1. PLACE THE DRILL JIG ON THE MACHINE AS SHOWN.
2. ALIGN THE TOP OF THE DRILL JIG WITH THE TOP OF THE
   MACHINE BED.
3. TIGHTEN THE LOCKNUT ON END OF SHOULDER SCREW.
4. DRILL (2) TWO HOLES MARKED "A" WITH #29 DRILL
   (30-2130-29) SUPPLIED.
5. LOOSEN THE LOCKNUT AND REALIGN THE JIG SO THE
   TAPPING GUIDE HOLES WILL ALIGN WITH THE DRILLED HOLES.
6. TAP THE HOLES WITH AN 8-32 TAP (30-1266-01) USING THE TAP GUIDE
   HOLES TO GUIDE THE TAP STRAIGHT.
7. REMOVE THE DRILL JIG.
**NOTES:**

1. ASSEMBLE MOVABLE BLADE 01-9448-01 WITH SCREWS (2) 33-3106-04 AND LOCK WASHERS (2) 33-1806-01.
2. DO NOT TIGHTEN MOVABLE BLADE SCREWS AT THIS TIME. REFER TO ALIGNMENT ADJUSTMENT.

**NOTE:** ASSEMBLE STATIONARY BLADE AS SHOWN.
**WARNING!!**

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

---

**RADIAL**

- 33-3108-08 SCREW
- 33-3106-08 ADJUSTING SCREWS
- 01-3051-01 SCREW

**ALIGNMENT**

- 02-0034-01 ADJUSTING SCREW
- 33-3106-04 SCREW
- 30-2489-01 SET SCREW

**NOTES:**

1. LOOSEN SCREW 01-3051-01 AND 33-3108-08 AND ROTATE ASSEMBLY FOR PROPER ENGAGEMENT.
2. LOOSEN SCREWS 33-3106-08 AND ADJUST MOVABLE BLADE AGAINST STATIONARY BLADE AND LOCK IN PLACE.

**CHECK ALIGNMENT BETWEEN BLADES AND ADJUST FOR 1/32" OVERLAP**

**NOTE:**

LOOSEN SET SCREW 30-2489-01 AND ADJUST SCREW 02-0034-01 COUNTER-CLOCKWISE FOR MORE CUTTING EDGE ENGAGEMENT.

---

**AIR CIRCUIT DIAGRAM**

**4 WAY AIR VALVE, KNEE OPERATED**

- 01-1539-01 SUPPORT
- 33-3712-16 DOWEL PIN
- 30-2737-250 FITTING
- 30-2010-16 (3) SCREW-P.H.S.M.S.
- 30-0886-01 AIR VALVE
- 30-2738-250 ELBOW
- 33-0106-20 SCREW-P.H.S.M.S.
- 01-4412-01 ROD
- 30-0288-01 KNEE PLATE
- 30-0902-01 KNEE PAD

**From the library of: Superior Sewing Machine & Supply LLC**