



MODEL S-4000 BH Omron

STRAIGHT BUTTONHOLE MACHINE WITH CHAIN STITCH

PARTS AND SERVICE MANUAL

MACHINE SERIAL No:

PART NUMBER **97.2403.2.001**



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:

AMF Reece - Cars s.r.o.
Tovární 837/9c
798 11 Prostejov
Czech Republic
e-mail: info@amfreece-cars.cz

TABLE OF CONTENTS

A - INTRODUCTION

1. BASIC INFORMATION	1-1
2. SAFETY DEVICE AND LABELS	1-2
3. GENERAL MACHINE PARTS DESCRIPTIONS	1-3
4. SPECIFICATIONS.....	1-4
5. TABLE TYPE	1-5
6. INSTRUCTIONS FOR OPERATOR SAFETY AND MAINTENANCE.....	1-6
7. SPECIAL ACCESSORIES.....	1-7

B - MACHINE INSTALLATION

1. CONTENT OF THE SHIPPING BOX.....	1-9
2. ACCESSORIES.....	1-9
3. POWER AND AIR CONNECTION	1-11
4. THREAD STAND INSTALLATION	1-13

C - PROPER APPLICATION

1. POWER UP / HOME POSITION	1-14
2. NEEDLE INSTALLATION	1-15
3. THREADING.....	1-16

D - MACHINE CONTROLS

1. PROGRESS OF SEWING.....	1-17
2. OPERATOR CONTROL PANEL PUSH BUTTONS AND SWITCHES	1-19
3. THE PROGRAMING MENU STITCHING HEAD	1-20
4. TESTS.....	1-22
5. PROGRAM VERSION	1-23
6. COUNTER RESET.....	1-23
7. PARAMETER CHECKLIST	1-24

E - MACHINE ADJUSTMENTS

1. MACHINE HOME POSITION	1-25
2. THE MAIN CAM ADJUSTMENT	1-26
3. THE PRINCIPLES FOR THE MACHINE ADJUSTMENT.....	1-26
4. NEEDLE BAR	1-27
5. BITE.....	1-28
6. FEEDING	1-30
7. SLIP CLUTCH	1-31
8. STITCH DENSITY.....	1-31
9. LOOPER ADJUSTMENT	1-32
10. THE BARRING STITCHES ADJUSTMENT	1-35
11. THE CLAMP PLATE HOME POSITION	1-36
12. THE CUTTING SPACE SETTING.....	1-37
13. THREAD DRAW - OFF	1-38
14. THREAD TENSION.....	1-39
15. KNIFE AND THE BUTTONHOLE LENGTH ADJUSTMENTS.....	1-42
16. THREAD TRIMMING	1-44
17. MACHINE HEAD CLAMP FEET ADJUSTMENT	1-45
18. ADJUSTMENT OF THE STOPPING SENSOR POSITION	1-46
19. CHANGING THE DRIVE BELT	1-47

TABLE OF CONTENTS

F - MAINTENANCE

1. MACHINE CLEANING AND MAINTENANCE.....	1-48
2. PERIODIC MAINTENANCE.....	1-50
3. LUBRICATION DIAGRAM.....	1-51
4. MACHINE LUBRICATION.....	1-52
5. MACHINE DISPOSAL.....	1-54

G - PNEUMATIC DIAGRAM

H - ELECTRICAL DIAGRAM

A - INTRODUCTION

1. BASIC INFORMATION

The sewing machine S-4000 BH is designed and produced to be very reliable. Important design goals have been to provide a safe machine that is simple and inexpensive to maintain.

The patented rotary needle bar shaft drive, a major benefit, delivers longer needle bar life. The added benefits of lower vibration and less noise, translate into less operator fatigue.

Simple buttonhole length adjustment located outside the machine, eliminates the need for tilt back, while the quick stop repair function delivers safety and makes repairs easier.

A halogen work light is included with the S-4000 BH, to enhance operator safety and product quality.

Special electronic and mechanical safety devices protect the operator and the machine. There is a special power lock out switch that permits the machine to be locked in the off position, so that it cannot be cycled accidentally. There is an emergency off switch. There is a low air pressure detector that will not permit machine operation if air pressure is dangerously low.

There are safety-warning labels on the machine in all areas that require special care. These must not be removed. If they are lost replace them immediately.

You are the most important safety equipment of all. Be sure you understand the proper operation of the machine. Never remove safety mechanisms or labels. We have made every effort to provide the safest possible machine, but without complete knowledge of how this machine operates, and the use of proper care by the operator, this machine can cause serious injury or death. That is why there are safety warnings throughout these instructions that carry one of these messages.

DANGER! Possible loss of life.

WARNING! Possible serious injury or machine damage.

NOTICE! Possible injury or machine damage.

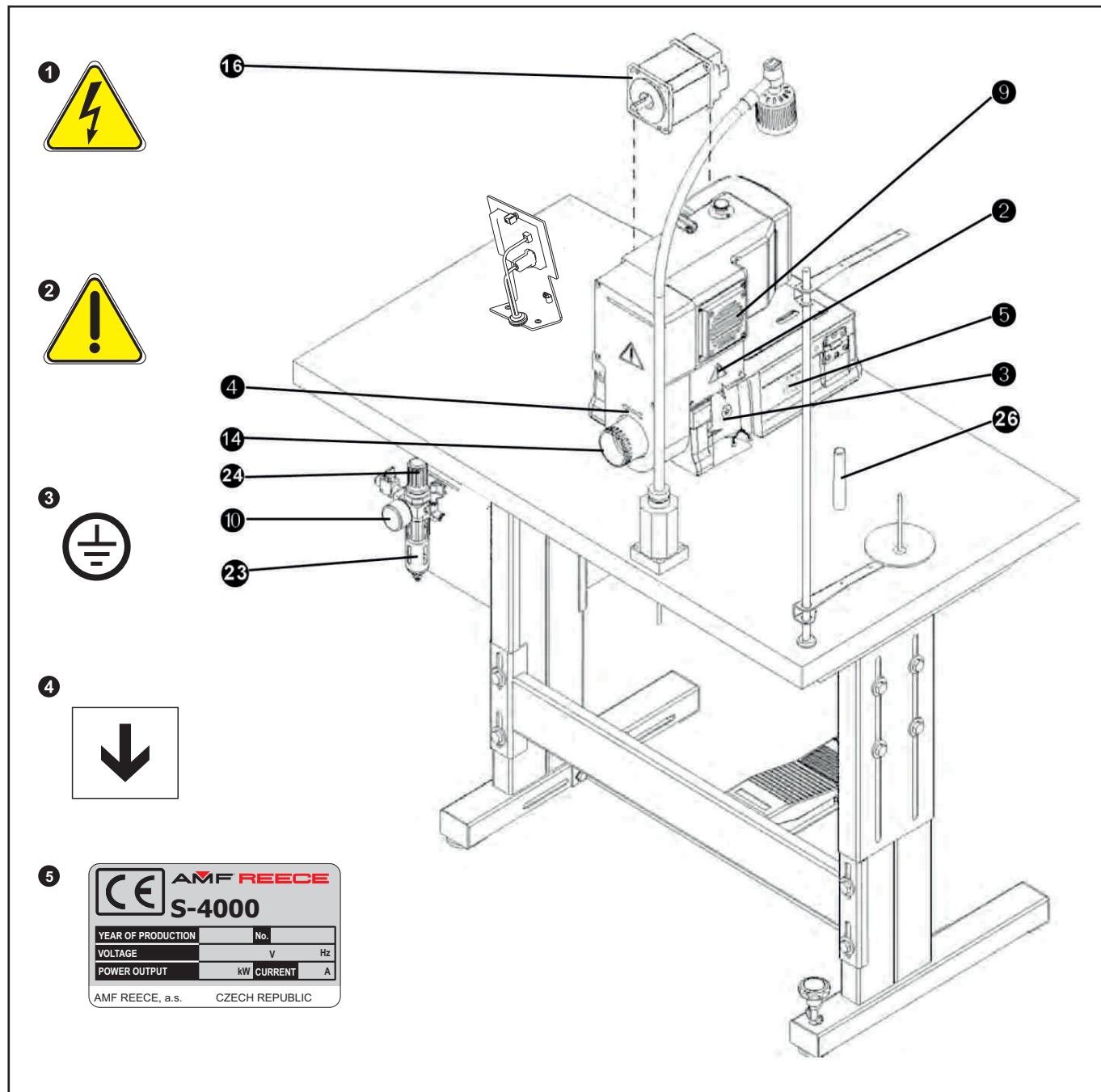
We recommend that service workers from AMF Reece oversee the installation and initial training of your mechanics and operators.

The most effective safety precaution is a well-managed safety program. Be sure those who use this machine are properly trained. Never disable safety equipment.

Always wear safety goggles when operating or servicing the machine.

A - INTRODUCTION

2. SAFETY DEVICE AND LABELS

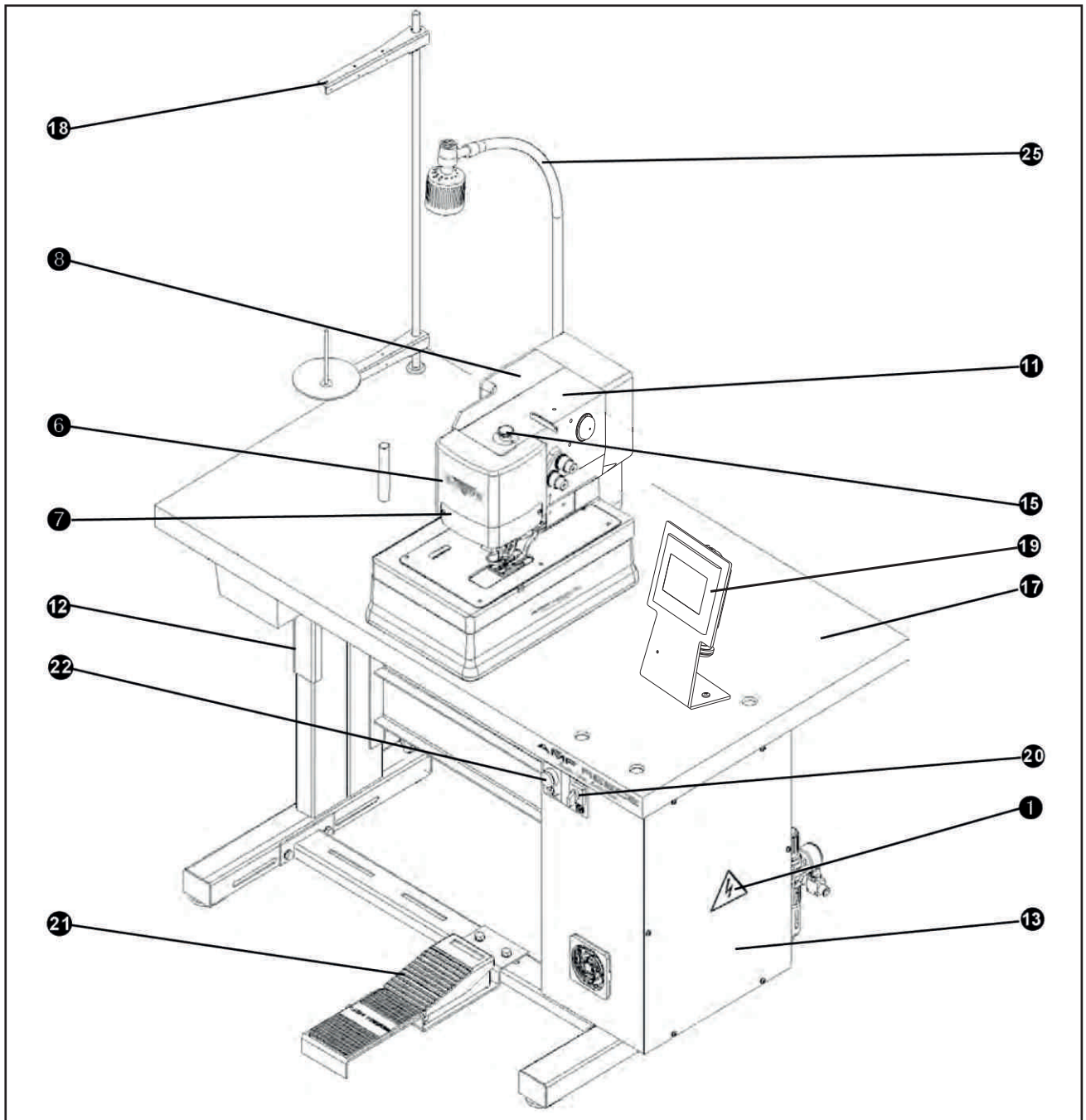


- 1 Warning
- 2 Covers removed, possible injury
- 3 Grounding
- 4 Rotational direction
- 5 Standard Label
- 6 Needle bar cover

- 7 Eye guard
- 8 Head cover
- 9 Fan cover
- 10 Manometer with pressure sensor
- 11 Machine head
- 12 Table Frame

A - INTRODUCTION

3. GENERAL MACHINE PARTS DESCRIPTIONS



- | | |
|--------------------------|---------------------------------|
| 13 Control box | 20 Main switch |
| 14 Hand wheel | 21 Foot pedal |
| 15 Emergency Stop Button | 22 Clamps Up/Down button |
| 16 Motor | 23 Air pressure regulator |
| 17 Table Top | 24 Air pressure adjustment knob |
| 18 Thread Stand | 25 Halogen Lamp |
| 19 Control Panel | 26 Rest Pin |

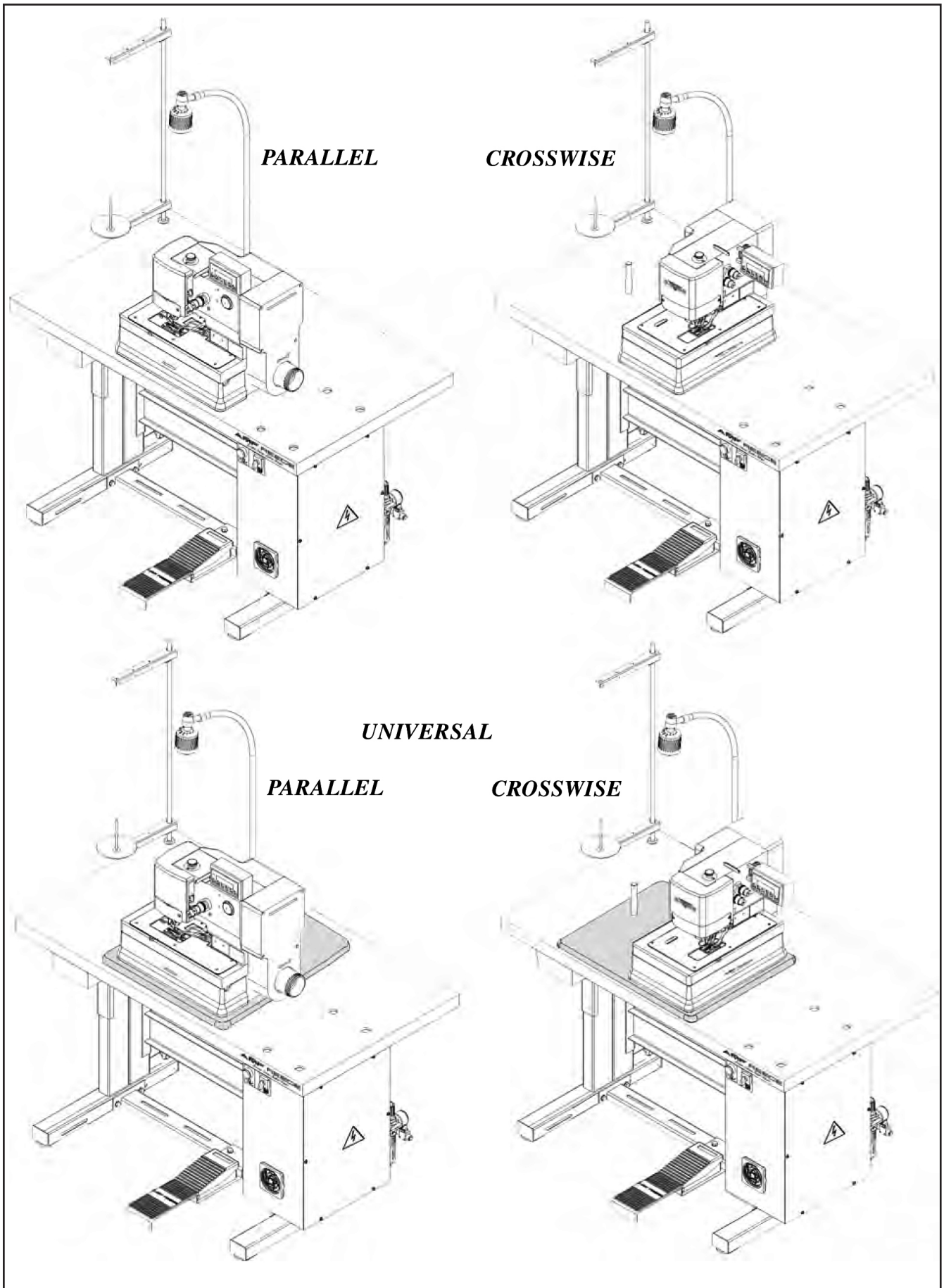
A - INTRODUCTION

4. SPECIFICATIONS

Machine type	S - 4000 BH													
Description	Electronic controlled chain stitch straight buttonhole machine for sewing the buttonholes													
Sewing Speed	1500-3800 stitches/min													
Buttonhole Length	6.3 - 35 mm (1/4" - 1 3/8")													
Knife Sizes Available	Milimeters:	6	10	11	13	14	16	19	22	25	29	32	35	
	Inches:	1/4"	3/8"	7/16"	1/2"	9/16"	5/8"	3/4"	7/8"	1"	1 1/8"	1 1/4"	1 3/8"	
Stitch Density	4 - 12 stitches/cm (10 - 30 spi)													
Type of a buttonhole	single thread chain stitch with center cutting													
Machine clamp foot height	12.7 mm (1/2")													
Maximum work thickness	to 3 mm (5/32")													
Bite range	1.7 - 2.3													
Cutting space	0 - 0.9 mm													
Recommended thread	thread size 80, 100, 120 (Tex size 40-60)													
Needle System	Needle 750 SC 90/14 (it is possible to order 80/12)													
Lubrication	semi-automatic													
Operating Conditions	according to IEC 364-3, IEC 364-5-51 temperature from +5`C to 40`C, relative air humidity from 30 to 80 %													
Air pressure	0.55 MPa (80 PSI)													
Machine db Level	Laeg = 74dB; LWA = 87dB; LpC, peak = 103dB													
Machine head dimension	340 mm (height) x 470 (width) x 250 mm (length)													
Machine head weight	62 kg													
Table dimension	700 mm (height) x 600 mm (width) x 1100 mm (length)													
Table Type	Parallel, Crosswise or Universal													
Electrical Requirements	1N+PE-60Hz 230V/TN-S (according to EN 60204-1)													
	1N+PE-50Hz 230V/TN-S (according to EN 60204-1)													
Line Circuit Breaker	10A characteristic C (according to EN 60947-2)													
	16A characteristic B (according to EN 60947-2)													

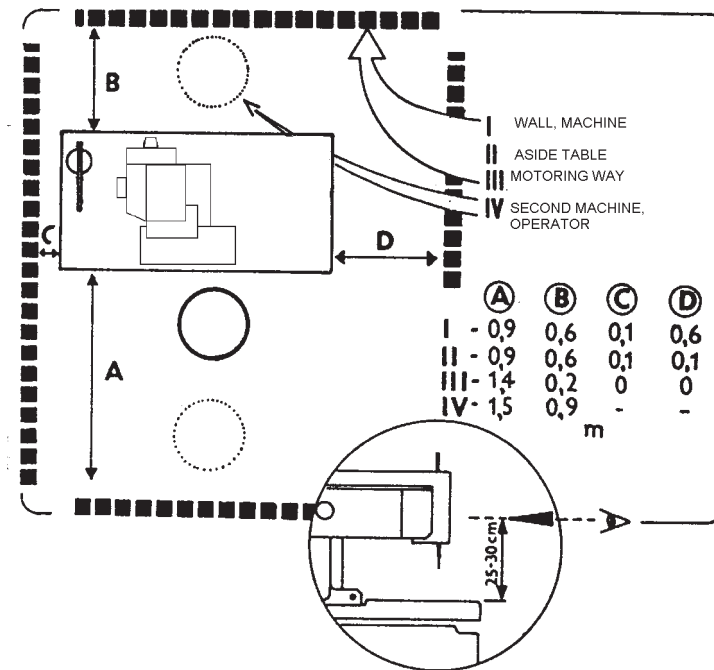
A - INTRODUCTION

5. TABLE TYPE



A - INTRODUCTION

6. INSTRUCTIONS FOR OPERATOR SAFETY AND MAINTENANCE



When installing the machine we recommend the minimum clearances noted above around the machine. Read all of the instructions that follow. **DO NOT PUT THE MACHINE INTO OPERATION UNTIL YOU ARE COMPLETELY FAMILIAR WITH ALL INSTALLATION AND OPERATING INSTRUCTIONS.**

DANGER!

- Before connecting the machine to the power supply, be positive that all safety covers are correctly installed.
- Always engage the power lockout switch, or disconnect the main power supply, before removing any safety covers.

WARNING!

- Locate the Emergency Stop button. Be sure you know how to use it.
 - Be sure that you have a reliable and uniform power supply.
 - Be sure that all electrical supply lines are in good condition and have no signs of damage to avoid electrical shock.
 - If any covers become damaged, they must be repaired or replaced immediately.
 - Do not touch moving parts of the machine while it is operating.
 - Keep clear of the needle.
 - Always switch off the main power before changing the needle.
 - Before cleaning the machine or performing service to the machine, engage the power lock out switch or disconnect the main power supply.
 - When the machine is not in use engage the power lock out switch or disconnect the main power supply.
 - When this machine is used incorrectly, or is incorrectly maintained, it can be dangerous.
- Everyone who uses this machine, or maintains this machine, must be completely familiar with this manual.

A - INTRODUCTION

CAUTION!

- Perform all regular service as described by this manual.
- If there is any problem with the power supply, turn off the main power switch.
- Do not remove, paint over, damage or in any way change safety labels. If a safety label cannot be easily read, replace it.
- Long hair and loose clothing may be dangerous near any machinery. Always contain long hair and avoid loose clothing, so that it cannot be caught by machinery and cause injury.
- Never use this machine while under the influence of drugs or alcohol.
- If anything seems to be operating incorrectly in the machine call for maintenance assistance immediately.
- Be sure that there is adequate light for safe operation. A normal minimum light level is 750 lux.

7. SPECIAL ACCESSORIES

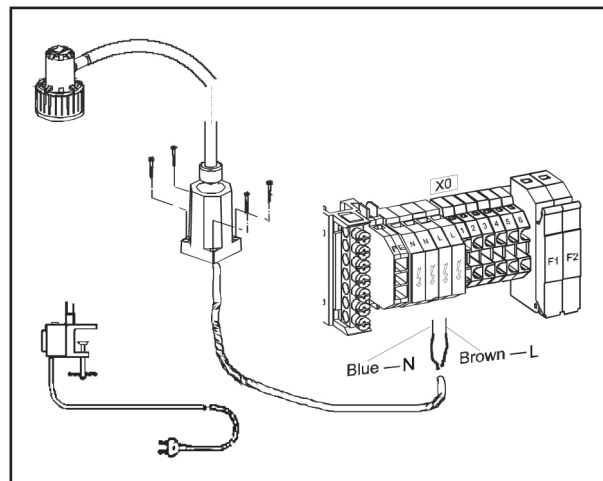
- machine device, which is not included in the standard equipment of the machine and can be ordered by the customer

Light

- customer can order - no. 12.0008.4.403
- connection according to chart (terminal connectors X0; cable clamps N, L)

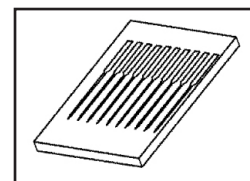
Warning: When turning on the light on the machine, disconnect the machine from the power supply.

- in case, you do not want to interfere into the machine wiring, it is possible to order the work light LBH-T65, order no. 12.0008.4.875, which contains its own clip fork for the table and supply conductor with fork (plug) CEE7 for connection to the power supply ~ 230 V.



Needles 750 SC 80/12, 70/10

- the manufacturer recommends to use these needles when sewing thin material
- order number 02.0750.2.100 (80/12), 02.0750.2.109 (70/10)



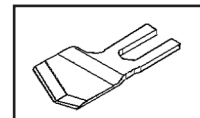
A - INTRODUCTION

Knives

- in addition to the commonly supplied knives it is possible to order the following knives according to the length of cutting

23.2356.2.050 - 3/8" - 10 mm
 23.2356.2.051 - 7/16" - 11 mm
 23.2356.2.053 - 9/16" - 14 mm
 23.2356.2.056 - 7/8" - 22 mm

23.2356.2.057 - 1" - 25 mm
 23.2356.2.058 - 1 1/8" - 29 mm
 23.2356.2.059 - 1 1/4" - 32 mm
 23.2356.2.060 - 1 3/8" - 35 mm



Connector Ø 8 ①

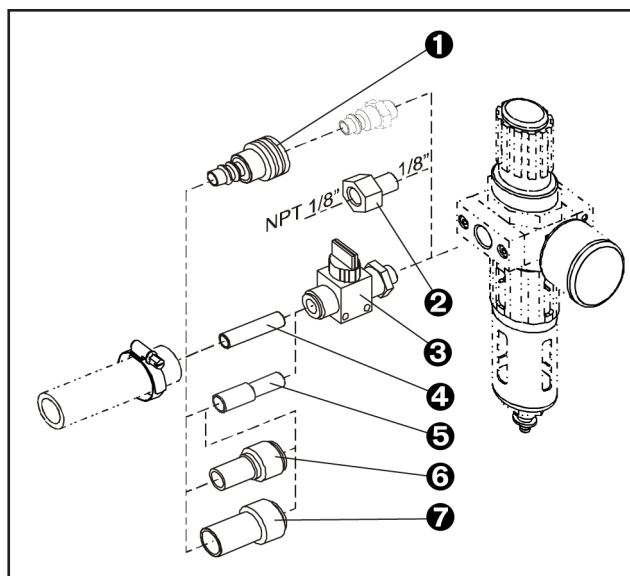
- order it if the connecting tube has the inner diameter 8 mm. The connector Ø 10 is supplied with the machine.
- part number is 12.0008.3.607

Pneumatic Adapter ②

- order it if using 1/8" NPT
- part number 12.0008.3.081

Hand valve ③

- to dissipate any air from the machine, order it (air circuit is bled). It is necessary to order the connectors (see below) to the hand valve for connection to the air tubes.
- part number 12.0008.3.463



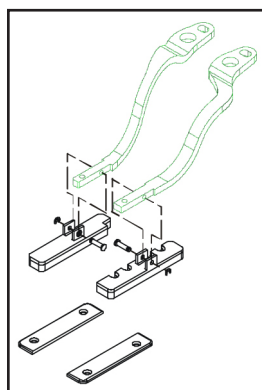
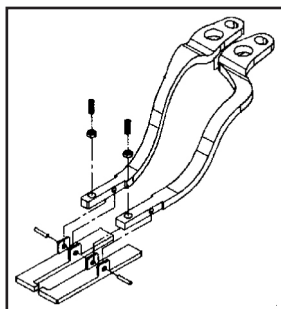
Connectors

- ④ 12.0008.3.464 Ø 8 for connection to the tube with inner Ø 8 mm
- ⑤ 12.0008.3.466 Ø 10 for connection to the tube with inner Ø 10 mm
- ⑥ 12.0008.3.467 Ø 12 for connection to the tube with inner Ø 12 mm*
- ⑦ 12.0008.3.465 Ø 16 for connection to the tube with inner Ø 16 mm*

* To connect the tube with inner Ø 12 and Ø 16, it is also necessary to order Ø 10

Short clamping kit

- for sewing the short buttonholes to 1" (25,4mm)
- part number: 24.9920.9.990



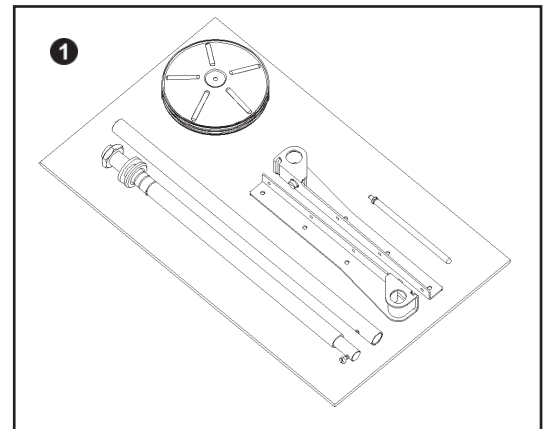
- used for sewing of lycra materials and knitwear
- part number: 24.9920.9.988

B - MACHINE INSTALLATION

1. CONTENT OF THE SHIPPING BOX

1. The shipment contains one box.
2. There is a carton with accessories, service manual with parts section and thread stand ❶ in the box.
3. During unpacking the shipment, follow the labels which are on a cover.

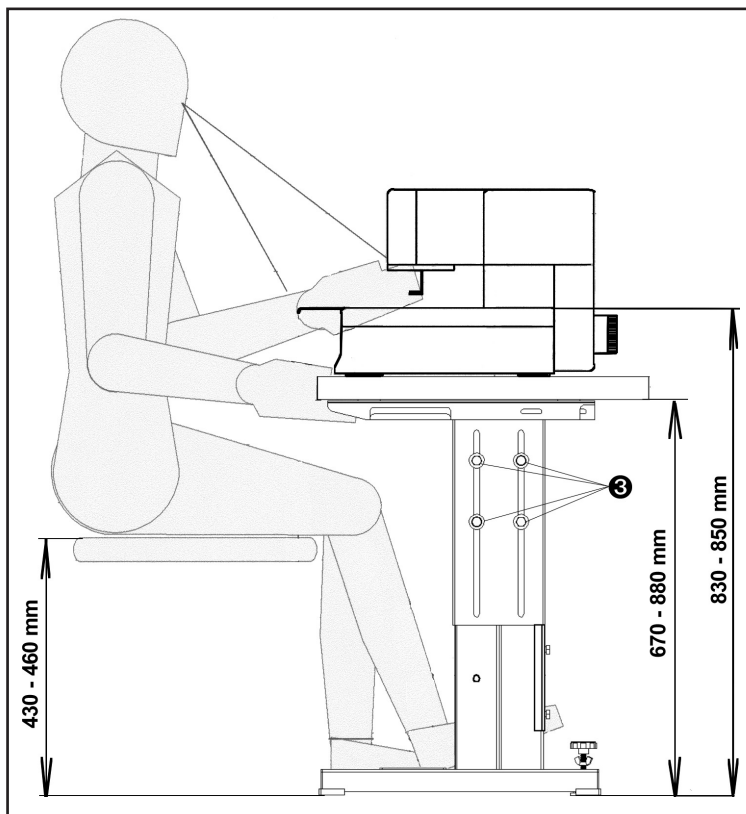
CAUTION: If the machine or crate was damaged in shipment inform the freight company immediately. Check the contents of the crate immediately and report any damage or missing items to the manufacturer immediately, late reports will not be considered.



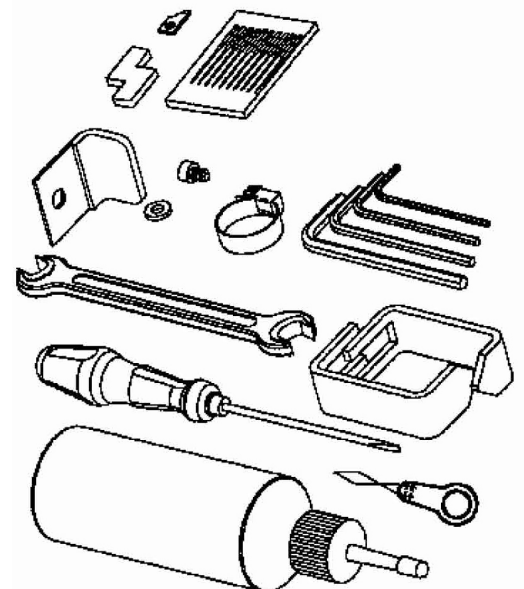
2. ACCESSORIES

A package of accessories is supplied with this machine, please refer to page 3-48 for detailed descriptions.

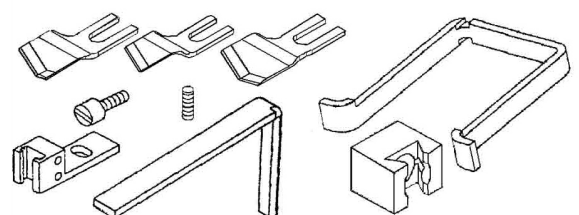
The height of the working area is standardly set in range 830 - 850 mm from the manufacturer. When using this height of the working area, recommended height of the operator seat is in range 430 - 460 mm. The height of the table can be set in range 670 - 880 mm by screws ❸.



STANDARD ACCESSORIES



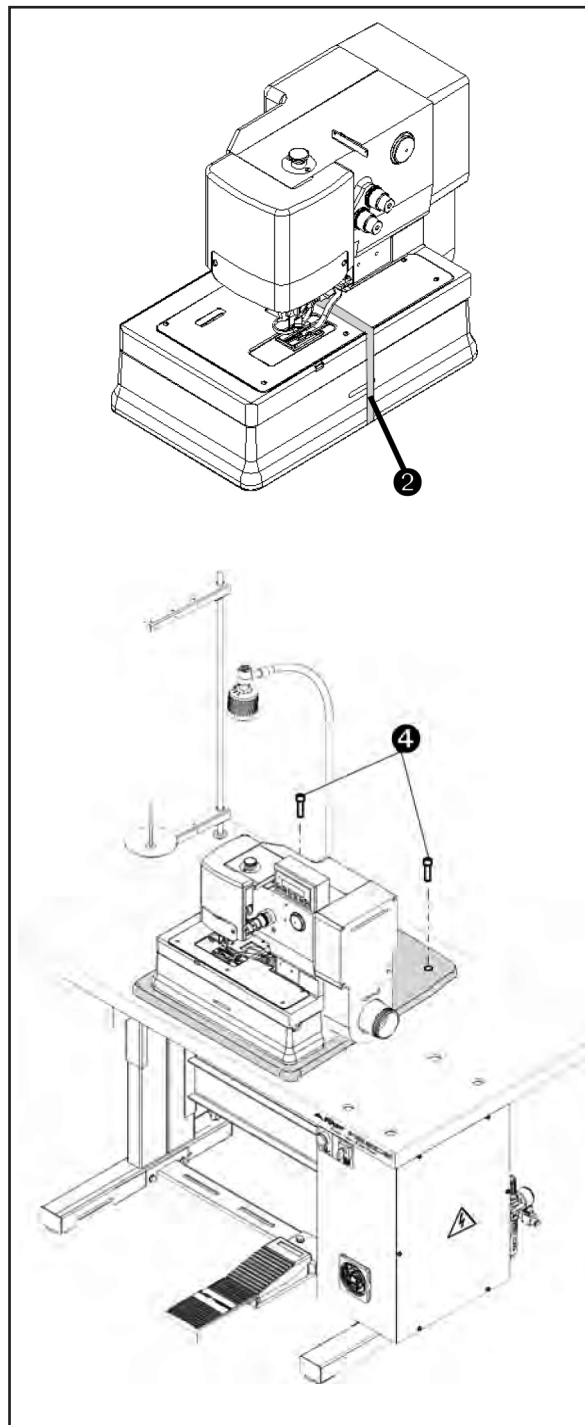
ACCESSORIES BH



B - MACHINE INSTALLATION

Remove the shipping strap ② after unpacking the machine, the use of this strap is recommended anytime the machine is transported (This is valid for all types of tables - parallel, crosswise, universal).

If a customer has ordered the *universal table*, and requires to change the parallel table to the crosswise table, it is necessary to remove 2 locking screws ④ and turn the machine head to the required position. It is also possible to change the display position.



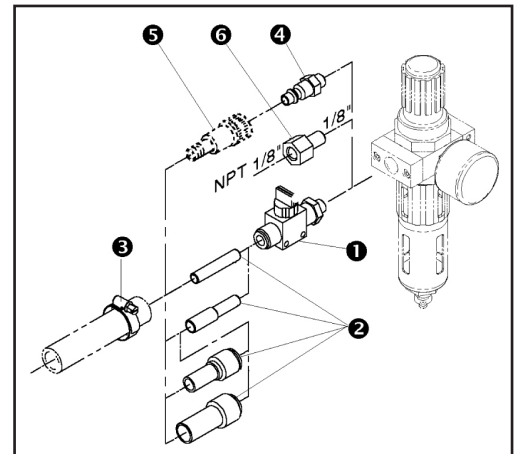
B - MACHINE INSTALLATION

3. POWER AND AIR CONNECTION

1. The machine is equipped with a quick coupler **4** required with connector **5** for inner Ø of the tube 10.

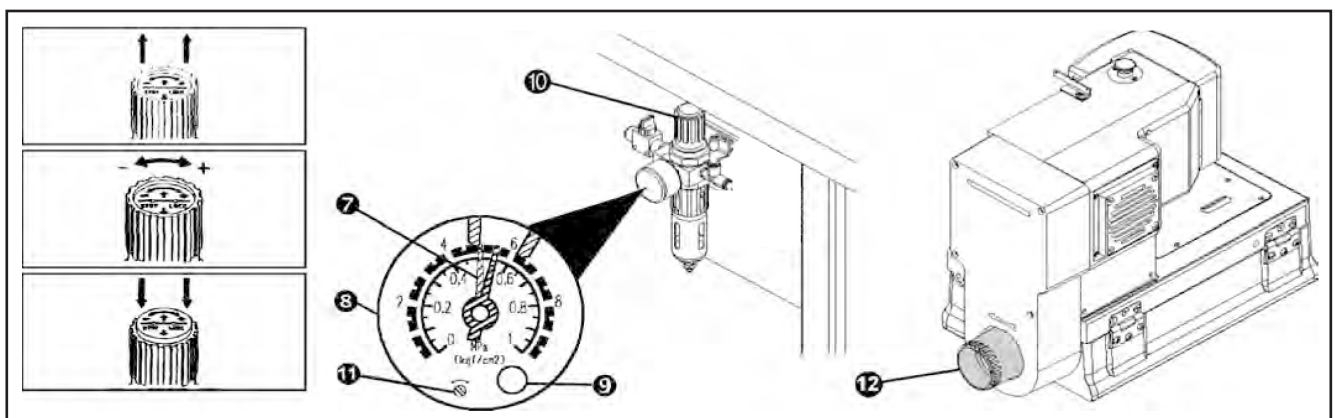
The connector for inner Ø of the tube 8 is not supplied with the machine, a customer has to order it. The manufacturer recommends to use connector **6** for customers who requires to connect the tube with connector NPT. If a customer needs to use a shut off valve **1**, which allows fast releasing of the air from the circuit, he must order it. A variety of connectors **2** can be used separately or in combination to adapt to the available input supply hose. It depends on type of the tube which is used by a customer.

These connectors are not included in the accessories. A tubing clamp **3** is provided.



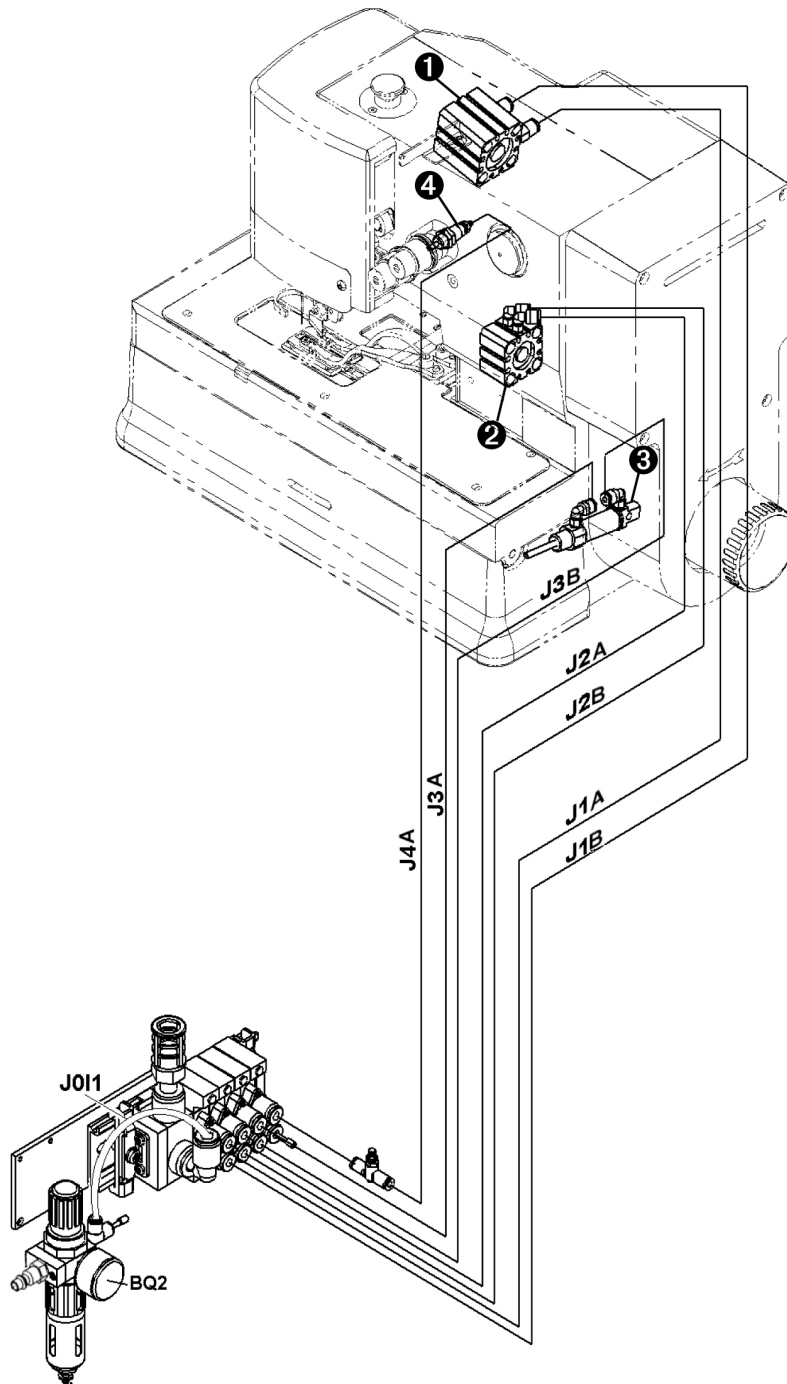
NOTE: Parts **1**, **2**, **5**, **6** are included in **Extra Parts**.

- After air connection check the set air pressure on the dial of the regulator. It should be in range 0.5 - 0.6 MPa. The green pointer **7** indicates the lowest working air pressure 0.5 MPa, which is set from the manufacturer on the regulator **8**. If the air pressure is lower than 0.5 Mpa after connecting the machine to the power supply, the red LED **9** lights up on the regulator and „Low Pressure“ message appears on the control panel display. To adjust the working pressure, loosen the regulator cap lock **10** and turn the regulator cap clockwise to increase the pressure. Push the regulator cap **10** down. The LED **11** is for setting the minimal operation air pressure.
- Power supply must be 208 to 230 volts 1 phase, 50 or 60 hertz. Receptacle plug must meet requirements of IEC standard 364-4-41, its circuit breaker must be minimal 10A with characteristic C according to the EN 60947-2 (or 16A with characteristic B). No other devices must not be connected to the circuit breaker of the socket. The hand wheel **12** must turn counter clockwise. The machine is equipped with a filters which contain capacitors which generate an high frequency leakage current. In order to prevent nuisance tripping, residual current protection device must be protected against these high frequency currents: this is the case for industrial residual current device (example „S“ type).



B - MACHINE INSTALLATION

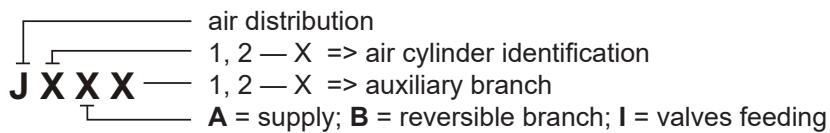
4. Head pneumatics



- ① - thread draw - off, cutting
- ② - clamp feet
- ③ - thread trimming
- ④ - tension release

J011 - air input
BQ2 - regulator with air pressure switch

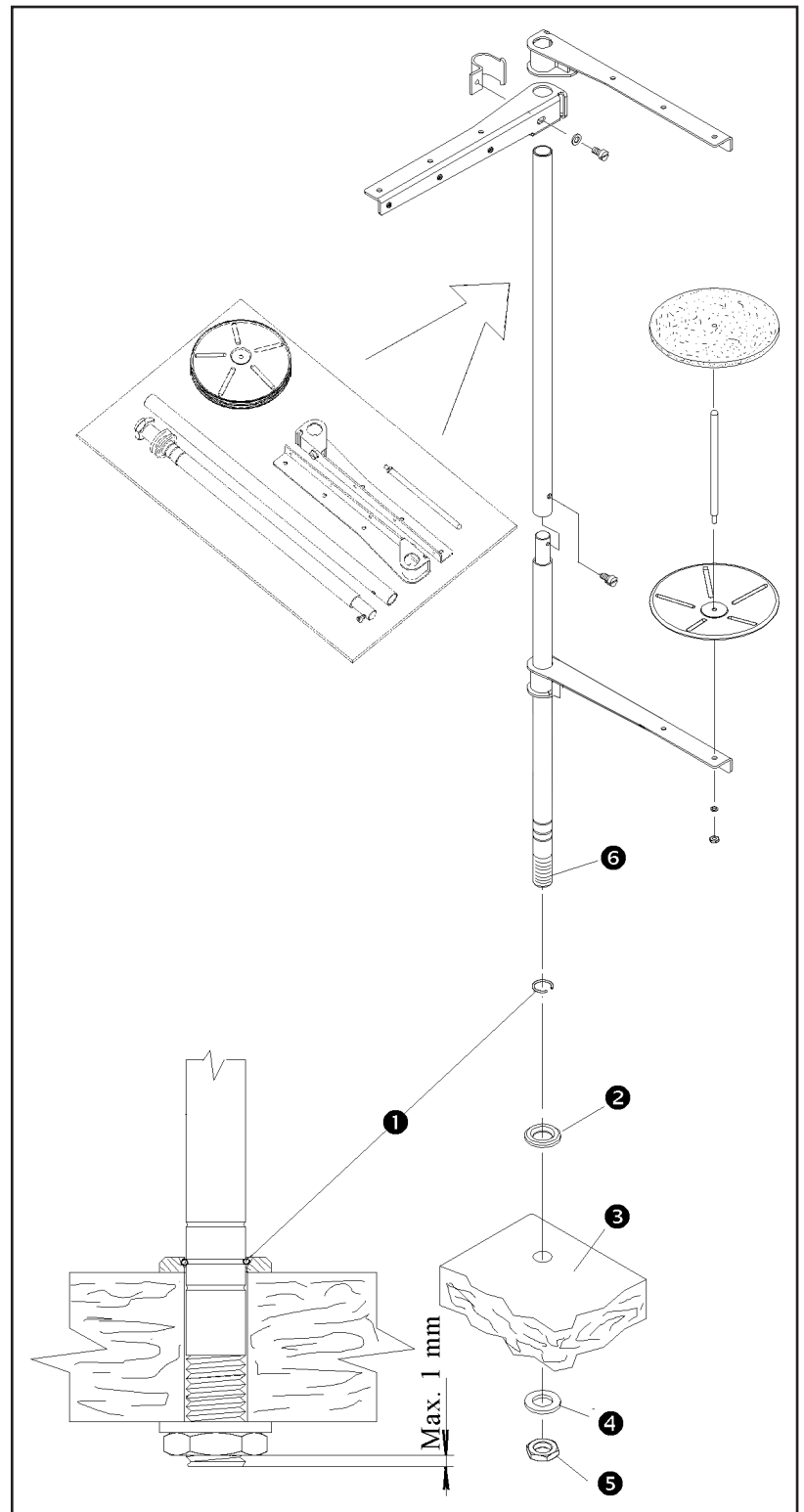
Tubes identification



B - MACHINE INSTALLATION


4. THREAD STAND INSTALLATION

1. Put the thread stand together according to the drawing.
2. Position of the locking ring **1** allows assembly of the thread stand for various thickness of the table top. Threaded end of the post **6** must not extend more that 1 mm (1/32) through the locking nut **5**.
3. Insert the washer **2** and the post into the hole provided in the right rear of the table top **3**. Insert the washer **4** and tighten the nut **5**.

