

SWEED MACHINERY

***“TURNING UNMANAGEABLE SCRAP INTO
MANAGEABLE ASSETS”***

OPERATIONS MANUAL SCRAP CHOPPER MODEL #450 AF 3PH 460V 60HZ

MANUFACTURED BY:

**SWEED MACHINERY
P.O. BOX 228
GOLD HILL, OREGON
97525**

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SERIAL NO: _____

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FOREWORD

THE PURPOSE OF THIS MANUAL IS TO FAMILIARIZE QUALIFIED INDIVIDUALS WITH THE OPERATIONAL PROCEDURES OF THE SWEED 450 SCRAP CHOPPER.

THE MANUFACTURER RECOMMENDS THAT THE USERS FAMILIARIZE THEMSELVES WITH THE APPLICATIONS AND USE OF THIS SYSTEM PRIOR TO OPERATION.

THE SWEED SCRAP CHOPPER IS A INDUSTRIAL GRADE MACHINE. IT HAS A WIDE RANGE OF CAPABILITIES, BUT THE SCRAP CHOPPER SHOULD NOT BE USED FOR ANY PURPOSE FOR WHICH IT IS NOT DESIGNED. IN ORDER TO PROVIDE DEPENDABLE AND SAFE SERVICE, THIS CHOPPER MUST BE OPERATED BY TRAINED PERSONNEL WEARING EYE PROTECTION AND GLOVES.

PERSONNEL OPERATING THE MACHINE MUST UNDERSTAND THE TYPE OF MATERIAL THE CHOPPER IS CAPABLE OF PROCESSING.

ANY MISUSE OF THE SWEED SCRAP CHOPPER CAN BE DANGEROUS. ALL OPERATORS SHOULD BE FAMILIAR WITH THE GENERAL OPERATING INSTRUCTIONS AND WARNINGS.

NOTE: IT IS THE OWNERS RESPONSIBILITY TO INSTALL THE SWEED SCRAP CHOPPER IN CONFORMANCE WITH APPLICABLE FEDERAL, STATE AND LOCAL LAWS AND TO INSTRUCT PERSONNEL IN SAFE OPERATING PROCEDURES.

1. **GENERAL INFORMATION:** THE MODEL 450 CHOPPER IS DESIGNED TO PROCESS MATERIALS SUCH AS WIRE, PLASTIC, STEEL BANDING, SMALL TUBING, ALONG WITH MILD STEEL FLAT BAR.

THE CHOPPER WEIGHS APPROXIMATELY 285 LBS. AND IS DESIGNED TO SIT ON A SWEED CHOPPER STAND.

1.1 MAXIMUM CUTTING CAPACITIES:

MATERIAL	STRENGTH / KSI	SIZE WIDTH X THK
STANDARD	145	.375 X .130
HEAT TREATED		.500 X .090
BANDING OR		.625 X .060
STEEL		.750 X .060
		.875 X .040
		*** 1.000 X .040
		*** 1.250 X .020
		*** 1.500 X .020

***** DENOTES BANDING SHOULD NOT BE FED INTO MACHINE WITH CLIPS**

REDUCE THICKNESS BY 1/2 IF BANDING IS BEING FED INTO THE CHOPPER WITH CLIPS OR SEALS, OR IF BANDS ARE FOLDED.

EXCEEDING THE RECOMMENDED MAXIMUM MATERIAL THICKNESS VOIDS MANUFACTURERS WARRANTY.

REDUCE QUANTITY BY 1/2 IF WIRE IS FOLDED.

EXCEEDING THE RECOMMENDED QUANTITY VOIDS MANUFACTURERS WARRANTY.

CHECK WITH MANUFACTURER FOR RECOMMENDED INFEED FUNNELS IN WIRE APPLICATIONS.

CONSULT WITH THE MANUFACTURER FOR MATERIALS NOT COVERED ON CAPACITY SHEET.

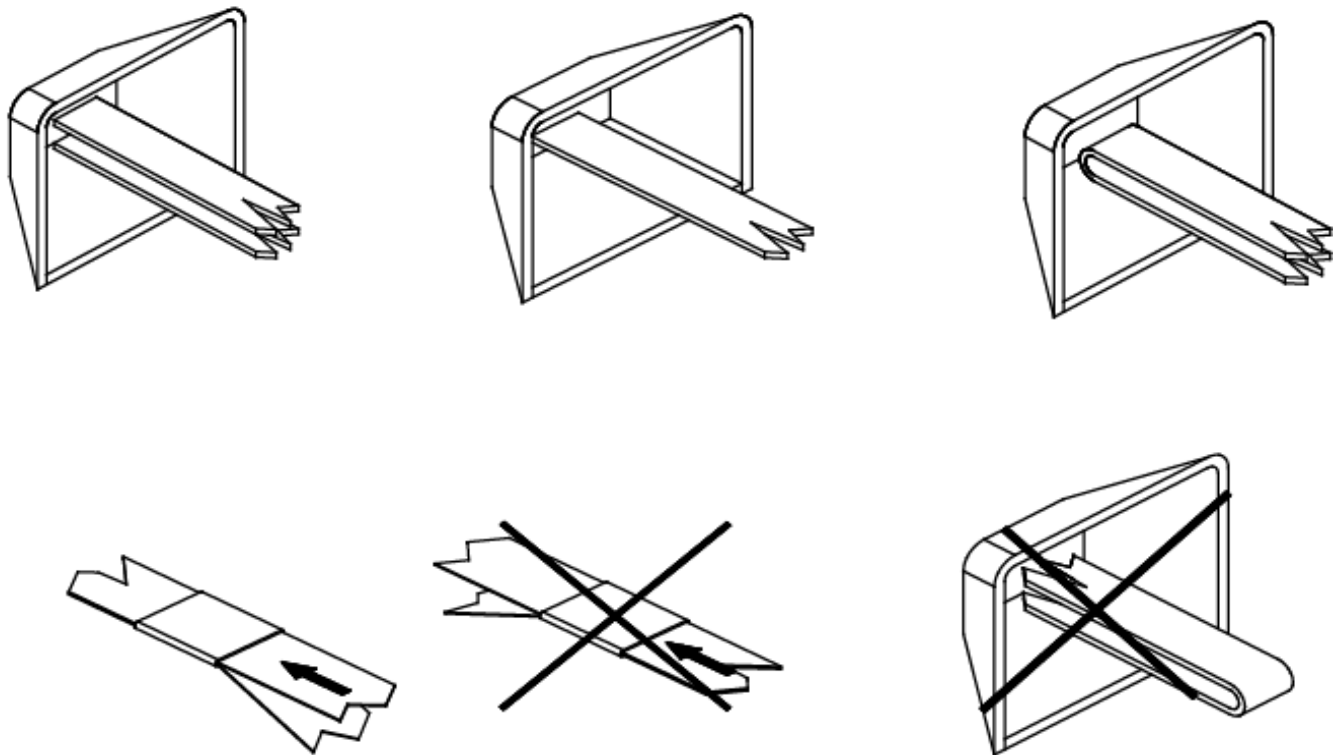
NOTE: THESE ARE MAXIMUM CAPACITIES. PLEASE CONSULT SWEED WHEN HIGH PRODUCTION OPERATION IS REQUIRED. EXCEEDING THESE RECOMMENDATIONS VOIDS MANUFACTURERS WARRANTY.

