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(252 Series)



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WebPress
Revolutionary™

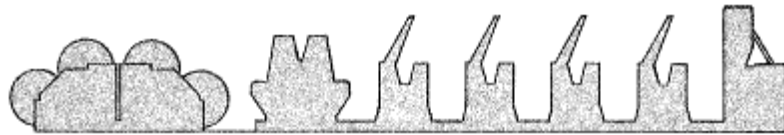
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P. O. Box 2274 | Tacoma, WA | 98401

701 East "D" Street | Tacoma, WA | 98421

Atlas



The illustrations showing the relative positions of significant parts, can be used to locate the part desired or, for older machines, to locate the part performing the same function. Reference to the parts list will provide the description.

When possible, please include with the parts order the number stamped on the broken or worn part. The number may not correspond exactly to the number in the catalog, but will be helpful in assuring that your order is filled correctly. If some frequently ordered parts for an older Atlas are numbered differently than in the illustration, please note in the catalog the appropriate part numbers so the information is readily available

NOTE: Illustrations have been photographically reduced, dimensions are not to scale.

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**ATLAS 22-3/4 SPECIFICATIONS
STANDARD & OPTIONAL EQUIPMENT**

ATLAS 22 3/4





Specifications		
Max full width web	36"	914mm
Min. full width web	18"	457mm
Nominal cutoff	22 3/4"	578mm
Image length	21 3/4"	552mm
Plate gap	3/16"	4.76mm
Plate size	24x36"	610x914mm
Plate thickness	.009"	.22mm
Blanket size	24 1/2x36"	622x914mm
Blanket thickness	.065"	1.65mm
1 st Ink form	2 3/4"	70mm
2 nd Ink form	2 7/8"	73mm
Water form	2 7/8"	73mm
Ink fountain capacity	12 lb	5.5kg
Running register ranges:		
Perfecting unit		
Sidelay, both sides	±.125"	3.175
Circumferential Both sides	±.100"	2.54
Quadra-Color unit		
Sidelay	±.125"	±3.175
Circumferential	±.100"	±2.54
Skewing	±.012"	±.3
Roll Sidelay	±.437"	±11mm
Speed	30,000 iph	
Folder	2:1 jaw	
Folder Capacity	10 webs	
Products	Broadsheet	Tabloid
	Options	Magazine
	Digest-2 off	
	Digest-1 off	
*Optional Image Length	22 1/8"	562mm

All specifications are for a 22 3/4" cutoff atlas press

Standard	Equipment
Brush dampener	Electric copy counter
Double-ended plate bender	Startup time delay and warning bell
Pin register, bender to cylinder	Water recirculator, factory installed
Factory supplied blankets, rollers	Quarter fold seam moistener
Hand wheels	Water stops
Full width platform	Lockable electric counter
Spare roll shaft and chucks	Anti-offset tape
Spare blankets	Floor lvl, pneumatic clutched
Asst. spare folder parts	Auto grease lubrication
Tachometer (i.p.h)	
Portable delivery table	

Optional	Equipment
Pneumatic throwoffs	Under and over folder leads
Stacked units	Extended delivery table
Unit washup device	Perforation
Fountain dividers	In-line
Swing units	Across the web
Cross-association leads	Ribbon shifters
Direct litho compensator	Air former
Aisle guards	Upper former
Control console	Angle bars
Web break detectors	Bindery paster
3/8" gap blanket lockups	Wiring harnesses
ASO spray bars	Digest size fold capability
Motorized remote roll sidelay	Two-off double digest
Air locking roll shafts	Standard double parallel
Twinned folders	

21 1/2" is optional.

# of Webs	Pages in: Broadsheet	 Tabloid	 Magazine	 Double parallel	 2-off digest
1	4	8	16	16	8
2	8	16	32	32	16
3	12	24	48	48	24
4	16	32	64	64	32
5	20	40	80	80	40
6	24	48	96		
7	28 (2 sec.)	56	112		
8	32(2 sec.)	64	128		
9	36(2 sec.)	72	144		
10	40(2 sec.)	80	160		
Max Size	22 3/4"x18"	18x11 3/8"	9x11 3/8"	18x 5 11/16"	
Min Size	578x457mm	457x289mm	229x289mm	457x 144mm	
Max Size	22 3/4"x9"	9x11 3/8"	4 1/2"x11 3/8"	9x 5 11/16"	
Min Size	578x229mm	229x289mm	114x289mm	229x 144mm	

These sizes assume even fold (no lap). High or low folio lap can be obtained to a maximum of approximately 1/2 in. (12mm) Note: largest and smallest products may require some reduction in speed; fold quality is dependent on type and weight of paper used. Since improvements in design and manufacture are incorporated as soon as experience demonstrates their value, Web Press Corporation reserves the right to modify its equipment specifications without notice.

ATLAS

The Atlas continues the Web Press Corporation tradition of producing quality web offset presses for a wide range of newspaper and commercial printing. It is designed with wide, walk-through aisles, vertical web lead and convenient controls for easy operation — a real pressman's press. Running sidelay and circumferential adjustments for both sides of the web facilitate production of high quality products quickly and without unnecessary waste. Quality printing, coupled with exceptional fold accuracy and flex-

PERFECTING UNIT

Unique among single-width presses, the 22-3/4 x 36 inch* (578 x 914mm) format Atlas has ink fountains situated to provide a clear view of both plate and web. Large solid steel side frames joined by generous cross braces provide maximum stability while giving the pressmen full working room for fast and efficient plating, webbing and washup. Each unit is equipped with full running sidelay and circumferential register adjustments for both sides of the web and a quick acting pneumatic clutch for silencing. Close register is insured by the precision plate mounting system.

QUADRA-COLOR UNIT

The only four-color common impression cylinder unit designed for quality printing of a broad range of newspaper and commercial products. The common impression configuration insures quick make-ready, freedom from register fluctuations caused by normal tension and speed changes while taking up a minimum of floor space — about 5 x 6 feet. The 5-foot web lead, shortest in the industry, holds waste down for a new standard of profitability.

HALF/UNIT COLOR DECK

The half/unit color deck brings a new dimension of flexibility to the small press market. It may be pedestal mounted at floor level or stacked above a standard perfecting unit for additional color placement. The half/unit color deck incorporates all of the features of our full units

COMBINATION FOLDER

A reliable, accurate, high speed folder is the key to profitable press operation. The Atlas 2:1 folder is rated at 30,000 papers per hour and accommodates full webs from 18 inches (457mm) to 36 inches (914mm). For superior web control two driven rolls, each fitted with adjustable rubber-faced trolleys, pull webs into the folder. Large diameter, gear driven nipping rollers meter the former folded ribbons into the folding couple. To insure the strength and rigidity necessary for consistent fold accuracy, the folding cylinders rotate in robust, heavy-duty bearings. They are driven by wide-faced helical gears for quiet operation and long life.

ibility, demonstrate the high productivity built into the Atlas. At 30,000 copies per hour, this dependable and uncomplicated press consistently out-performs comparably priced equipment. No tools are needed for any routine operating procedures such as plateup, silencing or register moves. Every aspect of the Atlas is designed for one purpose; to help you produce more quality products every day with less effort, less waste, and more profit.

Notches to engage the cylinder register pin are cut simultaneously with bending action. The leading edge plate bend mounts right on the nose of the cylinder opening and when in position over the register pin, cannot creep out of register. The simple no tool lockup, coupled with the ability to manually rotate any unit in either direction, provides the fastest plate changing system of any newspaper web offset press. Brush dampening is included as a standard item to round out the labor saving and profit making features of the Atlas unit.

Its quality capability and waste-reducing fast make-ready are matched with almost limitless flexibility to give you cost effective superior four color on any page in any section of your product. The unit can be built for either direction of rotation, providing quality color on the top, bottom, or both sides of the web as required. Four colors in five feet — only with Web Press Corporation's Quadra-Color.

including brush dampening as standard and all compensator and lead rollers. The half/unit color deck is also unique in that it can be inexpensively converted to a full perfecting unit at any time. Its flexibility makes it possible to place added color on up to three web positions.

The unique folded edge forward, half-fold delivery is ideal for delivery of products to stackers or count-veyors. For accurate quarter folding (up to 10 webs) and avoidance of jams, every signature is restrained by delivery tapes prior to jaw release, then carried between them through the second fold. A two-off double digest folder is available as an option on the standard machine. For large volume production of digest sized products, a standard double parallel option is also available in the same folder.



General Assembly

General Assembly, 22 ¾" Atlas Quadra-Color Assembly 2521000

Part No.	Description	Qty. Req'd
001054	BEARING	6
005010	SPHERICAL WASHER	8
031021	DOWEL PIN 1/2X3" LONG	8
090122	ATLAS WEB LEAD NAME PLATE	1
511260	LEVELING BOLT	4
511490	ROLLER CORE	3
511580	OPER. LABEL, SIDELAY TO OPER.	4
521363	GEAR, IMPRESSION CYLINDER L.H.	1
1511380	SHAFT, STIFFENER	3
1521140	SHAFT, STIFFENER, OUTRIGGER	1
1521150	SHAFT, STUB, OUTRIGGER	2
1527010	TIE STRAP	4
1521160	OUTRIGGER, O.S.	1
2511410	LEVELING PAD	4
2521010	SIDE PLATE – BOTTOM G.S.	1
2521020	SIDE PLATE – BOTTOM O.S.	1
2521030	SIDE PLATE – TOP G.S.	1
2521040	SIDE PLATE – TOP O.S.	1
2521071	STIFFENER, LOWER FRAME	2
2521082	INK COVER	2
2521381	IMPRESSION CYLINDER	1

Option, Standard Atlas Quadra-Color Assembly 2521000a1

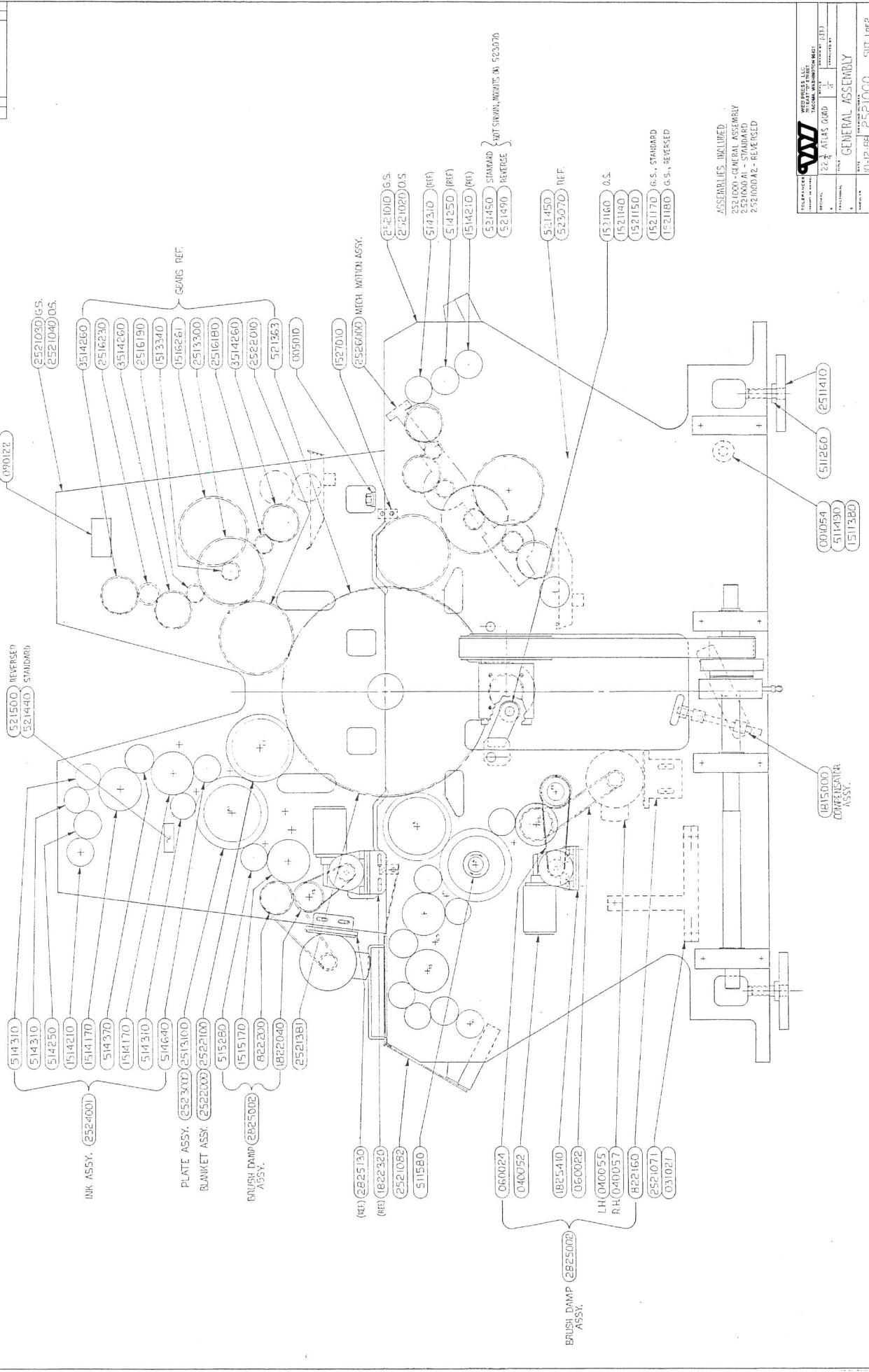
1521170	OUTRIGGER, G.S.	1
521440	OPER. LABEL – SKEWING TO PINS	4
521450	OPER. LABEL – CIRC. TO PINS	4

Option, Reversed Atlas Quadra-Color Assembly 2521000a2

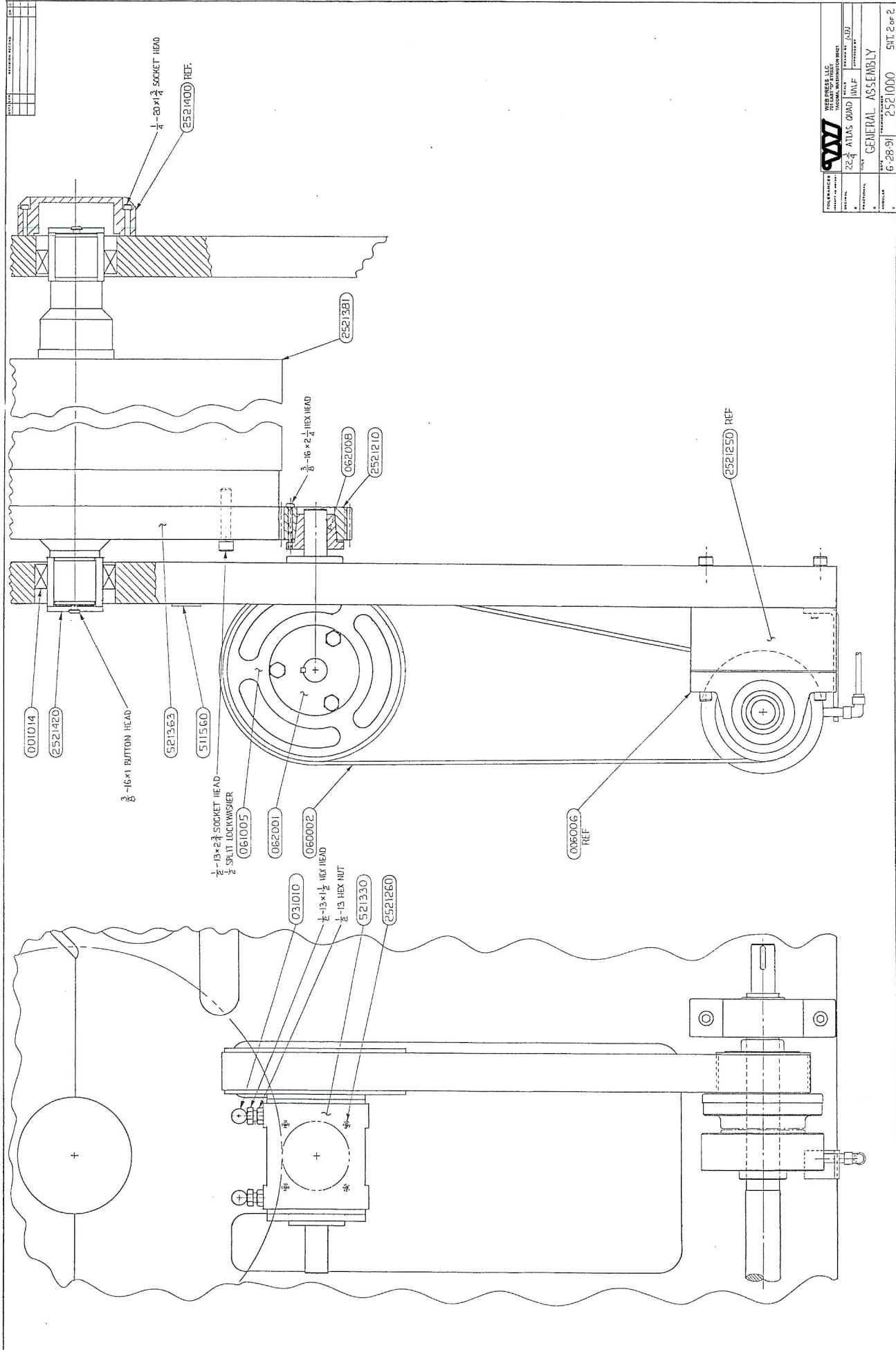
1521180	OUTRIGGER, G.S. REVERSED ONLY	1
521500	LABEL – SKEWING TO PINS	4
521490	LABEL – CIRC. TO PINS	4

General Assembly, 22 ¾" Atlas Quadra-Color Assembly 2521000

Part No.	Description	Qty. Req'd
001014	BEARING	2
031010	DOWEL PIN ¾ X 3" LONG	2
060002	TIMING BELT, 700 H 200	1
061005	PULLEY, 60 H 200 (TIMING BELT)	1
062001	TAPER BUSHING, SF 1 ¼	1
062008	TAPER BUSHING, SD 1 ¼	1
511560	NAME PLATE	1
521330	GEAR BOX, MAIN DRIVE	1
521363	GEAR, IMPRESSION CYLINDER L.H.	1
2521210	PINION GEAR	1
2521260	STUD, INPUT GEAR BOX	4
2521420	RETAINER	2
2521381	IMPRESSION CYLINDER	1



GENERAL ASSEMBLY	
REV	1
DATE	01-12-84
BY	2521000
CHKD	SPT Ter2
GENERAL ASSEMBLY	
REV	1
DATE	01-12-84
BY	2521000
CHKD	SPT Ter2



		VAV VALVE & VALVE ACCESSORIES VALVE & VALVE ACCESSORIES
PART NUMBER 2521400	TITLE AIDS 0040 HALF	DATE 6-28-91
DRAWN BY (blank)	CHECKED BY (blank)	PROJECT NO. 2521000
PARTIAL NO. (blank)	GENERAL ASSEMBLY	SHEET NO. 2 OF 2

