



**MODEL LW 7001**

**LOCKSTITCH POCKET WELT  
MACHINE**

**PARTS AND SERVICE MANUAL**

**MACHINE SERIAL No:**

**PART NUMBER 97.6800.1.000**





## LIMITED WARRANTY ON NEW AMF REECE EQUIPMENT

### Warranty provisions:

A ninety (90) day limited service labor warranty to correct defects in installation, workmanship, or material without charge for labor. This portion of the warranty applies to machines sold as "installed" only.

A one (1) year limited material warranty on major component parts to replace materials with defects. Any new part believed defective must be returned freight prepaid to AMF Reece, Inc. for inspection. If, upon inspection, the part or material is determined to be defective, AMF Reece, Inc. will replace it without charge to the customer for parts or material.

Service labor warranty period shall begin on the completed installation date. Material warranty shall begin on the date the equipment is shipped from AMF Reece, Inc.

### Exclusions:

Excluded from both service labor warranty and material warranty are: (1) Consumable parts which would be normally considered replaceable in day-to-day operations. These include parts such as needles, knives, loopers and spreaders. (2) Normal adjustment and routine maintenance. This is the sole responsibility of the customer. (3) Cleaning and lubrication of equipment. (4) Parts found to be altered, broken or damaged due to neglect or improper installation or application. (5) Damage caused by the use of non-Genuine AMF Reece parts. (6) Shipping or delivery charges.

There is no service labor warranty for machines sold as "uninstalled".

Equipment installed without the assistance of a certified technician (either an AMF Reece Employee, a Certified Contractor, or that of an Authorized Distributor) will have the limited material warranty only. Only the defective material will be covered. Any charges associated with the use of an AMF Reece Technician or that of a Distributor to replace the defective part will be the customer's responsibility.

NO OTHER WARRANTY, EXPRESS OR IMPLIED, AS TO DESCRIPTION, QUALITY, MERCHANTABILITY, and FITNESS FOR A PARTICULAR PURPOSE, OR ANY OTHER MATTER IS GIVEN BY SELLER OR SELLER'S AGENT IN CONNECTION HEREWITH. UNDER NO CIRCUMSTANCES SHALL SELLER OR SELLER'S AGENT BE LIABLE FOR LOSS OF PROFITS OR ANY OTHER DIRECT OR INDIRECT COSTS, EXPENSES, LOSSES OR DAMAGES ARISING OUT OF DEFECTS IN OR FAILURE OF THE EQUIPMENT OR ANY PART THEREOF.

## WHAT TO DO IF THERE IS A QUESTION REGARDING WARRANTY

If a machine is purchased through an authorized AMF Reece, Inc. distributor, warranty questions should be first directed to that distributor. However, the satisfaction and goodwill of our customers are of primary concern to AMF Reece, Inc. In the event that a warranty matter is not handled to your satisfaction, please contact AMF Reece office:

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Tovární 837/9c  
798 11 Prostejov  
Czech Republic  
e-mail: [info@amfreece-cars.cz](mailto:info@amfreece-cars.cz)



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## **A - INTRODUCTION**

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### **1. INSTRUCTIONS**

- This machine has been produced in accordance with European Union directives mentioned on Compliance and Manufacturer's Declaration.
- Do not neglect to consider general laws and other rules in force — also in the country of operator — as well as law decrees and valid environment protection directives!
- Always observe valid provisions of local professional organizations and other inspection authorities.

### **2. GENERAL SAFETY WARNINGS**

- Machine may only be used by operators and technical specialists trained accordingly!
- Safety rules and operating directions shall be read prior to operating the machine!
- Danger and safety warnings about machine shall be taken into consideration!
- Machine may only be operated in accordance with instruction and after taking protection measures with this regard; in addition, all safety rules shall be taken into consideration.
- While changing parts (for example needle, sewing foot and spool), inserting thread and leaving the premises and during maintenance of machine, main switch of the machine shall be shut down and unplugged!
- Daily maintenance may only be performed by trained individuals!
- During maintenance and repair regarding pneumatic hardware, machine shall be disconnected from pneumatic power network! Exceptions are only valid for trained specialist staff during adjustment and function control works!
- Repair and special maintenance works may only be performed by specialist personnel or trained personnel.
- Works regarding electrical installations may only be performed by qualified specialists!
- No operation may be performed on parts and hardware under tension! Exceptions are according to directives regarding EN 50110.
- Modifying the form of machine or other changes shall be made in accordance with safety instructions.

Please use spare parts provided by AMF Reece for repair work! In cases where spare parts and accessories other than provided ones are used, machine will not be guaranteed by our AMF Reece. Installation and/or use of such products may affect the formal specifications of machine in some cases. No responsibility is accepted due to any damage arising from non original parts.

## A - INTRODUCTION

### 3. SAFETY SYMBOLS



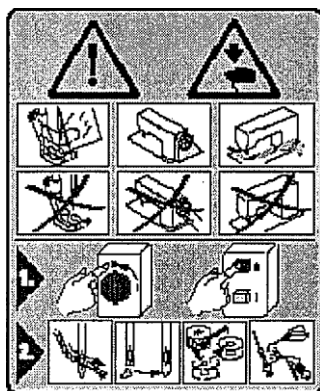
Dangerous Part!  
Points to especially pay attention!



Danger of injury for user or specialized personnel!



Dangerous part due to laser beam!



**Warning!** Do not put your hand under mechanism and do not operate without safety equipments. Switch off the main switch before inserting thread, changing reel, changing and cleaning needle and etc.

### 4. POINTS TO BE ESPECIALLY CONSIDERED BY OWNER

- This handbook is an integral part of the machine and must be easily accessible by user personnel.
- Handbook must be read before commissioning the machine for the first time.
- User staff members and specialized personnel shall be trained about protection equipments of machine and safe working methods.
- Owner shall only be obliged to completely operate the machine.
- Owner shall ensure that no safety equipment is taken away or made inoperative.
- Owner shall pay attention to employ only authorized individuals to work on the machine.
- Other detailed information is available at authorized dealer.

### 5. MAINTENANCE PERSONNEL AND SPECIALIZED PERSONNEL

- Maintenance personnel consists of individuals who are responsible from preparing the machine for use, operating and cleaning the machine.
- Maintenance personnel are obliged to observe the following points:
  - Safety measures in instructions manual shall be observed in all operations!
  - All kinds of operation modification which damage safety of machine shall be avoided!
  - Only authorized individuals shall be allowed to work on the machine!
  - Any change that may affect the safety of machine shall immediately be informed to the owner!



## A - INTRODUCTION

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### 6. SPECIALIZED PERSONNEL

- Any individual professionally trained in Electrics/Electronics and Mechanics are considered as specialized personnel. Such individuals are responsible for lubricating, maintaining, repairing and adjusting the machine.
- Specialized personnel shall be obliged to observe the following points:
- He/she observe safety measures in instructions manual for all operations!
- He/she switch off the main switch prior to adjustment and repair and shall take all safety measures against switching on of the machine!
- Operation with parts and equipments under tension shall be prohibited!
- Exceptions are regulated by EN 50110 instructions.
- Protection cover shall closed after repair and maintenance works!

### 7. PROPER USE

- This machine is intended to be used for pocket stitching production in garment industry.
- Any use unauthorized by manufacturer shall be deemed as improper use.
- Manufacturing company is not responsible from any damage which arises from improper use!
- Proper use includes use, maintenance, adjustment and repair measures defined by the manufacturer!

### 8. TECHNICAL SPECIFICATIONS

Speed	2100 min.-1
Welt Length	19 cm
Stitch Type	301
Needle System	134-35 (R)
Needle Size	80-110 Nm
Stitching Motor	See motor instructions manual
Electrical Voltage	230 V, 50 — 60 Hz alternate current
Power requirement	1,2 kW
Air pressure in operation	minimum 5.5 bar — maximum 6 bar
Air Consumption	about 5 3/times

Information about noise:

Pressure level for noise emission is 2000 minutes-1 1 stitch number at factory... LpA=74 dB (A) (noise measures according to DIN 45 635-48-A-1; ISO 11204, ISO 3744, ISO 4871)

Sizes of machine:                      Length: about: 1300 mm  
     Width: about: 1000 mm  
     Height: about: 1300 mm  
     Counter height: 850 mm

Net weight: 234 kg  
 - KpA = 2,5 dB

### 9. MEASURES TO BE TAKEN IN CASE MACHINE IS SCRAPED

Measures to be taken in case machine is scraped

- The customer shall be liable from scraping the machine properly.
- The materials used in producing the machine consist of steel, aluminum, brass and various plastics.
- Electrical installation consists of plastic and copper.
- The machine is scraped in accordance with current environment protection laws in territory and probably with the help of a privately held company.
- Lubricated parts shall be disposed in accordance with local environment protection directives.

## A - INTRODUCTION

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### 10. TRANSPORT, PACKING AND STORING

- **Transport in delivery of machine to customer**
- Transport in delivery of machine to customer is not included in manufacturer's warranty.
- Please ensure that machine is only transported in straight form.
  
- **Disposal of Packing**
- Packing of machine consists of wooden crate, paper, cardboard and nylon.
- Customer is responsible from proper disposal.

#### Storing

- Machine may stored up to 6 months when not used. Machine shall be stored away from dirt and humidity.

### 11. WORK SYMBOLS

Detailed operations or important information are emphasized with symbols herein.  
Symbols used herein shall have the following meanings:



Information



Maintenance




Maintenance, Repair, Adjustment,  
(to be performed only be specialized personnel)

## B - MACHINE INSTALLATION

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### 1. ASSEMBLING AND PREPARING FOR FIRST OPERATION

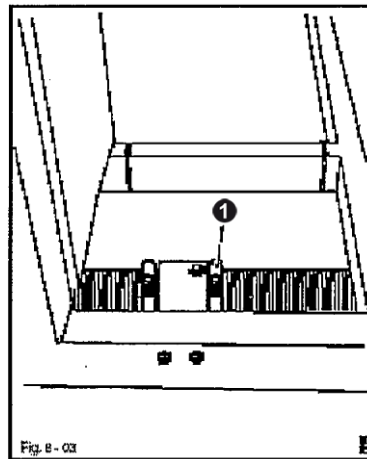
- After unpacking the machine, check if there is any damage due to transportation. Please notify transporter and AMF Reece representative of any possible damage.
-  Machine must be assembled and operated by only qualified personnel! All relevant safety regulations specified herein shall be strictly observed!

### 2. ASSEMBLY

- Please ensure that convenient electricity and supply connections for compressed air are available at the assembly place of machine (please refer to Technical Data, Section 3).
- Machine should be lifted by forklift machine from transport pallet.
- Machine shall be lifted horizontally from the ground and shall be placed in the place of assembly in a balanced manner on its four legs.

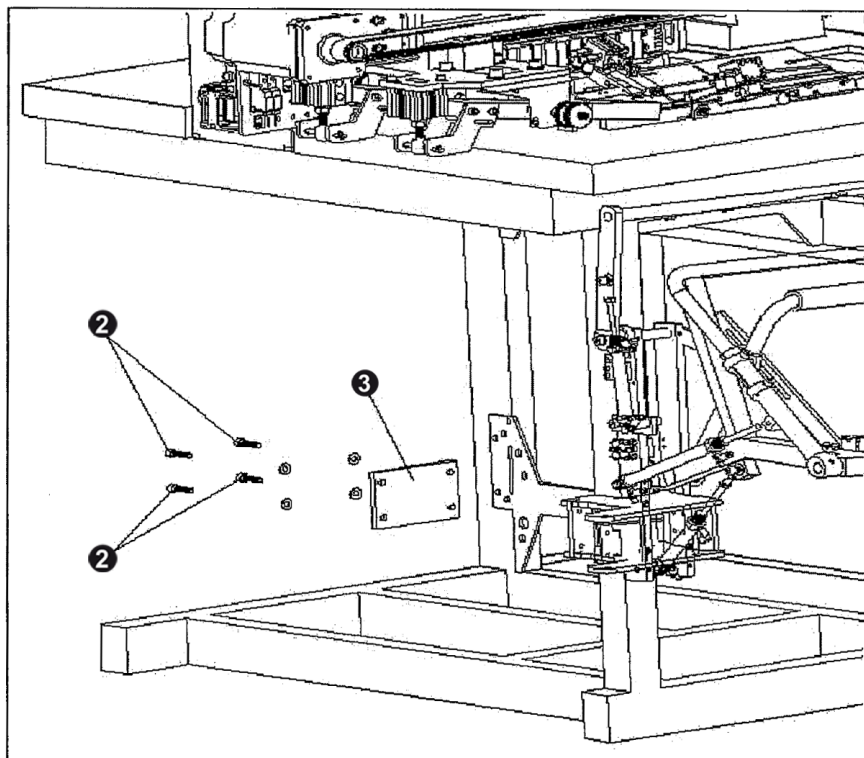
### 3. INSTALLING VACUUM (ABSORPTION) CONNECTION

Vacuum (absorption) connection is inserted into hose bearings supplied with absorption and is fixed with clamp nr. ①. (This system is available in machines requiring vacuum installation).



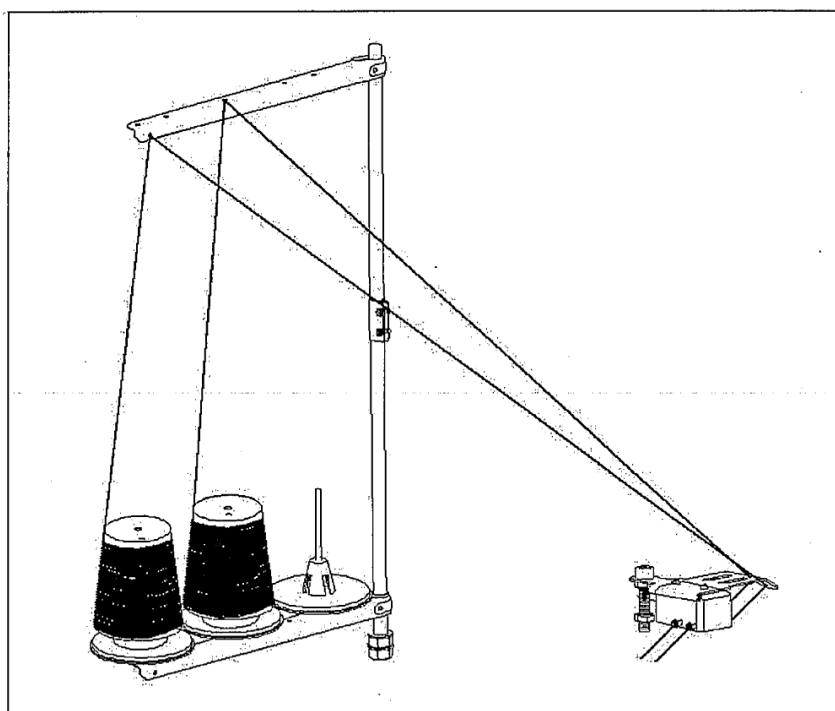
## B - MACHINE INSTALLATION

### 4. INSTALLATION OF STOWAGE MODULE



- Stowage module is connected to installation position on machine stand foot with parts numbered ③ and screw numbered ②.
- Pneumatic hoses are connected according to connection scheme.

### 5. INSTALLING SEWING THREAD PATH

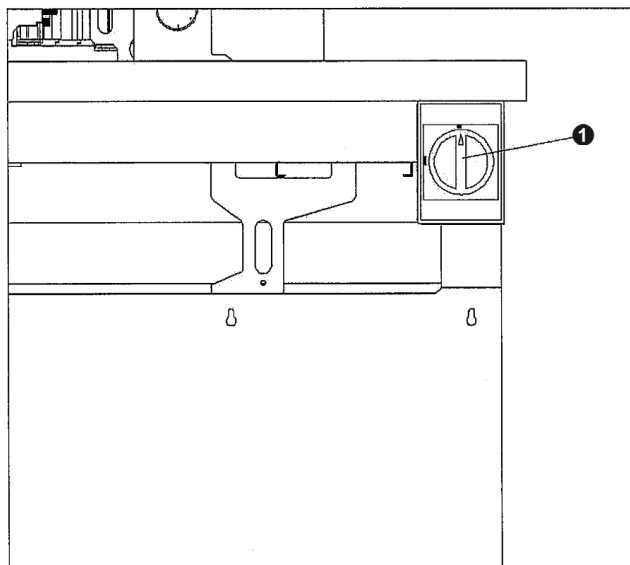


- Rod of sewing thread spool is installed as shown in the figure.
- Attach properly the thread reels to sewing thread spool.

## B - MACHINE INSTALLATION

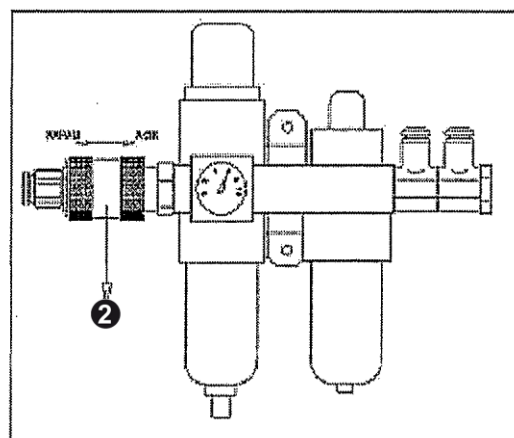
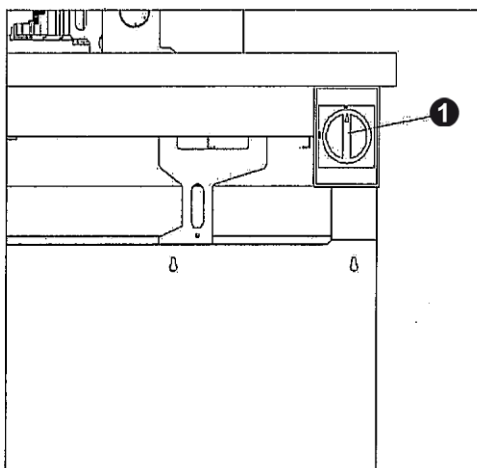
### 6. CONNECTING THE MACHINE

Switch on and off switch numbered **1**.



- Thoroughly clean the machine and check electrical cables and pneumatic hose connections for any damage.
- Check if current voltage is the same with the connection voltage of machine (see Machine Technical Specifications)
- Do not operate the machine in case of any conflict
- Allow only specialists to connect the machine to electricity network
- Lubricate the machine or put oil into machine (see Section F - Machine Cleaning and Lubricating)
- Connect machine to compressed air system
- Nanometer on machine should read 6 bars  
If necessary, adjust the value (see Related air pressure control/adjustment section)

### 7. SWITCHING ON/OFF THE MACHINE



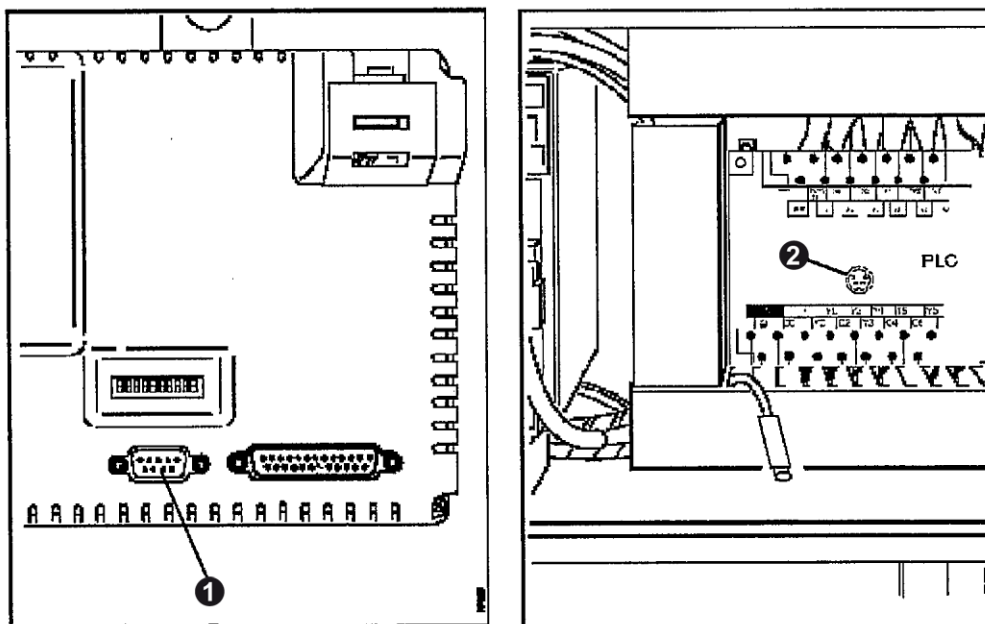
- Open main air inlet nr. **2**
- Check air pressure and adjust if necessary
- Adjust air pressure to at least 6 bars
- Turn main electrical switch of machine (as in figure nr. **1**) to position "1".
- Motor switch indicated should be in on (I position) at all times.
- Move main switch to "0" position to switch off the machine and main air inlet (figure nr. **2**) should be in off position.

## B - MACHINE INSTALLATION

### 8. PANEL CONNECTION CONTROL

- If panel cable and pic cables are not plugged in (socket nr. ① — socket nr. ②) they should be installed and screwed as below.

(One end of connection cables should be connected to COM1 socket and the other one to connection socket inside electronic control box).



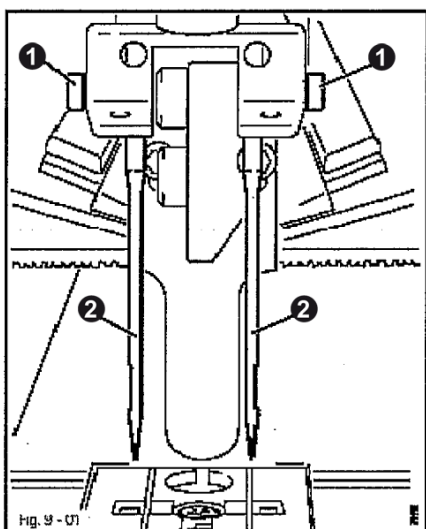
## C - CORRECT USAGE

### 1. PREPARING MACHINE FOR SEWING



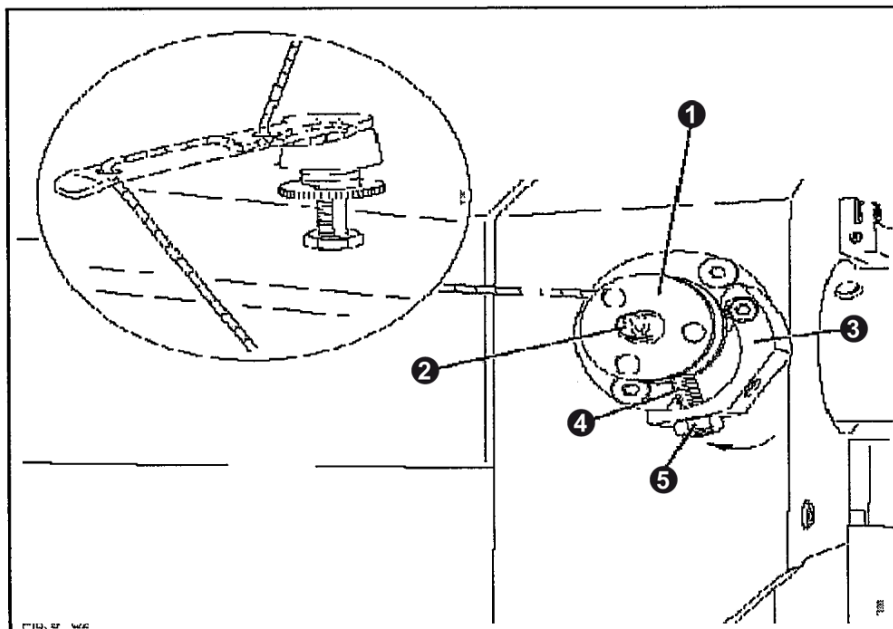
All preparation work must only be performed by authorized personnel!

### 2. INSERTING THE NEEDLE



- Shut down the machine! (Danger of injury in case of sudden operation of machine!)
- Only use 134 DP 5 system needles!
- Carrier Clamp Carriage must be placed at the back
- Loosen screw nr. ①
- Mount the part nr. ② (needle) until the lowest part in its housing.
- Groove of needles must be installed to face bobbin case.
- Properly tighten screws nr. ①.

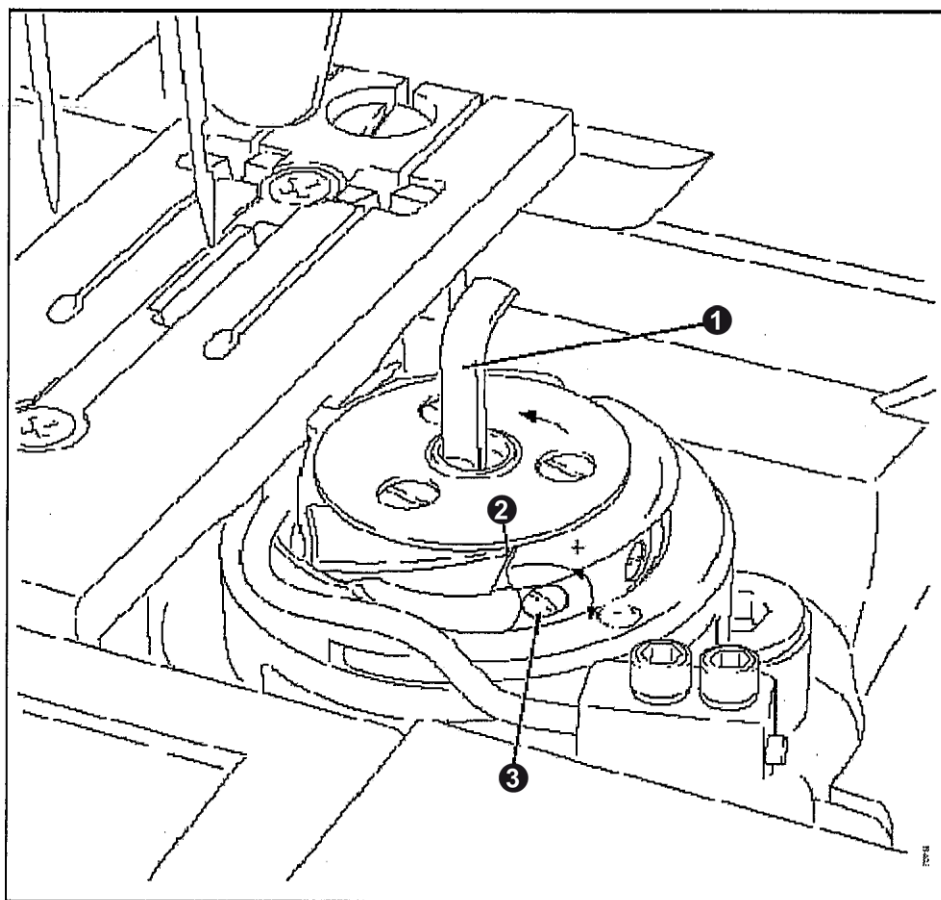
### 3. WINDING (REELS OF) LOWER THREAD/ TENSION ADJUSTMENT OF LOWER THREAD



- Insert empty bobbins (part nr. ①) into bobbin housing.
- Insert thread into thread path as shown in the magnified figure and wind clockwise for once on bobbin
- Press arm (part nr. ③) and operate the bobbin in direction of arrow.
- Bobbin (part nr. ①) is automatically filled during sewing.
- Once bobbin is sufficiently filled (part nr. ①), it automatically stops.
- Filling quantity of bobbin may be changed according to the adjustment of screw (part nr. ④) but the screw head (part nr. ⑤) must be loosened for this.
- After adjusting, screw head (part nr. ⑤) must be tightened again.

## C - CORRECT USAGE

### 4. INSTALLING BOBBIN CASE & TENSION ADJUSTMENT OF LOWER THREAD

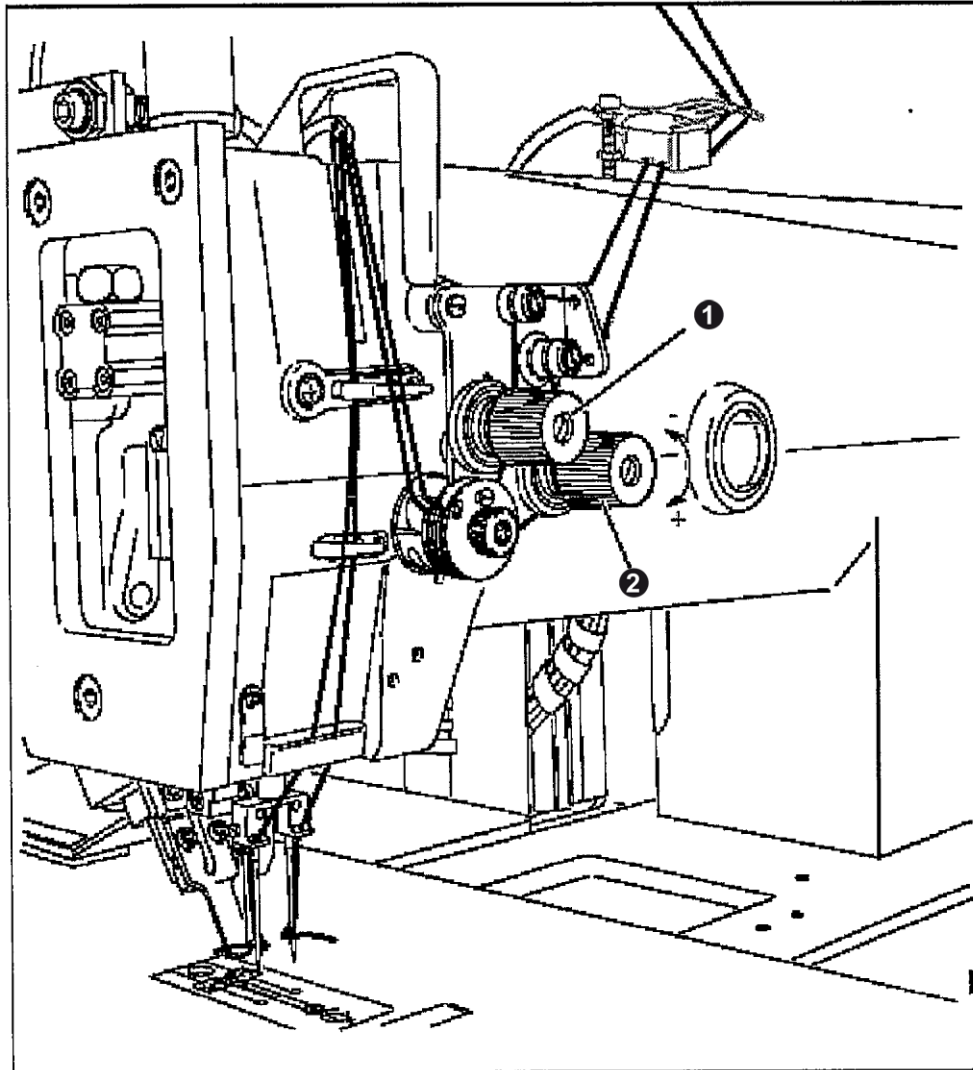


- Shut down the machine to check and replace the bobbin case.
- Pull bedplate to left and you will see the bobbin underneath.
- Lift the arm (part nr. ①) upwards and remove the empty bobbin case.
- Attach filled bobbin case to looper so that thread pulls off in the direction of arrow.
- Close the arm (part nr. ①)
- Place the thread first to groove of bobbin case capsule (place nr. ②) and the underneath the thread spring.
- Tension of lower thread is adjusted by turning the screw (screw nr. ③).
- Pull (close) bedplate sheet to left.



## C - CORRECT USAGE

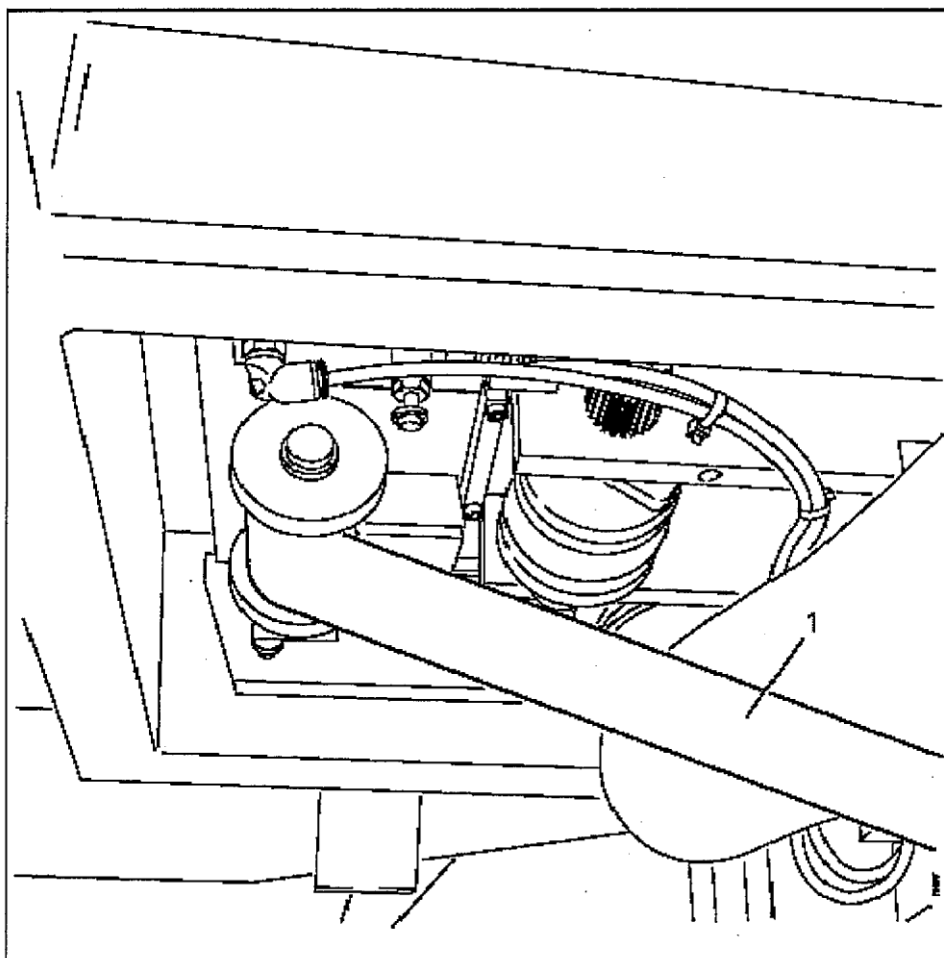
### 5. ATTACHING UPPER THREAD / TENSION ADJUSTMENT OF UPPER THREAD



- Switch of the machine.
- Push bedplate sheet to left.
- Insert completely both upper threads according to the graphic above.
- Tension of upper thread is adjusted by turning knurl screws (parts nr. ① and ②).

## C - CORRECT USAGE

### 6. REPLACING TAPE FLEECE BAND

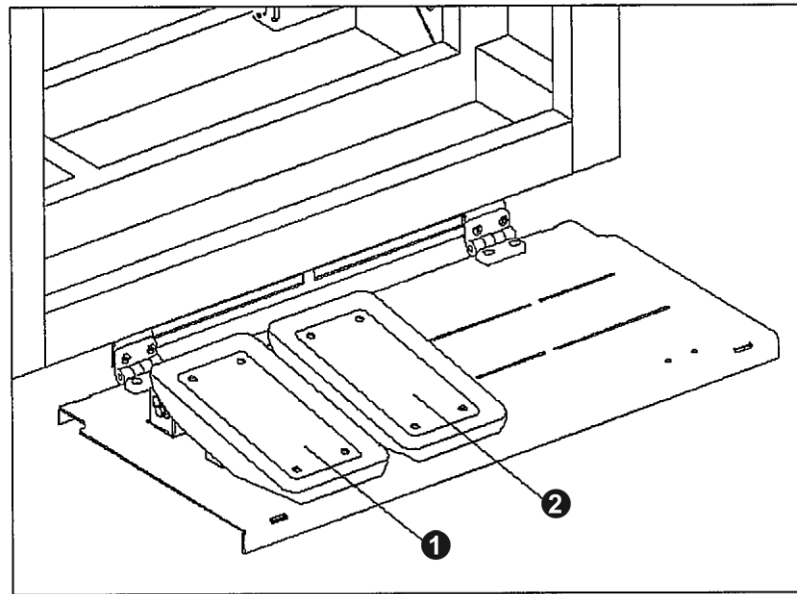


- Insert tape fleece band as shown in figure.
- Operate the machine.
- Find 'cut and drive fleece band' in any pocket program as shown in figure below:



Press the button 'drive/cut tape functions' (as shown in the figure above). Tape is driven and cut.

## C - CORRECT USAGE



### 7. FOOT PEDAL FUNCTIONS

#### Function of foot pedal nr. 1:

- Prepares the machine according to the settings and stitching program selected on panel.
- If trolley is behind, then trolley comes forward when foot pedal nr. ① is pressed on.

#### Function of foot pedal nr. 2:

- Cancels operations made with foot pedal nr. ①.
- If pedal nr. ② is pressed after starting to stitch, stitching machine immediately stops, and if pedal nr. ② is pressed again, the operation resumes.

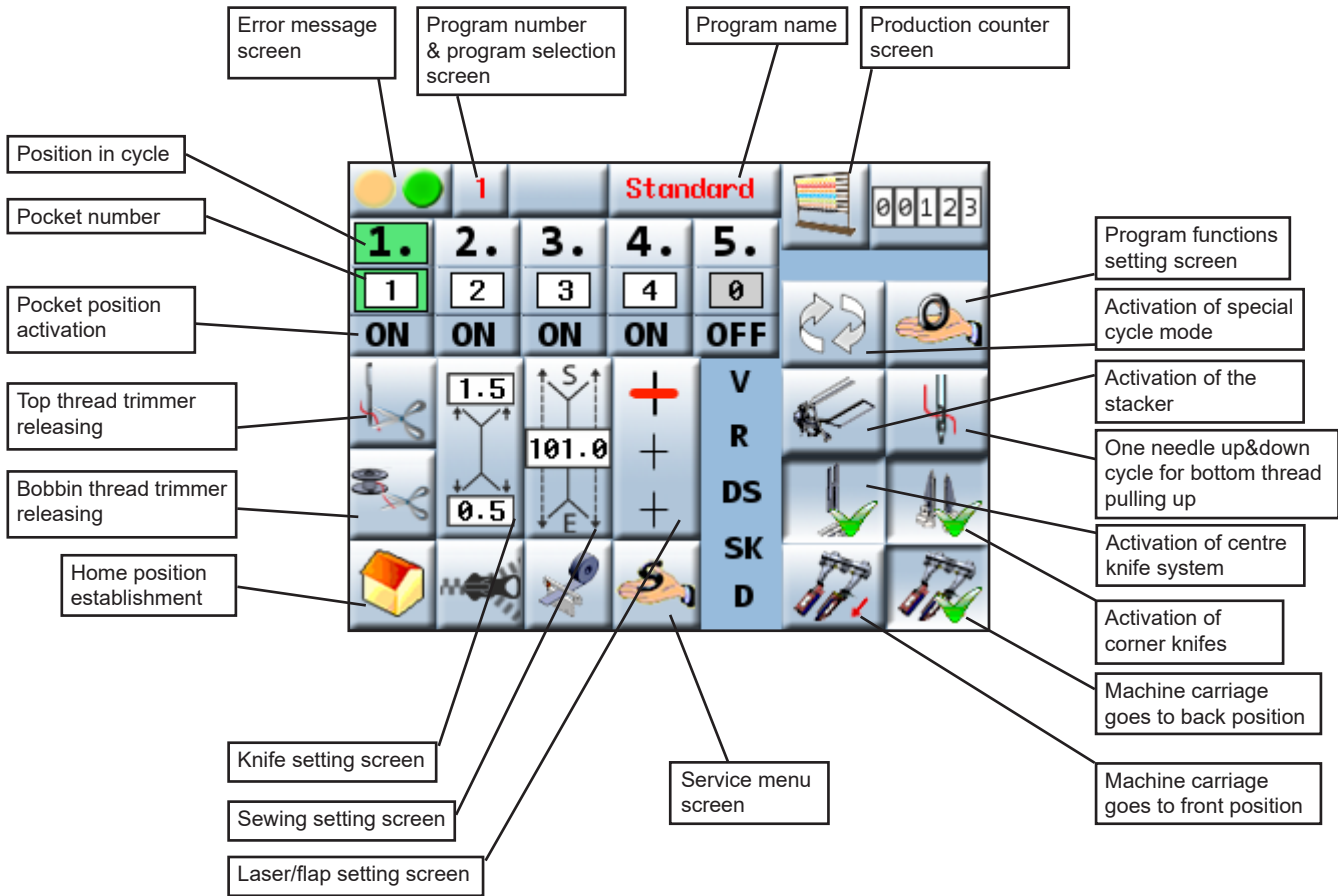
#### Operating Sequence of Foot Switch:

1. Fabric Tension rot or vacuum motor runs according to the position preferred on control indicator of machine.
2. Trolley comes from backwards to forwards.
3. Clamps (according to the position preferred on control indicator of machine: clamps automatically or first from right to left and left to right) descends downwards.
4. Front folding level lowers and folding plates run.
5. Cover holder lever runs (according to the position preferred on control indicator of machine)
6. Stitching starts.

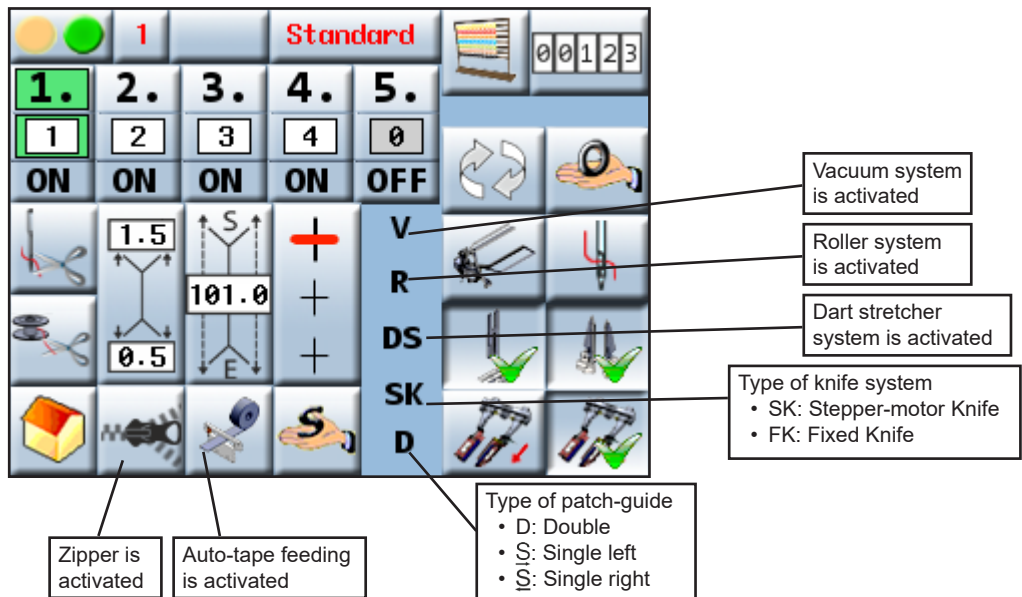
## D - MACHINE CONTROLS

### 1. MACHINE PANEL

#### 1.1. Main Screen



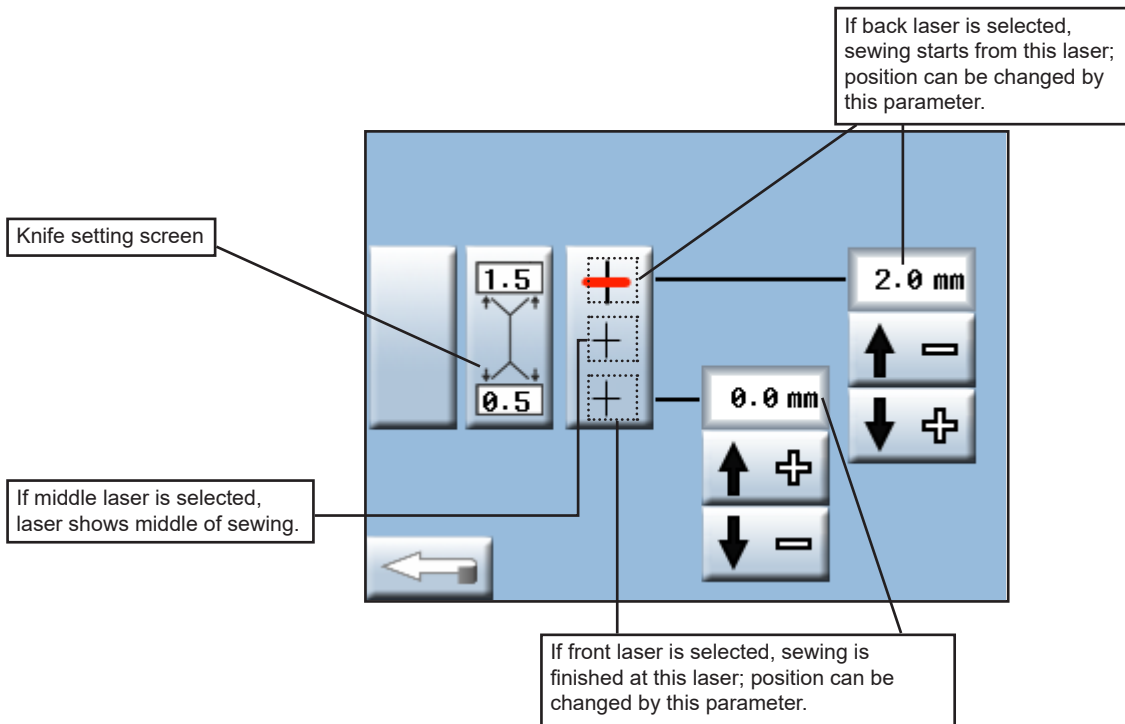
- In the standard cycle mode pockets are sewn in sequence of maximum 5 positions defined from the main screen. Each position can be separately activated/deactivated and a pocket assigned to it. Current sewn position is highlighted by red color.
- In the special cycle mode the operator is able to quickly change the pocket sewing cycle by entering a sequence of pocket numbers from 1 to 9 (e.g. for sewing of pockets 1, 5 and 9 type 159 and enter).



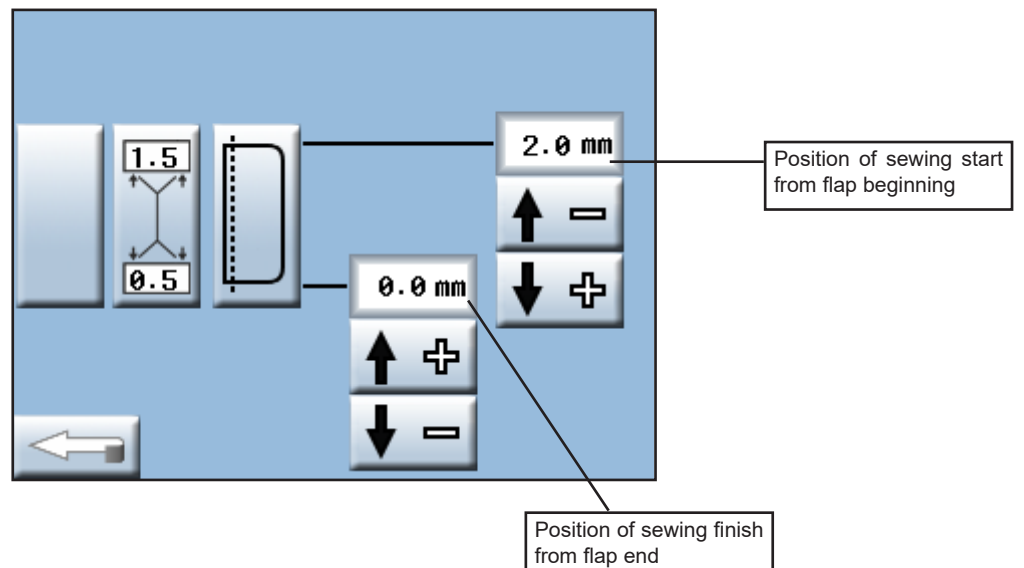
## D - MACHINE CONTROLS

### 1.2. Laser/Flap Setting Screen, Autotape Setting

#### 1.2.1. Laser material positioning (program 1-10)

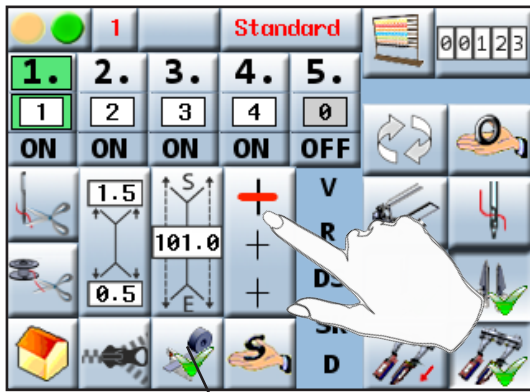


#### 1.2.2. Sewing driven by flap detection (program 11-20)

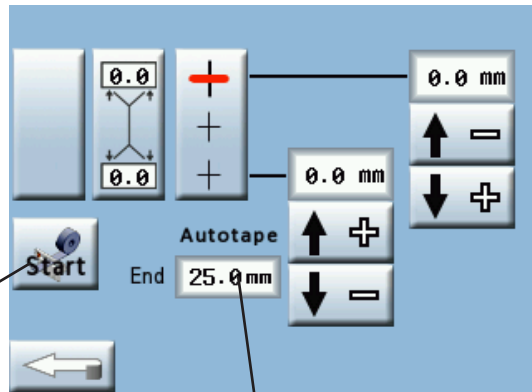


## D - MACHINE CONTROLS

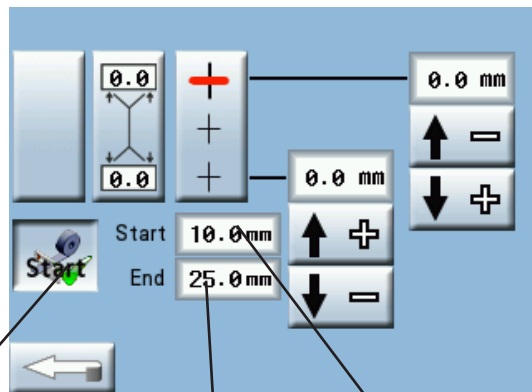
### 1.2.3. Autotape Setting



Without programmable start length of reinforcement tape. Recommended from 22 mm bite.



Programmable end of reinforcement tape.



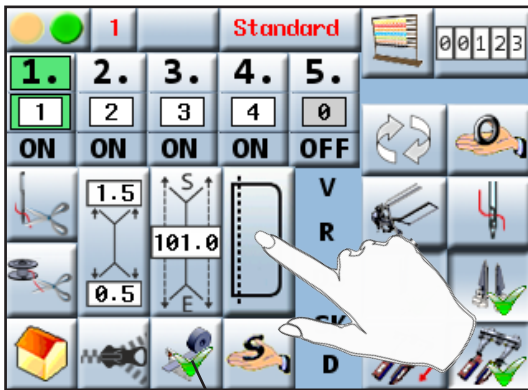
Programmable start and end of reinforcement tape. Recommended up to 20 mm bite.

Programmable end of reinforcement tape.

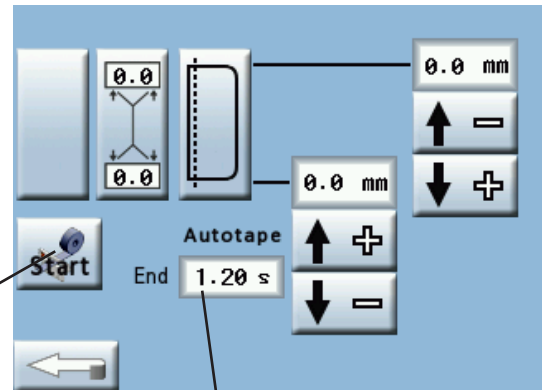
Programmable start of reinforcement tape.

## D - MACHINE CONTROLS

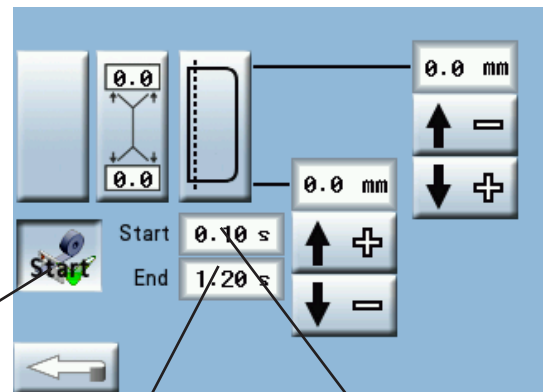
### 1.2.4. For Flap Autotape Setting



Without programmable start length of reinforcement tape. Recommended from 22 mm bite.



Programmable end of reinforcement tape.



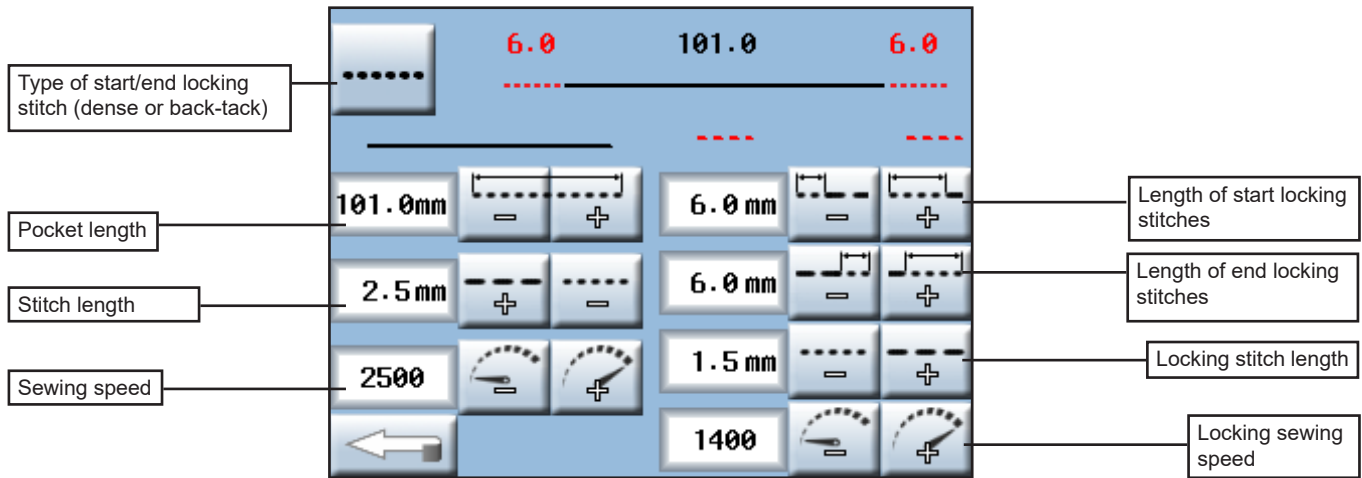
Programmable start and end of reinforcement tape. Recommended up to 20 mm bite.

Programmable end of reinforcement tape.

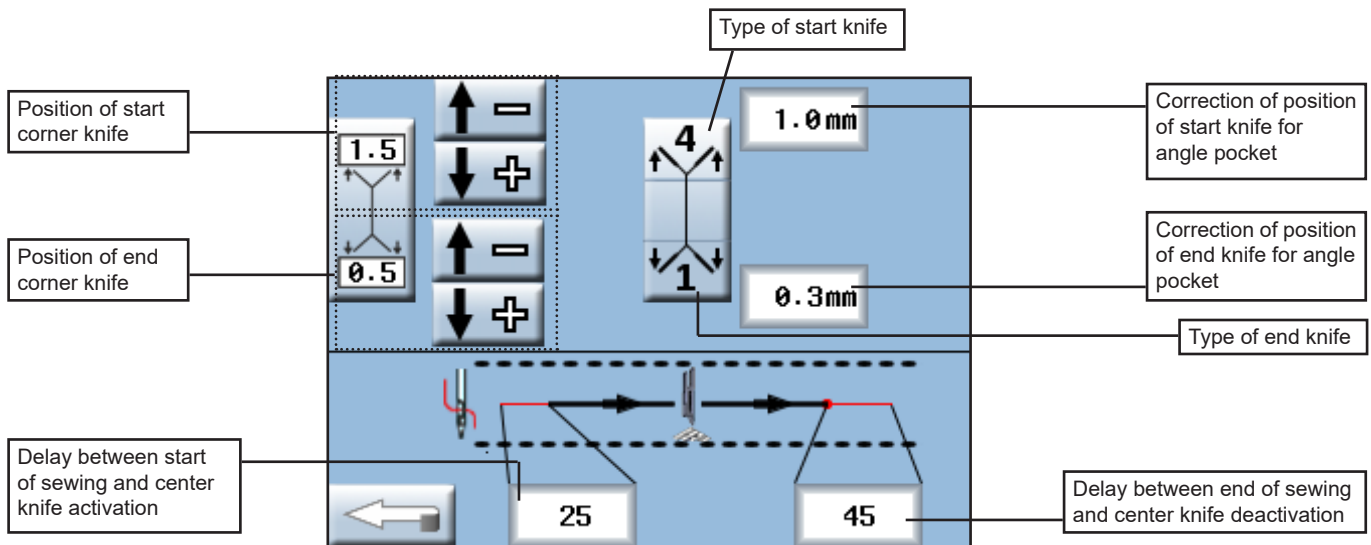
Programmable start of reinforcement tape.

## D - MACHINE CONTROLS

### 1.3. Sewing Setting Screen



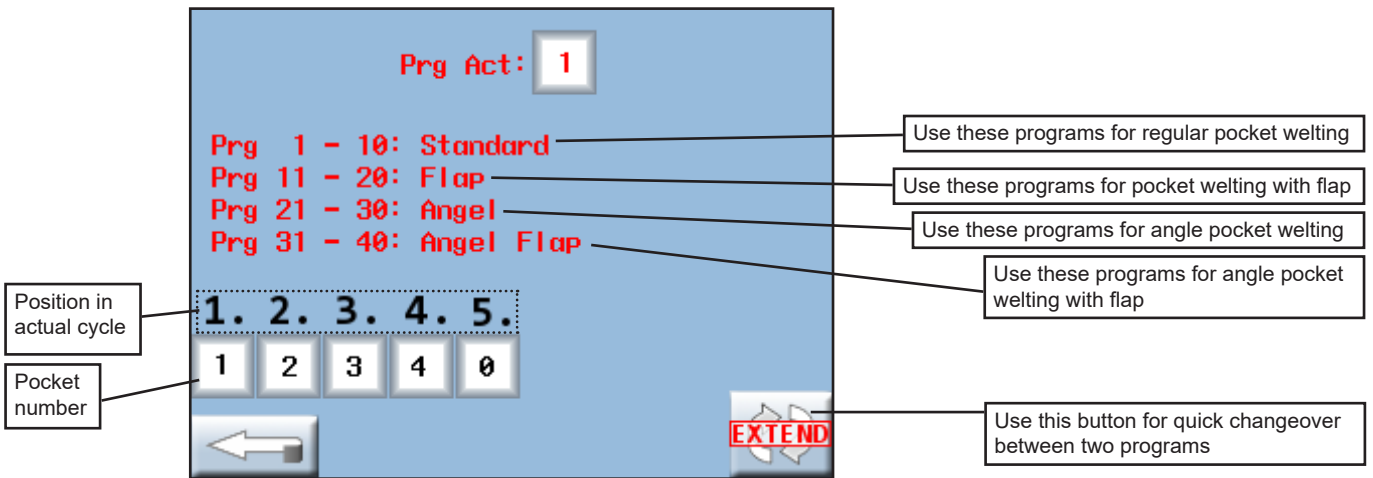
### 1.4. Knife Setting Screen



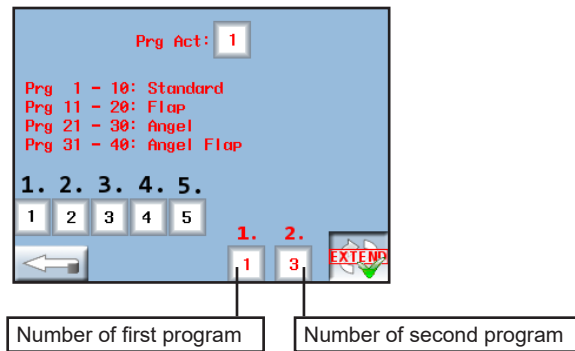


## D - MACHINE CONTROLS

### 1.5. Program Selection Screen

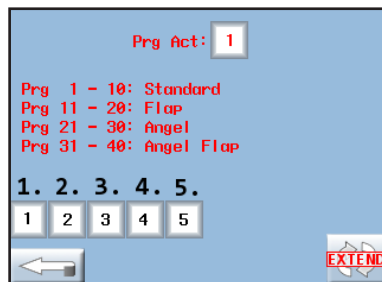


#### 1.5.1. Quick changeover between two programs

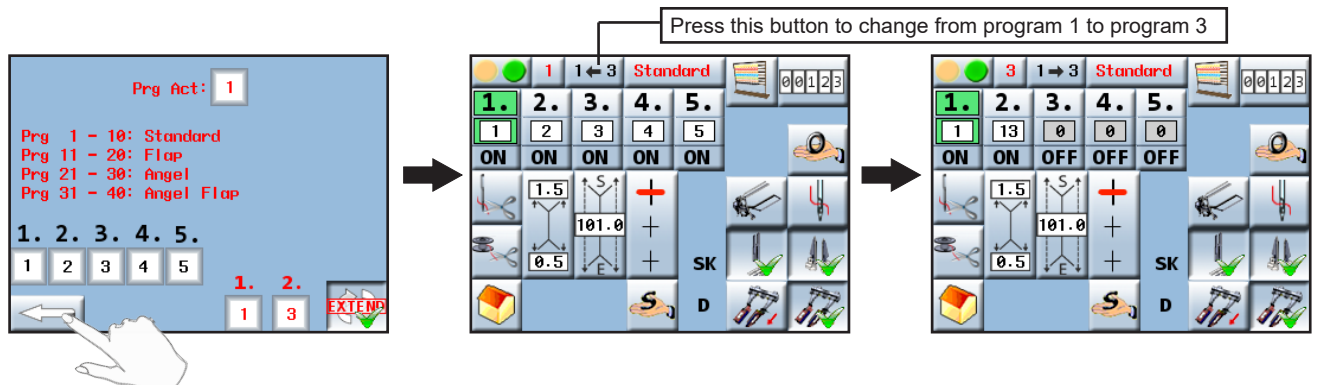
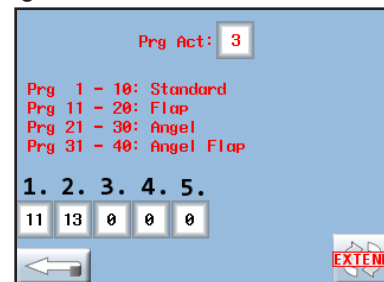


Example: Definition of quick changeover between program 1 and program 3.

Program 1

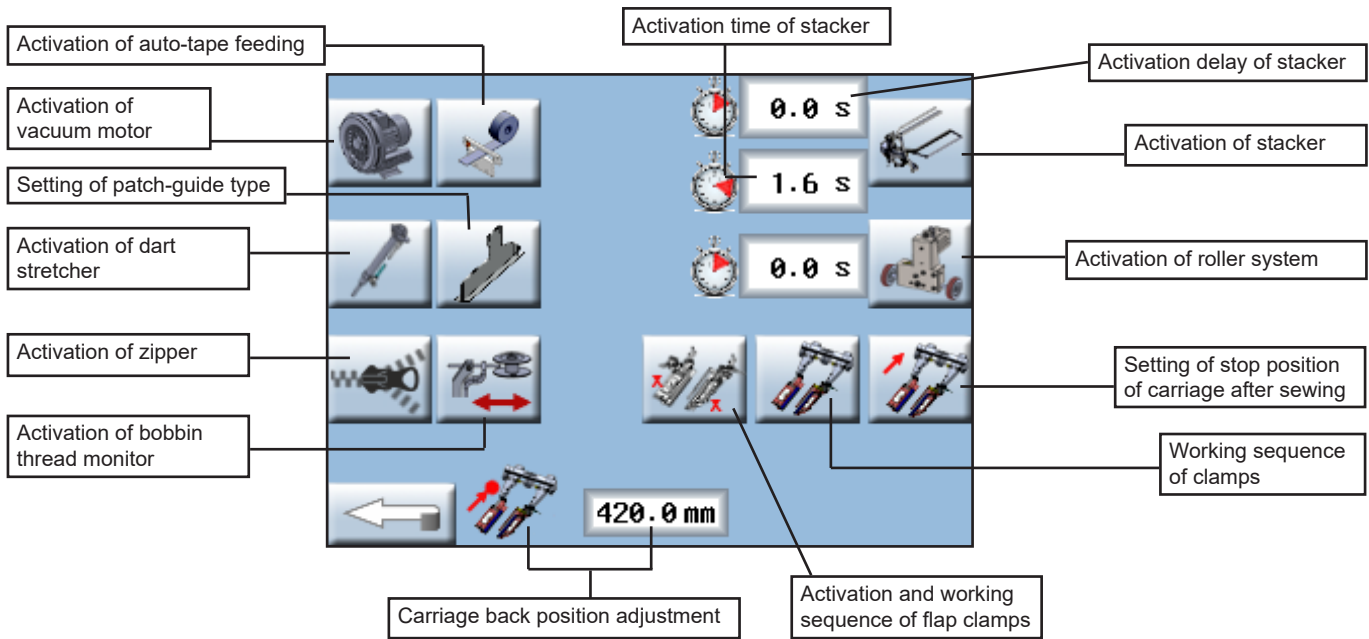


Program 3

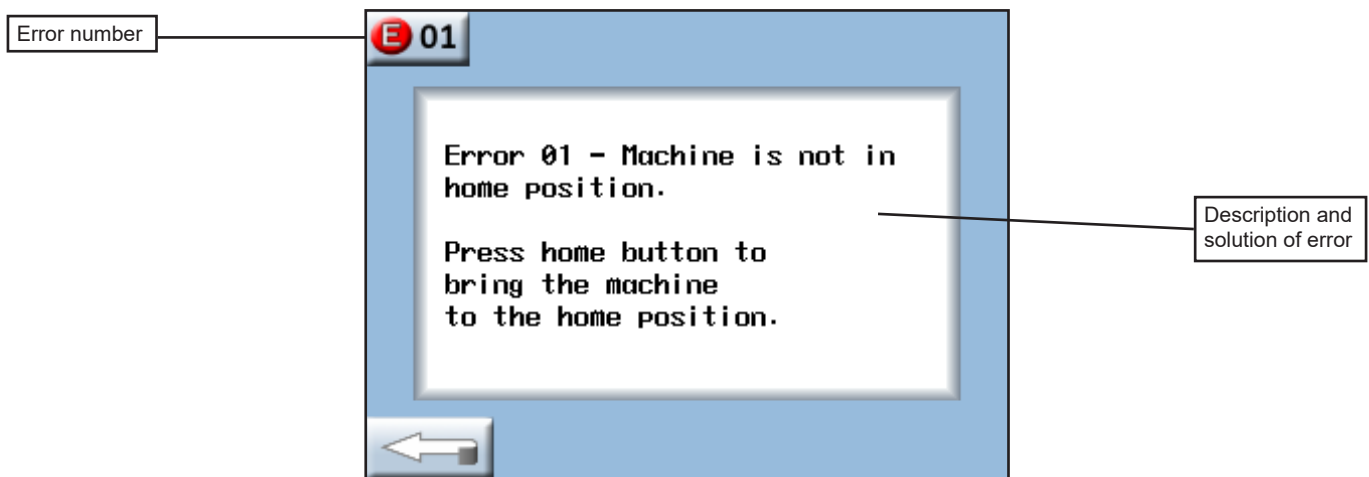


## D - MACHINE CONTROLS

### 1.6. Program Functions Setting Screen

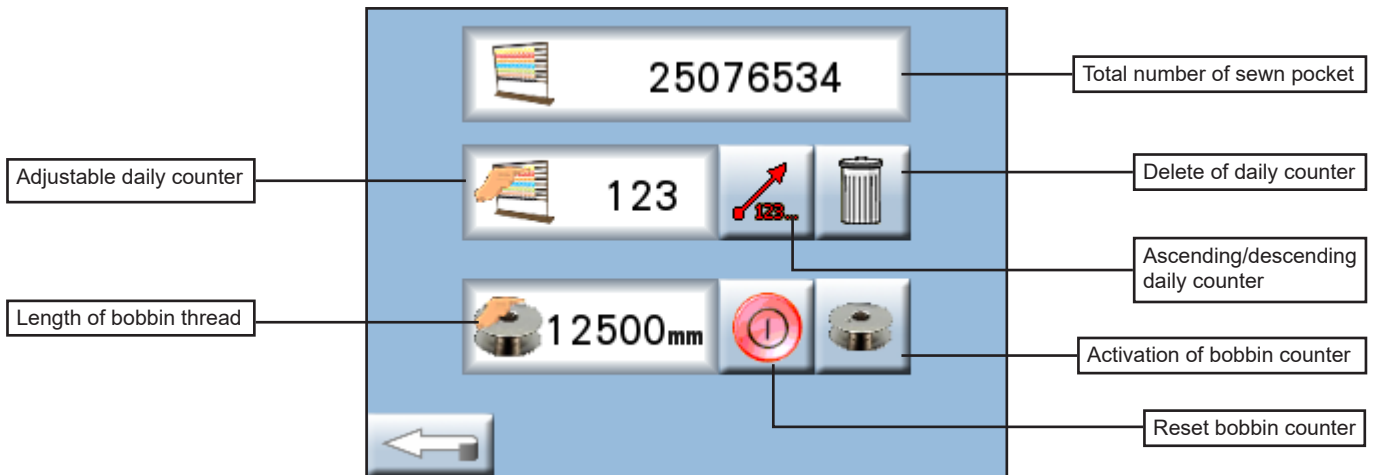


### 1.7. Error Message Screen



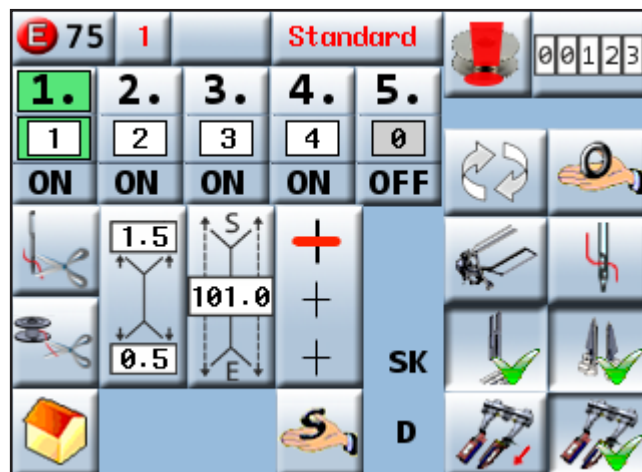
## D - MACHINE CONTROLS

### 1.8. Counter Screen



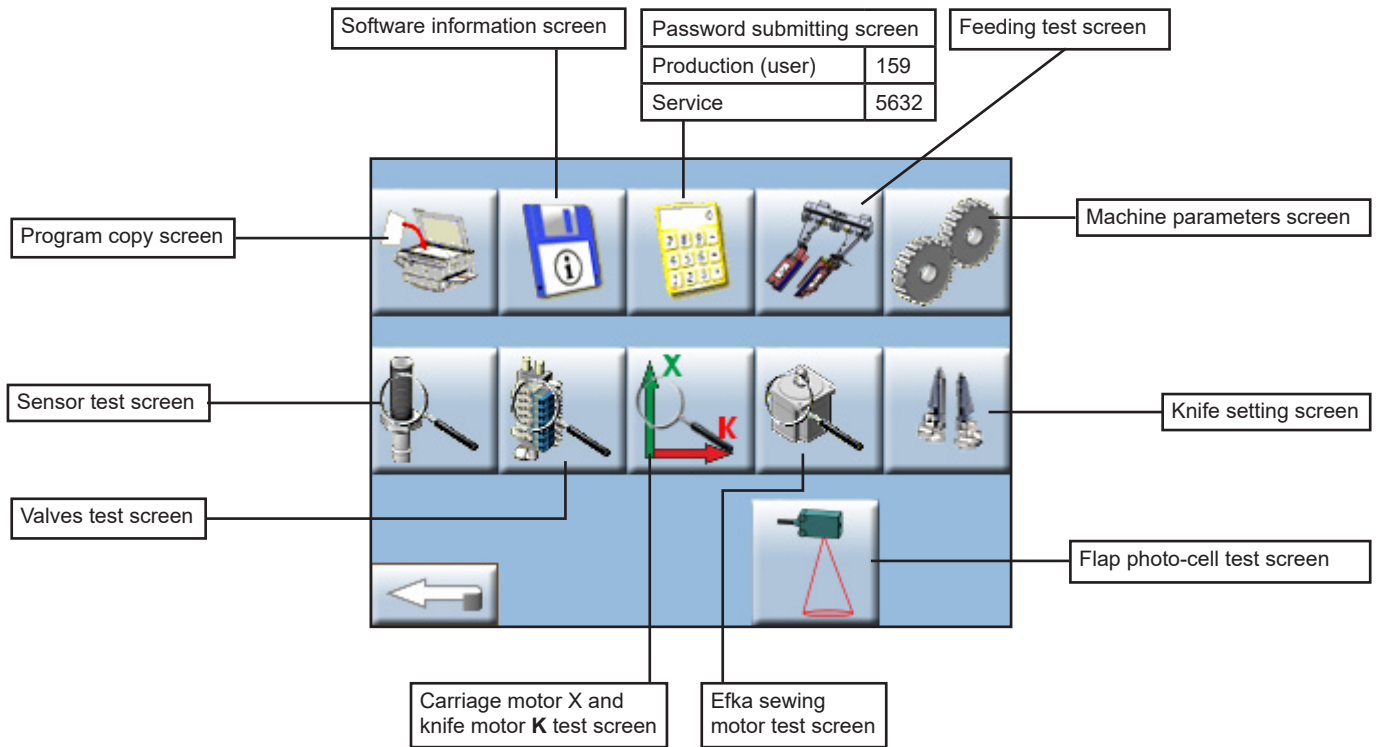
*Note:*

When pocket length is longer then rest of thread winded on to the bobbin, machine is blocked. Main screen shows error 75 and bobbin icon at main screen is flashing. To continue sewing change empty bobbin and press bobbin reset button.

