
ASTRO



**FF-14NW
and
FF-14NEW
Friction Feeder**

Parts Manual

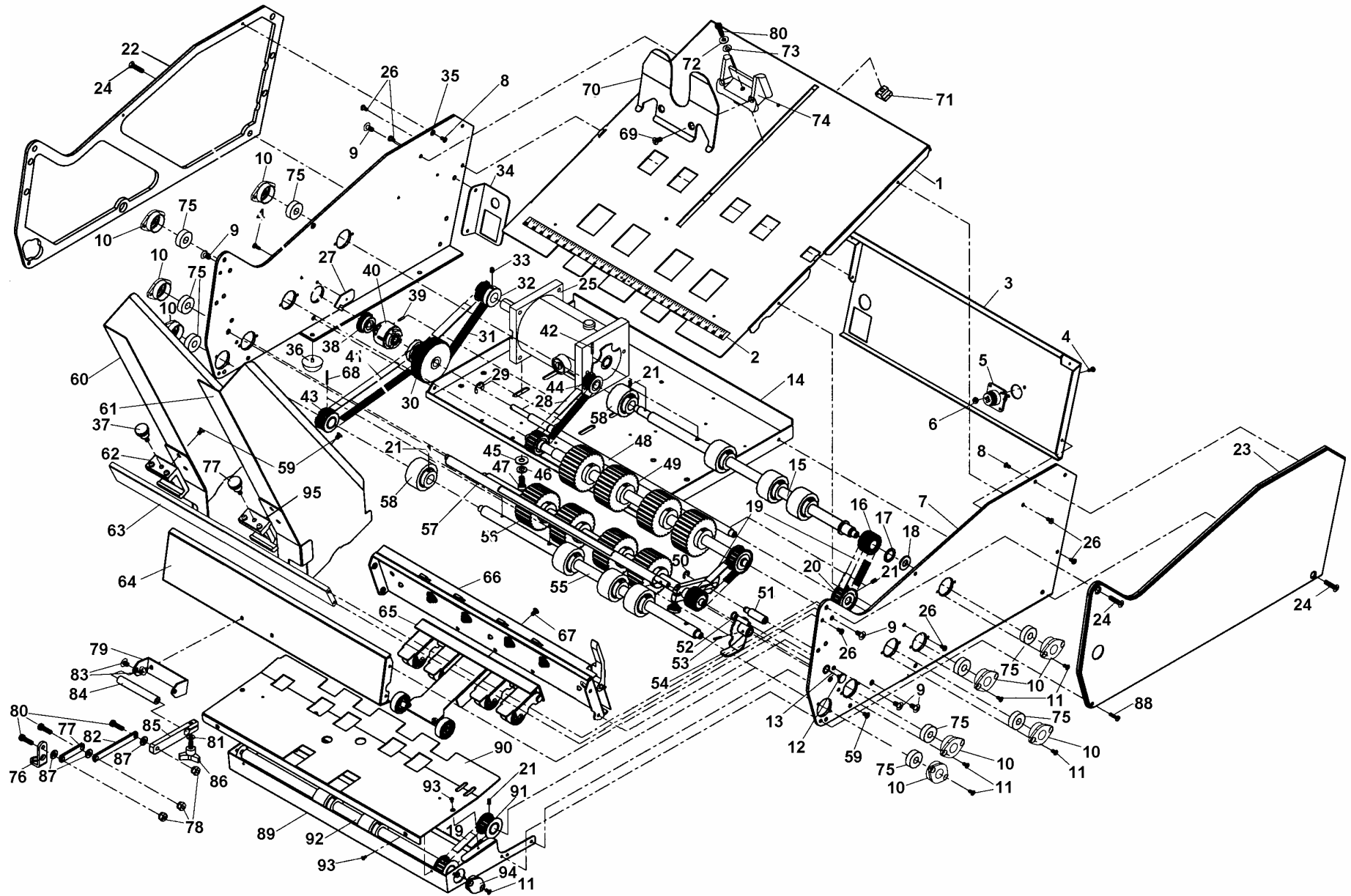
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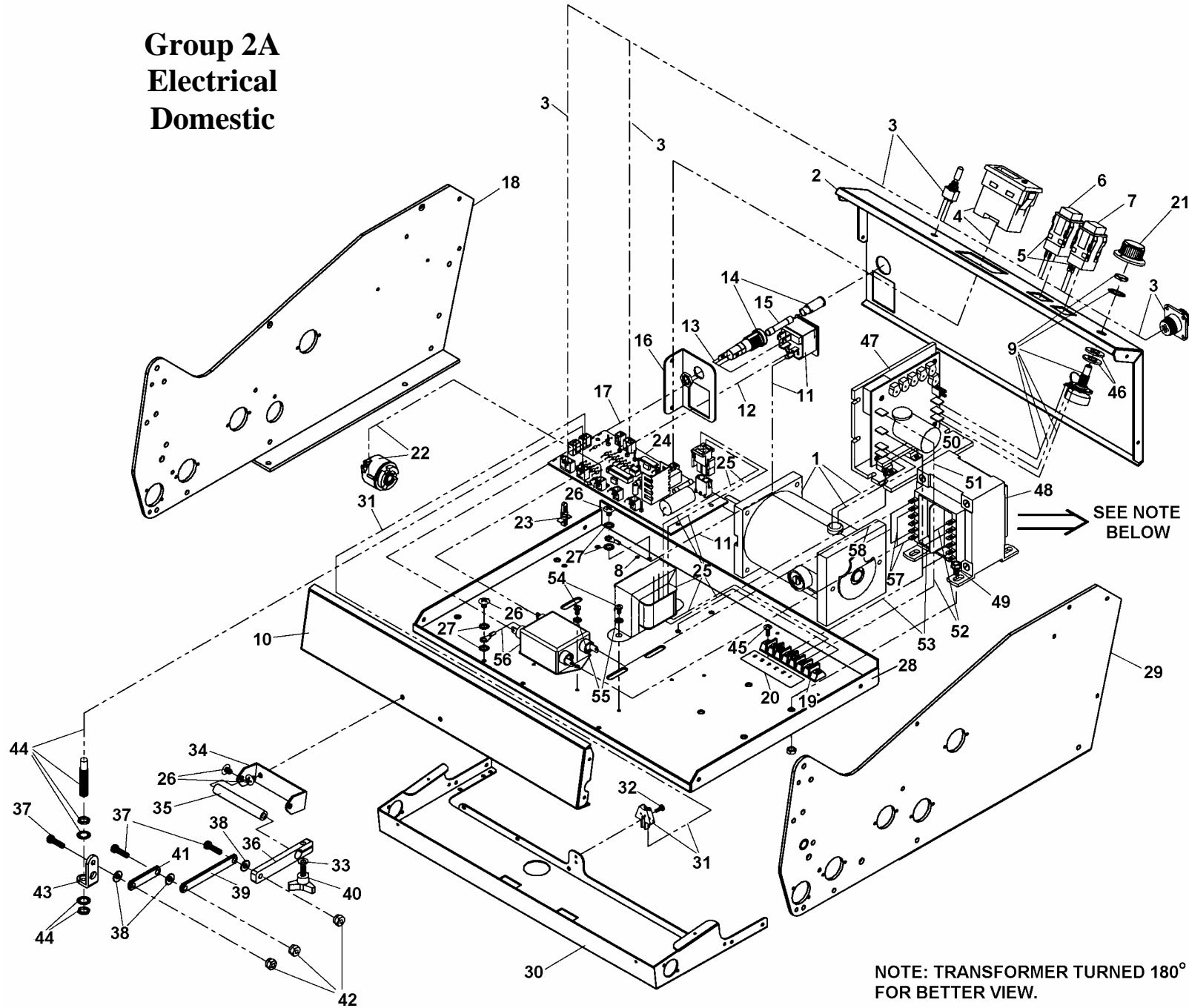
Group 1 Mechanical



