



series **S2**

SERVICE MANUAL

ALL S2 MACHINES – EFFECTIVE AS OF #54290
ALL S2 OFFSET HEAD MODELS – EFFECTIVE AS OF #53203

Form 20-51
10M – 4/1979
Printed in U.S.A.

NEEDLES

1

Needles for the Reece Series S2 Machines are packaged and sold in boxes of 100, in the sizes and types listed. They are of superior struck groove construction, chrome plated and are spotted at the eye except in sizes 00 and finer. When ordering, specify quantity – (100, 200, etc.) and give the Needle E.D.P. Number.

TYPE	APPLICATION	E.D.P. NUMBER	CODE NUMBER	NEEDLE BLADE SIZE
ROUND POINT LONG SHANK	Applicable to the majority of woven fabrics, knits and materials of similar consistency. These needles have a long shank that gives added stiffness to the blade permitting the use of one size smaller needle than would be normally required. Cannot be used on heavy materials that would be penetrated by the tapered portion of the needle's shank.	02-0750-1-400	750-LS-0000	Extremely Fine
		02-0750-1-000	750-LS-000	Extra Fine
		02-0750-1-000	750-LS-00	Very Fine
ROUND POINT	Applicable to the majority of woven fabrics, knits and materials of similar consistency.	02-0750-0-110	750-0	Fine
		02-0750-0-111	750-1	Medium
		02-0750-0-112	750-2	Heavy
BALL POINT LONG SHANK	Applicable to tightly woven or knitted fabrics, particularly silks and synthetics when the fibers of the materials are subject to damage or fracture by conventional Round Point needles. The Long Shank of this needle gives it the advantages stated for Round Point Shank needles.	02-0751-1-400	751-LS-0000	Extremely Fine
		02-0751-1-000	751-LS-000	Extra Fine
		02-0751-1-000	751-LS-00	Very Fine
BALL POINT	Same application as the Long Shank Ball Point needle above.	02-0751-0-110	751-0	Fine
		02-0751-0-111	751-1	Medium
SPEAR POINT	Applicable to fabrics containing a high percentage of starch or similar substances that tend to cause needle heating or resistance to proper pulling up of the stitches.	02-0752-0-110	752-0	Fine
		02-0752-0-111	752-1	Medium
		02-0742-0-112	752-2	Heavy
SPEAR POINT DOUBLE GROOVE	The Double Groove needle should be used only when the conditions justify it because it casts a smaller loop than standard needles and may introduce skipping. For this reason looper points should be set close to the needle blade. This needle is used on materials that have a tendency to trap the thread in its descent into the work which affects the thread take-up, or causes the thread to break at the needle's eye.	02-0752-0-211	752-1-DG	Medium
		02-0752-0-212	752-2-DG	Heavy
CROSS POINT LONG SHANK	Applicable to fine leather and similar materials as well as some types of plastics where conventional needles tend to leave excessive punctures. This needle permits a higher stitch density than Round Point needle. There may be a tendency in some cases, for the materials to cling to this needle, therefore, it should be used only after comparative test with other needles. The Long Shank of this needle gives it the advantages stated for Round Point Long Shank needles.	02-0753-1-100	753-LS-00	Very Fine
CROSS POINT	The same applications as the Cross Point Long Shank needle above.	02-0753-0-110	753-0	Fine
		02-0753-0-111	753-1	Medium
		02-0753-0-112	753-2	Heavy
ROCKED POINT	Applicable to leather and similar materials where conventional sharp pointed needles tend to leave excessive punctures. The slit made by the Rocked Point needle will tend to close up after penetration. This needle permits a higher stitch density than is possible in leather with a round point needle.	02-0754-0-110	754-0	Fine
		02-0754-0-111	754-1	Medium

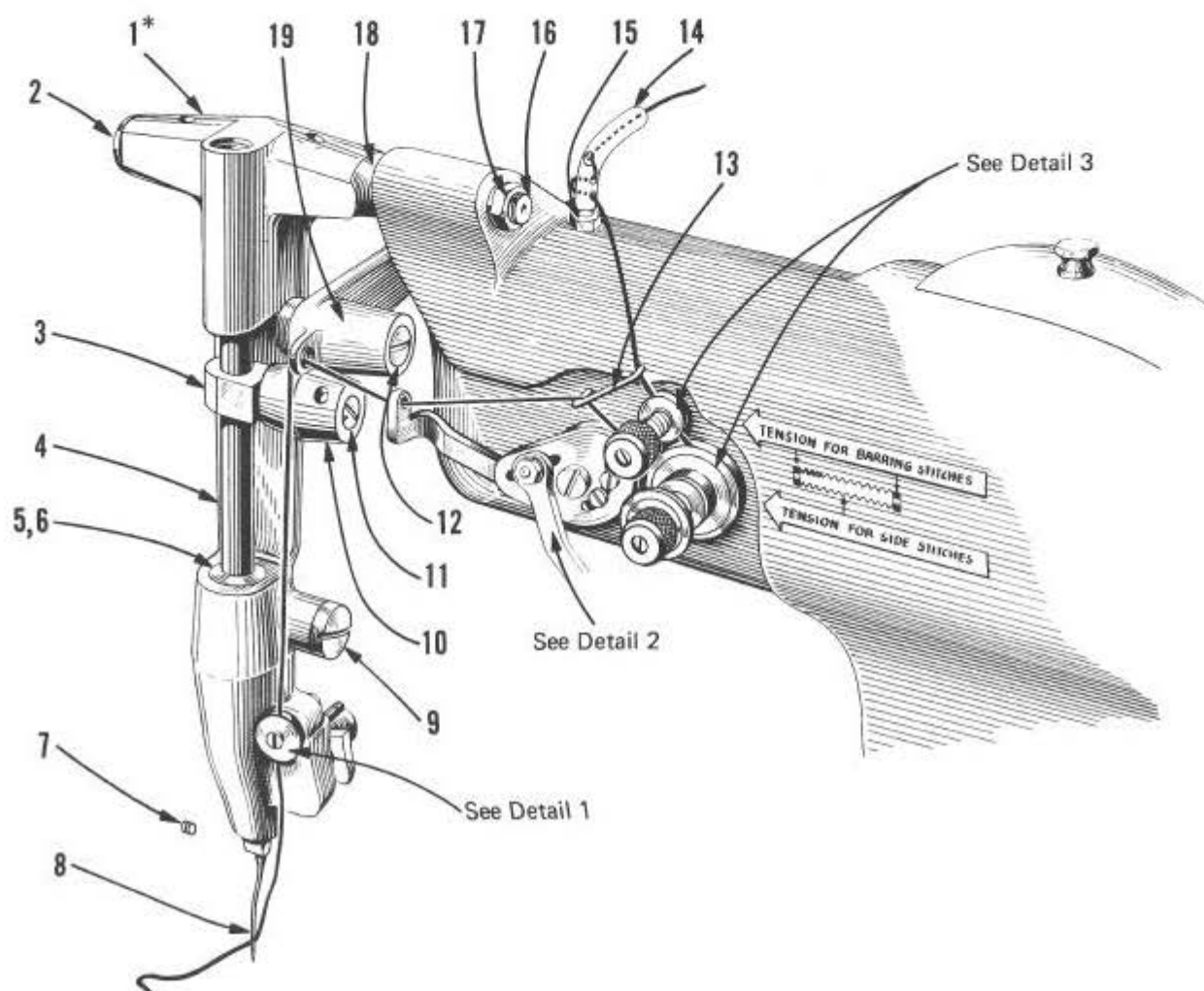
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3-1

2

NEEDLE BAR & THREAD TENSION



DET.	PART NUMBER	DESCRIPTION
1	20-0005-0-811*	Needle Bar Rocker
2	01-2146	Screw
3	20-0008	Clamp
4	20-0001-1	Needle Bar (tb. S2-32)
5	20-0587	Cover
6	20-0588	Wick
7	01-2193	Needle Screw
8		See needle chart on page 1
9	01-1074	Eccentric Screw
10	20-0022-1	Driver Lever
11	01-2145	Screw
12	01-1036	Shoulder Screw

13	01-6090	Thread Guide
14	05-0043	Thread Smoother
15	01-3001	Nut
16	20-0014	Bearing Stud
17	01-3037	Nut
18	01-4017	Shim
19	20-0007	Link

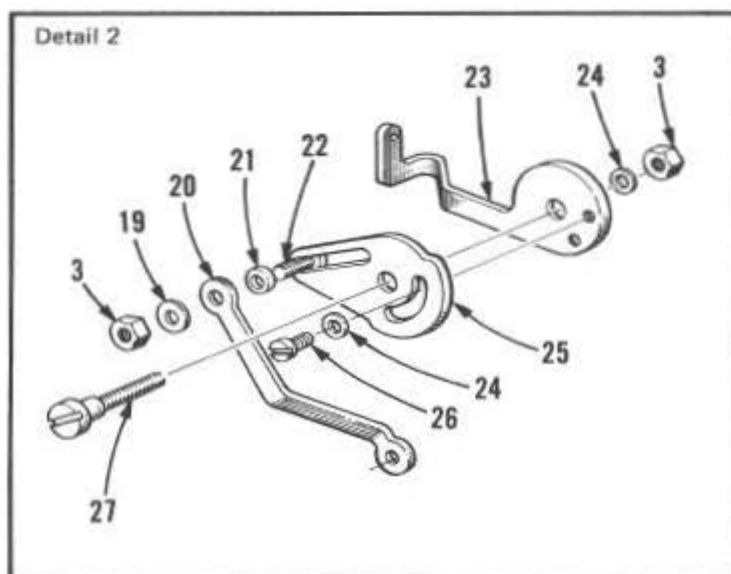
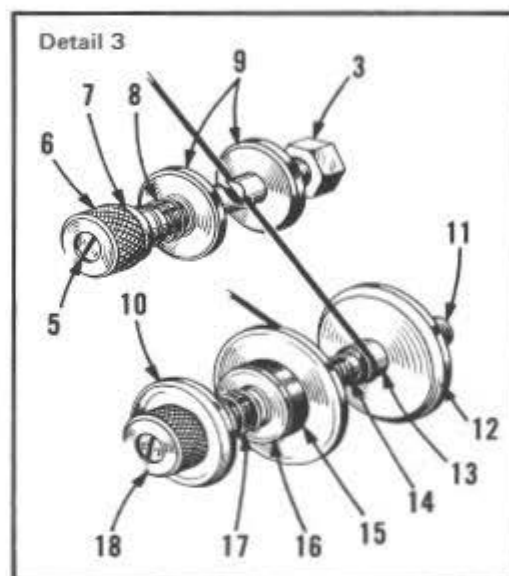
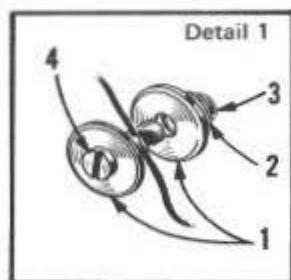
* Assembly, refer to parts index for assembly components.

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THREAD TENSIONS & CONTROLS

3

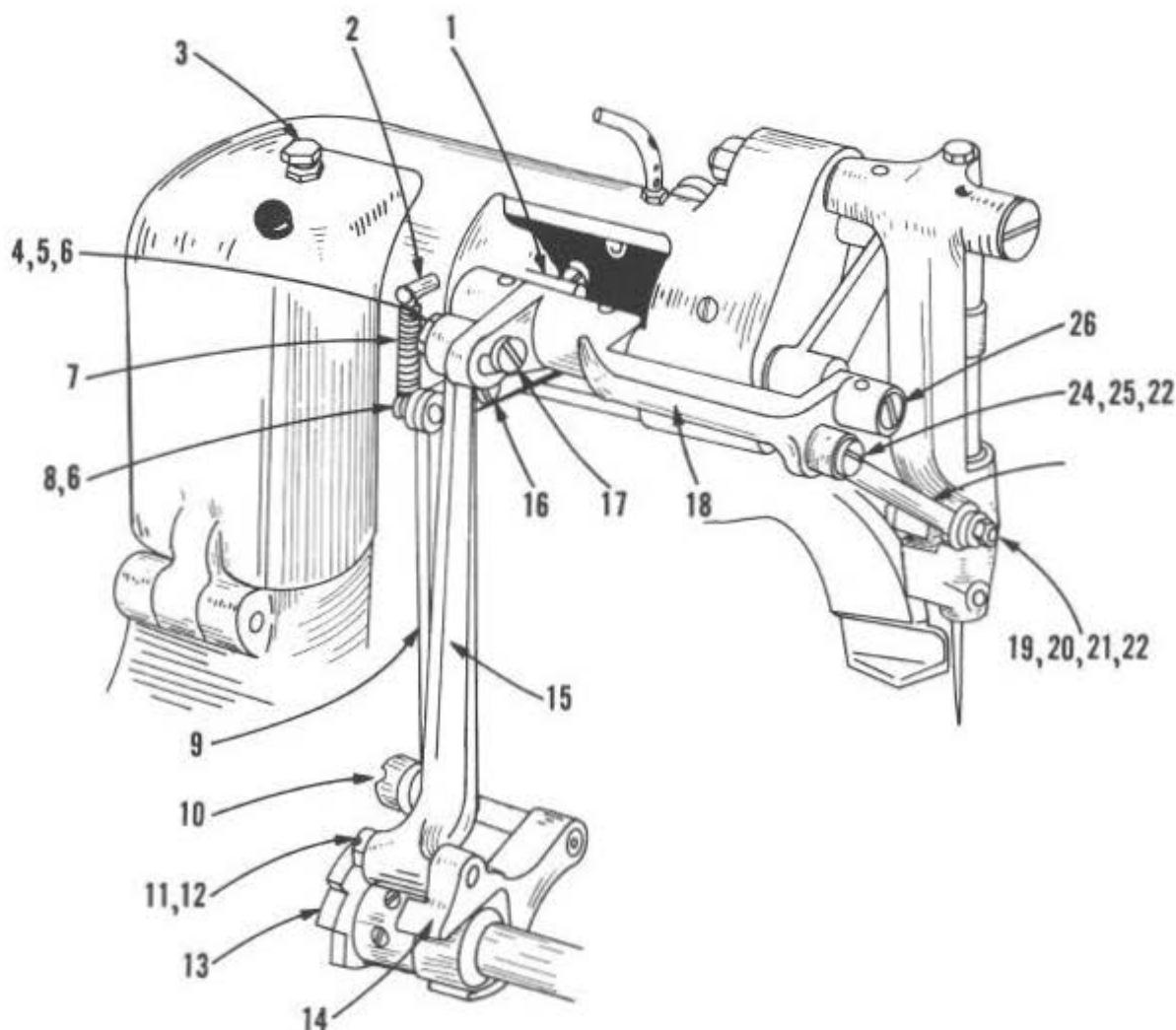


DET.	PART NUMBER	DESCRIPTION
1	01-4039	Tension Discs
2	01-5004	Spring
3	01-3426	Round Nut
4	20-0595-1	Screw
5	01-1099-1	Stud
6	01-3055	Knurled Adjustable Nut
7	20-0603	Check Collar
8	01-5151	Spring
9	01-4064	Tension Disc
10	20-0684	Check Collar
11	01-6300	Release Pin
12	20-0054	Tension Discs
13	20-0602	Bushing

14	01-1430	Stud
15	01-4062	Rubber Washer
16	10-4221	Release Washer
17	01-5098	Spring
18	01-3422	Knurled Adjustable Nut
19	01-4029	Washer
20	20-0608-0-015	Link
21	01-7017	Bushing
22	01-1065-1	Stud
23	20-0062-2	Take-up Lever
24	01-4406	Washer
25	20-0607-2	Adjustable Plate
26	01-2131	Screw
27	01-1505	Shoulder Screw

4

NEEDLE BAR – VIBRATING

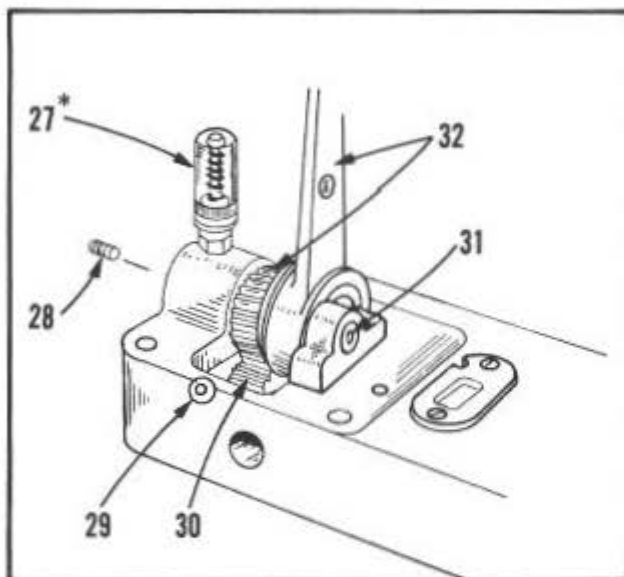
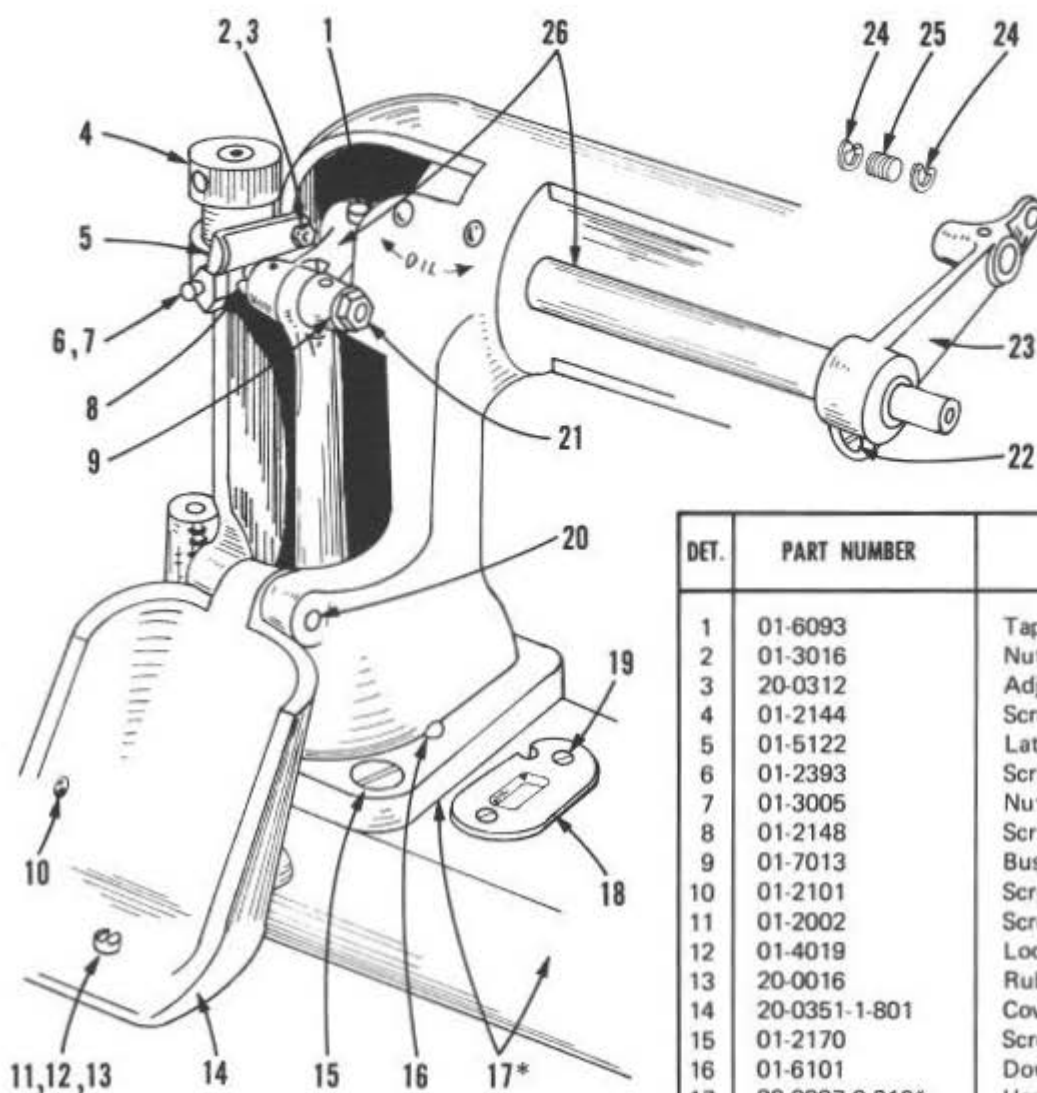


DET.	PART NUMBER	DESCRIPTION
1	20-0006	Release Lever
2	01-6833	Anchor (part of Head Assembly)
3	01-3040	Knob
4	01-7013	Bushing-Inside
5	01-3012	Nut
6	01-4011	Washer (2 used)
7	01-5134	Spring
8	01-6186	Pin
9	20-0011	Release Rod
10	01-1038	Shoulder Screw
11	01-2149	Screw
12	01-7012	Bushing

13	20-0047-2	Bite Cam
14	20-0043-1	Bite Cam Follower
15	20-0038	Link
16	01-1103	Shoulder Screw
17	20-0041	Stud
18	20-0024-2	Rocker
19	01-1074	Eccentric Screw
20	01-7018	Flanged Bushing
21	01-3001	Nut
22	01-4013	Washer
23	20-0611	Link
24	01-1006	Shoulder Screw
25	01-7022	Bushing
26	20-0021-0-100	Shaft

NEEDLE BAR DRIVE

5



DET.	PART NUMBER	DESCRIPTION
1	01-6093	Taper Pin
2	01-3016	Nut
3	20-0312	Adjustable Nut
4	01-2144	Screw
5	01-5122	Latch Spring
6	01-2393	Screw
7	01-3005	Nut
8	01-2148	Screw
9	01-7013	Bushing (2 used)
10	01-2101	Screw
11	01-2002	Screw
12	01-4019	Lock Washer
13	20-0016	Rubber Bumper
14	20-0351-1-801	Cover
15	01-2170	Screw
16	01-6101	Dowel Pin
17	20-0397-0-010*	Head & Bedplate Asm. (see note)
18	20-0584	Cover Plate
19	01-2131	Screw
20	01-6115	Pivot Pin
21	01-3012	Nut
22	01-2127	Screw
23	20-0022-1-100	Drive Lever
24	20-0604	Clip
25	20-0605	Thread Guide Bushing
26	20-0021-1-100	Shaft
27	20-0029-2-100*	Oil Well Assembly
28	01-2194	Screw
29	20-0609	Oil Well
30	20-0079-0-850	Large Gear & Screws (4 screws used)
31	20-0020-2	Bearing Studs
32	20-0019-0-100	Small Gear & Strap

Note: Head and Bedplate are furnished only as a factory assembled unit. Furnish machine serial number.

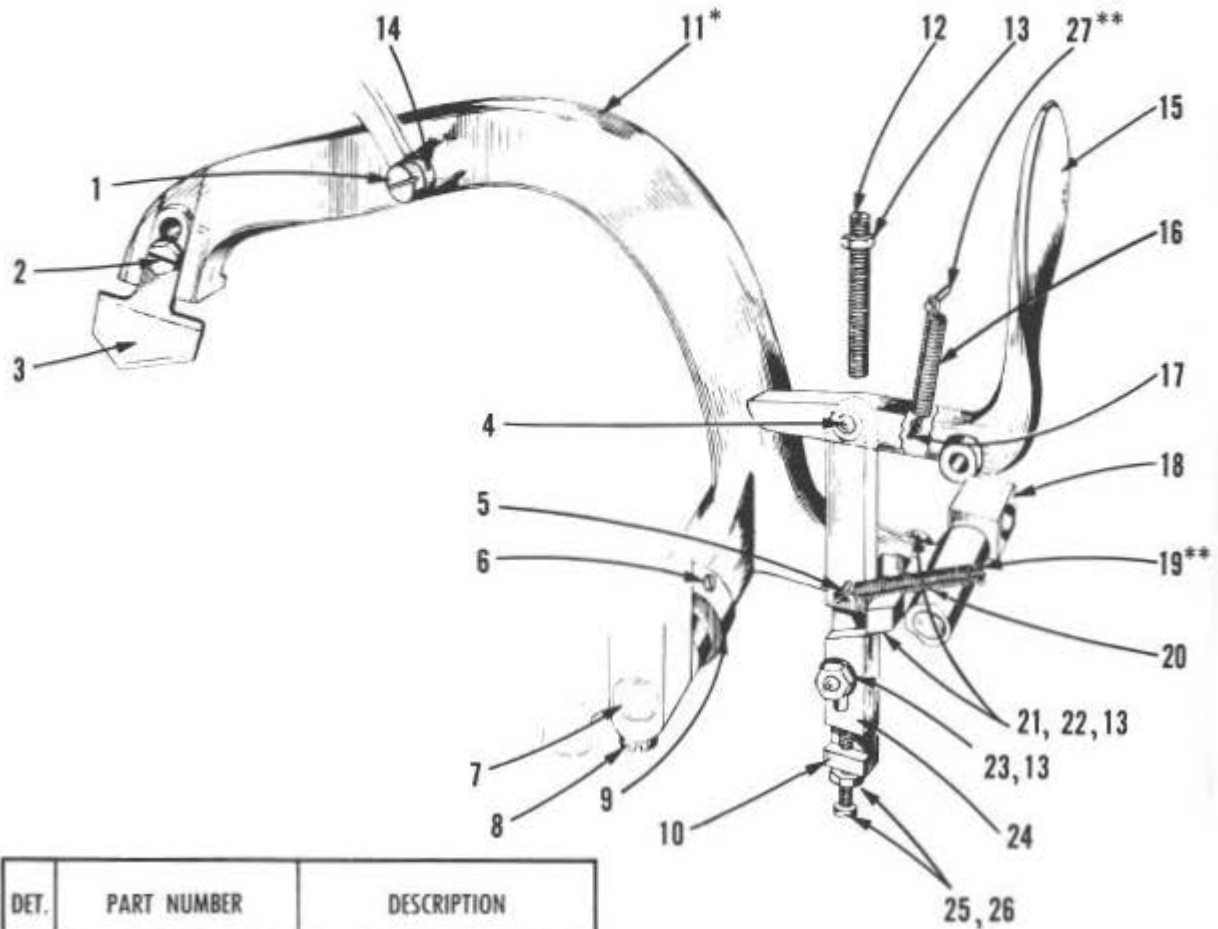
* Assembly, refer to parts index for assembly components.

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6

CUTTING & CLAMP RAISING



DET.	PART NUMBER	DESCRIPTION
1	01-2027-0-001	Shoulder Screw
2	01-2313	Screw
3	20-0356-1-049	Knife 1/4"
	20-0356-1-050	" 3/8"
	20-0356-1-051	" 7/16"
	20-0356-1-052	" 1/2"
	20-0356-1-053	" 9/16"
	20-0356-1-054	" 5/8"
	20-0356-1-055	" 3/4"
	20-0356-1-056	" 7/8"
	20-0356-1-057	" 1"
	20-0356-1-058	" 1 1/8"
	20-0356-1-059	" 1 1/4"
	20-0356-1-060	" 1 3/8"
4	01-1124	Shoulder Screw
5	01-6344	Anchor
6	01-2028	Set Screw
7	20-0358	Pivot Stud
8	01-2041	Set Screw
9	20-0571	Collar
10	20-0328	Link
11	20-0357-0-008*	Cutting Lever Asm.

12	01-2341	Screw
13	01-3005	Nut
14	01-7480-0-001	Bushing
15	20-0332-2	Unclamping Handle
16	01-5157	Spring
17	01-6015**	Anchor
18	20-0321	Pivot Block
19	01-6839-2	Anchor
20	01-5143	Spring
21	20-0360-1	Stop Post
22	01-4003	Washer
23	01-4011	Washer
24	20-0583	Adjustable Catch
25	01-2045	Adjustable Screw
26	01-3016	Nut
27	01-6833-0-001**	Anchor

* Assembly, refer to parts index for assembly components.

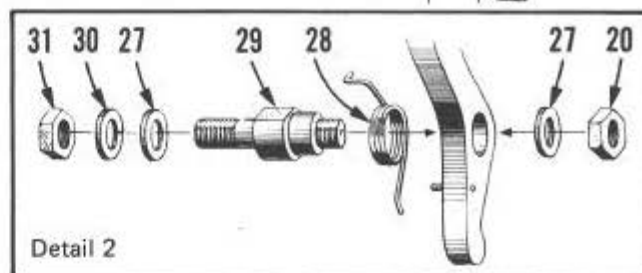
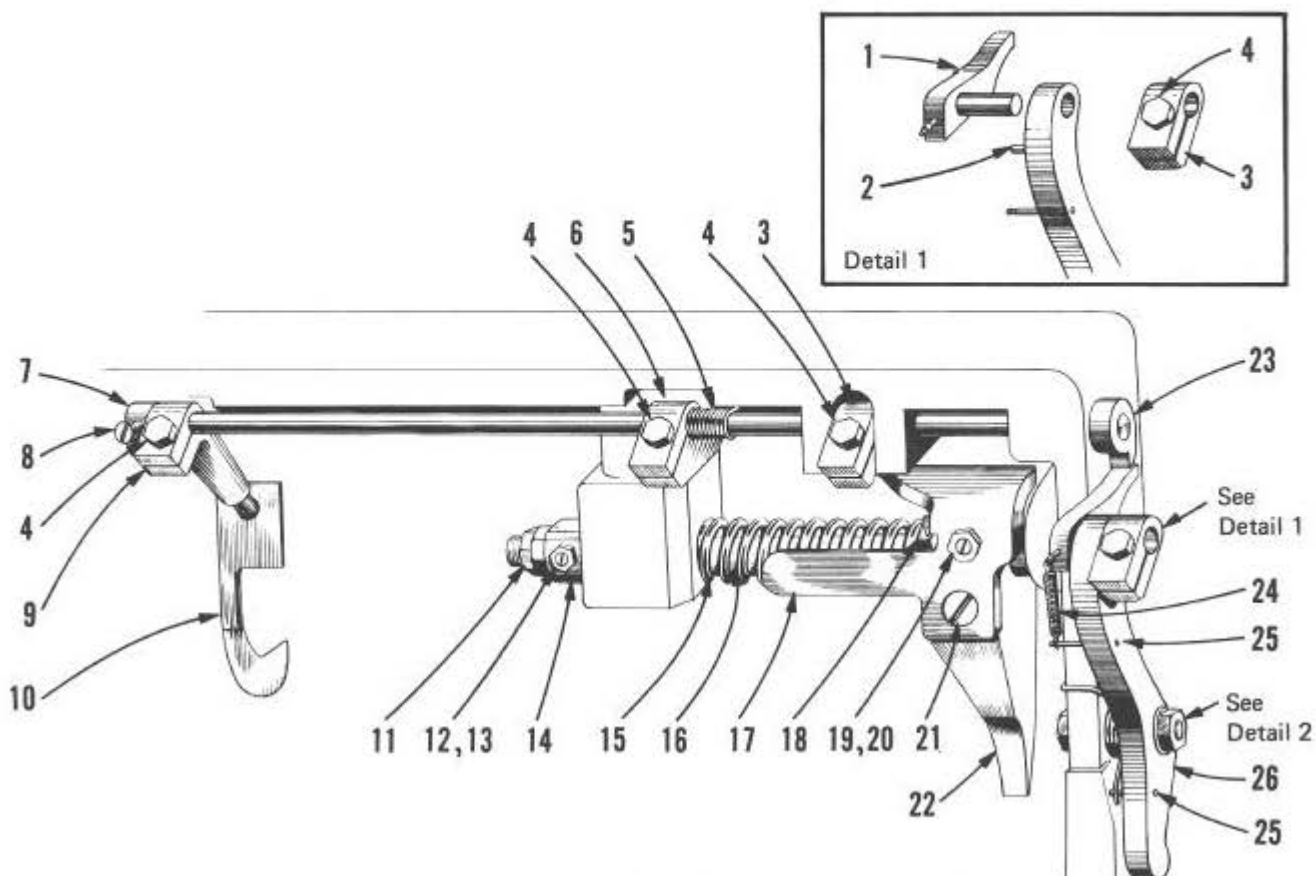
** Part of Head Bedplate Assembly

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THREAD TRIMMING

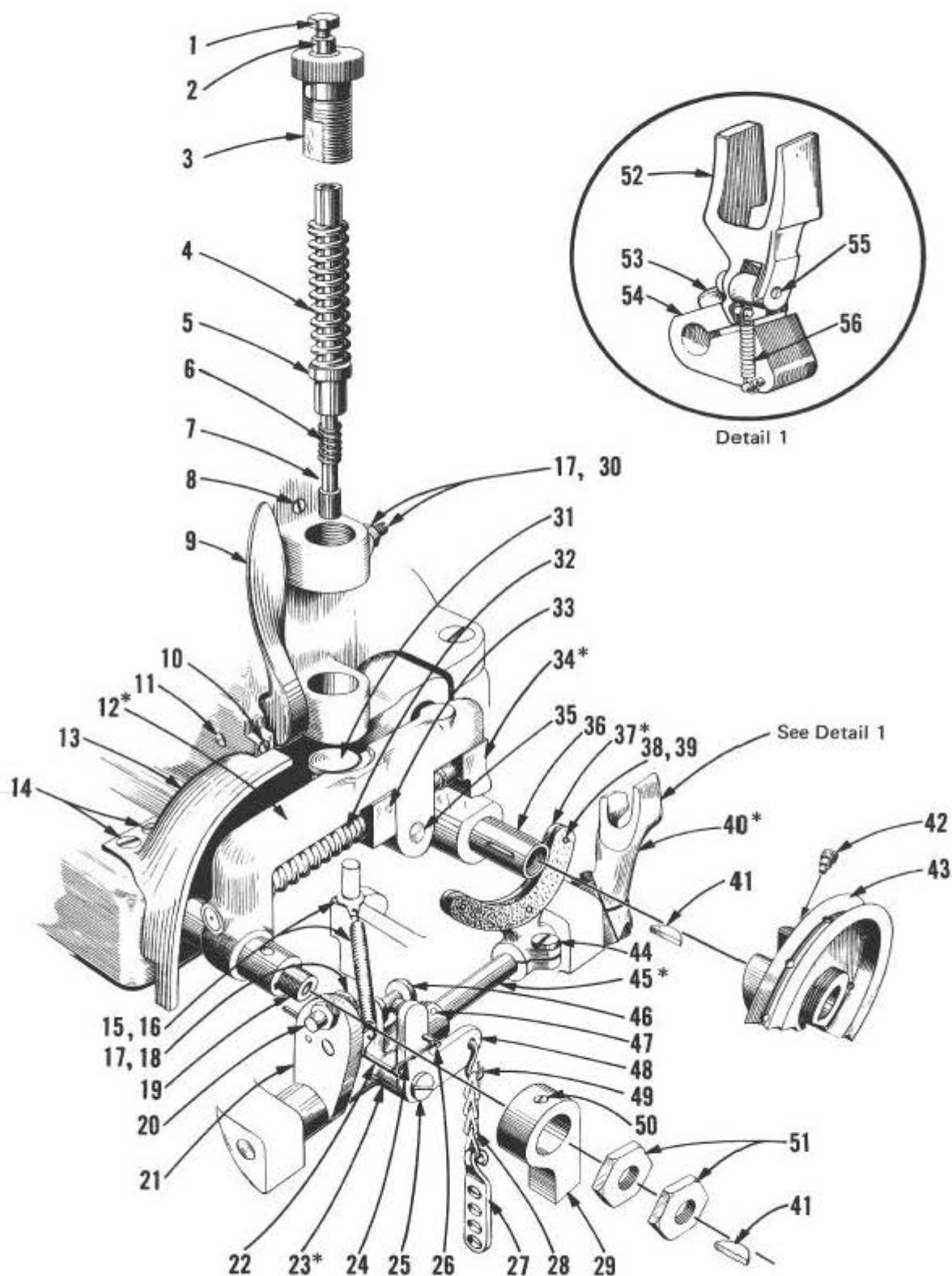
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DET.	PART NUMBER	DESCRIPTION
1	20-0641-2	Pawl
2	01-6362-1	Pin
3	20-0646-1	Safety Arm
4	01-2386	Clamp Screw
5	01-5162	Spring
6	20-0643-1	Stop Arm
7	01-7039	Collar
8	01-2019	Set Screw
9	20-0092-0-004	Trimmer Actuator
10	20-0093-1-004	Trimmer Hook
11	01-3030	Lock Nut
12	01-2304	Set Screw
13	01-3021	Lock Nut
14	20-0613	Adjustable Collar
15	01-5113	Spring
16	20-0320-1	Shaft
17	20-0645	Bracket
18	01-3008	Nut
19	01-2366	Screw
20	01-3011	Nut
21	01-2367	Screw

22	20-0323-1	Arm
23	20-0086-1	Ratchet and Rod
24	01-5033	Spring
25	01-6831	Anchor
26	20-0639-1	Lever (includes details 2 & 25)
27	01-4063	Washer
28	01-5161	Spring
29	20-0638	Stud
30	01-4004	Lock Washer
31	01-3042	Nut

STOP MOTION



STOP MOTION

9

DET.	PART NUMBER	DESCRIPTION
1	01-2543	Adjustable Screw
2	01-3423	Lock Nut
3	20-0312	Adjusting Nut
4	01-5111	Spring
5	20-0313	Guide Rod
6	01-5022	Spring
7	20-0316	Plunger
8	01-2144	Screw
9	20-0332-2	Unclamping Handle
10	01-2139	Screw
11	01-6590	Pivot Pin
12	20-0317-0-100*	Stop Bolt Holder (includes details 31 & 36)
13	20-0586-1	Cover
	20-0586-0-075	Cover - Parallel Garment Feeders
14	01-2344	Screw
15	10-1116	Anchor
16	01-5052	Spring
17	01-3005	Nut
18	01-4003	Lock Washer
19	20-0320-1	Shaft
20	20-0053-2	Shifter Stud
21	20-0040-2	Shifter Lever
22	20-0703	Spring Anchor
23	20-0044*	Plunger Holder
24	01-5152	Spring
25	01-1057	Shoulder Screw
26	01-6311	Anchor
27	04-0760	Adjustable Link
28	04-0747-2	Chain
29	20-0039-1	Actuator
30	01-2393	Screw
31	20-0318	Plunger Anvil
32	01-5112	Spring
33	01-6196	Taper Pin
34	20-0309-1-100*	Stop Bolt Asm. (includes detail 33)
35	01-6195	Stud
36	20-0070-3	Drive Shaft
37	20-0048-0-100*	Brake Shoe
38	20-0049	Leather
39	01-6313	Rivet
40	20-0343-4-100*	Belt Shifter (see insert)
41	01-8002	Key
42	01-2385	Set Screw
43	20-0074-3	Driving Pulley
44	01-2017	Screw

45	20-0042-0-100*	Shifter Shaft (includes details 23 & 48)
46	20-0045	Plunger
47	01-6312	Taper Pin
48	20-0046	Bell Crank (includes detail 26)
49	20-0715	Chain Hook
50	01-2394	Set Screw
51	01-3063	Lock Nut
52	20-0343-4	Belt Shifter
53	01-2338	Screw
54	20-0716	Clamp and Pin
55	01-6587	Pivot Pin
56	01-5469	Spring

* Assembly, Refer to Parts Index for Assembly Components.

