

REVISION	NAME-DATE
A	9409-3 W/9409-2, ADD(2)225-0082-07-00 L REOK 10/13/2011

VOLTAGE OPTION						
-10	208/3/60	802	2	514456	SPROCKET 60B24 X 2 W/KEYWAY &	EA
		801	1	E-208360-7.5C-1640	ELECTRICS,1640,7 1/2HP,208/3/60,C	EA
		800	REF	501427	MOTOR,7 1/2HP,208-460/3/60,213TC,	EA
-11	230/3/60	802	2	514456	SPROCKET 60B24 X 2 W/KEYWAY &	EA
		801	1	E-230360-7.5C-1640	ELECTRICS,1640,7 1/2HP,230/3/60,C	EA
		800	REF	501427	MOTOR,7 1/2HP,208-460/3/60,213TC,	EA
-12	460/3/60	802	2	514456	SPROCKET 60B24 X 2 W/KEYWAY &	EA
		801	1	E-460360-7.5C-1640	ELECTRICS,1640,7 1/2HP,460/3/60,C	EA
		800	REF	501427	MOTOR,7 1/2HP,208-460/3/60,213TC,	EA
-13	575/3/60	802	2	514456	SPROCKET 60B24 X 2 W/KEYWAY &	EA
		801	1	E-575360-7.5C-1640	ELECTRICS,1640,7 1/2HP,575/3/60,C	EA
		800	REF	501430	MOTOR,7 1/2HP,575/3/60,TEFC,C213T	EA
-14	380/3/50 415/3/50	802	2	514084-1	SPROCKET - 60B28 2.00 BORE 1/2	EA
		801	1	E-380415350-7.5C-1640	ELECTRICS,1640,7 1/2HP,380-415/3/	EA
		800	REF	501427-1	MOTOR,7 1/2HP,190-380/3/50,213TC,	EA

65	32	571008	SPRING, DISC, ROLEX Z16	EA
64	2	514201	SPROCKET - 60B18 X 1 1/2 (3/8	EA
63	16	513095	1-1/4 END CAP WASHER (1/2" CTR	EA
62	4	511129	STEEL THRUST WASHER TRD2031	EA
61	16	511195	1 1/4 END CAP WASHER	EA
60	3	511147	1 1/4 CAM FOLLOWER W/STUD (IKO	EA
59	68	511138	1 1/2 END CAP WASHER	EA
58	64	511125	BRONZE THRUST WASHER	EA
57	64	511121	NEEDLE BEARING	EA
56	32	511110-H	INNER RACE - HONED (1.25 X 1.2	EA
55	26	511108	STEEL THRUST WASHER - TRB2031	EA
54	32	511098-H	INNER RACE - HONED (1.25 X 1)	EA
53	14	511076-H	INNER RACE - HONED (1 X 1.25)	EA
52	1	511055	NICE BEARING - 1606DS	EA
51	4	511038-1	B4416-OH BEARING W/OIL HOLE	EA
50	4	511037	INNER RACE	EA
49	2	511019-H	INNER RACE - HONED (1 X 1)	EA
48	16	511018-1	BEARING WITH OIL HOLE	EA
47	1	501432	LEESON 516 QUILL MNT.REDUCER,3	EA
46	1	4679-3	END CAP WASHER W/ COUNTERSUNK	EA
45	3	4529	SIDE ROLL MOUNT SHAFT	EA
44	2	4528	GUIDE ROLL / SIDE ROLL	EA
43	2	4494-1	THRUST BEARING-MOV	EA
42	10	4494	THRUST BEARING-MOV	EA
41	2	4491	SPUR GEAR - SPLINED	EA
40	16	4235	LANCER KNIFE	EA
39	4	4219-19	END CAP WASHER	EA
38	1	4207	ADJUSTING KNOB	EA
37	1	4206-2	ECCENTRIC SHAFT	EA
36	2	4172	BOTTOM SPREADER BAR	EA
35	61	4171	#11 WOODRUFF KEY 3/16, GROUND	EA
34	32	4170	#808 WOODRUFF KEY 1/4, GROUND	EA
33	16	4167-10	POST,SPNDL HSN6,1/2-20 THD,7.5	EA
32	1	4165-5	GREASE BOLT, 3/8-24 X 1 1/4 LG	EA
31	13	4165-1	GREASE BOLT **** (3/8-24 X 3/	EA
30	16	4156-8	BOTTOM SPINDLE GEAR - 1 1/4 *	EA
29	4	4033	CAP RING MOVEABLE	EA
28	4	4032	SPLINE COLLAR	EA
27	2	4031	SPACER RACE SUPPORT	EA
26	2	4030-2	SPACER SPLINE SHAFT MOV HEAD	EA
25	6	225-0082-07-00	ROLL FINNED CUSHION 4.0000	EA
24	1	602-8792-01-00	SIDE ROLL BRACKET WELD #9	EA
23	1	11907	FRAME ASSEMBLY 1640 ROLL MACHI	EA
22				
21	1	11899-1	BTM SPNDL HSN6 NON-GEAR SIDE-	EA
20	1	11899	PLATE,BTM SPNDL HSN6 GEAR SIDE	EA
19	1	11847	TIE PLATE - HB-1640 (NEW STYLE	EA
18	2	11846	CROSS BAR - INFEEED/OUTFEED TAB	EA
17	2	11844	CLAMPING BAR	EA
16	1	11843	INFEEED GUIDE-1246/HB1640	EA
15	4	11841	TIE PLATE SPACER- HB-1640 & HB	EA
14	1	11795	SLIDE GUIDE MOUNT - 1246 SPECI	EA
13	1	11794	SLIDE GUIDE - 1246 SPECIAL	EA
12				
11	1	11718	PLATE,REDUCER MNT(325/450/516)	EA
10	2	11716	LOWER TRANSFER BEARING BLOCK	EA
9	4	11715	TRANSFER IDLER GEAR SPACER	EA
8	2	11714	TRANSFER IDLER SHAFT	EA
7	2	11713	GROB SPLINE SHAFT 15 3/16 LG	EA
6	2	11712-1	TRANSFER IDLER SPUR GEAR	EA
5	12	11712	IDLER SPUR GEAR	EA
4	16	11711	UPPER SPUR GEAR	EA
3	1	11651-4	MOUNT BAR FOR GUARD	EA
2	16	1075934-11	SPACER 3/4ID X 1-1/4OD X 1-5/8	EA
1	1	050-0035-01-00	CHAIN, ROLLER 60 STANDARD	EA
A	6	ST-TR-00500020	THREADED ROD 1/2-20UNF	2.50

