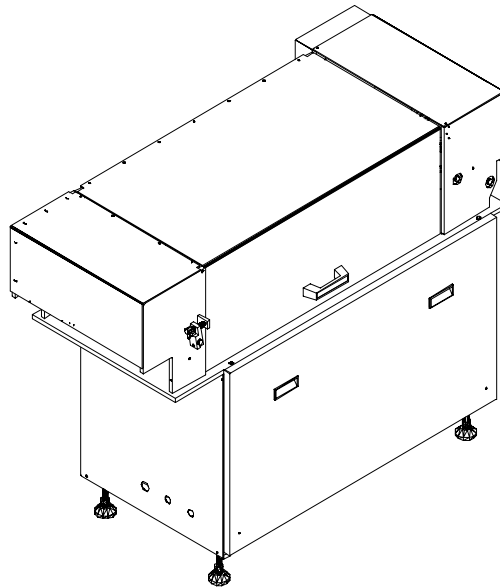


TURNOVER

10 X 13

Parts Manual



Pitney Bowes

SURE-FEED ENGINEERING

12050 49th STREET NORTH - CLEARWATER, FL. 33762-4301
PHONE: 727.571.3330 - FAX: 727.571.3443 - TOLL FREE: 1.800.INSERTER
web: sure-feed.com

TABLE OF CONTENTS

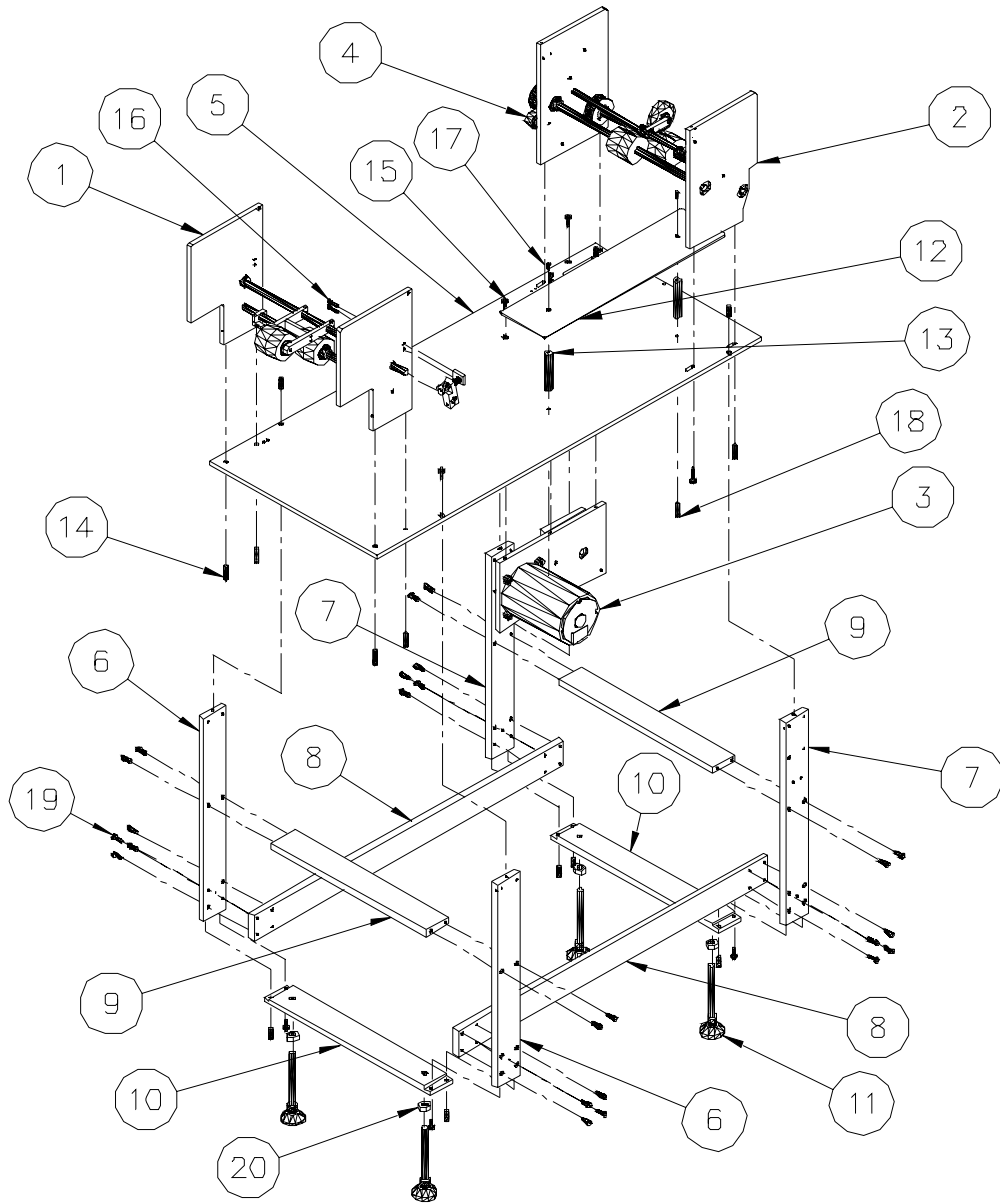
I. TURNOVER / FRAME ASSEMBLY (FIG. 5-1).....	4
A. INFEEED ASSEMBLY (FIG. 5-2).....	8
B. DISCHARGE ASSEMBLY (FIG 5-3).....	10
C. MOTOR ASSEMBLY (FIG. 5-4).....	12
D. DRIVE ASSEMBLY (FIG. 5-5).....	14
E. COVER ASSEMBLY (FIG. 5-6).....	16
1. CENTER COVER ASSEMBLY (FIG. 5-7).....	18
F. ELECTRICAL ASSEMBLY (FIG. 5-8).....	20

