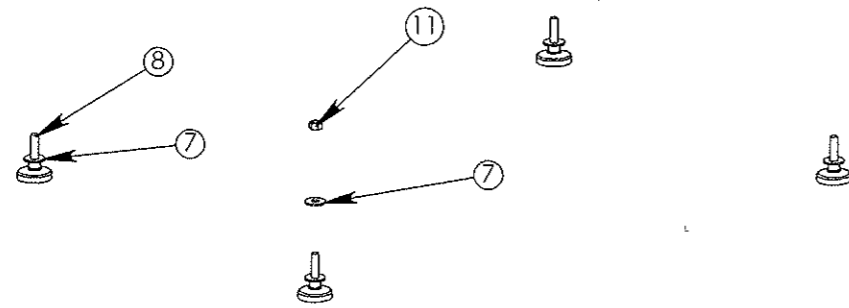
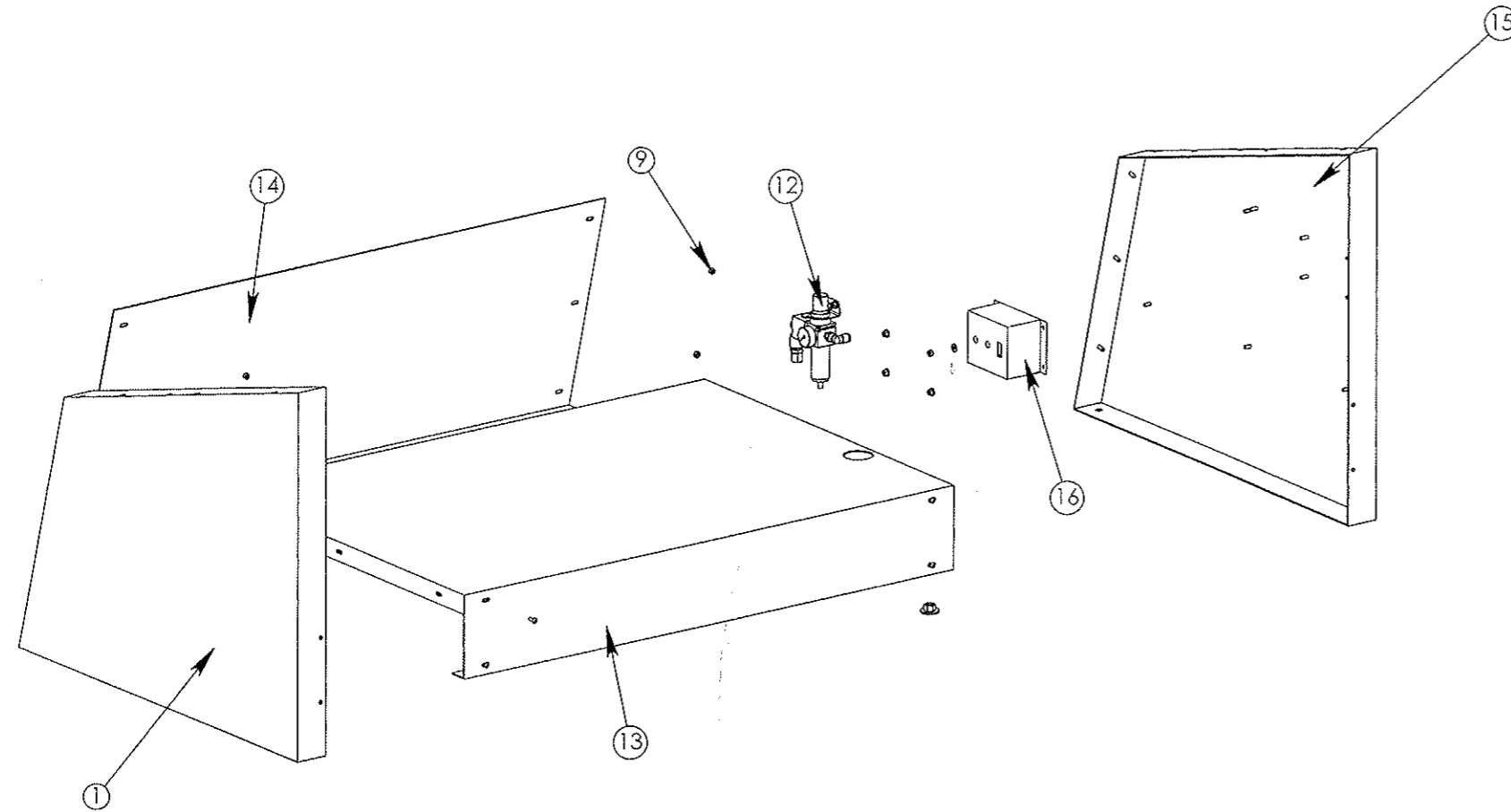


ITEM NO.	QTY	PART NO.	DESCRIPTION	TYPE	VENDOR	VENDOR NO.
1	1	21714	BASE ASSEMBLY	A	NTR	
2	1	21715	UPPER SHEETMETAL	A	NTR	
3	1	BG702307	MAIN CRIMPER ASSEMBLY	A	NTR	
4	1	21774	Bottom Cover	SM	OMV	
5	4	14882 (#12 FW)	WASHER	F	ANB	
6	5	1180-04 (16mm)	M6 X 1.0 SHSC	F	ANB	
7	2	1354-06 (20mm)	M8 X 1.25 SHCS	F	ANB	
8	4	2951-04 (20mm)	M10 X 1.5 SHSC	F	ANB	
9	4	1204 (M10 X 1.5)	M10 X 1.5 HN	F	ANB	

	Bemaßung [DIMENSIONS] INCHES ----- [mm]		Material/Purchased Part SEE BOM	
	General Tolerances DIN ISO 2768-mk Form and Positional Tolerance DIN ISO 1101 Workpiece edge DIN 6784 Surface Finish DIN ISO 1302		Masstab Scale 1:10	Gewicht Weight
	Allgemeintoleranzen DIN ISO 2768-mk Form- und Lagetoleranzen DIN ISO 1101 Werkstueckkanten DIN 6784 Oberflaechen DIN ISO 1302		Benennung, Title POLYFORM 107, MITSUBISHI	
	Drawn by Approved by	Date 07-14-03	Init TJC	Zeichnungsnummer, Drawing No. BG702305
REV REV. NUMBER DATE INIT.	1 1	Blatt Sheet 1	Format DIN B	

