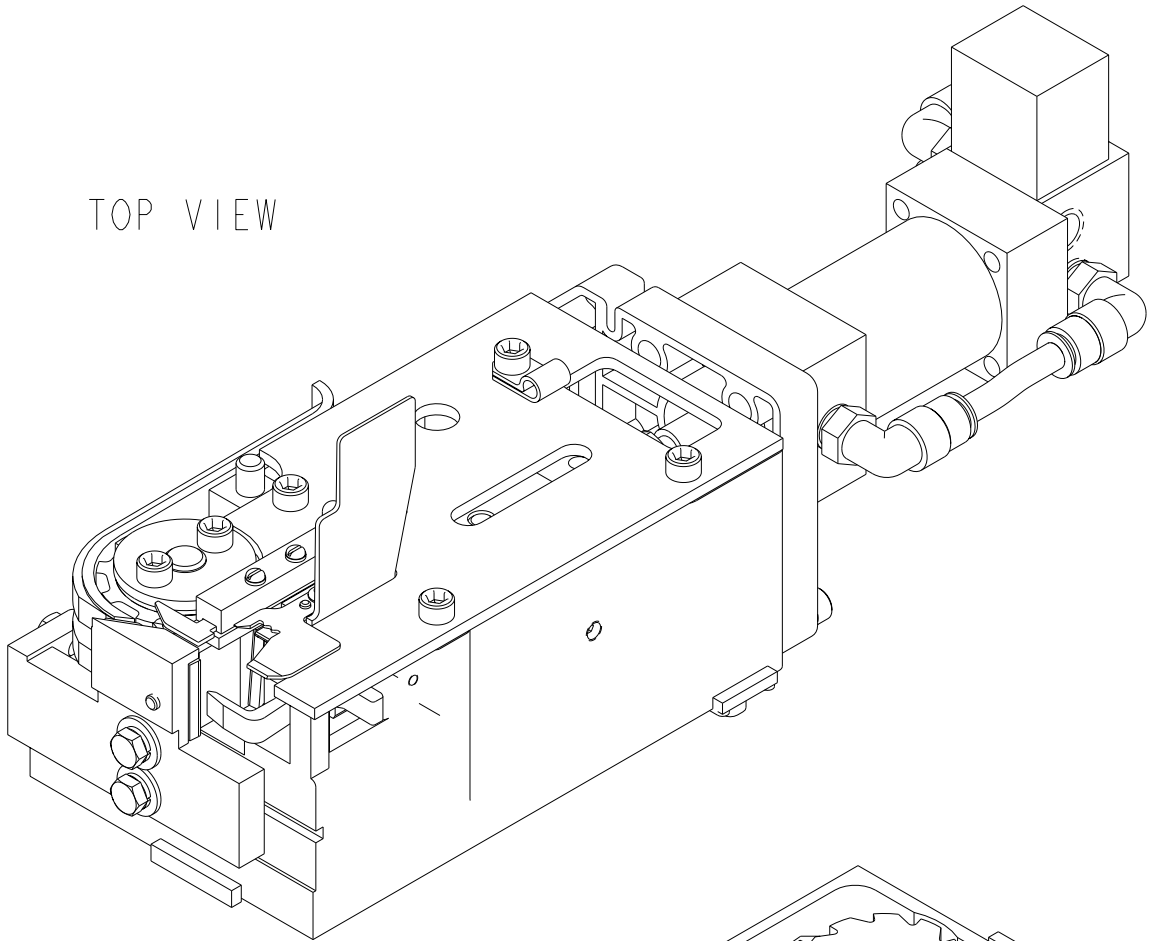
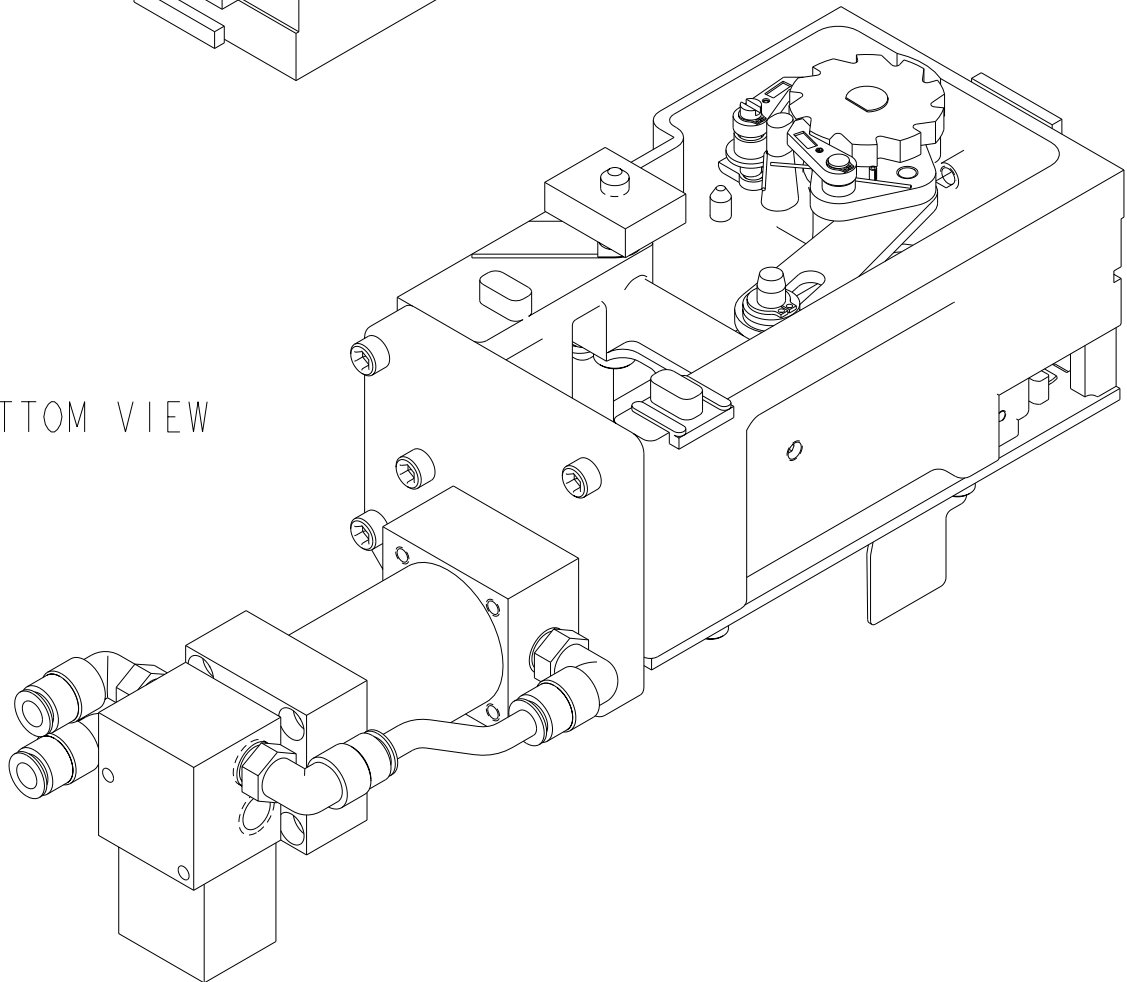