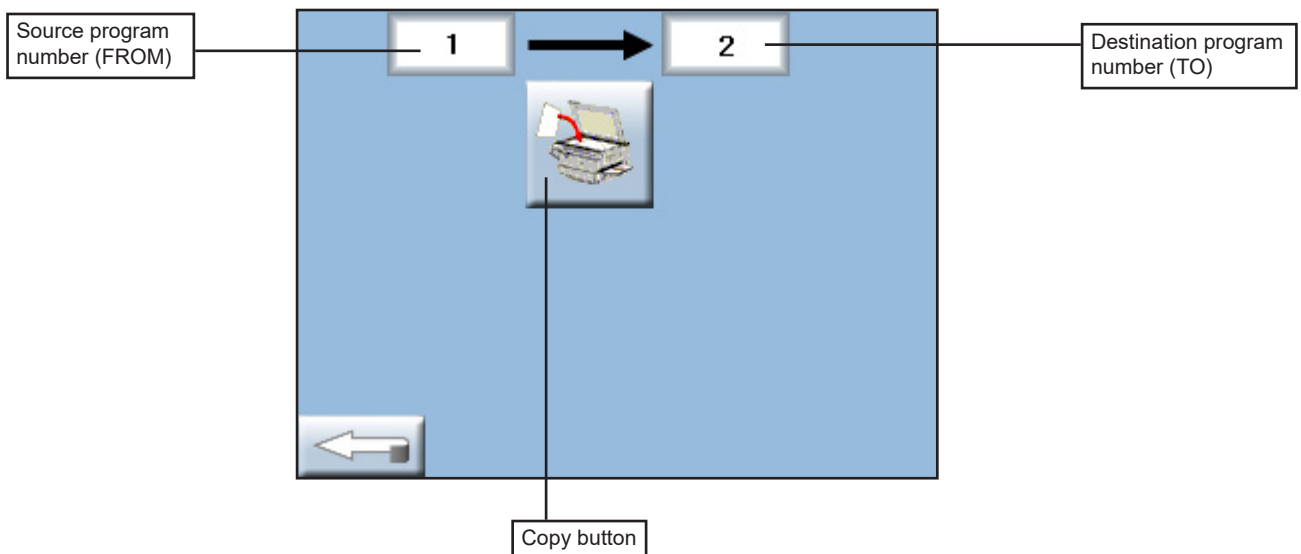


## D - MACHINE CONTROLS

### 2. SERVICE MENU SCREEN

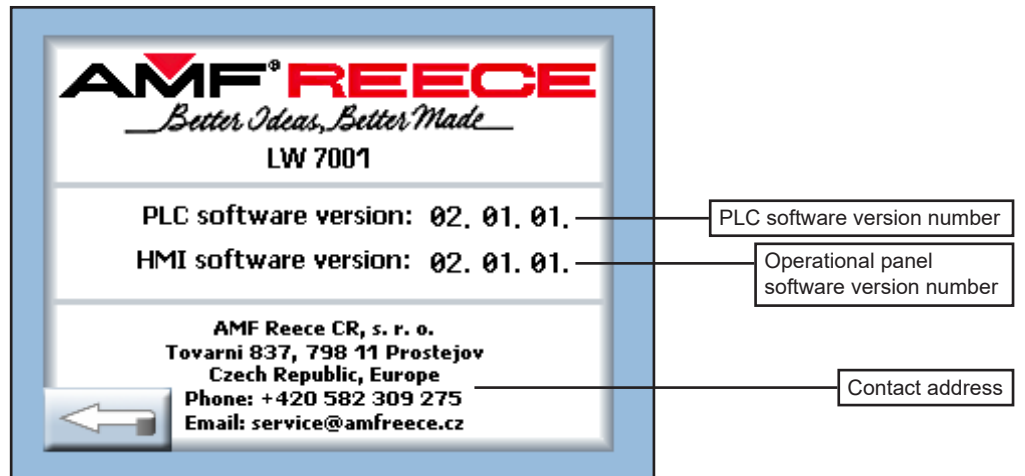


#### 2.1. Program Copy Screen

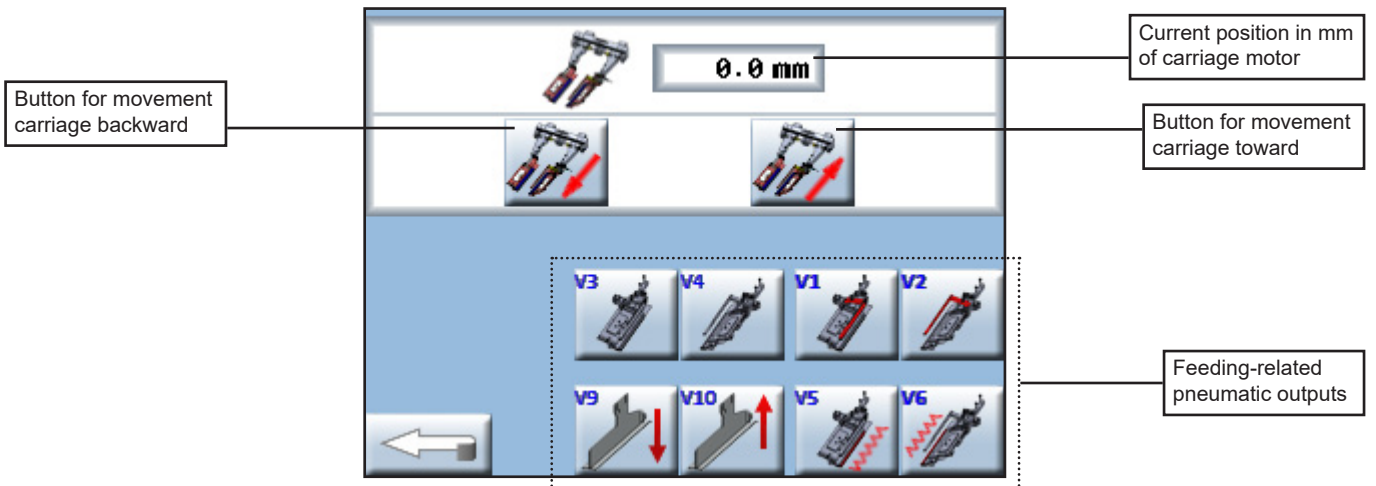


## D - MACHINE CONTROLS

### 2.2. Software Information Screen

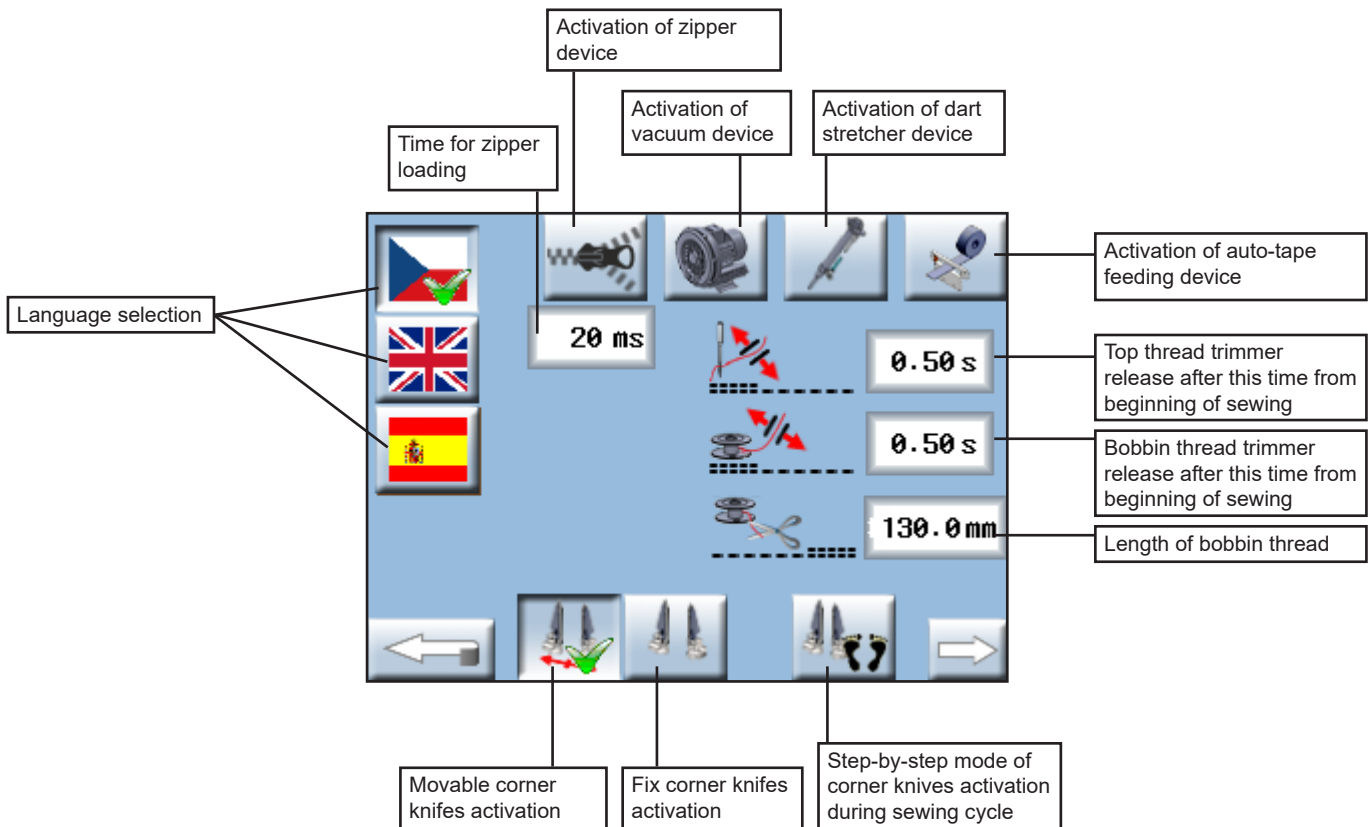


### 2.3. Feeding Test Screen

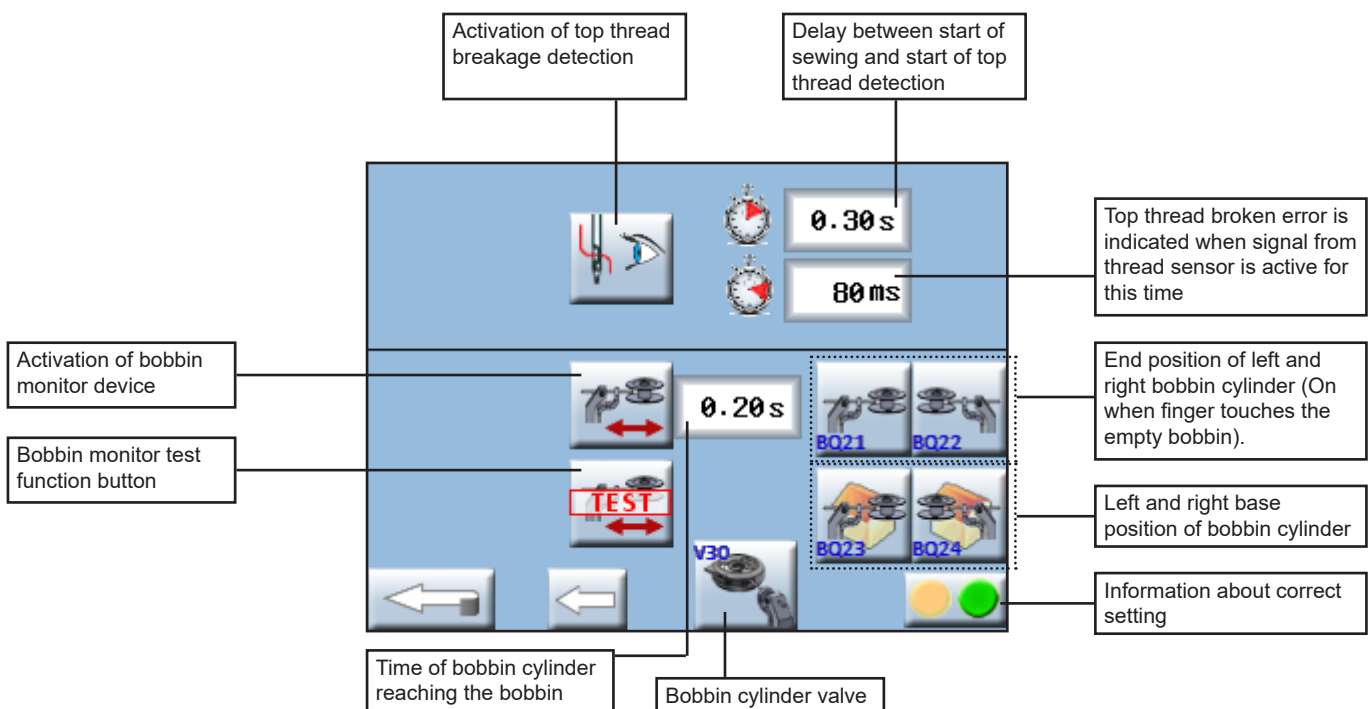


## D - MACHINE CONTROLS

### 2.4. Machine Parameters Setting I

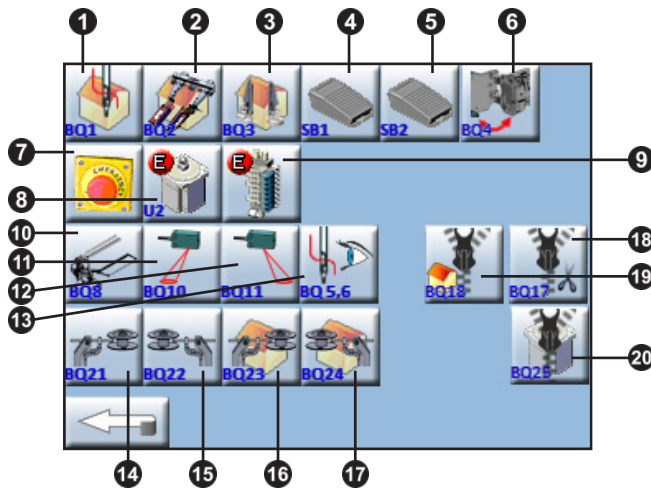


### Machine Parameters Setting II



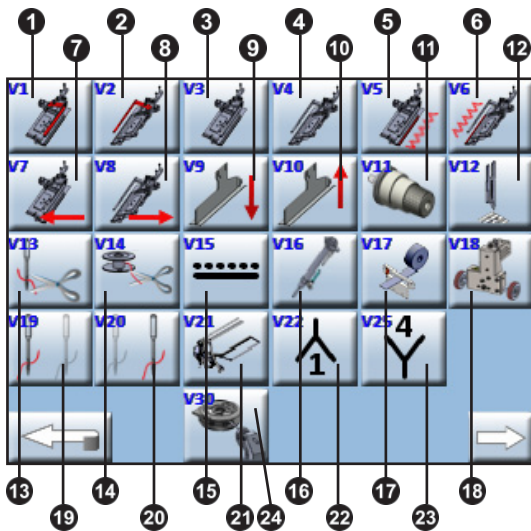
## D - MACHINE CONTROLS

### 2.5. Input Screen



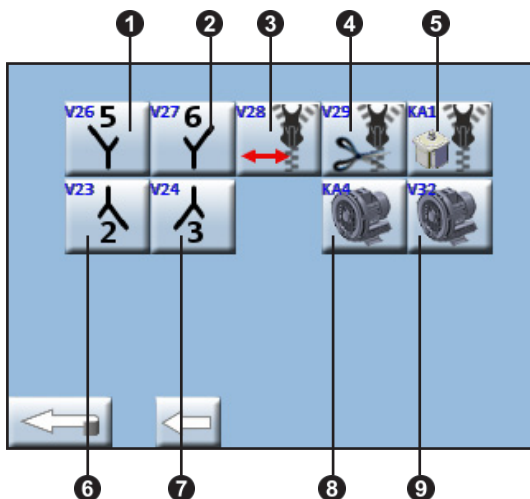
- 1 Sewing motor home-position sensor
- 2 X-Carriage motor home-position sensor
- 3 K-Knife motor home-position sensor
- 4 Left foot pedal
- 5 Right foot pedal
- 6 Cover sensor
- 7 Emergency stop button
- 8 X-Carriage motor error signal
- 9 Low air-pressure signal
- 10 Stacker photocell
- 11 Left flap photocell
- 12 Right flap photocell
- 13 Needle-thread breakage monitor
- 14 Front bobbin thread monitor
- 15 Back bobbin thread monitor
- 16 Front bobbin thread monitor - Home
- 17 Back bobbin thread monitor - Home
- 18 Zipper cut sensor
- 19 Zipper home sensor
- 20 Zipper motor switch

### 2.6. Output Screen I



- 1 Left flap clamp
- 2 Right flap clamp
- 3 Left material clamp
- 4 Right material clamp
- 5 Left folder
- 6 Right folder
- 7 Left spreader
- 8 Right spreader
- 9 Patch guide down
- 10 Patch guide up
- 11 Thread tension
- 12 Centre knife up/down
- 13 Needle thread trim
- 14 Bobbin thread trim
- 15 Dense/Back tack
- 16 Dart stretcher
- 17 Auto tape feed
- 18 Garment roller
- 19 Needle 1 (AP)
- 20 Needle 2 (AP)
- 21 Stacker
- 22 Corner knife end type 1
- 23 Corner knife start type 4
- 24 Bobbin thread monitor fingers

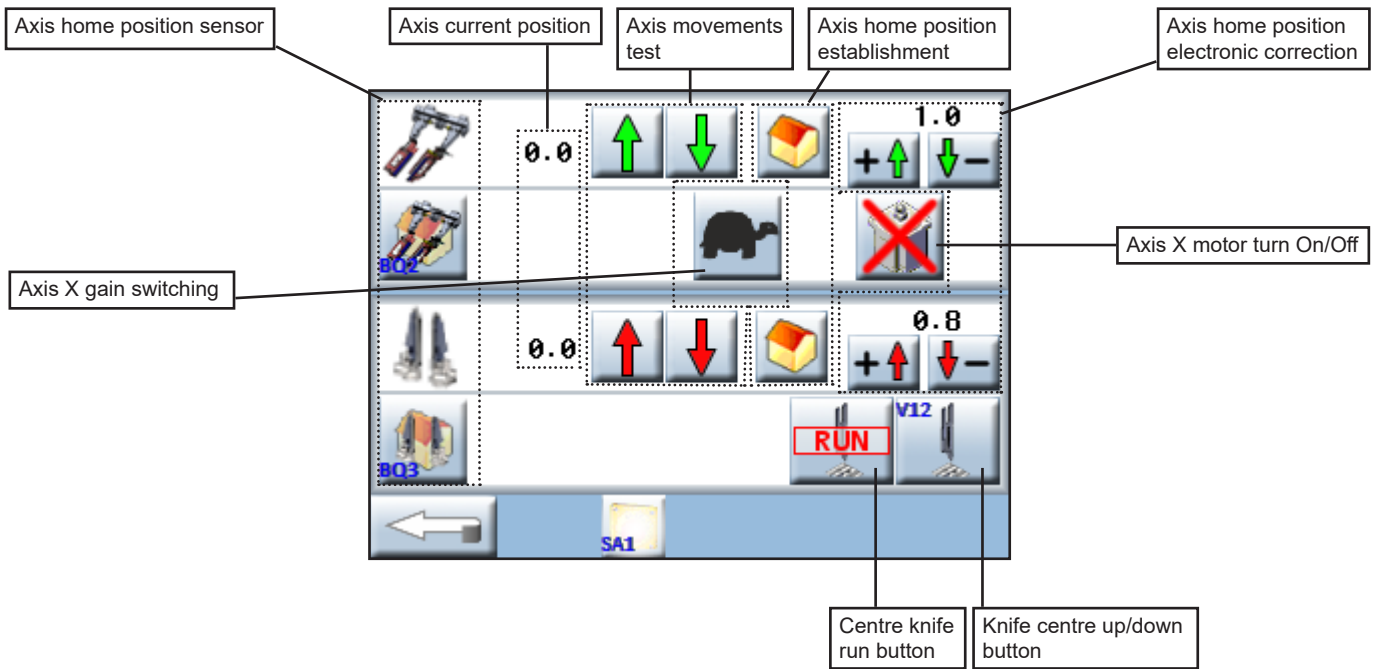
### 2.7. Output Screen II



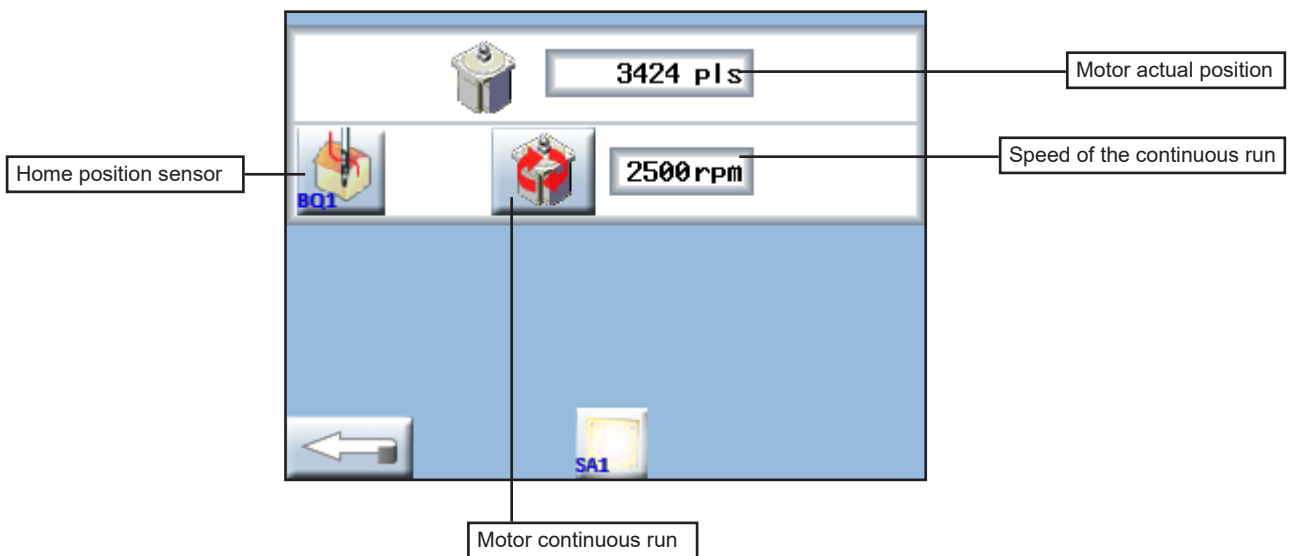
- 1 Corner knife start type 5
- 2 Corner knife start type 6
- 3 Zipper arm move
- 4 Zipper trim
- 5 Zipper motor run
- 6 Corner knife end type 2
- 7 Corner knife end type 3
- 8 Vacuum
- 9 Vacuum switch

## D - MACHINE CONTROLS

### 2.8. Carriage Motor X and Knife Motor K Test Screen



### 2.9. Efka Sewing Motor Test Screen

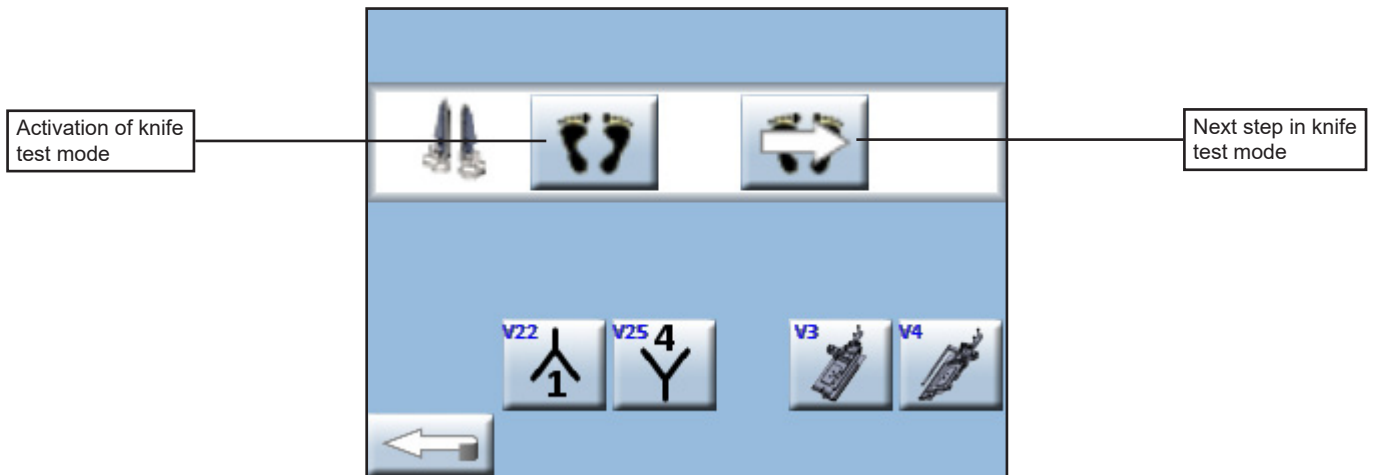




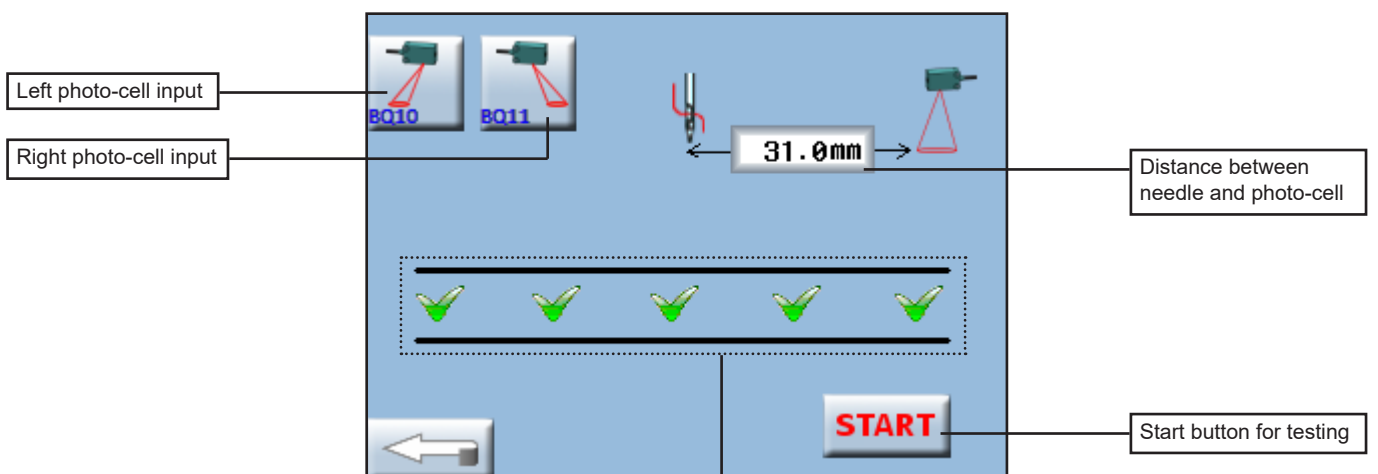
## D - MACHINE CONTROLS

### 2.10. Knife Setting Screen

Here you can check corner knives and sewing:



### 2.11. Flap Photo-Cell Testing Screen



There are 5 photo-cell checkpoints passed during the test. Green tick indicates proper detection, red cross indicates fault. If both sensor works well and reflective tape is installed properly, you will see 5 green ticks (as in the picture).

## E - STANDARD MACHINE ADJUSTMENT

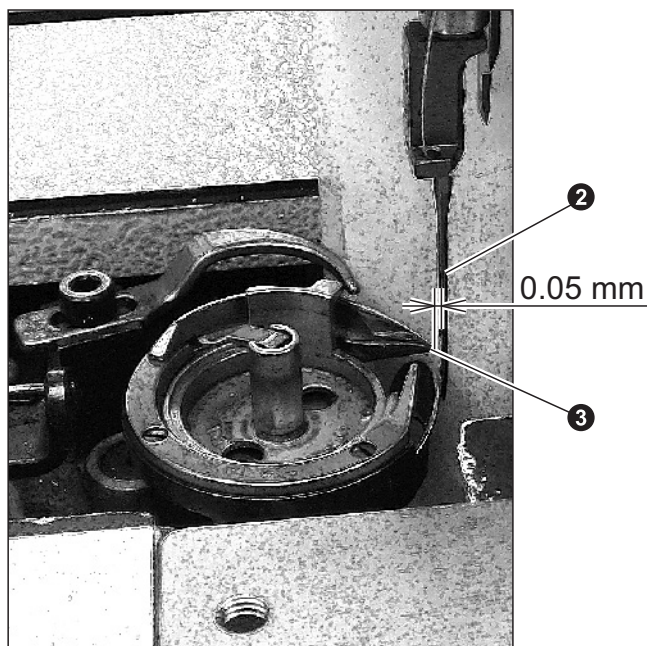
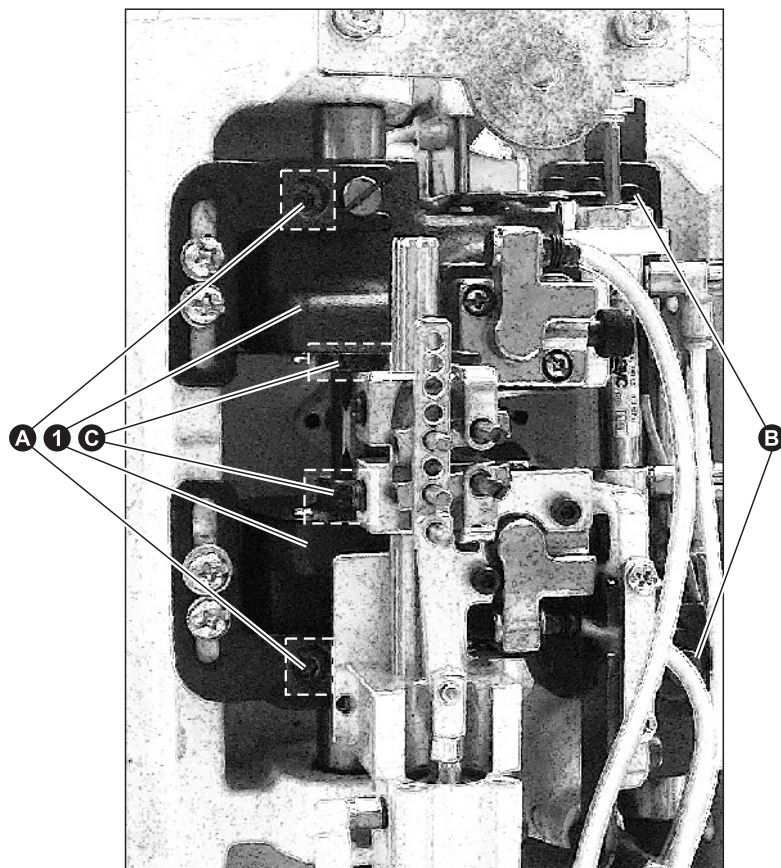
### 1. ADJUSTING THE NEEDLE AND ROTARY HOOK TIMING

#### Needle to Rotary Hook Point Gap

- 1 - Tilt back the machine head.
- 2 - Loosen screws **A**, **B** and screws on the ring **C**.
- 3 - Move the rotary hook base **1** to the left or right so that the clearance between the needle **2** and the rotary hook tip **3** is **0.05 mm**.

- 4 - After adjusting , securely tighten screws **A**, **B** and **C**.

**Note:** Tighten screws on ring **C** while gently pressing the ring.  
 Furthermore, tighten screw **C** without moving it from its screw stop.



## E - STANDARD MACHINE ADJUSTMENT

### 2. ADJUSTING THE THREAD TAKE-UP SPRING

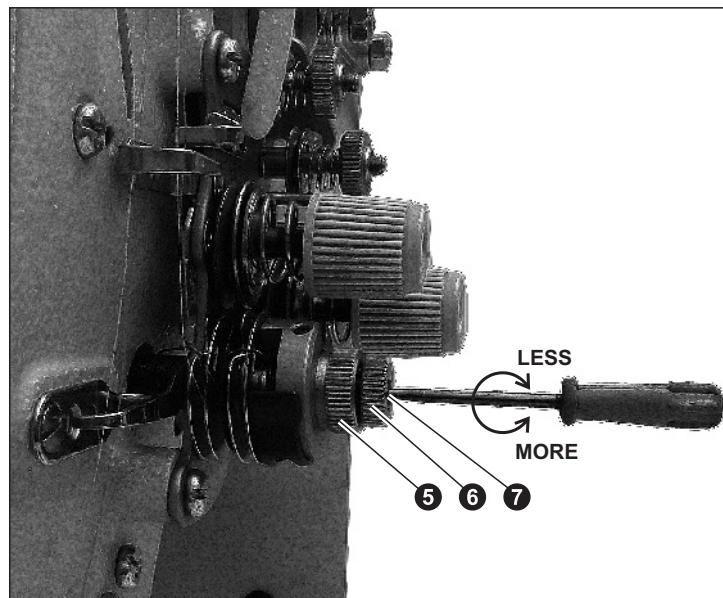
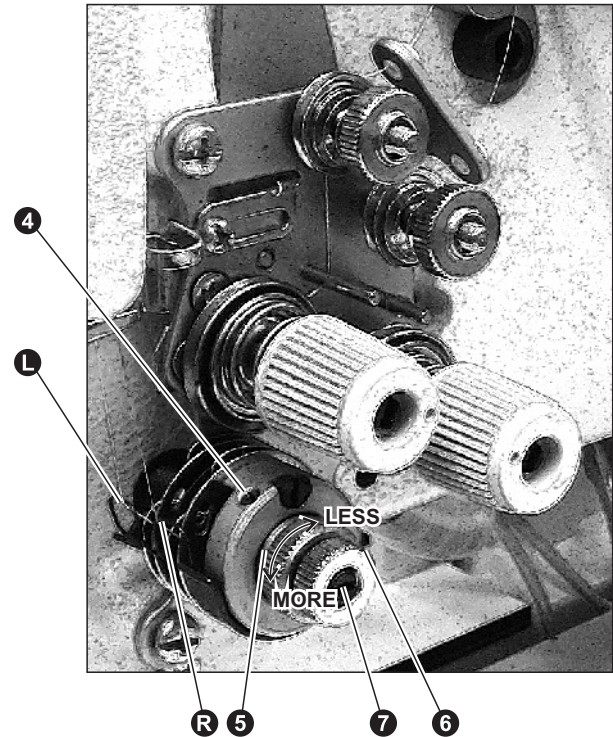
The standard tension for thread take-up spring **L** and thread take-up spring **R** is **0.15 — 0.35 N** for both springs.

#### <Thread take-up spring **L**>

- 1 - Open the face plate.
- 2 - Loosen the screw **4**.
- 3 - Turn the thread tension stud **5** to adjust the tension.
- 4 - Tighten the screw **4**.

#### <Thread take-up spring **R**>

- 1 - Loosen the knob **6**.
- 2 - Turn the adjustment knob **7** to adjust the tension.
- 3 - Tighten the knob **6**.



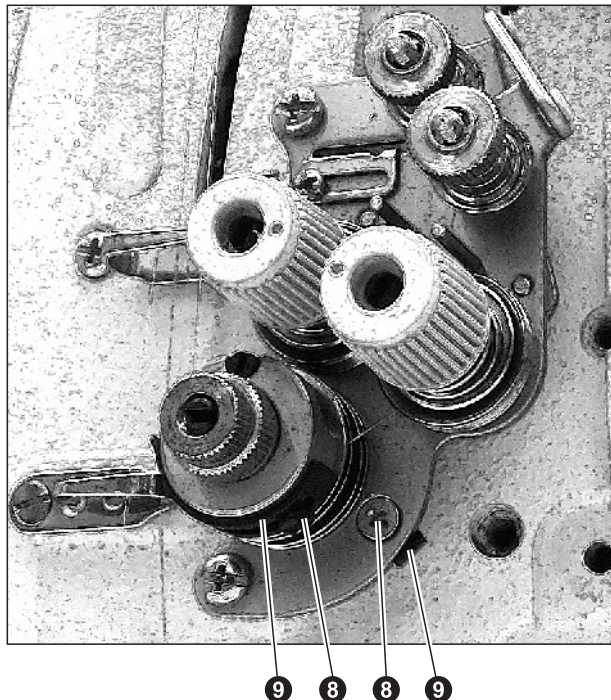
## E - STANDARD MACHINE ADJUSTMENT

### Operating range of the thread take-up spring

Operating range for thread take-up spring **L** and thread take-up spring **R** is **5 —10 mm** for both springs.

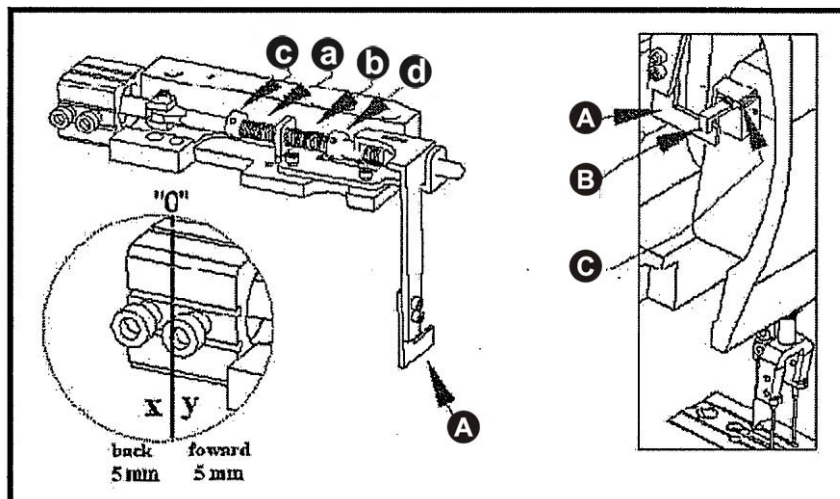
1 - Loosen the left and/or right screw(s) **8** and then turn the left and/or right thread take-up spring stoppers **9** to adjust the operating range.

2 - Tighten the screws **8**.



### 3. ANGLE POCKET NEEDLE SYSTEM ADJUSTMENT

The piston must stand right in the middle at “0” point. To make the piston stay in the middle or to adjust its stopping:



1- Bring the machine to one of the **NORMAL POCKET** (not angle) programs ( 1-10).

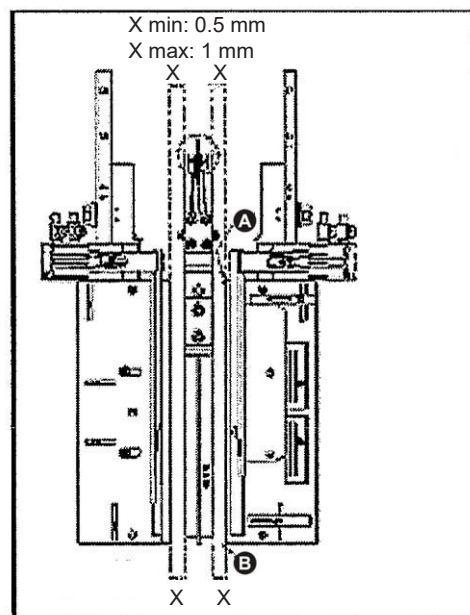
2 - Springs number **a** and **b** control the piston to stop in the middle. The balance adjustment of the springs is controlled by rings **c** and **d**.

3 - When the piston is adjusted to stay on “0” point, the pin number **B** that controls the needles separate motions must be exactly on the line. If pin no **B** is not exactly at line **C** is even a little out side this line, split needle timings will not be correct while stitching.

## E - STANDARD MACHINE ADJUSTMENT

### 4. CLAMP SETTINGS

Fabric folding gap between clamp and patch-guide should be between 0.5 mm and 1 mm according to the thickness of fabric stitched. It should be exactly the same from point **A** up to point **B** between clamp and patch-guide.

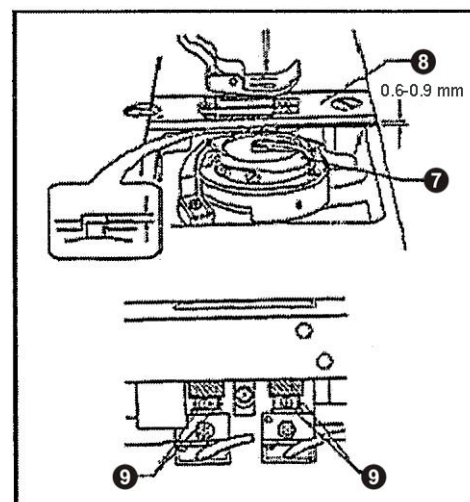


### 5. CLEARANCES BETWEEN ROTARY HOOKS AND PLATE

- 1- Remove the slide plates.
- 2 - Tilt back the machine head.
- 3 - Loosen the set screws **9** and move the rotary hook **7** up and down to adjust so that the clearance between the rotary hook **7** and the needle plate **8** is 0.6 — 0.9 mm.

**Note:** Do not turn the rotary hook while the set screws **9** are loosened , otherwise it will change the timing between the needle and the rotary hook.

- 4 - Tighten the set screws **9**.



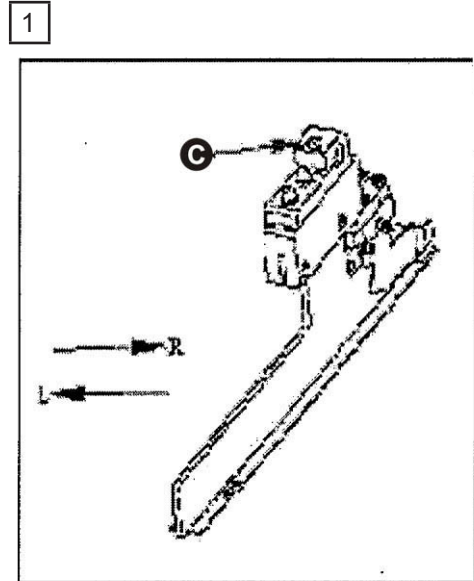
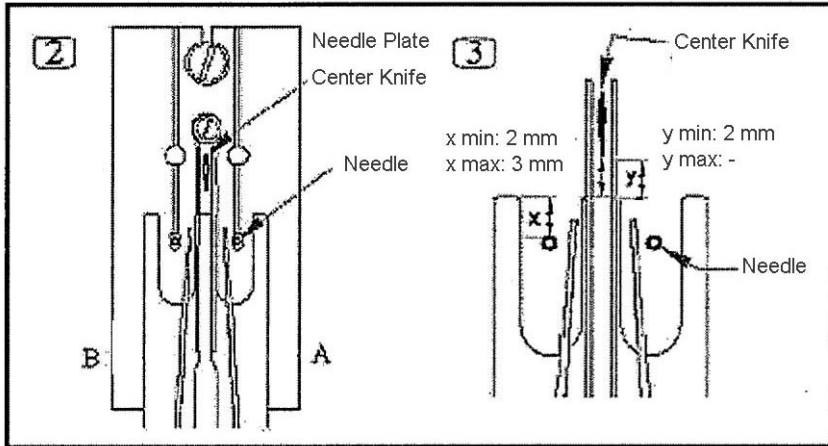
### 6. CRUCIAL POINTS WHEN ADJUSTING THE PATCH-GUIDE FOR THE FIRST TIME

- 1 - If we refer to the sides of the needle plate when we assemble the patch-guide, the guide has to be at equal distances to these two points. We can realize the right-left slip setting of the guide to the desired direction (Right-Left) by loosening the **C** screw.
- 2 - The second crucial aspect of the patch-guide is how much the back of the guide needs to pass the needle.

This distance (x) should be 'minimum 2 mm', 'maximum 3 mm'.

## E - STANDARD MACHINE ADJUSTMENT

**Note:** At this point, there is a very important point to be taken care of. The knife protector of the guide should not hit the central knife, (the space shown by 'y' should be minimum '2' mm) if the "y" distance is less than 2 mm, the central guide hits the central knife while coming down and damages the knife, it also damages the square of the guide and blocks it to work properly.



3 - When the patch-guide comes down, the bottom of the guide and the bottom base should be parallel and flat. You can make the angle adjustment of the guide and the bottom base by the **C** (or **D**) screw on the Figure 1 (Figure 5).

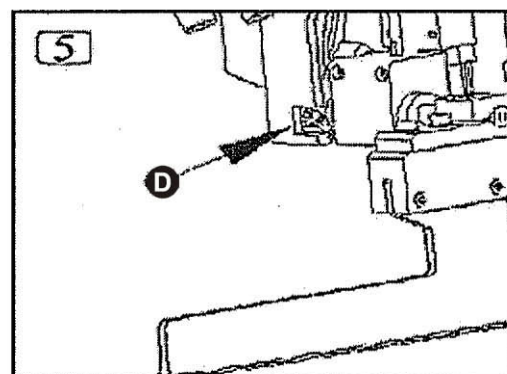
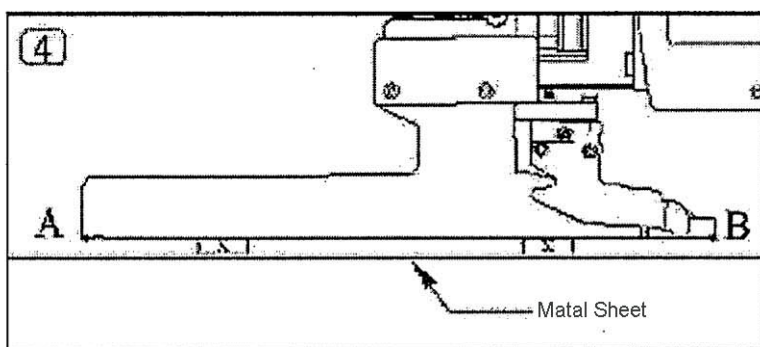
The bottom of the guide should be parallel with the base.

Bottom space at thin works should be X = 1 mm

Bottom space at middle works should be X = 1.5 mm

Bottom space at thick works should be X = 2 mm.

**Note:** If the back and front ends of the patch guide are not at equal distance from the base plate, your machine could catch the fabric while you are sewing.



## E - STANDARD MACHINE ADJUSTMENT

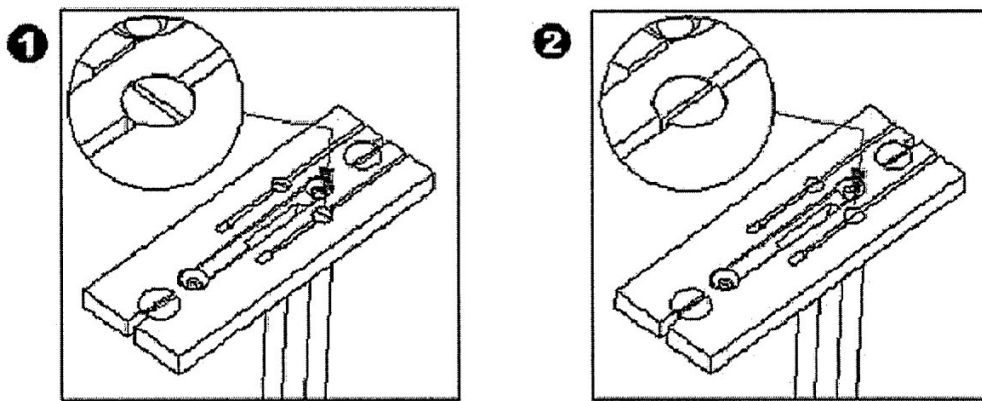
### 7. HOW TO ADJUST THE BOTTOM THREAD CUTTER?

At the end of the sewing, the threads coming from the bottom bobbin are cut by the bottom cutter and they are held in order the threads not to be free.

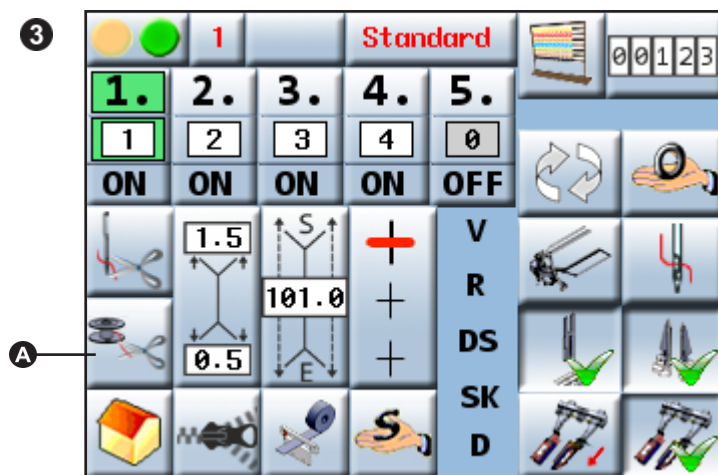
The cutting process of the bottom thread is handled by the cylindrical stick shape steel knives which are located inside the needle plate.

#### Important Issues While Making the Adjustments.

The normal position of the bottom thread cutting knives inside the plate should be as shown on Figure 1. When your machine starts sewing, the bottom thread cutting knives rotate 80 degrees counter clock wise and take the flat position as shown on Figure 2, and at the end of the sewing, they again take their initial position as shown on Figure 1. During this stage, the threads are being cut and held in order not to become free.



You can test the thread cutting knives manually at the **A** button shown on Figure 3.



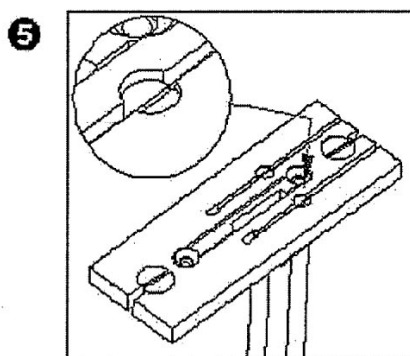
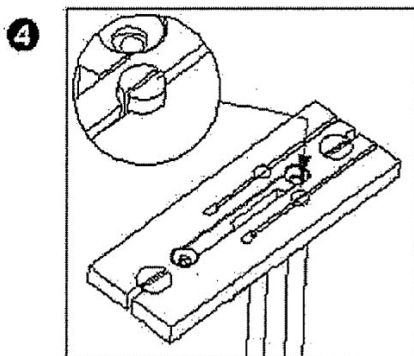
(Refer to section D1.1.)

## E - STANDARD MACHINE ADJUSTMENT

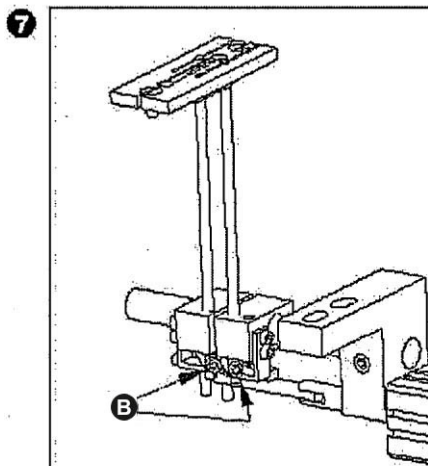
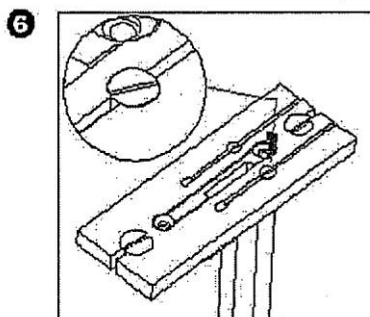
### Important Issues to be taken care of while Adjusting the Bofton Thread Cutting Knife Inside the Plate.

1 — Bottom thread cutting knives must definitely be on the same level as the plate, and may even be very little (0.2 mm) below the top level of the plate.(Figure 1 & 2).

2— Bottom thread cutting knives should not be adjusted to be higher or too much lower than the plate. (Figure 4 & 5). If the bottom cutting knives are adjusted this way, your machine would catch the fabric and it causes the stopping problem.



3 — By using the button **A** on the Figure 3, activate the bottom thread cutting knives manually and make sure that the canal inside the knife and the thread way are adjusted correctly. If the canal is not in compliance (Figure 6), the thread might not be cut, in this kind of situation you can make your adjustments by loosening the screws shown by **B** on Figure 7. The final position of your adjustment must be as shown on Figure 2.



**Note:** Please replace your bottom thread cutting knives periodically at least once a year or turn the cutting axle upside down. Both bottom surfaces of the axles are convenient to be used as spare knives.



## E - STANDARD MACHINE ADJUSTMENT

### 8. HOW TO ADJUST THE START/END OF SEWING IN THE BEGINNING OF THE POCKET-FLAP COVER AND AT THE END?

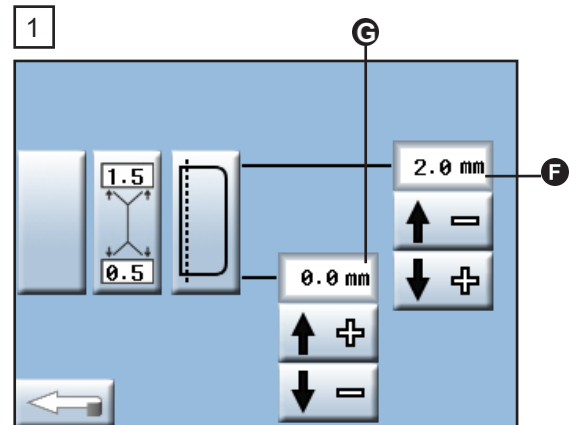
Choose one of the Programs 11 - 20. (Because the photocell scans the flap length in these programs and the machine determines the flap beginning and ending automatically.)

1 - On the flap being sewn, if the beginning sewing starts inside the cover (**Picture 2**), increase the **F** parameter on the Picture 1 for the necessary distance.

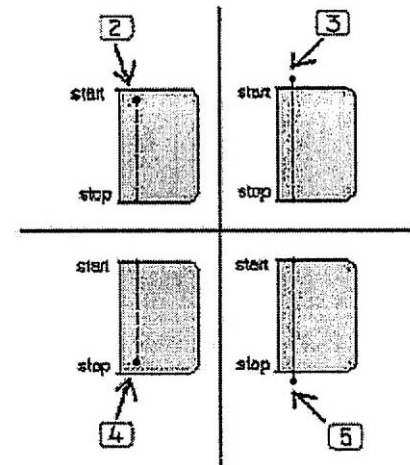
2 - On the flap being sewn, if the beginning sewing starts outside the cover (**Picture 3**), decrease the **F** parameter on the Picture 1 for the necessary distance.

3 - On the flap being sewn, if the ending sewing ends inside the cover (**Picture 4**), increase the **G** parameter on the Picture 1 for the necessary distance.

4 - On the flap being sewn, if the ending sewing ends outside the cover (**Picture 5**), decrease the **G** parameter on the Picture 1 for the necessary distance.



(Refer to section D1.2.2.)



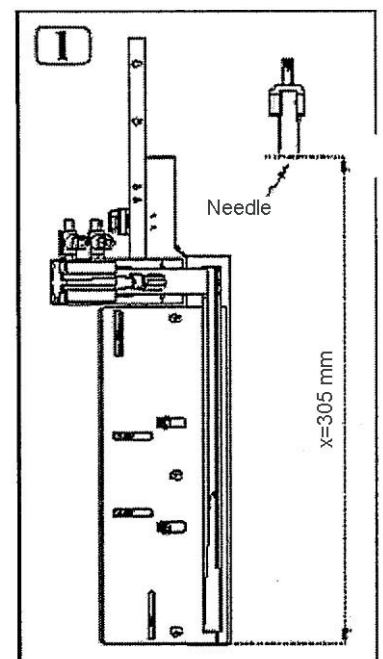
### 9. HOW TO ADJUST THE FRONT POSITION OF THE CLAMP?

Clamp finds the Home position after pressing the home button. It is important that the Clamp stays in right position in front. Many positioning settings on the machine are directly related to this setting. If the clamp stands on a different location than the one it should, it might change all the settings completely and you might face many problems.

#### How to Make This Adjustment?

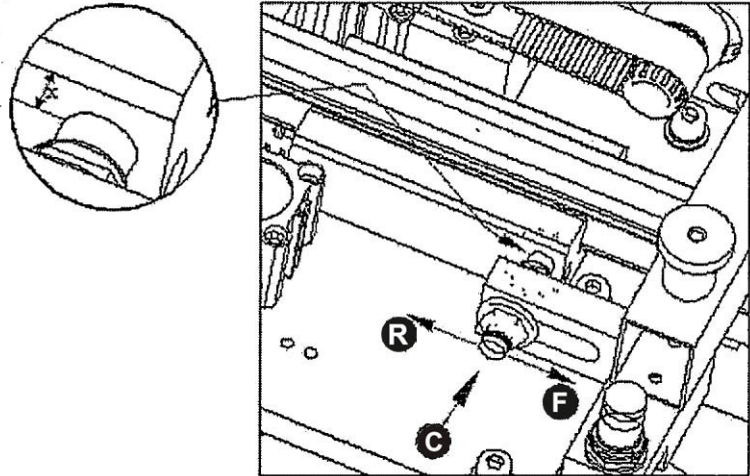
The distance between the needle and the clamp's standing point in the front after taking the home position should be exactly 305 mm (Figure 1). If the clamp passes 305 mm and stands more in front, slip the sensor shown by "C" on Figure 2 in the direction of arrow "R" and adjust it by necessary mm.

If the clamp stops before reaching mm, slip the sensor shown by "C" on Figure 2 in the direction of arrow "F" and adjust it by necessary mm.



## E - STANDARD MACHINE ADJUSTMENT

2 x=0.3 mm

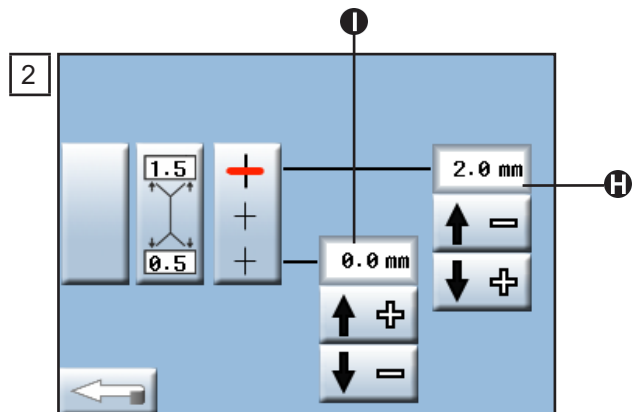
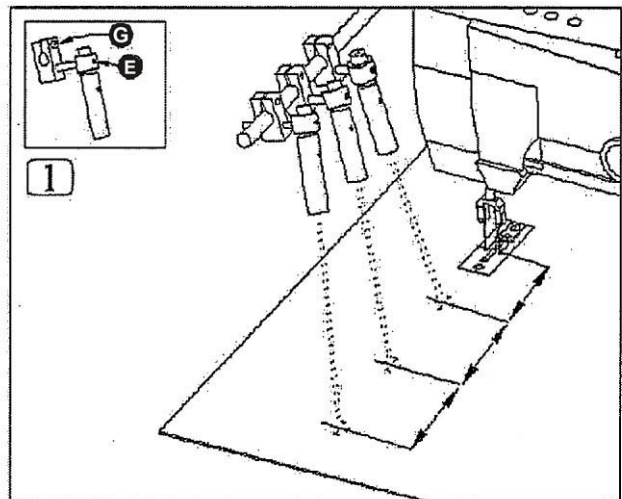


**Note:** While the linear cart stands in front, the distance between the position sensor and shutter (metal plate) should be approx. 0.3 mm. (Figure 2)

### 10. HOW TO ADJUST THE LASER POINTERS?

Machine starts and completes by referring to the place marked by the laser point which is chosen on the panel. That is why the user places the material to be sewn under the machine, referring to these laser pointers. Laser pointers are assembled and adjusted on the machine at standard distances from the needle. (Figure 1)

You can also see the places that the laser pointers should mark, labeled on the base plate of your machine. In case of any adjustment change or loss of adjustment, you can set the laser pointers to their standard adjustment by benefitting from here. You can make this adjustment from the **G** and **E** screw shown on Figure 1. On some special applications, if you would like to change the beginning and ending locations of the sewing without changing the location of the laser pointers, you can take advantage of the parameters shown by **H** and **I** on Figure 2.

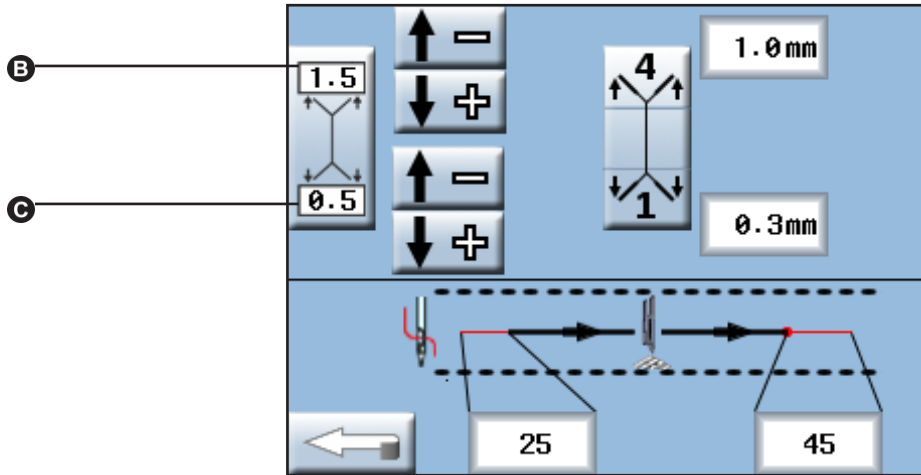


(Refer to section D1.2.1.)

## E - STANDARD MACHINE ADJUSTMENT

### 11. HOW TO MAKE KNIFE CUTTING POSITIONS FROM THE PANEL?

No matter how long is the sewn pocket or the flap, the cutting position of the corner knives is realized automatically by the machine. The settings of the corner knife cutting positions of the sewn pockets are made from the Panel as shown below.



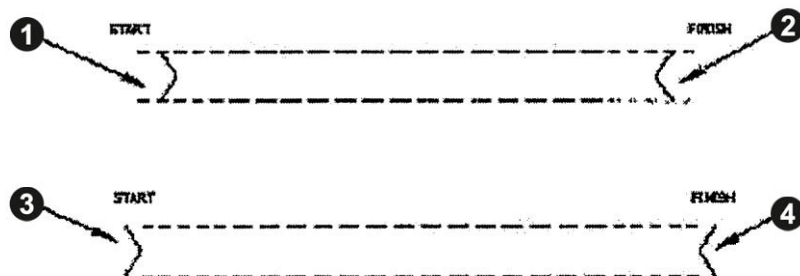
(Refer to section D1.4.)

**B** - You adjust the cutting position of the Start corner knife. By changing the parameter, you can let in or out the position of the corner knife.

**C** - You adjust the cutting position of the Stop corner knife. By changing the parameter, you can let in or out the position of the corner knife.

For example:

- When the **B** parameter value is reduced, the Start corner knife proceeds outside the sewing. Shown by the arrow labeled **3**
- When the **B** parameter value is increased, Start corner knife proceeds inside the sewing. Shown by the arrow labeled **1**
- When the **C** parameter value is reduced, Stop corner knife proceeds inside the sewing. Shown by the arrow labeled **2**
- When the **C** parameter value is increased, Start corner knife proceeds outside the sewing. Shown by the arrow labeled **4**



## E - STANDARD MACHINE ADJUSTMENT

### 12. THE SOLUTION FOR THE CORNER KNIFE CUTTING PROBLEMS

For the perfect and correct cutting of the corner knives at the pocket beginnings and ends:

- 1 - It is necessary that the knife which cuts the center of the sewing is new and not rusty.
- 2 - The settings of the middle knife which cuts the center of the sewing has to be correct and perfect.

**Note:** The problematic middle knife cuttings directly affect the corner knife cuttings and cause problematic corner knife cuttings; because it cuts the fabric while gathering it and it creates sewing with breaks. And it also causes the start corner knife to lose its position.

- 3 - The corner knives need to be replaced periodically in periods of 2 to 4 months depending on the type of the fabric. You cannot get perfect sewing result with bad quality knives.

After the above three main factors are controlled, you will face the below problems in corner knife cuttings.

Apply the mechanical solutions as described below:

**Problem 1:** Instead of dropping the corner knives at exact places, it drops on the sewing by cutting one of them, (Picture 2 A & B).

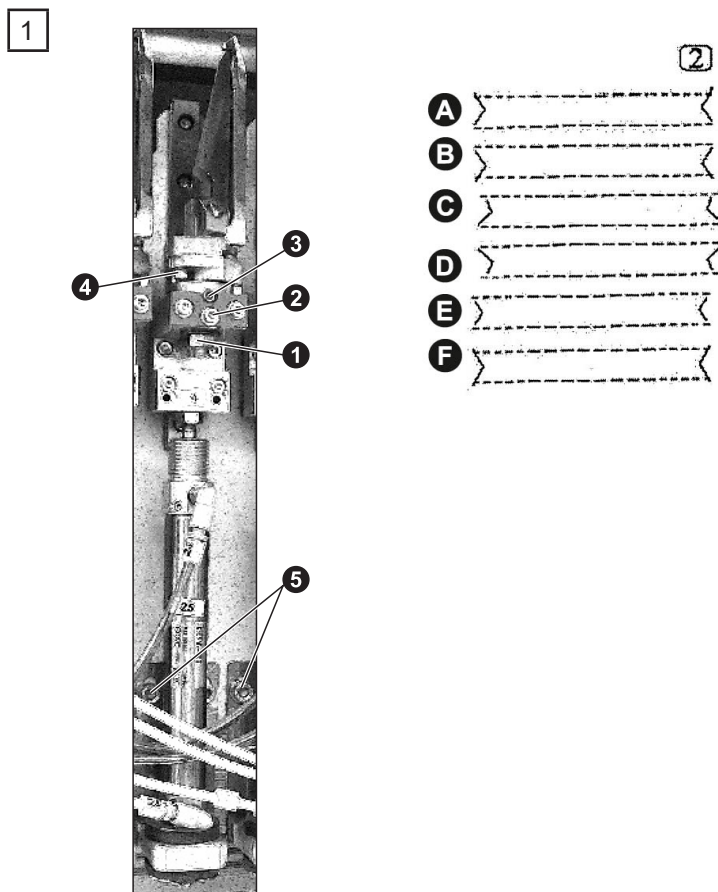
**Solution:** The nut of the corner knife cutting mechanism that cuts the sewing, shown with the arrow ① has to be opened (Picture 1) and from the in/out adjustment screw shown by the arrow ②, you can adjust the knife unit, in the opposite direction of cut sewing.

**Problem 2:** The corner knives make angled cuttings to any direction instead of exact cuttings (Picture 2 C & D);

**Solution:** After removing the knife head using screw ③ open the screw shown by the arrow ④ of the problematic corner knife mechanism that makes angled cuttings and making the adjustment by the sufficient angle, you can set the cutting angles again. (Picture 1)

**Problem 3:** If the corner knives cut much less than they are supposed to cut and the corner knife cut appears to be too small (Picture 2 E) or if they cut too much than it has to and the corner knife cutting appears to be too big (Picture 2 F).

**Solution:** Open the screws shown with the arrow ⑤ (Picture 1) of the knife unit which makes smaller corner knife cuttings and lift the knife piston unit a little bit up. If the corner knife makes larger cuttings, loosen the screw shown by the arrow ⑤ (Picture 1) of the problematic side and drop the knife piston unit a little bit below.



## E - STANDARD MACHINE ADJUSTMENT

### 13. HOW TO MAKE PHOTOCELL SETTING?

In the pocket flap sewing, the length of the cover is totally distinguished by the photocell.

Therefore, the setting of the photocell has to be very neat and perfect.

Firstly, it is necessary that the reflector strip on the clamp is scratch less, very clean and not deformed.

Do not forget that this strip has to renewed in 2-month periods.

It is necessary that from the beginning of the reflector strip at point **A** until the end of the reflector at point **B** has to be taped. If the reflector strip is deformed at even a very slight degree, the photocell perceives this deformed place during sewing and causes the flap to be on a different length than it is supposed to be.

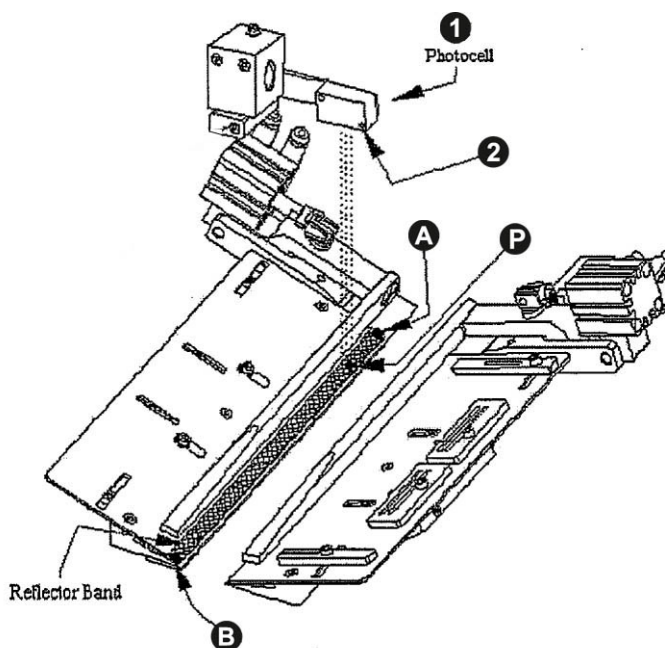
After making sure that the reflector is very new and clean, the photocell has to be facing the reflector strip perpendicularly with 90 degree angle. (point **P**)

When the photocell (item no **1**) sees the reflector strip, orange led lights.

Photocell has to see the reflector strip from point **A** to point **B** of the clamp without turning off. If it does not see it, check the strip and then check the facing angle of the photocell with the reflector strip.

You can check if the photocell can see the point **A** and point **B** on the clamp by benefitting the Test Screen (refer to Section D2.11).

If the viewing angle of the photocell and the reflector strip is not 90 degrees, adjust the viewing angle from the screw shown by the arrow **2**, behind the photocell. If the photocell still does not see the reflector strip and it faces the side of the reflector, then you can adjust by rotating the photocell slightly.



## E - STANDARD MACHINE ADJUSTMENT

### 14. HOW TO MAKE SETTINGS OF THE WING PLATES OF THE PATCH-GUIDE?

In order to adjust the wing plates:

**1** - Bring the needles to the level of the plate hole openings as shown on the picture.(Picture A)

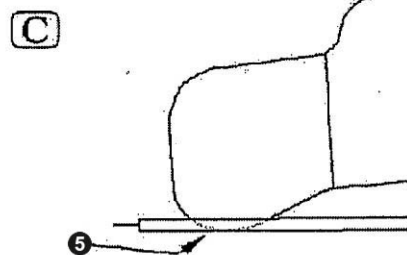
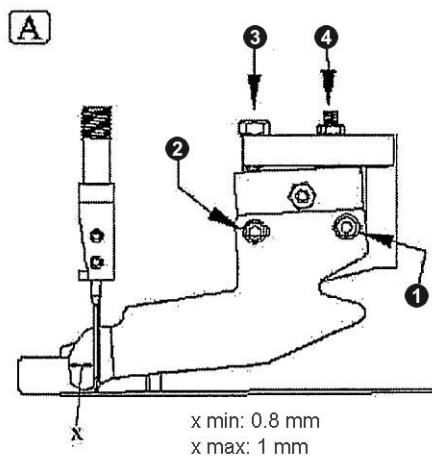
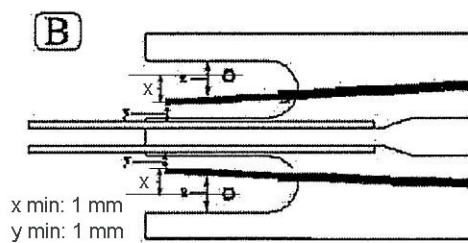
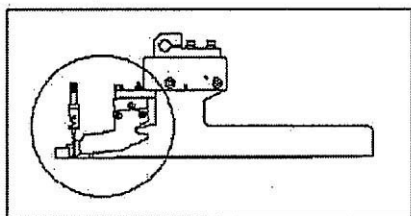
**2** - Wing plates have to pass the needle ends by 0.8 mm to 1 mm. (as shown on the Picture A with x) You can make the back/forward settings of the plates by loosening the screws numbered **1** and **2**.

**3** - It is necessary that the wing plates does not run longer from under the lower guide plate (as shown by the arrow **5**). The plates have to be adjusted on the same level of the lower part of the lower guide plate. You can make these adjustments by loosening the screw numbered **4** and moving the plates up/ down.

You can arrange the pressures of the wing plates by the screw numbered **3**. The pressure setting of the plates has to be neither too hard nor too soft.

**Note:** The wing plate setting is very important. The wing plates should never touch the needles. If they touch them during the sewing, then it causes the thread breaking problems.

The settings on both sides of the plates and the needles have to be equal and balanced. (Picture B)



## E - STANDARD MACHINE ADJUSTMENT

### 15. HOW TO MAKE THE ADJUSTMENT OF THE CENTRAL KNIFE?

Central knife adjustment is one of the most important adjustments at the Pocket Welt Automat.

If the adjustment of the central knife is with problems, when the machine begins the sewing the central knife would not cut neatly and the cuttings would not be correct.

At this kind of a problem, the users tend to first make adjustments of the corner knife cuttings, but the problem does not occur because of the corner knives. The basic reason of the problem is caused by the adjustments of the central knife.

The maintenance of the central knife in the machine must be made neatly and periodically. If the garment is polyester and with Lycra, check the adjustments of the central knives in periods of 2 or 3 months and replace the knives.

If the garment is cotton or linen, check the adjustments of the central knives in periods of 4 or 5 months and replace the knives.

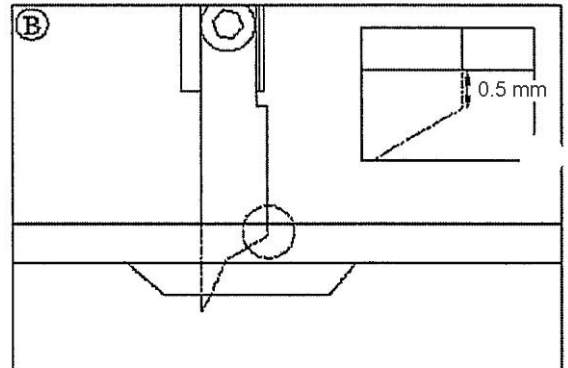
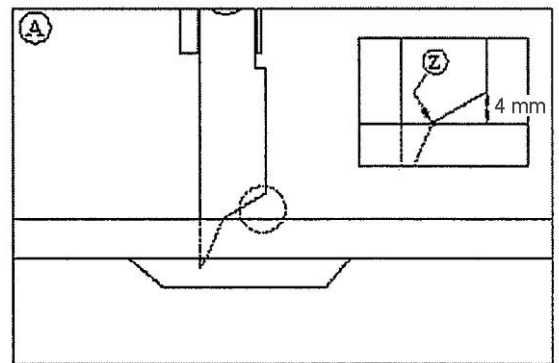
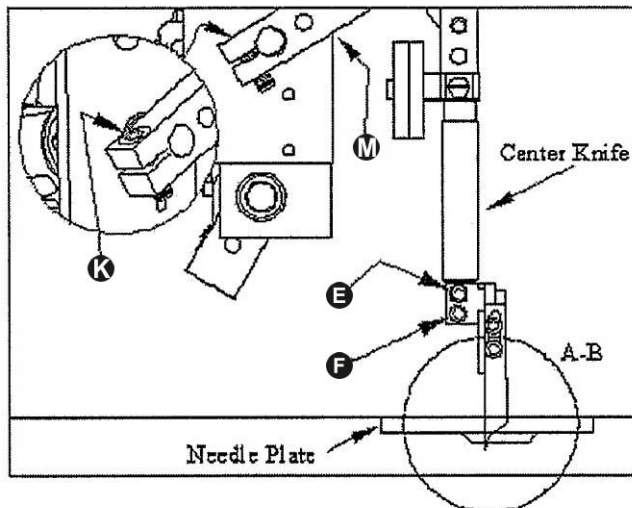
#### How to Make the Height Setting of the Central Knife?

By entering the test screen from the panel, pass the button A and activate the central knife.

Turn the hand pulley of the machine head slowly. When the central knife is at the very top point, it has to be above the throat plate top level and Z corner by 4 — 4.5 mm (Figure-A)

It has to be exactly equalized with the plate's top point (Figure-A).

Turn the machine's hand pulley slowly once again. When the central knife is at the very bottom point, the cutting edge of it should be below the plate surface by at least 0.5 mm (Figure-B).



When replacing the central knife with a new one lift the central knife to the lowest point and tighten the **E** and **F** screws (Refer to the figure). (Tighten the screws definitely when the central knife is at the very top point).

You can make the cutting adjustment from the plate level by the **K** screw.

If you loosen the **K** screw and lift the **M** handle, cutting space slips up from the plate level. If you loosen the **K** screw and take down the **M** handle, cutting space slips down from the plate level.

## E - STANDARD MACHINE ADJUSTMENT

### 16. HOW TO MAKE THE SQUARE ADJUSTMENT OF THE PATCH-GUIDE?

**Note:** The square adjustment of the patch-guide has to be made by a technical service personnel or by someone who has done this adjustment before. And also, no fluctuation should be made unless the patch-guide square adjustment is necessary.

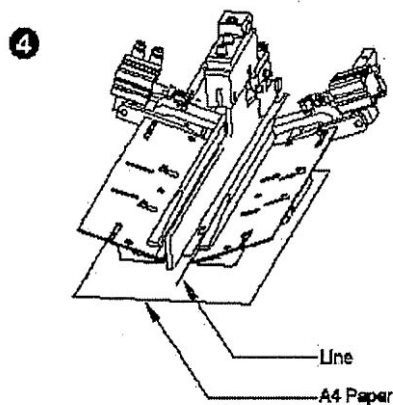
**1** - Square adjustment of the central guide according to the needle is very crucial. If the parallelity setting of the central guide and needle are not the same, there might be variations on the patch width of the sewn pockets at the beginning and at the end. (Figure 2, 3)

**2** - When the square adjustment of the central guide according to the needle is correct, the patch width of the sewn pockets will be correct at the beginning and at the end. (Figure 1)



#### How to make these square adjustments?

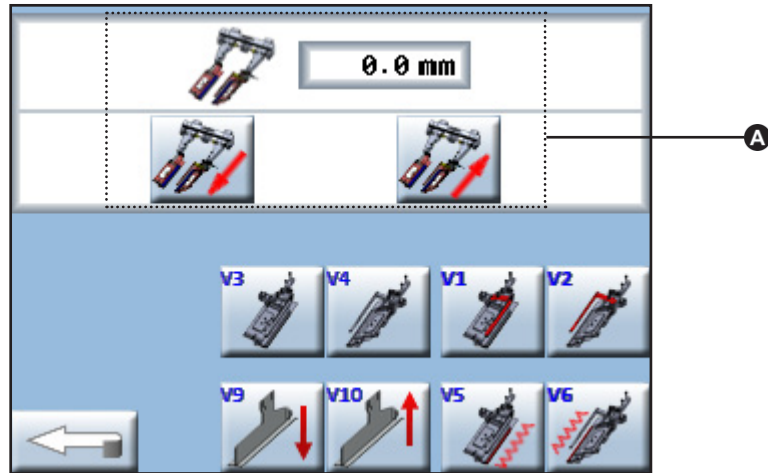
- 1 - Place a white A4 paper under the Clamps.
- 2 - Draw a 3 cm long line on the side of the central guide. (Figure 4)





## E - STANDARD MACHINE ADJUSTMENT

3 - From the test section on the panel send the clamps back by 5-6 cm manually by the button shown by **A**.

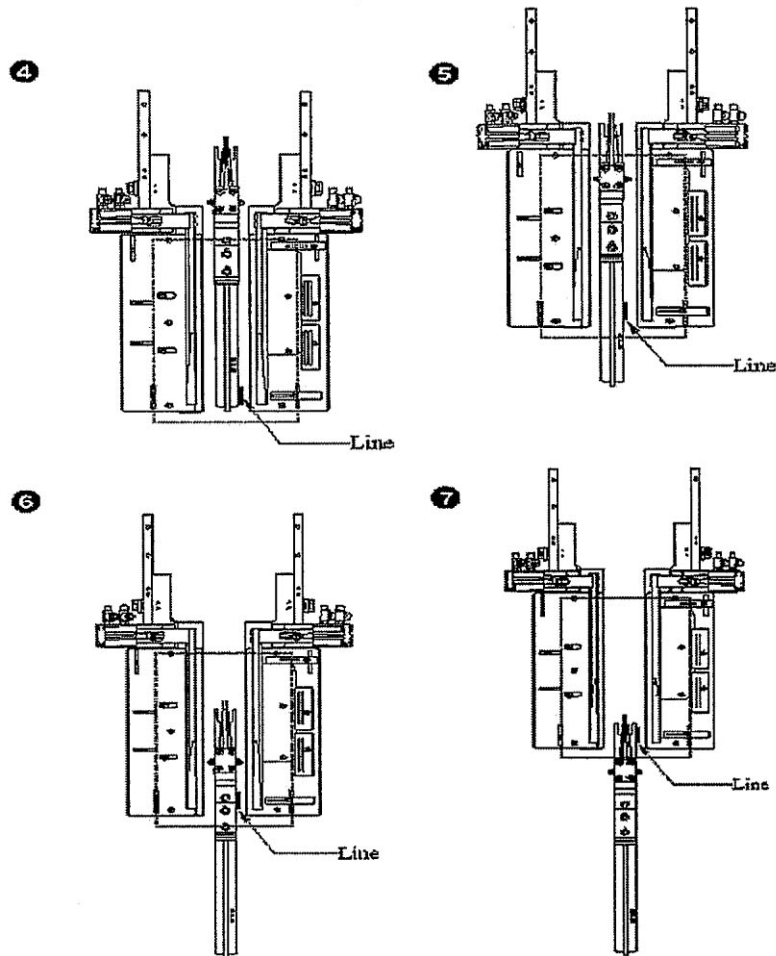


(Refer to section D2.3)

4 - Overview the parallelism of the the drawn line's getting remote — closer from the patch-guide. (Figure **5**)

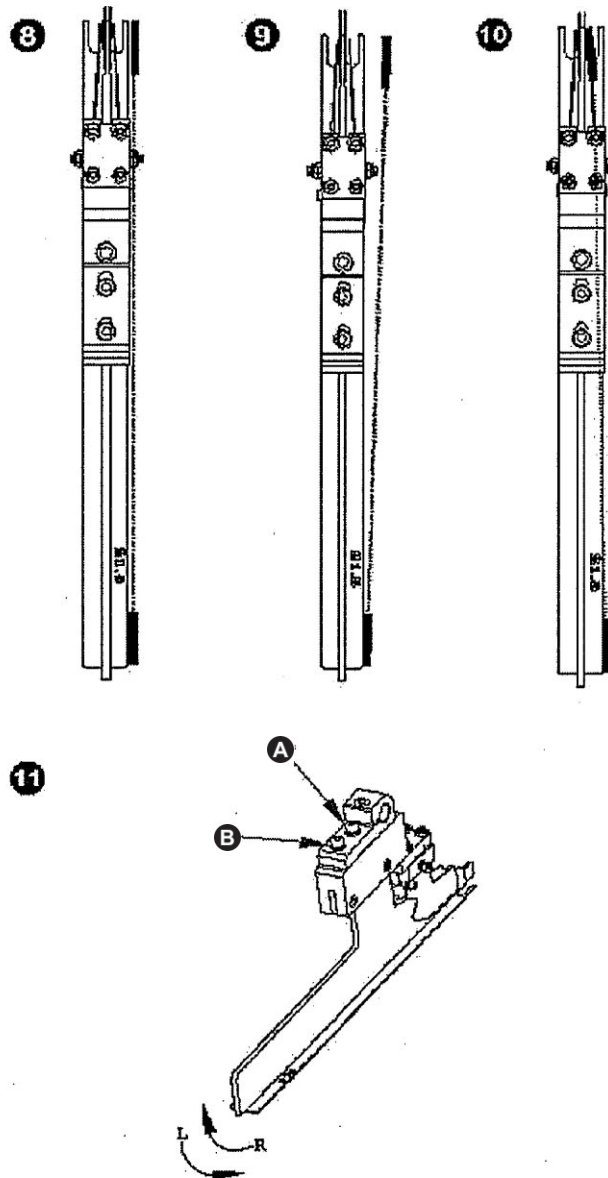
5 - After another 5 - 6 cm, overview the location of the line once again. (Figure **6**)

6 - When the line comes to the rearest part of the patch-guide: (Figure **7**)



## E - STANDARD MACHINE ADJUSTMENT

- If the line drawn on the paper goes parallel to the guide until the end of the central guide, it means that the square adjustment is correct. (Figure 8)
- If the line drawn on the paper slips outside the guide instead of going parallel to the central guide until the end of the guide (Figure 9), please rotate slightly the guide clockwise (arrow R) by loosening the A and B screws on figure 11.
- If the line drawn on the paper slips inside the guide instead of going parallel to the central guide until the end of the guide (Figure 10), please rotate slightly the guide clockwise (arrow L) by loosening the A and B screws on figure 11.
- After these processes, check the correctness of the adjustments you have made by repeating the whole operation.

