

Atlas Quadra-Color

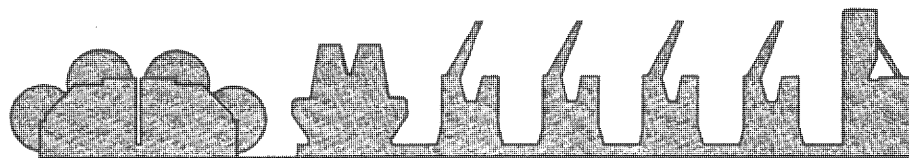
21 1/2 inch model Model 152

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WebPress
Revolutionary

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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. This 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.

INDEX

(PAGE ONE)

21-1/2" ATLAS QUADRA-COLOR - 1520000

21-1/2" ATLAS SPECIFICATION SHEET

GENERAL ASSEMBLY & MAIN DRIVELINE (INDEX).....	1521000
BLANKET CYLINDER.....	1522000
- BLANKET CYLINDER, 21-1/2" ATLAS QUADRA-COLOR.....	1522000A1
- BLANKET CYLINDER W/REDUCED T-BAR.....	1522000B1
- REFERENCE, MANUAL THROW-OFF.....	2840000
PLATE CYLINDER.....	1523000
- STANDARD PLATE CYLINDER.....	1523000A1
- REVERSE PLATE CYLINDER.....	1523000A2
- REFERENCE, MANUAL THROW-OFF.....	2840000
INK SYSTEM (SHT 1 OF 3).....	1524001
INK SYSTEM (SHT 2 OF 3).....	1524001
INK SYSTEM (SHT 3 OF 3).....	1524001
BALDWIN INK WASH-UP.....	2524001A1
- MOUNTING.....	2524001A2
- BALDWIN INK FOUNTAIN DIVIDER.....	2524001B1
MECHANICAL MOTION (SHT 1 OF 2).....	1526000
MECHANICAL MOTION (SHT 2 OF 2).....	1526000
- ADJUSTING TOOL.....	2526000A1
- HANDWHEEL.....	2526000A2
BRUSH DAMPENING (SHT 1 OF 6).....	1825002
BRUSH DAMPENING (SHT 2 OF 6).....	1825002
- OPTION WATER STOPS.....	2825002A1
BRUSH DAMPENING (SHT 3 OF 6).....	1825002
BRUSH DAMPENING (SHT 4 OF 6).....	1825002
BRUSH DAMPENING (SHT 5 OF 6).....	1825002
BRUSH DAMPENING (SHT 6 OF 6).....	1825002
AUTO LUBE SCHEMATIC	
AUTO LUBE, ATLAS QUADRA-COLOR.....	1832000
SL-32 INJECTOR SPECIFICATION SHEET	
AUTO LUBE SYSTEM INSTALLATION.....	1834000
- UNIT HOOK UP.....	1834000A1
- LINE JUNCTION.....	1834000A2
- END UNIT OR FOLDER.....	1834000A3
- T&A AUTO LUBE.....	1834000A4
- CROSS PERFECTOR AUTO LUBE.....	1834000A5
AIR OPERATED GREASE PUMP SPECIFICATION SHEET	

INDEX
(PAGE TWO)

21-1/2" ATLAS QUADRA-COLOR - 1520000

COMPENSATOR.....	1815000
- 21-1/2" AND 22-3/4" ATLAS QUADRA-COLOR.....	1815000A1
- 600mm ATLAS QUADRA-COLOR.....	1815000A2
PNEUMATIC THROW-OFF (SMC).....	2830001
- 21-1/2" AND 22-3/4" ATLAS QUADRA-COLOR.....	2830000A1
- 600mm ATLAS QUADRA-COLOR.....	2830000A2
GUARDS	
PNEUMATIC, QUADRA-COLOR.....	1527000A
MANUAL, QUADRA-COLOR.....	1527000B
INK TRAIN GUARDS.....	1527000C

ATLAS 21¹/₂

Specifications

Max. full width web	36"	914mm
Min. full width web	18"	457mm
Nominal cutoff	21-1/2"	548mm
Image length*	20-1/2"	523mm
Plate gap	3/16"	4.76mm
Plate size	22-3/4 × 36"	578 × 914mm
Plate thickness	.009"	.22mm
Blanket size	23-1/4 × 36"	590 × 914mm
Blanket thickness	.065"	1.65mm
1st Ink form	2-3/4"	70mm
2nd 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"	± 3.175mm
Circumferential, both sides	±.100"	± 2.54mm
Quadra-Color unit		
Sidelay	±.125"	± 3.175mm
Circumferential	±.100"	± 2.54mm
Skewing	±.012"	± .3mm
Roll Sidelay	±.437"	± 11mm
Speed	30,000 i.p.h.	
Folder	2:1 jaw	
Folder capacity	10 webs	
Products	Broadsheet	
	Tabloid	
	Magazine	
	Options:	
	Digest - 2-off	
	Digest - 1-off	
*Optional image length	20-7/8"	533mm

STANDARD EQUIPMENT

Brush dampener	Electric copy counter
Double-ended plate bender	Startup time delay and warning bell
Factory supplied blankets, rollers	Water recirculator, factory installed
Handwheels	Quarter fold seam moistener
Full width platforms	Water stops
Spare roll shaft and chucks	Lockable electric counter
Spare blankets	Anti-offset tape
Asst. spare folder parts	Floor-level, pneumatic clutches
Tachometer (i.p.h.)	Automatic grease lubrication
Portable delivery table	EC standard compliant for export
Aisle guards	Roll carts with IRU's

OPTIONAL EQUIPMENT

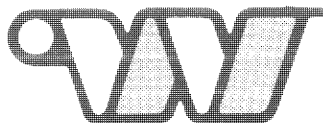
Pneumatic throwoffs	Twinned folders
Stacked units	Under and over folder leads
Integrated Rollstand Units	Extended delivery table
Digital Vector Drive	Perforation: In-line
Unit washup devices	Across the web
Fountain dividers	Ribbon shifters
Swing units	Air former
Cross-association leads	Upper former
Direct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

PRODUCT SIZES

Number 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		
Maximum Size	21-1/2 × 18 in. 548 × 457mm	18 × 10-3/4 in. 457 × 273mm	9 × 10-3/4 in. 229 × 273mm	18 × 5-3/8 in. 457 × 136mm	
Minimum Size	21-1/2 × 9 in. 548 × 229mm	9 × 10-3/4 in. 229 × 273mm	4-1/2 × 10-3/4 in. 114 × 273mm	9 × 5-3/8 in. 229 × 136mm	

These sizes assume even fold (no overlap). High or low folio lap can be obtained to a maximum of approximately 1/4 inch (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.



Web Press Corporation

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Represented in Principal Cities Worldwide

ATLAS

(21-1/2")

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 flexibility, 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.

PERFECTING UNIT

Unique among single-width presses, the 21-1/2 x 36 inch (548 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 press operator 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. 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. The Atlas perfecting unit is now available in an Integrated Roll Unit (IRU) model. In addition to the above features, the IRU can be equipped with an automatic roll loading mechanism that will transfer a roll from its dolly to its operating position mechanically.

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. 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. The Quadra-Color is now available with an independent Digital Vector Drive, enabling it to be placed in-line with competitive model presses as well. Four colors in five feet - only with Web Press Corporation's Quadra-Color.

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. The unique folded edge forward, half-fold delivery is ideal for delivery of products to stackers or count-oveyors. 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, 21-1/2" ATLAS QUADRA-COLOR
ASSEMBLY 1521000**

PART NO.	DESCRIPTION	QTY. REQ'D
001054	ER-16X BEARING	6
005010	SPHERICAL WASHER	8
031021	DOWEL PIN 1/2 x 3" LONG	8
090122	ATLAS WEB LEAD NAME PLATE	1
511490	ROLLER CORE	3
511580	LABEL, SIDELAY TO OPERATOR	4
1521080	GEAR, IMPRESSION CYLINDER L.H.	1
1511380	SHAFT, STIFFENER, 49-1/16 LONG	3
1521150	SHAFT, STUB, OUTRIGGER	2
1527010	TIE STRAP	4
2511410	LEVELING PAD	4
1521010	SIDE FRAME - LOWER G.S.	1
1521020	SIDE FRAME - LOWER O.S.	1
1521030	SIDE FRAME - UPPER G.S.	1
1521040	SIDE FRAME - UPPER O.S.	1
2521071	STIFFENER, LOWER FRAME	2
1521131	INK COVER	2
1521351	IMPRESSION CYLINDER	1
511260	LEVELING BOLT	4
1726020	SHAFT, STIFFENER, 45-1/4" LONG	1
1521420	OUTRIGGER, O.S., 21-1/2	2

**OPTION, STANDARD ATLAS QUADRA-COLOR
ASSEMBLY 1521000A1**

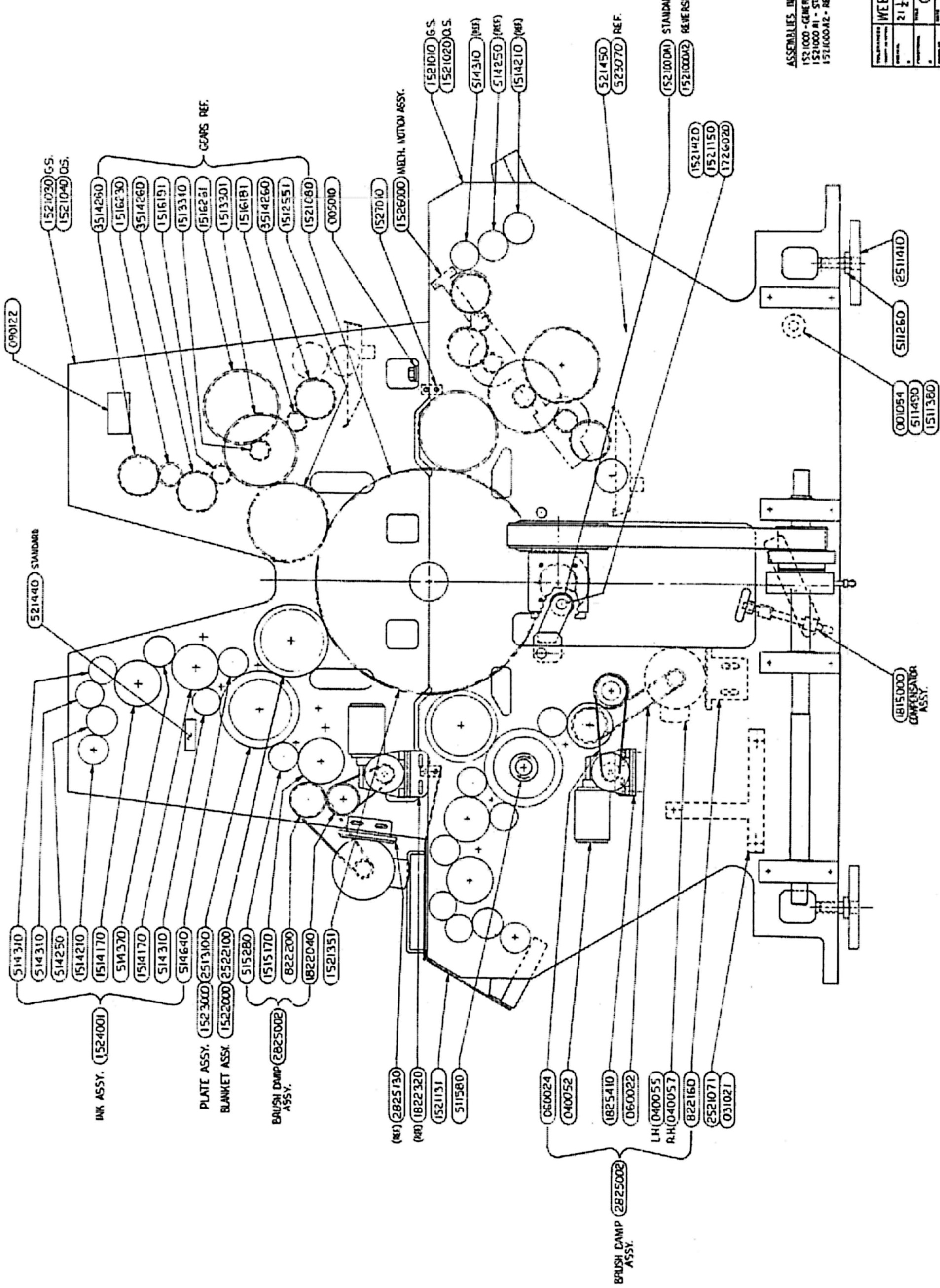
001054	BEARING, ER-16X	2
511490	ROLLER CORE	1
1521150	SHAFT, STUB, OUTRIGGER	2
1726020	SHAFT, STIFFENER	1
1521420	OUTRIGGER, O.S.	2
521440	LABEL - OPERATOR, SKEWING TO PINS	4
521450	LABEL - OPERATOR, CIRC. TO PINS	4

**OPTION, REVERSE ATLAS QUADRA-COLOR
ASSEMBLY 1521000A2**

001054	BEARING, ER-16X	2
511490	ROLLER CORE	1
1521160	OUTRIGGER, O.S.	1
1521180	OUTRIGGER, G.S. REVERSED	1
1521150	SHAFT, STUB, OUTRIGGER	2
1521140	SHAFT, STIFFENER, LOWER DECK	1
521440	LABEL - OPERATOR, SKEWING TO PINS	4
521450	LABEL - OPERATOR, CIRC.TO PINS	4

**GENERAL ASSEMBLY 21-1/2" ATLAS QUADRA-COLOR
ASSEMBLY 1521000
REFERENCE GEARS**

PART NO.	DESCRIPTION	USED ON
1521080	GEAR, IMPRESSION CYLINDER	1521000
1513340	GEAR, DRIVE PLATE CYLINDER	1523000
3514260	GEAR, L.H. OSCILLATOR	1514001
1516261	GEAR, MECHANICAL MOTION	1526000
1513301	GEAR, CIRC. PLATE CYL. L.H.	1523000
1516181	GEAR, PINION R.H.	1526000
1516191	GEAR, PINION R.H.	1526000
1516230	GEAR, PINION R.H.	1526000
1512551	GEAR, BLANKET CYLINDER	1522000

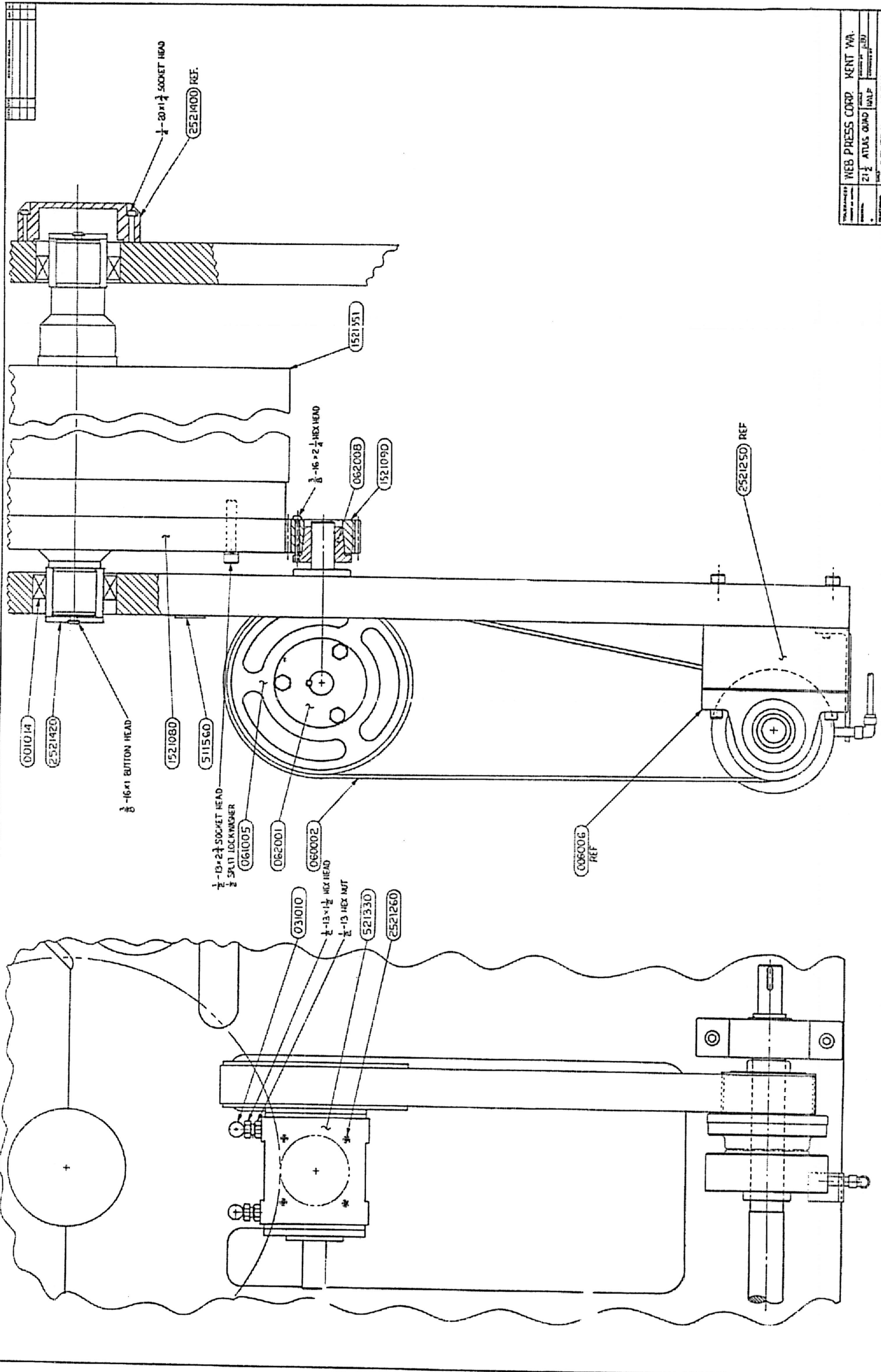


ASSEMBLIES INCLUDED
 1521000 - GENERAL ASSEMBLY
 1521000 #1 - STANDARD
 1521000 #2 - REVERSED

WEB PRESS CORP. KENT WA.	
21 1/2 ATUS QMB	REVISED BY
11-30-92	1521000
GENERAL ASSEMBLY	Page 10 of 62
SHT 1 of 2	

**GENERAL ASSEMBLY 21-1/2" ATLAS QUADRA-COLOR
ASSEMBLY 1521000**

PART NO.	DESCRIPTION	QTY. REQ'D
001014	BEARING, ER-36	2
031010	DOWEL PIN 3/4 x 3" LONG	2
060002	TIMING BELT, 700 H 200	1
061005	PULLEY, 60 H 200 (TIMING BELT)	1
062001	TAPER BUSHING, SF 1-1/4	1
062008	TAPER BUSHING, SD 1-1/4	1
511560	NAME PLATE	1
521330	GEAR BOX, MAIN DRIVE	1
1521080	GEAR, IMPRESSION CYLINDER L.H.	1
1521090	PINION GEAR	1
2521260	STUD, INPUT GEAR BOX	4
2521420	RETAINER	2
1521351	IMPRESSION CYLINDER	1



