

32-100

PRELIMINARY

PARTS

MANUAL

AMF REECE **AMF REECE, INC.**
Niederlassung Deutschland

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COPYRIGHT

No safeguard, safety appliance, or device attached to or forming an integral part of this machine shall be removed or made ineffective except for the purpose of making immediate repairs or adjustments.

Any such safeguard, safety appliance, or device removed or made ineffective during the repair or adjustment of such machine shall be replaced immediately upon completion of such repair or adjustment.

No machine shall be operated until such repairs or adjustments have been made and the machine is in good working condition.

Safety glasses should be worn when operating the machine.

JANUARY 1991

This illustrated parts list is published by

THE REECE CORPORATION

Gorham Industrial Park
Gorham, Maine 04038

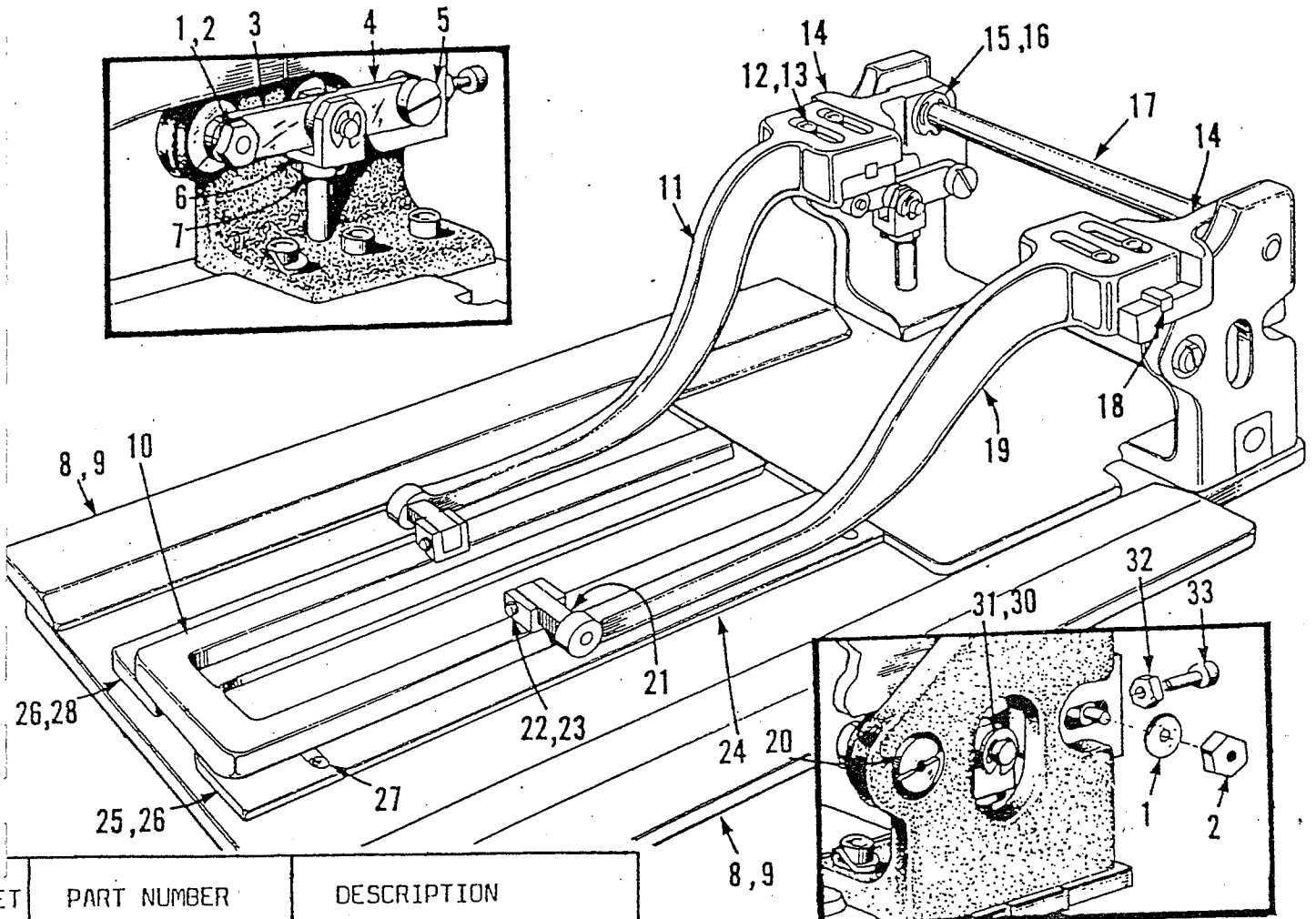
"Precision and Quality Since 1881"

P/N 97-0032-1-001
01/91
Printed in U.S.A.

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CLAMPING

1

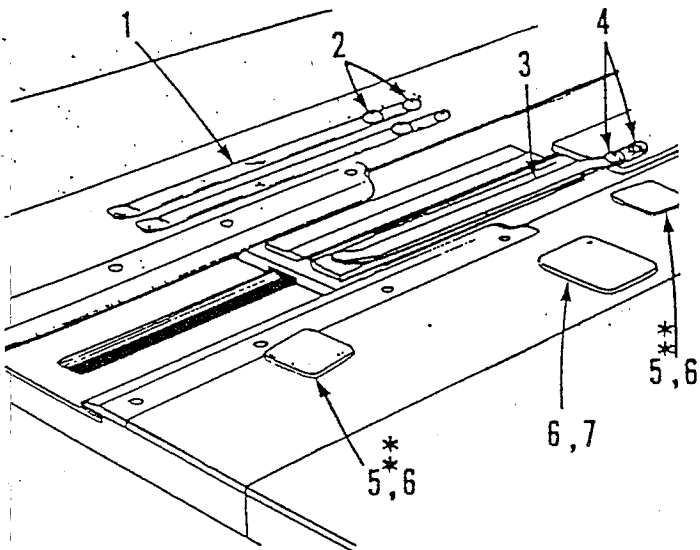


DET	PART NUMBER	DESCRIPTION
1	01-3404-0-000	Nut
02	01-4441-0-000	Washer
3	40-0085-0-000	Lever
4	40-0079-0-000	Lever
05	01-1419-0-000	Screw
06	40-0087-0-000	Link
7	01-3415-0-000	Nut
08	40-0332-1-000	Slide Plate Cover (pair)
9	01-2451-0-000	Screw
10	see page 7A	Clamp Foot
11	42-0071-0-004	Clamp Arm (left, front)
12	01-2447-0-000	Screw
13	01-4402-0-000	Washer
14	42-0071-0-007	Clamp Arm (Rear)
	32-2131-0-000	Clamp Arm (Right) Extra Wide Welt
	32-2132-0-000	Clamp Arm (Left) Extra Wide Welt
	42-0071-0-010	Clamp Arm Rear (Left) (Left) Narrow Welt
	42-0071-0-020	Clamp Arm (Rear) (Right) Extra Wide Welt

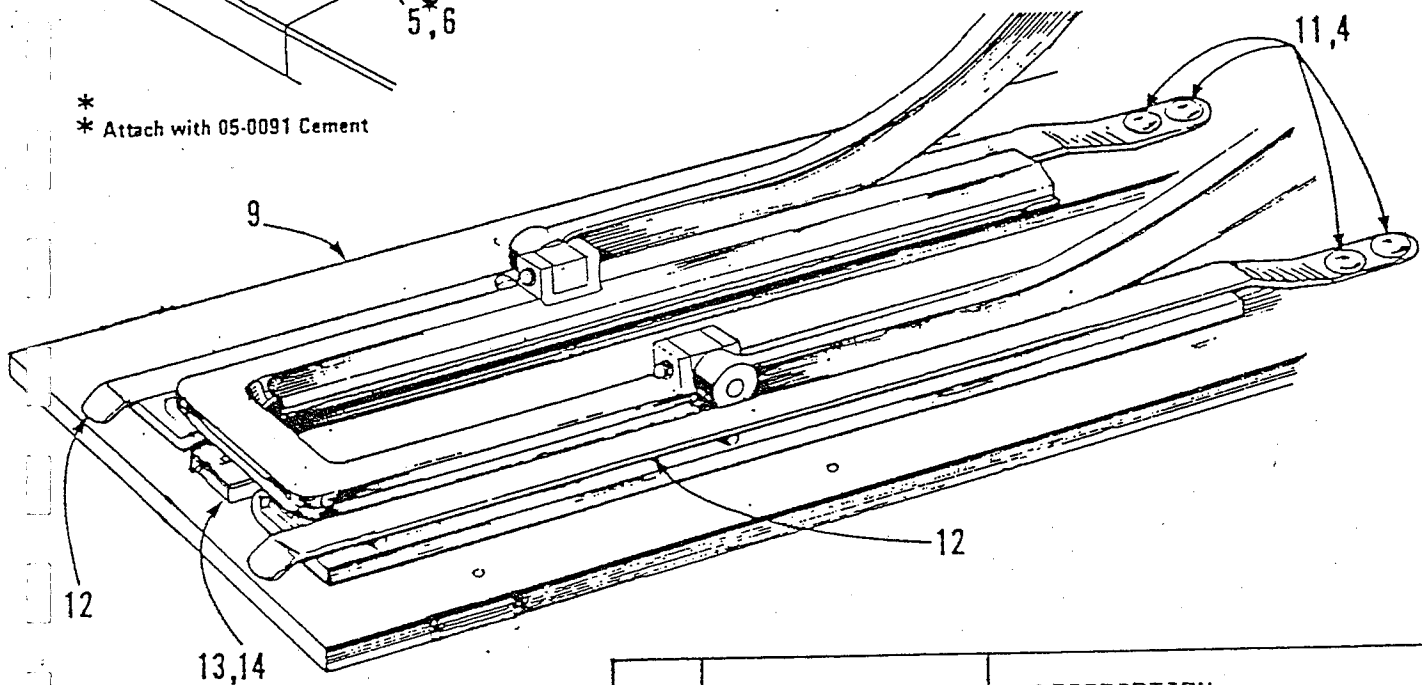
15	01-4484-0-000	Spacer
16	01-6561-0-000	Retaining Ring
17	41-0080-0-000	Slide Bar
18	01-7530-0-000	Key
19	42-0071-0-003	Clamp Arm (Right, Front)
20	01-1418-0-000	Screw
21	41-0072-0-002	Pivot Block
22	01-6477-0-000	Pin
23	01-6368-0-000	Retaining Ring
24	40-0676-0-000	Spacer (used with 1/2" support plate)
25	see page 7B	Plate Cover
26	see page 7B	Support Plate (R.H.)
27	01-2461-0-000	Screw
28	see page 7B	Support Plate (L.H.)
30	01-6489-0-000	Pin
31	01-6558-0-000	Retaining Ring
32	01-3402-0-000	Nut
33	01-2482-0-000	Screw

CLAMPING

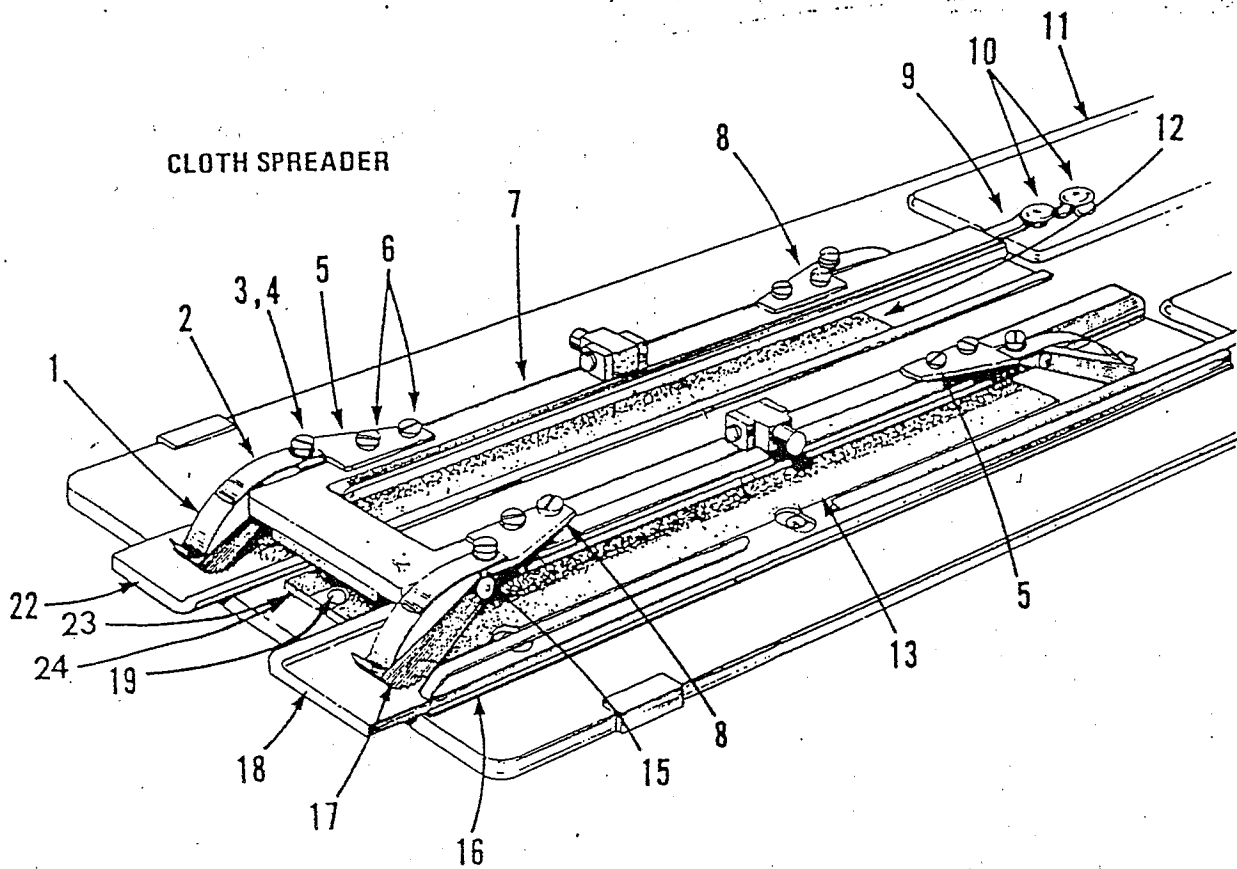
TROUSER UNIT SETUP



* Attach with 05-0091 Cement

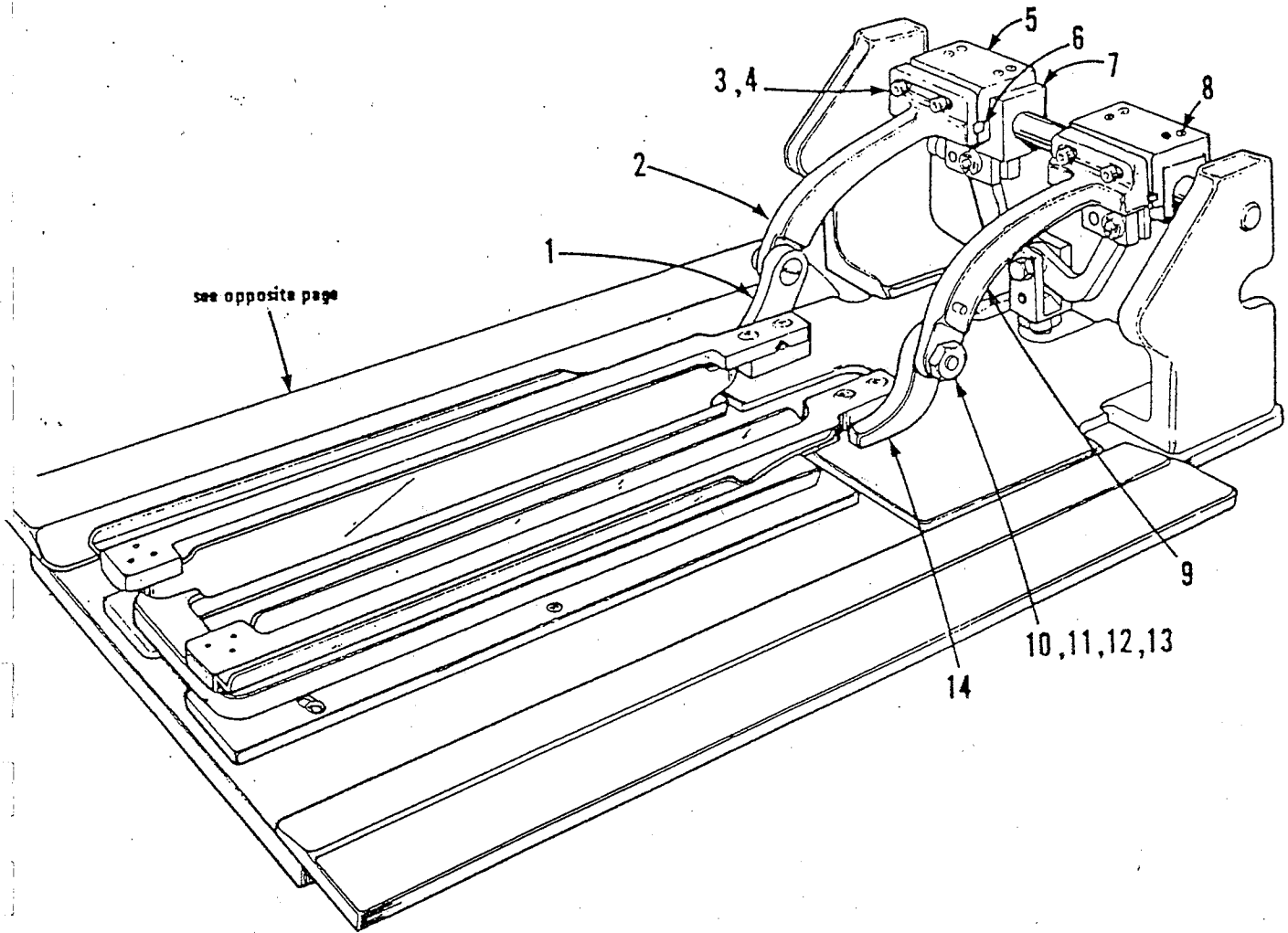


DET	PART NUMBER	DESCRIPTION
01	40-0596-0-000	Hold Down, Long
02	01-2536-0-000	Screw
03	42-0597-0-000	Hold Down
04	01-2633-0-000	Screw
05	40-0613-0-000	Gauge
06	05-0091-0-000	Contact Cement
07	40-0614-0-000	Gauge
09	32-2110-0-050	Clamp Plate Asm.
11	01-4489-0-000	Lockwasher
12	42-0595-0-002	Hold Down
13	32-1025-0-050	Block Asm. (3/8-7/16" Gray)
	32-1025-0-051	Block Asm. (1/2-7/8" Gray)
	32-2211-0-000	Block Asm. (3/8-7/16" Black)
	32-2212-0-000	Block Asm. (1/2-7/8" Black)
14	32-2209-0-000	Block Cover (3/8-7/16" Black)
	32-2210-0-000	Block Cover (1/2-7/8" Black)
	40-0717-2-375	Block Cover (3/8-7/16" Gray)
	40-0717-2-500	Block Cover (1/2-7/8" Gray)



DET	PART NUMBER	DESCRIPTION
01	01-5479-0-000	Spreader Spring
02	01-5480-0-000	Support Spring
03	01-2667-0-000	Screw
04	01-4494-0-000	Washer
05	40-0700-0-152	Foot Asm.
	40-0767-1-102	Spring Support
06	01-2597-0-000	Screw
07	see page 7A	Clamp Foot Asm.
08	40-0700-0-151	Foot Asm.
	40-0767-1-101	Spring Support
09	42-0595-0-002	Hold Down (L.H.)
	42-0597-0-002	Hold Down (R.H.)
10	01-2545-0-000	Screw
11	41-0680-0-000	Stiffener Plate
12	see page 7B	Support Patch Cover
13	see page 7B	Support Patch Cover
15	01-6519-0-000	Rollpin
16	40-0676-0-000	Spacer
17	40-0700-2-100	Spreader Foot
18	see page 7B	Support Plate (R.H.)
19	01-2523-0-000	Screw
22	see page 7B	Support Plate (L.H.)
23	see page 7C	Block Asm.
24	see page 7C	Block Cover

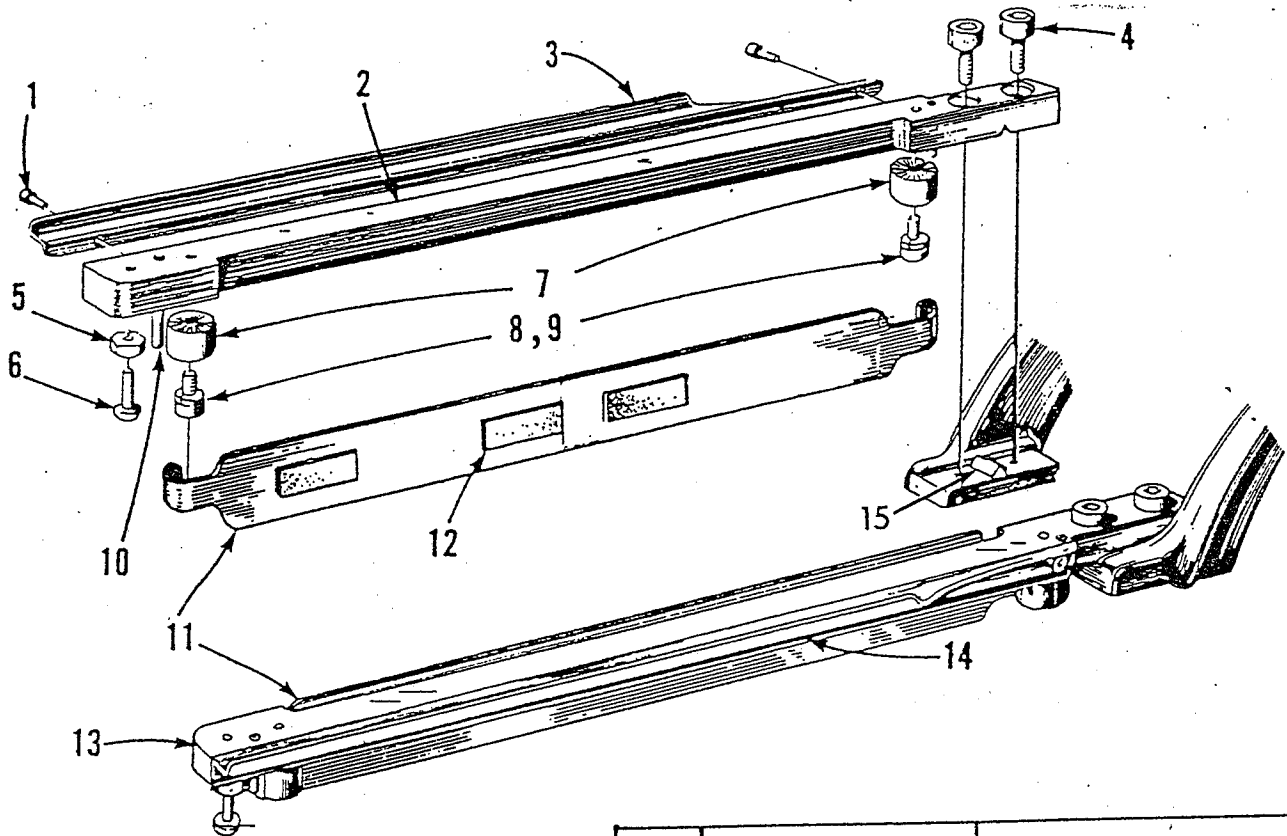
PATCH FOLDING BRUSHES



DET	PART NUMBER	DESCRIPTION
01	42-0073-0-004	Brush Arm (Lower L.H.)
02	42-0073-0-002	Brush Arm (Upper L.H.) (Upper L.H.)
	42-0073-0-010	Brush Arm Extra Wide
03	01-2412-0-000	Screw
04	01-4446-0-000	Washer
05	42-0846-1-000	Slide Block Cover
06	01-7530-0-000	Key
07	41-0433-0-000	Slide Block
08	01-2413-0-000	Screw
09	42-0073-0-001	Brush Arm (Upper R.H.)
	42-0073-0-020	Brush Arm Extra Wide (Upper R.H.)
10	01-1486-0-000	Screw
11	01-4044-0-000	Washer
12	01-3415-0-000	Nut
13	01-4672-0-003	Lockwasher
14	42-0073-0-003	Brush Arm (Lower R.H.)

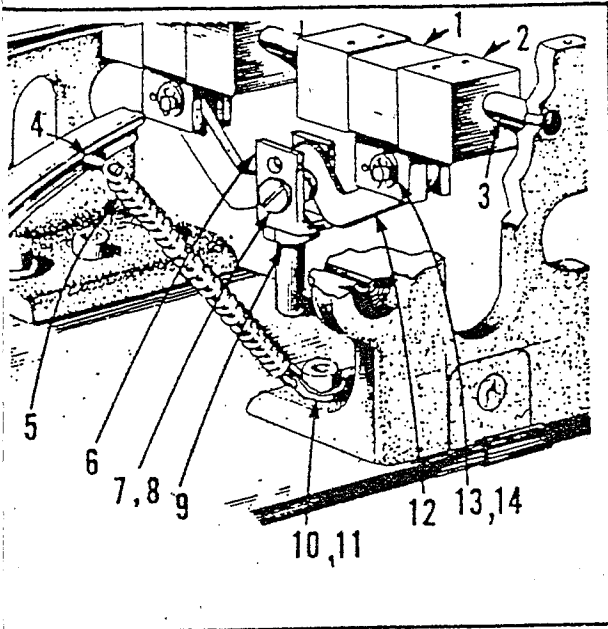
PATCH FOLDING

5

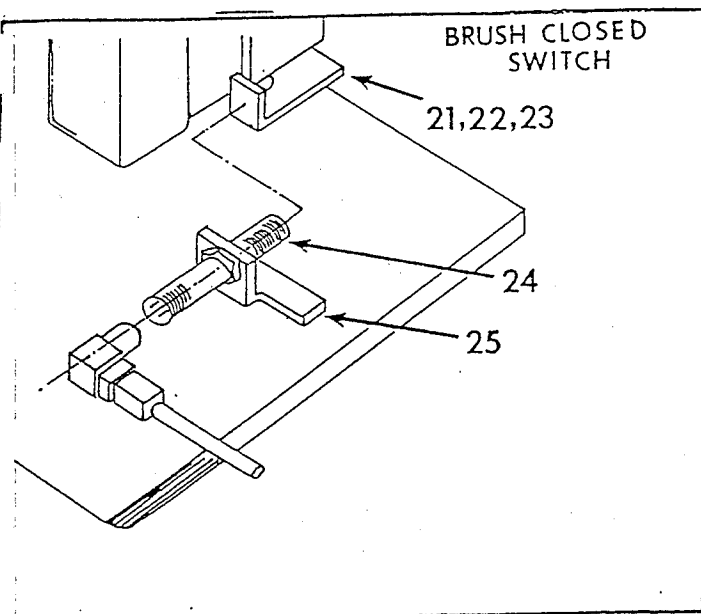
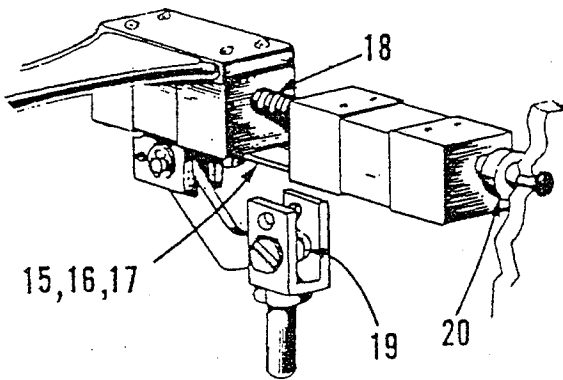


DET	PART NUMBER	DESCRIPTION
01	01-2415-0-000	Screw
02	40-0070-0-072	Brush (L.H.)(3/8"-1/2")
02	41-0070-0-072	Brush (L.H.)(5/8"-7/8")
03	chart, page 7	Patch Locator (L.H.)
04	01-2407-0-000	Screw
05	01-3426-0-000	Nut
06	01-2569-0-000	Screw
07	41-0468-0-000	Pivot
08	01-2413-0-000	Screw
09	01-4406-0-000	Washer
10	01-6521-0-000	Rollpin
11	--	Brush Blades
	41-0089-0-570	for Heavy Weight Mat.
	41-0089-0-670	Medium Weight Mat.
	41-0089-0-770	Med./Light Weight Mat.
		used on all models equipped with Automatic Patch Loaders
		Light Weight Mat.
12	41-0089-0-870	Pad, self-adhesive when working with silk lining or similar material, pads may be attached to brush blade as shown.
	40-0762-1-000	
13	40-0070-0-071	Brush (R.H. 3/8"-1/2")
	41-0070-0-071	Brush (R.H. 5/8"-7/8")
14	see pg. 7	Patch Locator (R.H.)
15	40-0476-0-000	Leveling Pin

PATCH FOLDING



ONE SIDE FOLD



DET	PART NUMBER	DESCRIPTION
01	41-0081-0-000	Slide Bracket
02	41-0433-0-000	Slide Block
03	41-0080-0-000	Slide Bar
04	01-1422-0-000	Screw, Special
05	01-5419-0-000	Spring
06	41-0088-0-000	Clevis
07	01-2580-0-000	Screw
08	01-4003-0-000	Lockwasher
09	01-3434-0-000	Nut
10	01-2404-0-000	Screw
11	40-0434-0-000	Anchor
12	41-0086-0-000	Spreader Arm
13	01-6483-0-000	Pin
14	01-6474-0-000	Retaining Ring
15	41-0796-0-000	Link
16	01-2693-0-000	Screw
17	01-4411-0-000	Lockwasher
18	01-5486-0-000	Spring
19	01-4533-0-000	Spacer
20	01-4534-0-000	Spacer
21	32-5030-0-000	Bracket
22	01-2413-0-000	Screw
23	01-4406-0-000	Lockwasher
24	06-0775-0-000	Proximity Switch,
25	32-5004-0-000	Bracket

CLAMPING AND FOLDING REPLACEMENT PARTS 7A

MODELS		CLAMPFOOT ASSEMBLY	SPREADER
SIZE	STYLE OF WELT		
3/8	DOUBLE W=.661	40-0069-0-050 (ASSY) 40-0090-0-000 (MAT)	42-0069-0-150
	DOUBLE W=.725	40-0069-0-050 (ASSY) 40-0090-0-000 (MAT)	42-0069-0-150
	SINGLE W=.661	40-0069-0-050 (ASSY) 40-0090-0-000 (MAT)	42-0069-0-150
7/16	DOUBLE W=.690	41-0069-0-053 (ASSY) 32-1036-0-000 (MAT-1 REQD) 41-0090-0-100 (MAT-2 REQD)	42-0069-0-153
	DOUBLE W=.730	41-0069-0-053 (ASSY) 32-1036-0-000 (MAT-1 REQD) 41-0090-0-100 (MAT-2 REQD)	42-0069-0-153
	SINGLE OFFSET W=.759	41-0069-0-053 (ASSY) 32-1036-0-000 (MAT-1 REQD) 41-0090-0-100 (MAT-2 REQD)	42-0069-0-153
1/2	DOUBLE W=.786	41-0069-0-053 (ASSY) 32-1036-0-000 (MAT-1 REQD) 41-0090-0-100 (MAT-2 REQD)	42-0069-0-153
	DOUBLE W=.850	41-0069-0-053 (ASSY) 32-1036-0-000 (MAT-1 REQD) 41-0090-0-100 (MAT-2 REQD)	42-0069-0-153
	SINGLE W=.801	41-0069-0-053 (ASSY) 32-1036-0-000 (MAT-1 REQD) 41-0090-0-100 (MAT-2 REQD)	42-0069-0-153
	SINGLE W=.945	41-0069-0-053 (ASSY) 32-1036-0-000 (MAT-1 REQD) 41-0090-0-100 (MAT-2 REQD)	42-0069-0-153
5/8	DOUBLE W=1.100	41-0069-0-050 (ASSY) 41-0090-0-125 (MAT-1 REQD) 41-0090-0-100 (MAT-2 REQD)	42-0069-0-154
	DOUBLE W=1.1480	41-0069-0-050 (ASSY) 41-0090-0-125 (MAT-1 REQD) 41-0090-0-100 (MAT-2 REQD)	42-0069-0-154
	SINGLE W=1.230	41-0069-0-050 (ASSY) 41-0090-0-125 (MAT-1 REQD) 41-0090-0-100 (MAT-2 REQD)	42-0069-0-154
3/4	DOUBLE W=1.350	41-0069-0-051 (ASSY) 41-0090-0-375 (MAT-1 REQD) 41-0090-0-100 (MAT-2 REQD)	42-0069-0-154
	SINGLE W=1.470	41-0069-0-051 (ASSY) 41-0090-0-375 (MAT-1 REQD) 41-0090-0-100 (MAT-2 REQD)	42-0069-0-154
	OVER LAPPING SINGLE	41-0069-0-051 (ASSY) 41-0090-0-375 (MAT-1 REQD) 41-0090-0-100 (MAT-2 REQD)	42-0069-0-154
7/8	DOUBLE W=1.655	41-0069-0-052 (ASSY) 41-0090-0-625 (MAT-1 REQD) 41-0090-0-100 (MAT-2 REQD)	42-0069-0-151
	SINGLE W=1.669	41-0069-0-052 (ASSY) 41-0090-0-625 (MAT-1 REQD) 41-0090-0-100 (MAT-2 REQD)	42-0069-0-051

CLAMPING AND FOLDING REPLACEMENT PARTS 7c

MODELS	PATCH LOCATORS (1)		BLOCK ASSEMBLY		BLOCK COVER		
	STYLE OF WELT	LEFT	RIGHT	GRAY*	BLACK **	GRAY*	BLACK **
17	DOUBLE W=.661	40-0470-0-072 (2)	40-0470-0-071	32-1025-0-050	32-2211-0-000	40-0717-2-375	32-2209-0-000
3/	DOUBLE W=.725	40-0470-0-072	40-0470-0-071	32-1025-0-050	32-2211-0-000	40-0717-2-375	32-2209-0-000
	SINGLE W=.661	40-0470-0-072	40-0470-0-071	32-1025-0-050	32-2211-0-000	40-0717-2-375	32-2209-0-000
	DOUBLE W=.690	40-0470-0-072	40-0470-0-071	32-1025-0-050	32-2211-0-000	40-0717-2-375	32-2209-0-000
1/	DOUBLE W=.730	40-0470-0-072	40-0470-0-071	32-1025-0-050	32-2211-0-000	40-0717-2-375	32-2209-0-000
5	SINGLE OFFSET W=.759	40-0470-0-072	40-0470-0-071	32-1025-0-050	32-2211-0-000	40-0717-2-375	32-2209-0-000
	DOUBLE W=.786	40-0470-0-072	40-0470-0-071	32-1025-0-051	32-2212-0-000	40-0717-2-500	32-2210-0-000
	DOUBLE W=.850	40-0470-0-072	40-0470-0-071	32-1025-0-051	32-2212-0-000	40-0717-2-500	32-2210-0-000
1/2	SINGLE W=.801	40-0470-0-072	40-0470-0-071	32-1025-0-051	32-2212-0-000	40-0717-2-500	32-2210-0-000
	SINGLE W=.945	40-0470-0-072 (4)	40-0470-0-073	32-1025-0-051	32-2212-0-000	40-0717-2-500	32-2210-0-000
	DOUBLE W=1.100	40-0470-0-074	40-0470-0-073	32-1025-0-051	32-2212-0-000	40-0717-2-500	32-2210-0-000
5 3	DOUBLE W=1.1480	40-0470-0-074	40-0470-0-073	32-1025-0-051	32-2212-0-000	40-0717-2-500	32-2210-0-000
	SINGLE W=1.230	40-0470-0-072	40-0470-0-073	32-1025-0-051	32-2212-0-000	40-0717-2-500	32-2210-0-000
	DOUBLE W=1.350	40-0470-0-074	40-0470-0-073	32-1025-0-051	32-2212-0-000	40-0717-2-500	32-2210-0-000
4	SINGLE W=1.470	40-0470-0-072	40-0470-0-073	32-1025-0-051	32-2212-0-000	40-0717-2-500	32-2210-0-000
	OVER LAPPING SINGLE	(3) 40-0470-0-074 41-0470-0-072	(3) 40-0470-0-073 41-0470-0-071	32-1025-0-051	32-2212-0-000	40-0717-2-500	32-2210-0-000
	DOUBLE W=1.655	41-0470-0-072	41-0470-0-071	32-1025-0-051	32-2212-0-000	40-0717-2-500	32-2210-0-000
7/8	SINGLE W=1.669	41-0470-0-072	41-0470-0-071	32-1025-0-051	32-2212-0-000	40-0717-2-500	32-2210-0-000

NOTES

1. NOT USED ON MODELS EQUIPPED WITH AUTOMATIC PATCH LOADER.

2. USE 40-0470-0-072 FOR TROUSER APPLICATIONS.

3. USE WITH 5 1/4 WIDE PATCH.

4. INSERT 01-4436-0-000 WASHERS BETWEEN PATCH LOCATOR AND BRUSH, SUBSTITUTE 01-2402-0-000 SCREW FOR REGULAR SCREW.

* MATERIAL: 3M RESILIENT SAFETY WALK COLOR-GRAY

** MATERIAL: GENERAL PURPOSE ANTISLIP SURFACING COLOR-BLACK

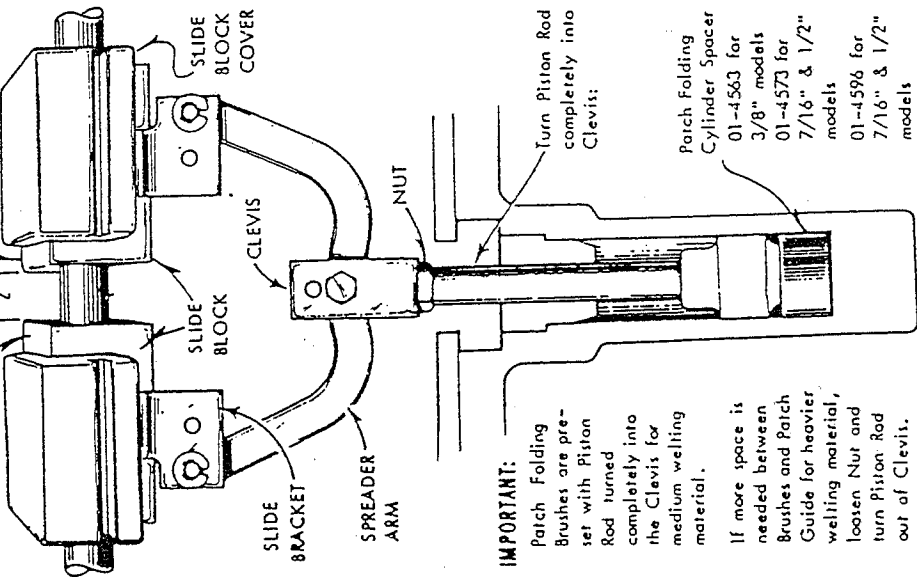
POSITIONING OF PATCH FOLDING BRUSHES

MODELS

3/8" Double	.661	7/16" Double	.730
3/8" Double	.725	1/2" Double	.786
7/16" Double	.690	1/2" Double	.850
		7/16" Single	.744
		1/2" Single	.787

Slide Brush Arms to accommodate Brushes

all left hand Slide Blocks are in position "C"
all right hand Slide Blocks are in position "A"



IMPORTANT:

Patch Folding Brushes are pre-set with Piston Rod turned completely into the Clevis for medium welling material.

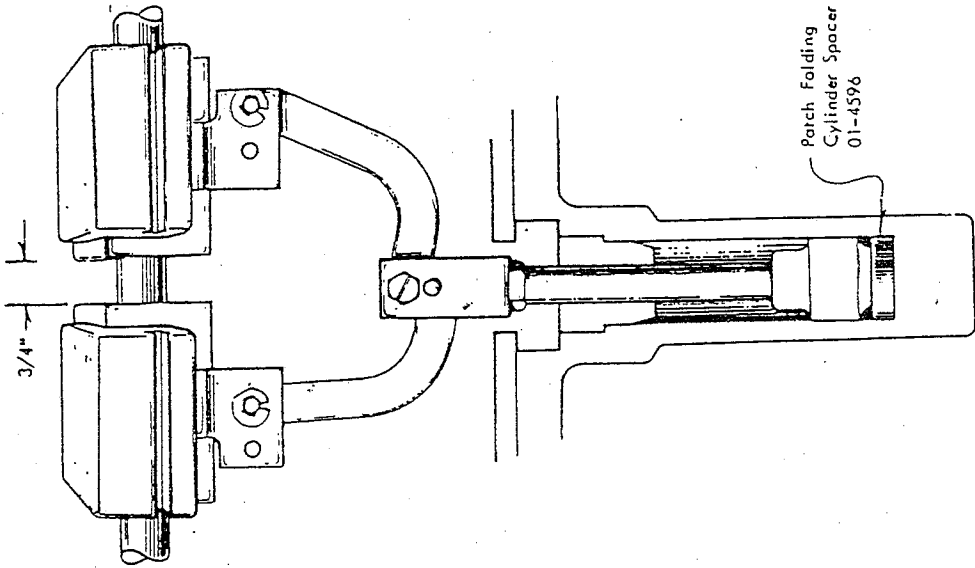
If more space is needed between Brushes and Patch Guide for heavier welling material, loosen Nut and turn Piston Rod out of Clevis.