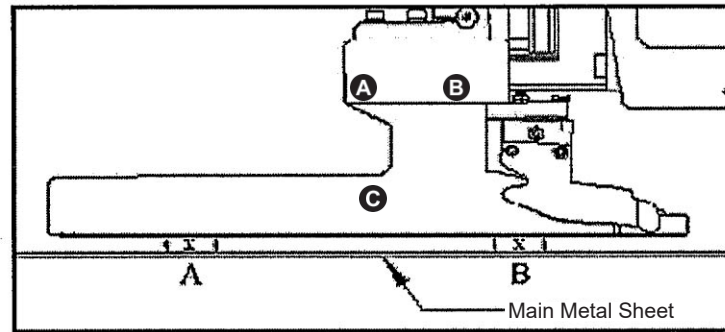


## E - STANDARD MACHINE ADJUSTMENT

### 17. INSTALLATION OF DOUBLE-SINGLE FILLET APPARATUS TO THE MACHINE AND CLAMP SETTINGS

It is possible to use either double or single fillet apparatus basing on the pocket model to be stitched on the machine. Double and single fillet apparatuses are changed by loosening screws **A** and **B** in figure and installing other apparatus to housing **C**.

**Note:** Check if bottom part of apparatus is in parallel with main sheet after changing apparatus.



- 1 - Points "A" and "B" should be equally away from the metal sheet.
- 2 - Clamps will be automatically located depending on the apparatus installed on the machine (machine detects this by sensor if installed).
- 3 - assuming that we work with double fillet apparatus, clamps work basing on rings **A2** and **B1**.

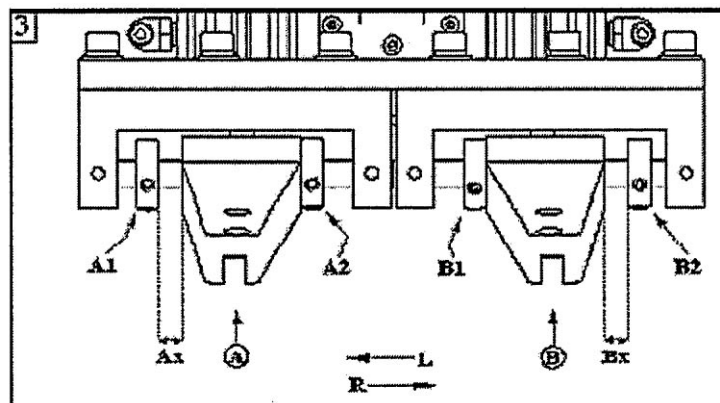
**Note:** Tensioning piston under clamps pull clamps to each other when double fillet apparatus is installed.

Tensioning piston under clamps separate clamps from each other when single fillet apparatus is installed.

Assuming that double fillet apparatus is replaced with left-hand expanded fillet apparatus, machine will detect only single fillet apparatus and clamps will shift externally to lean on **A1** ring.

"Ax" distance is as much as the excessive distance of single fillet apparatus.

Clamp based on **A1** ring and left single fillet apparatus newly installed on the machine should be 0.5 mm and 1 mm away from the clamps on both sides. If such a distance is not possible, loosen ring **A1** and take necessary direction. In a like manner, if only right single fillet apparatus is installed, make necessary settings from **B2** ring position.

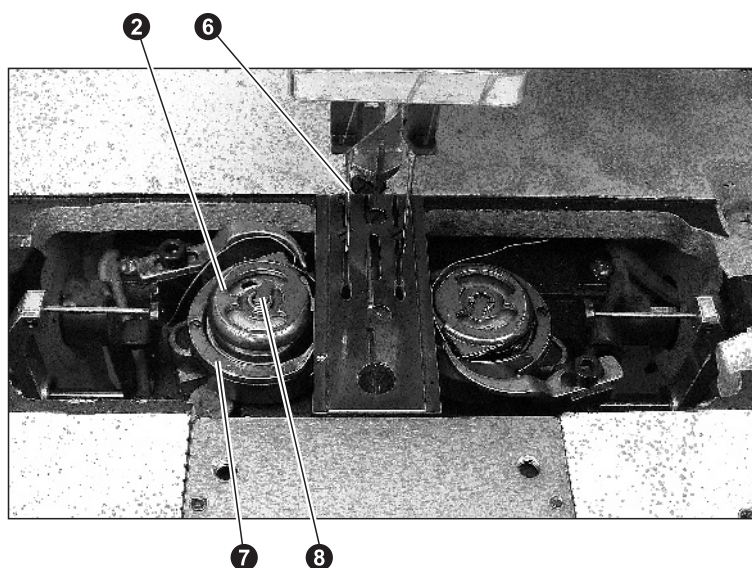
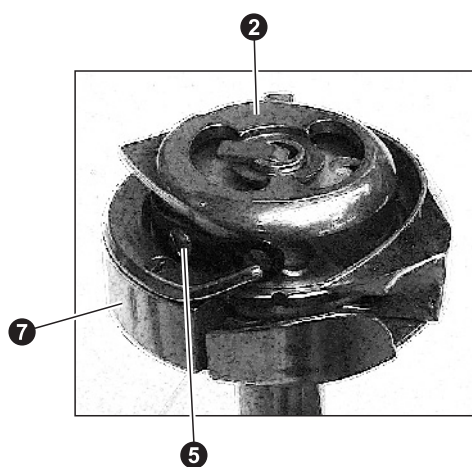
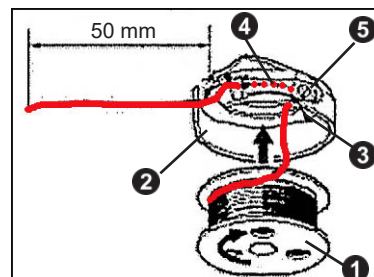


## E - STANDARD MACHINE ADJUSTMENT

### 18. INSTALLING THE BOBBIN AND THE CUP

#### Installing The Bobbin

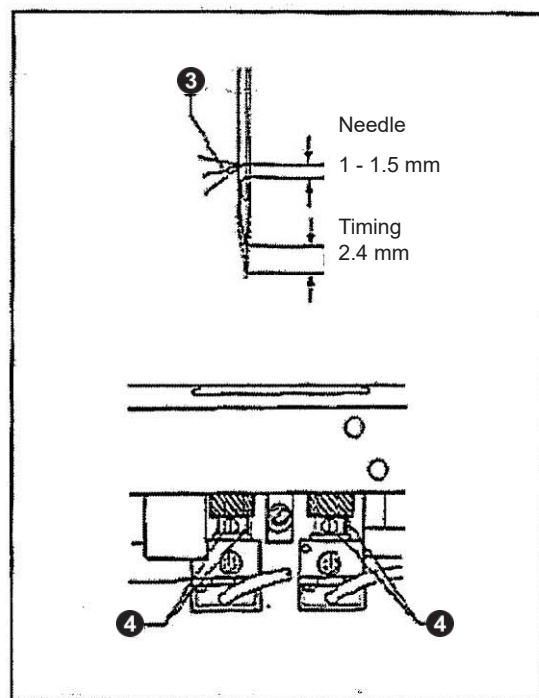
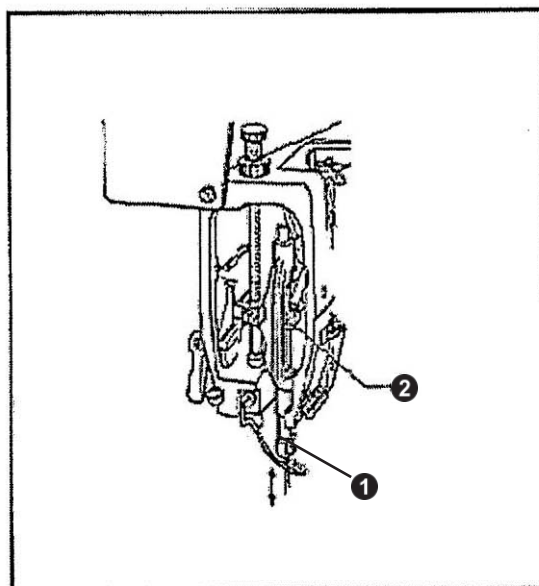
- 1 - Insert the bobbin ① into the cap ② so that the winding direction is as shown in the illustration.
- 2 - Pass the thread through slot ③ and under the tension spring ④.
- 3 - Pull out the thread to a length of approximately 50 mm.
- 4 - Adjust the thread tension ⑤.
- 5 - Turn the machine hand-wheel to raise the needle ⑥ to its highest position.
- 6 - Insert the bobbin-cap ② into the rotary hook ⑦.
- 7 - Return the rotary hook latch ⑧ to its original position.
- 8 - Close the slide plates.



## E - STANDARD MACHINE ADJUSTMENT

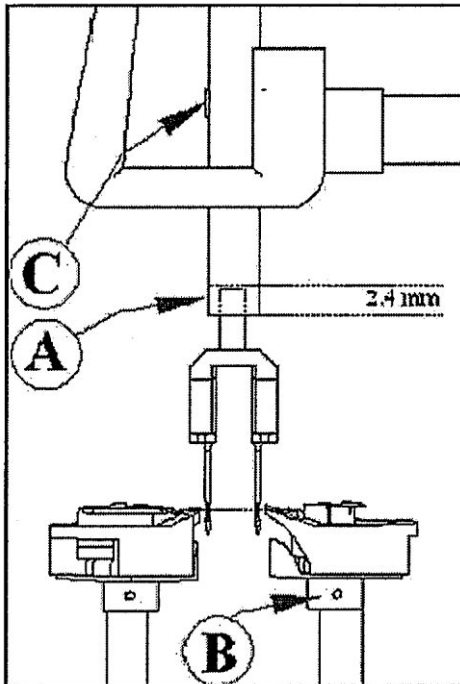
### 19. NEEDLE BAR HEIGHT

- 1 - Change the stitch length to the smallest possible setting.
- 2 - Open the face plate.
- 3 - Turn the machine pulley to move the needle bar **1** to its lowest position.
- 4 - Check that the needle goes into the middle of the needle hole in the throat-plate.
- 5 - Remove the needle plate.
- 6 - Turn the machine pulley to raise the needle bar **1** by the requested timing (default: 2.4 mm) from its lowest position.
- 7- The rotary hook tip **3** must be aligned with the center of the needle at this time.
- 8 - Tilt back the machine head , loosen the three screws **4**, and then align the rotary hook tip **3** with the center of the needle.
- 9 - Tighten the screws **4**.
- 10 - The distance from the upper edge of the needle hole to the rotary hook tip **3** must be **1 —1.5 mm** when the rotary hook tip **3** is aligned with the center of the needle.
- 11 - Loosen the screw **2** and move the needle bar **1** up and down to adjust the height.
- 12 - Tighten the screw **2**.
- 13 - Install the needle plate.



## E - STANDARD MACHINE ADJUSTMENT

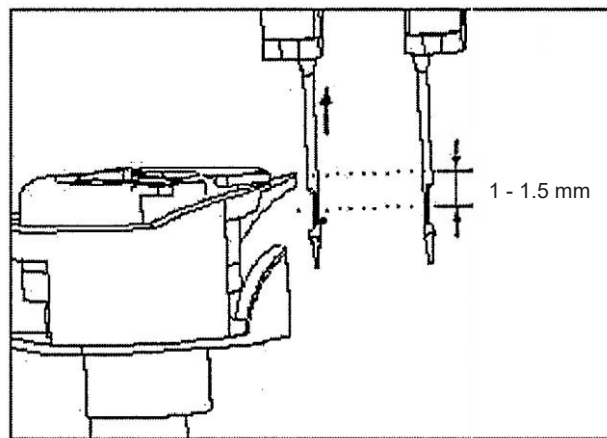
### 20. ROTARY HOOK TIMING



**A** - When the needle rises 2.4 mm above from the bottom dead point, the rotary hook point should be 1-1.5 mm above the needle eye.

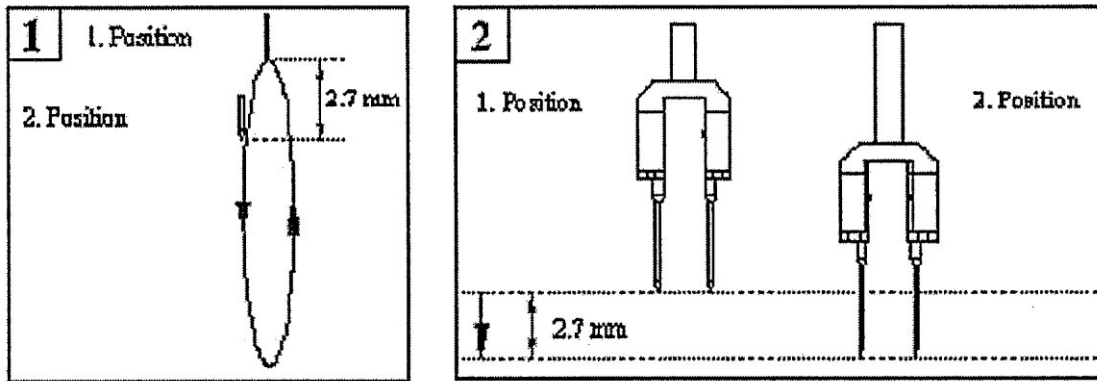
**B** - When needle rises 2.4 mm above from the bottom dead point, if the rotary hook point is not aligned with the needle loosen screws B and align the point of rotary hook with the center of needle.

**C** - When needle rises 2.4 mm above from the bottom dead point, if rotary hook point is aligned with the needle but the height between needle eye and rotary hook point is not 1— 1.5 mm, adjust the needle-bar height using the screw **C**.



## E - STANDARD MACHINE ADJUSTMENT

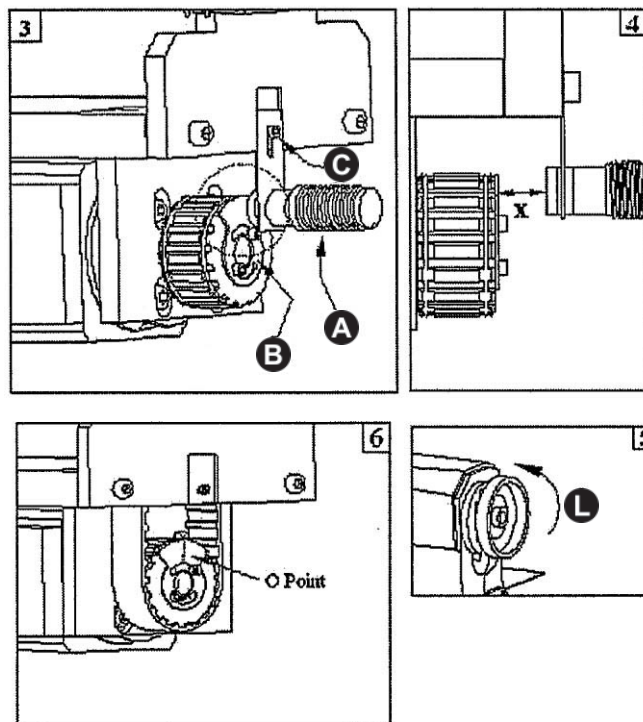
### 21. SENSOR SETTINGS OF HEAD POSITION SENSOR



1 - Home position of stitching head is adjusted by sensor **A** in Figure 3. The distance between sensor **A** and positioning plate on gear pulley should be **approx. 0.3 mm** (Figure 4, x distance)

2 - Turn hand pulley of machine forwards so that needles face the top point (Figure 5, **arrow direction L**). When needles reach the top point (Figure 1, 2 position 1) take from the top point of needles again in the same direction about **2.7 mm** downwards and stop (Figure 1, 2 position 2.). At that point the center of plate **B** in Figure 3 should be against sensor A (Figure 5, point "0") (necessary settings can be done with screws on **B**.)

3 - Perform a sewing cycle and check the stopping position. Readjust the plate **B** if necessary.



## E - STANDARD MACHINE ADJUSTMENT

### 22. THE ISSUES TO BE TAKEN CARE OF ABOUT THE POCKET FLAPS

Sewing Quality on the Pocket Flap Applications:

- 1 - It depends on the technical specifications of the machinery and the perfection of the settings.
- 2- It depends on the form of the flap and the production quality.
- 3 - During sewing, the machine distinguishes the length of the flap when the photocell perceives the side borders of the flap.

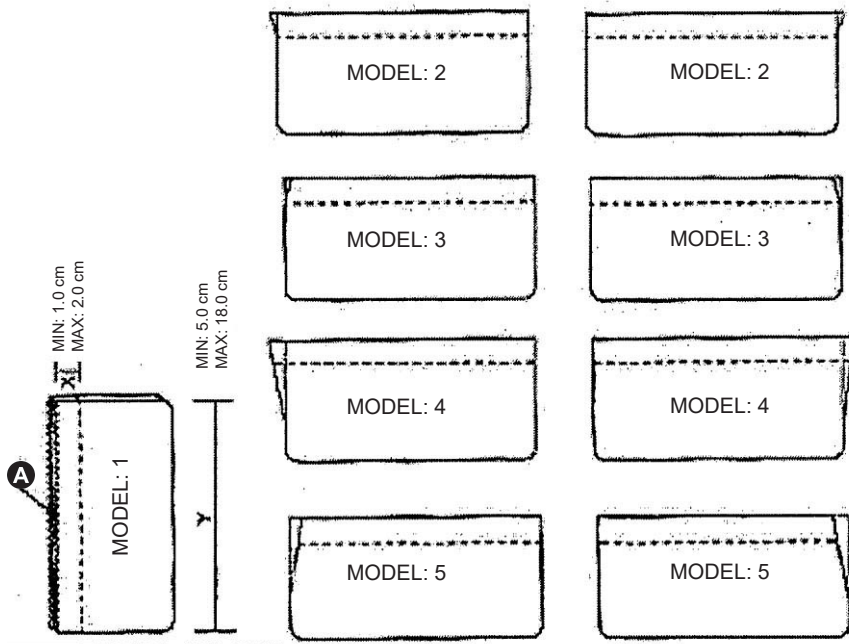
Therefore, the neatness of the side borders affects the quality of the work directly.

Model-1 is a correct example for the flap sewing and neatness of the side borders.

Model-2, Model-3, Model-4, Model-5, are good examples for the wrong flap and side sewing.

This kind of wrong flap sewing blocks the machine to perceive the flap length correctly, that way you will get different results than the original length of the flap. While working with this type of incorrect flap examples, do not change the machine settings unnecessarily. Solve the real problem (flap sewing quality) first.

On the flaps sewn from thin and delicate fabrics, always use interlining or reinforcement, a material to keep the flap hard and thick, inside the flap which consists of two separate parts. The place shown with an arrow labeled A. This will provide the flap's form to look neat and does not create puckering or waviness on the flap during sewing.





## E - STANDARD MACHINE ADJUSTMENT

### 23. THE ISSUES TO BE TAKEN CARE OF ABOUT THE POCKET FLAPS

#### How to Locate the Pocket Carrier on the Clamp?

The A and B stops on the clamp have a role on the beginning and the ending of the flap to be sewn according to the garment reference pointers (Lasers).

They are put under the clamps, according to the body reference lamps of the flap that is to be sewn.

According to the right and left position of the body that the flap is to be sewn, the flap is sewn on the exact location on the body, benefitting the A and B leaning points.

The E and F leaning points on the clamp are the stops to be used to adjust the width of the flap by the user after the sewing.

If you are working on a jacket pocket flap on the machine, put the flap on the left clamp, if you are working on a pants pocket flap on the machine, put the flap on the right clamp, while working.

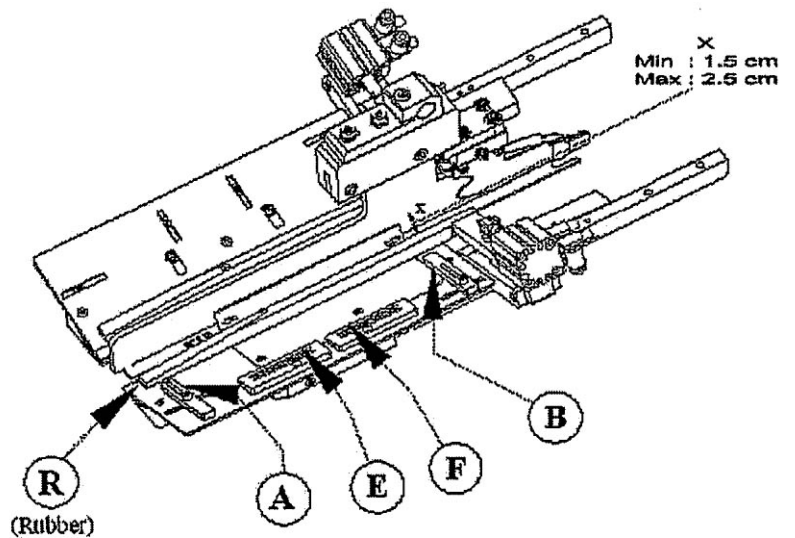
When the pocket flap is being sewn on the right and left body (fabric), it is sewn by first leaning on the A leaning point and then on the B leaning point, respectively. When the flap is located on the clamp, the next action is clamping the flap while holding arm is activated, by pushing the pedal button.

**Note:** The rubber(R) under the holding arm here has to be necessarily clean and neat. The flap held by an incorrect rubber, might slip and the sewing is done with breaks, therefore, the sewing outcome will be incorrect.

These rubbers have to be periodically replaced in 3-6 month periods.

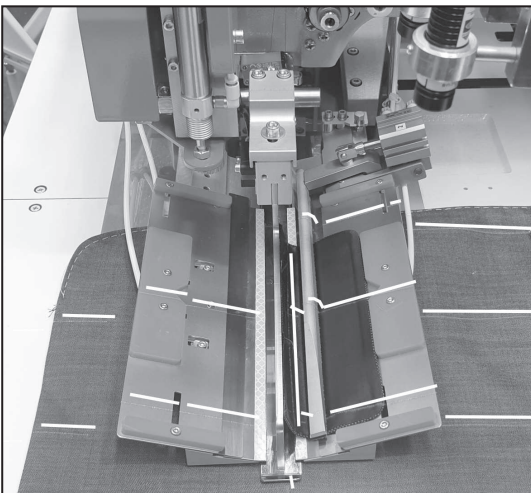
Before starting the sewing, we have to correct the flap with a finger or a long object first to the X direction and then to the Y direction, so that we provide the 90 degree refraction.

If this action is done continuously before the sewing of every flap, the beginning and ending sides of the flaps will be sewn neatly and cleanly.

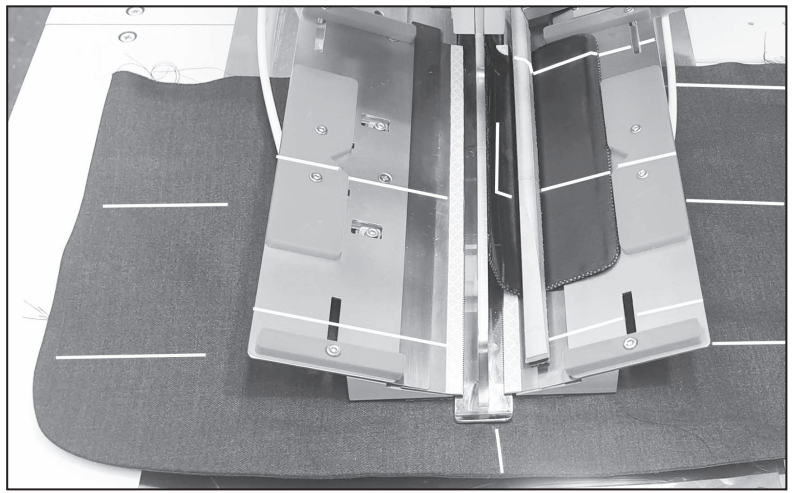


#### Flap positioning for:

##### Left pocket welt



##### Right pocket welt



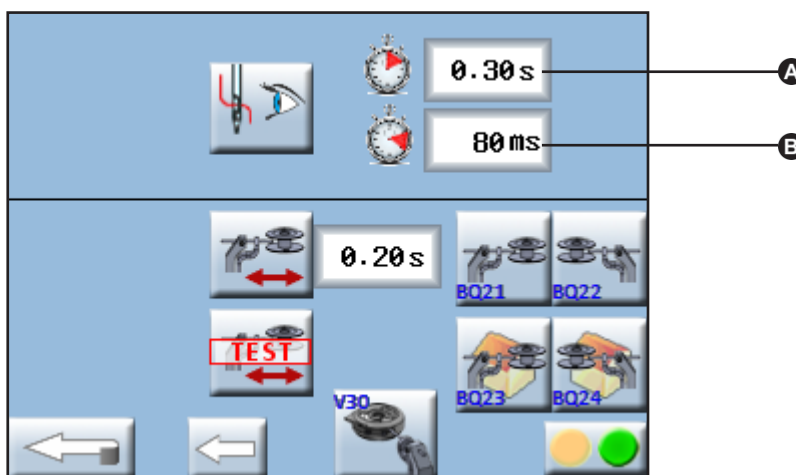
## E - STANDARD MACHINE ADJUSTMENT

### 24. TOP THREAD-BREAKAGE SENSOR SENSITIVITY SETTING

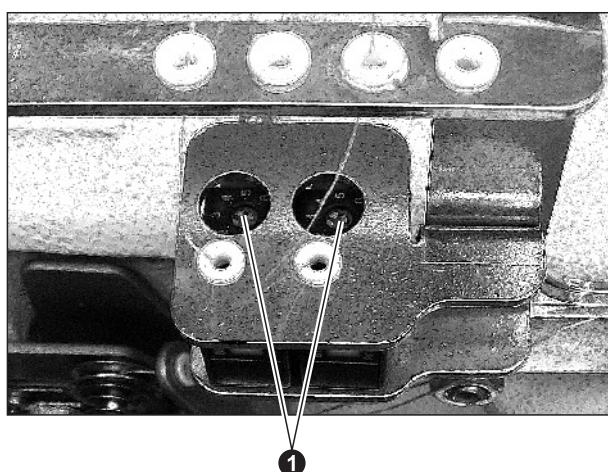
Upper thread sensor is an electronic device which detects if any of those threads feeding the needle is broken or is not freely fed to the needle while machine performs stitching and stops the machine.

If during stitching the thread broke warning message is displayed on screen although the thread is not broken and at that time machine stops or does not stop even if the thread is broken (since it does not detect such a break):

- 1 - If a faulty thread detection occurs in the beginning of sewing, increase the parameter value **B**.
- 2 - If a faulty thread detection occurs at random points during sewing, increase the parameter value **A**.
- 3 - In case of a breakage non-detection, increase the parameters **A** and **B**.
- 4 - If problem persists even if parameter value has been increased or decreased, then you must recheck sensitivity settings of the respective thread-breakage sensor (left or right) **1**.



(Refer to section D2.4)



## F - MAINTENANCE

Cleaning entire machine.....	weekly
Cleaning bobbin case section.....	several times per day
Checking oil level.....	prior to operation everyday
Lubricating latch levers.....	once a month
Checking air pressure.....	prior to operation everyday
Cleaning maintenance unit air filter.....	whenever necessary

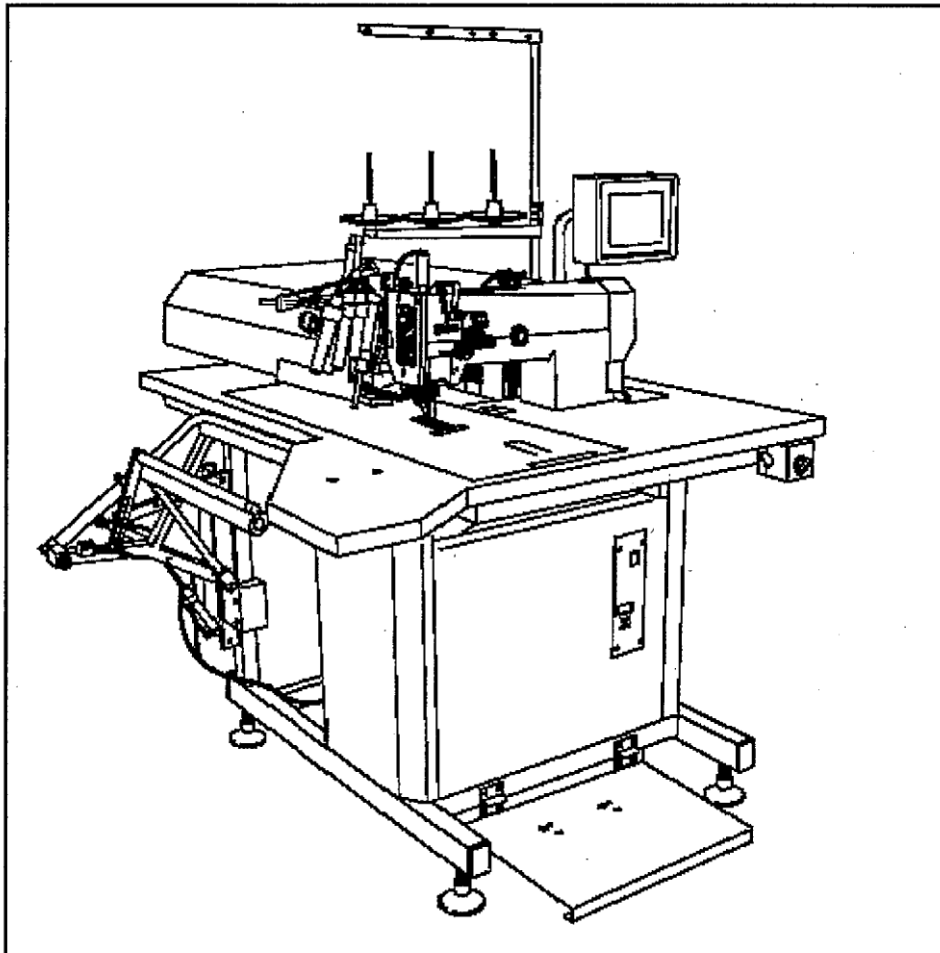


Time intervals for maintenance have been calculated according to average working time of machine at a single shift factory. In case machine is operated for more, it is highly recommended to keep maintenance intervals more frequent.

### 1. CLEANING THE MACHINE

Time interval necessary for cleaning and lubricating the machine depends on the following Factors:

- Single or multiple shift operation
- Possibility of sewn material to get dusty

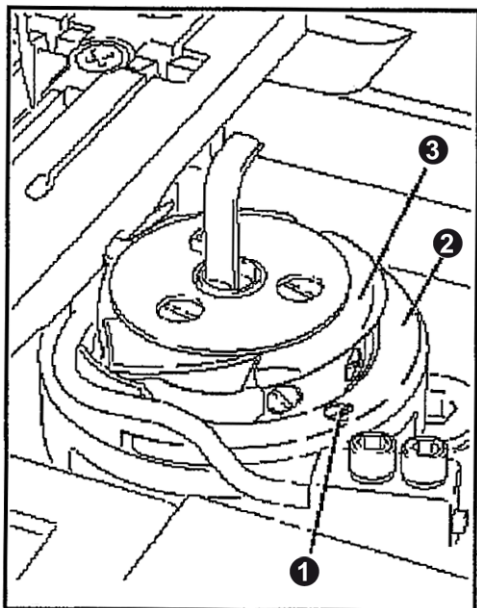


It is recommended to carry out the following cleaning processes in order to prevent any operative failures in single shift operations:

The entire machine must be cleaned for at least once a week.

## F - MAINTENANCE

### 2. CLEANING THE HOOK AND BASE

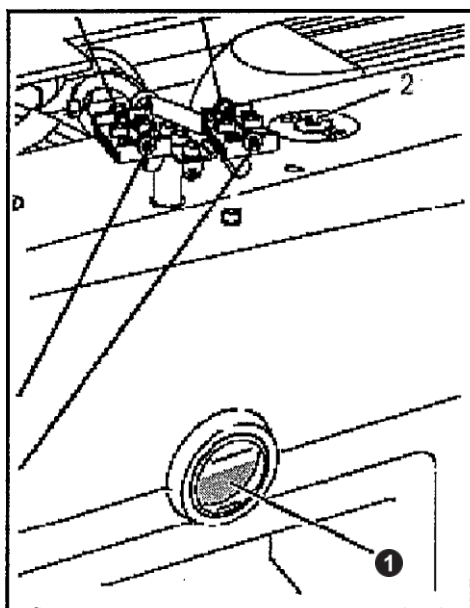


#### 1. CLEANING THE HOOK AND BASE

Bobbin case section and needle part must be cleaned for several times per day.

- Switch off the machine!
- Turn of air pressure!
- Remove screws nr. **1**
- Remove base retainer nr. **2**
- Turn hand pulley of head until base side stops horizontally at capsule ventilator.
- Remove base nr. **3**
- Clean hook and base.
- And lubricate thoroughly.
- Insert spool capsule nr. **3**
- Return base retainer nr. **2**.

### 3. CHECKING OIL LEVEL



- Switch off the machine!
- Check oil level from window (figure nr. **1**) prior to operation every day.
- If oil is at lower level, it must be refilled until 1 oil level reaches between upper and lower level on windows.



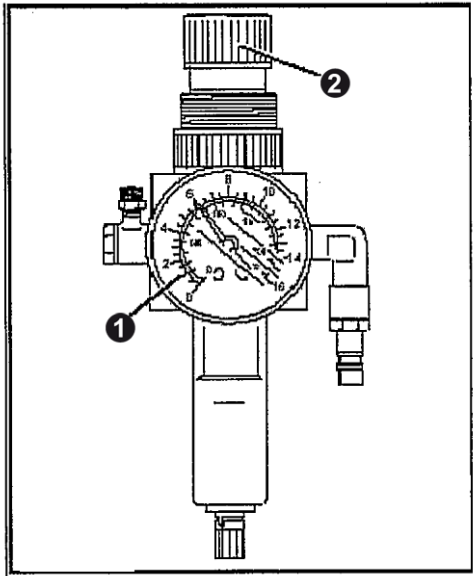
- Use only 22,0 mm<sup>2</sup>/s oil with medium center viscosity at 40°C and density of 0,865 g/cm<sup>3</sup> at 40°C!

## F - MAINTENANCE

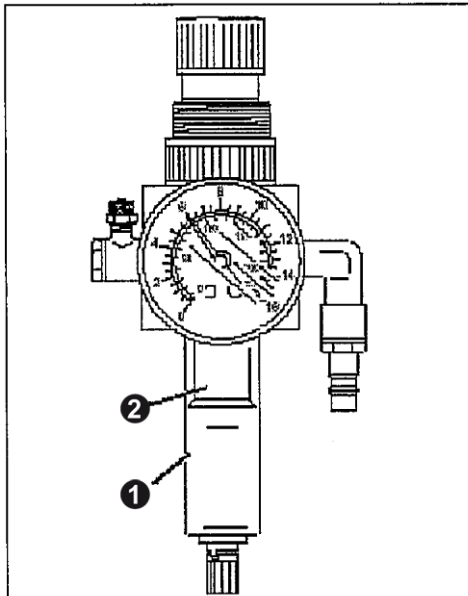
### 4. AIR PRESSURE SETTING OF MACHINE AND CLEANING PRESSURE TUBE

#### Air pressure setting of machine:

- Air pressure must be checked with manometer prior to each operation of machine.
- Manometer shall be adjusted according to air pressure of 6 bars. (Button nr. ① is pulled upwards and turned until manometer reads pressure of 6 bars and button nr. ② is pressed and fixed in place. Please see figure below).



### 5. CLEANING MAINTENANCE UNIT AIR FILTER



- Switch off the machine!
- Remove compressed air pipe on maintenance unit.
- Water container (figure nr. ①) is discharged.
- Water container nr. ① is automatically discharged after removing maintenance unit compressed air pipe.

## F - MAINTENANCE

---

### Cleaning Filter:

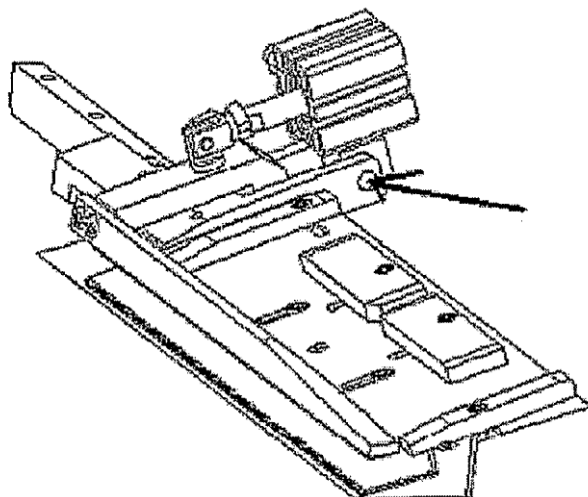
- Water container nr. ❶ is removed.
- Filter nr. ❷ is removed.
- Filter nr. ❷ is cleaned with compressed air or isopropyl alcohol.
- Filter nr. ❷ is turned and assembled and water container nr. ❶ is turned and assembled.

## F - MAINTENANCE

### 6. LUBRICATING CLAMP FEET



Clamp feet must be cleaned with air everyday and the zone indicated must be lubricated with machine oil once a week.



### 7. LUBRICATING AND CLEANING THE MECHANISMS ON SEWING MACHINE



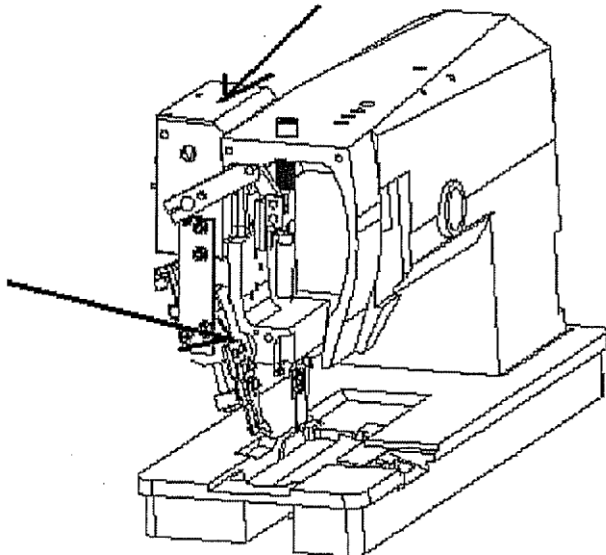
All lubricating holes on sewing machine and zones indicated with arrow must be properly wiped and cleaned once a week and must be regularly lubricated.

Zones on sewing head must also be lubricated.

Upper thread cutting equipment must also be cleaned several times per day.



Touch 'cut and hold thread' sign on pocket programs, and clean waste thread parts accumulated at the mouth of upper thread cutting mechanism.

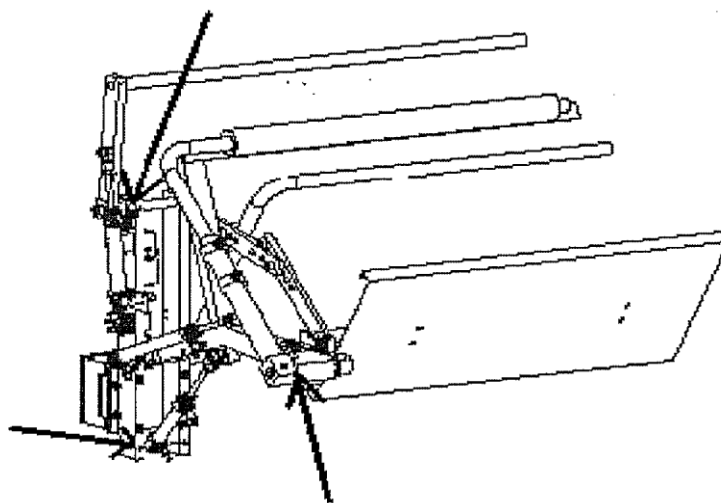


## F - MAINTENANCE

### 8. LUBRICATING ALL JOINTS AND MOVING PARTS ON STACKING MACHINE



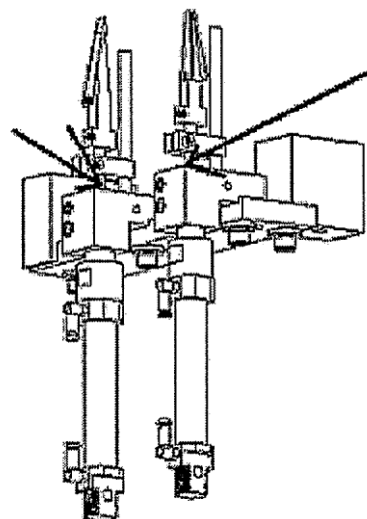
All joints and moving parts on stacking machine must be properly cleaned with air everyday and lubricated with machine oil for once a week.



### 9. LUBRICATING CORNER KNIFE MECHANISM

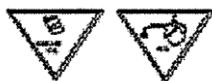
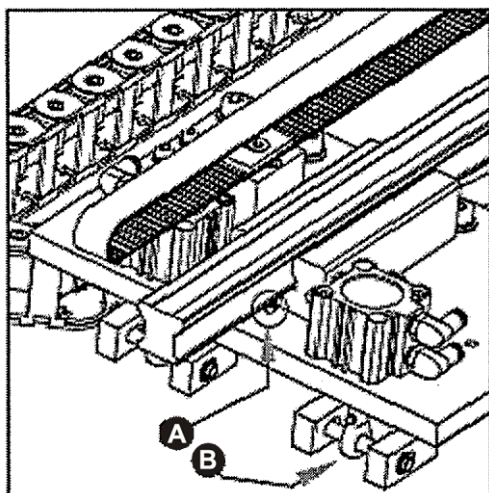


Corner knife mechanism must be cleaned with air everyday and spindles and moving parts must be lubricated with machine oil once a week.



### 10. PERIODICAL LUBRICATION OF MACHINE

#### Clamp Carrier and Clamps



**A:**

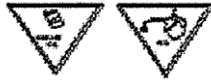
You need to make oiling in 6 month periods with grease oil.

**B:**

It is necessary first to clean and then to make normal oiling in 3 month periods.



## F - MAINTENANCE

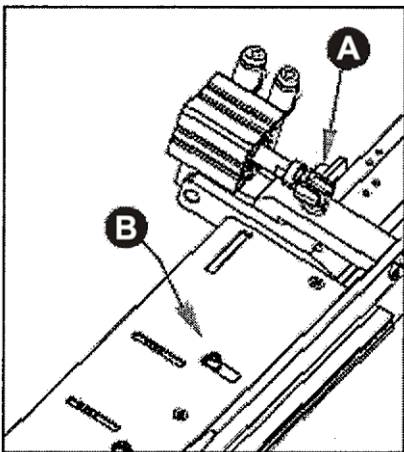
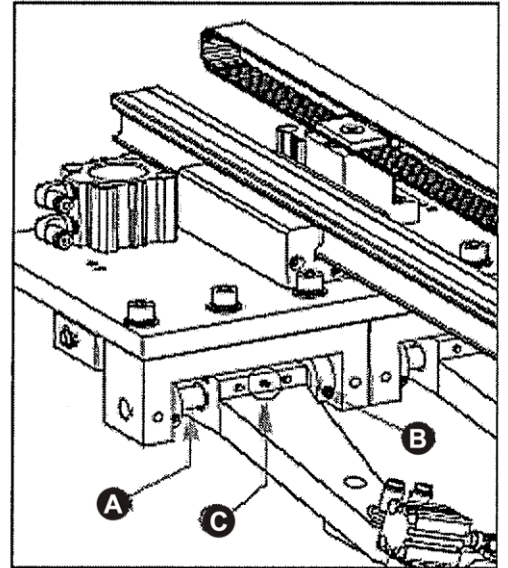


**A & B:**

It is necessary first to clean and then to make normal oiling in 3 month periods.

**C:**

You need to make oiling in 6 month periods with grease oil.



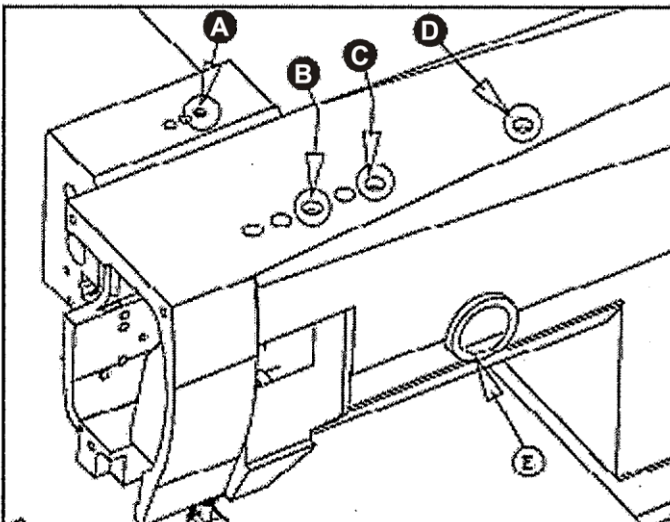
**A:**

It is necessary first to clean and then to make normal oiling in 3 month periods.

**B:**

It is necessary to continuously clean in 1 month periods and to make normal oiling in 3 month periods.

### Oil Inlets and Front of Section



**A:**

It is necessary to make oiling in 1 month periods.

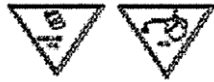
**B & C:**

It is necessary to make oiling in 3 month periods.

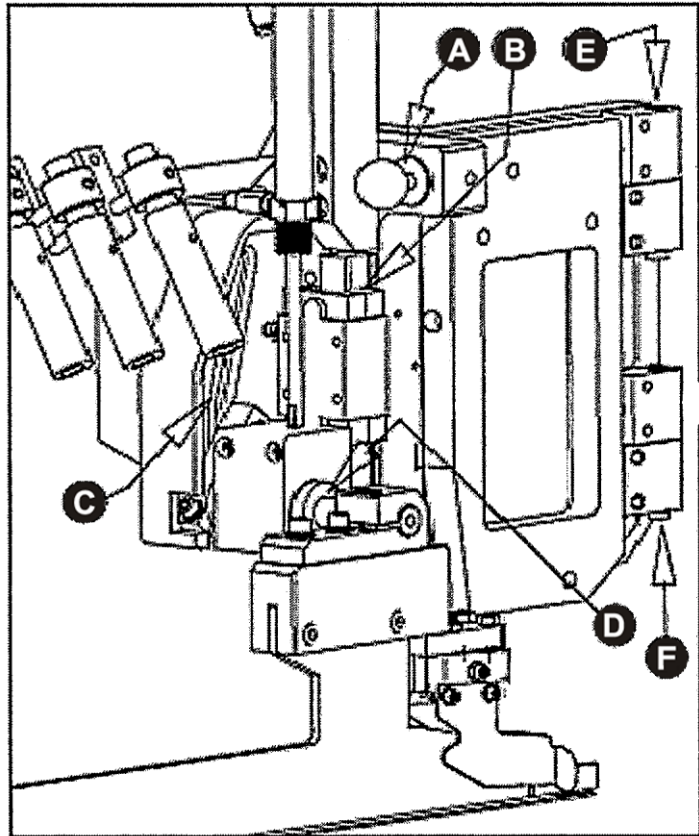
**D:**

The oilbox "E" on top of the machine head is the place I which normal oil is added. When the oil level in the Oilbox becomes lower than the minimum required level, add oil to the oilbox from the "D" point.

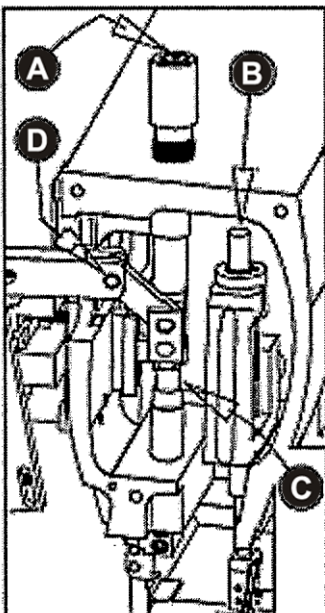
## F - MAINTENANCE



- A:**  
It is necessary to clean in 1 month periods and to make normal oiling in 3 month periods.
- B:**  
It is necessary first to clean and then to make normal oiling in 6 month periods.
- C:**  
It is necessary first to clean and then to make normal oiling in 6 month periods.
- D:**  
It is necessary first to clean and then to make normal oiling in 6 month periods.
- E & F:**  
It is necessary first to clean and then to make normal oiling in 6 month periods.



### Clamp Carrier and Clamps



- A:**  
It is necessary first to clean and then to make normal oiling in 3 month periods.
- B:**  
It is necessary first to clean and then to make normal oiling in 3 month periods.
- C:**  
It is necessary first to clean and then to make normal oiling in 3 month periods.
- D:**  
It is necessary first to clean and then to make normal oiling in 3 month periods.

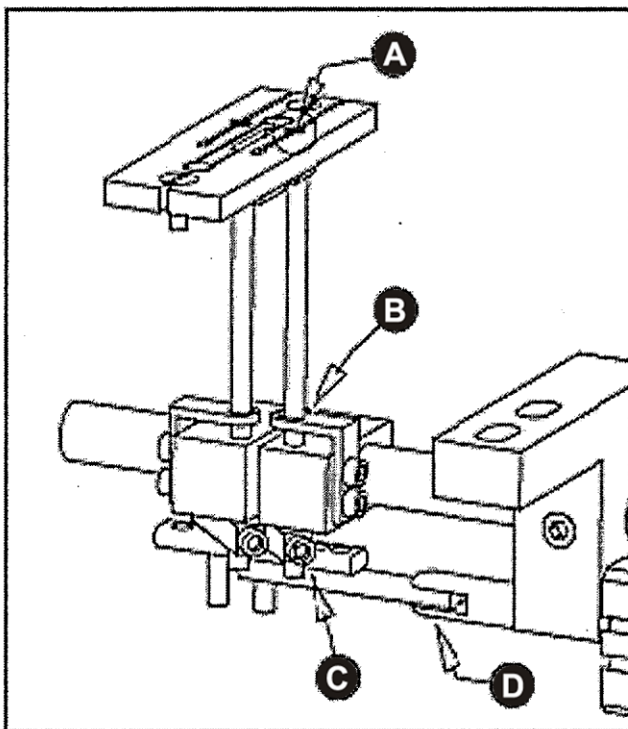
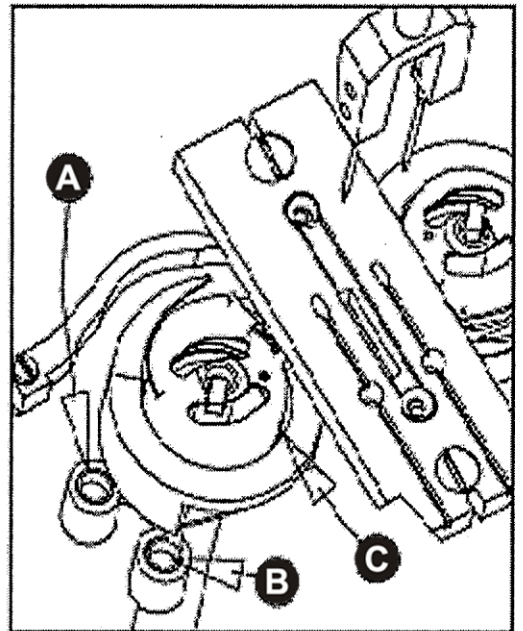
## F - MAINTENANCE

**A & B:**

It is necessary first to clean in one week periods and then to make normal oiling carefully.

**C:**

It is necessary first to clean in one week periods and then to make normal oiling carefully.



**A:**

It is necessary to clean in weekly periods carefully.

**B:**

It is necessary first to clean and then to make normal oiling in 3 month periods.

**C:**

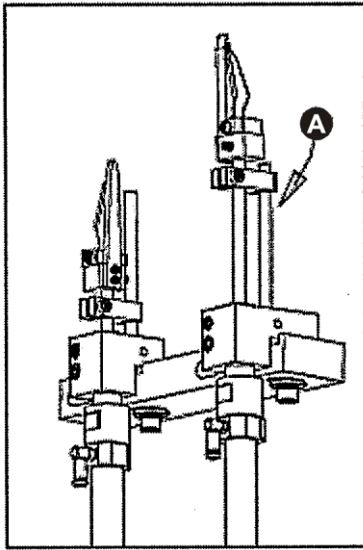
It is necessary first to clean and then to make normal oiling in 3 month periods.

**D:**

It is necessary first to clean and then to make normal oiling in 3 month periods.

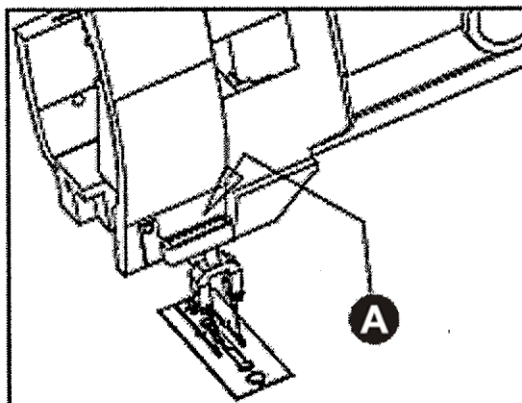
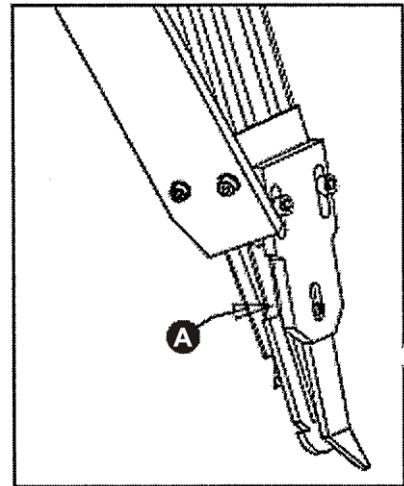
## F - MAINTENANCE

### Corner Knife, Top Thread Trimmer and Arm Thread Guide



**A:** It is necessary to clean very well in 1 month periods and then make normal oiling very carefully.

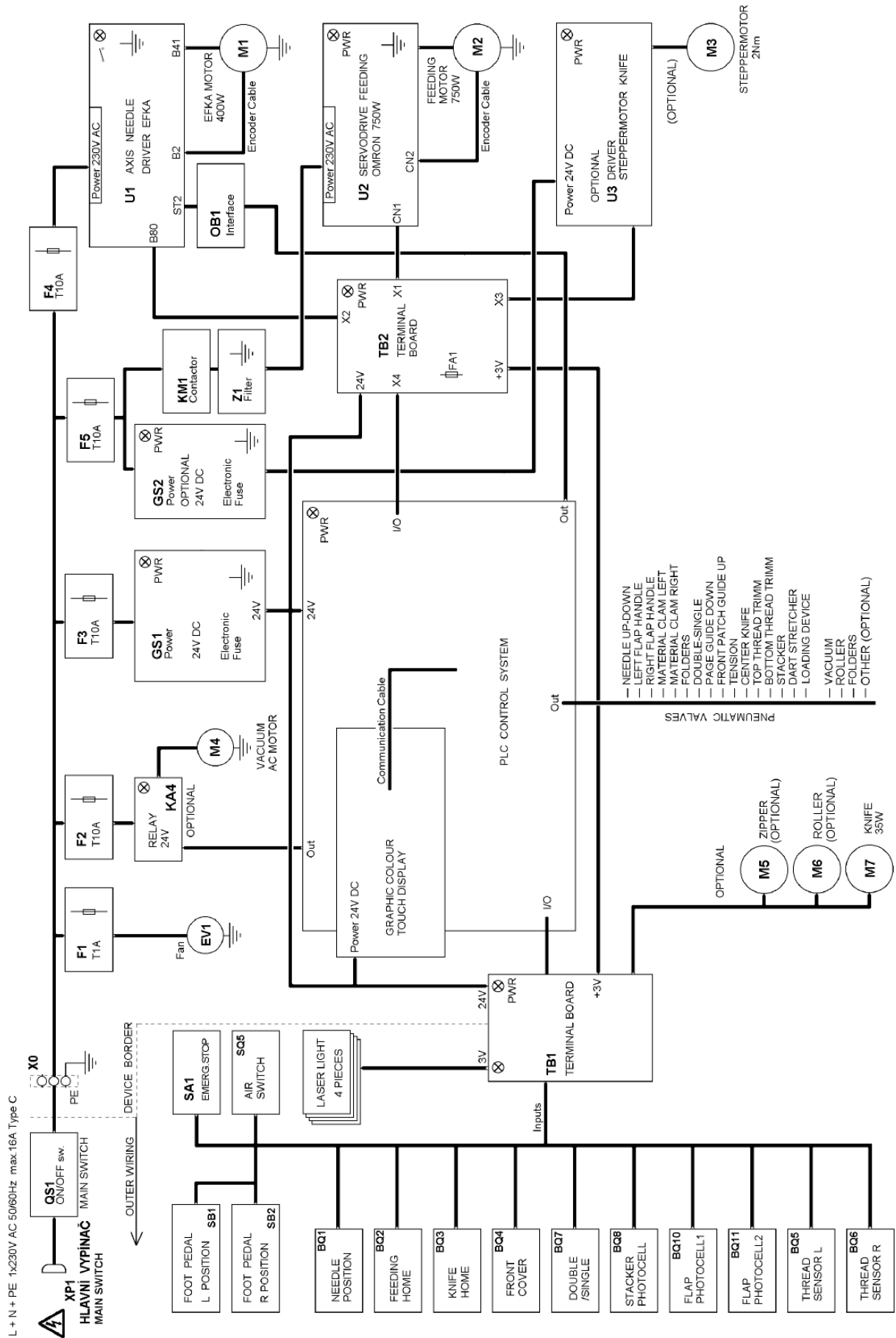
**A:** It is necessary to clean in weekly periods and to make normal oiling in 1 month periods.



**A:** You need to make oiling with special silicone oil in 1 Month periods and replace the thread bag every Month.

**G - DOCUMENTATION**

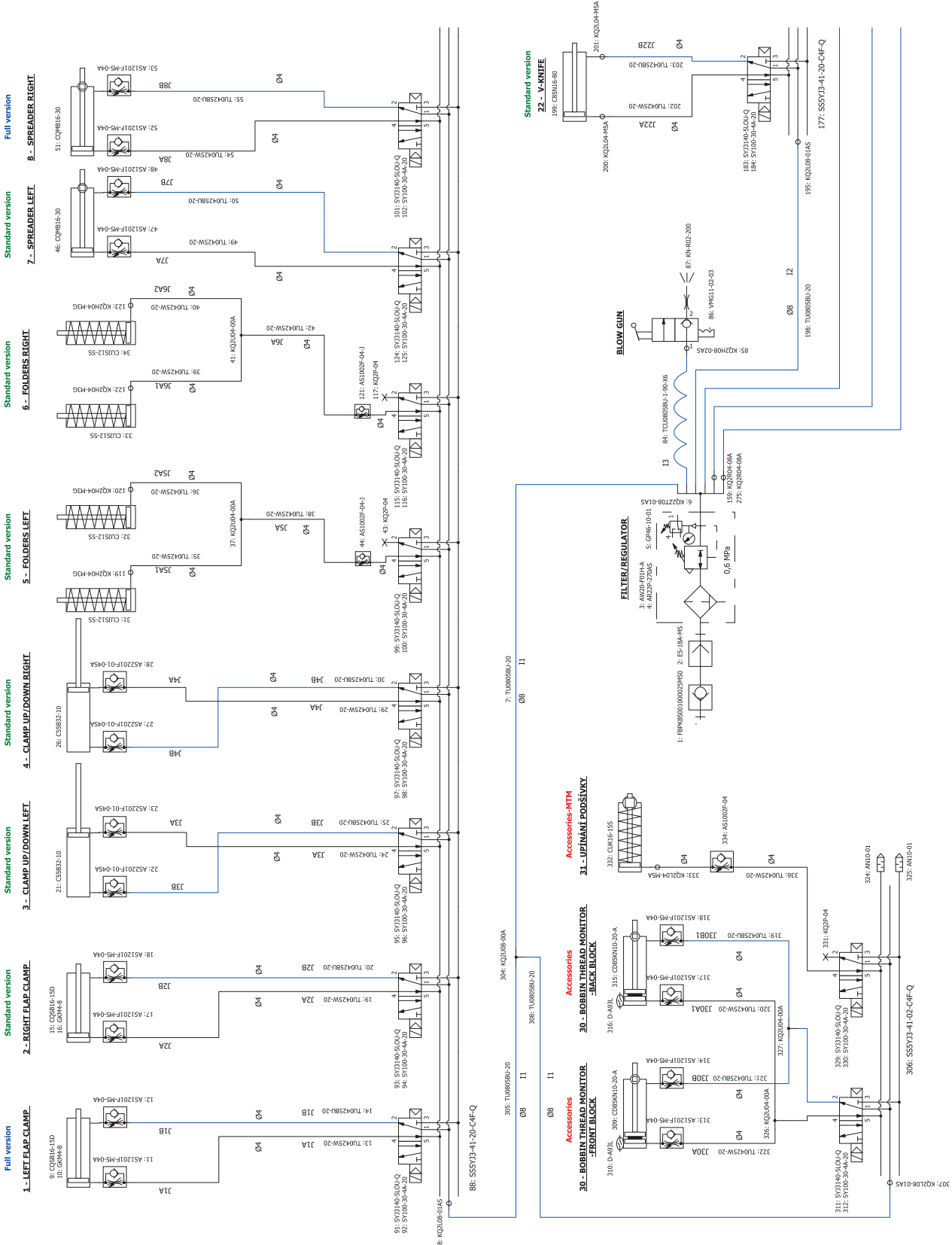
**1. ELECTRICAL DIAGRAM**



# G - DOCUMENTATION

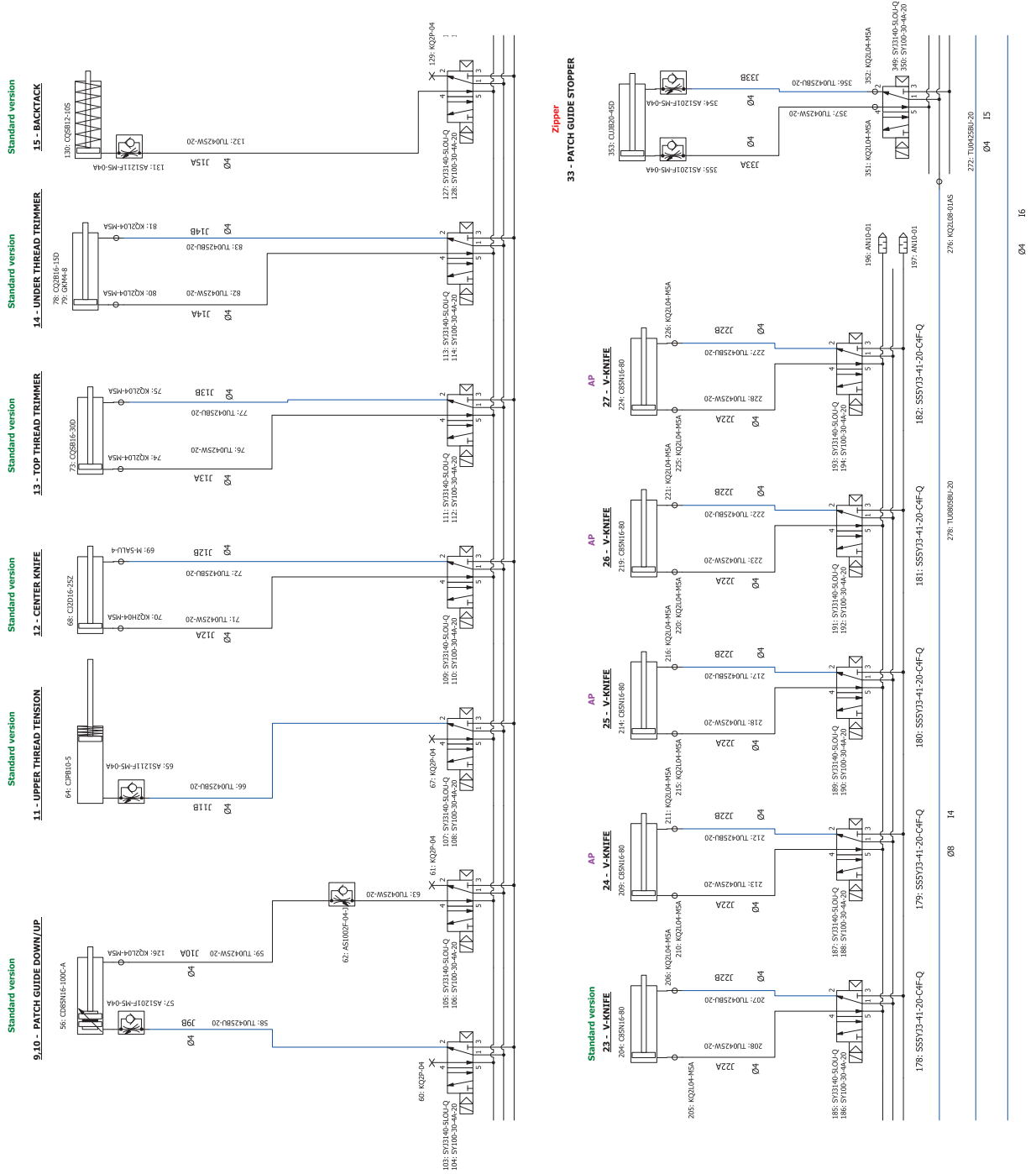
## 2. PNEUMATIC DIAGRAM

### Part 1



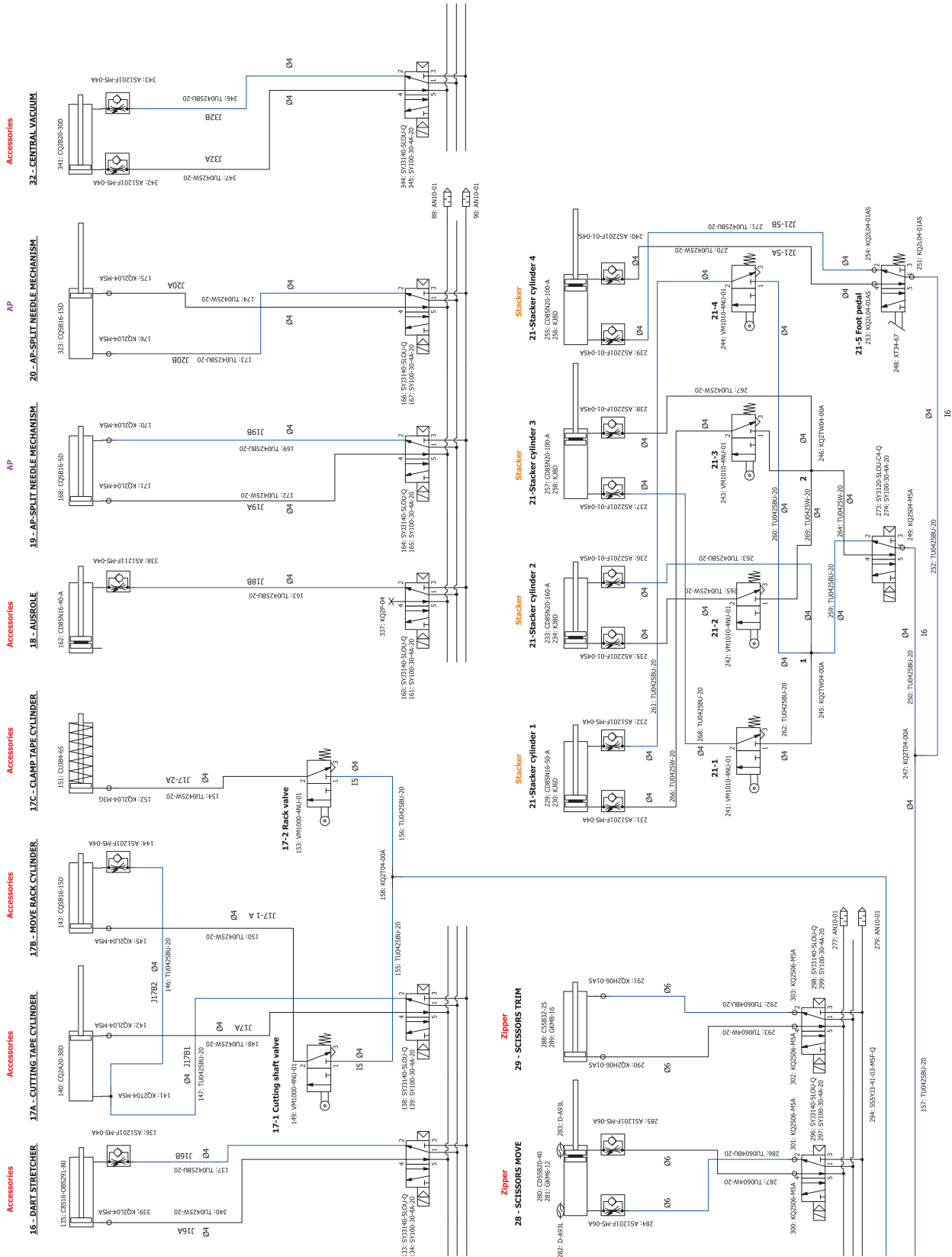
**G - DOCUMENTATION**

Part 2



G - DOCUMENTATION

Part 3





## TROUBLESHOOTING

List of faults indicated on display

<b>Error Nr.</b>	<b>Description</b>
Error 01	Machine is not in home position. Press home button to bring the machine to the home position.
Error 02	Needle is not in the upper position. Turn the handwheel to reach upper position.
Error 04	Low air pressure. Air pressure is bellow 4.0 bar. Check the air supply.
Error 07	Zipper is not in home position. Check the sensors.
Error 08	Head is opened. Close the sewing head.
Error 09	Machine is in threading mode. Press threading button or home button, please.
Error 10	Machine is in threading mode. Press threading button or home button, please.
Error 14	Servo timeout positioning error. Check servo-driver, sensor and sewing mechanisms.
Error 15	X axis timeout positioning error. Check X axis home sensor, stepper motor, driver and X axis mechanism.
Error 16	K axis timeout positioning error. Check K axis home sensor, stepper motor, driver and K axis mechanism.
Error 20	Servomotor error. Check error message on servo-driver display.
Error 25	Servo-driver recovery time. Wait please.
Error 31	Software in PLC and HMI are not compatible. Download correct software, please.
Error 40	Service knife mode.
Error 41	Checking feed mode. Press home button or Emergency stop for exit.
Error 50	Parameters of sewing are adjusted incorrectly. Change density or sewing length.
Error 55	Cycle program errorr. Make active one pocket at least.
Error 56	Parameter error. Distance between two points in material is too small. Change the distance or style of sewing.
Error 60	It is not possible to used stepper motor with AP version of machine. Please change type of pocket or knife settings.
Error 61	End of flap is not detected. Eliminate the photosensor fault and press home button.
Error 65	It is not possible to sew flap witch Zipper system. Please deselect Flap or Zipper.
Error 66	Zipper fault during trimming. Check sensors BQ17 and BQ 18 placed at solenoids.

