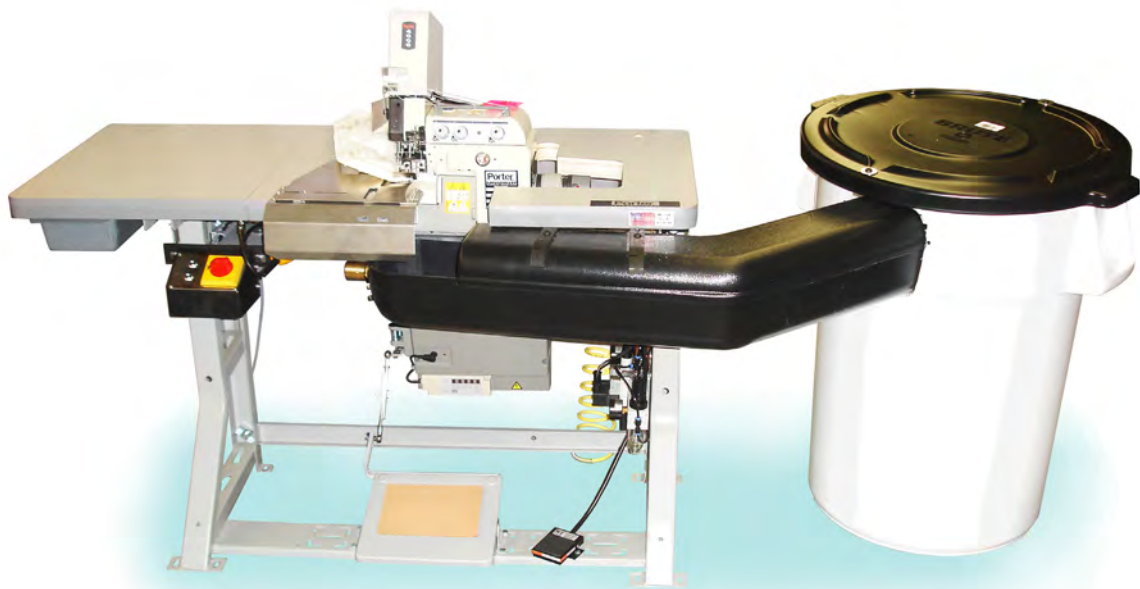


## Parts Manual



## PFM-4000 Flange Machine

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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.

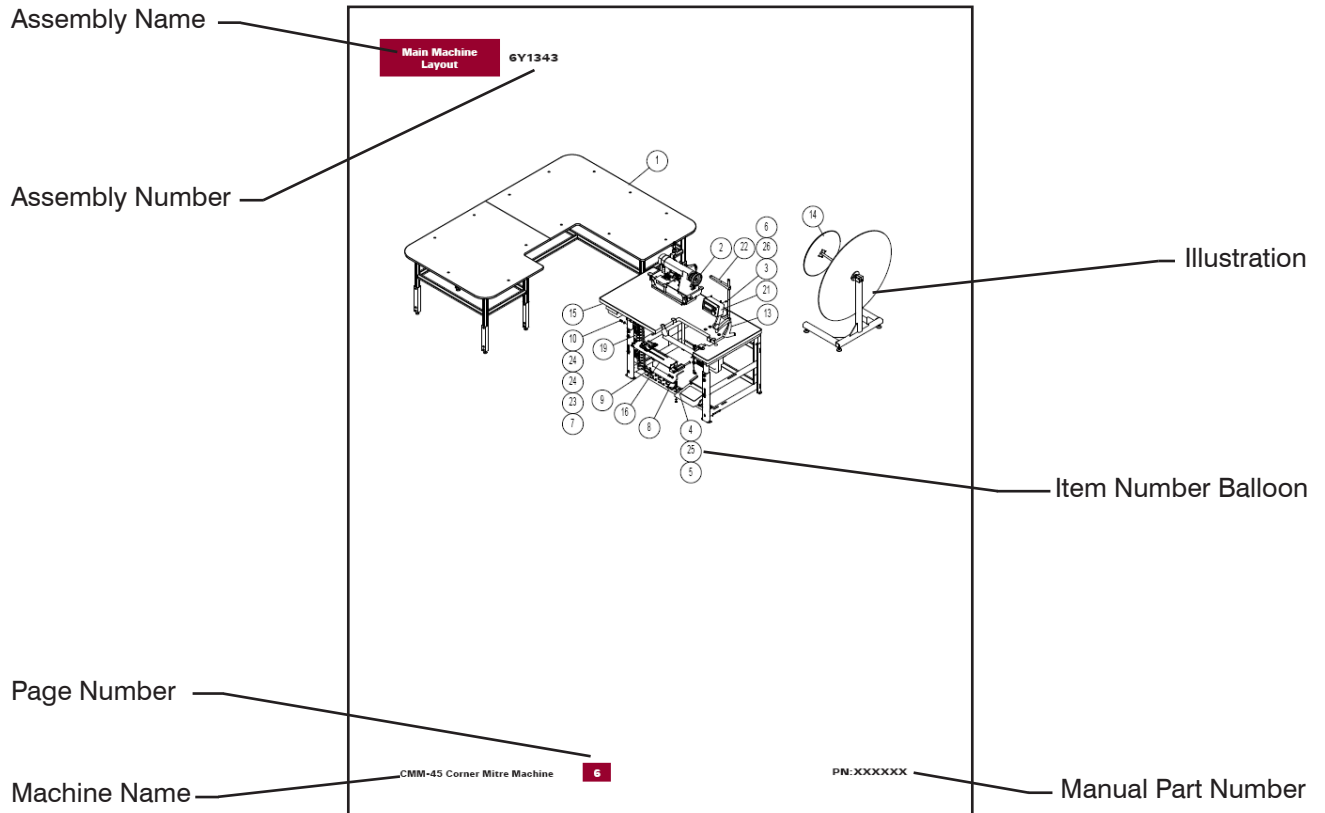
The Item column contains the balloon callout in the illustration. Quantity column (Qty) lists the number of those parts used in the illustration. Assembly column (Assy) identifies that another assembly illustration can be referenced for further part breakdown. The Description column is a description 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	62B631
14	1	S	MATERIAL PAYOFF STAND ASSY	62B611
15	1	S	STAND ASSY	62B618
16	1	S	FOLDER ASSY	62B620
17	1		VALVE STATION, 2002 SERIES, 8 MANIFOLD, WITH CONNECTORS (NOT SHOWN)	62B639
18	1		FRL ASSY (NOT SHOWN)	62B640
19	1	S	ELECTRICAL ASSY	62B644
20	1		1/4 NPT TO 1/4 TUBE BRANCH TEE, (SPC - TEE-4MP-4T) (NOT SHOWN)	62B648
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	62D997

PN:XXXXXX

7 CMM-45 Corner Mitre Machine



## 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.



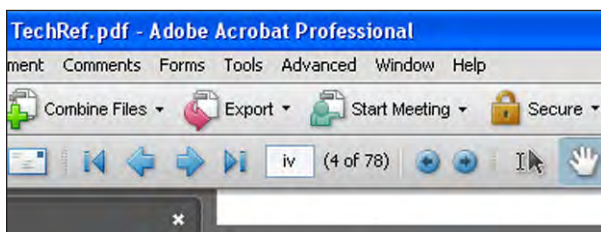
**IMPORTANT!** For additional information about Adobe® Acrobat® Reader or to download a free version of Adobe® Acrobat® Reader, please visit [www.adobe.com](http://www.adobe.com) on the internet.

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.