REV	ECO #	DATE	BY	REVISIONS
A	1673	12/10/98	JDG	ORIGNIAL
B	-	12/16/00	JDG	CHANGED TO NEW REGULATER ASSEMBLY



ITEM NO.	QTY	PART NO.	DESCRIPTION	TYPE	VENDOR	VENDOR NO.	SP
1	1	21761	STAND, LEFT SIDE	SM	OMV		
13	1	21763C	BOTTOM TRAY	SM	OMV		
15	1	21762B	STAND, RIGHT SIDE	SM	OMV		
14	1	21764B	FRONT PANNEL	SM	OMV		
16	1	19127B	ELECTRICAL COVER	SM	OMV		
6	4	3604-05	M6 X 1.0 BHCS	F	ANB		
7	8	14864 (1-2 FW)	WASHER	F	ANB		N
8	4	14660	Leveling_Foot (McMaster 6167K13)	H	MCC	6167K13	
9	22	5551 (M6 X 1.0)	METRIC HN	F	ANB		
10	6	14882 (#12 FW)	WASHER	F	ANB		N
11	4	1-2-13 Nut	1/2-20 UNC HEX JAM NUT	F	ANB		
12	1	27482A	FILTER/REGULATOR/SHUTOFF	H	AUT	AFP610-0	N

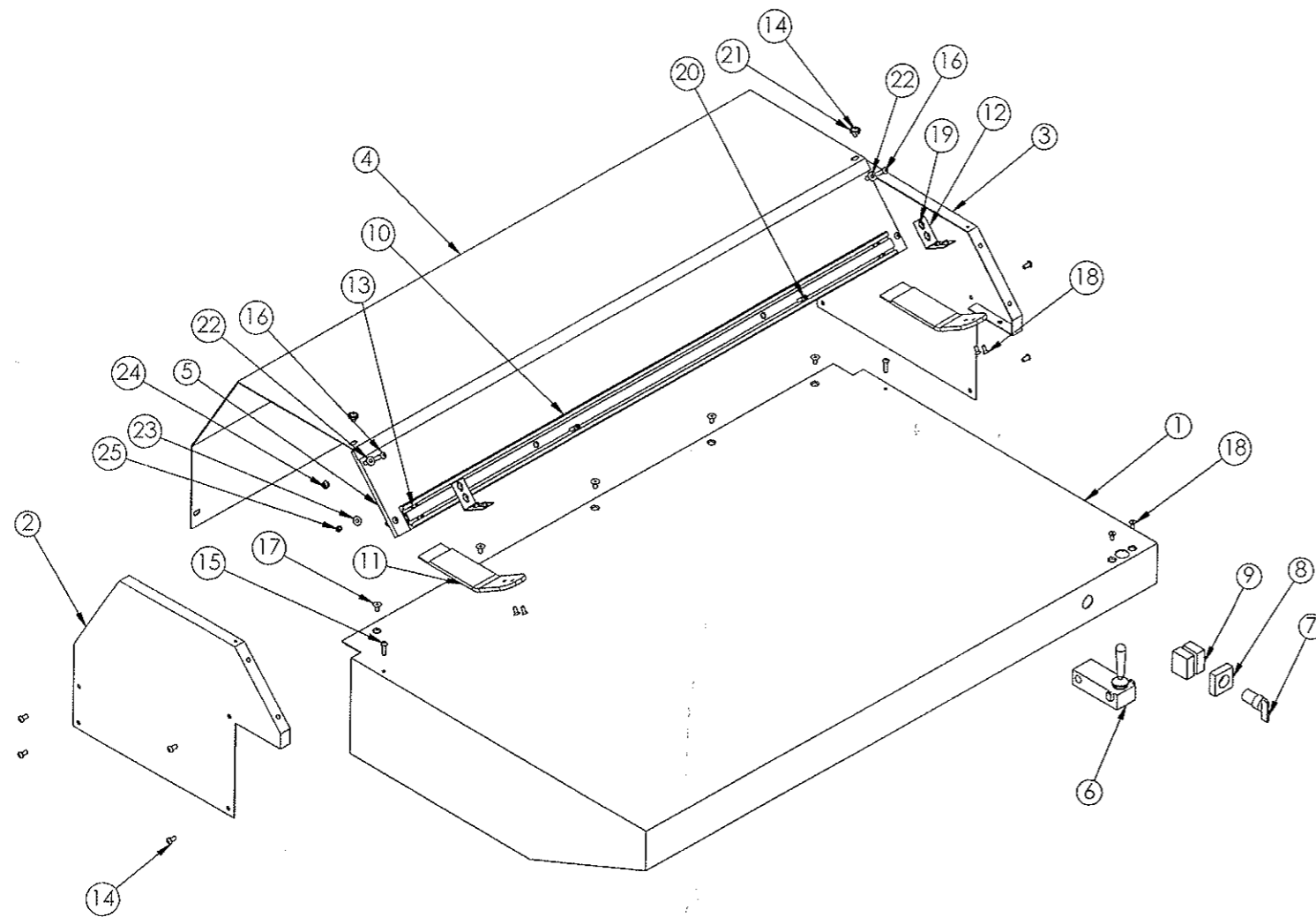
MATERIAL	14 GAUGE MILD SHEETMETAL
HEAT TREAT	N.A.
HARDNESS	N.A.
FINISH	H.B. FULLER IF2336 CHAMPAGNE
NEXT ASS'Y	N.A.

DIMENSIONS ARE IN INCHES	
TOLERANCES UNLESS NOTED ANSI Y14.5M-1982	
TWO PLACES	±.01
THREE PLACES	±.005
ANGULAR	±0°.30'
SURFACE FINISH	125/
BREAK SHARP CORNERS .020	

THIS DOCUMENT CONTAINS PROPRIETARY DATA OF:
TERNES REGISTER SYSTEM
NO DISCLOSURE, REPRODUCTION OR USE OF ANY PART THEREOF MAY BE MADE WITHOUT WRITTEN PERMISSION

TERNES REGISTER SYSTEM			
4851 WHIT BEAR PKWY, WHIT BEAR TWP, MN 55110 1-612-407-4800 FAX 1-612-407-4801			
TITLE		BASE ASSEMBLY	
SCALE	PROJECTION	DWG. SIZE	
NONE		B	
APP'D BY	DRAWN BY	DATE	DWG./PART NO.
	JDG	12/11/98	21714
		REV. NO.	B

