

VersaClipper 3000

Model # _____

Serial # _____

Vertex Fasteners
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DESCRIPTION OF EQUIPMENT

The VersaClipper 3000, a specially designed machine used by upholstered furniture manufacturers, quickly and accurately installs patented VersaClips into wooden frame rails. The straightforward, innovative design elements have resulted in a productive and versatile machine for all manufacturers.

The VersaClipper 3000 is made up of five main components:

1. Clip Dispenser Frame
 - a. The Clip Dispenser Frame holds a spool of VersaClips containing 1,500 pieces.
2. Tool Assembly (Clipping Head)
 - a. The Tool Assembly, which installs VersaClips into wooden furniture rails, is height adjustable to accommodate rails from 5/8" to 2 1/2" thick.
 - b. Each time the Tool fires, the "CLIPPER" indicator light on the Control Box will flash.
3. Control Box
 - a. The Control Box coordinates and controls all functions of the machine: installation of all clips, timing/speed settings, tool height adjustment, manual clipping and programmed rail information.
4. Rail Sensor
 - a. The purpose of the Rail Trigger Switch (Drawing VC5732), when activated, prompts the machine to begin the clipping sequence for the currently loaded rail program. When the Rail Trigger Switch is tripped, the "RAIL SENSOR" indicator light on the Control Box will illuminate.
5. Control Circuit

OPERATING INSTRUCTIONS

Loading a Spool of VersaClips

1. Load clips so they run off top of spool (Fig. 1).
2. Push spool against magnetic brake.
3. Thread clips over Clip Lifter and down Inside Chute.
4. Verify that feed cylinder is down.
5. While depressing "MANUAL CLIP" pushbutton (Fig. 2.5), push clips into back of tool until clips contact driver blade. Release pushbutton.

Loading a Spool of VersaClips while Clips are Running

1. Remove empty spool while last of the clips are running.
2. Follow steps 1-3 above.
3. With constant pressure, feed clips in behind the last clip of the previous roll.
 - a. Apply constant pressure until feed cylinder has engaged new strand of clips.

Removing VersaClips from Tool Assembly

1. Lift feed cylinder up, swing flag up to support cylinder.
2. Spread left and right pawls away from side plates while removing clips from rear.
Caution: Do not overspread pawls.

FIGURE 1

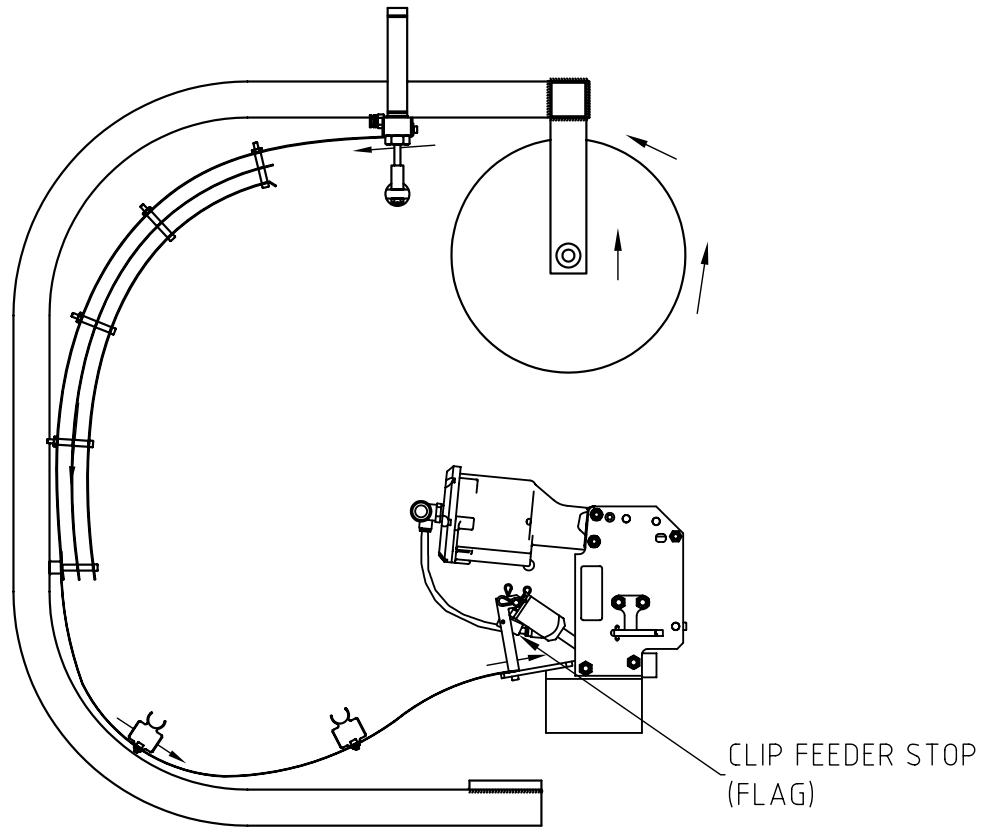
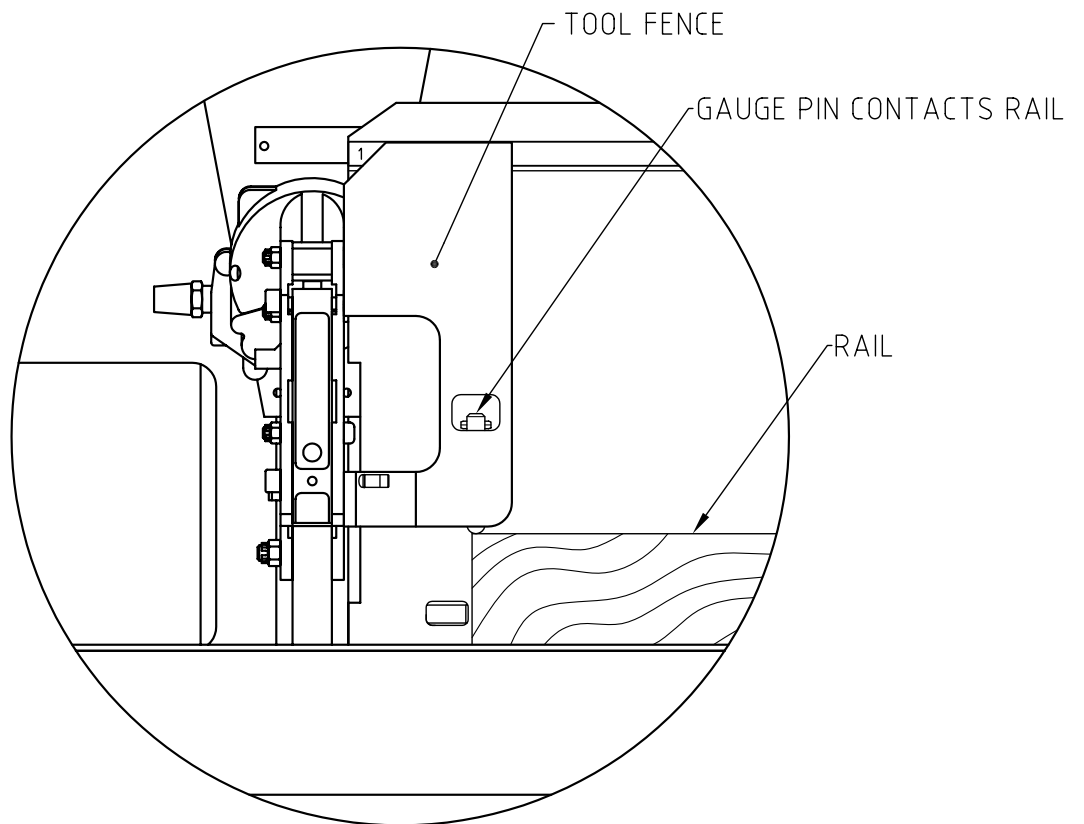


FIGURE 2



CONTROL BOX

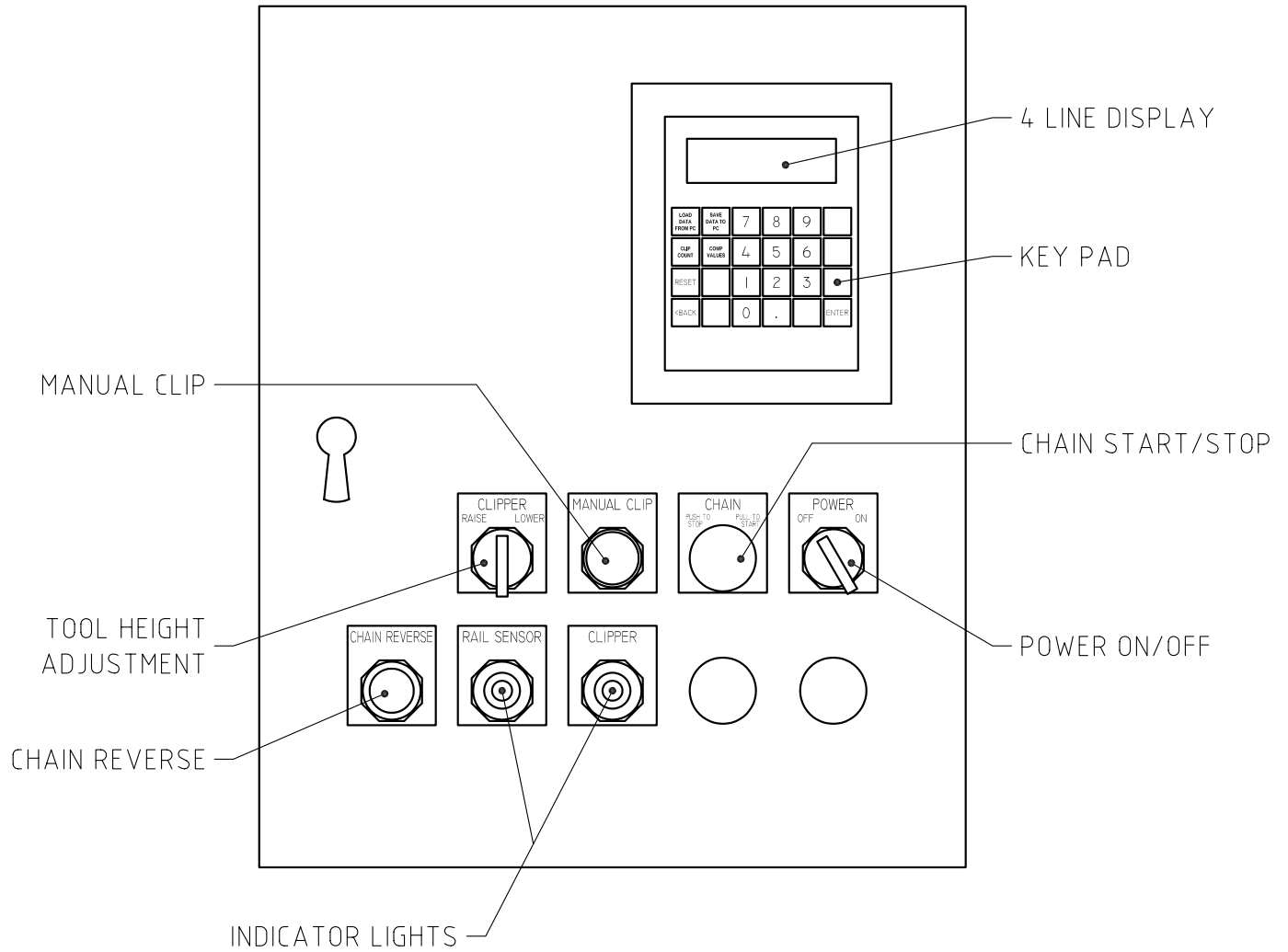


FIGURE 2.5

Programming

1. Using "POWER" selector switch (Fig. 2.5), turn machine "ON".
 - a. Welcome Screen will appear.

Welcome Screen

```
VERSACLIPPER 3000
Release xxx#####x
Vertex (847) 329-8530
Hit Any Key To Start
```

- b. Main Menu Screen will appear.
 - i. Main Menu is also shown when "RESET" is pressed.
 - ii. "MANUAL CLIP" and "CHAIN" are operational while Main Menu is visible.

Main Menu Screen

```
ENTER SELECTION:
1: RECALL SAVED RAIL
2: RUN RAIL 12345678
3: PROGRAM NEW RAIL
```

1) Running Preprogrammed Rails

- Press 1.

```
Input a Saved Rail
Number and Hit ENTER
```

- Enter desired rail number.

Program Start Screen

```
#XXXX: XX CLIPS
START CHAIN or RESET
P1 at XXX
To edit rail: hit 4
```


- 2) Continuing Current Program – used when production is interrupted or machine is turned off.
- Press 2.

Program Start Screen

```
#XXXX: XX CLIPS
START CHAIN or RESET
P1 at XXX
To edit rail: hit 4
```

- Continue clip installation using most recent program loaded.

3) Programming New Rail Patterns

- Press 3.

```
Input a RAIL Number
From 1-8 Digits Long
```

- Enter new rail number up to 8 digits long.
 - If number already exists, a warning message will appear.
 - You may overwrite existing program with new pattern.
 - New screen appears.

Rail Type Screen

```
STANDARD: hit 1
GROUP: hit 2
ODD: hit 3
GO BACK: hit RESET
```

Standard – equally spaced center clips with a maximum of three additional end rail intervals. (Fig. 2.7A)

Group – application of multiple clip groups per rail. (Fig. 2.7B)

A set interval within group and another set interval between groups.

Odd – unique spacing for every clip. (Fig. 2.7C)

- Select type of rail.

Screen will prompt operator for the clip intervals. Spacing is measured from center to center of clip. Operator will enter appropriate number, minimum of 2.00, followed by "ENTER." Operator need not enter trailing zeros. Example: 3 = 3.00, 7.5 = 7.50. When entering new values, you may use "<BACK" key to delete previous number entered on that screen. Once you begin entering a new rail, you must proceed through the screens to exit.

STANDARD RAIL

P1 = END OF RAIL TO CENTER OF 1ST CLIP

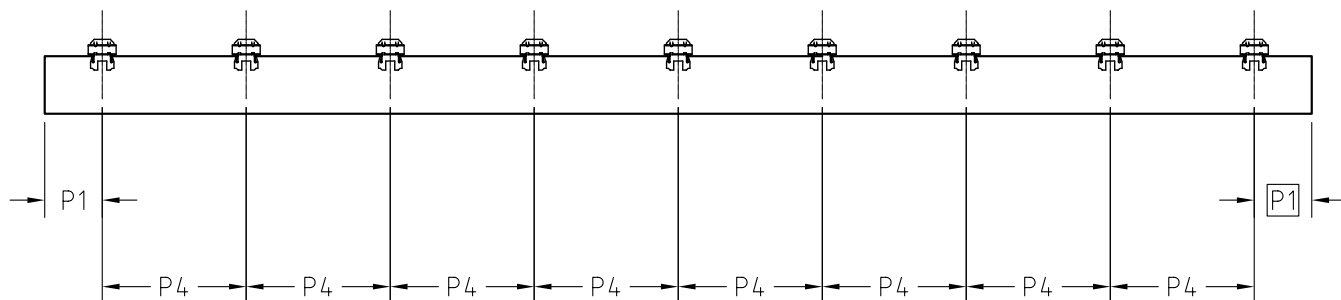
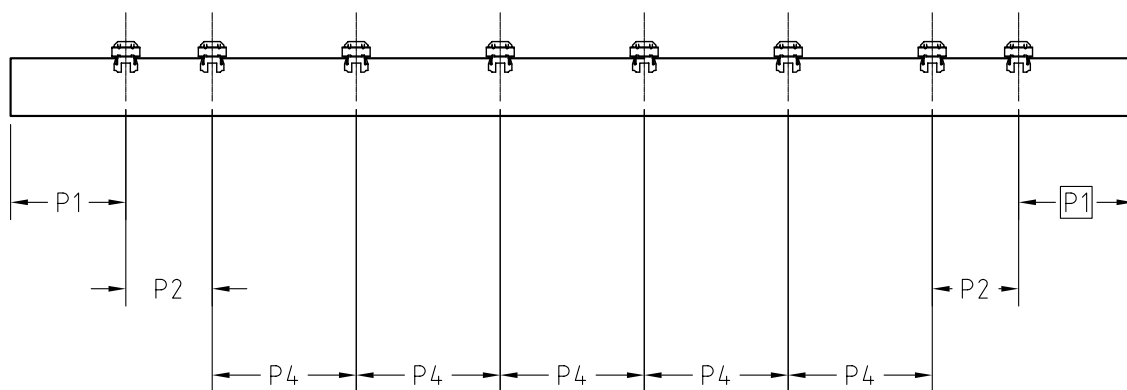
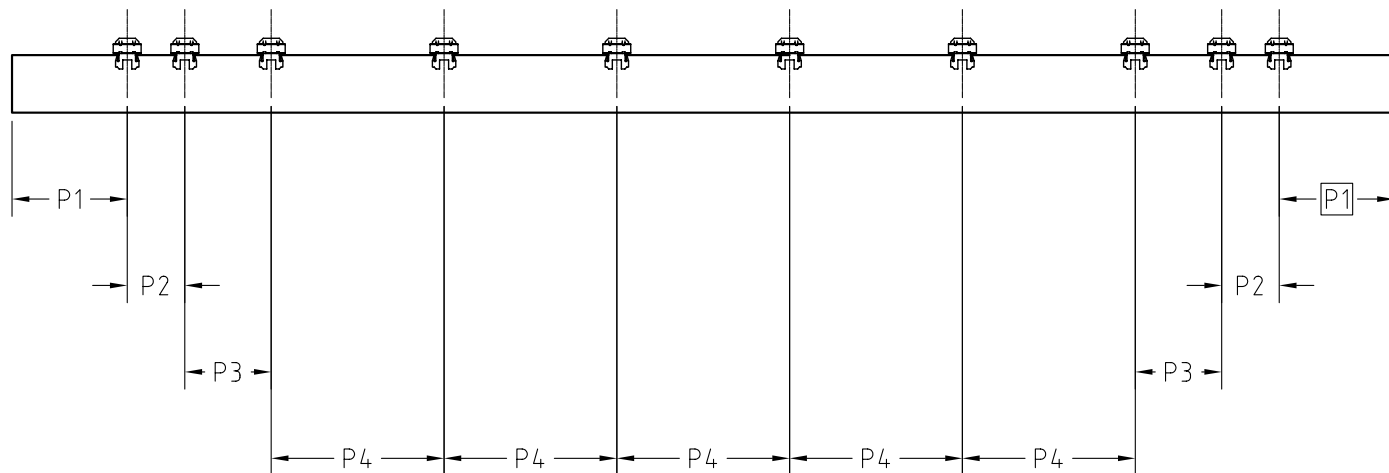
P2* = CENTER OF 1ST CLIP TO CENTER OF 2ND CLIP

P3* = CENTER OF 2ND CLIP TO CENTER OF 3RD CLIP

P4 = COMMON CENTER TO CENTER

P5 = TOTAL NUMBER OF CLIPS

* OPTIONAL



GROUP RAIL

P1 = END OF RAIL TO CENTER OF 1ST CLIP

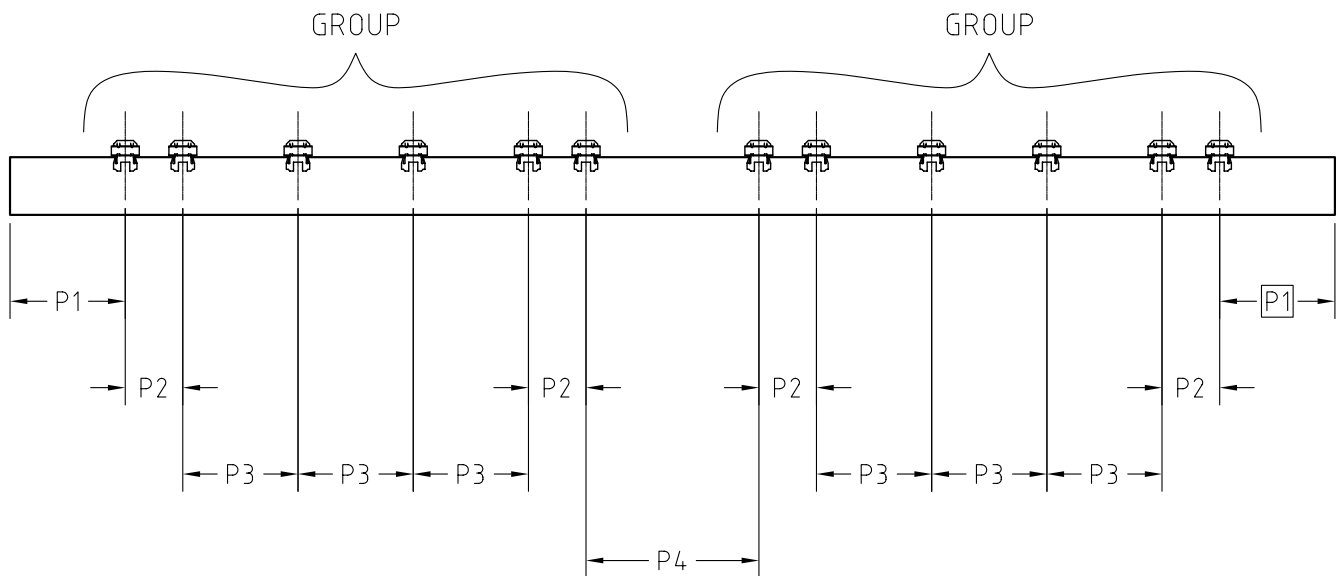
P2 = CENTER OF 1ST CLIP TO CENTER OF 2ND CLIP

P3 = CENTER TO CENTER IN GROUP

P4 = GROUP TO GROUP

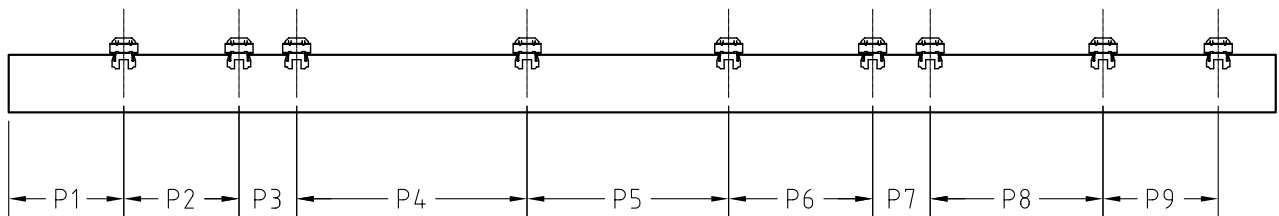
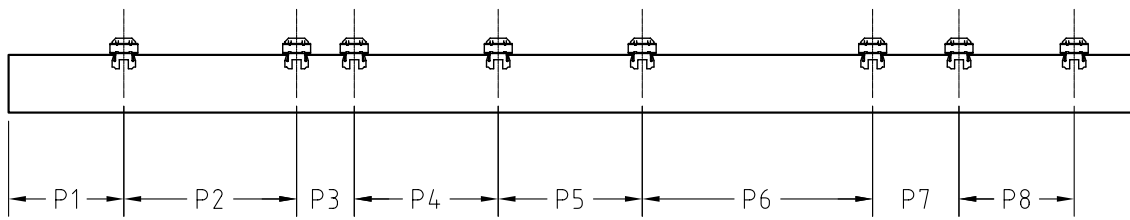
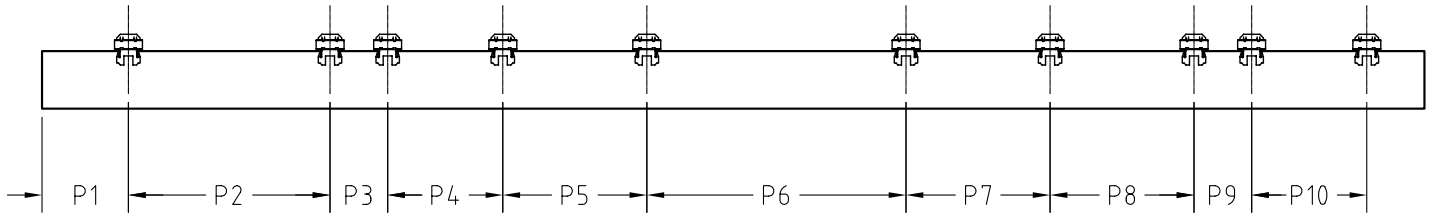
P5 = NUMBER OF CLIPS PER GROUP

P6 = NUMBER OF GROUPS



P1 LAST P1 WILL EQUAL 1ST P1 ONLY IF CUSTOMER CALCULATIONS ARE CORRECT.

