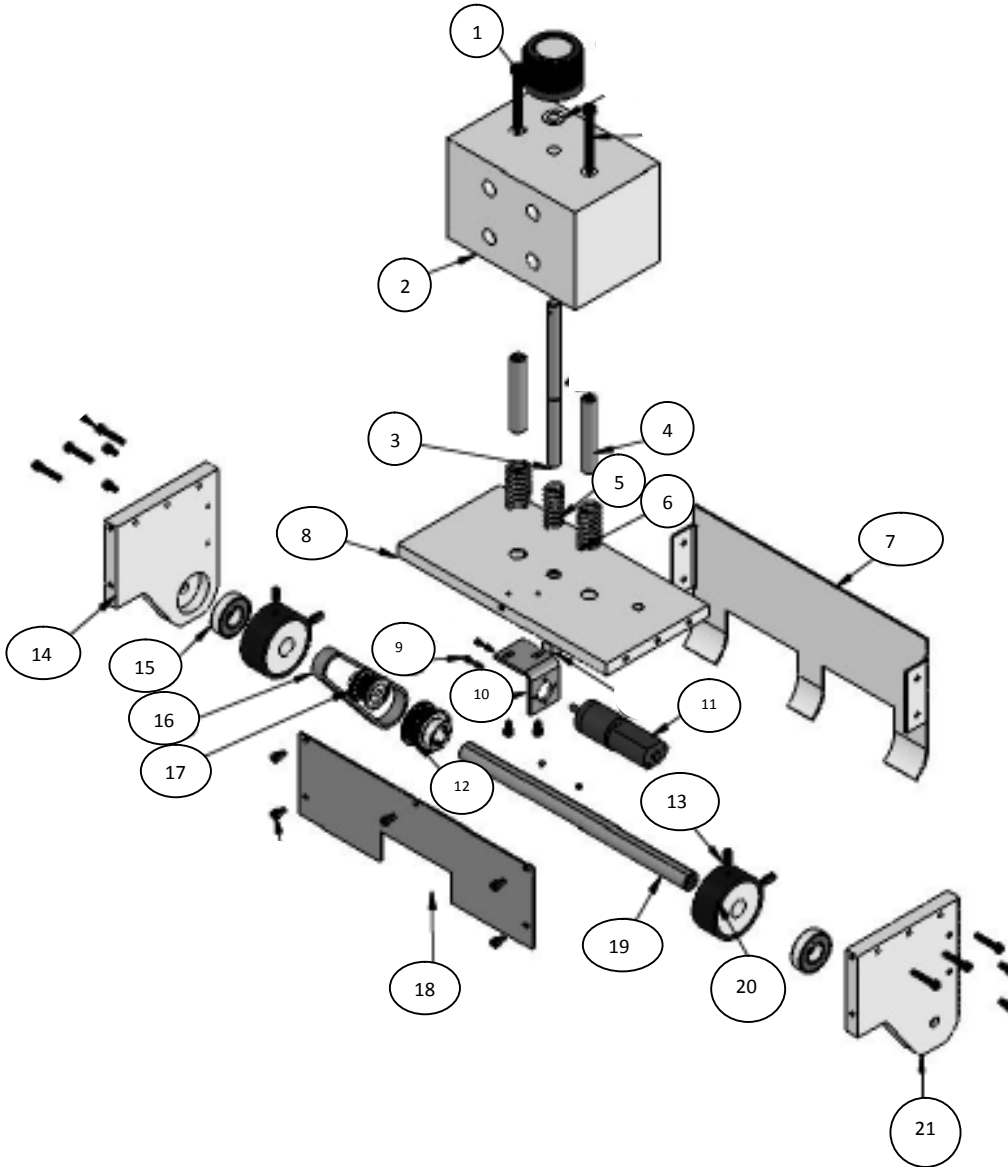




PARTS GUIDE
XM-SERIES FRICTION FEEDERS
XM-1, XM-21
(December 2009)