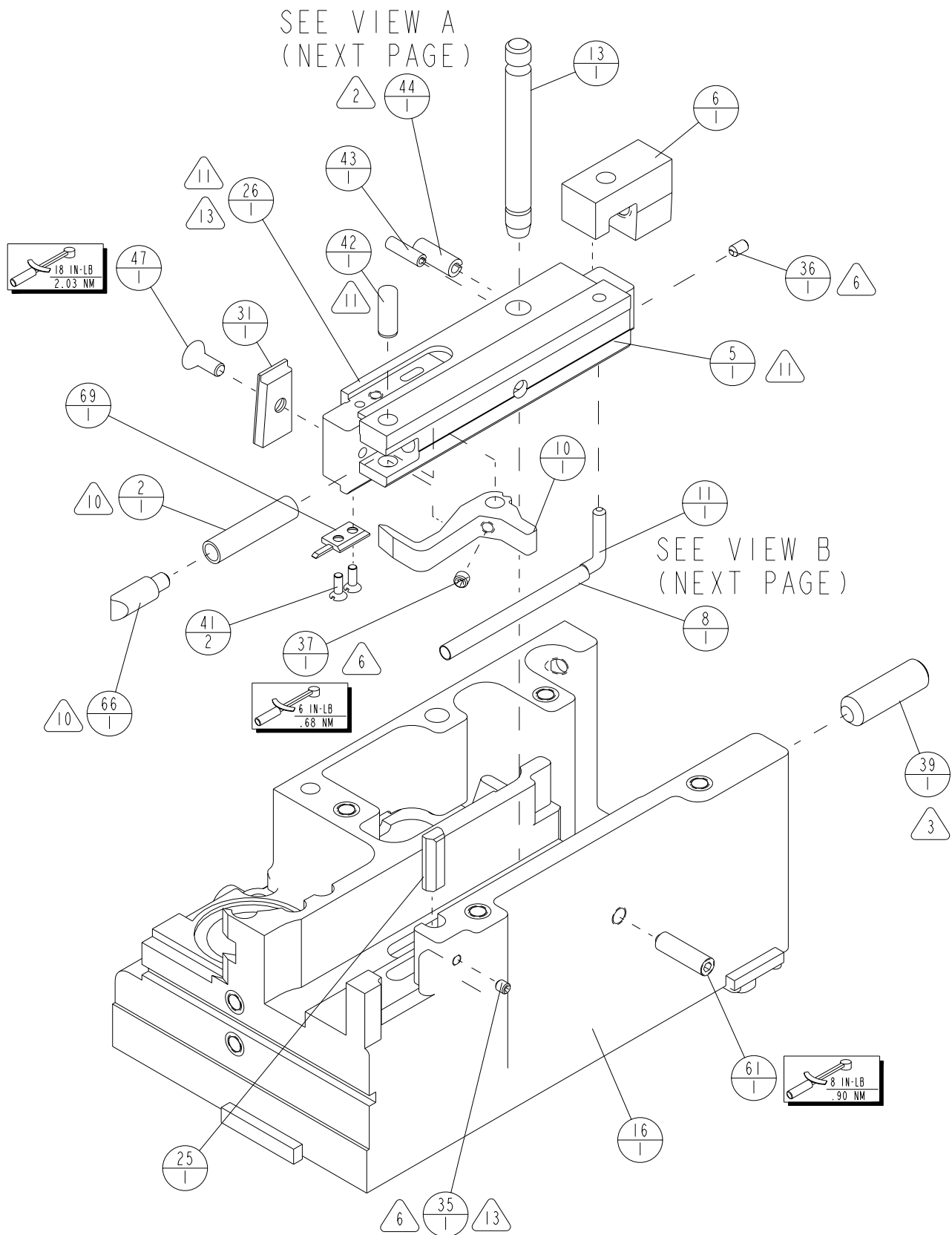