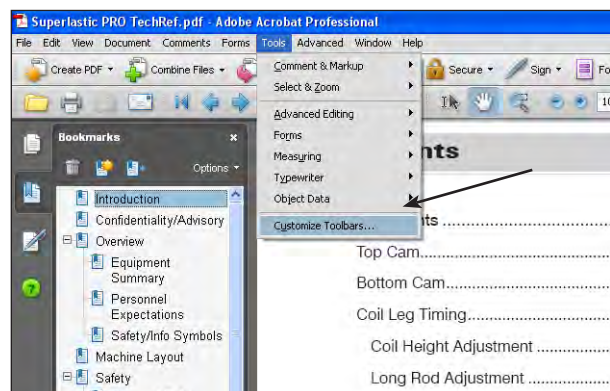
Before using the digital manual, it is recommended that navigational toolbar in Acrobat® be set with all navigation tools available. This is not required to open or read the manual, however if the reader uses a link and “jumps” multiple pages the default Acrobat® settings will only move one page at a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

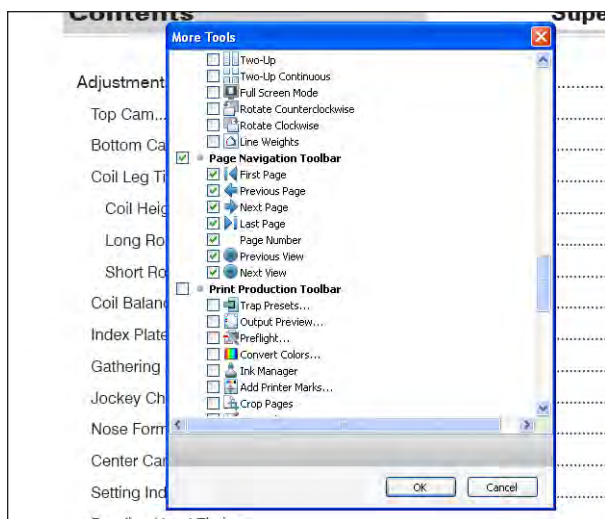


fig.3: A snapshot of the main toolbar with all the navigation tools visible.

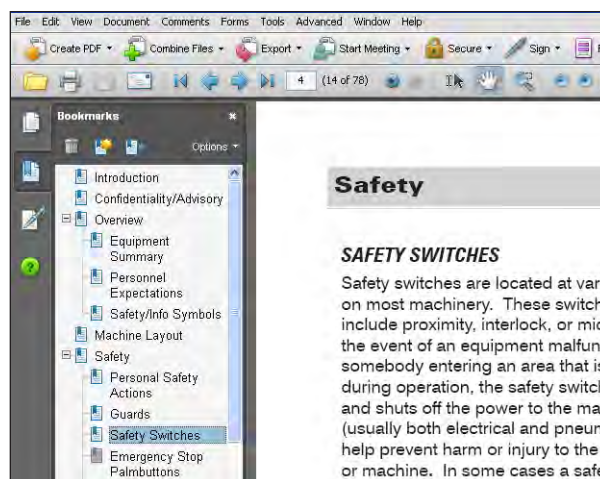


fig.5: Click on a Bookmark topic (left) to open that page in the manual (right).

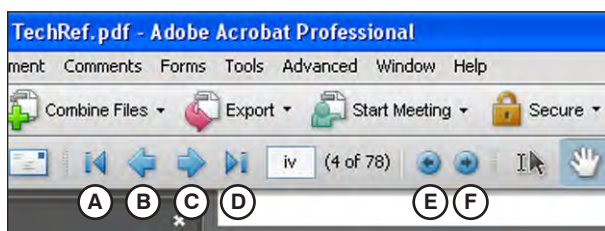


fig.4: The navigational tools.

## 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.

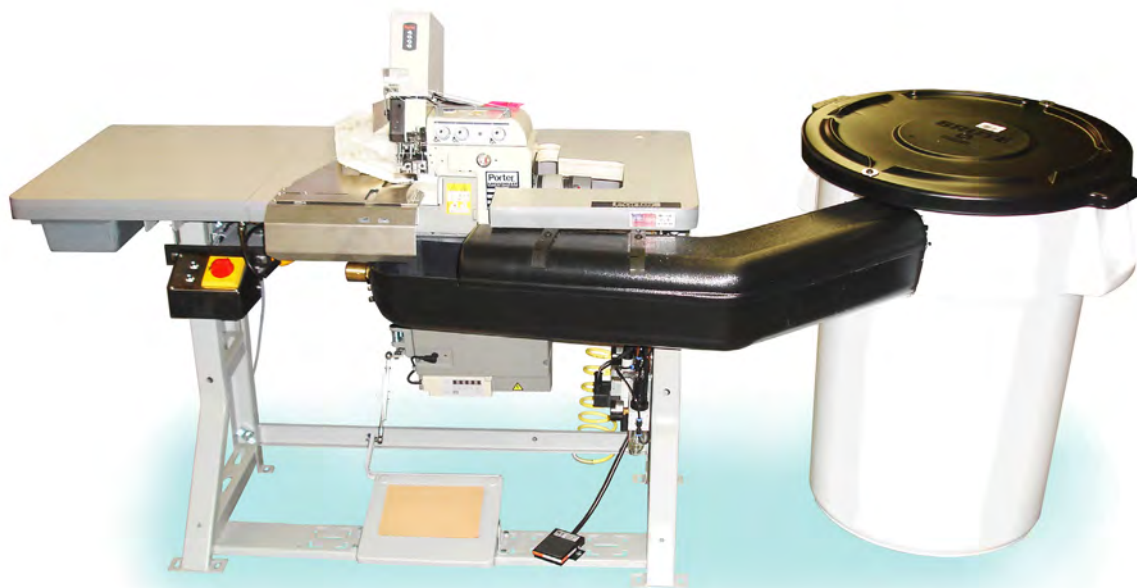
## How to Give Feedback

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.

Please address all comments to:

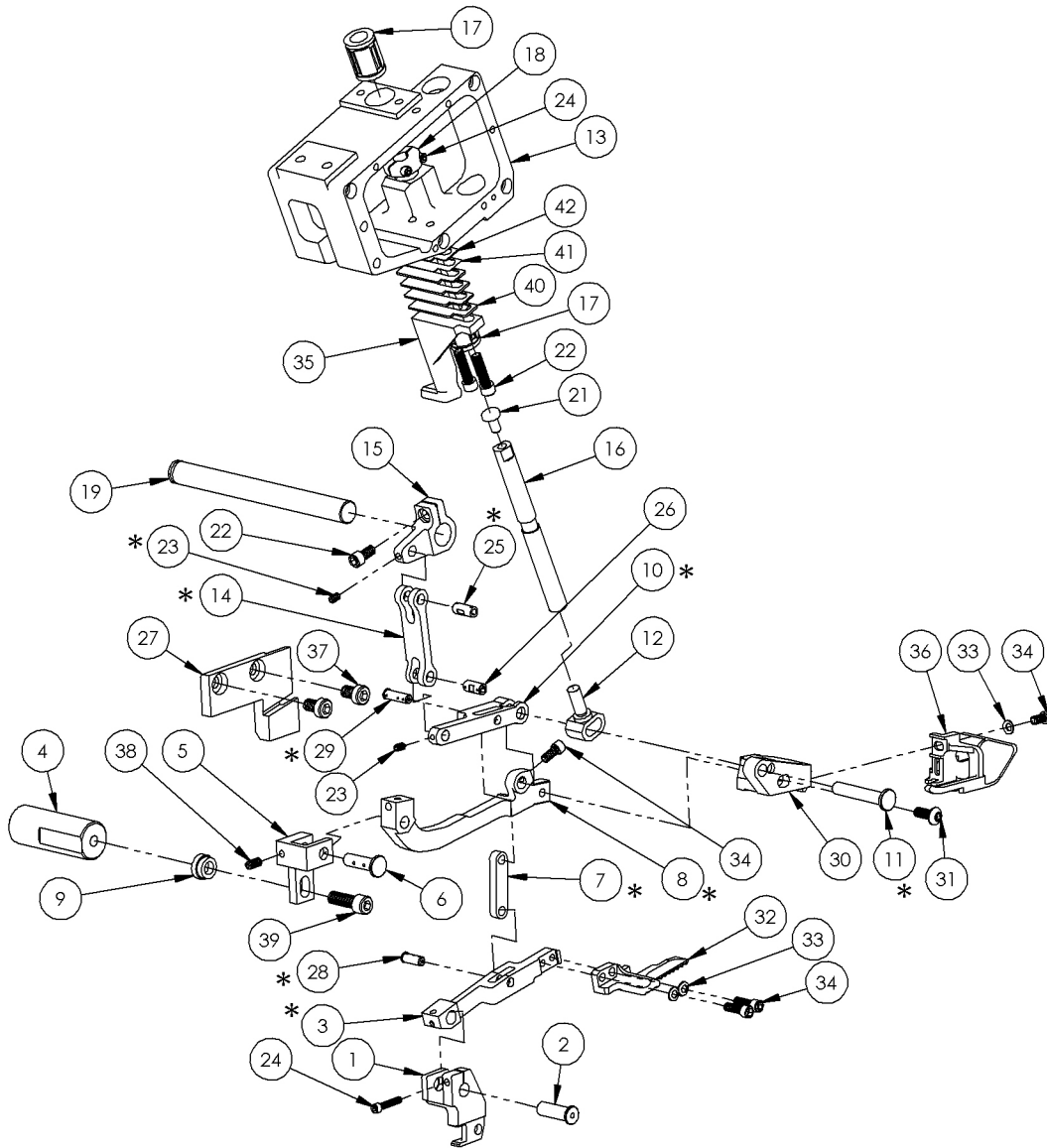
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# Walking Foot Mechanism