Turn Piston Rod completely into Clevis:

Patch Folding Cylinder Spacer
01-4563 for 3/8" models
01-4573 for 7/16" & 1/2" models
01-4596 for 7/16" & 1/2" models

MODELS

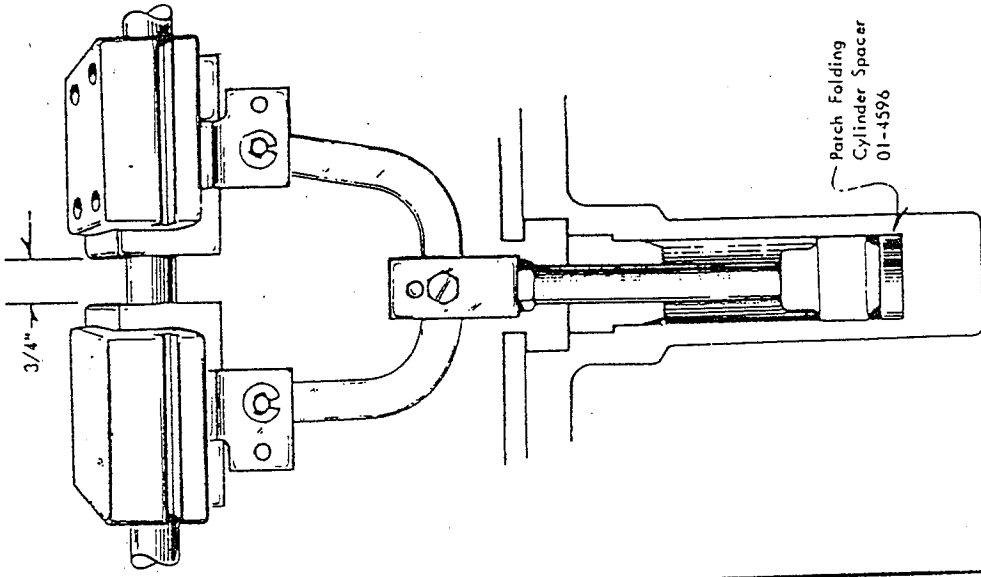
1/2" Single, left .932



Patch Folding Cylinder Spacer
01-4596

MODELS

5/8" Double .100
5/8" Double .148
3/4" Double .350

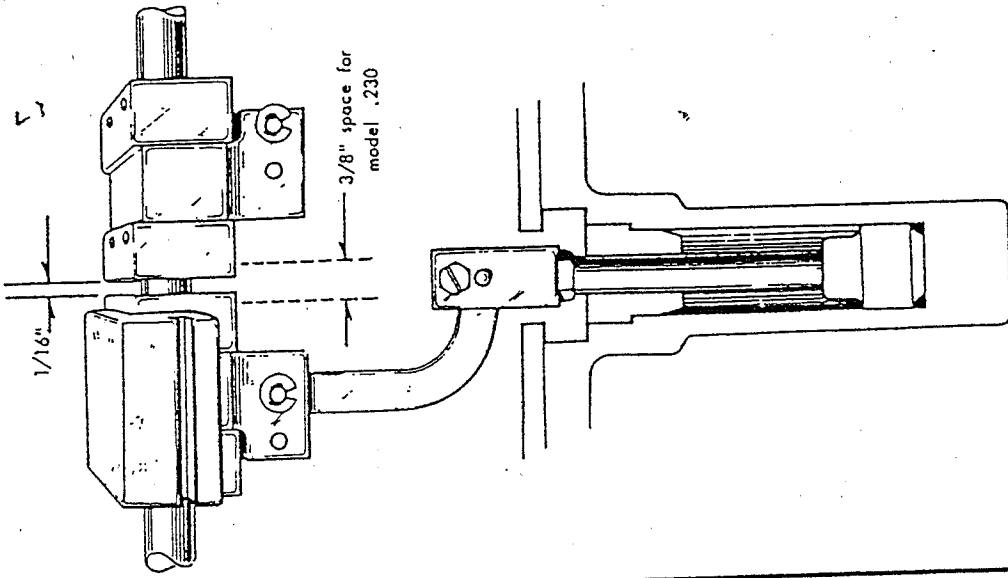


Patch Folding Cylinder Spacer
01-4596

⚠ = use these holes to position upper Brush Arms to Slide Block Covers

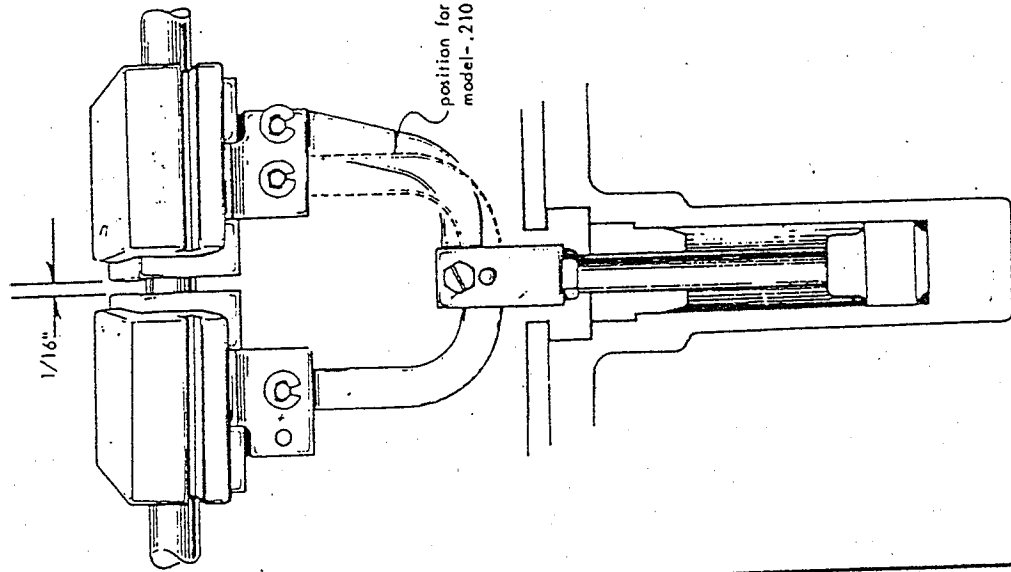
MODELS

3/4" Single	.470	5/8" Single	.230
7/8" Single	.654		



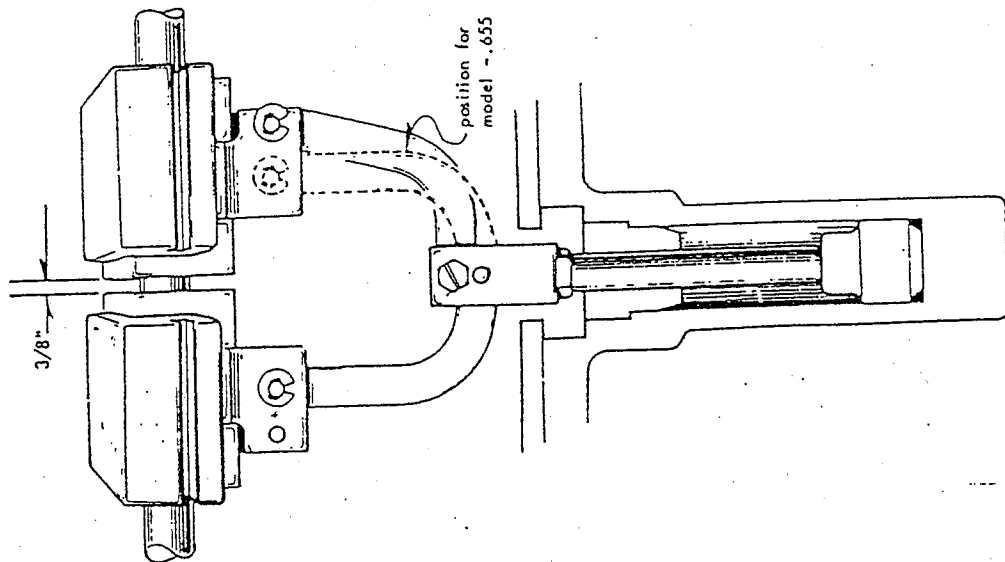
MODELS

7/8" Single	.654	3/4" Overlapping Single, left and right	.210
3/4" Single	.470		

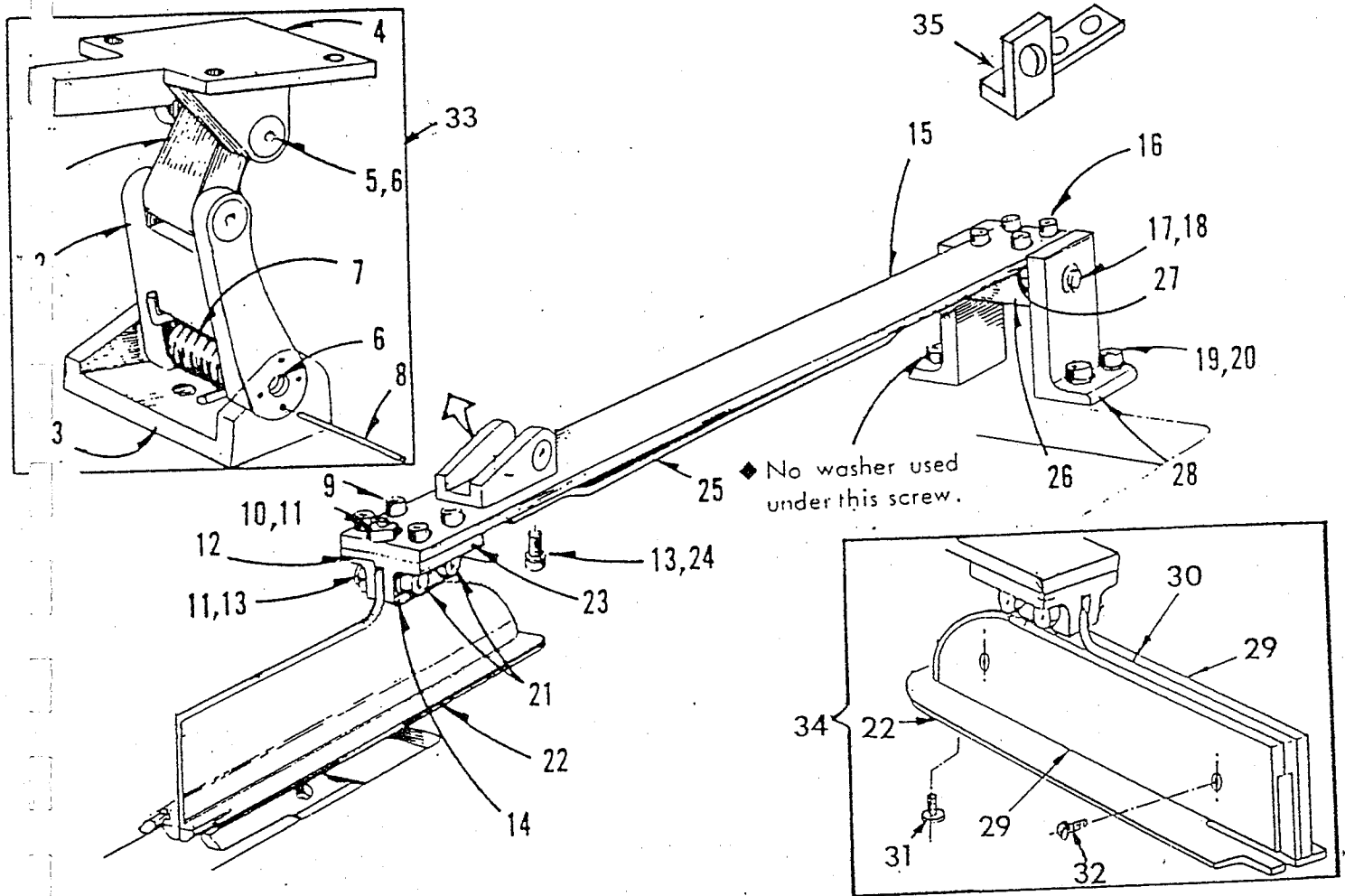


MODELS

5/8" Single	.230
7/8" Double	.655



PATCH GUIDES



DET	PART NUMBER	DESCRIPTION			
01	42-0829-0-000	Lower Link	17	01-6488-0-000	Pin
02	42-0828-0-000	Upper Link	18	01-6454-0-000	Retaining Ring
03	41-0615-0-000	Bracket	19	01-2425-0-000	Screw
04	41-0427-1-000	Guide Block, front (3/8"-1/2")	20	01-4003-0-000	Washer
	32-2133-0-000	Guide Block, front (5/8"-7/8")	21	01-2448-0-000	Screw
05	01-2713-0-000	Screw	22	see page 11	Patch Guide
07	01-7482-0-000	Heli-Coil	23	40-0414-1-000	Patch Guide Block
0	01-5490-0-000	Spring	24	01-2531-0-000	Screw
08	01-6633-0-000	Pin	25	40-0708-0-000	Cam Plate
09	01-2411-0-000	Screw	26	41-0708-0-000	Cam Plate, single welt
1	01-2409-0-000	Screw	27	40-0053-0-000	Pivot Block
11	01-3426-0-000	Nut	28	41-0683-0-000	Spacer (5/8"-7/8" only)
12	40-0648-0-000	Nut Plate	29	40-0412-0-000	Bracket
1	01-4406-0-000	Lockwasher	30	32-2089-0-000	Spacer, left w/relief (3/32)
1	01-4470-0-000	Spacer	31	32-2204-0-000	Spacer, right w/relief (3/32)
15	40-0413-0-000	Patch Guide Arm	32	32-2089-0-000	Vertical Plate
16	01-2412-0-000	Screw	33	32-2103-0-000	Vertical Plate (5/8"-7/8")
			34	01-2638-0-002	Screw
			35	01-2472-0-000	Screw
				01-2488-0-000	Screw (for 2 spacers)
				32-2142-0-050	Stabilizer Asm. (5/8"-7/8")
				see page 11	Patch Guide Asm.
				32-5004-0-000	Bracket

PATCH GUIDES, NEEDLE HOLDERS & THROAT PLATES 11

MODELS

NET LOSS H.C. 2000 R

THROAT PLATE

page 21

SCREW

HORIZONTAL PLATE

VERTICAL PLATE

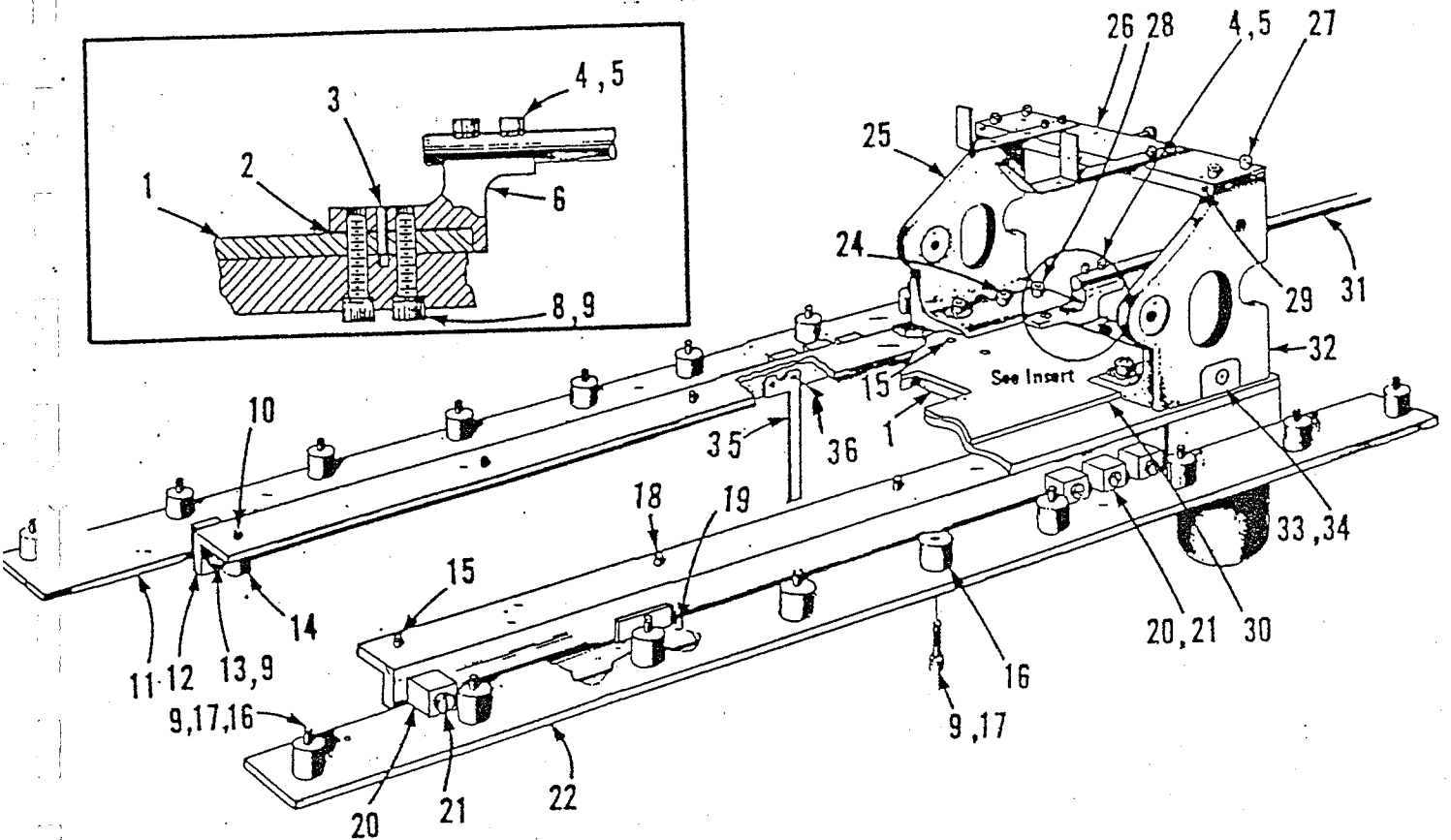
PATCH GUIDE ASM.

STYLE OF WELT

SIZE

3/8	DOUBLE W = .725	32-2080-0-051	32-2089-0-000	32-2078-0-001	01-2638-0-002	32-2200-0-001	32-2070-1-051
	DOUBLE W = .661	32-2080-0-052	32-2089-0-000	32-2078-0-002	01-2638-0-002	32-2200-0-001	32-2070-1-051
	SINGLE W = .661	32-2080-0-053	32-2089-0-000	32-2144-0-000	01-2638-0-002	32-2200-0-001	32-2070-1-051
7/16	DOUBLE W = .690	32-2084-0-051	32-2089-0-000	32-2091-0-002	01-2638-0-002	32-2200-0-002	32-2070-1-052
	DOUBLE W = .730	32-2084-0-050	32-2089-0-000	32-2091-0-001	01-2638-0-002	32-2200-0-002	32-2070-1-052
	SINGLE OFFSET W = .759	32-2114-0-050	32-2089-0-000	32-2095-0-000	01-2638-0-002	32-2200-0-002	32-2070-1-052
1/2	DOUBLE W = .786	32-2088-0-051	32-2089-0-000	32-2090-0-002	01-2638-0-002	32-2200-0-003	32-2070-1-053
	DOUBLE W = .850	32-2088-0-050	32-2089-0-000	32-2090-0-001	01-2638-0-002	32-2200-0-003	32-2070-1-053
	SINGLE W = .801	32-2115-0-050	32-2089-0-000	32-2096-0-001	01-2638-0-002	32-2200-0-003	32-2070-1-053
5/8	SINGLE W = .945	32-2115-0-051	32-2089-0-000	32-2096-0-002	01-2638-0-002	32-2200-0-003	32-2070-1-053
	DOUBLE W = 1.100	32-2111-0-050	32-2103-0-000	32-2092-0-001	01-2638-0-002	32-2200-0-004	32-2070-1-054
	DOUBLE W = 1.1480	32-2111-0-051	32-2103-0-000	32-2092-0-002	01-2638-0-002	32-2200-0-004	32-2070-1-054
3/4	SINGLE W = 1.230	32-2116-0-050	32-2103-0-000	32-2097-0-000	01-2638-0-002	32-2200-0-004	32-2070-1-054
	DOUBLE W = 1.350	32-2112-0-050	32-2103-0-000	32-2093-0-000	01-2638-0-002	32-2200-0-005	32-2070-1-055
	SINGLE W = 1.470	32-2117-0-050	32-2103-0-000	32-2098-0-000	01-2638-0-002	32-2200-0-005	32-2070-1-055
7/8	OVERLAPPING SINGLE	32-2128-0-050	32-2103-0-000	32-2127-0-000	01-2638-0-002	32-2200-0-005	32-2070-1-055
	DOUBLE W = 1.655	32-2113-0-050	32-2103-0-000	32-2094-0-000	01-2638-0-002	32-2200-0-006	32-2070-1-056
	SINGLE W = 1.669	32-2118-0-050	32-2103-0-000	32-2099-0-000	01-2638-0-002	32-2200-0-006	32-2070-1-056

CLAMP TABLE TRAVEL

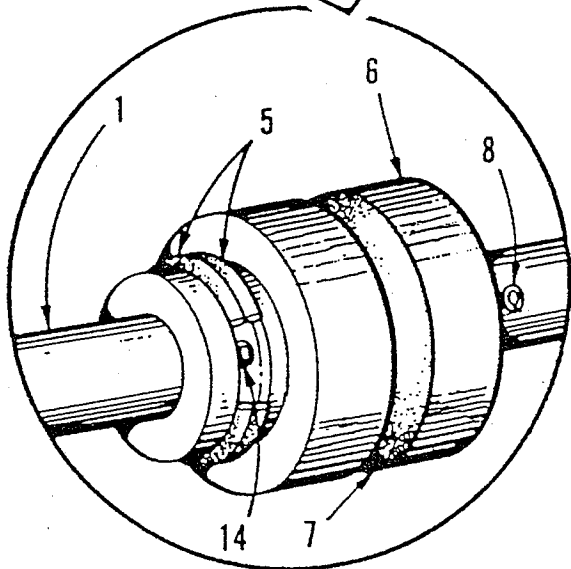
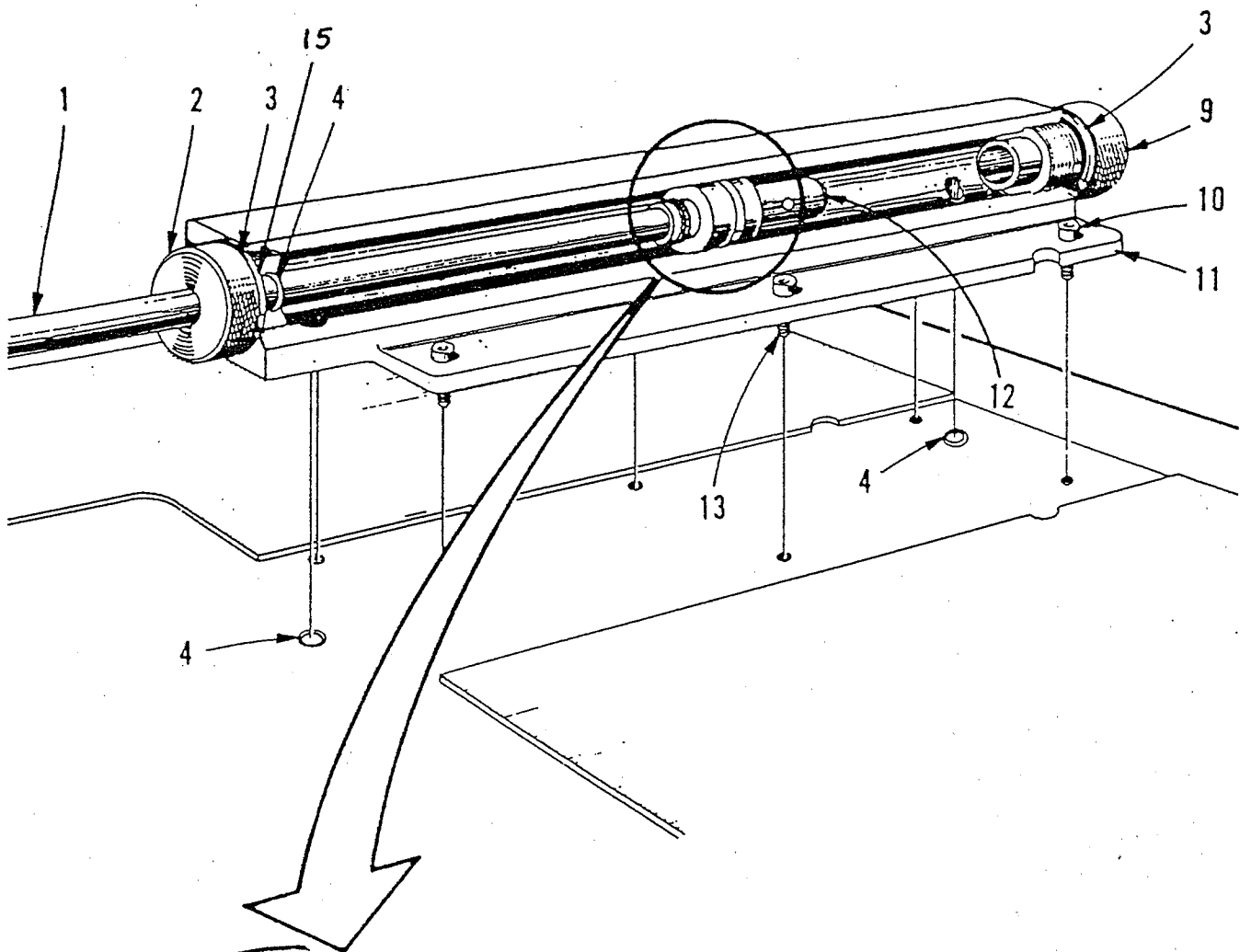


DET	PART NUMBER	DESCRIPTION
01	32-2110-0-050	Clamp Plate
02	42-1600-0-000	Shim
03	01-6652-0-000	Pin
04	01-2531-0-000	Screw
05	01-4406-0-000	Lockwasher
06	42-0100-0-000	Bracket
08	01-2446-0-000	Screw
09	01-4003-0-000	Lockwasher
10	01-2450-0-000	Screw
11	41-0452-0-002	Track (L.H.)
12	41-0451-0-002	Bracket (L.H.)
13	01-3404-0-000	Nut
14	40-0547-0-000	Actuator
15	01-2534-0-000	Screw
16	01-4442-0-000	Spacer

17	01-2490-0-000	Screw
18	41-0451-0-001	Bracket
19	01-2481-0-000	Screw
20	42-1624-0-000	Slide
21	01-1444-0-000	Screw
22	41-0452-0-001	Track (R.H.)
24	01-2407-0-000	Screw
25	41-0076-0-002	Bracket (L.H.)
26	41-0075-0-000	Plate
27	01-2448-0-000	Screw
28	01-2447-0-000	Screw
29	01-2591-0-000	Screw
30	41-0680-0-000	Stiffener Plate
31	40-0252-0-000	Piston Rod
32	41-0076-0-001	Bracket (R.H.)
33	43-2505-0-000	Access Plate
34	01-2652-0-000	Screw
35	32-5006-0-000	Flag
36	01-2412-0-000	Screw

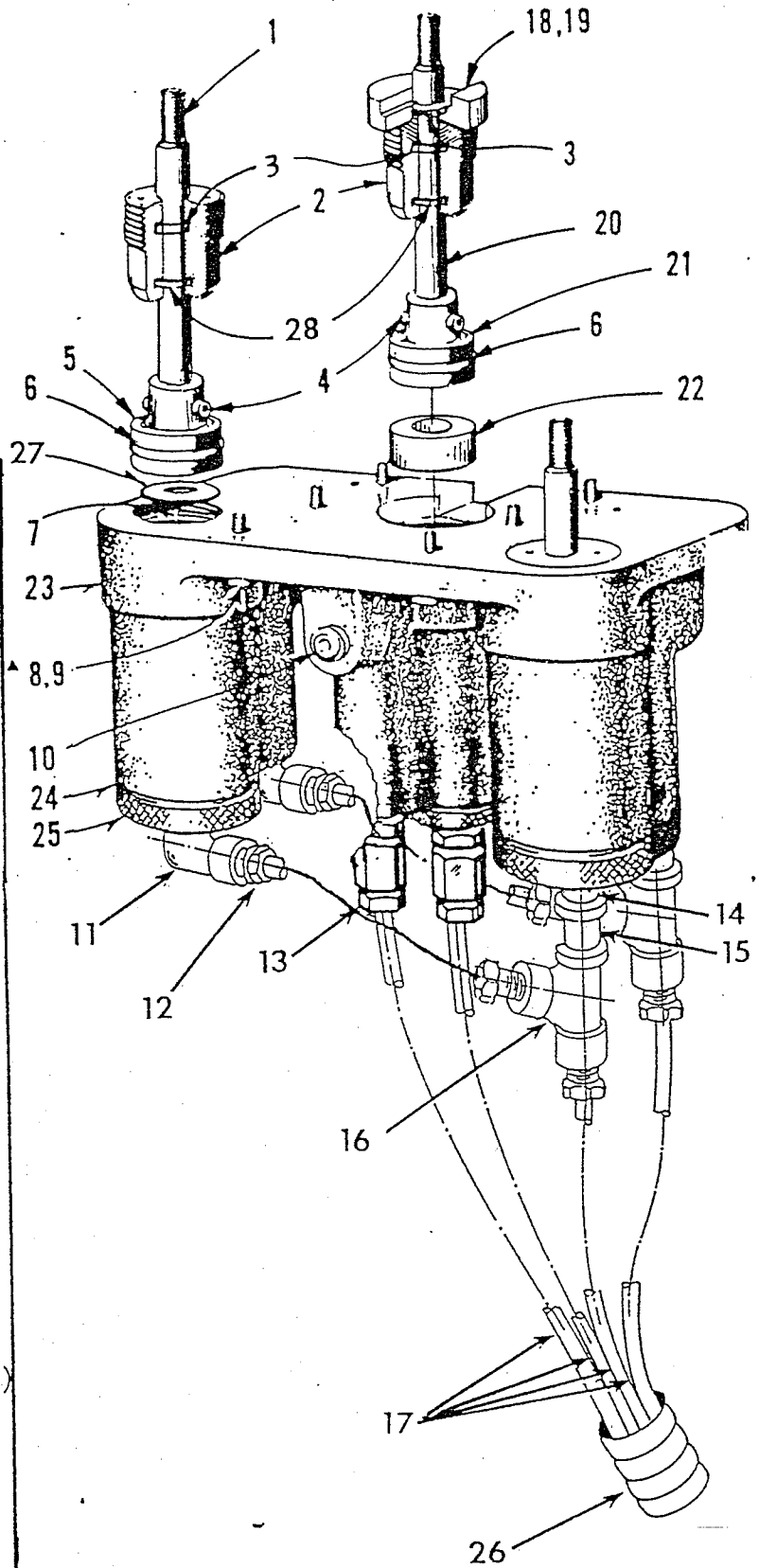
CLAMP TABLE TRAVEL CYLINDER

13



DET	PART NUMBER	DESCRIPTION
01	40-0252-0-000	Piston Rod
02	42-1058-0-000	Cap Asm.
03	30-0194-0-000	Gasket
04	01-4480-0-000	'O' Ring
05	01-4450-0-000	'O' Ring
06	40-0472-1-000	Piston
07	01-4451-0-000	'O' Ring
08	01-6501-0-000	Roll Pin
09	40-0453-1-000	End Cap
10	01-2430-0-000	Screw
11	32-3032-0-000	Cylinder
12	40-0528-0-000	Plunger
13	01-2447-0-000	Screw
14	01-6652-0-000	Roll Pin
15	01-4301-0-000	'U-Cup' Seal

14 CLAMPING & PATCH FOLDING CYLINDER



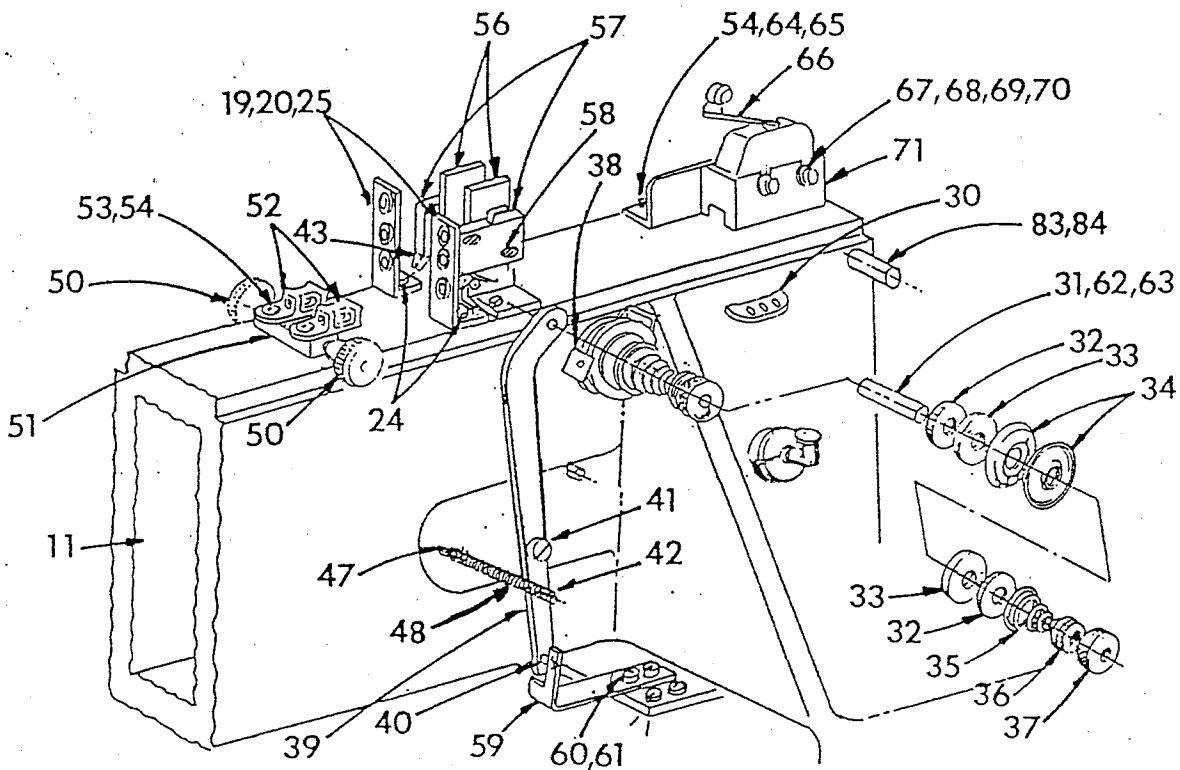
QTY	PART NUMBER	DESCRIPTION
1	40-0190-0-000	Piston Rod
1	42-1059-0-000	Cap Asm.
03	01-4480-0-000	'O' Ring
04	01-6470-0-000	Roll Pin
05	40-0191-0-000	Piston
06	01-4451-0-000	'O' Ring
07	01-4438-0-000	'O' Ring
08	01-2425-0-000	Screw
09	01-4003-0-000	Lockwasher
10	01-2438-0-000	Plug
11	32-0218-0-000	Tee
12	40-0575-2-000	Nut & Ferrule
13	40-0310-1-000	Nut, Ferrule & Fitting
14	20-6050-0-000	Nipple
15	07-0689-0-000	Coupling
16	07-0688-0-000	Tee
17	07-0294-0-000	1/4" Tubing - 27"
18	41-0681-0-000	Cap Retainer
18	32-2129-0-000	Cap Retainer (7/8" only)
19	01-6555-0-000	Roll Pin
20	41-0202-0-000	Piston Rod
20	32-2109-0-000	Piston Rod (7/8" only)
21	40-0203-0-000	Piston
21	32-2108-0-000	Piston (7/8" only)
22	01-4563-1-000	Spacer } SEE PAGES 8 & 9
22	01-4573-0-000	Spacer }
22	01-4596-0-000	Spacer }
23	41-0229-2-050	Cylinder Housing
24	30-0194-0-000	Gasket
25	40-0744-1-000	Cap
25	40-0586-0-000	'Spirap', 45"
27	01-4439-0-000	Washer/Spacer
28	01-4301-0-000	'U-Cup' Seal

▲ When replacing thread insert in clamp plate, order part no. 01-7419.

