

FaceClipper 4000

Model # _____

Serial # _____

Vertex Fasteners
A Subsidiary of Leggett & Platt, Inc.
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DESCRIPTION OF EQUIPMENT

The FaceClipper 4000, a specially designed machine used by upholstered furniture manufacturers, quickly and accurately installs FaceClips into wooden frame rails. The multi-head tool allows you to simultaneously install clips on straight and curved rails. The straightforward, innovative design elements have resulted in a productive and versatile machine for all manufacturers.

The FaceClipper 4000 is made up of four main components:

1. Turntable Assembly
 - a. Each turntable holds a coil of FaceClips each containing 625 pieces.
2. Tool Assembly (Clipping Head)
 - a. The Tool Assembly, which installs FaceClips into wooden furniture rails, can be adjusted to suit the needs of straight or curved rails.
3. End Stop
 - a. Provides an accurate guide for correct and consistent placement of clips on rails.
4. Pneumatic Control Circuit

OPERATING INSTRUCTIONS

Loading a Coil of FaceClips

Refer to Coil Illustration (VC3100) drawing.

1. Place coil on hub of Turntable Assembly (VC3049).
2. Place Disk Cap Assembly (VC3073) on top of coil
3. Run clips off coil, onto Platform (VC3060), down rail, and onto Platform (VC3067).
4. Lift Feed Cylinder (VC3006), swing flag forward to support cylinder.
5. Feed clips onto Tool Mount Rail (VC3010).
6. From the front of tool, slide the Loading Tool Hook (VC3096); hook down, through slot in Front Plate (VC3034), pull clips forward.
7. Verify that Feed Cylinder is down.

Removing FaceClips from Tool Assembly

1. Lift Feed Cylinder (VC3006) up, swing flag forward to support cylinder.
2. Spread Pawl (VC3011) away from side plates while removing clips from rear.

Caution: Do not overspread pawl.

Adjusting Tool Position for Straight Rail

1. Depress Limit Valve (VH0468) on side of tool.
2. Slide tool backward until both SHCS (VH0220) on bottom of Tool Base (VC3101) hits Tool Rail (VC5945).
3. Then slide tool left or right for desired location.
4. Release Limit Valve.

Adjusting Tool Position for Curved Rail

1. Depress Limit Valve (VH0468) on side of tool.
2. Position tool into desired location.
3. Release Limit Valve

Adjusting End Stop

1. Depress Limit Valve (VH0468) on side of Stop Base (VC5925).
2. Position Stop Base in correct location.
3. Release Limit Valve.

Place Stop (VC5924) on base. Choose hole location appropriate for rail width. Stop is used to ensure accurate and consistent placement of clips.

Anvils

Different Anvil heights are available and easily interchanged. Simply lift Anvil off Tool Base (VC3101) and place new anvil on Tool Base.

Air Pressure

Set air pressure between 60-90 psi for proper operation of the FaceClipper 4000. Hardness of wood will determine setting. After required adjustments have been made you may begin production.

Clipping Rails

Keep hands and fingers away from FaceClip exit point!!

1. Check that desired tools are enabled.
 - a. To disable a tool, turn valve handle (VH0387) of desired tool to a horizontal position.
2. Lay rail on Anvils.
3. Slide rail toward End Stop and tools to make contact.
4. Depress Knee Switch – all Tools with Valve (VH0387) “On” (handle in vertical position) will install a clip.
5. Remove rail and repeat.

Manual Clipping

- Use to install individual clips without use of Knee Switch.

Keep hands and fingers away from FaceClip exit point!!

1. Position rail for correct placement of clip.
2. Depress button on valve (VH0470) on side of tool you wish to fire.
3. Repeat as necessary.

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 Tools.
2. Add 2-3 drops of 30-weight oil to opening between front plate and top of blade of Tool assembly.

Self-Lubricating Regulator

Use Air Tool Oil, Almo 525 or equivalent.

Turn knob one full turn (counterclockwise) from closed position for correct lubrication.

**FACECLIPPER 4000
RECOMMENDED SPARE PARTS LIST**

PART #	DESCRIPTION	QTY
VC0340	AIR LUBE OIL	1
VC3011	PAWL	1
VC3014	PAWL SPRING	2
VC3016	PISTON FEED SPRING	2
VC5117	TORSION SPRING	2
VC5132	PIN, FEED CYLINDER	2
VC5983	PNEUMATIC ASSY.	1
VH0030	O'RING, #111	2
VH0069	PUSH-IN FTG 90 DEG	2
VH0135	O'RING, #210	2
VH0468	SWITCH, LIMIT VALVE	1
VH0470	VALVE, PUSH BUTTON	1
VH0483	SWITCH, KNEE	1
VH0531	HAIR PIN	2

TROUBLESHOOTING INFORMATION

PROBLEM	CAUSE	SOLUTION
Blade does not return.	Obstruction in tool. Cylinder Spring damaged.	Remove obstruction. Replace Spring (VC3016).
Clips not feeding.	Dispenser obstruction. Feed cylinder not engaged.	Remove obstruction. Engage by lifting up cylinder allowing flag to drop.
Clip not seated against rail (Fig. 3).	Low air pressure. Incorrect anvil height.	Increase pressure. (Never exceed 90 psi) Use taller anvil.
Clip's hook is overhanging edge of rail (Fig. 4).	Board is warped. Rail is not against tool. Incorrect Tool position.	Operator must hold rail firmly against tools. Move tool to correct location.
Incorrect clip spacing.	Tools are incorrectly spaced.	Move tool assemblies to correct location.
Tools do not fire.	Air Supply not connected. Main Valve is off.	Connect Air Supply. Turn valve (VH0172) on.
Missed clip.	Clips ran out. Valve (VH0387) is closed.	Reload with new coil. Line up rail for correct clip placement. Press button on valve to fire matching tool. Turn lever to vertical position.

EXAMPLES OF INCORRECT CLIP INSTALLATION

FIGURE 3

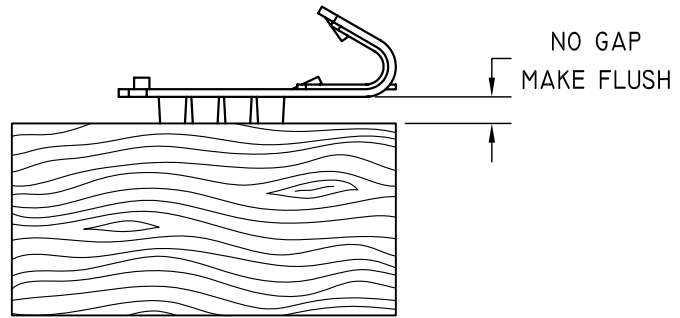
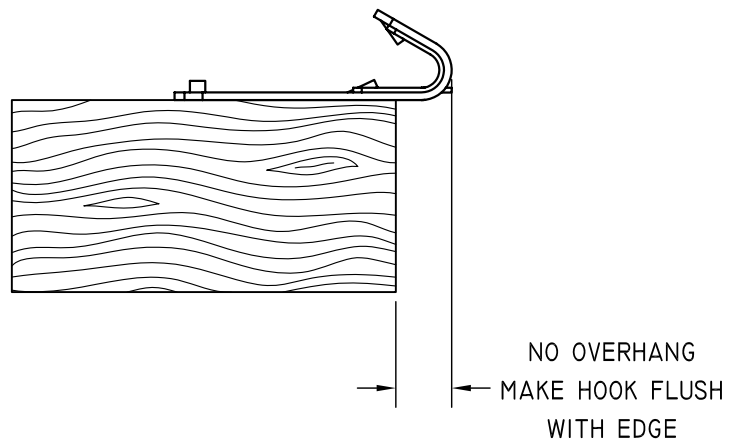


FIGURE 4



Specifications

Air: 60-90 psi, 6 cfm

Machine Size: Depth: Footprint = 81", Overall 98"

Width: Footprint = 59", Overall 67"