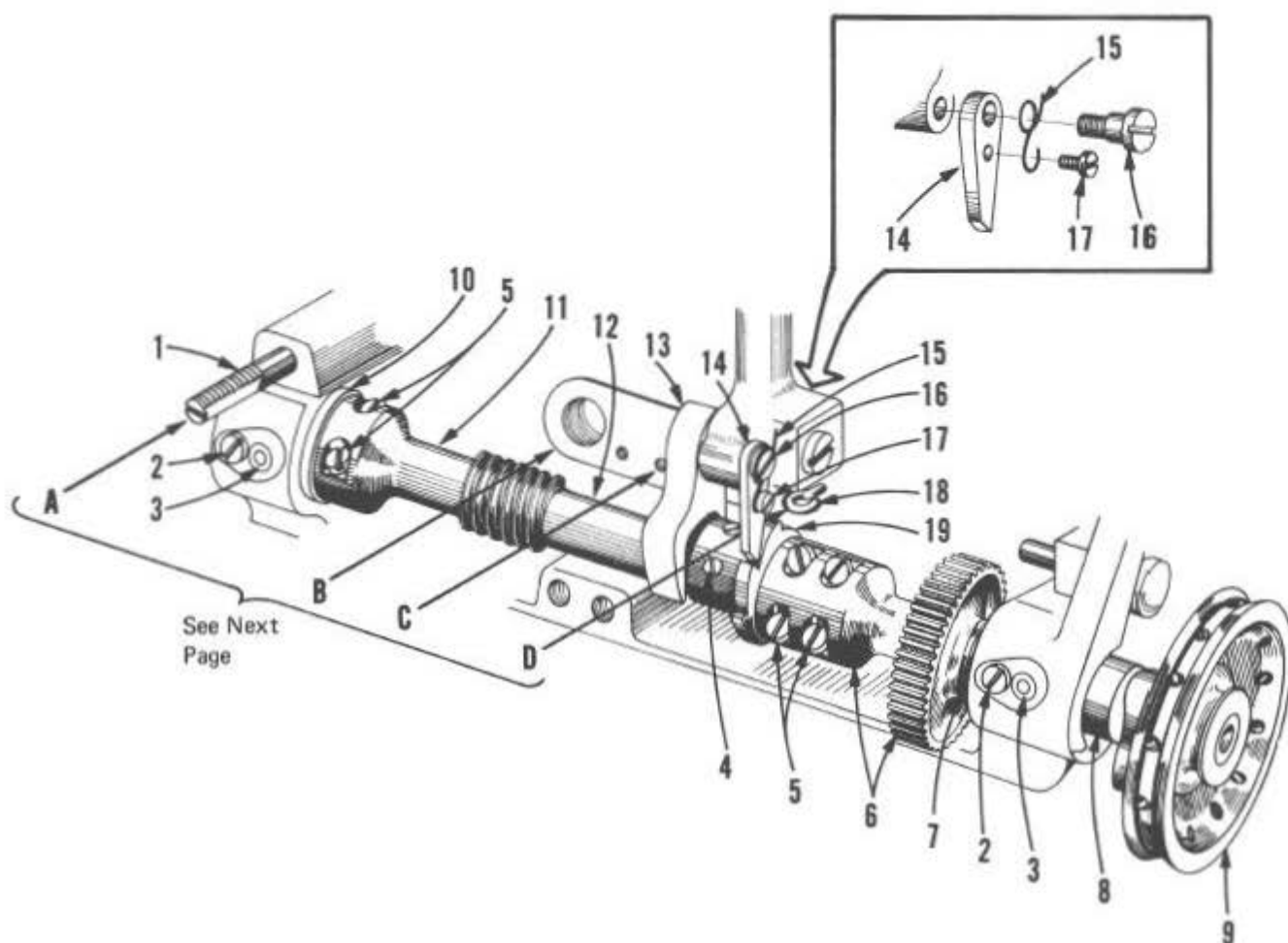
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3-9

10

BARRING MECHANISM & TENSION RELEASE

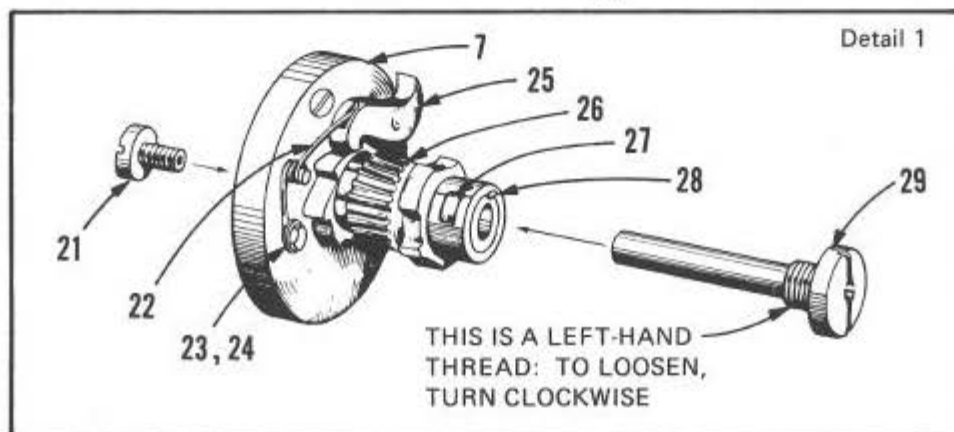
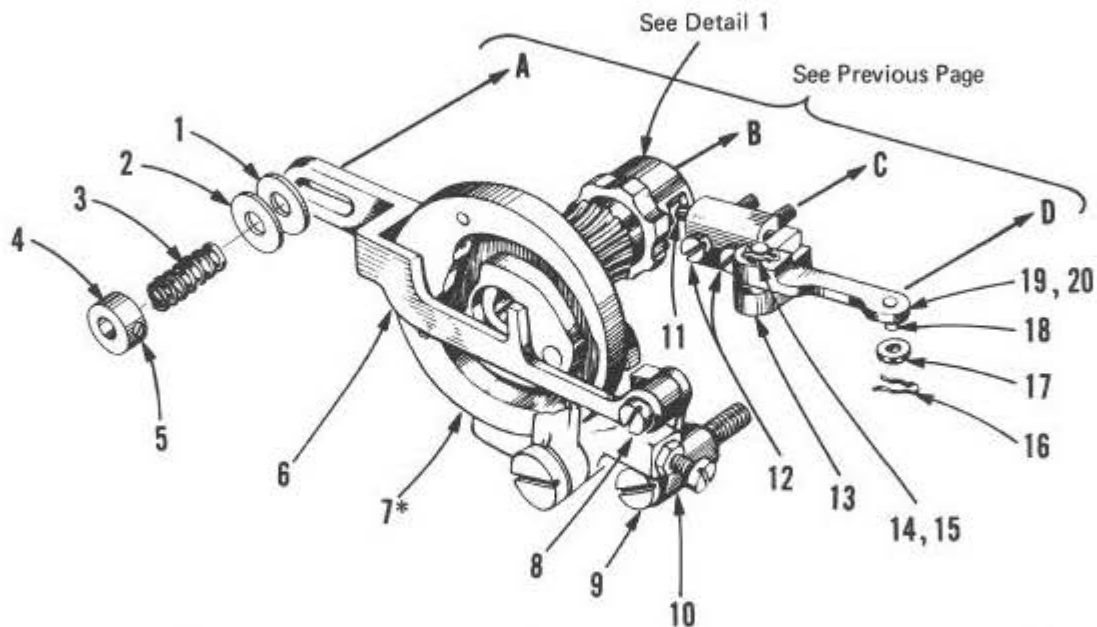


DET.	PART NUMBER	DESCRIPTION
1	01-1094	Stud
2	01-2157	Screw
3	01-6197	Pin
4	01-2150	Screw
5	01-2305	Screw
6	20-0079-0-850	Large Gear (includes (4) of detail 5)
7	20-0623	Thrust Bearing
8	20-0072-1	Bushing
9	20-0074-3	Drive Pulley
10	20-0071-2	Bushing
11	20-0082-1	Worm Gear
12	20-0567	Space Collar
13	20-0043-1	Bit Cam Follower
14	20-0066	Pawl
15	01-5148	Pawl Spring

16	01-1057	Shoulder Screw
17	01-2004	Screw
18	20-0011	Release Rod (see page 4 detail 9)
19	20-0047-2	Bite Cam

BARRING MECHANISM & TENSION RELEASE

11



DET.	PART NUMBER	DESCRIPTION
1	01-4062	Friction Washer
2	01-4035	Washer
3	01-5108	Spring
4	01-3048	Nut
5	01-2052	Set Screw
6	20-0288	Shifting Lever
7	20-0276-3-801	Fixed Reversing Cam
8	01-1053	Shoulder Screw
9	01-1054	Shoulder Screw
10	20-0290-1	Pawl Stop
11	01-6303	Push Pin
12	01-2024	Screw
13	20-0009	Bracket
14	01-6122	Cotter Pin
15	01-4063	Washer
16	01-6121	Cotter Pin

17	01-4011	Washer
18	01-6186	Pin
19	20-0010	Lever (includes detail 18)
20	01-6340	Pivot Pin
21	01-2146	Screw
22	01-5449	Spring
23	01-3016	Nut
24	01-4029	Washer
25	20-0271-3	Pawl
26	20-0277-1	Worm Gear
27	20-0278-1	Barring Cam
	20-0278-1-041	Barring Cam (3 stitch)
28	01-8405	Key
29	20-0281	Bearing Stud

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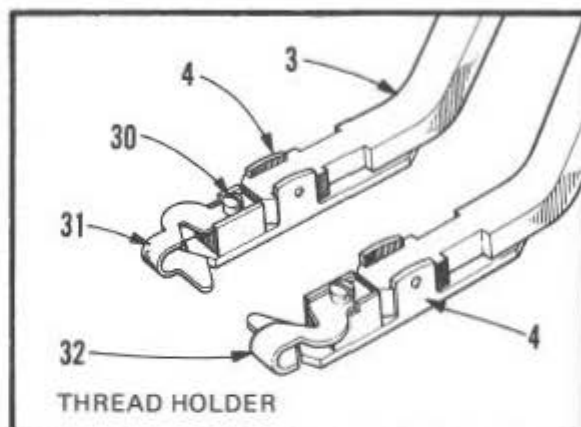
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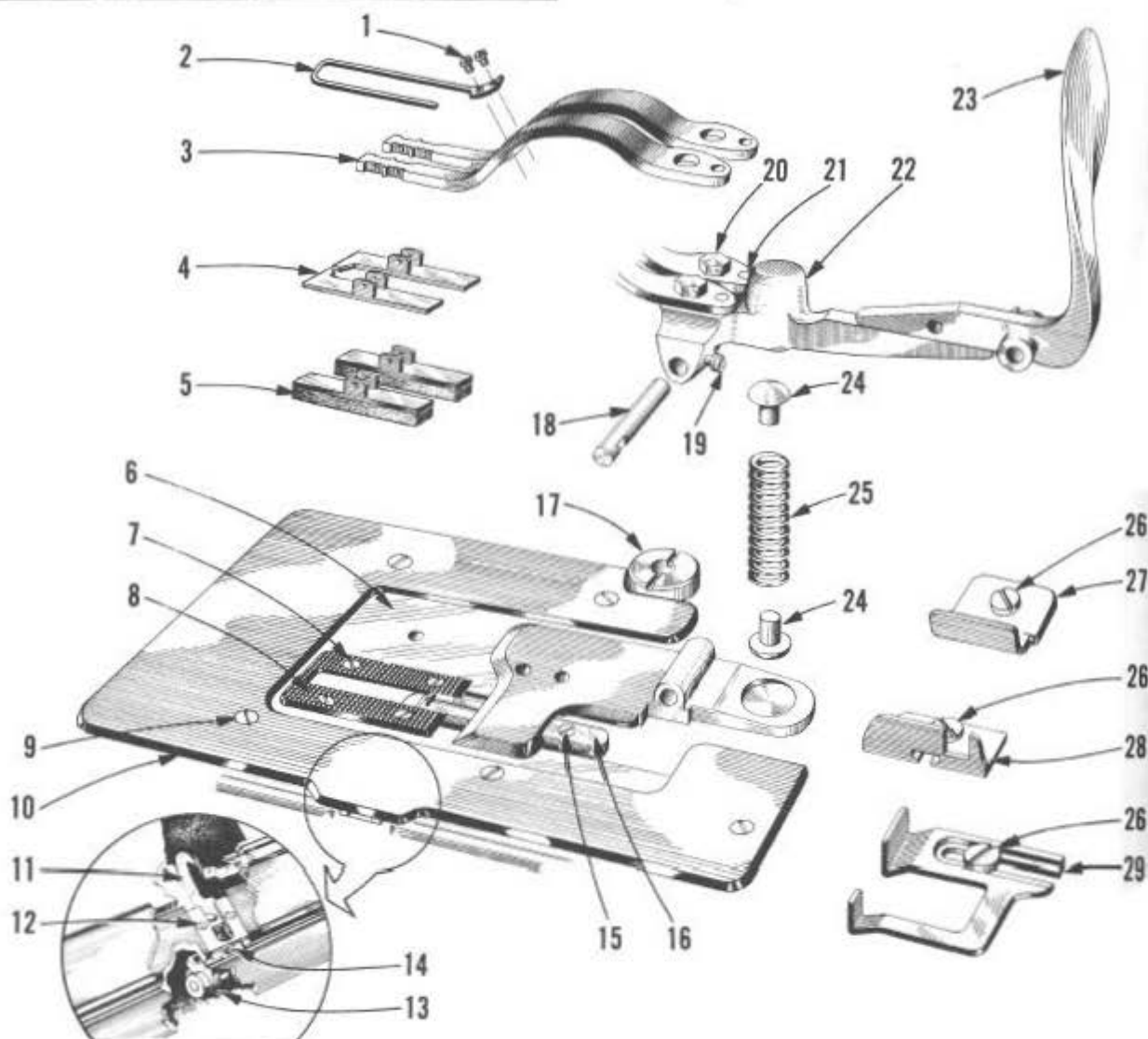
12

CLAMPING

DET.	PART NUMBER	DESCRIPTION
1	01-2013	Screw
2	20-0767-0-020 20-0767-0-023	Needle Guard, Needle Guard for 1/2" high arm.
3	20-0194-1-043 20-0194-1-052	Clamp Arms, Clamp Arms, 1/2" high arm
4	---	Clamp Feet (see chart next page)
5	20-0197-0-029 20-0197-0-035	Rubber Sole, long Rubber Sole, short
6	20-0210-2 20-0210-0-075	Clamp Plate Clamp Plate, for AGF



Cement for attaching Rubber
Soles to Feet is listed in
Accessory Section .



CLAMPING

13

7	01-2376	Screw	17	20-0281	Bearing Stud
8	---	Mat (see chart, this page)	18	01-6103	Pivot Pin
9	01-2395	Screw	19	01-2019	Set Screw
10	20-0214	Cover Plate	20	01-2355	Screw
	20-0214-0-275	Cover Plate, right CW-AGF	21	01-6055	Pin
	20-0214-0-175	Cover Plate, left CW-AGF	22	20-0190-1	Clamp Tailpiece
11	20-0093-0-004	Trimmer Hook	23	20-0332-2	Unclamping Handle
12	01-2075	Screw	24	20-0606	Spring Guide
13	20-0092-0-004	Trimmer Actuator	25	01-5082	Spring
14	20-0655-0-039	Cover Plate	26	01-2111	Screw
15	01-2084	Screw	27	20-0698	Gauge
16	---	Throat Plate (see chart this page)	28	20-0590	Gauge
			29	20-0591	Gauge
			30	01-2317	Screw
			31	20-0722-0-063	Thread Holder, left
			32	20-0722-0-064	Thread Holder, right

CLAMP FEET

PART NUMBER	DESCRIPTION		
	SIZE	TYPE	CORRUGATION
20-0196-1-337	Short	Right	FINE
20-0196-1-336	Short	Left	
20-0196-1-331	Long	Right	
20-0196-1-330	Long	Left	
20-0196-1-352	1/2"	2 used	
20-0196-0-066	Short	Right	FINE For Thread Holders see details 31 & 32 Page 10
20-0196-0-065	Short	Left	
20-0196-0-068	Long	Right	
20-0196-0-067	Long	Left	
20-0196-1-237	Short	Right	COARSE
20-0196-1-236	Short	Left	
20-0196-1-231	Long	Right	
20-0196-1-230	Long	Left	
20-0196-0-135	Short	2 used	RUBBER SOLED
20-0196-0-129	Long	2 used	

THROAT PLATE AND MATS

Throat Plates and Mats are available in the following bites and corrugations. When replacing these parts, check that replacement parts have similar bite designations.

THROAT PLATE		MATS	
PART NUMBER	BITE	PART NUMBER	CORRUGATION
20-0051-0-023	Narrow 1/16"	20-0208-1-323 20-0208-1-423	FINE SMOOTH
20-0051-0-022	Medium 5/64"	20-0208-1-322	FINE
20-0051-0-024	Regular 3/32"	20-0208-1-324 20-0208-1-224 20-0208-1-424	FINE COARSE SMOOTH
20-0051-0-025*	Wide 3/32"	20-0108-1-324 20-0108-1-224 20-0108-1-424	FINE COARSE SMOOTH

*Differs from 20-0051-0-024 only in the location of the cutting slot.

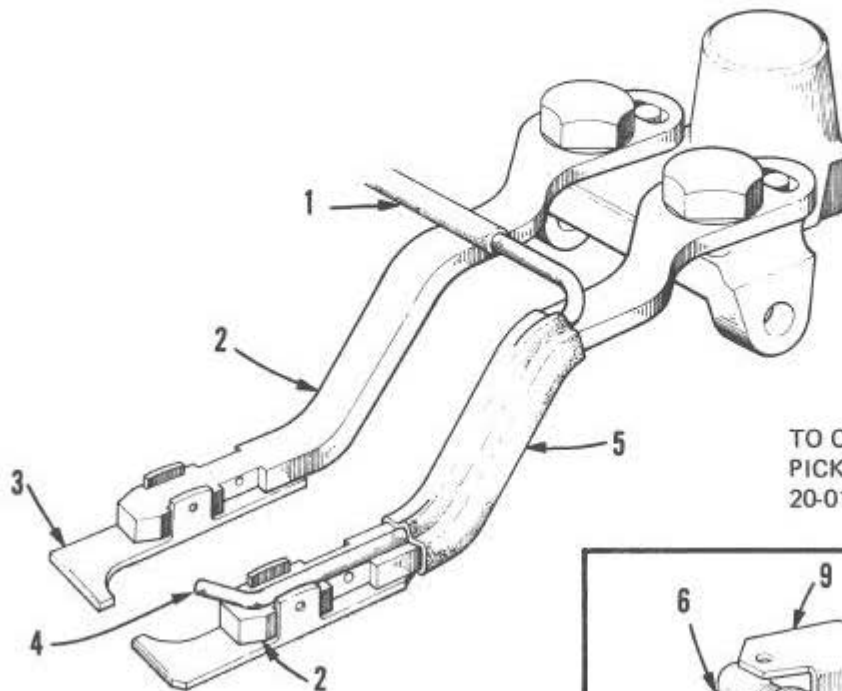
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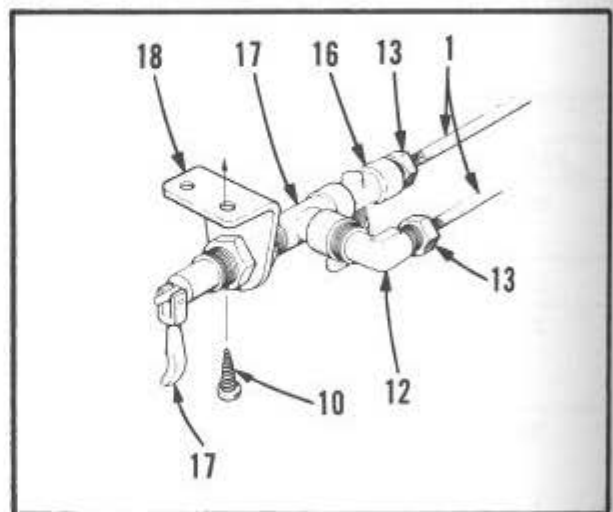
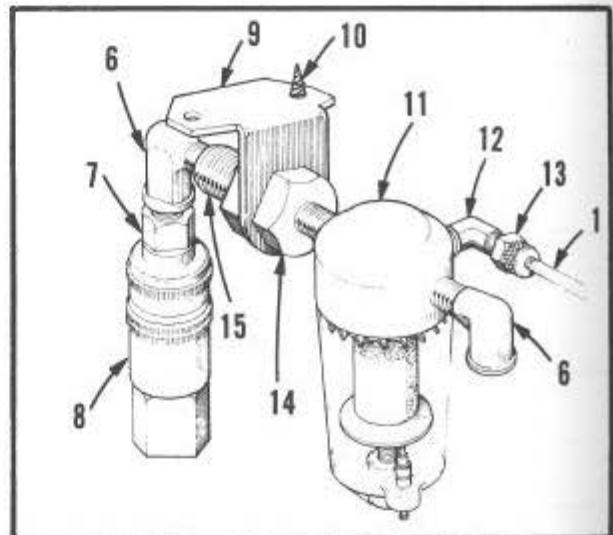
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THREAD PICK-UP (optional)



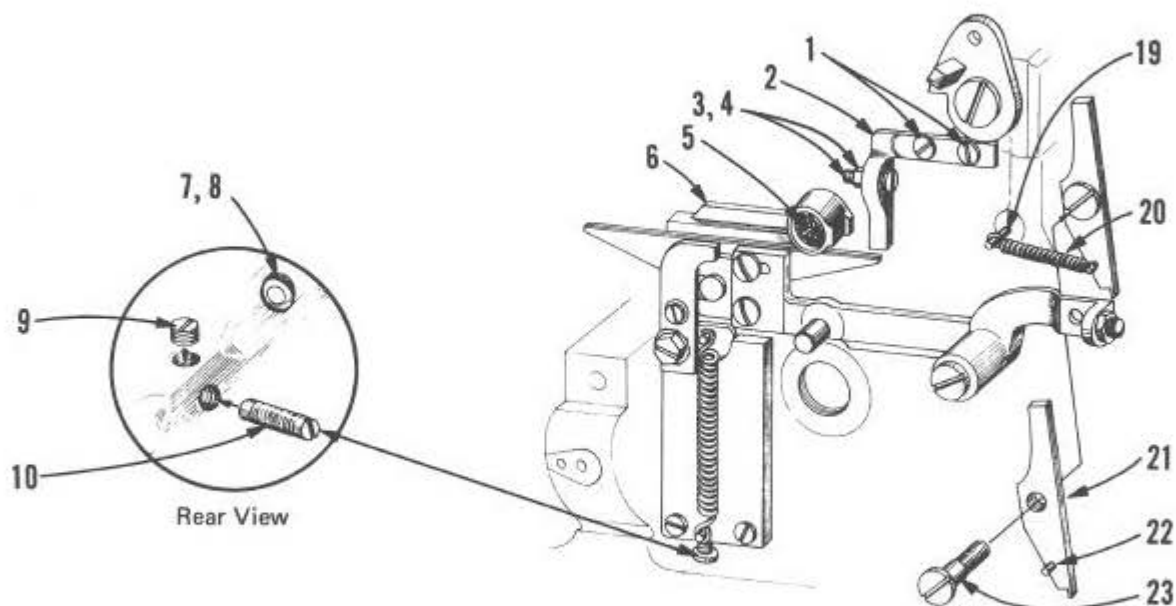
TO OBTAIN ENTIRE S2 THREAD
PICKUP KIT, ORDER NUMBER
20-0194-0-276

DET.	PART NUMBER	DESCRIPTION
1	04-2040	Tubing
2	20-0194-0-176	Thread Pickup Clamp Arm (includes details 4 & 5)
3	—	Clamp Feet (see chart page 13)
4	20-0746	Air Tube (must be soldered to detail 2)
5	20-7047	Heat Shrinkable Tubing
6	07-0003-0-001	Street Elbow
7	20-6047	Plug
8	20-6048	Coupler
9	20-6091	Bracket
10	01-2616	Screw
11	04-0496	Filter
12	20-6245	Elbow (includes detail 13)
13	04-2041	Nut & Ferrule
14	20-6049	Nipple
15	20-6092	Bulkhead Adapter
16	20-6086	Needle Valve
17	20-6085	Toggle Valve
18	20-6089	Bracket

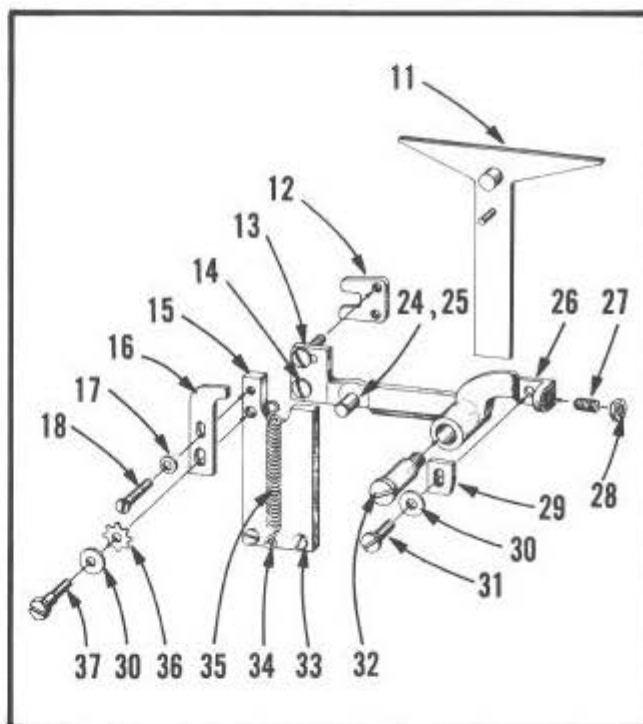


CLAMP PLATE SIDE SHIFTING MECHANISM

15



DET.	PART NUMBER	DESCRIPTION
1	01-2039	Screw
2	20-0230-1-850	Adjustable Stop (includes details 3 & 4)
3	01-2122	Screw
4	01-3001	Nut
5	20-0566	Oil Wick
6	20-0210-2	Clamp Plate
7	20-0609	Oil Well
8	20-0610	Felt Wick
9	01-2150	Set Screw
10	01-2331	Screw
11	20-0225-1	"T" Piece
12	20-0254	Adjusting Finger
13	01-2166	Screw
14	01-1051	Shoulder Screw
15	20-0222-1	Cover Plate (includes detail 35)
16	20-0012	Stop
17	01-4029	Washer
18	01-2045	Adjustable Screw
19	01-6833	Pin (part of bedplate)
20	01-5033	Spring
21	20-0634	Latch (includes detail 22)
22	01-6079	Anchor
23	01-1031	Screw
24	01-6108	Stud
25	01-7013	Roll
26	20-0251-1-100	Lever & Finger Asm. (includes details 24 & 25)



27	01-2304	Screw
28	01-3021	Nut
29	20-0633	Stop
30	01-4011	Washer
31	01-2130	Screw
32	01-1047	Shoulder Screw
33	01-2550	Screw
34	01-6165	Anchor
35	01-5106	Spring
36	01-4018	Washer
37	01-2332	Screw

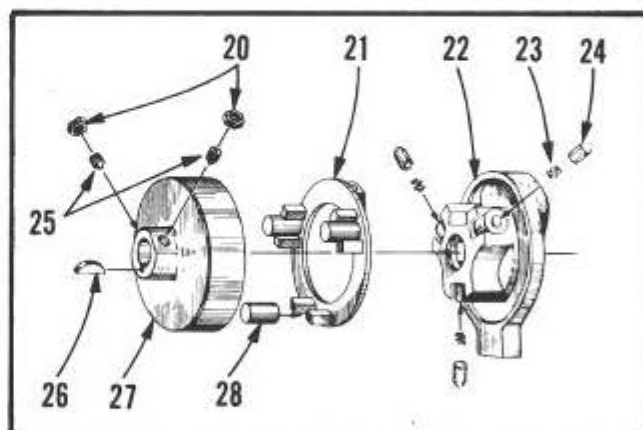
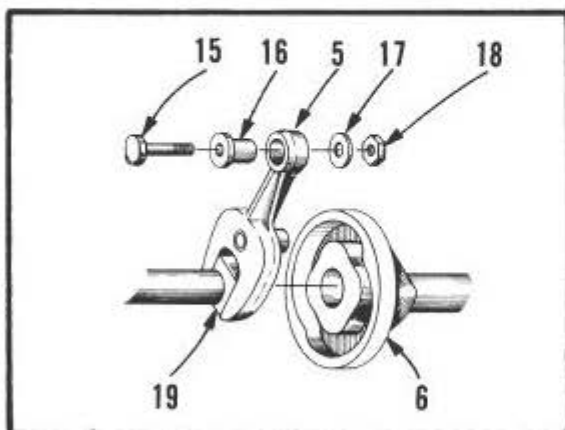
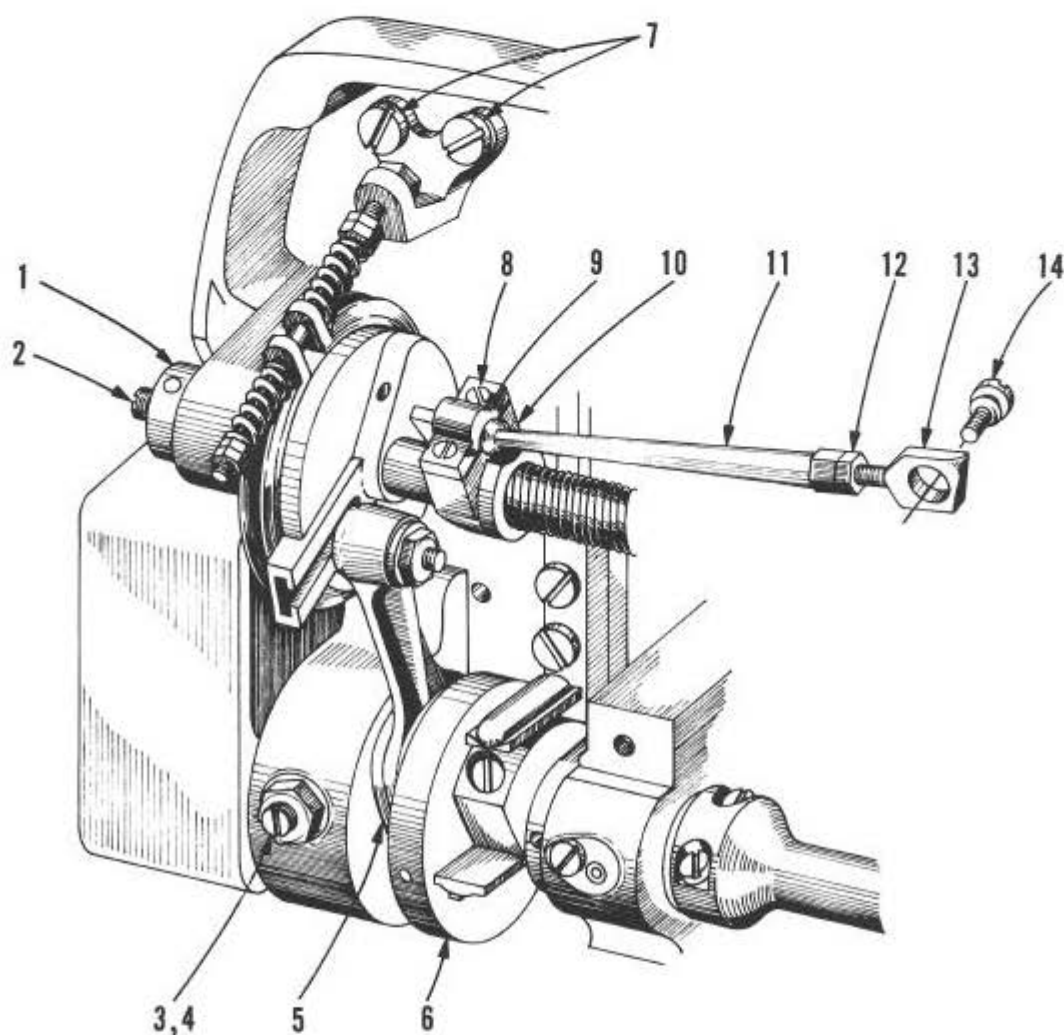
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3-15

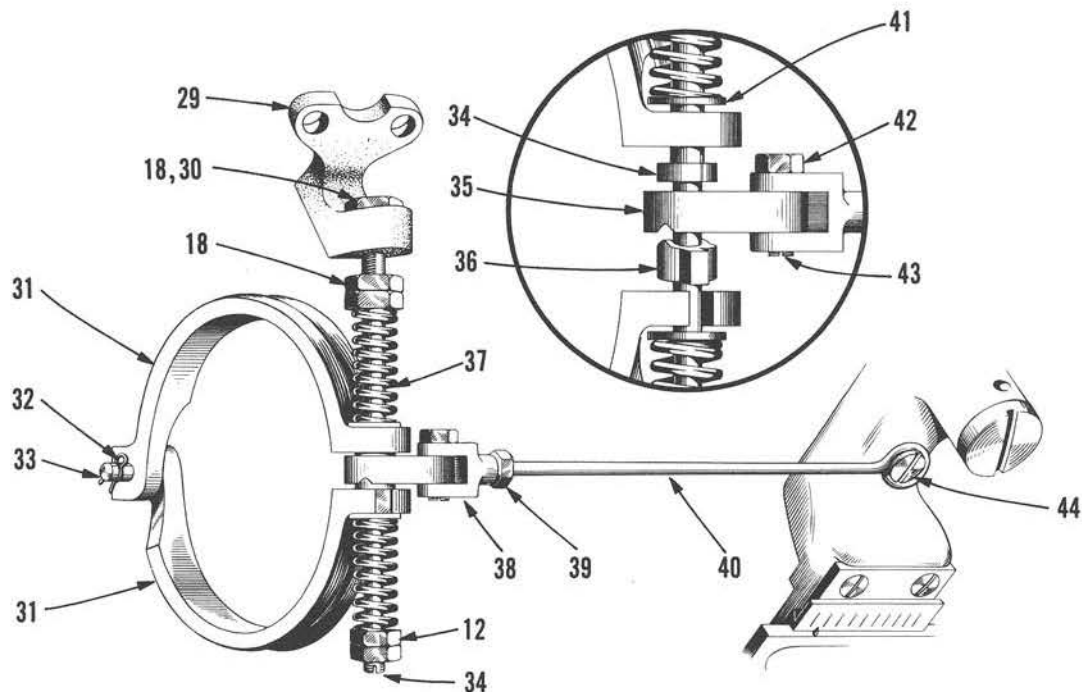
16

FEED MECHANISM



FEED BRAKE MECHANISM

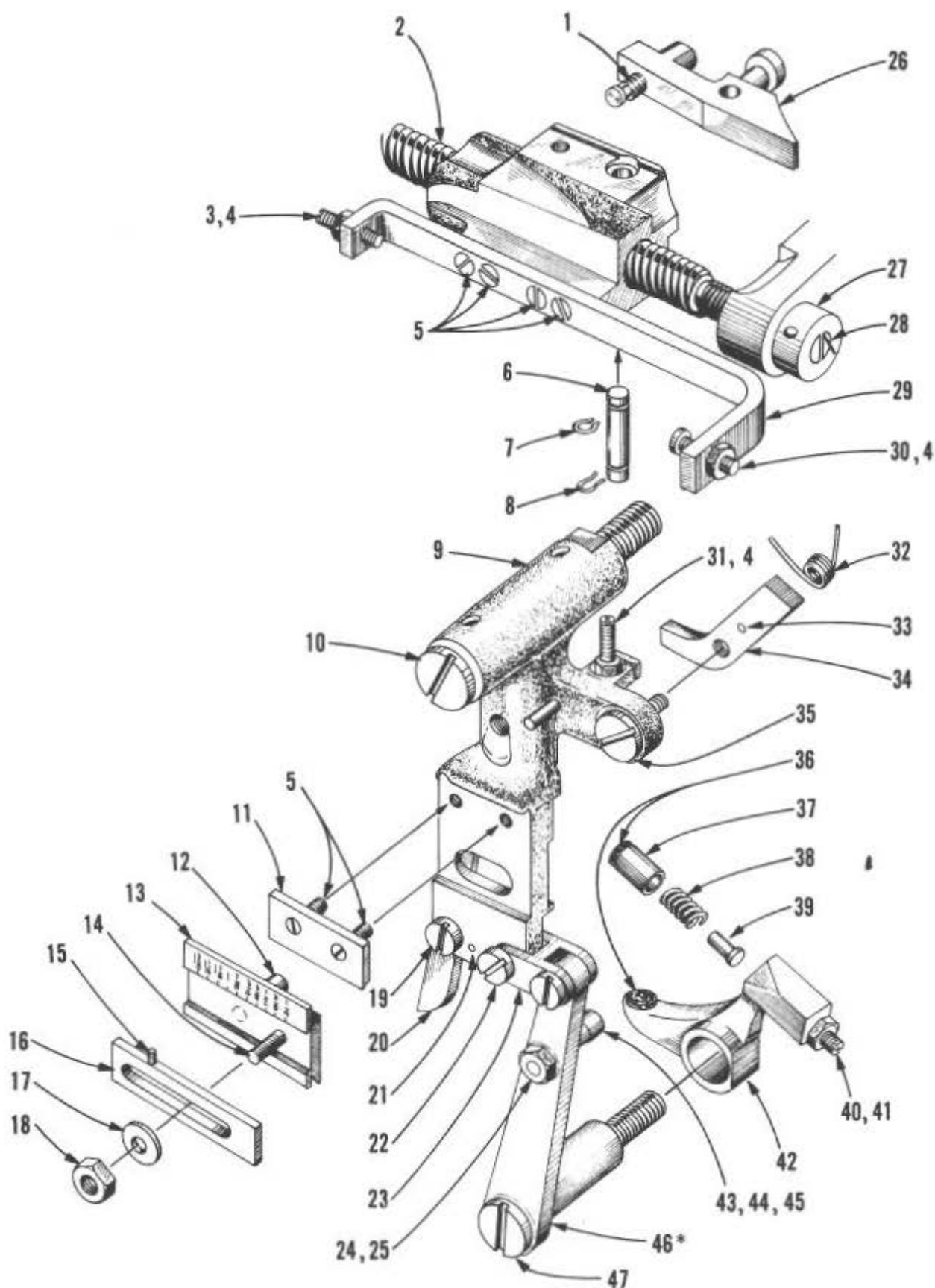
17



DET.	PART NUMBER	DESCRIPTION
1	01-3039	Lock Collar
2	01-2160	Bearing Screw
3	01-2359	Set Screw
4	01-3011	Lock Nut
5	20-0122-1-100	Cam Follower
6	20-0096-1-100	Cam with Screws
7	01-2041	Screw
8	01-2019	Clamp Screw
9	20-0169	Bearing Cap
10	20-0166	Shifter
11	20-0167-1	Connecting Rod
12	01-3001	Nut
13	20-0172	Link
14	20-0173	Ball Screw
15	01-1096	Screw
16	01-7029	Bushing
17	01-4002	Washer
18	01-3020	Nut
19	20-0036	Cam Block
20	01-3021	Nut
21	20-0032-1	Shifter Ring
22	20-0030-1	Feed Cage
23	01-5102	Spring
24	20-0033	Race Plunger
25	01-2304	Set Screw
26	01-8005	Key
27	20-0031	Feed Drum
28	20-0035	Roller
29	20-0134-1	Bracket
30	01-4011	Washer
31	20-0135-2	Brake Shoe
32	01-6121	Cotter Pin
33	01-6306	Pin (Part of Bedplate Asm.)
34	01-1134	Brake Stud
35	20-0661	Release Arm
36	20-0660	Release Cam
37	01-5156	Spring
38	20-0580	Clevis
39	01-3025	Nut
40	20-0582	Rod
41	01-4065	Washer
42	01-3016	Nut
43	01-1039	Screw
44	01-1071	Screw

18

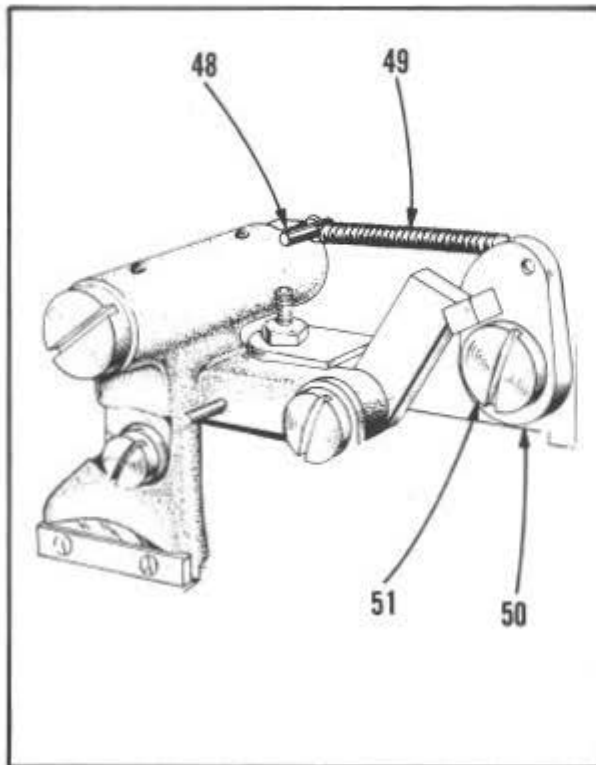
BUTTONHOLE LENGTH CONTROL



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BUTTONHOLE LENGTH CONTROL

19


DET.	PART NUMBER	DESCRIPTION
1	01-5020	Spring
2	20-0133-0-100	Feed Screw and Feed Block
3	01-2505	Adjustable Screw
4	01-3001	Nut
5	01-2123	Screw
6	01-6508	Pin
7	01-6406	Retaining Ring
8	01-6121	Cotter Pin
9	20-0243-2	Rocker Lever (includes detail 21)
10	01-1044	Pivot Screw
11	20-0015	Cover Plate
12	01-6105	Pin
13	20-0236	Length Gage (inches)
	20-0236-0-001	Length Gage (mm)
14	01-1069	Stud
15	01-6106	Pin (part of detail 16)

16	20-0240-1 20-0240-0-052	Adjustable Slide Adjustable Slide (use only with 20-0196-0-352 1/2" Clamp Feet)
17	01-4059	Washer
18	01-3053	Nut
19	01-1043	Shoulder Screw
20	20-0241-1	Shifter
21	01-6574	Pin
22	01-1045	Shoulder Screw
23	20-0246	Link
24	01-3402	Nut
25	01-4672-0-001	Lock Washer
26	20-0174-1	Guide Block
27	01-3039	Nut
28	01-2336	Bearing Screw
29	20-0180	Bracket
30	01-2122	Adjustable Screw
31	01-2044	Adjustable Screw
32	01-5147	Spring
33	01-6135	Pin
34	20-0013	Latch (includes detail 33)
35	01-1098	Shoulder Screw
36	20-0266	Brake Pad
37	20-0268	Plunger
38	01-5107	Spring
39	10-4019	Pin
40	01-3066	Nut
41	01-2560	Adjustable Screw
42	20-0263	Brake
43	01-1496	Screw
44	01-7535	Roller
45	01-7536	Spacer
46	20-0258-1*	Lever Asm. (includes details 24, 25, 43, 44 & 45)
47	01-1048	Pivot Screw
48	01-6822	Anchor (part of bedplate)
49	01-5038	Spring
50	20-0308-1	Latch
51	01-1097	Shoulder Screw

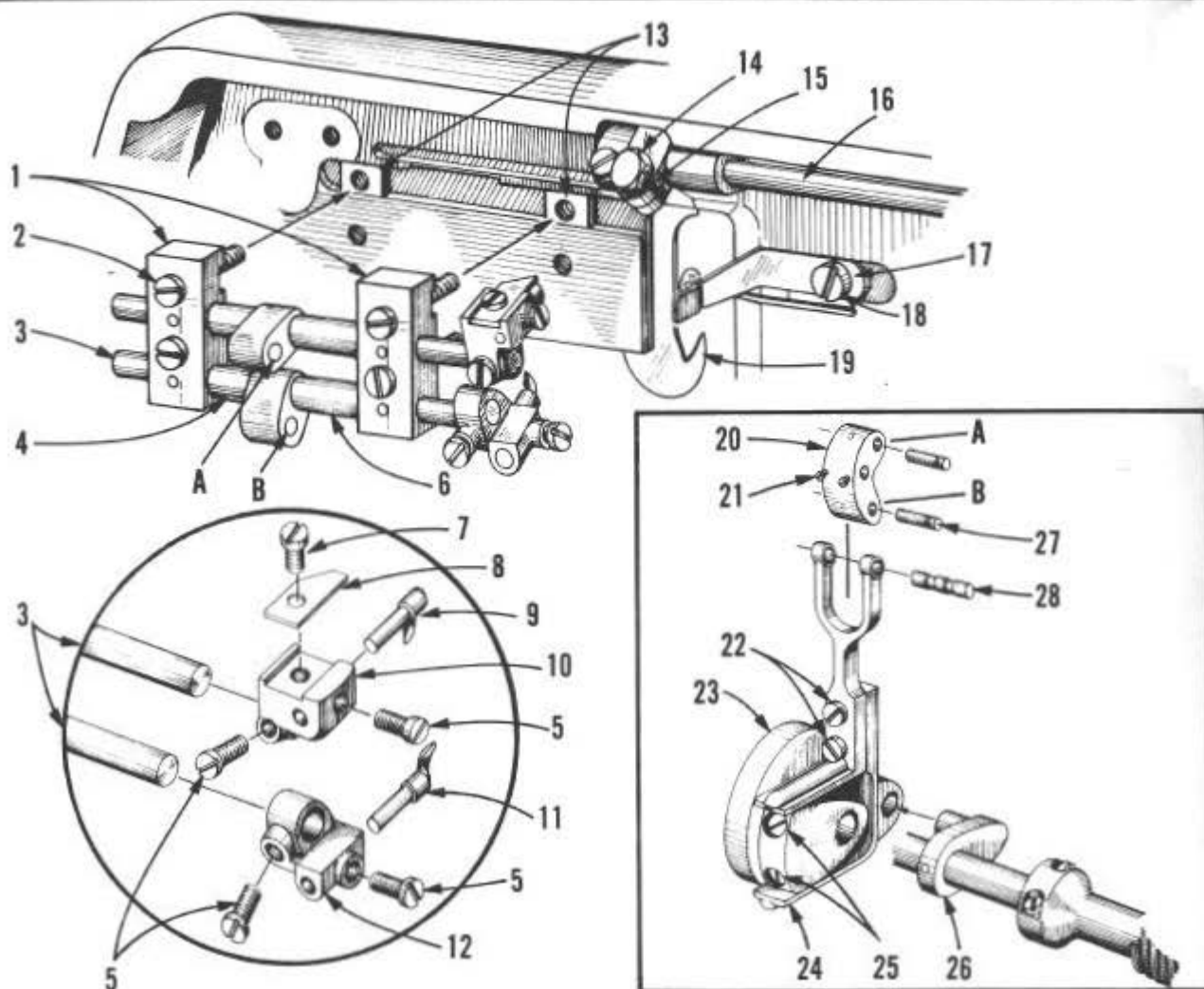
* Assembly, refer to Parts Index for assembly components.

