

WEB LEADER PERFECTING UNIT (51 Series)



PARTS CATALOG

WebPress
Revolutionary™

parts@webpressllc.com

Phone: (253) 620-4747 | www.webpressllc.com | Fax: (253) 722-0378

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

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

Web Leader Perfecting Unit

General Assembly	1-9
Standard Base Frame – 511001	
Base Frame and Stack Unit – 511001A1	
Air Clutch – 5H45TP – 511001C2	
Option: Standard Drive Air Clutch – 511001C2A	
Blanket Cylinder	10-13
Blanket Cylinder Assembly – 512001	
Plate Cylinder	14-17
Plate Cylinder Assembly – 513000	
Ink System	18-23
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Brush Dampener	24-31
Brush Dampener Assembly – 822001	
Option: DC Brush Dampener System – 822001C1	
Option: Stainless Steel Water Oscillating Shaft – 822001D1	
Mechanical Motion	32-38
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Guards

39-43

Guards, Gear Side – Web Leader – 517001C

Ink Train Guards – 54 Series – 5170001A

Compensator

44-47

Perfector Compensator – 814000

Stacked Unit

48-55

Ink Train Guards – 517001A

Guards, Gear Side – 517001C

Guards, Web Leader Stack – 517000F

Ink Train Guards – 517001D

Belt Drive 54 Series – 829005A1

Assembly Bottom Idler – 830460

Top Drive Assembly - 830470

Connective Parts

- Reverse Rollstand to Unit – 518000B2
 - Stack to Unit – 518000E15
-



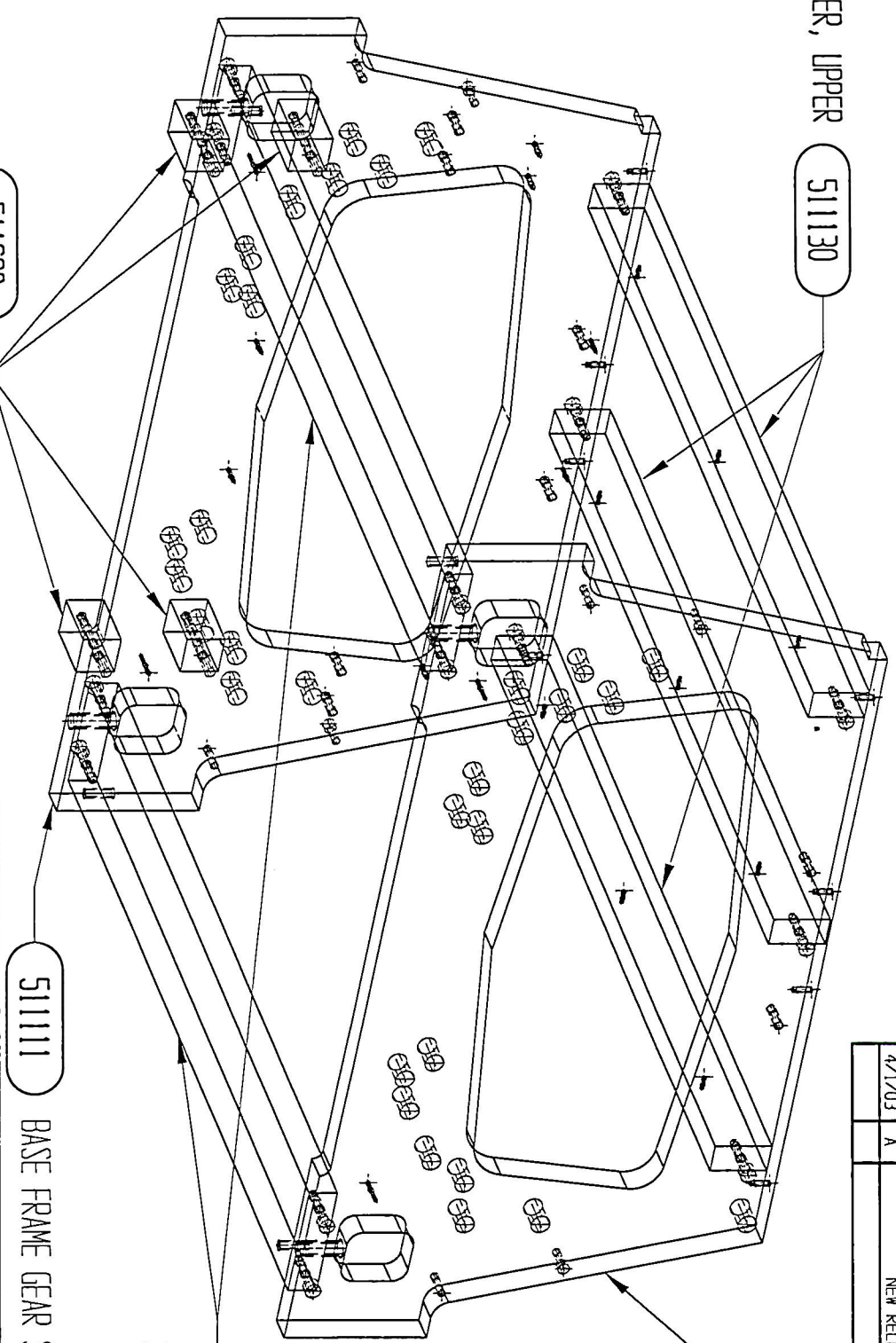
General Assembly

51101

General Assembly: Standard Base Frame

Part Number	Description	Quantity
511214	Perfactor Side Plate O.S.	1
511225	Perfactor Side Plate O.S.	1
511237	Perfactor Side Plate GS	1
511248	Perfactor Side Plate GS	1
511260	Leveling Bolt	4
511480	Shaft, Stiffener	2
511490	Roller Core	2
511510	Jacking Screw	2
511521	Unit Tie Bracket	2
511530	Pulley, Belt Idler	1
511540	Spacer, Belt Idler	1
1511360	Bolt, Drive Belt Idler	1
511570	Operator Label circ to pins	2
511580	Oper. Label Sidelay to Operator	2
511590	Bar, Roller Support	2
001054	ER-16x Bearing	4
003001	750 ID X 1.782 OD Bearing Assembly	1
060001	½ P X 1 ½ W X 85" LG Belt	1
061002	30T X ½ P X 2" W with Taper Bushing	1
062002	1 1/8 Bore Taper Bushing	1
1511390	Plate, Idler	1

DATE	SYM	REVISION RECORD	DR	CK
4/1/03	A	NEW RELEASE	WEN	



511690
SPACER, DRIVE LINE

511130
STIFFENER, UPPER

511111
BASE FRAME GEAR SIDE

511160
STIFFENER, LOWER

511121
BASE FRAME OPERATOR SIDE

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TOLERANCES (EXCEPT AS NOTED) DECIMAL .01 .XX ± .005 .XXX ± .005 FRACTIONAL ± 1/32 ANGULAR ± 1 Deg			TITLE WEB LEADER BASE FRAME	
DESIGNED BY W. E. N.	DRAWING NO. 511001A1		SCALE XXXXX	DATE 4-1-03
APPROVED BY XXXXXXXXXXXXX		SIZE B	REV - A	

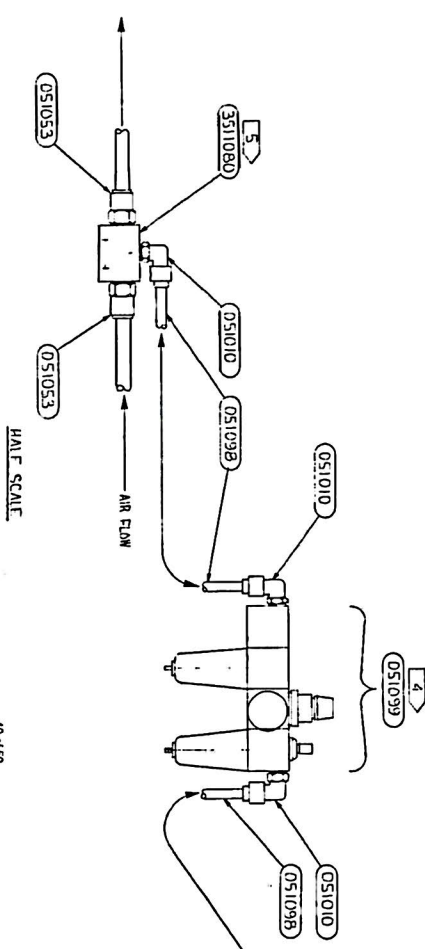
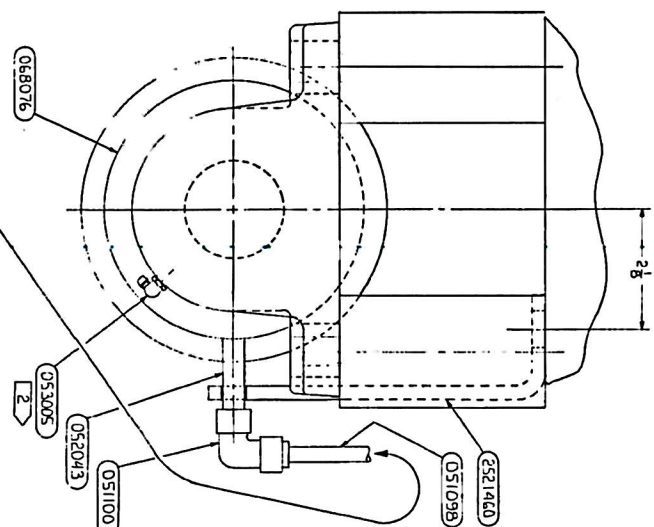
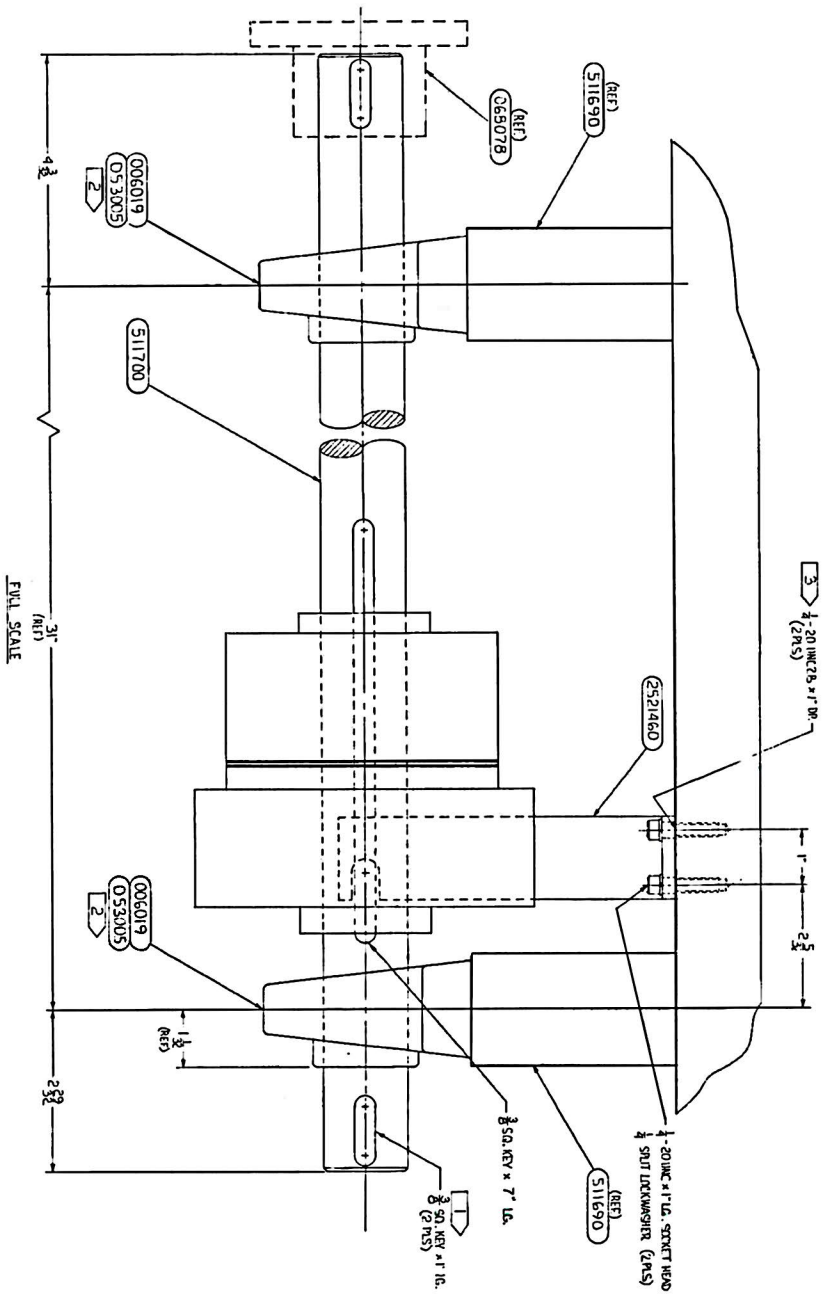
WEB PRESS, LLC
701 EAST 7TH STREET
TACOMA, WASHINGTON 98421