SEPARATOR ASSEMBLY





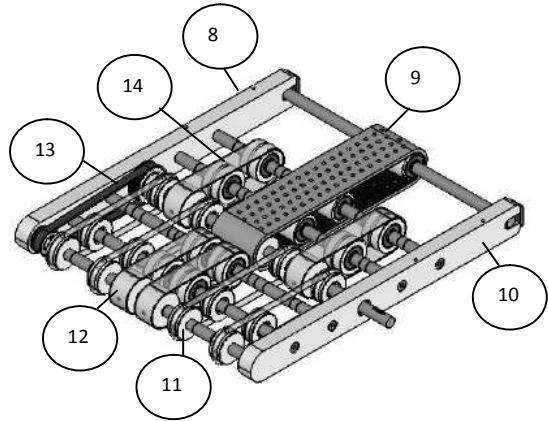
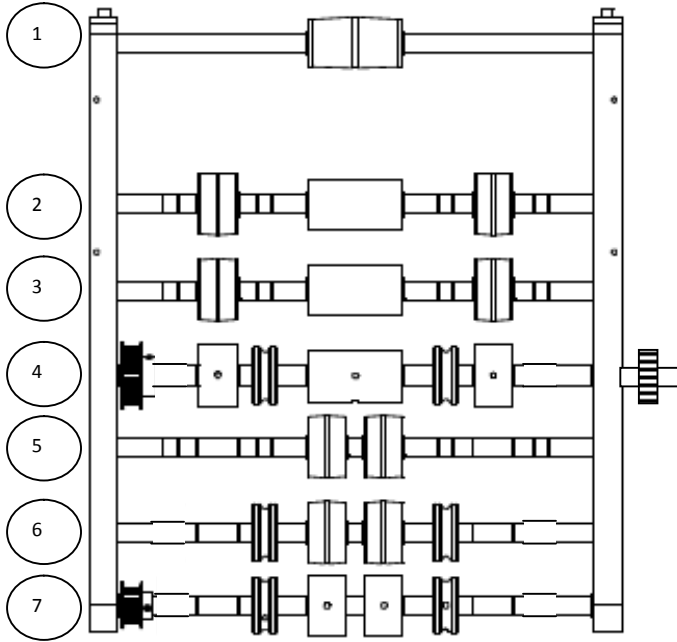
SEPARATOR ASSEMBLY

Note: if column for XM-21 is blank, use part number from XM-1 column

Item	Description	XM-1	XM-21
1	Knob, 5/16-18 threaded thru w/ set screws	100173	
2	Separator Mount Block	100170	
3	Threaded adjusting rod 5/16-18	100182	
4	Dowel Pin	100177	
5	Center spring	100184	
6	Outside spring	100372	
7	Separator Pregate plate	100169	
8	Separator top plate	100166	
9	SHCS M2.4x5	MSHC 25.4	
10	Separator Motor Mount Bracket	100180A	
11	Separator Motor 12VDC	100163A	
12	Aluminum Timing Pulley 16XL037, .500 bore	100194	
13	Set Screw Soft Tip 10/32 x 3/8	SSSNT 102 0038	
14	Separator right side plate	100167	
15	R8 Bearing	100141	
16	Belt 86XL037	100187	
17	Aluminum Timing Pulley 10XL037, 6mm bore	100198A	
18	Separator Front Cover Plate	100165	
19	Separator Drive Shaft	100174	
20	Separator Roller, Blue 68 Shore A	100172	
21	Separator left side plate	100168	
Not Shown	M8 Bulk Head Connector	100428	
Not Shown	M8 quick disconnect cable	100429	
Not Shown	Separator Label Kit	100430	