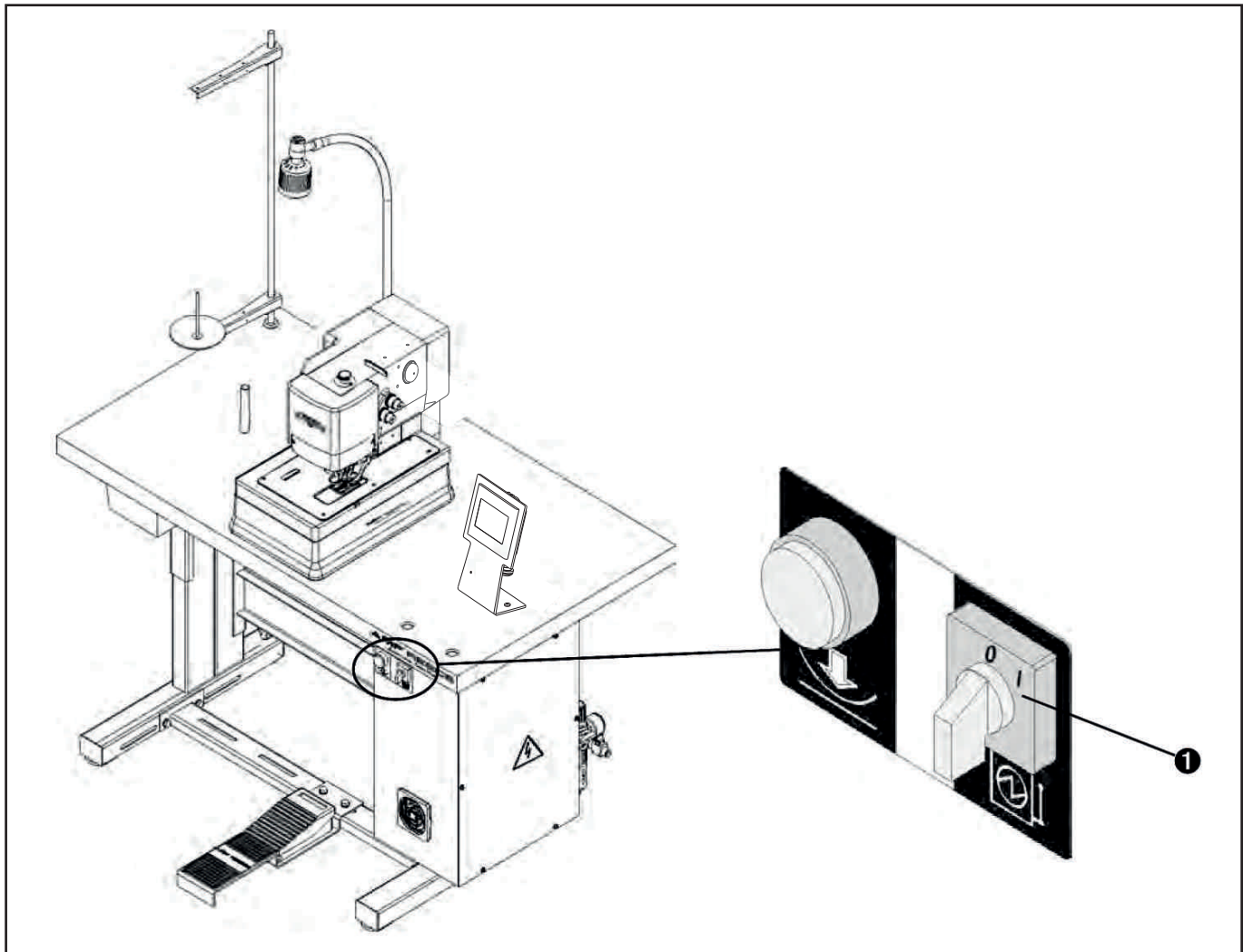


C - PROPER APPLICATION

1. POWER UP / HOME POSITION

1. Turn the main power switch on ① by turning clockwise to the I position.
2. The machine is ready for operation when the control panel display lights, the Ready message appears on the display and the green LED lights on display.  The machine must be in the home position before starting to sew (to be certain, press the foot pedal and sew one dummy buttonhole).
3. It is possible to instal power voltage control (Voltage monitoring relay HRN 35) in to the machine control system. This power voltage control cautions a machine operator if the supply voltage is not in the required range (185V - 255V) and the machine could be damaged - see section E20.

Note: The power voltage guard is installed in the machine only if a customer has ordered it with a machine.



C - PROPER APPLICATION

2. NEEDLE INSTALLATION

WARNING! Before performing this adjustment, switch the main machine power off to prevent accidental starting of the machine. Disconnect the air supply and dissipate any stored energy.

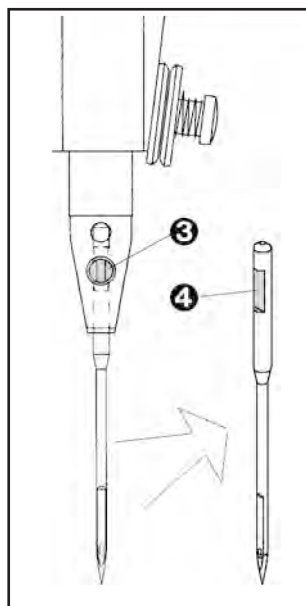
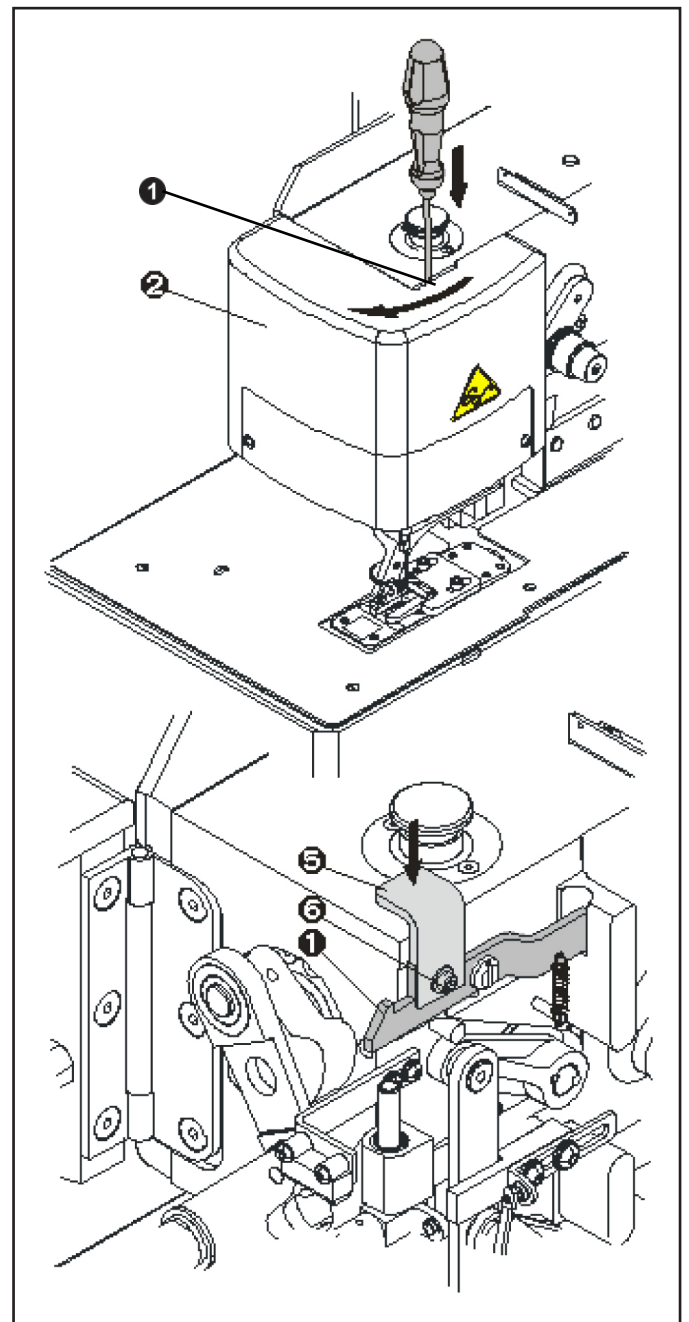
Use needles ordering number 02.0750.2.110 (750SC 90/14) only - see accessories.

It is also possible to use needles ordering number 02.0750.2.100 (750 SC 80/12) for sewing the thin materials - these needles are not included in the standard machine equipment.

1. Using the screwdriver push the latch **1** and open the needle bar cover **2**.

Note: The accessories contain the lever **5** (ordering number 22.0213.0.000) and screw (ordering number 08.6000.4.005) with washer (08.6850.4.000) **6**, which is possible to fit to the latch. It allows opening of the cover without using the tool.

2. Loosen the screw **3** and remove the needle.
3. Insert the new needle so that the long thread groove **4** is in the rear and the spot for the clamping screw **3** is in line. Do not install a bent or broken needle. Roll the needle on a flat surface to check for straightness.
4. Tighten the screw **3** well.

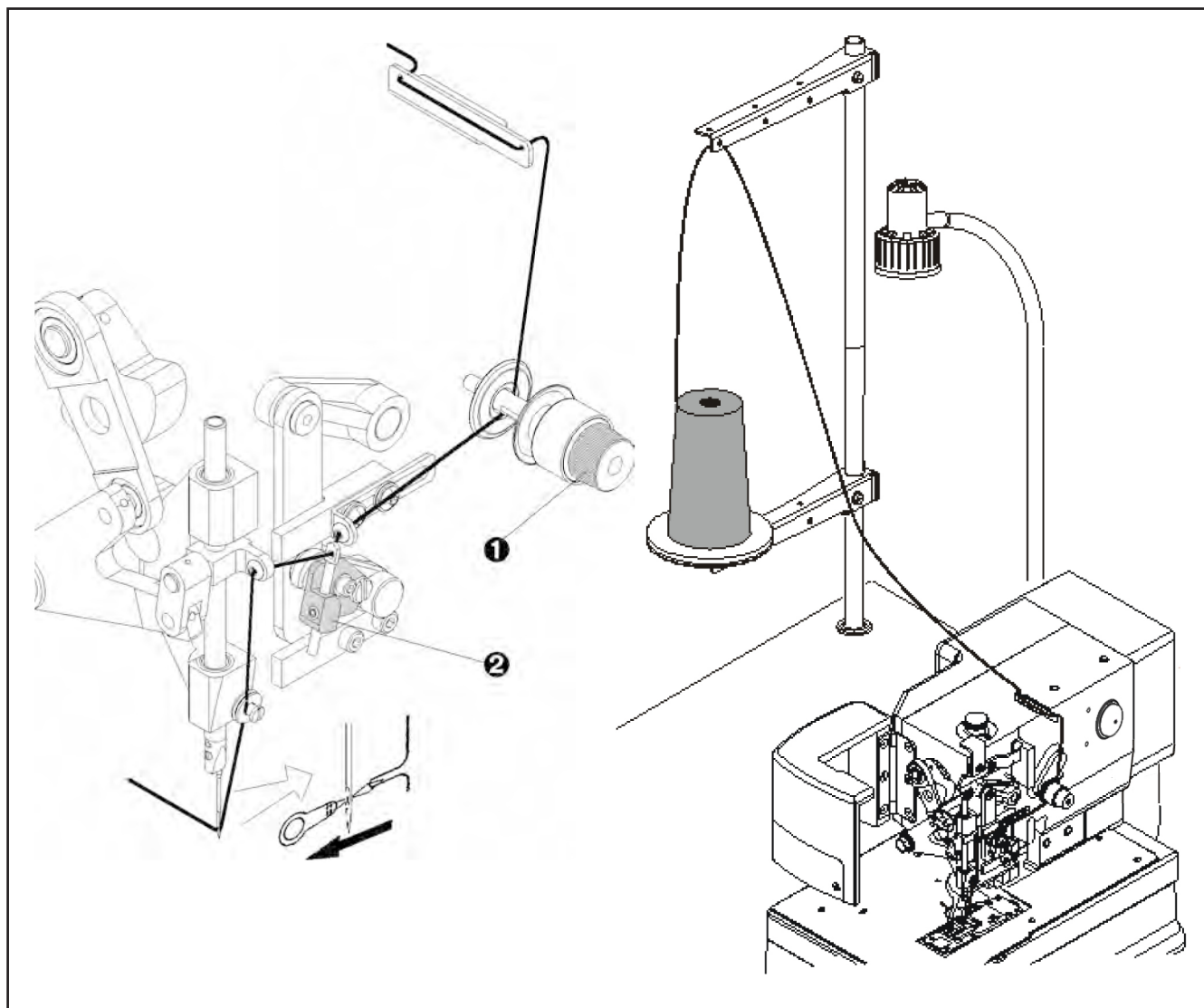


C - PROPER APPLICATION

3. THREADING

WARNING! Switch the main machine power off to prevent accidental starting of the machine. Disconnect the air supply and dissipate any stored energy.

When threading, see the pictures below. Change the thread tension by nut ❶ according to the sewing conditions. To increase the thread draw off (for example sewing on the thin fabrics) there is an arm ❷ installed on the thread draw off lever.



The appearance and quality of the buttonhole may be affected by one or more of the following:


- clamping of the material
- thread tension
- type of thread (size etc.)
- sewing width
- sewn material (thickness, density)

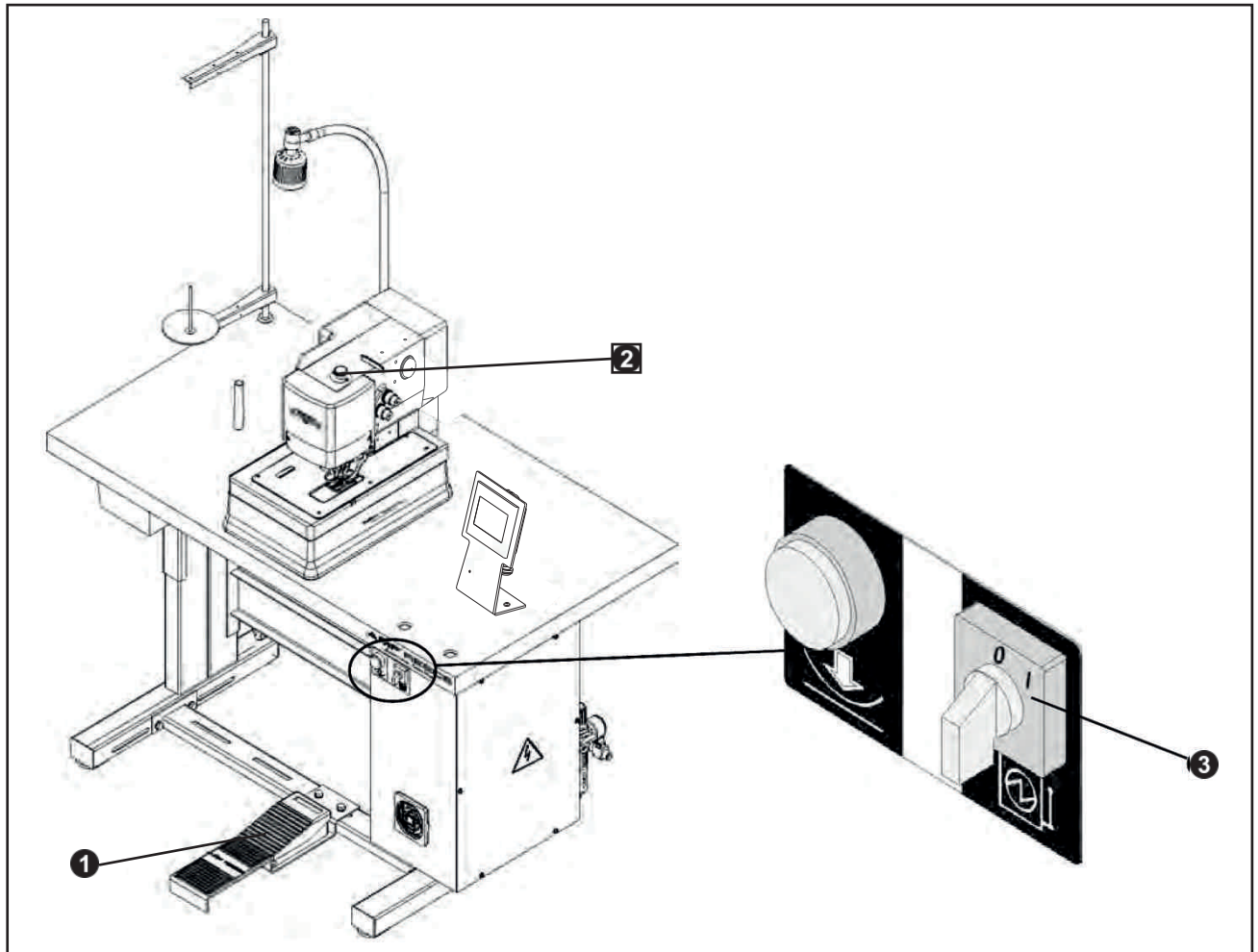
D - MACHINE CONTROLS

1. PROGRESS OF SEWING

1. Bring the machine to the home position according to the section C1.
2. Be certain that the machine is threaded correctly according to the section C3 and insert the work under the clamp feet.
3. When the foot pedal **1** is pressed to the first position, the work is clamped by the clamp feet.
(Releasing the foot pedal will rise the clamp feet).

Note: It is possible to set in the program the machine start on first pedal position.

4. When the foot pedal is pressed to its second position, the sewing is started. After finishing the sewing and trimming the thread, the machine returns to the home position and the clamp feet rise.
5. When the clamp feet are up, it is possible to move the sewn work for next sewing.
6. Machine can be stopped in any place of the cycle by pressing the Emergency Stop button **2** which is placed on the machine head. After releasing the Emergency Stop button, pressing the  button and pressing the foot pedal, the machine finishes the sewing.
7. If the foot pedal **1** is pressed before finishing the sewing, the clamp feet will not rise and the machine will sew four cycles instead of two - this is possible to set in program.
8. When the work is done, switch the machine off by the **3** button.



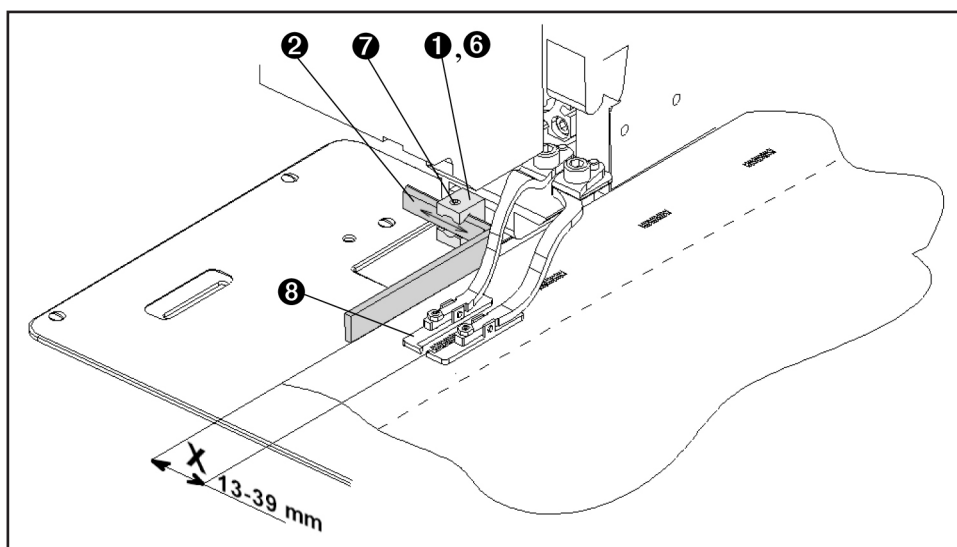
D - MACHINE CONTROLS

9. It is possible to sew two styles of buttonhole alignment on the machine.

a) Sewing the lengthwise buttonholes

- remove the parts 22.0011.0.000 **1**, 22.0012.0.000 **2**, 08.6010.5.008 **6**, 08.6400.4.004 **7** from accessories and install them to the machine.
- to adjust the clearance **X** between the center of a buttonhole and the material edge, loosen the screw **7** and move the stop **2** as needed. Tighten the screw **7**. It is possible to adjust the stop in range 13 - 39 mm.

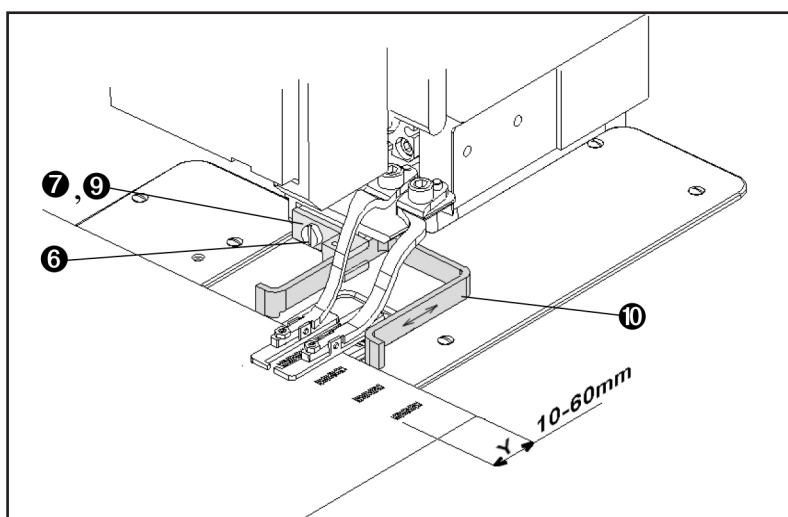
Note: If the stop is set to 13 mm and the bite size is increased, the left clamp foot **8** must not hit the stop **2**.



b) Sewing the crosswise buttonholes

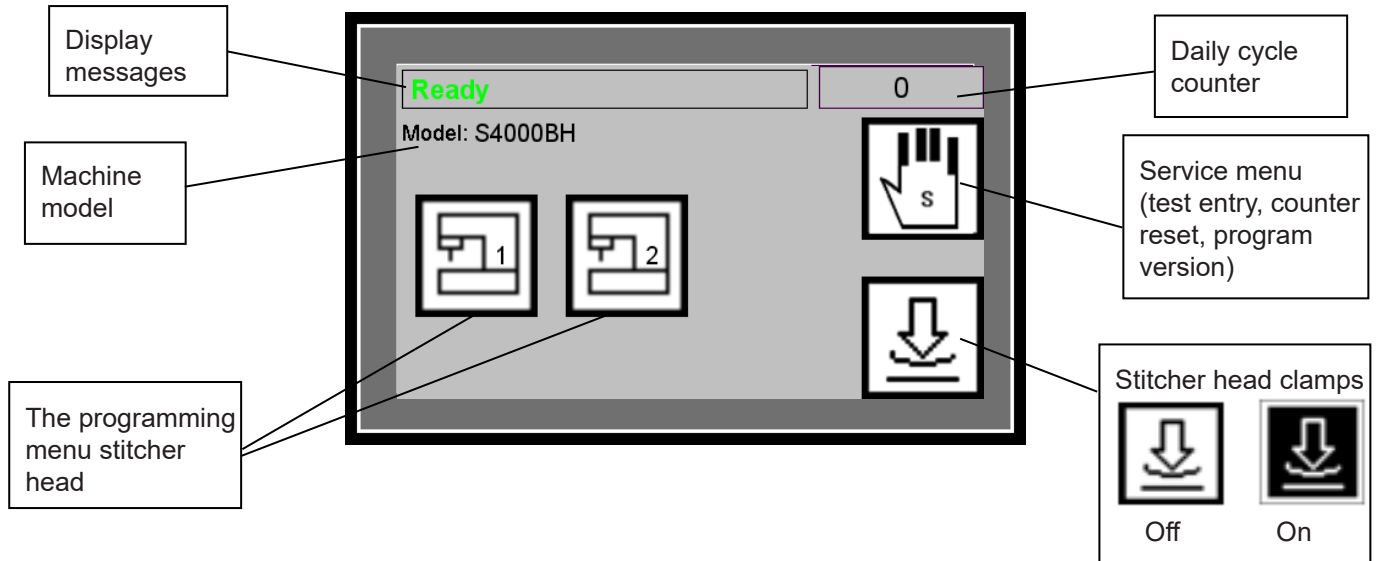
- remove the parts 22.0044.0.000 **9**, 22.0010.0.000 **10**, 08.6010.5.008 **6**, 08.6400.4.004 **7** from accessories and install them to the machine.
- to adjust the clearance **Y** between the buttonhole edge and the material edge, loosen the screw **7** and move the stop **2** as needed. Tighten the screw **7**. It is possible to adjust the stop in range 10 - 60 mm.

Note: If the stop is set to 10 mm and the length of a buttonhole is increased, it is necessary to move the stop towards the machine head!



D - MACHINE CONTROLS

2. OPERATOR CONTROL PANEL PUSH BUTTONS AND SWITCHES



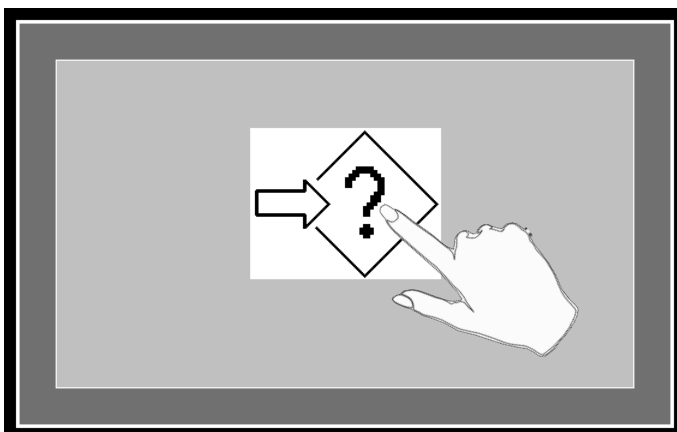
Display messages:	
<u>Standard messages:</u>	<ul style="list-style-type: none"> • Ready • Emergency stop • Wait please • Busy
<u>Error messages:</u>	<ul style="list-style-type: none"> • Motor not ready • Low air pressure • Low voltage

ATTENTION!

When doing any kind of adjustment, keep your hands off the needle area. The basic machine design is equipped with a pedal control; therefore never place your foot onto the foot pedal.

Error messages on the display are mentioned in *Troubleshooting* section.

Error setting



It will display if the value of the parameter is adjusted out of range.

Press the screen on the display, you will return on the main screen

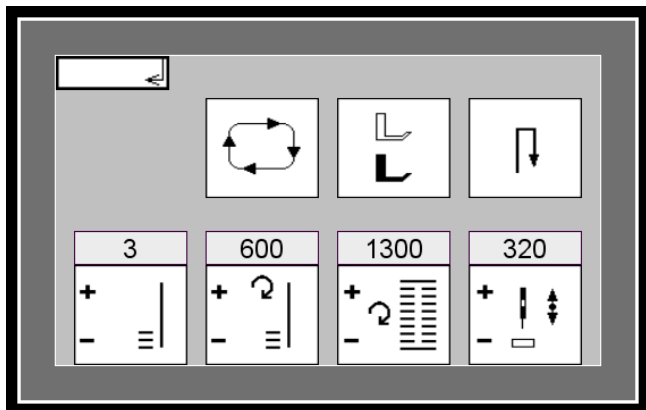
D - MACHINE CONTROLS

3. THE PROGRAMING MENU STITCHING HEAD

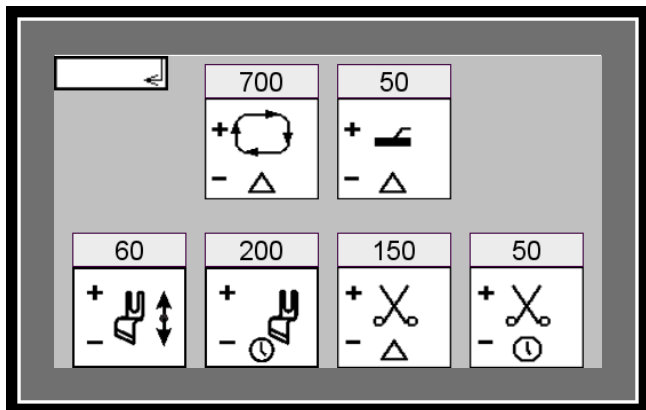
Enter the sewing head program menu by pressing button




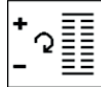



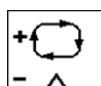
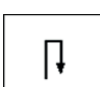
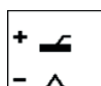

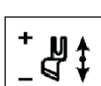
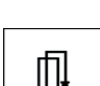

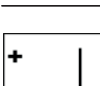
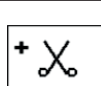
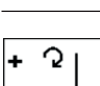
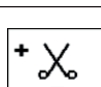
Parameters set 1




Parameters set 2



D - MACHINE CONTROLS

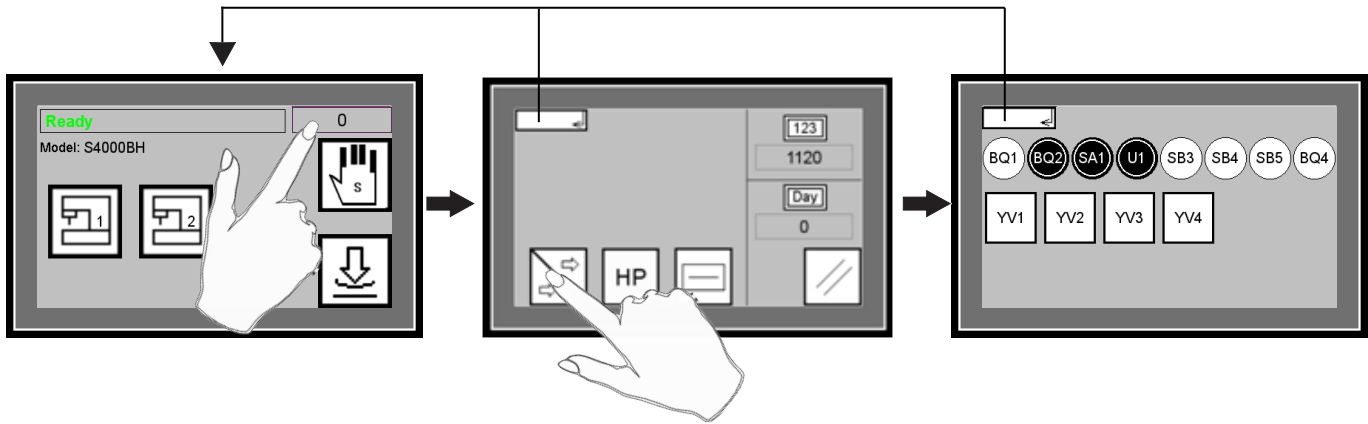
 <p>Setting the machine cycling. (On/Off). If the button is backlit, the function is active.</p>	 <p>Setting the maximum sewing speed. (Range 1000 - 3840 ppm)</p>
 <p>Setting the foot pedal position. (Possible setting 1step/2steps). Adjustment for position 1 means, that the machine closes clamps and starts sewing in one moment.</p>	 <p>Setting correction of the needle bar upper position. (Range 0 - 600 imp)</p>
 <p>Adjustment for position 2 means, that the machine closes clamps on 1 position and on position 2 starts the sewing cycle.</p>	 <p>Setting the delay between the button hole sewing cycles. (Range 500 - 2500 ms)</p>
 <p>Setting the number of buttonhole sewing (It is possible to set 1 sewing/2 sewings/1 or 2 sewings)</p> <p>Setting 1 sewing</p>	 <p>Clamp feet opening delay adjustment, at the end of cycle. (Range 0 - 100 ms)</p>
 <p>Setting 2 sewings</p>	 <p>Knife position (± 200). Correction of the knife cutting position.</p>
 <p>Setting 1 or 2 sewings. If you press the foot pedal and keep it pressed down after sewing 1 buttonhole, the buttonhole will be sewn again. If you press the foot pedal only at the start of sewing and release it, a buttonhole will be sewn by 1 sewing.</p>	 <p>Knife time (30 - 200 ms). Setting the knife cutting time.</p>
 <p>Setting the number of stitches in slow speed at the beginning. (it is possible to set 0 - 3 rpm)</p>	 <p>Setting the trim delay. (Range 0 - 200 ms)</p>
 <p>Setting the slow start speed at the start of sewing cycle. (Range 500 - 1000 rpm)</p>	 <p>Setting the trim timing activation. (Range 30 - 60 ms)</p>

To return to the main screen, press  key.

D - MACHINE CONTROLS

4. TESTS

Warning !!! The tests can be carried out by qualified service men only.



Inputs

BQ1 – The end position sensor BQ1. The symbol signalizes correct function of the sensor of the end position of the cam (HOME) BQ1.

Activate the sensor using a metal tool and the button turns black.

BQ2 – The symbol signalizes the correct function of the air pressure button BQ2.

If the air pressure is less than 0,5 MPa the button is under lighted.

SA1 – The symbol signalizes the correct function of the emergency button SA1.

After pressing button key EMERGENCY STOP the button is under lighted.

U1 – The symbol signalize the correct function of the servodriver.

If the servodriver is in operation, the button is underlighted.

SB3 – The sewing head clamps button.

When pressing the clamps button on the machine or in the main menu, the symbol turns black.

SB4 – The symbol signalizes the correct function of the first position button of the pedal SB4.

When the foot pedal is pressed to its first position the button SB4 is underlighted.

SB5 – The symbol signalizes the correct function of the second position button of the pedal.

When the foot pedal is pressed to its second position the button SB5 turns black.

BQ4 – Tension release sensor BQ2.

The symbol signalizes correct function of the tension release sensor BQ4.

Activate the sensor using a metal tool.

Outputs

YV1 – The button is used to activate the YV1 valve of the draw-off lever. The cutting lever goes down.

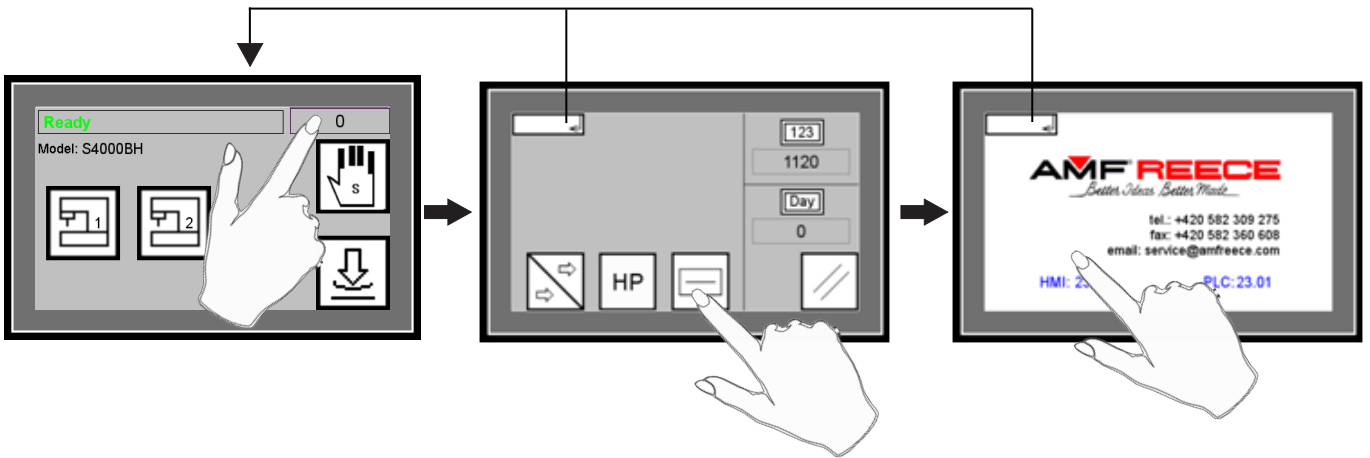
YV2 – This button is used to activate YV2 valve of the clamping. The clamps are pressed onto the fabric.

YV3 – The button is used to activate the YV3 valve of the thread trimming.

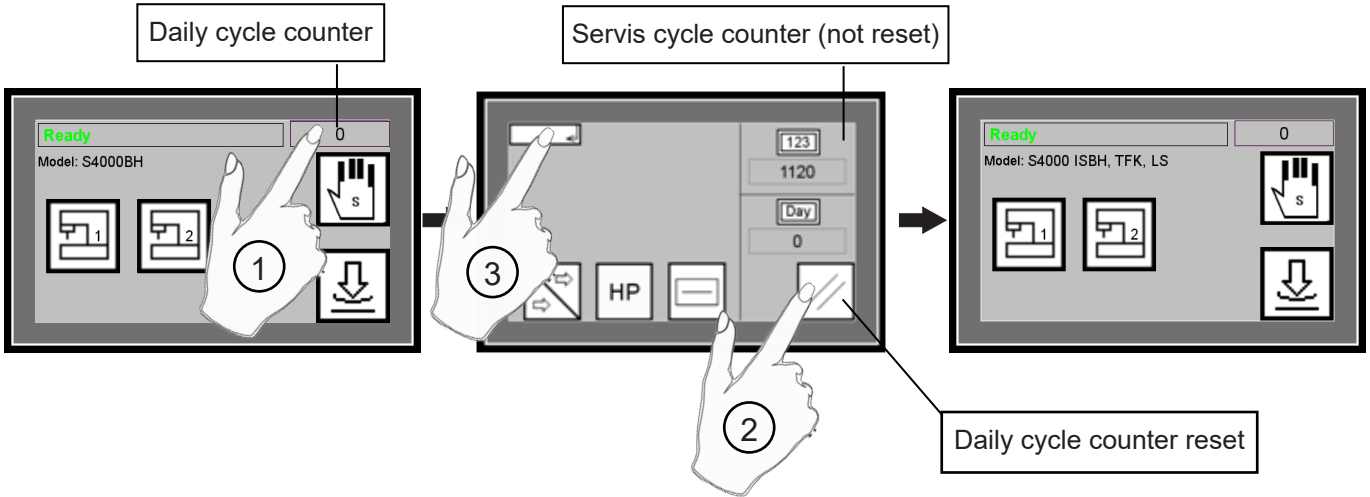
YV4 – The button is used to activate YV4 valve of the thread tension opener.

D - MACHINE CONTROLS

5. PROGRAM VERSION


























6. COUNTER RESET



D - MACHINE CONTROLS

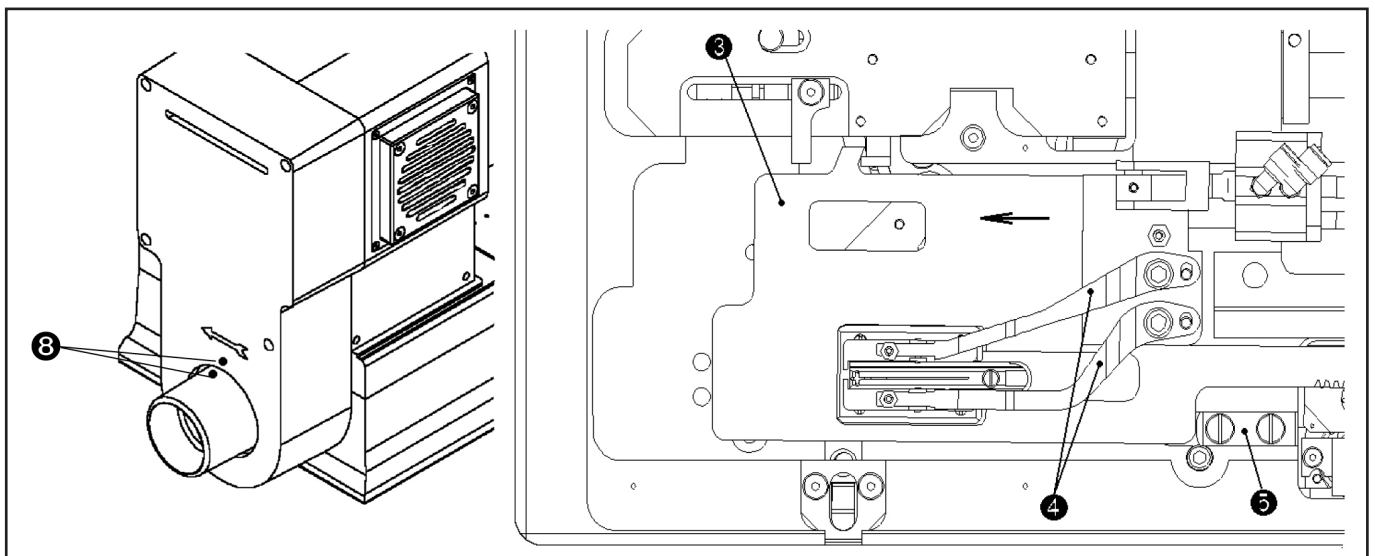
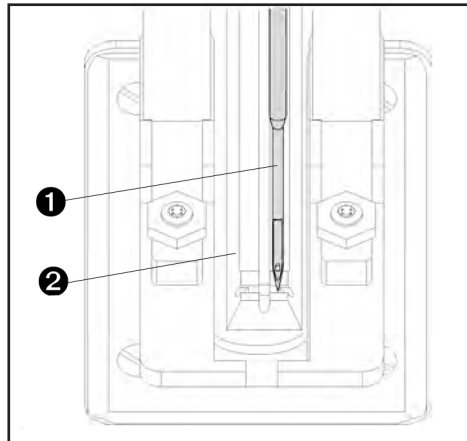
7. PARAMETER CHECKLIST

PARAMETER	RANGE	SETTING
	 Off  On	 Off
	 1 step  2 steps	 2 steps
	 1 repeat  2 repeat  1/2 repeat	 1 repeat
	0 - 3	0
	500 - 1000 rpm	1000
	1000 - 3840 rpm	3500
	0 - 600 ipm	320
	500 - 2500 ms	500
	0 - 100 ms	50
	± 200	
	30 - 200 ms	
	145 - 200 ms	
	30 - 60 ms	

E - MACHINE ADJUSTMENTS

1. MACHINE HOME POSITION

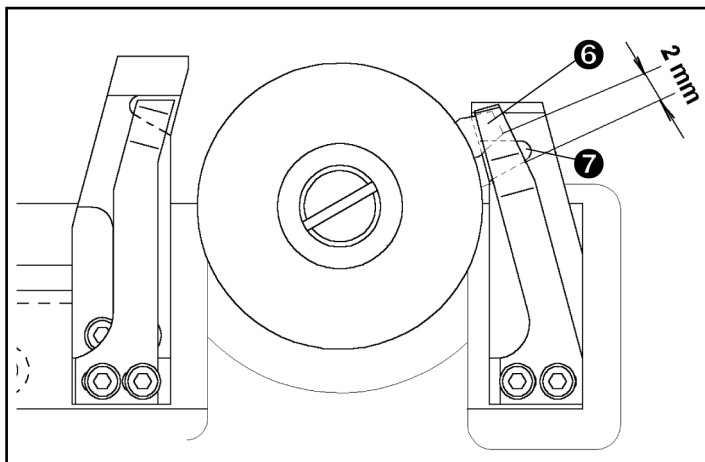
1. The needle bar is in the upper position. The needle **1** descends to the right side of the throat plate slot **2** during the first stitch. The marks **8** on the handwheel and cover casting are aligned.
2. The clamp plate **3** with clamp feet **4** is in the full forward position against the adjustable stop **5**. The clamp plate moves to the rear position during the first row of stitches.



E - MACHINE ADJUSTMENTS

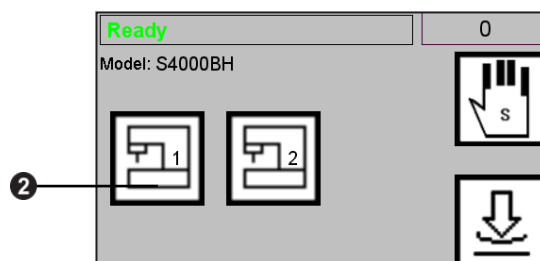
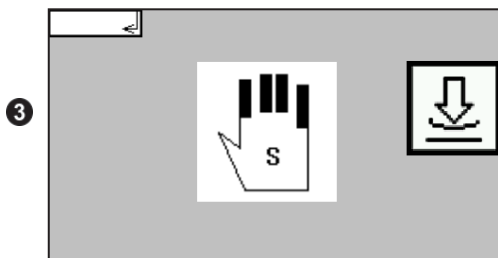
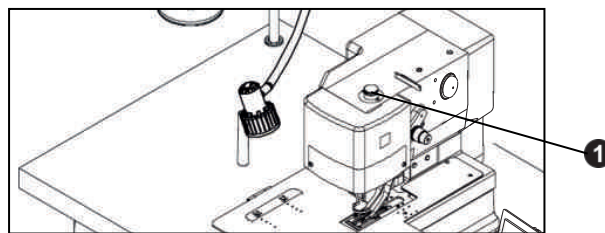
2. THE MAIN CAM ADJUSTMENT

1. Bring the machine to the home position.
2. Tilt the machine on the rest pin and view the main cam assembly. The distance between the control spring **6** and the right shifter block **7** is 2 mm.
3. If incorrect - see section E9, point 1.

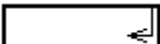


3. THE PRINCIPLES FOR THE MACHINE ADJUSTMENT

1. Before starting doing adjustments switch the machine into the service mode by pressing the emergency stop button **1** on the machine head and releasing it again. Press the button **2** on the control panel afterwards. "Service mode" message appears on the display **3**.



WARNING! THE MACHINE CANNOT START OPERATION BY PRESSING THE FOOT PEDAL IN THE SERVICE MODE!

2. Press  button to go back onto the main screen.

E - MACHINE ADJUSTMENTS

4. NEEDLE BAR

1. Needle bar crank position

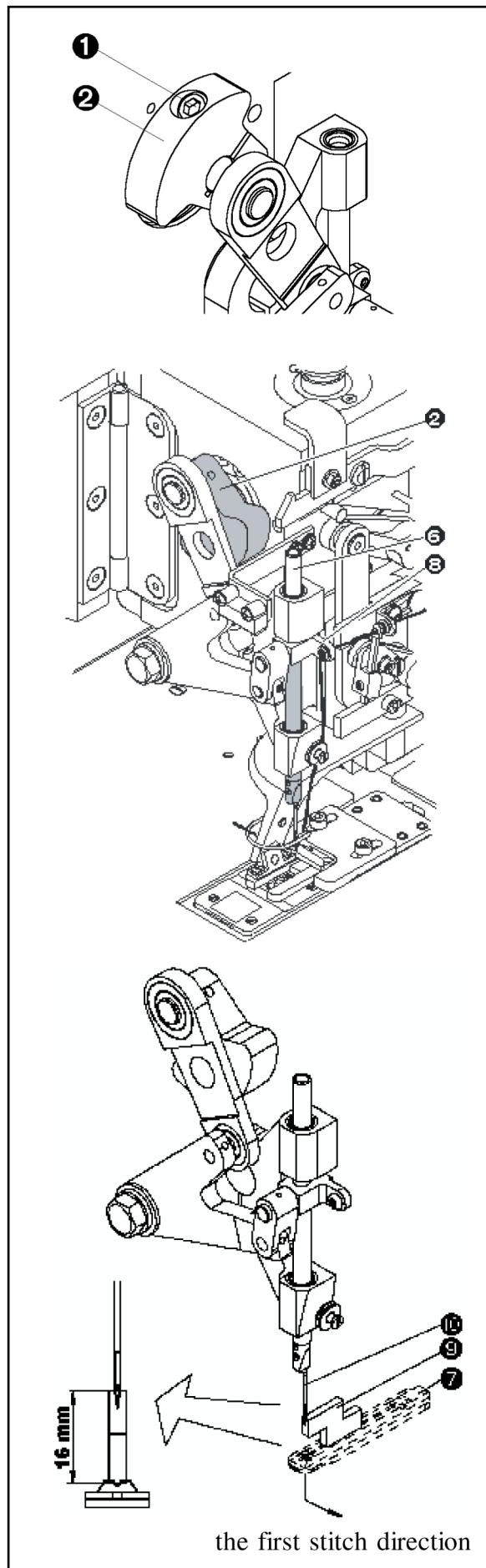
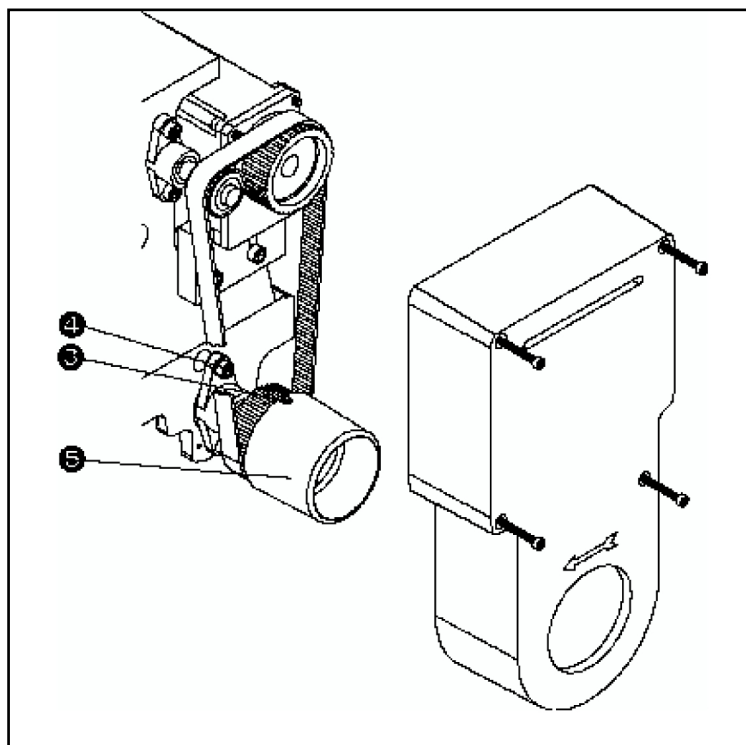
Turn the handwheel **5** and loosen the screw **1** in the needle bar crank **2**. Turn the handwheel until the needle bar reaches the upper position. Pulley screw **3** on the main shaft should be in the same line with screw **4**. Tighten the screw **1**.