\* PARTS MAY BE PURCHASED AS A COMPLETE LINKAGE ASSY PART #6ZD339



## Walking Foot Mechanism

Item	Qty	Assy	Description	Part Number
1	1		HOLDER TOP FEED	6Z5855
2	1		PIN TOP FEED	6Z5310
*3	1		TOP FEED BEAM	6Z7003
4	1		STUD PRESSER FOOT LOCATING	801026
5	1		HOLDER PRESSER FOOT ARM	802769
6	1		PRESSER FOOT ARM PIN	6Z4048
*7	1		LINK TOP FEED	6Z3554
*8	1		ARM PRESSER FOOT	6Z4052
9	1		1/4 SELF ALIGNING WASHER	6Z4220
*10	1		LINK WALKING LIFT H.D.	6Z8520
*11	1		LIFTER PIN	6Z9169
12	1		EXTENSION PR BAR	801254
13	1		HOUSING	801276
*14	1		LINK BEAM CONN.	802453
15	1		WALKING ARM	6Z8217
16	1		LOWER PR. BAR	801257
17	2		LINEAR BALL BEARING	402702
18	1		LIFTING COLLAR	802688
19	1		NEEDLE DRIVE	802685
20	1		PRESSER FOOT	6Z2087
21	1		BAR CAP	6Z8211
22	3		SHCS #10-32 x 3/4	SHCS-10-32X3/4
23	2		SCREW	6Z2790
24	3		SCREW	6Z9182
*25	1		LONG PIVOT PIN	6Z1407
26	1		PIN	6Z1946
27	1		LINKAGE INNER	802682
*28	1		PIVOT PIN LONG	6Z1947
*29	1		PIN PIVOT UPPER	6Z4050
30	1		PRESSER EXTENSION	6Z9168
31	1		SCREW	6Z5271
32	1		LONG	6Z8677
33	3		No. 8 BELLEVILLE WASHER	6Z4202
34	4		SHCS 8-32 X 5/16	6Z2765
35	1		LINKAGE - OUTER	802598
36	1		PRESSURE FOOT 1" SHORT	6Z7175
37	2		SCREW	LHSHCSM6X10
38	1		SHSS #8-32 x 3/8 CUP POINT	6Z2796

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**PN:6Z8304**

**11**

**PFM-4000 Flange Machine**

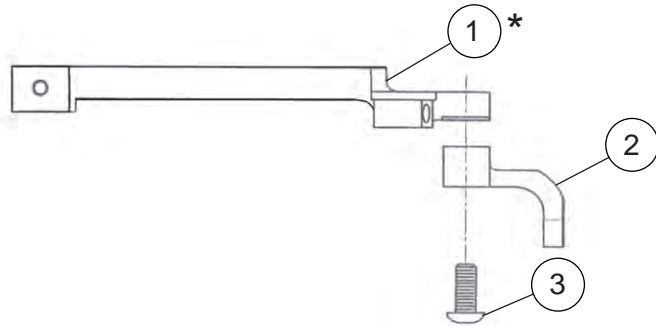
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**Walking Foot  
Mechanism**

<b>Item</b>	<b>Qty</b>	<b>Assy</b>	<b>Description</b>	<b>Part Number</b>
39	1		SHCS 1/4-28 X 3/4	6Z2760
40	4		LINKAGE SHIM .030	802694
41	1		LINKAGE SHIM .010	6Z7002
42	1		LINKAGE SHIM .020	6Z6484