**QUADRA-COLOR AIR CLUTCH, AUTO
ASSEMBLIES 2521000 B3-B2B**

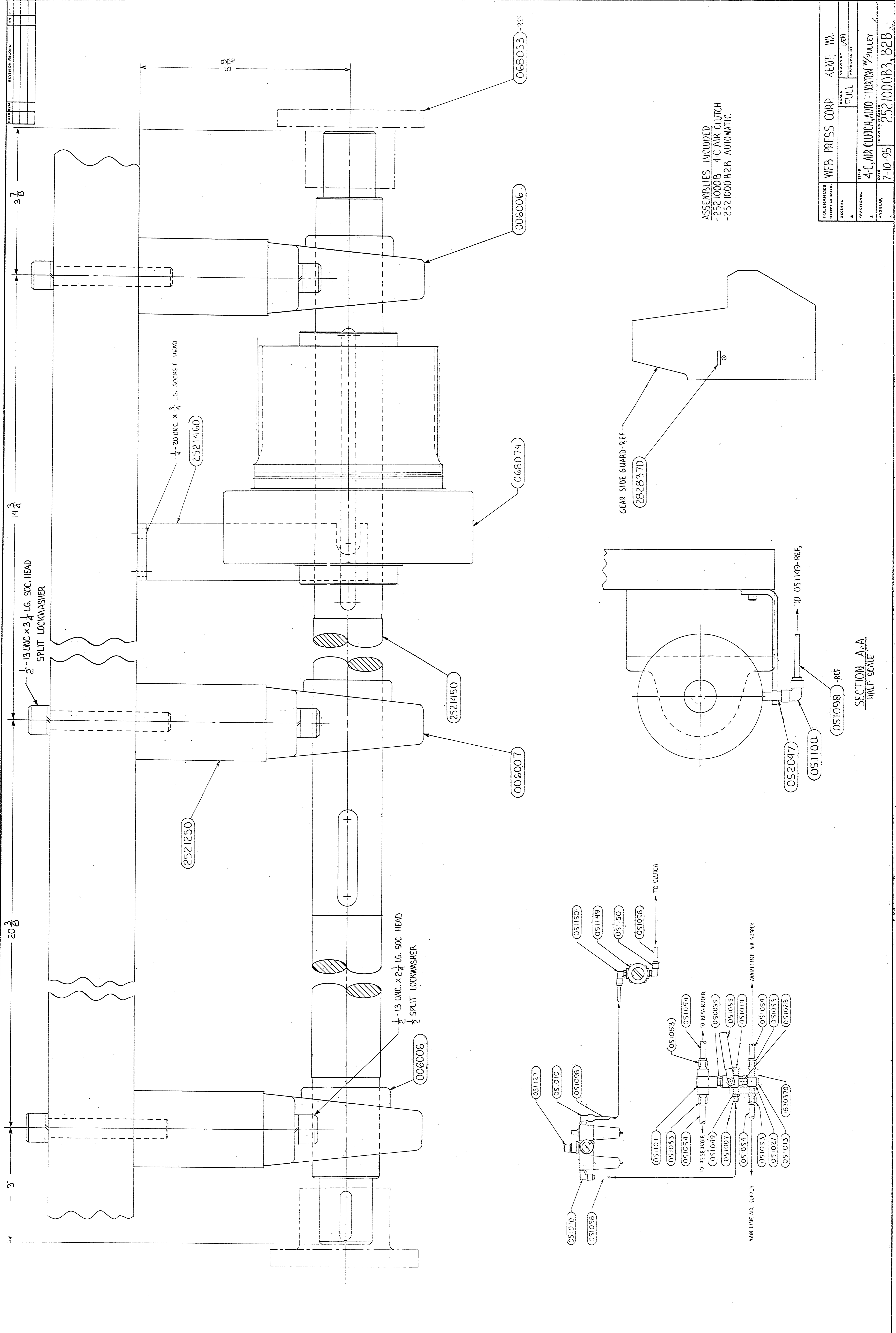
ASSEMBLY 2521000B3 (BASIC)

PART NO.	DESCRIPTION	QTY REQ'D
006006	C25 - 1-3/4 BEARING	2
006007	C25 - 1-13/16 BEARING	1
051010	SWIVEL ELBOW 1/4 T x 1/4 NPT	2
051149	VALVE, SMC, NVM130-N01-34B	1
051098	1/8 ID x 1/4 OD TUBING (FEET)	10
052047	NIPPLE 1/8 NPT x 3/4" LONG	1
051100	FEMALE ELBOW 1/4 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 1/4 TUBE	2
068074	HORTON AIR CLUTCH, 5H50TP	1

ASSEMBLY 2521000B2B (AUTOMATIC)

051010	SWIVEL ELBOW 1/4 T x 1/4 NPT	1
051014	PIPE PLUG 3/8 NPT	1
051053	CONN. 1/2 T x 3/8 NPT	2
051054	1/2 O.D. TUBING (FEET)	10
051013	PLUG	1
1830370	JUNCTION BOX	1

NO.	DATE	REVISION



SECTION A-A
 HALF SCALE

TOLERANCES UNLESS OTHERWISE SPECIFIED	WEB PRESS CORP.	KENT, WA.
DECIMAL	SCALE	DRAWN BY PJB
FRACTIONAL	FULL	APPROVED BY
ANGULAR	TITLE	DATE
	4-C, AIR CLUTCH, AUTO - HORTON 1/2 PULLEY	7-10-95
	QUANTITIES	2521000B3, B2B

Blanket Cylinder

**BLANKET CYLINDER 21-1/2" ATLAS QUADRA-COLOR
ASSEMBLY 1522000**

PART NO	DESCRIPTION	QTY. REQ'D
001011	BEARING, 2.3622 ID x 4.3307 OD, 1633 DC (SKF)	16
090085	LOCK NUT, 2.360 x 18, TN12 (TIMKEN)	8
090086	LOCK WASHER, TW112 (TIMKEN)	8
005008	THRUST WASHER, 1-1/4 ID x 1-15/16 OD x .03 THICK, TRA-2031 (TORRINGTON)	4
008001	ROD END, 1/2 ID LH THD, 1/2-20 MALE CFML-8 (SEALMASTER)	8
008002	ROD END, 1/2 ID, 1/2-20 MALE, CFM-8 (SEALMASTER)	8
011056	OILITE BUSHING, 1-1/8 ID x 1-1/2 OD x 1" LONG, AA-1509-4	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, SC-125 (BOSTON)	4
035015	SHOULDER SCREW, 1/2 x 3" LG.	8
053008	LUBE FITTING, 1/4-28 STRAIGHT x 1-1/8 LG., 1698 (ALEMITE)	8
069006	GREASE SEAL, 2-1/4 ID x 3" OD x 7/16, 22358 (C/R)	1
512230	IMPRESSION ARM	8
522290	KEEPER	8
522320	TIMING DIAL	1
2522020	IMPRESSION LINKAGE	6
2522030	INNER RING	8
2522040	BEARING CAP	7
1522050	BEARING CAP, TIMING DIAL	1
2522060	DIAL, BACK UP	1
2522080	SPACER, 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

**BLANKET CYLINDER 21-1/2" ATLAS QUADRA-COLOR
ASSEMBLY 1522000A1**

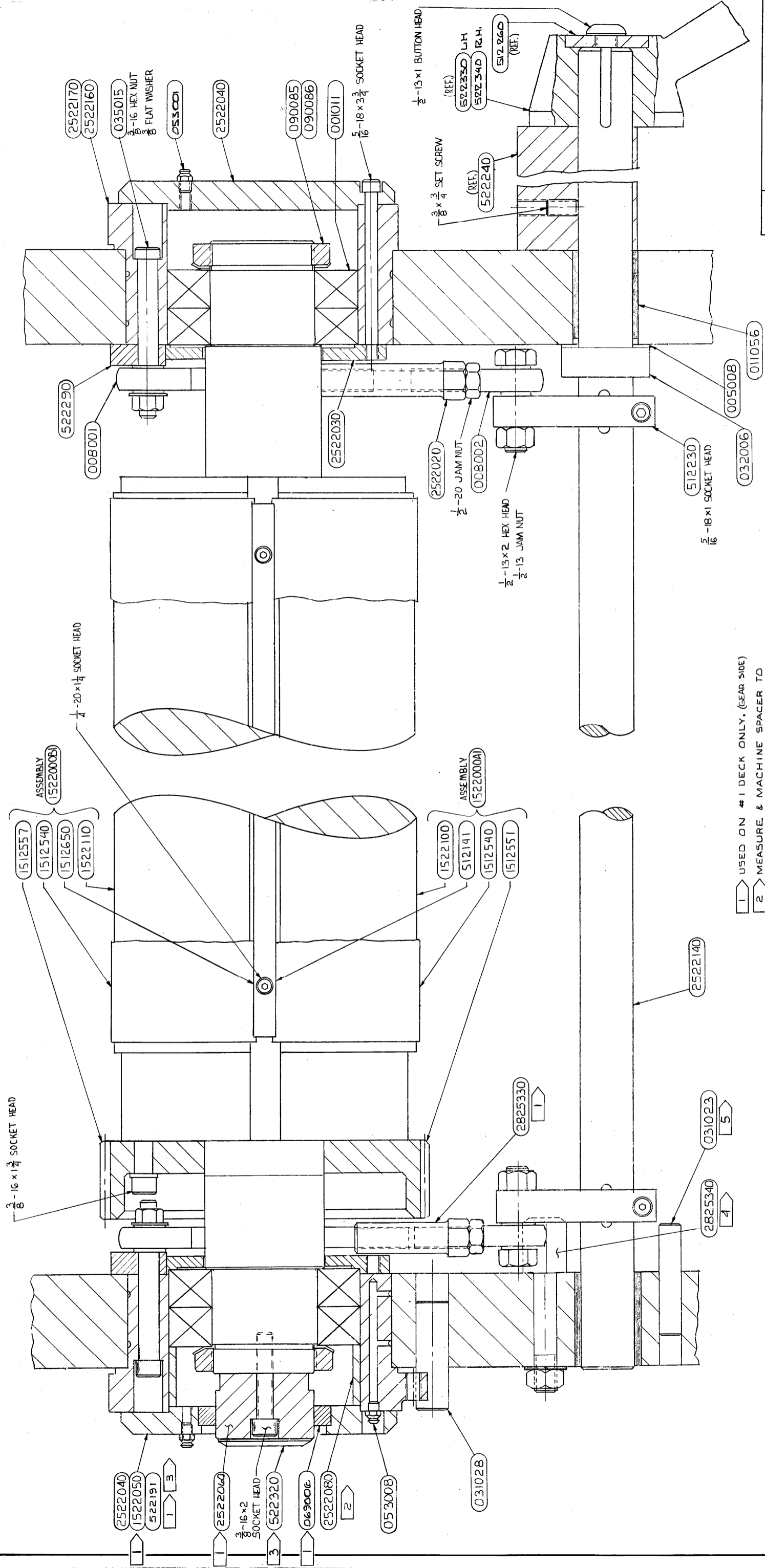
PART NO	DESCRIPTION	QTY. REQ'D
1522100	BLANKET CYLINDER	4
1512540	BLANKET WITH BAR	4
512141	BLANKET BAR	4
1512551	GEAR, BLANKET CYLINDER, R.H.	4

**BLANKET CYLINDER W/REDUCED T- BAR
ASSEMBLY 1522000B1**

1522110	BLANKET CYLINDER	4
1512540	BLANKET WITH BAR	4
1512650	BLANKET BAR	4
1512557	GEAR, BLANKET CYLINDER, R.H.	4

**REFERENCE - BLANKET CYLINDER ASSEMBLY 2522000
MANUAL THROW-OFF, 22-3/4" ATLAS QUADRA-COLOR
ASSEMBLY 2840000**

512260	WASHER, IMPRESSION HANDLE	4
522240	SPACER, IMPRESSION HANDLE	3
522330	HANDLE, IMPRESSION L.H.	2
522340	HANDLE, IMPRESSION R.H.	2



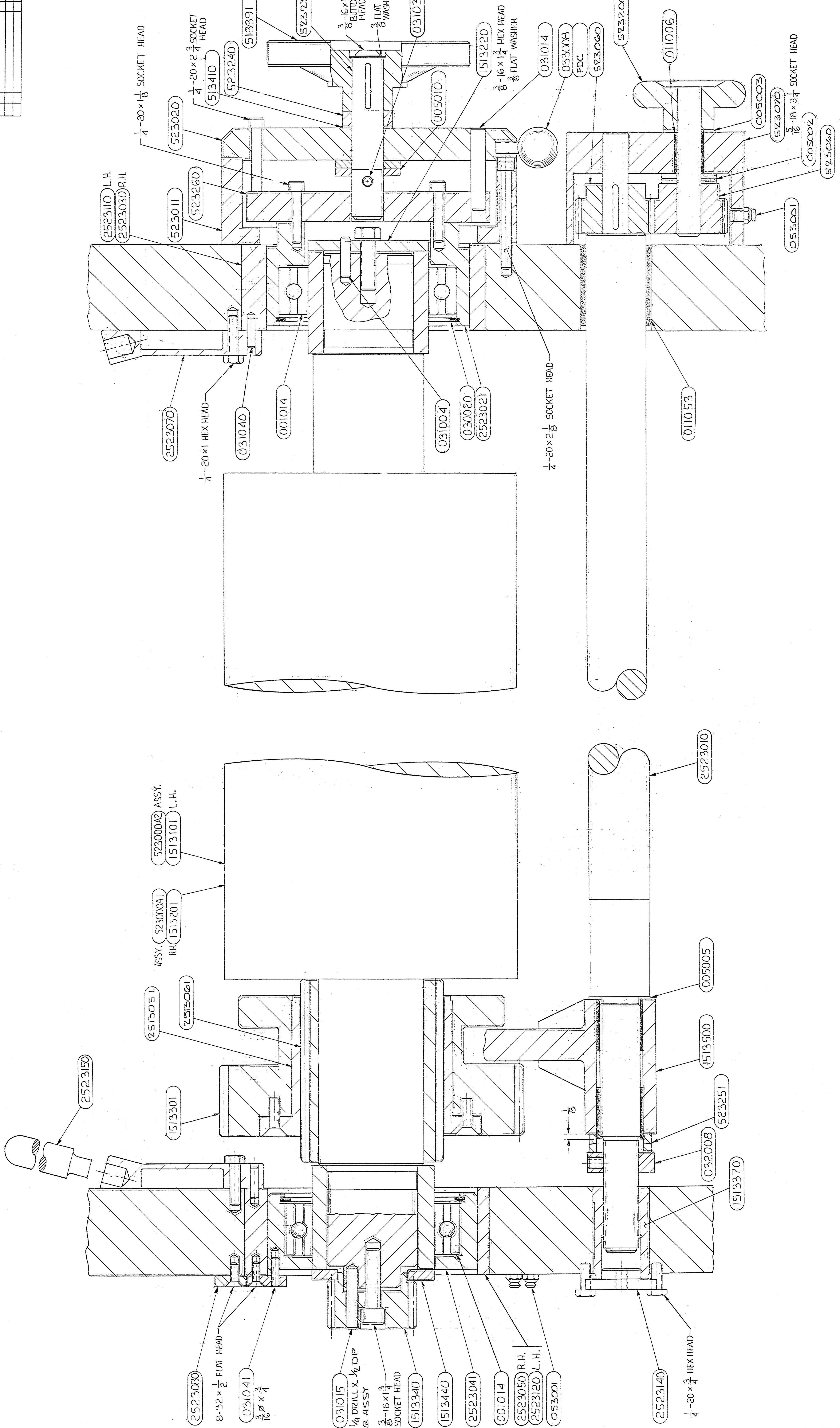
- 1 USED ON #1 DECK ONLY. (GEAR SIDE)
- 2 MEASURE & MACHINE SPACER TO ATTAIN .002 TO .003 CLEARANCE AFTER BEARING IS PRELOADED & TIGHT AGAINST INNER RING.
- 3 TIMING DIAL DECK #1 LOOKING AT GEAR SIDE.
- 4 USED ON GEAR SIDE DECK #1 ONLY (DP POS)
- 5 USED ON GEAR SIDE DECK'S #1 (DOWN POS), #2, #3, #4, (2 EA)