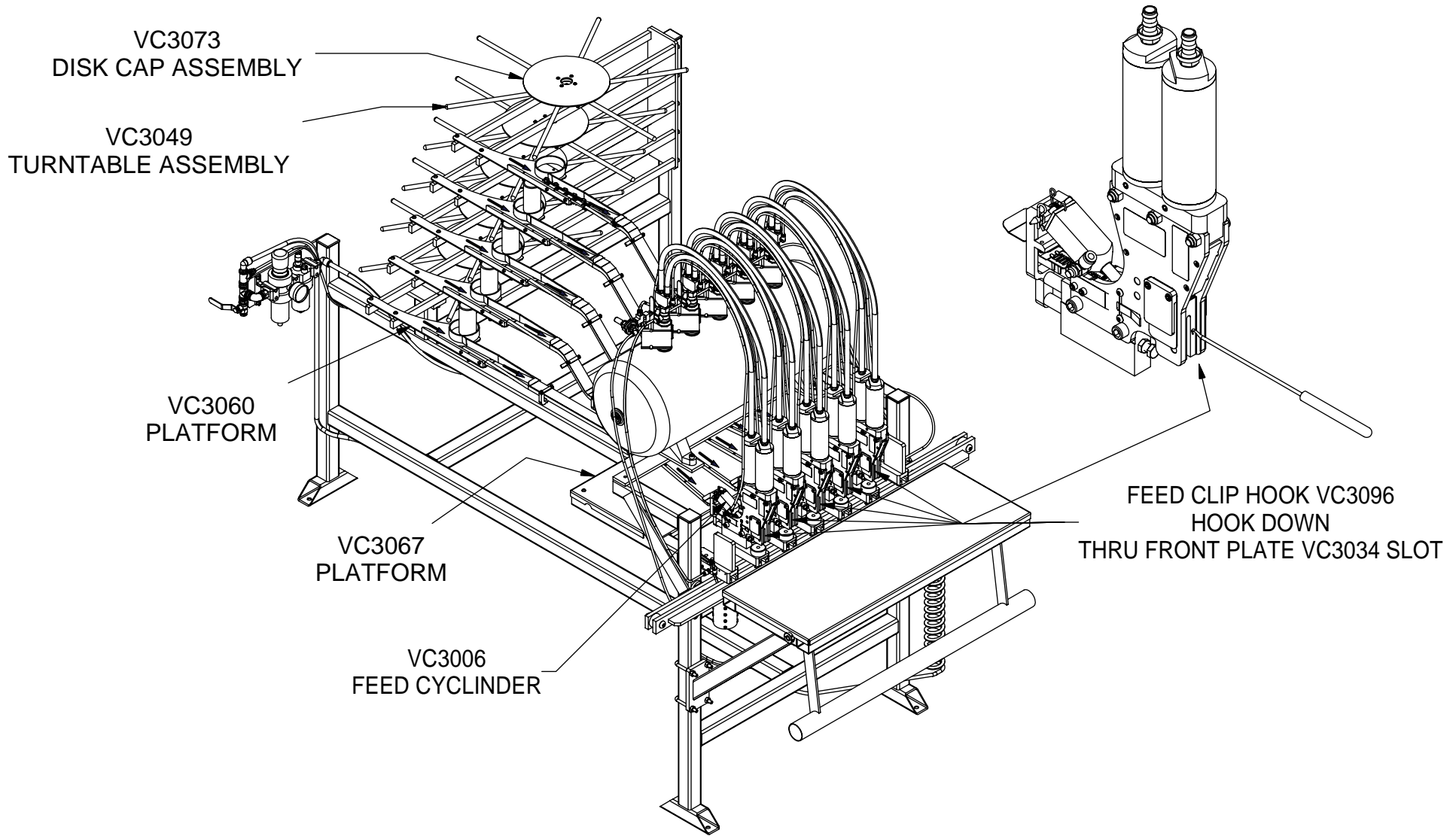
Height: 72"

Weight: 5 Head tool machine = 520 lbs

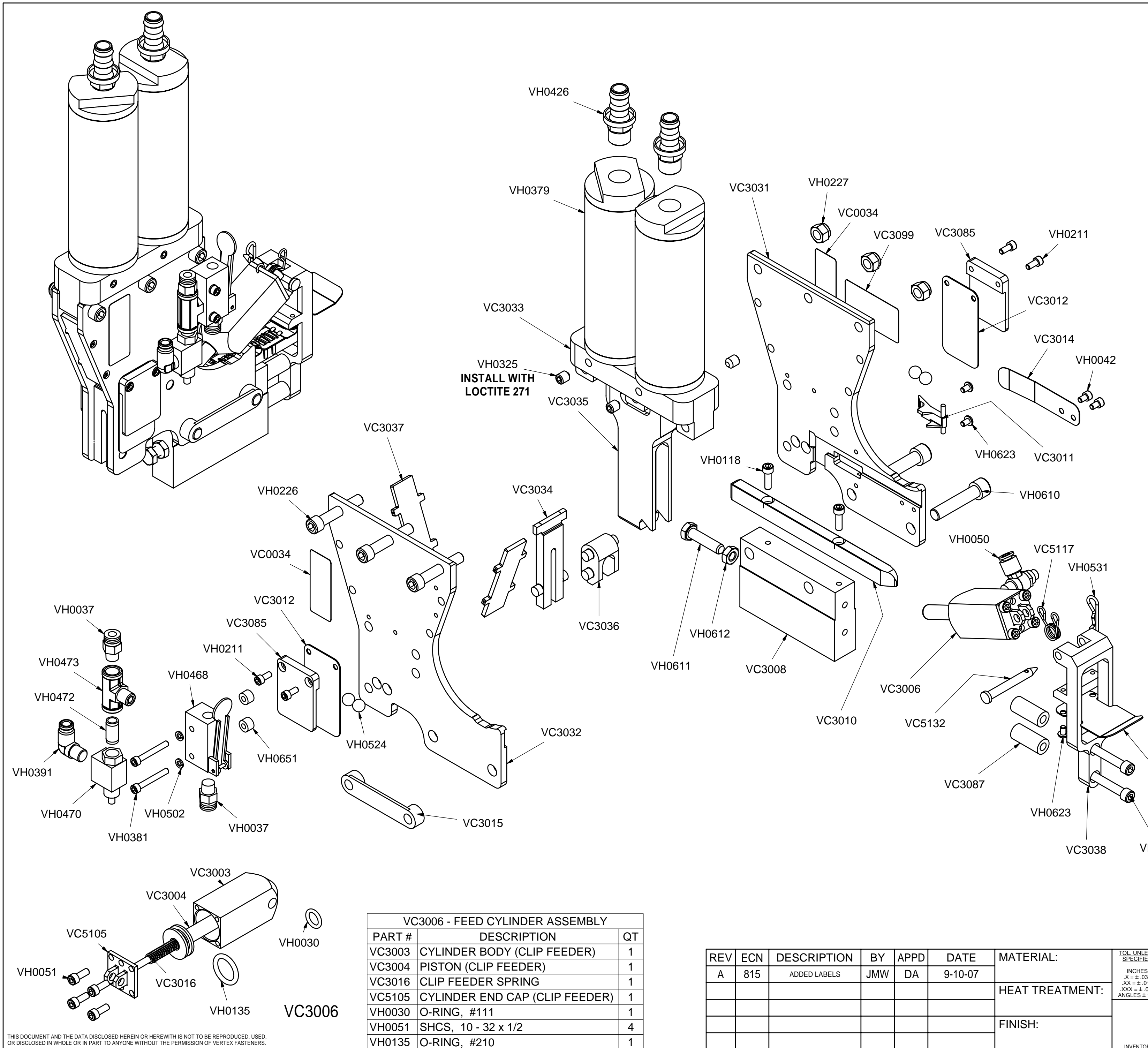
Rail Dimensions: Thickness: 5/8" – 2"

Length: Consult factory

Clip Coil Capacity: 625 FaceClips



REV	ECN	DESCRIPTION	BY	APPD	DATE	MATERIAL:	TOL. UNLESS SPECIFIED INCHES .X = ± .030 .XX = ± .015 .XXX = ± .005 ANGLES ± 1/2	© 2007	VERTEX FASTENERS 3714 JARVIS AVENUE SKOKIE, IL 60076 U.S.A.
						HEAT TREATMENT:		DWN BY JMW	
						FINISH:		APPD DA	
								DATE 10-10-07	
								SCALE	
							INVENTOR	DWG. NO. VC3100	A



