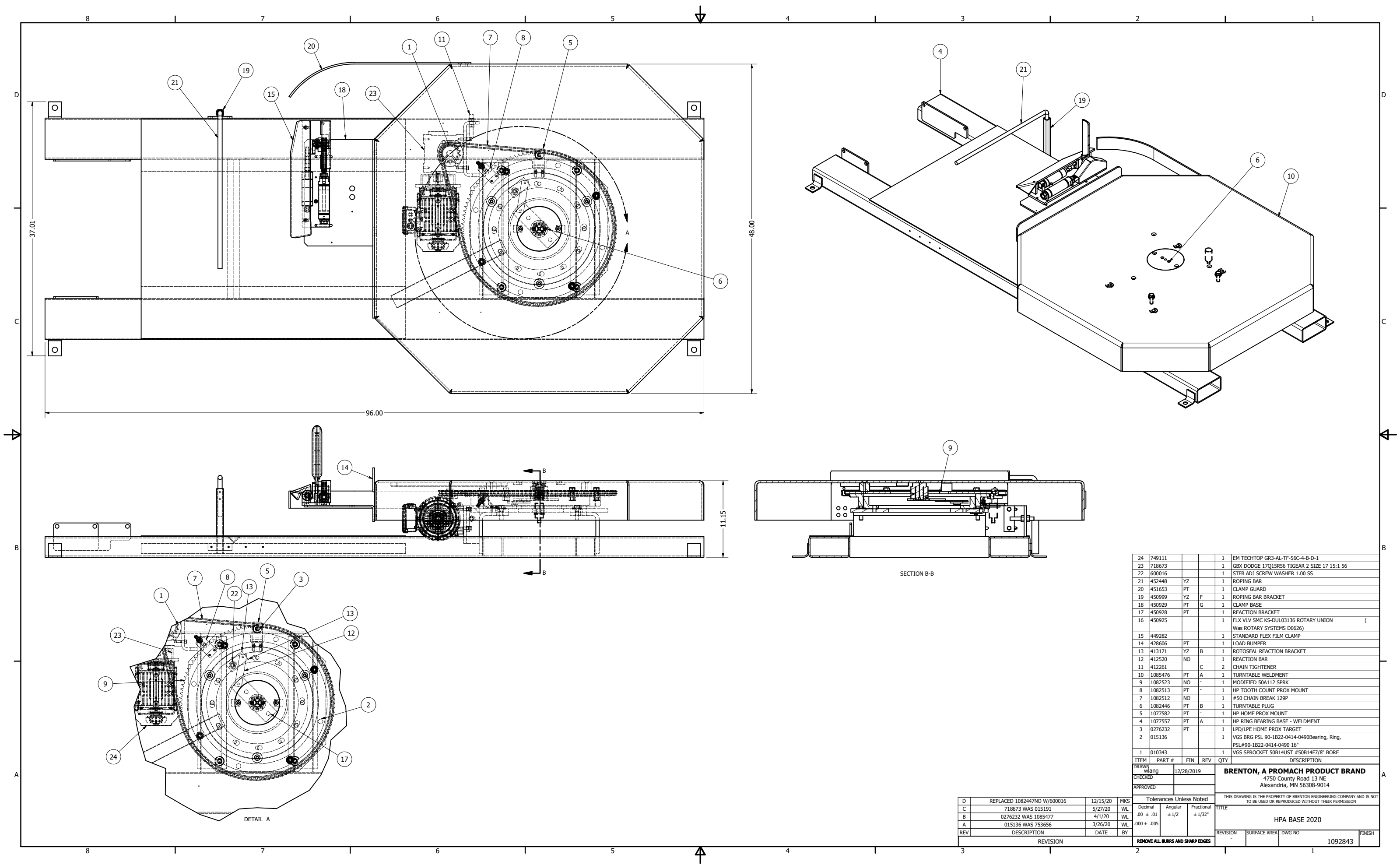
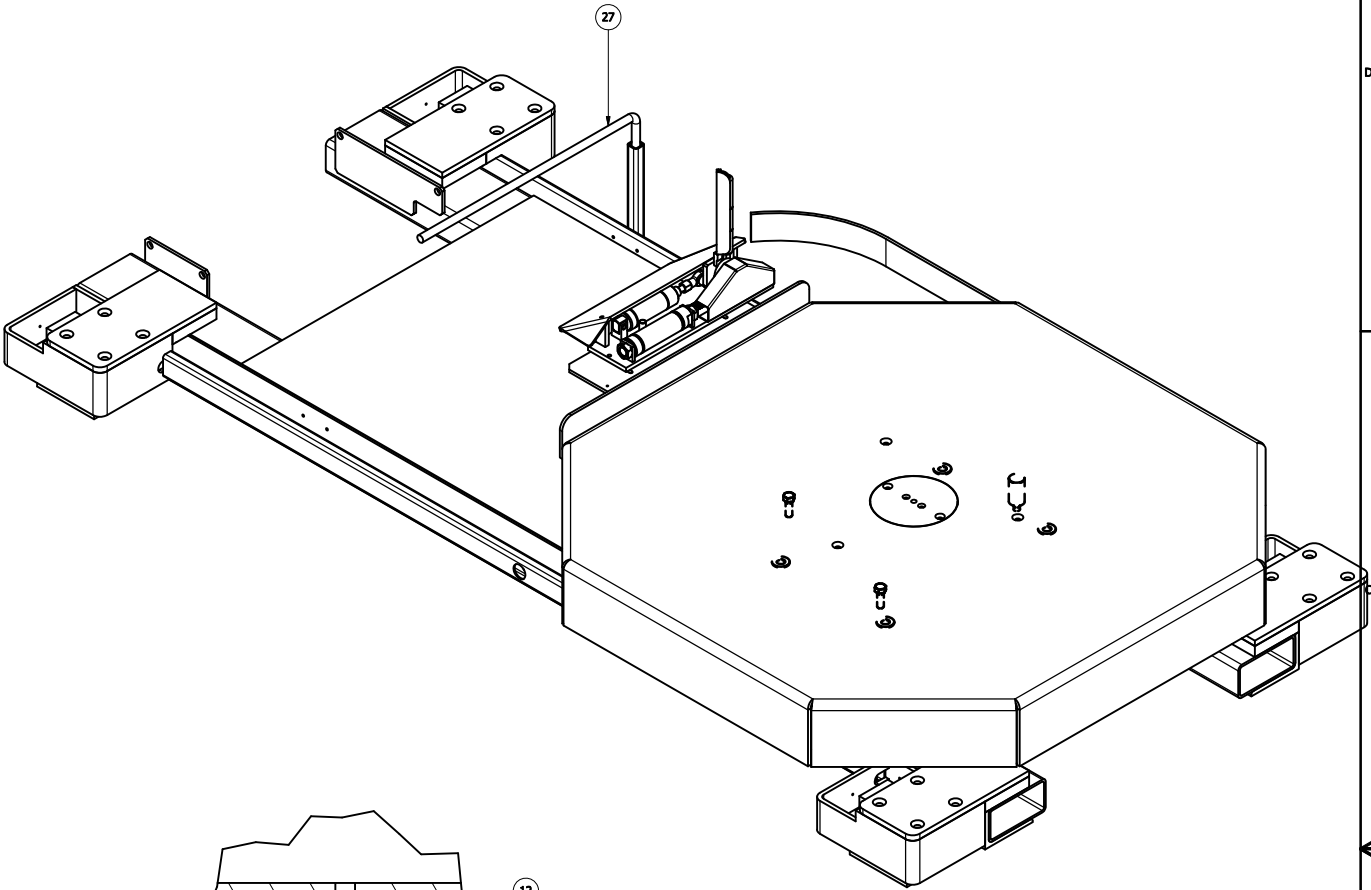
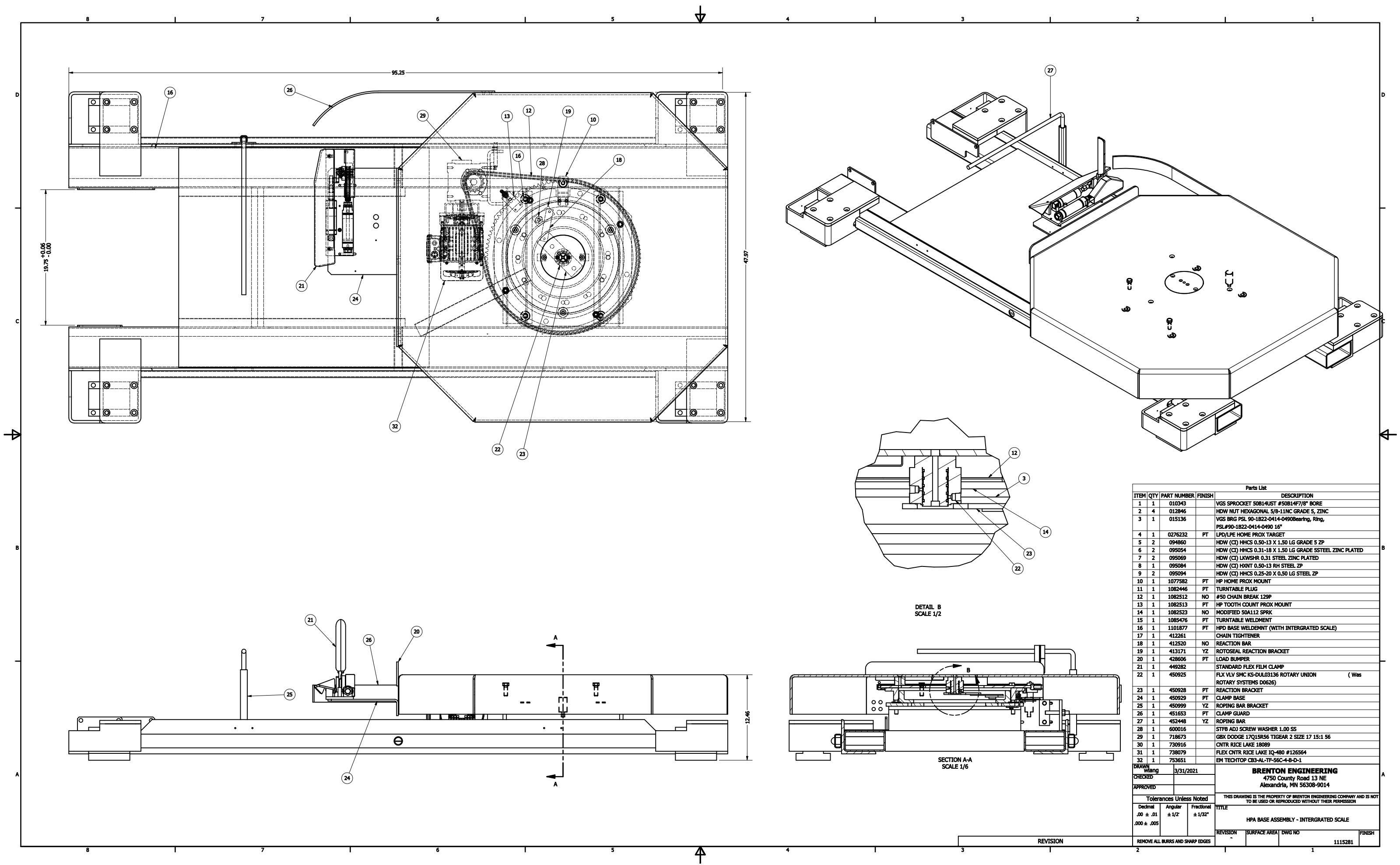




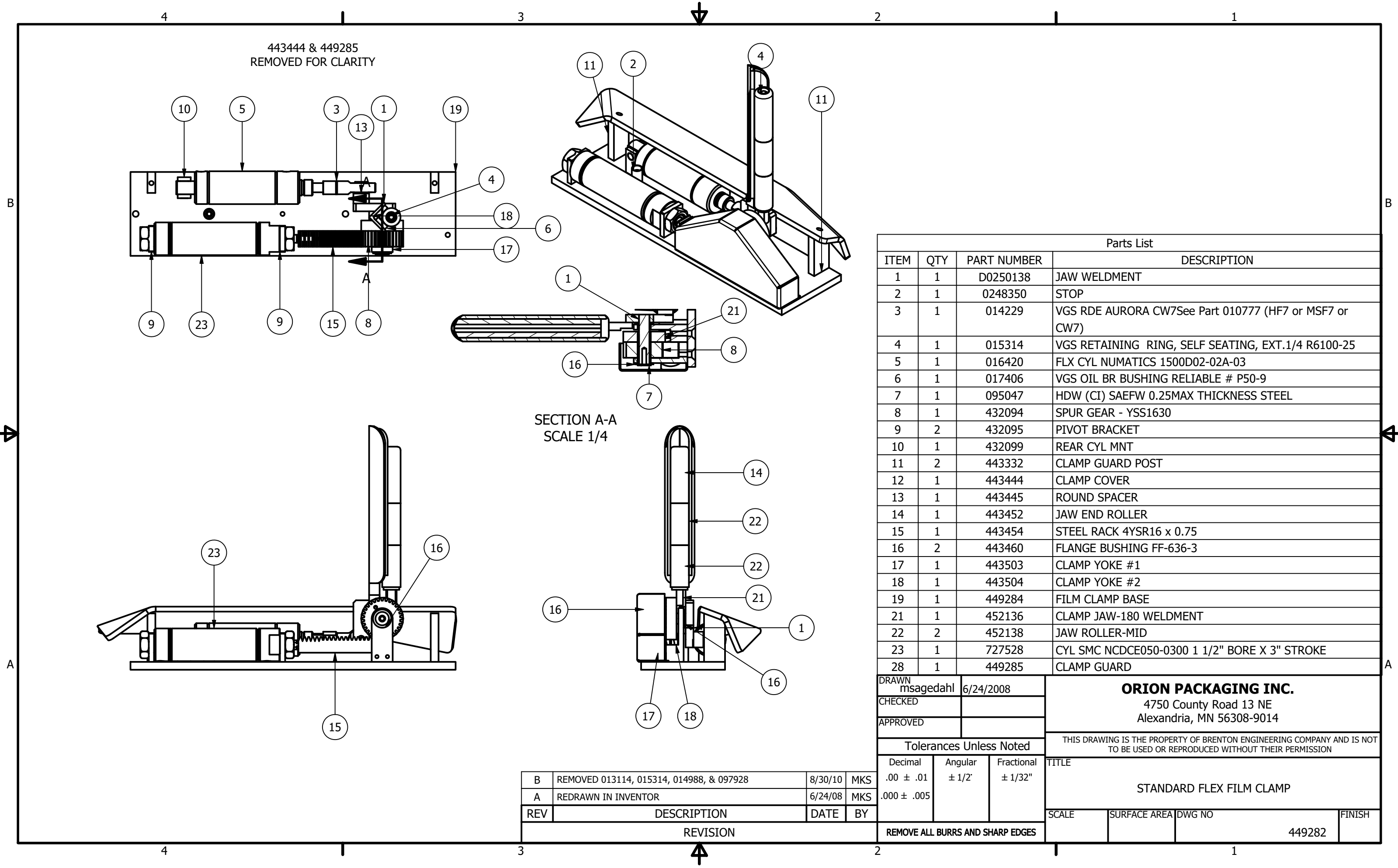
24	749111			1	EM TECHTOP GR3-AL-TF-56C-4-B-D-1
23	718673			1	GBX DODGE 17Q15R56 TIGEAR 2 SIZE 17 15:1 56
22	600016			1	STFB ADJ SCREW WASHER 1.00 SS
21	452448	YZ		1	ROPING BAR
20	451653	PT		1	CLAMP GUARD
19	450999	YZ	F	1	ROPING BAR BRACKET
18	450929	PT	G	1	CLAMP BASE
17	450928	PT		1	REACTION BRACKET
16	450925			1	FLX VLV SMC KS-DUL03136 ROTARY UNION (Was ROTARY SYSTEMS D0626)
15	449282			1	STANDARD FLEX FILM CLAMP
14	428606	PT		1	LOAD BUMPER
13	413171	YZ	B	1	ROTOSEAL REACTION BRACKET
12	412520	NO		1	REACTION BAR
11	412261		C	2	CHAIN TIGHTENER
10	1085476	PT	A	1	TURNABLE WELDMENT
9	1082523	NO	-	1	MODIFIED 50A112 SPRK
8	1082513	PT	-	1	HP TOOTH COUNT PROX MOUNT
7	1082512	NO		1	#50 CHAIN BREAK 129P
6	1082446	PT	B	1	TURNABLE PLUG
5	1077582	PT	-	1	HP HOME PROX MOUNT
4	1077557	PT	A	1	HP RING BEARING BASE - WELDMENT
3	0276232	PT		1	LPD/LPE HOME PROX TARGET
2	015136			1	VGS BRG PSL 90-1B22-0414-0490Bearing, Ring, PSL#90-1B22-0414-0490 16"
1	010343			1	VGS SPROCKET 50B14UST #50B14F/8" BORE
ITEM	PART #	FIN	REV	QTY	DESCRIPTION