WITH OUTBOARD 16 GA PITTSBURGH ROLLS MR-PL-16-16				
840	16	9251-2	OUTBOARD SPACER SUPPORT	EA
839	1	T5192-99	16GA. PITTS. ROLLS 1640/1240T	EA
838	16	9307-2	SPACER-3 OUTBOARD 1640	EA
837	1	613-0045-01-00	GUIDE SUPPORT CHANNEL	EA
836	4	511138	1 1/2 END CAP WASHER	EA
835	1	11847	TIE PLATE - HB-1640 (NEW STYLE	EA
834	1	11844	CLAMPING BAR	EA
833	1	11843	INFEEED GUIDE-1246/HB1640	EA
832	4	11841	TIE PLATE SPACER- HB-1640 & HB	EA
831	1	1086934	STRAIGHTENER ASSY (1246 & 1640	EA

WITHOUT OUTBOARD 16 GA PITTSBURGH ROLLS				
830	32	9307-2	SPACER-3 OUTBOARD 1640	EA

WITH INBOARD CLIP ROLLS MR-TDA-1B				
826	10	602-8766-01-00	ROLL SPACER 3.40 LG	EA
825	22	602-8765-01-00	ROLL SPACER 3.50 LG	EA
824	16	602-8764-02-00	ROLL SPACER 2.125 LG.	EA
823	16	602-8764-01-00	ROLL SPACER 2.75 LG	EA
822	1	T6251	ROLL SET-ALTERNATE TDF CLIP	EA
821	1	9429-1	THIN INFEEED GUIDE	EA
820	1	11874	OUTFEED GUIDE BAR - CLIP ROLLS	EA
819	1	11873	OUTFEED GUIDE BASE - CLIP ROLL	EA
818	2	11844-1	CLAMPING BAR FOR CLIP STICHER	EA
817	2	11844	CLAMPING BAR	EA
816	2	11843	INFEEED GUIDE-1246/HB1640	EA
815	1	593295	INFEEED GUIDE DEFLECTOR,HB1246-	EA
812	1	592977	LC BENT INFEEED TABLE ***	EA
811	1	593293	GUARD,OUTFD.FNGR,HB1246 W/CLIP	EA
810	1	593291	GUARD, INFEEED FINGER,HB1246 W/	EA