CARRIAGE ASSEMBLY





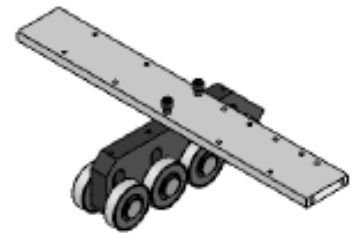
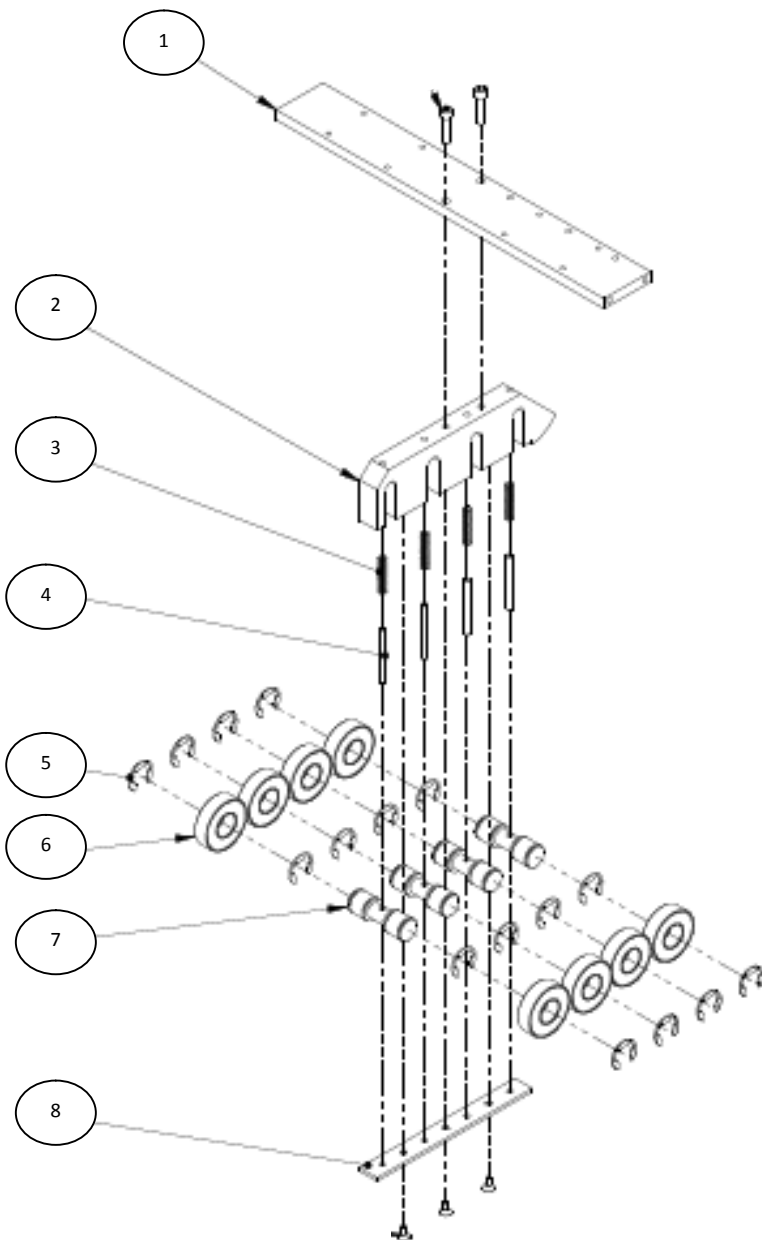
CARRIAGE ASSEMBLY

Note: if column for XM-21 is blank, use part number from XM-1 column

Item	Description	XM-1	XM-21
1	Rear Idler Shaft	100142	
	Crowned Idler Pulley Long	100149	
	R8 Bearing	100141	
	Tension plate	100161	
2 / 3	Idler Shaft (Feed Section)	100139	
	Crowned Idler Pulley Short	100148	
	Flat Idler Pulley Long	100150	
	R8 Bearing	100141	
4	Main Drive Shaft (Thompson Hardened SST)	100231	
	Aluminum Timing Pulley 24XL037, .500 bore (speed up)	100195	
	Idler Pulley O-Ring	100144	
	R8 Bearing	100141	
	Flat Drive Pulley Short (.500 bore)	100152	
	Flat Drive Pulley Long	100151	
	Aluminum Timing Pulley 20XL037, .500 bore, keyed (Drive)	100245A	
5	Discharge Shaft, Rear	100139	
	Crowned Idler Pulley short	100148	
	R8 bearing	100141	
6	Discharge Shaft, Center	100139	
	Crowned Idler Pulley short	100148	
	R8 Bearing	100141	
	Idler Pulley O-Ring	100144	
7	Discharge Drive Shaft (.625)	100138	
	Aluminum timing pulley 15XL037, .500 bore, keyed	100543	
	R8 Bearing	100141	
	Drive Pulley, O-ring (.625 bore)	100191A	
	Flat Drive Pulley Short (.625 bore)	100152A	
8	Right Carriage Holder	100137	
9	Feed Belt	100157	
10	Left Carriage Holder	100136	
11	O-Ring	100156	
12	Discharge Belt	100159	
13	Timing Belt 160XL037	100196	
14	Idler Belt	100158	
Not Shown	Support Rail, Snap In	100439A	