7-4150

511001C2

Air Clutch - 5H45TP

Part Number	Description	Quantity
006019	Pillow Block 1 ½ Centrik	2
051098	1/8 X ¼ OD Tubing FT	10
051100	Female Elbow 1/4T OD X 1/8	1
052043	Nip LG Male 1/8 NPT X 2"	1
051099	Filter/Regulator/Lube	1
051010	Swivle Elbow ¼ NPT X ¼ T	2
051053	Connector 3/8 NPT X ½ T	2
3511080	Manifold	1
2521460	Bracket	1
068076	Air Clutch 5H45 With Pulley	1
2828760	Spacer, Air Regulator	1
511680	Bracket, Manifold.	1



- 1 - INSTALL KEY TO SHFT & TIRE IN PLACE (FOR REM- FINIS)
- 2 - REBARE GEARSE FITTING WITH SQA FITTINGS.
- 3 - BRILL AND TAP 1-20 UNC x 1.125 KEYS BEFORE CLUTCH AND TIRE ASSEMBLY'S ARE IN PLACE.
- 4 - MOUNT GEAR SIDE, EYE LEVEL ON COMP. RISER.
- 5 - ARCHIT HIDE GEAR-SIDE FRAME, NEXT TO FLOOR.

THE WALT AIR SYSTEMS, LTD. 1000 W. 10TH AVE. DENVER, CO. 80202	PROJECT NO. 100012 DRAWING NO. 100012
TITLE W.L. DUFF, AIR CLUTCH, SH45TP	DATE 12-8-97
DRAWN BY W.L. DUFF	CHECKED BY S100012

511001C2A

Option: STD/Drive Air Clutch

Part Number

Description

Quantity

511700	Shaft Main Drive	1
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Blanket Cylinder Assembly

512001

Blanket Cylinder Assembly

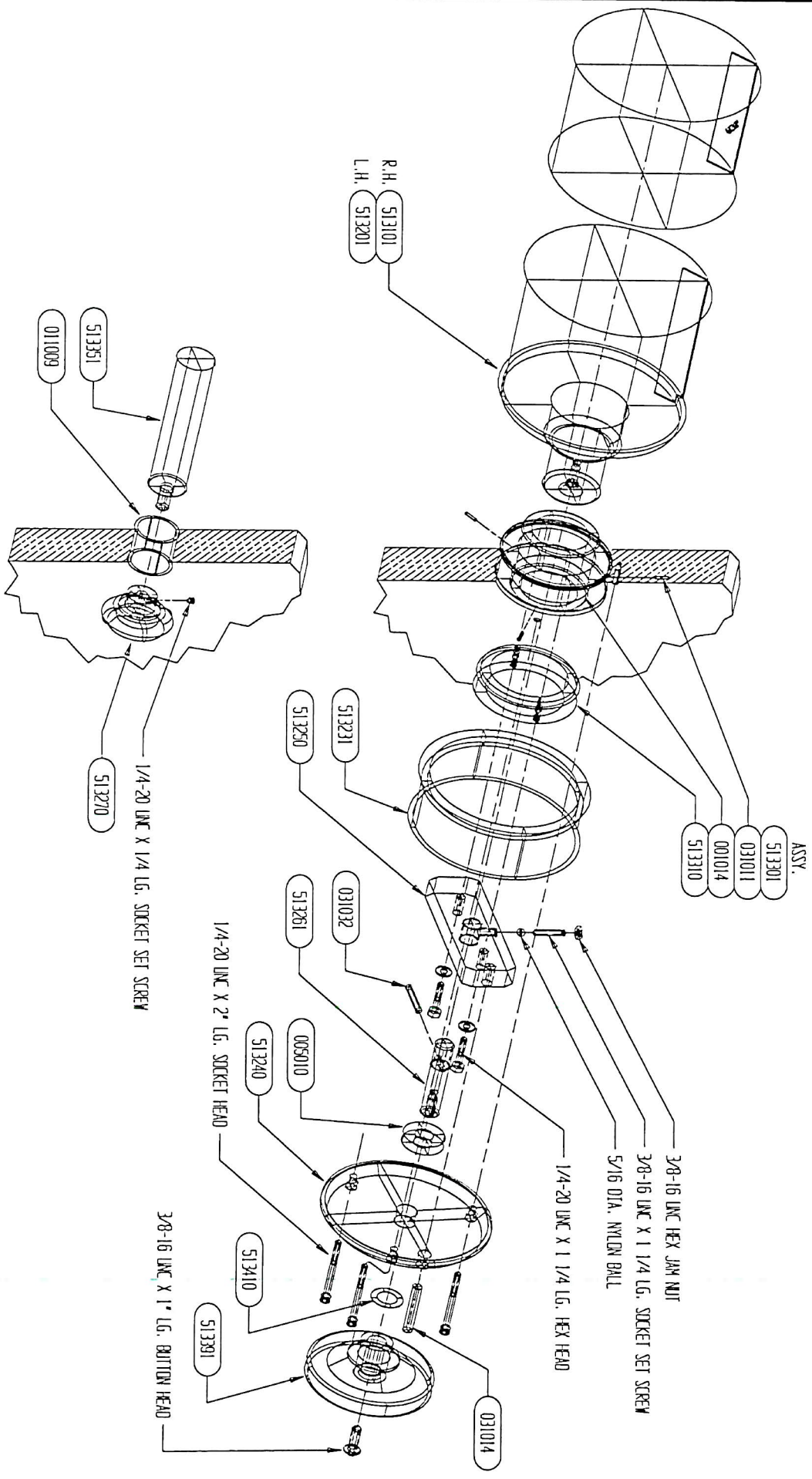
Part number	Description	Quantity
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512101	Perfector Blanket Cylinder	2
512171	Bearing Cap	3
512192	Timing Dial	1
512220	Impression Dial	1
512242	Shaft, Impression	2
512251	Handle Impression LH	1
512260	Washer, Impression Handle	2
512281	Spacer, Impression Linkage	4
512340	Eccentric, Black Cylinder	2
512350	Eccentric, Black Cylinder RH	2
512360	Impression Arm	4
512370	Impression Link	4
512380	Guide, Black Cylinder Eccentric	8
512390	Phenolic Washer	4
512410	Handle, Impression RH	1
512420	Stop, Eccentric	4
522141	Gear, Circ. Blanket Cylinder	1
522151	Gear, Circ. Blanket Cylinder	1
001014	ER-36 Bearing	4
008001	Rod Eye ½ ID LH	4
011003	Bush 1 ¼ X 1 ½ X 1 ½	4
012001	Dunbushing ¾ X 7/8 X ¾	4
068006	INR Race ½ X ¾ X ¾	4



Plate Cylinder Assembly

DATE	SYM	REVISION/RECORD	DR.	CK.
3/7/03	A	NEW RELEASE	VEN	



TOLERANCES
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FINISH	.01
XXX	.05
FRS/DIM.	
±	1/2
ANGLE	1 Deg.

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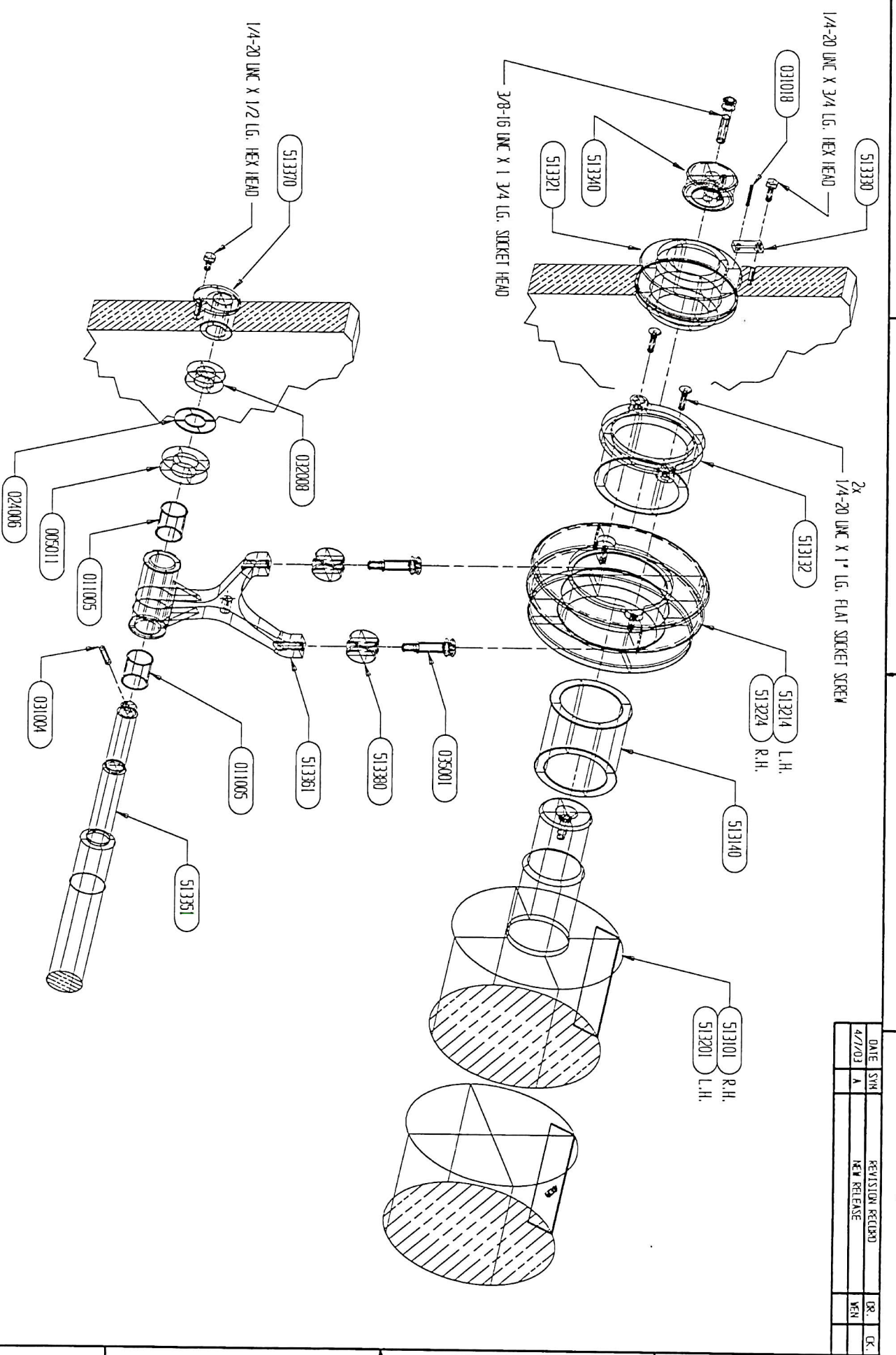
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707 EAST 10TH STREET
TACOMA, WASHINGTON 98401

PLATE CYL. ASSY 0.S.