DRAWN	Wiang	12/28/2019	BRENTON, A PROMACH PRODUCT BRAND	
CHECKED			4750 County Road 13 NE	
APPROVED			Alexandria, MN 56308-9014	
Tolerances Unless Noted			THIS DRAWING IS THE PROPERTY OF BRENTON ENGINEERING COMPANY AND IS NOT TO BE USED OR REPRODUCED WITHOUT THEIR PERMISSION	
REVISION			TITLE	
REMOVE ALL BURRS AND SHARP EDGES			HPA BASE 2020	
			REVISION	SURFACE AREA
			DWG NO	1092843
			FINISH	

D	REPLACED 1082447NO W/600016	12/15/20	MKS	Decimal	Angular	Fractional
C	718673 WAS 015191	5/27/20	WL	.00 ± .01	± 1/2°	± 1/32"
B	0276232 WAS 1085477	4/1/20	WL	.000 ± .005		
A	015136 WAS 753656	3/26/20	WL			
REV	DESCRIPTION	DATE	BY			



Parts List				
ITEM	QTY	PART NUMBER	FINISH	DESCRIPTION
1	1	010343		VGS SPROCKET 50B14UST #50B14F7/8" BORE
2	4	012846		HDW NUT HEXAGONAL 5/8-11NC GRADE 5, ZINC
3	1	015136		VGS BRG PSL 90-1822-0414-0490Bearing, Rng, PSL#90-1822-0414-0490 16"
4	1	0276232	PT	LPD/LPE HOME PROX TARGET
5	2	094860		HDW (C) HHCS 0.50-13 X 1.50 LG GRADE 5 ZP
6	2	095054		HDW (C) HHCS 0.31-18 X 1.50 LG GRADE SSTEEL ZINC PLATED
7	2	095069		HDW (C) LKWSHR 0.31 STEEL ZINC PLATED
8	1	095084		HDW (C) HXNT 0.50-13 RH STEEL ZP
9	2	095094		HDW (C) HHCS 0.25-20 X 0.50 LG STEEL ZP
10	1	1077582	PT	HP HOME PROX MOUNT
11	1	1082446	PT	TURNABLE PLUG
12	1	1082512	NO	#50 CHAIN BREAK 129P
13	1	1082513	PT	HP TOOTH COUNT PROX MOUNT
14	1	1082523	NO	MODIFIED 50A112 SPRK
15	1	1085476	PT	TURNABLE WELDMENT
16	1	1101877	PT	HPD BASE WELDEMENT (WITH INTERGRATED SCALE)
17	1	412261		CHAIN TIGHTENER
18	1	412520	NO	REACTION BAR
19	1	413171	YZ	ROTOSEAL REACTION BRACKET
20	1	428606	PT	LOAD BUMPER
21	1	449282		STANDARD FLEX FILM CLAMP
22	1	450925		FLX VLV SMC KS-DUL03136 ROTARY UNION (Was ROTARY SYSTEMS D0626)
23	1	450928	PT	REACTION BRACKET
24	1	450929	PT	CLAMP BASE
25	1	450999	YZ	ROPING BAR BRACKET
26	1	451653	PT	CLAMP GUARD
27	1	452448	YZ	ROPING BAR
28	1	600016		STFB ADJ SCREW WASHER 1.00 SS
29	1	718673		GBX DODGE 17Q15R56 TIGEAR 2 SIZE 17 15:1 56
30	1	730916		CNTR RICE LAKE 18089
31	1	738079		FLEX CNTR RICE LAKE IQ-480 #126564
32	1	753651		EM TECHTOP CB3-AL-TF-56C-4-B-D-1
DRAWN Wang			3/31/2021	BRENTON ENGINEERING 4750 County Road 13 NE Alexandria, MN 56308-9014
CHECKED				
APPROVED				
Tolerances Unless Noted				THIS DRAWING IS THE PROPERTY OF BRENTON ENGINEERING COMPANY AND IS NOT TO BE USED OR REPRODUCED WITHOUT THEIR PERMISSION
Decimal .00 ± .01 .000 ± .005	Angular ± 1/2°	Fractional ± 1/32"	TITLE	
			HPA BASE ASSEMBLY - INTERGRATED SCALE	
REVISION		SURFACE AREA	DWG NO	FINISH
REMOVE ALL BURRS AND SHARP EDGES			1115281	



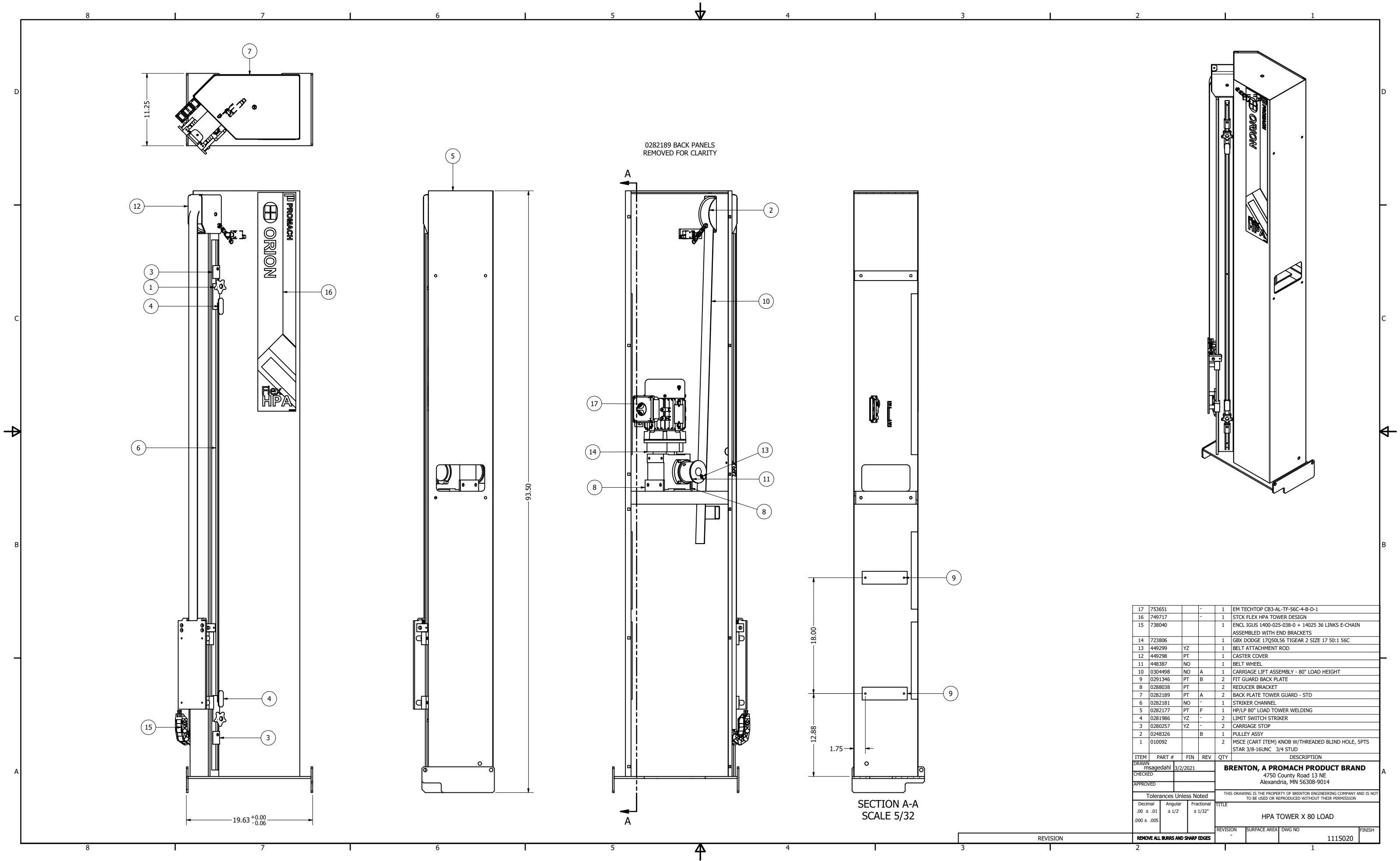
443444 & 449285
REMOVED FOR CLARITY

SECTION A-A
SCALE 1/4

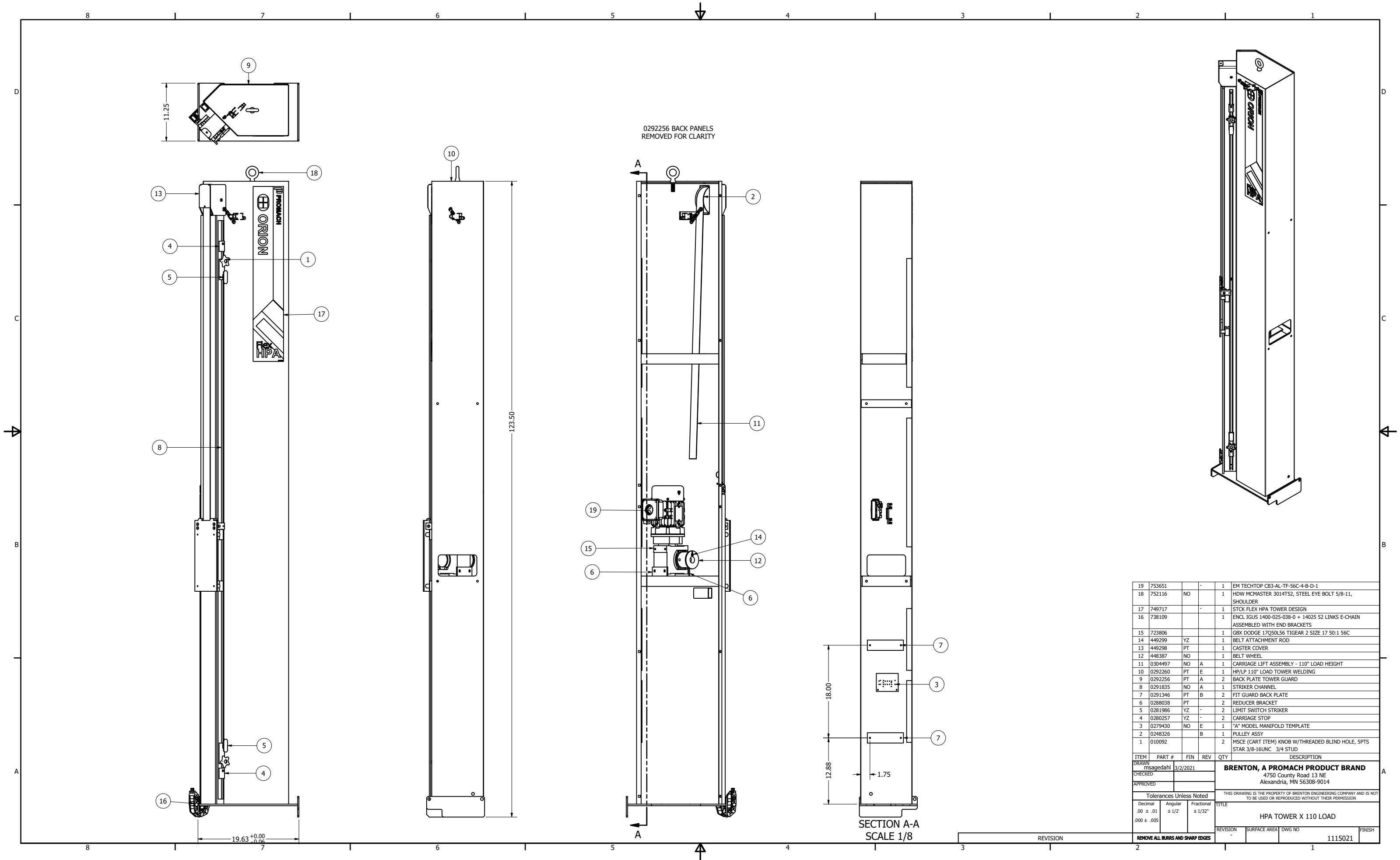
Parts List			
ITEM	QTY	PART NUMBER	DESCRIPTION
1	1	D0250138	JAW WELDMENT
2	1	0248350	STOP
3	1	014229	VGS RDE AURORA CW7See Part 010777 (HF7 or MSF7 or CW7)
4	1	015314	VGS RETAINING RING, SELF SEATING, EXT.1/4 R6100-25
5	1	016420	FLX CYL NUMATICS 1500D02-02A-03
6	1	017406	VGS OIL BR BUSHING RELIABLE # P50-9
7	1	095047	HDW (CI) SAEFW 0.25MAX THICKNESS STEEL
8	1	432094	SPUR GEAR - YSS1630
9	2	432095	PIVOT BRACKET
10	1	432099	REAR CYL MNT
11	2	443332	CLAMP GUARD POST
12	1	443444	CLAMP COVER
13	1	443445	ROUND SPACER
14	1	443452	JAW END ROLLER
15	1	443454	STEEL RACK 4YSR16 x 0.75
16	2	443460	FLANGE BUSHING FF-636-3
17	1	443503	CLAMP YOKE #1
18	1	443504	CLAMP YOKE #2
19	1	449284	FILM CLAMP BASE
21	1	452136	CLAMP JAW-180 WELDMENT
22	2	452138	JAW ROLLER-MID
23	1	727528	CYL SMC NCDCE050-0300 1 1/2" BORE X 3" STROKE
28	1	449285	CLAMP GUARD

DRAWN msagedahl	6/24/2008	ORION PACKAGING INC. 4750 County Road 13 NE Alexandria, MN 56308-9014	
CHECKED			
APPROVED			
Tolerances Unless Noted		THIS DRAWING IS THE PROPERTY OF BRENTON ENGINEERING COMPANY AND IS NOT TO BE USED OR REPRODUCED WITHOUT THEIR PERMISSION	
Decimal .00 ± .01	Angular ± 1/2'	Fractional ± 1/32"	TITLE STANDARD FLEX FILM CLAMP
REVISION	REMOVE ALL BURRS AND SHARP EDGES	SCALE	SURFACE AREA DWG NO 449282 FINISH

