE: B
RELEASED: 2/21/2013	FILENAME: 286910	APPROVED BY: SRA	
DESCRIPTION: ASSY, DETECT, PRODUCT, 4 LANES, 20" WIDE			
			DRAWING NUMBER: 286910

Arpac BOM

Parent Number: 15269 Parent Revision: B
Description: ASSY, FINAL, MACH, EL-2100, LH
Model: EL-2121

Assembly Part Number: 286910
Assembly Drawing Number: 286910
Description: ASSY, DETECT, PRODUCT, 4 LANES, 20" WIDE, HIGH PROD
Quantity: 1.00

Item	Qty	Arpac Part	Description
1	4.00	848956	LEVER, DETECT, PRODUCT, W/INSERT
2	1.00	286911	POST MTG DETECTOR, RH
3	1.00	286911-001	POST MTG DETECTOR, LH
4	1.00	214781-004	SHAFT, MTG, DETECTOR, BOTTLE 22 1/4 LG
5	1.00	225647	WLDMT, BKT, MTG, P.E., SS
6	1.00	238514	WLDMT, BKT, MTG, P.E. REFLECTOR, SS
7	4.00	283414	COLLAR, LOCATOR, FINGER
8	4.00	842149	SPRING, EXTENSION
9	2.00	216906	SPACER
10	2.00	286907	INDICATOR
11	2.00	808969	HDL, ADJ, SS, 2.56 LG 5/16-18 X .59 STUD

Arpac BOM

Parent Number: 15269 Parent Revision: B
Description: ASSY, FINAL, MACH, EL-2100, LH
Model: EL-2121

Assembly Part Number: 219639-000A
Assembly Drawing Number: 219639
Description: ASSY, CENTRAL POINT LUBE BLOCK, NYLON
Quantity: 1.00

Item	Qty	Arpac Part	Description
1	120.00	800179	TBG, 1/8 OD, NYL, PRESSURE TYPE H, .079" ID
2	12.00	801406	FTG, ELBOW, 1/8 OD TBG COMP X 1/4-28 TAPERED MALE
3	30.00	801449	FTG, CONN, 1/8 OD TBG COMP X 1/4-28, MALE, SILVER BASE
4	30.00	801455	FTG,ADAPTER,1/8 NPT,1/4-28ID,1/8-27 NPSM, USE W/NUT 51055 (801456)
5	30.00	801456	NUT, 1/8 NPSM, USE W/ADAPTER 13154 (801455)
6	30.00	802208	FTG, GREASE, 1/8 NPT, STRAIGHT, ZINC PL
8	2.00	219641	PLT, CENTRAL LUB, 4 HOLE

Arpac BOM

Parent Number: 15269 Parent Revision: B
Description: ASSY, FINAL, MACH, EL-2100, LH
Model: EL-2121

Assembly Part Number: 292546
Assembly Drawing Number: 292546
Description: GENERAL PARTS, EL-2000
Quantity: 1.00

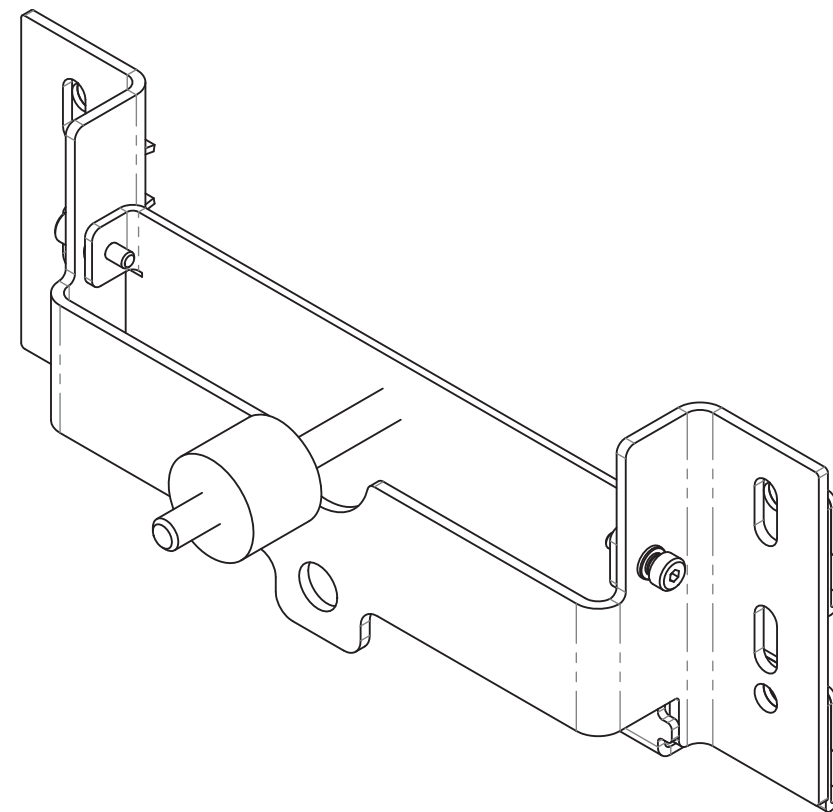
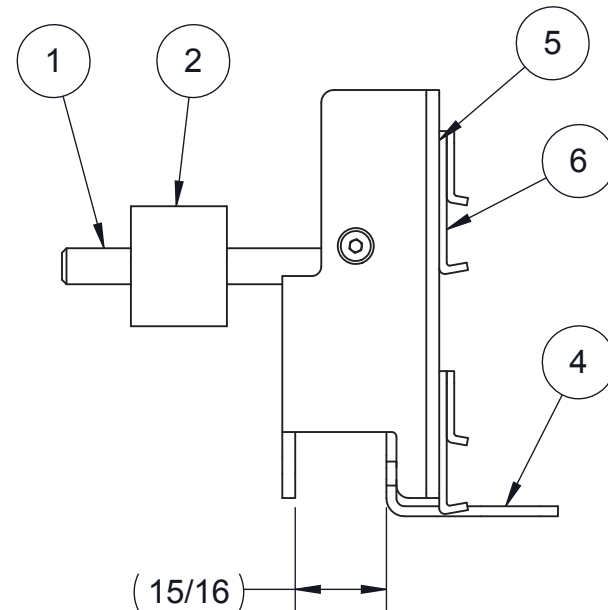
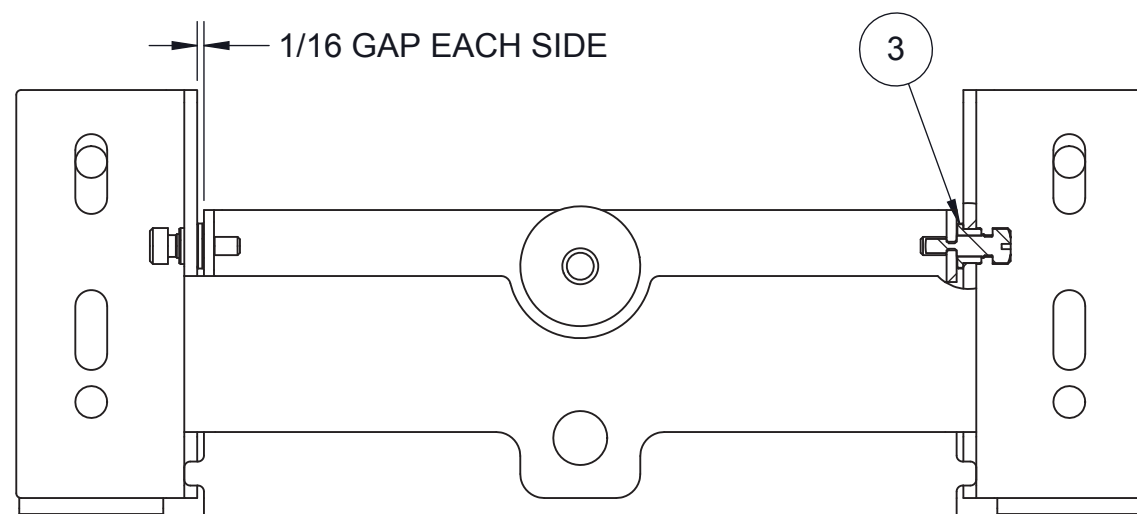
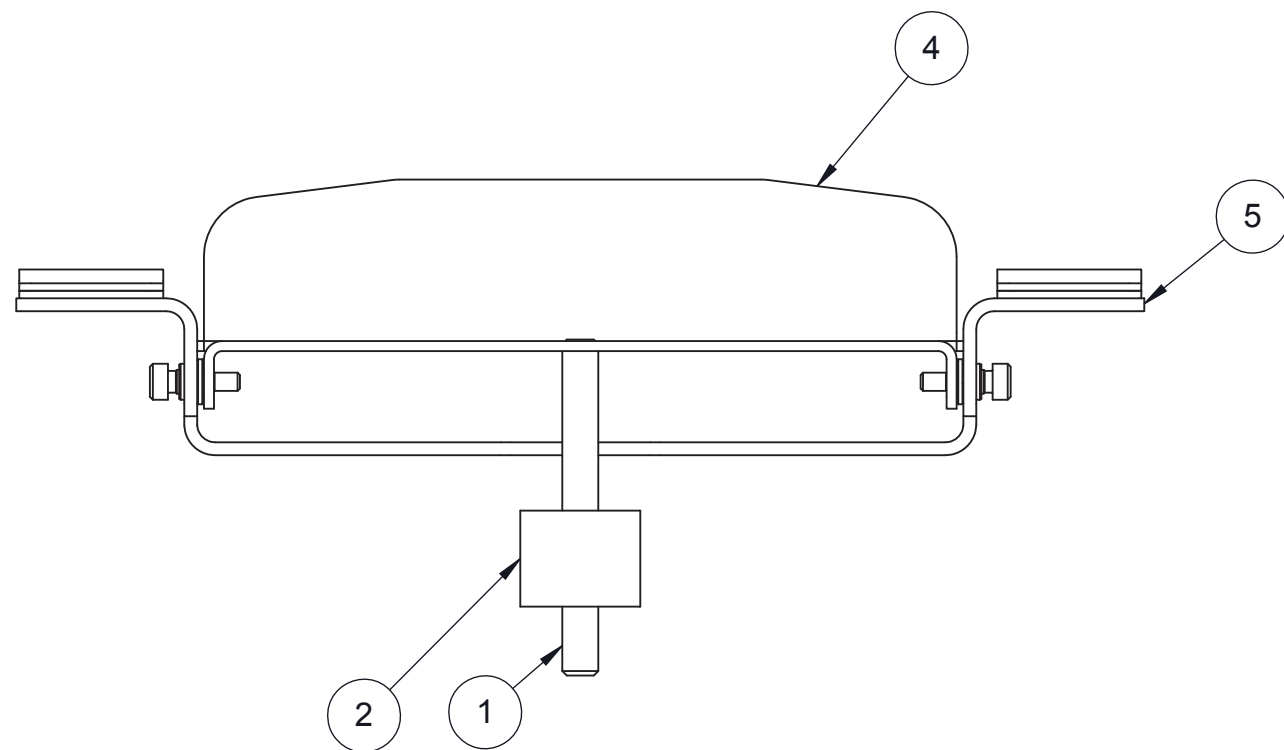
Item	Qty	Arpac Part	Description
1	1.00	999999-002	1407 GENERAL NON-BOM CCCC, FSXX, MMSS, PPCN
2	10.00	845767	PAINT BLACK S/G TEXTURE HYBRID
3	10.00	828102	PAINT, POWDER, SILVER, SPARKLE

Arpac BOM

Parent Number: 15269 Parent Revision: B
Description: ASSY, FINAL, MACH, EL-2100, LH
Model: EL-2121

Assembly Part Number: 364278
Assembly Drawing Number: 364278
Description: KIT, PARTS, CHANGE, 15269
Quantity: 1.00

Item	Qty	Arpac Part	Description
1	1.00	364277	ASSY, GUIDE, POP-UP, 6-LANE, LH, 2.09 DIA PROD
2	1.00	364275	WLDMT, PLT, PUSHES
3	1.00	364274	SUBASSY, SPACER, GUIDE, 6-LANE, 2.09 DIA
4	1.00	322570	BLK, HOSE PARKING



6	4	801359	CLAMP, RAIL, SINGLE, 1.5 LG, SS, ROUND HOLE
5	1	323269	BRKT, FRAME, PRD DTCTR, ACCUM, ADJ
4	1	291031	BRACKET, PROD DETECTOR, ACCUM
3	2	800424	BUSH, OILITE, FLG, 0.252 X 0.3775 X 1/4, 15/32 OD X 1/16 THK FLG
2	1	107147	WEIGHT, COUNTER
1	1	107149	SHAFT, WEIGHT, COUNTER
ITM	QTY	PART NUM	DESCRIPTION

BILL OF MATERIALS

ARPAC

9511 WEST RIVER ST.
SCHILLER PARK, IL 60176

UNLESS OTHERWISE SPECIFIED
ALL DIMENSIONAL TOLERANCES:

FRACTIONS
TWO (2) DECIMALS ± 1/64
THREE (3) DECIMALS ± 0.010
ANGLES ± 0.5°

DRAWN: 11/8/2012 BY: SR SCALE: 1:2 SIZE: B

RELEASED: 11/8/2012 FILENAME: 323268 APPROVED BY: SRA

DESCRIPTION:
ASSY, PRODUCT DETECTOR, ACCUMULATION, ADJ

3

DRAWING NUMBER:
323268

Arpac BOM

Parent Number: 15269 Parent Revision: B
Description: ASSY, FINAL, MACH, EL-2100, LH
Model: EL-2121

Assembly Part Number: 323268
Assembly Drawing Number: 323268
Description: ASSY, PRODUCT DETECTOR, ACCUMULATION, ADJ
Quantity: 1.00

Item	Qty	Arpac Part	Description
1	1.00	107149	SHAFT WEIGHT COUNTER
2	1.00	107147	WEIGHT COUNTER
3	2.00	800424	BUSH, OILITE, FLG, 0.252 X 0.3775 X 1/4, 15/32 OD X 1/16 THK FLG
4	1.00	291031	BRACKET, PROD DETECTOR, ACCUM
5	1.00	323269	BRKT, FRAME, PRD DTCTR, ACCUM, ADJ
6	4.00	801359	CLAMP, RAIL, SINGLE, 1.5 LG, SS, ROUND HOLE

Arpac BOM

Parent Number: 15269 Parent Revision: B
Description: ASSY, FINAL, MACH, EL-2100, LH
Model: EL-2121

Assembly Part Number: 357410
Assembly Drawing Number: 357410
Description: ASSY, AGITATOR, 20"WIDE, 6 LANES, 230/460V
Quantity: 1.00

Item	Qty	Arpac Part	Description
1	3.00	245943	WLDMT, PLT, DIVIDER
2	4.00	245946	WLDMT, PLT, DIVIDER
3	1.00	245954	PLT, TOP
4	4.00	245956	SPACER
5	2.00	245957	BLK, GUIDE
6	2.00	292992	BAR, OSCILLATOR
7	2.00	292993	BAR, SLIDE
8	1.00	303335	WLDMT, SHAFT, DRIVE, ECCENTRIC
9	1.00	303334	PLT, MOUNT, GEARBOX
10	1.00	303332	WLDMT, BRIDGE, 20"
11	1.00	300790	BAR, MTG, FRONT, AGITATOR, 20"
12	14.00	811880	HDL, ADJ, SS, 3.13 LG, PLAS 3/8-16 X 1.18 LG
13	14.00	819732	FSNR, WASHER, 1 OD, 3/16 TH.
14	1.00	819733	FTG, GREASE 45 DEG, 1/4-28
15	1.00	848034	GEARMOTOR, FLEXBLOC, 1/3 HP, OUTPUT: 28 RPM, 1.125 BORE, 230/460VAC, 3PH,
16	2.00	300789	SPACER