WEB LEADER DWG. NO. 513000 SHT. 1/2

SCALE XXXXX DATE 4-7-03 SHEET 8 REV - A

DATE	SYN	REVISION RETURNED	DR.	CK.
4/7/03	A	NEW RELEASE	VEN	



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FINISH	ASSEMBLY		
± .01	± 1.0%	DATE BY	TITLE
± .05		F. E. N.	PLATE CYL. ASSY. G.S.
± 1/2		APPROVED BY	WEB LEADER
		XXXXXXXXXX	DATE 4-7-03
			SHEET 8
			REV - 1



Ink System Assembly

514000

Ink System Assembly

Part Number	Description	Quantity
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514011	Block, Ink Fountain RH	1
514021	Block, Ink Fountain LH	1
514040	Ink Fountain Cheek	4
514050	Ink Fountain Seal	4
514060	Strap Lower	2
514070	Strap Upper	2
514080	Blade, Ink Fountain	2
514091	Key, Ink Fountain	66
514120	Roll, Ink Fountain	2
514130	Fountain Roll Cover	2
3514050	Washer, Fountain Drive Retainer	2
514150	Arm, Ink Fountain Roll	2
514151	Arm, Double Stroke Fountain RH	1
514171	Arm, Double Stroke Fountain LH	1
514180	Tab, Ink Fountain Drive Spring	2
514190	Bracket, Slide	2
514210	Locking Cam, Slide	2
514220	Eccentric Pin, Slide Cam	2
514230	Slide, Double Stroke Inker	2
514240	Rod, Adjusting Inker	2
514250	Roll, Ink Skimmer	2
514260	Shaft, Ink Skimmer	2
514270	Plate, Ink Skimmer Eccentric	4
3514060	Screw, Fountain Drive Retainer	2
514291	Bracket, Ink Skimmer Clamp	4

514000

Ink System Assembly

Continued From Previous Page

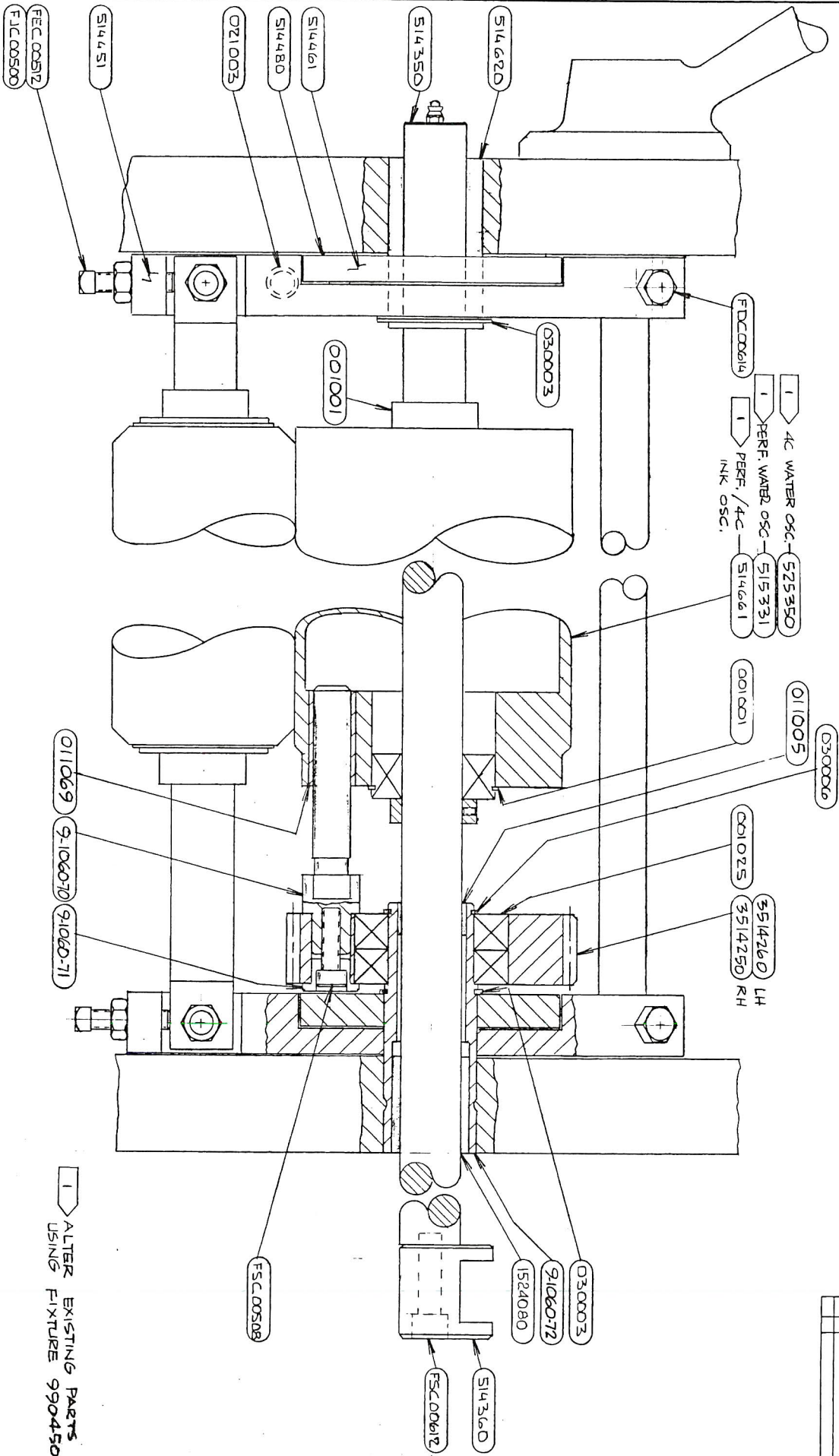
514310	Ink Form Roll 2 ¾	4
514320	Form Roll Shaft	4
514330	Swing Bolt, Ink Skimmer	4
514350	Shaft, Oscillator	4
514360	Oscillator Shaft Button	4
514370	Ink Transfer Roll, 3" Dia	2
514380	Transfer Roll Bracket	4
514390	Form Roll Cam Shaft	2
514411	Cam, Form Roll	4
514420	Handle, Form Roll R	1
514430	Handle, Form Roll L	1
514440	Detent Piston	2
514451	Roller Hanger Bracket	4
514461	Roller Hanger Bracket	4
514480	Phenolic Washer	8
514512	Gear, Oscillator RH	1
514531	Key, Driven Oscillator	1
001007	1.378 ID X 2.8345 OD Bearing	1
514522	Gear, Osc. LH	1
514531	Key, Driven Oscillator	1
001007	1.378 ID X 2.8345 OD Bearing	1
514611	Wear Strip, Osc. Pin	4
514620	Oscillator Bushing Brass	2
514630	Oscillator Bushing, Steel	2
514640	Ink Form Roll 2 7/8	2
514710	Oscillator, Ink Undriven	2
514740	Shaft, Transfer Roll	4
514760	Phenolic Washer	2

514000

Ink System Assembly

Continued From Previous Page

515480	Spacer	2
514661	Ink Oscillator	2
001001	ER-16	28
001002	1 1/8 ID X 2.4409 ER-18	4
1524080	Bushing	6
011002	Oilite Bushing 3/4 X 1 X 1 1/2	4
020016	Spring	4
021003	Comp. Spring 1/2 OD X 3 LG	4
021008	Comp. Spring 3/8 OD X 1 1/4	2
021009	Spring Plun 1/4 - 20 X 3/4	2
033003	Knob 3 1/8 Dia 1/2-13	2
033004	Knob 3/4 OD 10-32 X 1/2 LG	2
068002	One Way Clutch 1 X 5/8	4
068048	Inner Race 3/4 ID X 1 OD X 1.515	2



1 ALTER EXISTING PARTS USING FIXTURE 990450

DATE	BY

W WEB PRESS LLC
701 EAST 7th STREET
TACOMA, WASHINGTON 98431

Scale: 1:1
Date: 3-14-84
Oscillating Roller Prefector,
Four Color
Drawing Number:
Perfector & Four Color

Drawn by: GP	514000
Revised	524000
	Sheet 2 of 2



Brush Dampening Assembly

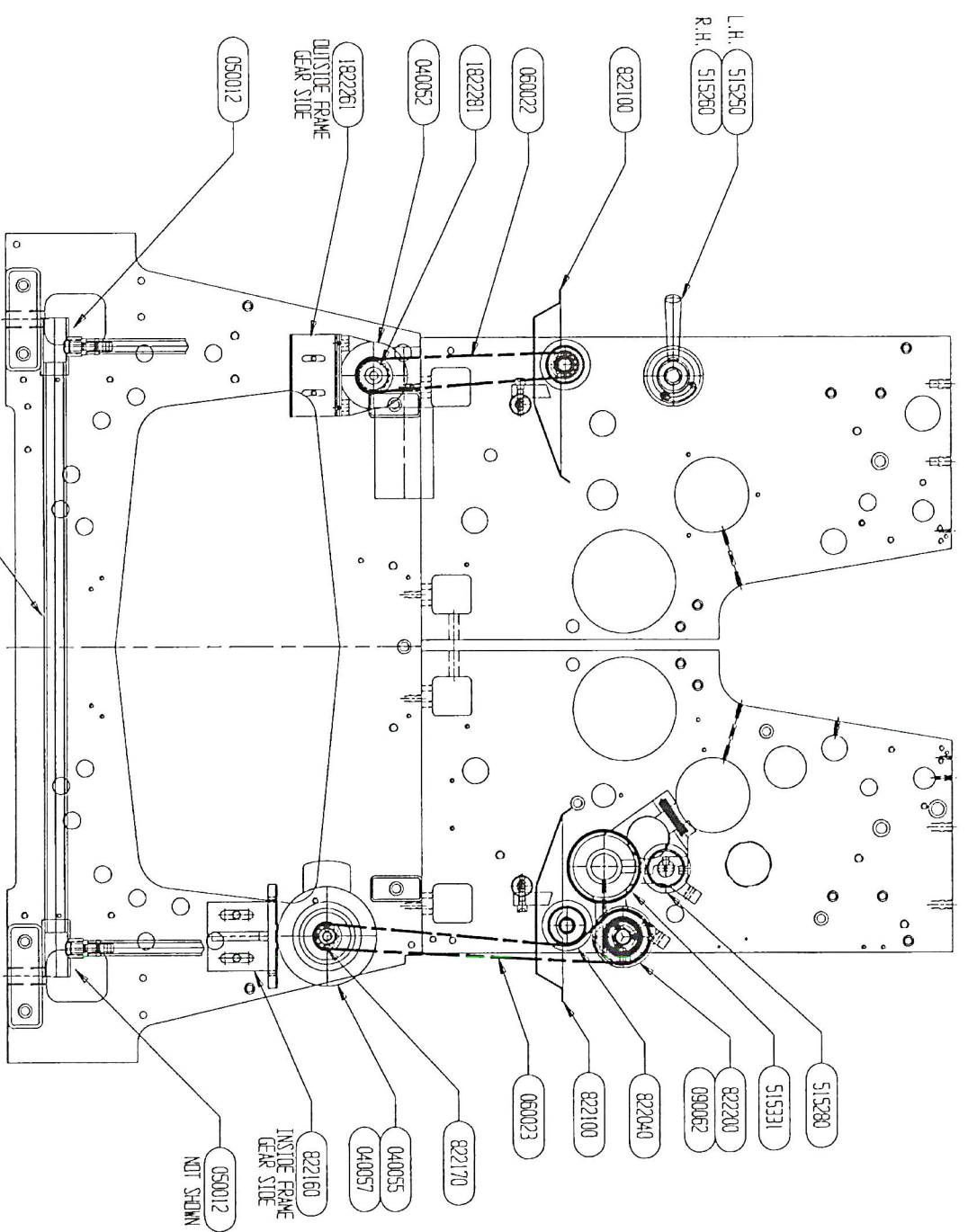
822001

Brush Dampening Assembly

Continued From Previous Page

822050	Idler, Water Fountain Drive	2
822100	Water Pan Assembly	2
822120	Shaft, Brush Roll	2
822130	Drive Pulley, Brush Roll	2
822140	Shaft Form Roll	2
822151	Cam Form Roll	4
822160	Bracket Motor Mount	2
822170	Drive Pulley, Brush Roll	2
822200	Assembly Brush Roll	2
090062	Brush 2 ¼ X 3 9/16 50 Turn	2
822370	Stiffener, Water Pan Perf.	2
1524080	Bushing	2
050133	Reducer	2
822640	Cap-Stainless	2
050132	Nipple	2
001001	ER-16	16
001018	¾ ID X 1.8504 OD Bearing	4
011002	Oilite Bushing ¾ X 1 X 1 ½	4
021022	Comp Spring ½ X 3"	4
021008	Comp Spring 3/8 OD X 1 ¼	2
050015	Male Barb Fitting ½ PVC	2
050011	¾ Hose Clamp	4
050012	19/16 to 1 ¼ Clamp	4
050131	CLS NIP 3/8 NPT-PVC	2
050020	O-Ring	4
051068	Ball Valve ½ NPT-PVC	2
060023	3/8 P X ¾ W X 42 LG Timing Belt	2
050135	Pipe Nut 3/8 NPT Stainless Steel	6

