AMF® REECE

Better Ideas, Better Made

MODEL AUTOJIG

84-72 MJ

PARTS AND SERVICE MANUAL

PART NUMBER 97.8472.1.000

11/2024

LIMITED WARRANTY ON NEW AMF REECE - CARS 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 - Cars for inspection. If, upon inspection, the part or material is determined to be defective, AMF Reece - Cars 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 - Cars.

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 - Cars 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 - Cars 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 - Cars 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 - Cars. In the event that a warranty matter is not handled to your satisfaction, please contact AMF Reece - Cars office:

Prostejov, Czech Republic
Phone: (+420) 725-088-560
E-mail: info@amfreece-cars.cz

Warranty Registration Card

((Please E-mail immediately after installation)

Note: All Warranty Claims void, unless Registration Card on file at AMF Reece - Cars HQ

Machine model number:
(Deco 3000, S-4000, S-4002, EBS Mark II, etc.)

Manufacturer‘s serial or production number:

Installation Site Information:

Customer‘s Name:

Customer‘s Mailing Address:

Customer‘s Telephone Number:

Supervising Mechanic‘s or Technician‘s Name:

Signature of Supervising Technician:

AMF Reece - Cars Technician‘s Name:

AMF Reece - Cars Technician‘s Signature:

Type of garment produced at this location?

Average Daily Production Expected from this machine?
(number of buttonholes, jackets sewn, pants produced, buttons sewn, etc)

Any special requirements required at this location?

What other AMF Reece Machines are at this location?

How can we serve you better?

SERVICE MANUAL

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SAFETY FIRST
A CAREFUL WORKER IS THE BEST SAFETY DEVICE

SAFETY INSTRUCTIONS

- The machine must only be used for the purpose it was designed for. In case of conversion into another version all valid safety instructions have to be considered.
- Do not operate this machine without the safety devices it is equipped with.

DANGER

All guards must be in position before starting.

- The machine must only be switched on and operated by persons who have been instructed accordingly.

Do not operate this equipment unless technically qualified.

Unauthorized person not to use this machine.

- When exchanging parts end when doing maintenance work the machine must be disconnected either by actuating the master switch or by removing the mains plug.

This machine must not be dismounted or cleaned unless it has been switched off and unplugged.

CAUTION
Risk of electric shock.

- When threading machine Emergency Stop must be engaged or the machine switched off.

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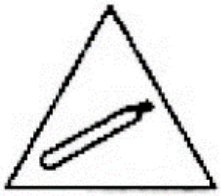
1 – INTRODUCTION

SAFETY FIRST
A CAREFUL WORKER IS THE BEST SAFETY DEVICE

SAFETY INSTRUCTIONS

- When carrying out maintenance or repair work on pneumatic devices the machine must be disconnected from the pneumatic supply source.



CAUTION
Compressed air

- Work on electrical equipment on this machine must only be carried out by electricians or other persons who have been instructed accordingly.

Do not maintain this equipment
unless technically qualified.

- The actual ‘A’ weighted sound pressure level taken on an identical machine is 75.5 DB (A).
- Take appropriate measures for protection of hearing if sound pressure of 85 DB (A) is exceeded.

- Ensure lifting rail is used when lifting with fork lift truck.

1 – INTRODUCTION

IMPORTANT NOTES

- To avoid trouble or damage it is absolutely necessary to observe the following instructions:
- Before you put the machine into operation for the first time clean it thoroughly, remove all dust which has accumulated on it.
- Oil all necessary parts ensuring drive wheel section is free from any type of lubricant.
- Check to make sure line voltage agrees with the voltage indicated on the machine label. If it does not, be sure not to plug in the machine.
- The balance wheel should always rotate towards you (when standing at the front of the machine). If it does not, alter the direction of the motor. Refer to Efka manual section, motor direction setup.
- Check you have the correct pneumatic line pressure.
- Always make sure the correct program is selected on the AMF Reece controller related to the type of jig being used.

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1 – INTRODUCTION

QUICK REFERENCE SPECIFICATION SHEET

ELECTRICAL REQ:	220V @60Hz, single phase, 600W 240V @50Hz, single phase, 600W
AIR SUPPLY:	Pressure - 80 p.si (5.5 Bar) Consumption - 0.40 c.f.m (12 L/Min)
NOISE LEVEL:	75.5 DB (A)
SEWING HEAD:	Lockstitch with underbed trimmer
SEWING HEAD MOTOR:	AB221A
SEWING HEAD SPEED:	2600 SPM (at max)
STITCH SIZE:	0.5 mm - 3.5 mm (max varies with material)
LUBRICATION SYSTEM:	Sump Reservoir, Wick and Pump Distribution System. Jig Track - Silicon Spray
NEEDLE TYPE:	134 R
RECOMMENDED THREAD:	Core spun polyester/cotton
SEWING AREA:	175 × 175 mm
TABLE HEIGHT:	930 mm (36.5”)
OPERATOR POSITION:	Standing

2 – USING JIGS

2.1 Loading of Material into the Jig (e.g. Collar)

a. Open jig and position lower ply of cloth to the jig location marks.

b. If the jig has a fulling bar (i.e. middle section) close this on to the lower ply of cloth.

c. Position the upper ply of cloth to jig location marks.

d. Close the top plate of the jig.

e. Jig is now ready to insert into machine.

2.2 Loading Jig to the Machine

a. Slide the loaded jig with the right hand on the top plate, towards the needle, lining up the start position approximately 1/2" (13 mm) behind the needle.

NOTE: When the jig is loaded, do not lift up from the table.

b. Push the jig to the right and over the raised flap in front of the needle plate.

c. As the jig is pushed to the right, the jig flap will drop to its normal position.

d. If the jig is located correctly, the raised ´D´ shape of the needle plate will locate in the track of the jig.

e. Pull jig back to closed track. (Double jig should be pulled back so jig contacts presser foot).

f. When the jig is loaded correctly to the machine, press the green start button located on the table top; and the automatic cycle will begin.

g. At the end of the cycle the jig will be ejected (or in the case of a double jig, wait to be pulled forward to its start position).

NOTE:
The machine has an AMF Reece controller that is programmed to perform different functions, depending on the type of jig being used.

2.3 Program Selection

The different programs are achieved by selecting programs 1 - 6 on the machine control panel.

a) Single pocket Flap - select program 1

b) Double Pocket Flap - select program 2

c) Collar Jig - requiring needle down both corners - select program 3

d) Collar Jig - slow sew round collar - select program 4

e) Single Breasted Jacket - select program 5

f) Double Breasted Jacket - select program 6

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3 – OPERATING INSTRUCTIONS

3.1 To Start up the Machine

a) Turn the green switch on the right hand front panel of the machine, to switch on the air supply to the machine.
b) Press black button on starter box.

NOTE: The presser foot of the machine is always in the raised position when the machine is in the 'Stop' mode with the air and power switched on.

Carry out the following steps of procedure after the power switch has been turned OFF.

3.2 Installation of Needle

Insert the needle to the needle bar to the full with its longer groove to the left, and firmly fasten by using the needle clamp screw (Figure 3.1).

Applicable needle: 134

NOTE: Needle size and needle point are dependent on the type of material being used. (Refer to needle and thread section 3.13).

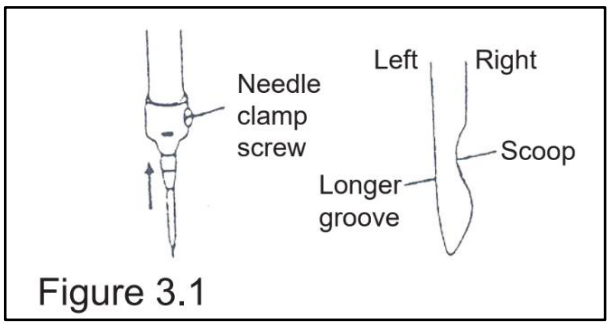

Figure 3.1

a. Using a screwdriver, loosen the needle set screw on the left hand side of the needle bar.
b. Insert the needle and push it up as far as it will go (make sure the long groove faces towards the left).
c. Tighten needle set screw securely.

3.3 Threading of Upper Thread

Turn the handwheel toward you to make the thread take-up reach the highest position, and run a thread from the spool pin to the needle through each part in such an order as numbered in Figure 3.2. At the needle, run the thread from left to right and leave the thread end for approx. 5 cm.

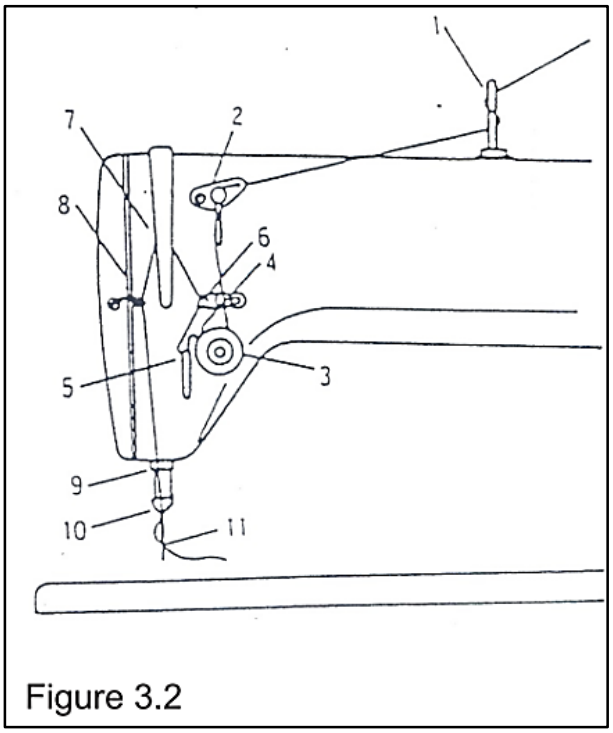

Figure 3.2

3.4 Bobbin Winding

a) Set the bobbin with the bobbin winder spindle and wind the thread on the bobbin for a few turns by hand.

b) Push fully the bobbin winder setting lever to make the winder pulley contact with the V-belt.

c) Set winding capacity at 80% using the bobbin winding capacity regulating screw.

d) If bobbin winding is uneven, adjust the position of the bobbin winder complete so that winding becomes even.

e) When winding finishes, the bobbin winder setting lever flips up and the bobbin winding pulley stops.

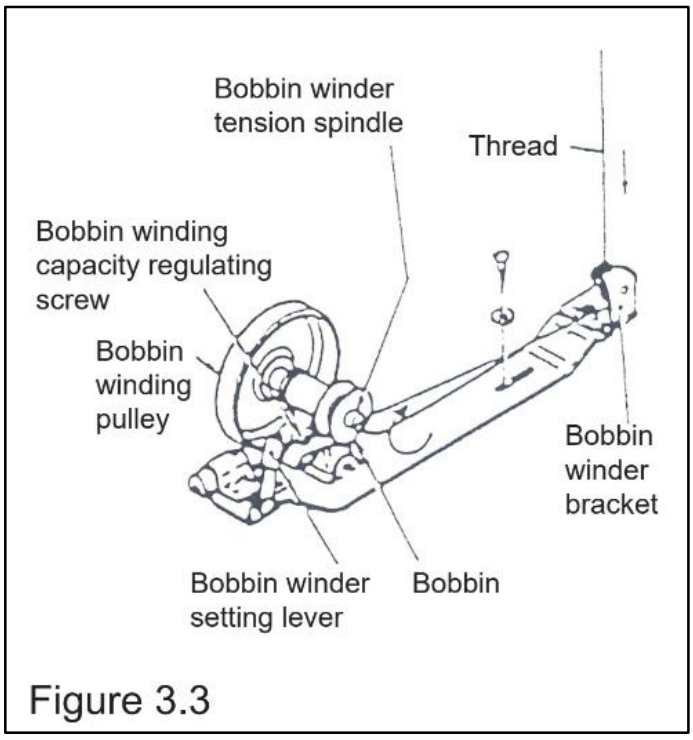

Figure 3.3

3.5 Bobbin Setting into Bobbin Case

a) Set the bobbin in the bobbin case in such a way that the bobbin will rotate in the direction as shown by arrow in Figure 3.4 when thread is pulled out.

b) Run a thread through the thread guide of the bobbin case and draw the thread, and the thread will come out from the thread feeder through the tension spring.

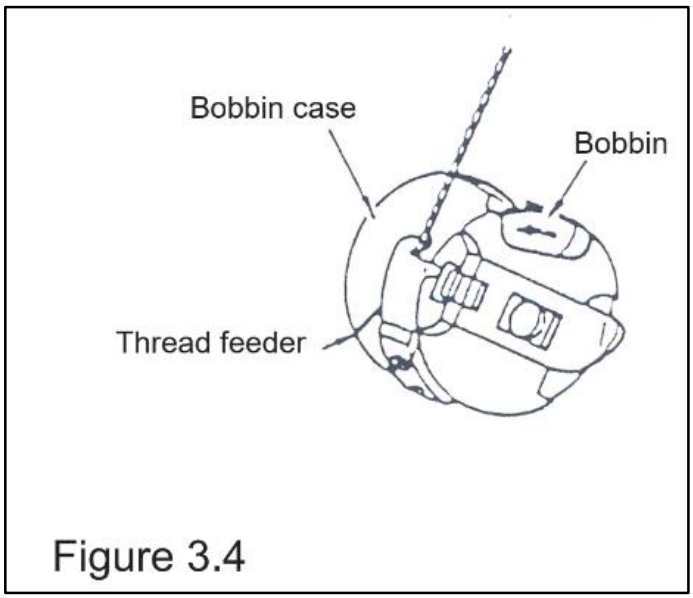

Figure 3.4

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3 – OPERATING INSTRUCTIONS

MACHINE ADJUSTMENTS

3.6 Upper Thread Tension (Figure 3.5)

Use the tension regulating thumb nut. Clockwise turns increase tension, and counterclockwise turns decrease tension.

3.7 Lower Thread Tension (Figure 3.6)

Turn the tension screw clockwise to increase, and counterclockwise to decrease.

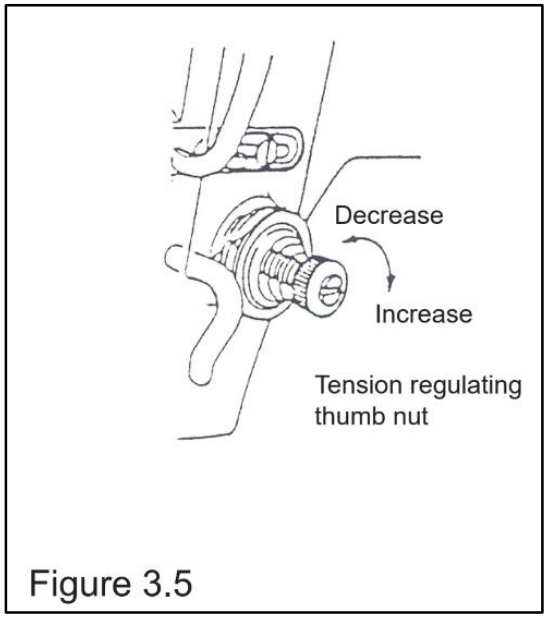


Figure 3.5

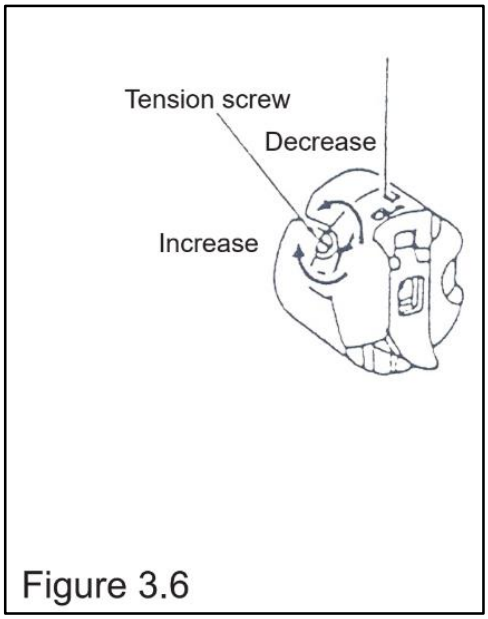


Figure 3.6

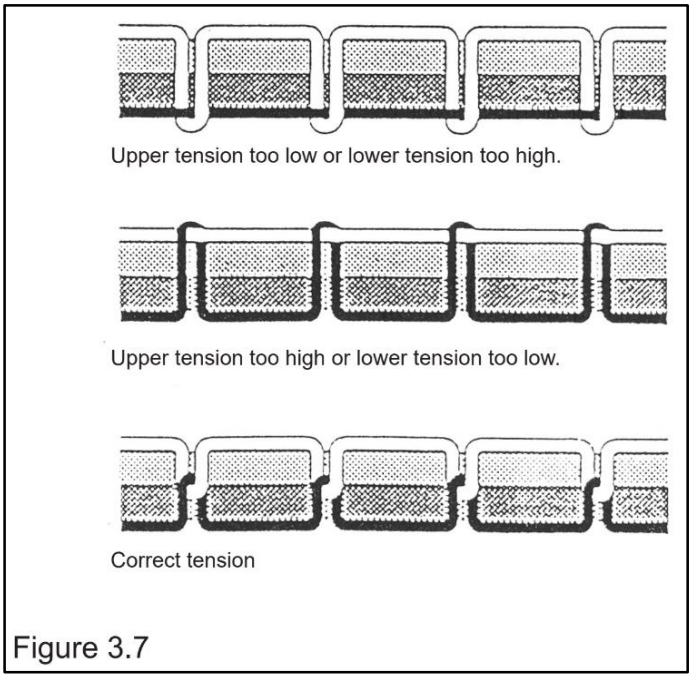
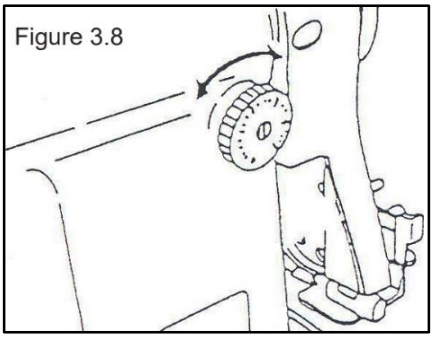


Figure 3.7

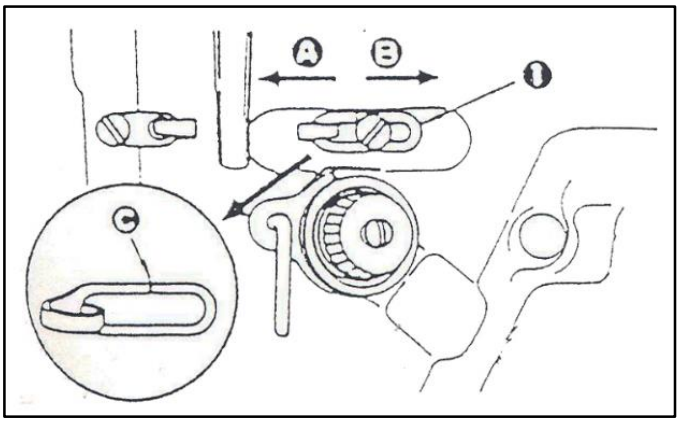
3.8 Adjustment of Stitch Length



To adjust the stitch length, turn the feed regulating dial (Figure 3.8).

3.9 Adjusting the Thread Take-up Stroke

Carry out the following steps of procedure after the power switch has been turned OFF.



a) When sewing heavy-weight materials, move thread guide **(1)** to the left (in direction **(A)**) to increase the length of thread pulled out by the thread take-up.

b) When sewing light-weight materials, move thread guide **(1)** to the right (in direction **(B)**) to decrease the length of thread pulled out by the thread take-up.

c) Normally, thread guide **(1)** is positioned in a way that marker line **(C)** is aligned with the center of the screw.

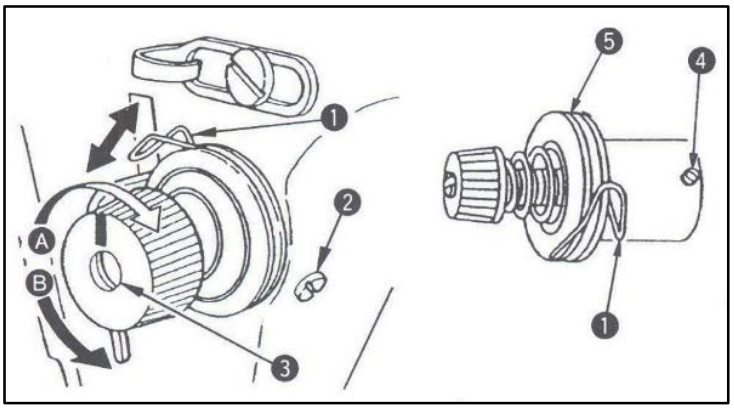
3.10 Thread Take-up Spring

1. Changing the stroke of thread take-up spring (1)

1) Loosen setscrew **(2)**.
2) As you turn tension post **(3)** clockwise (in direction **(A)**), the stroke of the thread take-up spring will be increased.
3) As you turn the knob counterclockwise (in direction **(B)**), the stroke will be decreased.

2. Changing the pressure of thread take-up spring (1)

1) Loosen setscrew **(2)**, and remove thread tension (asm.) **(5)**
2) Loosen setscrew **(4)**.
3) As you turn tension post **(3)** clockwise (in direction **(A)**), the pressure will be increased.
4) As you turn the post counterclockwise (in direction **(B)**), the pressure will be decreased.



Cleaning

Clean the hook and base area once every day, removing any lint or thread which may have accumulated. For this purpose, the jig plate can be removed from the machine. Switch off the machine, unscrew the needle plate and remove the lint with a soft brush.Remove the jig drive guard and clean away any dust or lint which may have accumulated.

NOTE: Never oil the jig drive wheel.

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3.11 Regulating Foot Pressure on Jig

Adjustment of Presser Pressure

Turn the presser regulating screw clockwise to increase, and counterclockwise to decrease the pressure. Be sure to tighten the nut after adjustment. A foot pressure of approximately 1.5 to 2 kg will give best results on all materials.

3.12 Emergency Stop

This is achieved by pressing the red Stop button. This will activate Emergency Stop sequence. Machine will not restart until Stop button is reset.

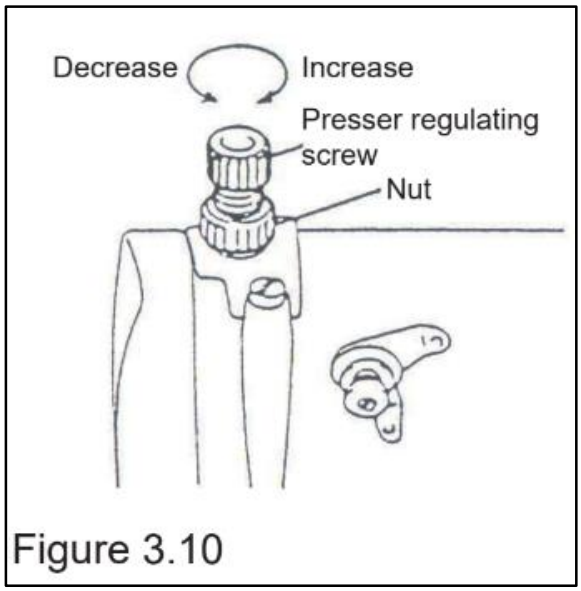

Figure 3.10

3.13 Needle and Thread

Selection of the proper needle depends on the material and thread used.

For selection of the proper needle and thread sizes refer to the table below:

	THREAD SIZE					
	NEDDLE SIZE (NM)"	COTTON	SILK	SYNTHETIC	LINEN	NEEDLE
A	60 70	100 - 80 70 - 60	140 120	200 - 150 180 - 120		134 R
B	80 90 100	60 - 50 50 - 40 40 - 30	100 80 70	120 - 100 100 - 80 80 - 60	70 60	134 R
C	110 120 130 140	30 - 24 20 12 10	60 50 40 30	60 - 50 50 - 40 40 - 30 30 - 20	50 40 35 30	134 R

A = LIGHT WEIGHT MATERIALS
B = MEDIUM WEIGHT MATERIALS
C = HEAVY WEIGHT MATERIALS
NM" = NEEDLE SIZE IN HUNDRETHS OF MM

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4 – SETTING PROCEDURES

4.1 Jig Feed Mechanism

1. Feed Motion Timing

Time the feed motion to be completed when the descending needle is approximately 6 mm above the material. Alterations to the stitch length are made in the usual manner using the stitch regulator.

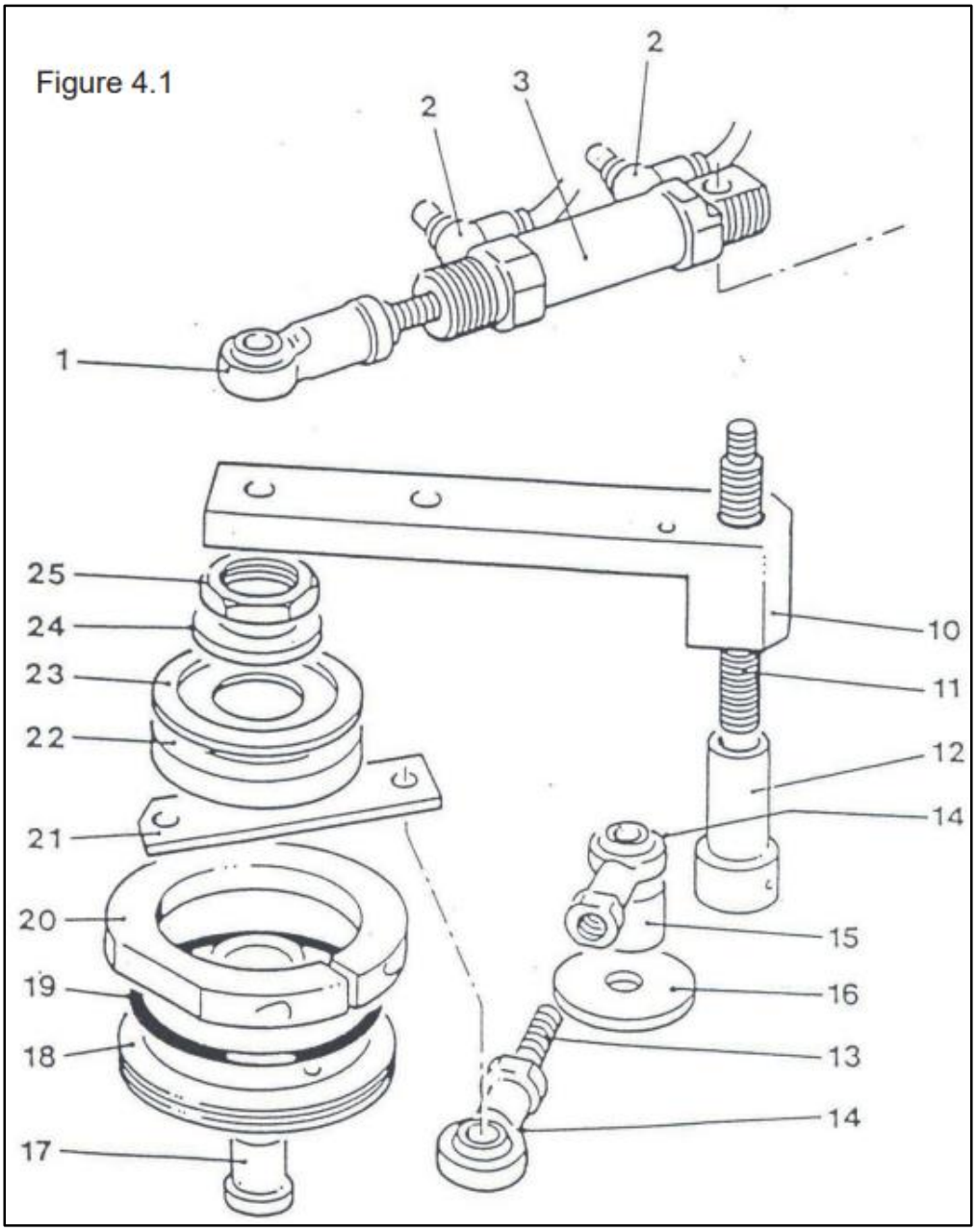
2. Drive Wheel Assembly (Figure 4.1)

To replace a worn drive wheel detach the drive arm **(10)** from the machine bed, unfasten the spherical rod end bearings **(14)** from the arm and the drive wheel housing. Next remove the bearing **(22)**, free-wheel housing **(20)** and drive wheel **(18)** complete from the arm. Using the two M5 holes in the drive wheel with two screws as an anchor, loosen nut **(25)** and remove drive wheel from bearing. When re-assembling care should be taken that all surfaces are clean and free from lint etc. The pivot spindle **(17)** should at this stage be lubricated with graphited grease before replacement into the drive wheel.

CAUTION:

ORDINARY GREASE OR LUBRICATING OIL IS NOT SATISFACTORY IN THE DRIVE WHEEL STUD HOUSING. USE A GREASE CONTAINING GRAPHITE OR MOLYBDENUM DISULPHIDE.

Figure 4.1



The clutch is lubricated with oil and has an 'O'-ring on the bottom to prevent oil leakage. It is also covered with a 'Nilos' sealing ring to exclude dust and fibrous waste. The clutch should be lubricated lightly every 100 running hours with light machine oil (non-staining).

Ensure drive wheel does not foul on base of machine, when unit is tightened down.

3. Drive Wheel Cylinder (Figure 4.1)

The rod end bearing (1) should be set so that when the cylinder is fully extended the drive wheel is taken 3 mm past its contact position.

CAUTION:
CHECK THIS SETTING BECAUSE, IF THE DRIVE WHEEL TRAVELS TOO FAR, IT WILL CONTACT AND DAMAGE THE PHOTOCELL IF THE MACHINE IS RUN WITHOUT A JIG.

4. Drive Wheel Surface

The driving surfaces of the wheel must not be contaminated with any lubricant or silicone aerosols etc., as this will affect the feeding. Clean the tapered groove with solvent if contamination is suspected.

4.2 Dense Stitch Size

The size of the dense stitches themselves may be altered using the adjustment nut 2 on the dense stitch adjuster located underneath the machine bed. By loosening nut 1 and rotating nut 2 clockwise the size of the dense stitches will increase. When the correct size is achieved use nut 1 to lock nut 2 in position. See Fig 4.2.

