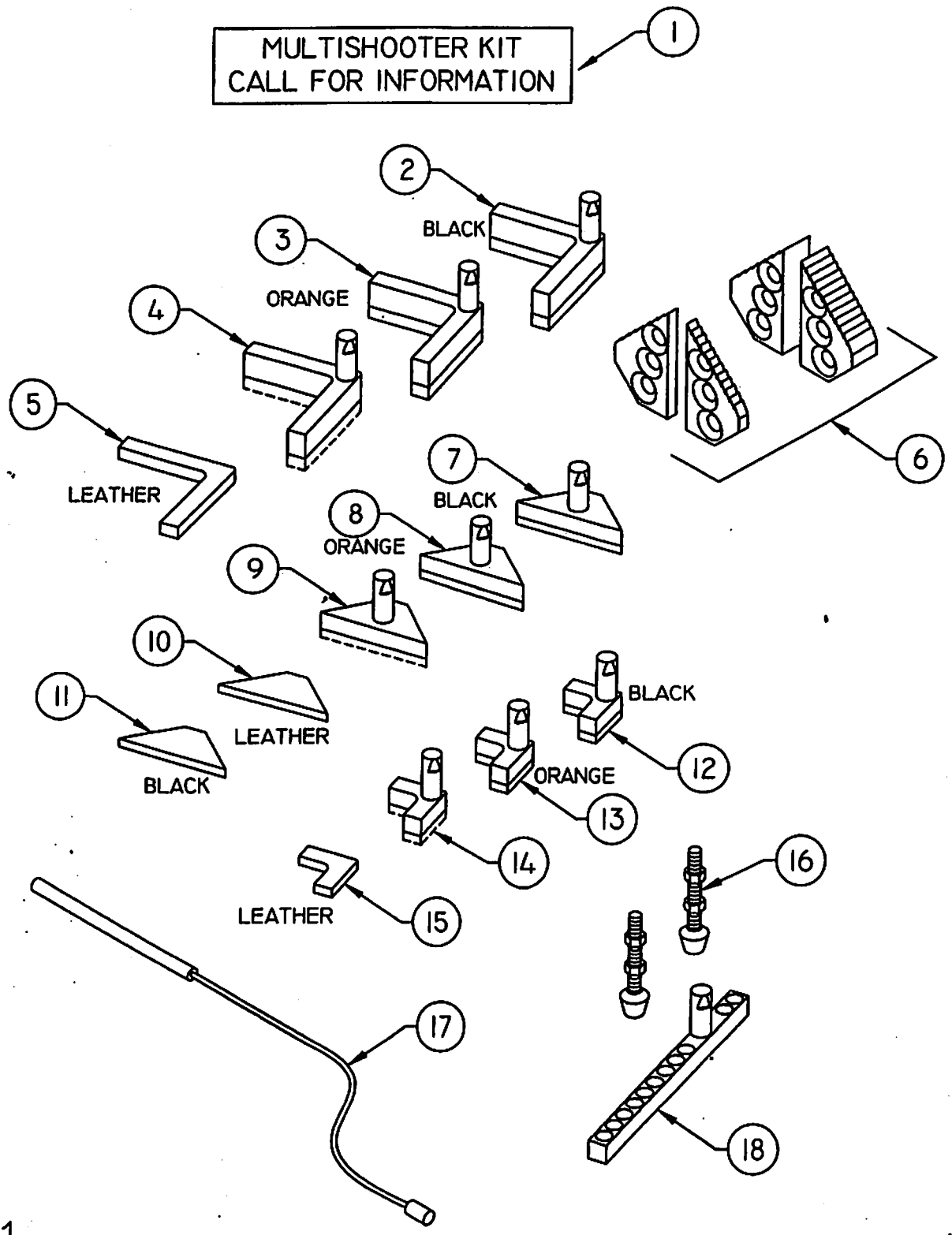


Item #	Description	Part#
1	Multishooter Kit	Call For Details
2	Large Chevron w/Black Urethane	V9810 BLACK
3	Large Chevron w/Orange Urethane	V9810 ORANGE
4	Large Chevron w/No Pad	V9810
5	Leather Pad for Large Chevron	P5017
6	Special Jaws Various Heights	Call for Sizes
7	Triangle	V9682
8	Triangle w/Black Urethane	V9682 BLACK
9	Triangle w/Orange Urethane	V9682 ORANGE
10	Leather Pad for V9682 Triangle	P5015
11	Rubber Pad for V9682 Triangle	P5020
12	Small Chevron w/Black Urethane	V9811, BLACK
13	Small Chevron w/Orange Urethane	V9811 ORANGE
14	Small Chevron w/No Pad	V9811
15	Leather Pad for Small Chevron	P5018
16	Rubber Tipped Spindle	S2954
17	Magnetic Pickup	T6703
18	Two Point Hold Down Bracket	V9681X

Item #	Description	Part#	Qty
1	Trunion Block	A0002	2
2	1/4 Hard Washer	A9325	4
3	1/4-20 x 1 SHCS	A1559	4
4	Adjustable Handle 1-1/4	P5025	2
5	Adjustable Handle 1-1/4	P5025	2
6	Stand	FFTAFRAME	1
7	Gas Shock	S2920	2

STEP-MASTER VER: 1.0, 1.1

OPTIONS AND ACCESSORIES

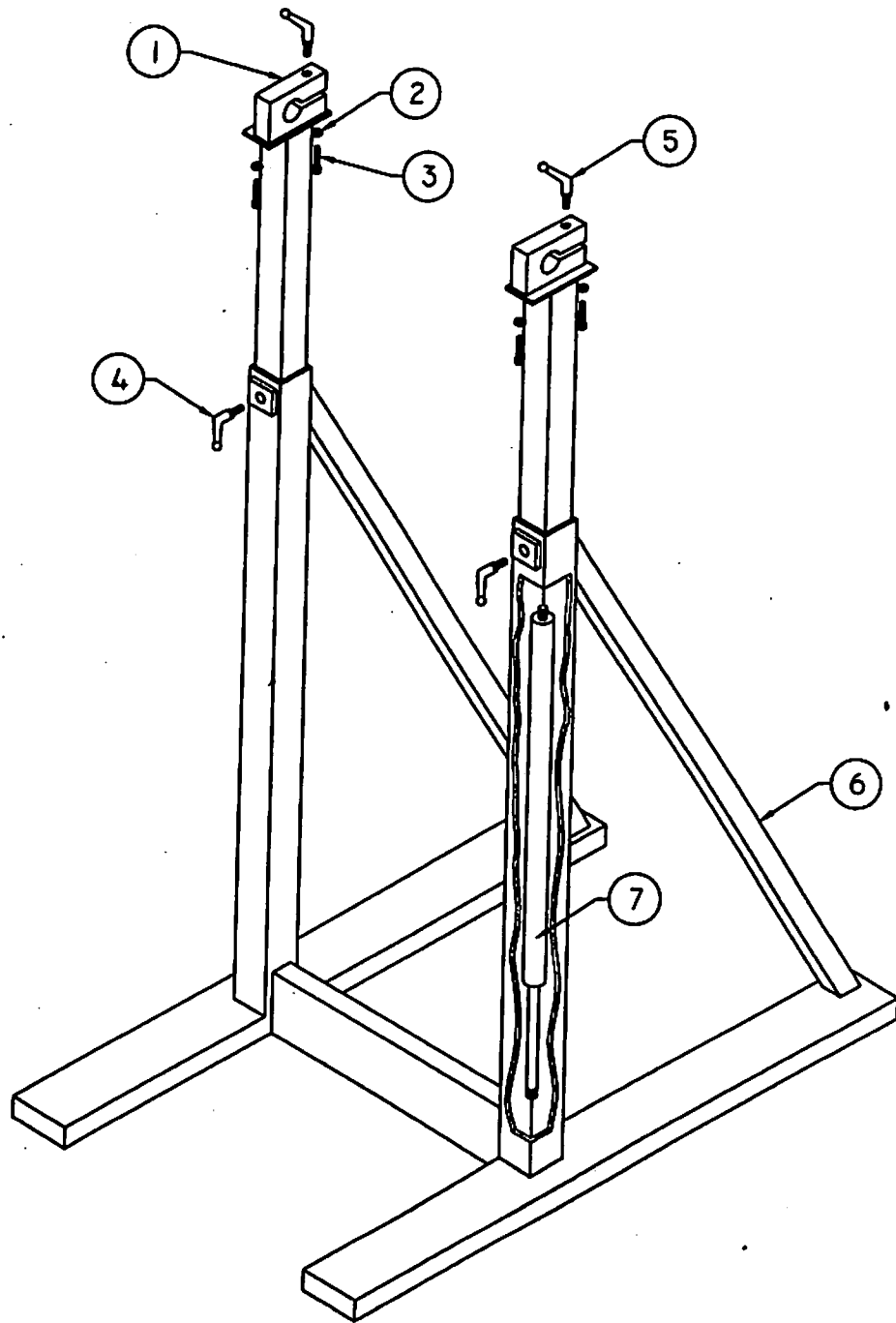


9.31

Item #	Description	Part#	Qty
1	Trunion Block	A0002	2
2	1/4 Hard Washer	A9325	4
3	1/4-20 x 1 SHCS	A1559	4
4	Adjustable Handle 1-1/4	P5025	2
5	Adjustable Handle 1-1/4	P5025	2
6	Stand	FFTAFRAME	1
7	Gas Shock	S2920	2