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3-19

20

LOOPERS & THREAD TRIMMING

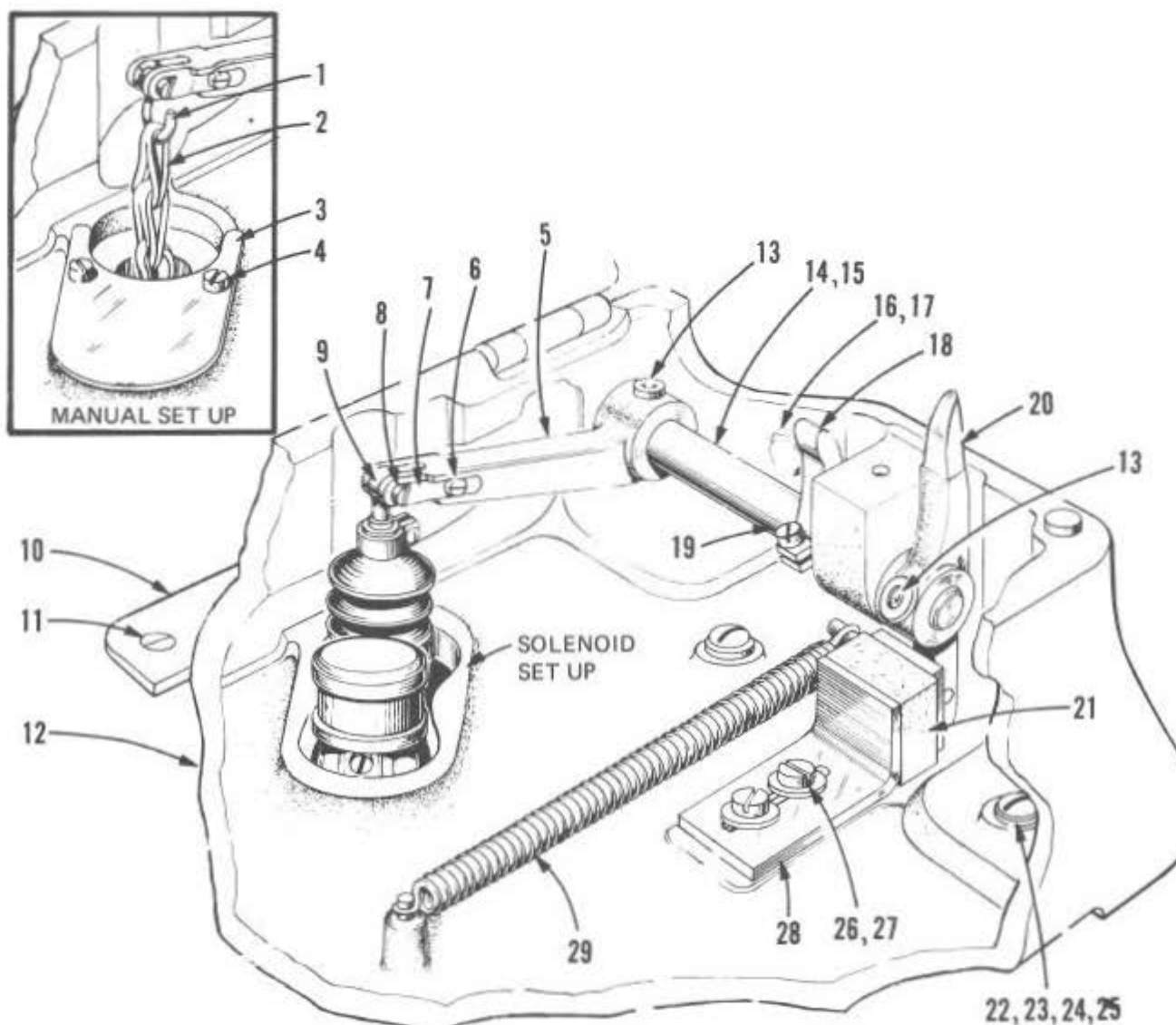


DET.	PART NUMBER	DESCRIPTION
1	20-0106-1	Bearing Blocks, Pair (replace both blocks at the same time)
2	01-2128	Screw
3	20-0107-2	Looper Drive Shaft
4	20-0569	Spacing Collar
5	01-2019	Screw
6	20-0570	Long Space Collar
7	01-2351	Screw
8	20-0094-1	Thread Trimmer Knife (for S2BH & 2 row tackers only)
	20-0094	Thread Trimmer Knife (for all other models)
9	20-0116-3	First Looper
10	20-0115-2	First Looper Holder
11	20-0119-2	Second Looper
12	20-0118-3	Second Looper Holder

13	20-0577	Key
14	01-2386	Screw
15	20-0092-0-004	Trimmer Actuator
16	20-0086-1	Rod
17	20-0624	Needle, Guard, Optional
18	01-2004	Screw, Optional
19	20-0093-0-004	Trimmer Hook
20	20-0110-1	Rocker
21	01-2334	Set Screw
22	01-2601	Screw (2 used)
23	20-0096-1-100	Looper and Feed Cam (includes detail 25)
24	20-0098-2-100	Looper Cam Follower (includes detail 22)
25	01-2372	Screw
26	20-0085-2	Rocker Arm
27	01-6096	Pivot Pin
28	01-6097	Pivot Pin

BASE & COMPONENT PARTS

21



DET.	PART NUMBER	DESCRIPTION
1	04-0538	Hook (Manual)
2	04-0537	Chain (Manual)
3	20-0696	Cover (Manual)
4	01-2050	Screw (Manual)
5	20-0688	Lever
6	01-2157	Screw
7	01-5442	Clip
8	01-6534	Pin
9	04-0089	Upper Link
10	04-0119	Plate
11	01-2632	Screw
12	20-0398-3	Base
13	01-2548	Screw
14	20-0687	Shaft
15	01-8002	Key

16	01-2020	Screw
17	01-4004	Washer
18	20-0690	Trip Lever
19	01-2156	Screw
20	20-0689	Arm
21	20-0692-1	Rubber
22	01-2547-1	Wood Screw
23	01-4052	Washer
24	01-4037	Rubber Washer
25	01-7016	Rubber Bushing
26	01-2017	Screw
27	01-4024	Washer
28	20-0691-1-100	Bumper (includes detail 21)
29	01-5158	Spring

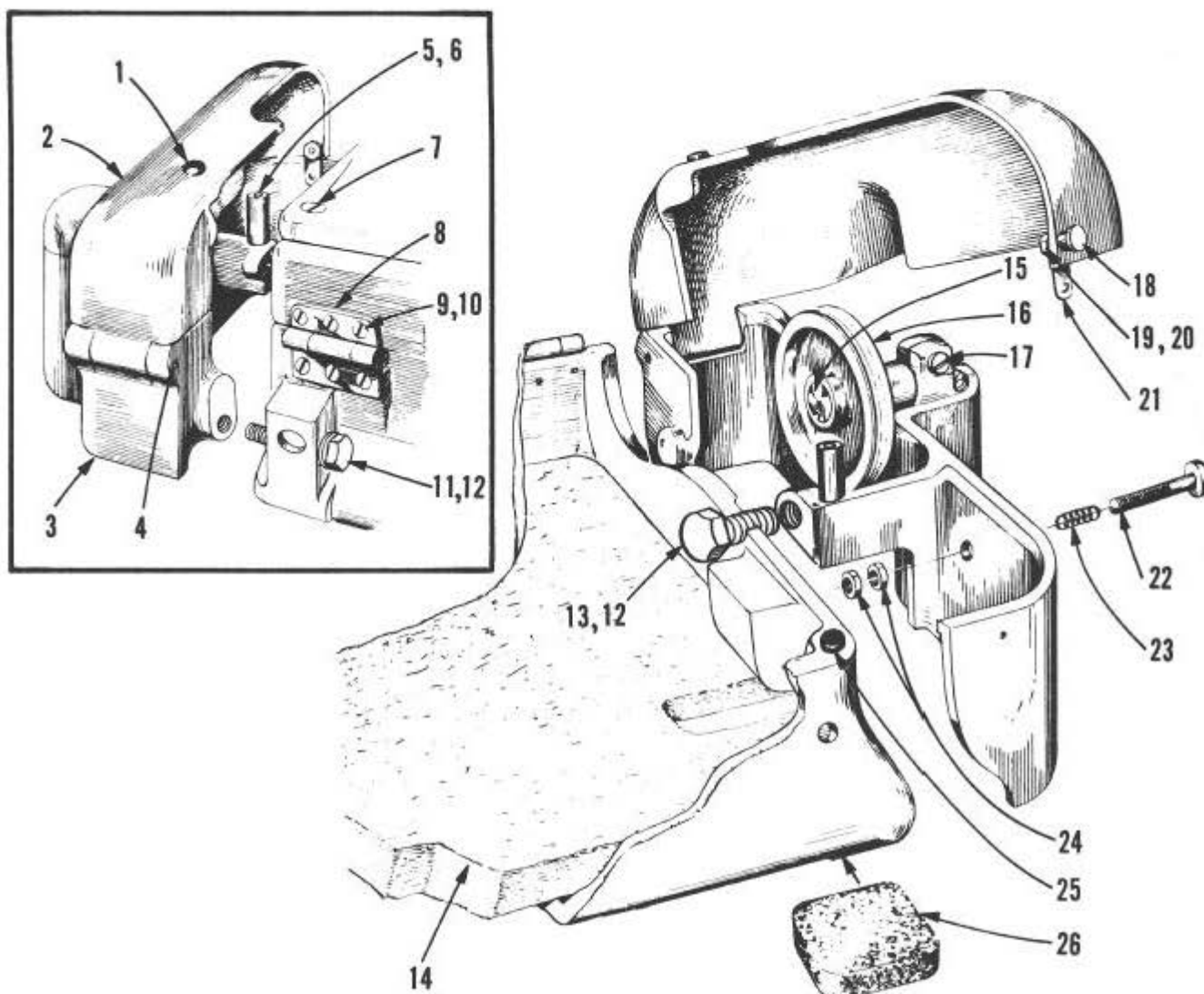
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3-21

22

BASE & COMPONENT PARTS



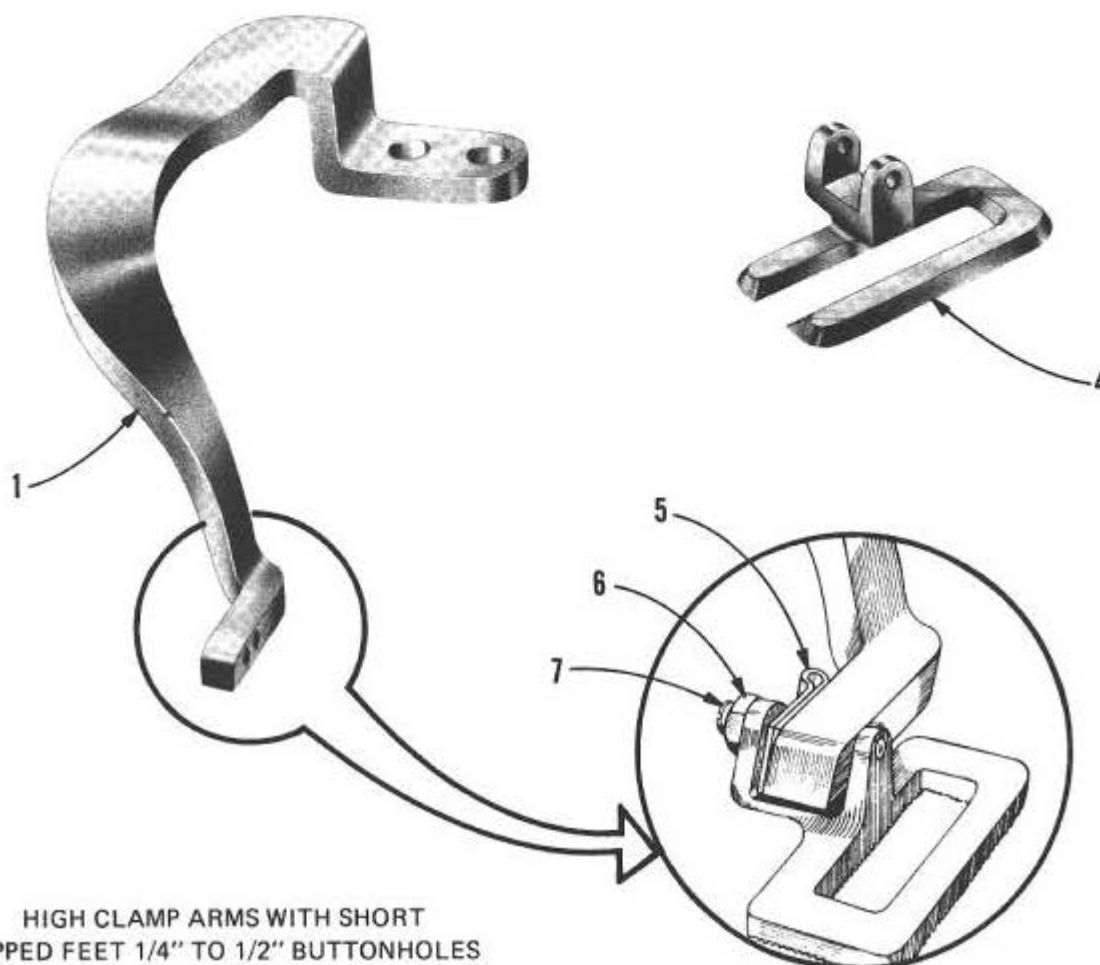
DET.	PART NUMBER	DESCRIPTION
1	20-0016	Bumper
2	20-0585-0-811	Belt Guard Cover
	20-0585-0-075	Belt Guard Cover (for parallel garment feeders)
3	20-0348-1-811	Belt Guard
4	01-6314	Pin
5	01-6327	Pin
6	01-7037	Bumper
7	01-2170	Screw
8	20-0376-0-850	Hinge
9	01-4068	Washer
10	01-2339	Screw
11	01-2549	Screw

12	01-4004	Lock Washer
13	01-2020	Screw
14	05-0042-2	Pad (pkg. 5)
15	20-0345-0-100	Bearing Stud
16	20-0346-2	Idle Pulley
17	01-2171	Screw
18	01-3040	Knob
19	01-2059	Screw
20	01-4019	Lock Washer
21	01-5123	Latch Spring
22	20-0052	Plunger
23	01-5116	Spring
24	01-3011	Nut
25	20-0596	Bumper
26	20-0598-2	Felt Pad

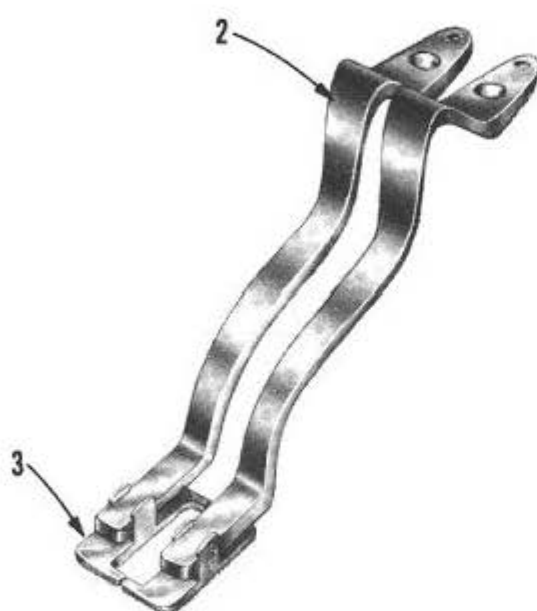
SPECIAL BUTTONHOLE CLAMPS

23

HIGH CLAMP ARM WITH "U" SHAPED FOOT



HIGH CLAMP ARMS WITH SHORT LIPPED FEET 1/4" TO 1/2" BUTTONHOLES

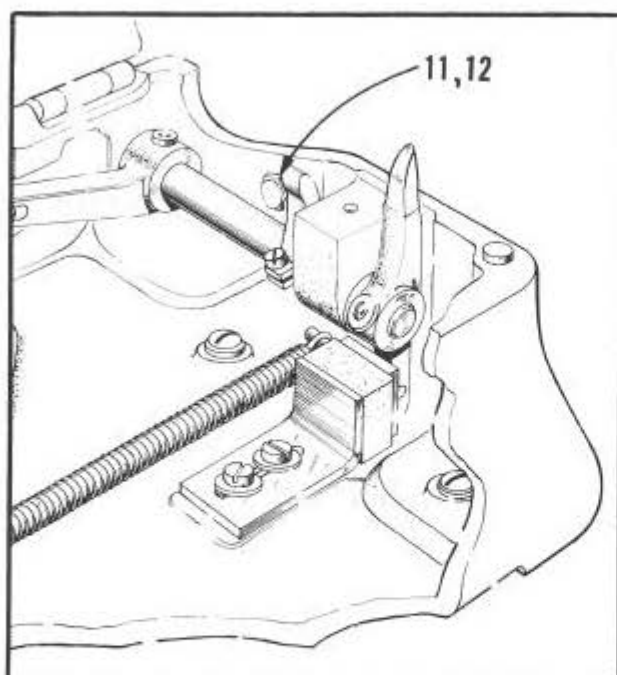
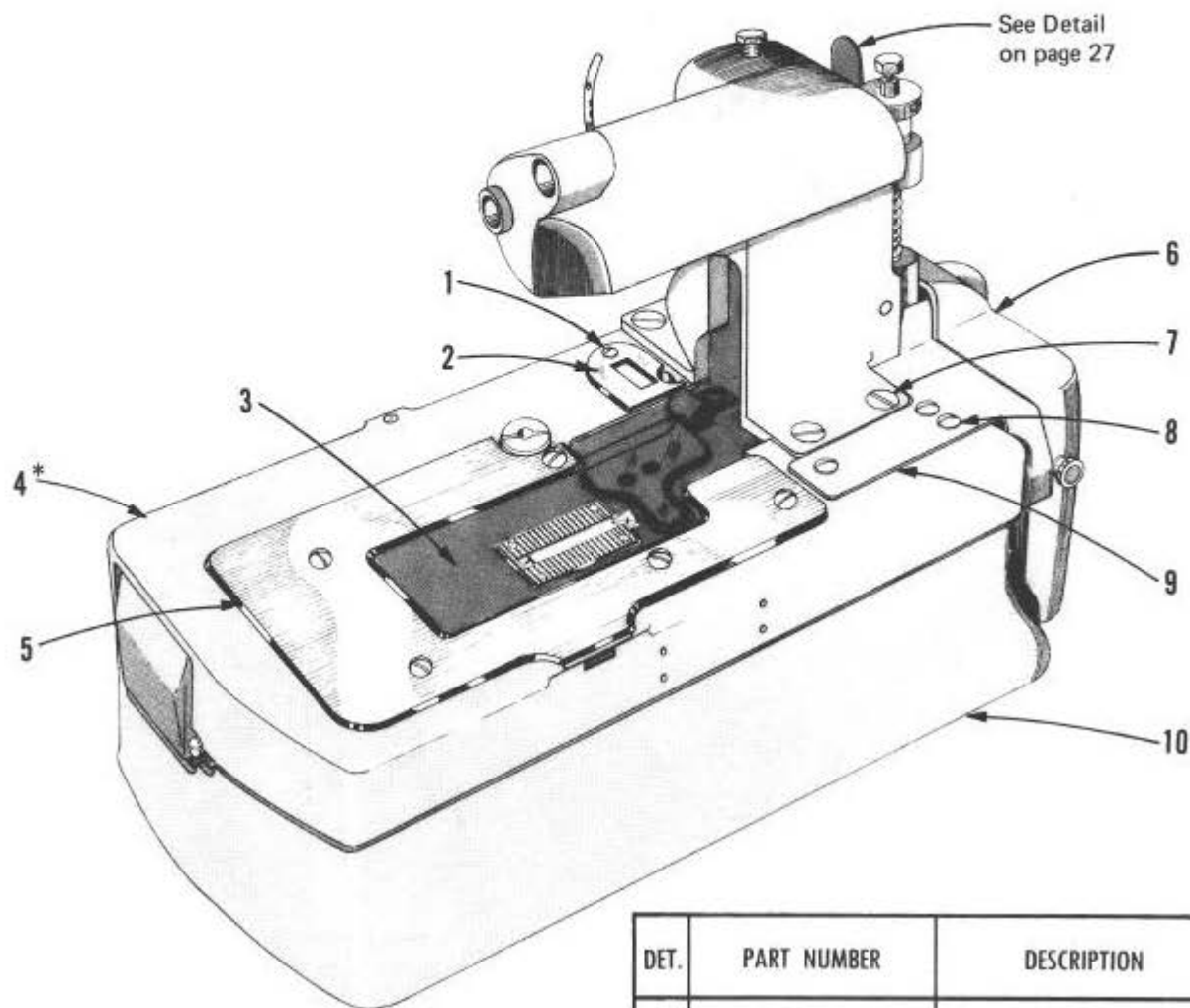


DET.	PART NUMBER	DESCRIPTION
1	20-0649-0-041	High Clamp Arm
2	20-0194-0-052	High Clamp Arm
3	20-0196-0-352	Foot, short Use 20-0240-0-052 1/2" Adjustable Slide
4	20-0650-0-401	Clamp Foot "U" shaped - 7/8"
	20-0650-0-501	Clamp Foot "U" shaped - 1-3/8"
5	01-5174	Spacer Spring
6	01-3065	Nut
7	01-1125	Screw

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3-23



DET.	PART NUMBER	DESCRIPTION
1	20-0584-1-001	Cover Plate
2	01-6550	Pin
3	20-0210-0-015	Clamp Plate
4	20-0397-0-015*	Head & Bedplate Asm.
5	20-0214-0-001	Cover Plate
6	20-0585-0-002	Belt Guard Cover
7	01-2422	Screw
8	01-2344	Screw *
9	20-0586-0-001	Cover
10	20-0398-4-801	Base
11	01-2020-0-001	Screw
12	01-4004	Washer

* Assembly, refer to Parts Index for assembly components

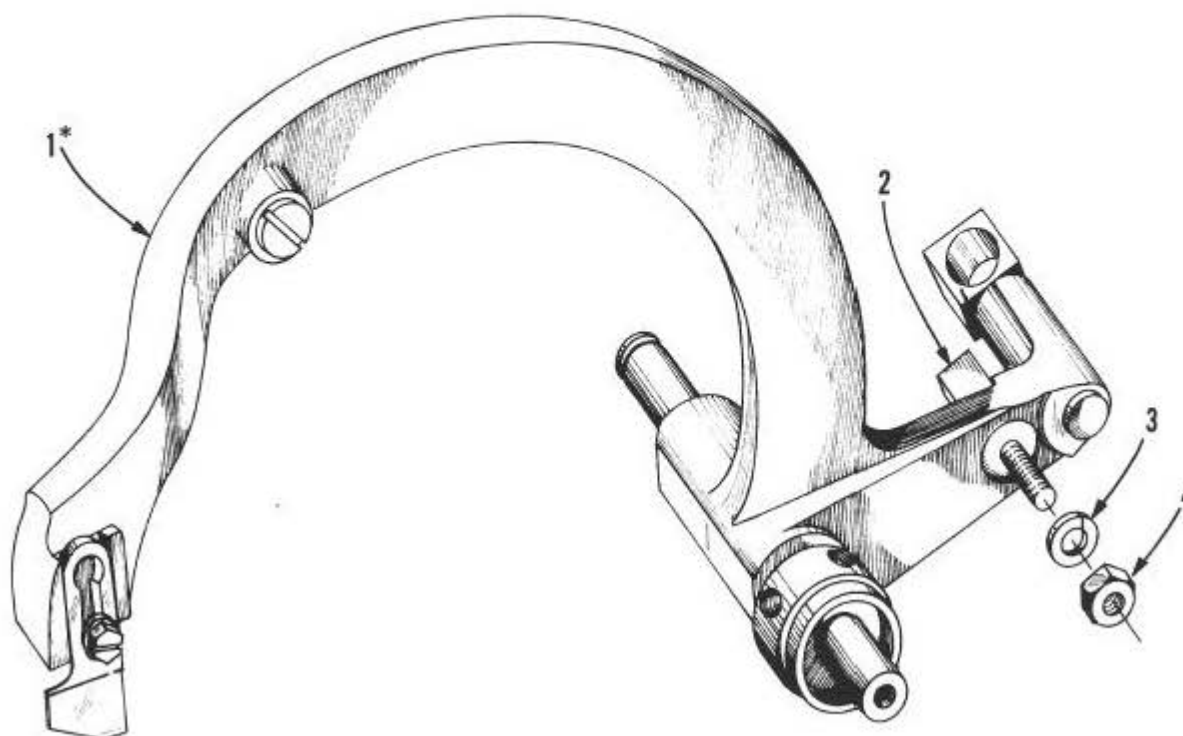
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3-25

26

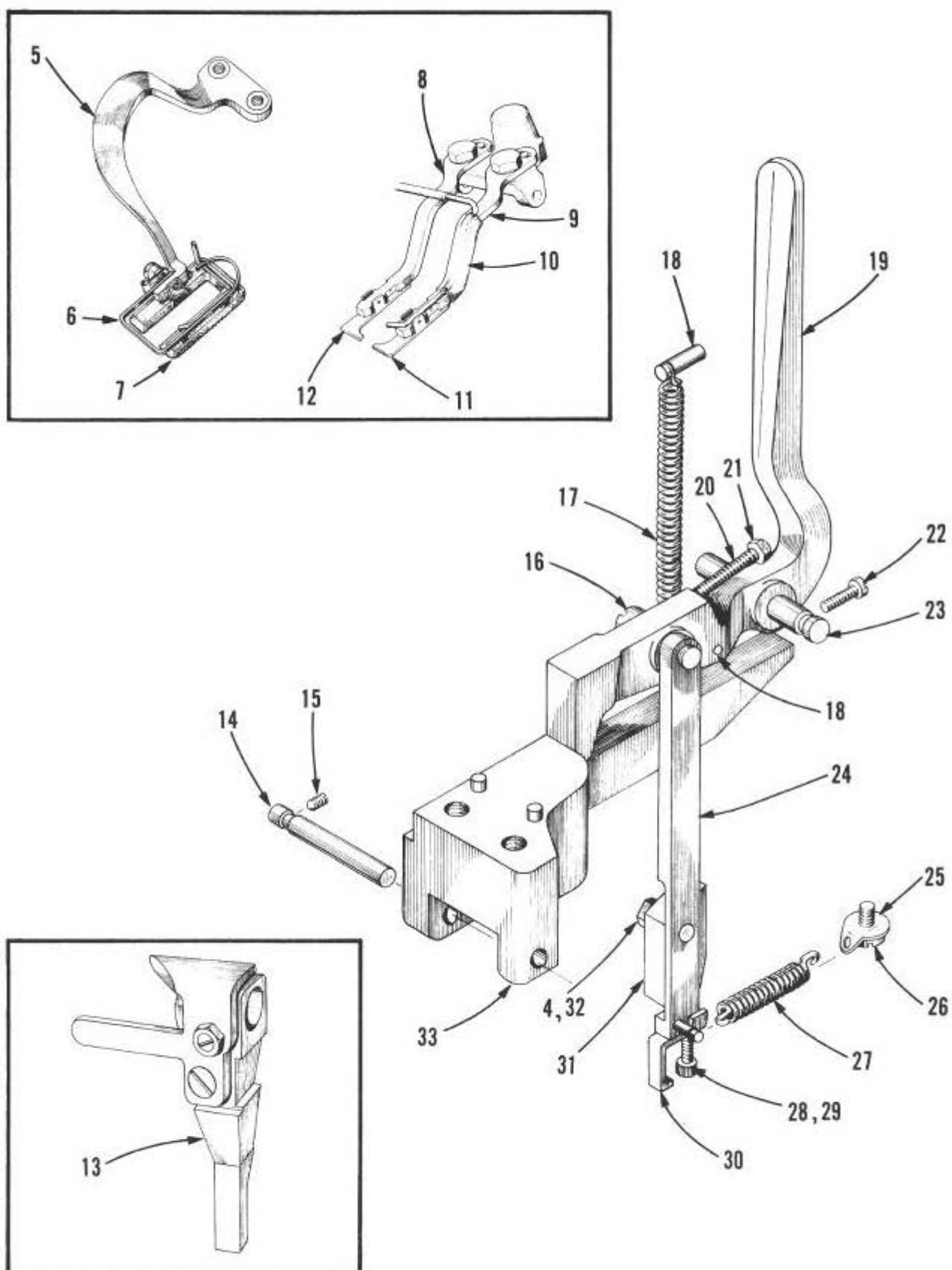
OFFSET HEAD MODEL

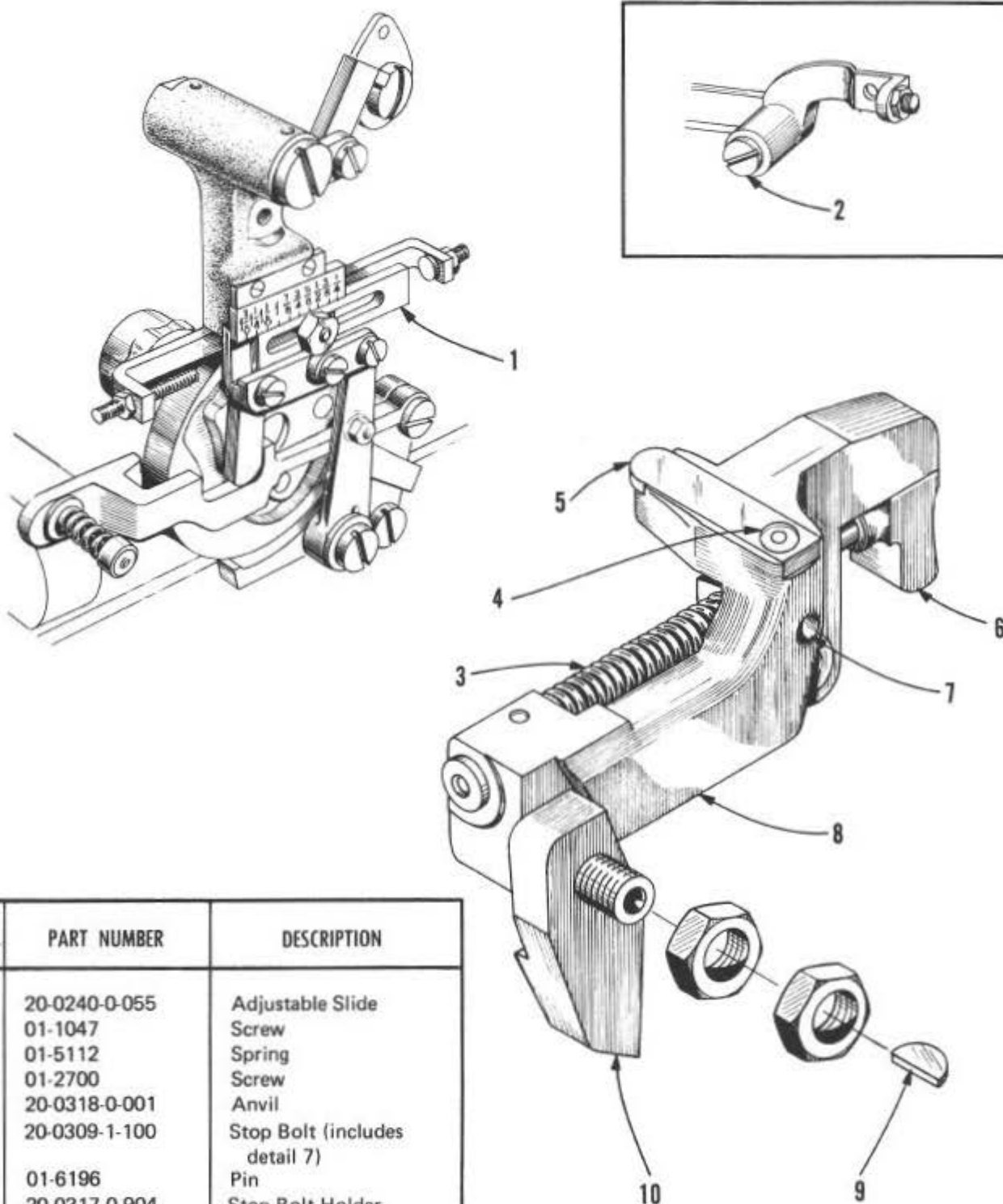


DET.	PART NUMBER	DESCRIPTION
1	20-0357-1-006*	Cutting Lever Asm.
2	20-0360-0-001	Stop Post
3	01-4003	Lock Washer
4	01-3005	Nut
5	20-0649-0-048	Clamp Arm
6	20-0767-0-043	Needle Guard
7	20-0650-0-401	Clamp Foot (7/8" "U" shape)
8	20-0194-1-004	Clamp Arm
9	20-0194-0-005	Clamp Arm
10	20-0747	Shrink Tube
11	20-0196-1-331	Clamp Foot (fine right long)
	20-0196-1-337	Clamp Foot (fine right short)
12	20-0196-1-330	Clamp Foot (fine left long)
	20-0196-1-336	Clamp Foot (fine left short)
13	20-0323-0-001	Arm
14	01-6103-0-001	Pivot Pin
15	01-2522	Set Screw

16	01-1124-0-001	Screw
17	01-5571-0-001	Spring
18	01-6833-0-001	Anchor
19	20-0332-0-001	Unclamping Handle
20	01-2044	Screw
21	01-3001	Hex Nut
22	01-2274-0-001	Screw
23	01-6590-0-001	Pivot Pin
24	20-0328-0-001	Link Asm.
25	40-0434	Anchor
26	01-2870	Screw
27	01-5571	Spring
28	01-2748	Screw
29	01-3414	Nut
30	20-0771	Switch Actuator (part of link asm.)
31	20-0583-0-001	Adjusting Catch
32	01-4011	Washer
33	20-0190-0-001	Tail Piece Asm.

* Assembly, refer to Parts Index for assembly components.

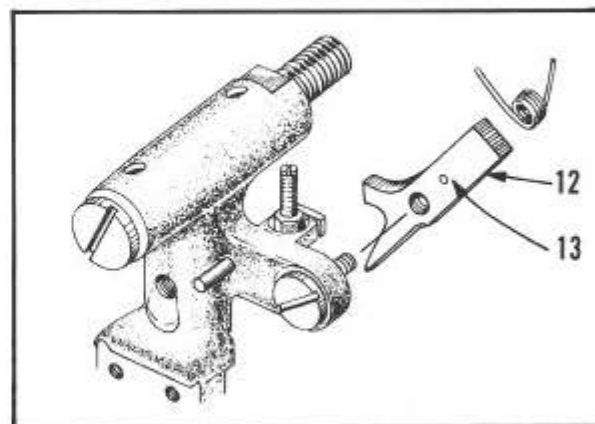
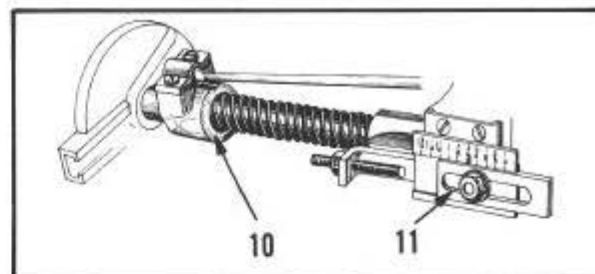
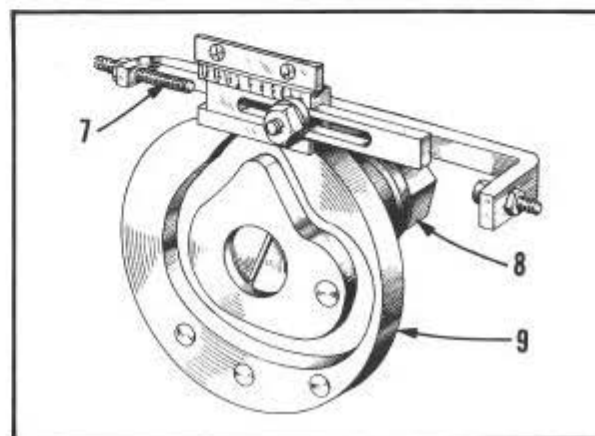
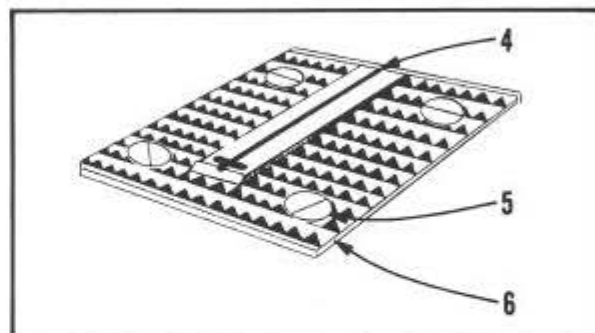
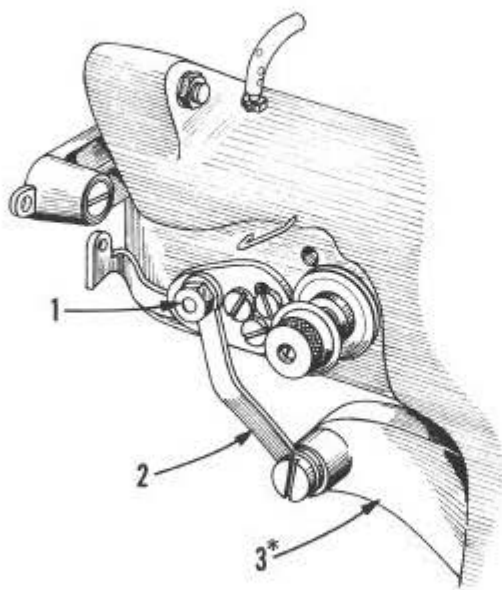




DET.	PART NUMBER	DESCRIPTION
1	20-0240-0-055	Adjustable Slide
2	01-1047	Screw
3	01-5112	Spring
4	01-2700	Screw
5	20-0318-0-001	Anvil
6	20-0309-1-100	Stop Bolt (includes detail 7)
7	01-6196	Pin
8	20-0317-0-904	Stop Bolt Holder
9	01-8002-0-001	Key
10	20-0039-0-001	Actuator

MODEL S2-TRB — 1½" TWO ROW TACKER BACK STARTING POSITION

29

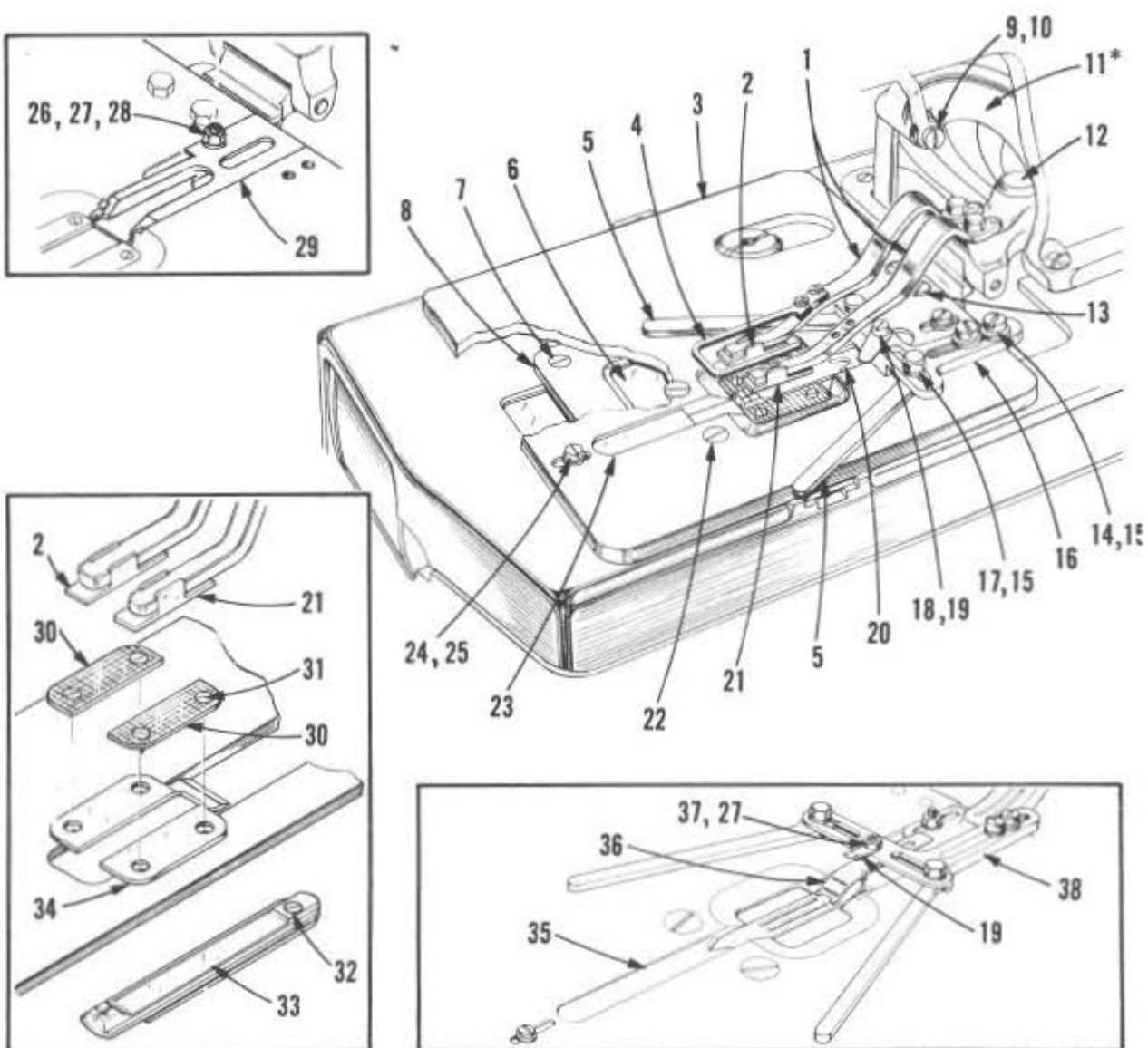


Note: Clamp Arms and Feet are shown on pages 12, 13 and 39.