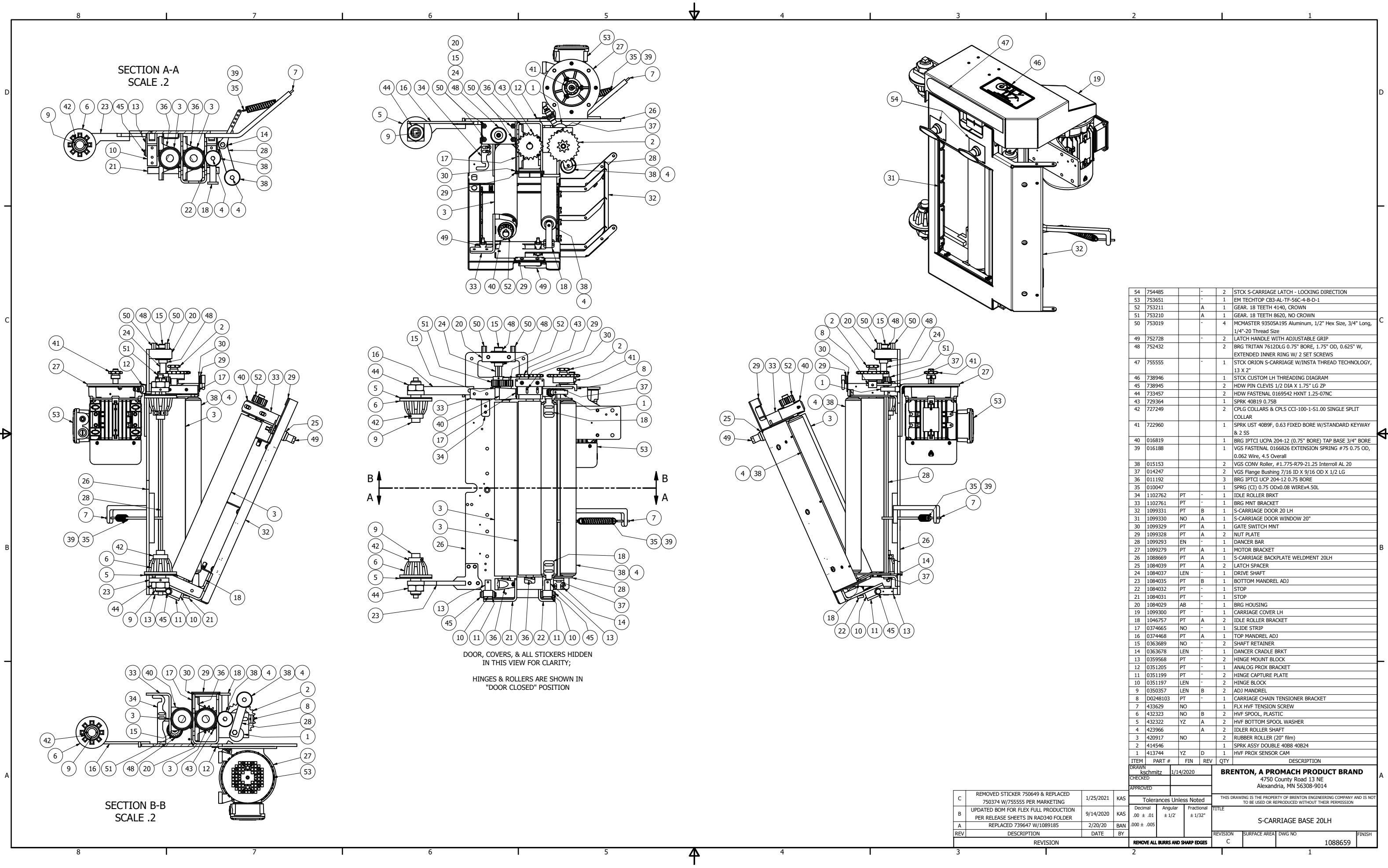
B	REMOVED 013114, 015314, 014988, & 097928	8/30/10	MKS
A	REDRAWN IN INVENTOR	6/24/08	MKS
REV	DESCRIPTION	DATE	BY



17	753651		-	1	EM TECHTOP CB3-AL-TF-56C-4-B-D-1
16	749717		-	1	STCK FLEX HPA TOWER DESIGN
15	738040			1	ENCL IGUS 1400-025-038-0 + 14025 36 LINKS E-CHAIN ASSEMBLED WITH END BRACKETS
14	723806			1	GBX DODGE 17Q50L56 TIGEAR 2 SIZE 17 50:1 56C
13	449299	YZ		1	BELT ATTACHMENT ROD
12	449298	PT		1	CASTER COVER
11	448387	NO		1	BELT WHEEL
10	0304498	NO	A	1	CARRIAGE LIFT ASSEMBLY - 80" LOAD HEIGHT
9	0291346	PT	B	2	FIT GUARD BACK PLATE
8	0288038	PT		2	REDUCER BRACKET
7	0282189	PT	A	2	BACK PLATE TOWER GUARD - STD
6	0282181	NO	-	1	STRIKER CHANNEL
5	0282177	PT	F	1	HP/LP 80" LOAD TOWER WELDING
4	0281986	YZ	-	2	LIMIT SWITCH STRIKER
3	0280257	YZ	-	2	CARRIAGE STOP
2	0248326	B		1	PULLEY ASSY
1	010092			2	MSCE (CART ITEM) KNOB W/THREADED BLIND HOLE, 5PTS STAR 3/8-16UNC 3/4 STUD
ITEM	PART #	FIN	REV	QTY	DESCRIPTION
DRAWN	msagedahl 3/2/2021				BRENTON, A PROMACH PRODUCT BRAND 4750 County Road 13 NE Alexandria, MN 56308-9014
CHECKED					
APPROVED					
Tolerances Unless Noted					THIS DRAWING IS THE PROPERTY OF BRENTON ENGINEERING COMPANY AND IS NOT TO BE USED OR REPRODUCED WITHOUT THEIR PERMISSION
Decimal .00 ± .01 .000 ± .005	Angular ± 1/2"	Fractional ± 1/32"			
TITLE			HPA TOWER X 80 LOAD		
REVISION		SURFACE AREA		DWG NO	FINISH
-					
REMOVE ALL BURRS AND SHARP EDGES					1115020



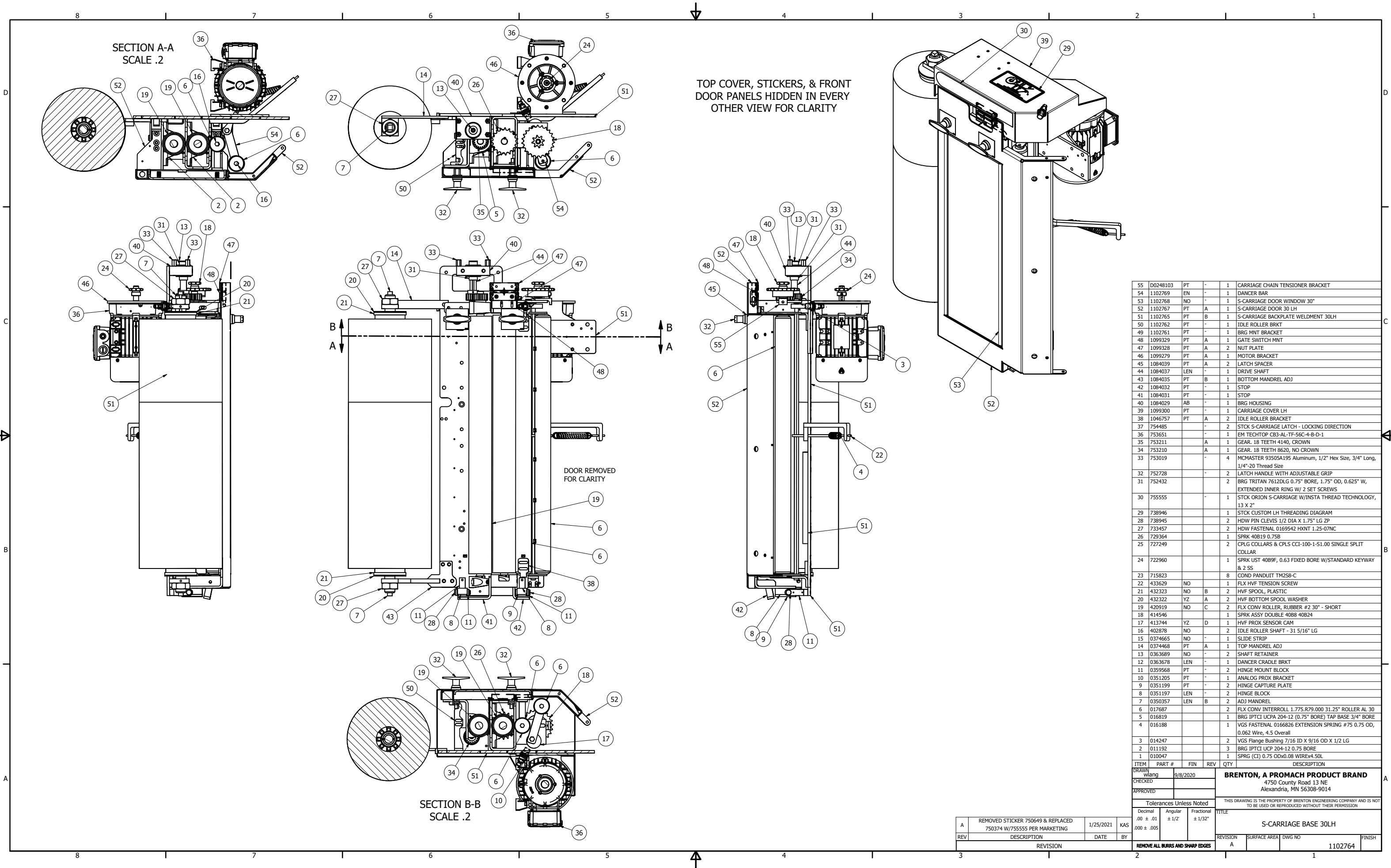
19	753651		-	1	EM TECHTOP CB3-AL-TF-56C-4-B-D-1
18	752116	NO		1	HDW MCMASTER 3014T52, STEEL EYE BOLT 5/8-11, SHOULDER
17	749717		-	1	STCK FLEX HPA TOWER DESIGN
16	738109			1	ENCL IGUS 1400-025-038-0 + 14025 52 LINKS E-CHAIN ASSEMBLED WITH END BRACKETS
15	723806			1	GBX DODGE 17Q50L56 TIGEAR 2 SIZE 17 50:1 56C
14	449299	YZ		1	BELT ATTACHMENT ROD
13	449298	PT		1	CASTER COVER
12	448387	NO		1	BELT WHEEL
11	0304497	NO	A	1	CARRIAGE LIFT ASSEMBLY - 110" LOAD HEIGHT
10	0292260	PT	E	1	HP/LP 110" LOAD TOWER WELDING
9	0292256	PT	A	2	BACK PLATE TOWER GUARD
8	0291835	NO	A	1	STRIKER CHANNEL
7	0291346	PT	B	2	FIT GUARD BACK PLATE
6	0288038	PT		2	REDUCER BRACKET
5	0281986	YZ	-	2	LIMIT SWITCH STRIKER
4	0280257	YZ	-	2	CARRIAGE STOP
3	0279430	NO	E	1	"A" MODEL MANIFOLD TEMPLATE
2	0248326		B	1	PULLEY ASSY
1	010092			2	MSCE (CART ITEM) KNOB W/THREADED BLIND HOLE, 5PTS STAR 3/8-16UNC 3/4 STUD
ITEM	PART #	FIN	REV	QTY	DESCRIPTION
DRAWN	ITSagedahl		3/2/2021		
CHECKED					
APPROVED					
					BRENTON, A PROMACH PRODUCT BRAND 4750 County Road 13 NE Alexandria, MN 56308-9014
					THIS DRAWING IS THE PROPERTY OF BRENTON ENGINEERING COMPANY AND IS NOT TO BE USED OR REPRODUCED WITHOUT THEIR PERMISSION
					Tolerances Unless Noted
Decimal	Angular	Fractional	TITLE		
.00 $\pm$.01	$\pm 1/2^\circ$	$\pm 1/32"$	HPA TOWER X 110 LOAD		
.000 $\pm$.005			REVISION	SURFACE AREA	DWG NO
REMOVE ALL BURRS AND SHARP EDGES					1115021



54	754485	-	-	2	STCK S-CARRIAGE LATCH - LOCKING DIRECTION
53	753651	-	-	1	EM TECHTOP CB3-AL-TF-56C-4-B-D-1
52	753211	A	-	1	GEAR. 18 TEETH 4140, CROWN
51	753210	A	-	1	GEAR. 18 TEETH 8620, NO CROWN
50	753019	-	-	4	MCMASTER 93505A195 Aluminum, 1/2" Hex Size, 3/4" Long, 1/4"-20 Thread Size
49	752728	-	-	2	LATCH HANDLE WITH ADJUSTABLE GRIP
48	752432	-	-	2	BRG TRITAN 7612DLG 0.75" BORE, 1.75" OD, 0.625" W, EXTENDED INNER RING W/ 2 SET SCREWS
47	755555	-	-	1	STCK ORION S-CARRIAGE W/INSTA THREAD TECHNOLOGY, 13 X 2"
46	738946	-	-	1	STCK CUSTOM LH THREADING DIAGRAM
45	738945	-	-	2	HDW PIN CLEVIS 1/2 DIA X 1.75" LG ZP
44	733457	-	-	2	HDW FASTENAL 0169542 HXNT 1.25-07NC
43	729364	-	-	1	SPRK 40B19 0.75B
42	727249	-	-	2	CPLG COLLARS & CPLS CCI-100-1-S1.00 SINGLE SPLIT COLLAR
41	722960	-	-	1	SPRK UST 40B9F, 0.63 FIXED BORE W/STANDARD KEYWAY & 2 SS
40	016819	-	-	1	BRG IPTCI UCBA 204-12 (0.75" BORE) TAP BASE 3/4" BORE
39	016188	-	-	1	VGS FASTENAL 0166826 EXTENSION SPRING #75 0.75 OD, 0.062 Wire, 4.5 Overall
38	015153	-	-	2	VGS CONV Roller, #1.775-R79-21.25 Interroll AL 20
37	014247	-	-	2	VGS Flange Bushing 7/16 ID X 9/16 OD X 1/2 LG
36	011192	-	-	3	BRG IPTCI UCP 204-12 0.75 BORE
35	010047	-	-	1	SPRG (CI) 0.75 ODx0.08 WIREx4.50L
34	1102762	PT	-	1	IDLE ROLLER BRKT
33	1102761	PT	-	1	BRG MNT BRACKET
32	1099331	PT	B	1	S-CARRIAGE DOOR 20 LH
31	1099330	NO	A	1	S-CARRIAGE DOOR WINDOW 20"
30	1099329	PT	A	1	GATE SWITCH MNT
29	1099328	PT	A	2	NUT PLATE
28	1099293	EN	-	1	DANCER BAR
27	1099279	PT	A	1	MOTOR BRACKET
26	1088669	PT	A	1	S-CARRIAGE BACKPLATE WELDMENT 20LH
25	1084039	PT	A	2	LATCH SPACER
24	1084037	LEN	-	1	DRIVE SHAFT
23	1084035	PT	B	1	BOTTOM MANDREL ADJ
22	1084032	PT	-	1	STOP
21	1084031	PT	-	1	STOP
20	1084029	AB	-	1	BRG HOUSING
19	1099300	PT	-	1	CARRIAGE COVER LH
18	1046757	PT	A	2	IDLE ROLLER BRACKET
17	0374665	NO	-	1	SLIDE STRIP
16	0374468	PT	A	1	TOP MANDREL ADJ
15	0363689	NO	-	2	SHAFT RETAINER
14	0363678	LEN	-	1	DANCER CRADLE BRKT
13	0359568	PT	-	2	HINGE MOUNT BLOCK
12	0351205	PT	-	1	ANALOG PROX BRACKET
11	0351199	PT	-	2	HINGE CAPTURE PLATE
10	0351197	LEN	-	2	HINGE BLOCK
9	0350357	LEN	B	2	ADJ MANDREL
8	D0248103	PT	-	1	CARRIAGE CHAIN TENSIONER BRACKET
7	433629	NO	-	1	FLX HVF TENSION SCREW
6	432323	NO	B	2	HVF SPOOL, PLASTIC
5	432322	YZ	A	2	HVF BOTTOM SPOOL WASHER
4	423966	-	A	2	IDLER ROLLER SHAFT
3	420917	NO	-	2	RUBBER ROLLER (20" film)
2	414546	-	-	1	SPRK ASSY DOUBLE 40B8 40B24
1	413744	YZ	D	1	HVF PROX SENSOR CAM
ITEM	PART #	FIN	REV	QTY	DESCRIPTION
					BRENTON, A PROMACH PRODUCT BRAND 4750 County Road 13 NE Alexandria, MN 56308-9014 THIS DRAWING IS THE PROPERTY OF BRENTON ENGINEERING COMPANY AND IS NOT TO BE USED OR REPRODUCED WITHOUT THEIR PERMISSION
Tolerances Unless Noted					
Decimal .00 ± .01 .000 ± .005	Angular ± 1/2°	Fractional ± 1/32"	TITLE		
S-CARRIAGE BASE 20LH					
REVISION		C	SURFACE AREA	DWG NO	FINISH
					1088659

C	REMOVED STICKER 750649 & REPLACED 750374 W/755555 PER MARKETING	1/25/2021	KAS
B	UPDATED BOM FOR FLEX FULL PRODUCTION PER RELEASE SHEETS IN RAD340 FOLDER	9/14/2020	KAS
A	REPLACED 739647 W/1089185	2/20/20	BAN
REV	DESCRIPTION	DATE	BY
REVISION			

