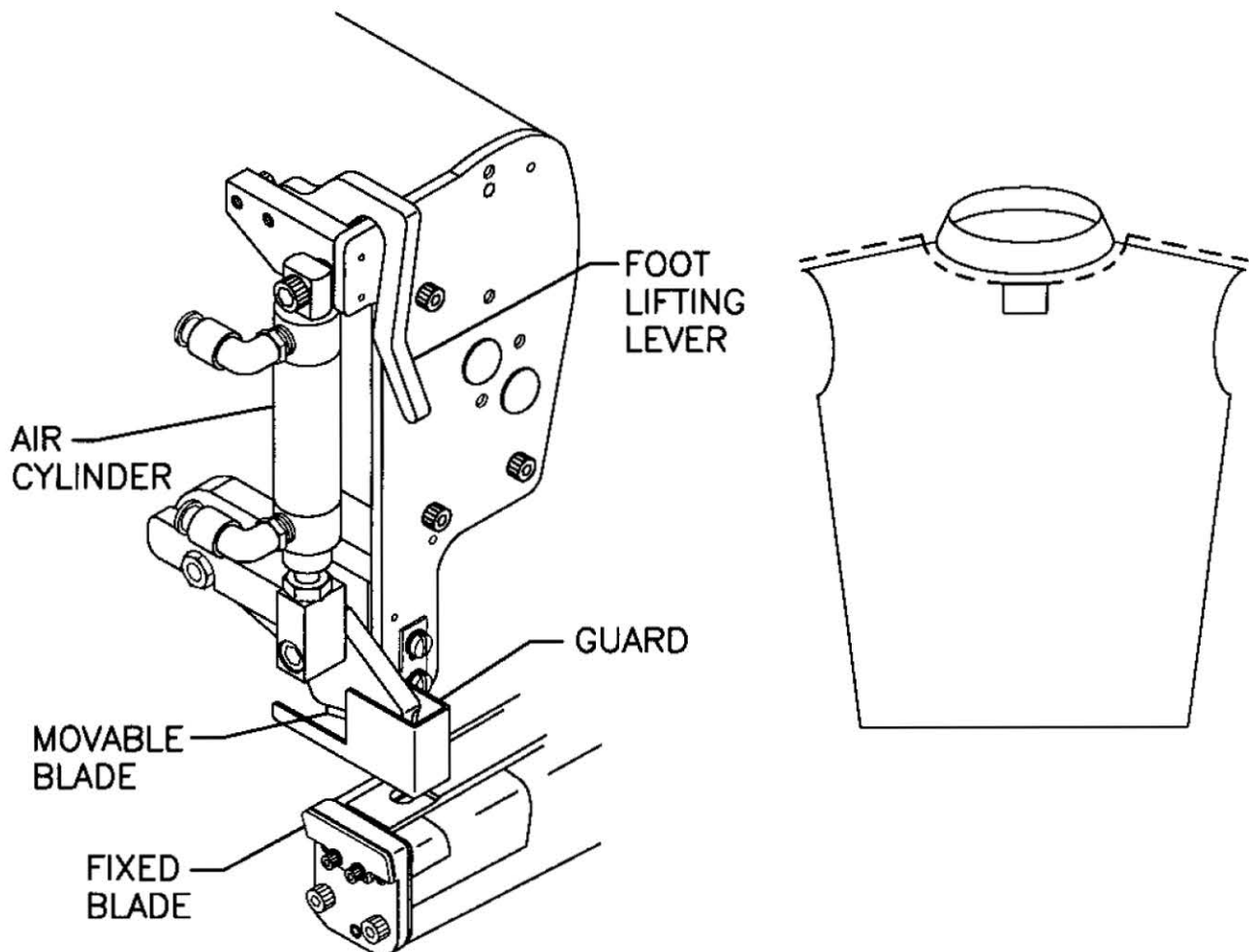


CLINTON SERVICE GUIDE MODEL 117VS-FOTA-KS BROTHER B925

SHEAR CUTTER FOR SHOULDER TAPING OPERATION

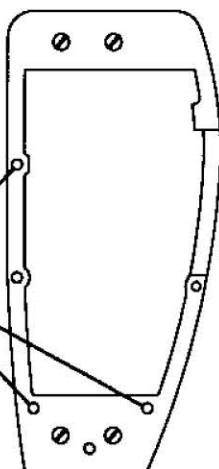


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STEP 1 DRILLING INSTRUCTIONS FOR THE FACE PLATE END

REMOVE THE EXISTING HINGED FACE PLATE INCLUDING THE HINGE, ALONG WITH THE THREE SCREWS HOLDING THE OIL DAM PLATE. DRILL AND TAP THE (3) THREE EXISTING SCREW HOLES SHOWN, WITH DRILL NO.29 (30-2130-29) AND TAP 8-32 (30-1266-01) SUPPLIED.