DET.	PART NUMBER	DESCRIPTION
1	01-1065-1	Stud
	01-3426	Nut
2	20-0608-0-015	Link
3	20-0357-0-007*	Lever Asm.
4	20-0051-0-015	Throat Plate
5	01-2376	Screw
6	20-0208-1-215	Mat: course corrugations
	20-0208-1-315	Mat: fine corrugations
	20-0208-1-415	Mat: smooth surface
7	01-2352	Screw
8	20-0281-0-004	Bearing Stud
9	20-0276-1-004	Feed Reversing Cam
10	20-0166-0-015	Shifter
11	20-0240-0-015	Adjustable Slide
12	20-0647	Trip
13	01-6135	Anchor

* Assembly, refer to Parts Index for assembly components.

30 MODEL S2-SRCS — SINGLE ROW COLLAR STAY TACKER

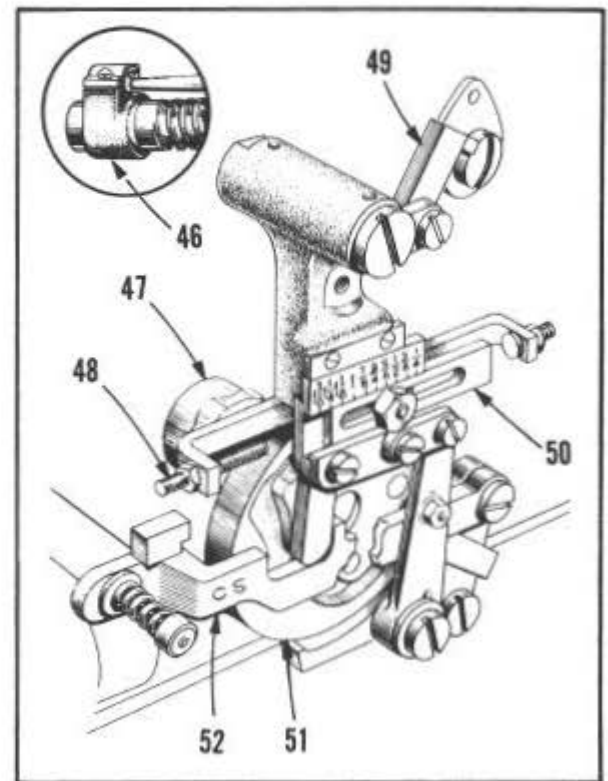
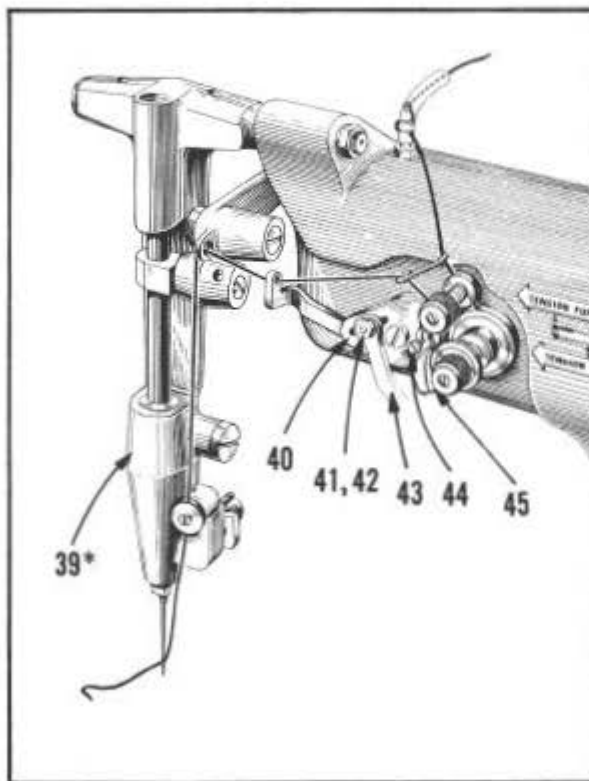


DET.	PART NUMBER	DESCRIPTION
1	20-0194-0-052	Clamp Arm
2	20-0194	Clamp Arm
3	20-6064	Clamp Foot, left
4	20-0196-0-502**	Clamp Foot
5	20-6024	Plate
6	20-0707-0-502**	Plate (manual)
7	20-0767-0-020	Needle Guard,
	20-0767-0-023	Needle Guard for
		1/2" high arm.
8	20-0711	Slide Gauge
9	20-0210-0-002	Clamp Plate
10	01-2395	Screw
11	20-0214-0-002	Cover Plate
12	20-0214-0-502**	Cover Plate
13	01-2027	Screw
14	01-7480-0-001	Bushing
15	20-0357-0-007*	Cutting Lever Asm.
16	20-0190-1-011	Clamp Tail Piece
17	01-2600	Screw
18	01-2175	Screw
19	01-4011	Washer
20	20-0710	Rear Gauge (manual)
21	20-0710-0-502**	Rear Gauge (manual)
22	01-2508	Screw
23	01-2136	Screw (manual)
24	10-2054	Clip
25		

*Furnished only as an Assembly. Refer to Parts Index for assembly components.

**Used on 1/2" wide, 3" to 5" Collar Stay Models.

MODEL S2-SRCS — SINGLE ROW COLLAR STAY TACKER 31



20	20-0708	Rear Stop
	20-0708-0-501**	Rear Stop, short (manual)
	20-0708-0-502**	Rear Stop, long (manual)
21	20-6063	Clamp Foot, right
	20-0196-0-502**	Clamp Foot
22	01-2589	Screw
23	20-0709-1	Front Stop
	20-0709-0-502**	Front Stop (manual)
24	01-2137	Screw
25	01-4420	Washer
26	01-2361	Screw
27	01-3025	Nut
28	01-4527	Nylon Washer
29	20-6096	Adaptor (manual)
30	20-6062	Mat
	20-0208-0-501**	Mat, right
	20-0208-0-502**	Mat, left
31	01-2642	Screw
32	01-2104	Screw
33	20-0051-1-002	Throat Plate
34	20-6037-1	Mat Plate
35	20-6025	Front Stop (automatic)
36	20-6065	Upper Stay Guide (automatic)

37	01-2103	Screw (automatic)
38	20-6066	Rear Gauge (automatic)
39	20-0005-0-102*	Needle Bar Rocker
40	20-0607-2	Adjustable Plate
41		Stud
42	01-3426	Nut
43	20-0608-1-002	Link
44	01-2131	Screw - no washer
45	20-0713	Tension Release
46	20-0166-0-015	Shifter
47	20-0704-0-002	Barring Cam
48	01-2352	Screw
49	20-0013-0-002	Latch
50	20-0240-0-050	Adjustable Slide, 3/4"
	20-0240-1**	Adjustable Slide
51	20-0276-0-002	Feed Reversing Cam
52	20-0288-0-002	Shifter Lever

*Furnished only as an Assembly. Refer to Parts Index for assembly components.

**Used on 1/2" wide, 3" to 5" Collar Stay Models.

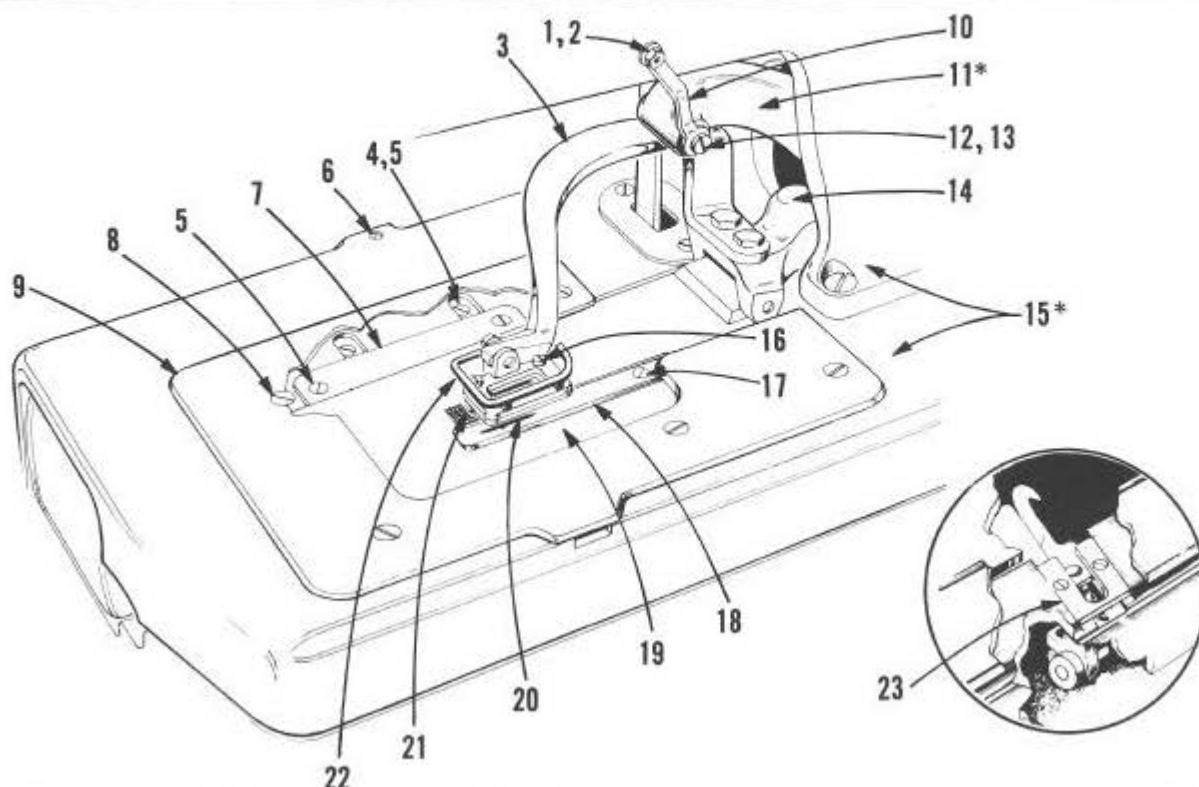
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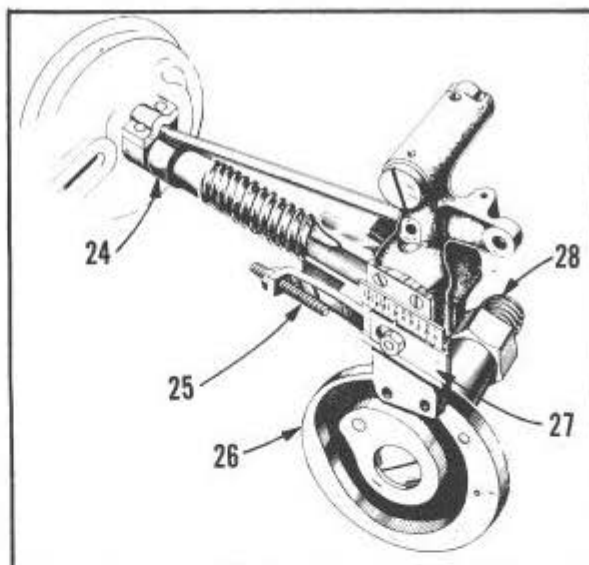
3-31

32

MODEL S2-TRPB — TWO ROW TAB TACKER FOR BOUND BUTTONHOLE TACKING



DET.	PART NUMBER	DESCRIPTION
1		Stud
2	01-3426	Nut
3	20-0649-0-042	Clamp Arm
4	20-0654	Stop
5	01-2396	Screw
6	01-2379	Screw
7	20-0653-0-007	Guide
8	01-2395	Screw
9	20-0214-1-007	Cover Plate
10	20-0608-1-002	Link
11	20-0357-0-007*	Cutting Lever Asm.
12	01-2027	Screw
13	01-7480-0-001	Bushing
14	20-0190-1-011	Clamp Tail Piece
15	20-0397-0-013*	Head & Bedplate Asm.
16	01-2318	Screw
17	01-2104	Screw
18	20-0051-1-007	Throat Plate
19	20-0210-1-007	Clamp Plate
20	20-0650-0-242	Tacker Clamp Foot
21	20-0667-0-993	Pad, left .09 (for thin material)
	20-0667-0-995	Pad, right .09 (for thin material)
	20-0667-0-994	Pad, left .075 (for heavy material)



	20-0667-0-996	Pad, right .075 (for heavy material)
22	20-0767-1-020	Needle Guard
23	20-0655-0-042	Cover Plate
24	20-0166-0-015	Shifter
25	01-2352	Screw
26	20-0276-1-017	Feed Reversing Cam
27	20-0240-0-050	Adjustable Slide
28	20-0281-0-004	Bearing Stud

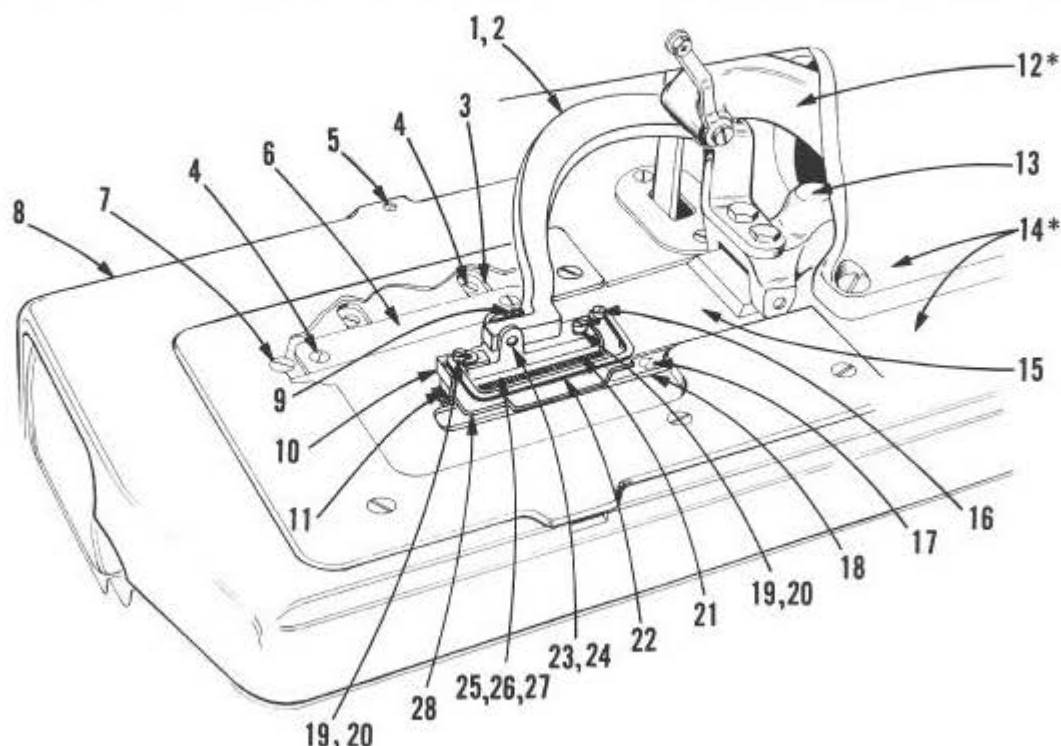
* Assembly, refer to Parts Index for assembly components.

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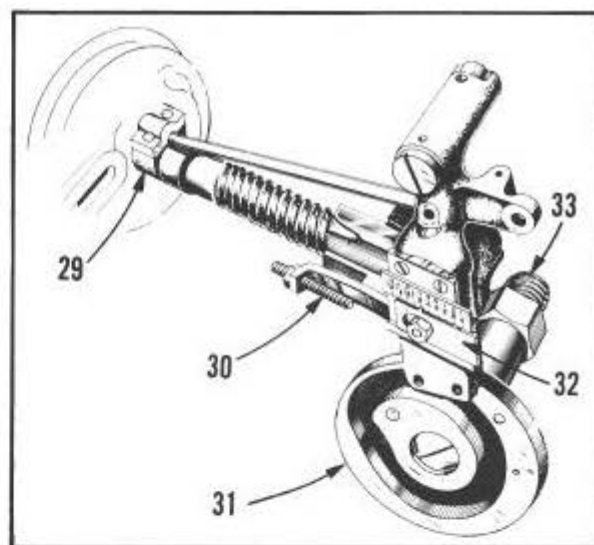
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MODEL S2-PW — TWO ROW TAB TACKER FOR POCKET WELT TACKING

33



DET.	PART NUMBER	DESCRIPTION
1	20-0649-0-041	Clamp Arm - 1" and 1 1/4" tack.
2	20-0649-0-042	Clamp Arm - for 3/4" tack
3	20-0654	Stop
4	01-2396	Screw
5	01-2379	Screw
6	20-0653-0-007	Guide
7	01-2395	Screw
8	20-0214-1-007	Cover Plate
9	01-5174	Spacer Spring
10	20-0650-0-311	Clamp Foot
11	20-0667-0-988	Clamp Pad, left
12	20-0357-0-007*	Cutting Lever Asm.
13	20-0190-1-011	Clamp Tail Piece
14	20-0397-0-013*	Head & Bedplate Asm.
15	20-0210-0-008	Clamp Plate
16	01-2053	Screw
17	01-2104	Screw
18	20-0051-1-007	Throat Plate
19	01-2688	Screw
20	01-4535	Washer
21	20-0667-0-989	Clamp Pad, right
22	20-0767-0-021	Needle Guard
23	01-1125	Screw
24	01-3065	Nut
25	20-0748-0-155	Rubber, Pad, 3/4"
26	20-0748-0-157	Rubber Pad, 1"



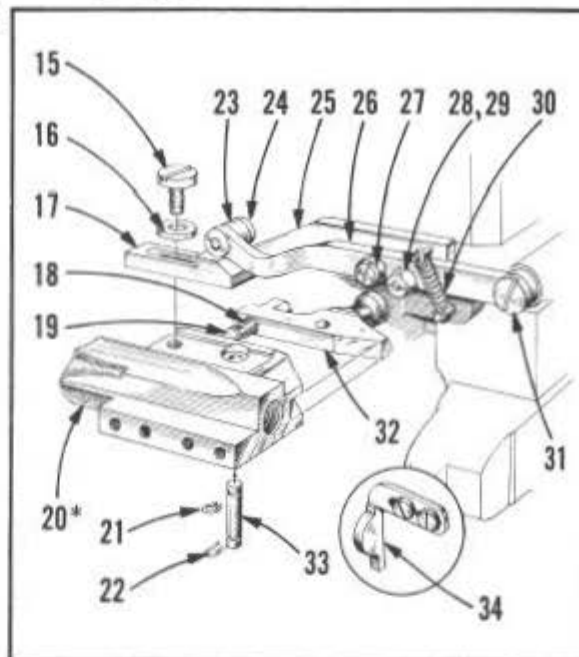
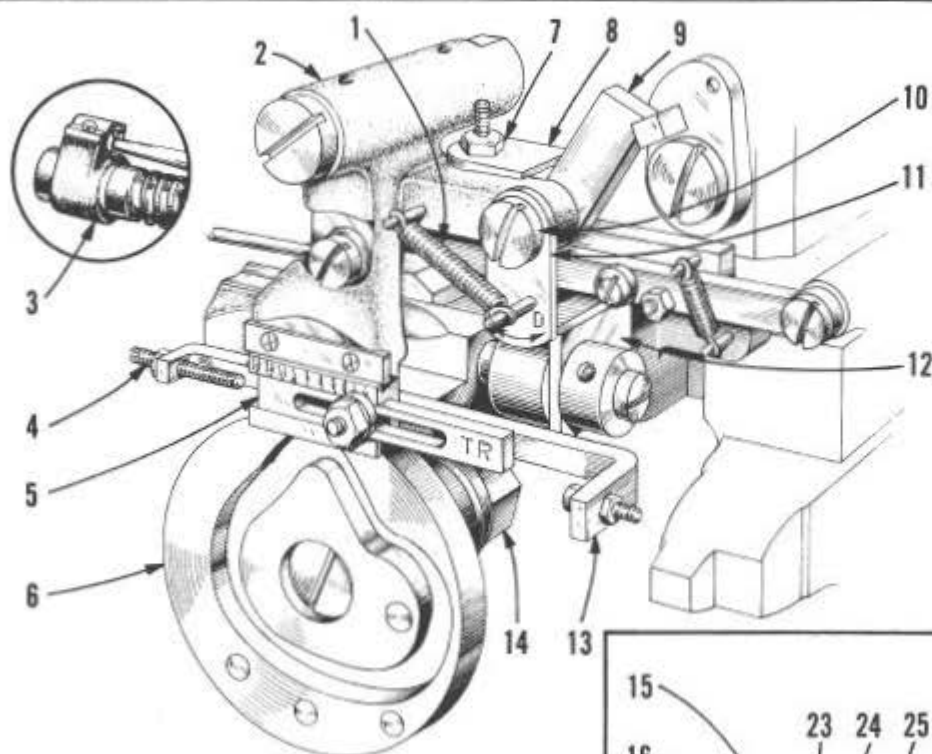
27	20-0748-0-159	Rubber Pad, 1-1/4"
28	01-5485	Clamp Spring
29	20-0166-0-015	Shifter
30	01-2352	Screw
31	20-0276-3-801	Feed Reversing Cam
32	20-0240-0-015	Adjustable Slide
33	20-0281-0-004	Bearing Stud

*Assembly, refer to Parts Index for assembly components.

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3-33

34 MODEL S2-TK2F — 2" COMBINATION SINGLE & TWO ROW FRONT STARTING TACKER



DET.	PART NUMBER	DESCRIPTION
1	01-5429	Spring
2	20-0243-2	Rocker Lever
3	20-0166-0-015	Shifter
4	01-2044	Screw
5	20-0240-0-032	Adjustable Slide
6	20-0276-1-004	Feed Reversing Cam
7	20-0683	Stop
8	01-4067	Washer
9	20-0013-0-006	Latch
10	01-1425	Screw
11	20-0682	Shifter
12	20-0702	Stop
13	20-0180-0-032	Bracket
14	20-0281-0-004	Bearing Stud
15	01-2021	Screw
16	01-4011	Washer
17	20-0701	Wedge
18	01-5020	Spring
19	01-6511	Plunger Pin
20	20-0133-1-105*	Feed Screw and Feed Block
21	01-6406	Retainer Ring
22	01-6121	Cotter
23	01-7453	Roll
24	01-1437	Screw
25	20-0700	Latch

26	20-0699	Lever (includes details 23 and 24)
27	01-1002	Screw
28	01-3016	Nut
29	01-1438	Eccentric
30	01-5042	Spring
31	01-1097	Screw
32	20-0174-0-032	Guide Block
33	01-6508	Pivot Pin
34	20-0230-0-032	Adjustable Bumper

* Assembly, refer to Parts Index for assembly components.

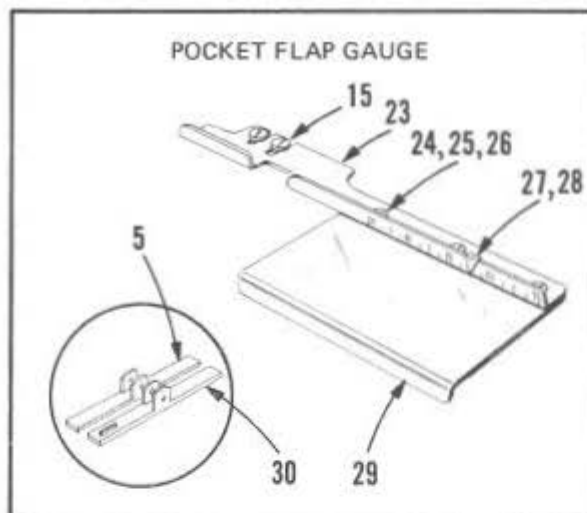
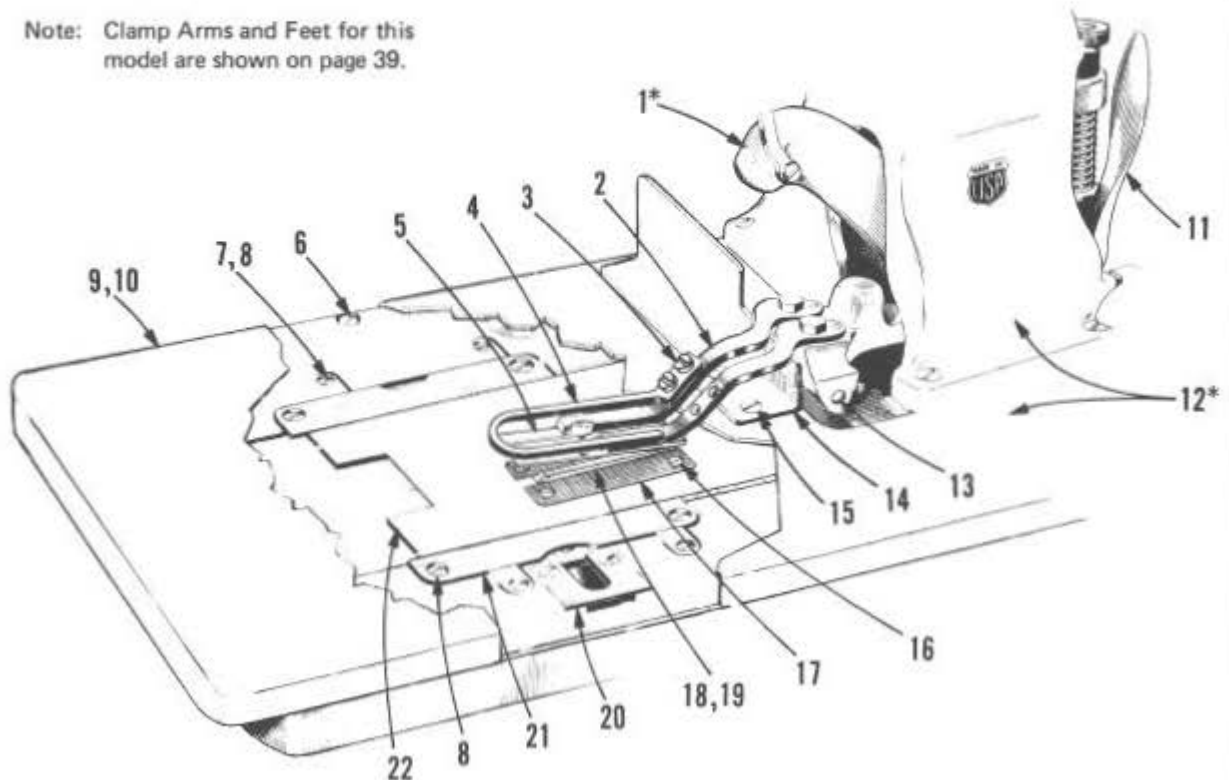
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MODEL S2-TK2F — 2" COMBINATION SINGLE & TWO ROW FRONT STARTING TACKER

35

Note: Clamp Arms and Feet for this model are shown on page 39.



DET.	PART NUMBER	DESCRIPTION
1	20-0357-0-007*	Cutting Lever Asm.
2	20-0194-1-032	Clamp Arm
3	01-2013	Screw
4	20-0767-0-027	Needle Guard
5	20-0196-0-032	Clamp Foot
6	01-2379	Screw

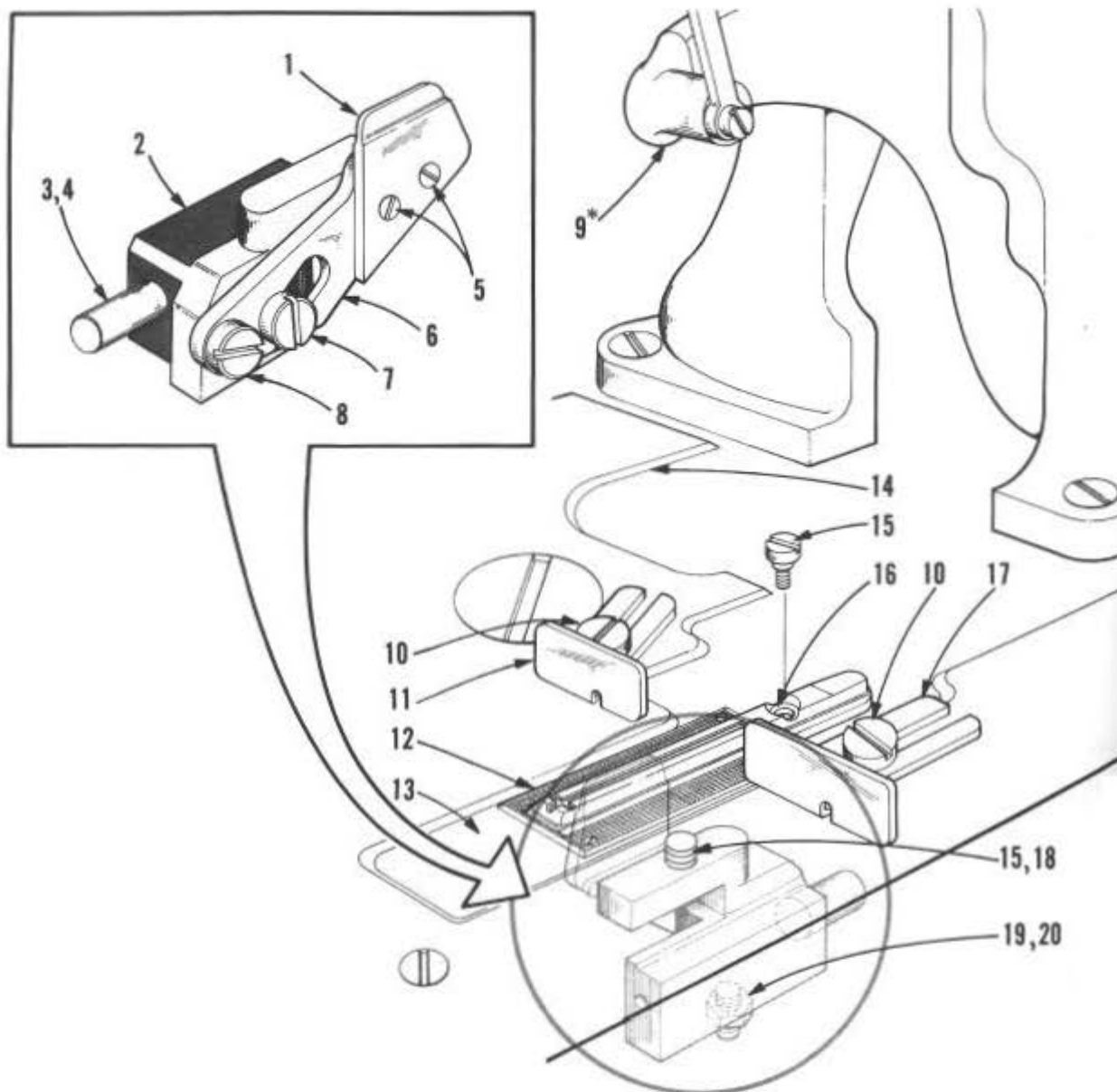
7	20-0654	Stop
8	01-2131	Screw
9	20-0652-2	Cover
10	20-6272	Shim
11	20-0332-2	Unclamping Handle
12	20-0397-0-012*	Head & Bedplate Asm.
13	20-0190-0-032	Clamp Tailpiece
14	20-0658	Guard
15	01-2377	Screw
16	01-2376	Screw
17	20-0208-0-232	Mat (coarse corrugation)
	20-0208-0-332	Mat (fine corrugation)
18	20-0051-2-004	Throat Plate
19	01-2104	Screw
20	20-0655-0-041	Cover Plate
21	20-0653	Guide
22	20-0210-1-004	Clamp Plate
23	20-0693	Gauge
24	01-2312	Screw
25	01-3001	Nut
26	01-4067	Washer
27	20-0695	Pointer
28	01-2081	Screw
29	20-0694	Plate
30	20-0196-0-033	Clamp Foot, right

*Furnished only as an assembly. Refer to Parts Index for assembly components.

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3-35

36
MODEL S2-FST — FLAT SEAM TACKER


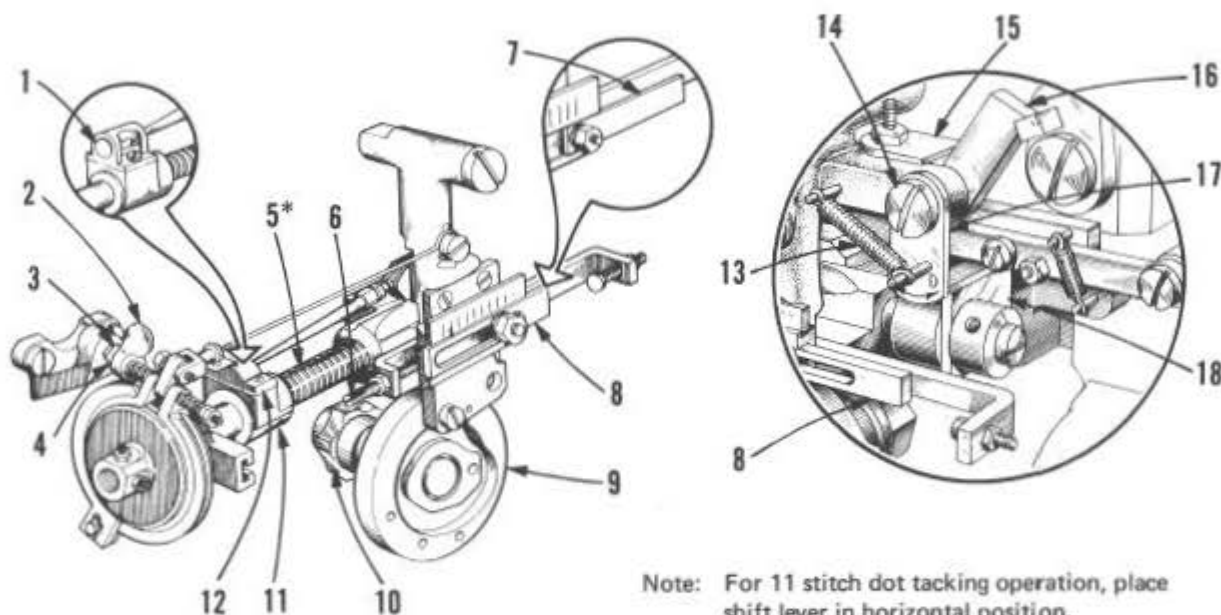
DET.	PART NUMBER	DESCRIPTION
1	20-0759	Position Plate
2	20-0756	Housing
3	20-0757	Plunger
4	01-5057	Spring
5	01-2015	Screw
6	20-0758	Link
7	01-1464	Screw
8	01-1051	Screw
9	20-0357-0-007*	Cutting Lever Asm.
10	01-2157	Screw

11	20-0761	Cloth Guide
12	20-0208-1-324	Mat
13	20-0210-0-078	Clamp Plate
14	20-0652-1-078	Cover
15	01-2084	Screw
16	20-0051-0-078	Throat Plate
17	20-0760-1	Cloth Gauge
18	01-4029	Washer
19	01-2304	Screw
20	01-3021	Nut

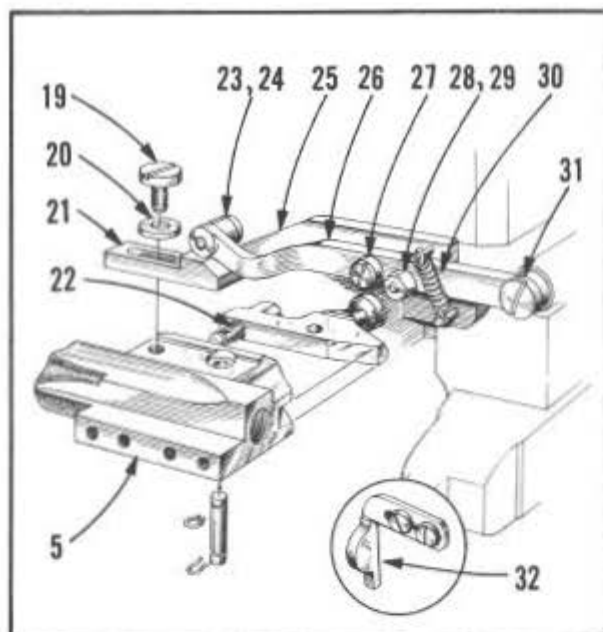
* Assembly, refer to Parts Index for assembly components.

MODEL S2-FST — FLAT SEAM TACKER

37



Note: For 11 stitch dot tacking operation, place shift lever in horizontal position.



DET.	PART NUMBER	DESCRIPTION
1	20-0169-0-016	Bearing Cap (for Dot Tack)
2	20-0697	Shift Lever (See Note)
3	01-3068	Nut
4	01-3432	Nut
5	20-0133-0-116*	Feed Screw and Feed Block
6	01-2352	Screw

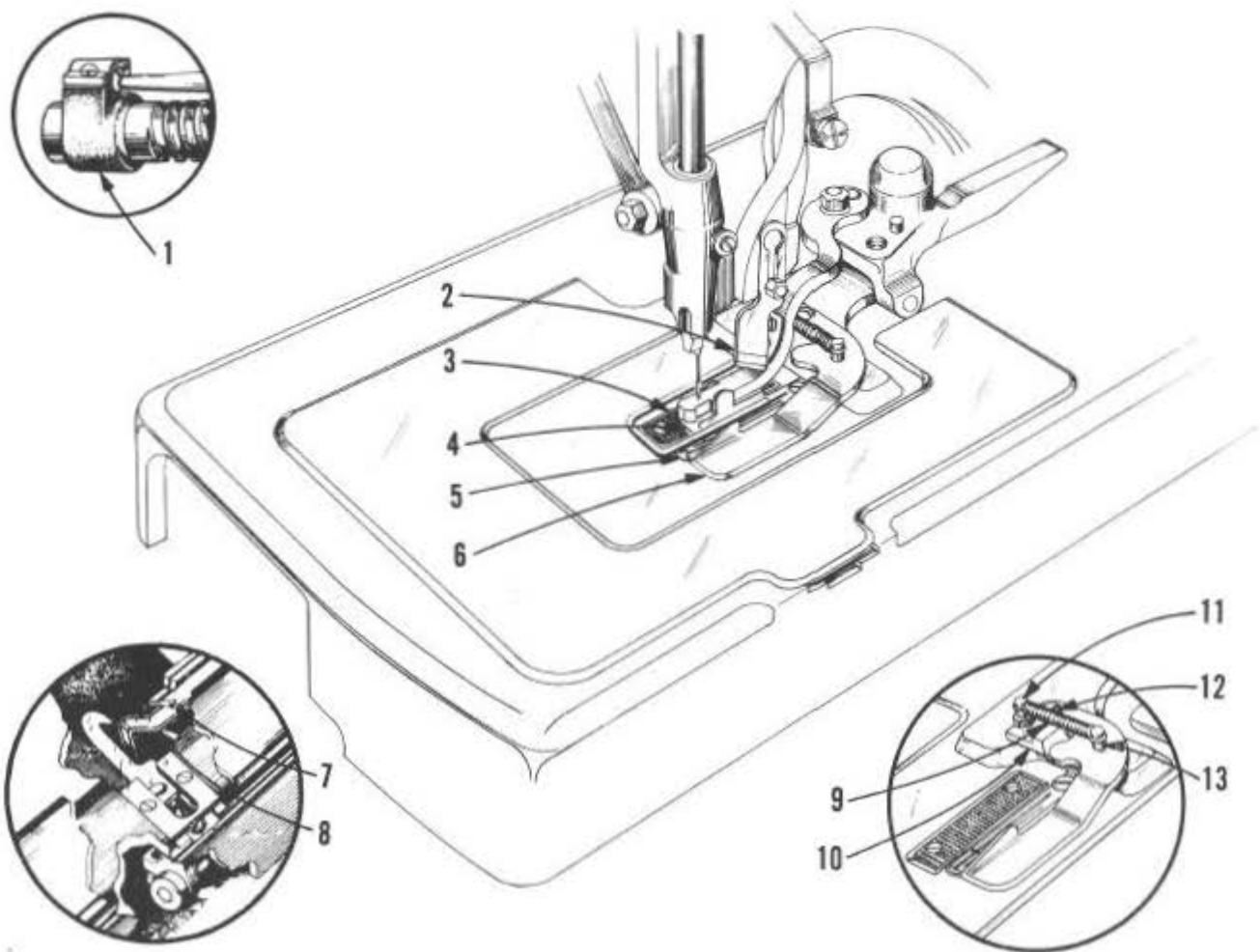
7	20-0240-0-016	Stop (for Dot Tack)
8	20-0240-0-015	Adjustable Slide
9	20-0276-0-013	Feed Reversing Cam
10	20-0704	Combination Barring Cam and Worm Gear
11	20-0166-0-015	Shifter
12	20-0169	Bearing Cap
13	01-5429	Spring
14	01-1425	Screw
15	20-0683	Stop
16	20-0013-0-006	Latch
17	20-0682	Shifter
18	20-0702	Stop
19	01-2021	Screw
20	01-4011	Washer
21	20-0701	Wedge
22	01-5020	Spring
23	01-7453	Roll
24	01-1437	Screw
25	20-0700	Latch
26	20-0699	Lever (includes details 23 and 24)
27	01-1002	Screw
28	01-1438	Eccentric
29	01-3016	Nut
30	01-5042	Spring
31	01-1097	Screw
32	20-0230-0-032	Adjustable Bumper

*Assembly, refer to Parts Index for assembly components.