REMOVE ALL BURRS AND SHARP EDGES



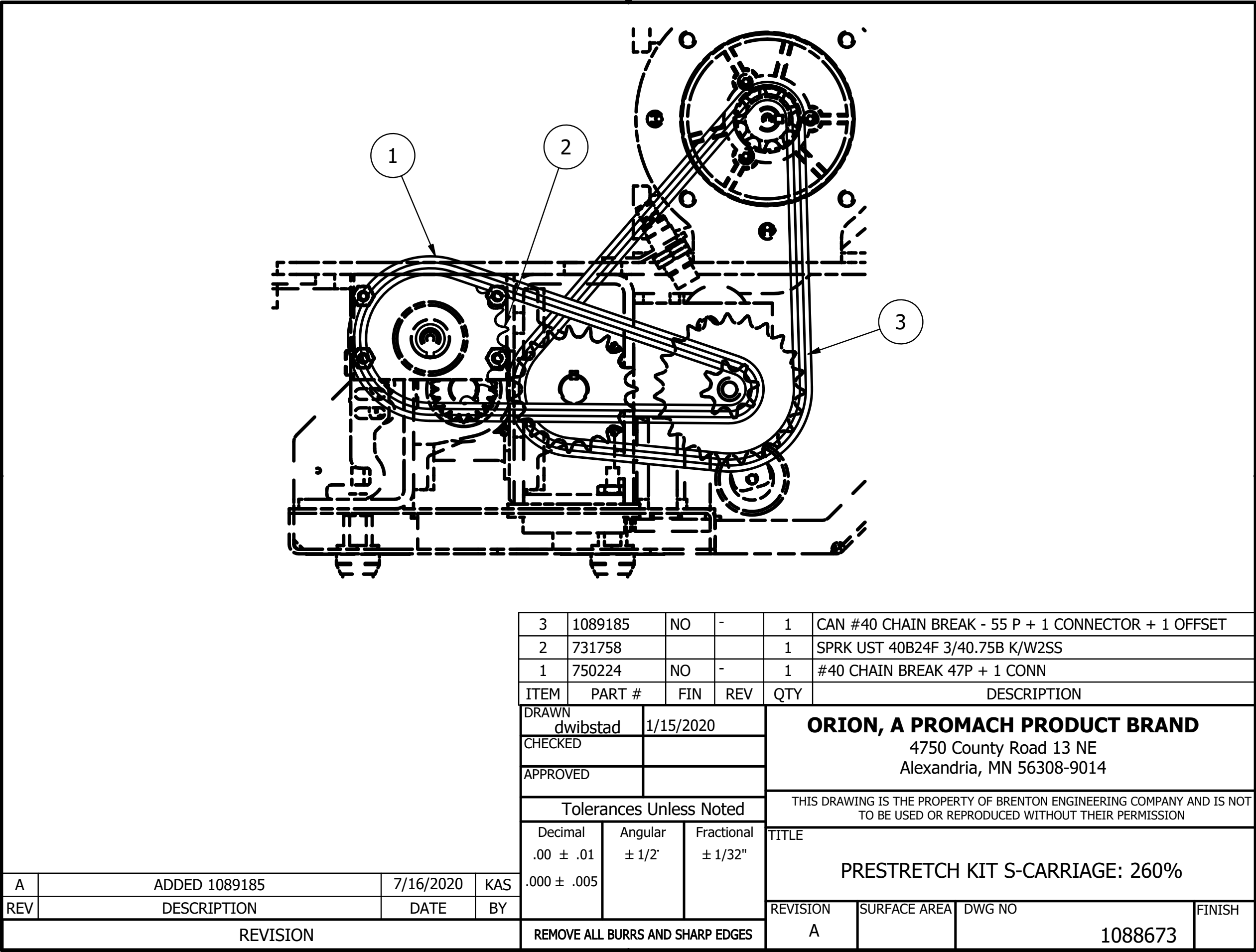
TOP COVER, STICKERS, & FRONT
DOOR PANELS HIDDEN IN EVERY
OTHER VIEW FOR CLARITY

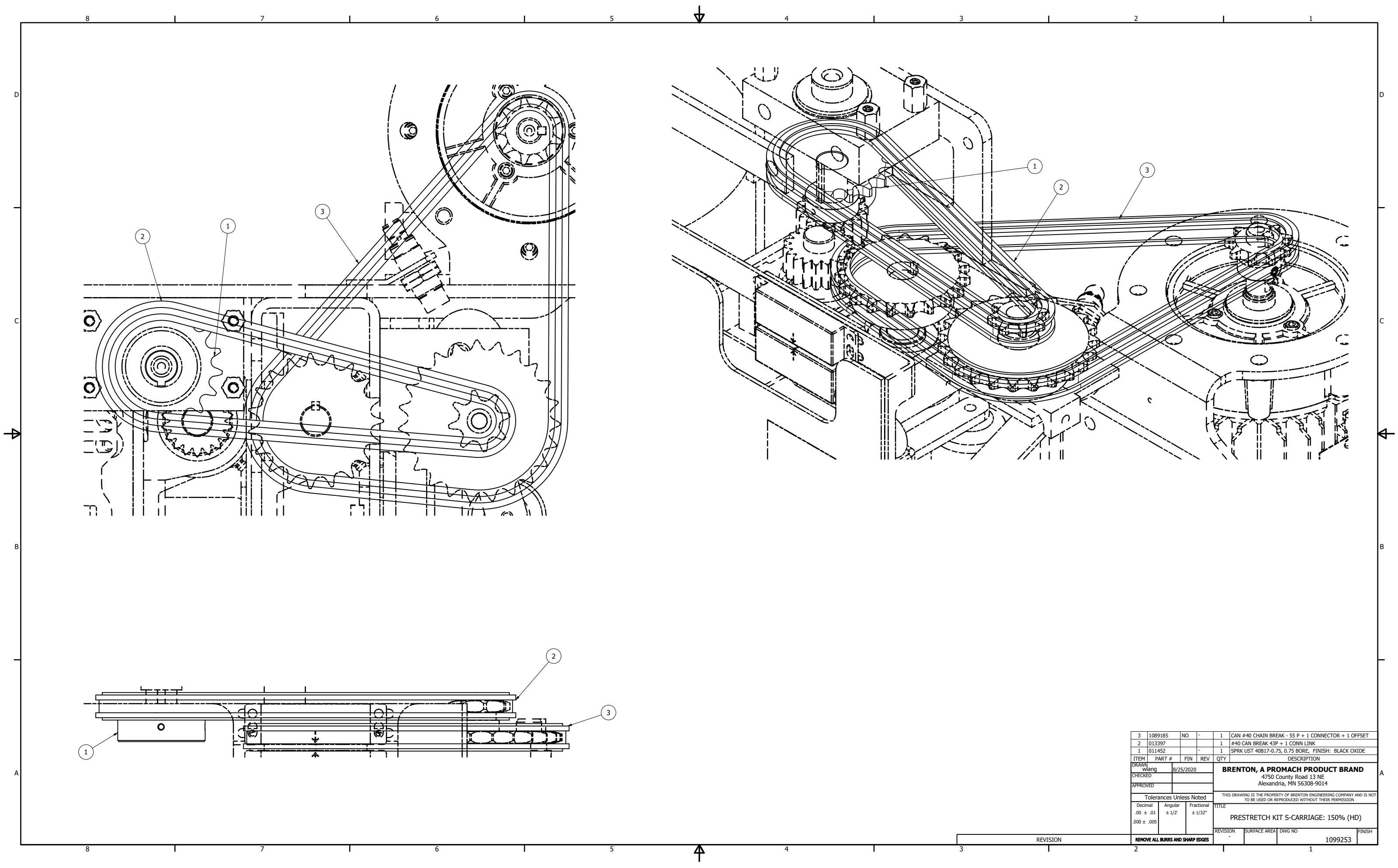
DOOR REMOVED
FOR CLARITY

SECTION B-B
SCALE .2

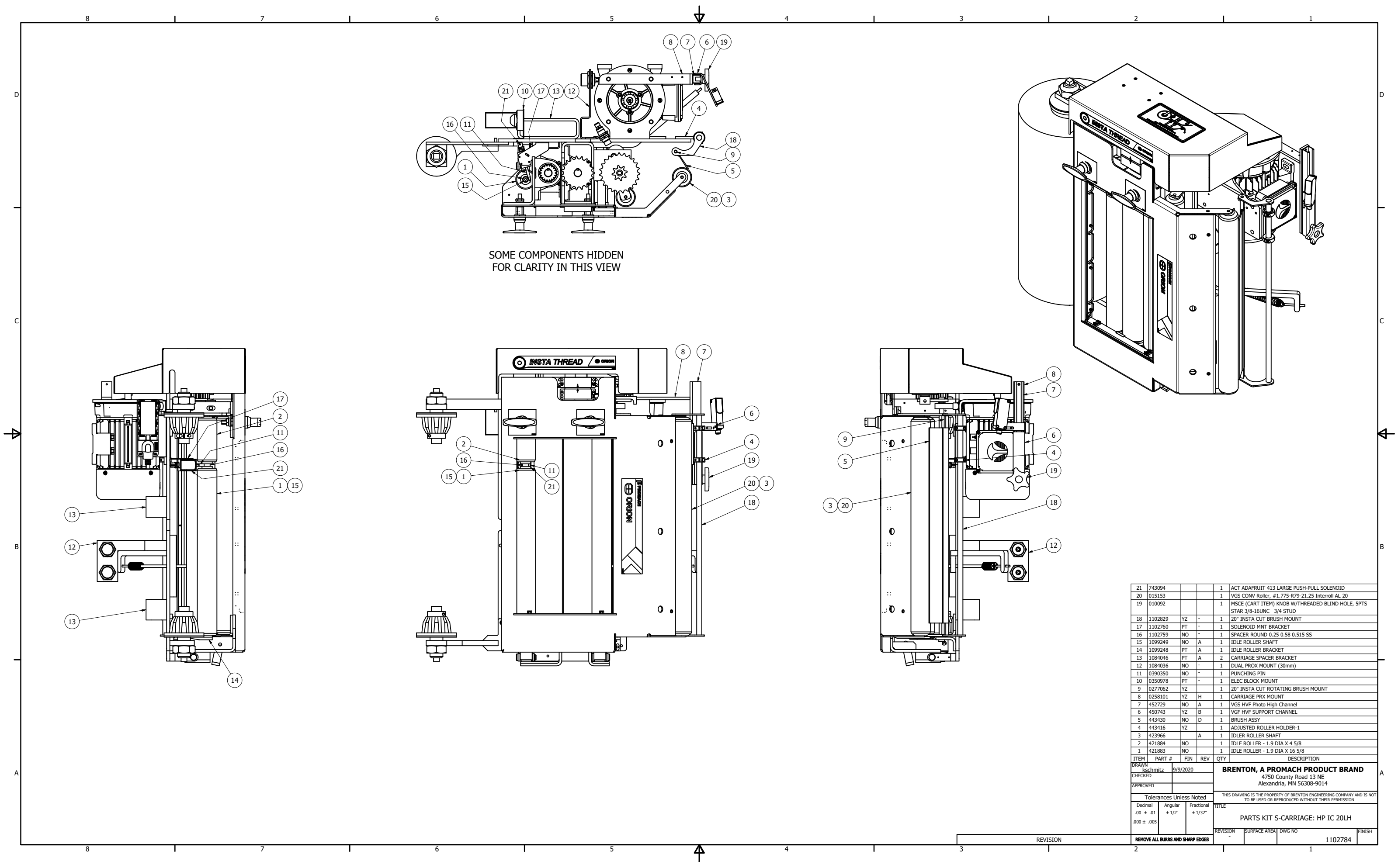
SECTION A-A
SCALE .2

55	D0248103	PT	-	1	CARRIAGE CHAIN TENSIONER BRACKET
54	1102769	EN	-	1	DANCER BAR
53	1102768	NO	-	1	S-CARRIAGE DOOR WINDOW 30"
52	1102767	PT	A	1	S-CARRIAGE DOOR 30 LH
51	1102765	PT	B	1	S-CARRIAGE BACKPLATE WELDMENT 30LH
50	1102762	PT	-	1	IDLE ROLLER BRKT
49	1102761	PT	-	1	BRG MNT BRACKET
48	1099329	PT	A	1	GATE SWITCH MNT
47	1099328	PT	A	2	NUT PLATE
46	1099279	PT	A	1	MOTOR BRACKET
45	1084039	PT	A	2	LATCH SPACER
44	1084037	LEN	-	1	DRIVE SHAFT
43	1084035	PT	B	1	BOTTOM MANDREL ADJ
42	1084032	PT	-	1	STOP
41	1084031	PT	-	1	STOP
40	1084029	AB	-	1	BRG HOUSING
39	1099300	PT	-	1	CARRIAGE COVER LH
38	1046757	PT	A	2	IDLE ROLLER BRACKET
37	754485	-	2	STCK S-CARRIAGE LATCH - LOCKING DIRECTION	
36	753651	-	1	EM TECHTOP CB3-AL-TF-56C-4-B-D-1	
35	753211	A	1	GEAR. 18 TEETH 4140, CROWN	
34	753210	A	1	GEAR. 18 TEETH 8620, NO CROWN	
33	753019	-	4	MCMASTER 93505A195 Aluminum, 1/2" Hex Size, 3/4" Long, 1/4"-20 Thread Size	
32	752728	-	2	LATCH HANDLE WITH ADJUSTABLE GRIP	
31	752432	-	2	BRG TRITAN 7612DLG 0.75" BORE, 1.75" OD, 0.625" W, EXTENDED INNER RING W/ 2 SET SCREWS	
30	755555	-	1	STCK ORION S-CARRIAGE W/INSTA THREAD TECHNOLOGY, 13 X 2"	
29	738946	-	1	STCK CUSTOM LH THREADING DIAGRAM	
28	738945	-	2	HDW PIN CLEVIS 1/2 DIA X 1.75" LG ZP	
27	733457	-	2	HDW FASTENAL 0169542 HXNT 1.25-07NC	
26	729364	-	1	SPRK 40B19 0.75B	
25	727249	-	2	CPLG COLLARS & CPLS CCI-100-1-S1.00 SINGLE SPLIT COLLAR	
24	722960	-	1	SPRK UST 40B9F, 0.63 FIXED BORE W/STANDARD KEYWAY & 2 SS	
23	715823	-	8	COND PANDUIT TM258-C	
22	433629	NO	1	FLX HVF TENSION SCREW	
21	432323	NO	B	HVF SPOOL, PLASTIC	
20	432322	YZ	A	HVF BOTTOM SPOOL WASHER	
19	420919	NO	C	FLX CONV ROLLER, RUBBER #2 30" - SHORT	
18	414546	-	1	SPRK ASSY DOUBLE 40B8 40B24	
17	413744	YZ	D	HVF PROX SENSOR CAM	
16	402878	NO	2	IDLE ROLLER SHAFT - 31 5/16" LG	
15	0374665	NO	-	SLIDE STRIP	
14	0374468	PT	A	TOP MANDREL ADJ	
13	0363689	NO	-	SHAFT RETAINER	
12	0363678	LEN	-	DANCER CRADLE BRKT	
11	0359568	PT	-	HINGE MOUNT BLOCK	
10	0351205	PT	-	ANALOG PROX BRACKET	
9	0351199	PT	-	HINGE CAPTURE PLATE	
8	0351197	LEN	-	HINGE BLOCK	
7	0350357	LEN	B	ADJ MANDREL	
6	017687	-	2	FLX CONV INTERROLL 1.775.R79.000 31.25" ROLLER AL 30	
5	016819	-	1	BRG IPTCI UCPA 204-12 (0.75" BORE) TAP BASE 3/4" BORE	
4	016188	-	1	VGS FASTENAL 0166826 EXTENSION SPRING #75 0.75 OD, 0.062 Wire, 4.5 Overall	
3	014247	-	2	VGS Flange Bushing 7/16 ID X 9/16 OD X 1/2 LG	
2	011192	-	3	BRG IPTCI UCP 204-12 0.75 BORE	
1	010047	-	1	SPRG (CI) 0.75 ODx0.08 WIREx4.50L	
ITEM	PART #	FIN	REV	QTY	DESCRIPTION
DRAWN	Wiang	9/8/2020	BRENTON, A PROMACH PRODUCT BRAND 4750 Country Road 13 NE Alexandria, MN 56308-9014		
CHECKED					
APPROVED					
Tolerances Unless Noted					THIS DRAWING IS THE PROPERTY OF BRENTON ENGINEERING COMPANY AND IS NOT TO BE USED OR REPRODUCED WITHOUT THEIR PERMISSION
Decimal	Angular	Fractional	TITLE		
.00 ± .01	± 1/2°	± 1/32"	S-CARRIAGE BASE 30LH		
.000 ± .005			REVISION	SURFACE AREA	DWG NO
REMOVE ALL BURRS AND SHARP EDGES			A		1102764
FINISH					



