

PARTS CATALOG NO. 9516

MAY 1988

PORTER SPECIAL AUTOMOTIVE OVERCASTER

**MODELS: PTF 504 A
 PWF 504 A**

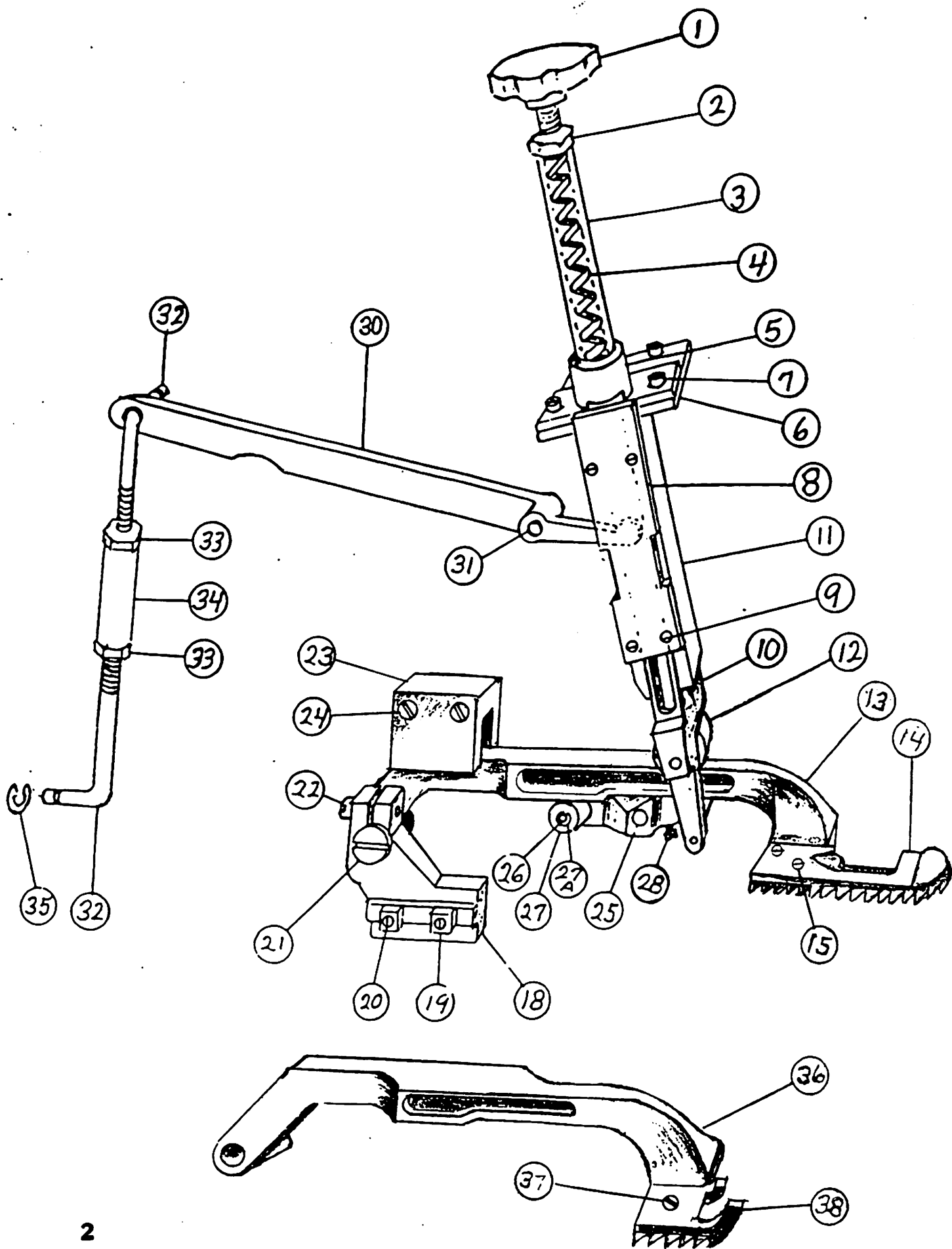
Porter
INTERNATIONAL

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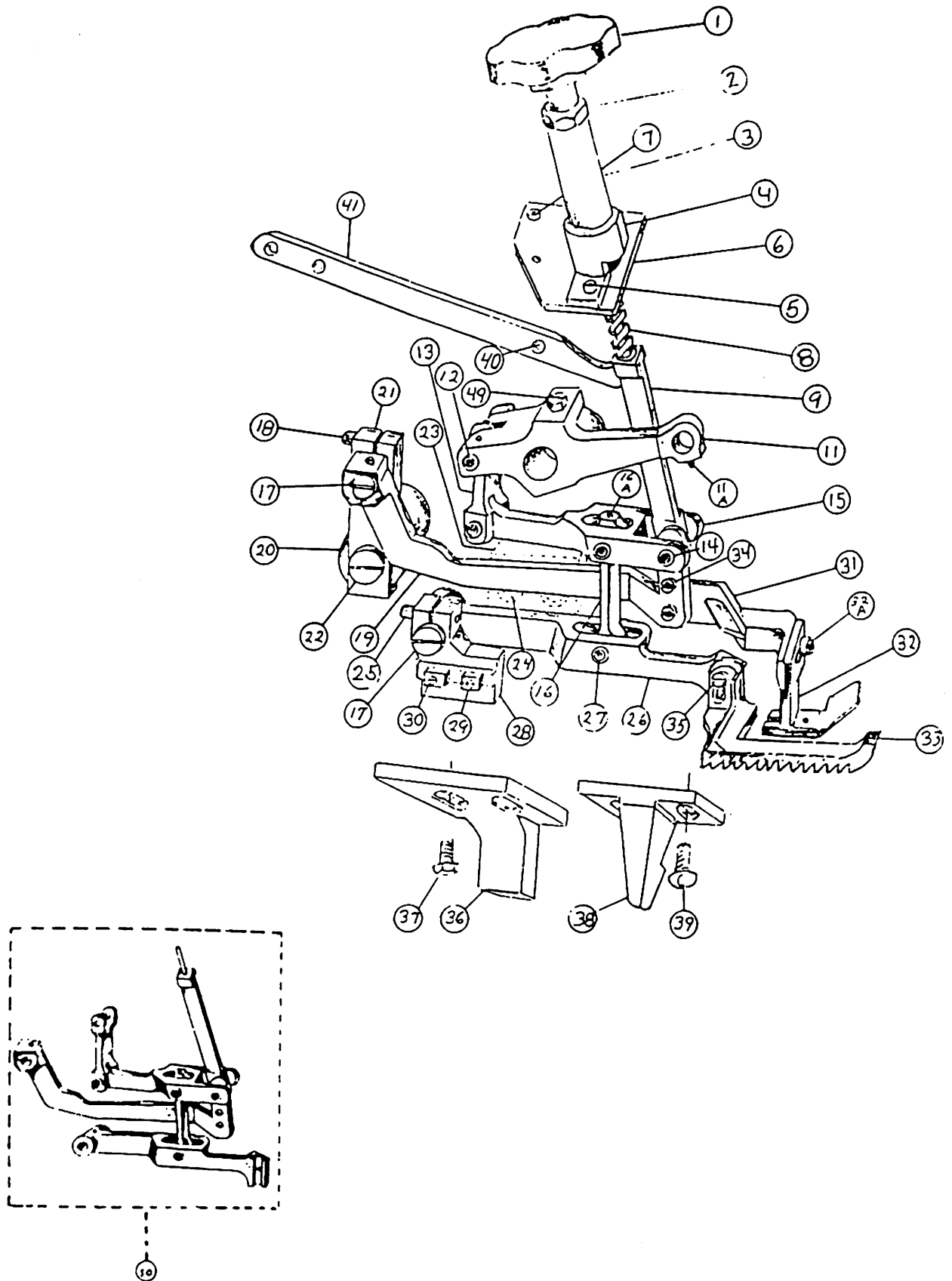
TABLE OF CONTENTS

PTF 504A "ONLY" TOP FEED MECHANISM	2	-	3
PWF 504A "ONLY" WALKING FOOT MECHANISM	4	-	5
MACHINE BED FRAME	6	-	7
(1) MISCELLANEOUS COVERS	8	-	9
(2) MISCELLANEOUS COVERS	10	-	11
CRANKSHAFT MECHANISM	12	-	13
(1) NEEDLE DRIVE MECHANISM	14	-	15
(2) NEEDLE DRIVE MECHANISM	16	-	17
(3) NEEDLE DRIVE MECHANISM	18	-	19
RIGHT LOOPER DRIVE MECHANISM	20	-	21
LEFT LOOPER DRIVE MECHANISM	22	-	23
(1) MAIN AND DIFFERENTIAL FEED DRIVE MECHANISM	24	-	25
(2) MAIN AND DIFFERENTIAL FEED DRIVE MECHANISM	26	-	27
LIFTER & GUIDE	28	-	29
PRESSER FOOT AND LIFT MECHANISM	30	-	31
LUBRICATING MECHANISM	32	-	33
THREAD STAND	34	-	35
ACCESSORIES	36	-	37
MACHINE ADJUSTMENTS	38		



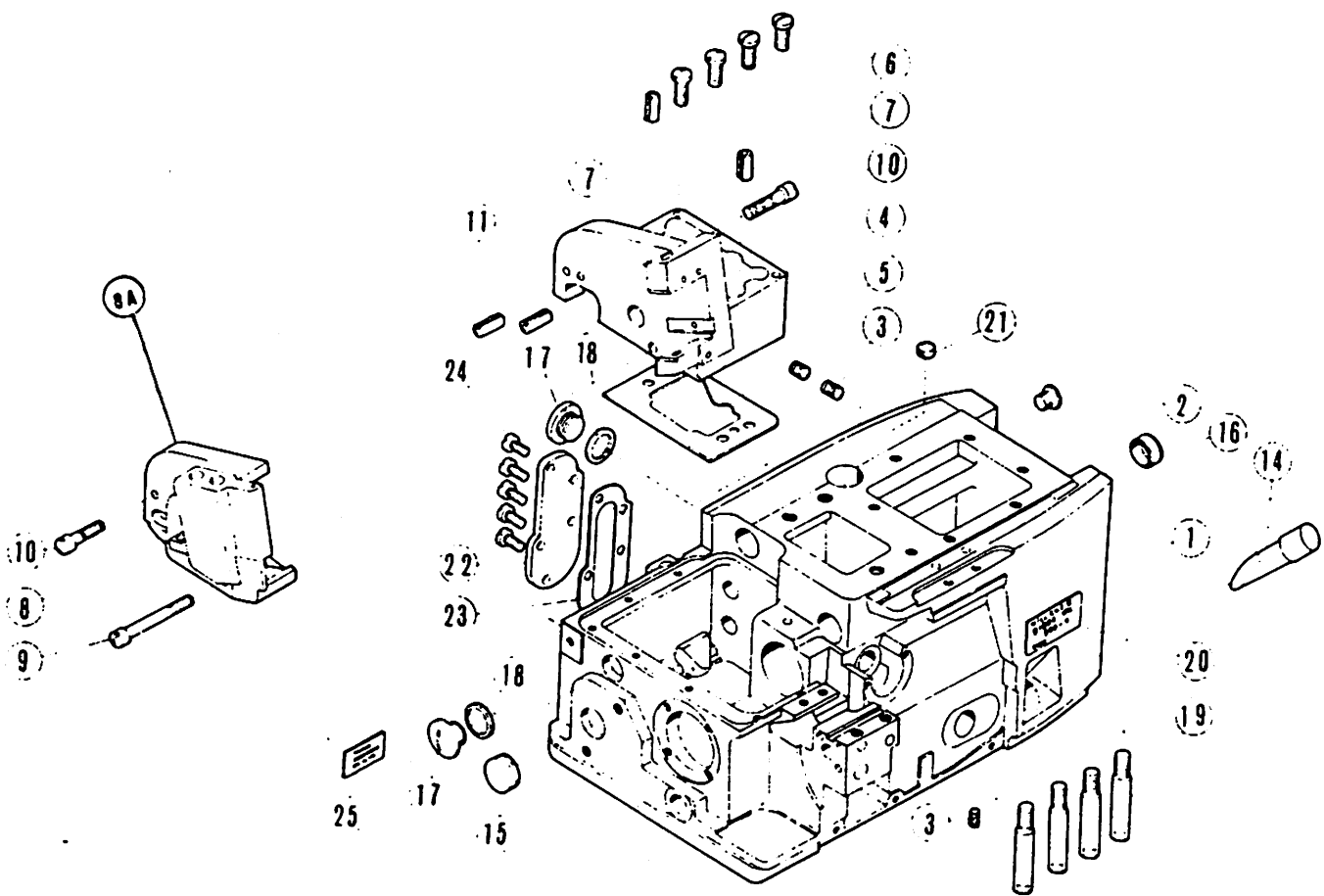
PTF 504A "ONLY"
TOP FEED MECHANISM

REF. NO.	PORTER NO.	DESCRIPTION	QTY.
1	1185	THUMBSCREW	1
2	1186	NUT	1
3	1442	SPRING GUIDE SLEEVE	1
4	1184	PRESSURE SPRING	1
5	1440	FLANGE	1
5A	SHCS8-32X.500	SCREW	2
6	1143	FLANGE BASE	1
7	SHCS8-32X.250	SCREW	2
8	1142	PRESSURE BAR COVER	1
9	610940	SCREW	4
10	1256	PRESSURE BAR ASSEMBLY	1
11	1140	PRESSURE BAR GUIDE BLOCK	1
12	1187	PRESSURE ROLLER	1
12A	5133-12	RETAINER	1
13	1233	TOP FEED ARM	1
14	1234	TOP FEED FOOT	1
15	FHS 9/64X36	SCREW	2
18	1201	TOP FEED HOLDER	1
19	1209	TOP FEED HOLDER NUTS	2
20	619820	SCREW	2
21	1271	ECCENTRIC STUD	1
22	SHCS4-40X.375	SCREW	1
23	1146	GUIDE BLOCK	1
24	FHS	SCREW	2
25	1370	LIFTER ASSEMBLY	1
26	1206	LIFTER PIN	1
27	1247	LIFTER ROLLER	1
27A	5560-18	RETAINER	1
28	SCS 6x32x7/8	SCREW	1
30	1166	AUX. LIFTER ARM	1
31	DP 3/16X.874	AUX. LIFTER ARM PIN	1
32	1214	CONNECTOR	2
33	HN8-32	NUT	2
34	2219	KEYSTONE CONNECTOR	1
35	5133-15	RETAINER	2
36	1212	TOP FEED ARM	1
37	FHS 9/64x36	SCREW	1
38	1179	SKI	1