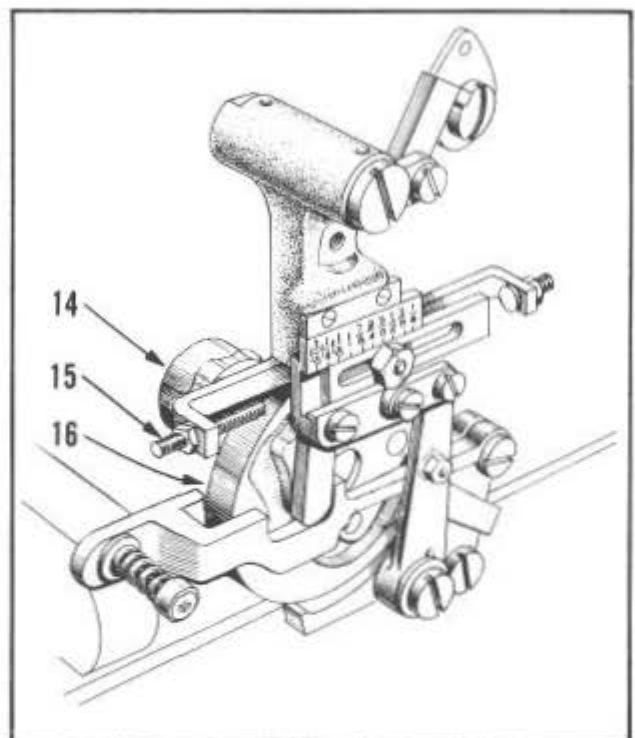
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3-37

38**MODEL S2-OST – OVER SEAM TACKER**

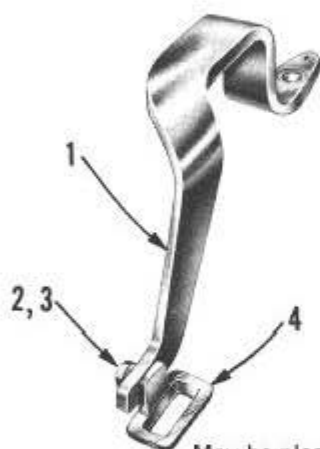
DET.	PART NUMBER	DESCRIPTION
1	20-0166-0-015	Shifter
2	20-0356-1-052	Knife
3	20-0208-0-071	Mat
4	20-0196-0-336	Clamp Foot
5	20-0051-1-303	Throat Plate
6	20-0734	Cloth Gauge
7	01-2004	Screw
8	20-0767-0-020	Needle Guard
9	01-5048	Spring
10	10-2002	Stop
11	01-2643	Anchor Screw
12	01-1112	Shoulder Screw
13	01-6603	Anchor Pin
14	20-0278-1-073	Barring Cam
15	01-2044	Adjusting Screw
16	20-0276-3-801	Feed Reversing Cam



TACKER CLAMPS

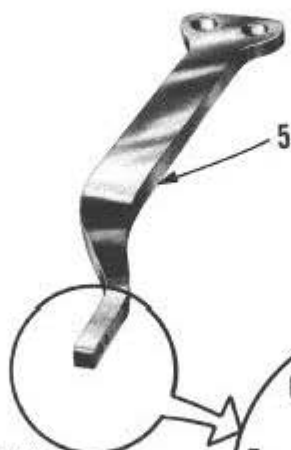
39

SPECIAL SHORT CLAMPS FOR 1½" TACKER MODELS

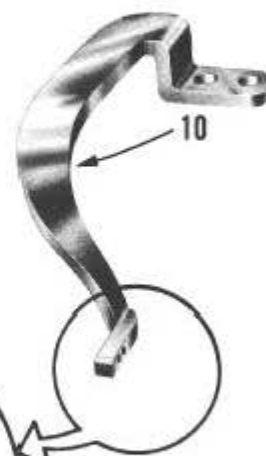


May be placed on
either side of clamp arm.

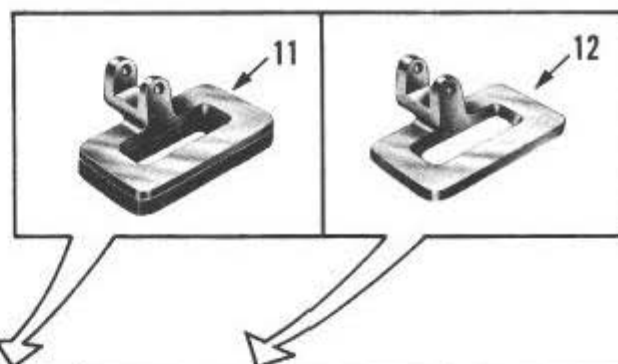
LOW CLAMP ARM ASSEMBLY FOR 1½" TACKER MODELS



HIGH CLAMP ARM ASM. FOR 1½" AND 2" TACKER MODELS



DET.	PART NUMBER	DESCRIPTION
1	—	Clamp Arm, see chart
2	01-3413	Nut
3	01-4003	Lock Washer
4	—	Clamp Foot, see chart
5	—	Clamp Arm, see chart
6	01-5174	Spring
7	01-1125	Screw
8	01-3065	Nut
9	—	Needle Guard, see chart
10	—	Clamp Arm, see chart
11	—	Clamp Foot, see chart
12	—	Clamp Foot, see chart



DET.	TACKER MODEL	MAX TACK	CLAMP ARM	CLAMP FOOT CORRUGATED	CLAMP FOOT RUBBER SOLED	RUBBER SOLE REPLACEMENT	GUARD
5	Low Clamps for 1-1/2" Tackers	3/8"	20-0649-1-000	20-0650-1-240	20-0650-0-241	20-0651-0-241	20-0767-1-002
		3/4"	20-0649-1-000	20-0650-0-340	20-0650-0-341	20-0651-0-341	20-0767-1-003
10	High Clamps for 1-1/2" Tackers	3/8"	20-0649-1-042	20-0650-1-240	20-0650-0-241	20-0651-0-241	20-0767-1-002
		3/4"	20-0649-1-042	20-0650-1-340	20-0650-0-341	20-0651-0-341	20-0767-1-003
		1-1/2"	20-0649-1-041	20-0650-0-640	20-0650-0-641	20-0651-0-641	20-0767-1-022
	High Clamps for 2" Tackers	3/8"	20-0649-1-045	20-0650-1-240	20-0650-0-241	20-0651-0-241	20-0767-1-002
		3/4"	20-0649-1-045	20-0650-1-340	20-0650-0-341	20-0651-0-341	20-0767-1-003
		1-1/2"	20-0649-1-046	20-0650-0-640	20-0650-0-641	20-0651-0-641	20-0767-1-022
		2"	20-0649-1-046	20-0650-0-740	none	none	20-0767-1-026
	S2-SD	2"	20-0649-1-047	20-0650-0-740	none	none	20-0767-1-025
1	Spec. short clamps for 1-1/2" Tackers	3/8"	20-0649-0-243	20-0650-0-243	none	none	20-0767-0-039
		3/4"	20-0649-0-343	20-0650-0-343	none	none	20-0767-0-040

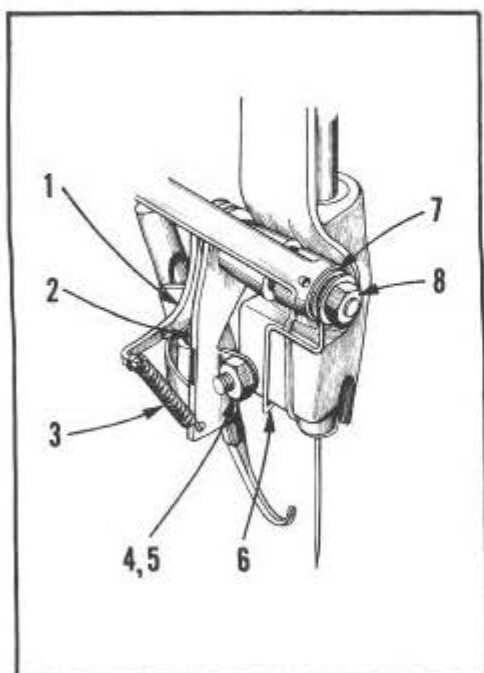
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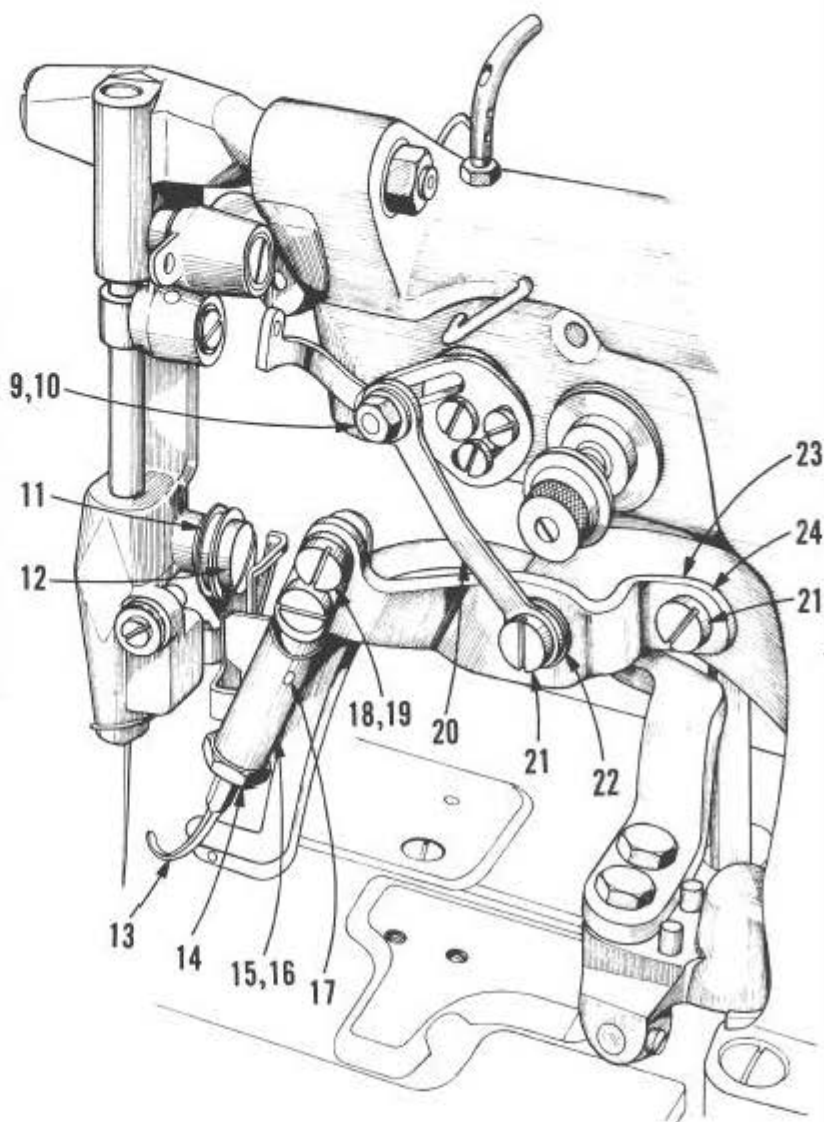
3-39

40

TACKER THREAD PICK-UP

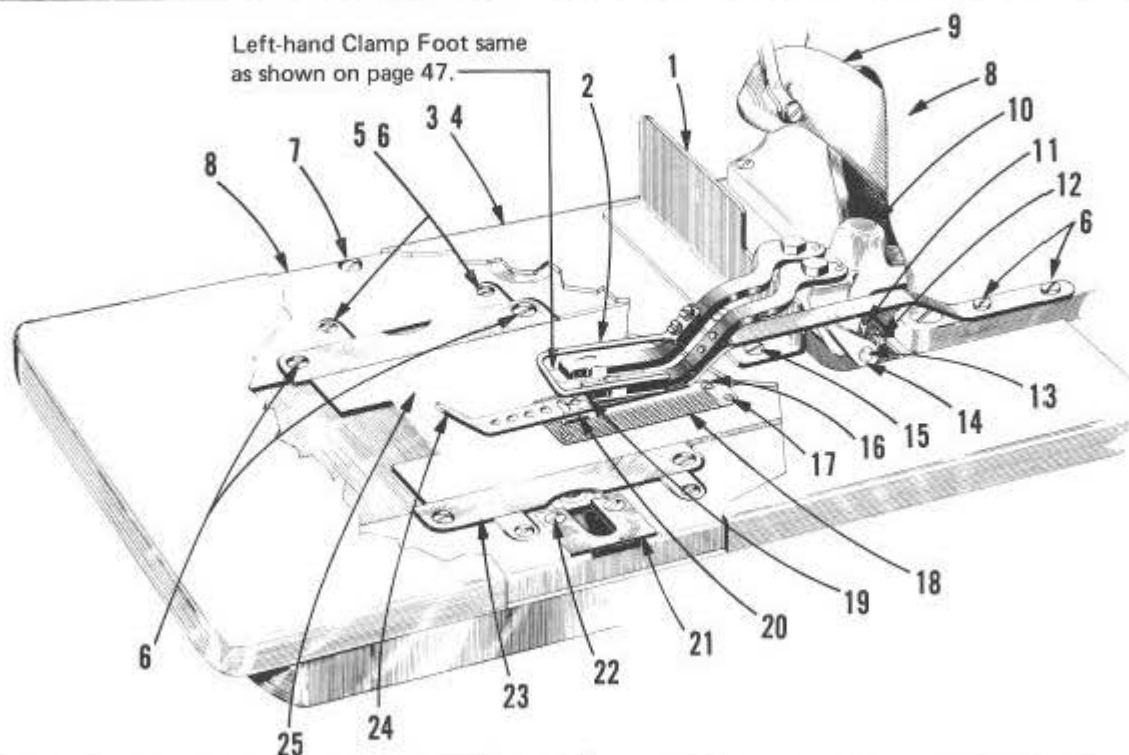


Note: To receive Mechanical Thread Pickup complete use;
20-0766-0-000

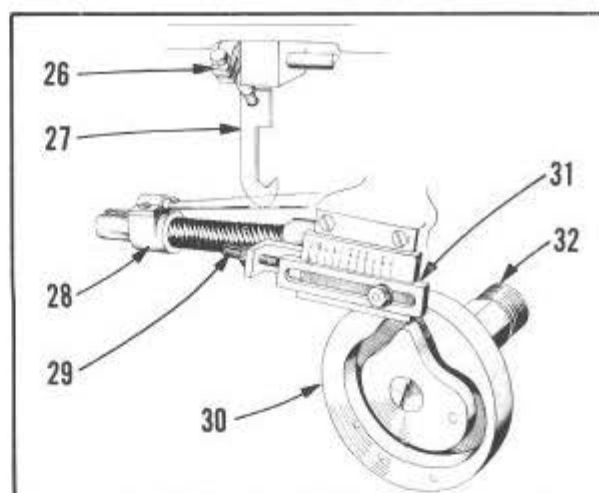


DET.	PART NUMBER	DESCRIPTION
1	20-0753	Latch
2	20-0754	Stop
3	01-5431	Spring
4	01-2333	Screw
5	01-3025	Nut
6	20-0755	Thread Guide
7	01-4013	Washer
8	01-3001	Nut
9	01-1065-1	Screw
10	01-3426	Nut
11	01-7481	Bushing
12	01-1463	Screw
13	20-0751	Hook

14	20-0752	Bushing
15	20-0750	Holder
16	01-5489	Spring
17	01-6631	Pin
18	01-2041	Screw
19	01-4402	Washer
20	20-0608-0-015	Link
21	01-2027-0-001	Screw
22	01-7480	Bushing
23	01-4002	Washer (not always used)
24	20-0749	Bracket

MODEL S2-SRLS — MODEL S2-TRLS
41


DET.	PART NUMBER	DESCRIPTION
1	20-0658	Guard
2	20-0767-0-020	Needle Guard
3	20-0652-2	Cover
4	20-6272	Shim
5	20-0654	Stop
6	01-2131	Screw
7	01-2379	Screw
8	20-0397-0-012*	Head & Bedplate Asm.
9	20-0357-0-007*	Cutting Lever Asm.
10	20-0190-1-011	Tailpiece
11	01-2019	Screw
12	01-2378	Screw
13	01-6338	Pivot Pin
14	20-0656	Level
15	01-2377	Screw
16	01-2104	Screw
17	01-2376	Screw
18	20-0208-1-204	Mat (coarse)
	20-0208-1-304	Mat (fine)
19	20-0196-0-604	Right Clamp Foot (short, coarse)
	20-0196-0-504	Right Clamp Foot (long, coarse)
20	20-0051-2-004	Throat Plate
21	20-0655-0-041	Cover Plate
22	01-2075	Screw
23	20-0653	Guide



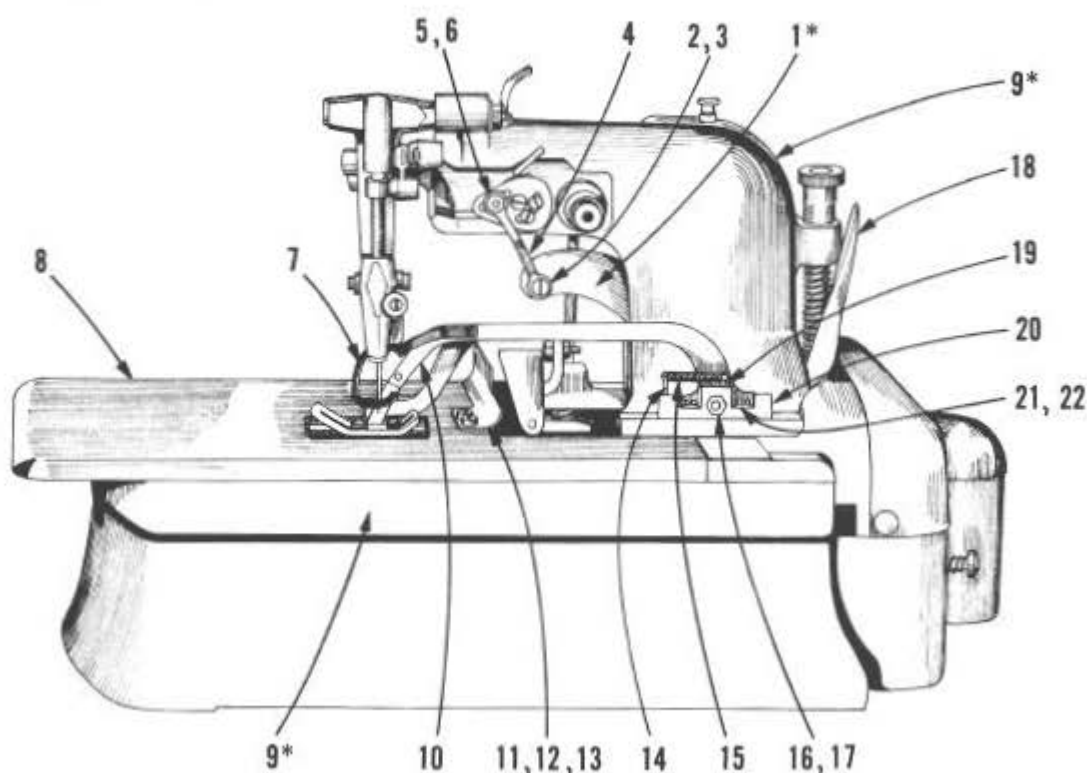
24	20-0648-2	Hold-down Member
	20-0648-0-998	Hold-down (offset)
	20-0648-0-997	Hold-down (short, offset)
25	20-0210-1-004	Clamp Plate
26	20-0092-0-004	Trimmer Actuator
27	20-0093-0-004	Trimmer Hook
28	20-0166-0-015	Shifter
29	01-2352	Screw
30	20-0276-1-004	Feed Reversing Cam (single row L.S.)
	20-0276-1-017	Feed Reversing Cam (two row L.S.)
31	20-0240-0-015	Adjustable Slide
32	20-0281-0-004	Bearing Stud

*Assembly, refer to Parts Index for assembly components.

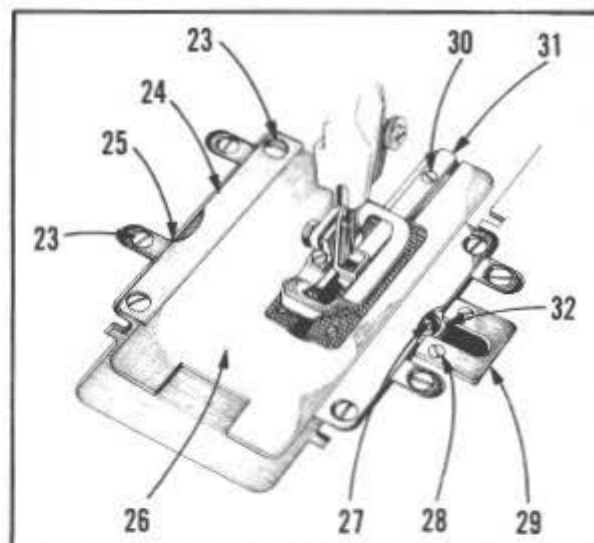
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3-41

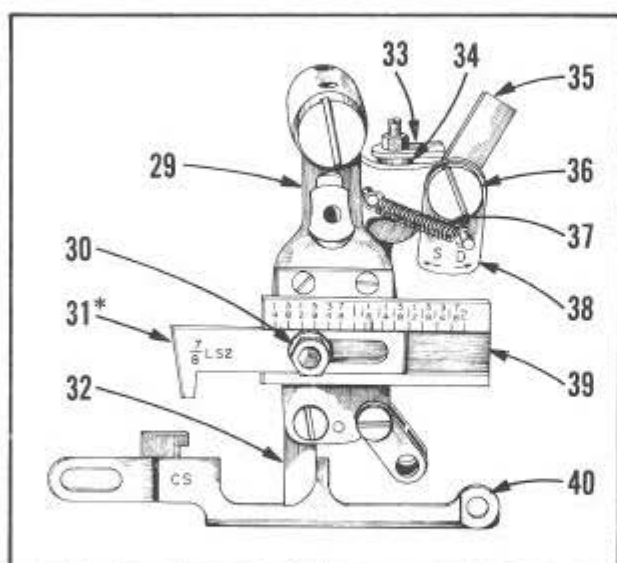
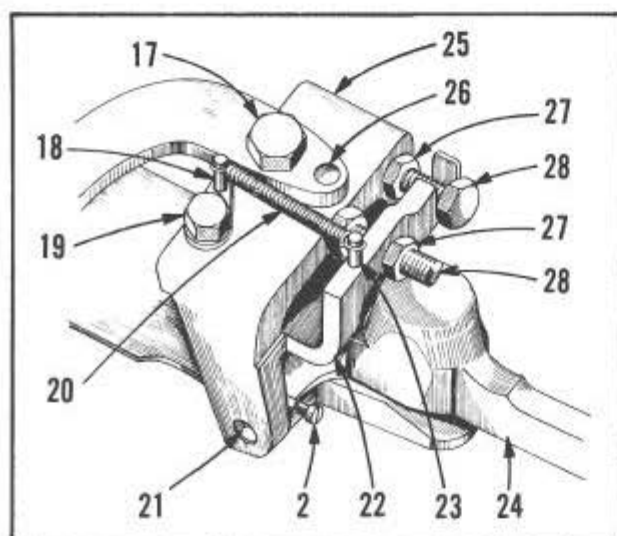
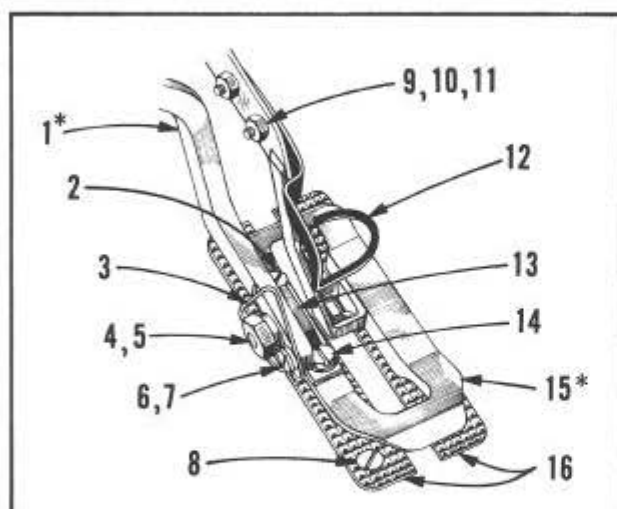
42
**MODEL S2-LS2N — 2" LABEL SEWER
SINGLE & TWO ROW SEWING**


DET.	PART NUMBER	DESCRIPTION
1	20-0357-0-007*	Cutting Lever Asm.
2	01-2027-0-001	Screw
3	01-7480	Bushing
4	20-0608-0-015	Link
5	01-1065-1	Screw
6	01-3426	Nut
7	20-0767-0-031	Needle Guard
8	20-0652-2	Cover
9	20-0397-0-012*	Head & Bedplate Asm.
10	20-0648-1-006	Hold-down Member
11	20-0658	Guard
12	01-2377	Screw
13	20-6272	Shim
14	01-6038	Anchor
15	01-5052	Spring
16	01-2527	Screw
17	01-3005	Nut
18	20-0332-2	Unclamping Handle
19	01-6513	Anchor
20	20-0681	Bracket
21	01-2045	Screw
22	01-4029	Washer
23	01-2131	Screw
24	20-0653	Guide
25	20-0654	Stop



26	20-0210-1-004	Clamp Plate
27	20-0092-0-004	Trimmer Actuator
28	01-2075	Screw
29	20-0655-0-041	Cover Plate
30	01-2104	Screw
31	20-0051-2-004	Throat Plate
32	20-0093-0-004	Trimmer Hook

* Assembly, refer to Parts Index for assembly components.

MODEL S2-LS2N – 2" LABEL SEWER
43


DET.	PART NUMBER	DESCRIPTION
1	20-0649-1-405*	Clamp Arm, 7/8"
	20-0649-1-605*	Clamp Arm, 1-1/2"
	20-0649-0-705*	Clamp Arm, 2"
2	01-2525	Screw
3	01-5445	Spring
4	01-3413	Nut
5	01-4003	Lock Washer
6	01-2136	Screw
7	01-4474	Washer
8	01-2376	Screw
9	01-2419	Screw
10	01-3414	Nut
11	01-4405	Washer
12	20-0767-0-031	Needle Guard
13	20-0680	Pivot Bracket
14	01-2563-1-406	Screw
15	20-0650-1-406*	Clamp Foot, 7/8"
	20-0650-1-606*	Clamp Foot, 1-1/2"
	20-0650-1-706*	Clamp Foot, 2"
16	20-0208-0-332	Mat (fine corrugation)
17	01-2355	Screw
18	20-0678	Spring Anchor
19	01-2124	Screw
20	01-5431	Spring
21	01-6507	Pivot Pin
22	20-0679-1	Bracket
23	01-6005	Anchor
24	20-0190-0-032	Tail Piece
25	20-0677	Clamp Arm Bracket
26	20-6055	Pin
27	01-3021	Nut
28	01-2526	Screw
29	20-0243-1-006	Rocker Level
30	01-1434	Stud
31	20-0240-0-405*	Adjustable Slide, 7/8"
	20-0240-0-605*	Adjustable Slide, 1-1/2"
	20-0240-0-705*	Adjustable Slide, 2"
32	20-0241-1-006	Shifter
33	20-0683	Stop
34	01-4067	Washer
35	20-0013-1-006	Latch
36	01-1425	Screw
37	01-5429	Spring
38	20-0682	Shifter
39	20-0236-0-005	Length Gauge (inches)
	20-0236-0-003	Length Gauge (mm)
40	20-0288-0-002	Shifter Lever

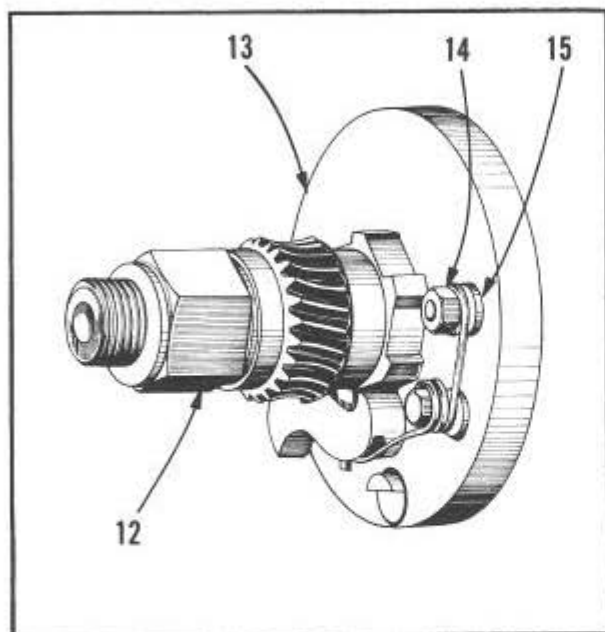
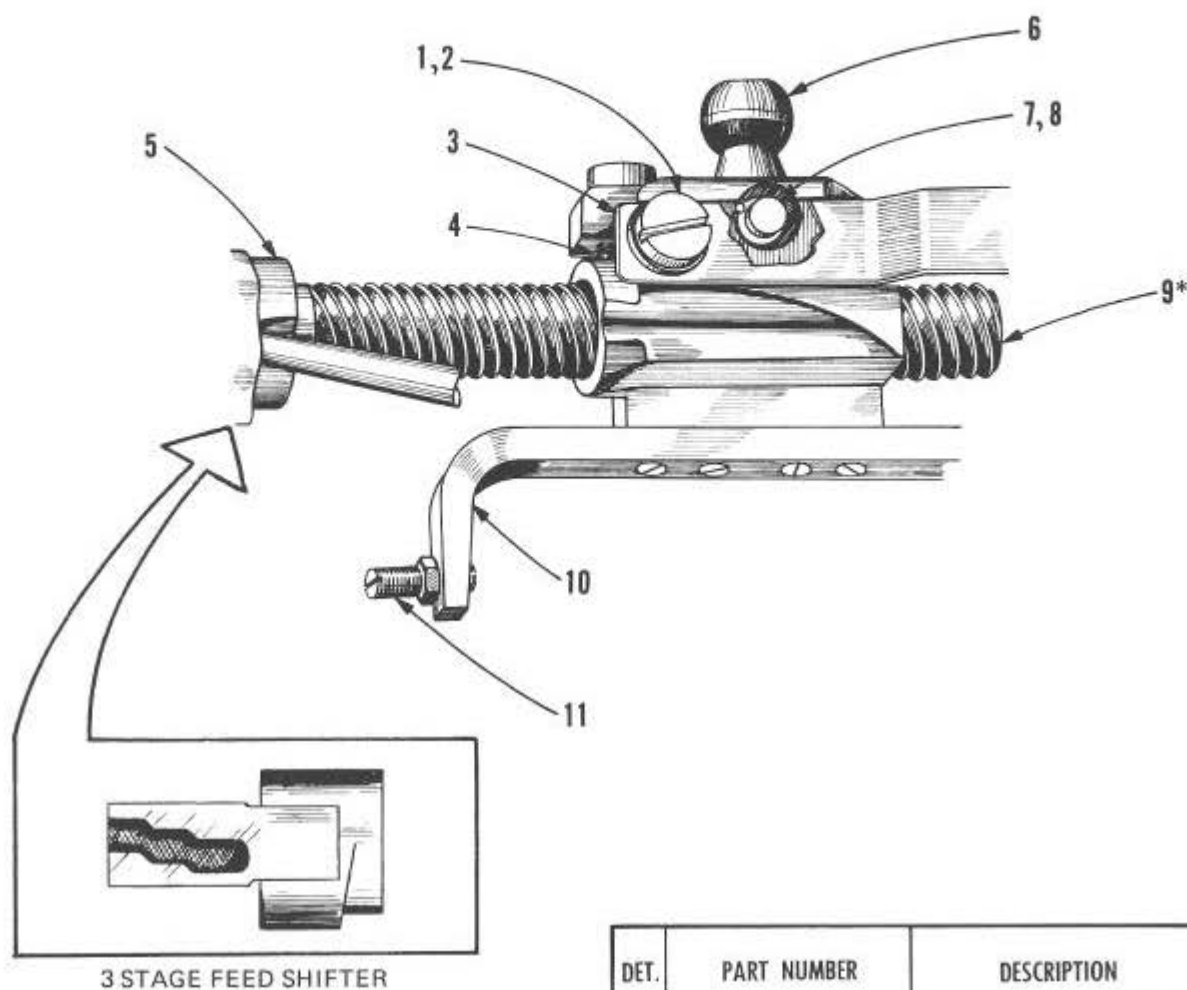
*These parts are not interchangeable.
Use only same sizes together.

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3-43

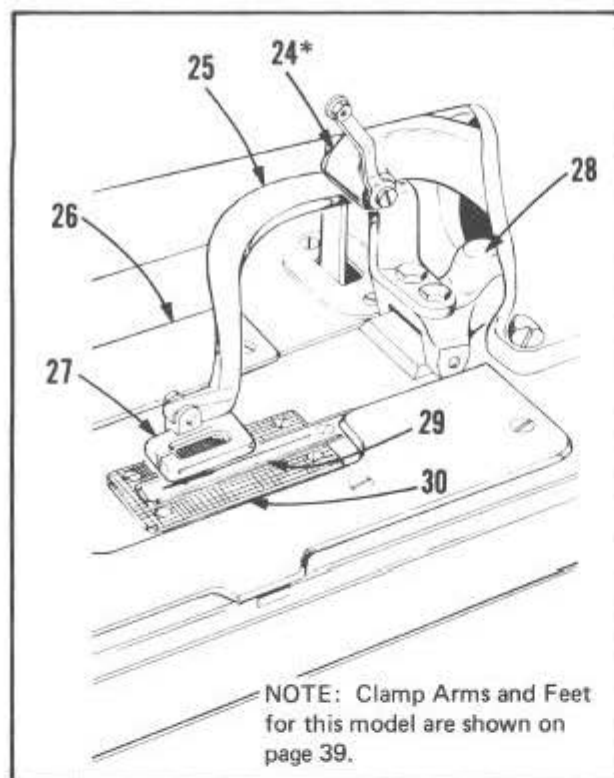
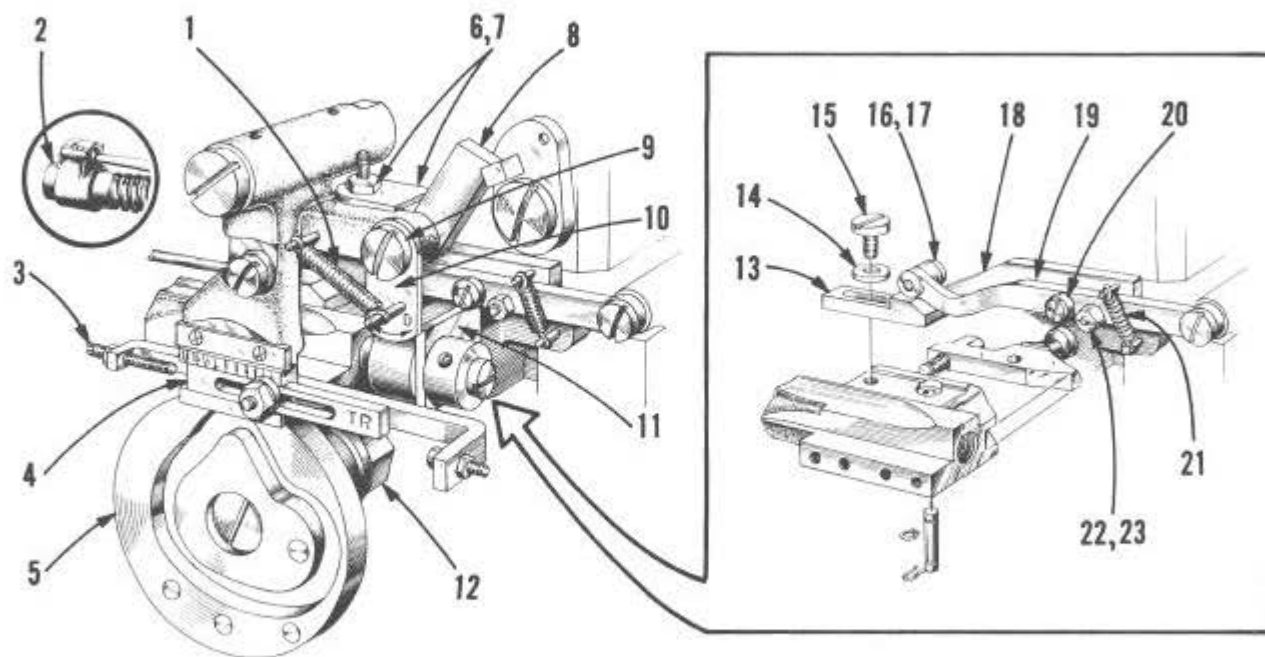
MODEL S2-LS2N — 2" LABEL SEWER **SINGLE & TWO ROW SEWING**



DET.	PART NUMBER	DESCRIPTION
1	01-2021	Screw
2	01-4059	Washer
3	01-5446	Flat Spring
4	01-6511	Plunge Pin
5	20-0166	Shifter
6	20-0174-0-032	Guide Block
7	01-6508	Pivot Pin
8	01-6406	Retaining Ring
9	20-0133-0-105*	Feed Screw and Feed Block
10	20-0180-1-005	Bracket
11	01-2122	Screw
12	20-0281-0-004	Bearing Stud
13	20-0276-2-004	Feed Reversing Cam
14	01-3016	Nut
15	01-4029	Washer

* Assembly refer to Parts Index for assembly components

MODEL S2-TKF-1-1/2" COMBINATION SINGLE AND TWO ROW-FRONT STARTING TACKER



DET	PART NUMBER	DESCRIPTION
1	01-5429	Spring
2	20-0166-0-015	Shifter
3	01-2352	Screw
4	20-0240-0-015	Adjustable Slide

5	20-0276-1-004	Feed Reversing Cam
6	20-0683	Stop
7	01-4067	Washer
8	20-0013-0-006	Latch
9	01-1425	Screw
10	20-0682	Shifter
11	20-0702	Stop
12	20-0281-0-004	Bearing Stud
13	20-0701	Wedge
14	01-4011	Washer
15	01-2021	Screw
16	01-7453	Roll
17	01-1437	Screw
18	20-0700	Latch
19	20-0699	Lever (includes details 16 and 17)
20	01-1002	Screw
21	01-5042	Spring
22	01-1438	Eccentric
23	01-3016	Nut
24	20-0357-0-007*	Cutting Lever Assembly
25	—	Clamp Arm (see page 39)
26	20-0214-0-015	Cover Plate
27	—	Clamp Foot (see page 39)
28	20-0190-1-011	Clamp Tail Piece
29	20-0051-0-015	Throat Plate
30	20-0208-1-215	Mat, coarse corrugation
	20-0208-1-315	Mat, fine corrugation
	20-0208-1-415	Mat, smooth surface

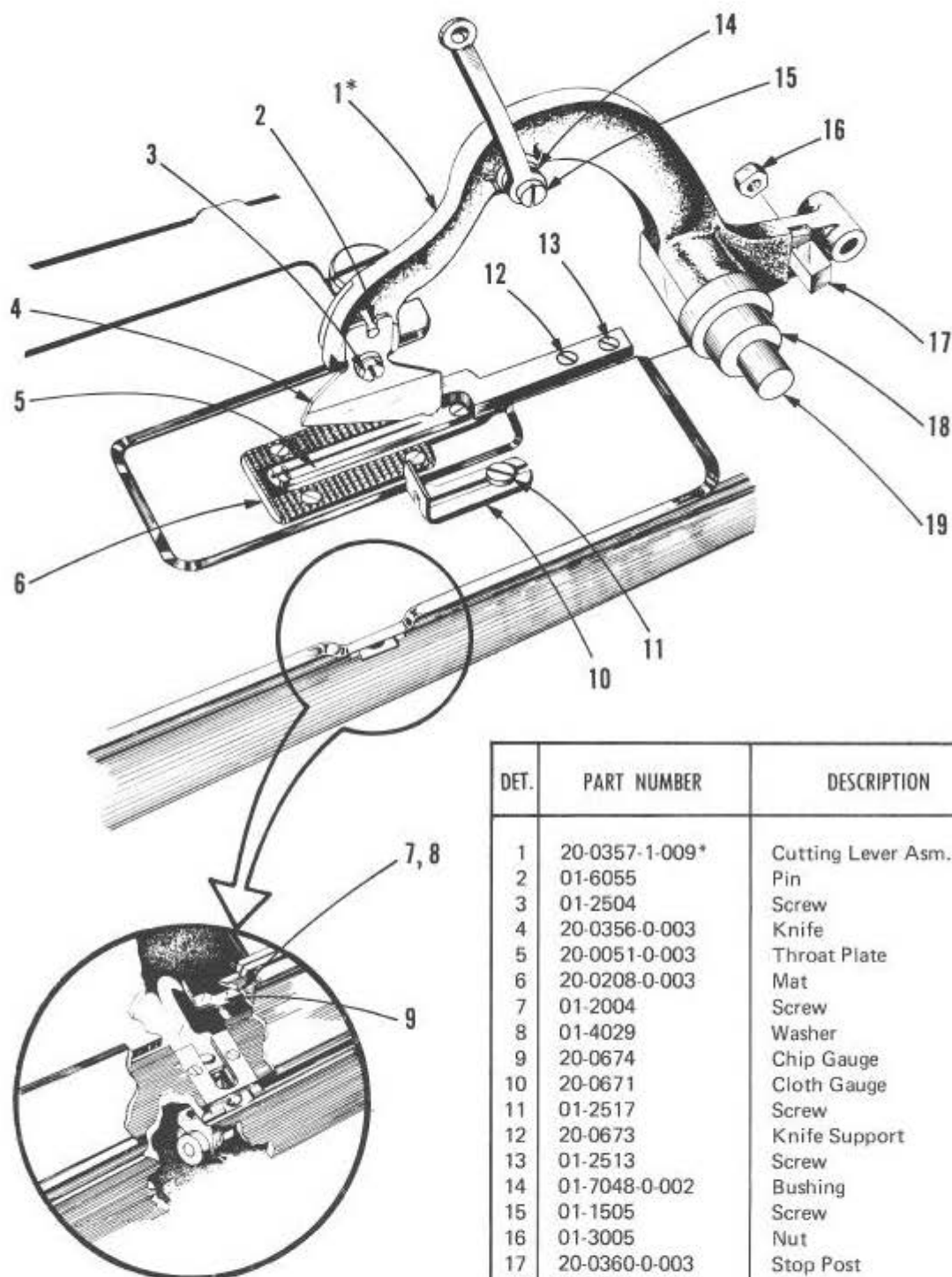
*Furnished only as an Assembly.

