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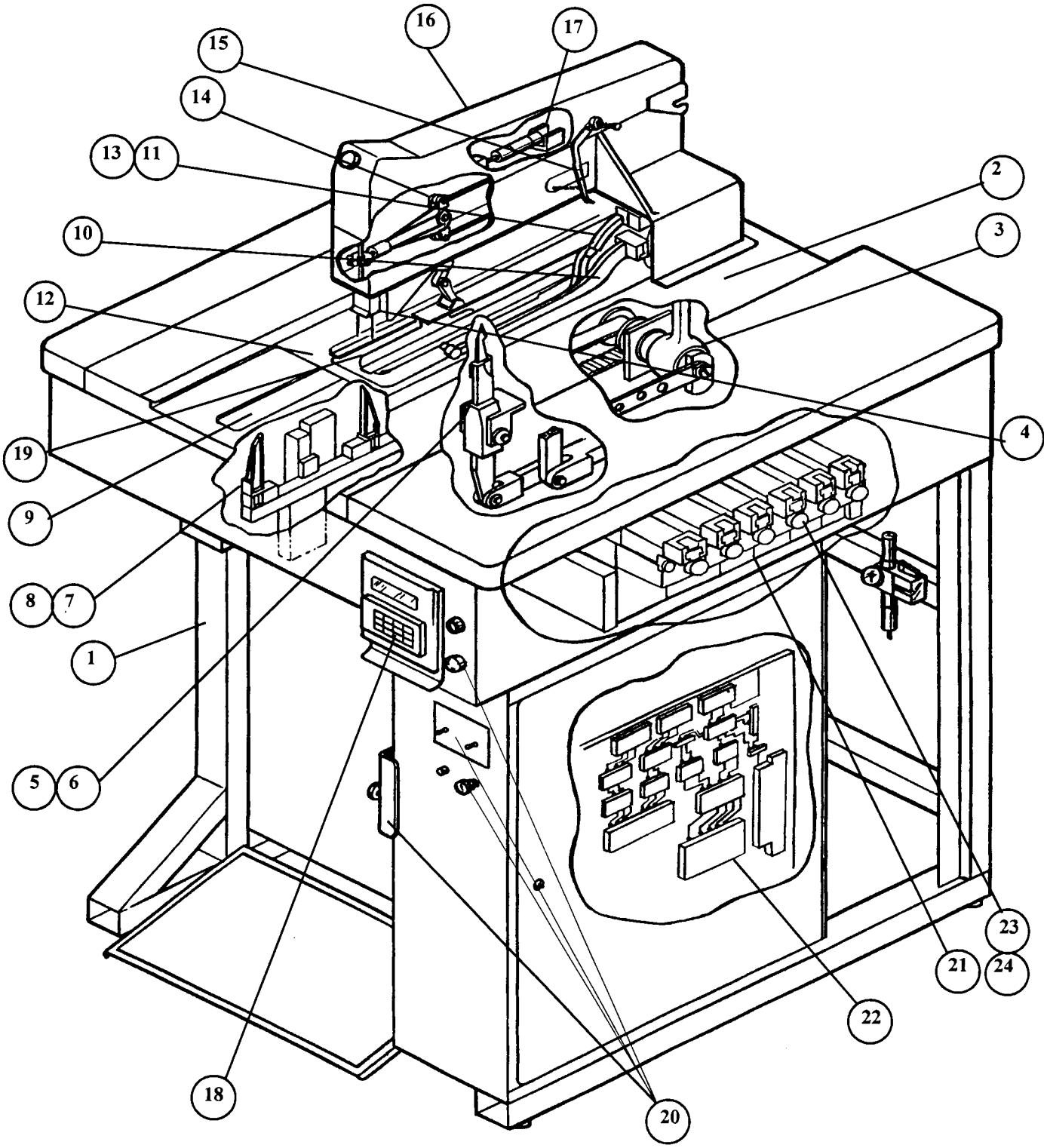

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FINAL ASSEMBLY

ITEM	ASS'Y NO.	DESCRIPTION	PAGE
1	7000	Frame Assembly	3-4
2	7005	Bedplate Assembly	3-8
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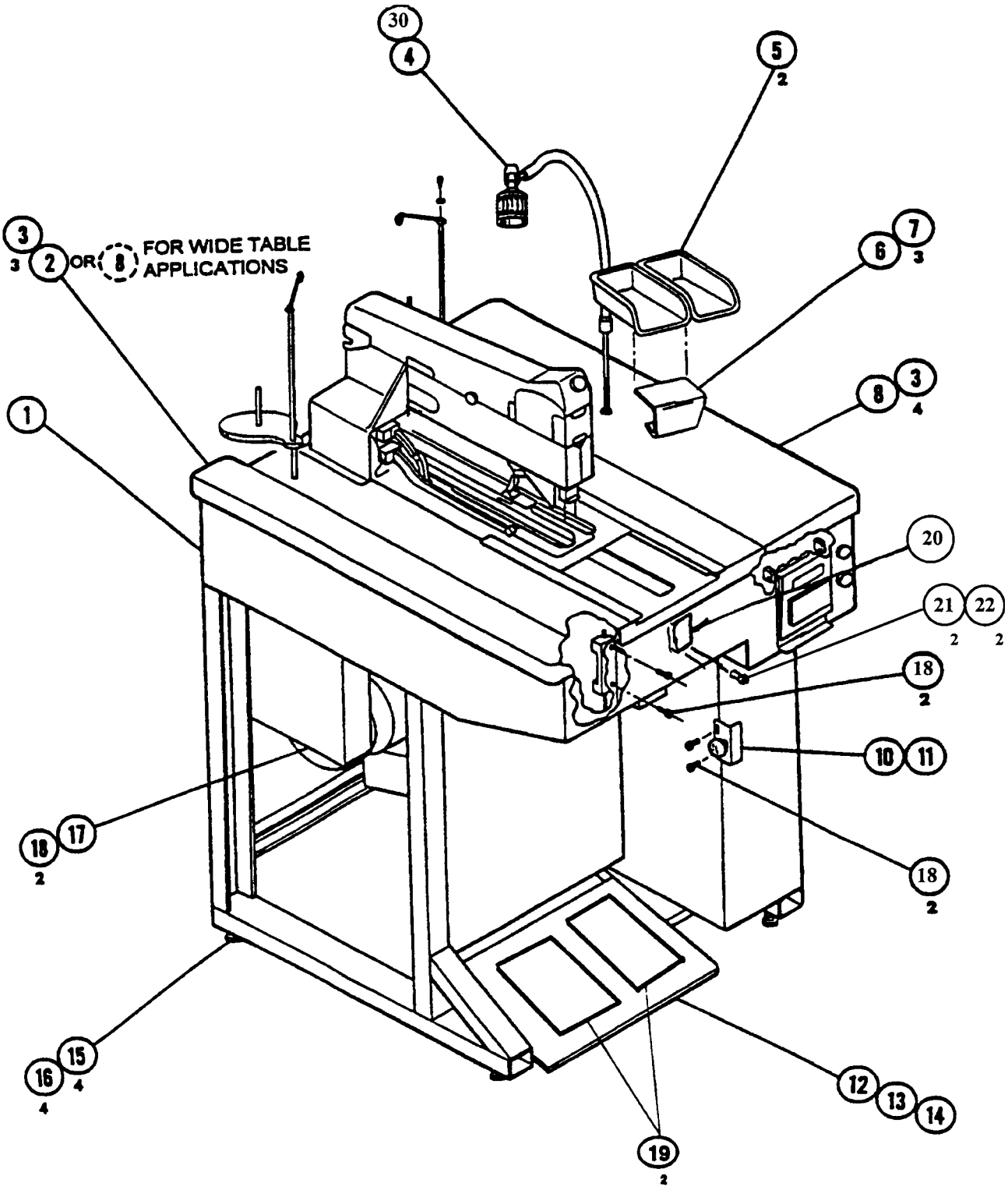
FRAME ASSEMBLY



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FRAME ASSEMBLY

ITEM	PART NUMBER	DESCRIPTION	QTY.
1	32.7102.0.000	Frame Weldment	1
2	32.7113.0.000	Left Hand Table Top	1
3	01.1658.0.001	# 5/16-18 x .75 Hex hd. Screw	7
4	07.6004.0.800	12V Table Light (KIT)	OPT.
5	See Chart	Patch Tray	2
6	42.0932.1.850	Base Assembly	1
7	01.2616.0.000	# 10 x .75 pan Hd. Screw	3
8	32.7104.0.000	Right Hand Table Top	1
10	32.7164.0.000	Sit Down Knee Switch Bracket	1
11	32.7165.0.000	Stand Up Knee Switch Bracket	1
12	32.7105.0.000	Treadle	1
13	07.6040.0.001	7/8 Set Collar	1
14	03.6852.9.114	# 7/8 Flat Washer	1
15	07.6560.0.000	# 1/2 - 13 Leveling Foot	4
16	01.3546.0.000	# 1/2 -13 Hex Nut	4
17	32.7108.0.000	Drive Belt Guard	1
18	03.6200.1.108	# 1/4-20 x 1/2 Button Hd. Screw	4
19	42.0925.0.000	Safety Pad	2
20	32.7209.0.003	Draw Latch	1
21	01.2413.0.000	#6-32 x 3/8 HSC Screw	2
22	01.3508.0.000	#6-32 Hex Nut	2
30	07.6004.0.003	12 V / 20 W Bulb (Spare Parts)	-
31	07.6004.0.004	12V 12W Bulb	
32	01.4581.0.000	Lock Washer	7
33	37711017	Serial Plate	1
34	01.1574.0.001	Screw	3
35	01.2695.0.000	Screw	2
36	03.5285.0.000	Eye Guard Kit	1
37	27461103	Clamp, CBL	1
38	32.7103.0.000	Table, Left Top	1
39	32.7204.0.000	Guard, Belt	1
40	32.7209.0.000	Draw Latch	1

Spacing Charts begin on page 3-50.

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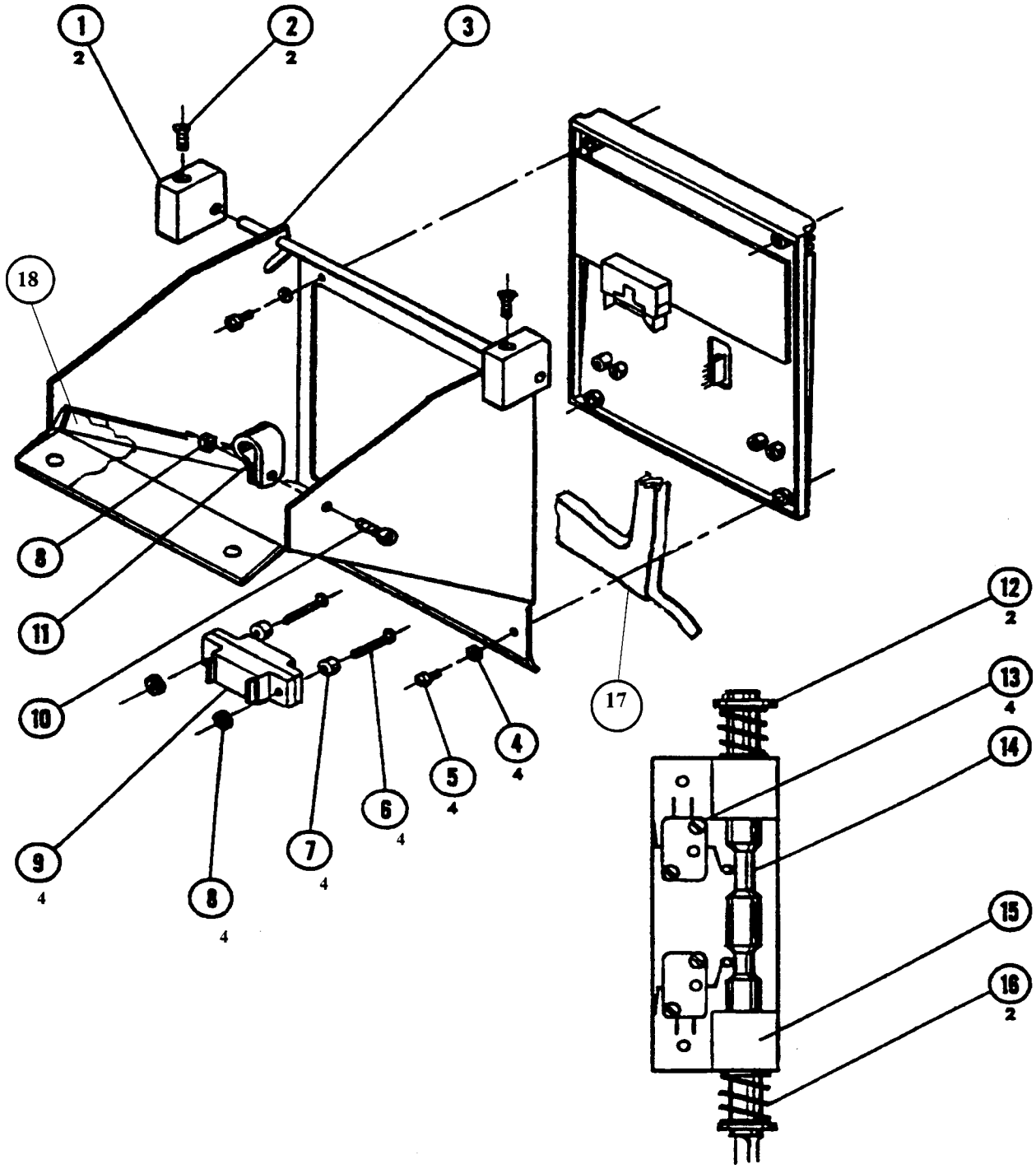
KEYPAD AND SWITCH MOUNT DETAILS



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KEYPAD AND SWITCH MOUNT DETAILS

ITEM	PART NUMBER	DESCRIPTION	QTY.
1	32.7161.0.000	Bearing Block	2
2	01.2416.0.000	#8-32 x .50 Flat Hd. Screw	2
3	32.7162.0.000	Keypad Mount	1
4	03.6802.3.000	M3 Lock Washer	4
5	01.1393.0.003	M3 x 10 Screw	4
6	03.6100.6.114	#6-32 x .88 Flat Hd. Screw	4
7	07.6680.0.000	Spacer	2
8	01.3455.0.000	#6-32 Hex Lock Nut	6
9	07.6000.0.000	Cabinet Magnet	2
10	01.2413.0.000	#6-32 x 3/8 Screw	2
11	07.6600.0.003	Cable Clamp	1
12	07.6760.0.000	Retaining Ring	2
13	03.6222.4.108	#4-40 x .50 Bind. Hd. Screw	4
14	32.7107.0.000	Actuator	1
15	32.7106.0.000	Foot Switch Mount	1
16	07.6440.0.014	Spring	2
17	32.7207.0.000	Static Shield	1
18	32.7205.0.000	Keyboard Cover	1
19	27861-605	Cable for Key Pad	
20	07.6600.0.004	Clamp Cable	1
21	01.4411.0.000	Washer	1
22	01.1574.0.001	Screw # 8-32 x 3/8 Button Hd.	2

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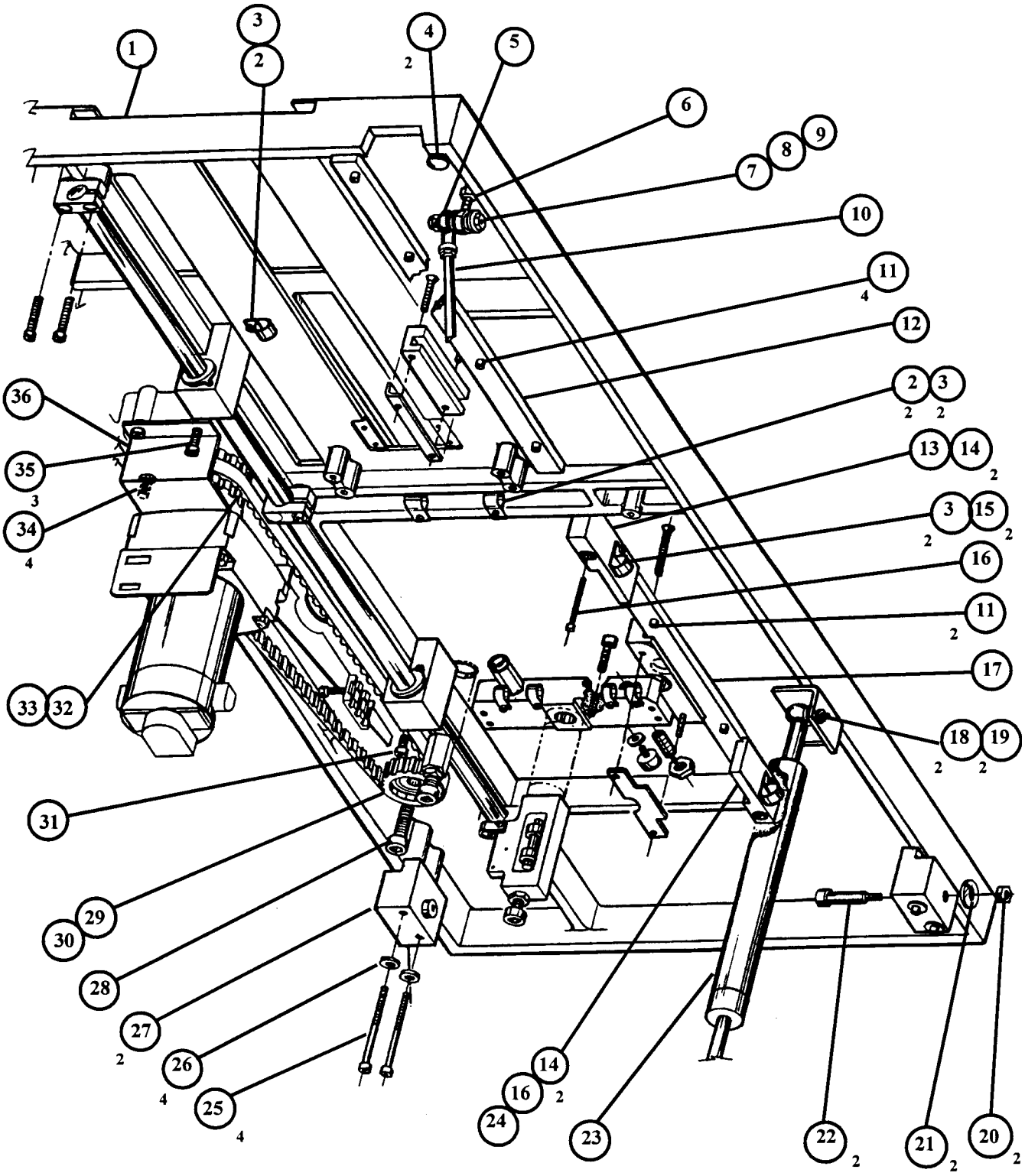
BEDPLATE ASSEMBLY



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BEDPLATE ASSEMBLY

ITEM	PART NUMBER	DESCRIPTION	QTY.
1	32.7100.0.000	Bedplate	1
2	07.6600.0.007	9/16 Cable Clamp	3
3	01.1574.0.001	#8-32 x 3/8 Button Hd. Screw	5
4	07.6481.0.000	Bumper	2
5	07.6481.0.002	Female Rod End Bearing	1
6	07.6481.0.001	Male Rod End Bearing	1
7	03.6301.7.120	#5/16-18 x 1.2 Screw	1
8	01.4581.0.000	#5/16 Lock Washer	2
9	01.3549.0.000	#5/16-18 Hex Nut	1
10	32.7109.0.000	Hold Up Rod	1
11	01.2437.0.000	#10-32 x 5/8 Screw	6
12	32.7129.0.000	Front Slide Rail	1
13	32.7157.0.000	Front Table Switch Mount	1
14	03.6222.4.108	#4-40 x .50 Bind. Hd. Screw	4
15	07.6600.0.010	#3/4 Cable Clamp	2
16	03.6000.0.216	#10-32 x 1 Screw	2
17	32.7130.0.000	Rear Slide Rail	1
18	07.0086.0.001	Ball Stud	2
19	07.0087.0.001	Retainer	2
20	01.3552.0.000	#3/8-16 Hex Nut	2
21	01.4582.0.000	#3/8 Lock Washer	2
22	03.6500.4.116	1/2 x 1 Shoulder Screw	2
23	07.0302.1.000	Gas Spring	1
24	32.7156.0.000	Rear Table Switch Mount	1
25	01.2757.0.000	#10-32 x 2 Screw	4
26	01.4579.0.004	#10 Flat Washer	4
27	32.7142.0.000	Bedplate Pivot Block	2
28	03.6000.9.116	#3/8-16 x 1 Screw	1
29	07.6723.0.001	Spacer	1
30	32.7203.0.050	Pulley / Bearing	1
31	03.6000.8.105	#8-32 x 5/16 Screw	1
32	03.6000.0.224	#10-32 x 1-1/2 Screw	1
33	32.7148.0.000	Clamp Plate Drive Pulley	1
34	01.2980.0.002	#10-32 x 3/8 Button Hd. Screw	4
35	01.2493.0.000	#10-32 x 1/2 Screw	3
36	32.7201.0.000	Motor Belt Mount	1
37	07.0087.0.000	Ball Socket	2
38	07.0087.0.001	Clip Safety	2
39	01.2412.0.000	Screw	1
40	01.3400.0.000	Nut, Hex.	1
41	01.3856.0.000	5/16 Flange Nut	1
42	01.4981.0.000	5/16 Fender Washer	1
43	01.49.82.0.000	5/16 Wave Washer	1
44	07.6481.0.014	Damper	1
45	32.7203.1.050	Idler	1
46	01.4581.0.000	Washer	2
47	01.3549.0.000	Nut	2

