

Parts Manual



PFM-1300 Flange Machine

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Porter International, Inc.
A Leggett & Platt Company
131 Zapletal Way
Carthage, Missouri 64836
1-417-358-8131

www.gsgcompanies.com

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Documentation**

1914 S. Baker Blvd.
Carthage, Missouri 64836
(417)358-8131 FAX: (417)358-9712
L&P Intranet: <http://zedcenter>
e-mail: zedcenter@leggett.com
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About This Manual

This manual has been developed for persons who will be searching for and ordering parts for this machine. It is imperative that all persons responsible for the operation, care and maintenance of these machines read and understand the information in this manual.

How This Manual is Organized

This manual contains assembly illustrations and parts lists for finding and ordering parts. Assemblies are arranged so that they always occur on an even number page. This is so that the part list for an assembly will begin on the adjacent odd page.

The illustrations contain balloons with numbers in them. The balloon numbers match the numbers in the Item column in the part list.

The part list contains multiple information columns. They are: Item, Quantity (Qty), Assembly (Assy), Description, and Part Number.

The Item column contains the balloon callout in the illustration. Quantity column (Qty) lists the number of those parts used in the illustration. Assembly column (Assy) identifies that another assembly illustration can be referenced for further part breakdown. The Description column is a description for the part. The Part Number column contains the Porter International part number or stock number for the part. This column also lists the assembly number, if applicable. The entire assembly may be ordered by the assembly number but in most cases only a few parts in the assembly are required. An asterisk preceding an entry in the parts list signifies that more information is available at the end of the part list.

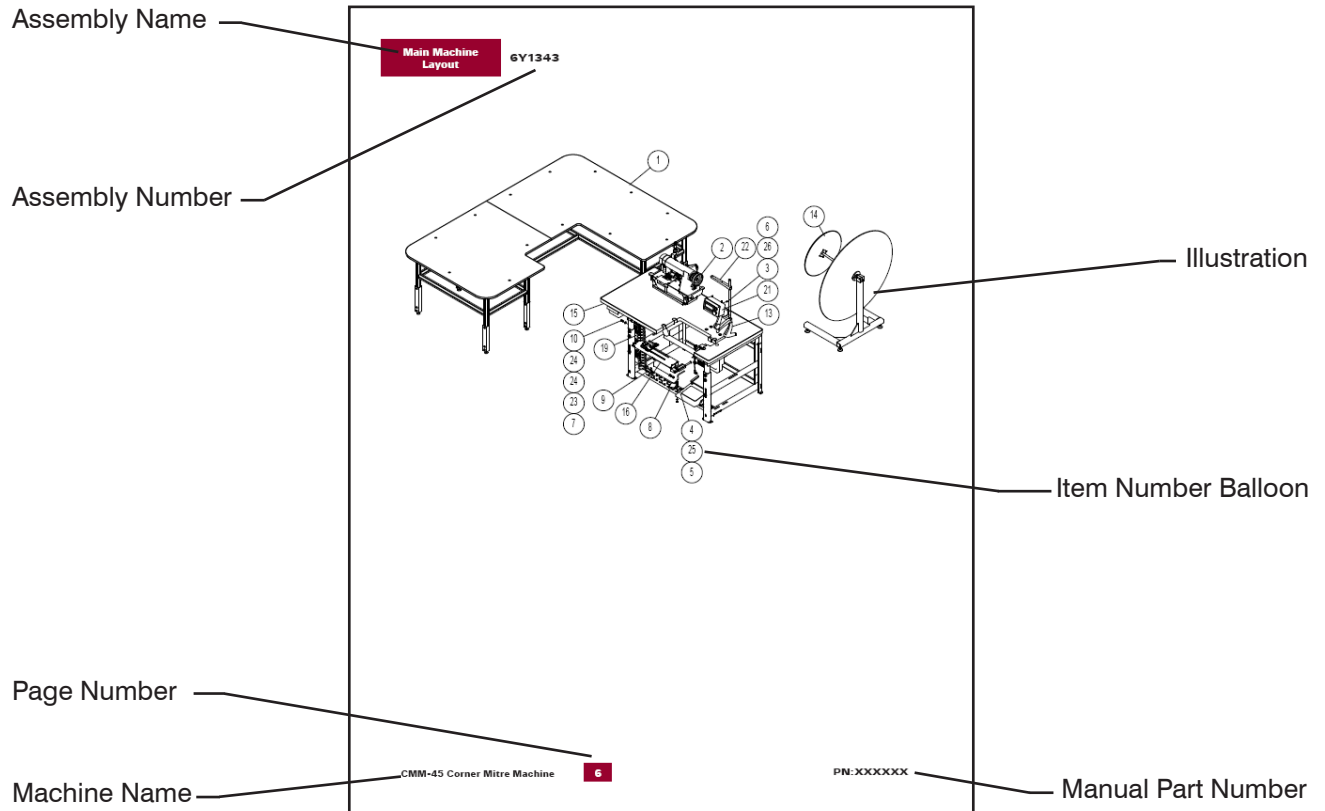
The Assembly column will contain an "S" for Sub-Assembly if there is another assembly breakdown available for a component. If there is a sub-assembly available it can be found following the current assembly illustration and part list. An asterisk preceding an S signifies that more information is available at the end of the part list for the assembly listed. Other notes for parts can be found at the end of the part list for the assembly as well.

The Index contains a list of all of the part numbers and assembly numbers for easy reference.

See the following page for an illustration of page layout for this manual.

How This Manual is Organized

About This Manual



6Y1343 Main Machine Layout				
Item	Qty	Assy	Description	Part Number
1	1	S	STATIC TABLE ASSY	6Y1273
2	1	S	CMM-45 HEAD ASSY	6Y1342
3	4		BHCS, #8-32 x 3/8	620489
4	2		HEX HD, 1/4-20 x 1/2, FULL THD	621167
5	2		NUT, HEX, 1/4-20	621172
6	4		NUT, HEX, #8-32	621179
7	4		NUT, HEX, 3/8-16	623529
8	1		SWITCH, FOOT, ELEC MOM (401017)	625990
9	1		PNEUMATIC BLOWGUN W/HOSE	627400
10	4		HEX HD, 3/8-16 x 7/8	62A391
11	1		1/4" BULKHEAD CONNECTOR (FSC, STR-BLK+FP+HT) (NOT SHOWN)	62A615
12	12		5/32 TUBE STRAIGHT BULKHEAD, (SPC - STR-BLK-2.5T) (NOT SHOWN)	62B311
13	1		TOUCH SCREEN ARM	62B831
14	1	S	MATERIAL PAYOFF STAND ASSY	62B811
15	1	S	STAND ASSY	62B818
16	1	S	FOLDER ASSY	62B820
17	1		VALVE STATION, 2002 SERIES, 8 MANIFOLD, WITH CONNECTORS (NOT SHOWN)	62B839
18	1		FRL ASSY (NOT SHOWN)	62B840
19	1	S	ELECTRICAL ASSY	62B844
20	1		1/4 NPT TO 1/4 TUBE BRANCH TEE, (SPC - TEE-4MP-4T) (NOT SHOWN)	62B848
21	1		TOUCHSCREEN STATION ASSY	62C103
22	1		2 SPOOL THREAD STAND	CONSEW STAND
23	4		WASHER, LOCK, 3/8	SLW3/8
24	6		WASHER, FLAT, 3/8, SAE	62C119
25	2		WASHER, FLAT, 1/4, SAE	62A335
26	4		WASHER, FLAT, #8, SAE	620997

PN:XXXXXX

7 CMM-45 Corner Mitre Machine

Item Number Column

Quantity Column

Description Column

Assembly Column

Part Number Column

CD-ROM Navigation

A PDF (Portable Document Format) of this manual is available in full color on CD-ROM and can be viewed or printed from Adobe® Acrobat® Reader.



IMPORTANT! For additional information about Adobe® Acrobat® Reader or to download a free version of Adobe® Acrobat® Reader, please visit www.adobe.com on the internet.

An interactive version of this manual has been created that will use the functionality of the Adobe Acrobat® reader. Hyperlinks and bookmarks have been embedded into the document to allow the reader to jump from one subject to another with minimal effort.

Before using the digital manual, it is recommended that navigational toolbar in Acrobat® be set with all navigation tools available. This is not required to open or read the manual, however if the reader uses a link and “jumps” multiple pages the default Acrobat® settings will only move one page at a time.

To add the needed navigational icons to the toolbar:

1. Open the manual in Acrobat® reader.
2. Check the toolbar to determine if the navigation icons are visible. If only the page forward and page back icons are visible, then go to step 3. If all the icons are present (**fig.1**), then no further action is required.

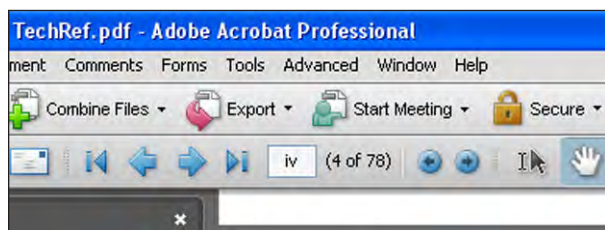


fig.1: A snapshot of the main toolbar with all the navigation tools visible.

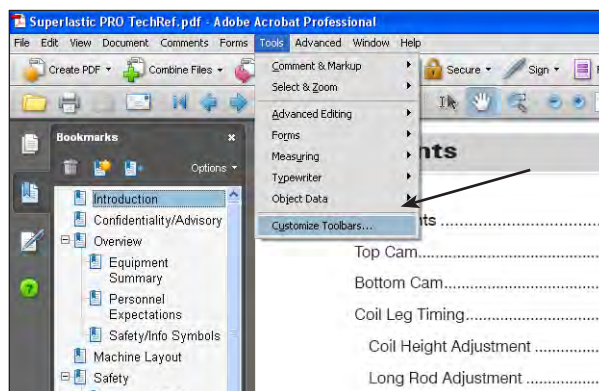


fig.2: The tools menu with customize toolbars highlighted.

3. Left click on the **TOOLS** menu (**fig.2**).
4. Scroll down and left click on the **CUSTOMIZE TOOLBAR** (**fig.2**)
5. Scroll down the **MORE TOOLS** flyout until the “Page Navigation Toolbar” section is visible (**fig.3**).
6. Select (check) all of the empty boxes in the section.
7. Click **OK**.
8. The navigation tools are now on the main toolbar and ready to use.

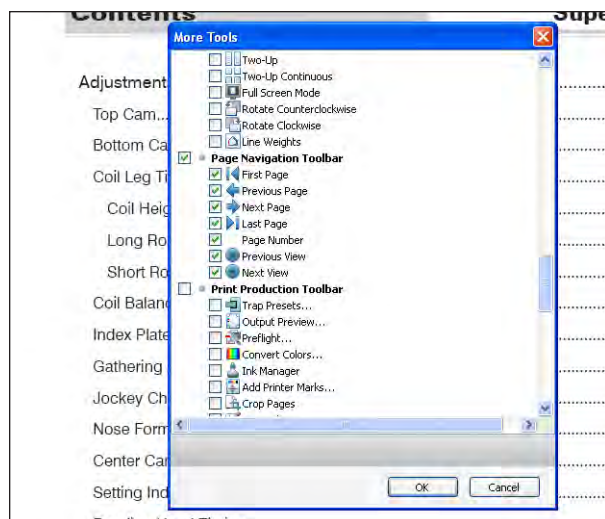


fig.3: A snapshot of the main toolbar with all the navigation tools visible.

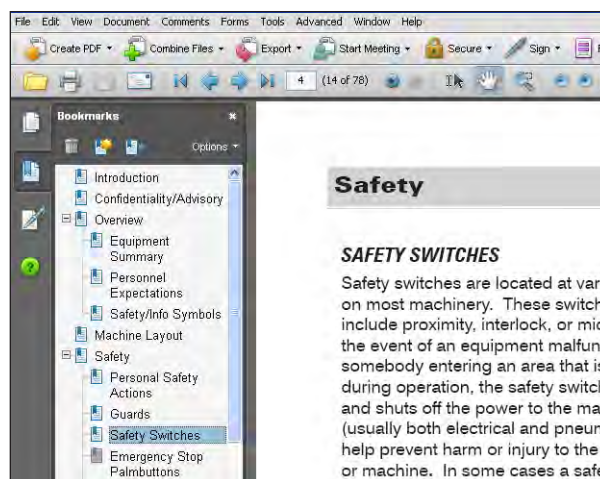


fig.5: Click on a Bookmark topic (left) to open that page in the manual (right).

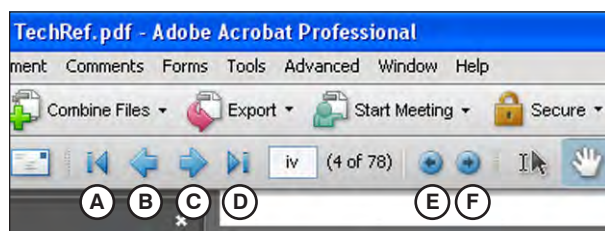


fig.4: The navigational tools.

NAVIGATION CONTROLS

There are many ways to read a document displayed in Acrobat®. First is scrolling up and down with the mouse wheel or scroll bar at the righthand side.

Using the navigation tools (fig.4) will “jump” the screen to and from pages quickly.

In fig.4 the navigation tools are labeled. Following is a list of brief definitions for each of the tools.

- A. **First Page** - Click to go immediately to the first page of the manual.
- B. **Previous Page** - Click to go to the page numerically before the current page. For example, page 10 is on the screen, click this icon to move to page 9.
- C. **Next Page** - Click to go to the page numerically after the current page. For example, page 10 is on the screen, click this icon to move to page 11.
- D. **Last Page** - Click to go immediately to the last page of this manual.
- E. **Previous Viewed** - Click to go to the most recent page that was viewed before the current page. For example, page 10 has a hyperlink that will open page 32. After reading the topic on page 32, click this icon to immediately return to page 10.
- F. **Next Viewed** - Click to reopen the hyperlink destination page after returning to the current page from the destination page with the *Previous Viewed* icon. For example, after returning to page 10 from page 32 (see E above), click this icon to return to page 32.



IMPORTANT! Scrolling will affect how a tool reacts.

Other methods of navigating through the manual include using the Bookmarks menu (**fig.5**) or the Table of Contents to go immediately to a subject page by clicking on that topic. If an index is provided, an index entry page number can be clicked to jump to that page.

There are additional ways to navigate the document in Acrobat®, however this document has been developed to use the tools described here.

HYPERLINKS

Throughout this manual are hyperlinks that, when clicked, will automatically open a destination page that is related to the current topic. These links are indicated with *colored, italicized text*. Table of Contents and Index page numbers are also hyperlinked to the topic listed, but are not stylized. A standard mouse cursor will change into a hand with a pointing finger when the cursor passes over an active hyperlink.



IMPORTANT! Electronic manuals can be e-mailed. They require a minimum of 20MB of available storage space on a server to download.

How to Get Additional Help

There may be times when additional help is needed. Porter International, Inc. is available Monday through Friday, 8:00 a.m. to 5:00 p.m., Central Time. Skilled personnel are trained to help with mechanical, electrical, electronic and computer questions.

There may be times when specific problems might require more attention than what can be delivered through telephone support. In this situation, the technical staff will address the problem and, if necessary, travel to the site. Please be aware that certain fees apply. Contact the Porter International, Inc. service department manager at 1-978-948-8288 for specific information on fees and services.

Answers can be obtained more quickly if the following actions are performed before calling:

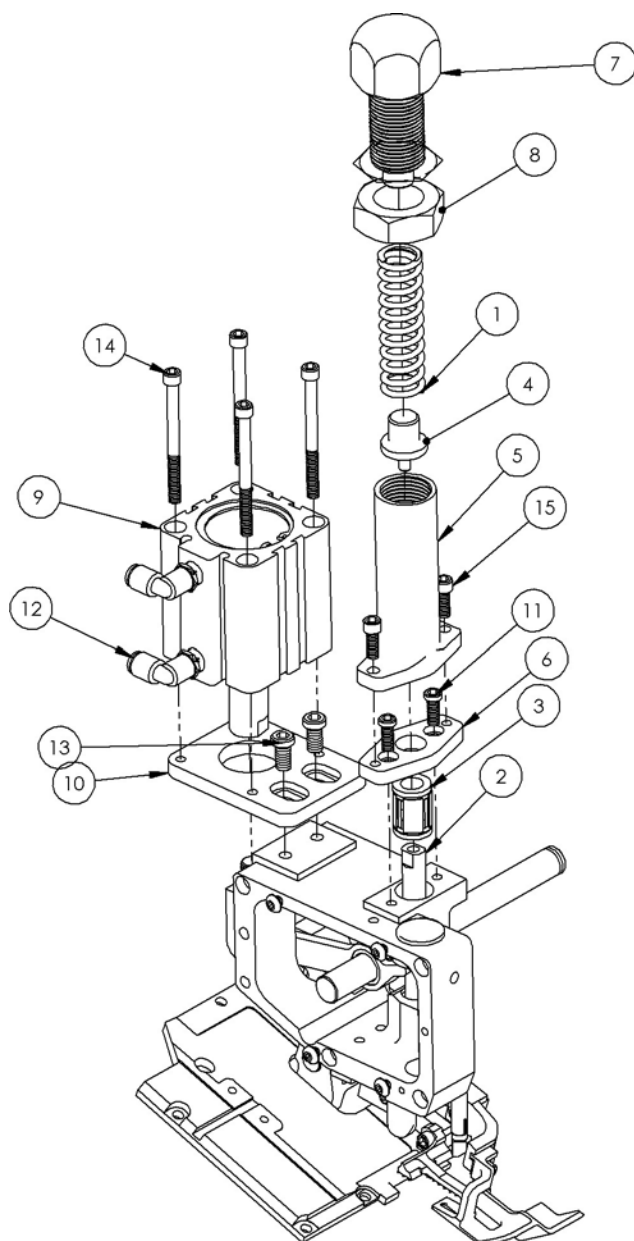
- Try to find the answer in a machine manual.
- Ask a supervisor the question.
- Look up your Customer ID number.
- Make a note of the machine's model and serial number.
- Locate a phone that is close to the machine to make it easier to tell the staff what the machine is doing.

How to Give Feedback

Your ideas are important! Please let us know what you like in this manual, as well as what you don't like. Tell us what you would like to see more or less of, or what you would like to see presented in a different way. We look forward to hearing from you soon.