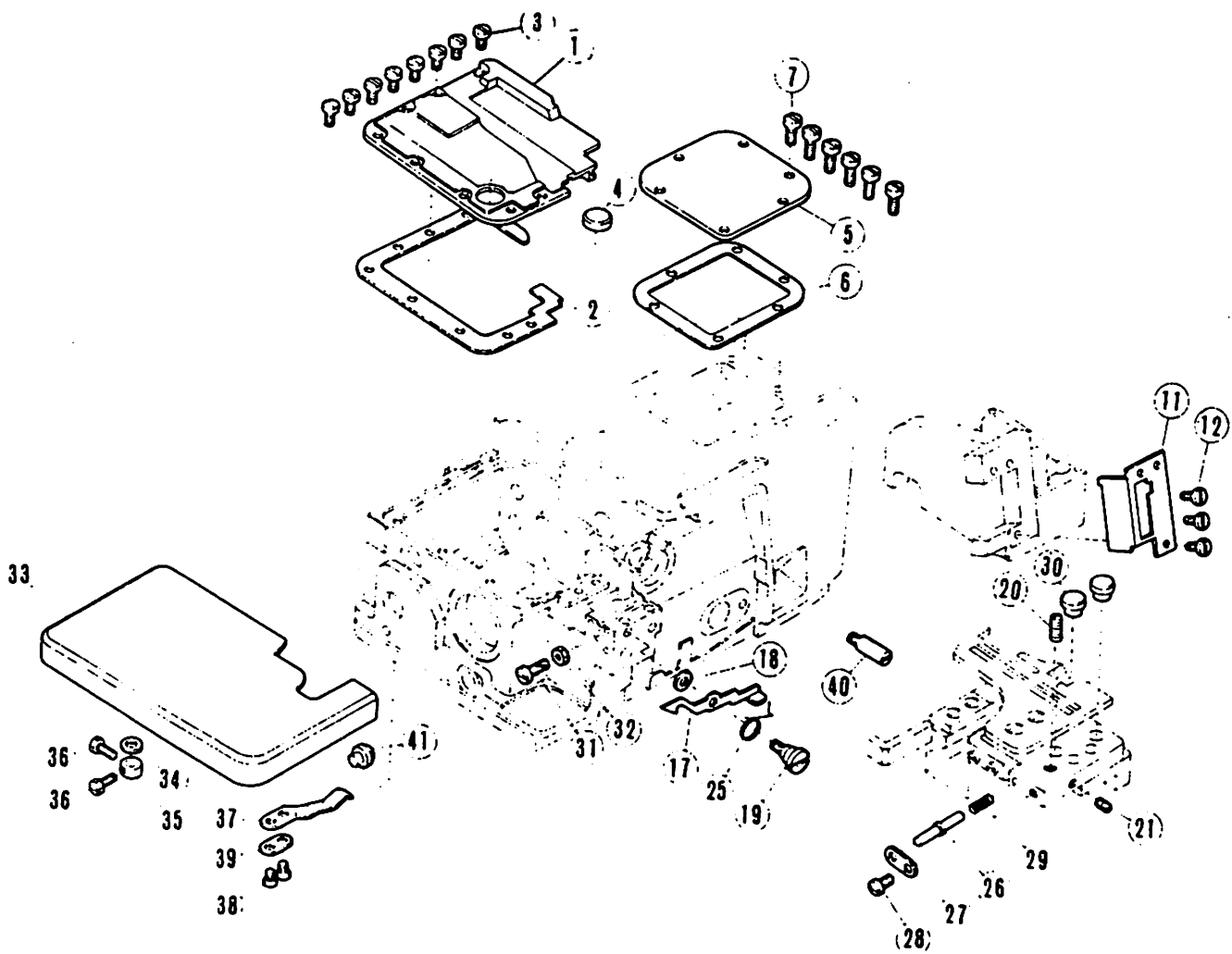
PWF 504A "ONLY"
WALKING FOOT MECHANISM

REF. NO.	PORTER NO.	DESCRIPTION	QTY.
1	1185	THUMBSCREW	1
2	1186	THUMBSCREW NUT	1
3	1730	PRESSURE SPRING SLEEVE	1
4	1737	PRESSURE SPRING BASE	1
5	SHCS8-32X.125	FLANGE SCREW	1
6	1728	PRESSURE SPRING MNTG. BLOCK	1
7	SHCS8-32X.500	SCREW	3
8	1184	PRESSURE SPRING	1
9	1729	PRESSER BAR	1
11	1738	NEEDLE DRIVE ARM	1
11A	619400	SCREW	1
12	1719	PIVOT PIN CONN. LINK	1
13	1706	LINK BEAM CONNECTOR	1
14	1720	PIVOT PIN (LONG)	2
15	1739	WALKING FOOT BEAM	1
16	1912	LINK TOP FEED CONNECTOR	1
16A	HLSS4-40X.078	SCREW	7
17	1271	ECCENTRIC STUD	2
18	SHCS6-32X.500	CLAMP SCREW	1
19	1709	PRESSER FOOT BEAM	1
20	1724	LOCATING STUD	1
21	1725	LOCATING BAR	1
22	PHMS1/4-28X.750	SCREW	1
23	1712	INSIDE RUBBING BLOCK	1
24	SHCS8-32X.500	SCREW	2
25	SHCS4-40X.375	CLAMP SCREW	1
26	1708	TOP FEED MAIN BEAM	1
27	1718	PIVOT PIN (SHORT)	2
28	1201	TOP FEED HOLDER	1
29	1209	TOP FEED HOLDER NUT	2
30	619820	TOP FEED HOLDER SCREW	2
31	1903	PRESSER FOOT EXTENSION	1
32	1887	PRESSER FOOT	1
32A	SHCS5-40X.250	SCREW	1
33	1722	WALKING TOP FEED FOOT	1
34	SHCS5-40X.250	SCREW	2
35	618420	WALKING FOOT SET SCREW	1
36	1831	RETAINING BLOCK REAR	1
37	HB10-32X.500	SCREW	2
38	2033	RETAINING BLOCK (FRONT)	1
39	BHS10-32X.375	SCREW	2
40	DP 3/16X.750	AUX. LIFTER ARM DOWEL PIN	1
41	2368	AUX. LIFTER ARM	1
49	611620	SCREW	1
50	10001	LINKAGE ASSEMBLY	1



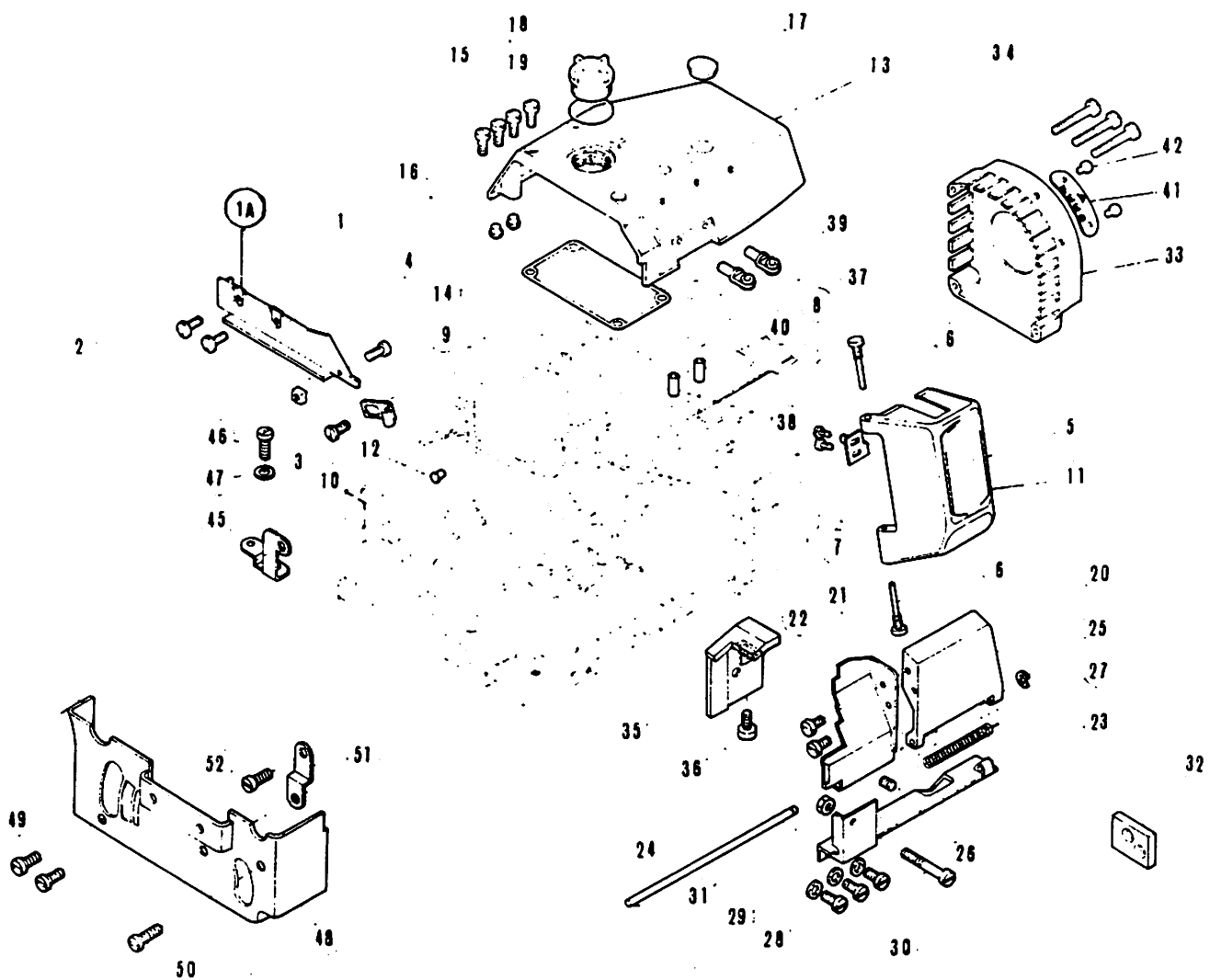
MACHINE BED FRAME

REF. NO.	PORTER NO.	DESCRIPTION	QTY.
1	617115	MACHINE BED FRAME	1
2	619540	OIL HOLE PLUG SCREW (WITH HEAD)	1
3	611618	OIL HOLE PLUG SCREW	3
4	617140	MACHINE ARM (RIGHT)	1
5	613580	GASKET	1
6	618500	SCREW	1
7	610980	DOWEL PIN	2
8	1935	MACHINE ARM (LEFT)	1
8A	1734	PWF 504A ONLY	1
9	619240	SCREW (LONG)	1
10	619000	SCREW (SHORT)	2
11	610980	DOWEL PIN	2
12	616650	OIL SHIELD	1
13	615210	GASKET	1
14	612000	OIL SIGHT GAUGE	1
15	615220	DEAD HOLE PLUG	1
16	614330	DEAD HOLE PLUG	1
17	619040	DEAD HOLE PLUG SCREW (SMALL)	2
18	611000	DEAD HOLE PLUG SCREW (SMALL) WASHER	2
19	612020	MACHINE BED BOTTOM PIN	4
21	614280	MACHINE BED OIL FILTER	1
22	617380	MACHINE BED COVER PLATE (BACK)	1
23	615755	GASKET	1
24	618740	SCREW	5
25	616905	MANUFACTURER'S NAME PLATE	1



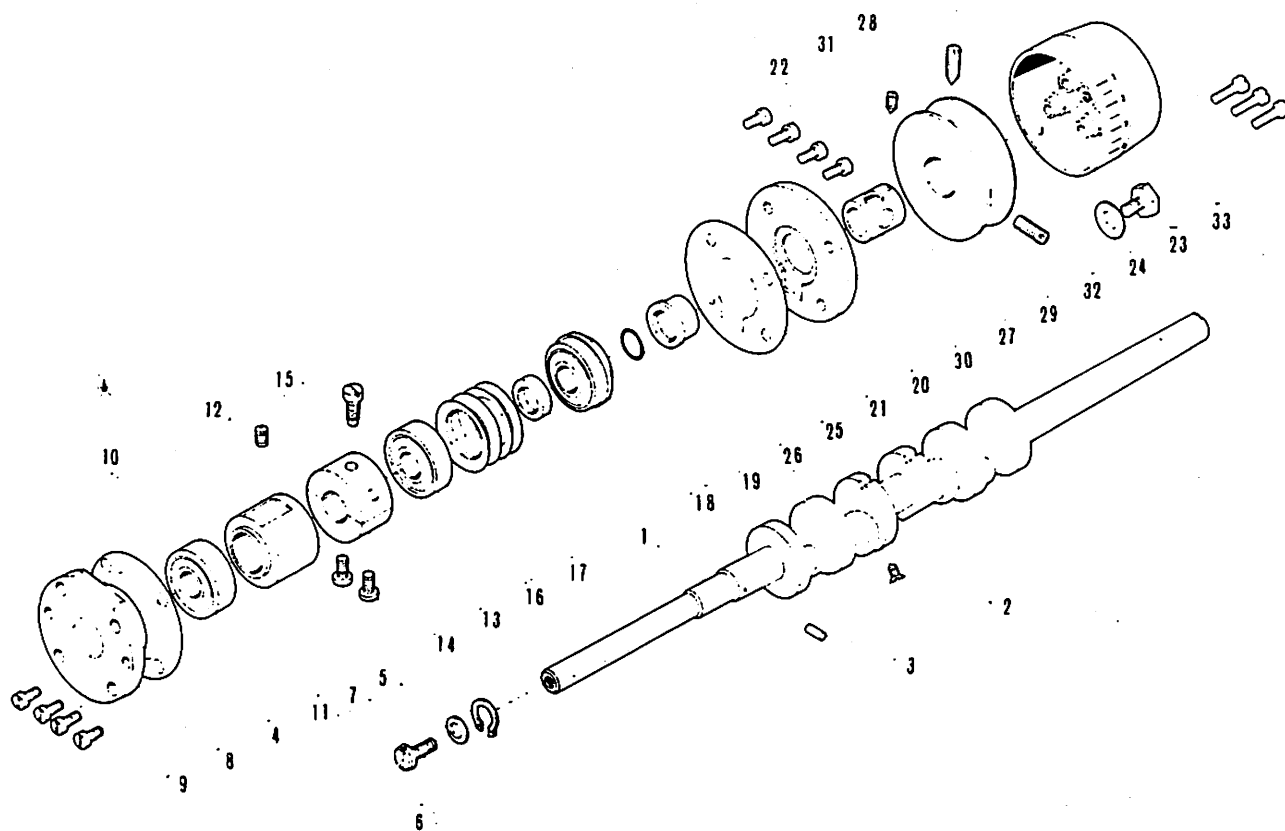
(1) MISCELLANEOUS COVERS

REF. NO.	PORTER NO.	DESCRIPTION	QTY.
1	615965	BED PLATE, COMPLETE	1
2	616540	GASKET	1
3	618340	SCREW	8
4	614340	CLOTH PLATE CUSHION (LARGE)	1
5	616100	BED COVER PLATE (RIGHT)	1
6	616120	GASKET	1
7	618740	SCREW	6
11	616640	FACE PLATE, COMPLETE	1
12	618340	SCREW	3
17	614065	LATCH	1
18	612705	LATCH SPACER	1
19	619665	LATCH SCREW	1
20	1435	LATCH ADJUST SCREW	1
21	1459	LATCH ADJUST SCREW LOCK SCREW	1
25	614070	SPRING	1
26	614075	PUSH PIN	1
27	614077	PUSH PIN GUIDE	1
28	618420	PUSH PIN GUIDE SCREW	1
29	614078	PUSH PIN SPRING	1
30	614079	RUBBERE PLUG (SMALL)	2
31	619800	STOP SCREW	1
32	618280	STOP SCREW NUT	1
33	617165	CLOTH PLATE (WIDE), COMPLETE	1
34	611760	HINGE STUD THRUST WASHER	1
35	611260	HINGE STUD THRUST COLLAR	1
36	618600	HINGE STUD THRUST COLLAR SCREW	2
37	613520	LOCK SPRING	1
38	610200	LOCK SPRING SCREW	2
39	610900	LOCK SPRING SCREW WASHER	1
40	619180	LOCK SPRING PIN	1
41	616820	RUBBER PLUB (SMALL)	1