- 1.2 UNPACKING THE MACHINE:** WHEN THE MODEL 450 CHOPPER ARRIVES, UNCRATE THE MACHINE AND INSPECT IT FOR POSSIBLE SHIPPING DAMAGE. IF ANY DAMAGE IS FOUND, PROMPTLY CONTACT THE SHIPPING COMPANY.
- 1.3 MACHINE LOCATION AND INSTALLATION:** THE LOCATION OF THIS MACHINE SHOULD BE OUT OF HIGH TRAFFIC AREAS AND WHERE STORAGE CONTAINERS CAN BE POSITIONED AND CHANGED EASILY. SET THE MACHINE, STAND AND BARREL ON A LEVEL CONCRETE AREA. MAKE SURE THIS UNIT IS NOT EXPOSED TO RAIN OR ANY HARSH ELEMENTS.

THIS MACHINE REQUIRES A 230/460V, 15 AMP, TRIPLE PHASE, 60 HZ POWER SOURCE. BEFORE THE MACHINE IS PLUGGED IN, MAKE SURE THE POWER SWITCH IS OFF AND THAT THE ELECTRIC CORD IS CLEAR OF THE OPERATOR AND OTHER TRAFFIC. THE MODEL 450 IS NOW READY TO OPERATE (SEE SECTION 2).

- 2. MACHINE OPERATION:** TURN THE MACHINE ON AND ALLOW IT TO REACH FULL SPEED. INSERT THE END OF THE STRAP OR THE FOLDED END OF THE STRAP INTO THE INFEED FUNNEL, (SHOWN ILL 1.1) , WHEN THE STRAP HAS BEEN INSERTED APPROXIMATELY FOUR INCHES INTO THE INFEED FUNNEL IT WILL REACH THE FEED ROLLS AND THE MACHINE WILL START TO SELF FEED.

ILL. 1.1



THE MACHINE SHOULD NOT BE REQUIRED TO UNTANGLE, UNROLL OR EXTRACT SCRAP MATERIAL FROM PACKAGES. THE FEEDWORKS ARE DESIGNED TO FEED THE MATERIAL IN A FREE FLOW CONDITION ONLY. DO NOT ALLOW THE FEED

ROLLS TO "SPIN OUT" AGAINST THE MATERIAL BEING FED. UNDUE MACHINE WEAR OR A MATERIAL JAM WILL OCCUR IF THE MATERIAL IS FED INCORRECTLY. IF THE MATERIAL BECOMES CAUGHT WITHIN THE FEEDWORKS, TURN THE POWER OFF AND PULL DOWN ON THE FEEDWORKS HANDLE TO OPEN THE FEEDROLLS. THE MATERIAL WILL FALL OUT OR CAN BE REMOVED FROM THE FEED THROAT AND BE RE-FED. DAMAGE TO THE UPPER FEED ROLL MAY OCCUR IF MATERIAL BECOMES LODGED WITHIN THE FEEDWORKS.

SAFETY/WARNING

1. **ALWAYS DISCONNECT THE POWER PRIOR TO REMOVING ANY MATERIAL THAT IS LODGED WITHIN THE FEEDWORKS.**
2. **TURN THE MACHINE OFF ONCE THE FEEDING IS COMPLETE. NEVER LET THE MACHINE RUN UNSUPERVISED.**
3. **MAINTENANCE: WARNING - ALL MAINTENANCE DONE TO THIS MACHINE MUST BE DONE WHILE THE POWER IS DISCONNECTED.**
 - 3.1 **KNIFE ROTATION AND REPLACEMENT:** THE MACHINE KNIVES HAVE FOUR KNIFE EDGES AND ARE ROTATED WHEN ONE EDGE BECOMES DULL.

TO ROTATE THE KNIVES, REMOVE THE GUARD FROM THE MACHINE . (REF 3.3). REMOVE THE 3/8" SOCKET HEAD CAP SCREWS HOLDING THE STATIONARY AND THE ROTATING KNIVES IN PLACE.