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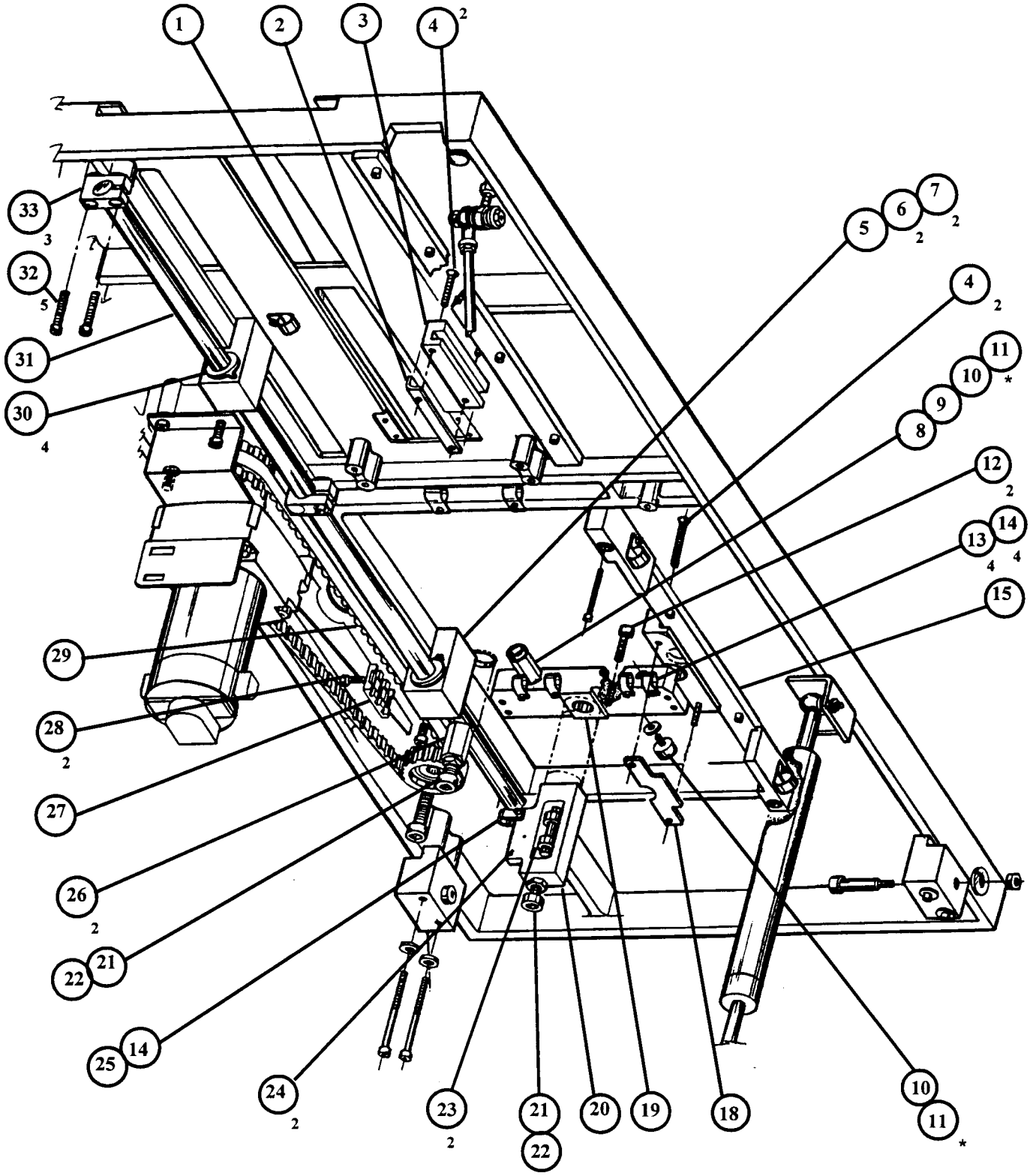
CLAMP PLATE ASSEMBLY



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CLAMP PLATE ASSEMBLY

ITEM	PART NUMBER	DESCRIPTION	QTY.
1	32.7140.0.000	Clamp Plate	1
2	32.7132.0.000	Actuator Guard Plate	1
3	32.7131.0.000	Front Table Slide	1
4	03.6100.0.220	#10-32 x 1-1/4 HS Flat Hd. Screw	4
5	03.6100.0.212	#10-32 x 3/4 HS Flat Hd. Screw	4
6	07.6761.0.000	Bearing	2
7	32.7128.0.000	Bearing Mounting Block	1
8	01.2542.0.000	#8-32 x 1-1/4 Screw	1
9	07.6680.0.002	5/8 Hex x 1.5 Spacer	1
10	07.6481.0.000	Bumper	2
11	03.6862.8.100	#8 Fender Washer	6
12	01.2435.0.000	# 10-32 x 3/4 HSC Screw	2
13	07.6600.0.002	1/4 Cable Clamp	4
14	01.1574.0.001	#8-32 x 3/8 Button Hd. Screw	5
15	32.7133.0.000	Rear Table Slide	1
18	32.7155.0.000	Table switch Actuator	1
19	32.7123.0.000	Brush Cylinder Mounting Bar	1
20	32.7154.0.000	Brush Cylinder Switch Mount	1
21	03.6000.9.120	3/8-16 x 1-1/4 HSC Screw	3
22	01.3072.0.000	3/8-16 Jam Nut	3
23	24117-216	Clamping Collar	2
24	03.6222.4.108	#4-40 x 1/2 Bind. Hd. Screw	2
25	07.6600.0.006	1/2" Clable Clamp	1
26	32.7192.0.000	Clamp-up Stop Mount	2
27	32.7202.0.000	Belt Grip	1
28	01.2448.0.000	#6-32 x 1/2 Screw	2
29	07.6040.0.004	Table Drive Belt	1
30	07.6760.0.001	Retaining Ring	4
31	07.6761.0.001	1/2" Shaft	1
32	03.6000.0.220	#10-32 x 1-1/4 Screw	5
33	32.7127.0.000	Linear Shaft Mounting Block	3
34	32.7128.0.001	Bearing Mounting Block Rear	1
35	07.6761.0.002	Bearing	2
36	22912607	Shim	4
37	22912615	Shim	4

* As Required

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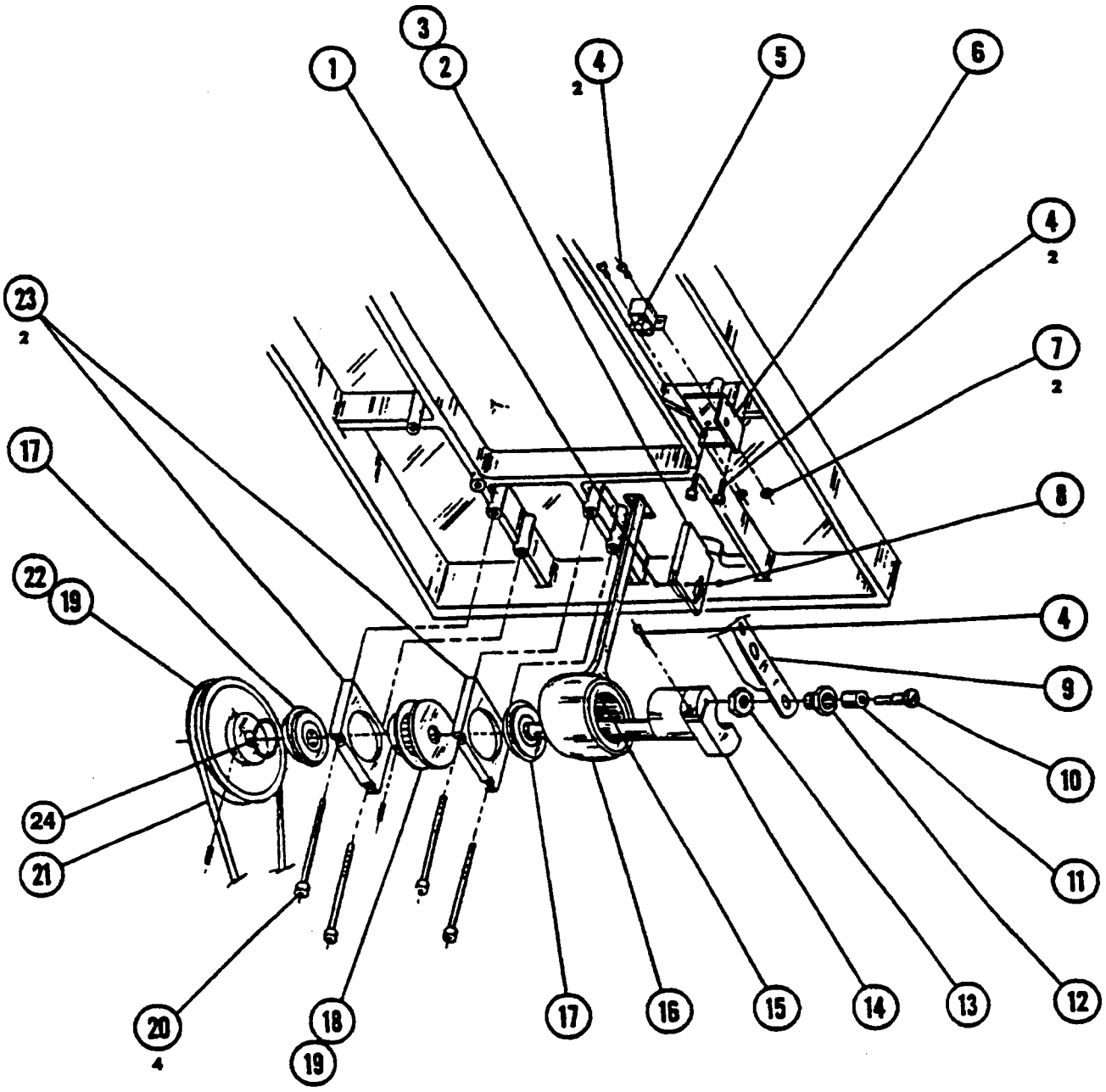
DRIVE SHAFT ASSEMBLY



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DRIVE SHAFT ASSEMBLY

ITEM	PART NUMBER	DESCRIPTION	QTY.
1	03.6221.3.108	#3-48 x 1/2 Bind. Hd. Screw	1
2	32.7168.0.000	Needle Positioner sensor Mount	1
3	01.1624.0.002	#1/4-20 x 1-1/4 Screw	1
4	01.2412.0.000	#8-32 x 1/2 Screw	5
5	07.6000.0.001	Cabinet Latch	1
6	32.7160.0.000	Hold Up Bracket	1
7	03.6702.8.100	#8-32 Hex Nut	2
8	03.6702.3.100	#3-48 Jam Hex Nut	1
9	42.0154.1.000	Looper Arm	1
10	32.7111.0.000	Eccentric Stud	1
11	01.7413.1.000	Bearing	1
12	40.0445.2.800	Bearing Holder	1
13	40.0444.0.000	Retaining Nut	1
14	32.7110.0.000	Drive Shaft	1
15	01.7802.0.000	Needle Bearing	1
16	40.0151.1.000	Connecting Rod	1
17	07.6200.0.000	Bearing	2
18	32.7116.0.000	Pulley	1
19	01.8404.0.900	Key	2
20	03.6000.1.140	#1/4-20 x 2-1/2 Screw	4
21	07.6040.0.003	V-Belt	1
22	07.6040.0.002	Pulley	1
23	32.7113.0.000	Bearing Block	2
24	07.6481.0.006	Thrust Washer	1
25	07.6480.0.001	Sensor Prox Micro	1
26	27512439	Recptcl./ Ears	1
27	27511114	Malex Female Term	3
28	27512628	Malex Female Plug	1
29	27511141	Malex Male Term	3
30	03.6221.3.108	# 3-48 x .50 Screw	1

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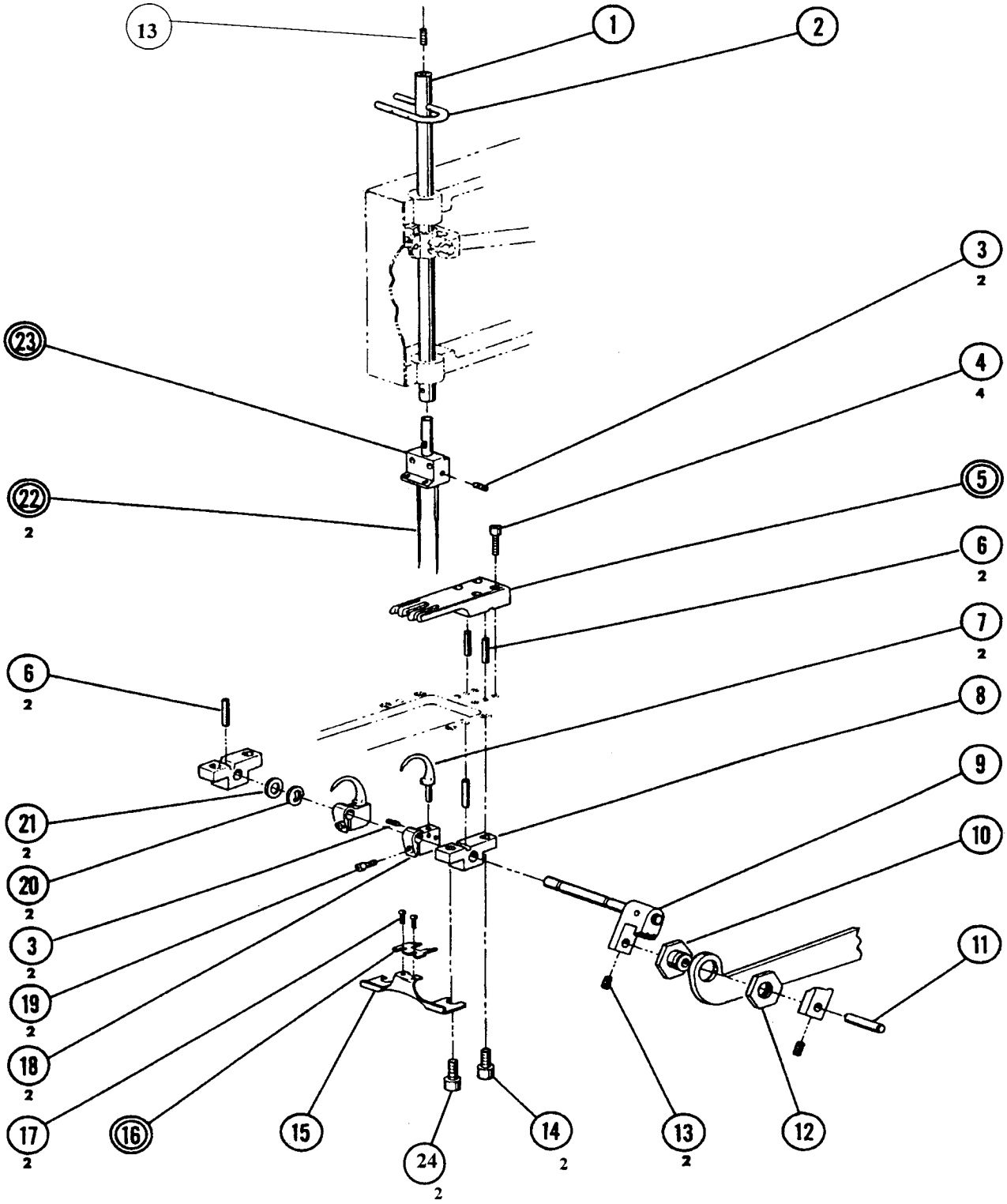
NEEDLE BAR & LOOPER ASSEMBLY



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NEEDLE BAR & LOOPER ASSEMBLY

ITEM	PART NUMBER	DESCRIPTION	QTY.
1	32.1012.0.050	Needle Bar Assembly	1
2	32.1005.0.000	Thread Takeup	1
3	01.2561.0.000	#4-48 Ov. Pt. Set Screw	4
4	01.2419.0.000	#4-40 x .38 Screw	4
5	See Chart	Throat Plate	1
6	01.6543.0.000	Pin	4
7	32.2064.1.000	Looper	2
8	40.0059.0.000	Bearing Block (Set)	1
9	42.0063.1.050	Shaft Assembly	1
10	42.1040.0.000	Looper Sleeve	1
11	01.6827.1.000	Looper Crank Pin	1
12	42.1041.0.000	Spacer Nut	1
13	01.2442.0.001	#6-32 x .19 Set Screw	3
14	03.6000.0.206	#10-32 x 3/8 Screw	4
15	See Chart	Trim Knife Bracket	1
16	See Chart	Trim Knife	1
17	03.6222.2.102	#2-56 x .125 Bind. Hd. Screw	2
18	32.2063.0.000	Looper Holder	2
19	01.2431.0.000	#4-48 x .25 Screw	2
20	01.6454.0.000	Retaining Ring	2
21	01.4402.0.000	Washer	2
22	See Chart	Needle	2
23	See Chart	Needle Holder	1
24	03.6000.0.207	#10-32 x 7/16 Screw	2
25	32.7223.0.000	Screw Set #4x48 Flat Pt	2
26	01.2515.0.000	Screw	1
27	01.7442.0.000	Bushing	2
28	07.6088.0.002	4-40 Insert Bedplate	4
29	07.6088.0.001	10-32 Insert Bedplate	4
30	01.2419.0.000	# 4-40 x .38 Screw	4
31	01.2431.0.000	# 4-48 x .19 Screw	2
32	32.2064.1.000	Looper, Single Thread Chain	1

Spacing Charts begin on page 3-50.

Needles Chart is on page 3-56.

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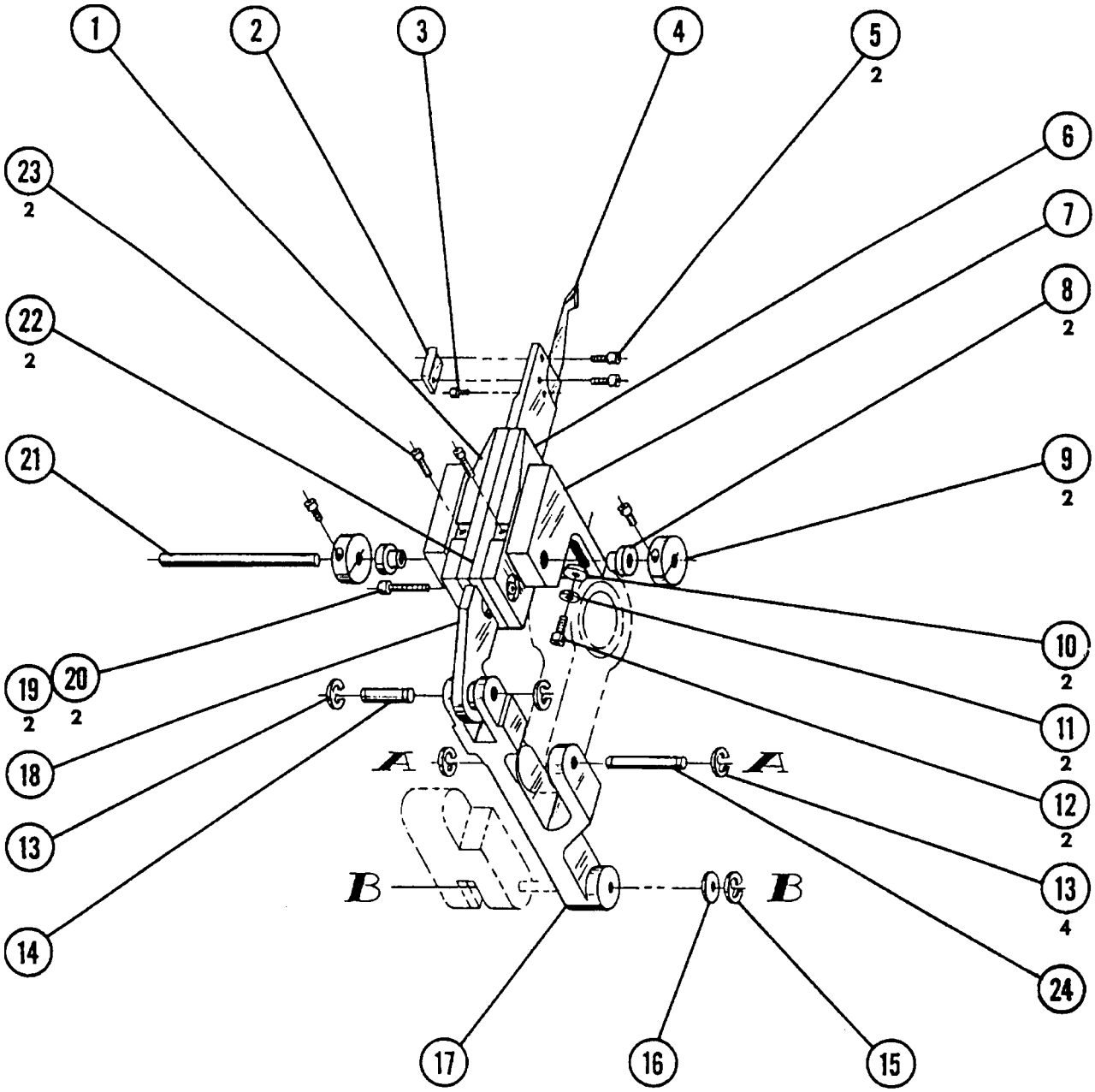
CENTER KNIFE ASSEMBLY



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CENTER KNIFE ASSEMBLY

ITEM	PART NUMBER	DESCRIPTION	QTY.
1	32.2196.0.000	Left Center Knife Guide	1
2	32.2208.0.000	Clamp	1
3	01.2318.0.000	Screw	1
4	32.2019.1.000	Knife Blade	1
5	01.2431.0.000	#4-48 x .19 Screw	2
6	32.2195.0.000	Right Center Knife Guide	1
7	32.7126.0.000	Pivot Block	1
8	01.7705.0.008	Flange Bearing	2
9	01.7314.0.001	Clamp Collar	2
10	01.4579.0.004	#10 Flat Washer	2
11	01.4003.0.000	#10 Lock Washer	2
12	01.2437.0.000	#10-32 x 5/8 Screw	2
13	01.6475.0.000	Retaining Ring	4
14	01.6928.0.002	1/4 x 5/8 Pin	1
15	01.6502.0.000	Retaining Ring	1
16	01.4591.0.000	Flat Washer	1
17	44.0966.2.000	Lever Assembly	1
18	32.2207.0.050	Knife Holder	1
19	01.1148.0.000	#4-40 x .88 Screw	2
20	01.3524.0.000	#4-40 Hex Nut	2
21	01.6950.0.004	#1/4 x 2-1/2 Dowel Pin	1
22	32.2194.0.000	Knife Guide Bearing	2
23	01.2413.0.000	#6-32 x .38 Screw	2
24	01.6928.0.001	Pin	1
25	01.1148.0.000		2

