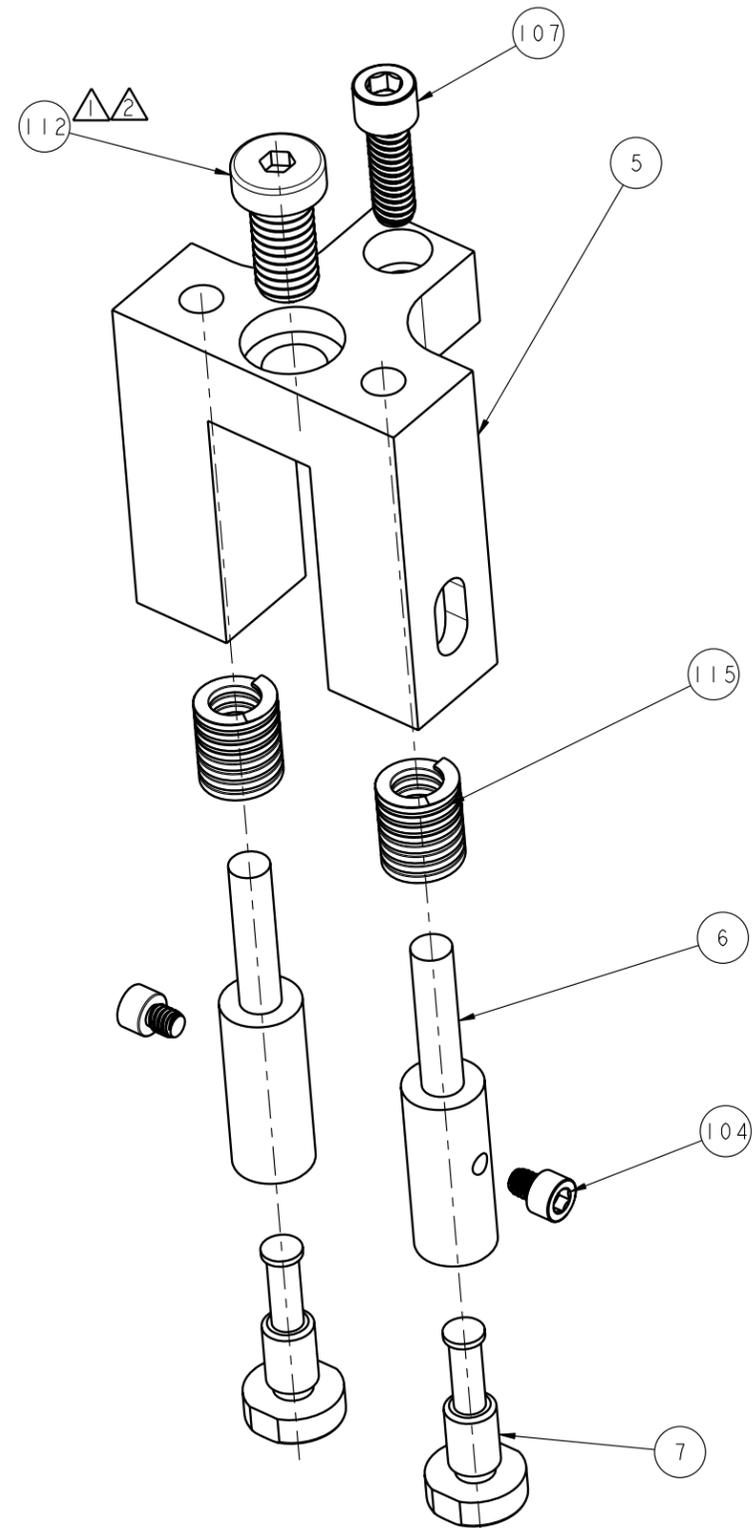


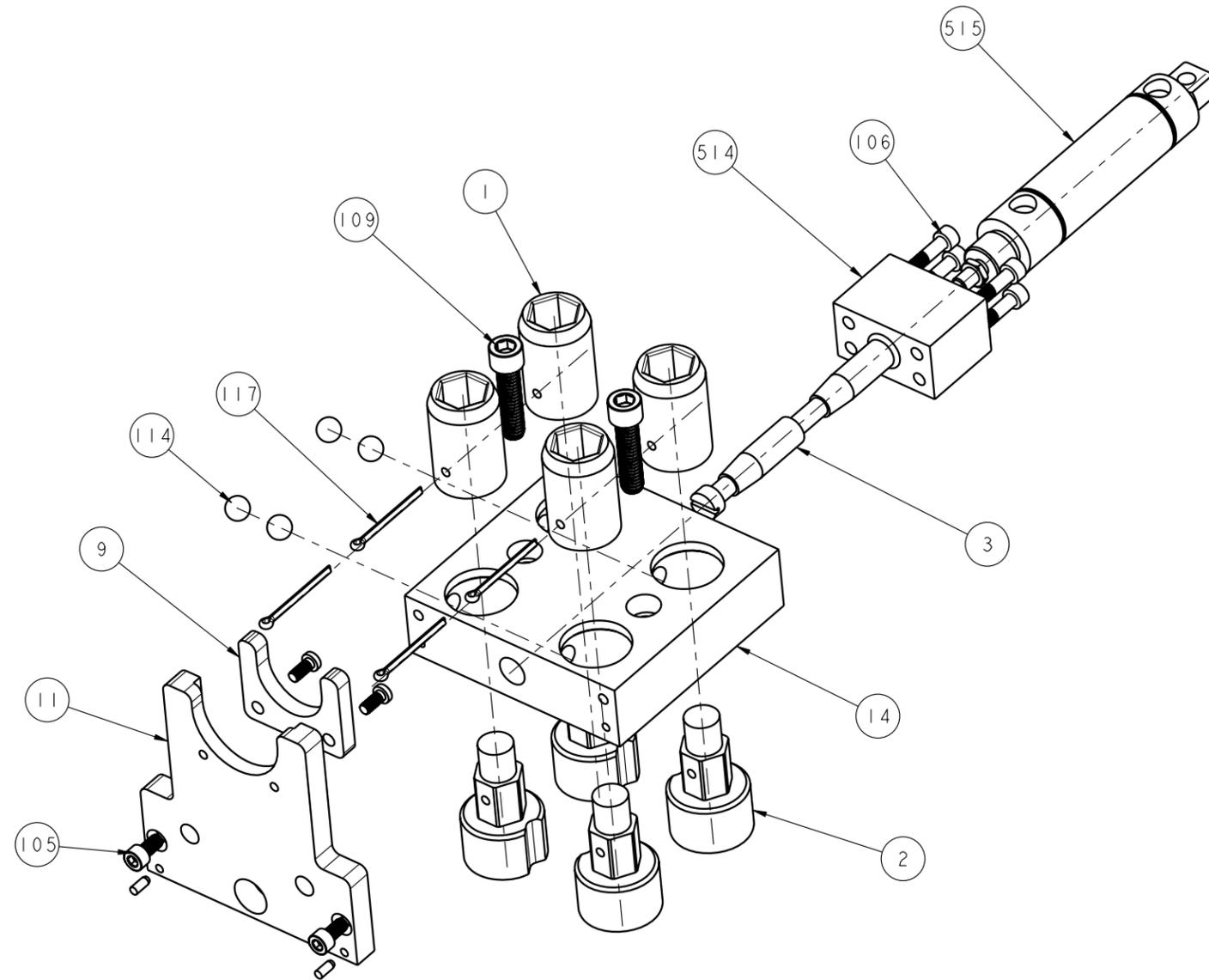
NOTES:  
 1- ADJUST FORWARD AND BACK STOPS  
 FOR NEW BOLT CENTERS.  
 OLD SPACING: 1.854  
 NEW SPACING: 2.017  
 MOVE BACK STOP BACK .0815  
 MOVE FORWARD STOP FORWARD .0815

| REV              | DESCRIPTION | DATE | BY |
|------------------|-------------|------|----|
| REVISION HISTORY |             |      |    |