ROTATE EACH KNIFE TO A NEW SHARP EDGE. DO NOT REMOVE THE SHIM BEHIND THE STATIONARY KNIFE.. WHEN REINSTALLING THE KNIVES REMOVE ANY BURRS FROM THE OLD KNIFE EDGE SO THAT IT SITS FLUSH IN THE KNIFE HOLDER. BE SURE TO BLOW OFF THE KNIFE POCKETS AND WIPE THEM CLEAN. WIPE DOWN THE KNIVES WITH A SUITABLE SOLVENT. WITH THE NEW KNIFE EDGES IN PLACE SNUG DOWN THE BOLTS. TAP THE KNIVES WITH A BRASS HAMMER TO MAKE SURE THE KNIFE IS SEATED PROPERLY.DRAW THE KNIFE BOLTS DOWN EVENLY AND TORQUE EACH BOLT TO 62 LBS FT/LBS. ONCE EACH KNIFE HAS BEEN TIGHTENED ROTATE THE FLYWHEEL AND CHECK THE GAP BETWEEN THE ROTARY AND STATIONARY KNIVES. THE GAP SHOULD BE A MINIMUM OF .001" AND A MAXIMUM OF .003".IF THE KNIFE GAP IS .003" OR MORE, THEN LOOSEN THE SET SCREWS ON THE BEARING, LOOSEN THE BEARING BOLTS , MOVE THE FLYWHEEL TOWARDS THE STATIONARY KNIFE AS NEEDED TO ATTAIN THE RECOMMENDED KNIFE GAP.OF .001"- .003" RE-TORQUE THE BEARING BOLTS TO 62 FT/LBS. .TIGHTEN THE SET SCREWS ON BEARINGS.

IF THE DESIRED GAP CAN NOT BE ATTAINED AS NOTED ABOVE, CONTACT SWEED MACHINERY FOR FURTHER INSTRUCTIONS.
 - 3.2 **LUBRICATION:** THE MAIN BEARINGS SHOULD BE GREASED WITH NO. 2 NLGL OR A MULTI PURPOSE BALL BEARING GREASE. GREASE SHOULD BE APPLIED TO THIS MACHINE ONCE A WEEK OR AS NEEDED. THE GREASE MUST BE ADDED SLOWLY TO THE FLYWHEEL BEARINGS TO PREVENT DAMAGING THE SEALS.

LUBE THE FEEDWORKS GREASE ZERKS EVERY 150 HOURS OF USE.

- 3.3 MAIN GUARD REMOVAL:** REMOVE THE TWO BOLTS LOCATED ON THE TOP OF THE GUARD ASSEMBLY AND ROTATE THE BACK OF THE GUARD TO THE RIGHT AND SLIDE FORWARD.
- 3.4 FEED ROLL ADJUSTMENT:** LOOSEN THE ADJUSTMENT BOLT LOCATED IN THE HANDLE ASSEMBLY (ITEM #7) IN FRONT OF THE LOWER FEED ROLL (ITEM #6). LOOSEN THE BOLT UNTIL THE LOWER FEED ROLL SPINS AGAINST THE UPPER FEED ROLL. ADJUST THE BOLT IN UNTIL THE LOWER ROLL STOPS SPINNING AND THERE IS A GAP BETWEEN THE UPPER AND LOWER ROLL (APPROX. .010" GAP). LOCK THE BOLT IN PLACE BY TIGHTENING THE LOCK NUT.

4.0 TROUBLE SHOOTING- UNPLUG THE MACHINE BEFORE CHECKING FOR ANY PROBLEMS.

PROBLEM	CAUSE	SOLUTION
ROUGH AND STRINGY CUTS:	1. DULL STATIONARY KNIFE	-ROTATE STATIONARY KNIFE, SEE SEC. 3.1
	2. DULL ROTATING KNIFE	-ROTATE ROTATING KNIFE, SEE SEC. 3.1
	3. CLEARANCE PROBLEMS	-CHECK KNIFE CLEARANCE, SEE SEC. 3.1
	4. WORN BEARINGS	-CONTACT SWEED FOR INFORMATION
MATERIAL FEED STOPPED	1. BROKEN OR WORN DRIVE BELT	-REPLACE OR RETENTION DRIVE BELT
	2. MATERIAL PLUGGING INFEED TUBE BEHIND INFEED ROLLS	-CLEAR MATERIAL FROM TUBE
	3. JAMMED FEED ROLLS	-CLEAR MATERIAL FROM THE FEED ROLLS, SEE SEC. 2
	4. WORN FEED ROLLS	-REPLACE FEED ROLLS
	5. REDUCED FEED ROLL SPRING TENSION	-REPLACE EXTENSION SPRING
CHOPPER WILL NOT START OR STOPS RUNNING	1. MATERIAL FEED JAMMED	-SEE MAT'L FEED STOPPED SECTION NOTED ABOVE

2. MOTOR PROTECTION
TRIPPED

-PUSH MOTOR
RESET

4.0 TROUBLE SHOOTING CONTINUED

PROBLEM	CAUSE	SOLUTION
CHOPPER WILL NOT START OR STOPS RUNNING	3. BROKEN DRIVE BELT	-REPLACE BELT
	4. FAILED ELECTRICAL SERVICE	-CHECK FOR CIRCUIT POWER
	5. SWITCH FAILURE	-REPLACE SWITCH

**RECOMMENDED SPARE PARTS
USE WITH PARTS DRAWING AD053271 PG 2-4**

<u>DESCRIPTION</u>	<u>QTY</u>	<u>PART NO.</u>
ROTATING KNIFE	1	CB000305
V-BELT 44" LONG	1	BN001384
KNURLED UPPER FEED ROLL	1	CB010080
3/4" ID THRUST WASHERS	2	BN001135
ANVIL KNIFE BAR	1	CB000349
3/4" ID X 1" OD X 3/4" LG SLEEVE BEARING	2	BN001133
BUSHING, FLANGED 3/4OD X 5/8ID X 5/8" LG	2	BX011376