Sure-Feed
Engineering Inc

TURNOVER ASSEMBLY (Fig. 5-1)

ITEM	PART NO.	QTY.	DESCRIPTION
1	(SEE FIG. 5-2)	1	INFEED / SEPERATOR ADJUSTOR ASSEMBLY
2	(SEE FIG. 5-3)	1	DISCHARGE ASSEMBLY
3	(SEE FIG. 5-4)	1	MOTOR / MOTOR MOUNT ASSEMBLY
4	(SEE FIG. 5-5)	1	DRIVE ASSEMBLY
5	20001-001	1	PLATE, DECK
6	20010-002	2	LEG, INFEED, TURNOVER
7	20010-001	2	LEG, DISCHARGE, TURNOVER
8	20003-003	2	CROSSBAR, SIDE, TURNOVER
9	20003-005	2	CROSSBAR, UPPER, TURNOVER
10	20003-004	2	CROSSBAR, LOWER, TURNOVER
11	99010-001	4	FOOT, ADJUSTING
12	20011-003	1	PLATE, SKID
13	18012-013	2	STANDOFF, SKID PLATE
14		8	SCREW, SKT HD, 5/16-18 X 1-1/4
15		7	SCREW, SKT HD, 5/16-18 X 3/4
16		2	SCREW, SKT HD, 1/4-20 X 1
17		2	SCREW, FLAT HD, 10-24 X 1/2
18		2	SCREW, SKT HD, 10-24 X 3/4
19		32	SCREW, SKT HD, 5/16-18 X 1
20		4	NUT, HEX, 5/8-11
21	99000-038	1	BELT, TURNOVER, 91.645 (NOT SHOWN)
22	99000-039	1	BELT, TURNOVER, 111.601 (NOT SHOWN)
23	20005-001	1	GUIDE, ENVELOPE TWIST (NOT SHOWN)
24	(SEE FIG. 5-6)	1	TURNOVER COVER ASSEMBLY (NOT SHOWN)