Group 1 - Mechanical

KEY	PART #	DESCRIPTION	QTY	KEY	PART #	DESCRIPTION	QTY.
1.	24-100-07	WELDMNT, CENTER PLATE	1	49.	24-103-00	ASSY., MIDDLE FEED SHAFT	1
2.	63-100-102	SCALE GUIDE	1	50.	123-0081	TRUARC, #5133-25	1
3.	24-150-16	REAR CLOSURE	1	51.	65-300-43	STUD, BRAKE	1
4.	123-1023	SCREW, 4-40x5/16 PANHEAD PH	3	52.	24-100-30	PIN	1
5.	123-0654	RECEPTACLE, CIRCULAR	1	53.	123-0695	SPRING PIN, 3/32x1/2	1
6.	123-0425	NUT, HEX 4-40	2	54.	24-100-33	ADJUSTMENT LEVER	1
7.	24-150-04	OPERATOR SIDE FRAME, WELDMNT	1	55.	24-105-02	PULL OUT FEED SHAFT	1
8.	123-1178	SCREW, 6-32x1/4 FL HD UNDRCT	4	56.	24-104-00	ASSY., FRONT FEED SHAFT	1
9.	123-0024	SCREW, 10-32x3/8 PHILLIPS TRUSS HD.	11	57.	24-100-35	ADJUSTMENT SHAFT	1
10.	99-100-99	BALL BEARING HOUSING	9	58.	56-101-17	ASSY., RUBBER FEED ROLLER	8
11.	123-0275	SCREW, 6-32x1/4 PHILLIPS OVAL CSK HD.	22	59.	123-0126	SCREW, 8-32x1/4 PH MS SS UNDRCT	8
12.	24-100-31	SCREW	1	60.	24-101-01	L/H SIDE GUIDE	1
13.	84-120-26A	SPRING, UPO ROLLER (#1 OF 2)	1	61.	24-101-06	R/H SIDE GUIDE	1
14.	24-150-10	MOTOR BASE	1	62.	24-101-09	R/H SIDE GUIDE BLOCK SUBASSY.	1
15.	24-102-01	REAR FEED SHAFT WITH INNER RACE	1	63.	65-302-10	SUPPORT	1
16.	94-105-04	PULLEY ASSY., 16 GROOVES	1	64.	24-150-20	FRONT COVER	1
17.	63-105-15	WASHER, .505ID, .703OD, .030 THICK	1	65.	24-115-10	ARM GUIDE ASSY.	1
18.	24-102-06	WASHER	1	66.	24-150-39	METERING PLATE ASSY.	1
19.	123-0934	BELT, 90XLO31	3	67.	123-1205	SCREW, 8-32x1/4 BTN HD SOC CAP	3
20.	123-0991	PULLEY, 16XLO37	1	68.	123-0487	SCREW, 6-32x1/2 PHILLIPS PAN HD. BLK	1
21.	123-0322	SET SCREW, 8-32x1/4	10	69.	123-0002	SCREW, 10-32x3/8 PH UNDERCUT SS	2
22.	24-150-49	NON-OPERATOR SIDE FRAME COVER, WELDMNT	1	70.	21-100-33	MEDIA SUPPORT	1
23.	24-150-48	OPERATOR SIDE FRAME COVER, WELDMNT	1	71.	21-100-32	SLIDER	1
24.	123-0531	SCREW, 10-32x3/4 FL HD PH	4	72.	123-0148	WASHER, 7/16OD X .200ID X 1/32	1
25.	22-540-12	MOTOR ASSEMBLY	1	73.	123-1335	CURVED DISC SPRING GR. 1074 HC STEEL	1
26.	123-0612	SCREW, 6-32x1/4 PHILLIPS PAN HD.	12	74.	21-100-31	SLIDER	1
27.	24-106-15	CLUTCH BRACKET, REELL	1	75.	123-0384	BEARING	9
28.	123-1564	BELT, TIMING 110XL041	1	76.	63-100-46	LINK, SENSOR	1
29.	123-0006	TRUARC	1	77.	63-100-47	LINK (SHORT)	1
30.	24-106-01	ASSY., DOUBLE CLUTCH PULLEY 16-28 GROOVES	1	78.	123-0053	NUT, SELF LOCKING 10-32	3
31.	123-1725	BELT, 120XL	1	79.	24-100-40	SENSOR BRACKET	1
32.	65-303-01	PULLEY ASSY.,MOTOR, 14 GROOVES	1	80.	123-0004	SCREW, 10-32x5/8 SOC. HD.	4
33.	123-0298	SCREW, SET 10-24x3/16 SOC PT	1	81.	123-0262	WASHER # 10 3/16X3/8X.032	1
34.	56-100-26	POWER SWITCH BRACKET	1	82.	63-100-45	LINK, CONNECTING	1
35.	24-150-05	NON-OPERATOR SIDE FRAME	1	83.	123-0017	SCREW, 10-32x1/4 PHILLIPS TRUSS HD.	2
36.	123-0620	FOOT, RUBBER	4	84.	24-100-41	SENSOR PIVOT	1
37.	24-101-11	SCREW, 10-32 PAPER GUIDE	2	85.	63-100-40	SENSOR BRACKET	1
38.	24-106-09	HOUSING, ASSY.	1	86.	24-100-42	KNOB, CLAMPING, 10-32x7/16	1
39.	123-0369	ROLL PIN, .093x3/8	1	87.	123-0114	WASHER, PLASTIC 3/16x7/16x1/32	3
40.	24-500-04	CLUTCH, ASSY. FEED	1	88.	123-2007	SCREW, 6-32x1/2 PHILLIPS PAN HD.	2
41.	123-1516	BELT, 160XL043	1	89.	24-115-16	FRONT FEED FRAME	1
42.	123-0036	ROLL PIN, 3/32x5/8	1	90.	24-115-17	FRONT FEED COVER	1
43.	20-109-04	PULLEY, 16XL GROOVES, ASSY.	1	91.	24-115-24	PULLEY, 14XL GROOVES	1
44.	20-106-09	PULLEY, 12XL GROOVES	1	92.	24-115-05	EXIT SHAFT, ASSY.	1
45.	123-0063	WASHER, 1/4" PLAIN MOTOR & PUMP ZINC	4	93.	123-1158	SCREW, 4-40x3/16 UNDERCUT	4
46.	123-0064	WASHER, LOCK 1/4	4	94.	90-103-52	BALL BEARING HOUSING, ASSY.	2
47.	123-0524	SCREW, 1/4-20x1/2 SOC. CAP	4	95.	24-114-09	L/H SIDE GUIDE BLOCK, ASSY.	1
48.	24-106-04	SHAFT, CLUTCH	1				