DATE	SYM	REVISION RECORD	DR.	CK.
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TOLERANCES
(unless in detail)

FINISH	XX ± .01
FUNCTION	XXX ± .05
ASSEMBLY	V/2

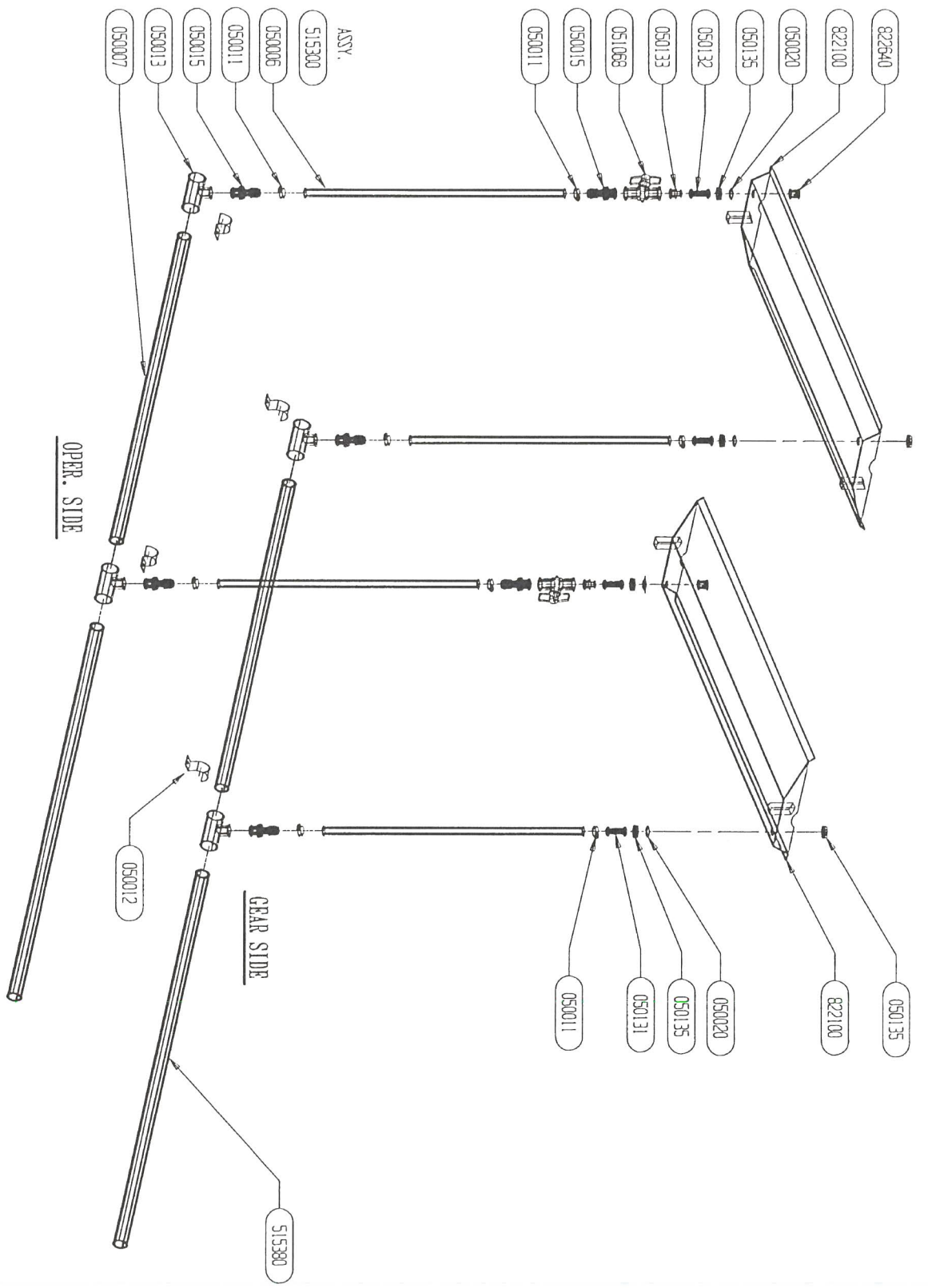
APPROVED BY: M.E.N.
 DRAWN BY: XXXXXXXXXXXX
 SCALE: XXXXX DATE: 4-7-03

WEB PRESS, LLC
 770 EAST 31ST ST
 TACOMA, WASHINGTON 98401

BRUSH DAMP ASSEMBLY
 WEB LEADER: DME NO. 822001 SHIT. 2/3
 INT. DATE: 4-7-03 SIDE: B REV: -A

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FINISH	± .01
XX	± .01
XY	± .05
FRACTIONS	
±	1/2
ANGLES	± 1 Deg.

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	TITLE BRUSH DAMP ASSEMBLY
DESIGN BY W.E.N.	WEB LEADER DEC NO: 822001 SHI. 3/3
APPROVED BY XXXXXXXXXXXXX	SCALE XXXXX
DATE 4-7-03	SIZE C
REV - A	

822001D1

Option: Steel Water Osc. Shaft

Part Number	Description	Quantity
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514350	Shaft, Oscillator	2
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Mechanical Motion Assembly

823001

Mechanical Motion Assembly

Part Number	Description	Quantity
516211	Gear, Mechanical Motion	2
516221	Pin Gear Mechanical Motion	2
516331	Spacer, Mechanical Motion	2
516340	Washer, Ink Push Rod	2
823010	Shaft Mechanical Motion	2
516150	Oscillator Swing Arm	6
516160	Fountain Drive Arm	2
516312	Yoke Mechanical Motion	2
516871	Link Mechanical Motion Driven	2
1516570	Assembly Spacer Bearing	2
1516580	Assembly Spacer Bearing	2
009003	3/8 24 X 3/4 OD Cam Follow	6
516890	Guide Blade	4
001002	1 1/8 ID X 2.4409 ER-18	6
003002	1.5000 ID X 2.5626 OD	2
008002	1/2 ID 1/2 20 Male	2
009002	7/16 20 X 1" OD	2
009003	3/8 24 X 3/4 OD Cam Follow	2
011001	Bushing 3/8 X 1/2 X 3/8	2
516960	Bearing Block, Mach.	2
516970	Bearing Block Machined	4
1516360	Bearing Housing	3
001033	10811 X 2.4409 Bearing	4
001001	ER-16	3
516710	Push Rod, Double Stroke LH	1
516720	Push Rod, Double Stroke RH	1
516980	Pinion Support Mach.	1
516990	Pinion, Drive LH Air Clutch	1
823420	Pinion Idler LH	1
823410	Pinion Idler RH	2
001059	ER-18T Clamp Bearing	1

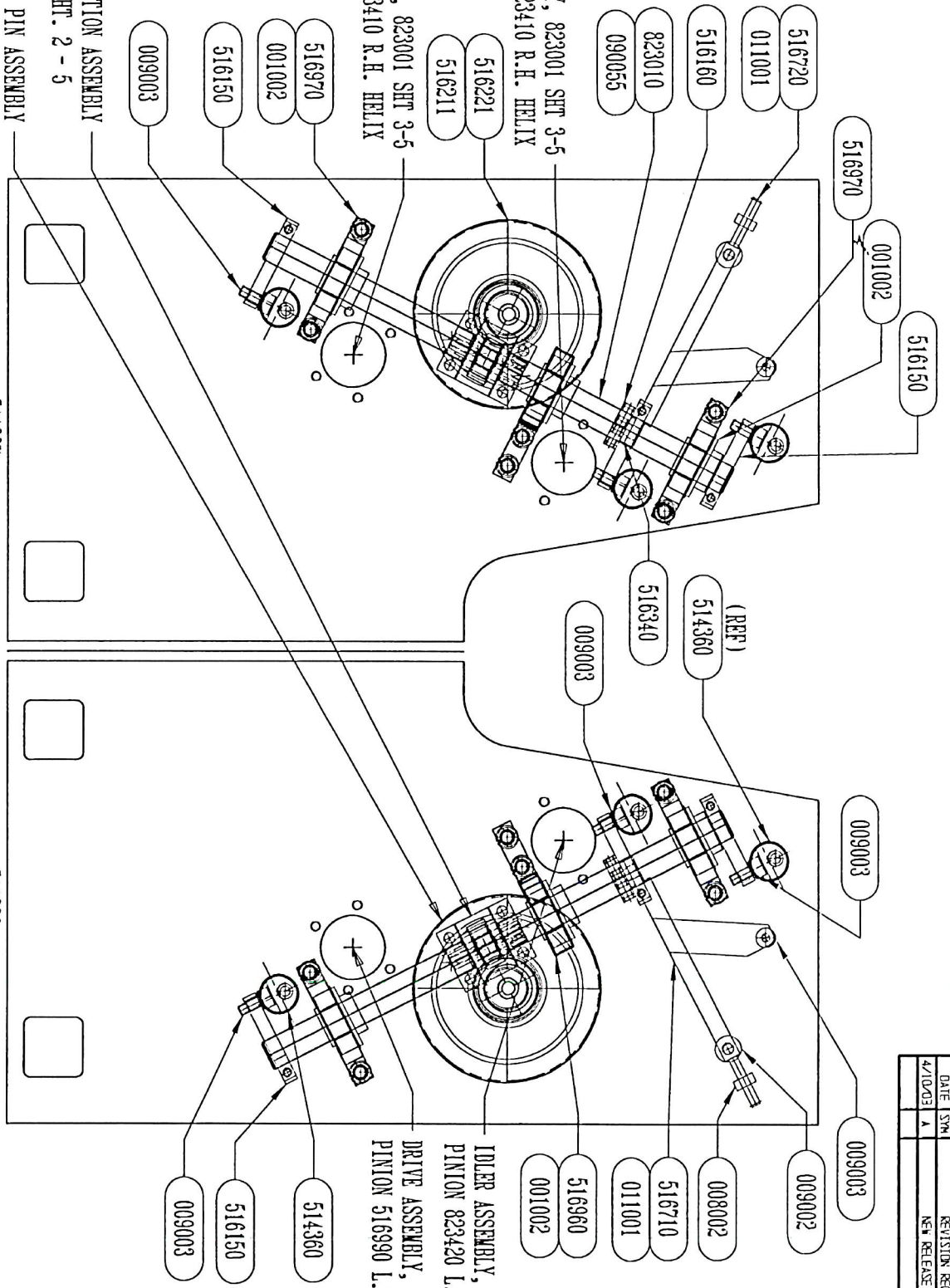
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3

2

1

DATE	SWM	REVISION RECORD	DR.	CR.
4/10/03	A	NEW RELEASE	WEN	



511237
PAGE TWO GEAR SIDE

511238
PAGE ONE GEAR SIDE

TOLERANCES
 UNLESS SHOWN OTHERWISE:
 DECIMAL ± .01
 FRACTIONAL ± .005
 ANGLES ± 1 Deg.