NOTE: The needle bar should be in the top dead center position when the screw **3** is at 12 o'clock. To check, turn the handwheel clockwise and counter clockwise. The needle bar must move downward in either direction. The needle **10** makes its first stroke into the right side of the throat plate.

2. The needle bar height adjustment

Adjust the needle bar **6** height to 16 mm (5/8") from the surface of the throat plate **7** to the lower edge of the needle eye. Use height gauge **9**.

Loosen the set screw **8** and move the needle bar up or down as necessary.



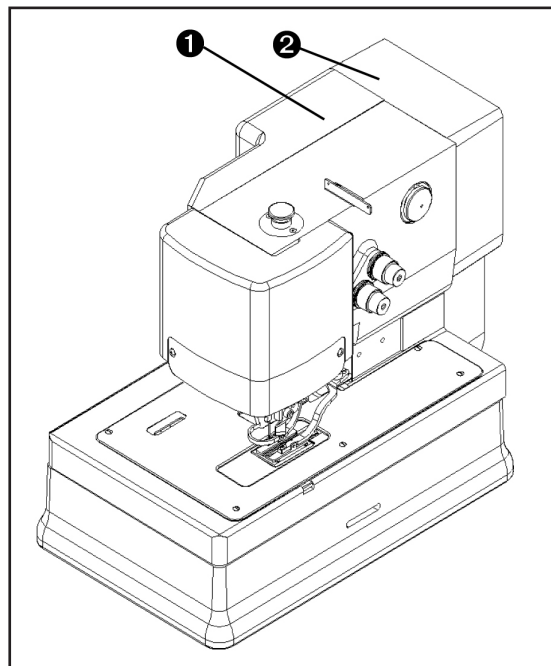
E - MACHINE ADJUSTMENTS

5. BITE

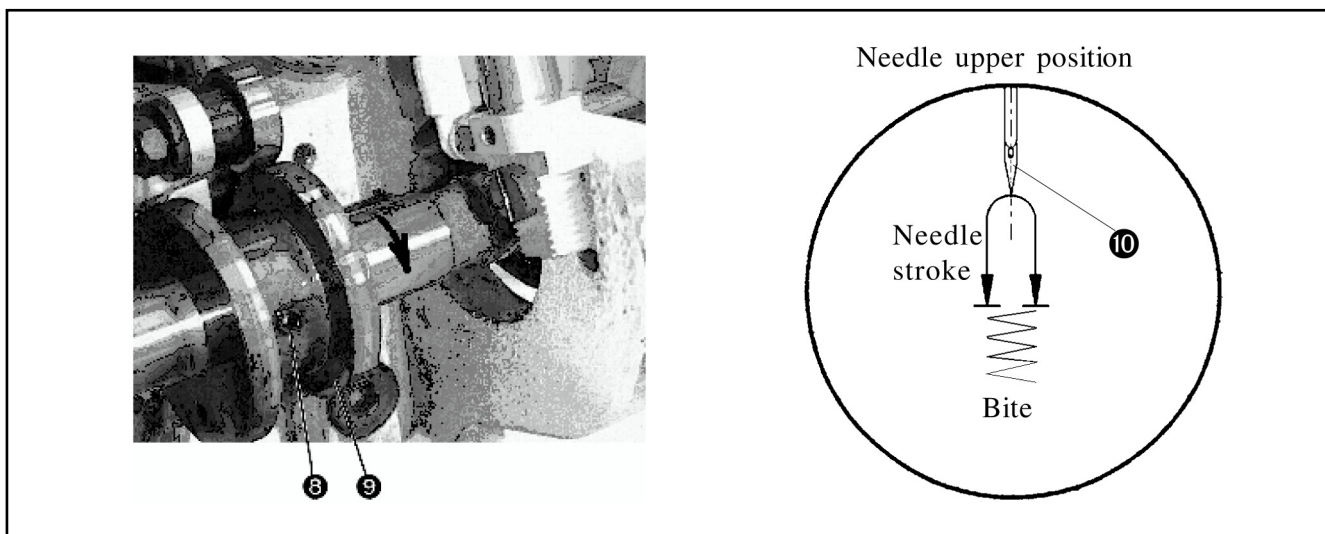
Before the bite adjustment, remove the pulley cover **2** and the head cover **1**.

1. Bite cam

- Check if the machine is in the home position.
- Tilt the machine on the rest pin **7**. If the adjustment is correct, the second cam locking screw **8** (counter clockwise of the bite cam **9**) must be roughly perpendicular to the bedplate casting.
- Adjust the position of the bite cam so that all of the needle bite motion occurs equally with the needle out of the work piece on the up and down stroke.



NOTE: There must be no bite movement before the needle **10** comes out of the work nor after it has descended into the work - see illustration. Tighten both locking screws **8** securely.



2. Bite width adjustment

To adjust the bite width, first remove the head cover for access to adjustments.

The S-4000 BH is fitted with a regular bite throat plate **11**, that allows a bite range of 1.7 mm (1/15") to 2.3 mm (3/32").

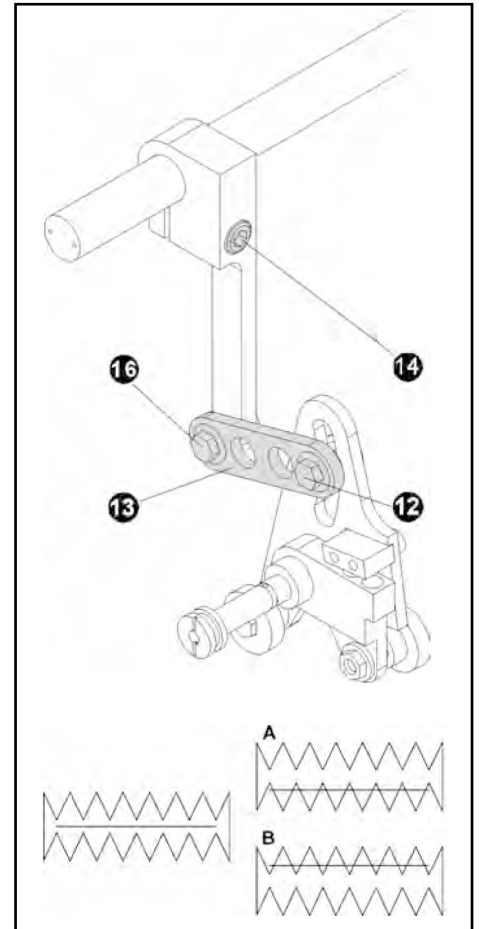
- loosen the adjusting screw **12**
- to increase the bite width, raise the bite lever **13**
- to decrease the bite width, lower the bite lever **13**
- tighten the adjusting screw **12**

E - MACHINE ADJUSTMENTS

3.1 Centering the bite over the throat plate

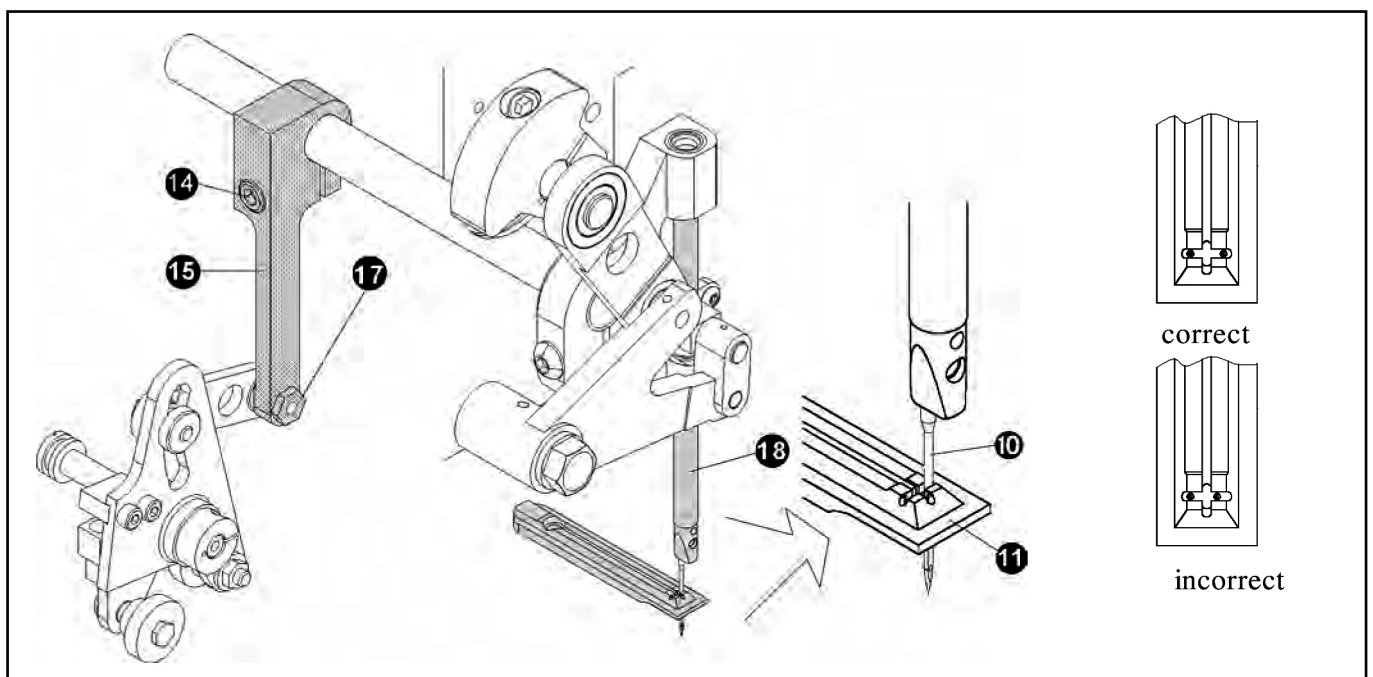
- with the machine in the home position - loosen the clamping screw **14** on the bite lever **15**
- for rough adjustment, using the handwheel, rotate the needle bar to its full down position and move the needle to the right side of the throat plate slot **11**. Turn the hand wheel to the second needle **10** down stroke and compare the needle position in the left side of the throat plate. Continue adjusting until the needle is roughly of equal distance from the right and left sides.
- tighten the clamping screw **14**
- check with rotating the handwheel, if needle **10** has the same clearance on both sides of the throat plate slot.

Note: This adjustment is just tentative. For fine adjustment loose the screw **16** of the eccentric nut **17** plate the needle the way the clearance is on both sides of the throat plate nut. Tighten the screw of the eccentric nut **16**.



3.2 Bite in the throat plate and in the knife cut adjustment

- take out the loopers from the machine
- sew the buttonhole sample on the paper. If you find out, that after sewing and cutting the buttonhole is cut the first or second row of stitches, do as follows:
see section E15 4. *The knife cutting adjustment*
- if you used the whole range of the parameters adjustment and the cut is not in the center - continue according to the point - 3.1 *Centering the bite over the throat plate*, until the cut is in the center of the buttonhole.
- put and adjust the loopers in the machine



E - MACHINE ADJUSTMENTS

6. FEEDING

1. Tilt the sewing head onto the rest pin.
2. Bevel Gear Adjustments

Manually turn the handwheel counter clockwise until the drive spring in the main cam engages with a indent (first row of stitches). The feeding lever is on the highest point of the feeding cam. Remove the bevel gear cover and loosen the screws **1**, **2** on the horizontal bevel gears and screw **3** on the stop.

3. Loosen two adjusting screws **4** in the right collar **5**.

Adjust the dimension 11mm from the end of the feed shaft **6** to the collar **7** by pressing the feed shaft **6** against the right collar **5**. Tighten the adjusting screws **4** in the right collar **5**. The tension of the left collar on the shaft is set.

4. Engage the right bevel gear **8** with the vertical bevel gear **9** and lock its position by the set screws **1**.
5. Manually turn the handwheel counterclockwise until the drive spring engages with right shifter block pocket (the second row of stitches). The feeding lever is on the lowest point of the feeding cam. Slide the right gear **10** into engagement with the vertical gear **9**. Tighten the set screws **2** securely. Move the crank drive to the left bevel gear **10** and lock it by screw **3**.

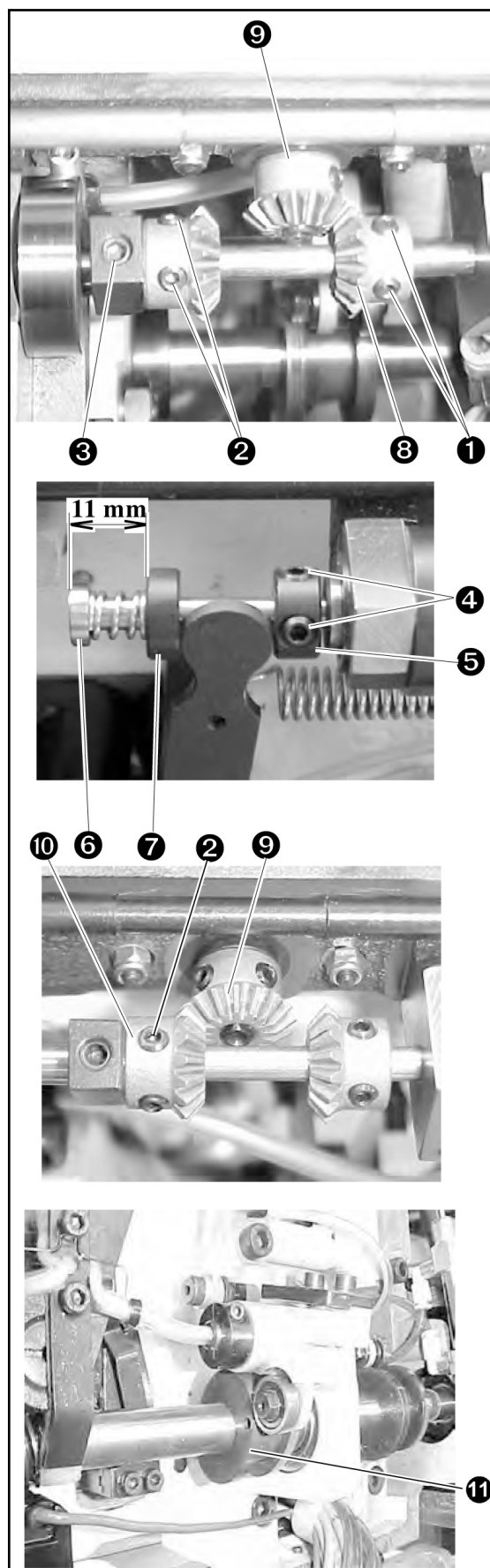
The bevel gear adjustment is done. By manually turning the handwheel finish the sewing cycle and bring the machine to the home position. Reinstall the bevel gear cover.

6. Clamp plate movement occurs only when the needlepoint has risen above the work piece and must be completed before the needle descends into the work.

7. For adjustment use a piece of paper to see the needle punctures.

If feeding occurs while the needle is in the work, engage the drive spring into a indent.

Loosen the screws **11** on the feed cam and adjust its position as needed so that all feed motion occurs with the needle out of the work. Retighten the feed cam set screws.



E - MACHINE ADJUSTMENTS

7. SLIP CLUTCH

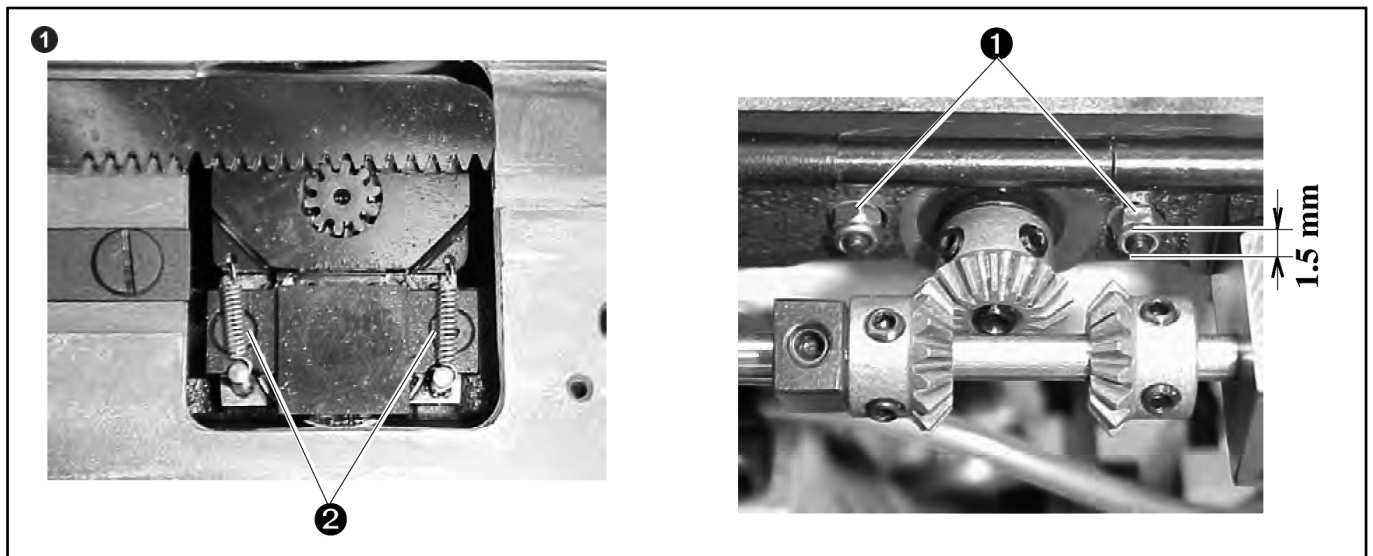
The slip clutch pressure is factory set and under normal conditions will not need adjusting. The correct clutch torque setting is 0.43 Nm (60 to 65 inch ounces).

Hold the nut **1** and tighten the adjusting screws **2** with a torque screwdriver. Apply an equal amount of pressure to both sides of the clutch.

NOTE: If a torque screwdriver is not available, tighten the lock nuts so that the screws **2** extend through the nuts **1** 1.5 mm.

CAUTION: Too little torque will produce an improper material feed.

Too much torque may damage parts (bevel gears).



8. STITCH DENSITY

Adjust the feed connecting link position **1** in the cam follower slot **2** to obtain the correct stitch density.

To increase the density 1:

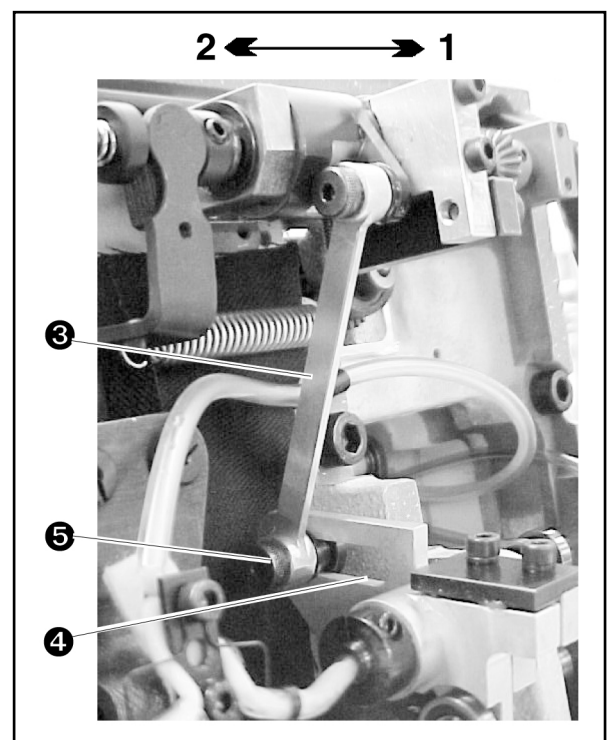
- Loosen the hex socket screw **3** and lower the link **1** away from the bedplate to increase density.
- Tighten the hex socket screw **3**.

Maximum density is 12 stitches per 10 mm (30 stitches per inch).

To decrease the density 2:

- Loosen the hex socket screw **3** and raise the link **1** toward the bedplate to decrease density.
- Tighten the hex socket screw **3**.

Minimum density is 4 stitches per 10 mm (10 stitches per inch).

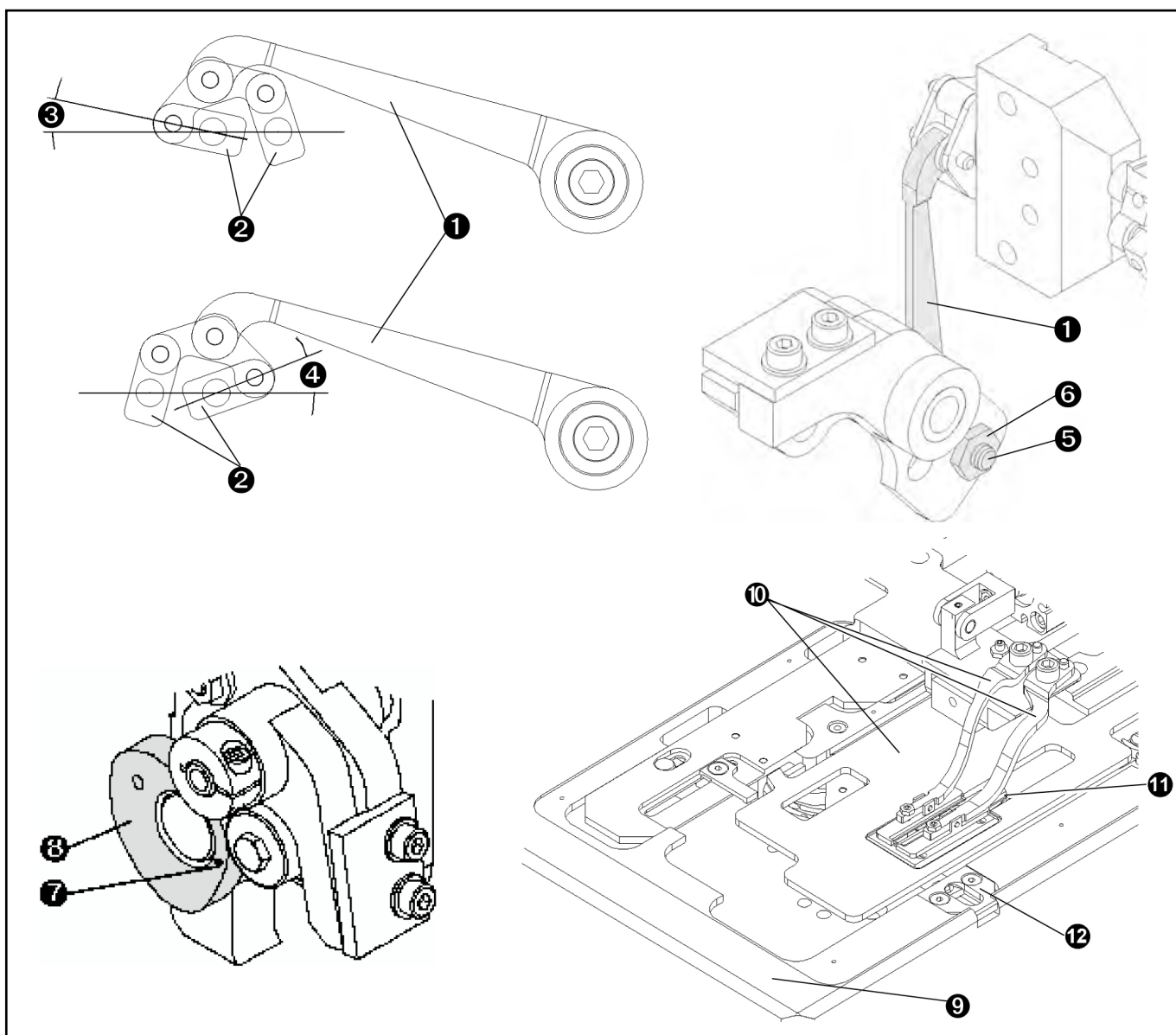


E - MACHINE ADJUSTMENTS

9. LOOPER ADJUSTMENT

Before making this adjustment, follow the below described points:

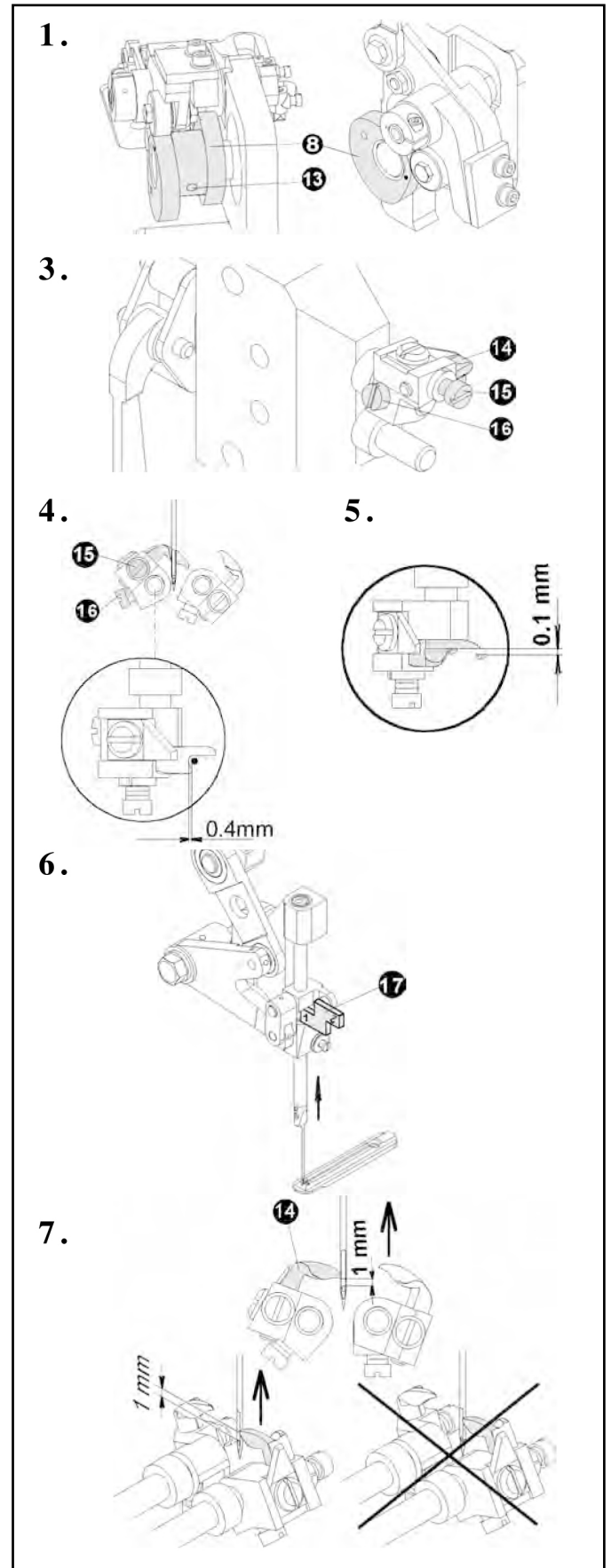
- Turn the handwheel and observe the position of the connecting link **1** at both ends of the looper link arm travel **2**. Angle A **3** must equal angle B **4**.
- If incorrect - loosen the hex mounting screw **5** and rotate the eccentric adjusting nut **6** as needed. Tighten the hex mounting screw **5**.
- Turn the handwheel and bring the needle bar to the upper position.
- Check if the needle is straight.
- Tilt the machine head on the rest pin and check if the mark **7** on the looper cam **8** is on the left side. If the mark is on the right side, remove it and install it correctly. Return the sewing head back.
- Remove the cover plate **9**, disconnect the air tubes from the clamp feet cylinder and remove the clamping assembly **10** from the machine, remove the throat plate **11**, trimming hook cover **12** and trimming hook **13**. Dismantle the loopers with holders.



E - MACHINE ADJUSTMENTS

The first looper adjustment

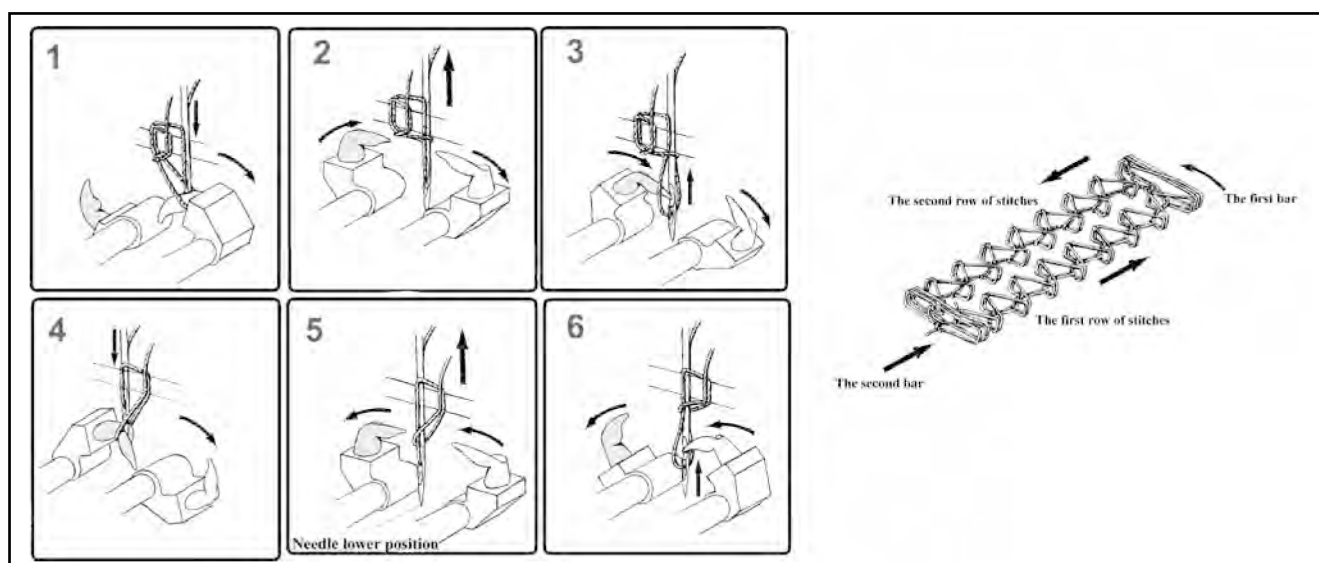
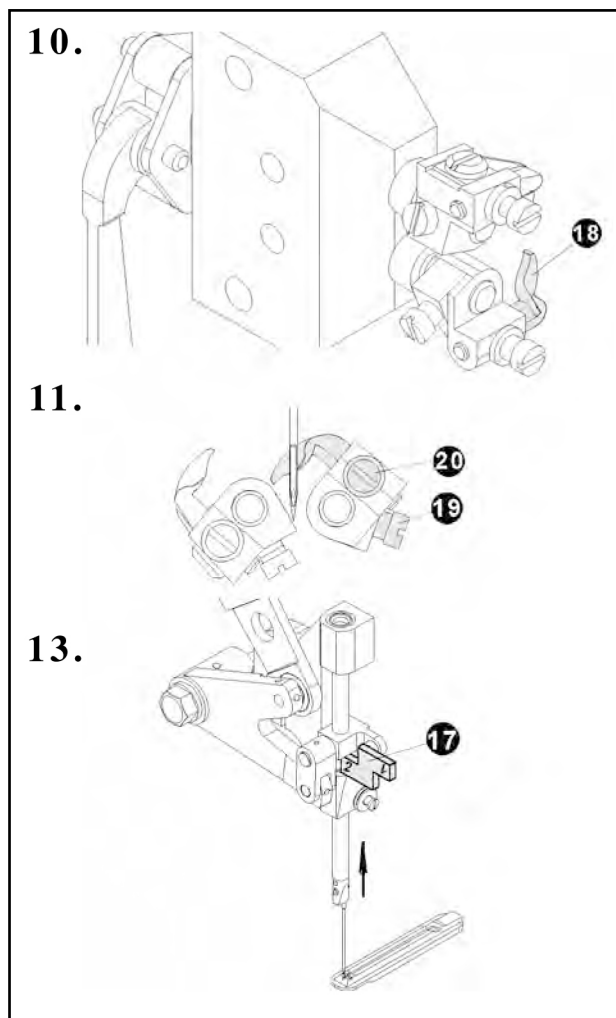
1. Bring the machine to the home position and loosen the screws **13** of the looper cam **8** and adjust the looper cam to the lowest position.
 2. Loosen the looper set screw **15** and turn the looper to be perpendicular to the hole in the looper holder.
 3. Install the holder with the first looper **14** on the shaft.
 4. Loosen the looper holder screw **16** and move the holder so that the needle passes the looper in the center of the looper recess. There must be clearance 0,4 mm between the needle and the looper recess. Tighten the looper holder screw **16**.
 5. Loosen the looper screw **15** and turn the looper **14** to the needle to obtain the distance 0,1 mm between the needle and the looper tip.
 6. Turn the hand wheel counter clockwise and insert the gauge **17** with 1 mark (wider side of the gauge) between the needle bar holder and the needle bar clamp when the needle returns to the home position from the lower position.
 7. Check to determine if the tip of the looper is at the centerline of the needle 1 mm above the needles eye.
 8. If incorrect - loosen the looper cam screw **13** by the wrench and hold it . Turn the hand wheel (counter clockwise - if the looper tip is higher than 1 mm; clockwise - if less than 1 mm).
- Tighten both looper cam screws **13** securely.
9. If it is necessary to adjust the looper cam again, check the clearance 0,4 mm between the needle and the looper recess.



E - MACHINE ADJUSTMENTS

The second looper adjustment

10. Insert the second looper **18** on the looper shaft.
11. Loosen the looper holder screw **19** and move the holder so that the needle passes the center of the looper recess. There must be clearance 0,4 mm between the needle and the looper recess. Tighten the looper holder screw.
12. Loosen the looper screw **20** and turn the looper **18** to the needle to obtain the distance 0,1 mm between the needle and the looper tip.
13. Turn the handwheel counter clockwise, insert gage **17** with mark 2 (narrower side of the gage) between the needle bar holder and needle bar clamp.
14. Check if the looper tip crosses the axis of the needle 1 mm above the needle eye.
15. If it is necessary to adjust the looper cam again, check the first looper adjustment.



E - MACHINE ADJUSTMENTS

10. THE BARRING STITCHES ADJUSTMENT

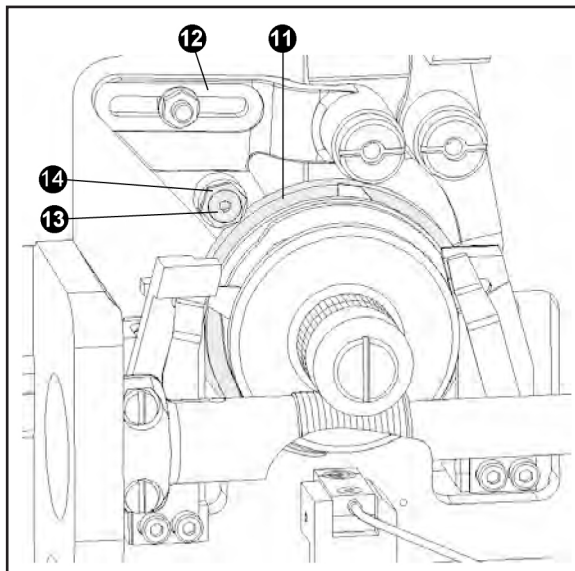
At first, it is necessary to adjust the clearance on the sewing cam.

1. The adjustment of a clearance on the cam when the first bar is sewn

- Turn the handwheel until the control spring engages into the detent of the shifter arm.
- Continue turning the handwheel. The main cam assembly ❶ starts turning and moving the rod ❷.
- Check the minimal clearance by hand on the rod ❷ when the control spring is not engaged with shifter arm.
- Check the rod tension when the control spring leaves the indent of the right shifter.

The clearance must approximately be the same. If incorrect:

- Slightly loosen M4 screw ❸ and turn the eccentric ❹ (clockwise - clearance decreases, anti-clockwise - clearance increases).
- Tighten M4 screw after adjustment and check the clearance in both positions.

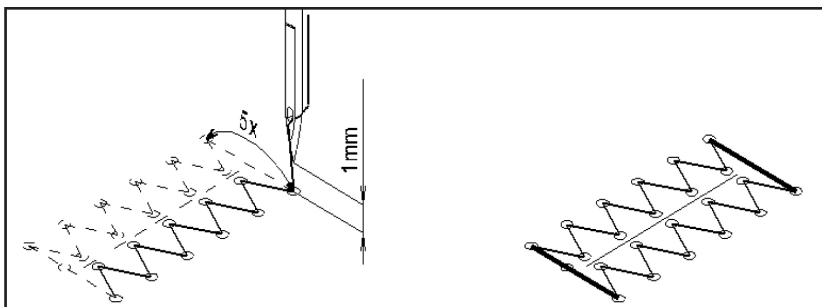
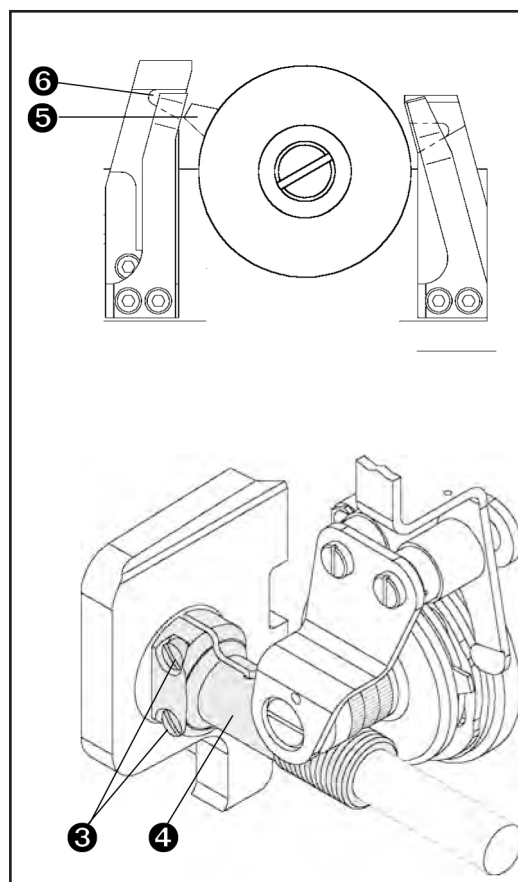


2. Second bar adjustment

Insert a piece of paper under the clamp feet. Turn the handwheel through the sewing cycle until the control spring ❶ release the left shifter arm pocket ❷. Check to see that the clamp plate starts to move to the left just as the needle point rises from the work piece approximately 1 mm.

If the adjustment is incorrect:

- If the clamp plate moves when the needle is in the work
 - loosen the screws ❸ in the worm gear
 - hold the worm gear ❹ by hand and turn the handwheel counter clockwise slightly
 - tighten the screws ❸ and recheck the adjustment. Repeat as needed.
- The clamp plate moves when the needle tip is higher than 1 mm above the work surface
 - loosen the screws ❸ of the worm gear
 - hold the worm gear ❹ by hand and turn the handwheel clockwise
 - tighten the screws ❸ and recheck the adjustment. Repeat as needed.



E - MACHINE ADJUSTMENTS

11. THE CLAMP PLATE HOME POSITION

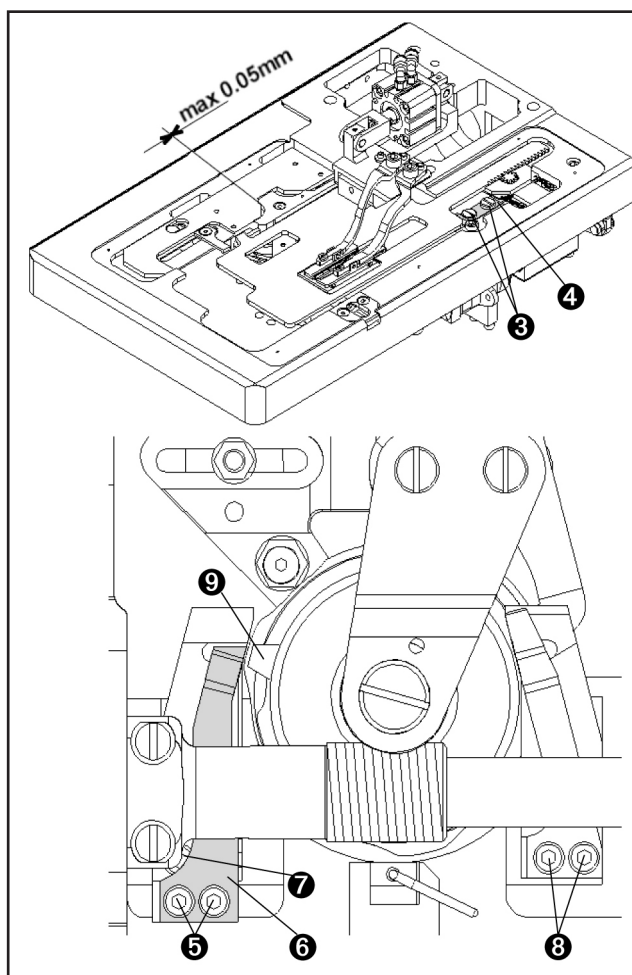
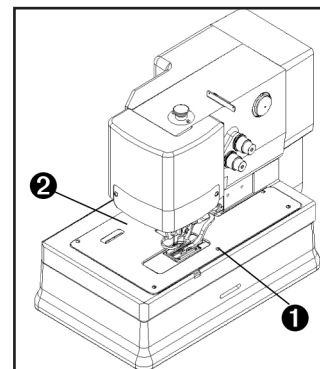
1. Bring the machine to the position. Loosen 7 screws **1** and remove the metal cover plate **2** from the machine.
2. Loosen the screws **3** and move the stop **4** to the right.
3. Tilt the machine onto the rest pin and manually secure the clamp plate.
4. Manually engage and rotate the machine until the drive spring releases from the left shifter spring. The moment the drive spring releases, stop rotating and tilt the machine back. Ensure a minimum clearance 0,05 mm exists between the shifter plate and the casting boss.

If a clearance is bigger:

- a. tilt the machine head onto the rest pin
 - b. loosen screws **5** and remove the left shifter spring **6**
 - c. loosen the two left shifter arm screws **7** and position the left arm to the right
 - d. install the left shifter spring **6** and ensure the right side of the spring is even with the left arm shifter
 - e. press the drive spring and check if a minimum clearance exists between the left shifter and drive spring
 - f. if the shifter is located too far to the right, the drive spring will not release and the machine will continue to sew in one spot, without feeding.
5. Manually rotate the machine until the drive spring releases from the right shifter arm. Tilt the machine head onto the rest pin. The shifter plate must be 0,05 mm from the boss.

If incorrect:

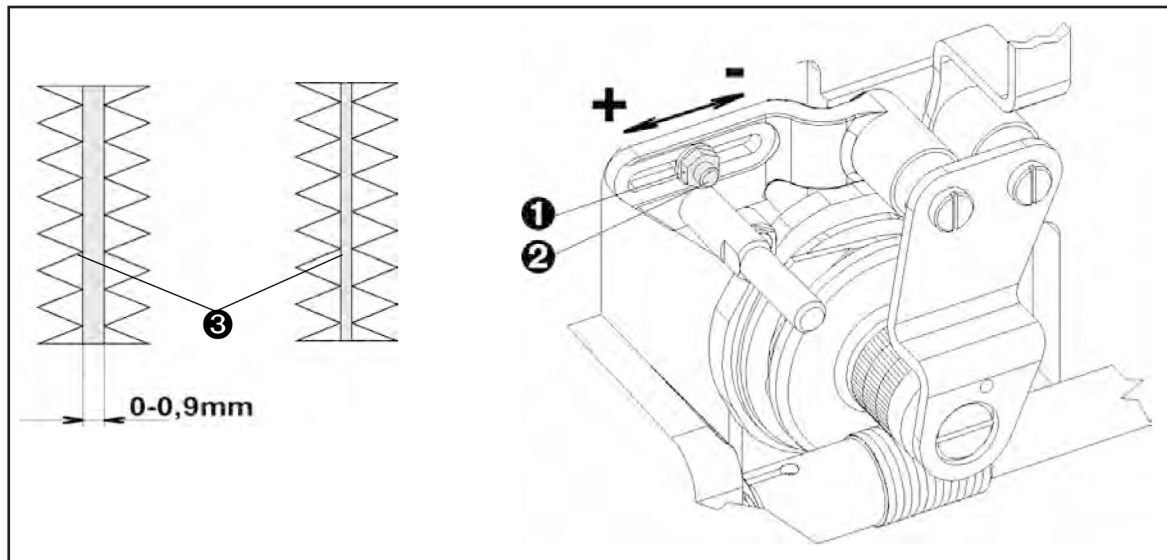
- a. loosen the screws **8** and position the right shifter arm and spring to the left towards the drive spring
 - b. ensure the left side of the spring is even with shifter arm. Tighten the screws **8**
 - c. press the drive spring and check if a minimum clearance exists between the left shifter and drive spring
 - d. if the shifter is located too far to the right, the drive spring will not release and the machine will continue to sew in one spot, without feeding.
6. Rotate the handwheel to bring the machine to the home position.
 7. Place the stop **4** to contact the clamp plate edge and tighten the screws **3**.
 8. While holding down the clamp plate, cycle the machine several times and ensure the machine stops correctly. If incorrect, check for worn parts and repeat setting.
 9. Install the metal cover plate **2** and 7 screws **1**. Sew a few buttonholes on a scrap piece of fabric, to ensure correct settings.



E - MACHINE ADJUSTMENTS

12. THE CUTTING SPACE SETTING

1. Tilt the sewing head onto the rest pin.
2. Loosen the nut **1** and move the stud **2** to the required position (to the right - cutting space **3** decreases, to the left - space increases). The cutting space can be adjusted in range 0 - 0.9 mm.
3. Sew a buttonhole on scrap fabric to check setting.



E - MACHINE ADJUSTMENTS

13. THREAD DRAW - OFF

1. Adjustment of the Draw-Off Lever Position

The correct adjustment ensures a long enough thread tail for starting the sewing of the next buttonhole. Remove the covers because this mechanism adjustment is performed in the rear of the machine head. The air supply is necessary for this adjustment.

- loosen the screw **6**
- the piston **7** of the cylinder **8** is in the home position (retracted). Move the lever **9** to the pin **10** with minimal clearance 0.1 mm. Tighten the screw **6**.
- check the correct clearance adjustment by switching the valve **11** of the draw-off cylinder (YV1).

2. Setting the thread tail length

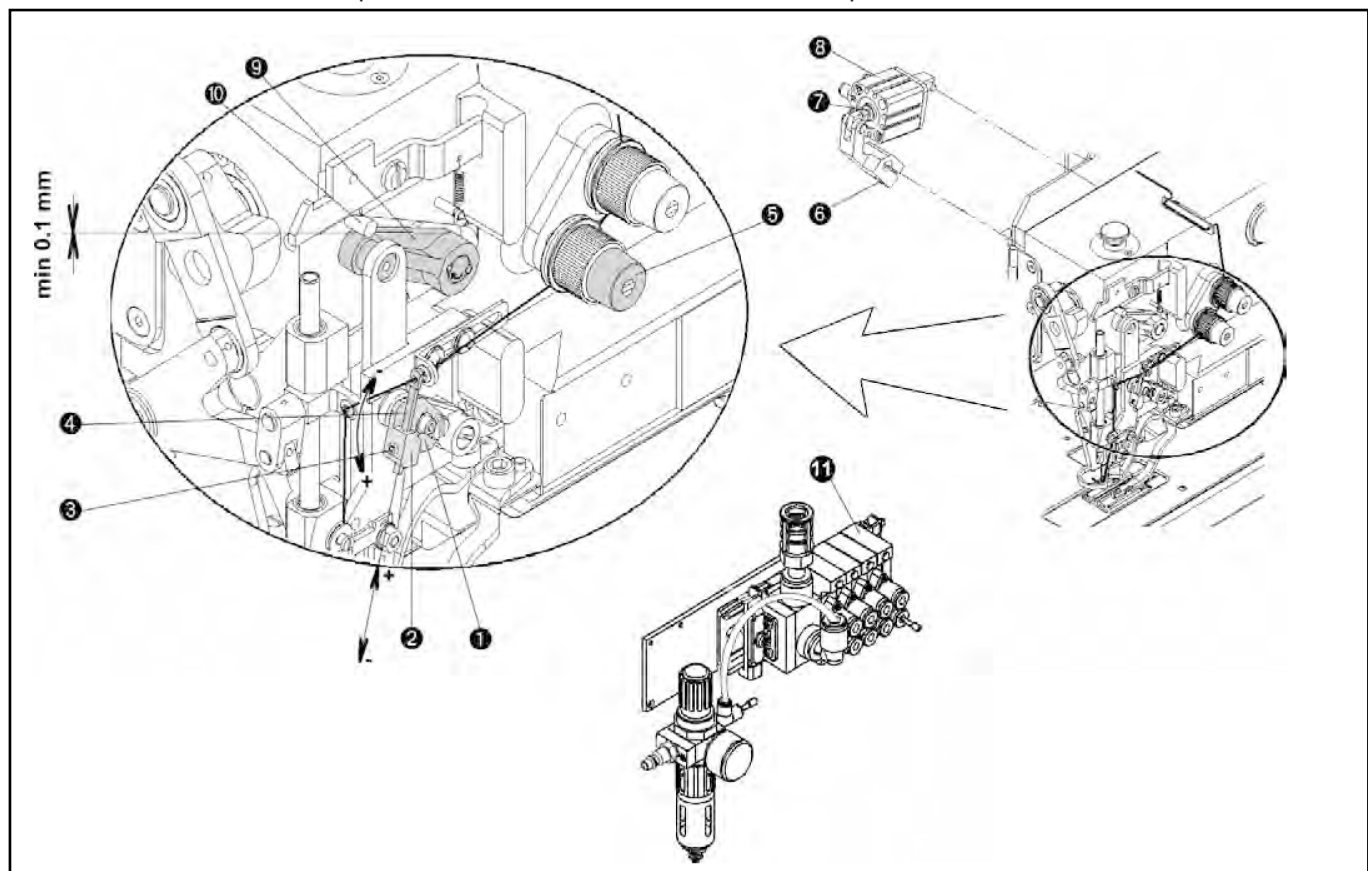
If the missing stitches appear at the beginning of the sewing or the buttonhole is not sewn, follow the below mentioned steps:

- loosen the screw **1**.
- turn the draw-off lever **2** counter clockwise to increase the thread tail length; turn the draw-off lever clockwise to decrease the thread tail length.