General Assembly, 22 ¾" Atlas Quadra-Color Assembly 2521000

(Cont'd From Previous Page)

Reference Gears

Part No.	Description	Used On
521363	GEAR, IMPRESSION CYLINDER	2521000
1513340	GEAR, DRIVE PLATE CYLINDER	2523000
3514260	GEAR, L.H. OSCILLATOR	2514001, 2522000
1516261	GEAR, MECHANICAL MOTION	2526000
2513300	GEAR, CIRC. PLATE CYL. L.H.	2523000
2516180	GEAR, PINION R.H.	2526000
2516190	GEAR, PINION R.H.	2526000
2516230	GEAR, PINION R.H.	2526000
2522010	GEAR, BLANKET CYLINDER	2522000



Auto Clutch

Quadra-Color Air Clutch, Auto Assemblies

2521000 B3-B2B

Assembly 2521000B3 (Basic)

Part No.	Description	Qty Req'd
006006	C25 – 1 ¼ BEARING	2
006007	C25 – 1 13/16 BEARING	1
051010	SWIVEL ELBOW ¼ T x ¼ NPT	2
051149	VALVE,	1
051098	1/8 ID X ¼ OD TUBING (FEET)	10
052047	NIPPLE 1/8 NPT X ¾" LONG	1
051100	FEMALE ELBOW ¼ T x 1/8 NPT	1
051127	FILTER – REGULATOR – LUBE W/GAUGE	1
2521450	SHAFT, MAIN DRIVE	1
2521250	PILLOW BLOCK SPACER	3
2521460	BRACKET	1
2828370	CLUTCH LABEL	1
051150	1/8 NPT X ¼ TUBE	2
068074	HORTON AIR CLUTCH, 5H50TP	1

Assembly 2521000B2B (Automatic)

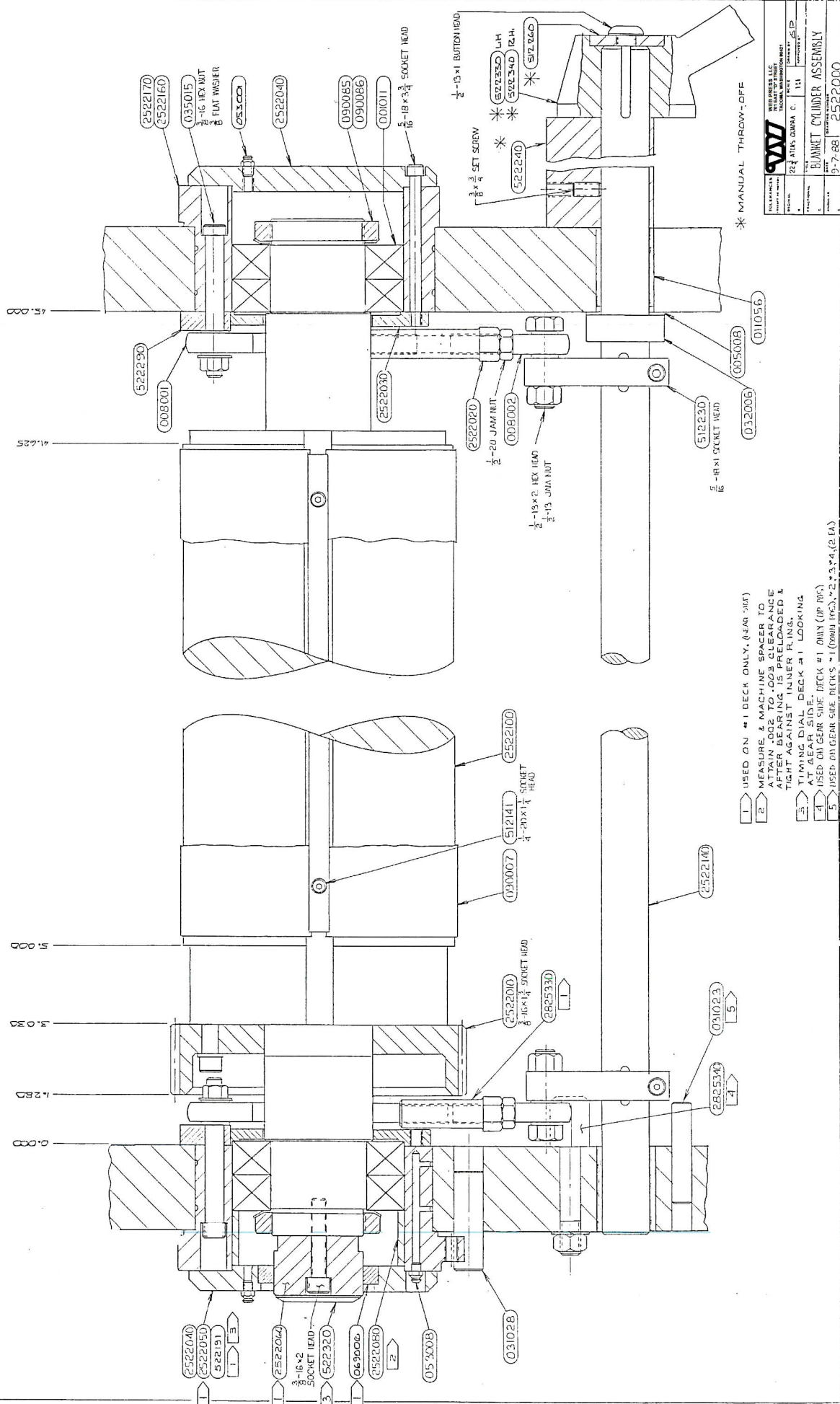
051010	SWIVEL ELBOW ¼ T x ¼ NPT	1
051014	PIPE PLUG 3/8 NPT	2
051053	CONN. ½ T x 3/8 NPT	2
051054	½ O.D. TUBING (FEET)	10
051013	PLUG	1
1830370	JUNCTION BOX	1



Blanket Cylinder Assembly

Blanket Cylinder 22 3/4" Atlas Quadra-Color Assembly 2522000

Part No.	Description	Qty Req'd
001011	BEARING, 2.3622 ID X 4.3307 OD	16
090085	LOCK NUT, 2.360 X 18,	8
090086	LOCK WASHER,	8
005008	THRUST WASHER, 1 1/4 ID X 1 15/16 OD X .03 THICK	4
008001	ROD END, 1/2 ID LH THD, 1/2 20 MALE	8
008002	ROD END, 1/2 ID, 1/2 20 MALE	8
011056	OILITE BUSHING, 1 1/8 ID X 1 1/2 OD X 1" LONG,	8
031023	ROLL PIN, 1/2 X 2 1/2 LG.	7
031028	DOWEL PIN, 3/4 X 2 1/2 LG.	4
032006	SET COLLAR, 1 1/4 ID X 2" OD,	4
035015	SHOULDER SCREW, 1/2 X 3" LG.	8
053008	LUBE FITTING, 1/4 28 STRAIGHT X 1 1/8 LG.,	8
069006	GREASE SEAL, 2 1/4 ID X 3" OD X 7/16,	1
090007	BLANKET, VULCAN #714	4
512141	BLANKET BAR	4
512230	IMPRESSION ARM	8
522290	KEEPER	8
522320	TIMING DIAL	1
2522020	IMPRESSION LINKAGE	6
2522030	INNER RING	8
2522040	BEARING CAP	7
2522050	BEARING CAP, TIMING DIAL	1
2522060	DIAL, BACK UP	1
2522080	SPACER, BLANKET CYLINDER	4
2522100	BLANKET, CYLINDER	4
2522140	SHAFT, IMPRESSION	4
2522160	ECCENTRIC BLANKET R.H.	4
2522170	ECCENTRIC BLANKET L.H.	4
2825330	IMPRESSION LINKAGE	2
2825340	STOP PIN	1



REV	DATE	BY	CHKD
1	11/11/88	WJ	WJ
2	12/11/88	WJ	WJ
3	12/11/88	WJ	WJ
4	12/11/88	WJ	WJ
5	12/11/88	WJ	WJ

WJ
 WILLYS MILITARY EQUIPMENT
 TECHNICAL DRAWING DEPARTMENT
 72 1/2 AIRS CORP. C. 111
 BLUNNET CYLINDER ASSEMBLY
 9-7-88 2522000



Plate Cylinder Assembly

Plate Cylinder 22 ¾" Atlas Quadra-Color Assembly 2523000

Part No.	Description	Qty. Req'd
001014	BEARING	8
005005	THRUST WASHER, 1" ID x 1.55 OD x .03 THK	4
005010	SPHERICAL WASHER, 25/32 ID x 1 5/8 OD x 3/8 THK,	4
011006	BUSHING, 5/8 ID x ¾ OD X 1" LG	4
011053	BUSHING, ¾ ID x 1" OD x 2 1/8 LG	4
030020	SNAP RING, 4.330 DIA.	8
031004	ROLL PIN, ¼ x 1" LG.	4
031014	ROLL PIN, 3/8 x 2 ½ LG.	4
031015	ROLL PIN, ¼ x 1 ¾ LG.	4
031032	SPIRAL ROLL PIN, ¼ x 1 ½ LG.	4
031041	ROLL PIN, 3/16 x ¾ LG.	4
031004	ROLL PIN, ¼ x 1" LG.	4
032008	SET COLLAR, 7/8 14 x 1 5/8 OD	4
053001	LUBE FITTING ¼ 28	4
513391	HANDLE, SIDE MOVEMENT	4
513410	PHENOLIC WASHER	4
523011	SPACER, SIDE MOVEMENT	4
523020	CAP, SKEWING	4
523240	SPACER, SIDE MOTION HANDWHEEL	4
523251	SPECIAL WASHER	4
523260	PLATE ADJUSTMENT	4
1513220	BEARING, RETAINER O.S.	4
1513370	BUSHING, CIRC. CONTROL SHAFT	4
1513340	GEAR, DRIVE PLATE CYL.	4
1513440	SPACER, DRIVE GEAR	4
1513500	CIRC. SHIFTING FORK ASSY, L.H.(request drawing 1513500 for list of separate parts)	4
2513300	GEAR, CIRC. PLATE CYL., L.H.	4
2513051	INTERNAL SPLINE BROACH, TURN	4
2523010	SHAFT, CIRC. CONTROL	4
2523021	ECCENTRIC BEARING HOUSING O.S.	4
2523030	ECCENTRIC O.S.	2
2523041	BEARING BUSHING G.S.	4
2523050	ECCENTRIC, G.S.	4
2523070	ECCENTRIC ADJUSTMENT TOOL	8
031040	DOWEL PIN 3/16 x ¾ LG.	16
2523080	RETAINER PLATE G.S.	4
2523110	ECCENTRIC, O.S., L.H.	2
2523120	ECCENTRIC PLATE, G.S., L.H.	2
2523140	STOP, QUAD CIRC. SHAFT	4
2523150	PLATE CYLINDER ADJUSTMENT TOOL	1

Plate Cylinder 22 3/4" Atlas Quadra-Color Assembly 2523000

(Continued)

Standard Plate Cylinder Assembly 2523000A1

Part No.	Description	Qty. Req'd
2513200	PLATE CYLINDER ASSY, R.H.	4
2513061	EXTERNAL SPLINE	4

Reverse Plate Cylinder Assembly 2523000A2

2513100	PLATE CYLINDER ASSY, L.H.	4
2513061	EXTERNAL SPLINE	4

Reference – Plate Cylinder Assy 2840000 Manual Throw-Off, 22 3/4" Atlas Quadra-Color

005002	THRUST WASHER, .656 ID x 1.500 OD x 1/8 THK	8
005003	THUST WASHER, .628 ID x 1.250 OD x 1/16 THK	4
033008	KNOB, 1" DIA. x 5/16 18 INSERT	4
523060	GEAR, CIRC. CONTROL	8
523070	GEAR BLOCK, CIRC. CONTROL	4
523200	HANDLE, CIRC. CONTROL	4
523230	SIDE ADJUSTMENT SCREW	4

Plate Cylinder 22 ¾ Atlas Quadra-Color Assembly 2523000

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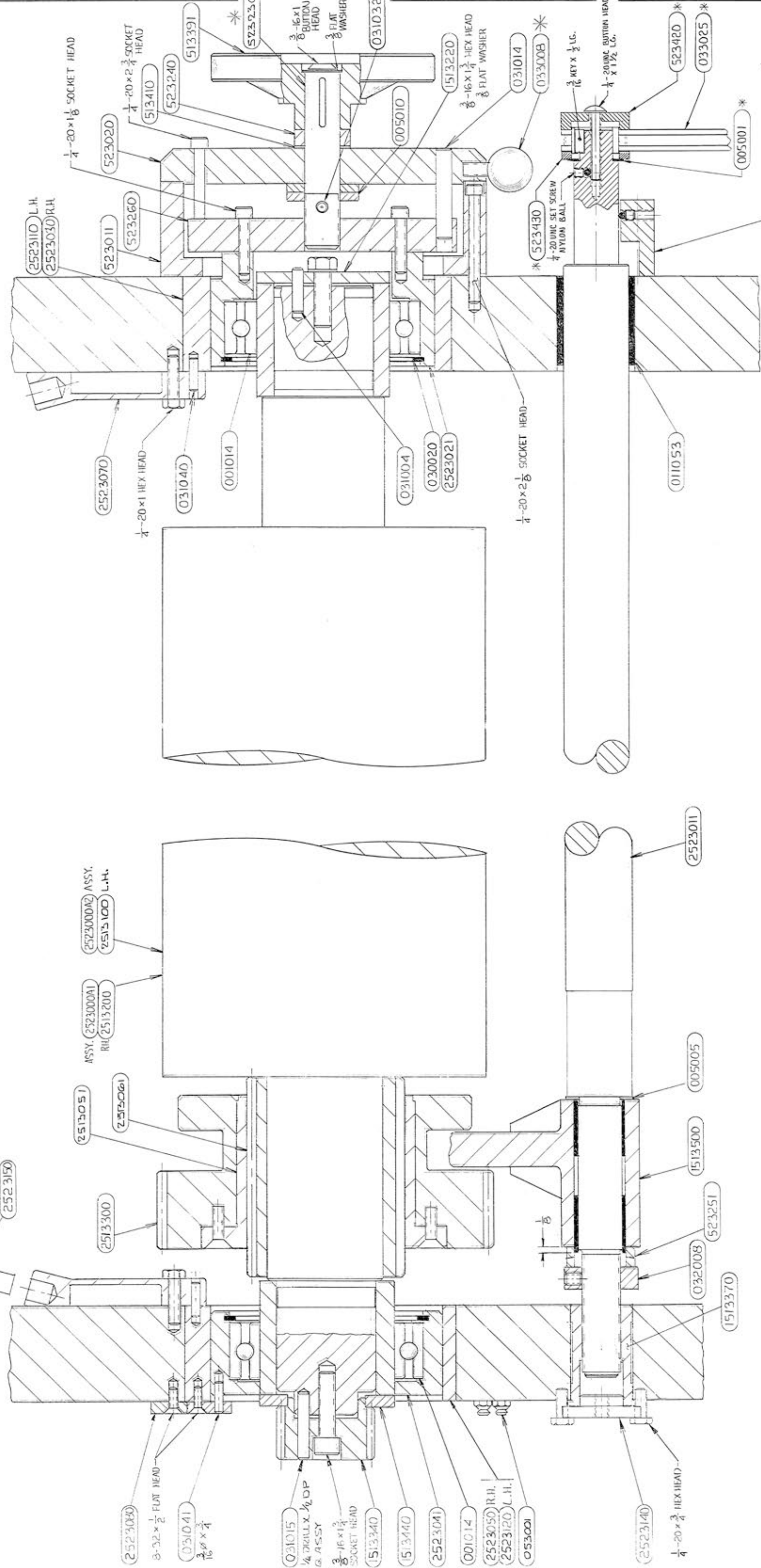
Reference – Blanket Cylinder Assembly 2522000

Manual Throw-Off, 22 ¾” Atlas Quadra-Color Assembly 2840000

Part No.	Description	Qty. Req'd
512260	WASHER, IMPRESSION HANDLE	4
522240	SPACER, IMPRESSION HANDLE	3
522330	HANDLE, IMPRESSION L.H.	2
522340	HANDLE, IMPRESSION R.H.	2

Conversion to Run 35k Assembly A1524-2

A1524-26	GEAR DRIVE PLATE CYLINDER (REPLACES 1513340, GEAR DRIVE PLATE CYL)	4
A1524-27	SPACER, DRIVE GEAR (REPLACES 1513440, SPACER DRIVE GEAR)	4



* DELETE THESE PARTS IF 4-C IS AUTOMATIC (REFER TO DWS. # 2830002)

TOLERANCES UNLESS OTHERWISE SPECIFIED	WEB PRESS CORP. KENT WA.	
REVISION	22	ATLUS QUADRA C. 1:1
DESIGNED BY	G.S.P.	
APPROVED BY		
FUNCTIONAL	PLATE CYLINDER ASSEMBLY	
DATE	12-9-97	DRAWING NUMBER 2523000



Ink System

Ink System 22 ¾ Atlas Quadra-Color Assembly

2524001

Part No.	Description	Qty. Req'd
001001	BEARING	60
001002	BEARING	8
011005	BUSHING, 1" x 1 1/8 x 1 ¼,	8
011069	BUSHING, .5025 ID x .753 OD x 1 ¼ LG.	16
011054	BUSHING, ¾ X 1 X 2 1/8, AA-1049-11	8
021008	COMPRESSION SPRING, 3/8 OD x 1 ¼ LG	8
030006	SNAP RING, EXTERNAL 1 3/8 SHAFT DIA.	8
030015	SNAP RING, EXTERNAL 2 " SHAFT DIA.	8
035007	SHOULDER SCREW, 3/8 x ¾ LG.	20
035029	SWING BOLT, 3/8 16 x 2 ½ LG.	20
035031	SHOULDER SCREW, ½ x 1 ¾ LG.	8
514250	ROLL, INK SKIMMER	4
514310	INK FORM ROLL, 2 ¾" DIA.	10
514360	OSCILLATOR SHAFT BUTTON	8
514370	INK TRANSFER ROLL, 3" DIA.	4
514411	CAM, FORM ROLL	8
514640	INK, FORM ROLL 2 7/8" DIA.	4
1514030	SHAFT, TRANSFER ROLL	10
1514040	FORM ROLL SHAFT	8
1514050	SHAFT, INK SKIMMER	4
1514060	SHAFT, FORM ROLL CAM	4
3514170	OSCILLATOR, INK	8
1514210	ROLL, INK FOUNTAIN	4
1514240	PHENOLIC WASHER	16
3514400	OSCILLATOR, GEAR ASSY., L.H.	8
001025	BEARING	16
3514260	GEAR, OSCILLATOR, L.H.	8
3514270	PIN, OSCILLATOR GEAR	16
1524021	HANGER BRACKET	8
1524011	HANGER BRACKET	8
1524060	OSCILLATOR BUSHING, G.S.	8
1524070	OSCILLATOR BUSHING, O.S.	8
1524080	BUSHING	16
2524010	BRACKET, INK SKIMMER	8