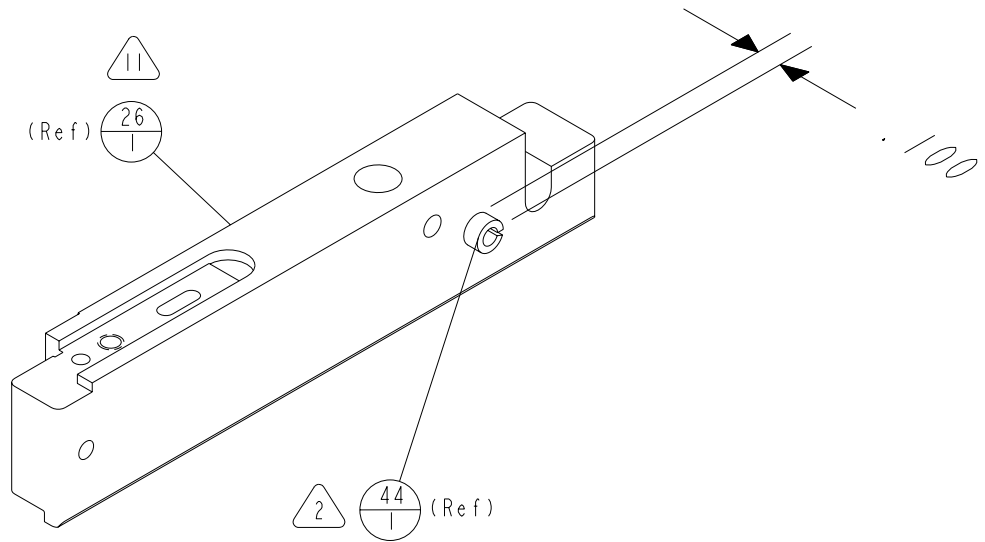
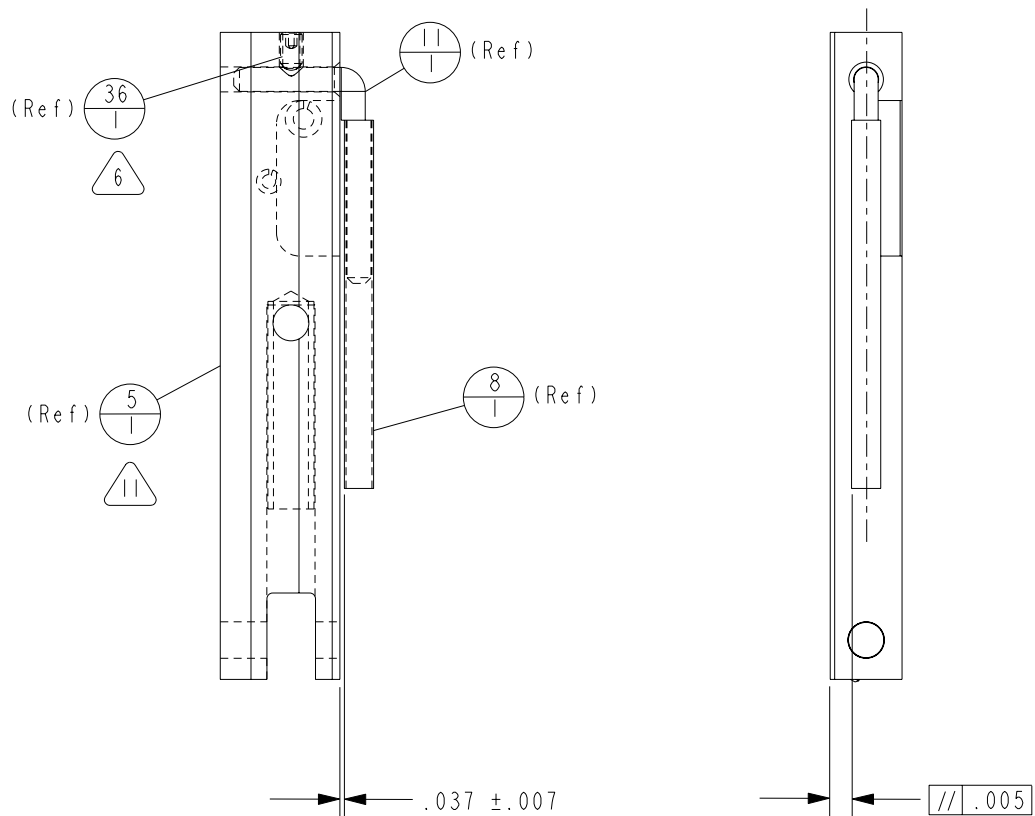
TOP VIEW