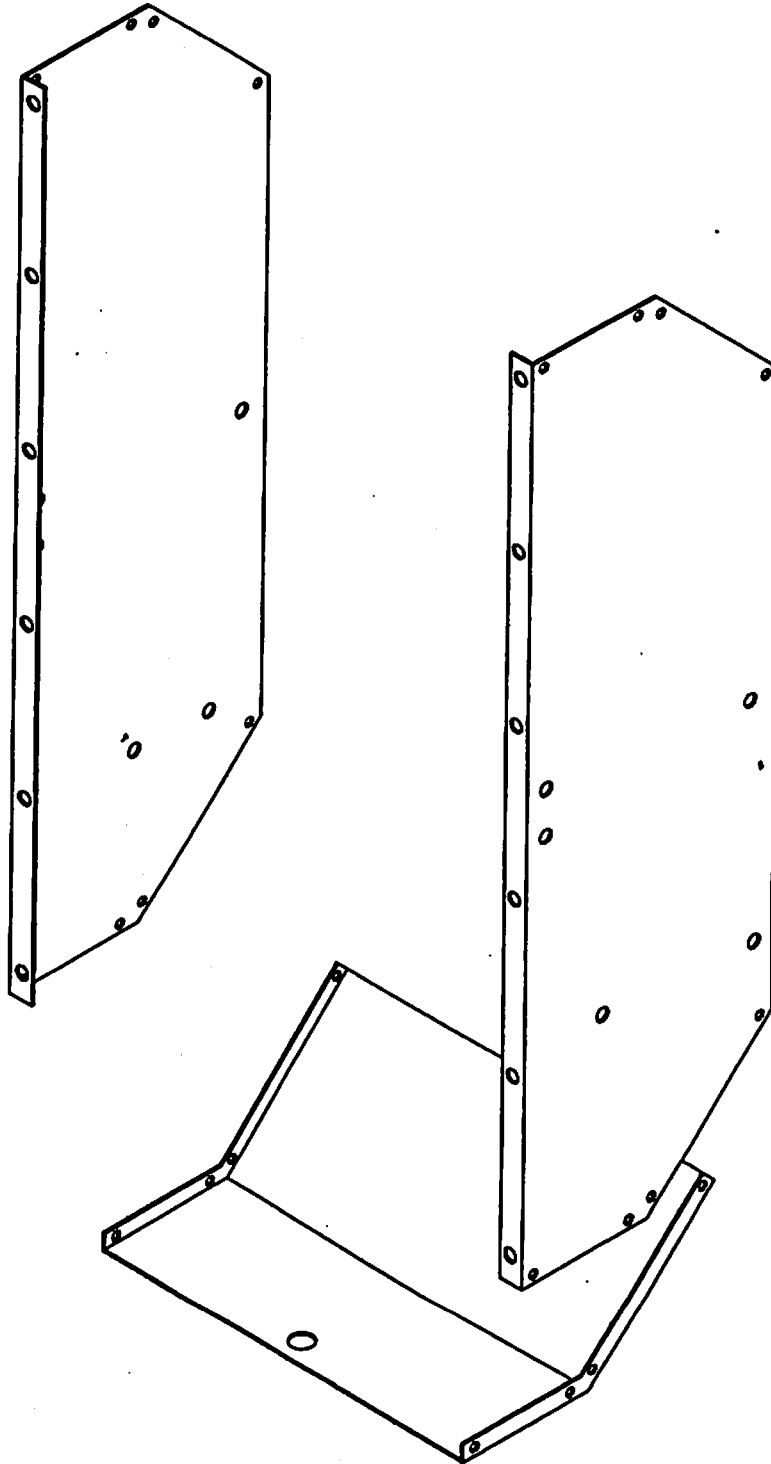
STEP-MASTER VER: 1.0, 1.1

STAND



STEP-MASTER VER: 1.0, 1.1

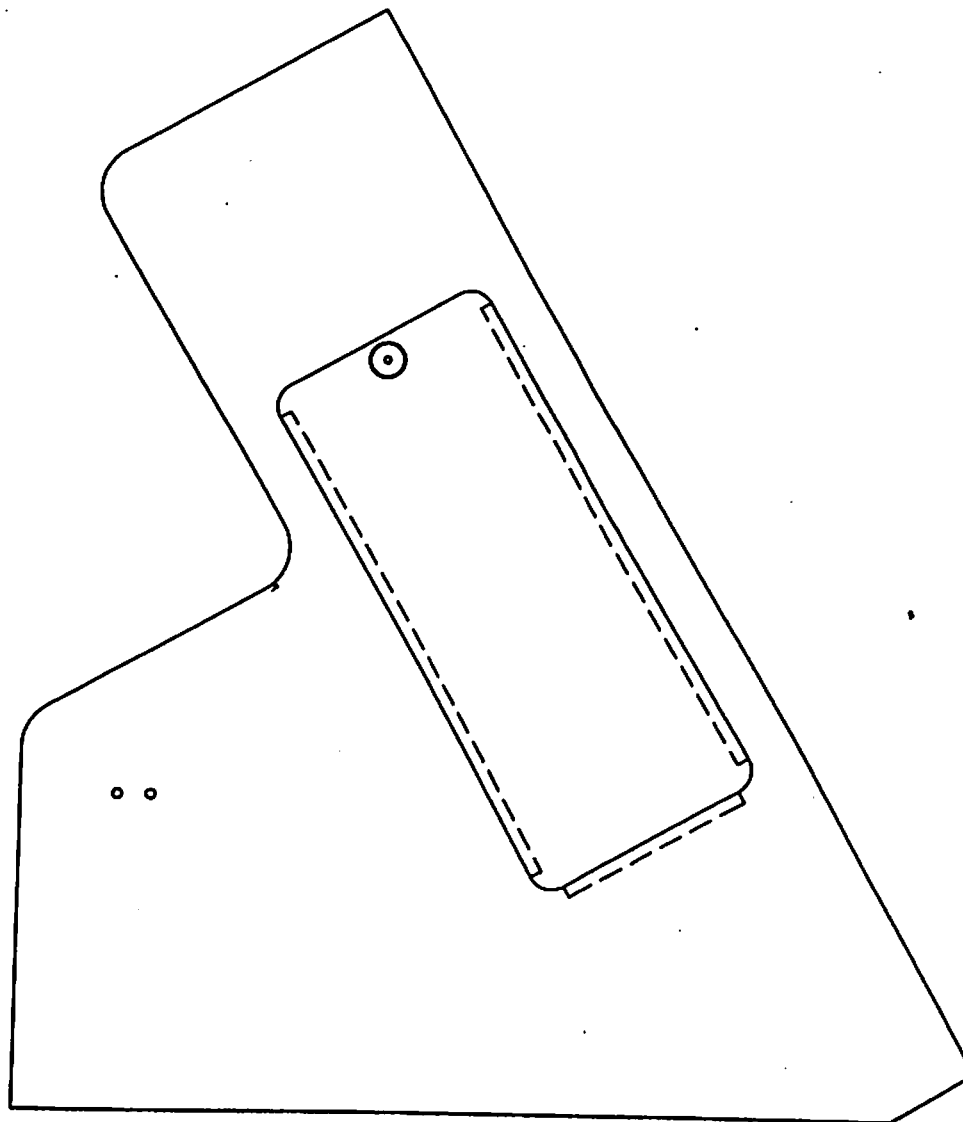
SKIRT
STAND MODEL



9.28

STEP-MASTER VER: 1.0, 1.1

SKIRT
TABLE TOP MODEL

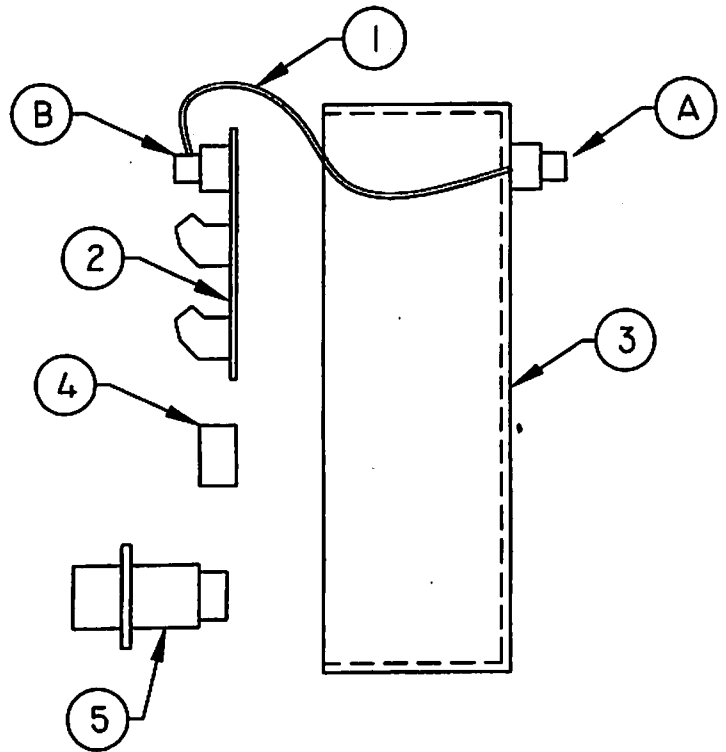
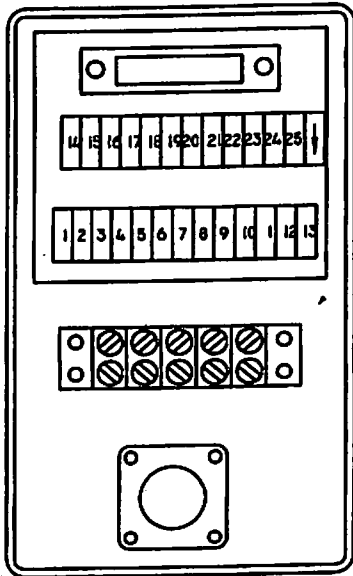


9.27

Item #	Description	Part#	Qty
1	Ribbon Cable		
2	Connection Interface	T7120	1
3	Plastic Box	T7121	1
4	Terminal Block	T7123	1
5	Foot Pedal Conection	T6908	1
A	25 Pin Connection to Control Unit		
B	25 Pin Connection to Interface		