REV	ECO.#	DATE	BY	REVISIONS
A	1673	12/10/98	JDG	ORIGINAL
B	N.A.	12/10/98	TJC	ADDED PLATE GUIDE COMPONENTS



ITEM NO.	QTY	PART NO.	DESCRIPTION	TYPE	VENDOR	VENDOR NO.
1	1	21754	Table_Top	SM	OMV	
2	1	21752	Right Side Cover	SM	OMV	
3	1	21753	Left Side Cover	SM	OMV	
4	1	21751	Top Cover	SM	OMV	
5	1	6579B	Guard	M	OMV	
6	1	14672	Control_Valve (Schrader Bellows 52981 1000	H	OMV	
7	1	17975	Three Position Switch (Parker 2B2BJ3P)	H	OMV	
8	1	17976	Mounting Base (Parker 2B2B2009P)	H	OMV	
9	2	17977	Single Switch Body (Parker PXBB1911P)	H	OMV	
10	1	EZ703610	RAIL, PLATE GUIDE MOUNT	M	NTR	
11	2	EZ703608	GUIDE, PLATE, PLEXIGLASS	M	OMV	
12	2	EZ703611	BRACKET, PLATE GUIDE	M	OMV	
13	4	EK700918	ITEM T-SLOT NUT, M5, 5MM SLOT	H	OMV	
14	12	3604-04	M6 X 1.0 BHCS	F	ANB	
15	2	3604-06	M6 X 1.0 BHCS	F	ANB	
16	4	3604-07	M6 X 1.0 BHCS	F	ANB	
17	5	1590-03 (12mm)	M6 X 1.0 FHCS	F	ANB	
18	6	2293-03 (12mm)	M5 X .8 FHSC	F	ANB	
19	4	1192-01 (6mm)	M5 X 1.0 BHCS	F	ANB	
20	2	1612-05 (18mm)	M5 X 1.0 SHCS	F	ANB	
21	4	16160 (1-4 ZIP)	WASHER	F	ANB	
22	4	14882 (#12 FW)	WASHER	F	ANB	
23	2	14863 (#10 FW)	WASHER	F	ANB	
24	4	5551 (M6 X 1.0)	METRIC HN	F	ANB	
25	6	14880	METRIC HN	F	ANB	

MATERIAL	N.A.
HEAT TREAT	N.A.
HARDNESS	N.A.
FINISH	N.A.
NEXT ASS'Y	N.A.

DIMENSIONS ARE IN INCHES
 TOLERANCES UNLESS NOTED
 ANSI Y14.5M-1982
 TWO PLACES ±.01
 THREE PLACES ±.005
 ANGULAR ±0°.30'
 SURFACE FINISH 125
 BREAK SHARP CORNERS .020

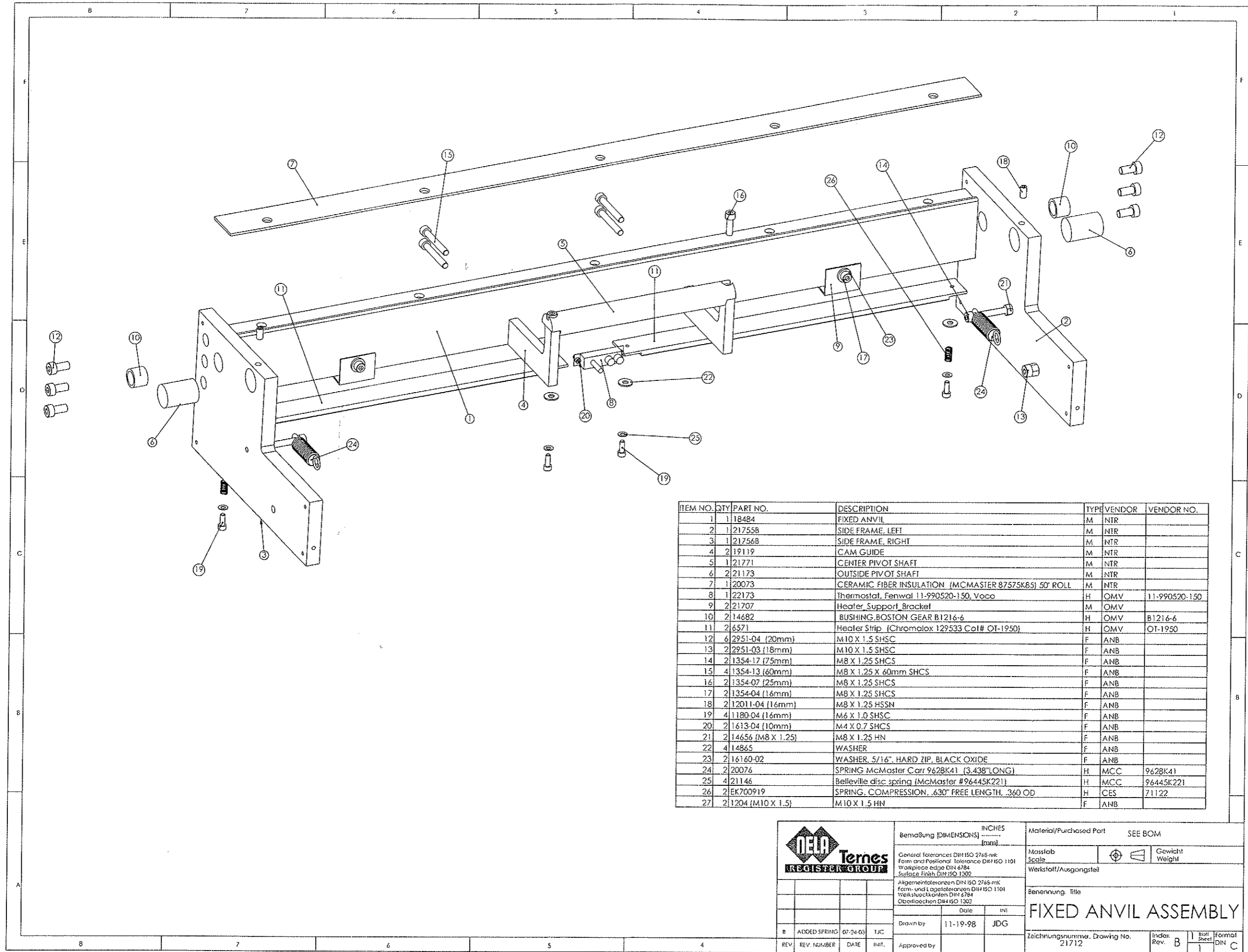
THIS DOCUMENT CONTAINS
 PROPRIETARY DATA OF:
 TERNES REGISTER SYSTEM
 NO DISCLOSURE, REPRODUCTION
 OR USE OF ANY PART THEREOF
 MAY BE MADE WITHOUT
 WRITTEN PERMISSION