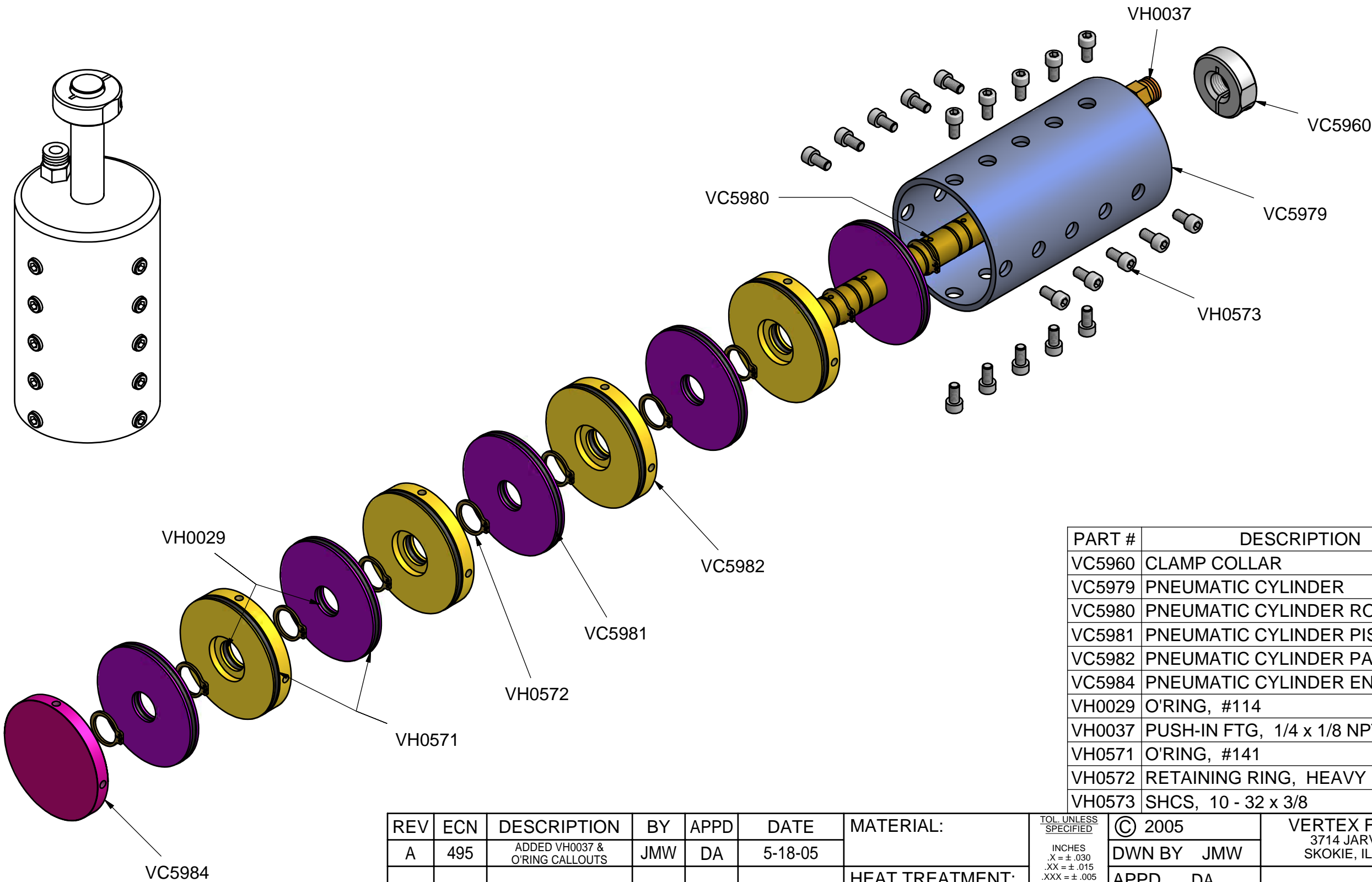
PART #	DESCRIPTION	QT
VC0034	WARNING LABEL	2
VC3006	CLIP FEEDER ASSEMBLY	1
VC3008	TOOL MOUNT	1
VC3010	RAIL - TOOL MOUNT	1
VC3011	PAWL	1
VC3012	BALL BEARINGS SPRING	2
VC3014	PAWL SPRING	1
VC3015	STRAP NUT	1
VC3031	LEFT-HAND SIDE PLATE	1
VC3032	RIGHT-HAND SIDE PLATE	1
VC3033	CYLINDER MOUNT	1
VC3034	FRONT PLATE	1
VC3035	BLADE	1
VC3036	BLADE GUIDE	1
VC3037	GUARD	2
VC3038	FEEDER BRACKET	1
VC3039	COVER	1
VC3085	SPRING RESTRICTOR	2
VC3087	SPACER, 1/2 x 1 1/8, 1/4	2
VC3099	FACECLIPPER LABEL	1
VC5117	TORSION SPRING	1
VC5132	PIN, FEED CYLINDER	1
VH0037	PUSH-IN FTG, 1/4 x 1/8 NPT	2
VH0042	SHCS, 8 - 32 x 1/4	2
VH0050	FLOW CONTROL	1
VH0118	SHCS, 10 - 32 x 5/8	2
VH0211	SHCS, 8 - 32 x 3/8	4
VH0226	SHCS, 5/16 - 24 x 1 3/4	3
VH0227	NUT, NYLOCK, 5/16 - 24	3
VH0325	SET SCREW, 5/16 - 18 x 3/8	4
VH0379	CYLINDER	2
VH0381	SHCS, 8 - 32 x 1 1/4	2
VH0391	BRASS FTG, 90, 1/4 x 1/8 NPT	1
VH0426	HOSE BARB, 1/2 x 3/8 NPT	2
VH0468	LIMIT VALVE	1
VH0470	VALVE, PUSH BUTTON	1
VH0472	NIPPLE 1/8	1
VH0473	TEE, 1/8	1
VH0502	WASHER, LOCK, #8	2
VH0524	3/8 CHROME BALL	4
VH0531	HAIR PIN	1
VH0610	SHCS, 3/8 - 24 x 1 3/4	2
VH0611	HHCS, 5/16 - 18 x 1 1/4	1
VH0612	NUT, JAM, 5/16 - 18	1
VH0623	BHCS, 8 - 32 x 1/4	4
VH0651	SPACER, 3/8 OD x 1/4, #8	2
VH0654	SHCS, 1/4 - 20 x 1 3/4	2

VC3006 - FEED CYLINDER ASSEMBLY		
PART #	DESCRIPTION	QT
VC3003	CYLINDER BODY (CLIP FEEDER)	1
VC3004	PISTON (CLIP FEEDER)	1
VC3016	CLIP FEEDER SPRING	1
VC5105	CYLINDER END CAP (CLIP FEEDER)	1
VH0030	O-RING, #111	1
VH0051	SHCS, 10 - 32 x 1/2	4
VH0135	O-RING, #210	1

REV	ECN	DESCRIPTION	BY	APPD	DATE	MATERIAL:
A	815	ADDED LABELS	JMW	DA	9-10-07	
						HEAT TREATMENT:
						FINISH:

<small>TOL UNLESS SPECIFIED</small> <small>INCHES</small> <small>X = ± .030</small> <small>.XX = ± .015</small> <small>.XXX = ± .005</small> <small>ANGLES ± 1/2</small>	© 2006	VERTEX FASTENERS
	DWN BY JMW	3714 JARVIS AVENUE
	APPD DA	SKOKIE, IL 60076 U.S.A.
	DATE 2-8-07	FACE CLIP TOOL ASSEMBLY
	SCALE 1:2	
	DWG. NO. VC3044	C