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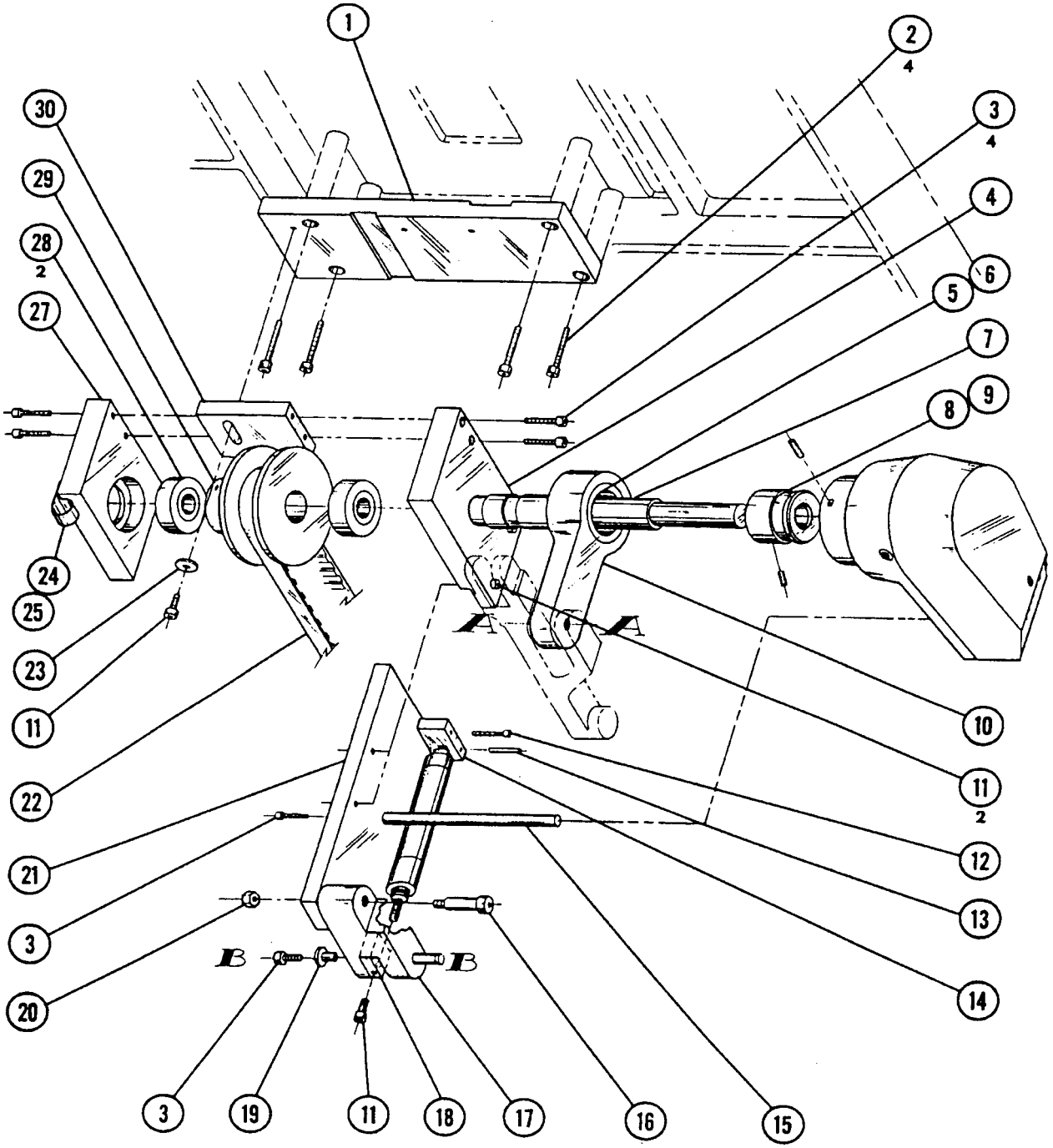
CENTER KNIFE DRIVE ASSEMBLY



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CENTER KNIFE DRIVE ASSEMBLY

ITEM	PART NUMBER	DESCRIPTION	QTY.
1	32.7122.0.000	Takeup Pulley Plate	1
2	01.2449.0.000	#1/4-20 x 3/4 Screw	4
3	01.2450.0.000	#8-32 x 5/8 Screw	6
4	32.7115.0.000	Right Hand Bearing Block	1
5	44.0970.0.001	Cam Eccentric	1
6	01.6470.0.000	Roll Pin	1
7	32.7112.0.000	Shaft	1
8	32.7153.0.000	Adapter	1
9	01.2408.0.000	#10-32 x 1/4 Set Screw	1
10	32.2022.0.050	Crank Assembly	1
11	01.2437.0.000	#10-32 x 5/8 Screw	4
12	03.6000.0.216	#10-32 x 1 Screw	1
13	03.6900.5.116	5/32 x 1 Dowel Pin	1
14	32.7118.0.000	Clevis	1
15	07.6680.0.001	Spacer	1
16	01.1952.0.000	#5/16 x .62 Shoulder Screw	1
17	32.2030.0.050	Pivot Link Assembly	1
18	32.7119.0.000	Cylinder Rod Adapter	1
19	32.7120.0.000	Shoulder Bushing	1
20	01.3057.0.000	#1/4-20 Hex Nut	1
21	32.7117.0.000	Cylinder Mounting Plate	1
22	05.1182.0.001	Timing Belt	1
23	01.4579.0.004	#10 Flat Washer	1
24	07.6600.0.002	#1/4 Cable Clamp	1
25	01.1574.0.001	#8-32 x 3/8 Button Hd. Screw	1
27	32.7114.0.000	Left Hand Bearing Block	1
28	07.6200.0.001	Bearing	2
29	32.7116.0.000	Pulley	1
30	32.7121.0.000	Knife Bearing Block Plate	1

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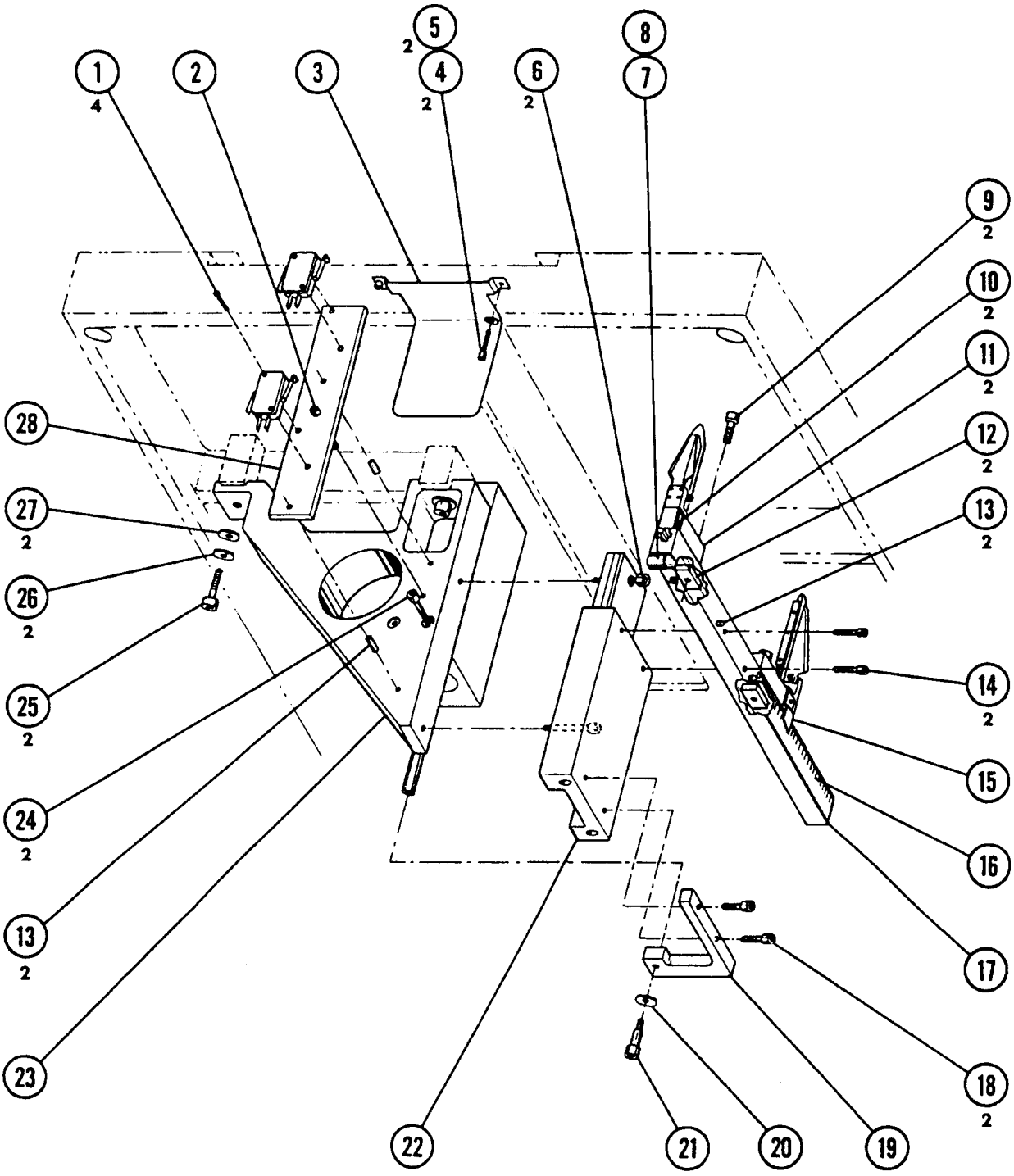
TAB KNIFE ASSEMBLY



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TAB KNIFE ASSEMBLY

ITEM	PART NUMBER	DESCRIPTION	QTY.
1	03.6222.4.108	#4-40 x 1/2 Bind. Hd. Screw	2
2	01.2412.0.000	#8-32 x 1/2 Screw	1
3	32.7177.0.000	Tab Knife Front Guard	1
4	01000003	#8-32 x 5/16 Screw	2
5	01.4407.0.000	#8 Lock Washer	2
6	01.2450.0.000	#8-32 x 5/8 Screw	2
7	07.6600.0.002	#1/4 Cable Clamp	1
8	01.1574.0.001	#8-32 x 3/8 Button Hd. Screw	1
9	01.2435.0.000	#10-32 x 3/4 Screw	2
10	01.2413.0.000	#6-32 x 3/8 Screw	2
11	32.7149.0.000	Finger Shoe	2
12	32.7137.0.000	Tab Knife Adjusting Nut	2
13	03.6900.4.110	1/8 x 5/8 Dowel Pin	4
14	01.2604.0.000	#6-32 x 5/8 Screw	2
15	32.7183.0.000	Pointer	1
16	32.7178.0.000	Scale	1
17	32.7136.0.000	Holder Bar	1
18	01.2448.0.000	#6-32 x 1/2 Screw	2
19	32.7138.0.000	Cylinder Adapter	1
20	01.4579.0.000	1/4" Flat Washer	1
21	01.1480.0.000	#1/4 x 3/8 Sholder Screw	1
22	32.7141.0.000	Slide	1
23	32.7139.0.000	Tab Knife Mount	1
24	03.6000.0.112	#10-24 x 3/4 Screw	2
25	01.2421.0.001	#1/4-20 x 1 Screw	2
26	01.4578.0.000	#1/4 Lock Washer	2
27	01.4579.0.000	#1/4 Flat Washer	2
28	32.7163.0.000	Switch Mounting Plate	1
29	32.7163.0.001	Upper Tab Knife Bracket	1
30	01.2419.0.000	4-40 x .38 Screw	2
31	01.4405.0.000	#4 Split Washer	2
32	01.4537.0.000	# Flat Washer	2
33	06.0865.0.000	Top Switch	1
34	01.2604.0.000	6-32 x .620	2

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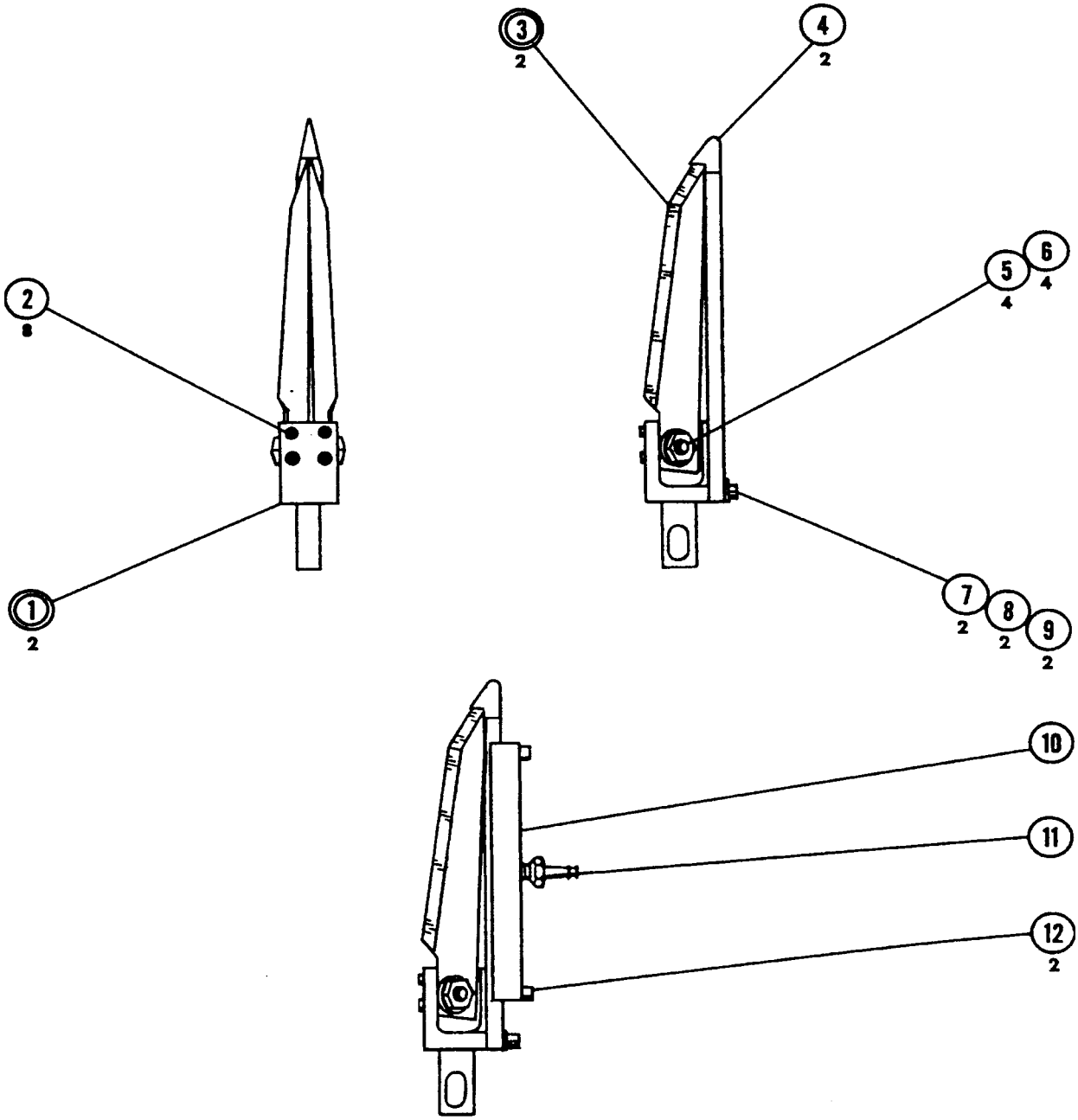
TAB KNIFE



NOTE: ITEMS 10, 11, & 12 ON REAR KNIFE SET ONLY.

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TAB KNIFE

ITEM	PART NUMBER	DESCRIPTION	QTY.
1	See Chart	Tab Knife Holder	2
2	01.1956.0.000	#4-40 x .12 Cone Pt. Set Screw	8
3	See Chart	Tab Knife Holder	2
	See Chart	Double Edge Knife	4
4	32.2045.0.050	Pointer Assembly	2
5	01.3074.0.000	#5-40 Hex Nut	4
6	01.4072.0.000	#4 Narrow Washer	4
7	03.6000.2.105	#2-56 x 5/16 Screw	2
8	01.4528.0.000	#2 Lock Washer	2
9	03.6852.2.100	#2 Flat Washer	2
10	32.7182.0.000	Thread Blow Off	1
11	25521-562	#10-32 x 3/32 Connector	1
12	03.6000.2.104	#2-56 x 1/4 Screw	2
13	32.2045.0.050	Pointer Asm. - Tab Knife	2

Spacing Charts begin on page 3-50.

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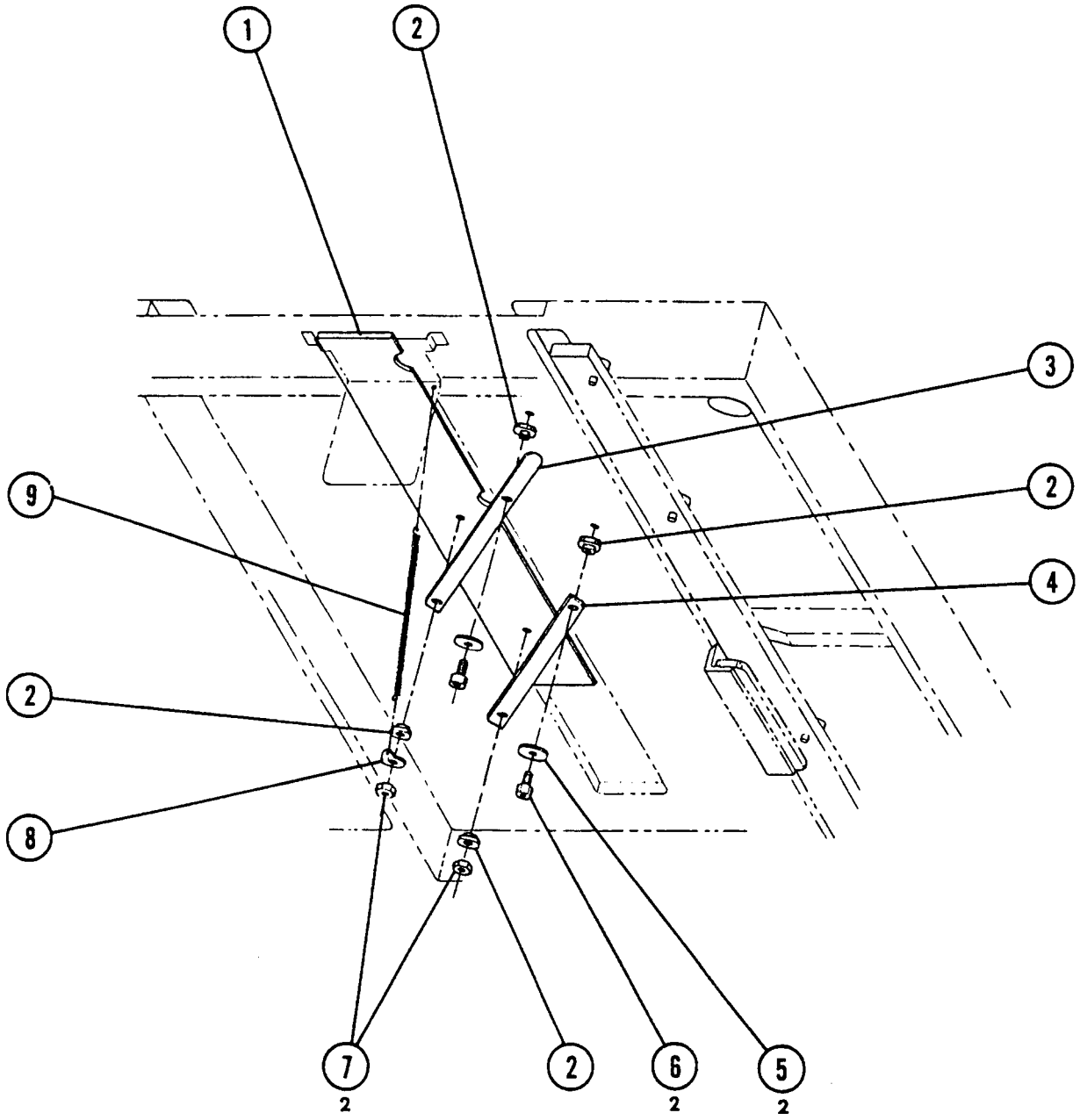
TAB KNIFE GUARD ASSEMBLY



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TAB KNIFE GUARD ASSEMBLY

ITEM	PART NUMBER	DESCRIPTION	QTY.
1	32.7177.0.000	Guard Plate	1
2	32.7144.0.000	Bushing	4
3	32.7145.1.000	Driver Link	1
4	32.7146.1.000	Link	1
5	01.4579.0.003	Flat Washer	2
6	01.2412.0.000	#8-32 x .50 Screw	2
7	03.6702.8.100	#8-32 Hex Nut	2
8	40.0434.0.000	Anchor	1
9	07.6440.0.015	Spring	1
10	07.6440.0.053	Ext. Spring	1