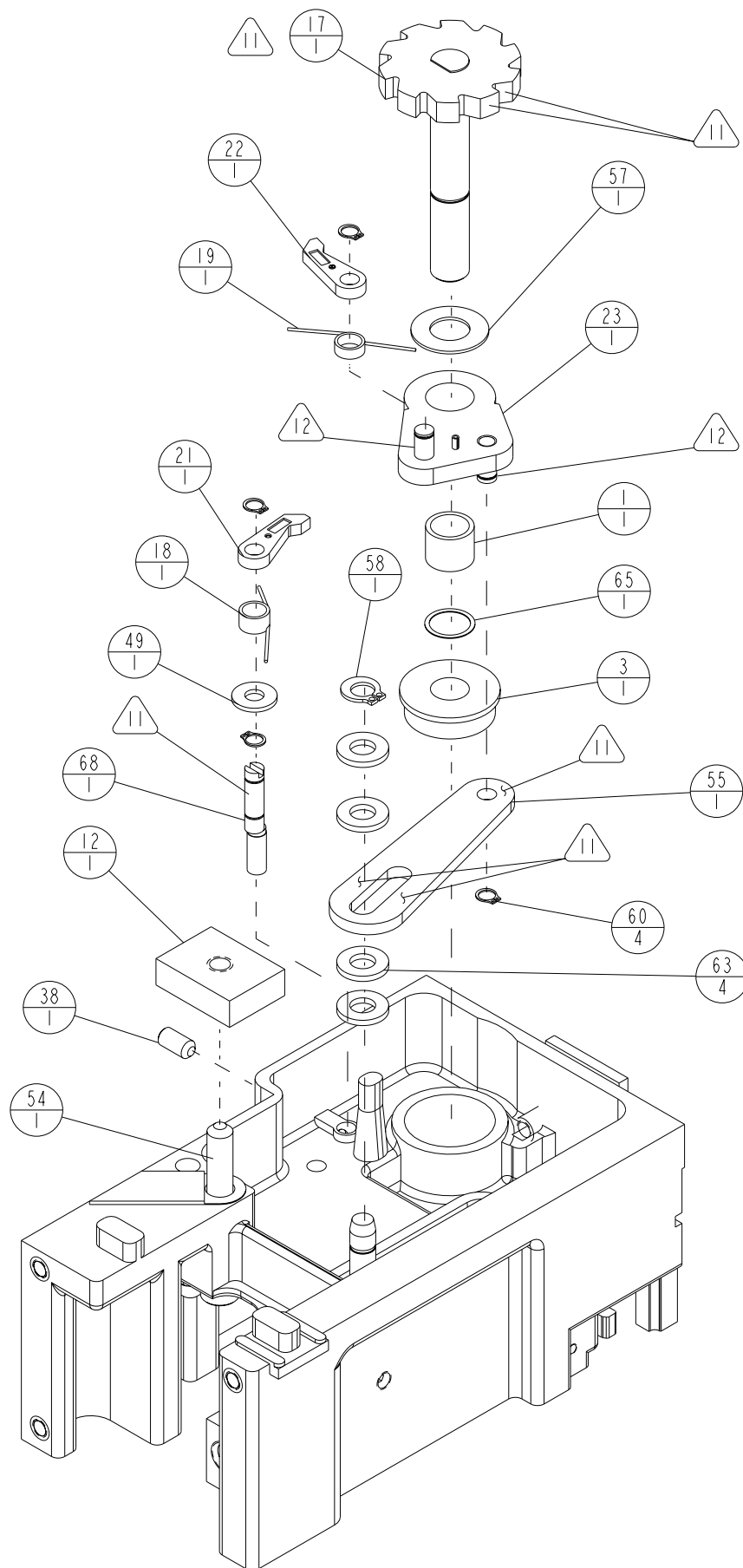


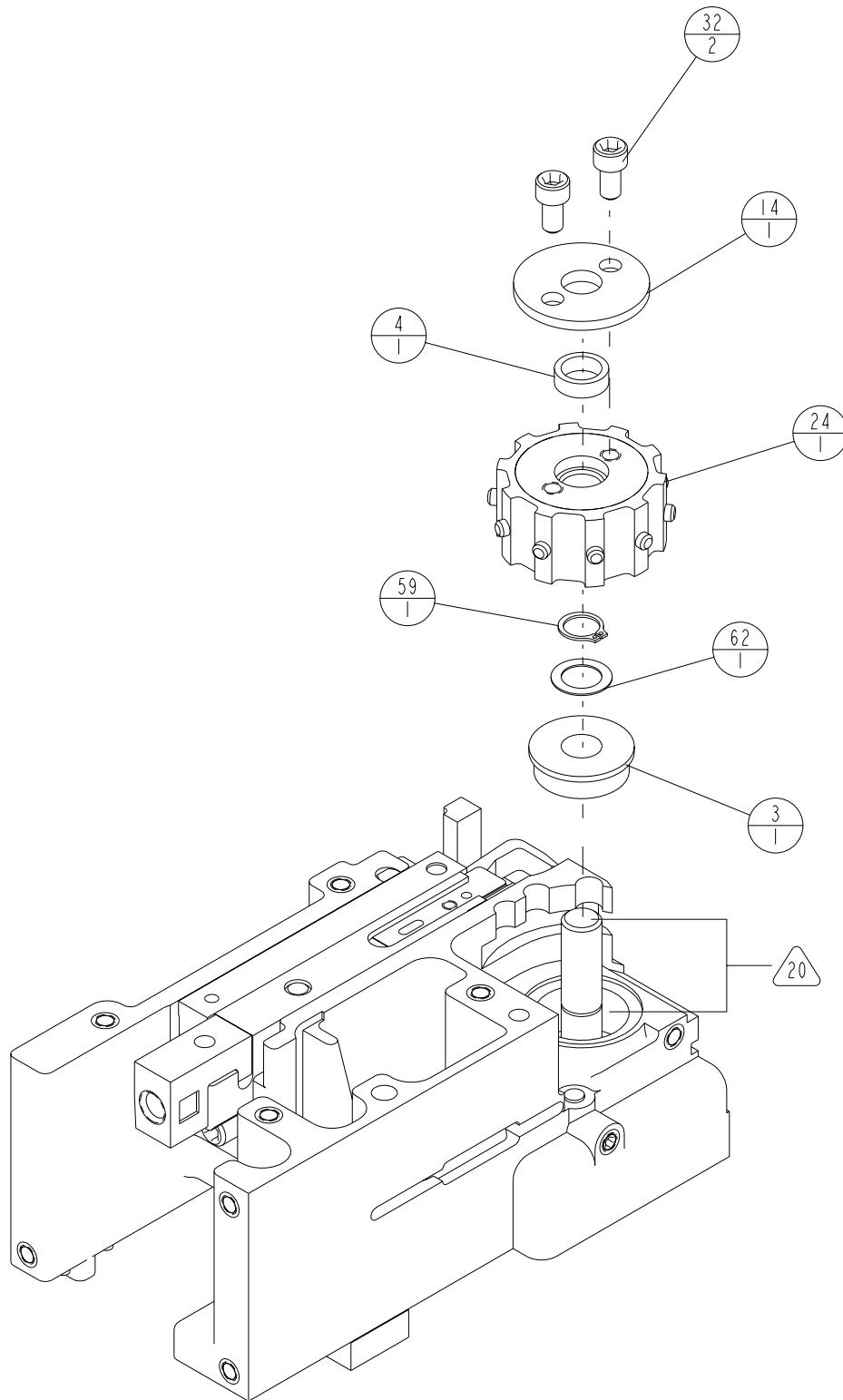