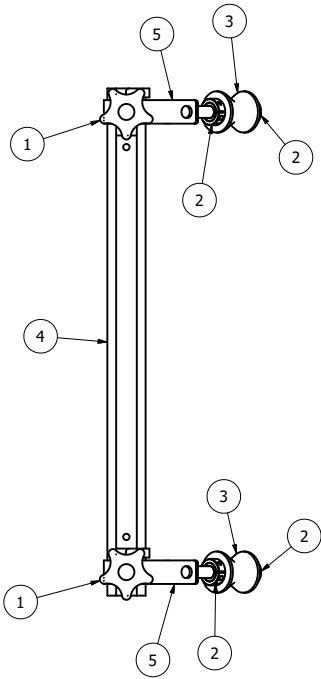
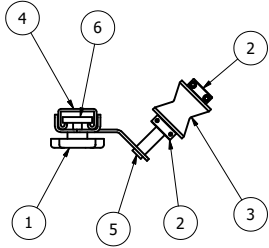


3	1089185	NO	-	1	CAN #40 CHAIN BREAK - 55 P + 1 CONNECTOR + 1 OFFSET
2	013397			1	#40 CAN BREAK 43P + 1 CONN LINK
1	011452		-	1	SPRK UST 40B17-0.75, 0.75 BORE, FINISH: BLACK OXIDE
ITEM	PART #	FIN	REV	QTY	DESCRIPTION
DRAWN	Wiang	8/25/2020			BRENTON, A PROMACH PRODUCT BRAND 4750 County Road 13 NE Alexandria, MN 56308-9014
CHECKED					
APPROVED					
Tolerances Unless Noted			THIS DRAWING IS THE PROPERTY OF BRENTON ENGINEERING COMPANY AND IS NOT TO BE USED OR REPRODUCED WITHOUT THEIR PERMISSION		
Decimal .00 ± .01 .000 ± .005	Angular ± 1/2°	Fractional ± 1/32"	TITLE PRESTRETCH KIT S-CARRIAGE: 150% (HD)		
REVISION			SURFACE AREA	DWG NO	FINISH
REMOVE ALL BURRS AND SHARP EDGES				1099253	

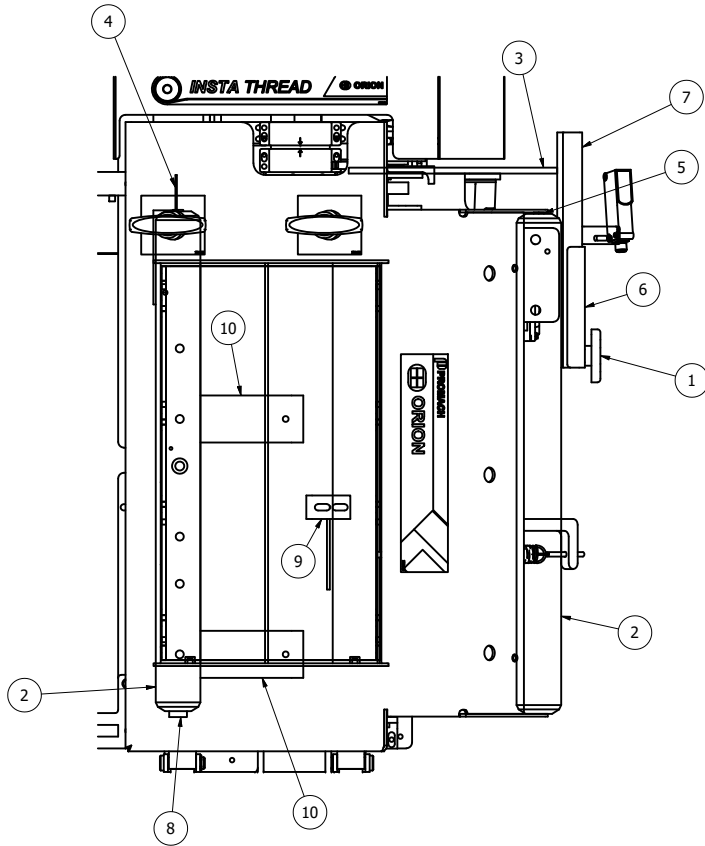
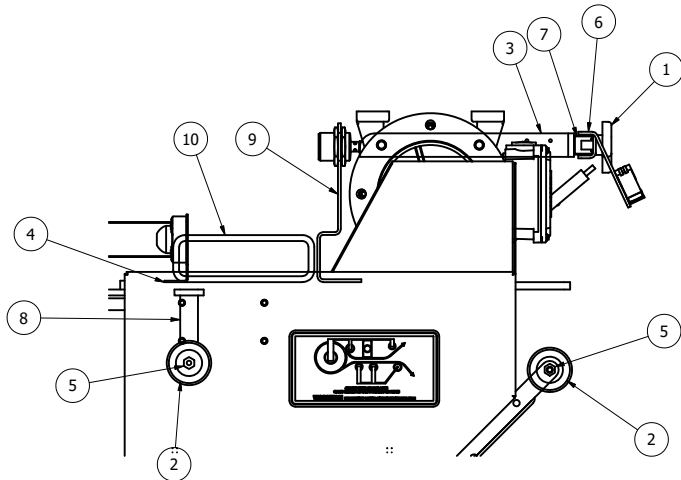


21	743094			1	ACT ADAFRUIT 413 LARGE PUSH-PULL SOLENOID	
20	015153			1	VGS CONV Roller, #1.775-R79-21.25 Interroll AL 20	
19	010092			1	MSCE (CART ITEM) KNOB W/THREADED BLIND HOLE, 5PTS STAR 3/8-16UNC 3/4 STUD	
18	1102829	YZ	-	1	20" INSTA CUT BRUSH MOUNT	
17	1102760	PT	-	1	SOLENOID MNT BRACKET	
16	1102759	NO	-	1	SPACER ROUND 0.25 0.58 0.515 SS	
15	1099249	NO	A	1	IDLE ROLLER SHAFT	
14	1099248	PT	A	1	IDLE ROLLER BRACKET	
13	1084046	PT	A	2	CARRIAGE SPACER BRACKET	
12	1084036	NO	-	1	DUAL PROX MOUNT (30mm)	
11	0390350	NO	-	1	PUNCHING PIN	
10	0350978	PT	-	1	ELEC BLOCK MOUNT	
9	0277062	YZ	-	1	20" INSTA CUT ROTATING BRUSH MOUNT	
8	0258101	YZ	H	1	CARRIAGE PRX MOUNT	
7	452729	NO	A	1	VGS HVF Photo High Channel	
6	450743	YZ	B	1	VGF HVF SUPPORT CHANNEL	
5	443430	NO	D	1	BRUSH ASSY	
4	443416	YZ	-	1	ADJUSTED ROLLER HOLDER-1	
3	423966		A	1	IDLER ROLLER SHAFT	
2	421884	NO	-	1	IDLE ROLLER - 1.9 DIA X 4 5/8	
1	421883	NO	-	1	IDLE ROLLER - 1.9 DIA X 16 5/8	
ITEM	PART #	FIN	REV	QTY	DESCRIPTION	
DRAWN	kschmitz	9/9/2020			BRENTON, A PROMACH PRODUCT BRAND 4750 County Road 13 NE Alexandria, MN 56308-9014	
CHECKED						
APPROVED						
Tolerances Unless Noted					THIS DRAWING IS THE PROPERTY OF BRENTON ENGINEERING COMPANY AND IS NOT TO BE USED OR REPRODUCED WITHOUT THEIR PERMISSION	
Decimal	Angular	Fractional	TITLE			
.00 ± .01	± 1/2°	± 1/32"	PARTS KIT S-CARRIAGE: HP IC 20LH			
.000 ± .005			REVISION	SURFACE AREA	DWG NO	
					1102784	
REMOVE ALL BURRS AND SHARP EDGES						

1099299 PARTS KIT

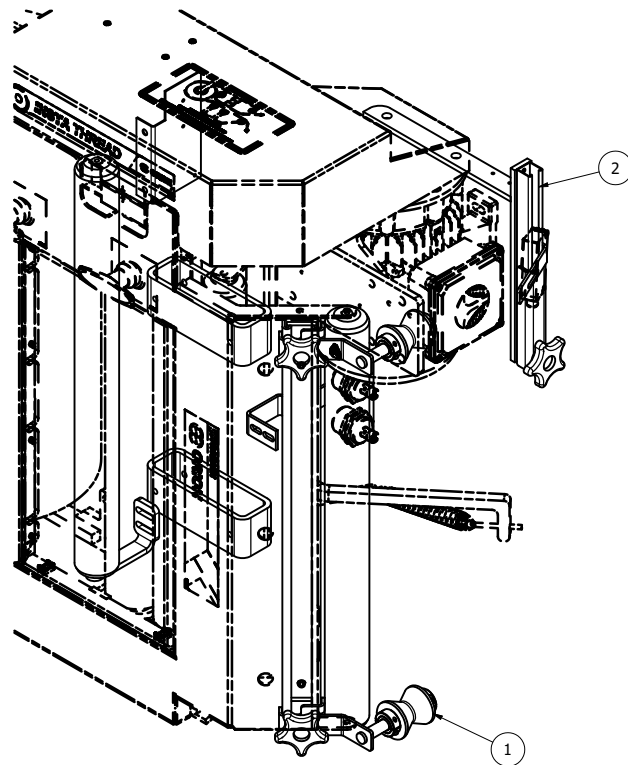
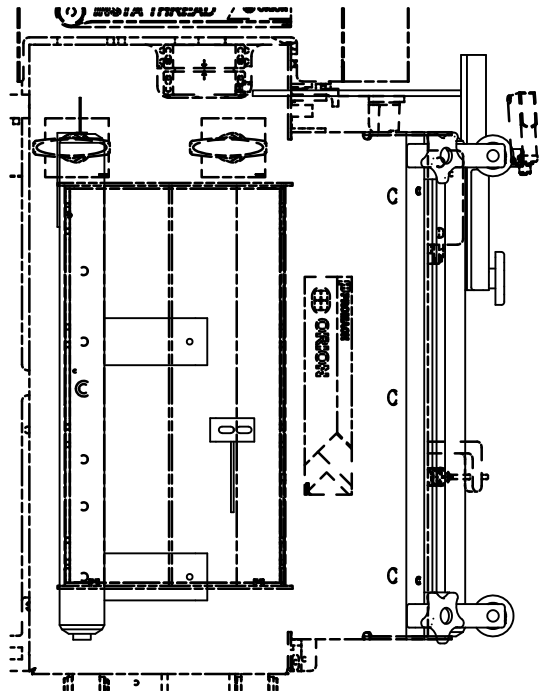
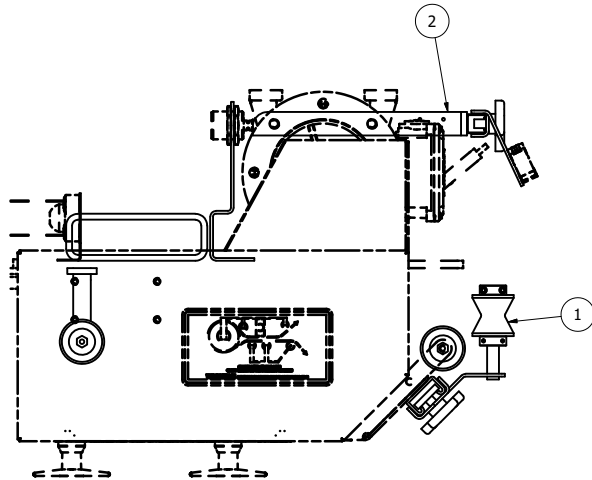


1099301 PARTS KIT

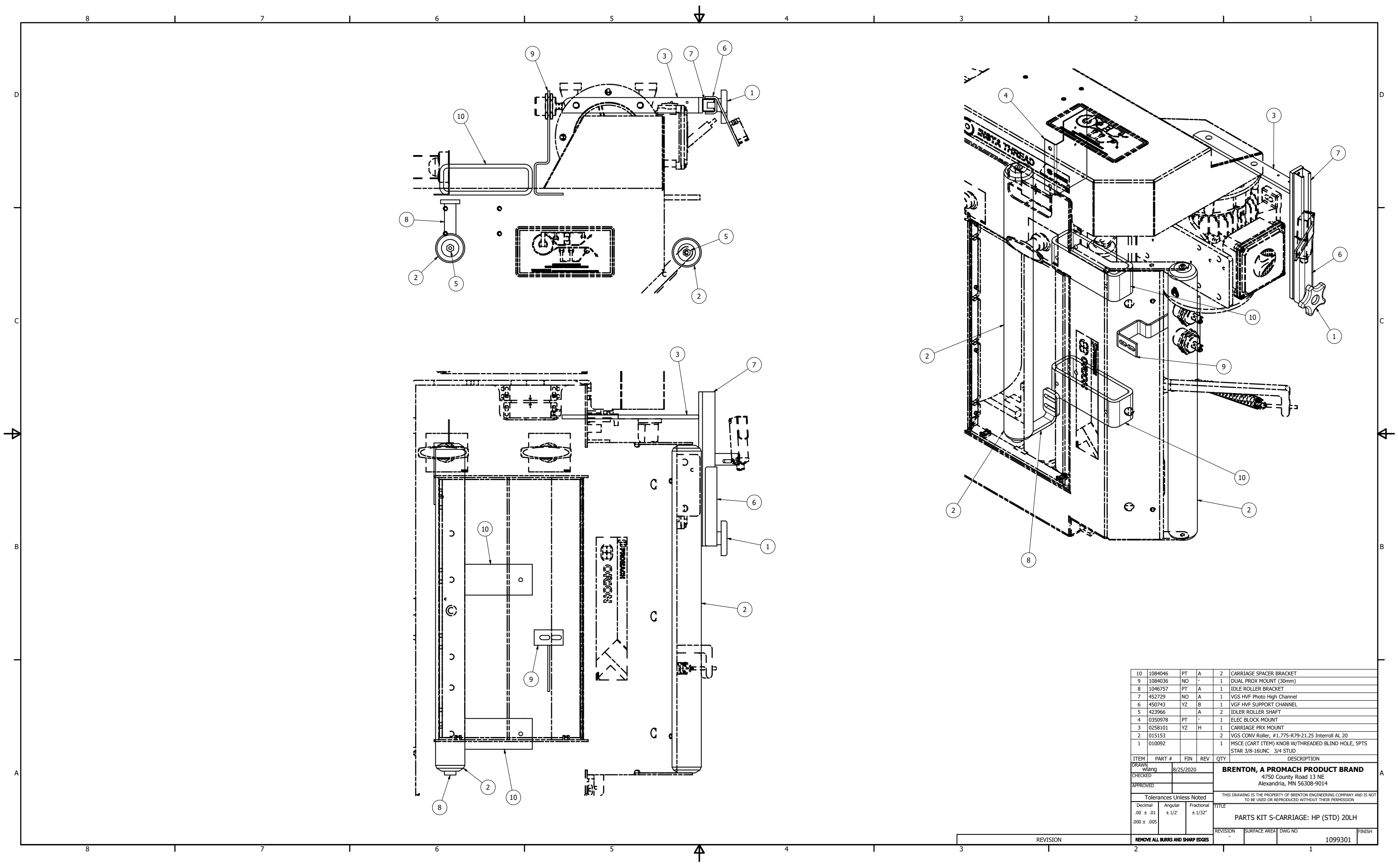


10	1084046	PT	A	2	CARRIAGE SPACER BRACKET
9	1084036	NO	-	1	DUAL PROX MOUNT (30mm)
8	1046757	PT	A	1	IDLE ROLLER BRACKET
7	452729	NO	A	1	VGS HVF Photo High Channel
6	450743	YZ	B	1	VGF HVF SUPPORT CHANNEL
5	423966		A	2	IDLER ROLLER SHAFT
4	0350978	PT	-	1	ELEC BLOCK MOUNT
3	0258101	YZ	H	1	CARRIAGE PRX MOUNT
2	015153			2	VGS CONV Roller, #1.775-R79-21.25 Interroll AL 20
1	010092			1	MSCE (CART ITEM) KNOB W/THREADED BLIND HOLE, 5PTS STAR 3/8-16UNC 3/4 STUD
ITEM	PART #	FIN	REV	QTY	DESCRIPTION