TOLERANCES EXCEPT AS SHOWN		WEB PRESS CORP. KENT WA.	
DECIMAL	21 ±	SCALE	1:1
FRACTIONAL	ATUMS 0.000	DRAWN BY	ASB
ANGULAR		APPROVED BY	
TITLE		DATE	
BLANKET CYLINDER ASSEMBLY		11-30-92	
DRAWING NUMBER		1522000	

Plate Cylinder

**PLATE CYLINDER 21-1/2" ATLAS QUADRA-COLOR
ASSEMBLY 1523000**

PART NO.	DESCRIPTION	QTY. REQ'D
001014	BEARING, ER-36 (SEALMASTER)	8
005005	THRUST WASHER, 1" ID x 1.55 OD x .03 THK TRA-1625 (TORRINGTON)	4
005010	SPHERICAL WASHER, 25/32 ID x 1-5/8 OD x 3/8 THK, SPW-6 (REID)	4
011006	BUSHING, 5/8 ID x 3/4 OD x 1" LG, AA-710-3 (OILITE)	4
011053	BUSHING, 3/4 ID x 1" OD x 2-1/8 LG, AA-1049-11 (OILITE)	4
030020	SNAP RING, 4.330 DIA., RR-433 (SPIROLOX)	8
031014	ROLL PIN, 3/8 x 2-1/2 LG.	4
031015	ROLL PIN, 1/4 x 1-3/4 LG.	4
031032	SPIRAL ROLL PIN, 1/4 x 1-1/2 LG.	4
031041	ROLL PIN, 3/16 x 3/4 LG.	4
031004	ROLL PIN, 1/4 x 1" LG.	4
032008	SET COLLAR, 7/8-14 x 1-5/8 OD (CLAMP-TITE)	4
053001	LUBE FITTING 1/4 - 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.	4
1513301	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



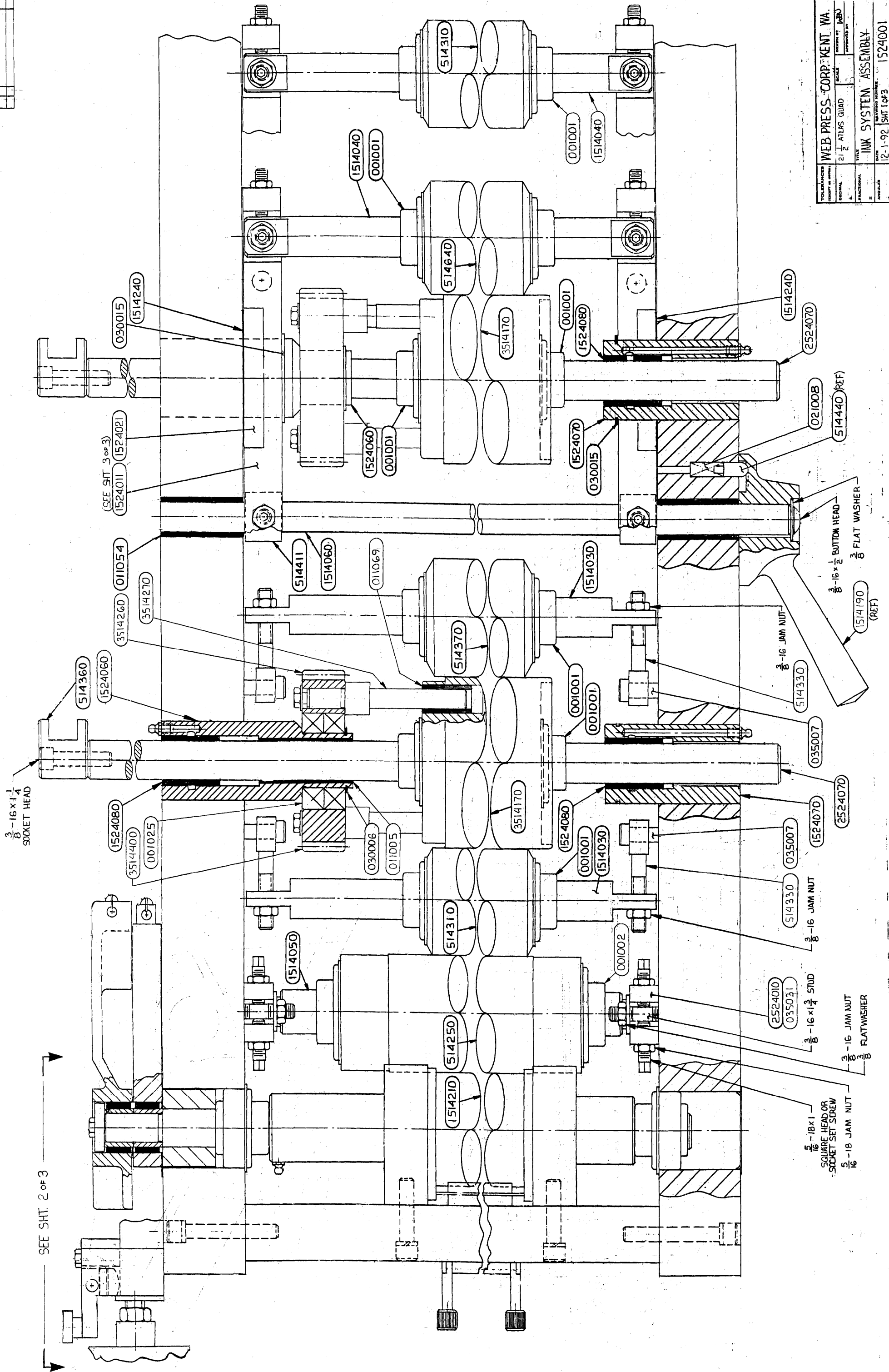
Ink System

**INK SYSTEM 21-1/2 ATLAS QUADRA-COLOR
ASSEMBLY 1524001**

PART NO.	DESCRIPTION	QTY. REQ'D
001001	BEARING, ER-16	60
001002	BEARING, ER-18	8
011005	BUSHING, 1" x 1-1/8 x 1-1/4, AA-1110-3 (OILITE)	8
011069	BUSHING, .5025 ID x .753 OD x 1-1/4 LG., AA-744 (OILITE)	16
011054	BUSHING, 3/4 x 1 x 2-1/8, AA-1049-11 (OILITE)	8
021008	COMPRESSION SPRING, 3/8 OD x 1-1/4 LG, 9-0605-1 (LEMPCO)	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 3/4 LG.	20
035031	SHOULDER SCREW, 1/2 x 1-3/4 LG.	8
514330	SWING BOLT, INK SKIMMER	20
514250	ROLL, INK SKIMMER	4
514310	INK FORM ROLL, 2-3/4" 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, 9107P (FAFNIR)	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
2524070	SHAFT, OSCILLATOR	8

SHT 1 OF 3

DATE	DESCRIPTION	BY	CHKD



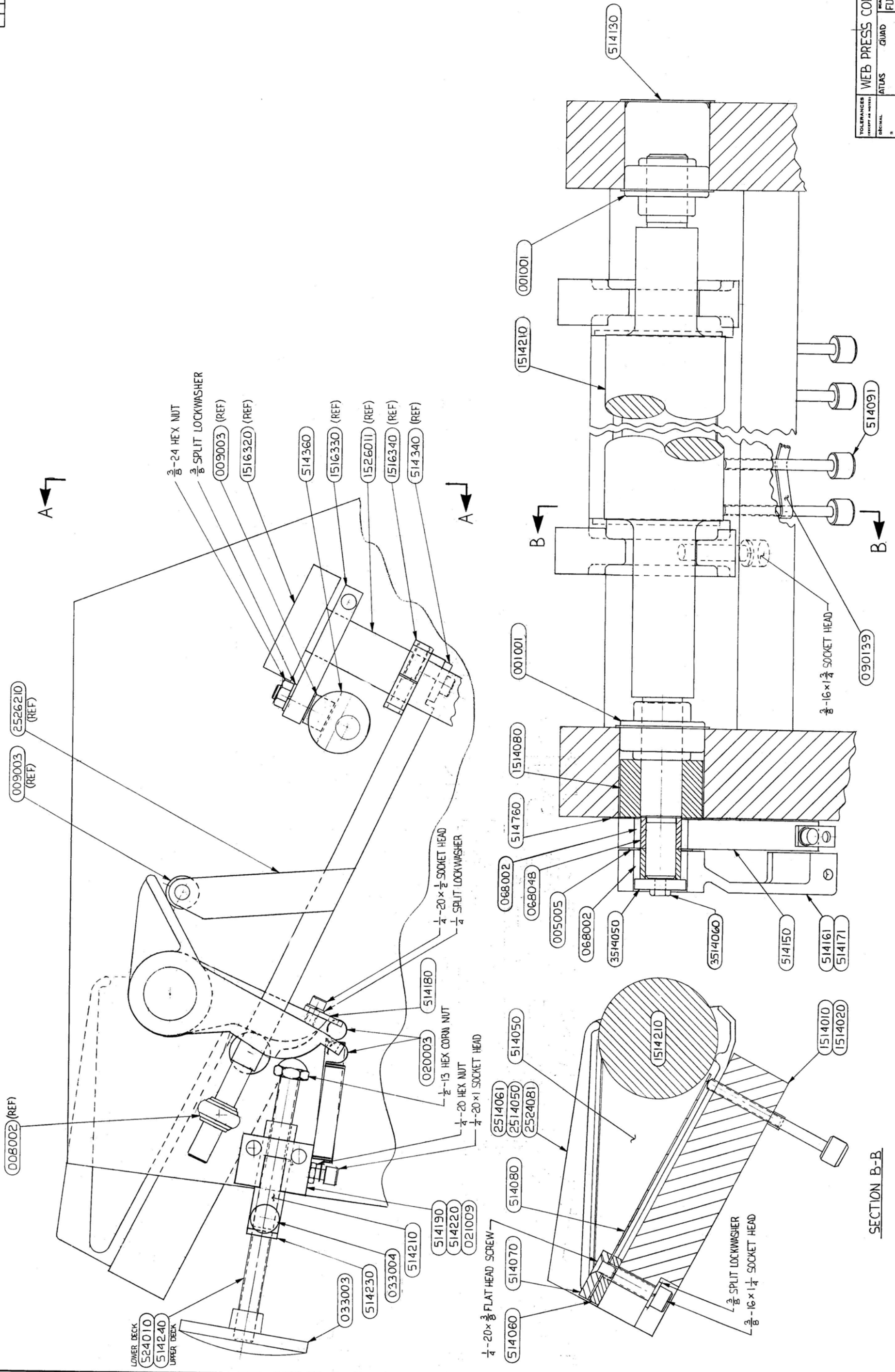
TOLERANCES UNLESS OTHERWISE SPECIFIED	
FRACTIONAL	DECIMAL
1/16	0.015
1/32	0.005
1/64	0.002
1/128	0.001
ANGLES	±0.01
UNLESS OTHERWISE SPECIFIED	
FINISH	APPROVED BY
1/8 ATLAS QJWD	
WEB PRESS CORP. KENT, WA.	
DATE	DRAWING NUMBER
12-1-92	1524001
INK SYSTEM ASSEMBLY	
SCALE	SHEET NO.
	1 OF 3

**INK SYSTEM 21-1/2 ATLAS QUADRA-COLOR
ASSEMBLY 1524001**

PART NO.	DESCRIPTION	QTY. REQ'D
001001	BEARING, ER-16	86
005005	THRUST WASHER, 1" ID x 1.55 OD x .03 THK TRA-1625 (TORRINGTON)	4
020003	TENSION SPRING, 1/2 OD x .041 WIRE DIA. x 1-3/4 LG, E0500-041-1750 (ASC)	4
021009	SPRING PLUNGER, 1/4-20 x 3/4" LG.	4
033003	KNOB, 3-1/8 DIA x 1/2-13, CL23-PHK (CARR-LANE)	4
033004	KNOB, 3/4" DIA x 10-32 STUD x 1/2 LG., DK-43 (REID)	4
068002	CLUTCH, 1" ID x 5/8 LG., RC162110 (TORRNGTN)	8
068048	INNER RACE, 3/4 ID x 1" OD x 1.515 LG., 1R-1224-OH (TORRINGTON)	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

SHT 2 OF 3

DATE	REVISION	RECORD



VIEW A-A

SECTION B-B

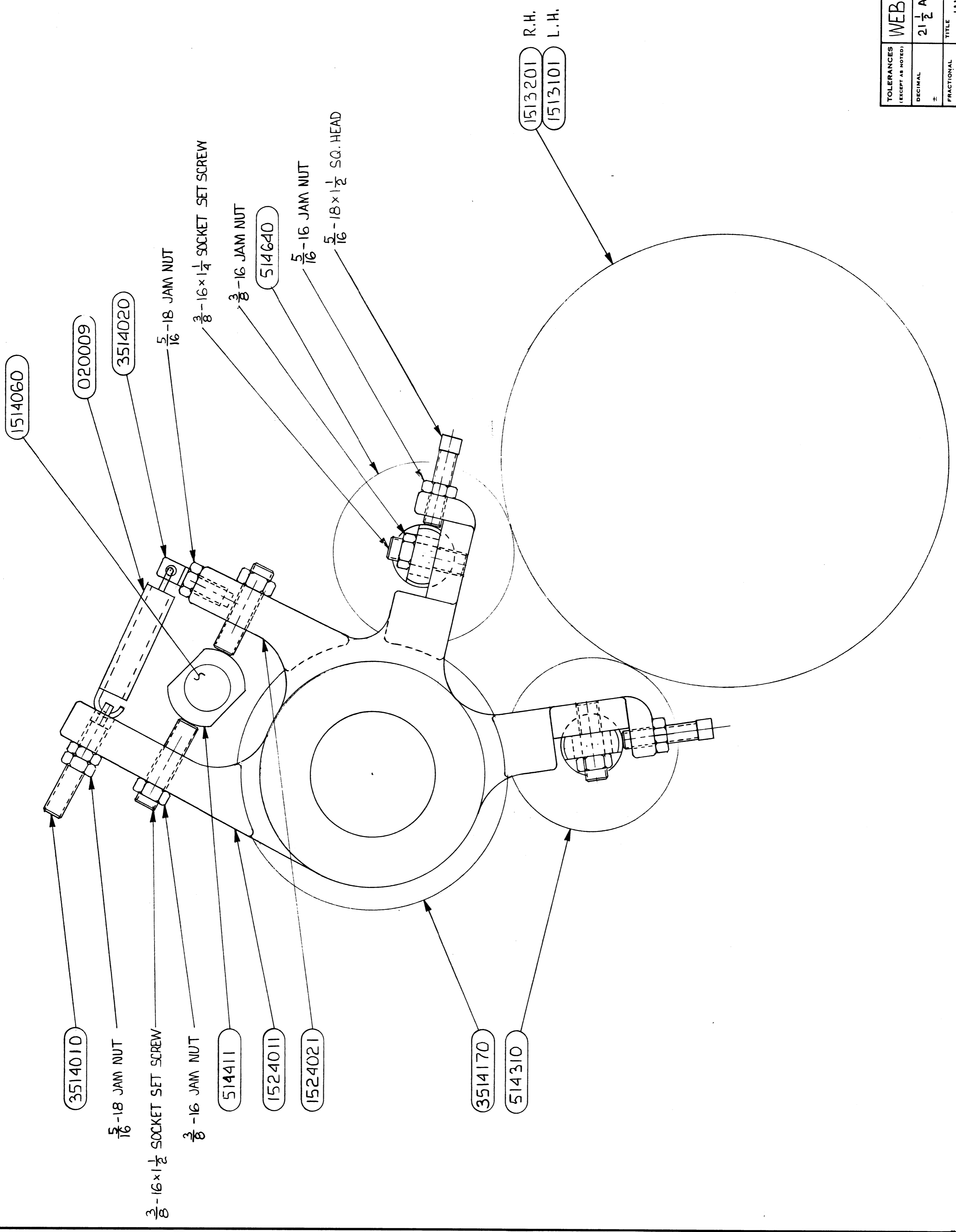
TOLERANCES (UNLESS OTHERWISE SPECIFIED)	WEB PRESS CORP. KENT WA.
DECIMAL	ATLAS
FRACTIONAL	GUARD
ANGULAR	FULL
DATE	DESIGNED BY
12-1-92	1524001
APPROVED BY	INK SYSTEM ASSEMBLY