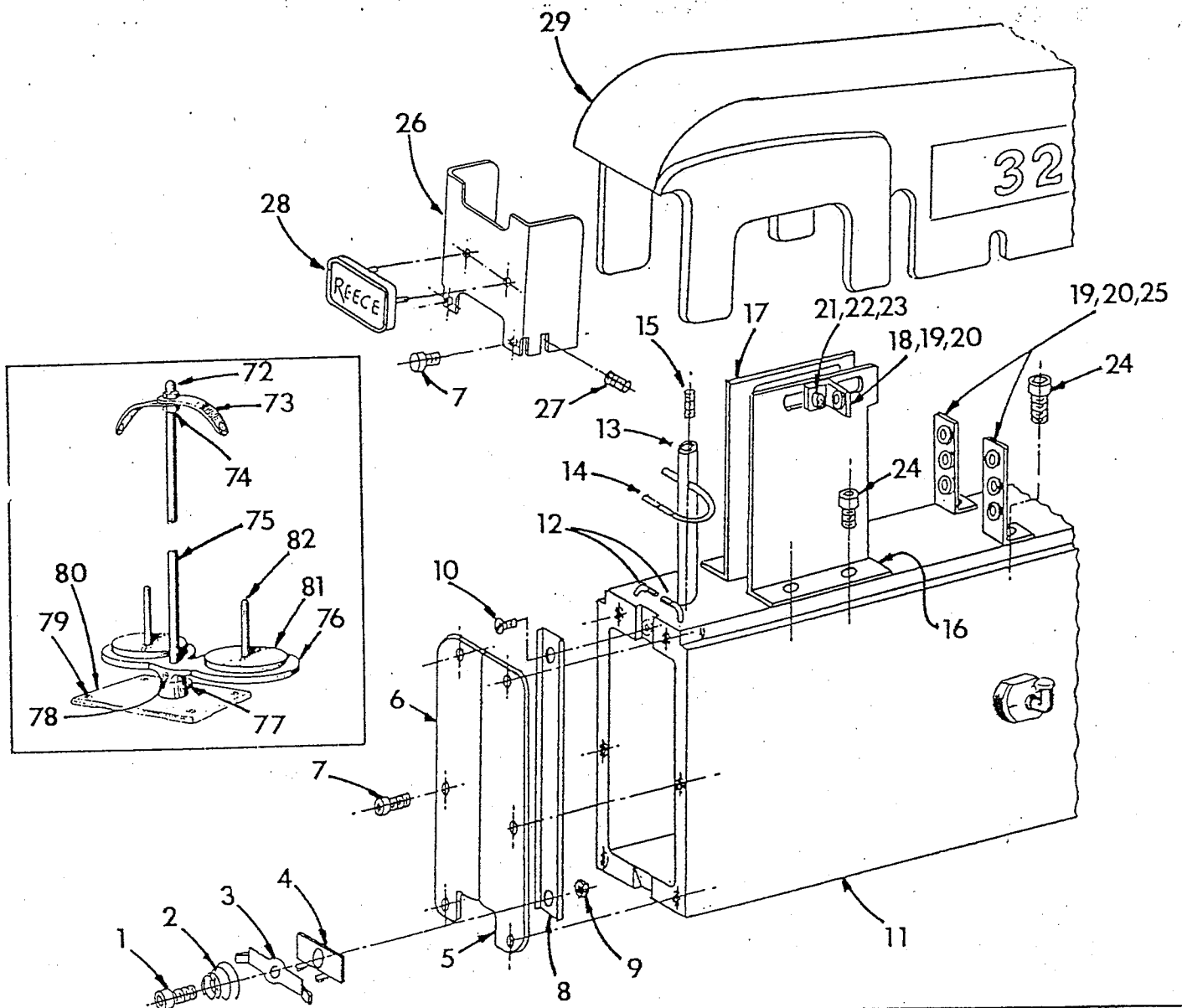
● Available only in multiples of one foot



THREAD TENSIONS & CONTROLS



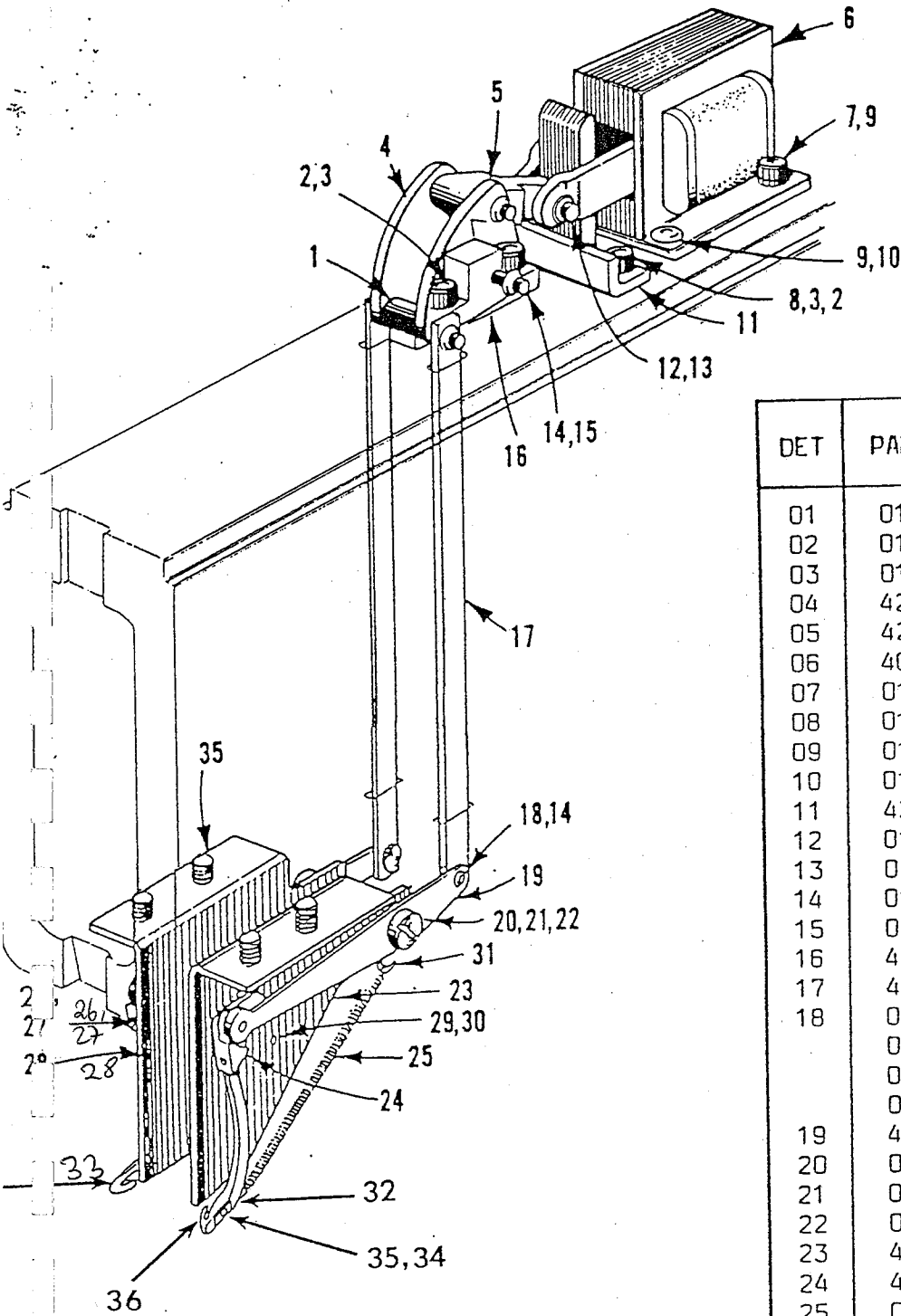
ET	PART NUMBER	DESCRIPTION
1	01-1475-0-000	Screw
2	01-1144-0-000	Spring
3	32-1030-0-000	Plate
4	32-1015-1-000	Plate-Spacer
5	32-1013-0-000	Front Cover-Right
6	32-1020-0-000	Front Cover-Left
7	01-2401-0-000	Screw
8	32-1014-0-000	Guide
9	01-3016-0-000	Nut
0	01-2406-0-000	Screw
1	32-1021-0-050	Head
2	32-1006-0-000	Bar-Adjustable
3	32-1012-0-050	Needle Bar Asm.
4	32-1005-0-000	Thread Take-up
5	01-2442-0-001	Screw
6	32-1010-0-000	Bracket-Right
7	32-1019-0-000	Bracket-Left
8	32-1007-0-000	Eyelet
9	01-7447-1-000	Guide
20	01-6551-0-000	Retaining Ring
21	01-2582-0-000	Screw
22	01-4029-0-000	Washer
23	01-3401-0-000	Nut
24	01-2411-0-000	Screw
25	42-0037-0-000	Thread Guide
26	32-1011-0-000	Cover-Top-Front
27	01-2409-0-000	Screw
28	05-1130-0-000	Reece Nameplate
29	32-1017-0-000	Head Cover
30	05-1302-0-000	Thread Smoother
31	01-1433-0-000	Stud
32	01-4005-0-000	Washer
33	01-4424-0-000	Felt Washer
34	40-0475-0-000	Tension Disc
35	01-5001-0-000	Spring
36	20-0603-0-000	Collar
37	01-3036-0-000	Nut
38	32-1009-0-000	Thread Guide
39	32-1034-0-050	Thread Drawoff Lever Asm. (Left)(Not Shown)
39	32-1035-0-050	Thread Drawoff Lever Asm. (Right)
40	01-6430-0-000	Pin



DET	PART NUMBER	DESCRIPTION
41	01-1410-0-000	Screw
42	01-6453-0-000	Pin
43	32-1022-0-000	Switch Actuator
47	01-6452-0-000	Pin
48	01-5418-0-000	Spring
49	01-2413-0-000	Screw
50	42-0902-0-000	Knob
51	42-0903-0-000	Block
52	04-1400-0-000	Anchor-Tie
53	01-2448-0-000	Screw
54	01-4406-0-000	Washer
56	42-0896-0-006	Bracket
57	04-1358-1-000	Switch
58	60-0079-0-000	Nut Plate
59	41-0034-0-001	Actuator-Right
	41-0034-0-002	Actuator-Left
60	01-2695-0-000	Screw
61	01-4411-0-000	Washer
62	01-7448-0-000	Post

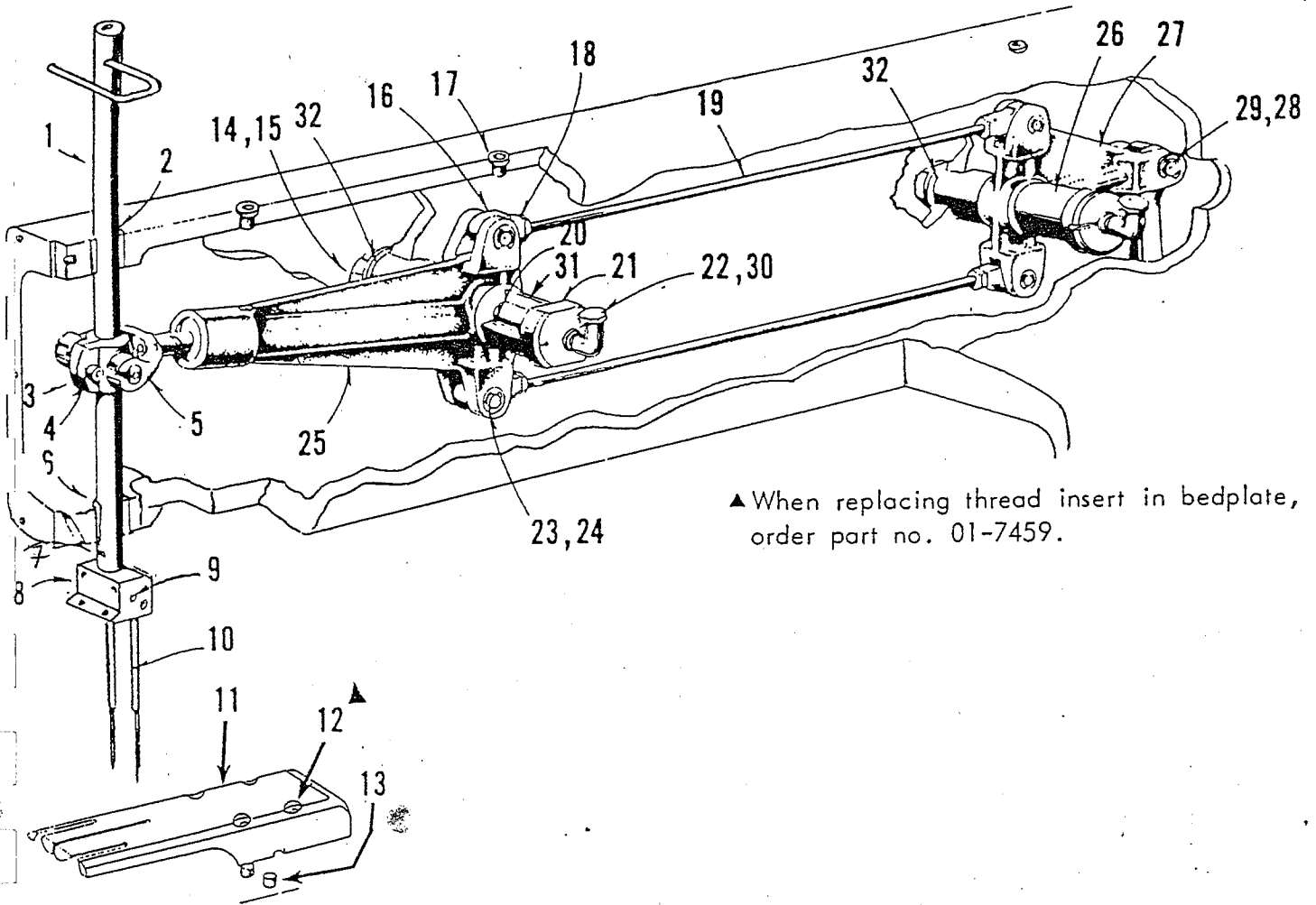
63	01-6474-0-000	Ring
64	42-0955-0-000	Bracket
65	01-2411-0-000	Screw
66	41-0257-0-000	Switch
67	42-1007-0-000	Rocker Bracket
68	42-1208-0-000	Stop Lever
69	01-2628-0-000	Screw
70	01-3401-0-000	Nut
71	06-0170-0-000	Enclosure
72	01-3052-0-000	Nut
73	32-3033-0-050	Arm
74	01-3026-0-000	Nut
75	05-0005-0-000	Post
76	05-0002-0-001	Shelf
77	01-2492-0-000	Screw
78	01-2028-0-000	Screw
79	01-2795-0-000	Screw
80	05-0001-0-001	Base
81	05-0006-0-000	Felt Pad
82	01-6138-1-000	Stand Post
83	01-6662-0-000	Retaining Ring
84	01-6657-0-001	Pin

THREAD TENSIONS & CONTROLS



DET	PART NUMBER	DESCRIPTION
01	01-6658-0-000	Shaft
02	01-2506-0-000	Screw
03	01-4407-0-000	Lockwasher
04	42-0899-0-000	Lever
05	42-0900-0-000	Link
06	40-0506-0-000	Solenoid
07	01-2558-0-000	Screw
08	01-4412-0-000	Washer
09	01-4406-0-000	Lockwasher
10	01-2668-0-000	Screw
11	42-0692-0-000	Stop
12	01-6551-0-000	Retainer
13	01-6660-0-000	Pin
14	01-6552-0-000	Retainer
15	01-6659-0-000	Shaft
16	42-0901-0-000	Block
17	42-0619-0-000	Link
18	01-6567-0-000	Pin (3/8"-1/2")
	01-6973-0-001	Pin (3/4")
	01-6973-0-002	Pin (7/8")
	01-6973-0-003	Pin (5/8")
19	40-0618-2-000	Link
20	01-3401-0-000	Nut
21	01-4487-0-000	Spacer
22	01-1440-0-000	Screw
23	40-0418-2-001	Bracket (R.H.)
24	40-0428-1-001	Holder (R.H.)
25	01-5455-0-000	Spring
26	01-2561-0-000	Screw
27	40-0428-1-002	Holder (L.H.)
28	40-0418-2-002	Bracket (L.H.)
29	01-4420-0-000	Washer
30	01-6480-0-000	Shaft
31	40-0759-0-000	Hook
32	32-5024-0-000	Arm (R.H.)
33	32-5025-0-000	Arm (L.H.)
34	01-1589-0-000	Screw
35	32-5027-0-000	Spring Retainer
36	32-5026-0-000	Spring

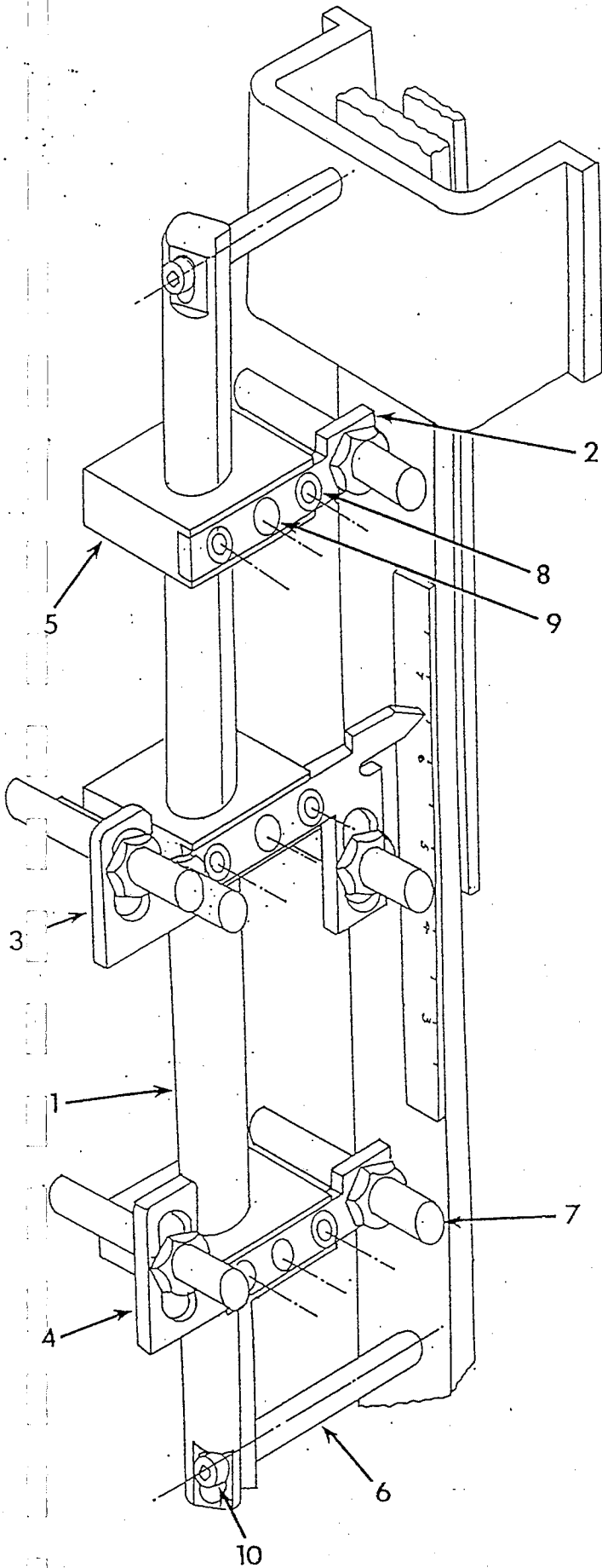
NEEDLE BAR DRIVE & THROAT PLATE



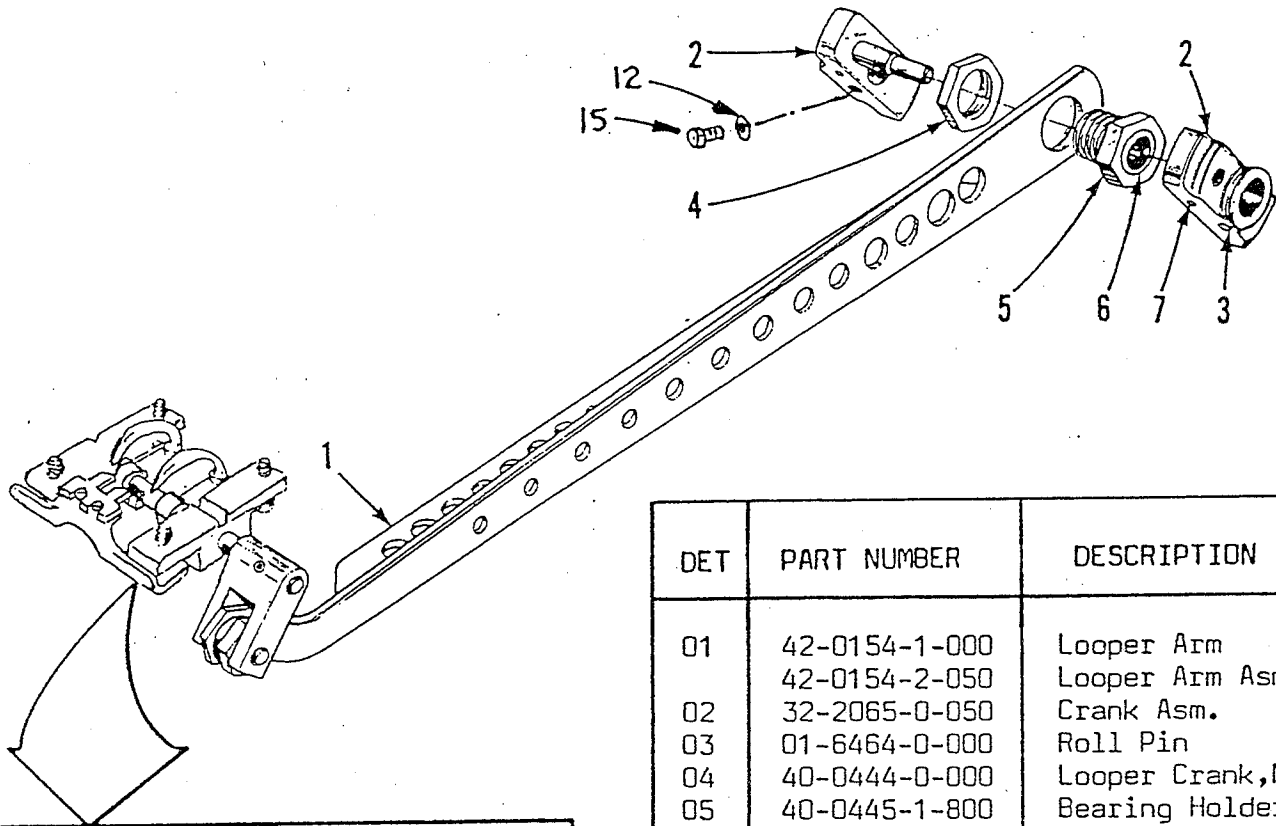
▲ When replacing thread insert in bedplate, order part no. 01-7459.

DET	PART NUMBER	DESCRIPTION
01	32-1012-0-050	Needle Bar Asm.
02	01-7401-0-000	Bushing
03	30-0008-0-000	Gimbals
04	01-2402-0-000	Screw
05	30-0009-0-000	Yoke
06	01-7442-0-000	Bushing
07	01-2515-0-000	Set Screw
08	see pg. 11	Needle Holder
09	01-2561-0-000	Set Screw
10	see pg. 20	Needles
11	see pg. 11	Throat Plate
12	01-2484-0-000	Screw
13	01-6543-0-000	Pin
14	01-3400-0-000	Nut
15	01-4439-0-000	Washer

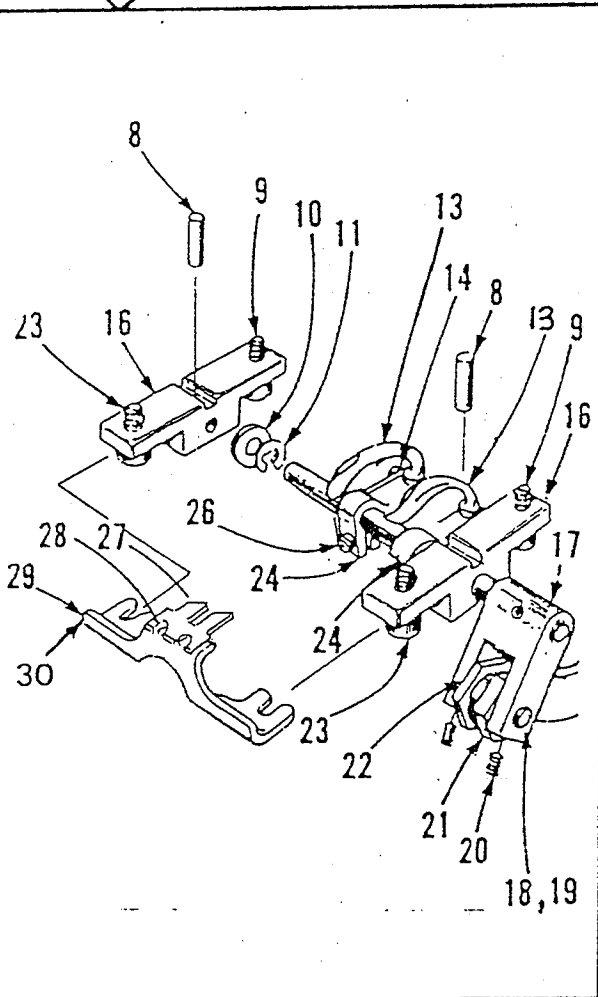
16	40-0466-0-000	Rod Connector
17	40-0593-0-000	Oil Inlet
18	01-3016-0-000	Nut
19	40-0467-0-000	Rod
20	01-8401-0-000	Key
21	40-0566-0-000	Front Shaft
22	30-0011-0-000	Oil Cup
23	01-6407-0-000	Pin
24	01-6454-0-000	Retaining Ring
25	40-0050-0-050	Front Lever
26	40-0010-0-000	Rear Shaft
27	40-0465-0-000	Rear Lever
28	01-6504-0-000	Pin
29	01-6475-0-000	Retaining Ring
30	01-6551-0-000	Plastic Ring
31	40-0567-0-000	Eccentric Ring
32	30-0007-0-000	Bushing



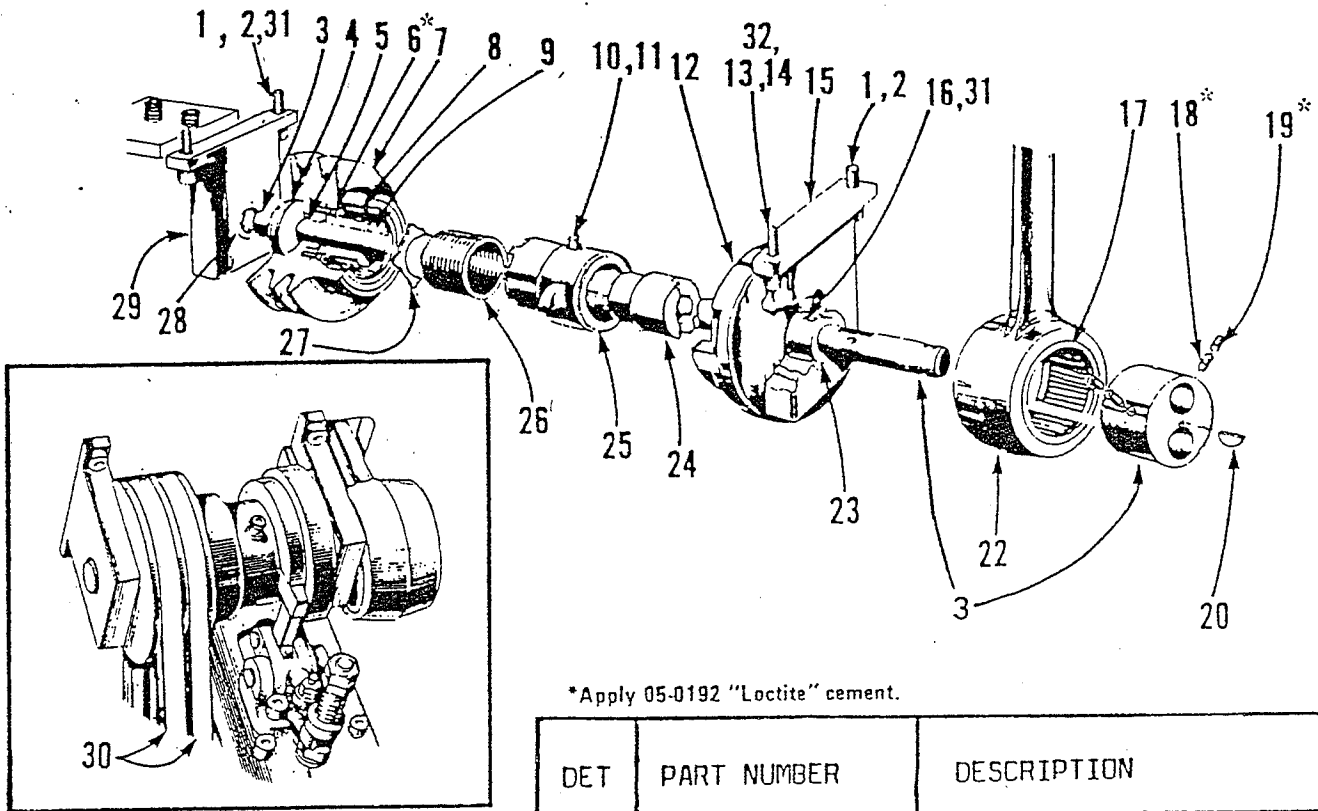
DET	PART NUMBER	DESCRIPTION
01	32-5008-0-000	Shaft
02	32-5003-0-000	Bracket
03	32-5002-0-000	Bracket
04	32-5001-0-000	Bracket
05	32-5007-0-000	Block
06	32-5023-0-050	Stand-Off Asm.
07	06-0775-0-000	Switch
08	01-2451-0-000	Screw
09	01-1590-0-000	Screw
10	01-1147-0-000	Screw



DET	PART NUMBER	DESCRIPTION
01	42-0154-1-000	Looper Arm
	42-0154-2-050	Looper Arm Asm.
02	32-2065-0-050	Crank Asm.
03	01-6464-0-000	Roll Pin
04	40-0444-0-000	Looper Crank, Nut
05	40-0445-1-800	Bearing Holder
06	01-7413-0-000	Bearing
07	01-6703-0-000	Rollpin
08	01-6543-0-000	Pin
09	01-2469-0-000	Screw, Rear
10	01-4402-0-000	Washer
11	01-6454-0-000	Retaining Ring
12	01-4578-0-000	Lockwasher
13	32-2064-0-000	Looper
14	01-2561-0-000	Screw
15	01-2421-0-000	Screw
16	40-0059-0-000	Support
17	42-0063-1-050	Looper Shaft Asm.
18	01-6827-1-000	Pin
19	01-6551-0-000	Shaft Retainer
20	01-2442-0-001	Set Screw
21	42-1041-0-000	Spacer Nut
22	42-1040-0-000	Sleeve
23	01-2407-0-000	Screw, Front
24	32-2063-0-000	Looper Holder (pair)
26	01-2431-0-000	Screw
27	32-2040-0-000	Knife (3/8")
	32-2067-0-000	Knife (7/16")
	32-2061-0-000	Knife (1/2")
	32-2125-0-000	Knife (5/8")
	32-2126-0-000	Knife (3/4")
	32-2119-0-000	Knife (7/8")
28	01-1683-0-000	Screw
29	32-2062-0-000	Trim Knife Bracket
30	32-2215-0-000	Trim Knife Bracket (3/8")

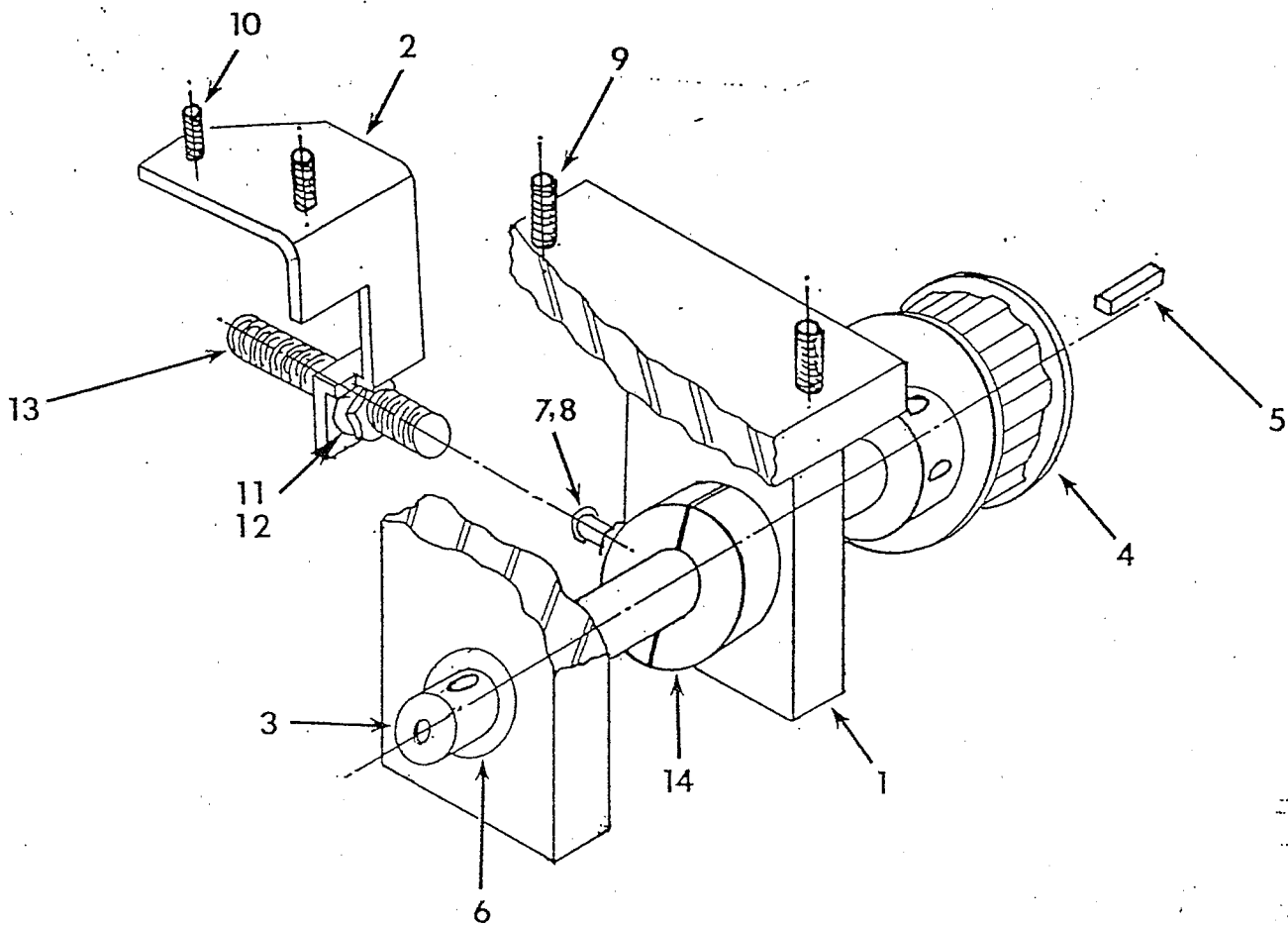


DRIVE SHAFT

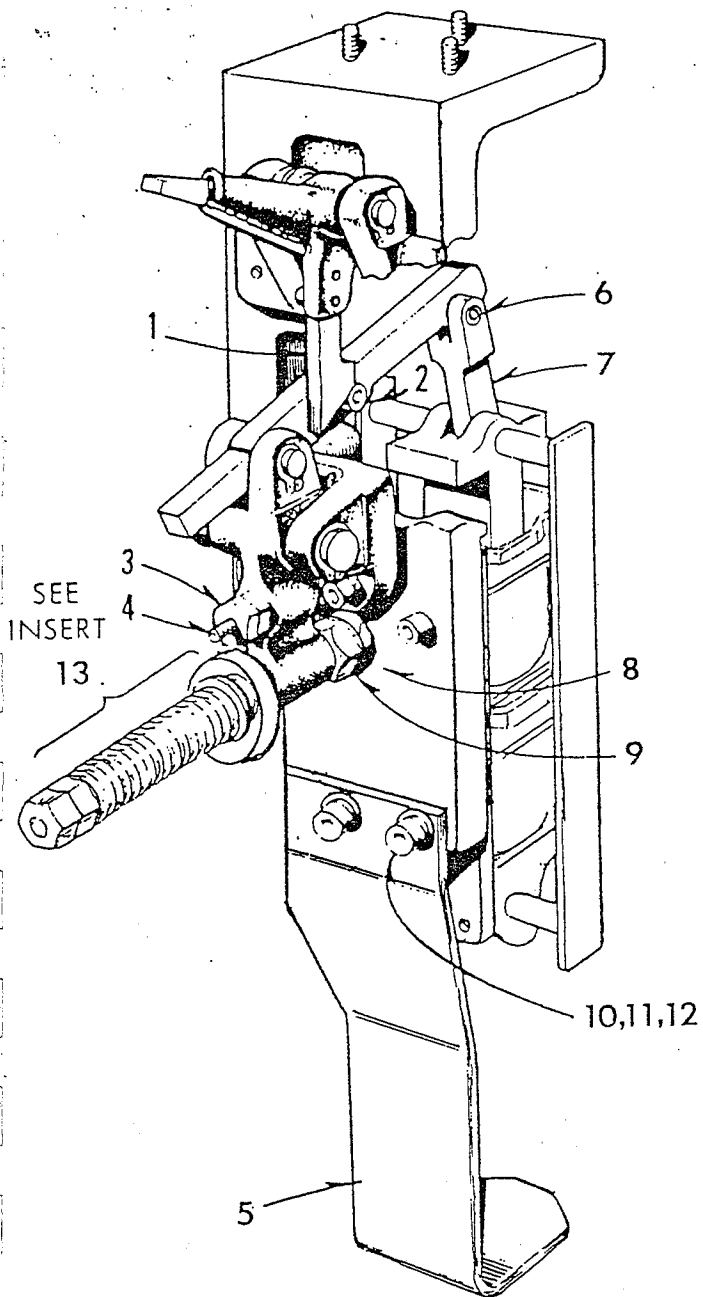


*Apply 05-0192 "Loctite" cement.

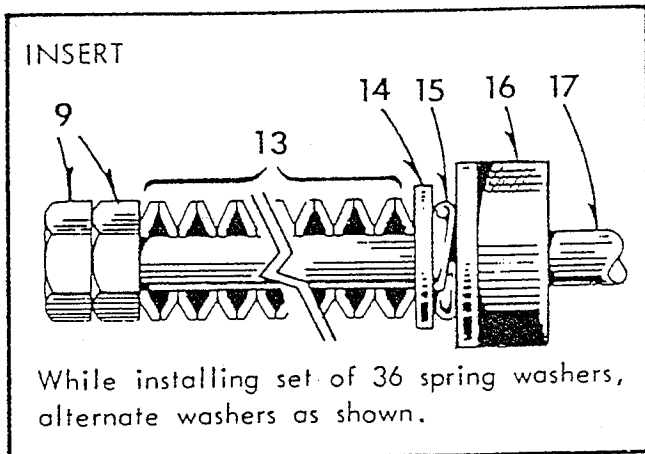
DET	PART NUMBER	DESCRIPTION
01	01-4004-0-000	Lockwasher
02	01-2430-0-000	Screw
03	32-2176-0-050	Eccentric and Shaft Asm.
04	20-0623-0-000	Bearing
05	01-7409-0-000	Needle Bearing
06	01-2427-0-000	Screw
07	30-0141-0-050	Clutch Sleeve Asm.
08	01-7411-0-000	Bearing
09	30-0142-0-000	Driving Drum
10	01-4011-0-000	Washer
11	30-0134-0-000	Fitting
12	30-0144-1-000	Clutch Dog Stop
13	01-4003-0-000	Lockwasher
14	01-2447-0-000	Screw
15	30-0133-0-000	Center Support
16	01-6419-0-000	Pin
17	01-7412-0-000	Bearing
18	01-2453-0-000	Screw
19	01-2408-0-000	Screw
20	01-8400-0-000	Key
22	40-0151-0-050	Needle Bar Asm.
23	01-7408-0-000	Bearing
24	30-0145-1-000	Driver Drum
25	30-0143-2-000	Clutch Release Dog
26	01-5441-0-000	Spring
27	30-0146-0-000	Ring
28	01-7409-0-000	Needle Bearing
29	30-0131-0-000	End Support
30	05-0088-0-350	Belt (60 Hz)
	05-0088-0-360	Belt (50 Hz)
31	01-7431-0-000	Helicoil
32	01-7430-0-000	Helicoil



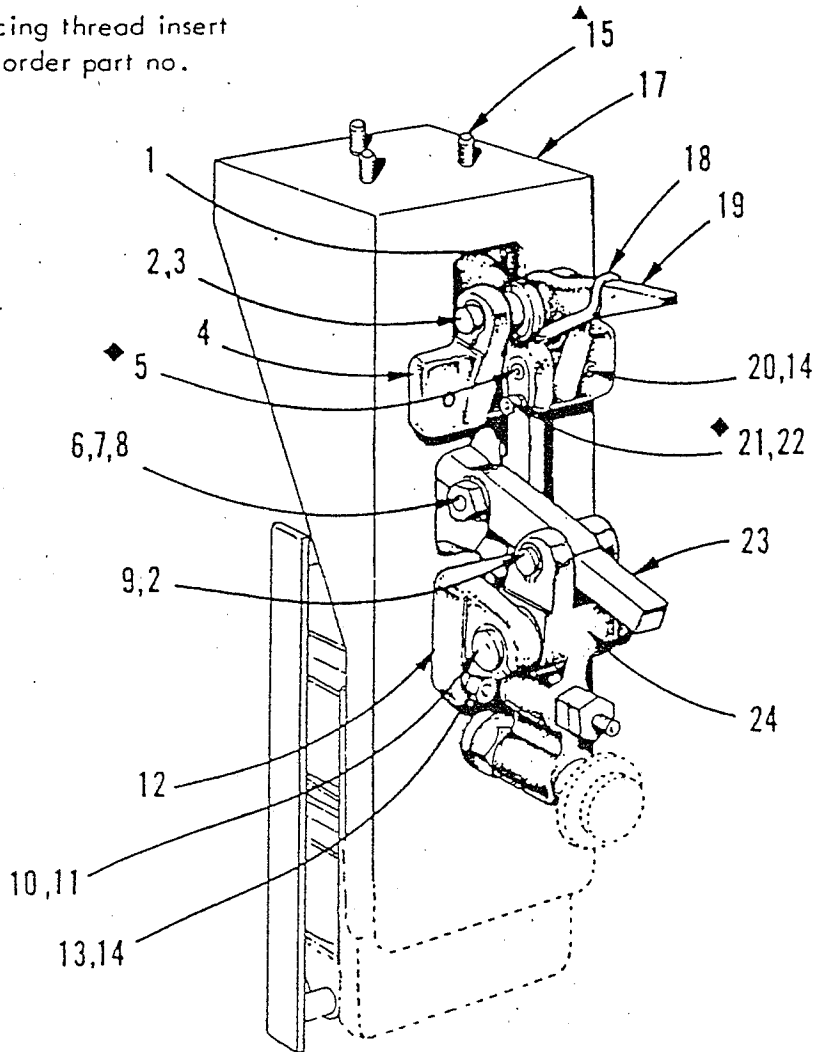
DET	PART NUMBER	DESCRIPTION
01	32-5022-0-000	Bracket
02	32-0555-0-000	Bracket
03	32-5021-0-000	Shaft
04	32-5031-0-000	Pulley
05	01-8416-0-002	Key
06	01-7409-0-000	Bearing
07	01-2644-0-000	Screw
08	01-3404-0-000	Nut
09	01-2425-0-000	Screw
10	01-2411-0-000	Screw
11	01-4143-0-000	Grommet
12	01-4005-0-000	Washer
13	06-0775-0-000	Switch
14	32-5017-0-000	Collar



DET	PART NUMBER	DESCRIPTION
01	30-0174-0-000	Lever
02	01-2412-0-000	Screw
03	01-3404-0-000	Nut
04	01-2434-0-000	Screw
05	40-0610-0-000	Bracket
06	01-6456-0-000	Roll Pin
07	30-0175-0-000	Link
08	01-4422-0-000	Lockwasher
09	01-3406-0-000	Nut
10	01-2437-0-000	Screw
11	01-4003-0-000	Lockwasher
12	01-4404-0-000	Washer
13	42-0989-0-050	Set of 36 (01-5521) Spring Washer
14	01-4491-0-000	Spacer
15	01-5458-0-000	Spring
16	32-0565-0-000	Prox. Actuator
17	01-1443-0-000	Stud



▲ When replacing thread insert in Bedplate order part no. 01-7431.