ODD RAIL



- VERTEX VERSACLIPPER 3000 -

**-
SPREADSHEET RULES FOR CLIP SPACINGS**

The clip spacing spreadsheet in Microsoft Excel should be created with the following guidelines. Deviating from these guidelines will cause unexpected results and possible damage to the VersaClipper 3000.

1. Column headings must be labeled: NUMBER, TYPE, P1, P2, P3, P4, P5, P6.
Do not label additional columns.
2. NUMBER
 - a. Rail numbers cannot exceed 8 digits.
 - b. Use numbers only, no letters, decimals or symbols.
 - c. Do not use duplicate rail numbers.
 - d. 5,500 rail numbers max. (5,000 STANDARD & GROUP, 500 ODD)
3. TYPE
 - a. 1 = STANDARD spacing rail
 - b. 2 = GROUP spacing rail
 - c. 3 = ODD spacing rail.
4. P1 thru P4
 - a. Refer to manual to determine P1-P4 definitions.
 - b. 2 places to the right of the decimal maximum. Examples: 4 or 4.1 or 4.12
 - c. Minimum dimension = 2.00
5. P5 & P6
 - a. Refer to manual to determine P5 & P6 definitions.
 - b. Use whole numbers only. Examples: 7, 5, 14, 3
 - c. For STANDARD rails, P5 must not exceed 24
 - d. For GROUP rails, (P5 x P6) must not exceed 24
6. For ODD rails, enter the individual clip spacings – rules for P5 & P6 do not apply.
 - a. 24 individual clip spacings max. (Column Z)

Excel Spreadsheet Example:

NUMBER	TYPE	P1	P2	P3	P4	P5	P6						
22	1	5	0	0	4.25	7							
333	1	2.75	3	0	4.5	12							
3840	1	6	2.5	3.5	4	17							
876543	1	2.5	3	5.1	5.1	8							
123456	1	2.5	3	4	6	12							
1513540	2	2.75	3	3.75	3	7	2						
654321	2	4	3	4	3	9	2						
9	3	6.5	9	12	6								
55555	3	2.75	3	4.5	4.5	4.5	3	12	4				
81876542	3	10	3	3	3	12	4	4	4	4	4	4	3

Important: Save the rail data spreadsheet as a **CSV (comma delimited)** file.

- VERTEX VERSACLIPPER 3000 -

**PROCEDURE to
LOAD DATA FROM PC**

1. Start the program "*Hyper Terminal*" from laptop.
2. For 1st time use, follow steps 3-8, otherwise proceed to step 9.
3. Create "New Connection".
4. Enter Name: **VersaClipper 3000**
5. Select any Icon and click on "OK".
6. In the "Connect To" screen, pull down the "Connect using:" menu and select **COM1**. Click on "OK".
7. In the "COM1 Properties" screen, select:
 - Bits per second: **19200**
 - Data bits: **8**
 - Parity: **none**
 - Stop bits: **1**
 - Flow control: **hardware**
8. Click on "OK" then proceed to step 12.
9. Click on the "File" pull-down menu.
10. Select "Open..."
11. Double Click on VersaClipper 3000
12. From the "Transfer" pull-down menu, select "Send File..."
13. In the "Send File" screen enter the file name to send. Protocol: Xmodem
14. Click on "Send"
15. Connect DB-9 adapter (Vertex part #VC5780) and cable (#VH0428) from COM1 port on laptop to external port marked "PC" on left side of VersaClipper 3000 Control Box.
16. Depress the "LOAD DATA FROM PC" key on VersaClipper 3000 Control Box and follow instructions. Note: This procedure will erase all the rails in memory before the new data is loaded.
17. When the operation is complete, depress key 9 to confirm the number of rails loaded.

- VERTEX VERSACLIPPER 3000 -

**PROCEDURE to
SAVE DATA TO PC**

1. Start the program "*Hyper Terminal*" from laptop.
2. For 1st time use, follow steps 3-8, otherwise proceed to step 9.
3. Create "New Connection".
4. Enter Name: **VersaClipper 3000**
5. Select any Icon and click on "OK".
6. In the "Connect To" screen, pull down the "Connect using:" menu and select **COM1**. Click on "OK".
7. In the "COM1 Properties" screen, select:
 - Bits per second: **19200**
 - Data bits: **8**
 - Parity: **none**
 - Stop bits: **1**
 - Flow control: **hardware**
8. Click on "OK" then proceed to step 12.
9. Click on the "File" pull-down menu.
10. Select "Open..."
11. Double Click on VersaClipper 3000
12. From the "Transfer" pull-down menu, select "Receive File..."
13. In the "Receive File" screen click on "Receive" (If desired, you may change folder destination) Protocol: Xmodem.
14. In the "Receive Filename" screen, enter a filename. Examples: *raildata spacings 123* to be uploaded and click "OK".
15. Connect DB-9 adapter (Vertex part #VC5780) and cable (#VH0428) from COM1 port on PC to external port marked "PC" on left side of VersaClipper 3000 Control Box.
16. Depress the "SAVE DATA TO PC" key on VersaClipper 3000 Control Box and follow instructions.
17. When the operation is complete, you may open the uploaded file with Microsoft Excel.
18. When opening the file in Microsoft Excel, you will be prompted to format the file. Follow these steps:

Step 1. Select: Delimited
Start import at row: 1
File origin: Windows

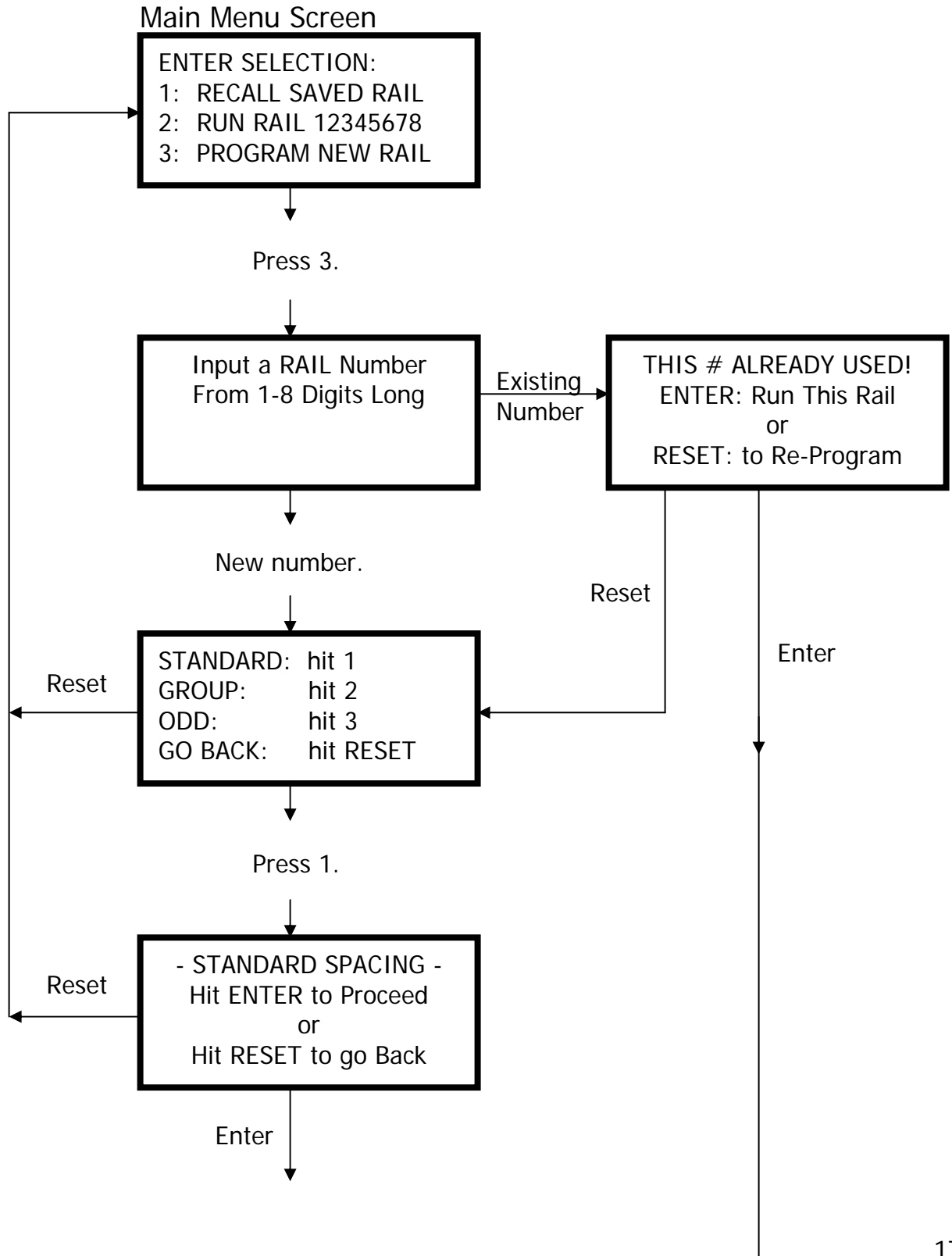
Step 2. Delimiters: Un-Check box next to *Tab*, Check box next to:
Comma, Space, Treat consecutive delimiters as one.

Step 3. Highlight “Number” Column in spreadsheet and check box marked “text” under *column data format*.
Click: Finished

19. Save file with new settings. **Save as type: CSV (Comma Delimited) !!!!!**

Programming a **Standard** rail

The default values for positions P2 and P3 are 0. If no change is necessary, the operator may continue by pressing, "ENTER." When entering "TOTAL CLIPS ON RAIL," this includes ALL clips.



END to 1st CLIP
ENTER P1: xx.xx

Enter number.

1st to 2nd CLIP
ENTER P2: xx.xx

(Optional)

Enter number or
press, "ENTER"

2nd to 3rd CLIP
ENTER P3: xx.xx

(Optional)

Enter number or
press, "ENTER"

EQUAL CENTER SPACING
ENTER P4: xx.xx

Enter number.

TOTAL CLIPS on RAIL:
ENTER P5:
Note: 24 CLIPS MAX



Once P5 is entered, a new screen is displayed.

Program Start Screen

#XXXX: XX CLIPS START CHAIN or RESET P1 at X.XX To edit rail: hit 4	(XX = P5)
--	-----------



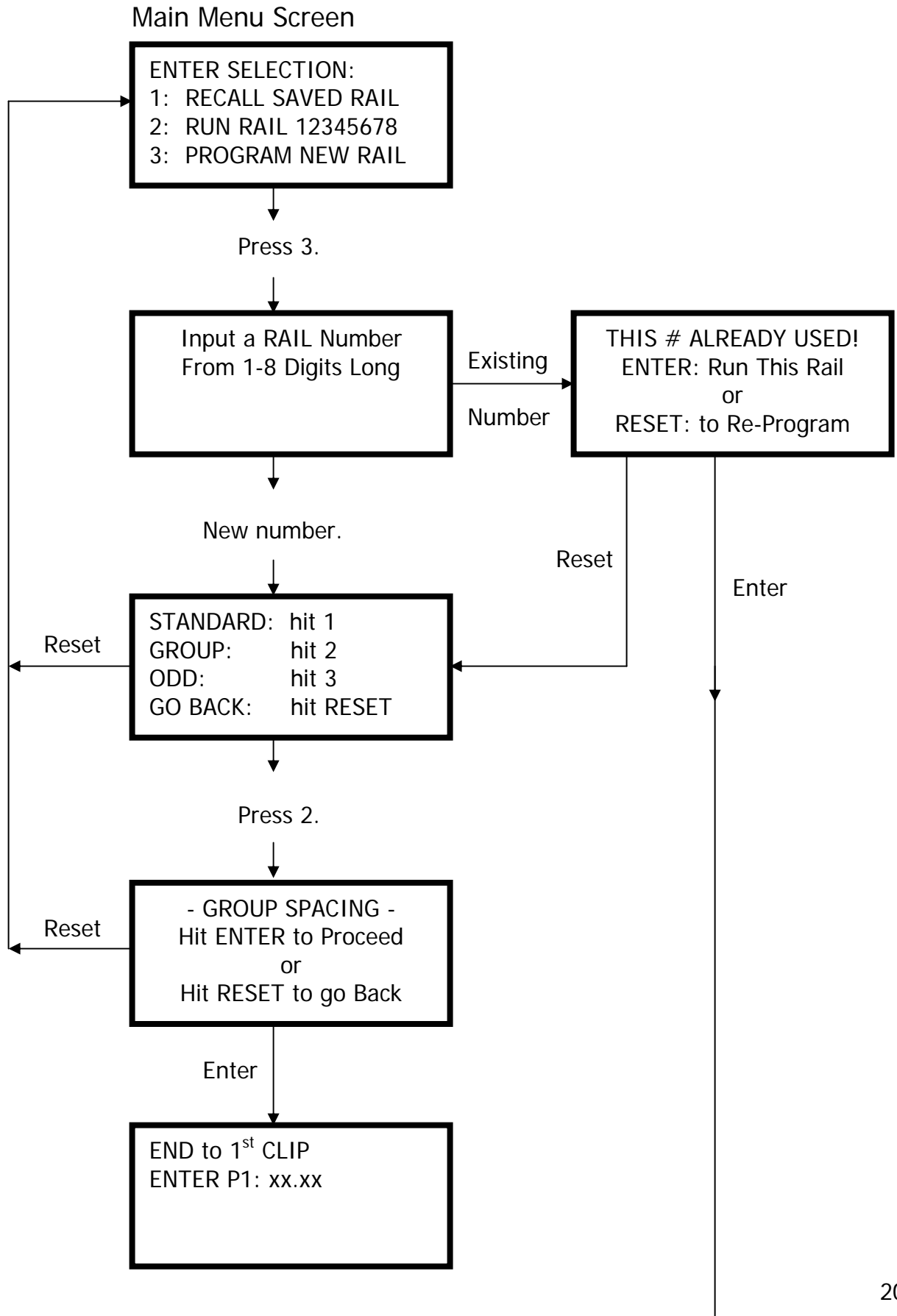
Should you choose to edit or review the rail please refer to page 26.

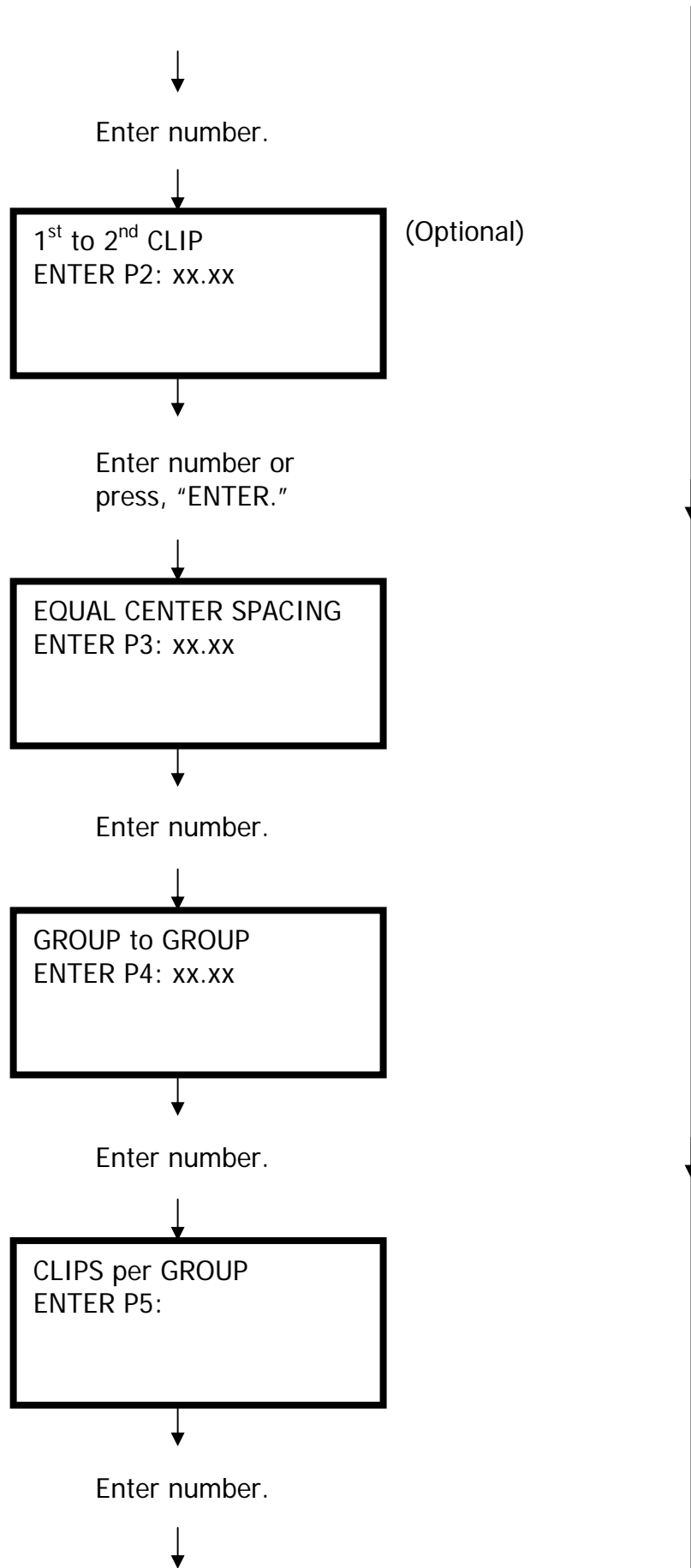
Program is now ready.

If clips and rails are loaded and tool height is set, pull the "CHAIN" knob (Fig. 2.5) to run rails. Otherwise, proceed with manual to continue machine setup.

Notes:

Programming a **Group** rail





NUMBER of GROUPS
ENTER P6:

Once P6 is entered, a new screen is displayed.

Program Start Screen

#XXXX: XX CLIPS
START CHAIN or RESET
P1 at X.XX
To edit rail: hit 4

(XX = P5 x P6)

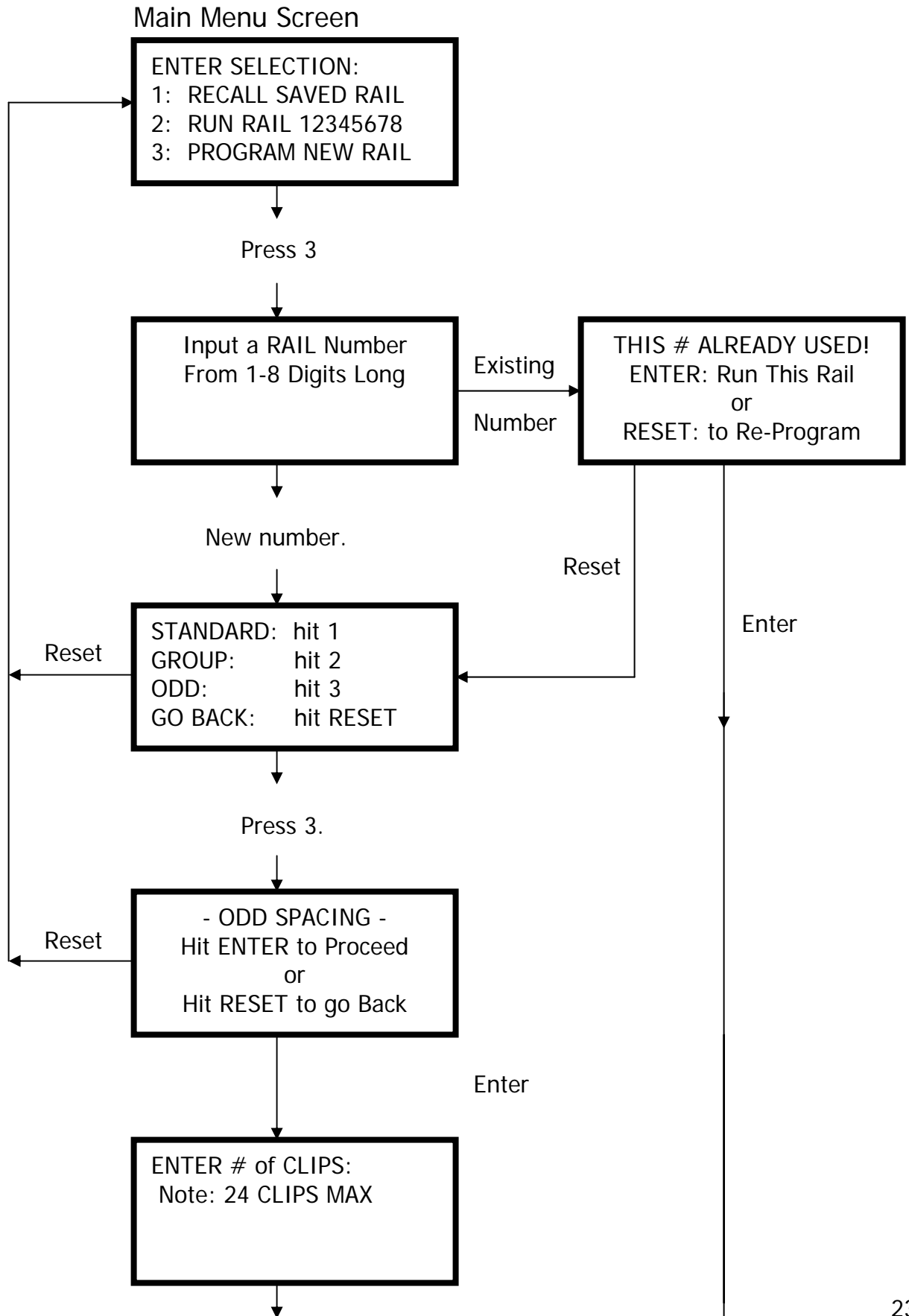
Should you choose to edit or review the rail please refer to page 26.