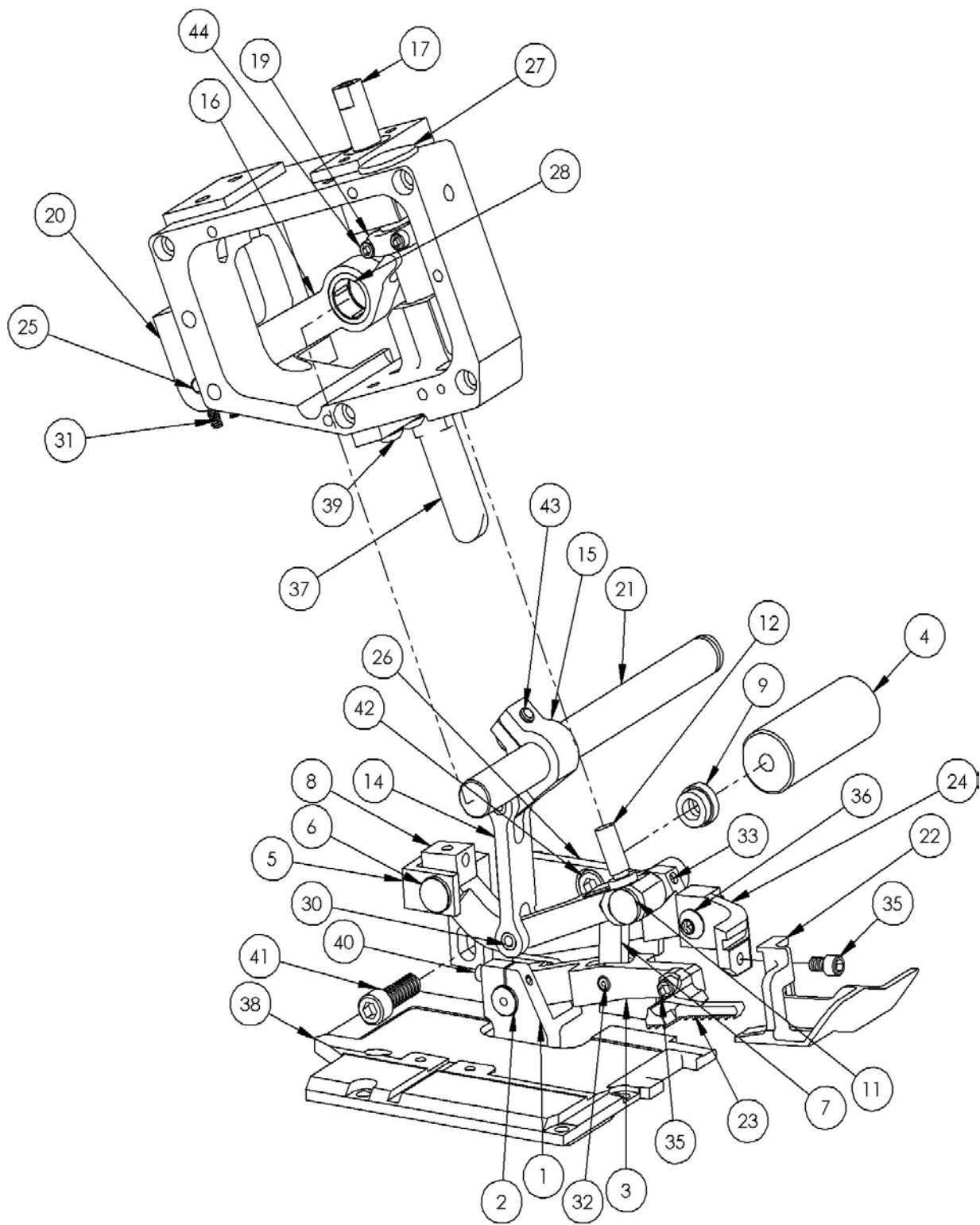
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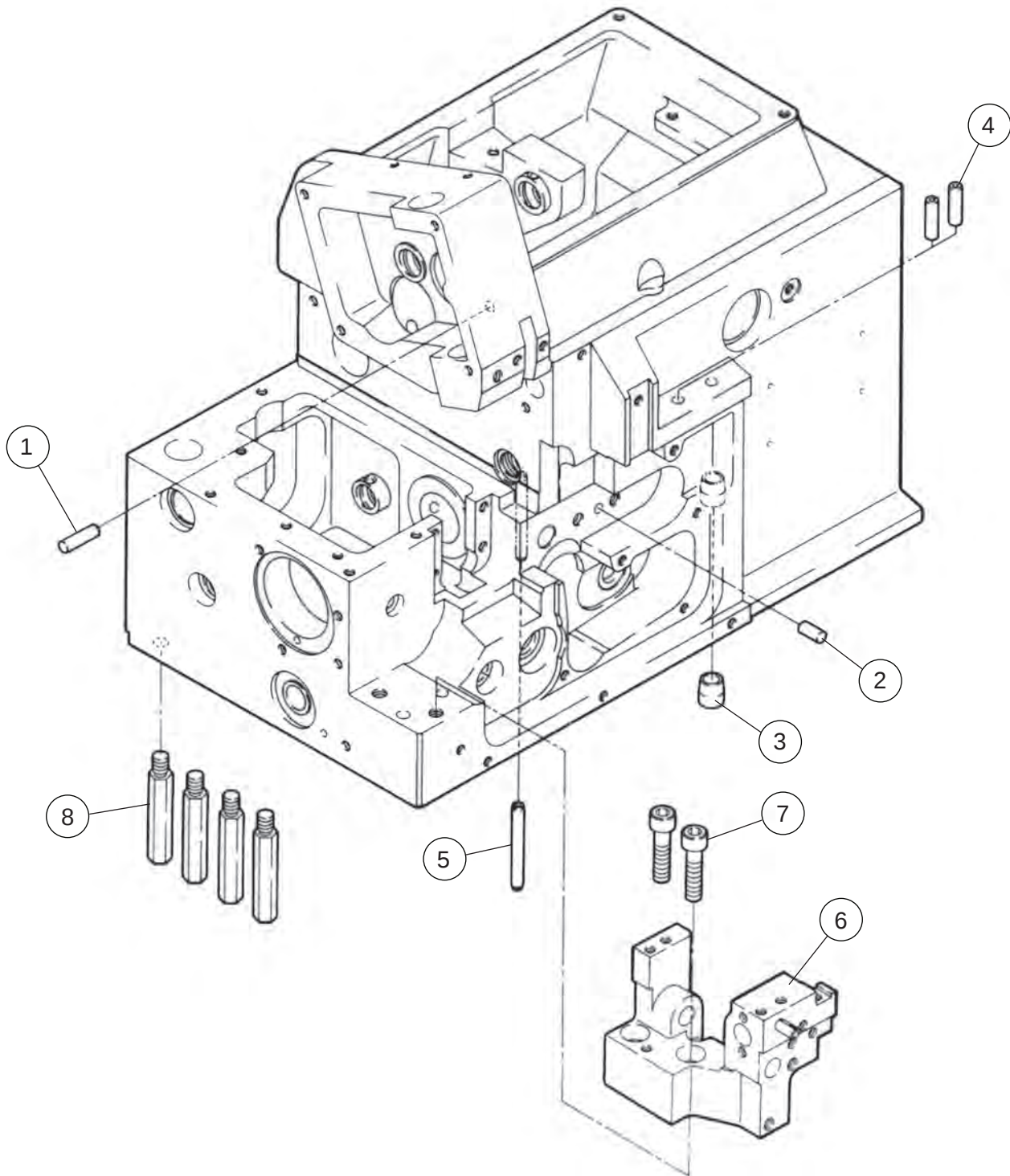
ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	6ZD040	SPRING	1
2	801257	LOWER PR. BAR	1
3	402702	LINEAR BALL BEARING	2
4	6ZC923	SPRING BASE	1
5	6ZC924	SPRING HOUSING	1
6	6ZC922	SPRING HOUSING MTG PLATE	1
7	6ZC925	TENSION CAP	1
8	JN7/8-14	NUT	1
9	6ZD039	40mm BORE x 30mm STROKE	1
10	6ZC921	FOOT LIFT MOUNTING PLATE	1
11	6Z9534	SHCS #10-32 x 1/2 LOW HEAD	2
12	KQL03-34S	1/8 NPT TO 5/32 ELBOW	2
13	SLHCS1/4-20X1/2	SCREW	2
14	SHCS10-32X2-1/4	SCREW	4
15	6Z2762	SHCS #10-32 x 1/2	2

continued on next page



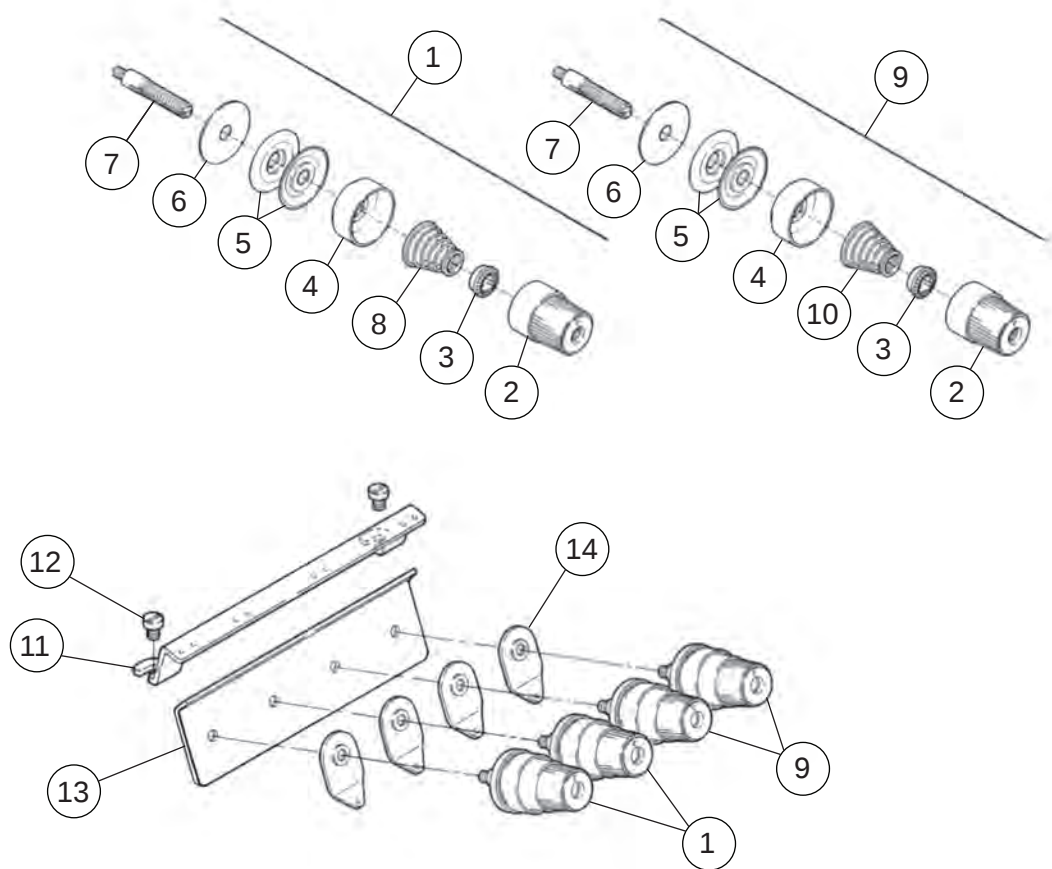
ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	6Z5855	HOLDER TOP FEED	1
2	6Z5310	PIN TOP FEED	1
3	6ZC919	TOP FEED BEAM	1
4	801026	STUD PRESSER FOOT LOCATING	1
5	802769	HOLDER PRESSER FOOT ARM	1
6	6Z4048	PRESSER FOOT ARM PIN	1
7	6Z3554	LINK TOP FEED	1
8	6Z4052	ARM PRESSER FOOT	1
9	6Z4220	1/4 SELF ALIGNING WASHER	1
10	6Z8520	LINK WALKING LIFT	1
11	6Z4049	PIN LIFTER	1
12	801254	EXTENSION PR BAR	1
13	801276	HOUSING	1
14	802453	LINK BEAM CONN.	1
15	6Z8217	ARM WALKING DRIVE	1
16	801438	ARM LIFTING	1
17	801257	LOWER PR. BAR	1
18	402702	LINEAR BALL BEARING	2
19	802688	LIFTING COLLAR	1
20	6ZC920	FOOT CLEVIS	1
21	6ZD097	NEEDLE DRIVE SHAFT	1
22	6Z2087	PRESSER FOOT	1
23	6Z3210	TOP FEED	1
24	6Z5284	EXTENSION PRESSER FOOT ARM	1
25	6ZC926	FOOT PIN	1
26	802682	LINKAGE INNER	1
27	240310	PLUG	1
28	4049000	NEEDLE BEARING 12mm ID	1
29	4107001	OIL SEAL	1
30	6Z1407	LONG PIVOT PIN	2
31	6Z2790	SCREW	4
32	6Z1947	PIVOT PIN LONG	1
33	6Z2796	SHSS #8-32 x 3/8 CUP POINT	2
34	6Z4050	PIN PIVOT UPPER	1
35	6Z3530	SCREW	2
36	6Z5271	SCREW	1
37	6Z3796	GUARD OUTER	1
38	6ZE523	CHAMBER COVER MOD	1
39	6Z0480	BHCS #10-32 x 1/2	2
40	6Z9182	SCREW	1
41	6Z2760	SHCS 1/4-28 X 3/4	1
42	LHSHCSM6X10	SCREW	2
43	6Z2782	10-32 SHCS X .375	1
44	6Z2774	SHCS #6-32 x 3/8	2

Machine Bed Frame

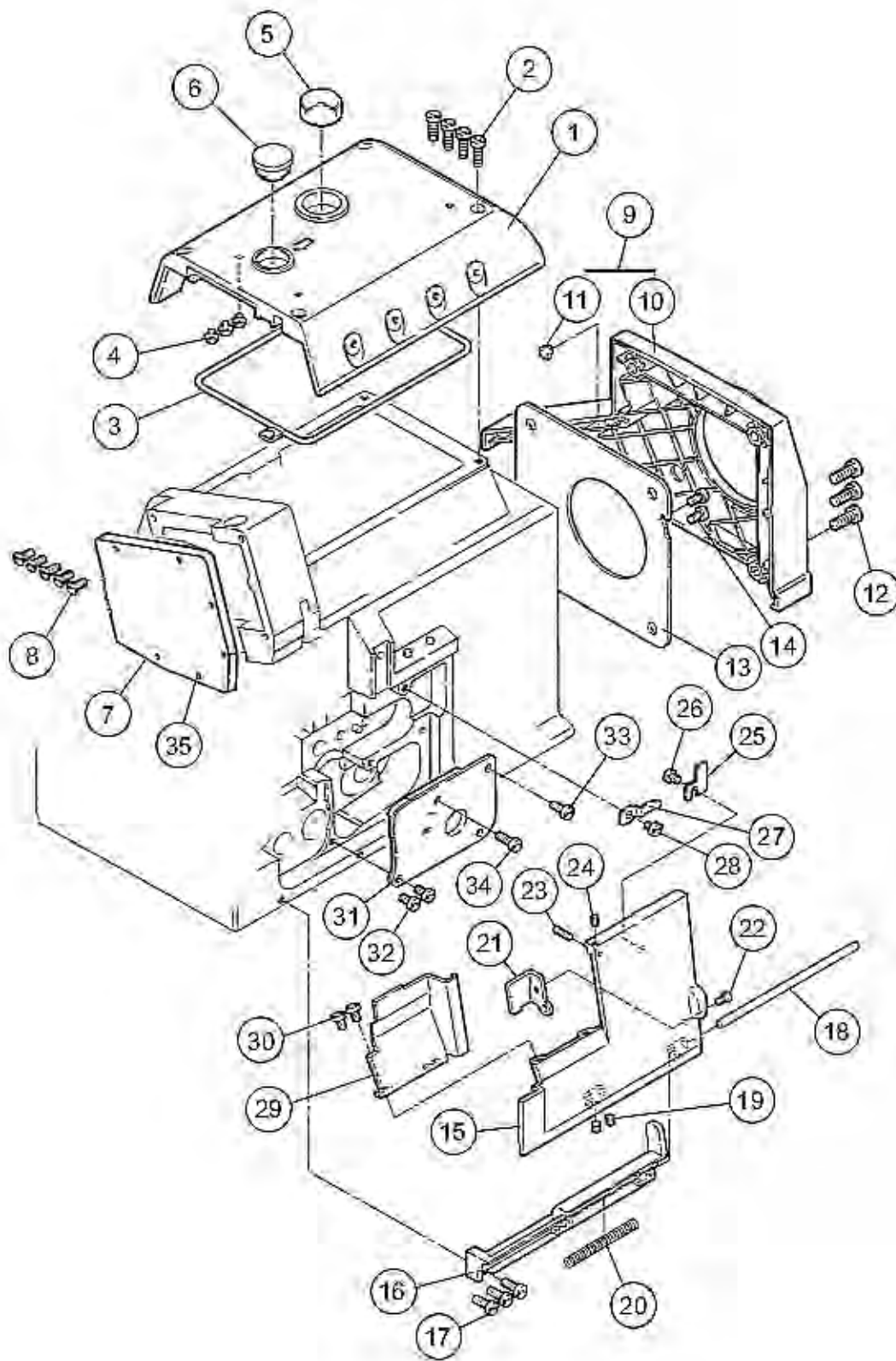


ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	6Z1925	ROD	1
2	660274	PIN	1
3	6Z4195	GUIDE OILER FLOAT	1
4	6Z9335	PIPE	2
5	660276	PLUG	1
6	6ZE091	NEEDLE PLATE/ KNIFE SUPPORT	1
7	6Z3643	SCREW	2
8	6Z0041	BED PIN	4