|               |   |   |                  |
|---------------|---|---|------------------|
| MATERIAL:     | NEST ASSEMBLY MOD CFF HEAD<br>BOLT TORQUING MACHINE | THIRD ANGLE PROJECTION                                      |                  |
|               | NEXT ASSEMBLY:                                      | DO NOT SCALE-USE DIMENSIONS ONLY                            |                  |
| FINISH:       | TOLERANCES UNLESS OTHERWISE SPECIFIED               | DRAWN<br>M. ADCOCK  | DATE<br>04-23-04 |
|               | .XX ±0.02<br>.XXX ±0.005<br>.XXXX ±0.0010           | BREAK CORNERS 0.01/0.02<br>FILLETS 0.01R MAX<br>ANGLES ± 1° | SCALE<br>1.000   |
| <b>TERMAR</b> |   | DRAWING NUMBER<br>400-010-000                               | SHEET 1 OF 4     |
|               |   | REVISION C<br>07-24-04                                      |                  |



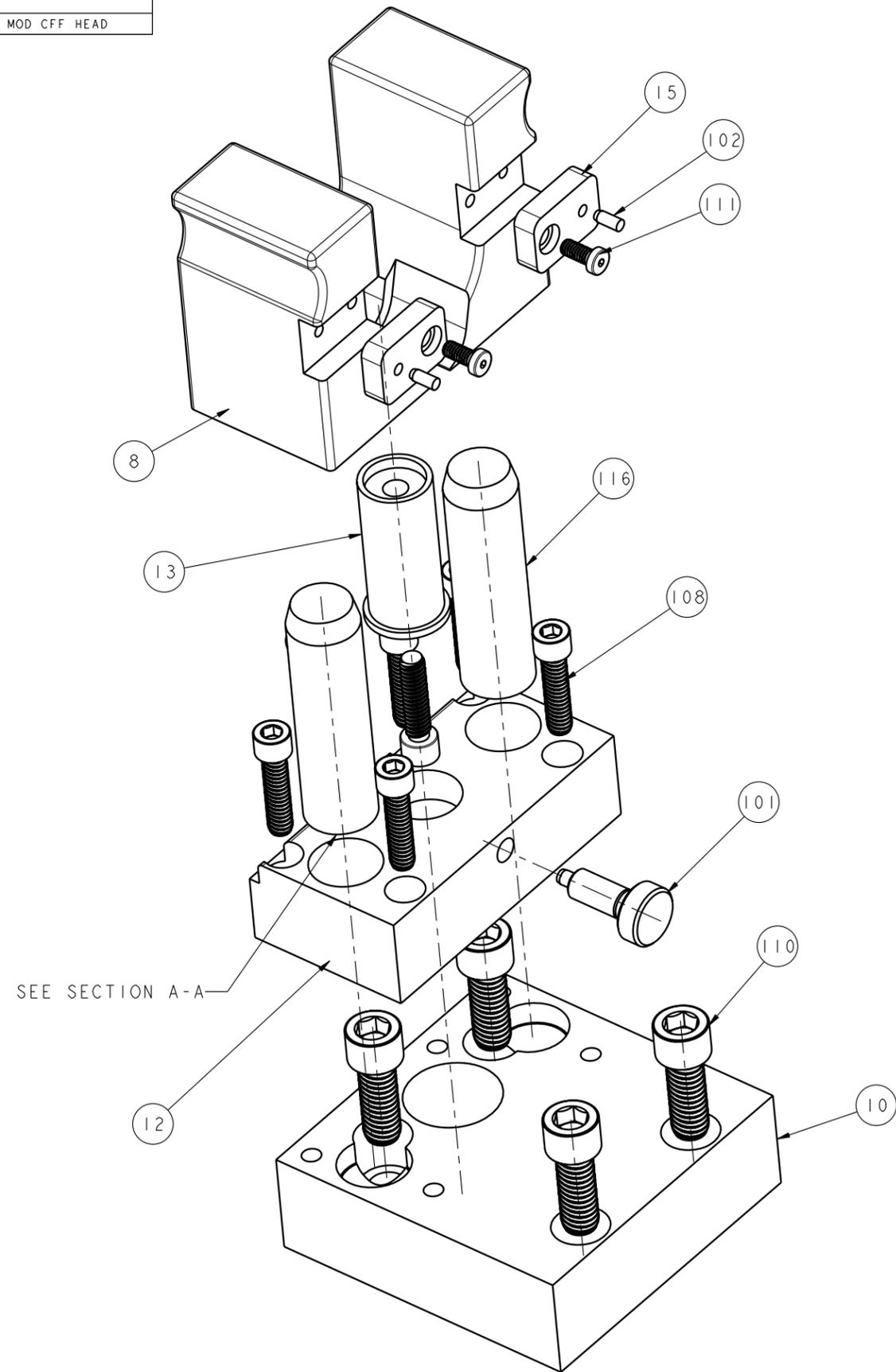
HOLD DOWN DETAIL  
 SCALE 2.000



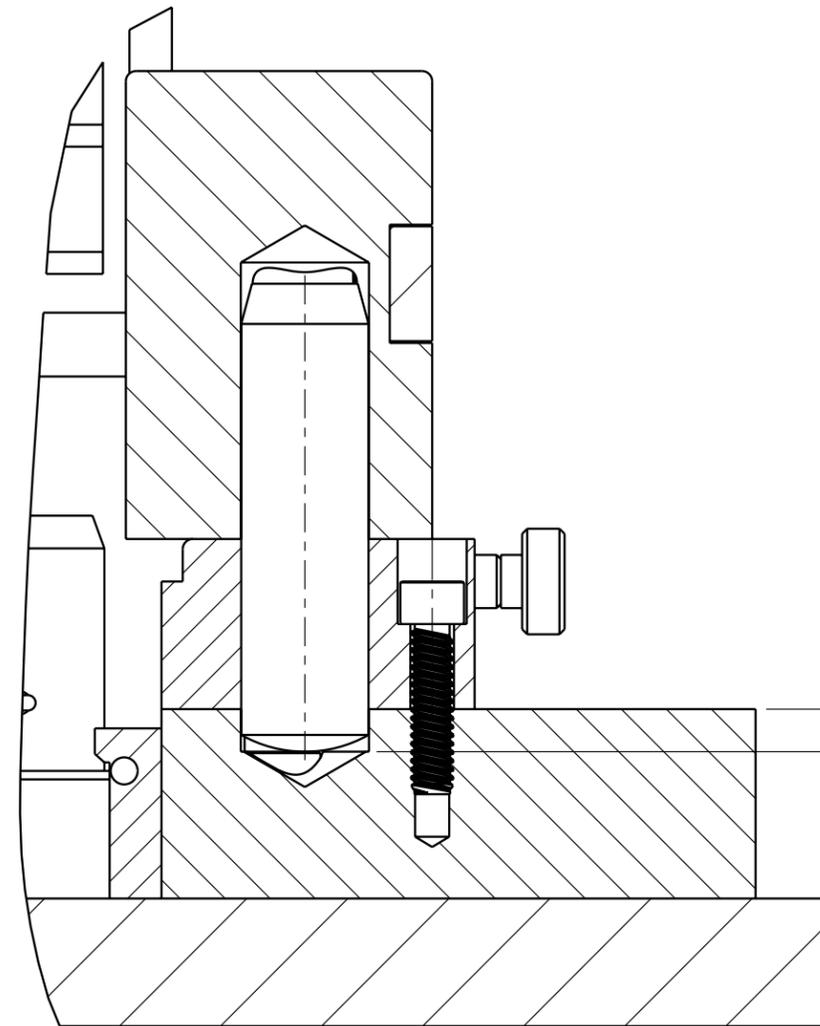
SOCKET HOLDER DETAIL  
 SCALE 1.000

| REV              | DESCRIPTION | DATE | BY |
|------------------|-------------|------|----|
| REVISION HISTORY |             |      |    |

|           |   |                                  |              |
|-----------|---|----------------------------------|--------------|
| MATERIAL: | NEST ASSEMBLY MOD CFF HEAD<br>BOLT TORQUING MACHINE   | THIRD ANGLE PROJECTION           |              |
|           | NEXT ASSEMBLY:  | DO NOT SCALE-USE DIMENSIONS ONLY |              |
| FINISH:   | TOLERANCES UNLESS OTHERWISE SPECIFIED   | DRAWN                            | DATE         |
|           | .XX ±0.02   BREAK CORNERS 0.01/0.02<br>.XXX ±0.005   FILLETS 0.01R MAX<br>.XXXX ±0.0010   ANGLES ± 1° | M. ADCOCK                        | 04-23-04     |
|           |   | APPROVED                         | SCALE 1.000  |
|           |   | DRAWING NUMBER 400-010-000       |              |
|           |   | REVISION C                       | SHEET 2 OF 4 |
|           |   | <b>TERMAR</b>                    |              |
|           |   | 07-24-04                         |              |