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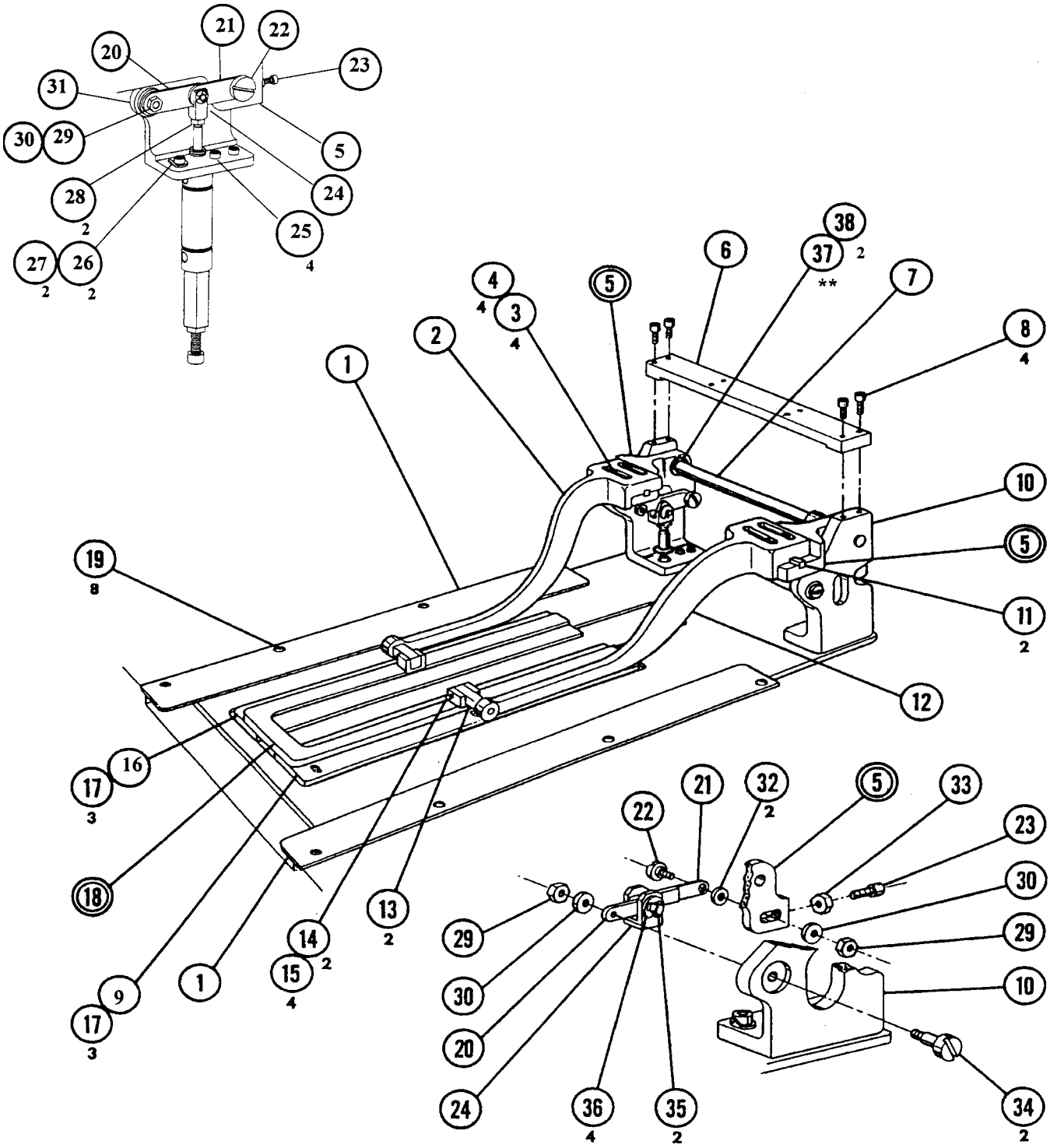
CLAMP ASSEMBLY



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CLAMP ASSEMBLY

ITEM	PART NUMBER	DESCRIPTION	QTY.
1	32.7134.0.000	Table Slide Cover	2
2	42.0071.0.004	Left Front Clamp Arm	1
3	01.2447.0.000	#10-24 x .620 Screw	4
4	01.4402.0.000	#10 Flat Washer	4
5	See Chart	Rear Clamp Arm	2
6	32.7185.0.000	Plate	1
7	41.0080.0.000	Slide Bar	1
8	01.2448.0.000	#6-32 x 1/2 Screw	4
9	32.7540.0.002	Right Hand Clamp Plate	1
10	32.7125.0.000	Right Hand Clamp Support	1
11	01.7530.0.000	Key	2
12	42.0071.0.003	Right Front Clamp Arm	1
13	41.0072.0.002	Pivot Block	2
14	01.6477.0.000	Pin	2
15	01.6368.0.000	Retaining Ring	4
16	32.7540.0.001	Left Hand Clamp Plate	2
17	03.6252.8.103	#8-32 x 3/16 Button Hd. Screw	6
18	See Chart	Clamp Foot Assembly	1
19	01.2545.0.000	#8-32 x 1/4 Button Hd. Screw	14
20	40.0085.0.000	Front Lever	2
21	40.0079.0.000	Rear Lever	2
22	01.1419.0.000	#10-32 x .374 x .127L Shoulder Screw	2
23	01.2482.0.000	#8-32 x .75 Screw	2
24	32.7180.0.000	Clevis	2
25	01.2435.0.000	#10-32 x .75 Screw	4
26	01.2493.0.000	#10-32 x .50 Screw	2
27	40.0434.0.000	Spring Anchor	2
28	01.3428.0.000	#1/4-28 Hex Nut	2
29	01.3471.0.000	#10-32 Hex Nut	4
30	01.4441.0.000	#10 Flat Washer	4
31	32.7124.0.000	Left Hand Clamp Support	1
32	01.4035.0.000	Spacer	2
33	03.6702.8.100	#8-32 Hex Nut	2
34	01.1418.0.000	#10-32 x .250 x .5L Shoulder Screw	2
35	01.6489.0.000	Pin	2
36	01.6558.0.000	Retaining Ring	4
37	01.4484.0.000	Spacer	5
38	01.6561.0.000	Retaining Ring	1
39	22912-607	Shim .005	
40	22912-615	Shim .015	
41	01.3072.0.000	#3/8-16 Jam Nut	2
42	03.6000.9.120	#3/8-16 x 1.25	2
43	03.6252.8.103	8-32 x 3/16 Screw	6
44	07.6481.0.009	Shim .38 x .025	1

Spacing Chart begin on page 3-50.

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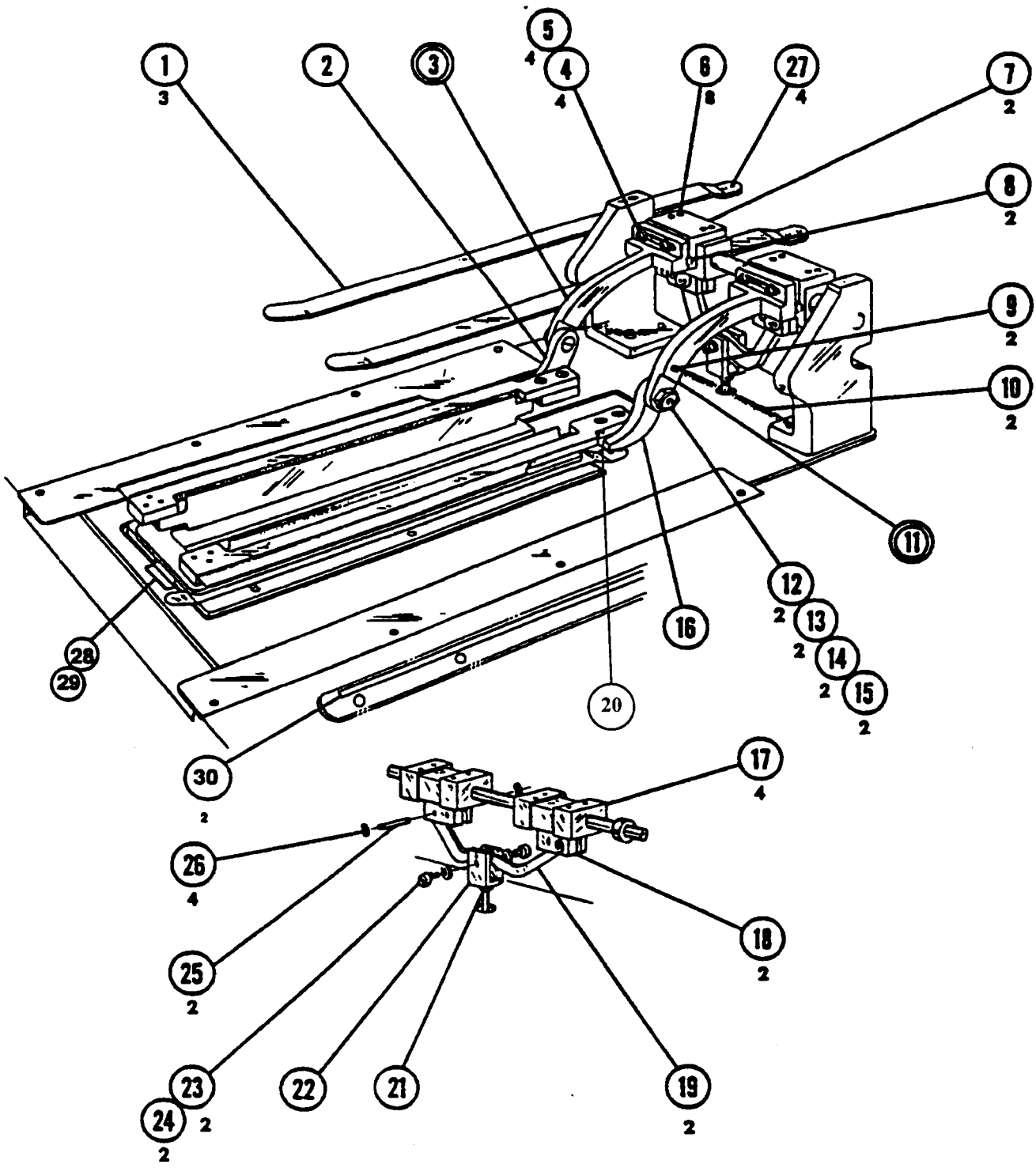
PATCH FOLDING ASSEMBLY



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PATCH FOLDING ASSEMBLY

ITEM	PART NUMBER	DESCRIPTION	QTY.
1	40.0596.0.000	Trouser Long Hold Down	4
2	42.0073.0.004	Left Hand Lower Brush Arm	1
3	See Chart	Left Hand Upper Brush Arm	1
4	01.2412.0.000	#8-32 x 1/2 Screw	4
5	01.4407.0.000	#8 Washer	4
6	01.2413.0.000	#6-32 x .38 Screw	8
7	42.0846.1.000	Slide Block Cover	2
8	01.7530.0.000	Key	2
9	01.1422.0.000	Special Screw	2
10	01.5419.0.000	Spring	2
11	See Chart	Right Hand Upper Brush Arm	1
12	01.1486.0.000	#1/4-20 x .300 Screw	2
13	01.4579.0.000	1/4 Flat Washer	2
14	01.4672.0.003	1/4 Ext. Washer	2
15	01.3415.0.000	#1/4-20 Hex Nut	2
16	42.0073.0.003	Right Hand Lower Brush Arm	1
17	41.0433.0.000	Slide Block	4
18	41.0081.0.000	Slide Bracket	2
19	41.0086.0.000	Spreader Arm	2
20	03.6200.0.204	#10-32 x 1/4 BH Screw	4
21	01.3400.0.000	#5/16-24 Jam Hex Nut	1
22	32.7173.0.000	Clevis	1
23	01.2580.0.000	#10-32 x .1550 x .163 Screw	2
24	01.4003.0.000	#10 Lock Washer	2
25	01.6483.0.000	Pin	2
26	01.6474.0.000	Retaining Ring	4
27	01.2980.0.000	#10-32 x .38 Button Hd. Screw	8
28	32.7150.0.000	Filler Block Clamp	1
29	01.2461.0.000	#6-32 x .25 F.H. Screw	1
30	32.2203.0.000	Cover Plate, Black	2
31	40.0766.0.000	Rubber For Clamp	2
32	01.3415.0.000	1/4-20 Nut	2
33	01.4672.0.003	Washer	2

Spacing Charts begin on page 3-50.

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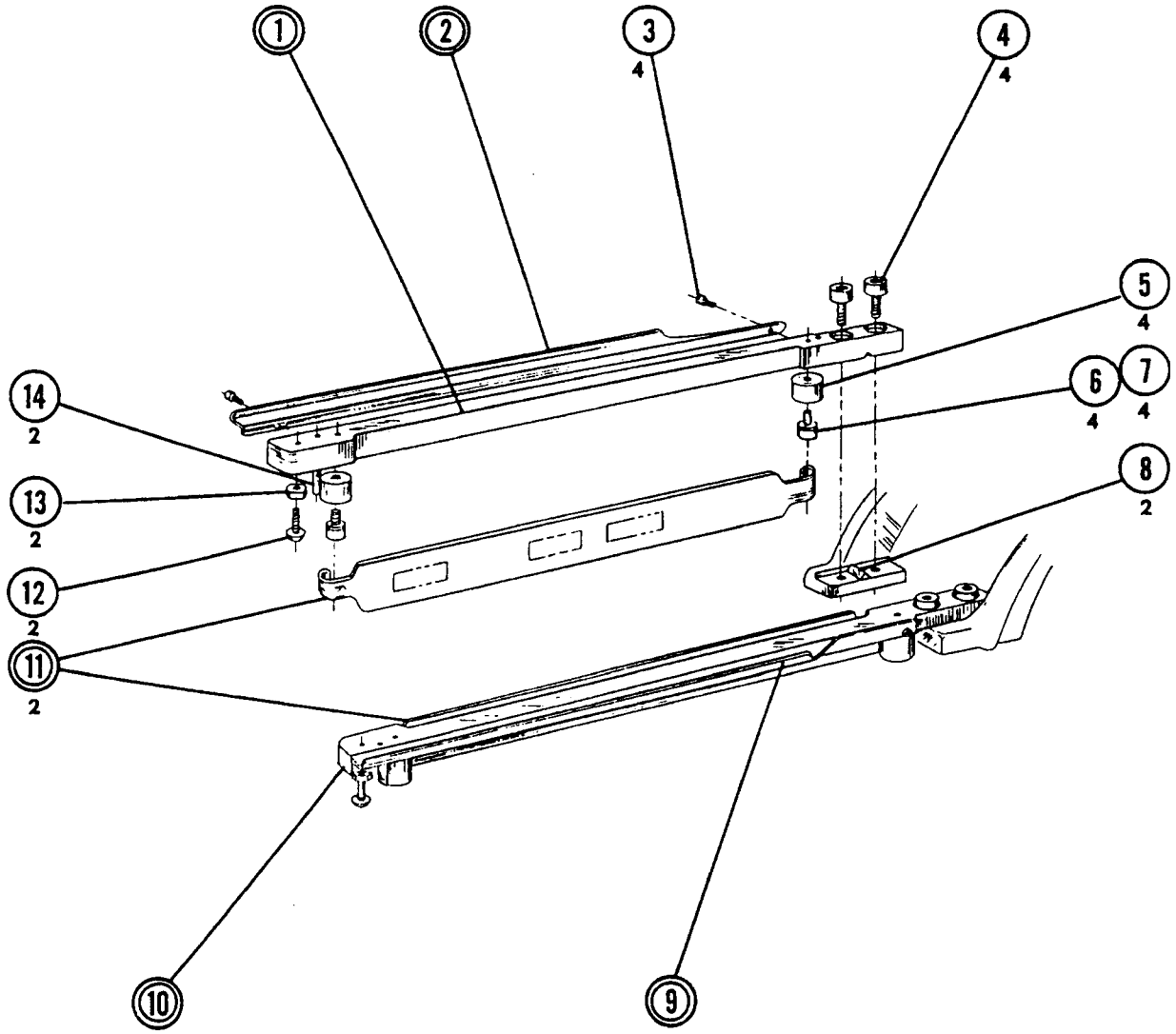
PATCH FOLDING BRUSHES



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PATCH FOLDING BRUSHES

ITEM	PART NUMBER	DESCRIPTION	QTY.
1	See Chart	Left Hand Brush	1
2	See Chart	Left Hand Patch Locator	1
3	01.2431.0.000	#4-48 x .19 Screw	4
4	01.2407.0.000	#10-24 x .38 Screw	1
5	41.0468.0.000	Pivot	4
6	01.4406.0.000	#6 Lock Washer	4
7	01.2413.0.000	#6-32 x .38 Screw	4
8	40.0476.0.000	Leveling Wedge	2
9	See Chart	Right Hand Patch Locator	1
10	See Chart	Right Hand Brush	1
11	See Chart	Brush Blade	2
12	01.2569.0.000	#6-32 x .50 Button Hd. Screw	2
13	01.3426.0.000	#6-32 Hex Nut	2
14	01.6521.0.000	Roll Pin	4

Spacing Charts begin on page 3-50.

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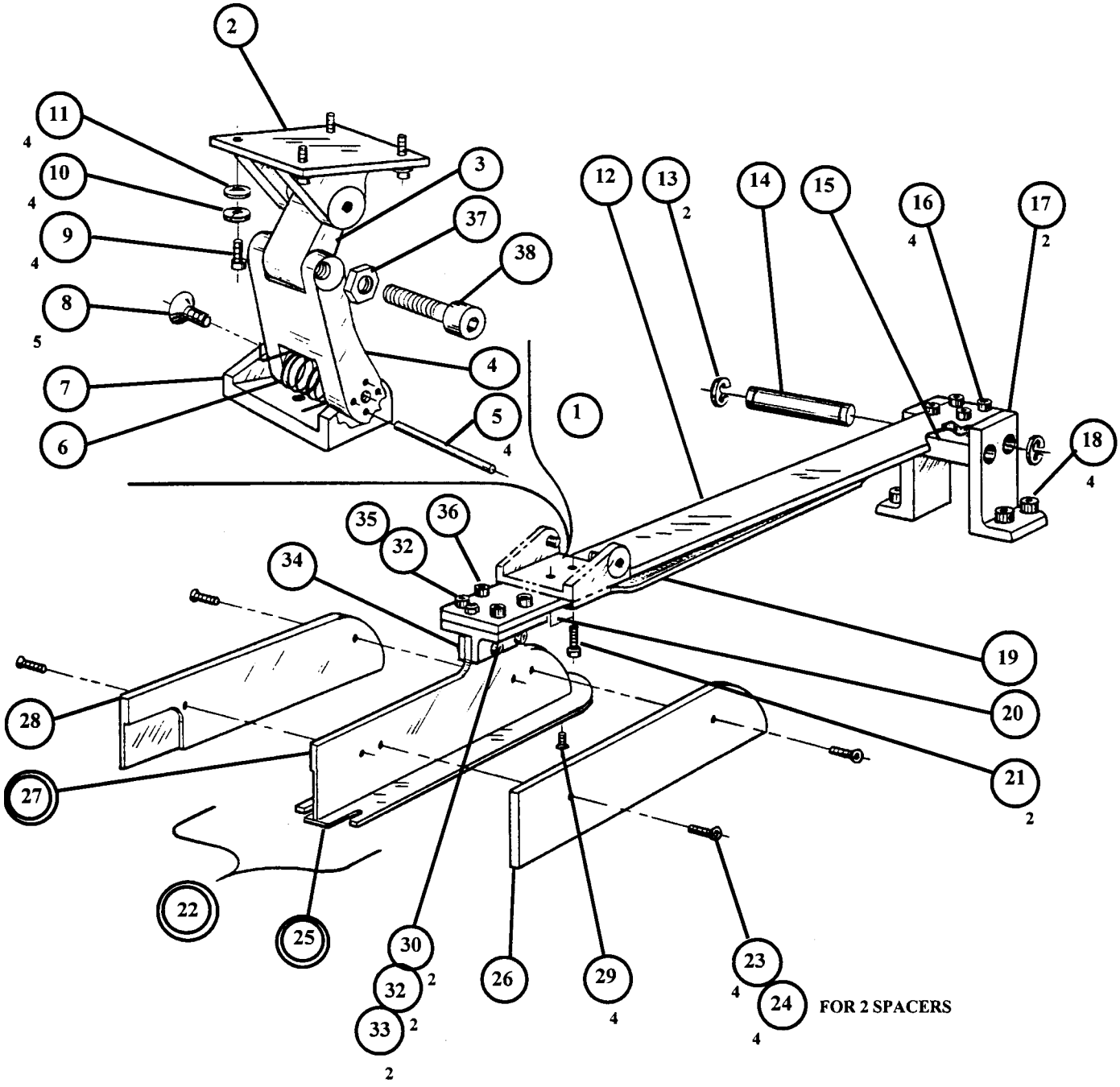
PATCH GUIDE ASSEMBLY



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PATCH GUIDE ASSEMBLY

ITEM	PART NUMBER	DESCRIPTION	QTY.
1	32.2142.0.050	Stabilizer Assembly	1
2	32.2133.0.000	Front Guide Block	1
3	42.0829.0.000	Lower Link	1
4	42.0828.0.000	Upper Link	1
5	01.6633.0.000	Pin	4
6	01.5490.0.000	Spring	1
7	41.0615.0.000	Bracket	1
8	01.2713.0.000	#10-32 x 3/8 Screw	5
9	01.2419.0.000	#4-40 x 3/8 Screw	4
10	03.6802.4.100	#4 Lock Washer	4
11	01.4072.0.000	#4 Flat Washer	4
12	40.0413.0.000	Patch Guide Arm	1
13	01.6454.0.000	Retaining Ring	2
14	01.6488.0.000	Pin	1
15	32.7174.0.000	Pivot Block	1
16	01.2412.0.000	#8-32 x 1/2 Screw	4
17	32.7175.0.000	Bracket	2
18	01.2493.0.000	#10-32 x 1/2 Screw	4
19	See Chart	Cam Plate	1
20	40.0414.1.000	Patch Guide Block	1
21	01.2531.0.000	#6-32 x 7/16 Screw	2
22	See Chart	Patch Guide Assembly	1
23	01.2472.0.000	#4-40 x 3/16 Screw	4
24	01.2488.0.000	#4-40 x 1/4 Screw for 2 Spacers	4
25	See Chart	Horizontal Plate	1
26	See Chart	Right Hand Spacer Plate	1
27	See Chart	Vertical Plate	1
28	See Chart	Left Hand Spacer Plate	1
29	01.2638.0.002	#2-56 x 1/4 Screw	4
30	01.2448.0.000	#6-32 x 1/2 Screw	2
32	01.3426.0.000	#6-32 Hex Nut	3
33	01.4470.0.000	Spacer	1
34	40.0648.0.000	Nut Plate	1
35	01.2409.0.000	#6-32 x 3/8 Set Screw	1
36	01.2411.0.000	#6-32 x 1/4 Screw	4
37	32.2217.0.000	Support Nut	1
38	01.2757.0.002	#10-32 x 1.50 Screw	1
39	01.3710.0.000	Nut 10-32	

Spacing Charts begin on page 3-50.