3. Locking the stitches

If the skipped stitches problem occurs during sewing, follow the below mentioned steps::

- loosen the screw **3**.
- move the thread take-up **4** to increase the size of the needle loop.



E - MACHINE ADJUSTMENTS

14. THREAD TENSION

The thread tension influences the appearance of the buttonhole. A thread tension change may be needed if the thread and fabric change. Check to be certain all parts, which contact the thread, are smooth and polished with no burrs or sharp edges.

- By turning the tension knob **1** clockwise, the thread tension increases.
- By turning the tension knob **1** anti-clockwise, the thread tension decreases.

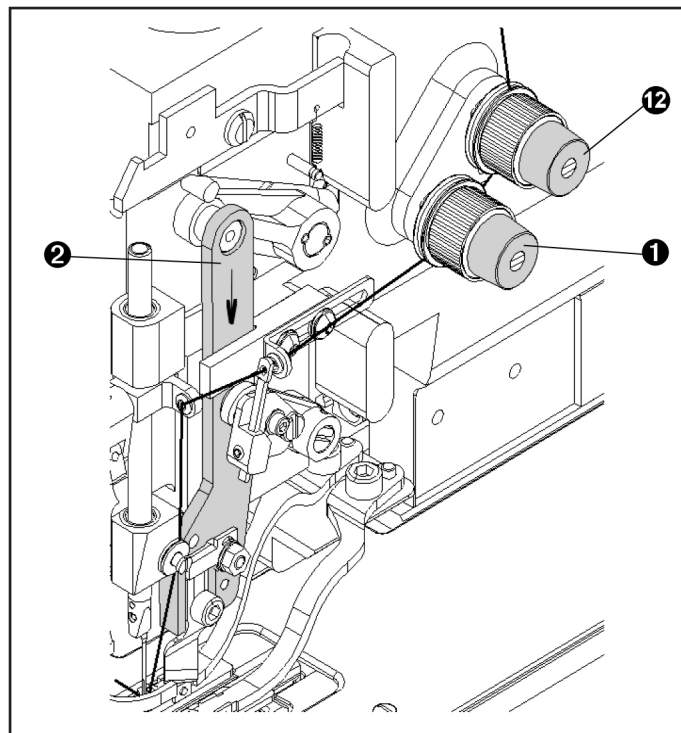
NOTE: Too big thread tension can cause the unsightly appearance of the buttonhole when sewing on a thin and elastic material.

The S-4000 BH machine has 2 thread tensions. The first one **1** influences the thread tension when the first and the second rows of stitches are sewn, the second one **12** influence the thread tension when the bars are sewn.

1. Adjustment of the tension discs opening

The opening of the tension discs is preformed when the bars are sewn. When the tension discs are opened:

- it is possible to pull the thread from the spool when the cutting lever **2** receives the impulse for operation
- by decreasing or increasing of the air flow it is possible to regulate the tightening of the last loop in the sewn buttonhole



E - MACHINE ADJUSTMENTS

2. The correct position of the tension mechanism

- remove the tension assembly **3** from the shaft **4**
- check if the distance between the stud slot edge and the pin **5** is 3.5 mm. If incorrect, it is necessary to adjust the position on the pin.
- remove the pulley cover and the head cover to obtain a good access for this adjustment. Switch off the air supply.

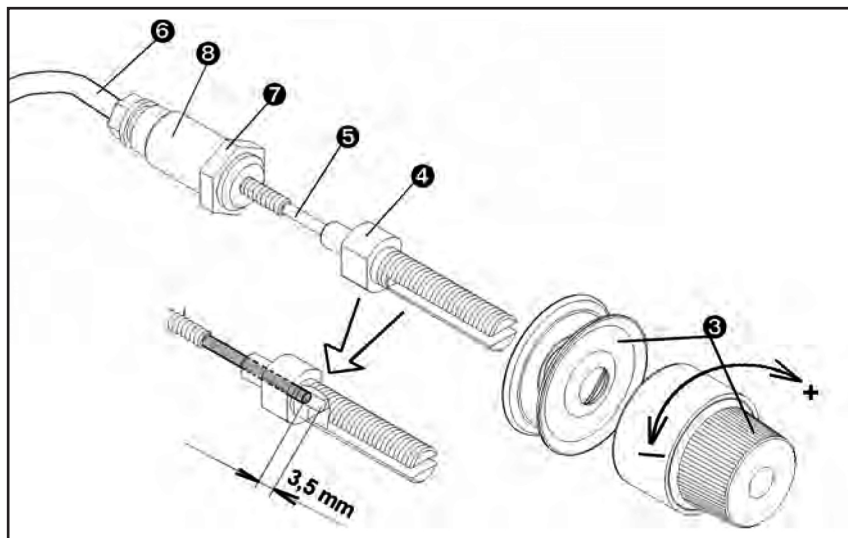
d. disconnect the air tube **6** from the cylinder.

e. loosen the nut **7** and turn the cylinder **8** as necessary.

Turning clockwise the pin is extended.

Tighten the nut **7** when the correct measurement is obtained.

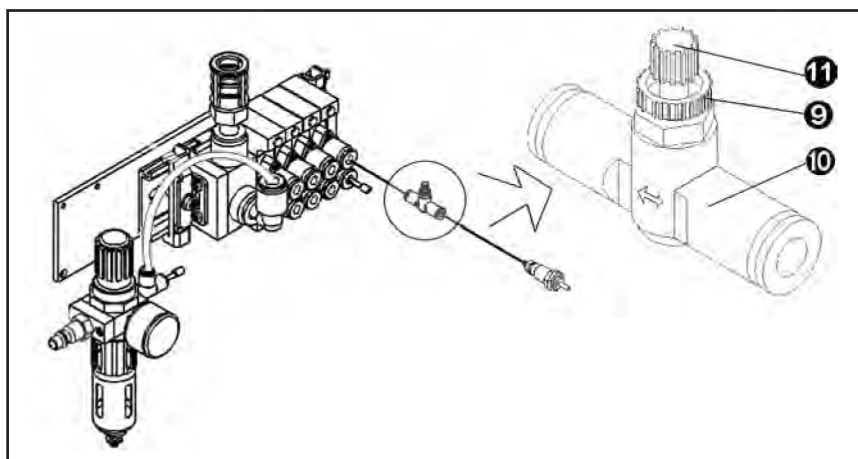
f. connect the air tube **6** to the cylinder, open the air supply and install the covers.



3. Regulation of the tension discs opening

If the last stitch is not tightened, follow the below mentioned steps:

- loosen the locking nut **9** on the speed controller **10**
- to obtain better tightening of the last stitch, tighten screw **11** and lock the nut **9** securely.

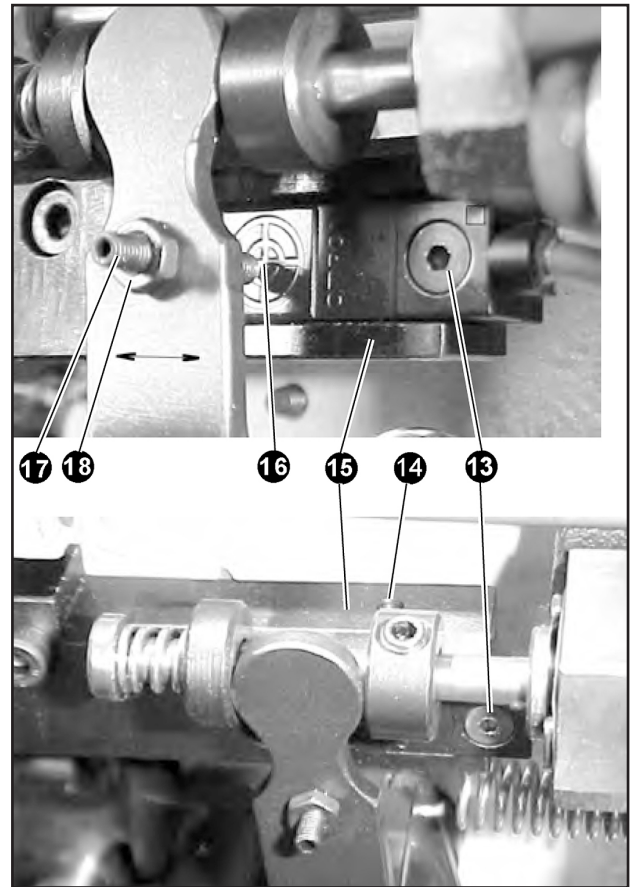


E - MACHINE ADJUSTMENTS

4 . *Barring Tension Release Sensor*

The tension discs opening is controlled by sensor. To ensure the correct function of the tension, it is necessary to adjust the sensor position.

- a. tilt the machine head onto the rest pin
- b. rotate the handwheel until the drive spring releases the left shifter arm detent. Feeding gears are disengaged.
- c. sensor **13** must be activated (the red LED lights) and the tension discs are open. If incorrect, follow the below mentioned steps:
 - loosen the set screw **14** of the sensor holder **15** and move the sensor so that the center of the sensor **16** is opposite the sensing screw **17**.
 - Tighten the set screw **14**
 - if the sensor will not activate, loosen the nut **18** and turn the screw **17** clockwise until the sensor is activated.
 - lock the screw **17** by nut **18**
- d. rotate the handwheel until the drive spring engages with the right shifter arm detent. Sensor must be deactivated. If incorrect, repeat the point c).
- e. check the adjustment for the second bar.
- f. return the machine head back to the operating position



5 . *Adjustments of the second tension*

The second tension influences the tension when the bars are sewn. It is common that the tension in the bar should be lower than the tension in the first and the second row of stitches.

If the tension in the bar is higher than the tension in the first and the second row of stitches, the first tension is not operating, which can cause:

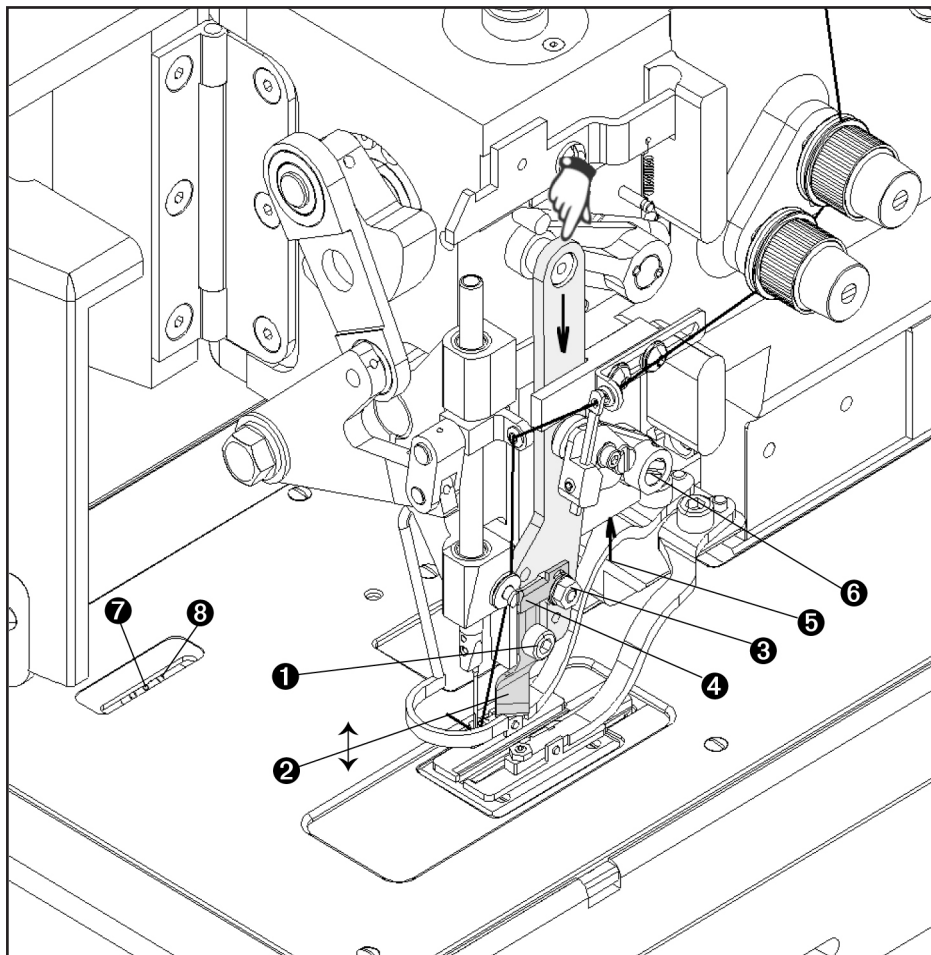
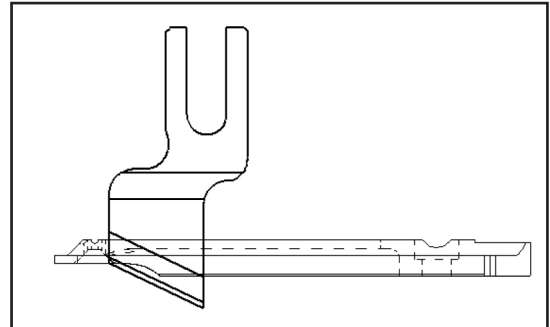
- stitches tightening or the fabric to bunch up during sewing
- short thread tail for sewing the next buttonhole. The next buttonhole will not be sewn at all or missing stitches appear at the beginning of the sewing.

E - MACHINE ADJUSTMENTS

15. KNIFE AND THE BUTTONHOLE LENGTH ADJUSTMENTS

1. Setting the knife depth

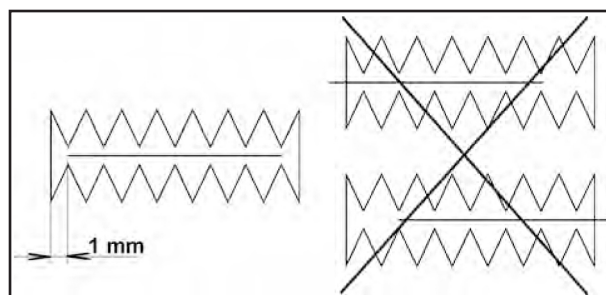
- a. Switch the air pressure off
- b. Manually press down on the knife lever
- c. Ensure the knife blade is aligned with the lower edge of the throat plate
- d. If incorrect, loosen the knife screw **1** and move the knife **2** as needed. Tighten the knife screw **1**
- e. Loosen the nut **3** and move the stop **4** to the knife. Tighten the nut **3**
- f. Switch the air pressure on



E - MACHINE ADJUSTMENTS

2. Setting the distance between the cutting space and the buttonhole edge

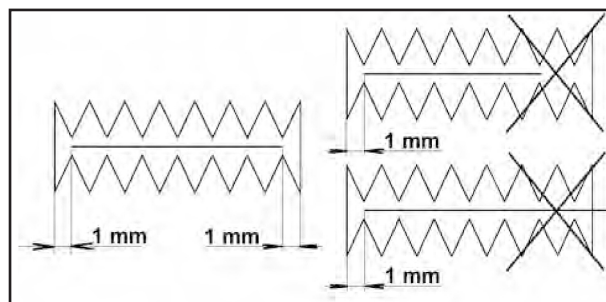
- a. Sew one buttonhole
- b. The correct distance between the cutting space and the inner side of a buttonhole is 1 mm. If incorrect:
 - loosen the screw **5** and turn the eccentric stud **6** to obtain the required distance. Tighten the screw **5**. Sew a few buttonholes to check the adjustments.



3. The buttonhole length adjustment

If the stitches in the first bar are cut or if the distance between the first bar and the cut is too big, follow the below mentioned steps:

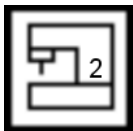
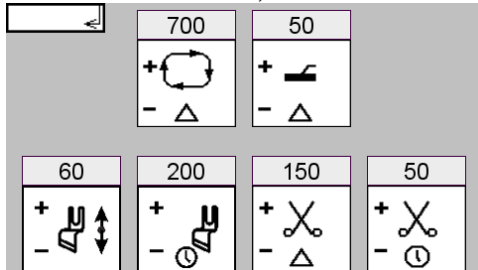


- loosen the screws **7** and move the stop **8** to obtain the correct appearance of a buttonhole. Tighten the screw **7**. Sew a few buttonholes to check the adjustment.



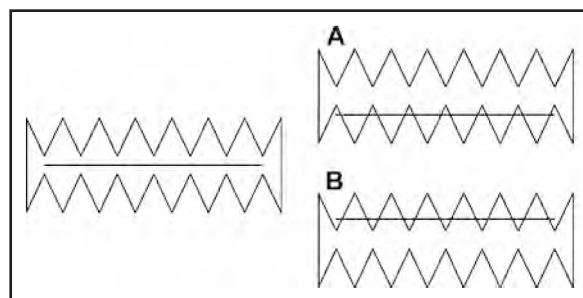
Note: When the knife is changed, the buttonhole length must be changed!

4. The knife cutting adjustment

If the first or the second row of stitches are cut, follow the below mentioned steps:

• press  key,  appears on the display. To enter the  press  appears on the display. To change the parameter value - see section D4.

- If the first row of stitches are cut - see picture **A** - decrease the value
- If the second row of stitches are cut - see picture **B** - increase the value
- If the cut will be too close to the stitches range, after using whole range of parameters, do as follows: see section E5 3.2 Bite adjustment in the throat plate and knife cut.



E - MACHINE ADJUSTMENTS

16. THREAD TRIMMING

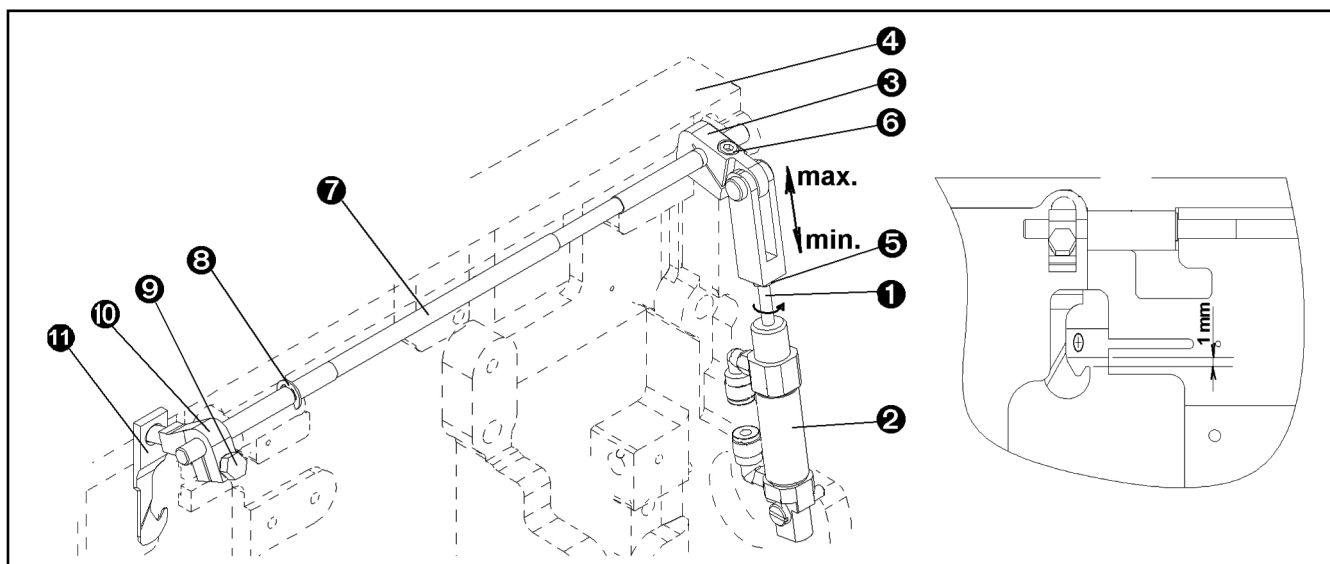
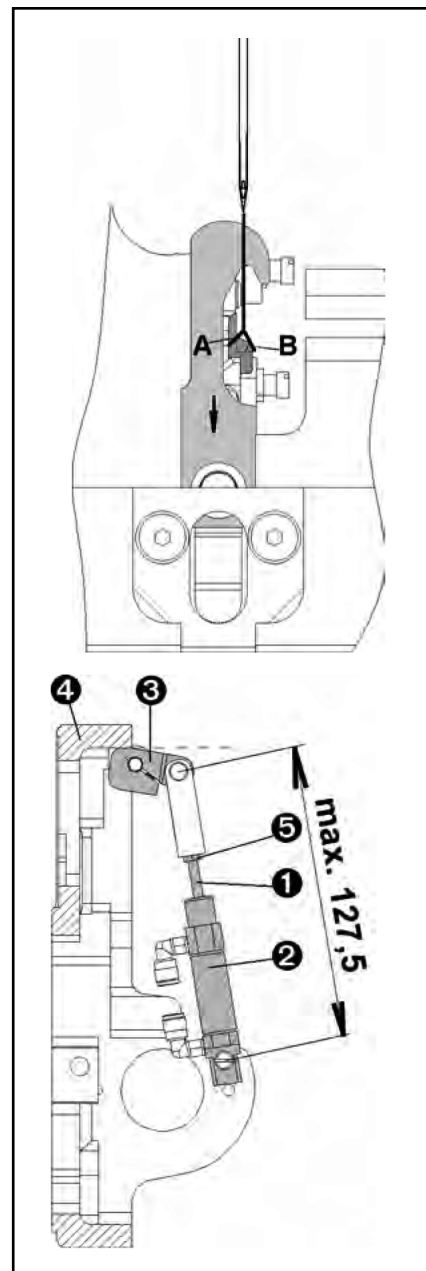
Trimming mechanism ensures the correct thread trimming after sewing the last stitch. A the trimming hook moves in the direction of arrow, both thread loop legs A and B are pulled forward. When the thread hook approaches the end of the stroke, leg A contact the trimming knife, cutting the thread.

1. Trimming cylinder adjustment

- tilt the machine head on the rest pin and close the air supply.
Extend the piston **1** of the cylinder **2** to the maximum position.
- check to be certain that the cylinder does not push the lever **3** too high and into contact with the bedplate casting **4**. If no clearance exists, adjust as described in c, d, and e below:
- loosen the screw **6**
- to obtain the correct position of the lever **3**, loosen the nut **5** and turn the cylinder piston **1** in or out as needed
- tighten the nut **5** and the screw **6**. After this adjustment check if no axial clearance exists on the shaft **7**.
- if the axial clearance exists on the shaft, loosen the screw **6**, move the shaft **7** to the left so that the locking ring **8** touches the recess in the plate **3**. Move the lever to the right and tighten the screw **6**.

2. The trimming hook **11** adjustment

- push the piston **1** of the trimming cylinder **2** to the maximal position and loosen the screw **9** of the trimming actuator **10**.
- turn the trimming actuator **10** and set the clearance 1.0 mm between the throat plate and the point of the trimming hook.
- tighten the screw **9** of the trimming actuator **10**.
- open the air supply and check by switching the valve of the trimming cylinder if the actuator **10** does not hit the bedplate casting



E - MACHINE ADJUSTMENTS

17. MACHINE HEAD CLAMP FEET ADJUSTMENT

1. Adjustment for clamp height

Be sure that air supply is switch on and the clamp feet are opened. If clamp feet are not opened, push the clamp Up / Down button.

- a. loosen the nut ❶
- b. turning the screw ❷ clockwise lowers the clamp feet mechanism ❸ to clamp mat ❹.
- c. tighten the nut ❶

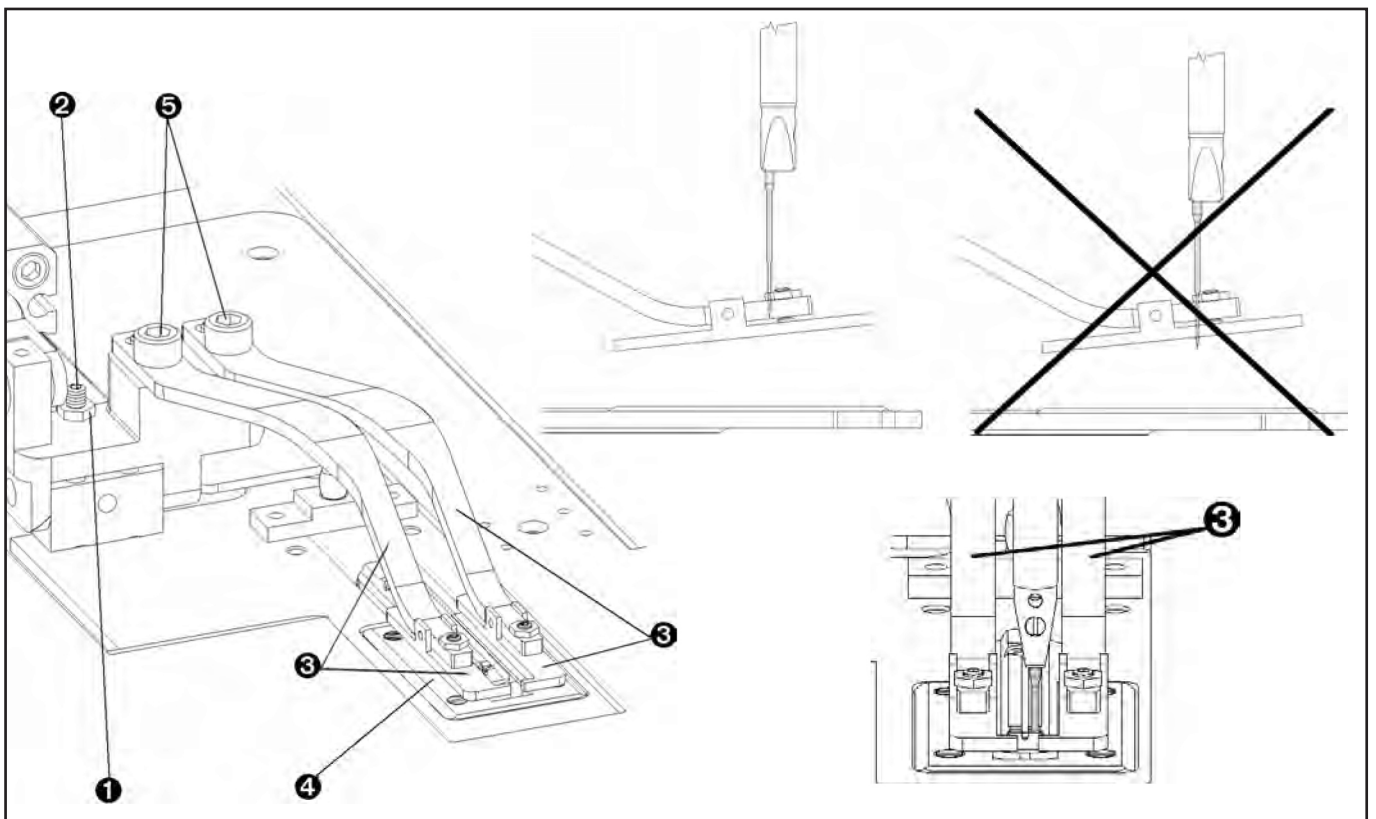
NOTE: Correct height is when the underside of the clamp feet are slightly lower than the point of the needle in the home position.

2. Adjustment of the distance between the clamp feet

Be sure that the clamp feet are closed. If clamp feet are not closed, push the clamp Up / Down button.

- a. turn the handwheel to be sure that needle does not hit the clamp feet ❸. If it hits:
- b. push the clamp up/down button to open the clamp feet
- c. loosen the screw ❺ and get the clamp feet arm further from the needle and tighten the screw ❺
- d. to check this adjustmet, turn the handwheel when the clamp feet are closed. The needle must not hit the clamp feet.

NOTE: Keep minimal distance between the needle bar and the clamp feet during this adjustment. Too big distance of the clamp feet can cause the missing stitches when sewing on thin and elastic fabrics.

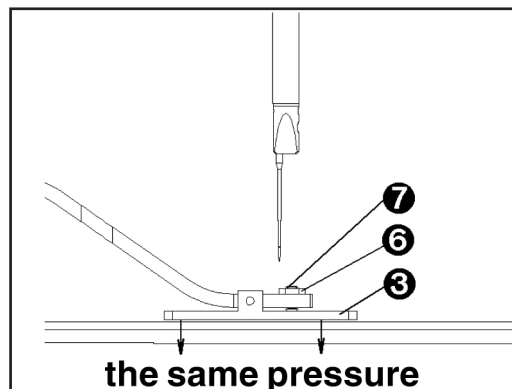


E - MACHINE ADJUSTMENTS

3. Clamp feet pressure adjustment

The whole length of the clamp feet must hold the sewn work with the same pressure.

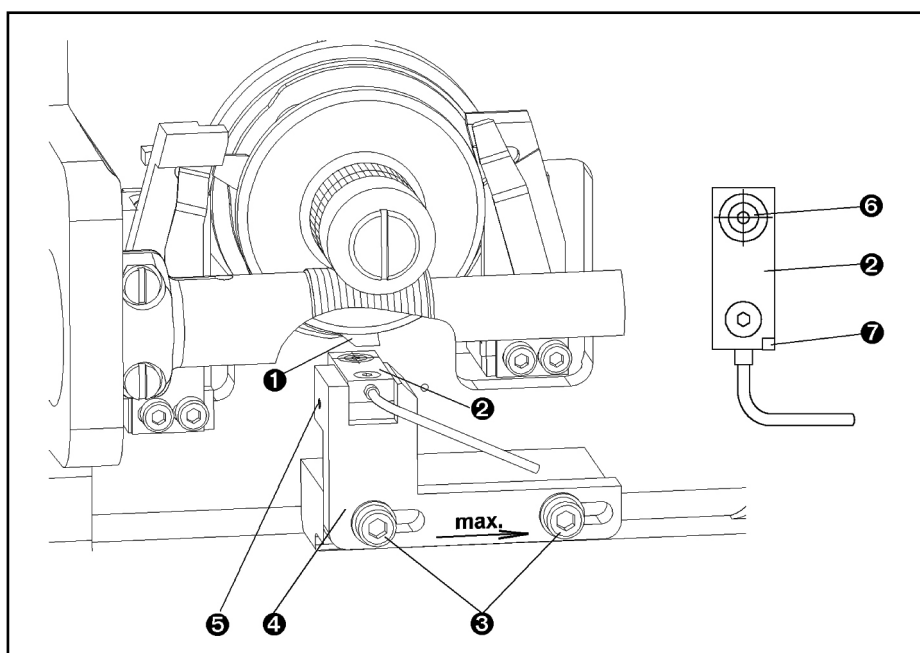
- a. Push the clamp up/down button to close the clamp feet **3**.
- b. To adjust the clamp feet to the correct position, loosen the nut **6** and turn the screw **7**.
- c. Tighten the nut **6**.



18. ADJUSTMENT OF THE STOPPING SENSOR POSITION

Follow the below described steps to set the position of the sensor.

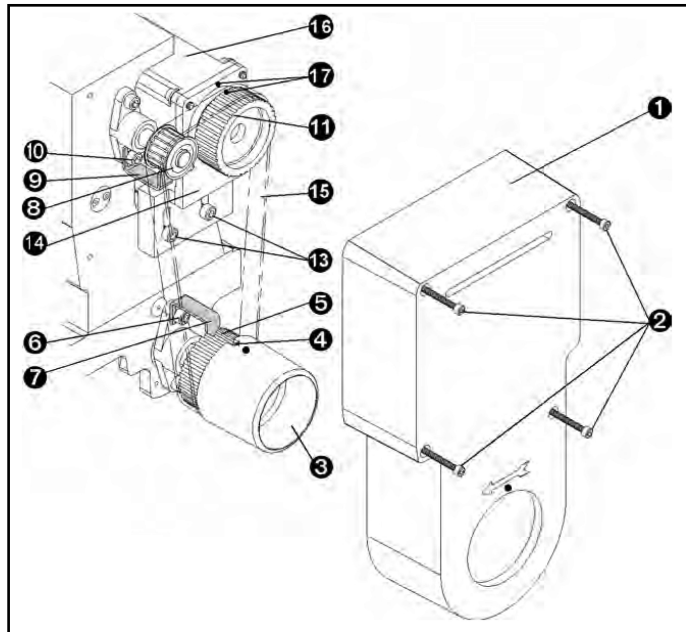
1. Put machine in the service mode (see E-3).
2. Turn the handwheel counter clockwise until the machine is in the position for sewing the second bar.
The stop disk finger **1** must be perpendicular to the sensor **2**.
3. Loosen the screws **3** and move the sensor bracket **4** to the right. Tighten the screws **3**.
4. Loosen M3 screw **5** and adjust the sensor position so that the stop disk finger **1** is in the center of the sensor mark **6**. The red LED **7** lights up on the sensor.
5. Tighten the M3 screw **5**.
6. Return the machine head back to the working position.
7. Push the F6 key on the control panel and switch the machine to the working mode.
8. Connect the air tubes with the indexer clamp feet. Open the air supply.
9. Start the machine and check the correct stopping of the machine. The needle bar must stop in the home (upper) position.



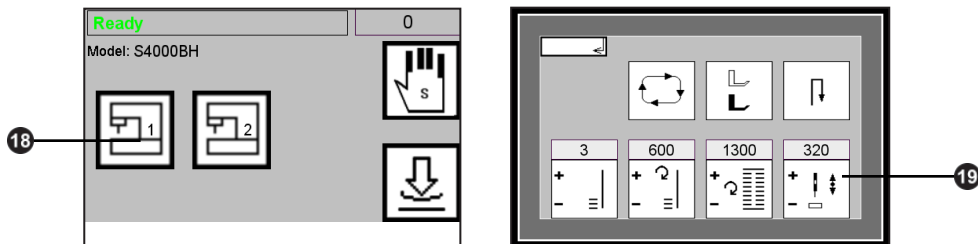
E - MACHINE ADJUSTMENTS

19. CHANGING THE DRIVE BELT

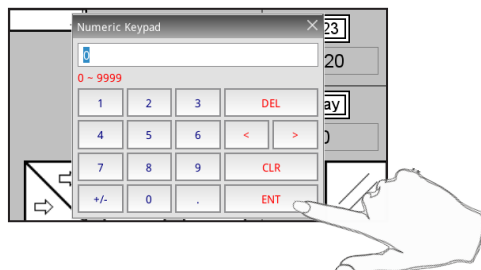
1. Remove the pulley cover **1** after loosening the M4 screws **2**.
2. By turning the hand wheel **3** adjust the position of the shaft so that the screw **4** on the pulley **5** is level with screw **6** on the bearing carrier lower shaft.
3. Lock the position by the holder 24.0030.0.000 **7**, which is included in the accessories. Using the screw **6** fix the holder to the bearing holder upper screw.
4. Turn the pulley **8** of the needle bar shaft, until the needle bar reaches the upper position.
5. Lock the position by the holder 24.0024.0.000 **9**, which is included in the accessories. Using the screw **10** fix the holder to the bearing carrier lower mounting screw.
6. Rotate the motor pulley **11** until the marks **17** on the motor pulley and the motor bracket are aligned.
7. Loosen the screws **13** on the motor bracket **14** and move the motor with the machine bracket down to fit the belt.
8. Fit the belt **15** on the shaft pulleys **5**, **8** and motor pulley **11**. To tighten the belt **15**, move the motor bracket **14** with motor **16** up. Tighten the screws **13** to lock the motor bracket. Be sure the marks **17** are aligned.
9. Remove the pulley holders **7**, **9**.
10. Press the pedal to check the adjustment. The needle bar must be in the upper position.
11. Small changes of the needle bar adjustment are possible in the program parameters:





- a) needle bar just before top dead centre
- **18** press => **19** „Ndl up posimp“



- increase the value to reach correct position of the needle bar



- press , to go back to the operation mode

- b) needle bar behind top dead centre
- reduce the value to reach correct position of the needle bar
- press , to go back to the operation mode

F - MAINTENANCE

- Warning:**
- Check for damage to electrical cables
 - Check safety covers for damage and replace if needed immediately
 - Keep your hands out of the sewing area
 - Do not modify the machine in any way, which could eliminate safety parts
 - Do not attach external lights or other devices to the machine's electrical system

- Caution:**
- Do not neglect periodic maintenance.
 - If you have fault in electrical power supply, switch off the operating switch (circuit breaker).
 - Do not damage, correct and remove safety labels.
 - Do not work with the machine when you are under the influence of the drugs or alcohol.
 - User has to ensure the lighting of the working area minimal 750 Luxes.

1. MACHINE CLEANING AND MAINTENANCE

1. Switch the power off and disconnect air supply.

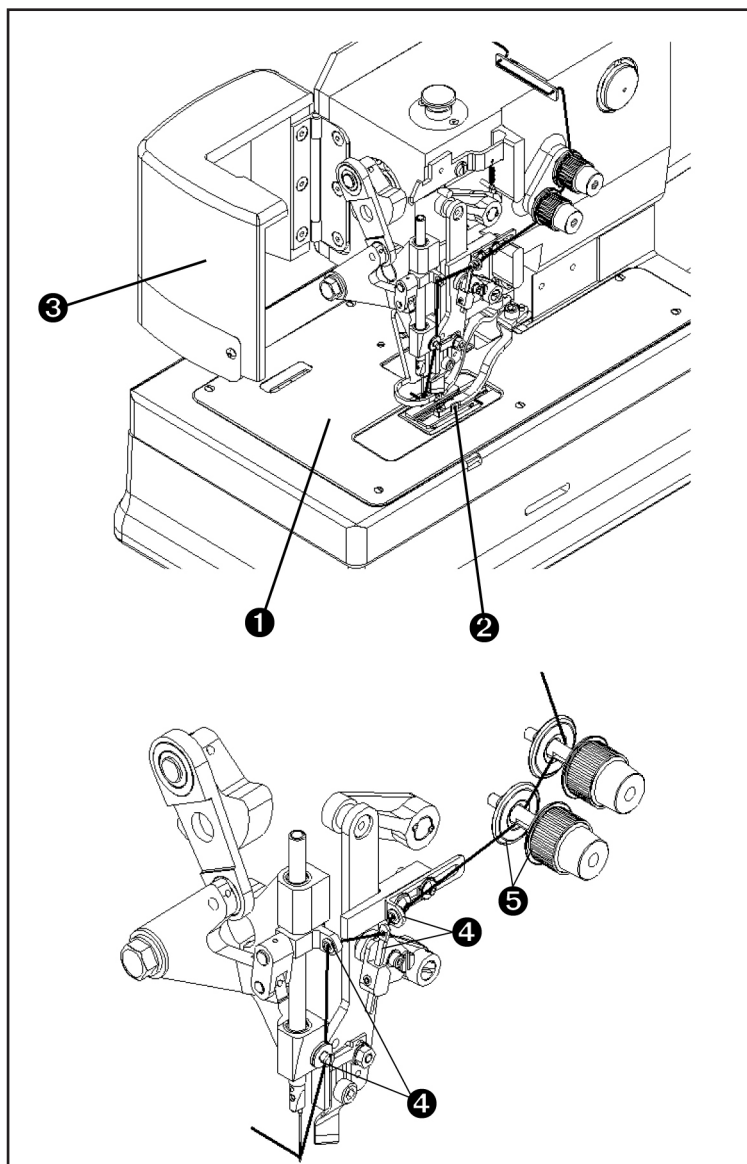
2. For cleaning and oiling, remove the cover **1** and take out the clamp feet mechanism **2**.

Clean the clamping area from the fabric and thread lints.

3. Open the needle bar cover **3** and clean the thread lints from the guides **4** and thread tension **5**.

4. Using the air flow, clean the thread lints and fabric from the sewing area - throat plate, loopers.

5. Lubricate the machine according to the section G 4.

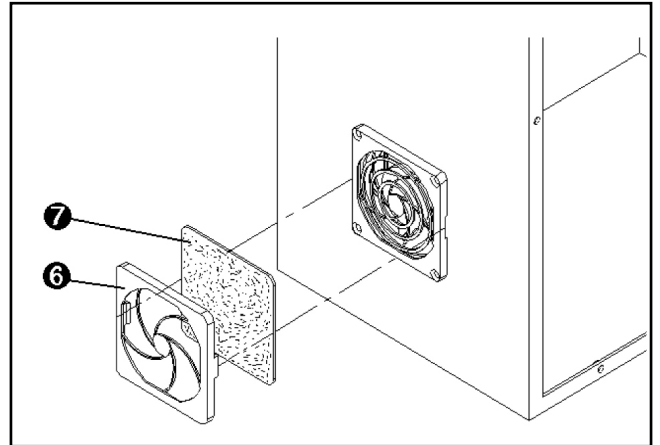


F - MAINTENANCE

6. Remove the filter cover **6** with cleaning pad **7**.
Remove the dust from the cleaning pad or in case of considerable dirt, wash it using a mild detergent.
Perform the same cleaning on the rear fan.

7. The filter and regulator maintenance
Bowl assembly - polycarbonate bowls may be damaged and possibly fail if exposed to synthetic oils, thinner solvents, trichlorethylene, kerosene and other aromatic hydrocarbons. Clean only with a neutral detergent .

Auto drain - Drain line length should be shorter than 5 m. Be sure not to have any upward turns in the drain line which would prevent drainage.



If the unit has no function it is necessary to:

- check if the supplied pressure is higher than the set pressure of the regulator
- check if the valve assembly is clean
- check the membrane or spring because of damage
- check if the air flow direction is correct

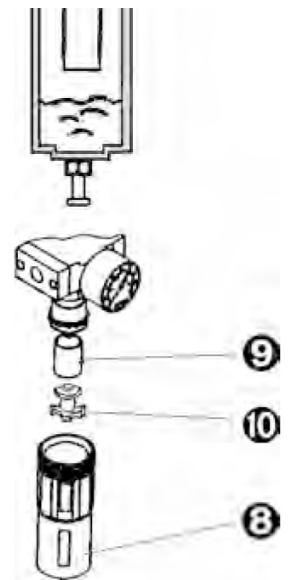
Change of the filter element

Conditions

- low flow rate
- high pressure drop
- when the pressure drops to 0.7 bar
- filter element change after one year (in case it has not been changed)

- unscrew the polycarbonate bowl **8**
- take the filter element out **9** with baffle **10**
- change old filter element with new one
- fit the baffle **10** into new filter element **9** and place them both back
- place the polycarbonate bowl back

8. Check the mechanisms especially in the sewing area by sight.



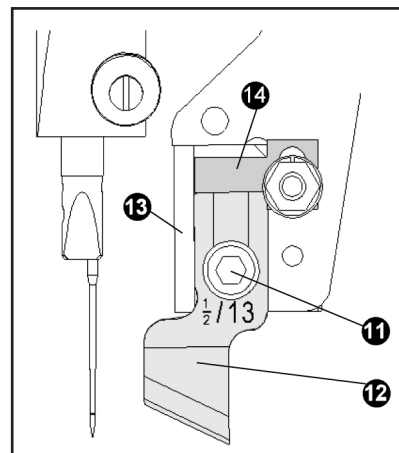
F - MAINTENANCE

9. Knife maintenance

Inspect the knife and cut, if the knife is bent, damaged, or dull, replace or sharpen as needed.

To change:

- a. loosen the screw ⑪ and remove the knife ⑫
 - b. replace or sharpen the knife
 - c. insert the new knife into the slot ⑬ and move it fully up to the stop ⑭.
Tighten the knife holder screw ⑪. Installation is correct when the knife size number is facing the operator. If incorrect, reverse the knife.
 - d. disconnect the air supply and ensure the knife blade goes through the slot in the center of the throat plate. Connect the air supply.
10. When the maintenance and checking are finished, insert the clamp feet mechanism into the machine.



2. PERIODIC MAINTENANCE

once a day (8 hours of operation)

- cleaning of the sewing mechanism area and inner frame of the machine
- lubrication of mechanisms - see area F4.

once a week (40 hours of operation)

- visual check - external and internal mechanisms
- fill oil into reservoir with oil level indicator, or sooner if required

once a month (160 hours of operation)

- check of the clearance in sewing mechanism drive
- check of the screw connections tightening (obtain values below)
- check of condensate in regulator
- check of dirty of cleaning pads in control box

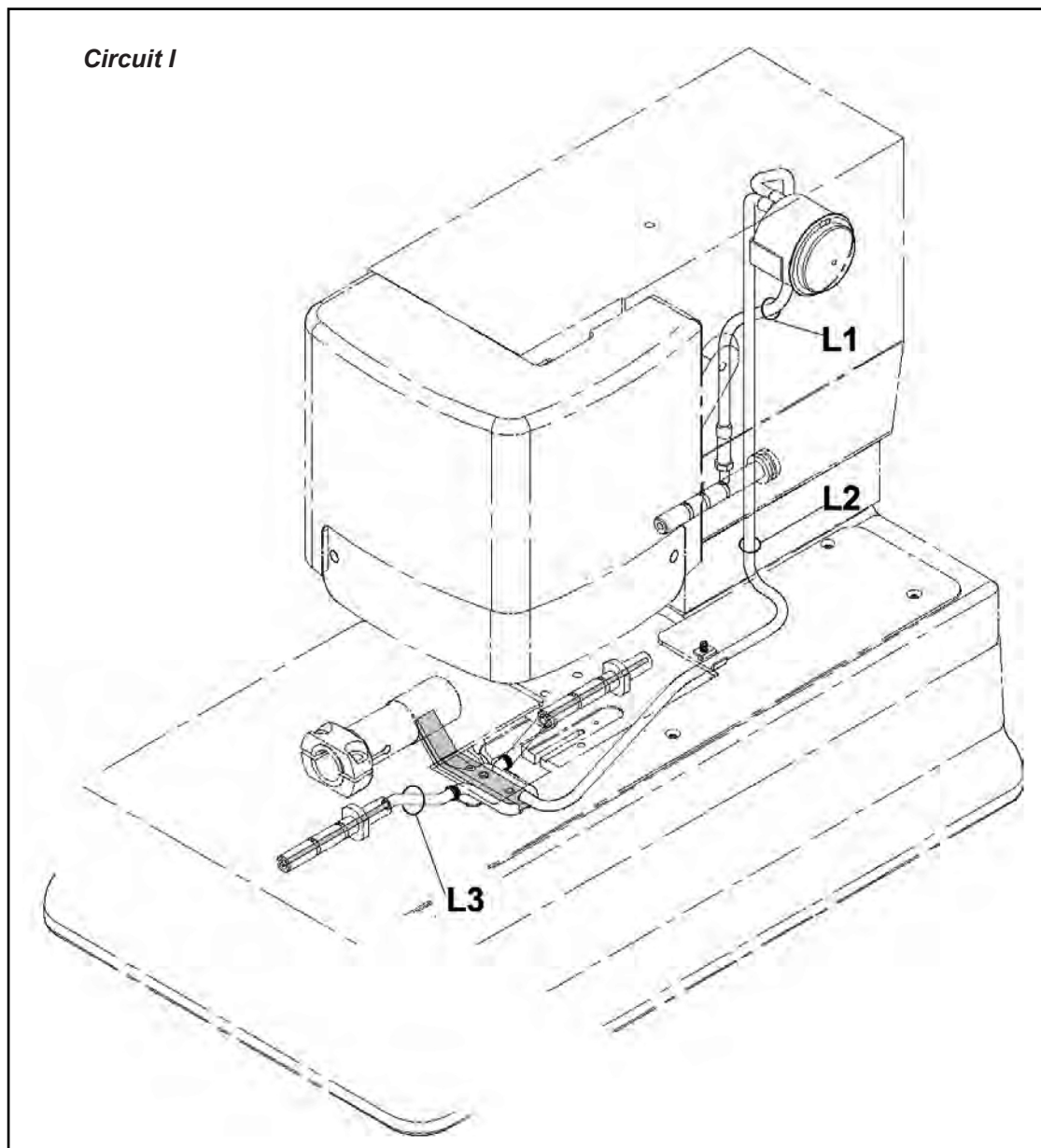
Recommended values for screws (Nm):			
M3	0,5	0,6	0,8
M4	1,2	1,5	2,0
M5	2,5	3,0	4,0
M6	4,0	5,0	7,0
M8		8,0	16,0
M10		10,0	30,0

F - MAINTENANCE

3. LUBRICATION DIAGRAM

The machine is mainly equipped with needle and ball bearings, which in combination with single lubrication circuit decrease the requirements for maintenance.