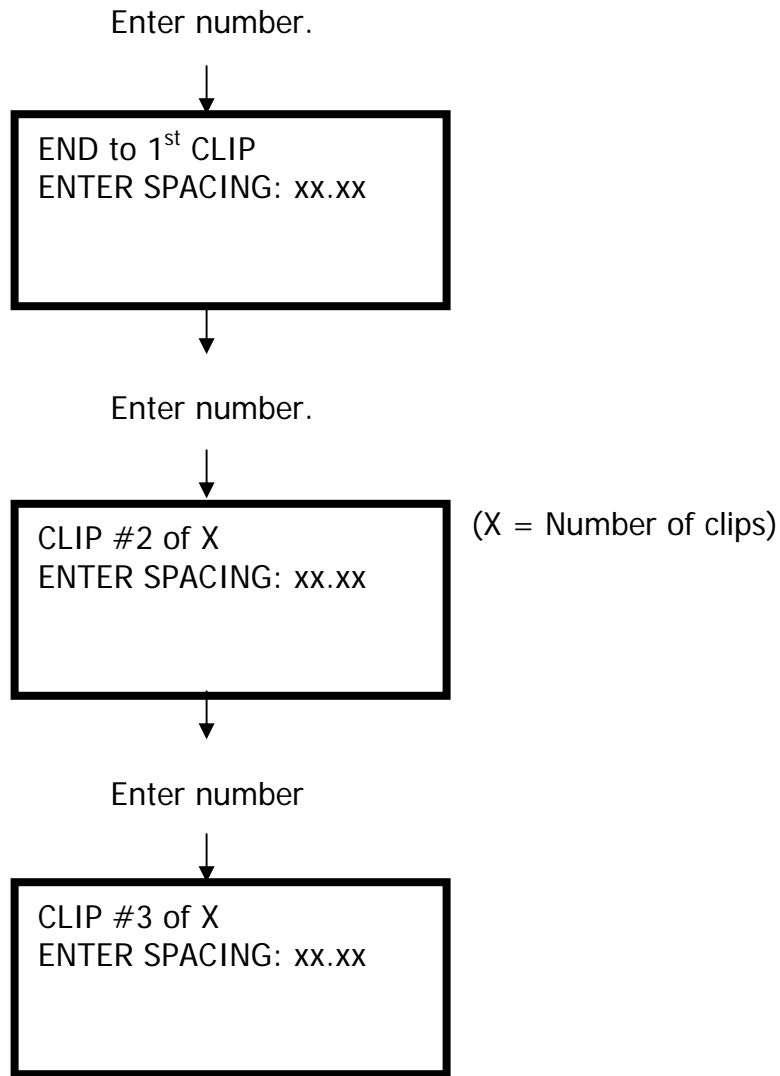
Program is now ready.

If clips and rails are loaded and tool height is set, pull the "CHAIN" knob (Fig. 2.5) to run rails. Otherwise, proceed with manual to continue machine setup.

Notes:

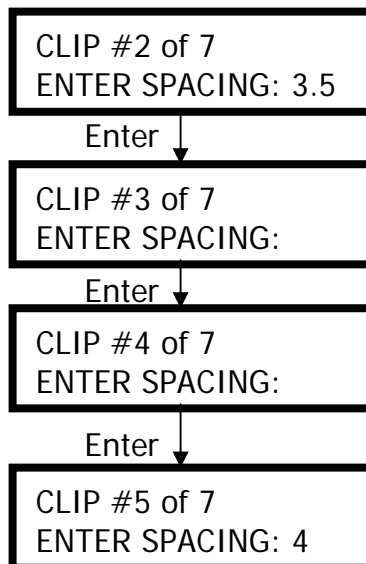
Programming an **Odd** rail





Repeats until all clips have been completed. Should a clip interval repeat itself in a row, the operator may hit "ENTER" to repeat the previous entry.

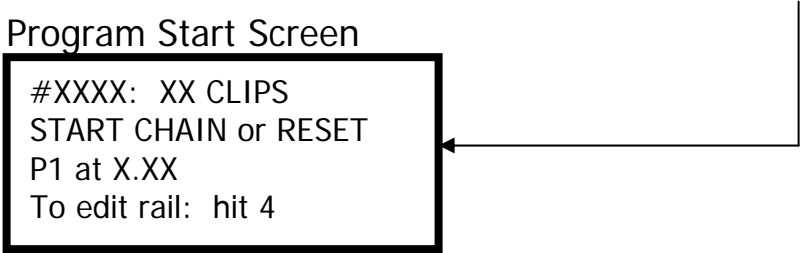
Example:



Clips 2, 3 and 4 will have the same spacing of 3.50 inches.

Once all clip spacing has been entered, a new screen is displayed.

Program Start Screen



```
#XXXX: XX CLIPS  
START CHAIN or RESET  
P1 at X.XX  
To edit rail: hit 4
```

Should you choose to edit or review the rail please refer to page 26.

Program is now ready.

If clips and rails are loaded and tool height is set, pull the "CHAIN" knob (Fig. 2.5) to run rails. Otherwise, proceed with manual to continue machine setup.

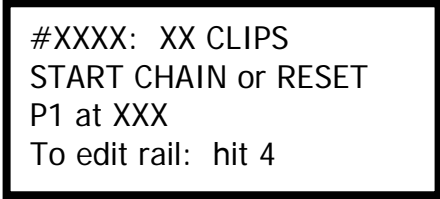
Notes:

Editing a Program

Used to review settings or alter previously set values. If a setting is correct, do not reenter the value, simply press, "ENTER" to continue.

Starting from the Program Start Screen.

Program Start Screen



```
#XXXX: XX CLIPS  
START CHAIN or RESET  
P1 at XXX  
To edit rail: hit 4
```

- Press 4.
 - Next screen shown will list the value entered for that particular program.
 - You may input a new value or press, "ENTER" to continue to the next clip setting.
 - Repeat this procedure for all settings.
 - Program Start Screen will reappear.

HIDDEN SCREENS

-accessible through the **Main Menu Screen**.

Contact Vertex 847-329-8530 for password.

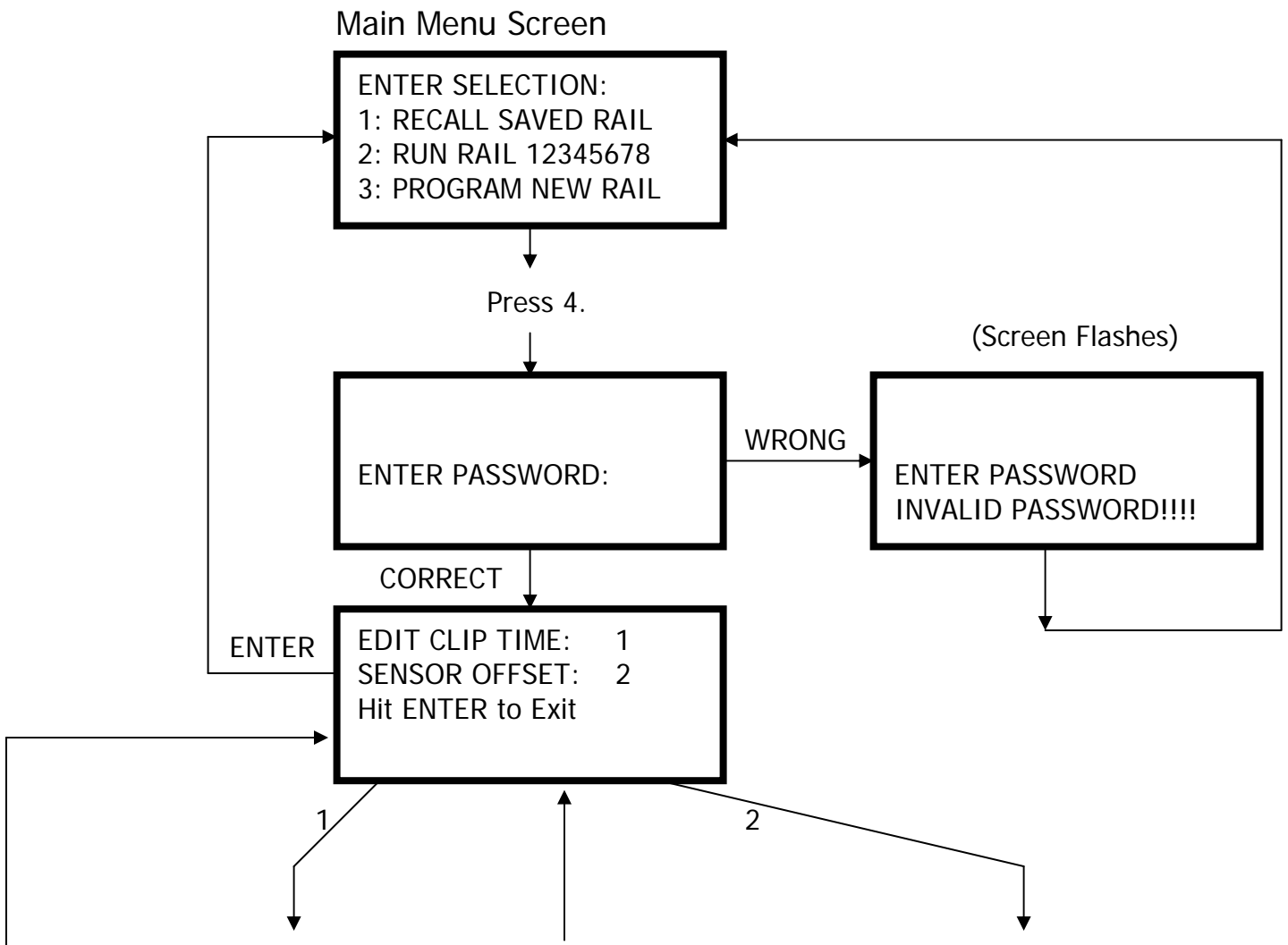
4 = Setup Screen – allows changes to be made to clipping parameters.

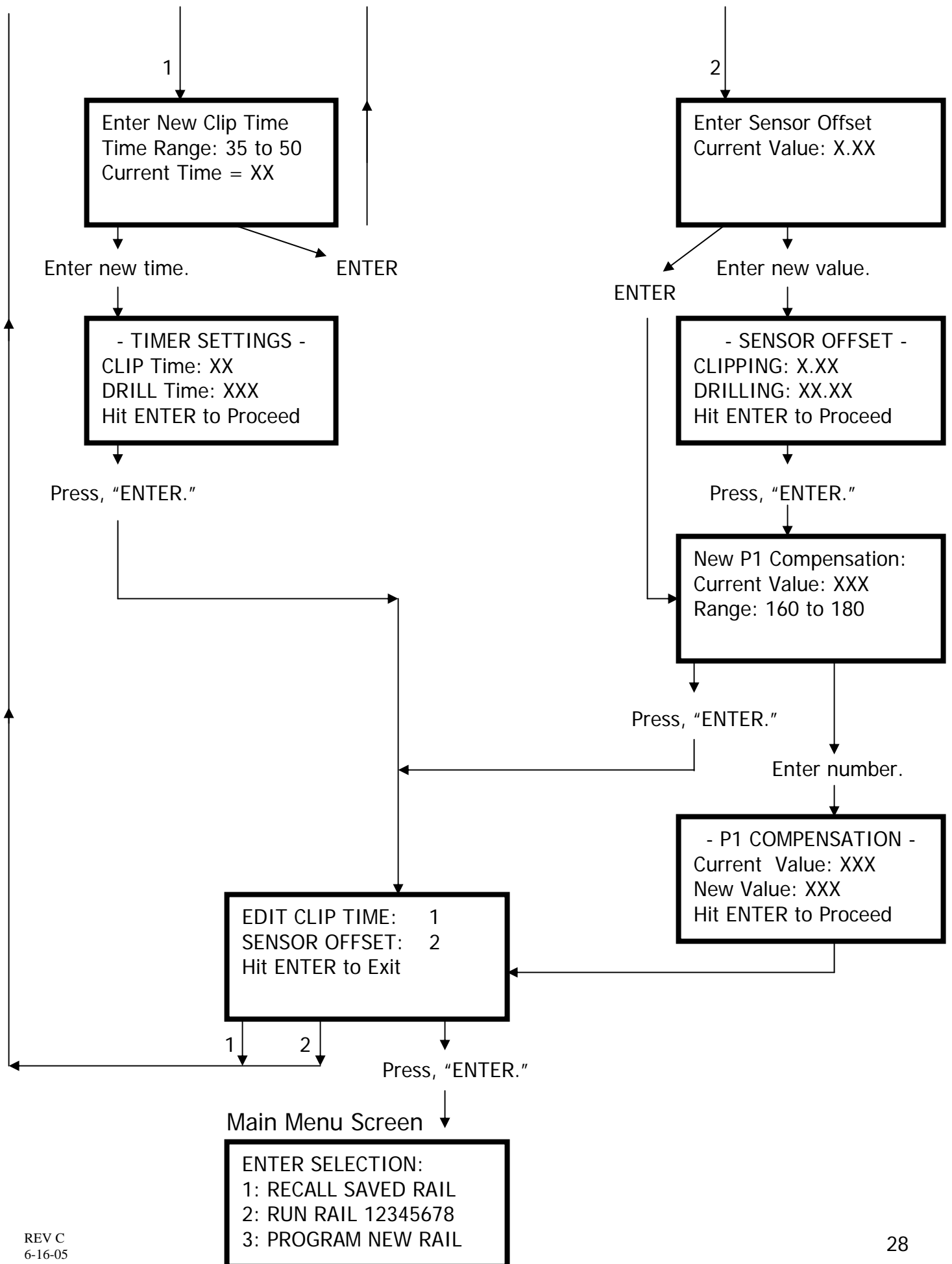
Disregard "DRILL Time" or "DRILLING" references.

Edit Clip Time – allows changes to be made to clip tool cycle time (default = 30).
Larger value = longer tool cycle, smaller value = shorter tool cycle.

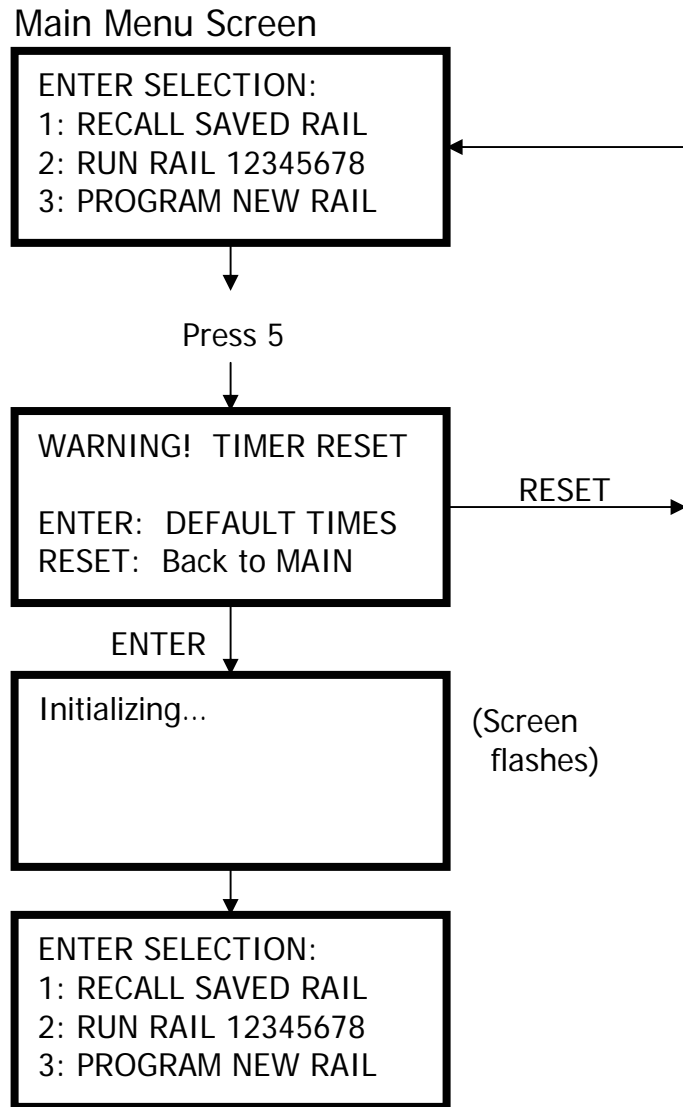
Sensor Offset – allows changes to be made to entire set of clips (default = 3.00).
If all clips are longer than their correct placement, decrease the sensor offset value. Increase the value if all clips are short of their correct placement.

P1 Compensation - allows changes to be made to 1ST clip offset (default = 176). Decrease if 1ST clip position is short of P1 setting. Increase if 1ST clip position is longer than P1 setting.



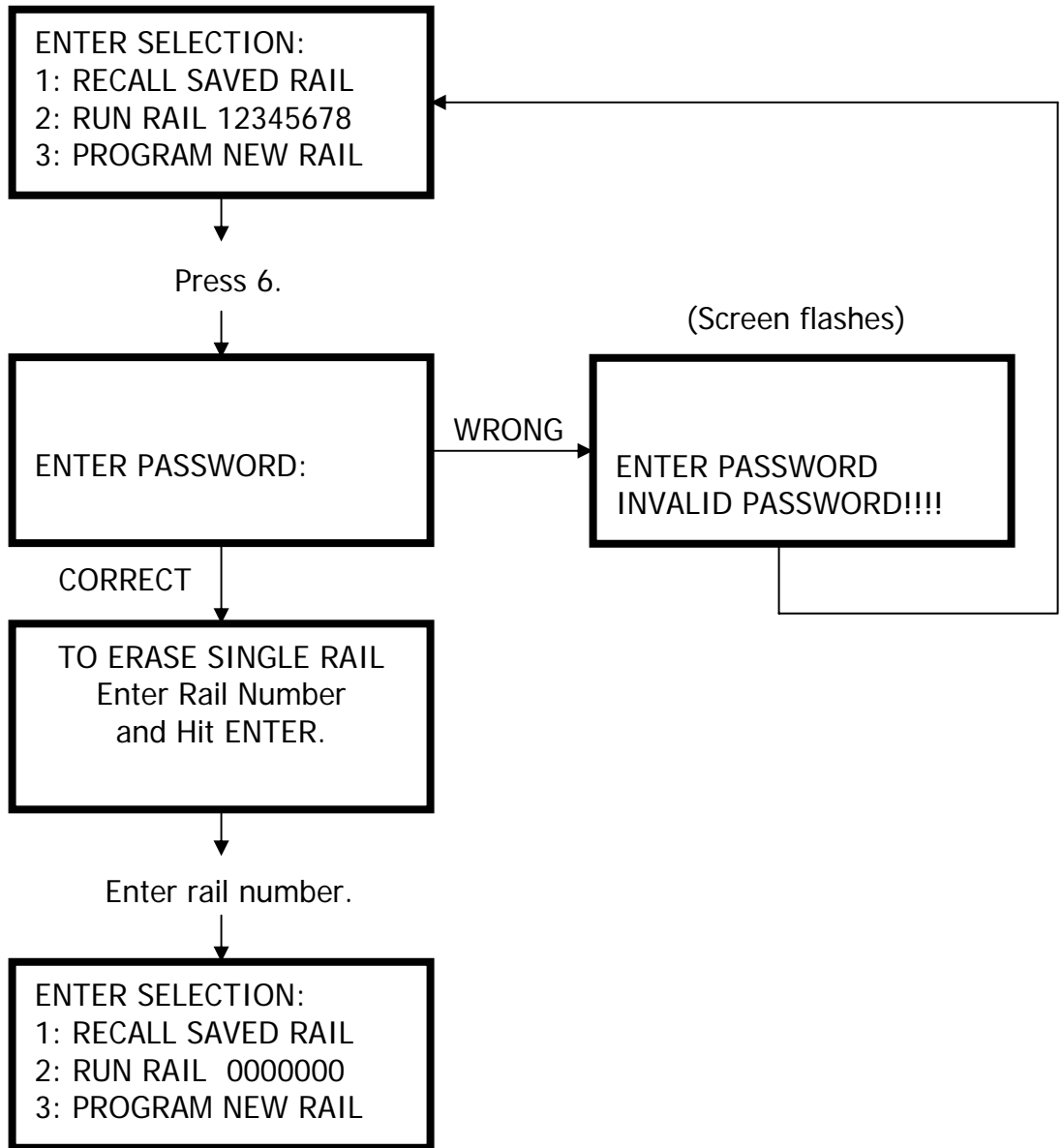


5 = Initialize Screen – reloads all initial settings (Clipping Time and Sensor Offset).