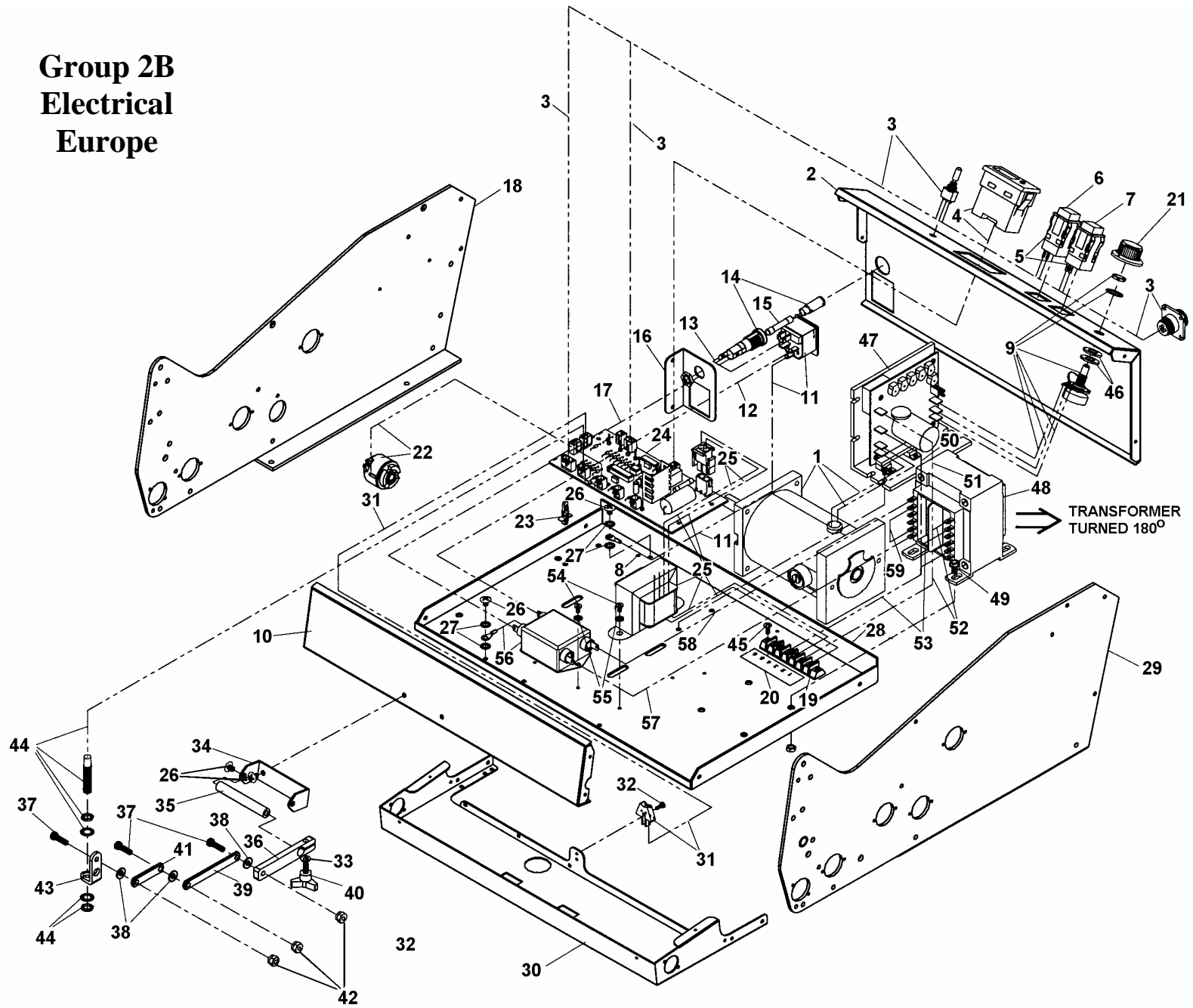
Group 2A Electrical Domestic



KEY	PART #	DESCRIPTION	QTY	KEY	PART #	DESCRIPTION	QTY.
1.	22-540-12	ASSY., MOTOR	1	30.	24-115-16	FRONT FEED FRAME	1
2.	24-150-16	REAR CLOSURE	1	31.	63-500-13	WIRE HARN., MEDIA SENSOR	1
3.	24-505-01	WIRE HARN., SWITCHES, ASSY.	1	32.	123-1023	SCREW, 4-40x5/16 PANHEAD PH	1
4.	24-500-08	COUNTER ASSY.	1	33.	123-0262	WASHER # 10 3/16X3/8X.032	1
5.	123-0354	SWITCH, 50-21BBA2BA	2	34.	24-100-40	SENSOR BRACKET	1
6.	123-0615	CAP, BUTTON SWITCH BLACK	1	35.	24-100-41	SENSOR PIVOT	1
7.	123-0616	CAP, BUTTON SWITCH RED	1	36.	63-100-40	SENSOR BRACKET	1
8.	123-0712	LABEL, GROUND SYMBOL	1	37.	123-0004	SCREW, 10-32x5/8 SOC. HD.	3
9.	24-515-13	POTENTIOMETER, SPD. CONT., ASSY.	1	38.	123-0114	WASHER, PLASTIC 3/16x7/16x1/32	3
10.	24-150-20	FRONT COVER	1	39.	63-100-45	LINK, CONNECTING	1
11.	63-500-10	POWER SWITCH	1	40.	24-100-42	KNOB, CLAMPING, 10-32x7/16	1
12.	24-515-08	WIRE HARN., FILTER- POWER INLET	1	41.	63-100-47	LINK (SHORT)	1
13.	27-500-01	WIRE HARN., FUSE/.POWER INLET	1	42.	123-0053	NUT, SELF LOCKING 10-32	3
14.	123-0355	FUSE HOLDER LF#345611	1	43.	63-100-46	LINK, SENSOR	1
15.	123-1585	FUSE, 2AMP SLO-BLO	1	44.	24-500-40	ASSY., FIBEROPTIC SENSOR	1
16.	56-100-26	POWER SWITCH BRACKET	1	45.	123-0274	SCREW, 6-32x3/8 PHILLIPS TRUSS HD.	2
17.	24-515-07	WIRE HARN., FILTER- FUSE	1	46.	123-0096	WASHER, PLASTIC 3/8x3/4x1/16	2
18.	24-150-05	NON-OPERATOR SIDE FRAME	1	47.	123-1651	CONTROL, SPEED	1
19.	63-500-26	TERM. BLOCK ASSY	1	48.	123-1562	TRANS., A41-130-230	1
20.	25-550-04	TERM. STRIP	1	49.	123-1761	SCREW, 10-32 x 3/8 HEX HD	4
21.	123-0390	KNOB	1	50.	24-515-09	WIRE HARN. , TERM. BLOCK- SPD. CONT.	1
22.	24-500-04	ASSY., FEED CLUTCH	1	51.	24-515-10	WIRE HARN. , TERM. BLOCK- SPD. CONT.	1
23.	123-0426	SUPPORT, CIRCUIT BOARD	4	52.	24-515-14	WIRE HARN. , TRANS.- TERM. BLOCK	1
24.	63-500-00	CONTROLLER BOARD, FEEDER	1	53.	24-515-15	WIRE HARN. , TRANS.- TERM. BLOCK	1
25.	24-515-12	WIRE HARN., TRANS. WIRE	1	54.	123-0612	SCREW, 6-32x1/4 PHILLIPS PAN HD.	4
26.	123-0017	SCREW, 10-32x1/4 PHILLIPS TRUSS HD.	4	55.	123-0252	WASHER, STAR #6 EXTERNAL	4
27.	123-0237	WASHER, STAR #10	4	56.	29-500-16	FILTER, ASSY.	1
28.	24-150-10	MOTOR BASE	1	57.	24-515-05	WIRE HARN., TRANS.- FILTER	1
29.	24-150-04	OPERATOR SIDE FRAME, WELDMENT	1	58.	24-515-06	WIRE HARN., TRANS.- FILTER	1