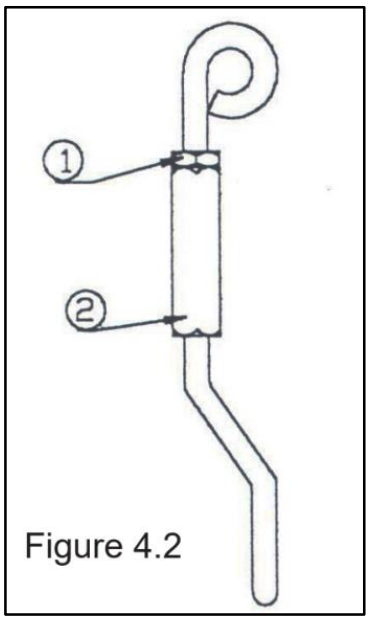


Figure 4.2

4.3 Number of Dense Stitches

The AMF Reece controller is set to give a timed sequence of dense stitches at the start and end of stitching. These two conditions can be altered by tenths of a second to give longer or shorter length of dense stitch.
The speed of the dense stitch may be altered to faster or slower (see Section 5).

4.4 Needle Reverse

The Efka motor may be programmed to take the needle to its highest position, when thick cloth is being used. This allows the presser foot to be set higher without needle protruding, (see Efka Manual).

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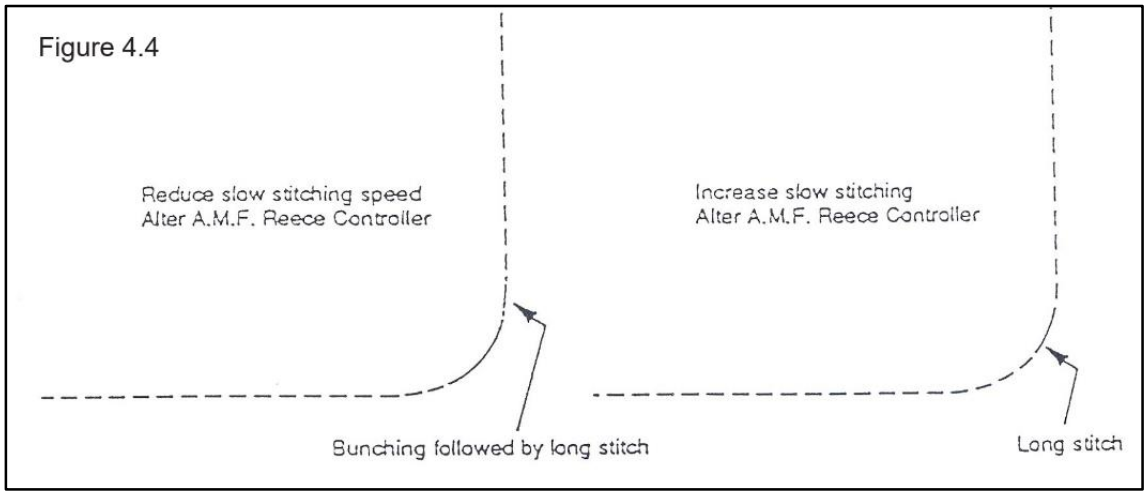
4 – SETTING PROCEDURES

4.5 Turn Arm / Variable Speed Setting Instructions

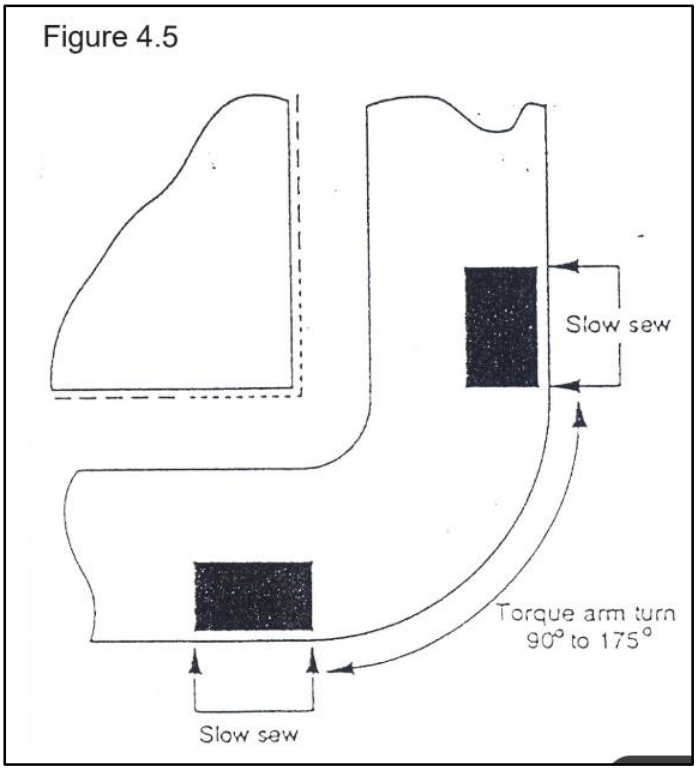
1. To obtain uniform stitching on radiused corners it is necessary to find the machine speed that is matched to the speed of the torque arm. This is done by altering slow sew speed in AMF Reece controller (see Section 5). Small stitches at the corner indicate too fast a machine speed, so this would require the speed to be lowered. Large stitches at the corner indicate too slow a machine speed. Correct this by increasing speed in AMF Reece controller.

Figure 4.4



2. Actuation of the torque arm is caused by the photocell being energised after it has cleared the first piece of tape on the corner of the jig, it is returned when it is de-energised by the second piece of tape which is placed after the corner. It is possible to turn approx. 175° (see Figure 4.5).

Figure 4.5



3. The turn arm has a 20 mm cylinder fitted. This is in return position when torque arm is at rest, this is to allow jigs with internal radii to pass underneath. Also fitted to the torque unit are two flow controls: these restrict the exhausted air to ensure that the jig turns smoothly.

TAPE POSITION AT CORNERS (Guide only)

4.6 Photo-Electric Switch

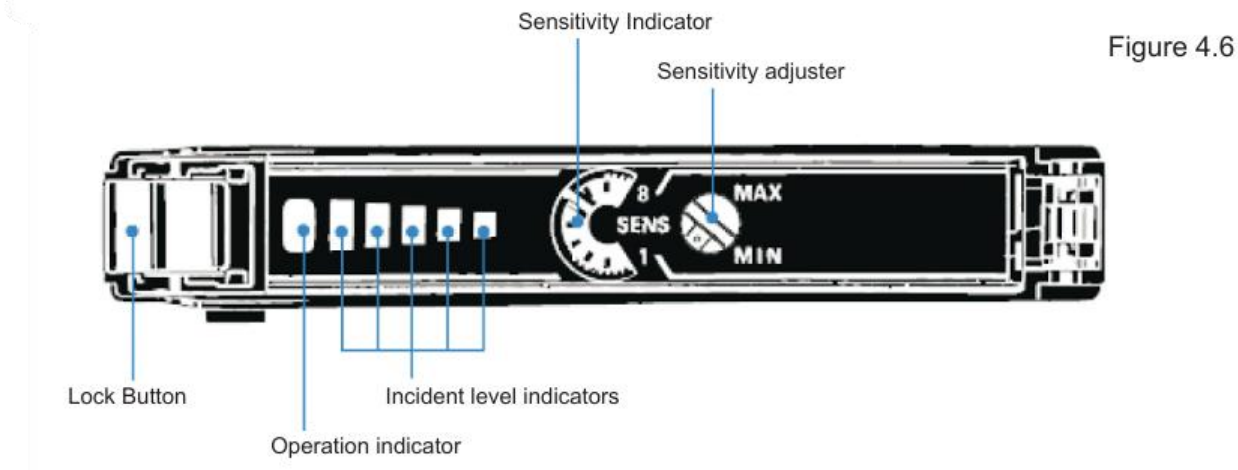


Figure 4.6

1. Hints on Correct use

Do not use the sensor in explosive or ignition gas.
Never disassemble, repair nor taper with the sensor.
Do not apply excess voltage and current over rating.
Do not wire improperly such as reversing polarity.
Do not short-circuit load.
Do not remove protective cover from the sensor.

2. Indication

In addition to the operation (orange), sensor has indicators that denotes the level (4 green and 1 red indicators). Use them for optical axis adjustment and maintenance.

3. Sensitivity Adjustment

For correct adjustment follow these steps:

a) Put the jig with black tape under the sensor. When the black tape is under the sensor, operation indicator must not lit and one or two incident level indicators have to lit (green), see Figure 4.7 a, 4.7 b.

b) Move the jig to the position without black tape. Here operation indicator has to lit and three or more incident indicators have to lit, see Figure 4.7 d, 4.7 e.

If the sensor doesn't work according to the points mentioned above change the position of sensitivity adjuster. Standard position for sensitivity adjuster is shown in Figure 4.8.

Figure 4.7

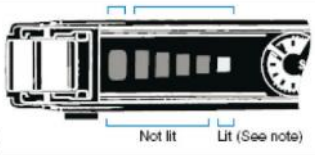
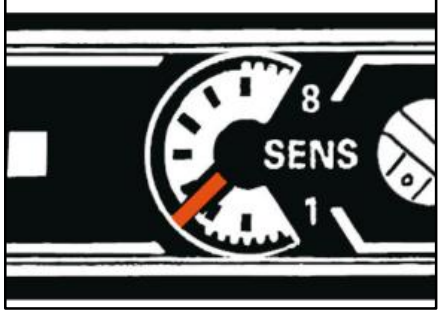
Indicator status (L/ON)	Operation indicator (L/ON)	Incident level
a) 	Not lit	Approx. 80% to 90% of operating level
b) 	Not lit	Approx. 80% to 90% of operating level
c) 	Not lit or lit	Approx. 90% to 110% of operating level
d) 	Lit	Approx. 110% to 120% of operating level
e) 	Lit	Approx. 120% min. of operating level

Figure 4.8



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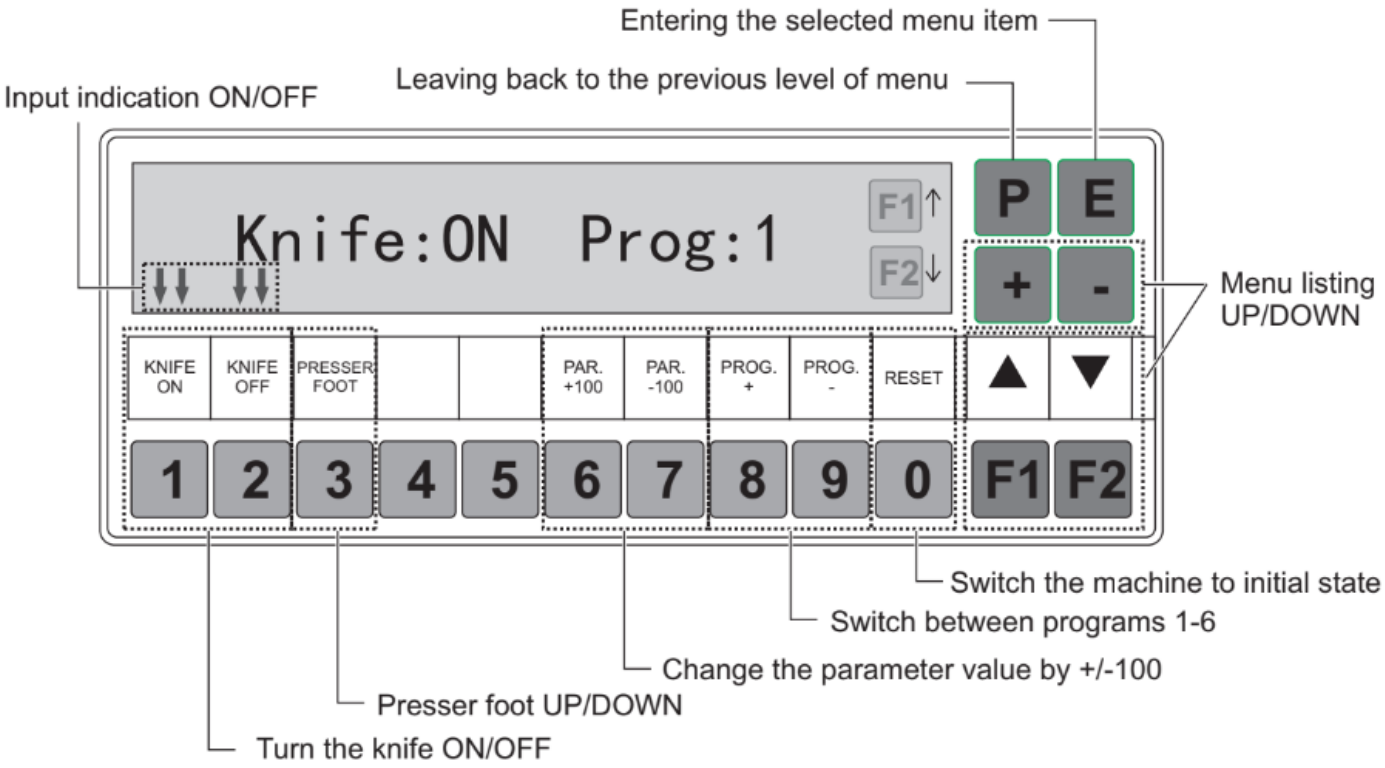
Control Panel

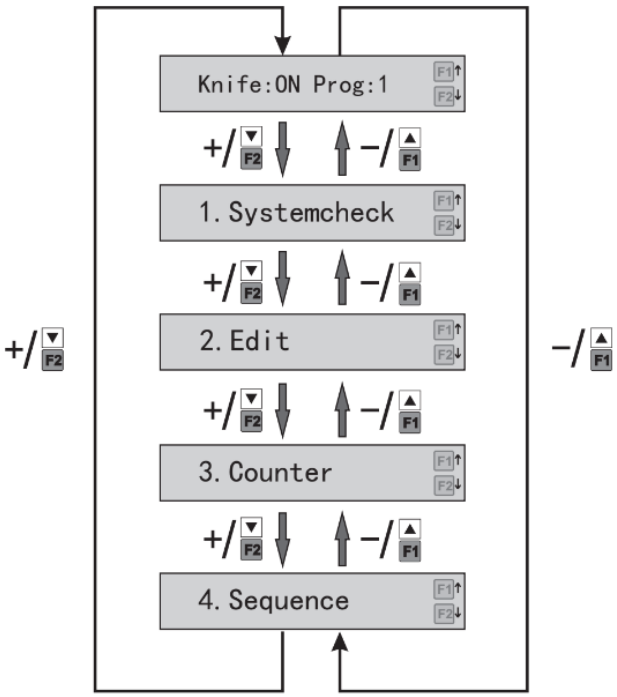


The following screen is displayed after turning the machine on:

To get into the main machine menu and to list

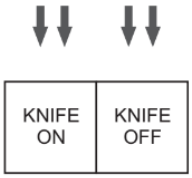
in this menu,

use the cursor arrows ▲ , ▼ (F1, F2) or + , - :

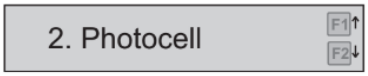


1. Systemcheck

1.1. Input Test

Input status is indicated by 

.



1.2. Output Test

Output can be tested by pressing 

button

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1.3. Position Test

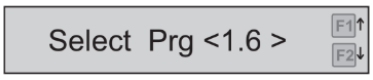
Sewing motor function can be tested:

- by 1st press of E button the needle goes to the bottom position,
- by 2nd press of E button the needle goes to the top position.

2. Edit

1. For the first time after turning the machine on, the following screen will appear:

Enter the code 131

2. 

Select the program for editing by pressing 1 - 6 .

3. Adjust the parameter value by PAR. +100 6 and PAR. -100 7 .

2.1. Program Parameters

Nr.	Parameter	Values	Description
1	Double Jig	OFF / ON	sewing of double-jig off / on
2	1Jig Corner	NeDN / SlSp / END?	1st jig corner: needle stay down / sewing at slow speed / end of cycle
2a	1 C.Slow Sp	400 – 2600 [spm]	1st jig corner: speed of the slow sewing
3	2Jig Corner	NeDN / SlSp / END?	2nd jig corner: needle stay down / sewing at slow speed / end of cycle
3a	2 C.Slow Sp	400 – 2600 [spm]	2nd jig corner: speed of the slow sewing
4	3Jig Corner	NeDN / SlSp / END?	3rd jig corner: needle stay down / sewing at slow speed / end of cycle
4a	3 C.Slow Sp	400 – 2600 [spm]	3rd jig corner: speed of the slow sewing
5	4Jig Corner	NeDN / SlSp / END?	4th jig corner: needle stay down / sewing at slow speed / end of cycle
5a	4 C.Slow Sp	400 – 2600 [spm]	4th jig corner: speed of the slow sewing
6	K.DelayStart	OFF / ON	delayed activation of the cutting knife off / on
6a	Time ON/Tape	OFF / ON	delay of the cutting knife activation determined by time (ON) / black-tape (OFF)
6b	K.DelayTime	0 – 9999 [ms]	time of the cutting knife activation delay (when activation by time selected)
7	K.DelayEnd	OFF / ON	delay of the cutting knife deactivation from the final black-tape
8	Dense into C	OFF / ON	dense-stitches sewing in the corners off / on
9	Sta Den.Tim	0 – 9999 [ms]	time of dense-stitches sewing from the sewing start
10	End Den.Tim	0 – 9999 [ms]	time of dense-stitches sewing from the final black-tape
11	Set Den. Sp	400 – 2600 [spm]	setting of the dense-stitches sewing speed
12	Slow Sew Sp	400 – 2600 [spm]	setting of the speed when “sewing at slow speed” is selected in a corner
13	Needle DnSp	400 – 2600 [spm]	setting of the speed when “needle-stay down” is selected in a corner
14	Max Sew Sp	400 – 2600 [spm]	setting of the maximum sewing speed
15	J.Flap Act.	OFF / ON	jig flapping off / on
16	Sp to Corne	400 – 2600 [spm]	setting of the speed before reaching the first corner

3. Counter

- daily production counter delete by pressing

- total machine production counter

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4. Sequence

a) By pressing **1** you activate the sequence-mode:

- S: 0-0-0-0-0-0- select the individual desired programs for the sequence by successive pressing buttons **1** - **6**.

- This will be indicated by 

on the main screen.

b) By pressing **2** you deactivate the sequence-mode:

6 – PNEUMATICS

The pneumatics are switched by a bank of solenoid valves located inside the cabinet door. Air is normally on the ‘B’ lines. When a solenoid valve is energised, the air is transferred to line ‘A’.

6.1 Jig Flap.

When solenoid is energised this allows air through line A1 causing jig flap to lift.

6.2 Jig Turn

When solenoid is energised this allows air through line A2 causing turn arm to function and turn jig. When solenoid is de-energised this allows turn arm to return to rest position, air through line B2.

6.3 Jig Eject

When solenoid is energised this allows air through line A3 causing jig eject cylinder to operate. When de-energised this allows air to line B3 causing jig eject cylinder to return.

6.4 Jig Drive

When solenoid is energised this allows air through line A4 causing jig drive cylinder to operate and grip jig. When solenoid is de-energised this allows air through B4 causing jig drive to return.

6.5 Knife

When solenoid is energised this allows air through line A5 causing knife to engage and allowing air to foot and rear blower. When solenoid is de-energised this allows air through B5 causing knife to return to up position, and removes air from waste blowers.

6.6 Air Blowers

There are three blowers fitted to the machine: one to the throat plate, one to the foot and one to the rear of the machine. All blowers should be set so they dispose of trimmed material to the rear of the machine.

6.7 Air Flow Regulators

Most air cylinders are fitted with flow control valves, to adjust the speed of operation of the air piston. For example, drive wheel cylinder (Fig 4.1, item 2) must be adjusted so that the drive wheel is brought smoothly into contact with the edge of the jig, otherwise damage may be caused to the jig.

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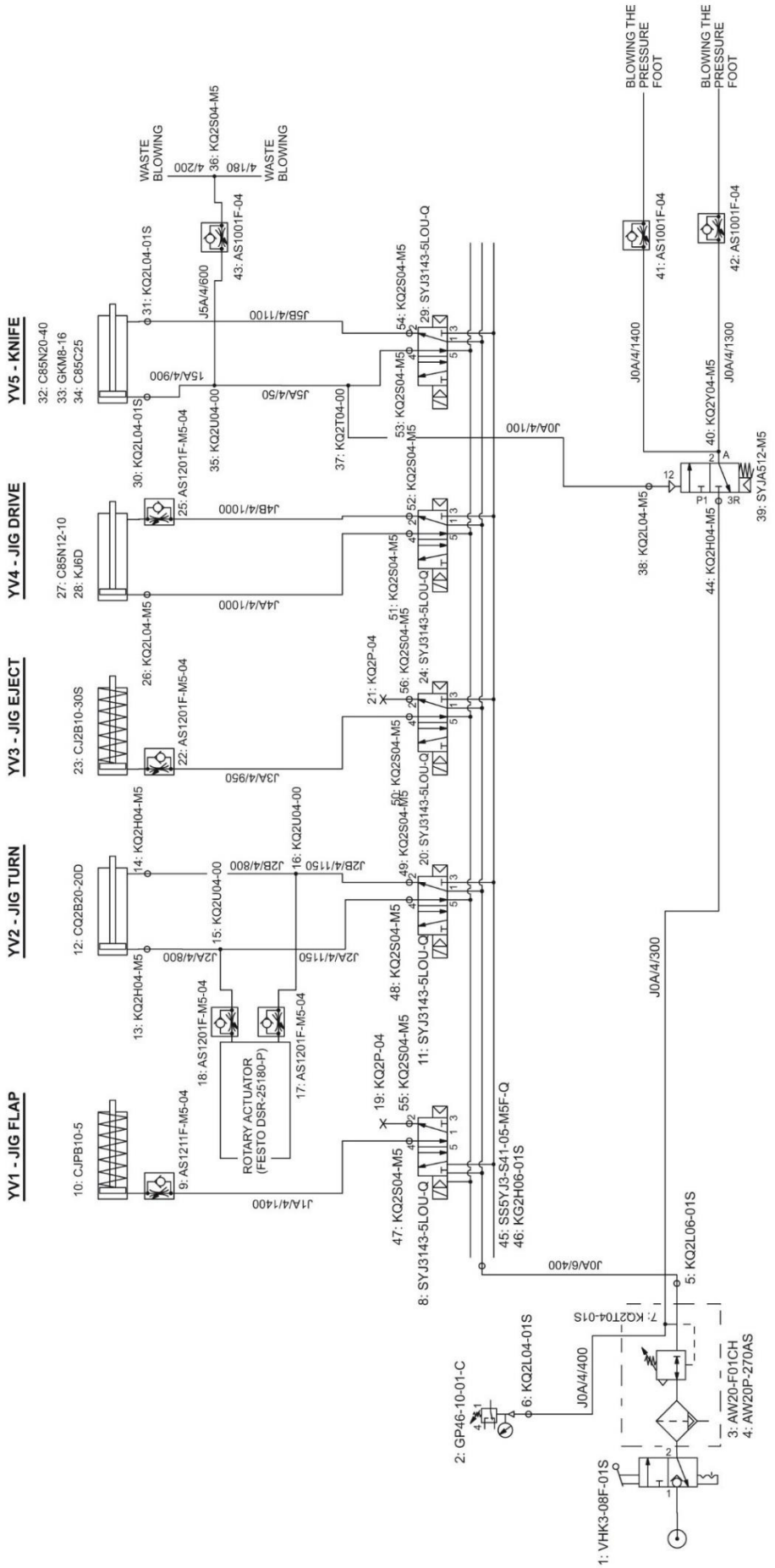
6 – PNEUMATICS



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7 – HEAD SETTING PROCEDURES

7.1 Needle Insertion

Hold the lower punch mark of the needle **(1)** to face the left. Then make the end of the needle butt up to the upper side of the stopper hole **(2)**. Then secure the needle with the fixing screw **(3)**. (Refer to Fig. 7.1)

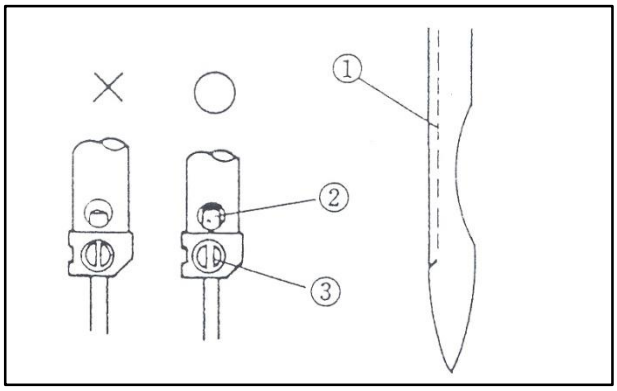

Figure 7.1

7.2 Adjusting the Needle Bar

As shown in Fig. 7.2, remove the rubber plug **(4)** from the front cover. Rotate the pulley to move the needle to its lowest position. Then release the needle fixing screw **(5)**. Align the upper punch mark **(7)** on the needle bar with the bottom end of the needle bar lower bushing **(6)** and then tighten the screw **(5)** and fit the rubber plug **(4)**.

7.3 Adjusting the Timing of the Needle Hook

As shown in Fig. 7.2, align the lower punch mark of the needle bar **(1)** with the end of the lower needle bar bushing **(6)** and release the three fixing screws **(2)**. With the point of the hook **(3)** set to the centre of the needle, adjust the point of the hook to give 0.05-0.1 mm gap. Tighten the three screws **(2)**.

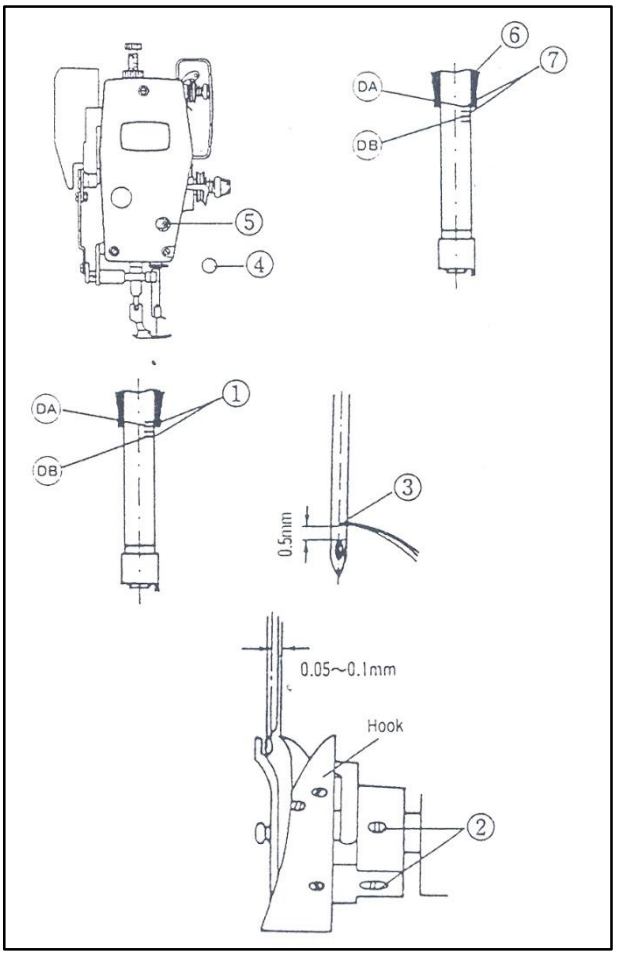

Figure 7.2

7.4 Adjusting the Lubrication of the Thread Take-up Lever

As shown in Fig. 7.3, when the dot **(2)** marked on the head of the oil adjusting pin **(1)** aligns with the centre of the thread-take up crank shaft hole **(3)**, the maximum amount of oil is released. If the adjusting pin is turned towards the marks **(5)**, the amount of oil released will be reduced. If the dot **(2)** passes marks **(5)**, no oil will be released.

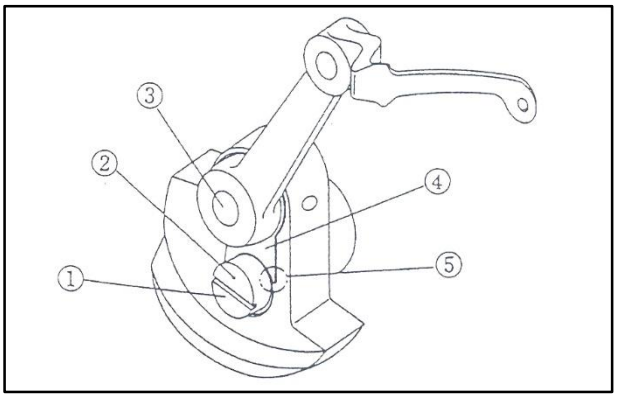

Figure 7.1

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7.5 Regulation of Amount of Oil Supply to Hook

A. Measuring amount of oil supplied

1. Run the sewing machine on full speed for 3 minutes. Place a piece of paper in position as shown in Fig. 7.4, and run machine for a further 5 seconds. The amount of oil being supplied can now be seen.

2. Repeat this process a further 3 times making sure the oil being supplied is within the limits shown in Fig 7.4. Too much oil could stain the material being sewn. Too little can cause the hook to seize.

B. Oil Supply Adjustment

Turning the adjusting screw clockwise, as shown in Fig. 7.4, will Increase the oil flow, turning the screw counter clockwise will Decrease the oil flow.