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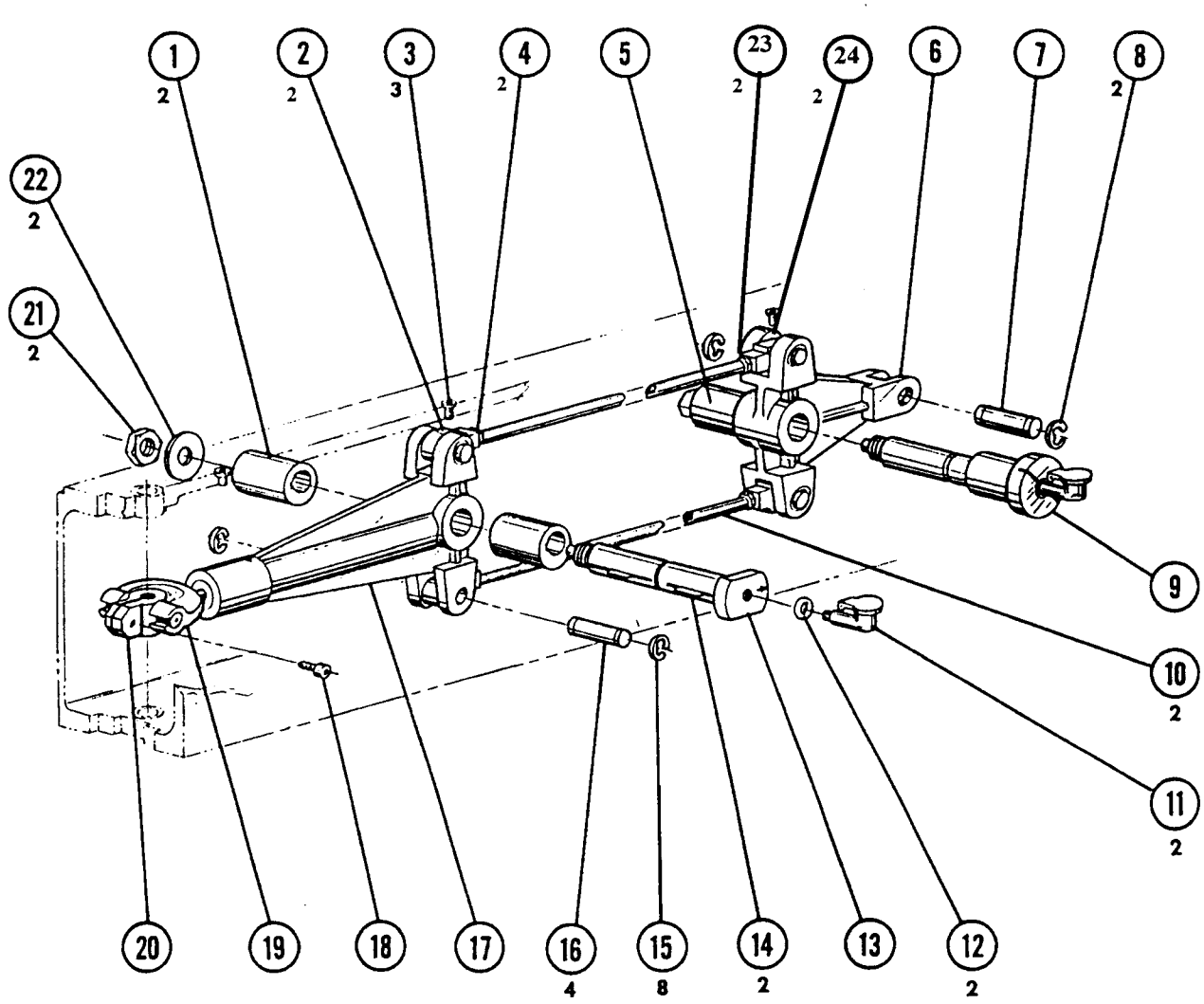
NEEDLE BAR DRIVE ASSEMBLY



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NEEDLE BAR DRIVE ASSEMBLY

ITEM	PART NUMBER	DESCRIPTION	QTY.
1	40.0567.0.000	Eccentric Bushing	2
2	32.7198.0.001	Rod Connector	2
3	40.0593.0.000	Oil Inlet	3
4	03.6702.6.200	#6-40 Hex Nut	2
5	30.0007.0.000	Bushing	1
6	40.0465.0.000	Rear Lever	1
7	01.6504.0.000	Pin	1
8	01.6475.0.000	Retaining Ring	2
9	40.0010.0.000	Rear Shaft	1
10	32.7199.0.000	Rod	2
11	30.0011.0.000	Oil Cup	2
12	01.6551.0.000	Retaining Ring	2
13	40.0566.0.000	Front Shaft	1
14	01.8401.0.000	Key	2
15	01.6454.0.000	Retaining Ring	8
16	01.6407.0.000	Pin	4
17	40.0050.0.050	Front Lever	1
18	01.2402.0.000	#4-48 x .25 Screw	1
19	30.0009.0.000	Yoke	1
20	30.0008.0.000	Gimbal	1
21	01.3400.0.000	#5-16-24 Hex Nut	2
22	01.4005.0.000	#5/16 Flat Washer	2
23	03.6710.6.200	#6-40 L.H. Hex Nut	2
24	32.7198.0.002	Rod Connector	2

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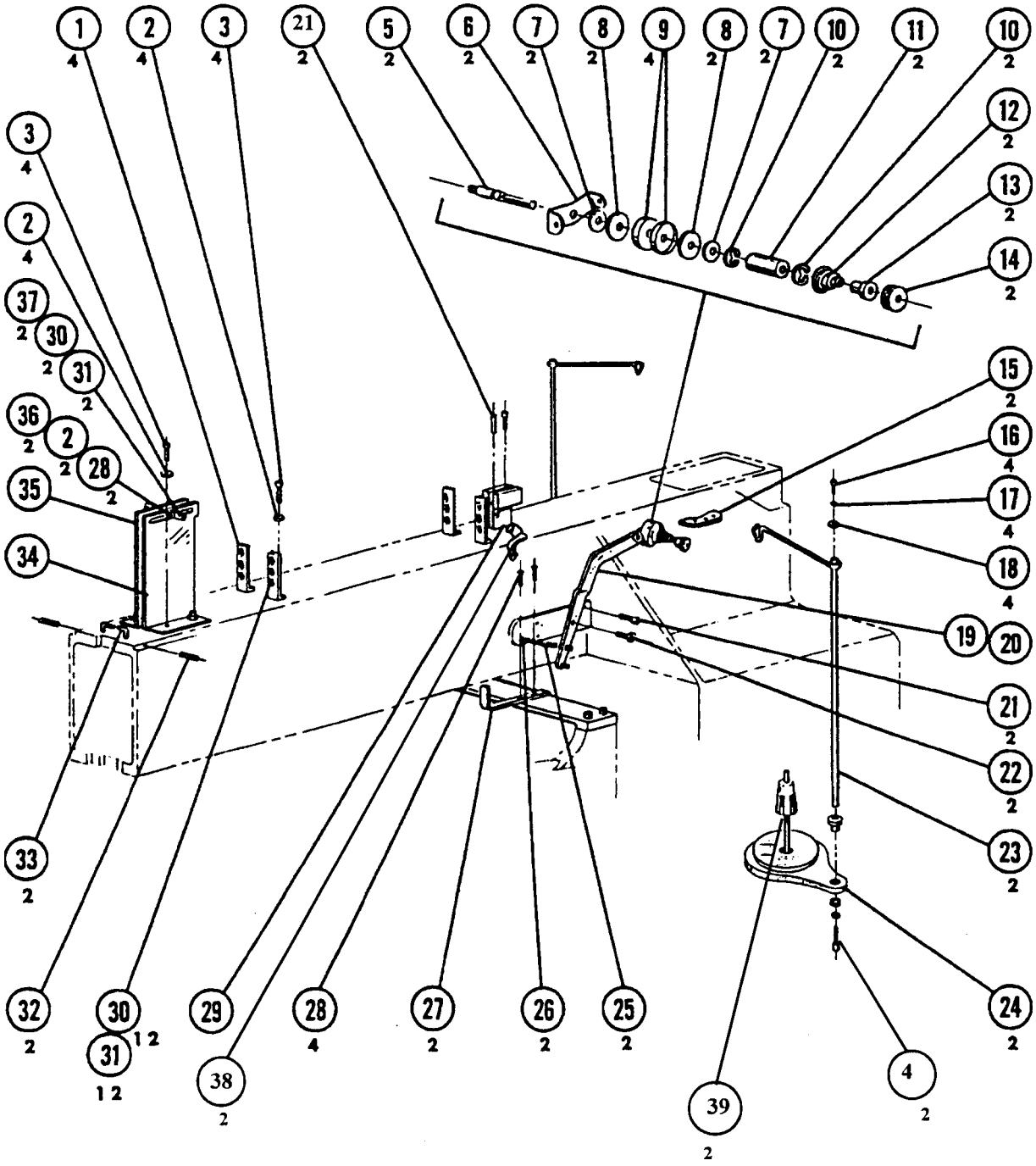
THREAD TENSION AND CONTROL ASSEMBLY



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THREAD TENSION AND CONTROL ASSEMBLY

ITEM	PART NUMBER	DESCRIPTION	QTY.
1	42.0037.0.000	Thread Guide Bracket	4
2	01.4411.0.000	#6 Flat Washer	10
3	01.2411.0.000	#6-32 x 1/4 Screw	8
4	03.6302.1.136	1/4-20 x 2-1/4 Screw	2
5	01.1433.0.000	Stud	2
6	32.1009.0.000	Thread Guide	2
7	01.4005.0.000	Washer	4
8	01.4424.0.000	Felt Washer	4
9	40.0475.0.000	Tension Disc	4
10	01.6474.0.000	Retaining Ring	4
11	01.7448.0.000	Bushing	2
12	01.5001.0.000	Spring	2
13	20.0603.0.000	Collar	2
14	01.3036.0.000	Knurled Nut	2
15	05.1302.0.000	Thread Smoother	2
16	01.2430.0.000	#1/4-20 x 5/8 Screw	2
17	01.4578.0.000	#1/4 Lock Washer	4
18	01.4579.0.000	#1/4 Flat Washer	6
19	32.1035.0.050	Right Hand Thread Drawoff Lever	1
20	32.1034.0.050	Left Hand Thread Drawoff Lever	1
21	01.2448.0.000	#6-32 x 1/2 Screw	4
22	01.1410.0.000	#10-24 x .125 Shoulder Screw	2
23	32.7176.0.000	Thread Stand Post	2
24	07.6721.0.000	Thread Stand	2
25	07.6440.0.015	Spring	2
26	01.6452.0.000	Pin	2
27	32.7186.0.000	Thread Adj. Actuator	2
28	01.1661.0.000	Button Hd. Screw	6
29	32.7170.0.000	Thread Brake Mtg. Block Switch	1
30	01.7447.1.000	Rover Guide	14
31	01.6551.0.000	Retaining Ring	14
32	03.6410.6.106	#6-32 x .375 Set Screw	2
33	32.1006.0.000	Adjustable Bar	2
34	32.1010.0.000	Right Bracket	1
35	32.1019.0.000	Left Bracket	1
36	01.3508.0.000	#6-32 Hex Nut	2
37	32.1007.0.000	Eyelet	2
38	32.7196.0.000	Actuator Switch Alt.	2
39	07.6721.0.001	Pin Cap	2

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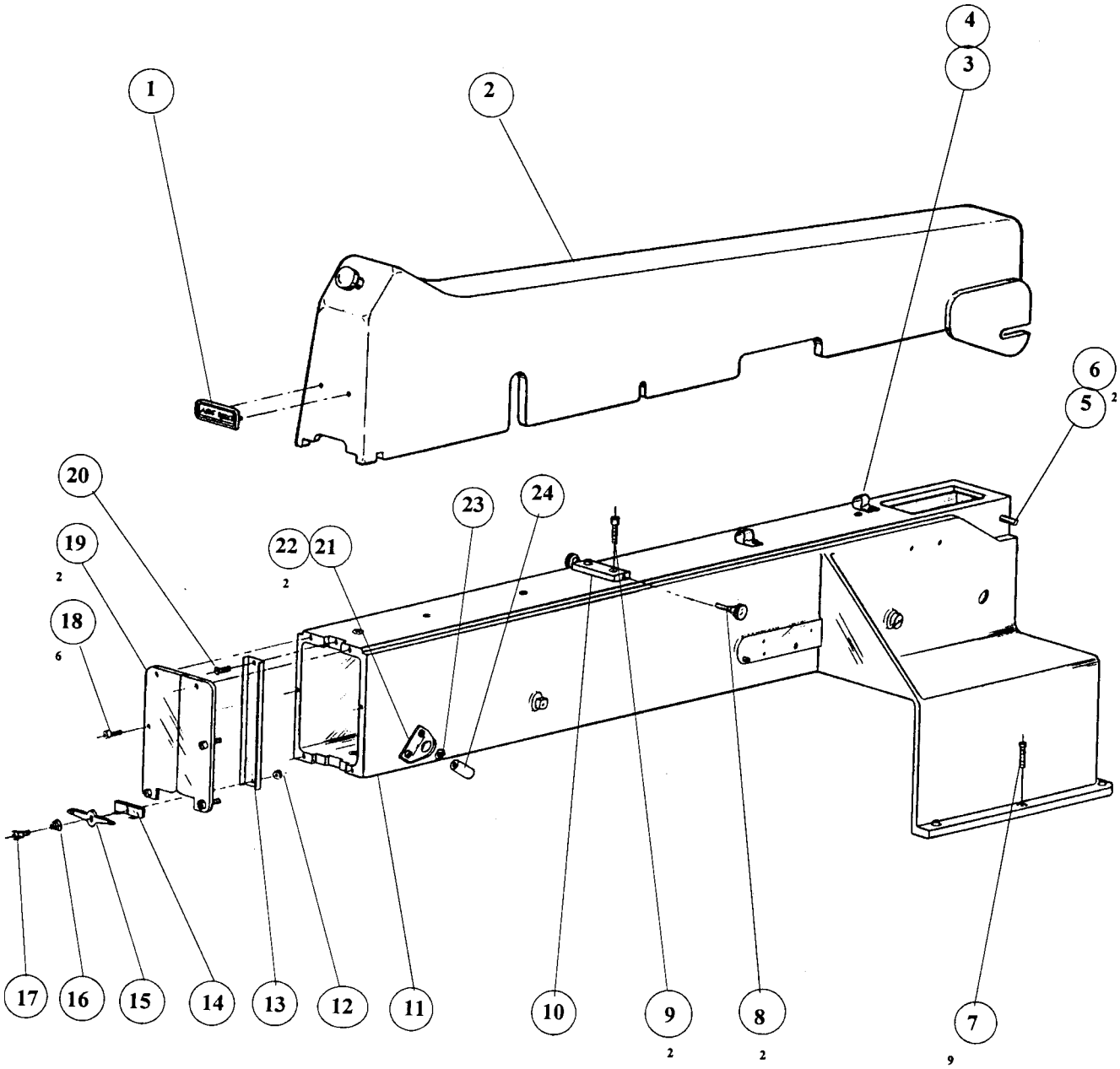
HEAD AND TOP COVER



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HEAD AND TOP COVER

ITEM	PART NUMBER	DESCRIPTION	QTY.
1	05.4111.0.000	Nameplate	1
2	32.7172.0.000	Top Cover	1
3	07.6600.0.004	#3/8 Cable Clamp	2
4	01.2695.0.000	#8-32 x 3/8 Button Hd. Screw	2
5	01.6657.0.001	Hinge Pin	1
6	01.6662.0.000	Retaining Ring	2
7	01.2449.0.000	#1/4-20 Screw	8
8	07.6681.0.001	Knob	2
9	01.2448.0.000	#6-32 x .50 Screw	2
10	32.7187.0.000	Cover Clamp Block	1
11	32.7169.0.000	Head	1
12	01.3016.0.000	#6-52 Hex Nut	1
13	32.1014.0.000	Guide	1
14	32.1015.1.000	Guide	1
15	32.1030.0.000	Plate	1
16	01.1144.0.000	Spring	1
17	01.1475.0.000	#6-52 x .203 Shoulder Screw	1
18	01.2401.0.000	#4-40 x .25 Screw	6
19	32.7188.0.000	Thread Cover	2
20	01.2406.0.000	#2-56 x .19 Flat Hd. Screw	1
21	07.0692.0.000	Cylinder Mounting Bracket	1
22	01.1574.0.001	#10-32 x .38 Btn. Hd. Screw	2
23	01.3471.0.000	#10-32 Hex Nut	1
24	32.2216.0.000	Nylon Plunger	1
25	01.1624.0.002	1/4 x 20 x 1.25 Soc. Hd. Cup Screw	1
26	01.4549.0.000	Flat Plastic Washer	2
27	01.1574.0.001	Screw	6
28	32.7189.0.050	Cover	1
29	01.1624.0.000		1
30	01.6898.0.003	Pin-Spring 3/16 x .875	2
31	01.7442.0.000	Bushing	2
32	05.1392.0.000	Hard Acrylic Logo Large	2
33	32.7189.0.001	Guard, Stationary L.H.	1
34	32.7189.0.002	Guard, Stationary R. H.	1
35	32.7190.0.001	Guard, Moving L. H.	1
36	32.7190.0.002	Guard, Moving R. H.	1

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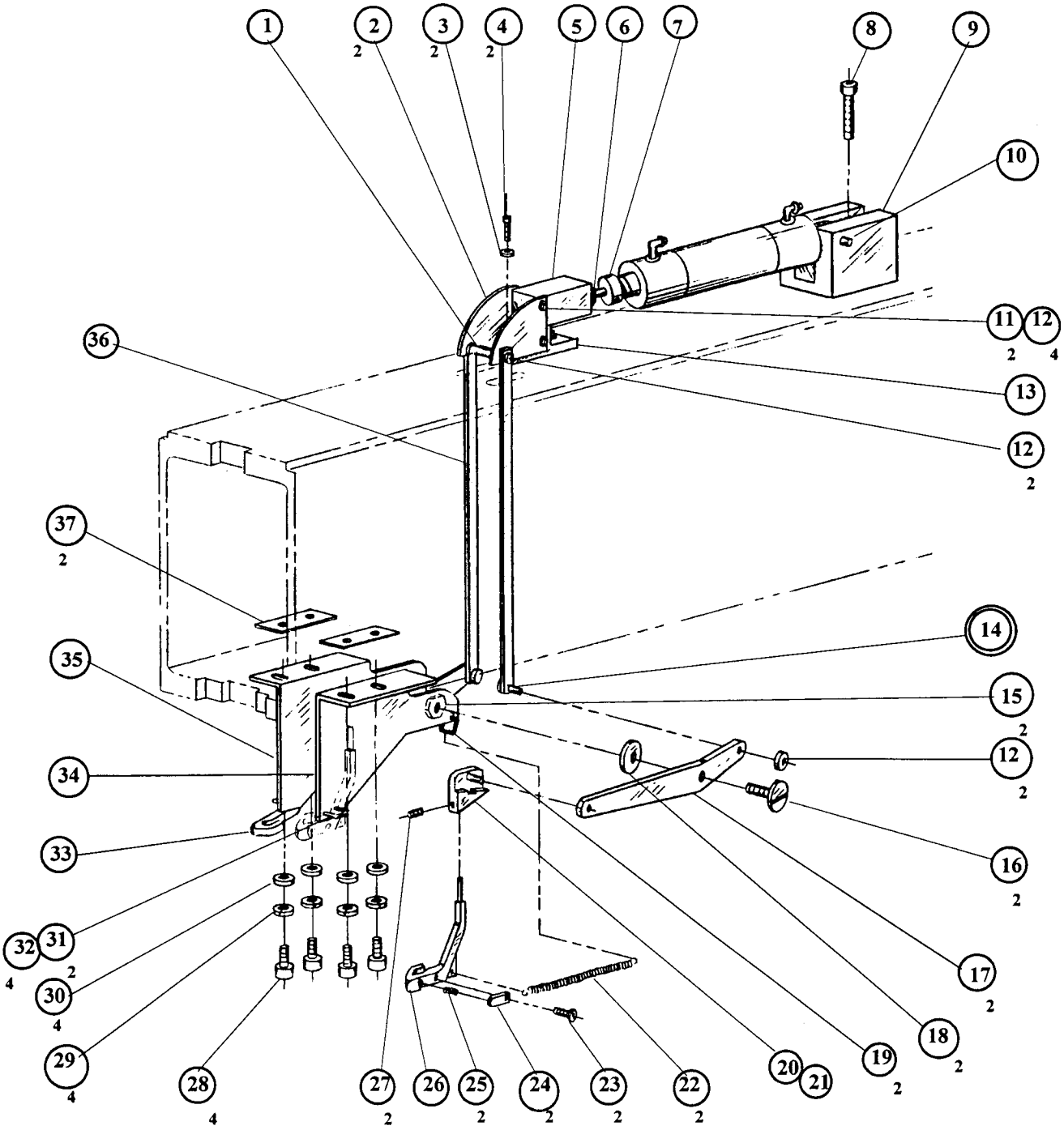
THREAD PICKUP ASSEMBLY



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THREAD PICKUP ASSEMBLY

ITEM	PART NUMBER	DESCRIPTION	QTY.
1	01.6658.0.000	Shaft	1
2	42.0899.0.000	Lever	2
3	01.4407.0.000	#8 Lock Washer	2
4	01.2506.0.000	#8-32 x .44 Screw	2
5	32.7158.0.000	Cylinder Rod Link	1
6	01.3471.0.000	#10-32 Hex Nut	1
7	07.6680.0.006	Spacer	1
8	01.2493.0.000	#10-32 x 1/2 Screw	1
9	32.7159.0.000	Cylinder Mounting Block	1
10	03.6900.5.112	Pin	1
11	01.6659.0.000	Shaft	2
12	01.6552.0.000	Retaining Ring	8
13	42.0901.0.000	Mounting Block	1
14	01.6567.0.000	Pin	2
15	01.3508.0.000	#6-32 Hex Nut	2
16	01.1440.0.000	#6-32 x .102 Shoulder Screw	2
17	40.0618.2.000	Thread Pickup Lever	2
18	01.4487.0.000	Spacer	2
19	40.0759.0.000	Hook	2
20	40.0428.1.001	Right Hand Pickup Holder	1
21	40.0428.1.002	Left Hand Pickup Holder	1
22	01.5455.0.000	Spring	2
23	01.1589.0.000	Screw	2
24	32.5029.0.000	Retainer	2
25	32.7197.0.000	Spring	2
26	32.5024.0.000	Right Hand Pickup Arm	1
27	01.2515.0.000	#4-48 x .12 Set Screw	2
28	01.2419.0.000	#4-40 x 1/0 Screw	4
29	03.6802.4.100	#4 Lock Washer	4
30	01.4072.0.000	#4 Flat Washer	4
31	40.0760.1.000	Retainer	2
32	01.6569.0.000	Spring Pin	4
33	32.5025.0.000	Left Hand Pickup Arm	1
34	40.0418.2.001	Right Hand Bracket	1
35	40.0418.2.002	Left Hand Bracket	1
36	42.0619.0.000	Link	2
37	32.7193.0.000	Thread Pick-up Spacer	2
38	01.2419.1.001		4

Spacing Charts begin on page 3-50.