**Group 2A
Electrical
Domestic**

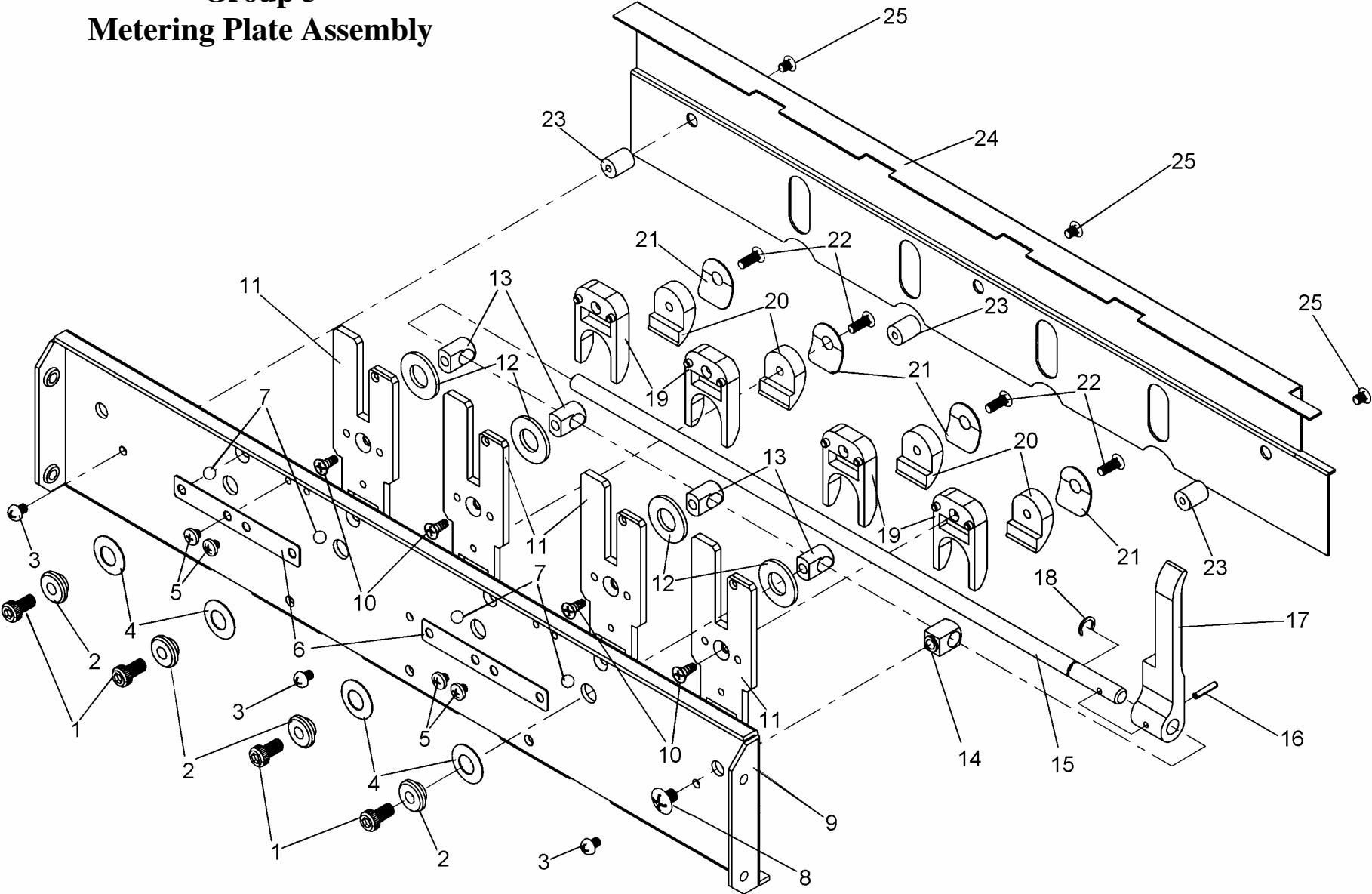
**Group 2B
Electrical
Europe**



KEY	PART #	DESCRIPTION	QTY	KEY	PART #	DESCRIPTION	QTY.
1	22-540-12	ASSY., MOTOR	1	31	63-500-13	WIRE HARN., MEDIA SENSOR	1
2	24-150-16	REAR CLOSURE	1	32	123-1023	SCREW, 4-40x5/16 PAN HEAD PH	1
3	24-505-01	WIRE HARN., SWITCHES, ASSY.	1	33	123-0262	WASHER # 10 3/16X3/8X.032	1
4	24-500-08	COUNTER ASSY.	1	34	24-100-40	SENSOR BRACKET	1
5	123-0354	SWITCH, 50-21BBA2BA	2	35	24-100-41	SENSOR PIVOT	1
6	123-0615	CAP, BUTTON SWITCH BLACK	1	36	63-100-40	SENSOR BRACKET	1
7	123-0616	CAP, BUTTON SWITCH RED	1	37	123-0004	SCREW, 10-32x5/8 SOC. HD.	3
8	123-0712	LABEL, GROUND SYMBOL	1	38	123-0114	WASHER, PLASTIC 3/16x7/16x1/32	3
9	24-515-13	POTENTIOMETER, SPD. CONT., ASSY.	1	39	63-100-45	LINK, CONNECTING	1
10	24-150-20	FRONT COVER	1	40	24-100-42	KNOB, CLAMPING, 10-32x7/16	1
11	63-500-10	POWER SWITCH	1	41	63-100-47	LINK (SHORT)	1
12	24-515-08	WIRE HARN., FILTER- POWER INLET	1	42	123-0053	NUT, SELF LOCKING 10-32	3
13	27-500-01	WIRE HARN., FUSE/.POWER INLET	1	43	63-100-46	LINK, SENSOR	1
14	123-0355	FUSE HOLDER LF#345611	1	44	24-500-40	ASSY., FIBER OPTIC SENSOR	1