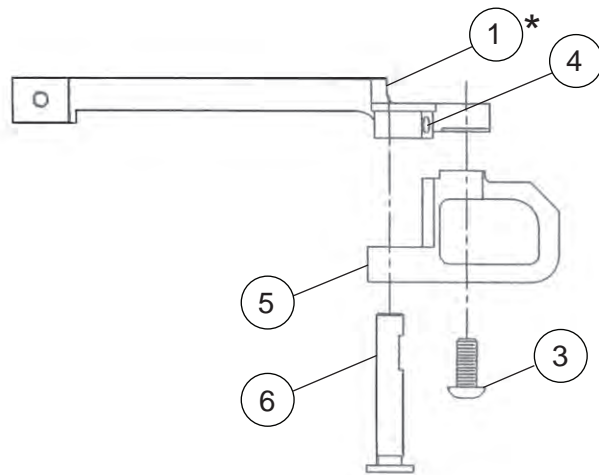


**Presser Foot Arm  
and Extension**



OLD STYLE -  
PRESSER FOOT ARM & EXTENSION ASSEMBLED

---

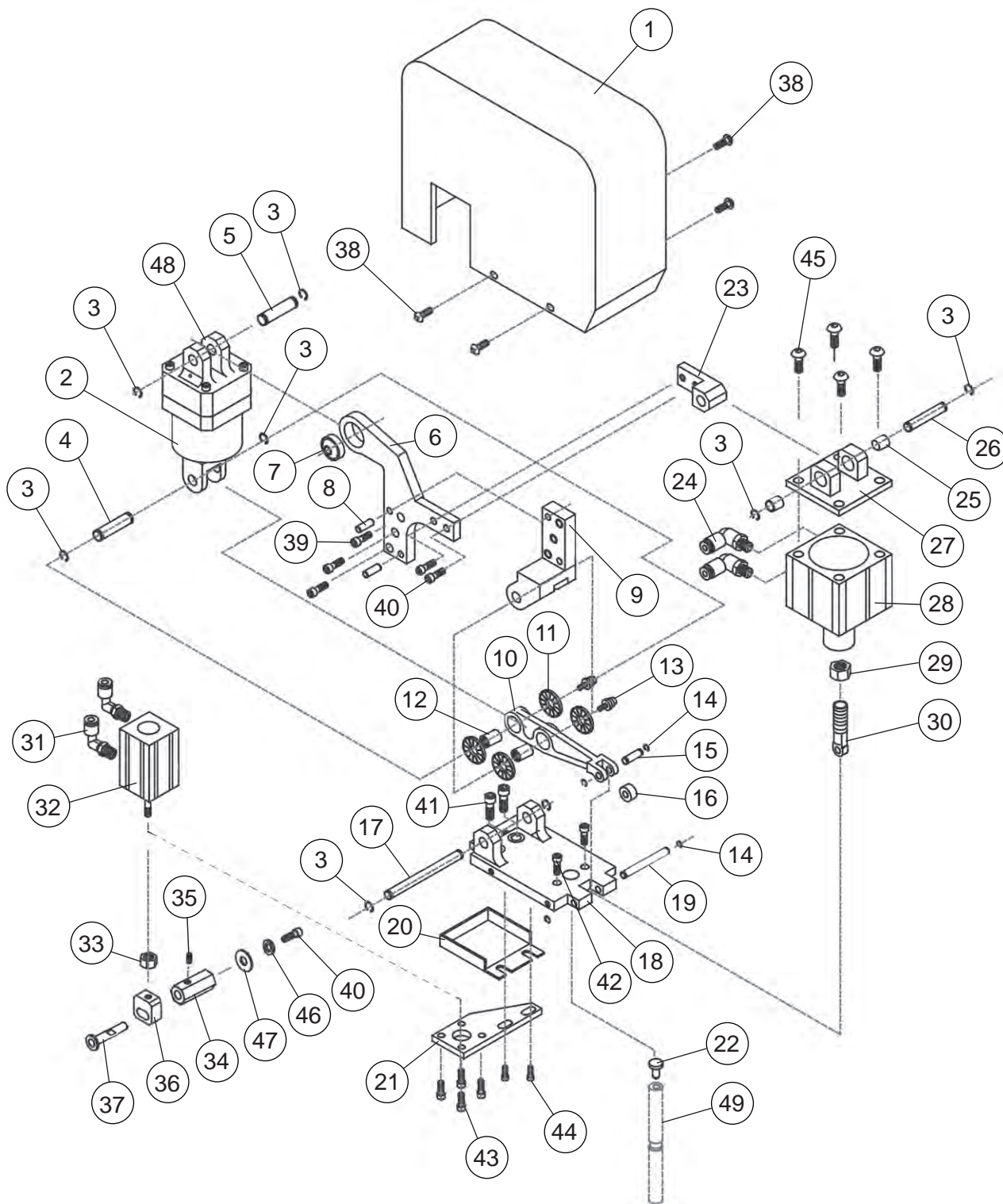


NEW STYLE -  
PRESSER FOOT ARM & WIDE EXTENSION ASSEMBLED

\*SEE MOD KIT (6Z9628) FOR FIELD UPGRADE INFORMATION

**Presser Foot Arm  
and Extension**

<b>Item</b>	<b>Qty</b>	<b>Assy</b>	<b>Description</b>	<b>Part Number</b>
**1	1		ARM, PRESSER FOOT	6Z4052
2	1		EXTENSION, PRESSER FOOT	6Z5284
3	1		BHCS, TORX, #10-32 x 1/2	6Z5271
4	1		SHCS, #8-32 x 3/8	6Z3530
5	1		WIDE EXTENSION, PRESSER FOOT	6Z9168
6	1		PIN, LIFTER, WIDE EXTENSION	6Z9169
7	1		T-HANDLE TORX KEY, T25 (NOT SHOWN)	6Z4054



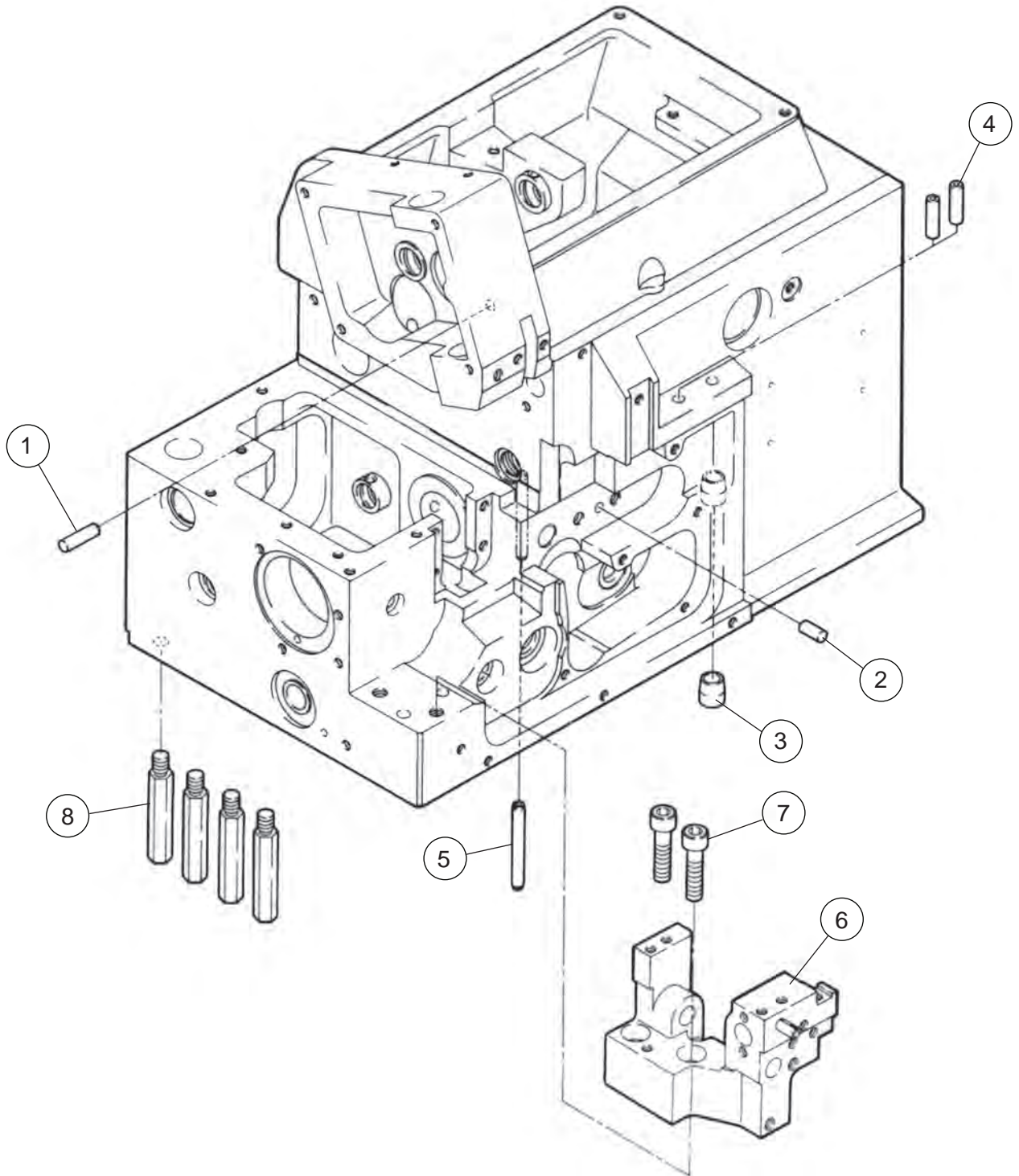
Item	Qty	Assy	Description	Part Number
1	1		COVER ASSEMBLY, SPRING HOUSING	6Z8370
2	1		SPRING ASSEMBLY UNIT	6Z8208
3	8		E-RING, 5/16 SHAFT	6Z8232
4	1		CLEVIS PIN, TOGGLE	6Z8228
5	1		CLEVIS PIN, SPRING UNIT	6Z8231
6	1		PLATE, BRACKET EXTENSION	6Z8223
7	1		BEARING, BALL JOINT	6Z8233
8	2		PIN, GROOVE	6Z6533
9	1		BRACKET, PIVOT SPRING UNIT	6Z8220
10	1		LINK, SPRING TOGGLE	6Z8221
11	4		BEARING, THRUST	6Z8234
12	2		BEARING, NEEDLE	6Z8239
13	2		FITTING, GREASE	6Z8235
14	4		E-RING, 3/16 SHAFT	6Z8236
15	1		CLEVIS PIN, LINK ROLLER	6Z8215
16	1		BLOCK, LINK TOGGLE	6ZB603
17	1		CLEVIS PIN, LINK PIVOT	6Z8219
18	1		BRACKET, BASE SPRING PIVOT	6Z8222
19	1		CLEVIS PIN, ROD MOUNT	6Z8227
20	1		CATCH PAN	6Z8362
21	1		PLATE, CYL MOUNT	6Z8225
22	1		BUTTON, PRESSER BAR CAP	6Z8211
23	1		BRACKET, CYL MOUNT	6Z8212
24	2		FITTING, AIR, 90° ELBOW, 1/8NPT x 5/32 TUBE	KQL03-34S
25	2		BUSHING, SINTERED BRONZE	4019015
26	1		CLEVIS PIN, CYL MOUNT	6Z8226
27	1		DOUBLE CLEVIS, CYL	6Z8218
28	1		AIR CYL 40B, 15S	6Z8237
29	1		NUT, JAM, HEX, 3/8-24	90567A031
30	1		ROD END, SPRING TILT CYL	6Z8214
31	2		FITTING, AIR, 90° ELBOW, #10-32 x 5/32	6Z0173
32	1		AIR CYL, FOOT LIFT	6Z8416
33	1		NUT, JAM, 5/16-24UNF	JN5/16-24
34	1		STANDOFF EXTENSION MOUNT	6Z8224
35	1		SET SCREW, #8-32 x 1/8	6Z2794
36	1		ROD END, CYL ROD	6Z8213
37	1		PIN, LIFTER	6Z4049
38	4		BHCS, #8-32 x 3/8	6Z0489
39	3		SHCS, 1/4-20 x 3/4	6Z2780