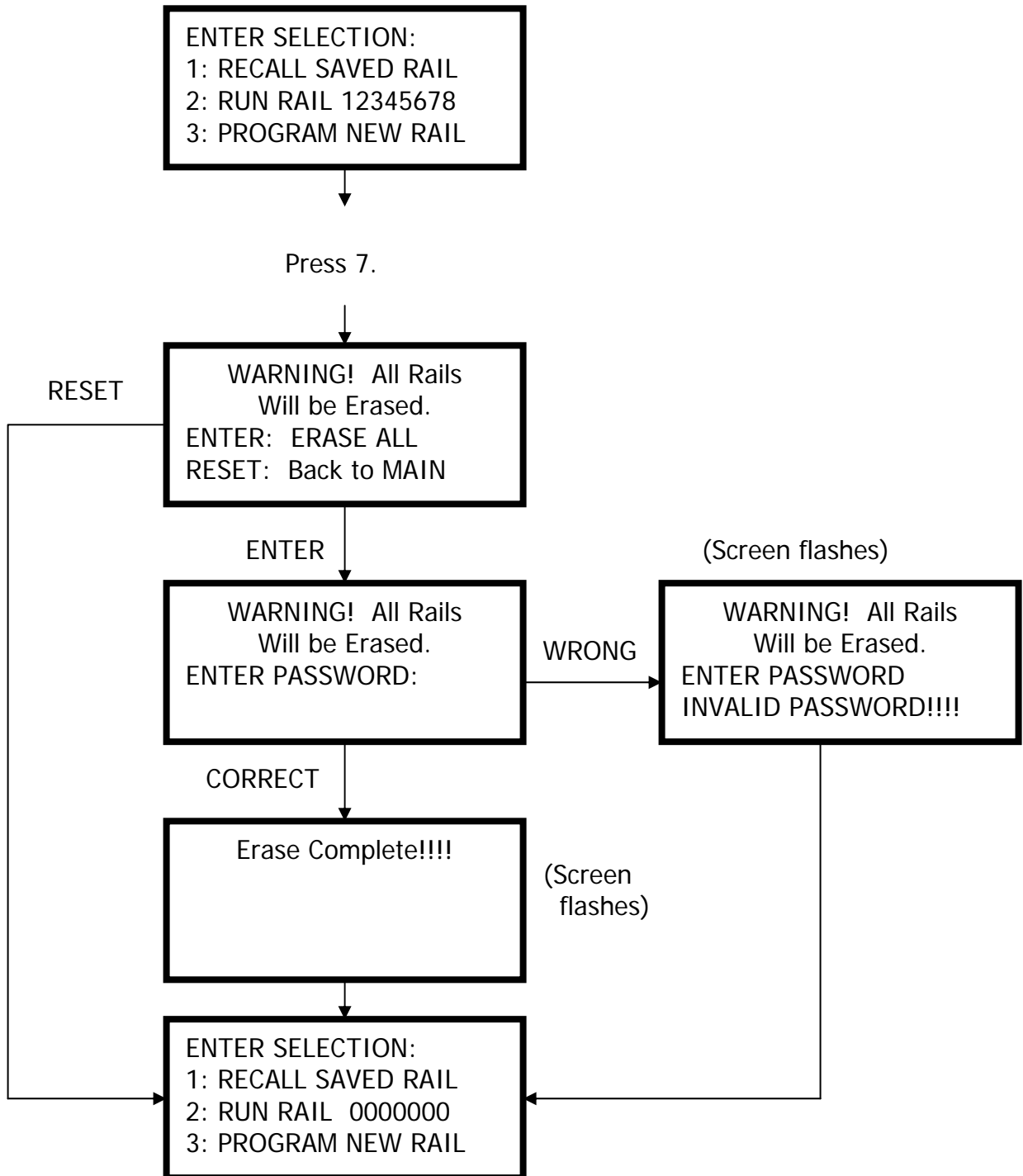
6 = Individual Erase – erases **INDIVIDUAL** rails from memory.
Contact Vertex 847-329-8530 for password.

Main Menu Screen



7 = Global Erase Screen – erases **ALL** rails from memory.
Contact Vertex 847-329-8530 for password.

Main Menu Screen



9 = Memory Allocation Screen – shows the quantity of rails in memory.

Main Menu Screen

ENTER SELECTION:
1: RECALL SAVED RAIL
2: RUN RAIL 12345678
3: PROGRAM NEW RAIL



Press 9.



XX STD/GROUP Rails
XX ODD Rails
MEMORY: XX.X% USED
Hit ENTER to Proceed



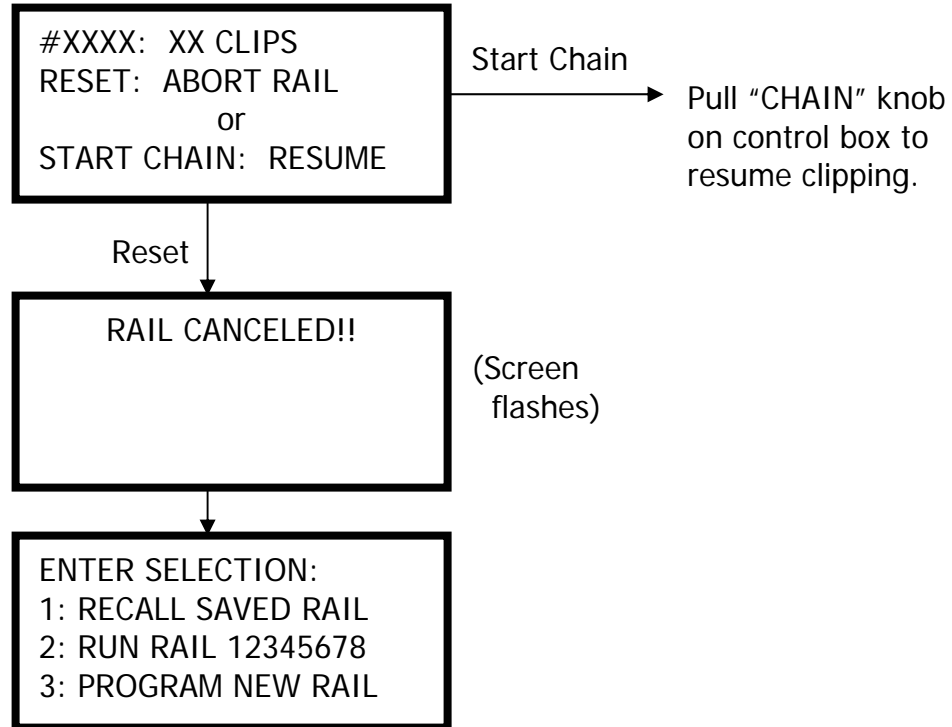
ENTER

ENTER SELECTION:
1: RECALL SAVED RAIL
2: RUN RAIL 12345678
3: PROGRAM NEW RAIL

Aborting a Rail

- interrupting a rail in mid clipping operation.

- Stop Chain.
- Screen appears.



Manual Clipping

- used to install individual clips without the use of a program or the chain.

- Push "CHAIN" knob (Fig. 2.5) to turn chain off.
- Line rail underneath clipping head of tool and flush against the back fence.
- Once the rail is positioned correctly and hands are away from the tool, press the "MANUAL CLIP" pushbutton (Fig. 2.5) on the control box.

Adjusting Tool Assembly Height

1. Turn "CLIPPER" selector lever (Fig. 2.5) counterclockwise to raise tool.
2. Place rail underneath tool fence (Fig. 2).
3. Turn "CLIPPER" selector lever clockwise to lower tool until height gauge pin contacts rail.

NEVER adjust tool height while chain is moving!!

Lug Placement

Divide chain length, 270 inches, by number of lugs you wish to use.

2 lugs → 135 inches

3 lugs → 90 inches

4 lugs → 67.5 inches

5 lugs → 54 inches

6 lugs → 45 inches

A 4-inch gap should be left between end of rail and following lug. To optimize machine efficiency, use the maximum number of lugs appropriate for your rail length. To figure the maximum possible lugs you can use, add 4 inches to the rail length you will be using. Then divide the chain length, 270 by this number; the answer will equal the maximum number of lugs you may fasten to the drive chain.

Example:

Rail length = 48 inches

$48 + 4 = 52$

$270 \div 52 = 5.019$

5 lug maximum on drive chain

Use chart above for equal distant lug placement on chain.

Applying Universal Lugs to Drive Chain

1. Twist front half of lug 90 degrees from rear half.
2. Insert pegs of rear half into chain.
3. Holding rear half in place, pull lug apart.
4. Twist front half back 90 degrees.
5. Insert pegs into chain.

Applying Flip-up Lugs to Drive Chain

1. Unscrew from chain.
2. Re-position and tighten screws.
 - a. Do not position on Master Link.

Jammed Lugs

Should a lug become caught underneath a rail, follow this procedure.

1. Press, "CHAIN" knob (Fig. 2.5) to stop chain.
2. Press, "CHAIN REVERSE" button until jammed lug is cleared.
3. Program will reset.

Fence Position

1. Place stack of rails against rear fence.
2. Loosen knobs on front fence.
3. Slide front fence against stack, back off 1/8" and tighten knobs.

- a. Correct location for front fence allows rails to drop freely onto (fence track) machine top.
4. Tighten knobs.

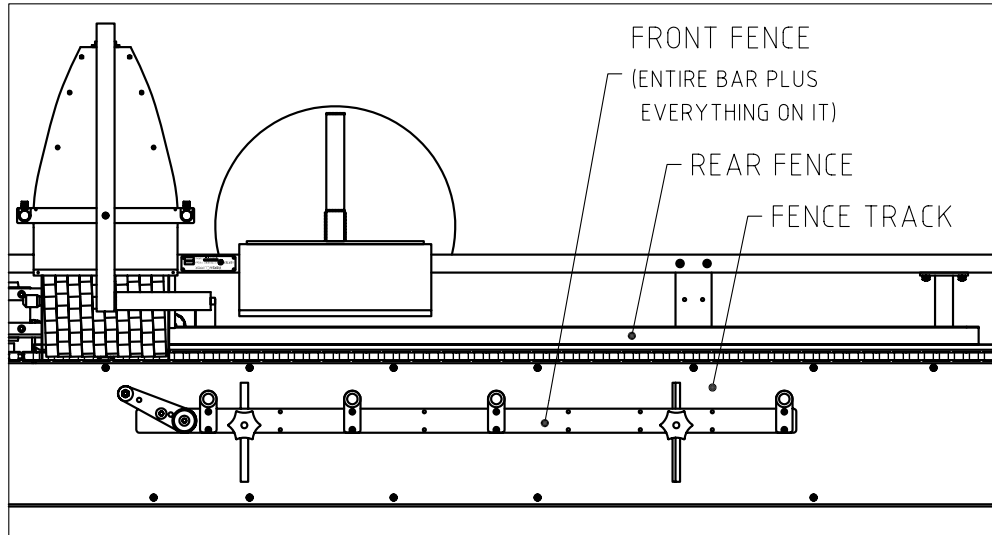


FIGURE 2.95
(TOP VIEW)

Set air pressure between 80 – 100 psi for proper operation of the VersaClipper 3000. After the required adjustments have been made, the program set and the clips and rails have been loaded you may begin production.

1. Start chain.
2. Continue to load rails as needed.

SAFETY INSTRUCTIONS

1. Operators should ALWAYS wear safety glasses while operating, maintaining or repairing the equipment.
2. NEVER place hands or fingers near clip exit area when operating tool or when connecting air supply to machine.
3. Always shut off air supply when servicing tool.

MAINTENANCE

Recommended Daily Maintenance

1. Using supplied air gun, blow off woodchips and debris from Tool, Rail Trigger and acme rod/tool height motor area.
2. Add 2-3 drops of 30 weight oil to opening between front plate and top of blade of Tool assembly.

Recommended Weekly Maintenance

1. Drain Reservoir Tank for condensation.
2. Remove air hose from Clip Feed Cylinder, add 2-3 drops of 30 weight oil to opening, reinstall hose.

Recommended Monthly Maintenance

Remove front plate from tool and lubricate driver blade, front plate and top plate.

**VERSACLIPPER 3000
RECOMMENDED SPARE PARTS LIST**

PART #	DESCRIPTION	QTY
VC0009	ROLLER	1
VC0011	LINK	2
VC0340	AIR LUBE OIL	1
VC5102	TOP PLATE	1
VC5113	FRONT PLATE	1
VC5117	TORSION SPRING	1
VC5118	LINK PIN	2
VC5121	PAWL SPRING	2
VC5122	LEFT-HAND PAWL	1
VC5123	RIGHT-HAND PAWL	1
VC5127	PISTON FEED SPRING	2
VC5132	PIN, FEED CYLINDER	1
VH0030	O-RING, #111	2
VH0069	PUSH-IN FTG, 90 DEG	2
VH0135	O-RING, #210	2
VH0398	NO/NC CONTACT BLOCK	1
VH0531	HAIR PIN	1

TROUBLESHOOTING INFORMATION

PROBLEM	CAUSE	SOLUTION
Blade does not return.	Obstruction in tool.	Remove obstruction.
Clips not feeding.	Dispenser obstruction. Feed cylinder not engaged.	Remove obstruction. Engage by lifting up cylinder allowing flag to drop (Fig. 1).
Top of clip not seated against rail (Fig. 3).	Low air pressure. Incorrect tool height.	Increase pressure. (Never exceed 100 psi) Lower tool.
Clip's base is away from rail (Fig. 4).	The board is warped. Rail is not against rear fence.	Operator must adjust front fence closer to rear fence.
Incorrect clip spacing.	Program is set inaccurately.	Edit program to correct interval.
Clip driven too far into rail.	Air pressure too high.	Reduce air pressure.
First clip too long.	P1 compensation wrong.	See Page 27, P1 compensation.
First clip too short.	P1 compensation wrong.	See Page 27, P1 compensation.
Machine locked up.	Logic confused.	Reset Function 5 (Page 29)
Rail sensor light "ON" continuously.	Obstruction in sensor arm	Remove obstruction.
Rail sensor light never on.	Sensor Arm loose.	Readjust and tighten arm.
Chain will not run.	Circuit Breaker tripped.	Reset Breaker.

FIGURE 3

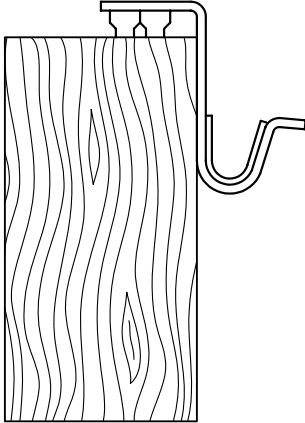
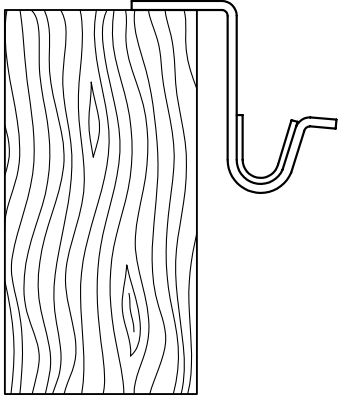


FIGURE 4



Specifications

Power: 120 VAC, 50/60 Hz, 1 \emptyset , 15 amps
Contact Vertex Fasteners for other power options.

Air: 80–100 psi, 6 cfm

Machine Size: Length: 16' 6 5/8"
Width: Footprint = 33", Overall 54"
Height: 72"
Weight: 500 lbs

Chain Speed: 72' per Minute

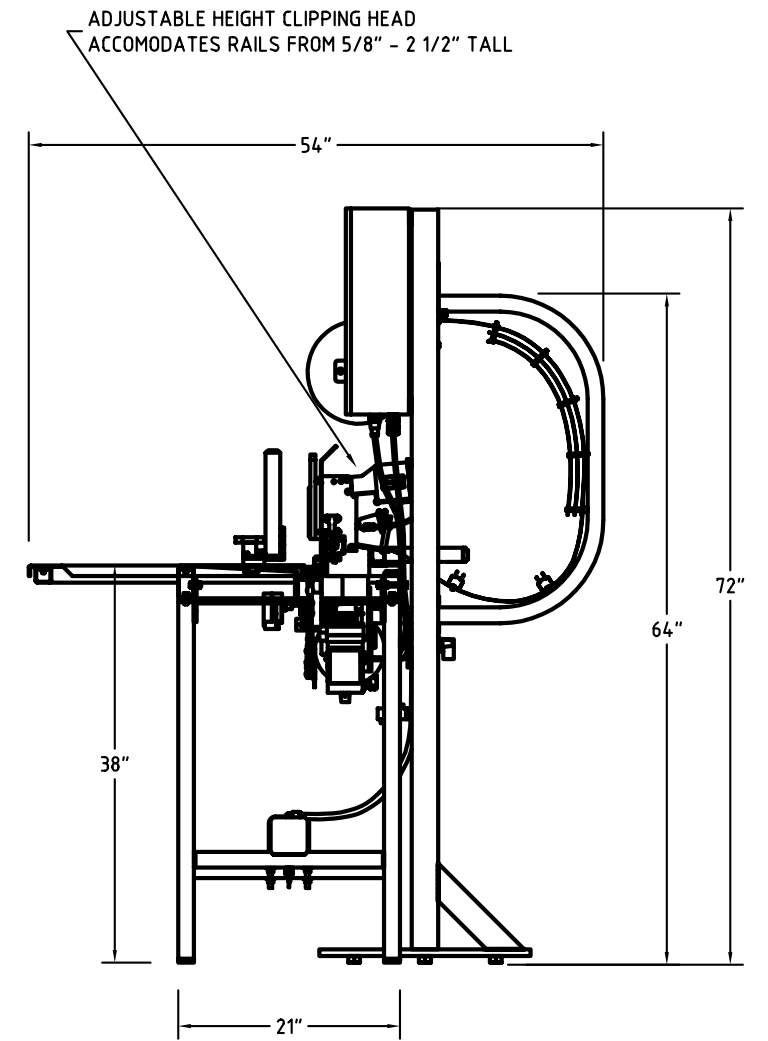
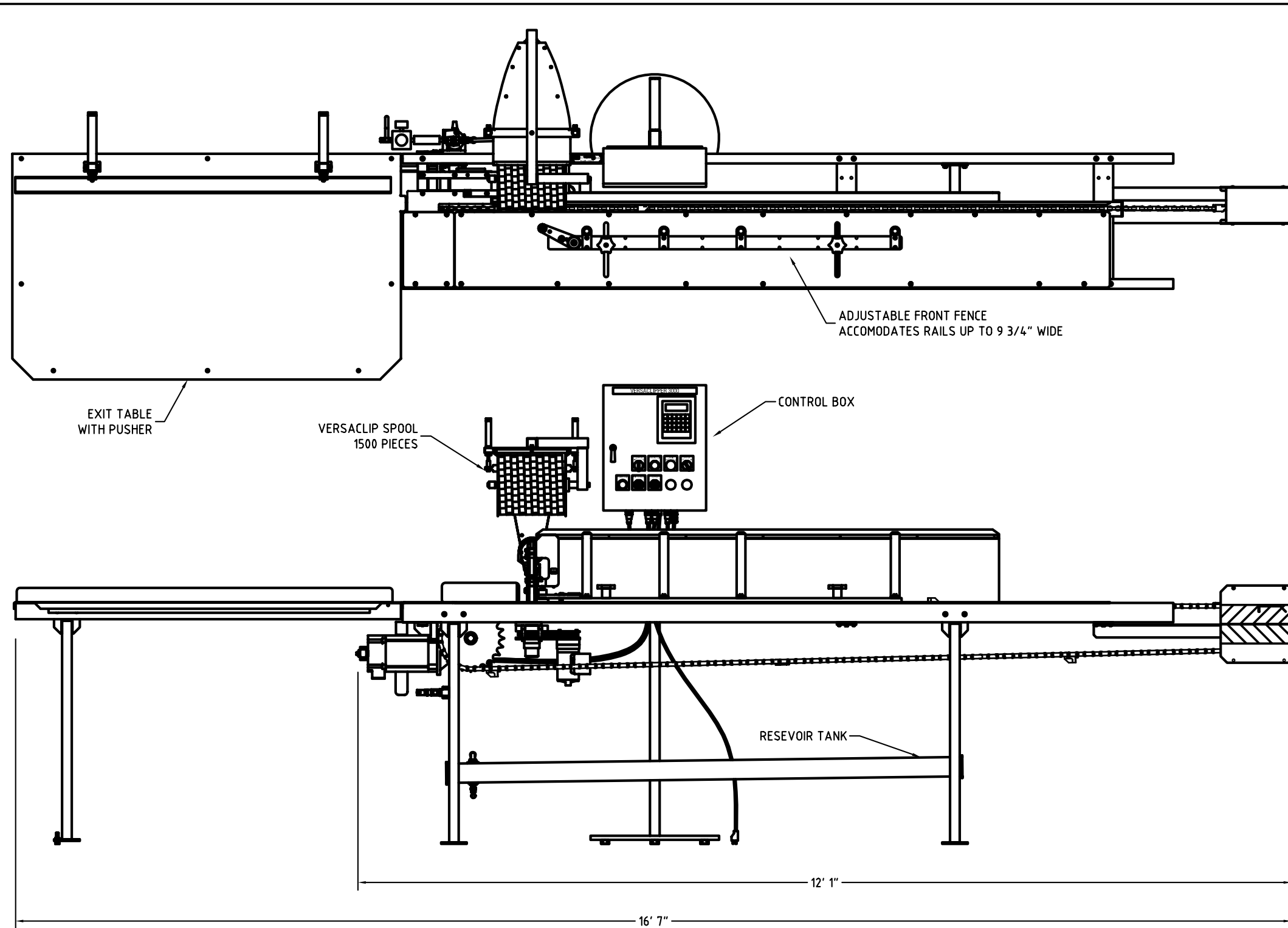
Rail Dimensions: Height: 5/8" – 2 1/2"
Width: 5/8" – 9 3/4"
Length: 84" Maximum