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MECH. MOTION ASSEMBLY

DATE: 4-10-03
 SIZE: 8
 REV: A

4

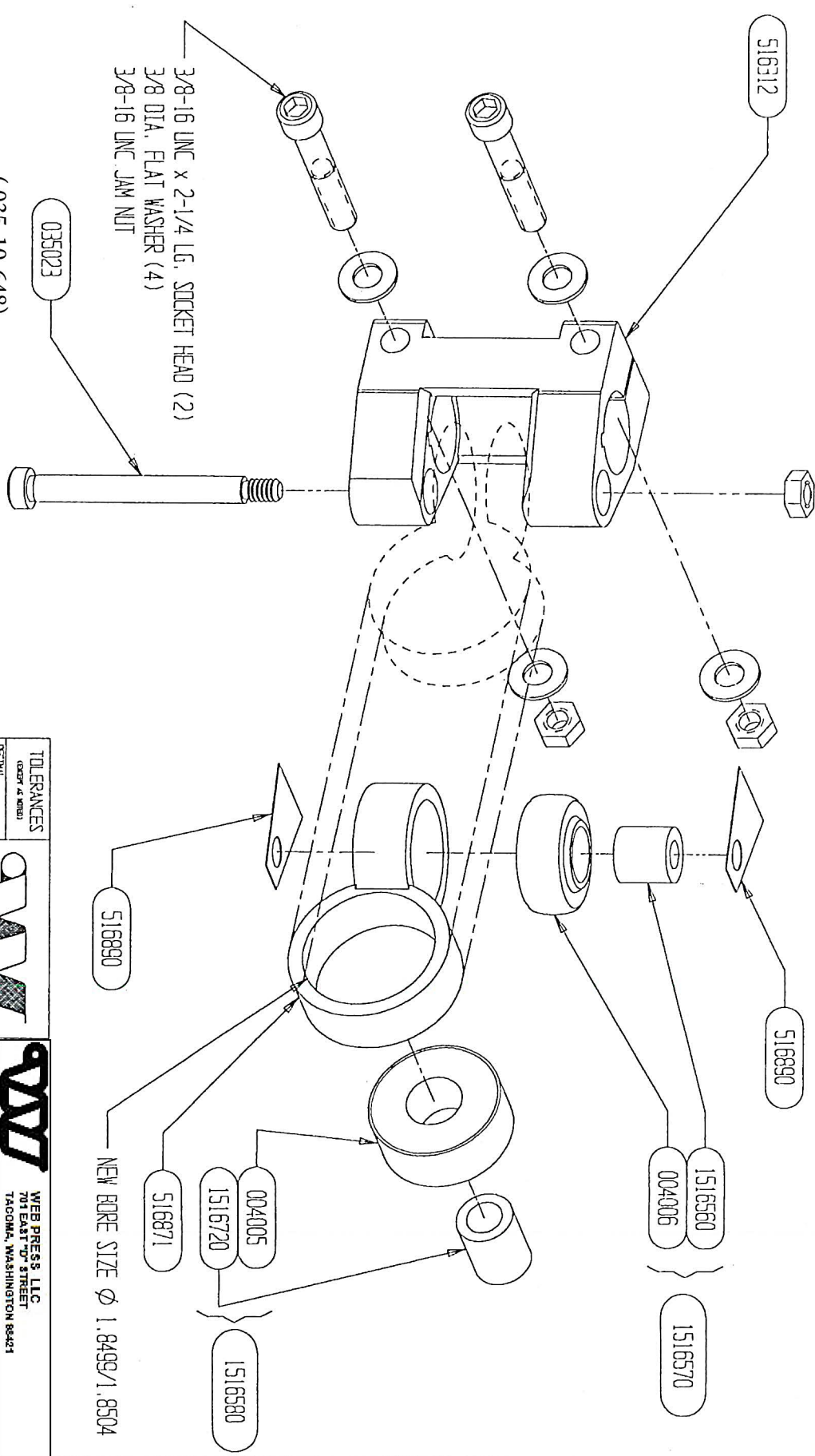
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2

1

3 of 50

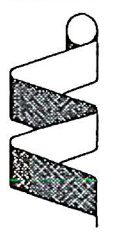
DATE	SYN	REVISION RECORD	DR.	CK.
11/5/95	A	SEE DN #1281	F.D.	



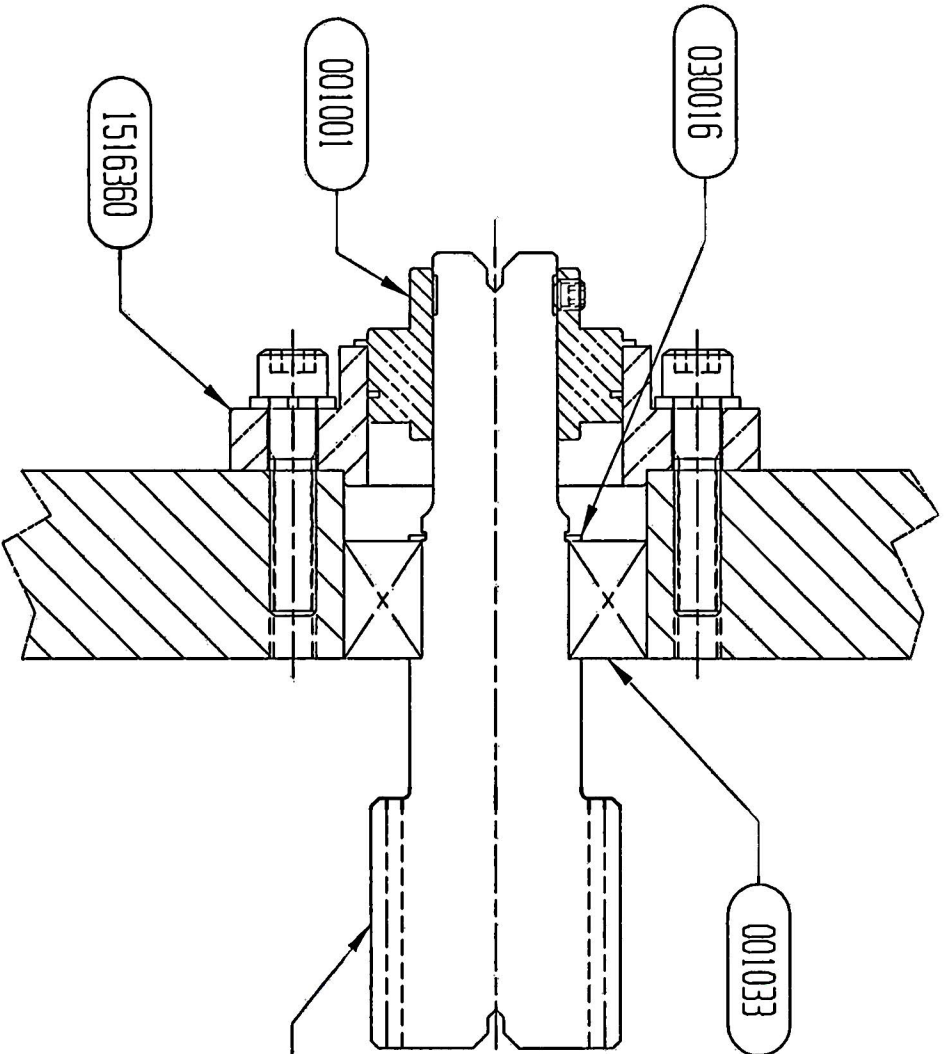
TOLERANCES
(EXCEPT AS NOTED)

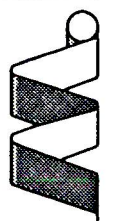
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ANGULAR	± 1/32
FUNCTIONAL	± .005

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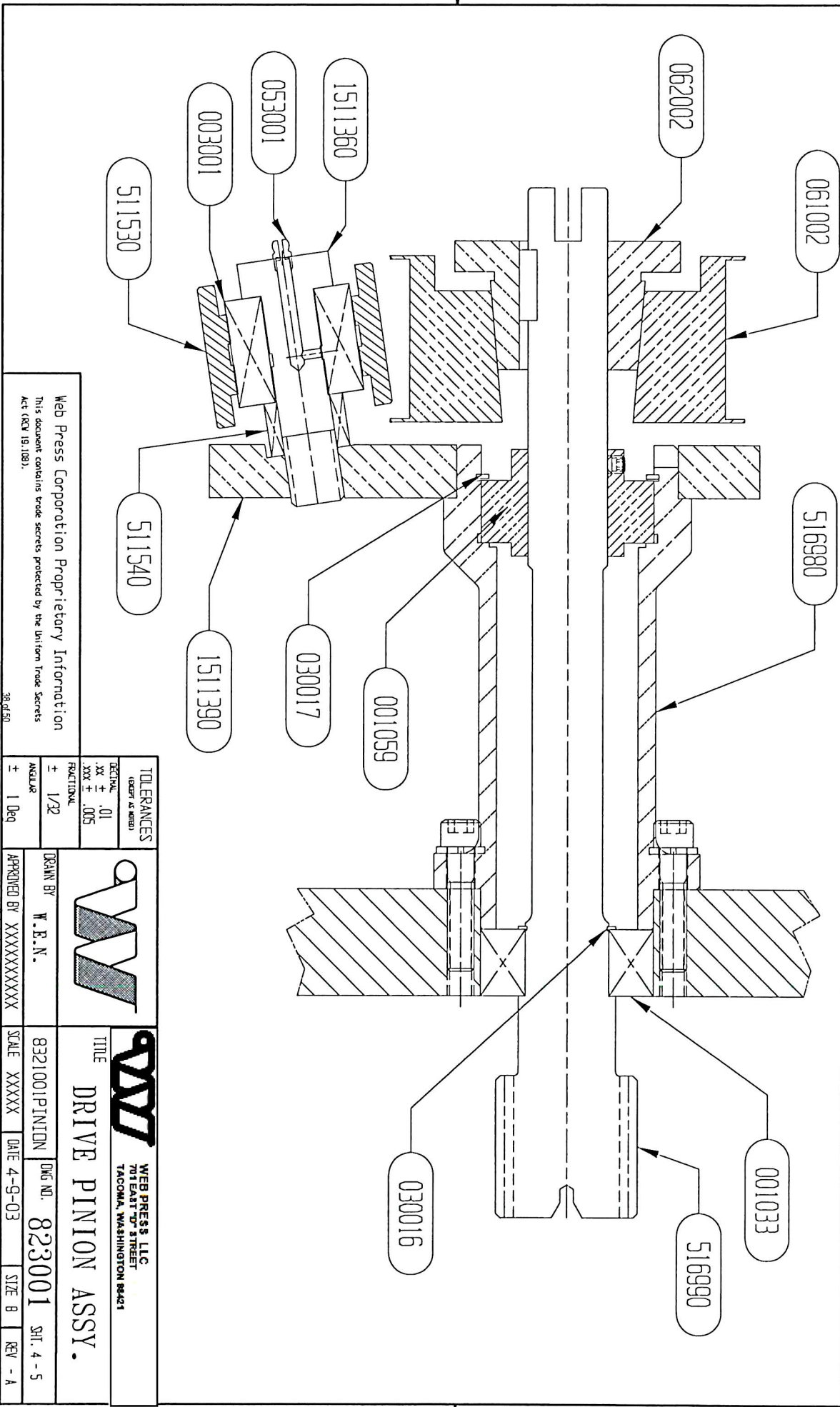
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	TITLE MECH. MOTION ASSEMBLY
DRAWN BY W.E.N.	DWG. NO. 823001
APPROVED BY XXXXXXXXXXXXX	DATE 4-8-03
SCALE .750	SIZE B
SHEET 2-5	REV 8

DATE	SYM	REVISION RECORD	DR.	CK.
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DESIGN BY W.E.N. APPROVED BY XXXXXXXXXXXXX		IDLER PINION ASSY. TITLE		DWG NO. 823001 DATE 4-9-03	
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FRACTIONAL	.005
ANGULAR	± 1/32
±	1 Deg