**TROUBLESHOOTING**

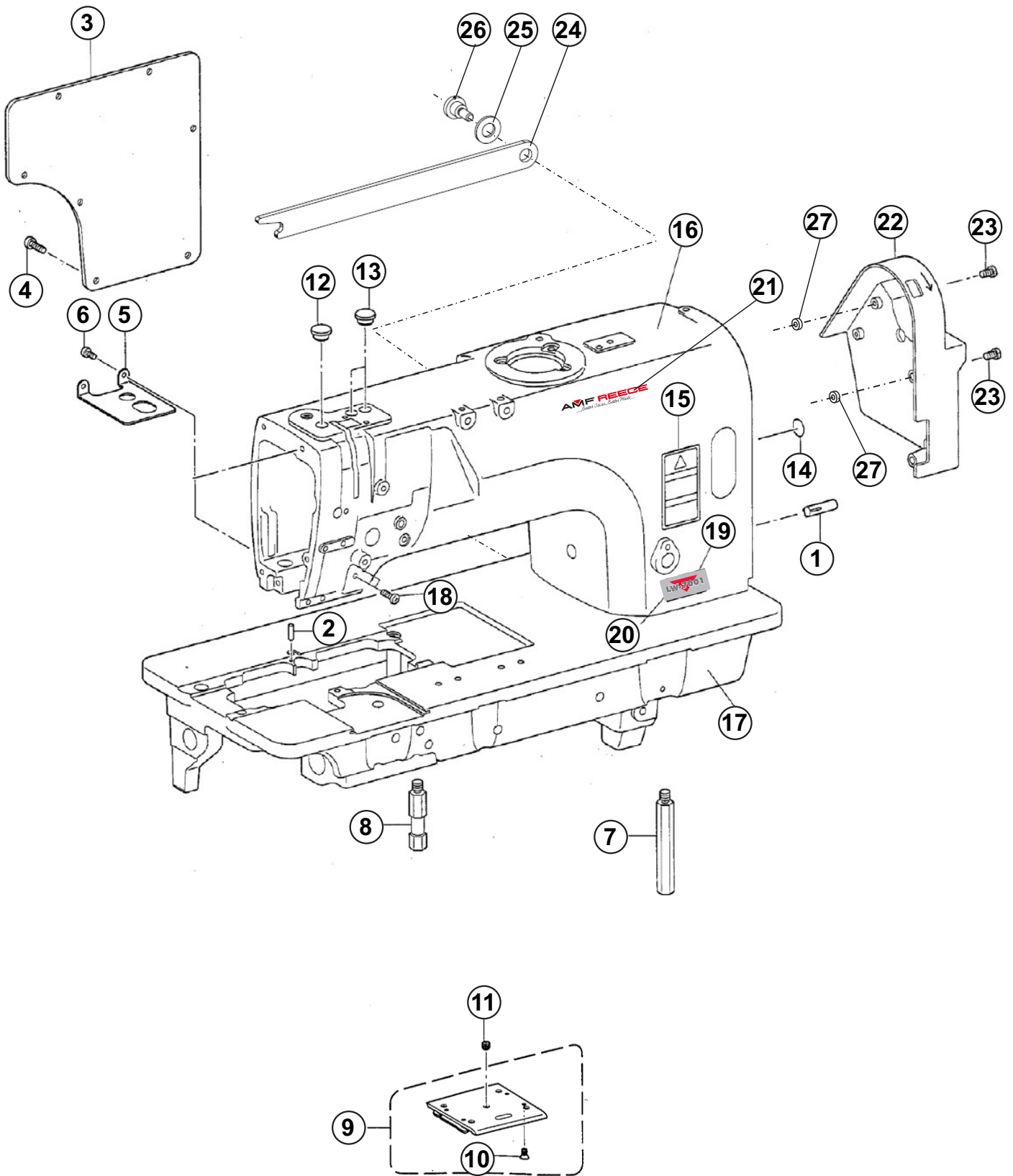
---

<b>Error Nr.</b>	<b>Description</b>
Error 70	Upper thread has been broken during sewing. Press home button or button for threading upper thread. Machine gets to ready to sew.
Error 71	Front bobbin finger is not in base position.
Error 72	Back bobbin finger is not in base position.
Error 73	Fault during checking bobbin thread. Check sensors.
	thread
Error 75	Lower thread is sewed out. Check lower bobbin.
Error 99	Emergency stop button pressed. Release the Emergency stop button, please.
Busy	

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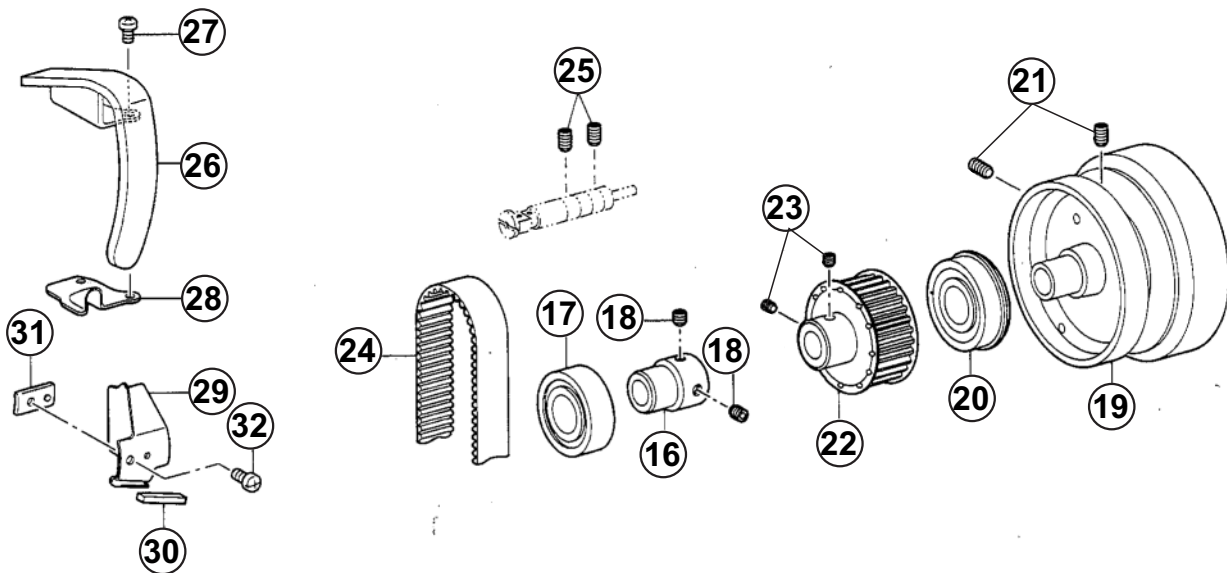
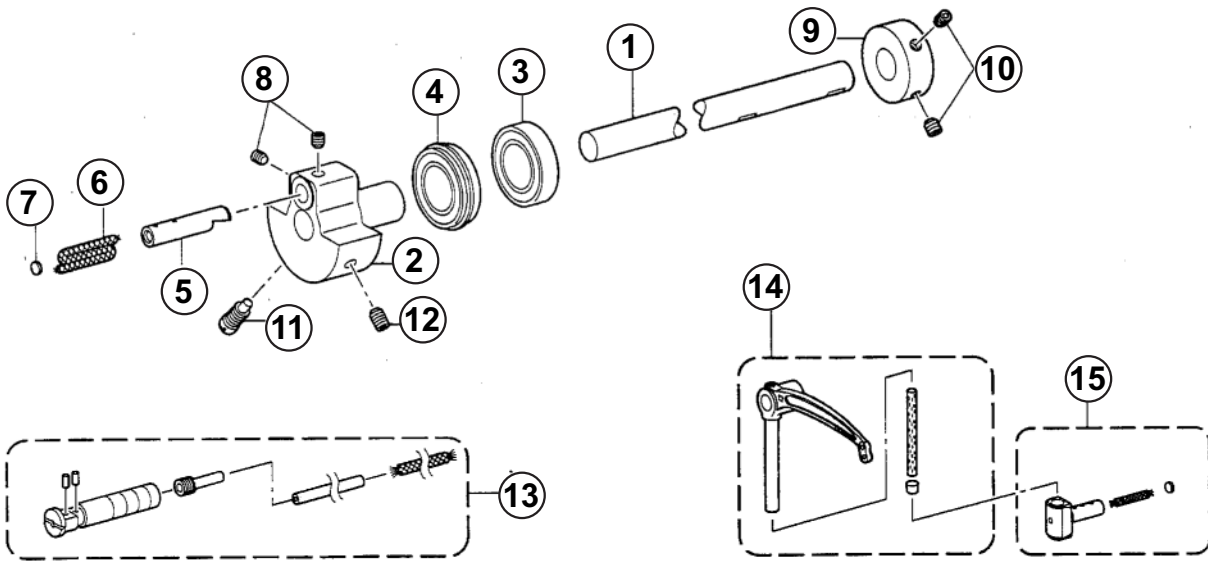
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# MACHINE BODY





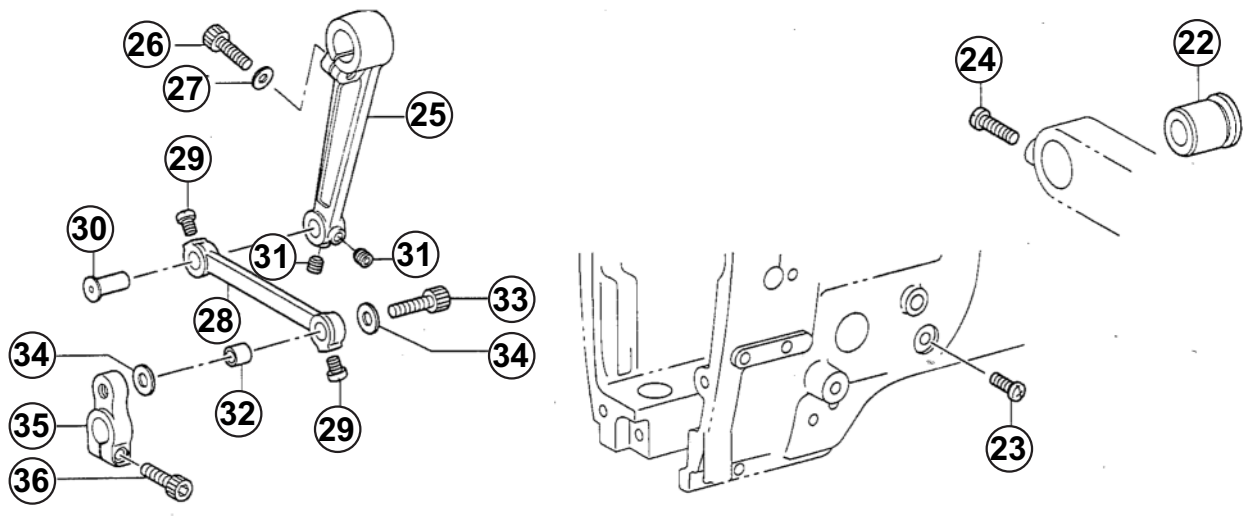
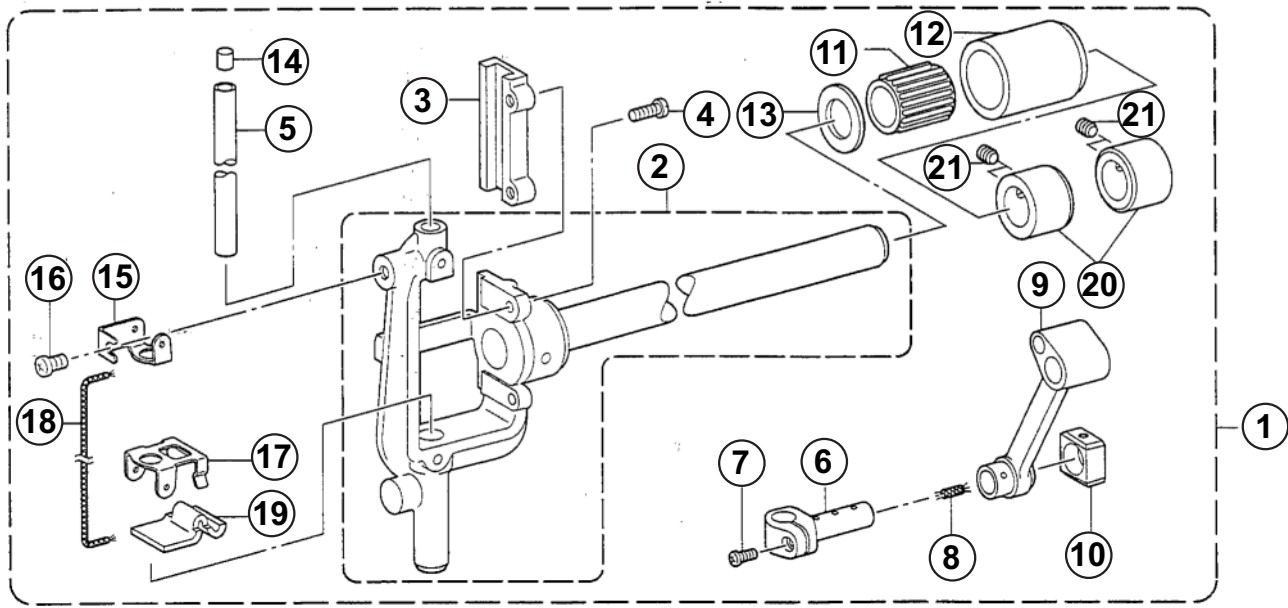
# UPPER SHAFT MECHANISM



## UPPER SHAFT MECHANISM

DET	PART NUMBER	DESCRIPTION	QTY.
01	SA2746201	UPPER SHAFT, ST	1
02	SA4089001	THREAD TAKE-UP CRANK	1
03	S25234001	BALL BEARING, 6004ZZ	1
04	S38707001	BALL BEARING, 6004ZZNR	1
05	S38398001	CRANKSHAFT, N-BAR	1
06	SA4335001	WICK, 6 x 6 (L=90)	1
07	113014000	PUSHER	1
08	S25260001	SET SCREW, SOCKET (FT) M6-0.75 x 5	2
09	SA1120001	BOBBIN WINDER DRIVING WHEEL	1
10	S23651001	SET SCREW, SOCKET (FT) M6-0.75 x 6	2
11	S25235001	SCREW, M8	1
12	S25236001	SET SCREW, SOCKET (FT) M6-0.75 x 10	1
13	SA2861001	THREAD TAKE-UP S-SHAFT UNIT	1
14	SA2935101	THREAD TAKE-UP LEVER ASSY	1
15	S13160001	T-TAKE-UP SLIDE BLOCK ASSY. 2	1
16	SA2748001	BALL BEARING BUSH	1
17	076023800	BALL BEARING	1
18	S23651001	SET SCREW, SOCKET (FT) M6-0.75 x 6	2
19	SA2750001	PULLY	1
20	158115001	BALL BEARING, 6204ZZNR	1
21	012061036	SET SCREW, SOCKET (FT) M6 x 10	2
22	SA2720001	TIMING PULLEY ASSY	1
23	SA4214001	SET SCREW, SOCKET (FT) M6-0.75 x 6	2
24	SA2463001	TIMING BELL	1
25	012061036	SET SCREW, SOCKET (FT) M6 x 10	2
26	SA2469001	THREAD TAKE-UP LEVER COVER	1
27	062500816	SCREW, PAN M5 x8	2
28	SA3057001	DUST COVER	1
29	SA3058101	SHELTER PLATE	1
30	SA3065001	FELT	1
31	SA3059001	HOLDER, SHELTER PLATE	1
32	062500816	SCREW, PAN M5 x8	1

# NEEDLE BAR ROCKING MECHANISM

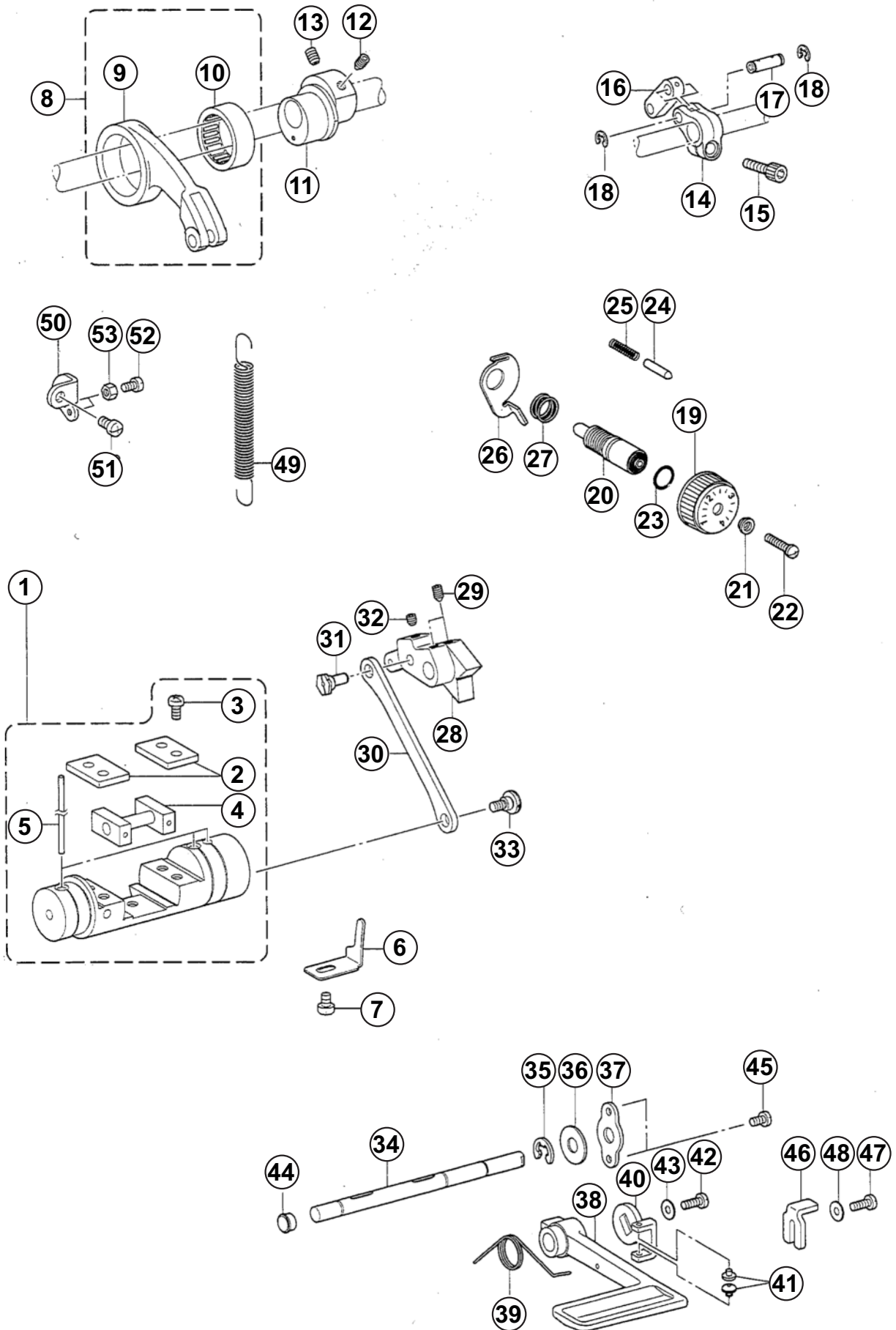




## NEEDLE BAR ROCKING MECHANISM

DET	PART NUMBER	DESCRIPTION	QTY.
01	SA4124101	NEEDLE BAR ROCKER SHAFT ASSY	1
02	SA3854001	NEEDLE BAR BASE ASSY	(1)
03	SA2474101	SLIDE BLOCK SLIDER	(1)
04	062401016	SCREW, PAN M4x10	(2)
05	SA2475001	NEEDLE BAR	(1)
06	SA3710001	NEEDLE BAR CLAMP	(1)
07	062350816	SCREW, PAN M3.5 x 8	(1)
08	112728001	WICK, L=50	(1)
09	SA3711001	CRANK ROD, N-BAR	(1)
10	SA3712001	SLIDE BLOCK	(1)
11	SA2482001	NEEDLE BEARING	(1)
12	SA2483001	CASE	(1)
13	SA2484001	WASHER, PLAIN	(1)
14	148394000	CAP, N-BAR	(1)
15	SA4007001	FELT SUPPORT	(1)
16	062500616	SCREW, PAN M5 x 6	(1)
17	SA3848001	FELT SUPPORT	(1)
18	S07465000	WICK, L=200	(1)
19	SA3852001	FELT	(1)
20	SA2485001	SET SCREW COLLAR	(2)
21	S25260001	SET SCREW, SOCKET(FT) M6-0.75 x 5	(4)
22	SA2486101	BUSH, R	1
23	062500816	SCREW, PAN M5 x 8	1
24	062061616	SCREW, PAN M6 x 16	1
25	SA2489001	NEEDLE BAR ROCKER LEVER ASSY	1
26	018062032	BOLT, SOCKET M6 x 20	1
27	118735002	WASHER	1
28	SA2490101	ROCKER LINK, N-BAR	1
29	062060816	SCREW, PAN M6 x 8	2
30	SA4117001	LINK SHAFT, N-BAR ROCKER P	1
31	012060636	SET SCREW, SOCKET (FT) M6 x 6	2
32	SA4118001	ZIGZAG LINK BUSH, P	1
33	018062532	BOLT, SOCKET M6 x 25	1
34	SA2493001	WASHER, PLAIN	2
35	SA2494001	NEEDLE BAR ROCK ARM	1
36	018062032	BOLT, SOCKET M6 x 20	1

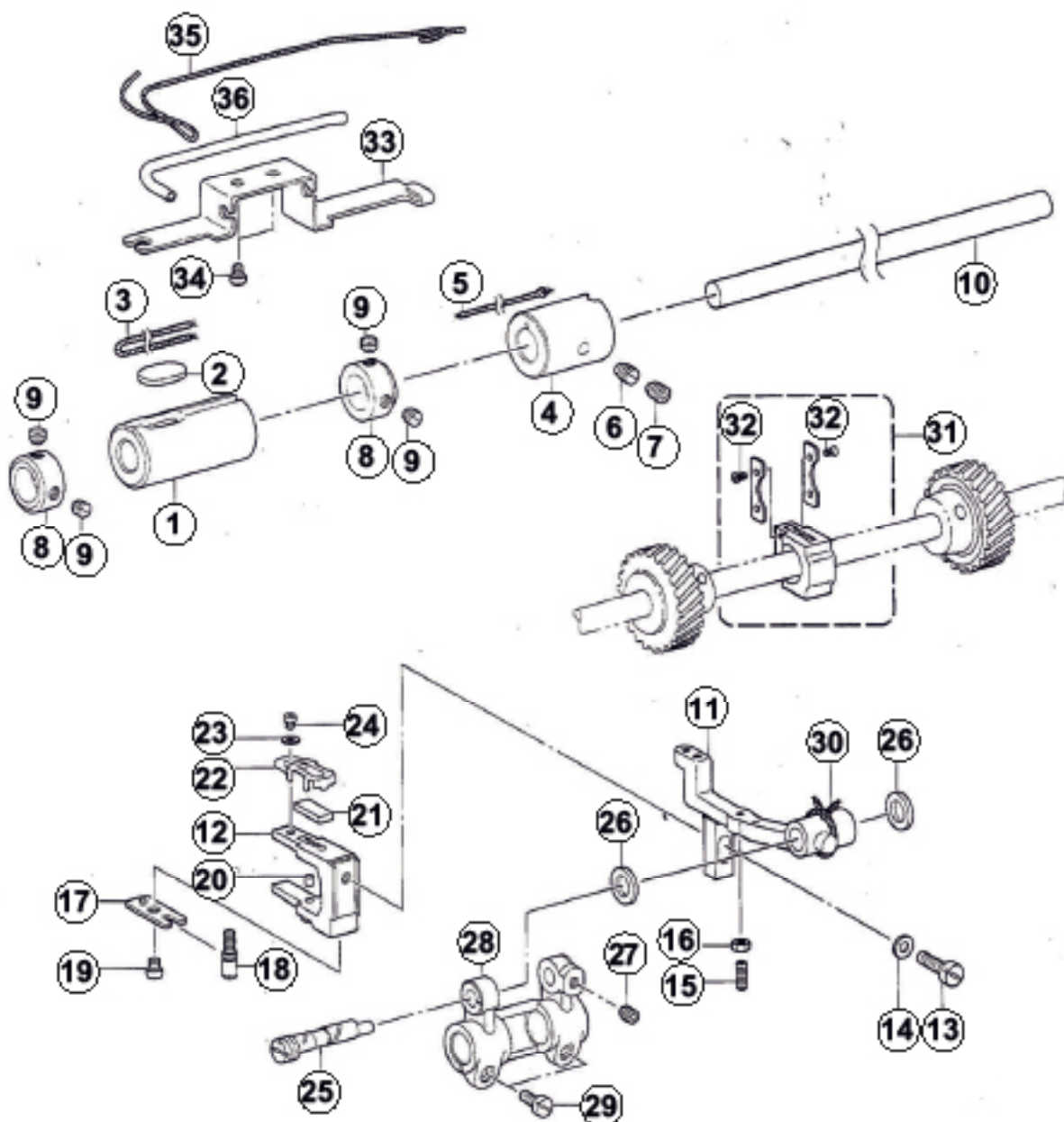
# FEED MECHANISM



## FEED MECHANISM

DET	PART NUMBER	DESCRIPTION	QTY.
01	SA3062001	FEED REGULATOR ASSY	1
02	SA2511001	GUIDE PLATE	(2)
03	062501016	SCREW, PAN M5 x 10	(4)
04	SA2512001	SLIDE BLOCK ASSY	(1)
05	SA2515001	FELT	(3)
06	SA2516001	STOPEER	1
07	062060816	SCREW, PAN M6 x 8	1
08	143611201	F-ROCKER CONNECTING ROD ASSY	1
09	143612100	FEED ROCKER CONNECTING ROD	(1)
10	118954000	NEEDLE BEARING	(1)
11	SA2518001	LEVEL FEED ECCENTRIC WHEEL	1
12	SA2585001	SET SCREW, SOCKET (FT) M6-0.75 x 10	1
13	S25236001	SET SCREW, SOCKET,(FT) M6-0.75 x 10	1
14	SA2521001	FEED ROCKER ARM	1
15	018062032	BOLT, SOCKET M6 x 20	1
16	143613051	LINK	1
17	143616001	SHAFT	1
18	048060342	RETAINING RING, 6	2
19	S38422001	STITCH LENGTH DLAL	1
20	SA3056001	FEED REGULATING STUD	1
21	142746002	FEED REGULATING SUPPORTER	1
22	129458102	SCREW, 3/16-28 x 14	1
23	108549001	O RING	1
24	S50098101	POSITIONING PIN	1
25	100328001	NOTCH SPRING	1
26	SA2523001	DLAL LOCK LEVER	1
27	S39830101	SPRING	1
28	SA2525001	FEED REGULATOR	1
29	016061031	SET SCREW, SOCKET (CN) M6 x 10	2
30	SA2526001	CONNECTING ROD	1
31	SA2527001	ECCENTRIC SHAFT	1
32	012060636	SET SCREW, SOCKET (FT) M6 x 6	1
33	SA2528101	SHOULDER SCREW, M6	1
34	SA2529101	SHAFT, R-LEVER TR	1
35	048080342	RETAINING RING, 8	1
36	025100132	WASHER, PLAIN 10	1
37	SA2530001	SPACER	1
38	S07374109	REVERSE STITCHING LEVER	1
39	SA2531001	SPRING	1
40	SA3067001	LEVER GUIDE	1
41	S48367000	RUBBER	2
42	062501216	SCREW, PAN M5 x 12	1
43	025050336	WASHER, PLAIN 5	1
44	104821001	RUBBER CAP, 10.5	1
45	062500816	SCREW, PAN M5 x 8	2
46	SA2532001	STOPPER	1
47	062501216	SCREW, PAN M5 x 12	1
48	025050236	WASHER, PLAIN 5	1
49	S07376001	FEED REGULATOR SPRING	1
50	SA2533001	SPRING HOOK	1
51	062060816	SCREW, PAN M6 x 8	1
52	062501216	SCREW, PAN M5 x 12	1
53	021500106	NUT, M5	1

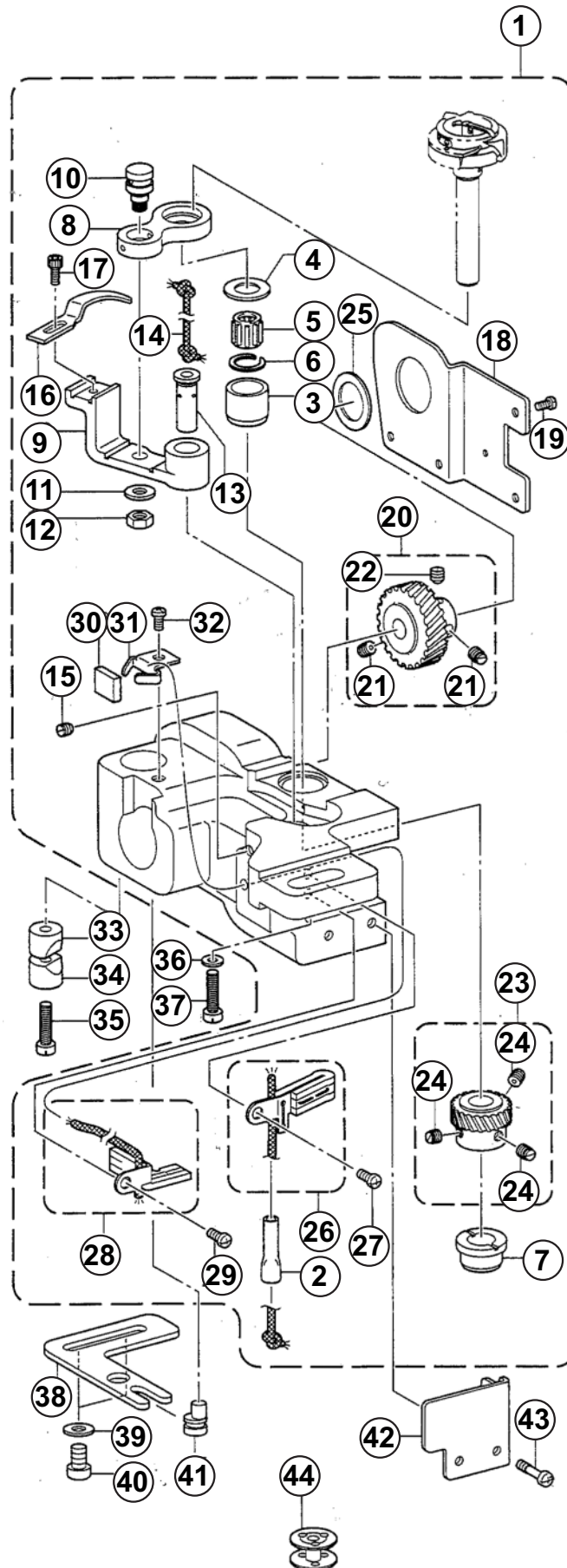
## FEED SHAFT MECHANISM



# FEED SHAFT MECHANISM

DET	PART NUMBER	DESCRIPTION	QTY.
01	SA3855001	BUSH, L:F-ROCKER SHAFT	1
02	SA3965001	FELT	1
03	SA4028001	WICK, 4 x 4 L=220	1
04	SA2543001	FEED ROCKER SHAFT BUSH, R	1
05	108802001	WICK, 4 x 4 L=250	1
06	SA2544001	SET SCREW M6	1
07	012060636	SET SCREW, SOCKET (FT) M6 x 6	1
08	SA2546001	SET SCREW COLLAR	2
09	S23651001	SET SCREW, SOCKET (FT) M6-0.75 x 6	4
10	SA3840001	FEED ROCKER SHAFT	1
11	SA3864001	FEED BAR, ST	1
12	SA3886001	FEED BAR FORK	1
13	SA2927001	SCREW, M6 x 14	1
14	025060132	WASHER , PLAIN 6	1
15	SA2566001	SET SCREW, M3.5 x 12	1
16	021350106	NUT, M3.5	1
17	SA2553001	FORKED PLATE	1
18	SA2554001	ADJUSTING SCREW, HIGHT M4	1
19	062400616	SCREW, PAN M4 x6	1
20	SA3990001	FELT	1
21	SA3887001	FELT	1
22	SA3888001	FELT HOLDER	1
23	1025030132	WASHER, PLAIN 3	1
24	062300612	SCREW, PAN M3 x 5	1
25	SA2550001	FEED BAR SHAFT	1
26	SA2551001	THRUST RING	2
27	012060636	SET SCREW, SOCKET (FT) M6 x 6	1
28	SA2555001	FEED ROCKER BASE ARM	1
29	SA2928001	SCREW, M5 x 12	2
30	SA4025001	WICK, 4 x 4 L=180	1
31	SA2806001	FEED BAR SLIDE BLOCK ASSY	1
32	W01519001	SCREW, FLAT M2 x 4	(4)
33	SA4009001	WICK SUPPORT	1
34	062400616	SCREW, PAN M4 x 6	2
35	SA2724001	WICK, L=400	1
36	SA4011001	OIL TUBE, L=100	1

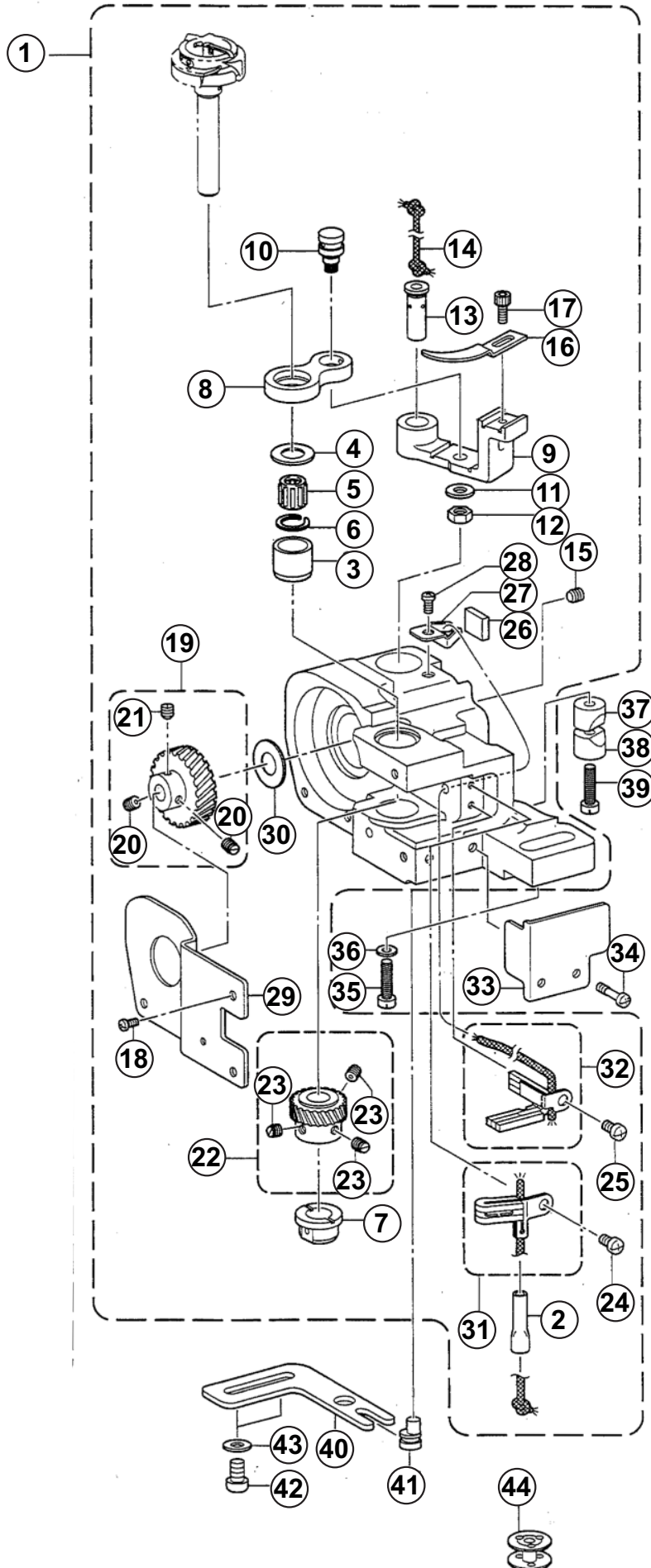
# ROTARY HOOK MECHANISM - LEFT



## ROTARY HOOK MECHANISM - LEFT

DET	PART NUMBER	DESCRIPTION	QTY.
01	SA2755101	ROTARY HOOK BASE ASSY, 842ST (L)	1
02	SA3961001	PIPE	(1)
03	SA4029001	ROTARY HOOK SHAFT BUSH	(1)
04	S09260001	THRUST RING 1.2	(1)
04	SA4038001	THRUST RING 1.0	(1)
04	S09261001	THRUST RING 1.4	(1)
04	SA4444001	THRUST RING 0.8	(1)
05	S07420000	NEEDLE BEARING	(1)
06	S07419001	RETAINING RING	(1)
07	SA2557001	ROTARY HOOK SHAFT BUSH,D	(1)
08	SA3856001	OPENER LINK	(1)
09	SA3859001	OPENER LEVER	(1)
10	SA2560001	SHAFT, 0-LINK	(1)
11	25710132	WASHER, PLAIN 4.76	(1)
12	21500316	NUT, M5	(1)
13	SA3889101	0-LEVER SHAFT	(1)
14	SA4026001	WICK, 4 x 4 L=100	(1)
15	12500536	SET SCREW, SOCKET (FT) M5 x 5	(1)
16	S38212001	OPENER	(1)
17	154965001	BOLT, SOCKET 9/64-40 x 8	(1)
18	SA2562101	ROTARY HOOK BASE COVER, L	(1)
19	62300612	SCREW, PAN M3 x 5	(4)
20	SA4549001	SPIRAL GEAR SCREW ASSY	(1)
21	SA2574001	SET SCREW, (FT) M6-0.75 x 5	((2))
22	SA2575001	SET SCREW, (FT) M6-0.75 x 5.7	((1))
23	SA2576001	PINION GEAR SCREW ASSY	(1)
24	SA2574001	SET SCREW, (FT) M6-7.5 x 5	((3))
25	SA3054001	THRUST WASHER	(1)
26	SA4042001	FELT UL ASSY	(1)
27	62400616	SCREW, PAN M4 x 6	(1)
28	SA4044001	FELT DL ASSY	(1)
29	62400616	SCREW, PAN M4 x 6	(1)
30	SA4012001	FELT	(1)
31	SA3894001	FELT SUPPORT	(1)
32	62400616	SCREW, PAN M4 x 6	(1)
33	SA2722001	PINCH SLEEVE A	2
34	SA2565001	PINCH SLEEVE B	2
35	SA2556001	SCREW, M6 x 25	2
36	115947001	WASHER, PLAIN 6.35	2
37	SA2556001	SCREW, M3 x 25	2
38	SA2567001	NEEDLE UPPER POSITIONING PLATE	2
39	025060136	WASHER, PLAIN 6	4
40	062061016	SCREW, PAN M6 x 10	4
41	SA2568001	NEEDLE UPPER POSITIONING SHAFT	2
42	SA3988001	ROTARY HOOK BASE COVER, FL	1
43	SA2825001	SCREW, M3 x 12	4
44	S01928151	BOBBIN	2

# ROTARY HOOK MECHANISM - RIGHT

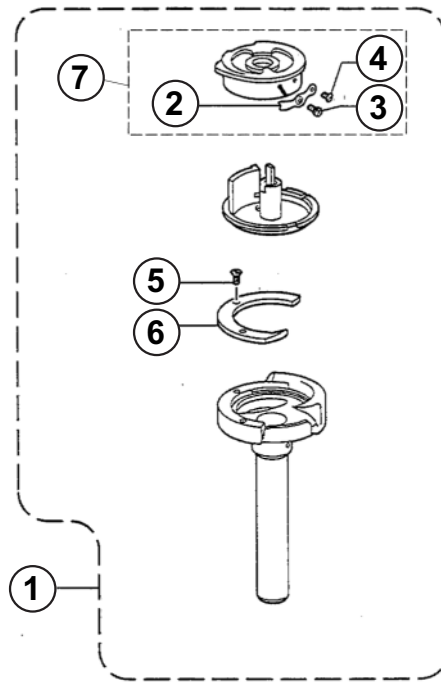




## ROTARY HOOK MECHANISM - RIGHT

DET	PART NUMBER	DESCRIPTION	QTY.
01	SA2757201	ROTARY HOOK BASE ASSY, 842S(R)	1
02	SA3961001	PIPE	(1)
03	SA4029001	ROTARY HOOK SHAFT BUSH	(1)
04	S09260001	THRUST RING 1.2	(1)
04	SA4038001	THRUST RING 1.0	(1)
04	S09261001	THRUST RING 1.4	(1)
04	SA4444001	THRUST RING 0.8	(1)
05	S07420000	NEEDLE BEARING	(1)
06	S07419001	RETAINING RING	(1)
07	SA2557001	ROTARY HOOK SHAFT BUSH, D	(1)
08	SA3856001	OPENER LINK	(1)
09	SA3859001	OPENER LEVER	(1)
10	SA2560001	SHAFT, 0-LINK	(1)
11	25710132	WASHER, PLAIN 4.76	(1)
12	21500316	NUT, M5	(1)
13	SA3889101	0-LEVER SHAFT	(1)
14	SA4026001	WICK, 4 x 4 L=100	(1)
15	12500536	SET SCREW, SOCKET (FT) M5 x 5	(1)
16	S38212001	OPENER	(1)
17	154965001	BOLT, SOCKET 9/64-40 x 8	(1)
18	62300612	SCREW, PAN M3 x 5	(4)
19	SA4549001	SPIRAL GEAR SCREW ASSY	(1)
20	SA2574001	SET SCREW, (FT) M6-0.75 x 5	((2))
21	SA2575001	SET SCREW, (FT) M6-0.75 x 5.7	((1))
22	SA2576001	PINION GEAR SCREW ASSY	(1)
23	SA2574001	SET SCREW, (FT) M6-0.75 x 5	((3))
24	062400616	SCREW, PAN M4 x 6	(1)
25	062400616	SCREW, PAN M4 x 6	(1)
26	SA4012001	FELT	(1)
27	SA3894001	FELT SUPPORT	(1)
28	062400616	SCREW, PAN M4 x 6	(1)
29	SA2563101	ROTARY HOOK BASE COVER, R	(1)
30	SA2579001	SPECER	(1)
31	SA4043001	FELT UR ASSY	(1)
32	SA4045001	FELT DR ASSY	(1)
33	SA3916001	ROTARY HOOK BASE COVER, FR	1
34	SA2825001	SCREW, M3 x 12	4
35	SA2556001	SCREW, M3 x 25	2
36	115947001	WASHER, PLAIN 6.35	2
37	SA2722001	PINCH SLEEVE A	2
38	SA2565001	PINCH SLEEVE B	2
39	SA2556001	SCREW, M6 x 25	2
40	SA2567001	NEEDLE UPPER POSITIONING PLATE	2
41	SA2568001	NEEDLE UPPER POSITIONING SHAFT	2
42	062061016	SCREW, PAN M6 x 10	4
43	025060136	WASHER, PLAIN 6	4
44	S01928151	BOBBIN	2

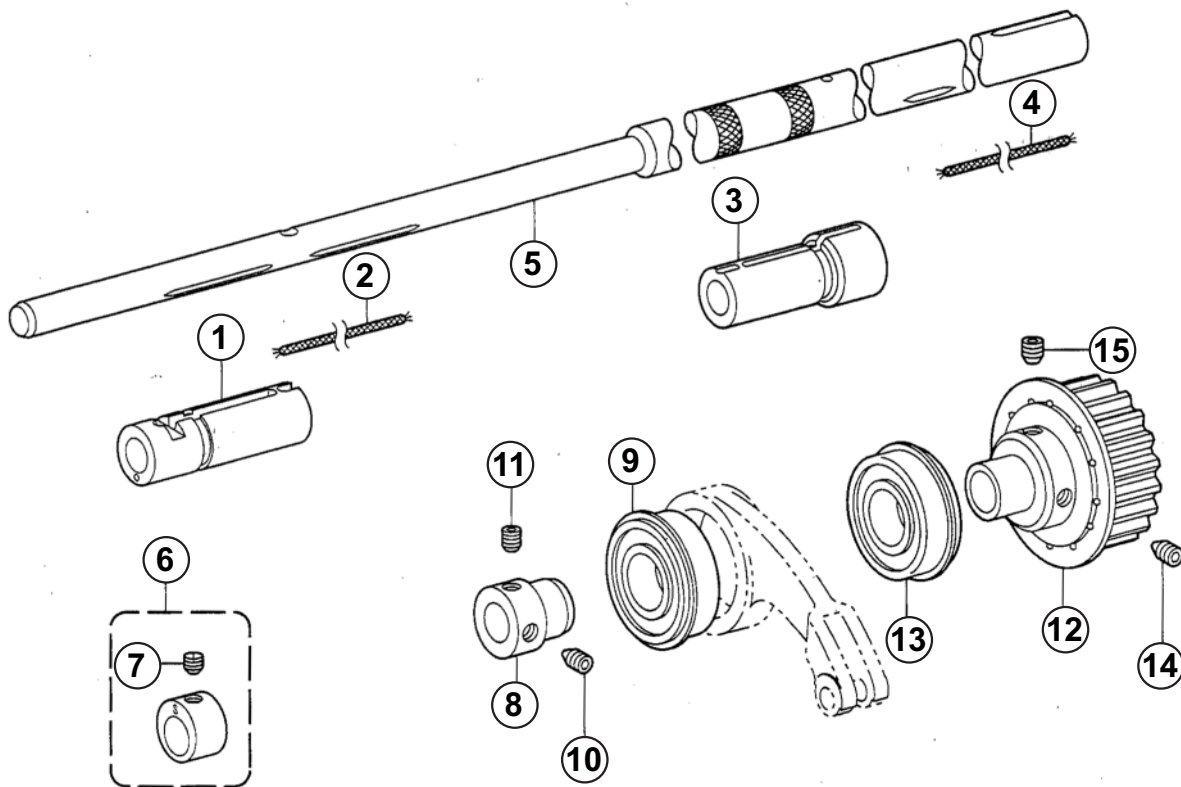
# ROTARY HOOK MECHANISM



**ROTARY HOOK MECHANISM**

<b>DET</b>	<b>PART NUMBER</b>	<b>DESCRIPTION</b>	<b>QTY.</b>
01	SA1668111	ROTARY HOOK ASSY	1
02	154518001	TENSION SPRING	((1))
03	154519001	TENSION ADJUSTING SCREW	((1))
04	151030001	SET SCREW	((1))
05	151027001	SET SCREW	(2)
06	S07746001	INNER ROTARY HOOK HOLDER	(1)
07	S07740-001	BOBBIN CASE ASSY	(1)

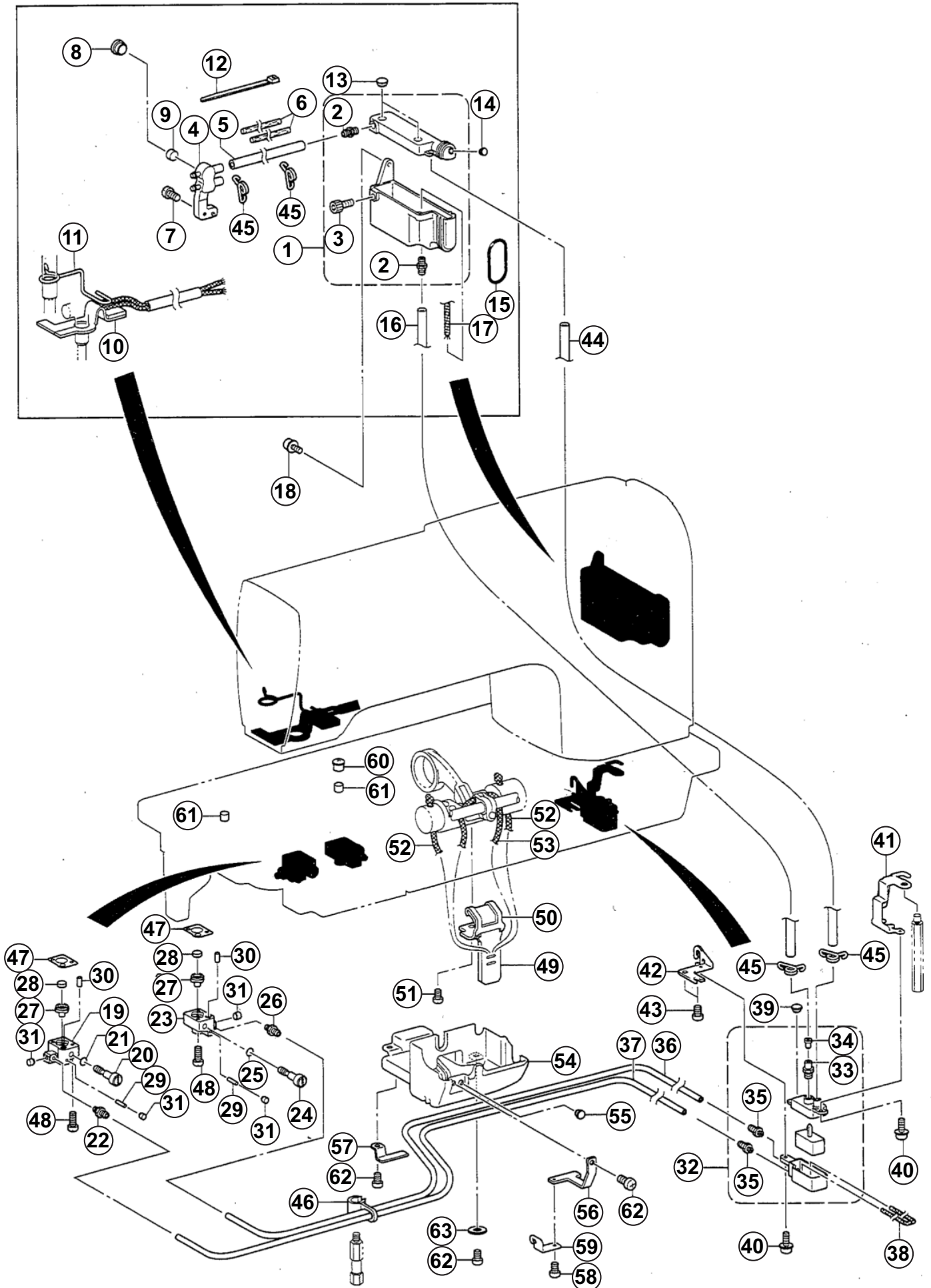
# LOWER SHAFT MECHANISM



## LOWER SHAFT MECHANISM

DET	PART NUMBER	DESCRIPTION	QTY.
01	SA3890001	ROTARY HOOK BASE BUSH, L	1
02	S38481000	WICK, L=41	1
03	SA3891001	ROTARY HOOK BASE BUSH, R	1
04	S38481000	WICK, L=41	1
05	SA2571001	LOWER SHASFT	1
06	SA2759001	F-LIFTING ECCENTRIC WHEEL ASSY	1
07	SA2575001	SET SCREW, (FT) M6-0/5 x 5.7	(1)
08	SA2584001	BALL BEARING BUSH	1
09	072600480	BALL BEARING, THRUST 6004ZZ	1
10	SA2585001	SET SCREW, SOCKET (FT) M6-0.75 x 10	1
11	S25236001	SET SCREW, SOCKET (FT) M6-0.75 x 10	1
12	SA2587001	TIMING PULLEY ASSY	1
13	158115001	BALL BEARING, 6204ZZNR	1
14	SA2585001	SET SCREW, SOCKET (FT) M6-0.75 x 10	1
15	SA4213001	SET SCREW, SOCKET (CP) M6-0.75 x 10	1

# LUBRICATION

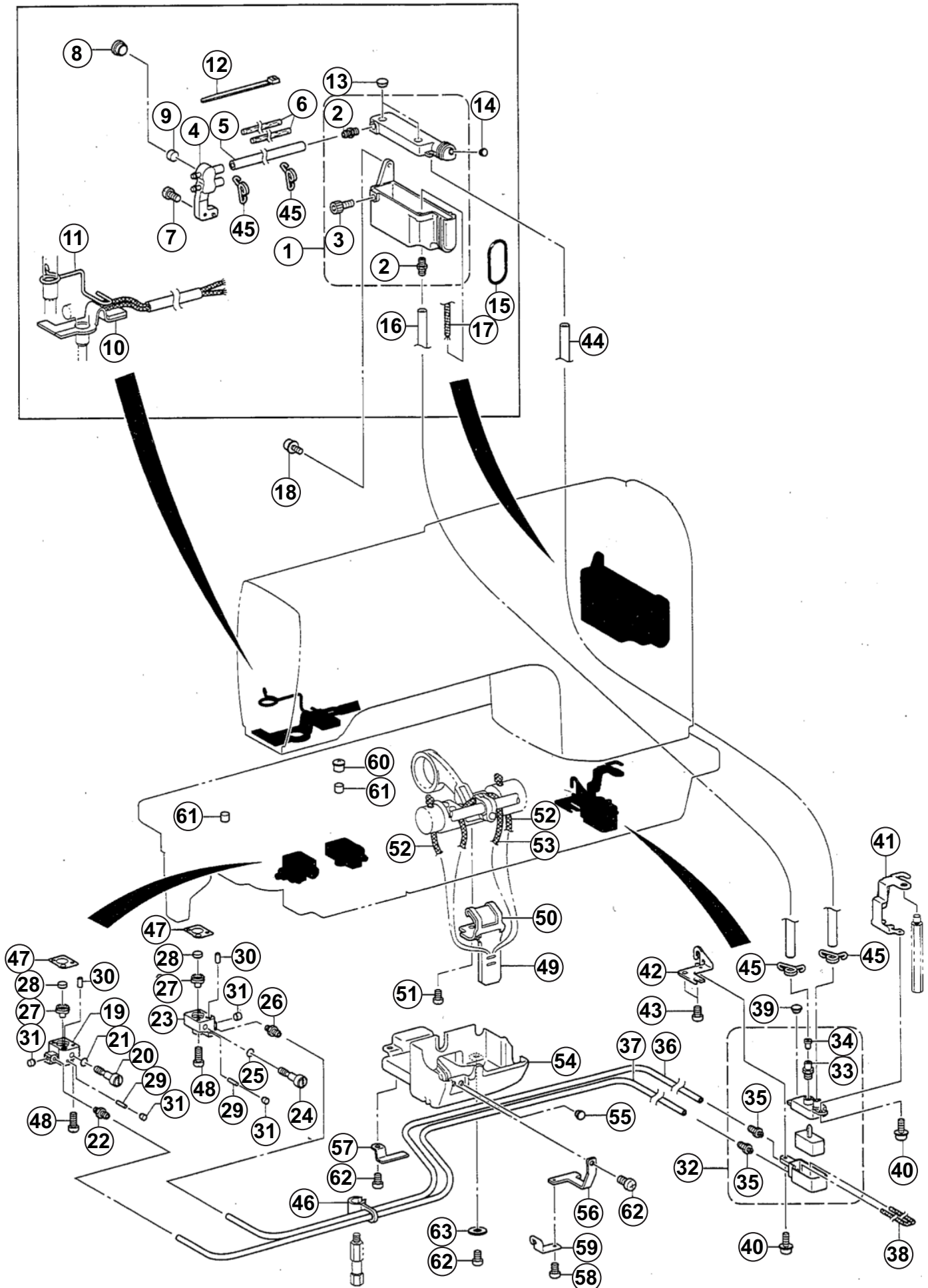


## LUBRICATION

DET	PART NUMBER	DESCRIPTION	QTY.
01	SA4205001	OIL TANK ASSY	1
02	S51815001	OIL FEEDING PIPE, 8.6	(2)
03	18081236	BOLT, SOCKET M8 x 12	(1)
04	SA3946001	OIL TERMINAL	1
05	SA2956001	OIL TUBE, L=135	1
06	SA2957001	FELT	2
07	62500816	SCREW, PAN M5 x 8	1
08	SA2929001	RUBBER CAP, 12.5	1
09	S38266000	ROTARY HOOK SHAFT FELT	1
10	SA4215001	FELT ASSY	1
11	SA4033001	FELT SUPPORT	1
12	228475000	FASTENING BAND 1.9 x 80	1
13	SA2929001	RUBBER CAP, 12.5	2
14	104450101	RUBBER CAP, 8	1
15	81038070	O RING 38	1
16	SA2723001	OIL TUBE, L=210	1
17	SA2724001	WICK, L=400	1
18	0A5501006	SCREW, PAN (S/P WASHER) M5 x 10	2
19	SA3896001	OIL BLOCK, L	1
20	SA2599001	OIL ADJUSTING SCREW M6-0.75	1
21	81004070	O RING 4	1
22	SA3147001	OIL FEEDING PIPE 2.5	1
23	SA3898001	OIL BLOCK, R	1
24	SA2599001	OIL ADJUSTING SCREW M6-0.75	1
25	81004070	O RING 4	1
26	SA3147001	OIL FEEDING PIPE 2.5	1
27	SA3061001	RUBBER PACKING	2
28	SA2727101	ROTARY HOOK SHAFT FELT	2
29	S05246000	FELT	2
30	148743001	FELT	2
31	142274101	RUBBER CAP, 4.2	4
32	SA3037001	SUB-TANK ASSY	1
33	SA3040001	OIL FEEDING PIPE	1
34	SA3060001	VALVE PACKING	1
35	SA3147001	OIL FEEDING PIPE 2.5	2
36	SA2596001	OIL TUBE, L=400	1
37	SA2597001	OIL TUBE, L=500	1
38	SA2598001	WICK, L=1100	1
39	104450101	RUBBER CAP, 8	1
40	0A4400806	SCREW, PAN (S/P WASHER) M4 x 8	2
41	SA3045101	SUB-TANK SETTING PLATE, A	1
42	SA3046001	SUB-TANK SETTING PLATE, B	1
43	62060816	SCREW, PAN M6 x 8	2
44	SA3044001	OIL TUBE, L=242	1
45	SA3055101	TUBE CLIP	4



# LUBRICATION



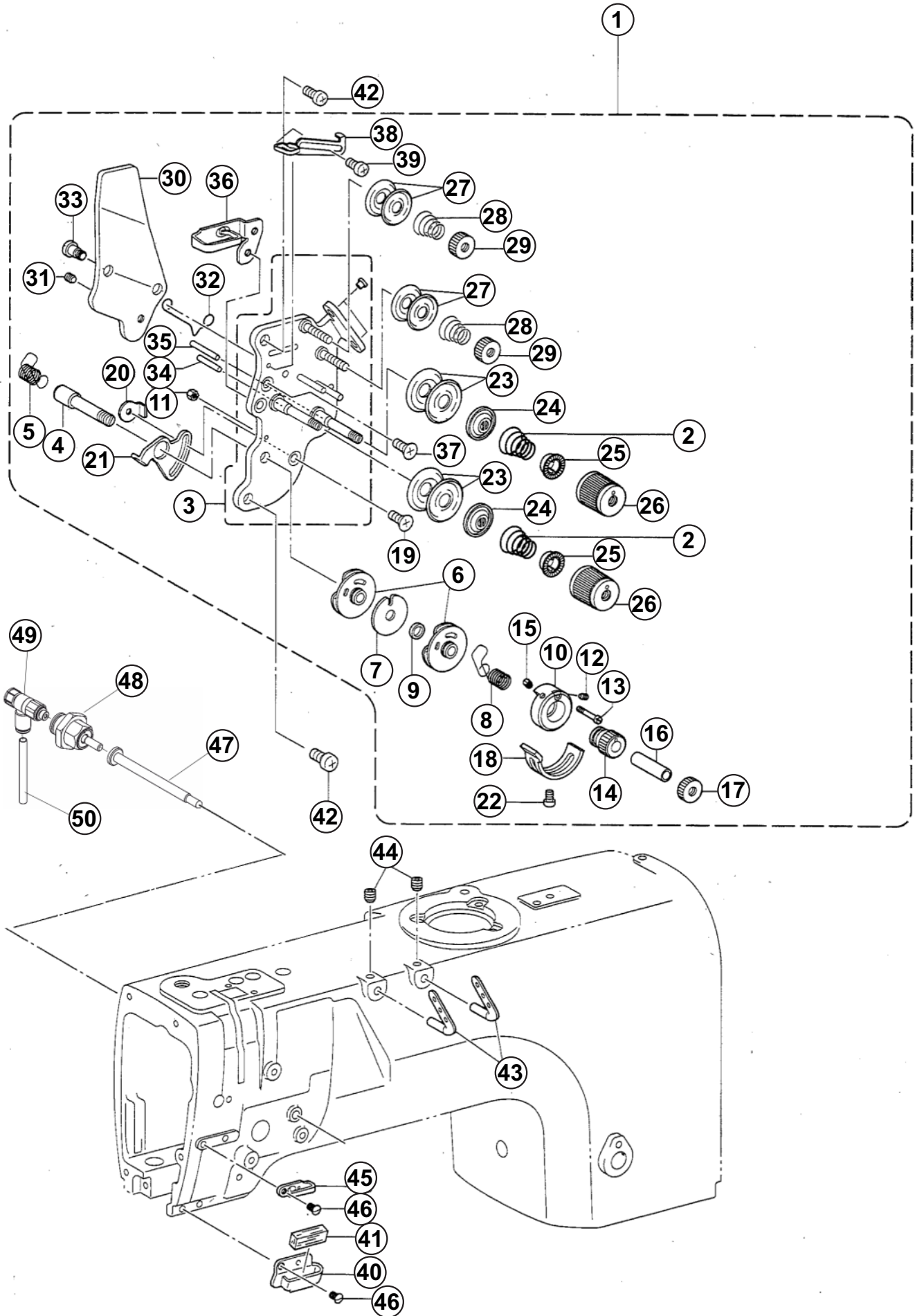


## LUBRICATION



DET	PART NUMBER	DESCRIPTION	QTY.
46	SA3047001	TUBE SUPPORT	1
47	SA3923001	ROTARY HOOK BASE D PACKING	2
48	62401616	SCREW, PAN M4 x 16	4
49	SA2604001	FEED REGULATOR FELT	1
50	SA2605001	FELT SUPPORT	1
51	62500616	SCREW, PAN M5 x 6	1
52	108802001	WICK, 4 x 4 L=250	2
53	108801001	WICK, 4 x 4 L=350	1
54	SA2606101	OIL COVER	1
55	104450101	RUBBER CAP, 8	1
56	SA3048101	TUBE SUPPORT, A	1
57	SA3049001	TUBE SUPPORT, B	1
58	062400616	SCREW, PAN M4 X6	2
59	SA4014001	TUBE GUIDE	1
60	140890009	OIL CAP	1
61	112753001	FELT	2
62	062061016	SCREW, PAN M6 x 10	3
63	025060236	WASHER, PLAIN 6	1

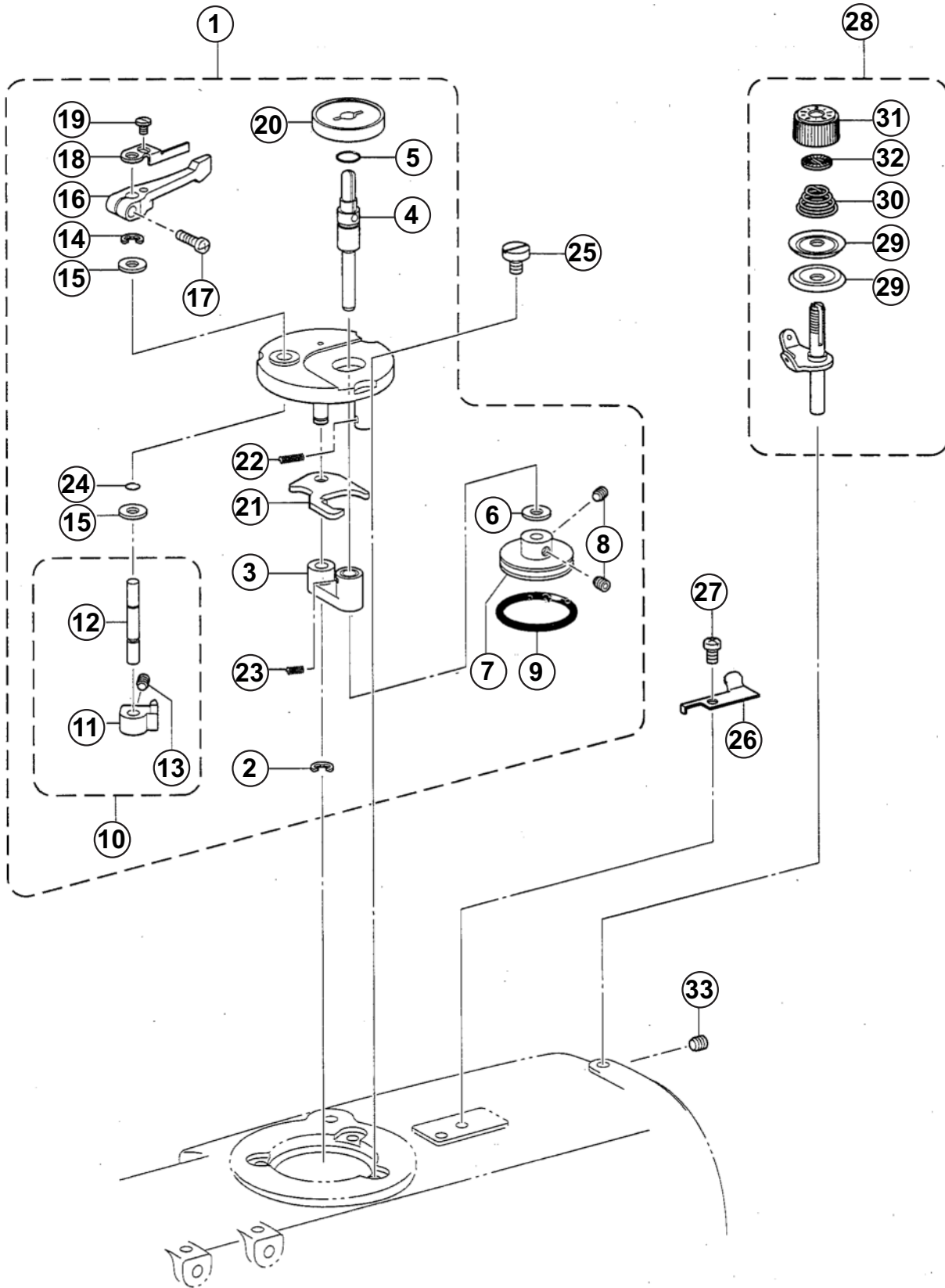
# THREADING MECHANISM



## THREADING MECHANISM

DET	PART NUMBER	DESCRIPTION	QTY.
01	SA3417001	UPPER THREAD TENSION ASSY, -3	1
02	SA3415001	TENSION SPRING, L	(2)
03	SA4212001	TENSION PLATE ASSY	(1)
04	SA2613001	TENSION STUD	(1)
05	SA2614001	THREAD TAKE-UP SPRING, L	(1)
06	SA2615001	GUIDE ASSY, T/TAKE-UP SPRING	(2)
07	SA2619001	SPACER	(1)
08	SA2623001	THREAD TAKE-UP SPRING, R	(1)
09	SA2620001	COLLAR	(1)
10	SA2621001	STOPPER SUPPORT	(1)
11	021300106	NUT, M3	(1)
12	SA2626001	SET SCREW, (CP) M3.5x6	(1)
13	SA2624001	SPRING GUIDE SET SCREW	(1)
14	SA2625001	ADJUSTING THUMB	(1)
15	SA2626001	SET SCREW, (CP) M3.5 x 6	(1)
16	SA2627001	COLLAR	(1)
17	SA2628001	TENSION NUT	(1)
18	SA2629001	STOPPER	(1)
19	061350616	SCREW, FLAT M3.5 x 6	(1)
20	SA2824001	WHIRL-STOP	(1)
21	SA2630001	STOPPER	(1)
22	062350512	SCREW, PAN M3.5 x 5	(1)
23	145446001	DISC, TENSION	(4)
24	159805001	TENSION DISC PRESSER	(2)
25	S20681000	WASHER	(2)
26	S20682105	ADJUSTING THUMB	(2)
27	144504001	THREAD GUIDE DISC	(4)
28	154560001	PRE-TENSION SPRING	(2)
29	155510001	TENSION NUT	(2)
30	SA2632001	TENSION RELEASE PLATE	(1)
31	012500536	SET SCREW, SOCKET (FT) M5 x 5	(1)
32	S38274001	T-RELEASE SPRING	(1)
33	SA2633001	T-RELEASE SCREW	(2)
34	SA4506001	TENSION RELEASE PIN, L	(1)
35	SA4507001	TENSION RELEASE PIN, R	(1)
36	SA2634001	THREAD GUIDE, U:ARM	(1)
37	061350616	SCREW, FLAT M3:5 x 6	(2)
38	SA2635001	THREAD QUANTINTY ADJUST	(1)
39	062300616	SCREW, PAN M3 x6	(1)
40	SA2639001	THREAD GUIDE, D:ARM	1
41	114941001	FELT	1
42	062500816	SCREW, PAN M5 x 8	2
43	SA2636001	THREAD RETAINER	2
44	012060636	SET SCREW, SOCKET (FT) M6 x 6	2
45	SA2638001	THREAD GUIDE, M:ARM	1
46	SA2640001	SCREW, FLAT M5 x 8	2
47	68.0223.0.300	ROD	1
48	12.0008.3.733	CYLINDER	1
49	12.0010.3.113	SPEED CONTROLLER	1
50	12.0008.3.416	AIR TUBE	1

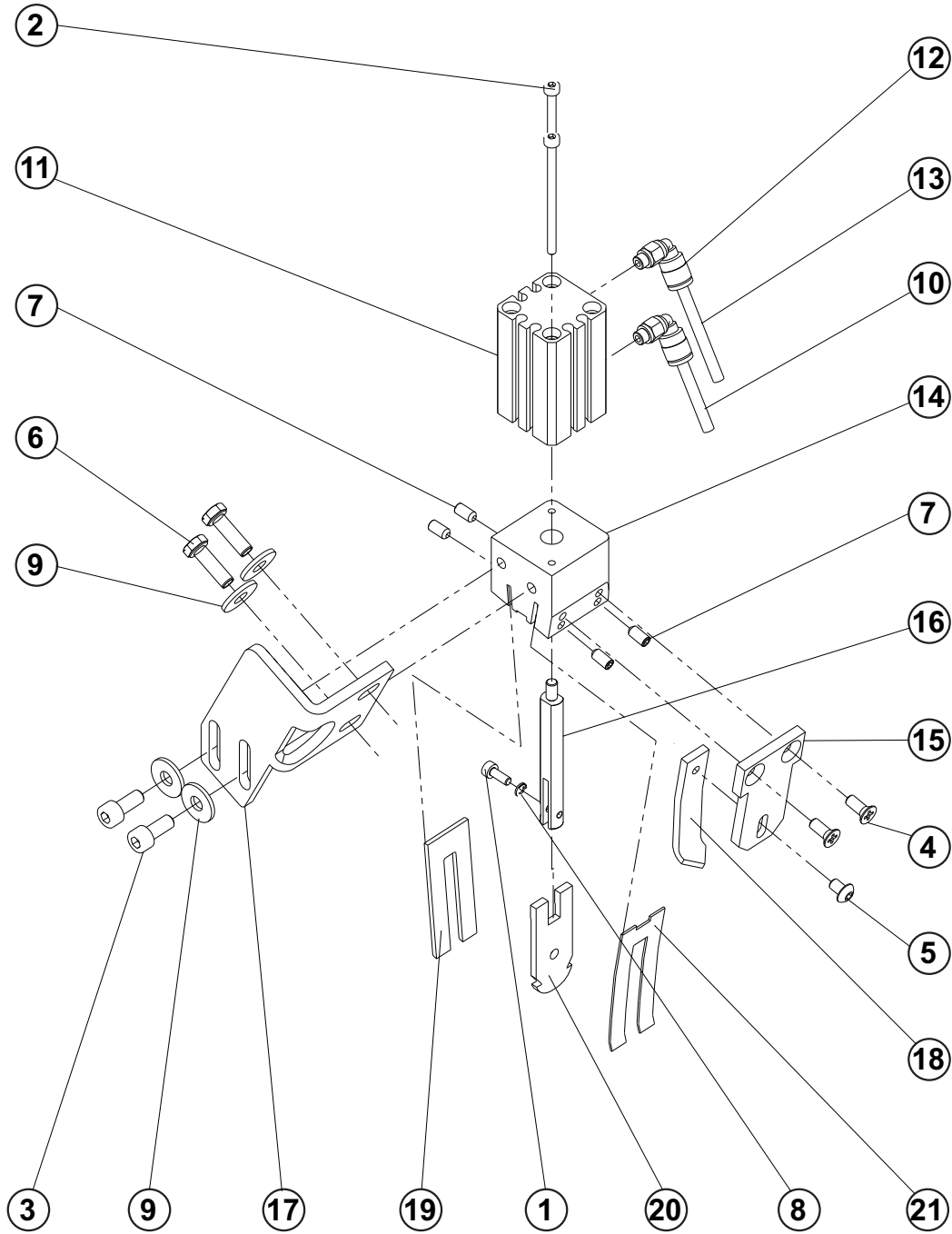
# BOBBIN WINDER MECHANISM



## BOBBIN WINDER MECHANISM

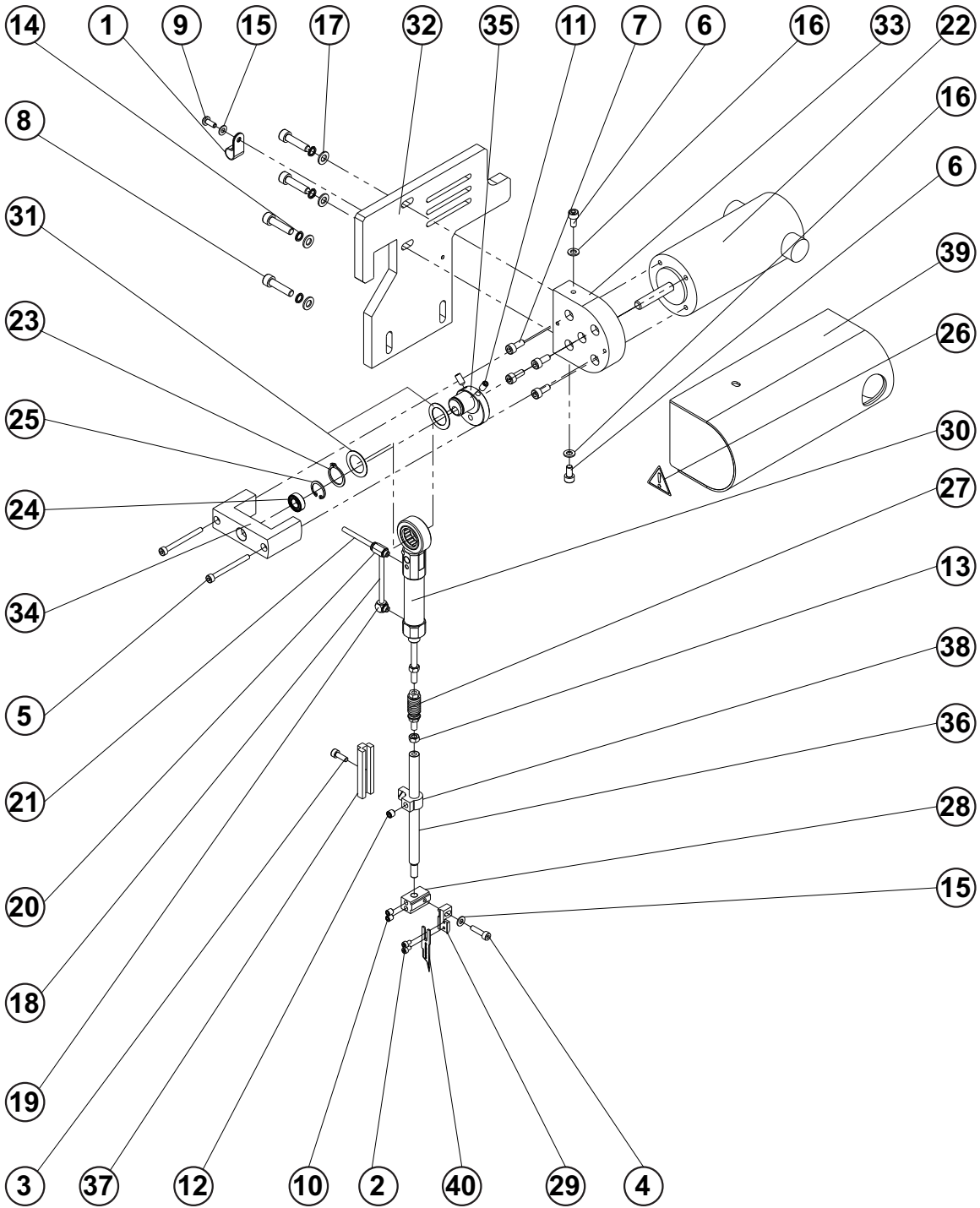
DET	PART NUMBER	DESCRIPTION	QTY.
01	SA1971101	BOBBIN WINDER UNIT	1
02	048040342	RETAINING RING, 4	(1)
03	SA1975001	B-WINDER SHAFT SUPPORT ASSY	(1)
04	SA1978001	BOBBIN WINDER SHAFT	(1)
05	081009070	O RING, 9	(1)
06	025060136	WASHER, PLAIN 6	(1)
07	SA1980001	BOBBIN WINDER WHEEL	(1)
08	012500536	SET SCREW, SOCKET (FT) M5 x 5	(2)
09	S25789000	RUBBER RING, 29	(1)
10	SA1981101	BOBBIN PRESSER CAM ASSY	(1)
11	SA1982101	BOBBIN PRESSER CAM	((1))
12	SA1983001	BOBBIN WINDER ARM SHAFT	((1))
13	012500536	SET SCREW, SOCKET (FT) M5 x 5	((1))
14	048040342	RETAINING RING, 4	(1)
15	025060136	WASHER, PLAIN 6	(2)
16	SA1984001	BOBBIN PRESSER ARM	(1)
17	062401216	SCREW PAN M4 x 12	(1)
18	SA1985001	BOBBIN PRESSER	(1)
19	S23418002	SCREW M4 x 5	(1)
20	SA1988001	BOBBIN SUPPORT	(1)
21	SA1989001	BOBBIN WINDER LEVER	(1)
22	SA1990101	SPRING	(1)
23	SA1991001	BOBBIN WINDER BASE SPRING	(1)
24	SA2190001	O RING, 5	(1)
25	SA1992101	BOBBIN WINDER FIXED SCREW	3
26	SA1360001	KNIFE	1
27	062500616	SCREW, PAN M5 x 6	1
28	SA1994001	BOBBIN WINDER TENSION ASSY	1
29	145446001	DISC, TENSION	(2)
30	100401021	TENSION SPRING	(1)
31	S31032001	TENSION NUT	(1)
32	S12441001	WASHER	(1)
33	012500536	SET SCREW, SOCKET (FT) M5 x 5	1

# TOP THREAD TRIMMER ASSEMBLY





# CENTER KNIFE SECTION

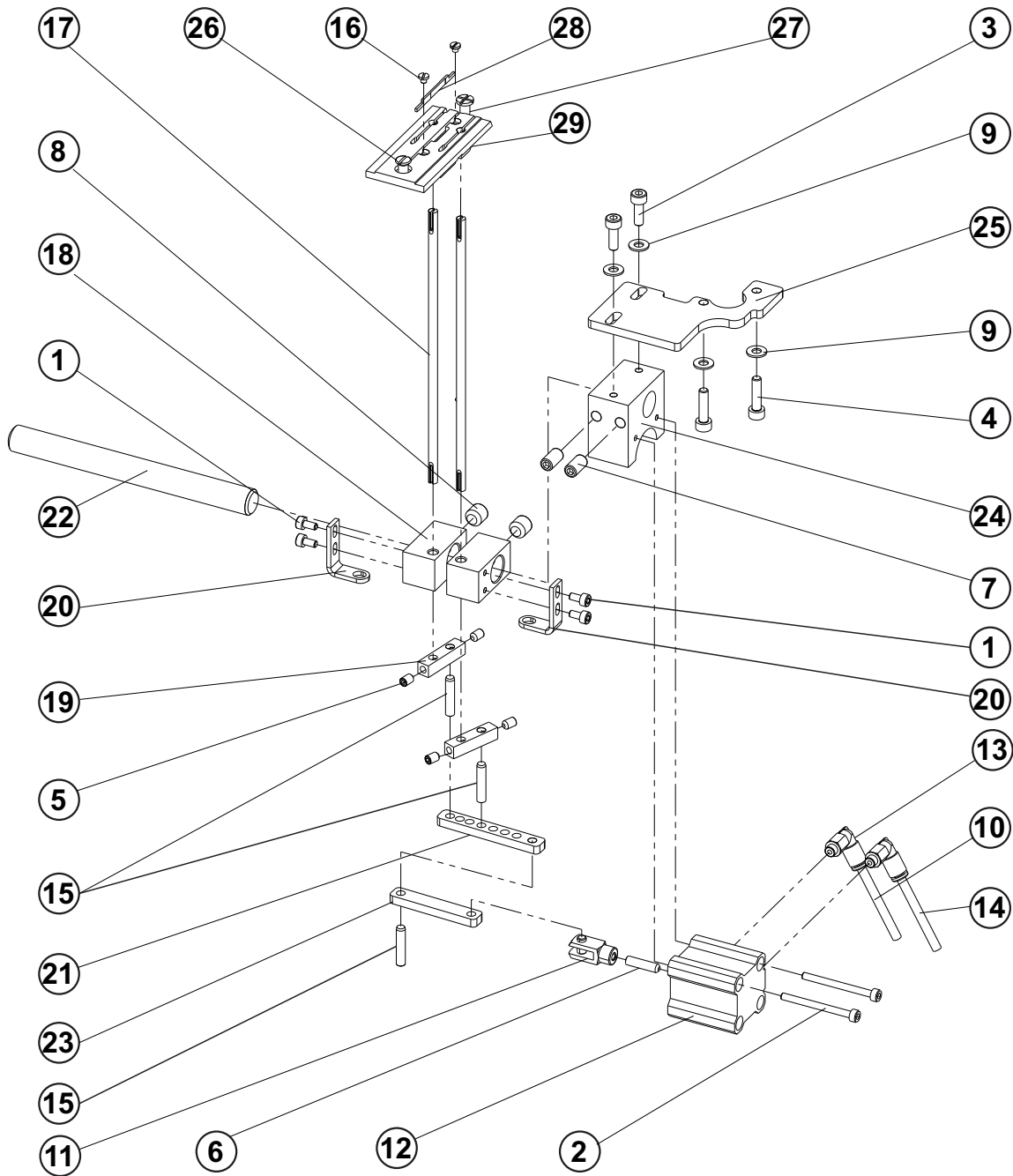




## CENTER KNIFE SECTION

DET	PART NUMBER	DESCRIPTION	QTY.
01	07.6600.0.004	CLAMP CABLE	1
02	08.6002.3.004	SCREW M3-4	2
03	08.6002.4.012	SCREW M4-12	1
04	08.6002.4.016	SCREW M4-16	1
05	08.6002.4.045	SCREW M4-45	2
06	08.6002.5.010	SCREW M5-10	2
07	08.6002.5.012	SCREW M5-12	4
08	08.6002.6.025	SCREW M6-25	4
09	08.6032.4.010	SCREW M4-10	1
10	08.6402.5.006	SCREW M5-6	2
11	08.6402.5.010	SCREW M5-10	2
12	08.6402.6.006	SCREW M6-6	1
13	08.6702.5.000	NUT M5	1
14	08.6802.6.000	SPRING WASHER M6	4
15	08.6852.4.000	WASHER M4	2
16	08.6852.5.000	WASHER 5,3	2
17	08.6852.6.000	WASHER 6,4	4
18	12.0008.3.416	AIR TUBE- J12B	1
19	12.0008.3.444	CONNECTOR	1
20	12.0010.3.027	CONNECTOR	1
21	12.0010.3.080	AIR TUBE- J12A	1
22	06.6800.0.062	CENTER KNIFE MOTOR	1
23	12.1045.1.017	CIRCLIP 17x1	1
24	12.2010.0.037	BEARING	1
25	17.0027.4.129	RETAINING RING 16	1
26	17.0097.5.174	LABEL- WARNING	1
27	68.0113.0.050	FLOATING JOINT	1
28	68.0114.0.600	BRACKET	1
29	68.0115.0.600	KNIFE BRACKET	1
30	68.0118.0.000	CENTER KNIFE CYLINDER	1
31	68.0119.0.100	WASHER 17x25-0,5	2
32	68.0130.0.800	PLATE	1
33	68.0131.0.600	MOTOR BRACKET	1
34	68.0132.0.600	HOLDER	1
35	68.0133.0.400	ECCENTRIC	1
36	68.0134.0.300	BAR	1
37	68.0135.0.600	GUIDE	1
38	68.0136.0.600	GUIDE BAR	1
39	68.0138.0.000	MOTOR COVER	1
40	69.0052.0.000	CENTER KNIFE	1