continued on next page ⇨

Item	Qty	Assy	Description	Part Number
40	3		SHCS, #10-32 x 1/2	6Z2762
41	2		SHCS, 1/4-20 x 3/8	6Z2751
42	2		SHCS, #10-32 x 5/8	6Z2755
43	4		SHCS, #8-32 x 1/2	6Z2782
44	2		SHCS, #10-32 x 3/8	6Z0478
45	4		BHCS, 1/4-20 x 1/2	6Z2826
46	1		WASHER, LOCK, SPLIT #10	6Z0994
47	1		WASHER, FLAT, #10	6Z8252
48	1		HSG, SPRING CAP	6Z8252
49	1		LWR PRESSURE BAR	801257

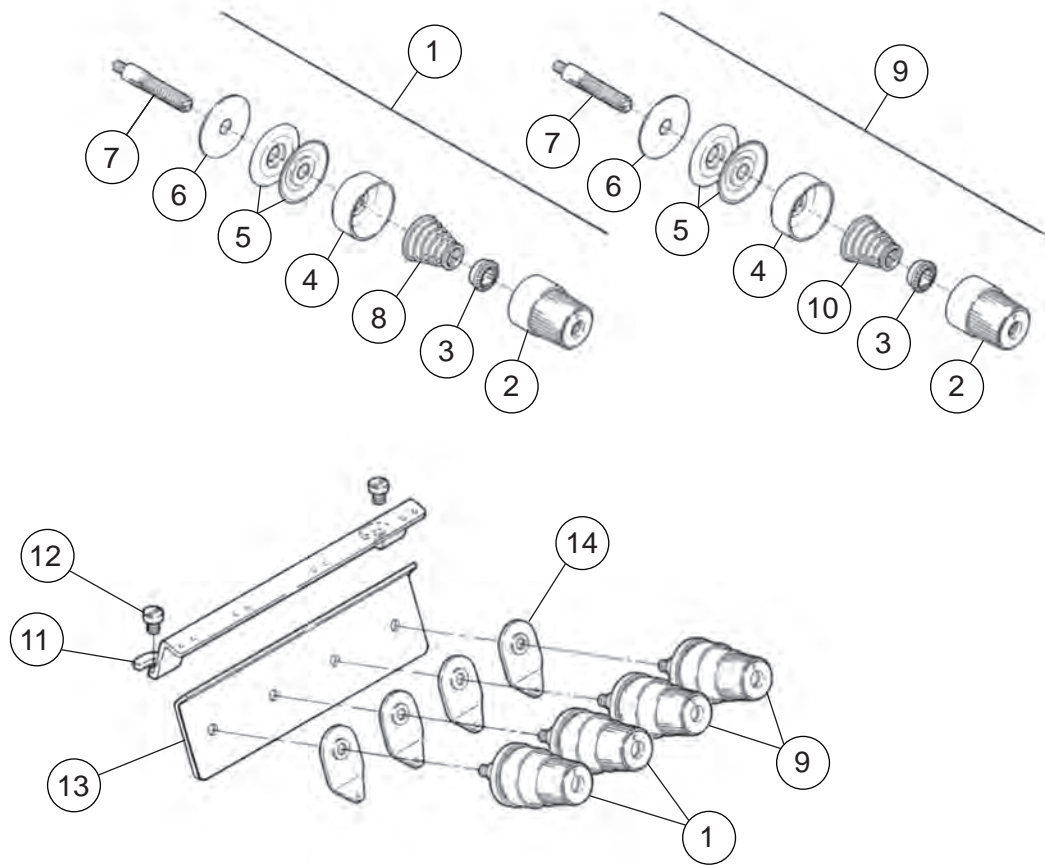


# Machine Bed Frame

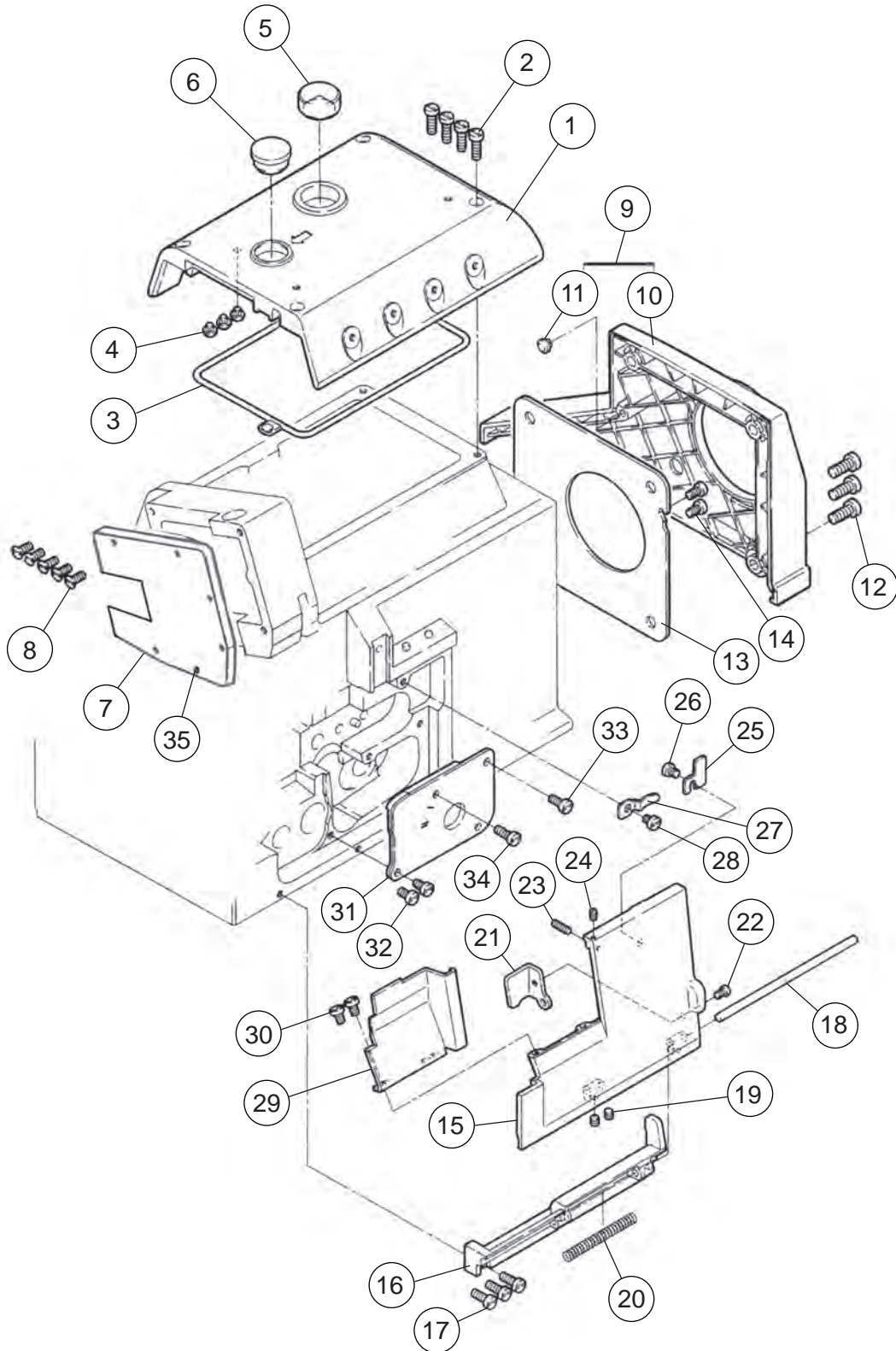


<b>Item</b>	<b>Qty</b>	<b>Assy</b>	<b>Description</b>	<b>Part Number</b>
1	1		ROD	6Z1925
2	1		PIN	660274
3	1		GUIDE, OILER FLOAT	6Z4195
4	2		PIPE	6Z9335
5	1		PLUG	660276
6	1		NEEDLE PLATE/ KNIFE SUPPORT	6Z3653
7	2		SCREW	6Z3643
8	4		BED PIN	6Z0041