**INK SYSTEM 21-1/2 ATLAS QUADRA-COLOR
ASSEMBLY 1524001**

PART NO.	DESCRIPTION	QTY. REQ'D
020009	TENSION SPRING, 1/2 x .080 x 1-5/8 LG.	8
514310	INK FORM ROLL, 2-3/4"	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
3514010	SCREW, SPRING ADJUSTMENT	8

SHT 3 OF 3

DATE	BY	REVISION RECORD



TOLERANCES (EXCEPT AS NOTED)		WEB PRESS CORP. KENT WA.	
DECIMAL	±	SCALE	2 1/2 ATLAS QUAD
FRACTIONAL	±	DRAWN BY	ASB
ANGULAR	±	APPROVED BY	
		TITLE	INK SYSTEM ASSEMBLY
		DATE	12-1-92
		DRAWING NUMBER	1524001
		SHT 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	1
090118	WASH-UP, DECK #2 - REVERSE QUAD OR, DECK #3 - STANDARD QUAD	1
090119	WASH-UP, DECK #3 - REVERSE QUAD OR, DECK #2 - STANDARD QUAD	1
090120	WASH-UP, DECK #4 - REVERSE QUAD OR, DECK #1 - STANDARD QUAD	1

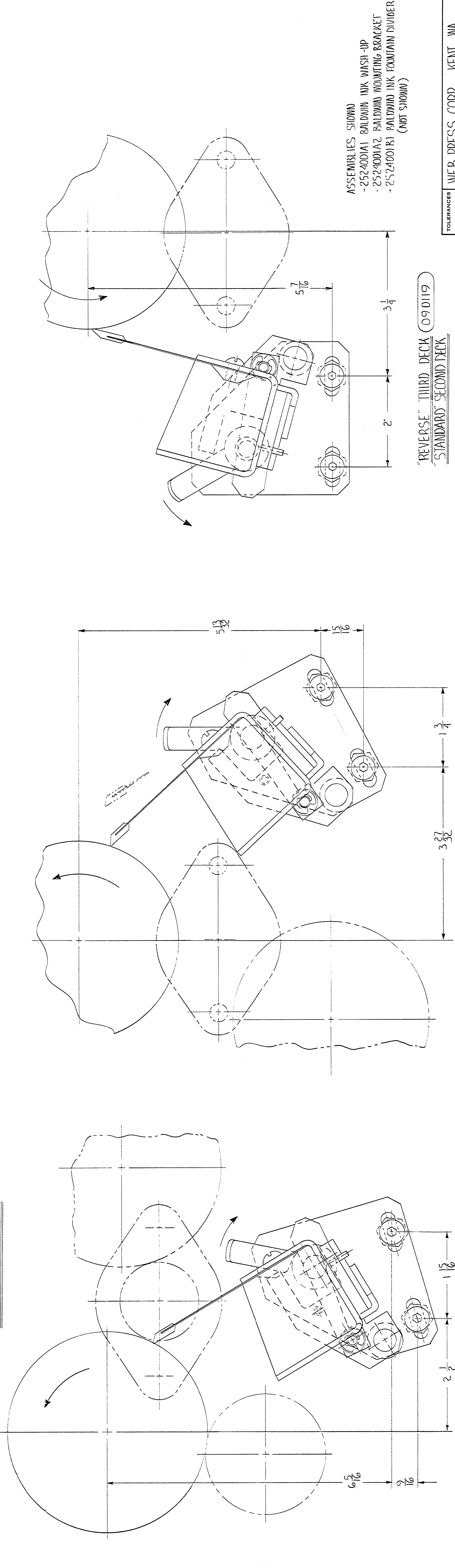
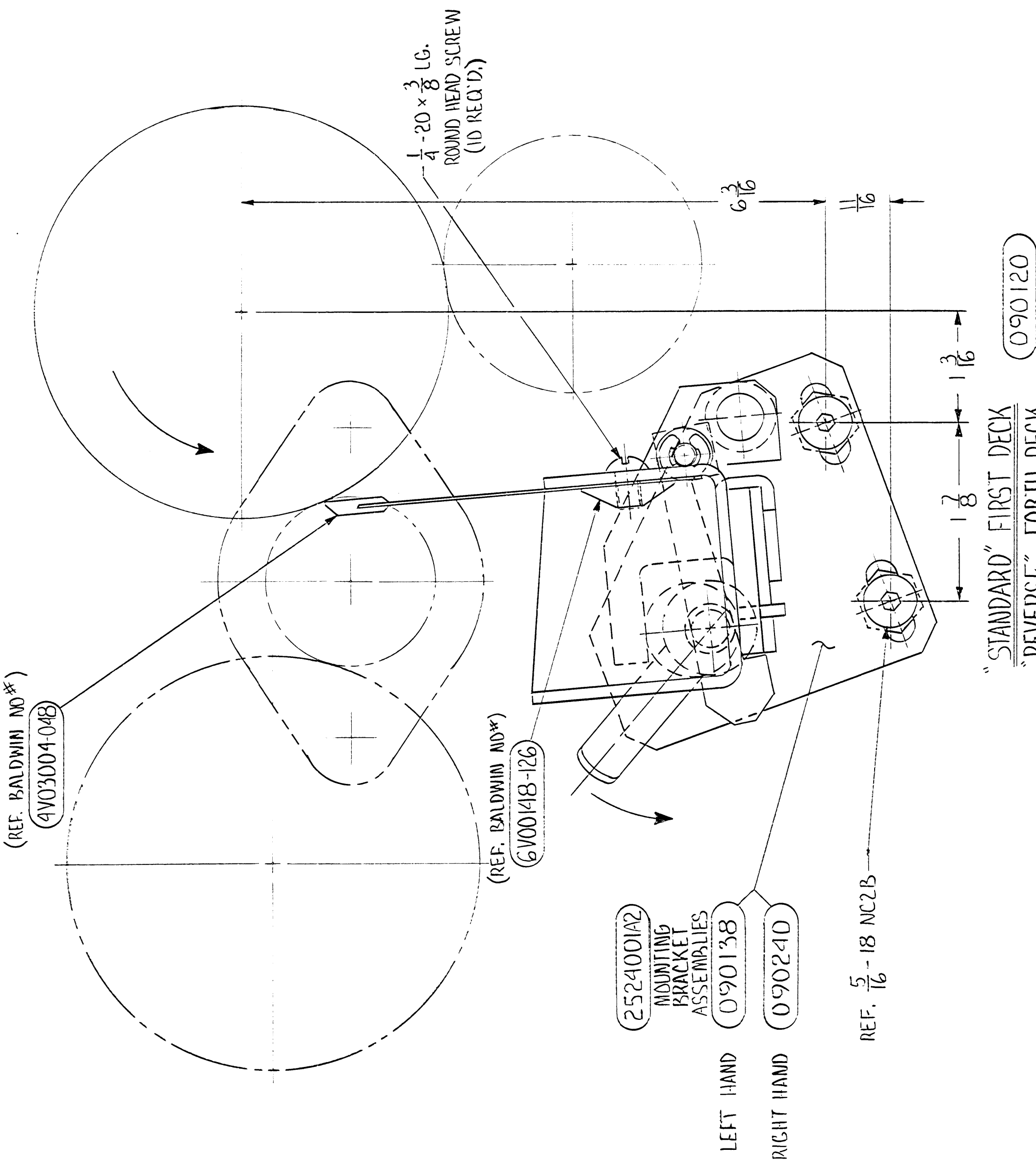
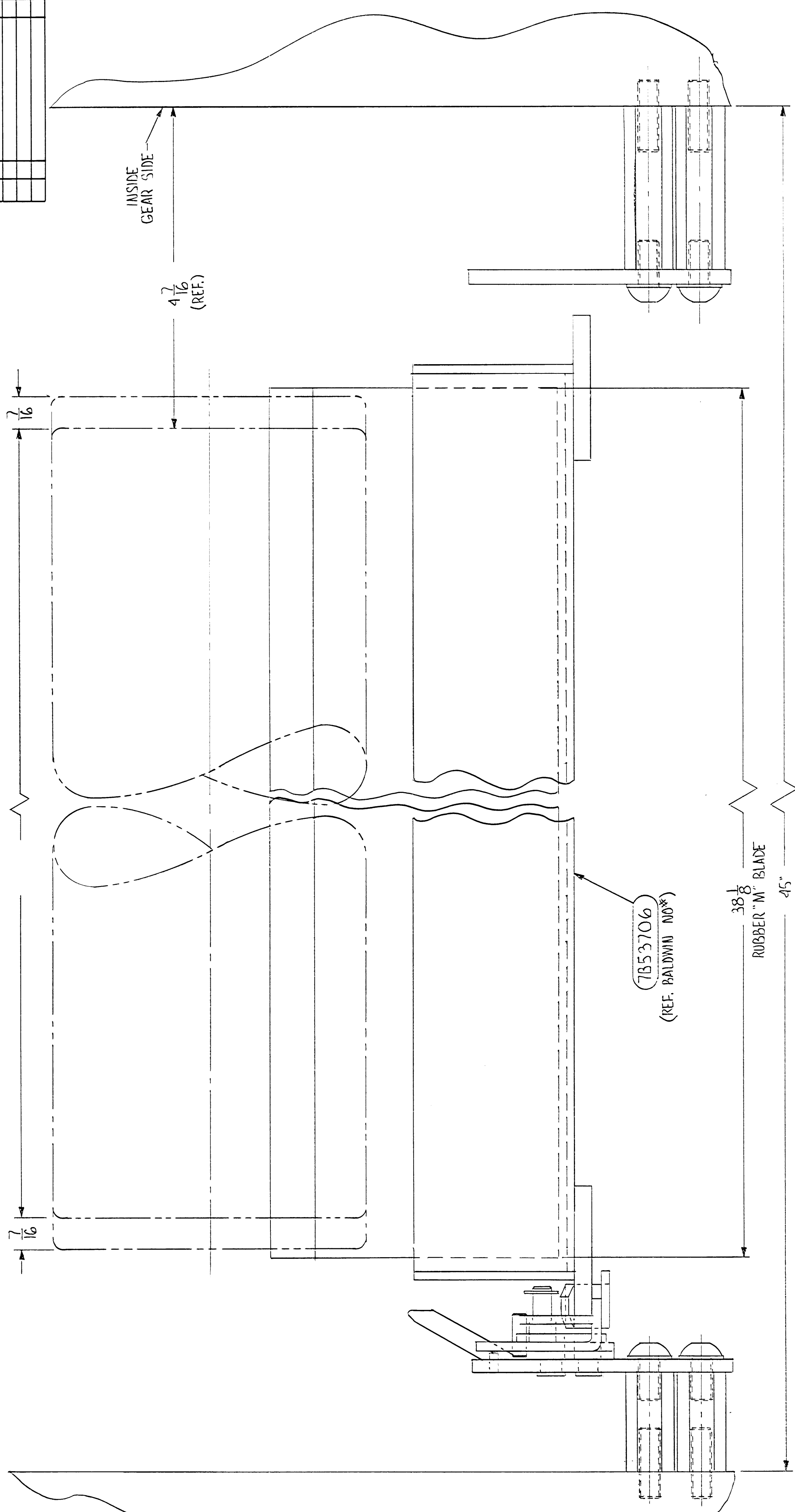
ASSEMBLY 2524001A2

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

**BALDWIN INK FOUNTAIN DIVIDER
ASSEMBLY 2524001B1**

090034	FOUNTAIN DIVIDER (NOT SHOWN) BALDWIN #1028	4
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DATE	BY	REVISION	RECORD	DR	CHK



ASSEMBLIES SHOWN
 - 2524001A1 BALDWIN INK WASH-UP
 - 2524001A2 BALDWIN MOUNTING BRACKET
 - 2524001B1 BALDWIN INK FOUNTAIN DIVIDER
 (NOT SHOWN)

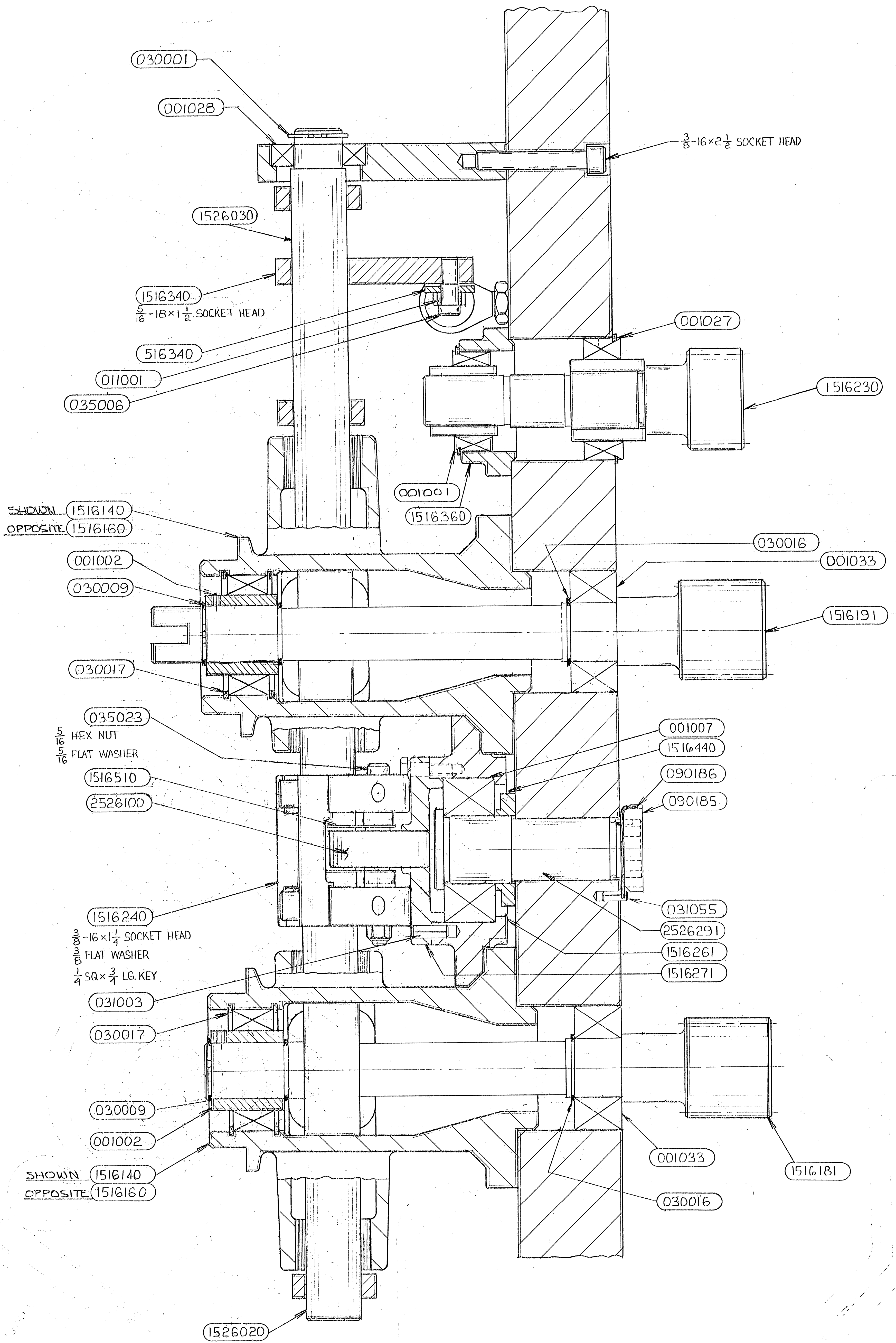
TOLERANCES UNLESS OTHERWISE SPECIFIED	WEB PRESS CORP. KENT WA.
DECIMAL	SCALE
FRACTIONAL	DRAWN BY
ANGULAR	APPROVED BY
DATE	TITLE
9-29-92	BALDWIN INK WASH-UP
DRAWING NUMBER	2524001A1