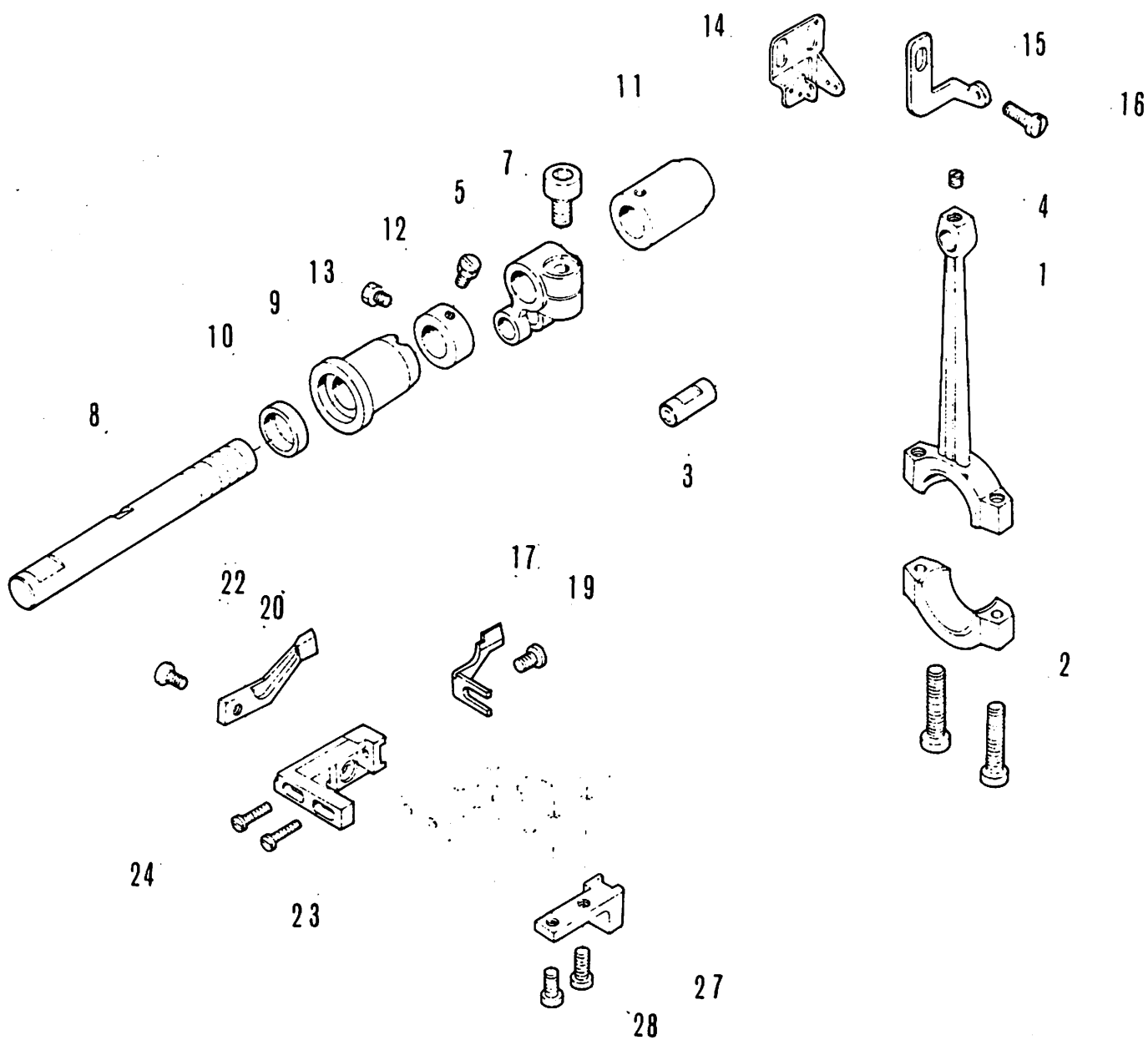
(2) MISCELLANEOUS COVERS

REF. NO.	PORTER NO.	DESCRIPTION	QTY.
1	1250	CLOTH PLATE FABRIC GUARD PTF 504A ONLY	1
1A	1795	CLOTH PLATE FABRIC GUARD PWF 504A ONLY	1
2	618340	SCREW	2
3	614010	SPACER	1
4	618220	SPACER SCREW	1
5	614940	NEEDLE BAR COVER	1
6	611820	HINGE PIN	2
7	611860	LOCK SPRING	1
8	610220	LOCK SPRING SCREW	2
9	613530	LOCK SPRING LATCH	1
10	618340	LOCK SPRING LATCH SCREW	1
11	613785	NAME PLATE	1
12	610650	CUSHION RUBBER	1
13	615860	TOP COVER	1
14	616800	GASKET	1
15	618980	SCREW	4
16	616820	CUSHION	2
17	616060	PLUG	1
18	614820	OIL SPLASH SIGHT WINDOW (ALSO USED FOR OILING)	1
19	614840	'O' RING	1
20	614860	FRONT COVER (RIGHT)	1
21	614870	FRONT COVER (LEFT)	1
22	610140	SCREW	2
23	614880	HINGE	1
24	614900	HINGE PIN	1
25	610920	HINGE PIN RETAINING RING	1
26	618920	HINGE SCREW	1
27	614920	HINGE SPRING	1
28	610200	HINGE SCREW (SMALL)	3
29	610400	HINGE SCREW WASHER	3
30	618660	HINGE SCREW (LONG)	1
31	618800	HINGE SCREW (LONG) NUT	1
32	613910	SPACER	1
33	613960	OIL COOLER COVER	1
34	618660	SCREW	3
35	617145	RIGHT LOOPER LEVER OIL SHIELD, COMPLETE	1
36	618940	SCREW	1
37	611060	RIGHT LOOPER THREAD EYELET	1
38	611140	RIGHT LOOPER THREAD TUBE	1
39	611060	LEFT LOOPER THREAD EYELET	1
40	611140	LEFT LOOPER THREAD TUBE	1
41	613940	STITCH INDICATOR	1
42	614200	RIVET	2
45	614440	SPACER	1
46	618120	SPACER SCREW	1
47	611640	SPACER SCREW WASHER	1
48	614420	MACHINE COVER (LEFT)	1
49	618640	SCREW (SHORT)	2
50	619060	SCREW (LONG)	1
51	614430	SPACER	1
52	618720	SPACER SCREW	1



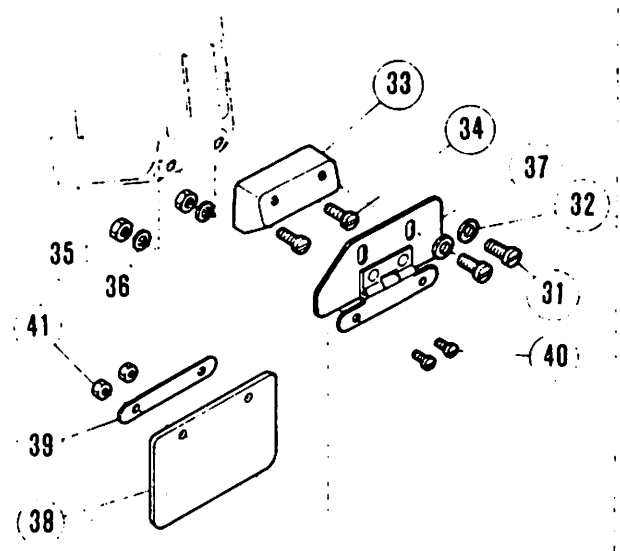
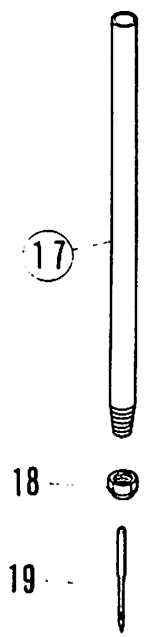
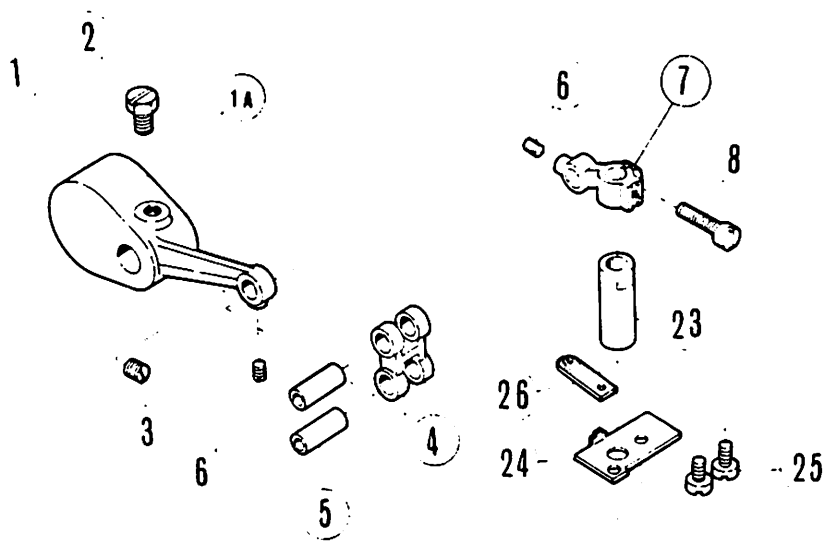
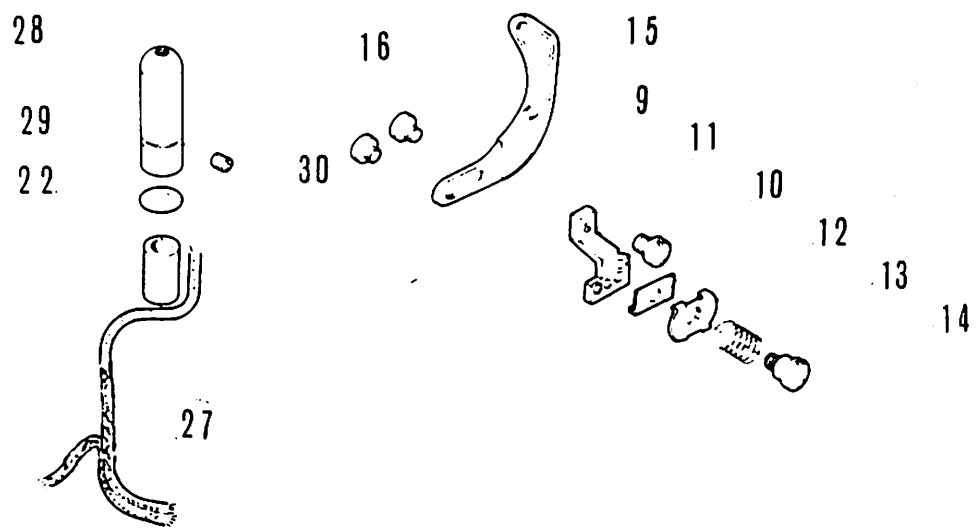
CRANKSHAFT MECHANISM

REF. NO.	PORTER NO.	DESCRIPTION	QTY.
1	616140	CRANKSHAFT	1
2	619440	OIL PLUG SCREW	1
3	611580	OIL FELT	1
4	612040	BALL BEARING (LEFT)	1
5	614050	BALL BEARING (LEFT) RETAINING RING	1
6	619660	BALL BEARING (LEFT) SCREW	1
7	613840	BALL BEARING (LEFT) SCREW WASHER	1
8	614055	BALL BEARING (LEFT) HOUSING	1
9	618780	BALL BEARING (LEFT) HOUSING SCREW	4
10	613680	BALL BEARING (LEFT) HOUSING GASKET	1
11	612060	BUSHING	1
12	611680	BUSHING SCREW	1
13	612080	BUSHING (CENTER)	1
14	610080	BUSHING (CENTER) ASSEMBLY SCREW	2
15	619300	BUSHING (CENTER) SCREW	1
16	611480	BALL BEARING (CENTER)	1
17	612100	BALL BEARING (CENTER) WASHER	4
18	612120	BALL BEARING (CENTER) SPACER	1
19	612140	BALL BEARING (RIGHT)	1
20	612160	BALL BEARING (RIGHT) PLATE	1
21	612180	BALL BEARING (RIGHT) PLATE GASKET	1
22	618740	BALL BEARING (RIGHT) PLATE SCREW	4
23	619260	BALL BEARING (RIGHT) SCREW	1
24	612200	BALL BEARING (RIGHT) SCREW WASHER	1
25	615520	OIL SEAL COLLAR	1
26	615540	OIL SEAL COLLAR 'O' RIGHT	1
27	612300	MACHINE PULLEY	1
28	618520	POSITION SCREW	1
29	618540	SCREW	1
30	612240	COLLAR	1
31	619340	COLLAR SCREW	1
32	616020	CAP	1
33	618360	CAP SCREW	3



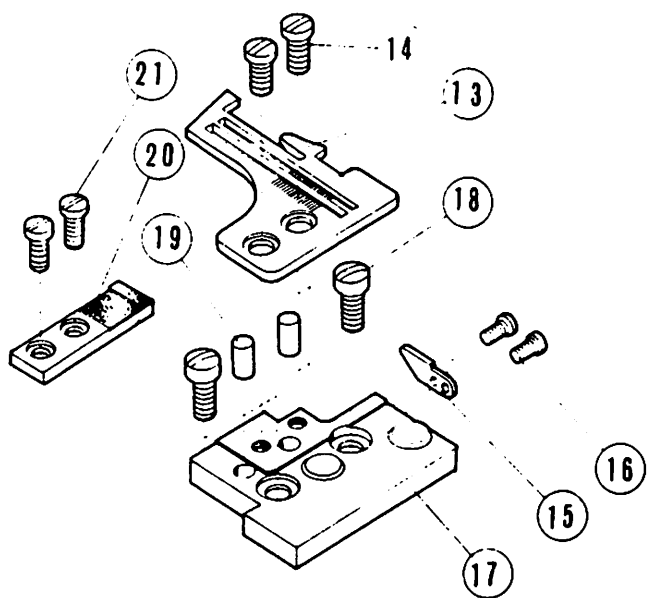
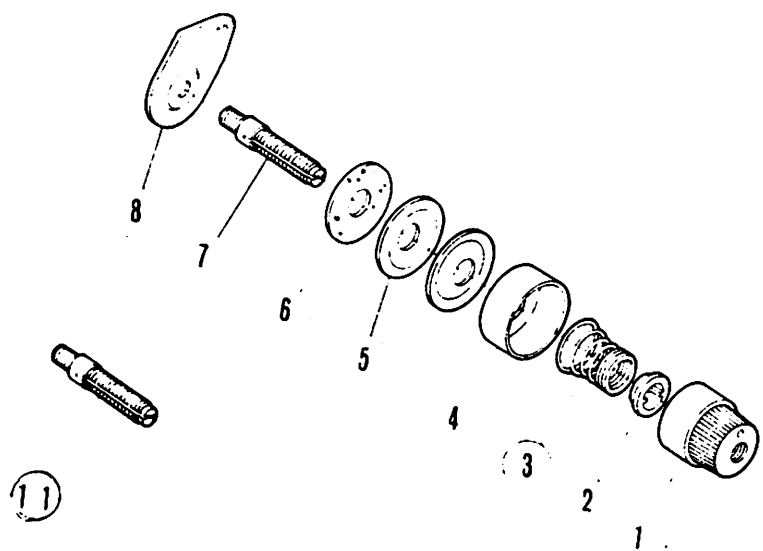
(1) NEEDLE DRIVE MECHANISM

REF. NO.	PORTER NO.	DESCRIPTION	QTY.
1	612260	NEEDLE BAR DRIVE CONNECTION	1
2	619100	CAP SCREW	2
3	614760	PIN	1
4	619220	PIN SCREW	1
5	611440	NEEDLE BAR DRIVE CRANK	1
7	619700	CLAMP SCREW	1
8	616600	NEEDLE BAR DRIVE SHAFT	1
9	616610	BUSHING (LEFT)	1
10	616620	BUSHING (LEFT) OIL SEAL	1
11	615440	BUSHING (RIGHT)	1
12	611220	THRUST COLLAR	1
13	618600	THRUST COLLAR SCREW	2
14	611885	NEEDLE THREAD GUIDE	1
15	616222	NEEDLE THREAD GUIDE	1
16	618340	SCREW	1
17	613925	NEEDLE GUARD (FRONT)	1
19	1206	SCREW	1
20	613926	NEEDLE GUARD (REAR)	1
22	1206	SCREW	1
23	613927	NEEDLE GUARD BRACKET	1
24	610120	SCREW	2
27	614185	EDGE GUIDE HOLDER BRACKET BASE	1
28	610100	SCREW	2