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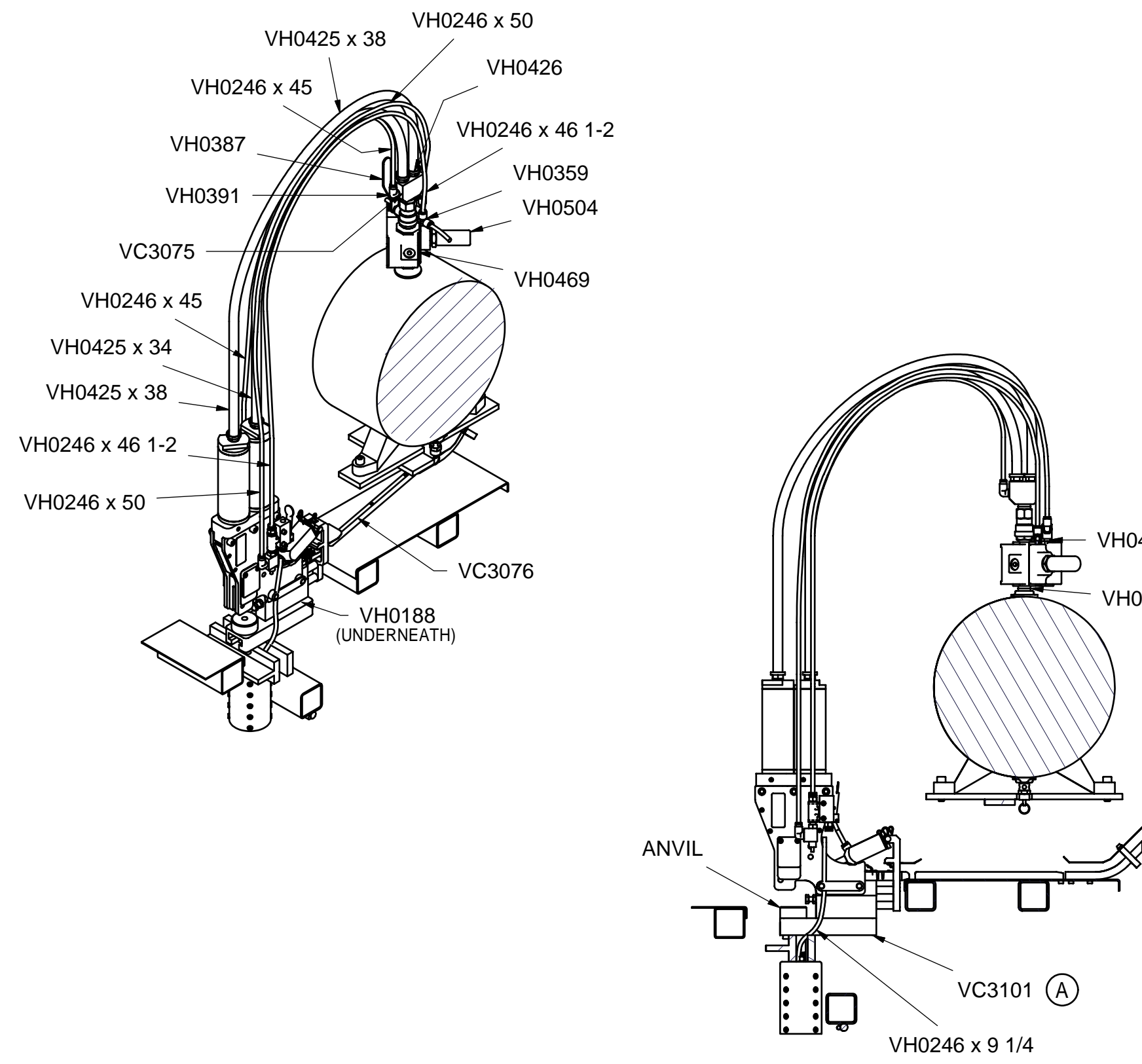
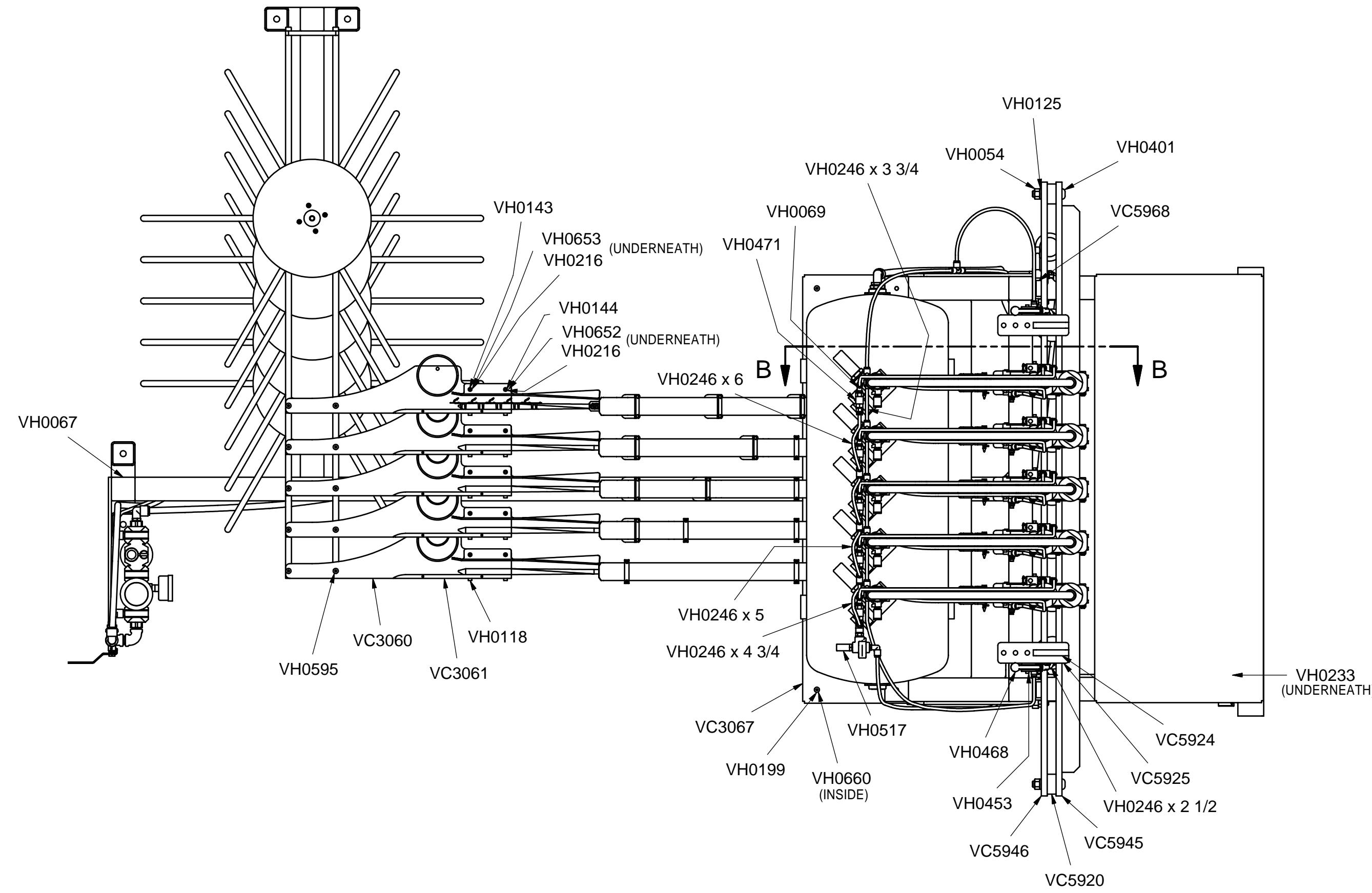


PART #	DESCRIPTION	QT
VC5960	CLAMP COLLAR	1
VC5979	PNEUMATIC CYLINDER	1
VC5980	PNEUMATIC CYLINDER ROD	1
VC5981	PNEUMATIC CYLINDER PISTON	5
VC5982	PNEUMATIC CYLINDER PARTITION	4
VC5984	PNEUMATIC CYLINDER END CAP	1
VH0029	O'RING, #114	-
VH0037	PUSH-IN FTG, 1/4 x 1/8 NPT	1
VH0571	O'RING, #141	-
VH0572	RETAINING RING, HEAVY DUTY,	10
VH0573	SHCS, 10 - 32 x 3/8	20