W

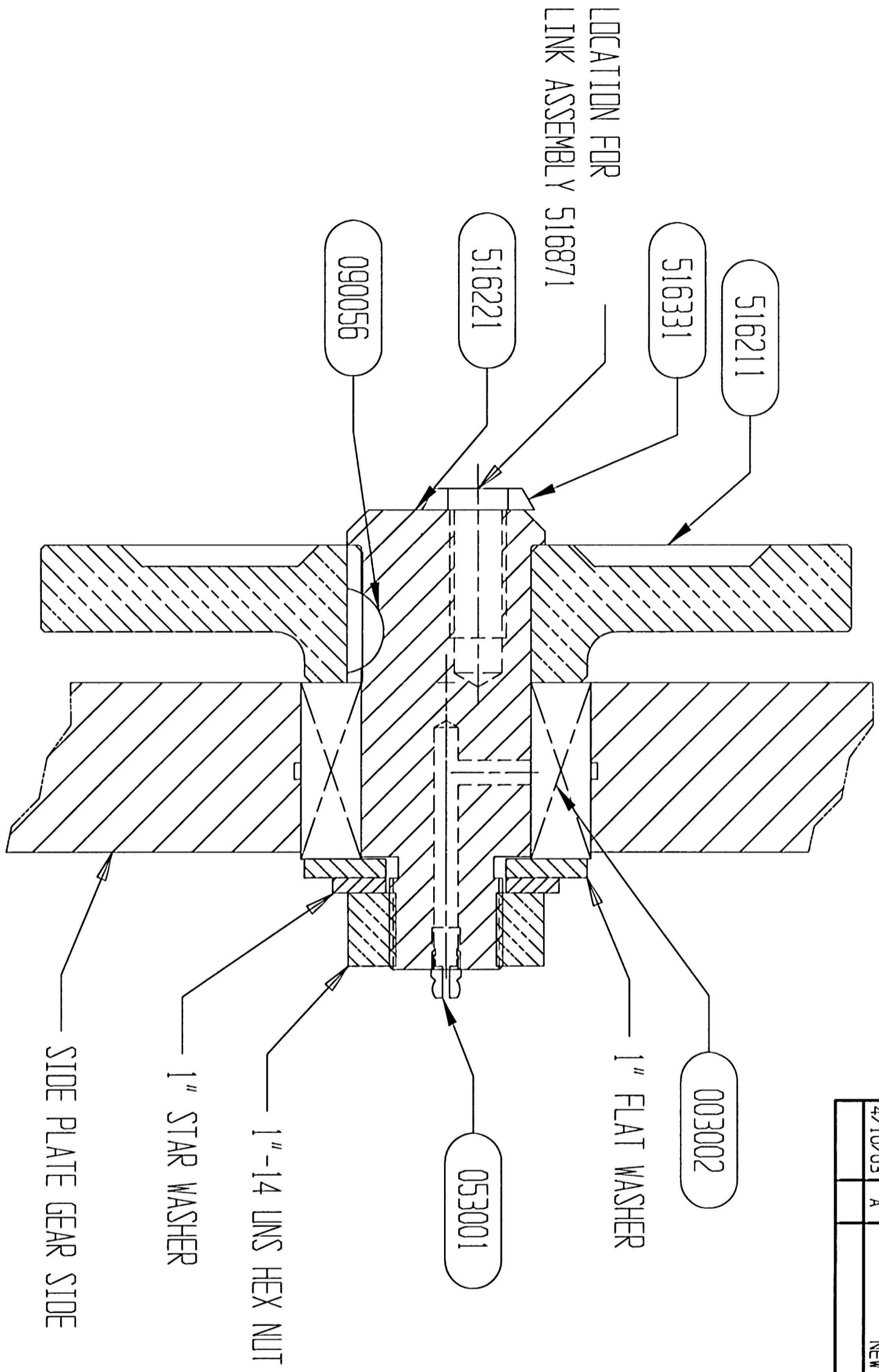
DRAWN BY: W. B. N.
 APPROVED BY: XXXXXXXXXXXXX

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 701 EAST 10TH STREET
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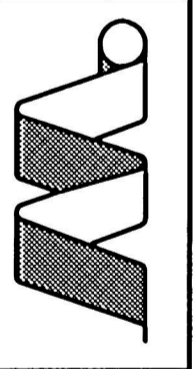
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DWG. NO. 823001 SH. 4 - 5
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DATE	SYM	REVISION RECORD	DR.	CK.
4/10/03	A	NEW RELEASE	WEN	



TOLERANCES (EXCEPT AS NOTED)	
DECIMAL	.01
.XX ±	.005
.XXX ±	
FRACTIONAL	
±	1/32
ANGULAR	
±	1 Deg



DRAWN BY W.E.N.
APPROVED BY XXXXXXXXXXXXX

WEB PRESS CORP., KENT, WASH.
TITLE
M.M GEAR & PIN ASSY.

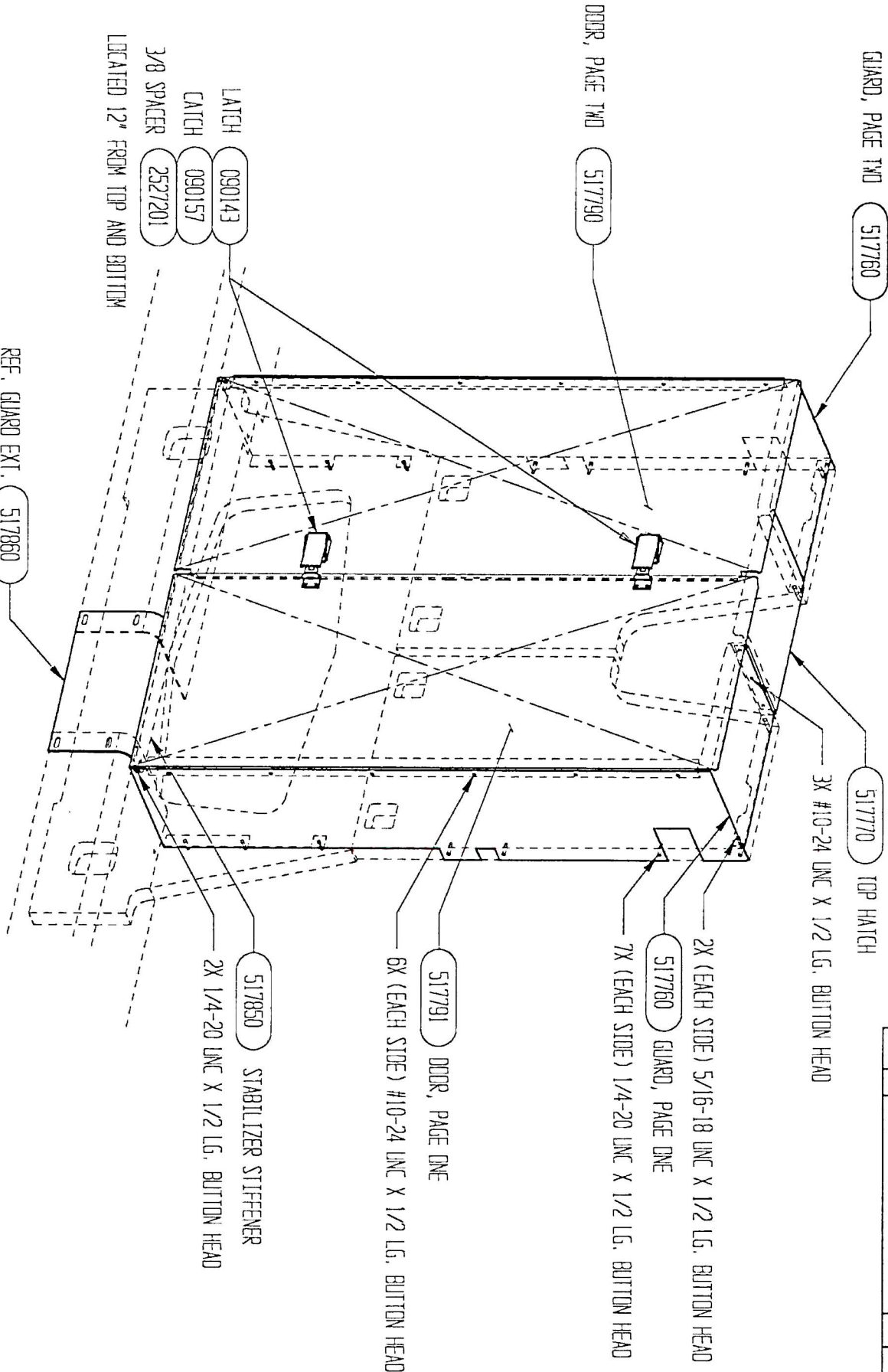
823001MGEAR
SCALE XXXXX
DATE 4-10-03
SIZE B
REV - A

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Guards

DATE	SYN	REVISION RECORD	GR	CK



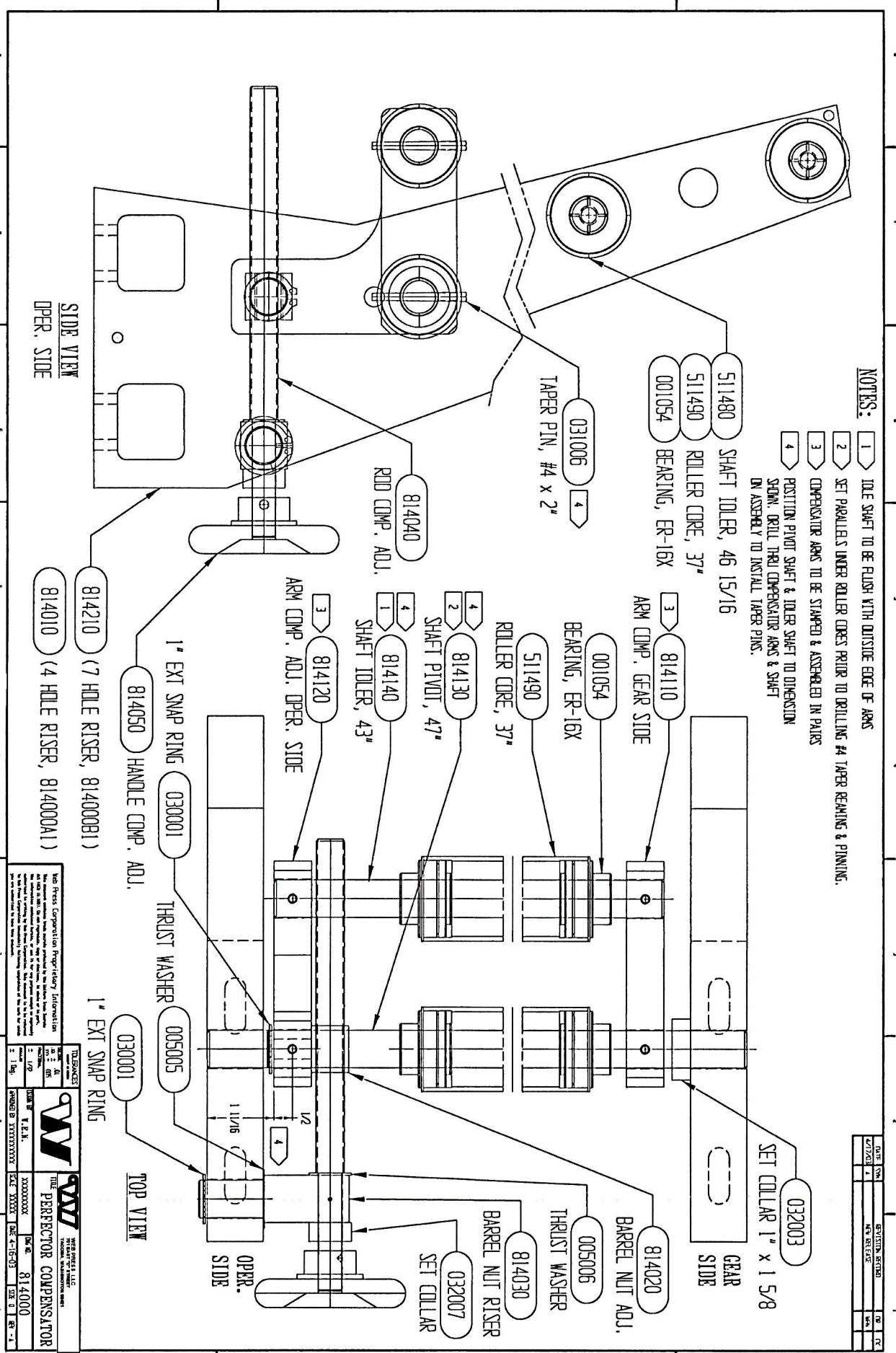
REF. GUARD EXT. 517860
SEE CONN. PARTS
W.L. UNITS, 54 SERIES ONLY

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DECIMAL XX ± .015	FRACTIONAL XX ± .005		
DIMENSIONS UNLESS OTHERWISE SPECIFIED		DRAWN BY: M.E.N.	TITLE: GUARDS, G.S., W.L.
APPROVED BY: XXXXXXXXXXXXX		SCALE: XXXXX	REF. 54 SERIES Dwg No. 517001C
DATE: 12-7-99		SHEET: B	DATE: 12-7-99



Perfector Compensator Assembly



NOTES:

- 1 IDE SHAFT TO BE FLUSH WITH OUTSIDE EDGE OF ARMS
- 2 SET PARALLEL UNDER ROLLER CORES PRIOR TO DRILLING #4 TAPER BEARING & PINNING.
- 3 COMPENSATOR ARMS TO BE STAMPED & ASSEMBLED IN PAIRS
- 4 POSITION PIVOT SHAFT & IDLER SHAFT TO DIMENSION
SHOW: DRILL THRU COMPENSATOR ARMS & SHAFT
ON ASSEMBLY TO INSTALL TAPER PINS.