DRILL & TAP
1/2" DEEP
THESE (3)
THREE HOLES.

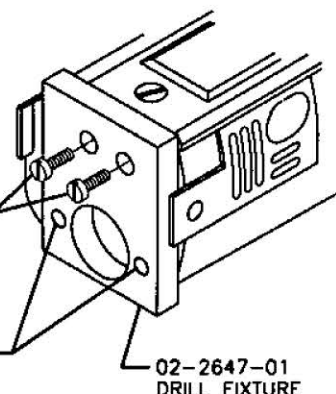


STEP 2 DRILLING INSTRUCTIONS FOR THE STATIONARY BLADE SUPPORT

1. PLACE DRILL FIXTURE ON THE MACHINE AS SHOWN.
2. DRILL (2) TWO HOLES 1/2" DEEP WITH NO.21 DRILL SUPPLIED. (30-2130-21)
3. REMOVE DRILL FIXTURE.
4. TAP THE (2) TWO HOLES WITH 10-32 TAP SUPPLIED. (30-1875-01)

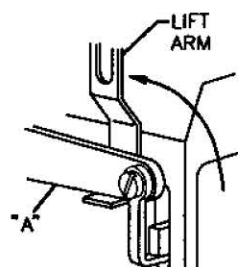
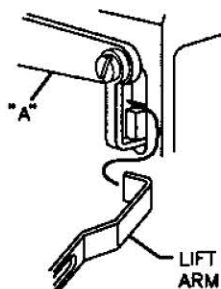
EXISTING SCREWS FOR
HOLDING THE DRILL
FIXTURE

DRILL GUIDE HOLES
FOR DRILL NO.21.



STEP 3

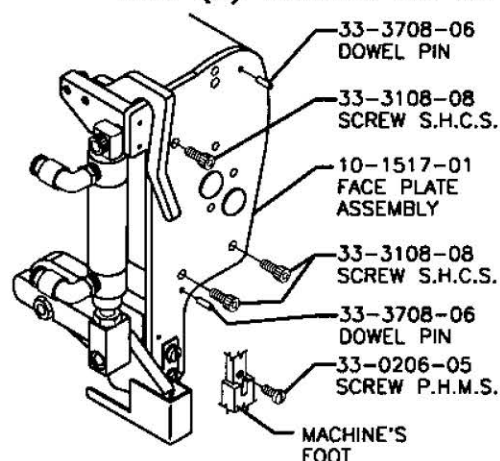
INSTALL THE CUTTER AS A COMPLETE ASSEMBLY. START BY PLACING THE LIFT ARM IN AND WORKING THE LIFT ARM UP AND AROUND BETWEEN THE MACHINE WALL AND BAR "A" AS SHOWN



ADJUSTMENTS

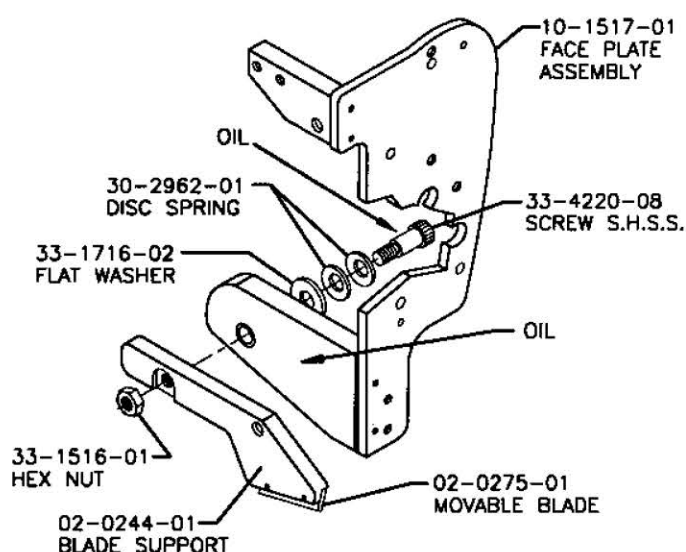
WARNING!! TO PREVENT SERIOUS INJURY, DISCONNECT AIR SUPPLY BEFORE MAKING ANY ADJUSTMENTS.