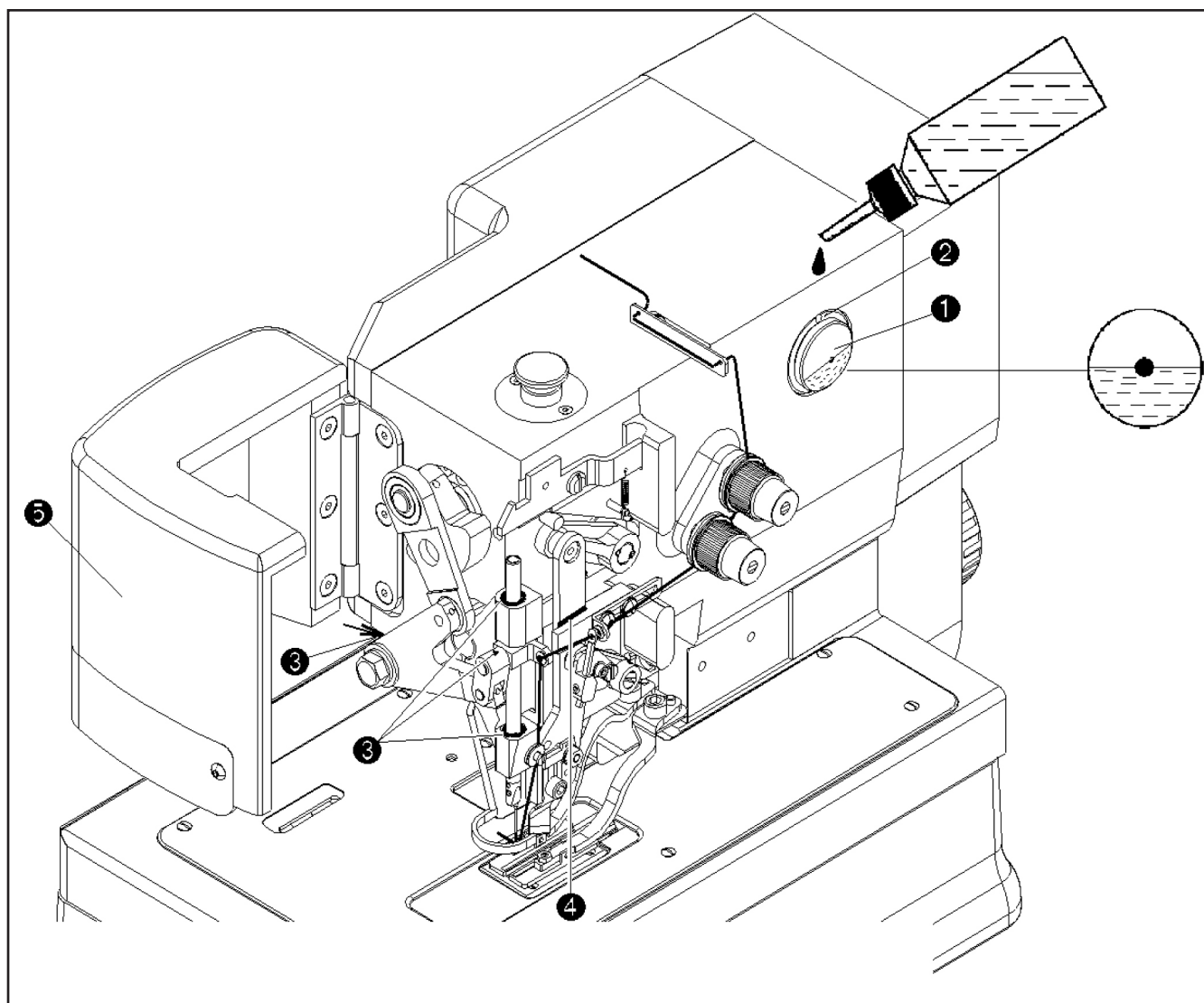
Circuit I - with the oil supply in oil indicator for lubrication of the bite, feeding and looper levers and worm gears. In case of replacement of any part of distribution, it is possible to order the tube kits and wicks. To connect the tubes - see picture.



F - MAINTENANCE

4. MACHINE LUBRICATION

1. It is necessary to lubricate the places shown below before the machine is switched on for the first time or after a long idle period. Use oil ESSO TERESSO 32 or similar quality.
2. The amount of oil in the reservoir **1** is indicated by the red mark. Too much oil may cause its overflowing from the base area.
3. The reservoir is fitted through the hole **2** in front of the gage.
4. The points for lubrication of the needle bar mechanism **3** and draw-off mechanism **4** are shown in the illustration below (after opening the needle bar cover **5**). Lubricate the main cam worm gear through the hole **6**. Lubricate all of these points every 8 hours.



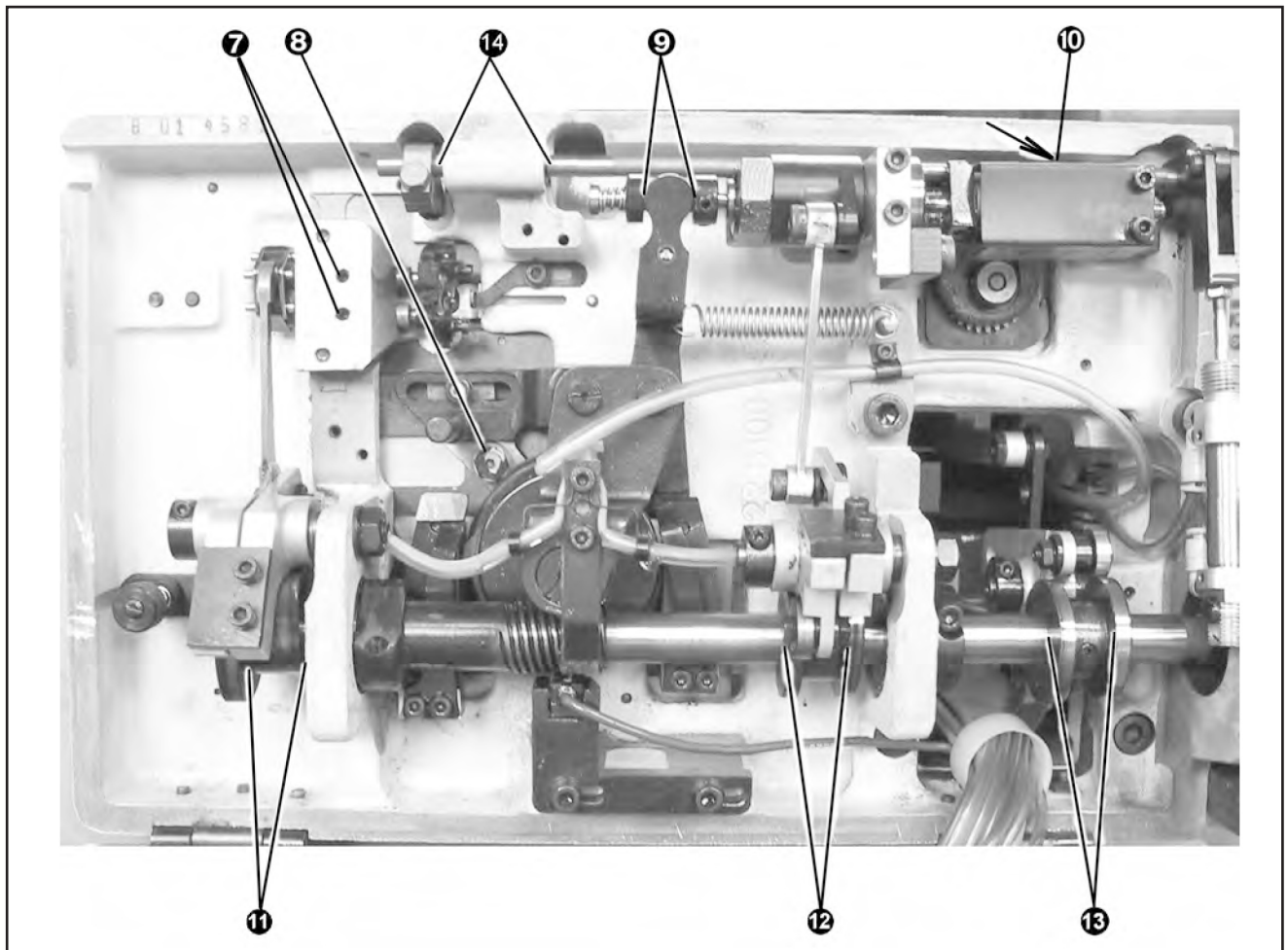
F - MAINTENANCE

5. Tilt the machine head on the rest pin and lubricate the places shown in the picture.

- ⑦ looper shafts
- ⑧ roller
- ⑨ shifter
- ⑩ bevel gears
- ⑪ looper cam surfaces
- ⑫ feed cam surfaces
- ⑬ bite cam surfaces
- ⑭ trimmer shaft

Tilt the sewing head back into the sewing position.

6. After lubrication it is important to sew minimum 10 buttonholes on scrap fabric to dispel any excess oil. Wipe all visible excess oil from the mechanism in the work area.



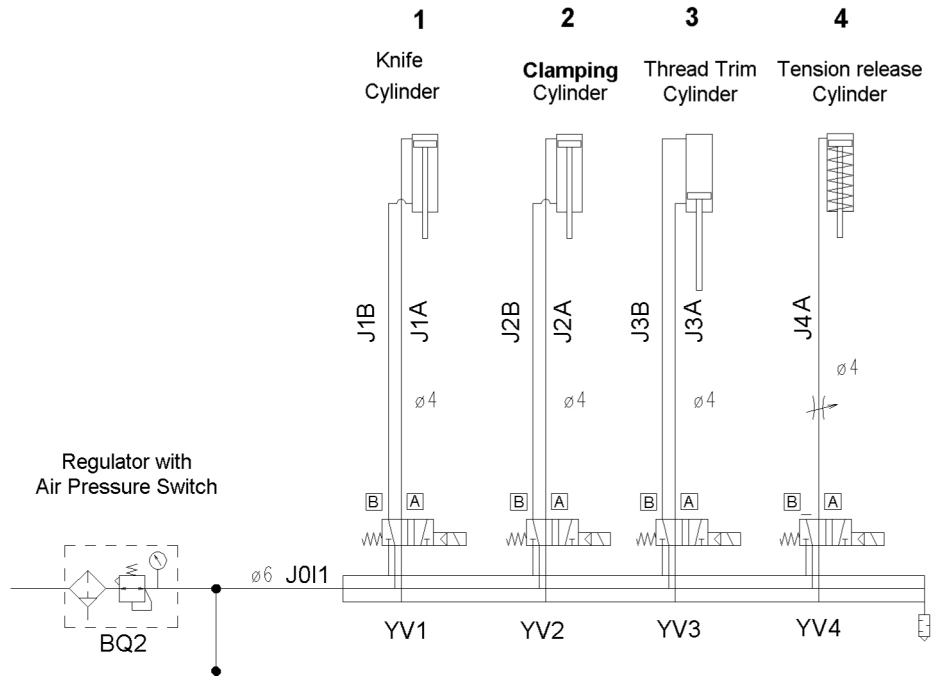
F - MAINTENANCE

5. MACHINE DISPOSAL

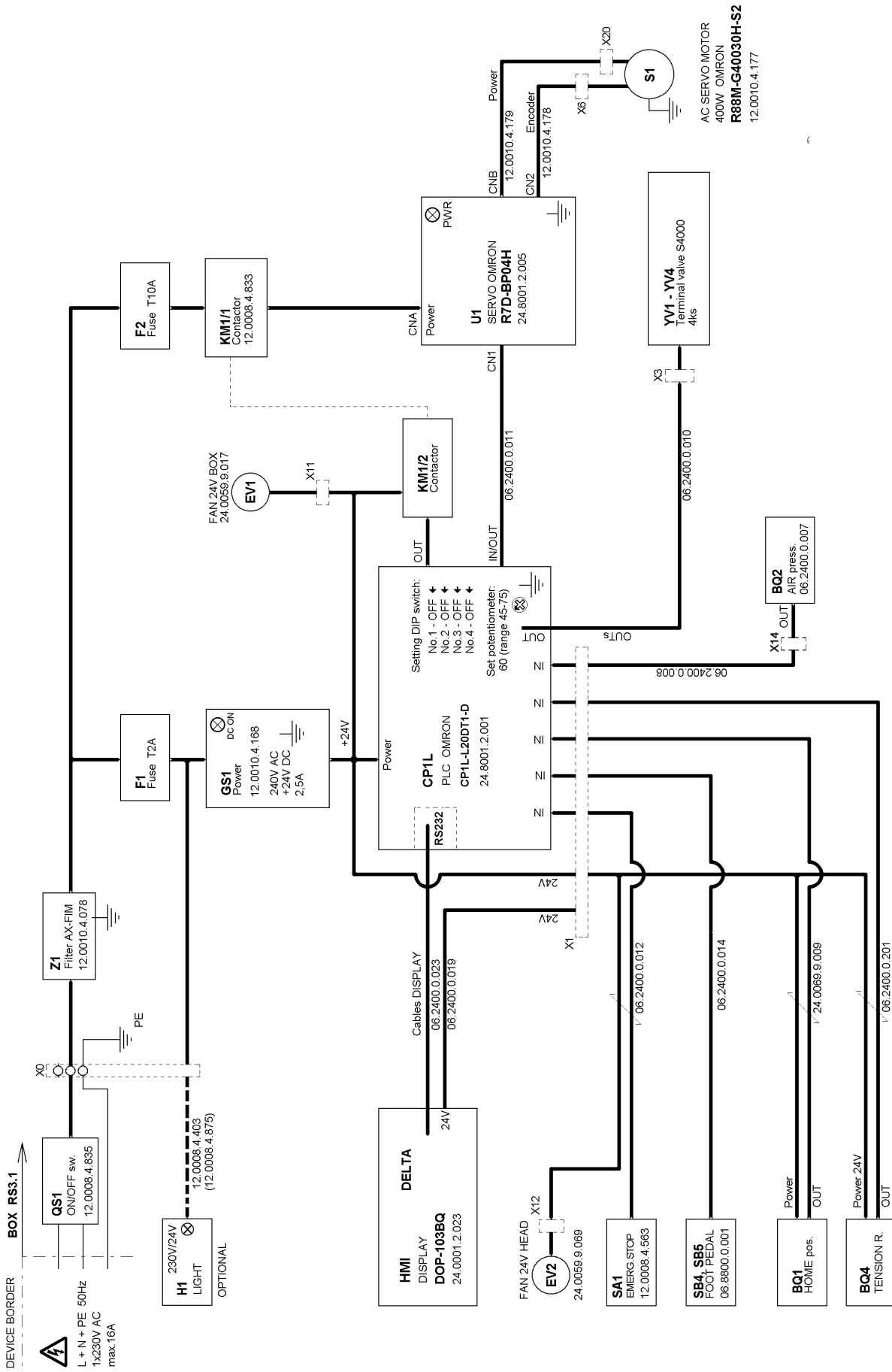
1. To ensure machine ecological disposal, it is necessary to remove nonmetallic parts from the machine.
To take these parts out, it is necessary to perform the partial dismantling of the machine, remove covers, dismantle the machine arm and remove the frame.
2. Aluminium and diralumin parts must be treated separately, also nonferrous metal parts and plastic parts.
3. Parts mentioned in point 2 can be found in the spare parts manual with these marks:

- aluminium parts
- ● non-ferrous metal parts
- ● ● plastic and non-metalic parts

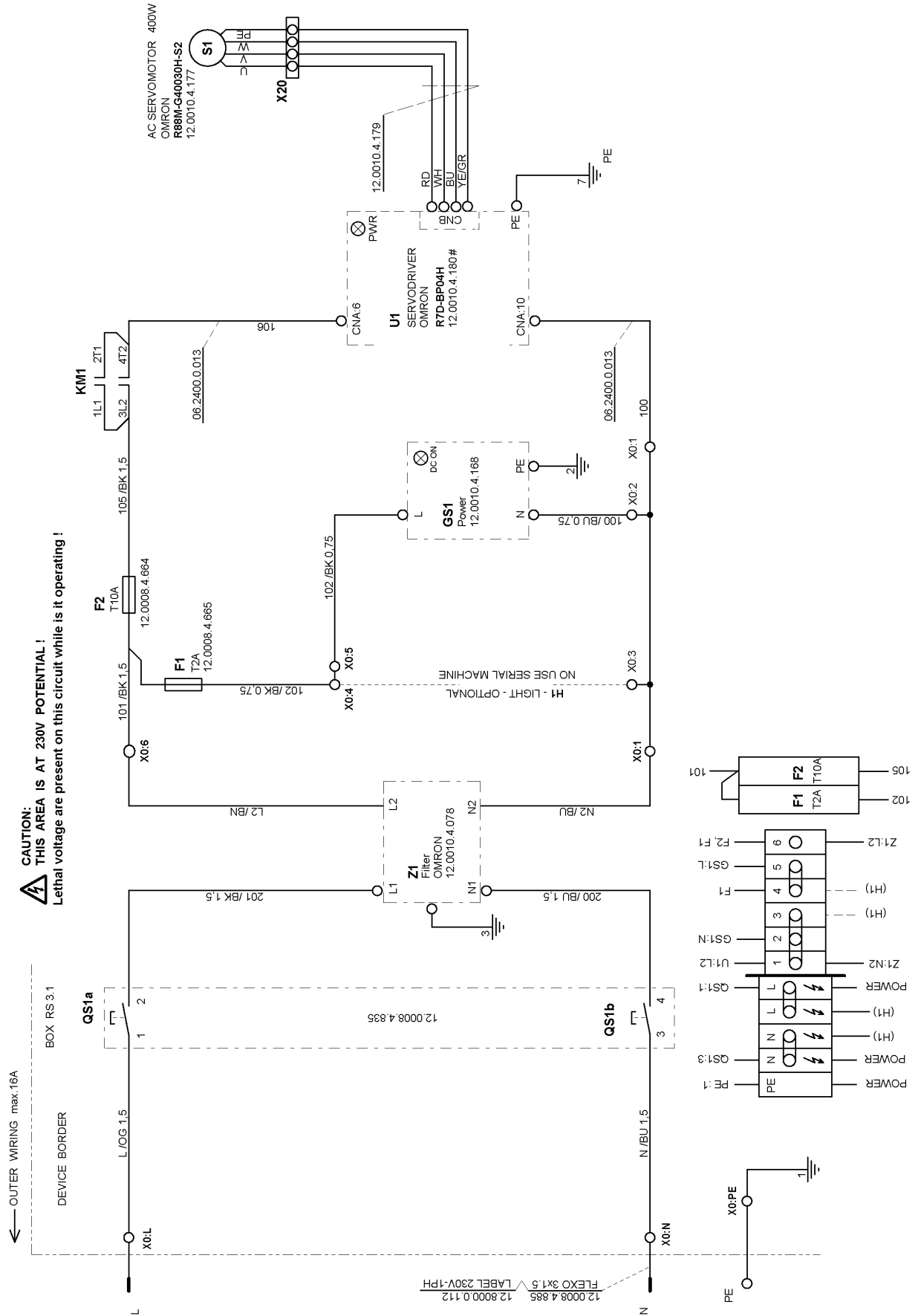
G - PNEUMATIC DIAGRAM



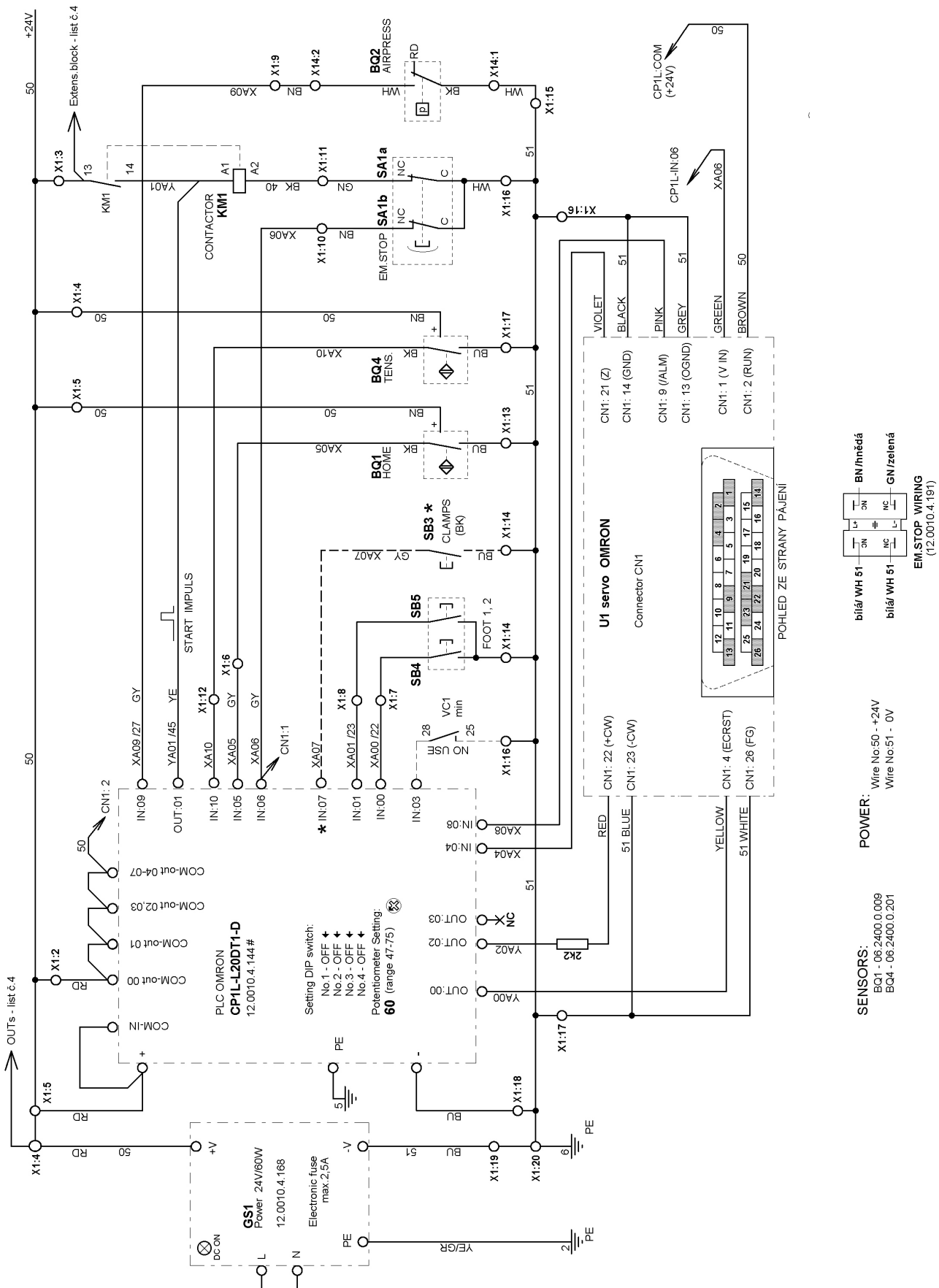
H - ELECTRICAL DIAGRAM



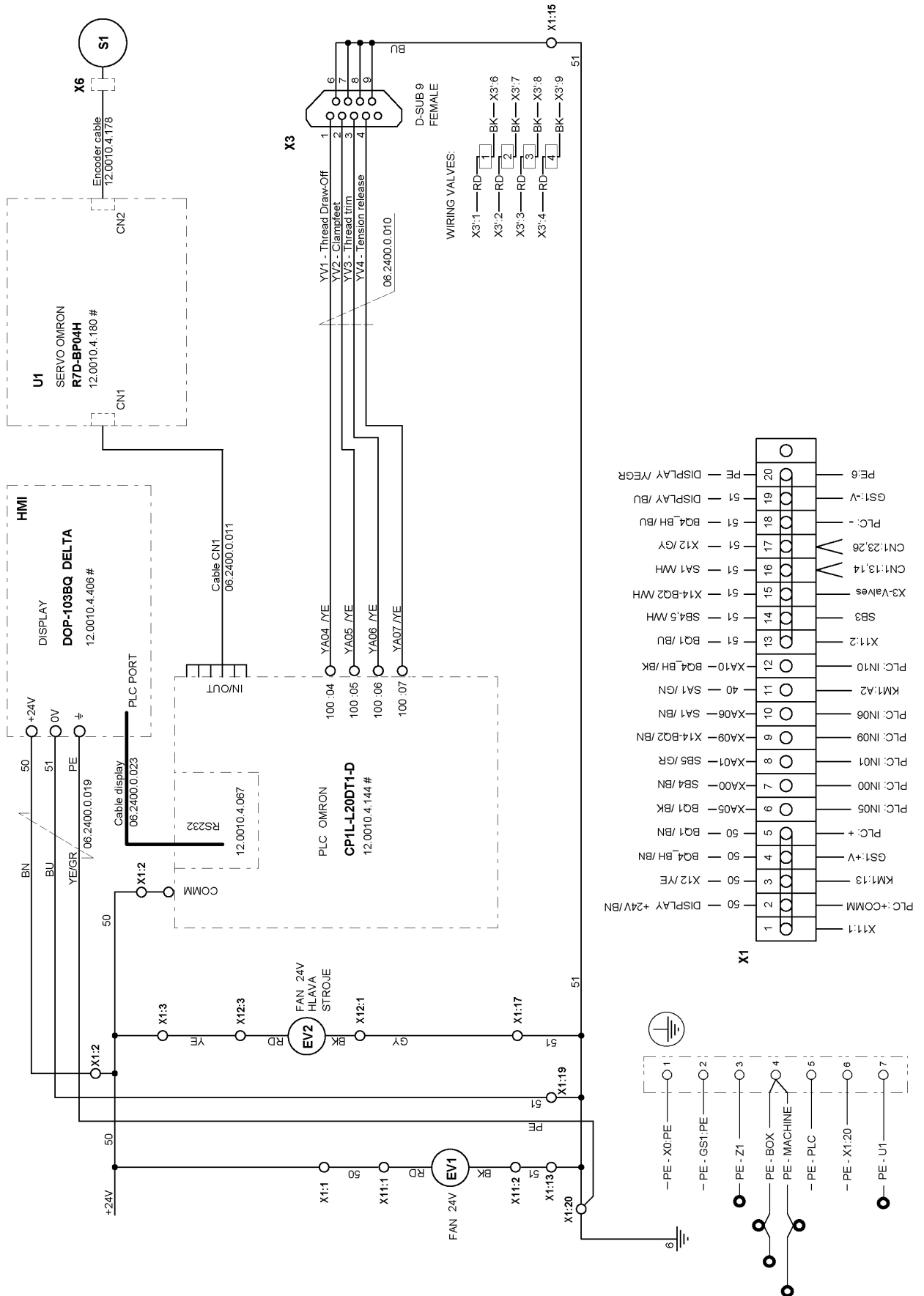
H - ELECTRICAL DIAGRAM



H - ELECTRICAL DIAGRAM



H - ELECTRICAL DIAGRAM



H - ELECTRICAL DIAGRAM

TROUBLESHOOTING

1. MECHANICAL FAULTS.....	2-2
2. CONTROL PANEL DISPLAY ERROR MESSAGES	2-4
3. SERVO ERROR MESSAGES	2-5
4. ELECTRICAL FAULTS	2-6

TROUBLESHOOTING

1. MECHANICAL FAULTS

SYMPTOM	POSSIBLE CAUSE	PROBABLE SOLUTION
Thread breakage	Needle, looper, throat plate damaged	Change damaged parts
	Incorrect needle and sewing mechanism adjustment	Check the adjustment of the mechanisms
	Thread tension is too tight	Adjust correct tension
	Incorrect threading	See section C3 for checking
	Thread guides polished incorrectly	Polish
	Poor thread quality	Replace thread
	Thread is too heavy for selected needle and throat plate	Use recommended thread sizes - see section A4
Machine fails to sew	Needle, looper, throat plate damaged	Change damaged parts
	Incorrectly adjusted needle bar height	See section E4 for checking
	Incorrectly adjusted clearance between needle and throat plate	See section E5 for checking
	Incorrect loopers timing	See section E9 for checking
Machine sews in one spot	Incorrectly adjusted the home position of the clamp plate	Adjust the stop - see section E11
Stitch skip at the beginning of sewing	Needle, looper, throat plate damaged	Change damaged parts
	Needle thread end is too short	See section E13, point 2
	Incorrectly adjusted needle bar height	See section E4
	Incorrectly adjusted clearance between needle and throat plate	See section E5
	Incorrect loopers timing	See section E9
	Incorrectly adjusted clamp feet pressure	See section E 17, point 3
	Incorrectly adjusted the home position of the clamp plate	See section E11

TROUBLESHOOTING

SYMPTOM	POSSIBLE CAUSE	PROBABLE SOLUTION
Stitch skip during sewing	Needle, looper, throat plate damaged	Change damaged parts
	Incorrectly adjusted needle bar height	See section E4
	Incorrectly adjusted clearance between needle and throat plate	See section E5
	Incorrect loopers timing	See section E9
	Incorrect thread tension adjustment	Adjust the tension correctly
	Incorrect threading	See section C3
	Thread loops are too small	See section E13 point 3
	Incorrectly adjusted clamp feet pressure	See section E17 point 3
	The clamp feet are adjusted too far from the sewing	See section E17 point 2
Thread not trimmed at the end of the cycle	Trimming knife damaged	Replace
	Low air pressure at trimming cylinder	Check supply pressure
	Flow control valve to tension cylinder closed	See section E14 point 3
	Incorrect loopers timing	See section E9
	Incorrect setting of trimming delay	Change Trim delay parameter - D4
	Trimming length incorrectly set	Change Trim time parameter - D4
Sewing motor turns, machine does not sew	Belt broken or loose	See section E19 for changing
Machine sews continually, does not stop	Stopping sensor adjusted incorrectly	See section E18 for correct position adjustment
Zero pressure on regulator	Shut off valve closed regulator	Open the shut off valve
Low air pressure	Filter element dirty	Change the filter element
	Air fitting or tubing obstruction	Check supply guides

TROUBLESHOOTING

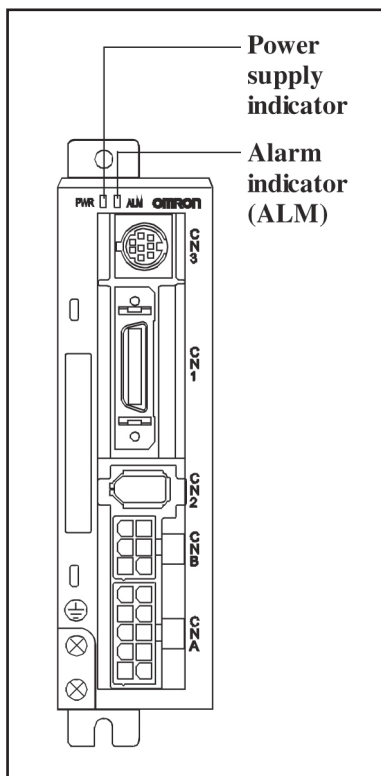
2. ERROR MESSAGES OF THE CONTROL PANEL DISPLAY

SYMPTOM	POSSIBLE CAUSE	PROBABLE SOLUTION
Low air pressure	Hand valve of the regulator switched off-it assembled	Open the hand valve
	The air pressure in the air supply piping below 5 MPa	Increase the air pressure
Emergency stop	Emergency Stop button is switched on	Release the Emergency Stop button and press F6 key on the control panel
Service mode	The machine is in the operation mode, motor is disconnected	Press F6 key on the control panel
Low voltage	The power supply is below 185V - relay HRN-35 is installed	Call electroengineer in a plant
Motor isn't ready	The power supply is below 185V - relay HRN-35 is not installed	Call electroengineer in a plant

TROUBLESHOOTING

3. ERROR MESSAGES OF THE SERVO

The following messages can be seen on the servo display, which is placed inside the control box. In order to eliminate these messages, switch off the machine for 5 minutes. Then switch the machine on again. The error message should not appear on the display. If the message appears - call AMF Reece service.



PWR - Power supply indication:



INDICATOR	STATUS
Lit green	Voltage is good
Lit orange - Flashes at a 1 sec. intervals	Varning - i.e.: - Exceeded power - Exceeded feed back - Default of inner fan
Lit red	Alarm - default

ALM - Default indication (Alarm indicator):

in case default appears, the indicator is switched on.

TROUBLESHOOTING

4. ELECTRICAL FAULTS

SYMPTOM	POSSIBLE CAUSE	PROBABLE SOLUTION
 <p>When switch in position I, neither the work light, display or the cooling fan operate</p>	No power supply	Check main power supply or voltage in the socket
	Fuse F1 failure	Replace fuse PN 12.0008.4.665
	Power switch QS1 damaged	Replace the switch 12.0008.4.835
	Power GS1 failure	Replace the power 12.0010.4.168
	The supply voltage is above 255 V - relay VC1 installed	Call electroengineer in the plant
	Relay VC1 failure	Replace the relay 12.0008.4.690
	Damaged Z1 filter	Replace the filter 12.0010.4.078
 <p>When switch in position I, display does not operate</p>	Cable from the display disconnected	Check the display connection
	Display or its control damaged	Replace display PN 24.8001.0.002
<p>When sewing operation started, motor does not operate. Contactor KM1 switched on.</p>	Fuse F1 damaged	Replace fuse 12.0008.4.664
	Contactor KM1 damaged	Replace contactor 12.0008.4.833
	Servo U1 error or filter Z2 error	Call AMF Reece service or replace servo U1 24.8001.2.005
	Error in sewing motor circuit	Switch the machine off for 1 minute, or restart it, alternatively call AMF Reece service
When the machine is switched on, incorrect type of the machine appear on the display (example: S4000 BH instead of S4000 ISBH, TKF, LS)	The PLC incorrectly set	Set the potentiometer on the PLC according to the electrical diagram - see service section, section H)
<p>When sewing operation started, motor fails to operate. Contactor KM1 switched off.</p>	Make sure the machine is ready for operation	Press key F6 - see D1, point 6
	Contactor KM1 damaged	Replace contactor 12.0008.4.833
	Check the Emergency Stop button	Replace button 12.0008.4.563
	Control unit PLC error	Replace the control unit PLC 24.8001.0.001

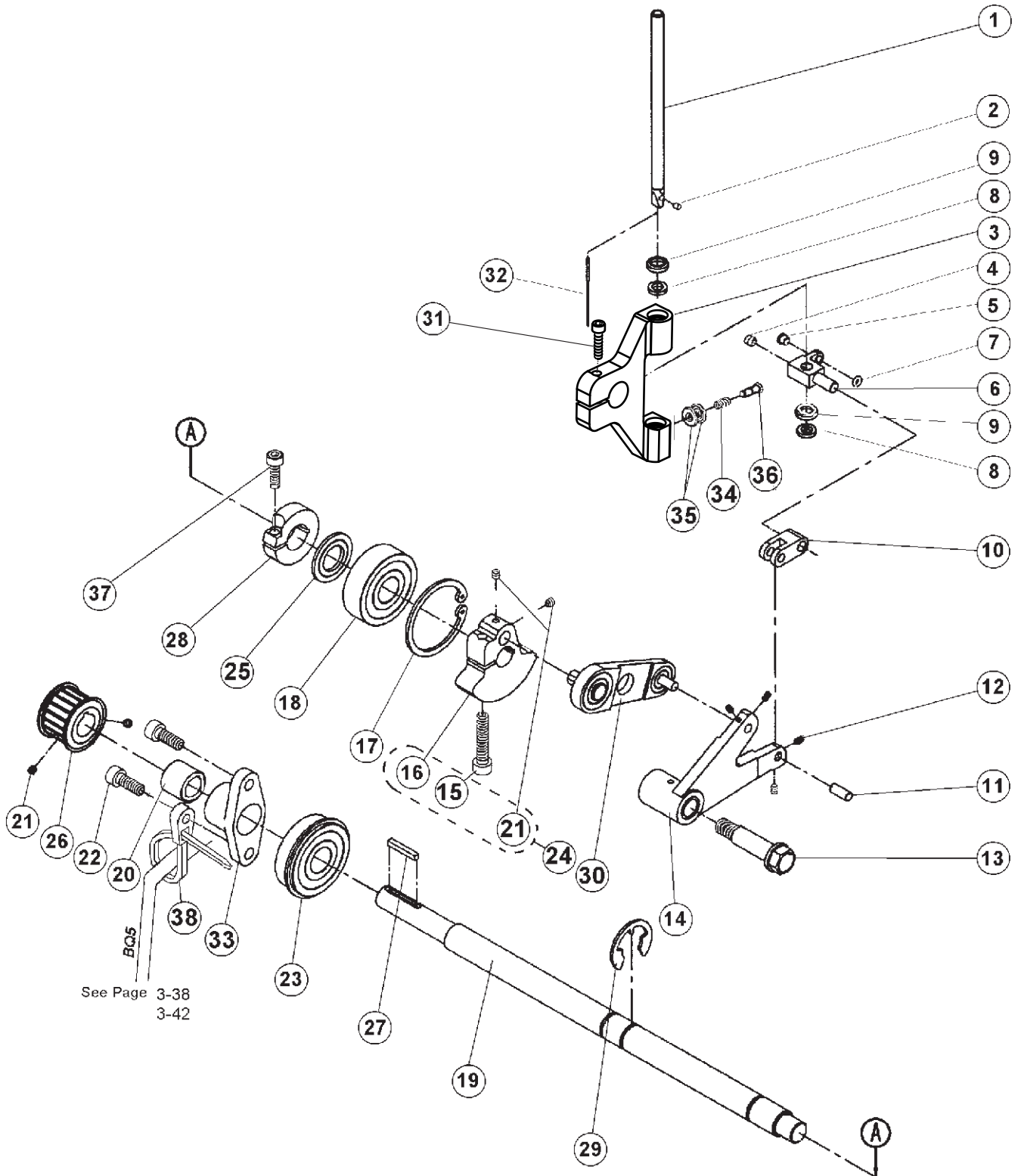
TROUBLESHOOTING

SYMPTOM	POSSIBLE CAUSE	PROBABLE SOLUTION
The needle does not stop in the upper position	Position of the sensor BQ1 incorrectly adjusted	Adjust according to section E17
	Sensor BQ1 failure	Replace the sensor 06.2400.0.009
	Check the servo amplifier and servo	To set the servo amplifier - call AMF Reece service, alternatively replace motor 12.0010.4.177 servo amplifier 24.8001.2.005
When sewing operation started, air valves do not operate. The air pressure correct.	Fork is not fitted properly into connector X3	Check the connector X3 connection
	Control unit PLC error	Replace the control unit 24.8001.0.001

TABLE OF CONTENTS

Needle Bar.....	2
Clamping.....	4
Thread Trimmer.....	6
Shifter Mechanism.....	8
Feed Mechanism.....	10
Looper Mechanism.....	14
Base.....	16
Bite Mechanism.....	18
Knife Thread Draw-OFF Mechanism.....	20
Main Cam.....	22
Head Assembly.....	24
Bedplate.....	26
Covers.....	28
Lubrication.....	30
Table Crosswise.....	32
Table Parallel.....	34
Table Universal.....	36
Table - Roller Kit - Extra Parts.....	38
Electrical — I.....	40
Electrical — II.....	44
Electrical — III.....	46
Panel Kit.....	48
Pneumatics.....	50
Accessories — Extra Parts.....	52

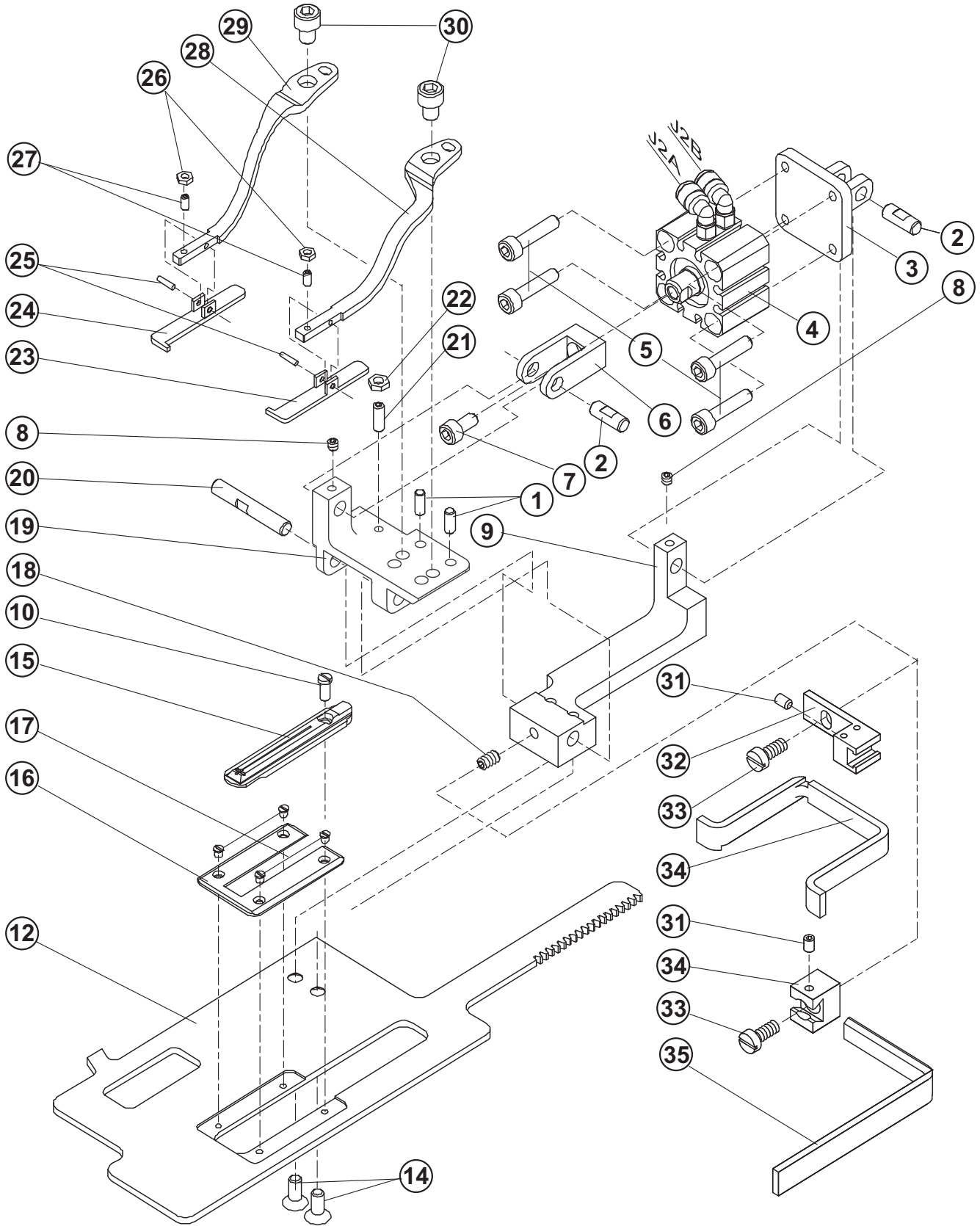
NEEDLE BAR



NEEDLE BAR

DET	PART NUMBER	DESCRIPTION	QTY.
1	22.0195.0.000	Needle Bar	1
2	01.2193.0.000	4-60 Screw	1
3	24.0510.0.000	Needle Bar Holder	1
4	08.6400.5.005	M5 x 5 Set Screw	1
5	01.7447.1.000	Porcelain Guide	1
6	22.0520.0.000	Needle Bar Clamp	1
7	01.6551.0.000	Retaining Ring	1
8	22.0230.0.000	Cupped Washer	2
9	22.0239.0.000	Felt Washer	2
10	22.0530.0.000	Needle Bar Connecting Link	1
11	22.0542.0.000	Needle Bar Connecting Link Pin	1
12	08.6400.3.005	M3 x 5 Set Screw	4
13	22.0541.0.000	Needle Bar Shoulder Screw	1
14	22.0540.0.000	Needle Bar Connecting Link Pin	1
15	08.6000.6.030	M6 x 30 Screw	(1)
16	22.0525.0.000	Needle Bar Crank	(1)
17	01.7809.0.000	Retaining Ring	1
18	01.7804.0.000	Top Shaft Bearing	1
19	24.0500.0.000	Needle Bar Drive Shaft	1
20	12.2050.0.003	Bearing	1
21	08.6400.4.004	M4 x 4 Set Screw	2 (2)
22	08.6000.6.016	M6 x 16 Screw	2
23	01.7805.0.000	Shaft Bearing	1
24	22.0525.0.050	Needle Bar Crank Asm.	1
25	22.0545.0.000	Washer	1
26	24.0048.0.000	Needle Bar Drive Pulley	1
27	22.0175.0.000	Drive Shaft Key	1
28	24.0002.0.000	Clamp Collar	1
29	12.1045.2.001	Retaining Ring	1
30	22.0535.0.100	Needle Bar Crank Link Asm.	1
31	08.6000.6.025	M6 x 25 Screw	1
32	02.0750.2.110	Needle	1
33	24.0001.0.000	Bearing Carrier Upper Shaft	1
34	22.0178.0.000	Spring	1
35	22.0177.0.000	Washer	2
36	24.0100.0.000	M3.5 x 0.35-11 Screw	1
37	08.6000.5.016	M5 x 16 Screw	1
38	12.0010.4.013	Plastic Cable Fitting	1

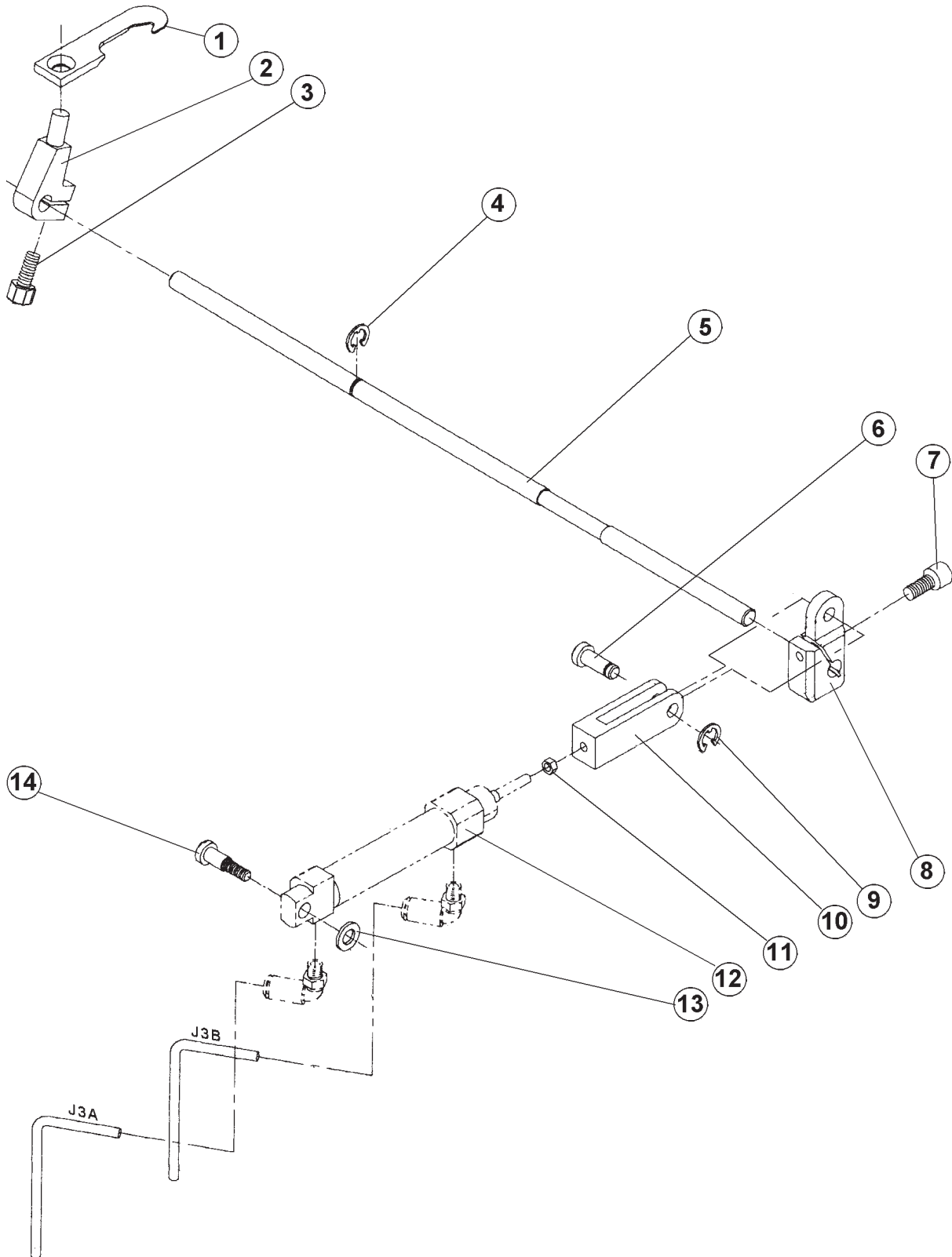
CLAMPING



CLAMPING

DET	PART NUMBER	DESCRIPTION	QTY.
01	07.6045.0.046	Pin	2
02	22.0173.0.000	Clamp Toggle Pivot Pin	2
03	24.0036.0.000	Cylinder Mounting Bracket	1
04	See Page 3-45	Cylinder ● ● ● ●	—
05	08.6000.5.022	Screw M5 x 22	4
06	24.0035.0.000	Cylinder Clevis	1
07	08.6000.5.012	Screw M5 x 12	1
08	08.6400.4.004	Set Screw M4 x 4	2
09	24.3210.0.000	Tail Bracket Clamp	1
10	01.2084.0.000	Fill. Screw 6-52	1
12	24.0125.0.000	Clamp Plate	1
14	08.6100.5.012	Screw M5 x 12	2
15	20.0051.1.024	Throat Plate	1
16	22.0164.0.000	Clamp Mat	1
17	01.2376.0.000	Screw 4-60	4
18	08.6400.5.005	M5 x 5 Set Screw	1
19	24.3209.0.000	Tail Pivot Clamp	1
20	22.0159.0.000	Tail Pivot Clamp Pin	1
21	08.6400.4.012	Set Screw M4 x 12	1
22	08.6700.4.000	Nut M4	1
23	22.0224.0.000	R.H. Clamp Foot	1
24	22.0223.0.000	L.H. Clamp Foot	1
25	17.0031.0.460	Roll Pin	2
26	08.6710.3.000	Nut M3	2
27	08.6400.3.006	Set Screw M3 x 6	2
28	22.0227.0.000	R.H. Clamp Arm	1
29	22.0226.0.000	L.H. Clamp Arm	1
30	08.6000.6.008	Screw M6 x 8	2
31	See Page 3-49	Gauge Lock Screw M4 x 5	—
32	See Page 3-49	Crosswise Gauge Guide	—
33	See Page 3-49	Screw M5 x 8	—
34	See Page 3-49	Parallel Gauge Block	—
35	See Page 3-49	Parallel Gauge	—