STEP-MASTER VER: 1.0, 1.1

JUNCTION BOX

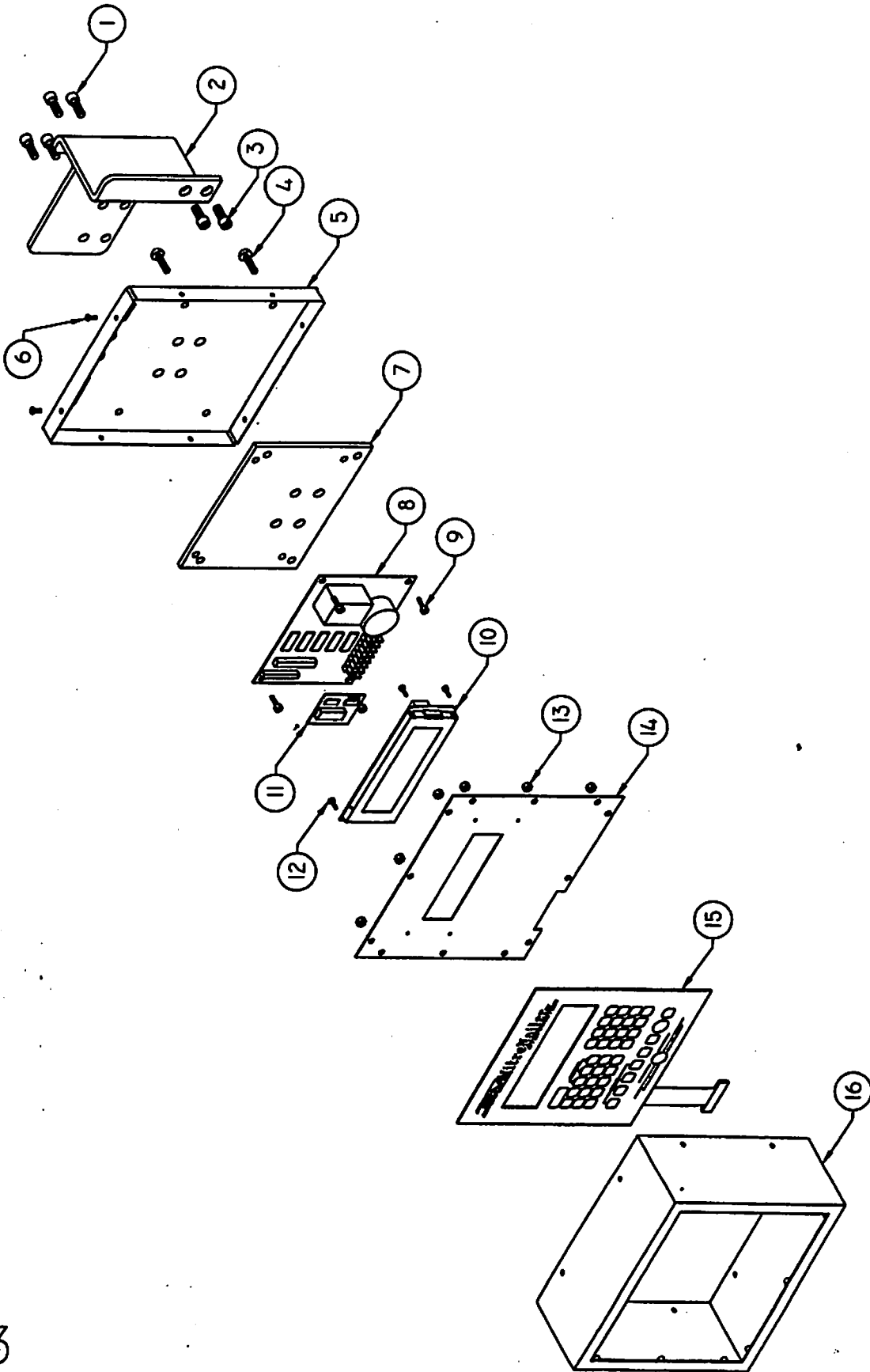


9.25

Item #	Description	Part#	Qty
1	3/8-16 X 7/8 SHCS	A2615	4
2	Mounting Plate Bent Aluminum	Z1011	1
3	1/2 x 1/2 Shoulder Bolts	C7156	2
4	1/4-20 X 1/2 BHCS	A2650	4
5	Rear Cover	Z1009	1
6	8-32 X 1/4 Pan Head Phillips Screw	A9384	7
7	Circuit Board Mount	Z1010	1
8	Circuit Board	Z1024	1
9	6-32 X 1/4 Pan Head Phillips Screw	A9385	4
10	LED Graphic Display	Z1022	1
11	CPU Board	Z1023	1
12	LED Display Screws 4-40 X 1/2 PAN PHILIPS	A9386	4
13	6-32 Nut	A5705	14
14	Overlay Mounting Plate	Z1007	1
15	Keypad Overlay	Z1025	1
16	Control Box Housing	Z1008	1

STEP-MASTER VER 1.0, 1.1

CONTROL UNIT

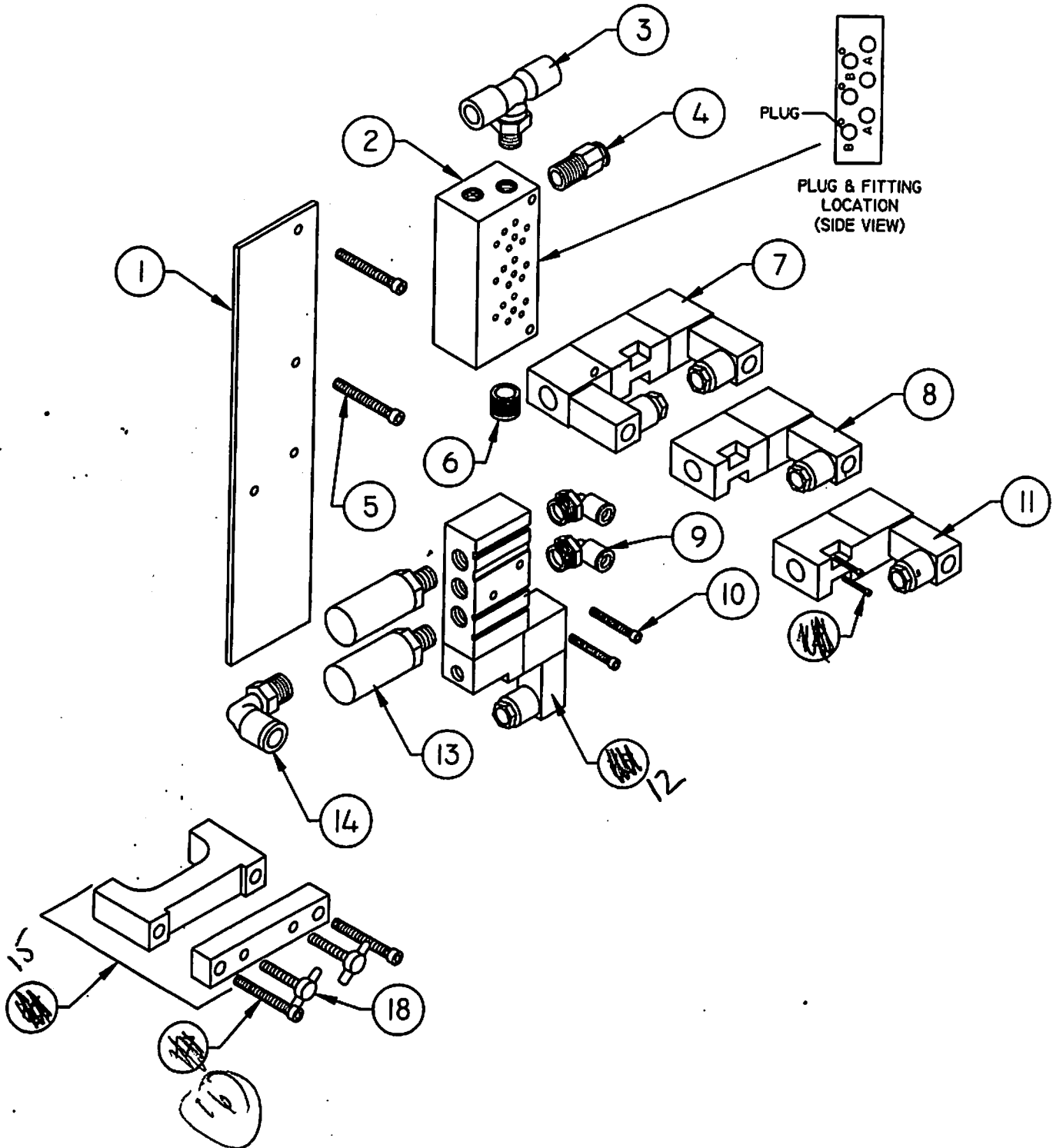


9.23

Item #	Description	Part#	Qty
1	Valve Mounting Plate	T7012	1
2	Valve Manifold	T7105	1
3	3/8 Hose -1/8 Thread Tee	C7527	1
4	1/4 Tube 1/8 Thread Straight	C7515	5
5	10-32 X 1-1/4 SHCS	A2349	2
6	1/8 Pipe plug	J1793	1
7	Double Pilot Valve (Up-Down)	T7100	1
8	Single Pilot Valve (In-Out)	T7110	1
9	1/4 Hose 1/4 Thread Elbow	C7512	2
10	8-32 X 1 SHCS	A2321	2
11	Single Pilot Valvé (Tool Fire)	T7110	1
12	Clamp - Holdown Valve	T7115	1
13	1/8 Silencer	T7417	2
14	3/8 Hose -1/4 Thread Elbow	C7537	1
15	Tower Plate Bracket Assy	T7420	1
16	1/4-20 x 5/8 SHCS	A2356	2

STEP-MASTER VER: 1.0, 1.1

VALVE TOWER



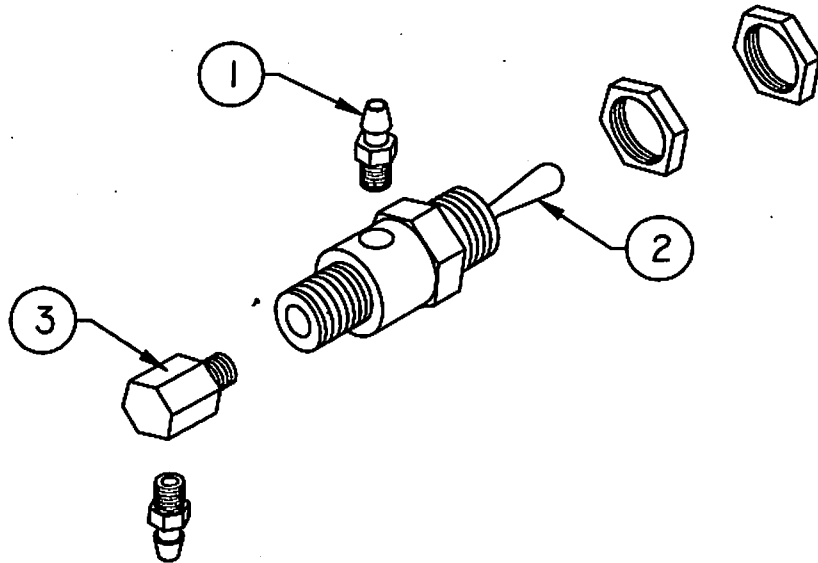
9.21

Item #	Description	Part#	Qty
1	10-32 x 1/8 Barb Fitting	C4515	9
2	1st/2nd Shot & Jaws On/Off	G4101	2
3	10-32 Street Ell	C4823	4

STEP-MASTER VER: 1.0, 1.1

SWITCH ASSEMBLY

ON JAWS / OFF

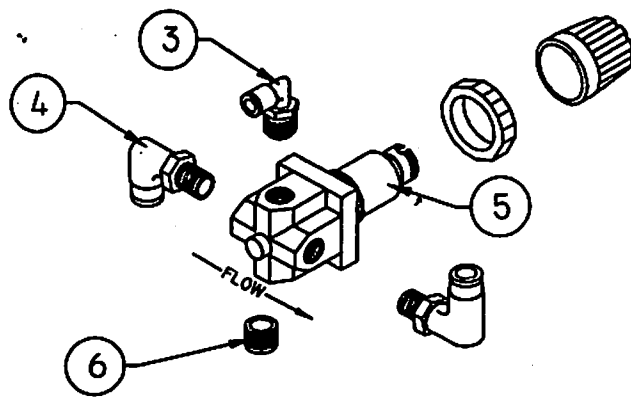
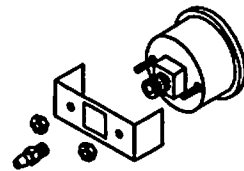
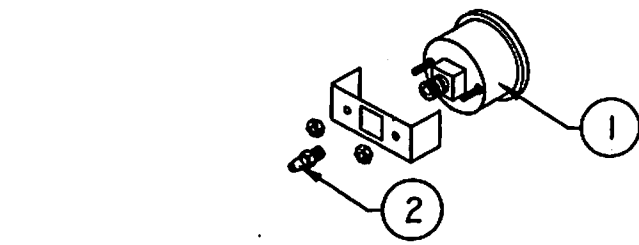