Rail Memory Storage Space: 5,000 Standard/Group Rails
500 Odd Rails

Clips per Rail: 24 Clips Maximum
1 Clip Minimum

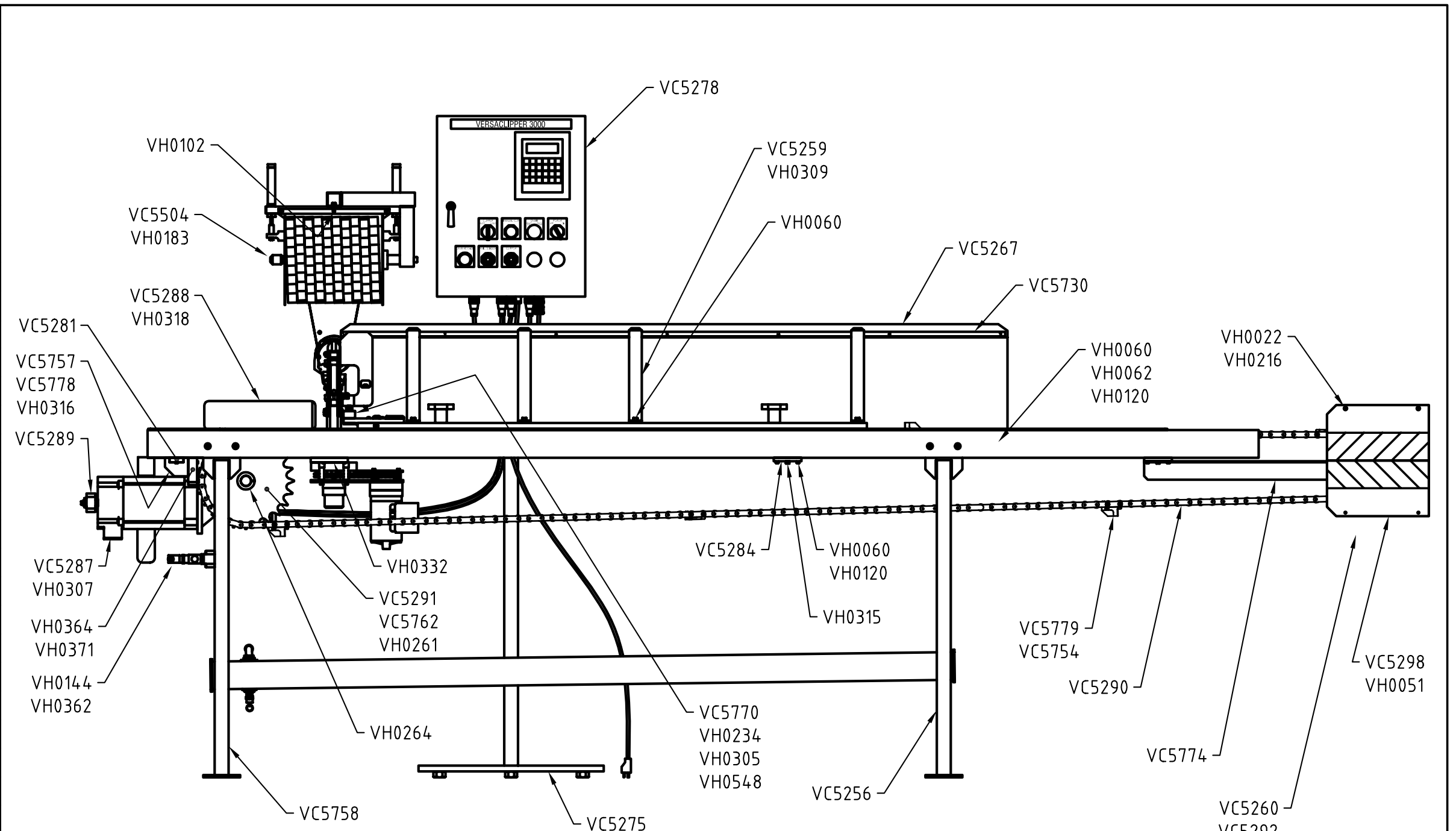
Clipping Speed: 3,000-4,000 per Hour

Clip Dispenser Capacity: 1,500 VersaClips



REV	DESCRIPTION	BY	APPD	DATE	MATERIAL:	© 2001	VERTEX FASTENERS INC. 3714 JARVIS AVENUE SKOKIE, IL 60076 U.S.A. VersaClipper 3000
A		JMW		1-23-01	-	DWN BY JMW	
B	UPDATE	JMW		8-15-01	HEAT TREATMENT:	APPD DA	
C	UPDATE	JMW		4-29-02	-	DATE 1-23-01	
D	ECN 404	JMW	DA	9-9-04	FINISH:	SCALE NONE	
					-	DWG. NO. VC5002	B

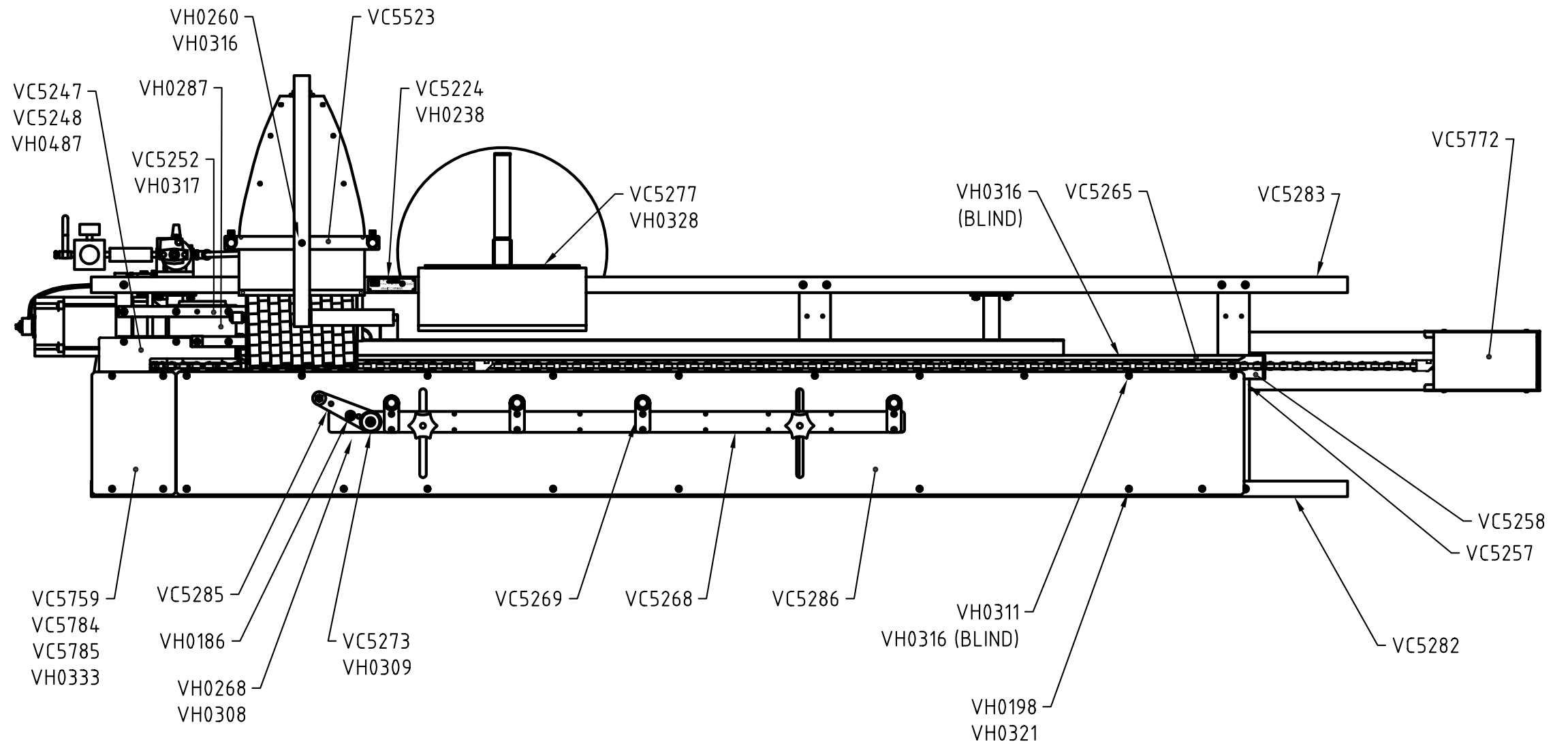
PART #	DESCRIPTION	QTY
VC5256	LEG ASSEMBLY	1
VC5259	FENCE POST	4
VC5260	IDLER SPROCKET RACE	1
VC5267	REAR FENCE	1
VC5275	CONTROL STAND	1
VC5278	CONTROL BOX ASSEMBLY	1
VC5281	STRUT (NARROW)	1
VC5284	STRUT	1
VC5287	MOTOR	1
VC5288	EXIT GUIDE PLATE	1
VC5289	ENCODER	1
VC5290	DRIVE CHAIN	1
VC5291	DRIVE SPROCKET	1
VC5292	IDLER SPROCKET	1
VC5298	SPROCKET GUARD	2
VC5504	SPOOL ROD	1
VC5730	RAIL FENCE TAPE MEASURE	1
VC5754	LUG ASSEMBLY	3
VC5757	SWITCH PLATE LATCH	1
VC5758	LEG ASSEMBLY W/ REG. BLOCK	1
VC5762	MACHINE KEY	1
VC5770	SPACER	1
VC5774	IDLER SPROCKET BRKT ASSY	1
VC5778	SWITCH PLATE	1
VC5779	FLIP-UP LUG ASSEMBLY	3
VH0022	BHCS 10 - 32 x 1/2	4
VH0051	SHCS 10 - 32 x 1/2	4
VH0060	SHCS, 5/16 - 18 x 3/4	30



VH0062	NUT, 5/16 - 18	8	VH0307	MACHINE KEY	1
VH0102	BHCS, 8 - 32 x 3/8 w/ LKG PATCH	3	VH0309	FHCS 1/2 - 13 x 1 1/4	4
VH0120	LOCK WASHER, 5/16	20	VH0315	SHCS 1/4 - 20 x 3	4
VH0144	SHCS, 10 - 32 x 1	2	VH0316	SHCS 1/4 - 20 x 3/4	2
VH0183	SHCS, 3/8 - 16 x 3/4	1	VH0318	SHCS 3/8 - 16 x 4	2
VH0216	FLEX LOCK NUT 10 - 32	4	VH0332	SHCS 1/4 - 20 x 2 3/4	2
VH0234	FLEX LOCK NUT 3/8 - 16	1	VH0362	MAC VALVE	1
VH0261	SET SCREW 3/8 - 16 x 1	1	VH0364	SWITCH, COIL SPRING	1
VH0264	SPLIT COLLAR 1 1/8	1	VH0371	SHCS 6 - 32 x 1 1/4	2
VH0305	CAM ROLLER	1	VH0548	FHCS 3/8 - 16 x 2	1

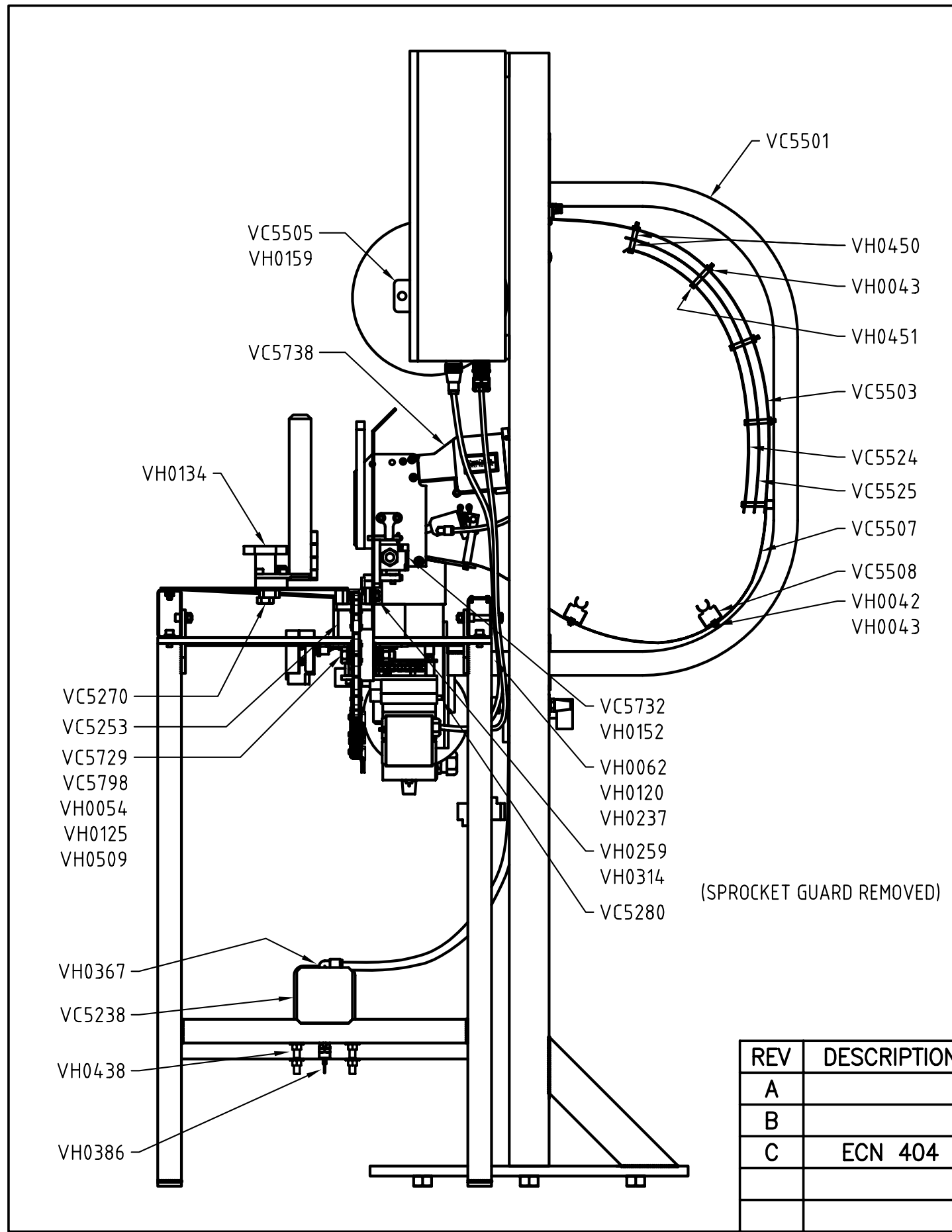
REV	DESCRIPTION	BY	APPD	DATE	MATERIAL:	© 2000	VERTEX FASTENERS INC. 3714 JARVIS AVENUE SKOKIE, IL 60076 U.S.A. FRONT FRAME DETAIL
A		JMW		4-2-01	-	DWN BY JMW	
B		JMW		4-8-02	HEAT TREATMENT:	APPD DA	
C	ECN 404	JMW	DA	8-30-04	-	DATE 4-2-01	
					FINISH:	SCALE NONE	
					-	DWG. NO. VC5733	B

PART #	DESCRIPTION	QTY
VC5224	VC NAME PLATE	1
VC5247	SPACER - EXTENSION PLATE	2
VC5248	EXTENSION PLATE	1
VC5252	MOTOR MOUNT	2
VC5257	FRONT CHAIN RAIL	1
VC5258	CHAIN SUPPORT RAIL	1
VC5265	REAR CHAIN RAIL	1
VC5268	FENCE MOUNT	1
VC5269	EXTENSION LUG	4
VC5273	PIVOT BUSHING	1
VC5277	CONTROL BOX MOUNTING STRAP	2
VC5282	FRONT RAIL	1
VC5283	REAR RAIL	1
VC5285	ARM	1
VC5286	FENCE TRACK	1
VC5523	CLIP LIFTER ASSEMBLY	1
VC5759	FENCE TRACK EXTENSION	1
VC5772	SPROCKET GUARD COVER	1
VC5784	SPACER FOR EXTENSION	1
VC5785	MOUNT FOR EXTENSION	1
VH0186	BHCS 1/2 - 13 x 1	1
VH0198	FHCS 1/4 - 20 x 3/4	10
VH0238	DRIVE SCREW #4 x 5/16	4
VH0260	LOCKWASHER 1/4	1
VH0268	PUSHER ARM SPRING	1
VH0287	GEAR BOX	1
VH0308	SET SCREW 1/2 - 13 x 3/8	1
VH0309	FHCS 1/2 - 13 x 1 1/4	1
VH0311	FHCS 1/4 - 20 x 3/8	12
VH0316	SHCS 1/4 - 20 x 3/4	13
VH0317	SHCS 3/8 - 16 x 1	6
VH0321	1/4-20 HVY HEX NUT, 1/2 ACRS FLTS	10
VH0328	SHCS 5/16 - 18 x 1/2	6
VH0333	SHCS 5/16 - 18 x 1	2
VH0487	SHCS 3/8 - 16 x 3	2



REV	DESCRIPTION	BY	APPD	DATE	MATERIAL:	© 2000	VERTEX FASTENERS INC.
A		JMW		7-13-01	-	DWN BY	3714 JARVIS AVENUE
B		JMW		4-29-02	HEAT TREATMENT:	APPD DA	SKOKIE, IL 60076 U.S.A.
C	ECN 404	JMW	DA	8-30-04	-	DATE	TOP FRAME
					FINISH:	SCALE	DETAIL
					-	DWG. NO.	

DWG. NO. VC5734 B

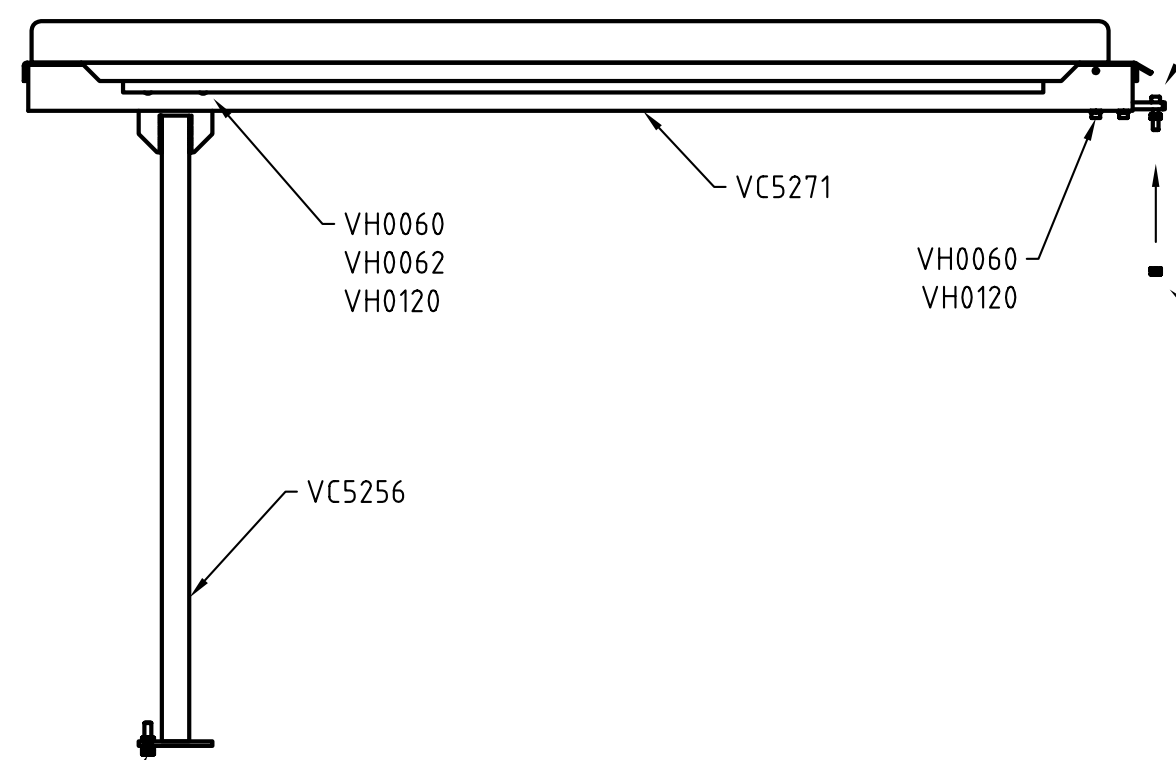
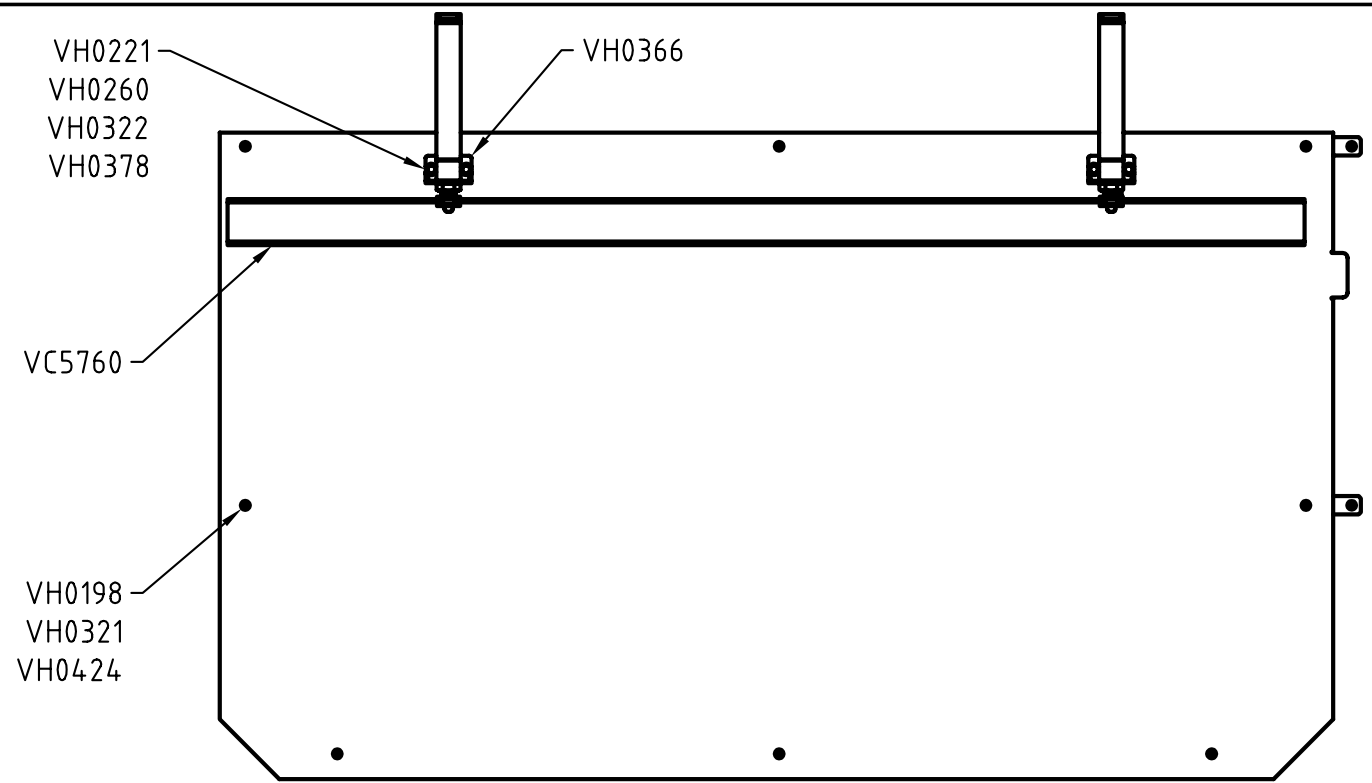


PART #	DESCRIPTION	QTY
VC5238	AIR TANK	1
VC5253	RISER	3
VC5270	CLAMP BAR	1
VC5280	TOOL POST	1
VC5501	DISPENSER FRAME	1
VC5503	CLIP CHUTE	1
VC5505	MAGNETIC BRAKE BLOCK	1
VC5507	TRACK	1
VC5508	TRACK GUIDE	2
VC5524	INSIDE CLIP CHUTE	1
VC5525	STRIP GUIDE FOR CHUTE	2
VC5729	IDLER SPROCKET WASHER	2
VC5732	RAIL TRIGGER SWITCH DETAIL	-
	VC5254 RAIL TRIGGER	1
	VC5742 TRIGGER PLATE	1
	VH0143 SHCS 10 - 32 x 3/4	1
	VH0146 SHCS 10 - 32 x 1 1/2	2
	VH0274 STRAIN RELIEF FITTING	1
	VH0279 RAIL SENSOR CABLE	1
	VH0335 TRIGGER SWITCH	1
VC5738	TOOL ASSEMBLY	-
VC5798	JACK SPACER	1
VH0042	SHCS, 8 - 32 x 1/4	4
VH0043	LOCK NUT, 8 - 32 (THIN HEIGHT)	12
VH0054	NUT 1/2 - 13	1
VH0062	NUT, 5/16 - 18	2
VH0120	LOCK WASHER, 5/16	2
VH0125	LOCK WASHER 1/2	1
VH0134	KNOB	2
VH0152	FHCS 1/4 - 20 x 1/2	4
VH0159	SET SCREW, 5/16 - 18 x 1/2	1
VH0237	SHCS, 5/16 - 18 x 1 1/2	2
VH0259	FLAT WASHER 3/8	8
VH0314	HHCS 3/8 - 16 x 5/8	8
VH0367	PUSH-IN TUBE FITTING, 90° 1/2 x 1/2 NPT	1
VH0386	SAFETY VALVE	1
VH0438	U-BOLT	2
VH0450	SPACER	20
VH0451	SHCS, 8 - 32 x 1 3/4	10
VH0509	HHCS, 1/2 - 13 x 3 1/2	1