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46

MODEL S2-CAED — 1½" CUT-AFTER EDGER FRONT STARTING POSITION

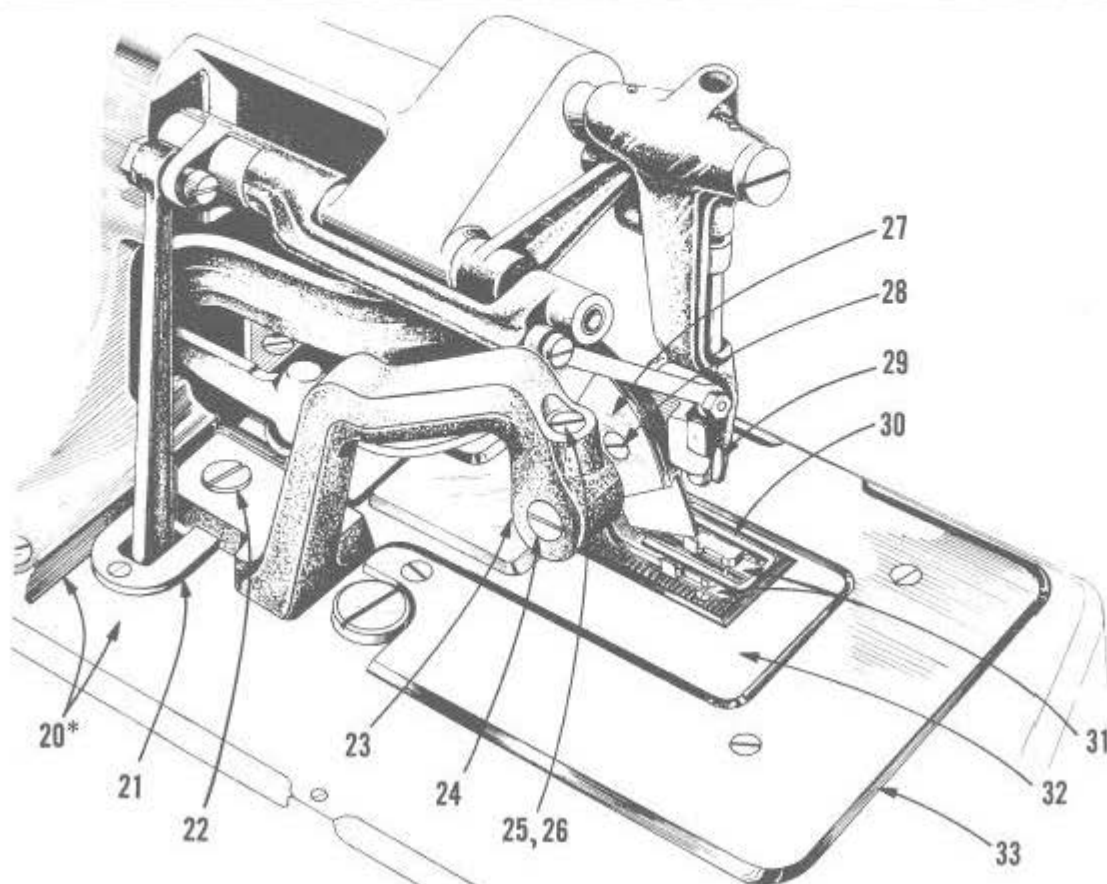


DET.	PART NUMBER	DESCRIPTION
1	20-0357-1-009*	Cutting Lever Asm.
2	01-6055	Pin
3	01-2504	Screw
4	20-0356-0-003	Knife
5	20-0051-0-003	Throat Plate
6	20-0208-0-003	Mat
7	01-2004	Screw
8	01-4029	Washer
9	20-0674	Chip Gauge
10	20-0671	Cloth Gauge
11	01-2517	Screw
12	20-0673	Knife Support
13	01-2513	Screw
14	01-7048-0-002	Bushing
15	01-1505	Screw
16	01-3005	Nut
17	20-0360-0-003	Stop Post
18	20-0571-0-003	Collar
19	20-0358-0-003	Pivot Stud
20	20-0397-1-011*	Head & Bedplate Asm.
21	20-0584-0-003	Cover Plate
22	01-2328	Screw

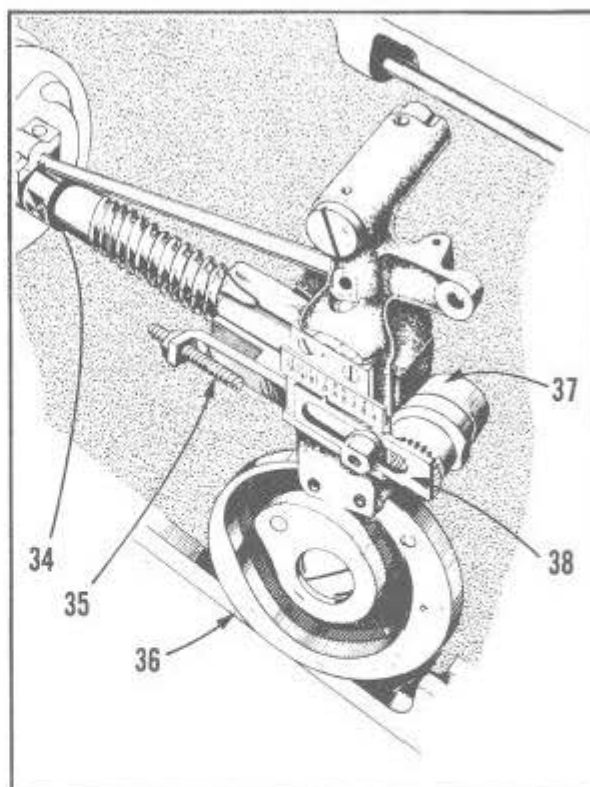
* Assembly, refer to Parts Index for assembly components.

MODEL S2 - CAED — 1½" CUT-AFTER EDGER FRONT STARTING POSITION

47



23	20-0669-1	Bracket
24	01-2634	Screw
25	01-2150	Set Screw
26	20-0733	Brass Plug
27	20-0670-1	Wear Plate
28	01-2339	Screw
29	20-0001-0-003	Needle Bar
30	20-0767-0-028	Needle Guard
31	20-0196-0-228	Clamp Feet, long, coarse corrugation
	20-0196-0-234	Clamp Feet, short, coarse corrugation
	20-0196-0-328	Clamp Feet, long, fine corrugation
	20-0196-0-334	Clamp Feet, short, fine corrugation
32	20-0210-1-003	Clamp Plate
33	20-0214-1-003	Cover Plate
34	20-0166-0-015	Shifter
35	01-2352	Screw
36	20-0276-2-815	Feed Reversing Cam
37	20-0278-2-003	Cam
38	20-0240-0-015	Adjustable Slide

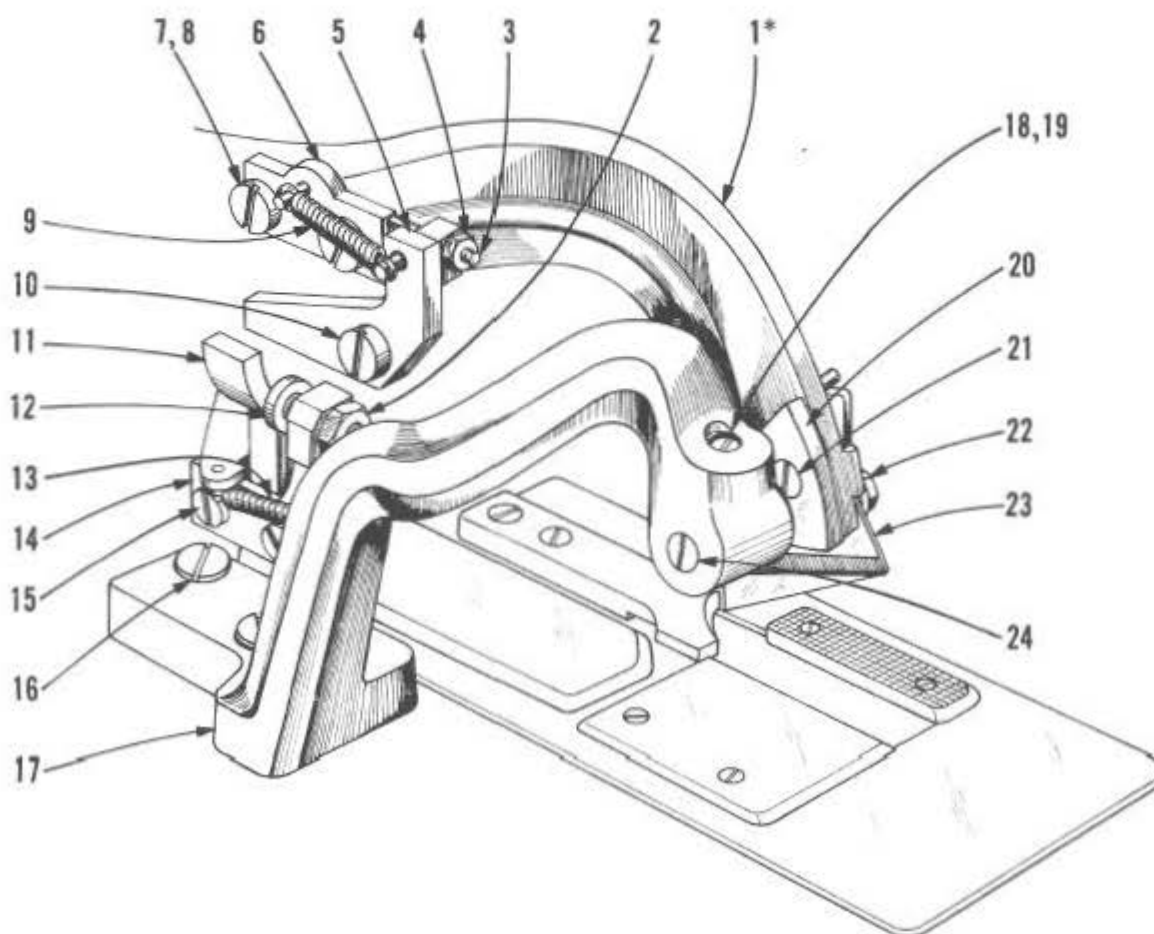


* Assembly, refer to Parts Index for assembly components.

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3-47

48 MODEL S2 — CAED — CHIP EJECTING MECHANISM



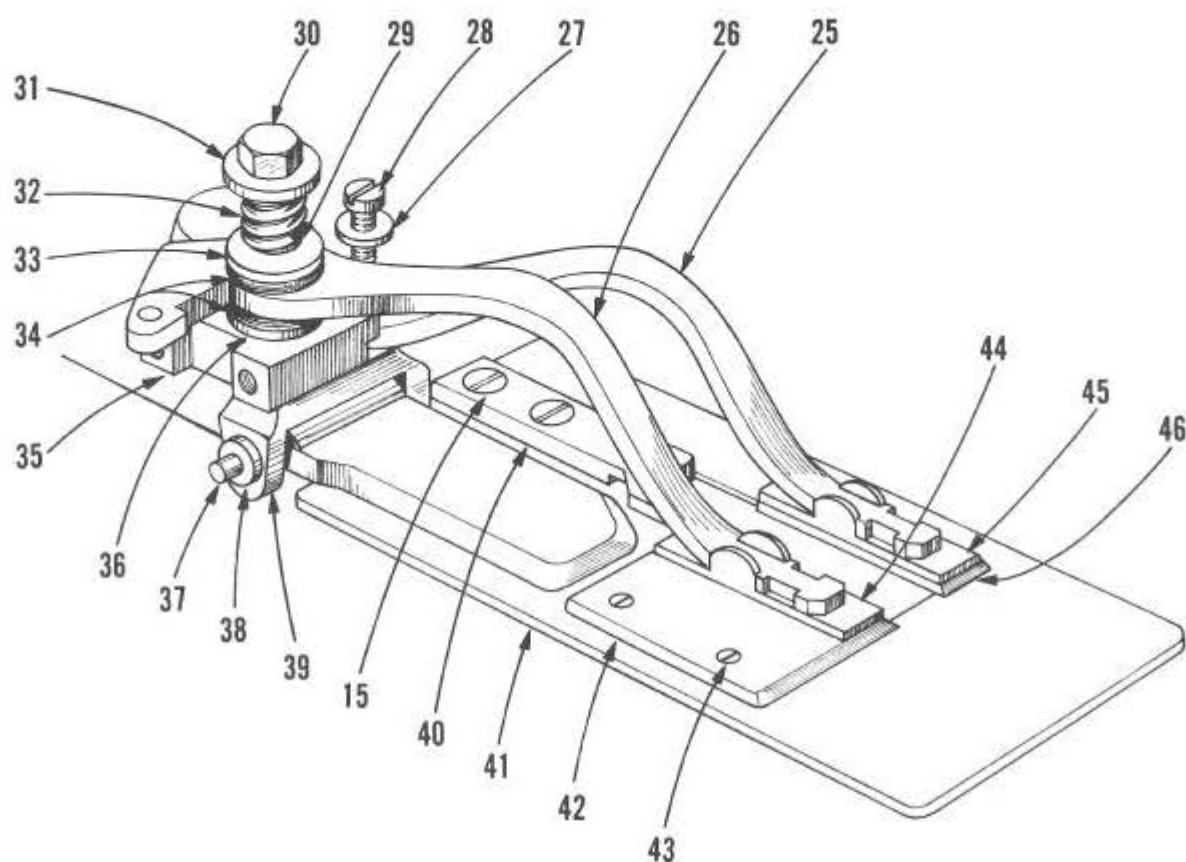
DET.	PART NUMBER	DESCRIPTION
1	20-0357-0-009*	Cutting Lever Asm.
2	01-3001	Nut
3	01-2076	Screw
4	01-3016	Nut
5	20-0728	Actuator
6	20-0727	Plate
7	01-2027-0-001	Screw
8	01-4011	Washer
9	01-5429	Spring
10	01-1455	Screw
11	20-0729	Ejector
12	01-2122	Screw
13	01-5452	Spring
14	20-0730	Plate
15	01-2513	Screw

16	01-2328	Screw
17	20-0669-1	Brace
18	01-2150	Screw
19	20-0733	Plug
20	20-0670-1	Plate
21	01-2339	Screw
22	01-2504	Screw
23	20-0356-0-003	Knife
24	01-2634	Screw

* Assembly, refer to Parts Index for assembly components.

MODEL S2-CAED – CHIP EJECTING MECHANISM

49



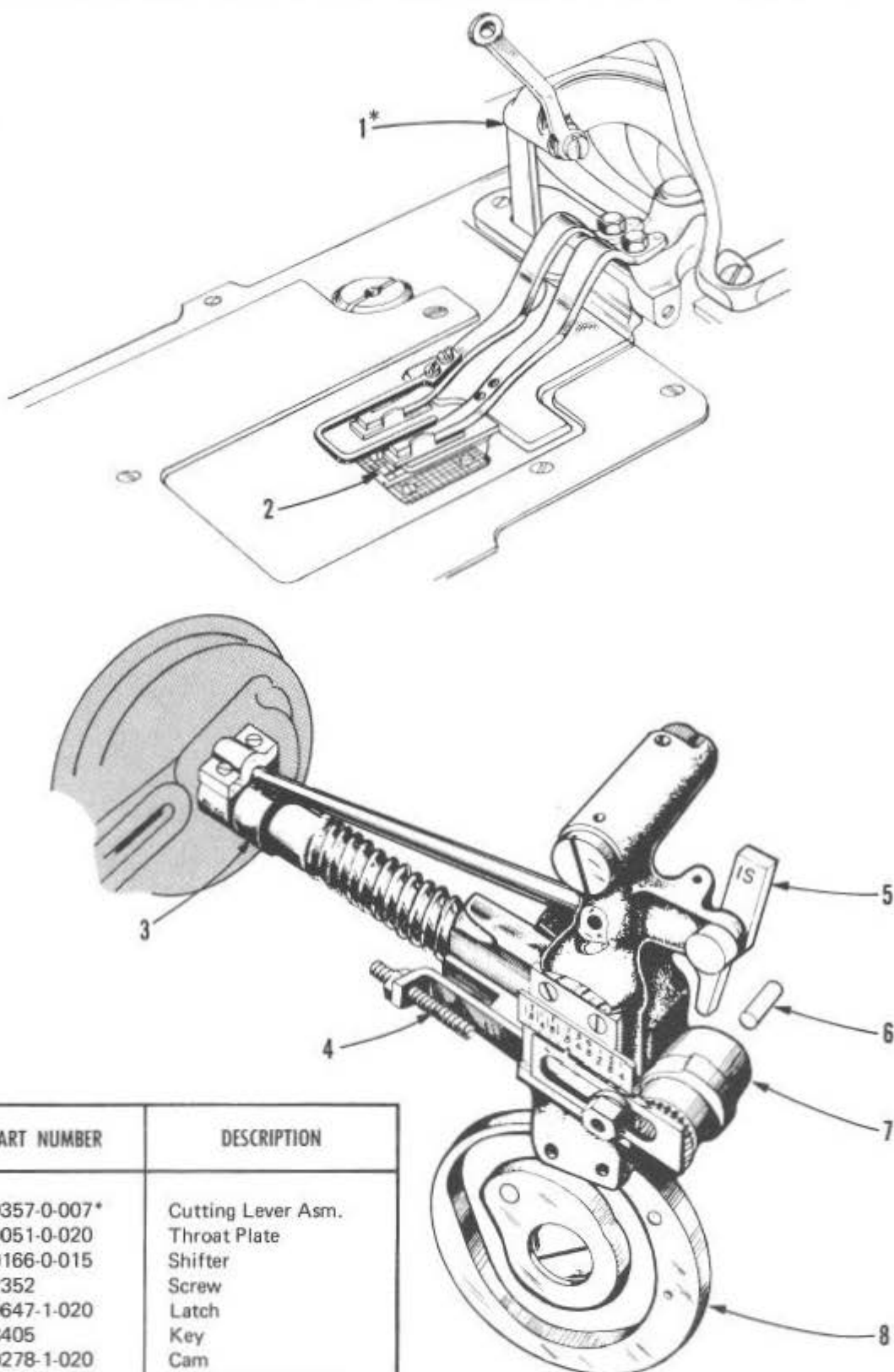
25	20-0194	Clamp Arm
26	20-0194-0-003	Clamp Arm
27	01-4513	Washer
28	01-2635	Screw
29	01-7467	Bushing
30	01-2646	Screw
31	01-4006	Washer
32	01-5451	Spring
33	01-4514	Washer
34	20-0732	Bearing
35	20-0731	Block
36	01-4515	Washer
37	01-6595	Pin
38	01-4516	Washer
39	20-0190-1	Tailpiece
40	20-0673	Knife Support
41	20-0210-1-003	Clamp Plate

42	20-0208-0-070	Mat
43	01-2376	Screw
44	20-0196-0-569	Clamp Foot, long
45	20-0196-0-659	Clamp Foot, short
45	20-0196-0-228	Clamp Foot - see detail 31 page 47.
46	20-0208-0-071	Mat

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3-49

**MODEL S2-ISBH — 1¼" BACK STARTING
SINGLE STITCH BARRING**


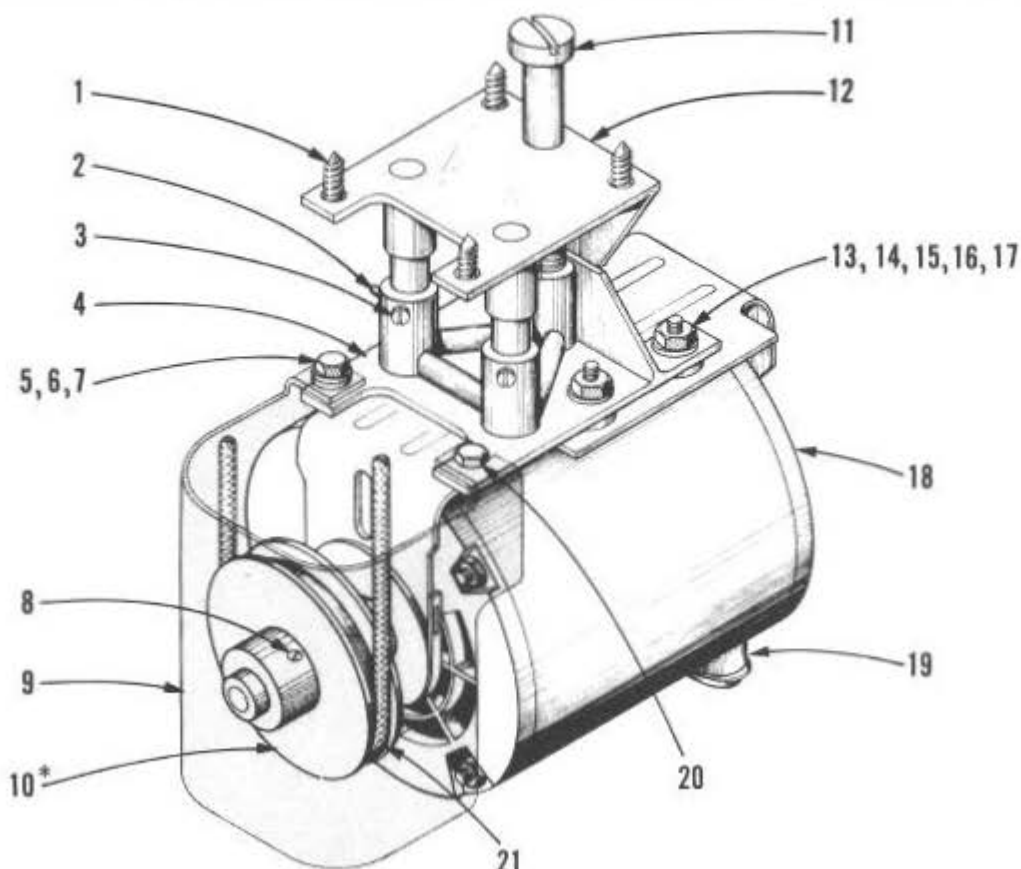
DET.	PART NUMBER	DESCRIPTION
1	20-0357-0-007*	Cutting Lever Asm.
2	20-0051-0-020	Throat Plate
3	20-0166-0-015	Shifter
4	01-2352	Screw
5	20-0647-1-020	Latch
6	01-8405	Key
7	20-0278-1-020	Cam
8	20-0276-2-011	Feed Reverse Cam

*Assembly, refer to Parts Index for assembly components.

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MOTOR MOUNTING

51


DET.	PART NUMBER	DESCRIPTION
1	01-2302	Screw
2	01-6031	Taper Pin
3	01-2158	Screw
4	04-0753-0-801	Bracket
5	01-1108	Screw
6	01-4004	Lock Washer
7	01-4006	Washer
8	01-2150	Set Screw
9	04-0754-1	Guard
10	04-0722-0-268*	Pulley (2.60 dia. used with 5/16" belts and 1725 RPM motors)
	04-0722-0-308*	Pulley (3.0 dia. used with 5/16" belts and 1440 RPM motors)
	04-0722-0-258**	Pulley (2.50 dia. used with 3/8" belts and 1725 RPM motors)
	04-0722-0-294**	Pulley (2.90 dia. used with 3/8" belts and 1440 RPM motors)
11	04-0751	Screw

12	04-0752	Mounting Bracket
13	01-2093	Clamp Screw
14	01-4043	Washer
15	01-4026	Rubber Washer
16	01-4049	Lock Washer
17	01-3013	Nut
18	—	Motor (1/3 HP, 60 Hz, 1725 RPM)
	—	Motor (1/3 HP, 50 Hz, 1440 RPM)
19	04-0013	Connector
	04-0014	Connector (universal)
20	01-2390	Screw
21	05-0102-1-335	Endless Belt (5/16" for 1725 RPM motors)
	05-0102-1-340 *	Endless Belt (5/16" for 1440 RPM motors)
	05-0102-0-335**	Endless Belt (3/8" for 1725 RPM motors)
	05-0102-0-340**	Endless Belt (3/8" for 1440 RPM motors)

*Use one size smaller Motor Pulley on Models S2-SRCS and on all Automatic Garment Feeders with S2 Buttonhole Machines.

**Machines Prior to No. 30931, Not Updated.

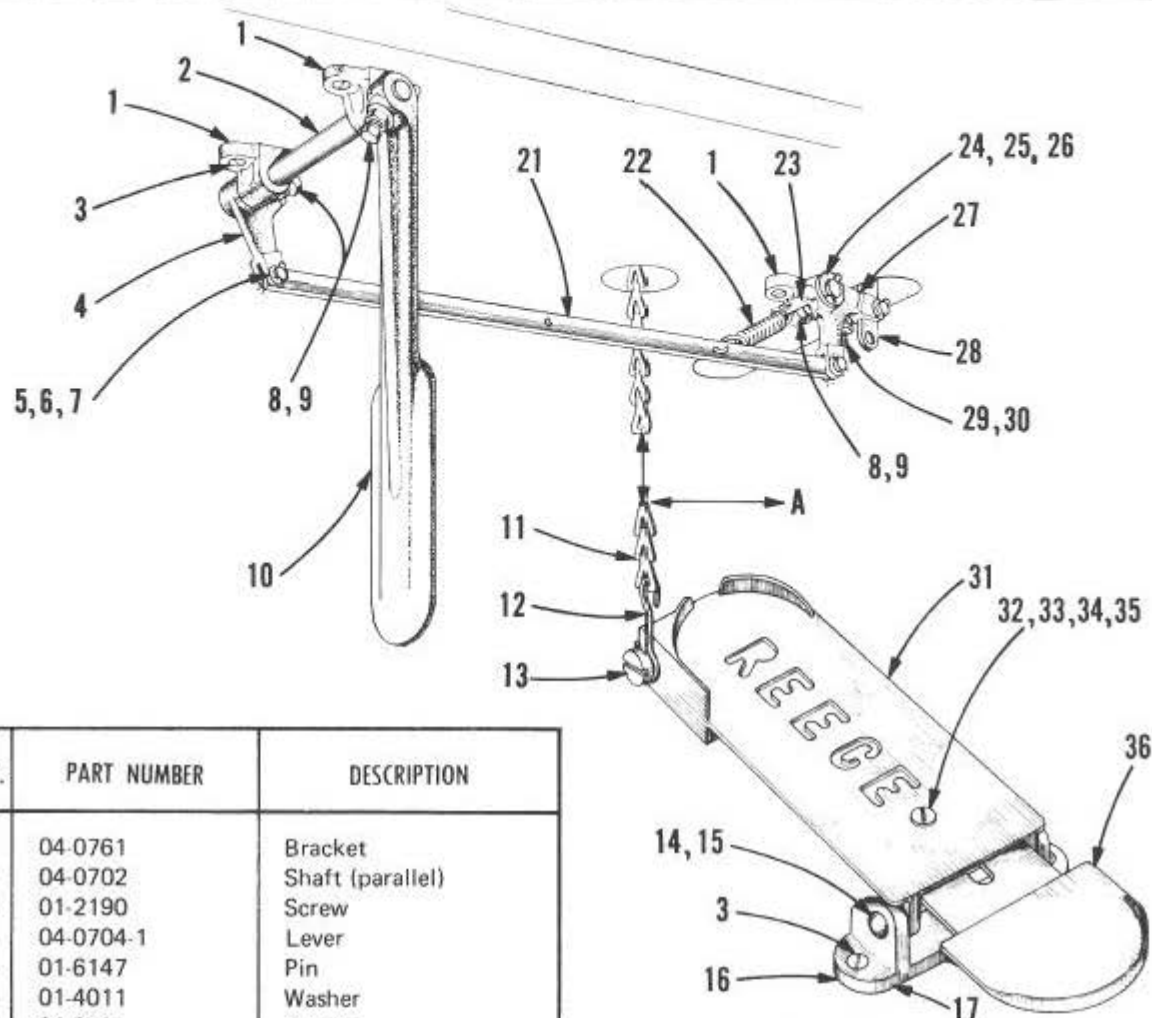
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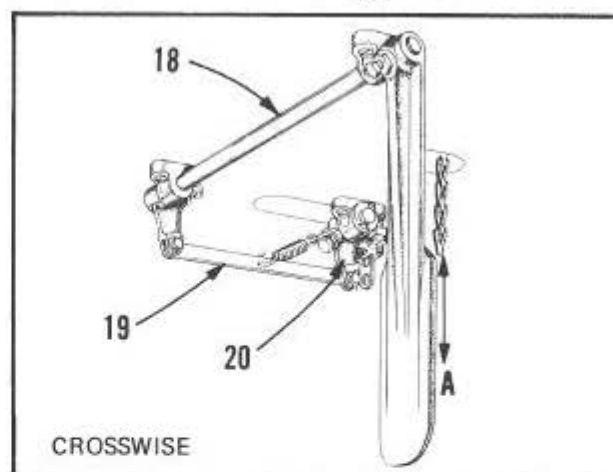
3-51

52

KNEE LEVEL & TREADLE CONTROLS



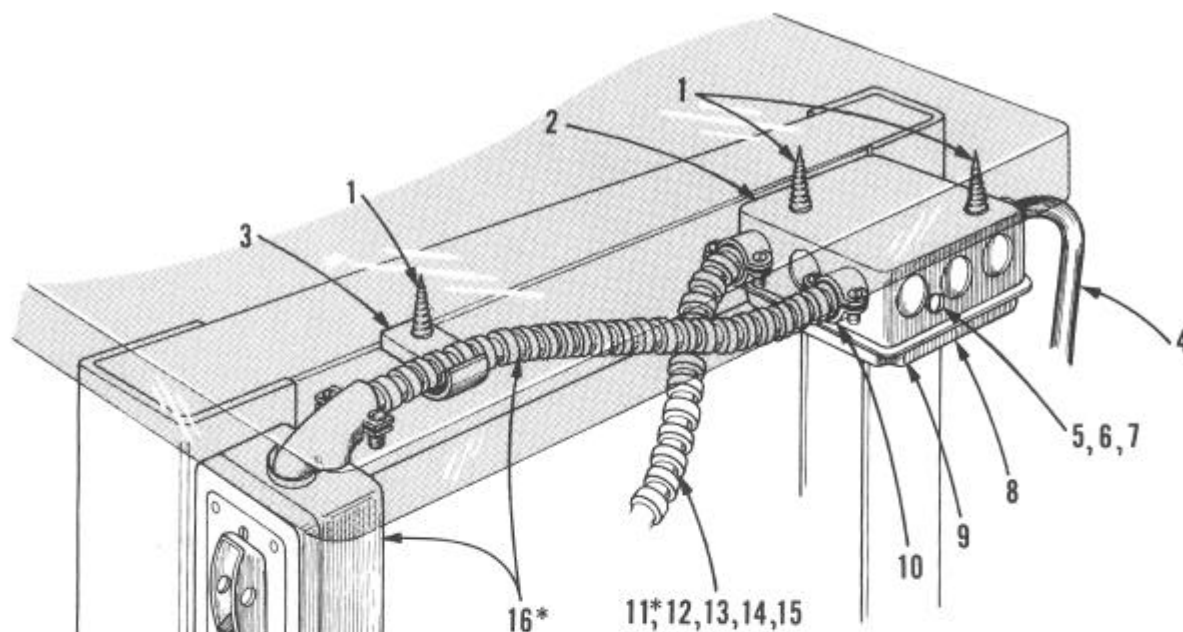
DET.	PART NUMBER	DESCRIPTION
1	04-0761	Bracket
2	04-0702	Shaft (parallel)
3	01-2190	Screw
4	04-0704-1	Lever
5	01-6147	Pin
6	01-4011	Washer
7	01-6121	Cotter
8	01-2195	Screw
9	01-3009	Nut
10	04-0701	Knee Lever
11	04-0537	Chain, long
12	04-0536	Link
13	01-2046	Screw
14	01-6137	Pivot Pin
15	01-6131	Cotter Pin
16	04-0542	Bracket
17	04-0558	Block
18	04-0763	Shaft (crosswise)
19	04-0759	Link (crosswise)
20	04-0762	Lever (crosswise)
21	04-0758	Link (parallel)
22	01-5154	Spring
23	04-0749	Anchor
24	01-6542	Pin
25	01-4047	Washer
26	01-6123	Cotter
27	04-0748	Lever (parallel)
28	04-0760	Adjustable Link
29	01-2077	Screw
30	01-3005	Nut



31	04-0539	Treadle
32	01-2189	Screw
33	01-4004	Lock Washer
34	01-4006	Washer
35	01-3007	Nut
36	04-0540	Treadle Heel

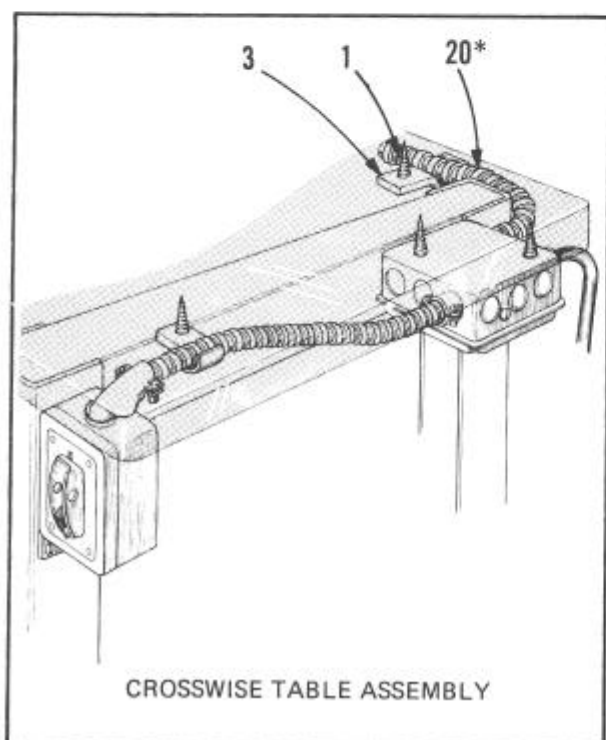
MANUAL OPERATED — ELECTRICAL SET UP

53



PARALLEL TABLE ASSEMBLY

17, 18, 19



CROSSWISE TABLE ASSEMBLY

DET.	PART NUMBER	DESCRIPTION
1	01-2083	Wood Screw
2	04-0207	4" Sq. Outlet Box
3	04-0016	Clamp
4	04-0136	Line Cord (115V)
	04-0137	Line Cord (230V)
	06-0173	Three Phase Line Cord (208/380V)
5	01-2369	Screw
6	01-4018	Washer
7	01-3421	Nut
8	04-0141	Receptacle (115V)
	04-0142	Receptacle (208/230V)
9	04-0121	Cover
10	04-0143	Straight Connector
11	30-0380-0-052*	Conduit (parallel)
	04-0183-0-050*	Conduit, 42" (universal)
12	04-0187	Clamp (universal)
13	01-2039	Screw (universal)
14	01-4019	Lock Washer (universal)
15	01-3402	Nut (universal)
16	04-0003-0-050*	Switch Asm.
17	01-2368	Screw
18	01-4046	Lock Washer
19	01-3057	Nut
20	30-0380-0-056*	3/8" Conduit, 41" (crosswise)

*Available by the foot only.

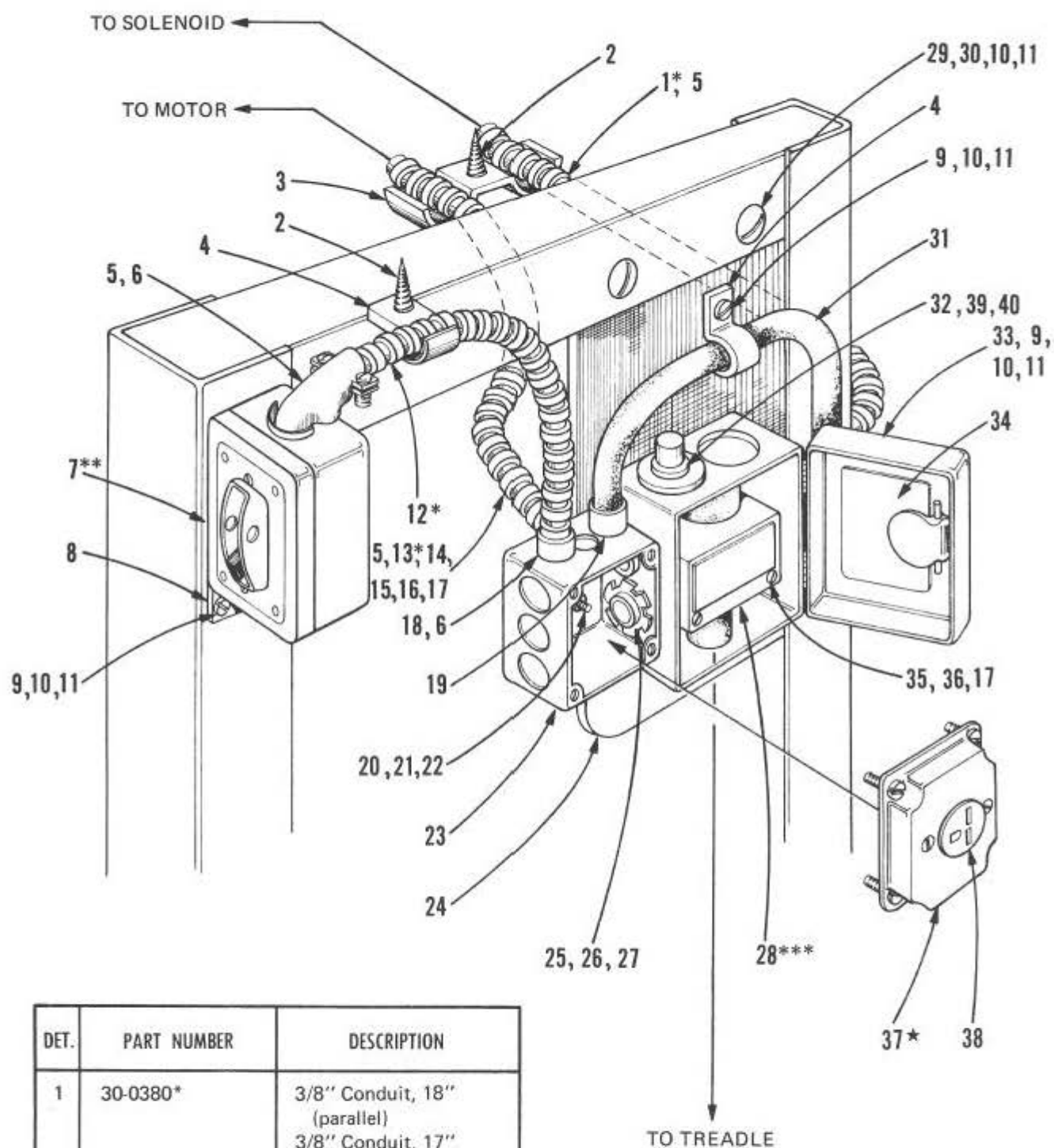
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3-53

54

SOLENOID STARTING — ELECTRICAL SET UP



DET.	PART NUMBER	DESCRIPTION
1	30-0380*	3/8" Conduit, 18" (parallel)
		3/8" Conduit, 17" (crosswise)
	04-0183-0-051	3/8" Conduit, 51" (universal)
2	01-2083	Screw
3	04-0126	Clamp

SOLENOID STARTING – ELECTRICAL SET UP

55

4	04-0016	Clamp
5	30-0044	Connector
6	04-0329	Insulator
7	04-0003-0-050**	Starter Switch Asm.
8	04-0065-1	Bracket
9	01-2368	Screw
10	01-4046	Lock Washer
11	01-3057	Nut
12	40-0594*	5/8" Conduit, 14"
13	30-0380*	3/8" Conduit, 61" (parallel)
		3/8" Conduit, 56" (crosswise)
	04-0183*	3/8" Conduit, 42" (universal)
14	04-0187	Clamp (universal)
15	01-2039	Screw (universal)
16	01-4019	Lock Washer (universal)
17	01-3402	Nut (universal)
18	04-0220	Connector
19	04-0143	Connector
20	01-2369-0-001	Screw
21	01-3421	Nut
22	01-4018	Washer
23	04-0207	Outlet Box, 4"
24	04-0062-1	Mounting Plate
25	04-0084-0-801	Connector
26	04-0084-0-802	Connector
27	01-4509	Washer
28	04-0112-0-115	Relay (regular 115V- 60 Hz)
	04-0112-0-179	Relay (regular 380V- 50 Hz)
	04-0112-0-180	Relay (regular 220V- 50 Hz)
	04-0112-0-195***	Relay (fast, 380V-50 Hz)
	04-0112-0-196***	Relay (fast, 230V-50 Hz and 220V-50 Hz)
	04-0112-0-230	Relay (regular 230V- 60 Hz)
	04-0112-1-115***	Relay (fast, 115V-60 Hz)
	04-0112-1-230***	Relay (fast, 230V-60 Hz)
29	01-2671	Screw
30	01-7472	Bushing
31	04-0136	Single Phase Line Cord (115V-60Hz)
	04-0137	Single Phase Line Cord (230V-60 Hz)
	06-0173	Three Phase Line Cord (208/230V-60 Hz)
32	04-0122	Switch
33	04-0113-1	Relay Box
34	05-0417-1	Decal

35	01-2153	Screw
36	01-4061	Washer
37	04-0121	Outlet Box Cover
	04-0132★	Outlet Box Cover (for three phase, 380V- 50 Hz only.)
38	04-0141	Receptacle, 110V
	04-0142	Receptacle, 230V
39	01-3430	Nut
40	01-4536	Washer

* Available by the foot only.