9.19

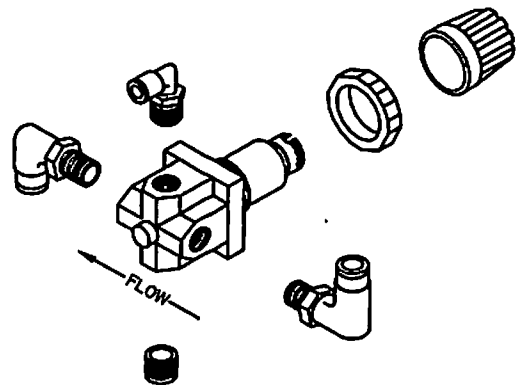
Item #	Description	Part#	Qty
1	0-160 PSI Gauge with Hardware	T6800	2
2	10-32 x 1/8 Hose Barb	C4515	2
3	1/8 Thread - 1/4 Tube Elbow	C7513	2
4	1/4 Thread - 3/8 Tube Elbow	C7537	4
5	1/4" Regulator	G3955	2
6	1/8" Pipe Plug	J1793	1

STEP-MASTER VER: 1.0, 1.1

REGULATOR ASSEMBLY



REGULATOR #2

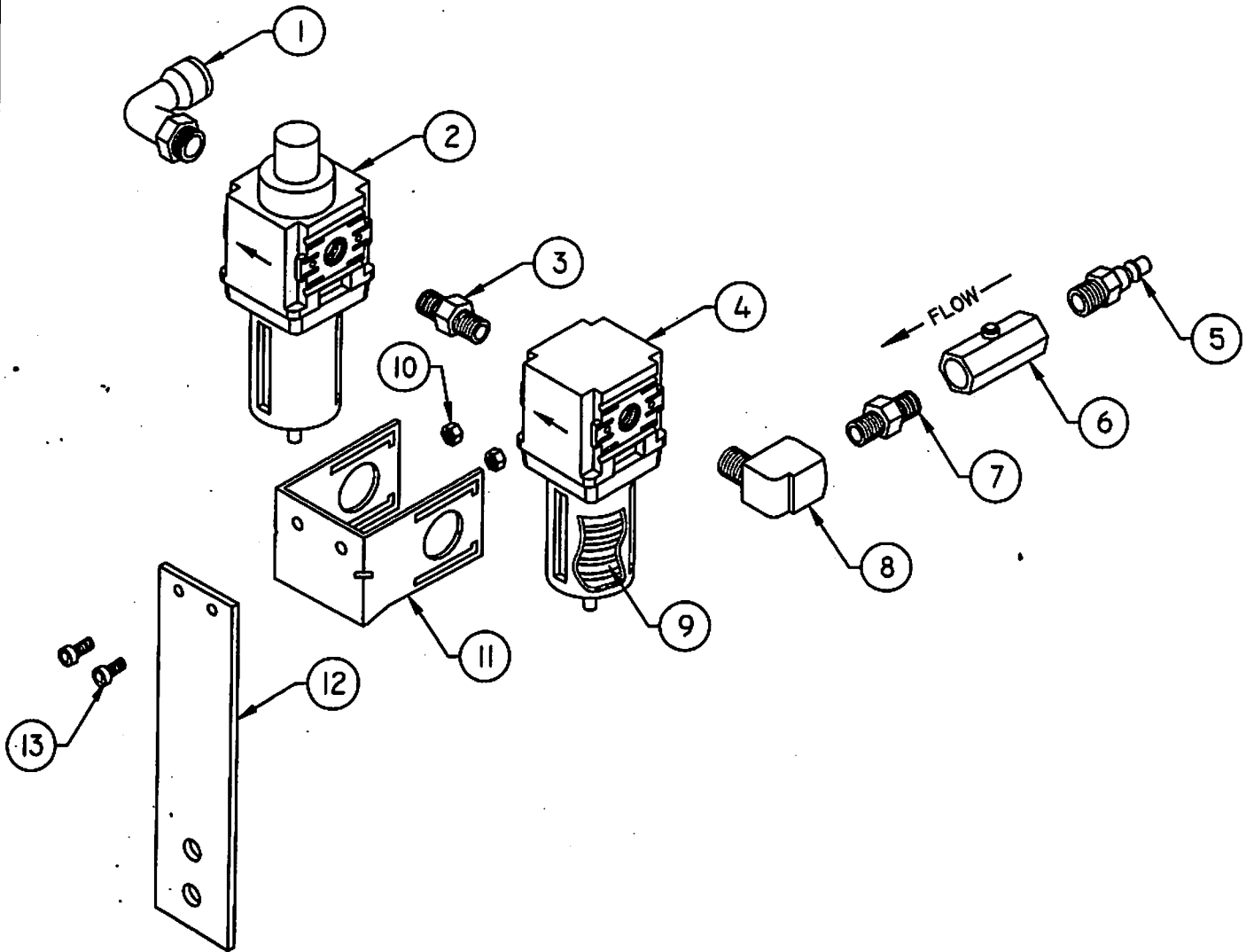


REGULATOR #1

Item #	Description	Part#	Qty
1	1/4 Thread - 3/8 Tube Elbow	C7537	1
2	1/4" Lubricator	G3952	1
3	1/4" Hex Nipple	C6336	1
4	1/4" Air Filter	J1751	1
5	Coupler Plug	C6343	1
6	Flow Control	G3852	1
7	1/4" Hex Nipple	C6336	1
8	1/4 Street Ell	C6325	1
9	Filter Element (Wilkerson)	G4105	1
10	10-32 Nuts	A2401	2
11	Mounting Bracket	G4100	1
12	Tall Mounting Bracket (Stand Model Only)	P4356	1
13	10-32 x 1/2 BHCS	A2350	2

STEP-MASTER VER 1.0, 1.1

FILTER AND LUBRICATOR ASSEMBLY

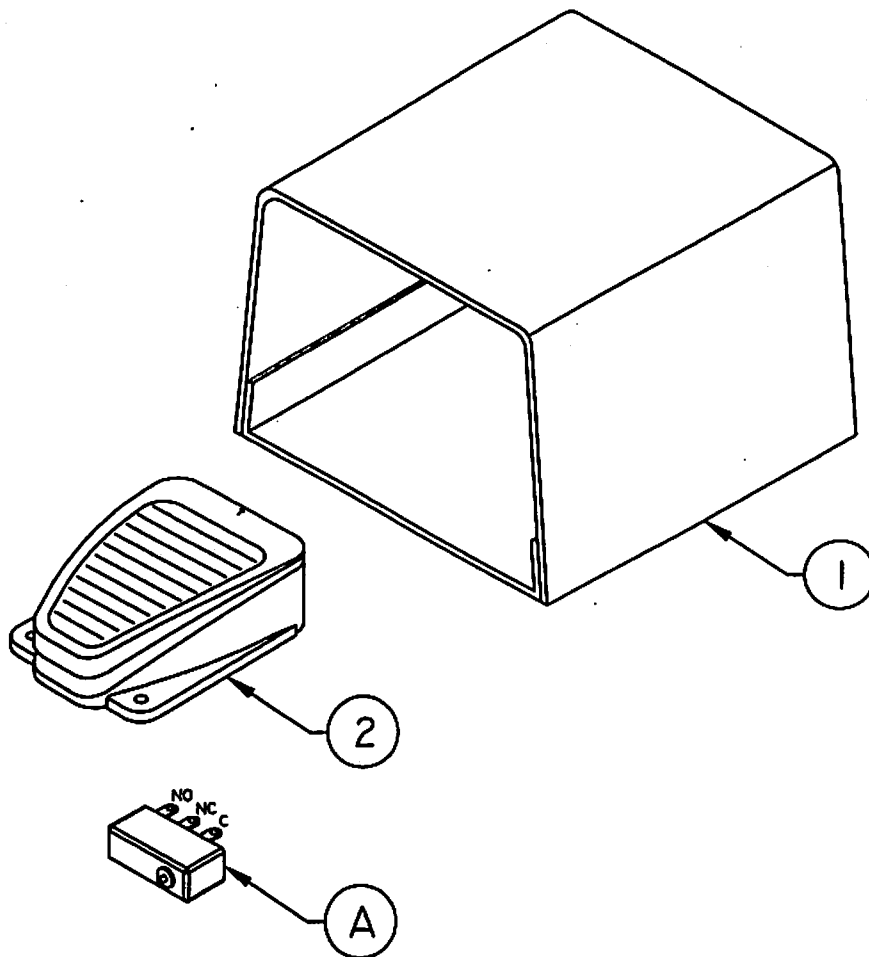


9.15

Item #	Description	Part#	Qty
1	Foot Switch Cover	S2887	1
2	Electric Foot Switch	S2888	1
A	Switch Diagram	NO	Normally Open
		NC	Normally Closed
		C	Closed