HOLD DOWN ASSEMBLY





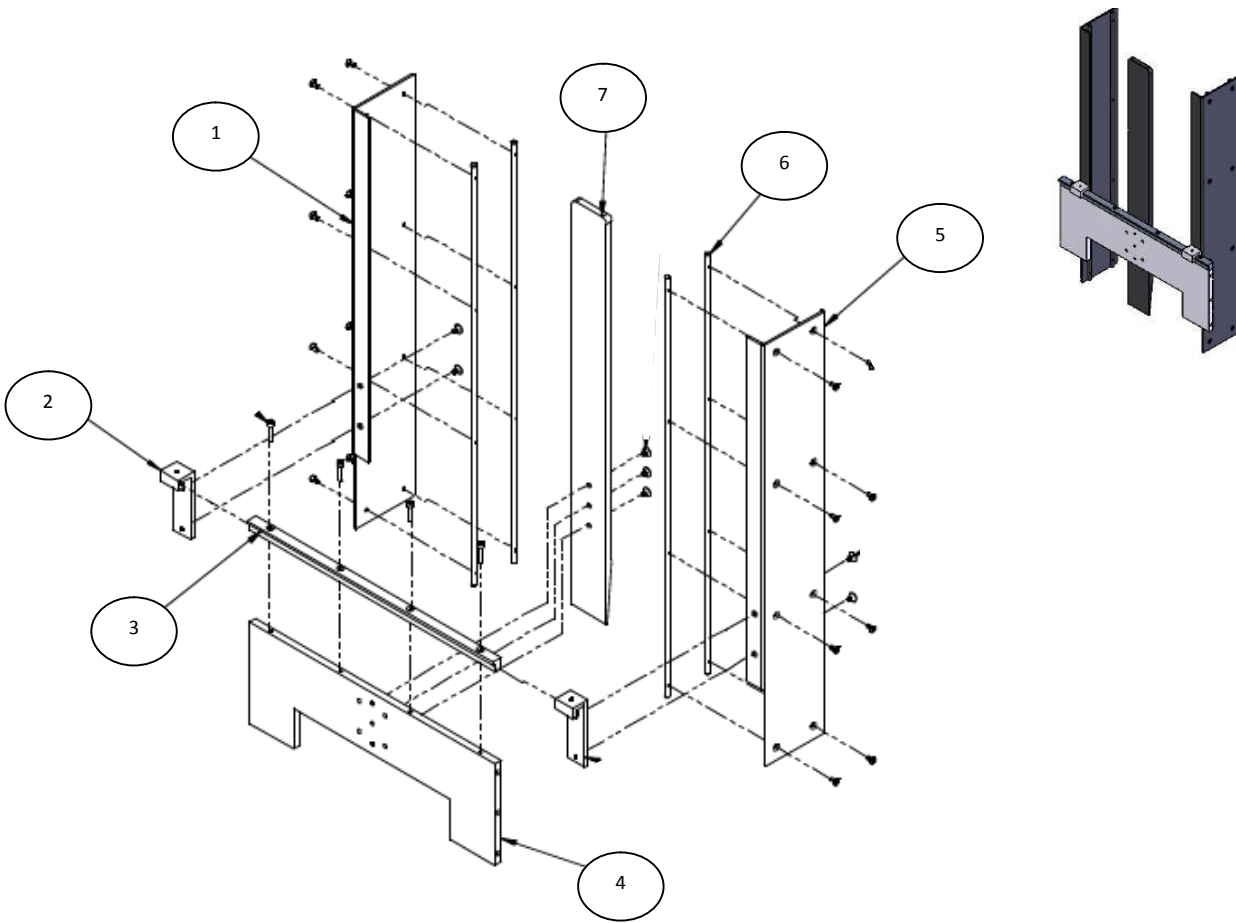
HOLD DOWN ASSEMBLY

Note: if column for XM-21 is blank, use part number from XM-1 column

Item	Description	XM-1	XM-21
1	Crossbar	100213	
2	Main Block	100208	
3	Spring .25 x 1.25	100212	
4	Pin, Spring 3/16 x 2	100211	
5	E-Clip 3/4	E Clip 3/4	
6	Bearing 1.75 OD / .75 ID	100214	
7	Axel Shaft	100209	
8	Retainer Plate	100216	
Not Shown	Warning Label	100375	
Not Shown	Knob 10/32 x 1/2 (Sheet Sensor)	100391	
Not Shown	Sheet Sensor Adjust Bracket	100259	
Not Shown	Sheet Sensor Mount	100260	100260A
Not Shown	NPN Sheet Sensor	100387	100387A
Not Shown	M12 Quick Disconnect Cable (sheet sensor)	100389	
Not Shown	M8 Quick Disconnect Cable (sheet sensor)		100429
Not Shown	Deflector Mount	100565	
Not Shown	Deflector Plate (narrow)	100566	
Not Shown	Deflector Plate (wide)		100566A
Not Shown	Knob 10/32 x 3/8 (deflector)	100619	