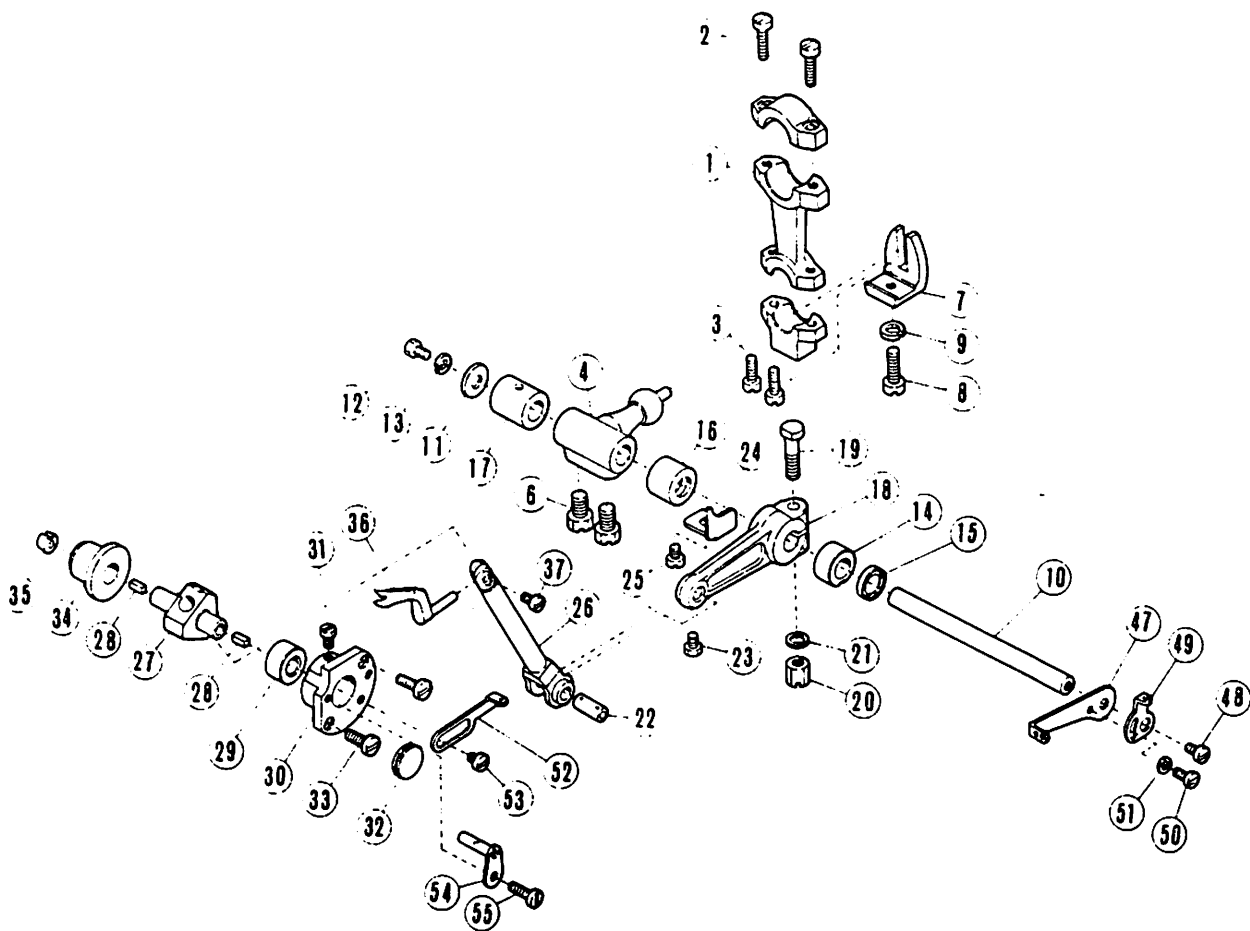
(2) NEEDLE DRIVE MECHANISM

REF. NO.	PORTER NO.	DESCRIPTION	QTY.
1	616560	NEEDLE BAR DRIVE CRANK (LEFT) PTF 504A ONLY	1
1A	1738	NEEDLE BAR DRIVE CRANK (LEFT) PWF 504A ONLY	1
2	611620	SCREW (WITH HEAD)	1
3	611680	SCREW	1
4	616580	NEEDLE BAR CONNECTING LINK	1
5	610960	PIN	2
6	619400	PIN SCREW	2
7	616600	NEEDLE BAR CLAMP	1
8	610060	CLAMP SCREW	1
9	611870	NEEDLE THREAD RETAINER BRACKET	1
10	611720	GUIDE SPACER	1
11	619640	SCREW	1
12	610760	GUIDE	1
13	610905	GUIDE SPRING	1
14	619850	GUIDE SCREW	1
15	611880	NEEDLE THREAD TAKEUP	1
16	619405	SCREW	2
17	613185	NEEDLE BAR	1
18	618325	NEEDLE CLAMP NUT	1
19	PSM 130	NEEDLE PSM 130	1
22	613900	NEEDLE BAR BUSHING (UPPER)	1
23	613920	NEEDLE BAR BUSHING (LOWER)	1
24	617200	DUST SHIELD	1
25	618440	DUST SHIELD SCREW	2
26	617220	OIL RELEASE FELT	1
27	611600	OIL WICK	1
28	617240	NEEDLE BAR CAP	1
29	610740	'O' RING	1
30	610420	SCREW	1
31	610060	HINGE SCREW	2
32	610970	HINGE SCREW WASHER	2
33	614713	HINGE BASE	1
34	618355	HINGE BASE SCREW	2
35	618665	HINGE BASE SCREW NUT	2
36	610480	HINGE BASE SCREW NUT WASHER	2
37	614667	HINGE, COMPLETE	1
38	614668	GUARD	1
39	614669	GUARD SCREW NUT WASHER	1
40	618170	GUARD SCREW	2



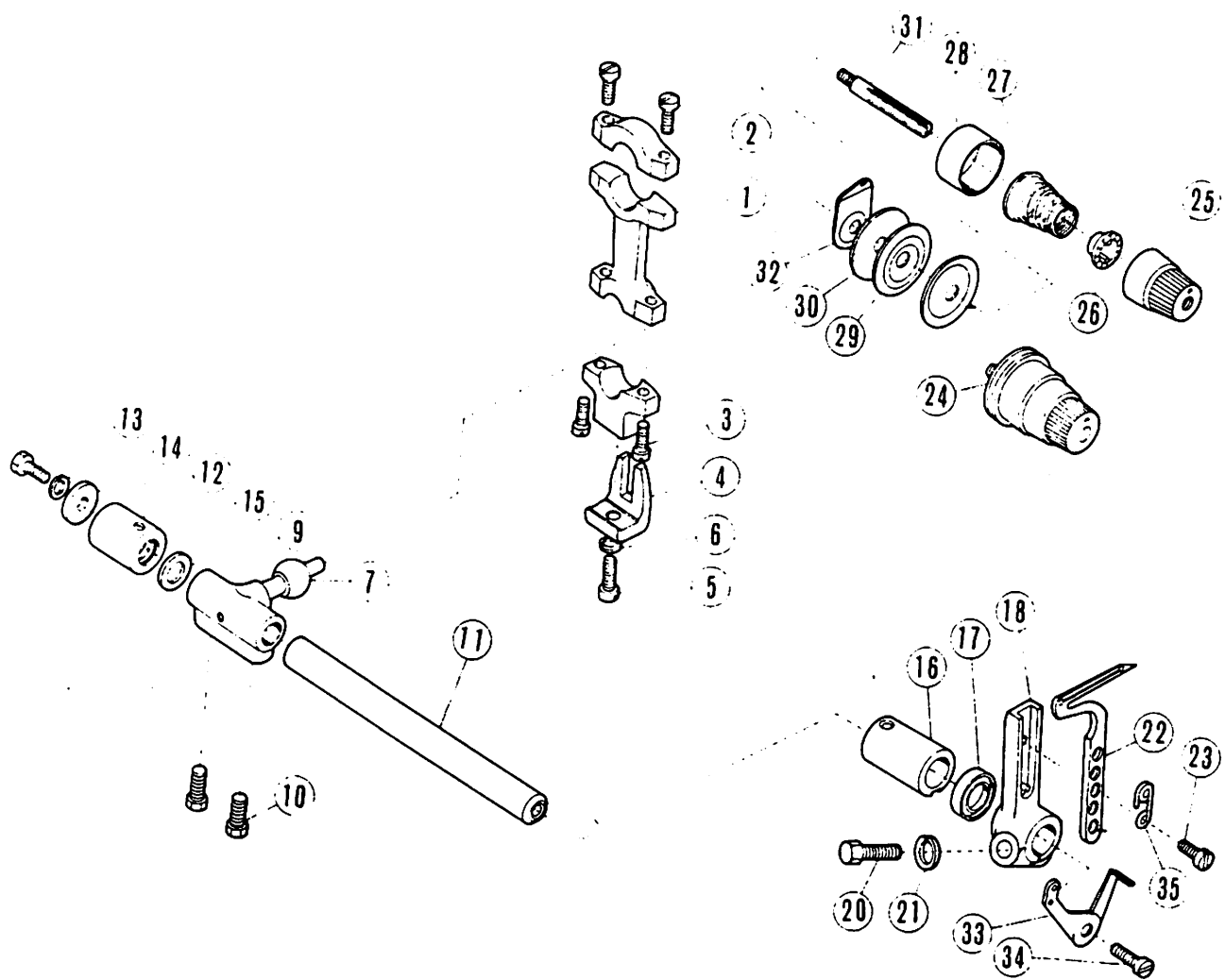
(3) NEEDLE DRIVE MECHANISM

REF. NO.	PORTER NO.	DESCRIPTION	QTY.
--	616840	NEEDLE THREAD TENSION, COMPLETE	1
1	616680	NUT	1
2	616700	SPRING BUSHING	1
3	611040	SPRING (HEAVY)	1
4	616740	SPRING CUP	1
5	611460	DISC	2
6	616720	CUSHION FELT	1
7	618560	POST	1
8	611920	GUIDE	1
13	614045	NEEDLE PLATE	1
14	618340	SCREW	2
15	613922	KEY	1
16	619402	KEY SCREW	2
17	614081	NEEDLE PLATE BRACKET	1
18	619625	SCREW	2
19	613921	GUIDE PIN	2
20	613923	NEEDLE PLATE SUPPORT	1
21	618640	SCREW	2
--	617045	NEEDLE BAR CONNECTING LINK COVER, COMPLETE	1



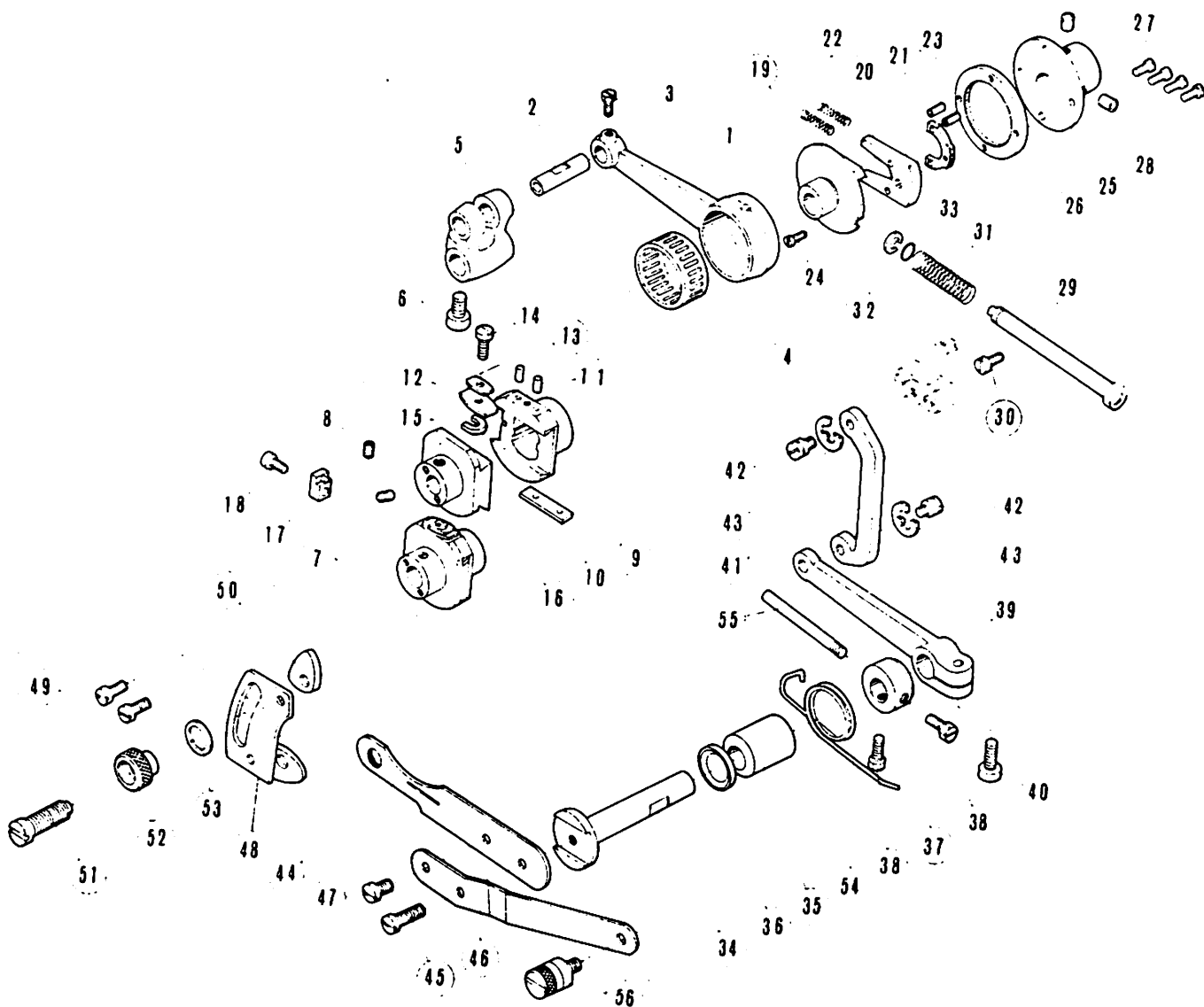
RIGHT LOOPER DRIVE MECHANISM

REF. NO.	PORTER NO.	DESCRIPTION	QTY.
1	616160	RIGHT LOOPER DRIVE CONNECTION	1
2	617600	CAP SCREW (LARGE)	2
3	610040	CAP SCREW (SMALL)	2
4	614250	DRIVE CRANK	1
6	611620	SCREW	2
7	611160	GUIDE	1
8	1156	GUIDE SCREW	1
9	611640	GUIDE SCREW WASHER	1
10	612400	RIGHT LOOPER DRIVE SHAFT	1
11	613660	THRUST WASHER	1
12	617540	THRUST WASHER SCREW	1
13	611640	THRUST WASHER SCREW WASHER	1
14	615860	BUSHING (FRONT)	1
15	612300	BUSHING (FRONT) OIL SEAL	1
16	612440	BUSHING (CENTER)	1
17	616620	BUSHING (REAR)	1
18	612340	RIGHT LOOPER LEVER CRANK	1
19	619280	CLAMP SCREW	1
20	619380	CLAMP SCREW NUT	1
21	611560	CLAMP SCREW NUT WASHER	1
22	615480	PIN	1
23	618600	PIN SCREW	1
24	615840	SET PLATE	1
25	618940	SET PLATE SCREW	1
26	615985	RIGHT LOOPER LEVER	1
27	615090	GUIDE	1
28	613600	OIL FELT	2
--	614400	RIGHT LOOPER LEVER GUIDE BUSHING (FRONT), COMPLETE	1
29	612345	BUSHING (FRONT)	1
30	612346	HOUSING	1
31	618600	BUSHING (FRONT) SCREW	1
32	615220	HOUSING CAP	1
33	610100	HOUSING CAP SCREW	2
34	617080	RIGHT LOOPER LEVER GUIDE BUSHING (REAR)	1
35	617060	CAP	1
36	614020	SPREADER	1
37	610700	CLAMP SCREW	1
47	616660	RIGHT LOOPER THREAD TAKEUP	1
48	611970	SCREW	1
49	614640	AUXILIARY	1
50	618200	AUXILIARY SCREW	1
51	611960	AUXILIARY SCREW WASHER	1
52	614660	RIGHT LOOPER THREAD GUIDE WIRE	1
53	618140	SCREW	1
54	613970	LOOPER THREAD GUIDE, COMPLETE	1
55	618380	SCREW	1



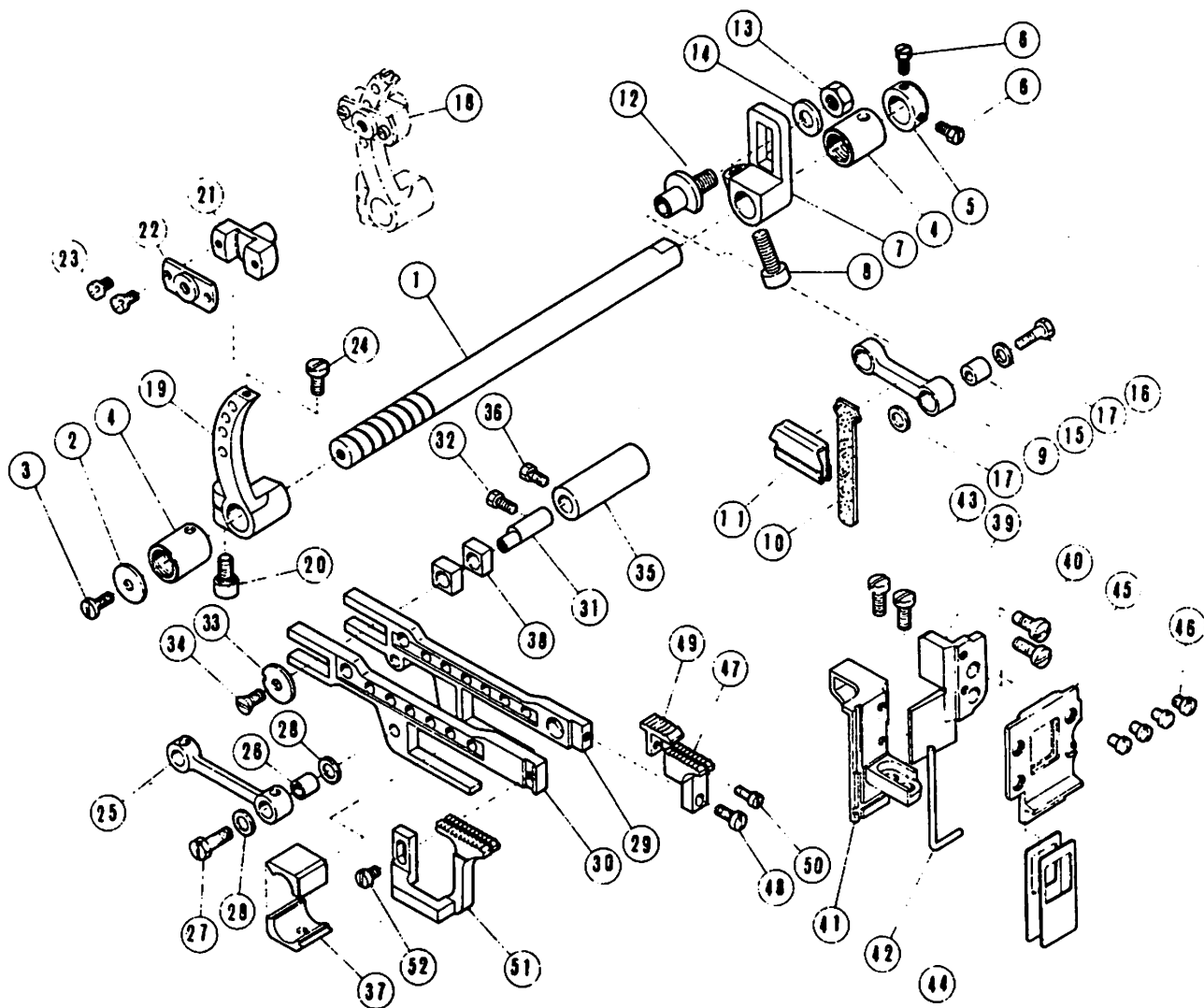
LEFT LOOPER DRIVE MECHANISM

REF. NO.	PORTER NO.	DESCRIPTION	QTY.
1	616160	LEFT LOOPER DRIVE CONNECTION	1
2	617600	CAP SCREW (LARGE)	2
3	610040	CAP SCREW (SMALL)	2
4	611160	GUIDE	1
5	1156	GUIDE SCREW	1
6	611640	GUIDE SCREW WASHER	1
7	614250	LEFT LOOPER DRIVE CRANK	1
9	614260	THRUST WASHER	1
10	611620	SCREW	2
11	612400	LEFT LOOPER LEVER SHAFT	1
12	613650	THRUST WASHER	1
13	617540	THRUST WASHER SCREW	1
14	611640	THRUST WASHER SCREW WASHER	1
15	612320	BUSHING (REAR)	1
16	615780	BUSHING (FRONT)	1
17	612300	BUSHING (FRONT) OIL SEAL	1
18	614000	LEFT LOOPER LEVER	1
20	619360	CLAMP SCREW	1
21	613640	CLAMP SCREW WASHER	1
22	612420	LEFT LOOPER	1
23	610060	SCREW	1
24	616860	LEFT LOOPER THREAD TENSION, COMPLETE	1
25	616680	NUT	1
26	616700	SPRING BUSHING	1
27	611180	SPRING (MEDIUM)	1
28	616740	SPRING CUP	1
29	611460	DISC	2
30	616720	CUSHION FELT	1
31	618560	POST	1
32	611920	GUIDE	1
33	614248	LEFT LOOPER THREAD TAKEUP	1
34	618120	SCREW	1
35	610660	LEFT LOOPER THREAD GUIDE WIRE	1