FIG. 5-1



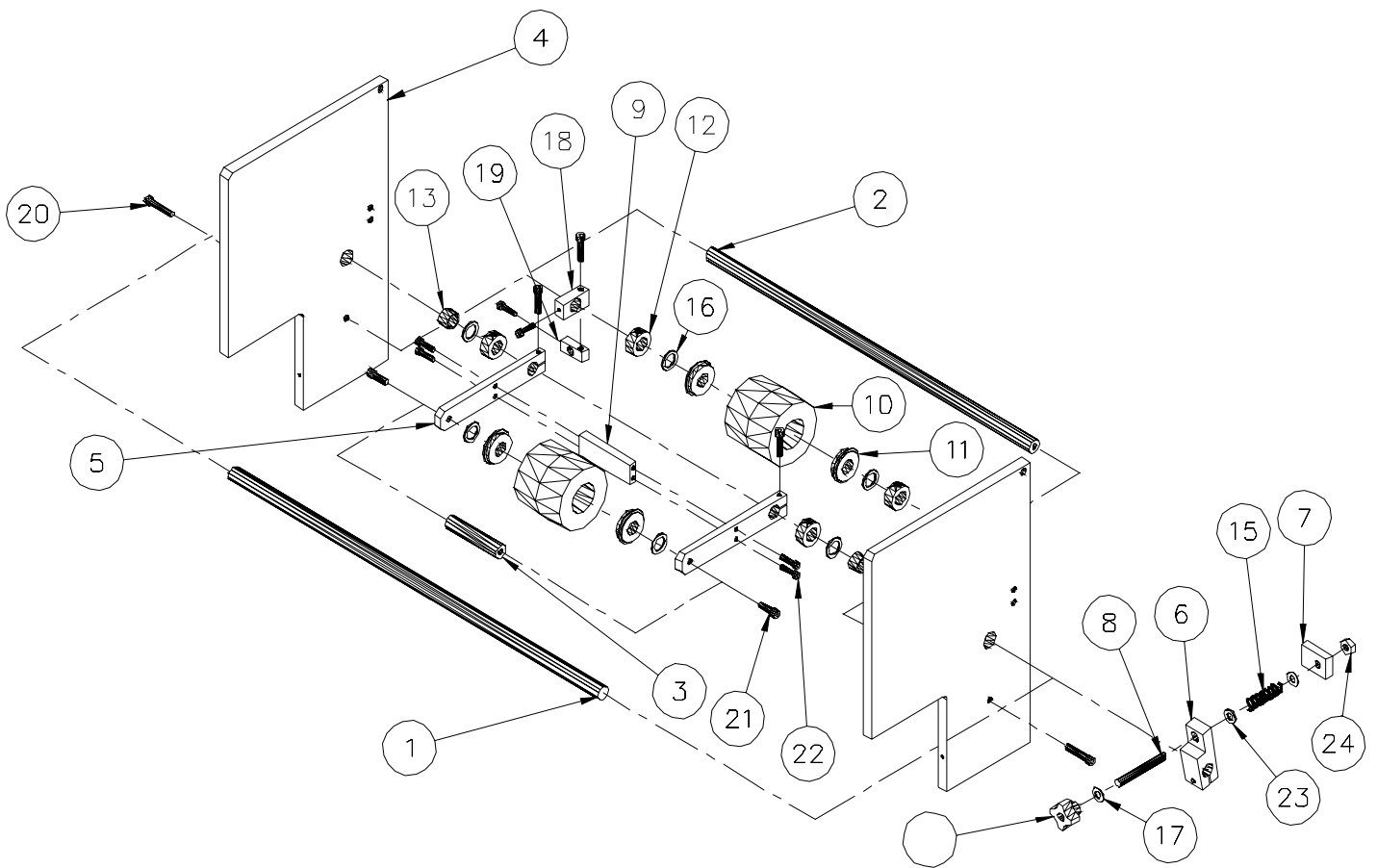
Sure-Feed
Engineering Inc

TURNOVER (Fig. 5-2)
INFEEED ASSEMBLY

ITEM	PART NO.	QTY.	DESCRIPTION
1	20004-010	1	SHAFT, IDLER PIVOT
2	20004-009	1	SHAFT, IDLER (LONG)
3	20004-001	1	SHAFT, IDLER (SHORT)
4	20000-004	2	SIDEPLATE, INFEEED
5	20008-001	2	BAR, IDLER ROLLER MTG.
6	20007-002	1	BLOCK, SHAFT CLAMP
7	20007-001	1	BLOCK, SHAFT ADJUSTING
8	10004-028	1	STUD, SEPERATOR ADJUSTING
9	20012-002	1	SPACER, IDLER ROLLER
10	20006-001	2	ROLLER, CROWNED (IDLER)
11	99003-006	4	BEARING, SEALED, 5/8 X 1-3/8
12	99017-005	4	COLLAR, SET, 5/8
13	99003-029	2	BUSHING, 5/8 X 3/4 X 1/2
14	99004-001	1	KNOB, FEMALE, 5/16-24
15	10019-001	1	SPRING, SEPERATOR (ROTATING)
16	99003-021	6	WASHER, NYLON, 5/8 X 1/16
17	99003-015	1	WASHER, NYLON, 5/16 X 1/16
18	20009-002	1	BRACKET, GUIDE MTG. (.625)
19	20009-004	1	BRACKET, GUIDE SUPPORT (.375)
20		5	SCREW, SKT HD, 1/4-20 X 1
21		2	SCREW, SKT HD, 1/4-20 X 3/4
22		6	SCREW, SKT HD, 10-24 X 3/4
23		2	WASHER, FLAT, 5/16
24		1	NUT, HEX HD, 5/16-24