HOPPER ASSEMBLY





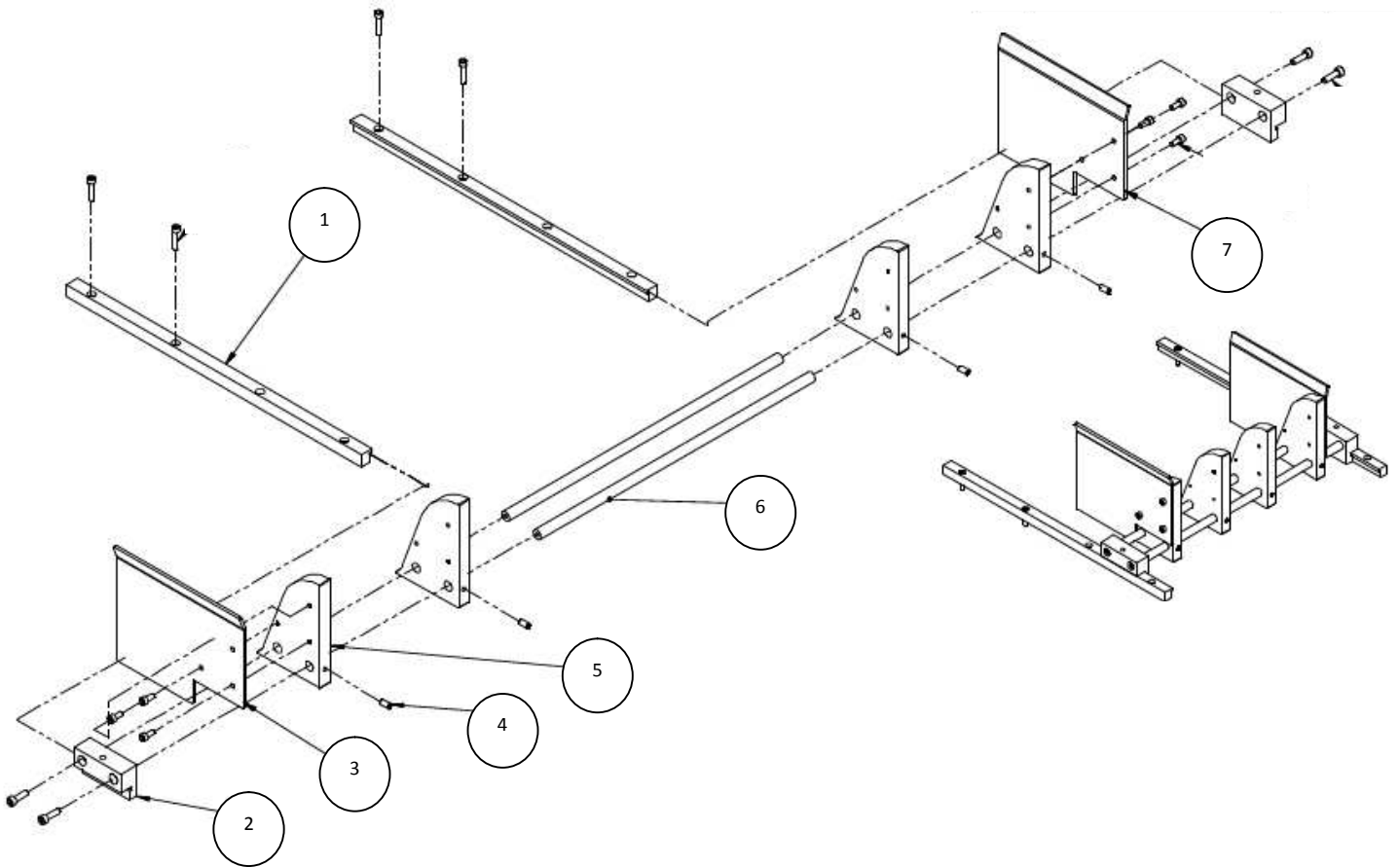
HOPPER ASSEMBLY

Note: if column for XM-21 is blank, use part number from XM-1 column

Item	Description	XM-1	XM-21
1	Right Side Guide	100204	
2	Side Guide Clamp	100203	
3	Rail	100202	
4	Cross Mount Plate	100199	
5	Left Side Guide	100205	
6	Insert Rod	100233	
7	Center Plate	100201	
Not Shown	Shim Plate for Center Plate	SHIM	
Not Shown	Adjustable Handle 10/32 x ½	100373	