Mechanical Motion

**MECHANICAL MOTION 21-1/2 ATLAS QUADRA-COLOR
ASSEMBLY 1526000**

PART NO.	DESCRIPTION	QTY. REQ'D
001001	BEARING, ER-16 (NTN)	4
001002	BEARING, ER-18 (SEALMASTER)	8
001007	BEARING, 555 07 (NEW DEPARTURE)	4
001027	BEARING, ER-19 (McGILL)	4
001028	BEARING, 60052RS (SKF)	4
001033	BEARING, DOUBLE ROW ANG. CONTACT-ND55506 (NEW DEPARTURE)	8
011001	BUSHING, 3/8 ID x 1/2 OD x 3/8 LG., AA-521-9 (OILITE)	4
030001	SNAP RING, EXTERNAL - 1", 5100-100 (TRU-ARC)	4
030009	SNAP RING, S.D. EXTERNAL - 1-1/8"	8
030017	SNAP RING, 2.44 HOUSING DIA.	16
031003	ROLL PIN, 1/4 x 3/4 LG.	4
031055	ROLL PIN, 3/16 x 1/2 LG.	4
035006	SHOULDER SCREW, 3/8 x 5/8 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)	12
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 HOUSING	4
1516440	SPACER	4
1516510	GUIDE BLADE	8
1526030	SHAFT, MECH. MOTION	4
1526020	SHAFT, MECH. MOTION	4
1516181	GEAR, PINION, R.H.	4
1516191	GEAR, PINION, R.H.	4
1516230	GEAR, PINION R.H.	4
2526100	LINK, SUB ASSY.	4
2526291	STUD SHAFT	4

SHT 1 OF 2



MECHANICAL MOTION
LEFT HAND LOWER DECK SHOWN

TOLERANCES (UNLESS AS NOTED)	WEB PRESS CORP KENT WA.
FRACATIONAL	ATLAS 2 1/2 QUAD
DECIMAL	SCALE 1:1
TITLE	MECHANICAL MOTION ASSEMBLY
DATE	12-1-92
ANSI/ASME	DRAWING NUMBER 1526000 1 of 2

DATE	BY	REVISION

**MECHANICAL MOTION 21-1/2 ATLAS QUADRA-COLOR
ASSEMBLY 1526000**

PART NO.	DESCRIPTION	QTY. REQ'D
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001001	BEARING, ER-16	4
008002	ROD END, CFPL-4Y (SEALMASTER)	4
009003	CAM FOLLOWER, CF-3/4 (McGILL)	16
009013	CAM FOLLOWER, YCR-16 (TORRINGTON)	4
030021	SNAP RING, 5/16" DIA - 5100-31 (TRU-ARC)	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 HOUSING	4
1526030	SHAFT, MECH. MOTION	4
1526020	SHAFT, MECH. MOTION	4
2526100	LINK, SUB ASSY.	4
1526210	PUSH ROD, L.H., UPPER DECK	1
1526220	PUSH ROD, R.H., UPPER DECK	1
1526210	PUSH ROD, L.H., LOWER DECK	1
1526220	PUSH ROD, R.H., LOWER DECK	1
2526250	CAM ROLL SHAFT (ONE FOR EACH PUSH ROD)	1

ASSEMBLY 2526000A1

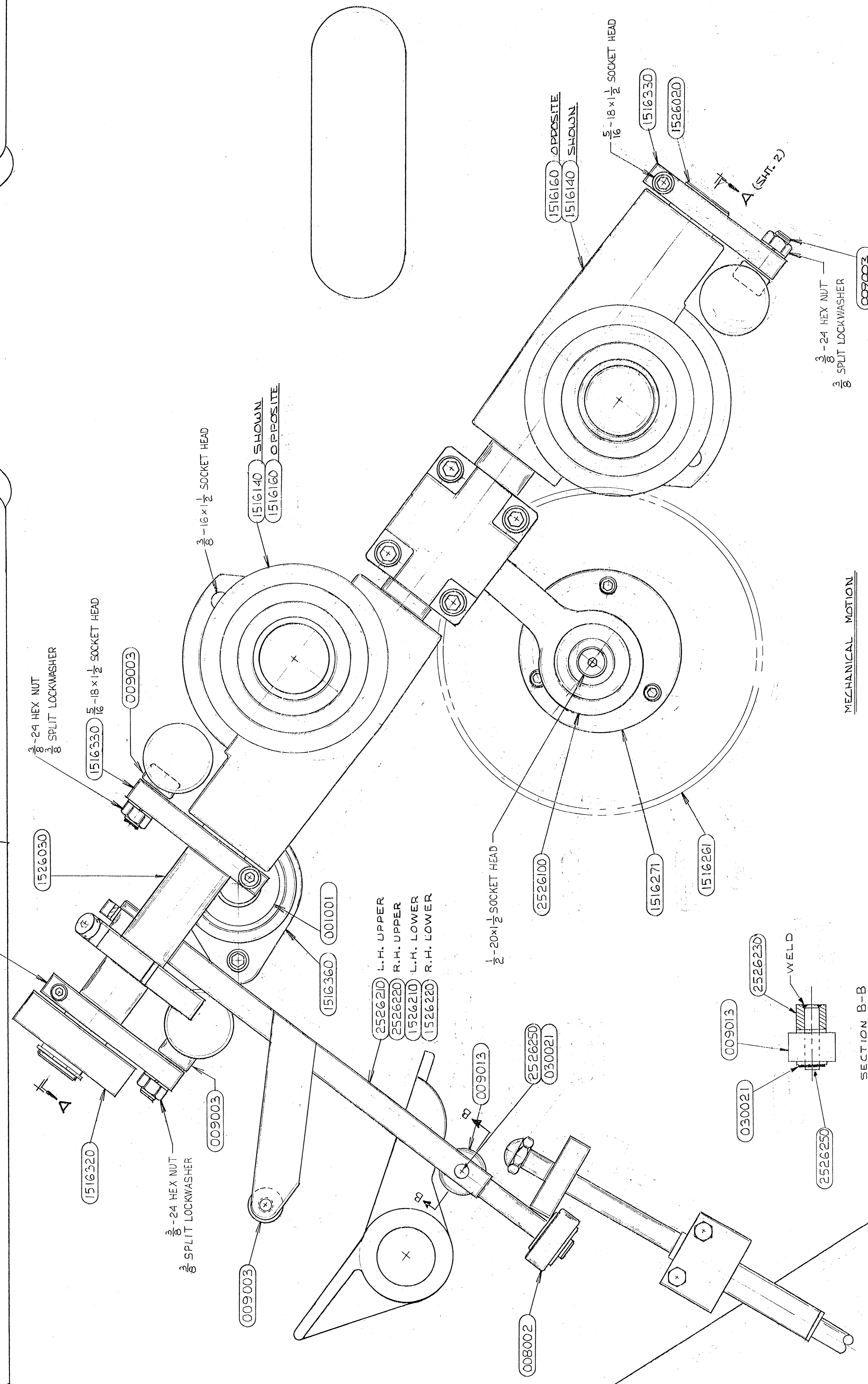
2516280	ADJUSTING TOOL (NOT SHOWN) NOTE: ONE PER CUSTOMER	1
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ASSEMBLY 2526000A2

1811042	HANDWHEEL (NOT SHOWN)	1
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SHT 2 OF 2

DATE	DESCRIPTION	BY	CHK



MECHANICAL MOTION
 LEFT HAND LOWER DECK SHOWN

SECTION B-B

TOLERANCES UNLESS NOTED	WEB PRESS CORP. KENT WA.
DIGITAL	ATLAS 2 1/2 QUAD
FRACTIONAL	SCALE 1:1
ANGULAR	DATE 12-1-92
	TITLE MECHANICAL MOTION ASSEMBLY
	DRAWING NUMBER 1526000
	2 OF 2

Brush Dampening System

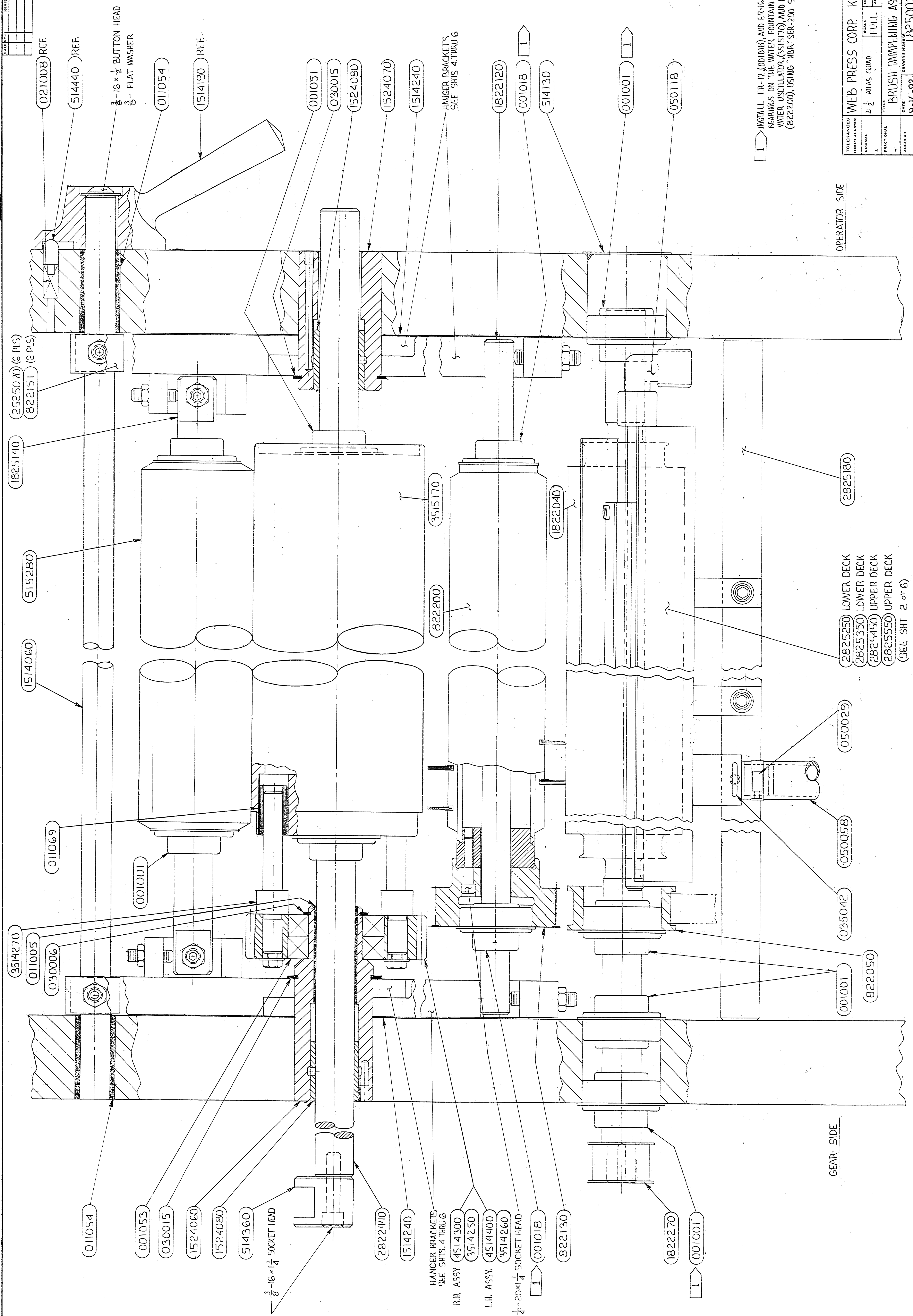
**BRUSH DAMPENING 21-1/2" ATLAS QUADRA-COLOR
ASSEMBLY 1825002**

PART NO.	DESCRIPTION	QTY. REQ'D
001001	BEARING, ER-16 (NTN)	22
001051	BEARING, ER-16-1 (NTN W/MIROPOLY GREASE)	8
001018	BEARING, ER-12 (SEALMASTER)	8
011005	BUSHING, 1" ID x 1-1/8 OD x 1-1/4 LG., AA-1110-3 (OILITE)	4
011069	BUSHING, .5025 ID x .753 OD x 1-1/4 LG., AA-744 (OILITE)	8
011054	BUSHING, 3/4 ID x 1" OD x 2-1/8 LG., AA-1049-11 (OILITE)	8
030006	SNAP RING, 1-3/8 SD. EXTERNAL, 5100-137 (TRUARC)	4
030015	SNAP RING, 2" SD. EXTERNAL, 5100-200 (TRUARC)	8
035042	THUMB SCREW, 1/4-20 x 3/4 LG.	4
050029	HOSE CLAMP, 1-3/4	4
050058	TUBING, VINYL - 1" OD x 3/4 ID., (INCHES)	84
514130	FOUNTAIN ROLL COVER	4
514360	OSCILLATOR SHAFT BUTTON	4
050118	ELBOW, 1/2 T x 1/2 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
1825140	FORM ROLL SHAFT	4
1514060	SHAFT, FORM ROLL CAM	4
1514240	PHENOLIC WASHER	16
4514400	OSCILLATOR GEAR ASSY., 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
1822120	SHAFT, BRUSH ROLL	4

**BRUSH DAMPENING 21-1/2" ATLAS QUADRA-COLOR
ASSEMBLY 1825002**

PART NO.	DESCRIPTION	QTY. REQ'D
2822440	SHAFT, OSCILLATOR	4
2525070	CAM, WATER FOUNTAIN	6
2825180	STIFFENER, WATER PAN	4
2825250	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

DATE	REVISION	RECORD



1 INSTALL ER-12, (001018), AND ER-16, (001001), BEARINGS ON THE WATER FOUNTAIN ROLL, (822040), WATER OSCILLATOR, (3515170), AND BRUSH ROLL, (822200), USING "NBR" SER-200 SERIES ONLY.

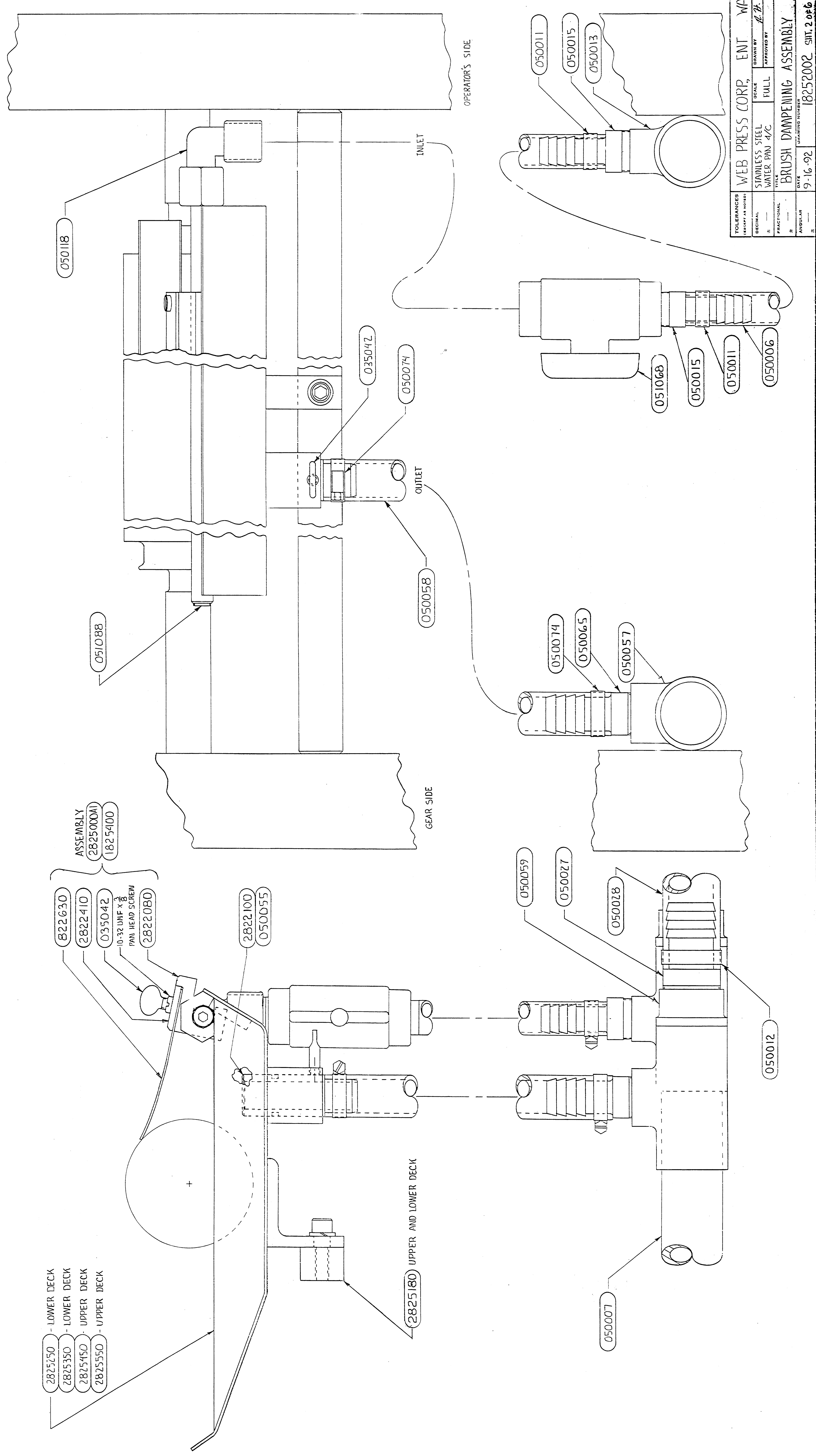
TOLERANCES UNLESS NOTED		WEB PRESS CORP. KENT WA	
FRACTIONAL	DECIMAL	SCALE	DRAWN BY
1/16	0.005	FULL	BAF
TITLE		DATE	DRAWING NUMBER
BRUSH DAMPENING ASSEMBLY		9-16-92	1825002-SHT. 1 OF 6