DATE	BY	DESCRIPTION	REV
2/17/23	J	REV RELEASE	1

THE PERCEPTOR COMPENSATOR

Part No. 814000

REV. 1

DATE: 4-16-03

DESIGNED BY: JYK/XXX

DRAWN BY: JYK/XXX

Checked by: JYK/XXX

Approved by: JYK/XXX

THE PERCEPTOR COMPENSATOR

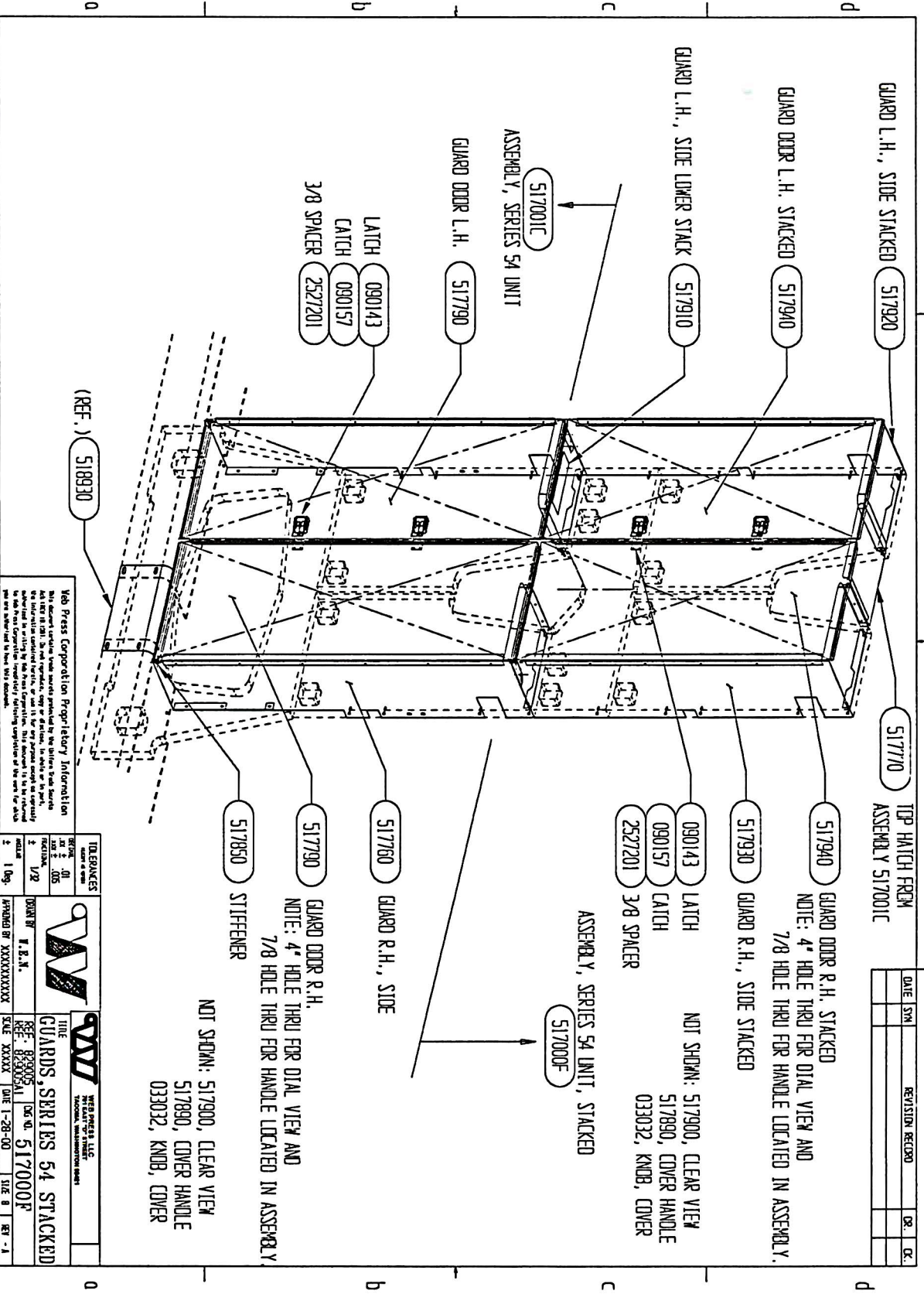
PERCEPTOR COMPENSATOR

PERCEPTOR COMPENSATOR

PERCEPTOR COMPENSATOR



Stacked Unit



DATE	SW	REVISION RECORD	OR	CR.

TOP HATCH FROM
ASSEMBLY 517001C

GUARD L.H., SIDE STACKED 517920

GUARD DOOR L.H. STACKED 517940

GUARD L.H., SIDE LOWER STACK 517910

ASSEMBLY, SERIES 54 UNIT
517001C

GUARD DOOR L.H. 517790

LATCH 090143
CATCH 090157
3/8 SPACER 2527201

(REF.) 518930

517770

TOP HATCH FROM
ASSEMBLY 517001C

GUARD DOOR R.H. STACKED

NOTE: 4" HOLE THRU FOR DIAL VIEW AND
7/8 HOLE THRU FOR HANDLE LOCATED IN ASSEMBLY.

517940 GUARD DOOR R.H. STACKED

517930 GUARD R.H., SIDE STACKED

090143 LATCH
090157 CATCH
2527201 3/8 SPACER

ASSEMBLY, SERIES 54 UNIT, STACKED

517000F

517760 GUARD R.H., SIDE

517790 GUARD DOOR R.H.

NOTE: 4" HOLE THRU FOR DIAL VIEW AND
7/8 HOLE THRU FOR HANDLE LOCATED IN ASSEMBLY.

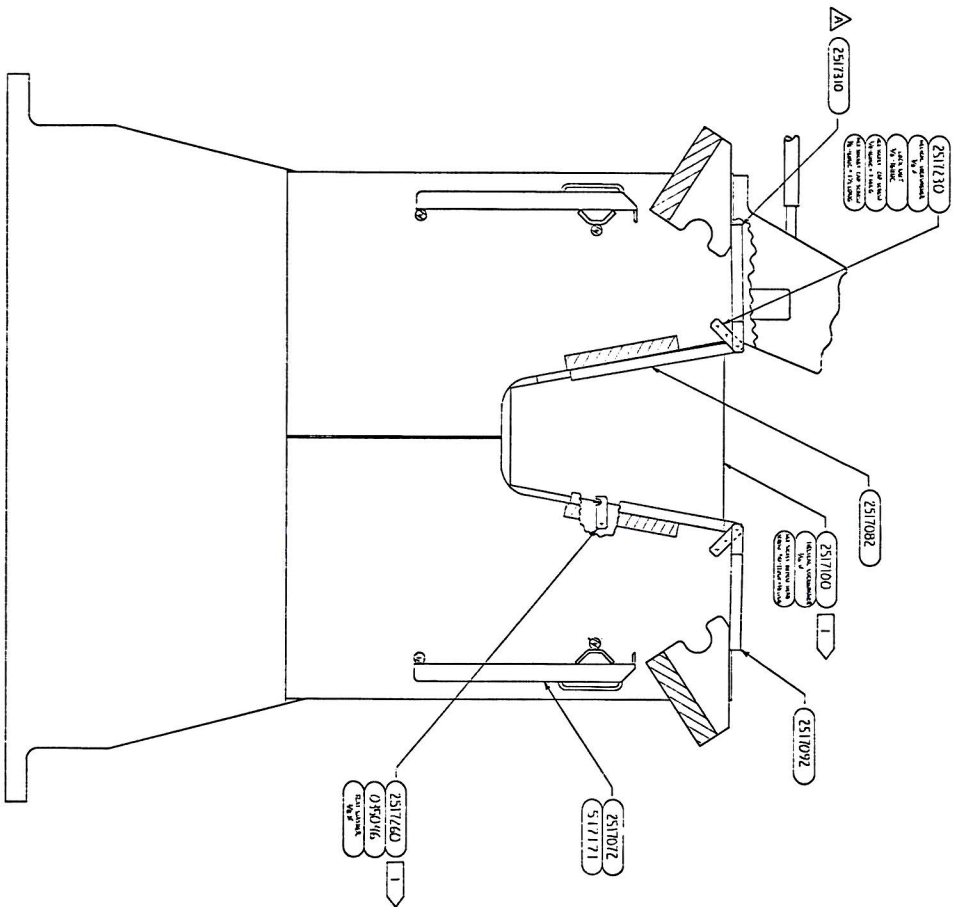
517850 STIFFENER

NOT SHOWN: 517900, CLEAR VIEW
517890, COVER HANDLE
033032, KNOB, COVER

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IDT SPACES			WEB PRESS, LLC 201 EAST 10 TH STREET TOWSON, MARYLAND 21286
DATE	BY		
1/2	1/2	TITLE GUARDS, SERIES 54 STACKED	
1/2	1/2	REF: 83002511, 036, 517000F	
1/2	1/2	SCALE: XXXXX	
1/2	1/2	DATE: 1-28-00	
1/2	1/2	SHEET: 8	
1/2	1/2	TOTAL: 8	

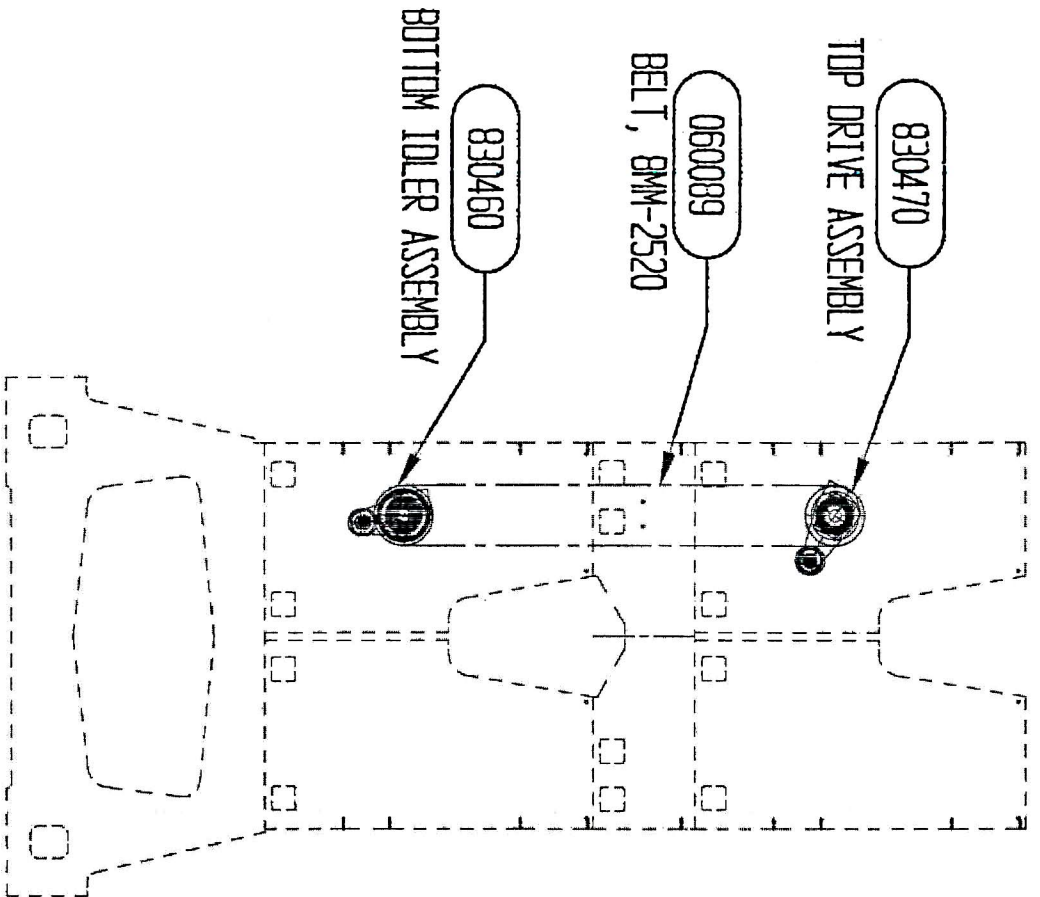
1 CENTER GUARD, LOCATE LATCH AND MATCH DRILL PWERD HOLES IN SIDE PLATE.