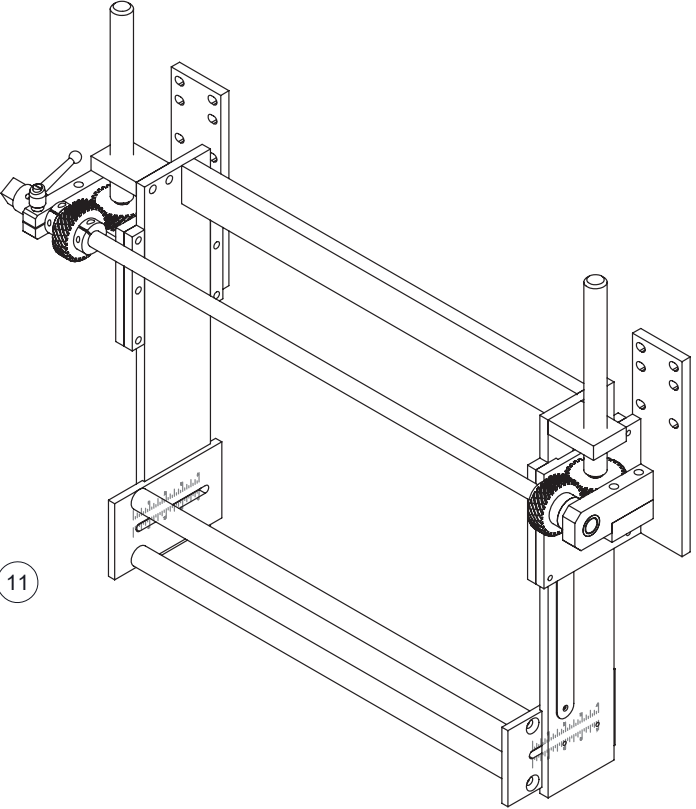
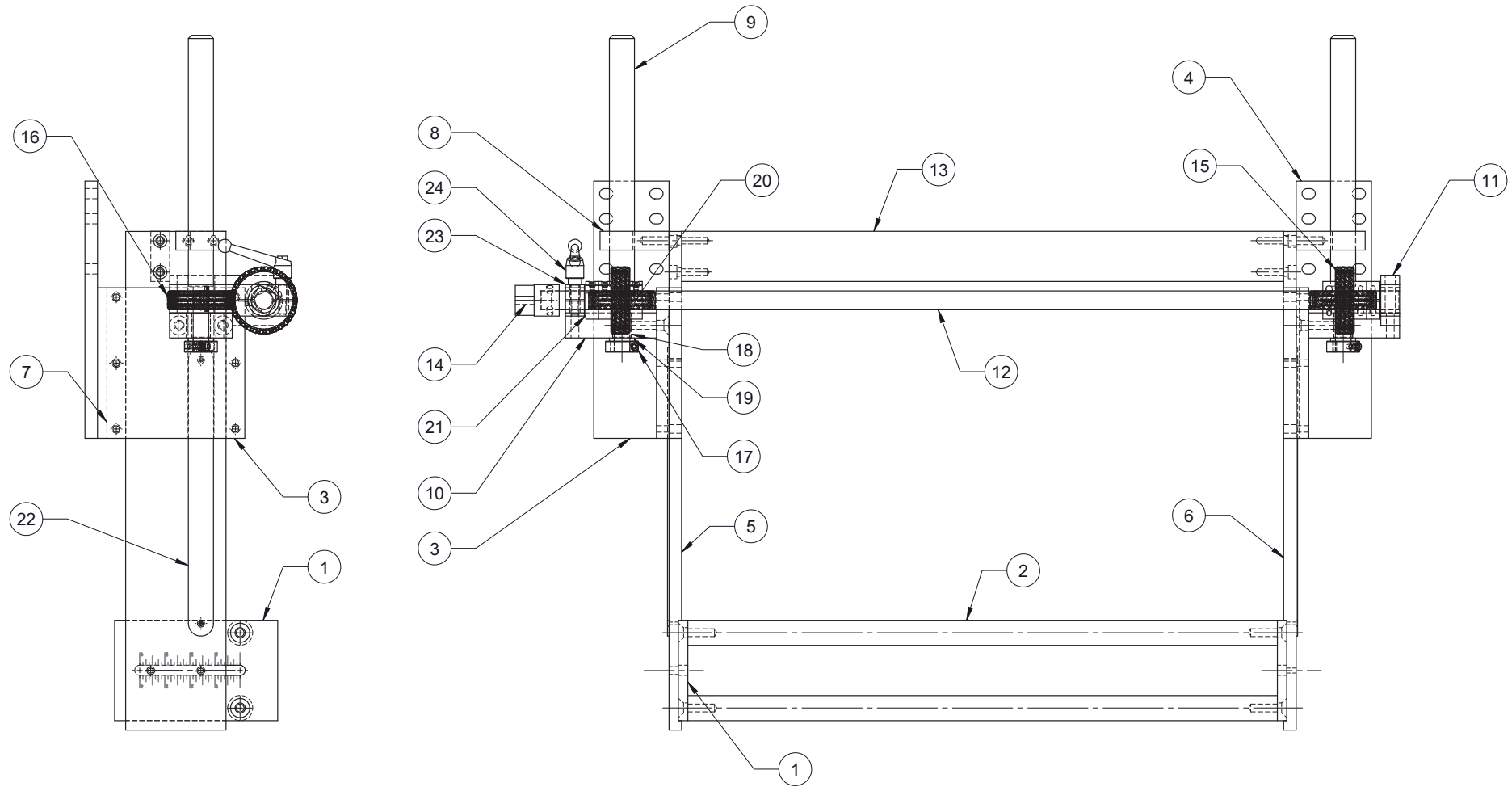
Arpac BOM

Parent Number: 15269 Parent Revision: B
Description: ASSY, FINAL, MACH, EL-2100, LH
Model: EL-2121

Assembly Part Number: 357171
Assembly Drawing Number: 357171
Description: ASSY, GUARD, AGITATOR, EL-2000
Quantity: 1.00

Item	Qty	Arpac Part	Description
1	4.00	810174	HINGE, DOOR, POLYAMIDE, BLACK
2	2.00	802653	LATCH, VISE-ACTION
3	2.00	357168	DOOR, AGITATOR, EL-2000
4	2.00	357166	TBG, MTG, LEXAN
5	2.00	357169	BKT, MTG
6	1.00	357167	BKT, STOP & LOCK

REVISIONS			
RV	DATE	BY	DESCRIPTION
A	4/1/2013	SRA	ADDED ITEMS 23 AND 24



24	1	806459	HDL, ADJ, ZINC, 2-1/2 LG 5/16-18 X 1.18 STUD
23	1	290615	BLK, CLAMP, SHAFT
22	2	242962	GAUGE, STOP, CAN
21	2	807258	WSHR, OILITE, 0.753 X 1.250 X 1/16 THK
20	6	807096	COLLAR, SHAFT, CLAMP, 1-PIECE, 3/4
19	2	800449	WSHR, OILITE, 0.628 X 1.000 X 1/8 THK
18	4	800357	BUSH, OILITE, 0.6270 X 0.7530 X 1 LG
17	2	800578	COLLAR, SHAFT, CLAMP, 1-PIECE, 5/8
16	2	808333	GEAR, HELICAL, 12 DP, 30T, 14.5 DEG PA, 3/4 FACE, 5/8 BORE, 2.500 PD, HARD TEETH
15	2	243330	VERTICAL ADJUSTMENT GEAR
14	1	243280	ADJ NUT 3/4 SQUARE, Ø5/8 BORE
13	1	242951	XBAR, STOP, CAN
12	1	242955	SHAFT, ADJ, STOP, CAN
11	1	242954	BLK,SUPPORT,LWR
10	2	242957	BLK, MTG, ADJ, STOP, CAN
9	2	243416	VERT. ADJ. SCREW
8	2	242956	NUT, ADJ, STOP, CAN
7	4	242949	BLK, GUIDE
6	1	242948-002	BAR, VER, STOP, CAN, LH
5	1	242948-001	BAR, VER, STOP, CAN, RH
4	1	242952-002	WLDMT, BKT, STOP, CAN, LH
3	1	242952-001	WLDMT, BKT, STOP, CAN, RH
2	2	214314	SHAFT, TAPPED
1	2	228674	PLT, STOP, CAN

ITM	QTY	PART NUM	DESCRIPTION
BILL OF MATERIALS			
ARPAC		9511 WEST RIVER ST. SCHILLER PARK, IL 60176	
UNLESS OTHERWISE SPECIFIED ALL DIMENSIONAL TOLERANCES:		FRACTIONS TWO (2) DECIMALS THREE (3) DECIMALS ANGLES	± 1/64 ± 0.010 ± 0.005 ± 0.5°
DRAWN:	02/13/2007	BY:	HHG
RELEASED:	02/13/2007	FILENAME:	243312
SCALE:	0.25:1	APPROVED BY:	HHG
SIZE:	C	DESCRIPTION: ASSY, ADJ, CAN STOP	
			DRAWING NUMBER: 243312

PART NUMBER	MODE
243312-001	LH, AS SHOWN
243312-002	RH, OPPOSITE
243312-100	LH, AS SHOWN, SS

Arpac BOM

Parent Number: 15269 Parent Revision: B

Description: ASSY, FINAL, MACH, EL-2100, LH

Model: EL-2121

Assembly Part Number: 243312-001B

Assembly Drawing Number: 243312

Description: ASSY, ADJ., CAN STOP, LH EL2000

Quantity: 1.00

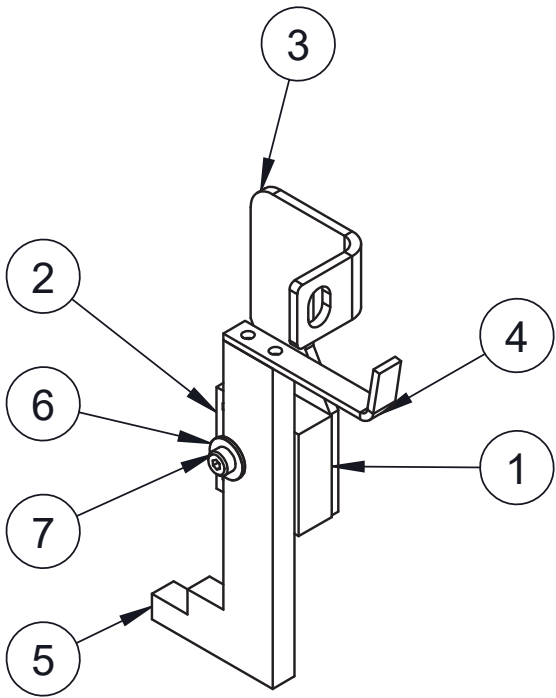
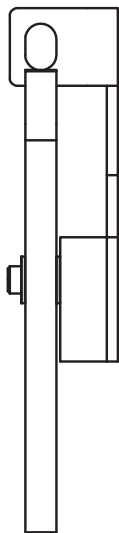
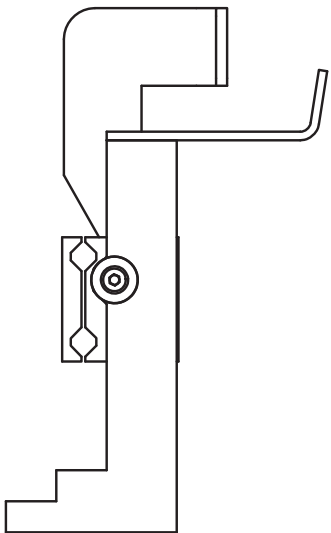
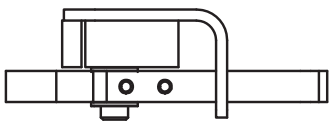
Item	Qty	Arpac Part	Description
1	2.00	228674	PLT, STOP, CAN
2	2.00	214314	SHAFT TS-25 STD, 23 1/2 LG
3	1.00	242952-001	WLDMT, BKT, CAN STOP, RH
4	1.00	242952-002	WLDMT, BKT, CAN STOP, LH
5	1.00	242948-001	BAR, VER, STOP, CAN, RH
6	1.00	242948-002	BAR, VER, STOP, CAN, LH
7	4.00	242949	BLK, GUIDE
8	2.00	242956	NUT, ADJ, STOP, CAN
9	2.00	243416	SCREW, ADJ, VERTICAL
10	2.00	242957	BLK, MTG, ADJ, STOP, CAN
11	1.00	242954	BLK, SUPPORT, LWR
12	1.00	242955-100	SHAFT, ADJ, STOP, CAN, SS
13	1.00	242951	XBAR, STOP, CAN
14	1.00	243280	ADAPTER, WRENCH, 3/4 DIA TO 7/8 SQ
15	2.00	243330	GEAR, ADJUST., 12 DP, 30 T, 14.5 DEG 3/4" FACE, 3/4 BORE
16	2.00	808333	GEAR, HELICAL, 12 DP, 30T, 14.5 DEG PA, 3/4 FACE, 5/8 BORE, 2.500 PD, HAR
17	2.00	800578	COLLAR, SHAFT, CLAMP, 1-PIECE, 5/8, *USE 800578-001 FOR STRETCH
18	4.00	800357	BUSH, OILITE, 0.6270 X 0.7530 X 1 LG
19	4.00	800449	WSHR, OILITE, 0.628 X 1.000 X 1/8 THK
20	6.00	807096	COLLAR, SHAFT, CLAMP, 1-PIECE, 3/4, EXTREME CL8867
21	2.00	807258	WSHR, OILITE, 0.753 X 1.250 X 1/16 THK
22	2.00	242962	SCALE, STOP, CAN
23	1.00	290615	BLK, CLAMP, SHAFT
24	1.00	806459	HDL, ADJ, ZINC, 2-1/2 LG 5/16-18 X 1.18 STUD

Arpac BOM

Parent Number: 15269 Parent Revision: B
Description: ASSY, FINAL, MACH, EL-2100, LH
Model: EL-2121

Assembly Part Number: 364284
Assembly Drawing Number: 364284
Description: ASSY, CLAMP, STOP, PRODUCT, 2 X 5-1/2
Quantity: 6.00

Item	Qty	Arpac Part	Description
1	1.00	364283	ASSY, CLAMP, STOP, PRODUCT, 2 X 5-1/2
2	1.00	261117	BARREL, CAN STOP
3	1.00	243425	CLAMP, CAN STOP
4	1.00	122151-002	SHAFT, CAN STOP 5 1/4 LG
5	1.00	825526	CYL, AIR, 1-1/4 BORE, 1 STROKE, ROUND, NOSE MTG
6	1.00	802678	HDL, ADJ, ZINC, 2-1/2 LG 3/8-16 X 1.57 STUD
7	1.00	223560	BLK, GUIDE
8	1.00	223575	ROD, SS, 0.500, TAPPED, 1/4-20



7	1	800322-009	FSNR, BOLT, SHLDR, 5/16 DIA X 5/8 LG
6	2	800445	WSHR, OILITE, 0.315 X 0.750 X 1/16 THK
5	1	300785	FINGER, DETECTOR
4	1	300781	FLAG, PROX
3	1	300783	BKT, MTG, PROX
2	1	242950	BLK, TOP, ADJ, BKT, MTG, PROX
1	1	242947	BLK, ADJ, BKT, MTG, PROX
ITM	QTY	PART NUM	DESCRIPTION