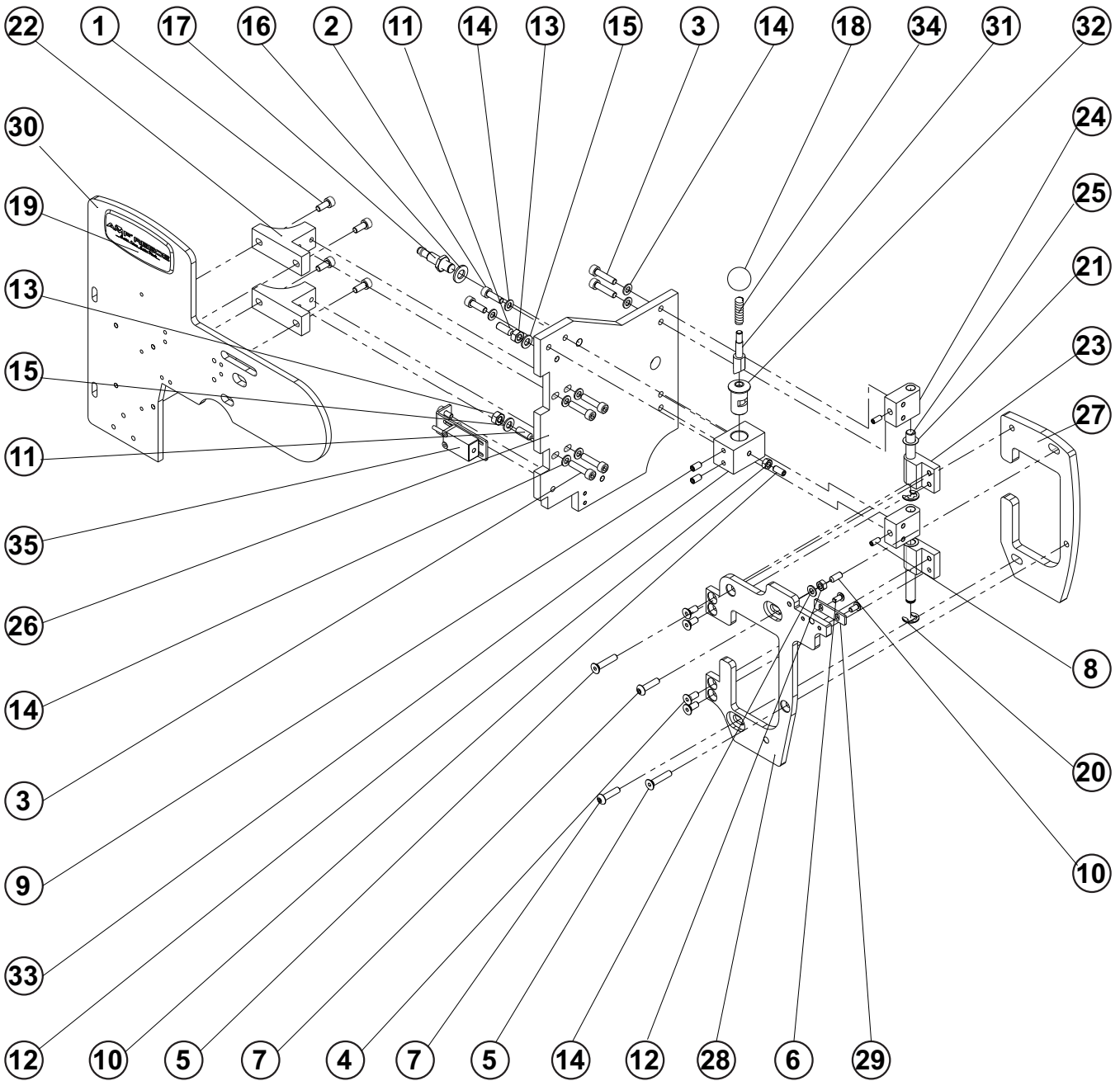
# UNDER THREAD TRIMMER SECTION



## UNDER THREAD TRIMMER SECTION

DET	PART NUMBER	DESCRIPTION	QTY.
01	08.6002.3.006	SCREW M3-6	4
02	08.6002.3.035	SCREW M3-35	2
03	08.6002.4.012	SCREW M4-12	2
04	08.6002.4.025	SCREW M4-25	2
05	08.6402.4.006	SCREW M4-6	4
06	08.6402.4.016	SCREW M4-16	1
07	08.6402.6.012	SCREW M6-12	2
08	08.6402.8.008	SCREW M8-8	2
09	08.6852.4.000	WASHER M4	4
10	12.0008.3.416	AIR TUBE- J14B	
11	12.0008.3.738	KNUCKLE	1
12	12.0010.3.021	CYLINDER	1
13	12.0010.3.028	CONNECTOR	2
14	12.0010.3.080	AIR TUBE- J14A	
15	12.1010.2.032	PIN	3
16	17.0012.0.688	SCREW M2,5-2,5	2
17	68.0070.0.300	CUTTING AXLE	2
18	68.0071.0.600	CUBE	2
19	68.0072.0.600	HOLDING PART	2
20	68.0073.0.800	SIDE STOP	2
21	68.0074.0.800	CONNECTING ROD	1
22	68.0075.0.300	BAR	1
23	68.0076.0.800	CONNECTING ROD	1
24	68.0077.0.600	HOLDER	1
25	68.0078.0.800	HOLDER	1
26	68.0175.0.100	SCREW	1
27	68.0176.0.100	SCREW	1
28	69.0010.0.004	KNIFE	1
29	See page 3-99	NEEDLE PLATE	1

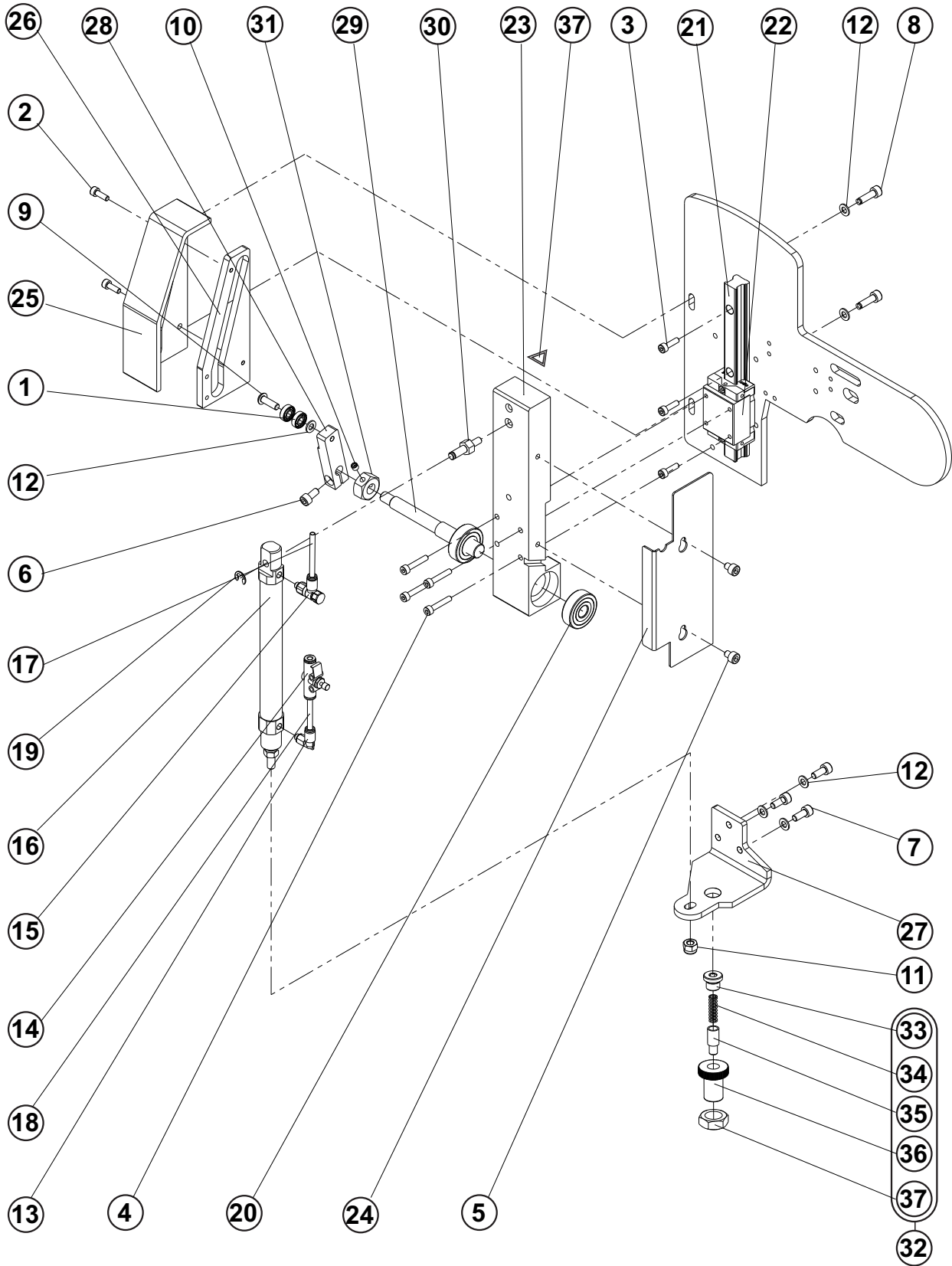
# FRONT OF HEAD SECTION-BASE



## FRONT OF HEAD SECTION-BASE

DET	PART NUMBER	DESCRIPTION	QTY.
01	08.6002.5.012	SCREW M5-12	4
02	08.6002.5.016	SCREW M5-16	2
03	08.6002.5.022	SCREW M5-22	8
04	08.6102.5.012	SCREW M5-12	4
05	08.6102.5.025	SCREW M5-25	2
06	08.6202.4.008	SCREW M4-8	2
07	08.6202.5.020	SCREW M5-20	2
08	08.6400.4.010	SCREW M4-10	2
09	08.6402.5.010	SCREW M5-10	2
10	08.6402.5.012	SCREW M5-12	2
11	08.6412.6.016	SCREW M6-16	2
12	08.6702.5.000	NUT M5	2
13	08.6702.6.000	NUT M6	2
14	08.6852.5.000	WASHER 5,3	11
15	08.6852.6.000	WASHER 6,4	2
16	08.6852.8.000	WASHER M8	1
17	12.0010.4.093	SENSOR	1
18	12.0010.6.212	ROD END	1
19	12.8000.0.436	LABEL	1
20	17.0027.4.085	LOCK RING 7	2
21	24.4068.0.003	WASHER	2
22	68.0145.0.600	ANGLE BRACKET	2
23	68.0146.0.600	HINGE	2
24	68.0147.0.600	HINGE	2
25	68.0148.0.300	HINGE PLUG	2
26	68.0150.1.800	BRACKET SHEET	1
27	68.0151.0.800	DISTANCE PLATE	1
28	68.0152.0.800	FRONT BRACKET	1
29	68.0156.0.800	STOP	1
30	68.0162.0.800	REMOVABLE BRACKET	1
31	68.0167.0.300	CATCH	1
32	68.0168.0.400	CATCH CASE	1
33	68.0169.0.600	CATCH BODY	1
34	68.0172.0.200	SPRING	1
35	68.0213.0.050	FLAP SENZOR ASSY.	1

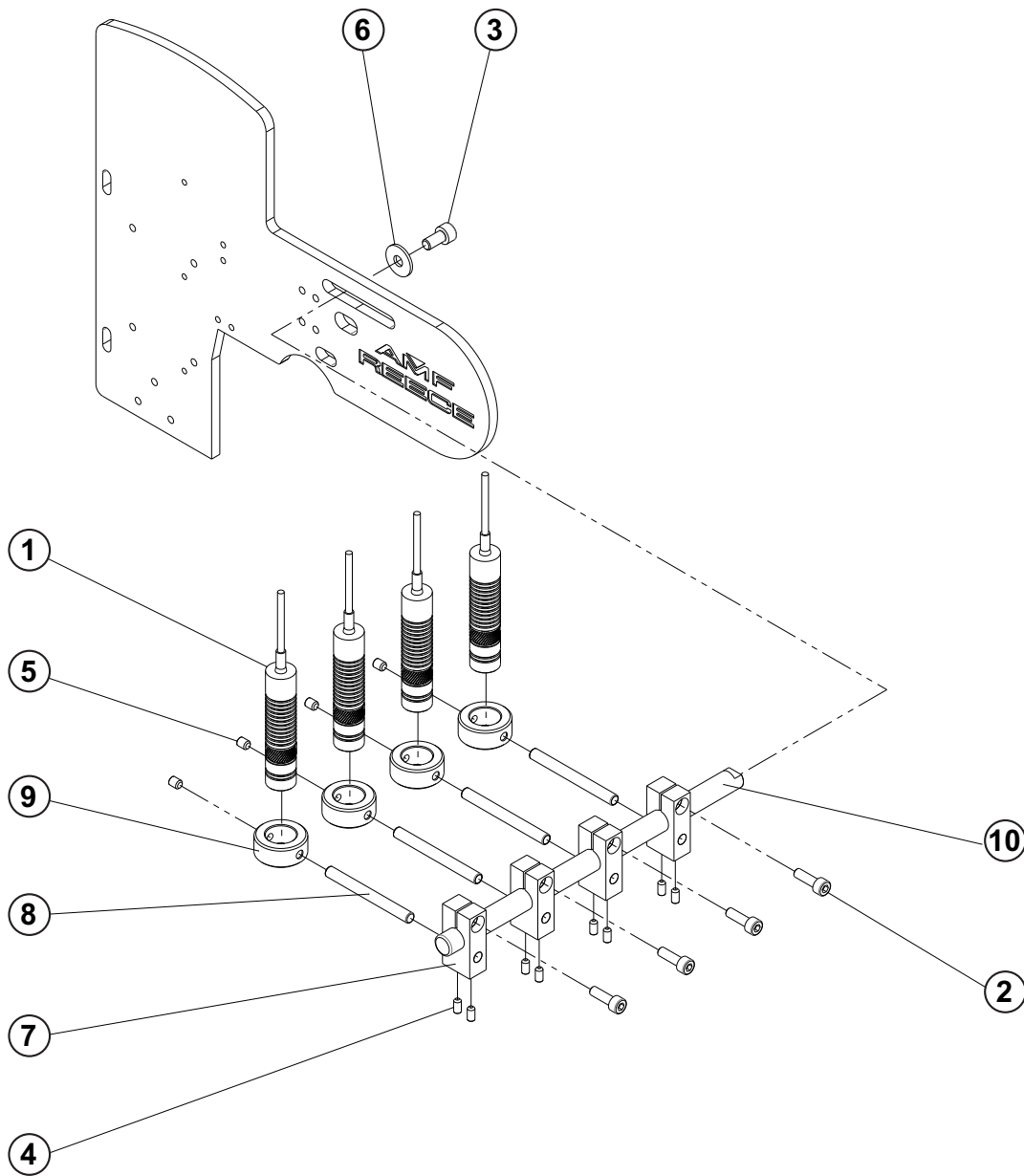
# FRONT OF HEAD SECTION-PATCH GUIDE DRIVE



## FRONT OF HEAD SECTION-PATCH GUIDE DRIVE

DET	PART NUMBER	DESCRIPTION	QTY.
01	07.6321.0.029	BEARING	2
02	08.6002.4.012	SCREW M4-12	2
03	08.6002.4.014	SCREW M4-14	3
04	08.6002.4.022	SCREW M4-22	4
05	08.6002.5.006	SCREW M5-6	2
06	08.6002.5.010	SCREW M5-10	1
07	08.6002.5.012	SCREW M5-12	3
08	08.6002.5.016	SCREW M5-16	2
09	08.6202.5.016	SCREW M5-16	1
10	08.6402.5.005	SCREW M5-5	1
11	08.6732.6.000	NUT M6	1
12	08.6852.5.000	WASHER 5,3	6
13	12.0010.3.028	CONNECTOR	1
14	12.0010.3.029	SPEED VALVE	1
15	12.0010.3.047	SPEED CONTR.	1
16	12.0010.3.069	CYLINDER	1
17	12.0010.3.080	AIR TUBE- J10A	1
18	12.0010.3.080	AIR TUBE- J9A	2
19	12.1045.0.005	E-CLIP 5	1
20	12.2010.0.000	BEARING	1
21	12.2070.1.067	LINEAR RAIL	1
22	12.2070.1.068	GUIDE	1
23	68.0149.0.600	HOLDER	1
24	68.0153.0.800	COVER	1
25	68.0154.0.600	COVER WITH GROOVE	1
26	68.0155.0.800	GROOVE DRIVER	1
27	68.0157.0.800	BRACKET	1
28	68.0163.0.600	ROLLER HOLDER	1
29	68.0164.0.300	SHAFT	1
30	68.0165.0.300	HINGE STUD	1
31	68.0166.0.100	NUT M10x1,25	1
32	68.0170.0.050	SHOCK ABSORBER	1
33	08.6072.0.308	SCREW	(1)
34	68.0173.0.200	SPRING	(1)
35	68.0171.0.300	PLUNGER	(1)
36	68.0170.0.300	STOP CASE	(1)
37	68.0174.0.100	NUT	(1)

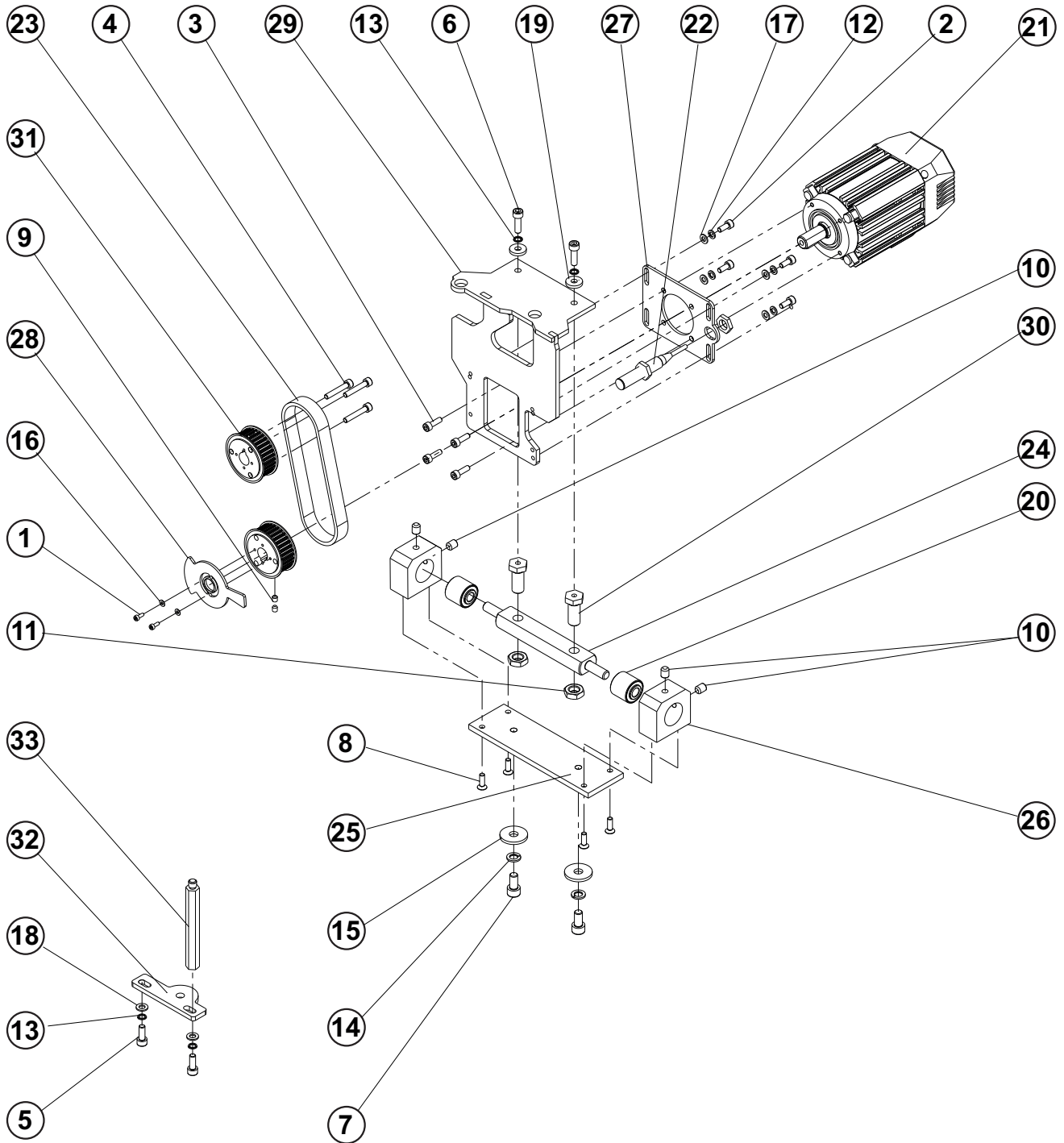
# FRONT OF HEAD SECTION-LASER







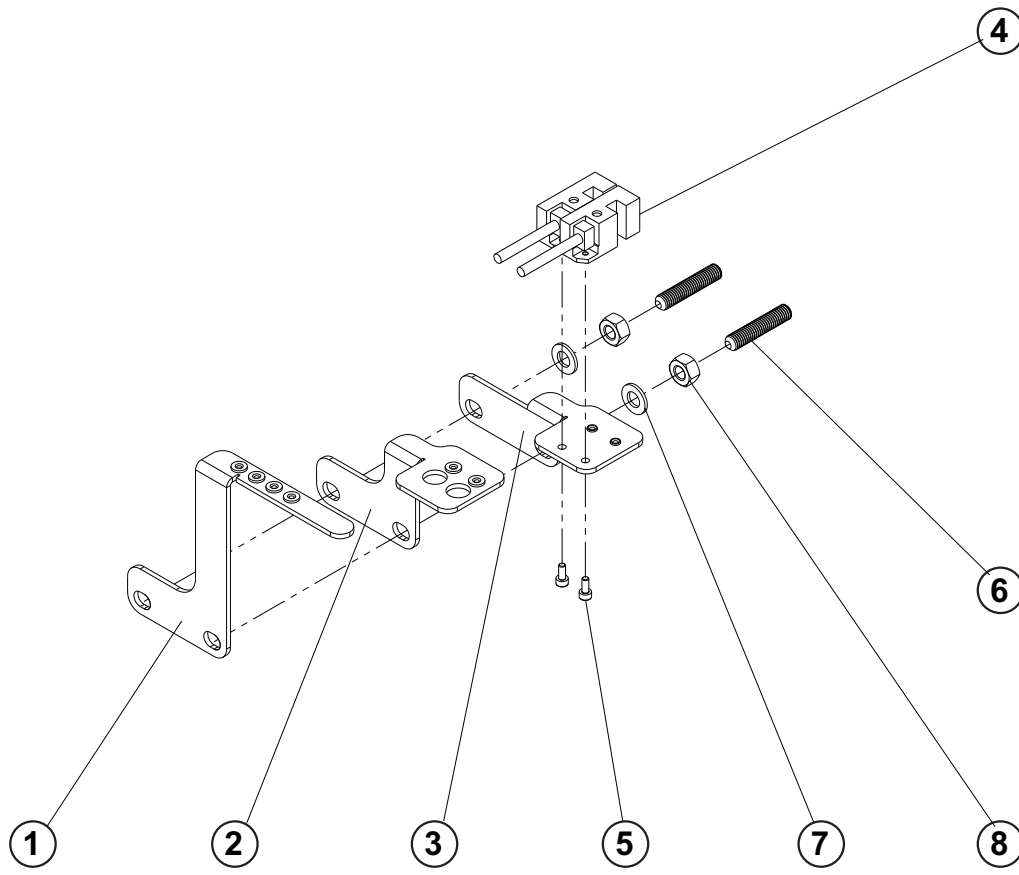
# HEAD MOTOR SECTION



## HEAD MOTOR SECTION

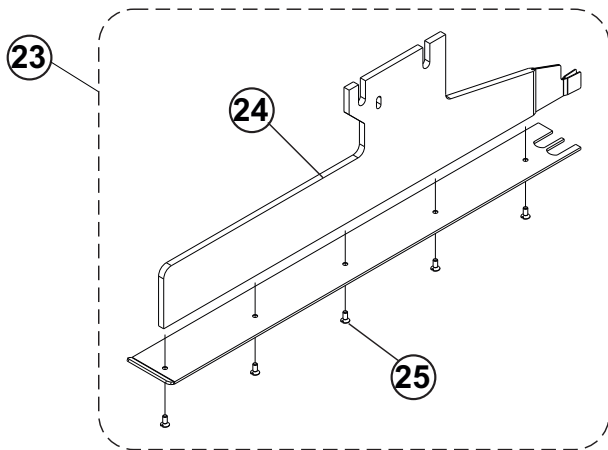
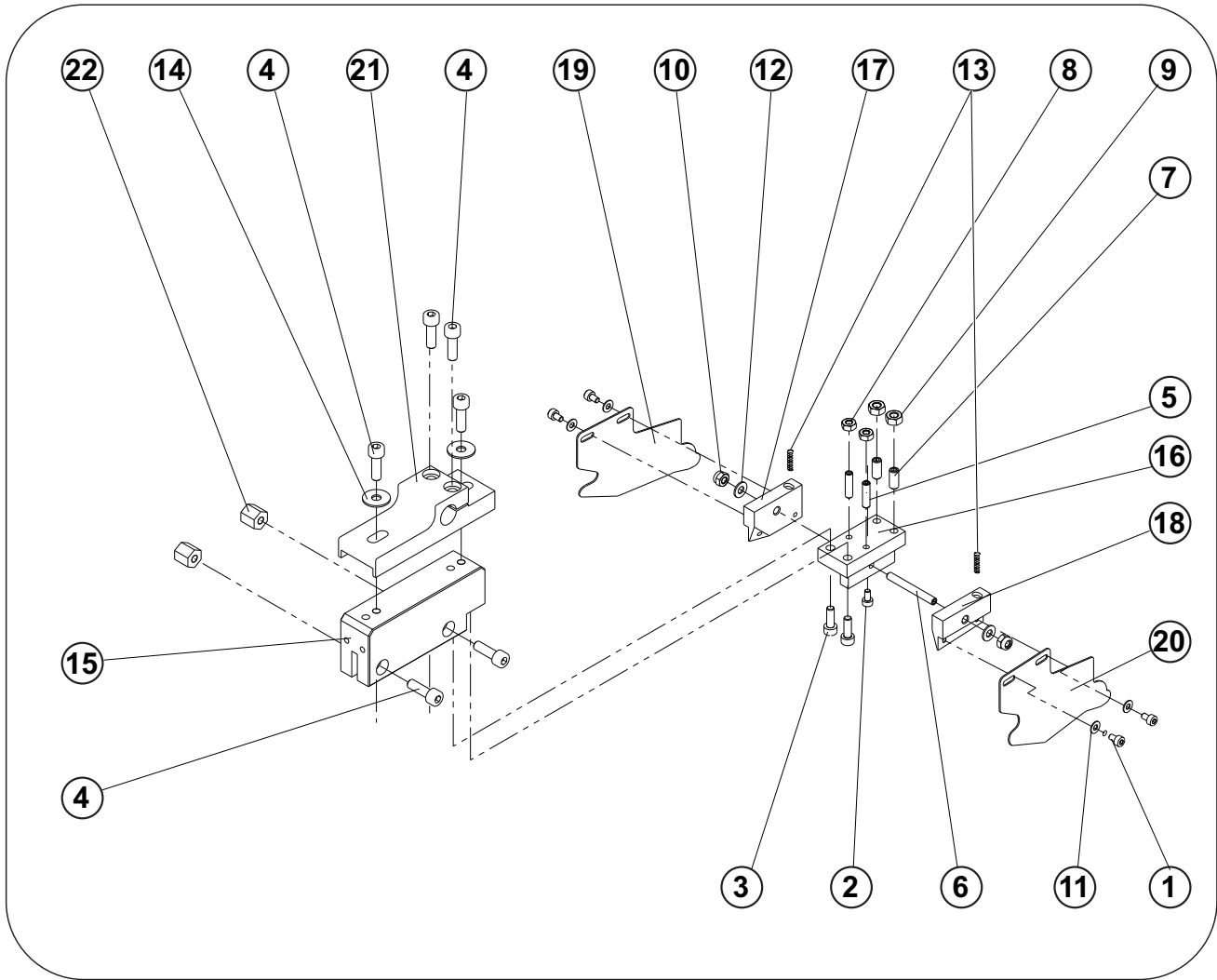
DET	PART NUMBER	DESCRIPTION	QTY.
01	08.6002.3.008	SCREW M3-8	2
02	08.6002.5.012	SCREW M5-12	4
03	08.6002.5.016	SCREW M5-16	4
04	08.6002.5.030	SCREW M5-30	3
05	08.6002.6.016	SCREW M6-16	2
06	08.6002.6.020	SCREW M6-20	2
07	08.6002.8.016	SCREW M8-16	2
08	08.6102.5.016	SCREW M5-16	4
09	08.6400.4.010	SCREW M5-6	1
10	08.6402.8.010	SCREW M8-10	4
11	08.6712.9.000	NUT M12	2
12	08.6802.5.000	SPRING WASHER M5	4
13	08.6802.6.000	SPRING WASHER M6	4
14	08.6802.8.000	SPRING WASHER M8	2
15	08.6842.8.000	WASHER M8	2
16	08.6852.3.000	WASHER M3	2
17	08.6852.5.000	WASHER 5,3	4
18	08.6852.6.000	WASHER 6,4	2
19	08.6892.6.000	WASHER M6	2
20	12.0008.6.818	VIBRATION-DAMPING BRONZE BEARING	2
21	12.0010.4.327	MOTOR EFKA	1
22	06.6800.0.021	SENSOR BQ1 ASSY./NEEDLE	1
23	12.5050.2.032	BELT	1
24	68.0120.0.300	CARRIER SHAFT	1
25	68.0121.0.800	BASE HINGE	1
26	68.0122.0.600	SIDE BRACKET	2
27	68.0125.0.800	MOTOR BASE-SHEET	1
28	68.0126.0.800	SENSOR PLATE	1
29	68.0127.0.000	MAIN MOTOR BRACKET	1
30	68.0128.0.300	SETTING SCREW	2
31	68.0129.0.500	PULLEY	2
32	68.0243.0.800	PLATE	1
33	68.0244.0.300	STUD	1

# THREAD MONITOR





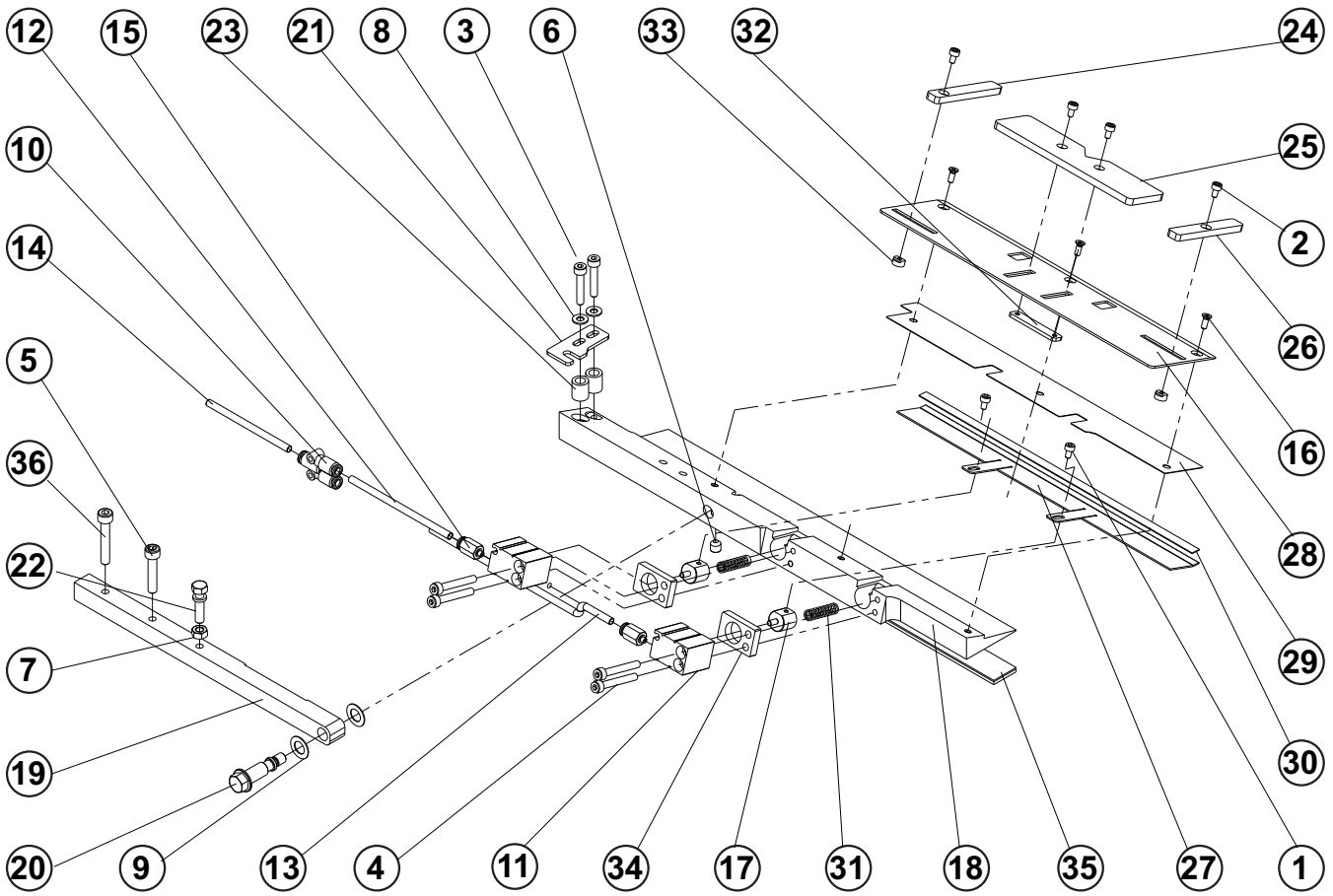
# PATCH GUIDE ASSEMBLY



## PATCH GUIDE ASSEMBLY

DET	PART NUMBER	DESCRIPTION	QTY.
01	08.6002.3.005	SCREW M3-5	4
02	08.6002.3.006	SCREW M3-6	1
03	08.6002.4.012	SCREW M4-12	2
04	08.6002.5.016	SCREW M5-16	6
05	08.6402.4.016	SCREW M4-16	2
06	08.6402.4.035	SCREW M4-35	1
07	08.6402.5.012	SCREW M5-12	2
08	08.6702.4.000	NUT M4	2
09	08.6702.5.000	NUT M5	2
10	08.6732.4.000	NUT M4	2
11	08.6852.3.000	WASHER M3	4
12	08.6852.4.000	WASHER M4	2
13	12.3010.0.025	SPRING	2
14	15.1142.0.400	WASHER 5/15	2
15	68.0104.0.600	CONNECTING PART	1
16	68.0105.0.600	PATCH GUIDE HOLDER	1
17	68.0106.0.600	HOLDER LEFT	1
18	68.0107.0.600	HOLDER RIGHT	1
19	68.0108.0.800	SLIDE PLATE LEFT	1
20	68.0109.0.800	SLIDE PLATE RIGHT	1
21	68.0110.1.600	FOOT SUPPORT JOINT	1
22	68.0144.0.100	DISTANCE NUT M5-10-OK10	2
23	See page 3-98	LOWER PATCH GUIDE ASSY.	-
24	68.0100.0.000	PATCH GUIDE UPPER	1
25	08.6112.7.006	SCREW M2,5-6	5
26	68.9026.0.050	PATCH GUIDE ASSEMBLY	1

# LEFT CLAMP SECTION-STANDARD

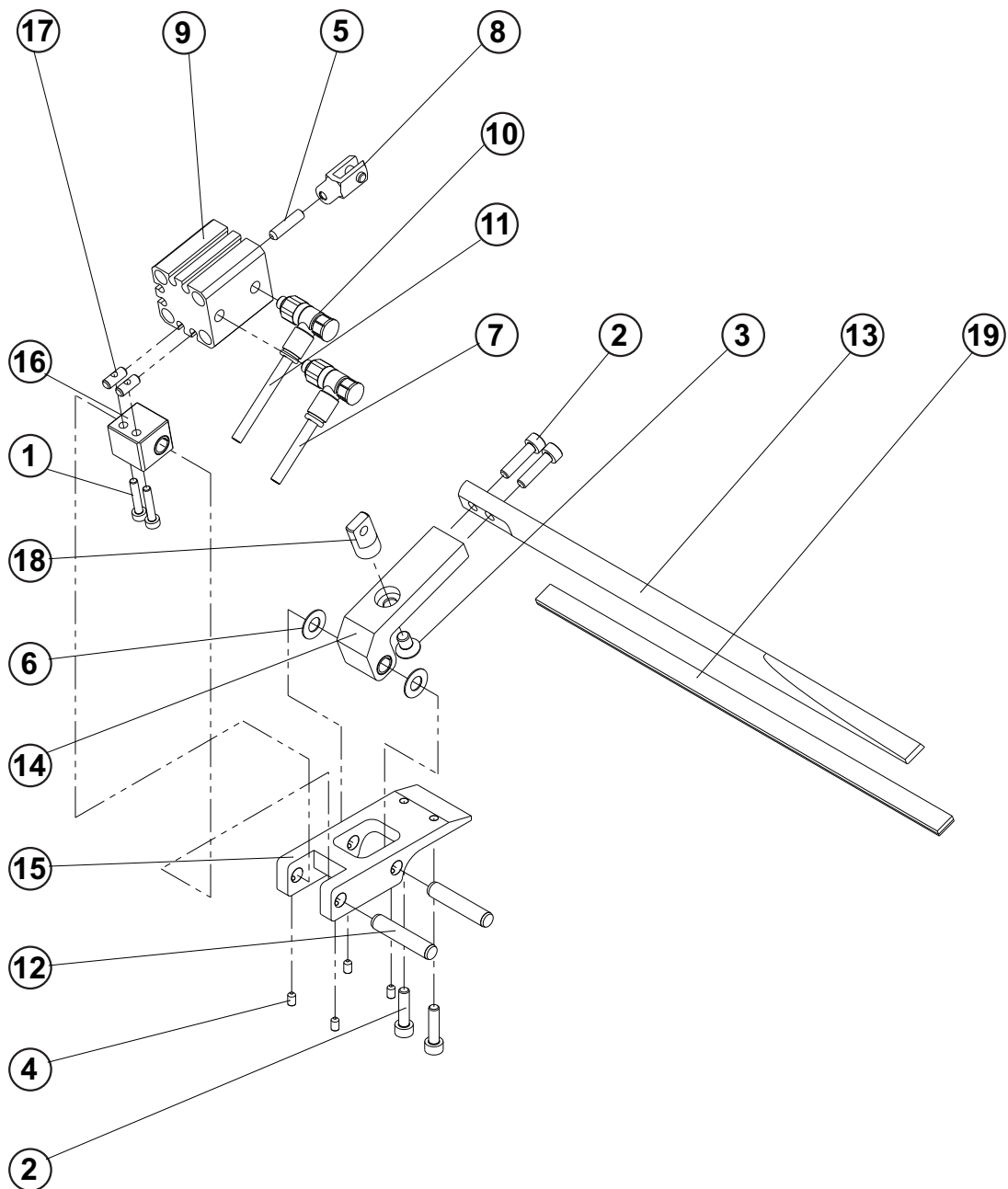




**LEFT CLAMP SECTION-STANDARD**

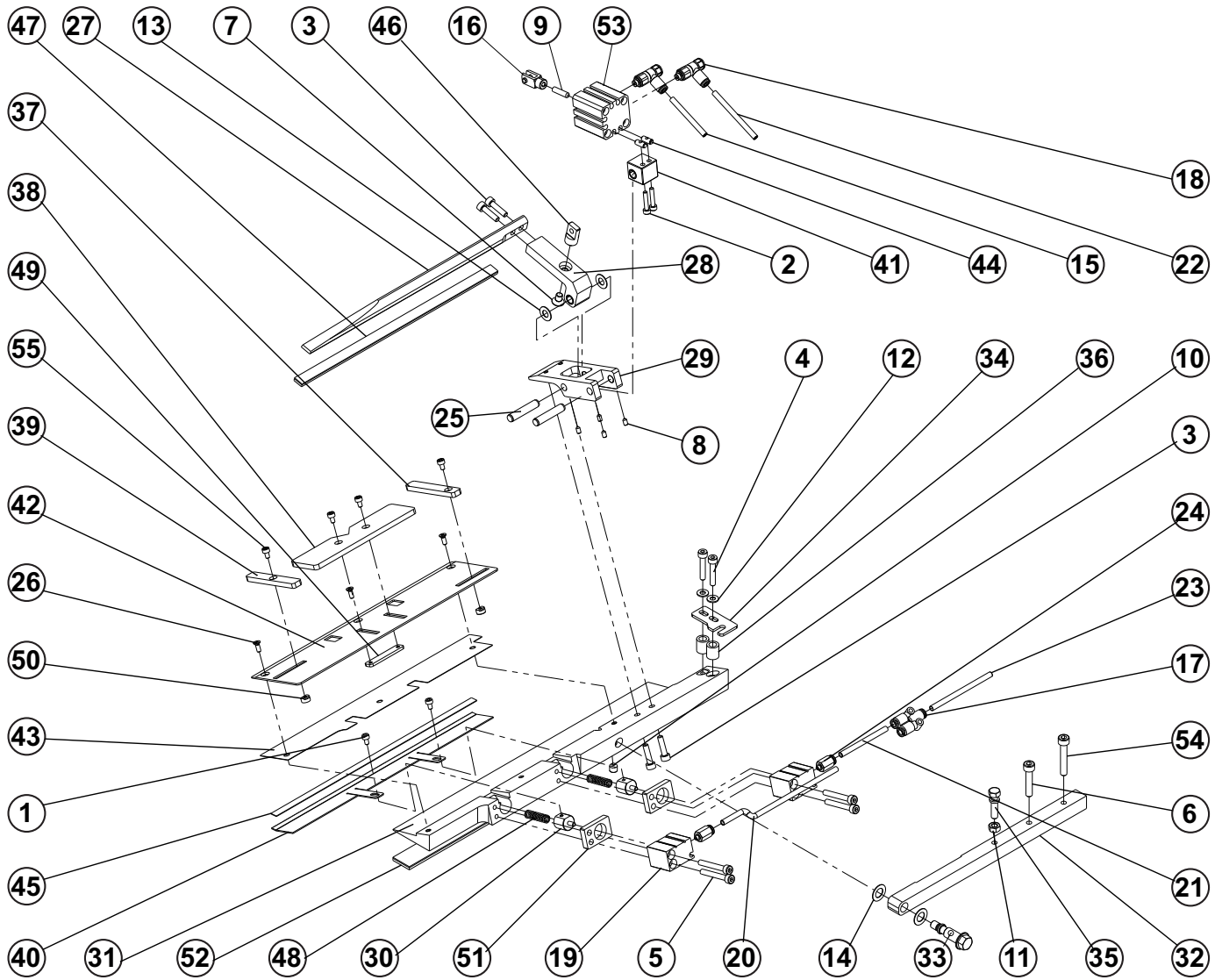
DET	PART NUMBER	DESCRIPTION	QTY.
01	08.6002.3.004	SCREW M3-4	2
02	08.6002.3.005	SCREW M3-5	4
03	08.6002.4.022	SCREW M4-22	2
04	08.6002.4.030	SCREW M4-30	4
05	08.6002.5.025	SCREW M5-25	1
06	08.6402.6.006	SCREW M6-6	1
07	08.6702.5.000	NUT M5	1
08	08.6852.4.000	WASHER M4	2
09	08.6887.8.000	WASHER 8x14-0,5	2
10	12.0010.3.037	CONNECTOR	1
11	12.0010.3.073	CYLINDER	2
12	12.0010.3.080	AIR TUBE- J5A2	
13	12.0010.3.080	AIR TUBE- J5A1	
14	12.0010.3.080	AIR TUBE- J5A	
15	12.0010.3.119	CONNECTOR	2
16	15.1420.0.100	SCREW M3-8	3
17	68.0005.0.300	PLUNGER	2
18	68.0006.0.600	CLAMP BRACKET LEFT	1
19	68.0008.0.600	CLAMP BRACKET	1
20	68.0009.0.300	BOLT	1
21	68.0010.0.800	PLATE	1
22	68.0011.0.300	ADJUSTING SCREW	1
23	68.0012.0.400	DISTANCE RING	2
24	68.0013.0.992	FLAP SIZE ADJUST. PART	1
25	68.0014.0.992	FLAP SIZE ADJUST. PART	1
26	68.0015.0.992	FLAP SIZE ADJUST. PART	1
27	68.0016.0.800	MOVING BAR	1
28	68.0018.0.800	FLAT PLATE LEFT	1
29	68.0020.0.800	METAL STRIP	1
30	68.0022.0.992	REFLEX TAPE	1
31	68.0025.0.200	SPRING	2
32	68.0026.0.800	NUT PLATE	1
33	68.0027.0.300	NUT	2
34	68.0028.0.800	PLATE	2
35	68.0029.0.990	RUBBER STRIP	1
36	08.6002.5.030	SCREW M5-30	1

# LEFT FLAP SECTION-FULL VERSION





# RIGHT CLAMP SECTION-STANDARD

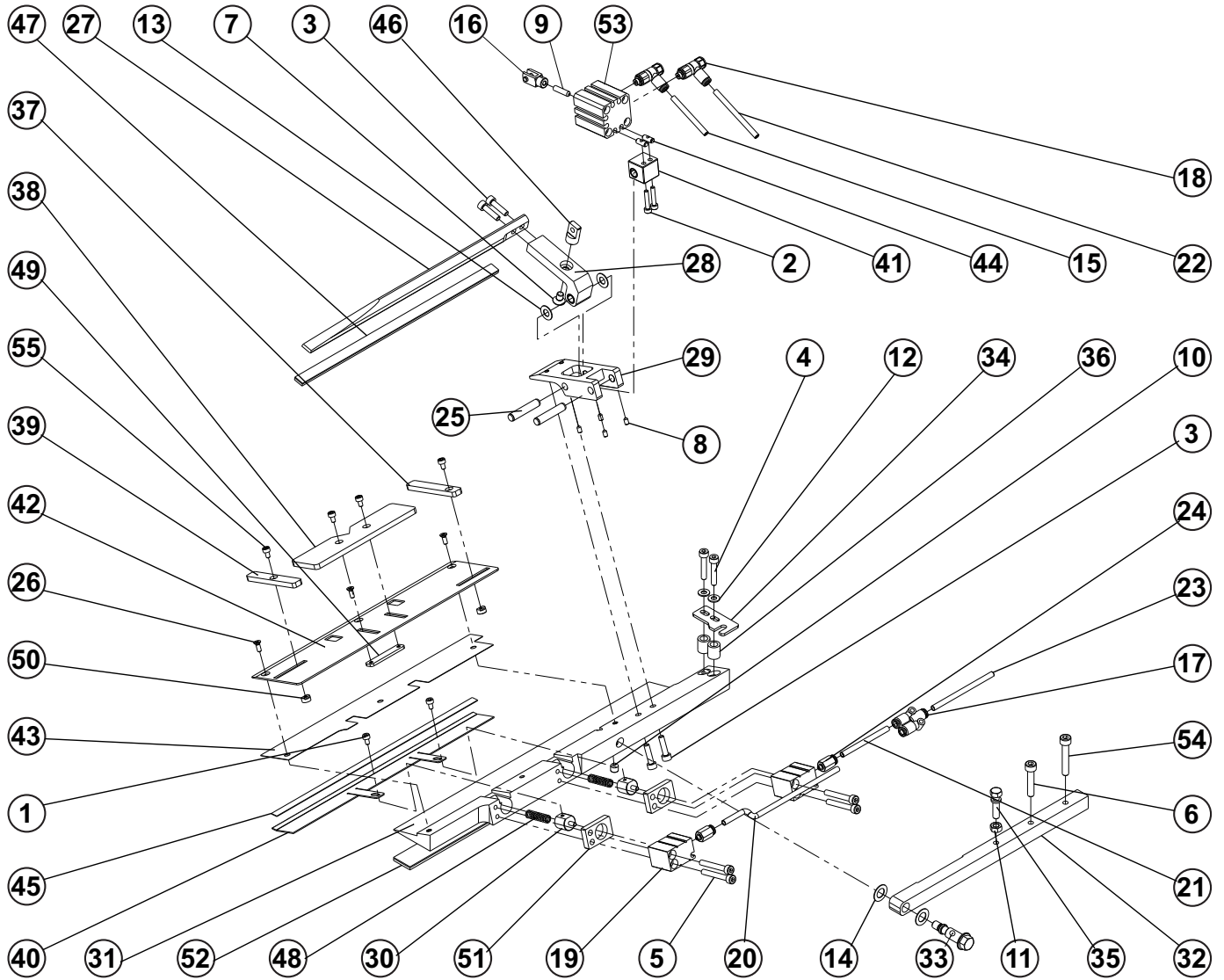


## RIGHT CLAMP SECTION-STANDARD

DET	PART NUMBER	DESCRIPTION	QTY.
01	08.6002.3.004	SCREW M3-4	2
02	08.6002.3.016	SCREW M3-16	2
03	08.6002.4.016	SCREW M4-16	4
04	08.6002.4.022	SCREW M4-22	2
05	08.6002.4.030	SCREW M4-30	4
06	08.6002.5.025	SCREW M5-25	1
07	08.6102.5.008	SCREW M5-8	1
08	08.6402.3.005	SCREW M3-5	4
09	08.6402.4.016	SCREW M4-16	1
10	08.6402.6.006	SCREW M6-6	1
11	08.6702.5.000	NUT M5	1
12	08.6852.4.000	WASHER M4	2
13	08.6887.6.500	WASHER 6x12-0,5	2
14	08.6887.8.000	WASHER 8x14-0,5	2
15	12.0008.3.416	AIR TUBE- J2B	
16	12.0008.3.738	KNUCKLE	1
17	12.0010.3.037	CONNECTOR	1
18	12.0010.3.047	SPEED CONTR.	2
19	12.0010.3.073	CYLINDER	2
20	12.0010.3.080	AIR TUBE- J6A1	
21	12.0010.3.080	AIR TUBE- J6A2	
22	12.0010.3.080	AIR TUBE- J2A	
23	12.0010.3.080	AIR TUBE- J6A	
24	12.0010.3.119	CONNECTOR	2
25	12.1010.2.035	PIN	2
26	15.1420.0.100	SCREW M3-8	3
27	68.0002.0.600	CLAMP RIGHT	1
28	68.0003.0.600	MOVING ARM	1
29	68.0004.0.600	BRACKET	1
30	68.0005.0.300	PLUNGER	2
31	68.0007.0.600	CLAMP BRACKET RIGHT	1
32	68.0008.0.600	CLAMP BRACKET	1
33	68.0009.0.300	BOLT	1
34	68.0010.0.800	PLATE	1
35	68.0011.0.300	ADJUSTING SCREW	1
36	68.0012.0.400	DISTANCE RING	2
37	68.0013.0.992	FLAP SIZE ADJUST. PART	1
38	68.0014.0.992	FLAP SIZE ADJUST. PART	1
39	68.0015.0.992	FLAP SIZE ADJUST. PART	1
40	68.0016.0.800	MOVING BAR	1
41	68.0017.0.600	HOLDER	1
42	68.0019.0.800	FLAT PLATE RIGHT	1
43	68.0020.0.800	METAL STRIP	1
44	68.0021.0.300	STUD	2
45	68.0022.0.992	REFLEX TAPE	1

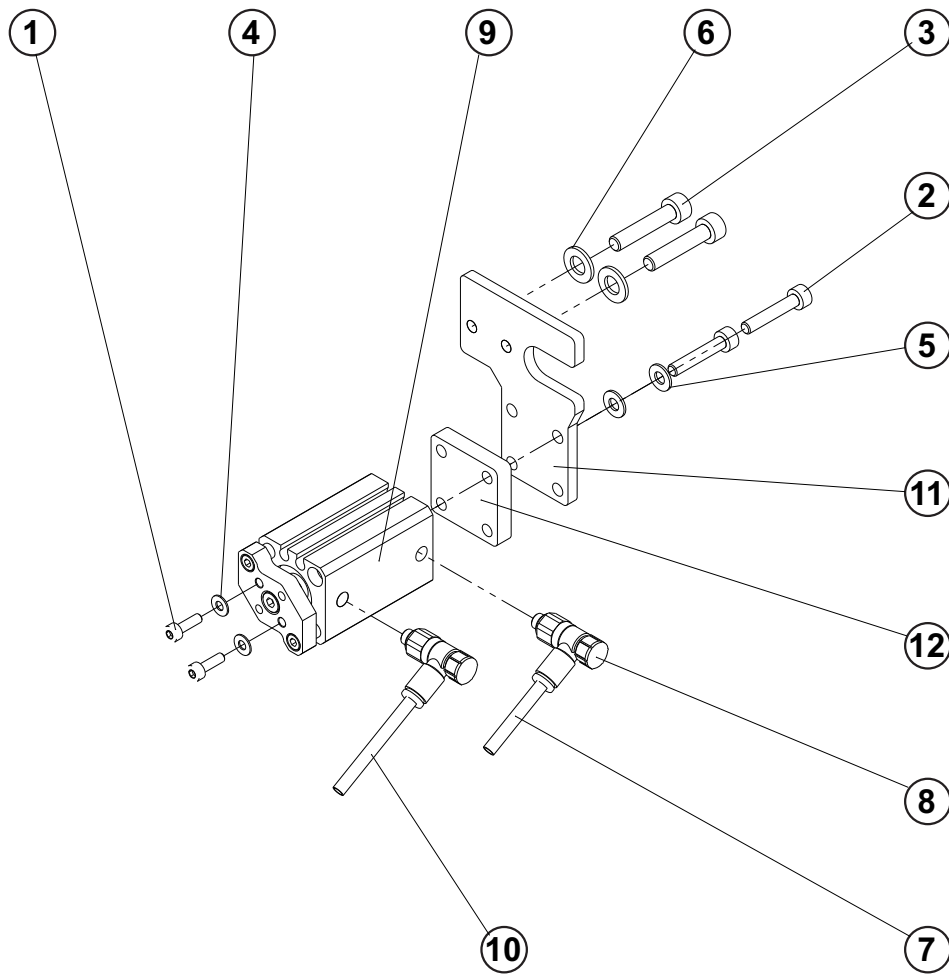


# RIGHT CLAMP SECTION-STANDARD





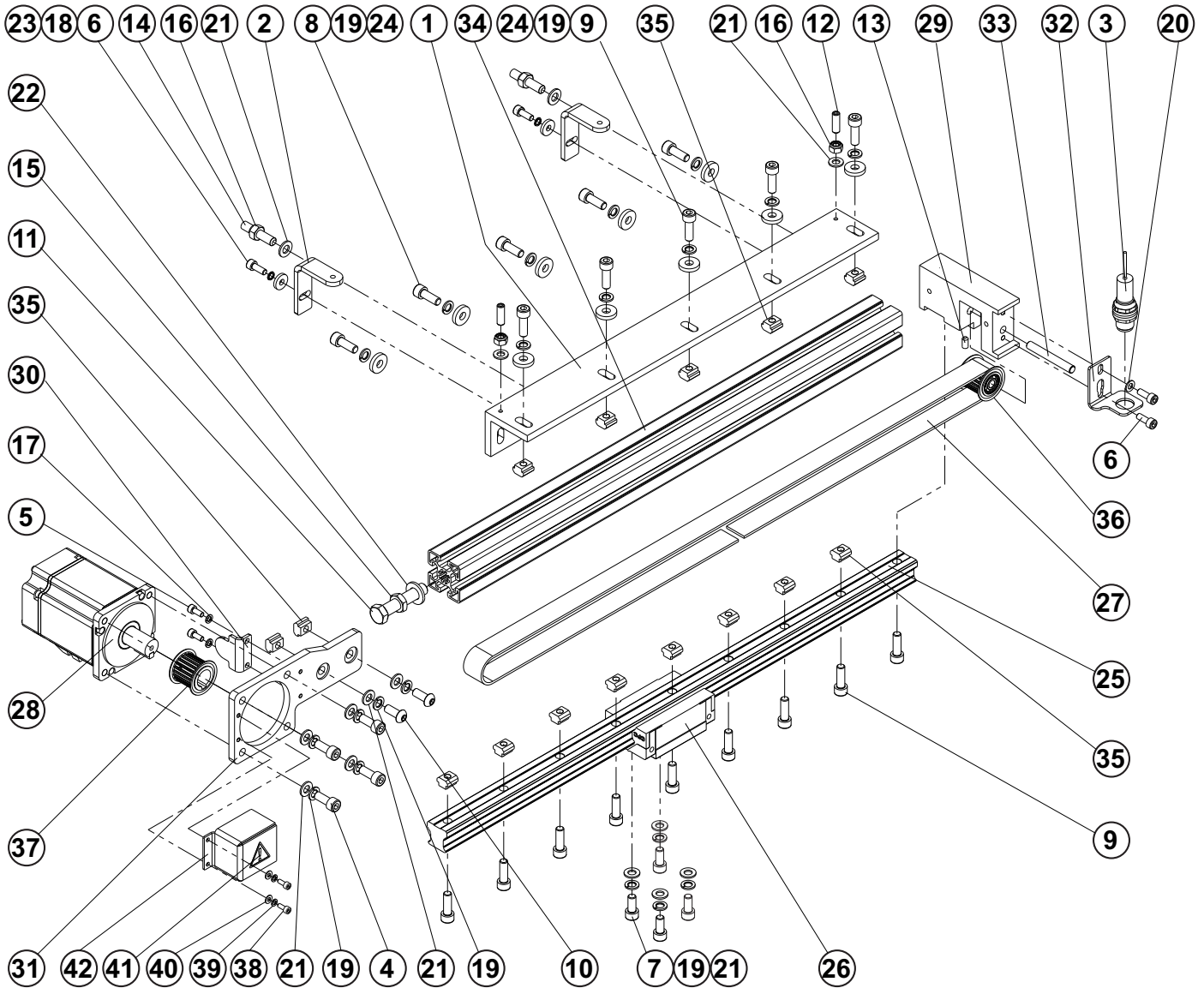
# CLAMP CARRIER-SPREADER RIGHT







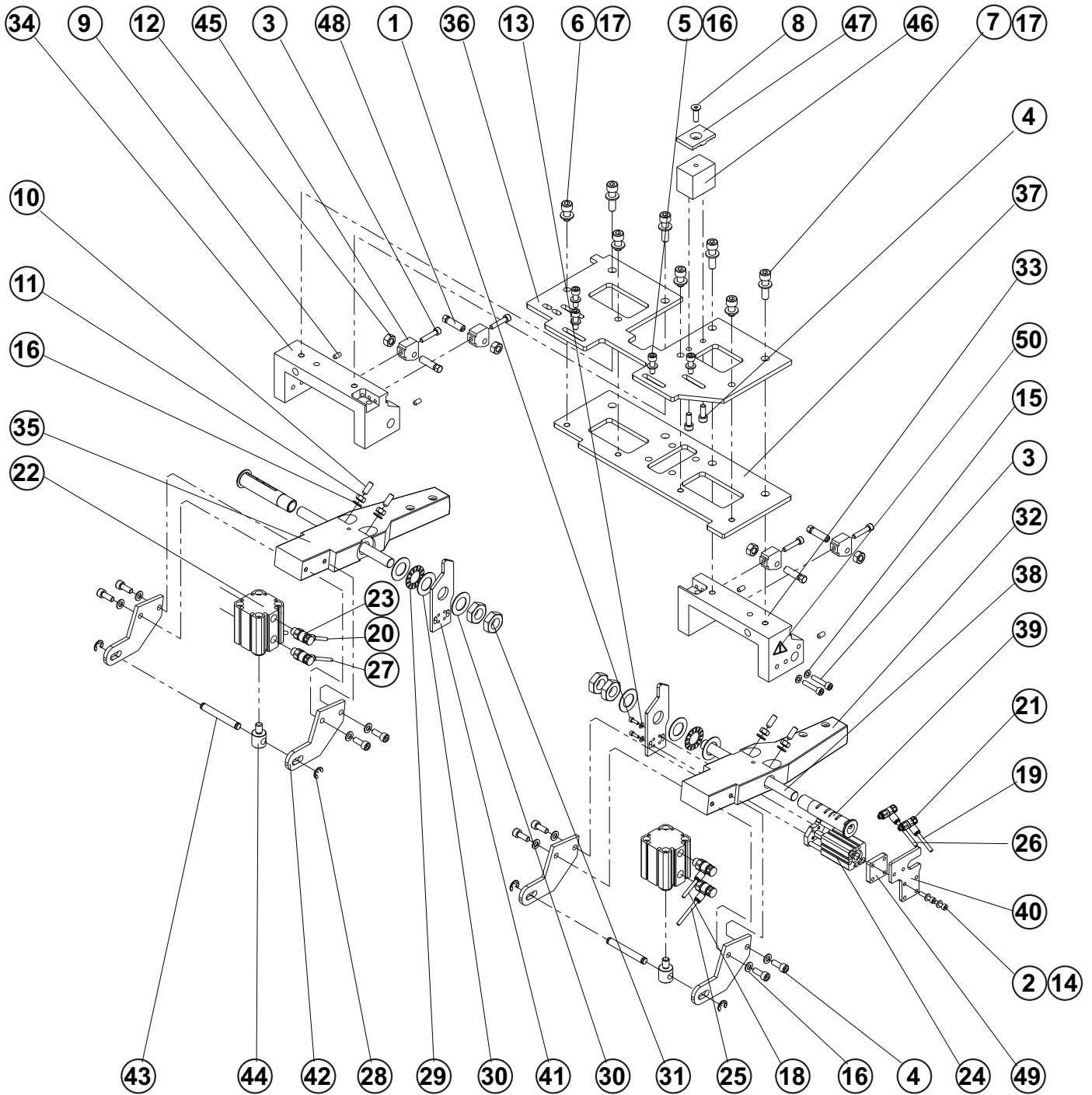
# CLAMP CARRIER SECTION-DRIVE AND GUIDE



## CLAMP CARRIER SECTION-DRIVE AND GUIDE

DET	PART NUMBER	DESCRIPTION	QTY.
01	04.9068.0.370	BRACKET	1
02	04.9068.0.371	PLEXI HOLDER	2
03	06.6800.0.028	SENSOR BQ8 ASSY./STACKER	1
04	08.6000.8.420	SCREW M8x1-20	4
05	08.6002.5.012	SCREW M5-12	2
06	08.6002.6.016	SCREW M6-16	4
07	08.6002.8.018	SCREW M8-18	4
08	08.6002.8.022	SCREW M8-22	13
09	08.6002.8.025	SCREW M8-25	6
10	08.6202.8.020	SCREW M8-20	2
11	08.6312.9.040	SCREW M12x40	1
12	08.6400.8.025	SCREW M8-25	2
13	08.6402.6.012	SCREW M6-12	1
14	08.6402.8.040	SCREW M8-40	2
15	08.6712.9.000	NUT M12	1
16	08.6702.8.000	NUT M8	4
17	08.6802.5.000	SPRING WASHER M5	2
18	08.6802.6.000	SPRING WASHER M6	2
19	08.6802.8.000	SPRING WASHER M8	20
20	08.6852.6.000	WASHER 6,4	1
21	08.6852.8.000	WASHER M8	14
22	08.6852.9.000	WASHER M12	1
23	08.6892.6.000	WASHER M6	2
24	08.6892.8.000	WASHER M8	10
25	12.2070.1.072	RAIL	1
26	12.2070.1.073	GUIDE	1
27	12.5050.2.033	BELT	
28	15.1144.0.000	SERVOMOTOR SMARTSTEP	1
29	68.0037.0.600	BRACKET	1
30	68.0046.0.800	PLATE	1
31	68.0047.0.800	BRACKET	1
32	68.0050.0.800	BRACKET	1
33	68.0043.0.300	SHAFT	1
34	68.0111.0.600	AL PROFILE	1
35	68.0222.0.100	T-SLOT NUT M8	15
36	68.0245.0.000	PULLEY	1
37	68.0246.0.500	MOTOR PULLEY	1
38	08.6002.4.010	SCREW M4-10	2
39	08.6802.4.000	SPRING WASHER M4	2
40	08.6852.4.000	WASHER M4	2
41	17.0097.5.174	LABEL - WARNING	1
42	68.0391.0.800	PULLEY COVER	1

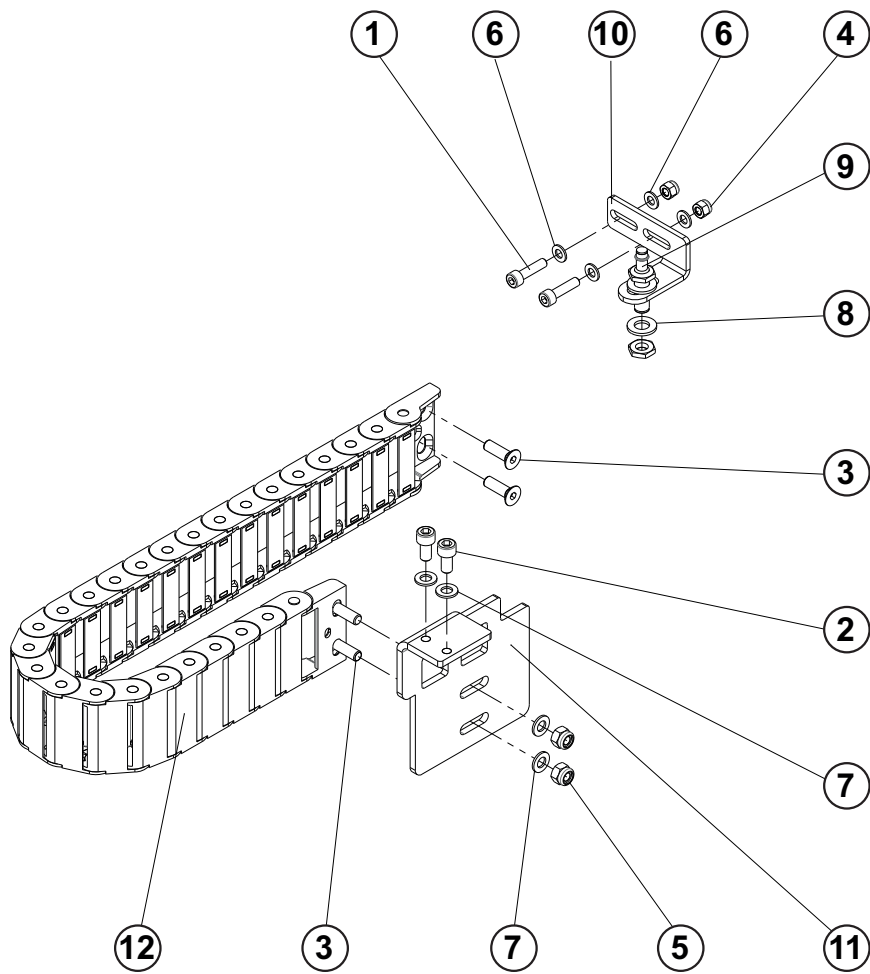
# CLAMP CARRIER SECTION-CLAMP ARM



## CLAMP CARRIER SECTION-CLAMP ARM

DET	PART NUMBER	DESCRIPTION	QTY.
01	08.6002.3.010	SCREW M3-10	2
02	08.6002.4.020	SCREW M4-20	2
03	08.6002.5.025	SCREW M5-25	6
04	08.6002.6.016	SCREW M6-16	10
05	08.6002.6.020	SCREW M6-20	4
06	08.6002.8.016	SCREW M8-16	4
07	08.6002.8.030	SCREW M8-30	4
08	08.6102.6.020	SCREW M6-20	1
09	08.6402.5.010	SCREW M5-10	4
10	08.6402.6.016	SCREW M6-16	4
11	08.6702.6.000	NUT M6	4
12	08.6702.8.000	NUT M8	4
13	08.6852.3.000	WASHER M3	2
14	08.6852.4.000	WASHER M4	2
15	08.6852.5.000	WASHER 5,3	2
16	08.6852.6.000	WASHER 6,4	16
17	08.6852.8.000	WASHER M8	8
18	12.0008.3.416	AIR TUBE- J3B	
19	12.0008.3.416	AIR TUBE- J6B1	
20	12.0008.3.416	AIR TUBE- J4B	
21	12.0010.3.047	SPEED CONTR.	2
22	12.0010.3.075	CYLINDER	2
23	12.0010.3.076	SPEED VALVE	4
24	12.0010.3.077	CYLINDER	1
25	12.0010.3.080	AIR TUBE- J3A	
26	12.0010.3.080	AIR TUBE- J6A1	
27	12.0010.3.080	AIR TUBE- J4A	
28	12.1045.0.007	RETAINER RING 7	4
29	12.2060.0.005	AXIAL BEARING	2
30	12.2099.5.001	AXIAL RING	6
31	68.0387.0.100	NUT M16	4
32	68.0031.0.600	BRACKET LEFT	1
33	68.0032.0.600	FIXING CLAMP LEFT	1
34	68.0033.0.600	FIXING CLAMP RIGHT	1
35	68.0034.0.600	BRACKET RIGHT	1
36	68.0035.0.800	BASE-SHEET	1
37	68.0036.0.800	BASE	1
38	68.0038.0.300	SHAFT	2
39	68.0039.0.400	BUSHING	2
40	68.0040.0.800	HOLDER	1
41	68.0041.0.800	CARRIER	2
42	68.0042.0.800	BRACKET WITH RUN	4
43	68.0043.0.300	GUIDE SHAFT	2
44	68.0044.0.300	ROD	2
45	68.0045.0.600	SIDE STOP	4
46	68.0048.0.600	BELT BRACKET	1
47	68.0049.0.600	FIXING PLATE	1
48	68.0052.0.100	SETTING SCREW	4
49	68.0214.0.800	DISTANCE PLATE	1
50	12.8000.0.409	LABEL	1

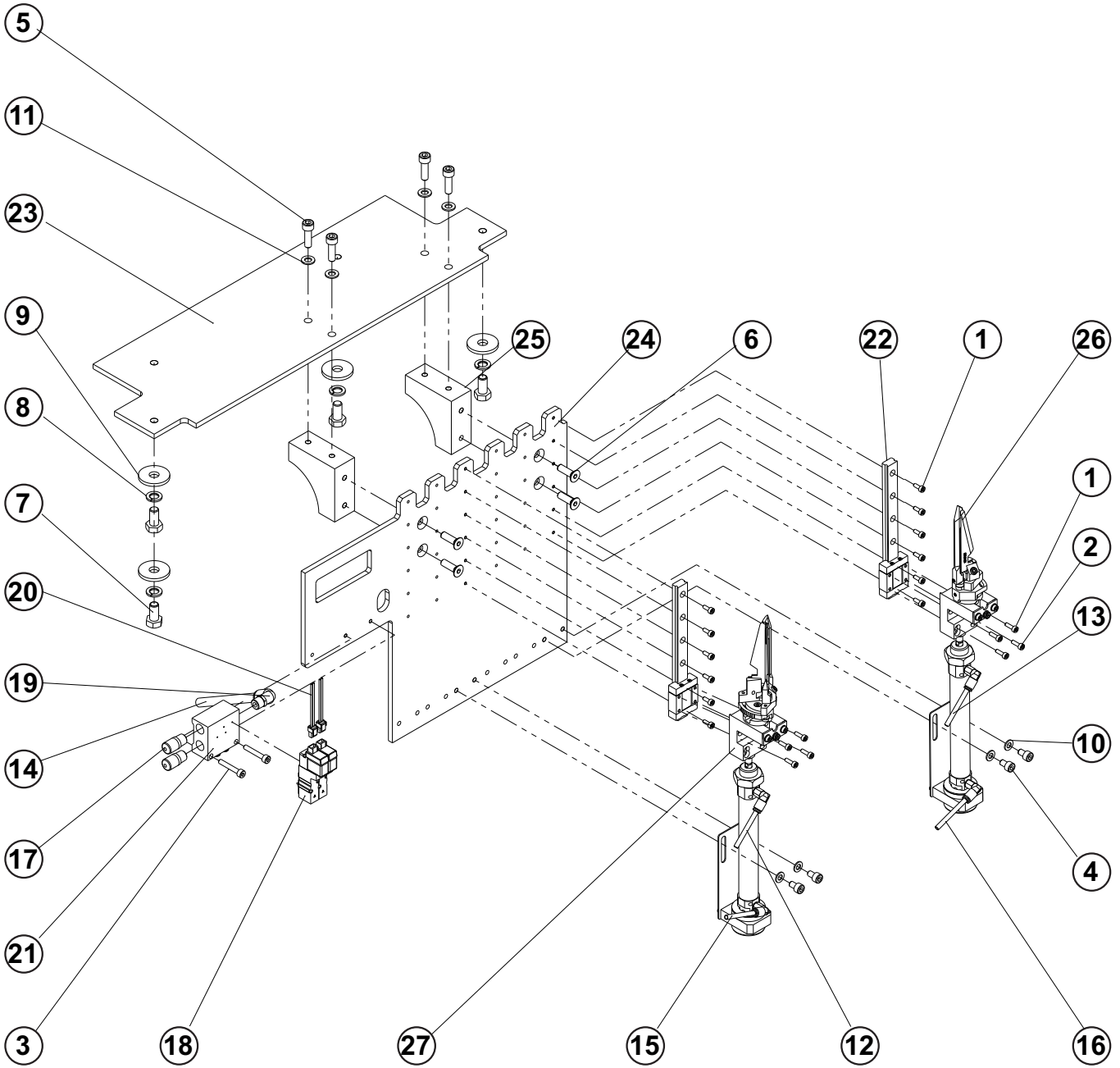
# CLAMP CARRIER SECTION-CHAIN AND SENZOR



## CLAMP CARRIER SECTION-CHAIN AND SENZOR

DET	PART NUMBER	DESCRIPTION	QTY.
01	08.6002.5.020	SCREW M5-20	2
02	08.6002.6.012	SCREW M6-12	2
03	08.6102.6.020	SCREW M6-20	4
04	08.6732.5.000	NUT M5	2
05	08.6732.6.000	NUT M6	2
06	08.6852.5.000	WASHER 5,3	4
07	08.6852.6.000	WASHER M6	4
08	08.6852.8.000	WASHER M8	2
09	12.0010.4.093	SENSOR	1
10	68.0210.0.800	SENSOR BRACKET	1
11	68.0211.0.800	CHAIN HOLDER	1
12	68.0410.0.050	CABLE DRAG CHAIN	1

# CORNER KNIFE UNIT ASSEMBLY-2 UNIT

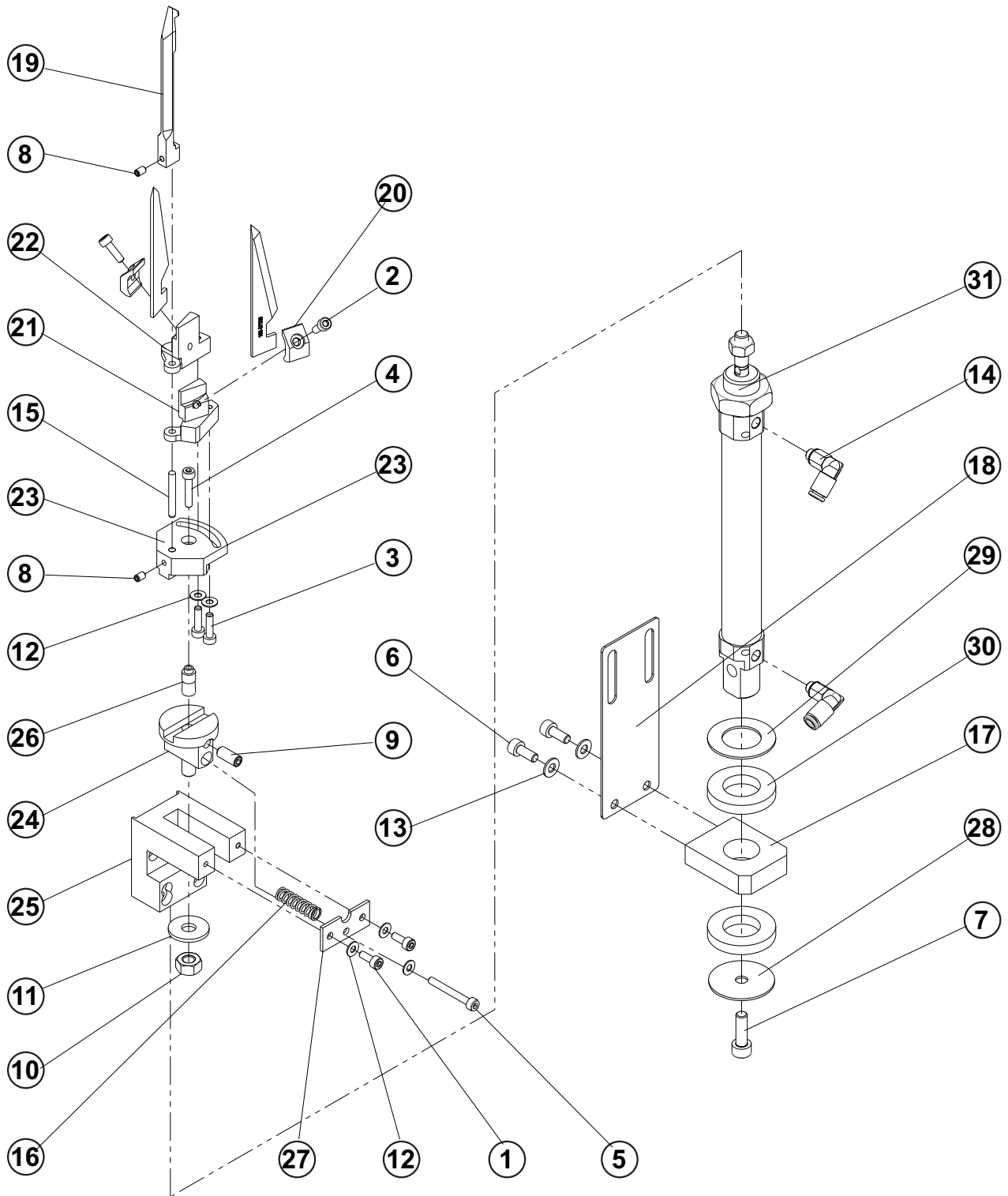




**CORNER KNIFE UNIT ASSEMBLY-2 UNIT**

DET	PART NUMBER	DESCRIPTION	QTY.
01	08.6002.3.008	SCREW M3-8	16
02	08.6002.3.016	SCREW M3-16	4
03	08.6002.4.025	SCREW M4-25	2
04	08.6002.5.008	SCREW M5-8	4
05	08.6002.6.020	SCREW M6-20	4
06	08.6102.6.020	SCREW M6-20	4
07	08.6312.8.016	SCREW M8-16	4
08	08.6802.8.000	SPRING WASHER M8	4
09	08.6842.8.000	WASHER M8	4
10	08.6852.5.000	WASHER 5,3	4
11	08.6852.6.000	WASHER 6,4	4
12	12.0008.3.416	AIR TUBE- J25B	
13	12.0008.3.416	AIR TUBE- J22B	
14	12.0008.3.431	AIR TUBING - J0A2	
15	12.0010.3.080	AIR TUBE- J25A	
16	12.0010.3.080	AIR TUBE- J22A	
17	12.0010.3.099	SILENCER	2
18	12.0010.3.105	5/2 VALVE	2
19	12.0010.3.106	CONNECTOR	1
20	12.0010.3.108	CABLE	2
21	12.0010.3.110	MANIFOLD PLATE	1
22	12.2070.1.069	GUIDE	2
23	68.0184.0.800	KNIFE BRACKET	1
24	68.0206.0.800	KNIFE BRACKET	1
25	68.0207.0.600	ALUMINIUM ANGLE	2
26	68.9031.0.050	CORNER KNIFE UNIT RIGHT	1
27	68.9032.0.050	CORNER KNIFE UNIT LEFT	1