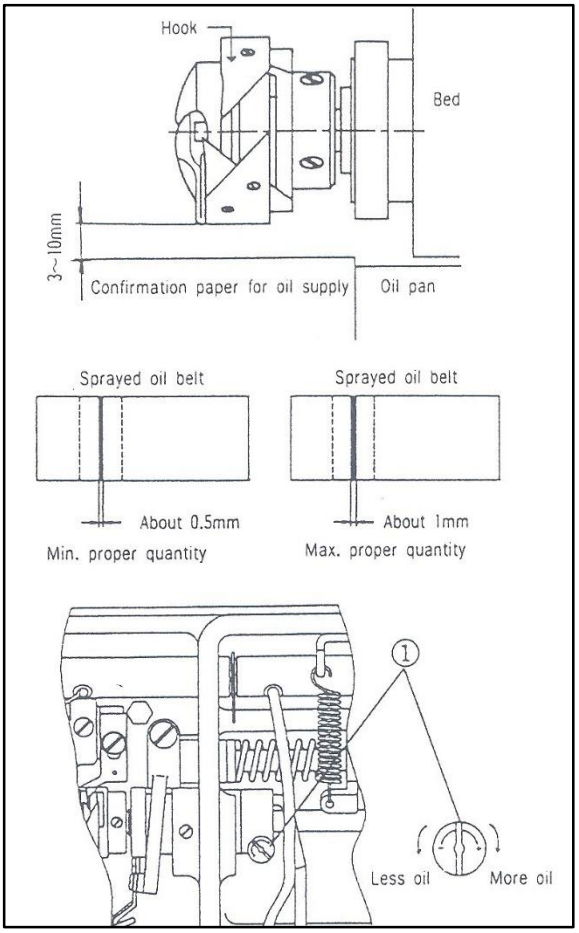

Figure 7.4

7.6 Lower Thread Take Up and Tension Adjustment

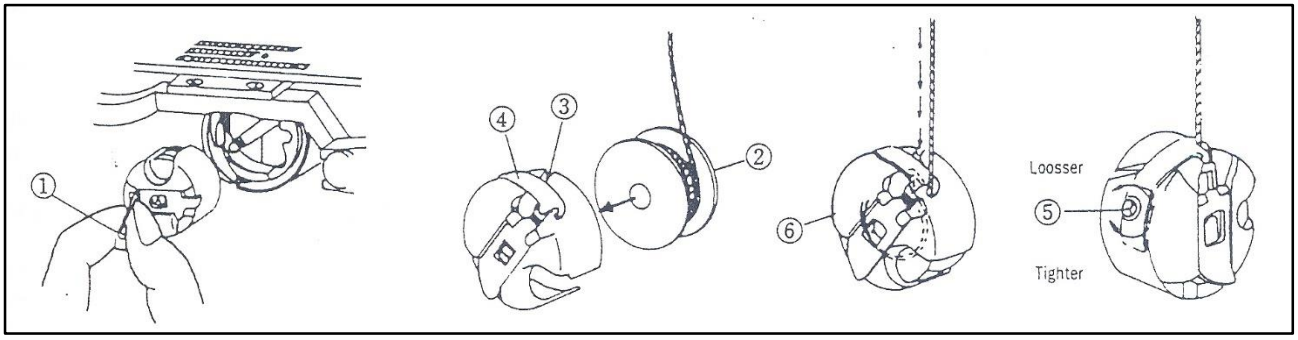

Figure 7.5

A. Spool Fitting and Tension Adjustment

Refer to Fig 7.5. Fit the spool **(2)** into the spool case **(6)** Insert the thread spool in the groove **(3)** Then hook the thread under the thread tension adjusting spring **(4)** Rotating the tension adjusting screw **(5)** clockwise increases the thread tension, rotating the tension adjusting screw **(5)** anti-clockwise decreases the thread tension. Adjust the thread tension so that the spool case will gradually drop under its own weight.

B. Insertion and Removal of Spool Case

Refer to Fig 7.5. Hold the spool case lever **(1)** and push the case into the hook. When removing, hold the spool case lever and pull it out of the hook.

7.7 Upper Thread Path

Place the thread at the optimum position, then insert the upper thread according to the sequential numbers in Fig. 7.6.

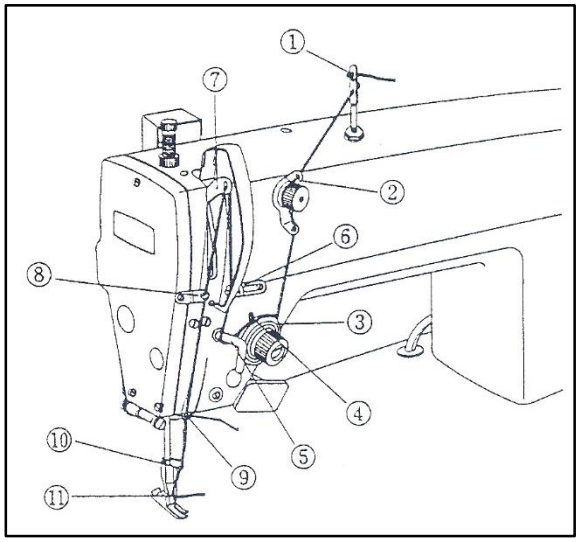

Figure 7.6

7.8 Upper Thread Adjustment

A. Main Thread Tension Adjusting

As shown in Fig. 7.7, turning the tension adjusting screw **(1)** clockwise increases the upper thread tension. Adjust the tension of the thread according to the material being sewn, the thread and the number of stitches.

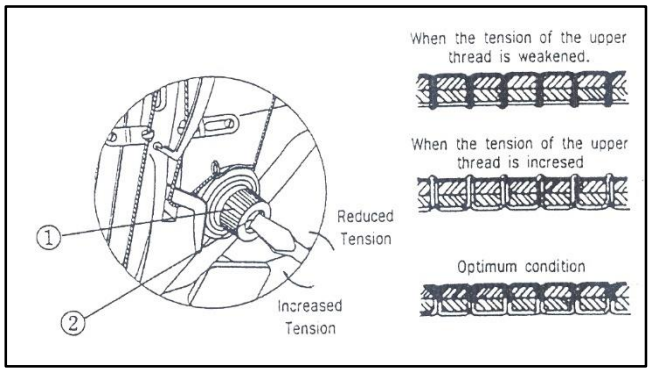

Figure 7.7

B. Tension Adjustment of Check Spring

As shown in Fig. 7.7, rotating screw **(2)** will increase the check spring tension.

C. Thread Pre-Tension Adjustment

As shown in Fig. 7.8, rotating the pre-tension screw **(1)** clockwise, the length of trimmed thread will be reduced. The optimum length of the remaining thread after trimming is 30 - 40 mm.

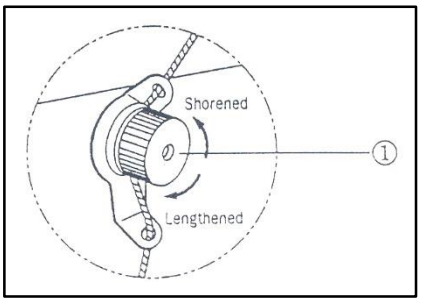

Figure 7.8

D. Adjusting Thread Release Unit

The thread release unit is operated by the movement of the thread trimming solenoid. As shown in Fig. 7.9 the thread release gap can be adjusted by moving the thread release cable wire **(2)** which is attached to the thread release operation lever **(1)** Release the two fixing nuts **(3)** Then move the cable wire **(2)** to the left and tighten the nuts **(3)**. The thread release gap will have increased. If the cable **(2)** is moved to the right the gap will be decreased. Adjust the cable to give a gap of 0.5 - 1 mm between the discs **(4)** when the thread release is operated. Ensure the discs are closed when the lever is released. The stroke of the thread release lever **(1)** is 5 mm. Adjust the lever so that the discs **(4)** do not open during the first 2 mm of lever travel and that they are open when the lever is pulled 2-5 mm. Refer to Fig. 7.9

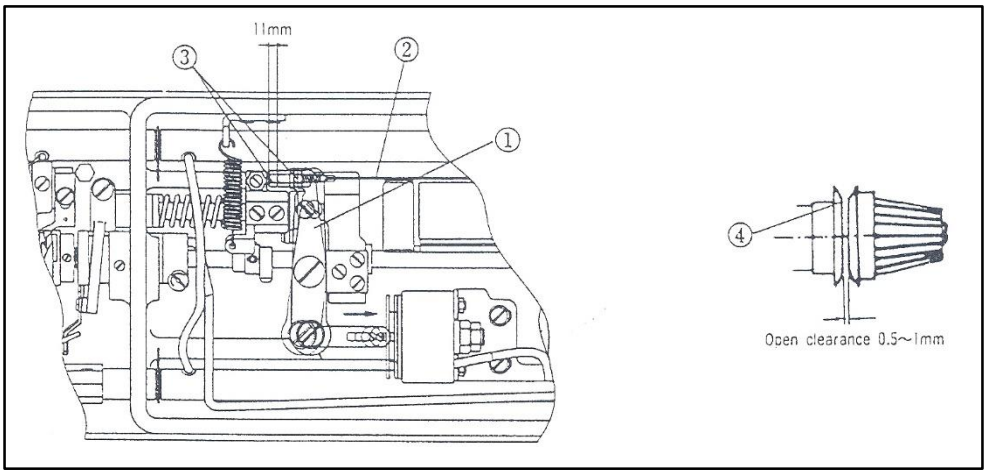

Figure 7.9

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7.9 Presser Foot Height and Pressure Adjustment

A. As shown in Fig. 7.10, remove the rubber plug **(2)** from the cover plate **(1)**. With the needle in the 'up' position and the presser foot **(3)** also in the 'up' position make sure the needle point is not showing below the presser foot. If the needle point is visible then release the presser bar holder screw **(4)** and adjust the holder until the foot covers the needle. Once the adjustment has been carried out check the presser foot will both clamp the jig in the 'down' position and also allow the jig to be loaded in the 'up' position.

B. Adjustment of the presser foot pressure. As shown in Fig. 7.10 rotating the adjusting screw **(6)** clockwise increases the foot pressure. After adjustment use nut **(7)** to lock adjusting screw '6' in position.

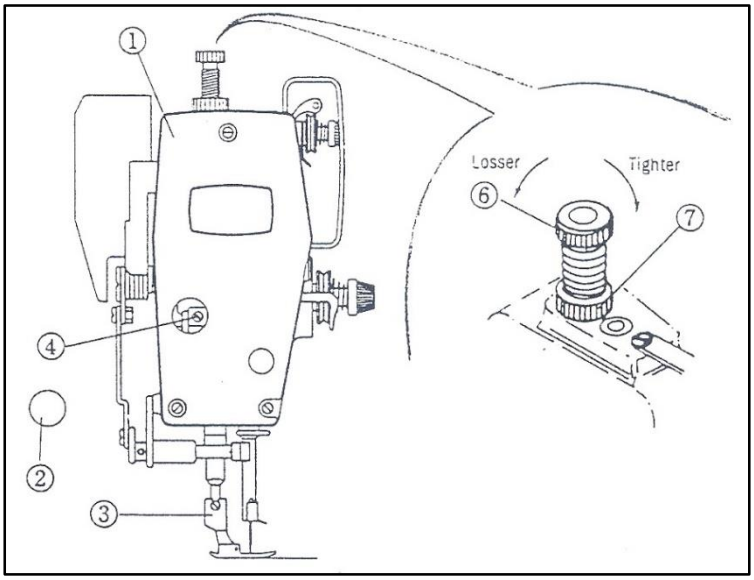

Figure 7.10

7.10 Presser Foot Solenoid Adjustment

Presser foot travel can be adjusted on the presser foot solenoid crank **(3)**. Referring to Fig. 7.11 Release the screws **(5)** securing the solenoid cover **(4)**. Release screw **(2)** for the solenoid crank pivot. Rotating the pivot **(1)** clockwise will increase the foot travel, anticlockwise will reduce the presser foot travel.

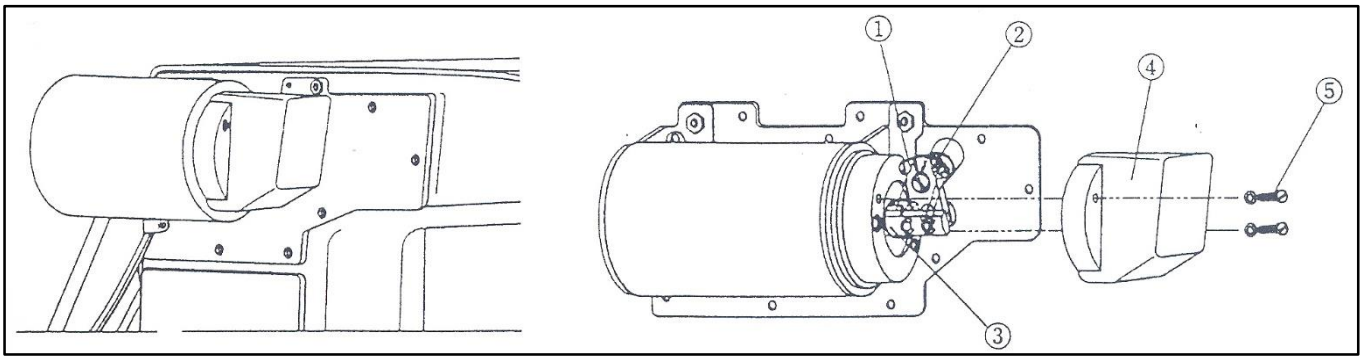

Figure 7.11

7.11 Stitch Length Adjustment

As shown in Fig. 7.12 the dial **(1)** increases stitch size when turned anti-clockwise and reduces the stitch size when turned clockwise.

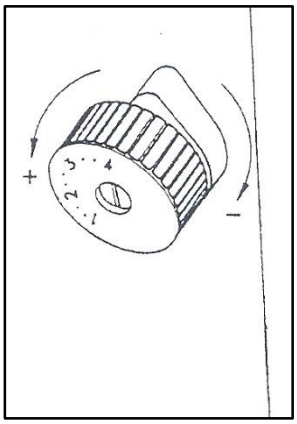

Figure 7.12

7.12 Feed Cam Adjustment

When the feed timing is correct the jig should be moved just after the needle has left the material. To obtain this timing remove the plate holding the presser foot lift solenoid and locate the feed cam **(1)** as shown in Fig. 7.13. After releasing screw **(2)** rotate the cam clockwise to advance the feed, or rotate the cam counter clockwise to retard the feed. Tighten screw **(2)** when finished.

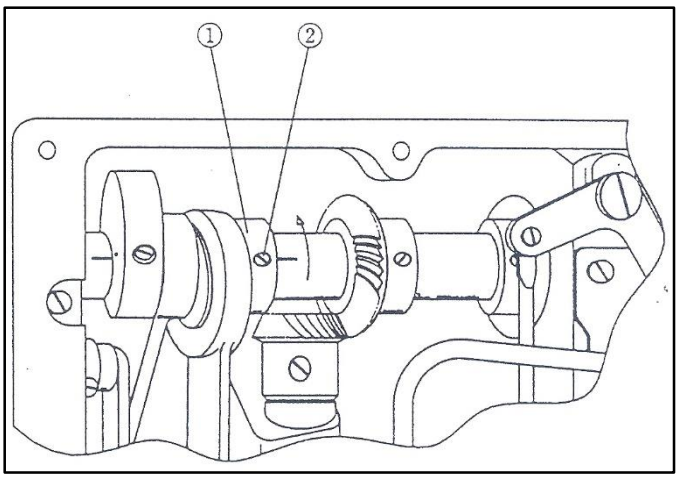

Figure 7.13

7.13 Thread Triming Timing Adjustment

A. Referring to Fig. 7.14 line up mark **(2)** on hand wheel with punch mark **(3)** on head.

B. Remove spring **(4)** as shown in Fig. 7.14.

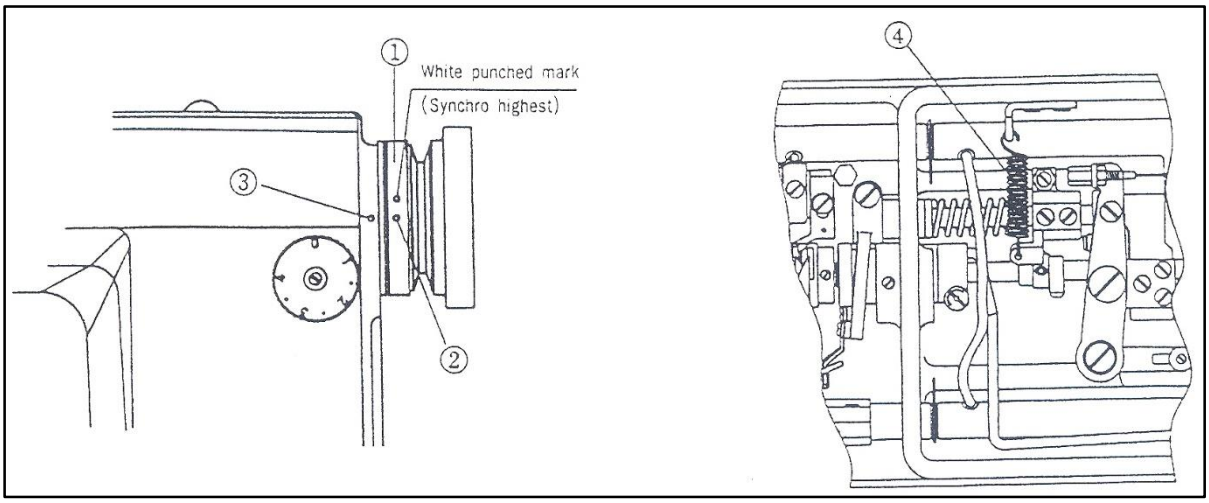

Figure 7.14

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C. Referring to Fig. 7.15, push trimming blade **(6)** up until fixed knife **(8)** is 1-1.5 mm onto mound **(7)**.

D. Referring to Fig. 7.15, push thread trimming solenoid **(10)** in with screw **(9)** of the thread trimming cam slackened. The distance between trimming cam **(11)** and roller screw **(12)** is 0.5 mm.

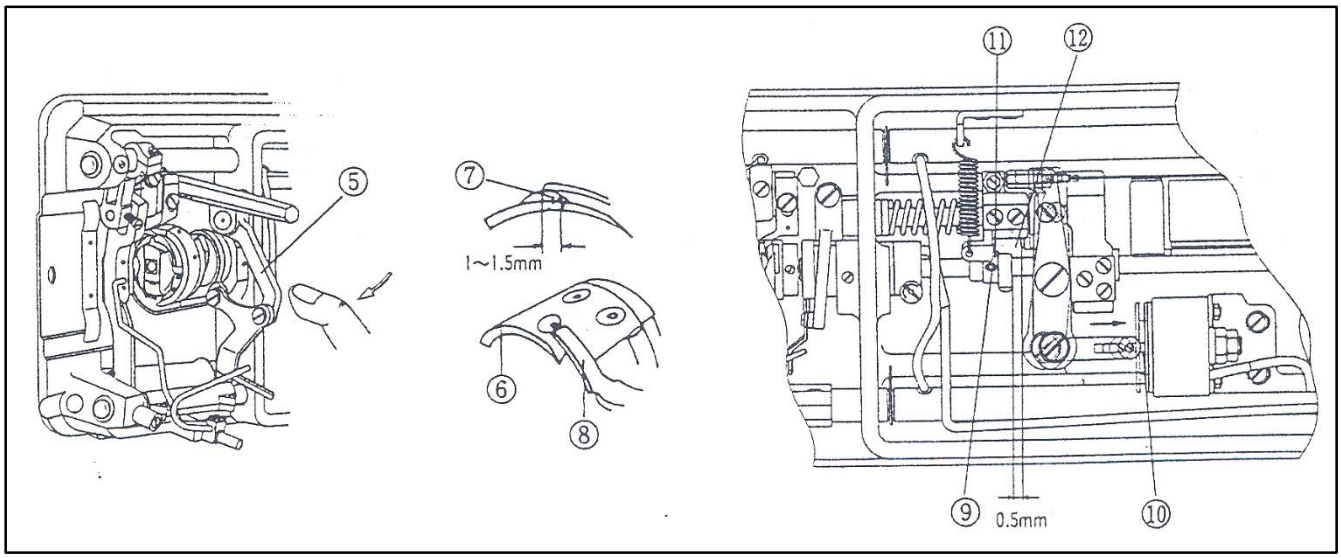

Figure 7.15

E. Tighten up screw **(9)** for the thread trimming cam after adjustment. Check the roller of cam **(11)** with roller **(14)** by rotating thread trimming cam **(11)** by hand. Refer to Fig. 7.16.

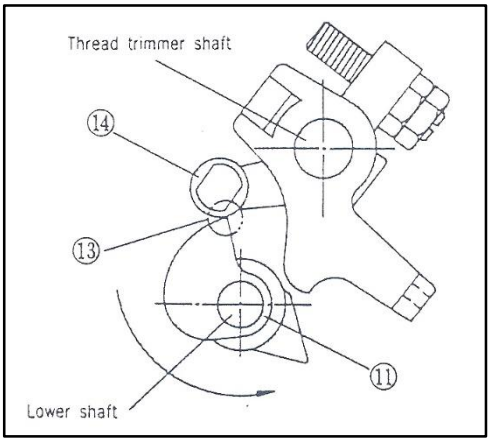

Figure 7.16

F. Connect return spring **(4)**.

7.14 Fixed Knife Tension Adjustment

Release the tension adjusting nut **(1)** with a box spanner and release the tension adjusting screw **(2)**. As shown in Fig. 7.17 push the moving knife towards the fixed knife until its blade point meets the fixed knife point. Tighten the fixed knife tension adjusting screw **(2)** until the two blades touch without force. Tighten the tension adjusting nut **(1)**.

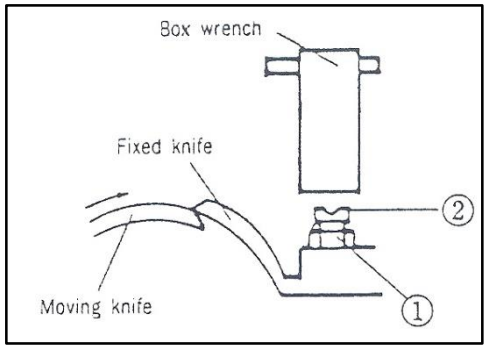

Figure 7.17

7.15 Replacing the Moving Knife

Ensure the needle is in the `up' position and remove the throat plate. Referring to Fig. 7.18 undo the two screws **(2)** and remove the moving knife **(1)**. Fit the new knife and tighten all screws.

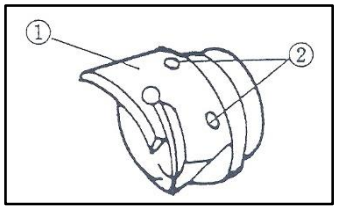

Figure 7.18

7.16 Replacing the Fixed Knife

A. To replace the fixed knife **(1)** release the spool case positioning finger fixing screw **(2)** as shown in Fig. 7.19 and remove washer **(3)** and finger **(4)**. Remove the fixed knife screw **(5)** and then remove the fixed knife.

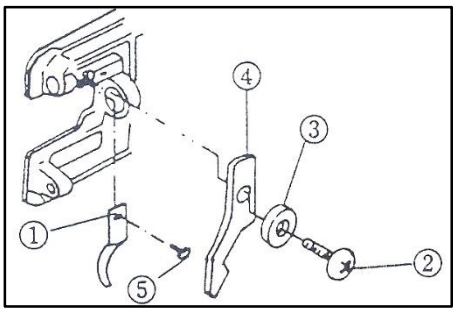

Figure 7.19

B. If the point of the blade is dull sharpen using an oil stone. Refer to Fig 7.20.

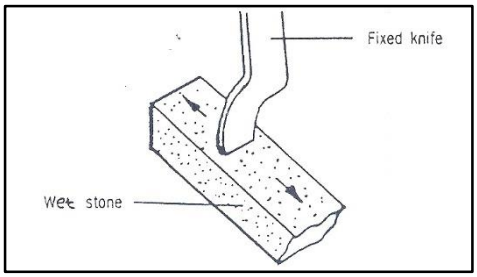

Figure 7.20

7.17 Bobbin Catcher Adjustment

As shown in Fig. 7.21 with the spool catcher lever **(3)** relaxed, release the fixing screws **(6)** and adjust the lever **(3)** until it is touching the bottom of the connector link **(2)** as shown by **(a)**.

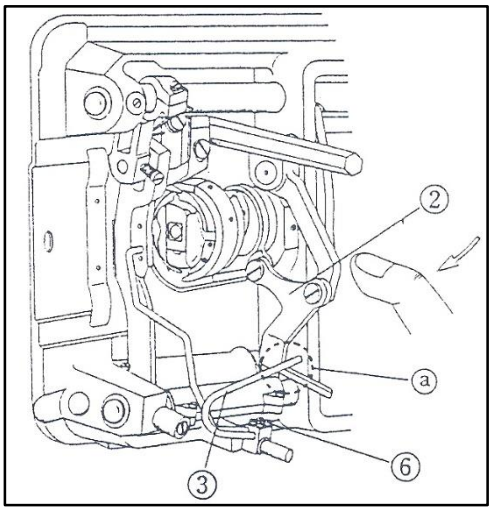

Figure 7.21

7.18 Side Knife Replacement and Adjustment

When the knife is engaged it should cut cloth cleanly without having excessive pressure on the throat plate. Referring to Fig. 7.22 loosen screws **(1)** and remove knife **(2)**. Insert new knife and, with the knife in its lowest position, adjust knife holder **(4)** by releasing screw **(3)** and pushing knife up to throat plate. Tighten all screws.

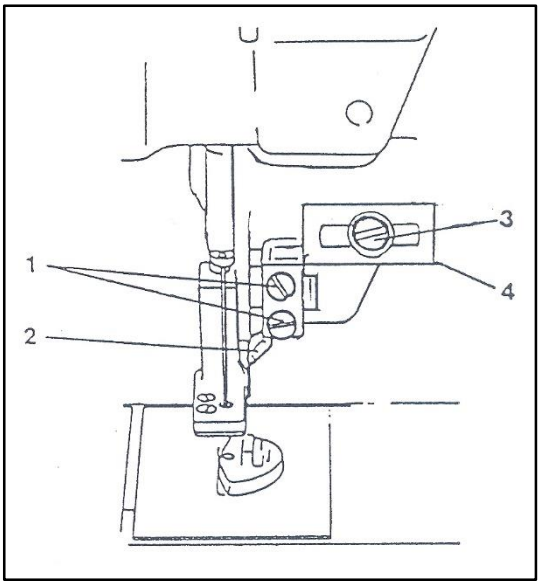

Figure 7.22

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7.19 Sewing Head Trouble Shooting

No	Problem	Check	Cause	Maintenance
1	The needle is broken.	Needle facing.	The needle is inserted incorrectly.	Replace the needle correctly.
		Needle.	The needle is bent.	Replace the needle.
			Improper feed dog timing.	Adjust the operating time.
		Raised height of the needle bar.	Improper needle and rotary hook timing.	Adjust the operating time.
		Height of the needle bar.	Improper needle and rotary hook timing.	Adjust the operating time.
		Clearance between the needle and the hook.	Improper needle and rotary hook timing.	Adjust the operating time.
2	The thread is cut.	Threading.	Threading is incorrect.	Re-thread it.
		Needle.	The needle is bent or damaged.	Replace the needle.
		Needle facing and height.	The needle is incorrectly inserted.	Reinstall the needle correctly.
		Upper thread tension.	The tension is too tight.	Adjust the tension adequately.
		Lower thread tension.	The tension is too tight.	Adjust the tension adequately.
		Stroke of the thread take up spring.	The upper thread is loose.	Adjust the thread take-up spring.
3	The stitching is passed over.	Needle facing and height.	The needle is inserted incorrectly.	Reinstall the needle correctly.
		Needle.	Needle is bent or damaged.	Replace the needle.
		Threading.	Threading is incorrect	Re-thread the needle.
		Raised height of the needle bar.	Improper needle and rotary hook timing.	Adjust the operating time.
		Height of the needle bar.	Improper needle and rotary hook timing.	Adjust the operating time.
		Clearance between the needle and the hook.	Improper needle and rotary hook timing.	Adjust the operating time.
			Remains of the upper thread is too short.	Adjust it with the thread tension adjusting unit.
		Bobbin case spring for preventing additional rotation.	During the thread trimming, the bobbin rotates additionally. So, the bobbin thread coming from the bobbin case is too short to be raised up.	Change the spring for preventing the rotation.
		Thread take-up spring.	The tension of the thread take-up spring is too losse to raise up the bobbin thread.	Adjust the stroke of the thread take-up spring.

8 – SYNCHRONISER

8.1 Synchroniser (Figure 8.1)

When sewing is interrupted with trim signal the machine should first stop with the needle bar positioned about 4 mm past bottom dead centre, then proceed to trim and stop in take up lever up position.

1. Remove the protecting cap of the synchroniser.

2. Run one sewing cycle.

3. Holding the stopping disk by right hand, turn the hand wheel anti clockwise, until the needle reaches the highest position. Then, turn the hand wheel slightly, so that the thread take up lever is in its top position - hand-wheel is aligned with the green-mark.

4. Put the protecting cap back.

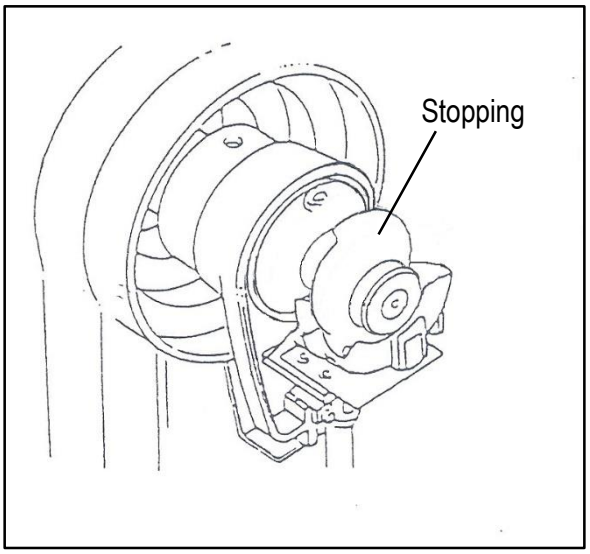

Figure 8.1

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Parameter list for machines AJ 84-72MS

EFKA MOTOR DRIVER: AB221A

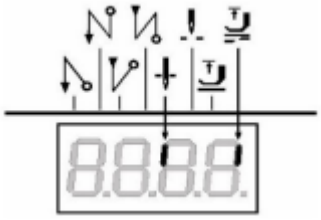
Parameter	Setting
290	00
272	1000 +/-1
401	1 Store the changed parameter value.

110	180
111	2600
153	03
161	1
180	005
181	010
182	1
202	200
204	020
207	8
208	8
213	40
219	5
220	5
225	8
240	16
270	3
780	150
781	500
782	500
783	1000
784	1000
401	1 Store the changed parameter values.

171	1. Sr2 Appears: Press 2. P1E Appears: Move the needle to the lowest position by hand-wheel and write down P1E value; Press **E** 3. P2E Appears: Move the needle to the topmost position by hand-wheel and write down P2E value; Press **E** 4. P1A Appears: Calculate the position P1A = P1E+60 and move the machine to this position by hand-wheel; Press **E** 5. P2A Appears: Calculate the position P2A = P2E+60 and move the machine to this position by hand-wheel; Press **E**
401	1 Store the changed parameter values.