Sheet 1 of 3

Ink System 22 ³/₄ Atlas Quadra-Color Assembly

2524001

Part No.	Description	Qty. Req'd
001001	BEARING	60
005005	THRUST WASHER, 1" ID x 1.55 OD x .03 THK	4
020003	TENSION SPRING, ½ OD x .041 WIRE DIA. x 1 ¾ LG	4
021009	SPRING PLUNGER, ¼ 20 x ¾" LG.	4
033003	KNOB, 3 1/8 DIA x ½ 13	8
033004	KNOB, 3 1/8 DIA x 10 32 STUD x ½ LG.	4
068002	CLUTCH, 1" ID x 5/8 LG.	8
068048	INNER RACE, ¾ ID x 1" OD x 1.515 LG.	4
090139	SPRING, STEEL .010 THK x 5/16 WIDE	4
2524081	CHEEK, INK FOUNTAIN	8
514050	INK FOUNTAIN SEAL	8
514060	STRAP, LOWER	4
514070	STRAP, UPPER	4
514080	BLADE, INK FOUNTAIN	4
514091	KEY, INK FOUNTAIN	132
514130	FOUNTAIN ROLL COVER	4
3514050	WASHER, FOUNTAIN DRIVE RETAINING	4
3514060	BOLT	4
514150	ARM, INK FOUNTAIN ROLL	4
514161	ARM, DOUBLE STROKE FOUNTAIN, R.H.	2
514171	ARM, DOUBLE STROKE FOUNTAIN, L.H.	2
514180	TAB, INK FOUNTAIN DRIVE SPRING	4
514190	BRACKET, SLIDE	4
514210	LOCKING CAM, SLIDE	4
514220	ECCENTRIC PIN, SLIDE CAM	4
514230	SLIDE, DOUBLE STROKE INKER	4
514240	ROD ADJUST INKER	2
524010	ROD ADJUST INKER, LOWER DECK	2
514760	PHENOLIC WASHER	4
1514010	BLOCK, INK FOUNTAIN, R.H.	2
1514020	BLOCK, INK FOUNTAIN, L.H.	2
1514080	SPACER, INK FOUNTAIN DRIVE	4
1514210	ROLL, INK FOUNTAIN	4
2514050	PRESSURE PLUG	8
2514061	SPRING HOUSING	8

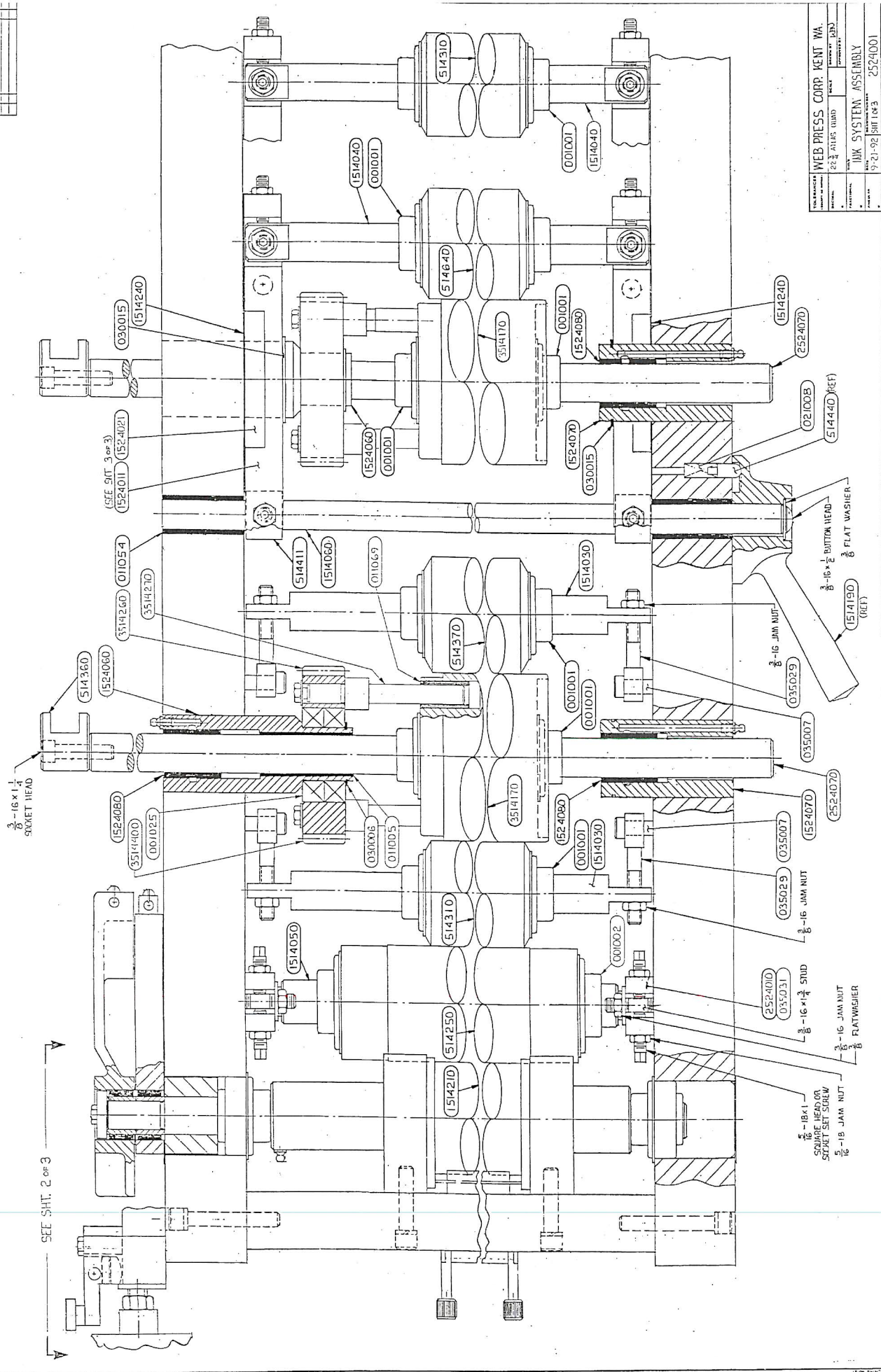
SHEET 2 OF 3

Ink System 22 ¾ Atlas Quadra-Color Assembly 2524001

Part No.	Description	Qty Req'd
020009	TENSION SPRING, ½ x .080 x 1 5/8 LG.	8
514310	INK FORM ROLL, 2 ¾"	10
514411	CAM, FORM ROLL	8
514640	INK FORM ROLL, 2 7/8"	4
1514060	SHAFT, FORM ROLL CAM	4
1524021	HANGER BRACKET	8
1524011	HANGER BRACKET	8
3514020	SCREW, SPRING ADJUSTMENT	8
3514030	SCREW, SPRING ADJUSTMENT	8

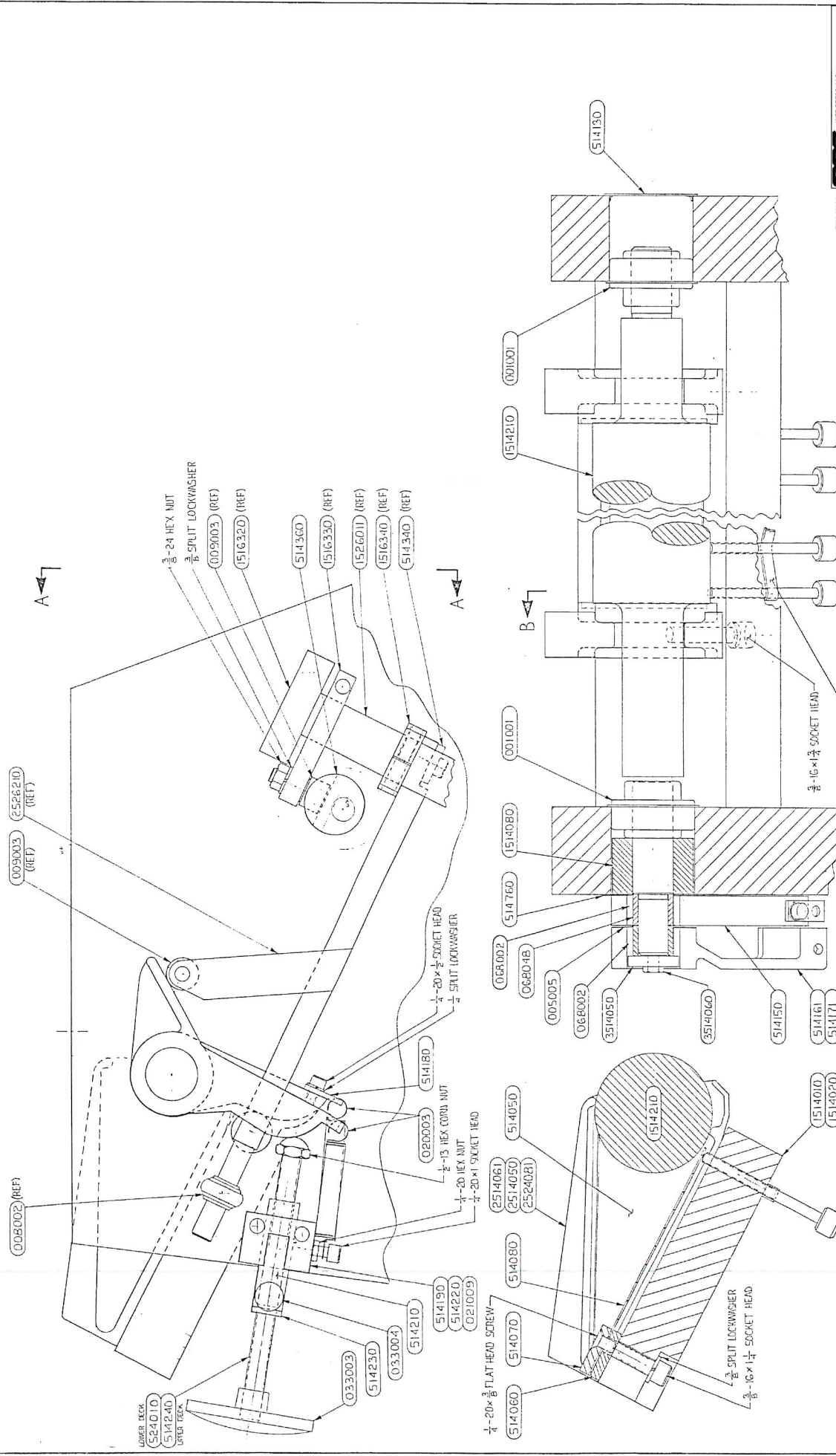
SHEET 3 OF 3

DATE	REV	BY	CHK



WEB PRESS CORP. KENT WA.		DATE	REV
2524010		01/15/85	01/15/85
INK SYSTEM ASSEMBLY		DESIGNED BY	REVISED BY
9-21-92 SHIT 1 of 3		2524001	

REV	DATE	BY	CHK

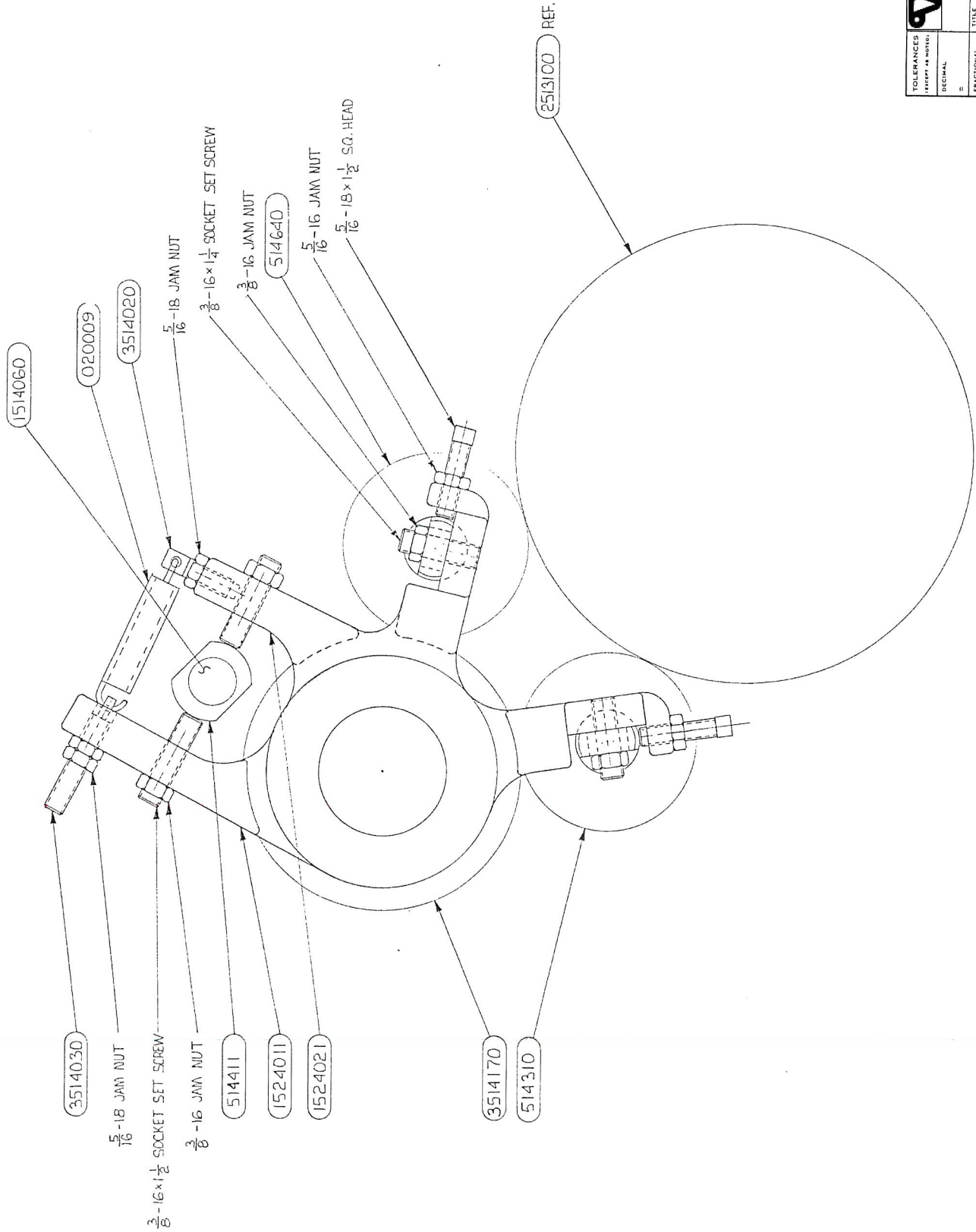



WES PRESS LLC 10000 W. 100th Street Overland Park, KS 66213	PART NO. 2524001 REV. 2 DATE 9-21-92
DRAWN BY: JLD CHECKED BY: JLD APPROVED BY: JLD	TITLE: INK SYSTEM ASSEMBLY SHEET: 2 OF 3

VIEW A-A

SECTION B-B

DATE	BY	REVISION	RECORD	DR	CHK



		WEB PRESS LLC 10000 1 ST AVENUE TACOMA, WASHINGTON 98401	
TOLERANCES UNLESS NOTED:	SCALE	DRAWN BY	APPROVED BY
FRACTIONAL	FULL		
DECIMAL			
TITLE	DATE	DRAWING NUMBER	SHEET NUMBER
INK SYSTEM ASSEMBLY	9-21-92	2524001	3 OF 3