**BRUSH DAMPENING 21-1/2" ATLAS QUADRA-COLOR
ASSEMBLY 1825002**

PART NO.	DESCRIPTION	QTY. REQ'D
035042	THUMB SCREW, 1/4-20 x 3/4 LG.	4
050006	VINYL TUBING, 5/8 ID (INCHES)	96
050007	PVC PIPE, 1" ID (INCHES)	58
050011	HOSE CLAMP, 3/4"	8
050012	HOSE CLAMP, 1-9/16 TO 1-3/4	8
050013	T-FITTING, 1" x 1/2 (THREADED) PVC 401 R (TURF & TORO)	4
050015	BARB FITTING, 1/2 MALE PIPE, PVC	4
050028	VINYL HOSE, 1" DIA. (FEET)	36
050027	1" THREADED PIPE x 1" HOSE BARB, PVC	8
050055	O-RING, .737 x .103 THICK, 2-116 (PARKER)	4
050057	REDUCING TEE, 1" x 1" x 3/4 THREADED (GSR)	4
050058	VINYL TEE, 1" OD x 3/4 ID (INCHES)	84
050059	ADAPTER, 1" S x 1" NPT, 3478-010 (RYAN-HERCO)	4
051068	BALL VALVE, 1/2 NPT-PVC, 73582M (CONS.)	4
050065	HOSE CONNECTOR, 3/4 NPT x 3/4 BARB, PVC	4
051088	PIPE PLUG, 1/8 MALE, SOCKET, 1/8-HHP-SS (PARKER)	4
050063	HOSE CLAMP, 1"	4
051075	CLOSE NIPPLE, 1/2 NPT, PVC	4
050074	HOSE CLAMP, 3/8 - 3/4" ID	8
050118	ELBOW, 1/2 TUBE x 1/2 NPT MALE (PARKER)	4
515280	WATER FORM ROLL, 2-7/8	4
2825180	STIFFENER, WATER PAN	4
2825250	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

**OPTION WATER STOPS
ASSEMBLY 2825002A1**

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

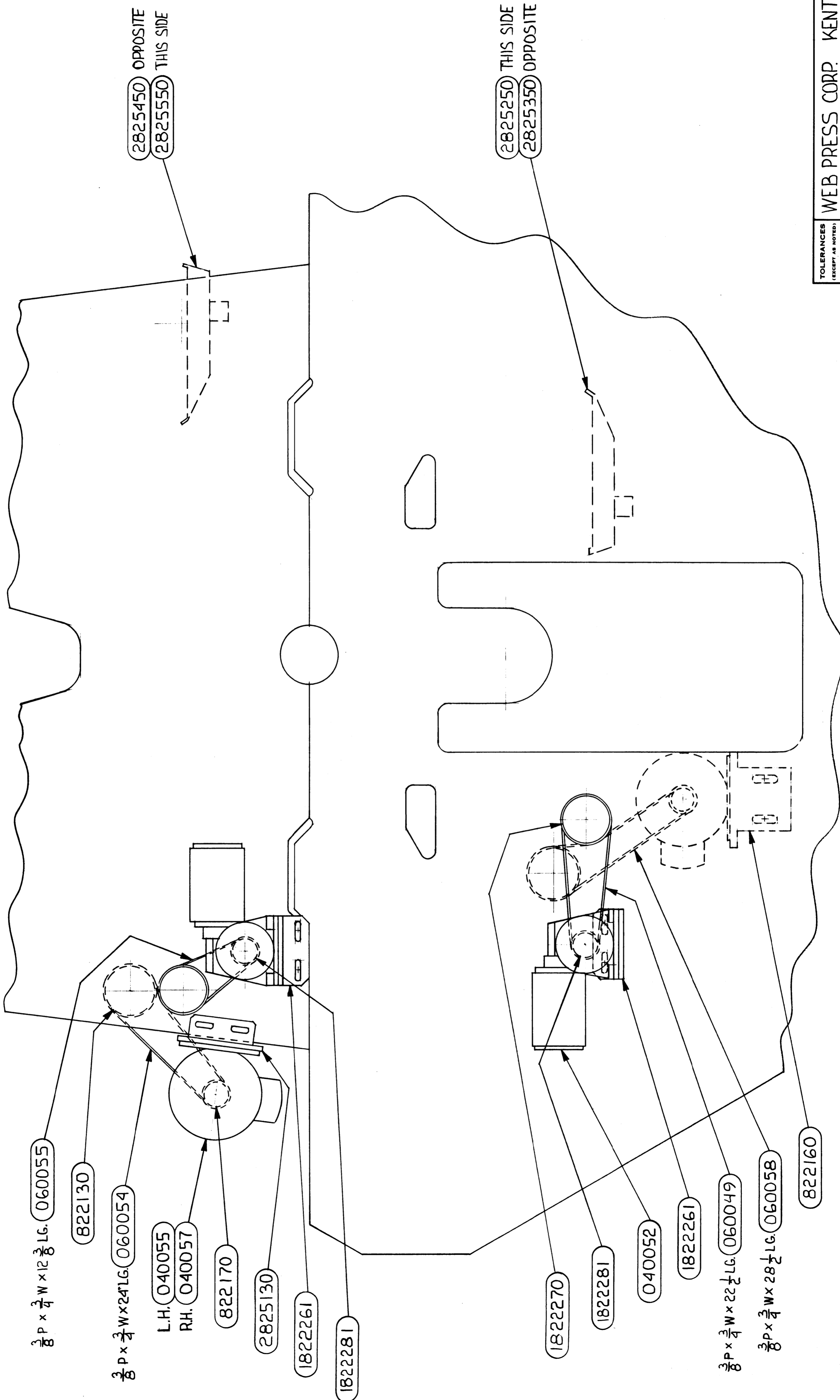


TOLERANCES UNLESS OTHERWISE SPECIFIED		WEB PRESS CORP. ENT. WA	
DECIMAL	SCALE	FULL	APPROVED BY
FRACTIONAL			
MATERIAL		STAINLESS STEEL	
FINISH		WATER PAIN 4/C	
TITLE		BRUSH DAMPENING ASSEMBLY	
DATE	DRAWING NUMBER	SHEET	
9-16-92	18252002	2 OF 6	

**BRUSH DAMPENING 21-1/2" ATLAS QUADRA-COLOR
ASSEMBLY 1825002**

PART NO.	DESCRIPTION	QTY. REQ'D
040052	MOTOR, GP 3005 (BALDOR)	4
040055	MOTOR, 1/4 HP, 230V, 3 PHASE, F2 (MAC)	2
040057	MOTOR, BRUSH, 1/4 HP, 60 HZ, F1 (CARMODY)	2
060058	TIMING BELT, MAUREY 285 L 075	2
060049	TIMING BELT, MAUREY 225 L 075	2
060055	TIMING BELT, MAUREY 124 L 075	2
060054	TIMING BELT, MAUREY 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
1822261	MOTOR MOUNTING BRACKET	4
2825130	BRACKET, BRUSH MOTOR MOUNT	2
2825250	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
1822281	PULLEY	4

DATE	BY	REVISION RECORD	DR. CK.



$\frac{3}{8}$ P x $\frac{3}{4}$ W x 12 $\frac{3}{8}$ LG. (060055)

(822130)

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

L.H. (040055)

R.H. (040057)

(822170)

(2825130)

(1822261)

(1822281)

(1822270)

(1822281)

(040052)

(1822261)

$\frac{3}{8}$ P x $\frac{3}{4}$ W x 22 $\frac{1}{2}$ LG. (060049)

$\frac{3}{8}$ P x $\frac{3}{4}$ W x 28 $\frac{1}{2}$ LG. (060058)

(822160)

(2825450) OPPOSITE
(2825550) THIS SIDE

(2825250) THIS SIDE
(2825350) OPPOSITE

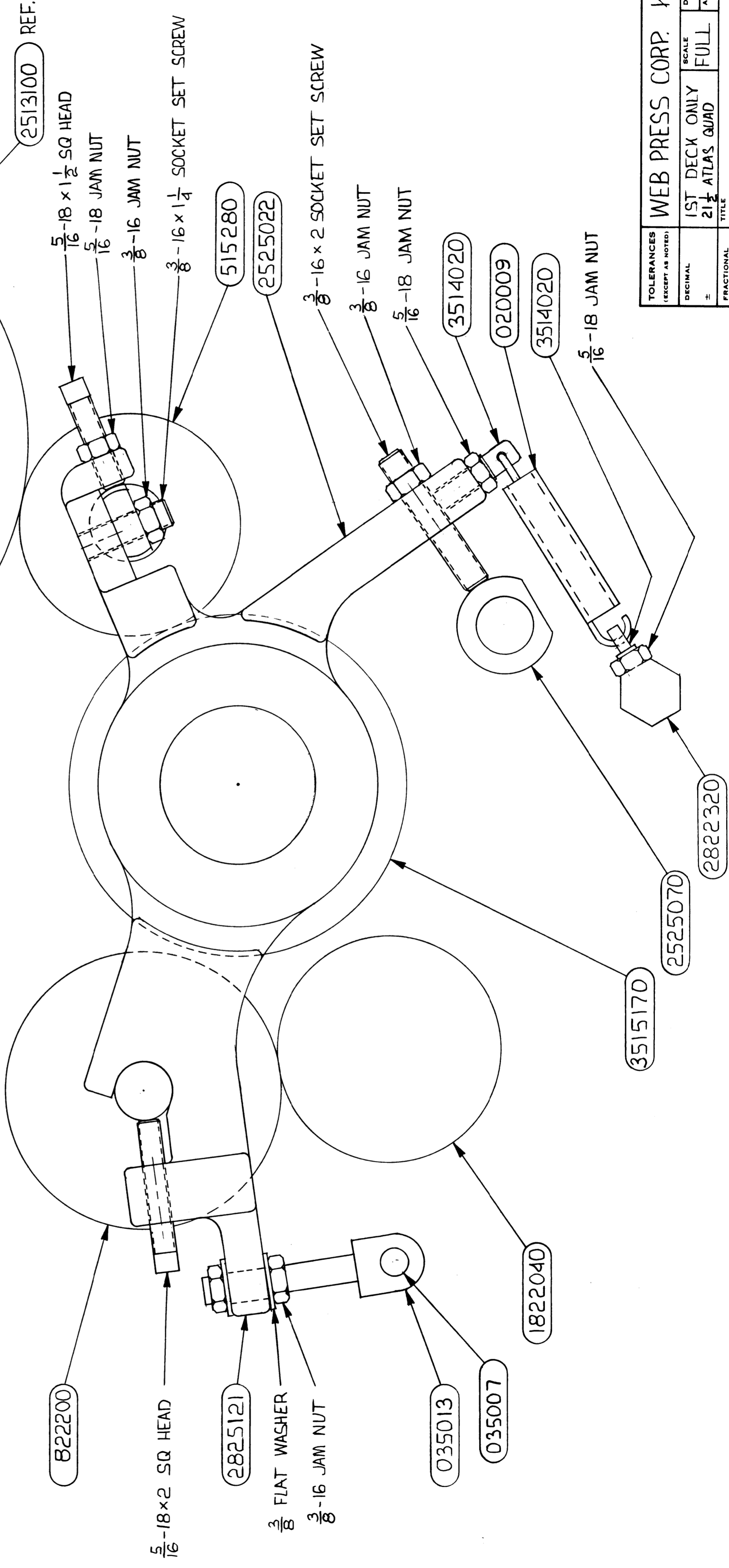
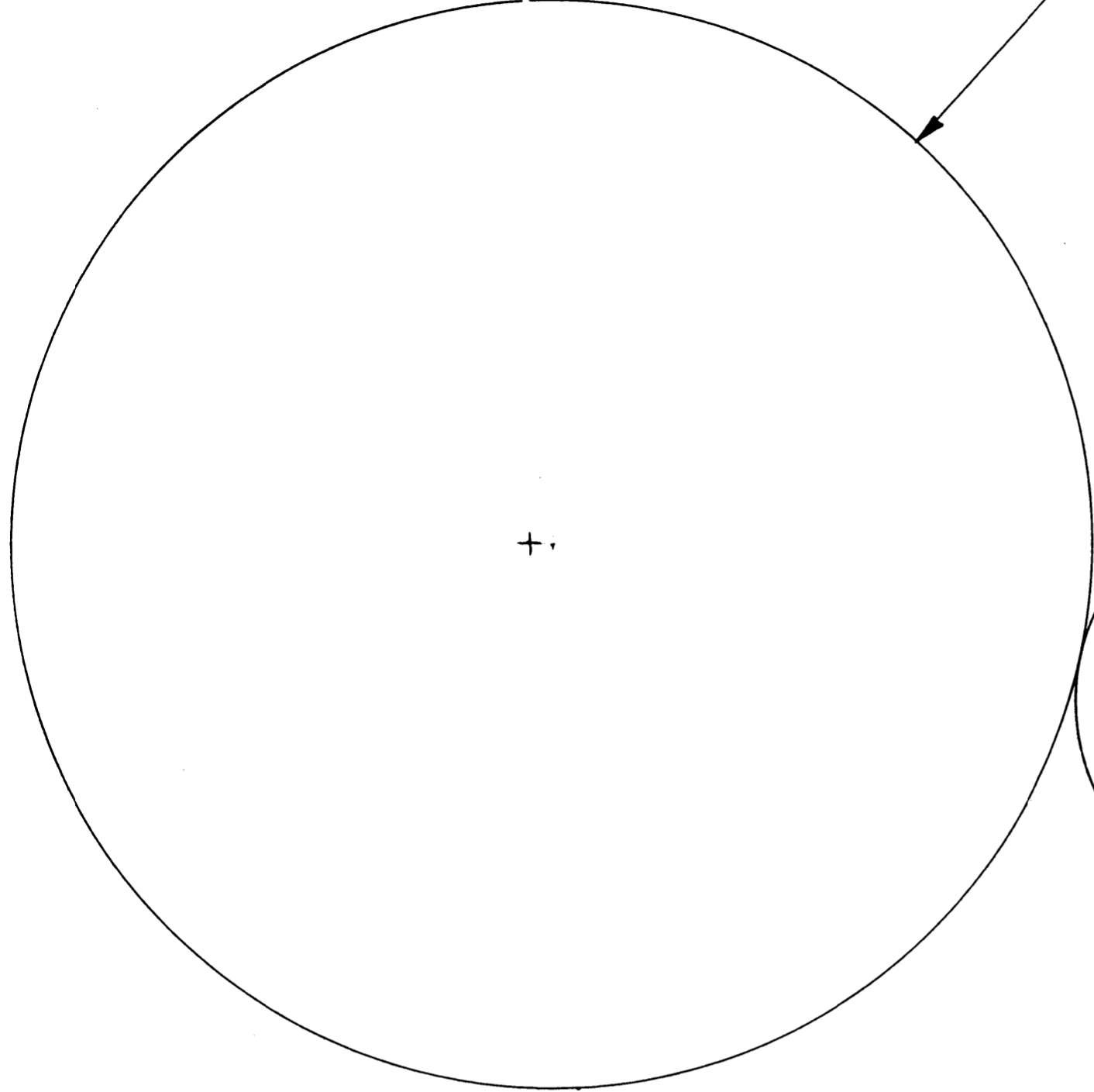
GEAR SIDE

TOLERANCES (EXCEPT AS NOTED)		WEB PRESS CORP. KENT WA.	
DECIMAL	±	SCALE	2 1/2" ATLAS QUAD
FRACTIONAL	±	DRAWN BY	J.F.S.
ANGULAR	±	APPROVED BY	
TITLE		BRUSH DAMPENING ASSEMBLY	
DATE	9-16-92	DRAWING NUMBER	1825002
SHEET		SHT. 3 OF 6	

**BRUSH DAMPENING 21-1/2" ATLAS QUADRA-COLOR
ASSEMBLY 1825002**

PART NO.	DESCRIPTION	QTY. REQ'D
020009	TENSION SPRING, 1/2 OD x .080 WIRE DIA. x 1-5/8 LG., #681 (LANE)	8
035013	SWING BOLT, 3/8-16 x 3-3/4 LG., EB-2 (CARR-LANE)	4
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

DATE	BY	REVISION	RECORD	DR. CHK.