Entering the Code Number:
Hold the **P** key and turn power on.
Technician code: **3112** Supplier code: 5913
Press the **P** key to exit programming mode

Setting Display:



Important!
To store the changed parameter values: Set parameter 401 to value 1. Press E or P.
All data are stored.
Use manual EFKA for more information!

MASTER RESET:
Password: 5913, parameter: 459 - set to: 3112

Programs Manufacturer Setting

Program 1

Nr.	Parameter	Values
1	Double Jig	OFF
6	K. DelayStart	ON
6a	Time ON/Tape	ON
6b	K. DelayTime	200
7	K. DelayEnd	ON
8	Dense into C	OFF
9	Sta Den.Tim	600
10	End Den.Tim	1000
11	Set Den. Sp	400
12	Slow Sew Sp	400
13	Needle DnSp	600
14	Max Sew Sp	2600
15	J.Flap Act.	ON
16	Sp to Corne	2600

Program 2

Nr.	Parameter	Values
1	Double Jig	ON
6	K. DelayStart	ON
6a	Time ON/Tape	ON
6b	K. DelayTime	200
7	K. DelayEnd	ON
8	Dense into C	OFF
9	Sta Den.Tim	600
10	End Den.Tim	1000
11	Set Den. Sp	400
12	Slow Sew Sp	400
13	Needle DnSp	600
14	Max Sew Sp	2600
15	J.Flap Act.	ON
16	Sp to Corne	2600

Program 3

Nr.	Parameter	Values
1	Double Jig	OFF
2	1Jig Corner	NeDN
3	2Jig Corner	NeDN
4	3Jig Corner	END?
5	4Jig Corner	END?
6	K. DelayStart	ON
6a	Time ON/Tape	ON
6b	K. DelayTime	200
7	K. DelayEnd	ON
8	Dense into C	OFF
9	Sta Den.Tim	600
10	End Den.Tim	1000
11	Set Den. Sp	400
12	Slow Sew Sp	400
13	Needle DnSp	600
14	Max Sew Sp	2600
15	J. Flap Act.	ON
16	Sp to Corne	2600

Program 4

Nr.	Parameter	Values
1	Double Jig	OFF
2	1Jig Corner	SISp
2a	1 C. Slow Sp	400
3	2Jig Corner	SISp
3a	2 C. Slow Sp	400
4	3Jig Corner	END?
5	4Jig Corner	END?
6	K. DelayStart	ON
6a	Time ON/Tape	ON
6b	K. DelayTime	200
7	K. DelayEnd	ON
8	Dense into C	OFF
9	Sta Den.Tim	600
10	End Den.Tim	1000
11	Set Den. Sp	400
12	Slow Sew Sp	400
13	Needle DnSp	600
14	Max Sew Sp	2600
15	J. Flap Act.	ON
16	Sp to Corne	2600
2a	1 C. Slow Sp	400

Program 5

Nr.	Parameter	Values
1	Double Jig	OFF
2	1Jig Corner	NeDN
3	2Jig Corner	END?
4	3Jig Corner	END?
5	4Jig Corner	END?
6	K. DelayStart	ON
6a	Time ON/Tape	ON
6b	K. DelayTime	200
7	K. DelayEnd	ON
8	Dense into C	OFF
9	Sta Den.Tim	600
10	End Den.Tim	1000
11	Set Den. Sp	400
12	Slow Sew Sp	400
13	Needle DnSp	600
14	Max Sew Sp	2600
15	J. Flap Act.	ON
16	Sp to Corne	2600

Program 6

Nr.	Parameter	Values
1	Double Jig	OFF
2	1Jig Corner	SISp
2a	1 C. Slow Sp	400
3	2Jig Corner	END?
4	3Jig Corner	END?
5	4Jig Corner	END?
6	K. DelayStart	ON
6a	Time ON/Tape	ON
6b	K. DelayTime	200
7	K. DelayEnd	ON
8	Dense into C	OFF
9	Sta Den.Tim	600
10	End Den.Tim	1000
11	Set Den. Sp	400
12	Slow Sew Sp	400
13	Needle DnSp	600
14	Max Sew Sp	2600
15	J. Flap Act.	ON
16	Sp to Corne	2600

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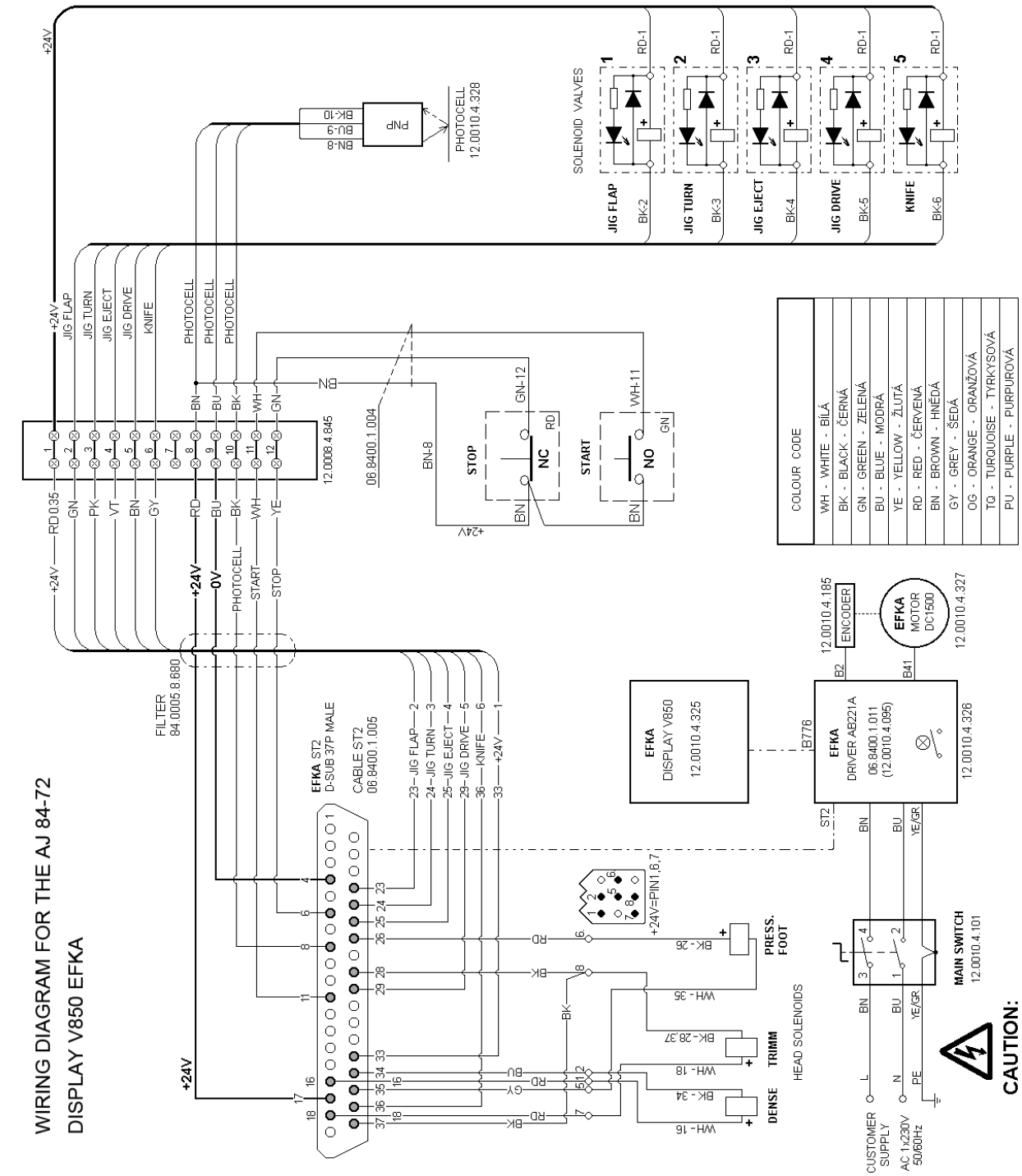
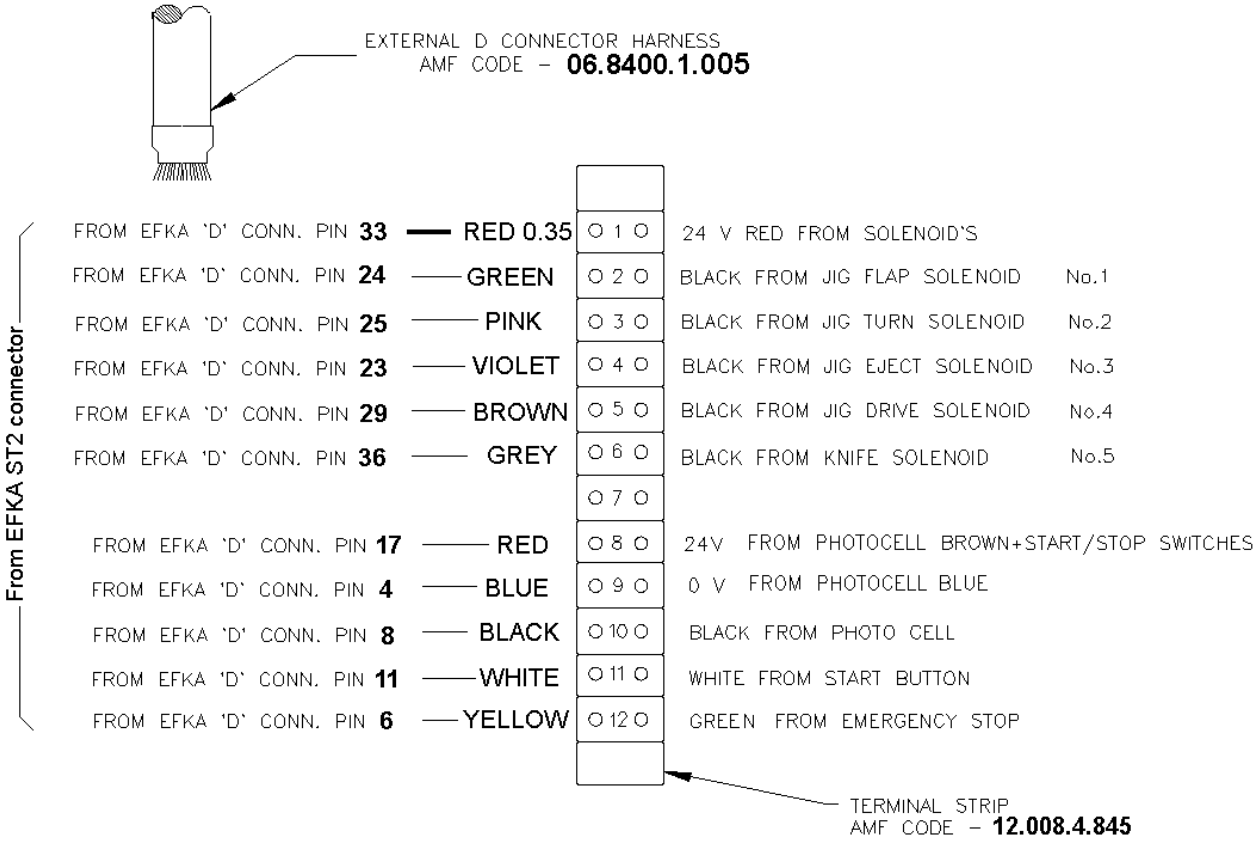
ST2 CABLE EXTERNAL CONNECTOR D-SUB 37P MALE 06.8400.0.0		
PIN D-SUB 37P/OL MALE NUMBER	SCREW CONNECTOR NUMBER	WIRE COLOUR
1	--	--
2	--	--
3	--	--
4	9	BU
5	--	--
6	12	YE
7	--	--
8	10	BK
9	--	--
10	--	--
11	11	WH
12	--	--
13	--	--
14	--	--
15	--	--
16	-◇-1	RD
17	8	RD
18	-◇-7	RD
19	--	--
20	--	--
21	--	--
22	--	--
23	2	GN
24	3	PK
25	4	VT
26	-◇-6	RD
27	--	--
28	-◇-8	BK
29	5	BN
30	--	--
31	--	--
32	--	--
33	1	RD 0.35
34	-◇-2	BU
35	-◇-5	GY
36	6	GY
37	-◇-8	BK





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TROUBLESHOOTING

Contents

1 Stitching....2-1
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3 Feed....2-4

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1 Stitching

FAULT	CAUSE	CORRECTION
Random thread breakage	Problem with thread path (including the throat plate and presser foot).	Remove burrs from thread path.
	Problem with the sewing hook.	Remove burrs, clean & polish. Check the hook point. Check the clearance between the hook and the bobbin case opener lever. Check lubrication.
	Thread is caught somewhere in the thread path.	Correct threading.
	Tension is wrong.	Adjust tension.
	Thread take-up spring misadjusted.	Adjust the take-up.
	Problem with needle.	Check or replace.
	Spool spin.	Fit friction washer.
	Material wrongly positioned in jig.	Ensure all stitching is in material.
	Jig damage.	Repair jig.
Skip stitching	Problem with the needle.	Check for needle damage and for correct needle orientation. Check that the needle size is correct for the thread being used.
	Problem with the sewing hook.	Check to see if the hook point is blunt or worn. Check the hook timing.
	Needle thread tension is too high.	Decrease the tension.
	Sewing head speed is too high.	Reduce the motor speed.
	Thread take-up spring misadjusted.	Adjust the take-up.
	Material flagging.	Check jig is clamping material. Check presser foot.
Short end on top or needle unthreads	Tension release mechanism.	Check that tension release is functioning properly.
	Under-bed moving knife or counter knife out of setting.	Reset trimming, section 7.

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TROUBLESHOOTING

FAULT	CAUSE	CORRECTION
Thread not trimmed	Thread catcher moved.	Reset synchronizer and trimming.
	Loose plug on solenoid lead.	Re-connect.
	Loose plug on synchronizer.	Re-connect.
	Synchronizer loose on handwheel.	Reset synchronizer, section 8.
	Sewing hook slipping last stitch.	Check to see if hook point is blunt or worn. Check hook timing.
	Blunt or misadjusted thread trimming knives.	Check knives.
Thread not picked up	Short end on spool thread due to "Spool Spin".	Increase the pressure of the bobbin case holder positioning finger. Increase the bobbin thread tension.
	The pressure of the bobbin case holder positioning finger is too high.	Decrease pressure of the finger, but check for "spool spin" - see above.
Spool thread picked up late after first few stitches	Short end on needle thread.	Correct as section 7.8.
	Short end on spool thread.	Correct as section 7.6.
First few stitches looped underneath	Foot lift cylinder sluggish on return.	Remove, clean and lubricate.

2 Machine Controls

FAULT	CAUSE	CORRECTION
Machine fails to start	Jig in wrong position.	Reset and return jig to machine correctly.
	Excessive cloth thickness jig.	
	Drop in air pressure.	Check 80 PSI (5.5 Bars) on gauge.
	Motor plug loose.	Re-connect.
	Synchronizer plug out.	Re-connect.
	Wire off start button.	Re-solder.
Machine fails to stop	No tape at end.	Add tape.
	Photo-cell missing tape.	Re-position tape.
	Photo-cell not clearing tape at end of jig.	Re-position tape.
Machine fails to position	Wrongly programmed Efka device.	See Section 8.
Machine runs slow	Photocell missed a signal from tape.	Check position of tape.

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3 Feed

FAULT	CAUSE	CORRECTION
Small stitches	Worn drive wheel.	Replace.
	Damaged jig.	Repair.
	Excessive foot pressure.	Reset to 1.5 - 2.0 kg.
Large stitches	Presser foot not in contact with jig.	Re-set presser bar, Section 7.9.
	Pressure foot pressure almost zero.	Re-set to 1.5 - 2.0 kg.
Dense stitch fails to operate	Feed lever adjustment bracket screw loose.	Re-set and tighten.
Large stitches on corner	Corner speed too slow.	Adjust speed by altering corner speed in AMF Reece controller, Section 5.
	Turn cylinder movement too fast.	Slow down through flow control.
Small stitches on corner	Corner speed too fast.	Adjust speed by altering corner speed in AMF Reece controller, Section 5.
	Turn cylinder movement too slow.	Speed up through flow control.
Irregular profile at corner	Needle down switch selection for round corner.	Switch to slow run position.
Jig fails to stitch slow at corners	No signal, check tape position.	Reset tape position, check photo-cell receiving signal.
Jig fails to stitch a sharp corner	Photo-cell faulty.	Replace.
	Sensitivity.	Re-set to sense black tape on jig.
	Wrong program selected.	Select correct program.

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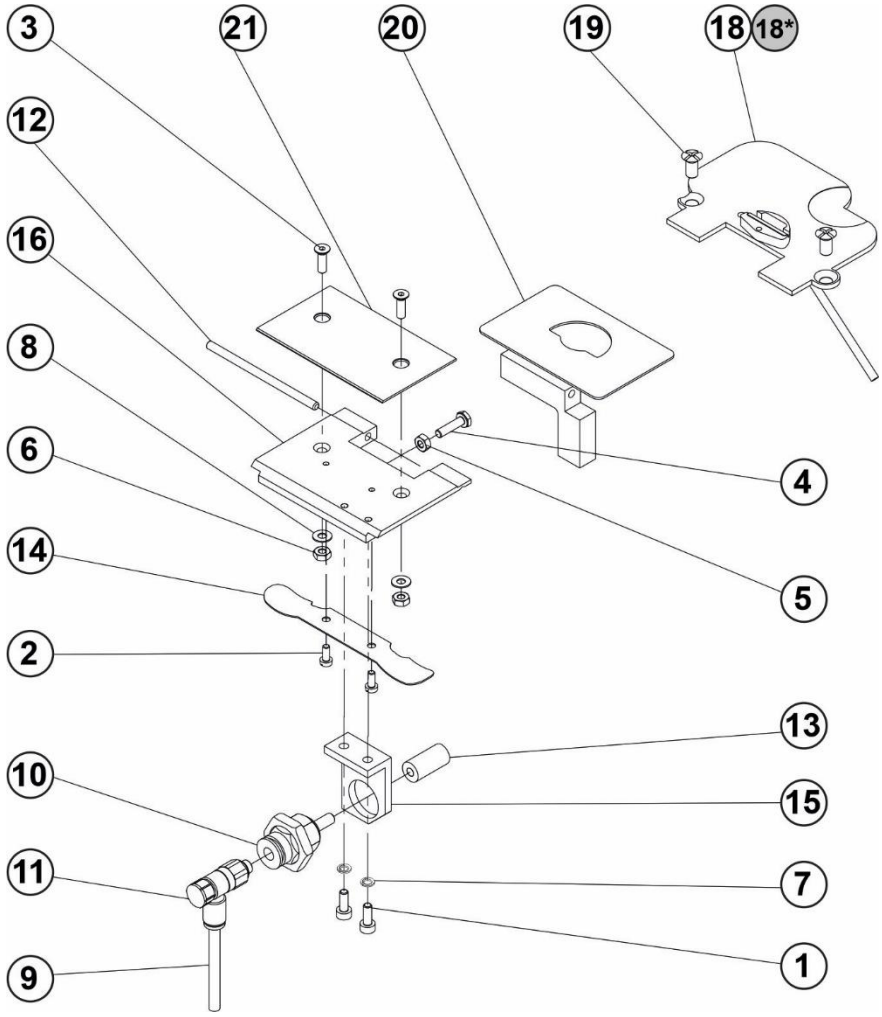
JIG FLAP



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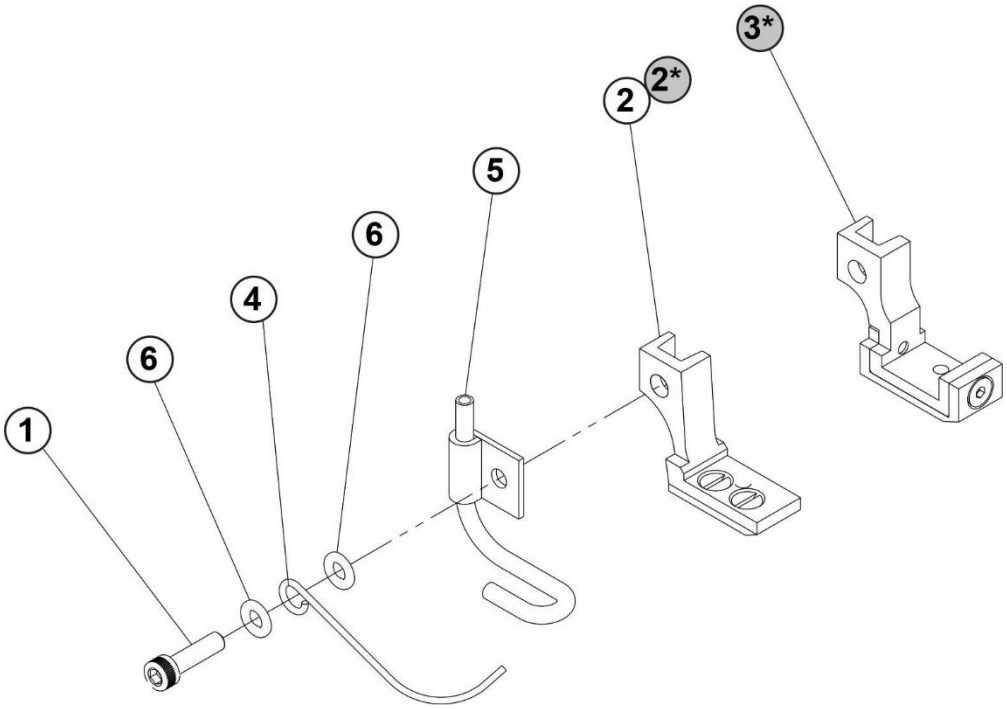
JIG FLAP

DET	PART NUMBER	DESCRIPTION	QTY.
01	08.6002.3.008	SCREW M3-8	2
02	08.6012.7.006	SCREW M2,5-6	2
03	08.6102.3.010	SCREW M3-10	2
04	08.6310.3.012	SCREW M3x12	1
05	08.6700.3.000	NUT M3	1
06	08.6702.3.000	NUT M3	2
07	08.6802.3.000	SPRING WASHER M3	2
08	08.6852.3.000	WASHER M3	2
09	12.0008.3.416	AIR TUBE- J1A	1
10	12.0008.3.732	CYLINDER	1
11	12.0010.3.113	SPEED CONTOLLER	1
12	84.0004.0.163	THROAT PLATE LOCATING PIN	1
13	84.0004.6.540	NYLON NOSE M4	1
14	84.0004.6.750	JIG FLAP SPRING	1
15	84.0004.6.755	JIG FLAP CYLINDER BRACKET	1
16	84.0005.7.010	EJECT SLIDE PLATE	1
18	84.0005.9.006	THROAT PLATE 3/16"	1
18*	84.0005.9.005	THROAT PLATE1/8" - EXTRA	1
18*	84.0005.9.007	THROAT PLATE1/4" - EXTRA	1
19	84.0005.9.016	SCREW W11/64-40	2
20	84.0005.9.040	JIG FLAP BRACKET	1
21	84.0005.9.050	JIG FLAP COVER PLATE	1

* EXTRA PARTS

PRESSER FOOT



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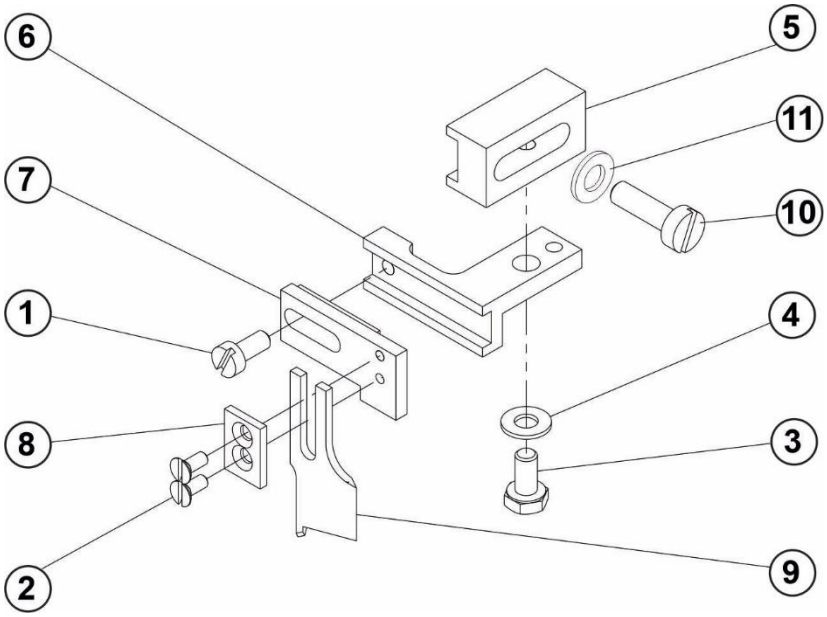
PRESSER FOOT

DET	PART NUMBER	DESCRIPTION	QTY.
01	08.7000.6.012	SCREW 6-40 X1/2 UNF IMBUS	1
02	84.0002.5.550	PRESSER FOOT 3/16"	1
02*	84.0002.6.640	PRESSER FOOT 1/8" - EXTRA	1
02*	84.0002.6.660	PRESSER FOOT 1/4" - EXTRA	1
03*	84.0002.5.552	PRESSER FOOT 3/16"- EXTRA	1
04	84.0002.5.702	FINGER GUARD	1
05	84.0005.7.120	FOOT BLOWER	2
06	7016003	WASHER FLAT, SAE No.5	

* EXTRA PARTS

KNIFE MECHANISM



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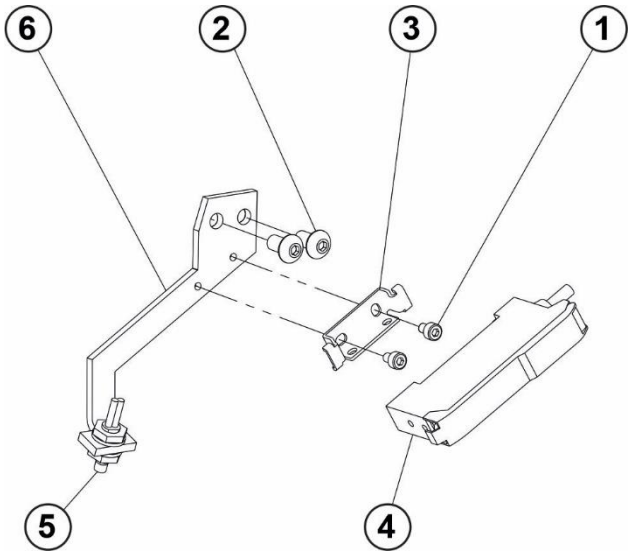
KNIFE MECHANISM

DET	PART NUMBER	DESCRIPTION	QTY.
01	08.6012.1.008	SCREW M 3,5x8	1
02	08.6112.7.006	SCREW M 2,5x6	2
03	08.6312.4.008	SCREW M 4-8	1
04	08.6852.4.000	WASHER M4	1
05	84.0005.9.164	ADJUSTABLE HOLDER BKT.	1
06	84.0005.9.166	SLIDE BLOCK	1
07	84.0005.9.171	ADAPTER	1
08	84.0005.9.172	CLAMP PLATE	1
09	84.0005.9.173	KNIFE 16 mm	1
10	84.0005.9.685	SCREW 11/64-40 x 15	1
11	08.6850.5.000	WASHER 5,3	1

PHOTOCELL



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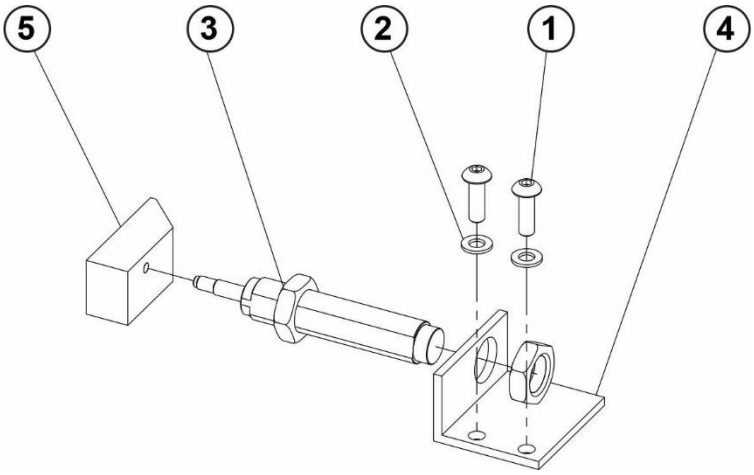
PHOTOCELL

DET	PART NUMBER	DESCRIPTION	QTY.
01	08.6000.3.005	SCREW M3-5	2
02	08.6200.5.010	SCREW M5-10	2
03	12.0010.4.256	MOUNTING BRACKET	1
04	12.0010.4.328	PHOTOCELL E3X-NA41 OMRON	1
05	84.0003.0.715	FIBER OPTIC SENSOR HEAD	1
06	84.0005.9.088	PHOTOCELL BRACKET-SUNSTAR	1

SNUBBER



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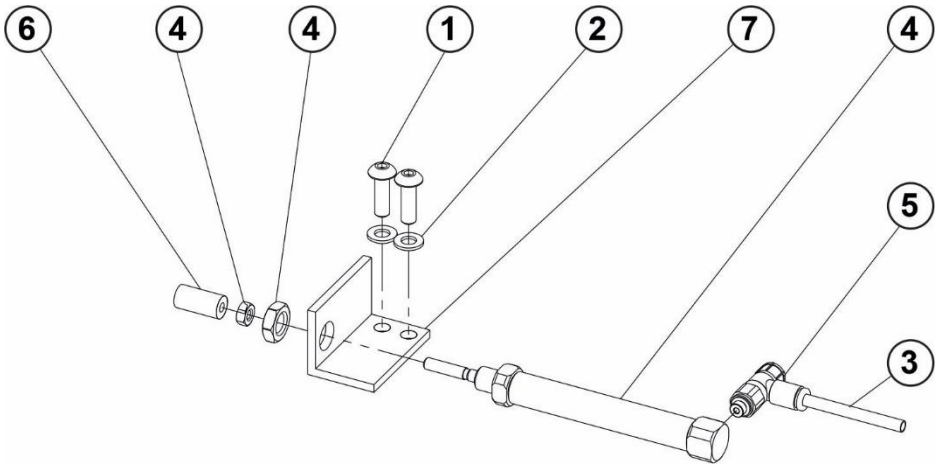
SNUBBER