Baldwin Ink Wash-Up Assembly 2524001A1

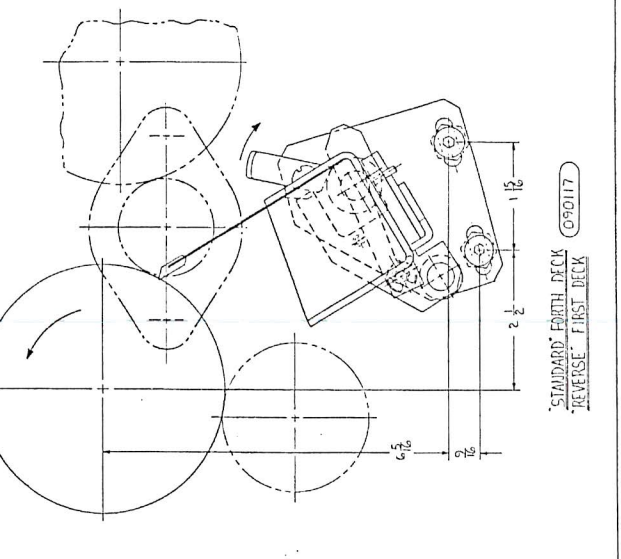
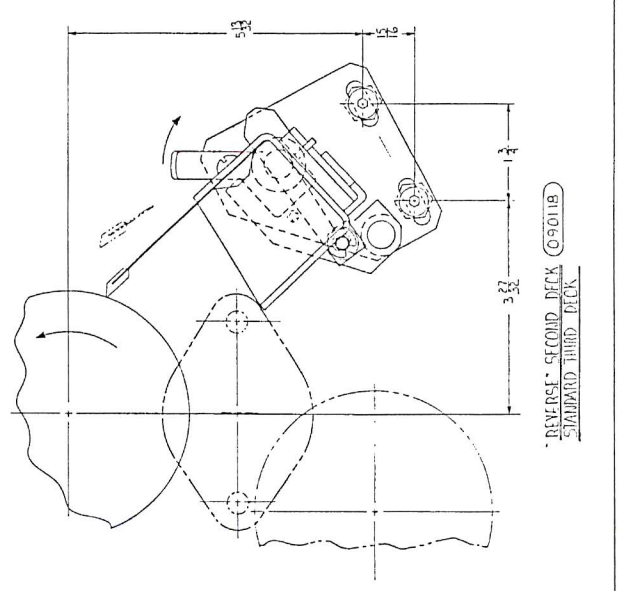
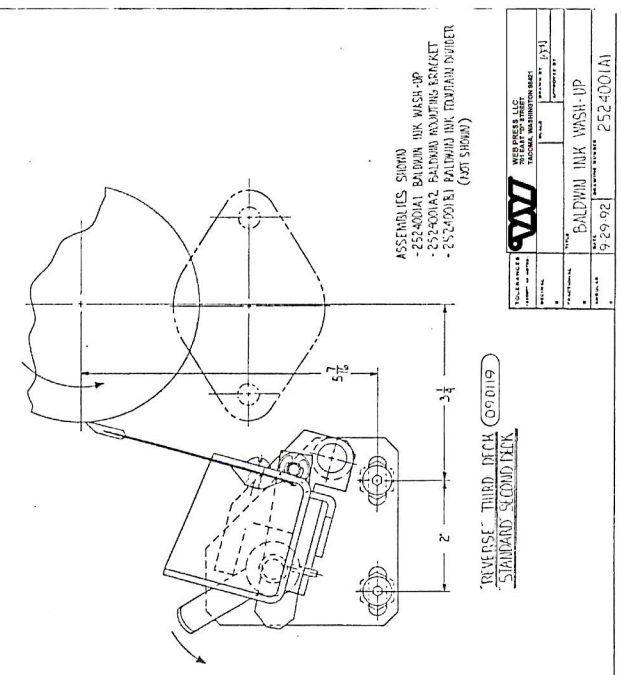
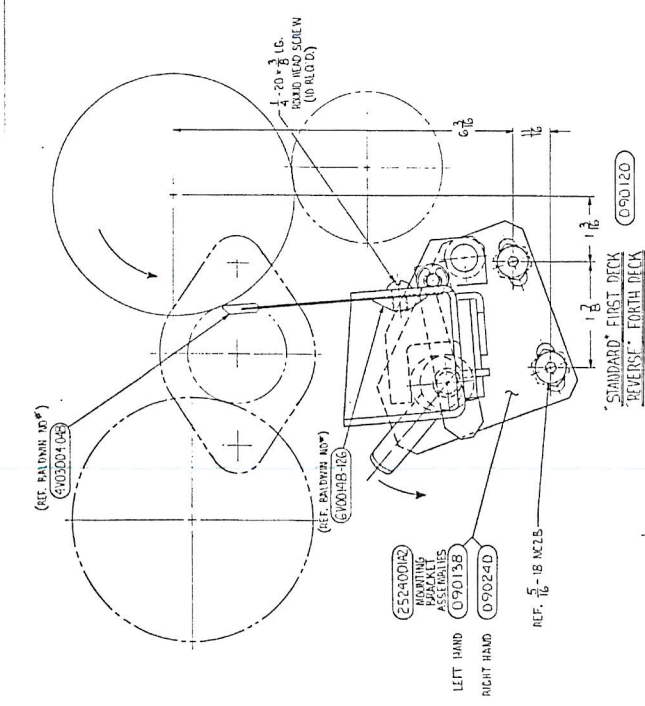
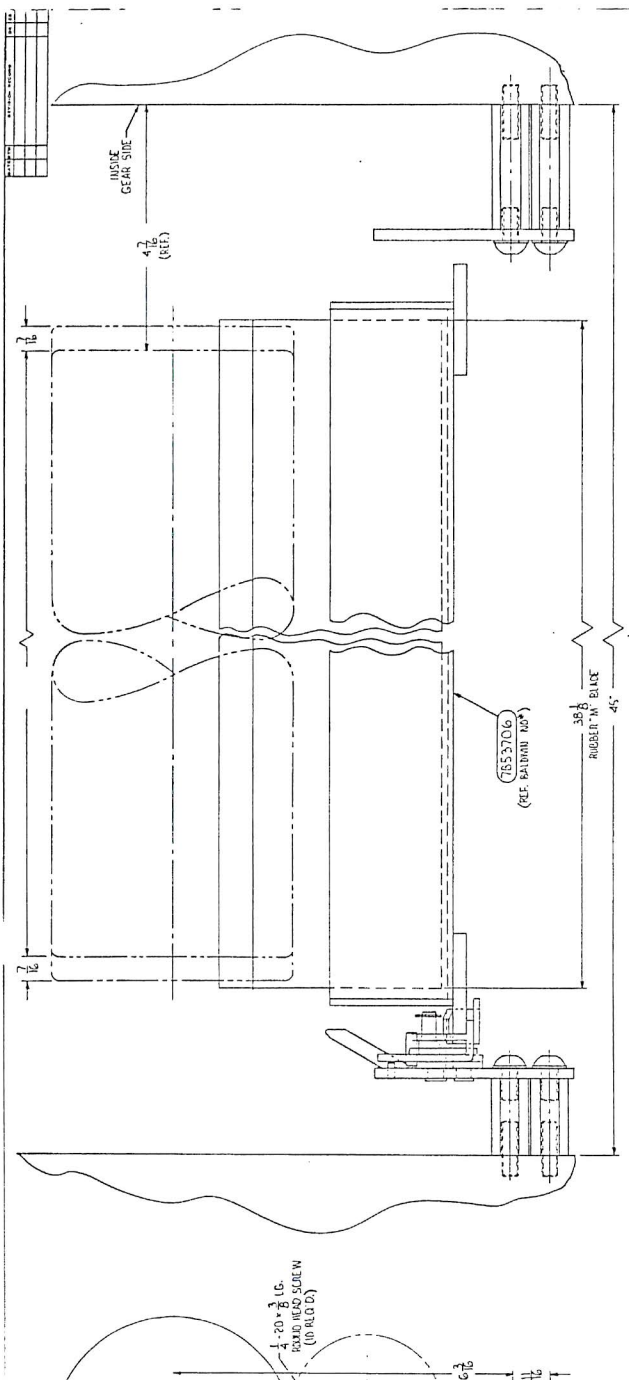
Part No.	Description	Qty Req'd
090117	WASH-UP, DECK #1 REVERSE QUAD OR, DECK #4 STANDARD QUAD BALDWIN #53604	1
090118	WASH-UP, DECK #2 REVERSE QUAD OR, DECK #3 STANDARD QUAD BALDWIN #53605	1
090119	WASH-UP, DECK #3 REVERSE QUAD OR, DECK #2 STANDARD QUAD BALDWIN #53603	1
090120	WASH-UP, DECK #4 REVERSE QUAD OR, DECK #1 STANDARD QUAD BALDWIN #53606	1

Assembly 2524001A2

090138	MOUNTING BRACKET, L.H., BALDWIN #53704	4
090240	MOUNTING BRACKET, R.H., BALDWIN #53705	4

Baldwin Ink Fountain Divider Assembly 2524001B1

090031	FOUNTAIN DIVIDER (NOT SHOWN) BALDWIN #1028	4
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		BALDWIN INK WASH-UP PART NO. 2524001A REV. 9/29/92
TITLE BALDWIN INK WASH-UP	DRAWN BY DATE	CHECKED BY DATE
DESIGNED BY DATE	MANUFACTURED BY DATE	PART NO. 2524001A



Mechanical Motion

Mechanical Motion 22 ¾ Atlas Quadra-Color Assembly 2526000

Part No.	Description	Qty Req'd
001001	BEARING	4
001059	BEARING	8
001007	BEARING	4
001027	BEARING	4
001028	BEARING	4
001033	BEARING, DOUBLE ROW ANG. CONTACT	8
011001	BUSHING, 3/8 ID x ½ OD x 3/8 LG.	4
030001	SNAP RING, EXTERNAL 1"	4
030009	SNAP RING, S.D. EXTERNAL 1 1/8"	8
030017	SNAP RING, 2.44 HOUSING DIA.	16
031003	ROLL PIN, ¼ x ¾ LG.	4
031055	ROLL PIN, 3/16 x ½ LG.	4
035006	SHOULDER SCREW, 3/8 x 3" LG.	4
030016	SNAP RING, EXTERNAL 1 3/16"	8
035023	SHOULDER SCREW 3/8 x 3" LG.	4
053009	DRIVE FITTING, 3/8"	(NOT SHOWN)
090185	LOCK NUT, 1.1811 x 18 THREAD	4
090186	LOCK WASHER	4
516340	WASHER, INK PUSH ROD	4
1516140	HOUSING M.M. SHAFT	4
1516160	HOUSING M.M. SHAFT	4
1516240	YOKE, MACHINING	4
1516261	GEAR, MECH. MOTION	4
1516271	BEARING RETAINER	4
1516340	ARM, INK FOUNTAIN DRIVE	4
1516360	BEARING HOUSEING	4
1516440	SPACER	4
1516510	GUIDE BLADE	8
1526011	SHAFT MECH. MOTION	4
1526020	SHAFT MECH. MOTION	4
2516180	GEAR, PINION, R.H.	4
2516190	GEAR, PINION R.H.	4
2516230	GEAR, PINION R.H.	4
2526100	LINK, SUB ASSY	4
2526291	STUD SHAFT	4

Continued on next page

Mechanical Motion 22 ¾ Atlas Quadra-Color Assembly 2526000

Part No.	Description	Qty Req'd
001001	BEARING	4
008002	ROD END	4
009003	CAM FOLLOWER	16
009013	CAM FOLLOWER	4
030021	SNAP RING, 5/16" DIA	4
1516140	HOUSING, MECH. MOTION SHAFT	4
1516160	HOUSING, MECH. MOTION SHAFT	4
1516261	GEAR, MECH. MOTION	4
1516271	BEARING RETAINER	4
1516320	BEARING BLOCK	4
1516330	ARM, OSCILLATOR DRIVE	12
1516360	BEARING HOUSE	4
1526011	SHAFT, MECH. MOTION	4
1526020	SHAFT, MECH. MOTION	4
2526100	LINK, SUB ASSY.	4
2526210	PUSH ROD, L.H., UPPER DECK	1
2526220	PUSH ROD, R.H., UPPER DECK	1
2526230	PUSH ROD, L.H., LOWER DECK	1
2526240	PUSH ROD, R.H., LOWER DECK	1
2526250	CAM ROLL SHAFT (ONE FOR EACH PUSH ROD)	1

Assembly 2526000A1

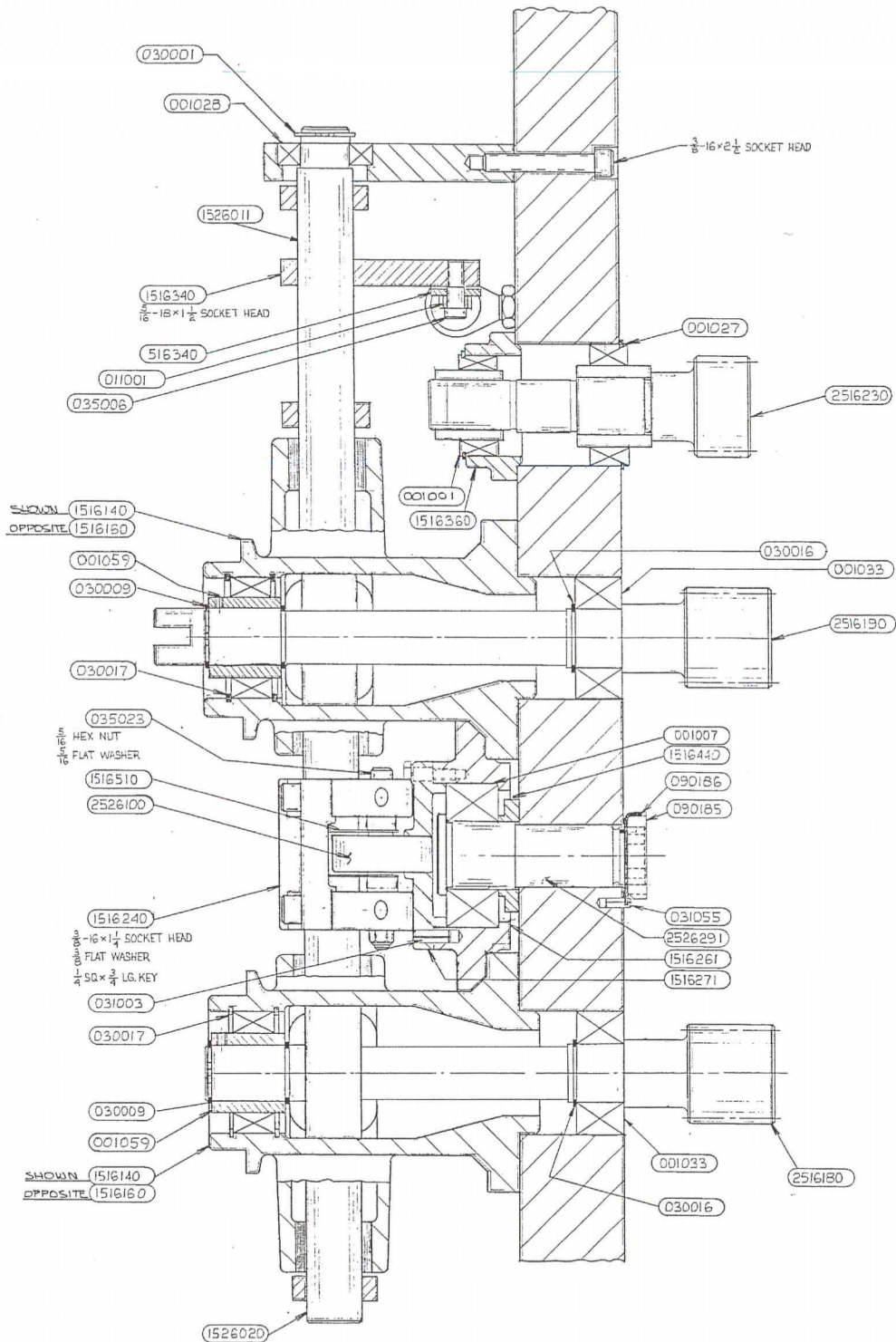
2516280	ADJUSTING TOOL (NOT SHOWN) NOTE: ONE PER CUSTOMER	1
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Assembly 2526000A2

1811042	HANDWHEEL (NOT SHOWN)	1
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Conversion to Run 35k Assembly A1524-2

A1524-28	GEAR, M.M. (REPLACES 1516261, GEAR, MECH. Motion)	4
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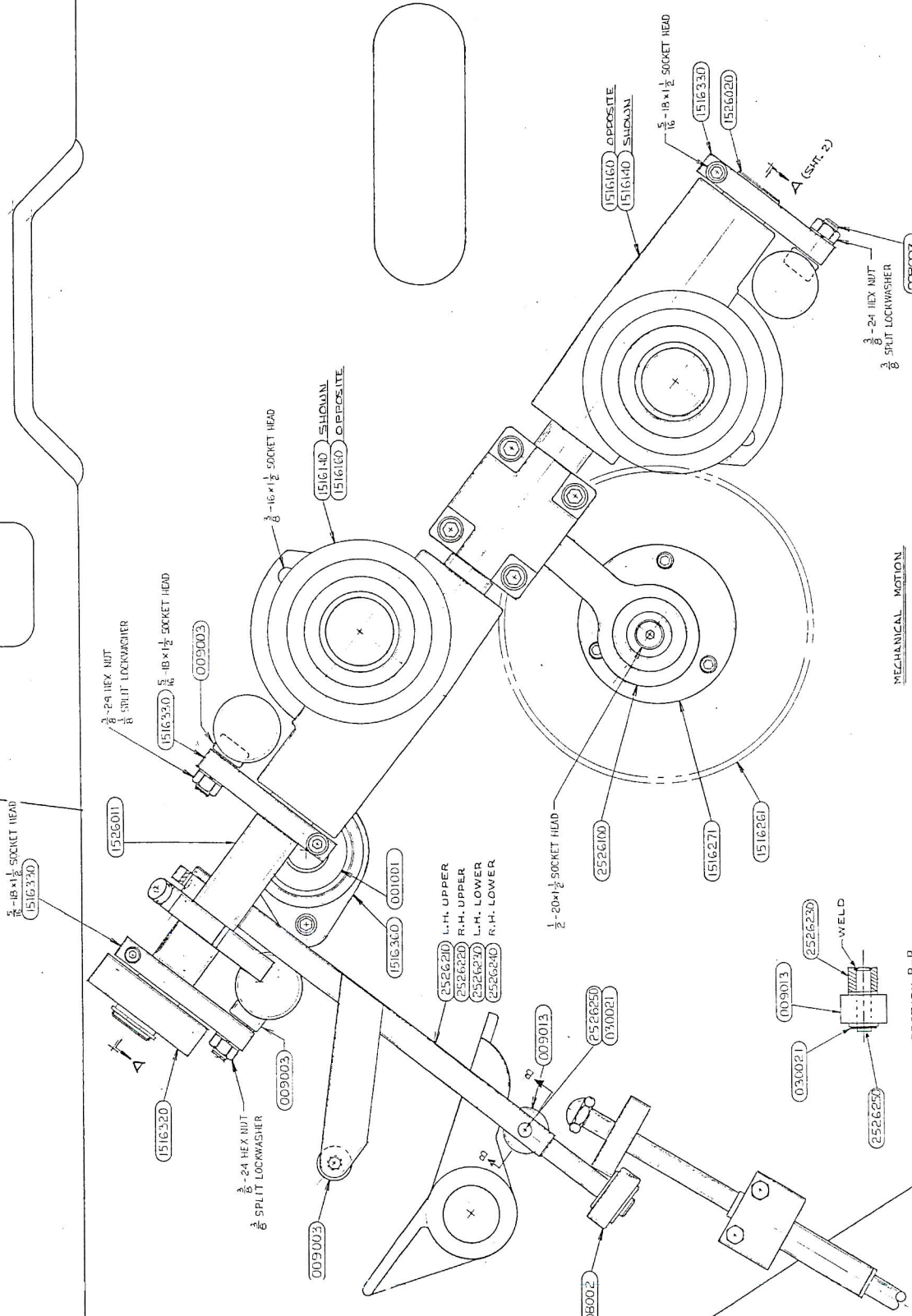


MECHANICAL MOTION
LEFT HAND LOWER DECK SHOWN

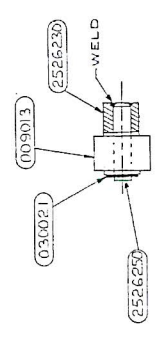
REV	DATE	BY	CHKD	DESCRIPTION
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TITLE: MECHANICAL MOTION ASSEMBLY PART NO: 2526000 SCALE: 1:1 SHEET NO: 1				

REV	DATE	BY	CHKD	DESCRIPTION

REV	DATE	DESCRIPTION



MECHANICAL MOTION
LEFT HAND LOWER DECK SHOWN



DESIGNED BY	ATLAS 212	QUAD	1.1	REVISED BY	GP
CHECKED BY					
MECHANICAL MOTION ASSEMBLY					
DATE	9-14-88	PROJECT NO.	2526000	P. 2	