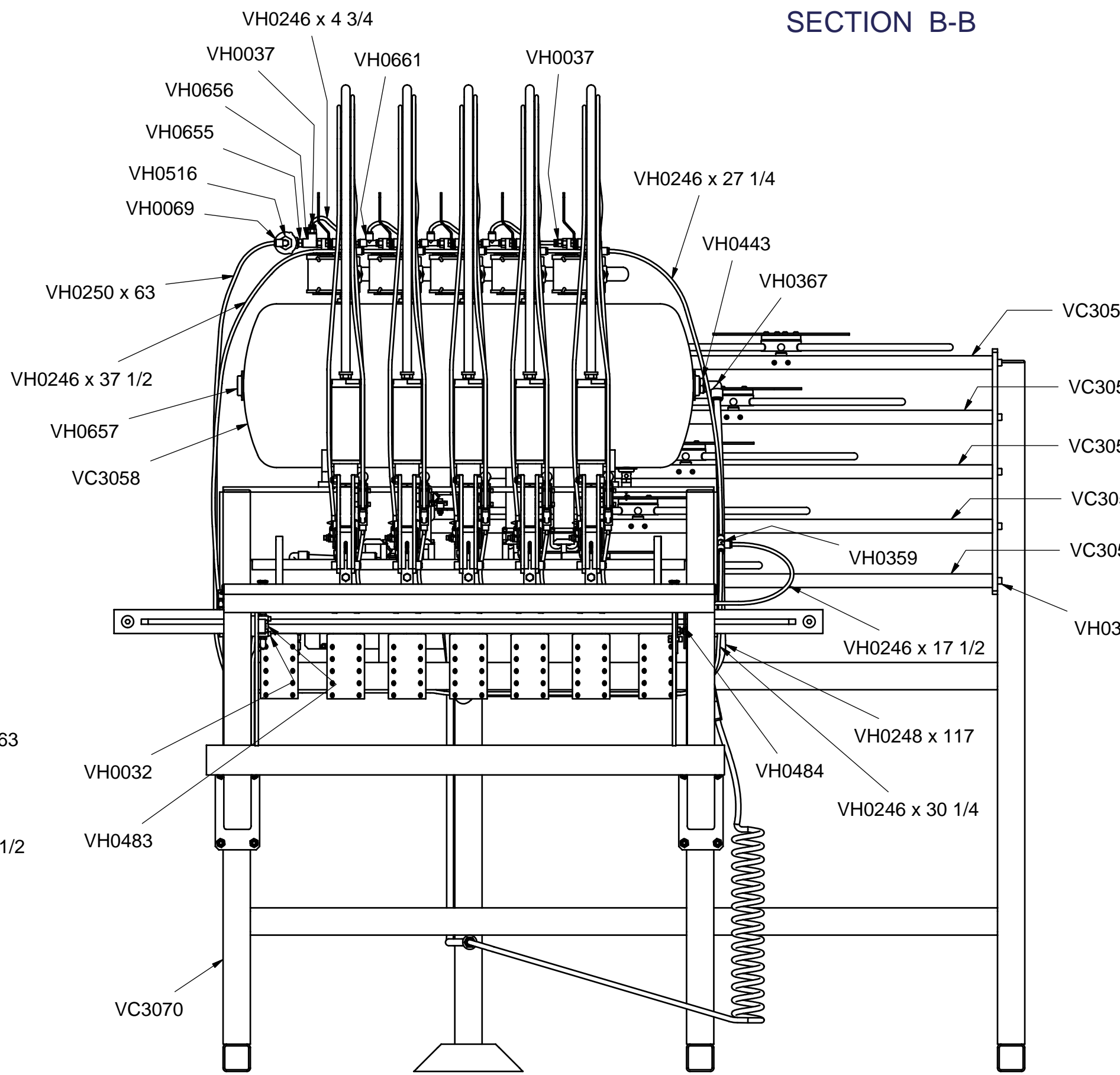
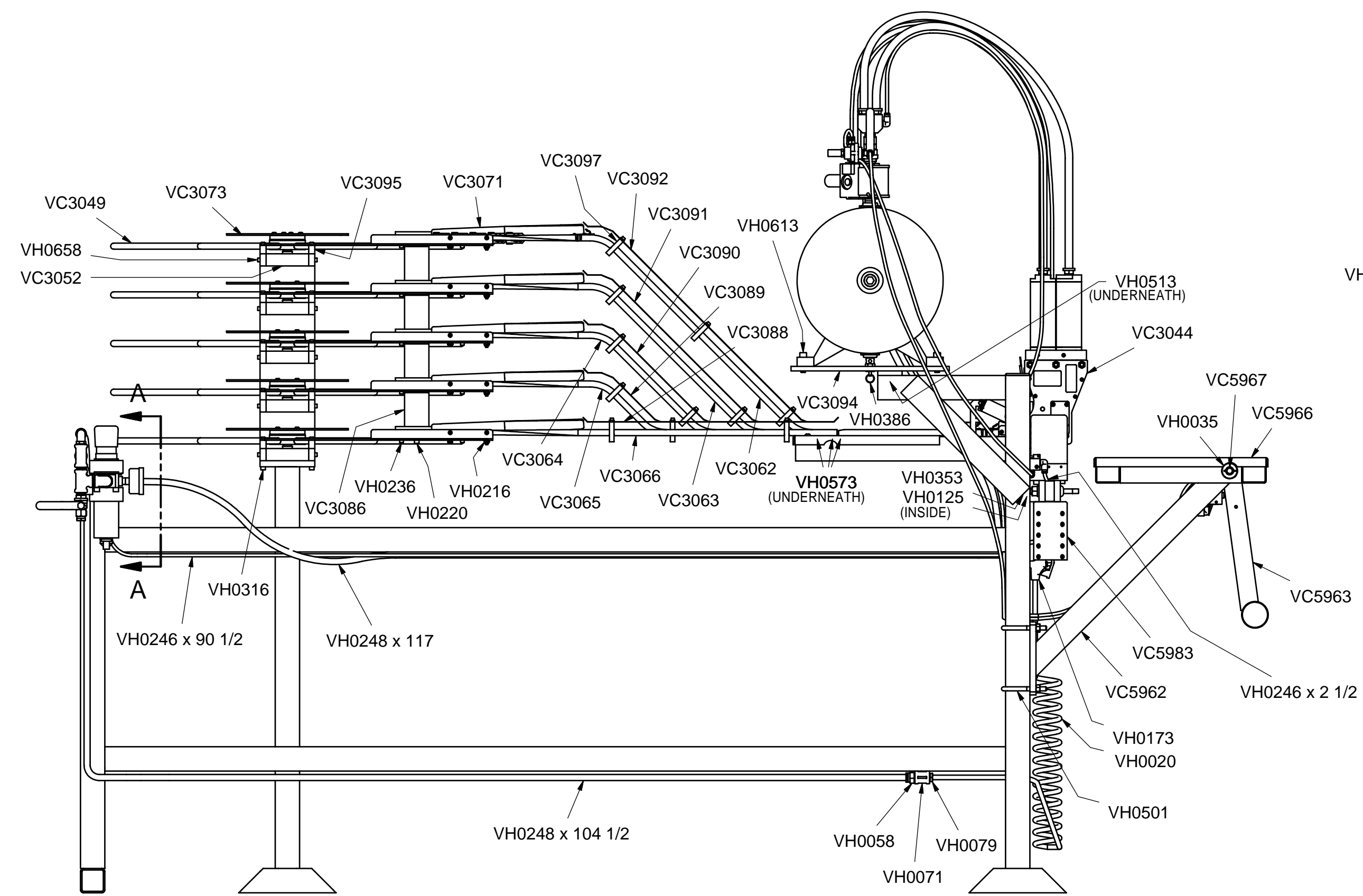
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						FINISH:

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	DWN BY JMW	
	APPD DA	
	DATE 3-15-05	
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INVENTOR	DWG. NO. VC5983	

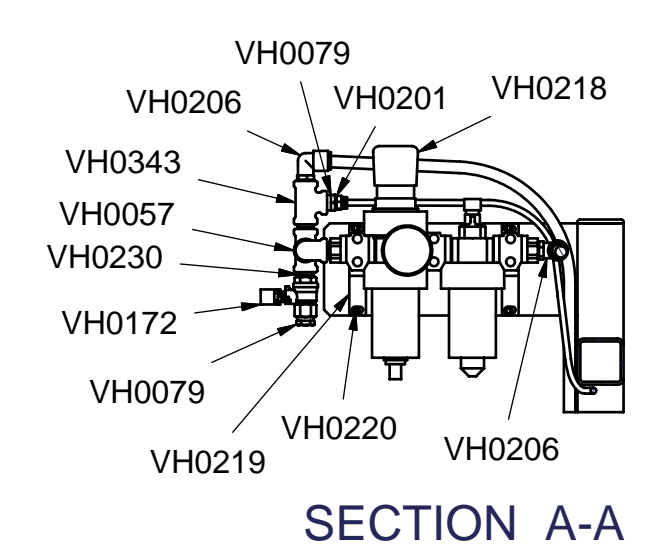
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SECTION B-B