WITHOUT INBOARD CLIP ROLLS				
814	16	11901	SPNDL SPCR 1 1/4 BORE 3.687 LG	EA
813	48	11720	INBOARD SPACER	EA
812	1	592824	LC BENT INFEEED & OUTFEED STD.T	EA
811	1	593321	GUARD,OUTFEED FINGER FOR STD.H	EA
810	1	593290	GUARD, INFEEED FINGER FOR HB124	EA

95	2	9853	MOUNT BRACKET OUTG	EA
94	8	9821	UPPER BEARING CAGE 1640U ROLL	EA
93	1	9771	STA. 12.5 ADJ. BRKT. WELDMENT	EA
92	12	9512	IDLER SHAFT	EA
91	3	9453	SPINDLE-ROLLER DIE	EA
90	29	9452	SPINDLE-ROLLER DIE	EA
89	1	9429-1	THIN INFEEED GUIDE	EA
88	1	9413-3	SLIDE GUIDE BAR	EA
87	1	9409-3	STILSON ROLL SIDE, LONG	EA
86	1	9408-2	OUTGUIDE HELPER BLOCK	EA
85	2	9397	SIDE ROLL BRK WELD/MT. 15&16	EA
84				
83	2	9251-5	SPACER	EA
82	1	9049	OUTGUIDE ROLLER - 1640 TDF	EA
81	2	7098-9	SPACER,1.5ID,3/8K,2"OD X .75 L	EA
80	2	7098-6	SPACER,1.5ID,3/8K,2"OD X .25 L	EA
79	1	613-0045-01-00	GUIDE SUPPORT CHANNEL	EA
78	1	612-0240-01-00	EXIT STRAIGHTENER WHEEL MOUNT	EA
77	1	612-0239-01-00	EXIT STRAIGHTENER VERTICAL SUP	EA
76	1	612-0238-01-00	TOP BAR STRAIGHTENING ROLL MT	EA
75	1	612-0237-01-00	SMALL PART FEEDER WELDMENT	EA
74	1	602-8761-01-00	SHAFT GUARD HB-1640-WT	EA
73	1	5941-18	SIDE ROLL STA. #16	EA
72	1	5941	DUCT SNAPFLANGE ROLLS -NO KNUR	EA
71	1	593320	GUARD DEFLECTR,INFEEED FINGER,H	EA
70	1	593219	CHAIN GUARD FOR HB-1640-WT	EA
69	1	593217	HOOD FOR STD. HB-1640-WT	EA
68	2	593025	LC,STILSON ROLL BRKT. (COMP.W/	EA
67	1	592824	LC BENT INFEEED & OUTFEED STD.T	EA
66	16	572153	CRS STUD	EA