BILL OF MATERIALS

ARPAC

9511 WEST RIVER ST.
SCHILLER PARK, IL 60176

UNLESS OTHERWISE SPECIFIED
ALL DIMENSIONAL TOLERANCES:

FRACTIONS
TWO (2) DECIMALS
THREE (3) DECIMALS
ANGLES

± 1/64
± 0.010
± 0.005
± 0.5°

DRAWN: 6/21/11	BY: HG	SCALE: 1:4	SIZE: A
FILENAME: 300784			
DESCRIPTION: ASSY, FINGER DETECTOR			
			DRAWING NUMBER: 300784

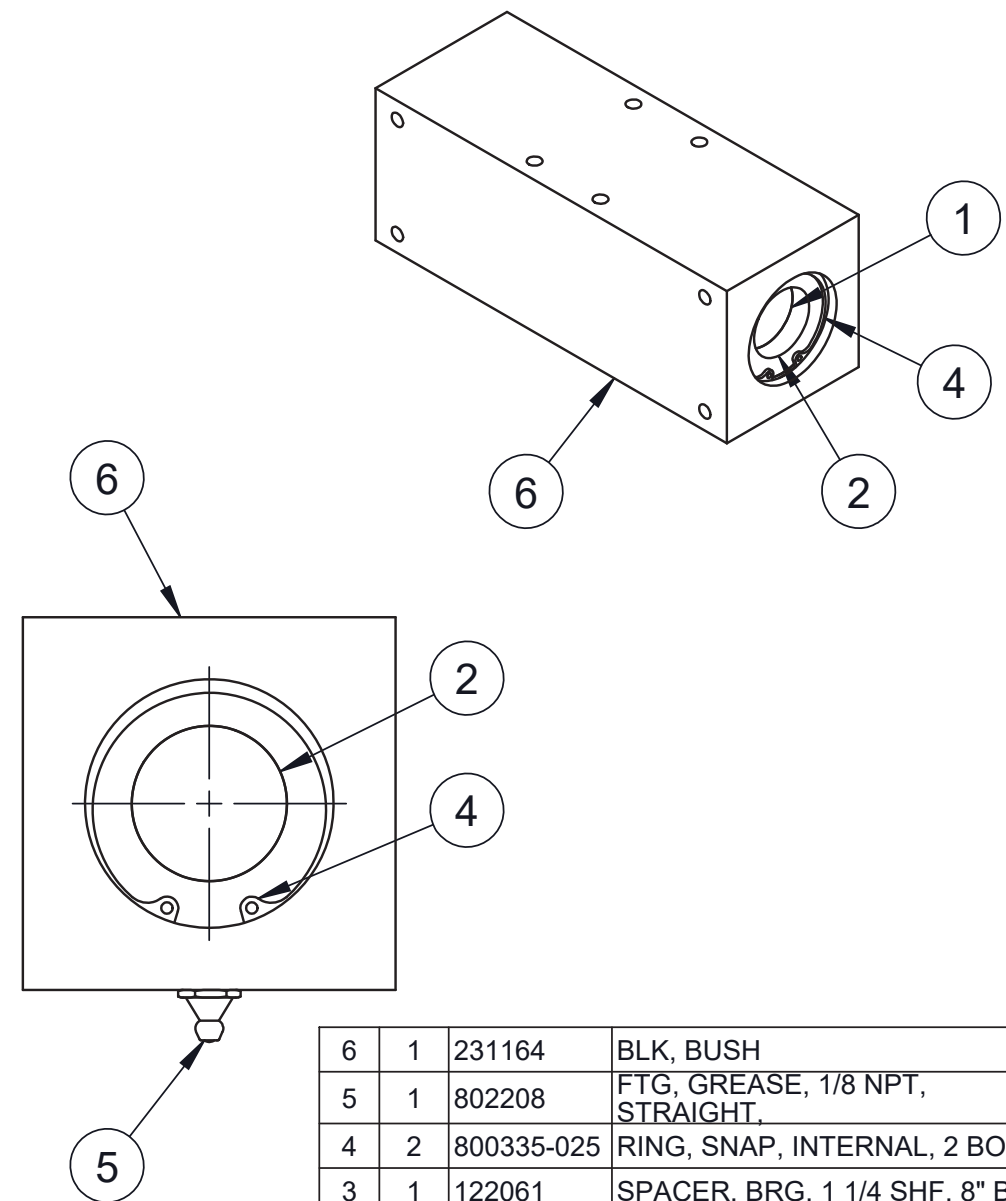
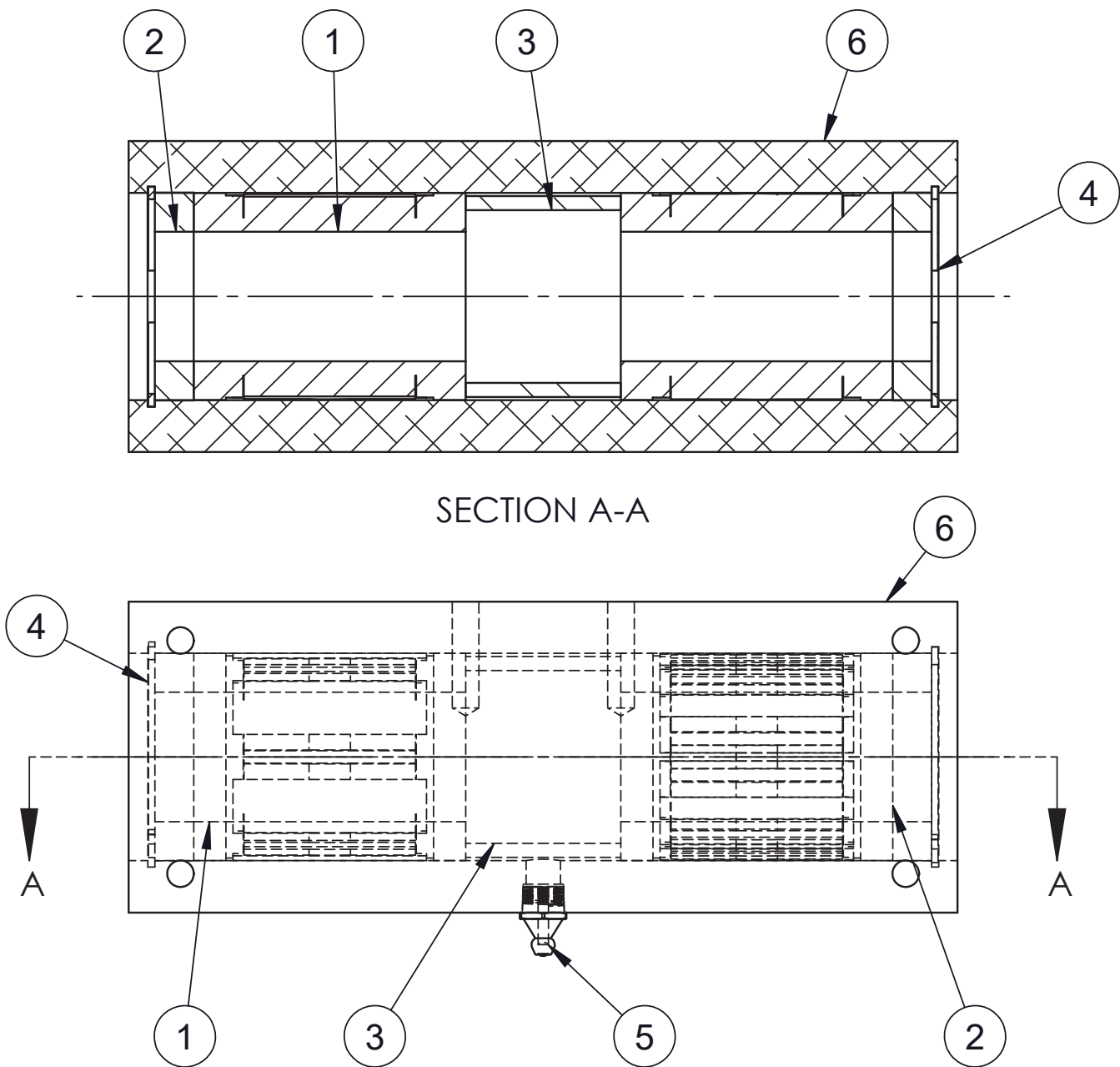
Arpac BOM

Parent Number: 15269 Parent Revision: B
Description: ASSY, FINAL, MACH, EL-2100, LH
Model: EL-2121

Assembly Part Number: 300784

Assembly Drawing Number: 300784
Description: ASSY, FINGER DETECTOR
Quantity: 6.00

Item	Qty	Arpac Part	Description
1	1.00	242947	BLK, ADJ, BKT, MTG, PROX
2	1.00	242950	BLK, TOP, ADJ, BKT, MTG, PROX
3	1.00	300783	BKT, MTG, PROX
4	1.00	300781	FLAG, PROX.
5	1.00	300785	FINGER, DETECTOR
6	2.00	800445	WSHR, OILITE, 0.315 X 0.750 X 1/16 THK
7	1.00	800322-009	F5NR, BOLT, SHLDR, 5/16 DIA X 5/8 LG, SS
8	2.13	900306	SS FLAT 3/4 X 1-1/2, 304, EXTRUDED FLAT BAR/TRUE BAR
9	0.50	902675	SS FLAT 3/4 X 2, 303, TRUE BAR
10	23.81	903588	SS SHEET 7GA, 304, #2B FINISH
11	2.38	900563	CRS FLAT 1-1/4 X 2-1/2, 1018
12	18.00	903817	PL NYLATRON GS SHEET 1/2 THK



6	1	231164	BLK, BUSH
5	1	802208	FTG, GREASE, 1/8 NPT, STRAIGHT,
4	2	800335-025	RING, SNAP, INTERNAL, 2 BORE
3	1	122061	SPACER, BRG, 1 1/4 SHF, 8" BLK
2	2	802927	RING, SEAL, 1-1/4 X 2.004 X 0.375 THK
1	2	805975	BUSH, BALL, 1-1/4 X 2 X 2-5/8 LG
ITM	QTY	PART NUM	DESCRIPTION

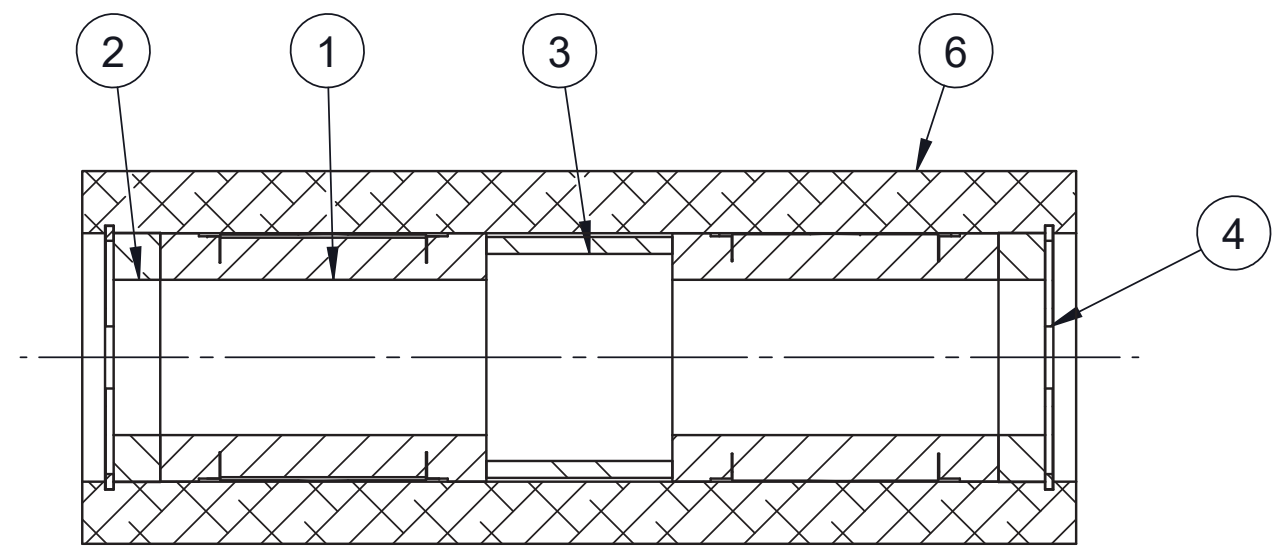
BILL OF MATERIALS			
ARPAC		9511 WEST RIVER ST. SCHILLER PARK, IL 60176	
UNLESS OTHERWISE SPECIFIED		FRACTIONS ± 1/64	
ALL DIMENSIONAL TOLERANCES:		TWO (2) DECIMALS ± 0.010	
		THREE (3) DECIMALS ± 0.005	
		ANGLES ± 0.5°	
DRAWN:	3/31/14	BY:	HG
		SCALE:	1:2
		SIZE:	A
		FILENAME:	231163
DESCRIPTION: ASSY, BLK, BUSH, SHAFT, 1-1/4", 8" LG,			
DRAWING NUMBER: 231163			