15	123-1585	FUSE, 2AMP SLO-BLO	1	45	123-0274	SCREW, 6-32x3/8 PHILLIPS TRUSS HD.	2
16	56-100-26	POWER SWITCH BRACKET	1	46	123-0096	WASHER, PLASTIC 3/8x3/4x1/16	2
17	24-515-07	WIRE HARN., FILTER- FUSE	1	47	123-1651	CONTROL, SPEED #MMXL02-D240AC-PCM	1
18	24-150-05	NON-OPERATOR SIDE FRAME	1	48	123-1562	TRANS., A41-130-230	1
19	63-500-26	TERM. BLOCK ASSY	1	49	123-1761	SCREW, 10-32 x 3/8 HEX HD	4
20	25-550-04	TERM. STRIP	1	50	24-515-09	WIRE HARN., TERM. BLOCK- SPD. CONT.	1
21	123-0390	KNOB	1	51	24-515-10	WIRE HARN., TERM. BLOCK- SPD. CONT.	1
22	24-500-04	ASSY., FEED CLUTCH	1	52	24-515-14	WIRE HARN., TRANS.- TERM. BLOCK	1
23	123-0426	SUPPORT, CIRCUIT BOARD	4	53	24-515-15	WIRE HARN., TRANS.- TERM. BLOCK	1
24	63-500-00	CONTROLLER BOARD, FEEDER	1	54	123-0612	SCREW, 6-32x1/4 PHILLIPS PAN HD.	4
25	24-515-12	WIRE HARN., TRANS. WIRE	1	55	123-0252	WASHER, STAR #6 EXTERNAL	4
26	123-0017	SCREW, 10-32x1/4 PHILLIPS TRUSS HD.	4	56	29-500-16	FILTER, ASSY.	1
27	123-0237	WASHER, STAR #10	4	57	24-525-05	WIRE HARN., TRANS.- FILTER	1
28	24-150-10	MOTOR BASE	1	58	24-525-06	WIRE HARN., TRANS.- FILTER	1
29	24-150-04	OPERATOR SIDE FRAME	1	59	20-500-107	WIRE HARN., TRANS, JUMPER	1
30	24-115-16	FRONT FEED FRAME	1				