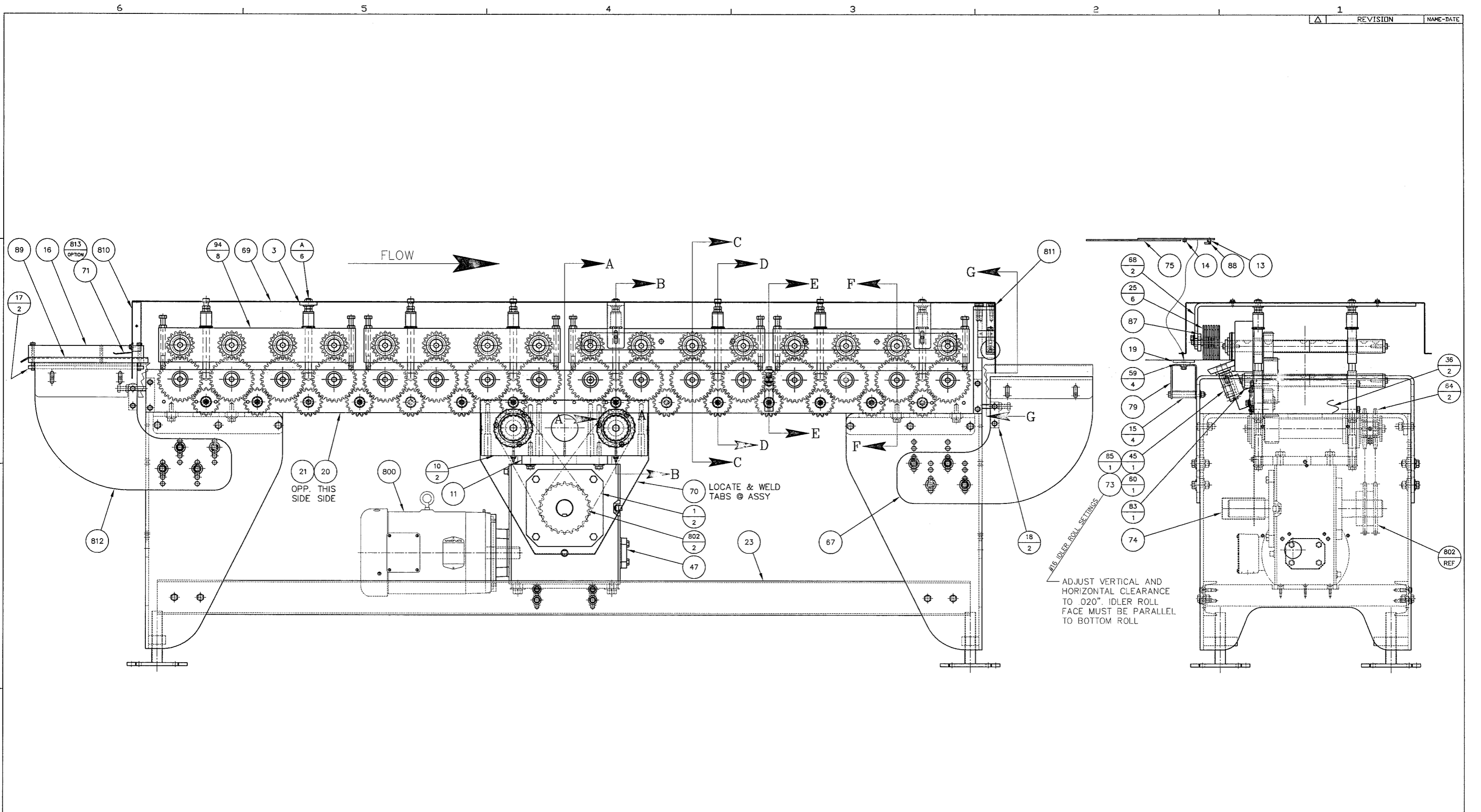
THIS MACHINE COMES WITH THE TDF ROLL SET AS STANDARD.  
IT WILL MOUNT ON THE RH OUTBOARD LOCATION AS STANDARD.