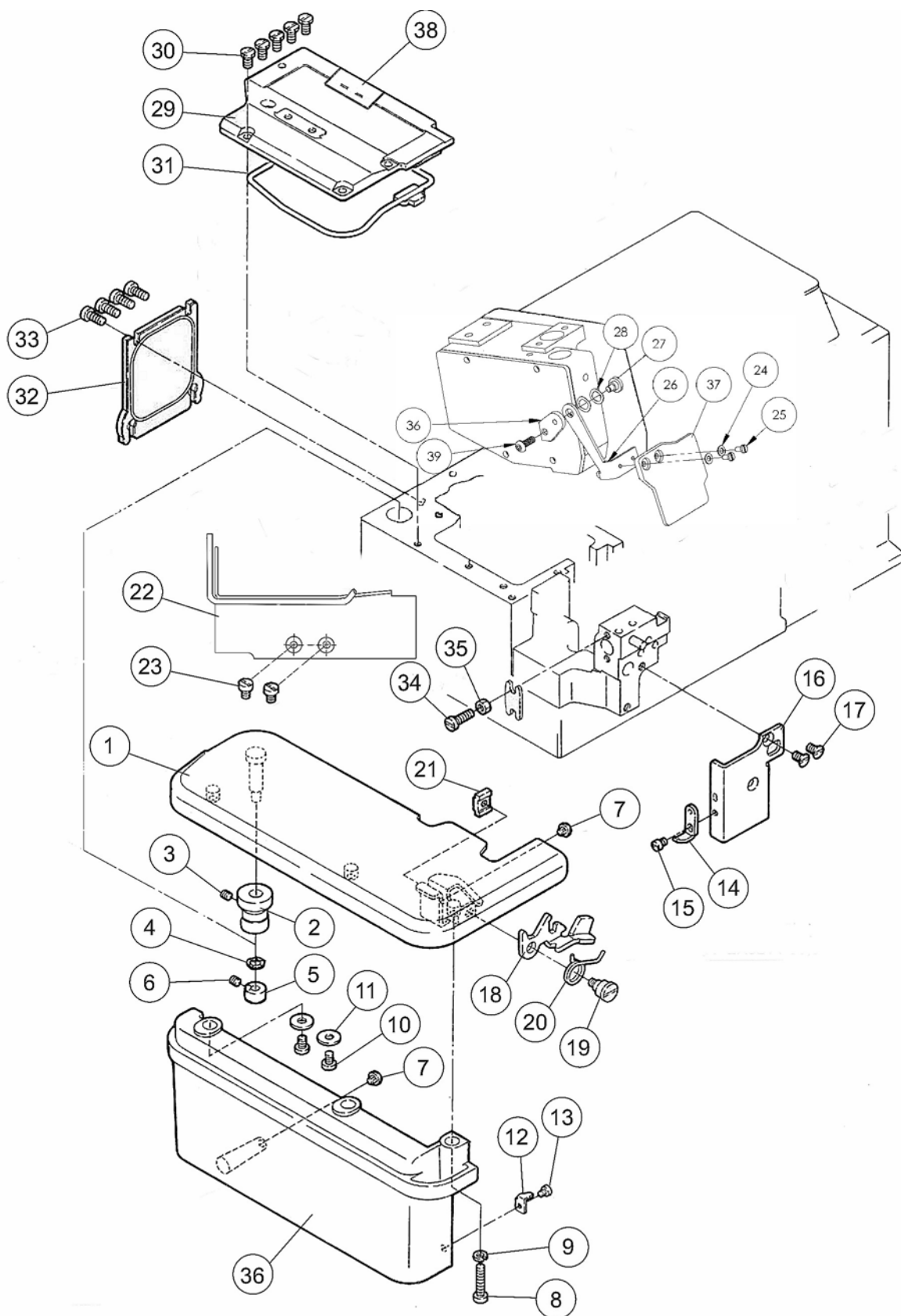
Thread Tension Mechanism



ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	6Z5675	THREAD TENSION COMPLETE	1
2	6Z1824	POST NUT	1
3	6Z2870	SPRING BUSHING	1
4	6Z2871	CUP	1
5	730061	TENSION DISC	2
6	6Z0709	FELT	1
7	6Z1998	SCREW STUD	1
8	6Z1161	SPRING HEAVY	1
9	6Z7874	THREAD TENSION COMPLETE	1
10	6Z1568	SPRING MEDIUM	1
11	730058	THREAD EYELET	1
12	660082	SCREW	1
13	730059	THREAD EYELET	1
14	730095	TENSION GUIDE	1

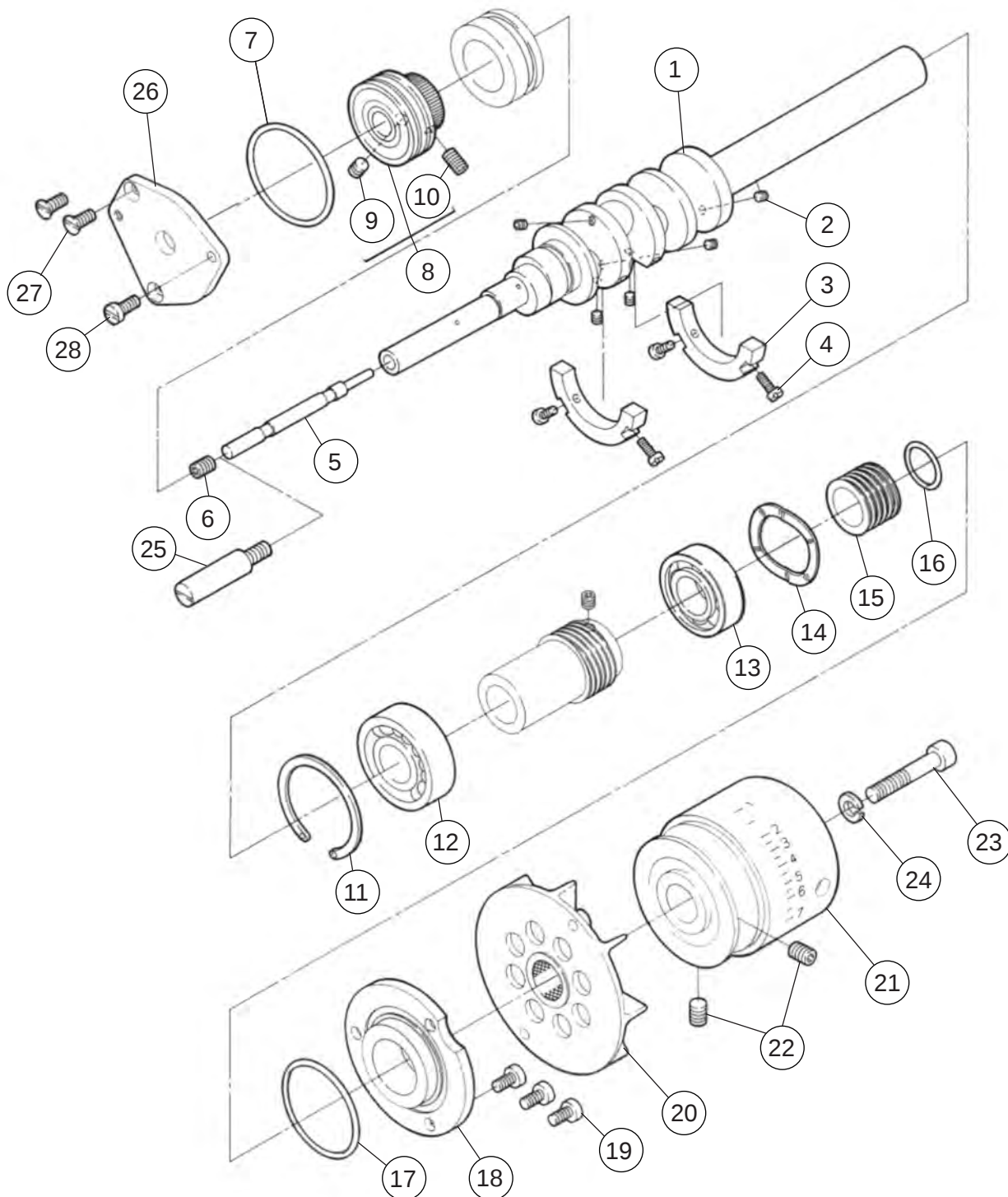


ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	730000	TOP COVER	1
2	6Z3640	SCREW	4
3	6Z0038	GASKET	1
4	730030	CUSHION RUBBER	3
5	6ZD168	OIL SIGHT WINDOW	1
6	730031	PLUG	1
7	6ZC927	COVER NEEDLE DRIVE	1
8	BHCS8-32X1/2	BHCS #8-32 x 1/2	5
9	730003	BELT COVER ASSEMBLY	1
10	730004	BELT COVER	1
11	730030	CUSHION RUBBER	1
12	6Z3749	SCREW	3
13	730005	FAN COVER	1
14	6Z0024	SCREW	2
15	6Z6559	FRONT COVER	1
16	6Z6560	HINGE	1
17	6Z3639	SCREW	3
18	730032	PIN	1
19	6Z2576	SCREW	2
20	6Z2912	SPRING	1
21	6Z8105	LATCH	1
22	6Z8057	SCREW	1
23	6Z8152	SCREW	1
24	6Z6203	SCREW	1
25	6Z8106	LATCH	1
26	6Z0015	SCREW	1
27	6Z5686	FLAT SPRING	1
28	6Z0015	SCREW	1
29	6Z3710	FRONT COVER LEFT	1
30	660082	SCREW	2
31	6Z5409	COVER	1
32	6Z0024	SCREW	2
33	6Z8095	SCREW	1
34	6Z3639	SCREW	1
35	6Z0482	SCREW	1

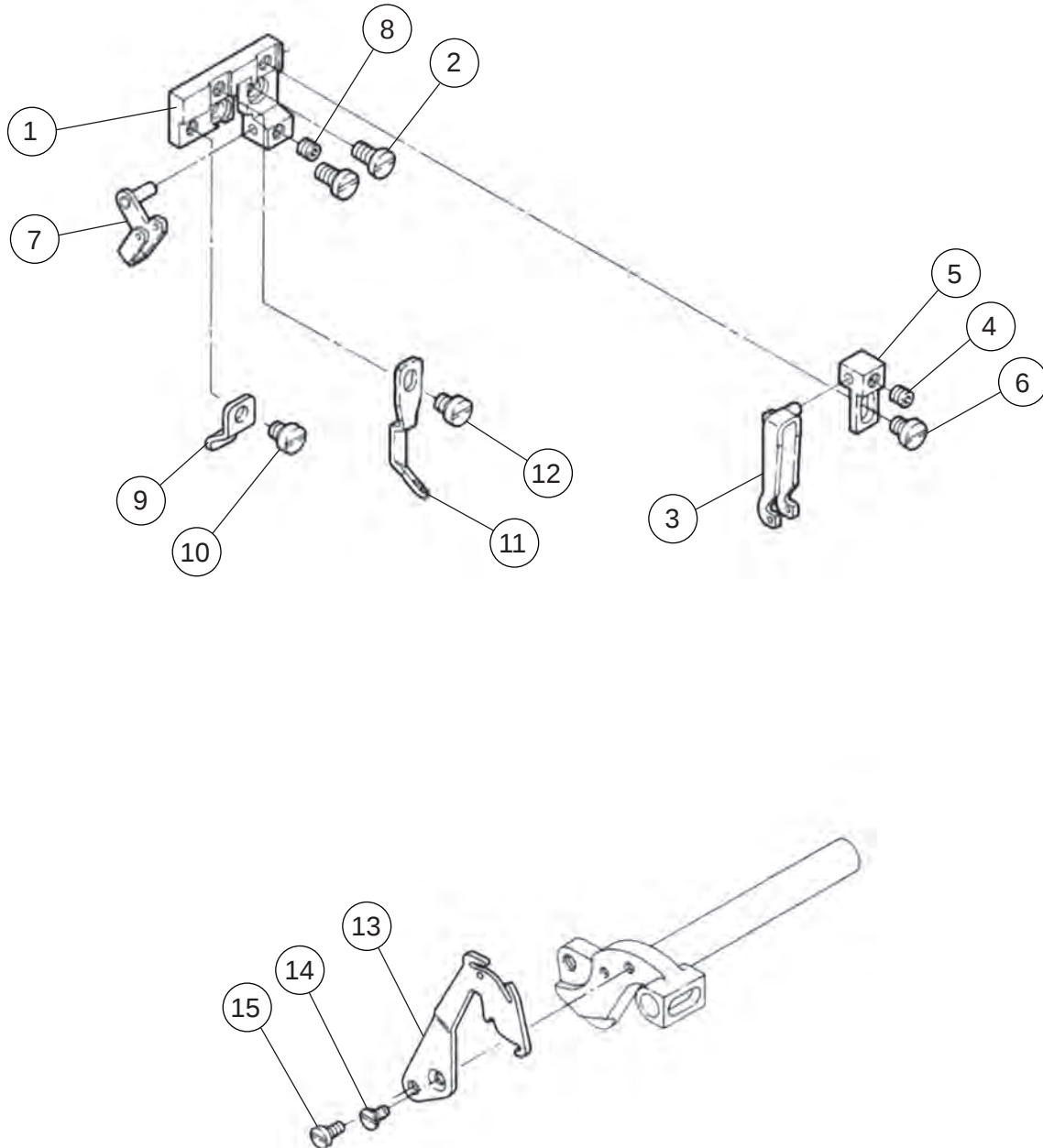


ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	801546	CLOTH PLATE	1
2	730012	BUSHING	1
3	6Z2576	SCREW	1
4	730051	WASHER	1
5	6Z2113	COLLAR	1
6	6Z2576	SCREW	1
7	730030	CUSHION RUBBER	1
8	660084	SCREW	1
9	640005	SPRING WASHER	1
10	660082	SCREW	1
11	730036	WASHER	2
12	6Z6893	LATCH	1
13	6Z0376	SCREW	1
14	730014	LATCH	1
15	660086	SCREW	1
16	6Z3768	PLATE	1
17	6Z3769	SCREW	1
18	730015	LEVER	2
19	660090	SCREW	1
20	6Z0040	SPRING	1
21	730017	BRACKET LOCKING CVR. PLATE	1
22	801450	COVER LINKAGE TUBE ASSY	1
23	BHCSM4X12	BHCS M4 x 12	1
24	6Z0215	WASHER	2
25	6Z0393	SCREW	2
26	6Z3686	BRACKET	2
27	6Z5719	SCREW	1
28	730051	SPRING WASHER	1
29	6ZE523	CHAMBER COVER	2
30	6Z3641	SCREW CHAMBER COVER	1
31	6Z1077	GASKET	5
32	2700260	COVER PLATE	1
33	6Z8095	SCREW	1
34	6Z0023	SCREW	4
35	HN-M4	NUT	1
37	6Z3687	EYE GUARD	1
38	6ZB604	OIL SHIELD	1
39	BHCS8-32X1/2	SCREW	1