Arpac BOM

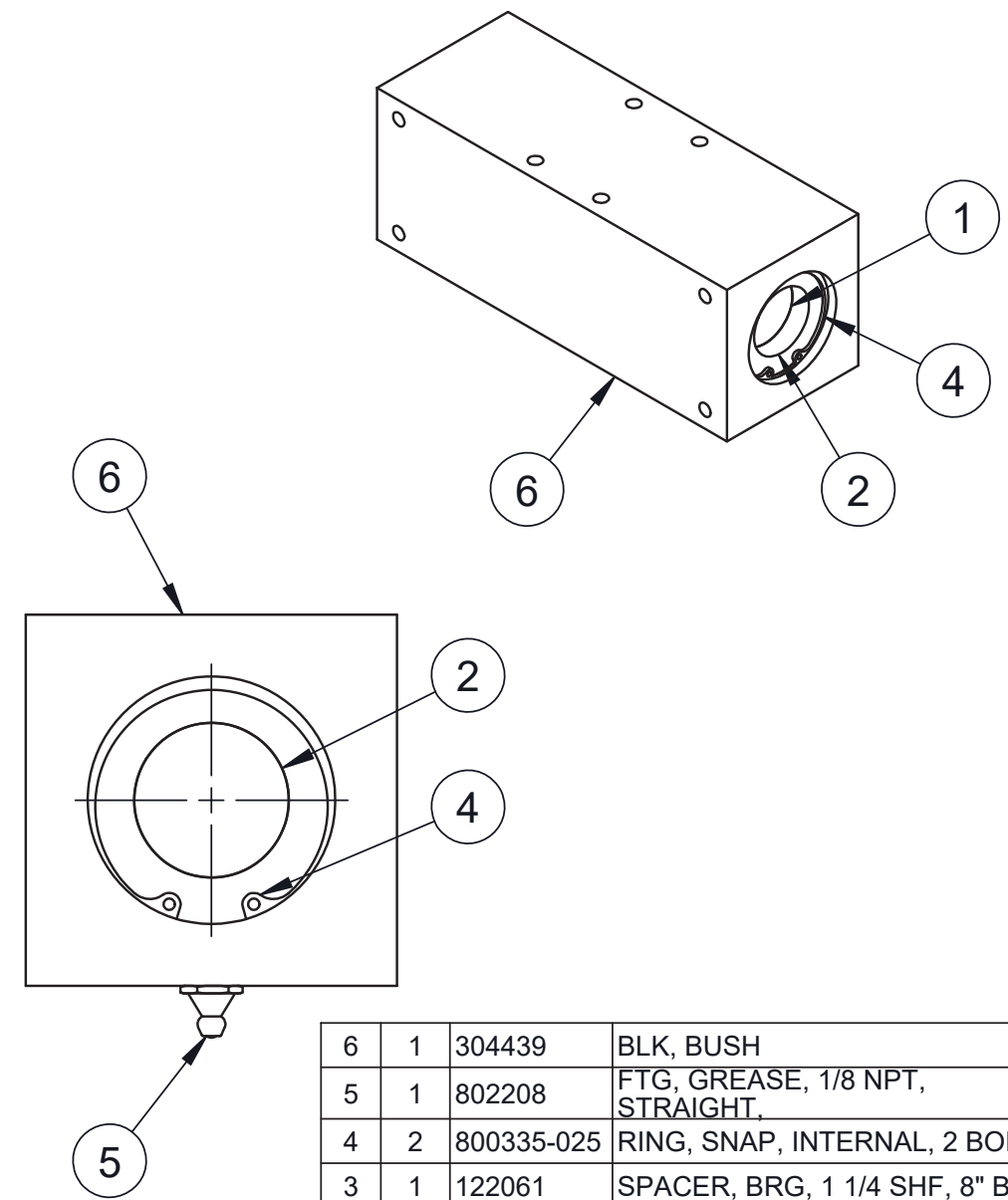
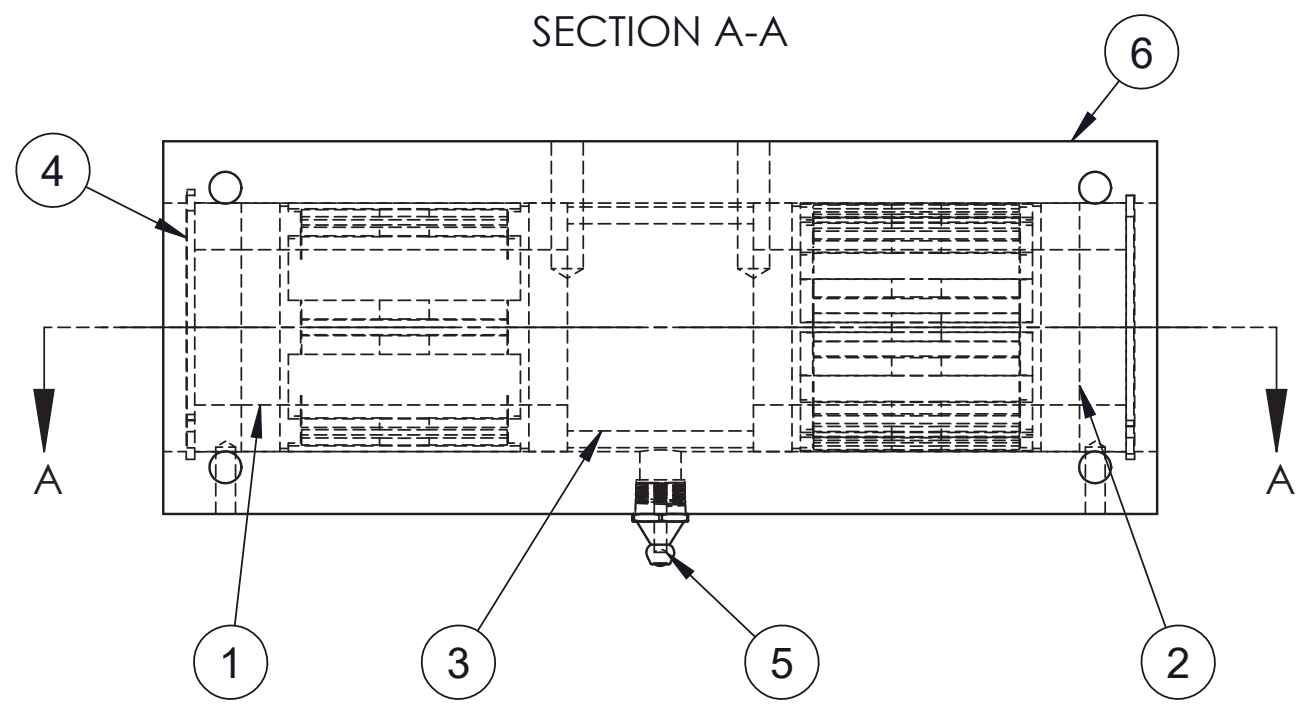
Parent Number: 15269 Parent Revision: B
Description: ASSY, FINAL, MACH, EL-2100, LH
Model: EL-2121

Assembly Part Number: 231163
Assembly Drawing Number: 231163
Description: ASSY, BLK, BUSH, SHAFT, 1-1/4", 8" LG,
Quantity: 1.00

Item	Qty	Arpac Part	Description
1	2.00	805975	BUSH, BALL, 1-1/4 X 2 X 2-5/8 LG
2	2.00	802927	RING, SEAL, 1-1/4 X 2.004 X 0.375 THK
3	1.00	122061	SPACER, BRG, 1 1/4 SHF, 8" BLK
4	2.00	800335-025	RING, SNAP, INTERNAL, 2 BORE
5	1.00	802208	FTG, GREASE, 1/8 NPT, STRAIGHT, ZINC PL
6	1.00	231164	BLK, BUSH
7	8.13	900169	AL SQ 3, 6061-T6511
8	1.88	900998	CRS TBG DOM 2 OD X 1.732 ID X 10GA (0.134) WALL



SECTION A-A



6	1	304439	BLK, BUSH
5	1	802208	FTG, GREASE, 1/8 NPT, STRAIGHT,
4	2	800335-025	RING, SNAP, INTERNAL, 2 BORE
3	1	122061	SPACER, BRG, 1 1/4 SHF, 8" BLK
2	2	802927	RING, SEAL, 1-1/4 X 2.004 X 0.375 THK
1	2	805975	BUSH, BALL, 1-1/4 X 2 X 2-5/8 LG
ITM	QTY	PART NUM	DESCRIPTION

BILL OF MATERIALS

ARPAC

9511 WEST RIVER ST.
SCHILLER PARK, IL 60176

UNLESS OTHERWISE SPECIFIED
ALL DIMENSIONAL TOLERANCES:

FRACTIONS
TWO (2) DECIMALS
THREE (3) DECIMALS
ANGLES

± 1/64
± 0.010
± 0.005
± 0.5°

DRAWN: 7/09/2014

BY: GGP

SCALE: 1:2

SIZE: A

FILENAME: 304441

DESCRIPTION: ASSY, BLK, BUSH, SHAFT, 1-1/4", 8" LG,

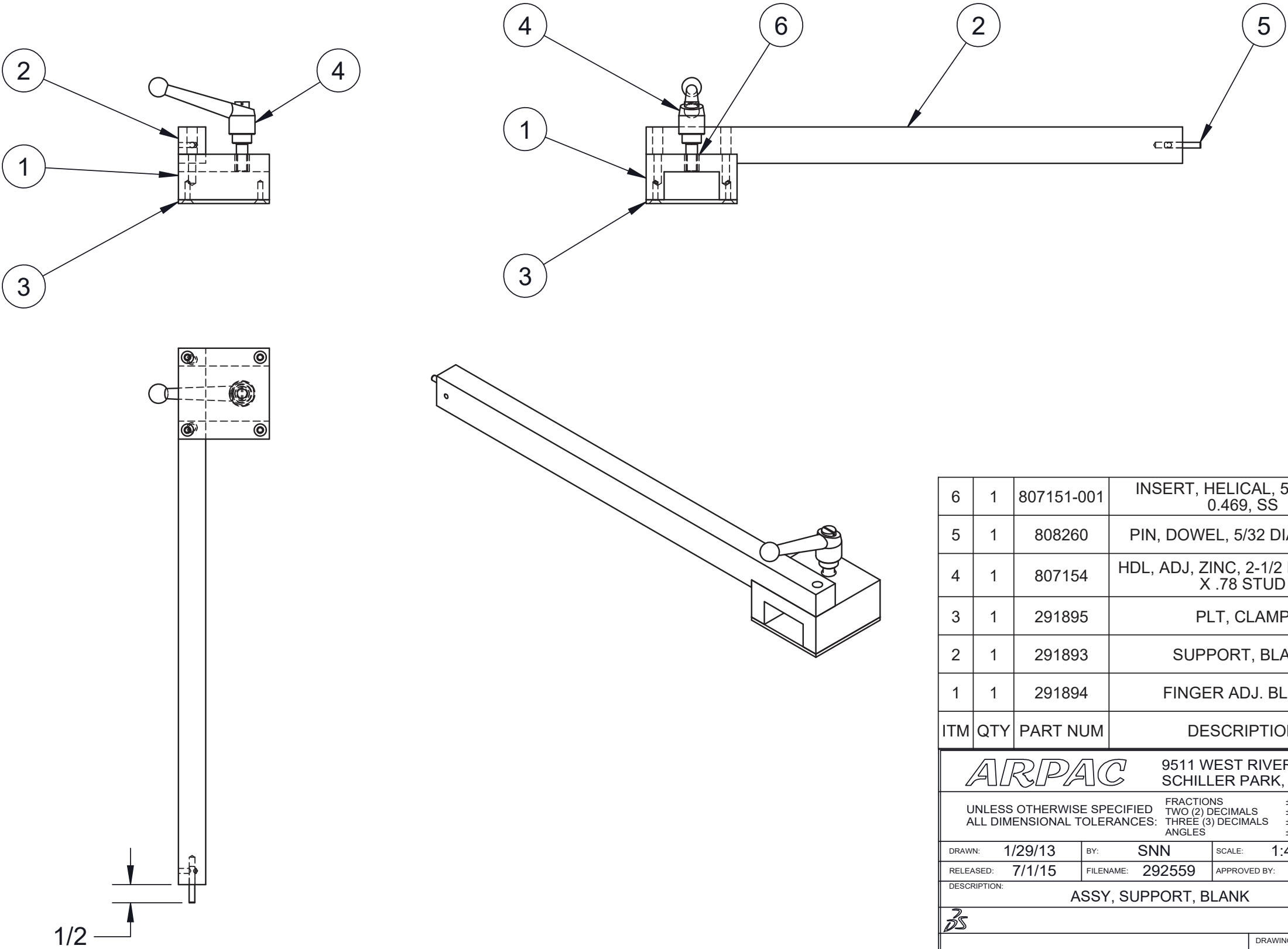
DRAWING NUMBER: 304441

Arpac BOM

Parent Number: 15269 Parent Revision: B
Description: ASSY, FINAL, MACH, EL-2100, LH
Model: EL-2121

Assembly Part Number: 304441
Assembly Drawing Number: 304441
Description: ASSY, BLK, BUSH, SHAFT, 1-1/4", 8" LG,
Quantity: 1.00

Item	Qty	Arpac Part	Description
1	2.00	805975	BUSH, BALL, 1-1/4 X 2 X 2-5/8 LG
2	2.00	802927	RING, SEAL, 1-1/4 X 2.004 X 0.375 THK
3	1.00	122061	SPACER, BRG, 1 1/4 SHF, 8" BLK
4	2.00	800335-025	RING, SNAP, INTERNAL, 2 BORE
5	1.00	802208	FTG, GREASE, 1/8 NPT, STRAIGHT, ZINC PL
6	1.00	304439	BLK, BUSH



REVISIONS			
RV	DATE	BY	DESCRIPTION
A	7/1/2015	SRA	ADDED ITEM 6 HELICAL INSERT

6	1	807151-001	INSERT, HELICAL, 5/16-18 X 0.469, SS
5	1	808260	PIN, DOWEL, 5/32 DIA X 1 LG,
4	1	807154	HDL, ADJ, ZINC, 2-1/2 LG 5/16-18 X .78 STUD
3	1	291895	PLT, CLAMP
2	1	291893	SUPPORT, BLANK
1	1	291894	FINGER ADJ. BLOCK
ITM	QTY	PART NUM	DESCRIPTION

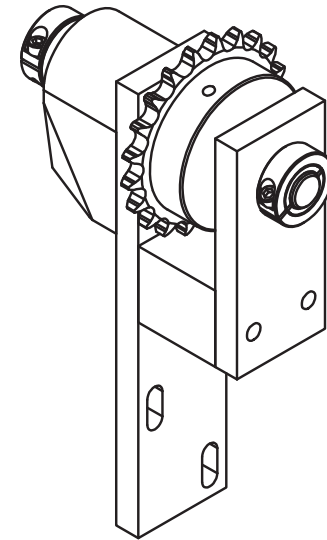
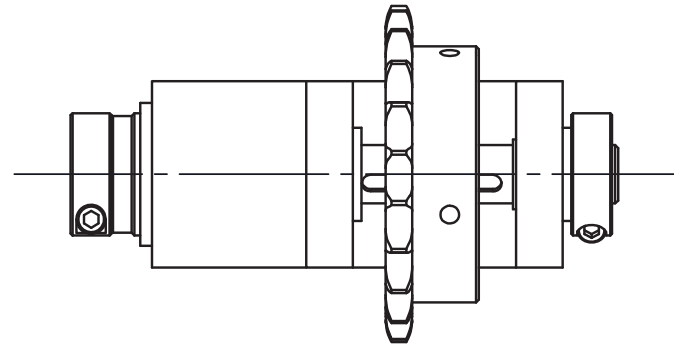
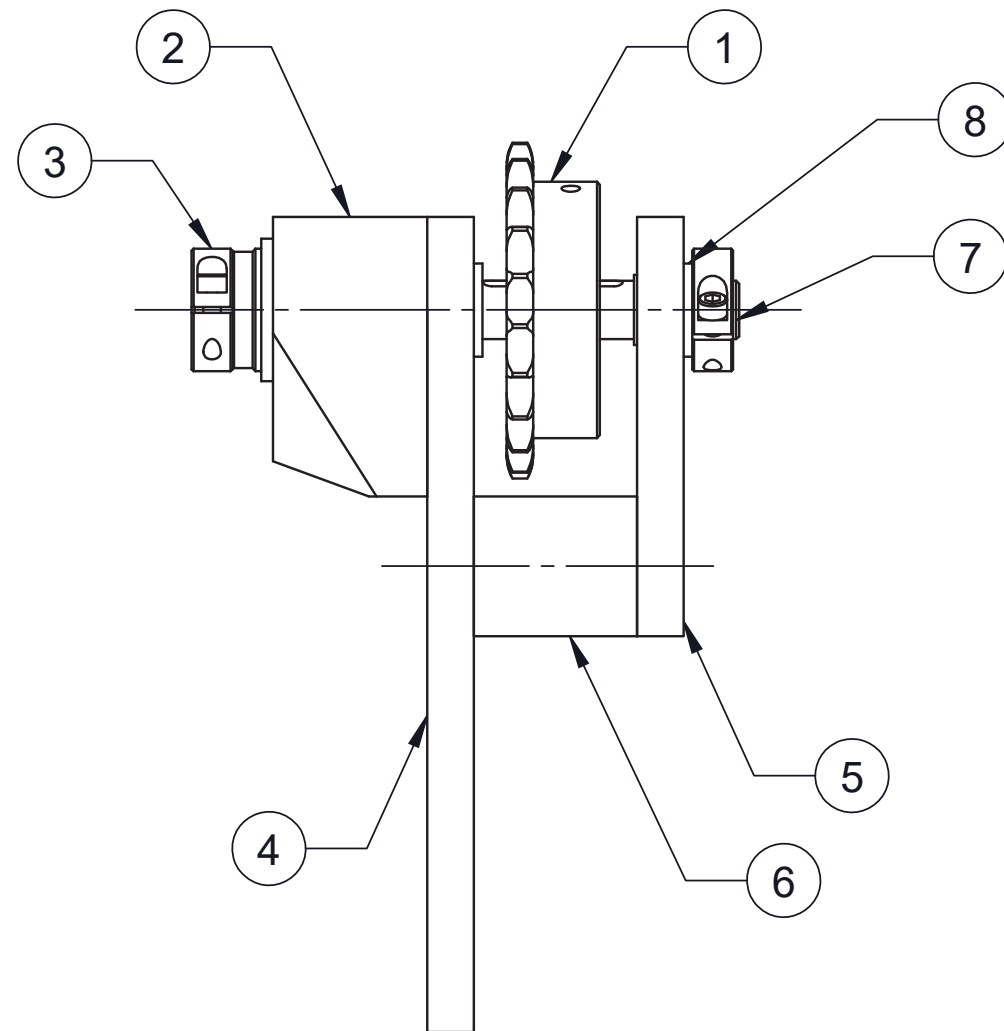
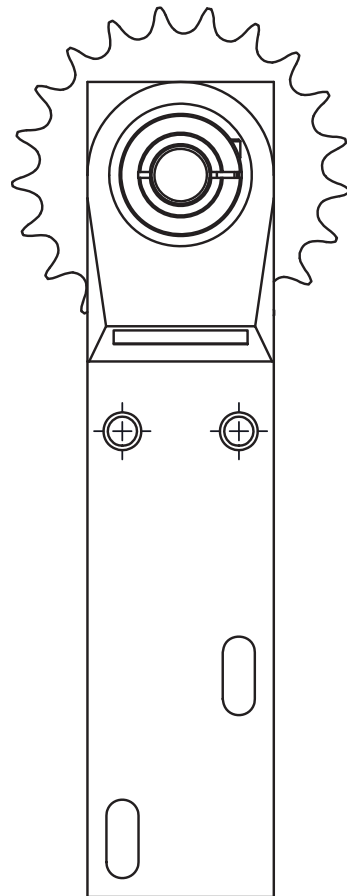
ARPAC		9511 WEST RIVER ST. SCHILLER PARK, IL 60176	
UNLESS OTHERWISE SPECIFIED ALL DIMENSIONAL TOLERANCES:		FRACTIONS TWO (2) DECIMALS THREE (3) DECIMALS ANGLES	± 1/64 ± 0.010 ± 0.005 ± 0.5°
DRAWN:	1/29/13	BY:	SNN
RELEASED:	7/1/15	FILENAME:	292559
DESCRIPTION:		SCALE:	1:4
		APPROVED BY:	SRA
		ASSY, SUPPORT, BLANK	
		DRAWING NUMBER: 292559	