(1) INBOARD & (1) OUTBOARD POSITION

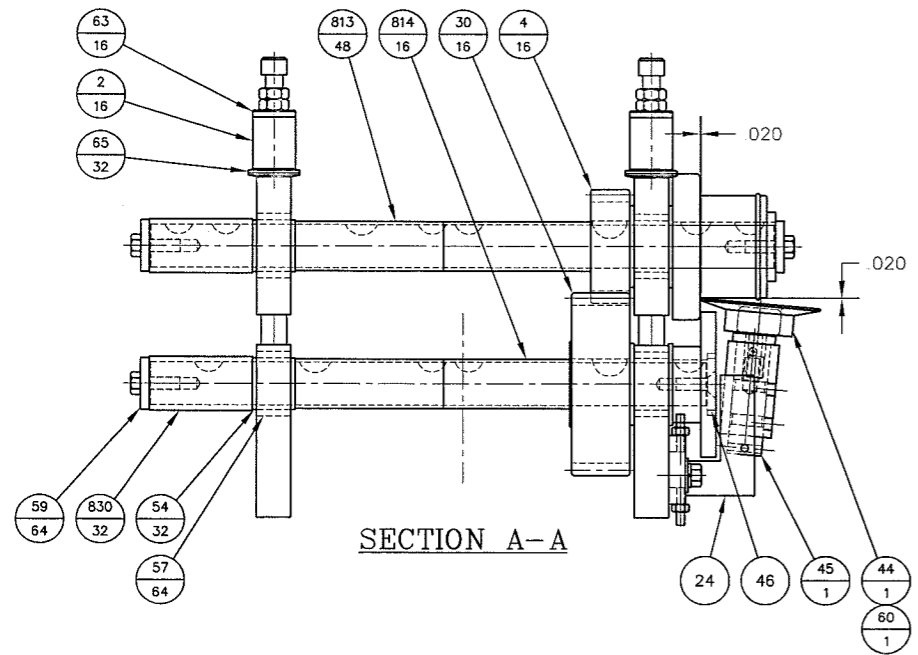
60 FPM

DO NOT SCALE	ITEM	QTY	STOCK NO.	DESCRIPTION	QTY EACH
TOLERANCES SPECIFIED BY DECIMAL PLACES	Cedar Rapids, Iowa 52404				TITLE
.0 ±.050	MESTEK MACHINERY				FINAL ASSY - HB-1640
.00 ±.025	© 2010				
.000 ±.005	DRAWN BY	DATE	SCALE	DECIDED BY	
ANGLES ±.5°	T COON	08/18/2011	-		
	NEXT REVISION NO.	QTY	TEMPLATE NO.	NO.	
	11824	1	-	-	