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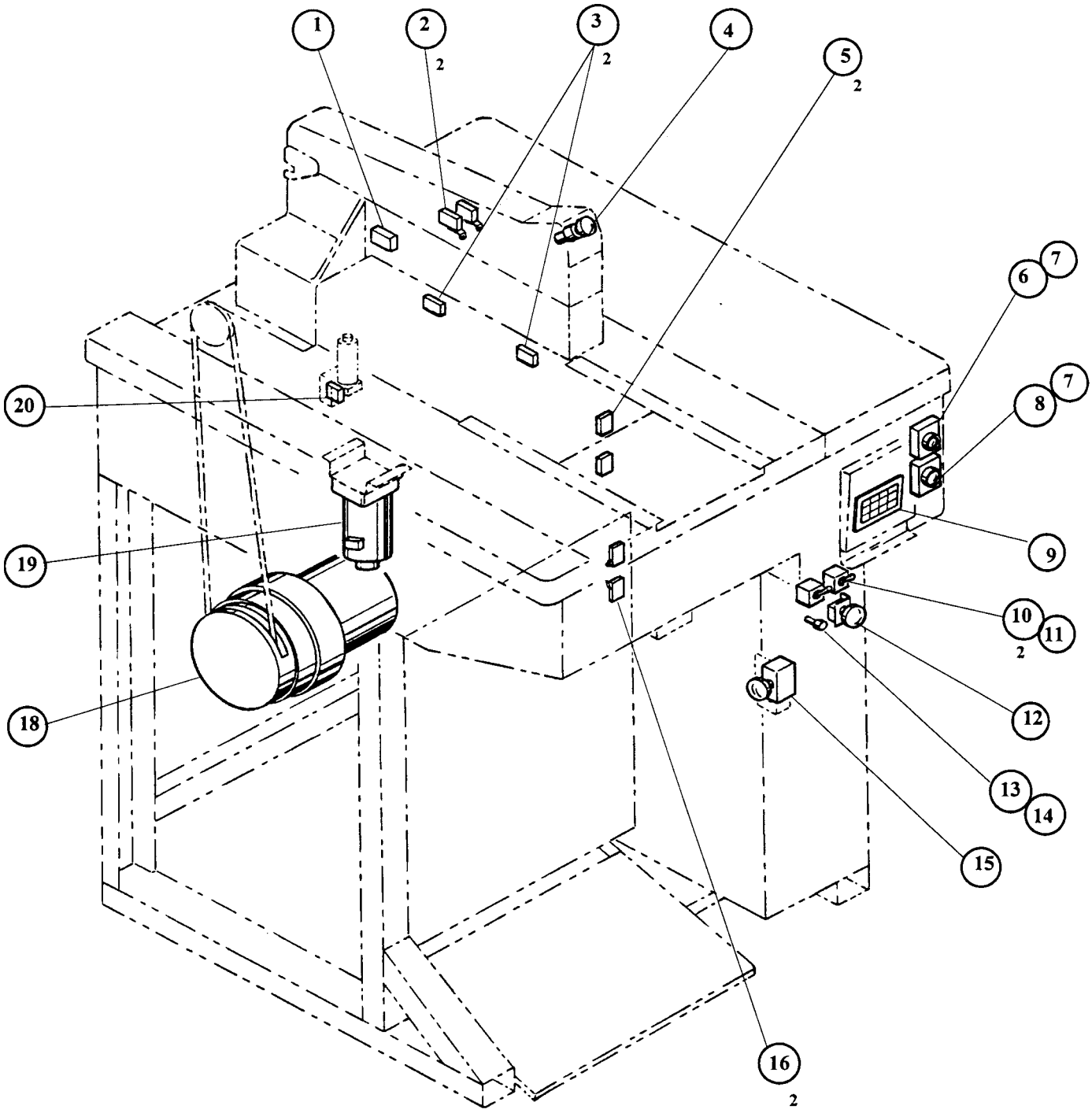
ELECTRICAL ASSEMBLY



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ELECTRICAL ASSEMBLY

ITEM	PART NUMBER	DESCRIPTION	QTY.
1	32.7954.0.050	Needle Up Proximity Switch	1
2	04.1358.1.000	Thread Break Switch	2
3	06.0120.0.000	Clamp Table Switch	2
4	07.6320.0.002	Sew Interrupt Switch	1
5	06.0120.0.000	Tab Knife Switch	1
6	07.6006.0.003	On Switch	1
7	07.6006.0.008	Latch/ Pwr. Module	2
8	07.6006.0.004	Threading Safety Switch	1
9	07.6483.0.001	Keypad	1
10	07.6081.0.000	Power & Motor On Switch	2
11	30065-403	Power & Motor "On-Off" Decals	1
12	07.6006.0.005	Emergency Power Off Switch	1
13	07.6043.0.000	Fuse Holder	1
14	07.6043.0.001	Fuse	1
15	07.6006.0.002	Knee Switch	1
16	06.0120.0.000	Threadle Switch	2
18	32.7952.0.050	Motor, 3 Phase, 220/380 Volt	1
	32.7957.0.050	Motor, 1 Phase, 110/220 Volt	1
	32.7956.0.050	Modified Controller	
	07.6280.0.003	Motor, 3 Phase, 220/380 Volt	
	07.6280.0.006	Motor, 1 Phase, 110/220 Volt	
	07.6280.0.005	Synchronizer	
19	32.7953.0.050	Clamp Table Motor	1
20	06.0120.0.000	Brushes Switch	1
21	06.0864.0.000	Upper Tab Knife Switch Actuator	1
22	06.0865.0.000	Upper tab Knife Switch	1
23	27861-605	Kable and Plug Bar Key pad	
24	07.6281.0.000	Encoder	1
25	07.6006.0.010	Bulb 24V	

* Some machines have a 3 phase, 220 volt, 60 cycle

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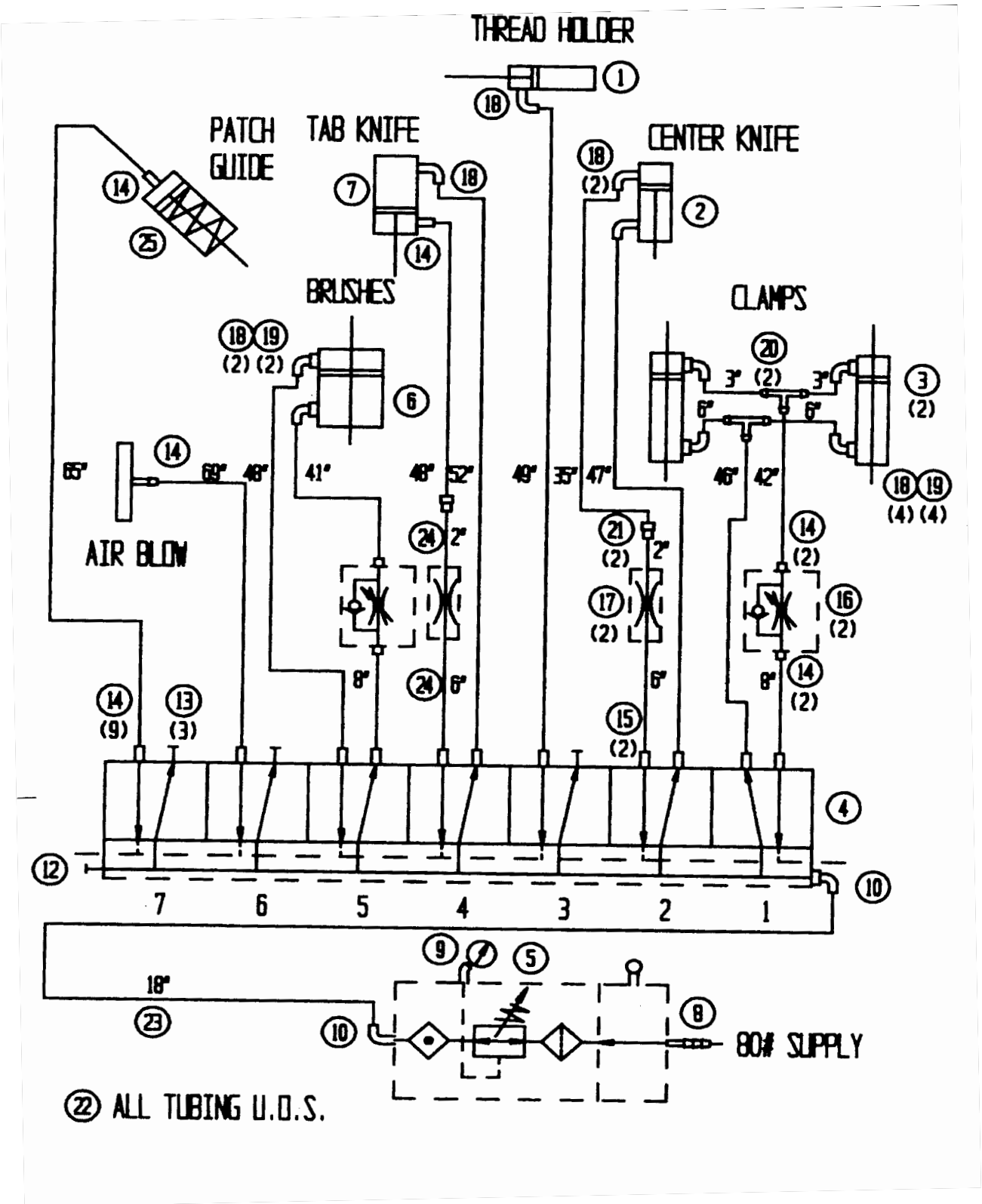

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PNEUMATIC ASSEMBLY

ITEM	PART NUMBER	DESCRIPTION	QTY.
1	07.6001.0.003	Thread Holder Cylinder	1
2	07.6001.0.002	Center Knife Cylinder	1
3	07.6001.0.005	Clamp Cylinder	2
4	07.6520.0.000	Valve Bank	1
5	07.6520.0.002	Filter Regulator Gauge Assembly	1
6	07.6001.0.001	Brush Cylinder	1
7	07.6080.0.000	Tab Knife Cylinder	1
8	07.6602.0.000	1/8 P x 3/16 T Connector	1
9	25521-353	1/8 M x 1/8 F 45 Deg. Elbow	1
10	25521-593	1/8 P x 1/8 T Elbow	1
12	25521-590	1/8 NPT Plug	1
13	25521-560	#10-32 Plug	2
14	25521-562	#10-32 x 3/32 Connector	20
15	25521-602	Restrictor, Check	1
16	26112-012	Flow Control	2
17	25521-598	Restrictor	3
18	25521-569	#10-32 x 3/32 Elbow	12
19	25521-591	1/8 NPT x 10-32 Reducer	6
20	25521-585	3/32 Equal Tee	2
21	20.6326.0.000	Patch Guide Cylinder	1
22	07.6086.0.000	3/32 ID Tubing	54'
23	07.6086.0.001	1/8 ID Tubing	2’
24	20.6042.0.000	Muffler	2
25	01.2153.0.003	8-32 x 1.750	2
26	01.3524.0.000	# 4 x 40 Nut	2
27	01.4407.0.000	Washer	2
28	03.6000.4.120	# 4-40 x 1.2 Screw	2
29	03.6702.8.100	# 8 x 32 Nut	2
30	25521602	Restr. CHK	1

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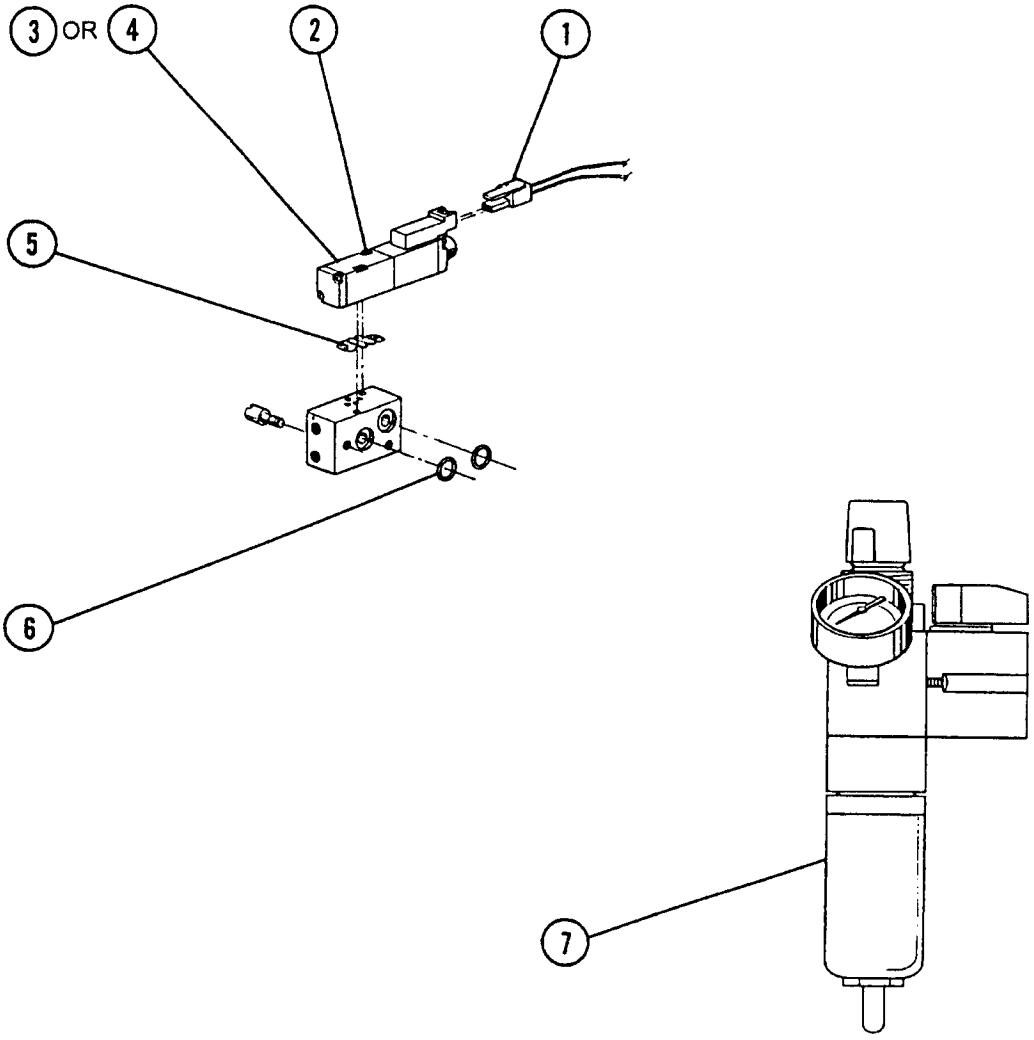

ITEM	PART NUMBER	DESCRIPTION
1	07.6520.0.001	Plug Assembly
2	07.6520.0.006	Mounting Screw
3	07.6520.0.005	Single Selenoid Valve
4	07.6520.0.003	Double Selenoid Valve
5	07.6520.0.007	Gasket
6	07.6520.0.008	Seal
7	07.6520.0.009	Filter Element

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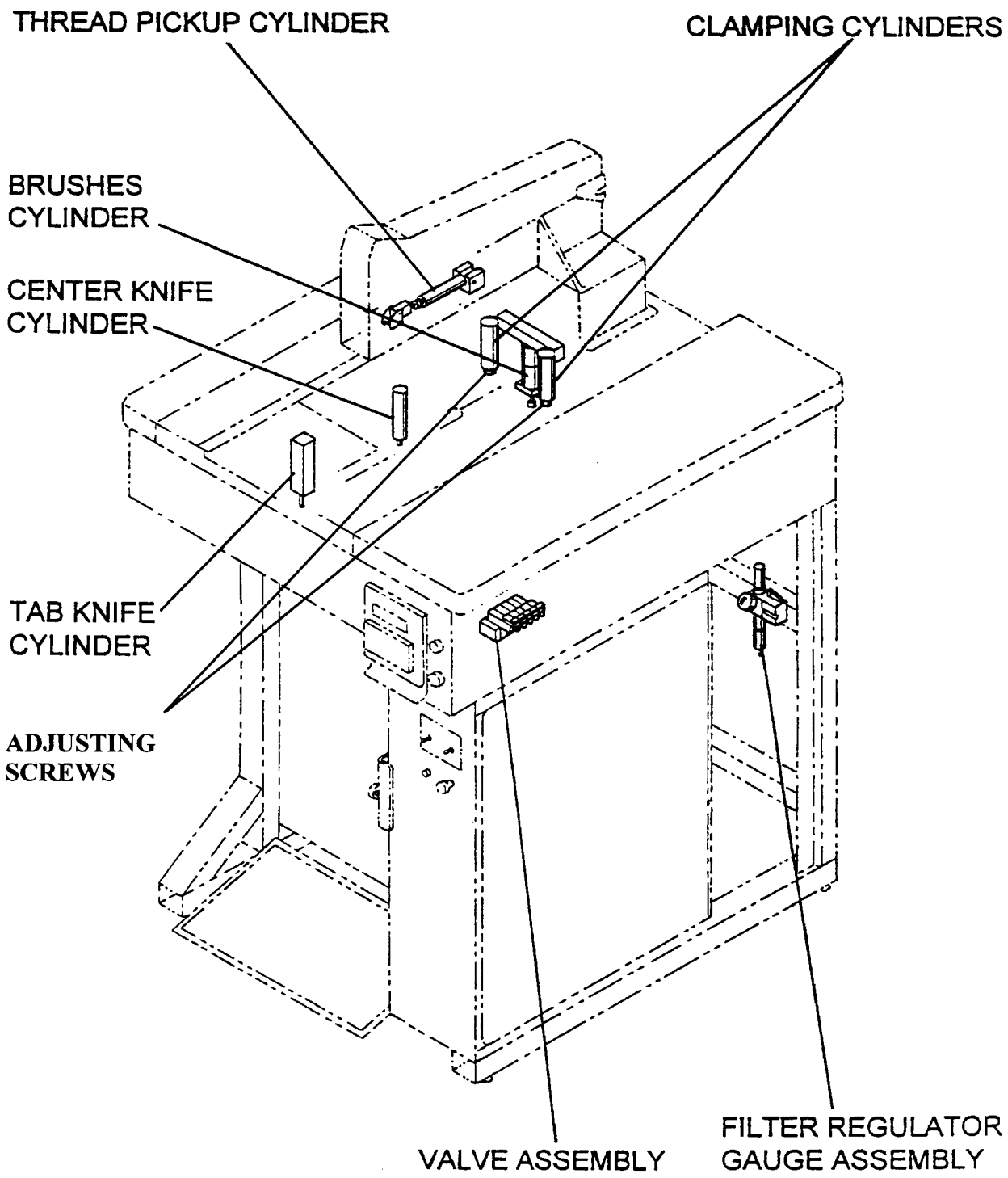
PNEUMATIC COMPONENTS LOCATION



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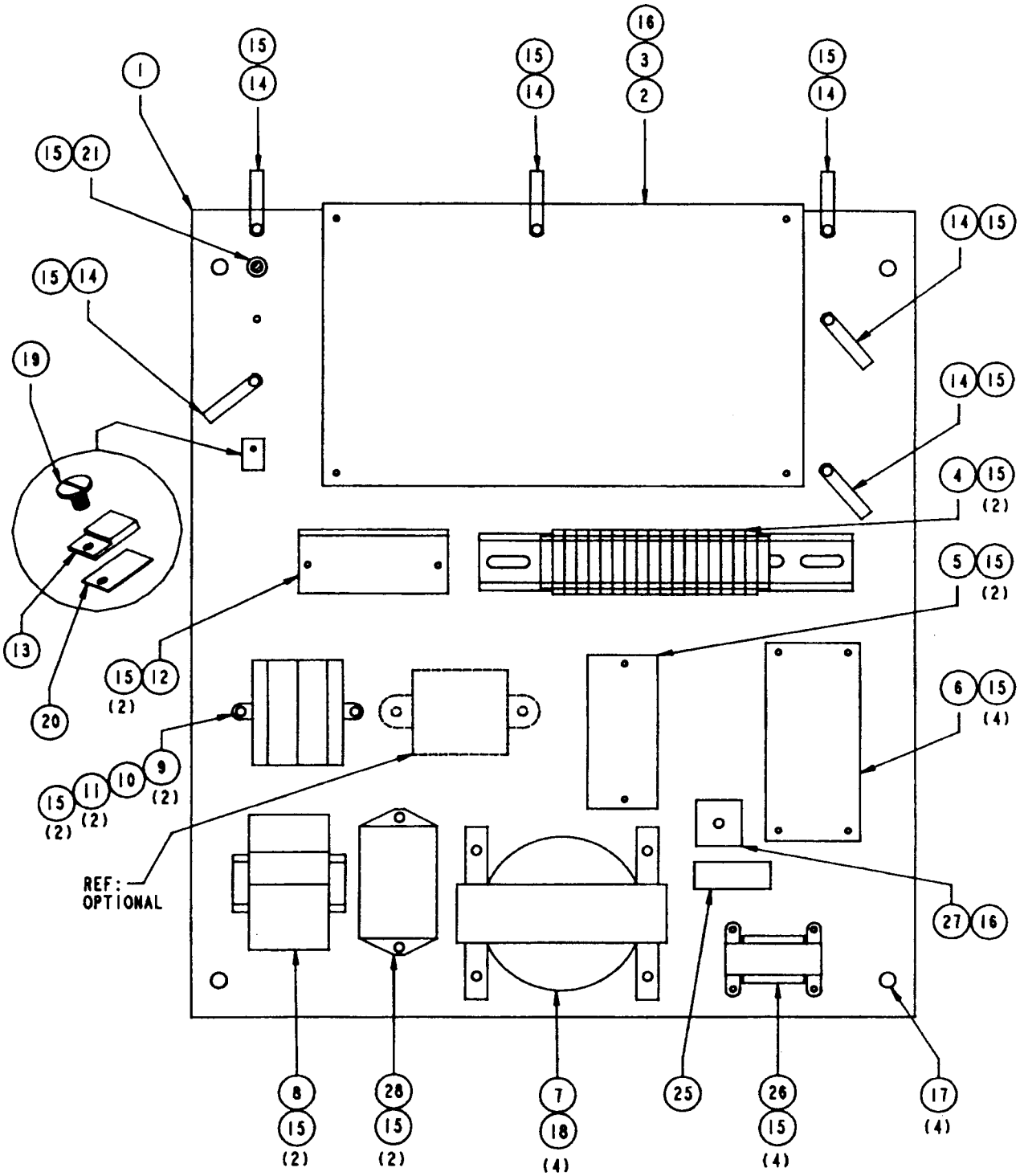
ELECTRICAL PANEL ASSEMBLY