TERNES REGISTER SYSTEM

4851 WHI BEAR PKWY, WHI BEAR TWP, MN 55110 1-612-407-4800 FAX 1-612-407-4801

TITLE
Upper Sheetmetal Assembly

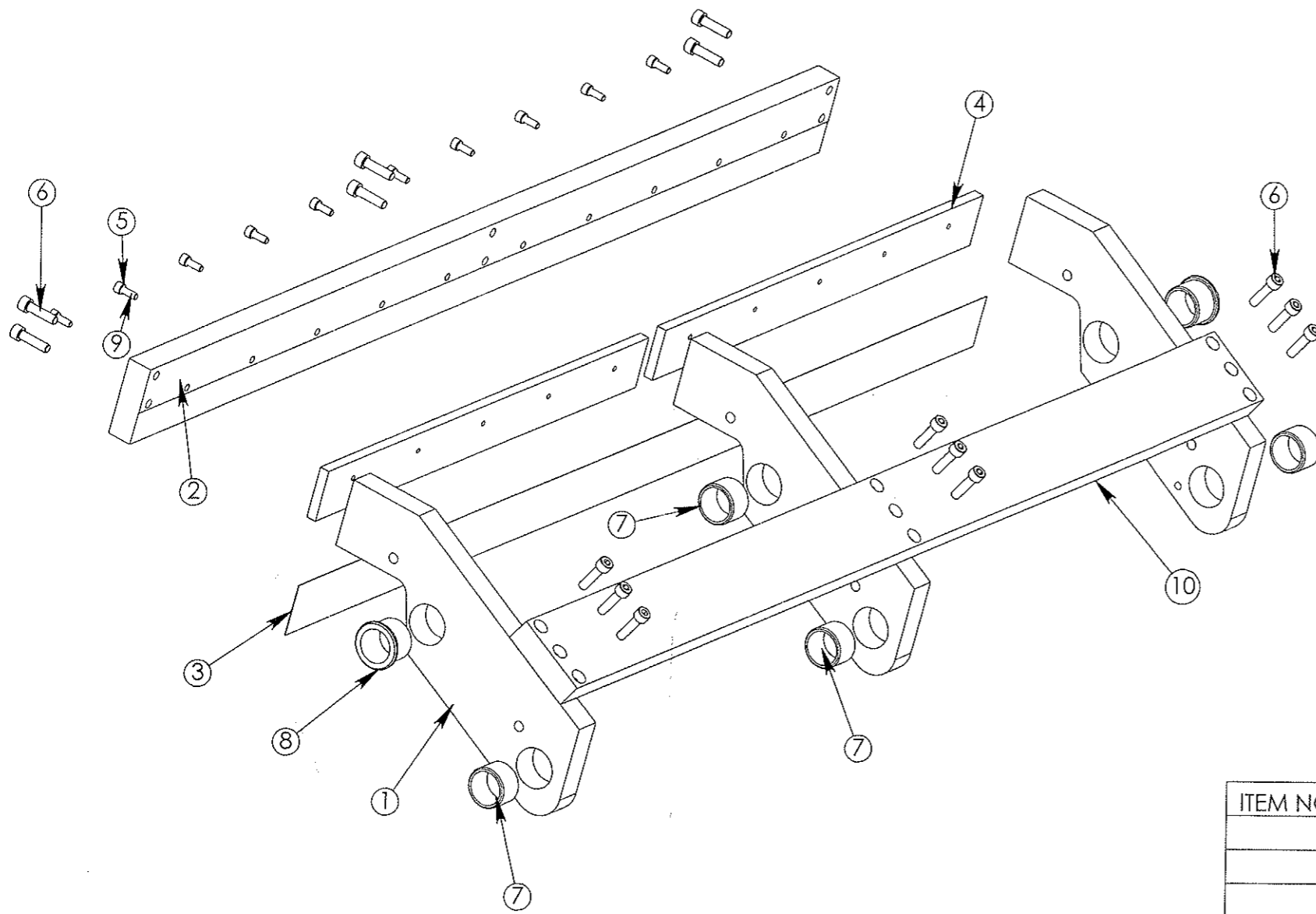
SCALE NONE	PROJECTION 	DWG. SIZE B
APP'D BY	DRAWN BY JDG	DATE 10/22/98
	DWG./PART NO. 21715	REV. NO. B



ITEM NO.	QTY	PART NO.	DESCRIPTION	TYPE	VENDOR	VENDOR NO.
1	1	18484	FIXED ANVIL	M	NTR	
2	1	21755B	SIDE FRAME, LEFT	M	NTR	
3	1	21756B	SIDE FRAME, RIGHT	M	NTR	
4	2	19119	CAM GUIDE	M	NTR	
5	1	21771	CENTER PIVOT SHAFT	M	NTR	
6	2	21173	OUTSIDE PIVOT SHAFT	M	NTR	
7	1	20073	CERAMIC FIBER INSULATION (MCMaster 87575K85) 50' ROLL	M	NTR	
8	1	22173	Thermostat, Fenwal 11-990520-150, Voco	H	OMV	11-990520-150
9	2	21707	Heater Support Bracket	M	OMV	
10	2	14682	BUSHING, BOSTON GEAR B1216-6	H	OMV	B1216-6
11	2	6571	Heater Strip (Chromalox 129533 Cat# OT-1950)	H	OMV	OT-1950
12	6	2951-04 (20mm)	M10 X 1.5 SHCS	F	ANB	
13	2	2951-03 (18mm)	M10 X 1.5 SHCS	F	ANB	
14	2	1354-17 (75mm)	M8 X 1.25 SHCS	F	ANB	
15	4	1354-13 (60mm)	M8 X 1.25 X 60mm SHCS	F	ANB	
16	2	1354-07 (25mm)	M8 X 1.25 SHCS	F	ANB	
17	2	1354-04 (16mm)	M8 X 1.25 SHCS	F	ANB	
18	2	12011-04 (16mm)	M8 X 1.25 HSSN	F	ANB	
19	4	1180-04 (16mm)	M6 X 1.0 SHCS	F	ANB	
20	2	1613-04 (10mm)	M4 X 0.7 SHCS	F	ANB	
21	2	14656 (M8 X 1.25)	M8 X 1.25 HN	F	ANB	
22	4	14865	WASHER	F	ANB	
23	2	16160-02	WASHER, 5/16", HARD ZIP, BLACK OXIDE	F	ANB	
24	2	20076	SPRING McMaster Carr 9628K41 (3.438" LONG)	H	MCC	9628K41
25	4	21146	Belleville disc spring (McMaster #96445K221)	H	MCC	96445K221
26	2	EK700919	SPRING, COMPRESSION, .630" FREE LENGTH, .360 OD	H	CES	71122
27	2	1204 (M10 X 1.5)	M10 X 1.5 HN	F	ANB	