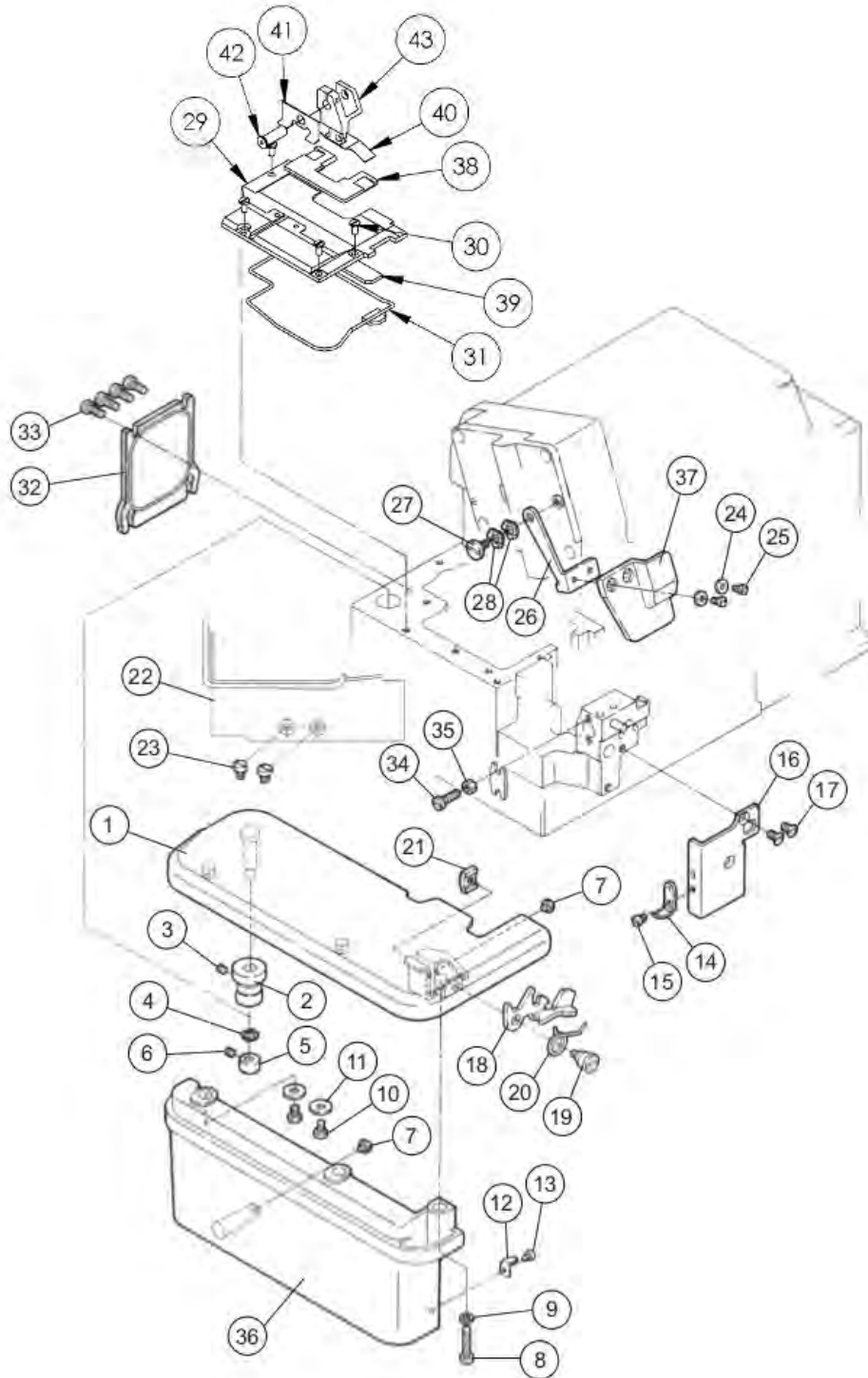
**Thread Tension  
Mechanism**



<b>Item</b>	<b>Qty</b>	<b>Assy</b>	<b>Description</b>	<b>Part Number</b>
1	1		THREAD TENSION, COMPLETE	6Z5675
2	1		POST NUT	6Z1824
3	1		SPRING BUSHING	6Z2870
4	1		CUP	6Z2871
5	2		TENSION DISC	730061
6	1		FELT	6Z0709
7	1		SCREW STUD	6Z1998
8	1		SPRING, HEAVY	6Z1161
9	1		THREAD TENSION, COMPLETE	6Z7874
10	1		SPRING, MEDIUM	6Z1568
11	1		THREAD EYELET	730058
12	1		SCREW	660082
13	1		THREAD EYELET	730059
14	1		TENSION GUIDE	6Z3036