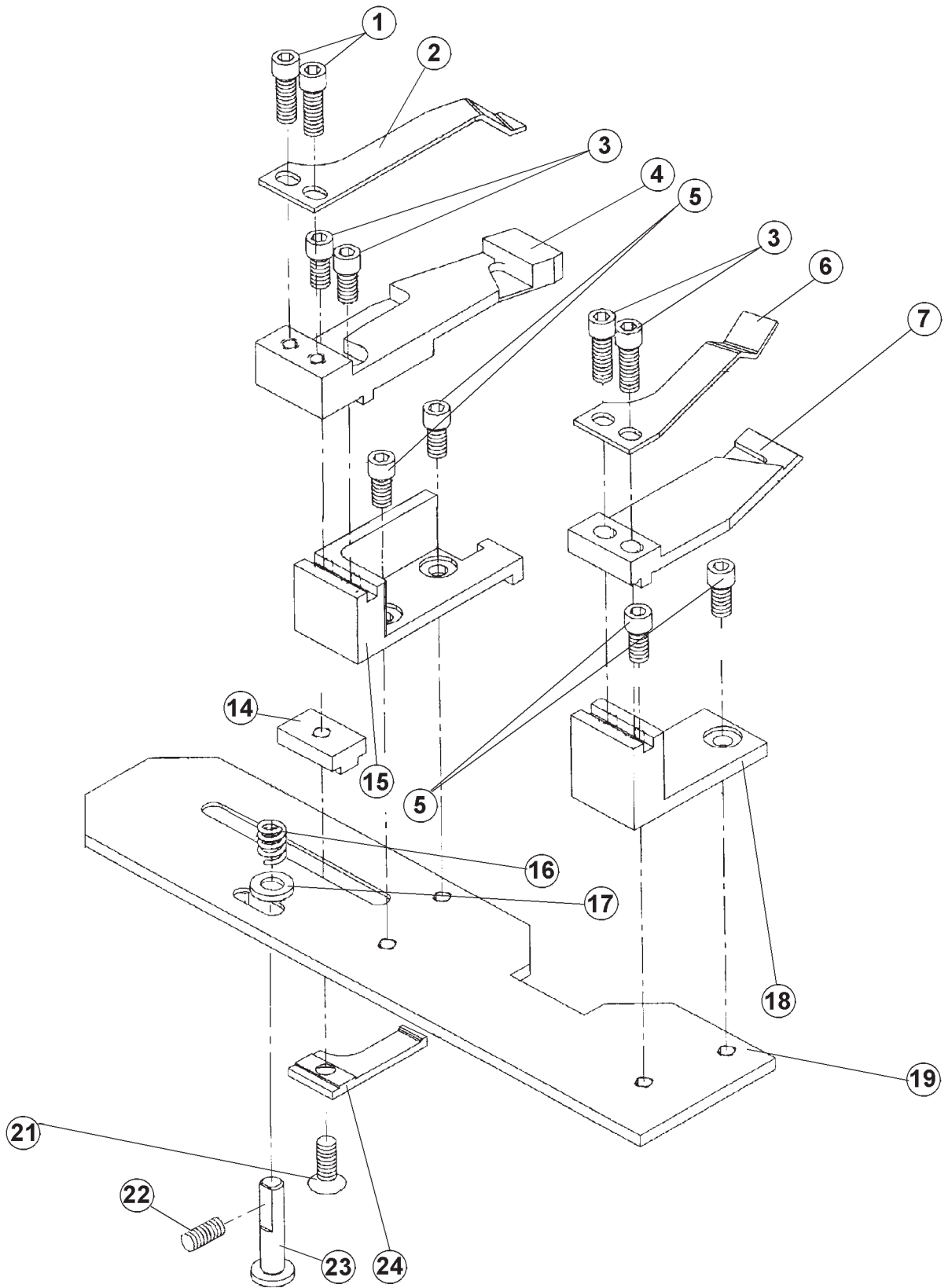
THREAD TRIMMER



THREAD TRIMMER

DET	PART NUMBER	DESCRIPTION	QTY.
01	20.0093.2.004	Trimmer Hook	1
02	20.0092.0.004	Trimmer Actuator	1
03	01.2386.0.000	3/16-36 x .5 Hex Screw	1
04	12.1045.3.001	E-Clip	1
05	24.0080.0.000	Trimmer Shaft	1
06	24.0003.0.000	Trimmer Pivot	1
07	08.6000.4.012	M4 x 12 Screw	1
08	24.0004.0.000	Trimmer Clamp Lever	1
09	07.6045.0.042	E-Clip	1
10	24.0005.0.000	Clevis	1
11	08.6700.4.000	M4 Nut	1
12	See Page 3-45	Trimmer Cylinder	● —
13	08.6852.6.000	Washer	1
14	24.0006.1.000	Pivot Screw	1

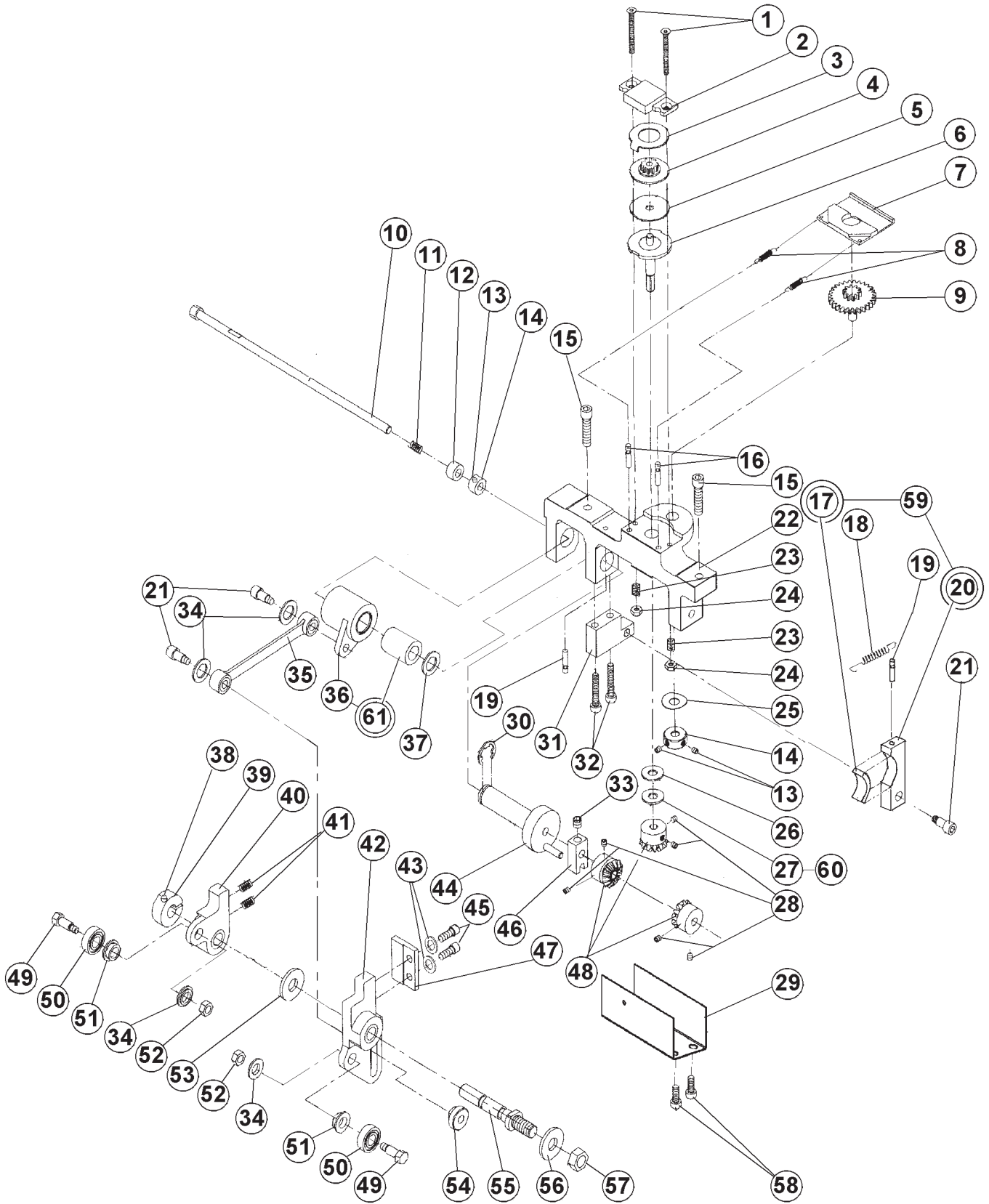
SHIFTER MECHANISM



SHIFTER MECHANISM

DET	PART NUMBER	DESCRIPTION	QTY.
01	08.6000.4.010	M4 x 10 Screw	2
02	22.2653.0.000	Left Shifter Arm Spring	1
03	08.6000.4.016	M4 x 16 Screw	4
04	22.2652.0.000	Left Shifter Arm	1
05	08.6000.4.005	M4 x 5 Screw	4
06	22.2657.0.000	Right Shifter Arm Spring	1
07	22.2656.0.000	Right Shifter Arm	1
14	22.0405.0.000	Adjustable Link Nut	1
15	22.2651.0.000	Left Shifter Block	1
16	07.6440.0.040	Spring	1
17	08.6887.5.000	Washer	1
18	22.2655.0.000	Right Shifter Block	1
19	22.2665.0.000	Main Cam Shifter Plate	1
21	08.6100.4.006	M4 x 6 Screw	1
22	08.6400.4.005	M4 x 5 Set Screw	1
23	22.0400.0.000	Spring Load Pin	1
24	22.2664.0.000	Buttonhole Adjusting Link	1

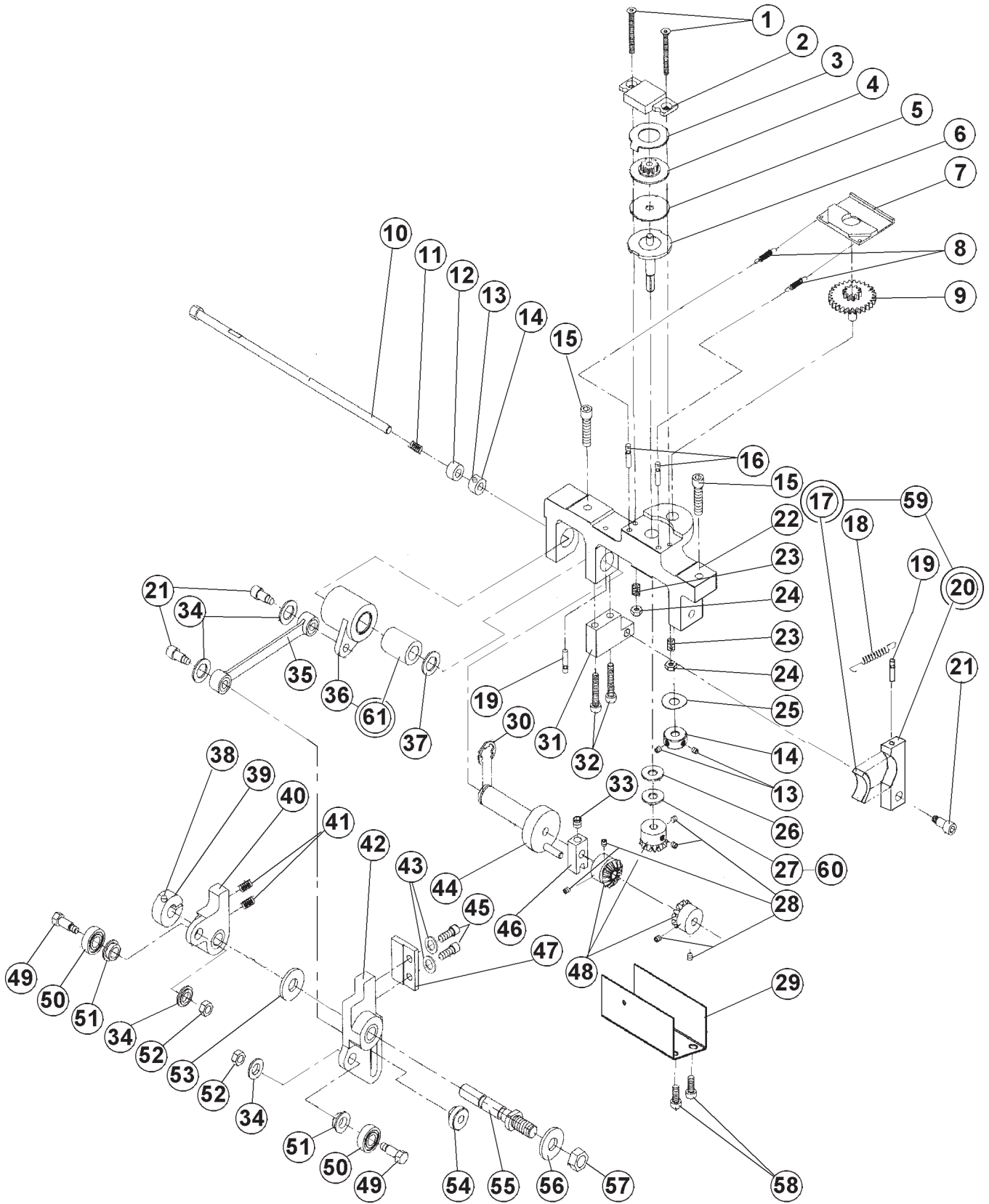
FEED MECHANISM



FEED MECHANISM

DET	PART NUMBER	DESCRIPTION	QTY.
01	08.6100.3.030	M3 x 30 Screw	2
02	22.0114.0.000	Feed Brake Pressure Plate	1
03	22.0121.0.000	Slip Clutch Drive Washer	1
04	22.0354.0.000	Slip Clutch Feed Gear	1
05	24.0126.0.000	Friction Washer ●●●	1
06	22.0312.0.000	Slip Clutch Feed Shaft	1
07	22.0061.0.000	Clamp Plate Gear Rack Retainer	1
08	07.6440.0.033	Spring	2
09	24.0351.0.000	Feed Gear Assembly	1
10	22.0325.0.000	Feed Reversing Shaft	1
11	07.6440.0.041	Spring	1
12	22.0228.0.000	Collar	1
13	08.6400.5.305	M5 x 0,5 - 5 Set Screw	4
14	24.0049.0.000	Set Collar	2
15	08.6000.5.020	M5 x 20 Screw	2
16	07.6045.0.037	3 x 16 Grooved Pin	2
17	22.0313.0.000	Feed Brake Pad ●●●	(1)
18	07.6440.0.050	Spring	1
19	07.6045.0.009	3 x 12mm Pin	2
20	22.0309.0.000	Feed Brake	(1)
21	22.0184.0.000	M5 x 8 Screw	3
22	22.0315.0.000	Feed Shaft Bracket ●●	1
23	07.6440.0.028	Spring	2
24	08.6733.3.000	M3 Lock Nut	2
25	17.0019.2.057	Lockwasher	1
26	22.0208.0.000	Flat Washer	1
27	22.0186.0.000	Washer Dia. 5.2/17-0.2	1
28	08.6400.4.005	M4 x 5 Set Screw	6
29	24.2035.0.000	Gear Cover	1
30	07.6045.0.034	E-Ring	1
31	22.0049.0.000	Feed Brake Mounting Block ●	1
32	08.6000.4.025	M4 x 25 Screw	2
33	08.6400.5.005	M5 x 5 Set Screw	1
34	22.0100.0.000	Shoulder Washer	4
35	22.0305.0.000	Feed Connecting Link ●●●	1
36	22.0320.0.000	Feed Shaft Bearing Housing	1
37	17.0019.0.517	Washer	1
38	08.6000.3.010	M3 x 10 Screw	1
39	22.0183.0.000	Collar Dia. 8	1
40	22.0026.0.000	L.H. Feed Cam Follower ●●●	1

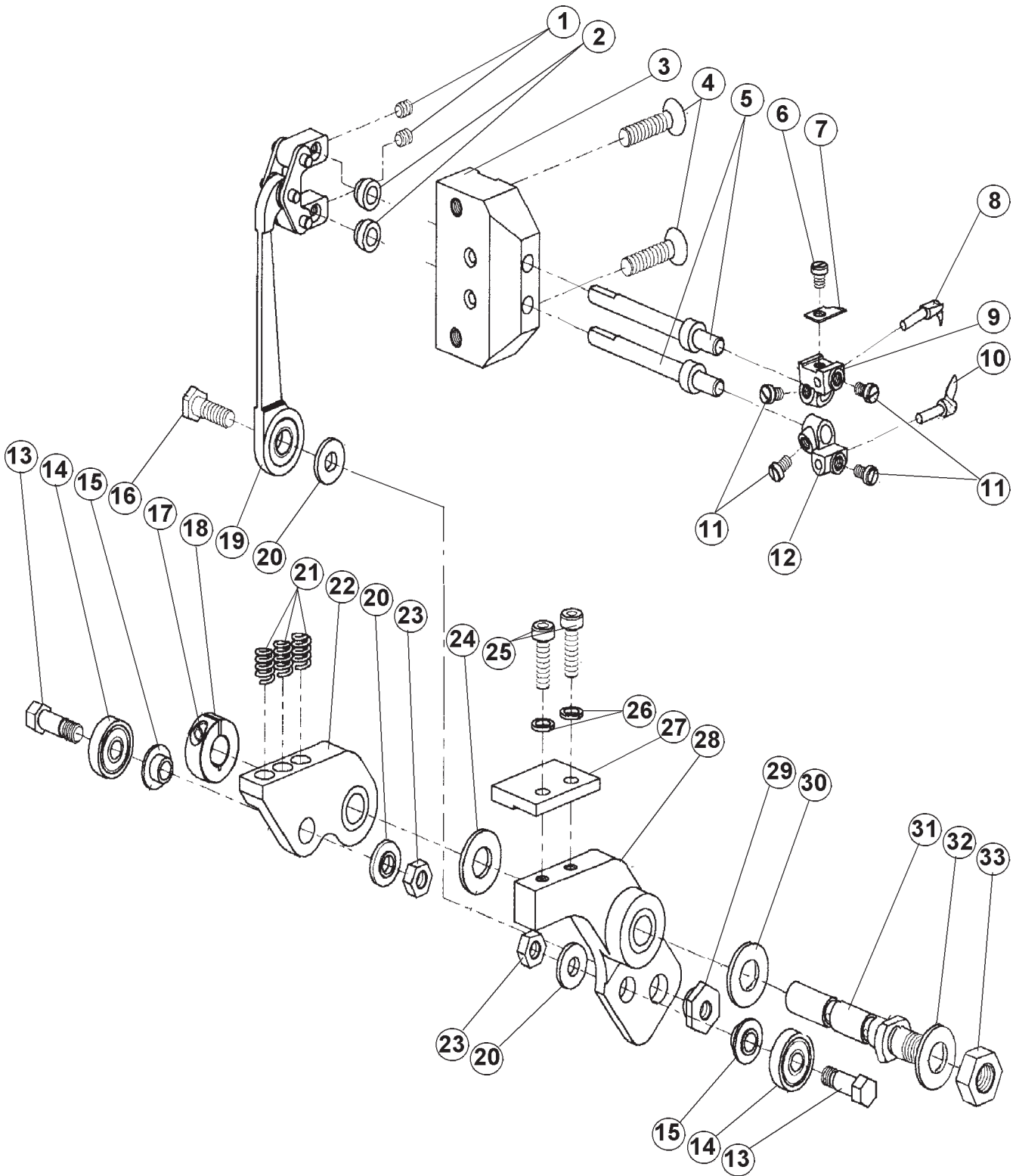
FEED MECHANISM



FEED MECHANISM

DET	PART NUMBER	DESCRIPTION	QTY.
41	07.6440.0.018	Spring	2
42	24.0127.0.000	R.H. Feed Cam Follower ● ● ●	1
43	08.6800.4.000	M4 Lockwasher	2
44	22.0336.0.000	Feed Shaft	1
45	08.6000.4.014	M4 x 14 Screw	2
46	22.0370.0.000	Feed Crank	1
47	22.0021.0.000	Spring Retain Block	1
48	22.0353.0.000	Steel Bevel Gear	3
49	22.0032.0.000	Bearing Shoulder Screw	2
50	07.6321.0.025	Bearing	2
51	22.0031.0.000	Bearing Spacer	2
52	08.6710.5.000	M5 Nut	2
53	22.0232.0.000	Washer	1
54	22.0110.0.000	M5 Shoulder Nut	1
55	22.0022.0.000	Pivot Shaft	1
56	08.6850.8.000	M8 Flat Washer	1
57	08.6700.8.000	M8 Nut	1
58	08.6000.4.005	M4 x 5 Screw	2
59	22.0309.0.050	Feed Brake Assembly	1
60	24.0140.0.000	Washer Dia. 5.2/17-0.1	1
61	07.6321.0.030	Bearing	(1)

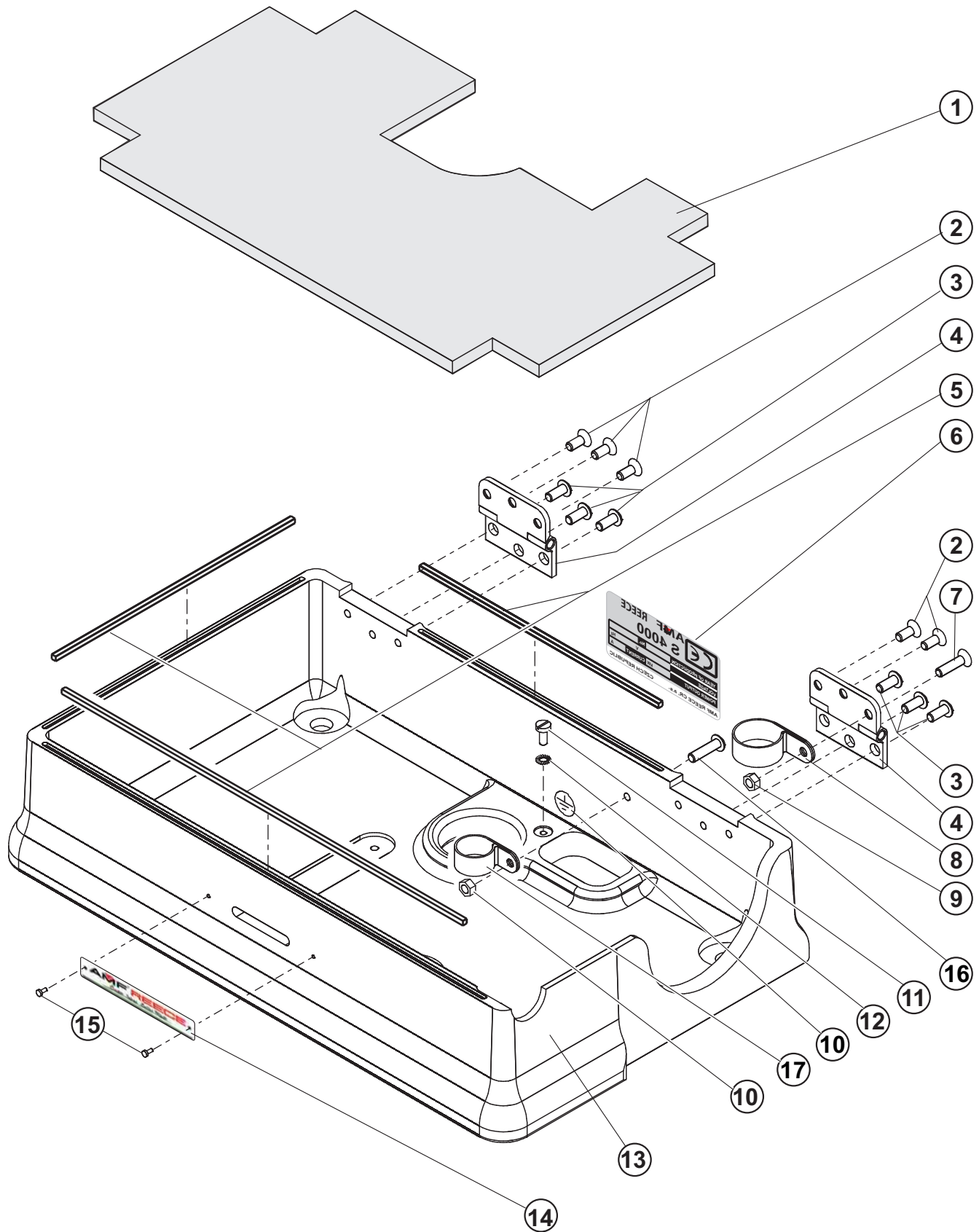
LOOPER MECHANISM



LOOPER MECHANISM

DET	PART NUMBER	DESCRIPTION	QTY.
01	08.6400.4.004	M4 x 4 Set Screw	2
02	22.2442.0.000	Looper Spacer	2
03	22.2410.0.000	Looper Shaft Block	1
04	08.6100.5.020	M5 x 20 Screw	2
05	22.2440.0.000	Looper Shaft	2
06	01.1382.0.000	Screw	1
07	20.0094.0.000	Trimmer Knife	1
08	20.0111.0.000	First Looper	1
09	23.2106.0.000	First Looper Holder	1
10	20.0112.0.000	Second Looper	1
11	01.1397.0.000	Screw	4
12	23.2107.0.000	Second Looper Holder	1
13	24.0066.0.000	Bearing Screw	2
14	12.2010.1.002	Cam Follower Bearing	2
15	22.0031.0.000	Bearing Spacer	2
16	22.0064.0.000	Bite Shoulder Screw	1
17	08.6000.3.010	M3 x 10 Screw	1
18	22.0183.0.000	Collar	1
19	22.2425.0.050	Looper Link Assembly	1
20	22.0100.0.000	Shoulder Washer	3
21	07.6440.0.036	Spring	3
22	22.0024.0.000	Looper Cam Follower Plate ● ● ●	1
23	08.6710.5.000	M5 Hex Nut	2
24	22.0232.0.000	Flat Washer	1
25	08.6000.4.014	M4 x 14 Screw	2
26	08.6800.4.000	M4 Lockwasher	2
27	22.0021.0.000	Spring Retainer Block	1
28	22.0023.0.000	R.H. Looper Cam Follower Plate ● ● ●	1
29	22.0105.0.000	Looper Eccentric Nut	1
30	22.0233.0.000	Flat Washer	1
31	22.0022.0.000	Pivot Shaft	1
32	08.6850.8.000	M8 Flat Washer	1
33	08.6700.8.000	M8 Hex Nut	1

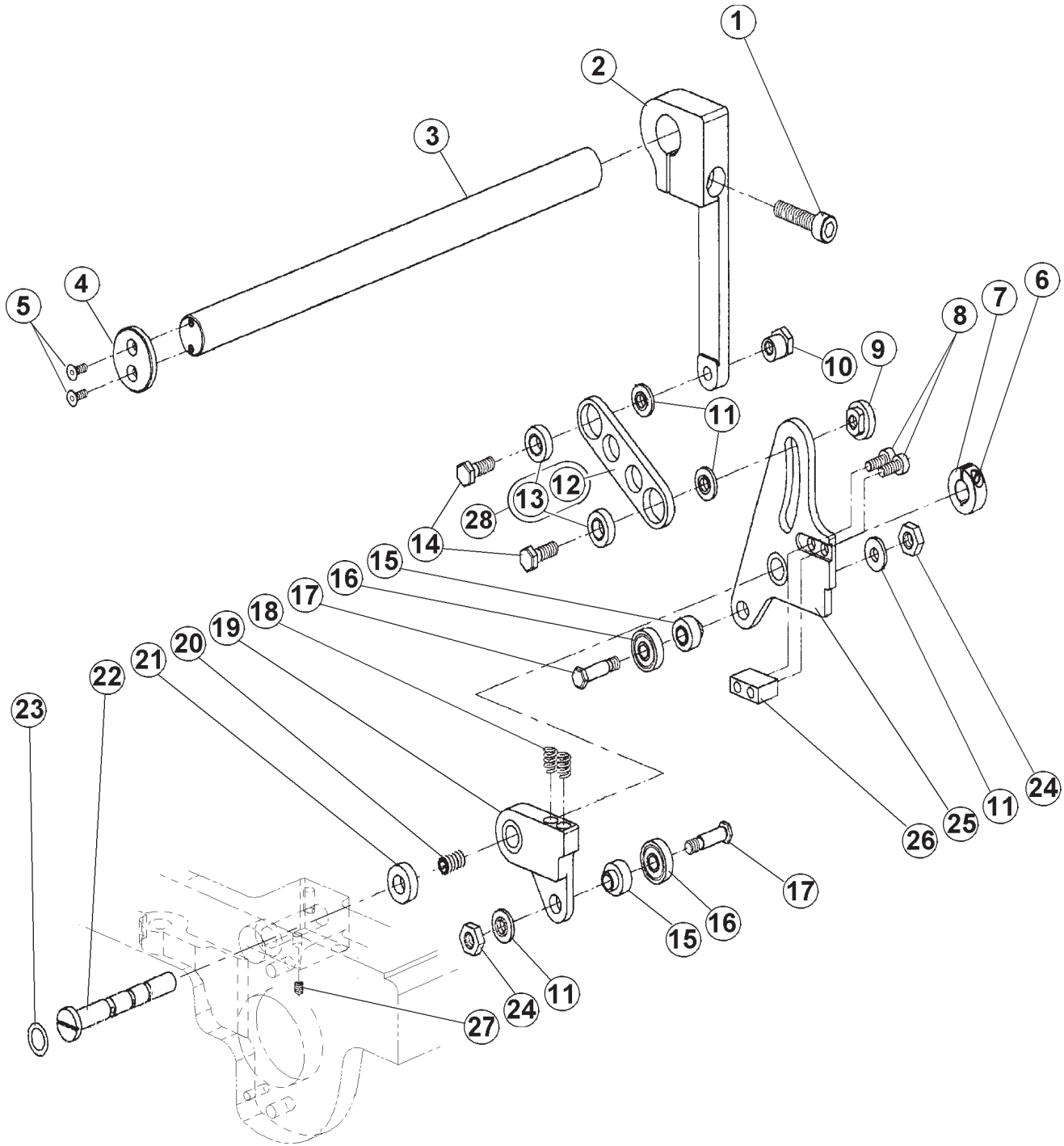
BASE



BASE

DET	PART NUMBER	DESCRIPTION	QTY.
01	24.0111.0.000	Base Sound Deadener ●●●	1
02	08.6100.5.012	M5 x 12 Screw	5
03	08.6200.5.012	M5 x 12 Screw	6
04	22.1010.0.000	Base Hinge	2
05	24.0038.0.000	Base Gasket ●●●	1
06	12.8000.0.016	CE™ Label	1
07	08.6100.5.020	M5 x 20 Screw	1
08	12.0008.4.197	Cord Clamp ●●●	1
09	08.6700.5.000	M5 Nut	2
10	12.0008.4.052	Label (Ground)	1
11	08.6012.4.010	M4 x 10 Screw	1
12	08.6832.4.000	M4 Serrated Lockwasher	1
13	24.6005.1.002	Base	1
14	—	Label	1
15	—	Drive Screw	2
16	08.6200.5.020	Screw	1
17	12.0008.4.100	Cord Clamp	1

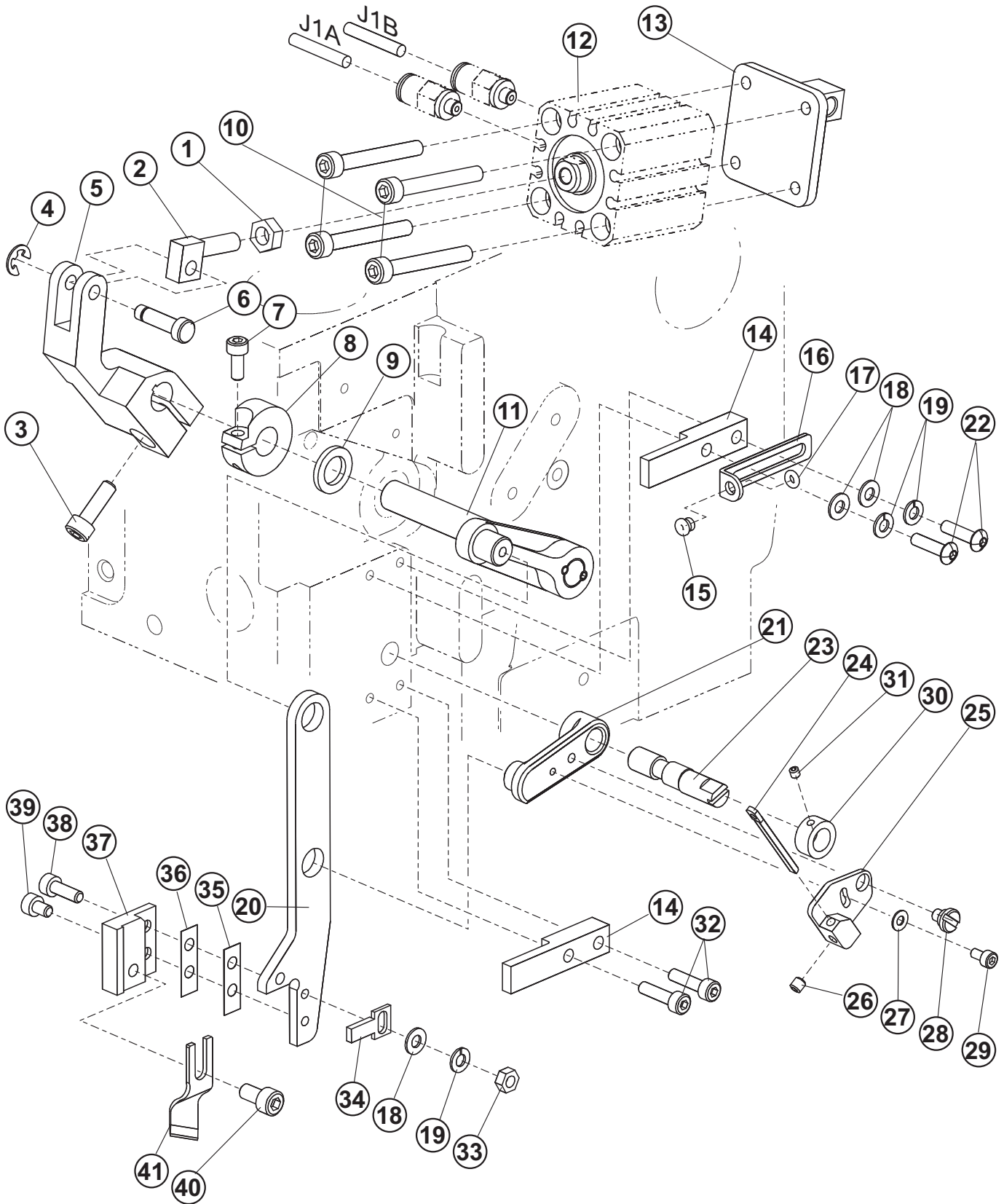
BITE MECHANISM



BITE MECHANISM

DET	PART NUMBER	DESCRIPTION	QTY.
01	08.6000.6.025	M6 x 25 Screw	1
02	22.0008.0.000	Bite Lever ●	1
03	24.0055.0.000	Bite Shaft	1
04	22.0063.0.000	Bite Shaft Retainer	1
05	08.6100.3.008	M3 x 8 FH Screw	2
06	08.6000.3.010	M3 x 10 Screw	1
07	22.0183.0.000	Collar*Dia. 8	1
08	08.6000.4.014	M4 x 14 Screw	2
09	22.0110.0.000	M5 Shoulder Nut	1
10	22.0214.0.000	M5 Eccentric Nut	1
11	22.0100.0.000	Shoulder Washer	4
12	22.0009.0.000	Bite Adjusting Link ●	(1)
13	07.6321.0.029	Bearing	(2)
14	22.0064.0.000	Bite Shoulder Screw	2
15	22.0029.0.000	Bite Follower Bearing Spacer	2
16	07.6321.0.025	Bearing	2
17	22.0028.0.000	Bite Follower Bearing Screw	2
18	07.6440.0.028	Spring	2
19	22.0027.0.000	Right Cam Follower ● ● ●	1
20	08.6400.4.005	M4 x 5 Set Screw	1
21	22.0069.0.000	Bite Follower Spacer	1
22	22.0020.0.000	Bite Pivot Shaft	1
23	12.0008.6.800	Rubber Ring ● ● ●	1
24	08.6700.5.000	M5 Hex Nut	2
25	22.0033.0.000	Left Cam Follower ● ● ●	1
26	22.0030.0.000	Bite Follower Spring Retainer	1
27	08.6400.4.004	M4x4 Screw	1
28	22.0009.0.050	Bite Adjusting Link Assembly	1

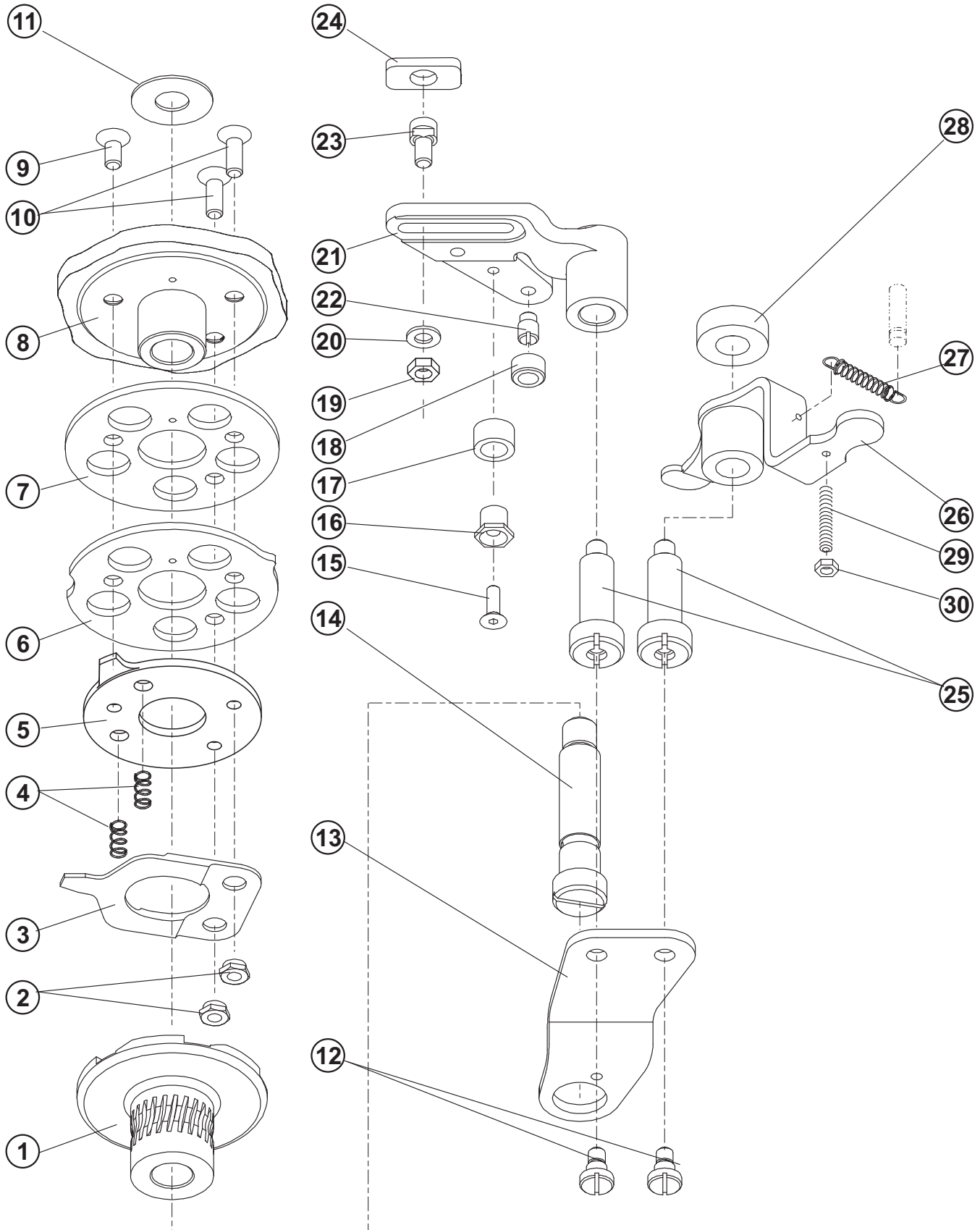
KNIFE THREAD DRAW-OFF MECHANISM



KNIFE THREAD DRAW-OFF MECHANISM

DET	PART NUMBER	DESCRIPTION	QTY.
01	08.6710.6.000	M6 Nut ●●●	1
02	24.0037.0.000	Cylinder Clevis ●●●	1
03	08.6000.5.016	M5 x 16 Screw	1
04	07.6045.0.042	E-Clip	1
05	24.0011.0.000	Knife Drive Lever	1
06	24.0014.0.000	Pivot	1
07	08.6000.4.010	M4 x 10 Screw	1
08	24.0010.0.000	Clamp Collar	1
09	24.0009.0.000	Washer	1
10	08.6000.5.040	Screw M5x40	4
11	22.1415.0.050	Knife Lever Assembly	1
12	See Page 3-47	Knife Cylinder	—
13	24.0039.0.000	Thread Draw-Off Bracket	1
14	22.1436.0.000	Drive Plate Retainer ● ●●●	2
15	01.7447.1.000	Porcelain Guide	1
16	22.0046.0.000	Thread Guide Bracket	1
17	01.6551.0.000	Retaining Ring	1
18	08.6850.4.000	M4 Flat Washer	2
19	08.6800.4.000	M4 Lockwasher	2
20	22.1430.0.901	Knife Holder	1
21	24.0062.0.000	Knife Guide Link	1
22	08.6200.4.016	M4 x 16 Screw	2
23	24.0093.0.000	Pivot Eccentric	1
24	22.0091.0.000	Thread Take-Up	1
25	24.0063.0.000	Thread Draw-Off	1
26	08.6400.4.004	M4 x 4 Set Screw	1
27	08.6850.3.000	M3 Washer	1
28	24.0061.0.000	Shoulder Screw	1
29	08.6000.3.006	M3 x 6 Screw	1
30	24.0094.0.000	Collar	1
31	08.6400.3.003	Set Screw M3x3	1
32	08.6000.4.016	Screw M4x16	2
33	08.6700.4.000	Nut M4	1
34	22.0145.0.000	Knife Stop	1
35	22.1442.0.000	Knife Shim 0,1	1
36	22.1443.0.000	Knife Shim 0,05mm	1
37	22.1426.0.000	Knife Holder Shim Block	1
38	08.6000.4.012	Screw M4x12	1
39	08.6000.4.006	Screw M4x6	1
40	08.6000.5.008	Screw M5x8	1
41	23.2356.2.052	Knife 13mm	1

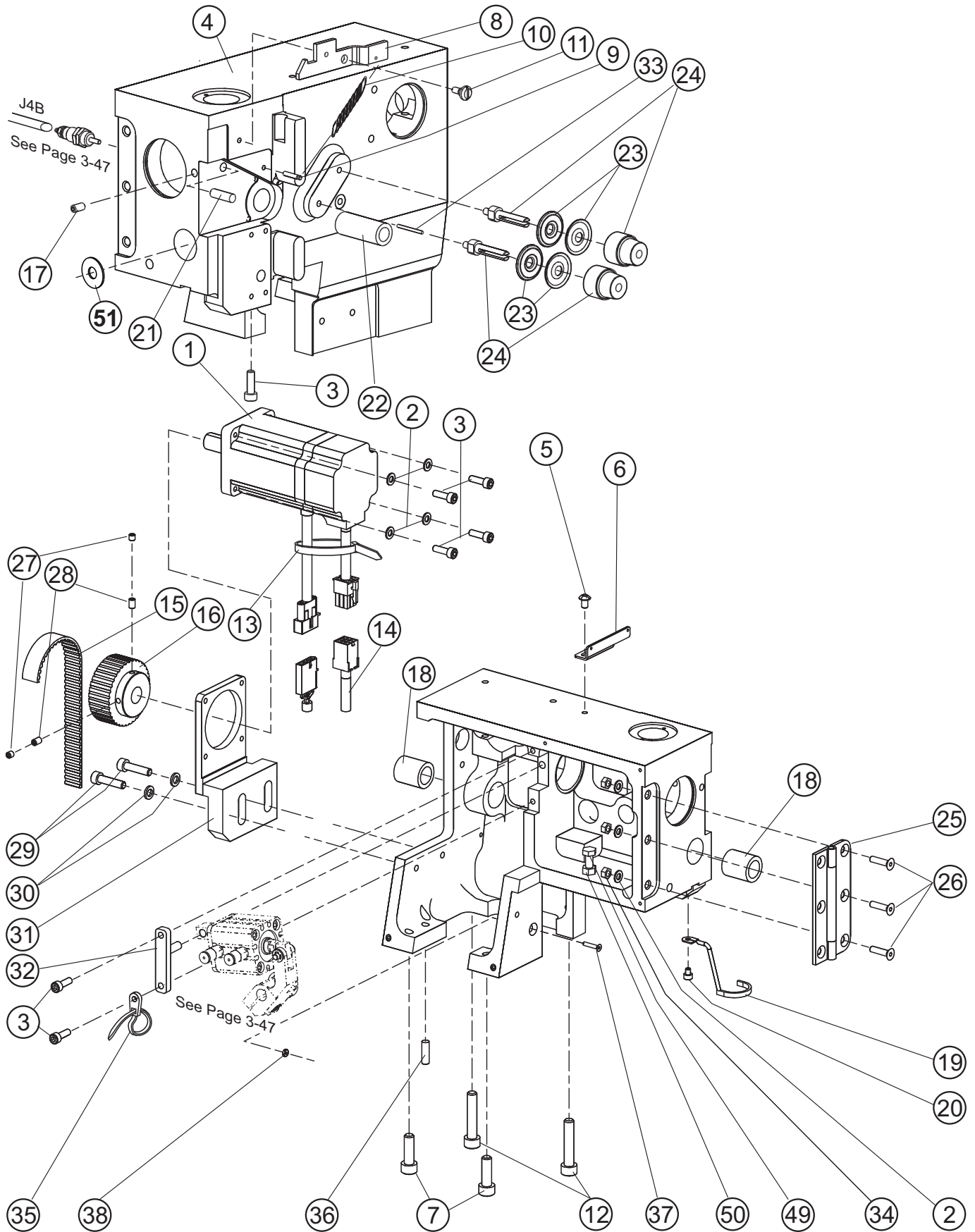
MAIN CAM



MAIN CAM

DET	PART NUMBER	DESCRIPTION	QTY.
01	22.2607.0.000	Drive Disk/Worm Gear Hub	1
02	22.2627.0.000	Shoulder Nut	2
03	22.2626.0.000	Drive Disk Switch Spring	1
04	07.6440.0.037	Spring	2
05	24.0151.0.000	Stop Disk	1
06	22.2620.0.000	Feed Reversing Cam	1
07	22.3069.0.000	Washer	1
08	22.2600.0.000	Barring Cam	1
09	08.6100.5.010	M5 x 10 Screw	1
10	22.0137.0.000	M5 x 14 Screw	2
11	07.6321.0.001	Thrust Washer	1
12	22.0182.0.000	M5 x 4 Screw	2
13	22.0097.0.000	Main Cam Brace	1
14	22.2610.0.000	Main Cam Shoulder Screw	1
15	08.6100.4.012	M4 x 12 Screw	1
16	22.2635.0.000	Barring Lever Eccentric	1
17	22.2638.0.000	Barring Lever Roller	1
18	22.2639.0.000	Barring Lever Roller	1
19	08.6700.5.000	M5 Nut	1
20	08.6850.5.000	M5 Washer	1
21	24.2630.1.000	Barring Lever	1
22	22.2637.0.000	Barring Lever Stud	1
23	22.2633.0.000	Slidestone Retaining Screw	1
24	22.2631.0.000	Clamp Plate Slidestone	1
25	22.0106.0.000	Hub Shoulder Screw	2
26	22.2640.0.050	Feed Reversing Lever	1
27	07.6440.0.045	Extension Spring	1
28	22.3003.0.000	Spacer	1
29	08.6400.3.020	Screw M3x20	1
30	08.6700.3.000	Nut M3	1