BOTTOM VIEW

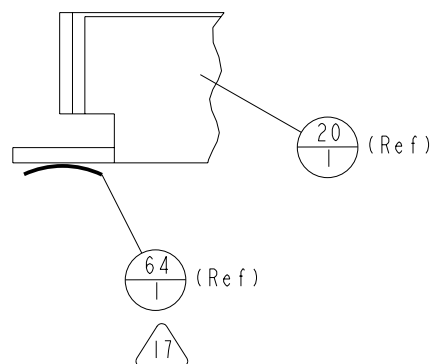
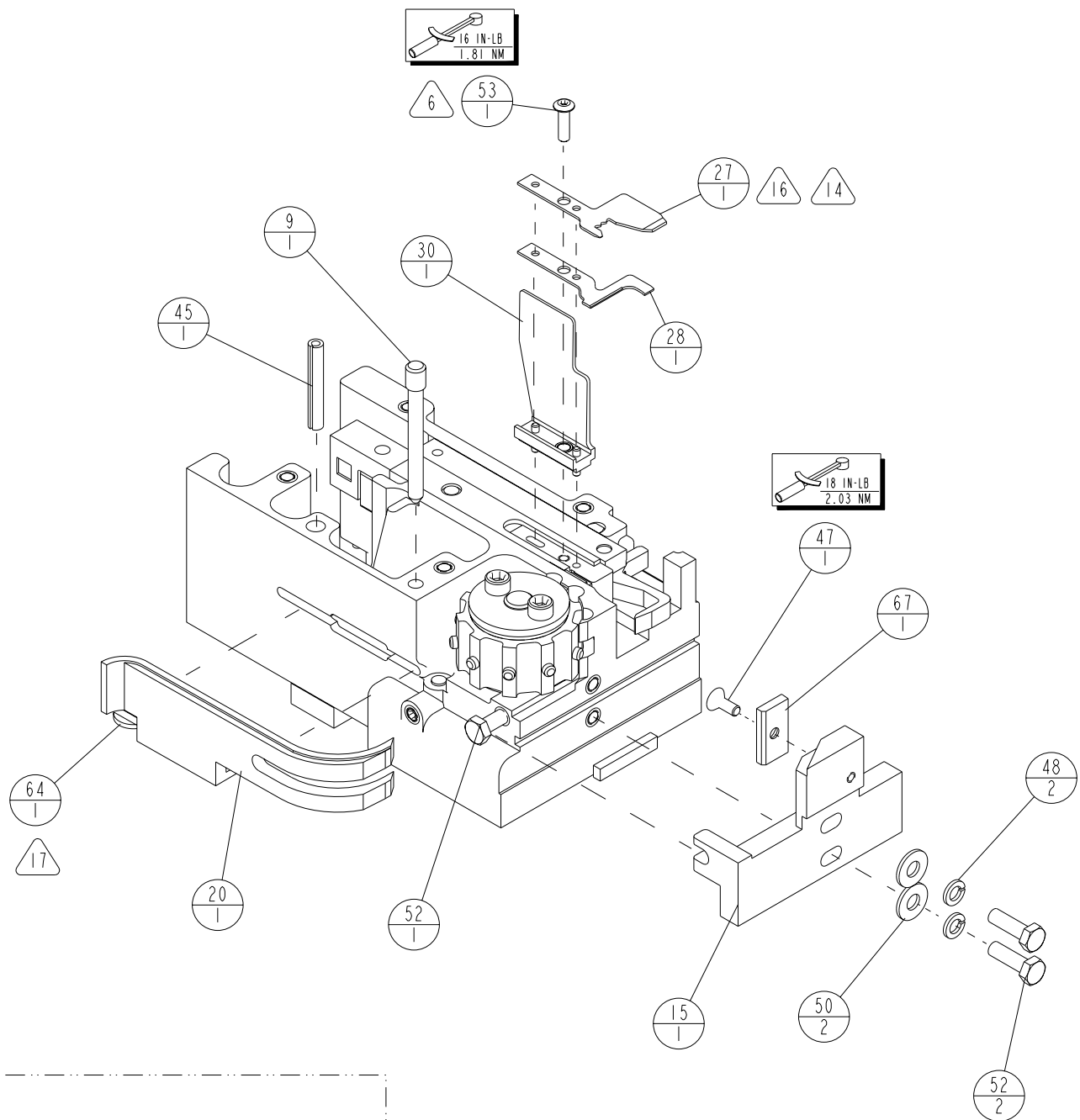