WEDGE ASSEMBLY





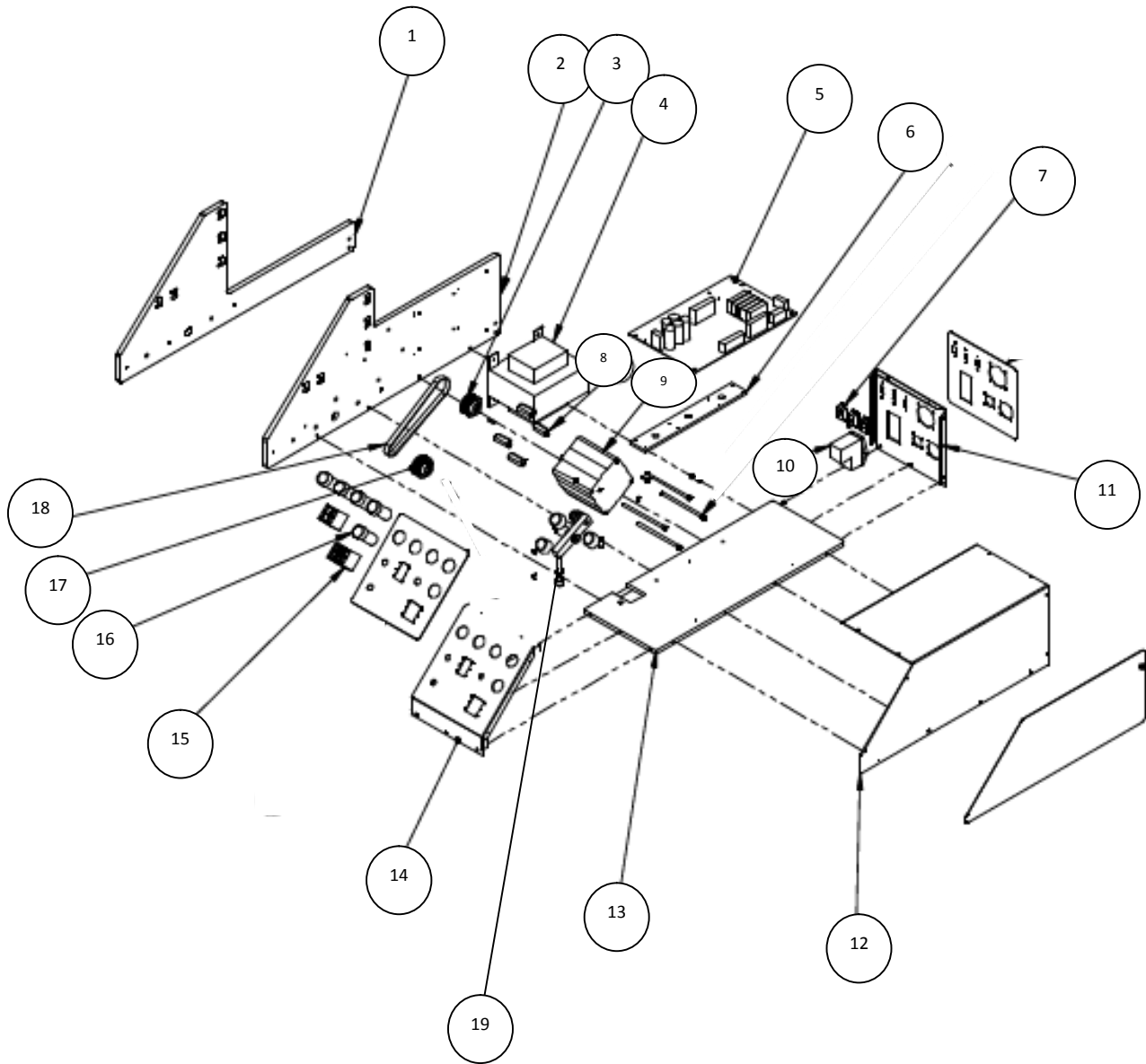
WEDGE ASSEMBLY

Note: if column for XM-21 is blank, use part number from XM-1 column

Item	Description	XM-1	XM-21
1	Rail	100202	
2	Slide Block	100221	
3	Wedge Guide Plate Left		100232
4	Set Screw 10/32 x 3/8	SSSNT 102 0038	
5	Wedge Block	100222	
6	Shaft, 3/8	100220	
7	Wedge Guide Plate Right		100235
Not Shown	Warning Label	100375	
Not Shown	Adjustable Handle 10/32 x 1	100523	
Not Shown	Spacer, Wedge handle	100536	
Not Shown	Set Screw 10/32 x 1.25	100537	
Not Shown	Set Screw 10/32 x .875	100618	
Not Shown	Roller Support Wedge Assembly	100894	
Not Shown	Small Product Wedge Extension Assembly	100449	



CHASSIS COMPONENTS





CHASSIS COMPONENTS

Note: if column for XM-21 is blank, use part number from XM-1 column

Item	Description	XM-1	XM-21
1	Right Side Plate	100225	
2	Left Side Plate	100224	
3	Pulley 20XL037 w/ keyway	100245A	
4	Transformer Assembly (includes connectors)	100405	
5	Control Board	100239-XM1	100239-XM21
6	Mount Bar, Control Board	100248	
7	Slide Switch	100242	
8	Hex Standoff	100237	