**MINIMUM ORDER \$25.00
PRICES SUBJECT TO CHANGE WITHOUT NOTICE**

WARRANTY

SWEED MACHINERY'S 450 IS WARRANTED AGAINST DEFECTS AND WORKMANSHIP FOR A PERIOD OF ONE YEAR FROM DATE OF SHIPMENT. PARTS CLAIMED TO BE DEFECTIVE MUST BE RETURNED, FREIGHT PREPAID, TO OUR PLANT IN GOLD HILL, OREGON. ANY PARTS DETERMINED DEFECTIVE DUE TO FAULTY WORKMANSHIP OR MATERIALS WILL BE REPLACED OR REPAIRED (AT OUR OPTION) FREE OF CHARGE, F.O.B. OUR PLANT. EXCEPT AS EXPRESSLY PROVIDED HEREIN, THIS WARRANTY IS IN LIEU OF ALL OTHER WARRANTIES, EXPRESSED OR IMPLIED, INCLUDING A WARRANTY OF MERCHANT ABILITY OF FITNESS FOR A PARTICULAR PURPOSE. THIS WARRANTY IS VOID IF THE UNIT HAS BEEN TAMPERED WITH, MODIFIED, ALTERED, OR OPERATED WITH PARTS OTHER THAN SUPPLIED OR RECOMMENDED BY SWEED MACHINERY, INC. IN NO EVENT SHALL SWEED MACHINERY, INC. BE LIABLE FOR SPECIAL, INDIRECT, INCIDENTAL OR CONSEQUENTIAL DAMAGES, HOWEVER ARISING.

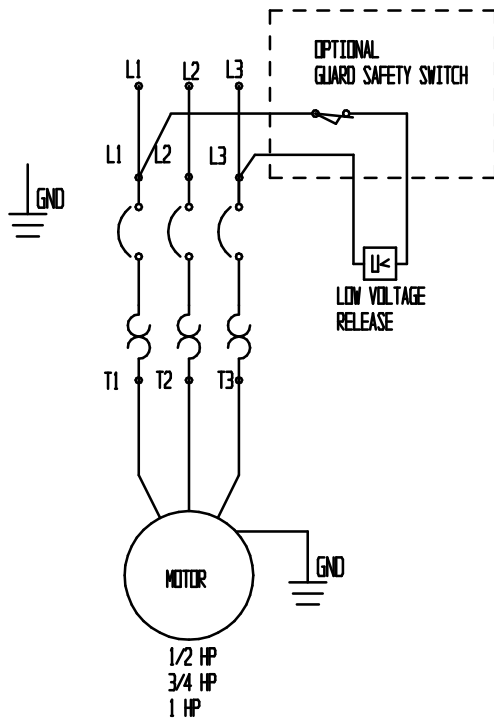
SWEED MACHINERY, INC DOES NOT WARRANTY THIS MACHINE TO MEET THE REQUIREMENTS OF ANY SAFETY CODES OF ANY STATE, MUNICIPALITY, OR OTHER JURISDICTION, AND THE PURCHASER ASSUMES ALL RISK AND LIABILITY WHATSOEVER RESULTING FROM THE USE THEREOF WHETHER USED SINGULARLY OR IN COMBINATION WITH OTHER MACHINERY OR APPARATUS.

ANY CHANGE IN MATERIALS, DESIGN, OR PERFORMANCE INTENDED TO IMPROVE ANY PRODUCT OF SWEED MACHINERY, INC. SHALL NOT OBLIGATE SWEED MACHINERY, INC. TO MODIFY ANY PREVIOUSLY MANUFACTURED EQUIPMENT.

SWEED MACHINERY INC.

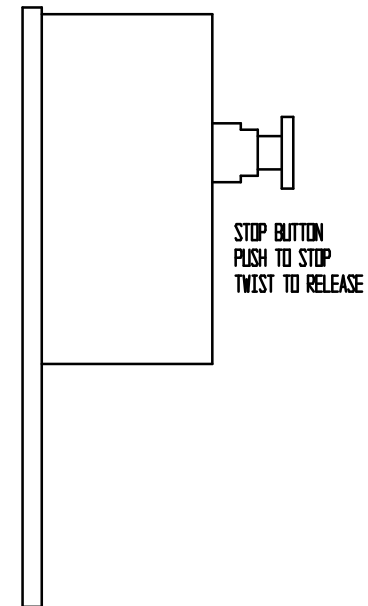
NOTE: ALL RETURNED MATERIAL MUST BE ACCOMPANIED BY A SWEED RETURN AUTHORIZATION NUMBER. PLEASE CALL OUR SERVICE DEPARTMENT AT 1-800-888-1352 IF YOU NEED HELP WITH THIS ORDER.

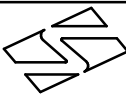
CUSTOMER TO INSTALL IN ACCORDANCE WITH
N.E.C. & ALL STATE & LOCAL REQUIREMENTS.