Sure-Feed
Engineering Inc

FIG. 5-2

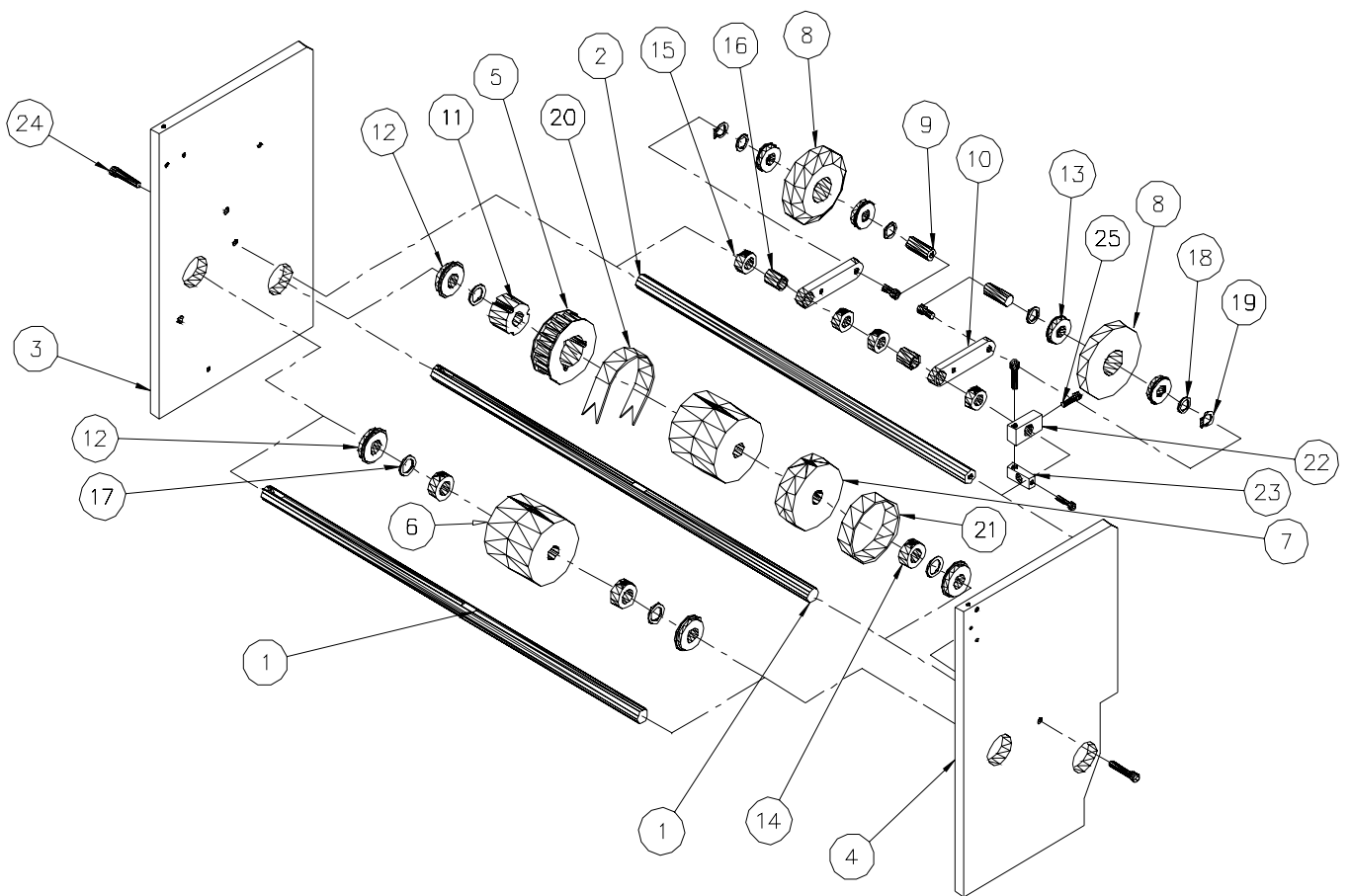


Sure-Feed
Engineering Inc

TURNOVER (Fig. 5-3)
DISCHARGE ASSEMBLY

ITEM	PART NO.	QTY.	DESCRIPTION
1	20004-012	2	SHAFT, DRIVE
2	20004-011	1	SHAFT, NIP PIVOT
3	20000-006	1	SIDEPLATE, DISCHARGE, LH
4	20000-005	1	SIDEPLATE, DISCHARGE, RH
5	99002-035	1	PULLEY, TL22L075, 1008
6	20006-002	2	PULLEY, CROWNED (DRIVE)
7	12006-001	1	ROLLER, CONVEYOR
8	20006-003	2	ROLLER, EXIT
9	20004-005	2	SHAFT, EXIT ROLLER
10	20008-002	2	BAR, EXIT, ROLLER MTG.
11	99017-019	1	BUSHING, TAPERLOCK 1008, 5/8 BORE
12	99003-006	4	BEARING, SEALED, 5/8 X 1-3/8
13	99003-007	4	BEARING, SEALED, 1/2 X 1-1/8
14	99017-005	3	COLLAR, SET, 5/8
15	99017-004	4	COLLAR, SET, 1/2
16	99003-038	2	BUSHING, 1/2 X 5/8 X 3/4
17	99003-021	4	WASHER, NYLON, 5/8 X 1/16
18	99003-018	4	WASHER, NYLON, 1/2 X 1/16
19	99022-004	2	SNAP RING, 1/2
20	99000-028	1	BELT, 255L075
21	10014-001	1	BELT, URETHANE
22	20009-003	1	BRACKET, GUIDE, MTG. (.500)
23	20009-004	1	BRACKET, GUIDE SUPPORT (.375)
24		3	SCREW, SKT HD, 1/4-20 X 1
25		2	SCREW, SKT HD, 10-24 X 3/4

FIG. 5-3



Sure-Feed
Engineering Inc

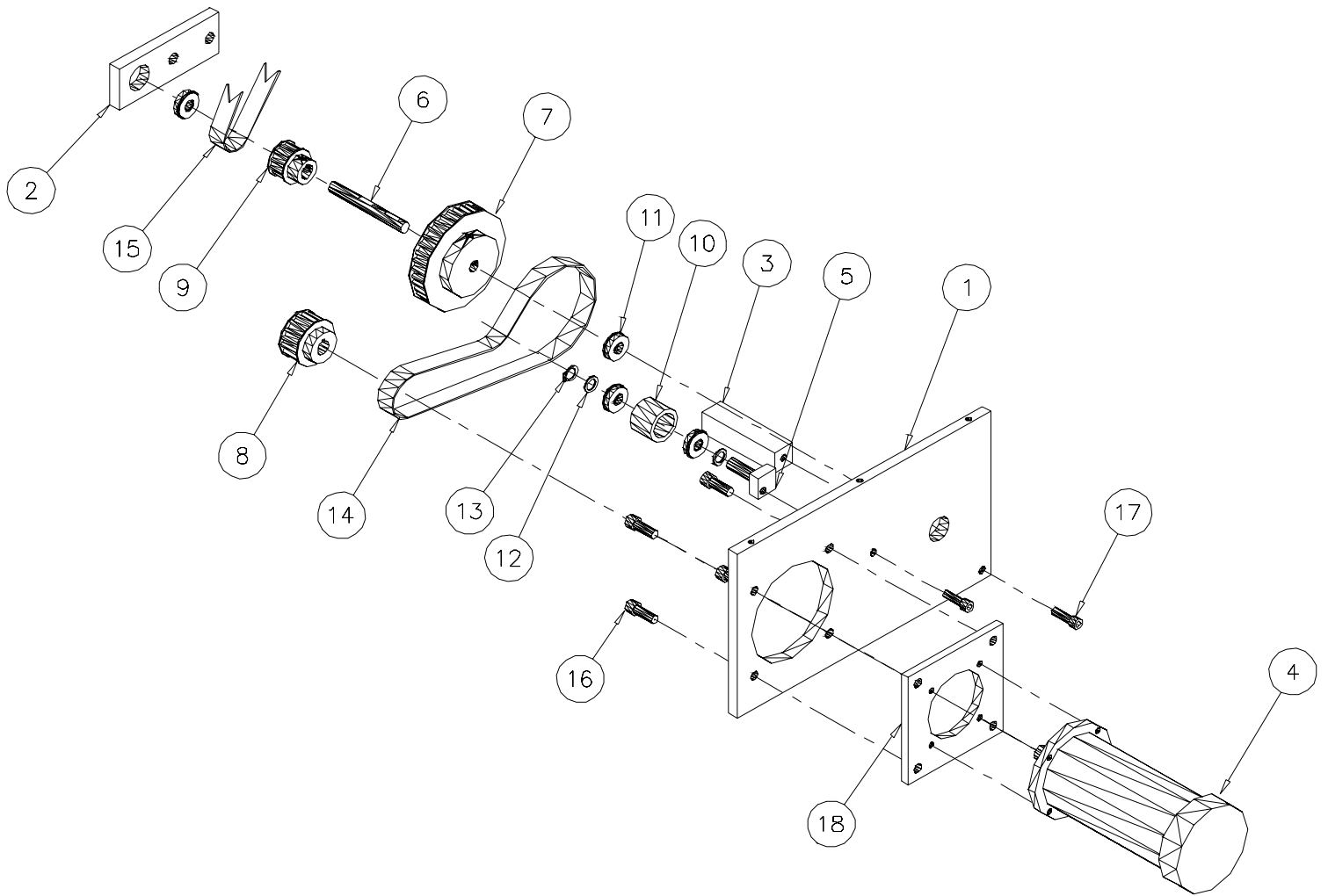
TURNOVER (Fig. 5-4)
MOTOR / MOTOR MOUNT ASSEMBLY