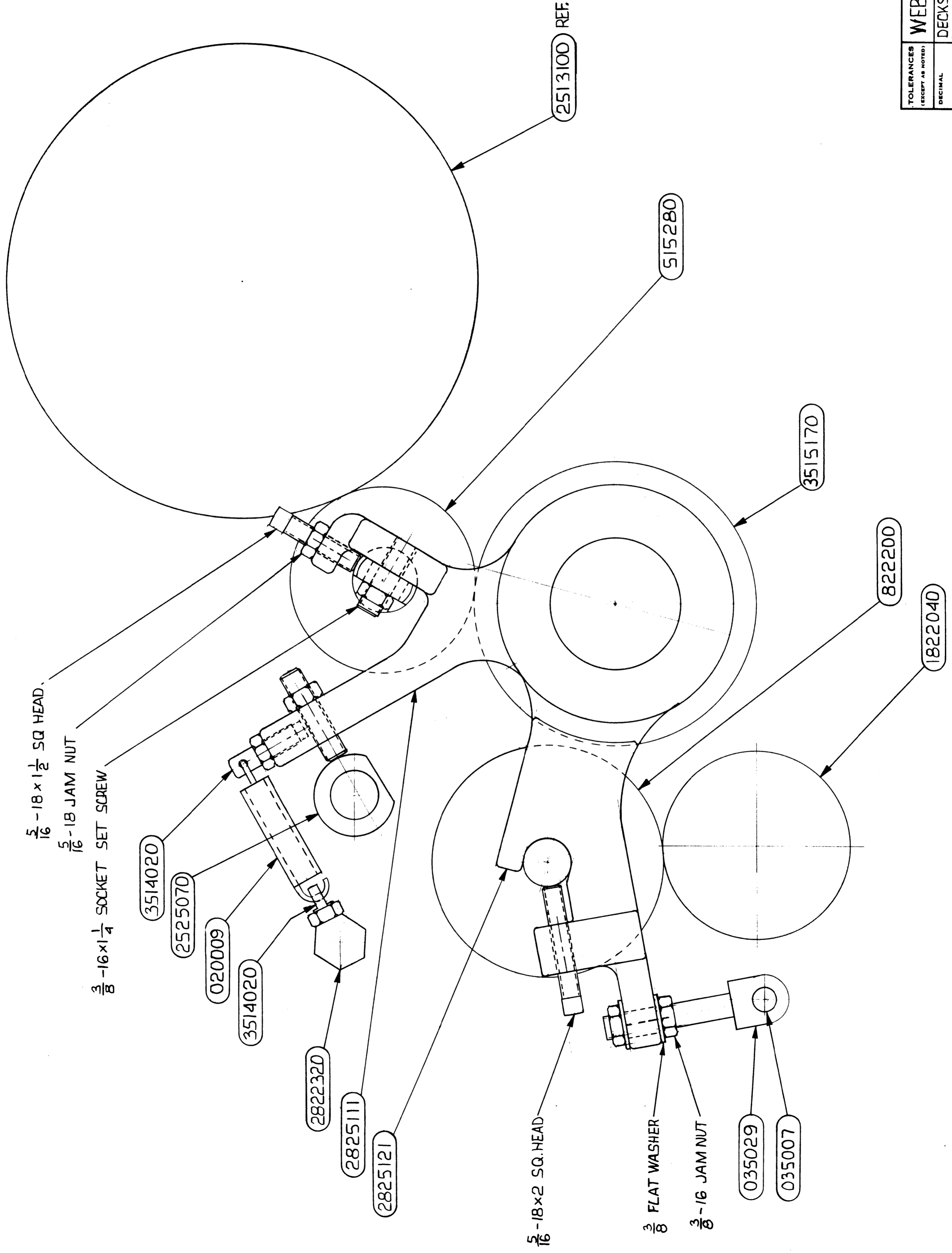


TOLERANCES (EXCEPT AS NOTED)		SCALE		DRAWN BY	
DECIMAL	±	1ST DECK ONLY	FULL	KENT WA.	J.E.S.
FRACTIONAL	±	2 1/2 ATLAS	QUAD	APPROVED BY	
ANGULAR	±	TITLE			
		BRUSH DAMPENING ASSEMBLY			
		DATE		DRAWING NUMBER	
		10-19-88		1825002	
		SHT 4 OF 6			

**BRUSH DAMPENING 21-1/2" ATLAS QUADRA-COLOR
ASSEMBLY 1825002**

PART NO.	DESCRIPTION	QTY. REQ'D
020009	TENSION SPRING, 1/2 OD x .080 WIRE DIA. x 1-5/8 LG. #681 (LANE)	8
035029	SWING BOLT, 3/8-16 x 2-1/2 LG.	4
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
2525070	CAM, WATER FOUNTAIN	6
2825111	HANGER BRACKET	4
2825121	HANGER BRACKET	8
2822320	STOP, BRUSH ROLL	8
3514020	SCREW, SPRING ADJUSTMENT	16

DATE	REVISION	RECORD	DR. USE



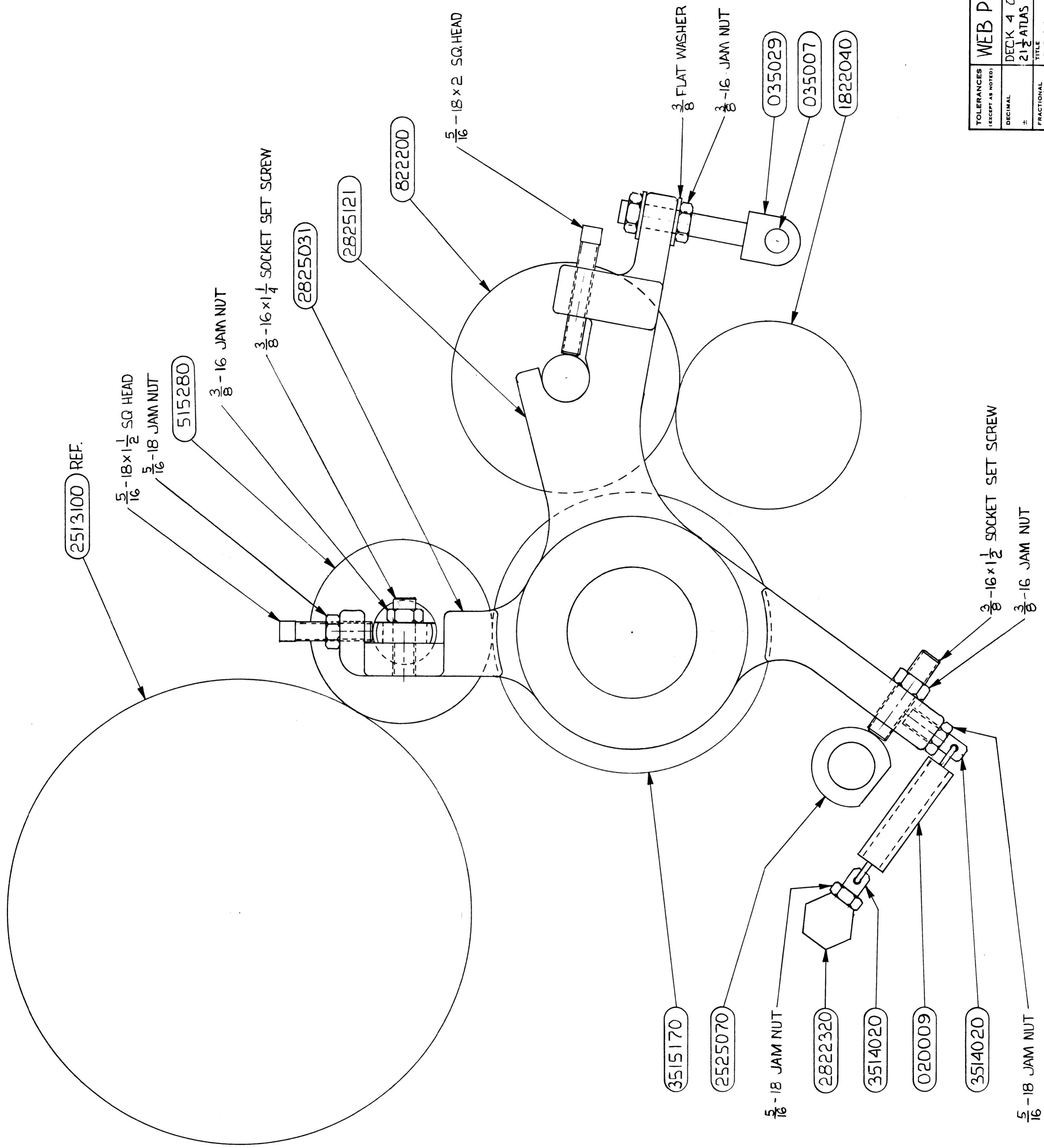
TOLERANCES (EXCEPT AS NOTED)	
DECIMAL	±
FRACTIONAL	±
ANGULAR	±

WEB PRESS CORP. KENT WA.	
DECKS 2 AND 3	SCALE FULL
2 ATLAS QUAD	DRAWN BY WED
TITLE BRUSH DAMPENING ASSEMBLY	
DATE 4-30-93	APPROVED BY
DRAWING NUMBER 1825002	SHT 5 OF 6

**BRUSH DAMPENING 21-1/2" ATLAS QUADRA-COLOR
ASSEMBLY 1825002**

PART NO.	DESCRIPTION	QTY. REQ'D
020009	TENSION SPRING, 1/2 OD x .080 WIRE DIA. x 1-5/8 LG #681 (LANE)	8
035013	SWING BOLT, 3/8-16 x 3-3/4 LG.	4
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
2525070	CAM, WATER FOUNTAIN	6
2825031	HANGER BRACKET	2
2825121	HANGER BRACKET	8
2822320	STOP, BRUSH ROLL	8
3514020	SCREW, SPRING ADJUSTMENT	16

DATE	BY	REVISION RECORD	DR



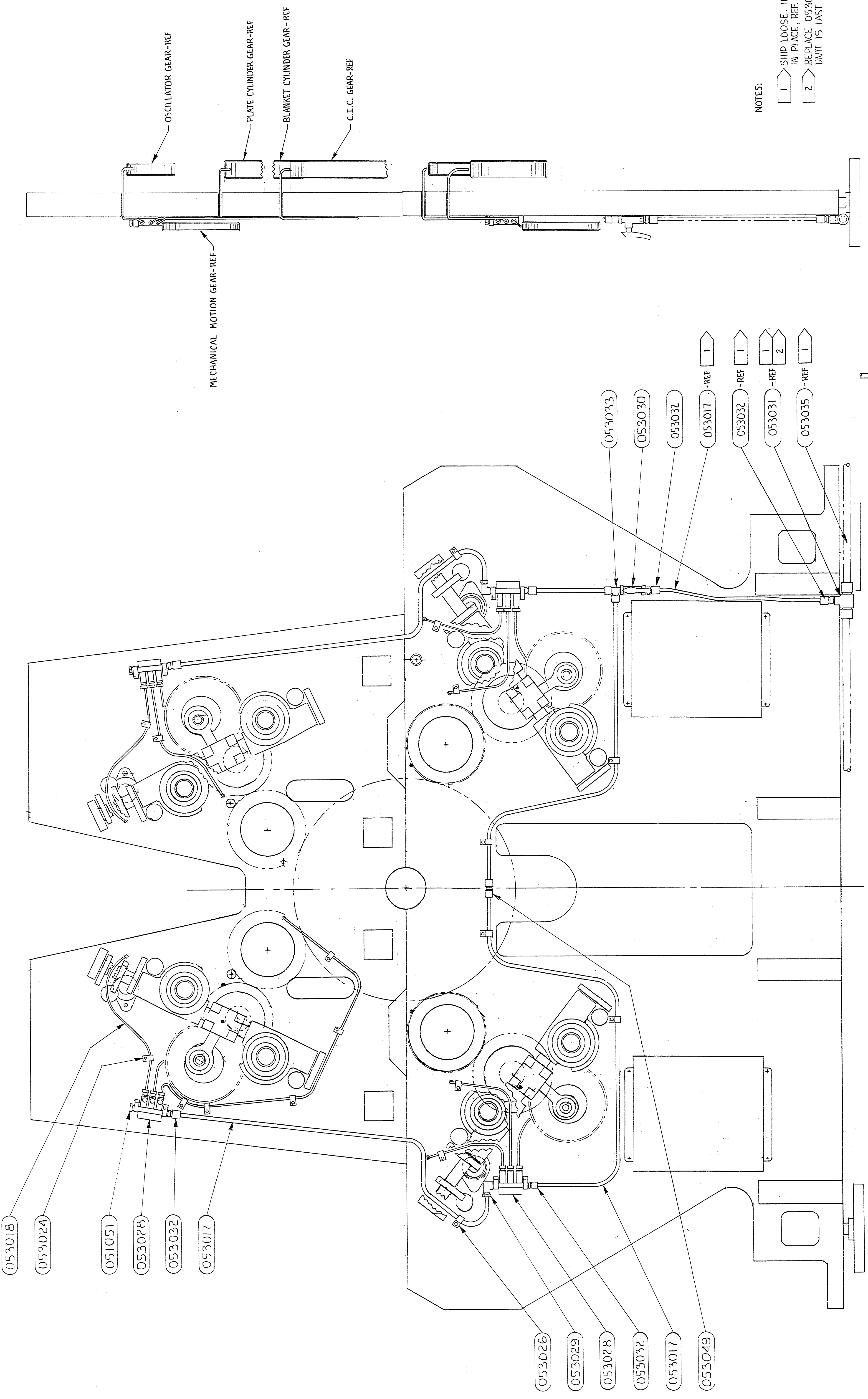
TOLERANCES (EXCEPT AS NOTED)	WEB PRESS CORP. KENT WA.		
DECIMAL	DECIMAL	SCALE	DRAWN BY
±	21-3 ATLAS QUAD	FULL	WJB
FRACTIONAL	TITLE	APPROVED BY	
±	BRUSH DAMPENING ASSEMBLY		
ANGULAR	DATE	DRAWING NUMBER	SHT. 6 OF 6
±	10-18-88	1825002	

Auto-Lube

**AUTOLUBE, ATLAS QUADRA-COLOR
ASSEMBLY 1832000**

PART NUMBER DESCRIPTION QTY. REQ'D

051051	1/4 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 1/4 NPT STAINLESS STEEL	1
053032	MALE CONNECTOR 69071	5
053033	MALE TEE 69090	1
053049	UNION TEE 3/8 69078	1



NOTES:

1 SHIP LOOSE. INSTALL AFTER UNIT IS IN PLACE, REF. 1834000.

2 REPLACE 053031 WITH 053034 WHEN UNIT IS LAST IN LINE.

TOLERANCES (EXCEPT AS NOTED)		WEB PRESS CORP. KENT WA.	
DECIMAL	SCALE	DRAWN BY	APPROVED BY
FRACTIONAL		AEO	
TITLE		DATE	ISSUANCE NUMBER
ATLAS FOUR COLOR AUTOLOBE		8-10-92	1832000
ANGULAR			

AUTOLUBE SYSTEM & ACCESSORIES
ASSEMBLY 1834000

PART NO.	DESCRIPTION	QTE 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) LENGTH 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 1834000A1 (BASIC HOOK-UP)

053029	MALE ELBOW 3/8 T x 1/4 NPT	1
053032	MALE 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 USED; QUANTITY SAME AS 053031)	

AUTOLUBE SYSTEM & ACCESSORIES**ASSEMBLY 1834000A3 (END UNIT OR FOLDER)**

PART NO.	DESCRIPTION	QTE REQ'D
052035	REDUCER, 1/2 NPT x 1/4 NPT (NOTE: REQ'D IF PARKER FITTING USED)	
053034	FEMALE ELBOW 5/8 T x 1/4 NPT (NOTE: END UNIT OR FOLDER ONLY)	

