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

SHEAR CUTTER FOR
SHOULDER TAPING OPERATION

- FOOT LIFTING LEVER
- AIR CYLINDER
- GUARD
- MOVABLE BLADE
- FIXED BLADE

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From the library of: Superior Sewing Machine & Supply LLC
### STEP 1
**DRILLING INSTRUCTIONS FOR THE FACE PLATE END**

Remove the existing hinged face plate including the hinge, along with the three screws holding the oil dam plate. Drill and tap the (3) three existing screw holes shown, with drill No. 29 (30-2130-29) and tap 8-32 (30-1266-01) supplied.

Drill & tap 1/2" deep these (3) three holes.

### STEP 2
**DRILLING INSTRUCTIONS FOR THE STATIONARY BLADE SUPPORT**

1. Place drill fixture on the machine as shown.
2. Drill (2) two holes 1/2" deep with No. 21 drill supplied (30-2130-21)
3. Remove drill fixture.
4. Tap the (2) two holes with 10-32 tap supplied (30-1875-01)

Existing screws for holding the drill fixture

Drill guide holes for drill No. 21.

### STEP 3
**INSTALL THE CUTTER AS A COMPLETE ASSEMBLY.** Start by placing the lift arm in and working the lift arm up and around between the machine wall and bar "A" as shown.

###(step 4)
**MOUNT VERTICAL SHEAR CUTTER WITH (3) SCREWS 33-3210-10.**

Note: later when the cutter is installed completely along with the stationary blade and all the adjustments have been made and the cutter is working perfectly, use the drills provided to drill holes for the dowel pins using the face plate holes as the template. Use drill #33 (30-1070-01) for the pilot holes first, 3/16" deep, then use 1/8" dia. (30-2376-08), same depth 3/16".

### STEP 5
**ADJUSTING THE MOVABLE BLADE**

Shoulder screw 33-4220-08 should be screwed into the blade support, finger tight. The hex nut 33-1516-01 is used to lock in the adjusted condition.

### ADJUSTMENTS

**WARNING!!** To prevent serious injury, disconnect air supply before making any adjustments.
STEP 6  ADJUSTING THE STATIONARY BLADE

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

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

ADJUST THE (2) SCREWS 33-1616-02 FOR THE RADIAL ADJUSTMENT OF THE FIXED BLADE AS SHOWN. RETIGHTEN THE (2) SCREWS 33-3210-08. TRY LOWERING THE MOVABLE BLADE SLOWLY (WITHOUT THE AIR BEING ON) FOR TESTING THE SHEARING ACTION. IT MAY REQUIRE SEVERAL ADJUSTMENTS TO GET EXACTLY YOUR CUTTING NEEDS.

02-0264-01 AIR CYLINDER SHAFT
02-0249-01 CLEVIS (shoulder screw)
02-0275-01 MOVABLE BLADE (shown in the down, start of the shearing position)
02-0252-01 FIXED BLADE
33-3210-03 SET SCREWS
02-0252-01 FIXED BLADE
33-3210-03 SCREW
33-2210-03 SET SCREW
02-0276-01 MOUNTING SCREW
33-1616-02 HEX NUT
02-0287-01 SPACER
02-0276-01 fixed blade support (with radial adjustment)
003/006 FAR SIDE OF FIXED BLADE'S RADIAL ADJUSTMENT FOR A SCISSOR LIKE CUT.
33-3210-08 mounting screw

FILTER, OILER, REGULATOR, GAUGE ASSEMBLY
80-0181-01
80-0181-10

30-2737-250 FITTING (80-0181-01)
30-2741-250 TEE (80-0181-10)

01-4528-01 BRACKET
33-2010-12 SCREW P.H.S.M.S.
30-0899-01 NUT
30-0277-01 QUICK DISCONNECT MALE
30-2737-250 Fitting

30-0282-01 GAUGE
* 30-2347-01 FILTER REGULATOR LUBRICATOR
30-1048-01 QUICK DISCONNECT FEMALE
30-2737-250 Fitting

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