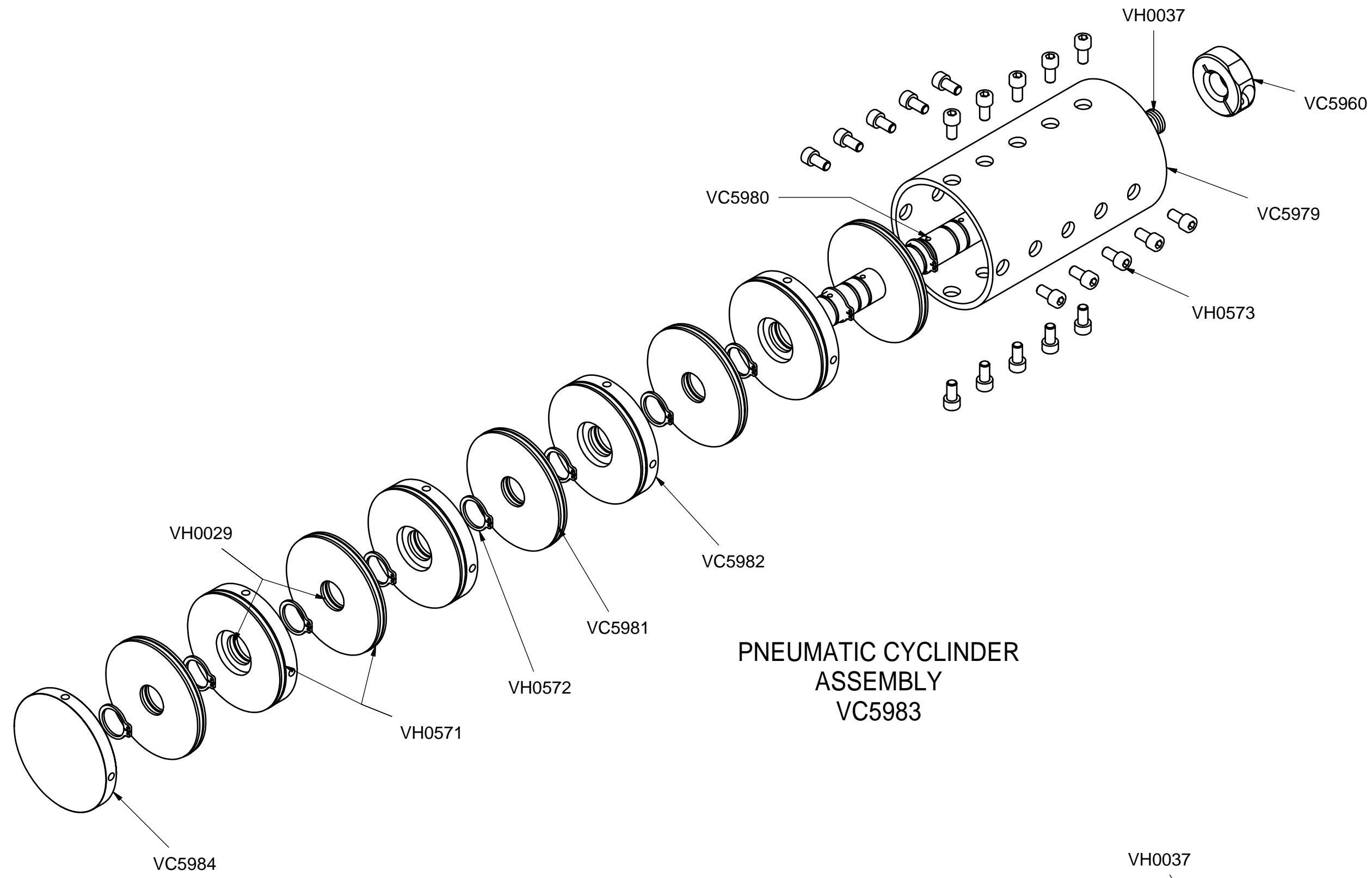
PART #	DESCRIPTION	QTY	PART #	DESCRIPTION	QTY	
VH0246 x 4 3/4	TUBING, 1/4, POLYETHYLENE	1	ANVIL	ANVIL	5	
VH0246 x 45	TUBING, 1/4, POLYETHYLENE	5	VC3044	FACE CLIP TOOL ASSEMBLY	5	
VH0246 x 46 1-2	TUBING, 1/4, POLYETHYLENE	5	VC3049	TURNTABLE ASSEMBLY	5	
VH0246 x 5	TUBING, 1/4, POLYETHYLENE	2	VC3052	PIVOT BLOCK	5	
VH0246 x 50	TUBING, 1/4, POLYETHYLENE	5	VC3053	DISK ARM - 16" DROP	2	
VH0246 x 6	TUBING, 1/4, POLYETHYLENE	1	VC3054	DISK ARM - 12" DROP	2	
VH0246 x 9 1/4	TUBING, 1/4, POLYETHYLENE	1	VC3055	DISK ARM - 8" DROP	2	
VH0246 x 90 1/2	TUBING, 1/2, POLYETHYLENE	1	VC3056	DISK ARM - 4" DROP	2	
VH0248 x 104 1/2	TUBING, 1/2, POLYETHYLENE	1	VC3057	DISK ARM	2	
VH0248 x 117	TUBING, 1/2, POLYETHYLENE	1	VC3058	TANK - 4 & 5 HEAD	1	
VH0250 x 250	TUBING, DUAL 1/4	1	VC3060	PLATFORM	5	
VH0250 x 63	TUBING, DUAL 1/4	1	VC3061	PLATFORM RAIL BASE	5	
VH0316	SHCS, 1/4 - 20 x 3/4	2	VC3062	RAIL 16.50	1	
VH0333	SHCS, 5/16 - 18 x 1	10	VC3063	RAIL 12.50	1	
VH0343	TEE, 3/8	2	VC3064	RAIL 8.50	1	
VH0353	HHCS, 1/2 - 13 x 1 1/2	2	VC3065	RAIL 4.50	1	
VH0359	PUSH-IN FTG, TEE, 1/4 OD	7	VC3066	RAIL	1	
VH0367	PUSH-IN FTG, 90, 1/2 x 1/2 NPT	1	VC3067	PLATFORM	1	
VH0386	SAFETY VALVE	1	VC3070	FACE CLIP 4000 FRAME ASSY	1	
VH0387	VLV, LVR HNDL BALL, 1/2 NPT	5	VC3071	ANGLE IRON COVER	5	
VH0391	BRASS FTG, 90, 1/4 x 1/8 NPT	9	VC3073	DISK CAP ASSEMBLY	5	
VH0401	BHCS, 1/2 - 13 x 2 1/2	2	VC3075	Y FITTING	5	
VH0405	NIPPLE, 1/2 NPT x 1	10	VC3076	TRANSFER RAIL	5	
VH0425 x 34	HOSE, 1/2 ID, BLUE	5	VC3086	PLATFORM SPACER	4	
VH0425 x 38	HOSE, 1/2 ID, BLUE	5	VC3088	COVER - STRAIGHT RAIL	1	
VH0425 x 50	HOSE, 1/2 ID, BLUE	5	VC3089	COVER - RAIL 4.5	1	
VH0425 x 38	HOSE, 1/2 ID, BLUE	5	VC3090	COVER - RAIL 8.5	1	
VH0426 x 2 1/2	HOSE, 1/2 ID, BLUE	5	VC3091	COVER - RAIL 12.5	1	
VH0426 x 3 3/4	HOSE, 1/2 ID, BLUE	5	VC3092	COVER - RAIL 16.5	1	
VH0426 x 4 3/4	HOSE, 1/2 ID, BLUE	5	VC3094	TANK BRACKET	10	
VH0426 x 5	HOSE, 1/2 ID, BLUE	5	VC3095	PLATFORM ARM SPACER	1	
VH0426 x 6	HOSE, 1/2 ID, BLUE	5	VC3097	RAIL BRACKET ASSEMBLY	14	
VH0426 x 9 1/4	HOSE, 1/2 ID, BLUE	5	VC3101	TOOL BASE	5	
VH0426 x 9 1/4	HOSE, 1/2 ID, BLUE	5	VC5920	SPACER	2	
VH0426 x 9 1/4	HOSE, 1/2 ID, BLUE	5	VC5924	STOP	2	
VH0426 x 9 1/4	HOSE, 1/2 ID, BLUE	5	VC5925	STOP BASE	2	
VH0426 x 9 1/4	HOSE, 1/2 ID, BLUE	5	VC5945	TOOL RAIL	1	
VH0426 x 9 1/4	HOSE, 1/2 ID, BLUE	5	VC5946	TOOL RAIL	1	
VH0426 x 9 1/4	HOSE, 1/2 ID, BLUE	5	VC5966	RAIL REST PLATFORM	1	
VH0426 x 9 1/4	HOSE, 1/2 ID, BLUE	5	VC5967	KNEE ASSEMBLY	1	
VH0426 x 9 1/4	HOSE, 1/2 ID, BLUE	5	VC5968	PLATFORM	1	
VH0426 x 9 1/4	HOSE, 1/2 ID, BLUE	5	VC5983	KNEE KNOCKER ROD	1	
VH0426 x 9 1/4	HOSE, 1/2 ID, BLUE	5	VC5983	SPACER	2	
VH0426 x 9 1/4	HOSE, 1/2 ID, BLUE	5	VC5983	PNEUMATIC CYL ASSEMBLY	7	
VH0426 x 9 1/4	HOSE, 1/2 ID, BLUE	5	VC5983	HOSE, RETENTION COIL	1	
VH0426 x 9 1/4	HOSE, 1/2 ID, BLUE	5	VC5983	SHCS, 10 - 24 x 1	3	
VH0426 x 9 1/4	HOSE, 1/2 ID, BLUE	5	VC5983	U-BOLT	2	
VH0426 x 9 1/4	HOSE, 1/2 ID, BLUE	5	VC5983	MUFFLER, 3/4 NPT	2	
VH0426 x 9 1/4	HOSE, 1/2 ID, BLUE	5	VC5983	SHCS, 3/8 - 16 x 1/2	2	
VH0426 x 9 1/4	HOSE, 1/2 ID, BLUE	5	VC5983	NUT, 1/2 - 13	2	
VH0426 x 9 1/4	HOSE, 1/2 ID, BLUE	5	VC5983	VALVE, QUICK EXHAUST	1	
VH0426 x 9 1/4	HOSE, 1/2 ID, BLUE	5	VC5983	MUFFLER, 1/4	1	
VH0426 x 9 1/4	HOSE, 1/2 ID, BLUE	5	VC5983	SHCS, 10 - 32 x 3/8	15	
VH0426 x 9 1/4	HOSE, 1/2 ID, BLUE	5	VC5983	CAP	4	
VH0426 x 9 1/4	HOSE, 1/2 ID, BLUE	5	VC5983	PUSH-IN FTG, 90, 1/4 x 1/8 NPT	8	
VH0426 x 9 1/4	HOSE, 1/2 ID, BLUE	5	VC5983	VH0069	3/8 NPT COUPLER	1
VH0426 x 9 1/4	HOSE, 1/2 ID, BLUE	5	VC5983	VH0613	BUSHING, HEX RDCR, 3/8 x 1/4	3
VH0426 x 9 1/4	HOSE, 1/2 ID, BLUE	5	VC5983	VH0653	SPACER, 1/2 OD x 3/8, #10	5
VH0426 x 9 1/4	HOSE, 1/2 ID, BLUE	5	VC5983	VH0655	SHCS, 10 - 32 x 5/8	10
VH0426 x 9 1/4	HOSE, 1/2 ID, BLUE	5	VC5983	VH0656	REDUCER HEX NPL, 1/4 x 1/8	4
VH0426 x 9 1/4	HOSE, 1/2 ID, BLUE	5	VC5983	VH0656	TEE, BRASS, 1/8, F x F x M	5
VH0426 x 9 1/4	HOSE, 1/2 ID, BLUE	5	VC5983	VH0657	PLUG, 3/4 NPT	5
VH0426 x 9 1/4	HOSE, 1/2 ID, BLUE	5	VC5983	VH0658	SHCS, 10 - 24 x 3/4	20
VH0426 x 9 1/4	HOSE, 1/2 ID, BLUE	5	VC5983	VH0660	NUT, NYLOCK, 1/4 - 20	4
VH0426 x 9 1/4	HOSE, 1/2 ID, BLUE	5	VC5983	VH0661	PUSH-IN FTG, T, 1/4 x 1/8 NPT	3
VH0426 x 9 1/4	HOSE, 1/2 ID, BLUE	5	VC5983	VH0199	BHCS, 1/4 - 20 x 5/8	4
VH0426 x 9 1/4	HOSE, 1/2 ID, BLUE	5	VC5983	VH0201	PUSH-IN FTG, ST, 1/4 x 1/4 NPT	1
VH0426 x 9 1/4	HOSE, 1/2 ID, BLUE	5	VC5983	VH0206	PUSH-IN FTG, 90, 1/2 x 3/8 NPT	2
VH0426 x 9 1/4	HOSE, 1/2 ID, BLUE	5	VC5983	VH0216	NUT, NYLOCK, 10 - 32	10
VH0426 x 9 1/4	HOSE, 1/2 ID, BLUE	5	VC5983	VH0218	FILTER/REG LUBRICATOR	1
VH0426 x 9 1/4	HOSE, 1/2 ID, BLUE	5	VC5983	VH0219	BRACKET	2
VH0426 x 9 1/4	HOSE, 1/2 ID, BLUE	5	VC5983	VH0220	SHCS, 1/4 - 20 x 1/2	8
VH0426 x 9 1/4	HOSE, 1/2 ID, BLUE	5	VC5983	VH0230	NIPPLE, 3/8 NPT	4
VH0426 x 9 1/4	HOSE, 1/2 ID, BLUE	5	VC5983	VH0233	WASHER, FLAT, 1/2	3
VH0426 x 9 1/4	HOSE, 1/2 ID, BLUE	5	VC5983	VH0236	SHCS, 10 - 24 x 3/8	10
VH0426 x 9 1/4	HOSE, 1/2 ID, BLUE	5	VC5983	VH0246	TUBING, 1/4, POLYETHYLENE	1
VH0426 x 9 1/4	HOSE, 1/2 ID, BLUE	5	VC5983	VH0246 x 17 1/2	TUBING, 1/4, POLYETHYLENE	2
VH0426 x 9 1/4	HOSE, 1/2 ID, BLUE	5	VC5983	VH0246 x 2 1/2	TUBING, 1/4, POLYETHYLENE	1
VH0426 x 9 1/4	HOSE, 1/2 ID, BLUE	5	VC5983	VH0246 x 2 1/2	TUBING, 1/4, POLYETHYLENE	1
VH0426 x 9 1/4	HOSE, 1/2 ID, BLUE	5	VC5983	VH0246 x 3 3/4	TUBING, 1/4, POLYETHYLENE	1
VH0426 x 9 1/4	HOSE, 1/2 ID, BLUE	5	VC5983	VH0246 x 30 1/4	TUBING, 1/4, POLYETHYLENE	1
VH0426 x 9 1/4	HOSE, 1/2 ID, BLUE	5	VC5983	VH0246 x 37 1/2	TUBING, 1/4, POLYETHYLENE	1