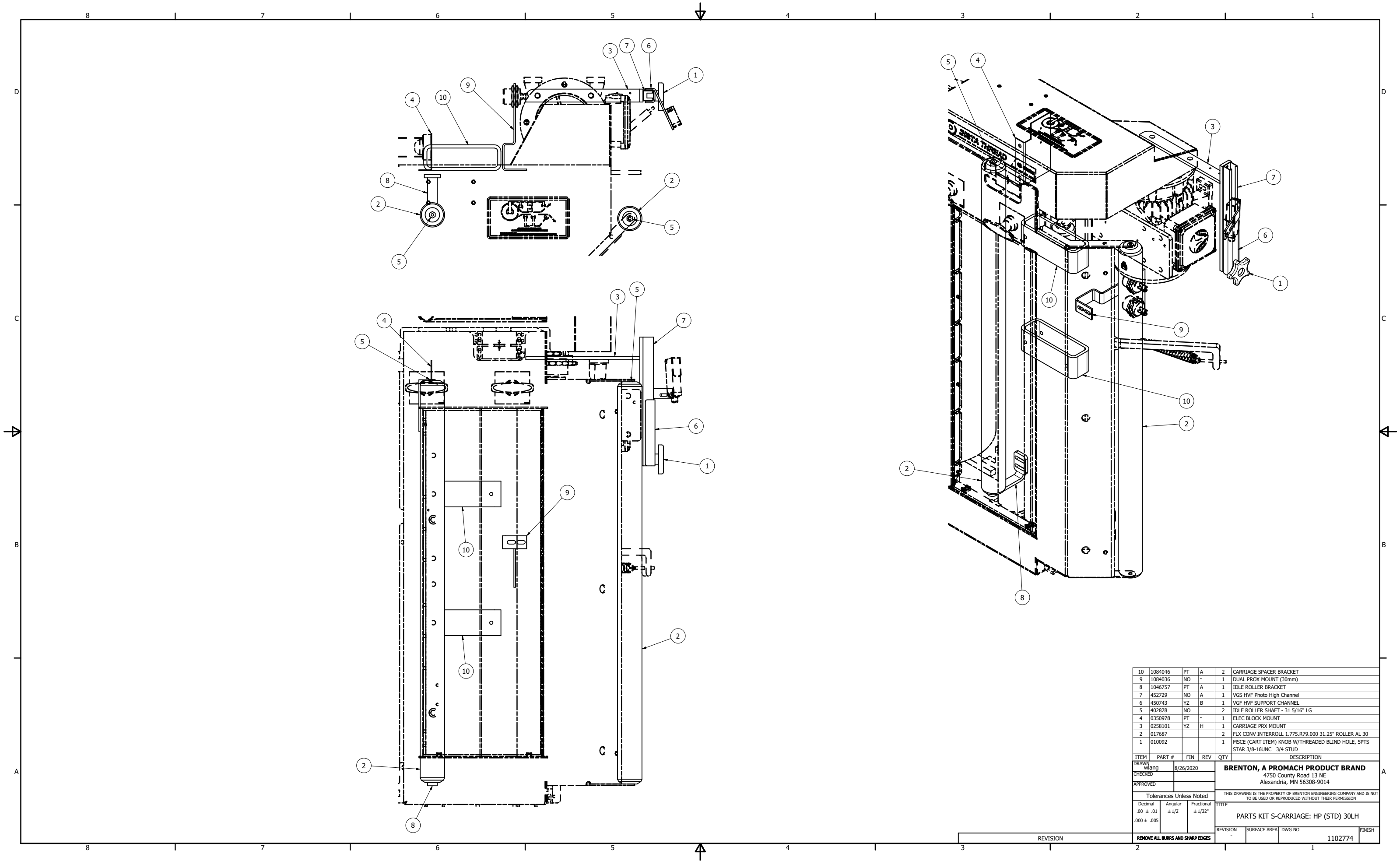
6	D0247113	YZ		2	HVA CHANNEL GUIDE
5	1087821	YZ	-	2	ROPING ROLLER BRACKET
4	0351161	NO		1	ROLLER CHANNEL
3	0303880	NO	A	2	ROPING ROLLER
2	094795			4	CPLG COLLARS & CPLS CCI-50-2-S0.50 SHAFT COLLAR
1	010092			2	MSCE (CART ITEM) KNOB W/THREADED BLIND HOLE, 5PTS STAR 3/8-16UNC 3/4 STUD
ITEM	PART #	FIN	REV	QTY	DESCRIPTION



2	1099301		-	1	PARTS KIT S-CARRIAGE: HP (STD) 20LH
1	1099299		-	1	PARTS KIT S-CARRIAGE: FLEX/RT MR/SW ROLLERS 20LH
ITEM	PART #	FIN	REV	QTY	DESCRIPTION
DRAWN	Wiang		8/26/2020		
CHECKED					
APPROVED					
Tolerances Unless Noted			THIS DRAWING IS THE PROPERTY OF BRENTON ENGINEERING COMPANY AND IS NOT TO BE USED OR REPRODUCED WITHOUT THEIR PERMISSION		
Decimal .00 ± .01 .000 ± .005	Angular ± 1/2°	Fractional ± 1/32"	TITLE PARTS KIT S-CARRIAGE: HP MR 20LH		
REVISION	SURFACE AREA	DWG NO	1099254	FINISH	
REMOVE ALL BURRS AND SHARP EDGES					



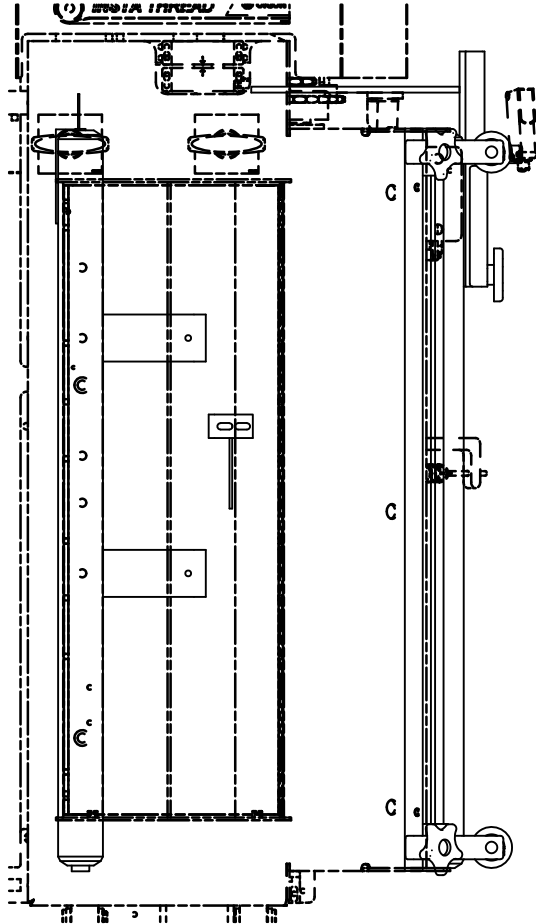
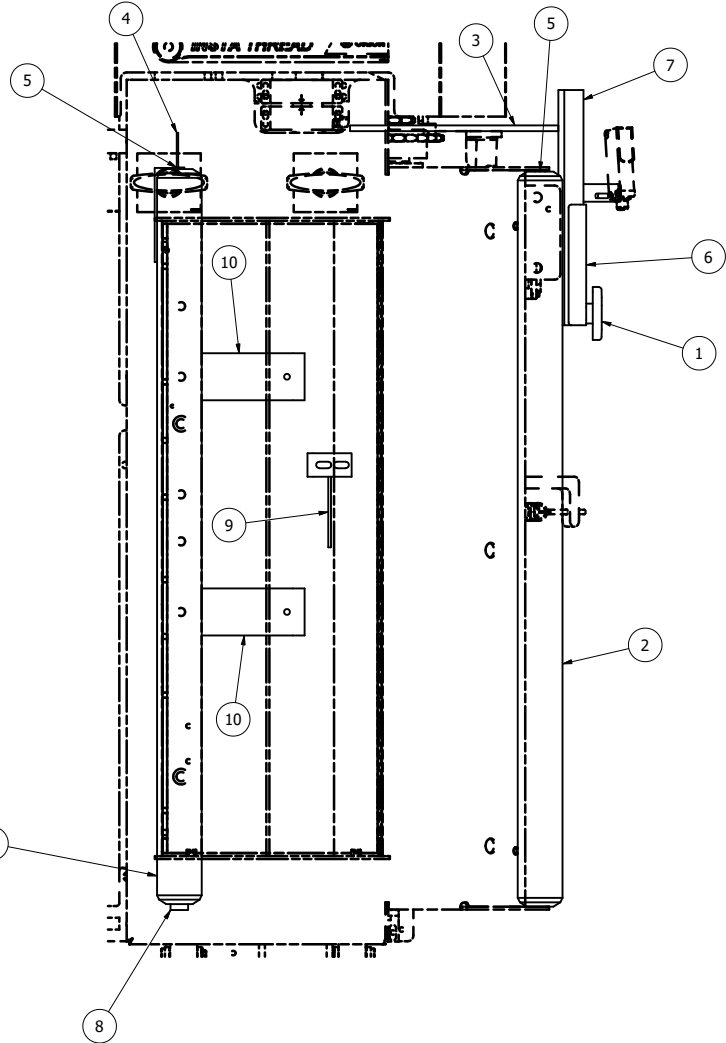
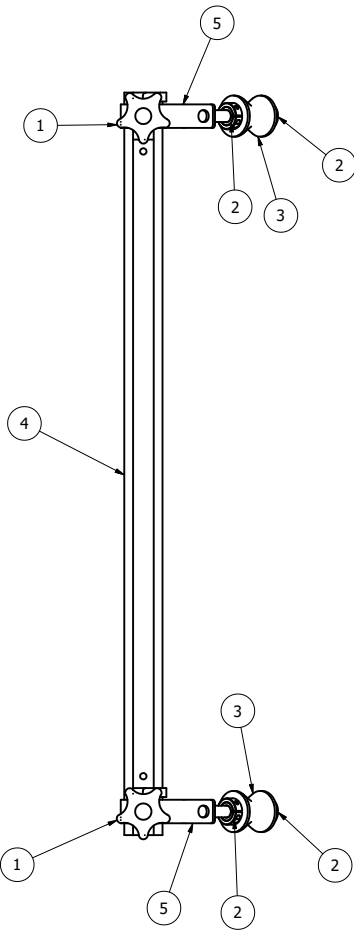
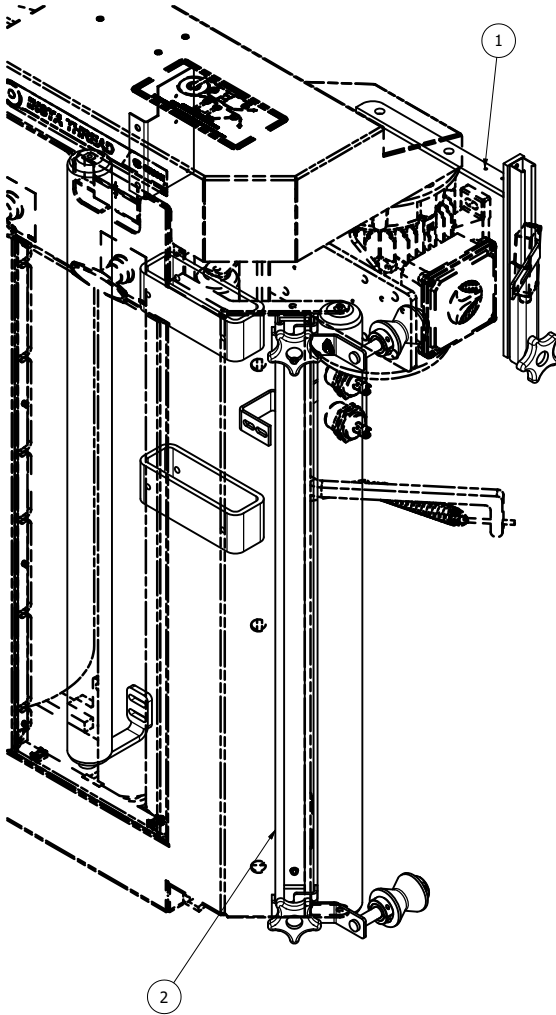
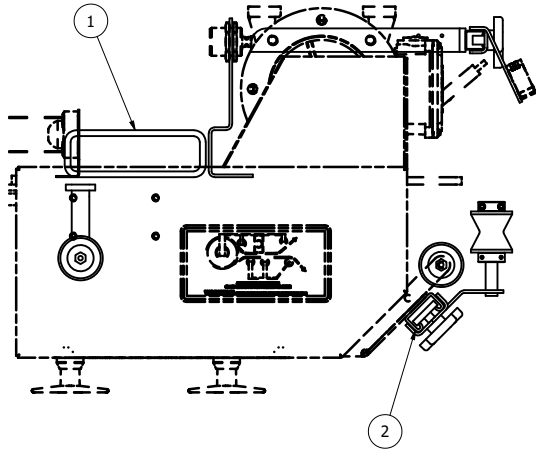
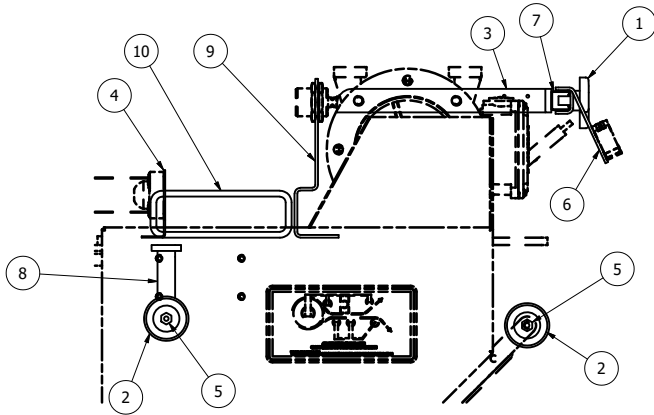
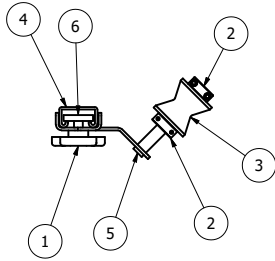
10	1084046	PT	A	2	CARRIAGE SPACER BRACKET
9	1084036	NO	-	1	DUAL PROX MOUNT (30mm)
8	1046757	PT	A	1	IDLE ROLLER BRACKET
7	452729	NO	A	1	VGS HVF Photo High Channel
6	450743	YZ	B	1	VGF HVF SUPPORT CHANNEL
5	423966		A	2	IDLER ROLLER SHAFT
4	0350978	PT	-	1	ELEC BLOCK MOUNT
3	0258101	YZ	H	1	CARRIAGE PRX MOUNT
2	015153			2	VGS CONV ROLLER, #1.775-R79-21.25 Interroll AL 20
1	010092			1	MSCE (CART ITEM) KNOB W/THREADED BLIND HOLE, SPTS STAR 3/8-16UNC 3/4 STUD
ITEM	PART #	FIN	REV	QTY	DESCRIPTION
DRAWN	Wiang	8/25/2020			BRENTON, A PROMACH PRODUCT BRAND 4750 County Road 13 NE Alexandria, MN 56308-9014
CHECKED					
APPROVED					
Tolerances Unless Noted					THIS DRAWING IS THE PROPERTY OF BRENTON ENGINEERING COMPANY AND IS NOT TO BE USED OR REPRODUCED WITHOUT THEIR PERMISSION
Decimal .00 ± .01 .000 ± .005	Angular ± 1/2°	Fractional ± 1/32"	TITLE		
			PARTS KIT S-CARRIAGE: HP (STD) 20LH		
REVISION					FINISH
REMOVE ALL BURRS AND SHARP EDGES					1099301



10	1084046	PT	A	2	CARRIAGE SPACER BRACKET
9	1084036	NO	-	1	DUAL PROX MOUNT (30mm)
8	1046757	PT	A	1	IDLE ROLLER BRACKET
7	452729	NO	A	1	VGS HVF Photo High Channel
6	450743	YZ	B	1	VGF HVF SUPPORT CHANNEL
5	402878	NO	-	2	IDLE ROLLER SHAFT - 31 5/16" LG
4	0350978	PT	-	1	ELEC BLOCK MOUNT
3	0258101	YZ	H	1	CARRIAGE PRX MOUNT
2	017687			2	FLX CONV INTERROLL 1.775.R79.000 31.25" ROLLER AL 30
1	010092			1	MSCE (CART ITEM) KNOB W/THREADED BLIND HOLE, 5PTS STAR 3/8-16UNC 3/4 STUD
ITEM	PART #	FIN	REV	QTY	DESCRIPTION
DRAWN	Wiang		8/26/2020		
CHECKED					
APPROVED					
Tolerances Unless Noted					THIS DRAWING IS THE PROPERTY OF BRENTON ENGINEERING COMPANY AND IS NOT TO BE USED OR REPRODUCED WITHOUT THEIR PERMISSION
Decimal	Angular	Fractional	TITLE		
.00 ± .01	± 1/2°	± 1/32"	PARTS KIT S-CARRIAGE: HP (STD) 30LH		
.000 ± .005					
REVISION		SURFACE AREA	DWG NO	FINISH	
REMOVE ALL BURRS AND SHARP EDGES			1102774		