DET	PART NUMBER	DESCRIPTION	QTY.
01	08.6200.5.012	SCREW M5-12	2
02	08.6852.5.000	WASHER 5,3	2
03	12.0008.3.650	SHOCK ABSORBER SMC RBC1412	1
04	84.0005.7.025	SUNSTAR EMS SNUBBER BKT	1
05	84.0005.7.037	SNUBBER BLOCK	1

JIG EJECT



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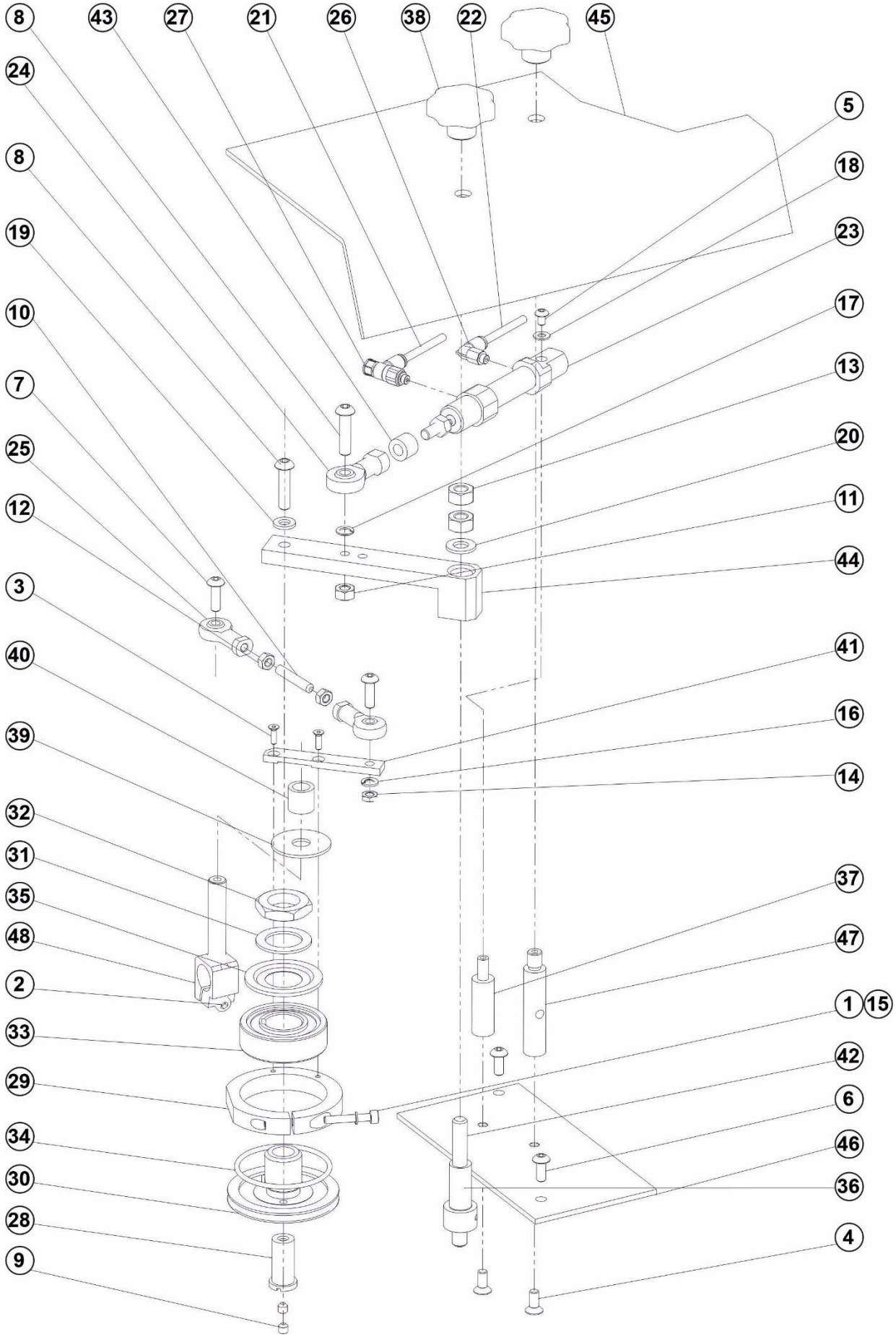
JIG EJECT

DET	PART NUMBER	DESCRIPTION	QTY.
01	08.6200.5.012	SCREW M5-12	2
02	08.6850.5.000	WASHER 5,3	2
03	12.0008.3.416	AIR TUBE- J3A	1
04	12.0008.3.705	CYLINDER	1
05	12.0010.3.113	SPEED CONTOLLER	1
06	84.0004.6.540	NYLON NOSE M4	1
07	84.0005.9.010	JIG EJECT BRKT	1

JIG DRIVE



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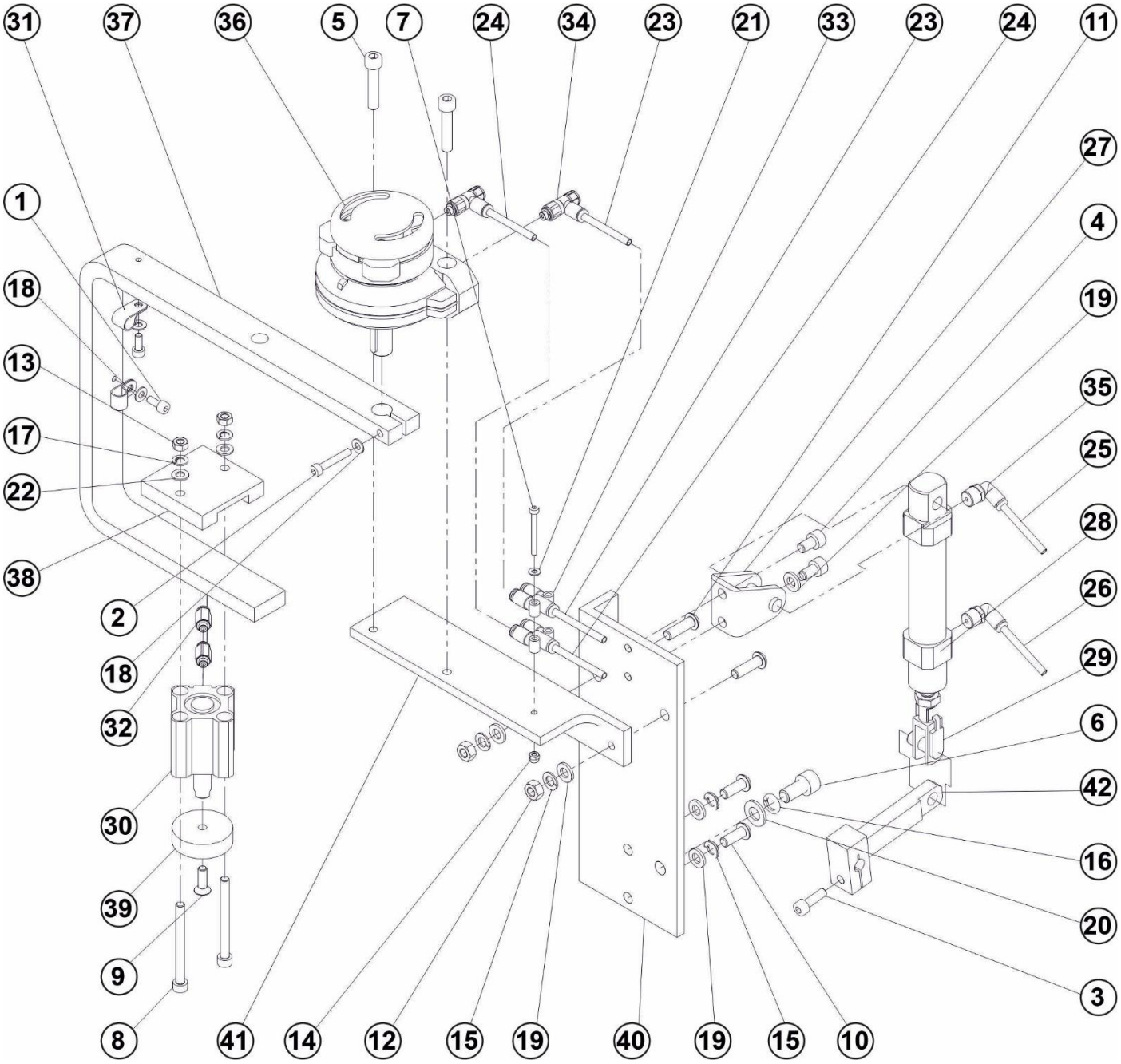
JIG DRIVE

DET	PART NUMBER	DESCRIPTION	QTY.
01	08.6000.4.025	SCREW M4-2C2:C385	1
02	08.6000.5.016	SCREW M5-16	1
03	08.6100.3.010	SCREW M3-10	2
04	08.6100.5.012	SCREW M5-12	2
05	08.6200.4.006	SCREW M4-6	1
06	08.6200.5.012	SCREW M5-12	2
07	08.6200.5.016	SCREW M5-16	2
08	08.6200.6.025	SCREW M6-25	2
09	08.6400.5.005	SCREW M5-5	2
10	08.6400.5.030	SCREW M5-30	1
11	08.6700.6.000	NUT M6	1
12	08.6702.5.000	NUT M5	2
13	08.6702.8.000	NUT M8	2
14	08.6710.5.000	NUT M5	1
15	08.6800.4.000	WASHER 4	1
16	08.6800.5.000	SPRING WASHER M5	1
17	08.6802.6.000	SPRING WASHER M6	1
18	08.6850.4.000	WASHER M4	1
19	08.6850.6.000	WASHER 6,4	1
20	08.6852.8.000	WASHER M8	1
21	12.0008.3.416	AIR TUBE- J4B	1
22	12.0008.3.416	AIR TUBE- J4A	1
23	12.0008.3.635	CYLINDER	1
24	12.0008.3.700	BEARING ROD END KJ6D	1
25	12.0008.3.701	ROD END	2
26	12.0010.3.028	CONNECTOR	1
27	12.0010.3.047	SPEED CONTR. AS1201F-M5-04A	1
28	84.0002.5.280	PIVOT SPINDLE	1
29	84.0002.5.290	FREE WHEEL HOUSING	1
30	84.0002.9.010	DRIVE WHEEL	1
31	84.0002.9.020	WASHER 20	1
32	84.0002.9.030	NUT M20	1
33	84.0002.9.070	ROLLER RAMP CLUTCHES	1
34	84.0002.9.125	O-RING	1
35	84.0002.9.126	DUST COVER	1
36	84.0003.0.511	MOUNTING ARM ECCENTRIC	1
37	84.0003.0.620	DRIVE CYLINDER STUD	1
38	84.0004.6.525	DRIVE COVER KNUBS	2
39	84.0004.6.530	WASHER	1
40	84.0004.6.535	ROUND NYLON SPACER	1
41	84.0004.6.920	DRIVE PLATE	1
42	84.0004.6.935	STUD	1
43	84.0004.7.090	JIG DRIVE CYL. SPACER	1
44	84.0004.8.085	DRIVE ARM	1
45	84.0005.7.055	DRIVE COVER 84-72M	1
46	84.0005.9.023	JIG DRIVE BASE PLATE	1
47	84.0005.9.110	COVER STUD	1
48	84.0005.9.140	BRACKET	1

TURN ARM



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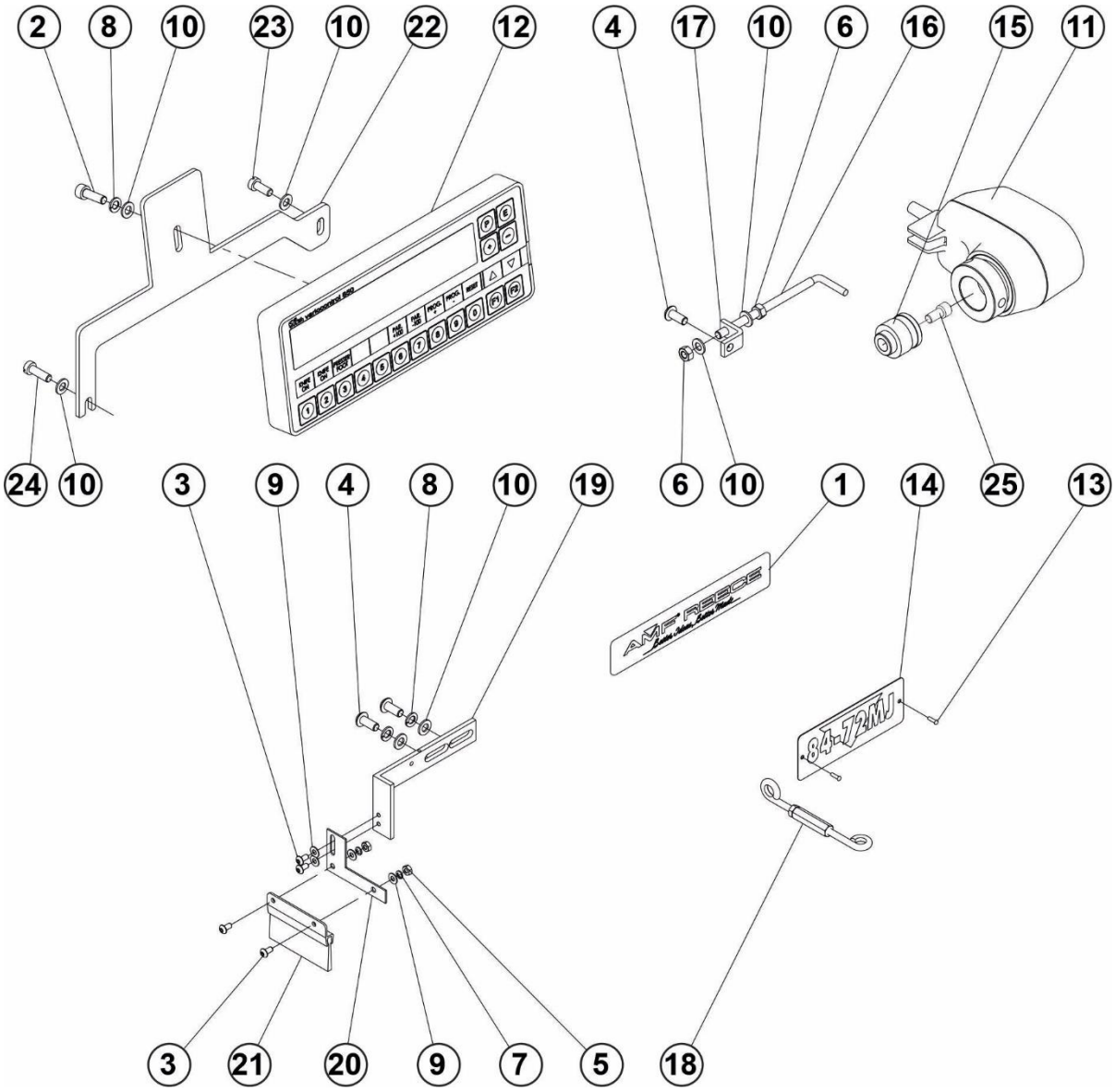
TURN ARM

DET	PART NUMBER	DESCRIPTION	QTY.
01	08.6000.4.010	SCREW M4-10	2
02	08.6000.4.025	SCREW M4-25	1
03	08.6000.5.016	SCREW M5-16	1
04	08.6000.6.010	SCREW M6-10	2
05	08.6000.6.030	SCREW M6-30	2
06	08.6000.8.016	SCREW M8-16	1
07	08.6002.3.030	SCREW M3-30	1
08	08.6002.5.055	SCREW M5-55	2
09	08.6102.5.016	SCREW M5-16	1
10	08.6200.6.016	SCREW M6-16	2
11	08.6202.6.020	SCREW M6-20	2
12	08.6700.6.000	NUT M6	2
13	08.6702.5.000	NUT M5	2
14	08.6733.3.000	NUT M3	1
15	08.6800.6.000	WASHER 6	4
16	08.6800.8.000	SPRING WASHER M8	1
17	08.6802.5.000	SPRING WASHER M5	2
18	08.6850.4.000	WASHER M4	3
19	08.6850.6.000	WASHER 6,4	5
20	08.6850.8.000	WASHER 8	1
21	08.6852.3.000	WASHER M3	1
22	08.6852.5.000	WASHER 5,3	2
23	12.0008.3.416	AIR TUBE- J2B	3
24	12.0008.3.416	AIR TUBE- J2A	3
25	12.0008.3.416	AIR TUBE- J5A	1
26	12.0008.3.416	AIR TUBE- J5B	1
27	12.0008.3.634	CYLINDER HOLDER	1
28	12.0008.3.654	CYLINDER C85N20-40	1
29	12.0008.3.673	CLEVIS GKM8-16	1
30	12.0008.3.706	CYLINDER CQ2B20-20D	1
31	12.0008.4.280	CLAMP CABLE UCF-1,5	2
32	12.0010.3.027	CONNECTOR KQ2H04-M5A	2
33	12.0010.3.037	CONNECTOR KQ2U04-00A	2
34	12.0010.3.047	SPEED CONTR. AS1201F-M5-04A	2
35	12.0010.3.090	CONNECTOR KQ2L04-01AS	2
36	84.0003.1.000	CYLINDER DSR-25-180P FESTO	1
37	84.0004.6.695	TURN ARM	1
38	84.0004.6.835	TURN ARM CYLINDER CLAMP	1
39	84.0004.6.840	TURN ARM CYLINDER NOSE	1
40	84.0005.9.011	TURN SUPPORT BRACKET	1
41	84.0005.9.012	OUTRIGGER TURNER	1
42	84.0005.9.013	KNIFE LEVER	1

HEAD



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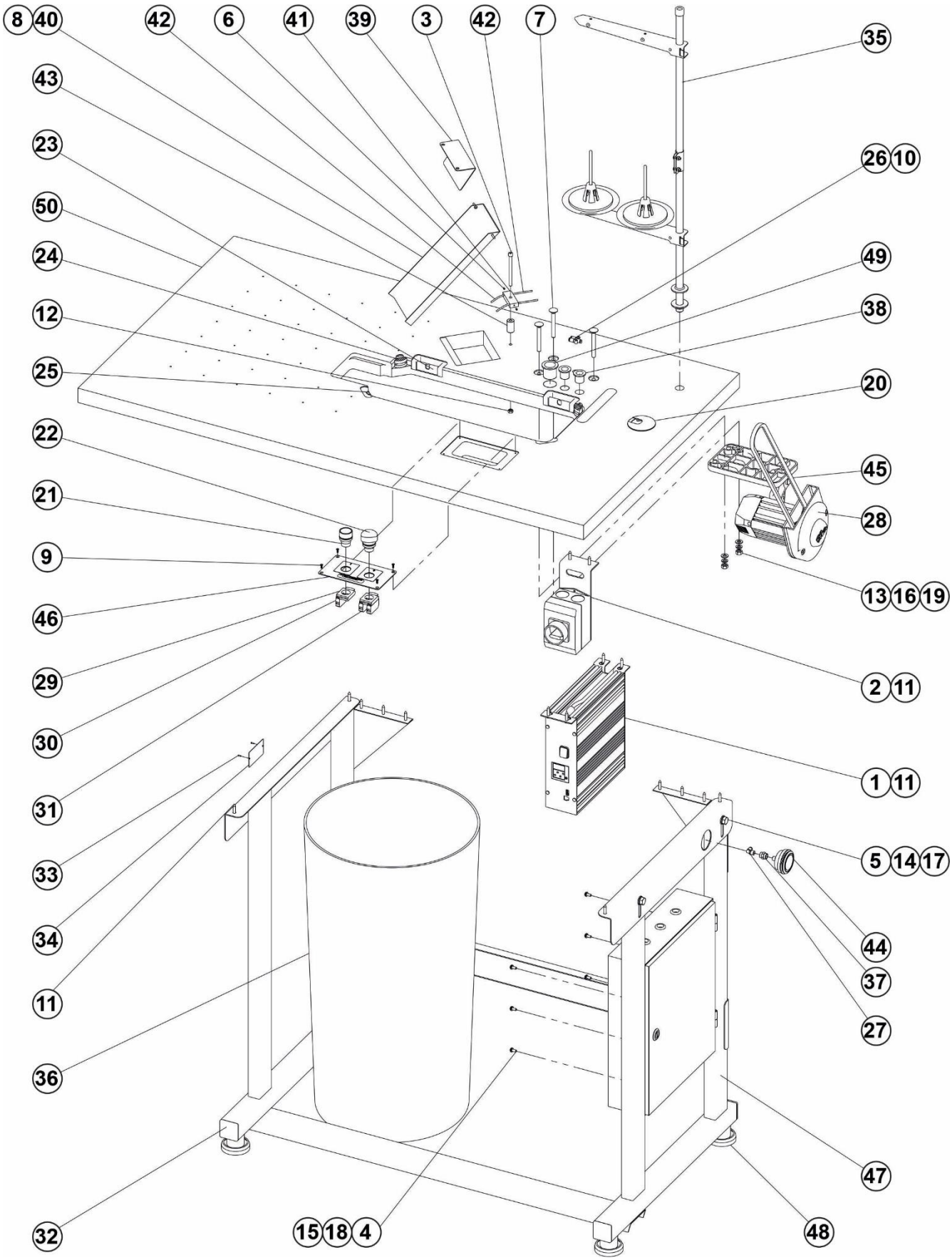
HEAD

DET	PART NUMBER	DESCRIPTION	QTY.
01	05.1396.0.000	LOGO ACRYL - AMF REECE	1
02	08.6002.5.016	SCREW M5-16	1
03	08.6202.3.006	SCREW M3-6	4
04	08.6202.5.012	SCREW M5x12	3
05	08.6702.3.000	NUT M3	2
06	08.6702.5.000	NUT M5	2
07	08.6802.3.000	SPRING WASHER M3	2
08	08.6802.5.000	SPRING WASHER M5	3
09	08.6852.3.000	WASHER M3	4
10	08.6852.5.000	WASHER 5,3	7
11	12.0010.4.185	SYNCHRONIZER EFKA	1
12	12.0010.4.325	DISPLAY EFKA V850	1
13	12.1016.0.002	NAIL 1.86x6.35 (1/4)	2
14	12.8000.1.026	LABEL AJ 84-72MJ	1
15	84.0005.7.020	SYNCHRONIZER SPIGOT	1
16	84.0005.7.035	SYNCHRONISER STABILISER ARM	1
17	84.0005.7.036	HOLDER	1
18	84.0005.7.076	ADJUSTING ROD	1
19	84.0005.9.170	ANTISTATIC BRUSH BRACKET	1
20	84.0005.9.175	EXTENSION BRACKET	1
21	84.0005.9.502	BRUSH (0,3-20mm)	1
22	84.0005.9.681	DISPLAY HOLDER - JUKI	1
23	84.0005.9.683	SCREW 3/16-28 x 12	1
24	84.0005.9.684	SCREW 3/16-28 x 15	1
25	08.7000.8.015	SCREW 5/16-24 x 5/8	1

TABLE TOP



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DET	PART NUMBER	DESCRIPTION	QTY.
01	06.8400.1.011	EFKA DRIVER_PROGRAMMED	1
02	06.8400.2.012	SWITCH ASSY.	1
03	08.6000.6.080	SCREW M6-80	1
04	08.6202.5.012	SCREW M5x12	6
05	08.6312.0.020	SCREW M10x20	12
06	08.6400.3.005	SCREW M3-5	2
07	08.6532.8.070	SCREW M8-70	3
08	08.6632.3.020	SCREW 3,5x19	2
09	08.6646.3.016	VRUT 3-16 ZAP. HLAVA	4
10	08.6652.3.016	SCREW ST3,5-16	1
11	08.6663.5.025	SCREW 4,8-25	16
12	08.6700.6.000	NUT M6	1
13	08.6702.8.000	NUT M8	3
14	08.6802.0.000	SPRING WASHER M10	12
15	08.6802.5.000	SPRING WASHER M5	6
16	08.6802.8.000	SPRING WASHER M8	3
17	08.6852.0.000	WASHER 10,5	12
18	08.6852.5.000	WASHER 5,3	6
19	08.6852.8.000	WASHER M8	3
20	12.0008.6.830	PLUG HOLE 50mm	1
21	12.0008.4.583	EMERGENCY STOP	1
22	12.0008.4.584	EMERGENCY STOP	1
23	12.0008.6.831	RUBBER HINGE	2
24	12.0008.6.832	RUBBER SPRING - REAR	2
25	12.0008.6.833	RUBBER SPRING - FRONT	2
26	12.0010.3.037	CONNECTOR KQ2U04-00A	1
27	12.0010.3.090	CONNECTOR KQ2L04-01AS	1
28	12.0010.4.095	MOTOR EFKA DC1500 - SET	1
29	12.0010.4.098	CLIP BACO	2
30	12.0010.4.099	CONTACT BLOCK NO	1
31	12.0010.4.102	CONTACT BLOCK NC	2
32	12.0010.6.932	PLUG	4
33	12.1016.0.002	NAIL 1.86x6.35 (1/4) BN 896	2
34	12.8000.1.031	LABEL CE AUTOJIG	1
35	12.9900.9.005	THREAD STAND ASSY.JUKI 2-THREAD	1
36	84.0002.0.380	WASTE BIN	1
37	84.0002.0.727	CONNECTOR MU-18-I	1
38	84.0002.5.490	SPARES FLANGET BUSH SKIFFY	2
39	84.0004.6.655	WASTE CHUTE EDGE PIECE	1
40	84.0004.6.660	WASTE CHUTE	1

TABLE TOP

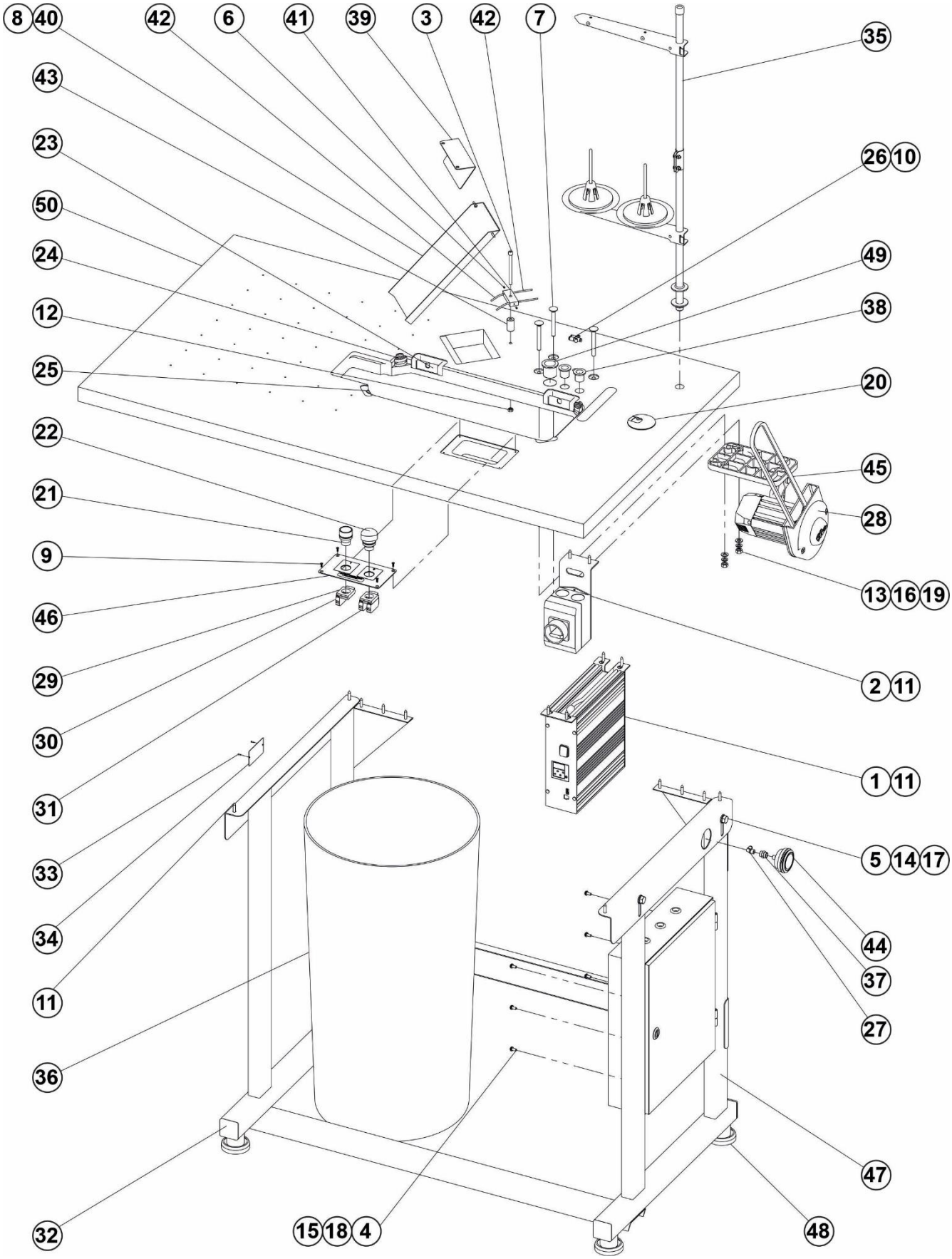

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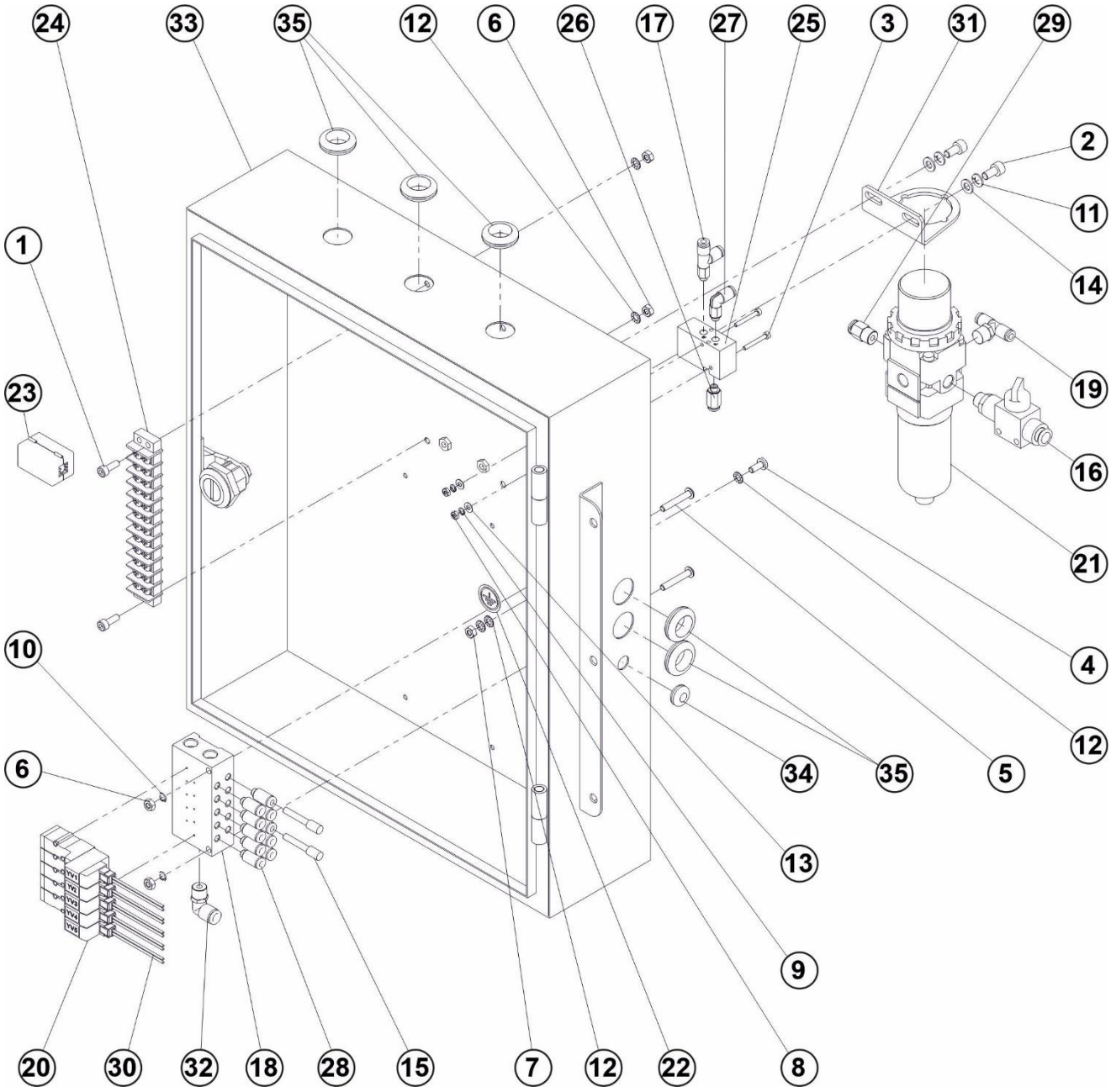
TABLE TOP