◆ Apply 05-0192 "Loctite" cement at these screws.

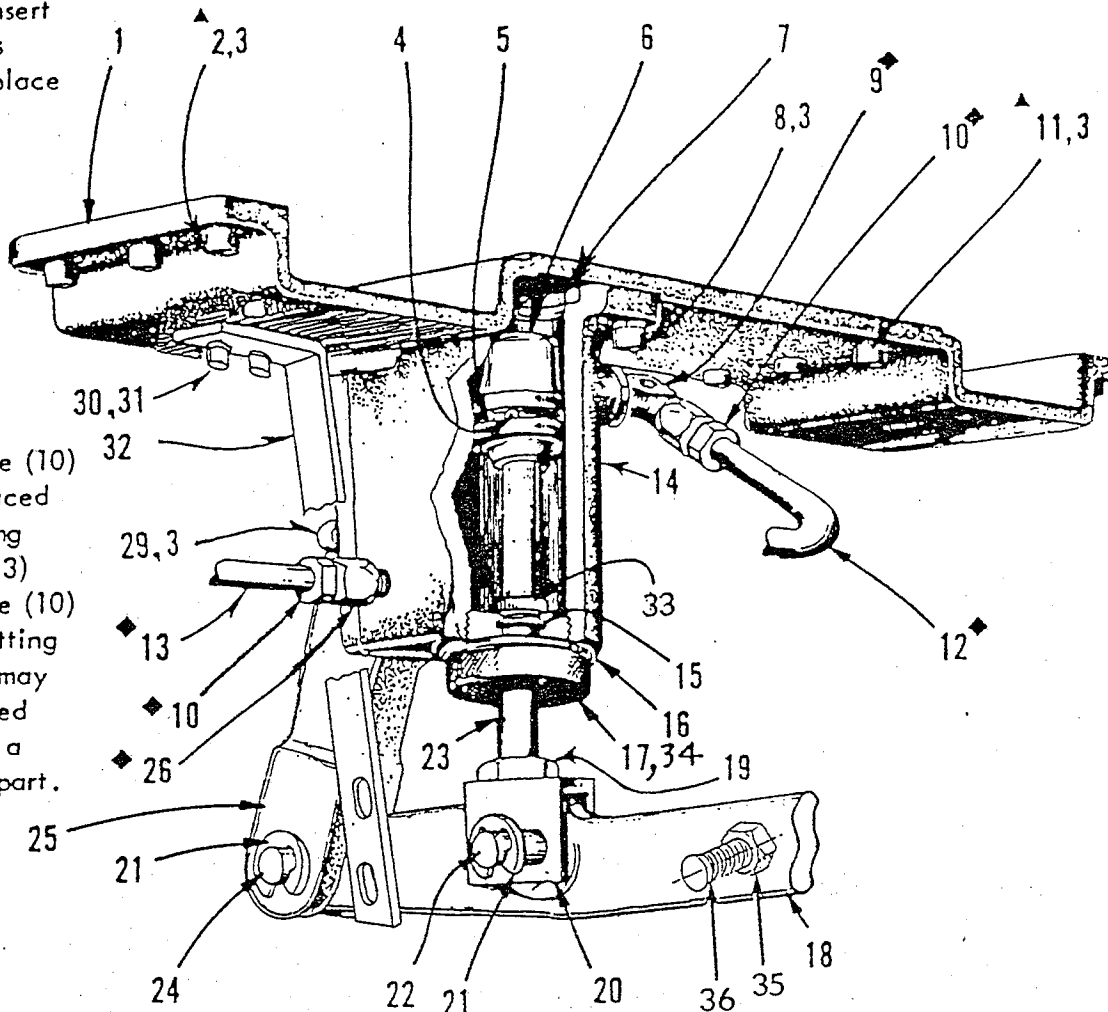
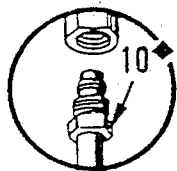
DET	PART NUMBER	DESCRIPTION
01	01-4410-0-000	Spacer
02	01-6423-0-000	Truarc
03	01-6431-0-000	Pin
04	30-0162-0-000	Bracket
05	01-2415-0-000	Screw
06	01-3402-0-000	Nut
07	01-4407-0-000	Washer
08	01-2412-0-000	Screw
09	01-6432-0-000	Pin
10	01-6434-0-000	Pin

11	01-6433-0-000	Truarc
12	30-0163-0-000	Bracket
13	01-2447-0-000	Screw
14	01-4003-0-000	Lockwasher
15	01-2449-0-000	Screw
17	40-0161-0-000	Bracket
18	01-5409-0-000	Spring
19	30-0160-0-000	Dog
20	01-2437-0-000	Screw
21	01-2402-0-000	Screw
22	01-4405-0-000	Lockwasher
23	30-0168-0-000	Clutch Dog
24	30-0169-0-000	Arm

TAB CUTTING

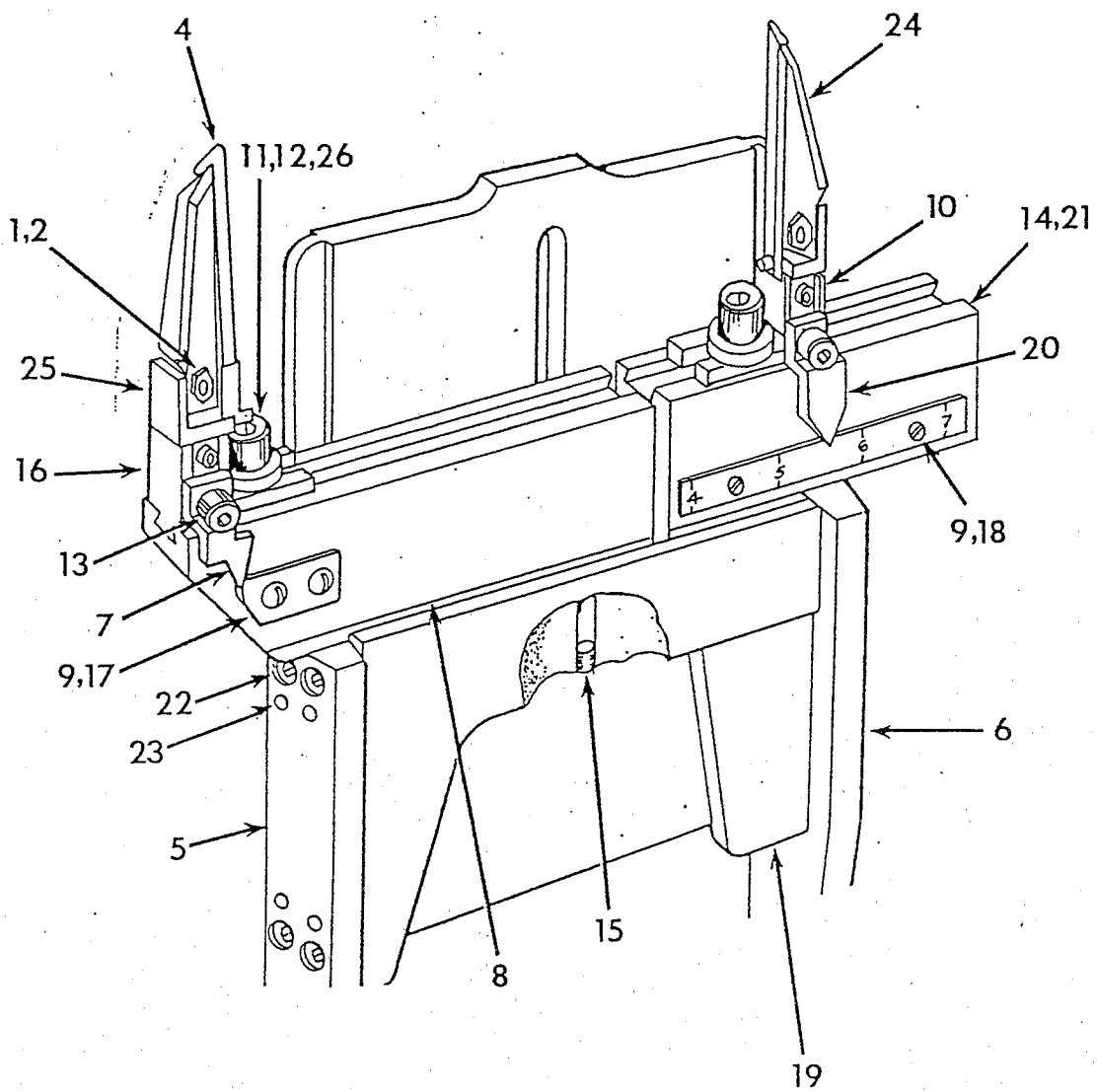
▲ When steel insert in Bedplate is damaged, replace with part no. 01-7452

◆ Nut & Ferrule (10) must be replaced when changing tubes (12 & 13) Nut & Ferrule (10) are part of fitting (9 & 26) but may also be ordered separately as a replacement part.



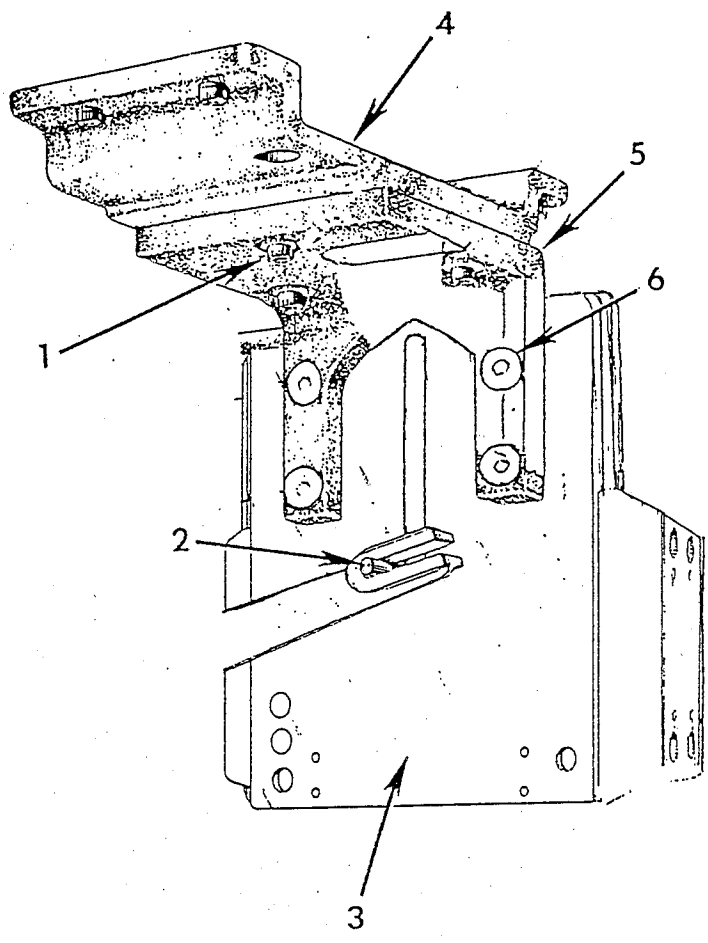
DET	PART NUMBER	DESCRIPTION
01	42-0450-0-000	Bracket
02	01-2425-0-000	Screw
03	01-4003-0-000	Lockwasher
04	01-6564-0-000	Roll Pin
05	01-4451-0-000	'O' Ring
06	41-0474-1-000	Piston
07	01-4438-0-000	'O' Ring
08	01-2404-0-000	Screw
09	40-0218-1-000	Elbow Fitting
10	40-0575-2-000	Nut and Ferrule
11	01-2407-0-000	Screw
12	07-0294-0-000	1/4" Tubing 39"
13	07-0294-0-000	1/4" Tubing 34"
14	40-0249-1-000	Cylinder
15	01-4480-0-000	'O' Ring
16	30-0194-0-000	Gasket

17	42-1058-0-000	Cap Asm.
18	40-0308-0-000	Folding Lever
19	01-3427-0-000	Nut
20	41-0247-0-000	Connector
21	01-6475-0-000	Retaining Ring
22	01-6503-0-000	Pin
23	41-0248-0-000	Piston Rod
24	01-6482-0-000	Pin
25	40-0309-0-000	Bracket
26	40-0310-1-000	Straight Fitting
29	01-2493-0-000	Screw
30	01-2411-0-000	Screw
31	01-4411-0-000	Washer
32	32-5005-0-000	Bracket
33	44-0533-0-000	Spacer
34	01-4301-0-000	'U-Cup' Seal
35	01-3404-0-000	Nut
36	01-2644-0-000	Screw



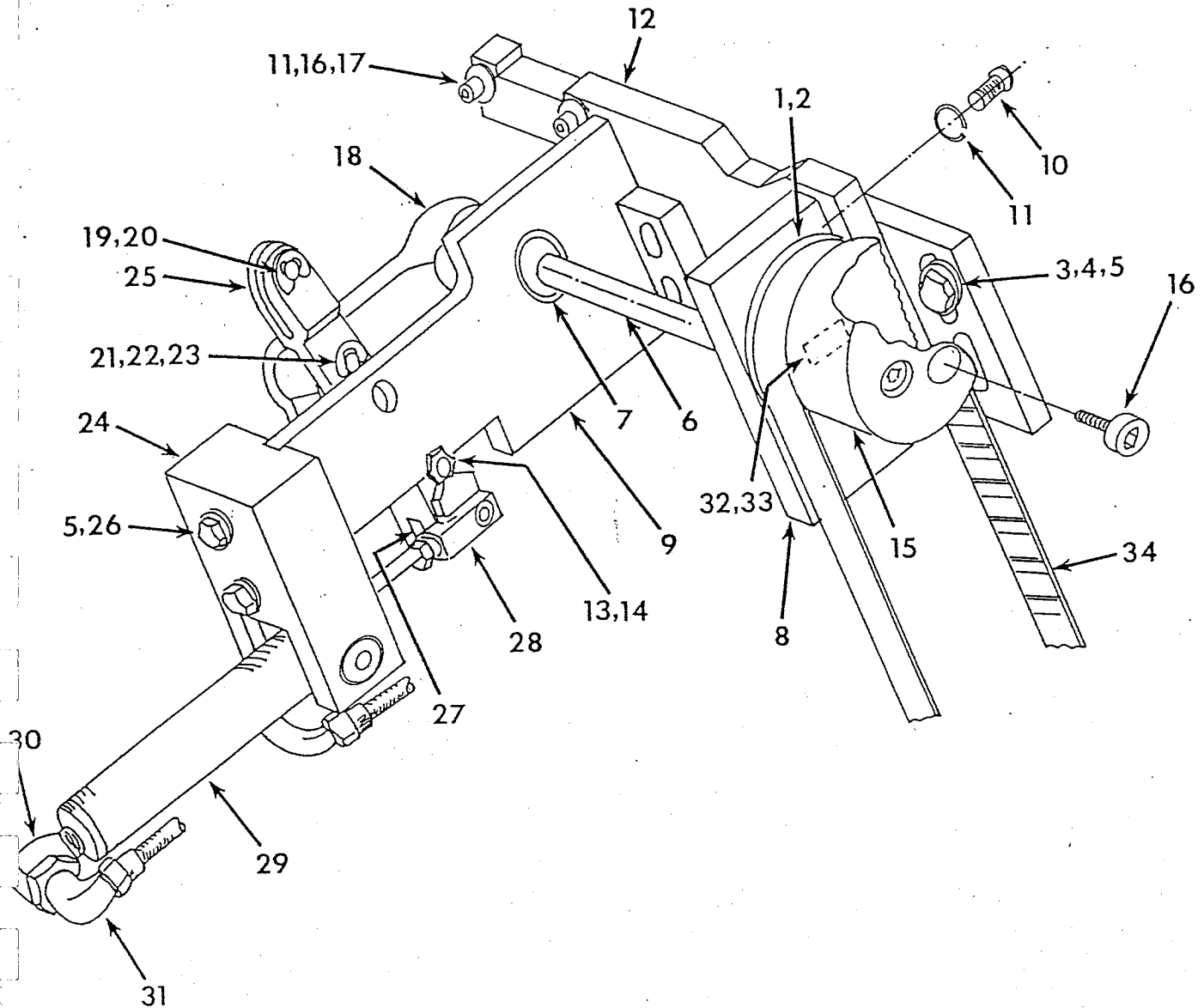
DET	PART NUMBER	DESCRIPTION			
			13	01-2413-0-000	Screw
			14	40-0438-1-000	Back Shoe Gib
			15	01-2408-0-000	Screw
			16	30-0115-0-000	Front Finger Shoe
			17	42-0389-0-000	Gauge
			18	40-0388-0-000	Scale
				40-0388-0-017	Scale Metric 10-18cm
			19	42-1282-0-000	Spacer Block
			20	40-0387-0-000	Pointer
			21	01-2435-0-000	Screw
			22	01-2412-0-000	Screw
			23	01-2639-0-000	Screw
			24	see Page	Tab Knives
			25	32-2046-0-000	Knife Holder
			26	30-0386-0-000	Slide Nut
01	01-3074-0-000	Nut			
02	01-4072-0-000	Washer			
03	01-6706-0-000	Pin			
04	32-2045-0-050	Pointer			
05	42-1519-0-000	Front Guide			
06	42-1520-0-000	Back Guide			
07	42-0387-0-000	Pointer			
08	42-0438-0-000	Front Finger Shoe Gib			
09	01-2481-0-000	Screw			
10	30-0114-0-000	Back Finger Shoe			
11	01-2423-0-000	Screw			
12	01-4404-0-000	Washer			

TAB CUTTING



DET	PART NUMBER	DESCRIPTION
01	01-2421-0-000	Screw
02	01-6706-0-000	Pin
03	32-2187-0-000	Cam Plate
04	41-0449-0-000	Bracket
05	40-0119-0-000	Bracket
06	01-2422-0-000	Screw

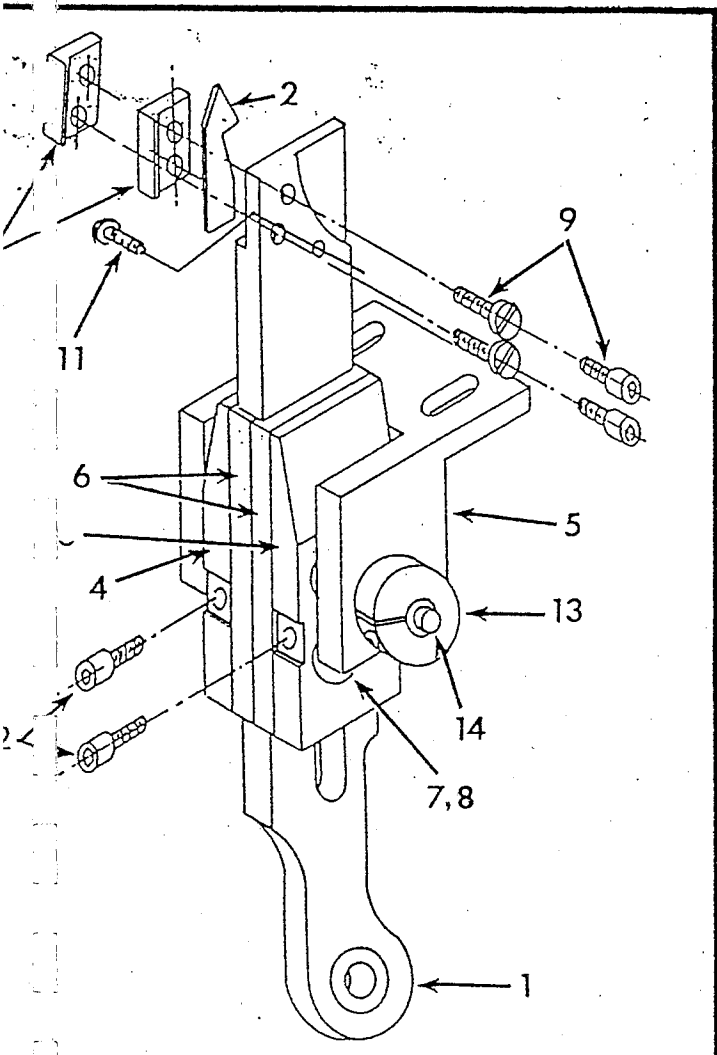
CENTER KNIFE



DET	PART NUMBER	DESCRIPTION
01	32-2009-0-000	Pulley
02	01-8416-0-002	Key
03	01-1601-0-303	Screw
04	01-4445-0-000	Washer
05	01-4004-0-000	Lockwasher
06	32-2013-0-050	Shaft Asm.
07	01-7313-0-001	Bearing
08	32-2015-0-000	Bearing Block
09	32-2016-0-000	Bearing Block
10	01-1958-0-001	Screw
11	01-4003-0-000	Lockwasher
12	32-2017-0-000	Yoke Support Bar
13	01-3472-0-000	Nut
14	01-1952-0-000	Shoulder Screw
15	32-2037-0-000	Handwheel

16	01-2437-0-000	Screw
17	01-4404-0-000	Washer
18	32-2022-0-050	Crank Asm.
19	01-6928-0-002	Pin
20	01-6475-0-000	Retaining Ring
21	01-6928-0-001	Pin
22	01-4591-0-000	Washer
23	01-6475-0-000	Retaining Ring
24	32-2027-0-050	Pivot Block Asm.
25	44-0966-2-000	Lever Asm.
26	01-1601-0-304	Screw
27	32-2030-0-050	Pivot Link Asm.
28	32-2034-0-000	Rod Clevis Asm.
29	07-0604-0-000	Air Cylinder
30	07-0003-0-001	Elbow-Street
31	07-0093-0-001	Elbow
32	32-2174-0-000	Retainer
33	01-2582-0-000	Screw
34	05-1182-0-001	Timing Belt

CENTER KNIFE

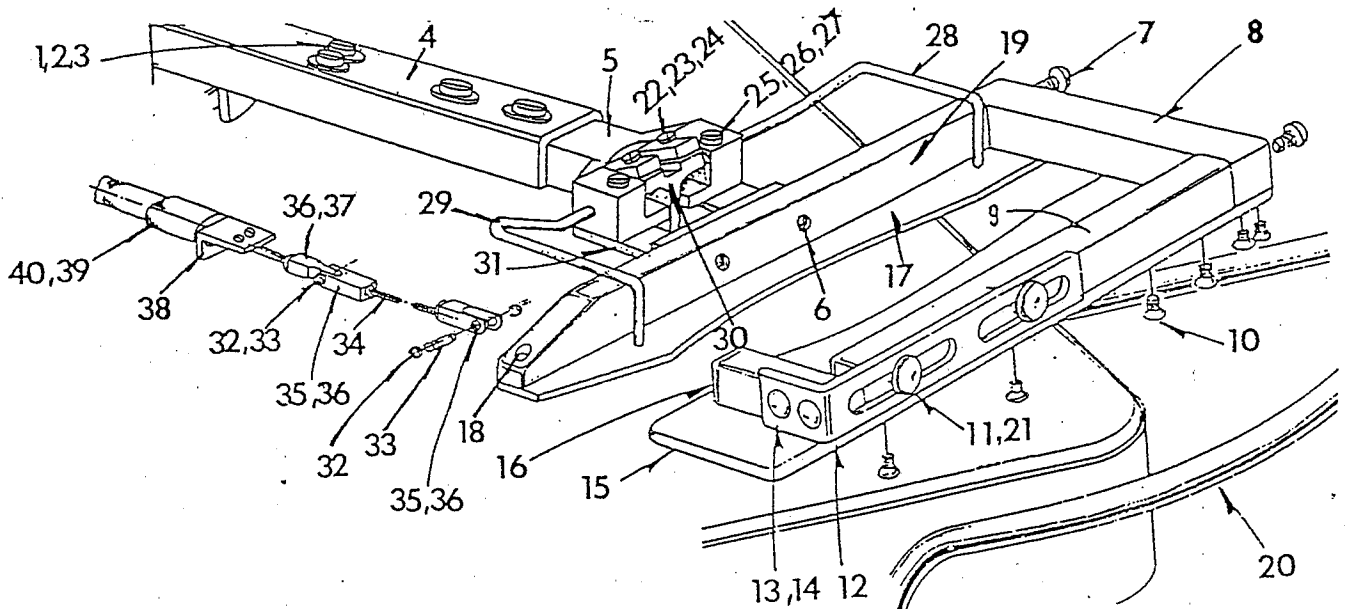


DET	PART NUMBER	DESCRIPTION
01	32-2207-0-050 32-2193-0-050	Knife Holder (3/8") Knife Holder (1/2"-7/8")
02	32-2019-1-000	Knife Blade
03	32-2195-0-000	Knife Guide-Right
04	32-2196-0-000	Knife Guide-Left
05	32-2197-0-050	Pivot Block Asm.
06	32-2194-0-000	Knife Guide Bearing
07	01-2783-0-000	Screw
08	01-3414-0-000	Nut
09	01-2431-0-000 01-1733-0-301	Screw (for 3/8") Screw (for 1/2"-7/8")
10	32-2208-0-000 32-2018-0-000	Clamp Knife (3/8") Clamp Knife (1/2"-7/8")
11	01-2318-0-000	Screw
12	01-2693-0-000	Set Screw
13	01-7314-0-001	Clamp Collar
14	01-6950-0-004	Pin

OPTION - Hydraulic Center Knife Asm. 32-2199-0-050

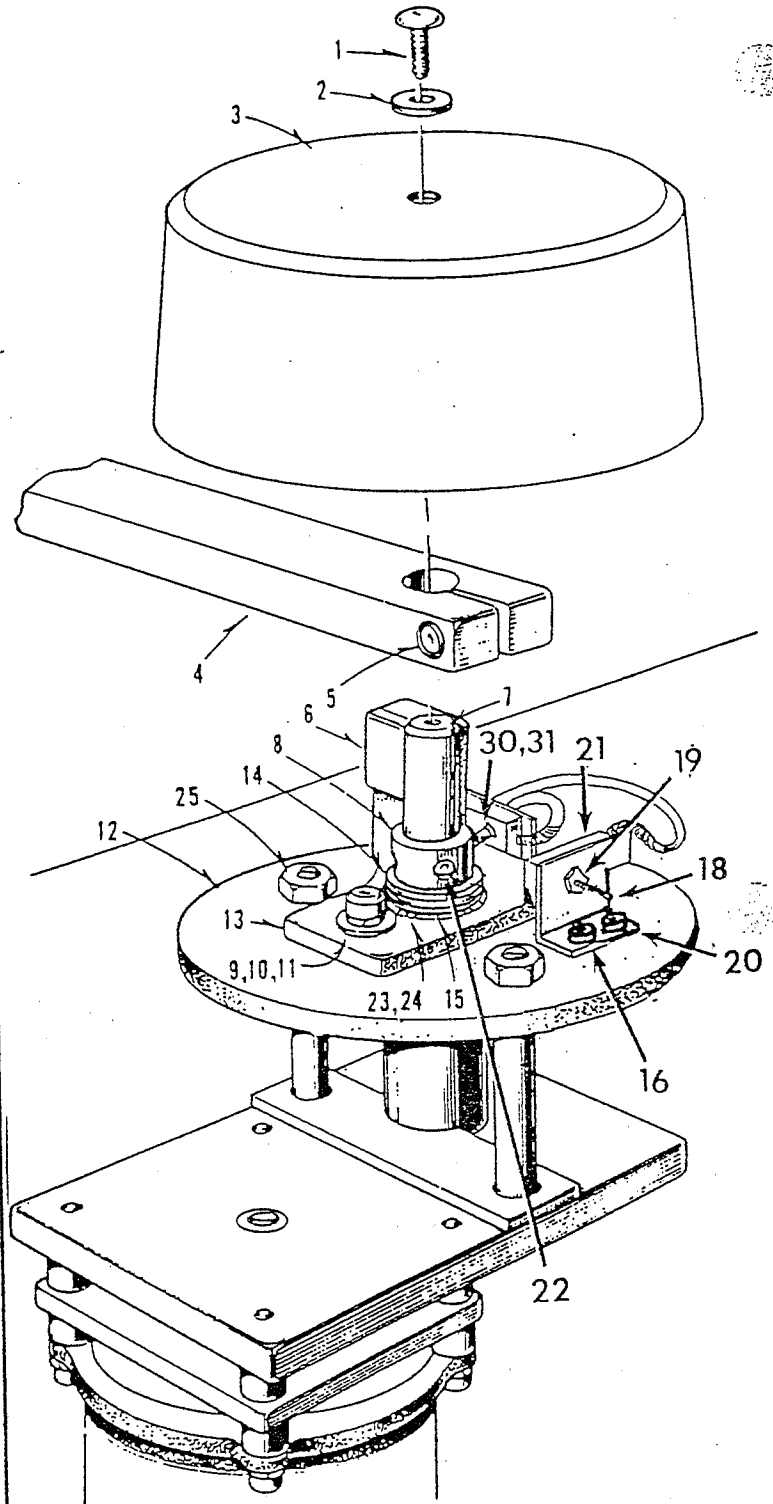
04-0815	Bolt	32-2190	Valve Block
07-0668	Hydraulic Cylinder	32-2191	Pivot
32-1033	Threaded Rod	32-2192	Cylinder Mount
32-2189	Pivot Block	32-2198-0-050	Retracting Cylinder Asm.
32-2189-0-050	Pivot Block Asm.	01-1148	Screw

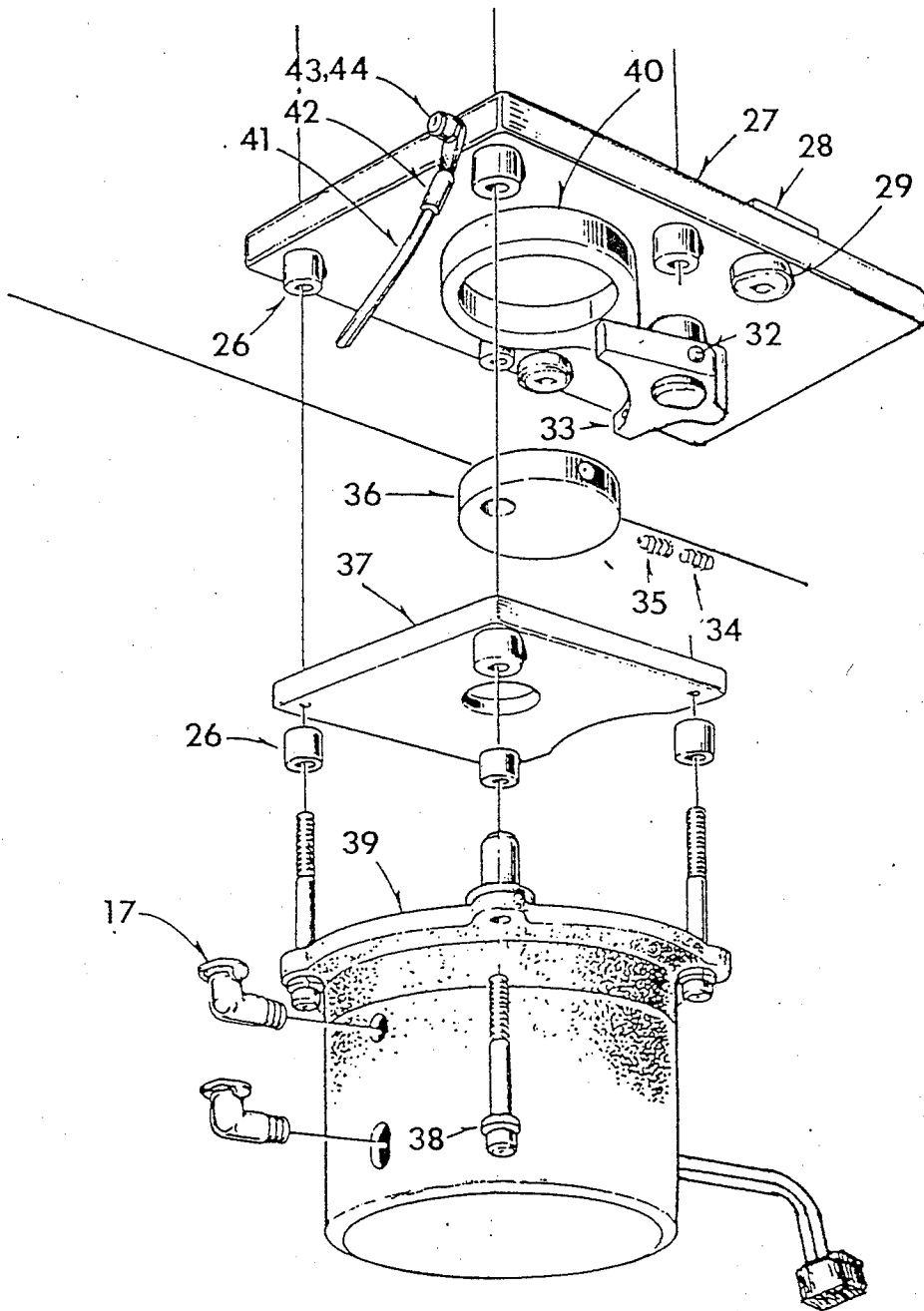
WELT STYLE (W =)	AUTOMATIC PATCH LOADING TRAY ASSEMBLIES			
	ASSEMBLY	TRAY PLATE, left (15)	TRAY PLATE, right (17)	BACK BLOCK (8)
690, 730	40-0515-1-050	40-0830-0-187	40-0831-0-187	40-0515-1-275
759, 786, 850	40-0515-1-052	40-0830-0-187	40-0831-0-062	40-0515-1-275
801, 945	40-0515-1-054	40-0830-0-438	40-0831-0-938	40-0515-1-300
Above models equipped with 6" trays except 801 & 945	41-0515-0-051	40-0830-0-438	40-0831-0-938	40-0515-1-275

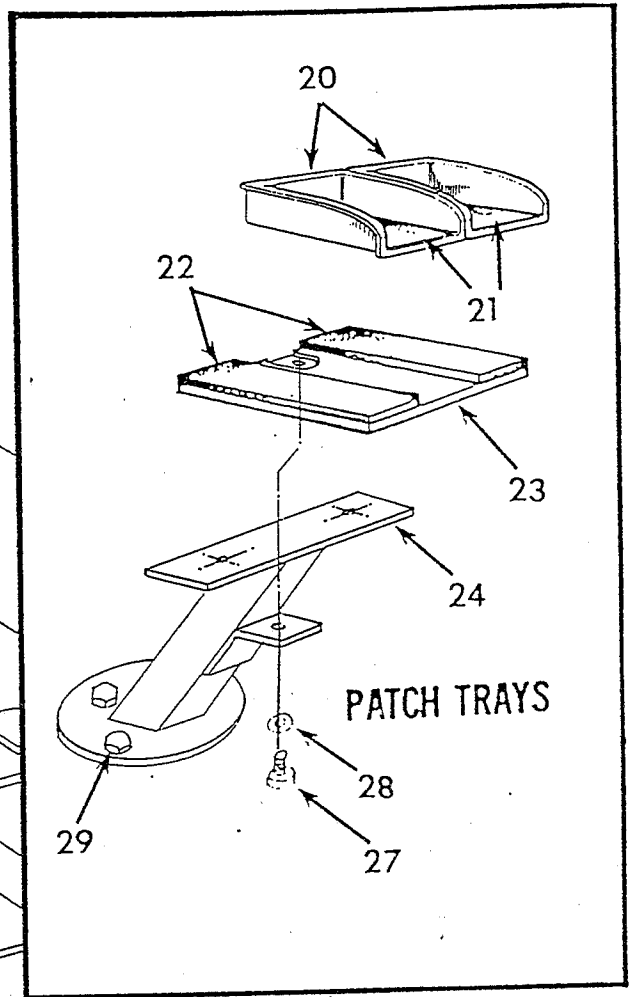
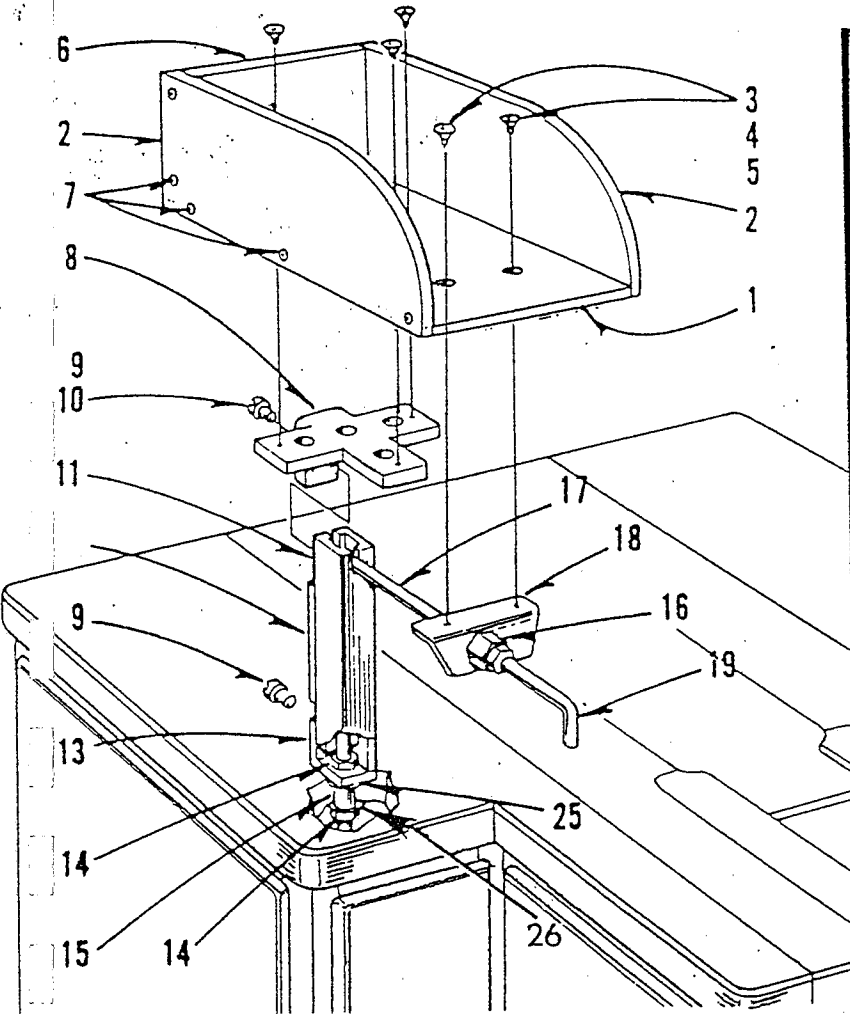


DET	PART NUMBER	DESCRIPTION
01	01-2247-0-000	Screw
02	01-4572-0-000	Lockwasher
03	01-4579-0-003	Washer
04	44-2102-1-000	Arm
05	44-2075-0-000	Neck
06	01-2545-0-000	Screw
07	01-2712-0-000	Screw
08	see Chart	Back Block
09	40-0832-0-002	Tray Rail, Left
10	01-2488-0-000	Screw
11	01-2633-0-000	Screw
12	40-0514-1-000	Tray Ear
13	01-2597-0-000	Screw
14	01-4528-0-000	Lockwasher
15	see Chart	Tray Plate, Left
16	40-0841-0-000	Patch Holder
17	see Chart	Tray Plate, Right
18	01-2472-0-000	Screw
19	40-0832-0-001	Tray Rail, Right
20	42-0927-0-000	Patch Loader Guard
21	01-4412-0-000	Washer
22	01-2246-0-001	Screw
23	01-4729-0-000	Washer
24	01-4673-0-000	Lockwasher
25	01-2599-0-102	Screw
26	01-4072-0-000	Washer
27	01-4571-0-000	Lockwasher
28	32-2152-0-000	Clamp-Long
29	32-2153-0-000	Clamp-Short
30	44-2076-0-000	Tray Yoke
31	32-2151-0-000	Bracket
32	01-6368-0-000	Retaining Ring
33	01-6943-0-000	Pin
34	44-2082-0-000	Threaded Rod
35	44-2079-0-000	Clevis
36	01-3414-0-000	Nut
37	44-2078-0-000	Cylinder Clevis
38	44-2077-0-000	Bracket
39	07-0388-0-000	Cylinder
40	07-0387-0-000	Elbow - 90 deg. Barb