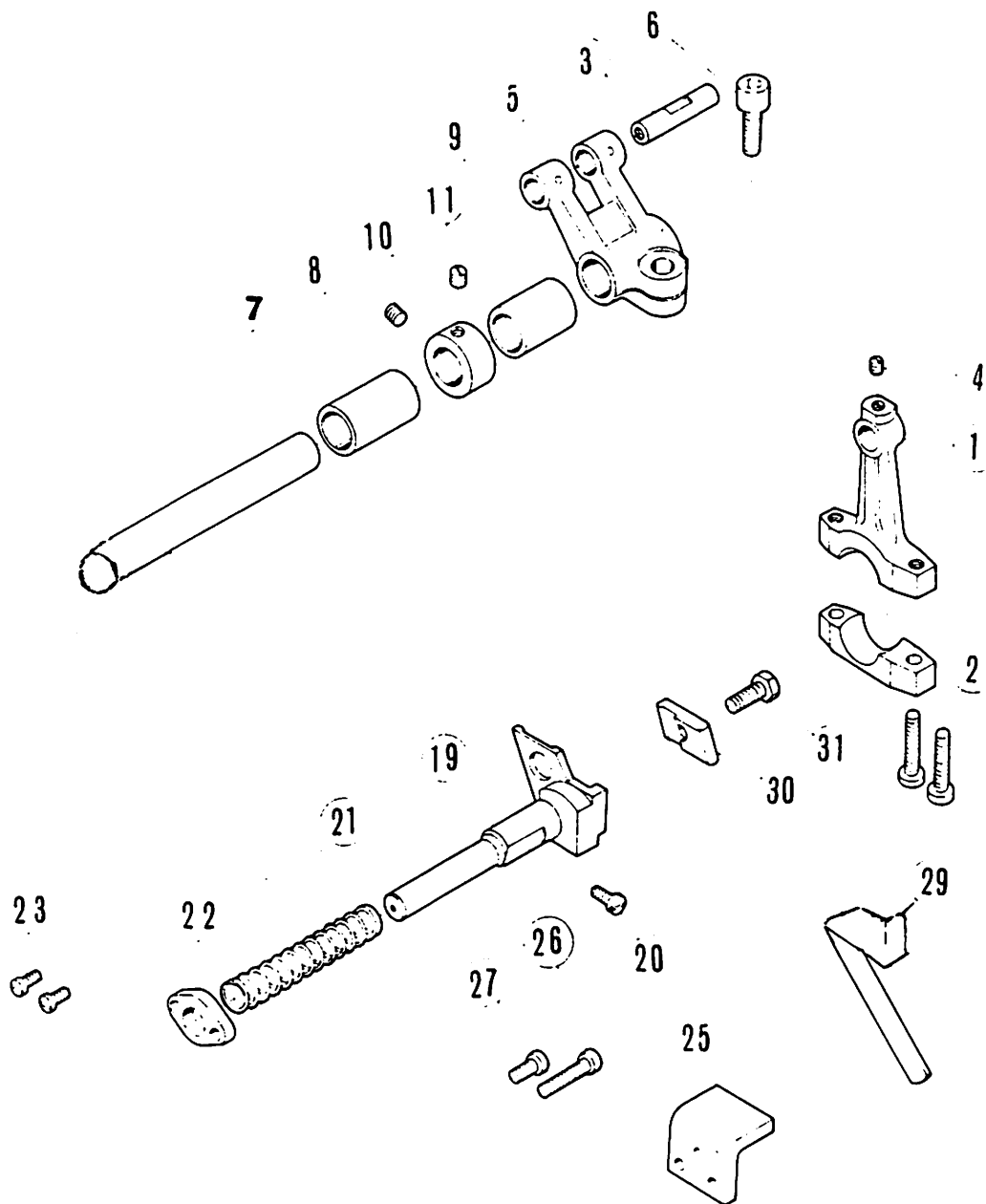
(1) MAIN AND DIFFERENTIAL FEED DRIVE MECHANISM

REF. NO.	PORTER NO.	DESCRIPTION	QTY.
1	612620	FEED DRIVE CONNECTION	1
2	614760	PIN	1
3	618600	PIN SCREW	1
4	612480	NEEDLE BEARING	1
5	1231	FEED DRIVE CRANK	1
6	619700	CLAMP SCREW	1
7	615680	FEED ECCENTRIC, COMPLETE	1
8	619420	SCREW	2
9	615680	FEED ECCENTRIC	1
10	615340	FEED ECCENTRIC LINER	1
11	613740	FEED ECCENTRIC PIN	2
12	615360	FEED ECCENTRIC SPRING PLATE (LARGE)	1
13	615380	FEED ECCENTRIC SPRING PLATE (SMALL)	1
14	1196	FEED ECCENTRIC SPRING PLATE SCREW	1
15	616300	FEED ECCEN.SPRING PLATE SCR.WASHER	1
16	615690	FEED ECCENTRIC RETAINER	1
17	616040	FEED ECCENTRIC STOPPER, COMPLETE	1
18	610120	SCREW	1
19	616320	FEED ECCENTRIC REGULATOR	1
--	616340	FEED ECCEN.REG.POS.GEAR, COMPLETE	1
20	616365	POSITION GEAR BRACKET	1
21	616360	POSITION GEAR	1
22	616400	SPRING	2
23	614415	PIN	2
24	619580	SCREW	1
--	616420	FEED ECCEN.REG.POS.INT.GEAR, COMP.	1
25	616450	INTERNAL GEAR BRACKET	1
26	616440	INTERNAL GEAR	1
27	619680	SCREW	4
28	619420	SCREW	2
29	616500	FEED ECCENTRIC PUSH ROD	1
30	619760	SCREW	1
31	616520	SPRING	1
32	616900	RETAINING RING	1
33	613320	'O' RING	1
34	614100	DIFFERENTIAL FEED SHAFT	1
35	615800	BUSHING	1
36	612300	OIL SEAL	1
37	614120	THRUST COLLAR	1
38	618600	THRUST COLLAR SCREW	2
39	612800	DIFFERENTIAL FEED SHAFT ARM	1
40	619700	CLAMP SCREW	1
41	612820	DIFFERENTIAL FEED LINK	1
42	619460	SCREW	2
43	616900	SCREW RETAINING RING	2
44	614140	DIFF. FEED REG. LEVER (REAR)	1
45	618760	SCREW	1
46	614600	LEVER (FRONT)	1
47	610200	LEVER (FRONT) SCREW	1
48	612840	LEVER GUIDE	1
49	618760	LEVER GUIDE SCREW	2
50	612860	LEVER LIFT GUIDE	2
51	619500	LEVER ADJUST SCREW	1
52	614480	LEVER ADJUST NUT	1
53	611940	LEVER ADJUST NUT WASHER	1
54	614160	DIFFERENTIAL FEED REGULATING SPRING	1
55	614180	LATCH SCREW	1
56	614460	KNEE CONT.CHAIN HOOK LATCH SCREW	1



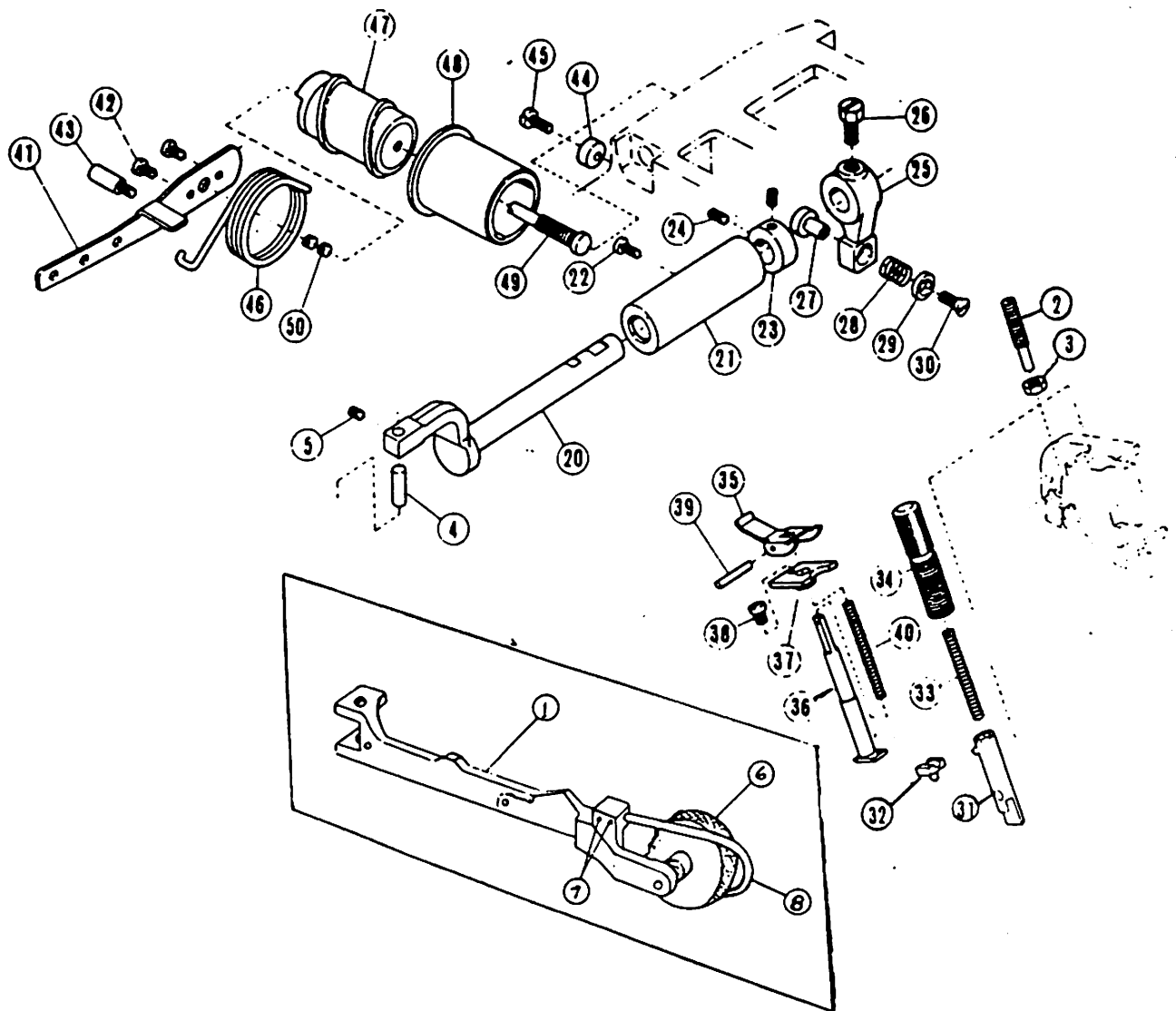
(2) MAIN AND DIFFERENTIAL FEED DRIVE MECHANISM

REF. NO.	PORTER NO.	DESCRIPTION	QTY.
1	614080	FEED BAR SHAFT	1
2	613660	THRUST WASHER	1
3	618340	THRUST WASHER SCREW	1
4	612320	BUSHING	2
5	611100	THRUST COLLAR	1
6	618600	THRUST COLLAR SCREW	2
7	615700	MAIN FEED REGULATING CRANK	1
8	619700	CLAMP SCREW	1
9	612660	MAIN FEED CONNECTING LINK	1
10	613180	OIL FELT	1
11	613860	OIL FELT RETAINER	1
12	615720	PIN	1
13	619710	PIN NUT	1
14	615740	PIN NUT WASHER	1
15	612680	BUSHING	1
16	619140	BUSHING SCREW	1
17	612700	BUSHING SCREW WASHER	2
18	615560	DIFFERENTIAL FEED REGULATOR, COMPLETE	1
19	615580	SEGMENT	1
20	619700	SEGMENT CLAMP SCREW	1
21	615600	BLOCK	1
22	615610	BLOCK COVER	1
23	618420	BLOCK COVER SCREW	2
24	618860	BLOCK STOP SCREW	1
25	612720	DIFFERENTIAL FEED CONNECTING LINK	1
26	612680	BUSHING	1
27	619140	BUSHING SCREW	1
28	612700	BUSHING SCREW WASHER	2
29	612730	MAIN FEED BAR	1
30	612740	DIFFERENTIAL FEED BAR	1
31	612760	FEED BAR HINGE PIN	1
32	618600	SCREW	1
33	613780	WASHER	1
34	619480	WASHER SCREW	1
35	612780	FEED BAR GUIDE BUSHING	1
36	617440	SCREW	1
37	614320	FEED BAR LIFT BLOCK (SPLIT)	1
38	611200	FEED BAR GUIDE BLOCK	2
39	615140	FEED BAR GUIDE (RIGHT)	1
40	619080	SCREW	2
41	615120	FEED BAR GUIDE (LEFT)	1
42	615200	GASKET	1
43	619080	SCREW	2
44	615160	FEED BAR OIL SPLASH GUARD	2
45	615165	INSERT PLATE	1
46	619600	SCREW	4
47	613990	MAIN FEED DOG	1
48	610100	SCREW	1
49	614002	AUXILIARY FEED DOG	1
50	618220	SCREW	1
51	613995	DIFFERENTIAL FEED DOG	1
52	610140	SCREW	1