DET	PART NUMBER	DESCRIPTION	QTY.
41	84.0004.6.680	BLOWER SPACER	1
42	84.0004.6.685	WASTE BLOWER	2
43	84.0004.6.790	BLOWER SPACER	1
44	84.0004.6.865	PRESSURE GAUGES	1
45	84.0004.7.150	BELT SPZ 9,5x1075La	1
46	84.0004.8.455	STOP, START LEGEND PLATE	1
47	84.0005.7.095	FRAME	1
48	84.0005.7.096	See 3-27	
49	84.0005.7.135	SLIDE BEARING	1
50	84.0005.7.145	TABLE TOP AJ84-72 MS	1

ELECTRICAL BOX



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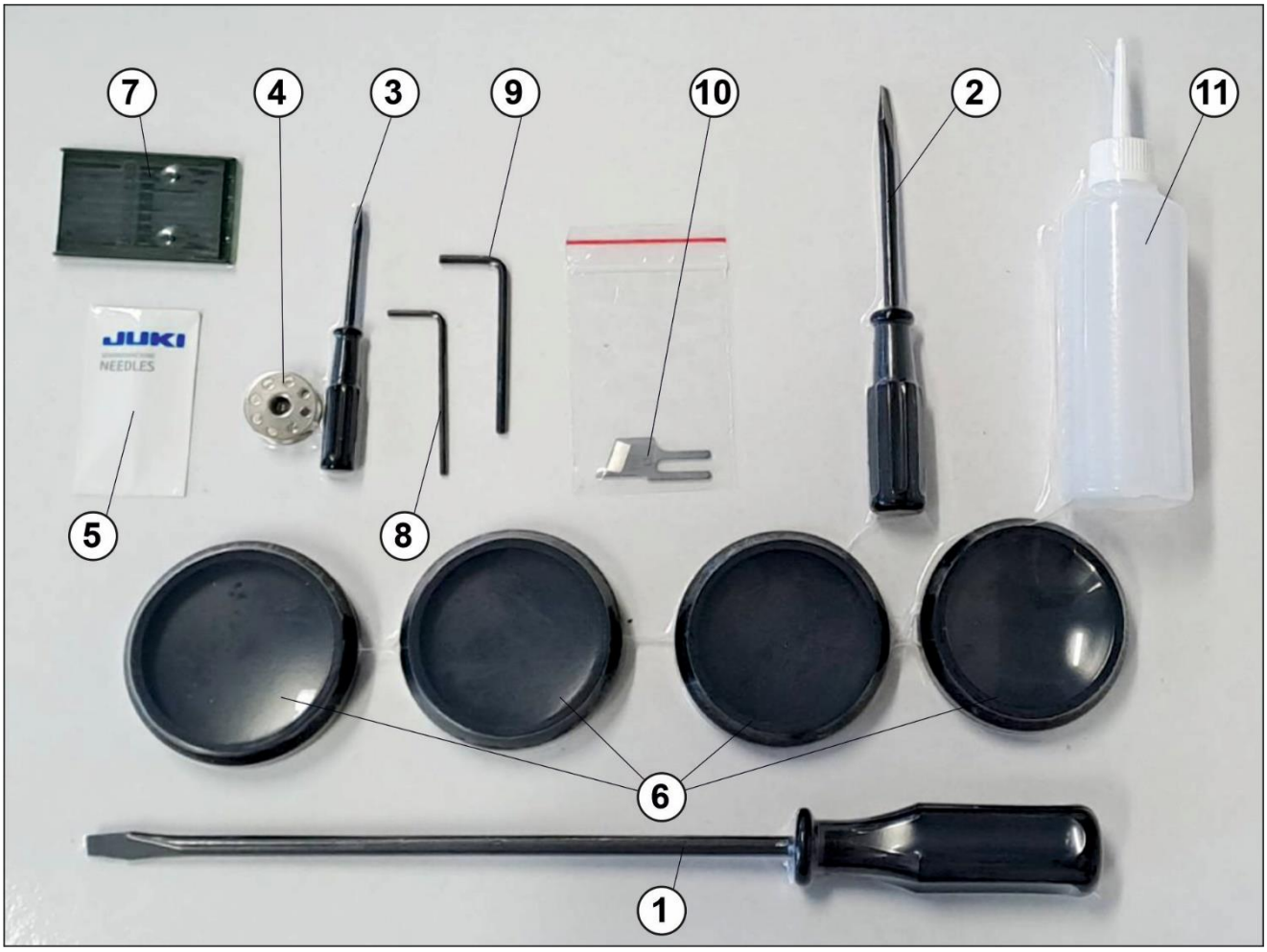
ELECTRICAL BOX

DET	PART NUMBER	DESCRIPTION	QTY.
01	08.6000.4.012	SCREW M4-12	2
02	08.6000.5.010	SCREW M5-10	2
03	08.6002.7.020	SCREW M2,5-20	2
04	08.6032.4.010	SCREW M4-10	1
05	08.6200.4.025	SCREW M4-25	2
06	08.6700.4.000	NUT M4	4
07	08.6702.4.000	NUT M4	1
08	08.6702.7.000	NUT M2,5	2
09	08.6800.3.000	WASHER 3	2
10	08.6800.4.000	WASHER 4	2
11	08.6800.5.000	SPRING WASHER M5	2
12	08.6832.4.000	WASHER M4	5
13	08.6850.3.000	WASHER 3,2	2
14	08.6850.5.000	WASHER 5,3	2
15	12.0008.3.426	PLUG KQ2P-04	2
16	12.0008.3.463	HAND VALVE VHK3-08F-01S	1
17	12.0008.3.472	CONNECTOR "Y"	1
18	12.0008.3.619	MANIFOILD PLATE SS5YJ3-S41-05-M5F-Q	1
19	12.0008.3.639	CONNECTOR "T"	1
20	12.0008.3.646	5/2 VALVE	5
21	12.0008.3.658	FILTER/REGULATOR AW20-F01CH-A	1
22	12.0008.4.052	LABEL GROUND	1
23	12.0008.4.745	FERIT CORE	1
24	12.0008.4.845	TERMINAL STRIP	1
25	12.0010.3.017	VALVE SYJA512-M5	1
26	12.0010.3.027	CONNECTOR KQ2H04-M5A	1
27	12.0010.3.028	CONNECTOR KQ2L04-M5A	1
28	12.0010.3.089	CONNECTOR KQ2S04-M5A	10
29	12.0010.3.097	CONNECTOR KQ2H06-01AS	1
30	12.0010.3.108	CABLE SY100-30-4A-20	5
31	12.0010.3.138	REGULATOR BRACKET AR22P-270AS	1
32	12.0010.3.172	CONNECTOR KQ2L06-01AS	1
33	84.0005.7.110	ELECTRICAL BOX	1
34	84.0005.8.625	RUBBER GROMMET 6,4	1
35	84.0005.8.627	RUBBER GROMMET 15,5	5

ACCESSORIES



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DET	PART NUMBER	DESCRIPTION	QTY.
01		Are delivered with JUKI HEAD 84.0005.9.022.	
02			
03			
04			
05			
06	84.0006.7.096	Frame rubber	4
07	84.0003.0.220	Needle	
07	12.0008.6.968	Box	1
08	12.0008.6.100	Key	1
09	84.0010.9.830	Key	1
10	84.0005.9.173	Knife	1
11	05.1322.0.000	Oiler	1

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PART NUMBER	PAGE	DET	QTY	PART NUMBER	PAGE	DET	QTY	PART NUMBER	PAGE	DET	QTY
7016003	3-5	6	0	08.6312.4.008	3-7	3	1	08.6850.5.000	3-13	2	2
05.1322.0.000	3-27	11	1	08.6400.3.005	3-21	6	2	08.6850.5.000	3-25	14	2
05.1396.0.000	3-19	1	1	08.6400.5.005	3-15	9	2	08.6850.6.000	3-15	19	1
06.8400.1.011	3-21	1	1	08.6400.5.030	3-15	10	1	08.6850.6.000	3-17	19	5
06.8400.2.012	3-21	2	1	08.6532.8.070	3-21	7	3	08.6850.8.000	3-17	20	1
08.6000.3.005	3-9	1	2	08.6632.3.020	3-21	8	2	08.6852.0.000	3-21	17	12
08.6000.4.010	3-17	1	2	08.6646.3.016	3-21	9	4	08.6852.3.000	3-3	8	2
08.6000.4.012	3-25	1	2	08.6652.3.016	3-21	10	1	08.6852.3.000	3-17	21	1
08.6000.4.025	3-15	1	1	08.6663.5.025	3-21	11	16	08.6852.3.000	3-19	9	4
08.6000.4.025	3-17	2	1	08.6700.3.000	3-3	5	1	08.6852.4.000	3-7	4	1
08.6000.5.010	3-25	2	2	08.6700.4.000	3-25	6	4	08.6852.5.000	3-11	2	2
08.6000.5.016	3-15	2	1	08.6700.6.000	3-15	11	1	08.6852.5.000	3-17	22	2
08.6000.5.016	3-17	3	1	08.6700.6.000	3-17	12	2	08.6852.5.000	3-19	10	7
08.6000.6.010	3-17	4	2	08.6700.6.000	3-21	12	1	08.6852.5.000	3-21	18	6
08.6000.6.030	3-17	5	2	08.6702.3.000	3-3	6	2	08.6852.8.000	3-15	20	1
08.6000.6.080	3-21	3	1	08.6702.3.000	3-19	5	2	08.6852.8.000	3-21	19	3
08.6000.8.016	3-17	6	1	08.6702.4.000	3-25	7	1	08.7000.6.012	3-5	1	1
08.6002.3.008	3-3	1	2	08.6702.5.000	3-15	12	2	08.7000.8.015	3-19	25	1
08.6002.3.030	3-17	7	1	08.6702.5.000	3-17	13	2	12.0008.3.416	3-3	9	1
08.6002.5.016	3-19	2	1	08.6702.5.000	3-19	6	2	12.0008.3.416	3-13	3	1
08.6002.5.055	3-17	8	2	08.6702.7.000	3-25	8	2	12.0008.3.416	3-15	21	1
08.6002.7.020	3-25	3	2	08.6702.8.000	3-15	13	2	12.0008.3.416	3-15	22	1
08.6012.1.008	3-7	1	1	08.6702.8.000	3-21	13	3	12.0008.3.416	3-17	23	3
08.6012.7.006	3-3	2	2	08.6710.5.000	3-15	14	1	12.0008.3.416	3-17	24	3
08.6032.4.010	3-25	4	1	08.6733.3.000	3-17	14	1	12.0008.3.416	3-17	25	1
08.6100.3.010	3-15	3	2	08.6800.3.000	3-25	9	2	12.0008.3.416	3-17	26	1
08.6100.5.012	3-15	4	2	08.6800.4.000	3-15	15	1	12.0008.3.426	3-25	15	2
08.6102.3.010	3-3	3	2	08.6800.4.000	3-25	10	2	12.0008.3.463	3-25	16	1
08.6102.5.016	3-17	9	1	08.6800.5.000	3-15	16	1	12.0008.3.472	3-25	17	1
08.6112.7.006	3-7	2	2	08.6800.5.000	3-25	11	2	12.0008.3.619	3-25	18	1
08.6200.4.006	3-15	5	1	08.6800.6.000	3-17	15	4	12.0008.3.634	3-17	27	1
08.6200.4.025	3-25	5	2	08.6800.8.000	3-17	16	1	12.0008.3.635	3-15	23	1
08.6200.5.010	3-9	2	2	08.6802.0.000	3-21	14	12	12.0008.3.639	3-25	19	1
08.6200.5.012	3-11	1	2	08.6802.3.000	3-3	7	2	12.0008.3.646	3-25	20	5
08.6200.5.012	3-13	1	2	08.6802.3.000	3-19	7	2	12.0008.3.650	3-11	3	1
08.6200.5.012	3-15	6	2	08.6802.5.000	3-17	17	2	12.0008.3.654	3-17	28	1
08.6200.5.016	3-15	7	2	08.6802.5.000	3-19	8	3	12.0008.3.658	3-25	21	1
08.6200.6.016	3-17	10	2	08.6802.5.000	3-21	15	6	12.0008.3.673	3-17	29	1
08.6200.6.025	3-15	8	2	08.6802.6.000	3-15	17	1	12.0008.3.700	3-15	24	1
08.6202.3.006	3-19	3	4	08.6802.8.000	3-21	16	3	12.0008.3.701	3-15	25	2
08.6202.5.012	3-19	4	3	08.6832.4.000	3-25	12	5	12.0008.3.705	3-13	4	1
08.6202.5.012	3-21	4	6	08.6850.3.000	3-25	13	2	12.0008.3.706	3-17	30	1
08.6202.6.020	3-17	11	2	08.6850.4.000	3-15	18	1	12.0008.3.732	3-3	10	1
08.6310.3.012	3-3	4	1	08.6850.4.000	3-17	18	3	12.0008.4.052	3-25	22	1
08.6312.0.020	3-21	5	12	08.6850.5.000	3-7	11	1	12.0008.4.280	3-17	31	2

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12.0008.4.583	3-21	21	1	84.0002.5.290	3-15	29	1	84.0005.7.036	3-19	17	1
12.0008.4.584	3-21	22	1	84.0002.5.490	3-21	38	2	84.0005.7.037	3-11	5	1
12.0008.4.745	3-25	23	1	84.0002.5.550	3-5	2	1	84.0005.7.055	3-15	45	1
12.0008.4.845	3-25	24	1	84.0002.5.552	3-5	03*	1	84.0005.7.076	3-19	18	1
12.0008.6.100	3-27	8	1	84.0002.5.702	3-5	4	1	84.0005.7.095	3-23	47	1
12.0008.6.830	3-21	20	1	84.0002.6.640	3-5	02*	1	84.0005.7.096	3-23	48	4
12.0008.6.831	3-21	23	2	84.0002.6.660	3-5	02*	1	84.0005.7.110	3-25	33	1
12.0008.6.832	3-21	24	2	84.0002.9.010	3-15	30	1	84.0005.7.120	3-5	5	2
12.0008.6.833	3-21	25	2	84.0002.9.020	3-15	31	1	84.0005.7.135	3-23	49	1
12.0008.6.968	3-27	7	1	84.0002.9.030	3-15	32	1	84.0005.7.145	3-23	50	1
12.0010.3.017	3-25	25	1	84.0002.9.070	3-15	33	1	84.0005.8.625	3-25	34	1
12.0010.3.027	3-17	32	2	84.0002.9.125	3-15	34	1	84.0005.8.627	3-25	35	5
12.0010.3.027	3-25	26	1	84.0002.9.126	3-15	35	1	84.0005.9.005	3-3	18*	1
12.0010.3.028	3-15	26	1	84.0003.0.220	3-27	7	0	84.0005.9.006	3-3	18	1
12.0010.3.028	3-25	27	1	84.0003.0.511	3-15	36	1	84.0005.9.007	3-3	18*	1
12.0010.3.037	3-17	33	2	84.0003.0.620	3-15	37	1	84.0005.9.010	3-13	7	1
12.0010.3.037	3-21	26	1	84.0003.0.715	3-9	5	1	84.0005.9.011	3-17	40	1
12.0010.3.047	3-15	27	1	84.0003.1.000	3-17	36	1	84.0005.9.012	3-17	41	1
12.0010.3.047	3-17	34	2	84.0004.0.163	3-3	12	1	84.0005.9.013	3-17	42	1
12.0010.3.089	3-25	28	10	84.0004.6.525	3-15	38	2	84.0005.9.016	3-3	19	2
12.0010.3.090	3-17	35	2	84.0004.6.530	3-15	39	1	84.0005.9.023	3-15	46	1
12.0010.3.090	3-21	27	1	84.0004.6.535	3-15	40	1	84.0005.9.040	3-3	20	1
12.0010.3.097	3-25	29	1	84.0004.6.540	3-3	13	1	84.0005.9.050	3-3	21	1
12.0010.3.108	3-25	30	5	84.0004.6.540	3-13	6	1	84.0005.9.088	3-9	6	1
12.0010.3.113	3-3	11	1	84.0004.6.655	3-21	39	1	84.0005.9.110	3-15	47	1
12.0010.3.113	3-13	5	1	84.0004.6.660	3-21	40	1	84.0005.9.140	3-15	48	1
12.0010.3.138	3-25	31	1	84.0004.6.680	3-23	41	1	84.0005.9.164	3-7	5	1
12.0010.3.172	3-25	32	1	84.0004.6.685	3-23	42	2	84.0005.9.166	3-7	6	1
12.0010.4.095	3-21	28	1	84.0004.6.695	3-17	37	1	84.0005.9.170	3-19	19	1
12.0010.4.098	3-21	29	2	84.0004.6.750	3-3	14	1	84.0005.9.171	3-7	7	1
12.0010.4.099	3-21	30	1	84.0004.6.755	3-3	15	1	84.0005.9.172	3-7	8	1
12.0010.4.102	3-21	31	2	84.0004.6.790	3-23	43	1	84.0005.9.173	3-7	9	1
12.0010.4.185	3-19	11	1	84.0004.6.835	3-17	38	1	84.0005.9.173	3-27	10	1
12.0010.4.256	3-9	3	1	84.0004.6.840	3-17	39	1	84.0005.9.175	3-19	20	1
12.0010.4.325	3-19	12	1	84.0004.6.865	3-23	44	1	84.0005.9.502	3-19	21	1
12.0010.4.328	3-9	4	1	84.0004.6.920	3-15	41	1	84.0005.9.681	3-19	22	1
12.0010.6.932	3-21	32	4	84.0004.6.935	3-15	42	1	84.0005.9.683	3-19	23	1
12.1016.0.002	3-19	13	2	84.0004.7.090	3-15	43	1	84.0005.9.684	3-19	24	1
12.1016.0.002	3-21	33	2	84.0004.7.150	3-23	45	1	84.0005.9.685	3-7	10	1
12.8000.1.026	3-19	14	1	84.0004.8.085	3-15	44	1	84.0006.7.096	3-27	6	4
12.8000.1.031	3-21	34	1	84.0004.8.455	3-23	46	1	84.0010.9.830	3-27	9	1
12.9900.9.005	3-21	35	1	84.0005.7.010	3-3	16	1				
84.0002.0.380	3-21	36	1	84.0005.7.020	3-19	15	1				
84.0002.0.727	3-21	37	1	84.0005.7.025	3-11	4	1				
84.0002.5.280	3-15	28	1	84.0005.7.035	3-19	16	1				

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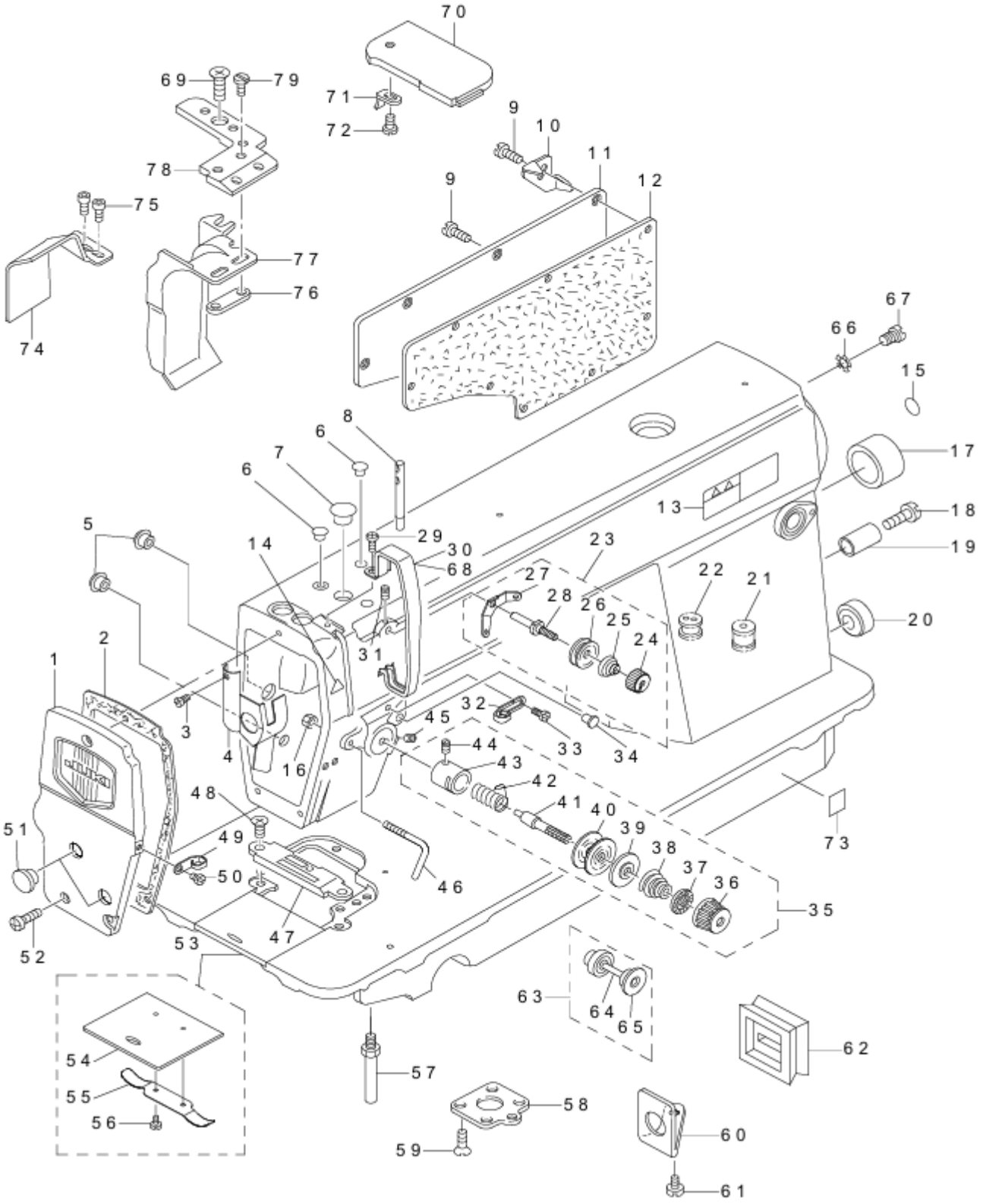
1. MACHINE FRAME & MISCELLANEOUS COVER COMPONENTS
頭部・外装関係



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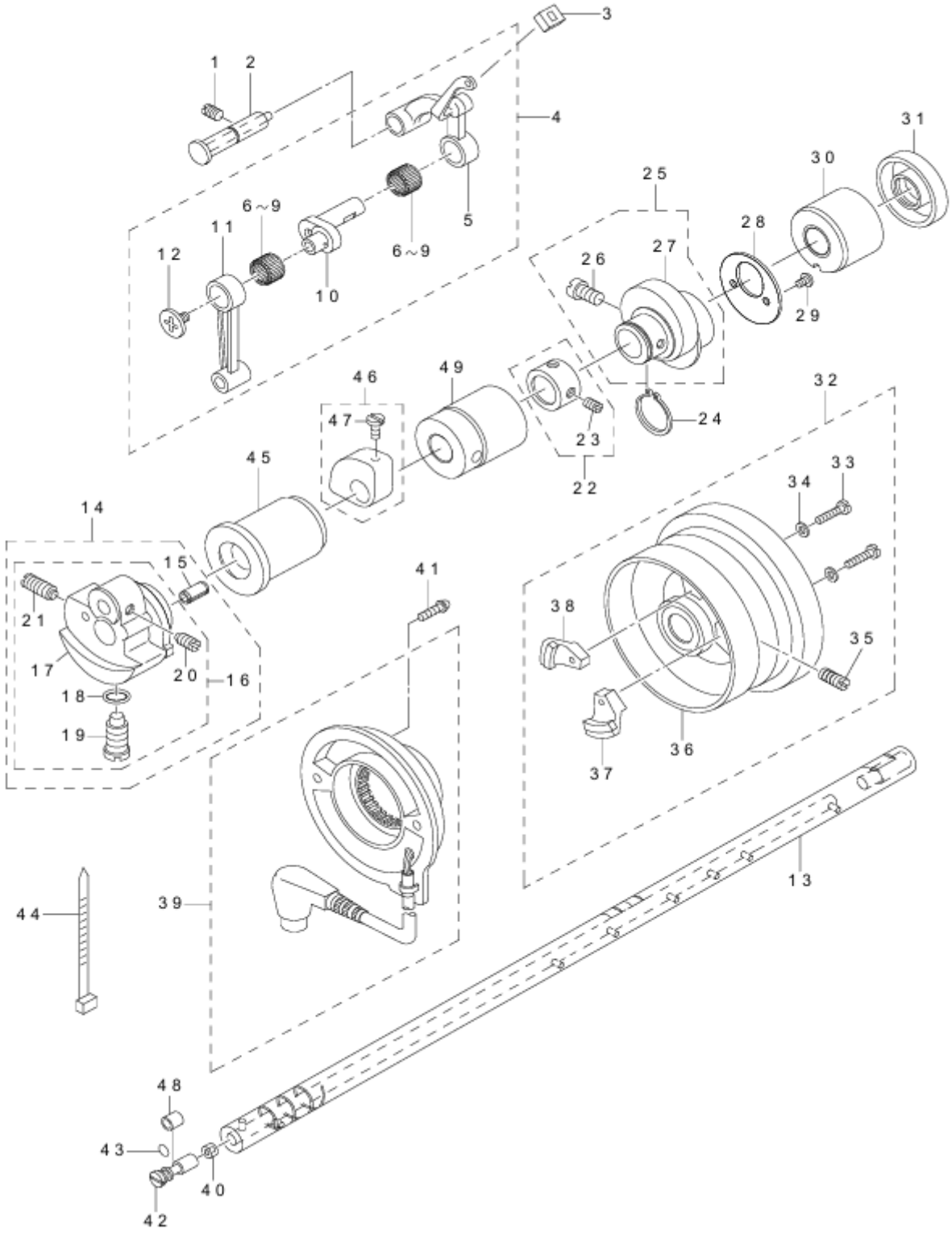
REF.NO		NOTE	PART NO	DESCRIPTION
1			113-25750	FACE PLATE ASM.
2			113-00506	FACE PLATE GASKET
3			SS-6080410-SP	SCREW 1/8-44 L=4
4			229-00757	FACE PLATE OIL SHIELD ASM.
5			TA-1250504-R0	RUBBER PLUG
6			TA-0850604-R0	RUBBER PLUG
7			TA-1250705-R0	RUBBER PLUG
8			229-58300	NEEDLE THREAD GUIDE PIN
9			SS-4120915-SP	SCREW 3/16-28 L=9
10		#01	111-02605	CORD HOLDER
11			229-00401	WINDOW PLATE
12			110-03308	GASKET
13			CM-3013000-01	SAFETY LABEL
14			CM-3002000-01	ATTENTION SEAL
15			229-01805	GROUND MARK
16			NS-6090310-SP	NUT 9/64-40
17			TA-2000502-R0	RUBBER PLUG
18		#01	SS-6121840-SP	SCREW 3/16-28 L=18
19		#01	111-00500	REVERSE FEED LEVER STOPPER
20			TA-2101002-R0	RUBBER PLUG
21		#03	110-30202	RUBBER BUSHING
22		#01	111-00104	MAGNET CORD RUBBER
23			229-45463	THREAD TENSION ASM. NO.1
24			229-45703	THREAD TENSION NUT
25			229-45505	THREAD TENSION SPRING
26			229-45802	THREAD TENSION DISK
27			229-45604	THREAD TENSION GUIDE
28			229-45406	THREAD TENSION POST
29			SS-4120615-SP	SCREW 3/16-28 L=6
30			229-00609	THREAD TAKE-UP LEVER COVER
31			SS-4120615-SP	SCREW 3/16-28 L=6
32			229-20508	ARM THREAD GUIDE A
33			229-21001	SCREW
34			TA-0850604-R0	RUBBER PLUG
35			229-45356	THREAD TENSION ASM.
36	*		229-21308	THREAD TENSION NUT
37	*		229-21407	ROTATION STOPPER
38	*		229-21704	THREAD TENSION SPRING A
39	*		229-21803	DISK STOPPER
40	*		229-21506	THREAD TENSION DISK
41	*		229-21209	THREAD TENSION POST
42	*		229-21605	THREAD TAKE-UP SPRING
43	*		229-45307	THREAD TENSION POST BASE
44			SS-8090670-SP	SCREW 9/64-40 L= 5.5
45			SS-8150710-TP	SCREW 15/64-28 L=7
46			229-72608	ARM THREAD GUIDE C
47			B1190-522-S00	GAUGE PLATE 1/8 S
48			SS-2110915-SP	SCREW 11/64-40 L=8.5
49			229-20607	ARM THREAD GUIDE B
50			SS-6110610-TP	SCREW 11/64-40 L=6
51			TA-1250406-R0	RUBBER PLUG D=12.5 L=4
52			SS-4121015-SP	SCREW 3/16-28 L=10
53			229-01250	SLIDE PLATE ASM.
54			229-01201	SLIDE PLATE
55			229-01300	SLIDE PLATE SPRING
56			SS-6060210-SP	SCREW 3/32-56 L= 1.9
57			229-01003	BED SCREW STUD
58			113-00407	PRESSER BAR SUPPORT
59			SS-1120710-SP	SCREW 3/16-28 L=6.5
60			113-45709	OIL SHIELD
61			SS-6110610-TP	SCREW 11/64-40 L=6
62			113-45600	OIL RUBBER
63			B3133-415-0A0	TENSION RELEASE PIN CAP ASM.
64			B3118-415-000	TENSION RELEASE PIN
65			B3136-415-000	CAP RING
66			WT-0530002-KS	TOOTHED WASHER D=5.3
67			SS-4120615-SP	SCREW 3/16-28 L=6
68		#02	114-15205	THREAD TAKE-UP LEVER COVER(JE)
69			SS-2110915-SP	SCREW 11/64-40 L=8.5
70			B1115-531-00D	THROAT PLATE COVER D ASM.
71			B1115-522-000-A	OPEN COVER SPRING
72			SS-4080310-SP	SCREW 1/8-44 L=3.4
73	*	#02	401-16677	GOST_SAFTY_LABEL_S
74			113-46400	WASTE MATERIAL GUIDE
75			113-45808	SCREW
76			B1193-530-000	WASTE MATERIAL GUARD PLATE
77			113-46905	WASTE MATERIAL GUARD E
78			113-46004	NEEDLE PLATE A
79			SS-6080410-SP	SCREW 1/8-44 L=4
			NOTE(注記)	#01....FOR DLM-5400N-7-0B,-WB #02....FOR JE #03....FOR DLM-5400N-7-00