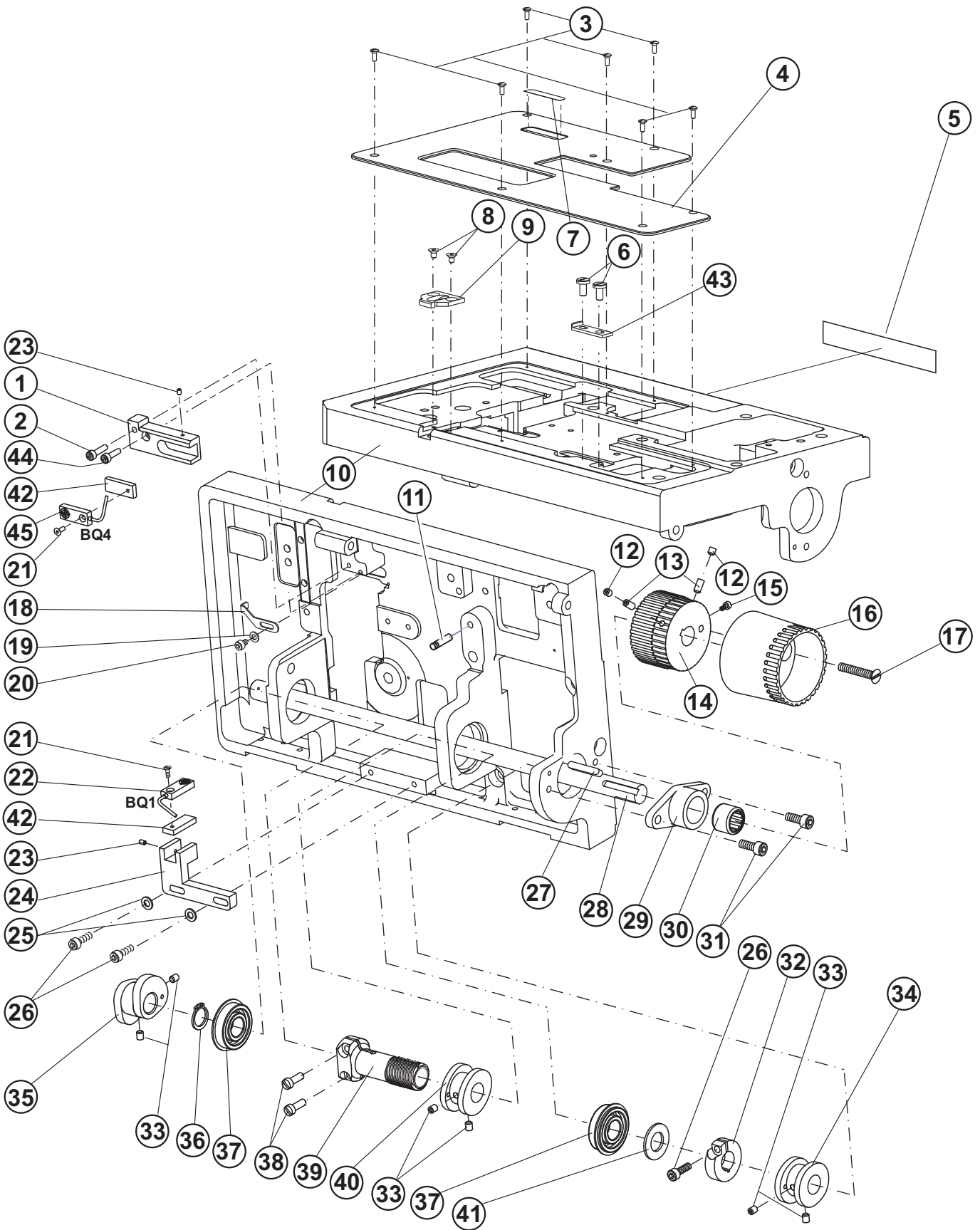
HEAD ASSEMBLY



HEAD ASSEMBLY

DET	PART NUMBER	DESCRIPTION	QTY.
01	See Page 3-39	Servomotor ● ● ● ● ●	1
02	08.6850.5.000	M5 Washer	7
03	08.6000.5.016	M5 x 16 Screw	8
04	24.6000.5.000	Head	1
05	08.6200.5.008	M5 x 8 Screw	1
06	22.0054.0.000	Upper Thread Guide	1
07	08.6000.8.025	M8 x 25 Screw	2
08	22.0058.0.000	Sewing Head Latch	1
09	07.6045.0.037	3 x 16 Grooved Pin	1
10	07.6440.0.051	Latch Tension Spring	1
11	22.0062.0.000	M4 x 3 Screw	1
12	08.6000.8.040	M8x40 Screw	2
13	12.0008.3.023	Ty-wrap ●	1
14	See Page 3-39	Encoder Cable ● ● ● ● ●	1
15	12.5050.2.009	Belt ● ● ● ●	1
16	24.0108.0.000	Motor Pulley ●	1
17	08.6400.5.010	M5 x 10 Screw	1
18	01.7806.0.000	Oilite Bushing ● ●	2
19	24.0044.0.000	Needle Guard	1
20	08.6000.4.005	M4 x 5 Screw	1
21	07.6045.0.053	6 x 20 Pin	1
22	22.1422.0.000	Knife Shaft Bushing	1
23	17.0082.8.082	Release Washer	2
24	23.2044.0.050	Large Tension Assembly ● ● ●	2
25	22.6002.0.000	Head Hinge Assembly	1
26	08.6100.5.020	M5 x 20 Screw	3
27	08.6400.5.005	M5 x 5 Set Screw	2
28	08.6400.5.008	M5x8 Set Screw	2
29	08.6000.6.025	M6 x 25 Screw	2
30	08.6850.6.000	M6 Washer	2
31	24.0106.1.000	Motor Bracket	1
32	24.0016.0.000	Cylinder Pivot Stud Assembly	1
33	12.1010.2.003	2 x 24 Pin	1
34	08.6700.5.000	M5 Nut	3
35	12.0008.4.598	Plastic Cable Fitting ● ● ●	1
36	12.1011.0.001	6 x 20 Pin	1
37	08.6100.3.016	M3 x 16 Screw	1
38	08.6700.3.000	M3 Nut	1
49	08.6310.6.035	Screw M6x35	1
50	08.6700.6.000	Nut M6	1
51	24.0546.0.000	Washer	1

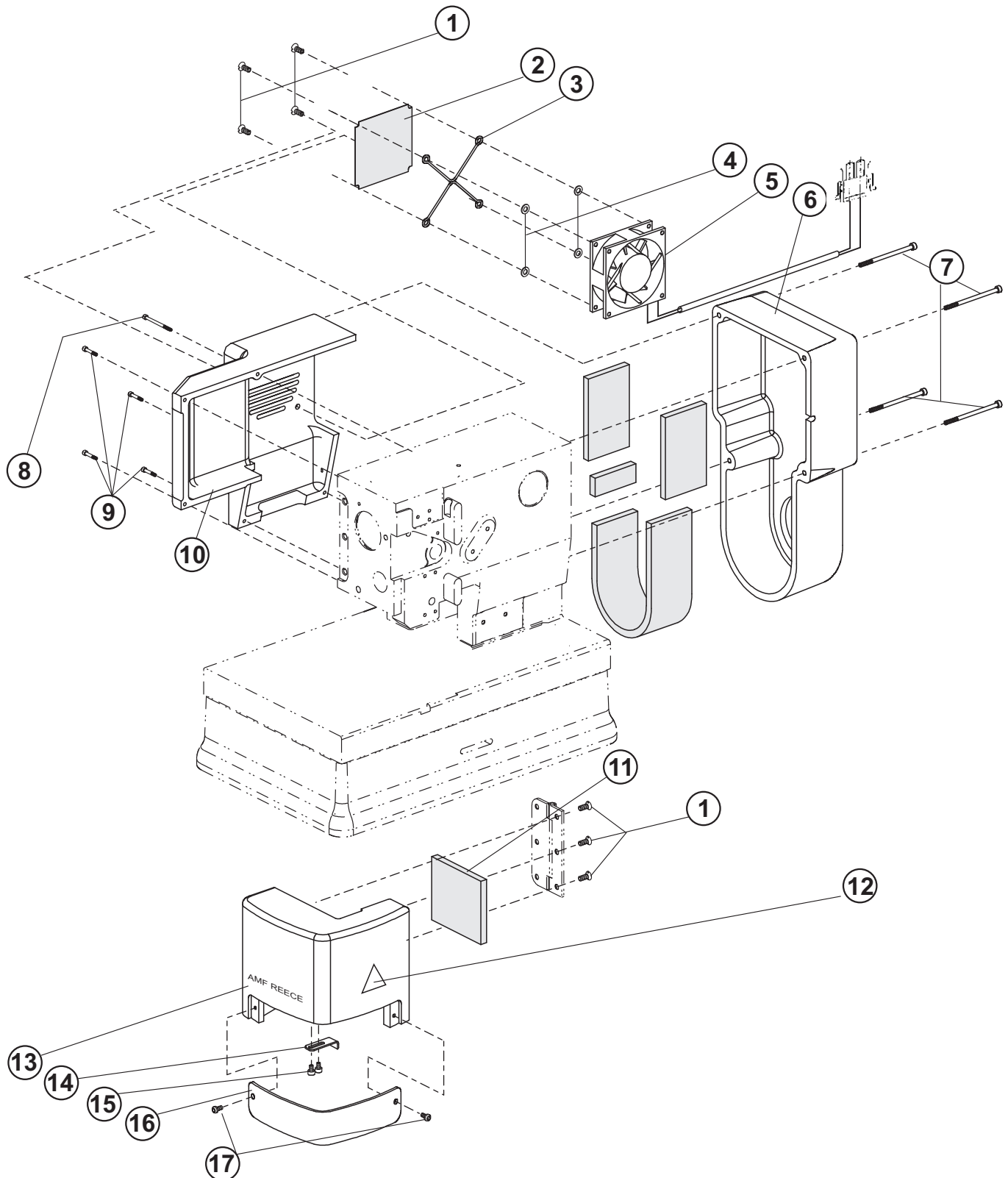
BEDPLATE



BEDPLATE

DET	PART NUMBER	DESCRIPTION	QTY.
1	24.0021.0.000	Tension Release Sensor Bracket	1
2	08.6000.4.014	M4x14 Screw	1
3	08.6120.3.008	M3x8 Screw	7
4	22.6101.0.000	Cover Plate	1
5	—	AMF Reece Label - small	1
6	22.0143.0.000	Screw	2
7	22.0096.0.000	Buttonhole Size Sticker	1
8	08.6100.4.006	M4x6 Screw	2
9	22.0408.1.000	Trimmer Cover Plate	1
10	24.6100.0.000	Bedplate	1
11	07.6045.0.054	5 x 20 mm Pin	1
12	08.6400.5.005	M5 x 5 Set Screw	2
13	08.6400.5.010	M5 x 10 Set Screw	2
14	24.0018.0.000	Main Shaft Drive Pulley	● 1
15	08.6000.3.006	M3 x 6 Screw	1
16	24.0051.0.066	Hand Wheel	● 1
17	08.6100.6.035	M6 x 35 Screw	1
18	22.3219.0.000	Needle Guard	1
19	08.6850.4.000	M4 Washer	1
20	08.6000.4.006	M4 x 6 Screw	1
21	08.6100.3.008	M3 x 8 Screw	2
22	See Page 3-39	End of Cycle Sensor with Cable (BQ1)	●●● —
23	08.6400.3.004	M3 x 4 Set Screw	2
24	24.0020.0.000	End of Cycle Sensor Bracket	1
25	08.6850.5.000	M5 Washer	2
26	08.6000.5.016	M5 x 16 Screw	3
27	12.4030.0.002	Key 5x5x30	1
28	24.1000.0.000	Main Shaft	1
29	24.0019.0.000	Bearing Carrier Lower Shaft	1
30	12.2050.0.005	Bearing	1
31	08.6000.6.016	M6 x 16 Screw	2
32	24.0002.0.000	Clamp Collar	1
33	08.6400.5.305	M5 x 0.5-5 Set Screw	6
34	22.0006.0.000	Bite Cam	1
35	24.2400.0.000	Looper Cam	1
36	12.1045.2.001	Retaining Ring	1
37	01.7805.0.000	Shaft Bearing	2
38	22.0153.0.000	Screw	2
39	22.8400.0.000	Shaft Worm Gear	1
40	22.0300.0.000	Feed Cam	1
41	22.0545.0.000	Washer	1
42	24.0027.0.000	Sensor Mounting Plate	2
43	22.0115.0.000	Stop	1
44	08.6000.4.016	M4x16 Screw	1
45	See Page 3-39	Tension Release Sensor with Cable (BQ4)	1

COVERS



COVERS

DET	PART NUMBER	DESCRIPTION	QTY.
01	08.6100.5.016	Screw M5 x 16	7
02	24.0068.0.000	Net ●●●	1
03	24.0067.0.000	Fan Rack	1
04	08.6850.5.000	Washer M5	4
05	See Page 3-35	Fan Assembly ●● ●●●	—
06	24.6004.1.001	Pulley Cover ●	1
07	08.6000.4.070	Screw M4 x 70	4
08	08.6000.3.040	Screw M3 x 40	1
09	08.6000.3.016	Screw M3 x 16	4
10	24.6001.2.000	Head Rear Cover ●	1
11	24.0112.0.000	Cover Sound Deadener ●●●	1
12	—	Label	1
13	24.6003.0.000	Needle Bar Cover ●	1
14	22.0057.0.000	Cover Latch	1
15	08.6000.4.006	Screw M4 x 6	2
16	24.0154.0.000	Eye Shield ●●●	1
17	08.6200.4.008	Screw M4 x 8	2

LUBRICATION

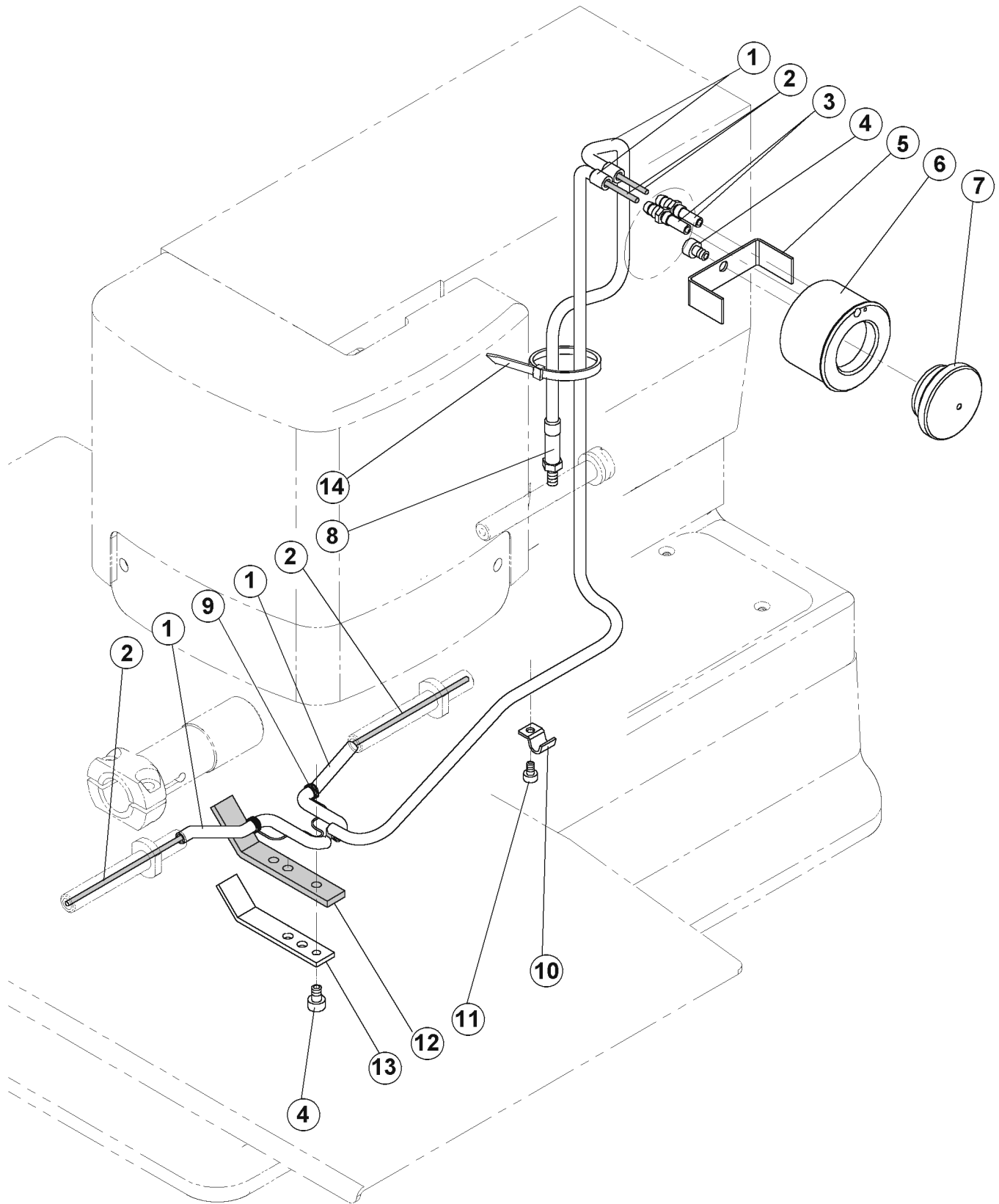


TABLE CROSSWISE

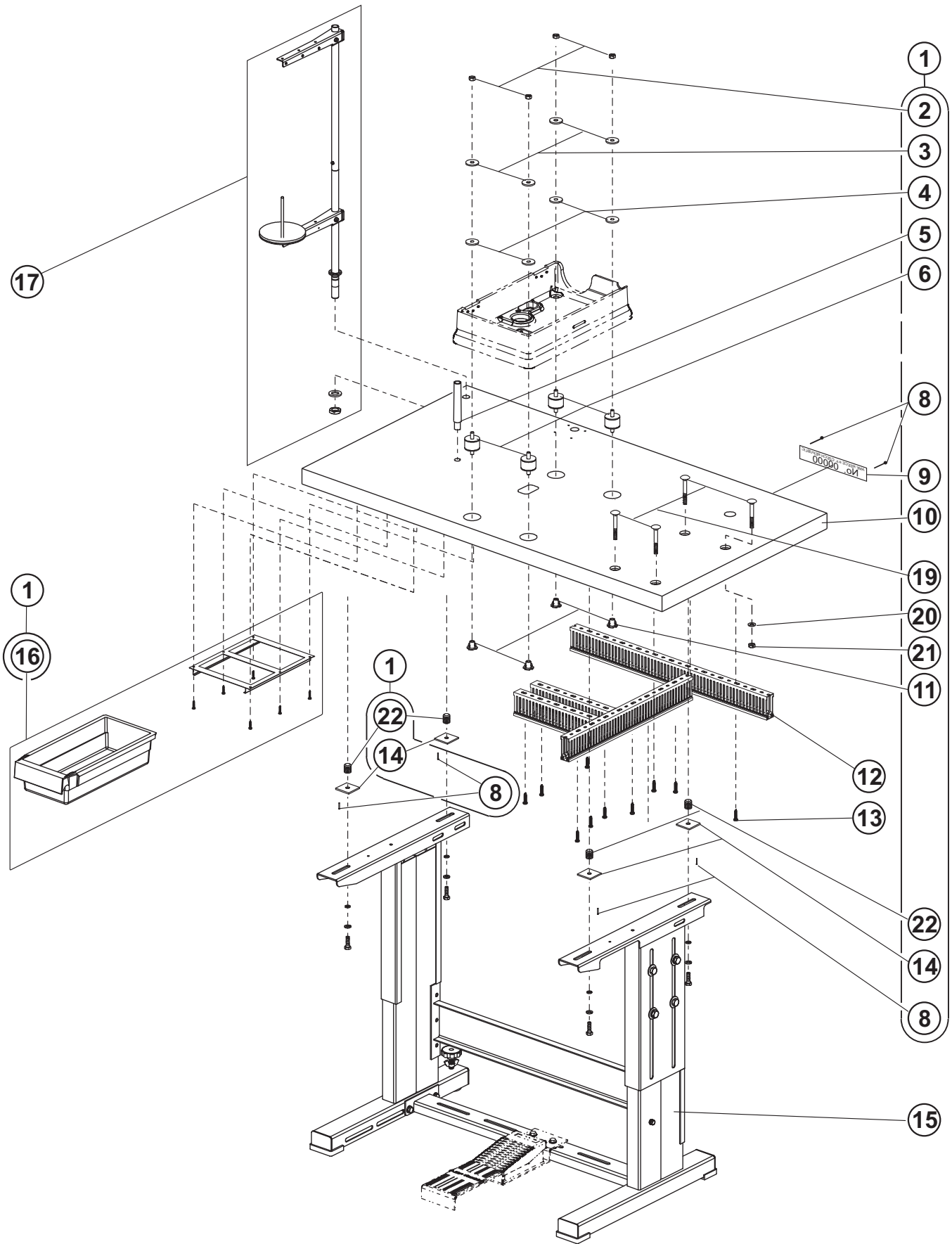


TABLE PARALLEL

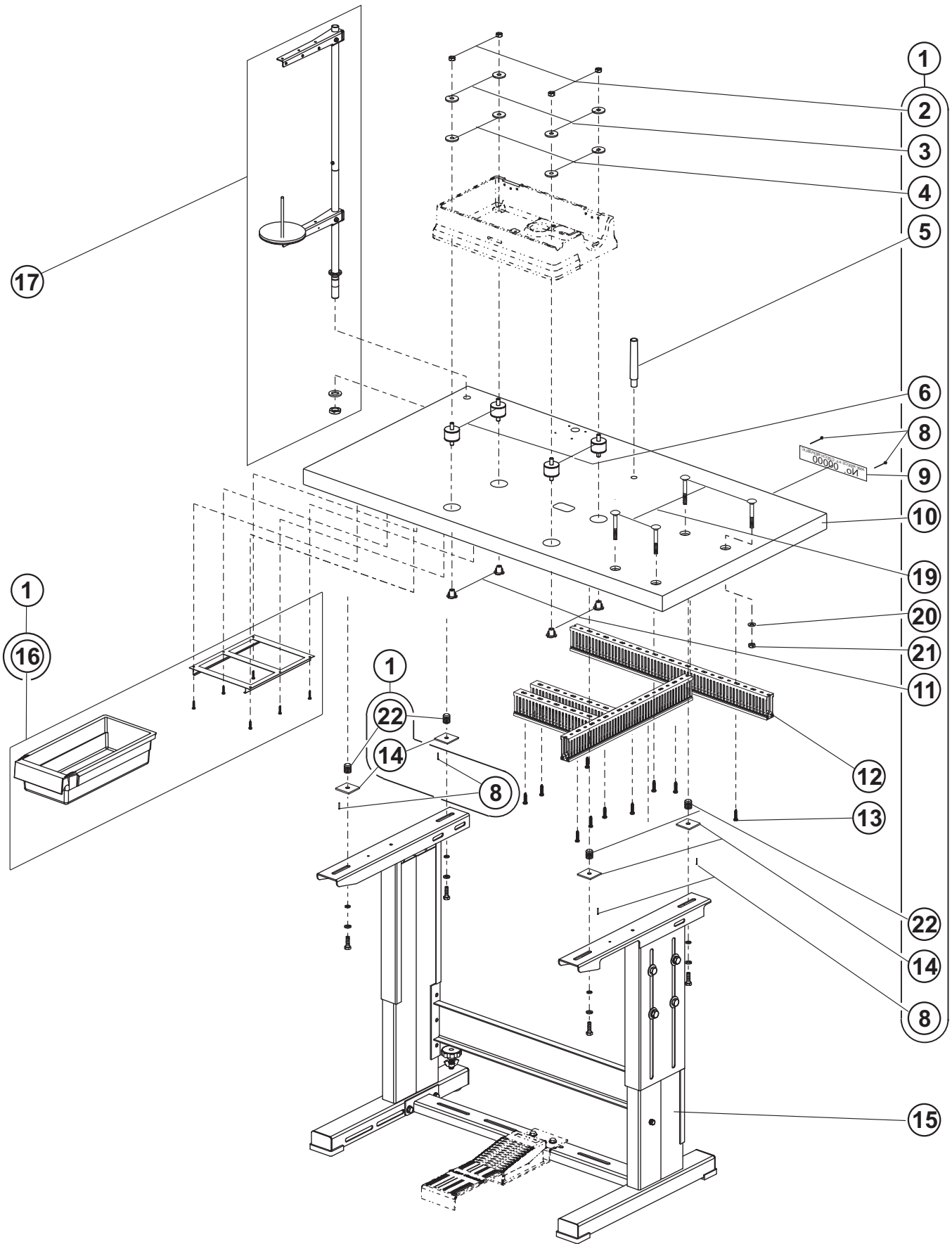


TABLE PARALLEL

DET	PART NUMBER	DESCRIPTION	QTY.
01	24.0149.0.050	Table Crosswise Assembly	1
02	08.6700.8.000	M8 Nut	(4)
03	17.0019.0.441	Washer	(4)
04	17.0095.1.272	Washer	●●● (4)
05	12.0008.6.900	Machine Rest Table Pin	(1)
06	12.0008.6.801	Rubber Spring	●●● (4)
08	12.1016.1.000	Nail	●●● (6)
09	04.1416.0.003	Label "No. xxxx"	(1)
10	24.0149.0.000	Table Crosswise	●●● (1)
11	08.6742.8.000	M8 Nut	(4)
12	24.0059.9.065	Wire Raceway Kit	●●● 1
13	08.6663.5.025	Screw 4,8 - 25	10
14	17.0094.0.200	Washer	●●● (4)
15	04.9000.2.123	Frame Kit	1
16	12.0008.6.901	Drawer Kit	●●● (1)
17	22.0219.0.000	Thread Stand	1
19	08.6532.8.055	Screw M8x55	(4)
20	08.6852.8.000	Washer	(4)
21	08.6702.8.000	Nut	(4)
22	08.6752.8.000	Nut	(4)

TABLE UNIVERSAL

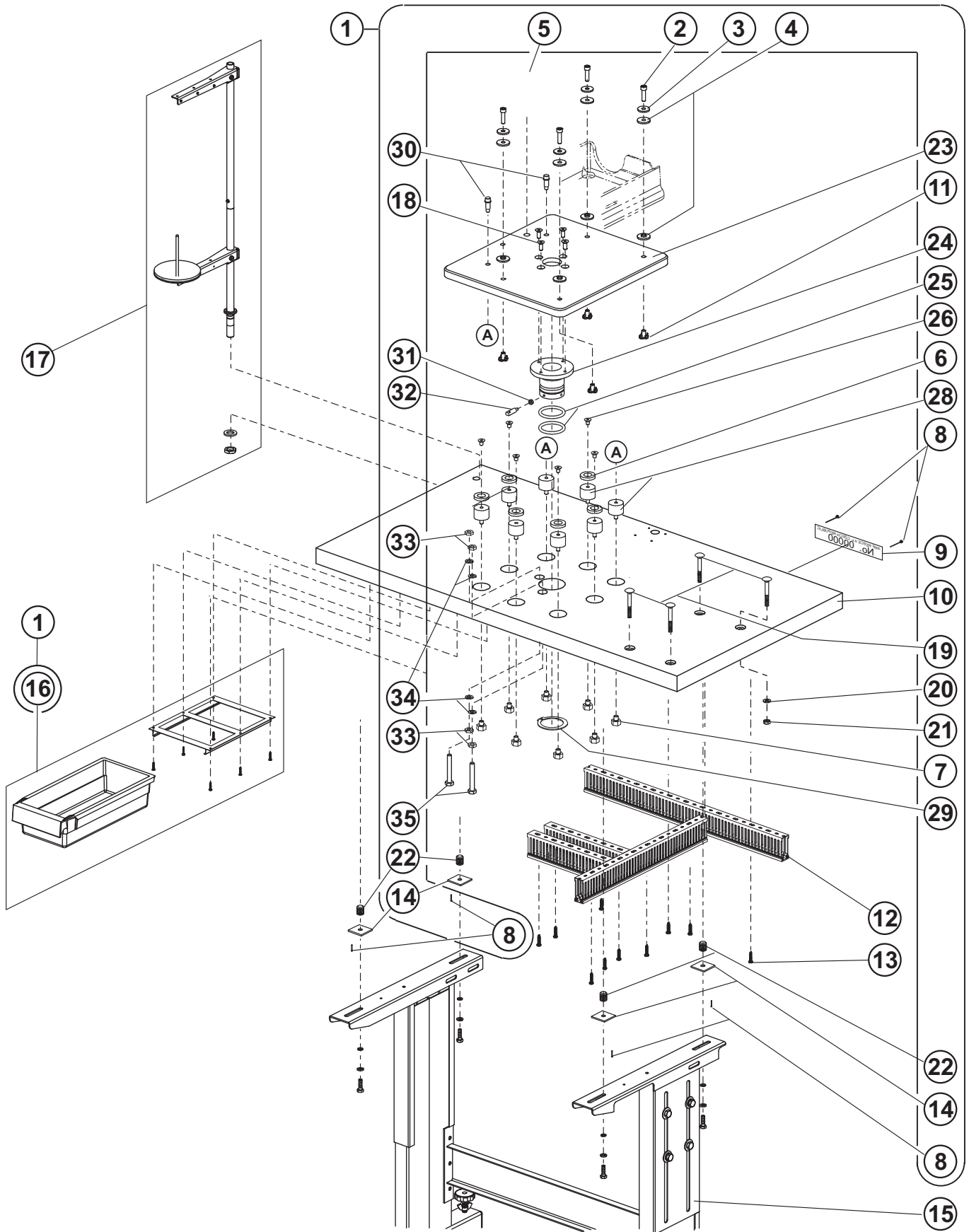


TABLE UNIVERSAL

DET	PART NUMBER	DESCRIPTION	QTY.
01	24.0150.0.050	Table Assembly	1
02	08.6000.8.030	Screw M8x30	(4)
03	17.0019.0.441	Washer	(4)
04	17.0095.1.272	Washer	●●● (8)
05	12.0008.6.900	Machine Rest Table Pin	(1)
06	24.0081.0.000	Bearing Disk	●●● (6)
07	24.0082.0.000	Retaining Nut	0
08	12.1016.1.000	Nail	●●● (6)
09	04.1416.0.003	Label "No. xxxx"	(1)
10	24.0150.0.000	Table	●●● (1)
11	08.6742.8.000	M8 Nut	(4)
12	24.0059.9.065	Wire Raceway Kit	●●● 1
13	08.6663.5.025	Screw 4,8 - 25	10
14	17.0094.0.200	Washer	●●● (4)
15	04.9000.2.123	Frame Kit	1
16	12.0008.6.901	Drawer Kit	●●● (1)
17	22.0219.0.000	Thread Stand	1
18	08.6100.8.020	Screw M8x20	(4)
19	08.6532.8.055	Screw M8x55	(4)
20	08.6852.8.000	Washer	(4)
21	08.6702.8.000	Nut	(4)
22	08.6752.8.000	Nut	(4)
23	24.0079.0.000	Base Plate	(1)
24	24.0086.0.000	Pivot, Base Subplate	(1)
25	12.0008.6.807	O Ring 50x6	(2)
26	08.6100.8.012	Screw M8x12	(6)
28	24.0084.0.000	Cylindrical Vibrator Isolator	(8)
29	12.1040.1.009	Ring 58	(1)
30	24.0087.0.000	Shoulder Screw	(2)
31	08.6700.6.000	Nut M6	(1)
32	24.0089.0.000	Stop Pin	(1)
33	08.6710.0.300	Nut M10	(4)
34	08.6850.0.000	Washer M10	(4)
35	08.6300.0.070	Screw M10x70	(2)

TABLE - ROLLER KIT - EXTRA PARTS

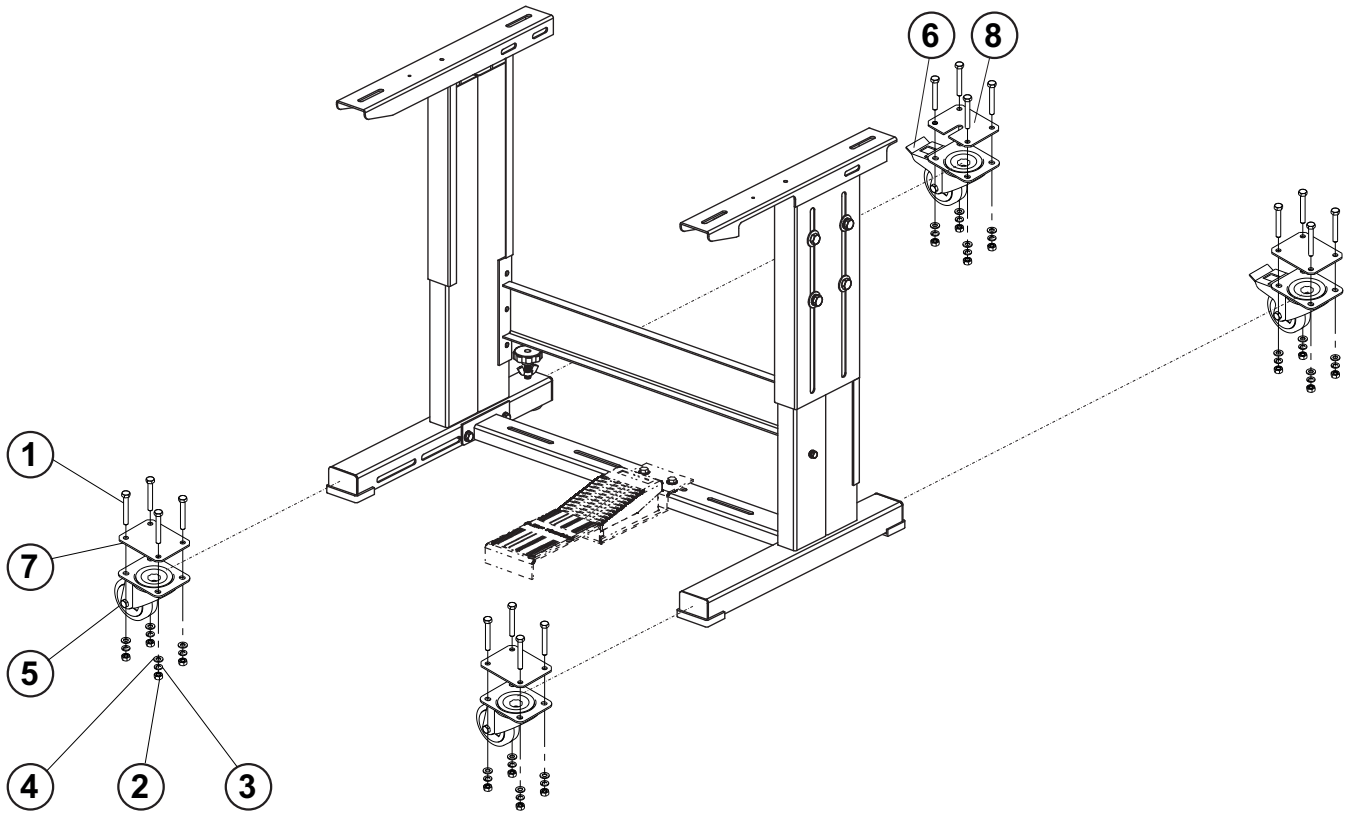
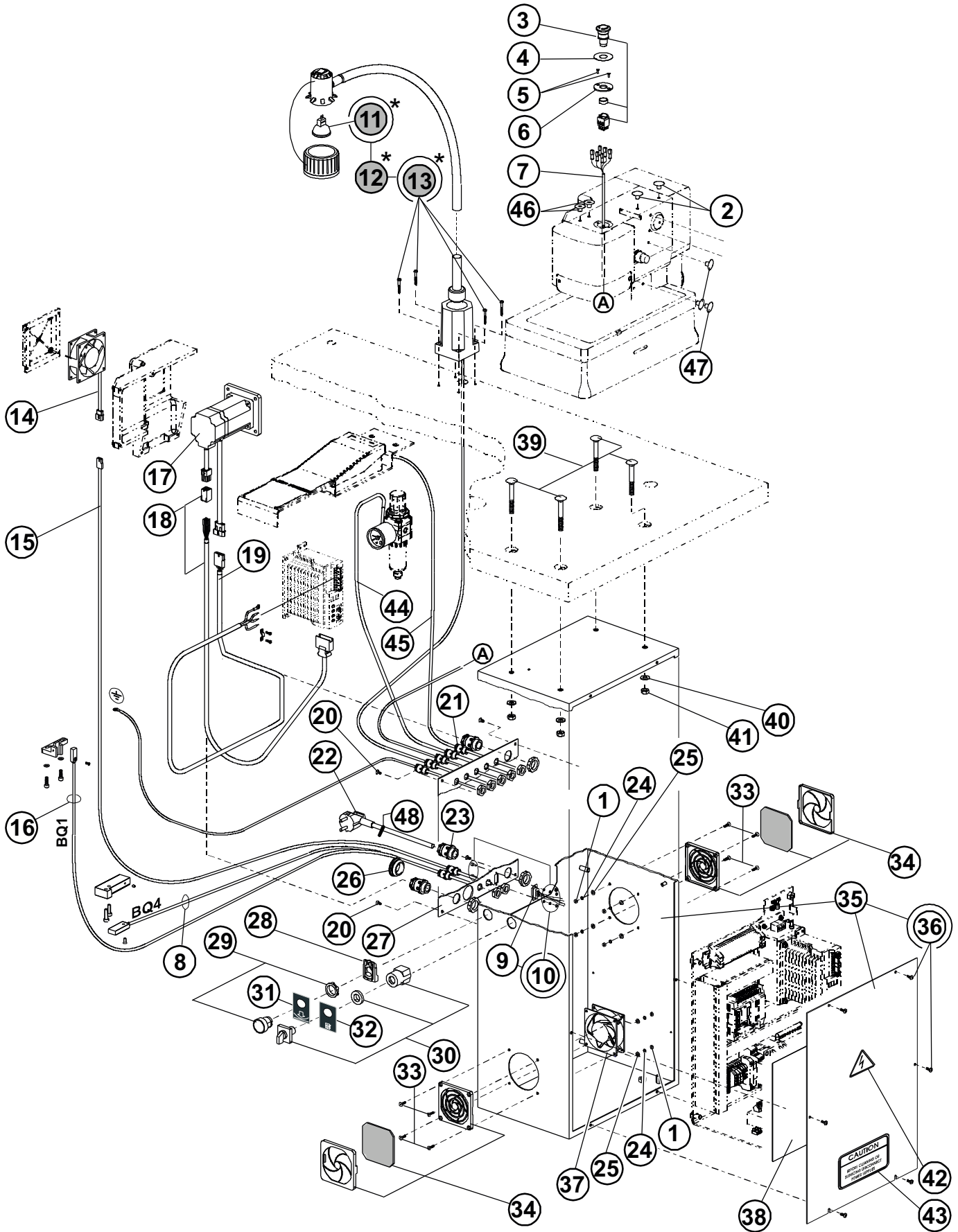


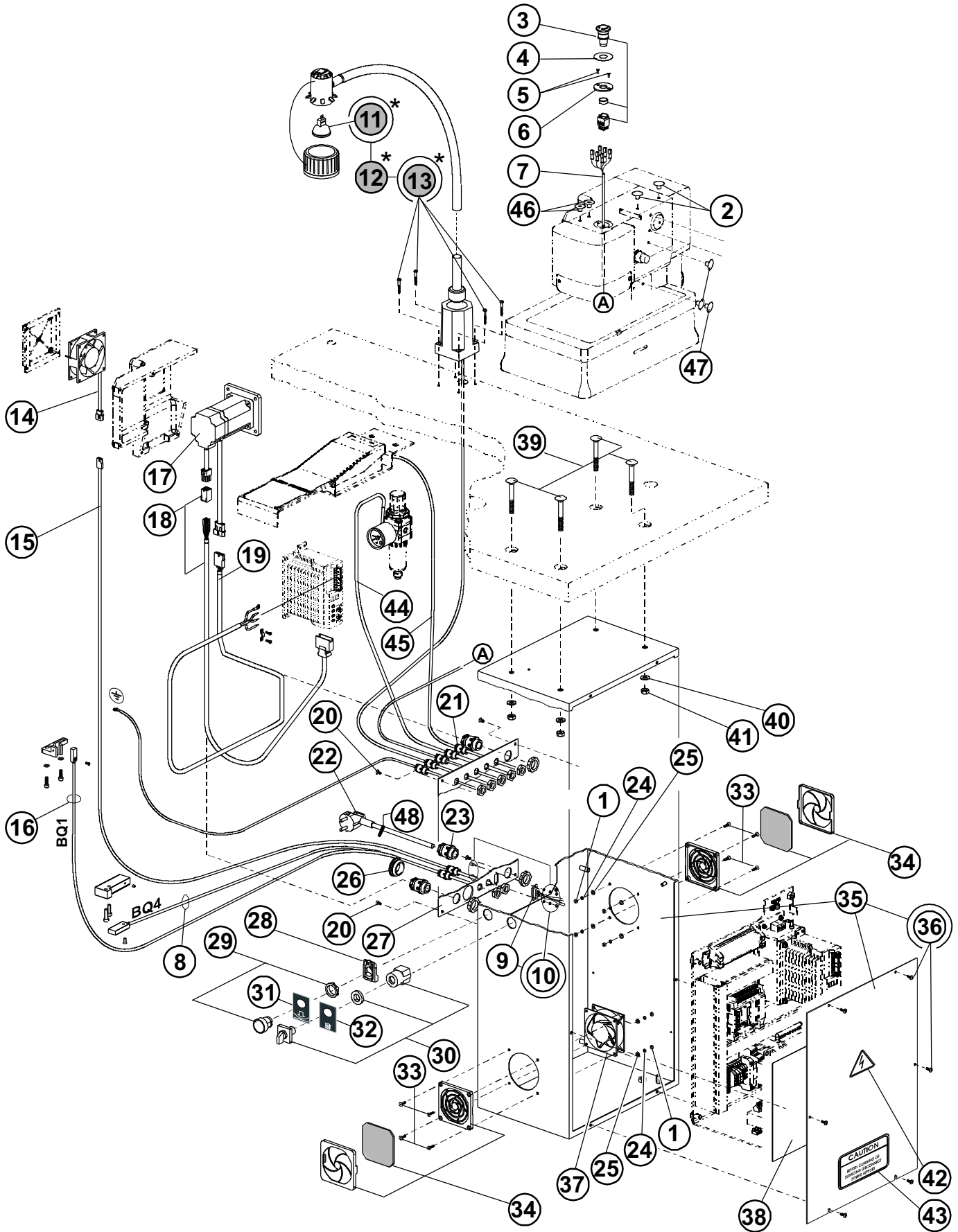
TABLE - ROLLER KIT - EXTRA PARTS

DET	PART NUMBER	DESCRIPTION	QTY.
01	08.6312.8.060	SCREW M8-60	16
02	08.6702.8.000	NUT M8	16
03	08.6802.8.000	SPRING WASHER M8	16
04	08.6852.8.000	WASHER M8	16
05	12.0008.6.527	ROLLER	2
06	12.0008.6.528	ROLLER WITH BRAKE	2
07	24.0170.0.000	PLATE	3
08	24.0171.0.000	PLATE	1