Arpac BOM

Parent Number: 15269 Parent Revision: B
Description: ASSY, FINAL, MACH, EL-2100, LH
Model: EL-2121

Assembly Part Number: 292559
Assembly Drawing Number: 292559
Description: ASSY, SUPPORT, BLANK
Quantity: 1.00

Item	Qty	Arpac Part	Description
1	1.00	291894	BLK, CLAMP
2	1.00	291893	POST, SUPPORT, BLANK
3	1.00	291895	PLT, CLAMP
4	1.00	807154	HDL, ADJ, ZINC, 2-1/2 LG 5/16-18 X .78 STUD
5	1.00	808260	PIN, DOWEL, 5/32 DIA X 1 LG,
6	1.00	807151-001	INSERT, HELICAL, 5/16-18 X 0.469LG, SS FREE RUNNING



8	2	800395	BUSH, OILITE, FLG, 0.6265 X 0.7525 X 5/8 1 OD X 3/32 THK FLG
7	1	227059	SHAFT
6	1	227058	SPACER
5	1	227057	PLT, SUPPORT
4	1	227056	PLT, MTG, COUNTER
3	2	806983	COLLAR, SHAFT, CLAMP, 1-PIECE, 5/8
2	1	822769	COUNTER, POSITION, 0.625 BORE
1	1	227066	SPKT, 40B21, MOD, 0.625 BORE
ITM	QTY	PART NUM	DESCRIPTION

BILL OF MATERIALS			
ARPAC		9511 WEST RIVER ST. SCHILLER PARK, IL 60176	
UNLESS OTHERWISE SPECIFIED		FRACTIONS ± 1/64	
ALL DIMENSIONAL TOLERANCES:		TWO (2) DECIMALS ± 0.010	
		THREE (3) DECIMALS ± 0.005	
		ANGLES ± 0.5°	
DRAWN:	6/14/2004	BY:	HHG
RELEASED:	6/14/2004	FILENAME:	227062
DESCRIPTION:		SCALE:	0.375:1
		APPROVED BY:	HHG
		ASSY, COUNTER	
		DRAWING NUMBER:	
		227062	

Arpac BOM

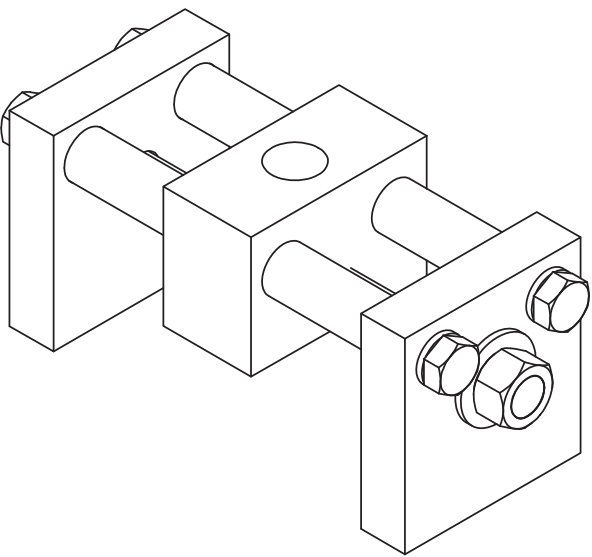
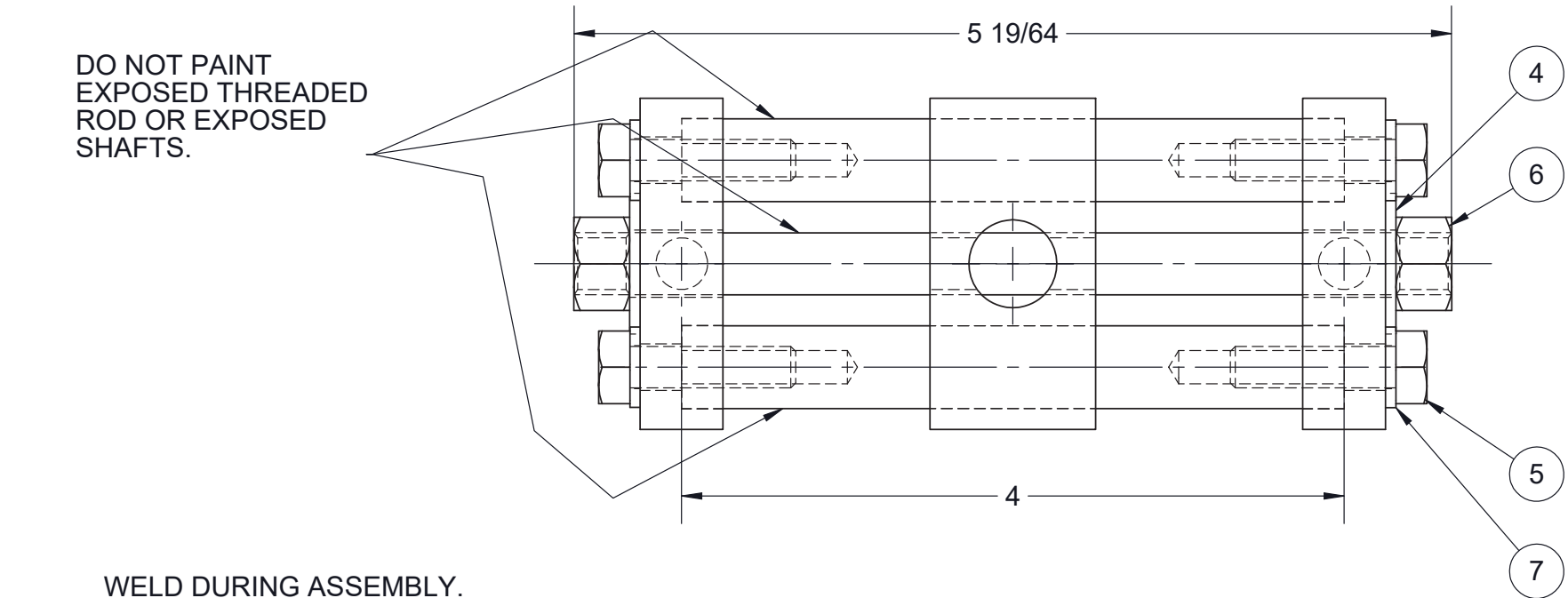
Parent Number: 15269 Parent Revision: B
Description: ASSY, FINAL, MACH, EL-2100, LH
Model: EL-2121

Assembly Part Number: 227062
Assembly Drawing Number: 227062
Description: ASSY, COUNTER
Quantity: 1.00

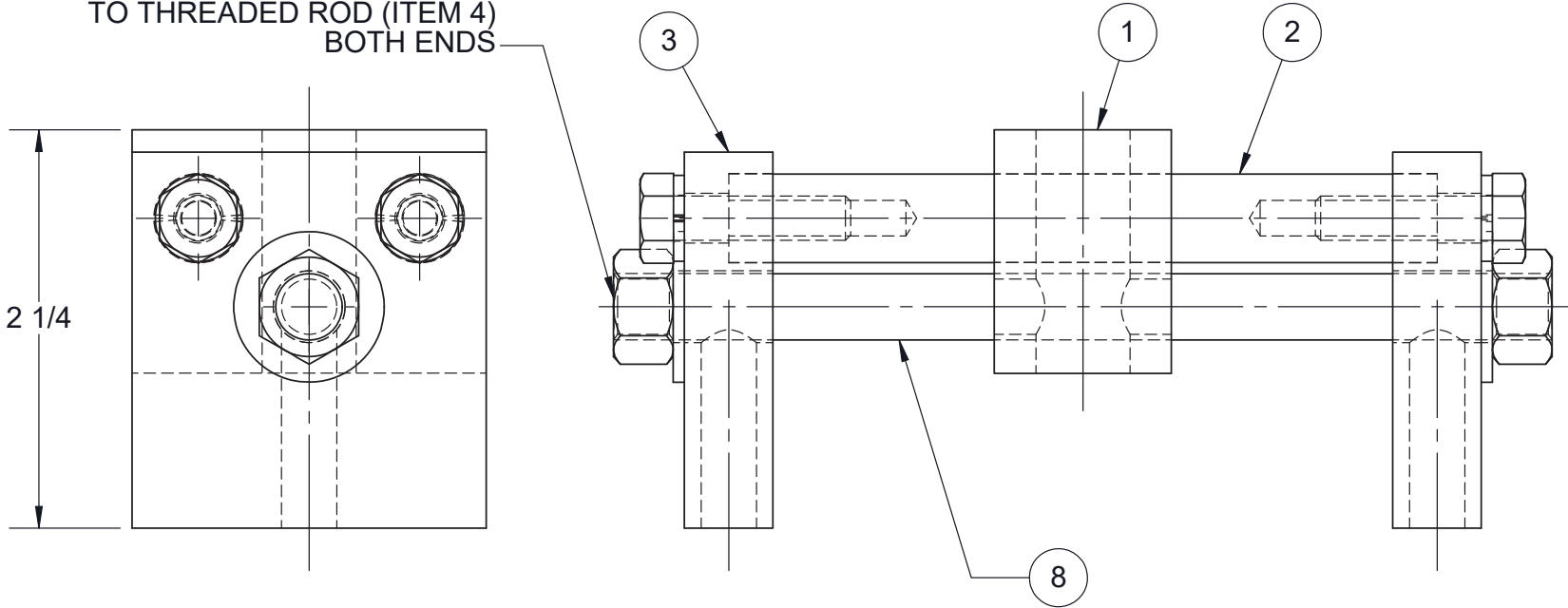
Item	Qty	Arpac Part	Description
1	1.00	227066	SPKT, 40B21, MOD, 0.625 BORE
2	1.00	822769	COUNTER, POSITION, 0.625 BORE
3	2.00	806983	COLLAR, SHAFT, CLAMP, 1-PIECE, 5/8, SS
4	1.00	227056	PLT, MTG, COUNTER
5	1.00	227057	PLT, SUPPORT
6	1.00	227058	SPACER
7	1.00	227059	SHAFT, COUNTER
8	2.00	800395	BUSH, OILITE, FLG, 0.6265 X 0.7525 X 5/8 1 OD X 3/32 THK FLG

REVISIONS			
RV	DATE	BY	DESCRIPTION
A	6/27/2017	JW	UPDATED NOTE. PER DCR #18243 AND #18137
B	10/5/2017	SRA	UPDATED BOM

DO NOT PAINT
EXPOSED THREADED
ROD OR EXPOSED
SHAFTS.



WELD DURING ASSEMBLY.
PLUG WELD NUT (ITEM 6)
TO THREADED ROD (ITEM 4)
BOTH ENDS



8	1	300814	THD RD 3/8-16, SLIDE, TAKE-UP, CHAIN, 2.250
7	4	800292-005	FSNR, WASHER, LOCK, SPLIT, 1/4,
6	2	800290-017	FSNR, NUT, HEX, 3/8-16,
5	4	800278-008	FSNR, HHCS, 1/4-20 X 1,
4	2	800275-014	FSNR, WASHER, FLAT, 3/8, SAE
3	2	101966	PLT, SIDE, TAKE-UP, CHAIN, 2.250
2	2	101798	SHAFT, TAKE-UP, CHAIN
1	1	101797	PLT, SLIDING, TAKE-UP, CHAIN
ITM	QTY	PART NUM	DESCRIPTION

BILL OF MATERIALS

ARPAC		9511 WEST RIVER ST. SCHILLER PARK, IL 60176	
UNLESS OTHERWISE SPECIFIED		FRACTIONS	± 1/64
ALL DIMENSIONAL TOLERANCES:		TWO (2) DECIMALS	± 0.010
		THREE (3) DECIMALS	± 0.005
		ANGLES	± 0.5°
DRAWN:	12/16/1997	BY:	JPC
RELEASED:	12/16/1997	SCALE:	0.75:1
DESCRIPTION:		APPROVED BY:	JPC
		ASSY, SLIDE, TAKE-UP, CHAIN, 2.250, STD	
		DRAWING NUMBER:	
		101965	