FIXED CLAMP DETAIL  
 SCALE 1.500



SECTION A-A  
 SCALE 2.000

| REV              | DESCRIPTION | DATE | BY |
|------------------|-------------|------|----|
| REVISION HISTORY |             |      |    |

|           |  |                               |                  |
|-----------|--|-------------------------------|------------------|
| MATERIAL: | NEST ASSEMBLY MOD CFF HEAD<br>BOLT TORQUING MACHINE  | THIRD ANGLE PROJECTION<br>    |                  |
| FINISH:   | DO NOT SCALE-USE DIMENSIONS ONLY<br>TOLERANCES UNLESS OTHERWISE SPECIFIED<br>.XX ±0.02   BREAK CORNERS 0.01/0.02<br>.XXX ±0.005   FILLETS 0.01R MAX<br>.XXXX ±0.0010   ANGLES ± 1° | DRAWN<br>M. ADCOCK            | DATE<br>04-23-04 |
|           |  | APPROVED                      | SCALE<br>1.000   |
|           |  | DRAWING NUMBER<br>400-010-000 |                  |
|           |  | REVISION C<br>07-24-04        | SHEET 3 OF 4     |

**TERMAR**

400-010-000  
 NEST ASSEMBLY MOD CFF HEAD

BILL OF MATERIAL

| ITEM | QTY | PART NUMBER          | MANUFACTURER       | DESCRIPTION                            |
|------|-----|----------------------|--------------------|--|
| 1    | 4   | 400-010-001          | PURCHASE           | SOCKET MODIFICATION                    |
| 2    | 4   | 400-010-002          |                    | DRIVE BLOCK                            |
| 3    | 1   | 400-010-003          |                    | PISTON                                 |
| 4    | 2   | 400-010-004          |                    | HEAD CLAMP BAR                         |
| 5    | 1   | 400-010-005          |                    | PRESSURE PAD HOUSING                   |
| 6    | 2   | 400-010-006          |                    | GUIDE POST                             |
| 7    | 2   | 400-010-007          |                    | PRESSURE PAD                           |
| 8    | 1   | 400-010-008          |                    | HEAD CLAMP, FIXED                      |
| 9    | 1   | 400-010-009          |                    | FRONT ALIGNMENT PLATE                  |
| 10   | 1   | 400-010-010          |                    | HEAD CLAMP BODY, LOWER                 |
| 11   | 1   | 400-010-011          |                    | ALIGNMENT PLATE MOUNT                  |
| 12   | 1   | 400-010-012          |                    | HEAD CLAMP BODY, UPPER                 |
| 13   | 1   | 400-010-013          |                    | PIVOT PIN                              |
| 14   | 1   | 400-010-014          |                    | BASE PLATE                             |
| 15   | 2   | 400-010-015          |                    | SIDE ALIGNMENT PLATE                   |
| 101  | 1   | 8692A13_WITH_LOCKING | McMASTER-CARR      | SPRING PLUNGER                         |
| 102  | 4   | 90145A878            | McMASTER-CARR      | DOWEL PIN .125 DIA X .3125 LG 18-8 SST |
| 103  | 1   | 90636A049            | McMASTER-CARR      | HEX NUT 3/8-16 SELF LOCKING            |
| 104  | 2   | 91251A180            | McMASTER-CARR      | SHCS 8-32 X .188 LG                    |
| 105  | 2   | 91251A340            | McMASTER-CARR      | SHCS 10-32 X .375 LG                   |
| 106  | 4   | 91251A349            | McMASTER-CARR      | SHCS 10-32 X 1.25 LG                   |
| 107  | 1   | 91251A540            | McMASTER-CARR      | SHCS 1/4-20 X .75 LG                   |