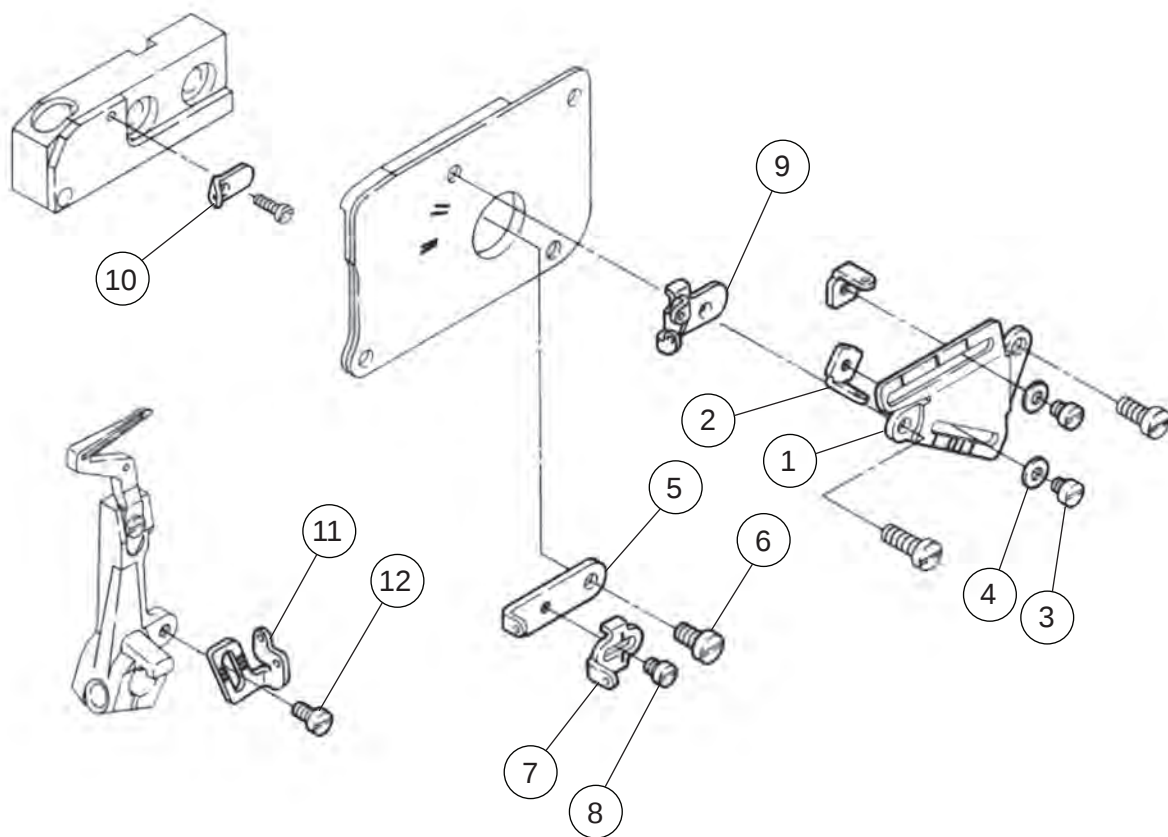
Crankshaft Drive Mechanism



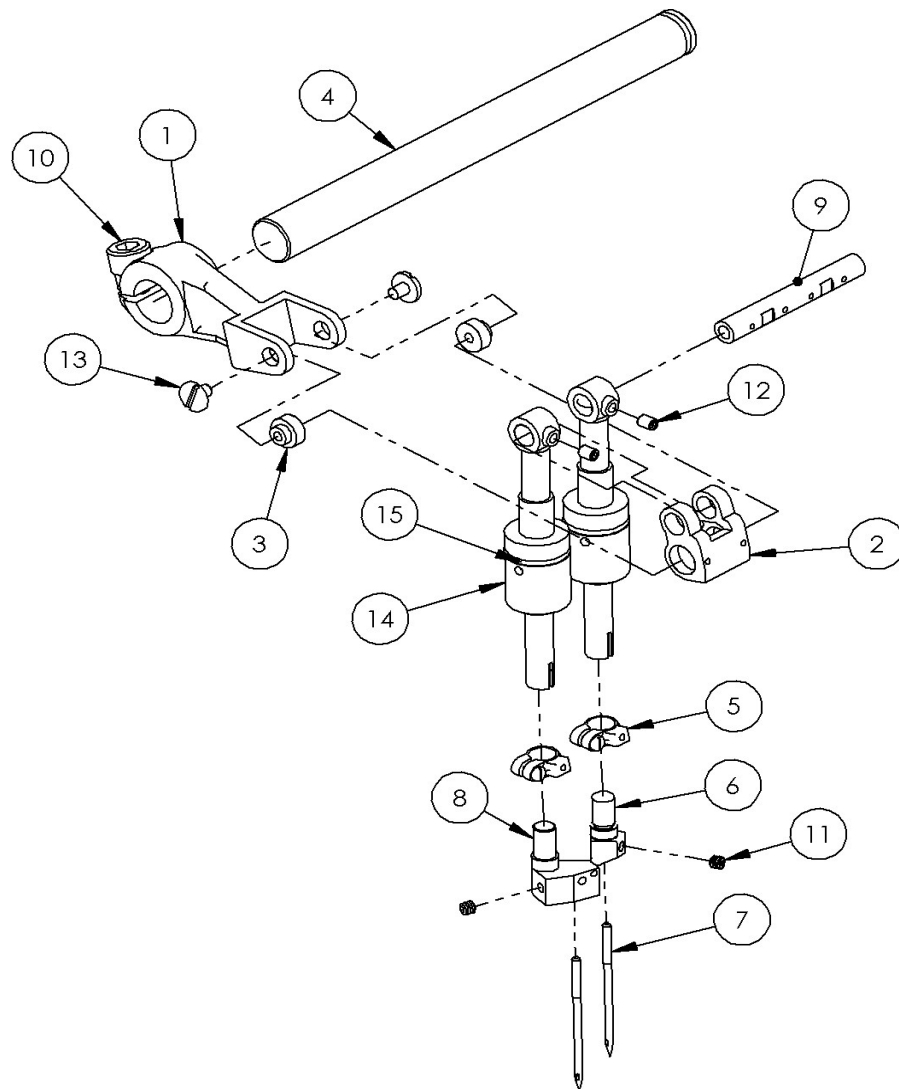
ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	6Z6938	CRANKSHAFT	1
2	660092	SCREW	5
3	730028	BALANCE WEIGHT	2
4	660093	SCREW	4
5	6ZC267	PIN	1
6	6Z0025	SCREW	1
7	6Z6194	O-RING	1
8	6Z6691	BALL BEARING COMPLETE	1
9	6Z8589	SCREW	2
10	6Z3753	SCREW	1
11	730040	RING	1
12	6Z8132	BALL BEARING	1
13	6Z4168	BALL BEARING	1
14	6ZA334	WASHER	1
15	6Z4167	OIL SEAL	1
16	6Z4166	O-RING	1
17	6Z6194	O-RING	1
18	6Z9376	BALL BEARING RETAINER	1
19	6Z8095	SCREW	3
20	6Z8550	FAN COMPLETE	1
21	6Z7740	MACHINE PULLEY	1
22	6Z0025	SCREW	2
23	660097	BOLT	1
24	6Z0551	SPRING WASHER	1
25	730044	PIN	1
26	730054	COVER	1
27	6Z3748	SCREW	2
28	6Z8095	SCREW	1



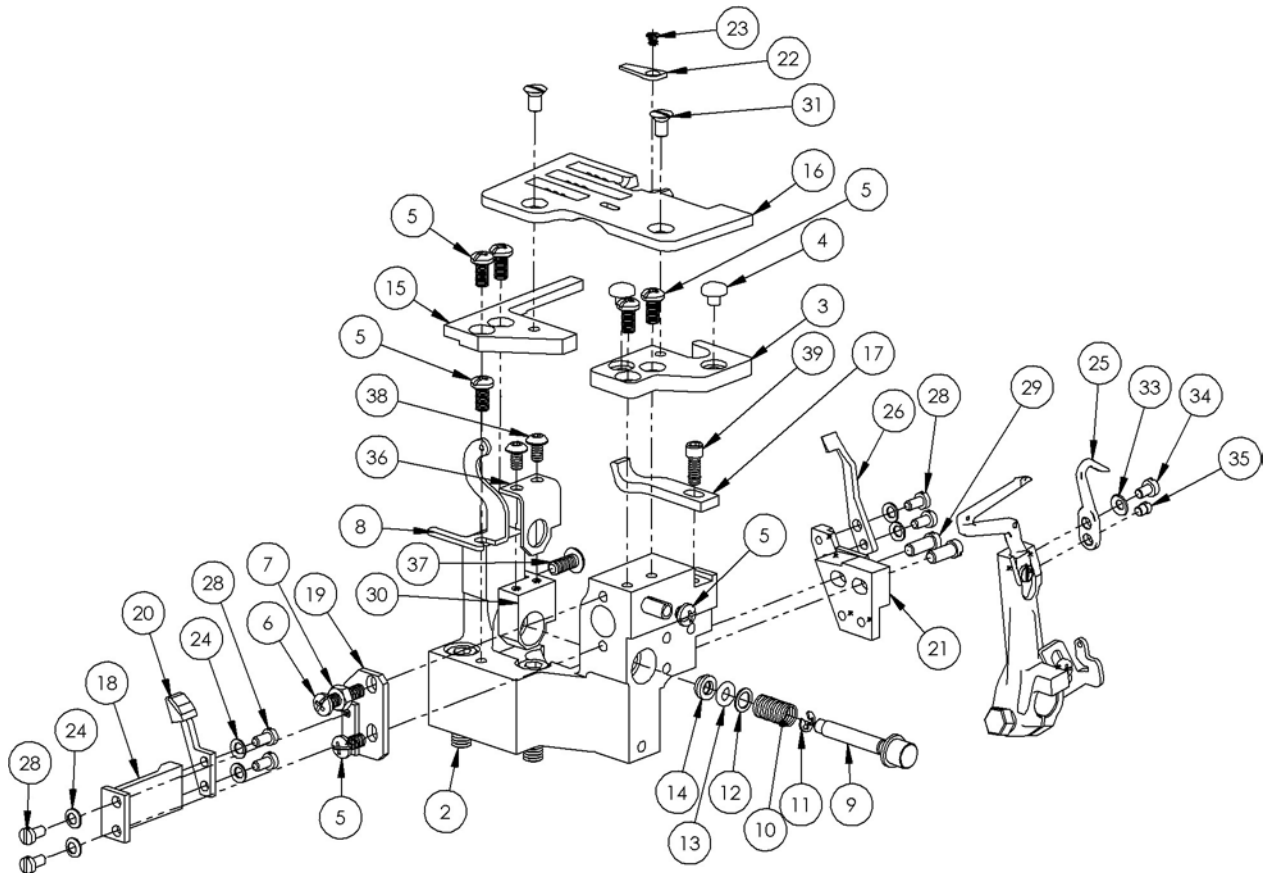
ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	6Z3690	BRACKET	1
2	6Z0614	SCREW	2
3	6Z3651	THREAD GUIDE	1
4	6Z2576	SCREW	1
5	6Z0055	BRACKET	1
6	6Z0015	SCREW	1
7	730066	THREAD GUIDE	1
8	6Z2576	SCREW	1
9	6Z0056	THREAD EYELET	1
10	6Z0015	SCREW	1
11	6Z3652	THREAD EYELET	1
12	6Z0015	SCREW	1
13	6Z3543	THREAD TAKE-UP	1
14	6Z0433	SCREW	1
15	6Z0393	SCREW	1



ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	730072	BRACKET	1
2	6Z9336	THREAD GUIDE RIGHT	2
3	6Z0376	SCREW	2
4	6Z0215	WASHER	2
5	6Z5514	THREAD TAKE-UP	1
6	6Z0024	SCREW	1
7	6Z5664	THREAD EYELET	1
8	6Z0376	SCREW	1
9	6Z8019	THREAD EYELET	1
10	6Z9337	THREAD EYELET	1
11	730078	THREAD TAKE-UP	1
12	6Z8151	SCREW	1

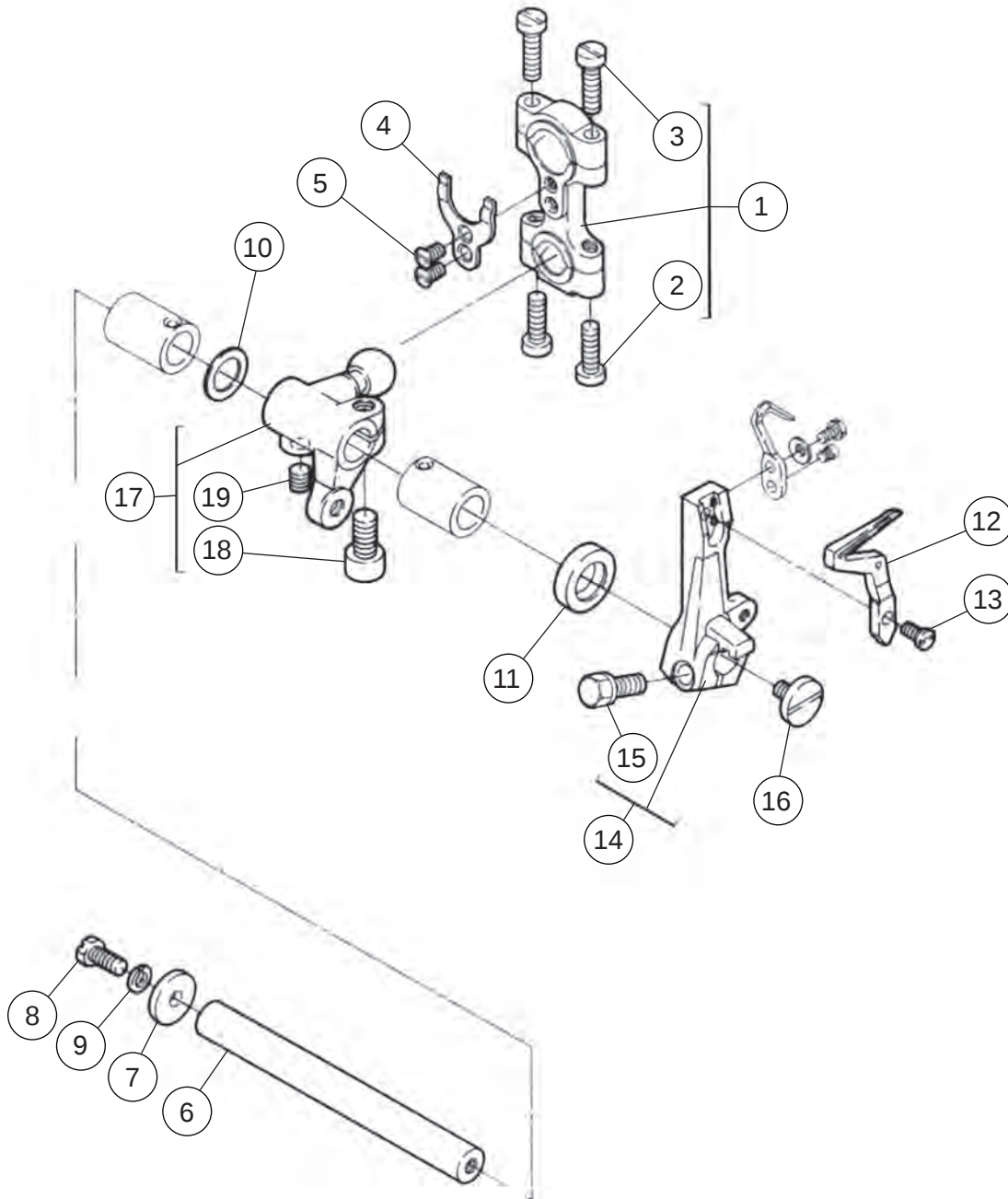


ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	801161	ARM NEEDLE BAR DRIVE	1
2	6Z1306	NEEDLE BAR LINK	1
3	6Z5398	NEEDLE LINK PIN	2
4	6ZD097	NEEDLE DRIVE SHAFT	1
5	6Z0565	NEEDLE CLAMP	2
6	6Z1725	NEEDLE HOLDER	1
7	6Z7027	NEEDLE #24 135 X 7	2
8	6ZB754	NEEDLE HOLDER LEFT 3/4	1
9	801445	PIN NEEDLE BAR TOP CONN	1
10	6Z8594	SHCS M6 x 1 x 12mm	1
11	6Z2547	SHSS #5-44 x 1/8 CUP POINT	2
12	6Z2494	SET SCREW	2
13	7185PEG	SCREW	2
14	6Z3556	NDLE.BAR/BSHG ASSY	2
15	6Z0061	O-RING	2



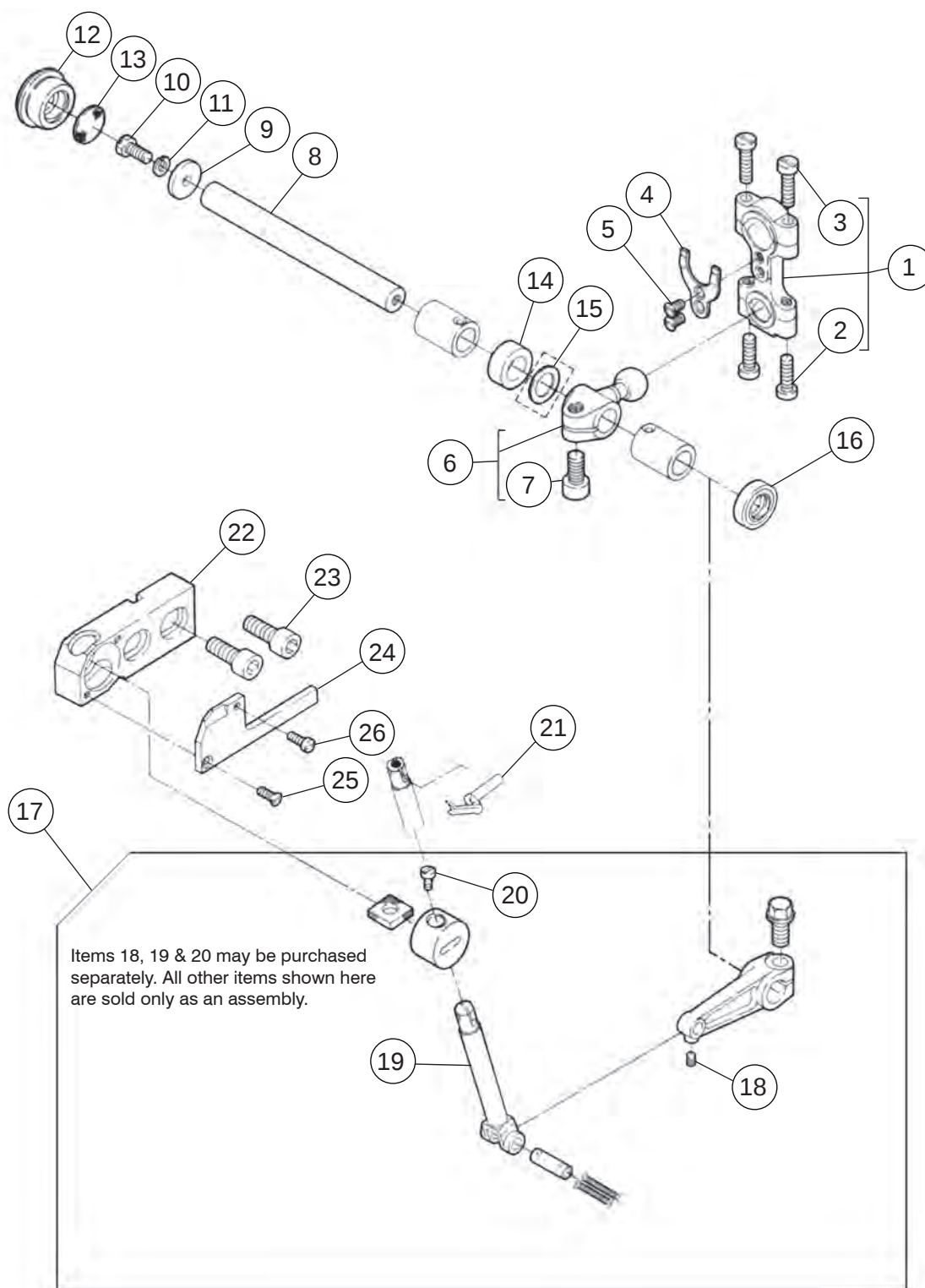
ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	730211	NEEDLE PLT SUPPORT BRACKET MOD	1
2	6Z3643	SCREW	2
3	6Z9574	FRONT BRACKET	1
4	730030	CUSHION RUBBER	2
5	6Z0024	SCREW	7
6	6Z0023	SCREW	1
7	0048210	HEX NUT	1
8	6Z0178	THREAD GUIDE	1
9	6Z5319	MODIFIED PUSH BUTTON	1
10	6Z7776	SPRING	1
11	6Z1199	RETAINING RING	1
12	6Z6540	WASHER	1
13	2063660	PUSH BUTTON O-RING	1
14	6Z6322	GASKET	1
15	6ZD098	NEEDLE PLATE SUPPORT	1
16	6ZC918	NEEDLE THROAT PLATE	1
17	6ZC917	NEEDLE GUARD	1
18	6ZC916	REAR NEEDLE GUARD BRACKET	1
19	6Z7341	REAR NEEDLE GUARD MTG PLATE	1
20	6Z7339	REAR NEEDLE GUARD	1
21	802848	NEEDLE GUARD BRACKET MOD	1
22	6Z0526	CHAIN FINGER	1
23	6Z0947	2-56 X .125 PHILLIPS FLAT HEAD	1
24	6Z4201	No. 6 - M3.5 BELLEVILLE WASHER	6
25	6Z2156	REAR OVEREDGE NEEDLE GUARD	1
26	6Z1048	OVEREDGE NEEDLE GUARD FRONT	1
27	6Z8151	SCREW	1
28	6Z0017	SCREW	6
29	6Z3642	SCREW	2
30	6Z5320	FLANGE STITCH REGULATOR	1
31	6Z1742	NEEDLE PLATE SCREW	2
32	6Z1455	SCREW	1
33	6Z2892	SPRING WASHER	1
34	6Z3595	BOLT NEEDLE GUARD	1
35	6Z0022	SCREW NEEDLE GD ANCHOR	1
36	6Z5321	COVER STITCH REGULATOR	1
37	6Z0489	SCREW	1
38	6Z0488	SCREW	2
39	6Z2774	SHCS #6-32 x 3/8	1