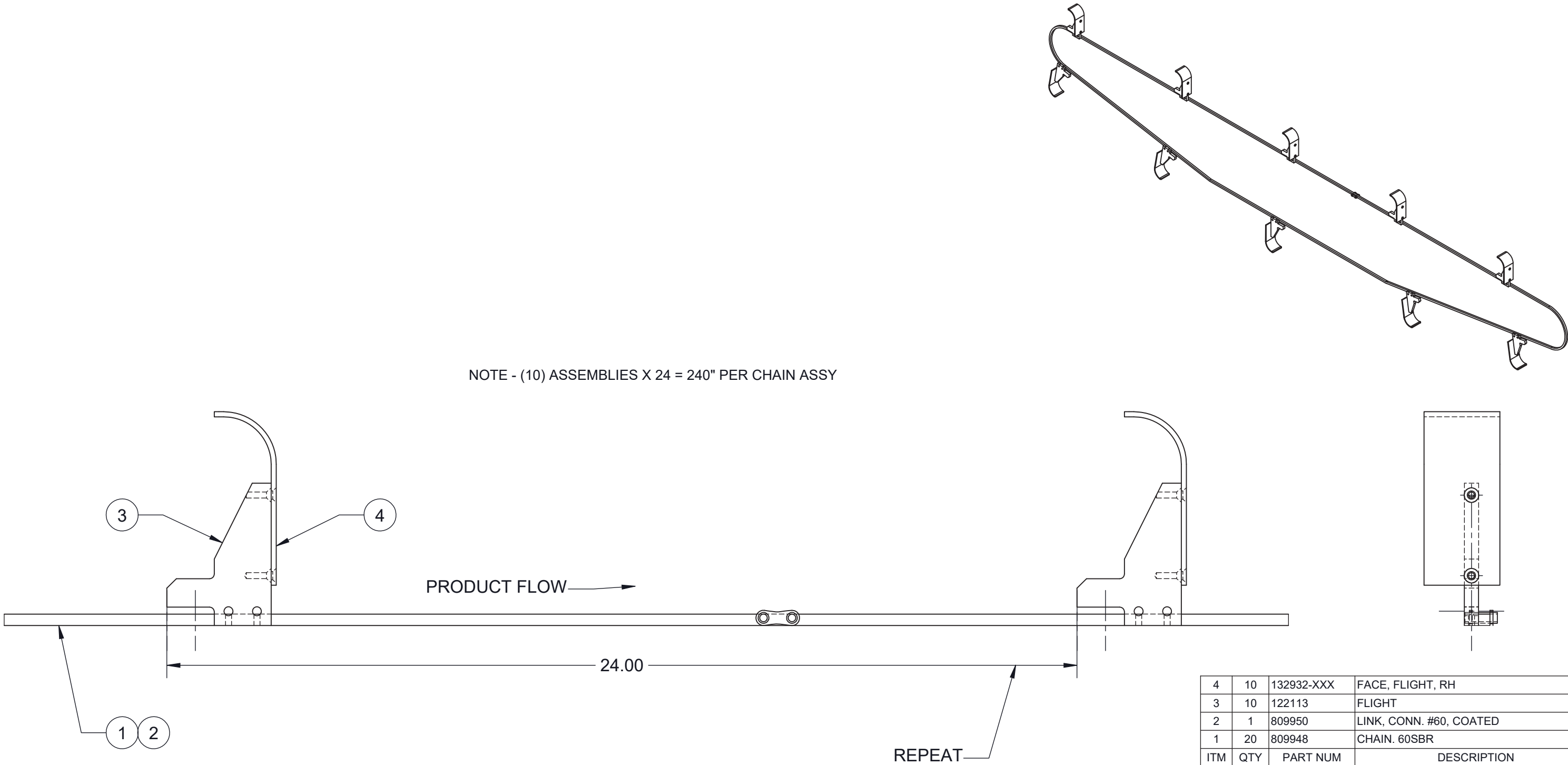
Arpac BOM

Parent Number: 15269 Parent Revision: B
Description: ASSY, FINAL, MACH, EL-2100, LH
Model: EL-2121

Assembly Part Number: 101965
Assembly Drawing Number: 101965
Description: ASSY, SLIDE, TAKE-UP, CHAIN, 2.250, STD,
Quantity: 1.00

Item	Qty	Arpac Part	Description
1	1.00	101797	PLT, SLIDING, TAKE-UP, CHAIN,
2	1.00	101797	PLT, SLIDING, TAKE-UP, CHAIN,
3	2.00	101966	PLT, SIDE, TAKE-UP, CHAIN, 2.250,
4	5.59	900763	CRS THD ROD 3/8-16, RH, ZINC PLATED, B7
5	4.00	800278-008	FSNR, HHCS, 1/4-20 X 1,
6	2.00	800290-017	FSNR, NUT, HEX, 3/8-16,
7	4.00	800292-005	FSNR, WASHER, LOCK, SPLIT, 1/4,
8	4.00	800292-005	FSNR, WASHER, LOCK, SPLIT, 1/4,
9	4.75	900009	CRS FLAT 1/2 X 2, 1018
10	1.50	900554	CRS FLAT 1 X 2, 1018
12	1.00	300814	ROD, THREAD, 3/8-16
13	22.00	900763	CRS THD ROD 3/8-16, RH, ZINC PLATED, B7
14	1.00	300814	ROD, THREAD, 3/8-16

NOTE - (10) ASSEMBLIES X 24 = 240" PER CHAIN ASSY



4	10	132932-XXX	FACE, FLIGHT, RH
3	10	122113	FLIGHT
2	1	809950	LINK, CONN. #60, COATED
1	20	809948	CHAIN. 60SBR
ITM	QTY	PART NUM	DESCRIPTION

BILL OF MATERIALS

ARPAC		9511 WEST RIVER ST. SCHILLER PARK, IL 60176	
UNLESS OTHERWISE SPECIFIED: ALL DIMENSIONAL TOLERANCES:		FRACTIONS TWO (2) DECIMALS THREE (3) DECIMALS ANGLES	± 1/64 ± 0.010 ± 0.005 ± 0.5°
DRAWN: 12/16/2004	BY: HHG	SCALE: 0.375:1	SIZE: B
RELEASED:	FILENAME: 230434	APPROVED BY: HHG	
DESCRIPTION: ASSY, FLIGHT, TRAILING			
			DRAWING NUMBER: 230434

PART NUMBER	DESCRIPTION
230434-001	RH, AS SHOWN
230434-002	LH, OPPOSITE

Arpac BOM

Parent Number: 15269 Parent Revision: B

Description: ASSY, FINAL, MACH, EL-2100, LH

Model: EL-2121

Assembly Part Number: 230434-001

Assembly Drawing Number: 230434

Description: ASSY, FLIGHT, TRAILING, RH

Quantity: 1.00

Item	Qty	Arpac Part	Description
1	20.00	809948	CHAIN, 60SBR NEO PERFEC, W/ D-3 @ 2 & 4 P ON A 32 PITCH REPEAT
2	1.00	809950	LINK, CONN, #60, NEO PERFECT COAT
3	10.00	122113	FLIGHT
4	10.00	132932-001	FACE FLIGHT, RH,
5	220.00	903576	SS SHEET 10GA, 304, #4 FINISH LASER VINYL
6	75.00	900077	AL FLAT 3/8 X 3, 6061-T6511
7	140.00	PLATING	PLATING FOR PARTS

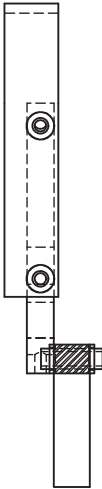
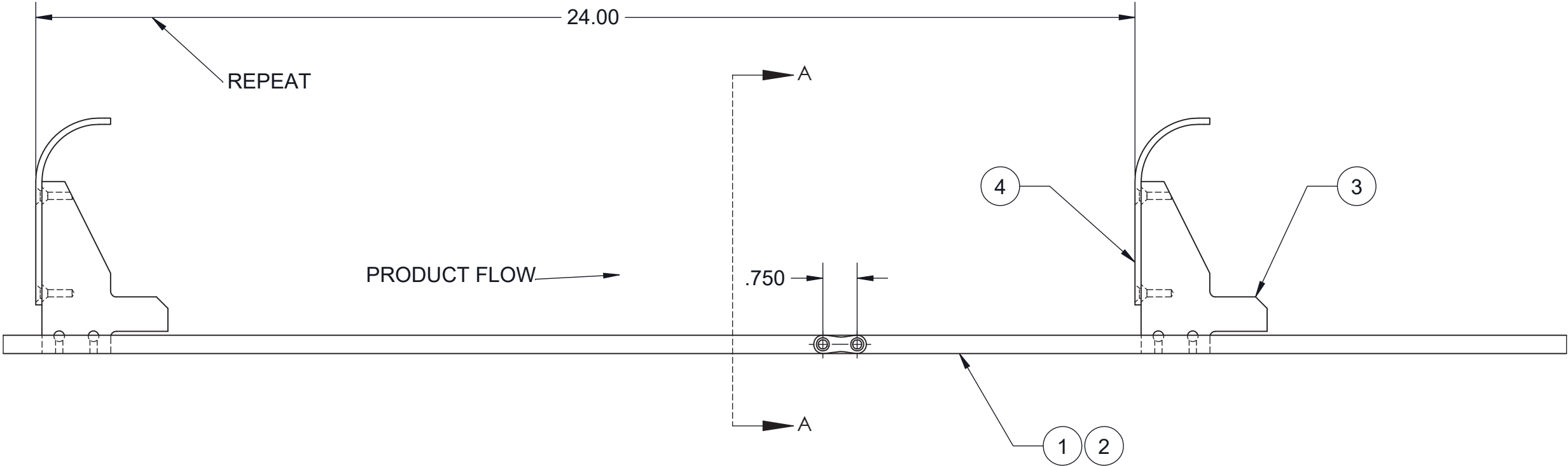
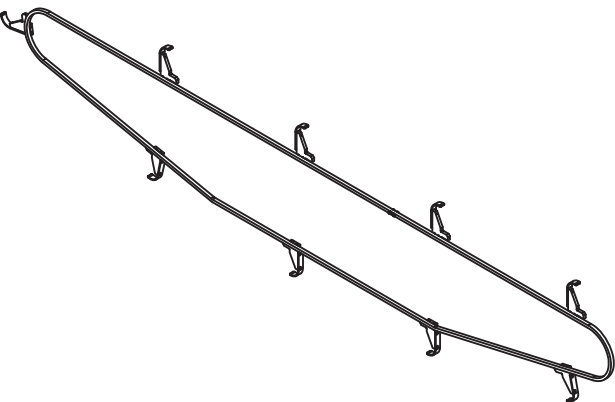
Arpac BOM

Parent Number: 15269 Parent Revision: B
Description: ASSY, FINAL, MACH, EL-2100, LH
Model: EL-2121

Assembly Part Number: 230434-002
Assembly Drawing Number: 230434
Description: ASSY, FLIGHT, TRAILING, LH
Quantity: 1.00

Item	Qty	Arpac Part	Description
1	20.00	809948	CHAIN, 60SBR NEO PERFEC, W/ D-3 @ 2 & 4 P ON A 32 PITCH REPEAT
2	1.00	809950	LINK, CONN, #60, NEO PERFECT COAT
3	10.00	122113	FLIGHT
4	10.00	132932-002	FACE FLIGHT, LH,
5	9.50	903576	SS SHEET 10GA, 304, #4 FINISH LASER VINYL
6	75.00	900077	AL FLAT 3/8 X 3, 6061-T6511
7	140.00	PLATING	PLATING FOR PARTS

(9) ASSEMBLIES X 24 = 216" PER CHAIN ASSY



SECTION A-A

PART NUMBER	DESCRIPTION
141291-001	RH, AS SHOWN
141291-002	LH, OPPOSITE

4	9	132931-001	FACE, FLIGHT, RH
3	9	122113	FLIGHT
2	1	809950	LINK, CONN. #60, COATED
1	18	809948	CHAIN, 60SBR
ITM	QTY	PART NUM	DESCRIPTION

BILL OF MATERIALS

ARPAC		9511 WEST RIVER ST. SCHILLER PARK, IL 60176	
UNLESS OTHERWISE SPECIFIED: ALL DIMENSIONAL TOLERANCES:		FRACTIONS TWO (2) DECIMALS THREE (3) DECIMALS ANGLES	± 1/64 ± 0.010 ± 0.005 ± 0.5°
DRAWN: 03/20/2001	BY: TTR	SCALE: 0.375:1	SIZE: B
RELEASED: 03/20/2001	FILENAME: 141291	APPROVED BY: TTR	
DESCRIPTION: ASSY, FLIGHT, LEADING			
			DRAWING NUMBER: 141291

Arpac BOM

Parent Number: 15269 Parent Revision: B

Description: ASSY, FINAL, MACH, EL-2100, LH

Model: EL-2121

Assembly Part Number: 141291-002

Assembly Drawing Number: 141291

Description: ASSY, FLIGHT, LEADING, LH

Quantity: 1.00

Item	Qty	Arpac Part	Description
1	18.00	809948	CHAIN, 60SBR NEO PERFEC, W/ D-3 @ 2 & 4 P ON A 32 PITCH REPEAT
2	1.00	809950	LINK, CONN, #60, NEO PERFECT COAT
3	9.00	122113	FLIGHT
4	9.00	132931-002	FACE FLIGHT, LH
5	220.00	903576	SS SHEET 10GA, 304, #4 FINISH LASER VINYL
6	67.50	900077	AL FLAT 3/8 X 3, 6061-T6511
7	140.00	PLATING	PLATING FOR PARTS

Arpac BOM

Parent Number: 15269 Parent Revision: B

Description: ASSY, FINAL, MACH, EL-2100, LH

Model: EL-2121

Assembly Part Number: 141291-001

Assembly Drawing Number: 141291

Description: ASSY, FLIGHT, LEADING, RH

Quantity: 1.00

Item	Qty	Arpac Part	Description
1	18.00	809948	CHAIN, 60SBR NEO PERFEC, W/ D-3 @ 2 & 4 P ON A 32 PITCH REPEAT
2	1.00	809950	LINK, CONN, #60, NEO PERFECT COAT
3	9.00	122113	FLIGHT
4	9.00	132931-001	FACE FLIGHT, RH
5	220.00	903576	SS SHEET 10GA, 304, #4 FINISH LASER VINYL
6	67.50	900077	AL FLAT 3/8 X 3, 6061-T6511
7	140.00	PLATING	PLATING FOR PARTS

D

C

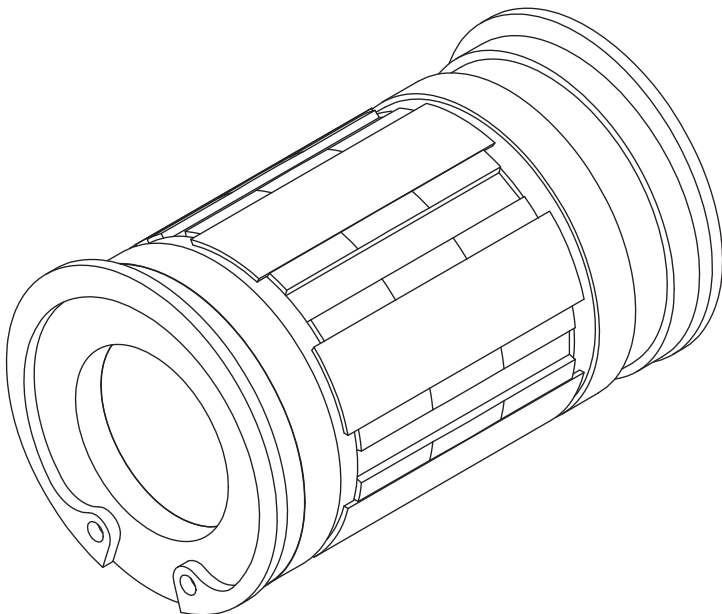
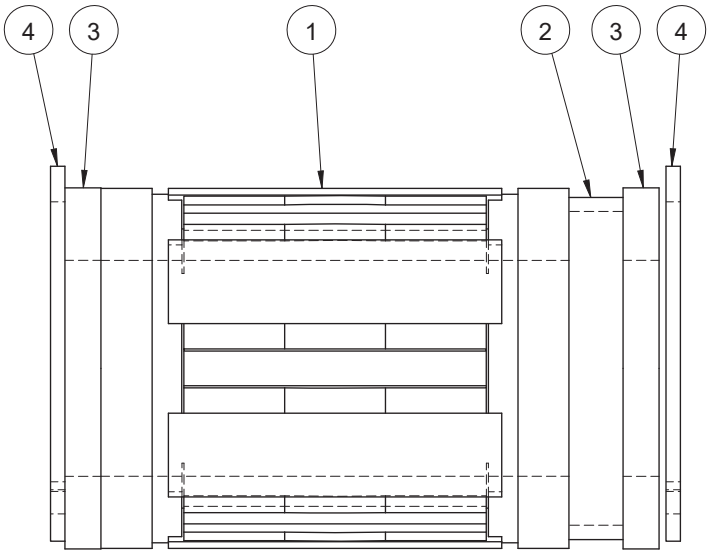
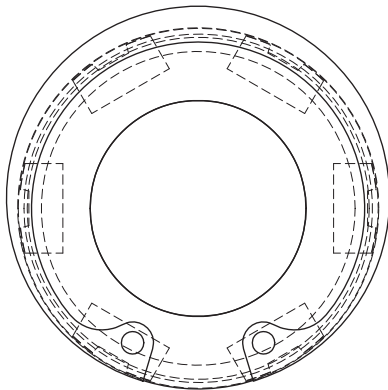
B