STEP-MASTER VER 1.0, 1.1

FOOT CONTROL ASSEMBLY

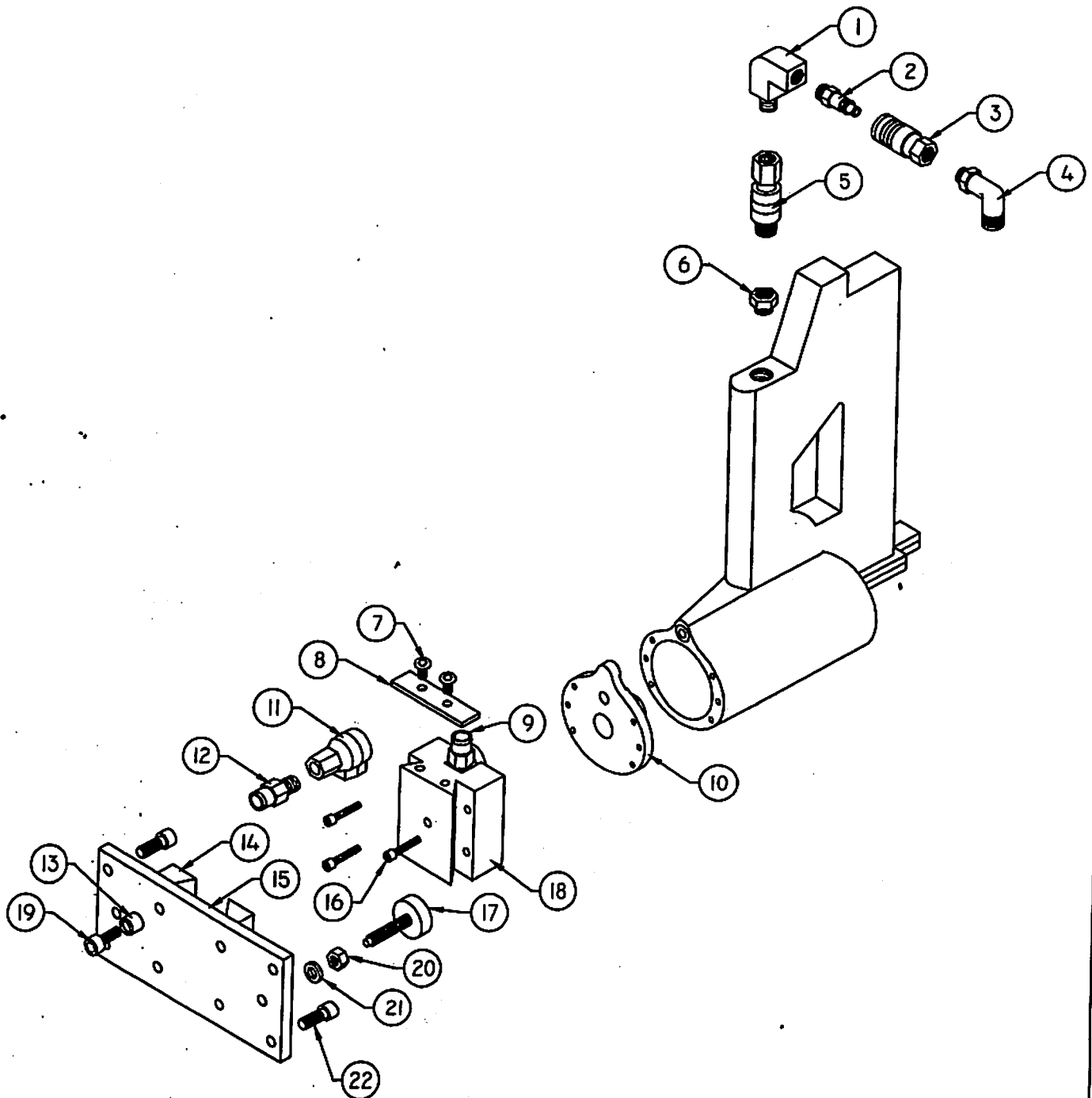


9.13

Item #	Description	Part#	Qty
1	1/4 Street Ell	C6325	1
2	Air Supply Plug	C6343	1
3	Primary Tool Air Supply Coupler	C6347	1
4	3/8 Tube 1/4 Thread Elbow	C7537	1
5	Foster Slide Valve	C6339	1
6	3/8 - 1/4 Reducer	C6353	1
7	8-32 x 1/2 BHCS	A2507	2
8	Stop Bar	T6722	1
9	1/4 Tube 1/8 Thread Elbow	C7513	1
10	Tool Cap	V9597	1
11	Quick Exhaust	C6378	1
12	1/4 Tube 1/8 Thread Straight	C7515	1
13	Spacer	L5160	4
14	Dovetail Sides	T6718	2
15	Tool Mount Plate	T7018	1
16	8-32 X 1-1/4 SHCS	A 1536	4
17	Depth Adjustment Screws (Ver 1.1 only)	T7419	2
18	Dovetail Cap	T6739	1
19	5/16-24 X 1-1/4 SHCS	A1547	4
20	5/16-18 Hex Nut (Ver 1.1 only)	A5731	2
21	5/16 Lock Washer (Ver 1.1 only)	A9383	2
22	5/16-18 x 3/4 SHCS	A2380	4

STEPMASTER VER: 1.0, 1.1

TOOL ASSEMBLY

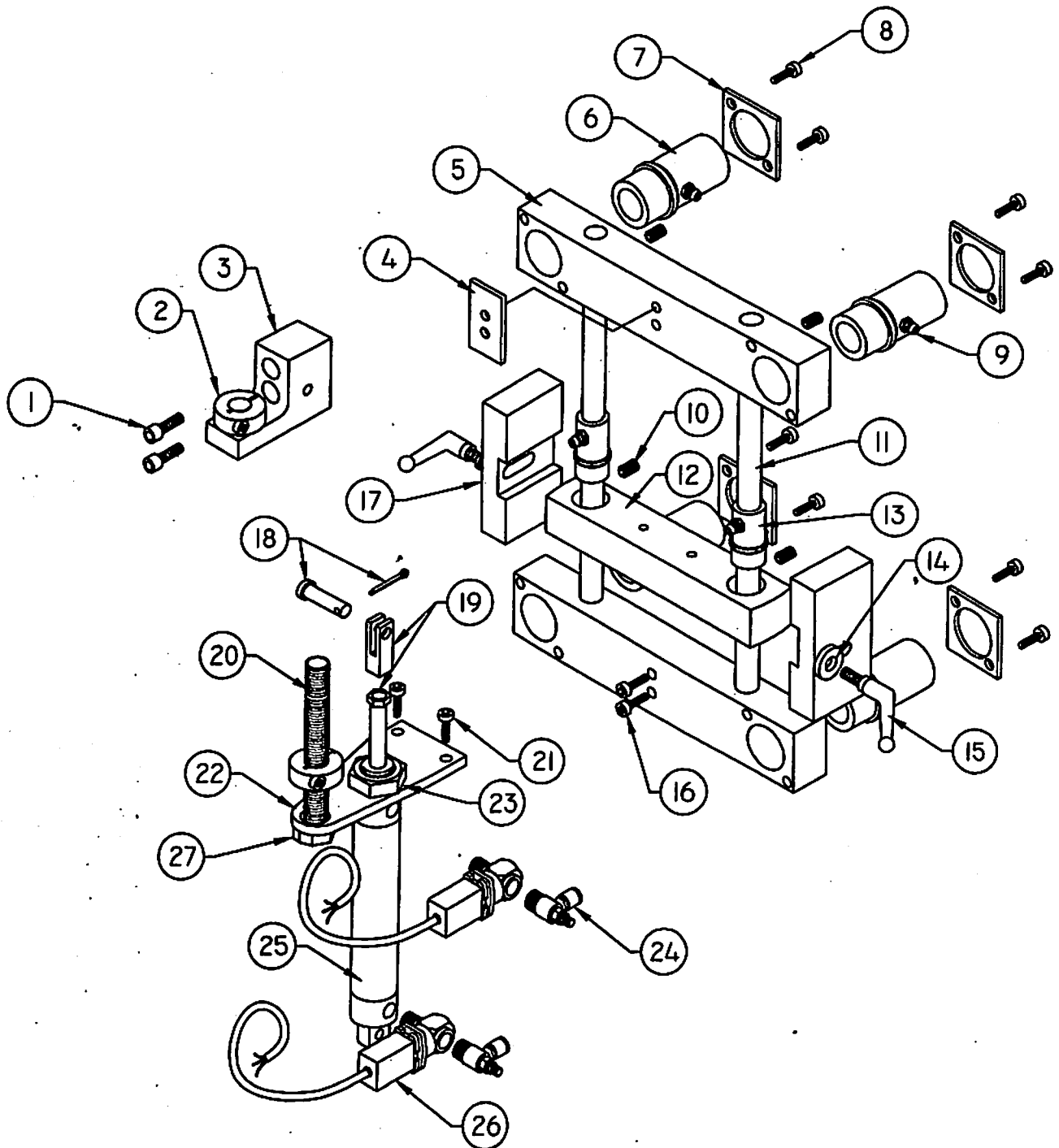


9.11

Item #	Description	Part#	Qty
1	1/4-20 x 1-3/4 SHCS	A2363	2
2	1/2"-13 Lock Collar	J1760	2
3	Cylinder Clevis Mount	T7010	1
4	Spacer	T7035	1
5	Cross Bracket	T7006	2
6	3/4" Bushing	P5060	4
7	3/4" Bushing Keeper	T7004	4
8	1/4-20 X 1/2 SHCS	A2408	8
9	Zurk Fitting	P5066	6
10	5/16-24 x 1/4 Set Screw	A2505	4
11	1/2" x 11" Rods	S2840	2
12	Center Cross Bar	T7030	1
13	1/2" Bushing	P5061	2
14	5/16 Hard Washer	A2508	2
15	5/16-18 x 3/4 Orange Handle	MN0057	2
16	1/4-20 x 1-1/4 SHCS	A2512	2
17	Pivot Block	T7002	2
18	1/4 x 1/2 Pin and cotter pin	J1830	1
19	Clevis and Nut	J1833	1
20	1/2-13 x 7" All Thread	S2841	1
21	1/4-20 x 5/8 SHCS	A2515	2
22	Cylinder Mounting Plate	T7009	1
23	5/8-18 Lock Nut	A5747	1
24	Flow Control 1/4 Tube - 1/8 Thd	C7528	2
25a	Cylinder 4" Stroke (Version 1.0)	T7021	1
25b	Cylinder 5" Stroke (Version 1.1)	T7022	1
26	Pressure Sensor	T7017	2
27	1/2 Hex Nut	A5742	1