Group 2B Electrical Europe

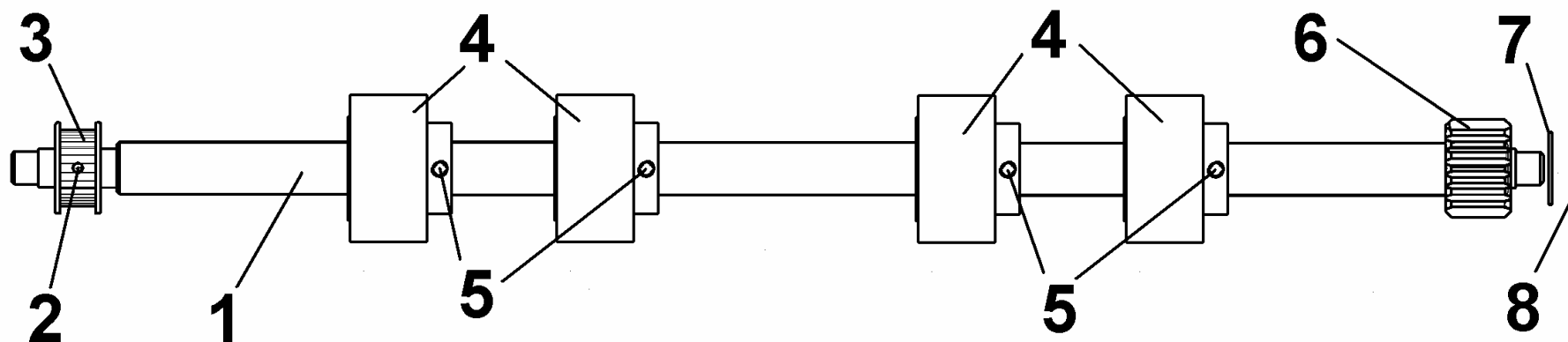
Group 3 Metering Plate Assembly



KEY	PART #	DESCRIPTION	QTY.
1.	123-0185	SCREW, 10-32x3/8 SOC CAP	4
2.	66-101-09	SPACER	4
3.	123-0461	SCREW, 6-32x3/16 PH RND HD ZINC	3
4.	123-0121	DISC SPRING, HIGH CARBON STEEL	4
5.	123-0127	SCREW, 6-32x1/8 PH PAN HD	4
6.	21-121-03	HOLDER, MTRN'G	2
7.	123-0347	BALL, STEEL .187D	4
8.	123-0017	SCREW, 10-32x1/4 PH TRUSS HD	1
9.	21-121-02	PLATE, MTRN'G.	1
10.	123-1310	SCREW, 6x3/8 PH FLAT SELF TAPPING TYPE A 18-8 SS	4
11.	21-121-12	MTRN'G FINGER	4
12.	123-0096	WASHER, PLASTIC 3/8x3/4x1/16	4
13.	66-101-10	STUD	4
14.	66-101-07	STUD	1
15.	66-101-04	BAR, MTRN'G. BRK'T. RELEASE	1
16.	123-0327	ROLL PIN, 3/32 X 7/16	1
17.	24-114-06	LEVER	1
18.	123-0169	C-CLIP 1/4in (CRESCENT)	1
19.	21-101-15	KNOB, MTRN'G.	4
20.	90-103-09S	SEGMENT, MTRN'G	4
21.	66-101-13	WASHER	4
22.	123-0751	SCREW, 6-32x3/8 PH UNDRCT SS	4
23.	66-101-14	STAND OFF	3
24.	22-100-40	COVER, MTRN'G PLATE	1
25.	123-0675	SCREW, 6-32x3/16 PH FH UNDRCT SS	3

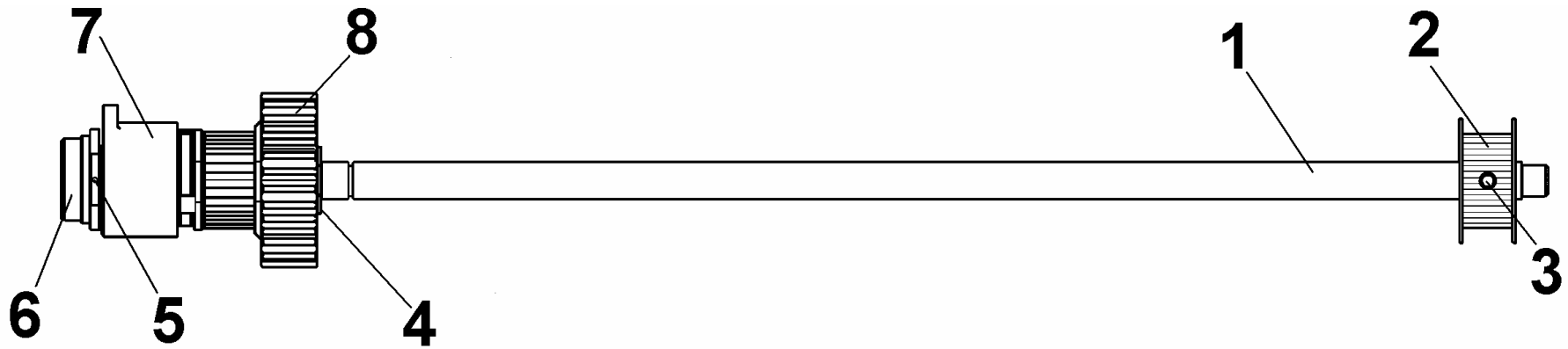
Group 3
Metering Plate Assembly

Group 4 Rear Feed Shaft Assembly



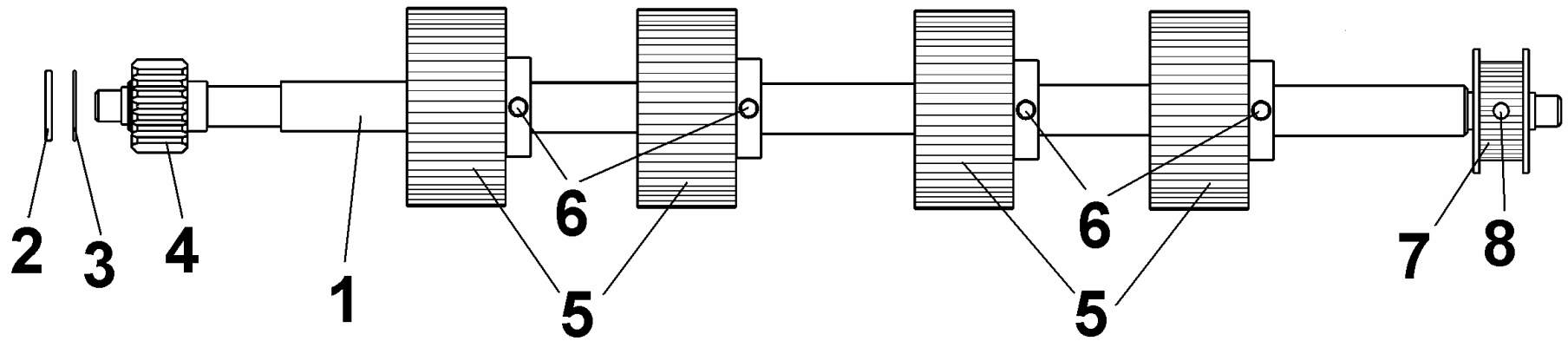
KEY	PART #	DESCRIPTION	QTY.
1.	24-102-01	REAR FEED SHAFT WITH INNER RACE	1
2.	123-0036	ROLL PIN, 3/32X5/8 STEEL	1
3.	20-106-09	PULLEY, 12XL GROOVES, ASSY.	1
4.	56-101-17	ASSY., RUBBER FEED ROLLER	4
5.	123-0322	SET SCREW, 8-32X1/4	4
6.	94-105-04	PULLEY ASSY., 16 GROOVES	1
7.	63-105-15	WASHER, .505ID, .703OD, .030 THICK	1
8.	24-102-06	WASHER	1