Brush Dampening System

Brush Dampening 22 ¾" Atlas Quadra-Color Assembly 2825002

Part No.	Description	Qty Req'd
001001	BEARING	18
001051	BEARING	8
001018	BEARING	8
011005	BUSHING, 1" ID x 1 1/8 OD x 1 ¼ LG.	4
011069	BUSHING, .5025 ID x .753 OD x 1 ¼ LG.	8
011054	BUSHING, ¾ ID x 1" OD x 2 1/8 LG.	8
030006	SNAP RING, 1 3/8 SD. EXTERNAL	4
030015	SNAP RING, 2" SD. EXTERNAL	8
035042	THUMB SCREW, ¼ 20 X ¾ LG.	4
050029	HOSE CLAMP, 1 ¾	4
050058	TUBING, VINYL 1" OD x ¾ ID., (INCHES)	84
514130	FOUNTAIN ROLL COVER	4
514360	OSCILLATOR SHAFT BUTTON	4
050118	ELBOW, ½ T x ½ NPT MALE, BRASS	4
515280	WATER FORM ROLL 2-7/8	4
822050	IDLER, WATER FOUNTAIN DRIVE	2
822130	DRIVE PULLEY, BRUSH ROLL	4
822200	ASSEMBLY, BRUSH ROLL	4
822151	CAM, FORM ROLL	2
1514040	FORM ROLL SHAFT	4
1514060	SHAFT, FORM ROLL CAM	4
1514240	PHENOLIC WASHER	16
4514400	OSCILLATOR GEAR ASSEMBLY, L.H.	4
3514270	PIN OSCILLATOR, L.H.	4
3515170	WATER OSCILLATOR	4
1524060	OSCILLATOR BUSHING, G.S.	4
1524070	OSCILLATOR BUSHING, O.S.	4
1524080	BUSHING	8
1822040	ROLL, WATER FOUNTAIN	4

Brush Dampening 22 ¾" Atlas Quadra-Color Assembly 2825002

Part No.	Description	Qty Req'd
035042	THUMB SCREW, ¼ 20 x ¾ LG.	4
050006	VINYL TUBING, 5/8 ID (INCHES)	8
050007	PVC PIPE, 1" ID (INCHES)	144
050011	HOSE CLAMP, ¾"	8
050012	HOSE CLAMP, 1 9/16 TO 1 3/4	8
050013	T-FITTING, 1" x ½ (THREADED) PVC	4
050015	BARB FITTING, ½ MALE PIPE, PVC	4
050028	VINYL HOSE, 1" DIA. (FEET)	84
050027	1" THREADED PIPE x 1" HOSE BARB, PVC	8
050055	O-RING, .737 x .103 THICK, 2	4
050057	REDUCING TEE, 1" x 1" x ¾ THREADED (GSR)	4
050058	VINYL TEE, 1" OD x ¾ ID (INCHES)	84
050059	ADAPTER, 1" S x 1" NPT	4
051068	BALL VALVE, ½ NPT-PVC 73582M (CONS.)	4
050065	HOSE CONNECTOR, ¾ NPT x ¾ BARB, PVC	4
051088	PIPE PLUG, 1/8 MALE, SOCKET,	4
050063	HOSE CLAMP, 1"	4
051075	CLOSE NIPPLE, ½ NPT, PVC	4
050074	HOSE CLAMP, 3/8 - ¾" ID	8
050118	ELBOW, ½ TUBE x ½ NPT MALE (PARKER)	4
515280	WATER FORM ROLL, 2 7/8	4
2825180	STIFFENER, WATER PAN	4
2825250	WATER PAN ASSEMBLY (LOWER DECK #4)	1
2825350	WATER PAN ASSEMBLY (LOWER DECK #1)	1
2825450	WATER PAN ASSEMBLY (UPPER DECK #2)	1
2825550	WATER PAN ASSEMBLY (UPPER DECK #3)	1

Brush Dampening 22 3/4" Atlas Quadra-Color Assembly 2825002

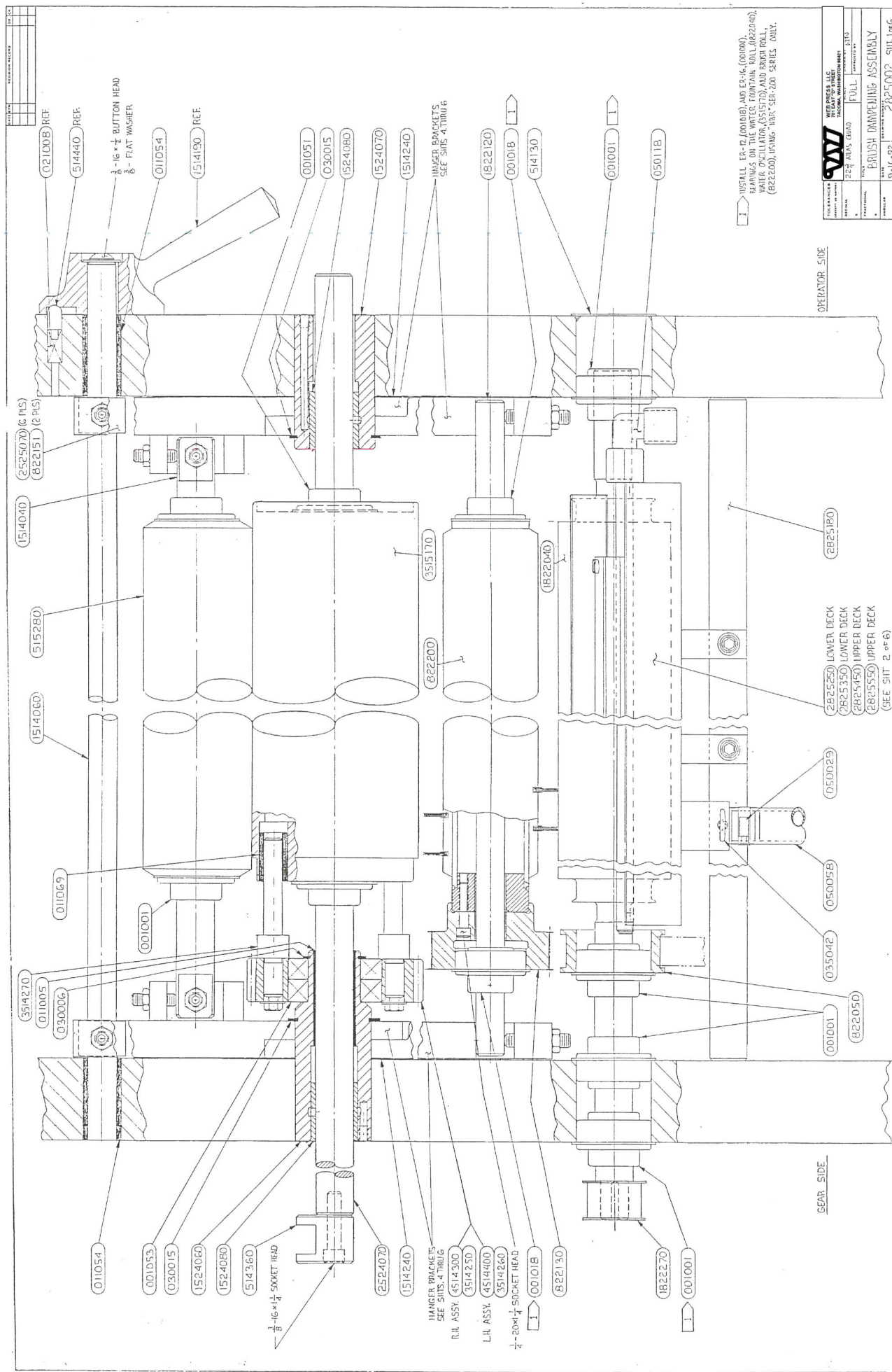
Part No.	Description	Qty Req'd
1822120	SHAFT, BRUSH ROLL	4
1822270	PULLEY, FOUNTAIN DRIVE	4
2524070	SHAFT, OSCILLATOR	4
2525070	CAM, WATER FOUNTAIN	6
2825180	STIFFENER, WATER PAN	4
2525250	WATER PAN ASSEMBLY (LOWER DECK)	1
2825350	WATER PAN ASSEMBLY (LOWER DECK)	1
2825450	WATER PAN ASSEMBLY (UPPER DECK)	1
2825550	WATER PAN ASSEMBLY (UPPER DECK)	1

Brush Dampening 22 ¾" Atlas Quadra-Color Assembly 2825002

Part No.	Description	Qty Req'd
040052	MOTOR, GP	4
040055	MOTOR, ¼ HP, 230V 3 PHASE,	2
040057	MOTOR BRUSH, ¼ HP, 60 HZ,	2
060022	TIMING BELT, 270 L 075	2
060024	TIMING BELT, 210 L 075	2
060046	TIMING BELT, 150 L 075	2
060054	TIMING BELT, 240 L 075	2
822130	DRIVE PULLEY, BRUSH ROLL	4
822160	BRACKET, MOTOR MOUNT	2
822170	DRIVE PULLEY, BRUSH ROLL	4
1822270	PULLEY, FOUNTAIN DRIVE	4
1822320	MOTOR MOUNTING BRACKET	2
1825410	MOTOR MOUNTING BRACKET (LOWER DECK)	2
2825130	BRACKET, BRUSH MOTOR MOUNT	2
2825250	WATER PAN ASSEMBLY (LOWER DECK #4)	1
2825350	WATER PAN ASSEMBLY (LOWER DECK #1)	1
2825450	WATER PAN ASSEMBLY (UPPER DECK #2)	1
2825550	WATER PAN ASSEMBLY (UPPER DECK #3)	1

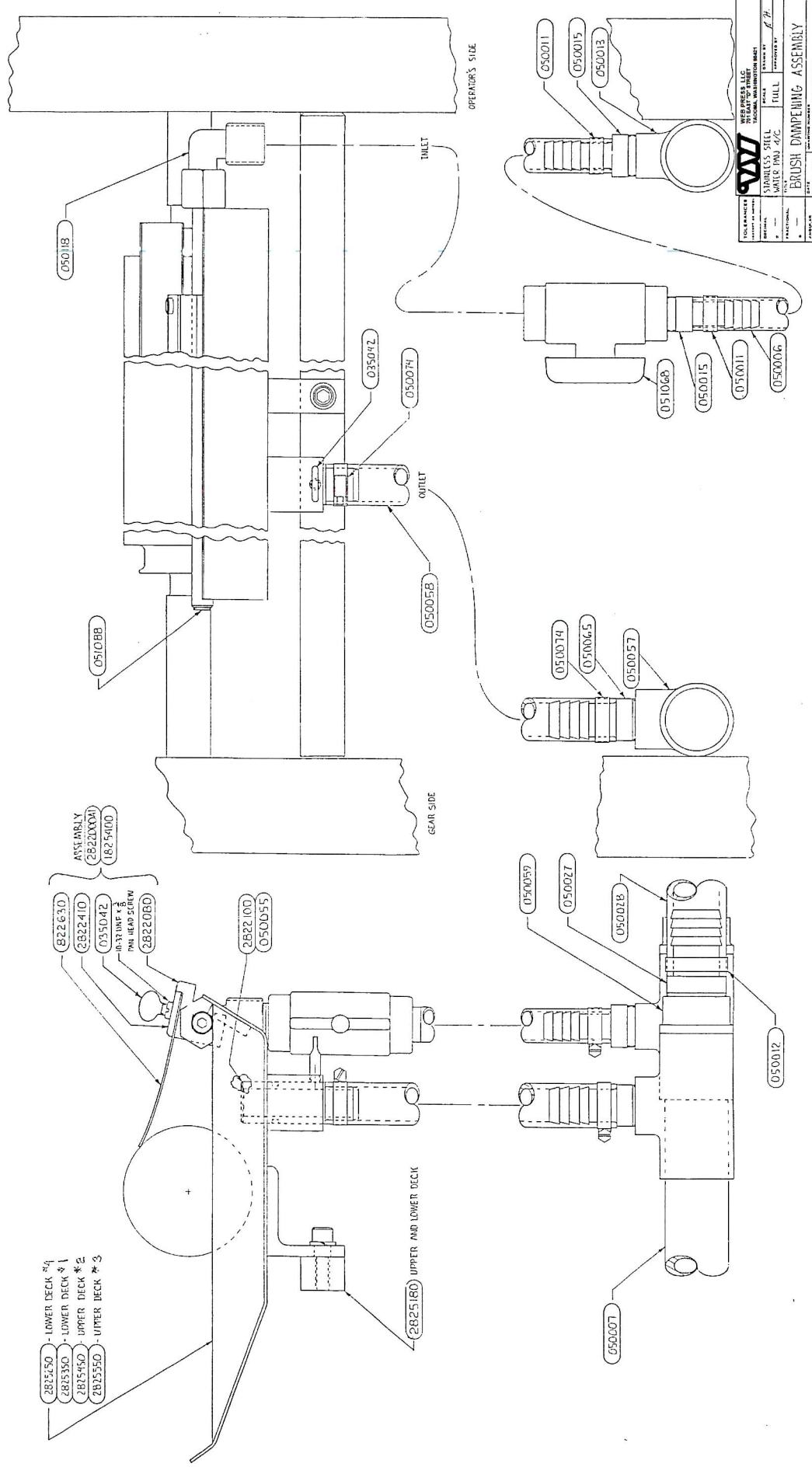
Brush Dampening 22 3/4" Atlas Quadra-Color Assembly 2825002

Part No.	Description	Qty Req'd
020009	TENSION SPRING, 1/2 OD x .080 WIRE DIA. x 1 5/8 LG.,	8
035029	SWING BOLT, 3/8 16 x 2 1/2 LG.,	8
035007	SHOULDER SCREW, 3/8 x 3/4 LG.	8
515280	WATER FORM ROLL, 2 7/8	4
822200	ASSEMBLY, BRUSH ROLL	4
3515170	WATER OSCILLATOR	4
1822040	ROLL, WATER FOUNTAIN	4
2525022	HANGER BRACKET, INK ROLLER	2
2525070	CAM, WATER FOUNTAIN	6
2825121	HANGER BRACKET	8
2822320	STOP, BRUSH ROLL	8
3514020	SCREW, SPRING ADJUSTMENT	16



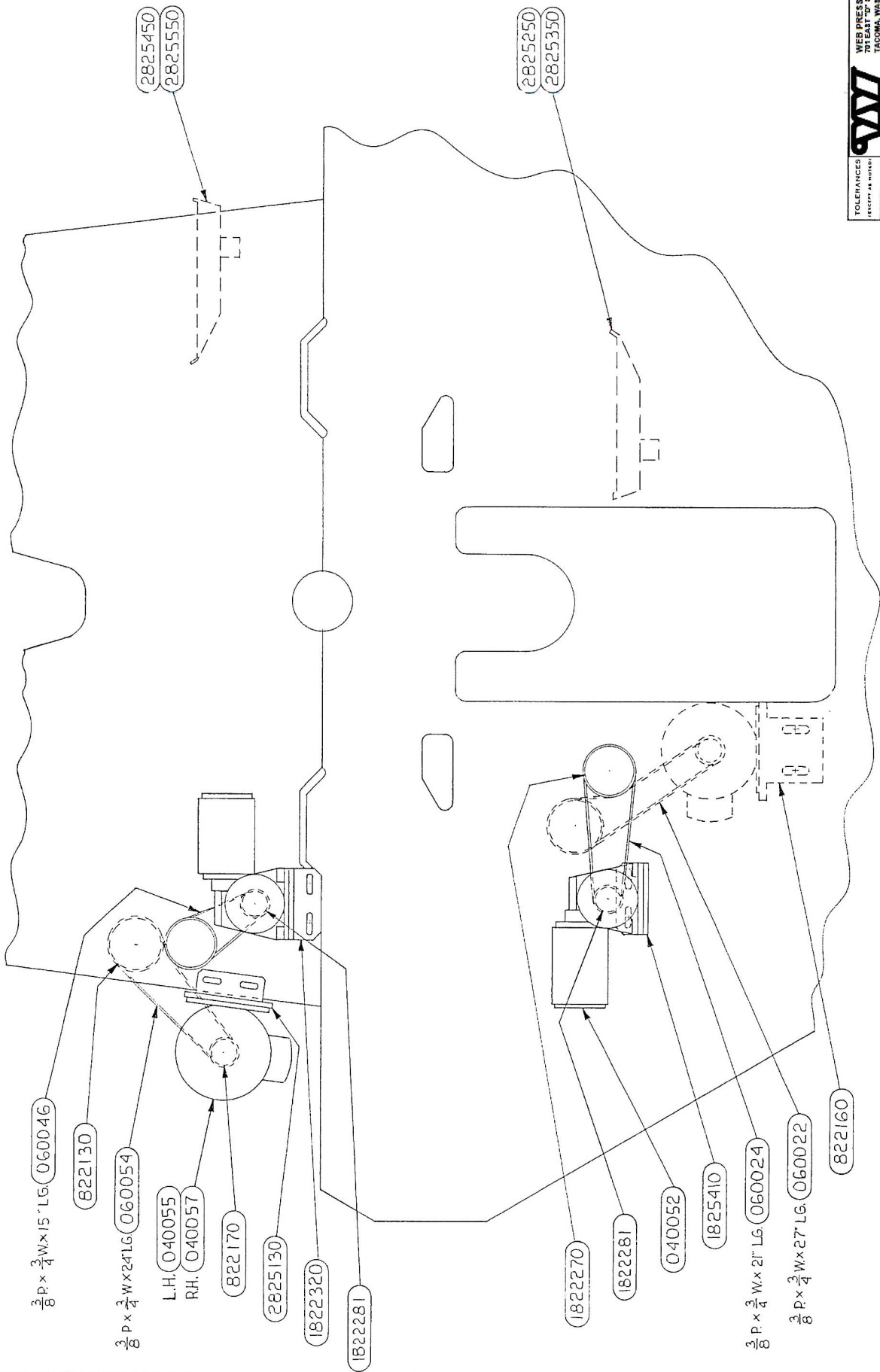
INSTALL ER-12 (00108), AND ER-16 (00100),
 BEARINGS ON THE WATER FRONTAIN ROLL (822046),
 WATER OCCURRING (051570), AND RIGID ROLL,
 (822200), USING "HUN" SER-200 SERIES ONLY.