STEP-MASTER VER 1.0, 1.1

CARRIAGE ASSEMBLY

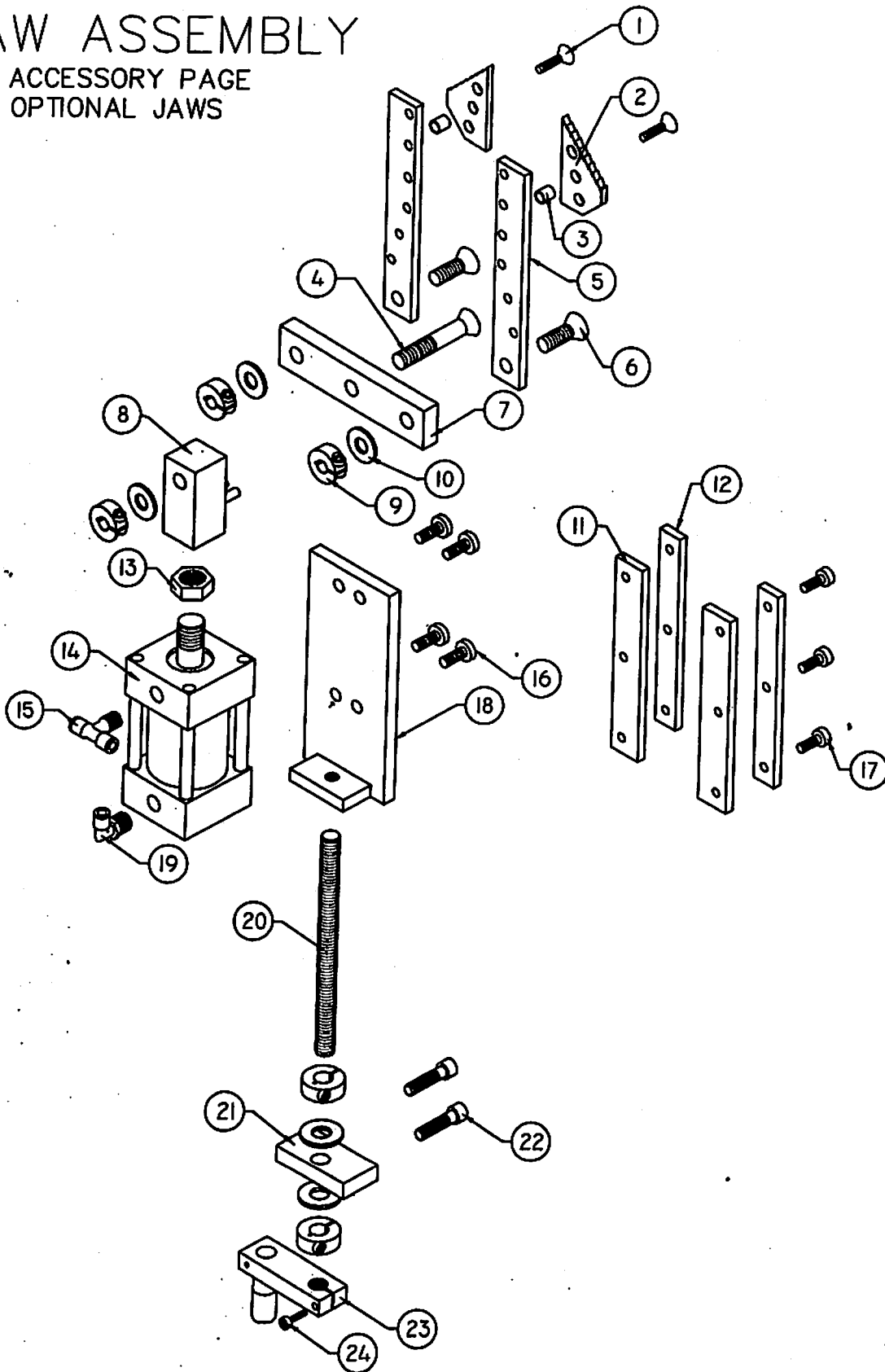


Item #	Description	Part#	Qty
1	5/16-18 x 7/8 FHCS	A2501	2
2	Jaw Set (No Threads)	P5008	1
3	Jaw Bushings	P5009	2
4	1/2-13 x 2-1/2 FHCS	A1558	1
5a	Jaw Extension Arm (Version 1.0)	P5010	2
5b	Jaw Extension Arm (Version 1.1)	P6010	2
6	1/2-13 x 1-1/4 FHCS	A1555	2
7a	Jaw Cross Bracket (Version 1.0)	P4354	1
7b	Jaw Cross Bracket (Version 1.1)	P6354	1
8	Jaw Arm Push Block	J1777	1
9	1/2-13 Lock Collar	J1760	5
10	1/2" Brass Washer	J1762	5
11a	Front Jaw Cylinder Rails (Version 1.0)	S2955	2
11b	Front Jaw Cylinder Rails (Version 1.1)	S2956	2
12a	Back Jaw Cylinder Rails (Version 1.0)	S2951	2
12b	Back Jaw Cylinder Rails (Version 1.1)	S2952	2
13	3/4" Hex Nut	A5750	1
14	Jaw Air Cylinder 1"	T6638	1
15	1/4 Hose 1/4 Thread Tee	C7518	1
16	5/16-24 x 3/4 FHCS	A1549	4
17	5/16-18 x 1-1/2 SHCS	A1546	8
18a	Jaw Cylinder Support (Version 1.0)	L5166	1
18b	Jaw Cylinder Support (Version 1.1)	L5168	1
19	1/4 Hose 1/4 Thread Elbow	C7512	1
20a	Jaw Extension Rod (Version 1.0)	S2941	1
20b	Jaw Extension Rod (Version 1.1)	S2942	1
21	Jaw Extension Bracket	P4367	1
22	1/4-20 x 1/2 SHCS	A2408	2
23	Jaw Extension Handle	C5138	1
24	10-32 x 1 SHCS	A2532	1

STEPMASTER VER: 1.0, 1.1

JAW ASSEMBLY

SEE ACCESSORY PAGE
FOR OPTIONAL JAWS

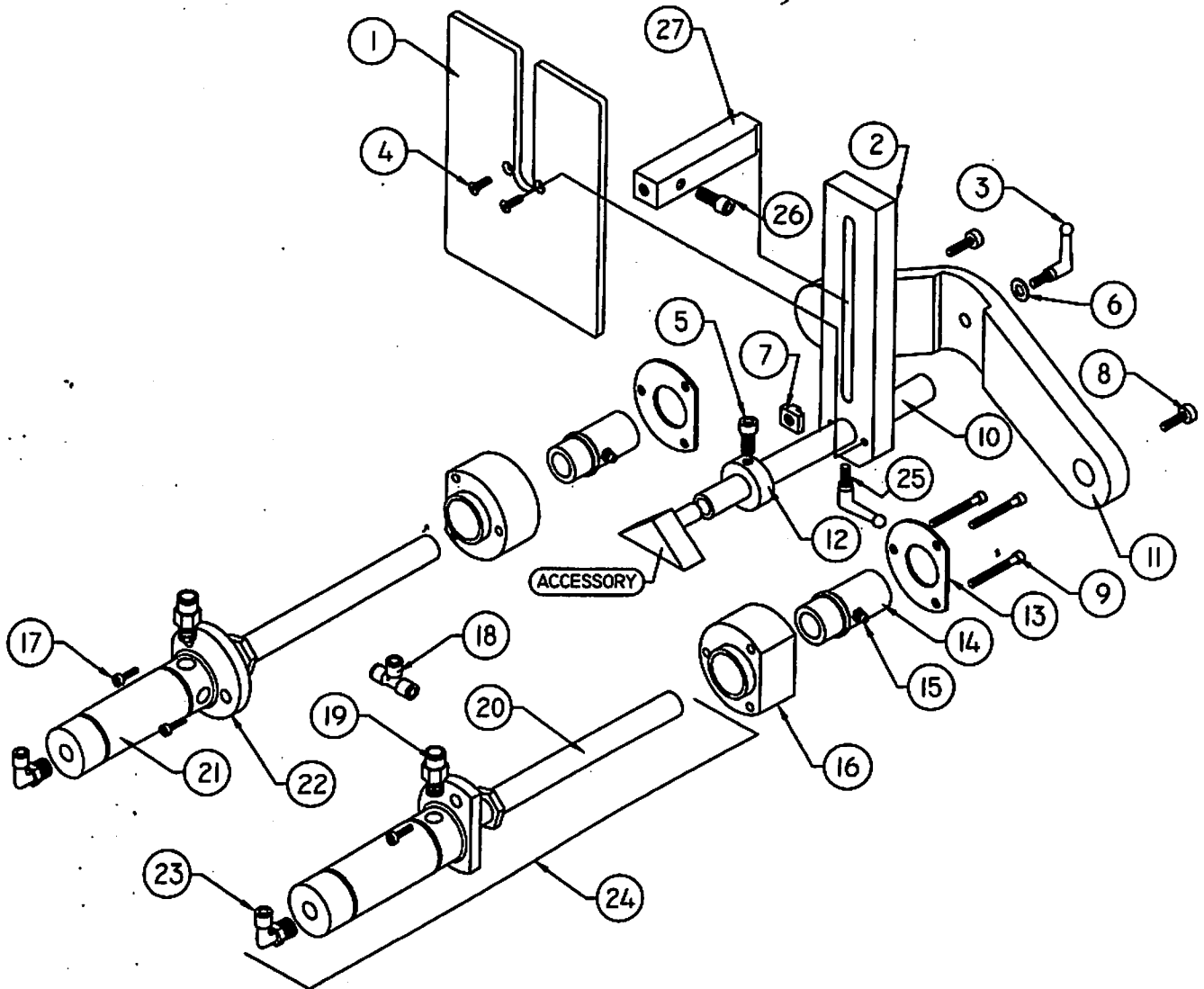


9.7

Item #	Description	Part#	Qty
1	Plastic Guard	T7016	1
2	Hold Down Slide	MN0028	1
3	Adjustable Handle 3/8-16 x 1-1/4	P5025	1
4	10-32 x 1/2 FHCS	A2523	2
5	5/16-18 x 3/4 SHCS	A2380	1
6	5/16 Hardened Washer	C7495	1
7	5/16-18 Modified Tee Nut	MN0031	1
8	3/8-16 x 1-1/4" SHCS	A2526	2
9	1/4-20 x 1/2" SHCS	A2408	6
10	Round Hold Down Bar	MN0039	1
11	Hold Down Cross Support	MN0014	1
12	3/4" Collar	J1759	1
13	Bushing Keepers	T7014	2
14	3/4" Bushings	P5060	2
15	Zurk Fitting	P5066	2
16	3/4" Bushing Mounts	T7011	2
17	1/4-20 x 1-1/4" SHCS	A2512	6
18	1/4 Tube - Tee	C7516	1
19	1/4 Tube - 1/8 Thd Straight	C7515	2
20	3/4 Cylinder Shaft	MN0010	2
21	Cylinder 2"	P6065	2
22	Cylinder Mount	MN0004	2
23	1/4 Tube - 1/8 Thd Elbow	C7513	2
24	Cylinder Assembly	MN0081	2
25	Adjustable Handle 5/16-18 x 3/4	MN0057	1
26	5/16-18 x 3/8 SHCS	A2376	1
27	Fixed Length Hold Down Bar	P5068	1