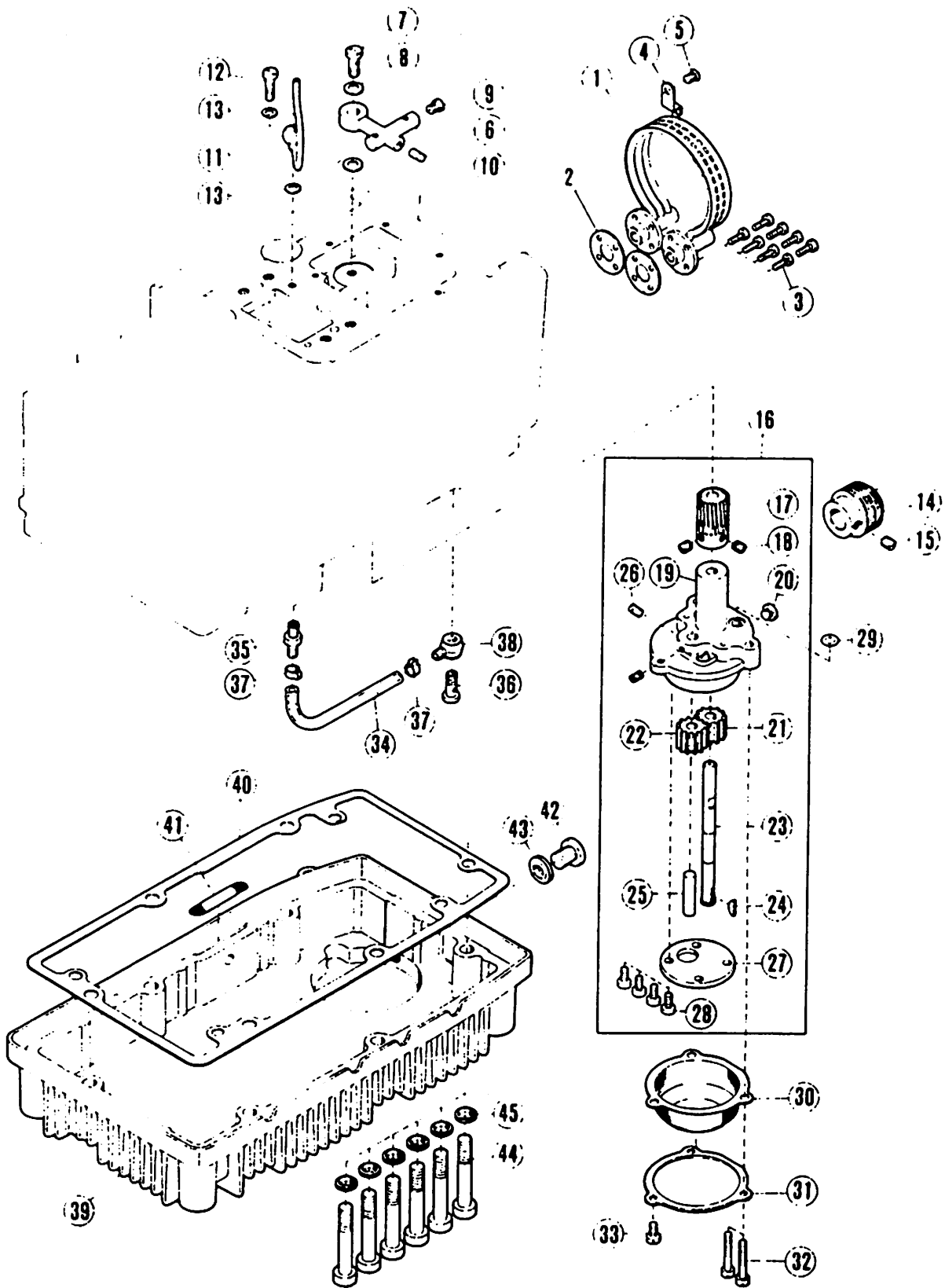
LIFTER & GUIDE MECHANISM

REF. NO.	PORTER NO.	DESCRIPTION	QTY.
1	612880	DRIVE CONNECTION	1
2	619200	CAP SCREW	2
3	612900	PIN	1
4	610440	PIN SCREW	1
5	613000	DRIVE CRANK	1
6	619700	CLAMP SCREW	1
7	1374	LIFTER SHAFT	1
8	613020	BUSHING (LEFT)	1
9	613040	BUSHING (RIGHT)	1
10	611500	THRUST COLLAR	1
11	618460	THRUST COLLAR SCREW	2
19	614186	GUIDE HOLDER	1
20	618354	SCREW	1
21	613080	SPRING	1
22	613100	SPRING SEAT	1
23	618740	SPRING SEAT SCREW	2
25	613120	LOWER HOLDER GUIDE	1
26	610100	SCREW (SHORT)	1
27	618360	SCREW (LONG)	1
29	1950	EDGE GUIDE	1
30	614187	EDGE GUIDE CLAMP	1
31	617540	SCREW	1



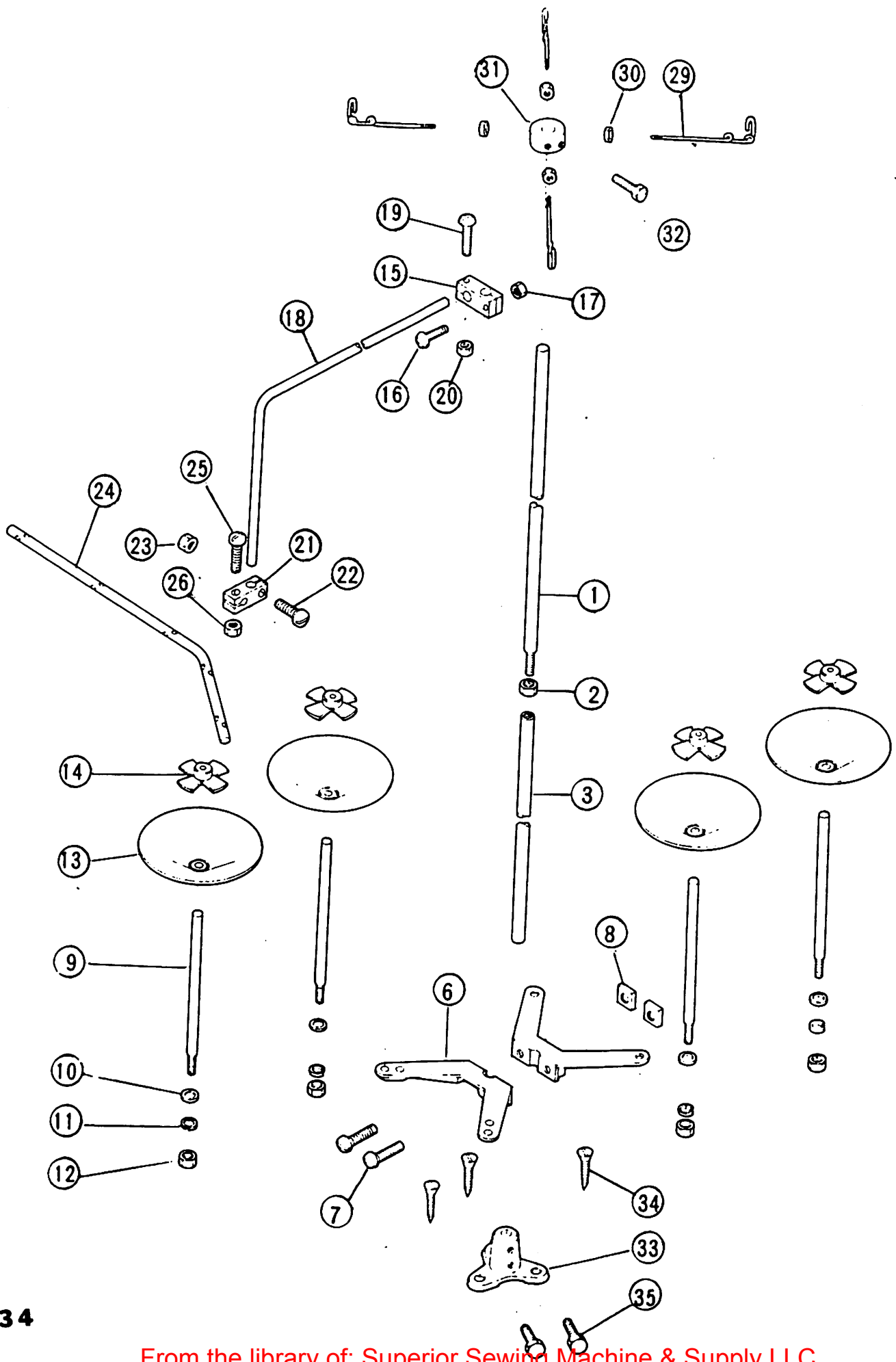
PRESSER FOOT AND LIFT MECHANISM

REF. NO.	PORTER NO.	DESCRIPTION	QTY.
1	1220	PRESSER ARM	1
2	619350	LIFT REGULATING SCREW	1
3	618280	LIFT REGULATING SCREW NUT	1
4	617040	HINGE PIN	1
5	619020	HINGE PIN SCREW	1
6	906	ROLLER ASSEMBLY	1
7	SS2-56X.125	SET SCREW	2
8	1178	HOLD DOWN WIRE	1
20	616960	FOOT LIFT LEVER SHAFT	1
21	616980	BUSHING, COMPLETE	1
22	617440	BUSHING SCREW	1
23	611100	COLLAR	1
24	610420	COLLAR SCREW	2
25	615900	FOOT LIFT INTERMEDIATE LEVER	1
26	611620	SCREW	1
27	615920	PIN	1
28	615940	PIN SPRING	1
29	611900	PIN WASHER	1
30	619480	PIN SCREW	1
31	617000	PRESSER BAR	1
32	616780	GUIDE	1
33	617020	SPRING	1
34	617180	PRESSURE REGULATING THUMB SCREW	1
35	617100	HAND LIFT LEVER	1
36	611780	SPRING PLUNGER	1
37	617120	SPRING PLUNGER BUSHING	1
38	618420	SPRING PLUNGER BUSHING SCREW	1
39	611800	HINGE PIN	1
40	611420	SPRING	1
41	613220	FOOT LIFT LEVER	1
42	610180	SCREW	2
43	619180	STOP SCREW	1
44	611840	REGULATOR	1
45	618760	REGULATOR SCREW	1
46	613240	SPRING	1
47	614680	FOOT LIFT CAM	1
48	614700	BUSHING	1
49	615960	REGULATING SCREW STUD	1
50	618160	REGULATING SCREW STUD STOP SCREW	1



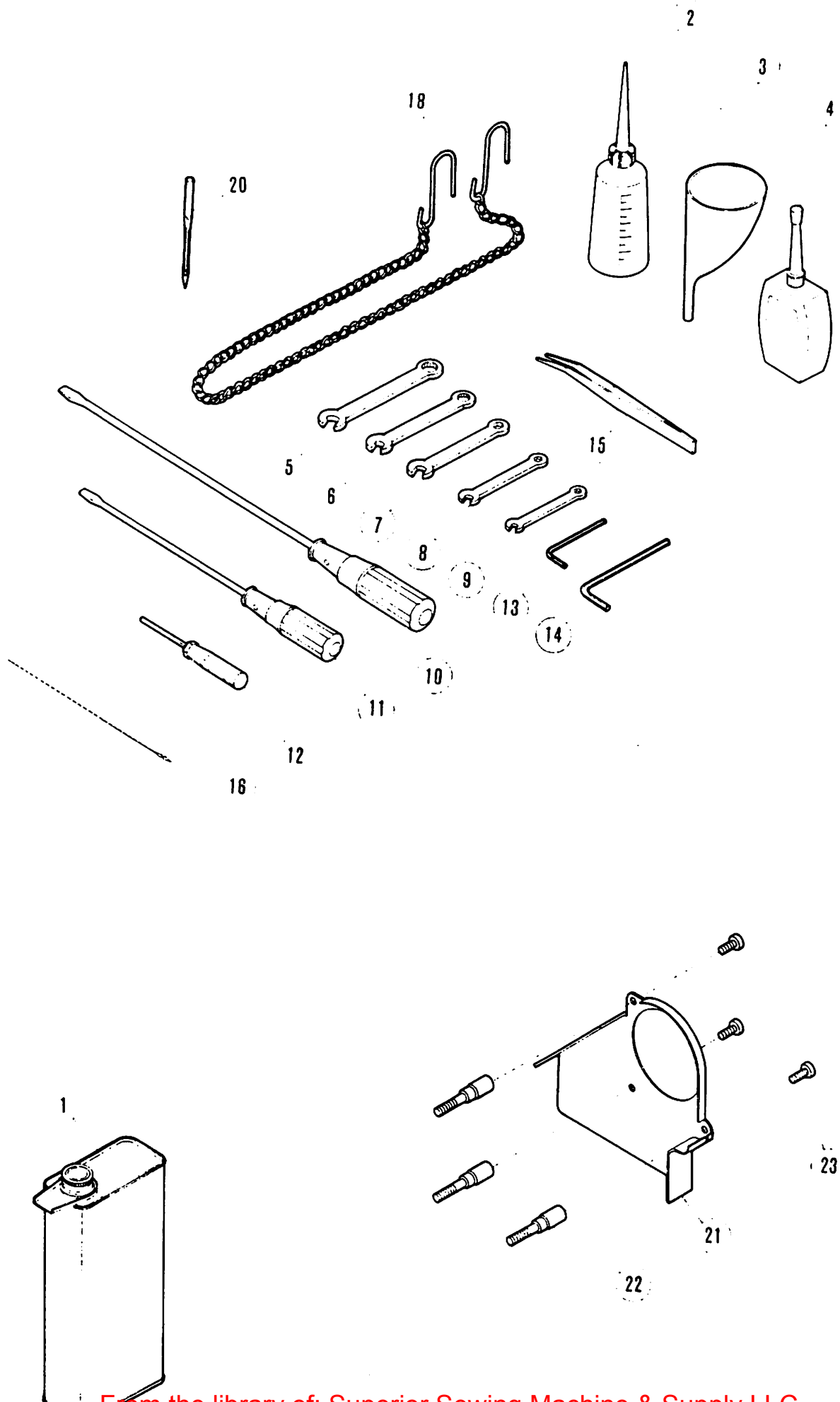
LUBRICATING MECHANISM

REF. NO.	PORTER NO.	DESCRIPTION	QTY.
1	613380	COOLER ASSEMBLY	1
2	613420	GASKET	2
3	610100	SCREW	8
4	613400	CLAMP	1
5	618260	SCREW	1
6	613440	DISTRIBUTOR	1
7	610860	OIL SPLASH SCREW	1
8	610820	WASHER	2
9	611365	SCREW	1
10	611980	PLUG	1
11	613460	OIL SPLASH PIPE COMPLETE	1
12	611520	OIL SPLASH SCREW	1
13	611540	WASHER	2
14	613340	WORM	1
15	611618	SCREW	1
16	613880	GEAR PUMP COMPLETE	1
17	613360	WORM WHEEL	1
18	618460	SCREW	2
19	613260	CASING COMPLETE	1
20	618900	SCREW	1
21	611300	PUMP GEAR (RIGHT)	1
22	201308	PUMP GEAR (LEFT)	1
23	613290	PUMP GEAR SHAFT	1
24	611020	KEY	1
25	613300	PUMP GEAR SHAFT	1
26	610440	SCREW	2
27	611280	PLATE	1
28	618740	SCREW	4
29	613320	'O' RING	1
30	611380	FILTER COMPLETE	1
31	611400	FRAME/FILTER	1
32	618660	SCREW	2
33	618740	SCREW	1
34	610840	OIL TUBE	1
35	610800	OIL SPLASH JOINT	1
36	610860	OIL SPLASH SCREW	1
37	611615	TUBE CLAMP	2
38	613480	NIPPLE	1
39	615500	OIL RESERVOIR	1
40	615980	GASKET	1
41	611465	OIL PAN SCREEN	1
42	618840	SCREW	1
43	611660	WASHER	1
44	618960	BOLT	6
45	614300	WASHER	6