Lower Looper Drive Mechanism



ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	6Z6726	CONNECTION	1
2	6Z0023	SCREW	2
3	6Z3640	SCREW	2
4	6ZA340	GUIDE	1
5	6Z0433	SCREW	2
6	730087	SHAFT	1
7	240388	WASHER	1
8	660114	SCREW	1
9	6Z3747	SPRING WASHER	1
10	6Z7721	WASHER	1
11	6Z1852	OIL SEAL	1
12	6Z1532	LOWER LOOPER	1
13	6Z1455	SCREW	1
14	6Z0014	LOWER LOOPER HOLDER ASSEMBLY	1
15	6Z0021	SCREW	1
16	660120	SCREW	1
17	6Z3691	CRANK	1
18	6Z0026	SCREW	1
19	6Z3753	SCREW	1

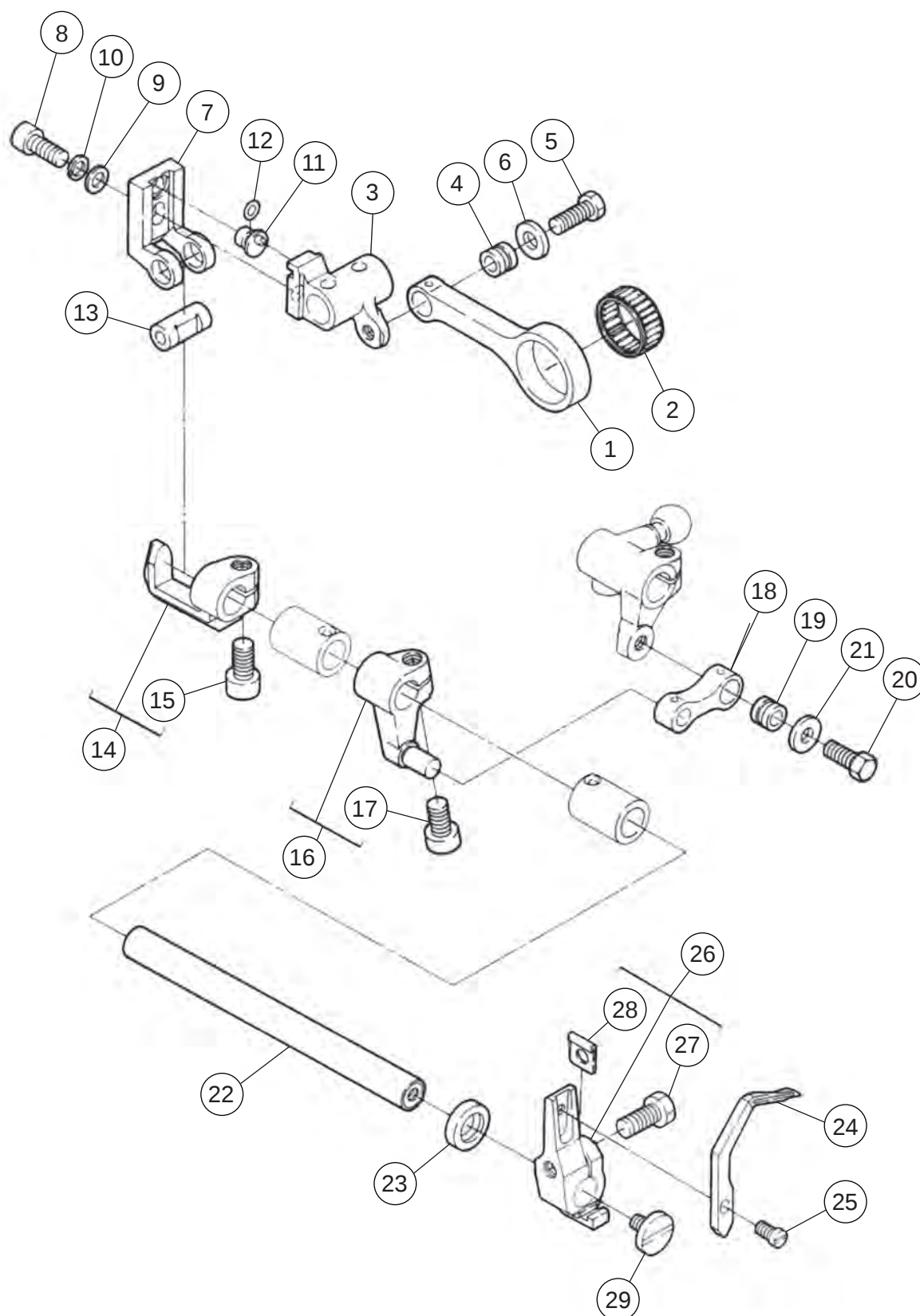
Spreader Drive Mechanism



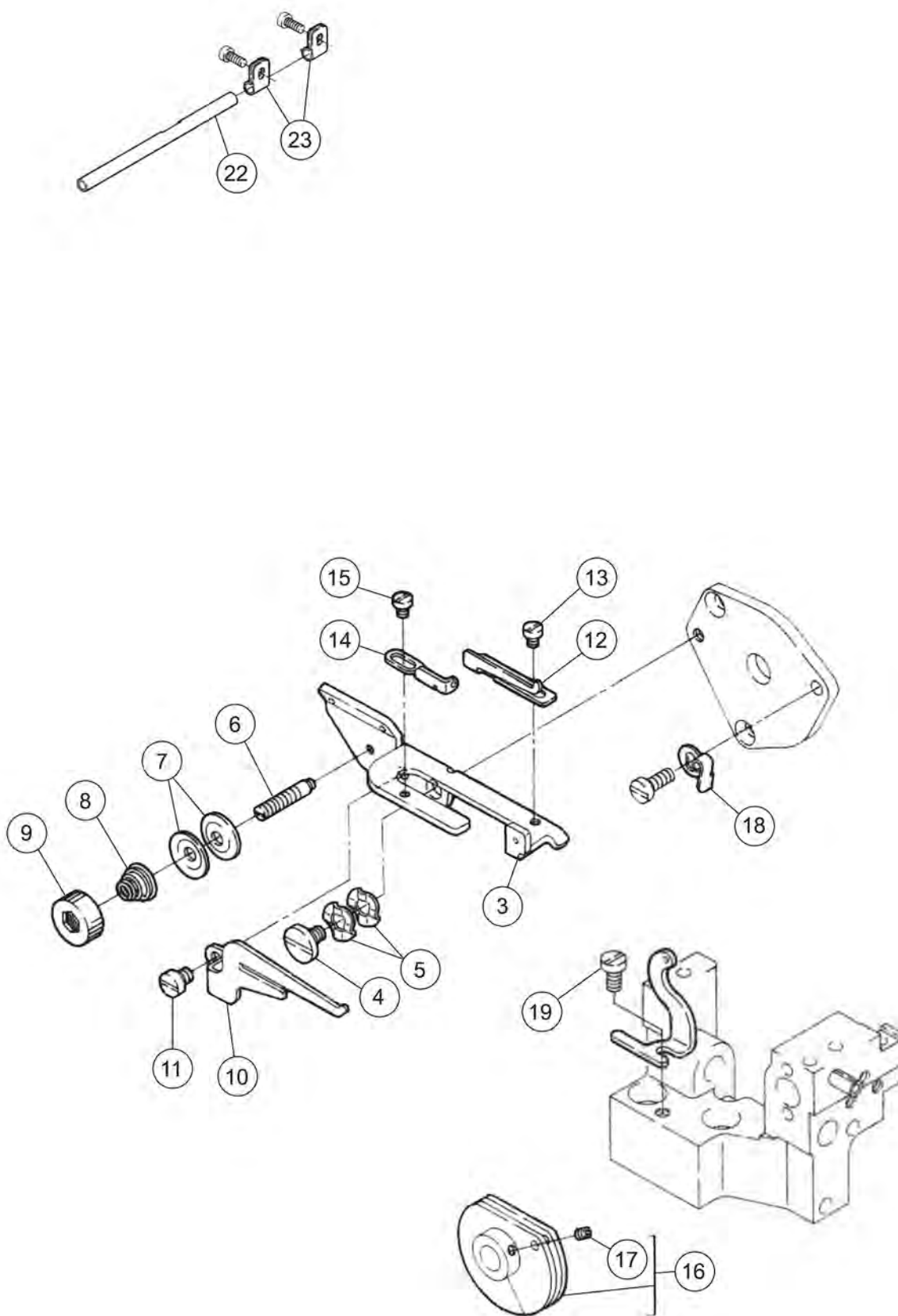
ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	6Z6726	CONNECTION ROD	1
2	6Z0023	SCREW	2
3	6Z3640	SCREW	2
4	6ZA340	GUIDE	1
5	6Z0433	SCREW	2
6	6ZB803	CRANK	1
7	6Z0026	SCREW	1
8	730087	SHAFT	1
9	6Z8786	WASHER	1
10	660114	SCREW	1
11	6Z3747	SRPING WASHER	1
12	6Z8170	PLUG	1
13	6Z6195	FILTER	1
14	6ZC875	SPACER 5.61	1
15	730122	WASHER	1
16	6Z1852	OIL SEAL	1
17	802739	SPREADER HOLDER ASSEMBLY COMPLETE	1
18	6Z2494	SCREW M3 x 4	1
19	6Z8944	SPREADER HOLDER	1
20	6Z5270	SPREADER SCREW	1
21	6Z2869	SPREADER	1
22	6Z6725	BASE SPREADER HOLDER	1
23	660116	SHCS M6 x 16	2
24	730128	COVER	1
25	6Z8076	SCREW	1
26	6Z0021	SCREW	1

Chain Stitch Looper Drive Mechanism 1

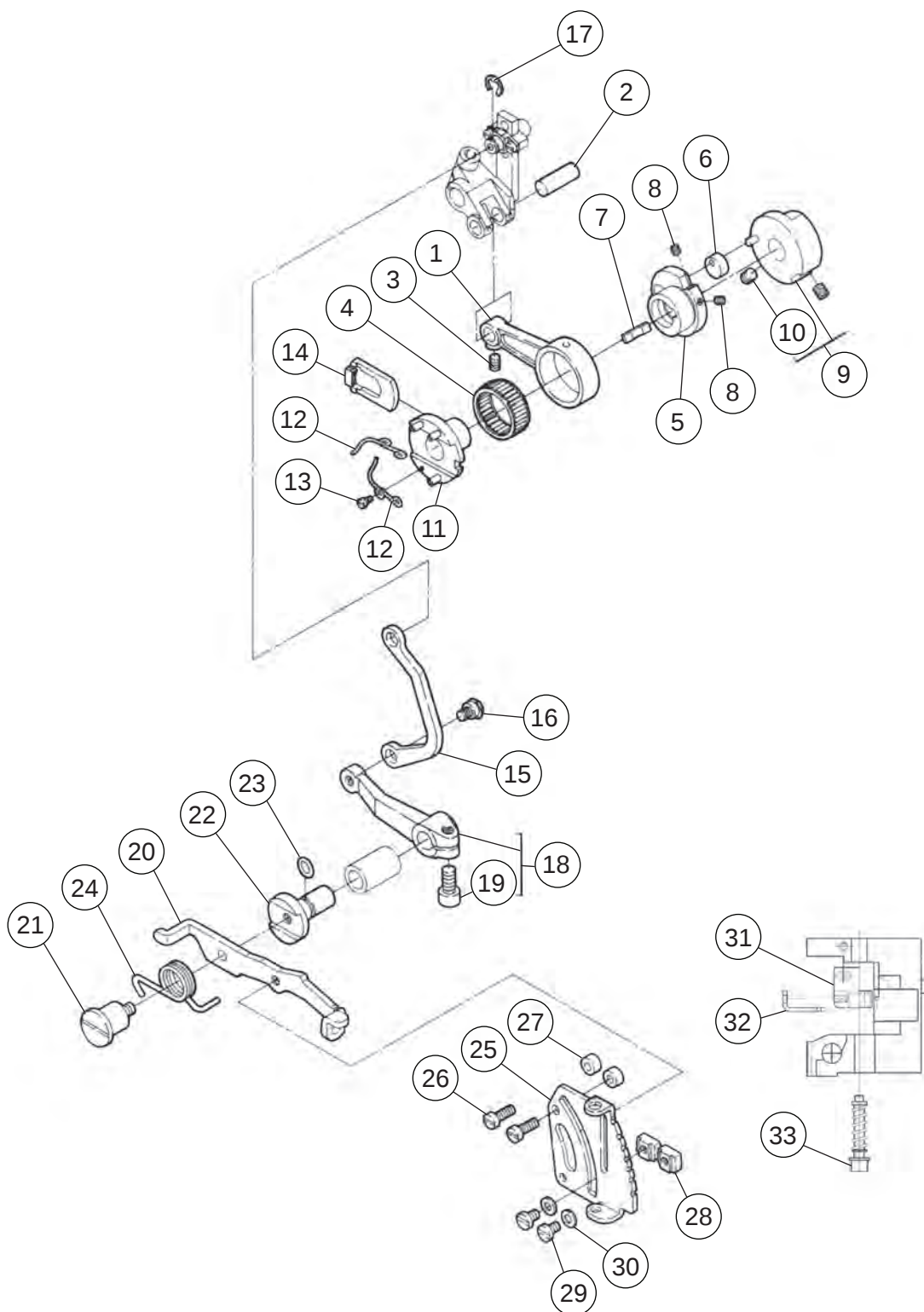
View 1 of 2



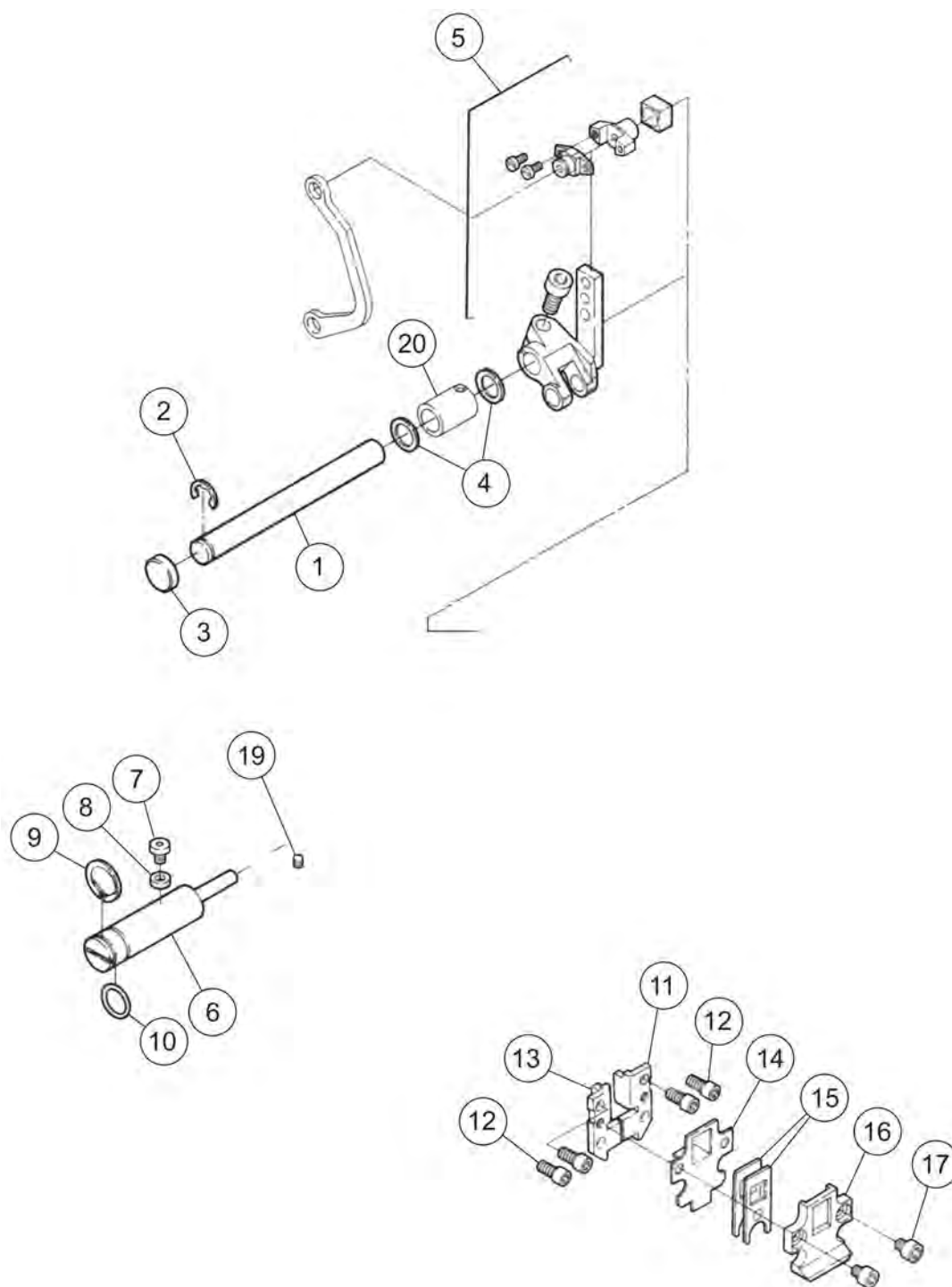
ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	6Z8153	CONNECTION	1
2	6Z1678	NEEDLE BEARING	1
3	6ZA645	CRANK	1
4	6Z7029	BUSHING	1
5	660265	SCREW	1
6	6Z6762	WASHER	1
7	6Z3615	SLIDER	1
8	6Z0028	BOLT	1
9	6Z6715	WASHER	1
10	6Z3747	SPRING WASHER	1
11	660159	PIN	1
12	6ZA646	O-RING	1
13	660194	SHAFT	1
14	6Z3621	HOLDER	1
15	6Z0026	SCREW	1
16	6Z8120	CRANK	1
17	6Z0026	SCREW	1
18	6Z7028	LINK	1
19	6Z7029	BUSHING	1
20	660265	SCREW	1
21	6Z6762	WASHER	1
22	660195	SHAFT	1
23	6Z1033	OIL SEAL	1
24	6Z1444	DOUBLE CHAIN STITCH LOOPER	1
25	6Z1455	SCREW	1
26	6Z3647	LOOPER HOLDER	1
27	6Z0021	SCREW	1
28	6Z0035	SPACER	1
29	6Z0974	SCREW	1



ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
3	6Z0053	BRACKET	1
4	6Z5719	SCREW	1
5	730051	WASHER	2
6	6Z0020	SCREW	1
7	6Z0039	TENSION DISC	2
8	6Z0060	SPRING	1
9	6Z0054	KNOB	1
10	6Z3594	THREAD GUIDE	1
11	6Z0015	SCREW	1
12	6Z0224	THREAD GUIDE	1
13	6Z0376	SCREW	1
14	6Z0207	THREAD GUIDE	1
15	6Z0376	SCREW	1
16	6Z1880	LOOPER THREAD TAKE-UP ASSEMBLY	1
17	6Z2547	SCREW	2
18	6Z6739	SPRING	1
19	6Z0178	THREAD GUIDE	1
22	6Z0317	THREAD GUIDE	1
23	660129	HOLDER	2

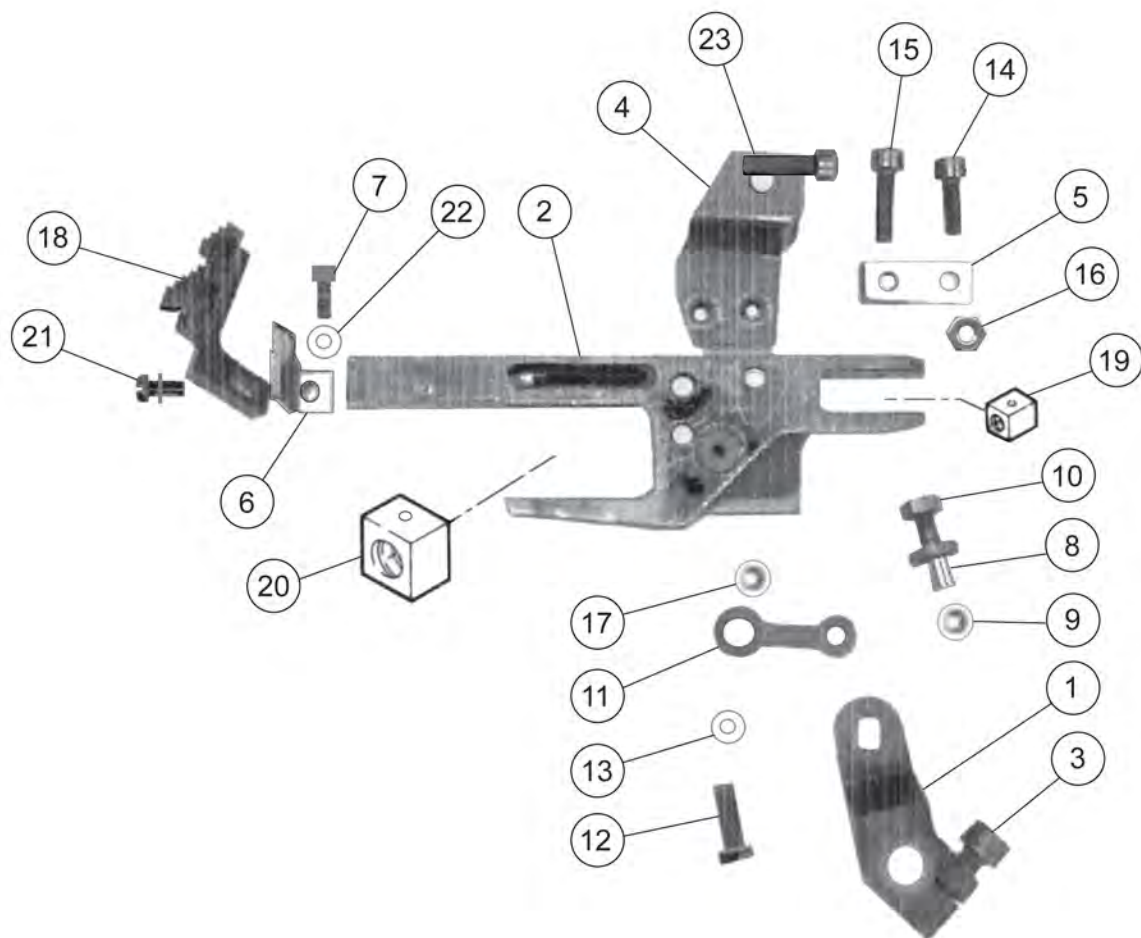


ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	6Z6972	CONNECTION	1
2	6Z0042	PIN	1
3	6Z0027	SCREW	1
4	6Z7786	NEEDLE BEARING	1
5	6Z6199	ECCENTRIC	1
6	6Z0905	GUIDE FEED ECCENTRIC	1
7	6Z0854	FLAT SPRING	1
8	6Z5614	SCREW	2
9	6Z6200	REGULATOR	1
10	6Z3753	SCREW	2
11	6Z8607	ECCENTRIC ASSEMBLY MOD DUAL-SPRING	1
12	6Z6173	SPRING	2
13	6Z6175	SCREW	1
14	6Z6172	RATCHET	1
15	6Z4102	LINK	1
16	6Z4807	SCREW	1
17	6Z2382	RING	1
18	6Z8107	LEVER	1
19	6Z0026	SCREW	1
20	660182	LEVER	1
21	6Z7785	SCREW	1
22	6Z5598	SHAFT	1
23	6Z1833	O-RING	1
24	660183	SPRING	1
25	660184	REGULATOR PLATE	1
26	6Z3639	SCREW	2
27	6Z5407	SPACER	2
28	6Z5631	STOPPER	2
29	6Z5908	SCREW	2
30	660227	WASHER	2
31	6Z5320	FLANGE STITCH REGULATOR	1
32	6Z5321	COVER STITCH REGULATOR	1
33	6Z5319	PUSH BUTTON STITCH REGULATOR	1



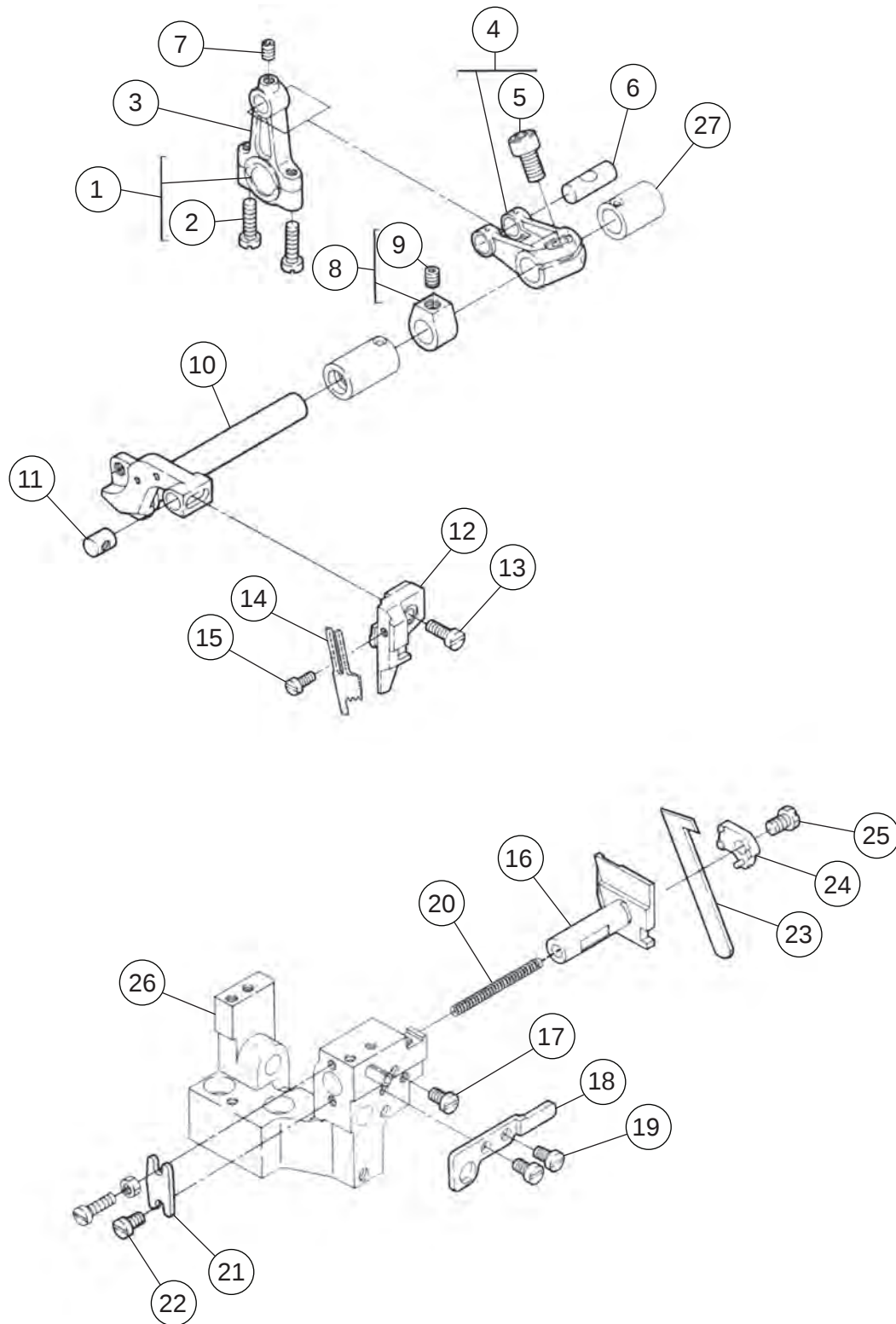
ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	6Z6807	SHAFT	1
2	660128	RING	1
3	6Z1254	PLUG	1
4	6Z7721	WASHER	2
5	6Z3646	CRANK ASSY/ MONO FEED BAR ASSY	1
6	6Z0046	PIN	1
7	6Z0018	SCREW	1
8	6Z0032	GASKET	1
9	6Z0033	RING	1
10	6Z0061	O-RING	1
11	6Z3644	GUIDE FEED BAR	1
12	6Z3649	SCREW	4
13	6Z0074	GUIDE FEED BAR LEFT	1
14	6Z0045	GUIDE FEED BAR OIL SEAL REAR	1
15	6Z0043	OIL SEAL	2
16	6Z4185	GUIDE FEED BAR OIL SEAL EX	1
17	6Z3648	SCREW	2
19	6Z2576	SCREW	2
20	6Z9403	BSHG BRASS	1

Mono Feed Bar

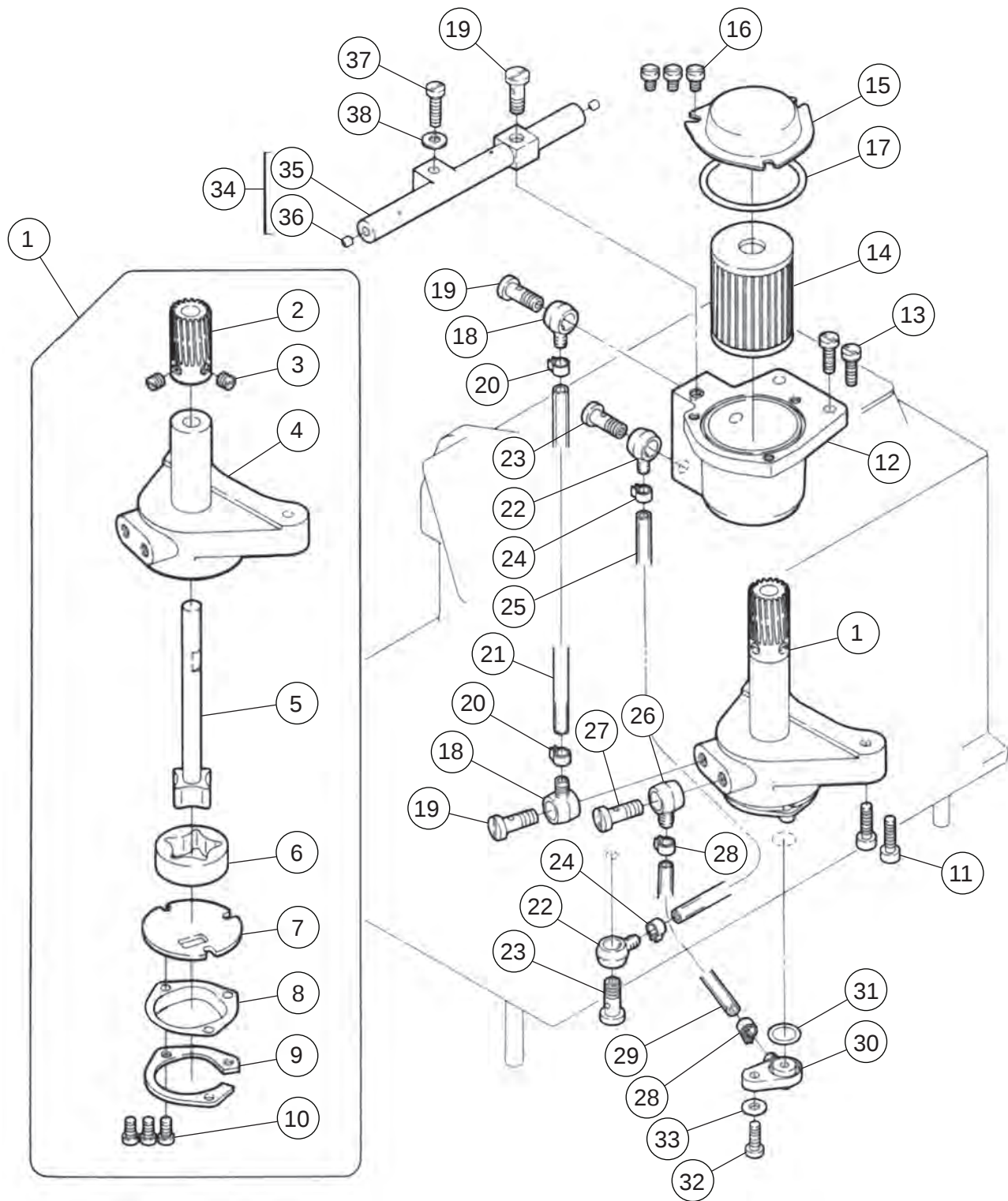


ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	6Z59006	CRANK MAIN FEED BAR	1
2	6Z5919	FEED BAR MONO 4000	1
3	SHCSM6X16	SHCS M6 x 16	1
4	6Z5855	HOLDER TOP FEED	1
5	6Z5856	KEY TOP FEED HOLDER	1
6	6Z5923	RETAINER LOWER FEED	1
7	SHCSM3.5X8	SHCS M3.5 x 8	1
8	6Z6713	PIN CRANK	1
9	6Z6715	WASHER CRANK	2
10	6Z1827	NUT CRANK	1
11	6Z7028	LINK CRANK	1
12	660265	SCREW LINK	1
13	6Z6762	WASHER	1
14	6Z2762	SCREW	1
15	SHCS10-32X3/4	SHCS #10-32 x 3/4	1
16	6Z1174	NUT HEX #10-32	2
17	6Z7029	BUSHING LINK	1
18	6ZD099	MAIN FEED DOG	1
19	6Z0047	BLOCK FEED LEVELING	1
20	6Z9683	GUIDE BLOCK MAIN FEED BAR	1
21	6Z9058	SCREW FILLISTER HEAD M3.5 x 10	1
22	6Z4201	WASHER BELLEVILLE #6	1
23	6Z9182	SHCS #5-4 x 5/8	1