OPERATOR SIDE 2825002 SHIT. 1 OF 6	GEAR SIDE 2825002 SHIT. 2 OF 6



WATERMATIC SYSTEMS	WES PRESS LLC	REVISED BY	DATE
STAINLESS STEEL	WATER 100-4/C	DESIGNED BY	DATE
FRONTAL	FULL	TESTED BY	DATE
BRUSH DAMPERING ASSEMBLY			
PROJECT	9-16-92	ISSUED BY	DATE
28252002 - SW.2 OF 6			

DATE	BY	REVISION RECORD	DN	CK



$\frac{3}{8}$ P x $\frac{3}{4}$ W x 15" LG (060046)

(822130)

$\frac{3}{8}$ P x $\frac{3}{4}$ W x 24" LG (060054)

L.H. (040055)
R.H. (040057)

(822170)

(2825130)

(1822330)

(1822281)

(2825450)

(2825550)

(2825250)

(2825350)

(1822270)

(1822281)

(040052)


(1825410)

$\frac{3}{8}$ P x $\frac{3}{4}$ W x 21" LG (060024)

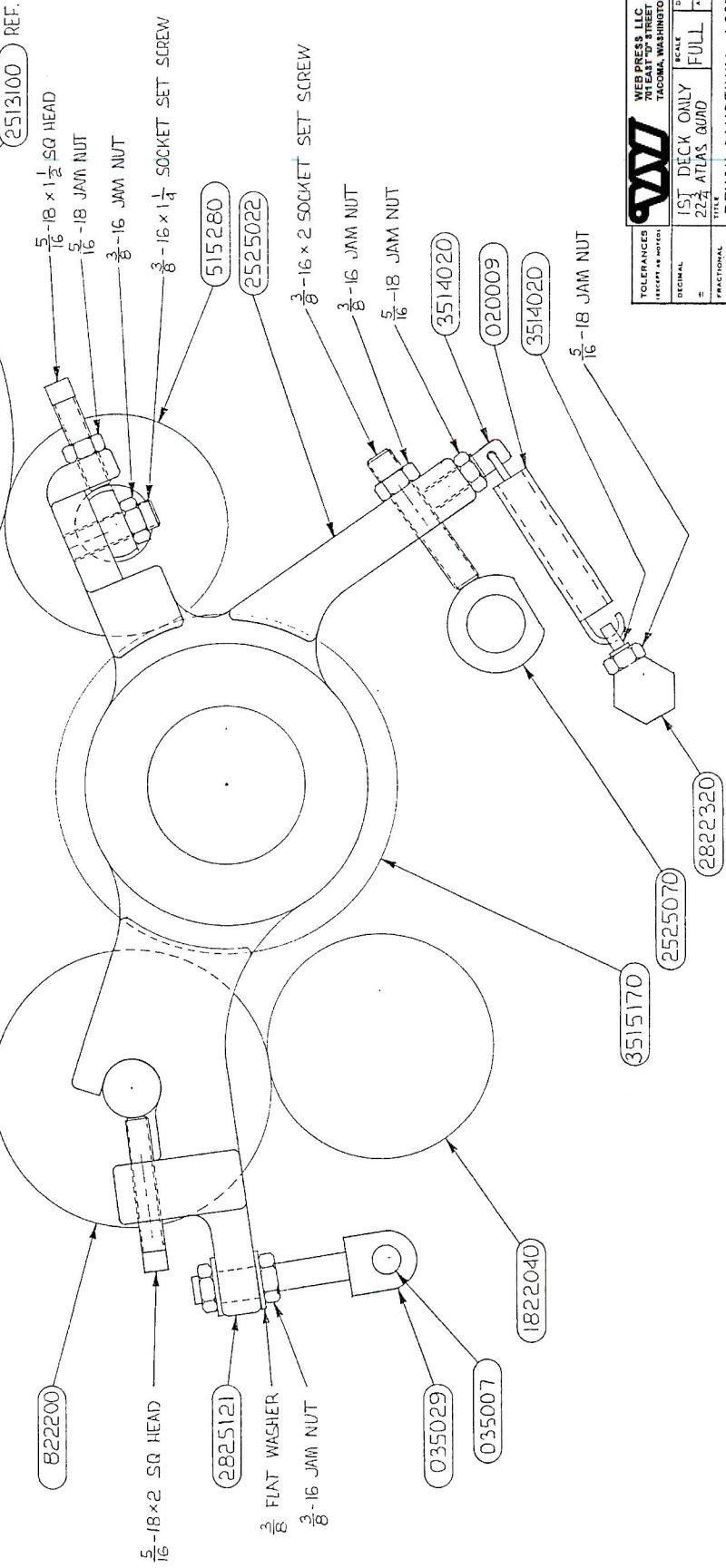
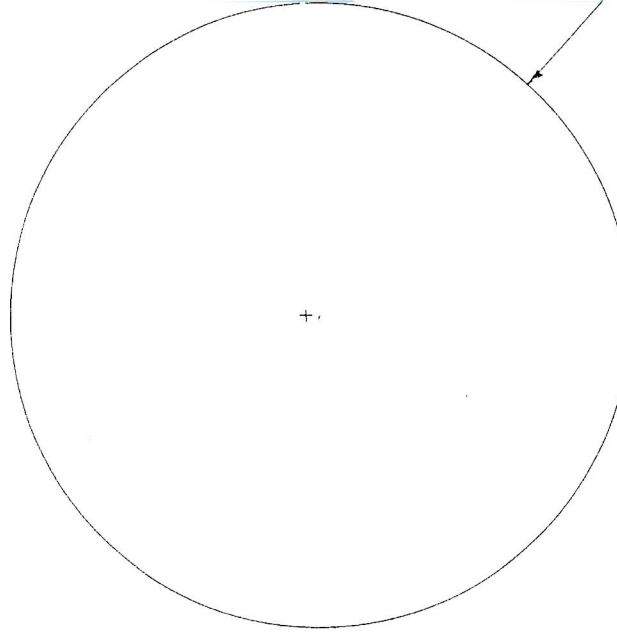
$\frac{3}{8}$ P x $\frac{3}{4}$ W x 27" LG (060022)

(822160)

GEAR SIDE

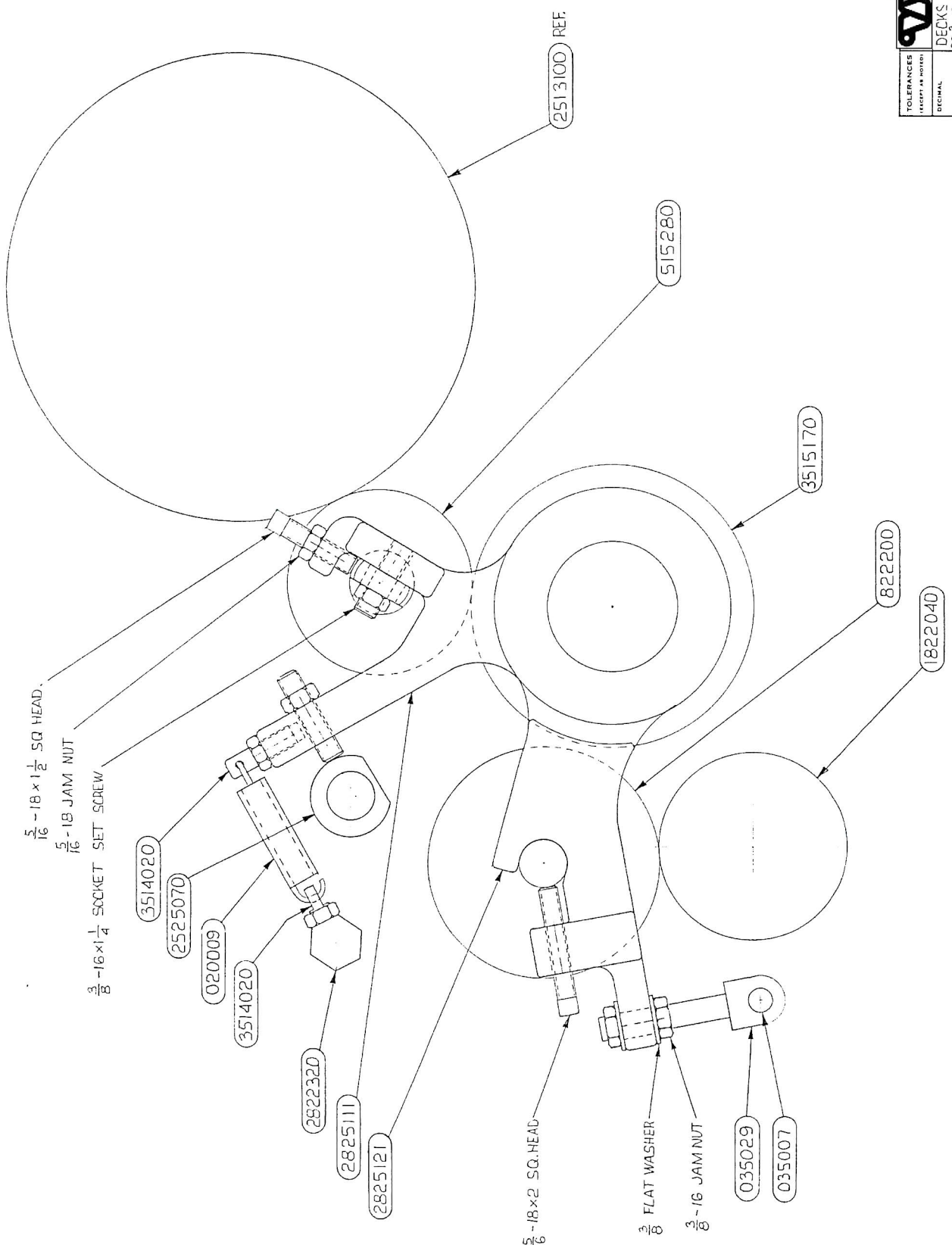
TOLERANCES UNLESS NOTED OTHERWISE		 WEP PRESS LLC 707 EAST 7 TH STREET TACOMA, WASHINGTON 98401	
DECIMAL	± .0005	FRACTIONAL	± .0005
APPROVED BY: J.F.P.		APPROVED BY:	
22 $\frac{3}{4}$ ATLAS QUAD		TITLE: BRUSH DAMPENING ASSEMBLY	
DATE: 9-16-92		DRAWING NUMBER: 2825002	
		SHEET: 3 OF 6	

DATE	REVISION	RECORD	DR. CR.



		WEB PRESS, LLC TACOMA, WASHINGTON 98421	
TOLERANCES UNLESS NOTED	SCALE	DATE	APPROVED BY
DECIMAL	FULL	10-19-88	J-EB
FRACTIONAL			
TITLE BRUSH DAMPENING ASSEMBLY		DRAWING NUMBER 2825002	
DATE 10-19-88		SHEET NUMBER SHT 4 OF 6	

DATE	BY	REVISION	RECORD	OR	ICE



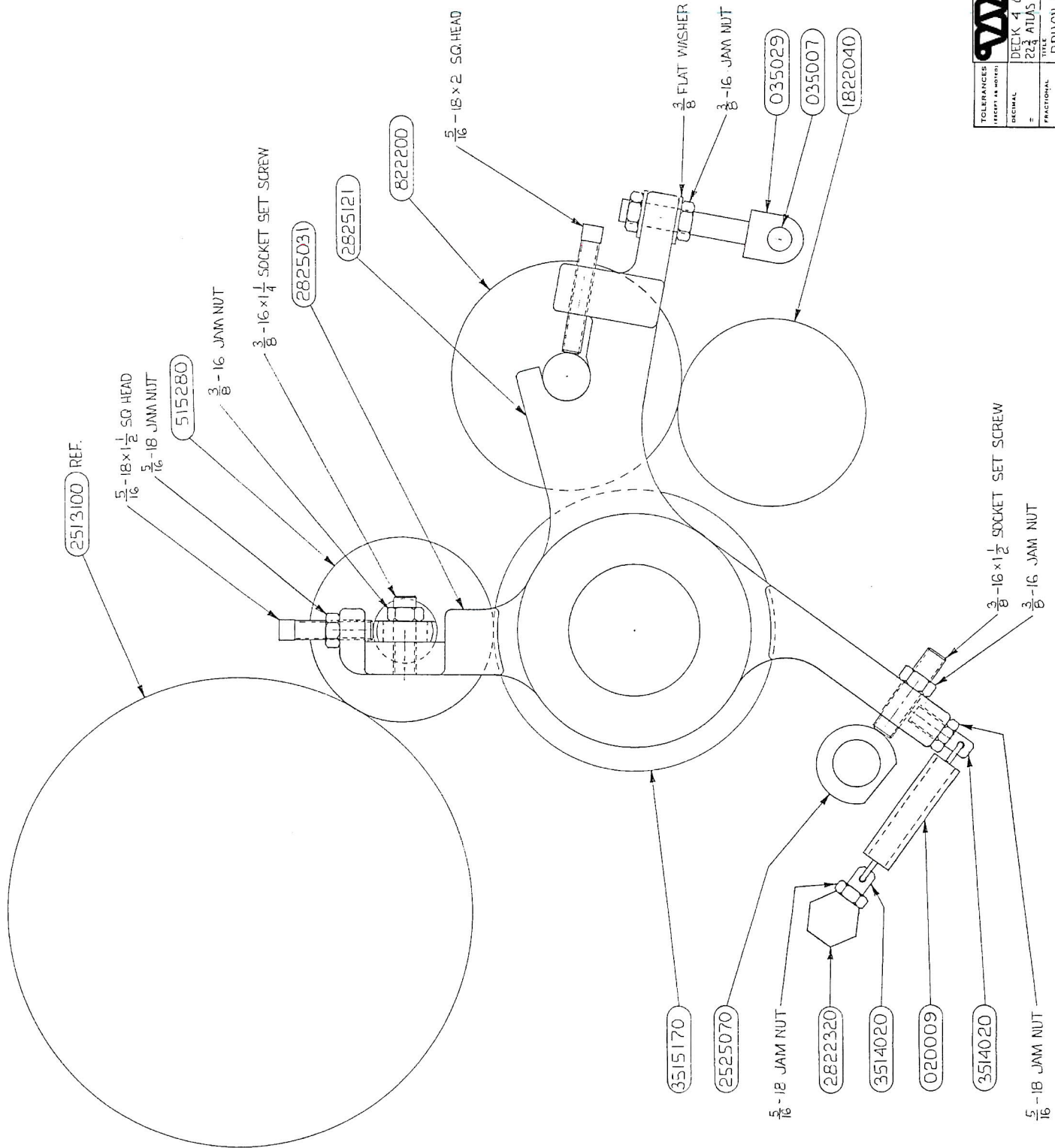
WEP PRESS, LLC
 701 EAST 70TH STREET
 TACOMA, WASHINGTON 98421

DECKS 2 AND 3 SCALE FULL
 22RD AVENUE QUAD DRAWN BY L.S.S.
 APPROVED BY

TOLERANCES UNLESS OTHERWISE SPECIFIED AS NOTED
 DECIMAL FRACTIONAL ANGULAR
 ± ± ±

BRUSH DAMPENING ASSEMBLY
 DATE 10-18-88 DRAWING NUMBER 2825002 SHEET 5 OF 6

DATE	REV	BY	CHK



TOLERANCES UNLESS NOTED		SCALE		DRAWN BY	
DECIMAL	FRACTIONAL	DESK 4 ONLY	FULL	PLJ	PLJ
±	±	223			
ANGULAR		TITLE		DATE	
±		BRUSH DAMPING ASSEMBLY		10-18-88	
		DRAWING NUMBER		SHEET	
		2825002		6 OF 6	



Brush Dampening 22 3/4" Atlas Quadra-Color Assembly 2825002

(Continued From Previous Page)

Option Water Stops Assembly 2822002A1

Part No.	Description	Qty Req'd
1825400	WATER STOP ASSEMBLY	1
2822080	MOUNT, WATER STOP	1
822630	WATER STOP	1
035042	1/4 20 x 3/4" LG. THUMB SCREW	1
2822410	PLATE WATER STOP	1



Water Recirculating System

Water Recirculating System Assembly 813000

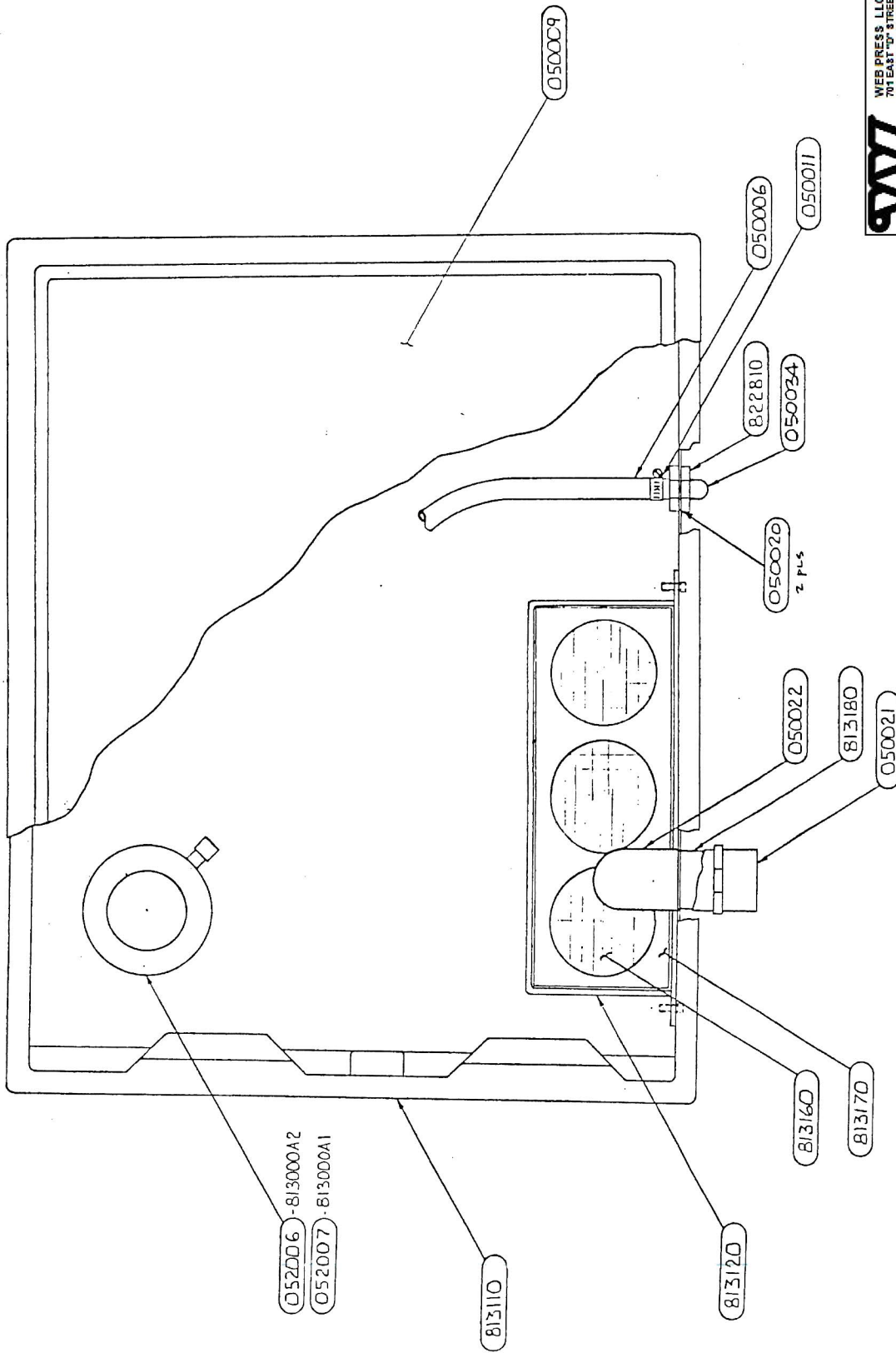
Part No.	Description	Qty Req'd
813110	WATER TANK	1
050008	WATER TANK	1
813120	FILTER BASKET	1
813160	FILTER SCREEN	1
813170	SCREEN HOLDER	1
813180	NIPPLE	1
813220	NIPPLE (NOT SHOWN)	4
050006	VINYL TUBING 5/8 ID (INCHES)	22
050009	LID, WATER TANK	1
050020	O-RING	2
050013	T-FITTING 1 x 1 x 1/2 SCREWED (NOT SHOWN)	2
050014	COUPLER, 1" PVC (NOT SHOWN)	1
050015	MALE BARB FITTING 1/2 PVC (NOT SHOWN)	1
050017	1" CAP SLIP (NOT SHOWN)	4
822810	PIPE NUT	2
050021	COUPLER, 1" SLIP x 1" THREAD	2
050022	90 ° ELBOW "SKTX1" PVC	2
050026	REDUCING BUSHING 1 x 1/2 (NOT SHOWN)	1
050027	1" SCRD PIPE x 1" HOSE BARB PVC (NOT SHOWN)	2
050028	1" VINYL HOSE (FEET) (NOT SHOWN)	25
050063	1 3/4" HOSE CLAMP 5 x 445 (NOT SHOWN)	6
050030	SCREWED T PVC, 1 x 1 x 1 (NOT SHOWN)	1
050034	BARB FITTING 1/2 x 90 °	1