THREAD STAND

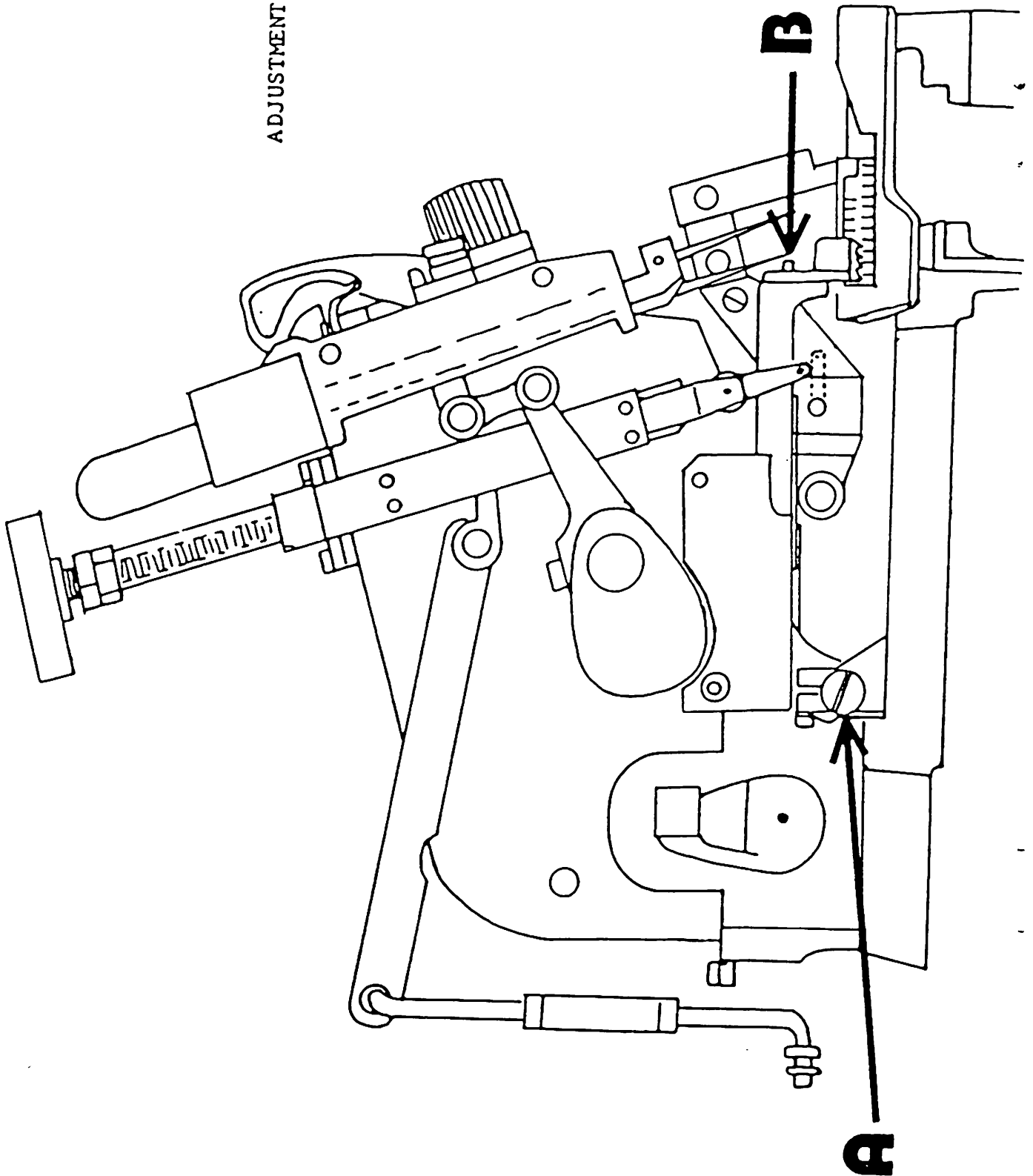
REF. NO.	PORTER NO.	DESCRIPTION	QTY.
--	618090	THREAD STAND COMPLETE -- 3 SPOOLS	1
1	617460	THREAD STAND UPPER ROD	1
2	617480	NUT	1
3	617500	THREAD STAND LOWER ROD	1
4	617520	SPOOL PIN BRACKET	1
5	617965	CLAMP PLATE	1
6	617560	SPOOL PIN BRACKET	--
7	617580	CLAMP SCREW	2
8	617620	CLAMP SCREW NUT	2
9	617640	SPOOL PIN	3
10	617660	WASHER	3
11	617680	NUT SPRING WASHER	3
12	617700	NUT	3
13	617720	SPOOL TRAY	3
14	617740	SPOOL RETAINING FIN	3
15	617760	THREAD GUIDE BAR ROD BRACKET	1
16	617780	CLAMP SCREW	1
17	617800	CLAMP SCREW NUT	1
18	618180	THREAD GUIDE BAR ROD	1
19	617780	SCREW	1
20	617800	SCREW NUT	1
21	617820	THREAD GUIDE ROD RETAINING BLOCK	1
22	617780	CLAMP SCREW	1
23	617800	CLAMP SCREW NUT	1
24	618240	THREAD GUIDE BAR	1
25	617780	CLAMP SCREW	1
26	617800	CLAMP SCREW NUT	1
27	617840	THREAD GUIDE WIRE (LONG)	2
28	617860	LOCK NUT	2
29	617880	THREAD GUIDE WIRE (SHORT)	1
30	617860	LOCK NUT	1
31	617970	THREAD GUIDE WIRE HOLDER	1
--	617975	THREAD GUIDE WIRE HOLDER	--
32	617900	SCREW	1
33	617920	THREAD STAND BASE	1
34	617940	WOOD SCREW	3
35	617960	THREAD STAND LOWER ROD SCREW	2



ACCESSORIES

REF. NO.	PORTER NO.	DESCRIPTION	QTY.
1	610365	OIL CONTAINER (750cc)	1
2	610385	OILER	1
3	610380	OIL FUNNEL	1
4	610580	SILICONE LUBRICANT CONTAINER (50cc)	1
5	618080	WRENCH (9.5mm)	1
6	618060	WRENCH (8mm)	1
7	618040	WRENCH (7mm)	1
8	618020	WRENCH (6mm)	1
9	618000	WRENCH (5mm)	1
10	610260	SCREWDRIVER (LARGE)	1
11	610280	SCREWDRIVER (MEDIUM)	1
12	610600	ALLEN WRENCH (1.56mm)	1
13	610640	ALLEN KEY (3.17mm)	1
14	610720	ALLEN KEY (4.76mm)	1
15	610300	TWEEZERS	1
16	610460	THREADING WIRE	1
18	610420	TREADLE CHAIN	1
20	PSM130	NEEDLE	1
21	614705	BELT GUARD	1
22	614740	FIXING SCREW	3
23	618740	SCREW	3
--	617980	ALLEN KEY (6.0mm) (NOT SHOWN)	1

ADJUSTMENT DIAGRAM

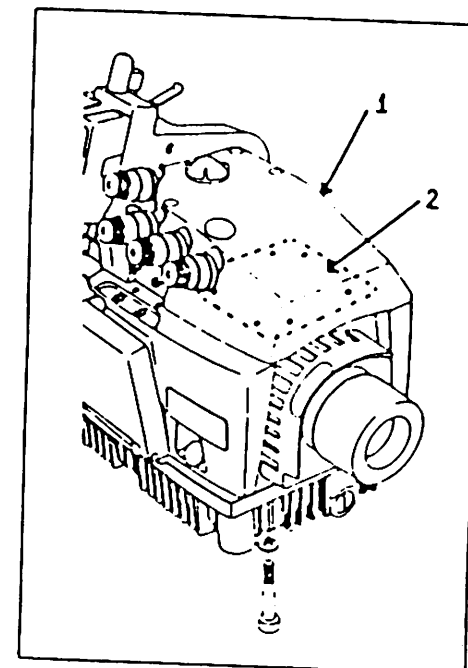


PTF 504A Adjustment Diagram

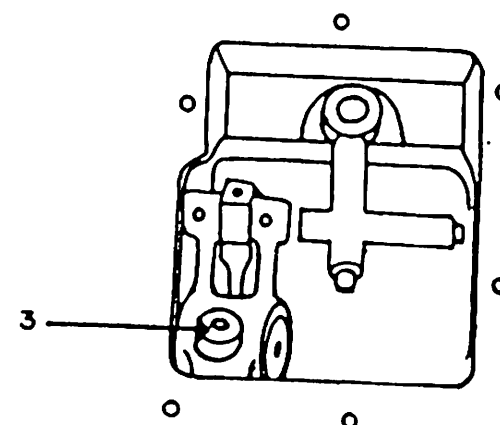
- A.....This eccentric pin adjusts the position of the top feed front to rear. This enables you to align the top feed teeth with the lower feed dog teeth.
- B.....This screw adjusts the height of the top feed. If the height of the top feed can not be adjusted by changing "B", it will have to be adjusted internally, by changing the upper knife shaft as described below and shown in the sub-diagrams.

1. Remove the top cover (four screws)
2. Then, remove the right cover plate #208341 (six screws). This will expose the upper knife drive crank with a socket cap screw. (Sub-diagram A)

3. Use a 3/16" allen wrench to loosen this screw. Lowering the knife arm will raise the top feed. Raising the knife will lower the top feed. (Sub-diagram B)
4. After adjusting the above, the upper trim knife will have to be reset.



Sub-diagram A

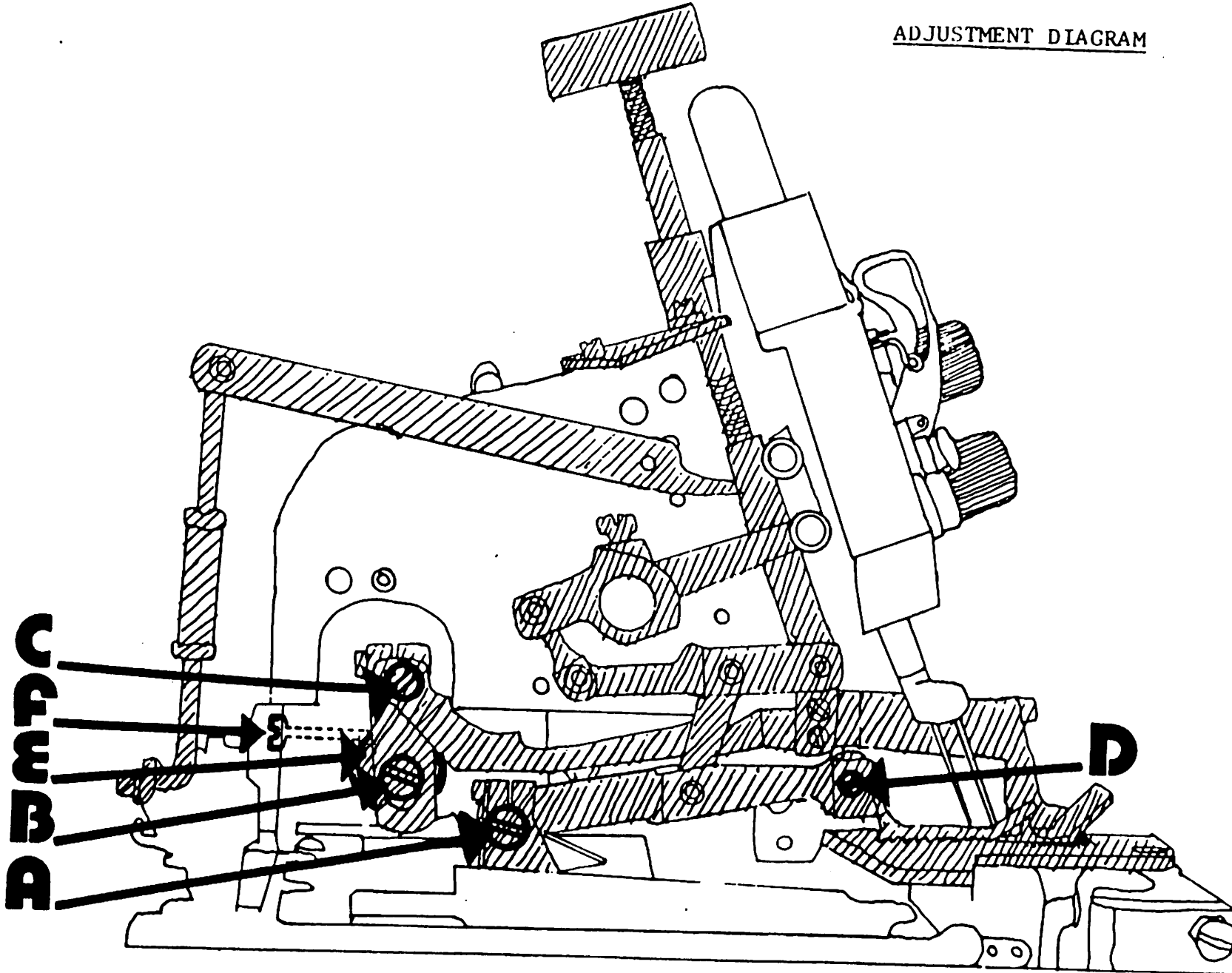


Sub-diagram B

PWF Walking Foot Mechanism

40

ADJUSTMENT DIAGRAM



MAIN ADJUSTMENTS

- A.....This eccentric pin adjusts the position of the Walking Foot front to rear. This enables you to align the Walking Foot teeth with the lower feed dog teeth.
- B.....This screw adjusts the Walking Foot movement in relation to the presser foot. The higher the bracket, the faster the presser foot will meet the needle plate, causing the Walking Foot to raise off of the work faster. Lowering the bracket will cause the Walking Foot to raise off of the work slower.
- C.....This eccentric pin primarily adjusts the position of the presser foot front to rear.
- D.....This screw adjusts the height of the lift of the Walking Foot.
- E.....This shaft adjusts the position of the presser foot front to rear. It is used to adjust the clearance between the presser foot and the Walking Foot.
- F.....This screw holds shaft 'E'. Loosen it to free the shaft.

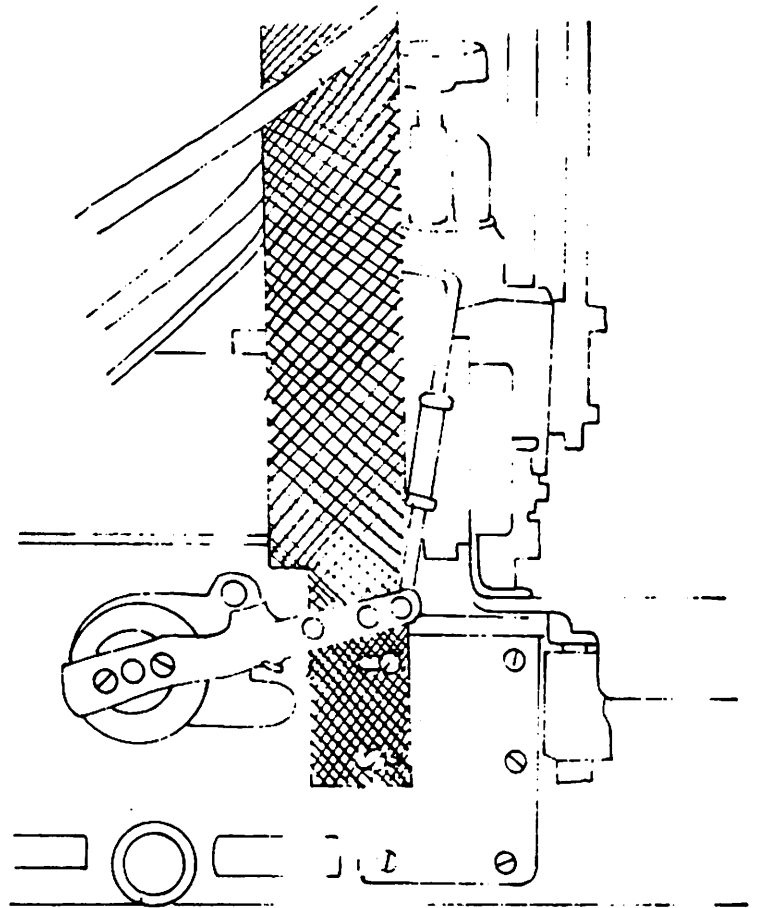
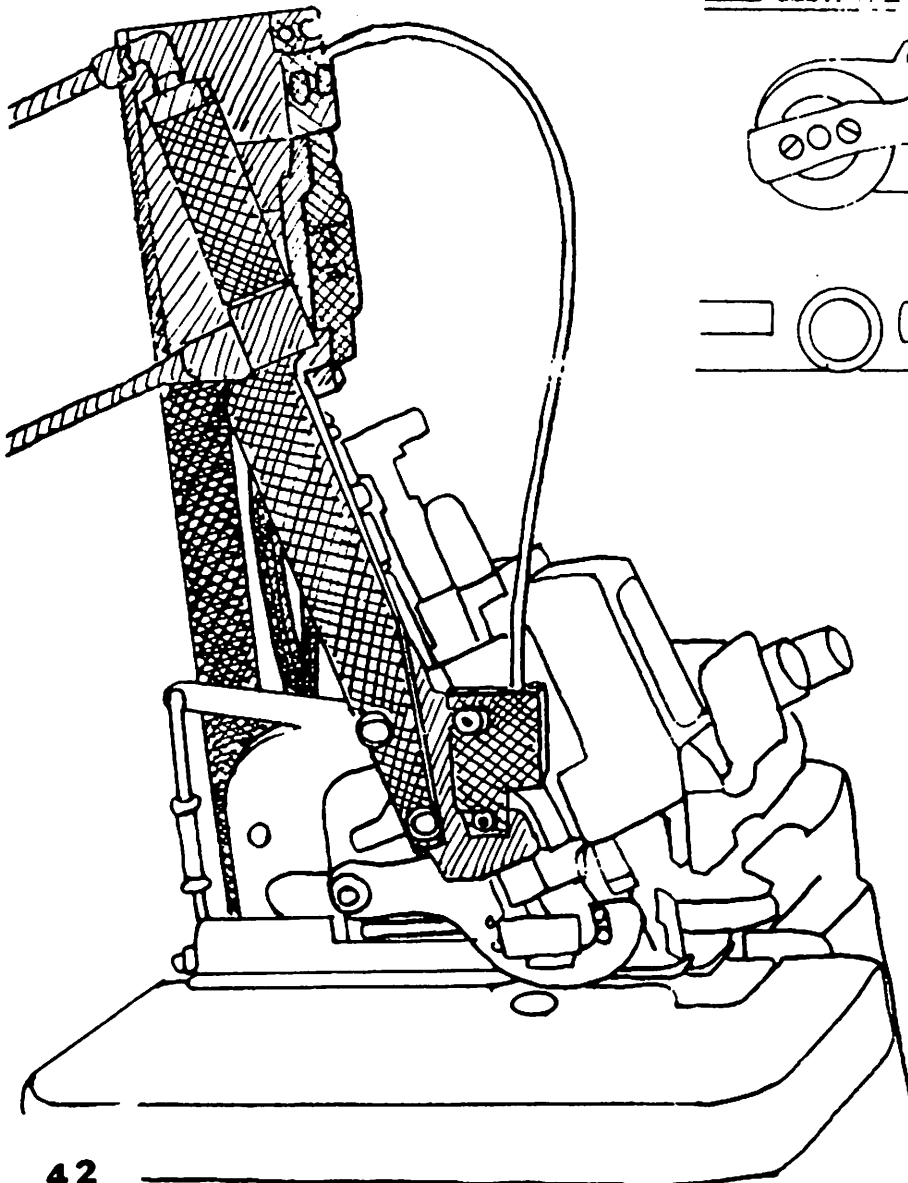
Any one of the above adjustments will slightly change one or all of the other adjustments. Take this into consideration when making any one adjustment. Before running the machine, turn it over by hand to check all clearances.