ITEM	PART NO.	QTY.	DESCRIPTION
1	20011-001	1	PLATE, MOTOR MOUNT
2	20011-002	1	PLATE, INTERMEDIATE SHAFT
3	20012-004	1	STANDOFF, MOTOR SUPPORT
4	99001-004	1	MOTOR, DC DRIVE, 1/4 HP
(4)	(99001-004)	(1)	(MOTOR, AC DRIVE, 1/4 HP)
5	18004-022	1	TENSIONER, ECCENTRIC
6	20004-008	1	SHAFT, INTERMEDIATE
7	99002-019	1	PULLEY, 36L075, 1/2 BORE
8	99002-036	1	PULLEY, 16L075, 5/8 BORE
9	99002-018	1	PULLEY, 12L075, 1/2 BORE
10	18006-012	1	ROLLER, TENSIONER
11	99003-007	4	BEARING, SEALED W/ SNAP RING, 1/2 X 1-1/8
12	99003-018	2	WASHER, NYLON, 1/2 X 1/16
13	99022-004	1	SNAP RING, 1/2
14	90000-035	1	BELT, 270L075
15	90000-028	1	BELT, 255L075
16		4	SCREW, SKT HD, 3/8-16 X 1
17		2	SCREW, SKT HD, 5/16-18 X 1
18	20011-005	1	MOTOR, ADPTOR MOUNT PLATE
19		4	SCREW, SKT HD, 1/4-20X5/8

(*MACHINES MANUFACTURED BEFORE JAN. 11, 2002 USE AC DRIVE MOTOR)