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ELECTRICAL PANEL ASSEMBLY

ITEM	PART NUMBER	DESCRIPTION	QTY.
1	32.7101.0.000	Electrical Panel	1
2	32.7818.0.050	PC Board	1
3	32.7990.0.000	Std. "E" Prom	1
4	07.6720.0.005	Terminal Block Assembly	1
5	07.6082.0.001	5V Power Supply	1
6	27378-690	24V Power Supply	1
7	**07.6482.0.000	Transformer	1
8	07.6720.0.004	Starter (220V/380V)	1
	07.6720.0.012	Starter (110V)	1
9	07.6044.0.000	Fuse Holder	2
10	07.6044.0.001	Fuse Holder End	1
11	27811101	Fuse	2
12	07.6483.0.002	Servo Driver Board	1
13	07.6483.0.003	Voltage Regulator	1
14	07.6600.0.010	3/4 Cable Clamp	9
15	01.2816.0.000	#8-32 x 3/8 Bind. Hd. Screw	30
16	03.6222.8.116	#8-32 x 1 Bind. Hd. Screw	5
17	01.3549.0.000	#5/16-18 Hex Nut	4
18	03.6222.0.206	#10-32 x 3/8 Bind. Hd. Screw	4
19	03.6225.6.104	#6-32 x 1/4 Plastic Screw	1
20	07.6521.0.002	Mylar Isolator	1
21	01.4579.0.003	#8 Flat Washer	1
22	32.7181.0.000	High Voltage Cover	1
23	01.2811.1.000	#6-32 x 1/2 Bind. Hd. Screw	1
24	07.6600.0.011	7/8 Cable Clamp	1
25	07.6521.0.006	Capacitor, 2200	1
26	07.6521.0.005	Transformer	1
27	27122-566	Rectifier	1
28	07.6087.0.002	Power Line Filter	1
29	01.2448.0.000	Screw 6-32 x 1/2	1
30	01.4411.0.000	Flat Washer #6	1
31	07.6600.0.011	Collar	1
32	3771107		1
33	39000010	Stud Asm	1
34	07.6087.0.002	Filter, power line	1
35	12.0008.4.263		1
36	27123760	T' Former	1
37	27511165	Cord Grip	1
38	27511197	Cord Grip	1
39	27511886		3
40	27511891	Fitting	2

** Transformer (Item #7) not required with 110V service.

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3/8 NEEDLE SPACING CHART

PAGE	ITEM	DESCRIPTION	PART NUMBER	D.W. (.725)	D.W. (.661)	S.W. (.661)
3-5	5	Patch Tray	32.2170.0.001	2	2	2
3-14	5	Throat Plate	32.2070.1.051	1	1	1
3-14	15	Trim Knife Bracket	32.2215.0.000	1	1	1
3-14	16	Trim Knife	32.2040.0.000	1	1	1
3-14	23	Needle Holder	32.2200.0.001	1	1	1
3-22	1	Tab Knife Holder	32.2044.0.050	2	2	2
3-22	3	Tab Knife Set	32.2047.1.050	2	2	2
3-22	3	Double Edge Knife	32.2047.1.000	4	4	4
3-26	5	Rear Clamp Arm	42.0071.0.007	2	2	2
3-26	18	Clamp Foot Assembly	40.0069.0.050	1	1	1
3-28	3	Upper L.H. Brush Arm	42.0073.0.002	1	1	1
3-28	11	Upper R.H. Brush Arm	42.0073.0.001	1	1	1
3-30	1	L.H.Brush	40.0070.0.072	1	1	1
3-30	2	L.H. Patch Locator	40.0470.0.072	1	1	1
3-30	9	R.H. Patch Locator	40.0470.0.071	1	1	1
3-30	10	R.H. Brush	40.0070.0.071	1	1	1
3-30	11	Brush Blade - Heavy	41.0089.0.570	2 Req.	per	mach.
3-30	11	Brush Blade - Medium	41.0089.0.670	2 Req.	per	mach.
3-30	11	Brush Blade - Medium/Light	41.0089.0.770	2 Req.	per	mach.
3-30	11	Brush Blade - Light	41.0089.0.870	2 Req.	per	mach.
3-32	22	Patch Guide Assembly	32.7080.0.725	1	-	-
3-32	22	Patch Guide Assembly	32.7080.0.661	-	1	-
3-32	22	Patch Guide Assembly	32.7081.0.661	-	-	1
3-32	25	Horizontal Plate	32.7200.0.725	1(SP)	-	-
3-32	25	Horizontal Plate	32.7200.0.661	-	1(SP)	-
3-32	25	Horizontal Plate	32.7210.0.661	-	-	1(SP)
3-40	14	Thread Pickup Pin	01.6567.0.000	2	2	2
3-40	23	Screw	01.1589.0.000			
3-21	9	Screw	01.2435.0.000			
		Screw	01.2616.0.000			

SP - Spare Parts Only

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7/16 NEEDLE SPACING CHART

PAGE	ITEM	DESCRIPTION	PART NUMBER	D.W. (.690)	S.W. (.730)	S.W.O. (.759)
3-5	5	Patch Tray	32.2170.0.001	2	2	2
3-14	5	Throat Plate	32.2070.1.052	1	1	1
3-14	15	Trim Knife Bracket	32.2062.0.000	1	1	1
3-14	16	Trim Knife	32.2067.0.000	1	1	1
3-14	23	Needle Holder	32.2200.0.002	1	1	1
3-22	1	Tab Knife Holder	32.2046.0.050	2	2	2
3-22	3	Tab Knife Set	32.2047.1.050	2	2	2
3-22	3	Double Edge Knife	32.2047.1.000	4	4	4
3-26	5	Rear Clamp Arm	42.0071.0.007	2	2	2
3-26	18	Clamp Foot Assembly	41.0069.0.053	1	1	1
3-28	3	Upper L.H. Brush Arm	42.0073.0.002	1	1	1
3-28	11	Upper R.H. Brush Arm	42.0073.0.001	1	1	1
3-30	1	L.H. Brush	40.0070.0.072	1	1	1
3-30	2	L.H. Patch Locator	40.0470.0.072	1	1	1
3-30	9	R.H. Patch Locator	40.0470.0.071	1	1	1
3-30	10	R.H. Brush	40.0070.0.071	1	1	1
3-30	11	Brush Blade - Heavy	41.0089.0.570	2 Req.	per	mach.
3-30	11	Brush Blade - Medium	41.0089.0.670	2 Req.	per	mach.
3-30	11	Brush Blade - Medium/Light	41.0089.0.770	2 Req.	per	mach.
3-30	11	Brush Blade - Light	41.0089.0.870	2 Req.	per	mach.
3-32	22	Patch Guide Assembly	32.7080.0.810			
3-32	22	Patch Guide Assembly	32.7080.0.690	1(SP)	-	-
3-32	22	Patch Guide Assembly	32.7080.0.730	-	1(SP)	-
3-32	22	Patch Guide Assembly	32.7081.0.759	-	-	1(SP)
3-32	25	Horizontal Plate	32.7200.0.810			
3-32	25	Horizontal Plate	32.7200.0.690	1	-	-
3-32	25	Horizontal Plate	32.7200.0.730	-	1	-
3-32	25	Horizontal Plate	32.7210.0.759	-	-	1
3-40	14	Thread Pickup Pin	01.6567.0.000	2	2	2

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1/2 NEEDLE SPACING CHART

PAGE	ITEM	DESCRIPTION	PART NUMBER	D.W. (.786)	D.W. (.850)	S.W. (.801)	S.W. (.945)	D.W. (.940)
3-5	5	Patch Tray	32.2170.0.001	1	1	1	1	1
3-14	5	Throat Plate	32.2070.1.053	1	1	1	1	1
3-14	15	Trim Knife Bracket	32.2062.0.000	1	1	1	1	1
3-14	16	Trim Knife	32.2061.0.000	1	1	1	1	1
3-14	23	Needle Holder	32.2200.0.003	1	1	1	1	1
3-22	1	Tab Knife Holder	32.2046.0.050	2	2	2	2	2
3-22	3	Tab Knife Set	32.2047.1.050	2	2	2	2	2
3-22	3	Double Edge Knife	32.2047.1.000	4	4	4	4	4
3-26	5	Rear Clamp Arm	42.0071.0.007	2	2	2	2	2
3-26	18	Clamp Foot Assembly	41.0069.0.053	1	1	1	1	1
3-28	3	Upper L.H. Brush Arm	42.0073.0.002	1	1	1	1	1
3-28	11	Upper R.H. Brush Arm	42.0073.0.001	1	1	1	1	1
3-30	1	L.H. Brush	40.0070.0.072	1	1	1	1	1
3-30	2	L.H. Patch Locator	40.0470.0.072	1	1	1	1	1
3-30	9	R.H. Patch Locator	40.0470.0.071	1	1	1	1	1
3-30	10	R.H. Brush	40.0070.0.071	1	1	1	1	1
3-30	11	Brush Blade - Heavy	41.0089.0.570	2	Req.	per	mach.	
3-30	11	Brush Blade - Medium	41.0089.0.670	2	Req.	per	mach.	
3-30	11	Brush Blade - Medium/Light	41.0089.0.770	2	Req.	per	mach.	
3-30	11	Brush Blade - Light	41.0089.0.870	2	Req.	per	mach.	
3-32	22	Patch Guide Assembly	32.7080.0.940	-	-	-	-	1
3-32	22	Patch Guide Assembly	32.7080.0.786	1	-	-	-	-
3-32	22	Patch Guide Assembly	32.7080.0.850	-	1	-	-	-
3-32	22	Patch Guide Assembly	32.7081.0.801	-	-	1	-	-
3-32	22	Patch Guide Assembly	32.7081.0.945	-	-	-	1	-
3-32	25	Horizontal Plate	32.7200.0.940					1
3-32	25	Horizontal Plate	32.7200.0.786	1	-	-	-	-
3-32	25	Horizontal Plate	32.7200.0.850	-	1	-	-	-
3-32	25	Horizontal Plate	32.7210.0.801	-	-	1	-	-
3-32	25	Horizontal Plate	32.7210.0.945	-	-	-	1	-
3-40	14	Thread Pickup Pin	01.6567.0.000	2	2	2	2	2

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5/8 NEEDLE SPACING CHART

PAGE	ITEM	DESCRIPTION	PART NUMBER	D.W. (1.100)	D.W. (1.148)	S.W. (1.230)	D.W.
3-5	5	Patch Tray	32.2175.0.001	2	2	2	2
3-14	5	Throat Plate	32.2070.1.054	1	1	1	1
3-14	15	Trim Knife Bracket	32.2062.0.000	1	1	1	1
3-14	16	Trim Knife	32.2125.0.000	1	1	1	1
3-14	23	Needle Holder	32.2200.0.004	1	1	1	1
3-22	1	Tab Knife Holder	32.2049.0.051	2	2	2	2
3-22	3	Tab Knife Set	32.2048.1.050	2	2	2	2
3-26	5	Rear Clamp Arm	42.0071.0.007	2	2	-	2
3-26	5	Rear Clamp Arm	42.0071.0.010	-	-	2	-
3-26	18	Clamp Foot Assembly	41.0069.0.050	1	1	1	1
3-28	3	Upper L.H. Brush Arm	42.0073.0.002	1	1	1	1
3-28	11	Upper R.H. Brush Arm	42.0073.0.001	1	1	1	1
3-30	1	L.H. Brush	41.0070.0.072	1	1	1	1
3-30	2	L.H. Patch Locator	40.0470.0.074	1	1	-	1
3-30	2	L.H. Patch Locator	40.0470.0.072	-	-	1	-
3-30	9	R.H. Patch Locator	40.0470.0.073	1	1	1	1
3-30	10	R.H. Brush	41.0070.0.071	1	1	1	1
3-30	11	Brush Blade - Heavy	41.0089.0.570	2 Req.	per	mach.	
3-30	11	Brush Blade - Medium	41.0089.0.670	2 Req.	per	mach.	
3-30	11	Brush Blade - Medium/Light	41.0089.0.770	2 Req.	per	mach.	
3-30	11	Brush Blade - Light	41.0089.0.870	2 Req.	per	mach.	
3-32	22	Patch Guide Assembly	32.7080.1.190	-	-	-	1
3-32	22	Patch Guide Assembly	32.7080.1.100	1	-	-	-
3-32	22	Patch Guide Assembly	32.7080.1.148	-	1	-	-
3-32	22	Patch Guide Assembly	32.7081.1.230	-	-	1	-
			32.7200.1.190				1
3-32	25	Horizontal Plate	32.7200.1.100	1	-	-	-
3-32	25	Horizontal Plate	32.7200.1.148	-	1	-	-
3-32	25	Horizontal Plate	32.7210.1.230	-	-	1	-
3-32	28	Spacer Plate	32.7220.0.000	-	-	1	2
3-40	14	Thread Pick-up Pin	01.6973.0.003	1	1	1	1

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3/4 NEEDLE SPACING CHART

PAGE	ITEM	DESCRIPTION	PART NUMBER	D.W. (1.350)	S.W. (1.470)	S.W.O. (2.100)	D.W. (1.440)
3-5	5	Patch Tray	32.2175.0.001	2	2	2	2
3-14	5	Throat Plate	32.2070.1.055	1	1	1	1
3-14	15	Trim Knife Bracket	32.2062.0.000	1	1	1	1
3-14	16	Trim Knife	32.2126.0.000	1	1	1	1
3-14	23	Needle Holder	32.2200.0.005	1	1	1	1
3-22	1	Tab Knife Holder	32.2049.0.052	2	2	2	2
3-22	3	Tab Knife Set	32.2048.1.050	2	2	2	2
3-26	5	Rear Clamp Arm	42.0071.0.007	2	-	2	2
3-26	5	Rear Clamp Arm	42.0071.0.010	-	2	-	-
3-26	18	Clamp Foot Assembly	41.0069.0.051	1	1	1	1
3-28	3	Upper L.H. Brush Arm	42.0073.0.002	1	-	-	1
3-28	3	Upper L.H. Brush Arm	42.0073.0.010	-	1	1	-
3-28	11	Upper R.H. Brush Arm	42.0073.0.001	1	1	-	1
3-28	11	Upper R.H. Brush Arm	42.0073.0.020	-	-	1	-
3-30	1	L.H. Brush	41.0070.0.072	1	1	1	1
3-30	2	L.H. Patch Locator	40.0470.0.072	-	1	-	-
3-30	2	L.H. Patch Locator	40.0470.0.074	1	-	1	1
3-30	9	R.H. Patch Locator	40.0470.0.073	1	1	1	1
3-30	10	R.H. Brush	41.0070.0.071	1	1	1	1
3-30	11	Brush Blade - Heavy	41.0089.0.570	2 Req.	per	mach.	
3-30	11	Brush Blade - Medium	41.0089.0.670	2 Req.	per	mach.	
3-30	11	Brush Blade - Medium/Light	41.0089.0.770	2 Req.	per	mach.	
3-30	11	Brush Blade - Light	41.0089.0.870	2 Req.	per	mach.	
3-32	22	Patch Guide Assembly	32.7080.1.440	-	-	-	1
3-32	22	Patch Guide Assembly	32.7080.1.350	1	-	-	-
3-32	22	Patch Guide Assembly	32.7081.1.470	-	1	-	-
3-32	22	Patch Guide Assembly	32.2128.0.050	-	-	1	-
3-32	25	Horizontal Plate	32.7200.1.440	-	-	-	1
3-32	25	Horizontal Plate	32.7200.1.350	1	-	-	-
3-32	25	Horizontal Plate	32.7210.1.470	-	1	-	-
3-32	25	Horizontal Plate	32.2127.0.000	-	-	1	-
3-32	26	Spacer Strip	32.7221.0.000	2	2	2	2
3-32	28	Spacer Plate	32.7220.0.000	2	2	2	2
3-40	14	Thread Pick-up Pin	01.6973.0.001	1	1	1	1

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7/8 NEEDLE SPACING CHART

PAGE	ITEM	DESCRIPTION	PART NUMBER	D.W. (1.655)	S.W. (1.669)	D.W. (1.690)
3-5	5	Patch Tray	32.2175.0.001	2	2	2
3-14	5	Throat Plate	32.2070.1.056	1	1	1
3-14	15	Trim Knife Bracket	32.2062.0.000	1	1	1
3-14	16	Trim Knife	32.2119.0.000	1	1	1
3-14	23	Needle Holder	32.2200.0.006	1	1	1
3-22	1	Tab Knife Holder	32.2049.0.053	2	2	2
3-22	3	Tab Knife Set	32.2048.1.050	2	2	2
3-26	5	Rear Clamp Arm	42.0071.0.007	2	-	2
3-26	5	Rear Clamp Arm	42.0071.0.010	-	2	-
3-26	18	Clamp Foot Assembly	41.0069.0.052	1	1	1
3-28	3	Upper L.H. Brush Arm	42.0073.0.002	1	-	1
3-28	3	Upper L.H. Brush Arm	42.0073.0.010	-	1	-
3-28	11	Upper R.H. Brush Arm	42.0073.0.001	1	-	1
3-28	11	Upper R.H. Brush Arm	42.0073.0.020	-	1	-
3-30	1	L.H. Brush	41.0070.0.072	1	1	1
3-30	2	L.H. Patch Locator	41.0470.0.072	1	1	1
3-30	9	R.H. Patch Locator	41.0470.0.071	1	1	1
3-30	10	R.H. Brush	41.0070.0.071	1	1	1
3-30	11	Brush Blade - Heavy	41.0089.0.570	2 per	mach.	
3-30	11	Brush Blade - Medium	41.0089.0.670	2 per	mach.	
3-30	11	Brush Blade - Medium/Light	41.0089.0.770	2 per	mach.	
3-30	11	Brush Blade - Light	41.0089.0.870	2 per	mach.	
3-32	22	Patch Guide Assembly	32.7080.1.690	-	-	1
3-32	22	Patch Guide Assembly	32.7080.1.655	1	-	-
3-32	22	Patch Guide Assembly	32.7081.1.669	-	1	-
3-32	25	Horizontal Plate	32.7200.1.690	-	-	1
3-32	25	Horizontal Plate	32.7200.1.655	1(SP)	-	-
3-32	25	Horizontal Plate	32.7210.1.669	-	1(SP)	-
3-32	26	Spacer Strip	32.7221.0.000	4	4	4
3-32	28	Spacer Plate	32.7220.0.000	2	2	2
3-40	14	Thread Pick-up Pin	01.6973.0.003	1	1	1

SP = Spare Parts Only

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NEEDLES CHART

PART NUMBER	SIZE	CHARACTERISTICS	APPLICATIONS
02.0950.3.100 02.0950.3.110 02.0950.3.111 02.0950.3.112	Very fine (00) Fine (0) Medium (1) Heavy (2)	Sharp point Sharp point (spotted) Sharp point (spotted) Sharp point (spotted)	Standard for the mahority of fibres and materials of average weight and texture, including knit goods.
02.0952.0.100 02.0952.3.110 02.0952.0.111	Very fine (00) Fine (0) Medium (1)	Ball Point Ball Point (spotted) Ball Point (spotted)	Use on synthetic fabrics, particularly it tightly woven or tightly knited where the fibers of the material are subject to damage by the conventional sharp pointed needle.
02.0956.0.111	Medium (1)	Wedge point, ball eye, double groove (spotted)	Applicable to leather and similar materials where conventional sharp pointed needles tent to leave excessive punctures. The slit made by the wedge point tends to close after penetration. Double groove is desirable on thick leather and similar materials that tent to close on blade and trap needle thread as it descends into work. NOTE: Use double groove needle only when conditions warrant, as loop case is smaller and may introduce skipping. Set looper points extremely close to needle blade.
02.0958.0.111	Medium (1)	Spear point, ball eye, double groove (spotted)	Applicable to closely woven or heavily starched fabrics, leather, and similar materials that offer considerable resistance to needle penetration. The ball eye tends to reduce needle heating. Double groove minimizes tendency of material to trap the needle thread during descent into work, but the loopers must be set extremely close to needles to avoid skipping.