Option – Water Recirculating System Assembly 813000A1

052007	PUMP 300 GPH	1
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Option – Water Recirculating System Assembly 813000A2

052006	PUMP, 500 GPH IP323 (FOR STACKED UNITS ONLY)	1
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WEB PRESS LLC
701 EAST 10TH STREET
TACOMA, WASHINGTON 98421

APPROVED BY:

SCALE: 1/16" = 1"

DATE: 2.2.76

MADE BY: TC

REVISED:

ASSY, WATER TANK

813000

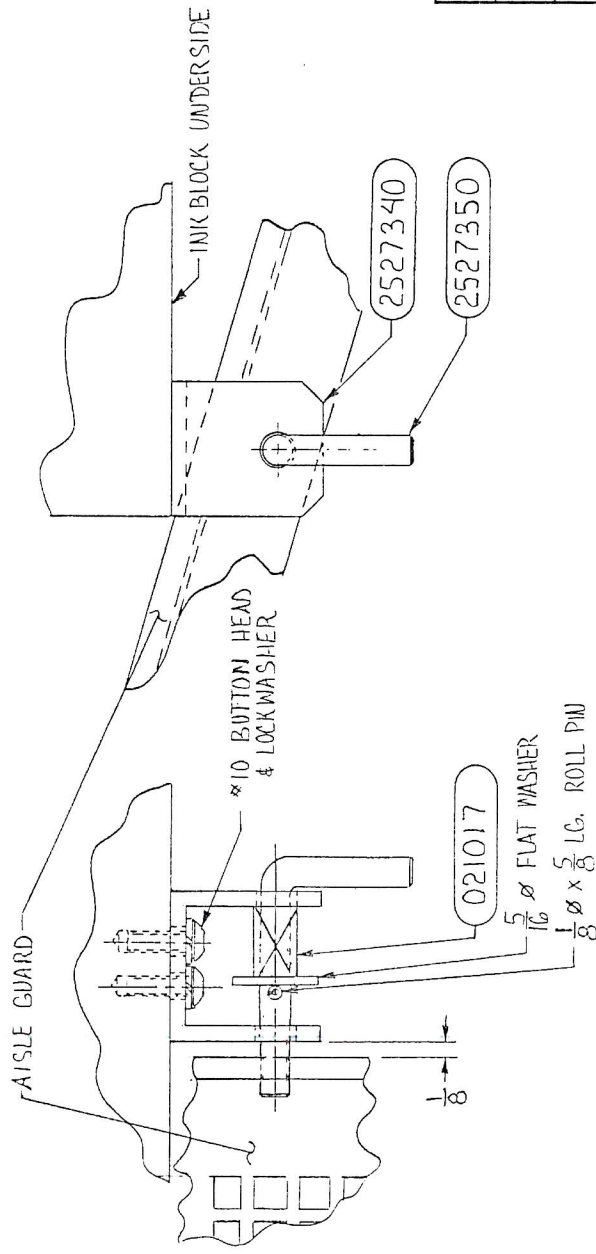
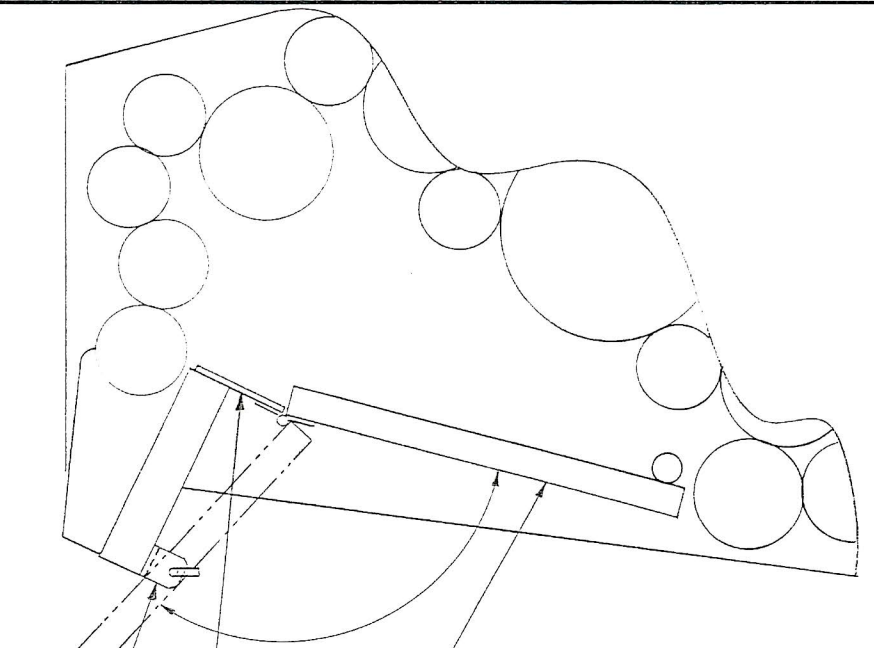


Guards

Option Ink Train Guard 22 3/4" Atlas Quadra- Color Assembly 2527000C

Part No.	Description	Qty Req'd
2527330	LATCH ASSY	2
2527340	BRACKET	2
2527350	PIN, GUARD, LATCH	2
021017	SPRING .360 x 1 1/8 x .026	2
2527251	BAR, GUARD MOUNTING	2
2527241	HINGE	4
2527261	GUARD, FACE, Q.C.	2

DATE BY	REVISION RECORD	DR	CK
2/2/95	REDRAWN - SEE FILE COPY		WEN



DETAIL -A-

	WEB PRESS, LLC 701 EAST 70th STREET TACOMA, WASHINGTON 98421		DRAWN BY WJN
	ATLAS 22 3/4 QUAD		APPROVED BY
TOLERANCES (EXCEPT AS NOTED)		TITLE INK TRAIN GUARD	
DECIMAL ±	FRACTIONAL ±		DATE 7-21-95
ANGULAR ±		DRAWING NUMBER 2527000 C	

Pneumatic Guards 22 3/4" Atlas Quadra-Color Assembly 2527000A

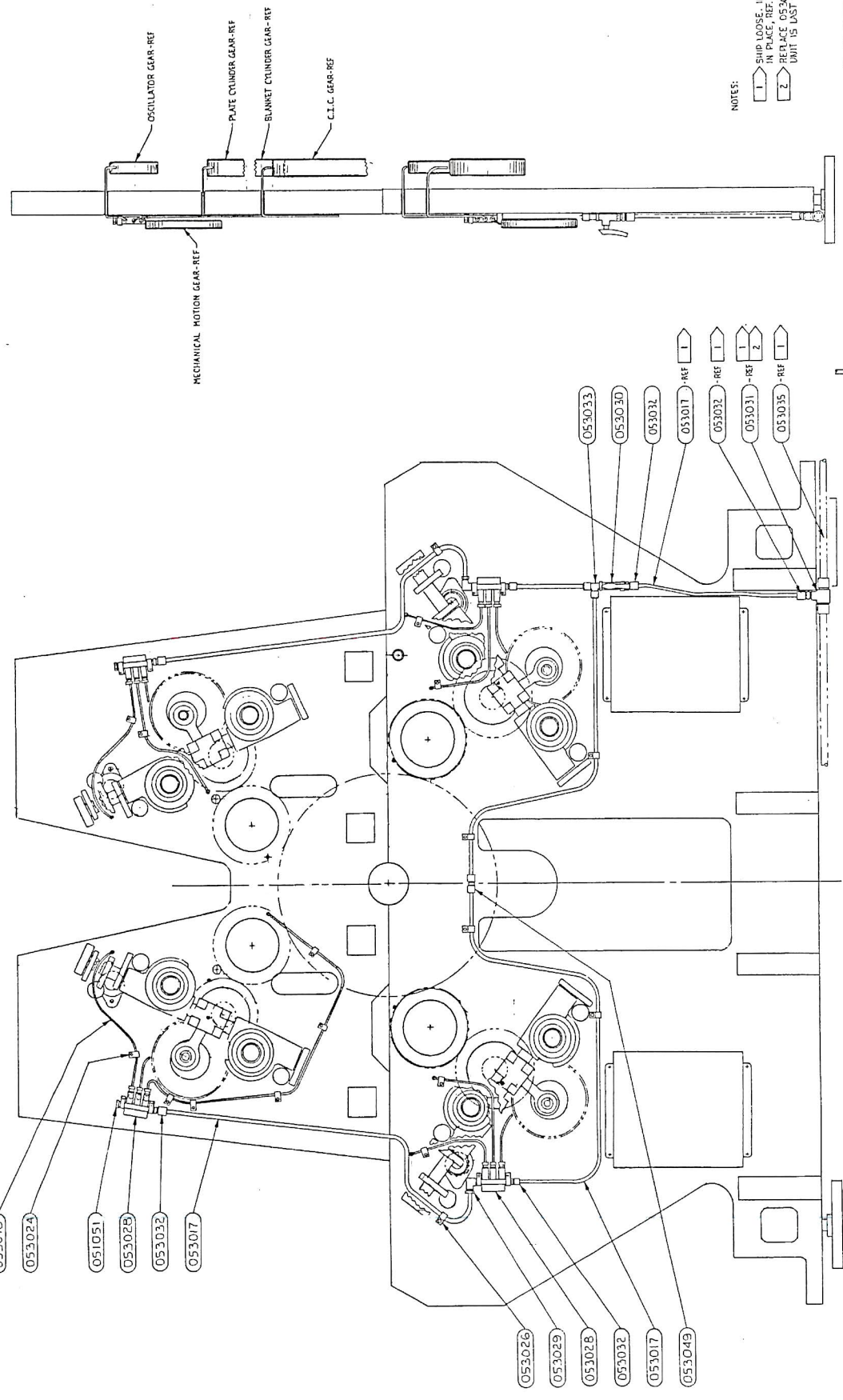
Part no.	Description	Qty Req'd
090124	RUBBER BUMPER	4
090143	LATCH	8
090157	CATCH, FOR 090143 LATCH	8
252730	HINGE	6
2527320	PLATE, BACKING	6
2527010	BRUSH GUARD	2
2527050	BRACKET, MOUNTING GUARD G.S.	1
2527060	STAND OFF	2
2527070	ANGLE MOUNTING	2
2527080	BAR	2
2527100	HINGE	2
2527110	GUARD, O.S. LH	1
2527120	GUARD, O.S. RH	1
2527132	GUARD, 4/C DRIVE LINE	1
2527140	STAND OFF	3
2527170	SHIM	3
2527180	BRACKET, MOUNTING	3
2527190	BRACKET, MOUNTING	3
2527201	SPACER, LATCH	8
2527211	GUARD, GEAR TRAIN	1
2527221	GUARD, GEAR TRAIN	1
2527230	SHAFT GUARD MOUNTING	2
2527270	GUARD, FIBERGLASS	1
2527280	GUARD FIBERGLASS	1
4257090	BRK. MOUNT RIGHT	2
4257100	BRK. MOUNT LEFT	2
4257110	LATCH ANGLE O.S. LEFT	1
090105	CLIP	2
4257120	LATCH ANGLE O.S. RIGHT	1
090105	CLIP	2
4257130	GUARD, LOWER INK TRAIN	2



Auto Lubrication Systems


Autolube, Atlas Quadra-Color Assembly 1823000

Part No.	Description	Qty Req'd
051051	¼ MALE PLUG	2
053017	3/8 STEEL TUBE 62249	10
053018	1/8 STEEL TUBE 62175	16
053024	1/8 TUBING CLAMP 64532-1	15
053026	3/8 TUBING CLAMP 360108	4
053028	INJECTOR 83336-3	4
053029	ELBOW 69082	2
053030	HOKE VALVE 7115 F4S ¼ NPT STAINLESS STEEL	1
053032	MALE CONNECTOR 69071	5
053033	MALE TEE 69090	1
053049	UNION TEE 3/8 69078	1



NOTES:

- 1 SUPPLIERS: INSTALL AFTER UNIT IS IN PLACE REF 053400
- 2 REPLACE 053031 WITH 053034 WHEN UNIT IS LAST IN LINE.


 THE VANDERBILT CORPORATION
 1000 WEST 10TH AVENUE
 DENVER, COLORADO 80202-1000
 (303) 733-1000

ATLAS FOUR COLOR AUTOLORE
 8-0-92 1B32000

Autolube System & Accessories Assembly

1834000

Part No.	Description	Qty Req'd
051053	CONNECTOR 3/8 NPT x 1/2 T	1
051063	NIPPLE 1/4 NPT x 1/4 NPT	1
052035	REDUCER, 1/2 NPT x 1/4 NPT	1
053023	GREASE DISPENSER	1
053035	5/8 OD TUBE (FEET)	Lgth of pressline
053042	MALE ELBOW 5/8 T x 1/2 NPT	1
053037	CENTROMATIC PUMP 25:1	1
053038	LOW LEVEL ALARM KIT	1
053044	GREASE, LUBE (NLGI #1)	1
053046	UNION TEE 5/8	1
053047	UNION L 5/8 T	3
053068	1/8 FERRULE	6
053069	3/8 FERRULE	6
053070	5/8 FERRULE	6
051058	AIR LINE CONTROL	1

Assembly 183400A1 (Basic Hook-Up)

053029	MALE ELBOW 3/8 T x 1/4 NPT	1
053032	MAKE CONNECTOR 3/8 T x 1/4 NPT	1
053026	TUBING CLAMP 3/8 TUBE	2
053017	3/8 STEEL TUBE	UNIT – 3 FT QUAD – 3 FT FOLDER – 6 FT

Assembly 1834000A2 (In-Line)

053075	UNION 5/8 T x 5/8 T (NOTE: ONE PER UNIT, QUAD, FOLDER, EXCEPT END UNIT)	1
053031	FEMALE BRANCH TEE 5/8 T x 1/4 NPT (NOTE: ONE PER UNIT, QUAD, FOLDER, EXCEPT END UNIT)	1
052035	REDUCER 1/2 NPT x 1/4 NPT (NOTE: REQ'D IF PARKER FITTING USER; QUANTITY SAME AS 053031)	

Autolube System & Accessories Assembly 1834000

(Continued From Previous Page)

Assembly 1834000A3 (End Unit or Folder)

Part No.	Description	Qty Req'd
052035	REDUCER, ½ NPT x ¼ NPT (NOTE: REQ'D IF PARKER FITING USED)	
053034	FEMALE ELBOW 5/8 T x ¼ NPT (NOTE: END UNIT OR FOLDER ONLY)	

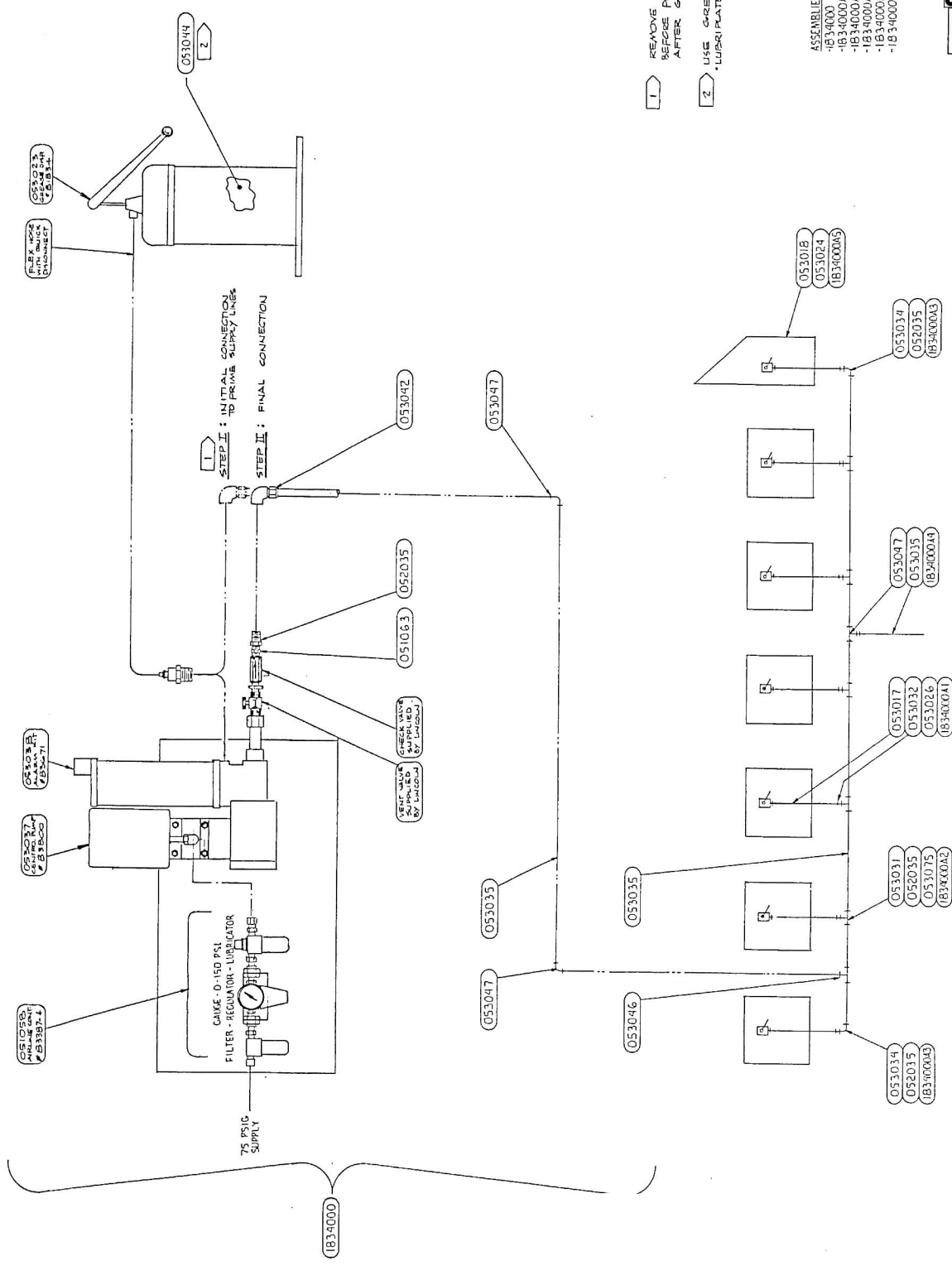
Assembly 1834000A4 (T & A)

053047	UNION 5/8 TEE	4
053035	5/8 OD TUBE (FEET)	20

Assembly 1834000A5 (Cross Perf.)