SECTION A-A

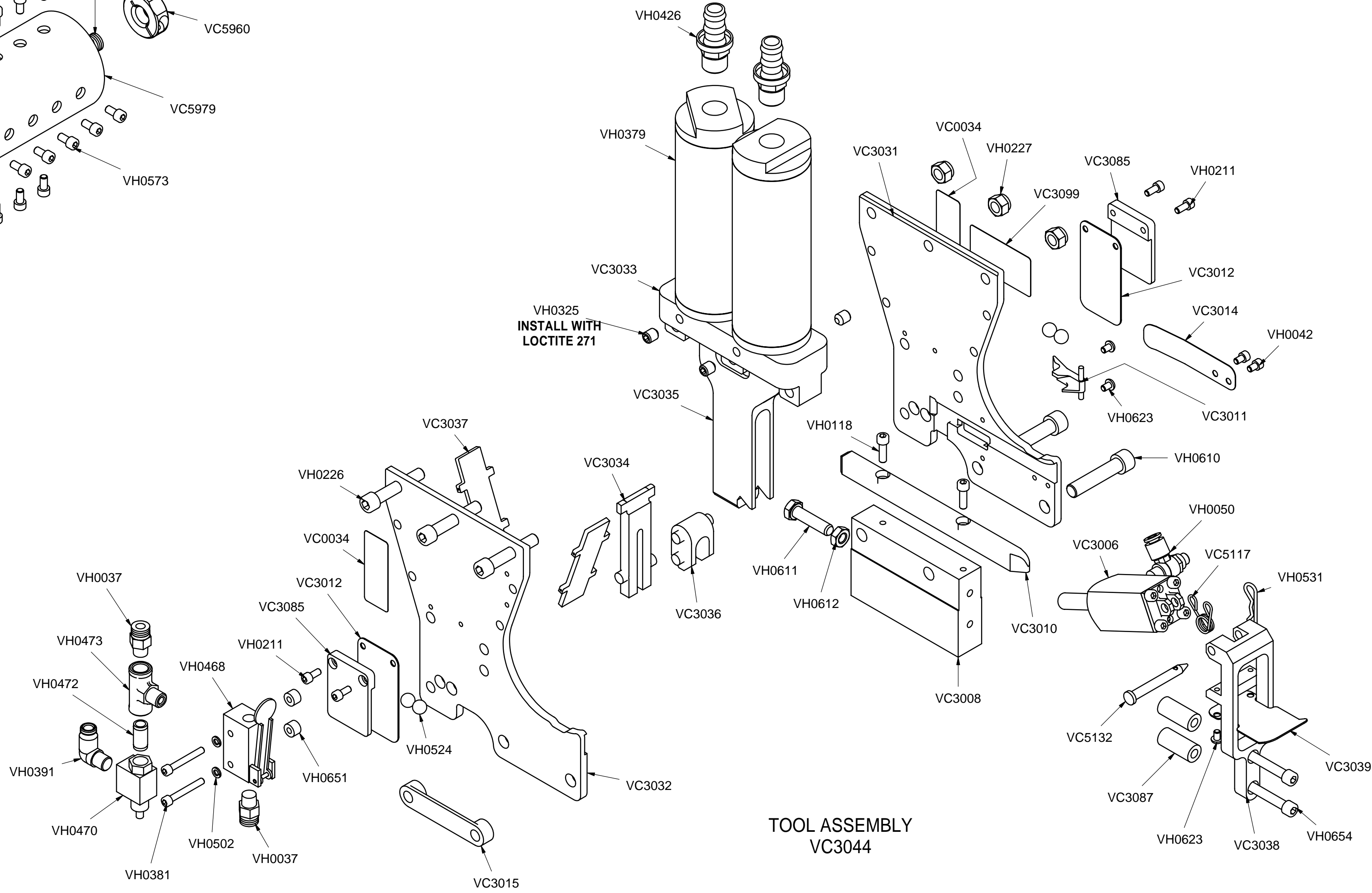
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REV	ECN	DESCRIPTION	BY	APPD	DATE	MATERIAL:	TOL. UNLESS SPECIFIED	© 2007	VERTEX FASTENERS
A	824	WAS R15915 NOW VC3101	JMW	DA	10-15-07		INCHES X=.005 XX=.015 XXX=.035 ANGLES ±1/2	DWN BY JMW	SKOKIE, IL 60076 U.S.A.
						HEAT TREATMENT:		APPD DA	FACE CLIP 5 HEAD ASSEMBLY
						FINISH:		DATE 3-17-07	
								SCALE 1:8	
								DWG. NO. VC3059	PAGE 1 OF 2