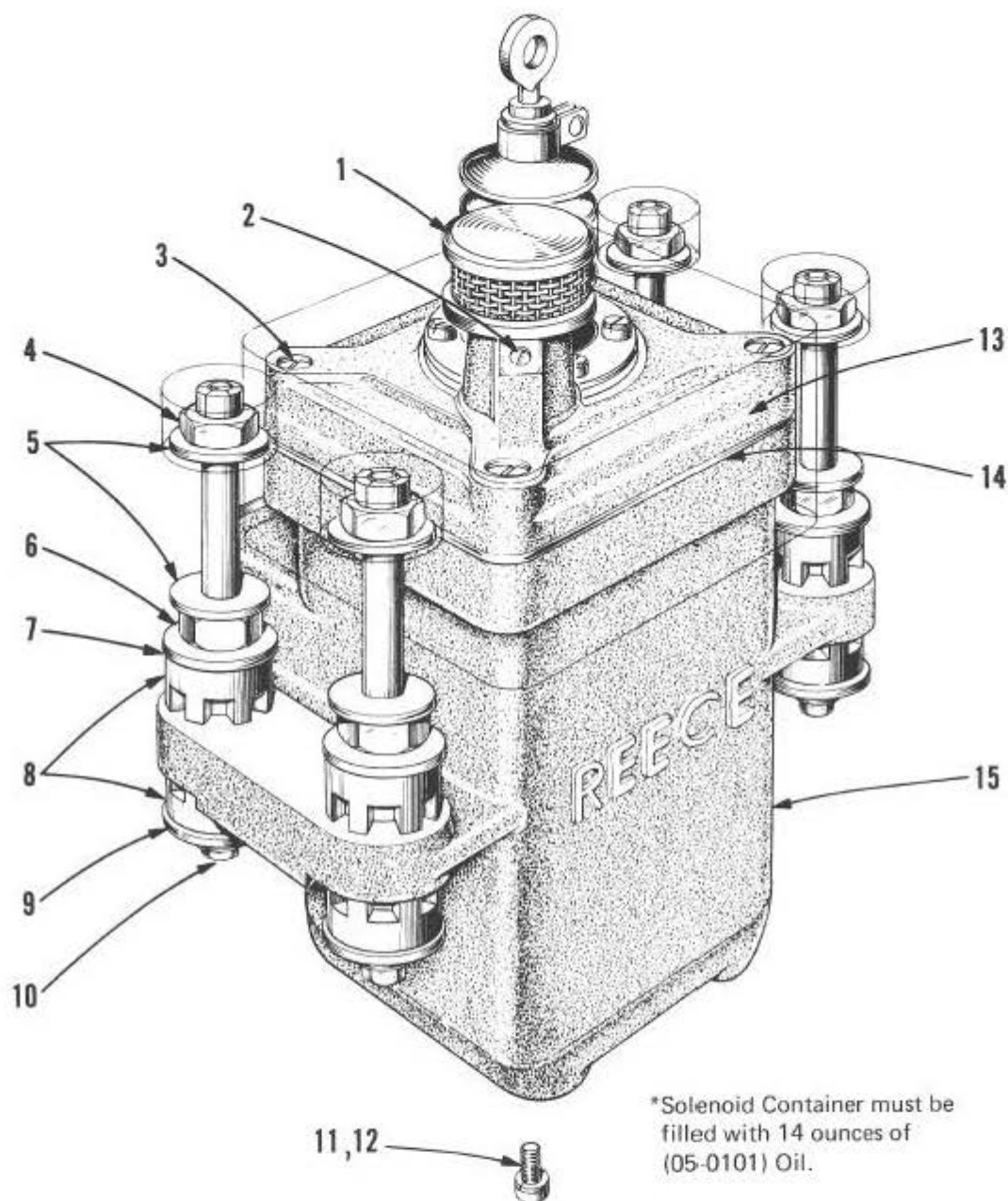
** Assembly, refer to Parts Index for assembly components

*** Fast Acting Relays for Dot Tacking Machines.

★ Furnished without receptacle.

56

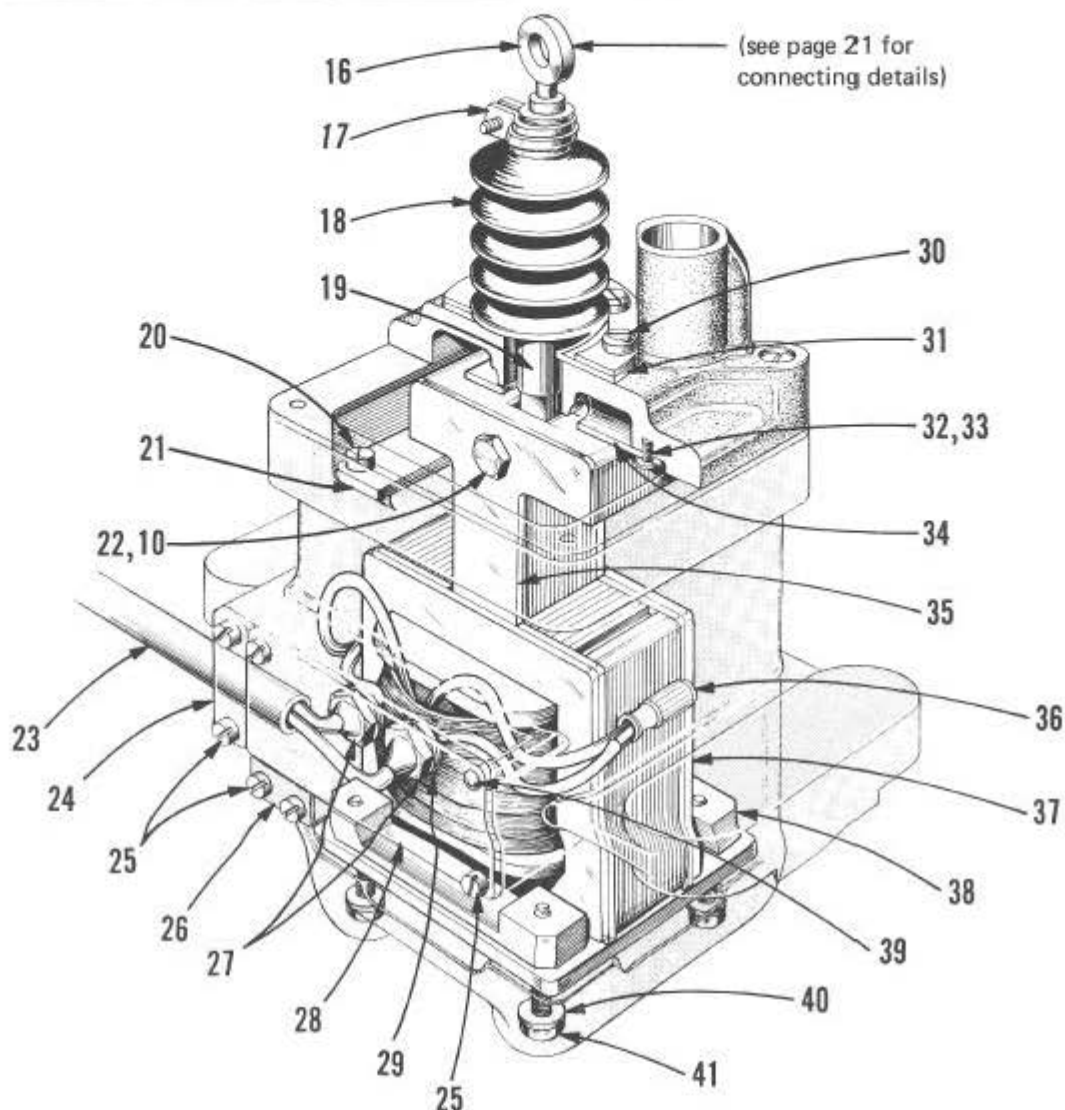
STARTING SOLENOID



DET.	PART NUMBER	DESCRIPTION
1	04-0107	Breather
2	01-2554	Set Screw
3	01-2046	Screw
4	01-3429	Nut (cw & par.)
	01-3400	Nut (universal)
5	01-4043	Washer (cw & par.)
6	04-0098-2	Stud, Long (cw. & par.)
	04-0160	Stud, Short (universal)
7	01-4469	Washer (cw & par.)

8	04-0099	Isolator (cw & par.)
9	01-4468	Washer
10	01-3428	Nut
11	01-2553	Screw
12	01-4466	Seal Washer
13	04-0093	Cover
14	04-0095	Gasket
15	04-0096-1*	Container

STARTING SOLENOID

57


16	04-0089	Upper Link
17	04-0116	Clamp
18	04-0090	Bellows
19	04-0091	Lower Link
20	01-2059	Screw
21	04-0097	Baffle
22	01-2551	Screw
23	30-0380-0-052	3/8" Cable, 42" Long
24	04-0102	Clip
25	01-2050	Screw
26	04-0168	Cover
27	04-0100-0-050	Terminal
28	04-0101-1-811	Cover (220V, 50 Hz)
	04-0101-1-812	Cover (380V, 50 Hz)
	04-0101-1-813	Cover (110V, 60 Hz)
	04-0101-1-814	Cover (205V, 60 Hz)
	04-0101-1-815	Cover (190V, 50 Hz)
29	01-4471	Seal Washer
30	01-2577	Screw
31	04-0092	Plate

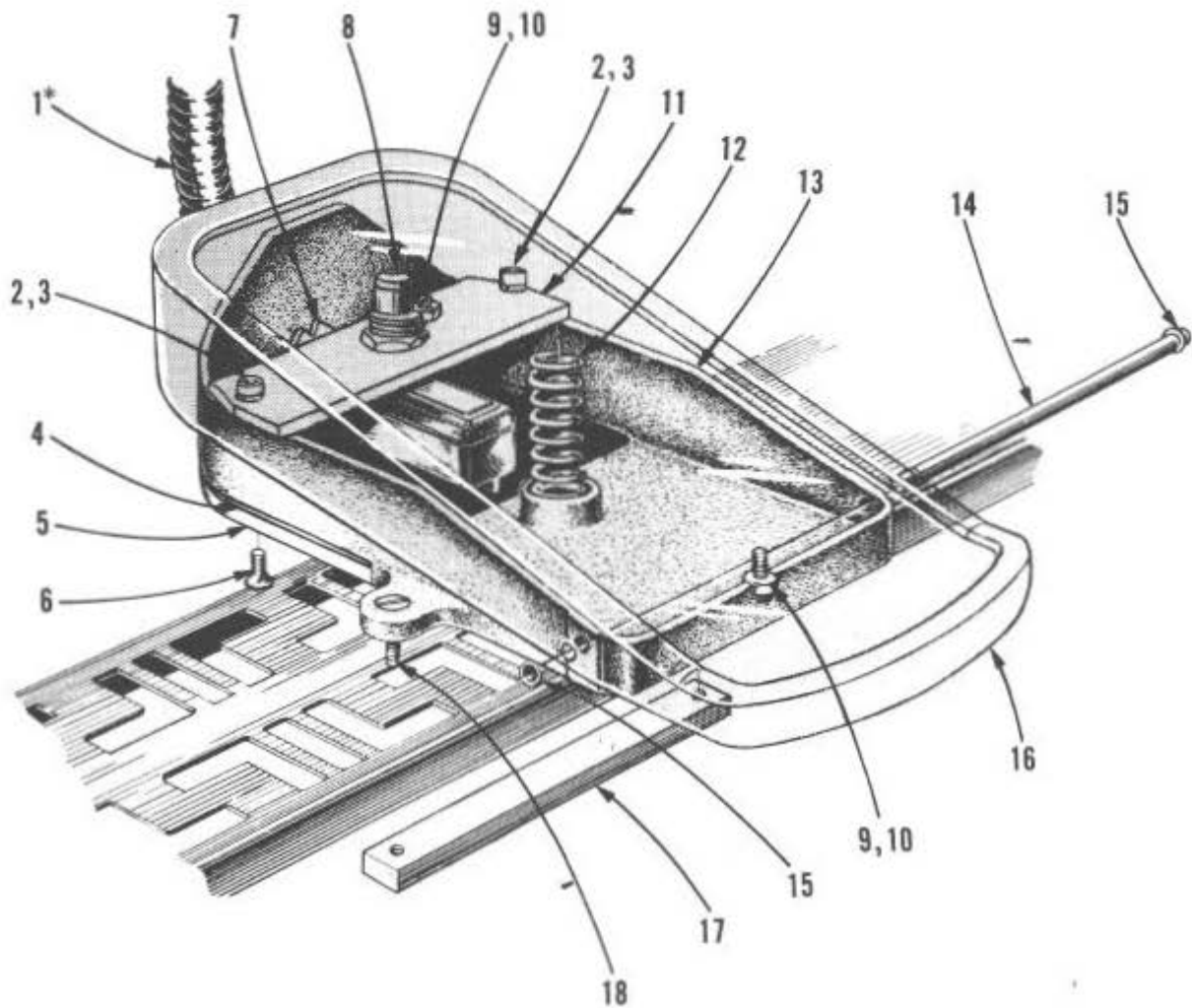
32	01-2312	Screw
33	01-4065	Washer
34	04-0094	Baffle
35	04-0103-0-001	Plunger (supplied with det. 38 and can be ordered separately)
36	05-0369	Wire Connector
37	04-0103-0-110	Solenoid (110V, 60 Hz)
	04-0103-0-205	Solenoid (205V, 60 Hz)
	04-0103-0-520	Solenoid (220V, 50 Hz)
	04-0103-0-580	Solenoid (380V, 50 Hz)
	04-0103-0-008	Solenoid (190V, 50 Hz)
38	04-0106	Plate
39	01-2592	Drive Screw
40	01-4467	Washer
41	01-2552	Screw

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3-57

58 SOLENOID STARTING — PEDAL SWITCH ASSEMBLY



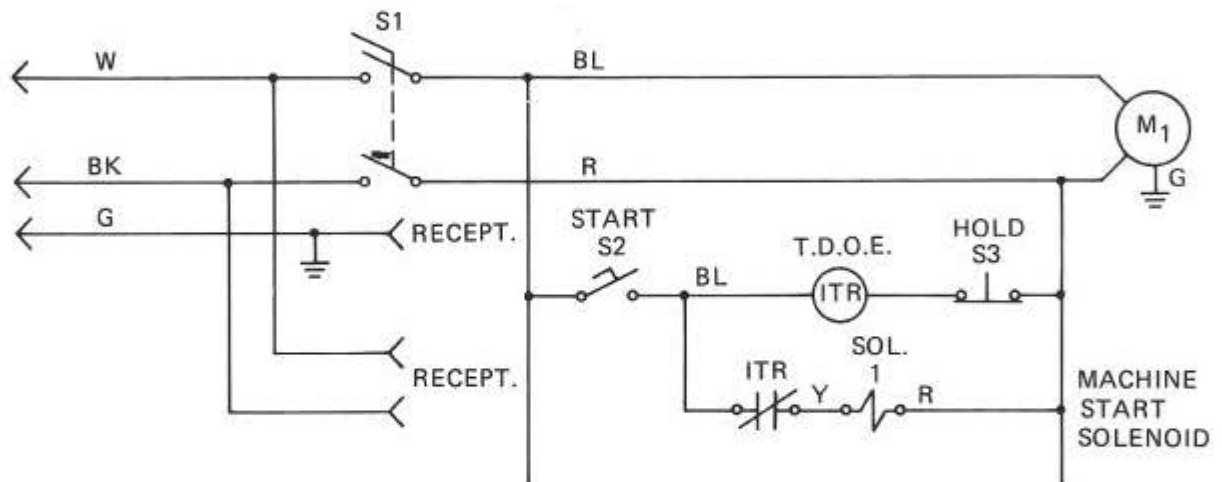
DET.	PART NUMBER	DESCRIPTION			
1	30-0380-0-052*	Conduit, 30" (parallel)			
	30-0380-0-56*	Conduit, 30" (crosswise)			
2	01-2142	Screw			
3	01-4407	Lock Washer			
4	40-0536	Insulator			
5	40-0537	Base Plate			
6	01-2451	Screw			
7	04-0087	Straight Connector, 3/8"			
8	04-0117	Switch			
9	01-2528	Screw			
10	01-3416	Nut			
11	04-0118	Switch Plate			
12	01-5428	Spring			
13	40-0535	Foot Base			
14	40-0538-2	Shaft			
15	01-6551	Retaining Ring			
16	04-0111	Pedal			
17	40-0301	Plate			
18	01-2444	Screw			

*Available by the foot only.

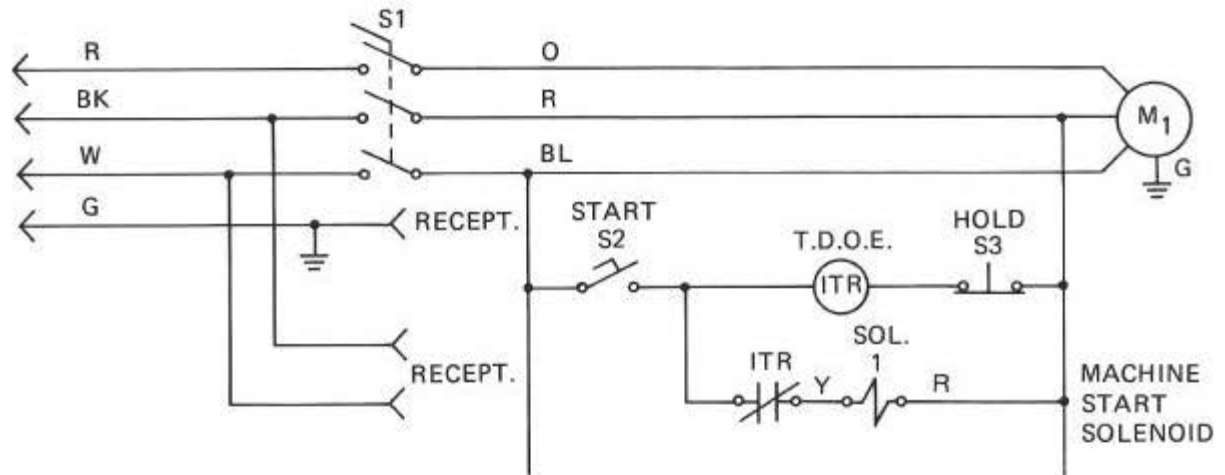
SOLENOID STARTING – WIRING DIAGRAMS

59

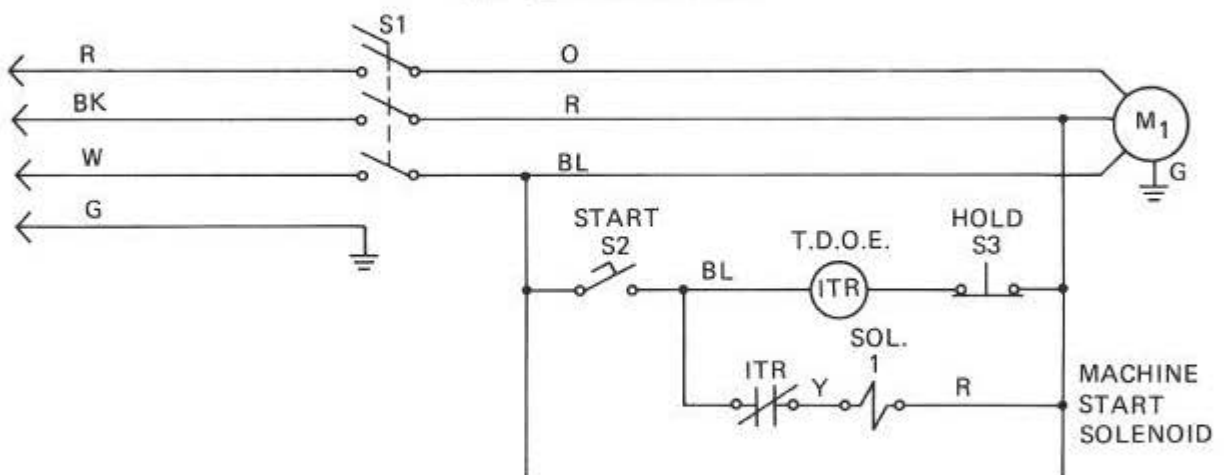
115/230V - 50 AND 60 HZ - SINGLE PHASE



208/230V - 50 AND 60 HZ - THREE PHASE



380V - 50 HZ - THREE PHASE

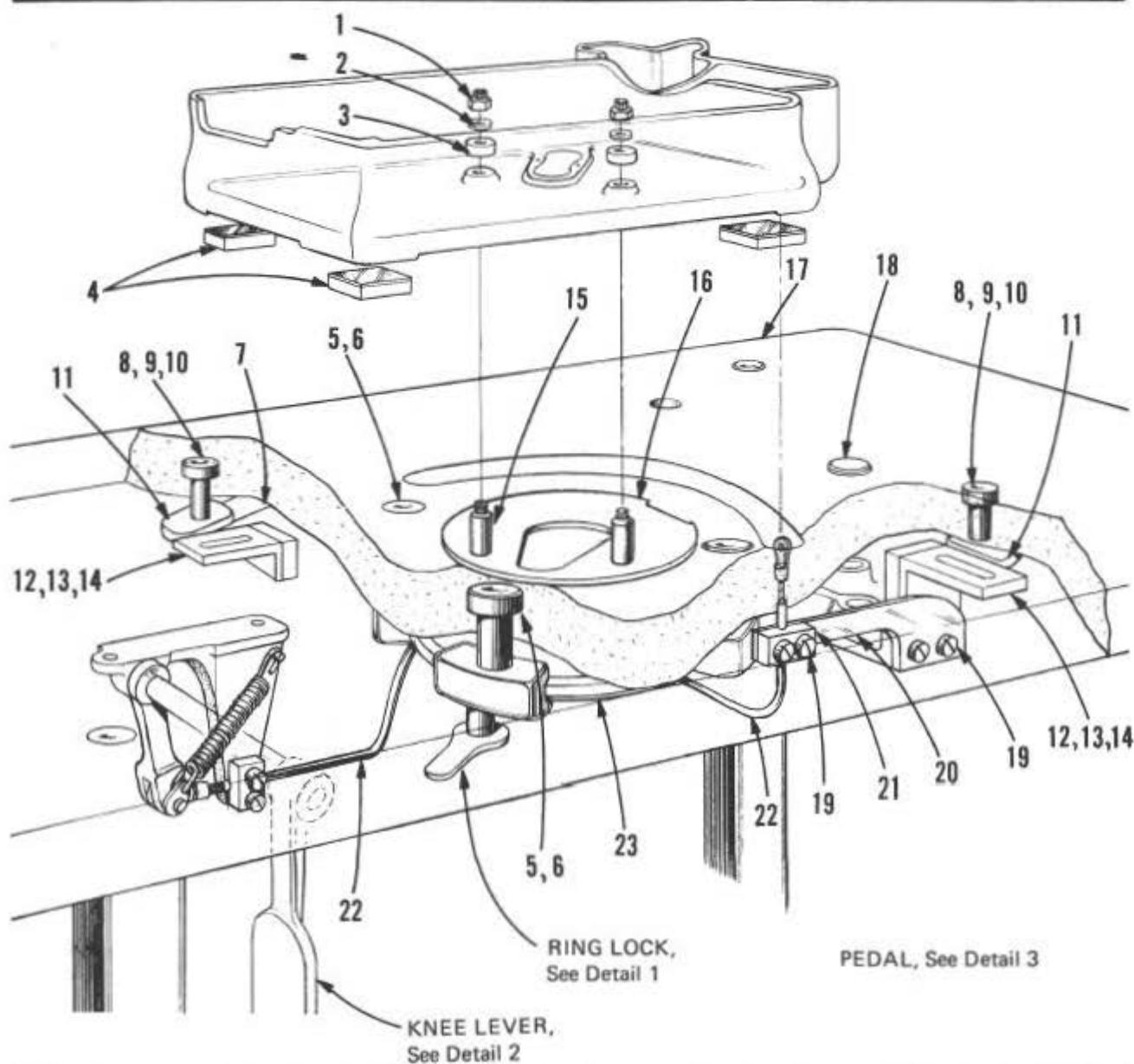


Note: M₁ 1/3 H.P. Motor with internal O/L Protection and Manual Reset.

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3-59

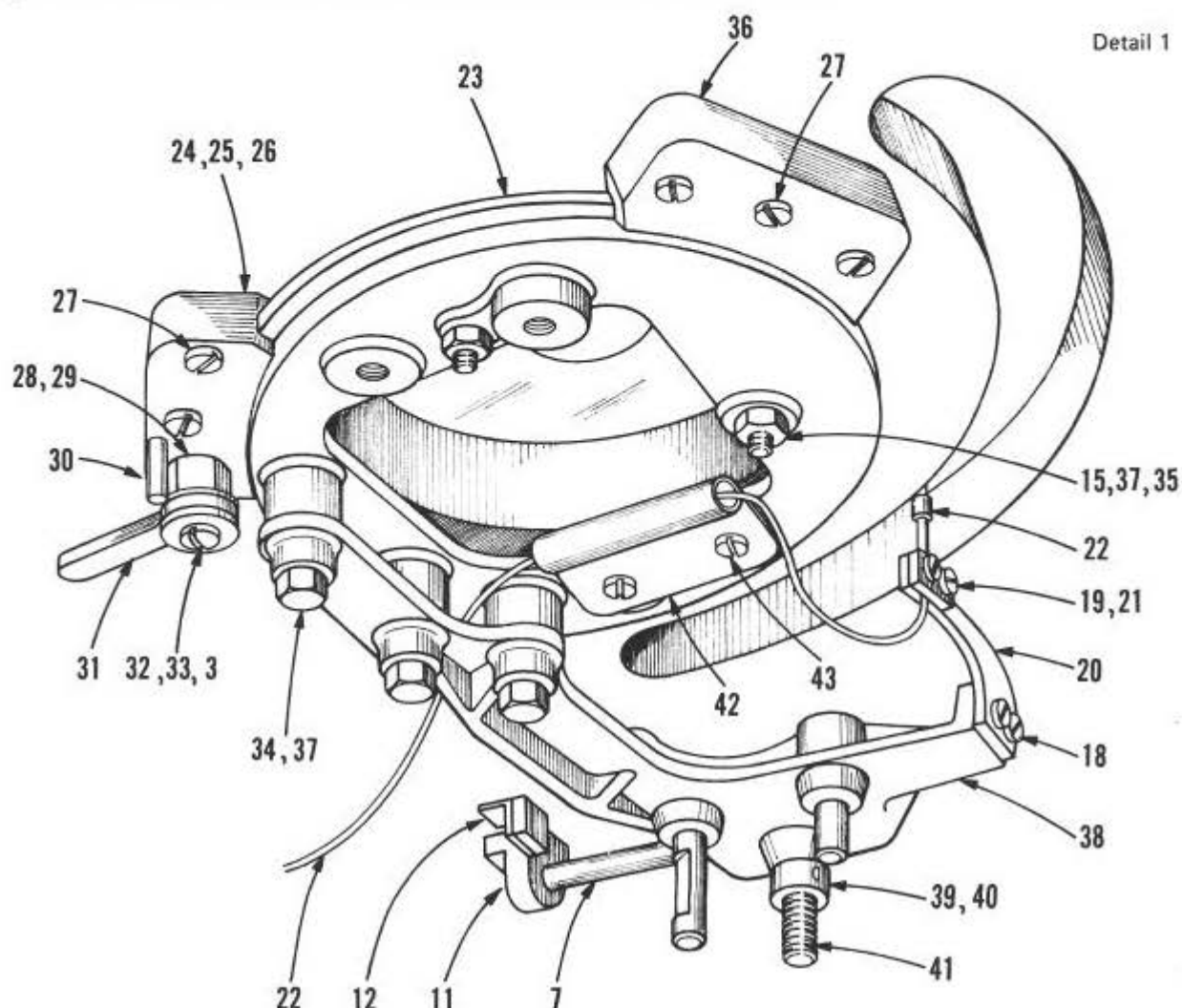
60
UNIVERSAL TABLE


DET.	PART NUMBER	DESCRIPTION
1	01-3429	Nut
2	01-4043	Washer
3	01-4501	Rubber Washer
4	20-0598-2	Pad
5	04-0158	Segment Screw
6	01-4500	Washer
7	04-0156	Support
8	01-2607	Screw
9	04-1061	Nut
10	04-0178	Shim
11	04-0157	Rail Bracket
12	20-0691-1	Bumper
13	01-2538	Screw
14	01-4063	Washer

15	04-0159	Location Stud
16	04-0161	Table Cover
17	04-0151	Table Top
18	04-0177	Snap Button
	04-0083	Snap Button (solenoid only)
19	01-2027	Screw
20	04-0171	Cable Bracket
21	04-0172	Cable Clamp
22	04-0175	Cable
23	04-0152	Center Ring

UNIVERSAL TABLE

61



24	04-0155	Segment
25	04-0165	Clamp
26	01-1450	Screw
27	01-2610	Wood Screw
28	04-0167	Clamp Nut
29	01-6580	Retaining Ring
30	01-6579	Pin
31	04-0166	Handle
32	01-2115	Screw
33	01-4502	Washer
34	01-2608	Screw
35	01-4054	Lock Washer
36	01-0154	Segment
37	01-3041	Nut
38	04-0153	Motor Bracket
39	04-0222	Collar
40	01-2639	Set Screw
41	04-0162	Motor Adjust Screw

42	04-0176	Cable Guide (manual only)
43	01-2609	Screw (manual only)
44	04-0298	Knee Lever
45	04-0299-0-050	Arm
46	01-2195	Screw
47	01-3009	Nut
48	01-2190	Wood Screw
49	04-0761	Bracket
50	04-0439	Stop Lever
51	01-5154	Spring
52	04-0169	Bracket
53	04-0170-1	Shaft
54	04-0704-1	Lever
55	01-6147	Pin
56	01-4011	Washer
57	01-6121	Cotter

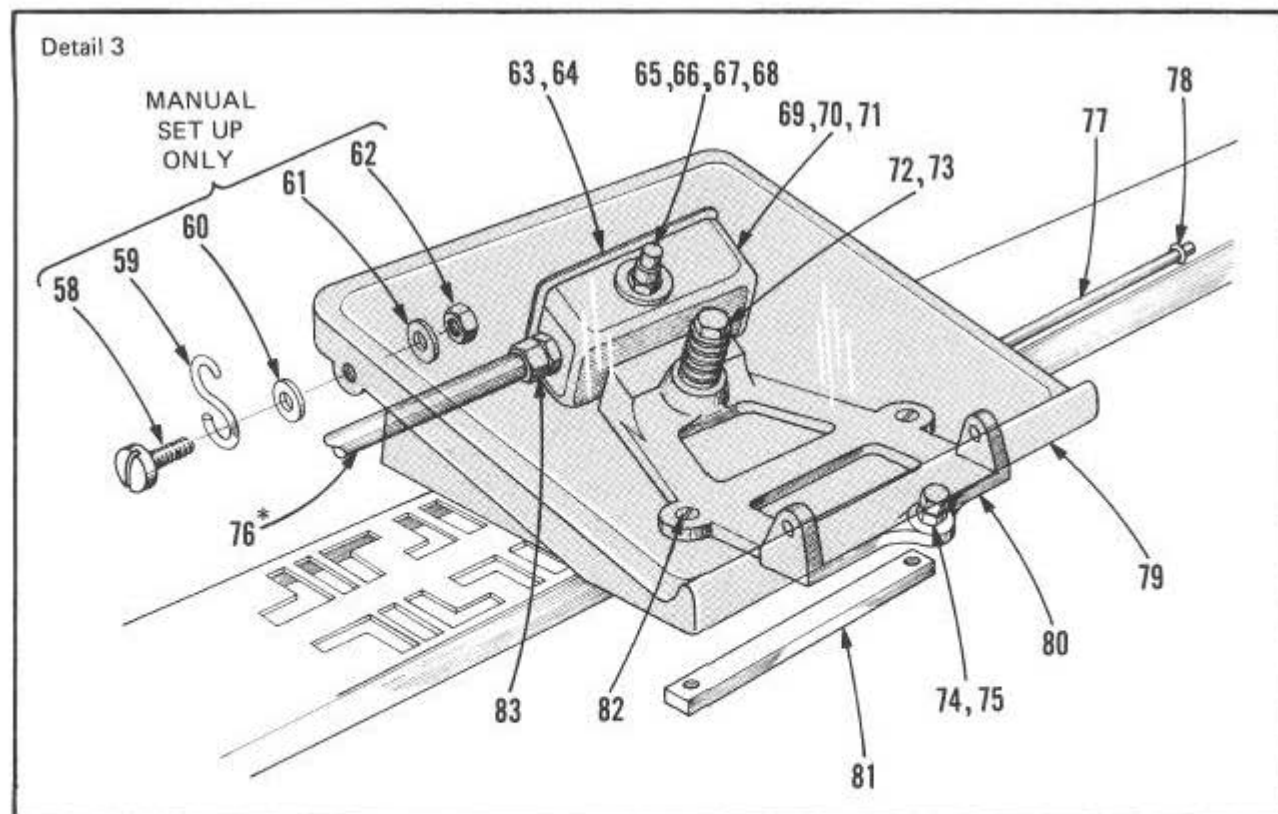
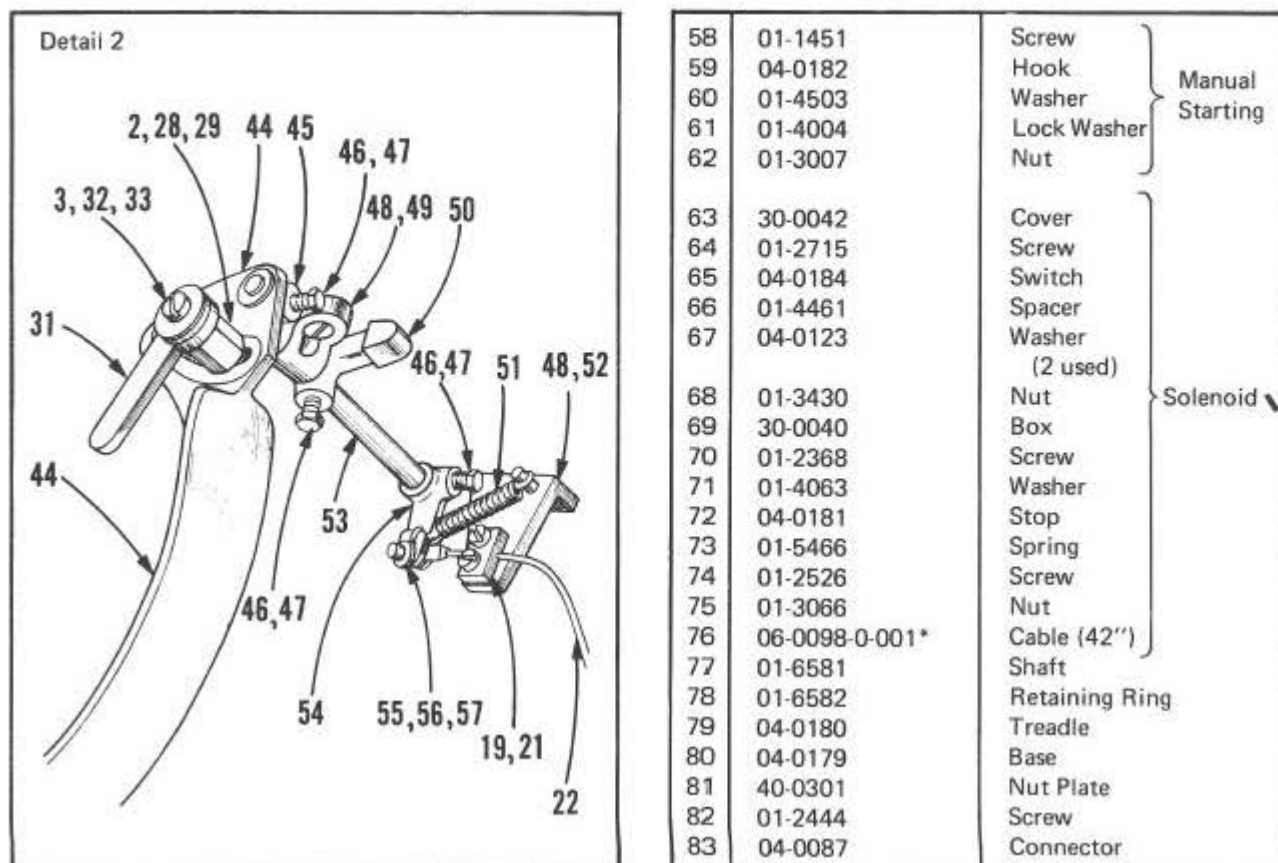
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3-61

62

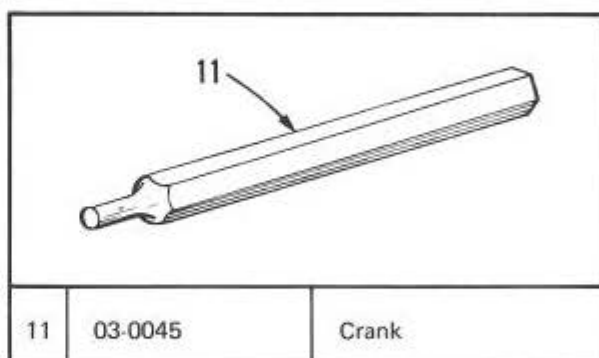
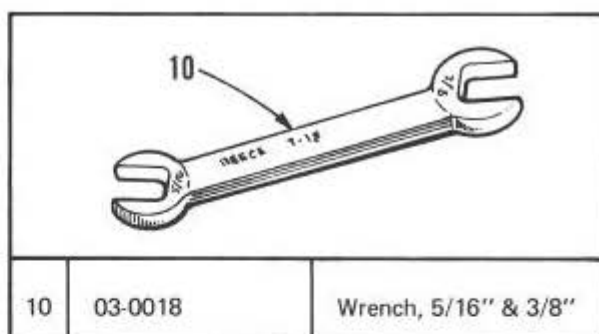
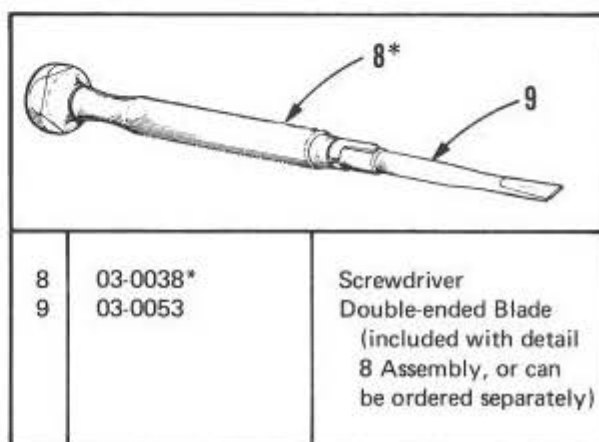
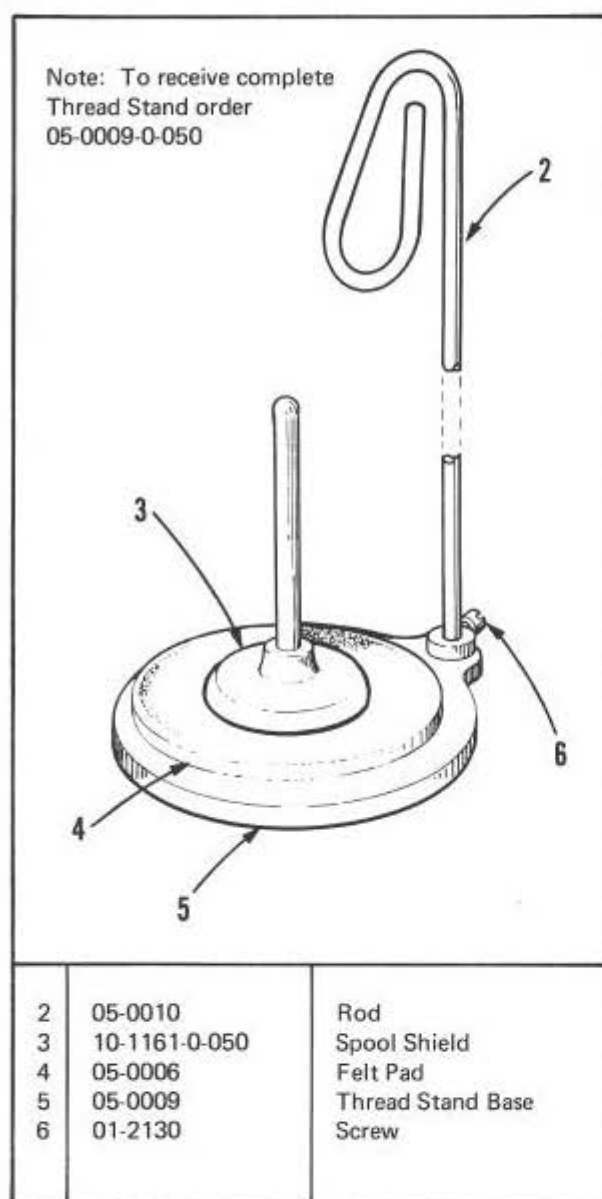
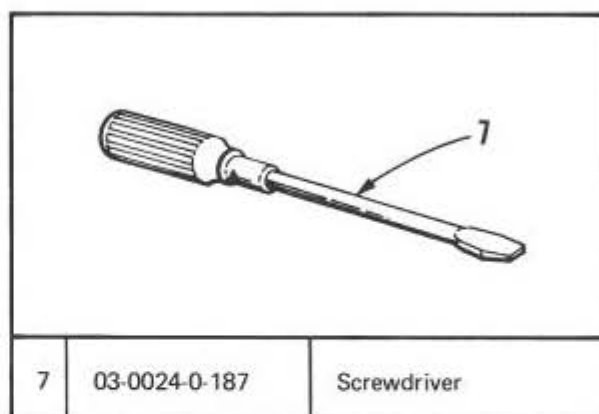
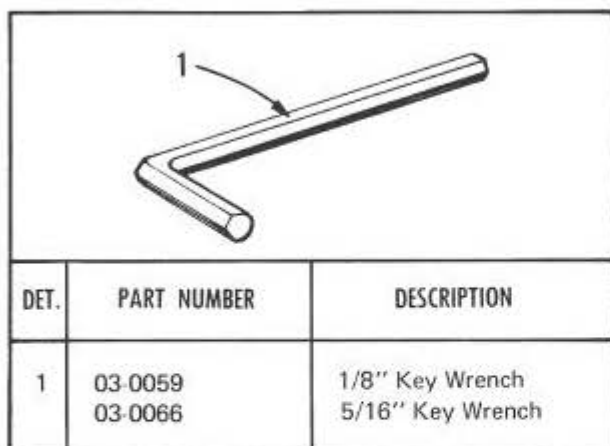
UNIVERSAL TABLE



*Available by the foot only.