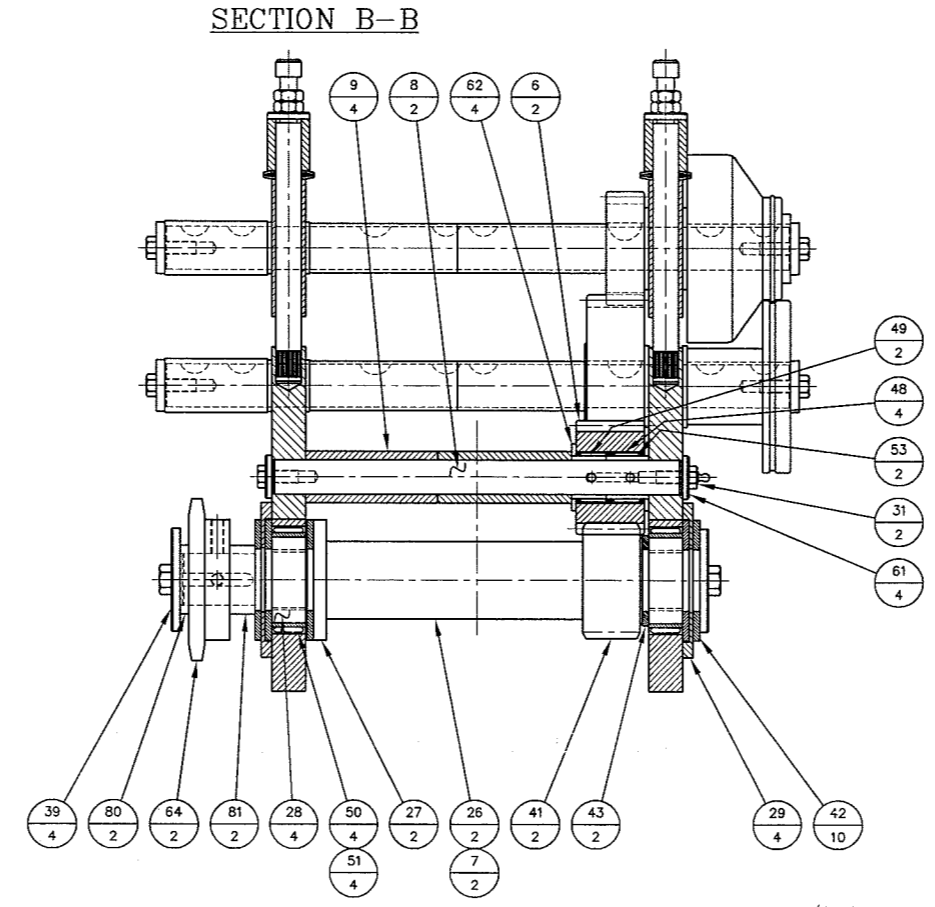
11824 SHEET 1 OF 3



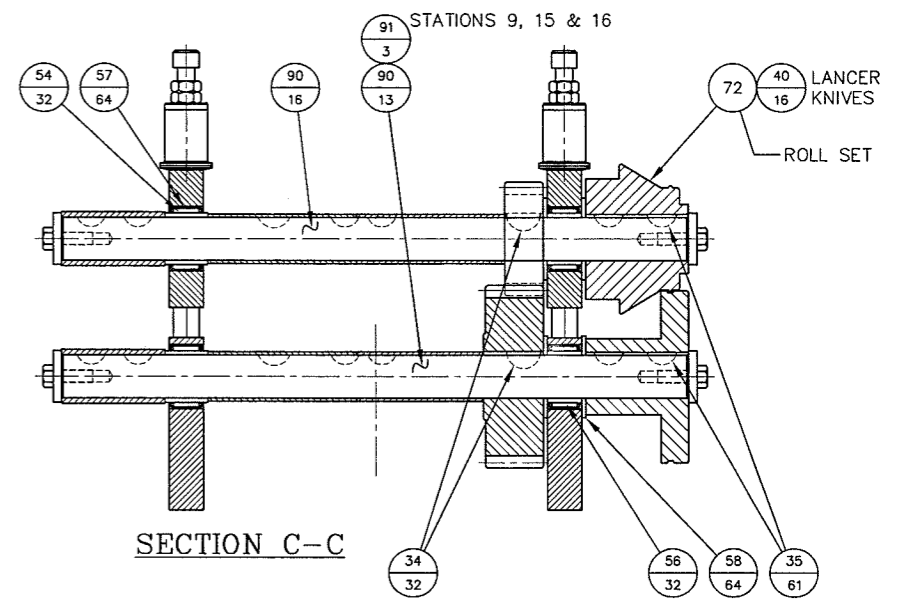
DO NOT SCALE	ITEM	ITEM QTY	STOCK NO.	DESCRIPTION	QTY EACH
TOLERANCES SPECIFIED BY DECIMAL PLACES	MESTEK MACHINERY			Cedar Rapids, Iowa 52404	TITLE
.0 ±.050*				© 2010	FINAL ASSY - HB-1640
.00 ±.025*	DRAWN BY	DATE	SCALE	CHECKED BY	SHEET 2 OF 3
.000 ±.005*	T COON	10/26/2011	-		
ANGLES ±.5°	NEXT HIGHER USAGE NO.	QTY	TEMPLATE NO/VERSION NO.		
	11824	1	-		11824