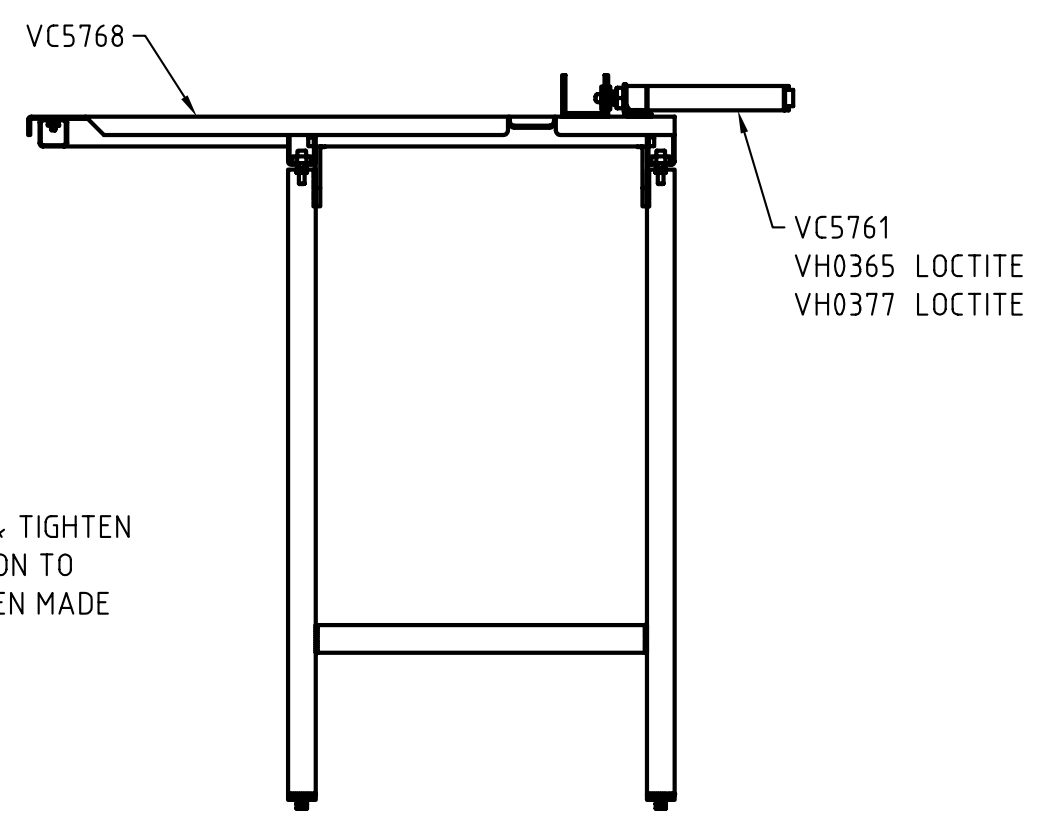
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A		JMW		7-13-01	-	DWN BY	JMW
B		JMW		4-2-02	HEAT TREATMENT:	APPD	DA
C	ECN 404	JMW	DA	9-1-04	-	DATE	7-13-01
					FINISH:	SCALE	1/8
					-	DWG. NO.	VC5735

3714 JARVIS AVENUE
SKOKIE, IL 60076 U.S.A.
RIGHT-SIDE FRAME
DETAIL
B



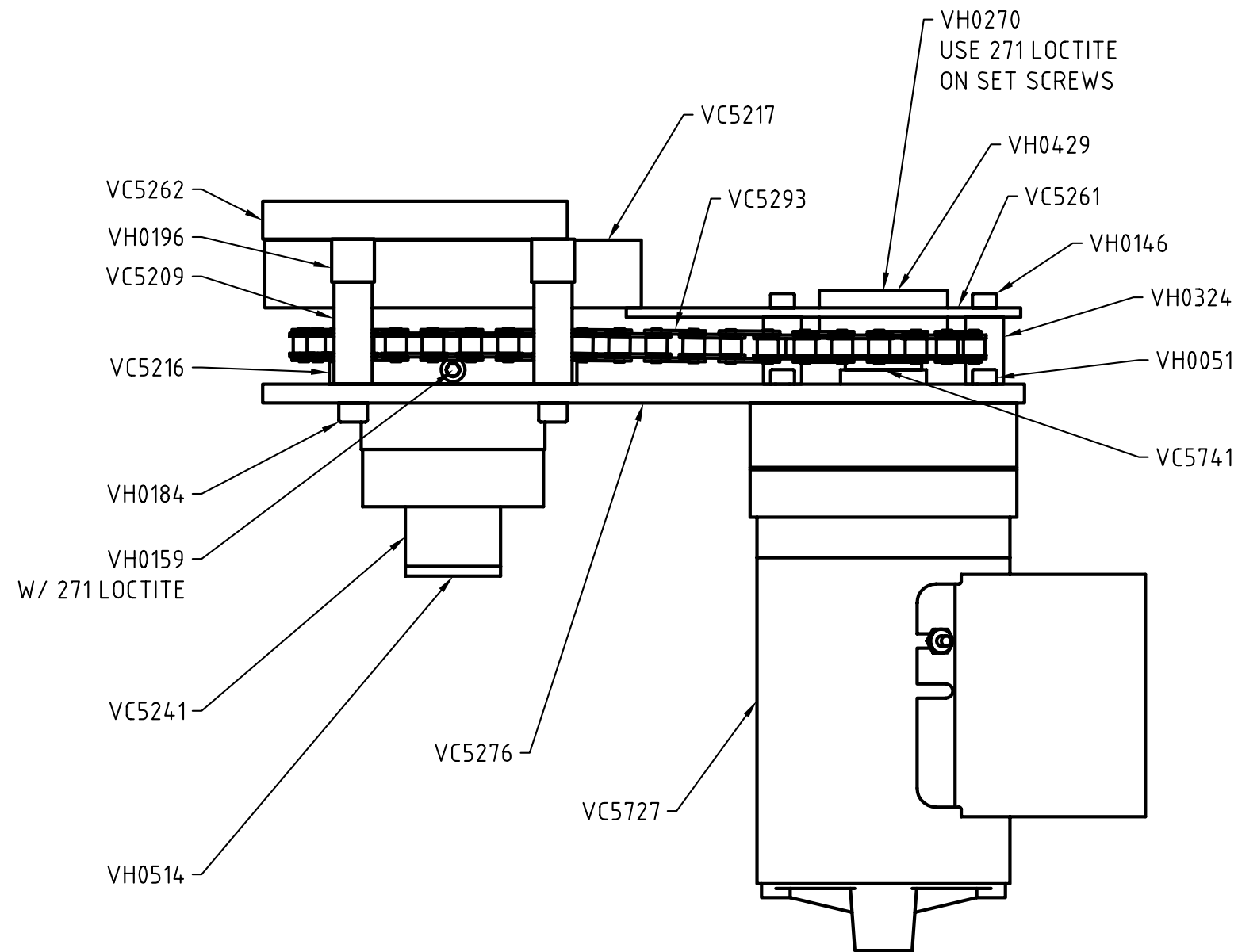
PART #	DESCRIPTION	QTY	PART #	DESCRIPTION	QTY
VC5221	BRACKET	2	VH0198	FHCS, 1/4 - 20 x 3/4	8
VC5256	LEG ASSEMBLY	1	VH0207	JAM NUT, 3/8 - 16	4
VC5271	EXIT CONVEYOR	1	VH0221	WASHER, SAE, 1/4	4
VC5760	PUSHER	1	VH0260	WASHER, SPLIT, 1/4	4
VC5761	NUT	2	VH0321	NUT, HEAVY HEX, 1/4 - 20	8
VC5768	CONVEYOR TABLE TOP	1	VH0322	NUT, HEX, 1/4 - 20	4
VH0060	SHCS, 5/16 - 18 x 3/4	8	VH0365	CYLINDER	2
VH0062	NUT, 5/16 - 18	8	VH0366	CYLINDER, HARDWARE	2
VH0120	LOCK WASHER, 5/16	10	VH0377	JAM NUT	2
VH0128	HHCS, 3/8 - 16 x 1 1/2	2	VH0378	HHCS, 1/4 - 20 x 3/4	4
			VH0424	WASHER, FLAT, 1/4	8



ADJUST HEIGHT & TIGHTEN
AFTER CONNECTION TO
MACHINE HAS BEEN MADE

VH0128
VH0207

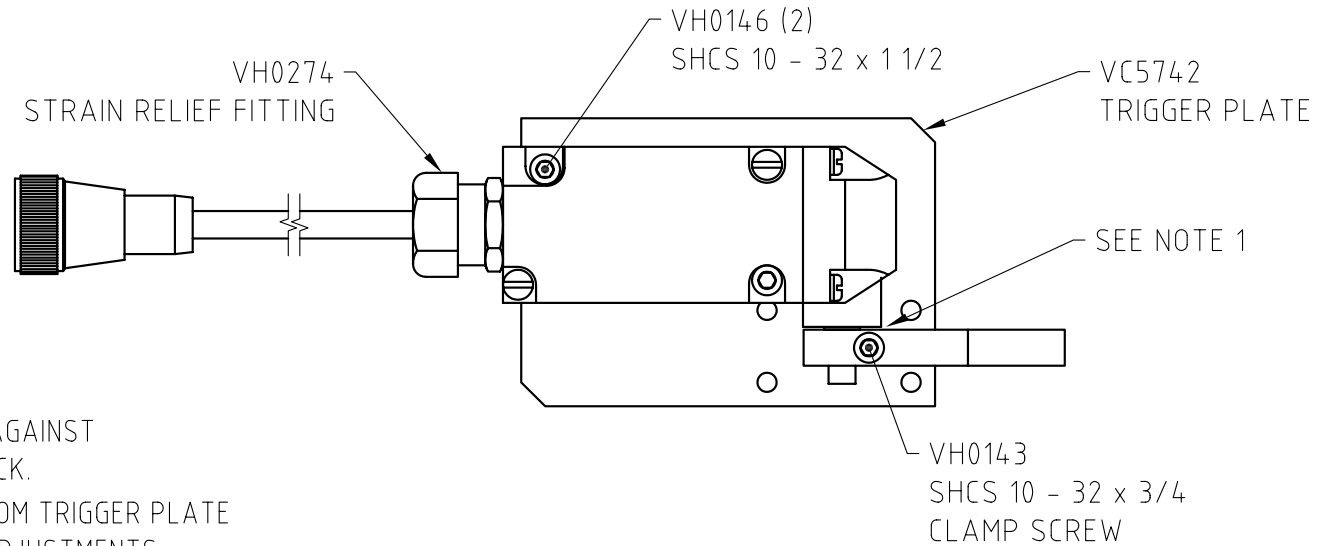
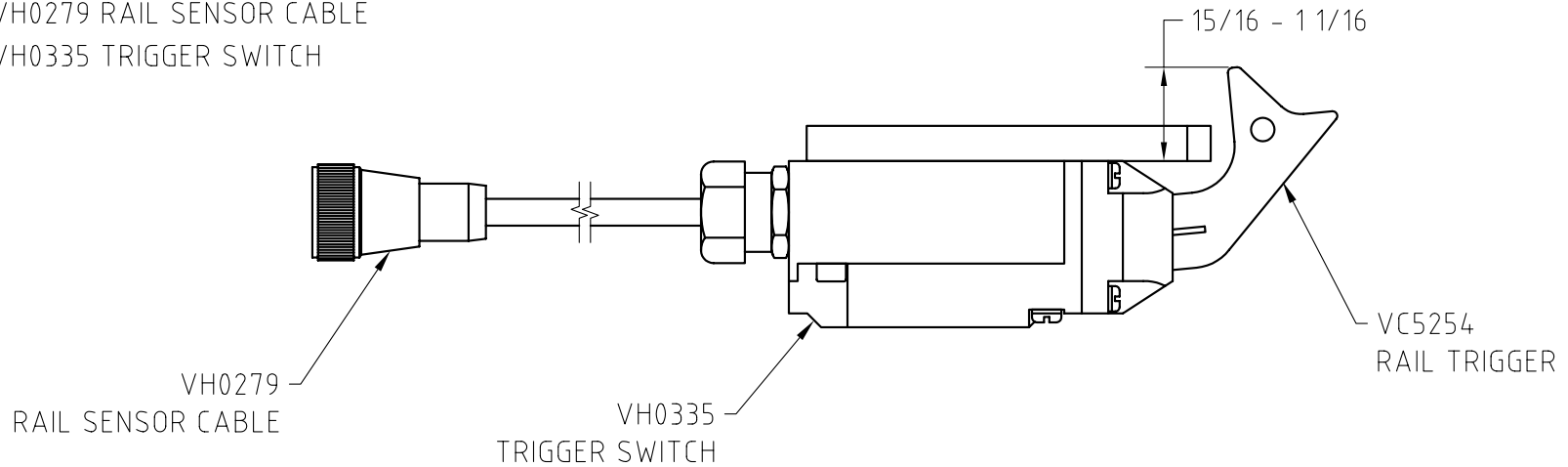
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A		JMW		1-16-01	-	DWN BY JMW	3714 JARVIS AVENUE SKOKIE, IL 60076 U.S.A.
B	REDESIGN	JMW		9-27-01	HEAT TREATMENT:	APPD DA	EXIT TABLE WITH PUSHER
C	REDESIGN	JMW		4-5-02	-	DATE 1-16-01	
D	ECN 404	JMW	DA	9-1-04	FINISH:	SCALE NONE	
					-	DWG. NO. VC5736	B



PART #	DESCRIPTION	QTY	VC5741	SPROCKET SPACER	1										
VC5209	SPACER	4	VH0051	SHCS 10 - 32 x 1/2	2										
VC5216	SPROCKET	1	VH0146	SHCS 10 - 32 x 1 1/2	2										
VC5217	ELEVATOR NUT	1	VH0159	SET SCREW, 5/16 - 18 x 1/2	1										
VC5241	ACME ROD	1	VH0184	SHCS, 1/4 - 20 x 2 1/2	4	REV	DESCRIPTION	BY	APPD	DATE	MATERIAL:	© 2000	VERTEX FASTENERS INC. 3714 JARVIS AVENUE SKOKIE, IL 60076 U.S.A. TOOL HEIGHT MOTOR DETAIL		
VC5261	CHAIN GUARD	1	VH0196	BEARING, CAM ROLLER	4	A		JMW		1-3-01	-	DWN BY JMW			
VC5262	FIXED PLATE	1	VH0270	SPROCKET 14 TEETH	1	B	NEW ACME ROD	JMW		3-26-01	HEAT TREATMENT:	APPD DA			
VC5276	LIFT MOTOR PLATE	1	VH0324	SPACER #10 ID 1/2 OD 7/8 LONG	2	C	+ VH0429	JMW		2-20-02	-	DATE 1-3-01			
VC5293	TOOL ELEVATION CHAIN	1	VH0429	MACHINE KEY 1/8 SQ. x 3/4	1	D	ECN 404	JMW	DA	8-19-04	FINISH:	SCALE 1/2			
VC5727	TOOL MOTOR	1	VH0514	SHCS, 5/8 - 11 x 6	1						-	DWG. NO. VC5737	B		

VC5255 RAIL TRIGGER SWITCH ASSEMBLY INCLUDES:

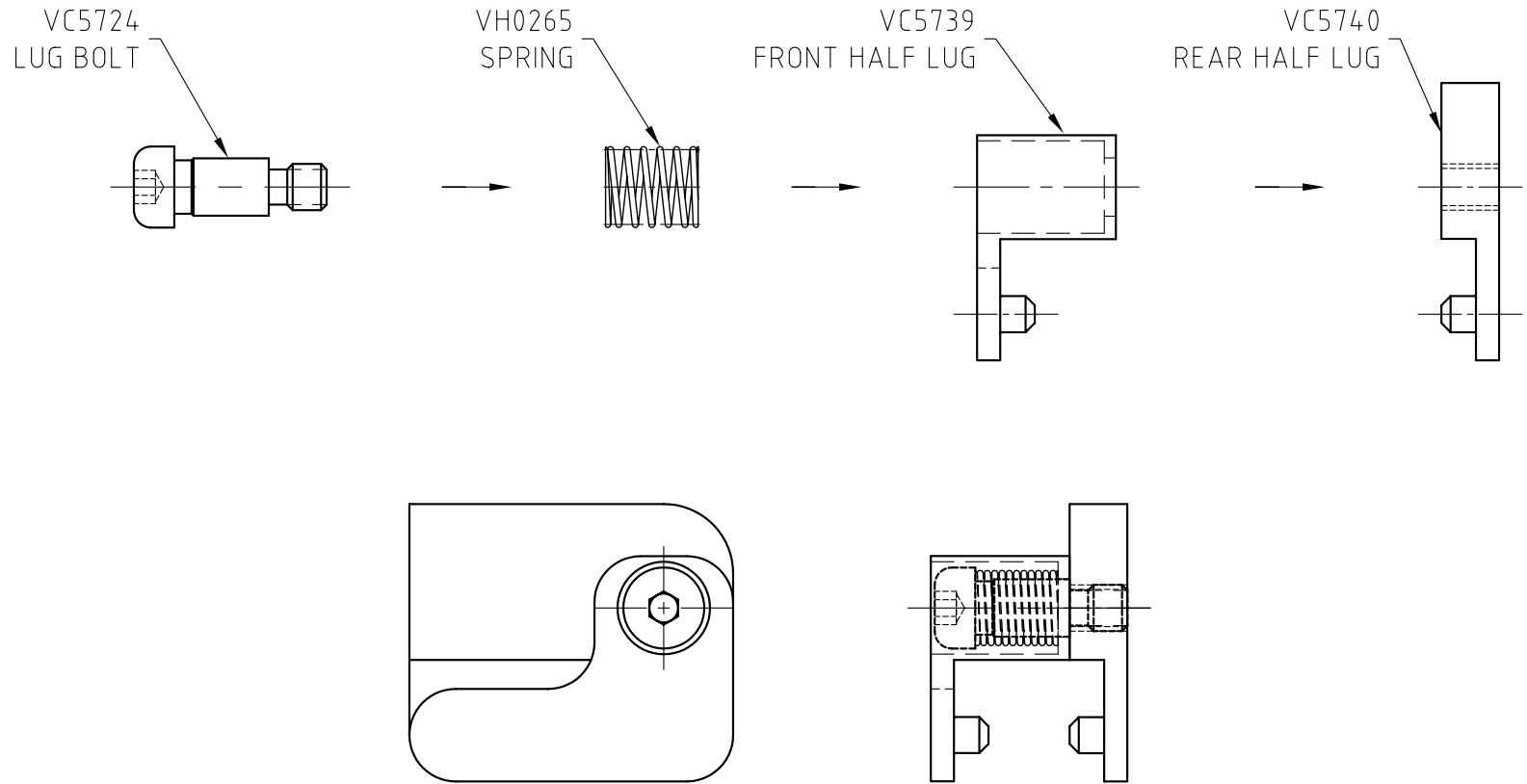
- VH0274 STRAIN RELIEF FITTING
- VH0279 RAIL SENSOR CABLE
- VH0335 TRIGGER SWITCH



NOTES:

1. RAIL TRIGGER MUST BE PUSHED AGAINST SHOULDER ON RAIL TRIGGER BLOCK.
2. REMOVE RAIL TRIGGER BLOCK FROM TRIGGER PLATE TO MAKE NECESSARY TRIGGER ADJUSTMENTS.

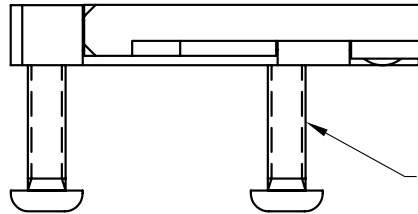
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A		JMW		12-19-00	-		DWN BY JMW	
B	REDESIGN	JMW		1-31-01	HEAT TREATMENT:		APPD	
					-		DATE -	
					FINISH:		SCALE 1:2	
					-	DWG. NO. VC5732B	A	



NOTE: ASSEMBLE WITH LOCTITE 271.