| 108  | 7   | 91251A542            | McMASTER-CARR      | SHCS 1/4-20 X 1.00 LG                  |
| 109  | 2   | 91251A585            | McMASTER-CARR      | SHCS 5/16-18 X 1.25 LG                 |
| 110  | 4   | 91251A624            | McMASTER-CARR      | SHCS 3/8-16 X 1.00 LG                  |
| 111  | 4   | 92220A192            | McMASTER-CARR      | LOW HEAD SCREW 8-32 X .375 LG          |
| 112  | 1   | 92220A622            | McMASTER-CARR      | LOW HEAD SCREW 3/8-16 X .75 LG         |
| 113  | 1   | 92220A628            | McMASTER-CARR      | LOW HEAD SCREW 3/8-16 X 1.50 LG        |
| 114  | 4   | 9529K18              | McMASTER-CARR      | BALL 11/32 DIA.                        |
| 115  | 2   | 9573K15              | McMASTER-CARR      | DIE SPRING                             |
| 116  | 2   | 98381A143            | McMASTER-CARR      | DOWEL PIN .750 DIAMETER X 2.75 LG      |
| 117  | 4   | 98401A450            | McMASTER-CARR      | COTTER PIN 3/32 DIAMETER X 1-1/4 LG    |
| 501  | -   | 16607-11             | FOR REFERENCE ONLY | SENSOR MOUNTING ANGLE                  |
| 502  | -   | 16607-12             | FOR REFERENCE ONLY | SENSOR MOUNTING PLATE                  |
| 503  | -   | 16607-17             | FOR REFERENCE ONLY | HEAD CLAMP PLATE                       |
| 504  | -   | 16607-18             | FOR REFERENCE ONLY | CLAMP CYLINDER ADAPTER                 |
| 505  | -   | 16607-19             | FOR REFERENCE ONLY | CLAMP CYLINDER WASHER                  |
| 506  | -   | 16607-20             | FOR REFERENCE ONLY | CLAMP CYLINDER MOUNTING PLATE          |
| 507  | -   | 16607-21             | FOR REFERENCE ONLY | CLAMP CYLINDER SUPPORT PLATE           |
| 508  | -   | 16607-22             | FOR REFERENCE ONLY | CLAMP CYLINDER STOP PLATE              |
| 509  | -   | 16607-7              | FOR REFERENCE ONLY | BED PLATE                              |
| 510  | -   | 16607-8              | FOR REFERENCE ONLY | TOGGLE CLAMP RISER                     |
| 511  | -   | 16607-9              | FOR REFERENCE ONLY | AIR POWERED CLAMP                      |
| 512  | -   | ADV-80-10-A          | FOR REFERENCE ONLY | SHORT STROKE AIR CYLINDER              |
| 513  | -   | B15-Q0-AP6X2-V1131   | FOR REFERENCE ONLY | PROXIMITY SENSOR                       |
| 514  | -   | T-1129114-2          | FOR REFERENCE ONLY | CYLINDER MOUNTING BLOCK                |
| 515  | -   | 061000_DXP           | FOR REFERENCE ONLY | AIR CYLINDER                           |



NOTES:

- 1 USED ON FIRST MACHINE ONLY.
- 2 USED ON SECOND MACHINE ONLY.

| REV              | DESCRIPTION | DATE | BY |
|------------------|-------------|------|----|
| REVISION HISTORY |             |      |    |

|           |  |                                  |                               |
|-----------|--|----------------------------------|-------------------------------|
| MATERIAL: | NEST ASSEMBLY MOD CFF HEAD<br>BOLT TORQUING MACHINE  | THIRD ANGLE PROJECTION<br>       |                               |
|           | NEXT ASSEMBLY:   | DO NOT SCALE-USE DIMENSIONS ONLY | DRAWN M. ADCOCK DATE 04-23-04 |
| FINISH:   | TOLERANCES UNLESS OTHERWISE SPECIFIED<br>.XX ±0.02   BREAK CORNERS 0.01/0.02<br>.XXX ±0.005   FILLETS 0.01R MAX<br>.XXXX ±0.0010   ANGLES ± 1° | APPROVED                         | SCALE 1.000                   |
|           | <b>TERMAR</b>  | DRAWING NUMBER 400-010-000       | REVISION C SHEET 4 OF 4       |