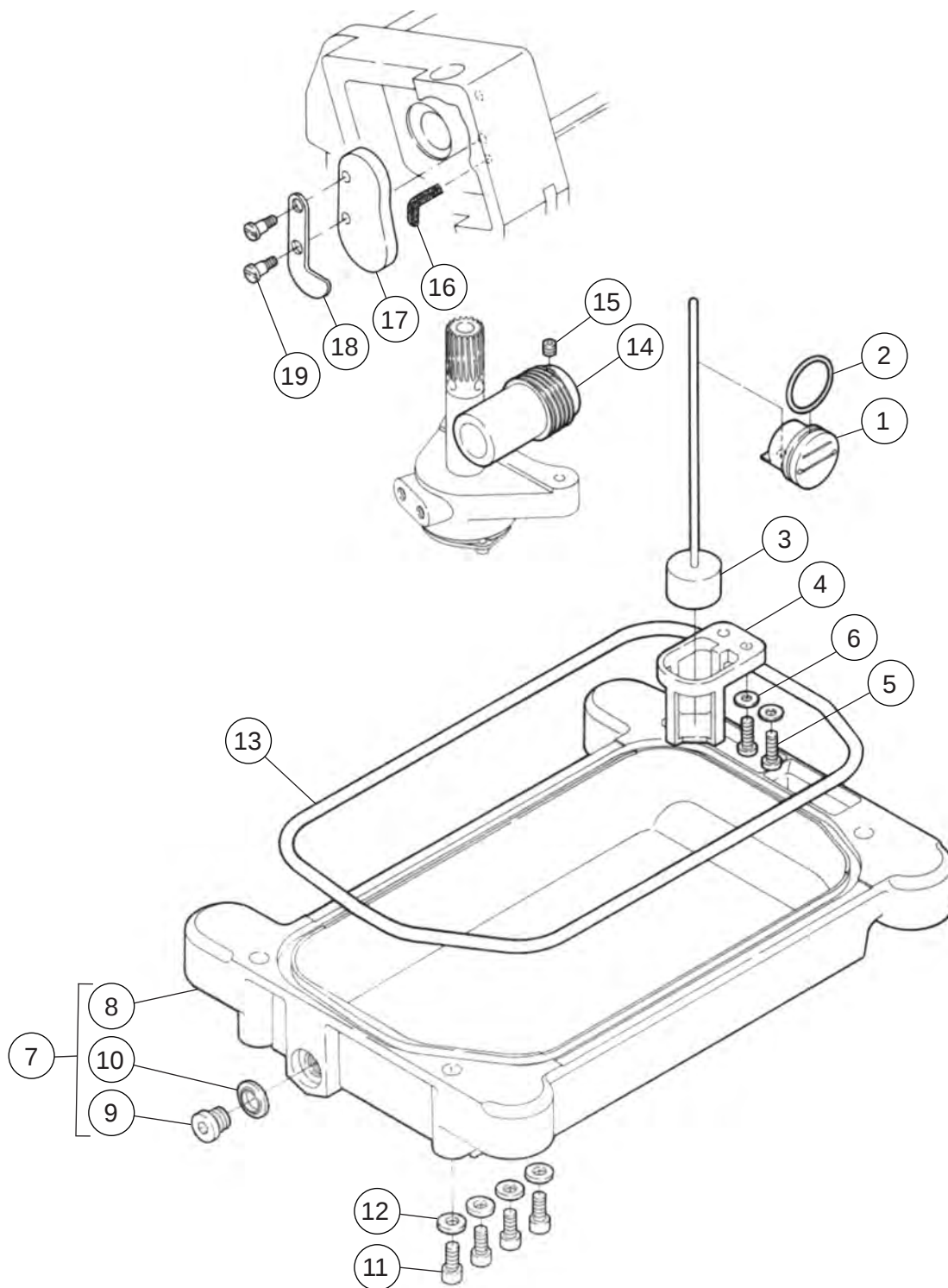
Knife Drive Mechanism



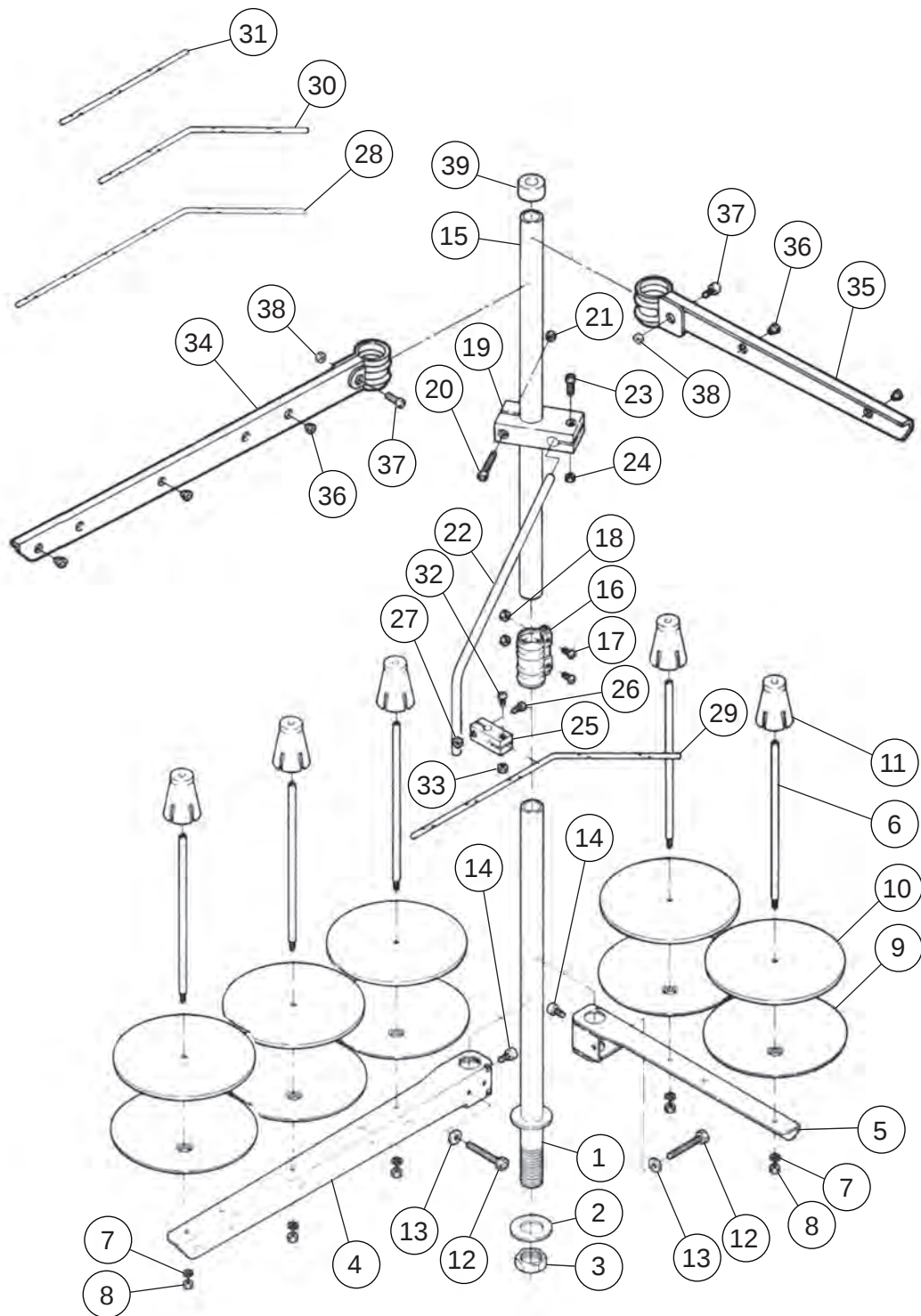
ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	6Z6271	CONNECTION	1
2	6Z0023	SCREW	2
3	6Z6935	CRANK	1
4	660245	CRANK	1
5	6Z0026	SCREW	1
6	6Z0042	PIN	1
7	6Z0027	SCREW	1
8	660236	COLLAR	1
9	660260	SCREW	1
10	6Z6116	TOP KNIFE LEVER	1
11	6Z0048	PIN	1
12	802017	TOP KNIFE CLAMP	1
13	6Z3639	SCREW	1
14	6Z6360	TOP KNIFE SERRATED	2
15	6Z3538	SCREW	1
16	6Z3654	BOTTOM KNIFE HOLDER	1
17	3Z0024	SCREW	1
18	6Z3759	GUIDE BOTTOM KNIFE HOLDER	1
19	6Z0024	SCREW	2
20	6Z0034	SPRING	1
21	6Z7341	PLATE	1
22	6Z0024	SCREW	1
23	6Z0386	BOTTOM KNIFE THICK	1
24	6Z0050	BOTTOM KNIFE CLAMP	1
25	730293	SCREW	1
26	6Z3653	NEEDLE PLATE / KNIFE SUPPORT	1
27	6Z9403	BSHG BRASS	2



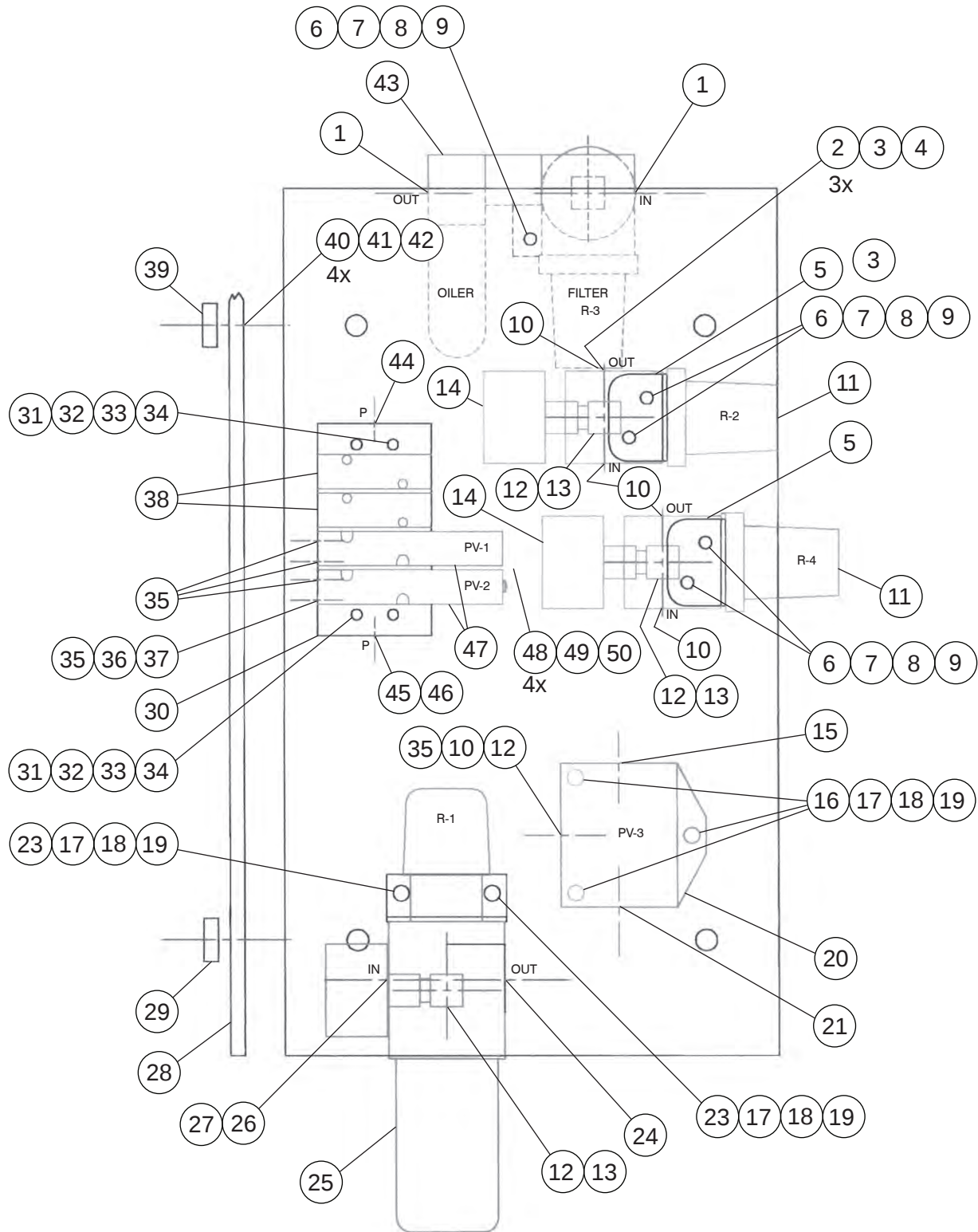
ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	6Z5680	PUMP	1
2	6Z3545	WORM WHEEL	1
3	6Z3149	SCREW	2
4	660200	PUMP BODY	1
5	6Z2278	ROTOR SHAFT INSIDE	1
6	6Z1850	ROTOR OUTSIDE	1
7	660201	CASING PLATE	1
8	6Z1845	FILTER	1
9	660140	GUIDE	1
10	6Z3538	SCREW	3
11	660257	SCREW	2
12	660202	TANK	1
13	6Z3639	SCREW	2
14	6Z1843	OIL FILTER	1
15	660203	COVER	1
16	660082	SCREW	3
17	6Z3622	O-RING	1
18	6Z1857	JOINT	2
19	660154	SCREW	3
20	6Z3234	CLAMP	2
21	660153	TUBE	1
22	6Z1857	JOINT	2
23	660154	SCREW	2
24	6Z3234	CLAMP	2
25	660146	TUBE	1
26	6Z1857	JOINT	1
27	660154	SCREW	1
28	6Z3234	CLAMP	2
29	660156	TUBE	1
30	660205	JOINT	1
31	6Z6193	O-RING	1
32	6Z3639	SCREW	1
33	660227	WASHER	1
34	6Z6328	OIL DISTRIBUTOR COMPLETE	1
35	660204	OIL DISTRIBUTOR	1
36	660133	PLUG	2
37	6Z0023	SCREW	1
38	660227	WASHER	1



ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	6Z3660	OIL SIGHT GAUGE	1
2	660141	O-RING	1
3	6ZA204	INDICATOR COMPLETE 210193	1
4	660134	INDICATOR SUPPORT	1
5	6Z3639	SCREW	2
6	660227	WASHER	2
7	6Z8158	OIL RESERVOIR ASSEMBLY	1
8	660196	OIL RESERVOIR	1
9	6Z0057	SCREW	1
10	6Z3340	GASKET	1
11	6Z0028	BOLT	4
12	6Z0036	WASHER	4
13	6Z0051	GASKET	1
14	6Z3752	WORM	1
15	6Z3753	SCREW	1
16	620275	OIL WICK 20 IN	1
17	6Z0058	OIL FELT	1
18	660208	COVER	1
19	660271	SCREW	1



ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	6Z3102	THREAD STAND ROD	1
2	640044	WASHER	1
3	640042	NUT	1
4	6Z1899	BRACKET	1
5	6Z0408	BRACKET	1
6	6Z2835	SPOOL PIN	5
7	640005	SPRING WASHER	5
8	6Z1828	NUT	5
9	6Z2838	SPOOL TRAY	5
10	6Z1900	CUSHION	5
11	6Z2837	SPOOL RETAINING PIN	5
12	640065	SCREW	2
13	6Z3347	WASHER	2
14	6Z2574	SCREW	2
15	640040	THREAD STAND UPPER	1
16	6Z3100	JOINT	1
17	6Z6120	SCREW	2
18	6Z1827	NUT	2
19	6Z2264	BRACKET	1
20	6Z2572	SCREW	1
21	6Z1828	NUT	1
22	6Z0237	THREAD GUIDE BAR ROD	1
23	6Z2573	SCREW	2
24	6Z1828	NUT	2
25	6Z1214	HOLDER	1
26	6Z2573	SCREW	1
27	6Z1828	NUT	1
28		THREAD GUIDE BAR	1
29	6Z3074	THREAD GUIDE BAR 5-SPOOL	1
30		THREAD GUIDE BAR	1
31		THREAD GUIDE BAR	1
32	6Z2573	SCREW	1
33	6Z1828	NUT	1
34	6Z0410	BRACKET	1
35	6Z0406	BRACKET	1
36	6Z3070	THREAD GUIDE	5
37	6Z2571	SCREW	2
38	6Z1827	NUT	2
39	640041	ROD CAP	1



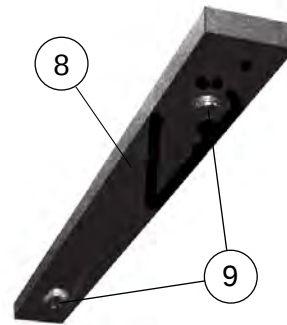
ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	KQL03-35S	FITTING AIR 90°	2
2	MF-1010	COUPLING #10-32	1
3	6Z2702	SHUTTLE VALVE MSV-1	1
4	6Z0172	FITTING AIR MH-1016	3
5	6Z1395	LOCK RING BRACKET	2
6	SHCS10-32X3/4	SHCS #10-32 x 3/4	5
7	6Z0994	WASHER FLAT #10	5
8	6Z2826	WASHER LOCK SPLIT #10	5
9	6Z1174	NUT HEX #10	5
10	KQL03-34S	FITTING AIR 90°	5
11	6Z3395	AIR REGULATOR 0-30 PSI	2
12	6Z5846	NIPPLE 1/8 NPT	3
13	6Z8288	ELBOW BRASS	3
14	6Z3394	GAUGE 0-30 PSI	2
15	KQL07-36S	FITTING AIR 90°	1
16	SHCS1/4-20X1	SHCS 1/4-20 x 1	3
17	6Z1000	WASHER FLAT 1/4	5
18	6Z2832	WASHER LOCK 1/4	5
19	6Z1172	NUT HEX 1/4	5
20	4099029	VALVE AIR PILOT	1
21	KQH11-36S	CONNECTOR MALE	1
22	AS1000F-04	FLOW CONTROL 1/8 IN-LINE (NOT SHOWN)	1
23	6Z2780	SHCS 1/4-20 x 3/4	2
24	KQT11-36S	FITTING AIR TEE BRANCH	1
25	409902	FILTER REGULATOR AIR	1
26	50925K343	REDUCER 3/8-1/8 NPT	1
27	6Z1556	MALE QUICK DISCONNECT	1
28	6Z4148	PANEL PFM PNE	1
29	6Z4154	CLAMP LOWER PFM PNE	1
30	6Z4156	MANIFOLD 4-STA	1
31	SHCS6-32X1-3/4	SHCS #6-32 x 1-3/4	2
32	6Z0139	WASHER FLAT #6	2
33	6Z1178	NUT HEX #6-32	2
34	6Z2829	WASHER LOCK SPLIT #6	2
35	6Z3532	CONNECTOR MALE 5/62 T x 1/8 NPT	5
36	6Z1971	FITTING PLUG-IN Y	1
37	KQU03-00	UNION Y	1
38	VVZ2000-31A-3	BLANKING PLATE	2
39	6Z4153	CLAMP UPPER PFM PNE	1

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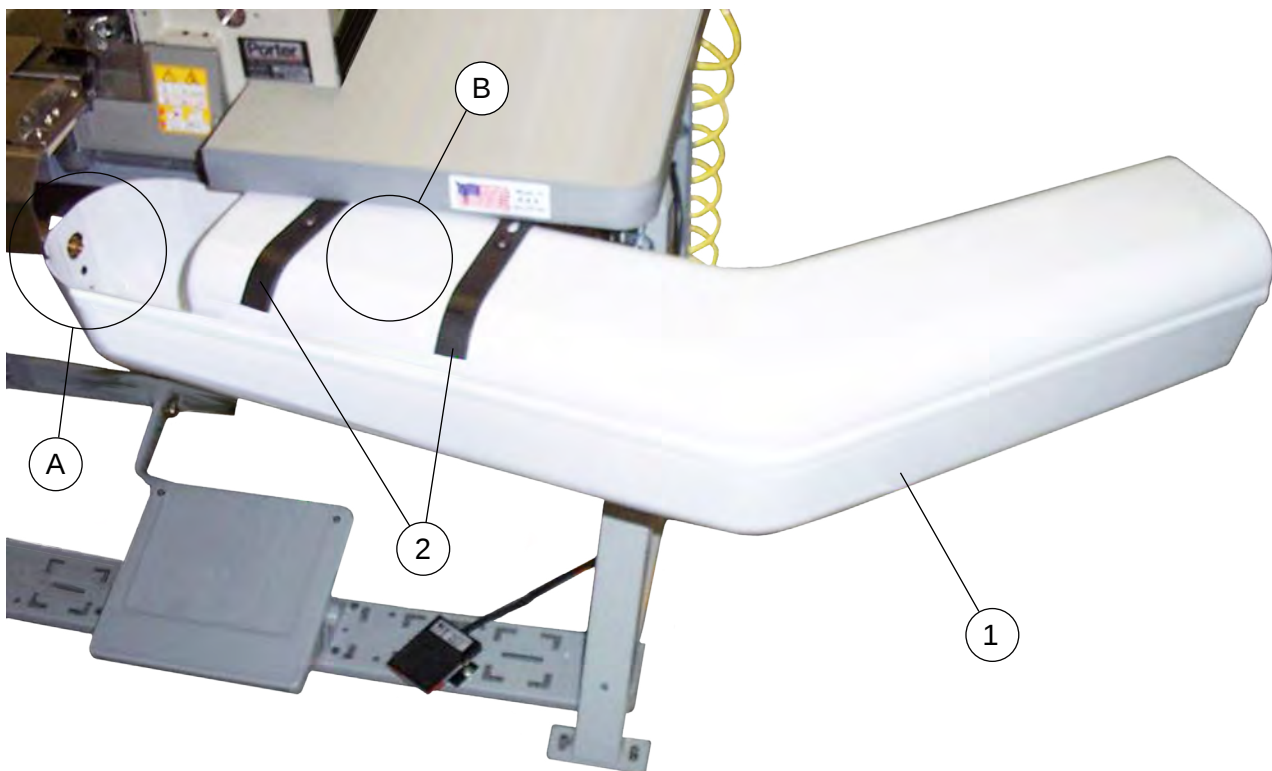
ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
40	BHCS5/16X1	BHCS 5/16-18 x 1	4
41	6Z1002	WASHER FLAT 5/16	4
42	6Z2833	WASHER LOCK SPLIT 5/16	4
43	6Z8475	FILTER REGULATOR GAUGE & LUBE 30 PSI	1
44	4464K331	PLUG HEX 1/8 NPT	1
45	6Z8292	COUPLING REDUCING	1
46	KQL07-34S	FITTING AIR 90°	1
47	NVZ2150-5G	VALVE SOLENOID 24V	2
48	6Z4204	CABLE ASSEMBLY PFM PNE	1
49	6Z4209	MOLEX RECEPTACLE 6-PIN	1
50	6Z0941	CRIMP PIN FEMALE	4
51	TU0425B-20	TUBING AIR 5/32 OD (NOT SHOWN)	17
52	TIUB11B-20	TUBING AIR 3/8 OD (NOT SHOWN)	2
53	4021010	TUBING AIR 1/4 OD (NOT SHOWN)	4
54	6Z8260	PNEUMATIC DIAGRAM PFM-4000	1