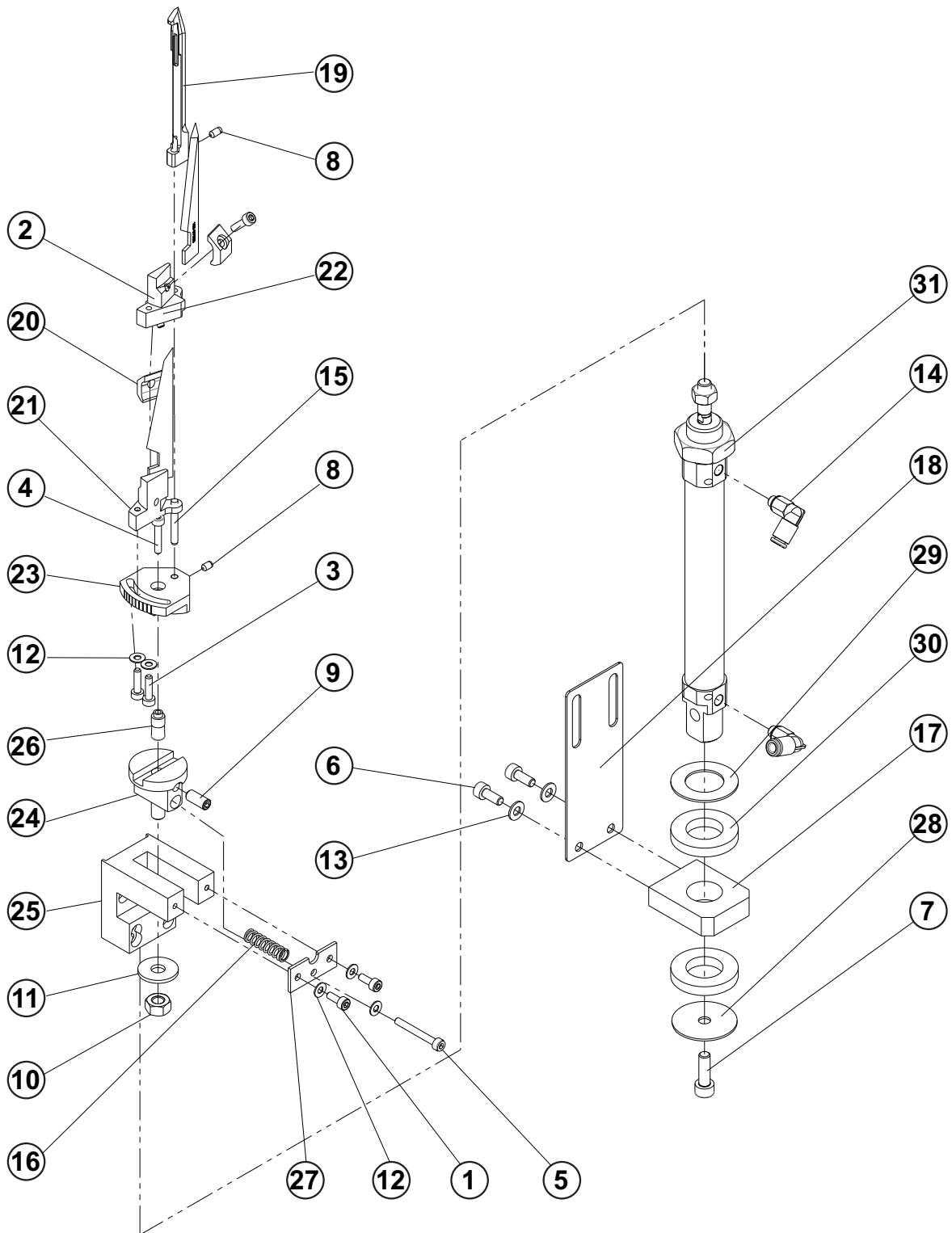
# CORNER KNIFE UNIT RIGHT



## CORNER KNIFE UNIT RIGHT

DET	PART NUMBER	DESCRIPTION	QTY.
01	08.6002.3.008	SCREW M3-8	2
02	08.6002.3.010	SCREW M3-10	2
03	08.6002.3.012	SCREW M3-12	2
04	08.6002.3.016	SCREW M3-16	1
05	08.6002.3.025	SCREW M3-25	1
06	08.6002.4.010	SCREW M4-10	2
07	08.6002.5.016	SCREW M5-16	1
08	08.6402.3.005	SCREW M3-5	2
09	08.6402.5.012	SCREW M5-12	1
10	08.6702.6.000	NUT M6	1
11	08.6842.6.000	WASHER M6	1
12	08.6852.3.000	WASHER M3	5
13	08.6852.4.000	WASHER M4	2
14	12.0010.3.028	CONNECTOR	2
15	12.1010.2.022	PIN	1
16	68.0025.0.200	SPRING	1
17	68.0188.0.600	BRACKET	1
18	68.0189.1.800	BRACKET-LONG VERSION	1
19	68.0190.0.600	KNIFE PROTECTION	1
20	68.0191.0.600	KNIFE HOLDER	2
21	68.0192.0.600	KNIFE HOLDER	1
22	68.0193.0.600	KNIFE HOLDER	1
23	68.0194.0.600	BASE	1
24	68.0195.0.300	BRACKET	1
25	68.0196.0.600	BASE OF UNIT	1
26	68.0197.0.300	PIN	1
27	68.0198.0.800	PLATE	1
28	68.0202.0.800	WASHER	1
29	68.0203.0.800	WASHER	1
30	68.0204.0.990	RUBBER WASHER	2
31	68.0208.0.000	KNIFE CYLINDER	1

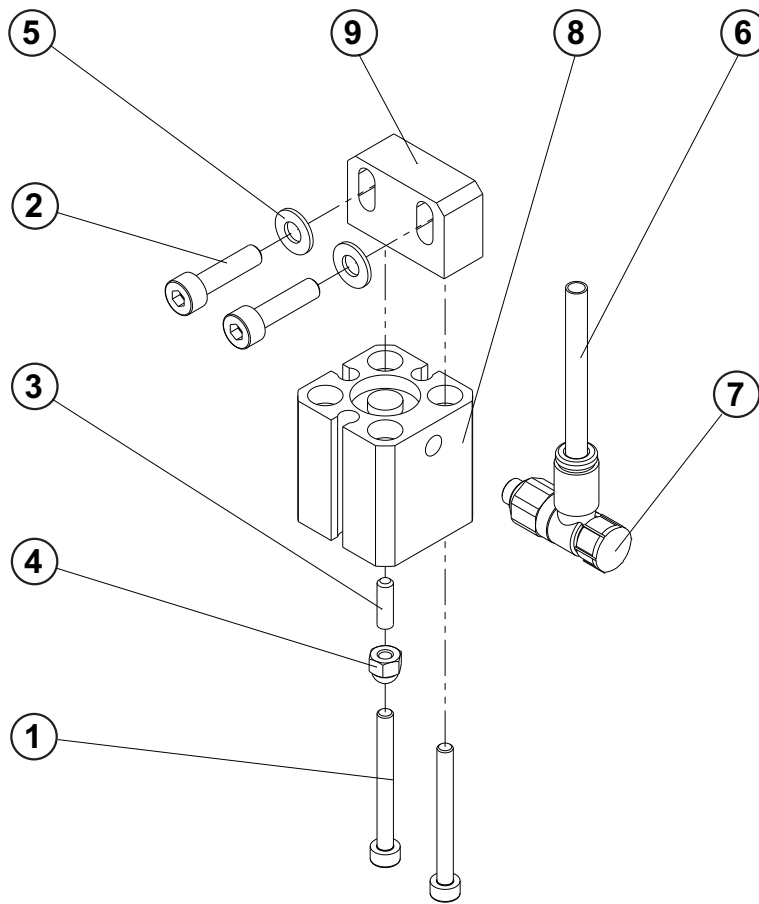
# CORNER KNIFE UNIT LEFT



## CORNER KNIFE UNIT LEFT

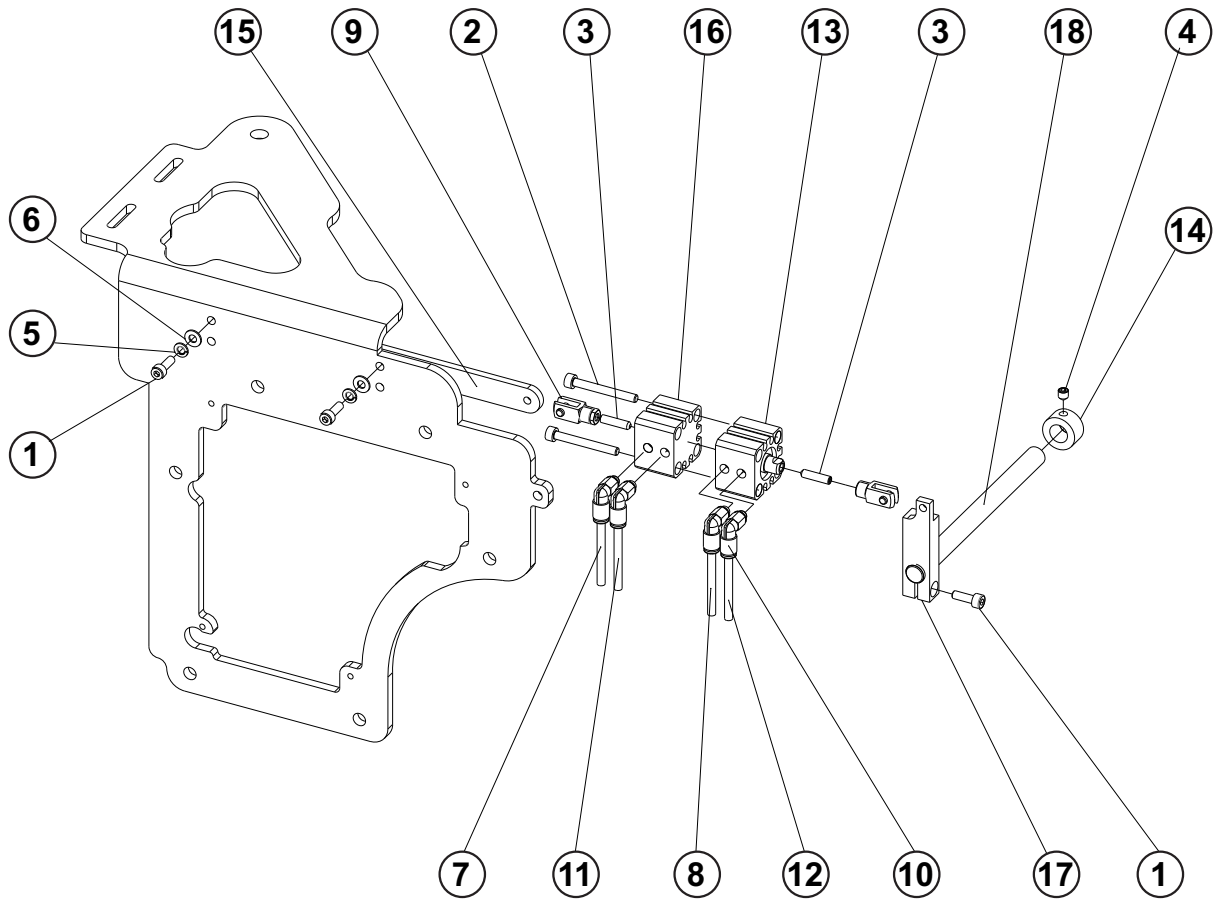
DET	PART NUMBER	DESCRIPTION	QTY.
01	08.6002.3.008	SCREW M3-8	2
02	08.6002.3.010	SCREW M3-10	2
03	08.6002.3.012	SCREW M3-12	2
04	08.6002.3.016	SCREW M3-16	1
05	08.6002.3.025	SCREW M3-25	1
06	08.6002.4.010	SCREW M4-10	2
07	08.6002.5.016	SCREW M5-16	1
08	08.6402.3.005	SCREW M3-5	2
09	08.6402.5.012	SCREW M5-12	1
10	08.6702.6.000	NUT M6	1
11	08.6842.6.000	WASHER M6	1
12	08.6852.3.000	WASHER M3	5
13	08.6852.4.000	WASHER M4	2
14	12.0010.3.028	CONNECTOR	2
15	12.1010.2.022	PIN	1
16	68.0025.0.200	SPRING	1
17	68.0188.0.600	BRACKET	1
18	68.0189.1.800	BRACKET-LONG VERSION	1
19	68.0190.0.600	KNIFE PROTECTION	1
20	68.0191.0.600	KNIFE HOLDER	2
21	68.0192.0.600	KNIFE HOLDER	1
22	68.0193.0.600	KNIFE HOLDER	1
23	68.0194.0.600	BASE	1
24	68.0195.0.300	BRACKET	1
25	68.0196.0.600	BASE OF UNIT	1
26	68.0197.0.300	PIN	1
27	68.0198.0.800	PLATE	1
28	68.0202.0.800	WASHER	1
29	68.0203.0.800	WASHER	1
30	68.0204.0.990	RUBBER WASHER	2
31	68.0208.0.000	KNIFE CYLINDER	1

# BACKTACKING





# SPLIT NEEDLE MECHANISM - AP

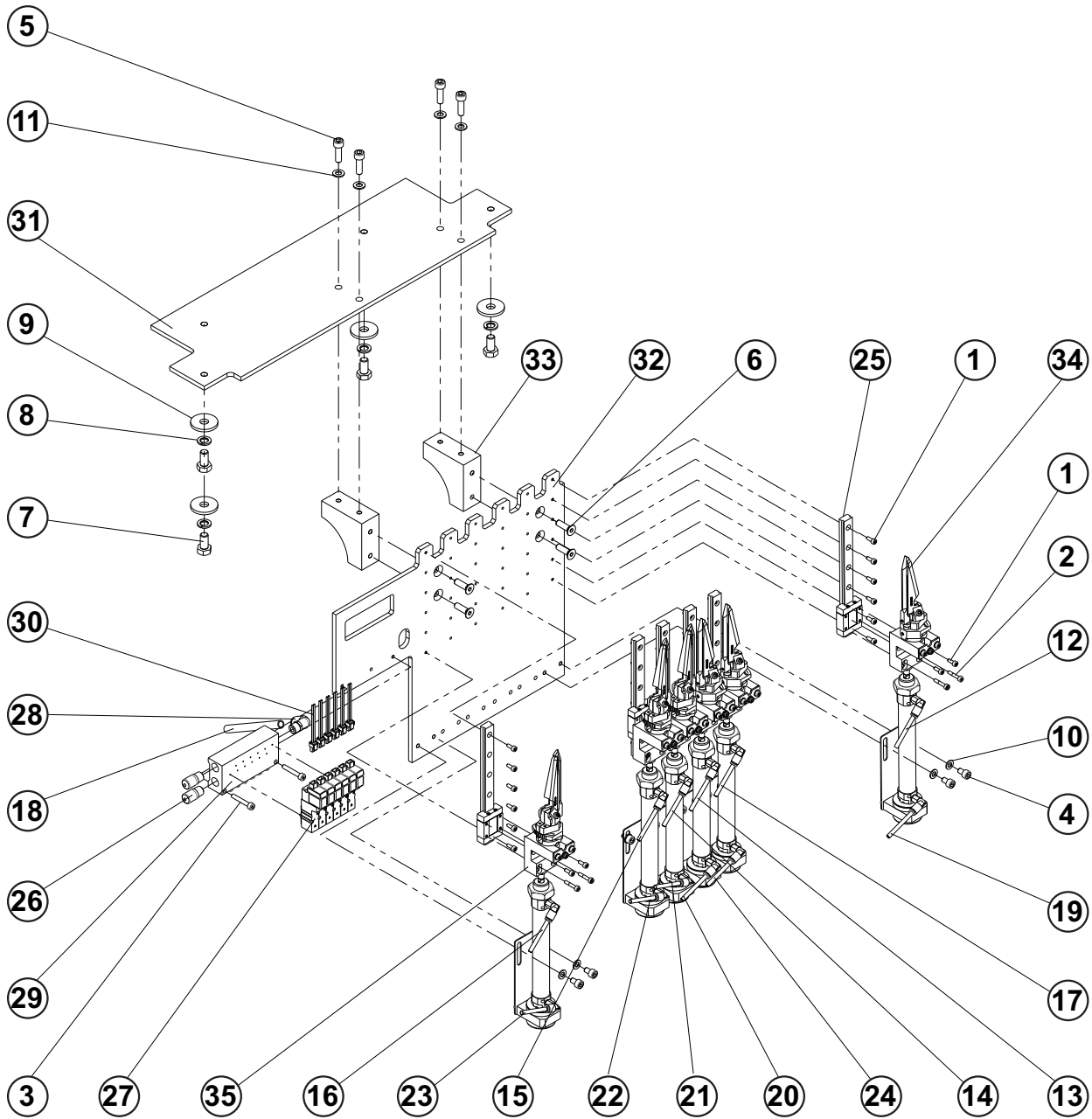




**SPLIT NEEDLE MECHANISM - AP**

<b>DET</b>	<b>PART NUMBER</b>	<b>DESCRIPTION</b>	<b>QTY.</b>
01	08.6002.4.012	SCREW M4-12	3
02	08.6002.4.035	SCREW M4-35	2
03	08.6402.4.016	SCREW M4-16	2
04	08.6402.5.005	SCREW M5-5	1
05	08.6802.4.000	SPRING WASHER M4	2
06	08.6852.4.000	WASHER M4	2
07	12.0008.3.416	AIR TUBE- J19B	—
08	12.0008.3.416	AIR TUBE- J20B	—
09	12.0008.3.738	KNUCKLE	2
10	12.0010.3.028	CONNECTOR	4
11	12.0010.3.080	AIR TUBE- J19A	—
12	12.0010.3.080	AIR TUBE- J20A	—
13	12.0010.3.189	CYLINDER	1
14	12.1050.0.005	CLAMP COLLAR 10	1
15	68.0140.0.800	HOLDER	1
16	68.0141.0.000	CYLINDER	1
17	68.0142.0.600	LEVER	1
18	68.0143.0.300	SHAFT	1

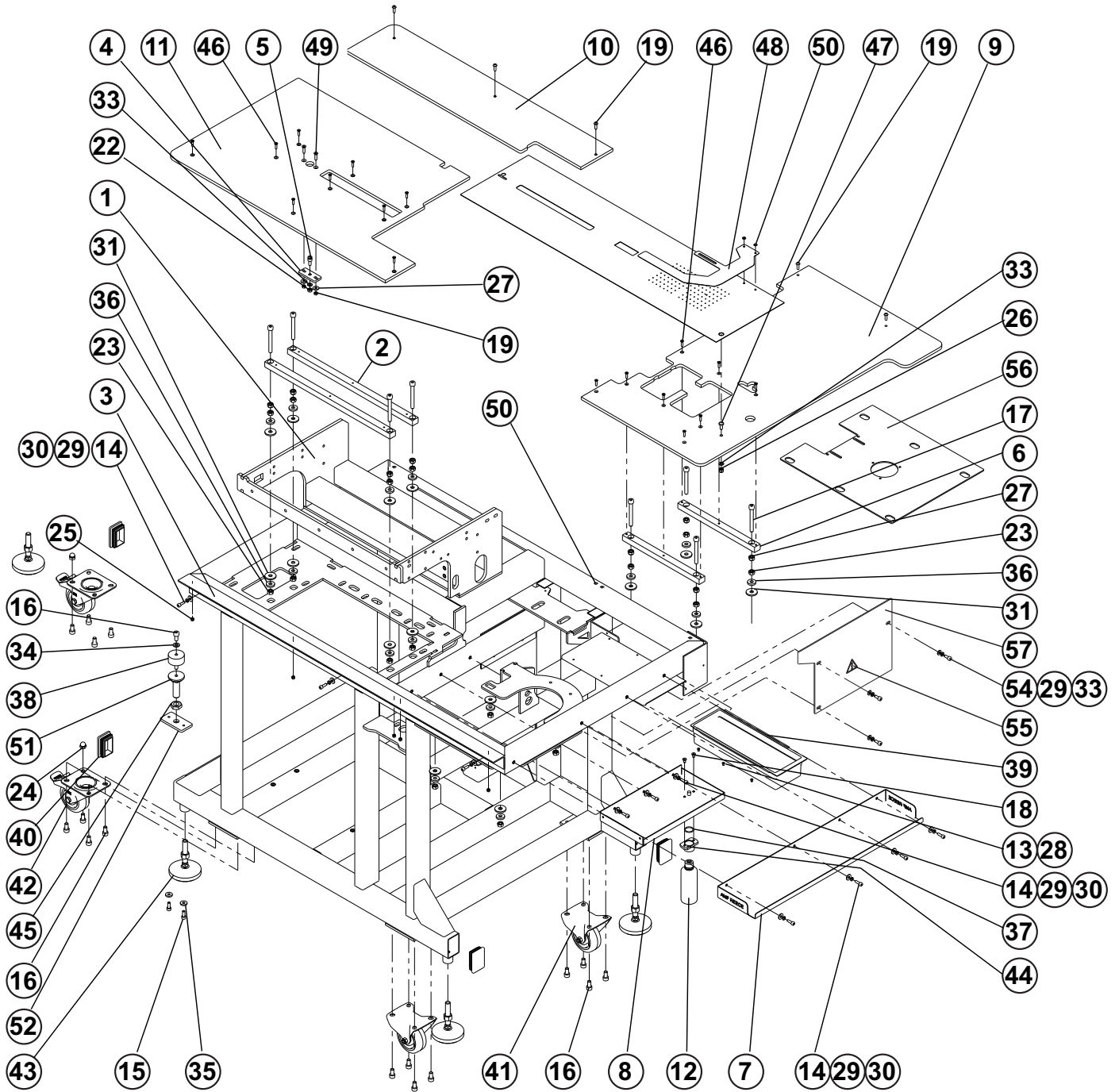
# CORNER KNIFE UNIT ASSEMBLY - 6 UNIT - AP



## CORNER KNIFE UNIT ASSEMBLY - 6 UNIT - AP

DET	PART NUMBER	DESCRIPTION	QTY.
01	08.6002.3.008	SCREW M3-8	48
02	08.6002.3.016	SCREW M3-16	12
03	08.6002.4.025	SCREW M4-25	2
04	08.6002.5.008	SCREW M5-8	12
05	08.6002.6.020	SCREW M6-20	4
06	08.6102.6.020	SCREW M6-20	4
07	08.6312.8.016	SCREW M8-16	4
08	08.6802.8.000	SPRING WASHER M8	4
09	08.6842.8.000	WASHER M8	4
10	08.6852.5.000	WASHER 5,3	12
11	08.6852.6.000	WASHER 6,4	4
12	12.0008.3.416	AIR TUBE- J22B	—
13	12.0008.3.416	AIR TUBE- J24B	—
14	12.0008.3.416	AIR TUBE- J25B	—
15	12.0008.3.416	AIR TUBE- J26B	—
16	12.0008.3.416	AIR TUBE- J27B	—
17	12.0008.3.416	AIR TUBE- J23B	—
18	12.0008.3.431	AIR TUBING - J0A2	—
19	12.0010.3.080	AIR TUBE- J22A	—
20	12.0010.3.080	AIR TUBE- J24A	—
21	12.0010.3.080	AIR TUBE- J25A	—
22	12.0010.3.080	AIR TUBE- J26A	—
23	12.0010.3.080	AIR TUBE- J27A	—
24	12.0010.3.080	AIR TUBE- J23A	—
25	12.2070.1.069	GUIDE	6
26	12.0010.3.099	SILENCER	2
27	12.0010.3.105	5/2 VALVE	6
28	12.0010.3.106	CONNECTOR	1
29	12.0010.3.107	MANIFOLD PLATE	1
30	12.0010.3.108	CABLE	6
31	68.0205.0.800	KNIFE BRACKET	1
32	68.0206.0.800	KNIFE BRACKET	1
33	68.0207.0.600	ALUMINIUM ANGLE	2
34	68.9031.0.050	CORNER KNIFE UNIT RIGHT	3
35	68.9032.0.050	CORNER KNIFE UNIT LEFT	3

# TABLE ASSEMBLY - BASE

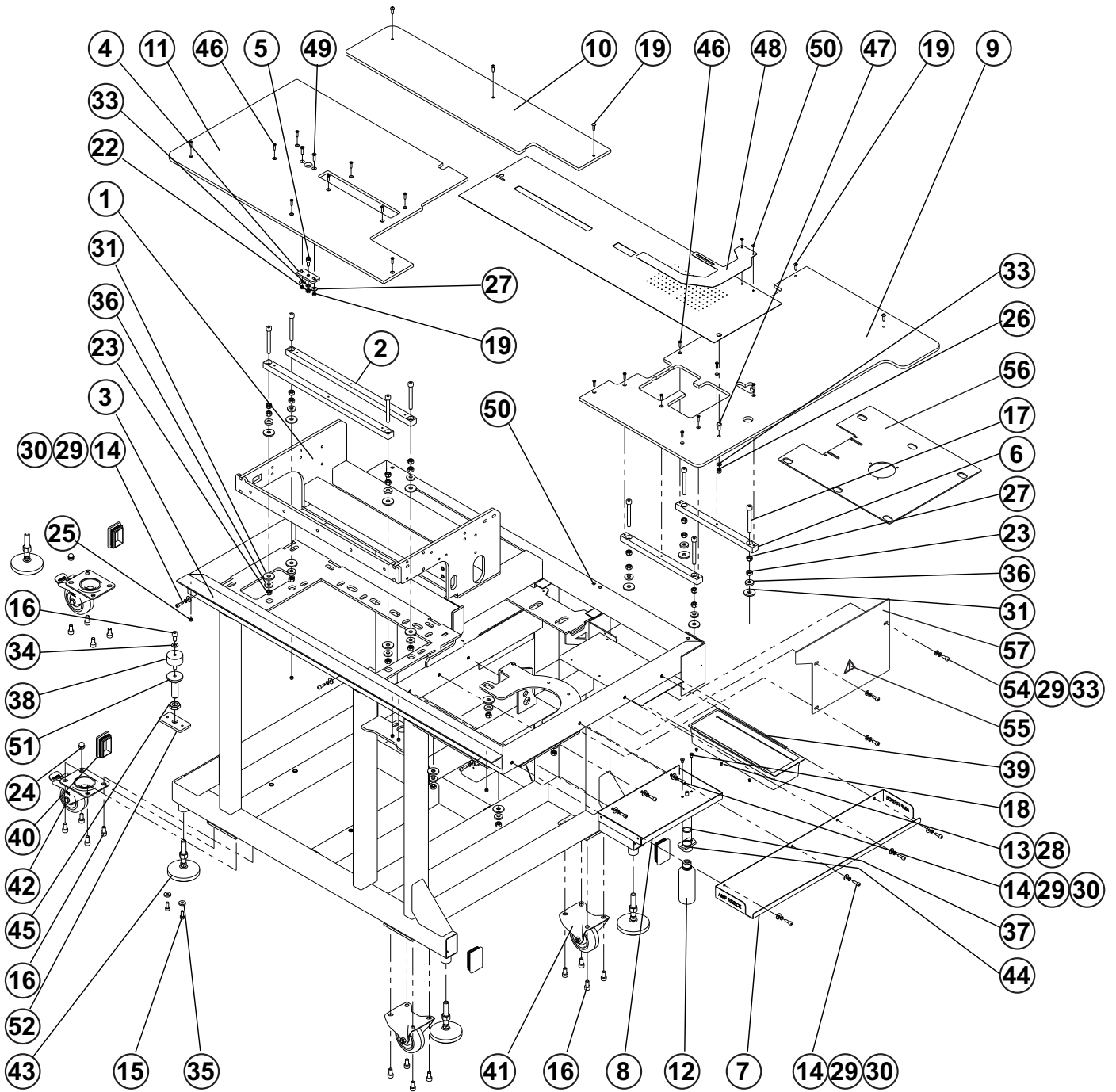


## TABLE ASSEMBLY - BASE

DET	PART NUMBER	DESCRIPTION	QTY.
01	04.9068.0.050	FRAME KIT	1
02	04.9068.0.361	TABLE SUPPORT	2
03	04.9068.0.363	LEFT TABLE SUPPORT	1
04	04.9068.0.364	PLATE	1
05	04.9068.0.365	STUD	1
06	04.9068.0.366	TABLE SUPPORT FRONT	2
07	04.9068.0.367	BOX	1
08	04.9068.0.368	OIL BATH	1
09	04.9068.0.900	TABLE FRONT	1
10	04.9068.0.901	TABLE RIGHT	1
11	04.9068.0.902	TABLE LEFT	1
12	05.1322.0.000	OIL RESERVOIR	1
13	08.6002.4.005	SCREW M4-5	6
14	08.6002.5.016	SCREW M5-16	10
15	08.6002.6.016	SCREW M6-16	2
16	08.6002.8.016	SCREW M8-16	17
17	08.6002.8.070	SCREW M8-70	8
18	08.6050.5.008	SCREW M5-8	2
19	08.6202.5.020	SCREW M5-20	4
20	08.6202.8.020	SCREW M8-20	1
21	08.6702.5.000	NUT M5	2
22	08.6702.6.000	NUT M6	1
23	08.6702.8.000	NUT M8	16
24	08.6722.8.000	NUT M8	2
25	08.6732.4.000	NUT M4	5
26	08.6732.6.000	NUT M6	1
27	08.6733.8.000	NUT M8	8
28	08.6802.4.000	SPRING WASHER M4	9
29	08.6802.5.000	SPRING WASHER M5	10
30	08.6842.5.000	WASHER 5	12
31	08.6842.8.000	WASHER M8	16
32	08.6852.4.000	WASHER M4	8
33	08.6852.6.000	WASHER 6,4	2
34	08.6852.8.000	WASHER M8	1
35	08.6892.6.000	WASHER M6	2
36	08.6892.8.000	WASHER M8	16
37	12.0008.6.812	O-RING 19x2	1
38	12.0008.6.819	SILENTBLOK 40	1
39	12.0008.6.901	BOX	1
40	12.0008.6.996	PLUG 60x40	4
41	12.0010.6.216	WHEEL	2
42	12.0010.6.217	WHEEL	2
43	12.0010.6.218	SHOCK AMOUNT	4
44	19.0044.5.404	HOLDER	1
45	52.0035.0.100	NUT M16	1
46	08.6132.4.016	SCREW M4-16	17



# TABLE ASSEMBLY - BASE

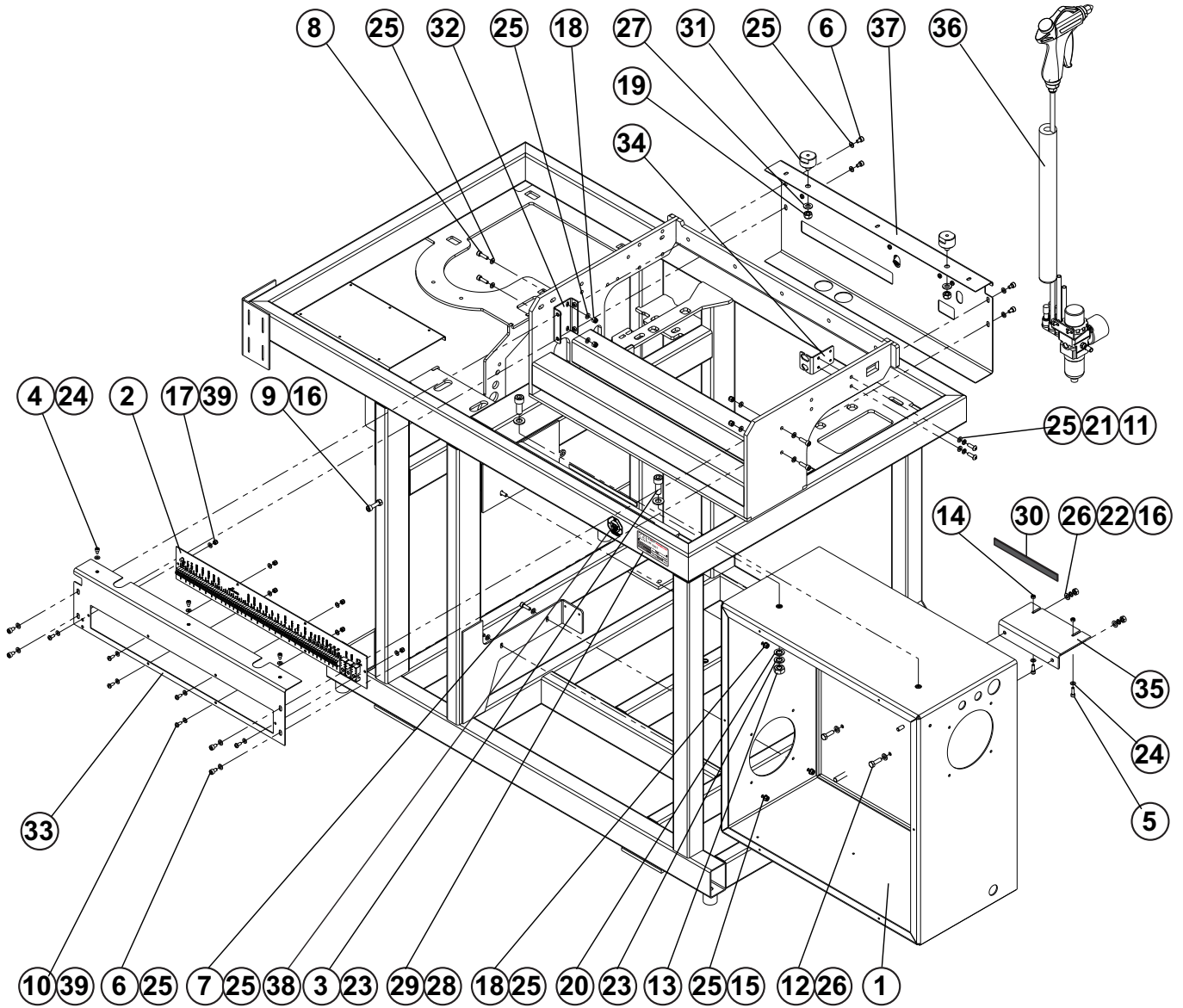


# TABLE ASSEMBLY - BASE



DET	PART NUMBER	DESCRIPTION	QTY.
47	68.0200.0.300	STUD	1
48	68.0201.0.800	SPLICE PLATE	1
49	08.6132.5.020	SCREW M5-20	2
50	68.0228.0.100	SCREW M4x0,5-1,5	2
51	68.0247.0.300	SETTING STUD	1
52	68.0248.0.800	PLATE	1
53	84.0004.6.940	ALU RIVNUT M5	5
54	08.6002.4.010	SCREW M4-10	3
55	17.0097.5.174	LABEL - WARNING	1
56	68.0259.1.800	PLATE	1
57	68.0392.0.800	MOTOR COVER	1

# TABLE ASSEMBLY - PNEUMATICS AND DRIVE

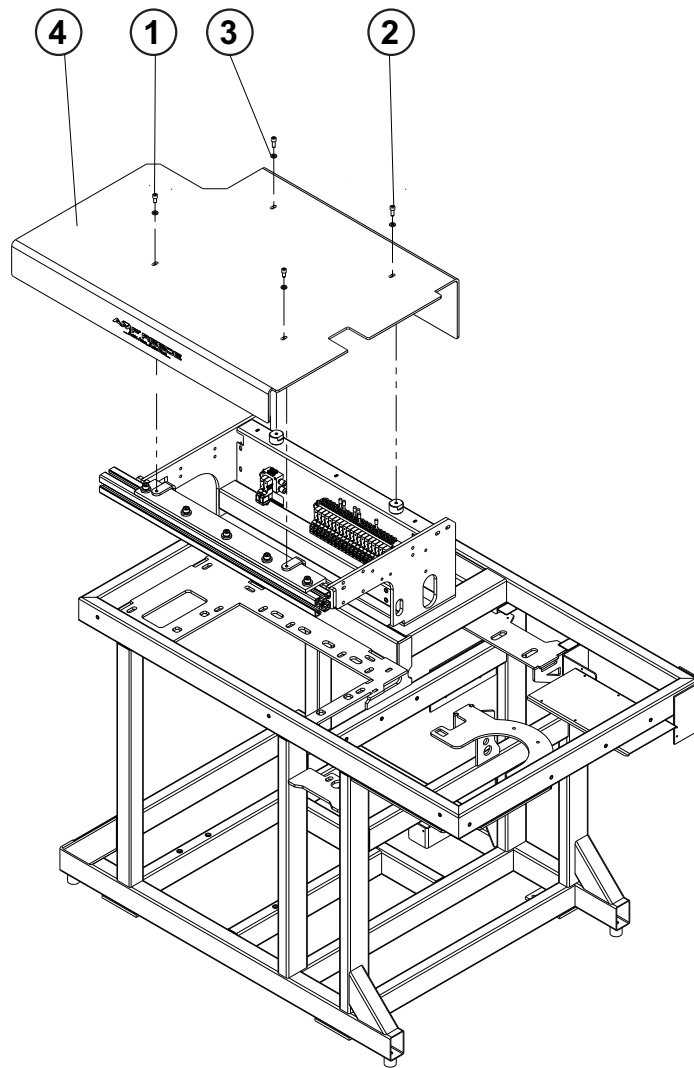




**TABLE ASSEMBLY - PNEUMATICS AND DRIVE**

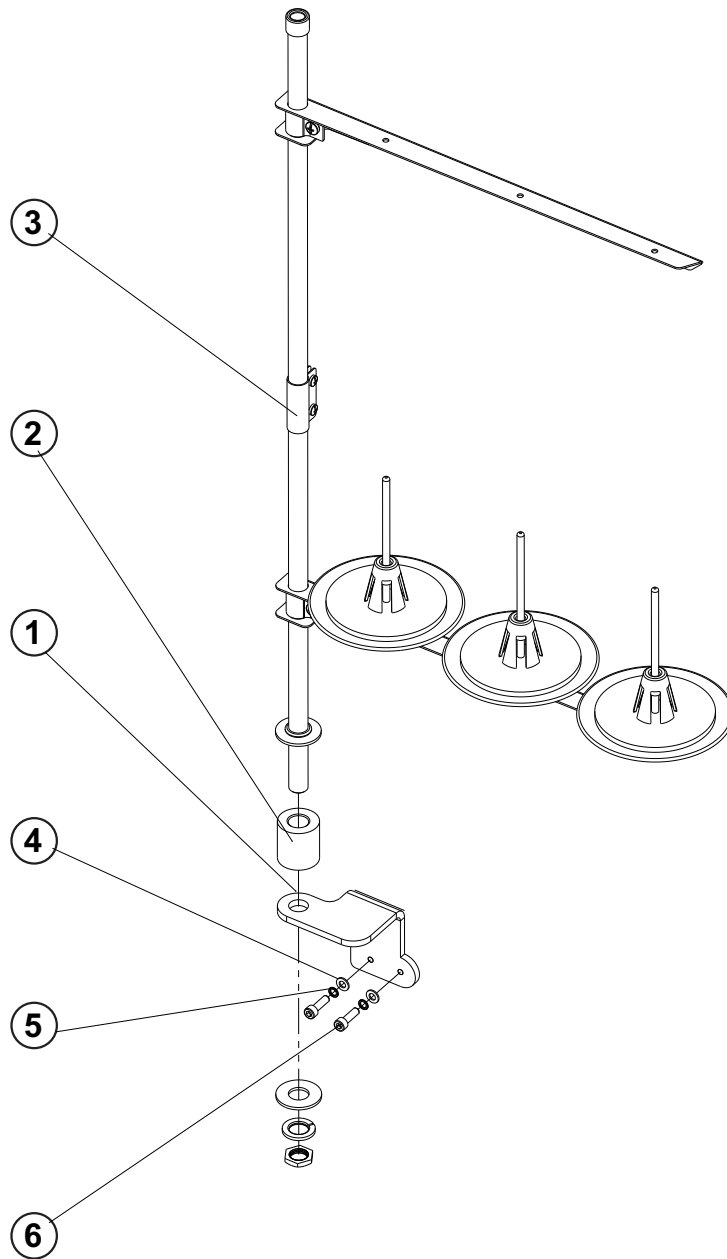
DET	PART NUMBER	DESCRIPTION	QTY.
01	04.9068.0.500	CONTROL BOX	1
02	06.6800.0.049	TB1 LW8000 ASSEMBLY	1
03	08.6002.0.025	SCREW M10-25	2
04	08.6002.4.006	SCREW M4-6	3
05	08.6002.4.014	SCREW M4-14	2
06	08.6002.5.008	SCREW M5-8	8
07	08.6002.5.016	SCREW M5-16	4
08	08.6002.5.018	SCREW M5-18	4
09	08.6002.6.045	SCREW M6-45	1
10	08.6032.3.010	SCREW M3-10	6
11	08.6202.5.016	SCREW M5-16	2
12	08.6312.6.020	SCREW M6-20	2
13	08.6702.0.000	NUT M10	2
14	08.6702.4.000	NUT M4	2
15	08.6702.5.000	NUT M5	2
16	08.6702.6.000	NUT M6	3
17	08.6733.3.000	NUT M3	6
18	08.6732.5.000	NUT M5	6
19	08.6733.8.000	NUT M8	2
20	08.6802.0.000	SPRING WASHER M10	2
21	08.6802.5.000	SPRING WASHER M5	4
22	08.6802.6.000	SPRING WASHER M6	2
23	08.6852.0.000	WASHER M10	4
24	08.6852.4.000	WASHER M4	5
25	08.6852.5.000	WASHER M5	26
26	08.6852.6.000	WASHER M6	4
27	08.6852.8.000	WASHER M8	2
28	12.1016.0.002	NAIL 1.86x6.35 (1/4)	2
29	12.8000.1.067	LABEL CE LW-7001	1
30	19.0094.0.414	GASKET	1
31	68.0212.0.300	STUD	2
32	68.0216.0.800	COVER HOLDER	2
33	68.0218.0.800	COVER LEFT	1
34	68.0219.0.800	SERVO CABLE HOLDER	1
35	68.6001.0.800	DRIVER HOLDER	1
36	68.7001.0.050	REGULATOR ASSY.	1
37	68.7002.0.050	VALVE BLOCK ASSY.	1
38	12.8000.0.438	LABEL - GUALITY TÜV SÜV	1
39	08.6852.3.000	WASHER M3	12

# TABLE ASSEMBLY - COVER





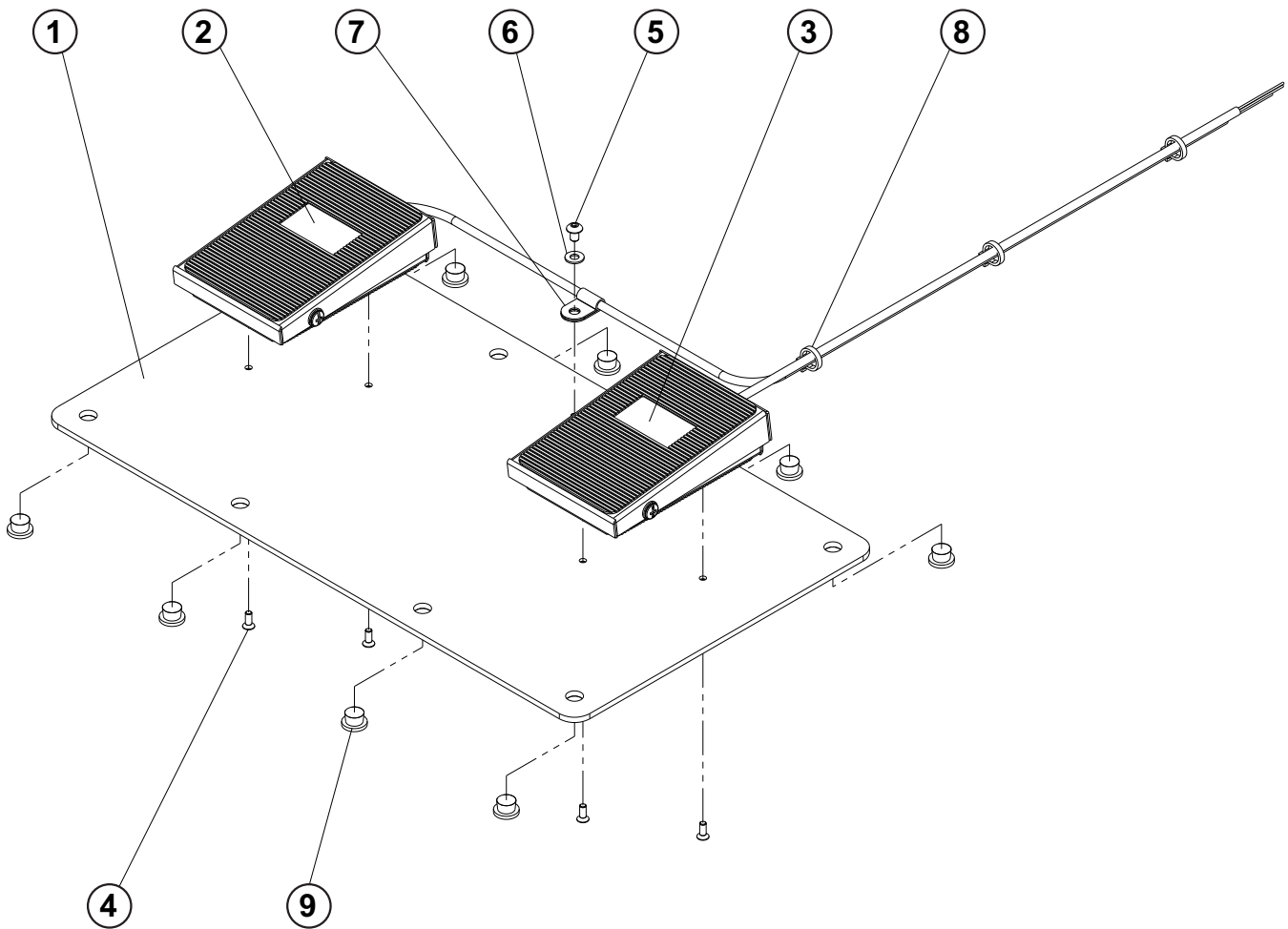
# THREAD STAND ASSEMBLY



**THREAD STAND ASSEMBLY**

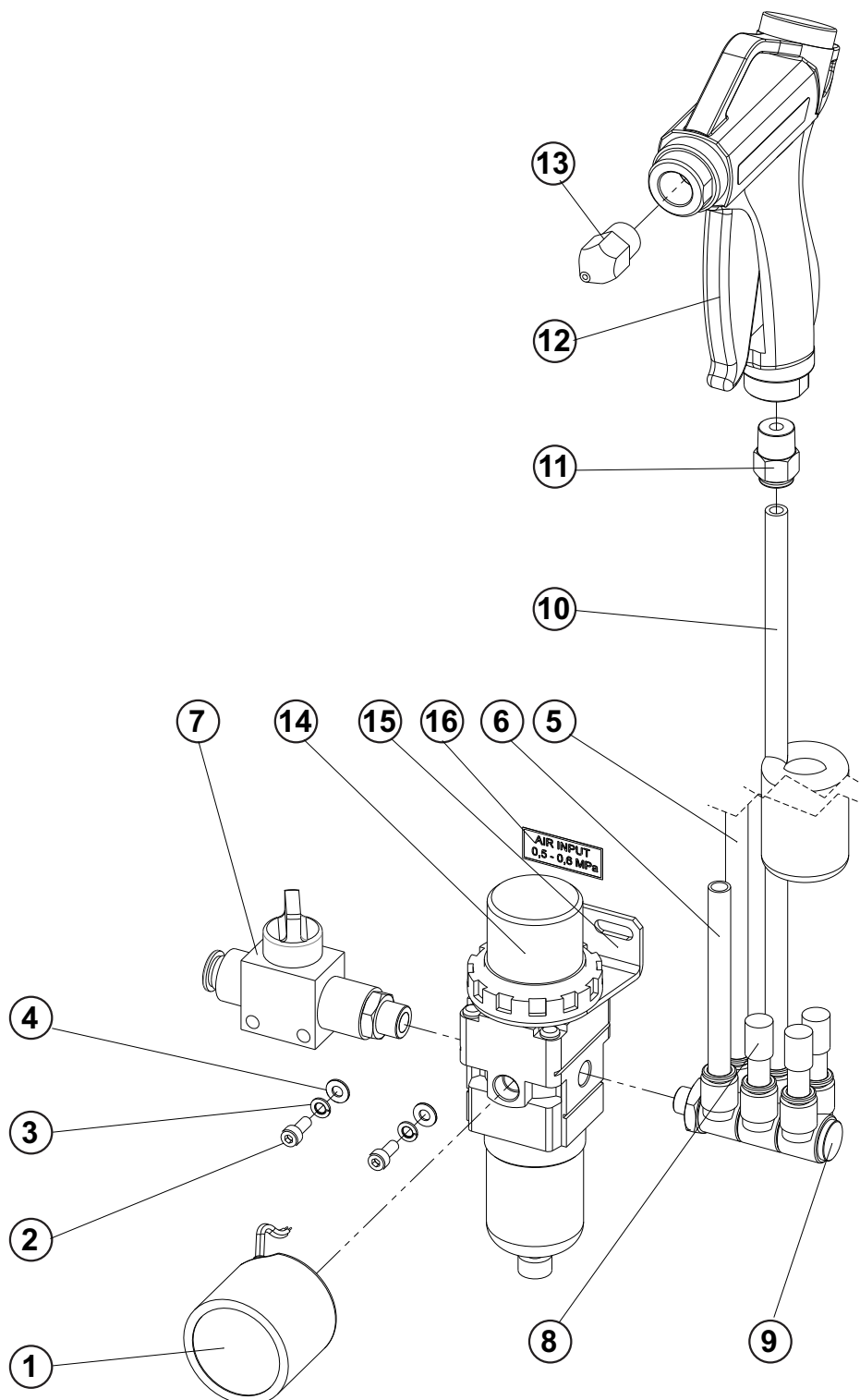
DET	PART NUMBER	DESCRIPTION	QTY.
01	68.0220.1.800	THREAD STAND BRACKET	1
02	68.0221.0.400	DISTANCE BUSHING	1
03	12.9900.9.010	THREAD STAND ASSY. 3-THREAD	1
04	08.6852.6.000	WASHER 6,4	2
05	08.6802.6.000	SPRING WASHER M6	2
06	08.6002.6.020	SCREW M6-20	2

# PEDAL ASSEMBLY





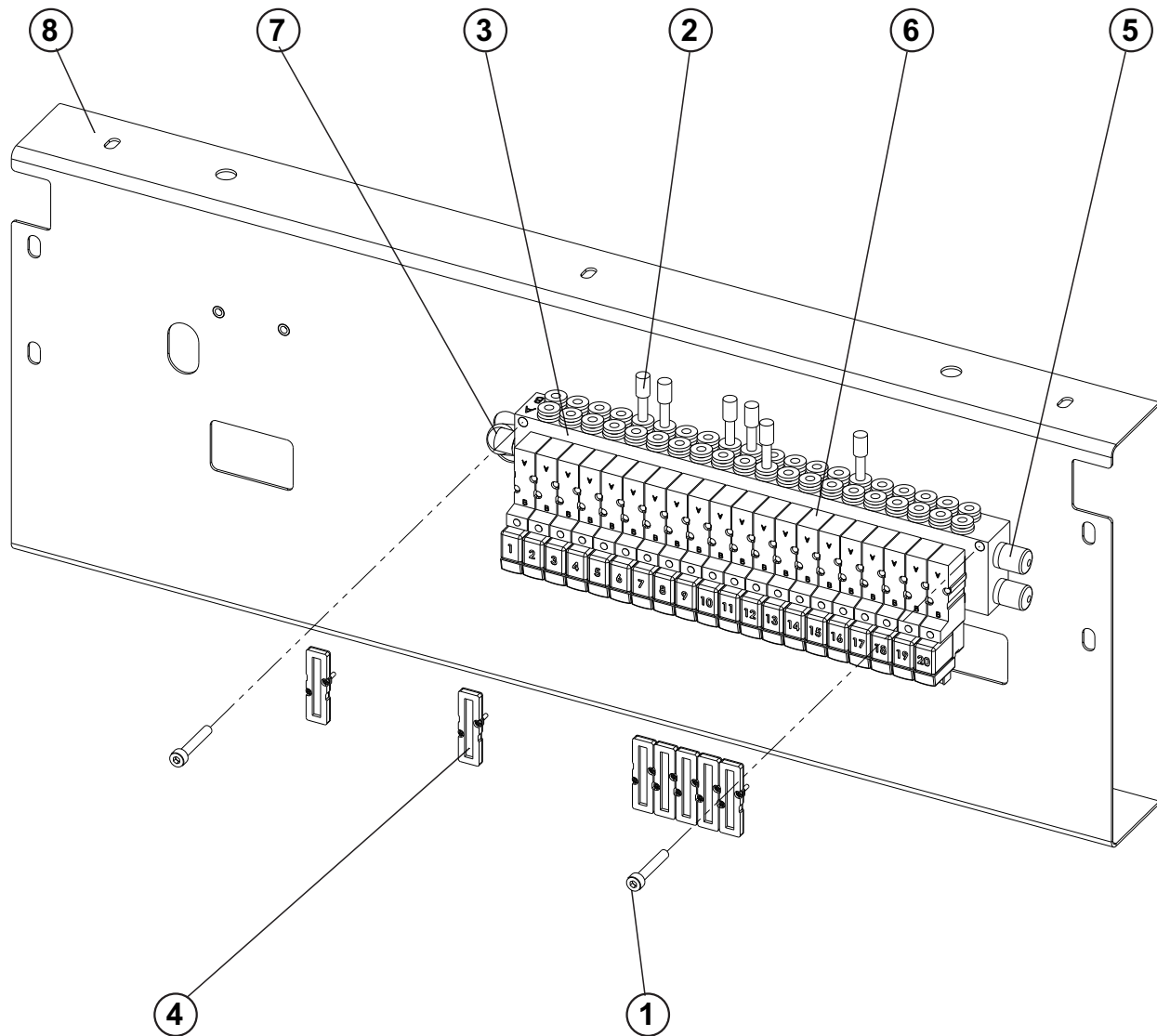
## REGULATOR ASSEMBLY





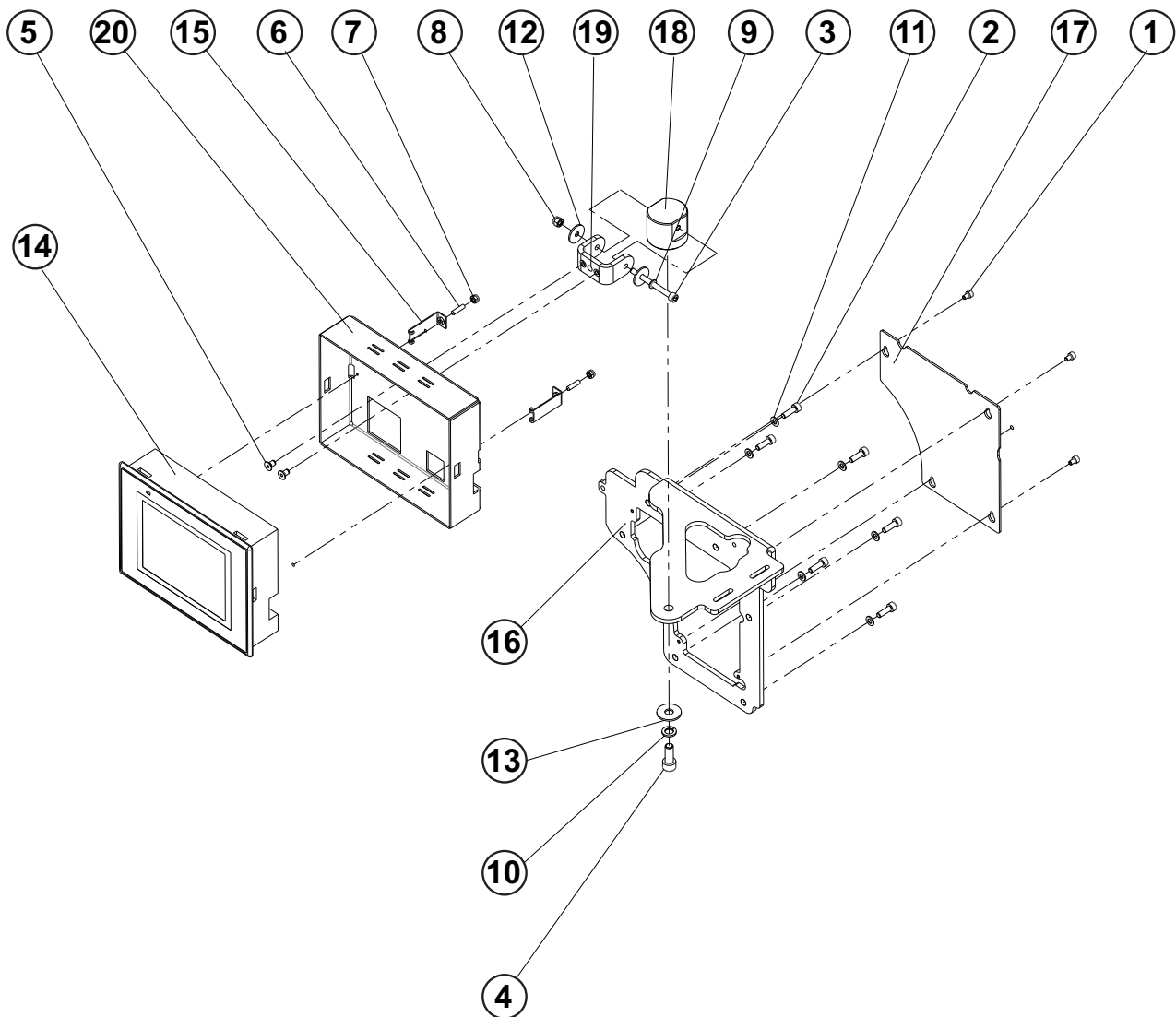


# VALVE BLOCK ASSEMBLY





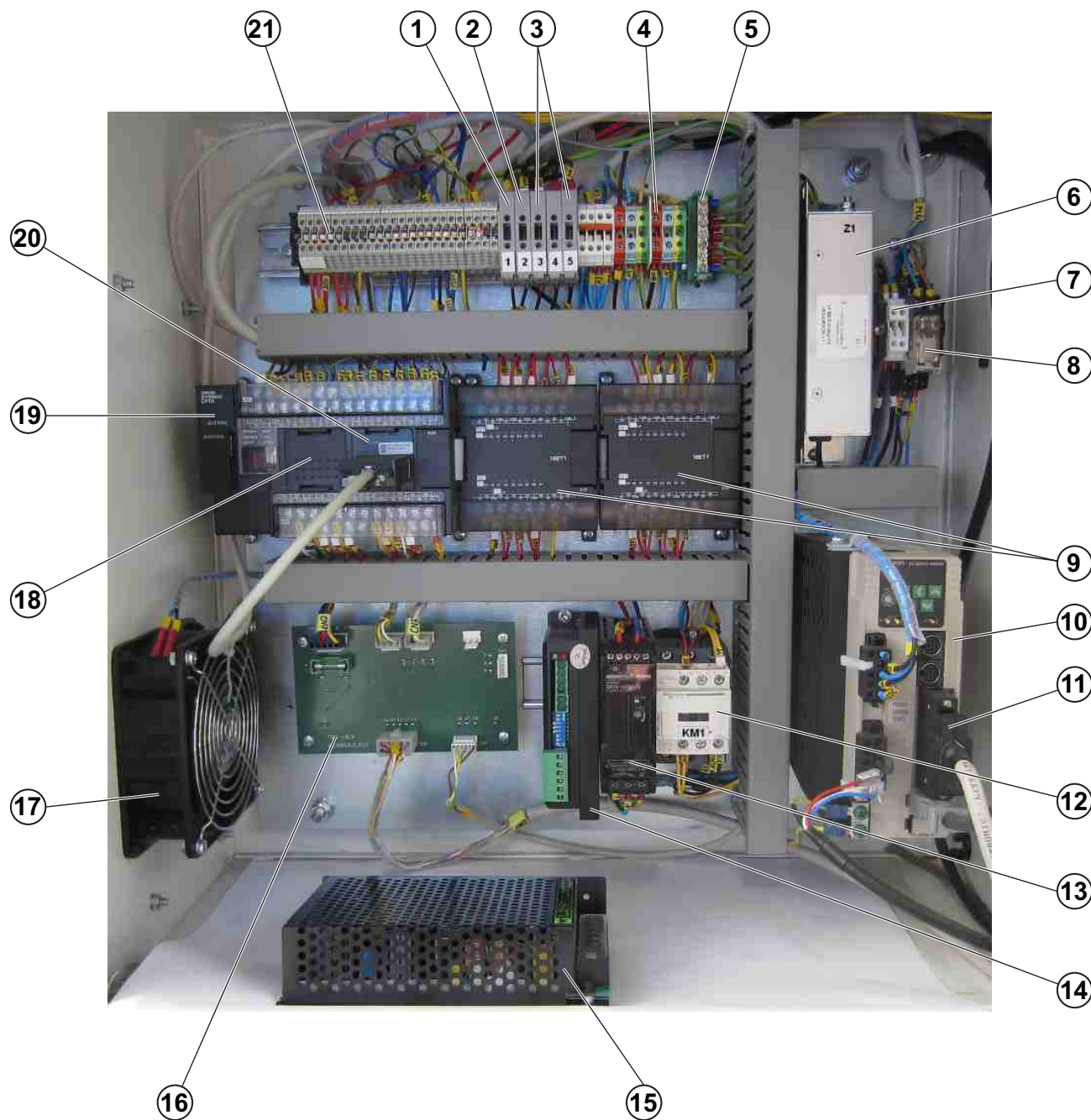
## DISPLAY ASSEMBLY



## DISPLAY ASSEMBLY

DET	PART NUMBER	DESCRIPTION	QTY.
01	08.6002.4.006	SCREW M4-6	3
02	08.6002.5.016	SCREW M5-16	6
03	08.6002.5.055	SCREW M5-55	1
04	08.6002.8.020	SCREW M8-20	1
05	08.6102.5.008	SCREW M5-8	2
06	08.6402.4.016	SCREW M4-16	2
07	08.6732.4.000	NUT M4	2
08	08.6732.5.000	NUT M5	1
09	08.6802.5.000	SPRING WASHER M5	1
10	08.6802.8.000	SPRING WASHER M8	1
11	08.6852.5.000	WASHER 5,3	6
12	08.6882.5.000	WASHER 5,3x20-1,5	2
13	08.6882.8.000	WASHER M8	1
14	12.0010.4.300	DISPLAY	1
15	24.0163.0.000	DISPLAY HOLDER - OMRON	2
16	68.0354.0.800	DISPLAY BRACKET	1
17	68.0355.0.800	COVER PLATE	1
18	68.0356.1.300	STUD	1
19	68.0357.0.800	BRACKET	1
20	68.0361.0.800	PANEL COVER	1

# ELECTROBOX



**ELECTROBOX**

DET	PART NUMBER	DESCRIPTION	QTY.
01	12.0008.4.063	FUSE F1 - T1A	1
02	12.0008.4.109	FUSE F2 - T5A	1
03	12.0008.4.664	FUSE F3 - F5 - T10A	3
04		TERMINAL X0	1
05	12.0008.4.050	PE BRIDGE	1
06	12.0010.4.078	FILTER Z1	1
07		TERMINAL X3	1
08	12.0010.4.338	RELAY KA4	1
09	12.0010.4.277	EXTER. BLOCK	2
10	06.8068.0.003	SERVODRIVE	1
11	06.6800.0.015	CABLE CN1	1
12	12.0008.4.833	CONTACTOR KM1	1
13	12.0010.4.168	POWER GS1	1
14	12.0010.4.249	DRIVER U3	1
15	12.0010.4.255	POWER GS2	1
16	12.0010.4.318	TERMINAL BOARD TB2	1
17	12.0008.4.682	FAN EV1	1
18	06.8068.0.001	PLC	1
19	12.0010.4.163	BATTERY	1
20	12.0010.4.067	COMM. BLOCK	1
21		TERMINAL X1	1

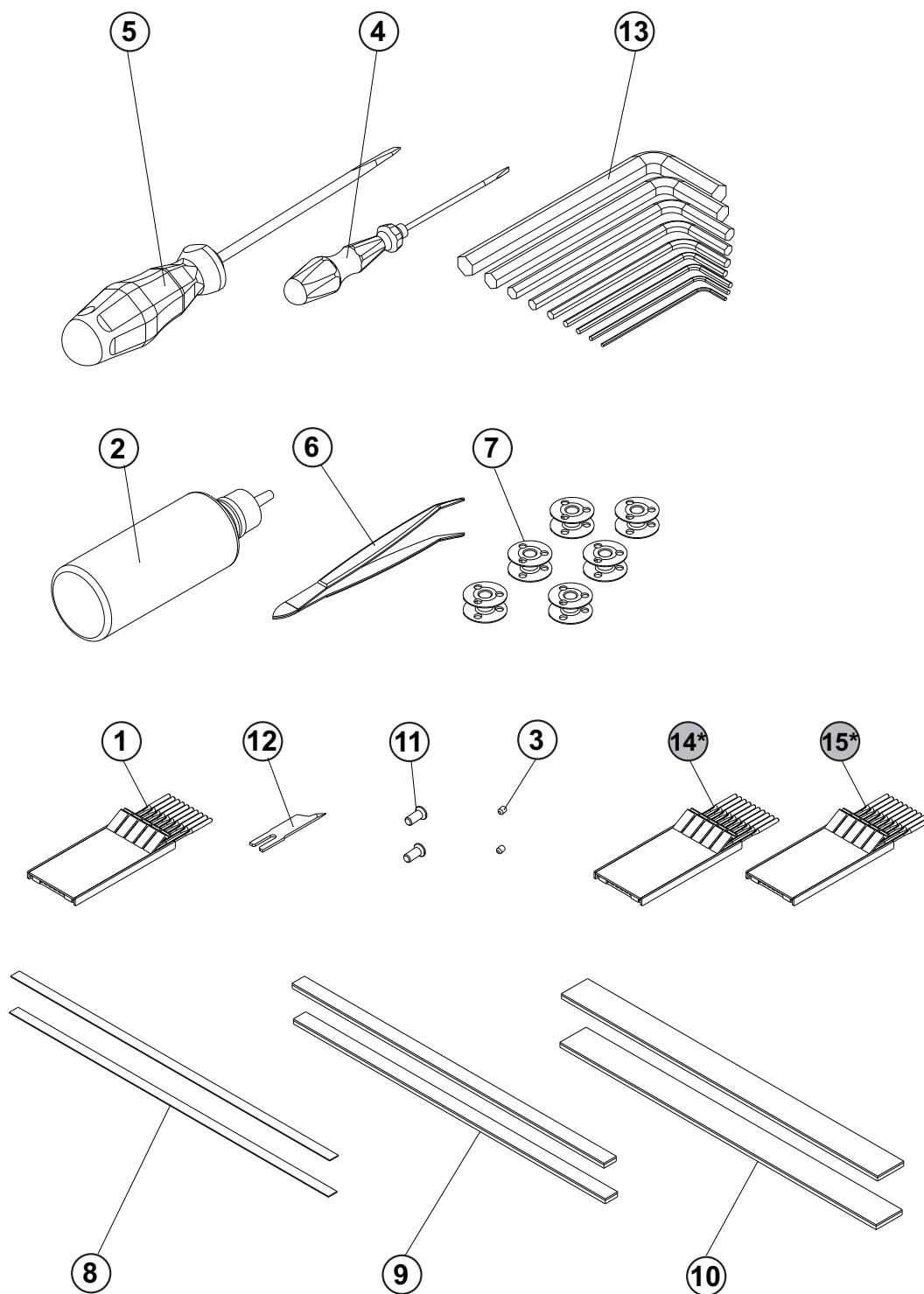




**ELECTRICAL**

DET	PART NUMBER	DESCRIPTION	QTY.
01	06.6800.0.049	TB1 ASSEMBLY	1
02	12.0008.4.720	RELAY	—
03	12.0010.4.271	CLAMP	—

# ACCESSORIES



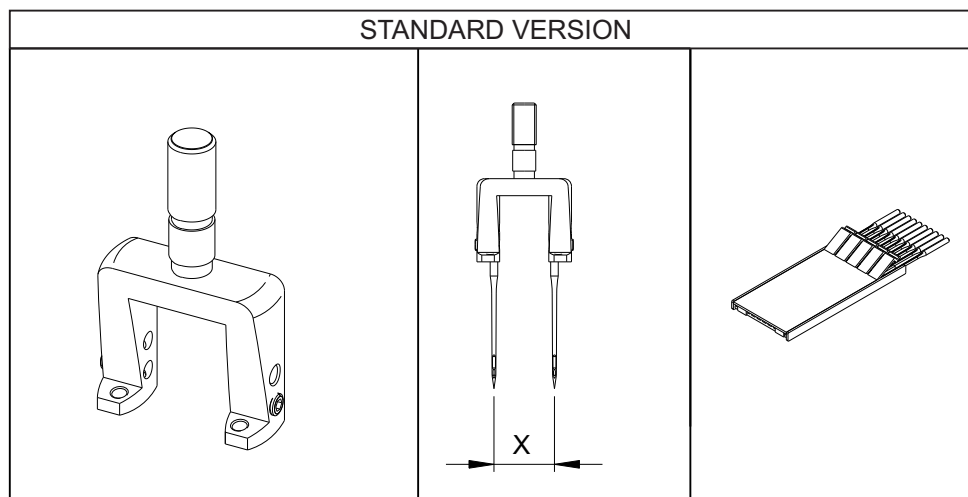
 EXTRA PARTS

## ACCESSORIES

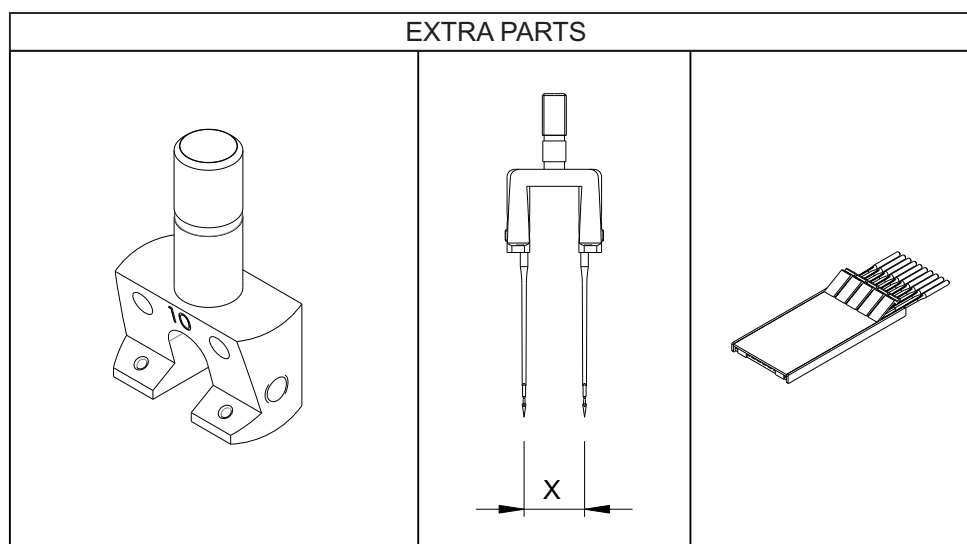
DET	PART NUMBER	DESCRIPTION	QTY.
01	02.1341.0.110	NEEDLE - Nm 90	10
02	05.1322.0.000	OIL RESERVOIR	1
03	08.6402.3.004	SCREW M3-4	2
04	12.0008.6.001	SCREWDRIVER	1
05	12.0008.6.005	SCREWDRIVER	1
06	12.0008.6.215	TWEEZERS	1
07	68.0374.0.400	BOBBIN	6
08	68.0022.0.992	REFLEX TAPE	2
09	68.0024.0.990	RUBBER STRIP	2
10	68.0029.0.990	RUBBER STRIP	2
11	68.0175.0.100	SCREW	2
12	69.0052.0.000	CENTER KNIFE	1
13	84.0003.0.390	ALLEN KEY-METRIC SET	1
14*	02.1341.0.109	NEEDLE - Nm 80	10
15*	02.1341.0.111	NEEDLE - Nm 100	10

\* EXTRA PARTS

## WELT SECTION-NEEDLE HEAD

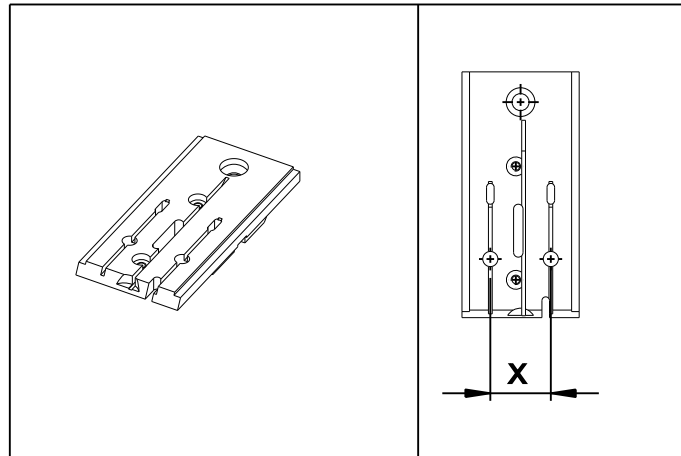


NEEDLE HEAD	SIZE "X"	NEEDLES 134 - 35
68.9901.0.607	6,35 mm	02.1341.0.109-80 Nm 02.1341.0.110-90 Nm 02.1341.0.111-100 Nm
68.9901.0.608	8 mm	
68.9901.0.610	10 mm	
68.9901.0.612	12 mm	
68.9901.0.614	14 mm	
68.9901.0.616	16 mm	
68.9901.0.618	18 mm	
68.9901.0.620	20 mm	
68.9901.0.628	28 mm	



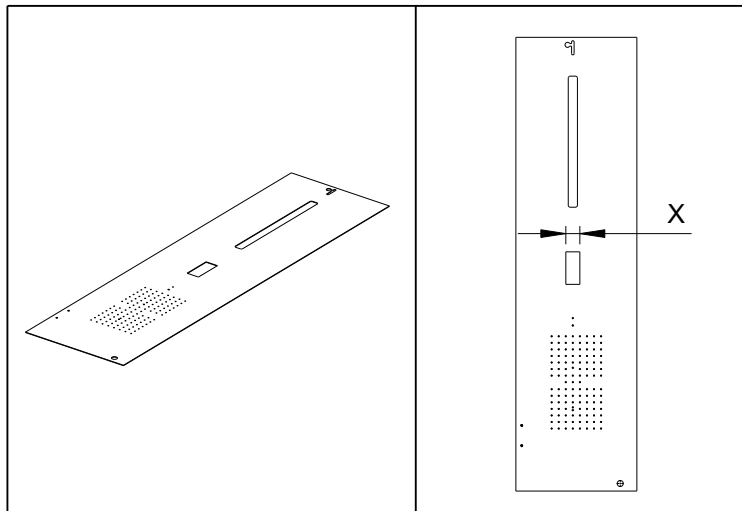
NEEDLE HEAD	SIZE "X"	NEEDLES 190
39.0039.4.001	10 mm	02.0190.0.109-80 Nm 02.0190.0.110-90 Nm 02.0190.0.111-100 Nm
39.0039.4.002	12 mm	
39.0039.4.003	14 mm	
39.0039.4.004	16 mm	
39.0039.4.005	18 mm	
39.0039.4.006	20 mm	

# WELT SECTION-NEEDLE HEAD NEEDLE PLATE

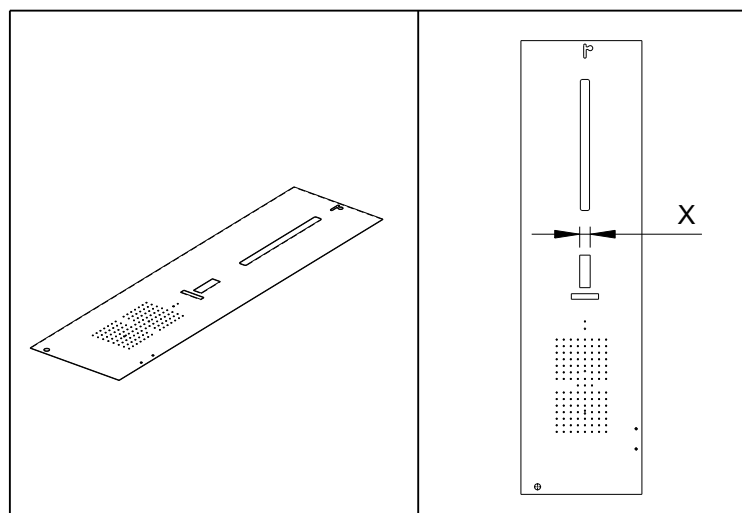


THROAT PLATE	SIZE "X"
68.9902.0.607	6,35 mm
68.9902.0.608	8 mm
68.9902.0.610	10 mm
68.9902.0.612	12 mm
68.9902.0.614	14 mm
68.9902.0.616	16 mm
68.9902.0.618	18 mm
68.9902.0.620	20 mm
68.9902.0.628	28 mm