STEP-MASTER VER 1.0, 1.1

HOLD DOWN ASSEMBLY SEE OPTION PAGE FOR HOLD DOWN PADS

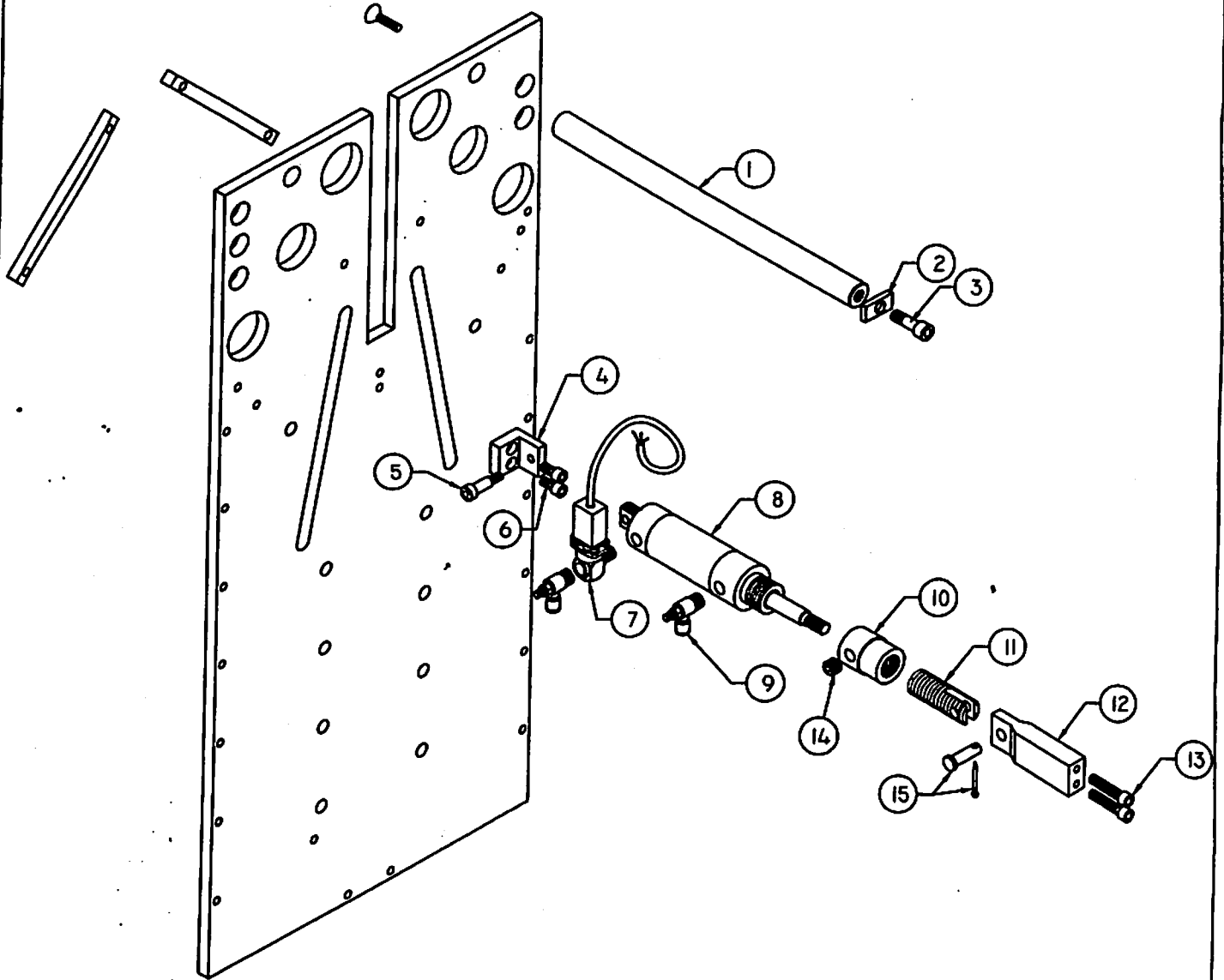


9.5

Item #	Description	Part#	Qty
1	3/4" x 13" Bearing Rods	T7023	4
2	Stop Plate on One Rod Only	T7034	1
3	3/8-16 x 5/8 SHCS	A2510	1
4	Step In Mount Bracket	T7008	1
5	5/16 x 5/8 Shoulder Bolt	C7497	1
6	1/4-20 x 1/2 SHCS	A2354	2
7	Pressure Sensor	T7017	1
8	1" In-Out Cylinder	G3885	1
9	Flow Control 1/4 Hose - 1/8 Thread Elbow	C7528	2
10	In-Out Adjustment Knob	P4210	1
11	Threaded Clevis	J1834,	1
12	Milk Bottle Bracket	T7007	1
13	1/4-20 x 1-1/4 SHCS	A2512	2
14	5/16-24 x 5/16 Set Screw	A2505	1
15	5/16 Cotter Pin	J1836	1

STEPMASTER VER: 1.0, 1.1

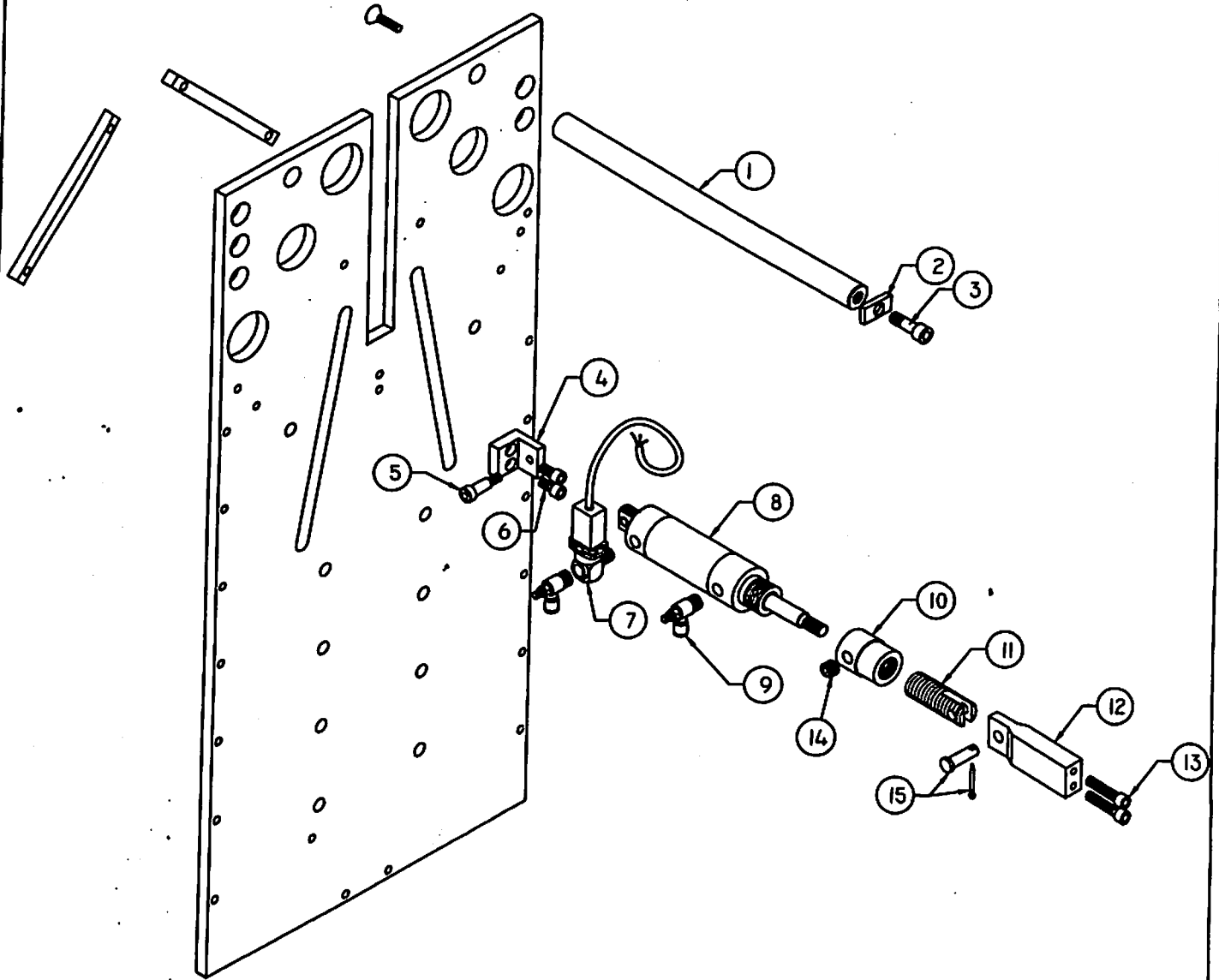
MAIN PLATE REAR VIEW



9.3

STEPMASTER VER: 1.0, 1.1

MAIN PLATE REAR VIEW

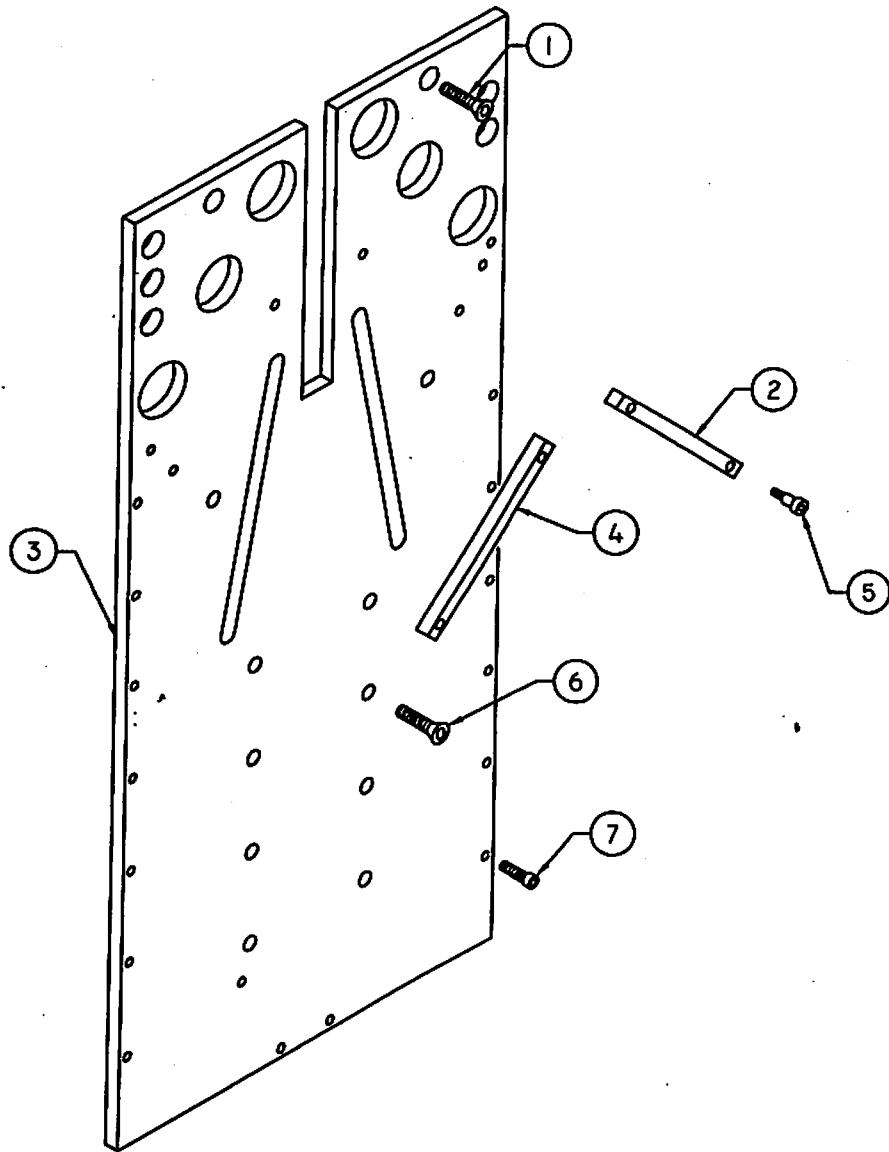


9.3

Item #	Description	Part#	Qty
1	3/8-16X1 FHCS	A2494	4
2	1/2" Right Fence	P5050	1
3	Main Plate	T6648DS	1
4	1/2" Left Fence	P5049	1
5	1/4x3/8"Shoulder Bolt	C7150	4
6	5/16-18 x 1 1/2 FHCS	A1546	6
7	1/4-20 x 1/2 SHCS	A2408	12