9	Drive Motor Stepper Assembly (includes connector)	100406	100406A
10	AC Inlet Module Fuse 6.25A / 250V / Slo-blo	100243 100424	
11	Rear Panel	100228	
12	Controls Cover	100229	
13	Chassis Plate	100226	
14	Front Panel	100227	
15	Thumbwheel, Single Screw Mount Thumbwheel, Single Snap In Mount	100241	100544
16	Knob, potentiometer	100407	
17	Pulley 20XL037 w/keyway	100245A	
18	Drive Belt 150XL037	100247	
19	Belt Tensioner Arm Tensioner Spacer Shoulder Bolt 3/8 x 1.5 – 5/16-18 thread Shoulder Bolt 3/8 x 5/8 – 5/16-18 thread R6 Bearing	100264 100263 100262 100265 100135	
Not Shown	Trigger Sensor Assembly (includes mounting)	100390	
Not Shown	Potentiometer (speed, trigger delay, EOB)	100418	
Not Shown	“Jog” pushbutton	100413	
Not Shown	“Cycle” pushbutton	100412	
Not Shown	“Reset” pushbutton “Reset” LED Base	100416 100417	
Not Shown	Ready Lamp Assembly Ready LED Base	100409 100410	
Not Shown	“Stop” pushbutton “Stop” LED Base	100414 100415	
Not Shown	N.O. Contact block w/ base (jog, cycle, reset)	100408	
Not Shown	N.C. Contact block w/ base (stop)	100404	
Not Shown	Power Cord	100431	