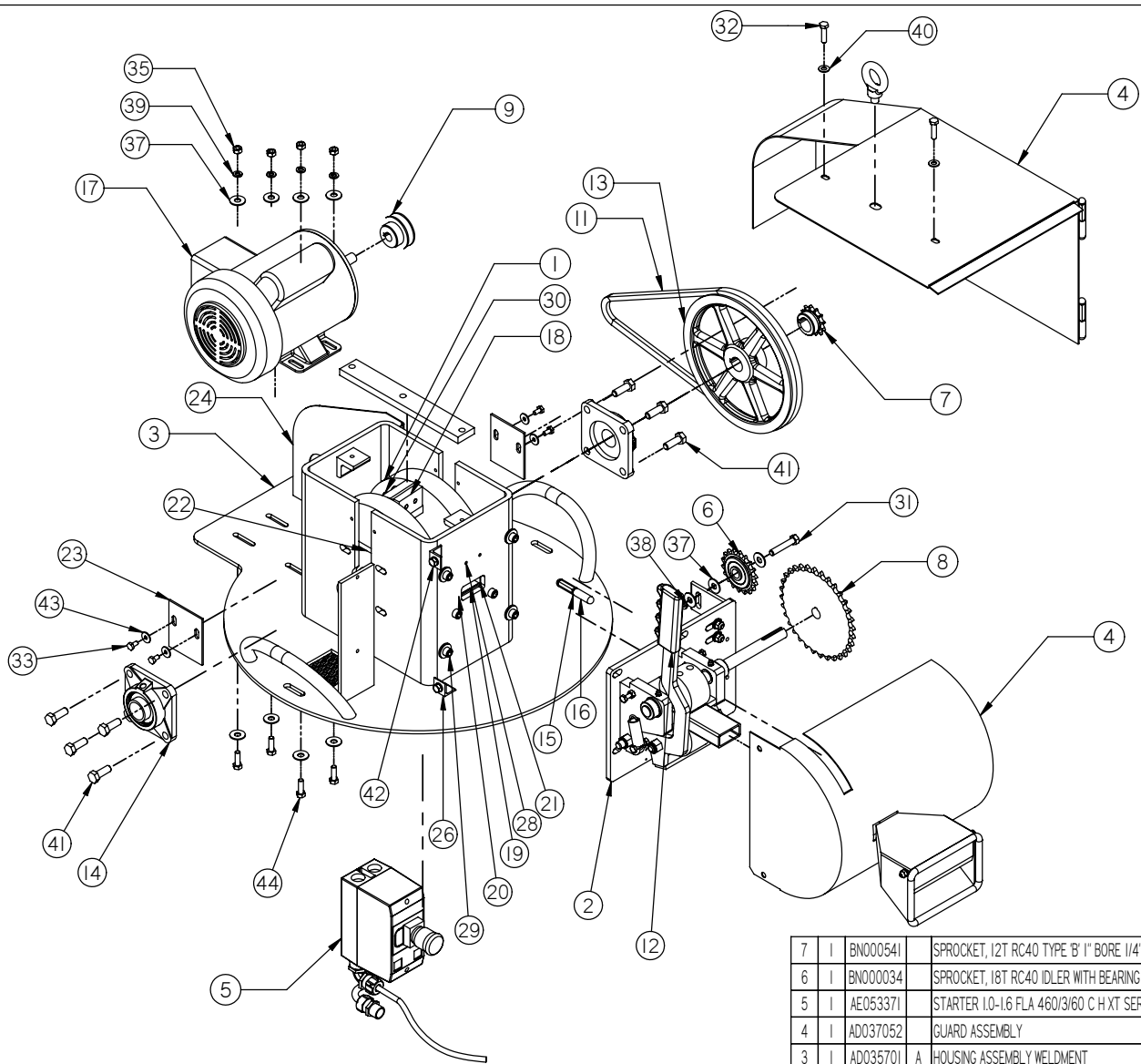


AE053371
AE053381
AE054771
AE055451

REVISIONS				
REV.	DESCRIPTION	BY	APPROVAL	DATE



REV. FILE	 Sweed Machinery, Inc. P.O. Box 228 Gold Hill, Oregon 97525 (541) 855-1512	SCALE: DNS
		DATE: 9/7/05
		DRAWN BY: WAH
		CHECKED BY:
		APPROVED BY:
400, 450 - 450 XHD 1/4HP STARTER, UNDERVOLT RELEASE & E. STOP & OPTIONAL GUARD SAFETY SWITCH		
1/2 HP, 3/4 HP, 1HP THREE PHASE 230/3/60, 460/3/60, 575/3/60		DWG. #: EB009441



7	I	BN000541		SPROCKET, 12T RC40 TYPE 'B' 1" BORE 1/4" KW 12I SS
6	I	BN000034		SPROCKET, 18T RC40 IDLER WITH BEARING
5	I	AE053371		STARTER 1.0-1.6 FLA 460/3/60 C H XT SERIES
4	I	AD037052		GUARD ASSEMBLY
3	I	AD035701	A	HOUSING ASSEMBLY WELDMENT
2	I	AD035631	B	FEEDWORKS MAIN ASSEMBLY
1	I	AD032121		FLYWHEEL ASSEMBLY
#	QTY	SWEED #	REV	DESCRIPTION