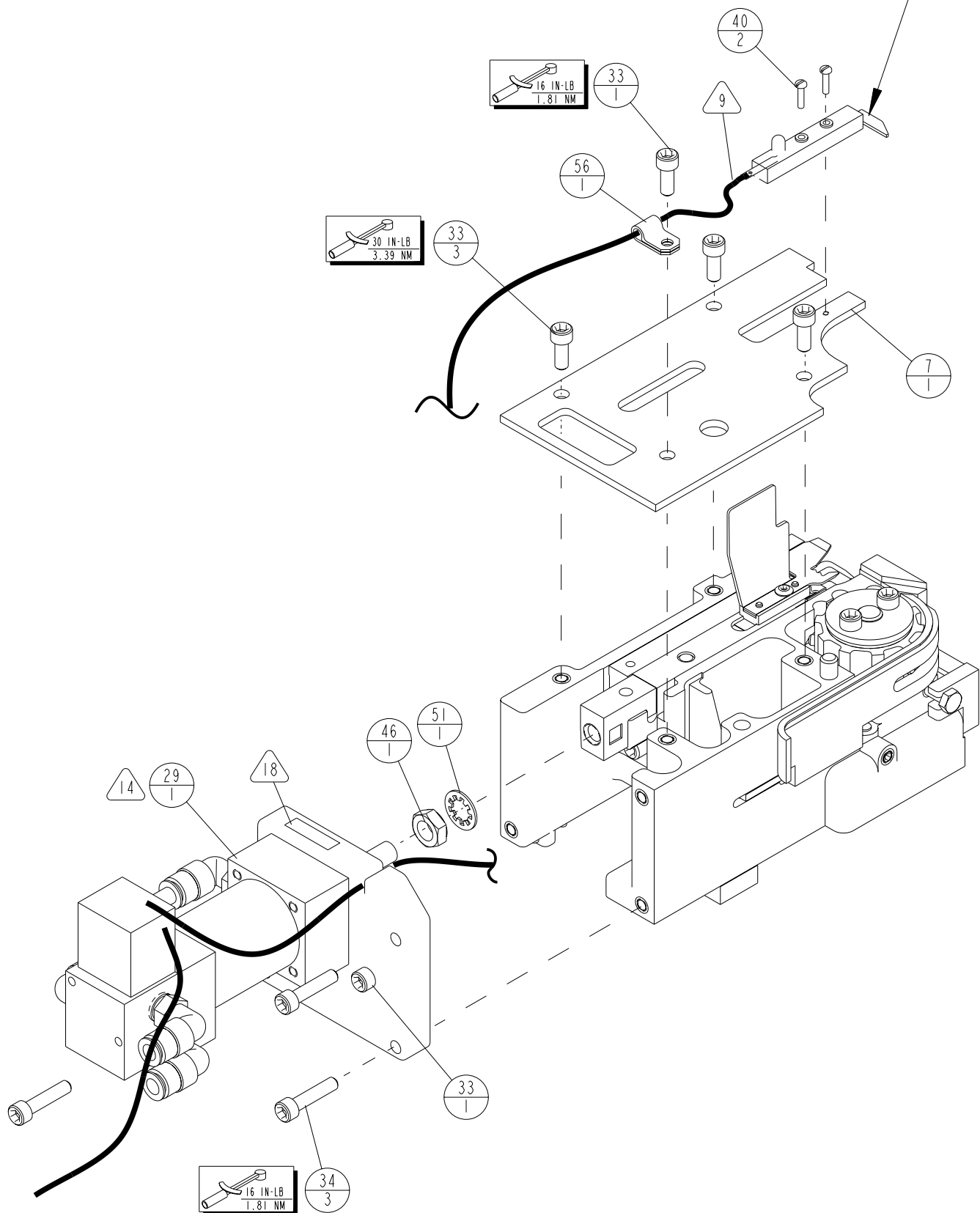


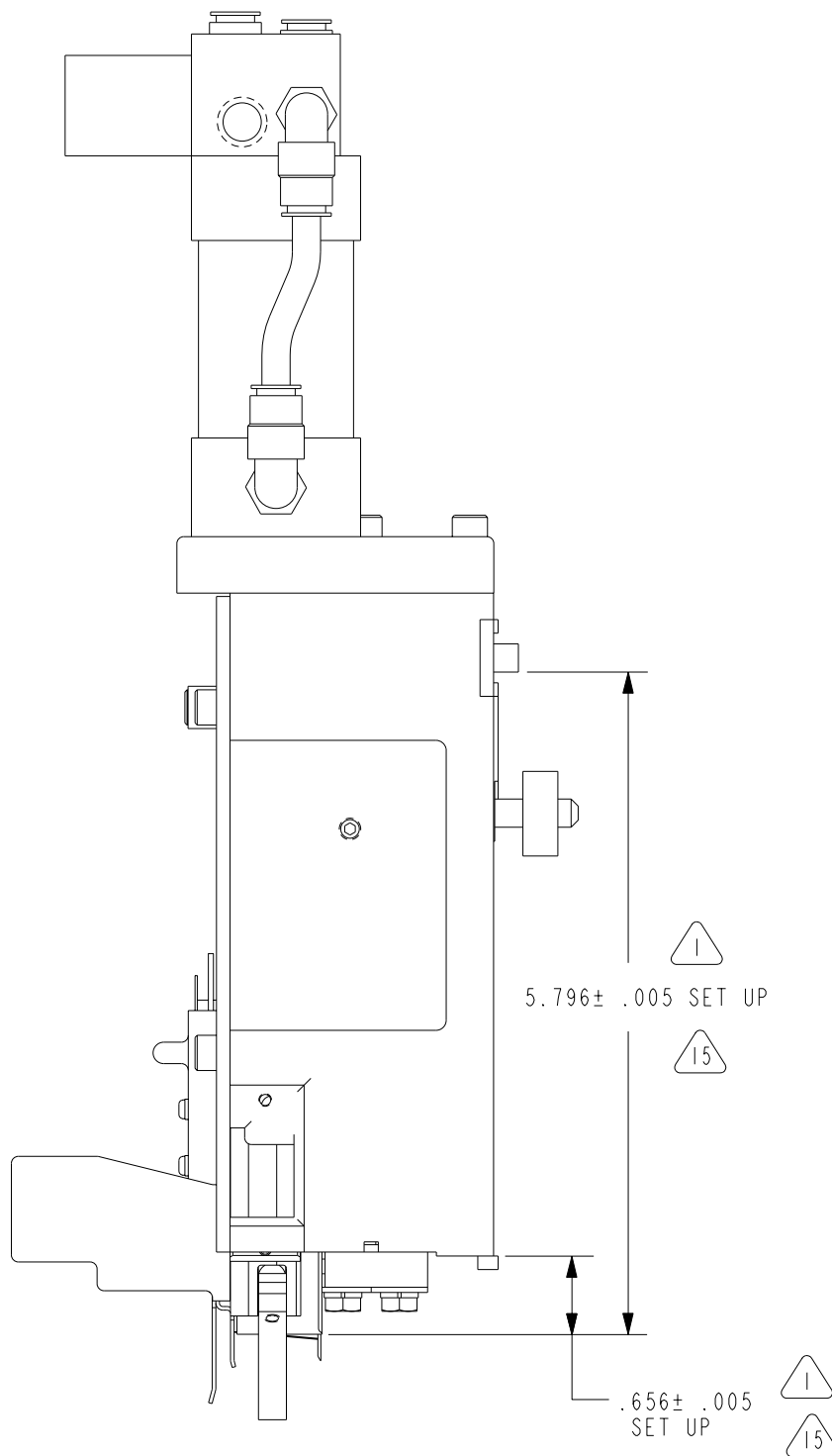
**VIEW A****VIEW B**



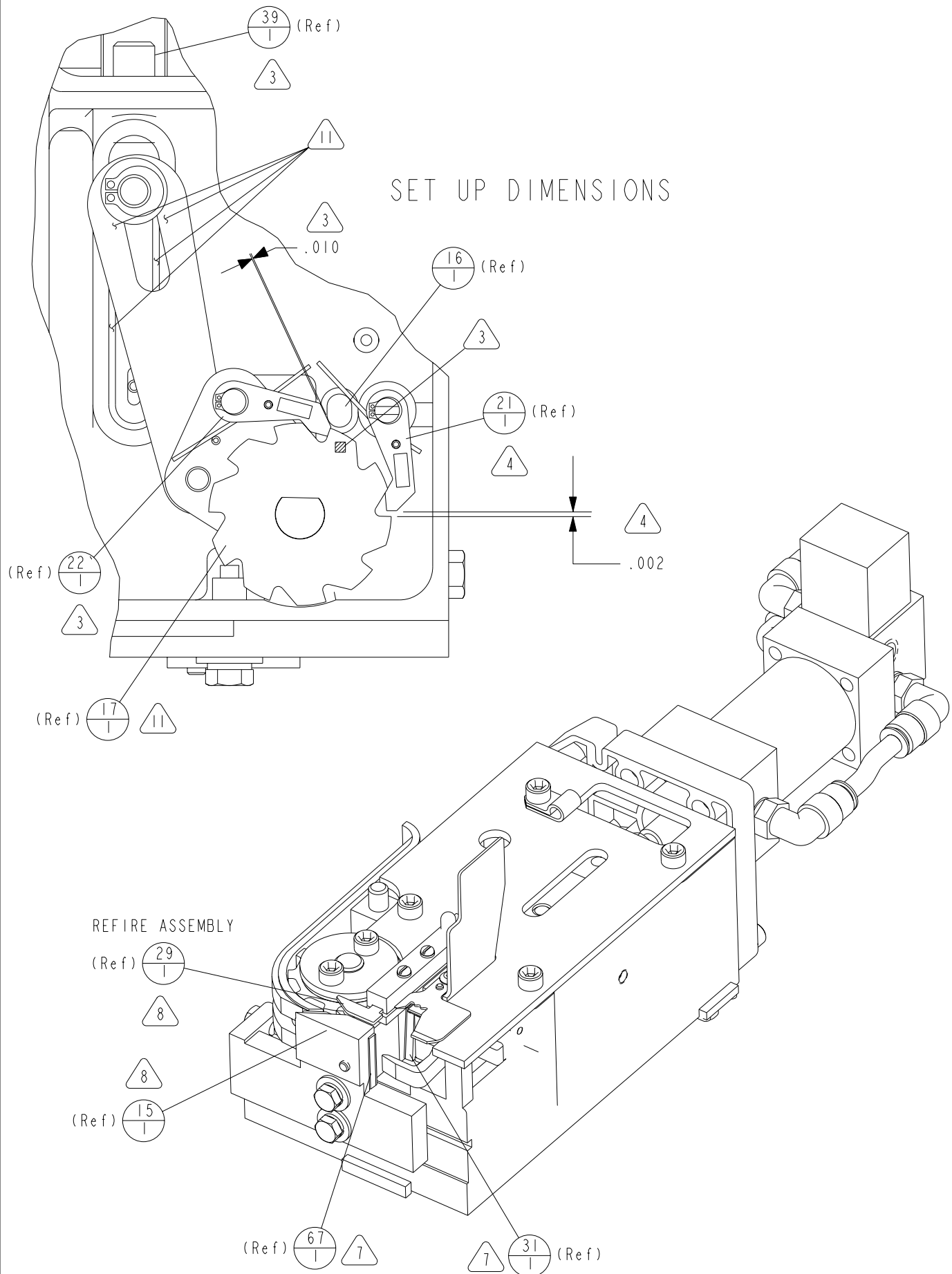




REFIRE ASSEMBLY PART
OF DET. NO. 29



SET UP DIMENSIONS



NOTES



SET TO DIM SHOWN WITH AIR PRESSURE AT 80 PSI
(FINAL ADJUSTMENT MAY BE REQ'D AT INSTALLATION
ON INSERTION MACHINE).



ORIENT PIN WITH SLOT TO REAR AS SHOWN. PIN TO
PROTRUDE .100 TO RIDE IN SLOT IN CARRIER.



SET UP .010" GAP BETWEEN DOG (.062 X .230) AND
HOUSING WHILE ON THE HIGHEST POINT OF RATCHET
ASSEMBLY, WITH AIR PRESSURE SET AT 80 PSI. MARK
TOOTH USED TO SET GAP.



SET UP .002" GAP BETWEEN DOG (.062 X .250) AND
RATCHET ASSEMBLY WHILE IN THE SAME SET UP POSITION
AS WAS USED IN NOTE 3. AIR PRESSURE SET AT 80 PSI.



5

TIME FOR EXTEND 70MS MAX (DRY CYCLE)
TIME FOR RETRACT 95MS MAX (DRY CYCLE)
DISP HEAD MUST CUT PAPER .004 THICK
DISP HEAD MUST CUT CARRIER TAPE .035 THICK



APPLY LOCTITE 222 NO. BLKM07389.