Sure-Feed
Engineering Inc

FIG. 5-4

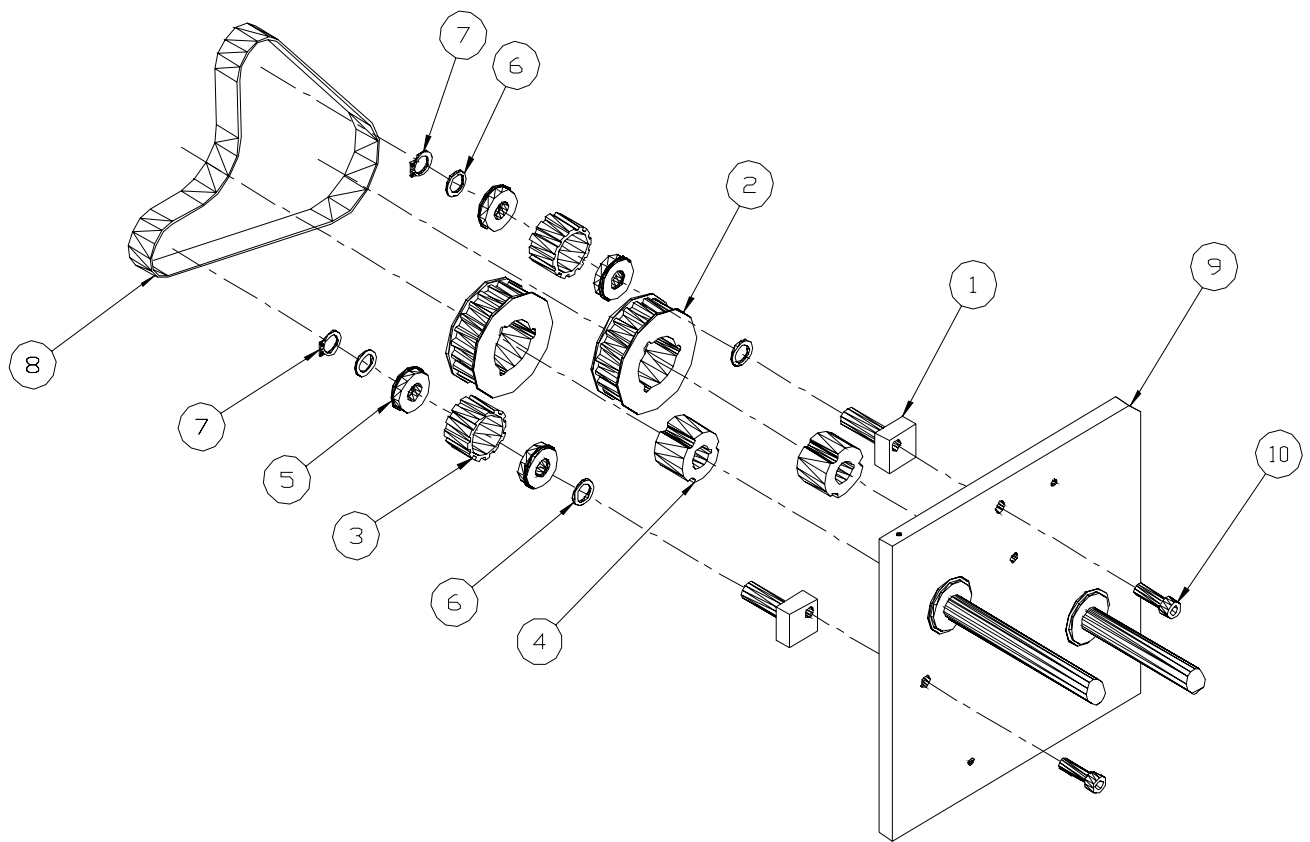


Sure-Feed
Engineering Inc

TURNOVER (Fig. 5-5)
DRIVE ASSEMBLY

ITEM	PART NO.	QTY.	DESCRIPTION
1	18004-022	2	TENSIONER, ECCENTRIC
2	99002-035	2	PULLEY, TL22L075 1008
3	20006-004	2	PULLEY, IDLER, 12L075
4	99017-019	2	BUSHING, TAPERLOCK, 1008, 5/8 BORE
5	99003-007	4	BEARING, SEALED W/ SNAP RING, 1/2 X1-1/8
6	99003-018	4	WASHER, NYLON, 1/2 X 1/16
7	99022-004	2	SNAP RING, 1/2
8	99000-034	1	BELT, D240L075
9	20000-006	1	SIDEPLATE, DISCHARGE, LH (REF. ONLY)
10		2	SCREW, SKT HD, 5/16-18 X 1

FIG. 5-5



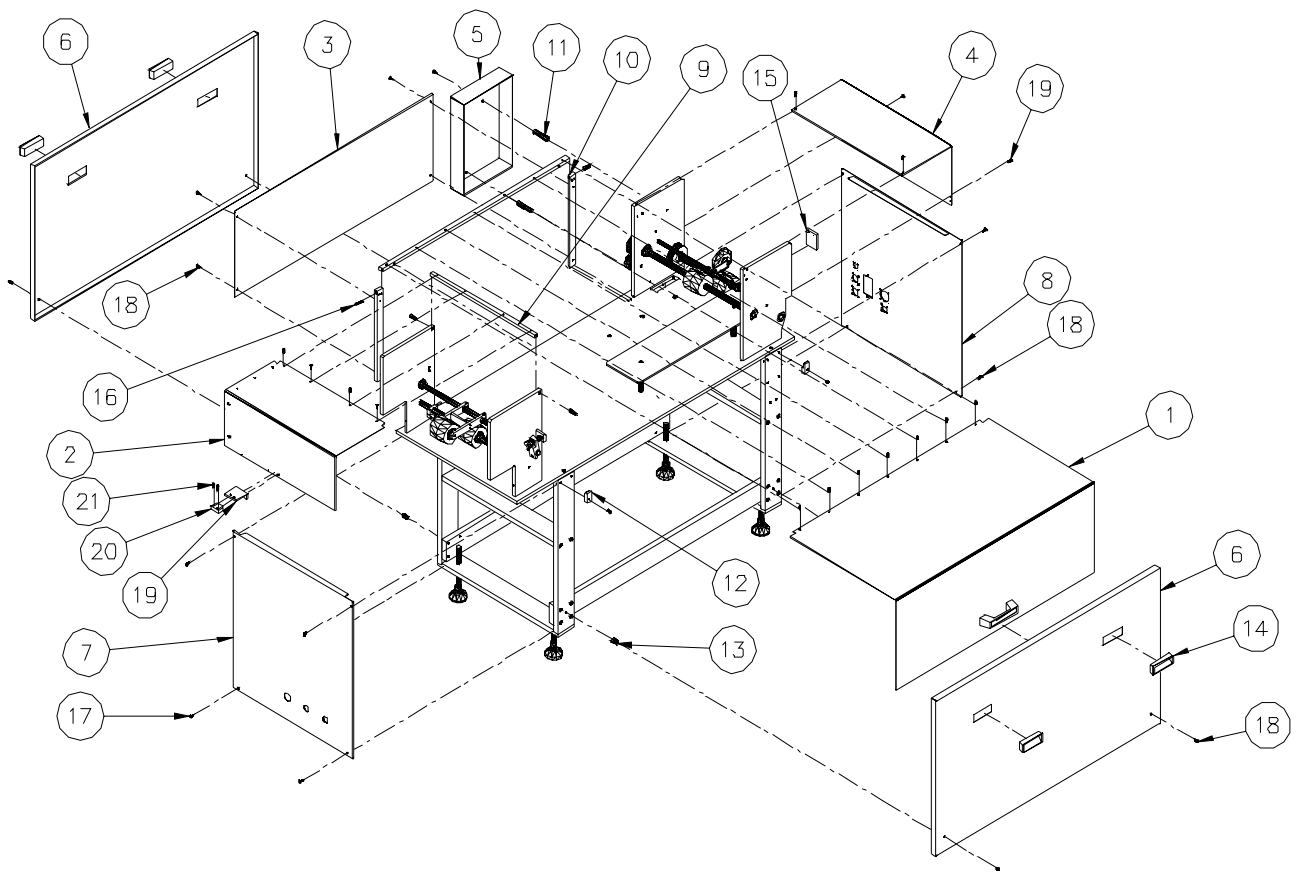
Sure-Feed
Engineering Inc

TURNOVER - COVERS (Fig. 5-6)