PORTER SEWING MACHINES, INC.
97 RANTOUL STREET, BEVERLY, MA 01915

PNEUMATIC BINDING CUTTER

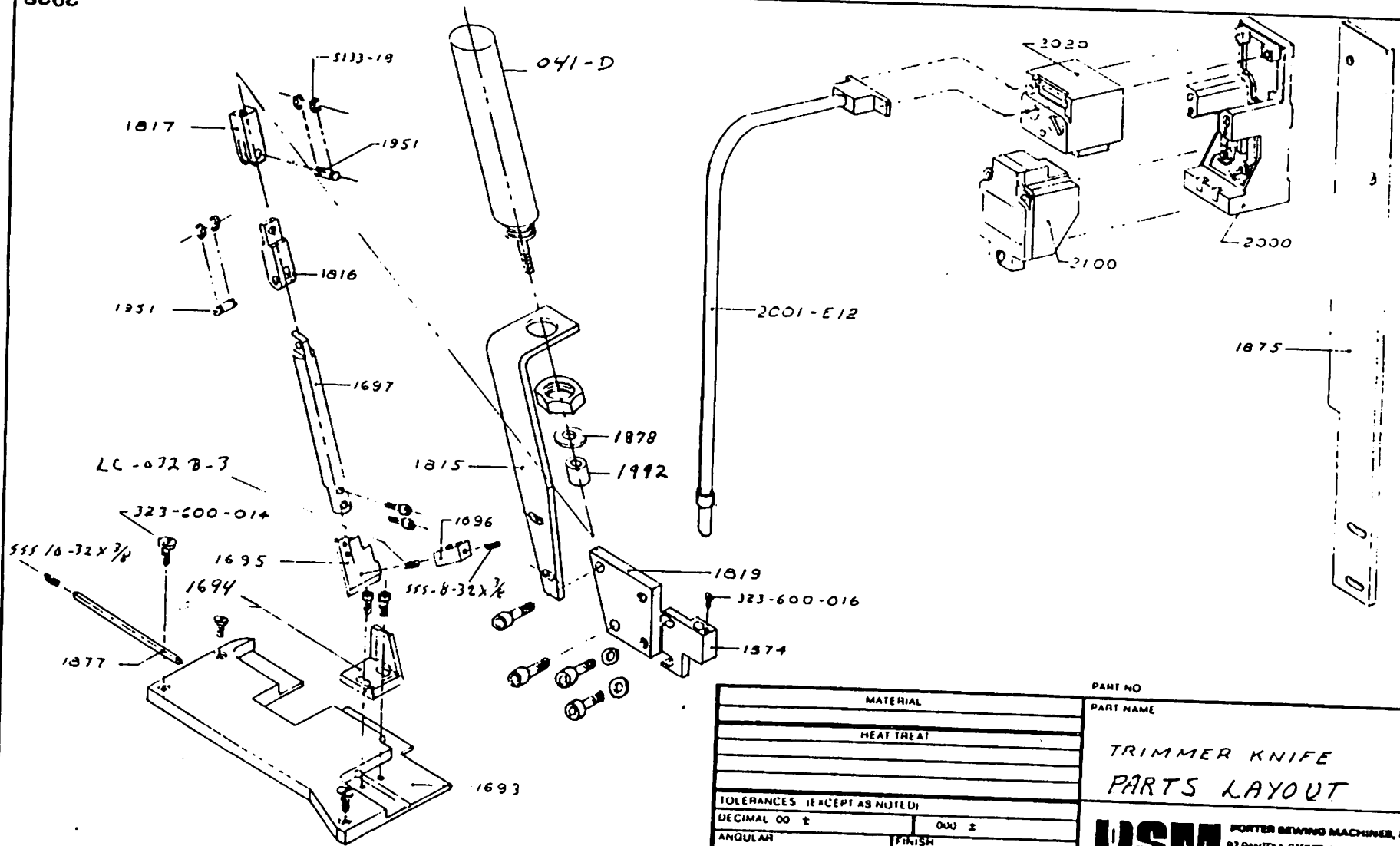
Installation Diagram



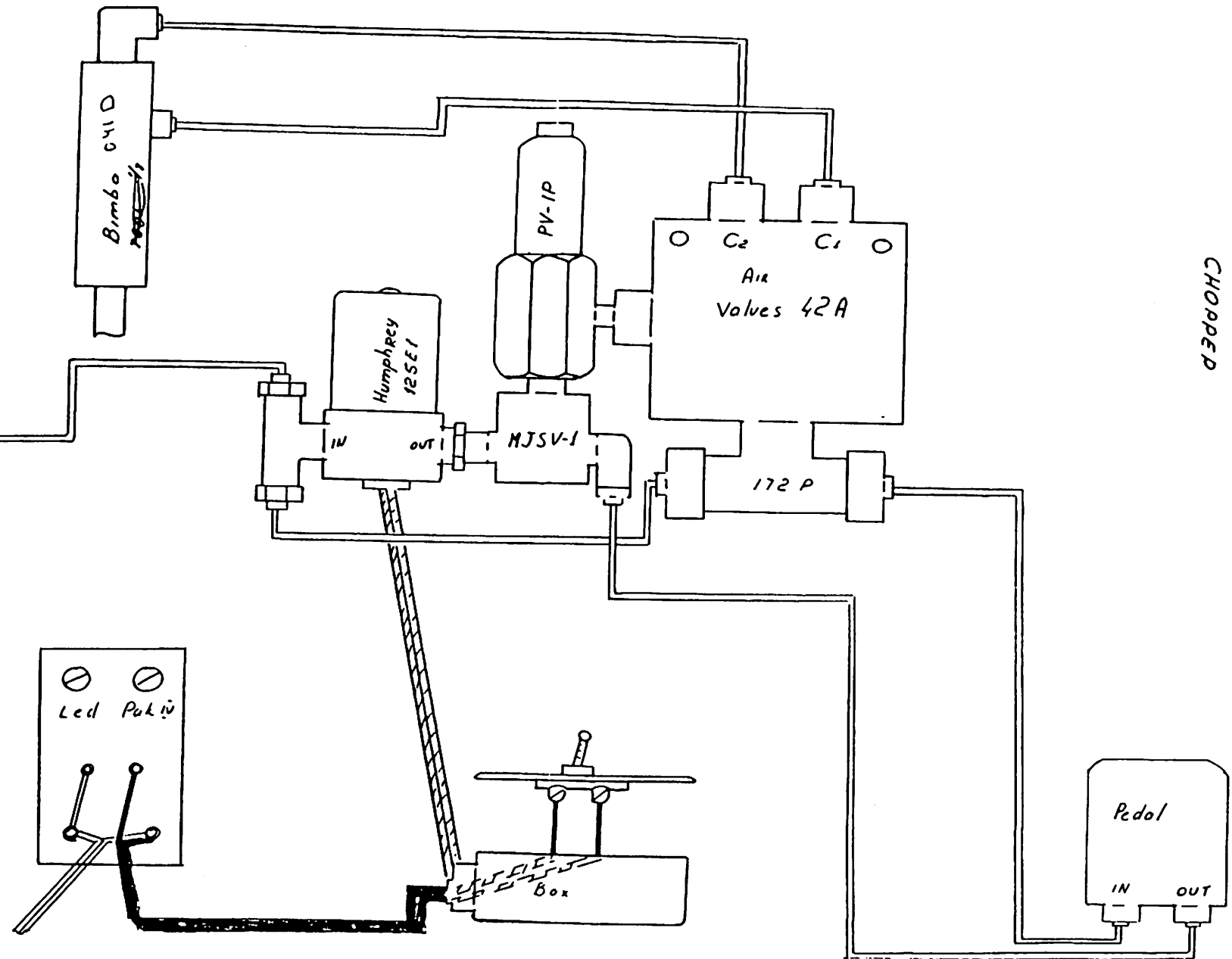
Rear View

Side View

8202



MATERIAL		PART NO	
HEAT TREAT		PART NAME	
		TRIMMER KNIFE	
		PARTS LAYOUT	
TOLERANCES (EXCEPT AS NOTED):			
DECIMAL .00 ±		ANGULAR ±	
FINISH		DATE	
DRAWN BY C. S. B		9-26-83	
SCALE		SHEET NO	
8		10	
DWG NO		8-WIL-TR-25 2028	



INITIAL ADJUSTMENT OF CHOPPER

1. Make sure air and electricity are disconnected before making any adjustments.
2. Back off blade adjusting screw found in back portion of new cover plate #1693 approximately 3/16".
3. Tighten both screws (#6-32) on lower knife holder #1694 to a point where blade can be moved with a slight drag. Push blade to the back of machine.
4. Slide top knife #1695 down to its lowest position.
5. Adjust lower knife holder forward, using blade adjusting screw, until lower and upper knives are a perfect match.
6. Tighten screws (#6-32) on lower knife holder #1694.
7. Adjust top blade pressure spring enough to hold top blade to bottom blade.
8. Place thread under chopper and manually push top chopper blade down. If blade makes a clean cut, chopper blades are set correctly.
9. If blade does not make a clean cut, add more pressure to blade pressure spring.

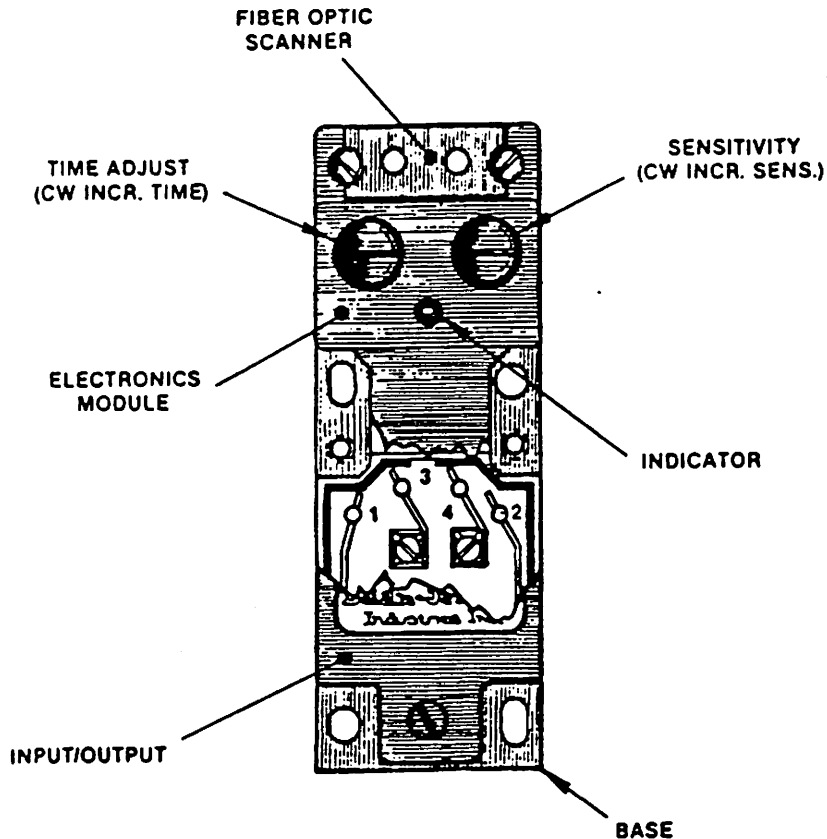
NOW REPEAT NO. 8

10. If addition of more spring pressure does not give a clean cut, check blades for sharpness. Check again for a good match of upper and lower knives.
11. Once blades are cutting, use the following procedure for adjusting LED-PAK IV:

BEFORE STARTING: MAKE SURE POWER IS ON

- A. Turn pneumatic flow control valve (located on pneumatic box) OFF.
- B. Scanner should be placed directly over reflector tape on cloth plate.

- C. Turn time adjust screw counter-clockwise as far as possible. (Adjusting screw will be found under large cover screw, left hand side).



- D. Turn sensitivity counter-clockwise as far as possible. Turn sensitivity clockwise slowly until indicator light turns red. At this point, turn sensitivity screw one quarter (1/4) turn clockwise. LED-PAK IV should be ready to run.
- E. Place a piece of cloth or paper between scanner and reflector tape when material is removed. This should cause chopper to come down and stay down.
- F. Turn air pressure on. Adjust flow control valve (located on pneumatic box) slowly until chopper returns to UP position. At this time, repeat: covering and uncovering scanner. Chopper should come down and return back up. By adjusting flow control correctly, a desirable speed down and up can be obtained.

- G. Automatic chain cutting should now be operating.
- H. For manual operation, turn electrical switch (located on side of pneumatic box) to OFF position.
- I. Pneumatic foot switch will now operate chopper.

PART NO.	PAGE NO.	REF. NO.	PART NO.	PAGE NO.	REF. NO.
10001	5	50	1719	5	12
1140	3	11	1720	5	14
1142	3	8	1722	5	33
1143	3	6	1724	5	20
1146	3	23	1725	5	21
1156	21	8	1728	5	6
1156	23	5	1729	5	9
1166	3	30	1730	5	3
1178	31	8	1734	7	8A
1179	3	38	1737	5	4
1184	3	4	1738	17	1A
1184	5	8	1738	5	11
1185	3	1	1739	5	15
1185	5	1	1795	11	1A
1186	3	2	1831	5	36
1186	5	2	1887	5	32
1187	3	12	1903	5	31
1196	25	14	1912	5	16
1201	3	18	1935	7	8
1201	5	28	1950	29	29
1206	15	19	201308	33	22
1206	15	22	2033	5	38
1206	3	26	2219	3	34
1209	3	19	2368	5	41
1209	5	29	5133-12	3	12A
1212	3	36	5133-15	3	35
1214	3	32	5560-18	3	27A
1220	31	1	610040	21	3
1231	25	5	610040	23	3
1233	3	13	610060	17	8
1234	3	14	610060	17	31
1247	3	27	610060	23	23
1250	11	1	610080	13	14
1256	3	10	610100	15	28
1271	3	21	610100	21	33
1271	5	17	610100	27	48
1370	3	25	610100	29	26
1374	29	7	610100	33	3
1435	9	20	610120	15	24
1440	3	5	610120	25	18
1442	3	3	610140	11	22
1459	9	21	610140	27	52
1706	5	13	610180	31	42
1708	5	26	610200	11	28
1709	5	19	610200	25	47
1712	5	23	610200	9	38
1718	5	27	610220	11	8
			610260	37	10
			610280	37	11
			610300	37	15
			610365	37	1
			610380	37	3
			610385	37	2
			610400	11	29
			610420	17	30
			610420	31	24
			610420	37	18
			610440	29	4

PART NO.	PAGE NO.	REF. NO.	PART NO.	PAGE NO.	REF. NO.
610440	33	26	611618	33	15
610460	37	16	611618	7	3
610480	17	36	611620	17	2
610580	37	4	611620	21	6
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PART NO.	PAGE NO.	REF. NO.	PART NO.	PAGE NO.	REF. NO.
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613180	27	10	614079	9	30
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613260	33	19	614120	25	37
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PART NO.	PAGE NO.	REF. NO.	PART NO.	PAGE NO.	REF. NO.
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PART NO.	PAGE NO.	REF. NO.	PART NO.	PAGE NO.	REF. NO.
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PART NO.	PAGE NO.	REF. NO.	PART NO.	PAGE NO.	REF. NO.
618760	25	49	619710	27	13
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618920	11	26	BHS10-32X.375	5	39
618940	11	36	DP 3/16X.750	5	40
618940	21	25	DP 3/16X.874	3	31
618960	33	44	FHS	3	24
618980	11	15	FHS 9/64X36	3	15
619000	7	10	FHS 9/64x36	3	37
619020	31	5	HB10-32X.500	5	37
619040	7	17	HLSS4-40X.078	5	16A
619060	11	50	HN8-32	3	33
619080	27	40	PHMS1/4-28X.750	5	22
619080	27	43	PSM 130	17	19
619100	15	2	PSM130	37	20
619140	27	27	SCS 6x32x7/8	3	28
619140	27	16	SHCS4-40X.375	3	22
619180	31	43	SHCS4-40X.375	5	25
619180	9	40	SHCS5-40X.250	5	32A
619200	29	2	SHCS5-40X.250	5	34
619220	15	4	SHCS6-32X.500	5	18
619240	7	9	SHCS8-32X.125	5	5
619260	13	23	SHCS8-32X.250	3	7
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619300	13	15	SHCS8-32X.500	5	7
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