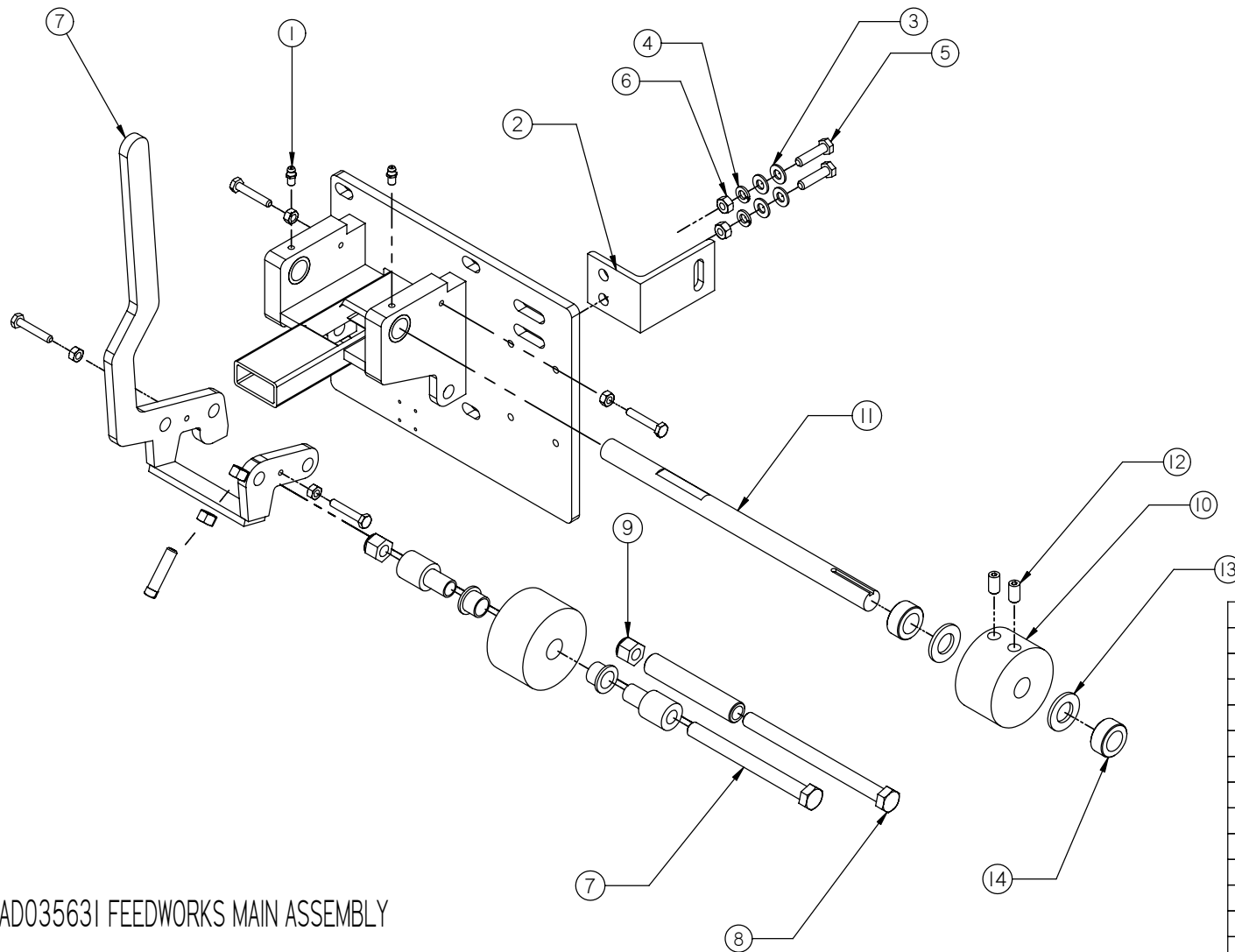
44	4	FA000231		BOLT, 5/16-18 X 1 HEX HEAD
43	8	FA000167		WASHER, 1/4 FLAT USS ZINC
42	2	FA000154		BOLT, 5/16-18 X 1/2 HEX HEAD GRADE 5
41	8	FA000142		BOLT, 7/16-14 X 1 1/4 HEX HEAD
40	2	FA000112		WASHER, 5/16 FLAT
39	6	FA000111		WASHER, 5/16 LOCK SPLIT
38	1	FA000110		WASHER, 3/8 LOCK SPLIT
37	19	FA000109		WASHER, 3/8 FLAT USS
36	2	FA000108		WASHER, 1/4 LOCK SPLIT ZINC
35	4	FA000063		NUT, 5/16-18 HEX
34	1	FA000059		NUT, 3/8-16 HEX
33	4	FA000041		BOLT, 1/4-20 X 1 1/2 HEX HEAD GRADE 5
32	2	FA000027		BOLT, 5/16-18 X 1 1/4 HEX HEAD
31	1	FA000015		BOLT, 3/8-16 X 2 HEX HEAD
30	2	FA000012		CAP SCREW, 3/8-16 UNC, 1 1/2" LONG
29	6	FA000011		CAP SCREW, 3/8-16 UNC, 1" LONG
28	2	FA000006		BOLT, 1/4-20 X 1 HEX HEAD GRADE 5
27	1	CX002745		KEY, 3/16" X 3/16" X 1 1/4" LONG
26	2	CX002614		ANG 1 X 1 X 1/8 X 1
25	1	CB023445		ESTOP MOUNTING PLATE
24	1	CB010122	B	MOTOR GUARD
23	2	CB007366	C	KEYHOLE COVER
22	2	CB006039	A	BEARING BACKING PLATE
21	1	CB002784	C	INTERNAL FEED GUIDE
20	1	CB001807	C	KNIFE SHIM
19	1	CB000349	A	D-2 ANVIL KNIFE BAR
18	1	CB000305	A	ROTATING KNIFE D-2
17	1	BX008572		MOTOR, 3/4HP 1725 460/3/60 56 FRAME TEFC F-2 MNT
16	2	BX006136		HINGE, WELDABLE LIFT OFF 19/32 OD X 1 3/16 LONG
15	2	BX006136		HINGE, WELDABLE LIFT OFF 19/32 OD X 1 3/16 LONG
14	2	BX005896		4-HOLE FLANGE BEARING, 1 1/4" BORE
13	1	BN002282		SHEAVE, 10" O.D., 1" BORE
12	1	BN001623		GRIP, BICYCLE 7/8" BLACK BICYCLE
11	1	BN001384		V-BELT, 44" LONG, 4LW
10	2	BN001132		SPRING, EXTENSION .105 WIRE 47/640D 258 HOOK 16 COIL
9	1	BN000929		SHEAVE, 2" O.D., 5/8" BORE
8	1	BN000697		SPROCKET, 36T RC40 TYPE 'B' 3/4" BORE 3/16KW 12/SS
#	QTY	SWEED #	REV	DESCRIPTION