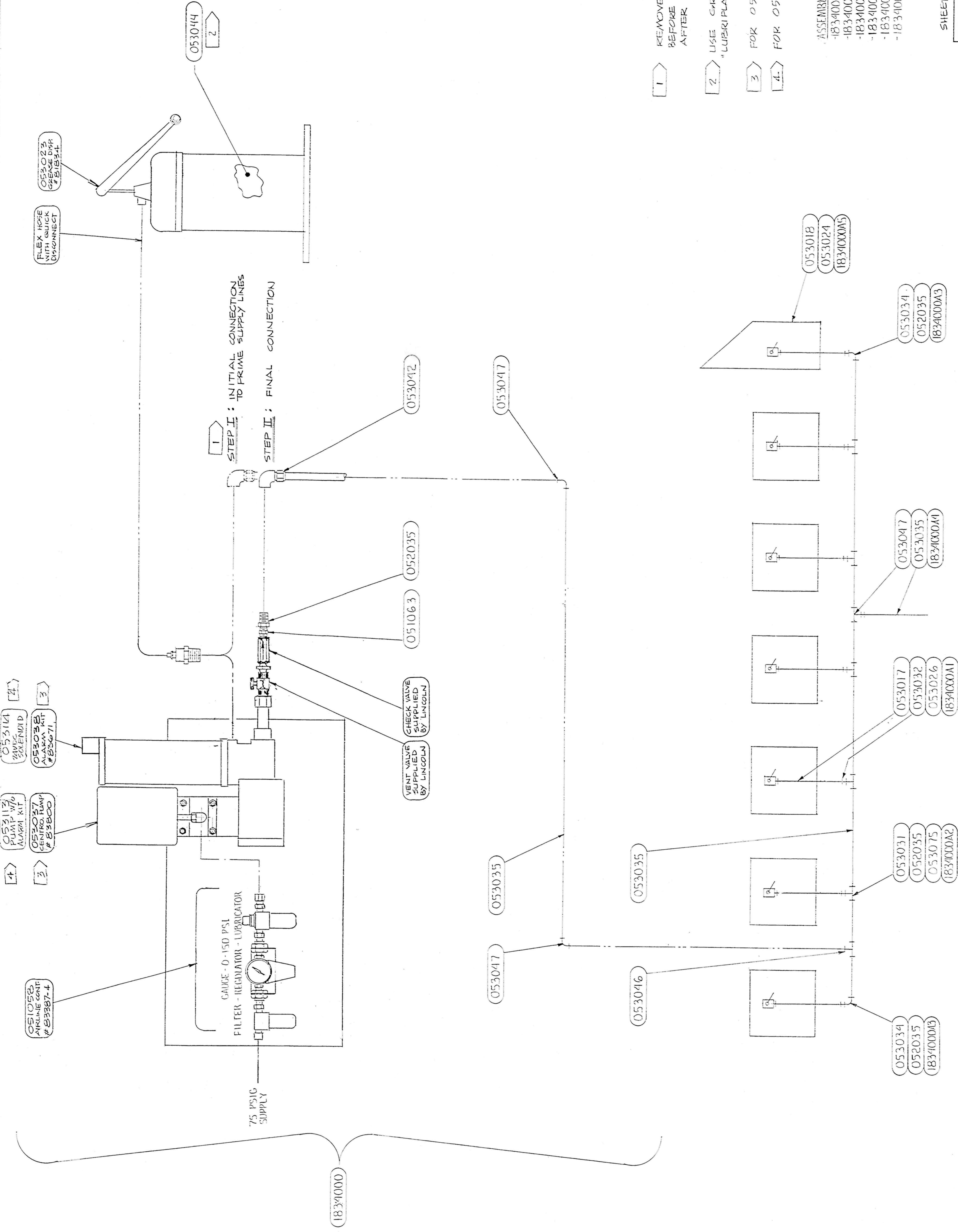
ASSEMBLY 1834000A4 (T & A)

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

REVISION RECORD	OR	EC



- 1 REMOVE INJECTOR PLUGS BEFORE PRIMING. REPLACE PLUGS AFTER GREASE COMES OUT.
 - 2 USE GREASE "LUBRIPLATE GEARSHIELD #1500% NLGI #1"
 - 3 FOR 053037 PUMP (STANDARD)
 - 4 FOR 053113 PUMP (OPTIONAL)
- ASSEMBLIES INCLUDED
- 1834000 AUTO LUBE SYSTEM
 - 1834000A1 OPTION: UNIT 100K-UP
 - 1834000A2 OPTION: LINE JUNCTION
 - 1834000A3 OPTION: END UNIT OR FOLDER
 - 1834000A4 OPTION: T4A AUTO LUBE
 - 1834000A5 OPTION: CROSS PERF AUTO LUBE

SHEET 2 OF 2 "B" SIZE

TECHNICAL	WEB PRESS CORP.	KENT WA.
DESIGN	ALAN PERCICOR	SCALE
DATE	12, 25, 1981	BY
PROJECT	AUTO LUBE SYSTEM INSTALLATION	
REVISED	DATE	BY
1834000	12-11-82	1834000

Compensator

**COMPENSATOR
ASSEMBLY 1815000**

PART NO.	DESCRIPTION	QTY. REQ'D
001054	ER-16X BEARING	4
005005	THRUST WASHER #TRA-1625, TORRINGTON	2
005006	THRUST WASHER #TRB-1018, TORRINGTON	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	1/4-28 LUBE FITTING	2
511490	ROLLER CORE	2
814020	BARREL NUT, COMPENSATOR ADJUST.	1
814050	HANDLE, COMPENSATOR ADJUST.	1
814140	SHAFT, IDLER	1
1815010	SHAFT	1
1815020	BARREL NUT, COMP. SIDE FRAME	1

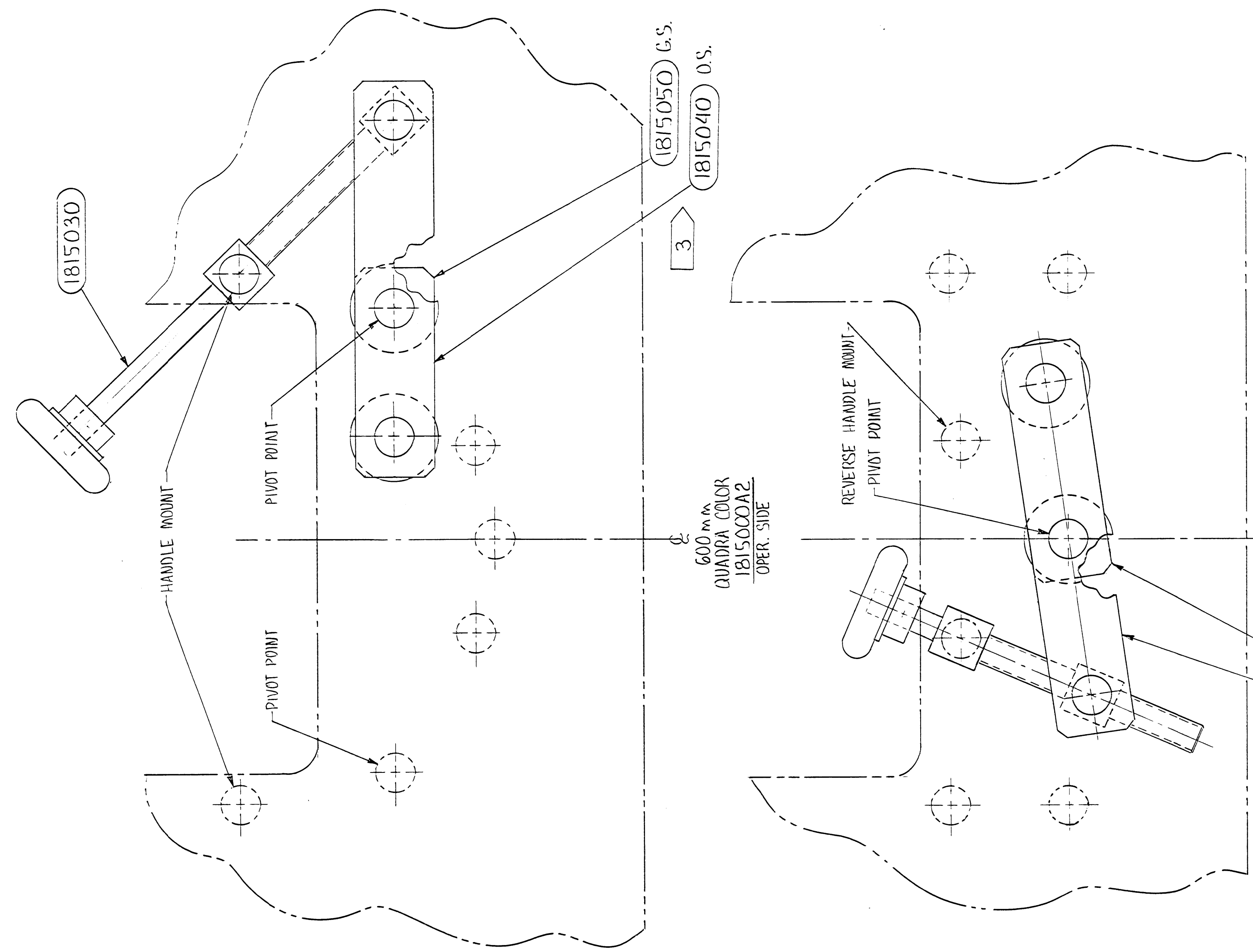
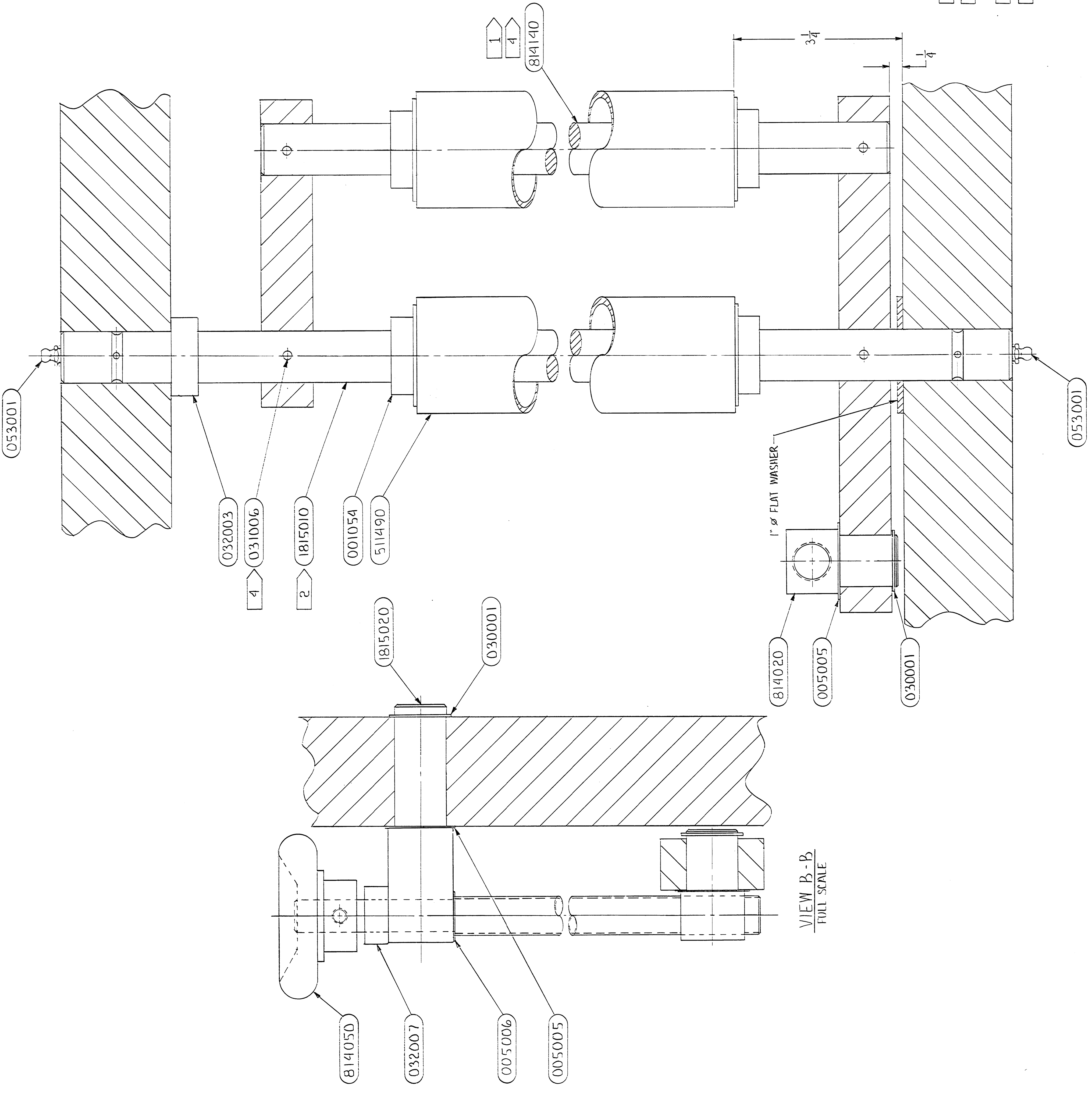
**21-1/2 - 22-3/4 ATLAS QUADRA-COLOR
ASSEMBLY 1815000A1**

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

DATE	BY	REVISION	RECORD
7/1	A	REWORK	SEE FILE COPY



- ASSEMBLIES INCLUDED
 1815000 — BASIC
 1815000A1 — 2 1/2" & 22 3/4" QUADRA COLOR
 1815000A2 — 600 mm QUADRA COLOR
- 1 > IDLE SHAFT TO BE FLUSH WITH OUTSIDE EDGE OF ARMS.
 - 2 > SET PARALLELS UNDER ROLLER CORES PRIOR TO DRILLING # *4 TAPER REAMING & PINNING.
 - 3 > COMPENSATOR ARMS TO BE STAMPED & ASSEMBLED IN PAIRS.
 - 4 > POSITION PIVOT SHAFT & IDLE SHAFT TO DIMENSION SHOWN. DRILL THRU COMPENSATOR ARMS & SHAFT ON ASSEMBLY TO INSTALL TAPER PINS.

TOLERANCES	UNLESS OTHERWISE SPECIFIED	SCALE	APPROVED BY
DECIMAL	±		KENT WA.
FRACTIONAL	±		
ANGULAR	±		

SECTION A-A
 FULL SCALE

VIEW B-B
 FULL SCALE

TITLE	DATE	DRAWING NUMBER
COMPENSATOR ASSEMBLY	9-1-92	1815000, A1 & A2

COMPANY	SCALE	DRAWN BY
WEB PRESS CORP.		KENT WA.

Pneumatics

**SMC PNEUMATIC THROW-OFF, 22-1/4" ATLAS QUADRA-COLOR
ASSEMBLY 2830001**

PART NO.	DESCRIPTION	QTY. REQ'D
051193	SIX STATION MANIFORD 4C LD	1
051175	CONDUIT COVER	1
051161	VALVE, SOLE. 4 WAY	6
051165	CONN. 1/4 MNPT x 3/8 T	4
051187	ELBOW, EXTENDED 1/4 TO 1/4 T	4
051188	ELBOW, EXTENDED 1/4 TO 3/8 T	2
051162	CONN. MALE STR. 1/4 NPT - 3/8 T	2
051182	FITTING	1
051183	MUFFLER 1/8	2
051184	MUFFLER 1/4	2
051166	AIR CYL. 1-1/2 - 4	8
051190	JAM NUT 40 MM BORE	8
051167	AIR CYL. TYPE "A" 3 x 6	4
051190	JAM NUT 40 MM BORE	4
051171	FLOW CONT. VALVE	16
051177	FLOW CONT. VALVE	6
051179	FLOW CONT. VALVE	2
2830060	STAND OFF	4
2830070	LEVER	2
071920	LEVER	2
2830110	COVER	4
2933208	BRACKET, ELECTRICAL BOX	4
2830130	SCREW, ADJUST	4
2830140	COVER	4
2830150	KNOB, CIRC. CONTROL	4
033005	2-3/4 x BLANK BORE HANDLE	4
1830330	CONDENSATION TUBE	2
052029	PIPE 3" BLACK x 36	2
050046	COUPLING 3/8 NPT (1830330)	2
1830320	PLUG	4
1830360	CLAMP, CONDENSATION TUBE	4
2830020	STAND OFF	8
2830250	ROD END. PNEU CYL, 4/C FORM (REF. 051166)	8

**SMC PNEUMATIC THROW-OFF, 22-1/4" ATLAS QUADRA-COLOR
ASSEMBLY 2830001**

PART NO. DESCRIPTION QTY. REQ'D

ASSEMBLY 2830000A1

2830100	EXTENSION	4
032007	5/8 x 1-1/8 SET COLLAR	4
030010	5/8 S.D. SNAP RING	4
2523132	BRAKE/STOP BLOCK-CIRC SHAFT	4

(CONT'D FROM PREVIOUS PAGE)