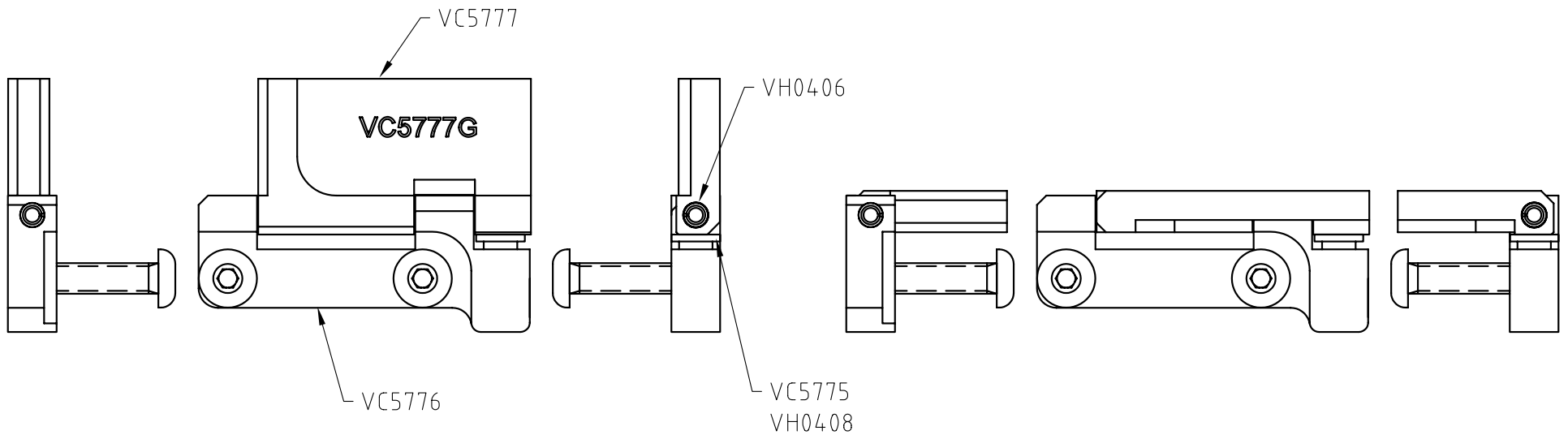
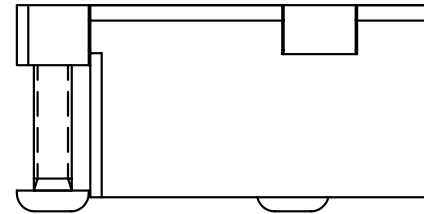
REV	DESCRIPTION	BY	APPD	DATE	MATERIAL:	<u>TOL. UNLESS SPECIFIED</u> INCHES .X = ±.125 .XX = ±.030 .XXX = ±.005	© 2001	VERTEX FASTENERS INC. 3714 JARVIS AVENUE SKOKIE, IL 60076 U.S.A. LUG ASSEMBLY (UNIVERSAL)	
A		JMW	DA	3-26-01	-		DWN BY		JMW
					HEAT TREATMENT:		APPD		DA
					FINISH:		DATE		3-26-01
					-		SCALE		FULL
							DWG. NO.	VC5754A	A

LUG FLIPPED UP



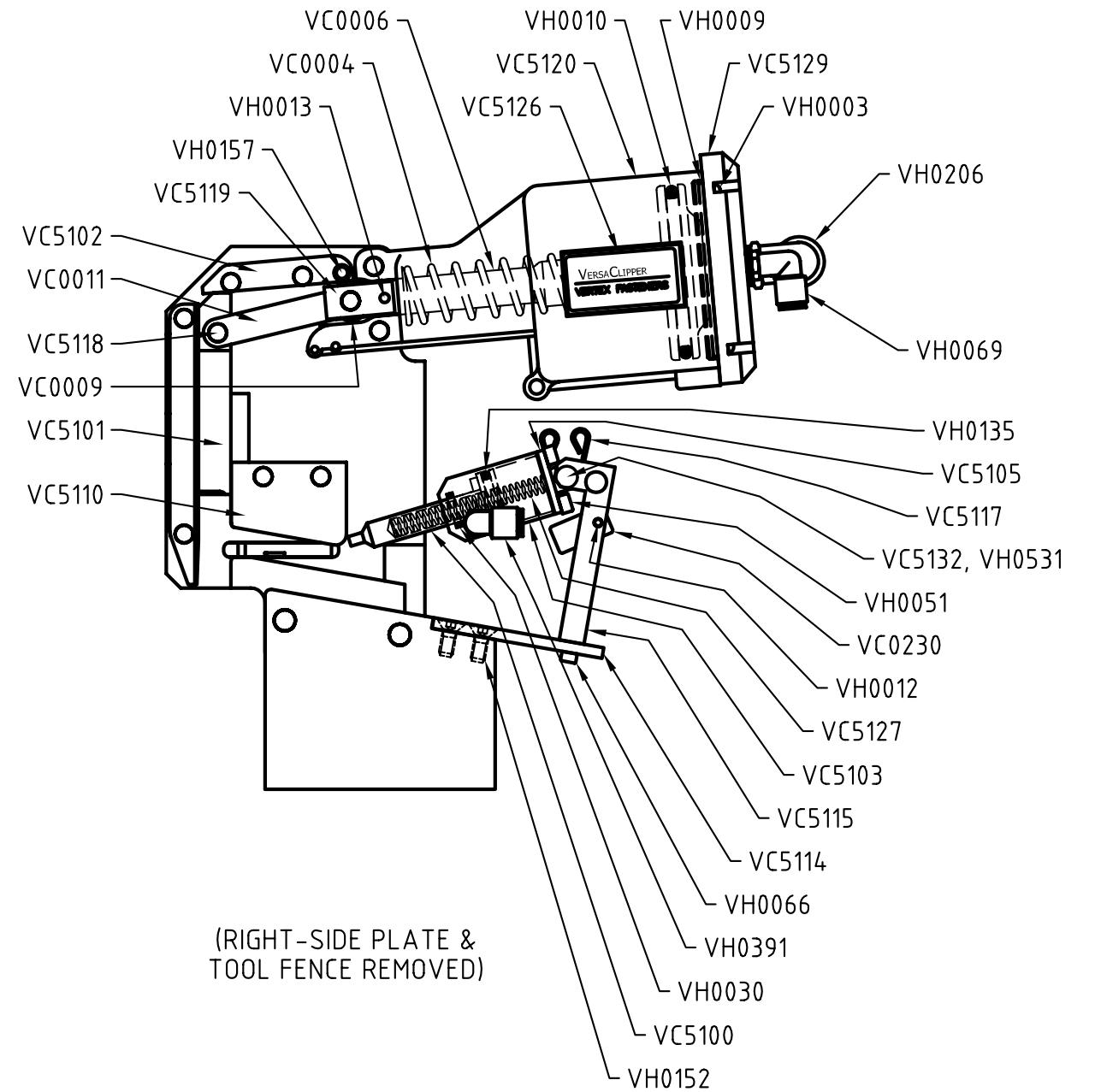
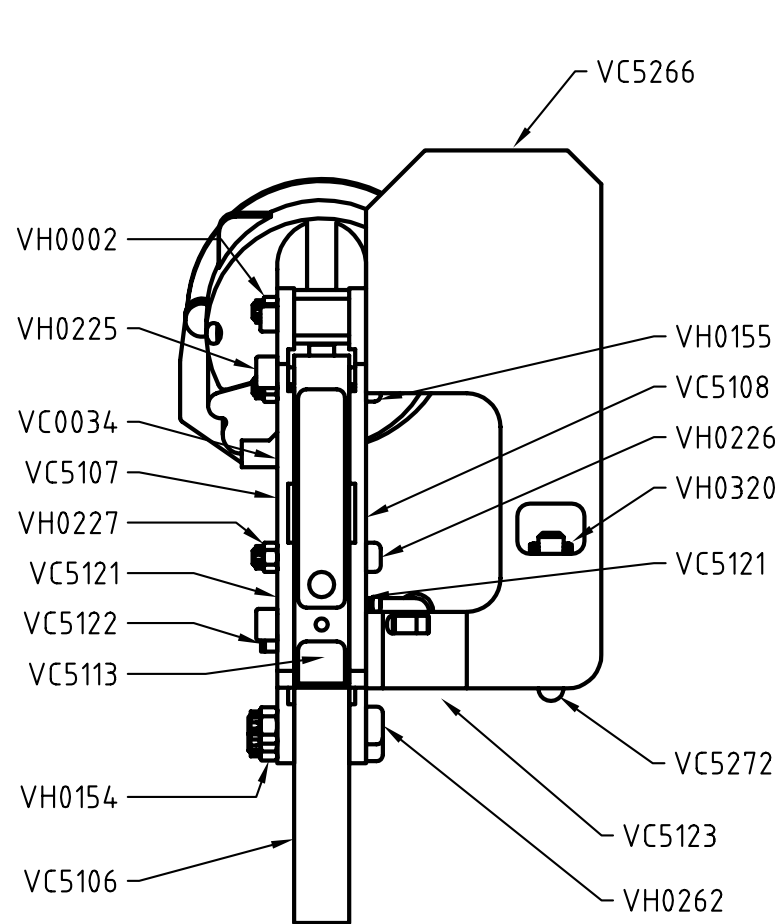
USE VH0407 (2 PER LUG) FOR
INSTALLATION ON CHAIN

LUG FLIPPED DOWN



REV	DESCRIPTION	BY	APPD	DATE	MATERIAL:	TOL. UNLESS SPECIFIED	© 2001	VERTEX FASTENERS INC. 3714 JARVIS AVENUE SKOKIE, IL 60076 U.S.A.
A	-	JMW		12-10-01	-	INCHES .X = ±.125 .XX = ±.030 .XXX = ±.005	DWN BY JMW	FLIP UP LUG ASSEMBLY
B	ECN 404	JMW	DA	8-19-04	HEAT TREATMENT:		APPD DA	
					-		DATE 12-10-01	
					FINISH:		SCALE FULL	
					-		DWG. NO. VC5779	
								A

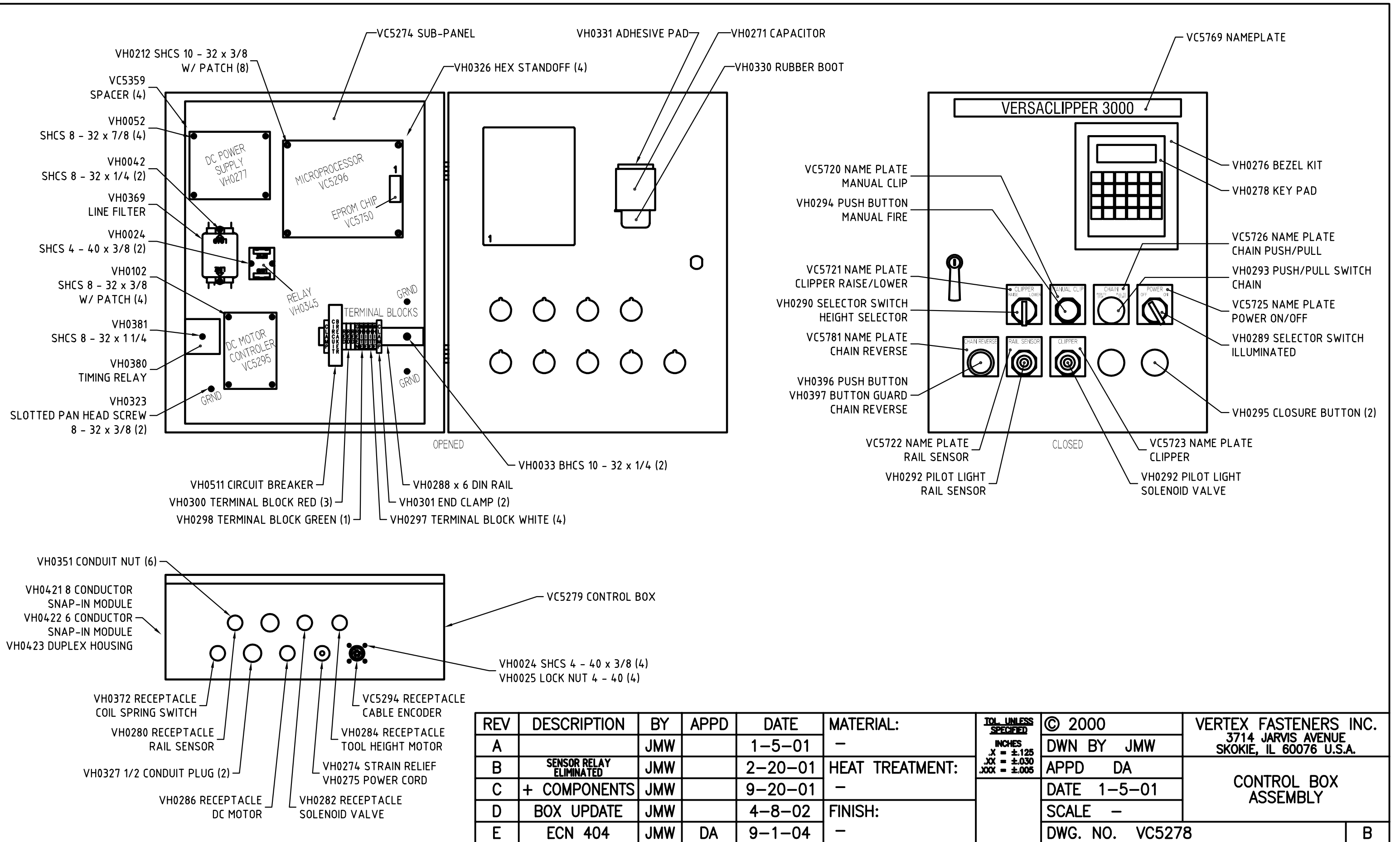
PART #	DESCRIPTION	QTY
VC0004	SPRING, PISTON	1
VC0006	PISTON	1
VC0009	ROLLER	1
VC0011	LINK	2
VC0034	WARNING LABEL	1
VC0230	CLIP FEEDER STOP	1
VC5100	PISTON (CLIP FEEDER)	1
VC5101	DRIVER BLADE	1
VC5102	TOP PLATE	1
VC5103	CYLINDER BODY (CLIP FEEDER)	1
VC5105	CYLINDER END CAP (CLIP FEEDER)	1
VC5106	ANVIL	1
VC5107	LEFT-HAND SIDE PLATE	1
VC5108	RIGHT-HAND SIDE PLATE	1
VC5110	BLADE GUIDE	1
VC5113	FRONT PLATE	1
VC5114	MOUNTING BRACKET (ANVIL)	1
VC5115	CYLINDER MOUNT	1
VC5117	TORSION SPRING	1
VC5118	LINK PIN	2
VC5119	YOKE	1
VC5120	CYLINDER BODY	1
VC5121	PAWL SPRING	2
VC5122	LEFT-HAND PAWL	1
VC5123	RIGHT-HAND PAWL	1
VC5126	VERSACLIPPER LABEL	1
VC5127	PISTON FEED SPRING	1
VC5129	CAP	1
VC5132	PIN, FEED CYLINDER	1
VC5266	TOOL FENCE	1
VC5272	HEIGHT GAUGE PIN	1
VH0002	FLEX LOCK NUT, 1/4 - 20	2
VH0003	10 - 14 x 5/8 PLASTITE	5
VH0009	O-RING, CAP, 2 7/8 x 3	-
VH0010	O-RING, PISTON, 2 3/4 x 3 1/8	-
VH0012	SPRING PIN, 1/8 x 1 1/4	1
VH0013	DOWEL PIN, 4MM x 24MM (YOKE)	1
VH0030	O-RING, 7/16 x 5/8	-
VH0051	SHCS, 10 - 32 x 1/2	4
VH0066	SHCS, 8 - 32 x 5/8	2
VH0069	1/4 x 1/8 90° TUBE FTG	1
VH0135	O-RING, #210	-
VH0152	FHCS, 1/4 - 20 x 1/2	2
VH0154	FLEX LOCK NUT, 5/16 - 18	2
VH0155	SHOULDER BOLT, 5/16 x 1 1/4	2
VH0157	SHCS, 1/4 - 20 x 5/8 W/ PATCH	2
VH0206	1/2 x 3/8 90° SWVL TUBE FTG	1
VH0225	SHCS, 5/16 - 18 x 1 3/4	2



(RIGHT-SIDE PLATE & TOOL FENCE REMOVED)

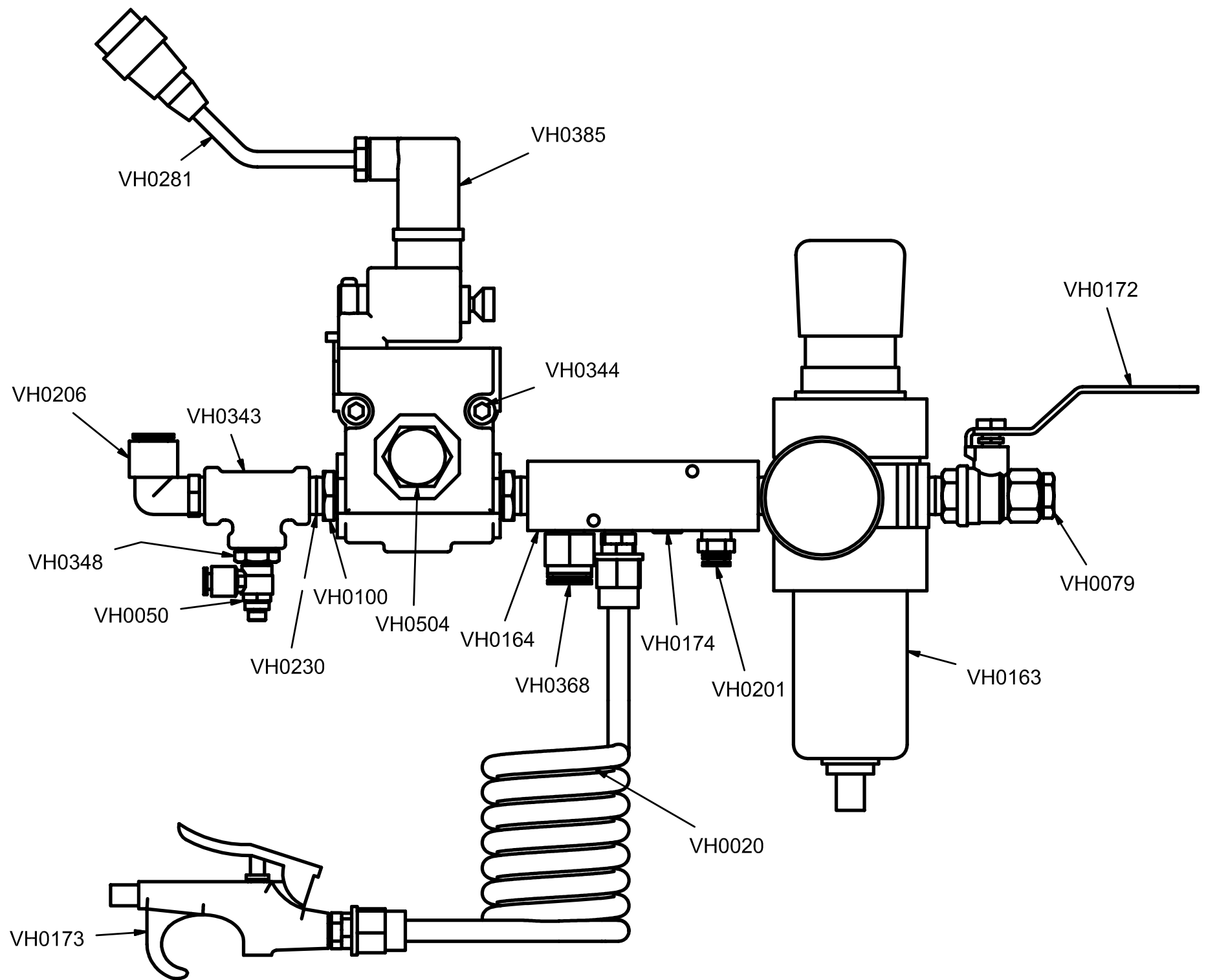
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B	NEW SPRING C5127	JMW		8-20-01	-	DWN BY JMW	3714 JARVIS AVENUE SKOKIE, IL 60076 U.S.A.
C	NEW CAP, ELIM PARTS	JMW		4-2-02	HEAT TREATMENT:	APPD DA	TOOL ASSEMBLY
D	ECN 304	JMW	DA	12-9-03	-	DATE 12-19-00	
E	ECN 404	JMW	DA	9-1-04	FINISH:	SCALE NONE	
F	ECN 504	JMW	DA	6-14-05	-	DWG. NO. VC5738	

B*



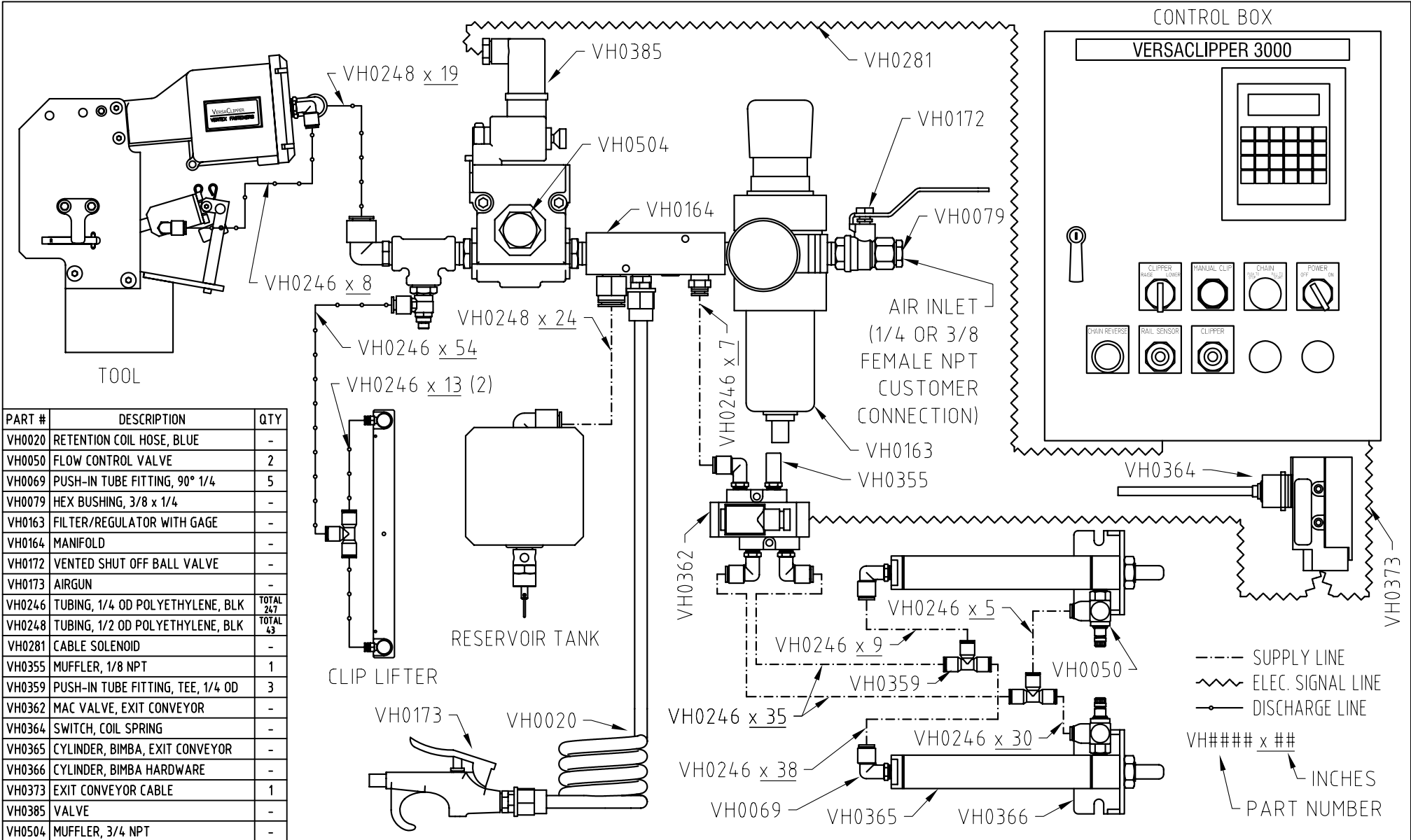
REV	DESCRIPTION	BY	APPD	DATE	MATERIAL:	TOL. UNLESS SPECIFIED	© 2000	VERTEX FASTENERS INC. 3714 JARVIS AVENUE SKOKIE, IL 60076 U.S.A.
A		JMW		1-5-01	-	INCHES .X = ±.125 .XX = ±.030 .XXX = ±.005	DWN BY JMW	CONTROL BOX ASSEMBLY
B	SENSOR RELAY ELIMINATED	JMW		2-20-01	HEAT TREATMENT:		APPD DA	
C	+ COMPONENTS	JMW		9-20-01	-	DATE 1-5-01		
D	BOX UPDATE	JMW		4-8-02	FINISH:	SCALE -		
E	ECN 404	JMW	DA	9-1-04	-	DWG. NO. VC5278	B	