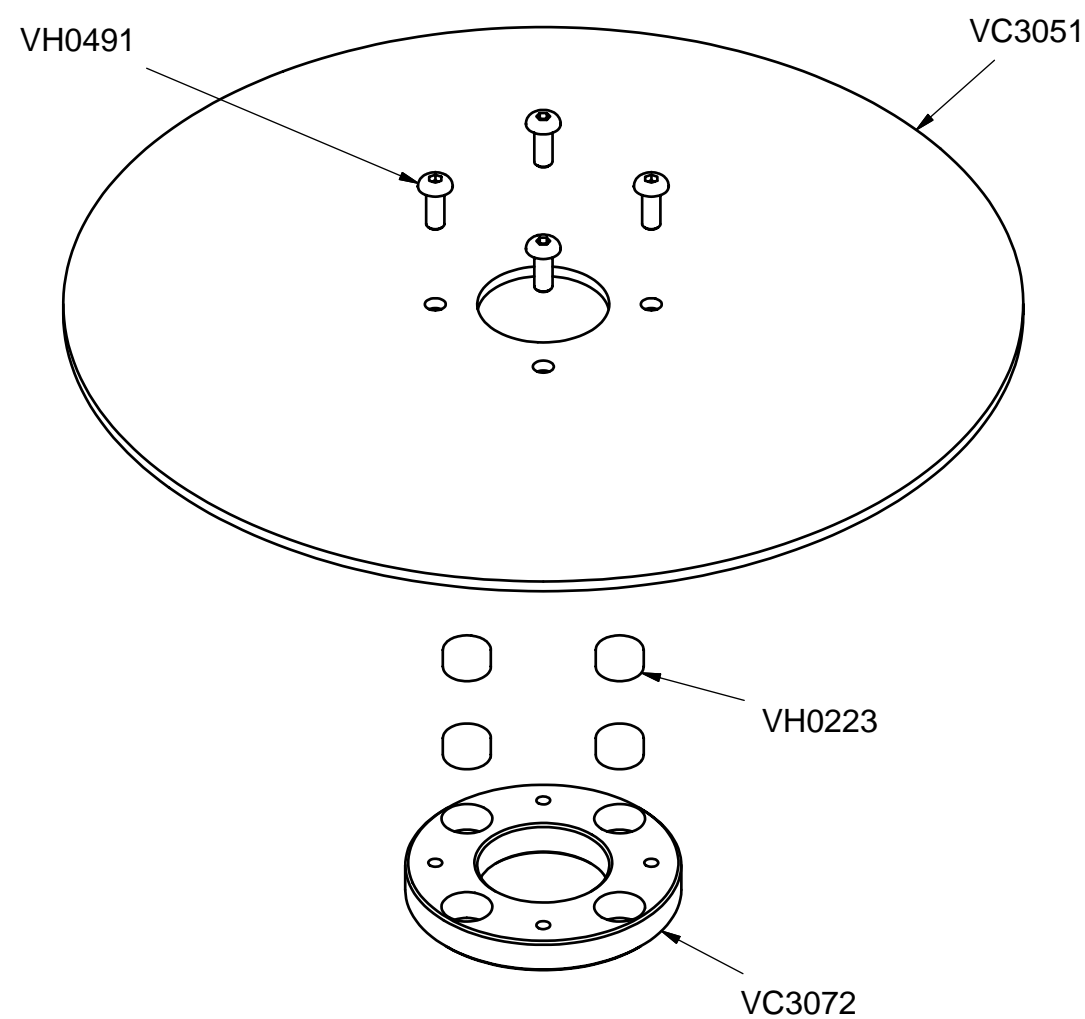
**PNEUMATIC CYLINDER ASSEMBLY
VC5983**

PNEUMATIC CYLINDER ASSEMBLY		
PART #	DESCRIPTION	QTY
VC5960	CLAMP COLLAR	1
VC5979	PNEUMATIC CYLINDER	1
VC5980	PNEUMATIC CYLINDER ROD	1
VC5981	PNEUMATIC CYLINDER PISTON	5
VC5982	PNEUMATIC CYLINDER PARTITION	4
VC5984	PNEUMATIC CYLINDER END CAP	1
VH0029	O-RING, #114	-
VH0037	PUSH-IN FTG, 1/4 x 1/8 NPT	1
VH0571	O-RING, #141	-
VH0572	RETAINING RING, HEAVY DUTY,	10
VH0573	SHCS, 10 - 32 x 3/8	20



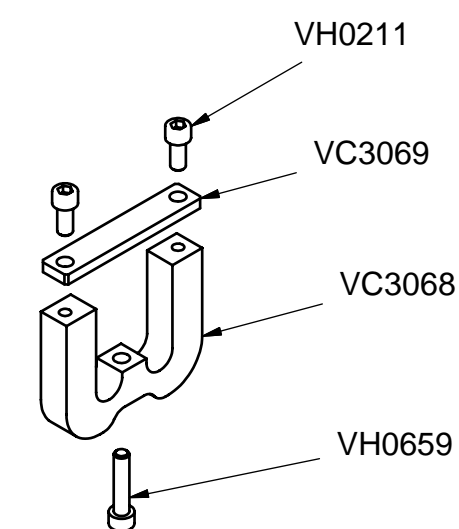
**TOOL ASSEMBLY
VC3044**

VC3044 - TOOL ASSEMBLY		
PART #	DESCRIPTION	QTY
VC0034	WARNING LABEL	2
VC3006	CLIP FEEDER ASSEMBLY	1
VC3008	TOOL MOUNT	1
VC3010	RAIL - TOOL MOUNT	1
VC3011	PAWL	1
VC3012	BALL BEARINGS SPRING	2
VC3014	PAWL SPRING	1
VC3015	STRAP NUT	1
VC3031	LEFT-HAND SIDE PLATE	1
VC3032	RIGHT-HAND SIDE PLATE	1
VC3033	CYLINDER MOUNT	1
VC3034	FRONT PLATE	1
VC3035	BLADE	1
VC3036	BLADE GUIDE	1
VC3037	GUARD	2
VC3038	FEEDER BRACKET	1
VC3039	COVER	1
VC3085	SPRING RESTRICTOR	2
VC3087	SPACER, 1/2 x 1 1/8, 1/4	2
VC3099	FACECLIPPER LABEL	1
VC5117	TORSION SPRING	1
VC5132	PIN, FEED CYLINDER	1
VH0037	PUSH-IN FTG, 1/4 x 1/8 NPT	2
VH0042	SHCS, 8 - 32 x 1/4	2
VH0050	FLOW CONTROL	1
VH0118	SHCS, 10 - 32 x 5/8	2
VH0211	SHCS, 8 - 32 x 3/8	4
VH0226	SHCS, 5/16 - 24 x 1 3/4	3
VH0227	NUT, NYLOCK, 5/16 - 24	3
VH0325	SET SCREW, 5/16 - 18 x 3/8	4
VH0379	CYLINDER	2
VH0381	SHCS, 8 - 32 x 1 1/4	2
VH0391	BRASS FTG, 90, 1/4 x 1/8 NPT	1
VH0426	HOSE BARB, 1/2 x 3/8 NPT	2
VH0468	LIMIT VALVE	1
VH0470	VALVE, PUSH BUTTON	1
VH0472	NIPPLE 1/8	1
VH0473	TEE, 1/8	1
VH0502	WASHER, LOCK, #8	2
VH0524	3/8 CHROME BALL	4
VH0531	HAIR PIN	1
VH0610	SHCS, 3/8 - 24 x 1 3/4	2
VH0611	HHCS, 5/16 - 18 x 1 1/4	1
VH0612	NUT, JAM, 5/16 - 18	1
VH0623	BHCS, 8 - 32 x 1/4	4
VH0651	SPACER, 3/8 OD x 1/4, #8	2
VH0654	SHCS, 1/4 - 20 x 1 3/4	2



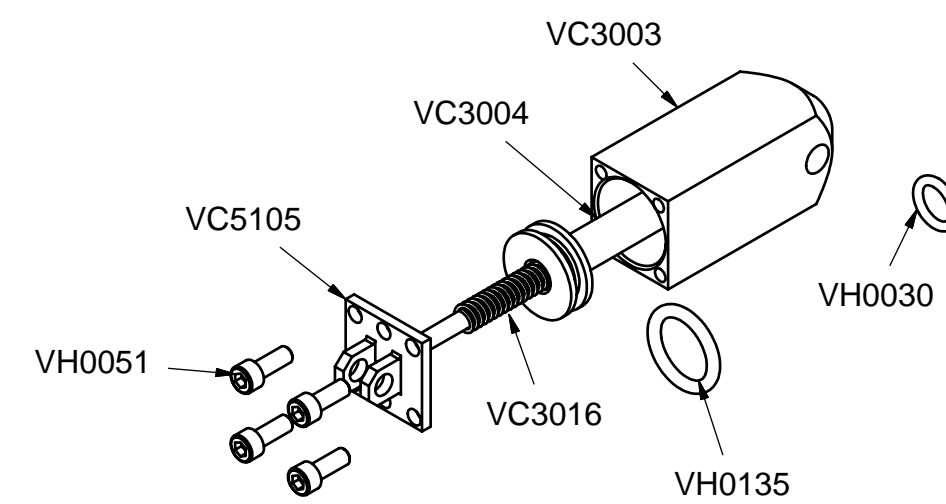
**DISK CAP ASSEMBLY
VC3073**

VC3073 - DISK CAP ASSEMBLY		
PART #	DESCRIPTION	QTY
VC3051	DISK CAP	1
VC3072	DISK CAP HUB	1
VH0223	MAGNET	4
VH0491	BHCS, 10 - 24 x 1/2	4



**RAIL BRACKET ASSEMBLY
VC3097**

VC3097 - RAIL BRACKET ASSEMBLY		
PART #	DESCRIPTION	QTY
VC3068	COVER BRACKET	1
VC3069	COVER BRACKET PLATE	1
VH0211	SHCS, 8 - 32 x 3/8	2
VH0659	SHCS, 8 - 32 x 3/4	1



**CLIP FEEDER ASSEMBLY
VC3006**

VC3006 - CLIP FEEDER ASSEMBLY		
PART #	DESCRIPTION	QTY
VC3003	CYLINDER BODY	1
VC3004	PISTON	1
VC3016	CLIP FEEDER SPRING	1
VC5105	CYLINDER END CAP	1
VH0030	O-RING, #111	-
VH0051	SHCS, 10 - 32 x 1/2	4
VH0135	O-RING, #210	-

REV	ECN	DESCRIPTION	BY	APPD	DATE	MATERIAL:	TOL UNLESS SPECIFIED
A	824	WAS R15915 NOW VC3101	JMW	DA	10-15-07	HEAT TREATMENT:	INCHES 3/4" = .005 XX = .015 XXX = .005 ANGLES # 1/2
						FINISH:	

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DWN BY	JMW	FACE CLIP 5 HEAD ASSEMBLY	
APPD	DA		
DATE	3-17-07		
SCALE	1:2		
DWG. NO.	VC3059	PAGE 2 OF 2	D