DET	PART NUMBER	DESCRIPTION
01	01-2536-0-000	Screw
02	01-4404-0-000	Washer
03	32-2134-0-000	Cover
04	44-2102-1-000	Loader Arm
05	01-2449-0-000	Screw
06	40-0773-0-000	Stop Pad
07	42-0498-0-000	Shaft
08	40-0496-1-000	Collar
09	01-2460-0-000	Screw
10	01-4422-0-000	Lockwasher
11	01-4491-0-000	Washer
12	42-0877-0-000	Mounting Flange
13	42-0769-0-000	Stop
14	01-4493-0-000	Race (2 used)
15	01-7458-0-000	Bearing
16	01-2401-0-000	Screw
17	30-0011-0-000	Oil Cup
18	01-1787-0-000	Screw
19	01-3157-0-000	Nut
20	32-5009-0-000	Bracket
21	06-0821-0-000	Switch
22	01-2522-0-000	Set Screw
23	01-4507-0-000	'O' Ring (outer)
24	01-4450-0-000	'O' Ring (inner)
25	01-3406-0-000	Lock Nut
26	01-7475-0-000	Spacer
27	40-0775-0-850	Mounting Plate
28	40-0772-0-000	Spacer
29	01-1460-0-000	Screw
30	01-2644-0-000	Screw
31	01-3404-0-000	Nut
32	01-8420-0-000	Roll Pin
33	40-0500-1-050	Actuator
34	01-2673-0-000	Set Screw
35	01-2674-0-000	Set Screw
36	40-0777-0-000	Eccentric
37	40-0771-0-000	Guide Plate
38	01-4407-0-000	Lockwasher
39	04-0285-1-000	Patch Loader Motor (60 Hz)
	04-0285-1-001	Patch Loader Motor (50 Hz)
40	40-0776-0-000	Eccentric Arm
41	42-0262-0-155	Jumper
42	30-0278-0-000	Wire Terminal
43	01-2804-0-000	Screw
44	01-4572-0-000	Lockwasher



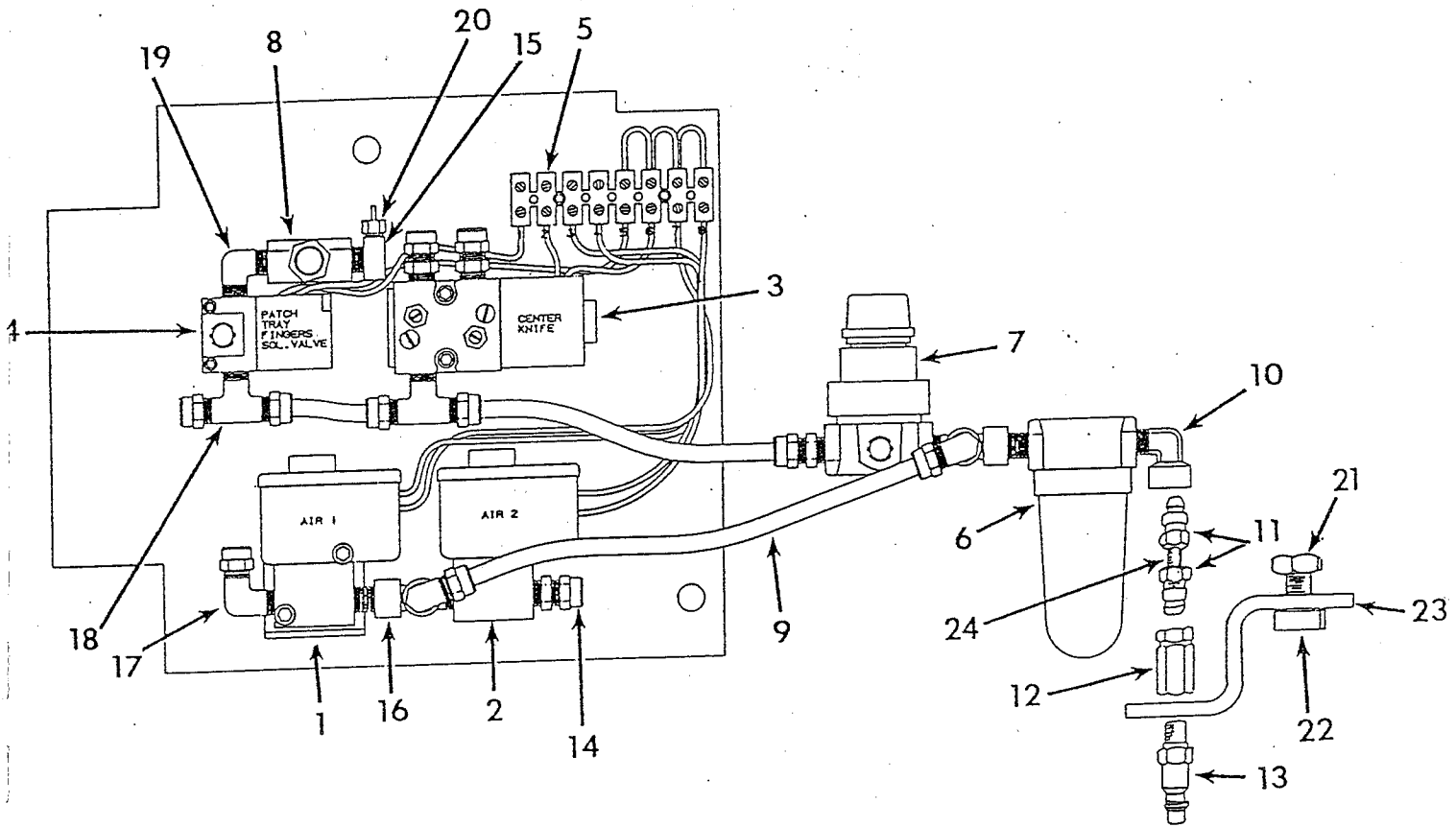




DET	PART NUMBER	DESCRIPTION
01	32-2163-0-000	Bottom Tray
02	32-2161-0-000	Side Tray
03	01-2583-0-000	Screw
04	01-4407-0-000	Lockwasher
05	01-3001-0-000	Nut
06	32-2162-0-000	Back Tray
07	01-2706-0-000	Screw
08	32-2166-0-000	Bracket
09	04-0396-0-000	Screw
10	04-0467-0-000	Nut Block
11	32-2164-0-000	Column
12	04-0490-0-071	Cover
13	04-0388-0-000	Angle
14	01-3419-0-000	Lock Nut

15	42-0924-0-000	Nipple
16	42-0930-0-000	Union
17	07-0294-0-000	Tubing, 80"
18	42-0929-0-000	Bracket
19	40-0816-0-000	Air Nozzle
20	32-2170-0-000	Patch Tray (3/8"-7/8")
21	40-0640-0-000	Pad (3/8")
	41-0640-0-000	Pad (5/8"-7/8")
	42-0640-0-000	Pad (3/8"-1/2")
		using 3" patches
22	42-0931-0-000	Tape, 3-3/8"
23	42-0942-0-000	Base
24	32-5012-0-000	Support
25	01-4569-0-000	Felt Washer
26	01-4500-0-000	Spacer
27	01-2421-0-000	Screw
28	01-4603-0-000	Washer
29	01-2640-0-000	Screw

• Available in multiples of one foot.

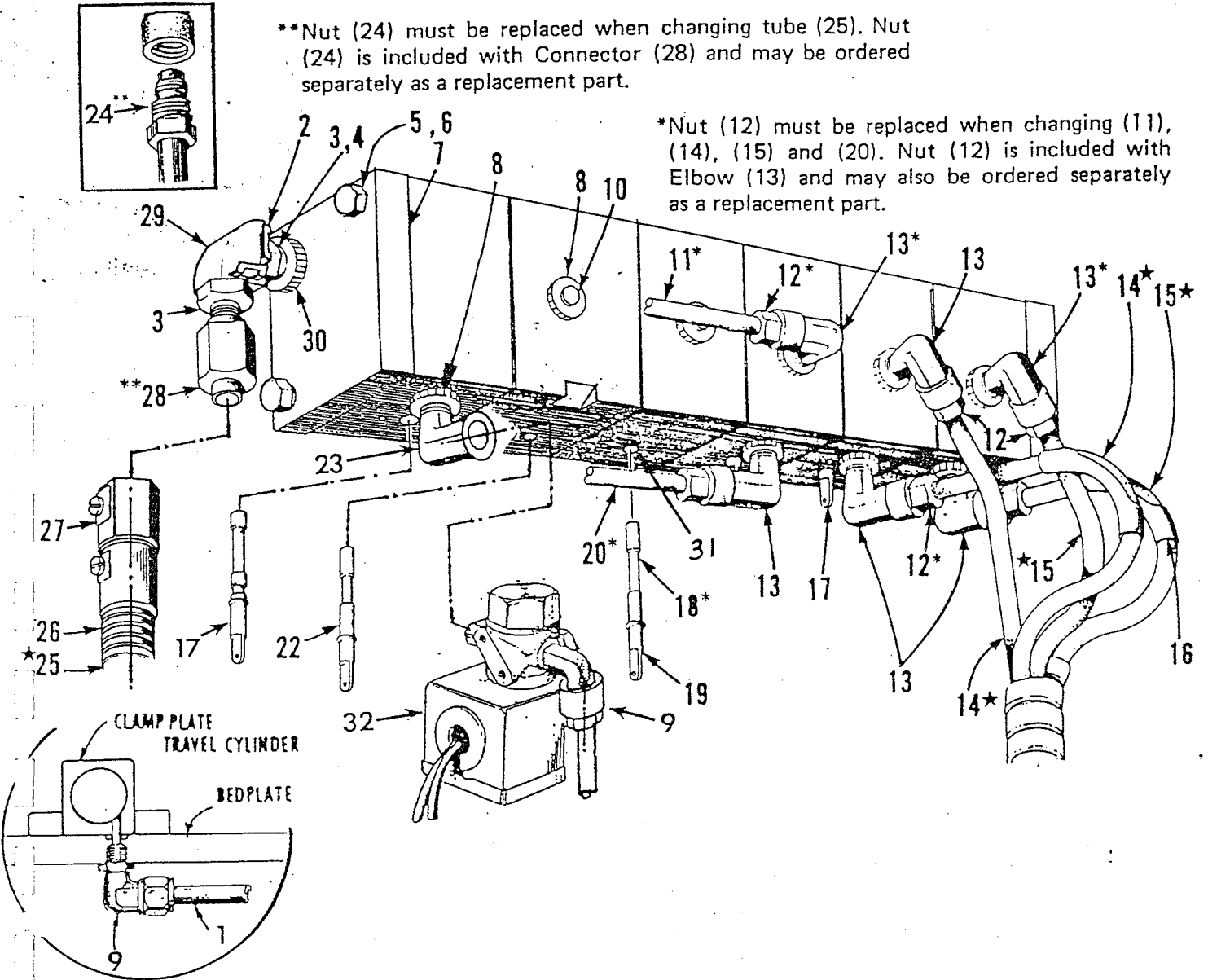


DET	PART NUMBER	DESCRIPTION
01	04-1053-0-000	Bracket
02	04-1052-0-000	Valve
03	07-0764-0-000	Valve <i>07-0606-</i>
04	07-0608-0-000	Valve
05	06-0643-0-004	Terminal Strip
06	04-0496-0-000	Filter
07	04-1017-0-000	Regulator
08	07-0097-0-000	Flow Control
09	07-0294-0-000	1/4" Tubing
10	07-0568-0-000	Elbow
11	07-0763-0-000	Fitting Nut
12	42-0908-0-000	Coupling
13	04-2003-0-000	Plug
14	07-0092-0-001	Connector
15	20-6245-0-000	Elbow
16	20-6051-0-000	Tee
17	07-0093-0-001	Elbow
18	07-0037-0-001	Tee
19	04-2083-0-000	Elbow
20	04-2041-0-000	Connector
21	04-0396-0-000	Screw
22	04-0467-0-000	Nut
23	42-0919-0-000	Bracket
24	40-0823-0-000	1/4 Tubing, Copper

MANIFOLD

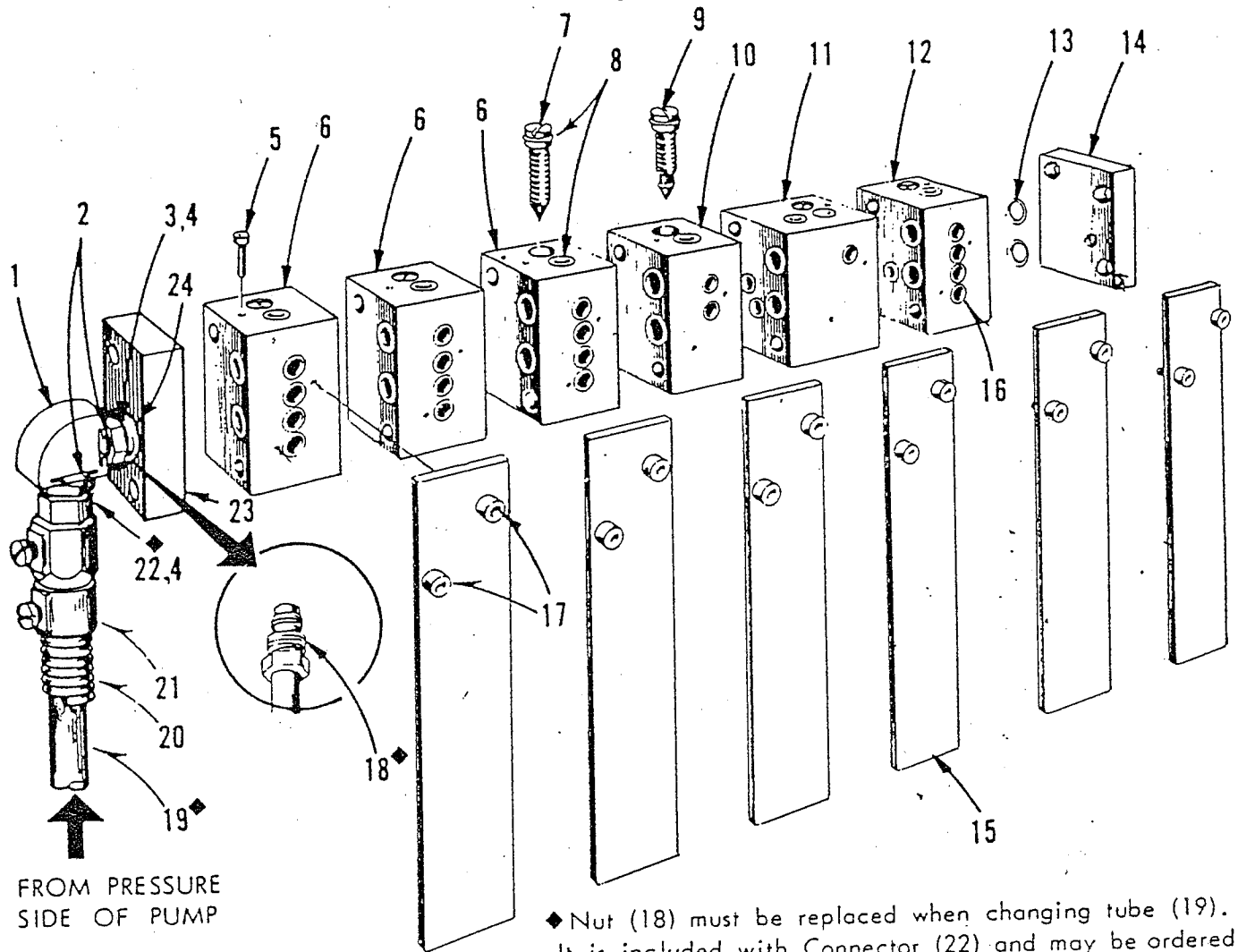
**Nut (24) must be replaced when changing tube (25). Nut (24) is included with Connector (28) and may be ordered separately as a replacement part.

*Nut (12) must be replaced when changing (11), (14), (15) and (20). Nut (12) is included with Elbow (13) and may also be ordered separately as a replacement part.



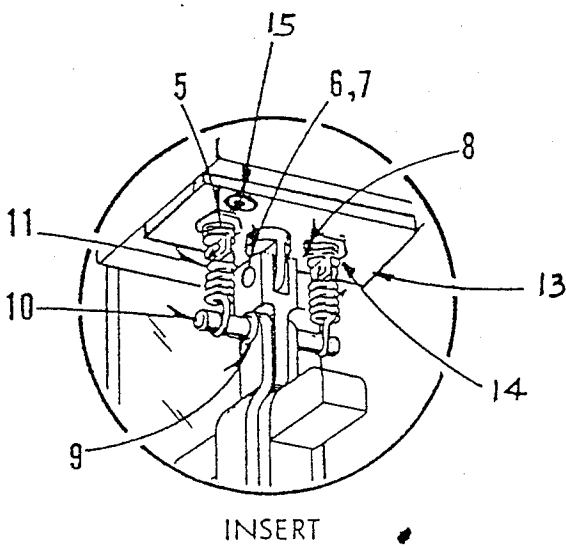
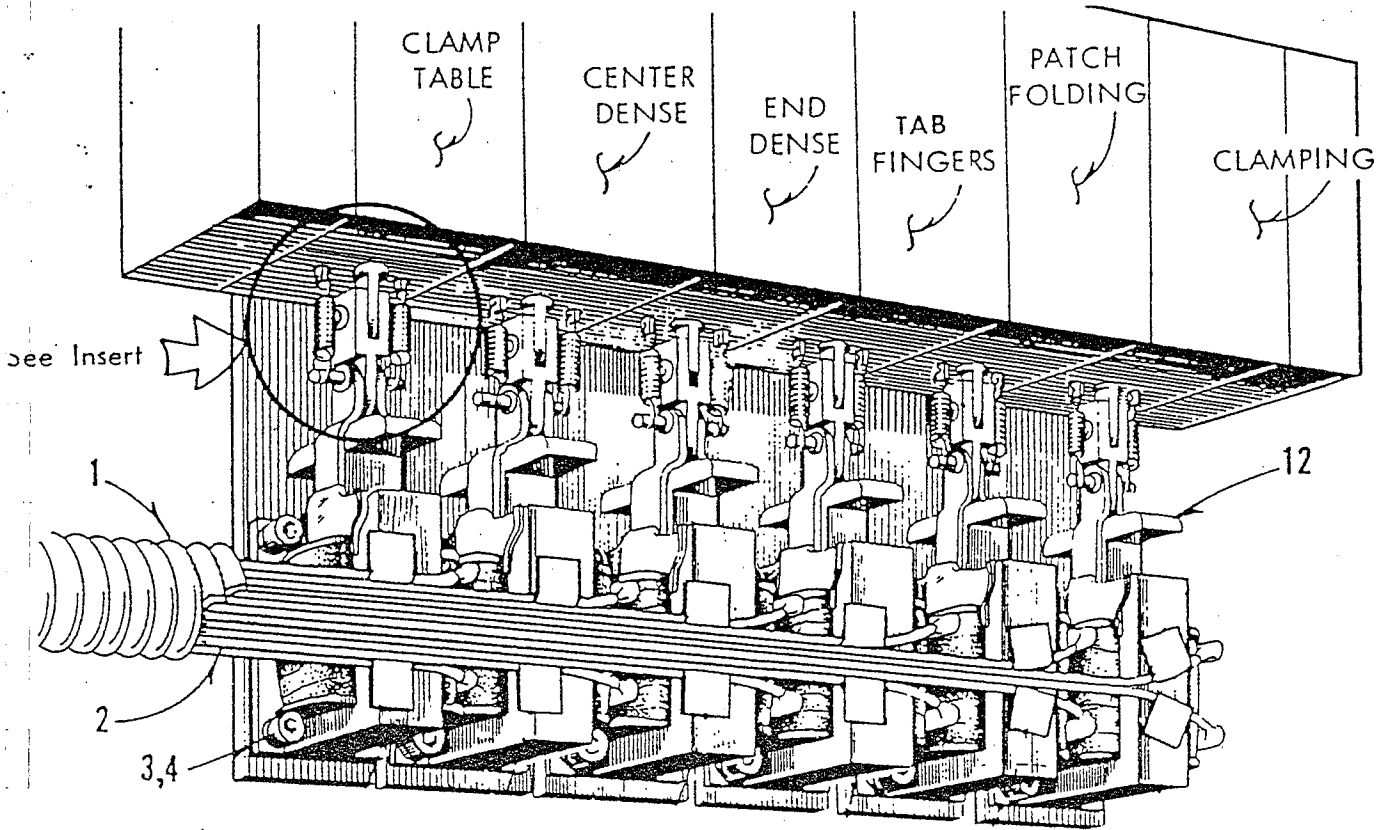
DET	PART NUMBER	DESCRIPTION			
			18	42-1049-0-000	Plunger
			19	01-4483-0-000	'O' Ring
			20	42-0953-0-000	Copper Tube
			22	42-1050-0-000	Plunger
			23	04-2083-0-000	Elbow
			24	40-0574-0-000	Nut
			25	40-0826-0-000	Tubing, 30"
			26	40-0594-0-000	Autoflex, 34"
			27	42-0598-0-000	Coupling
			28	07-0420-0-000	Connector
			29	42-0909-0-000	Elbow
			30	01-3419-0-000	Nut
			31	01-4300-0-000	'U-Cup' Seal
			32	06-0131-0-000	Valve - Solenoid
01	40-0826-0-000	3/8" Tubing - 11"			
02	42-0913-0-000	Clip			
03	42-0914-0-000	'O' Ring			
04	42-0911-0-000	Connector			
05	01-2540-0-000	Bolt			
06	01-4578-0-000	Lockwasher			
07	40-0603-0-000	Slide Plate (L.H.)			
08	01-3424-0-000	Nut			
09	07-0690-0-000	Elbow			
10	01-2438-0-000	Plug			
11	42-0952-0-000	Copper Tube			
12	40-0575-2-000	Nut & Ferrule			
13	07-0568-0-000	Elbow			
14	07-0294-0-000	1/4" Tubing, 27"			
15	07-0294-0-000	1/4" Tubing, 27"			
16	40-0564-0-000	Tube Bending Clip			
17	42-1048-0-000	Plunger			

*Available only in multiples of one foot.



♦ Nut (18) must be replaced when changing tube (19). It is included with Connector (22) and may be ordered separately as a replacement part.

DET	PART NUMBER	DESCRIPTION			
01	42-0909-0-000	Elbow	17	01-2492-0-000	Screw
02	42-0913-0-000	Clip	18	40-0574-0-000	Nut
03	42-0911-0-000	Connector	19	40-0826-0-000	Tubing, 27-1/2"
04	42-0914-0-000	'0' Ring	20	40-0594-0-000	Autoflex, 40-1/2"
05	01-2421-0-000	Screw	21	42-0598-0-000	Coupling
06	42-1052-0-000	Valve Block	22	07-0420-0-000	Connector
07	40-0524-0-000	Metering Pin (5 used)	23	40-0604-0-000	Side Plate, Right
08	01-4482-0-000	'0' Ring	24	01-3419-0-000	Nut
09	40-0607-0-000	Metering Pin			
10	42-1053-0-000	Valve Block			
11	42-1054-0-000	Valve Block			
12	42-1061-0-000	Valve Block			
13	01-4428-0-000	'0' Ring			** Available only in multiples of one foot.
14	40-0603-0-000	Side Plate, Left			
15	40-0606-0-000	Cover Plate			
16	01-4426-0-000	'0' Ring			



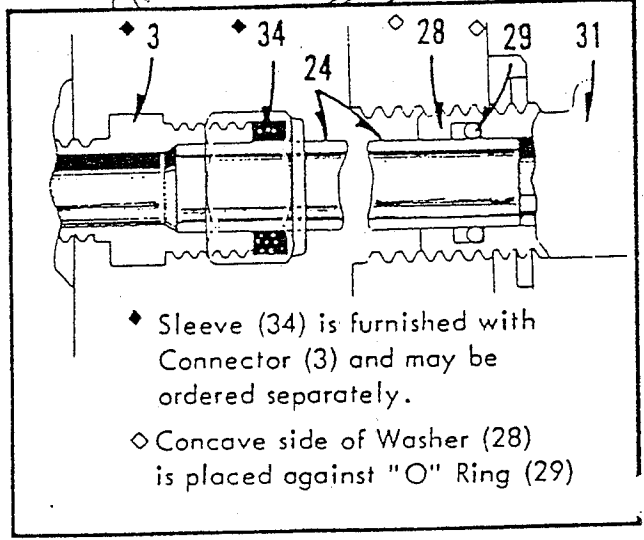
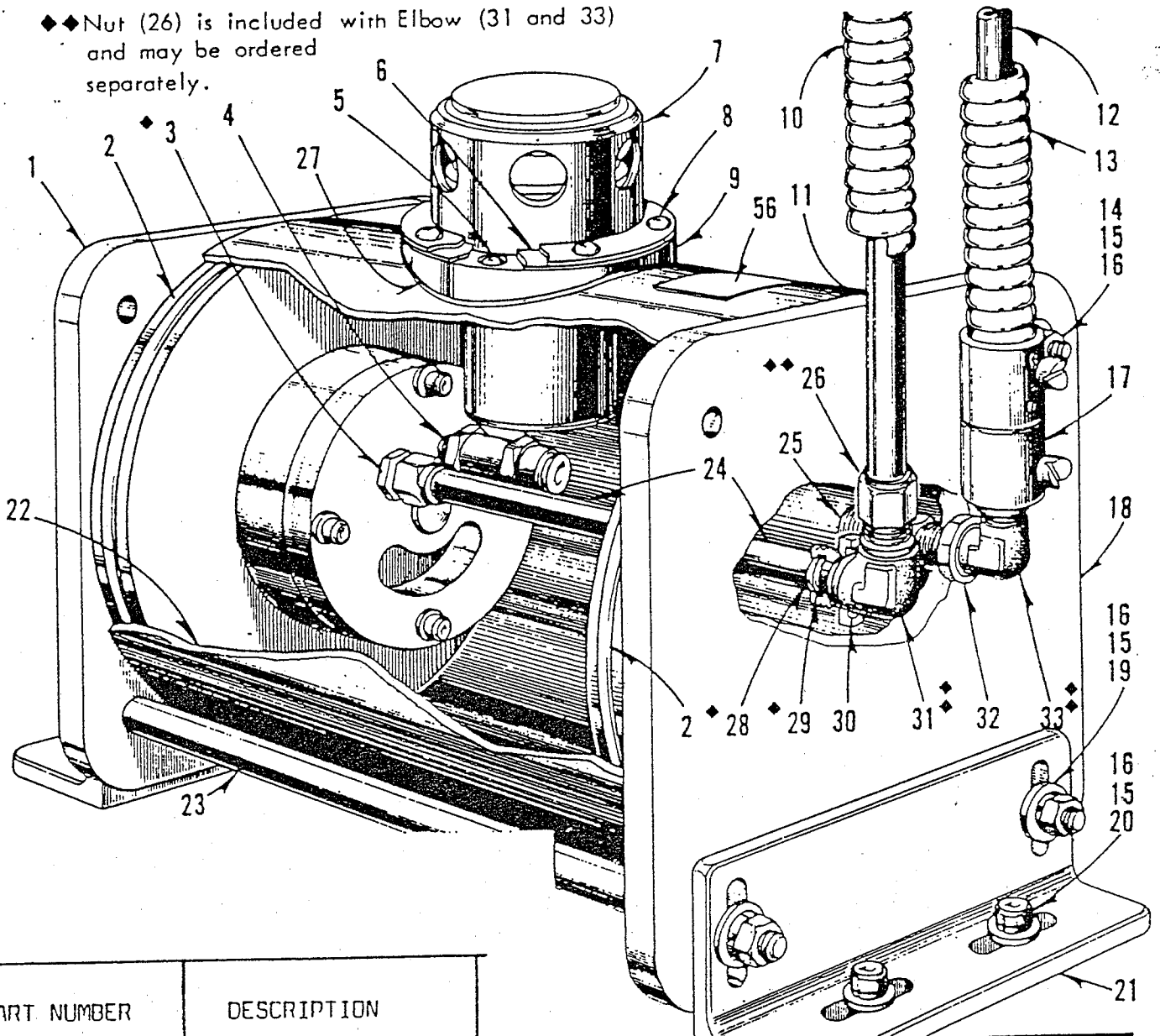
DET	PART NUMBER	DESCRIPTION
01	40-0586-0-000	'Spirap' - 24"
02	42-0262-3-116	Head Harness
03	01-2411-0-000	Screw
04	01-4406-0-000	Lockwasher
05	01-1422-0-000	Anchor
06	01-6549-0-000	Pin
07	01-6547-0-000	Retaining Ring
08	42-0525-0-000	Link
09	01-6551-0-000	Retaining Ring
10	01-6550-0-000	Pin
11	01-5425-0-000	Spring
12	40-0506-0-000	Solenoid
13	42-1051-0-000	Hold Down Plate
14	01-3401-0-000	Nut
15	01-2729-0-000	Screw

*Available only in multiples of one foot.

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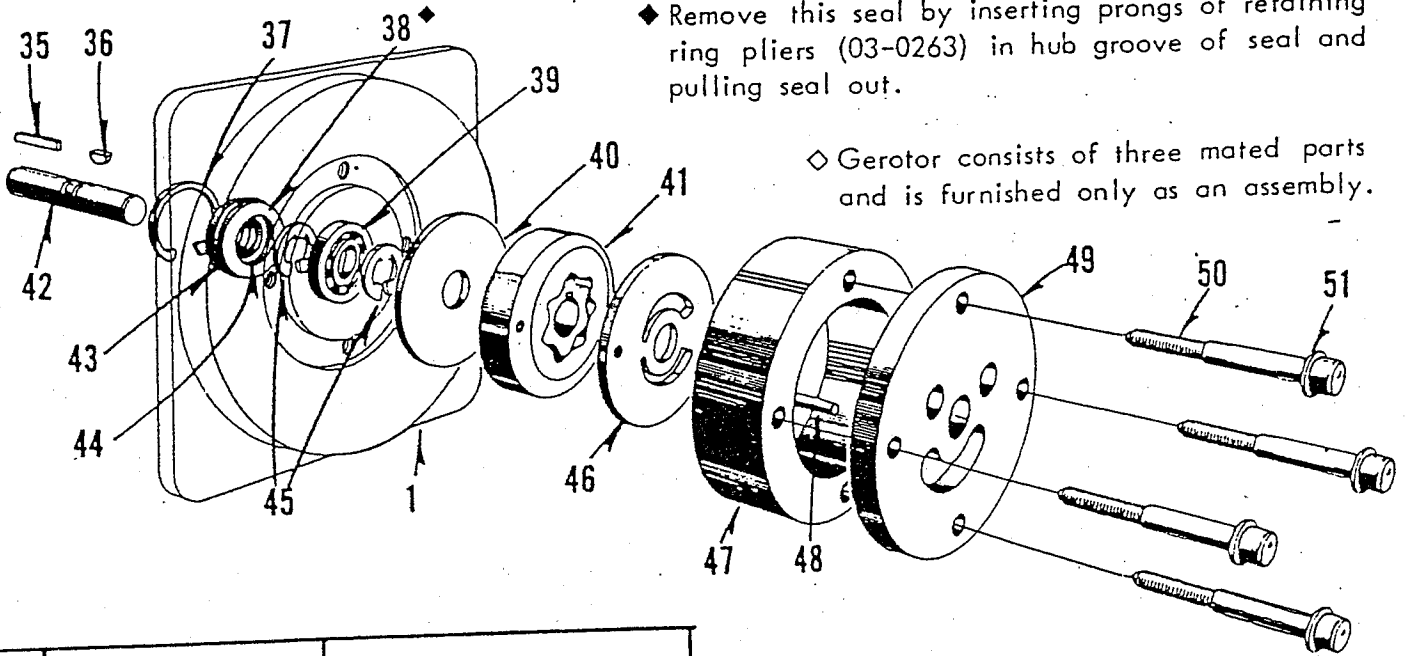
HYDRAULIC PUMP

◆◆Nut (26) is included with Elbow (31 and 33) and may be ordered separately.

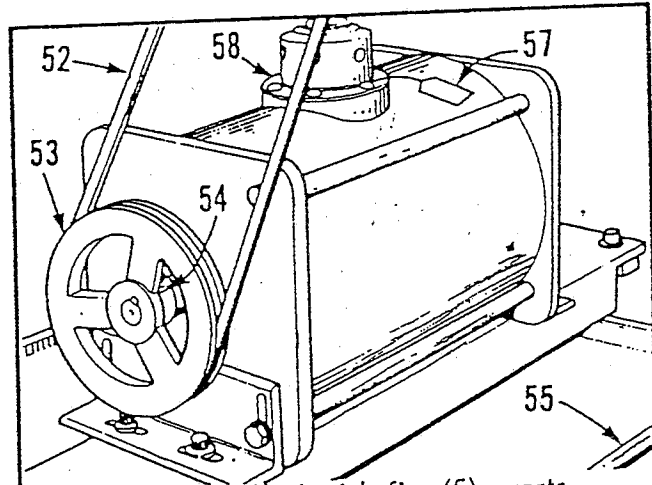


**Available only in multiples of one foot.

QTY	PART NUMBER	DESCRIPTION
1	40-0719-0-000	End Plate, Left
1	01-4505-0-000	'O' Ring
03	30-0342-0-000	Connector
04	40-0731-0-000	Relief Valve
1	01-2654-0-000	Screw
06	40-1013-0-000	Gasket
07	40-0729-0-000	Filler Cap
1	01-2536-0-000	Screw
1	40-0722-0-000	Filler Base
10	40-0594-0-000	Autoflex, 27-1/2"
11	40-0826-0-000	Tubing, 27-1/2"
12	40-0826-0-000	Tubing, 30"
13	40-0594-0-000	Autoflex, 30"
14	01-2615-0-000	Bolt w/Nut
15	01-3406-0-000	Nut
15	01-4422-0-000	Lockwasher
16	01-4400-0-000	Washer
17	40-0598-0-000	Coupling
18	40-0720-0-000	End Plate, Right



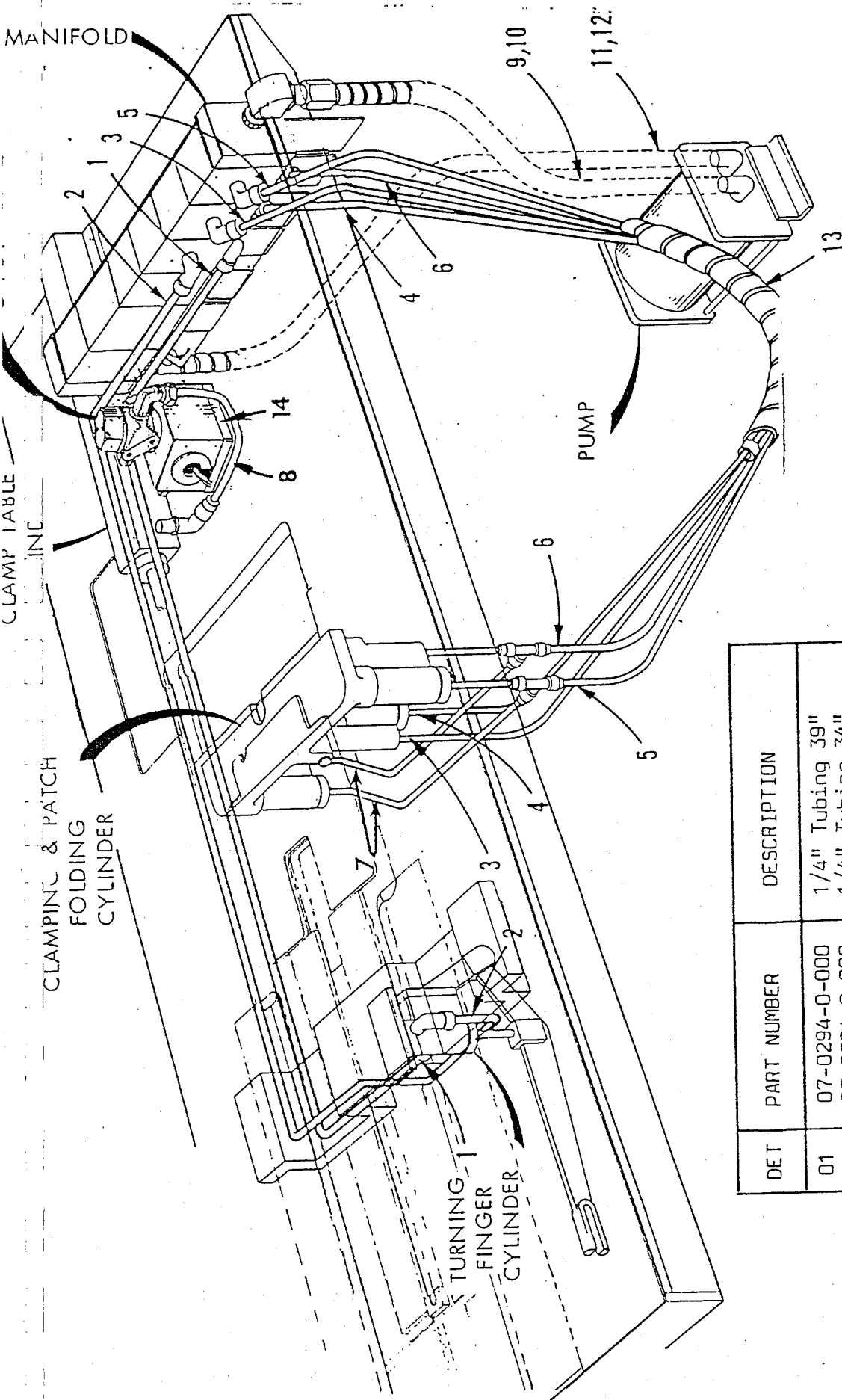
DET	PART NUMBER	DESCRIPTION
19	01-2614-0-000	Bolt w/Nut (01-3406)
20	01-2483-0-000	Screw
21	40-0721-0-000	Bracket
22	40-0718-0-000	Tank
23	40-0737-0-000	Tube
24	40-0734-0-000	Copper Tube
25	40-0730-0-000	Check Valve
26	40-0574-0-000	Ferruled Nut
27	40-0723-0-000	Gasket
28	01-4508-0-000	Back-up Washer
29	01-4428-0-000	'O' Ring
7	01-3441-0-000	Lock Nut
31	40-0733-1-050	Elbow
32	01-3419-0-000	Lock Nut
33	40-0236-0-000	Elbow
34	30-0226-0-000	Sleeve
35	01-8403-0-000	Square Key
36	01-8404-0-000	Woodruff Key
37	01-6585-0-000	Retaining Ring
38	40-0726-0-000	Shaft Seal
39	01-7465-0-000	Bearing
40	40-0732-0-000	Inner Disc
41	40-0728-0-000	Gerotor
42	40-0727-0-000	Shaft
43	01-4136-0-000	'O' Ring (outer)
44	01-4135-0-000	'O' Ring (inner)
45	01-6583-0-000	Retaining Ring
46	40-0735-0-000	Port Disc
47	40-0724-0-000	Gerotor Disc
48	01-6584-0-000	Pin
49	40-0725-0-000	Cover Plate
50	01-2613-0-000	Screw
51	01-4404-0-000	Lockwasher
52	05-0087-0-440	Belt (60 Hz.)
	05-0087-0-450	Belt (50 Hz.)



Pump must be filled with five (5) quarts hydraulic oil of the type that meets specifications "Aircraft Hydraulic Oil BB Code 1537" (05-0357-1). Pumps that are shipped prefilled have a shipping seal (40-0736) across the opening of the filler cap. Cut out this seal before operating pump. Oil pressure (165 p.s.i.) may be checked only at clamp table cylinder using gauge adaptor 03-0195.