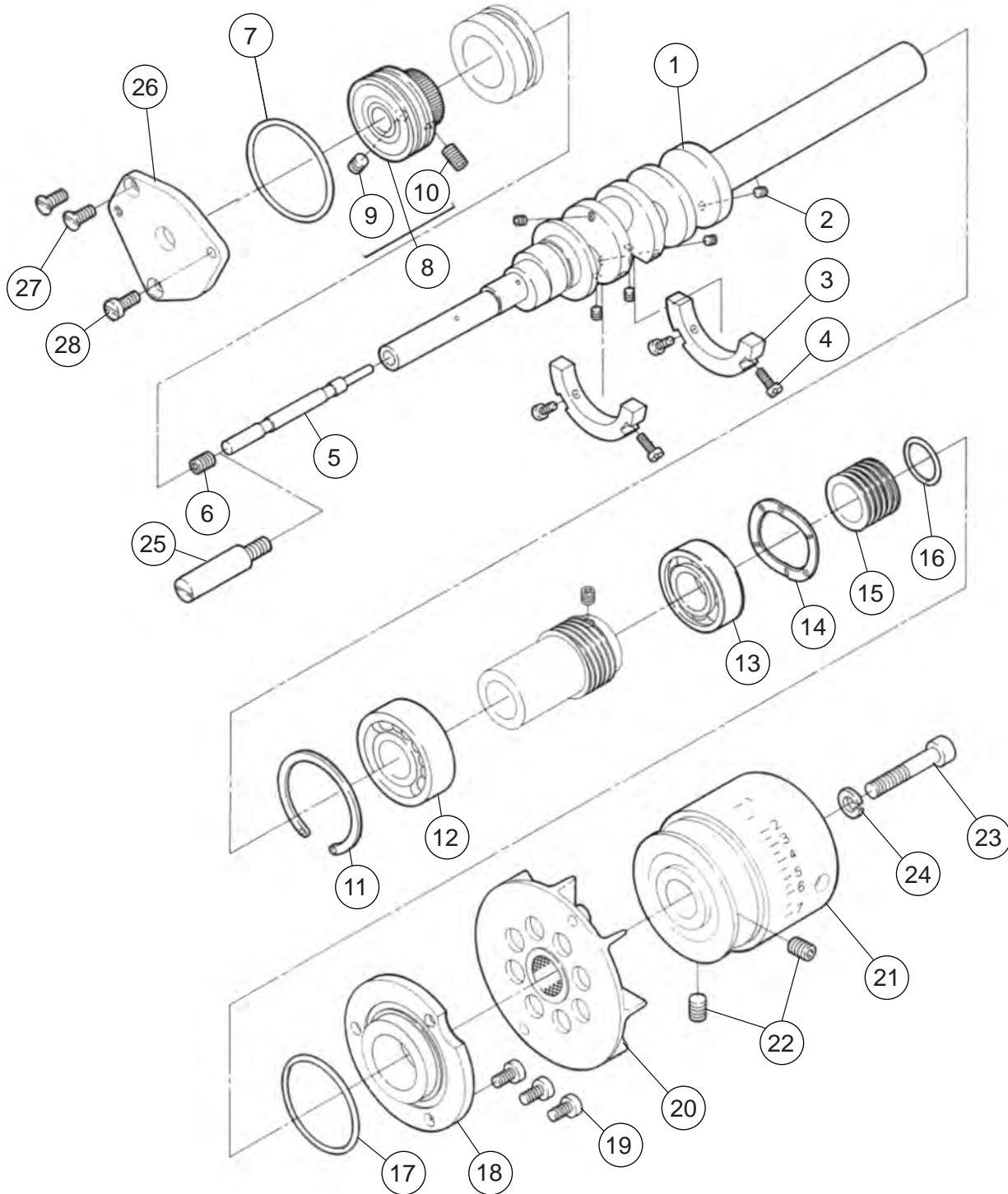


Item	Qty	Assy	Description	Part Number
1	1		TOP COVER	730000
2	4		SCREW	6Z3640
3	1		GASKET	6Z0038
4	3		CUSHION RUBBER	730030
5	1		OIL SIGHT WINDOW	6ZD168
6	1		PLUG	730031
7	1		COVER, NEEDLE DRIVE	802683
8	5		BHCS, #8-32 x 1/2	BHCS8-32X1/2
9	1		BELT COVER ASSEMBLY	730003
10	1		BELT COVER	730004
11	1		CUSHION RUBBER	730030
12	3		SCREW	6Z3749
13	1		FAN COVER	730005
14	2		SCREW	6Z0024
15	1		FRONT COVER	6Z6559
16	1		HINGE	6Z6560
17	3		SCREW	6Z3639
18	1		PIN	730032
19	2		SCREW	6Z2576
20	1		SPRING	6Z2912
21	1		LATCH	6Z8105
22	1		SCREW	6Z8057
23	1		SCREW	6Z8152
24	1		SCREW	6Z6203
25	1		LATCH	6Z8106
26	1		SCREW	6Z0015
27	1		FLAT SPRING	6Z5686
28	1		SCREW	6Z0015
29	1		FRONT COVER, LEFT	6Z3710
30	2		SCREW	660082
31	1		COVER	6Z5409
32	2		SCREW	6Z0024
33	1		SCREW	6Z8095
34	1		SCREW	6Z3639
35	1		SCREW	6Z0482

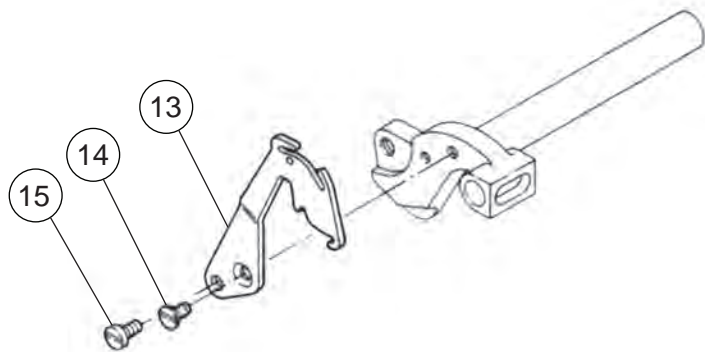
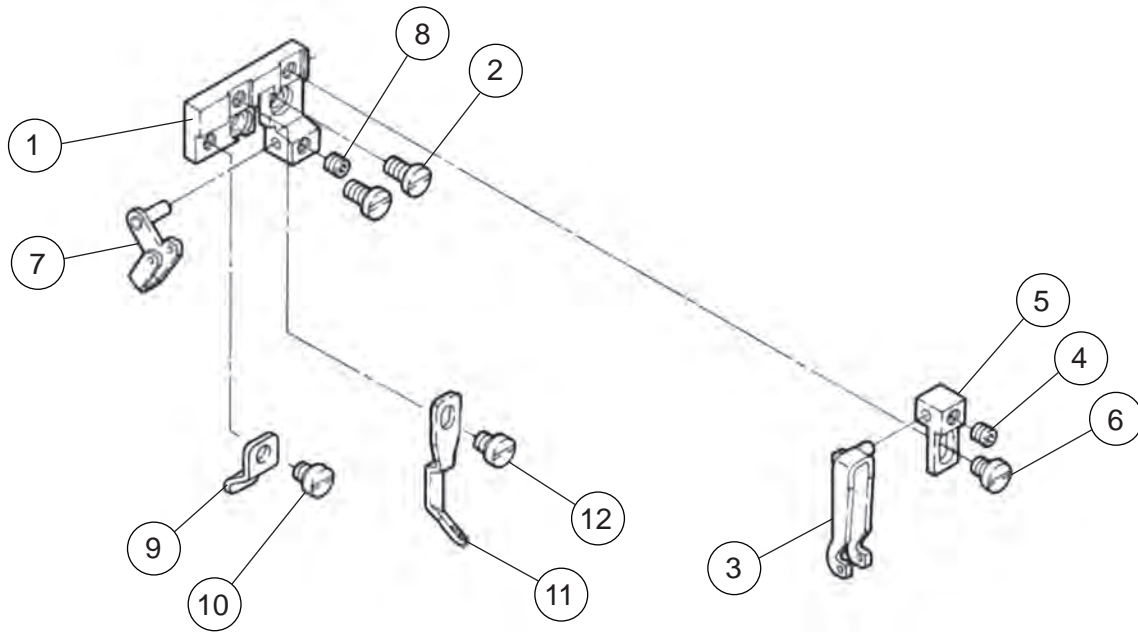


Item	Qty	Assy	Description	Part Number
1	1		CLOTH PLATE	801546
2	1		BUSHING	730012
3	1		SCREW	6Z2576
4	1		WASHER	730051
5	1		COLLAR	6Z2113
6	1		SCREW	6Z2576
7	1		CUSHION, RUBBER	730030
8	1		SCREW	660084
9	1		SPRING WASHER	640005
10	1		SCREW	660082
11	2		WASHER	730036
12	1		LATCH	6Z6893
13	1		SCREW	6Z0376
14	1		LATCH	730014
15	1		SCREW	660086
16	1		PLATE	6Z3768
17	1		SCREW	6Z3769
18	2		LEVER	730015
19	1		SCREW	660090
20	1		SPRING	6Z0040
21	1		BRACKET, LOCKING, CVR. PLATE	730017
22	1		COVER, LINKAGE TUBE ASSEMBLY	6Z7126
23	1		BHCS, M4 x 12	BHCSM4X12
24	2		WASHER	6Z0215
25	2		SCREW	6Z0393
26	2		BRACKET	6Z3686
27	1		SCREW	6Z5719
28	2		SPEING WASHER	730051
29	1		CHAMBER COVER	802687
30	4		SCREW, CHAMBER COVER	6Z3641
31	1		GASKET	6Z1077
32	1		PLATE	6Z8558
33	4		SCREW	6Z8095
34	1		SCREW	6Z0023
35	1		NUT	0048210
37	1		EYE GUARD	6Z3687
38	1		SEAL, TOP FEED	6ZB604
39	1		SEAL	802696
40	1		SPRING, TOP FEED SEAL, OUTER	6ZB605
41	1		SPRING, TOP FEED SEAL, UPPER	6ZB606
42	1		TOP FEED PIN	6Z5310
43	1		TOP FEED	6Z5855