Sweed Machinery, Inc.
PO Box 228 • Gold Hill, OR 97525
541-855-1512

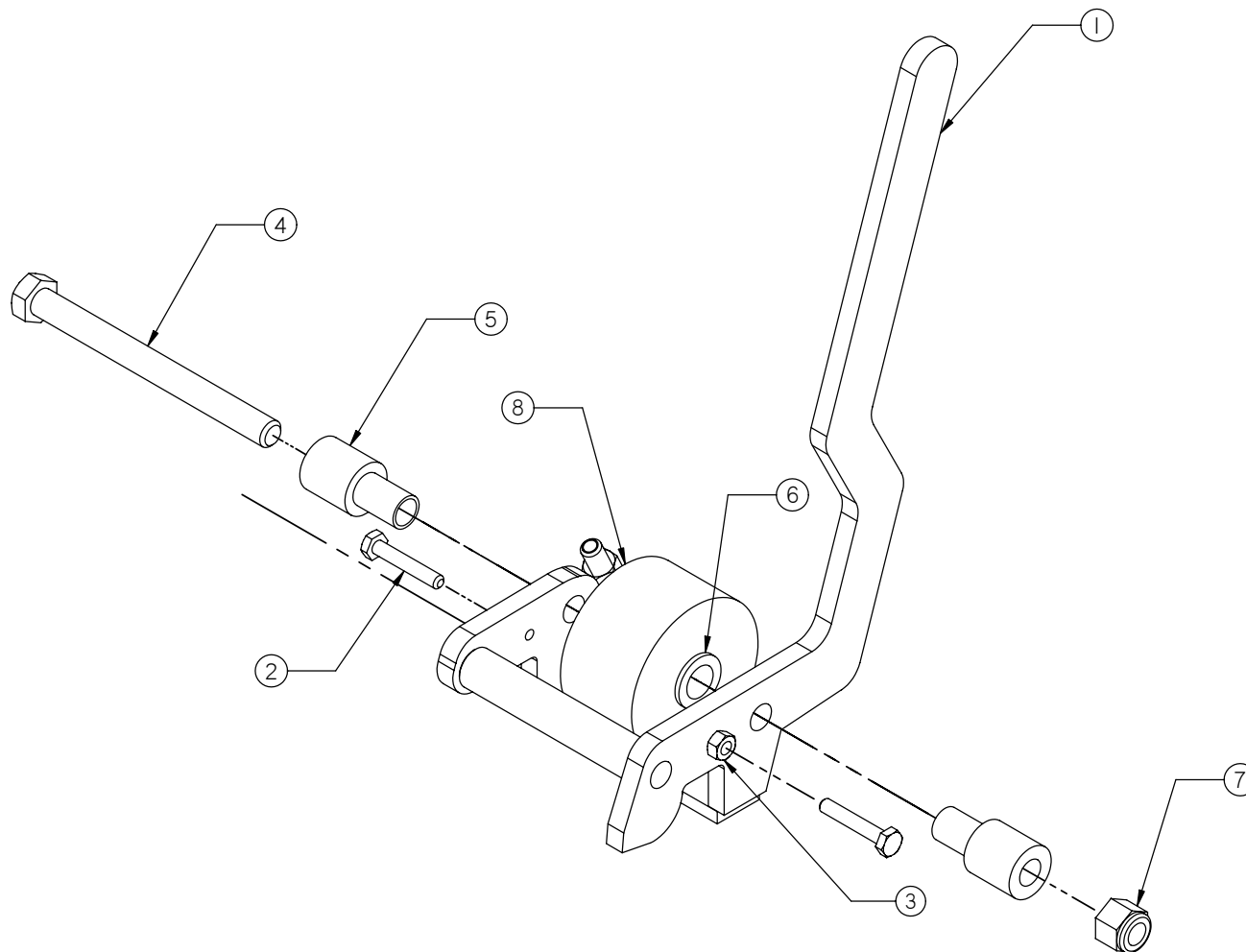
DATE: 1-25-06
SHEET: 2 OF 5

SWEED SCRAP CHOPPER MODEL #450 AF PART DWG AD053271



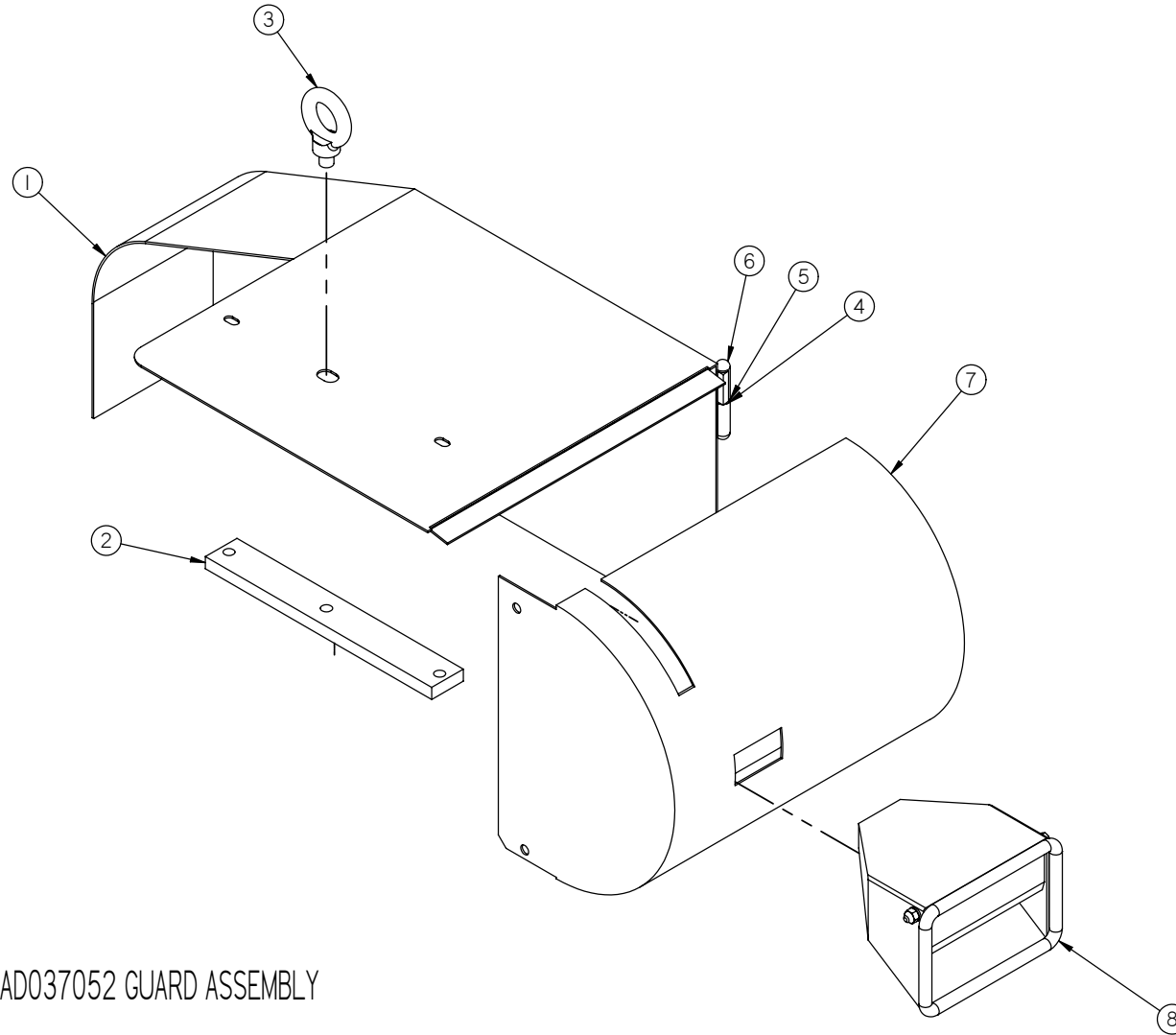
AD035631 FEEDWORKS MAIN ASSEMBLY

14	2	BN001327		COLLAR, 3/4" SET
13	2	BN001135		THRUST WASHER, 3/4" ID, 1 1/4" O.D., 1/8" THICK
12	2	FA000404		SCREW, 3/8-16 X 3/4 SET SQ HEAD
11	1	CB011667	A	FEEDWORKS DRIVE SHAFT
10	1	CB010080		FEEDROLL, 3" DIA 1045 KNURLED
9	1	FA000054		NYLOCK HEX NUT, 1/2-13 UNC
8	1	FA000635		HEX BOLT, 1/2-13 UNC, 6 1/2" LONG
7	1	AB035651		FEEDWORKS HANDLE ASSEMBLY
6	2	FA000063		NUT, 5/16-18 HEX
5	2	FA000027		BOLT, 5/16-18 X 1 1/4 HEX HEAD
4	2	FA000111		WASHER, 5/16 LOCK SPLIT
3	4	FA000112		WASHER, 5/16 FLAT
2	1	CB000477	B	BELT IDLER BRACKET
1	1	AB035641	A	FEEDWORKS WELDMENT
#	QTY	SWEED #	REV	DESCRIPTION
				 Sweed Machinery, Inc. PO Box 228 • Gold Hill, OR 97525 541-855-1512
				DATE: 1-25-06
				SHEET: 3 OF 5
				PART DWG: AD053271
SWEED SCRAP CHOPPER MODEL #450 AF				



AB035651 FEEDWORKS HANDLE ASSEMBLY

10"	1	FA000059		NUT, 3/8-16 HEX
9"	1	FA000018		SCREW, 3/8-16 X 1 1/2 SQ