53	40-0347-0-000	Pulley
54	01-2573-0-000	Screw
55	42-0353-0-000	Oil Pan
56	05-0421-0-000	Label, Oil Spec.
57	05-0422-0-000	Tag
58	see Note	Shipping Seal

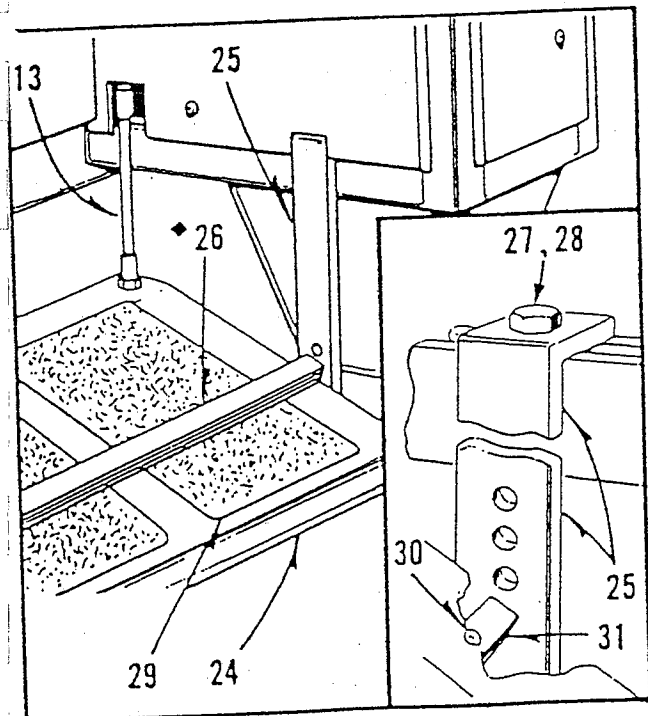
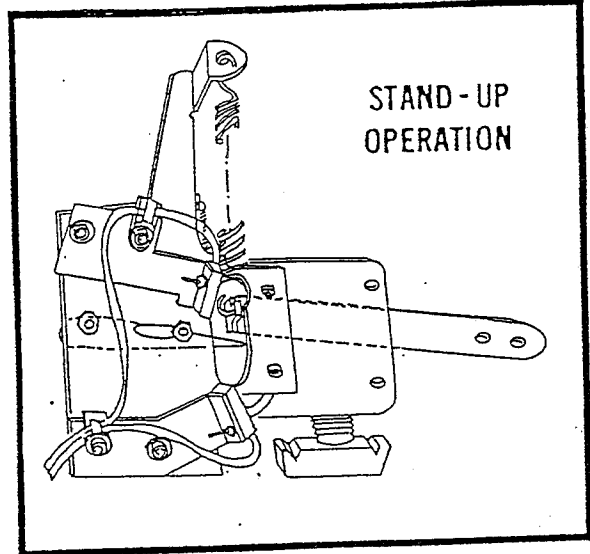
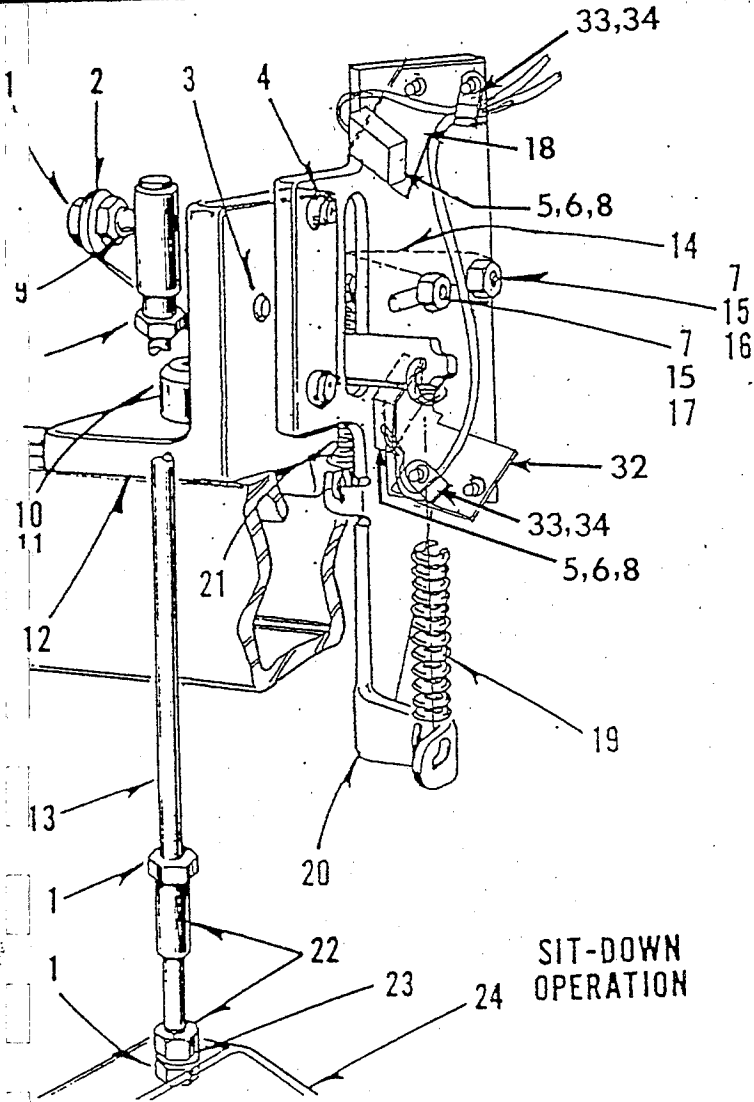
44 HYDRAULIC LINES & COMPONENTS



DET	PART NUMBER	DESCRIPTION
01	07-0294-0-000	1/4" Tubing 39"
02	07-0294-0-000	1/4" Tubing 34"
03	07-0294-0-000	1/4" Tubing, 27"
04	07-0294-0-000	1/4" Tubing 27"
05	07-0294-0-000	1/4" Tubing 27"
06	07-0294-0-000	1/4" Tubing 27"
07	07-0294-0-000	1/4" Tubing 5"
08	40-0826-0-000	3/8" Tubing 11"
09	40-0594-0-000	Conduit, 27-1/2"
10	40-0826-0-000	3/8" Tubing 27-1/2"
11	40-0594-0-000	Conduit, 30"
12	40-0826-0-000	3/8" Tubing, 30"
13	40-0586-0-000	Spirap, 45"
14	06-0131-0-000	Solenoid

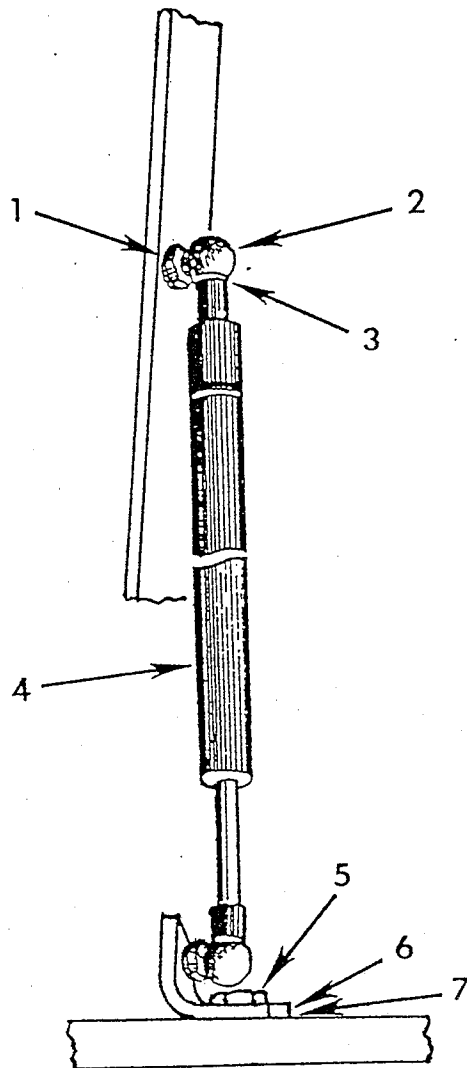
• Available only in multiples of one foot

PEDAL

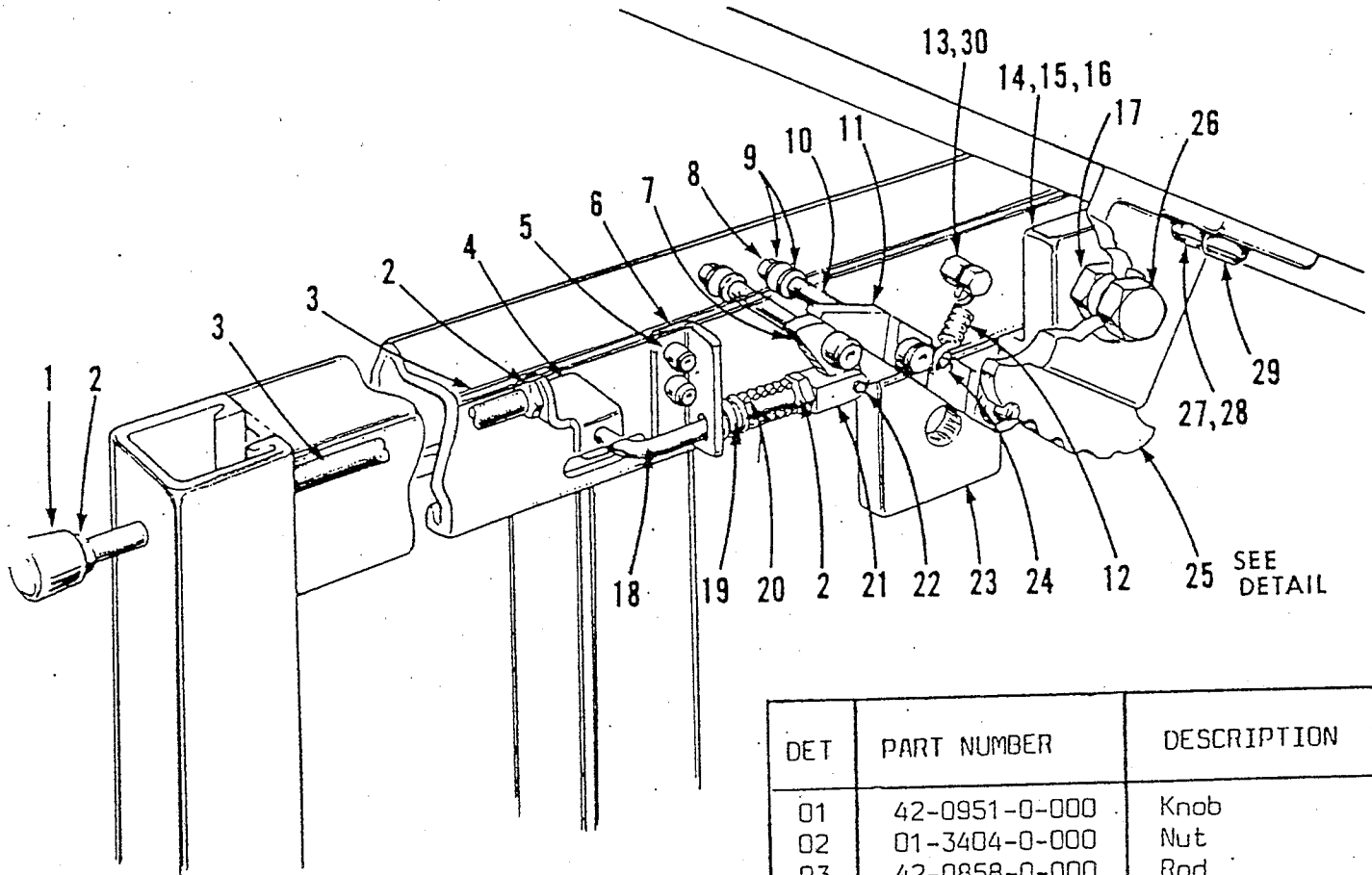


DET	PART NUMBER	DESCRIPTION
01	01-3404-0-000	Nut
02	42-0850-0-000	Actuator Arm
03	01-1467-0-000	Screw
04	01-2764-0-000	Screw
05	06-0821-0-000	Switch
06	01-1787-0-000	Screw
07	01-3401-0-000	Nut
08	01-3157-0-000	Nut
09	20-6261-0-000	Ball Joint Asm.
10	01-2455-0-000	Screw
11	04-0467-0-000	Nut Block
12	04-0468-0-000	Bracket
13	42-0857-0-000	Rod
14	42-0853-0-000	Stop Lever
15	01-4550-0-000	Washer
16	01-7487-0-000	Bushing
17	01-2413-0-000	Screw
18	32-5010-0-000	Bracket
19	01-5498-0-000	Spring
20	42-0852-0-000	Mounting Plate
21	01-5499-0-000	Spring
22	20-6263-0-000	Ball Joint Asm.
23	01-4003-0-000	Lockwasher
24	42-0855-0-000	Pedal
25	32-3037-0-000	Fitting
26	42-0854-0-000	Footrest
27	04-0396-0-000	Screw
28	04-0467-0-000	Nut
29	42-0925-0-000	Safety Pad
30	01-2451-0-000	Screw
31	42-0854-0-000	Shaft
32	32-5011-0-000	Bracket
33	04-1400-0-000	Anchor
34	01-2413-0-000	Screw

◆ Optional on Sitting Model only.

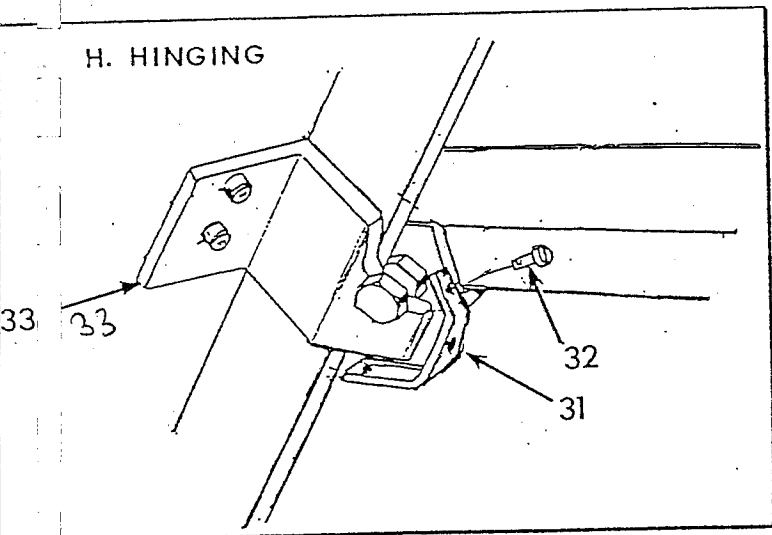


DET	PART NUMBER	DESCRIPTION
01	01-4701-0-000	Washer
02	07-0086-0-001	Stud - Ball
03	07-0087-0-001	Retainer
04	07-0302-1-000	Gas Spring
05	04-0396-0-000	Bolt
06	32-5015-0-000	Bracket
07	04-0467-0-000	Nut



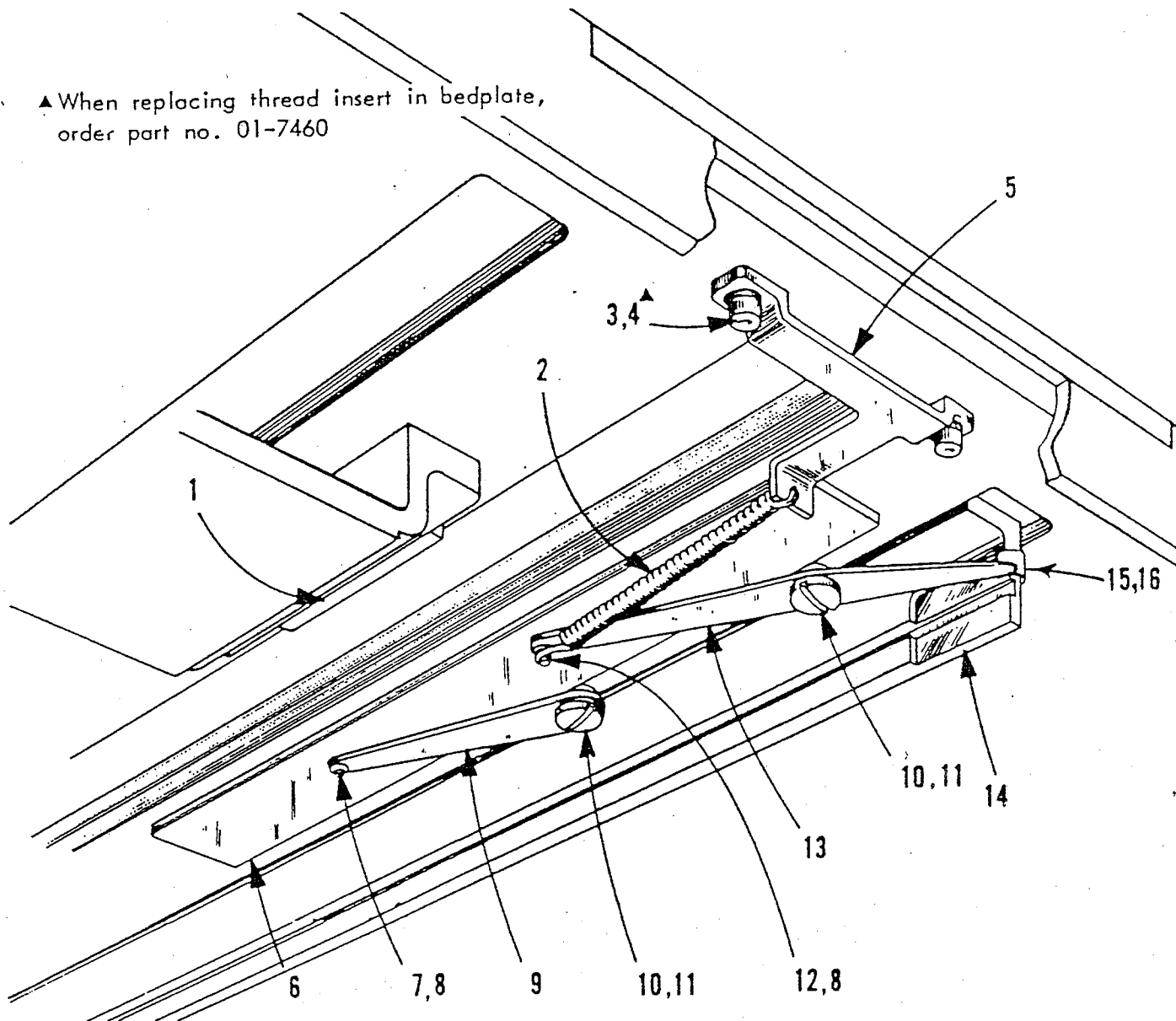
DET	PART NUMBER	DESCRIPTION
01	42-0951-0-000	Knob
02	01-3404-0-000	Nut
03	42-0858-0-000	Rod
04	42-0860-0-000	Connector
05	01-2411-0-000	Screw
06	42-0862-0-000	Bracket
07	42-0866-0-000	Lever
08	01-3415-0-000	Nut
09	01-4063-0-000	Washer
10	01-1470-0-000	Screw
11	42-0867-0-000	Latch
12	01-5507-0-000	Spring
13	01-1472-0-000	Screw
14	04-0443-1-000	Fitting
15	04-0396-0-000	Screw
16	04-0467-0-000	Nut
17	01-3462-0-000	Nut
18	42-0868-0-000	Rod
19	01-5508-0-000	Spring
20	42-0864-0-000	Spacer
21	42-0865-0-000	Clevis
22	01-6652-0-000	Rollpin
23	04-0391-0-000	Fitting
24	01-6655-0-000	Spring Anchor
25	42-0328-0-002	Hinge, left
26	01-1471-0-000	Pivot
27	01-2483-0-000	Screw
28	01-4422-0-000	Lockwasher
29	01-2460-0-000	Screw
30	01-4412-0-000	Washer
31	32-5016-0-000	Wire Bracket
32	01-2410-0-000	Screw
33	42-0328-0-001	Hinge, Right

H. HINGING



SLIDE SAFETY PLATE

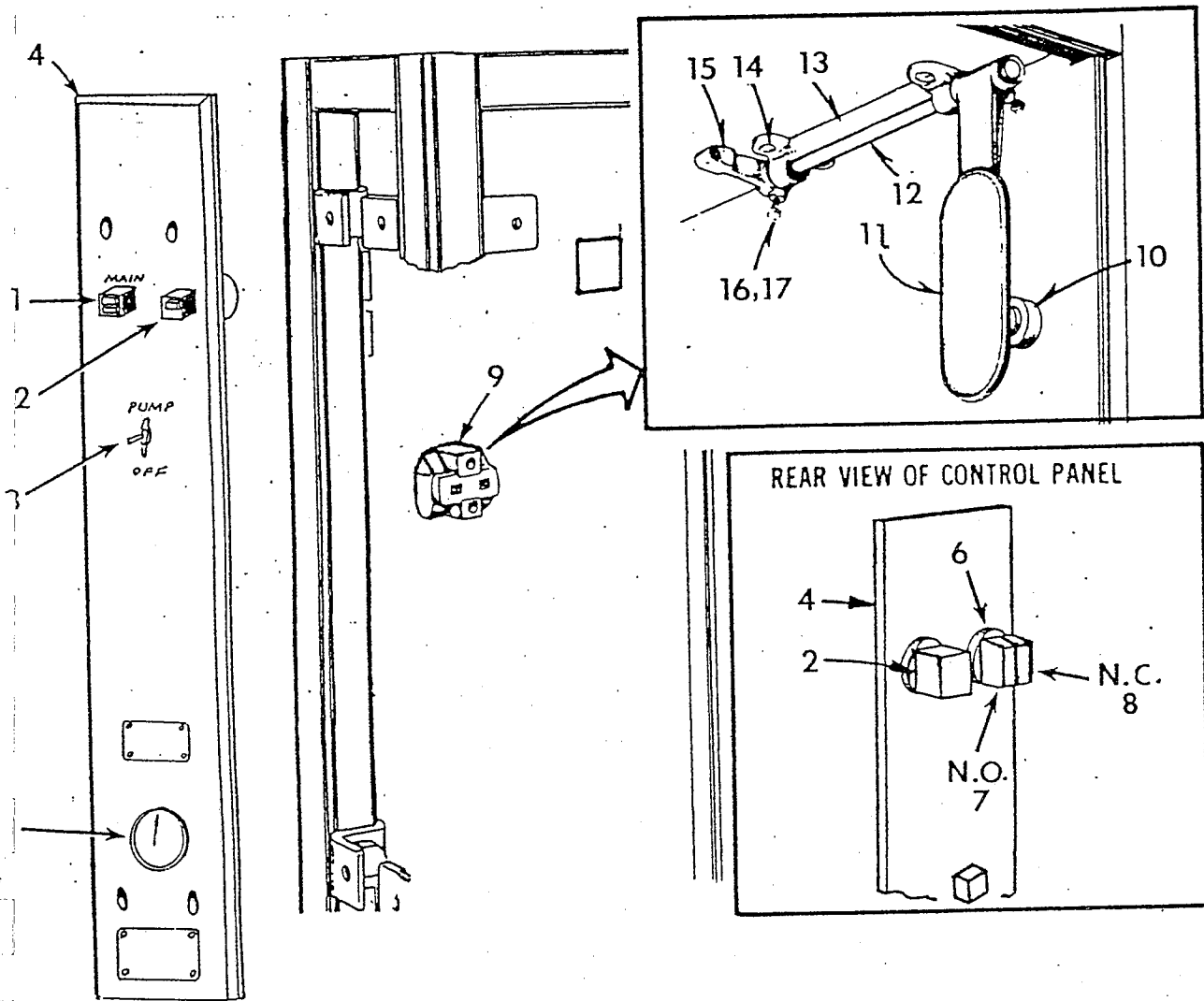
▲When replacing thread insert in bedplate,
order part no. 01-7460



DET	PART NUMBER	DESCRIPTION
01	40-0625-0-000	Pad
02	01-5436-0-000	Spring
03	01-2411-0-000	Screw
04	01-4406-0-000	Lockwasher
05	41-0624-0-000	Bracket
06	41-0621-0-000	Slide Plate
07	01-6539-0-000	Pin
08	01-6368-0-000	Retaining Ring
09	41-0623-0-000	Lever
10	01-2578-0-000	Screw
11	01-7454-0-000	Spacer
12	01-6538-0-000	Pin
13	41-0622-0-000	Lever
14	41-0451-0-001	Bracket, Right
15	01-7456-0-000	Roller
16	01-6565-0-000	Pin

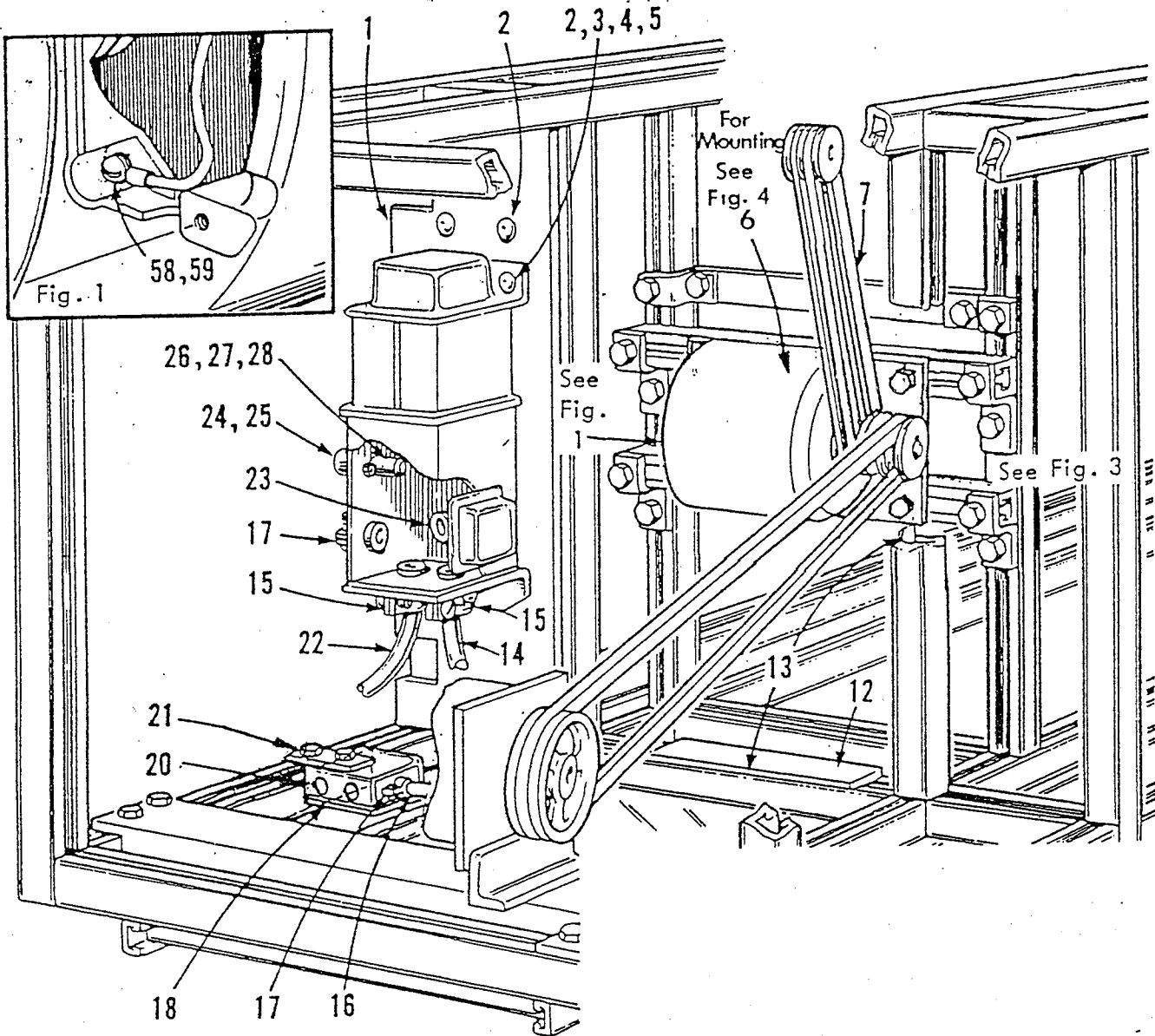
CONTROL PANEL

49



DET	PART NUMBER	DESCRIPTION
01	06-0343-0-000	Switch
02	06-0389-0-000	Light - Pilot
03	06-0215-0-000	Switch
04	32-5020-0-000	Panel - Front
05	07-0013-0-000	Gauge
06	06-0337-0-000	Push Button
07	06-0339-0-000	Contact Block - N.O.
08	06-0341-0-000	Contact Block - N.C.
09	04-1057-0-000	Switch Replacement
10	04-0458-0-000	Knee Switch
11	32-3035-0-000	Lever
12	40-0650-0-000	Shaft
13	32-3038-0-000	Bracket
14	01-2416-0-000	Screw
15	32-3036-0-000	Lever Actuator
16	01-2195-0-000	Screw
17	01-3009-0-000	Nut

ELECTRICAL COMPONENTS



DE	PART NUMBER	DESCRIPTION			
01	32-3012-0-000	Mounting Panel	07	05-0088-0-350	V-Belt, 60hz.
02	01-2793-0-000	Screw		05-0088-0-360	V-Belt, 50hz.
03	01-4400-0-000	Washer			(in pairs only)
04	01-4422-0-000	Lockwasher	12	04-0490-0-112	Cover
05	01-3406-0-000	Nut	13	04-0491-0-000	Fiber Retainer
		MOTORS	14	40-0262-0-118	Motor Harness
06	04-0002-0-016	115-230v. 1ph./60hz.	15	04-0014-0-000	Connector
	04-0002-0-017	208v. 3ph./60hz.	16	42-0262-0-151	Light Receptacle Harness
		190v. 3ph./50hz.	17	04-0143-0-000	Connector
	04-0002-0-023	115-230v. 1ph./50hz.	18	04-0145-0-000	Cover and 2 Receptacles
	04-0002-0-047	208-460v. 3ph./50hz./60hz.		04-1534-0-000	Cover with Receptacle
			20	04-0127-0-000	Junction Box
			21	04-0405-0-000	Bracket
			22	42-0262-1-162	Circuit Breaker Harness
			23	04-1083-0-001	Chase Nipple
			24	30-0763-0-000	Fuse Holder
			25	05-0058-0-000	Fuse, 8 amp.
			26	01-2369-0-000	Screw

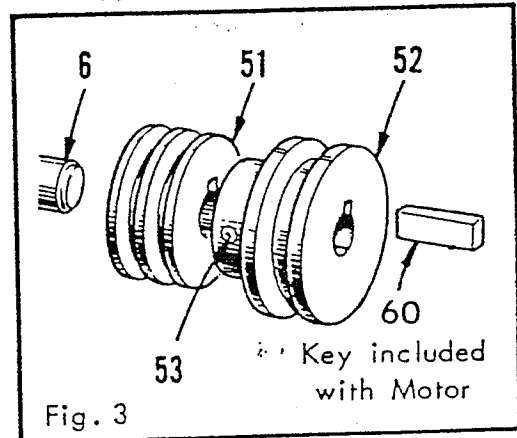
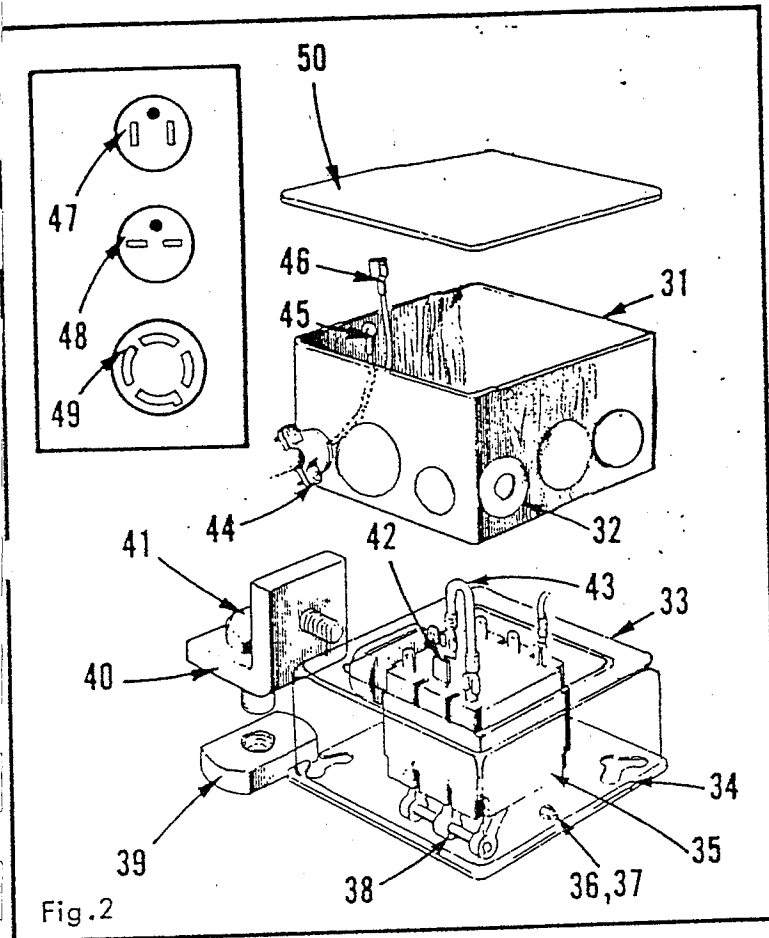


Fig. 3

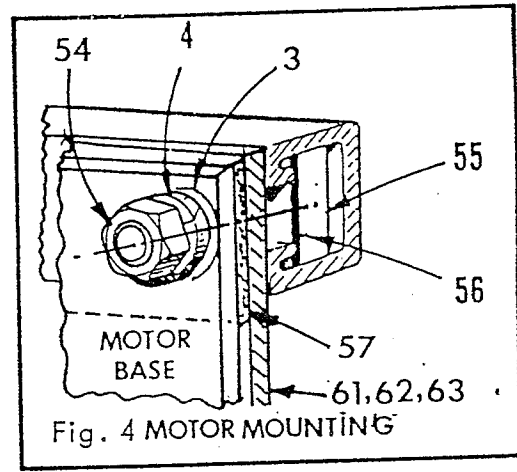
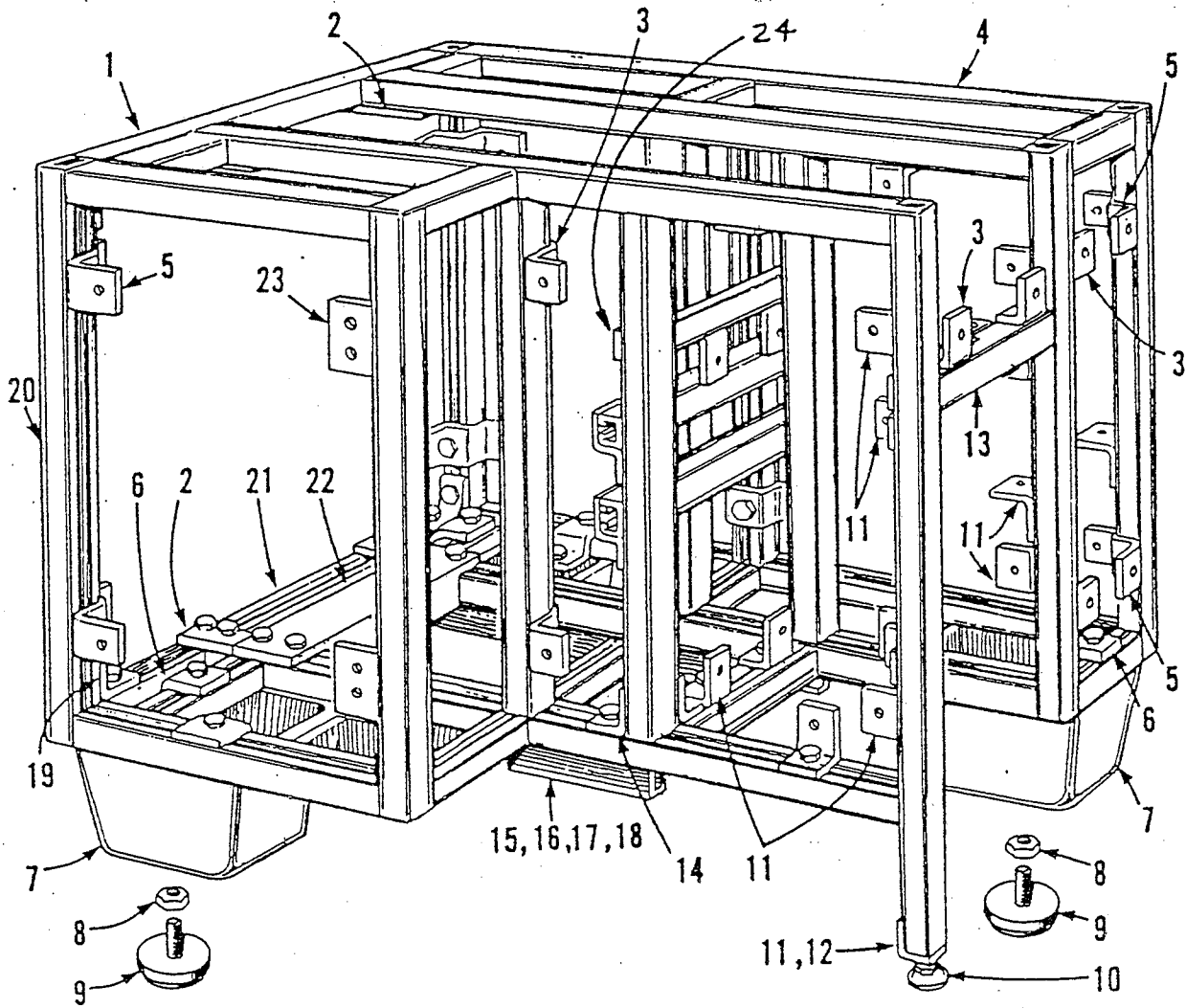


Fig. 4 MOTOR MOUNTING

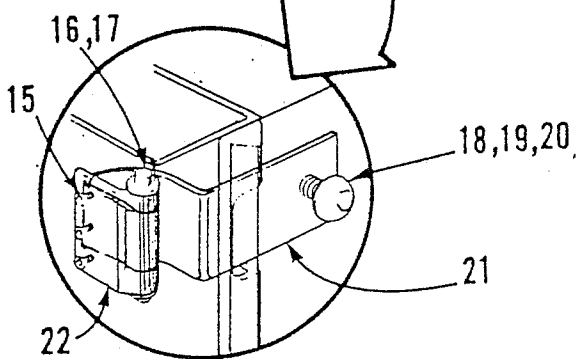
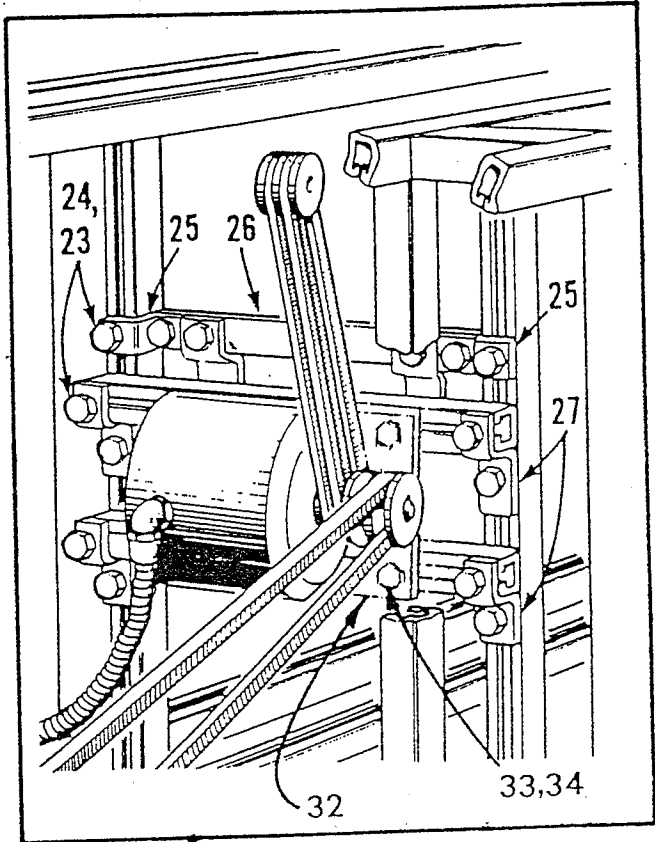
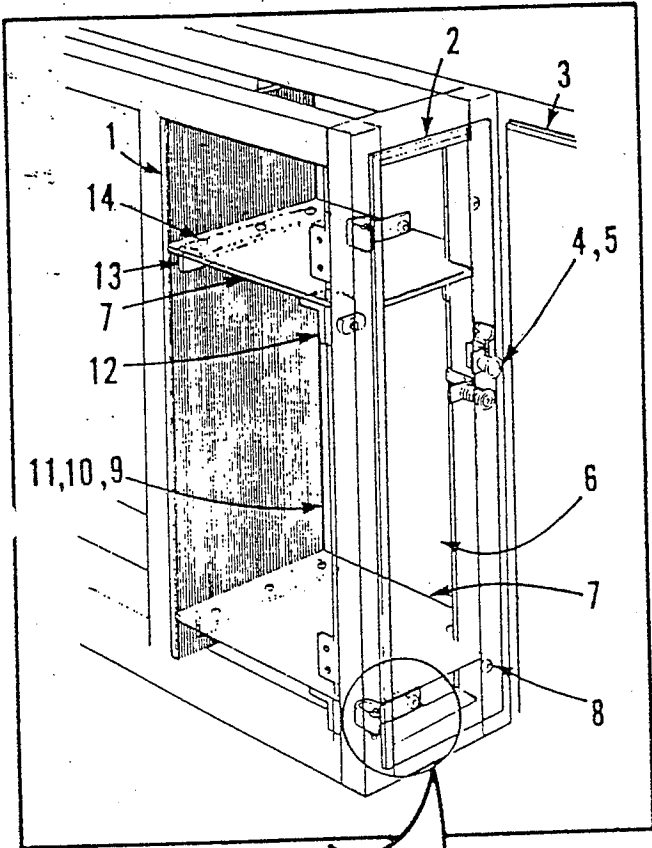
DEL.	PART NUMBER	DESCRIPTION	
27	01-3421-0-000	Nut	
28	30-0364-0-000	Transformer	
31	04-1120-0-000	Junction Box	
32	04-1083-0-001	Snap Bushing	
33	04-1002-0-000	Junction Box	
34	04-1056-0-000	Cover	
35	01-2411-0-000	Screw	
36	01-2803-0-000	Screw	
37	01-3420-0-000	Nut	
38	04-1055-0-000	Switch	
39	04-0467-0-000	Nut	
40	04-0388-0-000	Fitting	
41	04-0396-0-000	Screw	
42	04-1004-0-000	Adaptor (single phase)	
43	42-0262-1-152	Jumper (does not require adaptor 04-1004-0-000)	
	04-0143-0-000	Connector	
	30-0278-0-000	Terminal	
46	04-0258-0-251	Terminal	
47	04-0136-0-000	Cord and Plug 1 ph. 105/125V	
	48	04-0137-0-000	Cord and Plug 1 ph. 125/250V
	49	04-0139-0-001	Cord, 3ph. 230v. (use on Canadian machs. only)
	49	06-0173-0-000	Cord, 3ph. 208/460v.
	50	04-1173-0-000	Cover
	51	42-0352-0-001	Pulley, 60 hz.
		42-0352-0-625	Pulley, 50 hz.
	52	42-0352-0-002	Pulley, 60 hz.
		42-0352-0-626	Pulley, 50 hz.
	53	01-2456-0-000	Set Screw
	54	01-3406-0-000	Nut
	55	04-0442-0-000	Nut Plate
	56	42-0935-0-000	Rubber Strip
	57	42-0934-0-000	Rubber Strip
	58	01-2802-0-000	Screw
	59	01-4571-0-000	Lockwasher
	60	01-8410-0-000	Key
	61	04-1705-0-000	Plate
	62	01-4522-0-000	Washer
	63	01-2836-0-000	Screw