1099259 PARTS KIT

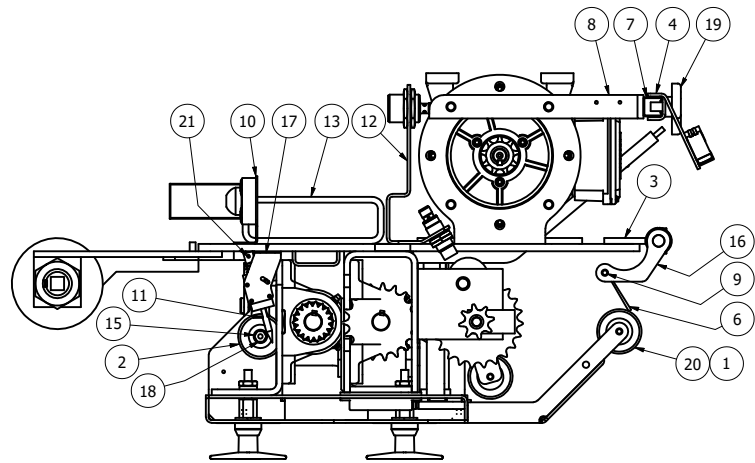
1102774 PARTS KIT



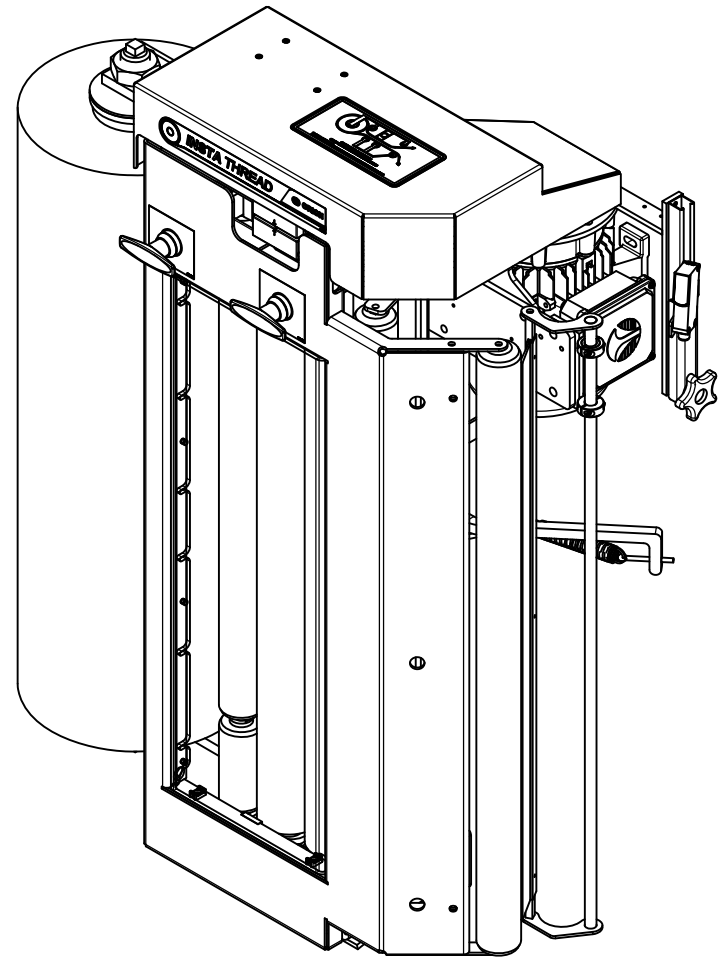
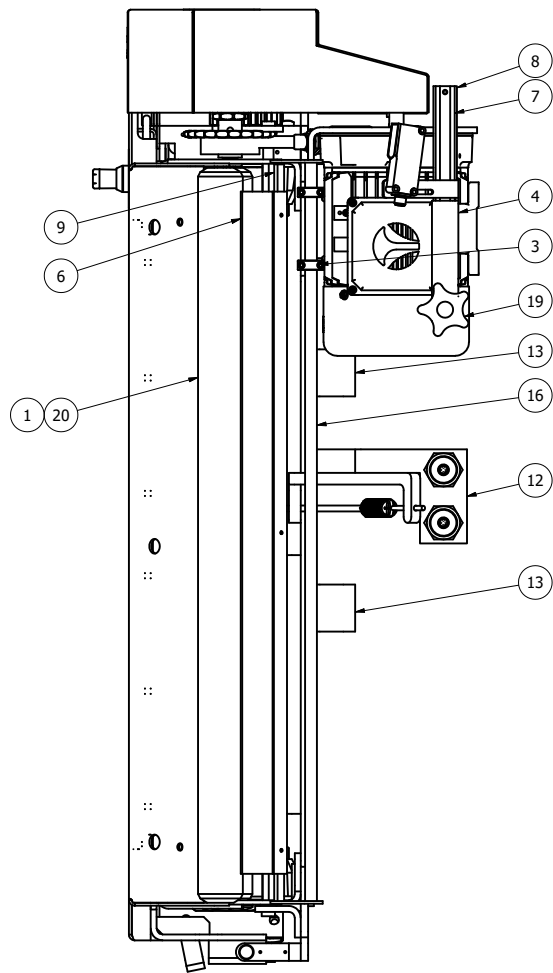
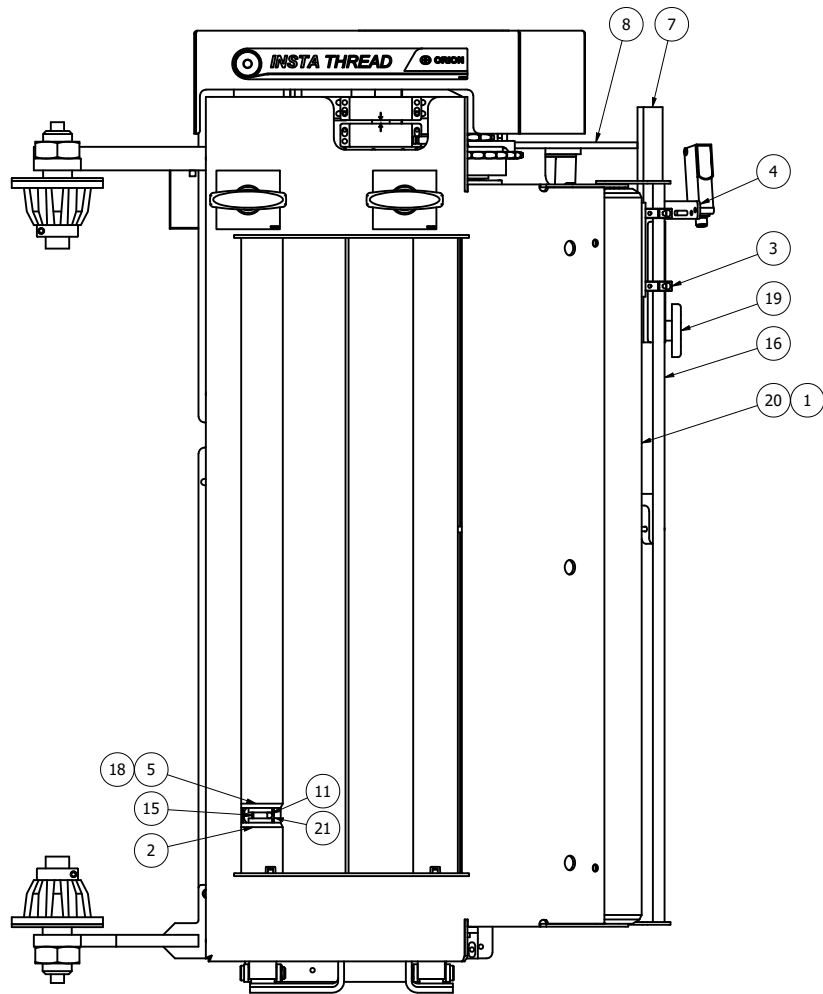
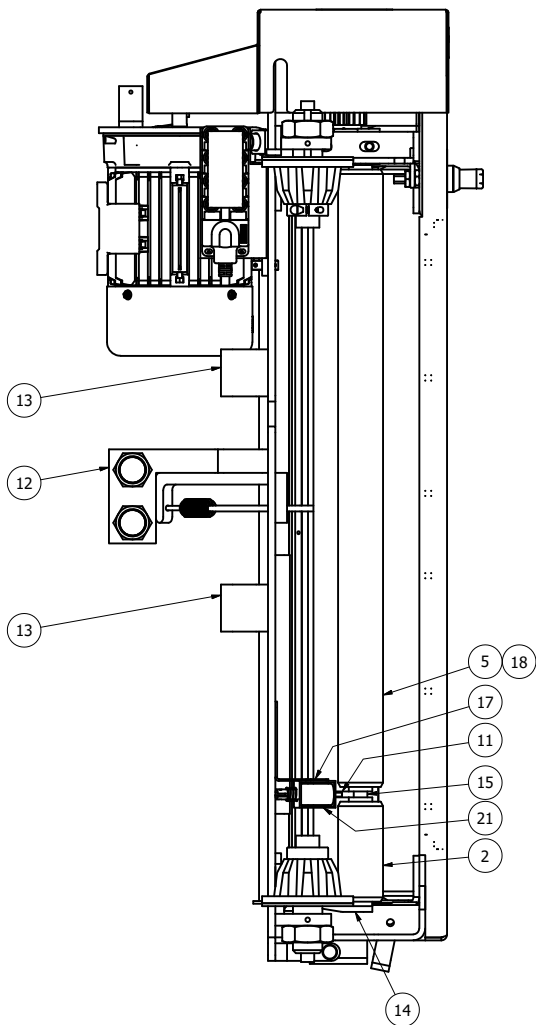
ITEM	PART #	FIN	REV	QTY	DESCRIPTION
6	D0247113	YZ		2	HVA CHANNEL GUIDE
5	1087821	YZ	-	2	ROPING ROLLER BRACKET
4	0351162	NO		1	ROLLER CHANNEL
3	0303880	NO	A	2	ROPING ROLLER
2	094795			4	CPLG COLLARS & CPLS CCI-50-2-S0.50 SHAFT COLLAR
1	010092			2	MSCE (CART ITEM) KNOB W/THREADED BLIND HOLE, 5PTS STAR 3/8-16UNC 3/4 STUD

ITEM	PART #	FIN	REV	QTY	DESCRIPTION
10	1084046	PT	A	2	CARRIAGE SPACER BRACKET
9	1084036	NO	-	1	DUAL PROX MOUNT (30mm)
8	1046757	PT	A	1	IDLE ROLLER BRACKET
7	452729	NO	A	1	VGS HVF Photo High Channel
6	450743	YZ	B	1	VGF HVF SUPPORT CHANNEL
5	402878	NO		2	IDLE ROLLER SHAFT - 31 5/16" LG
4	0350978	PT	-	1	ELEC BLOCK MOUNT
3	0258101	YZ	H	1	CARRIAGE PRX MOUNT
2	017687			2	FLX CONV INTERROLL 1.775.R79.000 31.25" ROLLER AL 30
1	010092			1	MSCE (CART ITEM) KNOB W/THREADED BLIND HOLE, 5PTS STAR 3/8-16UNC 3/4 STUD

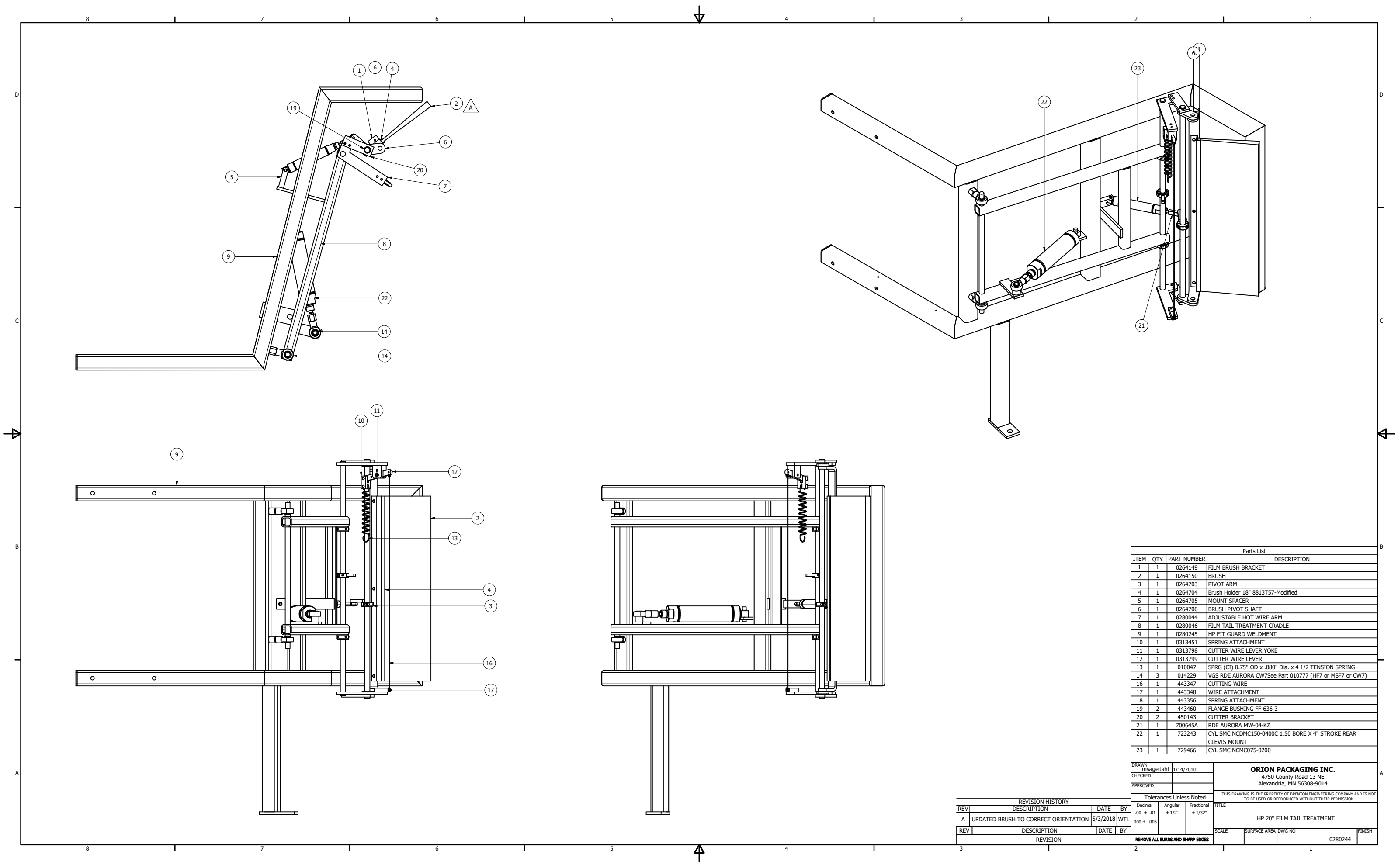
2	1099259		-	1	PARTS KIT S-CARRIAGE: RT/HP MR 30LH
1	1102774		-	1	PARTS KIT S-CARRIAGE: HP (STD) 30LH
ITEM	PART #	FIN	REV	QTY	DESCRIPTION
DRAWN	Wiang	8/26/2020		BRENTON, A PROMACH PRODUCT BRAND 4750 County Road 13 NE Alexandria, MN 56308-9014	
CHECKED					
APPROVED					
Tolerances Unless Noted				THIS DRAWING IS THE PROPERTY OF BRENTON ENGINEERING COMPANY AND IS NOT TO BE USED OR REPRODUCED WITHOUT THEIR PERMISSION	
Decimal .00 ± .01 .000 ± .005	Angular ± 1/2"	Fractional ± 1/32"		TITLE PARTS KIT S-CARRIAGE: HP MR 30LH	
REMOVE ALL BURRS AND SHARP EDGES				REVISION	FINISH
				SURFACE AREA	DWG NO 1102775