## WELT SECTION-MAIN SHEET TAPE/NO TAPE

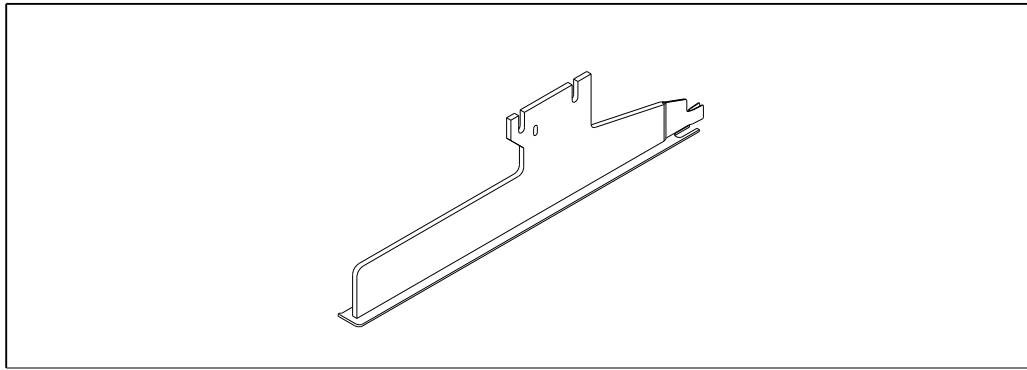


MAIN SHEET/NO TAPE	SIZE "X"
68.9903.0.808	6,35 mm
	8 mm
68.9903.0.814	10 mm
	12 mm
	14 mm
68.9903.0.820	16 mm
	18 mm
	20 mm
68.9903.0.828	26 - 28 mm

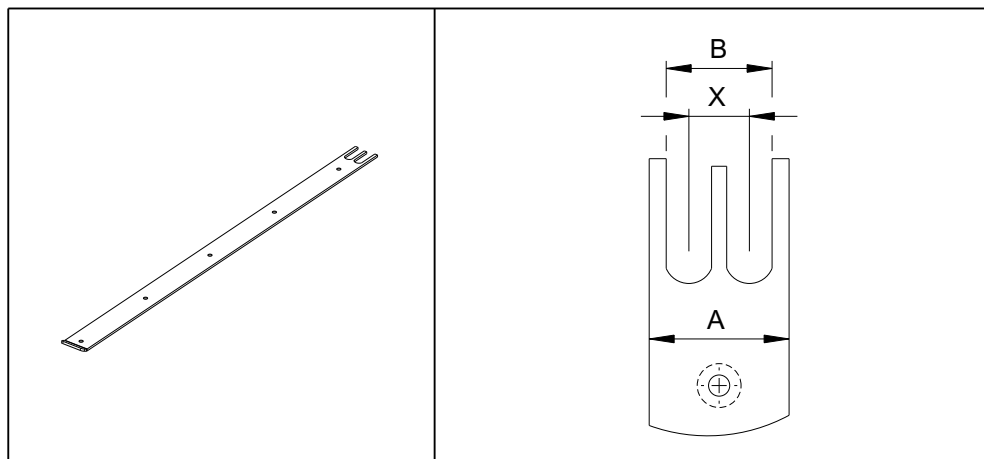


MAIN SHEET/TAPE	SIZE "X"
68.9904.0.808	6,35 mm
	8 mm
68.9904.0.814	10 mm
	12 mm
	14 mm
68.9904.0.820	16 mm
	18 mm
	20 mm
69.9904.0.828	26 - 28 mm

## WELT SECTION-PATCH GUIDE DOUBLE

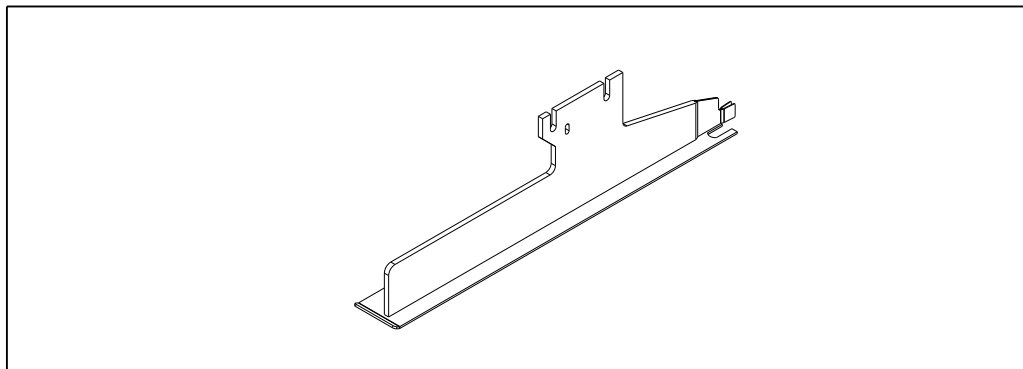


LOWER PATCH GUIDE DOUBLE WELT-ASSY.	LOWER PATCH GUIDE PLATE-DOUBLE WELT	SIZE "X"
68.9906.0.007	68.9905.0.807	6,35 mm
68.9906.0.008	68.9905.0.808	8 mm
68.9906.0.010	68.9905.0.810	10 mm
68.9906.0.012	68.9905.0.812	12 mm
68.9906.0.014	68.9905.0.814	14 mm
68.9906.0.016	68.9905.0.816	16 mm
68.9906.0.018	68.9905.0.818	18 mm
68.9906.0.020	68.9905.0.820	20 mm
68.9906.0.028	68.9905.0.828	28 mm

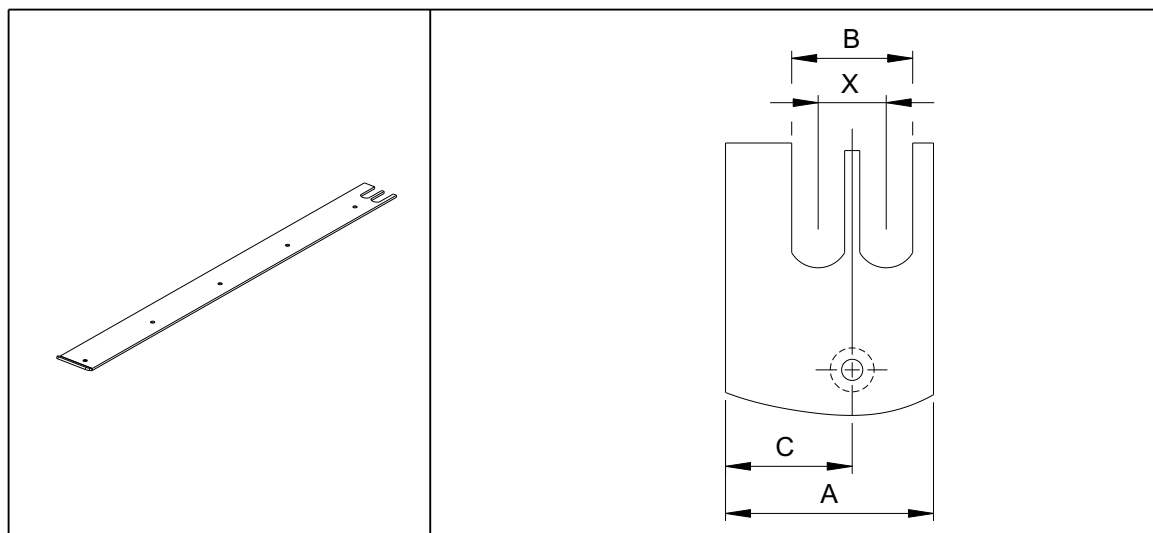


LOWER PATCH GUIDE PLATE-DOUBLE WELT	SIZE "X"	SIZE "A"	SIZE "B"
68.9905.0.807	6,35 mm	12 mm	9 mm
68.9905.0.808	8 mm	14,5 mm	11,5 mm
68.9905.0.810	10 mm	18,5 mm	14,5 mm
68.9905.0.812	12 mm	22,5 mm	16 mm
68.9905.0.814	14 mm	26,5 mm	18 mm
68.9905.0.816	16 mm	30,5 mm	20 mm
68.9905.0.818	18 mm	34,5 mm	22,4 mm
68.9905.0.820	20 mm	38,5 mm	24,4 mm
68.9905.0.828	28 mm	54,5 mm	32,4 mm

## WELT SECTION-PATCH GUIDE SINGLE



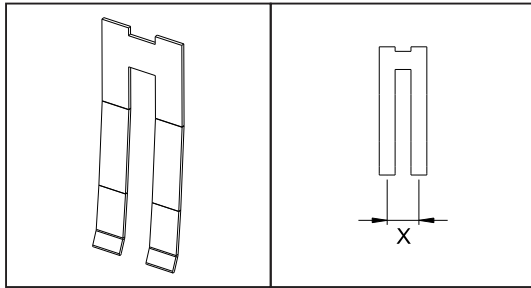
LOWER PATCH GUIDE SINGLE WELT-ASSY.	LOWER PATCH GUIDE PLATE-SINGLE WELT	SIZE "X"
68.9908.0.007	68.9907.0.807	6,35 mm
68.9908.0.008	68.9907.0.808	8 mm
68.9908.0.010	68.9907.0.810	10 mm
68.9908.0.012	68.9907.0.812	12 mm
68.9908.0.014	68.9907.0.814	14 mm
68.9908.0.016	68.9907.0.816	16 mm
68.9908.0.018	68.9907.0.818	18 mm
68.9908.0.020	68.9907.0.820	20 mm
68.9908.0.028	68.9907.0.828	28 mm



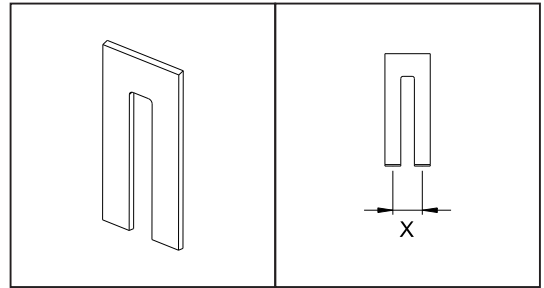
LOWER PATCH GUIDE PLATE-SINGLE WELT	SIZE "X"	SIZE "A"	SIZE "B"	SIZE "C"
68.9907.0.807	6,35 mm	14,7 mm	9 mm	8,7 mm
68.9907.0.808	8 mm	18,5 mm	11,5 mm	11,25 mm
68.9907.0.810	10 mm	24 mm	14 mm	14,75 mm
68.9907.0.812	12 mm	28 mm	16 mm	16,75 mm
68.9907.0.814	14 mm	33 mm	18 mm	19,75 mm
68.9907.0.816	16 mm	38,5 mm	20 mm	23,25 mm
68.9907.0.818	18 mm	43,5 mm	22,4 mm	26,25 mm
68.9907.0.820	20 mm	48,5 mm	24,4 mm	29,25 mm
68.9907.0.828	28 mm	70,5 mm	32,4 mm	43,4 mm



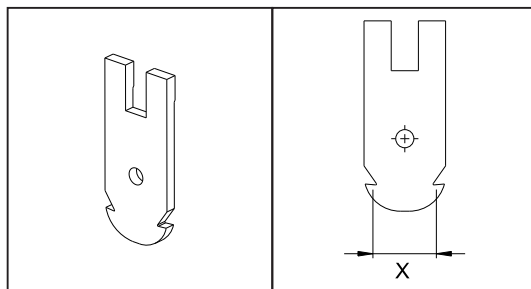
**WELT SECTION-OUTSIDE SPRING TOP THREAD TRIMMER INSIDE KNIFE**



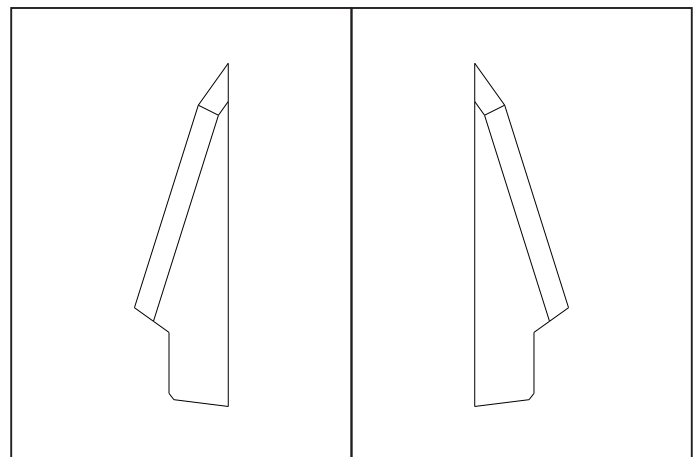
OUTSIDE SPRING	SIZE "X"
68.9909.0.814	6,35/8/10 mm
	12 mm
	14 mm
68.9909.0.818	16 mm
	18 mm
68.9909.0.824	20, 22, 24 mm
68.9909.0.828	26,28 mm



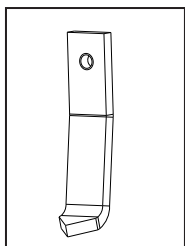
TOP THREAD TRIMMER	SIZE "X"
68.9910.0.814	6,35/8/10 mm
	12 mm
	14 mm
68.9910.0.818	16 mm
	18 mm
68.9910.0.824	20, 22, 24 mm
68.9910.0.828	26,28 mm



INSIDE KNIFE	SIZE "X"
68.9911.0.807	6,35 mm
	8 mm
68.9911.0.810	10 mm
68.9911.0.812	12 mm
68.9911.0.814	14 mm
68.9911.0.816	16 mm
68.9911.0.818	18 mm
68.9911.0.820	20 mm
68.9911.0.828	28 mm

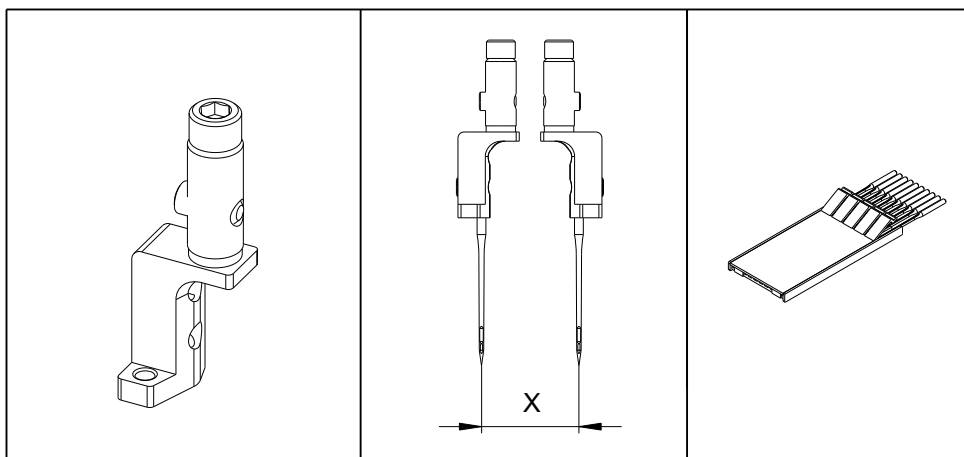


CORNER KNIFE	SIZE "X"
69.0052.1.014	6,35 mm
	8 mm
	10 mm
	12 mm
	14 mm
69.0052.1.020	16 mm
	18 mm
	20 mm
69.0052.1.026	22 mm
	24 mm
	26 mm
	28 mm
69.0052.1.032	30 mm
	32 mm



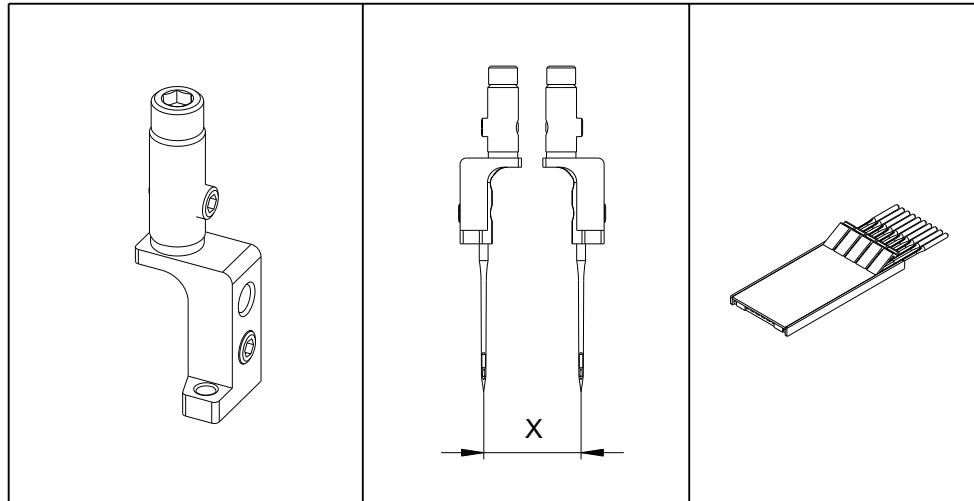
KNIFE GUARD	SIZE "X"
68.9912.0.807	6,35 mm
	8 mm
68.9912.0.810	10 mm
	12 mm
	14 mm
	16 mm
	18 mm
68.9912.0.818	20 mm
	26, 28 mm

## WELT SECTION - AP

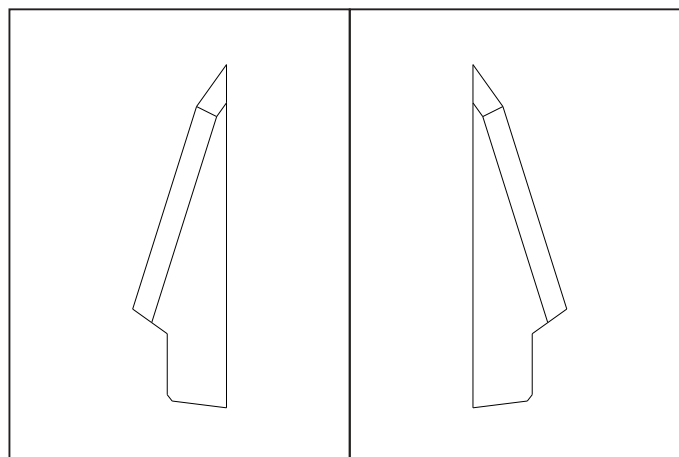


NEEDLE HEAD - left	SIZE "X"	NEEDLES 134 - 35
68.9914.0.610	10 mm	02.1341.0.109-80 Nm 02.1341.0.110-90 Nm 02.1341.0.111-100 Nm
68.9914.0.612	12 mm	
68.9914.0.614	14 mm	
68.9914.0.616	16 mm	
68.9914.0.618	18 mm	
68.9914.0.620	20 mm	
68.9914.0.607	6,35 mm	
68.9914.0.608	8 mm	

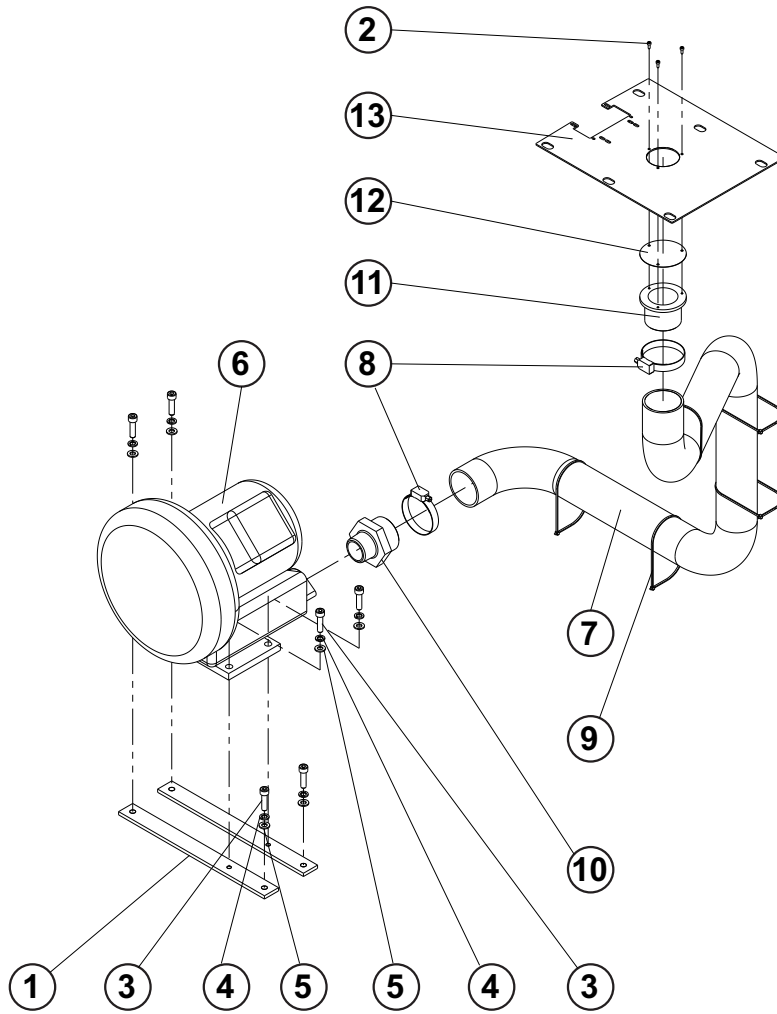
## WELT SECTION - AP



NEEDLE HEAD - right	SIZE "X"	NEEDLES 134 - 35
68.9915.0.610	10 mm	02.1341.0.109-80 Nm 02.1341.0.110-90 Nm 02.1341.0.111-100 Nm
68.9915.0.612	12 mm	
68.9915.0.614	14 mm	
68.9915.0.616	16 mm	
68.9915.0.618	18 mm	
68.9915.0.620	20 mm	
68.9915.0.607	6,35 mm	
68.9915.0.608	8 mm	

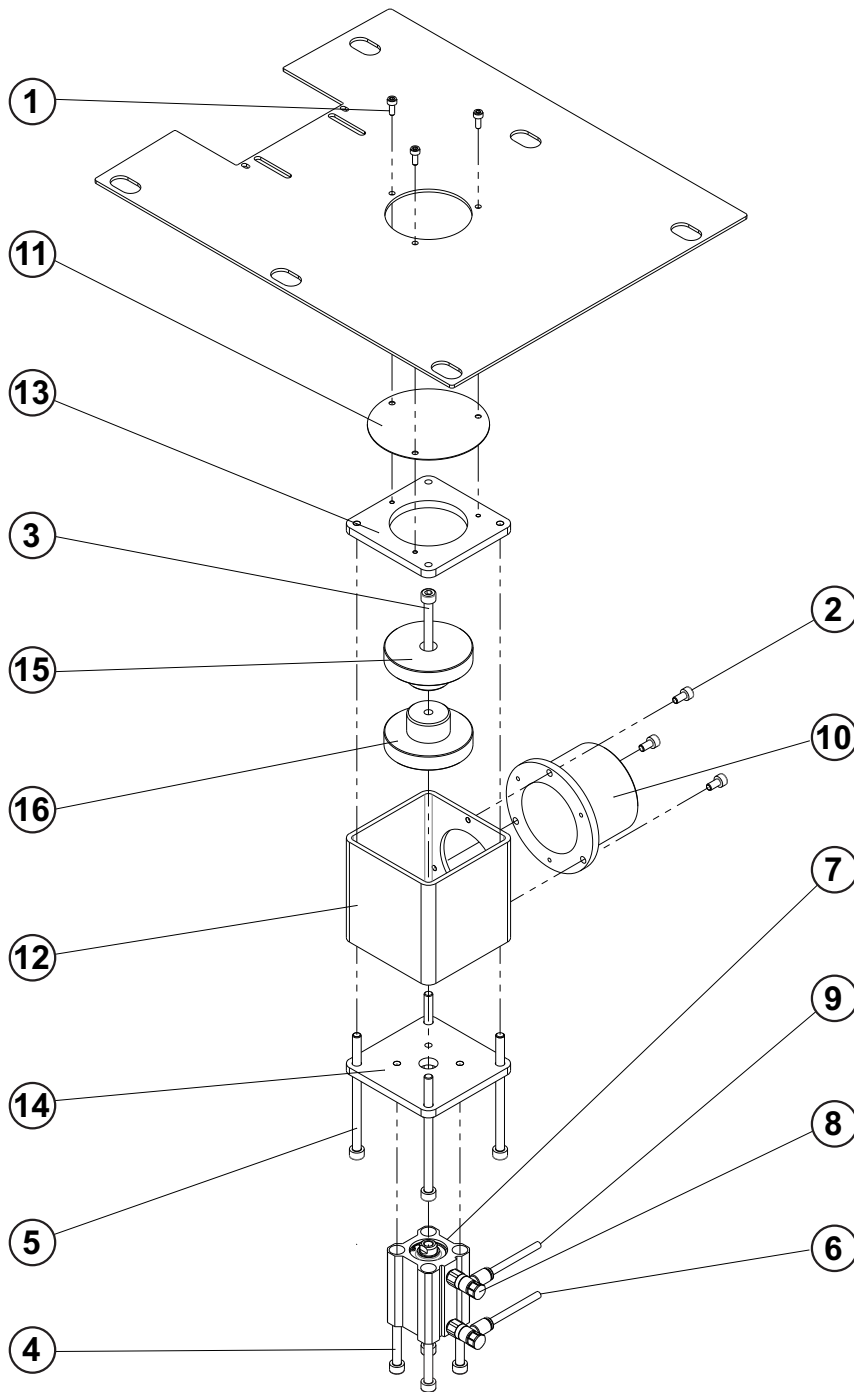


CORNER KNIFE	SIZE "X"
69.0052.1.014	6,35 mm
	8 mm
	10 mm
69.0052.1.020	12 mm
	14 mm
69.0052.1.026	16 mm
	18 mm
	20 mm



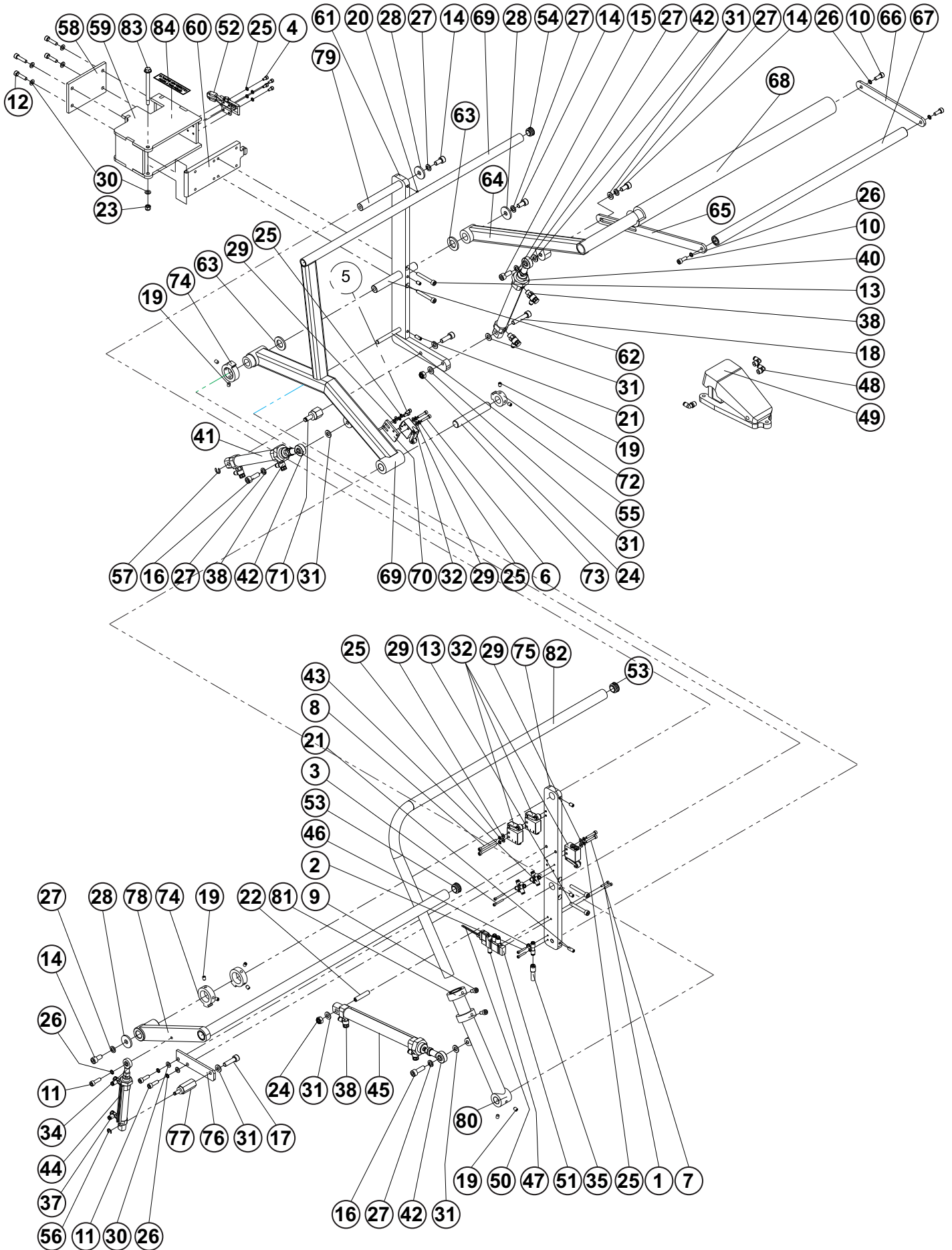


# CENTRAL VACUUM





# STACKER ASSEMBLY



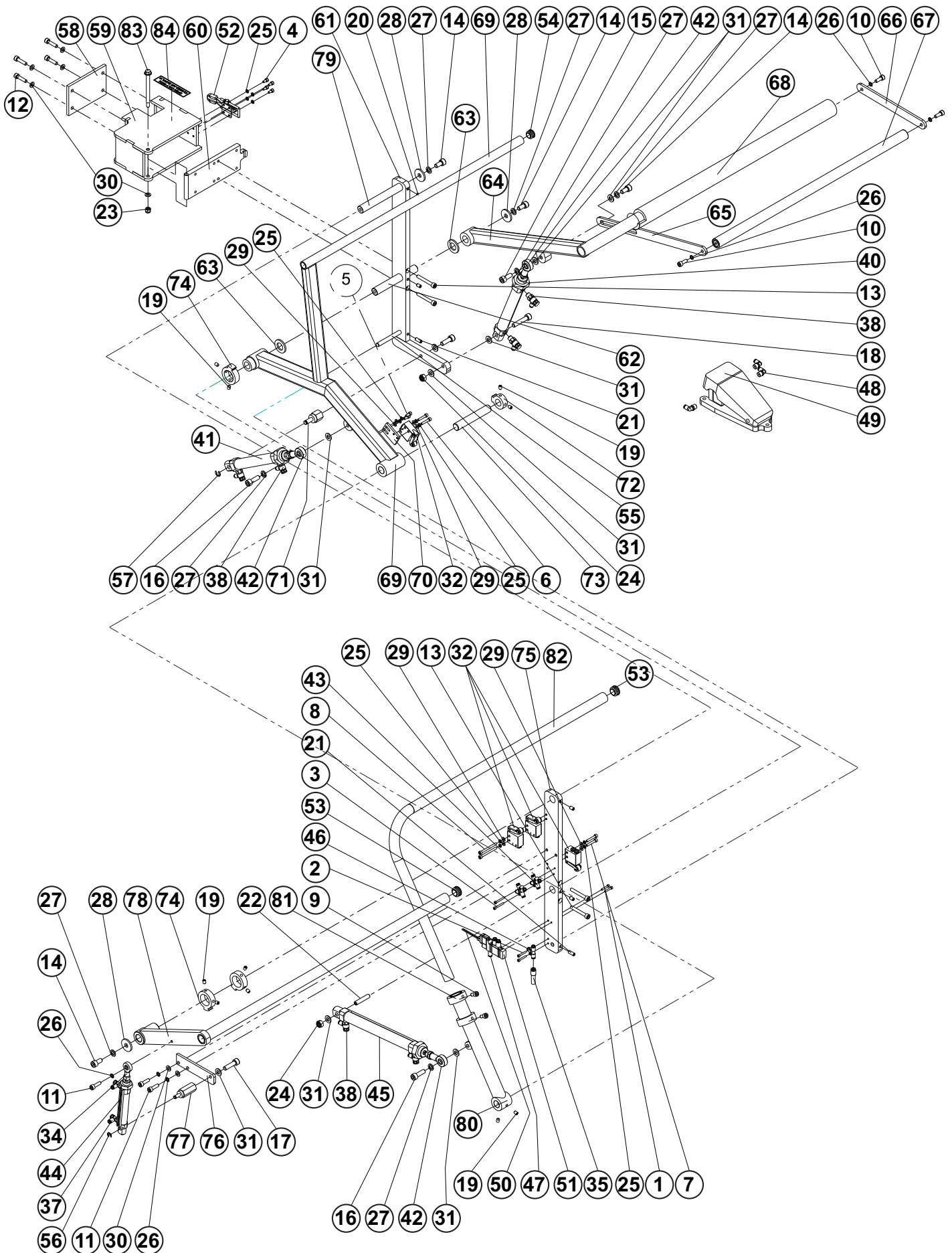


## STACKER ASSEMBLY

DET	PART NUMBER	DESCRIPTION	QTY.
01	08.6002.3.018	SCREW M3-18	2
02	08.6002.3.020	SCREW M3-20	2
03	08.6002.3.025	SCREW M3-25	2
04	08.6002.4.008	SCREW M4-8	4
05	08.6002.4.010	SCREW M4-10	2
06	08.6002.4.022	SCREW M4-22	2
07	08.6002.4.025	SCREW M4-25	2
08	08.6002.4.045	SCREW M4-45	2
09	08.6002.6.012	SCREW M6-12	2
10	08.6002.6.016	SCREW M6-16	3
11	08.6002.6.020	SCREW M6-20	3
12	08.6002.6.025	SCREW M6-25	4
13	08.6002.6.045	SCREW M6-45	4
14	08.6002.8.016	SCREW M8-16	4
15	08.6002.8.020	SCREW M8-20	1
16	08.6002.8.025	SCREW M8-25	3
17	08.6002.8.030	SCREW M8-30	1
18	08.6002.8.040	SCREW M8-40	1
19	08.6402.6.008	SCREW M6-8	10
20	08.6402.6.010	SCREW M6-10	4
21	08.6402.6.016	SCREW M6-16	2
22	08.6402.8.040	SCREW M8-40	1
23	08.6732.6.000	NUT M6	1
24	08.6733.8.000	NUT M8	2
25	08.6802.4.000	SPRING WASHER M4	12
26	08.6802.6.000	SPRING WASHER M6	6
27	08.6802.8.000	SPRING WASHER M8	7
28	08.6842.8.000	WASHER M8	3
29	08.6852.4.000	WASHER M4	8
30	08.6852.6.000	WASHER 6,4	7
31	08.6852.8.000	WASHER M8	10
32	12.0008.3.278	MECHANICAL VALVE	4
33	12.0008.3.416	TUBE	
34	12.0008.3.700	BEARING ROD	1
35	12.0008.3.716	REDUCER	1
36	12.0008.4.140	SPIRAL HOSE	
37	12.0010.3.047	SPEED CONTR.	2
38	12.0010.3.076	SPEED VALVE	6
39	12.0010.3.080	TUBE	
40	12.0010.3.082	CYLINDER	1
41	12.0010.3.082	CYLINDER	1
42	12.0010.3.083	KNUCKLE	3
43	12.0010.3.085	CONNECTOR	2
44	12.0010.3.086	CYLINDER	1
45	12.0010.3.087	CYLINDER	1
46	12.0010.3.088	CONNECTOR	1



# STACKER ASSEMBLY

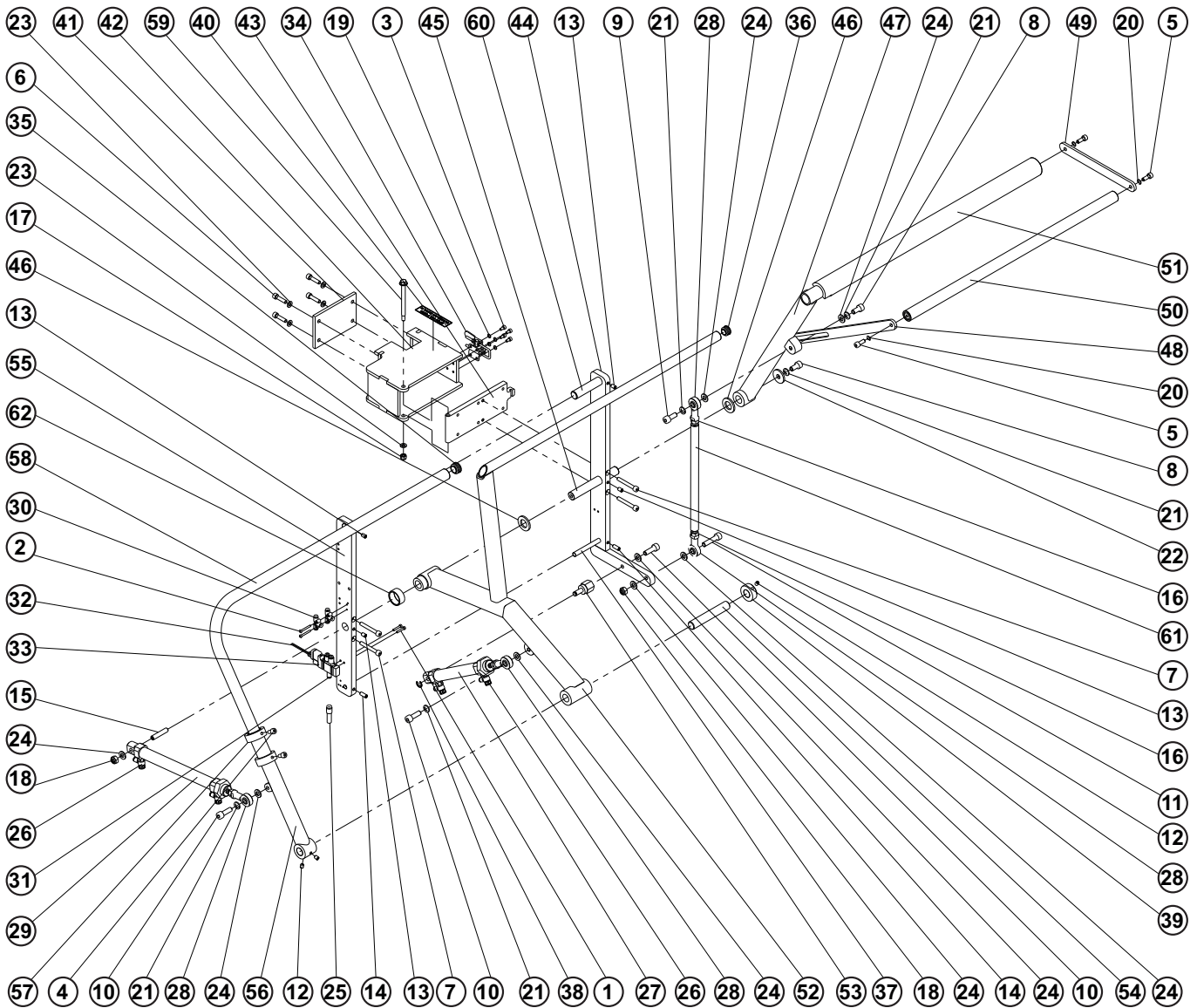


## STACKER ASSEMBLY



DET	PART NUMBER	DESCRIPTION	QTY.
47	12.0010.3.089	CONNECTOR	1
48	12.0010.3.090	KQ2L04-01AS CONNECTOR	3
49	12.0010.3.091	5/2 FOOT SWITCH	1
50	12.0010.3.108	CABLE	1
51	12.0010.3.109	5/2 VALVE	1
52	12.0010.6.219	KEYLESS	1
53	12.0010.6.914	PLUG 21x2,5	2
54	12.0010.6.915	PLUG 18x2,5	1
55	12.1010.2.036	PIN 8h6x80	1
56	12.1045.0.005	E-CLIP 5	1
57	12.1045.0.007	RETAINER RING 7	1
58	68.0260.0.800	PLATE	1
59	68.0261.0.000	HOLDER	1
60	68.0262.0.800	BRACKET	1
61	68.0263.0.000	LEVER	1
62	68.0264.0.300	SHAFT	1
63	68.0265.0.100	WASHER M16	2
64	68.0266.0.000	LEVER	1
65	68.0267.0.800	LEVER	1
66	68.0268.0.800	LEVER	1
67	68.0269.0.000	TUBE	1
68	68.0270.0.993	TUBE COVER	1
69	68.0271.0.000	LEVER	1
70	68.0272.0.800	PLATE	1
71	68.0273.0.300	STUD	1
72	68.0274.0.400	SENSOR RING	1
73	68.0275.0.300	BAR	1
74	68.0276.0.400	SENSOR RING	3
75	68.0277.0.800	HOLDER	1
76	68.0278.0.800	PLATE	1
77	68.0279.0.300	STUD	1
78	68.0280.0.000	LEVER	1
79	68.0281.0.300	SHAFT	1
80	68.0282.0.000	LEVER	1
81	68.0283.0.400	CLAMP RING	2
82	68.0284.0.000	TUBE	1
83	68.0359.0.300	STUD	1
84	12.8000.0.452	LABEL	1

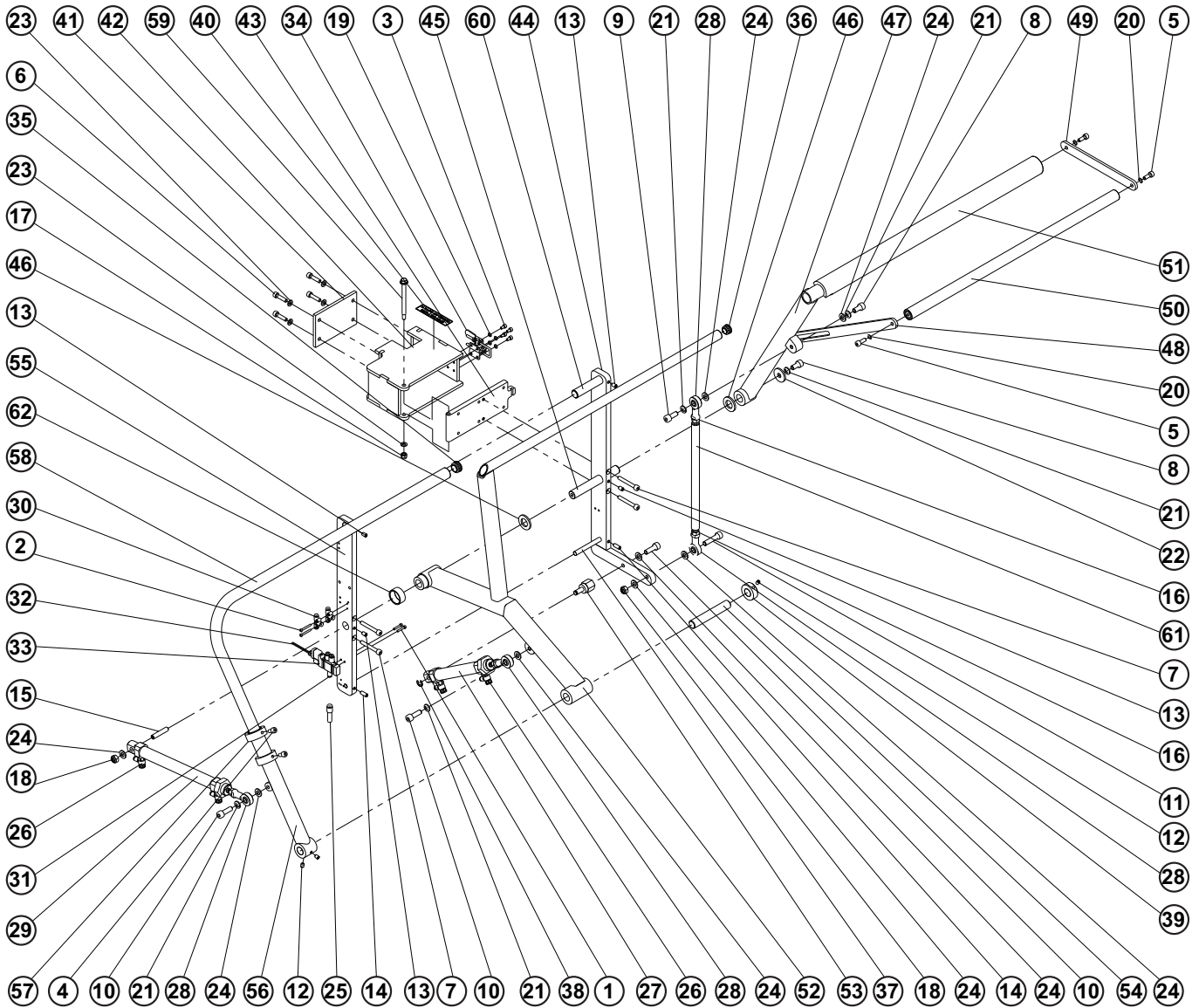
# TROUSERS STACKER



## TROUSERS STACKER

DET	PART NUMBER	DESCRIPTION	QTY.
01	08.6002.3.018	SCREW M3-18	2
02	08.6002.3.025	SCREW M3-25	2
03	08.6002.4.008	SCREW M4-8	4
04	08.6002.6.012	SCREW M6-12	2
05	08.6002.6.016	SCREW M6-16	3
06	08.6002.6.025	SCREW M6-25	4
07	08.6002.6.045	SCREW M6-45	4
08	08.6002.8.016	SCREW M8-16	2
09	08.6002.8.020	SCREW M8-20	1
10	08.6002.8.025	SCREW M8-25	3
11	08.6002.8.035	SCREW M8-35	1
12	08.6402.6.008	SCREW M6-8	3
13	08.6402.6.010	SCREW M6-10	4
14	08.6402.6.016	SCREW M6-16	2
15	08.6402.8.040	SCREW M8-40	1
16	08.6702.8.000	NUT M8	2
17	08.6732.6.000	NUT M6	1
18	08.6733.8.000	NUT M8	2
19	08.6802.4.000	SPRING WASHER M4	4
20	08.6802.6.000	SPRING WASHER M6	3
21	08.6802.8.000	SPRING WASHER M8	5
22	08.6842.8.000	WASHER M8	1
23	08.6852.6.000	WASHER M6	5
24	08.6852.8.000	WASHER M8	8
25	12.0008.3.716	REDUCER	1
26	12.0010.3.076	SPEED VALVE	4
27	12.0010.3.082	CYLINDER	1
28	12.0010.3.083	KNUCKLE JOINTS	4
29	12.0010.3.087	CYLINDER	1
30	12.0010.3.088	CONNECTOR	2
31	12.0010.3.089	CONNECTOR	1
32	12.0010.3.108	CABLE	1
33	12.0010.3.109	5/2 VALVE	1
34	12.0010.6.239	KEYLESS	1
35	12.0010.6.914	PLUG 21x2,5	1
36	12.0010.6.915	PLUG 18x2,5	1
37	12.1010.2.036	PIN 8h6x80	1
38	12.1045.0.007	RETAINER RING 7	1
39	12.1050.0.013	CLAMP COLLAR 16	1
40	12.8000.0.452	LABEL	1

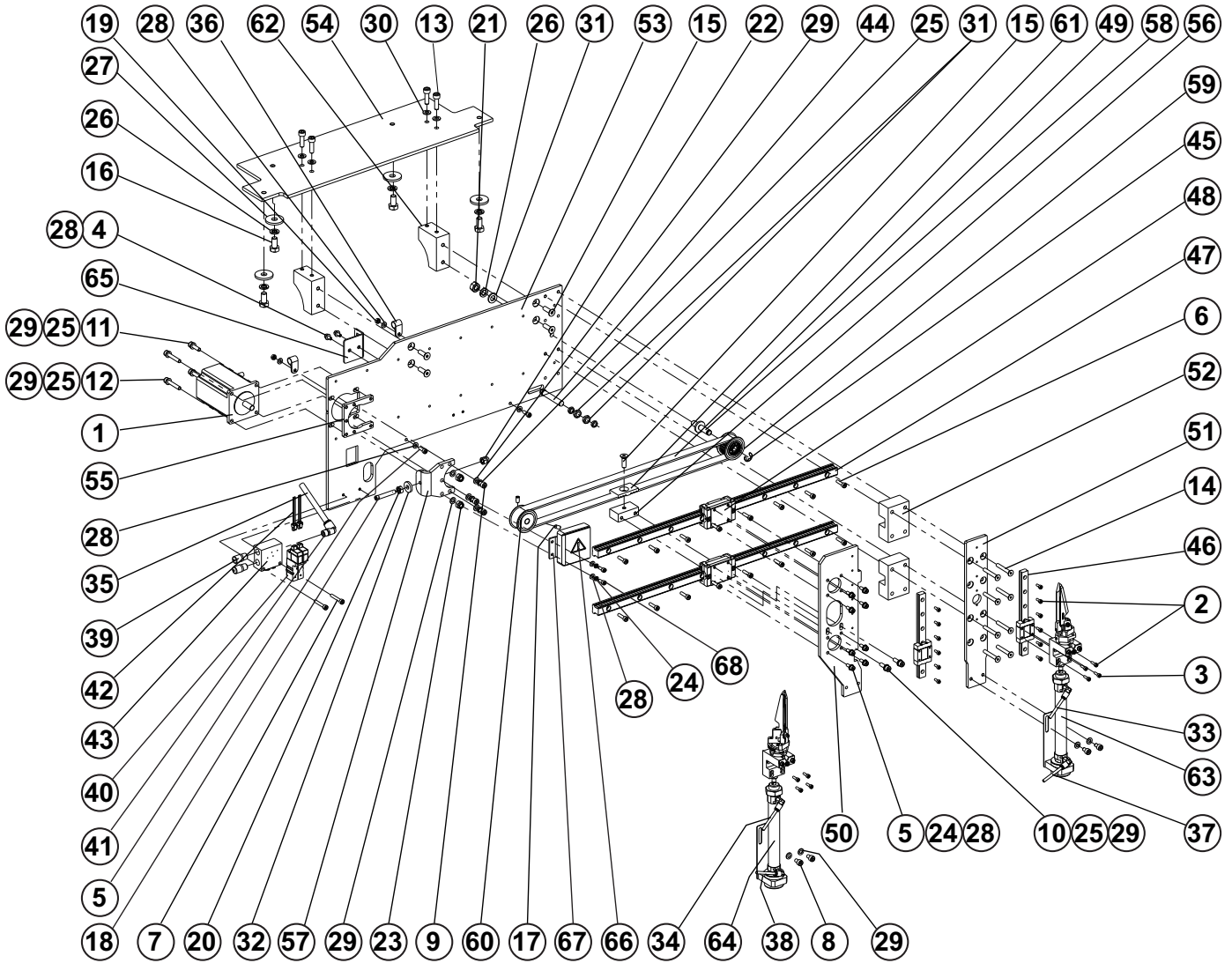
# TROUSERS STACKER



## TROUSERS STACKER

DET	PART NUMBER	DESCRIPTION	QTY.
41	68.0260.0.800	PLATE	1
42	68.0261.0.000	HOLDER	1
43	68.0262.0.800	BRACKET	1
44	68.0263.0.000	LEVER	1
45	68.0264.0.300	SHAFT	1
46	68.0265.0.100	WASHER M16 DIN 125 A	2
47	68.0266.0.000	LEVER	1
48	68.0267.0.800	LEVER	1
49	68.0268.0.800	LEVER	1
50	68.0269.0.000	TUBE	1
51	68.0270.0.993	TUBE COVER	1
52	68.0271.0.000	LEVER	1
53	68.0273.0.300	STUD	1
54	68.0275.0.300	BAR W16h6 L97	1
55	68.0277.0.800	HOLDER	1
56	68.0282.0.000	LEVER	1
57	68.0283.0.400	CLAMP RING	2
58	68.0284.0.000	TUBE	1
59	68.0359.0.300	STUD	1
60	68.0386.0.300	BAR W16h6 L80	1
61	68.0388.0.300	SHAFT	1
62	68.0409.0.400	DISTANCE WASHER	1

# CORNER KNIFE UNIT WITH STEPPER MOTOR



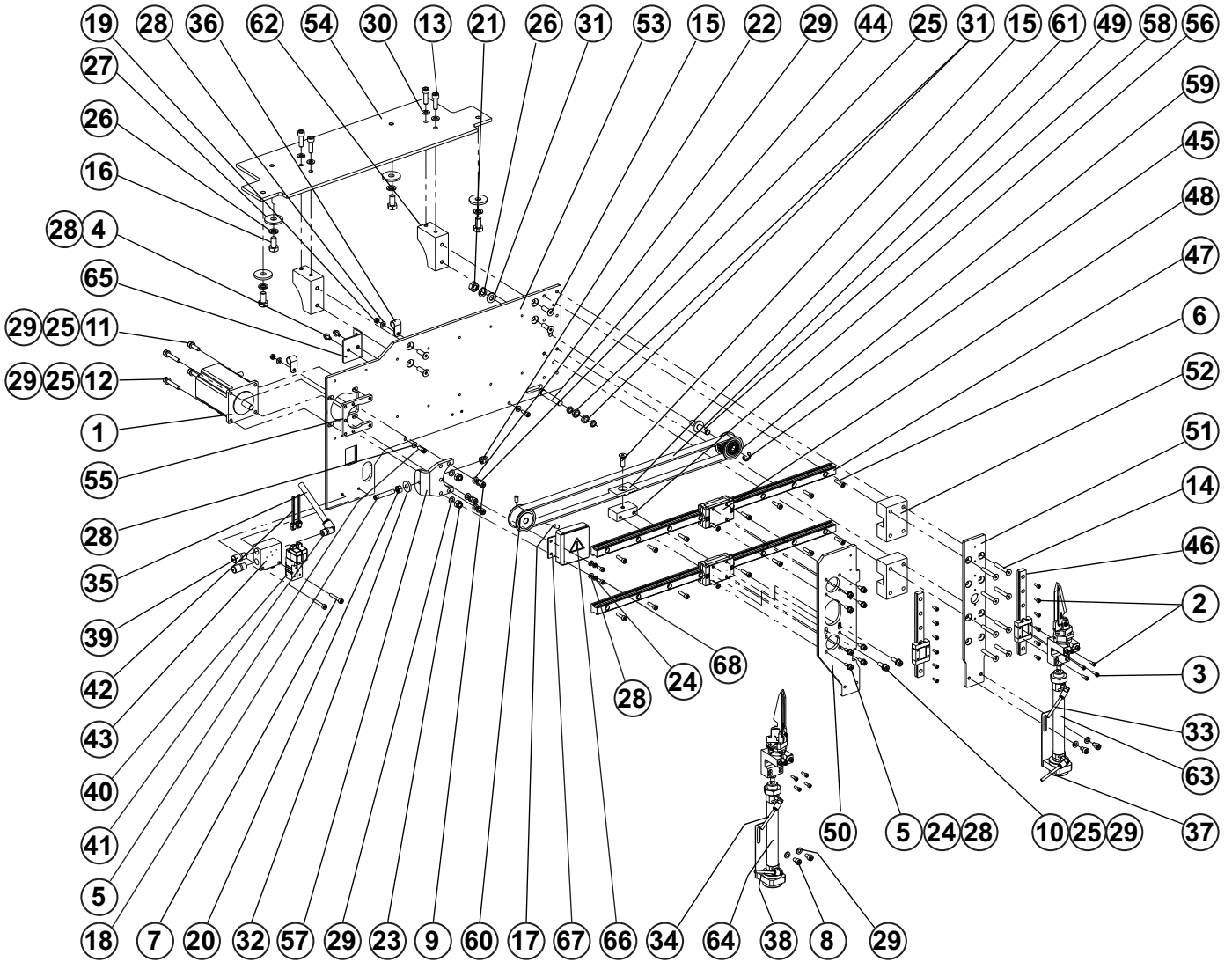


## CORNER KNIFE UNIT WITH STEPPER MOTOR

DET	PART NUMBER	DESCRIPTION	QTY.
01	06.6800.0.051	STEPPER MOTOR SM3 ASSY.	1
02	08.6002.3.008	SCREW M3-8	16
03	08.6002.3.016	SCREW M3-16	4
04	08.6002.4.008	SCREW M4-8	2
05	08.6002.4.012	SCREW M4-12	10
06	08.6002.4.016	SCREW M4-16	16
07	08.6002.4.025	SCREW M4-25	2
08	08.6002.5.008	SCREW M5-8	4
09	08.6002.5.012	SCREW M5-12	3
10	08.6002.5.016	SCREW M5-16	2
11	08.6002.5.018	SCREW M5-18	2
12	08.6002.5.030	SCREW M5-30	2
13	08.6002.6.020	SCREW M6-20	4
14	08.6102.5.035	SCREW M5-35	8
15	08.6102.6.020	SCREW M6-20	5
16	08.6312.8.016	SCREW M8-16	4
17	08.6402.5.010	SCREW M5-10	2
18	08.6402.6.030	SCREW M6-30	1
19	08.6702.4.000	NUT M4	2
20	08.6702.6.000	NUT M6	1
21	08.6702.8.000	NUT M8	1
22	08.6722.6.000	NUT M6	1
23	08.6732.5.000	NUT M5	2
24	08.6802.4.000	SPRING WASHER M4	10
25	08.6802.5.000	SPRING WASHER M5	9
26	08.6802.8.000	SPRING WASHER M8	5
27	08.6842.8.000	WASHER M8	4
28	08.6852.4.000	WASHER M4	16
29	08.6852.5.000	WASHER 5,3	15
30	08.6852.6.000	WASHER 6,4	4
31	08.6852.8.000	WASHER M8	3
32	08.6892.6.000	WASHER M6	1
33	12.0008.3.416	AIR TUBE	-
34	12.0008.3.416	AIR TUBE	-
35	12.0008.3.431	AIR TUBING	-
36	12.0008.4.253	CLAMP CABLE	2
37	12.0010.3.080	AIR TUBE	-
38	12.0010.3.080	AIR TUBE	-
39	12.0010.3.099	SILENCER	2
40	12.0010.3.105	5/2 VALVE	2
41	12.0010.3.106	CONNECTOR	1
42	12.0010.3.108	CABLE	2
43	12.0010.3.110	MANIFOLD PLATE	1
44	12.0010.4.025	SENSOR	1
45	12.1045.0.006	RETAINER RING	1
46	12.2070.1.069	GUIDE	2

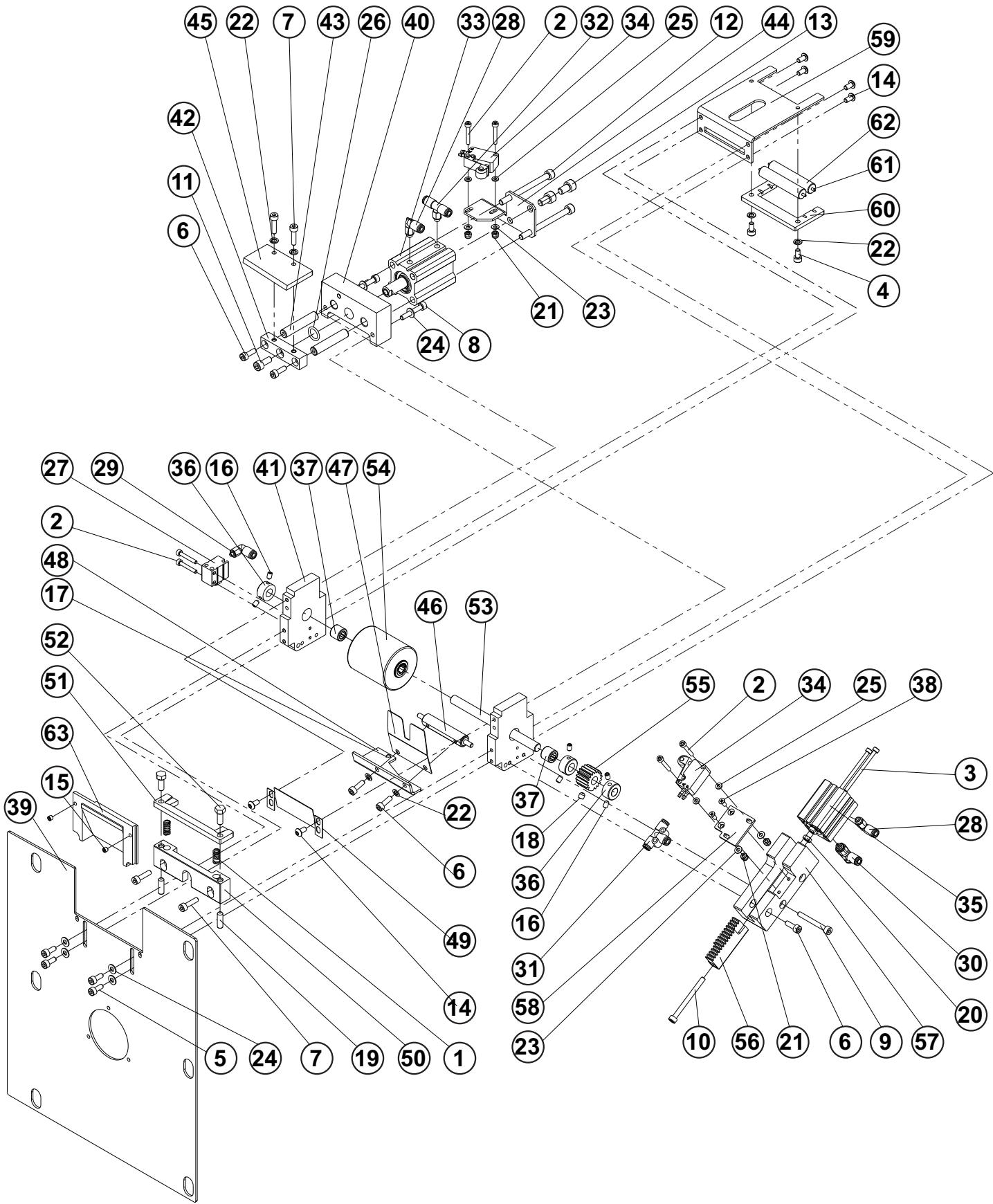


# CORNER KNIFE UNIT WITH STEPPER MOTOR





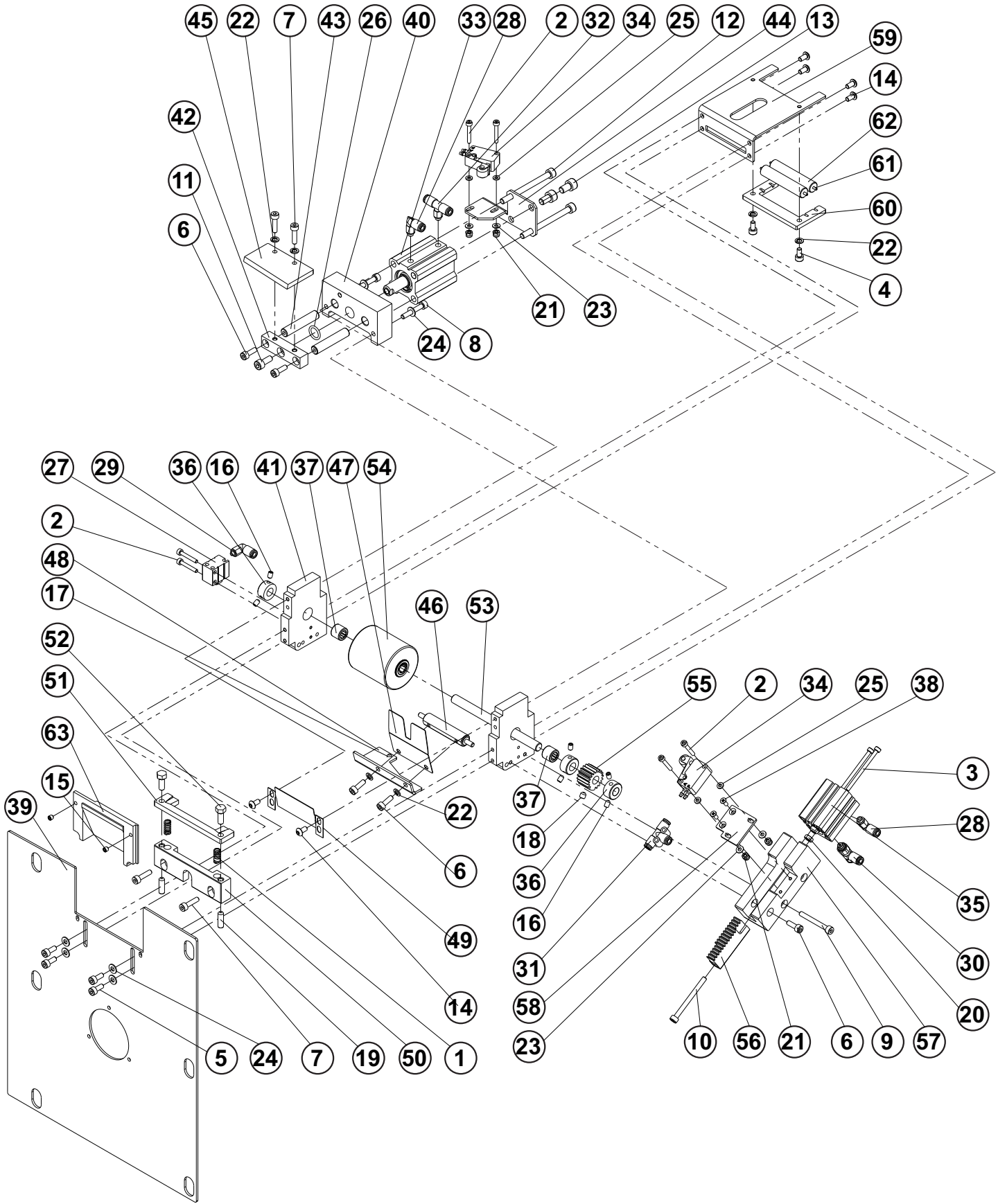
# AUTOMATIC LOADING AND CUTTING DEVICE



**AUTOMATIC LOADING AND CUTTING DEVICE**

DET	PART NUMBER	DESCRIPTION	QTY.
01	07.6440.0.052	SPRING	2
02	08.6002.3.020	SCREW M3-20	6
03	08.6002.3.050	SCREW M3-50	2
04	08.6002.4.008	SCREW M4-8	2
05	08.6002.4.010	SCREW M4-10	4
06	08.6002.4.012	SCREW M4-12	5
07	08.6002.4.016	SCREW M4-16	4
08	08.6002.4.025	SCREW M4-25	2
09	08.6002.4.035	SCREW M4-35	1
10	08.6002.4.045	SCREW M4-45	1
11	08.6002.5.012	SCREW M5-12	1
12	08.6002.5.060	SCREW M5-60	2
13	08.6002.6.010	SCREW M6-10	2
14	08.6202.4.008	SCREW M4-8	6
15	08.6402.4.004	SCREW M4-4	2
16	08.6402.4.006	SCREW M4-6	6
17	08.6402.4.008	SCREW M4-8	1
18	08.6402.5.005	SCREW M5-5	1
19	08.6402.5.012	SCREW M5-16	2
20	08.6702.4.000	NUT M4	1
21	08.6733.3.000	NUT M3 D	4
22	08.6802.4.000	SPRING WASHER M4	6
23	08.6852.3.000	WASHER M3	4
24	08.6852.4.000	WASHER M4	6
25	08.6887.3.000	WASHER 1x3x6	4
26	12.0008.6.800	O-RING 10x2	1
27	12.0010.3.126	CYLINDER	1
28	12.0010.3.028	CONNECTOR	2
29	12.0010.3.036	CONNECTOR	1
30	12.0010.3.047	SPEED CONTR.	1
31	12.0010.3.088	CONNECTOR	1
32	12.0010.3.092	CONNECTOR	1
33	12.0010.3.093	CYLINDER	1
34	12.0010.3.102	3/2 MECHANUCAL VALVE	2
35	12.0010.3.016	CYLINDER	1
36	12.1050.0.003	CLAMP COLLAR 6	3
37	12.2050.0.011	BEARING	2
38	15.1420.0.100	SCREW M3-8	2
39	68.0259.1.800	PLATE	1
40	68.0285.0.600	CYLINDER PLATE	1
41	68.0286.0.600	BEARING BRACKET	2
42	68.0287.0.600	KNIFE HOLDER	1
43	68.0288.0.300	SHAFT	2
44	68.0289.0.800	HOLDER	1
45	68.0290.0.800	KNIFE	1
			

# AUTOMATIC LOADING AND CUTTING DEVICE

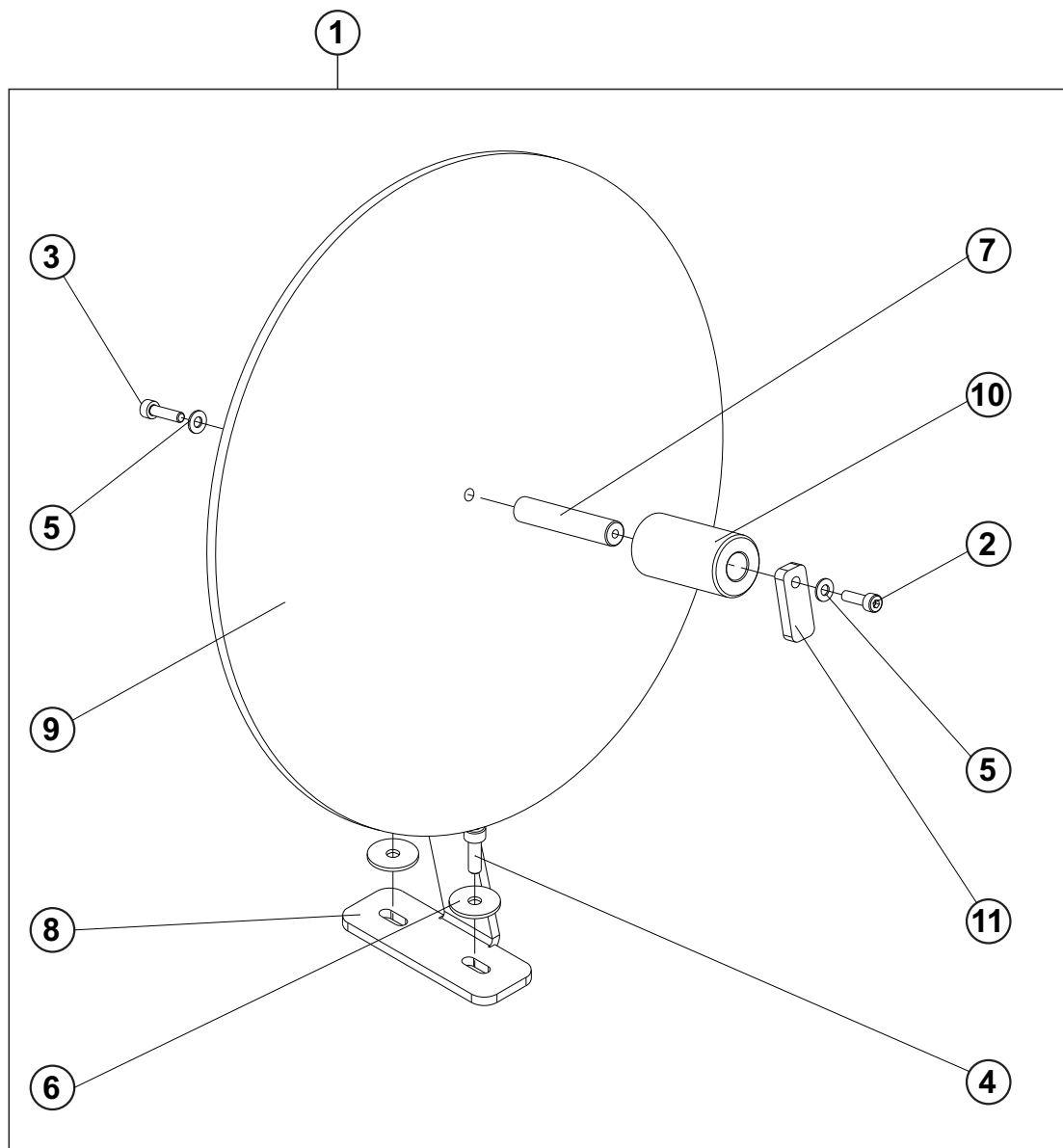


**AUTOMATIC LOADING AND CUTTING DEVICE**



DET	PART NUMBER	DESCRIPTION	QTY.
46	68.0291.0.300	SHAFT	1
47	68.0292.0.800	TAPE CLAMPER - MOVING	1
48	68.0293.0.800	DRIVER	1
49	68.0294.0.800	TAPE CLAMPER	1
50	68.0295.0.600	HOLDER	1
51	68.0296.0.800	HOLDER	1
52	68.0297.0.300	STUD	2
53	68.0298.0.300	SHAFT	1
54	68.0300.0.000	ROLLER ASSY.	1
55	68.0301.0.500	GEAR	1
56	68.0302.0.500	LINEAR GEAR	1
57	68.0303.0.600	MOVING ARM	1
58	68.0304.0.800	PLATE	1
59	68.0305.0.800	HOLDER	1
60	68.0306.0.800	HOLDER PLATE	1
61	68.0307.0.300	PIN 2h9-59	2
62	68.0308.0.400	ROLL	2
63	68.0364.0.600	TAPE GUIDE	1

# AUTOMATIC LOADING AND CUTTING DEVICE

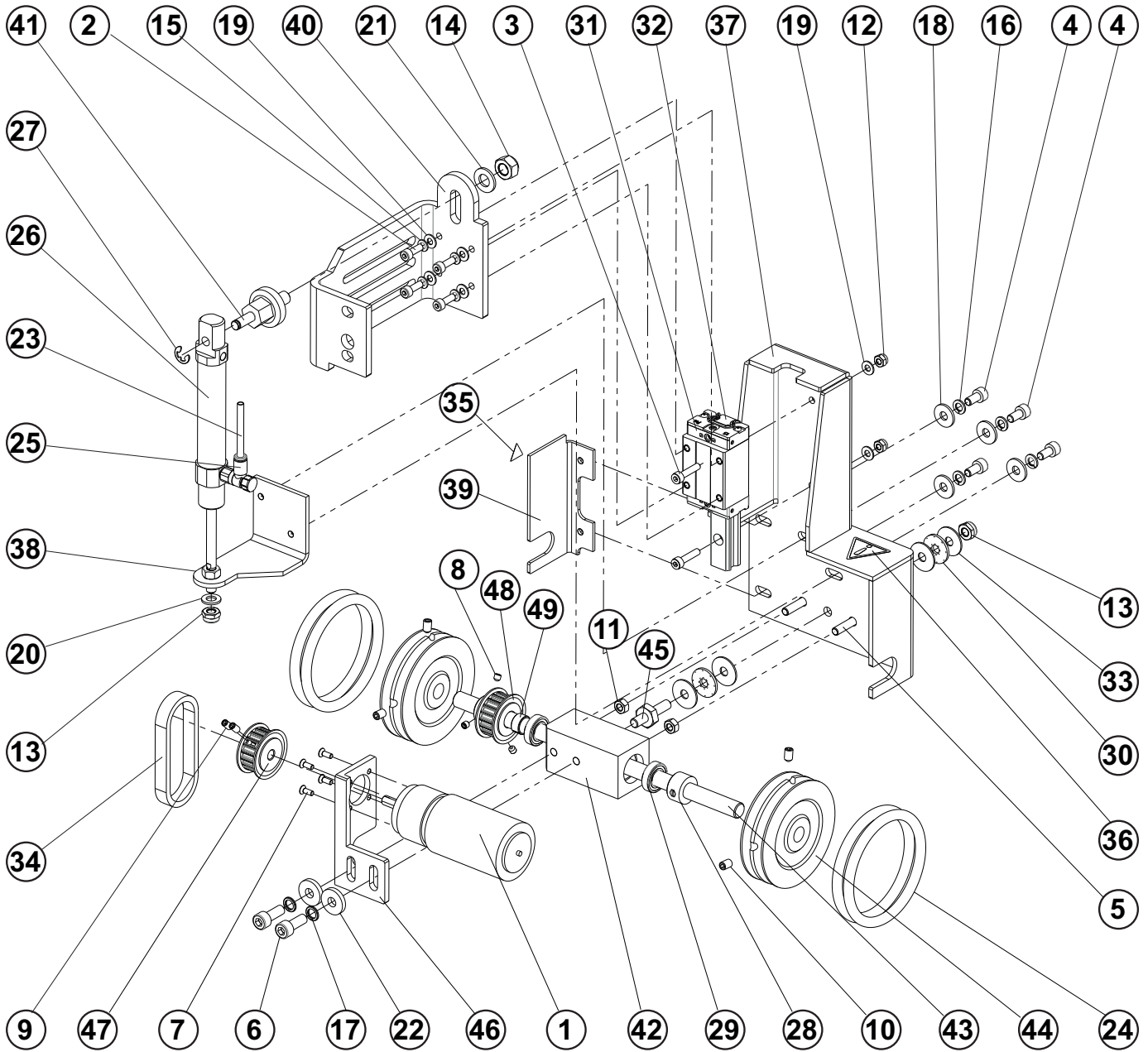




**AUTOMATIC LOADING AND CUTTING DEVICE**

DET	PART NUMBER	DESCRIPTION	QTY.
01	68.0310.0.050	TAPE HOLDER	
02	08.6002.4.014	SCREW M4-14	(1)
03	08.6002.4.016	SCREW M4-16	(1)
04	08.6002.5.016	SCREW M5-16	(2)
05	08.6852.4.000	WASHER M4	(2)
06	08.6882.5.000	WASHER 5,3x20-1,5	(2)
07	68.0309.0.300	SHAFT	(1)
08	68.0310.0.800	TAPE STAND	(1)
09	68.0311.0.992	COVER	(1)
10	68.0312.0.400	ROLLER	(1)
11	68.0313.0.992	STOP	(1)