	INCHES Bemessung [DIMENSIONS] [mm]	Material/Purchased Part SEE BOM
	General Tolerances DIN ISO 2768-mS Form and Positional Tolerance DIN ISO 1101 Workpiece edge DIN 6784 Surface Finish DIN ISO 1302	Maßstab Scale
Allgemeine Toleranzen DIN ISO 2768-mK Form- und Lagetoleranzen DIN ISO 1101 Werkstoffarten DIN 6784 Oberflächen DIN ISO 1302	Werkstoff/Ausgangsmaterial	Benennung, Title FIXED ANVIL ASSEMBLY
Drawn by 11-19-98 JDG	Date 11-19-98 Init. JDG	Zeichnungsnummer, Drawing No. 21712
Approved by	Index Rev. B	Blatt 1 Formal DIN C

REV.	ECO #	DATE	BY	REVISIONS
A	1673	12/10/98	JDG	ORIGINAL



ITEM NO.	QTY.	PART NO.	DESCRIPTION
1	3	19115	ROTATE ARM
2	1	19114	BLADE HOLDER
3	1	19113	BLADE, McMaster Carr 9036k11, 2"X.018" BLUE SPRING STEEL
4	2	19116	BLADE CLAMP
5	16	3723-7 (5mm)	RIBBED WASHER
6	15	1354-08 (30mm)	M8 X 1.25 SHCS
7	4	21765	BRONZE BUSHING, BOSTON B2024-8, Berry Bearing
8	2	21767	FLANGED BUSHING, BOSTON FB2024-8, Berry Bearing
9	10	1180-04 (16mm)	M6 X 1.0 SHSC
10	1	21766	BRACE BAR

MATERIAL	N.A.
HEAT TREAT	N.A.
HARDNESS	N.A.
FINISH	N.A.
NEXT ASS'Y	N.A.

DIMENSIONS ARE IN INCHES
 TOLERANCES UNLESS NOTED
 ANSI Y14.5M-1982
 TWO PLACES ±.01
 THREE PLACES ±.005
 ANGULAR ±0°.30'
 SURFACE FINISH 125
 BREAK SHARP CORNERS .020

THIS DOCUMENT CONTAINS
 PROPRIETARY DATA OF:
 TERNES REGISTER SYSTEM
 NO DISCLOSURE, REPRODUCTION
 OR USE OF ANY PART THEREOF
 MAY BE MADE WITHOUT
 WRITTEN PERMISSION