SOME COMPONENTS HIDDEN
FOR CLARITY IN THIS VIEW



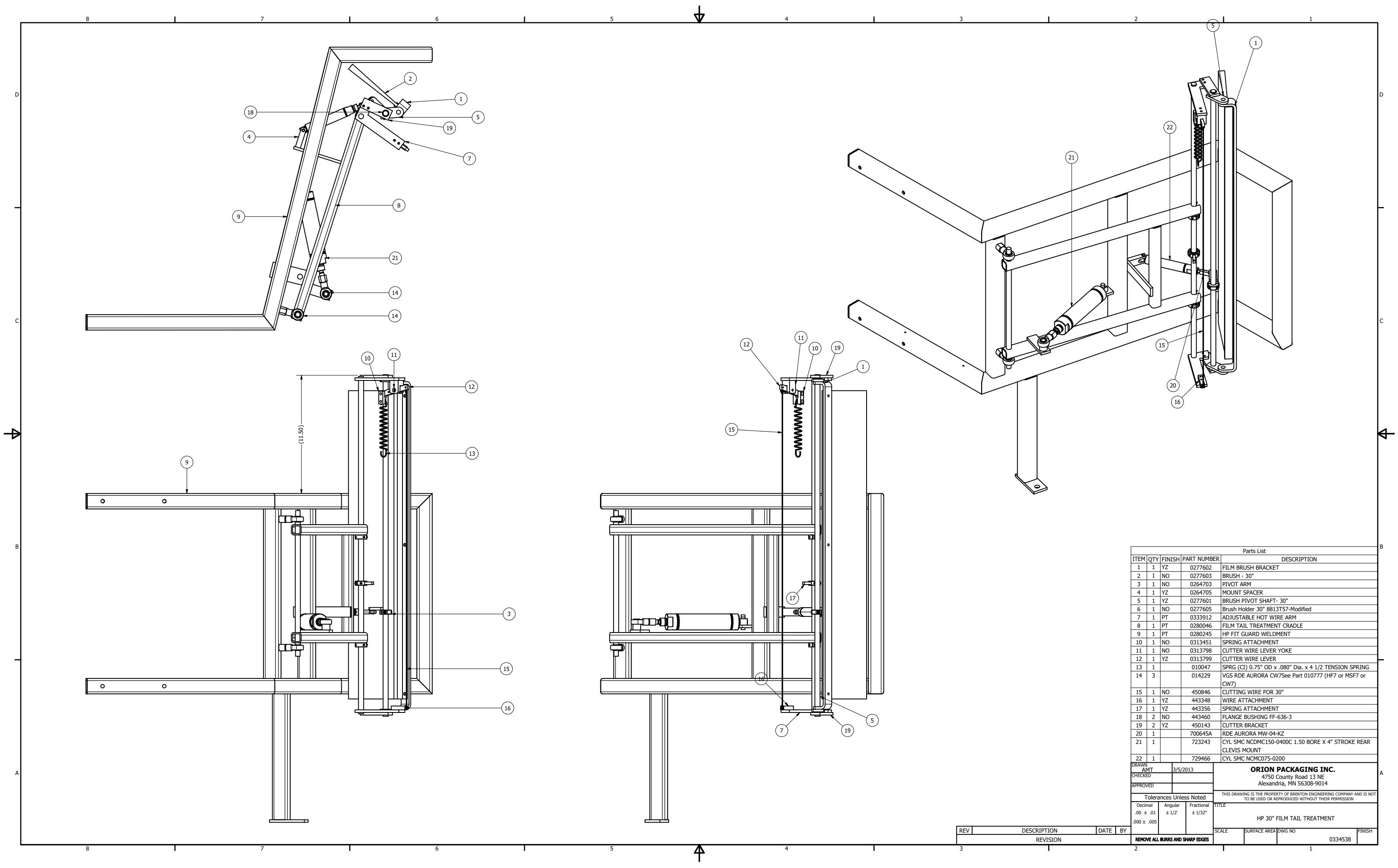
21	743094			1	ACT ADAFRUIT 413 LARGE PUSH-PULL SOLENOID			
20	017687			1	FLX CONV INTERROLL 1.775.R79.000 31.25" ROLLER AL 30			
19	010092			1	MSCE (CART ITEM) KNOB W/THREADED BLIND HOLE, 5PTS STAR 3/8-16UNC 3/4 STUD			
18	1102828	NO	-	1	IDLE ROLLER SHAFT			
17	1102827	PT	-	1	SOLENOID MNT BRACKET			
16	1102826	YZ	-	1	30" INSTA CUT BRUSH MOUNT			
15	1102759	NO	-	1	SPACER ROUND 0.25 0.58 0.515 SS			
14	1099248	PT	A	1	IDLE ROLLER BRACKET			
13	1084046	PT	A	2	CARRIAGE SPACER BRACKET			
12	1084036	NO	-	1	DUAL PROX MOUNT (30mm)			
11	0390350	NO	-	1	PUNCHING PIN			
10	0350978	PT	-	1	ELEC BLOCK MOUNT			
9	0277059	YZ	-	1	30" INSTA CUT ROTATING BRUSH MOUNT			
8	0258101	YZ	H	1	CARRIAGE PRX MOUNT			
7	452729	NO	A	1	VGS HVF Photo High Channel			
6	452087	NO	-	1	BRUSH ASSY - 30" CARRIAGE			
5	452084			1	IDLE ROLLER - 1.9 DIA X 26 5/8			
4	450743	YZ	B	1	VGF HVF SUPPORT CHANNEL			
3	443416	YZ	-	1	ADJUSTED ROLLER HOLDER-1			
2	421884	NO	-	1	IDLE ROLLER - 1.9 DIA X 4 5/8			
1	402878	NO	-	1	IDLE ROLLER SHAFT - 31 5/16" LG			
ITEM	PART #	FIN	REV	QTY	DESCRIPTION			
DRAWN	kschmitz	9/9/2020	BRENTON, A PROMACH PRODUCT BRAND 4750 County Road 13 NE Alexandria, MN 56308-9014					
CHECKED								
APPROVED								
Tolerances Unless Noted			THIS DRAWING IS THE PROPERTY OF BRENTON ENGINEERING COMPANY AND IS NOT TO BE USED OR REPRODUCED WITHOUT THEIR PERMISSION					
Decimal	Angular	Fractional				TITLE		
.00 ± .01	± 1/2°	± 1/32"						
.000 ± .005			PARTS KIT S-CARRIAGE: HP IC 30LH					
REMOVE ALL BURRS AND SHARP EDGES			REVISION	SURFACE AREA	DWG NO	FINISH		
					1102788			



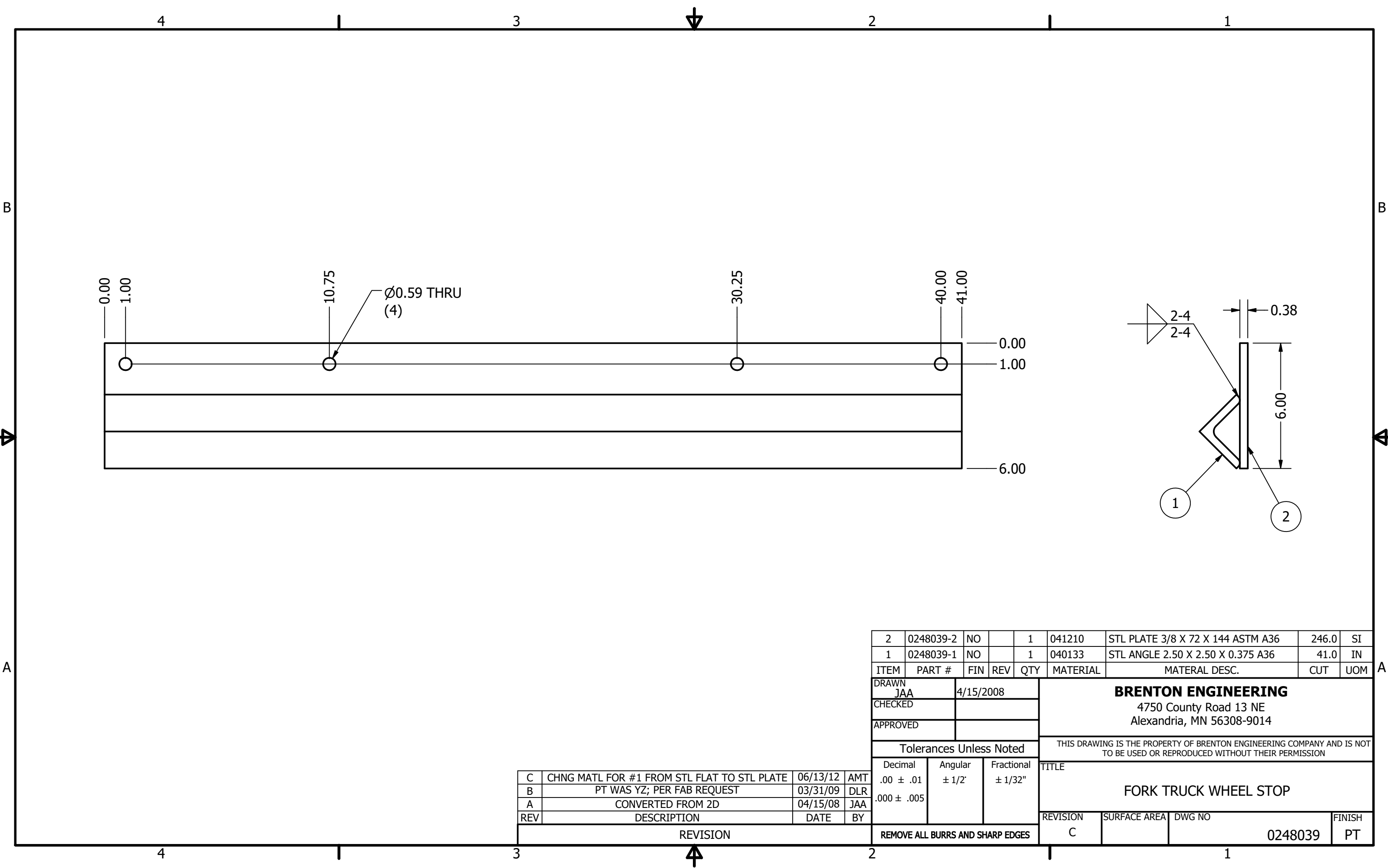
Parts List				
ITEM	QTY	PART NUMBER	DESCRIPTION	
1	1	0264149	FILM BRUSH BRACKET	
2	1	0264150	BRUSH	
3	1	0264703	PIVOT ARM	
4	1	0264704	Brush Holder 18" 8813T57-Modified	
5	1	0264705	MOUNT SPACER	
6	1	0264706	BRUSH PIVOT SHAFT	
7	1	0280044	ADJUSTABLE HOT WIRE ARM	
8	1	0280046	FILM TAIL TREATMENT CRADLE	
9	1	0280245	HP FIT GUARD WELDMENT	
10	1	0313451	SPRING ATTACHMENT	
11	1	0313798	CUTTER WIRE LEVER YOKE	
12	1	0313799	CUTTER WIRE LEVER	
13	1	010047	SPRG (CI) 0.75" OD x .080" Dia. x 4 1/2 TENSION SPRING	
14	3	014229	VGS RDE AURORA CW7See Part 010777 (HF7 or MSF7 or CW7)	
16	1	443347	CUTTING WIRE	
17	1	443348	WIRE ATTACHMENT	
18	1	443356	SPRING ATTACHMENT	
19	2	443460	FLANGE BUSHING FF-636-3	
20	2	450143	CUTTER BRACKET	
21	1	700645A	RDE AURORA MW-04-KZ	
22	1	723243	CYL SMC NCDMC150-0400C 1.50 BORE X 4" STROKE REAR CLEVIS MOUNT	
23	1	729466	CYL SMC NCMC075-0200	

REVISION HISTORY			
REV	DESCRIPTION	DATE	BY
A	UPDATED BRUSH TO CORRECT ORIENTATION	5/3/2018	WTL
REV	DESCRIPTION	DATE	BY
REVISION			

DRAWN ITSagedahl	1/14/2010	ORION PACKAGING INC. 4750 County Road 13 NE Alexandria, MN 56308-9014	
CHECKED			
APPROVED			
Tolerances Unless Noted		THIS DRAWING IS THE PROPERTY OF BRENTON ENGINEERING COMPANY AND IS NOT TO BE USED OR REPRODUCED WITHOUT THEIR PERMISSION	
Decimal .00 ± .01 .000 ± .005	Angular ± 1/2°	Fractional ± 1/32"	TITLE HP 20" FILM TAIL TREATMENT
SCALE		SURFACE AREA	DWG NO 0280244
REMOVE ALL BURRS AND SHARP EDGES			FINISH



Parts List				
ITEM	QTY	FINISH	PART NUMBER	DESCRIPTION
1	1	YZ	0277602	FILM BRUSH BRACKET
2	1	NO	0277603	BRUSH - 30"
3	1	NO	0264703	PIVOT ARM
4	1	YZ	0264705	MOUNT SPACER
5	1	YZ	0277601	BRUSH PIVOT SHAFT- 30"
6	1	NO	0277605	Brush Holder 30" 8813T57-Modified
7	1	PT	0333912	ADJUSTABLE HOT WIRE ARM
8	1	PT	0280046	FILM TAIL TREATMENT CRADLE
9	1	PT	0280245	HP FIT GUARD WELDMENT
10	1	NO	0313451	SPRING ATTACHMENT
11	1	NO	0313798	CUTTER WIRE LEVER YOKE
12	1	YZ	0313799	CUTTER WIRE LEVER
13	1		010047	SPRG (CI) 0.75" OD x .080" Dia. x 4 1/2 TENSION SPRING
14	3		014229	VGS RDE AURORA CW7See Part 010777 (HF7 or MSF7 or CW7)
15	1	NO	450846	CUTTING WIRE FOR 30"
16	1	YZ	443348	WIRE ATTACHMENT
17	1	YZ	443356	SPRING ATTACHMENT
18	2	NO	443460	FLANGE BUSHING FF-636-3
19	2	YZ	450143	CUTTER BRACKET
20	1		700645A	RDE AURORA MW-04-KZ
21	1		723243	CYL SMC NCDMC150-0400C 1.50 BORE X 4" STROKE REAR CLEVIS MOUNT
22	1		729466	CYL SMC NCMC075-0200
DRAWN		3/5/2013		ORION PACKAGING INC. 4750 County Road 13 NE Alexandria, MN 56308-9014
AMT				
CHECKED				
APPROVED				THIS DRAWING IS THE PROPERTY OF BRENTON ENGINEERING COMPANY AND IS NOT TO BE USED OR REPRODUCED WITHOUT THEIR PERMISSION
Tolerances Unless Noted				
Decimal .00 ± .01 .000 ± .005	Angular ± 1/2°	Fractional ± 1/32"	TITLE HP 30" FILM TAIL TREATMENT	
SCALE		SURFACE AREA DWG NO		FINISH
REMOVE ALL BURRS AND SHARP EDGES				0334538



C	CHNG MATL FOR #1 FROM STL FLAT TO STL PLATE	06/13/12	AMT
B	PT WAS YZ; PER FAB REQUEST	03/31/09	DLR
A	CONVERTED FROM 2D	04/15/08	JAA
REV	DESCRIPTION	DATE	BY

2	0248039-2	NO		1	041210	STL PLATE 3/8 X 72 X 144 ASTM A36	246.0	SI
1	0248039-1	NO		1	040133	STL ANGLE 2.50 X 2.50 X 0.375 A36	41.0	IN
ITEM	PART #	FIN	REV	QTY	MATERIAL	MATERAL DESC.	CUT	UOM
DRAWN JAA		4/15/2008			BRENTON ENGINEERING 4750 County Road 13 NE Alexandria, MN 56308-9014			
CHECKED								
APPROVED								
Tolerances Unless Noted					THIS DRAWING IS THE PROPERTY OF BRENTON ENGINEERING COMPANY AND IS NOT TO BE USED OR REPRODUCED WITHOUT THEIR PERMISSION			
Decimal .00 ± .01 .000 ± .005		Angular ± 1/2'		Fractional ± 1/32"	TITLE FORK TRUCK WHEEL STOP			
					REVISION C	SURFACE AREA	DWG NO 0248039	FINISH PT