2. MAIN SHAFT & THREAD TAKE-UP LEVER COMPONENTS
上軸・天秤関係



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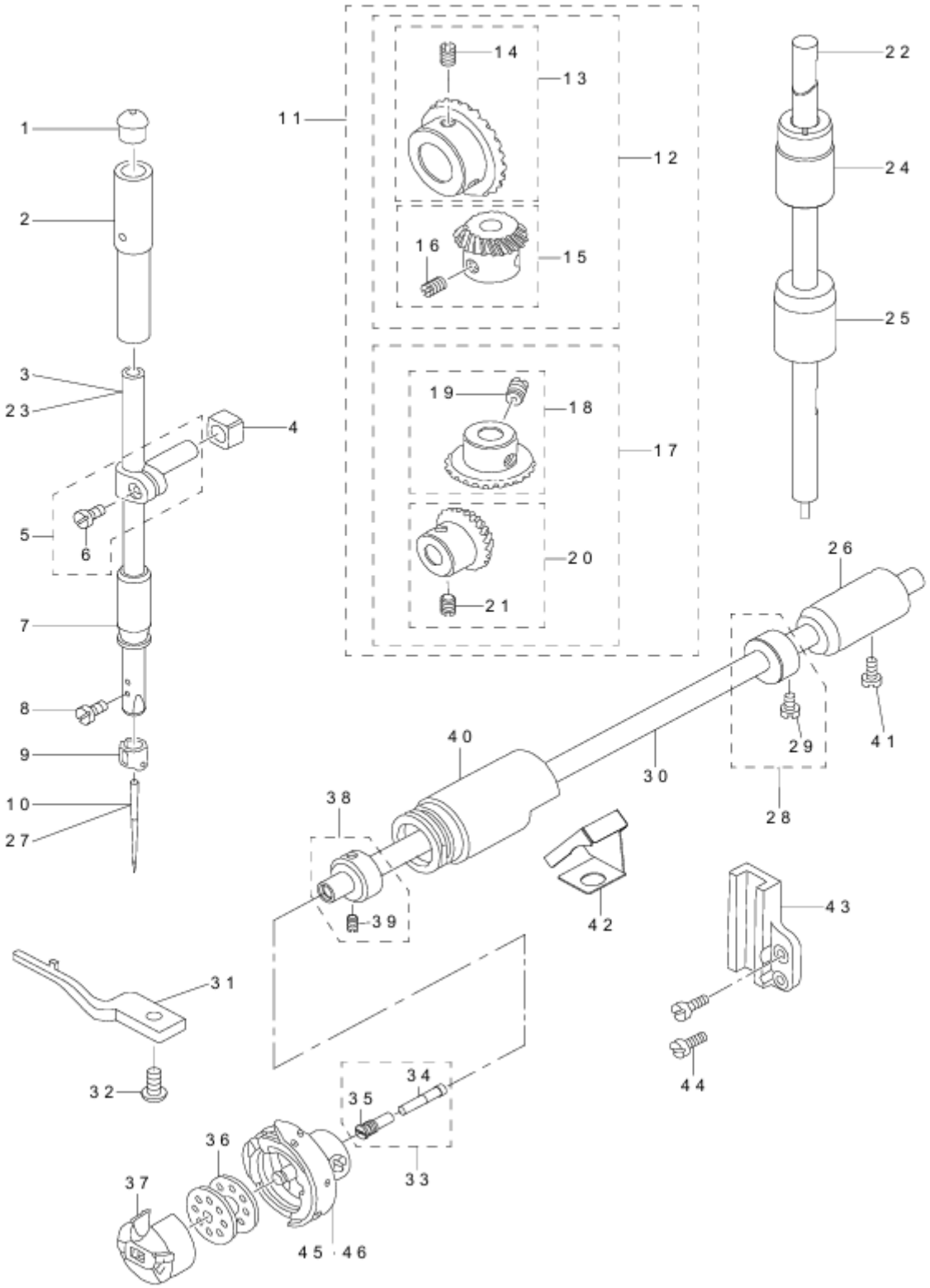
REF.NO		NOTE	PART NO	DESCRIPTION
1			SS-8151150-TP	SCREW 15/64-28 L=10.5
2			110-17357	THREAD TAKE-UP CRANK SHAFT ASM.
3			229-19203	OIL PROTECTING RUBBER
4	*		229-18072	THREAD TAKE-UP LEVER COMPL.
5	*		229-18064	THREAD TAKE-UP LEVER
6	*	#01	229-18403	NEEDLE BEARING A
7	*	#01	229-18502	NEEDLE BEARING B
8	*	#01	229-18601	NEEDLE BEARING C
9	*	#01	229-18700	NEEDLE BEARING D
10	*		229-18106	NEEDLE BAR CRANK
11	*		229-06606	NEEDLE BAR CRANK ROD
12	*		229-18304	LEFT SCREW
13			113-49008	MAIN SHAFT
14	*		400-97023	COUNTER WEIGHT M COMPL.
15	*		PS-0400082-KP	SPRING PIN
16	*		400-95785	COUNTER WEIGHT_M ASM.
17	*		400-95786	COUNTER WEIGHT_M
18			RO-0442401-00	RUBBER RING
19			SS-7681650-TP	SCREW 9/32-28 L=16
20			SS-8660610-TP	SCREW 1/4-40 L=6
21			SS-8681650-TP	SCREW 9/32-28 L=16
22			229-04155	MAIN SHAFT THRUST COLLAR ASM.
23			SS-8660610-TP	SCREW 1/4-40 L=6
24			RC-1850001-KP	SNAP RING 18.5
25			229-10053	FEED DRIVE ECCENTRIC CAM ASM.
26			SS-6661110-SP	SCREW 1/4-40 L=11
27			229-10004	FEED DRIVE ECCENTRIC CAM
28			229-10103	THRUST COLLAR
29			SS-4090615-SP	SCREW 9/64-40 L=6
30			110-02409	MAIN SHAFT BUSHING REAR
31	*		401-05231	OIL SEAL
32			110-71495	HAND WHEEL ASM.
33			SS-6111210-SP	SCREW 11/64-40 L=12
34			WP-0450801-SD	WASHER 4.5X10X0.8
35			SS-8151550-SP	SCREW 15/64-28 L=15
36			110-71453	HAND WHEEL ASM.
37			M4007-110-0AA	MAGNET FITTING BASE A ASM.
38			M4007-110-0AB	MAGNET FITTING BASE B ASM.
39			229-37965	DYNAMO STATOR
40			110-02904	ROLLER FELT
41			SL-4051001-MZ	SCREW M5 L=9.6
42			B1213-552-000-A	OIL ADJUSTING PIN
43			RO-0291801-00	RUBBER RING
44			HX-0004300-00	CLIP
45			113-49107	BUSHING FRONT
46			113-49453	BALANCER AMS.
47			SS-7150940-SP	SCREW 15/64-28 L=9
48			B1215-552-000	OIL ADJUSTING COLLAR
49			229-03306	BUSHING INTERMEDIATE
			NOTE(注記)	#01....SELECTIVE PART(A ~ D)

3. NEEDLE BAR, UPRIGHT SHAFT & HOOK DRIVING SHAFT COMPONENTS
針棒・立軸・下軸関係



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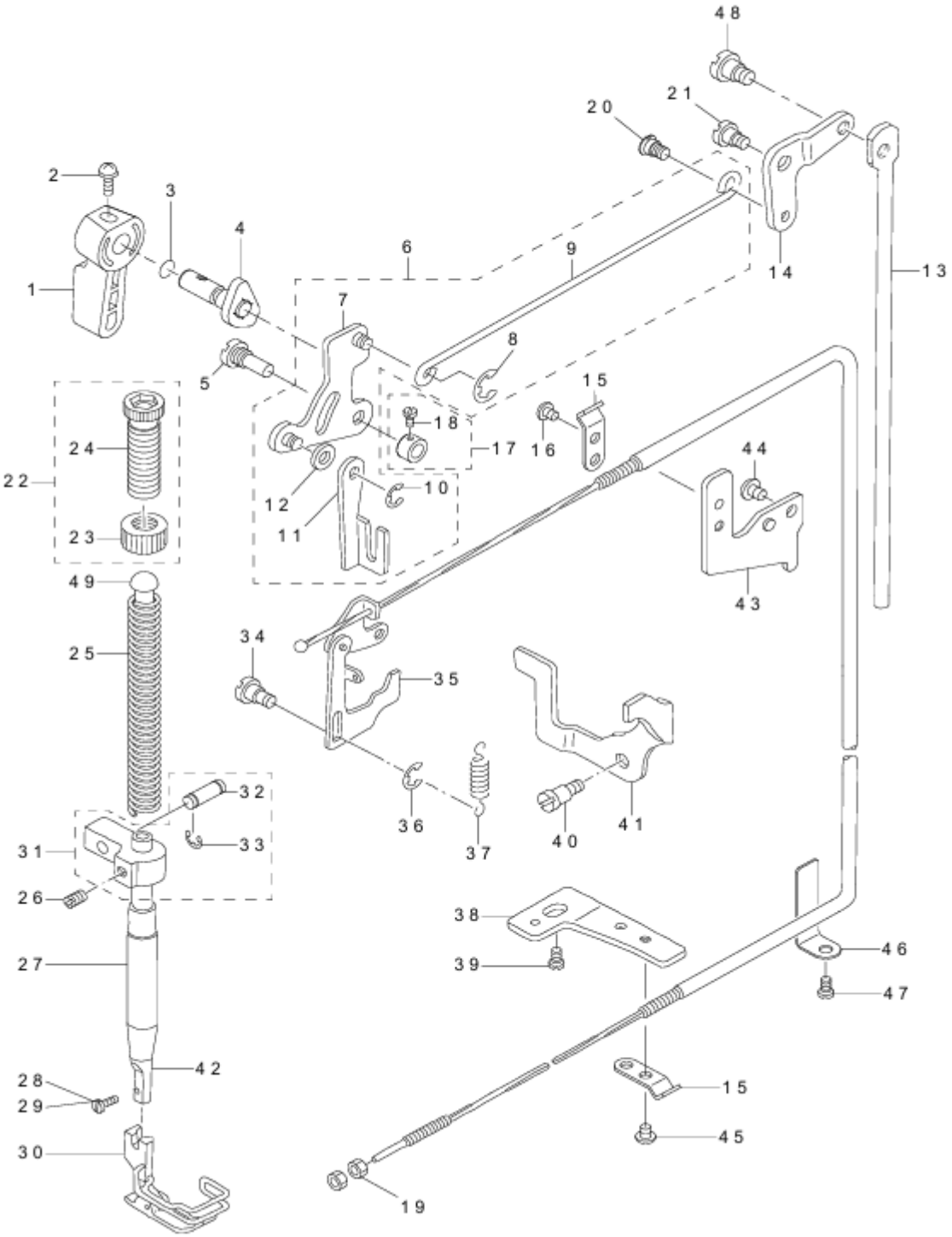
REF.NO	NOTE	PART NO	DESCRIPTION
1		229-01409	NEEDLE BAR UPPER BUSH CAP
2		229-06101	NEEDLE BAR BUSHING UPPER
3		113-49701	NEEDLE BAR A
4		400-90058	SLIDE BLOCK
5		229-06457	NEEDLE BAR HOLDER ASM.
6		SS-6090670-TP	SCREW 9/64-40 L=6
7		229-06200	NEEDLE BAR BUSHING LOWER
8		SS-7080510-TP	SCREW 1/8-44 L=4.5
9		B1418-530-000	NEEDLE BAR THREAD GUIDE
10		MDB-100B1400	NEEDLE DBX1 #14
11		B1306-155-0C0	GEAR & PINION ASM.
12		B1306-155-0B0	GEAR & PINION ASM. UPPER
13		B1305-012-0A0	GEAR ASM.
14		SS-8660810-TP	SCREW 1/4-40 L=8
15		B1306-155-0A0	PINION ASM.
16		SS-8660810-TP	SCREW 1/4-40 L=8
17		B1307-155-0B0	GEAR & PINION ASM. LOWER
18		B1307-155-0A0	GEAR ASM. LARGE
19		SS-8660810-TP	SCREW 1/4-40 L=8
20		B1308-155-0A0	PINION ASM.
21		SS-8660810-TP	SCREW 1/4-40 L=8
22		229-05004	UPRIGHT SHAFT
23	#01	113-49800	NEEDLE BAR B
24		229-05103	UPRIGHT SHAFT BUSHING UPPER
25		110-04207	UPRIGHT SHAFT BUSHING LOWER
26		229-16308	HOOK DRIVING SHAFT BUSH REAR
27	#01	MC-2005009-00	NEEDLE 134 90
28		229-17157	THRUST COLLAR ASM. REAR
29		SS-6110420-TP	SCREW 11/64-40 L=4.8
30		229-16001	HOOK DRIVING SHAFT
31		110-38809	BOBBIN CASE HOLDER
32		SS-4110915-TP	SCREW 11/64-40 L=9
33		229-16555	OIL SEAL SCREW ASM.
34		110-15906	OIL WICK
35		229-16506	SET SCREW
36		229-32909	BOBBIN
37		110-38759	BOBBIN CASE ASM.
38		229-17058	THRUST COLLAR ASM. FRONT
39		SS-8110410-TP	SCREW 11/64-40 L= 3.5
40		113-51004	BUSHING FRONT
41		SS-4120915-SP	SCREW 3/16-28 L=9
42		229-42601	OIL SHIELD
43		113-49909	ROLLER GUIDE BRACKET
44		SS-4120915-SP	SCREW 3/16-28 L=9
45		111-41355	HOOK ASM.
46	#02	110-38650	HOOK ASM.
		NOTE(注記)	#01....FOR JE #02....FOR USE IN JAPAN,JH

4. HAND LIFTER COMPONENTS
押え上げ関係



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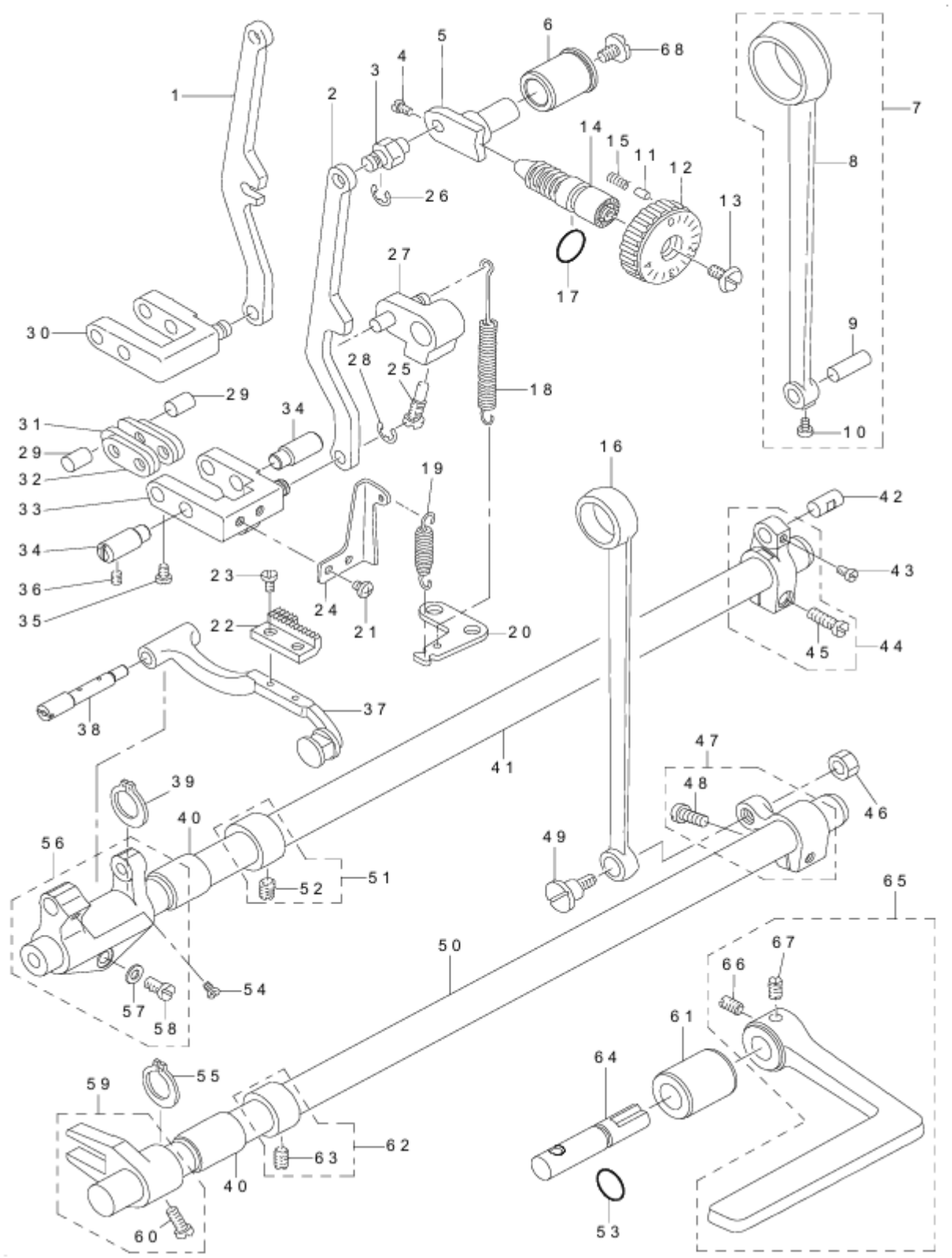
REF.NO		NOTE	PART NO	DESCRIPTION
1			229-07802	HAND LIFTER
2			B1521-555-000	SCREW
3			RO-0371801-00	RUBBER RING
4			229-08552	HAND LIFTER CAM ASM.
5			113-01702	LINK SHAFT
6			113-01652	LIFTING LEVER ASM.
7	*		229-08156	LIFTING LINK ASM.
8			RE-0500000-K0	E-RING
9	*		229-08305	KNEE LIFTER SIDE ROD
10			RE-0500000-K0	E-RING
11			113-01603	LIFTING LEVER
12			WP-0650876-SD	WASHER 6.5X13X0.8
13			112-05408	CONNECTING ROD
14			112-05309	LIFTING LEVER LINK
15			229-44508	WIRE PRESSER A
16			SS-4110515-SP	SCREW 11/64-40 L=5
17			CS-064061A-SP	THRUST COLLAR ASM.
18			SS-7090620-TP	SCREW 9/64-40 L=6.1
19			NS-6620310-SP	NUT 3/16-32
20			229-08909	HINGE SCREW
21			SD-0720331-SP	HINGE SCREW D= 7.24 H= 3.3
22			229-07554	PRESSER SPRING REGULATOR NUT ASM.
23			229-07604	PRESSER SPRING REGULATOR NUT
24			229-07505	PRESSER SPRING REGULATOR
25			229-07406	PRESSER SPRING
26			SS-8660610-TP	SCREW 1/4-40 L=6
27			400-60989	PRESSER BAR BUSHING LOWER
28		#01	SS-7090710-SP	SCREW 9/64-40 L= 6.8
29		#04	SS-6090910-SP	SCREW 9/64-40 L=9
30		#03	B1524-530-DB0	PRESSER FOOT ASM.
31			113-01355	NEEDLE BAR GUIDE BRACKET ASM.
32			113-01405	PIN
33			RE-0300000-K0	E-RING 3
34			113-06107	TENSION RELEASE PLATE SHAFT
35			113-55351	TENSION RELEASE WIRE ASM.
36			RE-0300000-K0	E-RING 3
37			113-05901	SPRING
38			229-44706	WIRE PRESSER BASE LOWER
39		#02	SS-4150915-SP	SCREW 15/64-28 L=9
40			SD-0640261-SP	HINGE SCREW D=3.65 H=2.6
41			113-55609	TENSION RELEASE HOLDER
42			B1501-530-000	PRESSER BAR
43			229-44607	WIRE PRESSER BASE UPPER
44			SS-4120615-SP	SCREW 3/16-28 L=6
45			SS-4110515-SP	SCREW 11/64-40 L=5
46			229-45109	WIRE CABLE SUPPORT
47			SS-4120615-SP	SCREW 3/16-28 L=6
48			SD-0600322-SD	HINGE SCREW D=6 H=3.2
49			229-07703	PRESSER GUIDE BAR
			NOTE(注記)	#01....FOR DLM-5400N-7-00,-0B #02....FOR DLM-5400N-7-00 #03....FOR EXPORT #04....FOR DLM-5400N-7-WB

5. FEED MECHANISM COMPONENTS
送り関係



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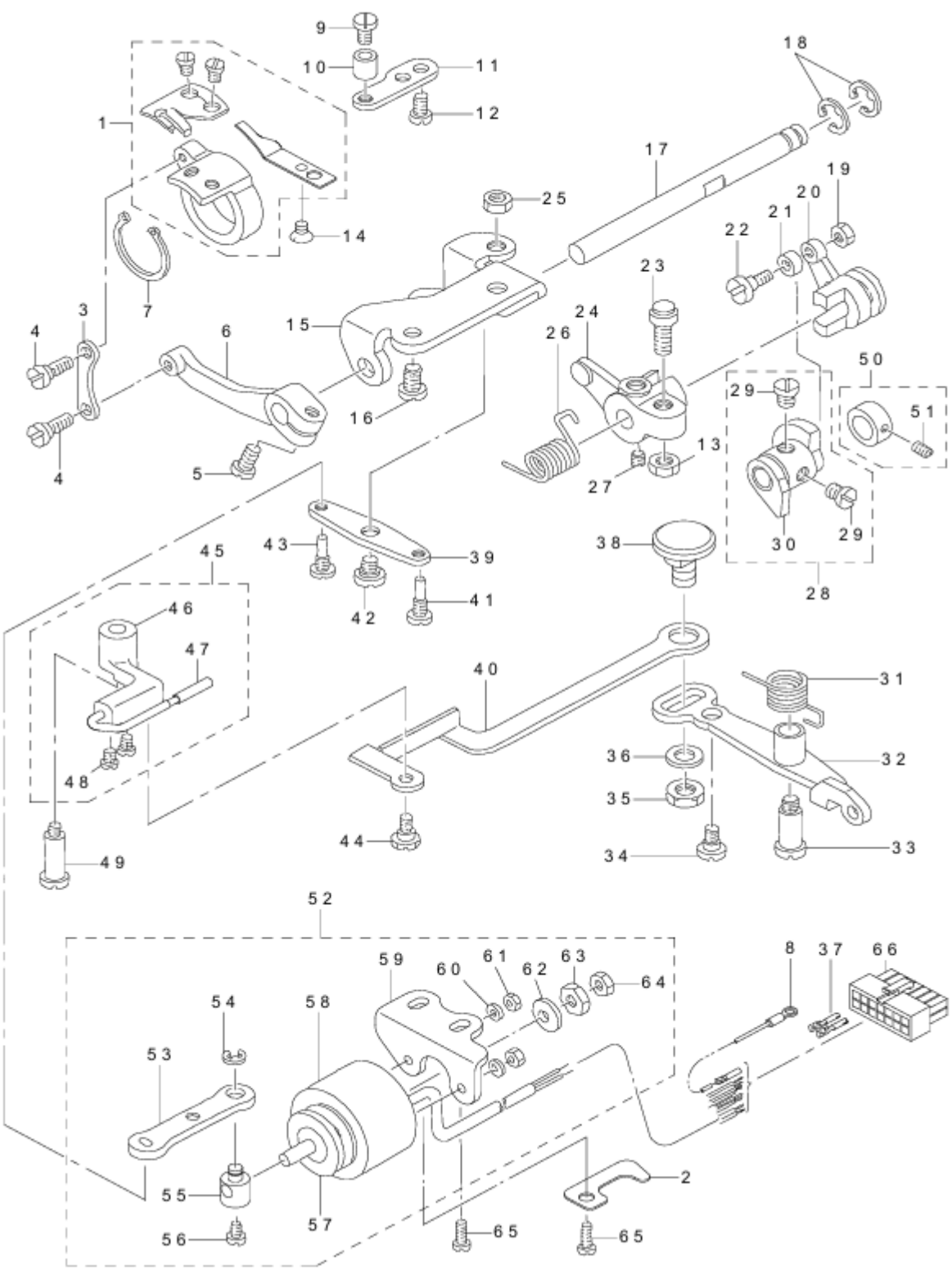
REF.NO	NOTE	PART NO	DESCRIPTION
1	#01	110-09503	FEED REGULATOR CONNCTING ROD
2	#02	229-41108	FEED ADJUST ROD
3		229-11507	WALKING FOOT PIN C
4		SS-7090520-TP	SCREW 9/64-40 L= 4.5
5		110-09701	FEED REGULATOR
6		110-09800	FEED REGULATOR BUSHING
7		229-10251	ROCKER SHAFT CONNECTING ROD ASM.
8		229-10202	ROCKER SHAFT CONNECTING ROD
9		229-11101	WALKING FOOT PIN C
10		SS-6090620-TP	SCREW
11		229-12000	FEED REGULATOR PIN
12		229-40506	FEED DIAL
13		SS-6121860-SP	SCREW 3/16-28 L=18
14		229-11804	FEED REGULATOR SCREW
15		B1148-555-000	SPRING
16		229-15003	CONNECTING ROD
17		RO-0922702-00	RUBBER RING
18		110-10311	FEED REVERSE SPRING
19		110-37405	SPRING
20		229-13701	FEED SPRING HOOK
21		SS-4110515-SP	SCREW 11/64-40 L=5
22		B1613-522-N00-A	FEED DOG
23		SS-4080620-TP	SCREW 1/8-44 L=6
24		229-41306	REGULATOR LINK SPRING HOOK
25	*	229-12505	FEED REVERSE ARM SCREW
26		RE-0500000-K0	E-RING
27		229-12257	FEED REVERSE ARM ASM.
28		RE-0500000-K0	E-RING
29		229-10905	WALKING FOOT PIN A
30	#01	229-10459	FEED ADJUSTING LINK ASM.
31	*	400-89548	CONNECTING LINK B
32	*	400-93417	CONNECTING LINK A
33	#02	229-40951	FEED ADJUST LINK ASM.
34		229-10806	ADJUST LINK FULCRUM SHAFT A
35		SS-6090620-TP	SCREW
36		SS-8150710-TP	SCREW 15/64-28 L=7
37		229-40753	FEED BAR ASM.
38		229-40803	FEED BAR SHAFT
39		RC-0150001-KP	RETAINING RING 13.8
40		229-13008	FEED ROCKER SHAFT BUSHING
41		229-12901	FEED ROCKER SHAFT
42		229-11002	WALKING FOOT PIN B
43		SS-6090620-TP	SCREW
44		229-10350	FEED ROCKER SHAFT CRANK ASM.
45		SS-6121610-SP	SCREW 3/16-28 L=15.5
46		NS-6680410-SP	NUT 9/32-28
47		229-15151	FEED ARM COMPL.
48		SS-7121610-SP	SCREW 3/16-28 L=15.5
49		SD-1000801-SH	HINGE SCREW D=10 H=8
50		229-15201	FEED DRIVING SHAFT
51		229-04155	MAIN SHAFT THRUST COLLAR ASM.
52		SS-8660610-TP	SCREW 1/4-40 L=6
53		RO-0781901-00	RUBBER RING
54		SS-7110740-TP	SCREW 11/64-40 L=7
55		RC-0150001-KP	RETAINING RING 13.8
56		229-40654	FEED ROCKER ASM.
57		WP-0480856-SP	WASHER 4.8X8.4X0.8
58		SS-7121410-TP	SCREW 3/16-28 L=14
59		229-15359	DRIVING SHAFT CRANK ASM.
60		SS-7111120-SP	SCREW 11/64-40 L=10.5
61		229-12802	FEED LEVER SHAFT BUSHING
62		229-04155	MAIN SHAFT THRUST COLLAR ASM.
63		SS-8660610-TP	SCREW 1/4-40 L=6
64		229-12604	FEED REVERSE SHAFT
65		229-12752	FEED LEVER ASM.
66		SM-8061010-TP	SCREW
67		SM-8061050-TP	SCREW
68		SS-7120770-SH	SCREW 3/16-28 L=7
		NOTE(注記)	#01....FOR DLM-5400N-7-00 #02....FOR DLM-5400N-7-0B,-WB