ITEM	PART NO.	QTY.	DESCRIPTION
1	(SEE FIG. 5-8)	1	CENTER COVER ASSEMBLY
2	20013-009	1	COVER, INFEED
3	20013-015	1	COVER, SIDE
4	20013-010	1	COVER, DISCHARGE
5	20013-013	1	COVER, DRIVE
6	20013-003	2	GUARD, SIDE
7	20013-011	1	COVER, END (INFEED)
8	20013-012	1	COVER, END (DISCHARGE)
9	20008-005	1	BAR, END COVER MTG.
10	20007-005	2	POST, COVER MTG.
11	20012-003	2	STANDOFF, DRIVE COVER
12	18007-042	4	BLOCK, SIDE GUARD MTG.
13	18012-006	4	STANDOFF, SIDE GUARD MTG.
14	99012-002	4	HANDLE, SIDE GUARD
15	20009-001	1	BRACKET, SWITCH MTG.
16	99006-024	4	PIN, STUD, 5/16-24 X 1-1/8
17		14	SCREW, BUTTON HD, 10-24 X 1/2
18		21	SCREW, BUTTON HD, 8-32 X 1/2
19	99018-002	1	BRACKET, SENSOR MTG.
20	98009-002	1	SENSOR, SENDER & RECIEVER, P& F THRU BEAM
21		2	SCREW, PAN HD, 6-32 X 1/4

Sure-Feed
Engineering Inc

FIG. 5-6

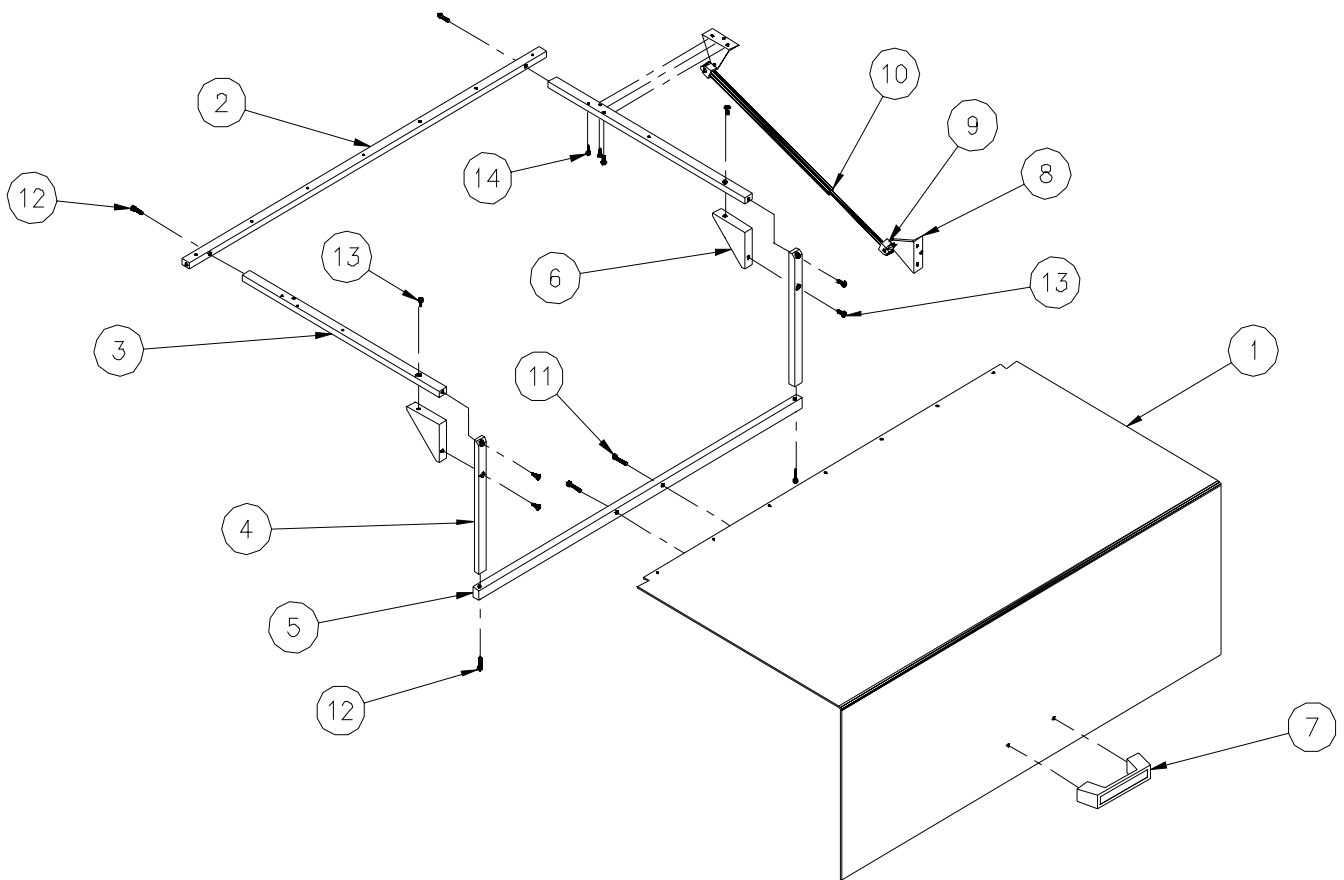


Sure-Feed
Engineering Inc

TURNOVER - COVERS (Fig. 5-7)
CENTER COVER ASSEMBLY

ITEM	PART NO.	QTY.	DESCRIPTION
1	20013-014	1	COVER, CENTER
2	20008-004	1	BAR, COVER MTG.
3	20008-008	2	BAR, COVER SUPPORT (TOP)
4	20008-007	2	BAR, COVER SUPPORT (SIDE)
5	20008-006	1	BAR, COVER SUPPORT (HANDLE)
6	20007-006	2	GUSSET, COVER SUPPORT
7	99012-001	1	HANDLE, CENTER COVER
8	99014-008	2	BALL STUD ANGLE BRACKET
9	99014-005	2	BALL SOCKET END FITTING
10	99014-007	1	GAS SPRING
11		2	SCREW, SKT HD, 1/4-20 X 1
12		4	SCREW, SKT HD, 1/4-20 X 3/4
13		6	SCREW, SKT HD, 1/4-20 X 1/2
14		3	SCREW, PAN HD, 10-24 X 1/2