SMALLEST MEASURED CLEARANCE SHOULD BE .0015
BETWEEN THE CUTTER AND STANDARD CUTTER.
CLEARANCE SHOULD BE CHECKED THE FULL LENGTH
OF THE CUTTER (BOTTOM TO TOP). ENSURE BOTH CUTTER
SURFACES ARE ENGAGED AT THE POINT OF MEASUREMENT.



SET REFIRE FLUSH TO THE EDGE OF CUTTER HOLDER.
REFIRE NOT TO OVERLAP MORE THAN .010".



LEAVE STRESS LOOP IN GROUND WIRE FROM REFIRE
ASSEMBLY.



APPLY FILM OF ANDEROL 40833833 TO BUTTON AND
COMPRESSION SPRING.

11

APPLY ANDEROL 40833833 TO ALL SLIDING SURFACES.

12

APPLY A LIGHT FILM OF ANDEROL 40833833 TO PIN OF CAM UNIT.

13

SET .001 GAP MAX BETWEEN HOUSING AND DRIVER BY TIGHTENING SSSFP SET SCREW. SET GAP WITH DRIVER STROKED OUT SO CUTTER AND STANDARD CUTTER ARE FLUSH.

14

BAG AND ATTACH 2.5MM UPPER PUSHER TO CYLINDER ASSEMBLY CABLE.

15

MANUFACTURING SET UP DIMENSIONS: $5.796 \pm .005$ APPLIES AT DRIVER FROM BOSS OF HOUSING OR $.656 \pm .005$ APPLIES AT DRIVER FROM FRONT SURFACE OF HOUSING.