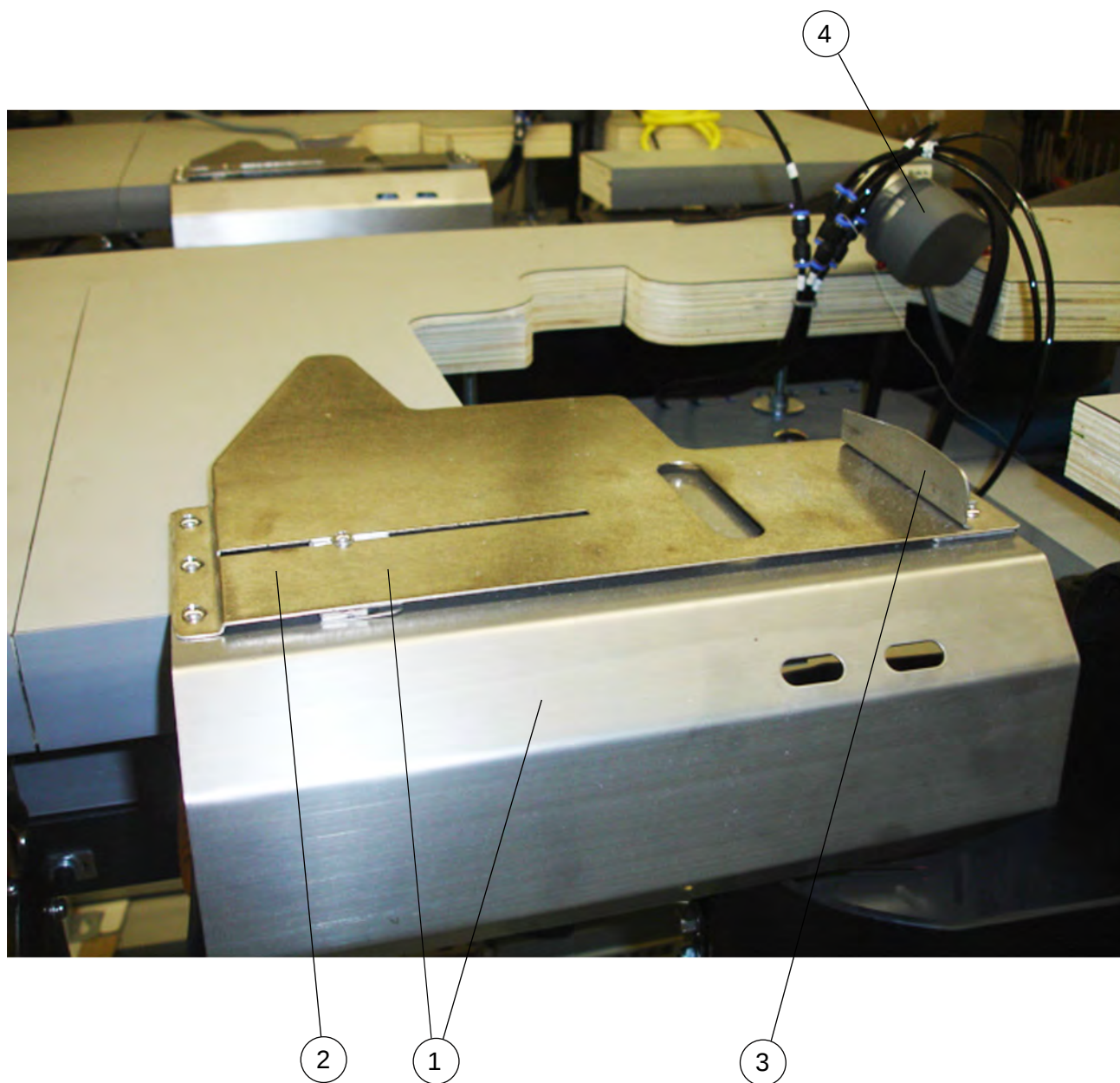
DETAIL A



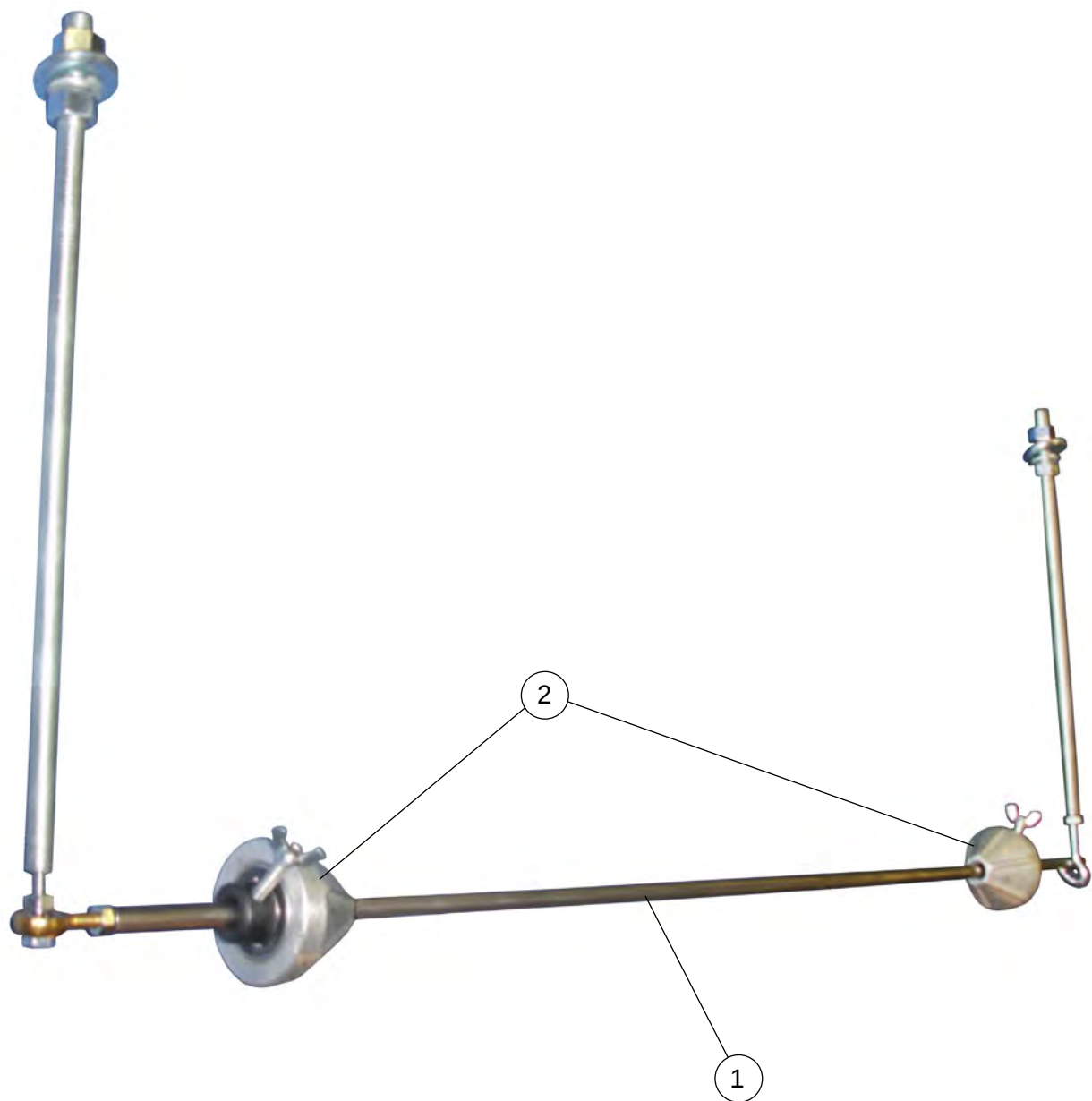
DETAIL B
BRACKET INSIDE PLENUM



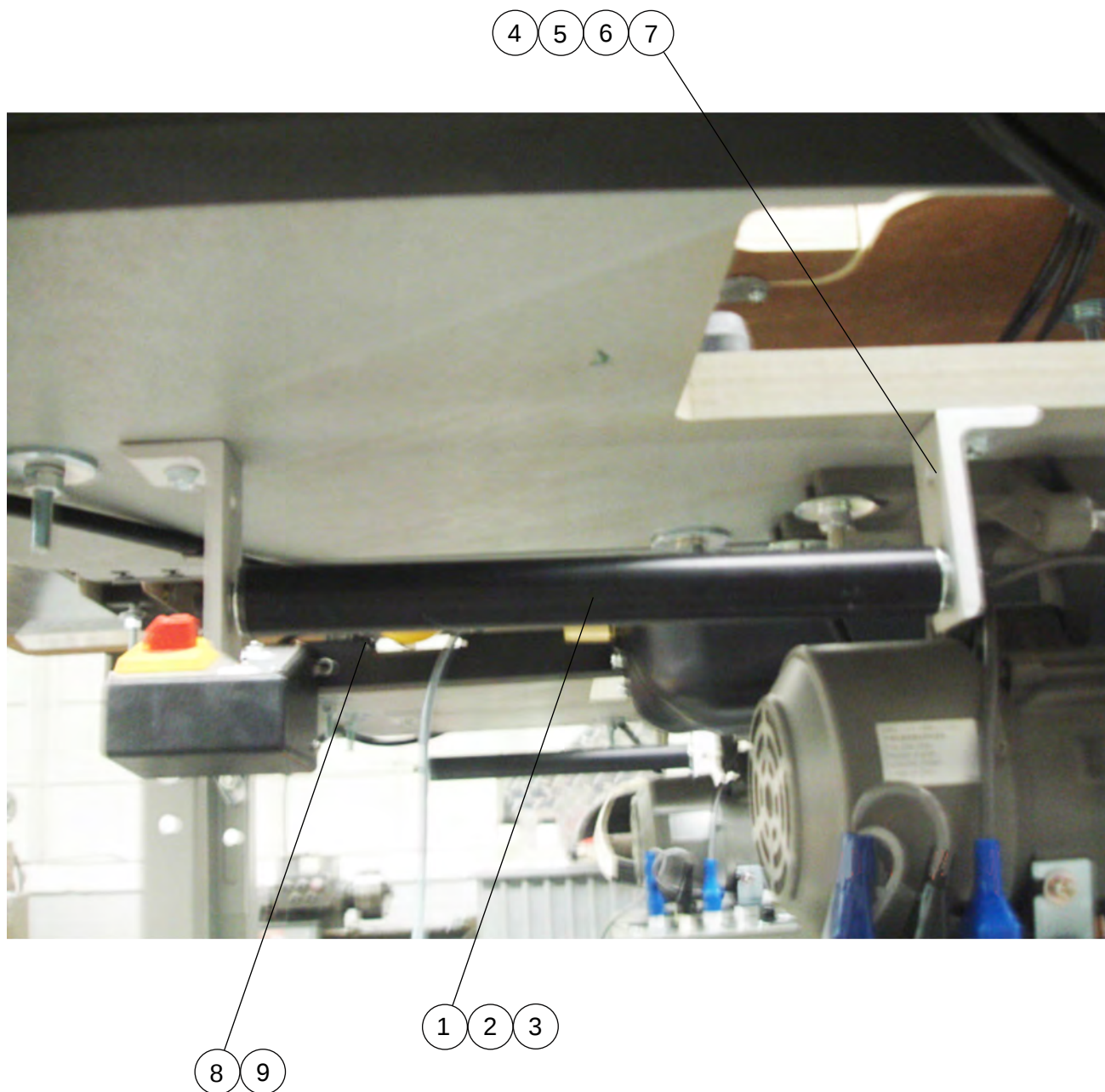
ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	6ZC386	VACUUM PLENUM	1
2	802757	BRKT HANGER MT	2
3	KQL07-34S	FTG AIR	1
4	6Z8334	AIR JET HIGH THRUST	1
5	6Z8281	BRKT AIR VACUUM	1
6	BHCS10-32X3/4	BHCS #10-32 x 3/4	2
7	LN10-32	NUT NYLON LOCK	2
8	6Z4153	CLAMP UPR	1
9	BHCS5/16-18X3/4	BHCS 5/16-18 x 3/4	2



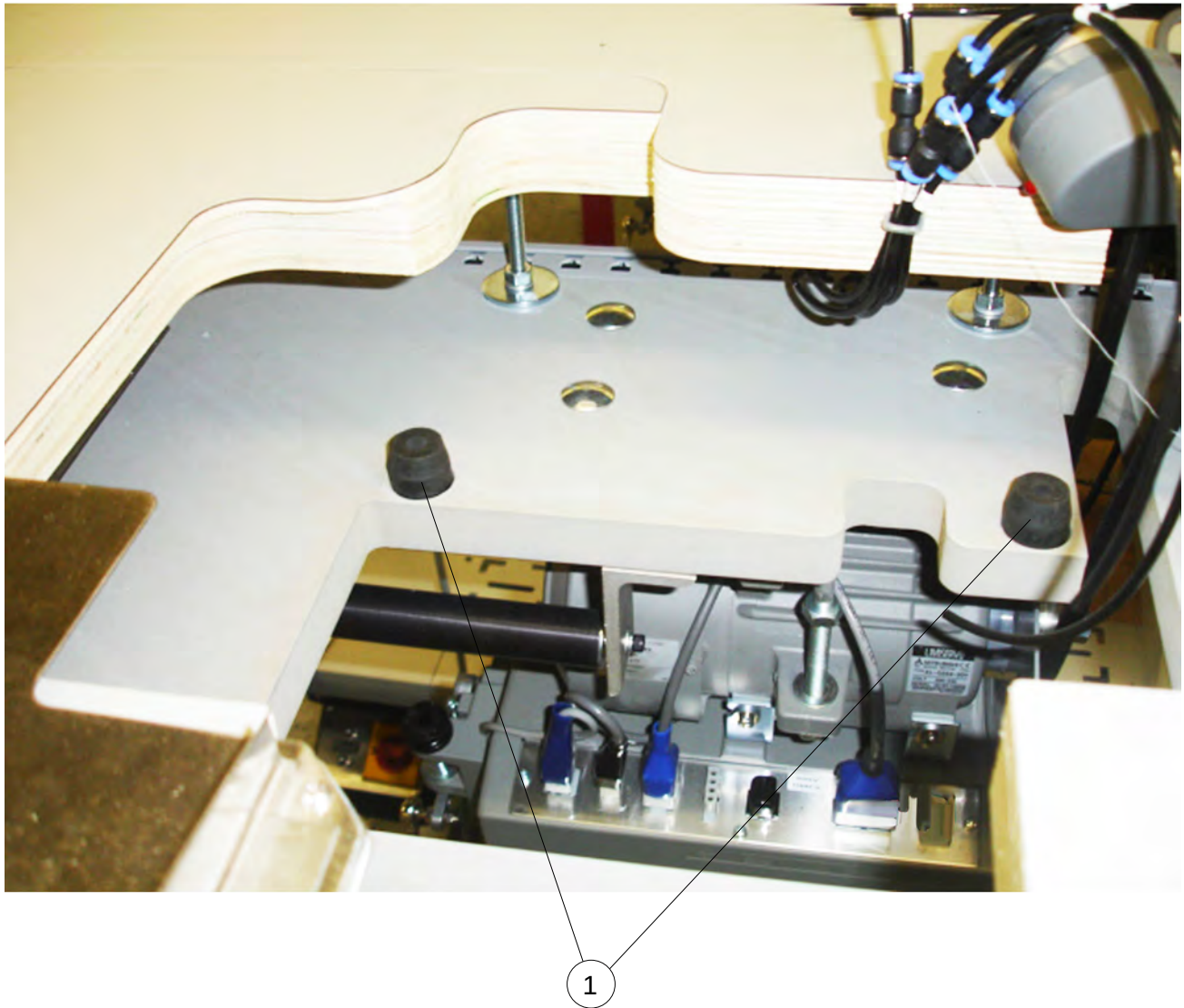
ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	6Z0966	FLANGE FOLDER ASSY	1
2	6Z5898	*MAY BE PURCHASED SEPARATELY	
3	6Z3186	EDGE GUIDE	1
4	6Z2991	SYNCHRONIZER NEEDLE POSITIONER	1
5	6Z5899	ROTARY CUTTER ASSY (NOT SHOWN)	
6	6Z5903	*ROTARY CUTTER BLADE MAY BE PURCHASED SEPARATELY	



ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	6Z0971	ROD ASSY	1
2	6Z0644	BRG CONE	2



ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	800859	IDLER ROLLER	1
2	800858	IDLER SHAFT (NOT SHOWN)	1
3	6383K215	BRG (NOT SHOWN)	2
4	BHCS10-32X3/4	BHCS #10-32 x 3/4	2
5	4376	BRKT	2
6	6Z2826	WASHER LOCK #10	2
7	6Z0994	WASHER FLAT #10	2
8	6Z5899	ROTARY CUTTER	1
9	6Z5903	*ROTARY CUTTER BLADE MAY BE PURCHASED SEPARATELY	



ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	6Z2287	ISOLATORS	4

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