6. THREAD TRIMMER MECHANISM COMPONENTS
糸切り装置関係



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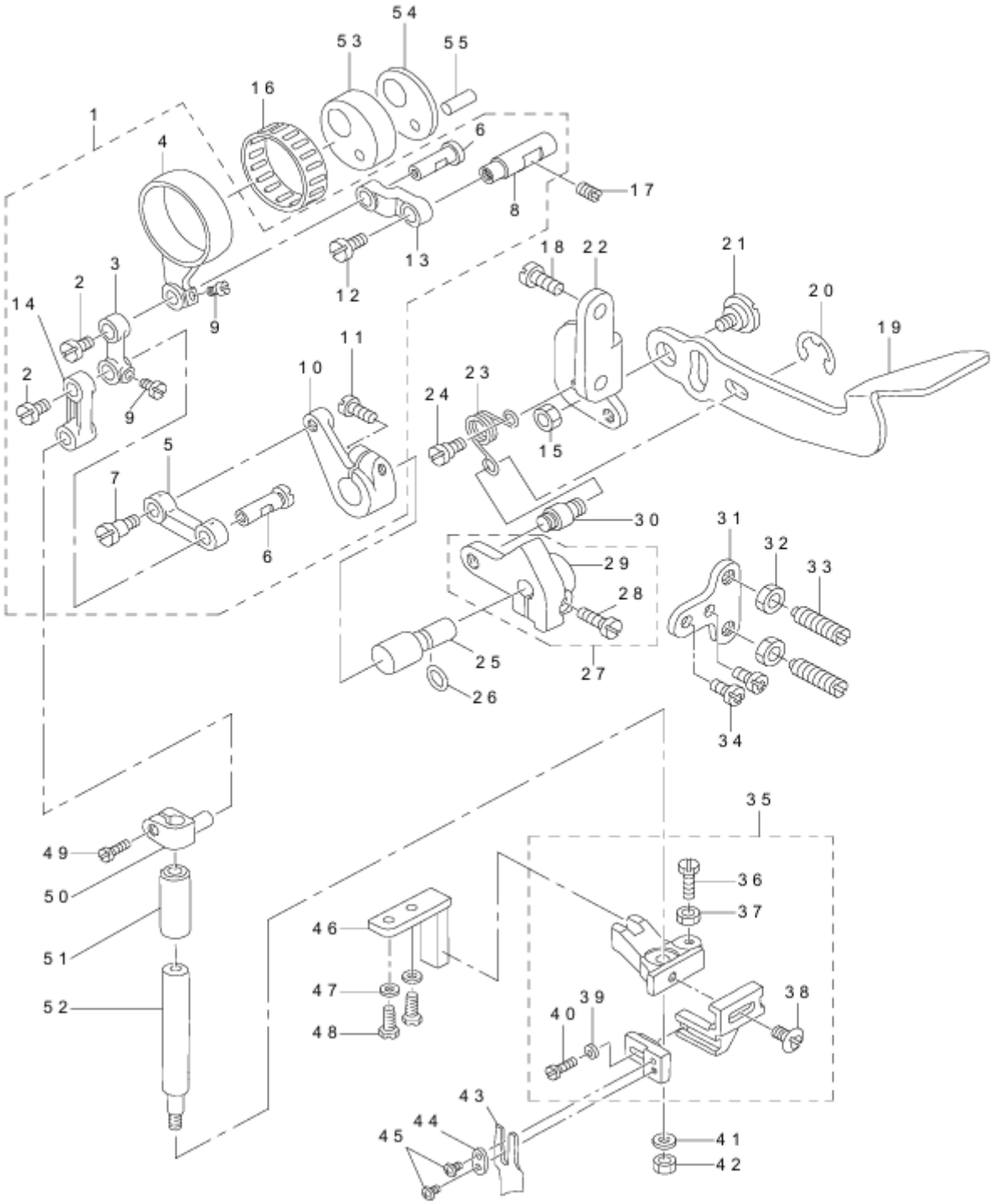
REF.NO	NOTE	PART NO	DESCRIPTION
1	*	401-20641	MOVING KNIFE ASM.
2		229-24807	PIPE HOLDER LOWER
3		113-52101	MOVING KNIFE LINK
4		SD-0500251-SP	HINGE SCREW D= 5 H= 2.5
5		SS-6121220-TP	SCREW 3/16-28 L=11.5
6		113-52200	KNIFE DRIVING
7		RC-2651218-KP	RETAINING RING
8		229-51552	GROUND WIRE ASM.
9		SS-8110710-SP	SCREW 11/64-40 L=6.5
10		113-54602	COLLAR
11		113-51608	KNIFE MOUNTING BASE
12		SS-4110715-SP	SCREW 11/64-40 L=7
13		NS-6150430-SP	NUT 15/64-28
14		SS-1090510-SP	SCREW 9/64-40 L=5
15		113-52408	BASE PLATE
16		SS-4150915-SP	SCREW 15/64-28 L=9
17		113-52309	KNIFE DRIVING SHAFT
18		RE-0600000-K0	E-RING 6
19		NS-6110310-SP	NUT 11/64-40
20		113-52606	SLIDE ARM
21		113-54404	DRIVING ROLLER
22		D2588-L8W-B00	ROLLER SHAFT
23		B1453-771-0A0	STOP SCREW ASM.
24		113-52507	KNIFE DRIVING ARM
25		NS-6150310-SP	NUT 15/64-28
26		113-53406	SPRING
27		SS-8660610-TP	SCREW 1/4-40 L=6
28		113-53653	THREAD TRIMMER CAM ASM.
29		SS-6660610-TP	SCREW 1/4-40 L=6
30		113-53604	THREAD TRIMMER CAM
31		113-53505	SPRING
32		113-53059	CLUTCH LEVER ASM.
33		SD-0701511-TP	HING SCREW D=7 H=15.1
34		SD-0600361-SP	HINGE SCREW D=6 H=3.6
35		NS-6150430-SP	NUT 15/64-28
36		WP-0621016-SH	WASHER
37		HK-0346400-0B	PIN CONTACT
38		229-50000	PICKER LINK PIN
39		113-52903	CLUTCH PLATE
40		113-54107	PICKER LINK
41		113-52705	SCREW PIN A
42		SD-0640261-SP	HINGE SCREW D=3.65 H=2.6
43		113-52804	SCREW PIN B
44		SD-0630275-SP	HINGE SCREW D=6.35 H=2.7
45		113-54057	PICKER ARM ASM.
46		113-54008	PICKER ARM
47		229-50356	HOOK THREAD PRESSER ASM.
48		SS-6090510-TP	SCREW 9/64-40 L= 5.0
49		SD-0641452-TP	HINGE SCREW D=6.35 H=14.5
50		229-50950	CAM COLLAR ASM.
51		SS-8110520-TP	SCREW 11/64-40 L=4.5
52		113-55054	SOLENOID UNIT
53		113-53307	CLUTCH LINK
54		RE-0500000-K0	E-RING
55		229-51008	SOLENOID PIN
56		SS-8110710-TP	SCREW 11/64-40 L=6.5
57		110-43205	SOLENOID RUBBER A
58		110-43908	THREAD TRIMMER SOLENOID
59		229-51404	SOLENOID BASE
60		WP-0450000-SD	WASHER 4.5X8X0.5
61		NM-6040000-SN	NUT M4
62		110-43304	SOLENOID RUBBER
63		NS-6660410-SH	NUT
64		NS-6660430-SP	NUT 1/4-40
65		SS-4151215-SP	SCREW 15/64-28 L=12
66		HK-0346101-40	HOUSING 14P

7. KNIFE COMPONENTS
メス関係



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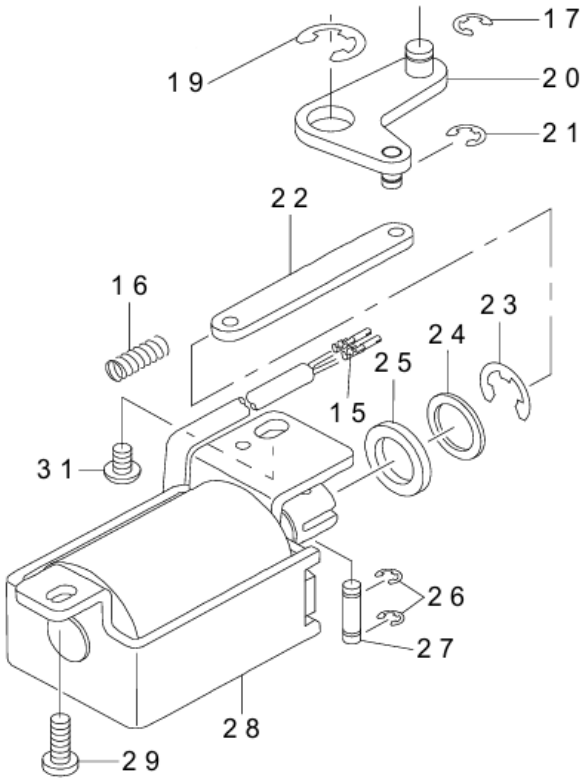
REF.NO	NOTE	PART NO	DESCRIPTION
1	*	113-56953	KNIFE ROD ASM.
2		SS-7110830-SP	SCREW 11/64-40 L=7.5
3		113-57308	KNIFE DRIVING ROD A
4		113-56904	KNIFE DRIVING ROD
5		113-57506	KNIFE DRIVING LINK
6		113-57209	PIN
7		SD-0640604-TP	HING SCREW D=6.35 H=6
8		113-57001	ROD LINK SHAFT
9		SS-7090520-TP	SCREW 9/64-40 L= 4.5
10		113-57704	LINK SUPPORT ARM
11		SS-6121220-TP	SCREW 3/16-28 L=11.5
12		SS-7110830-SP	SCREW 11/64-40 L= 7.5
13		113-57100	KNIFE DRIVING ROD LINK
14		113-57407	KNIFE DRIVING ROD B
15		NS-6160520-SP	NUT 1/4-24
16		B4123-522-00A	NEEDLE BEARING
17		SS-8151150-TP	SCREW 15/64-28 L=10.5
18		SS-4150915-SP	SCREW 15/64-28 L=9
19		113-58207	KNIFE LEVER
20		RE-0500000-K0	E-RING
21		SD-0920321-SP	HINGE SCREW D=9.20 H=3.2
22		113-58108	KNIFE LEVER BASE
23		B4126-530-000	SPRING
24		SD-0790431-SP	HINGE SCREW D=7.94 H=4.3
25		113-57803	KNIFE SET LEVER SHAFT
26		RO-0481901-00	RUBBER RING
27		113-57951	KNIFE SHIFTING BASE ASM.
28		SS-6121220-TP	SCREW 3/16-28 L=11.5
29		113-57902	KNIFE SET LEVER BASE
30		B4124-530-000	SET LEVER PIN
31		113-58306	KNIFE LEVER STOPPER
32		NS-6150310-SP	NUT 15/64-28
33		SS-8152080-SP	SCREW 15/64-28 L=19.5
34		SS-4120915-SP	SCREW 3/16-28 L=9
35		B4117-530-0A0	KNIFE MOUNTING BASE ASM.
36		SS-9121410-TP	SCREW 3/16-28 L=14
37		NS-6120310-SP	NUT 3/16-28
38		SS-6110810-TP	SCREW 11/64-40 L=8
39		WP-0371026-SD	WASHER 3.7X7X1
40		SS-6090910-SP	SCREW 9/64-40 L=9
41		WP-0501016-SD	WASHER 5X10.5X1
42		NS-6120480-SP	NUT 3/16-28
43		B4121-522-000	KNIFE
44		B4122-522-000	WASHER
45		SS-4080515-SP	SCREW 1/8-44 L=5
46		B4120-530-000	KNIFE MOUNTING BASE GUIDE
47		WP-0480856-SP	WASHER 4.8X8.4X0.8
48		SS-9121010-TP	SCREW
49		SS-6090810-TP	SCREW 9/64-40 L=7.5
50		B4115-530-000	KNIFE DRIVING STUD CONNECTION
51		B4116-530-000	BUSHING
52		B4114-530-000	KNIFE DRIVING STUD
53		B4101-531-000	KNIFE MOUNTING BASE ASM.
54		B4132-522-000-A	THRUST PLATE
55		B4107-522-000	PIN

8. AUTOMATIC REVERSE FEED COMPONENTS (FOR DLM-5400N-7-0B,-WB)
自動逆送り関係（ＤＬＭ－５４００Ｎ－７－０Ｂ，－ＷＢ用）



REF.NO	NOTE	PART NO	DESCRIPTION
15		HK-0346400-0B	PIN CONTACT
16		112-17601	WALKING FOOT SPRING
19		RE-0900000-K0	E-RING 9
20		229-53657	AUTO-BACK ARM ASM.
21		RE-0400000-KP	E-RING 4
22		229-53905	CONNECTING LINK
23		RE-1200000-K0	E-RING 12
24		WP-1602616-SZ	WASHER 16X24X2.6
25		D2468-555-B00	RUBBER PLUNGER
26		RE-0400000-K0	E-RING 4
27		229-53509	REVERSE FEED PLUNGER ARM PIN
28		111-02753	REVERSE FEED MAGNET ASM.
29		SS-4151215-SP	SCREW 15/64-28 L=12
31		SS-4150915-SP	SCREW 15/64-28 L=9
		NOTE(注記)	#01....FOR DLM-5400N-7-0B

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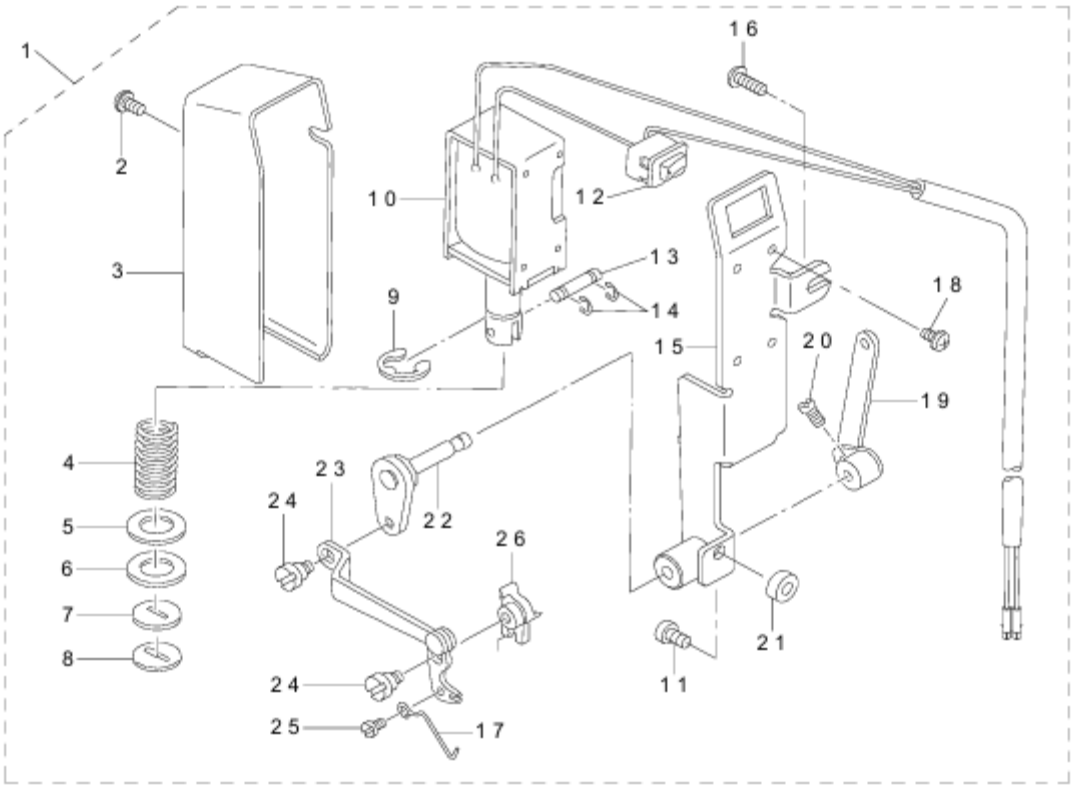
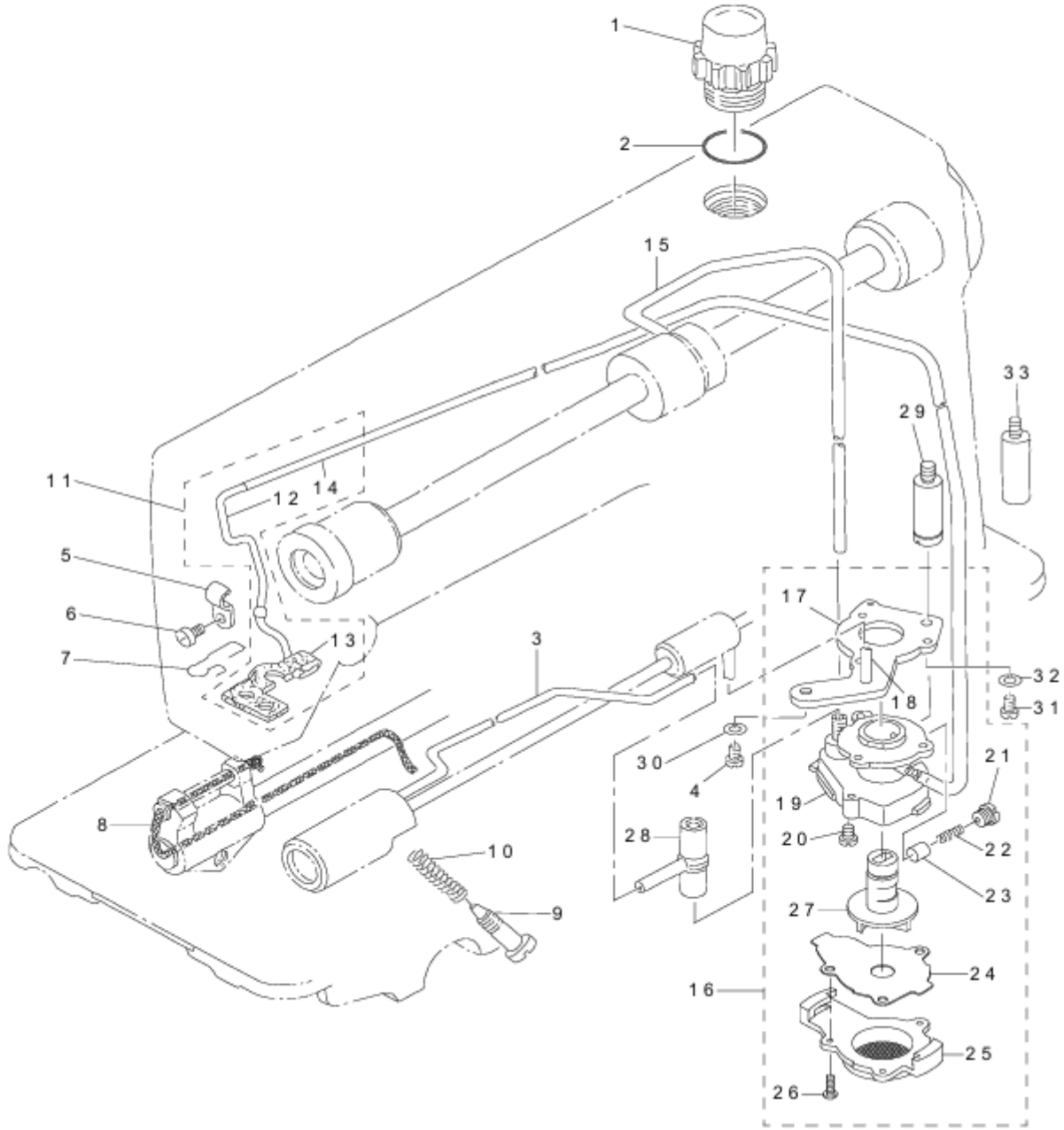
9. WIPER COMPONENTS (FOR DLM-5400N-7-WB)

ワイパー関係（DLM－5400N－7－WB用）



REF.NO	NOTE	PART NO	DESCRIPTION
1		113-62456	WIPER ASM.
2		SL-4030631-SC	SCREW M3X6
3		112-58001	WIPER COVER
4		112-33400	SPRING
5		WP-1221016-SP	WASHER
6		112-34408	SOLENOID RUBBER
7		112-33301	STOPPER RUBBER
8		112-34606	STOPPER RUBBER WASHER
9		RE-0900000-K0	E-RING 9
10	*	401-12705	WIPER SOLENOID ASM.
11		SS-4121415-SP	SCREW 3/16-28 L=14
12	*	HA-0060000-00-A	SWITCH
13		112-34507	PLUNGER CONNECTING PIN
14		RE-0300000-K0	E-RING 3
15		112-33053	WIPER INSTALLING BASE ASM.
16		SS-4120915-SP	SCREW 3/16-28 L=9
17		113-59700	WIPER
18		SL-4030641-SE	SCREW
19		112-33251	WIPER LEVER B ASM.
20		SS-6110710-TP	SCREW 11/64-40 L= 6.5
21		135-22206	COLLAR
22		113-60153	WIPER LEVER ASM. A
23		113-59957	WIPER ARM ASM.
24		SD-0550212-TP	HINGE SCREW D=5.5 H=2.1
25		SS-7090410-SP	SCREW 9/64-40 L= 3.5
26		113-59809	WIPER BASE

10. OIL LUBRICATION COMPONENTS
給油関係



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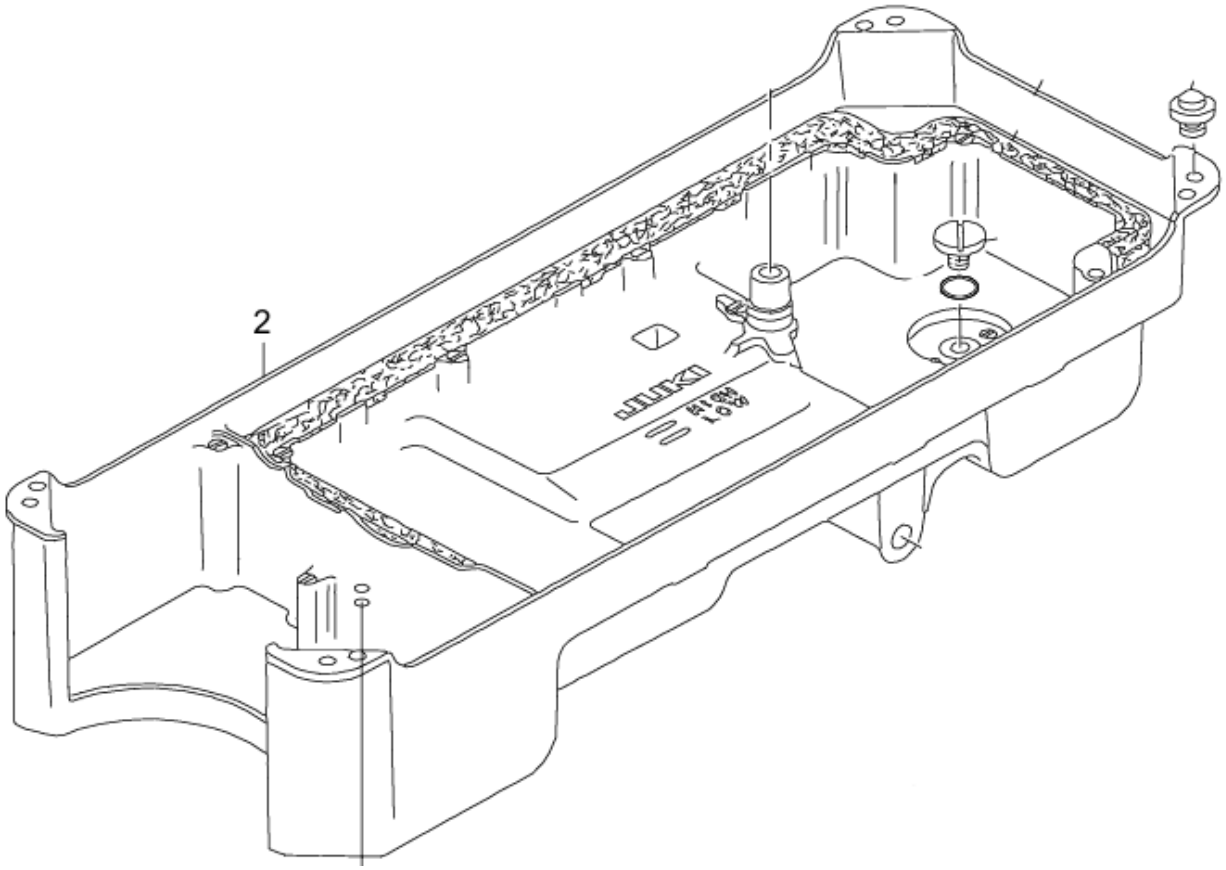
REF.NO	NOTE	PART NO	DESCRIPTION
1		229-47006	OIL SIGHT WINDOW
2		RO-1952401-00	RUBBER RING
3		229-24500	HOOK OIL TUBE
4		SS-4150915-SP	SCREW 15/64-28 L=9
5		B3538-112-000	OIL RETURN TUBE HOLDER
6		SS-4120615-SP	SCREW 3/16-28 L=6
7		113-56201	OIL FELT PRESSER
8		CQ-2520000-00	OIL WICK
9		229-25002	OIL REGULATOR SCREW
10		229-24906	OIL REGULATOR SCREW SPRING
11		113-55955	OIL RETURN TUBE ASM.
12		113-55906	OIL RETURN TUBE
13		113-56052	OIL FELT ASM.
14		BT-0500300-EA	OIL TUBE
15		229-24401	MAIN SHAFT OIL TUBE
16		229-23056	OIL PUMP ASM.
17	*	229-23312	PUMP BODY INSTALLING PLATE
18		229-23908	HOOK DRIVING SHAFT OILING PIPE
19	*	229-23015	PUMP BODY
20		SL-4030851-SF	SCREW M3 L=8
21		229-23502	PLUNGER SCREW
22		229-23601	PLUNGER SPRING
23		229-23403	PLUNGER
24		229-23809	PUMP BODY SUPPORT PLATE
25		229-23205	PUMP BODY COVER
26		SE-4301041-SR	SCREW D=3 L=10
27		229-23700	IMPELLER
28		229-24609	RUBBER JOINT
29	#02	229-47105	PUMP BODY STRUT
30	#02	WS-0651310-KP	SPRING WASHER 6.5X11X1.3
31		SS-6111010-TP	SCREW 11/64-40 L= 9.5
32	#02	WS-0451040-KP	SPRING WASHER 4.5X8.5X1
33	#01	229-24005	PUMP BODY STRUT
		NOTE(注記)	#01....FOR DLM-5400N-7-00 #02....FOR DLM-5400N-7-0B,-WB

11. OIL RESERVOIR COMPONENTS
油溜関係



REF.NO	NOTE	PART NO	DESCRIPTION
2		113-60708	OIL RESERVOIR

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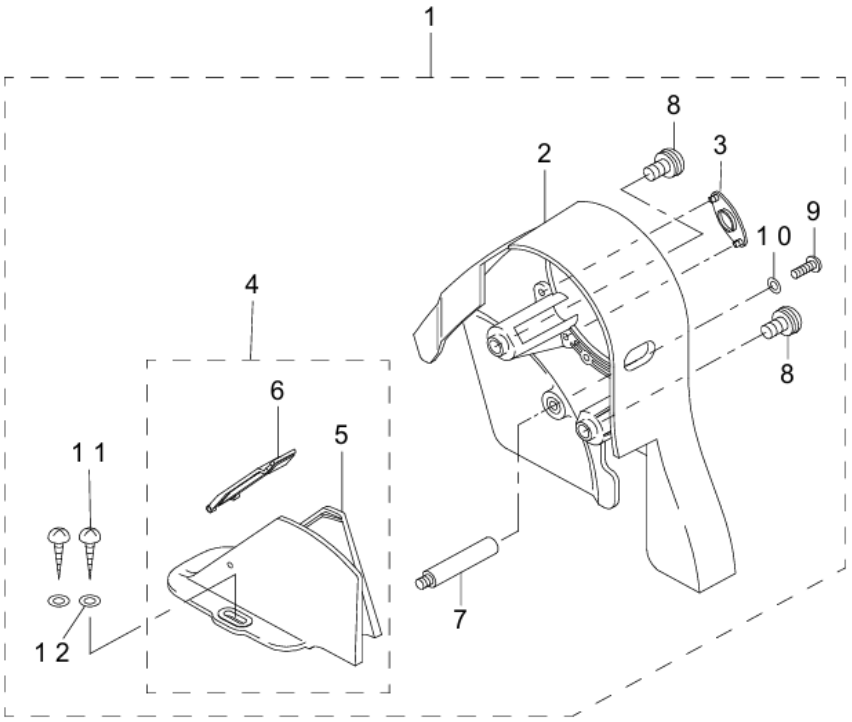
12. BELT COVER & BOBBIN WINDER COMPONENTS
ベルトカバー・糸巻装置関係



REF.NO	NOTE	PART NO	DESCRIPTION
1		229-33451	BELT COVER ASM.
2		229-33402	BELT COVER A
3		229-33501	BELT COVER A CAP
4		229-33659	BELT COVER B COMPL.
5		229-33600	BELT COVER B
6		229-33758	BELT COVER B LID ASM.
7		229-33907	BELT COVER STRUT
8		229-34004	SET SCREW
9		SS-4121415-SP	SCREW 3/16-28 L=14
10		WP-0501016-SD	WASHER 5X10.5X1
11		SK-3412000-SC	WOOD SCREW D=4.1 L=20
12		WP-0450826-SC	WASHER 4.5X10X0.8