053018	1/8 STEEL TUBE (FEET)	4
053024	1/8 TUBING CLAMP	4

REV	DATE	DESCRIPTION



- 1 REMOVE INJECTOR PLUGS BEFORE PLUG, REPLACE PLUGS AFTER GREASE COMES OUT.
- 2 USE GREASE LUBRICATE GEARWHEEL #15006 NUG F 4.

ASSEMBLIES INCLUDED
 -1834000 AUTO LUBE SYSTEM
 -1834000A1 OPTION: UNIT HOOP-UP
 -1834000A2 OPTION: LINE JUNCTION
 -1834000A3 OPTION: END UNIT OR ORDER
 -1834000A4 OPTION: TFA AUTO LUBE
 -1834000A5 OPTION: CROSS PERP AUTO LUBE

WELDWRENCH, LLC 151 251 200 051	18-11-92
ALAN REFFELOR PROJECT # 1834000	1834000
AUTO LUBE SYSTEM INSTALLATION	1834000



Compensator

Compensator Assembly 181500

Part No.	Description	Qty Req'd
001054	BEARING	4
005005	THRUST WASHER	2
005006	THRUST WASHER	1
030001	1" EXTERNAL SNAP RING	2
031006	#4 x 2" TAPER PIN	4
032003	1" ID. SET COLLAR	1
032007	5/8 ID. SET COLLAR	2
053001	¼ 28 LUBE FITTING	2
511490	ROLLER CORE	2
814020	BARREL NUT, COMPENSATOR ADJUST.	1
814050	HANDLE, COMPENSATOR ADJUST.	1
814040	SHAFT, IDLER	1
1815010	SHAFT	1
1815020	BARREL NUT, COMP. SIDE FRAME	1

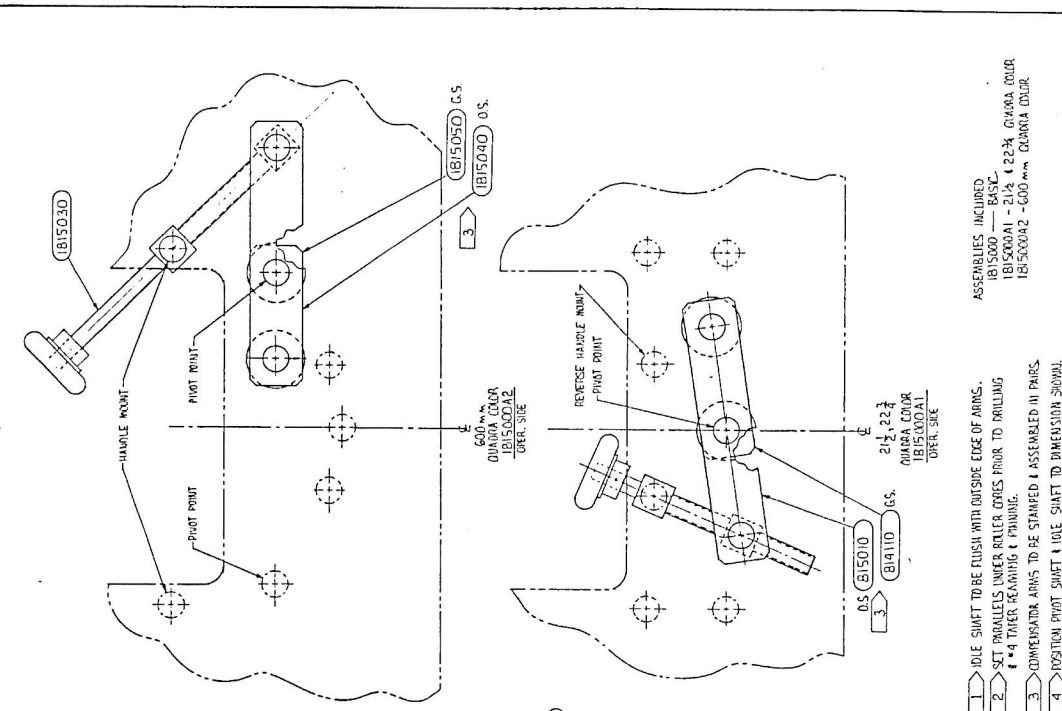
21 ½ - 22 ¾ Atlas Quadra-Color Assembly 1815000A1

814110	ARM, COMPENSATOR G.S.	1
815010	ARM, COMPENSATOR	1
815020	ROD, COMPENSATOR ADJUST. 9"	1

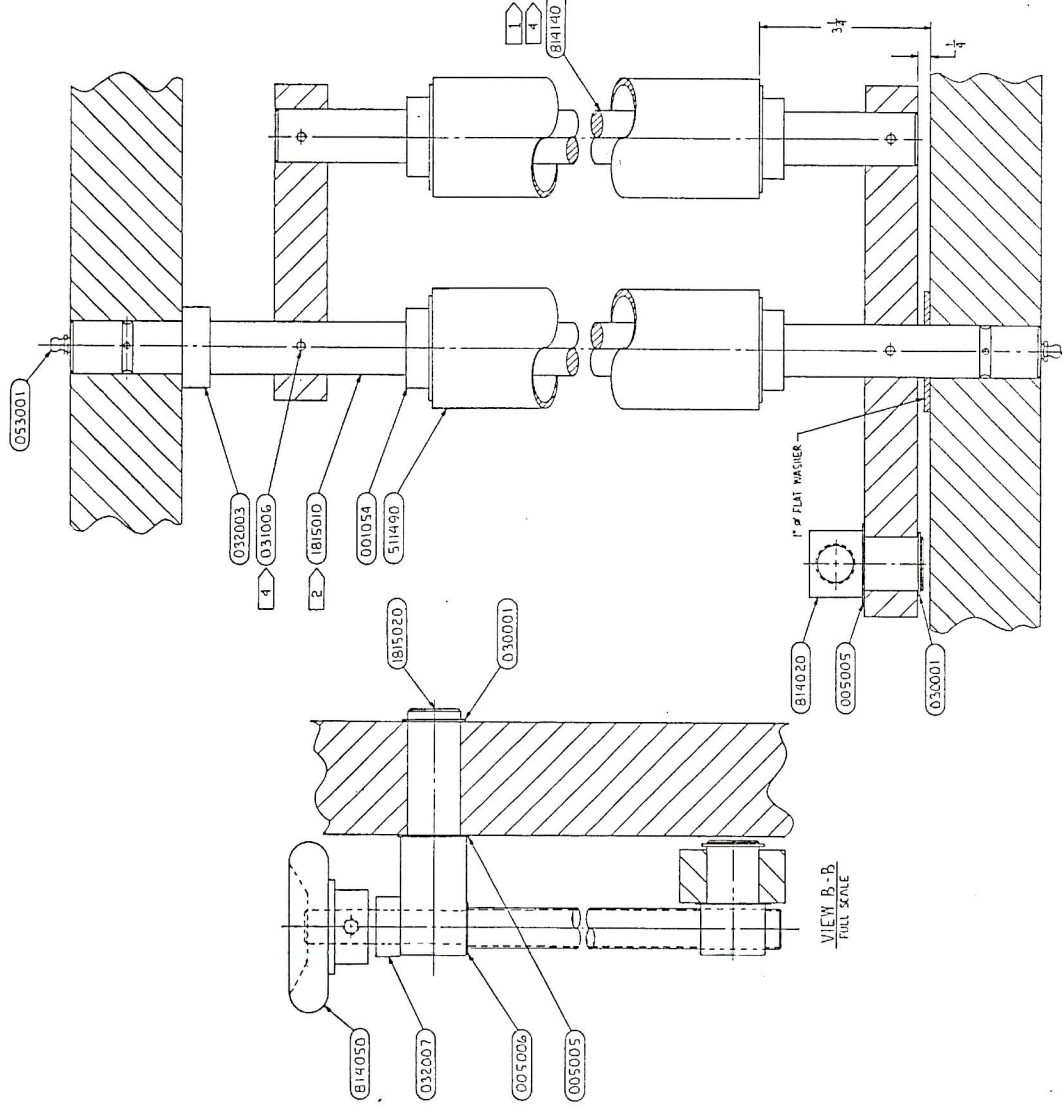
600mm Atlas Quadra-Color Assembly 1815000A2

1815030	ROD, COMPENSATOR ADJUST	1
1815040	ARM, COMPENSATOR	1
1815050	ARM, COMPENSATOR G.S.	1

REV	DESCRIPTION	DATE
1	ISSUED FOR PRODUCTION	10/1/92
2	REVISED TO REFLECT CHANGES TO THE DRAWING	10/1/92



- ASSEMBLIES INCLUDED
 1815000 — BASIC
 1815000A1 — 21 1/2 x 22 3/4 CHAIRA COLOR
 1815000A2 — 600 mm CHAIRA COLOR
- 1 IDLE SHAFT TO BE FINISH WITH OUTSIDE EDGE OF ARMS.
 - 2 SET PARALLELS UNDER ROLLER COXES PRIOR TO DRILLING & 4 THEM REMAINING & FINISHING.
 - 3 COMPENSATOR ARMS TO BE STAMPED & ASSEMBLED IN PAIRS.
 - 4 POSITION PIVOT SHAFT & IDLE SHAFT TO DIMENSION SHOWN. HULL THRU COMPENSATOR ARMS & SHAFT ON ASSEMBLY TO INSTALL TAPER PINS.



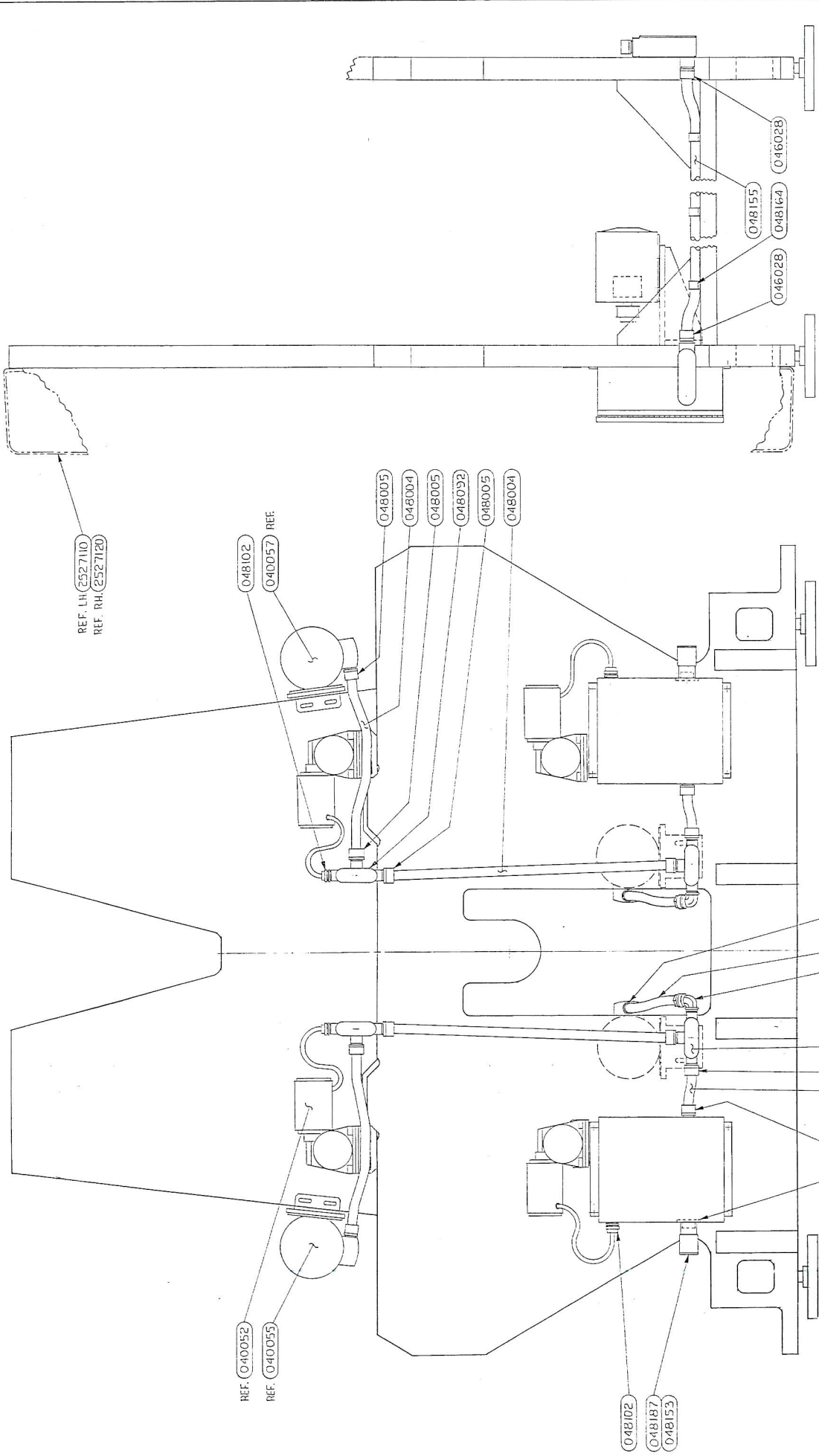
REV	DESCRIPTION	DATE
1	ISSUED FOR PRODUCTION	10/1/92
2	REVISED TO REFLECT CHANGES TO THE DRAWING	10/1/92

COMPENSATOR ASSEMBLY
 1815000, A1 & A2
 3-1-92



Electrical

DATE	DESCRIPTION



REF. LH. (2527110)
REF. RH. (2527120)

(048102)
(040057) REF.

(048005)
(048004)
(048005)
(048092)
(048005)
(048004)

REF. (040052)
REF. (040055)

(048102)
(048187)
(048153)

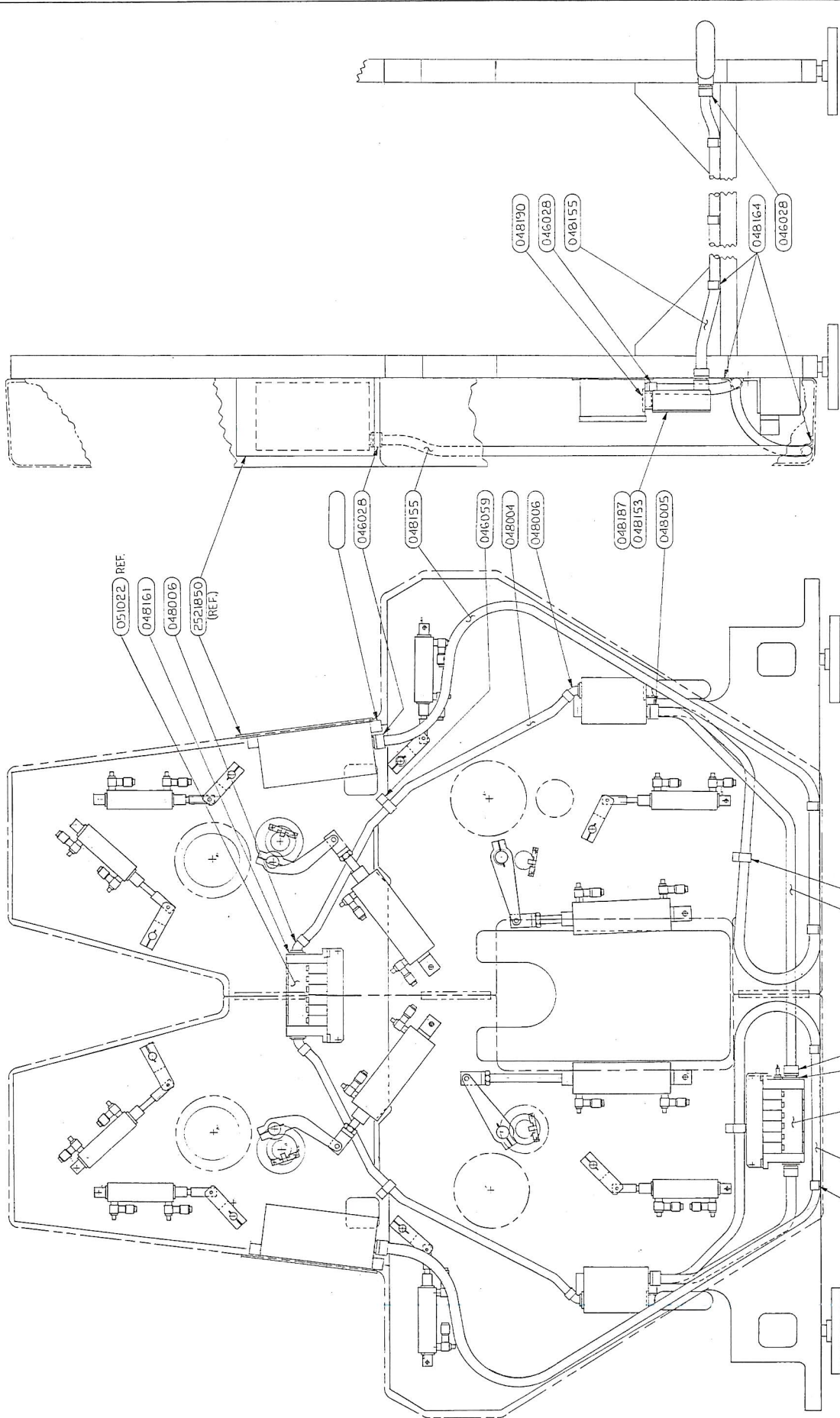
(048190)
(048005)
(048004)
(046018)
(048005)
(048004)
(048005)

GEAR SIDE

(046028)
(048155)
(048164)
(046028)

DRAWING NO. WEB PRESS CORP. KENT WA.	
SCALE	AS SHOWN
SHEET	1 OF 1
REVISED BY	3330
DATE	12-19-88
PROJECT	ATLAS 4/C. DNEU ELECTRICAL
DRAWN BY	12-19-88
CHECKED BY	12-19-88
APPROVED BY	12-19-88
	2951000 D

REV	DATE	DESCRIPTION



		WABER PRESS, LLC 12200 88TH AVENUE FARGO, ND 58103
PROJECT NO. 12-20-88	DRAWING NO. 2951000 D	TITLE ATLAS 4/C PNEU ELECTRICAL
SHEET NO. 1	TOTAL SHEETS 1	DATE 12-20-88