8	1	CB001309	C	FEEDROLL, 3" DIA 1045 SMOOTH IDLER
7	1	FA000054		NYLOCK HEX NUT, 1/2-13 UNC
6	2	BX011376		BEARING, FLANGE 3/4 OD X 5/8 ID X 5/8 LG X 1/8 FL
5	2	CB011377		MOUNTING ADAPTER, LOWER FEED ROLL
4	1	FA000346		HEX BOLT, 1/2-13 UNC, 5 1/2" LONG
3	2	FA000055		NUT, 1/4-20 HEX
2	2	FA000007		BOLT, HEX 1/4-20, 1 1/2" LONG
1	1	AB035661	C	FEEDWORKS HANDLE WELDMENT
#	QTY	SWEED #	REV	DESCRIPTION
				 Sweed Machinery, Inc. PO Box 228 • Gold Hill, OR 97525 541-855-1512
				DATE: 1-25-06
				SHEET: 4 OF 5
				PART DWG: AD053271
SWEED SCRAP CHOPPER MODEL #450 AF				



AD037052 GUARD ASSEMBLY

8	1	AD033171	D	INFEED FUNNEL MAIN ASSEMBLY
7	1	BB010208	A	FEEDWORKS GUARD
6	4	BX006136		HINGE, WELDABLE LIFT OFF 19/32 OD X 1 3/16 LONG
5	2	BX006136		HINGE, WELDABLE LIFT OFF 19/32 OD X 1 3/16 LONG
4	2	BX006136		HINGE, WELDABLE LIFT OFF 19/32 OD X 1 3/16 LONG
3	1	FA000002		EYE BOLT, 1/2-13
2	1	CB002081	A	HOUSING-GUARD CROSS BAR
1	1	BB010038	B	MAIN GUARD
#	QTY	SWEED #	REV	DESCRIPTION
				 Sweed Machinery, Inc. PO Box 228 • Gold Hill, OR 97525 541-855-1512
				DATE: 1-25-06
				SHEET: 5 OF 5
				PART DWG: AD053271
SWEED SCRAP CHOPPER MODEL #450 AF				