STEP 4 MOUNT VERTICAL SHEAR CUTTER WITH (3) SCREWS 33-3210-10.



NOTE: LATER WHEN THE CUTTER IS INSTALLED COMPLETELY ALONG WITH THE STATIONARY BLADE AND ALL THE ADJUSTMENTS HAVE BEEN MADE AND THE CUTTER IS WORKING PERFECTLY, USE THE DRILLS PROVIDED TO DRILL HOLES FOR THE DOWEL PINS USING THE FACE PLATE HOLES AS THE TEMPLATE. USE DRILL #33 (30-1070-01) FOR THE PILOT HOLES FIRST, 3/16" DEEP. THEN USE 1/8" DIA. (30-2376-08), SAME DEPTH 3/16".

STEP 5 ADJUSTING THE MOVABLE BLADE

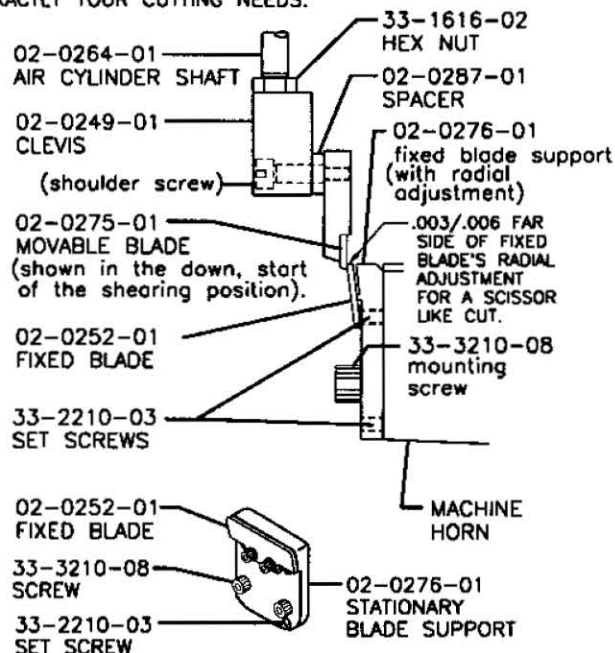


SHOULDER SCREW 33-4220-08 SHOULD BE SCREWED INTO THE BLADE SUPPORT, FINGER TIGHT. THE HEX NUT 33-1516-01 IS USED TO LOCK IN THE ADJUSTED CONDITION.

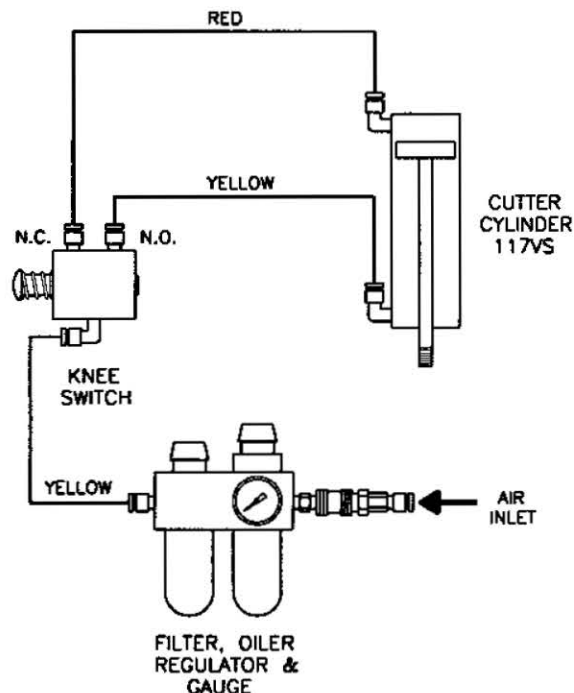
STEP 6**ADJUSTING THE STATIONARY BLADE**

IF THE BLADES ARE NOT TOUCHING EACH OTHER, LOOSEN THE THE (2) SCREWS 33-3210-08. THIS WILL ALLOW THE (2) TOP JACK SCREWS 33-2210-03 TO BE TURNED TO MAKE UP ANY ADJUSTMENT.