PART #	DESCRIPTION	QT
VH0020	RETRACTABLE HOSE	1
VH0050	FLOW CONTROL	1
VH0079	BUSHING, HEX REDUCER, 3/8 x 1/4	1
VH0100	BUSHING, HEX REDUCER, 1/2 x 3/8	2
VH0163	FILTER/REGULATOR W/ GAUGE	1
VH0164	MANIFOLD	1
VH0172	VALVE, VENTED SHUT-OFF BALL	1
VH0173	AIR GUN	1
VH0174	PLUG, 1/4 NPT	1
VH0201	PUSH-IN FTG, STR, 1/4 x 1/4 NPT	1
VH0206	PUSH-IN FTG, 90, 1/2 x 3/8 NPT	1
VH0230	NIPPLE, 3/8 NPT	4
VH0281	SOLENOID CABLE	1
VH0343	TEE, 3/8	1
VH0344	SHCS, 5/16 - 18 x 2	2
VH0348	BUSHING, HEX REDUCER, 3/8 x 1/8	1
VH0368	PUSH-IN FTG, STR, 1/2 x 1/4 NPT	1
VH0385	VALVE	1
VH0504	MUFFLER	1



REV	ECN	DESCRIPTION	BY	APPD	DATE	MATERIAL:	TOL. UNLESS SPECIFIED	© 2004	VERTEX FASTENERS INC.
B	404	UPDATE	JMW	DA	8-30-04		.INCHES .X = ± .030 .XX = ± .015 .XXX = ± .005 ANGLES ± 1/2°	DWN BY	3714 JARVIS AVENUE SKOKIE, IL 60076 U.S.A.
						HEAT TREATMENT:		APPD	CONTROL VALVE ASSEMBLY (AUTOMATIC)
						FINISH:		DATE	
								SCALE	
								DWG. NO.	
									B

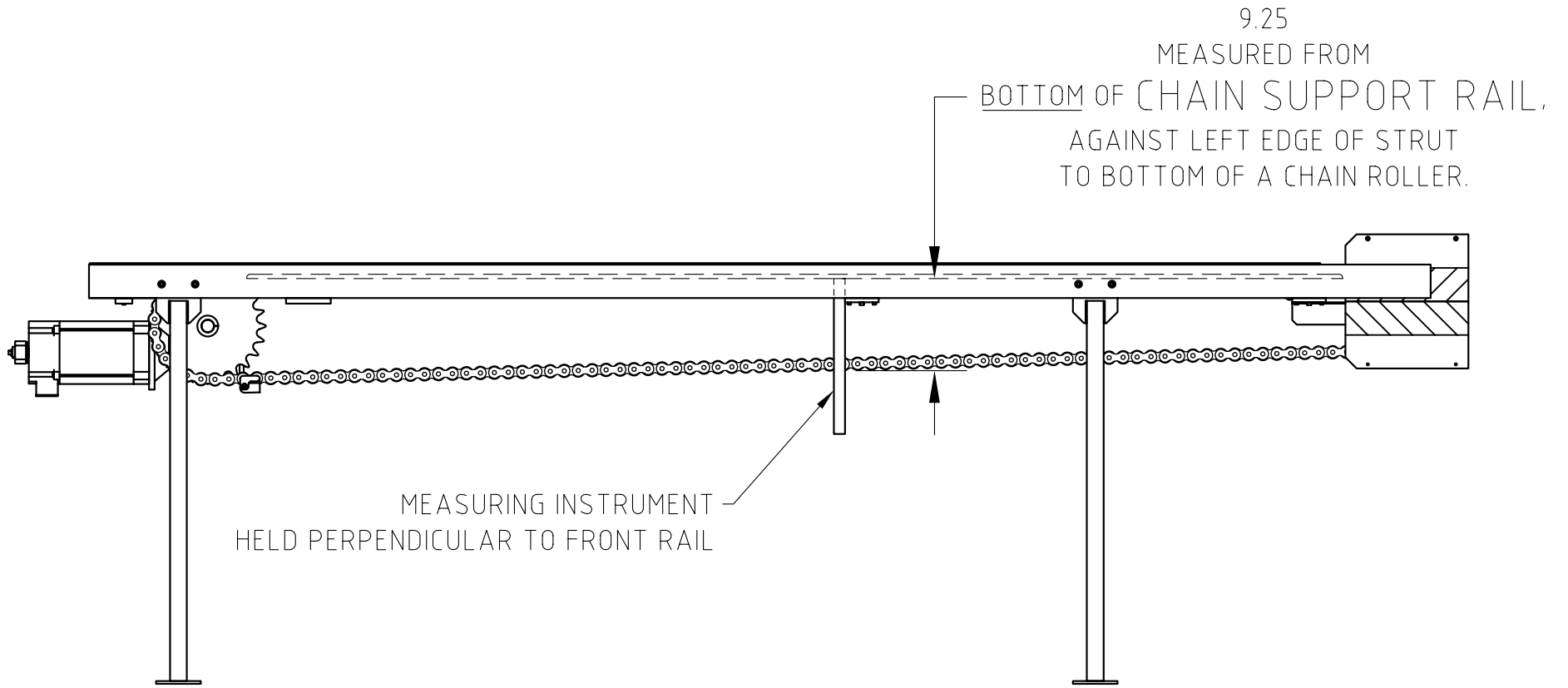
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PART #	DESCRIPTION	QTY
VH0020	RETENTION COIL HOSE, BLUE	-
VH0050	FLOW CONTROL VALVE	2
VH0069	PUSH-IN TUBE FITTING, 90° 1/4	5
VH0079	HEX BUSHING, 3/8 x 1/4	-
VH0163	FILTER/REGULATOR WITH GAGE	-
VH0164	MANIFOLD	-
VH0172	VENTED SHUT OFF BALL VALVE	-
VH0173	AIRGUN	-
VH0246	TUBING, 1/4 OD POLYETHYLENE, BLK	TOTAL 247
VH0248	TUBING, 1/2 OD POLYETHYLENE, BLK	TOTAL 43
VH0281	CABLE SOLENOID	-
VH0355	MUFFLER, 1/8 NPT	1
VH0359	PUSH-IN TUBE FITTING, TEE, 1/4 OD	3
VH0362	MAC VALVE, EXIT CONVEYOR	-
VH0364	SWITCH, COIL SPRING	-
VH0365	CYLINDER, BIMBA, EXIT CONVEYOR	-
VH0366	CYLINDER, BIMBA HARDWARE	-
VH0373	EXIT CONVEYOR CABLE	1
VH0385	VALVE	-
VH0504	MUFFLER, 3/4 NPT	-

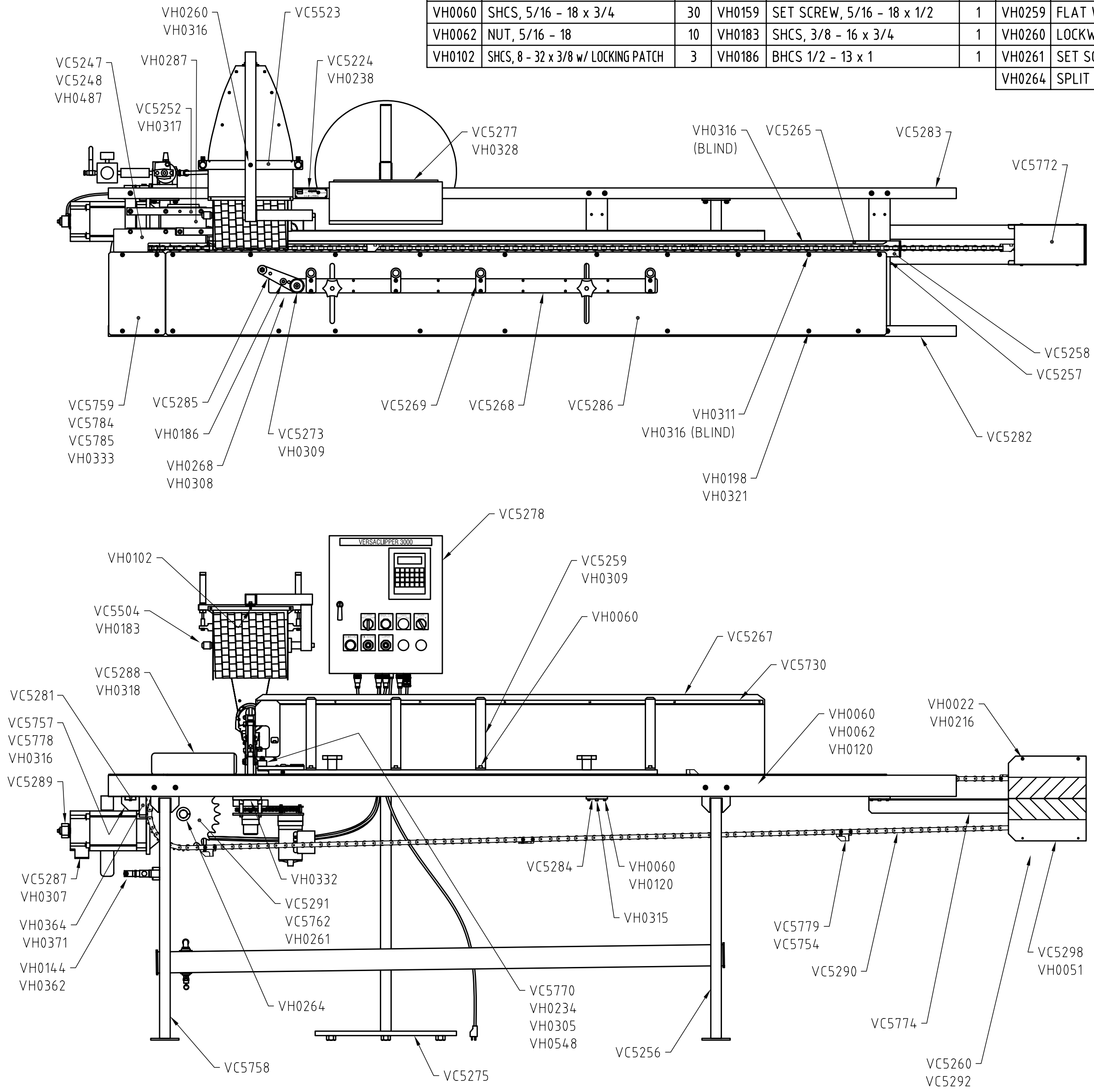
REV	DESCRIPTION	BY	APPD	DATE	MATERIAL:
A	-	JMW		9-19-01	-
B	UPDATE	JMW		4-8-02	HEAT TREATMENT:
C	ECN 404	JMW	DA	9-1-04	-
					FINISH:
					-

<p>TOL. UNLESS SPECIFIED</p> <p>INCHES</p> <p>.X = ±.125</p> <p>.XX = ±.030</p> <p>.XXX = ±.005</p>	© 2000	<p>VERTEX FASTENERS INC.</p> <p>3714 JARVIS AVENUE</p> <p>SKOKIE, IL 60076 U.S.A.</p>
	DWN BY JMW	
	APPD DA	
	DATE 9-19-01	
	SCALE -	<p>PNEUMATICS</p>
	DWG. NO. VC5406	
		A



REV	DESCRIPTION	BY	APPD	DATE	MATERIAL:	<u>TOL. UNLESS SPECIFIED</u> INCHES .X = ±.125 .XX = ±.030 .XXX = ±.005	© 2001	VERTEX FASTENERS INC. 3714 JARVIS AVENUE SKOKIE, IL 60076 U.S.A. CHAIN TENSION	
A	-	JMW		8-6-01	-		DWN BY		JMW
B		JMW		9-17-01	HEAT TREATMENT:		APPD		
					-		DATE		
					FINISH:		SCALE		-
					-	DWG. NO.	VC5773B	A	

PART #	DESCRIPTION	QTY
VC5224	VC NAME PLATE	1
VC5238	AIR TANK	1
VC5247	SPACER - EXTENSION PLATE	2
VC5248	EXTENSION PLATE	1
VC5252	MOTOR MOUNT	2
VC5253	RISER	3
VC5256	LEG ASSEMBLY	1
VC5257	FRONT CHAIN RAIL	1
VC5258	CHAIN SUPPORT RAIL	1
VC5259	FENCE POST	4
VC5260	IDLER SPROCKET RACE	1
VC5265	REAR CHAIN RAIL	1
VC5267	REAR FENCE	1
VC5268	FENCE MOUNT	1
VC5269	EXTENSION LUG	4
VC5270	CLAMP BAR	1
VC5273	PIVOT BUSHING	1
VC5275	CONTROL STAND	1
VC5277	CONTROL BOX MOUNTING STRAP	2
VC5278	CONTROL BOX ASSEMBLY	1
VC5280	TOOL POST	1
VC5281	STRUT (NARROW)	1
VC5282	FRONT RAIL	1
VC5283	REAR RAIL	1
VC5284	STRUT	1
VC5285	ARM	1
VC5286	FENCE TRACK	1
VC5287	MOTOR	1
VC5288	EXIT GUIDE PLATE	1
VC5289	ENCODER	1
VC5290	DRIVE CHAIN	1
VC5291	DRIVE SPROCKET	1
VC5292	IDLER SPROCKET	1
VC5298	SPROCKET GUARD	2
VC5501	DISPENSER FRAME	1
VC5503	CLIP CHUTE	1
VC5504	SPOOL ROD	1
VC5505	MAGNETIC BRAKE BLOCK	1
VC5507	TRACK	1
VC5508	TRACK GUIDE	2
VC5523	CLIP LIFTER ASSEMBLY	1
VC5524	INSIDE CLIP CHUTE	1
VC5525	STRIP GUIDE FOR CHUTE	2
VC5729	IDLER SPROCKET WASHER	2
VC5730	RAIL FENCE TAPE MEASURE	1
VC5732	RAIL TRIGGER SWITCH DETAIL	-
VC5254	RAIL TRIGGER	1
VC5742	TRIGGER BLOCK	1
VH0143	SHCS 10 - 32 x 3/4	1
VH0146	SHCS 10 - 32 x 1 1/2	2
VH0274	STRAIN RELIEF FITTING	1
VH0279	RAIL SENSOR CABLE	1
VH0335	TRIGGER SWITCH	1
VC5738	TOOL ASSEMBLY	-
VC5754	LUG ASSEMBLY	3
VC5757	SWITCH PLATE LATCH	1
VC5758	LEG ASSEMBLY W/ REG BLOCK	1
VC5778	SWITCH PLATE	1
VC5779	FLIP-UP LUG ASSEMBLY	3
VC5784	SPACER FOR EXTENSION	1
VC5785	MOUNT FOR EXTENSION	1
VC5798	JACK SPACER	1

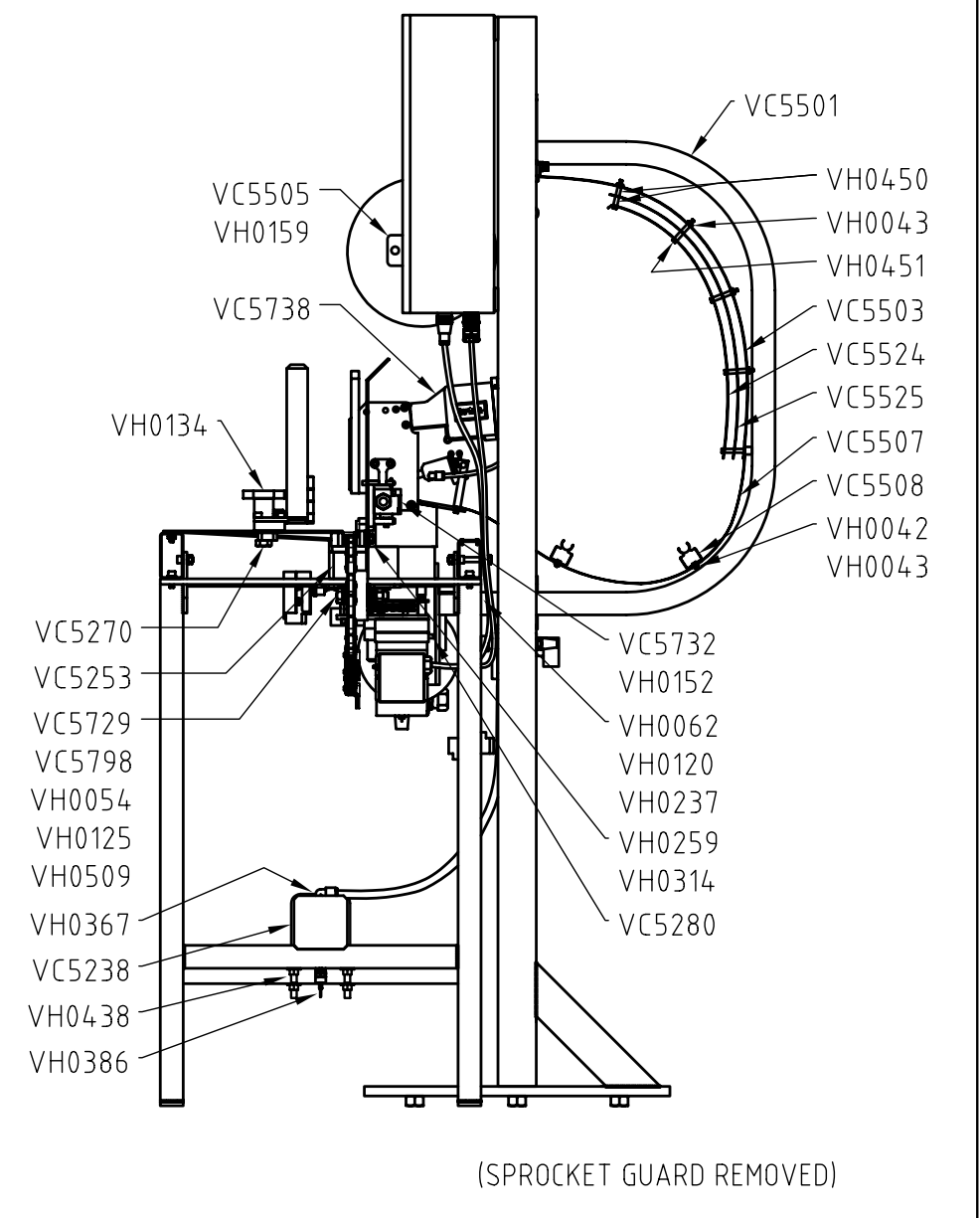


PART #	DESCRIPTION	QTY
VH0022	BHCS 10 - 32 x 1/2	4
VH0042	SHCS, 8 - 32 x 1/4	6
VH0043	LOCK NUT, 8 - 32 (THIN HEIGHT)	12
VH0051	SHCS 10 - 32 x 1/2	4
VH0054	NUT 1/2 - 13	1
VH0060	SHCS, 5/16 - 18 x 3/4	30
VH0062	NUT, 5/16 - 18	10
VH0102	SHCS, 8 - 32 x 3/8 w/ LOCKING PATCH	3

PART #	DESCRIPTION	QTY
VH0120	LOCK WASHER, 5/16	22
VH0125	LOCK WASHER 1/2	1
VH0134	KNOB	2
VH0144	SHCS, 10 - 32 x 1	2
VH0152	FHCS 1/4 - 20 x 1/2	4
VH0159	SET SCREW, 5/16 - 18 x 1/2	1
VH0183	SHCS, 3/8 - 16 x 3/4	1
VH0186	BHCS 1/2 - 13 x 1	1

PART #	DESCRIPTION	QTY
VH0198	FHCS 1/4 - 20 x 3/4	10
VH0216	LOCK NUT 10 - 32	4
VH0234	FLEX LOCK NUT 3/8 - 16	1
VH0237	SHCS, 5/16 - 18 x 1 1/2	2
VH0238	DRIVE SCREW #4 x 5/16	4
VH0259	FLAT WASHER 3/8	8
VH0260	LOCKWASHER 1/4	1
VH0261	SET SCREW 3/8 - 16 x 1	1
VH0264	SPLIT COLLAR 1 1/8	1

PART #	DESCRIPTION	QTY
VH0268	PUSHER ARM SPRING	1
VH0287	GEAR BOX	1
VH0305	CAM ROLLER	1
VH0307	MACHINE KEY	1
VH0308	SET SCREW 1/2 - 13 x 3/8	1
VH0309	FHCS 1/2 - 13 x 1 1/4	5
VH0311	FHCS 1/4 - 20 x 3/8	12
VH0314	HCSS 3/8 - 16 x 5/8	8
VH0315	SHCS 1/4 - 20 x 3	4
VH0316	SHCS 1/4 - 20 x 3/4	15
VH0317	SHCS 3/8 - 16 x 1	6
VH0318	SHCS 3/8 - 16 x 4	2
VH0321	1/4 - 20 HEAVY HEX NUT	10
VH0328	SHCS 5/16 - 18 x 1/2	6
VH0332	SHCS 1/4 - 20 x 2 3/4	2
VH0333	SHCS, 5/16 - 18 x 1	2
VH0362	MAC VALVE	1
VH0364	SWITCH, COIL SPRING	1
VH0367	90° PUSHIN-FITTING	1
VH0371	SHCS, 6 - 32 x 1 1/4	2
VH0386	SAFETY VALVE	1
VH0438	U-BOLT	2
VH0450	SPACER	20
VH0451	SHCS, 8 - 32 x 1 3/4	10
VH0487	SHCS 3/8 - 16 x 3	2
VH0509	HCSS, 1/2 - 13 x 3 1/2	1
VH0548	FHCS 3/8 - 16 x 2	1



REV	DESCRIPTION	BY	APPD	DATE	MATERIAL:	© 2000	VERTEX FASTENERS INC.
A		JMW		8-6-01	-	DWN BY	3714 JARVIS AVENUE
B		JMW		4-29-02	HEAT TREATMENT:	APPD DA	SKOKIE, IL 60076 U.S.A.
C	ECN 404	JMW	DA	9-8-04	-	DATE 8-6-01	VersaClipper 3000
					FINISH:	SCALE NONE	Quick Reference
					-	DWG. NO. VC5003	C