Group 5 Clutch Shaft Assembly



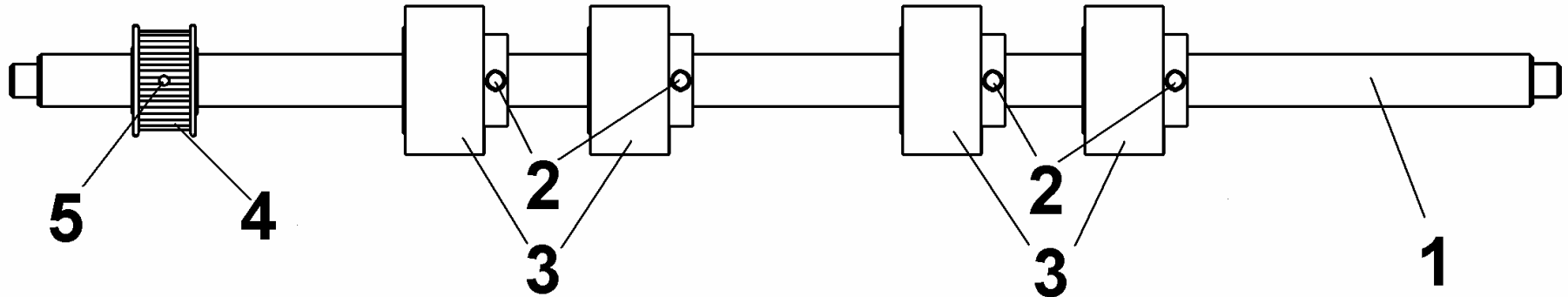
KEY	PART #	DESCRIPTION	QTY.
1.	24-106-04	SHAFT, CLUTCH	1
2.	123-0991	PULLEY 16XLO37	1
3.	123-0322	SET SCREW, 8-32X1/4	1
4.	123-0006	TRUARC	1
5.	123-0369	ROLL PIN, .093X3/8	1
6.	24-106-09	HOUSING ASSY.	1
7.	24-500-04	ASS., FEED CLUTCH	1
8.	24-106-10	ASS., DOUBLE CLUTCH PULLEY 16-28 GROOVES	1

Group 6 Middle Feed Shaft Assembly



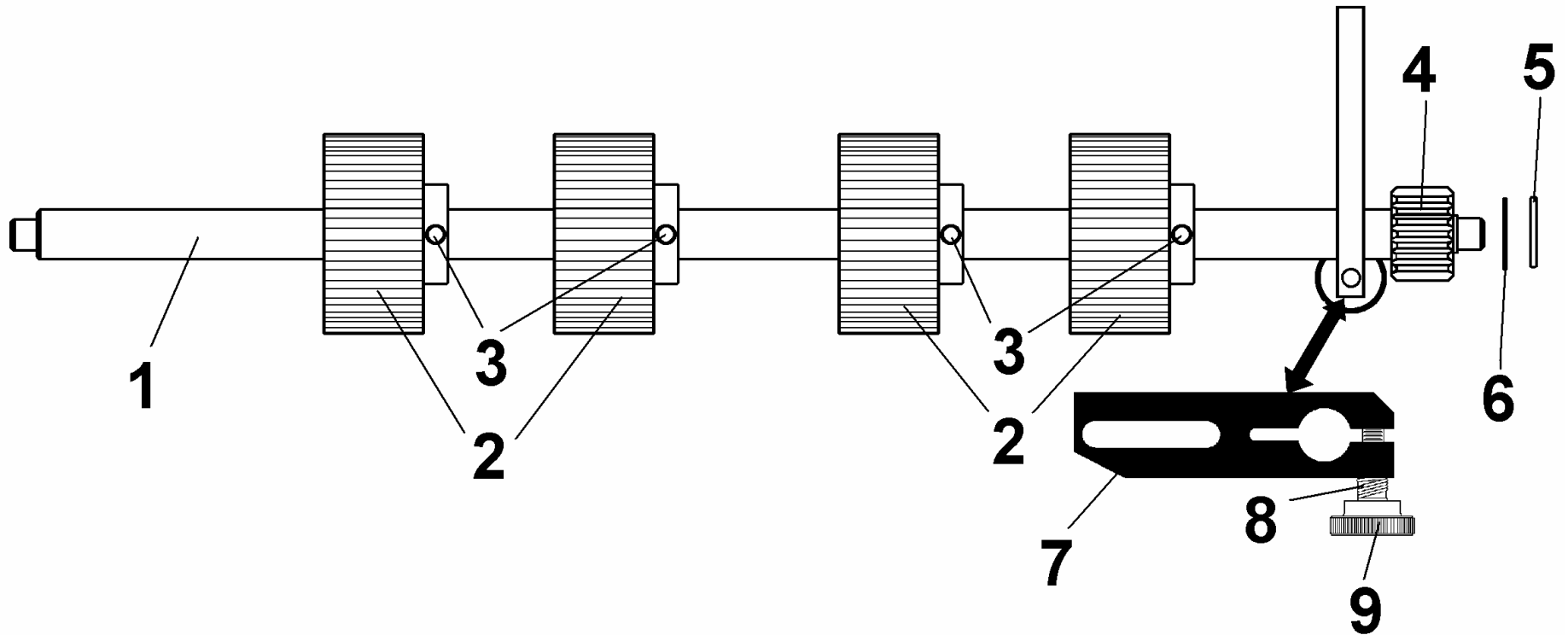
KEY	PART #	DESCRIPTION	QTY.
1.	24-103-01	MIDDLE FEED SHAFT WITH INNER RACE	1
2.	24-102-06	WASHER	1
3.	63-105-15	WASHER, .505ID, L703OD, .030 THICK	1
4.	21-113-03	PULLEY 17 GROOVES, ASSY.	1
5.	90-102-21	FEED ROLLER ASSEMBLY	4
6.	123-1861	SCREW, SET 10-24X1/4 CUP PT	4
7.	123-0991	PULLEY, 16XLO37	1
8.	123-0322	SET SCREW, 8-32X1/4	1