DET	PART NUMBER	DESCRIPTION
01	04-0400-0-000	Channel, Rear Top
02	04-0405-0-000	Plate
03	04-0409-0-000	'Z' Fitting
04	04-0404-0-050	Frame (RH)
05	04-0387-0-000	'W' Fitting
06	04-0408-0-000	'Z' Fitting
07	32-3031-0-000	Foot
08	01-3008-0-000	Washer
09	04-0393-0-000	Foot Pad
10	04-0493-0-000	Guide Foot
11	04-0391-0-000	'L' Fitting
12	01-3406-0-000	Nut
13	04-0401-0-000	Channel, Front
14	04-0386-0-000	'W' Fitting
15	04-0392-0-000	Oil Pan Support
16	01-2768-0-000	Screw, front
17	01-2436-0-000	Screw, rear
18	01-3001-0-000	Nut
19	04-0388-0-000	'L' Fitting
20	04-0390-0-050	Frame (LH)
21	04-0402-0-000	Channel, rear bottom
22	42-0349-1-000	Pump Channel
23	04-1069-0-000	Bracket
24	32-3014-0-000	Channel

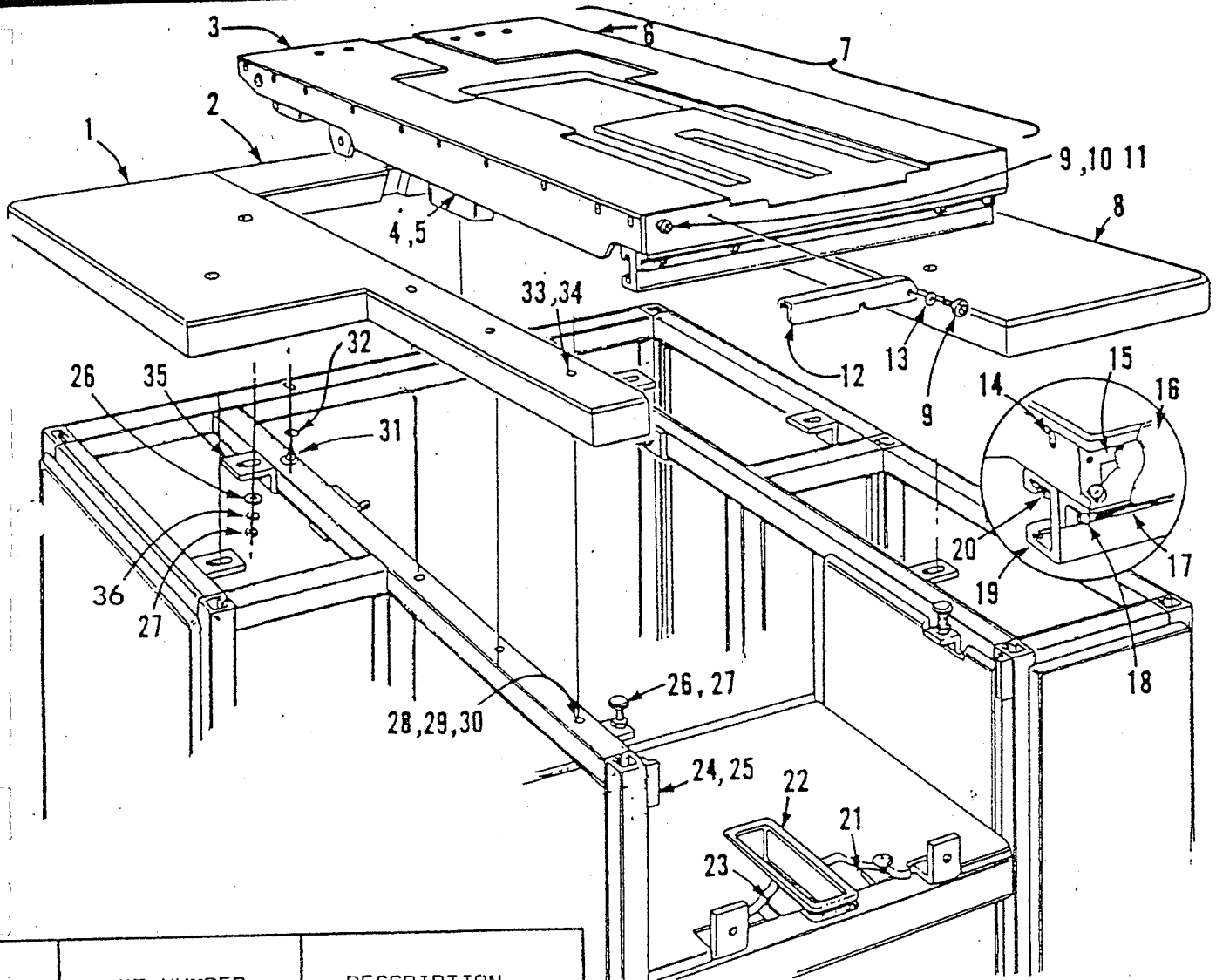
FRAME



DET	PART NUMBER	DESCRIPTION
01	32-3029-0-000	Back Panel (Cut-Out)
02	32-3019-0-001	Door Panel (Cut-Out)
03	32-3020-0-001	Side Panel (Cut-Out)
04	04-1086-0-001	Magnetic Latch
05	01-2582-0-000	Screw
06	32-3023-0-000	Side Panel (Cut-Out)
07	32-3028-0-000	Shelf (Cut-Out)
08	01-2801-0-000	Screw
09	04-0490-0-022	Closure (1-3/8")
10	04-0490-0-176	Closure (11")
11	04-0490-0-007	Closure (7/16")
12	04-0391-0-000	'L' Fitting
13	04-1091-0-000	Shelf Support
14	01-2654-0-000	Screw

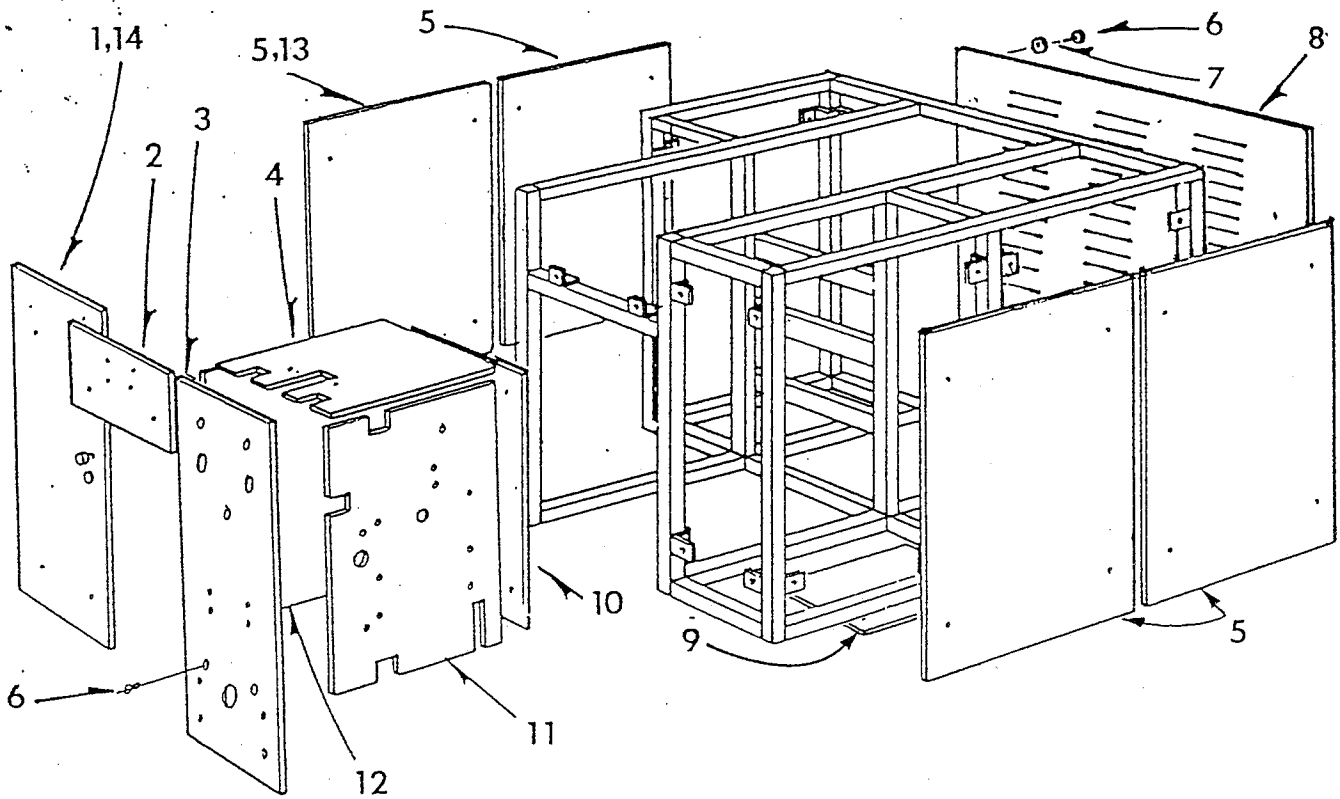
15	01-2461-0-000	Screw
16	01-6678-0-000	Hinge Pin
17	01-6368-0-000	Retaining Ring
18	01-2793-0-000	Screw
19	01-4400-0-000	Washer
20	01-3406-0-000	Nut
21	04-1073-0-000	Hinge Hasp
22	04-1072-0-000	Hinge Mounting Plate
23	04-0396-0-000	Screw
24	04-0467-0-000	Nut Block
25	04-0407-0-000	'Z' Fitting
26	04-0406-0-000	Channel
27	04-0408-0-000	'Z' Fitting
28	04-0424-0-000	Channel
29	32-3009-0-000	Door (Full)
30	32-3043-0-000	Rear Comp. (Full)
31	32-3008-0-000	Shelf (Full)
32	04-1705-0-000	Plate
33	01-2797-0-000	Screw
34	04-0442-0-000	Nut Plate

BEDPLATE & TABLE TOP



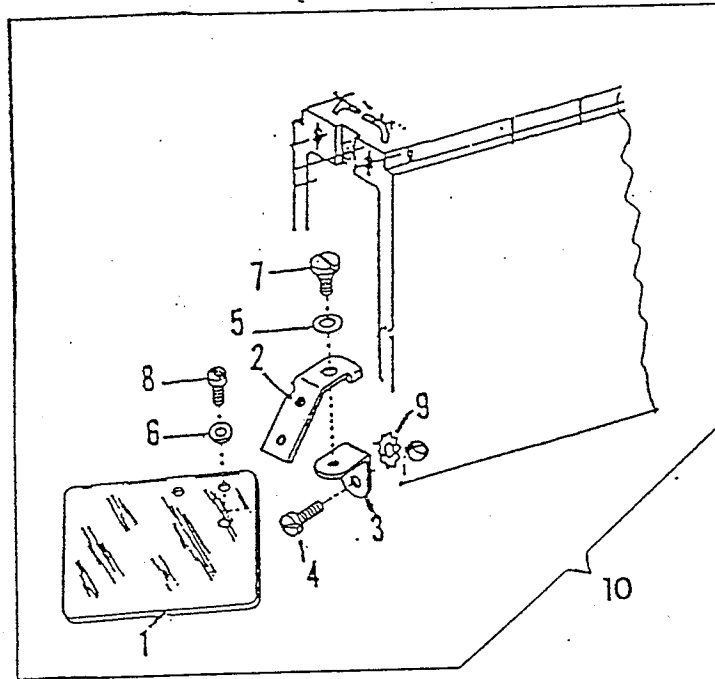
DET	PART NUMBER	DESCRIPTION
C	32-2105-0-000	Table Top (L.H.) (Cut-Out)
	32-2106-0-002	Table Top (L.H.)
02	32-2107-0-000	Table Top, Rear
03	32-2102-0-001	Cover (LH)
04	42-0703-0-000	Side Bar (LH)
05	42-0703-2-001	Side Bar (RH)
06	32-2102-0-002	Cover (RH)
07	32-2100-0-050	Bedplate Asm.
08	32-2106-0-001	Table Top (RH)
09	01-1476-0-000	Screw
10	01-4012-0-000	Washer
11	01-7492-0-000	Bushing
12	42-0813-0-000	Support
13	01-4452-0-000	Washer
14	01-2570-0-000	Screw
15	42-0873-0-000	Front Plate
16	42-0872-0-000	Front Plate Cover
17	42-1038-0-000	Support
18	01-2555-0-000	Screw
19	42-0874-0-000	Cross Bar

20	01-2506-0-000	Screw
21	04-0391-0-000	'L' Fitting
22	42-0554-0-000	Pan
23	40-0640-0-000	Foam Pad
24	04-0451-1-000	'Z' Fitting
25	01-2411-0-000	Screw
26	43-2229-0-000	Button
27	01-3406-0-000	Nut
28	01-2659-0-000	Screw
29	01-3468-0-000	Nut
30	42-0947-0-000	Nut Block
31	01-2536-0-000	Screw
32	01-4559-0-000	Washer
33	04-0055-0-000	Combination Nut
34	04-1062-0-000	Stud 1-3/4"
35	04-0464-0-000	'Z' Fitting
36	01-4422-0-000	Lockwasher



DET	PART NUMBER	DESCRIPTION
01	32-3019-0-001	Door Panel (Cut-Out)
02	32-5028-0-000	Panel
03	32-5020-0-000	Control Panel
04	32-3013-0-000	Panel
05	32-3018-0-001	Panel
06	01-2793-0-000	Screw
07	01-4439-0-000	Washer
08	32-3017-0-000	Back Cover
09	32-3026-0-000	Panel
10	32-3011-0-000	Panel
11	32-3025-0-000	Panel
12	32-3024-0-000	Panel
13	32-3020-0-001	Side Panel (Cut-Out)
14	32-3009-0-000	Door (Full Frame)

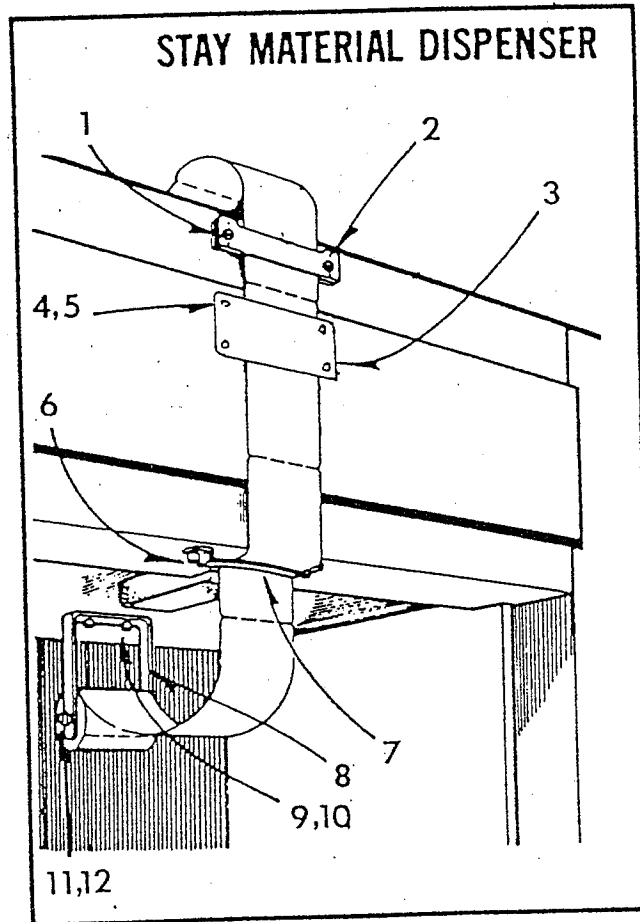
NEEDLE GUARD



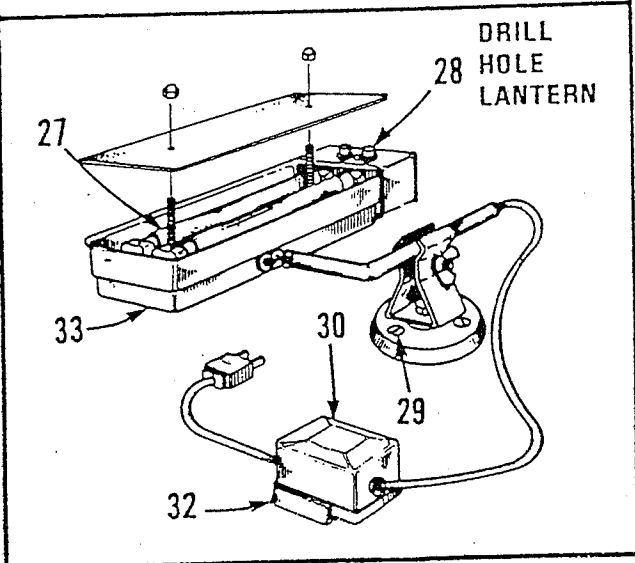
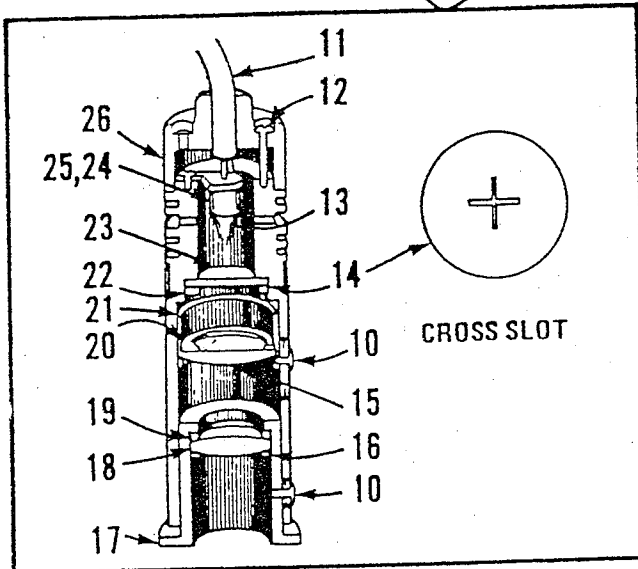
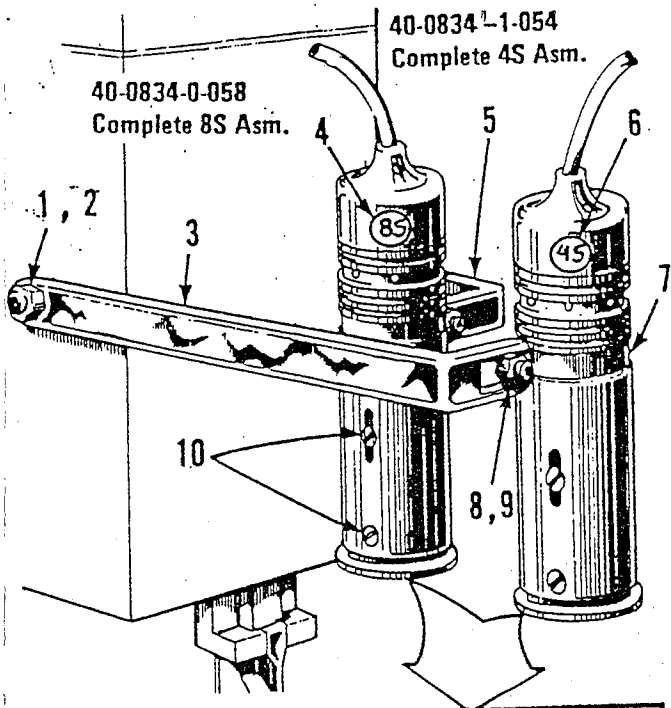
DET	PART NUMBER	DESCRIPTION
01	24-3032-0-000	Eye Guard
02	26-1008-5-143	Eye Guard Support
03	26-1008-5-144	Eye Guard Bracket
04	01-2407-0-000	Screw
05	26-1000-0-010	Spring Washer
06	26-1000-0-532	Washer
07	26-1000-6-004	Screw
08	01-1393-0-001	Screw
09	01-4672-0-002	Star Washer
10	03-5282-0-000	Eye Guard Asm.

Needles for the Reece Series 32 Welting Machine are packaged in boxes of 100, in the sizes and types listed. These needles are of superior struck groove construction, and chromium plated. When ordering, specify quantity and needle part number. The last group in part number indicates needle size.

PART NUMBER	SIZE	CHARACTERISTICS	APPLICATIONS
02-0950-0-100 02-0950-0-110 02-0950-0-111 02-0950-0-112	Very fine (00) Fine (0) Medium (1) Heavy (2)	Sharp point Sharp point (spotted) " "	Standard for the majority of fibers and materials of average weight and texture, including knit goods.
02-0951-0-110 02-0951-0-111	Fine (0) Medium (1)	Sharp point, Ball eye (spotted) "	Applicable to closely woven fabrics or sewing over heavy seams, particularly in cottons. The ball eye produces a hole slightly larger than the needle blade diameter. This results in less needle heat than with needles of uniform diameter.
02-0952-0-100 02-0952-0-110 02-0952-0-111	Very fine (00) Fine (0) Medium (1)	Ball point Ball point (spotted) "	Use on synthetic fabrics, particularly if tightly woven or tightly knitted where the fibers of the material are subject to damage by the conventional sharp pointed needle.
02-0953-0-110 02-0953-0-111	Fine (0) Medium (1)	Sharp point, double groove (spotted) "	Applicable to materials that tend to trap needle thread as it descends into work, thereby disturbing thread take-up or causing thread breakage at needle eye. NOTE: Use double groove needles only when conditions warrant, as loop cast is smaller and may introduce skipping. Set looper points extremely close to needle blade.
02-0955-0-110 02-0955-0-111	Fine (0) Medium (1)	Wedge point, Ball eye (spotted) "	Applicable to leather and similar materials where conventional sharp pointed needles tend to leave excessive punctures. The slit made by the wedge point tends to close after penetration. This needle cuts at right angles to line of stitching, permitting higher stitch density where desirable. The ball eye tends to reduce needle heat.
02-0956-0-110 02-0956-0-111	Fine (0) Medium (1)	Wedge point, ball eye, double groove (spotted) "	Same application as type 955 needles, except double groove is desirable on thick leather and similar materials that tend to close on blade and trap needle thread as it descends into work. Refer to NOTE above on 953 needle application.
02-0958-0-110 02-0958-0-111	Fine (0) Medium (1)	Spear point, ball eye, double groove (spotted) "	Applicable to closely woven or heavily starched fabrics, leather, and similar materials that offer considerable resistance to needle penetration. The ball eye tends to reduce needle heating. Double groove minimizes tendency of material to trap the needle thread during descent into work, but the loopers must be set extremely close to needles to avoid skipping.



DET	PART NUMBER	DESCRIPTION
01	01-3426-0-000	Nut
02	01-2591-0-000	Screw
03	04-1319-0-002	Name Plate
04	01-2592-0-000	Screw
05	01-4411-0-000	Spacer
06	01-2410-0-000	Screw
07	41-0584-0-000	Holder Bar
08	40-0582-0-000	Bracket w/o PL
	42-0582-0-000	Bracket w/PL
09	01-2436-0-000	Screw
10	01-4407-0-000	Washer
11	01-2083-0-000	Screw
12	40-0583-0-000	Roller w/PL
	41-0583-0-000	Roller w/o PL



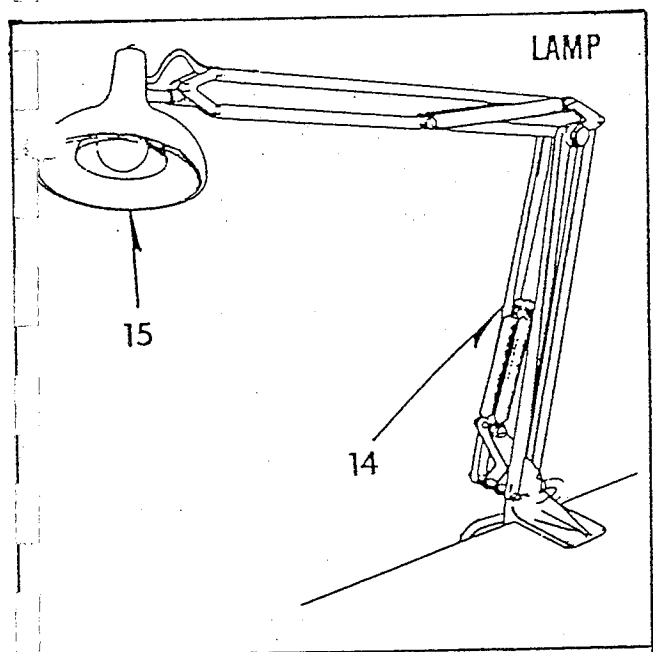
DET	PART NUMBER	DESCRIPTION
01	42-1005-0-000	Stud
02	01-3417-0-000	Nut
03	42-1002-0-002	Arm (Long)
04	05-1085-0-002	Decal (8S)
05	42-1002-0-001	Arm (Short)
06	05-1085-0-001	Decal (4S)
07	40-0791-0-000	Brace
08	01-2531-0-000	Screw
09	01-3401-0-000	Jam Nut
10	01-2481-0-000	Screw
11	40-0478-0-008	Sleaving (18")
12	01-2653-0-000	Screw
13	40-0788-0-000	Lamp (GE#261)
14	40-0834-0-004	Reticle Cross Slot (4S)
	40-0834-0-008	Reticle Cross Slot (8S)
15	40-0786-1-000	Lens
16	01-6628-0-000	Retaining Ring
17	40-0787-0-000	Carrier
18	40-0803-1-000	Lens
19	01-4507-0-000	'O' Ring
20	01-6629-0-000	Retaining Ring
21	40-0785-0-000	Carrier
22	01-6621-0-000	Retaining Ring
23	40-0782-1-000	Glass Disc
24	40-0789-0-050	Lamp Holder
25	01-2518-0-000	Screw
26	40-0781-0-000	End Cap
27	05-0381-0-000	Lamp
28	05-0096-0-000	Switch
29	01-2444-0-000	Screw
30	05-0383-0-110	Ballast
32	01-4411-0-000	Washer
33	05-0450-0-050	Lantern Asm. (complete asm.)

SUPPLIES, TOOLS & ACCESSORIES

DET		DESCRIPTION
01	40-0586	1/4" Spirap
2	40-0594	5/8" Conduit
3	32-1036	3/8" Sponge Rubber
04	07-0294	1/4" Plastic Tubing
5	40-0826	3/8" Plastic Tubing
6	42-0931	Vinyl Tape
07	40-0762-1	Pad, self-adhesive

● Materials are furnished in lengths that are multiples of one foot.

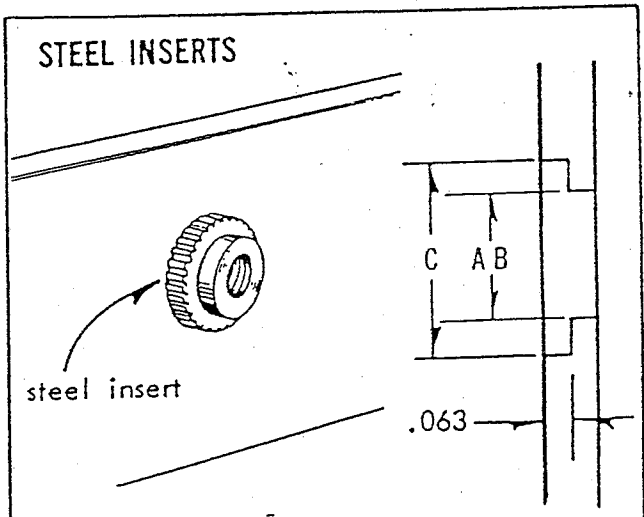
8	03-0022	Oiler
09	05-0090	Lubricating Oil, 8 oz. (Texaco Cepheus "D")
10	05-0091	Rubber Cement, 5 oz.
11	05-0140	Clutch Grease, 4-1/2 oz.
12	05-0192	'Loctite' Cement
13	05-0357-1	Hydraulic Fluid



14	05-0092-1	Luxo-Flair Lamp, com.
15	05-0106	Socket & switch, replacement part

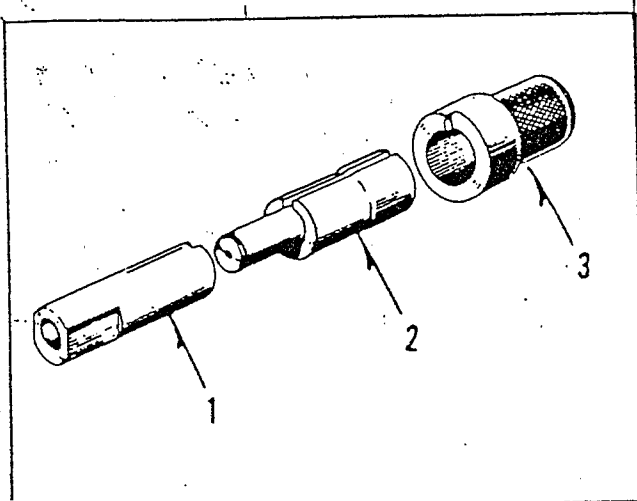
HELI-COIL S		Tap Size	Drill Size	Use Insert Mandrel
16	01-7432	4-40	32	03-0155
17	01-7443	4-40	32	03-0155
18	01-7441	8-32	18	03-0157
19	01-7417	10-24	8	03-0158
20	01-7419	10-24	8	03-0158
21	01-7430	10-24	8	03-0158
22	01-7446	10-24	8	03-0158
23	01-7418	1/4"-20	G	03-0159
24	01-7420	1/4"-20	G	03-0159
25	01-7431	1/4"-20	G	03-0159
26	03-0164	Inserting & Extracting Tool		

▲ Screw locking Heli-Coil

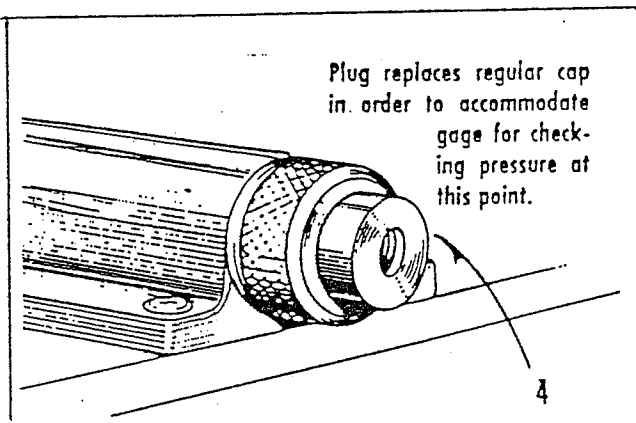


		Tap Size	A Drill Size	B Pilot	C Counter Bore
27	01-7452	10-24	1/4"	1/4"	3/8"
28	01-7461	8-32	1/4"	1/4"	3/8"
29	01-7460	6-32	#7	.200	21/64"
30	01-7459	4-40	#7	.200	21/64"

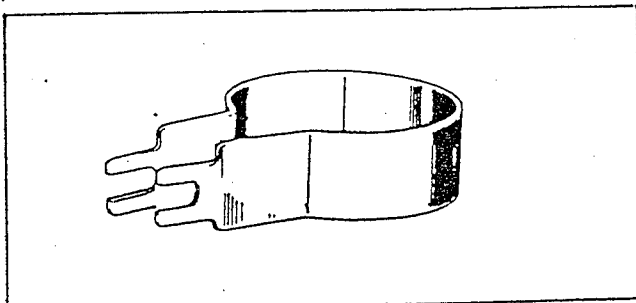
Only those items marked with an asterisk () are supplied initially with each machine. To order a complete set of tools marked with an asterisk (*), specify 03-0173.



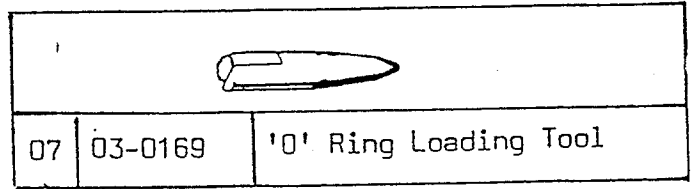
- | | | |
|----|-----------|------------|
| 01 | 03-0091-1 | Sleeve |
| 02 | 03-0092 | Guide Stud |
| 03 | 03-0090 | Collar |



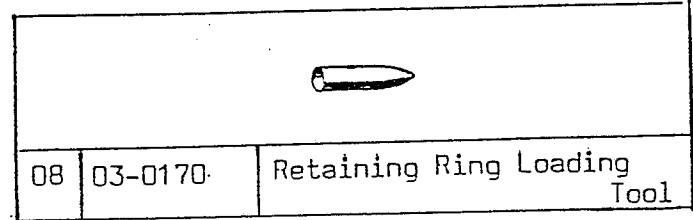
- | | | |
|----|---------|------------------------|
| 04 | 03-0195 | Pressure Gauge Adaptor |
| 05 | 03-0259 | Pressure Gauge |



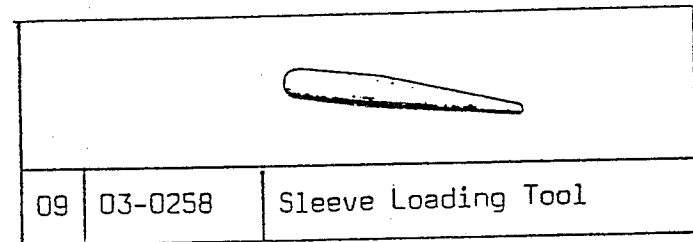
- | | | |
|----|---------|--|
| 06 | 03-0193 | Spring Clip for holding Slide Blocks in pos. |
|----|---------|--|



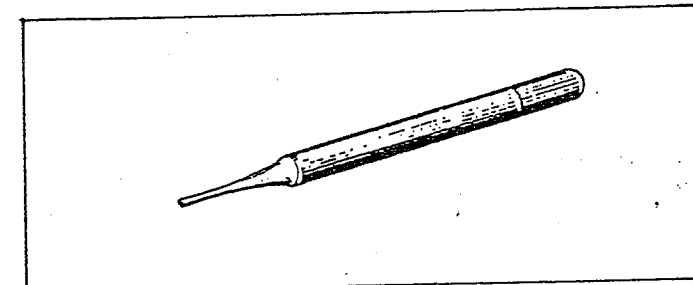
- | | | |
|----|---------|-----------------------|
| 07 | 03-0169 | '0' Ring Loading Tool |
|----|---------|-----------------------|



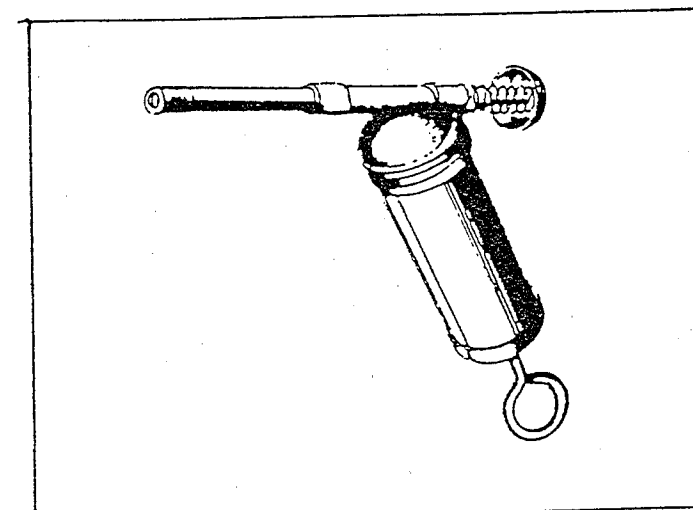
- | | | |
|----|---------|-----------------------------|
| 08 | 03-0170 | Retaining Ring Loading Tool |
|----|---------|-----------------------------|



- | | | |
|----|---------|---------------------|
| 09 | 03-0258 | Sleeve Loading Tool |
|----|---------|---------------------|



- | | | |
|----|---------|---------------------|
| 10 | 03-0079 | 1/8" Rollpin Punch |
| 11 | 03-0081 | 3/16" Rollpin Punch |

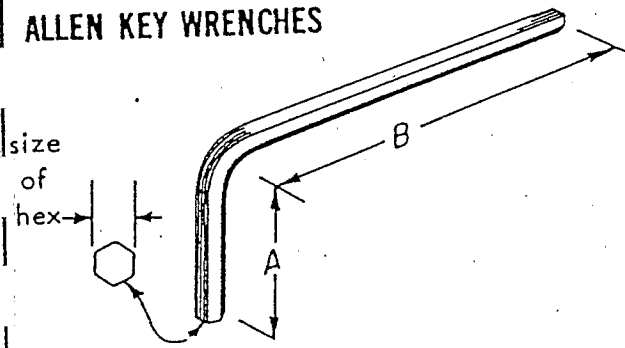


- | | | |
|----|---------|------------|
| 12 | 03-0085 | Grease Gun |
|----|---------|------------|

Only those items marked with an asterisk () are supplied initially with each machine. To order a complete set of tools marked with an asterisk (*), specify 03-0173.

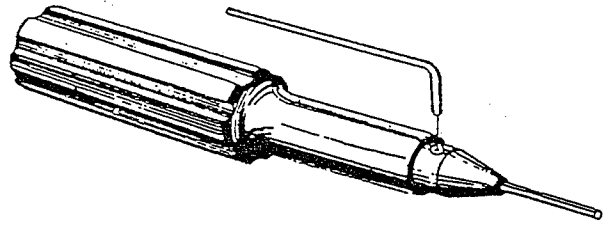
SUPPLIES, TOOLS & ACCESSORIES

ALLEN KEY WRENCHES



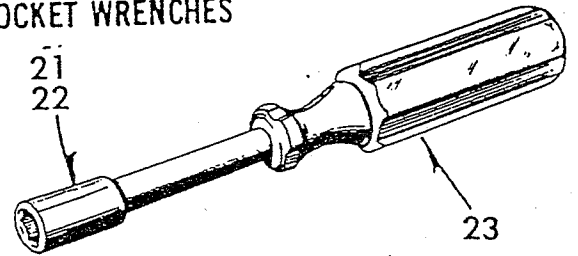
		SIZE OF HEX	A	B
01	03-0054*	3/32"	21/32"	2"
02	03-0055*	1/2"	9/16"	1-3/4"
03	03-0056*	1/16"	9/16"	1-3/4"
04	03-0057	5/64"	3/8"	1-7/8"
05	03-0059*	1/8"	1/2"	2-1/4"
06	03-0061*	5/32"	27/32"	2-1/2"
07	03-0063*	3/16"	15/16"	2-3/4"
08	03-0065	7/32"	1-1/32"	3"
09	03-0066	5/16"	1-1/4"	3-3/4"
10	03-0067	3/8"	1-3/8"	4-1/4"
11	03-0162	5/64"	5/8"	1-7/8"
12	03-0176	3/32"	3/8"	2"
13	03-0177	7/64"	45/64"	2-1/8"
14	03-0180	9/64"	51/64"	2-3/8"
15	03-0181	9/64"	1/2"	2-3/8"
16	03-0183	1/4"	1-1/8"	3-1/4"

HANDI-SET ALLEN KEY WRENCHES



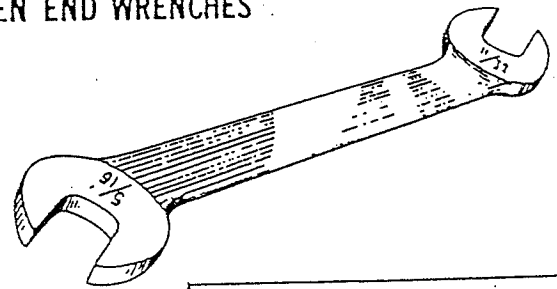
17	03-0105	5/64" Wrench, complete
18	03-0161	3/32" Wrench, complete
19	03-0175	.050" Wrench, complete
20	03-0179	7/64" Wrench, complete

SOCKET WRENCHES



21	03-0097	3/8" Socket
22	03-0133	1/4" Socket
23	03-0096	Socket Drive Handle

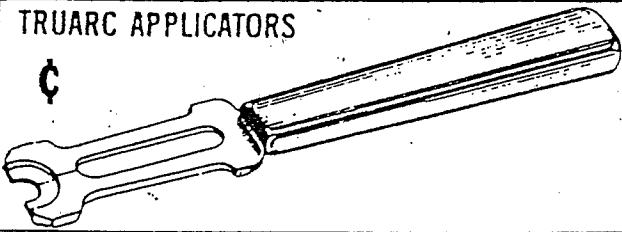
OPEN END WRENCHES



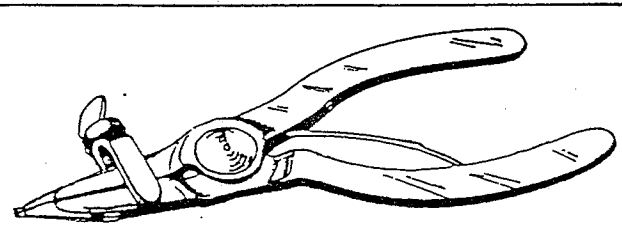
		Size of Openings
24	03-0019	1/4" & 1/4" (boxed)
25	03-0068	5/16" & 11/32"
26	03-0072	9/16" & 5/8"
27	03-0086	11/16" & 3/4"
28	03-0106	5/16" & 3/8"
29	03-0107	7/16" & 1/2"

Only those items marked with an asterisk () are supplied initially with each machine. To order a complete set of tools marked with an asterisk (*), specify 03-0173.