APP'D BY
 DRAWN BY
 JDG

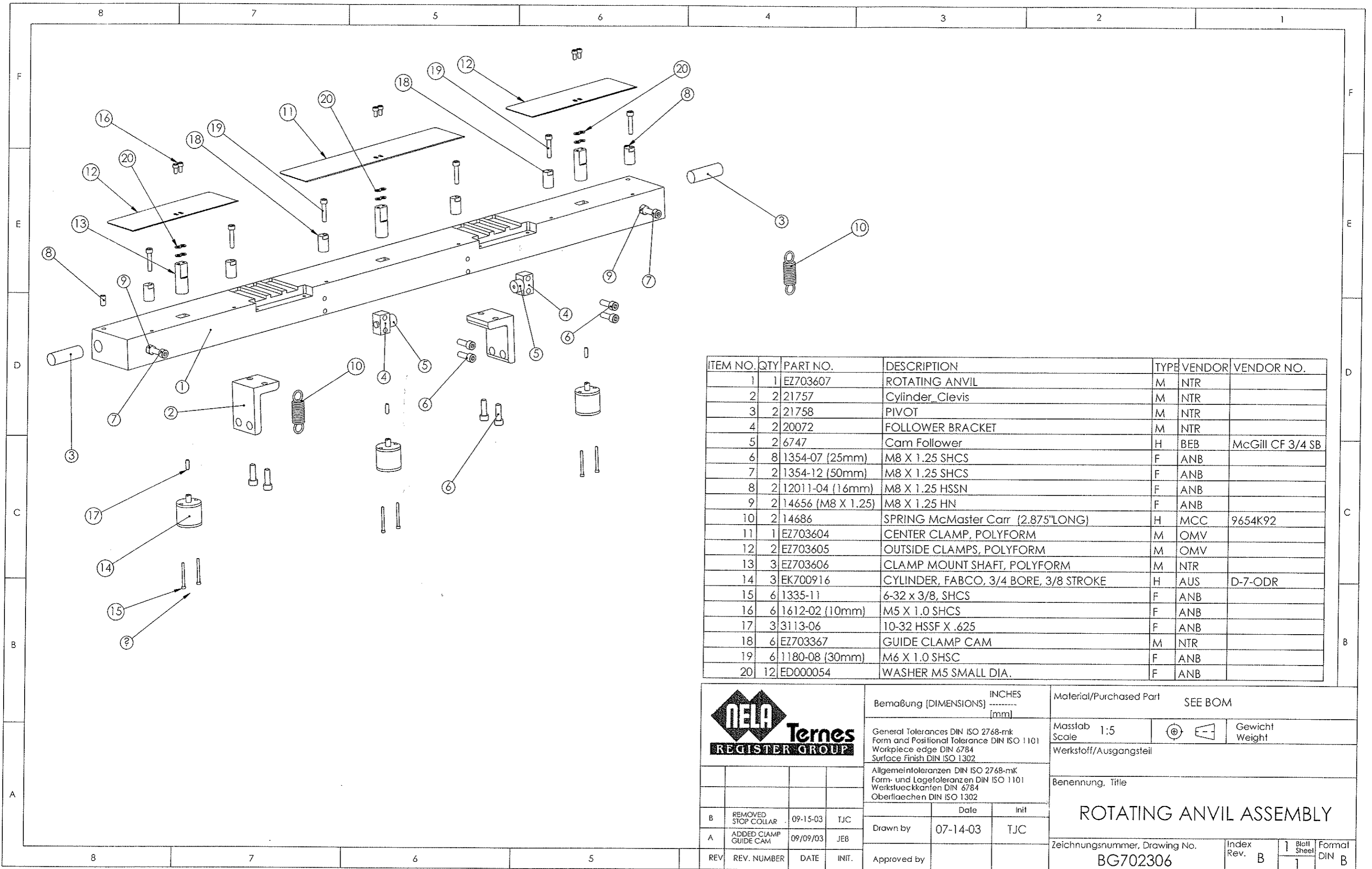
TERNES REGISTER SYSTEM

4851 WHT BEAR PKWY, WHT BEAR TWP, MN 55110 1-612-407-4800 FAX 1-612-407-4801

TITLE
BLADE ASSEMBLY

SCALE NONE PROJECTION DWG. SIZE B

DATE 12/11/98 DWG./PART NO. 21709 REV. NO. A



ITEM NO.	QTY	PART NO.	DESCRIPTION	TYPE	VENDOR	VENDOR NO.
1	1	EZ703607	ROTATING ANVIL	M	NTR	
2	2	21757	Cylinder_Clevis	M	NTR	
3	2	21758	PIVOT	M	NTR	
4	2	20072	FOLLOWER BRACKET	M	NTR	
5	2	6747	Cam Follower	H	BEB	McGill CF 3/4 SB
6	8	1354-07 (25mm)	M8 X 1.25 SHCS	F	ANB	
7	2	1354-12 (50mm)	M8 X 1.25 SHCS	F	ANB	
8	2	12011-04 (16mm)	M8 X 1.25 HSSN	F	ANB	
9	2	14656 (M8 X 1.25)	M8 X 1.25 HN	F	ANB	
10	2	14686	SPRING McMaster Carr (2.875"LONG)	H	MCC	9654K92
11	1	EZ703604	CENTER CLAMP, POLYFORM	M	OMV	
12	2	EZ703605	OUTSIDE CLAMPS, POLYFORM	M	OMV	
13	3	EZ703606	CLAMP MOUNT SHAFT, POLYFORM	M	NTR	
14	3	EK700916	CYLINDER, FABCO, 3/4 BORE, 3/8 STROKE	H	AUS	D-7-ODR
15	6	1335-11	6-32 x 3/8, SHCS	F	ANB	
16	6	1612-02 (10mm)	M5 X 1.0 SHCS	F	ANB	
17	3	3113-06	10-32 HSSF X .625	F	ANB	
18	6	EZ703367	GUIDE CLAMP CAM	M	NTR	
19	6	1180-08 (30mm)	M6 X 1.0 SHSC	F	ANB	
20	12	ED000054	WASHER M5 SMALL DIA.	F	ANB	

Bemaßung [DIMENSIONS] INCHES [mm]

General Tolerances DIN ISO 2768-mk
Form and Positional Tolerance DIN ISO 1101
Workpiece edge DIN 6784
Surface Finish DIN ISO 1302

Allgemeintoleranzen DIN ISO 2768-mK
Form- und Lagetoleranzen DIN ISO 1101
Werkstückkanten DIN 6784
Oberflächen DIN ISO 1302

Material/Purchased Part SEE BOM

Masstab Scale 1:5

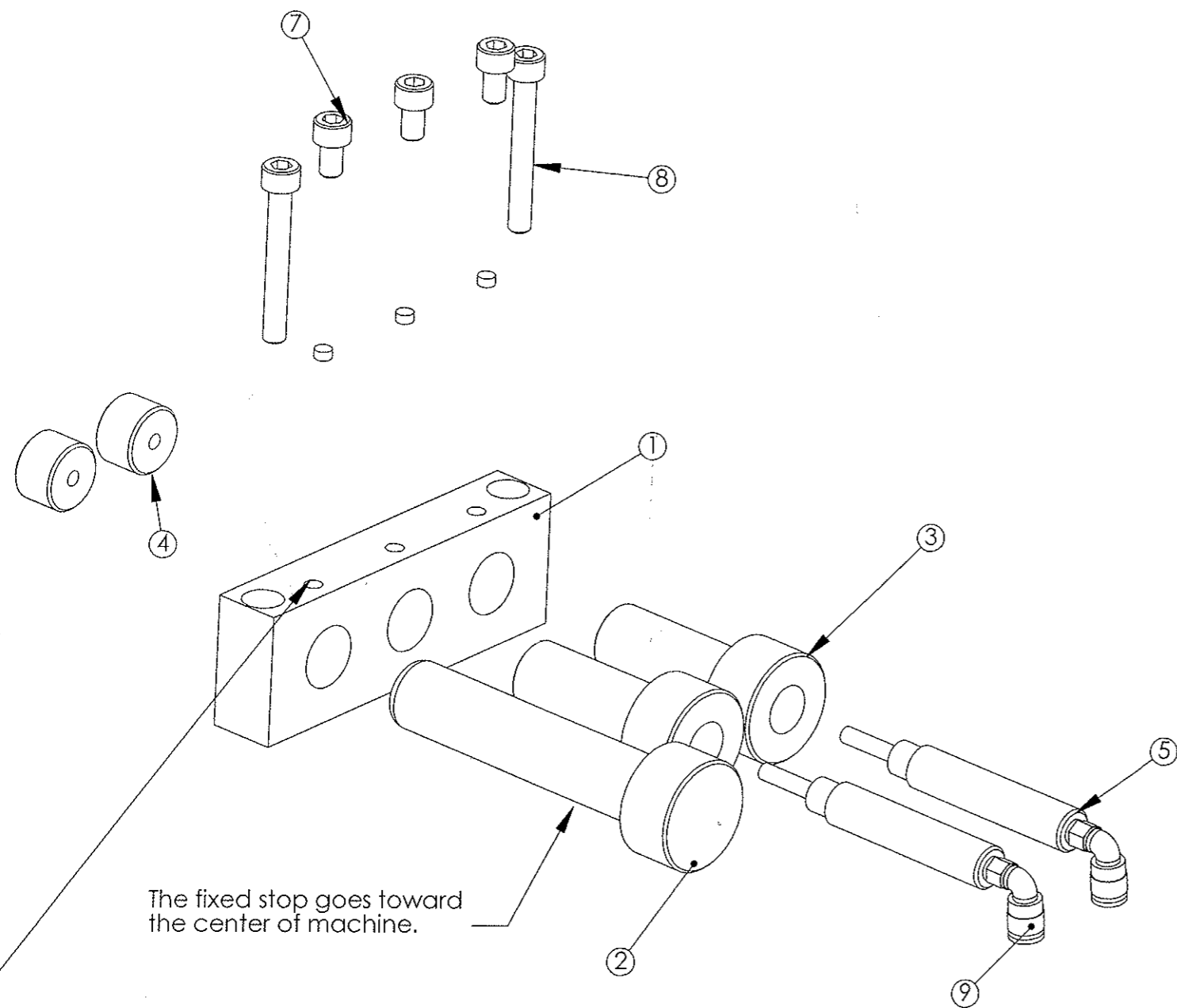
Werkstoff/Ausgangsteil

Benennung, Title
ROTATING ANVIL ASSEMBLY

Zeichnungsnummer, Drawing No.
BG702306

REV	REV. NUMBER	DATE	INIT.	Date	Init	Index Rev.	Blatt Sheet	Format DIN
B	REMOVED STOP COLLAR	09-15-03	TJC			B	1	B
A	ADDED CLAMP GUIDE CAM	09/09/03	JEB	07-14-03	TJC			
	Approved by							

REV	ECO #	DATE	BY	REVISIONS
A	1673	12/10/98	JDG	ORIGINAL



The fixed stop goes toward the center of machine.