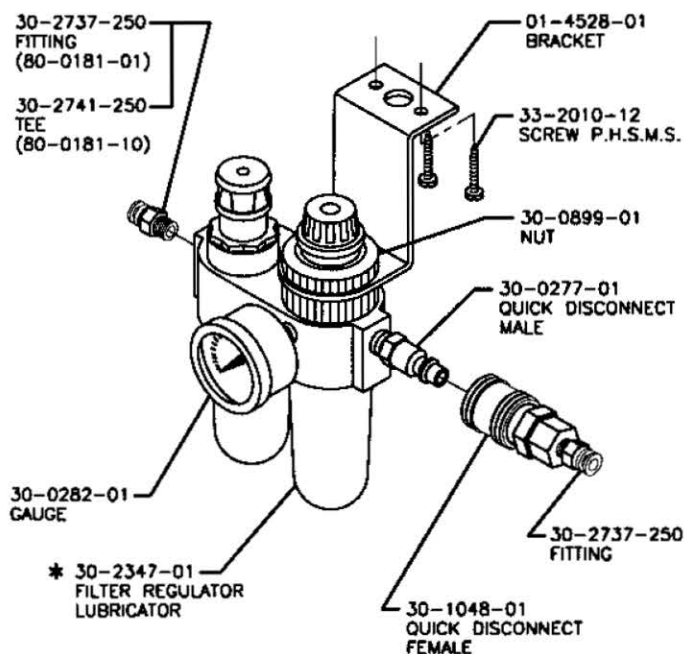
ADJUST THE (2) SCREWS 33-2210-03 ON THE RIGHT FOR THE RADIAL ADJUSTMENT OF THE FIXED BLADE AS SHOWN. RETIGHTEN THE (2) SCREWS 33-3210-08. TRY LOWERING THE MOVABLE BLADE SLOWLY (WITHOUT THE AIR BEING ON) FOR TESTING THE SHEARING ACTION. IT MAY REQUIRE SEVERAL ADJUSTMENTS TO GET EXACTLY YOUR CUTTING NEEDS.

**AIR CIRCUIT DIAGRAM**

MODEL 117VS KS
MODEL 117VS F.O.R.G.-KS

**FILTER, OILER, REGULATOR, GAUGE ASSEMBLY**

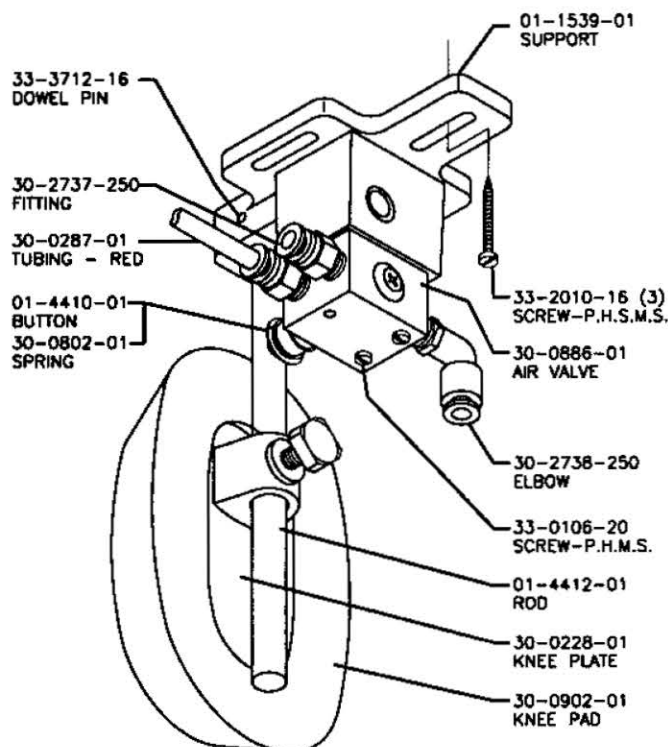
80-0181-01
80-0181-10



* NOTE: SEE INS-DRAWINGS 2100-1 AND 2100-2 FOR SPARE PARTS

4 WAY AIR VALVE, KNEE OPERATED

80-0185-01



CUTTER ASSEMBLY

MODEL 117VS
BROTHER B925
80-0539-05