FIG. 5-7



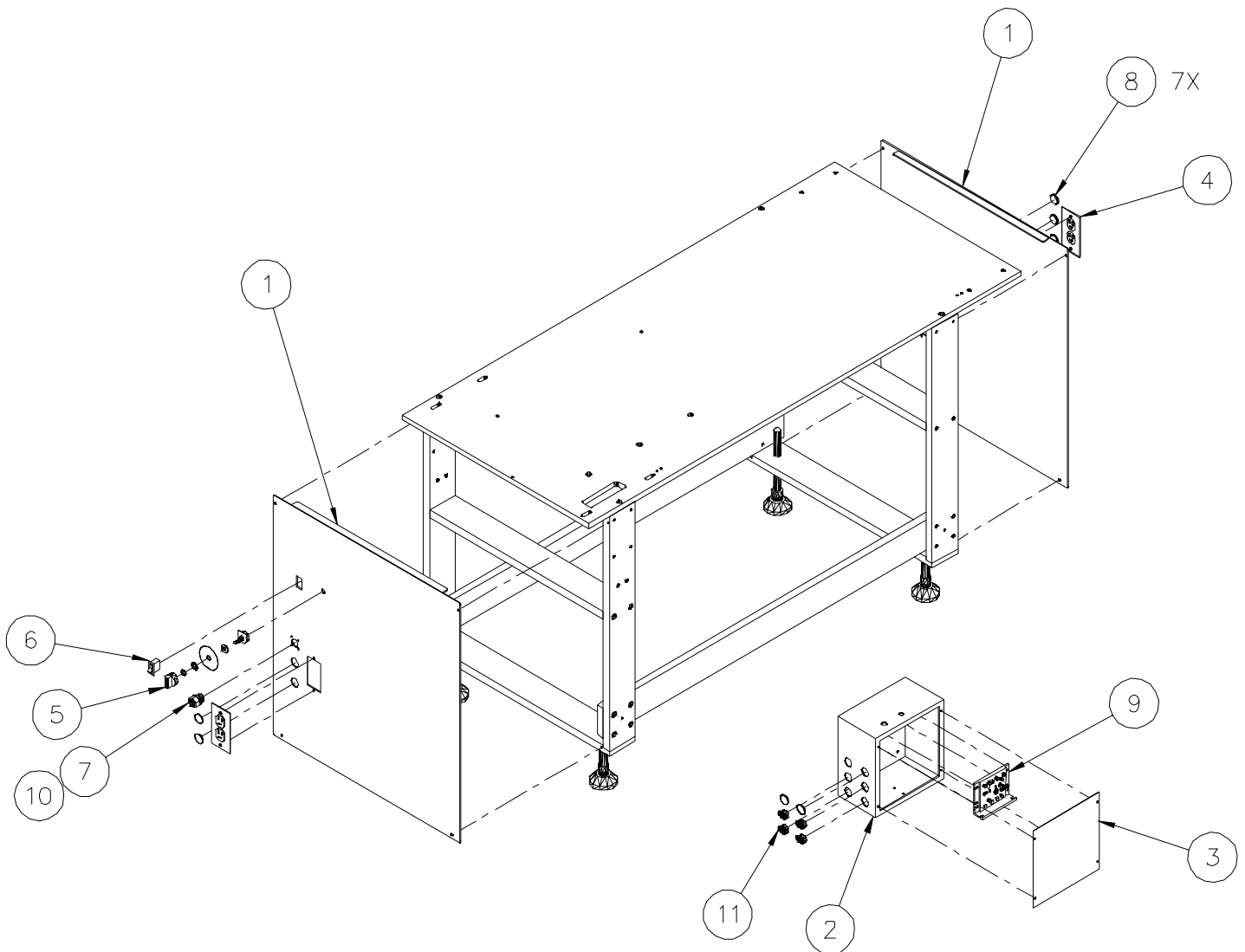
Sure-Feed
Engineering Inc

ELECTRICAL COMPONENTS (TURNOVER) (Fig. 5-8)

ITEM	PART NO.	QTY.	DESCRIPTION
1	20013-024	2	COVER, END, DISCHARGE (10X13)
2	12013-001	1	ENCLOSURE, ELECTRICAL
3	120013-002	1	COVER, ELECTRICAL ENCLOSURE
4	98016-032	2	COVER PLATE, CONDUIT BOX
5	98006-007	1	SPEED POT, 5K
6	98000-001	1	SWITCH, ROCKER, ON/OFF
7	98015-001	1	STRAIN RELIEF, 1/2"
8	98015-023	7	FINISHING PLUG, PLASTIC, BLACK, 7/8 HOLE
9	98005-007	1	MOTOR CONTROLLER, 240 VAC
10	98007-001	1	POWER CORD (NOT SHOWN)
11	98015-009	4	CONNECTOR, ROMEX, 3/8"

Sure-Feed
Engineering Inc

FIG. 5-8



Sure-Feed
Engineering Inc