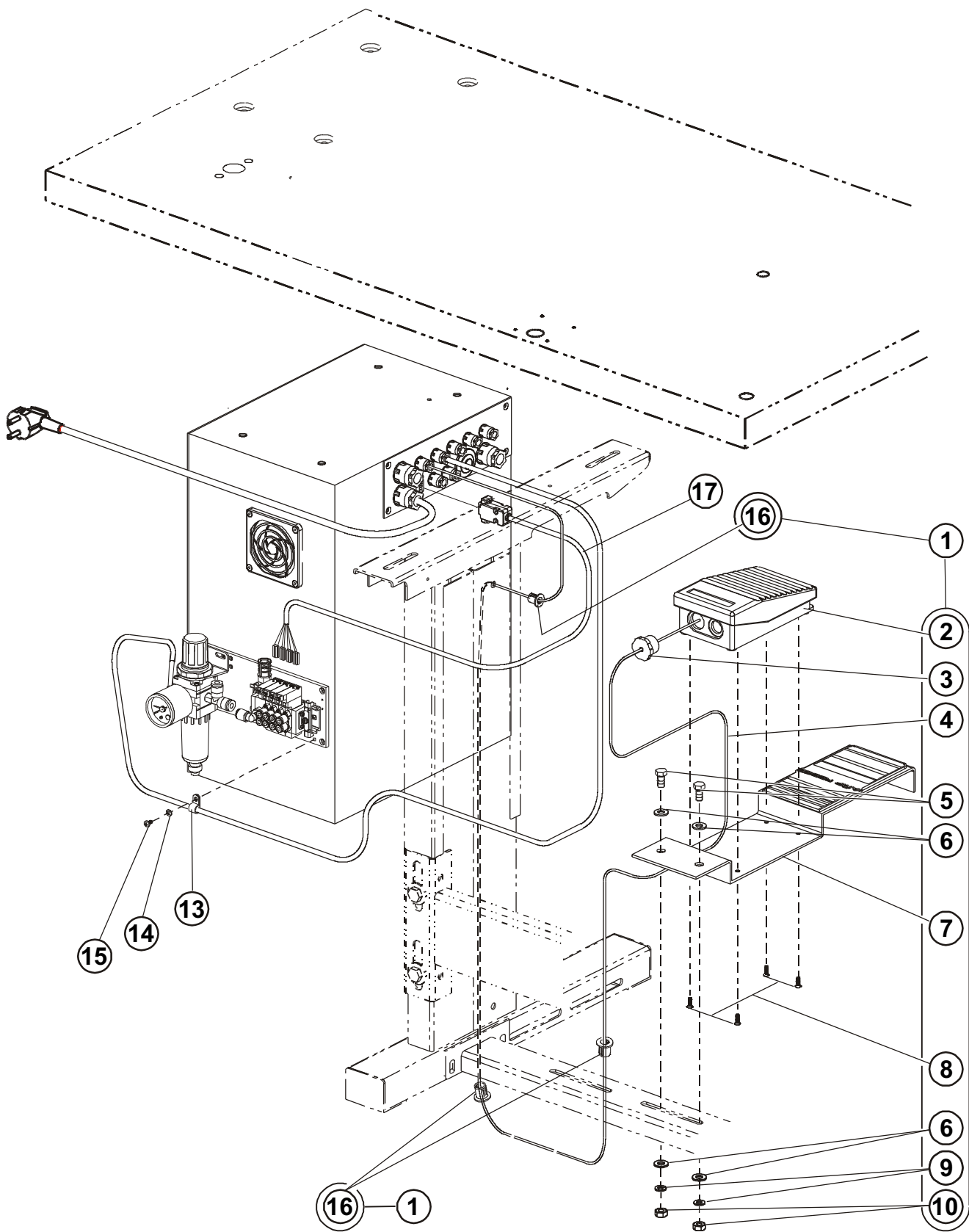
ELECTRICAL — I



ELECTRICAL — I



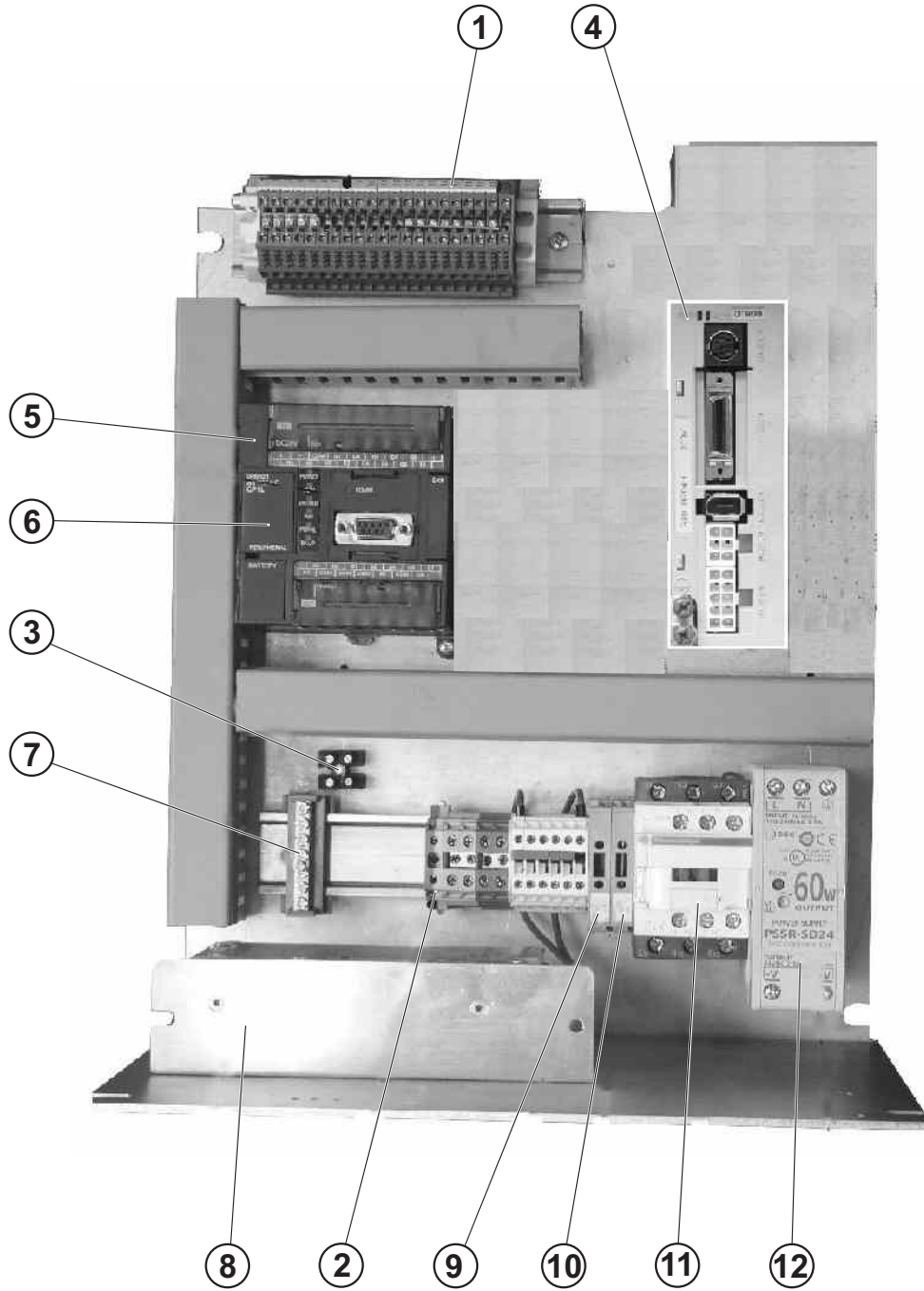
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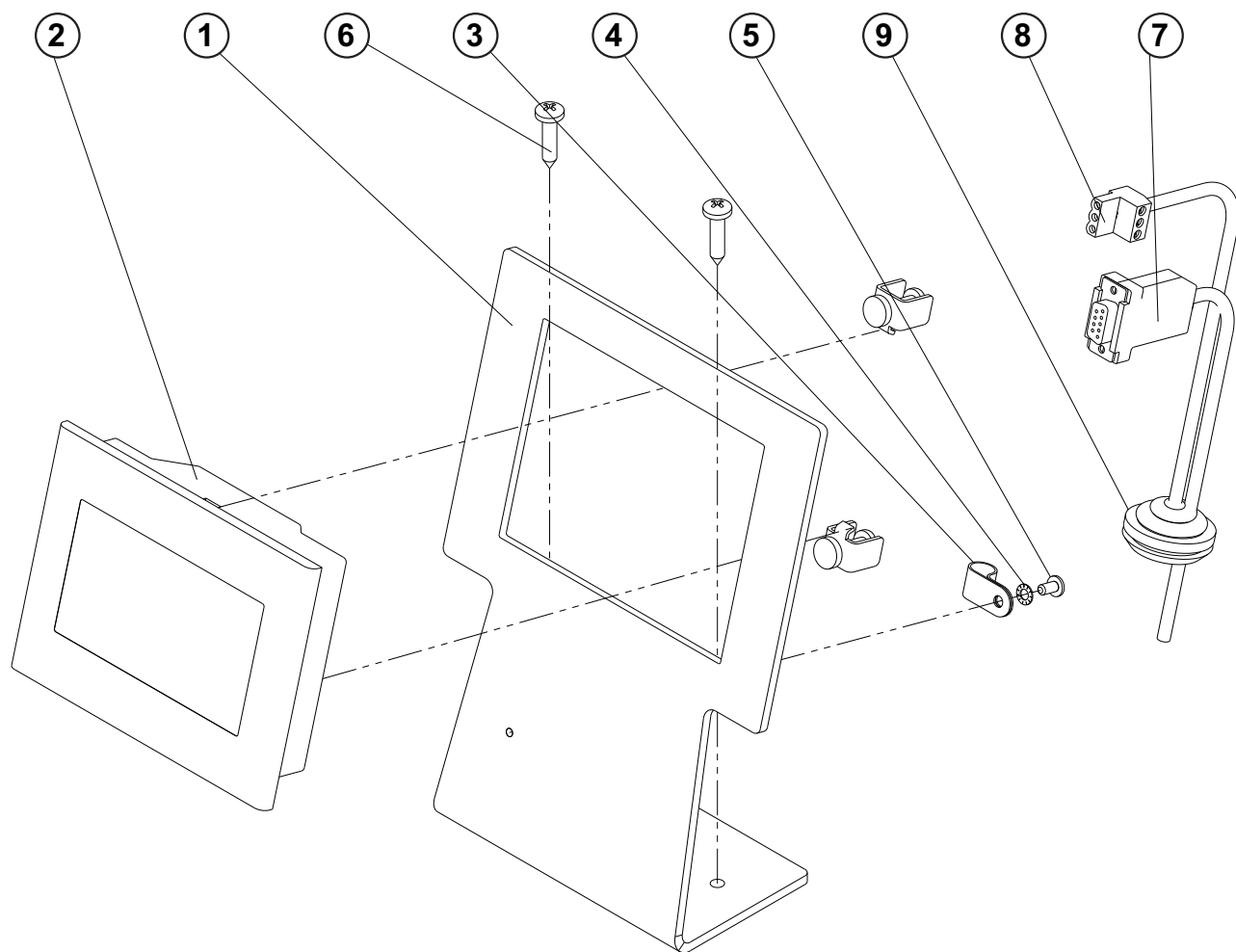
ELECTRICAL — II

DET	PART NUMBER	DESCRIPTION	QTY.
1	24.0069.9.009	Pedal Assembly	1
2	06.8800.0.001	Pedal ●●● (1)	(1)
3	12.0008.4.296	Bushing ●●● (1)	(1)
4	24.0069.9.003	Cable	(1)
5	08.6312.8.020	Screw M8x20	(2)
6	08.6852.8.000	Washer M8	(4)
7	24.0097.0.000	Holder Pedal	(1)
8	08.6100.4.012	Screw M4x12	(4)
9	08.6802.8.000	Spring Washer M8	(2)
10	08.6702.8.000	Nut M8	(2)
11			
12			
13	12.0008.4.280	Cord Clamp	1
14	08.6852.4.000	Washer M4	1
15	08.6683.4.007	Screw M4x7	1
16	12.0008.4.214	Bushing	(3)
17	12.0008.3.879	Cable Valve	1

ELECTRICAL — III



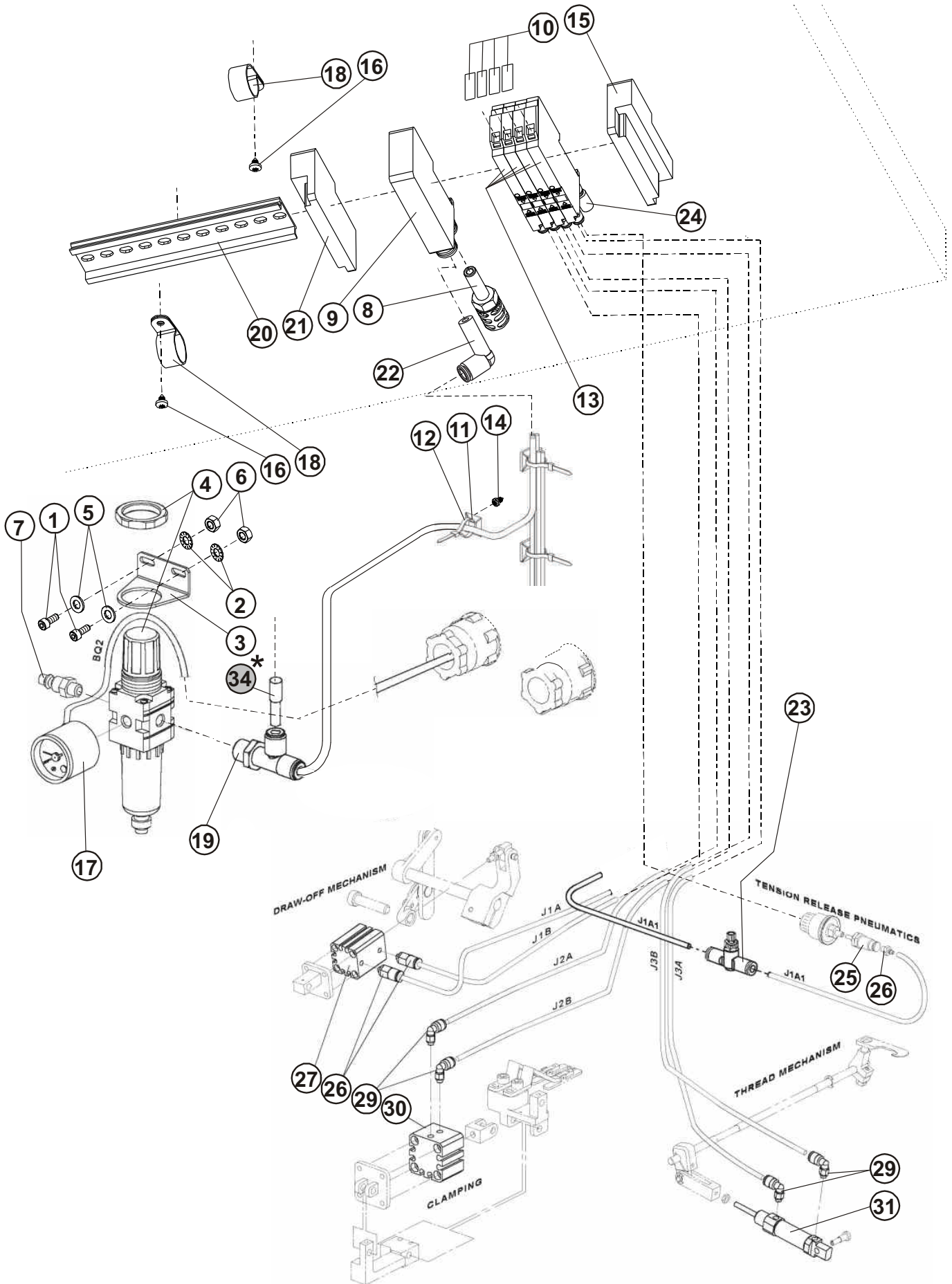
PANEL KIT



PANEL KIT

DET	PART NUMBER	DESCRIPTION	QTY.
01	24.0198.0.000	PANEL HOLDER-DELTA	1
02	24.8001.2.023	DISPLAY	1
03	07.6600.0.004	CLAMP CABLE	1
04	08.6832.4.000	WASHER M4	1
05	08.6032.4.008	SCREW M4-8	1
06	08.6663.5.025	SCREW 4,8-25	2
07	06.2400.0.023	CABLE DISPLAY DELTA	1
08	06.2400.0.019	CABLE DISPLAY DELTA POWER	1
09	12.0008.4.366	RUBBER PLUG 29	1

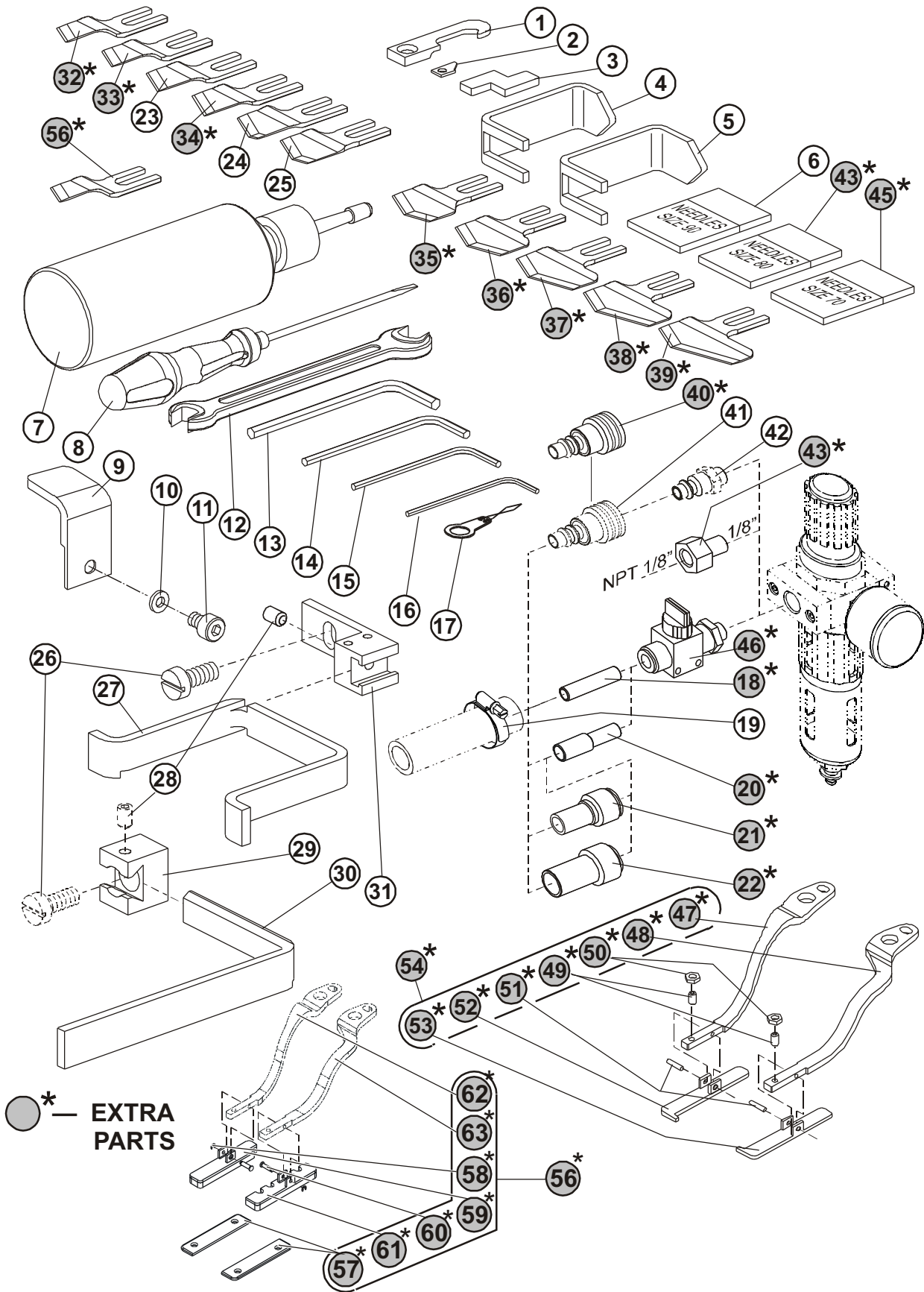
PNEUMATICS



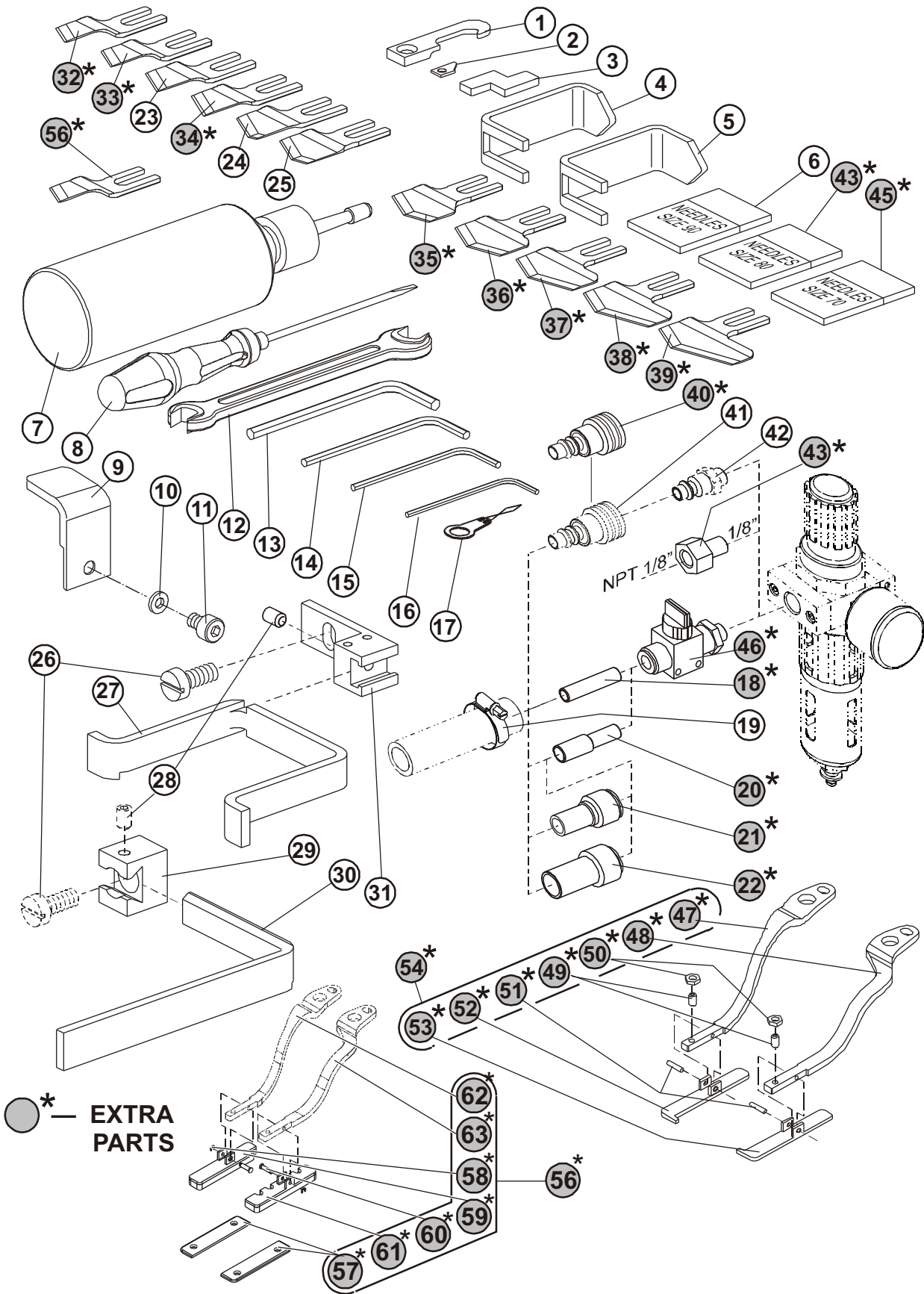
PNEUMATICS

DET	PART NUMBER	DESCRIPTION	QTY.
01	08.6000.5.012	Screw M4x12	2
02	08.6832.5.000	Washer M5	1
03	12.0010.3.138	Regulator Holder	1
04	12.0010.3.137	Regulator	1
05	08.6850.5.000	Washer M4	2
06	08.6700.5.000	Nut M4	2
07	12.0008.3.420	Connector	1
08	12.0010.3.030	Silencer	1
09	12.0008.3.829	Air Supply Block Assembly	1
10	12.8000.0.016	Label Kit	1
11	12.0008.4.058	Clip	●●● 4
12	12.0008.3.023	Ty-wrap	●●● 4
13	12.0008.3.828	Pneumatic Valve	4
14	08.6662.3.006	Screw	2
15	12.0008.3.830	Rail Stopper	1
16	08.6683.4.007	Screw	2
17	12.0008.3.418	Pressure Gauge	1
18	12.0008.4.280	Clamp	2
19	12.0010.3.032	Connector	1
20	12.0008.3.832	DIN Rail	1
21	12.0008.3.831	Rail Stopper	1
22	12.0010.3.031	Connector	●●● 1
23	12.0010.3.029	Speed Controller	●●● 1
24	12.0008.3.426	Plug	1
25	12.0008.3.413	Cylinder	1
26	12.0010.3.027	Connector	3
27	12.0008.3.433	Knife Cylinder	1
29	12.0010.3.028	Connector	●●● 4
30	12.0008.3.412	Clamp Cylinder	● 1
31	24.0050.1.000	Trimmer Cylinder	1
32	24.0145.1.000	Air Tubing Kit	●●● 1
34*	12.0008.3.437	Plug	1

ACCESSORIES — EXTRA PARTS



ACCESSORIES — EXTRA PARTS



INDEX

PART NUMBER	PAGE	DET	QTY	PART NUMBER	PAGE	DET	QTY	PART NUMBER	PAGE	DET	QTY
00.2751.3.602	3-43	43	1	07.6440.0.036	3-15	21	3	08.6000.6.016	3-3	22	2
01.1382.0.000	3-15	06	1	07.6440.0.037	3-23	04	2	08.6000.6.016	3-27	31	2
01.1397.0.000	3-15	11	4	07.6440.0.040	3-9	16	1	08.6000.6.025	3-3	31	1
01.2084.0.000	3-5	10	1	07.6440.0.041	3-11	11	1	08.6000.6.025	3-19	01	1
01.2193.0.000	3-3	2	1	07.6440.0.045	3-23	27	1	08.6000.6.025	3-25	29	2
01.2376.0.000	3-5	17	4	07.6440.0.050	3-11	18	1	08.6000.6.030	3-3	15	(1)
01.2386.0.000	3-7	03	1	07.6440.0.051	3-25	10	1	08.6000.8.025	3-25	07	2
01.6551.0.000	3-3	7	1	07.6600.0.004	3-49	03	1	08.6000.8.030	3-37	02	(4)
01.6551.0.000	3-21	17	1	08.6000.3.006	3-21	29	1	08.6000.8.040	3-25	12	2
01.7447.1.000	3-3	5	1	08.6000.3.006	3-27	15	1	08.6010.5.008	3-53	26	1
01.7447.1.000	3-21	15	1	08.6000.3.006	3-31	11	1	08.6012.4.010	3-17	11	1
01.7804.0.000	3-3	18	1	08.6000.3.010	3-11	38	1	08.6032.4.008	3-49	05	1
01.7805.0.000	3-3	23	1	08.6000.3.010	3-15	17	1	08.6032.4.010	3-41	36	(6)
01.7805.0.000	3-27	37	2	08.6000.3.010	3-19	06	1	08.6100.3.008	3-19	05	2
01.7806.0.000	3-25	18	2	08.6000.3.016	3-29	09	4	08.6100.3.008	3-27	21	2
01.7809.0.000	3-3	17	1	08.6000.3.040	3-29	08	1	08.6100.3.016	3-25	37	1
02.0750.2.100	3-55	44*	0	08.6000.4.005	3-9	05	4	08.6100.3.030	3-11	01	2
02.0750.2.109	3-55	45*	0	08.6000.4.005	3-13	58	2	08.6100.4.006	3-9	21	1
02.0750.2.110	3-3	32	1	08.6000.4.005	3-25	20	1	08.6100.4.006	3-27	8	2
02.0750.2.110	3-53	06	10	08.6000.4.005	3-53	11	1	08.6100.4.010	3-41	20	4
04.1416.0.003	3-33	09	(1)	08.6000.4.006	3-21	39	1	08.6100.4.012	3-23	15	1
04.1416.0.003	3-35	09	(1)	08.6000.4.006	3-27	20	1	08.6100.4.012	3-45	8	(4)
04.1416.0.003	3-37	09	(1)	08.6000.4.006	3-29	15	2	08.6100.4.014	3-41	33	1
04.9000.2.123	3-33	15	1	08.6000.4.006	3-31	04	2	08.6100.5.010	3-23	09	1
04.9000.2.123	3-35	15	1	08.6000.4.010	3-9	01	2	08.6100.5.012	3-5	14	2
04.9000.2.123	3-37	15	1	08.6000.4.010	3-21	07	1	08.6100.5.012	3-17	02	5
05.1322.0.000	3-53	07	1	08.6000.4.012	3-7	07	1	08.6100.5.016	3-29	01	7
06.2400.0.019	3-49	08	1	08.6000.4.012	3-21	38	1	08.6100.5.020	3-15	04	2
06.2400.0.023	3-49	07	1	08.6000.4.014	3-13	45	2	08.6100.5.020	3-17	07	1
06.8800.0.001	3-45	2	(1)	08.6000.4.014	3-15	25	2	08.6100.5.020	3-25	26	3
07.6045.0.009	3-11	19	2	08.6000.4.014	3-19	08	2	08.6100.6.035	3-27	17	1
07.6045.0.034	3-11	30	1	08.6000.4.014	3-27	2	1	08.6100.8.012	3-37	26	(6)
07.6045.0.037	3-11	16	2	08.6000.4.016	3-9	03	4	08.6100.8.020	3-37	18	(4)
07.6045.0.037	3-25	09	1	08.6000.4.016	3-21	32	2	08.6102.3.008	3-41	05	2
07.6045.0.042	3-7	09	1	08.6000.4.016	3-27	44	1	08.6120.3.008	3-27	3	7
07.6045.0.042	3-21	04	1	08.6000.4.025	3-11	32	2	08.6200.4.008	3-29	17	2
07.6045.0.046	3-5	01	2	08.6000.4.070	3-29	07	4	08.6200.4.016	3-21	22	2
07.6045.0.053	3-25	21	1	08.6000.5.008	3-21	40	1	08.6200.5.008	3-25	05	1
07.6045.0.054	3-27	11	1	08.6000.5.012	3-5	07	1	08.6200.5.012	3-17	03	6
07.6321.0.001	3-23	11	1	08.6000.5.012	3-51	01	2	08.6200.5.020	3-17	16	1
07.6321.0.025	3-13	50	2	08.6000.5.016	3-3	37	1	08.6215.4.006	3-43	46	2
07.6321.0.025	3-19	16	2	08.6000.5.016	3-21	03	1	08.6300.0.070	3-37	35	(2)
07.6321.0.029	3-19	13	(2)	08.6000.5.016	3-25	03	8	08.6310.6.035	3-25	49	1
07.6321.0.030	3-13	61	(1)	08.6000.5.016	3-27	26	3	08.6312.8.020	3-45	5	(2)
07.6440.0.018	3-13	41	2	08.6000.5.020	3-11	15	2	08.6312.8.060	3-39	01	16
07.6440.0.028	3-11	23	2	08.6000.5.022	3-5	05	4	08.6400.3.003	3-21	31	1
07.6440.0.028	3-19	18	2	08.6000.5.040	3-21	10	4	08.6400.3.004	3-27	23	2
07.6440.0.033	3-11	08	2	08.6000.6.008	3-5	30	2	08.6400.3.005	3-3	12	4

INDEX

PART NUMBER	PAGE	DET	QTY	PART NUMBER	PAGE	DET	QTY	PART NUMBER	PAGE	DET	QTY
08.6400.3.006	3-5	27	2	08.6700.8.000	3-35	02	(4)	08.6852.8.000	3-39	04	16
08.6400.3.006	3-55	49*	0	08.6702.4.000	3-41	1	8	08.6852.8.000	3-45	6	(4)
08.6400.3.020	3-23	29	1	08.6702.8.000	3-33	21	(4)	08.6887.5.000	3-9	17	1
08.6400.4.004	3-3	21	2 (2)	08.6702.8.000	3-35	21	(4)	12.0008.3.023	3-25	13	1
08.6400.4.004	3-5	08	2	08.6702.8.000	3-37	21	(4)	12.0008.3.023	3-31	14	1
08.6400.4.004	3-15	01	2	08.6702.8.000	3-39	02	16	12.0008.3.023	3-51	12	4
08.6400.4.004	3-19	27	1	08.6702.8.000	3-45	10	(2)	12.0008.3.081	3-55	43*	0
08.6400.4.004	3-21	26	1	08.6710.0.300	3-37	33	(4)	12.0008.3.251	3-53	19	1
08.6400.4.005	3-9	22	1	08.6710.3.000	3-5	26	2	12.0008.3.412	3-51	30	1
08.6400.4.005	3-11	28	6	08.6710.3.000	3-55	50*	0	12.0008.3.413	3-51	25	1
08.6400.4.005	3-19	20	1	08.6710.5.000	3-13	52	2	12.0008.3.418	3-51	17	1
08.6400.4.005	3-53	28	1	08.6710.5.000	3-15	23	2	12.0008.3.420	3-51	07	1
08.6400.4.012	3-5	21	1	08.6710.6.000	3-21	01	1	12.0008.3.420	3-55	42	0
08.6400.5.005	3-3	4	1	08.6733.3.000	3-11	24	2	12.0008.3.426	3-51	24	1
08.6400.5.005	3-5	18	1	08.6742.8.000	3-33	11	(4)	12.0008.3.433	3-51	27	1
08.6400.5.005	3-11	33	1	08.6742.8.000	3-35	11	(4)	12.0008.3.437	3-51	34*	1
08.6400.5.005	3-25	27	2	08.6742.8.000	3-37	11	(4)	12.0008.3.463	3-55	46*	0
08.6400.5.005	3-27	12	2	08.6752.8.000	3-33	22	(4)	12.0008.3.464	3-53	18*	1
08.6400.5.008	3-25	28	2	08.6752.8.000	3-35	22	(4)	12.0008.3.465	3-53	22*	1
08.6400.5.010	3-25	17	1	08.6752.8.000	3-37	22	(4)	12.0008.3.466	3-53	20*	1
08.6400.5.010	3-27	13	2	08.6800.4.000	3-13	43	2	12.0008.3.467	3-53	21*	1
08.6400.5.305	3-11	13	4	08.6800.4.000	3-15	26	2	12.0008.3.607	3-53	40*	0
08.6400.5.305	3-27	33	6	08.6800.4.000	3-21	19	2	12.0008.3.608	3-55	41	0
08.6532.8.055	3-33	19	(4)	08.6802.4.000	3-41	24	4	12.0008.3.828	3-51	13	4
08.6532.8.055	3-35	19	(4)	08.6802.8.000	3-39	03	16	12.0008.3.829	3-51	09	1
08.6532.8.055	3-37	19	(4)	08.6802.8.000	3-45	9	(2)	12.0008.3.830	3-51	15	1
08.6662.3.006	3-51	14	2	08.6832.4.000	3-17	12	1	12.0008.3.831	3-51	21	1
08.6663.5.025	3-33	13	10	08.6832.4.000	3-49	04	1	12.0008.3.832	3-51	20	1
08.6663.5.025	3-35	13	10	08.6832.5.000	3-51	02	1	12.0008.3.879	3-45	17	1
08.6663.5.025	3-37	13	10	08.6850.0.000	3-37	34	(4)	12.0008.4.050	3-47	7	1
08.6663.5.025	3-49	06	2	08.6850.3.000	3-21	27	1	12.0008.4.052	3-17	10	1
08.6683.4.007	3-45	15	1	08.6850.4.000	3-21	18	2	12.0008.4.058	3-51	11	4
08.6683.4.007	3-51	16	2	08.6850.4.000	3-27	19	1	12.0008.4.100	3-17	17	1
08.6700.3.000	3-23	30	1	08.6850.4.000	3-53	10	1	12.0008.4.155	3-43	42	1
08.6700.3.000	3-25	38	1	08.6850.5.000	3-23	20	1	12.0008.4.197	3-17	08	1
08.6700.4.000	3-5	22	1	08.6850.5.000	3-25	02	7	12.0008.4.207	3-41	21	7
08.6700.4.000	3-7	11	1	08.6850.5.000	3-27	25	2	12.0008.4.214	3-45	16	(3)
08.6700.4.000	3-21	33	1	08.6850.5.000	3-29	04	4	12.0008.4.231	3-41	23	3
08.6700.5.000	3-17	09	2	08.6850.5.000	3-51	05	2	12.0008.4.280	3-45	13	1
08.6700.5.000	3-19	24	2	08.6850.6.000	3-25	30	2	12.0008.4.280	3-51	18	2
08.6700.5.000	3-23	19	1	08.6850.8.000	3-13	56	1	12.0008.4.296	3-45	3	(1)
08.6700.5.000	3-25	34	3	08.6850.8.000	3-15	32	1	12.0008.4.366	3-41	26	1
08.6700.5.000	3-51	06	2	08.6852.4.000	3-41	25	4	12.0008.4.366	3-49	09	1
08.6700.6.000	3-25	50	1	08.6852.4.000	3-45	14	1	12.0008.4.403	3-41	12*	1
08.6700.6.000	3-37	31	(1)	08.6852.6.000	3-7	13	1	12.0008.4.563	3-41	03	1
08.6700.8.000	3-13	57	1	08.6852.8.000	3-33	20	(4)	12.0008.4.570	3-41	02	2
08.6700.8.000	3-15	33	1	08.6852.8.000	3-35	20	(4)	12.0008.4.598	3-25	35	1
08.6700.8.000	3-33	02	(4)	08.6852.8.000	3-37	20	(4)	12.0008.4.664	3-47	10	1

INDEX

PART NUMBER	PAGE	DET	QTY	PART NUMBER	PAGE	DET	QTY	PART NUMBER	PAGE	DET	QTY
12.0008.4.665	3-47	9	1	12.1045.2.001	3-3	29	1	22.0020.0.000	3-19	22	1
12.0008.4.679	3-41	11*	(1)	12.1045.2.001	3-27	36	1	22.0021.0.000	3-13	47	1
12.0008.4.710	3-41	10	1	12.1045.3.001	3-7	04	1	22.0021.0.000	3-15	27	1
12.0008.4.713	3-41	22	1	12.2010.1.002	3-15	14	2	22.0022.0.000	3-13	55	1
12.0008.4.762	3-41	34	2	12.2050.0.003	3-3	20	1	22.0022.0.000	3-15	31	1
12.0008.4.833	3-47	11	1	12.2050.0.005	3-27	30	1	22.0023.0.000	3-15	28	1
12.0008.4.835	3-41	30	1	12.4030.0.002	3-27	27	1	22.0024.0.000	3-15	22	1
12.0008.4.861	3-41	29	1	12.5050.2.009	3-25	15	1	22.0026.0.000	3-11	40	1
12.0008.4.863	3-41	28	1	12.8000.0.016	3-17	06	1	22.0027.0.000	3-19	19	1
12.0008.6.001	3-53	08	1	12.8000.0.016	3-51	10	1	22.0028.0.000	3-19	17	2
12.0008.6.100	3-53	16	1	12.8000.0.040	3-41	32	1	22.0029.0.000	3-19	15	2
12.0008.6.101	3-53	14	1	12.8000.0.041	3-41	31	1	22.0030.0.000	3-19	26	1
12.0008.6.102	3-53	13	1	12.8000.0.045	3-41	38	1	22.0031.0.000	3-13	51	2
12.0008.6.105	3-53	17	1	12.8000.0.047	3-41	04	1	22.0031.0.000	3-15	15	2
12.0008.6.109	3-53	12	1	12.8000.0.112	3-43	48	1	22.0032.0.000	3-13	49	2
12.0008.6.112	3-53	15	1	17.0019.0.441	3-33	03	(4)	22.0033.0.000	3-19	25	1
12.0008.6.527	3-39	05	2	17.0019.0.441	3-35	03	(4)	22.0044.0.000	3-53	31	1
12.0008.6.528	3-39	06	2	17.0019.0.441	3-37	03	(4)	22.0046.0.000	3-21	16	1
12.0008.6.800	3-19	23	1	17.0019.0.517	3-11	37	1	22.0049.0.000	3-11	31	1
12.0008.6.801	3-33	06	(4)	17.0019.2.057	3-11	25	1	22.0054.0.000	3-25	06	1
12.0008.6.801	3-35	06	(4)	17.0027.1.799	3-31	09	1	22.0057.0.000	3-29	14	1
12.0008.6.807	3-37	25	(2)	17.0031.0.460	3-5	25	2	22.0058.0.000	3-25	08	1
12.0008.6.900	3-33	05	(1)	17.0031.0.460	3-55	51*	0	22.0061.0.000	3-11	07	1
12.0008.6.900	3-35	05	(1)	17.0082.6.000	3-31	10	1	22.0062.0.000	3-25	11	1
12.0008.6.900	3-37	05	(1)	17.0082.8.082	3-25	23	2	22.0063.0.000	3-19	04	1
12.0008.6.901	3-33	16	(1)	17.0094.0.200	3-33	14	(4)	22.0064.0.000	3-15	16	1
12.0008.6.901	3-35	16	(1)	17.0094.0.200	3-35	14	(4)	22.0064.0.000	3-19	14	2
12.0008.6.901	3-37	16	(1)	17.0094.0.200	3-37	14	(4)	22.0069.0.000	3-19	21	1
12.0010.3.027	3-51	26	3	17.0094.5.310	3-31	12	1	22.0091.0.000	3-21	24	1
12.0010.3.028	3-51	29	4	17.0095.1.272	3-33	04	(4)	22.0096.0.000	3-27	7	1
12.0010.3.029	3-51	23	1	17.0095.1.272	3-35	04	(4)	22.0097.0.000	3-23	13	1
12.0010.3.030	3-51	08	1	17.0095.1.272	3-37	04	(8)	22.0100.0.000	3-11	34	4
12.0010.3.031	3-51	22	1	17.0095.1.329	3-31	07	1	22.0100.0.000	3-15	20	3
12.0010.3.032	3-51	19	1	20.0051.1.024	3-5	15	1	22.0100.0.000	3-19	11	4
12.0010.3.137	3-51	04	1	20.0092.0.004	3-7	02	1	22.0104.0.000	3-31	06	1
12.0010.3.138	3-51	03	1	20.0093.2.004	3-7	01	1	22.0105.0.000	3-15	29	1
12.0010.4.013	3-3	38	1	20.0093.2.004	3-53	1	1	22.0106.0.000	3-23	25	2
12.0010.4.067	3-47	6	1	20.0094.0.000	3-15	07	1	22.0107.0.000	3-31	13	1
12.0010.4.071	3-47	12	1	20.0094.0.000	3-53	02	1	22.0108.0.000	3-31	08	1
12.0010.4.078	3-47	8	1	20.0111.0.000	3-15	08	1	22.0110.0.000	3-13	54	1
12.0010.4.094	3-43	47	3	20.0112.0.000	3-15	10	1	22.0110.0.000	3-19	09	1
12.1010.2.003	3-25	33	1	22.0006.0.000	3-27	34	1	22.0114.0.000	3-11	02	1
12.1011.0.001	3-25	36	1	22.0008.0.000	3-19	02	1	22.0115.0.000	3-27	43	1
12.1016.1.000	3-33	08	(6)	22.0009.0.000	3-19	12	(1)	22.0120.0.000	3-31	05	1
12.1016.1.000	3-35	08	(6)	22.0009.0.050	3-19	28	1	22.0121.0.000	3-11	03	1
12.1016.1.000	3-37	08	(6)	22.0010.0.000	3-53	27	1	22.0137.0.000	3-23	10	2
12.1040.1.009	3-37	29	(1)	22.0011.0.000	3-53	29	1	22.0143.0.000	3-27	6	2
12.1045.0.012	3-55	58*	2	22.0012.0.000	3-53	30	1	22.0145.0.000	3-21	34	1

INDEX

PART NUMBER	PAGE	DET	QTY	PART NUMBER	PAGE	DET	QTY	PART NUMBER	PAGE	DET	QTY
22.0153.0.000	3-27	38	2	22.0400.0.000	3-9	23	1	22.3219.0.000	3-27	18	1
22.0159.0.000	3-5	20	1	22.0405.0.000	3-9	14	1	22.6002.0.000	3-25	25	1
22.0164.0.000	3-5	16	1	22.0408.1.000	3-27	9	1	22.6101.0.000	3-27	4	1
22.0173.0.000	3-5	02	2	22.0520.0.000	3-3	6	1	22.8400.0.000	3-27	39	1
22.0175.0.000	3-3	27	1	22.0525.0.000	3-3	16	(1)	23.2044.0.050	3-25	24	2
22.0177.0.000	3-3	35	2	22.0525.0.050	3-3	24	1	23.2106.0.000	3-15	09	1
22.0178.0.000	3-3	34	1	22.0530.0.000	3-3	10	1	23.2107.0.000	3-15	12	1
22.0182.0.000	3-23	12	2	22.0535.0.100	3-3	30	1	23.2356.1.049	3-55	55*	0
22.0183.0.000	3-11	39	1	22.0540.0.000	3-3	14	1	23.2356.2.050	3-53	32*	—
22.0183.0.000	3-15	18	1	22.0541.0.000	3-3	13	1	23.2356.2.051	3-53	33*	—
22.0183.0.000	3-19	07	1	22.0542.0.000	3-3	11	1	23.2356.2.052	3-21	41	1
22.0184.0.000	3-11	21	3	22.0545.0.000	3-3	25	1	23.2356.2.052	3-53	23	1
22.0186.0.000	3-11	27	1	22.0545.0.000	3-27	41	1	23.2356.2.053	3-53	34*	—
22.0195.0.000	3-3	1	1	22.1010.0.000	3-17	04	2	23.2356.2.054	3-53	24	1
22.0208.0.000	3-11	26	1	22.1415.0.050	3-21	11	1	23.2356.2.055	3-53	25	1
22.0209.0.000	3-53	03	1	22.1422.0.000	3-25	22	1	23.2356.2.056	3-53	35*	—
22.0213.0.000	3-53	09	1	22.1426.0.000	3-21	37	1	23.2356.2.057	3-53	36*	—
22.0214.0.000	3-19	10	1	22.1430.0.901	3-21	20	1	23.2356.2.058	3-53	37*	—
22.0219.0.000	3-33	17	1	22.1436.0.000	3-21	14	2	23.2356.2.059	3-53	38*	—
22.0219.0.000	3-35	17	1	22.1442.0.000	3-21	35	1	23.2356.2.060	3-53	39*	0
22.0219.0.000	3-37	17	1	22.1443.0.000	3-21	36	1	24.0001.0.000	3-3	33	1
22.0223.0.000	3-5	24	1	22.2410.0.000	3-15	03	1	24.0002.0.000	3-3	28	1
22.0223.4.000	3-55	59*	1	22.2425.0.050	3-15	19	1	24.0002.0.000	3-27	32	1
22.0224.0.000	3-5	23	1	22.2440.0.000	3-15	05	2	24.0003.0.000	3-7	06	1
22.0226.0.000	3-5	29	1	22.2442.0.000	3-15	02	2	24.0004.0.000	3-7	08	1
22.0226.0.000	3-55	62*	1	22.2600.0.000	3-23	08	1	24.0005.0.000	3-7	10	1
22.0227.0.000	3-5	28	1	22.2607.0.000	3-23	01	1	24.0006.1.000	3-7	14	1
22.0227.0.000	3-55	63*	1	22.2610.0.000	3-23	14	1	24.0009.0.000	3-21	09	1
22.0228.0.000	3-11	12	1	22.2620.0.000	3-23	06	1	24.0010.0.000	3-21	08	1
22.0229.0.000	3-31	03	2	22.2626.0.000	3-23	03	1	24.0011.0.000	3-21	05	1
22.0230.0.000	3-3	8	2	22.2627.0.000	3-23	02	2	24.0014.0.000	3-21	06	1
22.0232.0.000	3-13	53	1	22.2631.0.000	3-23	24	1	24.0016.0.000	3-25	32	1
22.0232.0.000	3-15	24	1	22.2633.0.000	3-23	23	1	24.0018.0.000	3-27	14	1
22.0233.0.000	3-15	30	1	22.2635.0.000	3-23	16	1	24.0019.0.000	3-27	29	1
22.0239.0.000	3-3	9	2	22.2637.0.000	3-23	22	1	24.0020.0.000	3-27	24	1
22.0300.0.000	3-27	40	1	22.2638.0.000	3-23	17	1	24.0021.0.000	3-27	1	1
22.0305.0.000	3-11	35	1	22.2639.0.000	3-23	18	1	24.0024.0.000	3-53	05	1
22.0309.0.000	3-11	20	(1)	22.2640.0.050	3-23	26	1	24.0027.0.000	3-27	42	2
22.0309.0.050	3-13	59	1	22.2651.0.000	3-9	15	1	24.0030.0.000	3-53	04	1
22.0312.0.000	3-11	06	1	22.2652.0.000	3-9	04	1	24.0035.0.000	3-5	06	1
22.0313.0.000	3-11	17	(1)	22.2653.0.000	3-9	02	1	24.0036.0.000	3-5	03	1
22.0315.0.000	3-11	22	1	22.2655.0.000	3-9	18	1	24.0037.0.000	3-21	02	1
22.0320.0.000	3-11	36	1	22.2656.0.000	3-9	07	1	24.0038.0.000	3-17	05	1
22.0325.0.000	3-11	10	1	22.2657.0.000	3-9	06	1	24.0039.0.000	3-21	13	1
22.0336.0.000	3-13	44	1	22.2664.0.000	3-9	24	1	24.0044.0.000	3-25	19	1
22.0353.0.000	3-13	48	3	22.2665.0.000	3-9	19	1	24.0048.0.000	3-3	26	1
22.0354.0.000	3-11	04	1	22.3003.0.000	3-23	28	1	24.0049.0.000	3-11	14	2
22.0370.0.000	3-13	46	1	22.3069.0.000	3-23	07	1	24.0050.1.000	3-51	31	1

INDEX

PART NUMBER	PAGE	DET	QTY	PART NUMBER	PAGE	DET	QTY	PART NUMBER	PAGE	DET	QTY
24.0051.0.066	3-27	16	1	24.0140.0.000	3-13	60	1				
24.0055.0.000	3-19	03	1	24.0141.0.000	3-31	01	1				
24.0059.9.017	3-41	37	1	24.0142.0.000	3-33	10	(1)				
24.0059.9.064	3-41	17	1	24.0142.0.050	3-33	01	1				
24.0059.9.065	3-33	12	1	24.0145.1.000	3-51	32	1				
24.0059.9.065	3-35	12	1	24.0148.0.000	3-41	06	1				
24.0059.9.065	3-37	12	1	24.0149.0.000	3-35	10	(1)				
24.0059.9.069	3-41	14	1	24.0149.0.050	3-35	01	1				
24.0061.0.000	3-21	28	1	24.0150.0.000	3-37	10	(1)				
24.0062.0.000	3-21	21	1	24.0150.0.050	3-37	01	1				
24.0063.0.000	3-21	25	1	24.0151.0.000	3-23	05	1				
24.0066.0.000	3-15	13	2	24.0154.0.000	3-29	16	1				
24.0067.0.000	3-29	03	1	24.0165.0.000	3-55	57*	2				
24.0068.0.000	3-29	02	1	24.0170.0.000	3-39	07	3				
24.0069.9.002	3-41	19	1	24.0171.0.000	3-39	08	1				
24.0069.9.003	3-45	4	(1)	24.0198.0.000	3-49	01	1				
24.0069.9.006	3-41	16	1	24.0224.4.000	3-55	61*	1				
24.0069.9.008	3-41	18	1	24.0351.0.000	3-11	09	1				
24.0069.9.009	3-45	1	1	24.0500.0.000	3-3	19	1				
24.0069.9.022	3-41	08	1	24.0510.0.000	3-3	3	1				
24.0069.9.023	3-41	07	1	24.0546.0.000	3-25	51	1				
24.0069.9.024	3-41	09	1	24.1000.0.000	3-27	28	1				
24.0069.9.027	3-41	15	1	24.2035.0.000	3-11	29	1				
24.0071.0.000	3-55	52*	0	24.2055.0.000	3-55	60*	2				
24.0072.0.000	3-55	53*	0	24.2400.0.000	3-27	35	1				
24.0073.0.000	3-55	47*	0	24.2630.1.000	3-23	21	1				
24.0074.0.000	3-55	48*	0	24.3209.0.000	3-5	19	1				
24.0079.0.000	3-37	23	(1)	24.3210.0.000	3-5	09	1				
24.0080.0.000	3-7	05	1	24.6000.5.000	3-25	04	1				
24.0081.0.000	3-37	06	(6)	24.6001.2.000	3-29	10	1				
24.0082.0.000	3-37	07	0	24.6003.0.000	3-29	13	1				
24.0084.0.000	3-37	28	(8)	24.6004.1.001	3-29	06	1				
24.0086.0.000	3-37	24	(1)	24.6005.1.002	3-17	13	1				
24.0087.0.000	3-37	30	(2)	24.6100.0.000	3-27	10	1				
24.0089.0.000	3-37	32	(1)	24.8001.2.001	3-47	5	1				
24.0093.0.000	3-21	23	1	24.8001.2.005	3-47	4	0				
24.0094.0.000	3-21	30	1	24.8001.2.023	3-49	02	1				
24.0097.0.000	3-45	7	(1)	24.9920.9.988	3-55	56*	0				
24.0100.0.000	3-3	36	1	24.9920.9.990	3-55	54*	0				
24.0106.1.000	3-25	31	1	70.4165.1.125	3-41	35	1				
24.0108.0.000	3-25	16	1								
24.0111.0.000	3-17	01	1								
24.0112.0.000	3-29	11	1								
24.0125.0.000	3-5	12	1								
24.0126.0.000	3-11	05	1								
24.0127.0.000	3-13	42	1								
24.0138.0.000	3-41	27	1								
24.0139.0.000	3-31	02	1								

INDEX