A

ARPAC B SIZE FORMAT R5

BILL OF MATERIALS			
ITEM	QTY	NUMBER	DESCRIPTION
1	1	823378	BUSH, BALL, 3/4 X 1-1/4 X 1-5/8 LG SUPER BALL
2	1	101169	SPACER, BUSH, 3/4" SHAFT, 4' LG BLK
3	2	802925	RING, SEAL, 3/4 X 1.254 X 0.125 THK
4	2	800335-019	RING, SNAP, INTERNAL, 1-1/4 BORE

NOTE: ITEM 5 NOT SHOWN



REV	DATE	BY	NOTE
REVISIONS			
SIZE	SCALE	MATERIAL	DESCRIPTION
B	3:2	SEE BILL OF MATERIALS	ASSY, BUSH, BRG, .75 SHAFT, SINGLE SUPER BALL BUSHING
3RD ANGLE	UNITS	FINISH	NUMBER
	INCH	NONE	226217
TOLERANCES			
X/X: ±1/32			
X.XX: ±.015			
X.XXX: ±.005			
ANGLES: ±1°			

NOTES • INTERPRET PER ASME Y14.5M-1994. • DIMENSIONS ARE IN INCHES [mm]. • DIMENSIONS IN PARENTHESES FOR REFERENCE ONLY. • BREAK SHARP EDGES AND CORNERS. • PROPRIETARY NOTICE: THIS INFORMATION IS THE PROPERTY OF ARPAC LLC AND SHALL NOT BE USED FOR ANY PURPOSE OTHER THAN THAT FOR WHICH IT WAS OBTAINED. • CREATED IN SOLIDWORKS 2013.	CREATED IN SOLIDWORKS 2013		 9555 W. Irving Park Rd Schiller Park, IL 60176 www.arpac.com
	MODEL	FILE \ CONFIG SIMILAR TO DATE CREATED DATE UPDATED UPDATED BY	226217\Default
			Friday, May 2, 2014 2:27:31 PM Thursday, October 5, 2017 11:15:10 AM sarcher
	DRAFT	DATE CREATED DATE UPDATED UPDATED BY	Thursday, October 5, 2017 11:07:05 AM Thursday, October 5, 2017 11:17:12 AM sarcher

D

C

B

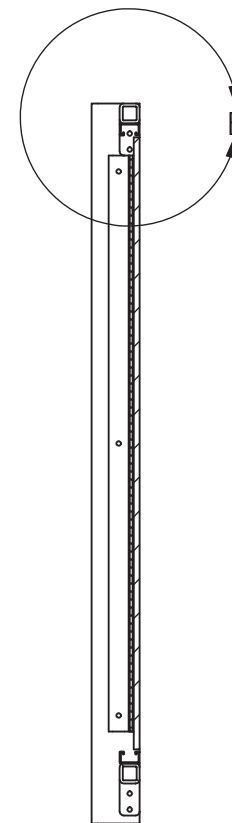
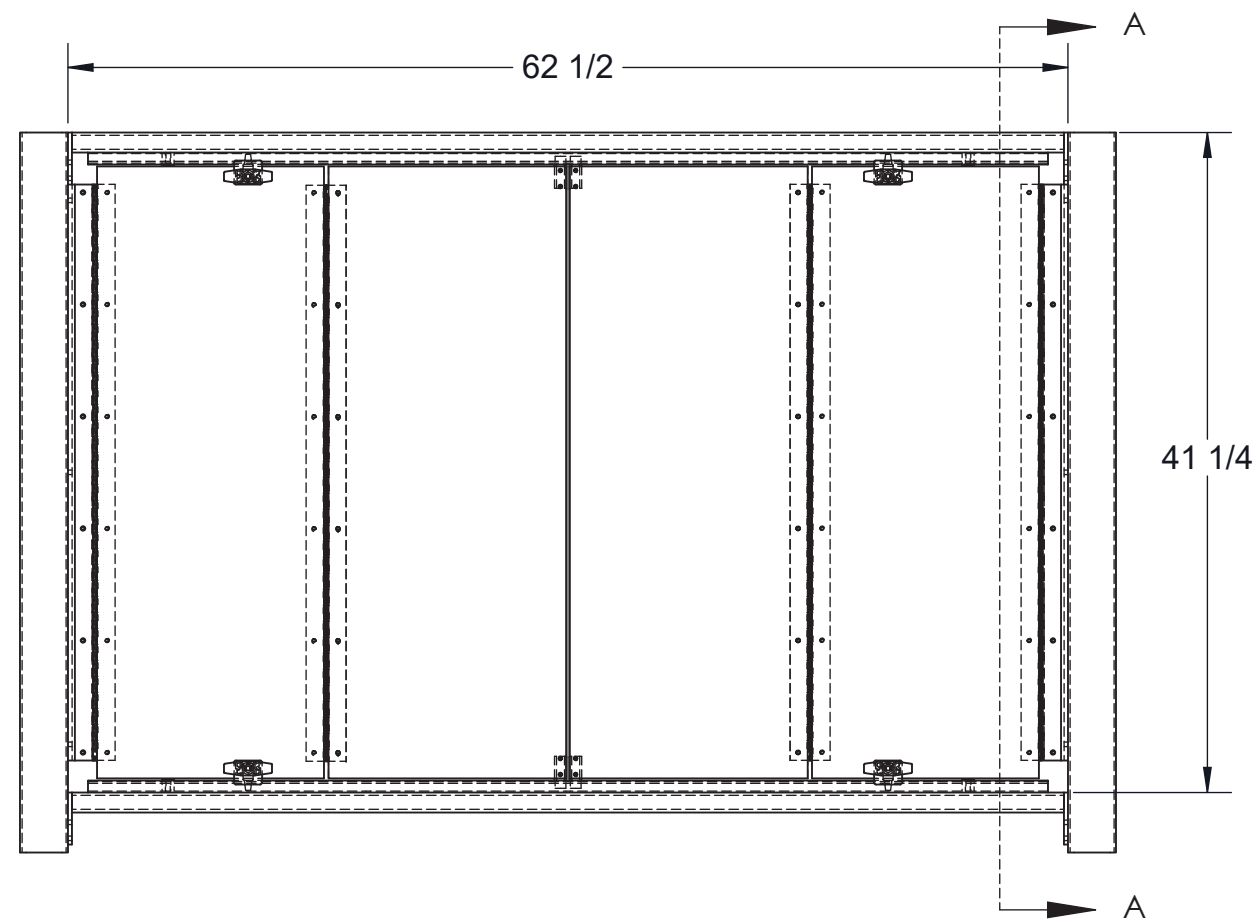
A

Arpac BOM

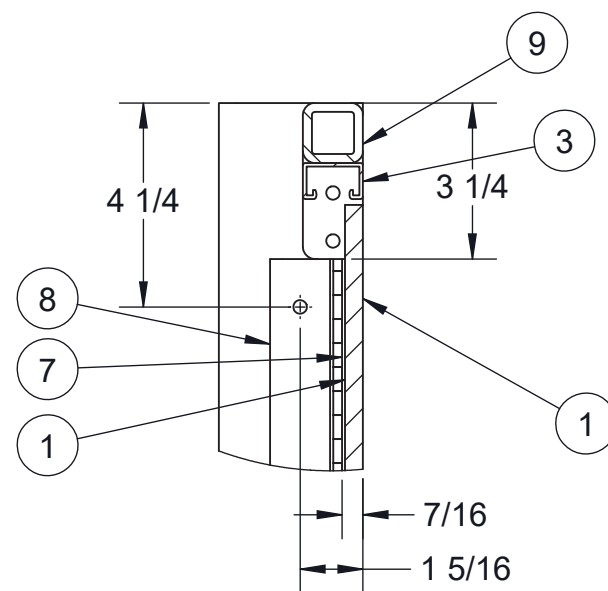
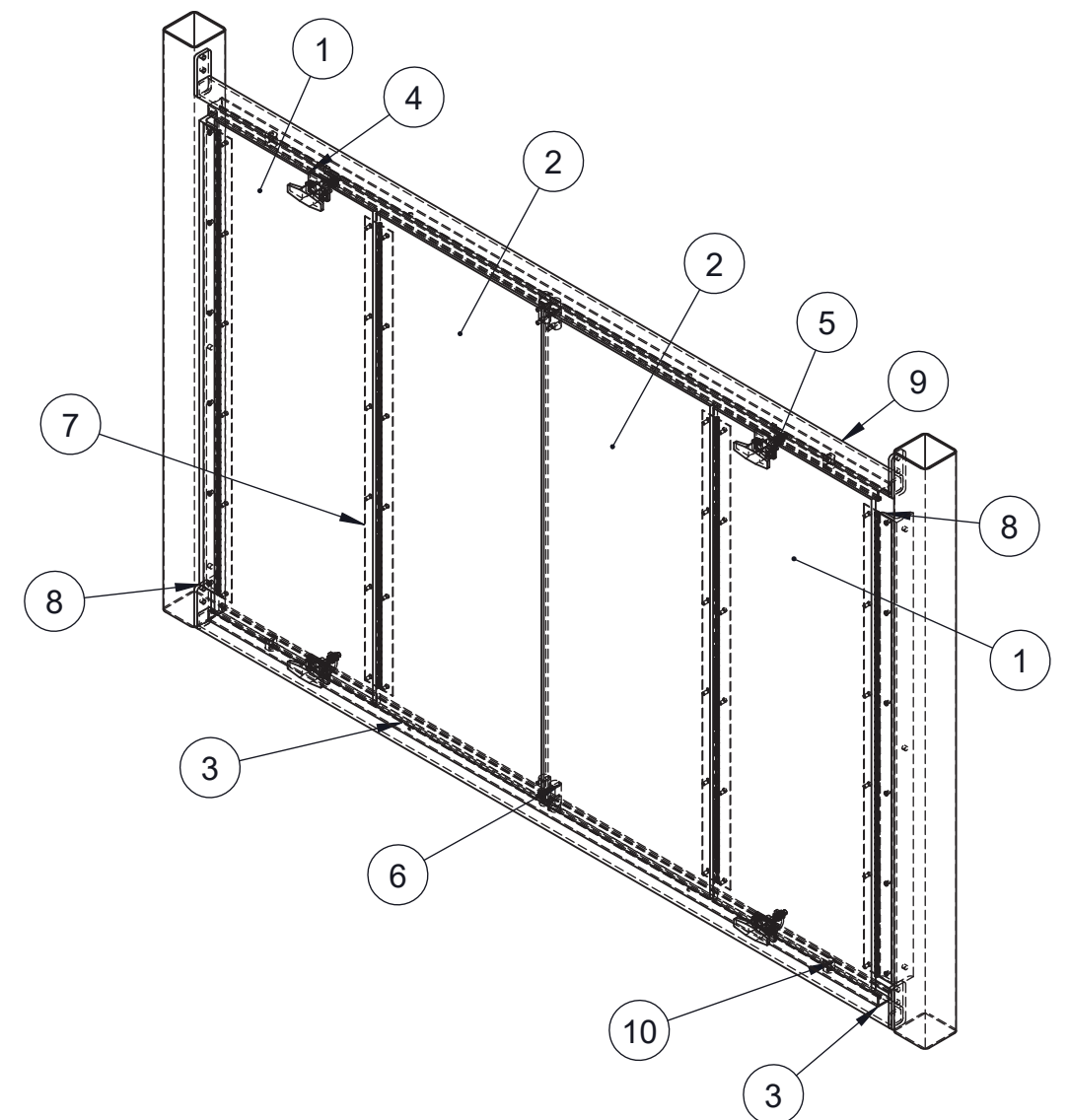
Parent Number: 15269 Parent Revision: B
Description: ASSY, FINAL, MACH, EL-2100, LH
Model: EL-2121

Assembly Part Number: 226217-000A
Assembly Drawing Number: 226217
Description: ASSY, BUSH, BRG, .75 SHAFT, SINGLE SUPER BALL BUSHING
Quantity: 1.00

Item	Qty	Arpac Part	Description
1	1.00	823378	DUPLICATE PART USE 802722***BUSH, BALL, 3/4 X 1-1/4 X 1-5/8 LG SUPER BALL
2	1.00	101169	SPACER, BUSH, 3/4 SHAFT, 4.000 LG BLK,
3	2.00	802925	RING, SEAL, 3/4 X 1.254 X 0.125 THK,
4	2.00	800335-019	RING, SNAP, INTERNAL, 1-1/4 BORE,
5	1.00	802208	FTG, GREASE, 1/8 NPT, STRAIGHT, ZINC PL



SECTION A-A



DETAIL B
SCALE 1 : 4

10	4	101751	STOP, DR, BIFOLD
9	2	311578	WLDMNT, MTG, BI-FOLD DOOR
8	2	311582	ANGLE, MTG, GUARD, PANEL, FOLDING
7	4	311581	HINGE, DOOR, GUARD
6	4	292839	PIN, GUIDE
5	4	802653	LATCH, VISE-ACTION
4	4	292841	SPACER, LATCH
3	2	311584	CHANNEL, DOOR
2	2	311580	PANEL, FOLLOWING, DOOR, BI-FOLD
1	2	311583	PANEL, LEADING, DOOR, BI-FOLD
ITM	QTY	PART NUM	DESCRIPTION

BILL OF MATERIALS

ARPAC

9511 WEST RIVER ST.
SCHILLER PARK, IL 60176

UNLESS OTHERWISE SPECIFIED
ALL DIMENSIONAL TOLERANCES:

FRACTIONS
TWO (2) DECIMALS ± 1/64
THREE (3) DECIMALS ± 0.010
ANGLES ± 0.005
± 0.5°

DRAWN: 2/13/13

BY: HG

SCALE: 1:12

SIZE: B

FILENAME: 311585

DESCRIPTION:

ASSY, DOOR, BI-FOLD



DRAWING NUMBER:

311585

Arpac BOM

Parent Number: 15269 Parent Revision: B

Description: ASSY, FINAL, MACH, EL-2100, LH

Model: EL-2121

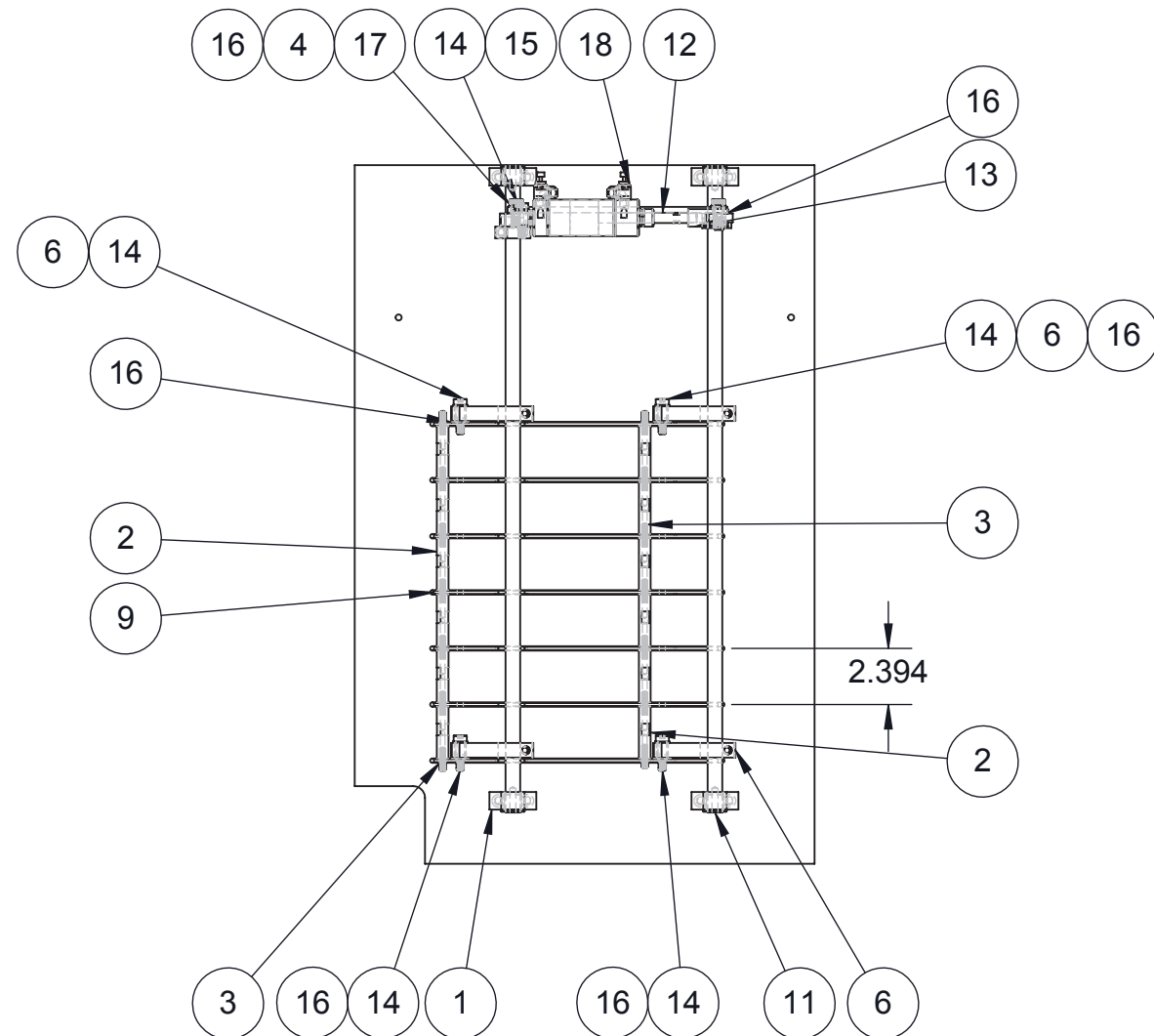
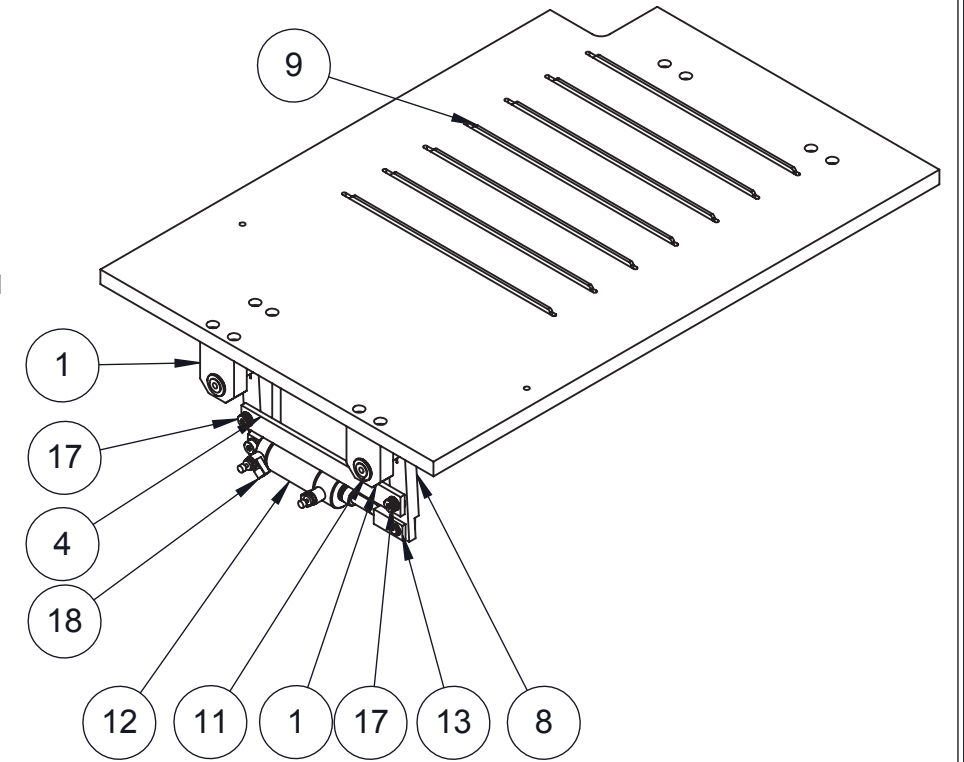
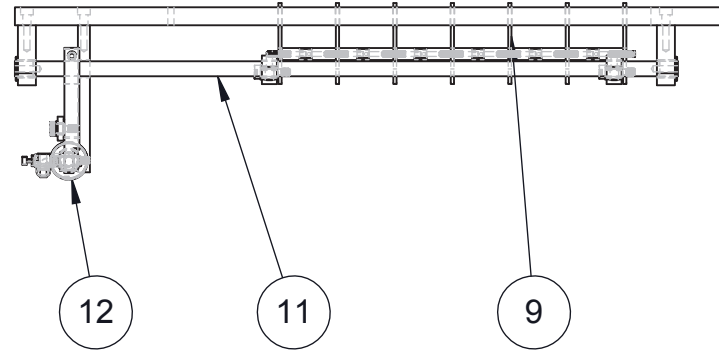
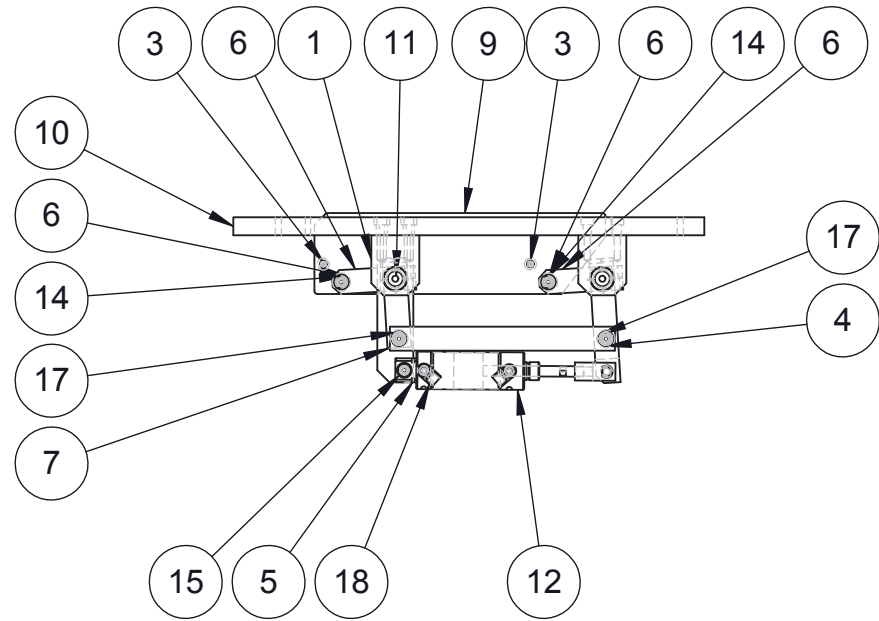
Assembly Part Number: 311585

Assembly Drawing Number: 311585

Description: ASSY, DOOR, BI-FOLD

Quantity: 1.00

Item	Qty	Arpac Part	Description
1	2.00	311583	PANEL, LEADING, DOOR, BI-
2	2.00	311580	PANEL, FOLLOWING, DOOR, BI-
3	2.00	311584	CHANNEL, DOOR
4	4.00	292841	SPACER, LATCH
5	4.00	802653	LATCH, VISE-ACTION
6	4.00	292839	PIN, GUIDE
7	4.00	311581	HINGE, DOOR, GUARD
8	2.00	311582	ANGLE, MTG, BI-FOLD DOOR
9	2.00	311578	WLDMNT, MTG, BI-FOLD DOOR
10	4.00	101751	STOP, DOOR, BIFOLD,



18	2	800090	VALVE, CONTROL, FLOW, 1/8" 90DEG
17	2	800323-001	FSNR, BOLT, SHLDR, 3/8 DIA X 3/8 LG, 5/16-18 THD
16	6	800444	WSHR, OILITE, 0.390 X .750 X 1/32 THK
15	2	808142	WSHR, OILITE, 0.385 X 0.625 X 1/16 THK
14	5	800323-006	FSNR, BOLT, SHLDR, 3/8 DIA X 3/4 LG,
13	1	816090	CLEVIS, ROD, CYLINDER, 7/16-20
12	1	816087	CYL, AIR, 1 1/2 BORE, 1.5" STROKE REAR PIVOT, 3/8 BUSH, DOUBLE CUSHION
11	2	189987-002	SHAFT, PIVOT
10	1	364272	PLT, DEAD, POP-UP, LH, 2.09 DIA
9	7	215217	GUIDE, POP-UP
8	1	189983-001	CLAMP, LINK, DRIVE
7	1	189982	BAR, TIE, CLAMP
6	4	189981	CLAMP, PIVOT
5	1	189980	MNT, REAR, CYL
4	1	189979	BAR, TIE
3	14	800342-011	FSNR, SCREW, SET, 1/4-20 X 1, SS
2	12	197925-096	SPACER, LANE, POP-UP, L=2.280
1	4	186781	PIVOT, SIDE
ITM	QTY	PART NUM	DESCRIPTION

BILL OF MATERIALS

ARPAC

9511 WEST RIVER ST.
SCHILLER PARK, IL 60176

UNLESS OTHERWISE SPECIFIED
ALL DIMENSIONAL TOLERANCES:

FRACTIONS ± 1/64
TWO (2) DECIMALS ± 0.010
THREE (3) DECIMALS ± 0.005
ANGLES ± 0.5°

DRAWN: 3/26/2019

BY: JW

SCALE: 1:8

SIZE: B

FILENAME: 364277

DESCRIPTION:

ASSY, GUIDE, POP-UP, 6-LANE, LH, 2.09 DIA PROD

DRAWING NUMBER:

364277

Arpac BOM

Parent Number: 15269 Parent Revision: B
Description: ASSY, FINAL, MACH, EL-2100, LH
Model: EL-2121

Assembly Part Number: 364277
Assembly Drawing Number: 364277
Description: ASSY, GUIDE, POP-UP, 6-LANE, LH, 2.09 DIA PROD
Quantity: 1.00

Item	Qty	Arpac Part	Description
1	4.00	186781	PIVOT, SIDE
2	12.00	197925-096	SPACER, LANE, POP-UP, L=2.260
3	14.00	800342-011	FSNR, SCREW, SET, 1/4-20 X 1, SS
4	1.00	189979	BAR, TIE
5	1.00	189980	MNT, REAR, CYL
6	4.00	189981	CLAMP, PIVOT
7	1.00	189982	BAR, TIE, CLAMP
8	1.00	189983-001	CLAMP, LINK, DRIVE STD, RH MACH,
9	7.00	215217	GUIDE, POPUP, SS
10	1.00	364272	PLT, GUIDE, POP-UP, 6-LANE, LH, 2.09 DIA PROD
11	2.00	189987-002	SHAFT, PIVOT, 0.625 DIA, 5/16-18 TAPPED, BOTH ENDS, 27.625 LG
12	1.00	816087	CYL, AIR, 1 1/2 BORE, 1.5" STROKE REAR PIVOT, 3/8 BUSH, DOUBLE CUSHION
13	1.00	816090	CLEVIS, ROD, CYLINDER, 7/16-20
14	5.00	800323-006	FSNR, BOLT, SHLDR, 3/8 DIA X 3/4 LG,
15	2.00	808142	WSHR, OILITE, 0.385 X 0.625 X 1/16 THK
16	6.00	800444	WSHR, OILITE, 0.390 X 0.750 X 1/32 THK
17	2.00	800323-001	FSNR, BOLT, SHLDR, 3/8 DIA X 3/8 LG, 5/16-18 THD
18	2.00	800090	VALVE, CONTROL, FLOW, 1/8" 90DEG

REV	DATE	BY	NOTE
REVISIONS			
SIZE B	SCALE 3:4	MATERIAL SEE BILL OF MATERIALS	DESCRIPTION ASSY, CLAMP, STOP, PRODUCT, 2 X 5-1/2
3RD ANGLE 	UNITS INCH		
TOLERANCES X/X: ±1/32 X.XX: ±.015 X.XXX: ±.005 ANGLES: ±1°		FINISH NONE	NUMBER 364283

NOTES • INTERPRET PER ASME Y14.5M-1994. • DIMENSIONS ARE IN INCHES [mm]. • DIMENSIONS IN PARENTHESES FOR REFERENCE ONLY. • BREAK SHARP EDGES AND CORNERS. • PROPRIETARY NOTICE: THIS INFORMATION IS THE PROPERTY OF ARPAC LLC AND SHALL NOT BE USED FOR ANY PURPOSE OTHER THAN THAT FOR WHICH IT WAS OBTAINED. • CREATED IN SOLIDWORKS 2018.	CREATED IN SOLIDWORKS 2018		 9555 W. Irving Park Rd. Schiller Park, IL 60176 www.arpac.com
	MODEL	FILE \ CONFIG SIMILAR TO DATE CREATED DATE UPDATED DATE UPDATED BY	364283\Default Tuesday, May 1, 2012 3:03:45 PM Wednesday, March 27, 2019 2:16:21 PM sarcher
	DRAFT	DATE CREATED DATE UPDATED DATE UPDATED BY	Wednesday, March 27, 2019 2:18:50 PM Wednesday, March 27, 2019 2:33:49 PM sarcher

Arpac BOM

Parent Number: 15269 Parent Revision: B
Description: ASSY, FINAL, MACH, EL-2100, LH
Model: EL-2121

Assembly Part Number: 364283
Assembly Drawing Number: 364283
Description: ASSY, CLAMP, STOP, PRODUCT, 2 X 5-1/2
Quantity: 1.00

Item	Qty	Arpac Part	Description
1	1.00	364282	WLDMT, PLT, CLAMP, PRODUCT, 2 X 5-1/2
2	0.10	803375	RUBBER, SPONGE SILICONE SH 3/8 X 36 X 36 (SEE COMMENTS)

Arpac BOM

Parent Number: 15269 Parent Revision: B

Description: ASSY, FINAL, MACH, EL-2100, LH

Model: EL-2121