STEP-MASTER VER: 1.0, 1.1

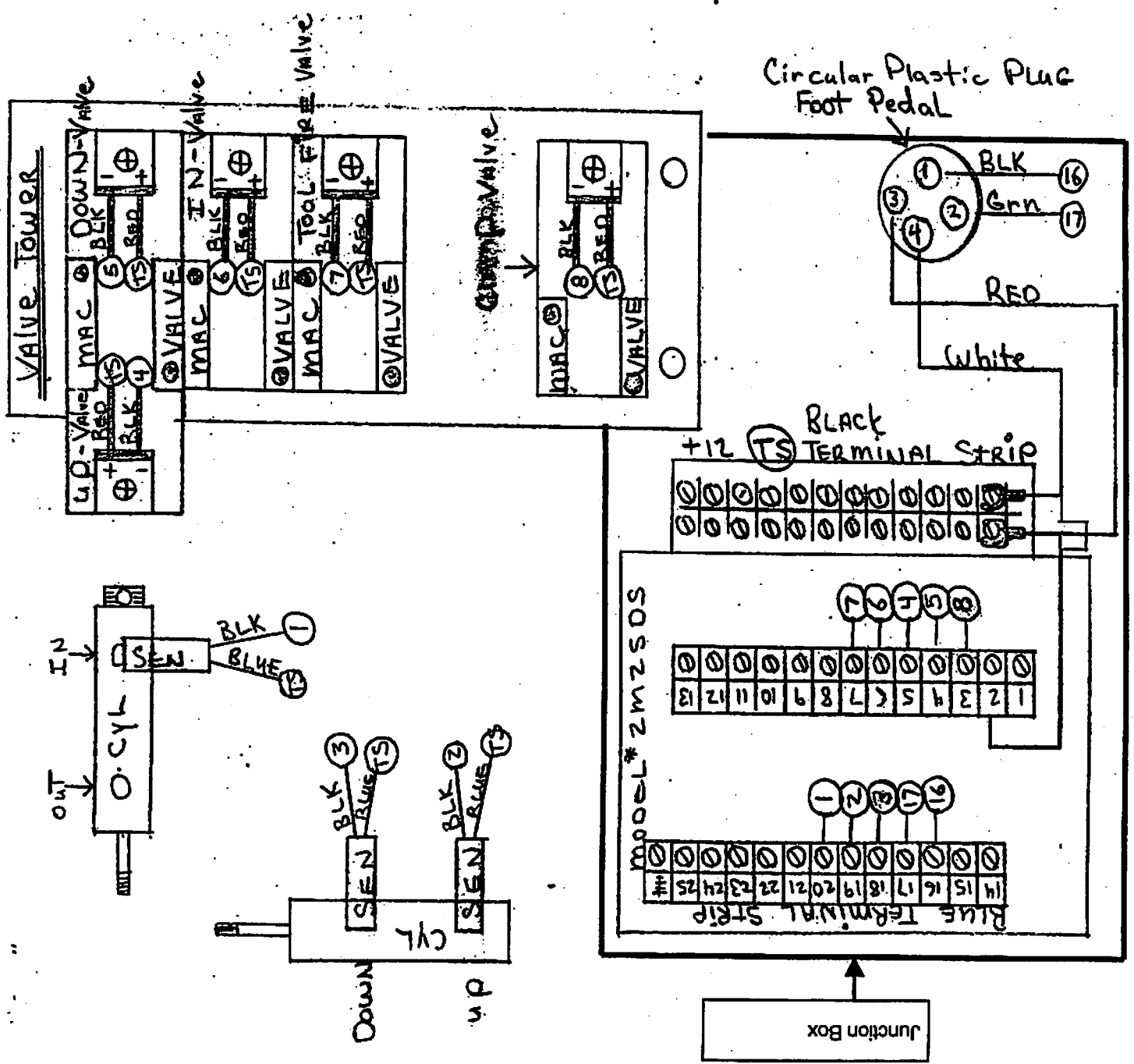
MAIN PLATE FRONT VIEW



9.1

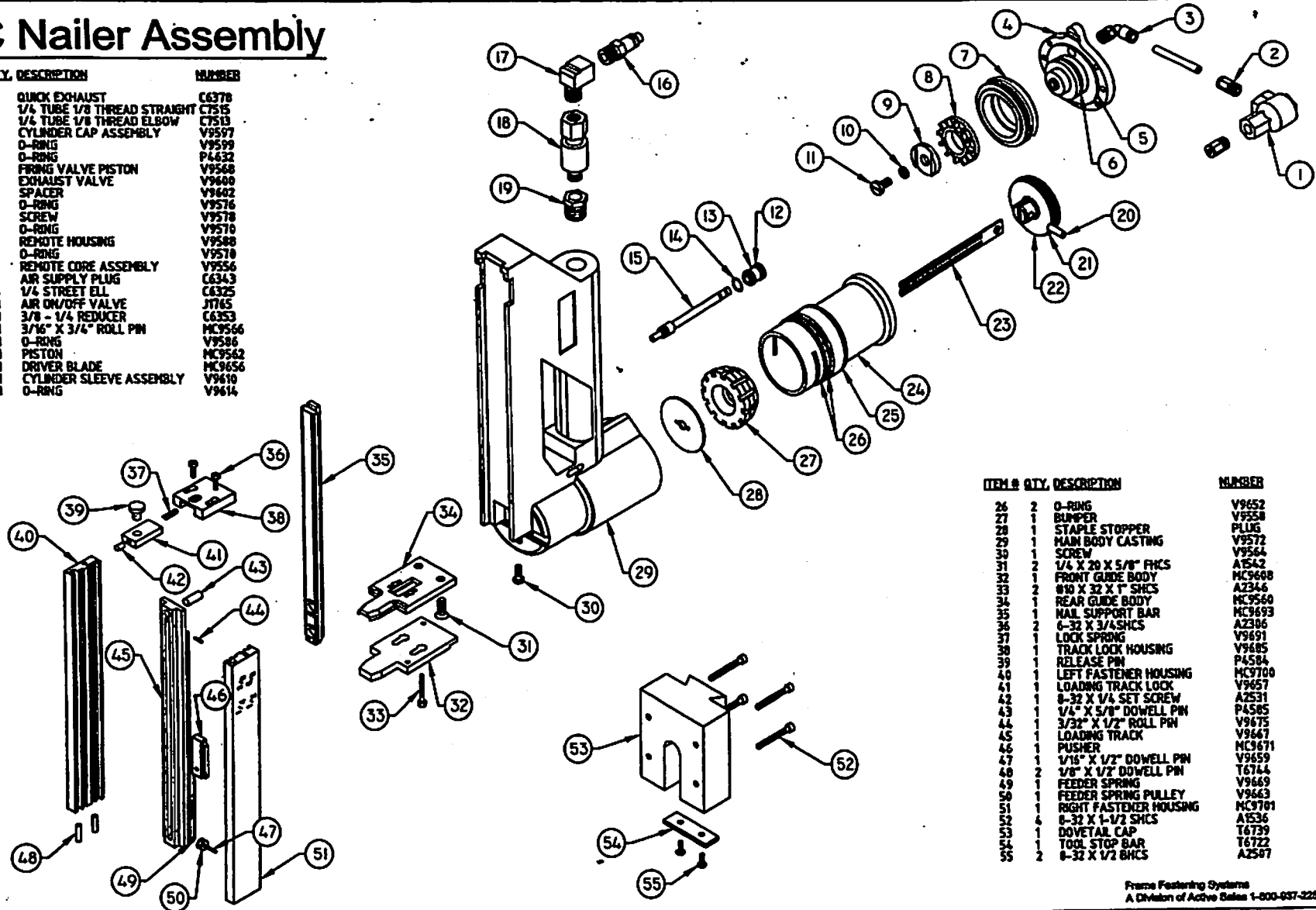
Electrical Connections

Following is an electrical connection diagram.



MC Nailer Assembly

ITEM #	QTY.	DESCRIPTION	NUMBER
1	1	QUICK EXHAUST	C6378
2	2	1/4" TUBE 1/8" THREAD STRAIGHT	C7515
3	1	1/4" TUBE 1/8" THREAD ELBOW	C7513
4	1	CYLINDER CAP ASSEMBLY	V9597
5	1	O-RING	V9599
6	1	O-RING	P4432
7	1	FIRING VALVE PISTON	V9568
8	1	EXHAUST VALVE	V9600
9	1	SPACER	V9602
10	1	O-RING	V9576
11	1	SCREW	V9578
12	1	O-RING	V9570
13	1	REMOTE HOUSING	V9588
14	1	O-RING	V9578
15	1	REMOTE CORE ASSEMBLY	V9556
16	1	AIR SUPPLY PLUG	C6343
17	1	1/4" STREET ELL	C6325
18	1	AIR ON/OFF VALVE	J1765
19	1	3/8" - 1/4" REDUCER	C6353
20	1	3/16" X 3/4" ROLL PIN	MC9566
21	1	O-RING	V9586
22	1	PISTON	MC9562
23	1	DRIVER BLADE	MC9556
24	1	CYLINDER SLEEVE ASSEMBLY	V9610
25	1	O-RING	V9614



ITEM #	QTY.	DESCRIPTION	NUMBER
26	2	O-RING	V9652
27	1	BUMPER	V9558
28	1	STAPLE STOPPER	PLUG
29	1	MAIN BODY CASTING	V9572
30	1	SCREW	V9564
31	2	1/4" X 20 X 5/8" FHCS	A2542
32	1	FRONT GUIDE BODY	MC9668
33	2	8/10 X 32 X 1" SHCS	AZ346
34	1	REAR GUIDE BODY	MC9560
35	1	NAIL SUPPORT BAR	MC9693
36	2	6-32 X 3/4" SHCS	AZ386
37	1	LOCK SPRING	V9691
38	1	TRACK LOCK HOUSING	V9685
39	1	RELEASE PIN	P4584
40	1	LEFT FASTENER HOUSING	MC9700
41	1	LOADING TRACK LOCK	V9657
42	1	8-32 X 1/4" SET SCREW	A2531
43	1	1/4" X 5/8" DOWELL PIN	P4585
44	1	3/32" X 1/2" ROLL PIN	V9675
45	1	LOADING TRACK	V9647
46	1	PUSHER	MC9671
47	1	1/16" X 1/2" DOWELL PIN	V9659
48	2	1/8" X 1/2" DOWELL PIN	T6744
49	1	FEEDER SPRING	V9669
50	1	FEEDER SPRING PULLEY	V9663
51	1	RIGHT FASTENER HOUSING	MC9701
52	4	6-32 X 1-1/2" SHCS	A2536
53	1	DOVETAIL CAP	T6739
54	1	TOOL STOP BAR	T6722
55	2	8-32 X 1/2" BHCS	A2507

Frame Fastening Systems
A Division of Active Sales 1-800-637-2256