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

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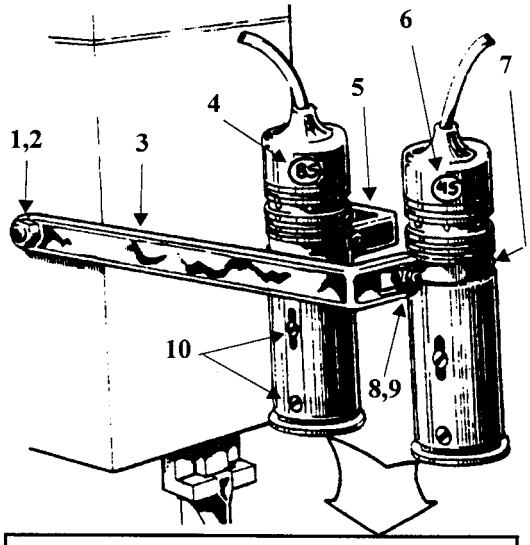
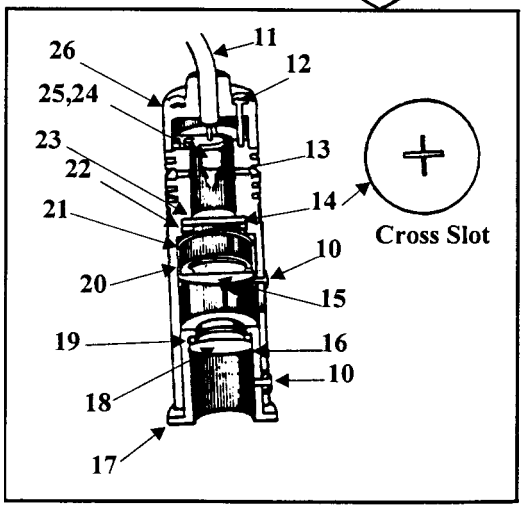
WORK LOCATING & DRILL HOLE LAMPS (OPTIONAL)

ITEM	PART NUMBER	DESCRIPTION
1	42.1005.0.000	Lamp Arm Stud
2	01.3417.0.000	10-24 Lock Washer
3	42.1002.0.002	LH Lamp Arm
4	05.1085.0.002	Decal (8S)
5	42.1002.0.001	RH Lamp Arm
6	05.1085.0.001	Decal (4S)
7	40.0791.0.000	Brace
8	01.2531.0.000	6-32 Screw
9	01.3401.0.000	6-32 Nut
10	01.2481.0.000	4-40 Screw
11	40.0478.0.008	VF Sleeving (18")
12	01.2653.0.000	2-56 Screw
13	40.0788.0.000	Lamp
14	40.0834.0.004	Cross Slot Reticle (4S)
	40.0834.0.008	Cross Slot Reticle (8S)
15	40.0786.1.000	Lens
16	01.6628.0.000	Retaining Ring
17	40.0787.0.000	Carrier
18	40.0803.1.000	Lens
19	01.4507.0.000	O-Ring
20	01.6629.0.000	Retaining Ring
21	40.0785.0.000	Carrier
22	01.6621.0.000	Retaining Ring
23	40.0782.1.000	Flat Lantern Lens
24	40.0789.0.050	Lamp Holder Assembly
25	01.2518.0.000	2-56 Screw
26	40.0781.0.000	End Cap





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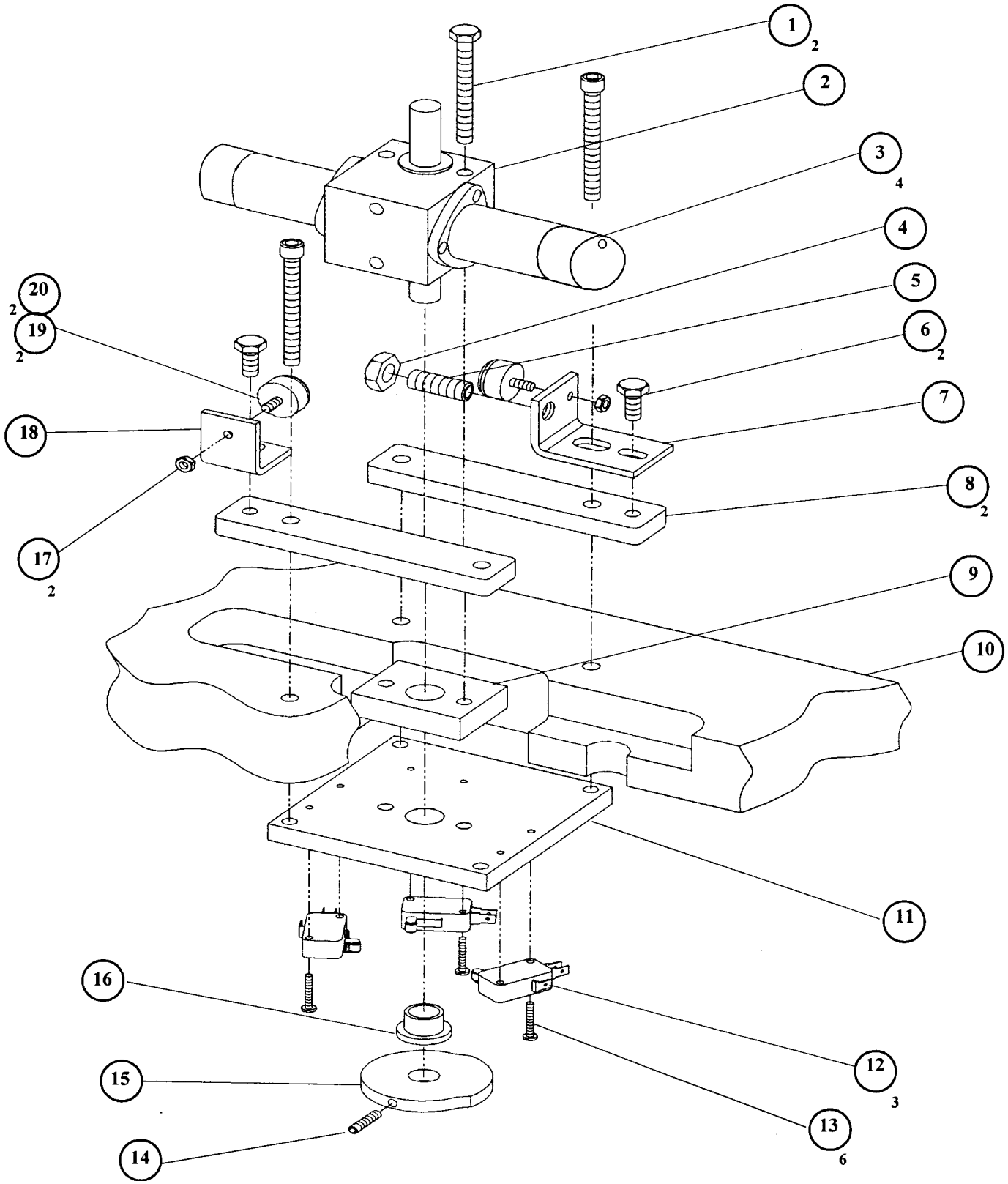
OPTIONS - AUTOMATIC PATCH LOADING



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OPTIONS - AUTOMATIC PATCH LOADING

ITEM	PART NUMBER	DESCRIPTION
1	04200060	#1/4-20 x 2 1/2 Hex Hd. Screw
2	07.6047.0.000	Rotary Actuator
3	01000049	#5/16-18 x 2 HSHC Screw
4	07.6161.0.001	3/8-32 Jam Nut
5	07.6161.0.003	Shock Absorber
6	01.2832.0.000	#1/4-20 x 1/2 Hex Hd. Screw
7	32.7505.0.000	APL Load Bracket
8	32.7504.1.000	APL Table Saddle
9	32.7503.0.000	APL Spacer
10	32.7500.1.000	APL Table Top
11	32.7501.0.000	APL Mounting Plate
12	06.0120.0.000	Micro Switch
13	04100037	#4-40 x 5/8 Bnd.Hd. Screw
14	01.2271.0.001	#8-32 x 1/2 Set Screw
15	32.7502.0.008	APL Switch Actuator
16	23161057	Flat Bushing
17	01.3553.0.000	#8 Hex Nut
18	32.7506.0.000	APL Home Stop
19	03.6862.8.100	#38 Fender Washer
20	07.6481.0.000	Bumper
21	0100048	5/16-18 x 1 1/2 HSHC Screw

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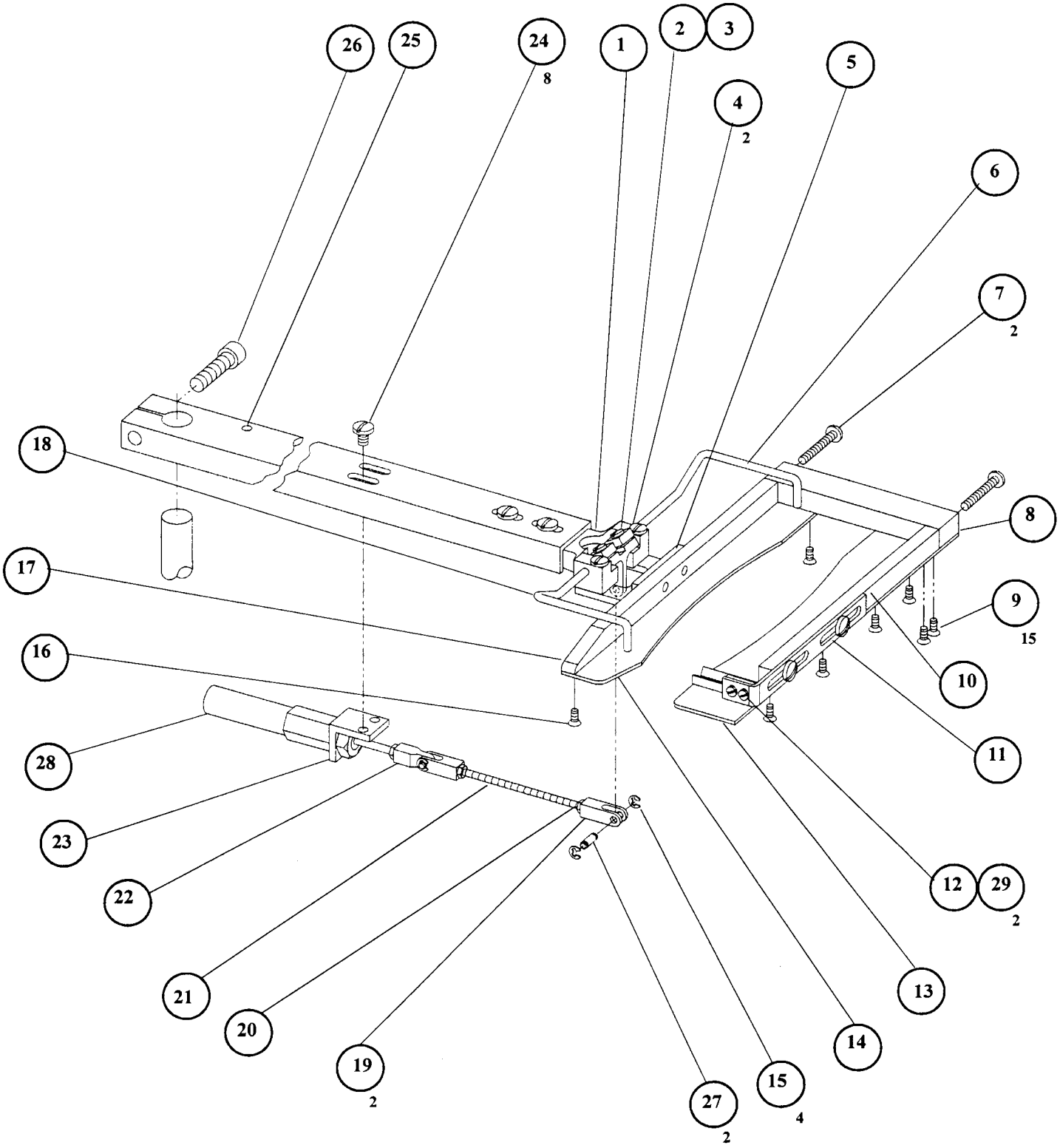

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OPTIONS - AUTOMATIC PATCH LOADING

ITEM	PART NUMBER	DESCRIPTION
1	44.2075.0.000	Patch Tray Neck
2	44.2076.0.000	Patch Holder Yoke
3	04100072	#4-40 x 5/16 Bnd. Hd. Screw
4	04100048	#6-32 x 3/4 Bnd. Hd. Screw
5	32.2151.0.000	Patch Tray Bracket
6	32.2152.0.000	Long Clamp
7	01.2712.0.000	#6-32 x 1" Btn. Hd. Screw
8	See Chart	Black Block
9	01.2488.0.000	#4-40 x 1/4 HSFH Screw
10	40.0832.0.002	Left Tray Rail
11	40.0514.1.000	Tray Ear
12	40.0841.0.000	Patch Holder
13	See Chart	Left Tray Rail
14	See Chart	Right Tray Rail
15	01.6368.0.000	E-Ring
16	01.2472.0.000	#4-40 x 3/16 HSFH Screw
17	40.0832.0.001	Right Tray Rail
18	32.2153.0.000	Short Clamp
19	44.2079.0.000	Clevis
20	01.3414.0.000	#4-40 Hex Nut
21	44.2082.0.000	Tie Rod
22	44.2078.0.000	Cylinder End
23	44.2077.0.000	Cylinder Mounting Bracket
24	04100053	#8-32 x 5/16 Bnd. Hd. Screw
25	44.2102.2.000	Patch Loader Arm
26	01.2421.0.001	#1/4-20 x 1" HSHC Screw
27	01.6943.0.000	Clevis Pin
28	07.0388.0.000	Cylinder
29	01.2597.0.000	#2-56 x 3/16 Bnd. Hd. Screw

Part	32.7808.0.050 (.690; .730)	32.7808.0.051 (.786; .850; .81)	32.7808.0.052 (.945)	32.7808.0.053 (.940)
Black Block	40.0515.1.275	40.0515.1.275	40.0515.1.300	40.0515.1.300
Tray Plate, Left	40.0830.0.187	40.0830.0.187	40.0830.0.438	40.0830.0.187
Tray Plate, Right	40.0831.0.187	40.0831.0.062	40.0831.0.938	40.0831.0.187

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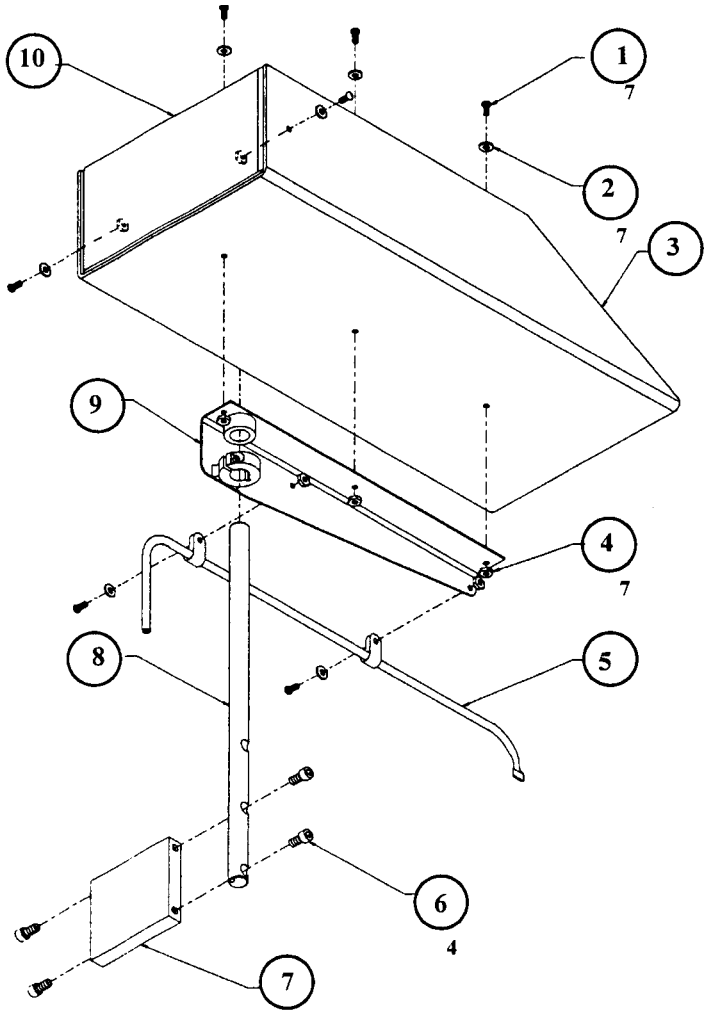
OPTIONS - AIR EJECT / SINGLE BAG TRAY KIT



KIT COMPLETE - ORDER P/N 32.7811.0.050

ITEM	PART NUMBER	DESCRIPTION
1	01200005	#8-32 x 3/8 Hex Screw
2	07012005	#8 Std. Flat Washer
3	32.7525.0.000	Tray
4	06000018	#8-32 Hex Nut
5	32.7530.0.000	Blow Down Tube
6	01200005	#8-32 x 3/8 Hex. Hd. Screw
7	32.7524.0.000	Tray Mount Block
8	32.7520.0.000	Tray Mount Post
9	32.7523.0.000	Angle Tray Mounting
10	32.7526.0.000	Tray Back

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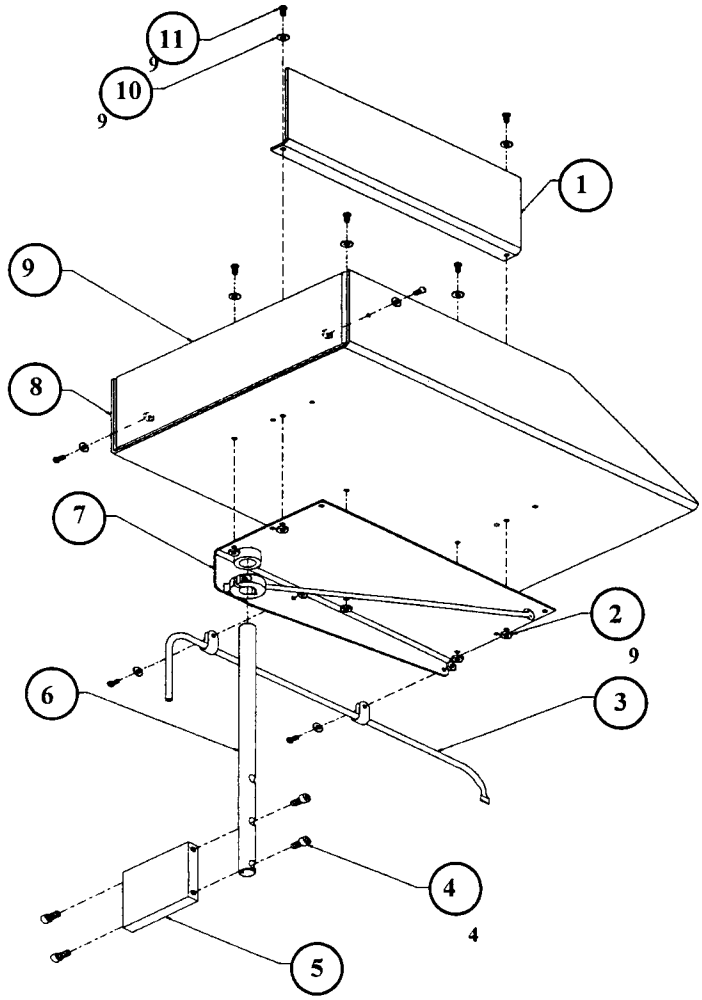
OPTIONS - AIR EJECT / DOUBLE BAG KIT



KIT COMPLETE - ORDER P/N 32.7811.0.051

ITEM	PART NUMBER	DESCRIPTION
1	32.7531.0.000	Double Tray Separator
2	06000003	#8-32 Hex Nut
3	32.7530.0.000	Blow Down Tube
4	01200005	#8-32 x 3/8 Hex Hd. Screw
5	32.7524.0.000	Tray Mount Black
6	32.7520.0.000	Tray Mount Post
7	32.7523.0.001	Angle Tray Mounting
8	32.7525.0.001	Double Tray
9	32.7526.0.001	Tray Back
10	07012005	Std. Flat Washer
11	01000014	#1/4-20 x 1/2 Hex Hd. Screw

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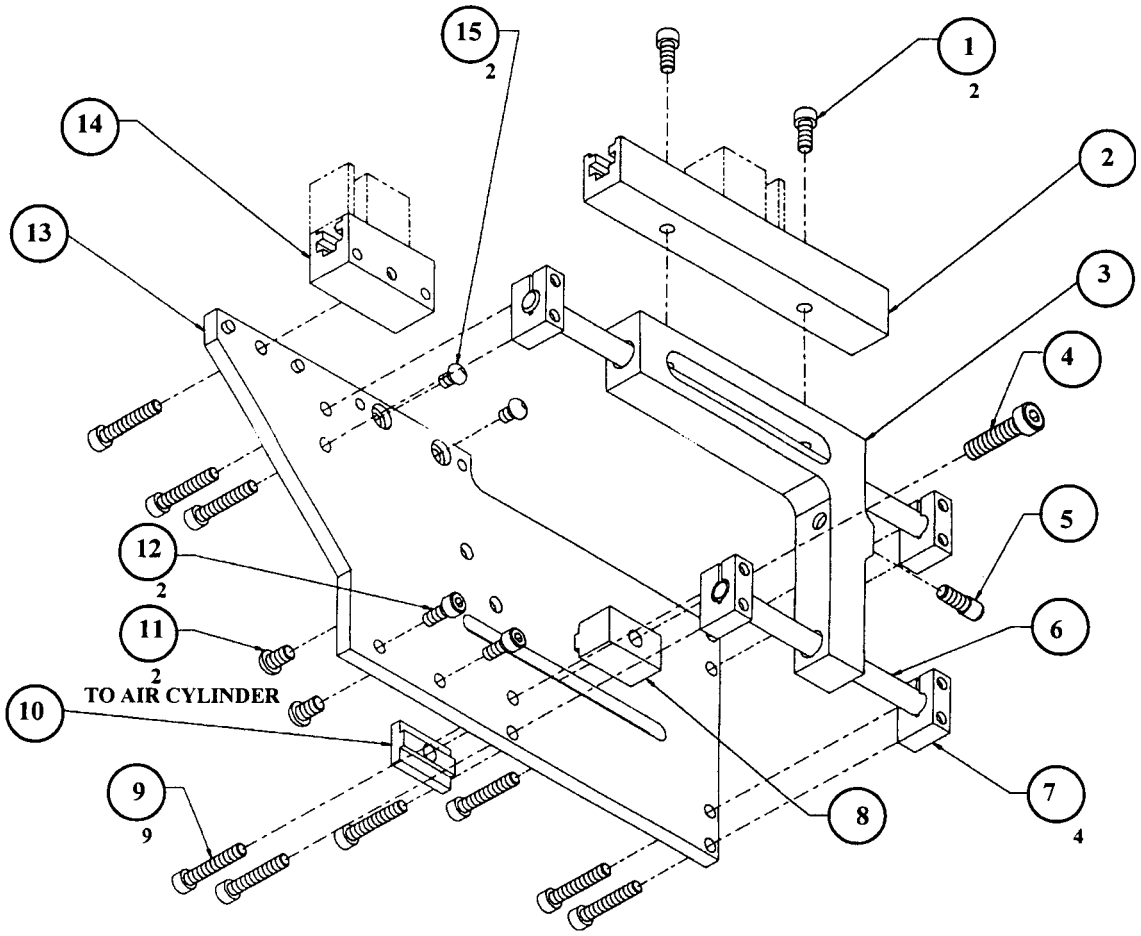
OPTIONS - 2-POSITION AUTO TAB KNIFE KIT



KIT COMPLETE - ORDER P/N 32.7810.0.050

ITEM	PART NUMBER	DESCRIPTION
1	01000023	#6-32 x 5/16 Soc. Hex Btn. Screw
2	32.7512.0.000	Adj. Knife Holder
3	32.7511.0.000	Carriage
4	01000019	#10-32 x 3/4 Soc. Hex Screw
5	06100011	#10-32 Lock Nut
6	32.7515.0.000	Short Shaft
7	32.7514.0.000	Shaft Support
8	32.7516.0.000	Adjustable Stop
9	01000080	#6-32 x 3/4 Soc. Hex Screw
10	32.7517.0.002	Stop Nut
11	01200011	#8-32 x 1/4 Soc. Hex Screw
12	01000023	#6-32 x 5/16 Soc. Hex Screw
13	32.7510.0.000	Mounting Plate
14	32.7513.0.000	Knife End-Holder
15	01200013	#6-32 x 3/16 Hex Soc. Btn. Screw

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