REV	DATE	DESCRIPTION
1	10/15/01	INITIAL RELEASE
2	10/15/01	REVISION

HP INC. NATIONAL HEADQUARTERS 3000 AVENUE OF THE SCIENCE FORT LEE, NJ 07024-4100	
PRODUCT NAME 251700C/12	PART NUMBER 251700C/12
MANUFACTURED IN CHINA	DRAWN BY JH
CHECKED BY JH	DATE 10/15/01

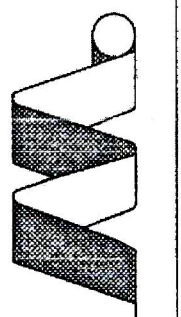
DATE	SYM	REVISION RECORD	DR.	CK



REF. MECH. MOTION ASSEMBLY 823001
 REF. GUARD ASSEMBLY 517000F & 517001C

TOLERANCES
(EXCEPT AS NOTED)

DECIMAL	.XX ±
FRACTIONAL	.XXX ±
ANGULAR	±



DRAWN BY
W.E.N.

APPROVED BY XXXXXXXXXXXXX



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

TITLE
BELT DRIVE, 54 SERIES

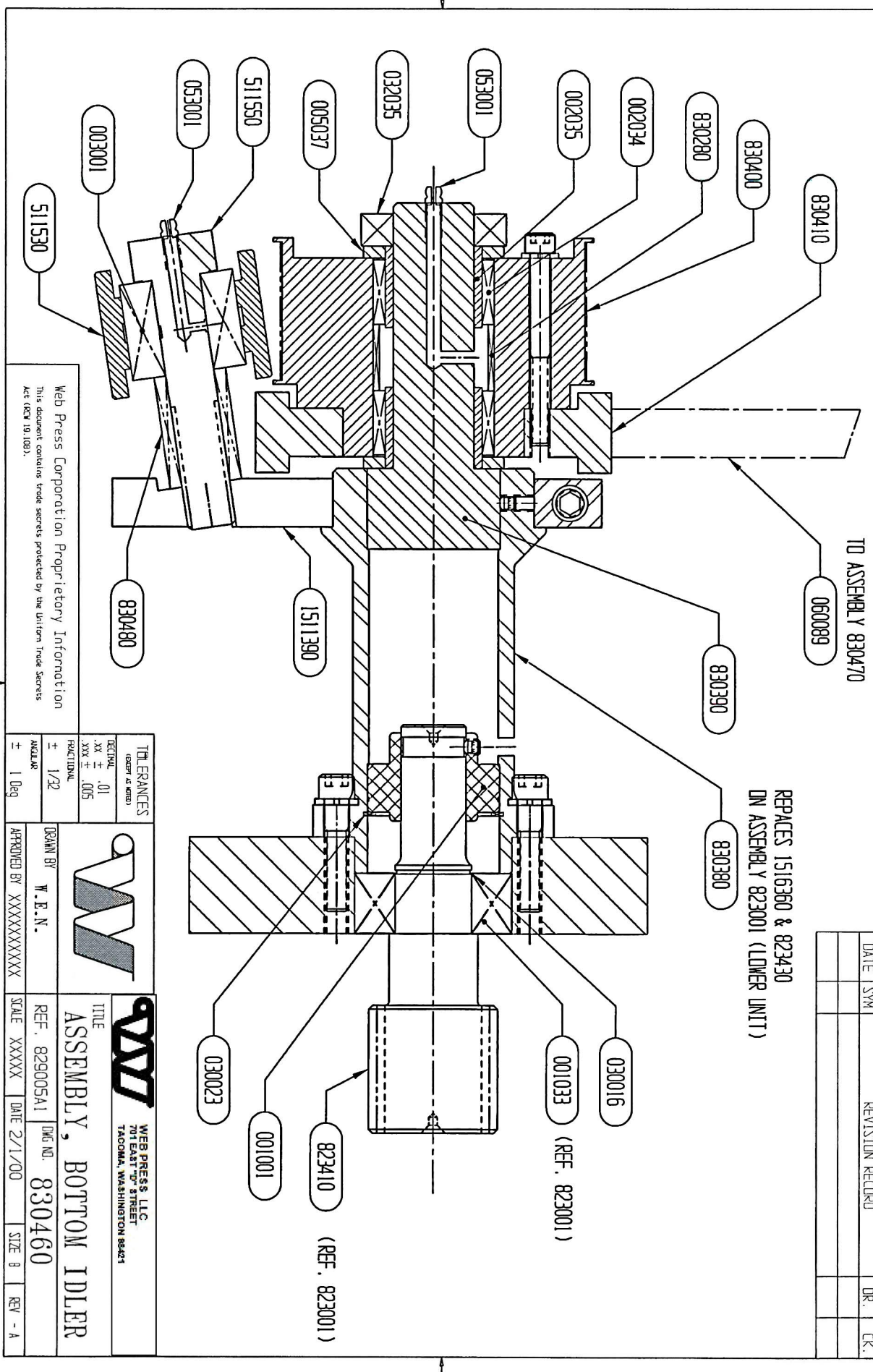
SHT. 2, D-SIZE DWG NO. **829005A1** SHT 1 OF 2

SCALE XXXXX DATE 2-3-00 SIZE A REV - A

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DATE	SYM	REVISION RECORD	DR.	CK.

REPLACES 1516360 & 823430
 DN ASSEMBLY 823001 (LOWER UNIT)



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TOLERANCES (EXCEPT AS NOTED)	DETAIL ± .01		TITLE ASSEMBLY, BOTTOM IDLER
FUNCTIONAL	.XXX ± .05		
ANGULAR	± 1/32	DESIGN BY W. D. N.	WEB PRESS, LLC 701 EAST 7TH STREET TACOMA, WASHINGTON 98421
± 1 Deg	APPROVED BY XXXXXXXXXXXXX	REF. 829005A1	
		SCALE XXXXX	DATE 2/1/00
		SIZE 8	REV - A

DATE	BY	REVISION	RECORD	DR	CR
3/21/02	B	WAS TAPER BUSH	062060, SIS 1 1/8	WEN	

(REF. 823001)

001033

REPLACES 823410 DN ASSEMBLY 823001

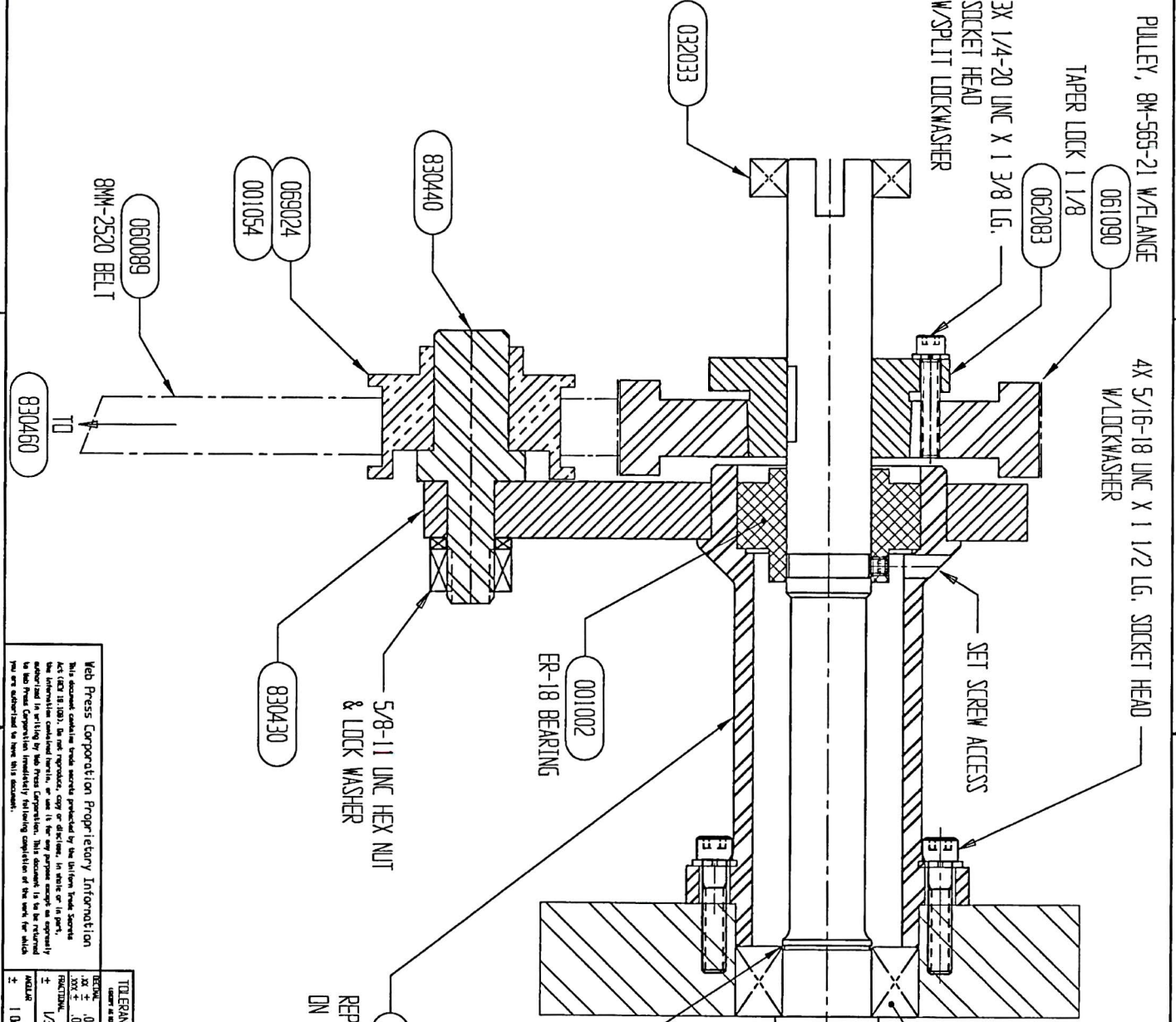
830450

SNAP RING, 1 3/16 EXT.

030016

REPLACES 1516360 & 823430 DN ASSEMBLY 823001 (TOP UNIT)

830370



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TOLERANCES			
FINISH	ASSEMBLY		
± .01	± .005	TOP DRIVE ASSEMBLY REF. B29005A1 DWG NO. 830470 SH. 3 OF 3	WEB PRESS, LLC 701 EAST 7 TH STREET TACOMA, WASHINGTON 98401
± .005	± .002		
± .002	± .001	DRAWN BY: V.B.N. APPROVED BY: XXXXXXXXXXXX	DATE: 1-31-00 SIZE: 8 REV: 8

8MM-2520 BELT

060089

069024

001054

830440

060089

830460

001002

830430

001033

830450

030016

830370