Group 7 Pull Out Feed Shaft Assembly



KEY	PART #	DESCRIPTION	QTY.
1.	24-105-02	PULL OUT FEED SHAFT	1
2.	123-0322	SET SCREW, 8-32X1/4	4
3.	56-101-17	ASSY, RUBBER FEED ROLLER	4
4.	20-109-04	PULLEY 16XL GROOVES, ASSY.	1
5.	123-0036	ROLL PIN, 3/32X5/8	1

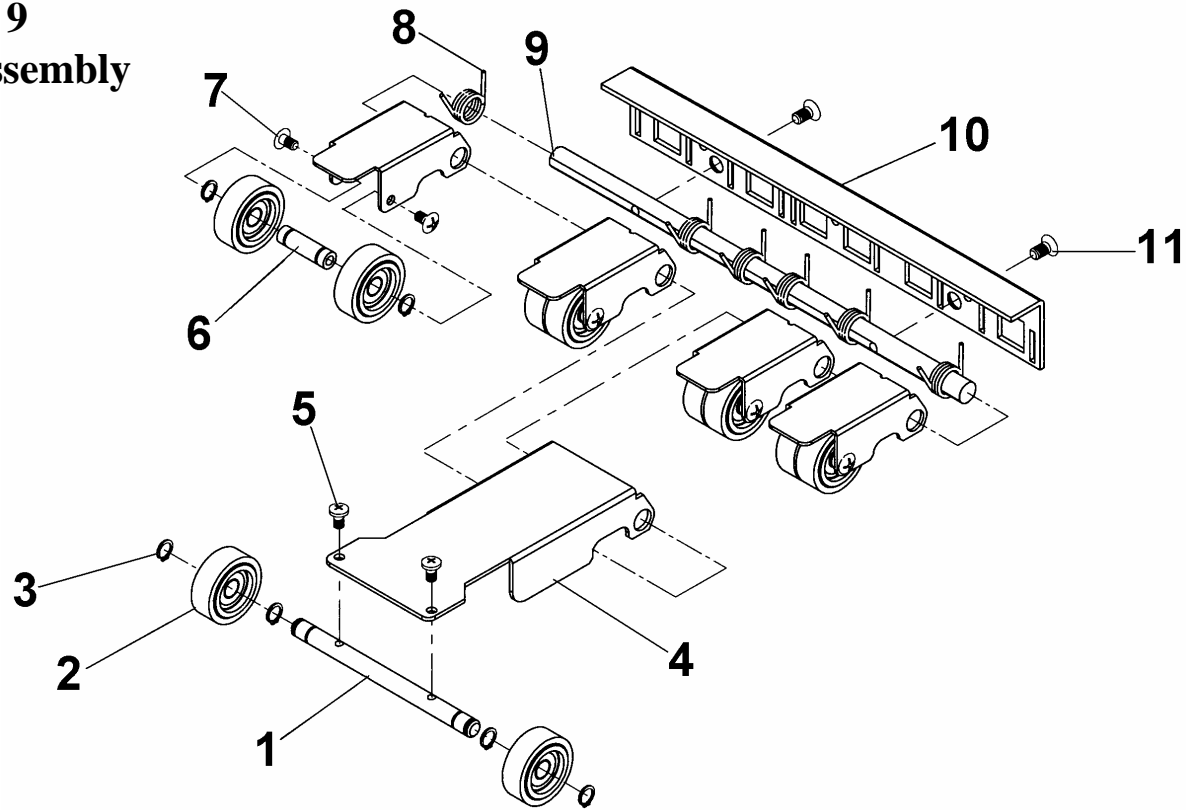
Group 8 Front Feed Shaft Assembly



KEY	PART #	DESCRIPTION	QTY.
1.	24-104-01	FRONT FEED SHAFT WITH INNER RACE	1
2.	90-102-21	FEED ROLLER ASSEMBLY	4
3.	123-1861	SCREW, SET 10-24X1/4 CUP PT	4
4.	94-105-04	PULLEY 16 GROOVES, ASSY.	1
5.	24-102-06	WASHER	1
6.	63-105-15	WASHER, .505ID, .703OD, .030 THICK	1
7.	63-108-04	BRAKE	1
8.	63-108-09	SPRING, FEED ROLLER BRAKE	1
9.	63-108-05	THUMBSCREW, BRAKE	1

GROUP 9

Arm Guide Assembly



KEY	PART #	DESCRIPTION	QTY
1.	24-115-14	SHAFT	1
2.	97-115-02	ASSEMBLY, WHEEL AND BEARING	10
3.	123-0257	TRUARC	12
4.	24-115-07	ARM	1
5.	123-0612	SCREW, 6-32x1/4 PHILLIPS PAN HD.	2
6.	21-122-06	SHAFT	4
7.	123-1135	SCREW, 6-32 x 1/4 TRUSS.HD.PH. SS	8
8.	21-122-08	SPRING	6
9.	21-122-03	SHAFT, ARM GUIDE	1
10.	20-110-02	GUIDE, ARM	1
11.	123-0446	SCREW, 8-32 x 5/16 FL.HD.UNDERCUT 18-8	2

Index

PART#	GROUP	KEY	PART#	GROUP	KEY	PART#	GROUP	KEY
123-0002	1	69	123-0354	2B	5	123-1651	2B	47
123-0004	1	80	123-0355	2A	14	123-1725	1	31
123-0004	2A	37	123-0355	2B	14	123-1761	2A	49
123-0004	2B	37	123-0369	1	39	123-1761	2B	49
123-0006	1	29	123-0369	5	5	123-1861	6	6
123-0006	5	4	123-0384	1	75	123-1861	8	3
123-0017	1	83	123-0390	2A	21	123-2007	1	88
123-0017	3	8	123-0390	2B	21	20-106-09	1	44
123-0017	2A	26	123-0425	1	6	20-106-09	4	3
123-0017	2B	26	123-0426	2A	23	20-109-04	1	43
123-0024	1	9	123-0426	2B	23	20-109-04	7	4
123-0036	1	42	123-0446	9	11	20-110-02	9	10
123-0036	4	2	123-0461	3	3	20-500-107	2B	59
123-0036	7	5	123-0487	1	68	21-100-31	1	74
123-0053	1	78	123-0524	1	47	21-100-32	1	71
123-0053	2A	42	123-0531	1	24	21-100-33	1	70
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