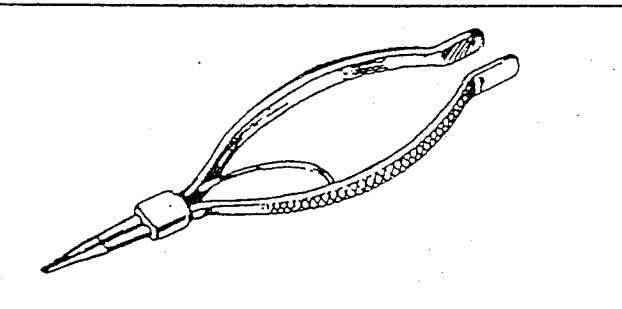
TRUARC APPLICATORS



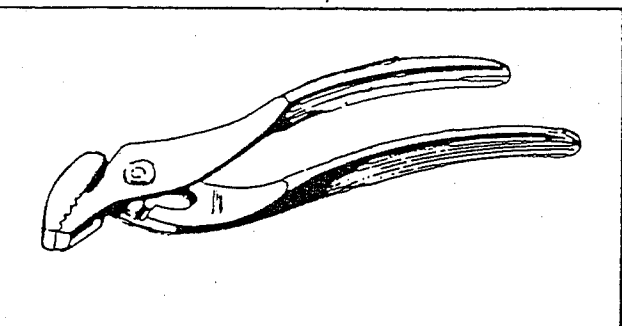
01	03-0139	Use for 5/16" Truarc
02	03-0140	Use for 1/4" Truarc
03	03-0141	Use for 3/16" Truarc
04	03-0142	Use for 5/32" Truarc
05	03-0143	Use for 1/8" Truarc
06	03-0144	Use for 3/32" Truarc
07	03-0163	Use for 3/16" Truarc (Heavy Duty)



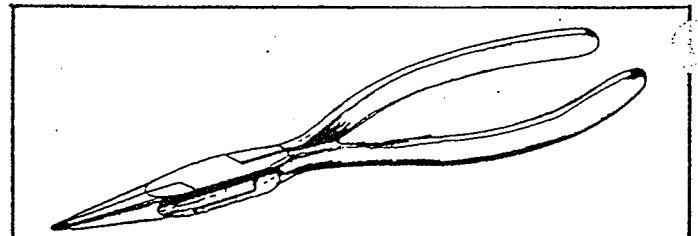
08	03-0074	Truarc Pliers
09	03-0263	Truarc Pliers (Offset)



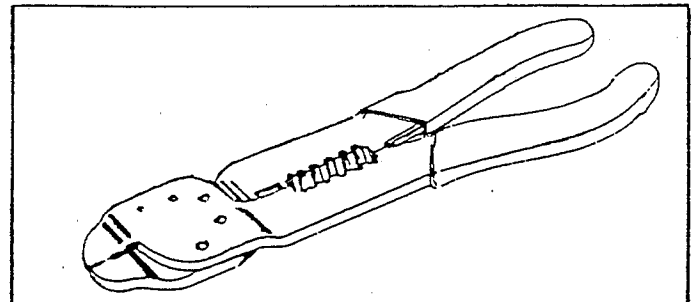
10	03-0071	Truarc Pliers
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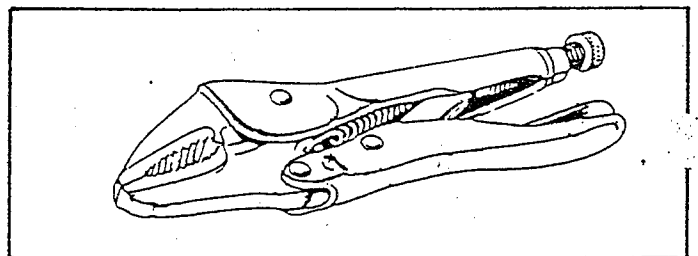
11	03-0123	Ignition Pliers
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12	03-0137	Long Nose Pliers
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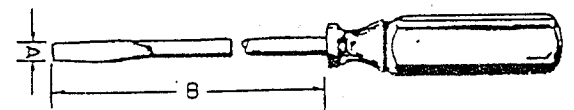


13	03-0148	Crimping & Stripping Pliers
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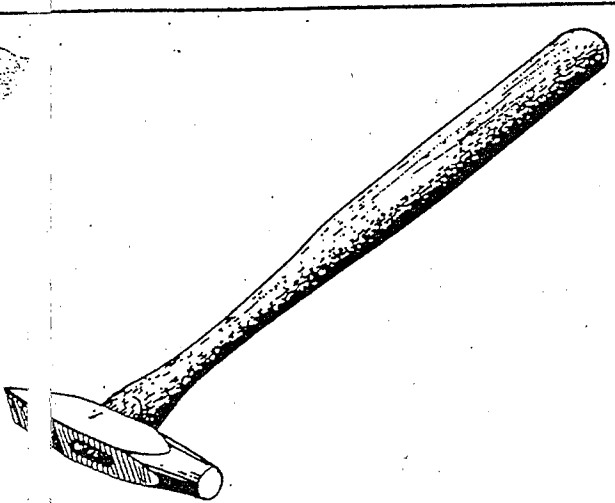
14	03-0149	Vise Grip Wrench
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SCREWDRIVERS

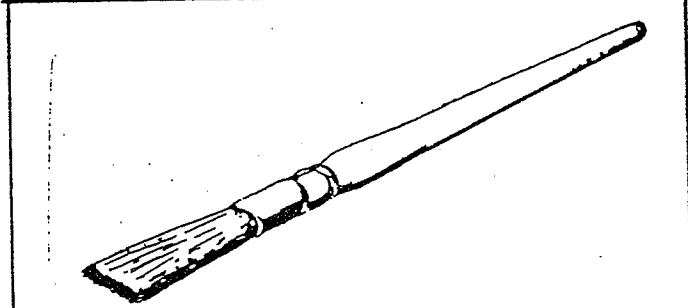


		A	B
15	03-0076*	1/8"	3"
16	03-0190	3/16"	6"
17	03-0083	3/16"	10"
18	03-0187	5/16"	8"
19	03-0117	1/4"	2-1/4"
20	03-0174	(with Screw Holding Feature)	3/16"
		(with Screw Holding Feature)	6"

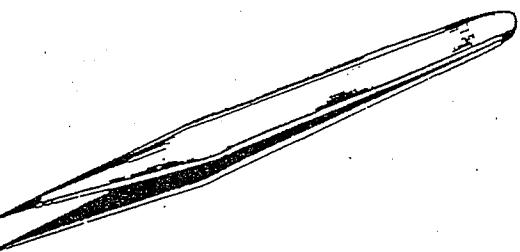
Only those items marked with an asterisk () are supplied initially with each machine. To order a complete set of tools marked with an asterisk (*), specify 03-0173.



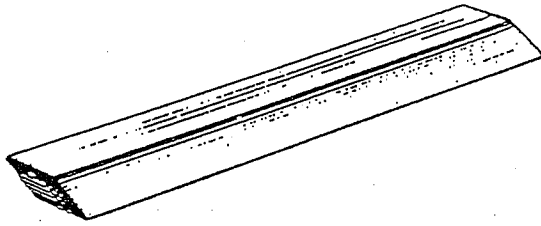
01	03-0121	7 oz. Rivet Hammer
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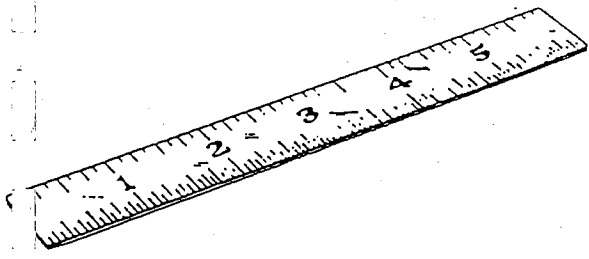
04	03-0147	Looper Brush
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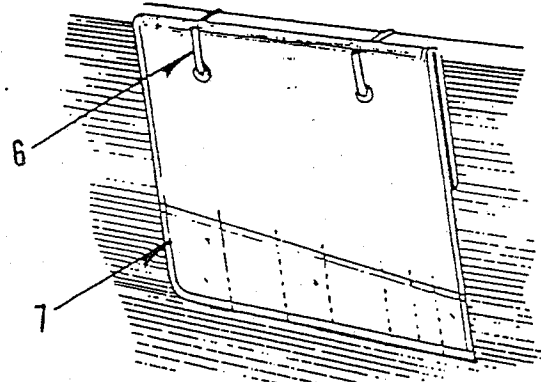
C	03-0013	Tweezers
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05	03-0115	4" Fine India Stone
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C	03-0109	6" Scale
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06	05-0104	Holder (2)
07	05-0103	Tool Pouch

Only those items marked with an asterisk () are supplied initially with each machine. To order a complete set of tools marked with an asterisk (*), specify 03-0173.

MICROPROCESSOR
CONTROLLED
POCKET WELT
MACHINE

- 1-2 AGENDA

- 3 INTRODUCTION

- 4 COMPONENT FUNCTION-CONTROL CONSOLE

- 5 COMPONENT FUNCTION-MACHINE

- 6 CONTROL CONSOLE-LAYOUT/FRONT PANEL-LAYOUT

- 7-9 CONTROL CABINET-LAYOUT

- 10 SEQUENCE CHART

- 11 SET UP AND ADJUSTMENTS

- 12 TROUBLESHOOTING-STATUS CONDITIONS

- 13-14 TROUBLESHOOTING-TEST PROCEDURES

The 32/100 POCKET WELT machine is an upgrade of the SERIES 32 machine. The controls have been changed from a single relay logic p.c. board to a microprocessor control board. Because of this, the performance of the 32/100 is greatly improved over the series 32.

Improvements found on the 32/100:

- * Sew Interrupt routine that allows repairs to be made simply
- * Three methods of entering the sew interrupt routine
- * Proximity sensors in place of mechanical switches
- * Test routine for set up and troubleshooting
- * Status Error displays
- * Improved thread pick ups

The 32/100 uses proximity sensors to sense the various table positions, foot pedal positions, and limit positions of moving mechanical parts. These signals are monitored by the computer and gives the proper response accordingly.

LOADING SWITCH-Select mode of operation.

TABLE FORWARD/BACK SWITCH-Sends table to the rear or sends table to the front.

CENTERKNIFE UP/AUTO/DOWN SWITCH-Up will send the knife up and hold there until auto is selected. Auto is for normal operation. Down will hold the knife down.

TABKNIFE UP/AUTO/SEMI-Up will send the tabknives up manually. Auto is for normal operation. Semi is for sending the tabknives up with the knee switch.

SEW INTERRUPT/SERVICE SWITCH-Sew interrupt interrupts sew cycle during sewing.

*Release with second pressing -
P.L.*

THUMBWHEEL SWITCHES-Air #1 and air #2 delay setting for patch loader model. Test operation numbers for test mode.

RESET SWITCH-Resets computer. / *To home position.*

DISPLAY-Displays error codes and test numbers.

CONTROL PANEL

MAIN SWITCH/Start/Stop

STOP SWITCH/Start/Stop

KNIFE SWITCH : To manually activate sewing, only Man Front or Man Back, manually activate tab knives when in the semi position, for Sew Interrupt.

TOGGLE : TEST : Is used for testing switches, solenoids and proximity switches.
OPERATE : normal position to run machine.

TABLE SWITCH : Back Pos - Clamp table moves to the Back Pos.
:FWD Pos - Clamp table moves to the Front Pos.

CENTER KNIFE :Up Pos - Center Knife will immediately fire up and remain up used for servicing.
:Auto Pos - Knife will fire up only during sewing.
:Down Pos - Knife will stay inoperative.

TAB KNIVES :Up Pos - Tab Knives will stay up at the end of a sewing cycle.
:Auto Pos - Tab Knives will rise and retract at the end of a sewing cycle.
:Semi Pos - Tab Knives will rise when Knee Switch is pressed.

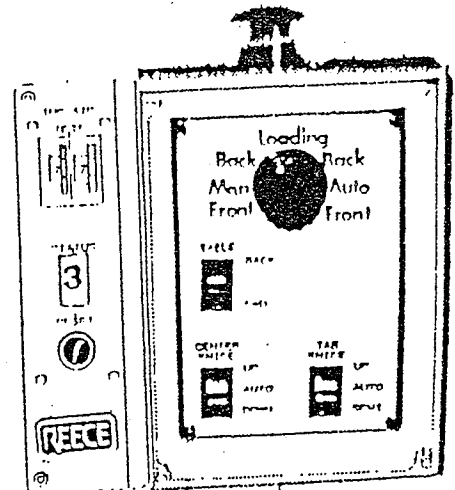
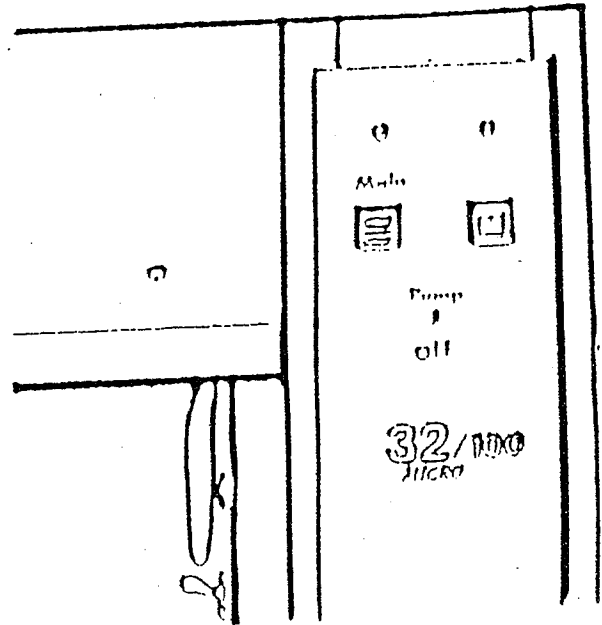
LOADING :Used when loading material in Back Pos. : also for manual operation of clamping, patch folding and sewing Manually Back.
:Used when loading material in the Front Pos. : also for manual operation of clamping, patch folding and sewing Manually Front.
:Used in this position for Automatic Front Loading.
:Used in this position for Automatic Back Loading.

THUMP REFL :Used for testing input/output functions and air option time delay settings.

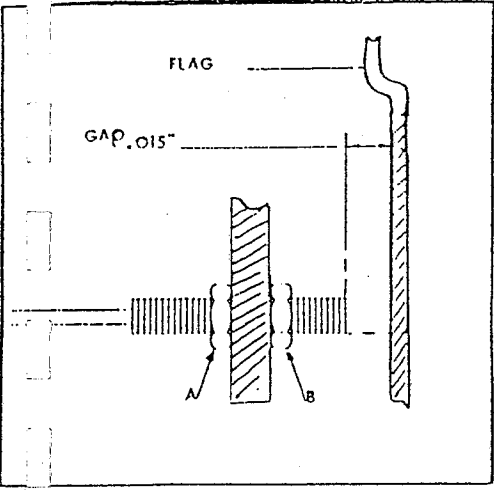
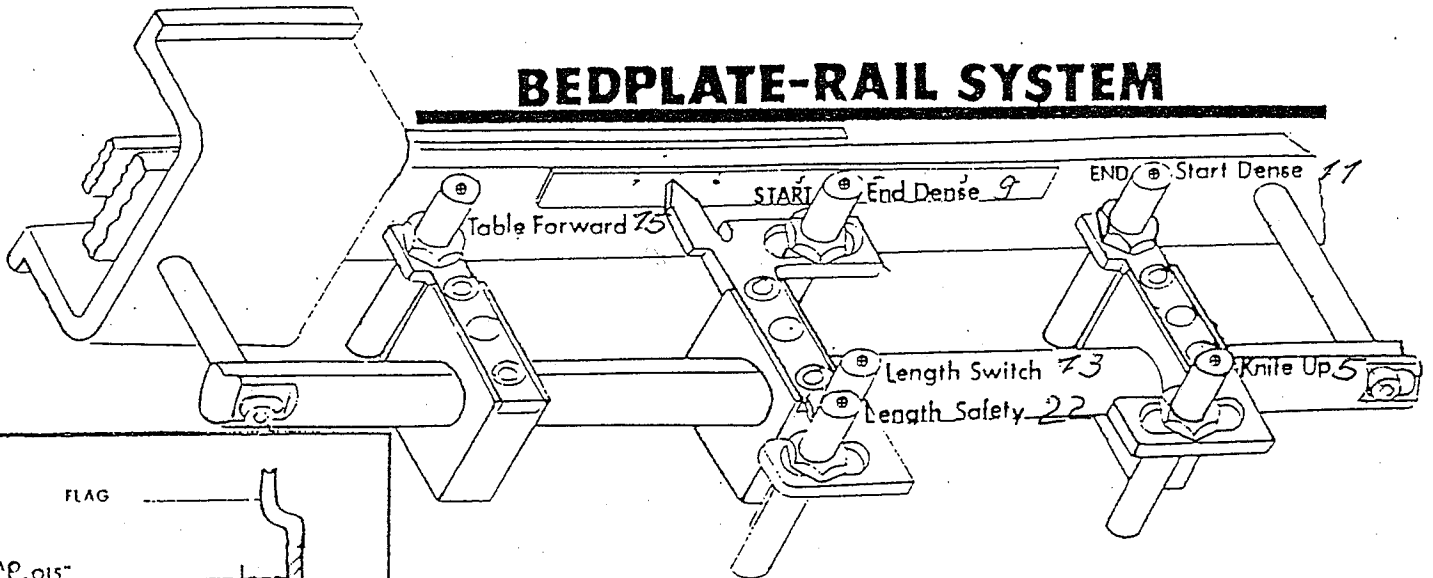
STATUS :Used in testing switches and also shows when an error has occurred.

RESET :Used to clear the MicroProcessor when an error has occurred.

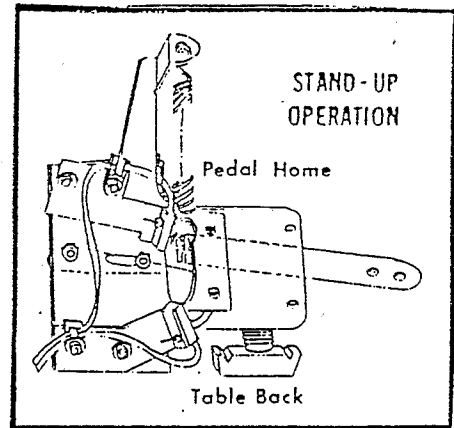
SEW INTERRUPT :Pressing this button causes the machine to lock up, and table will travel forward through a sewing cycle. When this has been done, the machine will automatically go into a repair mode. To cancel this, PRESS table switch to FWD and reset. Also, by pressing this switch when you raise the clamps and patch guide at the same time, they will stay in the up position. Again, if you press the treadle halfway to raise the patch guide, it will stay up. This is a means of servicing the machine, the center knife and removing the throat plate.



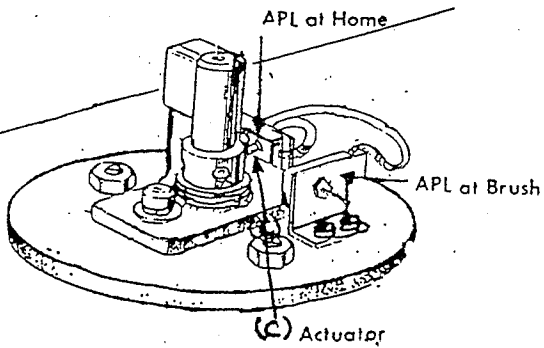
BEDPLATE-RAIL SYSTEM



PEDAL



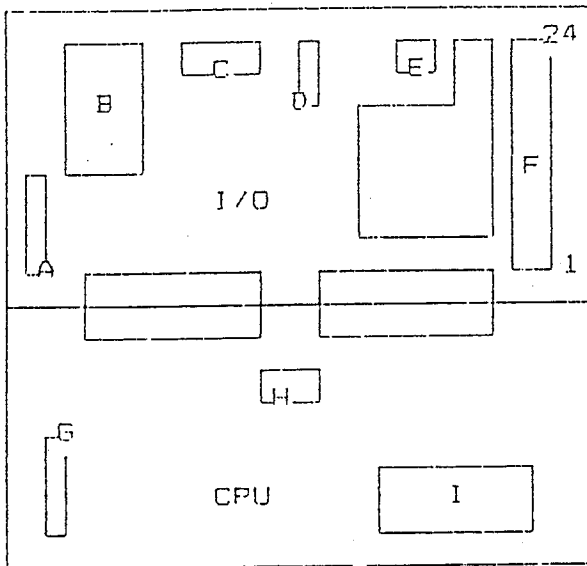
APL



- Control Voltage 5
- Motor Control - 24 VAC
- Motor power - Line.

Motor overload protection

32/100 I/O, CPU CARDS



- A CONTROL CONS. SWITCH INPUTS
- B PROX. SENS. INPUTS
- C OPTION SWITCHES
- D TEST/OPERATE SWITCH
- E LENGTH SAFETY PROX.
- F AC OUTPUT CONNECTOR
- G THUMBWHEEL INPUT
- H 5V D.C. I/O, CPU
- I EPROM

PROXIMITY SENSOR INPUTS (B)

- | | |
|---------------------|-------------------|
| P4 APL AT BRUSH | P5 CENTERKNIFE UP |
| P6 APL AT HOME | P7 KNEE SWITCH |
| P8 PEDAL TABLE BACK | P9 END DENSE |
| P10 PEDAL HOME | P11 START DENSE |
| P12 BRUSHES CLOSED | P13 LENGTH SWITCH |
| P14 TABKNIVES DOWN | P15 TABLE FORWARD |
| P16 TABKNIVES UP | P17 SPARE |
| P18 TIMING | P19 SPARE |
| P20 SPARE | P21 SPARE |
| P22 LENGTH SAFETY | |

AC OUTPUTS (F)

- | | | |
|-----------|-------------------|---------------|
| 1 SPARE | 11 CLAMP FINGERS | 21 TABLE DIR. |
| 2 SPARE | 12 APL MOTOR | 22 START SEW |
| 3 SPARE | 13 STOP TRAVEL | 23 STOP SEW |
| 4 SPARE | 14 CENTERKNIFE UP | 24 GND |
| 5 GND | 15 TABKNIVES | |
| 6 GND | 16 THREAD PICK UP | |
| 7 SPARE | 17 CLAMPS | |
| 8 SPARE | 18 PATCH FOLDER | |
| 9 AIR #2 | 19 END DENSE | |
| 10 AIR #1 | 20 CENTER DENSE | |

32/100 SEQUENCE CHART-MANUAL BACK OPERATION

TABLE POSITION

	1	2	3	4	5	6	7	8	9	10
TABLE DIR. BACK			*****							
CLAMPS		*****	*****							
PATCH FOLDER	*****	*****	*****							
STOP TRAVEL					*	*	*	*****		
START SEW					*****	*****	*****	*****		
END DENSE					*****		*****			
CENTER DENSE					*****	*****	*****	*****		
CENTERKNIFE						*****				
STOP SEW								*		
THREAD PICK UP									*	
TABKNIVES										*

POSITION:

- 1 TABLE FORWARD (TABLE FORWARD PROX.)
- 2 1ST POS.PEDAL (PEDAL NOT HOME)
- 3 2ND POS.PEDAL (PEDAL TABLE BACK PROX.)
- 4 TABLE BACK (BRUSHES CLOSED PROX.)
(RELEASE FOOT PEDAL, CLAMP DOWN, PATCH FOLDERS CLOSE)
- 5 START SEW (KNEE SWITCH)
- 6 0 POS.TABLE (START DENSE PROX.)
- 7 1ST POS.TABLE (CENTERKNIFE UP PROX.)
- 8 2ND POS.TABLE (END DENSE PROX.)
- 9 3RD POS.TABLE (LENGTH PROX.)
- 10 TABLE FORWARD (TABLE FORWARD PROX.)

DISPLAY STATUS STEADY ERROR NUMBERS

- Timed function in table back.
- Table took too long to go back.
- Something obstructing bedplate.
- ~~Press reset~~, table will return forward.

- Machine in repair mode.
- Thread monitors detected thread break.
- When operator presses knee switch or stop saw button on console, machine automatically goes into repair mode.
- To exit, press table forward switch to FWD position.

- Timed function in table forward.
- Table took too long to come forward.
- If pump is switched off 3 will appear.
- Switch pump off and check problem.
- ~~Press reset~~.

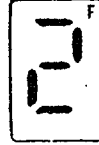
- Auto Patch Loader not installed.
- Rotary switch must be in manual back or manual front.
- Dip switch #1 on I/O Board is switched *off*

- Timed function brushes not closed after loading patch and pelon brushes did not close completely. This will only appear when knee switch is pressed.
- Depress pedal to remove patch and pelon and replace. Check proximity switch at back of head. - *Press Reset or resume cycle.*

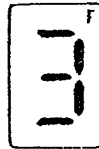
- Stop saw switch closed.
- Stop saw switch was pushed down.
- Push down to release.

DISPLAY STATUS FLASHING ERROR NUMBERS REQUIRE RESET

SHOT off m/c, l.l.



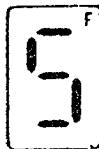
- Tab knives not fully down / *operator*
- Obstruction in cam plate guides.
- Proximity switch gap too large.



- Mach was switched from Auto to Manual. A.P.I. models only.



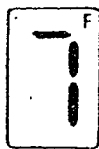
- Table not forward.
- Tab knives will not come up.



- Tab knives took too long to go down. Check tab knife assembly.



- Tab knives took too long to go up.
- Check tab knives. Null.
- Bad center cut.



- Machine did not stop in the proper position.
- Actuator for timing moved on shaft.



- Auto Patch loader took too long to go in. Check for obstruction to the A.P.I. arm.

TEST MICRO-PROCESSOR FUNCTIONS AND SWITCHES

TO START TEST, SET RUN/TEST TOGGLE SWITCH IN TEST MODE
WITH PUMP OFF; PRESS RESET BUTTON

<u>SWITCHES</u>	<u>THUMBWHEEL (DISPLAY)</u> <u>NUMBERS</u>		<u>COMMENTS</u>
APL OPTION (ON/OFF)	01	(0)(1)	DIP SWITCH LOCATED ON BOARD
APL HOME POSITION	02	(1)	SWITCH IN APL ARM
APL BRUSHES CLOSED	03	(0)	SWITCH IN APL ARM
PEDAL HOME POSITION	04	(1)	SWITCH IN FOOT PEDAL
PEDAL TABLE BACK	05	(0)	SWITCH IN FOOT PEDAL
TABLE FORWARD CONSOLE	06	(0)(1)	TABLE SWITCH (PUSH DOWN)
TABLE BACK CONSOLE	07	(0)(1)	TABLE SWITCH (PUSH UP)
KNEE SWITCH	08	(0)(1)	PRESS KNEE SWITCH
TAB KNIFE DOWN	09	(1)	SWITCH MONITORING TAB KNIFE DOWN
TAB KNIFE UP	10	(0)	SWITCH MONITORING TAB KNIFE UP
TABLE FORWARD	11	(0)	SWITCH MONITORING TABLE FORWARD
BRUSHES CLOSED	12	(1)	SWITCH IN REAR OF HEAD/SAFETY SEW
AIR EJECT (OPTION)	13	(0)(1)	DIP SWITCH LOCATED ON BOARD
POSITION -0	14	(0)	SWITCH SENSING START CENTER DENSITY
POSITION -2	15	(0)	SWITCH SENSING END OF CENTER DENSE
POSITION -3	16	(0)	SWITCH SENSING END OF SEWING
POSITION -1	17	(0)	SWITCH SENSING CENTER KNIFE UP
TIMING SWITCH	18	(1)	STOP MOTION LOCKED UP/TIMING SWITCH
TAB KNIFE UP CONSOLE	19	(0)(1)	TAB KNIFE SWITCH (PUSH UP)
TAB KNIFE SEMI CONSOLE	20	(0)(1)	TAB KNIFE SWITCH (PUSH DOWN)
LOADING AUTO FRONT	21	(0)(1)	AUTO FRONT SWITCH ON CONSOLE
LOADING MANUAL FRONT	22	(0)(1)	MANUAL FRONT SWITCH ON CONSOLE
LOADING MANUAL BACK	23	(0)(1)	MANUAL BACK SWITCH ON CONSOLE
LOADING AUTO BACK	24	(0)(1)	AUTO BACK SWITCH ON CONSOLE
STOP SEW BUTTON CONSOLE	25	(0)(1)	SWITCH ON TOP OF CONSOLE (PRESS DOWN)
SEQUENCE OF SWITCHES ON RAIL	30		THIS TEST WILL DISPLAY SWITCHES IN SEQUENCE; MANUALLY PULLING TABLE FORWARD ACTIVATES SWITCHES.
		()	HOME POSITION (NO DISPLAY)
		(0)	POS-0 START CENTER DENSE
		(1)	POS-1 CENTER KNIFE UP
		(2)	POS-2 START/FINISH END DENSE / CENTER KNIFE DOWN
		(3)	POS-3. END OF SEWING

NOTE: THESE TESTS DO NOT DISPLAY ANY NUMBERS ON READOUT DISPLAY

THE SOLENOIDS ARE ACTIVATED BY THE TABLE SWITCH. PUSHING UP WILL ACTIVATE EACH SOLENOID BY TURNING TO THE RESPECTIVE THUMBWHEEL NUMBER.

<u>SWITCHES</u>	<u>THUMBWHEEL NUMBERS</u>	<u>COMMENTS</u>
CLAMPS	41	CLAMP SOLENOID
APL FINGERS	42	APL TRAY FINGERS SOLENOID
PATCH FOLDING	43	PATCH FOLDING SOLENOID
TAB KNIVES	44	TAB KNIVES SOLENOID
END DENSITY	45	END DENSITY SOLENOID
CENTER DENSITY	46	CENTER DENSITY SOLENOID
TABLE CYLINDER DRIVE	47	TABLE SOLENOID
START SEM	48	START SEM SOLENOID
STOP SEM	49	STOP SEM SOLENOID (PUSH UP HAMMER AND ACTIVATE TABLE SWITCH)
FIRST AIR EJECT	50	AIR SOLENOID #1 (RIGHT SIDE)
SECOND AIR EJECT	51	AIR SOLENOID #2 (LEFT SIDE)
CENTER KNIFE UP	52	CENTER KNIFE SOLENOID
TABLE STOP	53	TABLE STOP SOLENOID (ON CLAMP MANIFOLD)
THREAD PICKUPS	54	THREAD PICKUP SOLENOID (ON TOP OF HEAD)

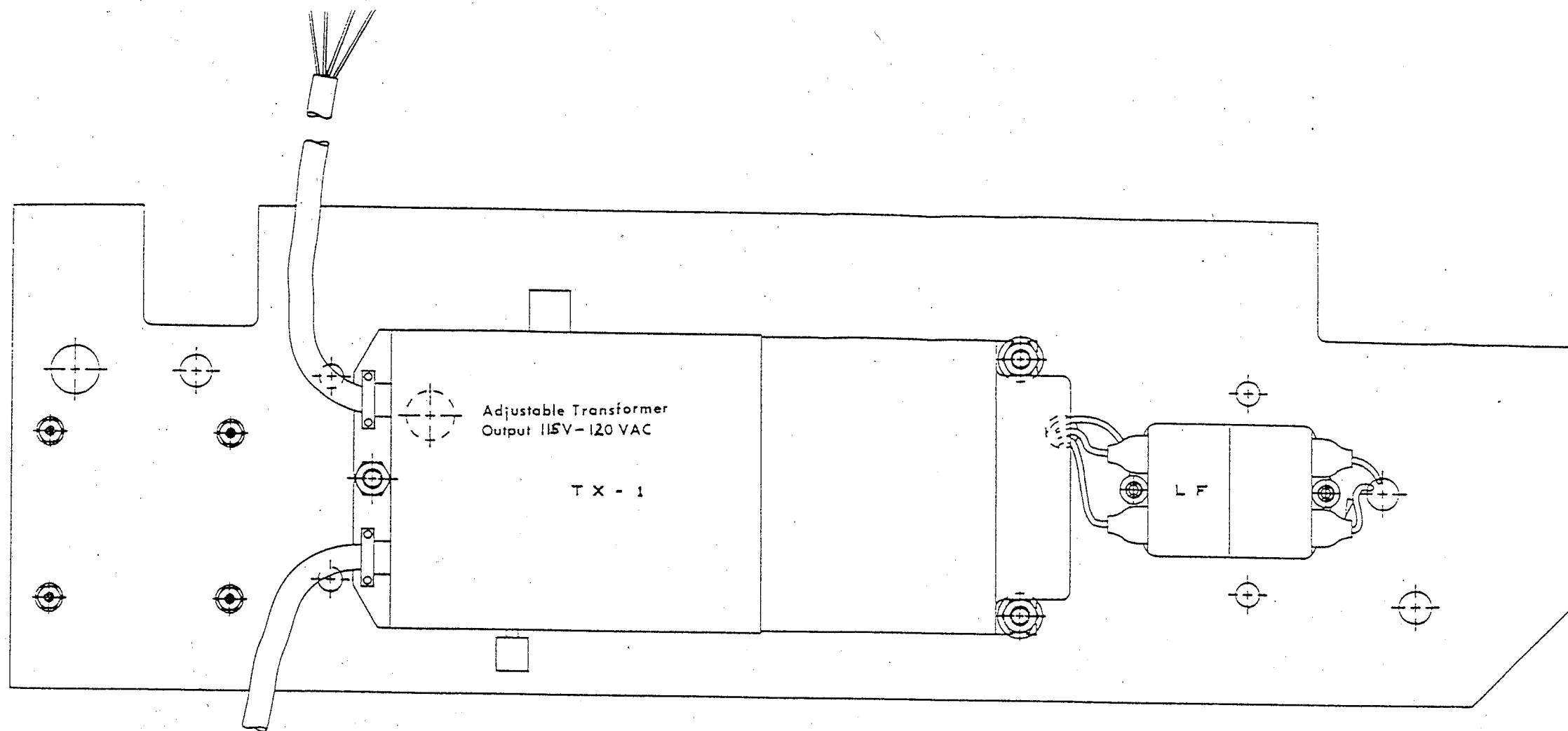
THUMBWHEEL TEST

ENTER 99 ON THUMBWHEEL, PUSH THE TABLE SWITCH TO BACK AND THEN RELEASE. THE DIGITS ON THE THUMBWHEEL WILL BE DISPLAYED SEQUENTIALLY, HIGHEST DIGIT FIRST, TURNING THUMBWHEEL TO EACH NUMBER TO CHECK. TO EXIT THIS TEST, RE-ENTER 99, PUSH THE TABLE SWITCH BACK AND THEN RELEASE.

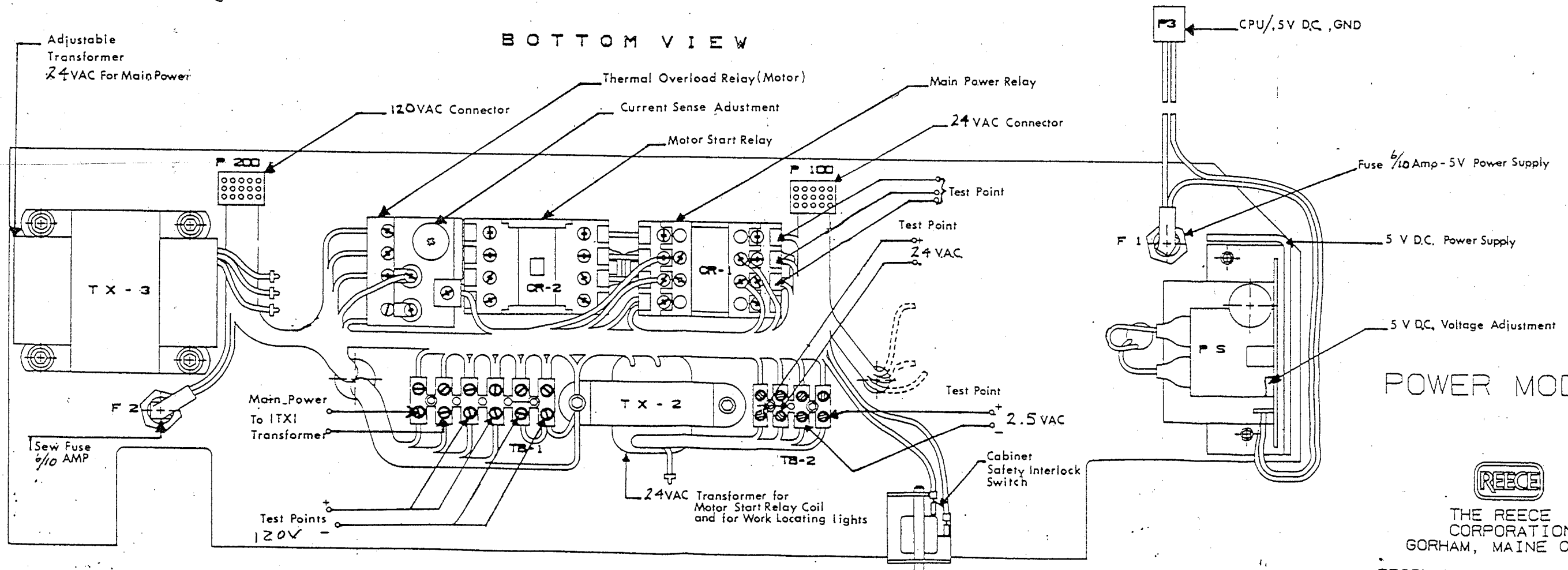
ON APL MACHINES, THE FINAL TEST WILL BE WITH THE PUMP ON.

SET THUMBWHEEL TO 72 AND TURN PUMP ON; PRESS FOOT PEDAL TO SEND TABLE BACK; AT THIS POINT, CLAMPS WILL REMAIN DOWN, BUT PATCH GUIDE WILL RAISE. WITH THE TABLE SWITCH, PUSHING UP WILL ACTIVATE THE APL ARM AND WILL STOP WHEN SWITCH IS RELEASED. TO END APL TEST, PRESS TABLE SWITCH DOWN; THIS WILL TERMINATE THE TEST. TURN RUN/TEST MODE SWITCH BACK TO RUN POSITION, AND PRESS RESET BUTTON.

NOTE: IN THE TEST MODE, WHEN THE AUTO PATCH LOADER IS ACTIVATED, A "1" WILL BE DISPLAYED WHEN THE HOME SWITCH IS CLOSED; A "2" WILL BE DISPLAYED WHEN THE PATCH LOADER REACHES THE BRUSHES CLOSED SWITCH; WHEN NEITHER SWITCH IS ACTIVATED, THE DISPLAY IS BLANK.



BOTTOM VIEW



TOP VIEW

POWER MODULE



THE REECE CORPORATION
GORHAM, MAINE 04038

PRODUCT ENGINEERING DEPT.

10-30-90

DRAWN: PHILLIPS