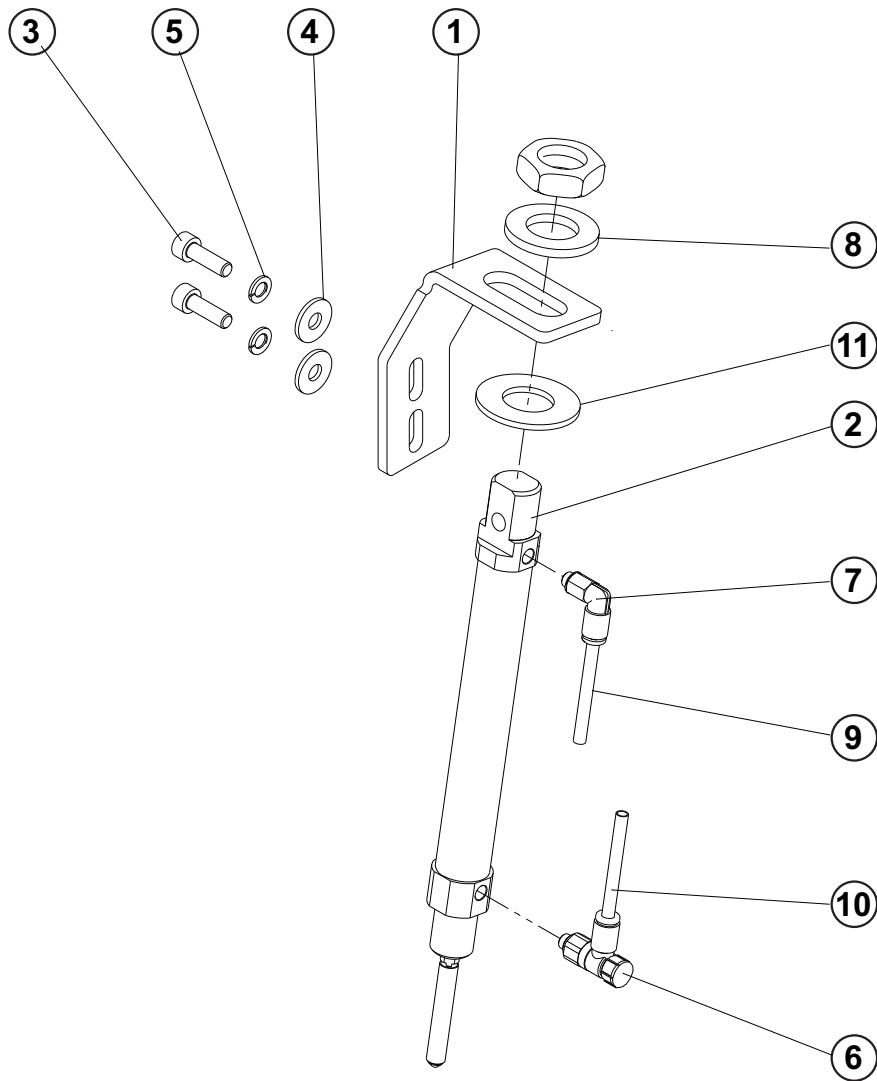
# AUSROLE UNIT



## AUSROLE UNIT

DET	PART NUMBER	DESCRIPTION	QTY.
01	06.6800.0.075	MOTOR AUSROLE ASSY.	1
02	08.6002.4.012	SCREW M4-12	4
03	08.6002.4.018	SCREW M4-18	2
04	08.6002.5.010	SCREW M5-10	4
05	08.6002.5.020	SCREW M5-20	2
06	08.6002.6.016	SCREW M6-16	2
07	08.6102.3.008	SCREW M3-8	4
08	08.6402.4.004	SCREW M4-4	3
09	08.6402.4.008	SCREW M4-8	2
10	08.6402.5.008	SCREW M5-8	4
11	08.6702.5.000	NUT M5	2
12	08.6732.4.000	NUT M4	2
13	08.6733.6.000	M6 NUT	2
14	08.6733.8.000	NUT M8	1
15	08.6802.4.000	SPRING WASHER M4	4
16	08.6802.5.000	SPRING WASHER M5	4
17	08.6802.6.000	SPRING WASHER M6	2
18	08.6842.5.000	WASHER 5	4
19	08.6852.4.000	WASHER M4	6
20	08.6852.6.000	WASHER 6,4	1
21	08.6852.8.000	WASHER M8	1
22	08.6892.6.000	WASHER M6	2
23	12.0008.3.416	AIR TUBE	1
24	12.0008.6.826	SILICONE O-RING	4
25	12.0010.3.113	SPEED CONTOLLER	1
26	12.0010.3.209	CYLINDER	1
27	12.1045.0.005	E-CLIP 5	1
28	12.1050.0.005	CLAMP COLLAR 10	1
29	12.2010.0.052	BEARING	2
30	12.2060.0.008	AXIAL BEARING	2
31	12.2070.1.068	LINEAR GUIDE	1
32	12.2070.1.074	LINEAR RAIL	1
33	12.2099.5.003	AXIAL RING	4
34	12.5050.2.045	BELT HTD	1
35	12.8000.0.437	LABEL-DANGER INJURY	1
36	17.0097.5.174	LABEL- WARNING	1
37	68.0360.0.000	BRACKET	1
38	68.0362.0.800	BRACKET	1
39	68.0363.0.800	PULLEY COVER	1
40	68.0365.0.800	BRACKET	1
41	68.0366.0.300	SCREW PIN	1
42	68.0367.0.600	HOUSE	1
43	68.0368.0.300	SHAFT	1
44	68.0369.0.400	WHEEL	2
45	68.0370.0.300	STUD	1
46	68.0371.0.600	MOTOR BRACKET	1
47	68.0372.0.500	MOTOR PULLEY	1
48	68.0373.0.500	WHEEL SHAFT PULLEY	1
49	68.0399.0.400	DISTANCE BUSHING	1

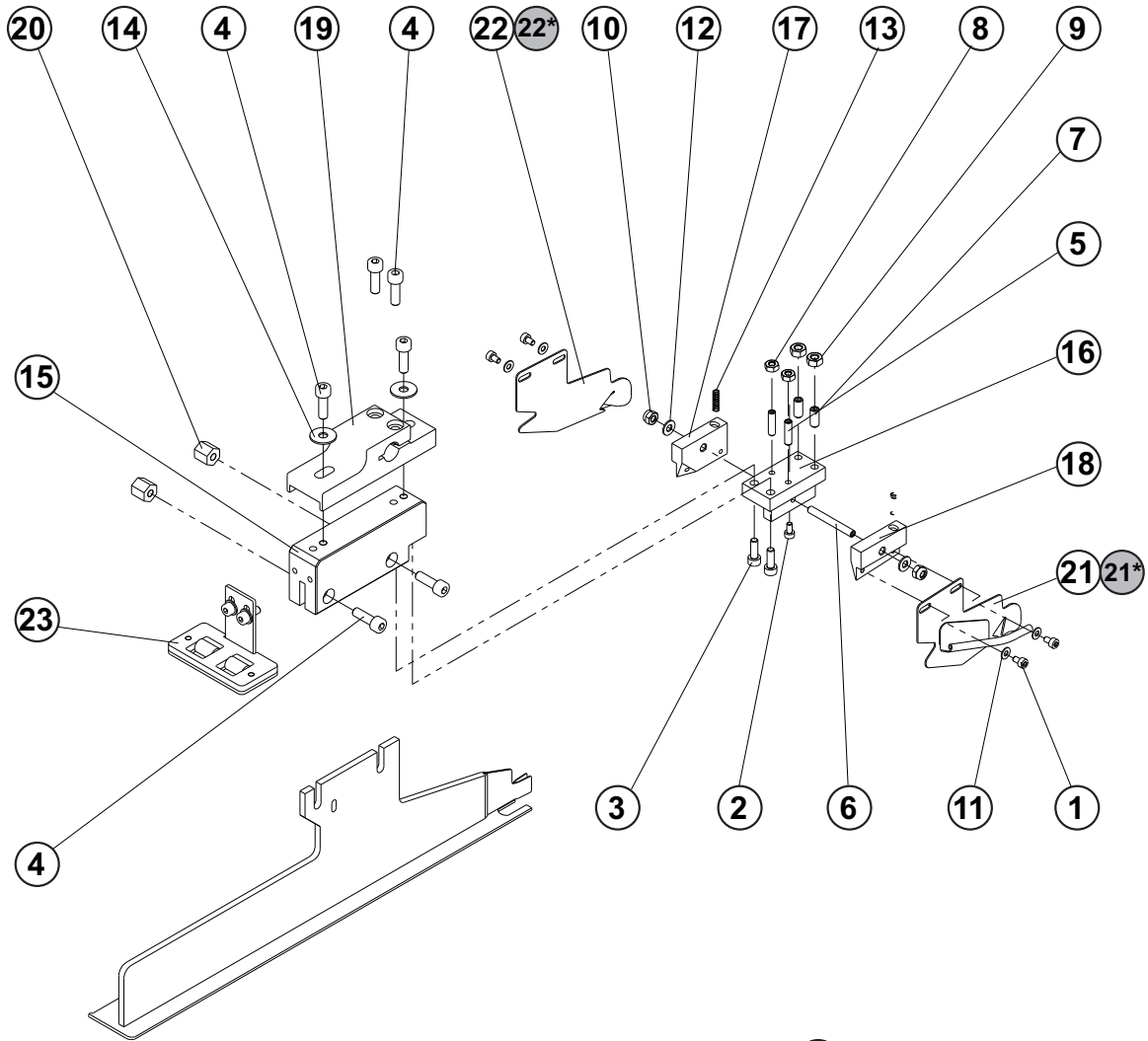
# DART STRETCHER



## DART STRETCHER

DET	PART NUMBER	DESCRIPTION	QTY.
01	68.0226.0.800	HOLDER	1
02	68.0227.0.000	DART STRETCHER CYLINDER	1
03	08.6002.5.016	SCREW M5-16	2
04	08.6842.5.000	WASHER 5	2
05	08.6802.5.000	SPRING WASHER M5	2
06	12.0010.3.047	SPEED CONTR.	1
07	12.0010.3.028	CONNECTOR	1
08	68.0265.0.100	WASHER M16	1
09	12.0010.3.080	AIR TUBE- J16A	
10	12.0008.3.416	AIR TUBE- J16B	
11	7002009	FLAT WASHER 5/8	1

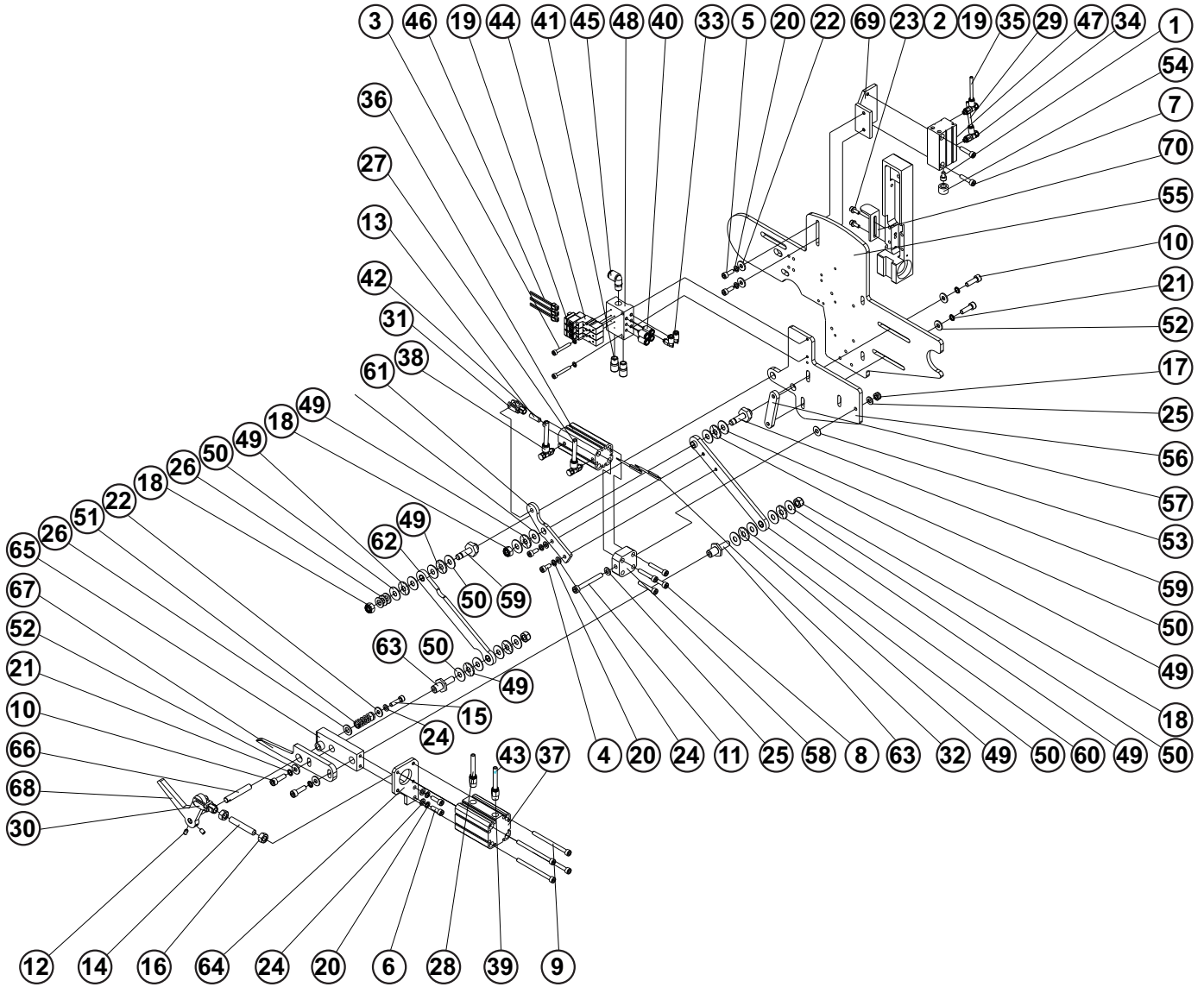
# ZIPPER - PATCH GUIDE



\* ZIPPER - Dia. 4 mm



# ZIPPER TRIMMING

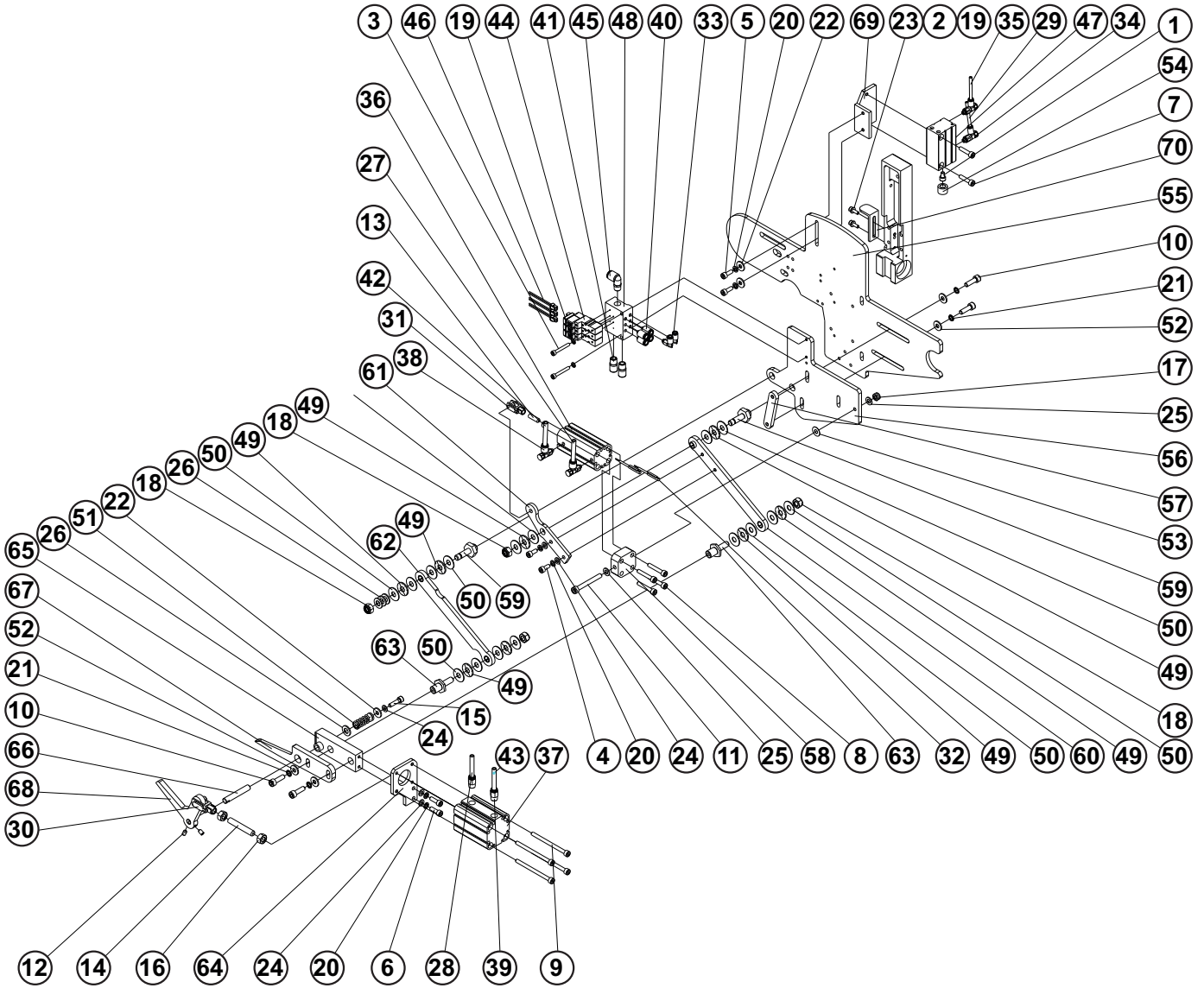




## ZIPPER TRIMING

DET	PART NUMBER	DESCRIPTION	QTY.
01	08.6000.5.008	SCREW M5 x 8	1
02	08.6002.4.012	SCREW M4-12	2
03	08.6002.4.030	SCREW M4-30	2
04	08.6002.5.012	SCREW M5-12	2
05	08.6002.5.014	SCREW M5-14	2
06	08.6002.5.016	SCREW M5-16	2
07	08.6002.5.022	SCREW M5-22	2
08	08.6002.5.030	SCREW M5-30	4
09	08.6002.5.070	SCREW M5-70	4
10	08.6002.6.020	SCREW M6-20	4
11	08.6002.6.050	SCREW M6-50	1
12	08.6402.5.008	SCREW M5-8	2
13	08.6402.6.020	SCREW M6-20	1
14	08.6402.8.050	SCREW M8-50	1
15	08.6502.5.020	SCREW M5-20	1
16	08.6702.8.000	NUT M8	2
17	08.6733.6.000	M6 NUT	1
18	08.6733.8.000	NUT M8	4
19	08.6802.4.000	SPRING WASHER M4	4
20	08.6802.5.000	SPRING WASHER M5	6
21	08.6802.6.000	SPRING WASHER M6	4
22	08.6842.5.000	WASHER 5	3
23	08.6852.4.000	WASHER M4	2
24	08.6852.5.000	WASHER 5,3	5
25	08.6852.6.000	WASHER M6	2
26	08.6852.8.000	WASHER M8	4
27	12.0008.3.415	AIR TUBING - J28B	1
28	12.0008.3.415	AIR TUBING - J29B	1
29	12.0008.3.416	AIR TUBE- J33B	1
30	12.0008.3.673	CLEVIS GKM8-16	1
31	12.0008.3.806	DOUBLE KNUCKLE	1
32	12.0008.3.825	SENSOR D-A93L	2
33	12.0010.3.028	CONNECTOR	2
34	12.0010.3.047	SPEED CONTR.	2
35	12.0010.3.080	AIR TUBE- J33A	1
36	12.0010.3.094	CYLINDER	1
37	12.0010.3.095	CYLINDER	1
38	12.0010.3.096	SPEED VALVE	2
39	12.0010.3.097	CONNECTOR	2
40	12.0010.3.098	CONNECTOR	4
41	12.0010.3.099	SILENCER	2
42	12.0010.3.101	AIR TUBING - J28A	1
43	12.0010.3.101	AIR TUBING - J29A	1
44	12.0010.3.105	5/2 VALVE	3
45	12.0010.3.106	CONNECTOR	1
46	12.0010.3.108	CABLE	3

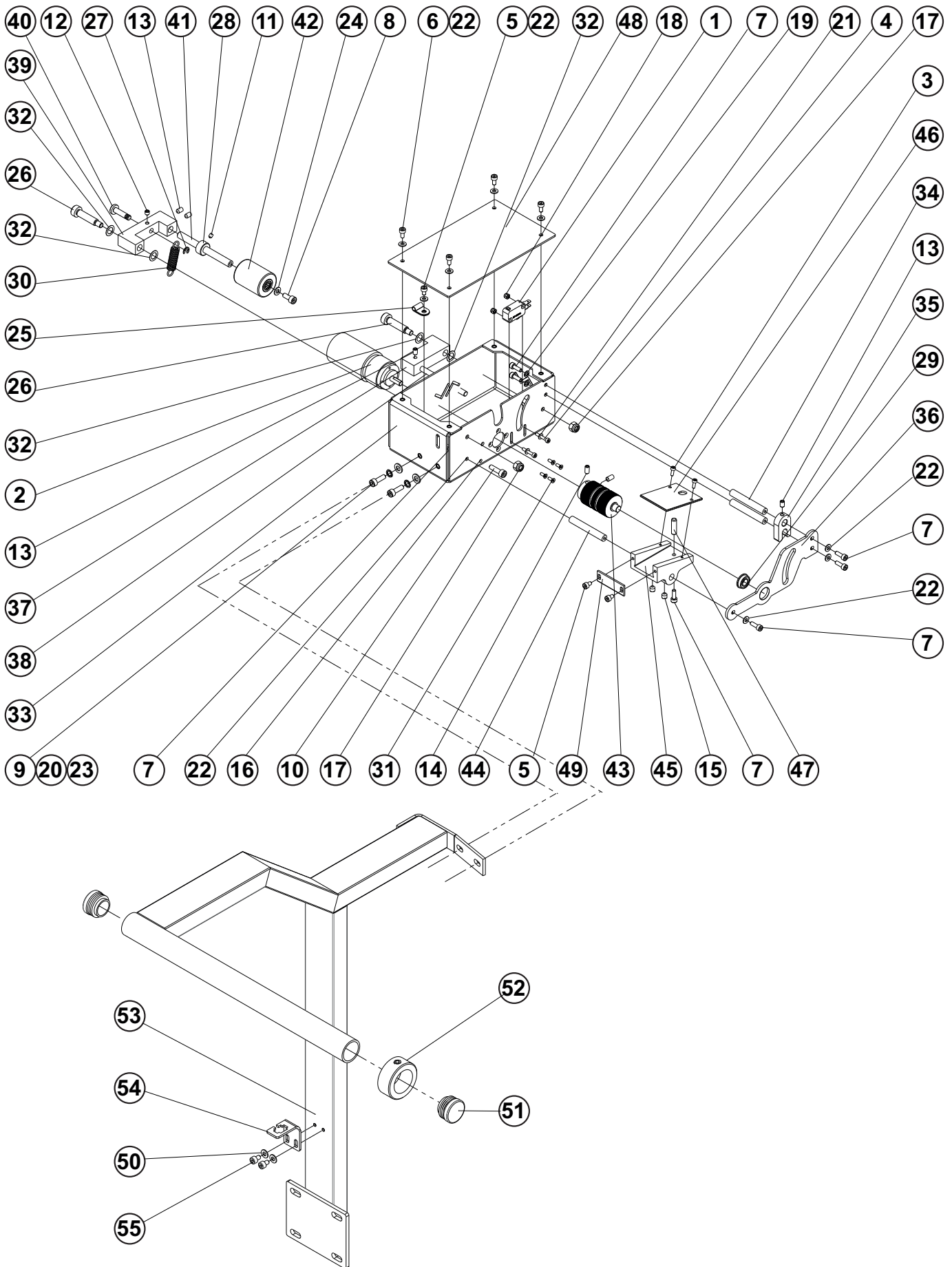
# ZIPPER TRIMMING



## ZIPPER TRIMING

DET	PART NUMBER	DESCRIPTION	QTY.
47	12.0010.3.245	CYLINDER	1
48	12.0010.3.246	MANIFOLD PLATE	1
49	12.2060.0.006	AXIAL BEARING	8
50	12.2099.5.002	AXIAL RING	16
51	12.3010.0.024	SPRING TL 1250x138x0280	1
52	17.0019.0.232	WASHER	4
53	17.0019.0.239	WASHER 6,2/15 - 0,2	1
54	19.0095.1.406	REST	1
55	68.0321.0.800	REMOVABLE BRACKET - ZIPPER	1
56	68.0322.0.800	BASE PLATE	1
57	68.0323.0.800	NUT	1
58	68.0324.0.600	CYLINDER BRACKET	1
59	68.0325.0.300	STUD	2
60	68.0326.0.800	LEVER	1
61	68.0327.0.800	LEVER	1
62	68.0328.0.800	LEVER	1
63	68.0329.0.300	STUD	2
64	68.0330.0.800	CYLINDER HOLDER	1
65	68.0332.0.000	BRACKET	1
66	68.0333.0.300	STUD	1
67	68.0334.3.800	LOWER KNIFE	1
68	68.0335.0.800	KNIFE UPPER	1
69	68.0402.0.600	CYLINDER BRACKET	1
70	68.0403.0.600	CYLINDER STOP	1

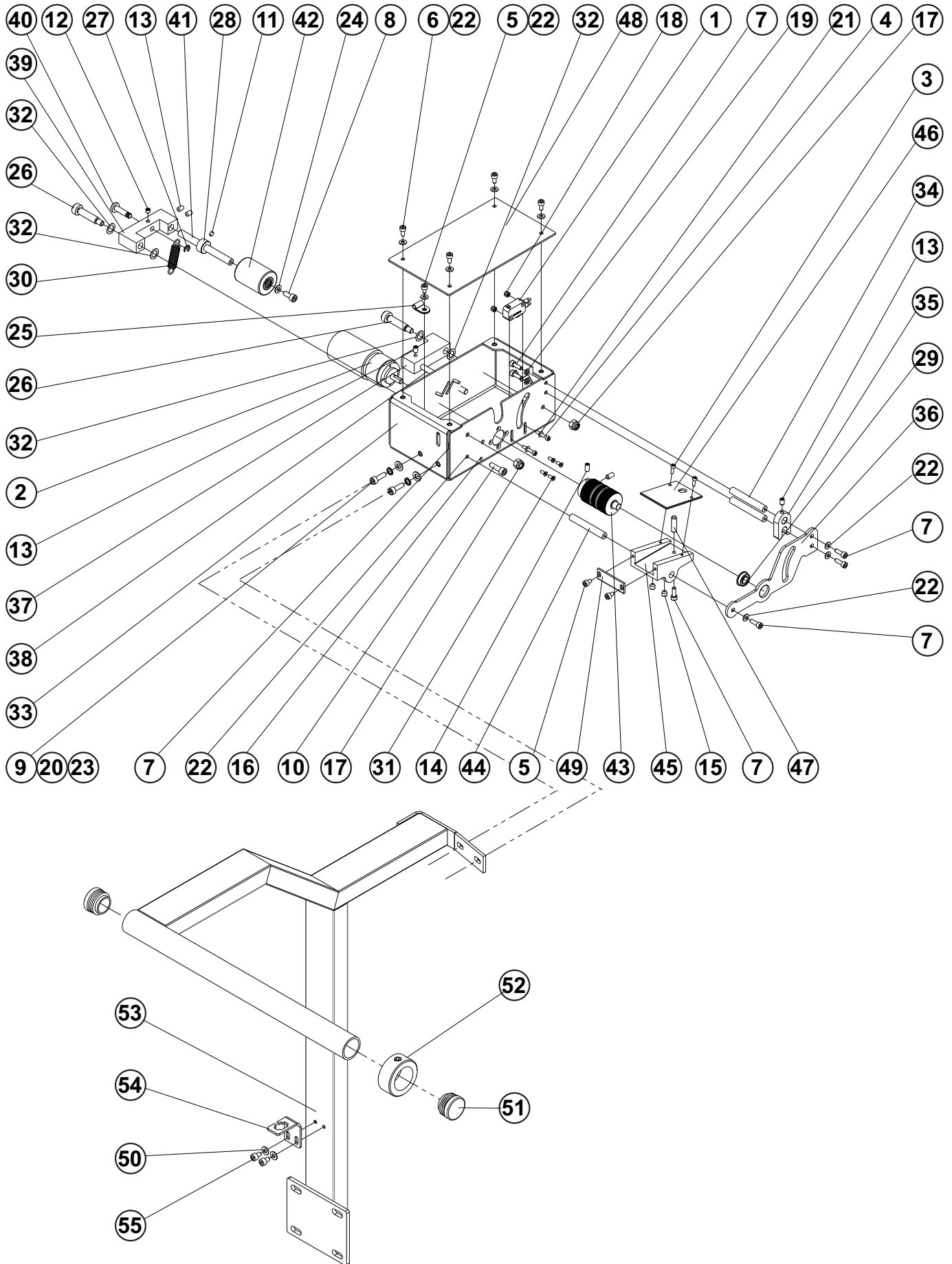
# ZIPPER - COVER LOADER



## ZIPPER - COVER LOADER

DET	PART NUMBER	DESCRIPTION	QTY.
01	04.1358.1.000	SWITCH-MICRO V3-2401-D8 HONEY	1
02	06.6800.0.077	DC MOTOR DRIVE ASSY.	1
03	08.6002.3.008	SCREW M3-8	2
04	08.6002.3.018	SCREW M3-18	2
05	08.6002.4.006	SCREW M4-6	3
06	08.6002.4.008	SCREW M4-8	4
07	08.6002.4.012	SCREW M4-12	7
08	08.6002.5.012	SCREW M5-12	1
09	08.6002.5.016	SCREW M5-16	2
10	08.6002.5.018	SCREW M5-18	1
11	08.6402.4.005	SCREW M4-5	1
12	08.6402.5.005	SCREW M5-5	1
13	08.6402.5.008	SCREW M5-8	4
14	08.6402.5.010	SCREW M5-10	2
15	08.6402.6.006	SCREW M6-6	2
16	08.6702.5.000	NUT M5	1
17	08.6732.6.000	NUT M6	2
18	08.6733.3.000	NUT M3	2
19	08.6802.4.000	SPRING WASHER M4	3
20	08.6802.6.000	SPRING WASHER M6	2
21	08.6852.3.000	WASHER M3	2
22	08.6852.4.000	WASHER M4	11
23	08.6852.6.000	WASHER 6,4	2
24	08.6887.5.000	WASHER 5	1
25	12.0008.4.277	CLAMP	1
26	12.1023.0.001	STUD 8g6x30/M6	2
27	12.1045.0.004	RETAINING RING 4	1
28	12.1050.0.003	CLAMP COLLAR 6	1
29	12.2010.0.036	BEARING FL688ZZ (MISUMI)	1
30	12.3011.0.015	SPRING 1,4x9,8x43,4	1
31	15.1420.0.100	SCREW M3-8	4
32	24.4068.0.002	WASHER	4
33	68.0337.0.800	COVER	1
34	68.0338.0.300	SHAFT	2
35	68.0339.0.800	GUIDE	1
36	68.0340.0.800	BRACKET	1
37	68.0341.0.600	BRACKET	1
38	68.0342.0.300	SHAFT	1
39	68.0343.0.600	BRACKET	1
40	68.0344.0.300	SPRING STUD	1
41	68.0345.0.300	SHAFT	1
42	68.0346.0.000	ROLLER ASSY.	1
43	68.0348.0.300	FEED ROLLER	1
44	68.0349.0.300	SHAFT	1
45	68.0350.0.600	ZIPPER GUIDE	1
46	68.0351.0.800	COVER	1

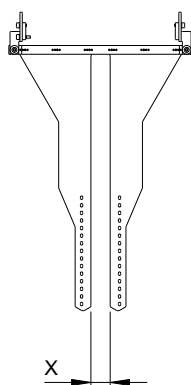
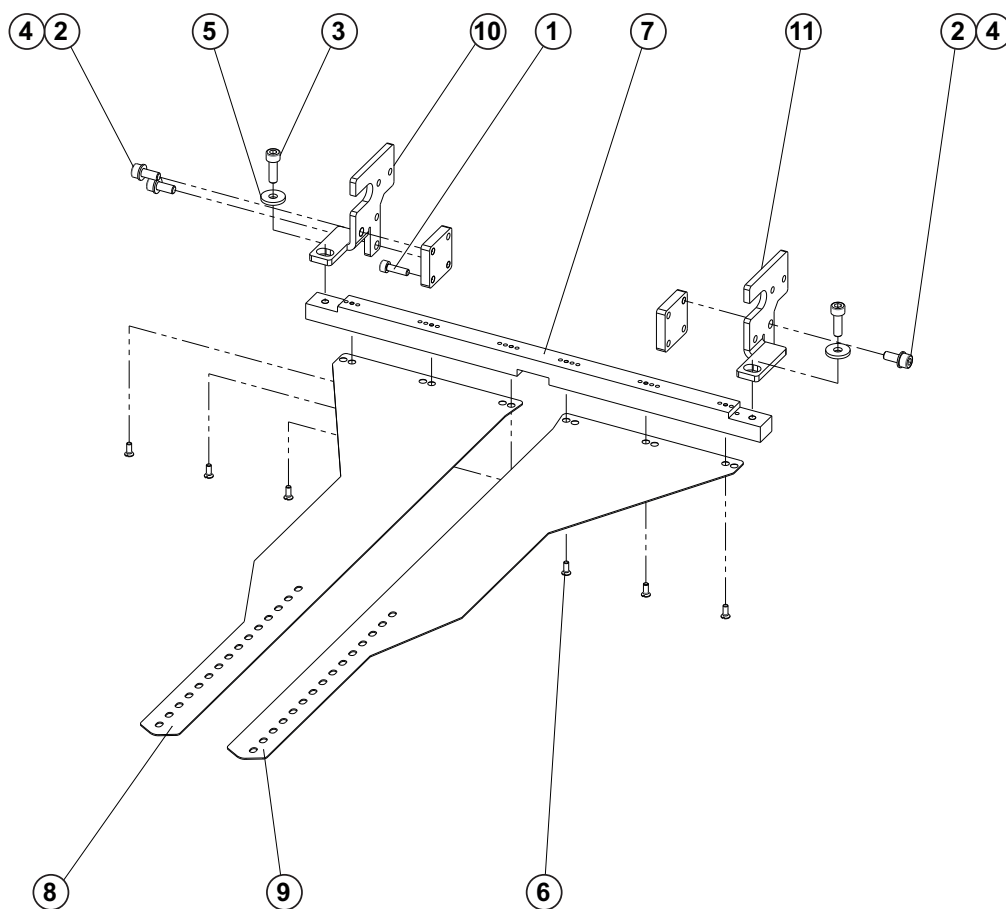
# ZIPPER - COVER LOADER



**ZIPPER - COVER LOADER**

DET	PART NUMBER	DESCRIPTION	QTY.
47	68.0352.0.300	GUIDE PIN	1
48	68.0353.0.800	COVER PLATE	1
49	68.0401.0.800	ZIPPER GUIDE PLATE	1
50	08.6852.4.000	WASHER M4	2
51	12.0010.6.918	PLUG 25x3	2
52	12.1050.0.008	RING 26	1
53	68.0336.0.000	ZIPPER STAND	1
54	68.0389.0.800	CABLE HOLDER	1
55	08.6002.4.006	SCREW M4-6	2

# SANDWICH CLAMP FOOT



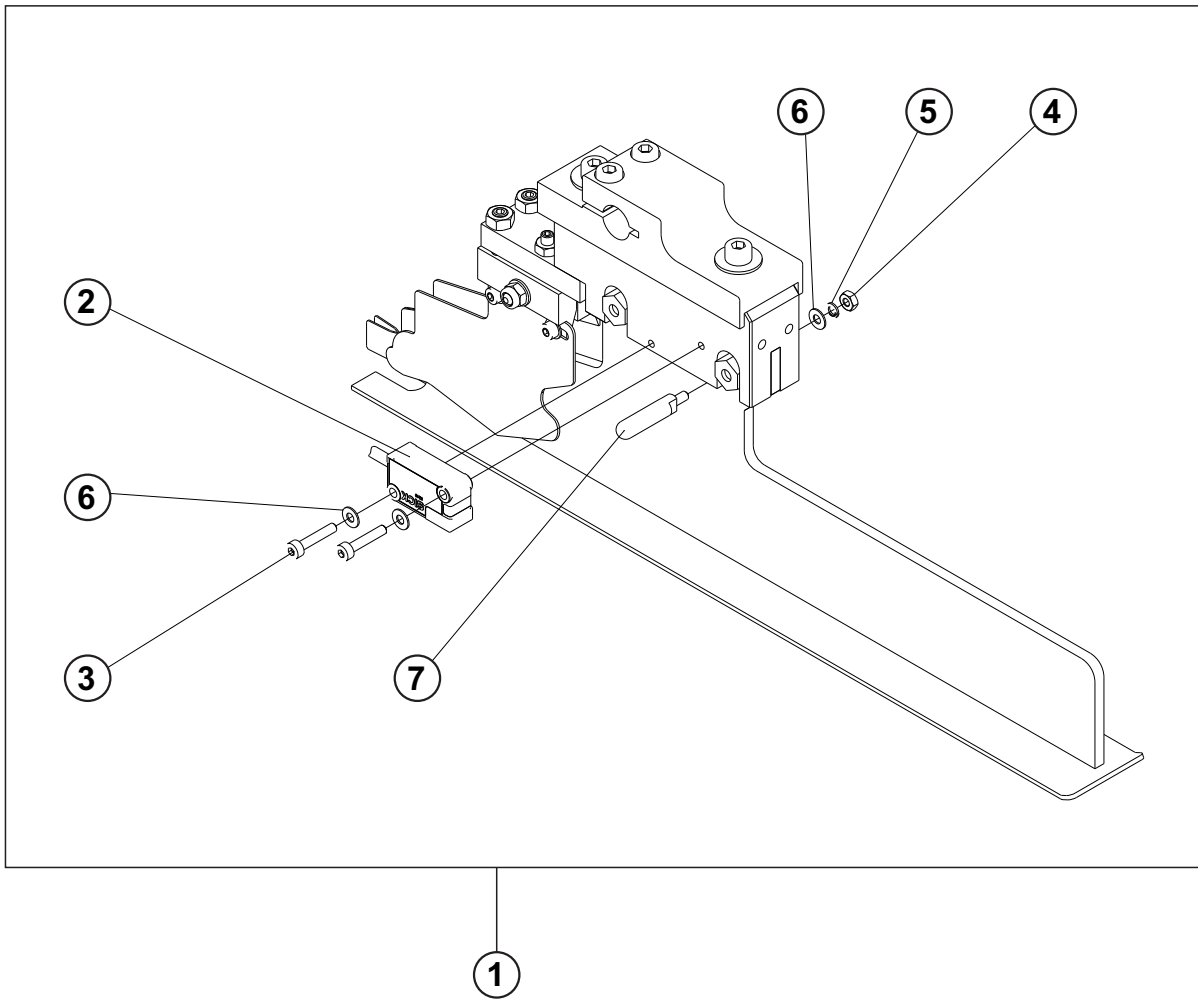
BITE SIZE "X"	
Bite 10 mm	21
Bite 12 mm	25
Bite 14 mm	29
Bite 16 mm	33
Bite 18 mm	37
Bite 20 mm	41



**SANDWICH CLAMP FOOT**

DET	PART NUMBER	DESCRIPTION	QTY.
01	08.6002.4.014	SCREW M4-14	1
02	08.6002.5.012	SCREW M5-12	3
03	08.6002.5.016	SCREW M5-16	2
04	08.6852.5.000	WASHER 5,3	3
05	08.6892.5.000	WASHER M5	2
06	15.1437.0.100	SCREW M3-8	6
07	68.0393.0.600	CLAMP BRACKET	1
08	68.0394.0.800	PLATE - LEFT	1
09	68.0395.0.800	PLATE - RIGHT	1
10	68.0396.0.800	HOLDER - LEFT	1
11	68.0397.0.800	HOLDER - RIGHT	1

# SINGLE/DOUBLE SENSOR KIT







**INDEX**

PART NUMBER	PAGE	DET	QTY	PART NUMBER	PAGE	DET	QTY	PART NUMBER	PAGE	DET	QTY
7002009	3-131	11	1	62060816	3-21	43	2	100328001	3-9	25	1
012060636	3-7	31	2	062061016	3-13	40	4	100401021	3-27	30	(1)
012060636	3-9	32	1	062061016	3-15	42	4	104450101	3-21	14	1
012060636	3-11	7	1	062061016	3-23	62	3	104450101	3-21	39	1
012060636	3-11	27	1	062061616	3-7	24	1	104450101	3-23	55	1
012060636	3-25	44	2	062300612	3-11	24	1	104821001	3-9	44	1
012061036	3-5	21	2	62300612	3-13	19	(4)	108549001	3-9	23	1
012061036	3-5	25	2	62300612	3-15	18	(4)	108801001	3-23	53	1
12500536	3-13	15	(1)	062300616	3-25	39	(1)	108802001	3-11	5	1
12500536	3-15	15	(1)	062350512	3-25	22	(1)	108802001	3-23	52	2
012500536	3-25	31	(1)	062350816	3-7	7	(1)	112728001	3-7	8	(1)
012500536	3-27	8	(2)	062400616	3-11	19	1	112753001	3-23	61	2
012500536	3-27	13	((1))	062400616	3-11	34	2	113014000	3-5	7	1
012500536	3-27	33	1	62400616	3-13	27	(1)	114941001	3-25	41	1
016061031	3-9	29	2	62400616	3-13	29	(1)	115947001	3-13	36	2
018062032	3-7	26	1	62400616	3-13	32	(1)	115947001	3-15	36	2
018062032	3-7	36	1	062400616	3-15	24	(1)	116010001	3-3	11	1
018062032	3-9	15	1	062400616	3-15	25	(1)	118735002	3-7	27	1
018062532	3-7	33	1	062400616	3-15	28	(1)	118954000	3-9	10	(1)
18081236	3-21	3	(1)	062400616	3-23	58	2	129458102	3-9	22	1
021300106	3-25	11	(1)	062401016	3-7	4	(2)	140063001	3-3	1	1
021350106	3-11	16	1	062401216	3-27	17	(1)	140890009	3-23	60	1
021500106	3-9	53	1	62401616	3-23	48	4	142274101	3-21	31	4
21500316	3-13	12	(1)	062500616	3-3	6	2	142746002	3-9	21	1
21500316	3-15	12	(1)	062500616	3-7	16	(1)	143611201	3-9	8	1
025050236	3-9	48	1	62500616	3-23	51	1	143612100	3-9	9	(1)
025050336	3-9	43	1	062500616	3-27	27	1	143613051	3-9	16	1
025060132	3-11	14	1	062500816	3-3	23	2	143616001	3-9	17	1
025060136	3-13	39	4	062500816	3-5	27	2	144504001	3-25	27	(4)
025060136	3-15	43	4	062500816	3-5	32	1	145446001	3-25	23	(4)
025060136	3-27	6	(1)	062500816	3-7	23	1	145446001	3-27	29	(2)
025060136	3-27	15	(2)	062500816	3-9	45	2	148394000	3-7	14	(1)
025060236	3-23	63	1	62500816	3-21	7	1	148743001	3-21	30	2
025100132	3-9	36	1	062500816	3-25	42	2	151027001	3-17	5	(2)
25710132	3-13	11	(1)	062501016	3-9	3	(4)	151030001	3-17	4	((1))
25710132	3-15	11	(1)	062501216	3-3	4	7	154518001	3-17	2	((1))
048040342	3-27	2	(1)	062501216	3-9	42	1	154519001	3-17	3	((1))
048040342	3-27	14	(1)	062501216	3-9	47	1	154560001	3-25	28	(2)
048060342	3-9	18	2	062501216	3-9	52	1	154965001	3-13	17	(1)
048080342	3-9	35	1	072600480	3-19	9	1	154965001	3-15	17	(1)
061350616	3-25	19	(1)	076023800	3-5	17	1	155510001	3-25	29	(2)
061350616	3-25	37	(2)	81004070	3-21	21	1	158115001	3-5	20	1
062060816	3-7	29	2	81004070	3-21	25	1	158115001	3-19	13	1
062060816	3-9	7	1	081009070	3-27	5	(1)	159805001	3-25	24	(2)
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02.1341.0.110	3-97	1	10	08.6002.3.004	3-47	1	2	08.6002.4.005	3-75	13	6
02.1341.0.111	3-97	15*	10	08.6002.3.004	3-51	1	2	08.6002.4.006	3-79	4	3
04.1358.1.000	3-139	1	1	08.6002.3.005	3-45	1	4	08.6002.4.006	3-91	1	3
04.9015.0.361	3-85	1	1	08.6002.3.005	3-47	2	4	08.6002.4.006	3-139	5	3
04.9068.0.050	3-75	1	1	08.6002.3.005	3-53	55	4	08.6002.4.006	3-141	55	2
04.9068.0.361	3-75	2	2	08.6002.3.005	3-133	1	4	08.6002.4.008	3-109	2	3
04.9068.0.362	3-107	1	2	08.6002.3.006	3-33	1	4	08.6002.4.008	3-111	4	4
04.9068.0.363	3-75	3	1	08.6002.3.006	3-45	2	1	08.6002.4.008	3-115	3	4
04.9068.0.364	3-75	4	1	08.6002.3.006	3-133	2	1	08.6002.4.008	3-119	4	2
04.9068.0.365	3-75	5	1	08.6002.3.008	3-29	01	1	08.6002.4.008	3-123	4	2
04.9068.0.366	3-75	6	2	08.6002.3.008	3-41	1	2	08.6002.4.008	3-139	6	4
04.9068.0.367	3-75	7	1	08.6002.3.008	3-63	1	16	08.6002.4.010	3-57	38	2
04.9068.0.368	3-75	8	1	08.6002.3.008	3-65	1	2	08.6002.4.010	3-65	6	2
04.9068.0.370	3-57	1	1	08.6002.3.008	3-67	1	2	08.6002.4.010	3-67	6	2
04.9068.0.371	3-57	2	2	08.6002.3.008	3-73	1	48	08.6002.4.010	3-77	54	3
04.9068.0.500	3-79	1	1	08.6002.3.008	3-107	2	3	08.6002.4.010	3-87	2	2
04.9068.0.900	3-75	9	1	08.6002.3.008	3-109	1	3	08.6002.4.010	3-111	5	2
04.9068.0.901	3-75	10	1	08.6002.3.008	3-119	2	16	08.6002.4.010	3-121	68	2
04.9068.0.902	3-75	11	1	08.6002.3.008	3-139	3	2	08.6002.4.010	3-123	5	4
05.1322.0.000	3-75	12	1	08.6002.3.010	3-55	1	2	08.6002.4.012	3-31	3	1
05.1322.0.000	3-97	2	1	08.6002.3.010	3-59	1	2	08.6002.4.012	3-33	3	2
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06.6800.0.021	3-41	22	1	08.6002.3.010	3-67	2	2	08.6002.4.012	3-45	3	2
06.6800.0.028	3-57	3	1	08.6002.3.012	3-65	3	2	08.6002.4.012	3-71	1	3
06.6800.0.037	3-87	1	1	08.6002.3.012	3-67	3	2	08.6002.4.012	3-119	5	10
06.6800.0.038	3-85	2	1	08.6002.3.016	3-49	1	2	08.6002.4.012	3-123	6	5
06.6800.0.039	3-85	3	1	08.6002.3.016	3-51	2	2	08.6002.4.012	3-129	2	4
06.6800.0.049	3-79	2	1	08.6002.3.016	3-63	2	4	08.6002.4.012	3-133	3	2
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06.6800.0.062	3-31	22	1	08.6002.3.016	3-73	2	12	08.6002.4.014	3-37	3	3
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06.6800.0.100	3-145	2	1	08.6002.3.018	3-111	1	2	08.6002.4.014	3-143	1	1
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08.6002.4.022	3-111	6	2	08.6002.5.016	3-91	2	6	08.6002.6.020	3-59	5	4
08.6002.4.025	3-33	4	2	08.6002.5.016	3-119	10	2	08.6002.6.020	3-63	5	4
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08.6002.4.025	3-73	3	2	08.6002.5.016	3-131	3	2	08.6002.6.020	3-83	6	2
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08.6002.4.025	3-119	7	2	08.6002.5.016	3-139	9	2	08.6002.6.020	3-135	10	4
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08.6002.4.030	3-51	5	4	08.6002.5.018	3-119	11	2	08.6002.6.025	3-115	6	4
08.6002.4.030	3-135	3	2	08.6002.5.018	3-139	10	1	08.6002.6.045	3-79	9	1
08.6002.4.035	3-71	2	2	08.6002.5.020	3-61	1	2	08.6002.6.045	3-111	13	4
08.6002.4.035	3-123	9	1	08.6002.5.020	3-129	5	2	08.6002.6.045	3-115	7	4
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08.6002.5.008	3-63	4	4	08.6002.5.025	3-55	3	2	08.6002.8.016	3-75	16	17
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08.6002.5.012	3-57	5	2	08.6002.5.070	3-135	9	4	08.6002.8.030	3-107	3	6
08.6002.5.012	3-119	9	3	08.6002.6.010	3-123	13	2	08.6002.8.030	3-111	17	1
08.6002.5.012	3-123	11	1	08.6002.6.012	3-39	3	1	08.6002.8.035	3-115	11	1
08.6002.5.012	3-135	4	2	08.6002.6.012	3-61	2	2	08.6002.8.040	3-111	18	1
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08.6002.5.016	3-37	8	2	08.6002.6.016	3-57	6	4	08.6050.5.008	3-75	18	2
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08.6102.5.008	3-91	5	2	08.6402.4.008	3-39	4	8	08.6402.6.030	3-43	6	2
08.6102.5.012	3-35	4	4	08.6402.4.008	3-123	17	1	08.6402.6.030	3-119	18	1
08.6102.5.016	3-41	8	4	08.6402.4.008	3-129	9	2	08.6402.8.008	3-33	8	2
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08.6102.6.020	3-59	8	1	08.6402.4.016	3-49	5	1	08.6402.8.040	3-111	22	1
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08.6202.4.006	3-85	5	1	08.6402.5.005	3-139	12	1	08.6702.4.000	3-119	19	2
08.6202.4.008	3-35	6	2	08.6402.5.006	3-31	10	2	08.6702.4.000	3-123	20	1
08.6202.4.008	3-123	14	6	08.6402.5.008	3-129	10	4	08.6702.4.000	3-133	8	2
08.6202.5.016	3-37	9	1	08.6402.5.008	3-135	12	2	08.6702.5.000	3-31	13	1
08.6202.5.016	3-79	11	2	08.6402.5.008	3-139	13	4	08.6702.5.000	3-35	12	2
08.6202.5.020	3-35	7	2	08.6402.5.010	3-31	11	2	08.6702.5.000	3-45	9	2
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08.6312.8.016	3-119	16	4	08.6402.5.012	3-67	9	1	08.6702.6.000	3-35	13	2
08.6312.9.040	3-57	11	1	08.6402.5.012	3-123	19	2	08.6702.6.000	3-43	8	2
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08.6402.3.005	3-51	8	4	08.6402.6.008	3-111	19	10	08.6702.6.000	3-119	20	1
08.6402.3.005	3-65	8	2	08.6402.6.008	3-115	12	3	08.6702.8.000	3-57	16	4
08.6402.3.005	3-67	8	2	08.6402.6.010	3-111	20	4	08.6702.8.000	3-59	12	4
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08.6402.4.005	3-139	11	1	08.6402.6.016	3-59	10	4	08.6702.8.000	3-135	16	2
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08.6722.8.000	3-75	24	2	08.6802.5.000	3-91	9	1	08.6852.3.000	3-59	13	2
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08.6732.4.000	3-75	25	5	08.6802.5.000	3-129	16	4	08.6852.3.000	3-67	12	5
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08.6732.6.000	3-37	11	1	08.6802.6.000	3-111	26	6	08.6852.4.000	3-45	12	2
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08.6732.6.000	3-115	17	1	08.6802.6.000	3-139	20	2	08.6852.4.000	3-57	40	2
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08.6733.6.000	3-135	17	1	08.6802.8.000	3-107	4	6	08.6852.4.000	3-75	32	8
08.6733.8.000	3-75	27	8	08.6802.8.000	3-111	27	7	08.6852.4.000	3-79	24	5
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08.6802.3.000	3-29	08	1	08.6842.5.000	3-135	22	3	08.6852.4.000	3-129	19	6
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08.6802.4.000	3-115	19	4	08.6842.8.000	3-75	31	16	08.6852.5.000	3-37	12	6
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08.6852.8.000	3-61	8	2	12.0008.3.416	3-63	12	0	12.0008.4.140	3-111	36	0
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12.0010.3.246	3-137	48	1	12.1045.0.007	3-113	57	1	12.8000.0.452	3-113	84	1
12.0010.4.025	3-119	44	1	12.1045.0.007	3-115	38	1	12.8000.0.452	3-115	40	1
12.0010.4.067	3-93	20	1	12.1045.1.017	3-31	23	1	12.8000.1.059	3-3	19	1
12.0010.4.078	3-93	6	1	12.1050.0.003	3-123	36	3	12.8000.1.067	3-79	29	1
12.0010.4.093	3-35	17	1	12.1050.0.003	3-139	28	1	12.9900.9.010	3-83	3	1
12.0010.4.093	3-61	9	1	12.1050.0.005	3-71	14	1	15.1142.0.400	3-45	14	2
12.0010.4.163	3-93	19	1	12.1050.0.005	3-129	28	1	15.1142.0.400	3-133	14	2
12.0010.4.168	3-93	13	1	12.1050.0.008	3-141	52	1	15.1144.0.000	3-57	28	1
12.0010.4.215	3-107	9	5	12.1050.0.013	3-115	39	1	15.1420.0.100	3-47	16	3
12.0010.4.249	3-93	14	1	12.2010.0.000	3-37	20	1	15.1420.0.100	3-51	26	3
12.0010.4.255	3-93	15	1	12.2010.0.036	3-139	29	1	15.1420.0.100	3-123	38	2
12.0010.4.271	3-95	3	—	12.2010.0.037	3-31	24	1	15.1420.0.100	3-139	31	4
12.0010.4.277	3-93	9	2	12.2010.0.052	3-129	29	2	15.1437.0.100	3-143	6	6
12.0010.4.300	3-91	14	1	12.2050.0.011	3-123	37	2	17.0012.0.688	3-33	16	2
12.0010.4.305	3-43	4	2	12.2060.0.005	3-59	29	2	17.0019.0.232	3-137	52	4
12.0010.4.318	3-93	16	1	12.2060.0.006	3-137	49	8	17.0019.0.239	3-137	53	1
12.0010.4.327	3-41	21	1	12.2060.0.008	3-129	30	2	17.0027.4.085	3-35	20	2
12.0010.4.338	3-93	8	1	12.2070.1.067	3-37	21	1	17.0027.4.129	3-31	25	1
12.0010.6.212	3-35	18	1	12.2070.1.068	3-37	22	1	17.0033.2.030	3-3	26	1
12.0010.6.216	3-75	41	2	12.2070.1.068	3-129	31	1	17.0094.0.029	3-85	9	8
12.0010.6.217	3-75	42	2	12.2070.1.069	3-63	22	2	17.0094.1.097	3-3	27	2
12.0010.6.218	3-75	43	4	12.2070.1.069	3-73	25	6	17.0097.5.174	3-31	26	1
12.0010.6.219	3-113	52	1	12.2070.1.069	3-119	46	2	17.0097.5.174	3-57	41	1
12.0010.6.239	3-115	34	1	12.2070.1.070	3-121	47	2	17.0097.5.174	3-77	55	1
12.0010.6.914	3-113	53	2	12.2070.1.071	3-121	48	2	17.0097.5.174	3-121	66	1
12.0010.6.914	3-115	35	1	12.2070.1.072	3-57	25	1	17.0097.5.174	3-129	36	1
12.0010.6.915	3-113	54	1	12.2070.1.073	3-57	26	1	19.0044.5.404	3-75	44	1
12.0010.6.915	3-115	36	1	12.2070.1.074	3-129	32	1	19.0094.0.414	3-79	30	1
12.0010.6.918	3-141	51	2	12.2099.5.001	3-59	30	6	19.0095.1.406	3-137	54	1
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12.1010.2.035	3-51	25	2	12.3010.0.025	3-133	13	2	39.0039.4.002	3-98	0	0
12.1010.2.036	3-113	55	1	12.3011.0.015	3-139	30	1	39.0039.4.003	3-98	0	0
12.1010.2.036	3-115	37	1	12.5050.2.032	3-41	23	1	39.0039.4.004	3-98	0	0
12.1016.0.002	3-3	20	2	12.5050.2.033	3-57	27	0	39.0039.4.005	3-98	0	0
12.1016.0.002	3-79	28	2	12.5050.2.034	3-121	49	-	39.0039.4.006	3-98	0	0
12.1023.0.001	3-139	26	2	12.5050.2.045	3-129	34	1	52.0035.0.100	3-75	45	1
12.1045.0.004	3-139	27	1	12.8000.0.409	3-59	50	1	68.0001.0.600	3-49	13	1
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68.0003.0.600	3-51	28	1	68.0026.0.800	3-47	32	1	68.0105.0.600	3-133	16	1
68.0004.0.600	3-49	15	1	68.0026.0.800	3-53	49	1	68.0106.0.600	3-45	17	1
68.0004.0.600	3-51	29	1	68.0027.0.300	3-47	33	2	68.0106.0.600	3-133	17	1
68.0005.0.300	3-47	17	2	68.0027.0.300	3-53	50	2	68.0107.0.600	3-45	18	1
68.0005.0.300	3-51	30	2	68.0028.0.800	3-47	34	2	68.0107.0.600	3-133	18	1
68.0006.0.600	3-47	18	1	68.0028.0.800	3-53	51	2	68.0108.0.800	3-45	19	1
68.0007.0.600	3-51	31	1	68.0029.0.990	3-47	35	1	68.0109.0.800	3-45	20	1
68.0008.0.600	3-47	19	1	68.0029.0.990	3-53	52	1	68.0110.1.600	3-45	21	1
68.0008.0.600	3-51	32	1	68.0029.0.990	3-97	10	2	68.0110.1.600	3-133	19	1
68.0009.0.300	3-47	20	1	68.0031.0.600	3-59	32	1	68.0111.0.600	3-57	34	1
68.0009.0.300	3-51	33	1	68.0032.0.600	3-59	33	1	68.0113.0.050	3-31	27	1
68.0010.0.800	3-47	21	1	68.0033.0.600	3-59	34	1	68.0114.0.600	3-31	28	1
68.0010.0.800	3-51	34	1	68.0034.0.600	3-59	35	1	68.0115.0.600	3-31	29	1
68.0011.0.300	3-47	22	1	68.0035.0.800	3-59	36	1	68.0118.0.000	3-31	30	1
68.0011.0.300	3-51	35	1	68.0036.0.800	3-59	37	1	68.0119.0.100	3-31	31	2
68.0012.0.400	3-47	23	2	68.0037.0.600	3-57	29	1	68.0120.0.300	3-41	24	1
68.0012.0.400	3-51	36	2	68.0038.0.300	3-59	38	2	68.0121.0.800	3-41	25	1
68.0013.0.992	3-47	24	1	68.0039.0.400	3-59	39	2	68.0122.0.600	3-41	26	2
68.0013.0.992	3-51	37	1	68.0040.0.800	3-55	11	1	68.0125.0.800	3-41	27	1
68.0014.0.992	3-47	25	1	68.0040.0.800	3-59	40	1	68.0126.0.800	3-41	28	1
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68.0016.0.800	3-51	40	1	68.0044.0.300	3-59	44	2	68.0131.0.600	3-31	33	1
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68.0017.0.600	3-51	41	1	68.0046.0.800	3-57	30	1	68.0133.0.400	3-31	35	1
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68.0019.0.800	3-51	42	1	68.0048.0.600	3-59	46	1	68.0135.0.600	3-31	37	1
68.0020.0.800	3-47	29	1	68.0049.0.600	3-59	47	1	68.0136.0.600	3-31	38	1
68.0020.0.800	3-51	43	1	68.0050.0.800	3-57	32	1	68.0138.0.000	3-31	39	1
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68.0021.0.300	3-51	44	2	68.0070.0.300	3-33	17	2	68.0141.0.000	3-71	16	1
68.0022.0.992	3-47	30	1	68.0071.0.600	3-33	18	2	68.0142.0.600	3-71	17	1
68.0022.0.992	3-51	45	1	68.0072.0.600	3-33	19	2	68.0143.0.300	3-71	18	1
68.0022.0.992	3-97	8	2	68.0073.0.800	3-33	20	2	68.0144.0.100	3-45	22	2
68.0023.0.300	3-49	18	1	68.0074.0.800	3-33	21	1	68.0144.0.100	3-133	20	2
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68.0024.0.990	3-53	47	1	68.0077.0.600	3-33	24	1	68.0147.0.600	3-35	24	2
68.0024.0.990	3-97	9	2	68.0078.0.800	3-33	25	1	68.0148.0.300	3-35	25	2
68.0025.0.200	3-47	31	2	68.0100.0.000	3-45	24	1	68.0149.0.600	3-37	23	1
68.0025.0.200	3-53	48	2	68.0104.0.600	3-45	15	1	68.0150.1.800	3-35	26	1
68.0025.0.200	3-65	16	1	68.0104.0.600	3-133	15	1	68.0151.0.800	3-35	27	1

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68.0153.0.800	3-37	24	1	68.0193.0.600	3-67	22	1	68.0230.1.992	3-81	4	1
68.0154.0.600	3-37	25	1	68.0194.0.600	3-65	23	1	68.0231.0.600	3-29	14	1
68.0155.0.800	3-37	26	1	68.0194.0.600	3-67	23	1	68.0233.0.800	3-29	15	1
68.0156.0.800	3-35	29	1	68.0195.0.300	3-65	24	1	68.0235.0.300	3-29	16	1
68.0157.0.800	3-37	27	1	68.0195.0.300	3-67	24	1	68.0236.0.800	3-29	17	1
68.0158.0.600	3-39	7	4	68.0196.0.600	3-65	25	1	68.0239.0.800	3-43	1	1
68.0159.0.300	3-39	8	4	68.0196.0.600	3-67	25	1	68.0240.0.800	3-43	2	1
68.0160.1.400	3-39	9	4	68.0197.0.300	3-65	26	1	68.0241.0.800	3-43	3	1
68.0161.0.300	3-39	10	1	68.0197.0.300	3-67	26	1	68.0242.0.800	3-3	24	1
68.0162.0.800	3-35	30	1	68.0198.0.800	3-65	27	1	68.0243.0.800	3-41	32	1
68.0163.0.600	3-37	28	1	68.0198.0.800	3-67	27	1	68.0244.0.300	3-41	33	1
68.0164.0.300	3-37	29	1	68.0200.0.300	3-77	47	1	68.0245.0.000	3-57	36	1
68.0165.0.300	3-37	30	1	68.0201.0.800	3-77	48	1	68.0246.0.500	3-57	37	1
68.0166.0.100	3-37	31	1	68.0202.0.800	3-65	28	1	68.0247.0.300	3-77	51	1
68.0167.0.300	3-35	31	1	68.0202.0.800	3-67	28	1	68.0248.0.800	3-77	52	1
68.0168.0.400	3-35	32	1	68.0203.0.800	3-65	29	1	68.0251.0.300	3-121	58	1
68.0169.0.600	3-35	33	1	68.0203.0.800	3-67	29	1	68.0252.0.000	3-121	59	1
68.0170.0.050	3-37	32	1	68.0204.0.990	3-65	30	2	68.0253.0.500	3-121	60	1
68.0170.0.300	3-37	36	(1)	68.0204.0.990	3-67	30	2	68.0254.0.600	3-121	61	1
68.0171.0.300	3-37	35	(1)	68.0205.0.800	3-73	31	1	68.0255.0.600	3-121	62	2
68.0172.0.200	3-35	34	1	68.0206.0.800	3-63	24	1	68.0256.0.300	3-107	10	1
68.0173.0.200	3-37	34	(1)	68.0206.0.800	3-73	32	1	68.0257.0.400	3-107	11	1
68.0174.0.100	3-37	37	(1)	68.0207.0.600	3-63	25	2	68.0257.0.400	3-109	10	1
68.0175.0.100	3-33	26	1	68.0207.0.600	3-73	33	2	68.0258.0.800	3-107	12	1
68.0175.0.100	3-97	11	2	68.0208.0.000	3-65	31	1	68.0258.0.800	3-109	11	1
68.0176.0.100	3-33	27	1	68.0208.0.000	3-67	31	1	68.0259.0.800	3-107	13	1
68.0180.0.800	3-121	50	1	68.0210.0.800	3-61	10	1	68.0259.1.800	3-77	56	1
68.0181.0.800	3-121	51	1	68.0211.0.800	3-61	11	1	68.0259.1.800	3-123	39	1
68.0182.0.600	3-121	52	2	68.0212.0.300	3-79	31	2	68.0260.0.800	3-113	58	1
68.0183.1.800	3-121	53	1	68.0213.0.050	3-35	35	1	68.0260.0.800	3-117	41	1
68.0184.0.800	3-63	23	1	68.0214.0.800	3-55	12	1	68.0261.0.000	3-113	59	1
68.0184.0.800	3-121	54	1	68.0214.0.800	3-59	49	1	68.0261.0.000	3-117	42	1
68.0185.0.800	3-121	55	1	68.0216.0.800	3-79	32	2	68.0262.0.800	3-113	60	1
68.0186.0.600	3-121	56	1	68.0217.0.800	3-89	8	1	68.0262.0.800	3-117	43	1
68.0188.0.600	3-65	17	1	68.0218.0.800	3-79	33	1	68.0263.0.000	3-113	61	1
68.0188.0.600	3-67	17	1	68.0219.0.800	3-79	34	1	68.0263.0.000	3-117	44	1
68.0189.1.800	3-65	18	1	68.0220.1.800	3-83	1	1	68.0264.0.300	3-113	62	1
68.0189.1.800	3-67	18	1	68.0221.0.400	3-83	2	1	68.0264.0.300	3-117	45	1
68.0190.0.600	3-65	19	1	68.0222.0.100	3-57	35	15	68.0265.0.100	3-113	63	2
68.0190.0.600	3-67	19	1	68.0223.0.300	3-25	47	1	68.0265.0.100	3-117	46	2
68.0191.0.600	3-65	20	2	68.0224.0.600	3-69	9	1	68.0265.0.100	3-131	8	1
68.0191.0.600	3-67	20	2	68.0226.0.800	3-131	1	1	68.0266.0.000	3-113	64	1
68.0192.0.600	3-65	21	1	68.0227.0.000	3-131	2	1	68.0266.0.000	3-117	47	1
68.0192.0.600	3-67	21	1	68.0228.0.100	3-77	50	2	68.0267.0.800	3-113	65	1

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68.0268.0.800	3-113	66	1	68.0304.0.800	3-125	58	1	68.0352.0.300	3-141	47	1
68.0268.0.800	3-117	49	1	68.0305.0.800	3-125	59	1	68.0353.0.800	3-141	48	1
68.0269.0.000	3-113	67	1	68.0306.0.800	3-125	60	1	68.0354.0.800	3-91	16	1
68.0269.0.000	3-117	50	1	68.0307.0.300	3-125	61	2	68.0355.0.800	3-91	17	1
68.0270.0.993	3-113	68	1	68.0308.0.400	3-125	62	2	68.0356.1.300	3-91	18	1
68.0270.0.993	3-117	51	1	68.0309.0.300	3-127	7	(1)	68.0357.0.800	3-91	19	1
68.0271.0.000	3-113	69	1	68.0310.0.050	3-127	1	0	68.0359.0.300	3-113	83	1
68.0271.0.000	3-117	52	1	68.0310.0.800	3-127	8	(1)	68.0359.0.300	3-117	59	1
68.0272.0.800	3-113	70	1	68.0311.0.992	3-127	9	(1)	68.0360.0.000	3-129	37	1
68.0273.0.300	3-113	71	1	68.0312.0.400	3-127	10	(1)	68.0361.0.800	3-91	20	1
68.0273.0.300	3-117	53	1	68.0313.0.992	3-127	11	(1)	68.0362.0.800	3-129	38	1
68.0274.0.400	3-113	72	1	68.0314.0.000	3-133	21	1	68.0363.0.800	3-129	39	1
68.0275.0.300	3-113	73	1	68.0314.1.000	3-133	21*	1	68.0364.0.600	3-125	63	1
68.0275.0.300	3-117	54	1	68.0315.0.000	3-133	22	1	68.0365.0.800	3-129	40	1
68.0276.0.400	3-113	74	3	68.0315.1.000	3-133	22*	1	68.0366.0.300	3-129	41	1
68.0277.0.800	3-113	75	1	68.0318.0.050	3-133	23	1	68.0367.0.600	3-129	42	1
68.0277.0.800	3-117	55	1	68.0321.0.800	3-137	55	1	68.0368.0.300	3-129	43	1
68.0278.0.800	3-113	76	1	68.0322.0.800	3-137	56	1	68.0369.0.400	3-129	44	2
68.0279.0.300	3-113	77	1	68.0323.0.800	3-137	57	1	68.0370.0.300	3-129	45	1
68.0280.0.000	3-113	78	1	68.0324.0.600	3-137	58	1	68.0371.0.600	3-129	46	1
68.0281.0.300	3-113	79	1	68.0325.0.300	3-137	59	2	68.0372.0.500	3-129	47	1
68.0282.0.000	3-113	80	1	68.0326.0.800	3-137	60	1	68.0373.0.500	3-129	48	1
68.0282.0.000	3-117	56	1	68.0327.0.800	3-137	61	1	68.0374.0.400	3-97	7	6
68.0283.0.400	3-113	81	2	68.0328.0.800	3-137	62	1	68.0381.0.600	3-109	12	1
68.0283.0.400	3-117	57	2	68.0329.0.300	3-137	63	2	68.0382.0.800	3-109	13	1
68.0284.0.000	3-113	82	1	68.0330.0.800	3-137	64	1	68.0383.0.800	3-109	14	1
68.0284.0.000	3-117	58	1	68.0332.0.000	3-137	65	1	68.0384.0.300	3-109	15	1
68.0285.0.600	3-123	40	1	68.0333.0.300	3-137	66	1	68.0385.0.300	3-109	16	1
68.0286.0.600	3-123	41	2	68.0334.3.800	3-137	67	1	68.0386.0.300	3-117	60	1
68.0287.0.600	3-123	42	1	68.0335.0.800	3-137	68	1	68.0387.0.100	3-59	31	4
68.0288.0.300	3-123	43	2	68.0336.0.000	3-141	53	1	68.0388.0.300	3-117	61	1
68.0289.0.800	3-123	44	1	68.0337.0.800	3-139	33	1	68.0389.0.800	3-141	54	1
68.0290.0.800	3-123	45	1	68.0338.0.300	3-139	34	2	68.0390.0.800	3-121	67	1
68.0291.0.300	3-125	46	1	68.0339.0.800	3-139	35	1	68.0391.0.800	3-57	42	1
68.0292.0.800	3-125	47	1	68.0340.0.800	3-139	36	1	68.0392.0.800	3-77	57	1
68.0293.0.800	3-125	48	1	68.0341.0.600	3-139	37	1	68.0393.0.600	3-143	7	1
68.0294.0.800	3-125	49	1	68.0342.0.300	3-139	38	1	68.0394.0.800	3-143	8	1
68.0295.0.600	3-125	50	1	68.0343.0.600	3-139	39	1	68.0395.0.800	3-143	9	1
68.0296.0.800	3-125	51	1	68.0344.0.300	3-139	40	1	68.0396.0.800	3-143	10	1
68.0297.0.300	3-125	52	2	68.0345.0.300	3-139	41	1	68.0397.0.800	3-143	11	1
68.0298.0.300	3-125	53	1	68.0346.0.000	3-139	42	1	68.0399.0.400	3-129	49	1
68.0300.0.000	3-125	54	1	68.0348.0.300	3-139	43	1	68.0401.0.800	3-141	49	1
68.0301.0.500	3-125	55	1	68.0349.0.300	3-139	44	1	68.0402.0.600	3-137	69	1
68.0302.0.500	3-125	56	1	68.0350.0.600	3-139	45	1	68.0403.0.600	3-137	70	1

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68.0409.0.400	3-117	62	1	68.9905.0.812	3-101	0	0	68.9908.0.020	3-102	0	0
68.0410.0.050	3-61	12	1	68.9905.0.814	3-101	0	0	68.9908.0.028	3-102	0	0
68.6001.0.800	3-79	35	1	68.9905.0.814	3-101	0	0	68.9909.0.814	3-103	0	0
68.7001.0.050	3-79	36	1	68.9905.0.816	3-101	0	0	68.9909.0.818	3-103	0	0
68.7002.0.050	3-79	37	1	68.9905.0.816	3-101	0	0	68.9909.0.824	3-103	0	0
68.9026.0.050	3-45	26	1	68.9905.0.818	3-101	0	0	68.9909.0.828	3-103	0	0
68.9031.0.050	3-63	26	1	68.9905.0.818	3-101	0	0	68.9910.0.814	3-103	0	0
68.9031.0.050	3-73	34	3	68.9905.0.820	3-101	0	0	68.9910.0.818	3-103	0	0
68.9031.0.050	3-121	63	1	68.9905.0.820	3-101	0	0	68.9910.0.824	3-103	0	0
68.9032.0.050	3-63	27	1	68.9905.0.828	3-101	0	0	68.9910.0.828	3-103	0	0
68.9032.0.050	3-73	35	3	68.9905.0.828	3-101	0	0	68.9911.0.807	3-103	0	0
68.9032.0.050	3-121	64	1	68.9906.0.007	3-101	0	0	68.9911.0.810	3-103	0	0
68.9037.0.050	3-145	1	1	68.9906.0.008	3-101	0	0	68.9911.0.812	3-103	0	0
68.9901.0.607	3-98	0	0	68.9906.0.010	3-101	0	0	68.9911.0.814	3-103	0	0
68.9901.0.608	3-98	0	0	68.9906.0.012	3-101	0	0	68.9911.0.816	3-103	0	0
68.9901.0.610	3-98	0	0	68.9906.0.014	3-101	0	0	68.9911.0.818	3-103	0	0
68.9901.0.612	3-98	0	0	68.9906.0.016	3-101	0	0	68.9911.0.820	3-103	0	0
68.9901.0.614	3-98	0	0	68.9906.0.018	3-101	0	0	68.9911.0.828	3-103	0	0
68.9901.0.616	3-98	0	0	68.9906.0.020	3-101	0	0	68.9912.0.807	3-103	0	0
68.9901.0.618	3-98	0	0	68.9906.0.028	3-101	0	0	68.9912.0.810	3-103	0	0
68.9901.0.620	3-98	0	0	68.9907.0.807	3-102	0	0	68.9912.0.818	3-103	0	0
68.9901.0.628	3-98	0	0	68.9907.0.807	3-102	0	0	68.9912.0.828	3-103	0	0
68.9902.0.607	3-99	0	0	68.9907.0.808	3-102	0	0	68.9914.0.607	3-104	0	0
68.9902.0.608	3-99	0	0	68.9907.0.808	3-102	0	0	68.9914.0.608	3-104	0	0
68.9902.0.610	3-99	0	0	68.9907.0.810	3-102	0	0	68.9914.0.610	3-104	0	0
68.9902.0.612	3-99	0	0	68.9907.0.810	3-102	0	0	68.9914.0.612	3-104	0	0
68.9902.0.614	3-99	0	0	68.9907.0.812	3-102	0	0	68.9914.0.614	3-104	0	0
68.9902.0.616	3-99	0	0	68.9907.0.812	3-102	0	0	68.9914.0.616	3-104	0	0
68.9902.0.618	3-99	0	0	68.9907.0.814	3-102	0	0	68.9914.0.618	3-104	0	0
68.9902.0.620	3-99	0	0	68.9907.0.814	3-102	0	0	68.9914.0.620	3-104	0	0
68.9902.0.628	3-99	0	0	68.9907.0.816	3-102	0	0	68.9915.0.607	3-105	0	0
68.9903.0.808	3-100	0	0	68.9907.0.816	3-102	0	0	68.9915.0.608	3-105	0	0
68.9903.0.814	3-100	0	0	68.9907.0.818	3-102	0	0	68.9915.0.610	3-105	0	0
68.9903.0.820	3-100	0	0	68.9907.0.818	3-102	0	0	68.9915.0.612	3-105	0	0
68.9903.0.828	3-100	0	0	68.9907.0.820	3-102	0	0	68.9915.0.614	3-105	0	0
68.9904.0.808	3-100	0	0	68.9907.0.820	3-102	0	0	68.9915.0.616	3-105	0	0
68.9904.0.814	3-100	0	0	68.9907.0.828	3-102	0	0	68.9915.0.618	3-105	0	0
68.9904.0.820	3-100	0	0	68.9907.0.828	3-102	0	0	68.9915.0.620	3-105	0	0
68.9905.0.807	3-101	0	0	68.9908.0.007	3-102	0	0	69.0010.0.004	3-33	28	1
68.9905.0.807	3-101	0	0	68.9908.0.008	3-102	0	0	69.0052.0.000	3-31	40	1
68.9905.0.808	3-101	0	0	68.9908.0.010	3-102	0	0	69.0052.0.000	3-97	12	1
68.9905.0.808	3-101	0	0	68.9908.0.012	3-102	0	0	69.0052.1.014	3-103	0	0
68.9905.0.810	3-101	0	0	68.9908.0.014	3-102	0	0	69.0052.1.014	3-105	0	0
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69.0052.1.026	3-105	0	0	S38274001	3-25	32	(1)	SA2493001	3-7	34	2
69.0052.1.032	3-103	0	0	S38398001	3-5	5	1	SA2494001	3-7	35	1
69.9904.0.828	3-100	0	0	S38422001	3-9	19	1	SA2511001	3-9	2	(2)
73.0084.0.800	3-121	65	1	S38481000	3-19	2	1	SA2512001	3-9	4	(1)
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S01928151	3-13	44	2	S39830101	3-9	27	1	SA2518001	3-9	11	1
S01928151	3-15	44	2	S48367000	3-9	41	2	SA2521001	3-9	14	1
S05246000	3-21	29	2	S50098101	3-9	24	1	SA2523001	3-9	26	1
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S07419001	3-13	6	(1)	SA1360001	3-27	26	1	SA2527001	3-9	31	1
S07419001	3-15	6	(1)	SA1668111	3-17	1	1	SA2528101	3-9	33	1
S07420000	3-13	5	(1)	SA1971101	3-27	1	1	SA2529101	3-9	34	1
S07420000	3-15	5	(1)	SA1975001	3-27	3	(1)	SA2530001	3-9	37	1
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S09260001	3-15	4	(1)	SA1983001	3-27	12	((1))	SA2544001	3-11	6	1
S09261001	3-13	4	(1)	SA1984001	3-27	16	(1)	SA2546001	3-11	8	2
S09261001	3-15	4	(1)	SA1985001	3-27	18	(1)	SA2550001	3-11	25	1
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S23651001	3-11	9	4	SA2190001	3-27	24	(1)	SA2556001	3-15	39	2
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S25236001	3-9	13	1	SA2445001	3-3	8	1	SA2560001	3-15	10	(1)
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SA2574001	3-13	24	((3))	SA2720001	3-5	22	1	SA3065001	3-5	30	1
SA2574001	3-15	20	((2))	SA2722001	3-13	33	2	SA3067001	3-9	40	1
SA2574001	3-15	23	((3))	SA2722001	3-15	37	2	SA3147001	3-21	22	1
SA2575001	3-13	22	((1))	SA2723001	3-21	16	1	SA3147001	3-21	26	1
SA2575001	3-15	21	((1))	SA2724001	3-11	35	1	SA3147001	3-21	35	2
SA2575001	3-19	7	(1)	SA2724001	3-21	17	1	SA3415001	3-25	2	(2)
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SA2605001	3-23	50	1	SA2928001	3-11	29	2	SA3886001	3-11	12	1
SA2606101	3-23	54	1	SA2929001	3-3	12	1	SA3887001	3-11	21	1
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SA4038001	3-15	4	(1)								
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