19

16

5.0 UPPER PUSHER SHOWN FOR 5.0 MM COMPONENTS. FOR 2.5 MM COMPONENTS REPLACE WITH 2.5 MM UPPER PUSHER.

17

INSTALL CURVED SPRING WASHER WITH CROWN UP (TOWARDS CHUTE).

18

INSTALL ID LABEL WITH PART NUMBER, REV, DATE AND SERIAL NUMBER THIS LOCATION.

19

CRITICAL TO FUNCTION.

20

NO GREASE AREA - WIPE OFF GREASE IN THIS AREA BEFORE ASSEMBLING THE FEED WHEEL ON TO THE RATCHET ASSEMBLY.

| | | | | | | |
|---------|----------|--|-----------|-----------------|-----|-----|
| Page 12 | | Rev. A | T50849901 | RL DISP HD ASSY | | |
| DET NO. | ITEM NO. | DESCRIPTION | | | QTY | U/M |
| 1 | 10219003 | BUSHING, DU | | | 1 | EA |
| 2 | 10249133 | SPRING, COMPRESSION | | | 1 | EA |
| 3 | 21838000 | BEARING, BALL | | | 2 | EA |
| 4 | 25239000 | LOCKING ELEMENT | | | 1 | EA |
| 5 | 30194200 | CARRIER | | | 1 | EA |
| 6 | 30194400 | DRIVER | | | 1 | EA |
| 7 | 30200100 | COVER | | | 1 | EA |
| 8 | 30486900 | SPRING | | | 1 | EA |
| 9 | 30535803 | PIN | | | 1 | EA |
| 10 | 30576403 | STOP | | | 1 | EA |
| 11 | 30590701 | RETAINER PIN, SPRING | | | 1 | EA |
| 12 | 30881501 | PLATE, NUT | | | 1 | EA |
| 13 | 30946901 | PIN, DRIVE | | | 1 | EA |
| 14 | 30947001 | CLAMP PLATE | | | 1 | EA |
| 15 | 40130305 | HOLDER, CUTTER | | | 1 | EA |
| 16 | 41835802 | HOUSING | | | 1 | EA |
| 17 | 42727001 | RATCHET ASM | | | 1 | EA |
| 18 | 43620501 | SPRING, R TORSION | | | 1 | EA |
| 19 | 43620601 | SPRING, R TORSION | | | 1 | EA |
| 20 | 44146102 | CHUTE | | | 1 | EA |
| 21 | 44170501 | DOG | | | 1 | EA |
| 22 | 44170502 | DOG | | | 1 | EA |
| 23 | 44170701 | CAM UNIT | | | 1 | EA |
| 24 | 44236802 | FEED WHEEL | | | 1 | EA |
| 25 | 44239301 | GIB | | | 1 | EA |
| 26 | 44426401 | DRIVER | | | 1 | EA |
| 27 | 44426606 | PUSHER, UPPER 5.0 | | | 1 | EA |
| 28 | 44426701 | PUSHER, LOWER | | | 1 | EA |
| 29 | 47061704 | CYLINDER ASSY | | | 1 | EA |
| 30 | 48732302 | FLAG, MOLDED | | | 1 | EA |
| | | This Document Supports Assembly T50849901 Rev. - | | | | |

| Page 13 | | Rev. A | T50849901 | RL DISP HD ASSY | | |
|---|-----------|------------------------|-----------|-----------------|---|----|
| 31 | 49599001 | CUTTER, STANDARD | | | 1 | EA |
| 32 | 80000514 | SHCS 10-32 X 3/8 | | | 2 | EA |
| 33 | 80000515 | SHCS 10-32 X 1/2 | | | 5 | EA |
| 34 | 80000518 | SHCS 10-32 X 7/8 | | | 3 | EA |
| 35 | 80004601 | SSSFP 4-40 X 1/8 | | | 1 | EA |
| 36 | 80004602 | SSSFP 4-40 X 3/16 | | | 1 | EA |
| 37 | 80004701 | SSSFP 6-32 X 1/8 | | | 1 | EA |
| 38 | 80004911 | SSSFP 10-32 X 3/8 | | | 1 | EA |
| 39 | 80005107 | SSSFP 5/16-18 X 1 | | | 1 | EA |
| 40 | 80008305 | PHMS 2-56 X 3/8 | | | 2 | EA |
| 41 | 80009303 | FHMS 2-56 X 1/4 | | | 2 | EA |
| 42 | 80010001 | SDP 3/16 X 1/2 | | | 1 | EA |
| 43 | 80014103 | SPRG PIN .125 X .437 | | | 1 | EA |
| 44 | 80014302 | SPRG PIN .187 X .500 | | | 1 | EA |
| 45 | 80014312 | SPRG PIN .187 X 1.250 | | | 1 | EA |
| 46 | 80015103 | HEX JAM NUT 5/16-18 | | | 1 | EA |
| 47 | 80017101 | SFHS-NP 6-32 X 3/8 | | | 2 | EA |
| 48 | 80018705 | SLW #10 | | | 2 | EA |
| 49 | 80018804 | FW #8 | | | 1 | EA |
| 50 | 80018805 | FW #10 | | | 2 | EA |
| 51 | 80019007 | ITLW 5/16 | | | 1 | EA |
| 52 | 80024012 | HHMS 10-32 X 5/8 | | | 3 | EA |
| 53 | 80062601 | BHTSCS 6-32 X 1/2 | | | 1 | EA |
| 54 | 80067817 | SHCS-ZP 1/2-20 X 1 3/4 | | | 1 | EA |
| 55 | 90055676 | 15mm DSP HD LINK | | | 1 | EA |
| 56 | BLKE01071 | CLAMP, 3/16" | | | 1 | EA |
| 57 | BLKM05004 | BEARING, THRUST | | | 1 | EA |
| 58 | BLKM06312 | RING, RETAINING | | | 1 | EA |
| 59 | BLKM06328 | RET RING 5100-37 | | | 1 | EA |
| 60 | BLKM06329 | RET RING 5100-18 | | | 4 | EA |
| 61 | BLKM06597 | "NO-MAR" SET SCREW | | | 1 | EA |
| This Document Supports Assembly 50849901 Rev. - | | | | | | |