Position the offset hole in the top of mounting bracket toward the back of machine.

All Qty's are for one assembly. There are two Qty's per each machine.

ITEM NO.	QTY.	PART NO.	DESCRIPTION
1	1	19101	STOP MOUNTING BRACKET
2	1	18499	FIXED STOP
3	2	18498	MOVABLE STOP
4	2	21759	STOP FACE
5	2	19124	CYLINDER, AMERICAL 437SNHS 1.00 SPRING RETURN NR
6	3	7365	ALUM PAD
7	3	1180-02 (10mm)	M6 X 1.0 SHSC
8	2	1180-11 (45mm)	M6 X 1.0 SHSC
9	2	3887-06	Male Elbow fitting

Notes:
Assemble left and right side stops as an exact mirrors of each other.

Factory Stop Settings are:
Center Stops .115
Outside Stops .156
Inside Stops .500

MATERIAL	N.A.
HEAT TREAT	N.A.
HARDNESS	N.A.
FINISH	N.A.
NEXT ASS'Y	N.A.

DIMENSIONS ARE IN INCHES
TOLERANCES UNLESS NOTED
ANSI Y14.5M-1982
TWO PLACES ±.01
THREE PLACES ±.005
ANGULAR ±0°.30'
SURFACE FINISH 125
BREAK SHARP CORNERS .020

THIS DOCUMENT CONTAINS PROPRIETARY DATA OF:
TERNES REGISTER SYSTEM
NO DISCLOSURE, REPRODUCTION OR USE OF ANY PART THEREOF MAY BE MADE WITHOUT WRITTEN PERMISSION

APP'D BY
DRAWN BY
JDG

TERNES REGISTER SYSTEM

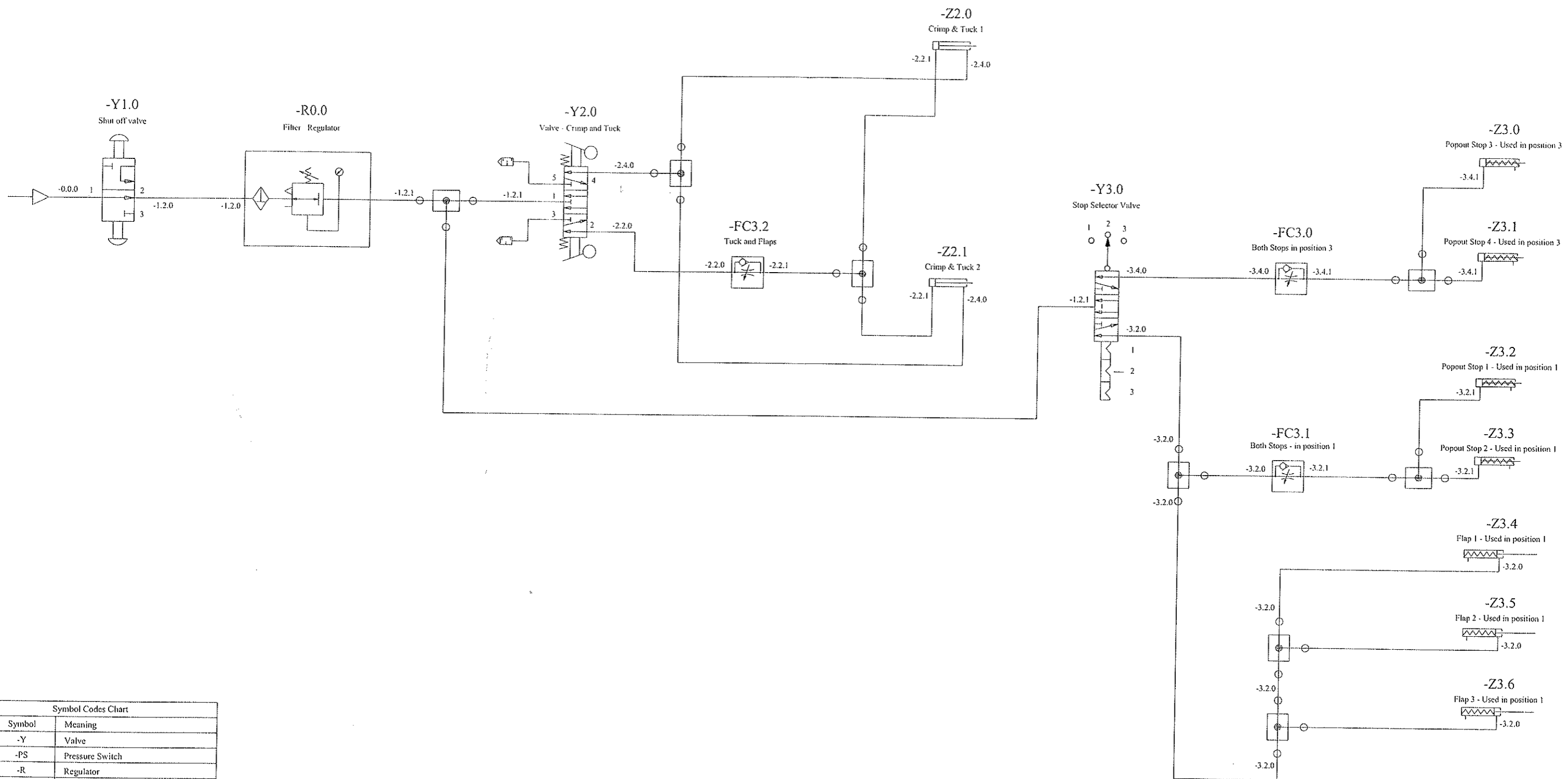
4851 WHT BEAR PKWY, WHT BEAR TWP, MN 55110 1-612-407-4800 FAX 1-612-407-4801