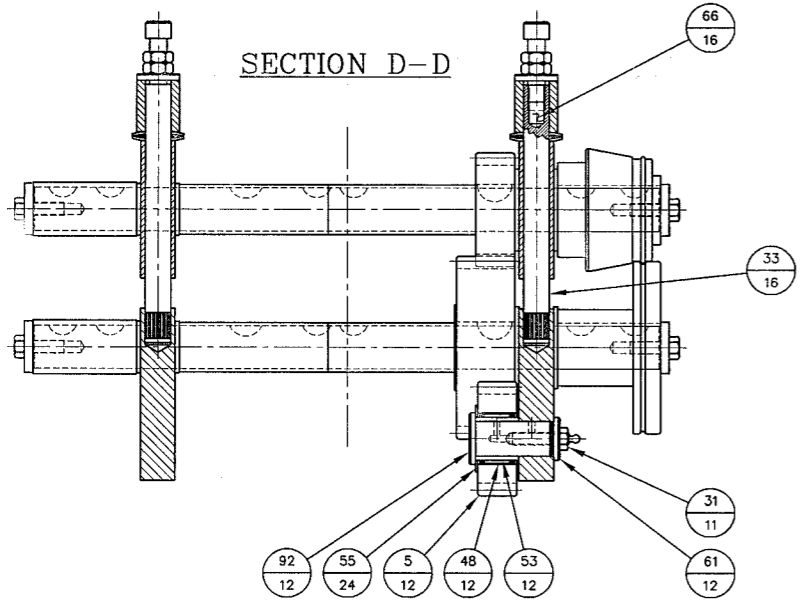
SECTION A-A



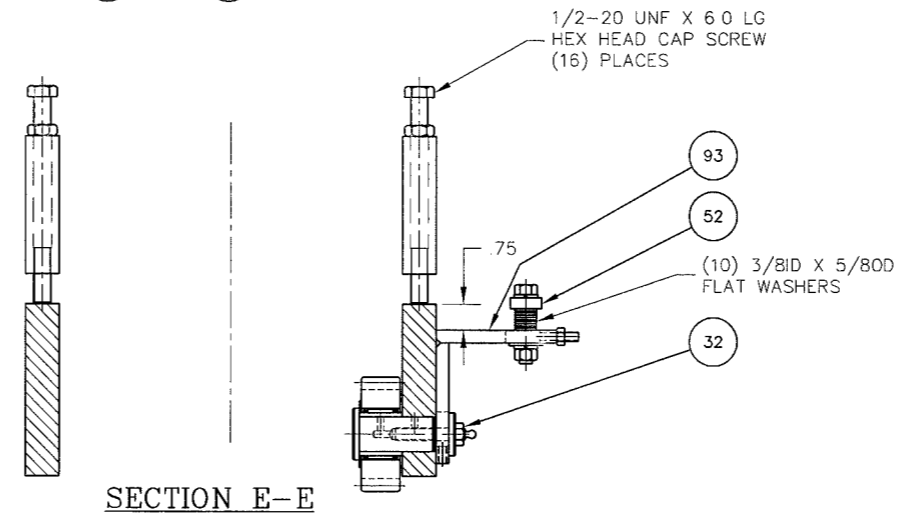
SECTION B-B



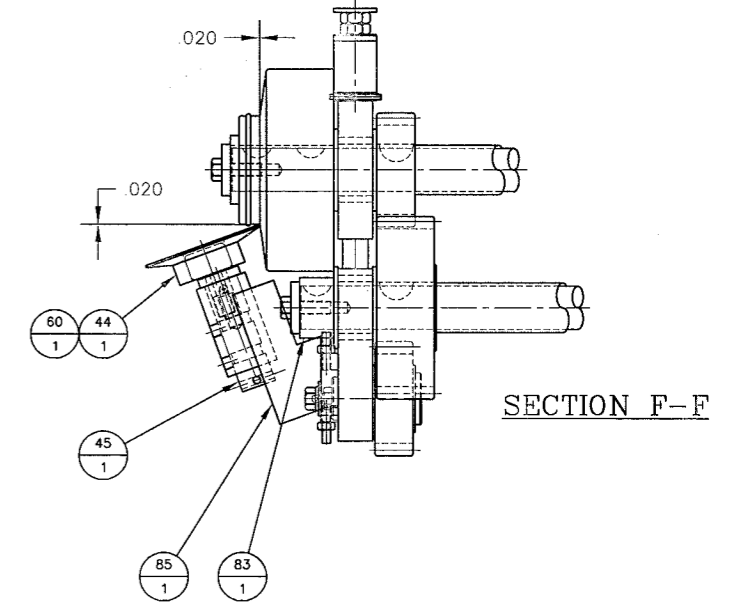
SECTION C-C



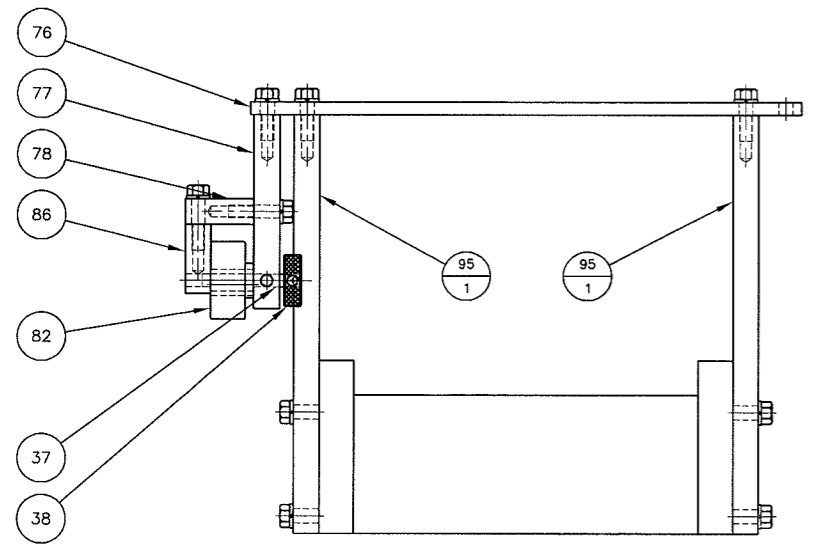
SECTION D-D



SECTION E-E



SECTION F-F



SECTION G-G

DO NOT SCALE	ITEM	ITEM QTY	STOCK NO.	DESCRIPTION	QTY EACH
TOLERANCES SPECIFIED BY DECIMAL PLACES		Cedar Rapids, Iowa 52404			
.0	±.050	MESTEK MACHINERY		TITLE	FINAL ASSY - HB-1640
.00	±.025	DATE 08/18/2011		SCALE	CHECKED BY
.000	±.005	DRAWN BY T COON		11824	SHEET 3 OF 3
ANGLES	±.5°	NEXT NUMBER USAGE NO. 11824		QTY 1	REPLATE NO/FITTING NO. -