TOOLS AND ACCESSORIES

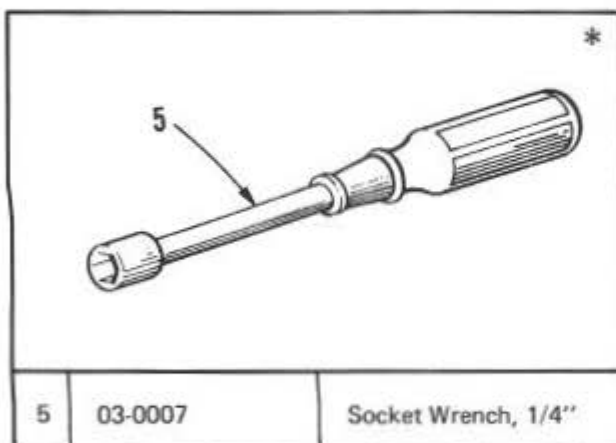
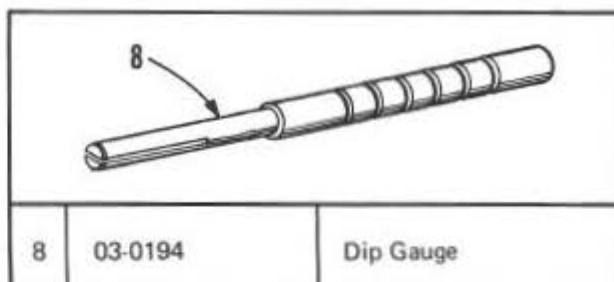
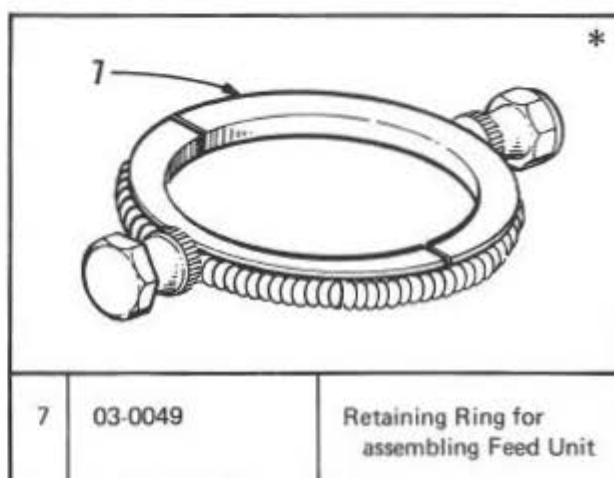
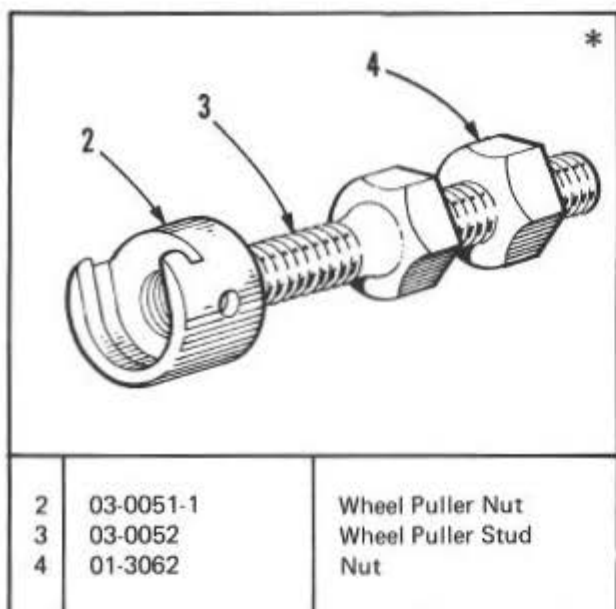
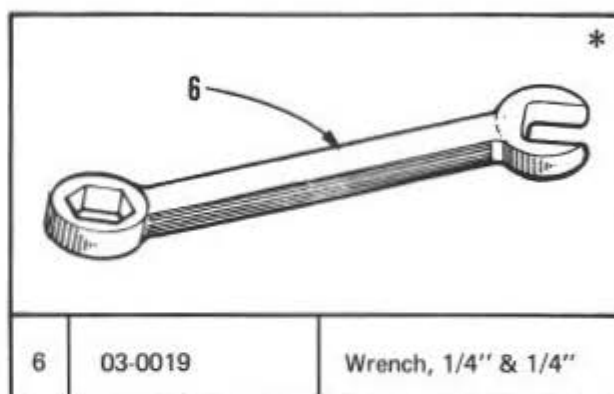
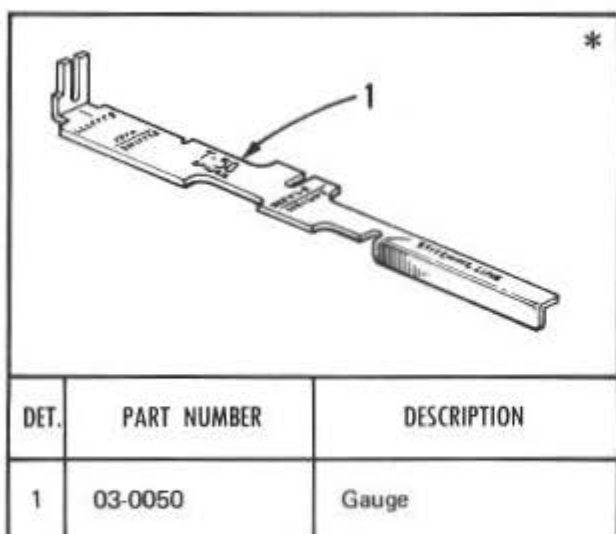
63



*Furnished as an Assembly.

64

TOOLS AND ACCESSORIES



*Optional Tools and Accessories.

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PARTS INDEX

PART NUMBER	PAGE	DET.	PART NUMBER	PAGE	DET.	PART NUMBER	PAGE	DET.
01-1000			01-1099-1	3	5	01-2013	12	1
01-1002	34	27	01-1103	4	16	01-2013	35	3
01-1002	37	27	01-1108	51	5	01-2015	36	5
01-1006	4	24	01-1112	38	12	01-2017	9	44
01-1031	15	23	01-1124	6	4	01-2017	21	26
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01-1038	4	10	01-1125	23	7	01-2019	17	8
01-1039	17	43	01-1125	33	23	01-2019	20	5
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01-1044	19	10	01-1134	17	34	01-2019	7	8
01-1045	19	22	01-1425	34	10	01-2020	21	16
01-1047	15	32	01-1425	37	14	01-2020	22	13
01-1047	28	2	01-1425	43	36	01-2020-0-001	25	11
01-1048	19	47	01-1430	3	14	01-2021	34	15
01-1051	15	14	01-1434	43	30	01-2021	37	19
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01-1057	10	16	01-1450	61	26	01-2027	60	19
01-1065-1	3	22	01-1451	62	58	01-2027-0-001	6	1
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01-1065-1	40	9	01-1463	40	12	01-2027-0-001	42	2
01-1065-1	42	5	01-1464	36	7	01-2027-0-001	48	7
01-1069	19	14	01-1496	19	43	01-2028	6	6
01-1071	17	44	01-1505	3	27	01-2039	15	1
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01-1074	4	19				01-2039	55	15
01-1094	10	1				01-2041	6	8
01-1096	17	15	01-2000			01-2041	17	7
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01-1097	37	31	01-2004	20	18	01-2044	26	20
01-1098	19	35	01-2004	38	7	01-2044	34	4
			01-2004	46	7	01-2044	38	15
						01-2045	6	25
						01-2045	15	18
						01-2045	42	21
						01-2046	52	13
						01-2046	56	3

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PARTS INDEX

PART NUMBER	PAGE	DET.
01-2050	21	4
01-2050	57	25
01-2052	11	5
01-2053	33	16
01-2059	22	19
01-2059	57	20
01-2075	13	12
01-2075	41	22
01-2075	42	28
01-2076	48	3
01-2077	52	29
01-2081	35	28
01-2083	53	1
01-2083	54	2
01-2084	13	15
01-2084	36	15
01-2093	51	13
01-2101	5	10
01-2103	31	37
01-2104	31	32
01-2104	32	17
01-2104	33	17
01-2104	35	19
01-2104	41	16
01-2104	42	30
01-2111	13	26
01-2115	61	32
01-2122	15	3
01-2122	19	30
01-2122	44	11
01-2122	48	12
01-2123	19	5
01-2124	43	19
01-2127	5	22
01-2128	20	2
01-2130	15	31
01-2130	63	6
01-2131	3	26
01-2131	5	19
01-2131	31	44

PART NUMBER	PAGE	DET.
01-2131	35	8
01-2131	41	6
01-2131	42	23
01-2136	30	18
01-2136	43	6
01-2137	31	24
01-2139	9	10
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01-2148	5	8
01-2149	4	11
01-2150	10	4
01-2150	15	9
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01-2150	48	18
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01-2160	17	2
01-2166	15	13
01-2170	5	15
01-2170	22	7
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01-2175	30	14
01-2189	52	32
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01-2193	2	7
01-2194	5	28
01-2195	52	8
01-2195	61	46
01-2274-0-001	26	22

PART NUMBER	PAGE	DET.
01-2302	51	1
01-2304	7	12
01-2304	15	27
01-2304	17	25
01-2304	36	19
01-2305	5	30
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01-2352	37	6
01-2352	41	29
01-2352	45	2
01-2352	47	35
01-2352	50	4
01-2355	13	20
01-2355	43	17
01-2359	17	3
01-2361	31	26

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PARTS INDEX

PART NUMBER	PAGE	DET.	PART NUMBER	PAGE	DET.	PART NUMBER	PAGE	DET.
01-3013	51	17	01-3402	19	24	01-4004	25	12
01-3016	5	2	01-3402	53	15	01-4004	51	6
01-3016	6	26	01-3402	55	17	01-4004	52	33
01-3016	11	23	01-3413	39	2	01-4004	62	61
01-3016	17	42	01-3413	43	4	01-4006	49	31
01-3016	34	28	01-3414	26	29	01-4006	51	7
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01-3016	44	14	01-3416	58	10	01-4011	4	6
01-3016	48	4	01-3421	53	7	01-4011	6	23
01-3020	17	18	01-3421	55	21	01-4011	11	17
01-3021	7	13	01-3422	3	18	01-4011	15	30
01-3021	15	28	01-3423	9	2	01-4011	17	30
01-3021	17	20	01-3426	3	3	01-4011	26	32
01-3021	36	20	01-3426	29	1	01-4011	30	15
01-3021	43	27	01-3426	31	42	01-4011	34	16
01-3025	17	39	01-3426	32	2	01-4011	37	20
01-3025	31	27	01-3426	40	10	01-4011	48	8
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01-3030	7	11	01-3428	56	10	01-4011	61	56
01-3037	2	17	01-3429	56	4	01-4013	4	22
01-3039	17	1	01-3429	60	1	01-4013	40	7
01-3039	19	27	01-3430	55	39	01-4017	2	18
01-3040	4	3	01-3430	62	68	01-4018	15	36
01-3040	22	18	01-3432	37	4	01-4018	53	6
01-3041	61	37				01-4018	55	22
01-3042	7	31				01-4019	5	12
01-3048	11	4				01-4019	22	20
01-3053	19	18				01-4019	53	14
01-3055	3	6				01-4019	55	16
01-3057	53	19						
01-3057	55	11				01-4024	21	27
01-3062	64	4				01-4026	51	15
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PARTS INDEX

PART NUMBER	PAGE	DET.	PART NUMBER	PAGE	DET.	PART NUMBER	PAGE	DET.
01-4037	21	24	01-4501	60	3	01-5111	9	4
01-4039	3	1	01-4502	61	33	01-5112	9	32
01-4043	51	14	01-4503	62	60	01-5112	28	3
01-4043	56	5	01-4509	55	27	01-5113	7	15
01-4043	60	2	01-4513	49	27	01-5116	22	23
01-4046	53	18	01-4514	49	33	01-5122	5	5
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01-4047	52	25	01-4516	49	38	01-5134	4	7
01-4049	51	16	01-4527	31	28	01-5143	6	20
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01-4054	61	35	01-4536	55	40	01-5148	10	15
01-4059	19	17	01-4672-0-001	19	25	01-5151	3	8
01-4059	44	2				01-5152	9	24
01-4061	55	36				01-5154	52	22
01-4062	11	1				01-5154	61	51
01-4062	3	15				01-5156	17	37
01-4063	11	15	01-5000			01-5157	6	16
01-4063	60	14				01-5158	21	29
01-4063	62	71				01-5161	7	28
01-4063	7	27	01-5004	3	2	01-5162	7	5
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01-4068	22	9	01-5038	19	49	01-5429	43	37
01-4402	40	19	01-5042	34	30	01-5429	48	9
01-4405	43	11	01-5042	37	30	01-5431	40	3
01-4406	3	24	01-5048	38	9	01-5431	43	20
01-4407	58	3	01-5052	9	16	01-5442	21	7
01-4420	31	25	01-5052	42	15	01-5445	43	3
01-4461	62	66	01-5057	36	4	01-5446	44	3
01-4466	56	12	01-5082	13	25	01-5449	11	22
01-4467	57	40	01-5098	3	17	01-5451	49	32
01-4468	56	9	01-5102	17	23	01-5452	48	13
01-4469	56	7	01-5106	15	35	01-5466	62	73
01-4471	57	29	01-5107	19	38	01-5469	9	56
01-4474	43	7	01-5108	11	3	01-5485	33	28
01-4500	60	6				01-5489	40	16

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PARTS INDEX

PART NUMBER	PAGE	DET.
01-5571	26	27
01-5571-0-001	26	17
01-6000		
01-6005	43	23
01-6015	6	17
01-6031	51	2
01-6038	42	14
01-6055	13	21
01-6055	46	2
01-6079	15	22
01-6090	2	13
01-6093	5	1
01-6096	20	27
01-6097	20	28
01-6101	5	16
01-6103	13	18
01-6103-0-001	26	14
01-6105	19	12
01-6106	19	15
01-6108	15	24
01-6115	5	20
01-6121	11	16
01-6121	17	32
01-6121	19	8
01-6121	34	22
01-6121	52	7
01-6121	61	57
01-6122	11	14
01-6123	52	26
01-6131	52	15
01-6135	19	33
01-6135	29	13
01-6137	52	14

PART NUMBER	PAGE	DET.
01-6147	52	5
01-6147	61	55
01-6186	11	18
01-6186	4	8
01-6165	15	34
01-6195	9	35
01-6196	28	7
01-6196	9	33
01-6197	10	3
01-6300	3	11
01-6303	11	11
01-6306	17	33
01-6311	9	26
01-6312	9	47
01-6313	9	39
01-6314	22	4
01-6327	22	5
01-6338	41	13
01-6340	11	20
01-6344	6	5
01-6362-1	7	2
01-6406	19	7
01-6406	34	21
01-6406	44	8
01-6507	43	21
01-6508	19	6
01-6508	34	33
01-6508	44	7
01-6511	34	19
01-6511	44	4
01-6513	42	19
01-6534	21	8
01-6542	52	24
01-6550	25	2
01-6551	58	15
01-6574	19	21
01-6579	61	30
01-6580	61	29
01-6581	62	77
01-6582	62	78
01-6587	9	55

PART NUMBER	PAGE	DET.
01-6590	9	11
01-6590-0-001	26	23
01-6595	49	37
01-6603	38	13
01-6631	40	17
01-6822	19	48
01-6831	7	25
01-6833	4	2
01-6833	15	19
01-6833-0-001	6	27
01-6833-0-001	26	18
01-6839-2	6	19
01-7000		
01-7012	4	12
01-7013	4	4
01-7013	5	9
01-7013	15	25
01-7016	21	25
01-7017	3	21
01-7018	4	20
01-7022	4	25
01-7029	17	16
01-7037	22	6
01-7039	7	7
01-7048-0-002	46	14
01-7453	34	23
01-7453	37	23
01-7467	49	29
01-7472	55	30
01-7480	40	22
01-7480	42	3
01-7480-0-001	6	14
01-7480-0-001	30	10
01-7480-0-001	32	13

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PARTS INDEX

PART NUMBER	PAGE	DET.
01-7481	40	11
01-7535	19	44
01-7536	19	45
01-8000		
01-8002	9	41
01-8002	21	15
01-8002-0-001	28	9
01-8005	17	26
01-8405	11	28
01-8405	45	5
01-8405	50	6
02-0000		
02-0750	1	
02-0751	1	
02-0752	1	
02-0753	1	
02-0754	1	
03-0000		
03-0007	64	5
03-0018	63	10
03-0019	64	6
03-0022	64	12
03-0024-0-187	63	7
03-0038	63	8

PART NUMBER	PAGE	DET.
03-0045	63	11
03-0049	64	7
03-0050	64	1
03-0051-1	64	2
03-0052	64	3
03-0053	63	9
03-0059	63	1
03-0066	63	1
03-0194	64	8
04-0000		
04-0003-0-050*	53	16
04-0003-0-050*	55	7
04-0013	51	19
04-0014	51	19
04-0016	53	3
04-0016	55	4
04-0062-1	55	24
04-0065-1	55	8
04-0083	60	18
04-0084-0-801	55	25
04-0084-0-802	55	26
04-0087	58	7
04-0087	62	83
04-0089	21	9
04-0089	57	16
04-0090	57	18
04-0091	57	19
04-0092	57	31
04-0093	56	13
04-0094	57	34
04-0095	56	14
04-0096-1	56	15
04-0097	57	21
04-0098-2	56	6
04-0099	56	8

PART NUMBER	PAGE	DET.
04-0100-0-050	57	27
04-0101-1-811	57	28
04-0101-1-812	57	28
04-0101-1-813	57	28
04-0101-1-814	57	28
04-0101-1-815	57	28
04-0102	57	24
04-0103-0-001	57	35
04-0103-0-008	57	37
04-0103-0-110	57	37
04-0103-0-205	57	37
04-0103-0-520	57	37
04-0103-0-580	57	37
04-0106	57	38
04-0107	56	1
04-0111	58	16
04-0112-0-115	55	28
04-0112-1-115	55	28
04-0112-0-179	55	28
04-0112-0-180	55	28
04-0112-0-195	55	28
04-0112-0-196	55	28
04-0112-0-230	55	28
04-0112-1-230	55	28
04-0113-1	55	33
04-0116	57	17
04-0117	58	8
04-0118	58	11
04-0119	21	10
04-0121	53	9
04-0121	55	37
04-0122	55	32
04-0123	62	67
04-0126	54	3
04-0132	55	37
04-0136	53	4
04-0136	55	31
04-0137	53	4
04-0137	55	31
04-0141	53	8
04-0141	55	38

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PARTS INDEX

PART NUMBER \	PAGE	DET.
04-0142	53	8
04-0142	55	38
04-0143	53	10
04-0143	55	19
04-0151	60	17
04-0152	60	23
04-0153	61	38
04-0154	61	36
04-0155	61	24
04-0156	60	7
04-0157	60	11
04-0158	60	5
04-0159	60	15
04-0160	56	6
04-0161	60	16
04-0162	61	41
04-0165	61	25
04-0166	61	31
04-0167	61	28
04-0168	57	26
04-0169	61	52
04-0170-1	61	53
04-0171	60	20
04-0172	60	21
04-0175	60	22
04-0176	61	42
04-0177	60	18
04-0178	60	10
04-0179	62	80
04-0180	62	79
04-0181	62	72
04-0182	62	59
04-0183	55	13
04-0183-0-050	53	11
04-0183-0-051	54	1
04-0184	62	65
04-0187	53	12
04-0187	55	14
04-0207	53	2
04-0207	55	23

PART NUMBER	PAGE	DET.
04-0220	55	18
04-0222	61	39
04-0298	61	44
04-0299-0-050	61	45
04-0329	55	6
04-0439	61	50
04-0496	14	11
04-0536	52	12
04-0537	21	2
04-0537	52	11
04-0538	21	1
04-0539	52	31
04-0540	52	36
04-0542	52	16
04-0558	52	17
04-0594	55	12
04-0701	52	10
04-0702	52	2
04-0704-1	52	4
04-0704-1	61	54
04-0722-0-258	51	10
04-0722-0-268	51	10
04-0722-0-294	51	10
04-0722-0-308	51	10
04-0747-2	9	28
04-0748	52	27
04-0749	52	23
04-0751	51	11
04-0752	51	12
04-0753-0-801	51	4
04-0754-1	51	9
04-0758	52	21
04-0759	52	19
04-0760	9	27
04-0760	52	28
04-0761	52	1
04-0761	61	49
04-0762	52	20
04-0763	52	18
04-1061	60	9

PART NUMBER	PAGE	DET.
04-2040	14	1
04-2041	14	13
 05-0000		
05-0006	63	4
05-0009	63	5
05-0010	63	2
05-0042-2	22	14
05-0043	2	14
05-0090	64	9
05-0091	64	10
05-0101	64	13
05-0102-0-335	51	21
05-0102-1-335	51	21
05-0102-0-340	51	21
05-0102-1-340	51	21
05-0369	57	36
05-0374	64	11
05-0417-1	55	34
 06-0000		
06-0098-0-001	62	76
06-0173	53	4
06-0173	55	31

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PARTS INDEX

PART NUMBER	PAGE	DET.	PART NUMBER	PAGE	DET.	PART NUMBER	PAGE	DET.
07-0000			20-0013-0-002	31	49	20-0051-0-015	29	4
			20-0013-0-006	34	9	20-0051-0-020	50	2
			20-0013-0-006	37	16	20-0051—	13	Chart all types
07-0003-0-001	14	6	20-0013-1-006	43	35			
			20-0014	2	16			
			20-0015	19	11	20-0051-0-078	36	16
			20-0016	5	13	20-0051-1-002	31	33
			20-0016	22	1	20-0051-1-007	32	18
			20-0019-0-100	5	32	20-0051-1-007	33	18
			20-0020-2	5	31	20-0051-1-303	38	5
10-0000			20-0021-0-100	4	26	20-0051-2-004	35	18
			20-0021-1-100	5	26	20-0051-2-004	41	20
			20-0022-1	2	10	20-0051-2-004	42	31
			20-0022-1-100	5	23	20-0052	22	22
			20-0024-2	4	18	20-0053-2	9	20
10-1116	9	15	20-0029-2-100*	5	27	20-0054	3	12
10-1161-0-050	63	3	20-0030-1	17	22	20-0062-2	3	23
10-2002	38	10	20-0031	17	27	20-0066	10	14
10-2054	30	19	20-0032-1	17	21	20-0070-3	9	36
10-4019	19	39	20-0033	17	24	20-0071-2	10	10
10-4221	3	16						
			20-0035	17	28	20-0072-1	10	8
			20-0036	17	19	20-0074-3	9	43
			20-0038	4	15	20-0074-3	10	9
			20-0039-0-001	28	10	20-0079-0-850	5	30
			20-0039-1	9	29	20-0079-0-850	10	6
20-0000								
			20-0040-2	9	21	20-0082-1	10	11
20-0001-0-003	47	29	20-0041	4	17	20-0085-2	20	26
20-0001-1	2	4	20-0042-0-100	9	45	20-0086-1	7	23
20-0005-0-102*	31	39	20-0043-1	4	14	20-0086-1	20	16
20-0587	2	5	20-0043-1	10	13	20-0092-0-004	7	9
20-0588	2	6						
			20-0044*	9	23	20-0092-0-004	13	13
20-0005-0-811*	2	1	20-0045	9	46	20-0092-0-004	20	15
20-0006	4	1	20-0046	9	48	20-0092-0-004	41	26
20-0007	2	19	20-0047-2	4	13	20-0092-0-004	42	27
20-0008	2	3	20-0047-2	10	19	20-0093-0-004	13	11
20-0009	11	13						
			20-0048-0-100*	9	37	20-0093-0-004	20	19
20-0010	11	19	20-0049	9	38	20-0093-0-004	41	27
20-0011	4	9	01-6313	9	39	20-0093-0-004	42	32
20-0011	10	18	20-0049	9	38	20-0093-1-004	7	10
20-0012	15	16	20-0051-0-003	46	5	20-0094-1	20	8
20-0013	19	34						

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PARTS INDEX

PART NUMBER	PAGE	DET.	PART NUMBER	PAGE	DET.	PART NUMBER	PAGE	DET.
20-0094	20	8	20-0180	19	29	20-0196-1-336	26	12
20-0096-1-100	17	6	20-0180-0-032	34	13	20-0196-1—	13	Chart all types
20-0096-1-100	20	23	20-0180-1-005	44	10			
20-0098-2-100	20	24	20-0190-0-001	26	33	20-0196-1-337	26	11
20-0106-1	20	1	20-0190-0-032	35	13			
20-0107-2	20	3	20-0190-0-032	43	24	20-0197-0-029	12	5
20-0110-1	20	20	20-0190-1	13	22	20-0197-0-035	12	5
20-0115-2	20	10	20-0190-1	49	39	20-0208-0-003	46	6
20-0116-3	20	9	20-0190-1-011	30	12	20-0208-0-070	49	42
20-0118-3	20	12	20-0190-1-011	32	14	20-0208-0-071	38	3
20-0119-2	20	11	20-0190-1-011	33	13	20-0208-0-071	49	46
20-0122-1-100	17	5	20-0190-1-011	41	10	20-0208-0-232	35	17
20-0133-0-100	19	2	20-0194	30	1	20-0208-0-332	35	17
20-0133-0-105*	44	9	20-0194	49	25	20-0208-0-501	31	30
20-0133-0-116*	37	5	20-0194-0-003	49	26	20-0208-0-502	31	30
20-0133-1-105*	34	20	20-0194-0-005	26	9	20-0208-1-204	41	18
20-0134-1	17	29	20-0194-0-052	23	2	20-0208-1-215	29	6
20-0135-2	17	31	20-0194-0-052	30	1	20-0208-1-304	41	18
20-0166	17	10	20-0194-0-176	14	2	20-0208-1-315	29	6
20-0166	44	5	20-0194-1-004	26	8	20-0208-1—	13	Chart all types
20-0166-0-015	29	10	20-0194-1-032	35	2			
20-0166-0-015	31	46	20-0194-1-043	12	3	20-0208-1-324	36	12
20-0166-0-015	32	24	20-0194-1-052	12	3	20-0208-1-415	29	6
20-0166-0-015	33	29	20-0196-0-032	35	5	20-0210-0-002	30	6
20-0166-0-015	34	3	20-0196-0-033	35	30	20-0210-0-008	33	15
20-0166-0-015	37	11	20-0196-0-228	47	31	20-0210-0-015	25	3
20-0166-0-015	38	1	20-0196-0-228	49	45			
20-0166-0-015	41	28	20-0196-0-234	47	31	20-0210-0-075	12	6
20-0166-0-015	45	1	20-0196-0-328	47	31	20-0210-0-078	36	13
20-0166-0-015	47	34	20-0196-0-334	47	31	20-0210-1-003	47	32
20-0166-0-015	50	3	20-0196-0-336	38	4	20-0210-1-003	49	41
20-0167-1	17	11	20-0196-0-352	23	3	20-0210-1-004	35	22
20-0169	17	9	20-0196-0-502	30	2			
20-0169	37	12	20-0196-0-502	31	21	20-0210-1-004	41	25
20-0169-0-016	37	1	20-0196-0-504	41	19	20-0210-1-004	42	26
						20-0210-1-007	32	19
						20-0210-2	12	6
20-0172	17	13	20-0196-0-569	49	44	20-0210-2	15	6
20-0173	17	14	20-0196-0-604	41	19			
20-0174-0-032	34	32	20-0196-0-659	49	44	20-0214	13	10
20-0174-0-032	44	6	20-0196-1-330	26	12	20-0214-0-001	25	5
20-0174-1	19	26	20-0196-1-331	26	11	20-0214-0-002	30	8
						20-0214-0-175	13	10
						20-0214-0-275	13	10

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PARTS INDEX

PART NUMBER	PAGE	DET.
20-0214-0-502	30	8
20-0214-1-003	47	33
20-0214-1-007	32	9
20-0214-1-007	33	8
20-0222-1	15	15
20-0225-1	15	11
20-0230-0-032	34	34
20-0230-0-032	37	32
20-0230-1-850	15	2
20-0236	19	13
20-0236-0-001	19	13
20-0236-0-003	43	39
20-0236-0-005	43	39
20-0240-0-015	29	11
20-0240-0-015	33	32
20-0240-0-015	37	8
20-0240-0-015	41	31
20-0240-0-015	47	38
20-0240-0-016	37	7
20-0240-0-032	34	5
20-0240-0-050	31	50
20-0240-0-050	32	27
20-0240-0-052	19	16
20-0240-0-055	28	1
20-0240-0-405	43	31
20-0240-0-605	43	31
20-0240-0-705	43	31
20-0240-1	19	16
20-0240-1	31	50
20-0241-1	19	20
20-0241-1-006	43	32
20-0243-1-006	43	29
20-0243-2	19	9
20-0243-2	34	2
20-0246	19	23
20-0251-1-100	15	26
20-0254	15	12
20-0258-1*	19	46
01-3402	19	24
01-4672-0-001	19	25
01-1496	19	43
01-7535	19	44
01-7536	19	45

PART NUMBER	PAGE	DET.
20-0263	19	42
20-0266	19	36
20-0268	19	37
20-0271-3	11	25
20-0276-0-002	31	51
20-0276-0-013	37	9
20-0276-1-004	29	9
20-0276-1-004	34	6
20-0276-1-004	41	30
20-0276-1-017	32	26
20-0276-1-017	41	30
20-0276-2-004	44	13
20-0276-2-011	50	8
20-0276-2-815	45	3
20-0276-2-815	47	36
20-0276-3-801	11	7
20-0276-3-801	33	31
20-0276-3-801	38	16
20-0277-1	11	26
20-0278-1	11	27
20-0278-1-020	50	7
20-0278-1-039	45	4
20-0278-1-041	11	27
20-0278-1-073	38	14
20-0278-2-003	47	37
20-0280-0-332	43	16
20-0281	11	29
20-0281	13	17
20-0281-0-004	29	8
20-0281-0-004	32	28
20-0281-0-004	33	33
20-0281-0-004	34	14
20-0281-0-004	41	32
20-0281-0-004	44	12
20-0288	11	6
20-0288-0-002	31	52
20-0288-0-002	43	40
20-0290-1	11	10
20-0308-1	19	50
20-0309-1-100*	9	34
01-6196	9	33

PART NUMBER	PAGE	DET.
20-0309-1-100*	28	6
01-6196	28	7
20-0312	5	3
20-0312	9	3
20-0313	9	5
20-0316	9	7
20-0317-0-100*	9	12
20-0318	9	31
20-0070-3	9	36
20-0317-0-904	28	8
20-0318	9	31
20-0318-0-001	28	5
20-0320-1	7	16
20-0320-1	9	19
20-0321	6	18
20-0323-0-001	26	13
20-0323-1	7	22
20-0328	6	10
20-0328-0-001	26	24
20-0332-0-001	26	19
20-0332-2	6	15
20-0332-2	9	9
20-0332-2	13	23
20-0332-2	35	11
20-0332-2	42	18
20-0343-4	9	52
20-0343-4-100*	9	40
20-0343-4	9	52
01-2338	9	53
20-0716	9	54
01-6587	9	55
01-5469	9	56
20-0344	22	18
20-0345-0-100	22	15
20-0346-2	22	16
20-0348-1-811	22	3
20-0351-1-801	5	14
20-0356-0-003	46	4
20-0356-0-003	48	23
20-0356-1-049	6	3
20-0356-1-050	6	3
20-0356-1-051	6	3

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4-11

PARTS INDEX

PART NUMBER	PAGE	DET.	PART NUMBER	PAGE	DET.	PART NUMBER	PAGE	DET.
20-0356-1-052	6	3	20-0397-0-015*	25	4	20-0608-0-015	40	20
20-0356-1-052	38	2	20-0397-1-011*	46	20	20-0680-0-015	42	4
20-0356-1-053	6	3	20-0398-3	21	12	20-0608-1-002	31	43
20-0356-1-054	6	3	20-0398-4-801	25	10	20-0608-1-002	32	10
20-0356-1-055	6	3	20-0566	15	5	20-0609	5	29
20-0356-1-056	6	3	20-0567	10	12	20-0609	15	7
20-0356-1-057	6	3	20-0569	20	4	20-0610	15	8
20-0356-1-058	6	3	20-0570	20	6	20-0611	4	23
20-0356-1-059	6	3	20-0571	6	9	20-0613	7	14
20-0356-1-060	6	3	20-0571-0-003	46	18	20-0623	10	7
20-0357-0-007*	29	3	20-0577	20	13	20-0624	20	17
20-0357-0-007*	30	11	20-0580	17	38	20-0633	15	29
20-0357-0-007*	32	11	20-0582	17	40	20-0634	15	21
20-0357-0-007*	33	12	20-0583	6	24	20-0638	7	29
20-0357-0-007*	35	1	20-0583-0-001	26	31	20-0639-1	7	26
20-0357-0-007*	36	9	20-0584	5	18	20-0641-2	7	1
20-0357-0-007*	41	9	20-0584-0-003	46	21	20-0643-1		6
20-0357-0-007*	42	1	20-0584-1-001	25	1	20-0645	7	17
20-0357-0-007*	50	1	20-0585-0-002	25	6	20-0646-1	7	3
20-0357-0-008*	6	11	20-0585-0-075	22	2	20-0647	29	12
20-0357-0-009*	48	1	20-0585-0-811	22	2	20-0647-1-020	50	5
20-0357-1-006*	26	1	20-0586-0-001	25	9	20-0648-0-997	41	24
20-0357-1-009*	46	1	20-0586-0-075	9	13	20-0648-0-998	41	24
20-0358	6	7	20-0586-1	9	13	20-0648-1-006	42	10
20-0358-0-003	46	19	20-0587	2	5	20-0648-2	41	24
20-0360-0-001	26	2	20-0588	2	6	20-0649-0-041	23	1
20-0360-0-003	46	17	20-0590	13	28	20-0649-0-041	33	1
20-0360-1	6	21	20-0591	13	29	20-0649-0-042	32	3
20-0376-0-850	22	8	20-0595-1	3	4	20-0649-0-042	33	2
Head and Bedplate Assembly*			20-0596	22	25	20-0649-0-048	26	5
20-0397-0-010*	5	17	20-0598-2	22	26	20-0649-0-705	43	1
20-0351-1-801	5	14	20-0598-2	60	4	20-0649-1—	39	Chart all types
01-6115	5	20	20-0602	3	13	20-0649-1-405	43	1
Head and Bedplate are furnished only as a factory assembled unit.			20-0603	3	7	20-0649-1-605	43	1
20-0397-0-012*	35	12	20-0604	5	24	20-0650—	39	Chart all types
20-0397-0-012*	41	8	20-0605	5	25	20-0650-0-242	32	20
20-0397-0-012*	42	9	20-0606	13	24	20-0650-0-311	33	10
20-0397-0-013*	32	15	20-0607-2	3	25	20-0650-0-401	23	4
20-0397-0-013*	33	14	20-0607-2	31	40	20-0650-0-401	26	7
			20-0608-0-015	3	20	20-0650-1-406	43	15
			20-0608-0-015	29	2			

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PARTS INDEX

PART NUMBER	PAGE	DET.	PART NUMBER	PAGE	DET.	PART NUMBER	PAGE	DET.
20-0650-0-606	43	15	20-0670-1	48	20	20-0703	9	22
20-0650-0-706	43	15	20-0671	46	10	20-0704	37	10
20-0650-1—	39	Chart all types	20-0673	46	12	20-0704-0-002	31	47
			20-0673	49	40	20-0707-0-502	30	3
			20-0674	46	9	20-0708	31	20
20-0651-0—	39	Chart all types	20-0677	43	25	20-0708-0-501	31	20
			20-0678	43	18	20-0708-0-502	31	20
20-0652-1-078	36	14	20-0679-1	43	22	20-0709-0-502	31	23
20-0652-2	35	9	20-0680	43	13	20-0709-1	31	23
20-0652-2	41	3				20-0710	30	16
20-0652-2	42	8	20-0681	42	20	20-0710-0-502	30	16
20-0653	35	21	20-0682	34	11	20-0711	30	5
20-0653	41	23	20-0682	37	17	20-0713	31	45
20-0653	42	24	20-0682	43	38	20-0715	9	49
20-0653-0-007	32	7	20-0683	34	7	20-0716	9	54
20-0653-0-007	33	6	20-0683	37	15	20-0722-0-063	13	31
20-0654	32	4	20-0683	43	33	20-0722-0-064	13	32
20-0654	33	3	20-0684	3	10	20-0727	48	6
20-0654	35	7	20-0687	21	14	20-0728	48	5
20-0654	41	5	20-0688	21	5	20-0729	48	11
20-0654	42	25	20-0689	21	20	20-0730	48	14
20-0655-0-039	13	14	20-0690	21	18	20-0731	49	35
20-0655-0-041	35	20	20-0691-1	60	12	20-0732	49	34
20-0655-0-041	41	21	20-0691-1-100	21	28	20-0733	47	26
20-0655-0-041	42	29	20-0692-1	21	21	20-0733	48	19
20-0655-0-042	32	23	20-0693	35	23	20-0734	38	6
20-0656	41	14	20-0694	35	29	20-0746	14	4
20-0658	35	14	20-0695	35	27	20-0747	26	10
20-0658	41	1	20-0696	21	3	20-0748-0-155	33	25
20-0658	42	11	20-0697	37	2	20-0748-0-157	33	26
20-0660	17	36	20-0698	13	27	20-0748-0-159	33	27
20-0661	17	35	20-0699	34	26	20-0749	40	24
20-0667-0-988	33	11	20-0699	37	26	20-0750	40	15
20-0667-0-989	33	21	20-0700	34	25	20-0751	40	13
20-0667-0-993	32	21				20-0752	40	14
20-0667-0-994	32	21	20-0700	37	25	20-0753	40	1
20-0667-0-995	32	21	20-0701	34	17	20-0754	40	2
20-0667-0-996	32	21	20-0701	37	21	20-0755	40	6
20-0669-1	47	23	20-0702	34	12	20-0756	36	2
20-0669-1	48	17	20-0702	37	18	20-0757	36	3
20-0670-1	47	27						

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PART NUMBER	PAGE	DET.