TITLE
STOP ASSEMBLY

SCALE NONE PROJECTION NONE DWG. SIZE B

DATE 11/19/98 DWG./PART NO. 21710 REV. NO. A

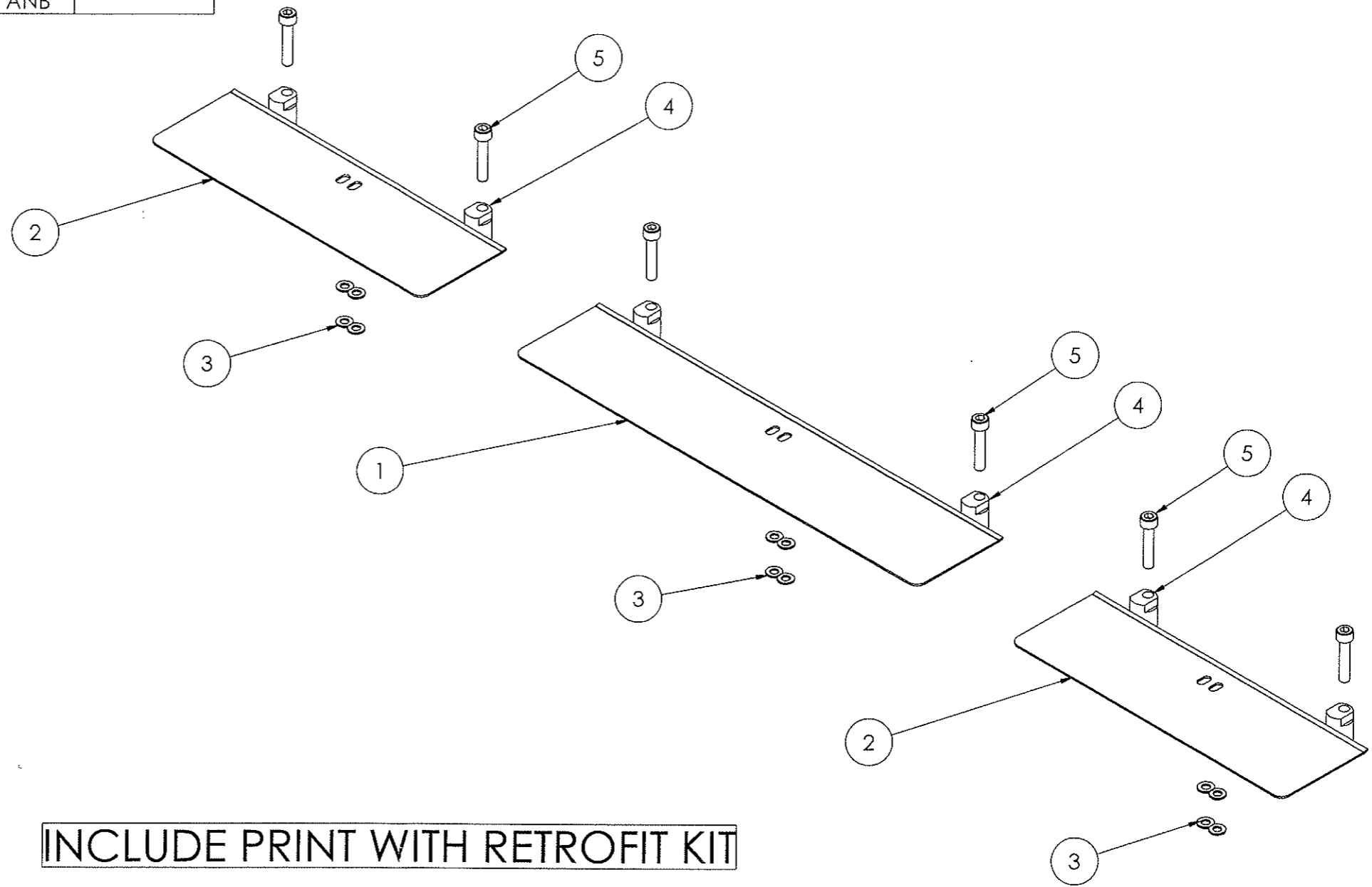
Rev.	ECO#	Date	By	Revision
A		08.20.2003	JAB	Flaps moved to Crimp control
B		09.15.2003	CP	Flaps moved to -Y3.0



Symbol Codes Chart	
Symbol	Meaning
-Y	Valve
-PS	Pressure Switch
-R	Regulator
-SW	Switch - Manual
-FC	Flow Control
-VG	Vacuum Generator
-Z	Cylinder
-VP	Vacuum Pump
-S	Magnetic Reed Sensor
-PCV	Piloted Check Valve
-O	Oil Reservoir
-FL	Oil Separator

Dimensions are in inches Tolerances unless noted ANSI Y14.5M-1982 Two places +.01 Three places +.005		This Document Contains Proprietary Data of: NELA Terns Register Group No disclosure, reproduction or use of any part thereof may be made without written permission		NELA Terns Register Group <small>4551 White Bear Parkway, White Bear Township, MN 55110-3125 Phone - 1.651.407.4500 Fax - 1.651.407.4501</small> Title Pneumatic Schematic - 42" Crimper Scale 1:1 Precision DWG. Size B	
AP'D By	Drawn By	Date	DWG. Part No	REV. No	
	JAB	07.22.2003	BE700337	B	

ITEM NO.	QTY.	PART NO.	DESCRIPTION	VENDOR	VENDOR NO.
1	1	EZ703604	CENTER CLAMP, POLYFORM	OMV	
2	2	EZ703605	OUTSIDE CLAMPS, POLYFORM	OMV	
3	12	ED000054	WASHER M5 SMALL DIA.	ANB	
4	6	EZ703367	GUIDE CLAMP CAM	NTR	
5	6	1180-08 (30mm)	M6 X 1.0 SHSC	ANB	



INCLUDE PRINT WITH RETROFIT KIT

INSTALLATION NOTES:

- 1) REMOVE COLLAR FROM END OF CLAMP LIFT CYLINDERS.
- 2) M5 WASHERS ARE TO BE INSTALLED BETWEEN CLAMP AND CYLINDER ROD.
- 3) INSTALL GUIDE CAMS IN EXISTING M6 HOLES BEHIND CLAMPS. ADJUST CLAMP POSITION SO THAT FRONT EDGE IS EVEN WITH RADIUS ON THE ANVIL. TIGHTEN CLAMP SCREWS, THEN BACK CAMS OFF SLIGHTLY (MINIMAL PLAY).

FINISH:

	Bemaßung [DIMENSIONS] [INCHES] mm		Material/Purchased Part	
	General Tolerances DIN ISO 2768-mk Form and Positional Tolerance DIN ISO 1101 Workpiece edge DIN 6784 Surface Finish DIN ISO 1302		Masstab 1:3	Gewicht
	Allgemeintoleranzen DIN ISO 2768-mK Form- und Lagetoleranzen DIN ISO 1101 Werkstückkanten DIN 6784 Oberflächen DIN ISO 1302		Scale	Weight
	Drawn by: 09/09/03 JEB Date: 09/09/03 Init: JEB		Werkstoff/Ausgangsteil	
Approved by: _____ Date: _____ Init: _____		Benennung, Title RETROFIT KIT, CLAMPS AND GUIDE CAM POLYFORM 107		
REV	REV. NUMBER	DATE	INIT.	Zeichnungsnummer, Drawing No. BG702403
				Index Rev. - Blatt Sheet 1 of 1 Format DIN B