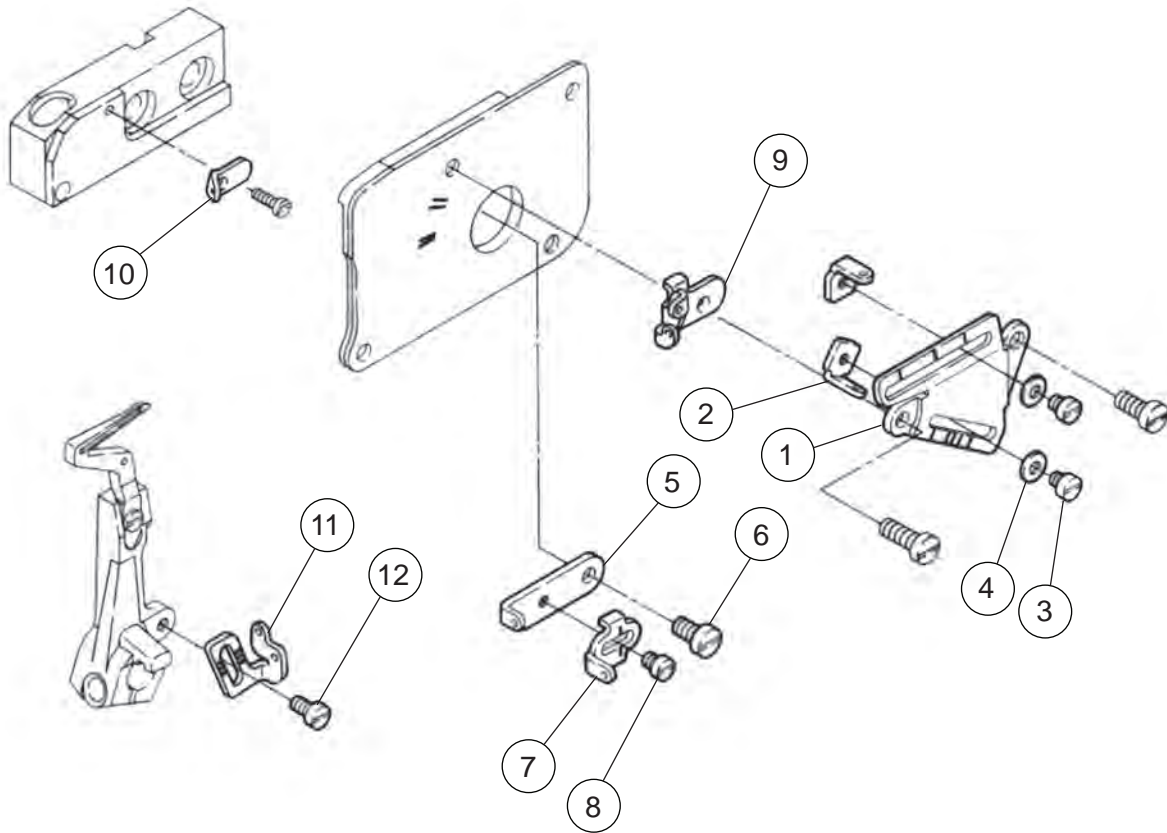
**Crankshaft Drive  
Mechanism**



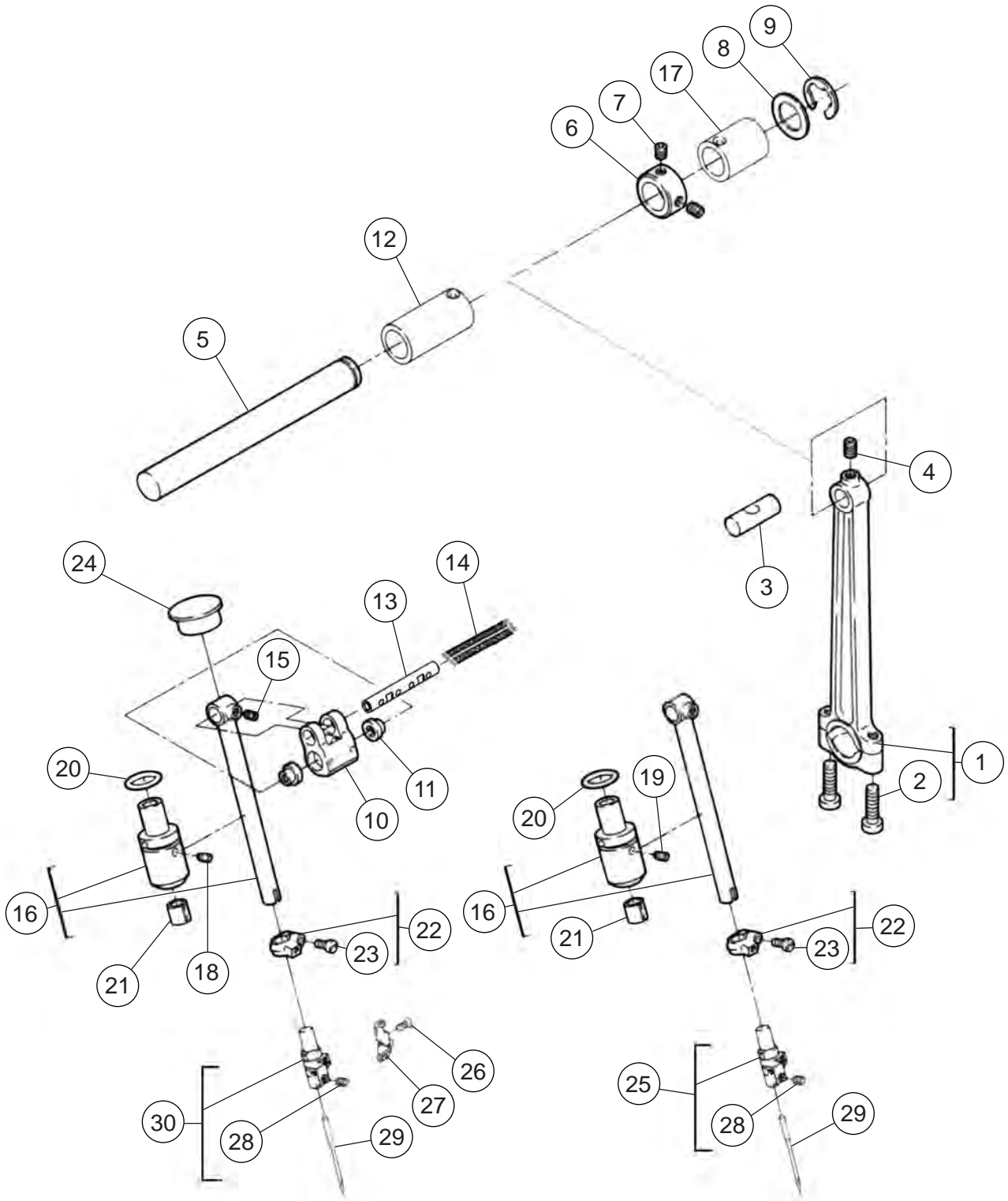
<b>Item</b>	<b>Qty</b>	<b>Assy</b>	<b>Description</b>	<b>Part Number</b>
1	1		CRANKSHAFT	6Z6938
2	5		SCREW	660092
3	2		BALANCE WEIGHT	730028
4	4		SCREW	660093
5	1		PIN	6ZC267
6	1		SCREW	6Z0025
7	1		O-RING	6Z6194
8	1		BALL BEARING, COMPLETE	6Z6691
9	2		SCREW	6Z8589
10	1		SCREW	6Z3753
11	1		RING	730040
12	1		BALL BEARING	6Z8132
13	1		BALL BEARING	6Z4168
14	1		WASHER	6ZA334
15	1		OIL SEAL	6Z4167
16	1		O-RING	6Z4166
17	1		O-RING	6Z6194
18	1		BALL BEARING RETAINER	6Z9376
19	3		SCREW	6Z8095
20	1		FAN, COMPLETE	6Z8550
21	1		MACHINE PULLEY	6Z7740
22	2		SCREW	6Z0025
23	1		BOLT	660097
24	1		SPRING WASHER	6Z0551
25	1		PIN	730044
26	1		COVER	730054
27	2		SCREW	6Z3748
28	1		SCREW	6Z8095



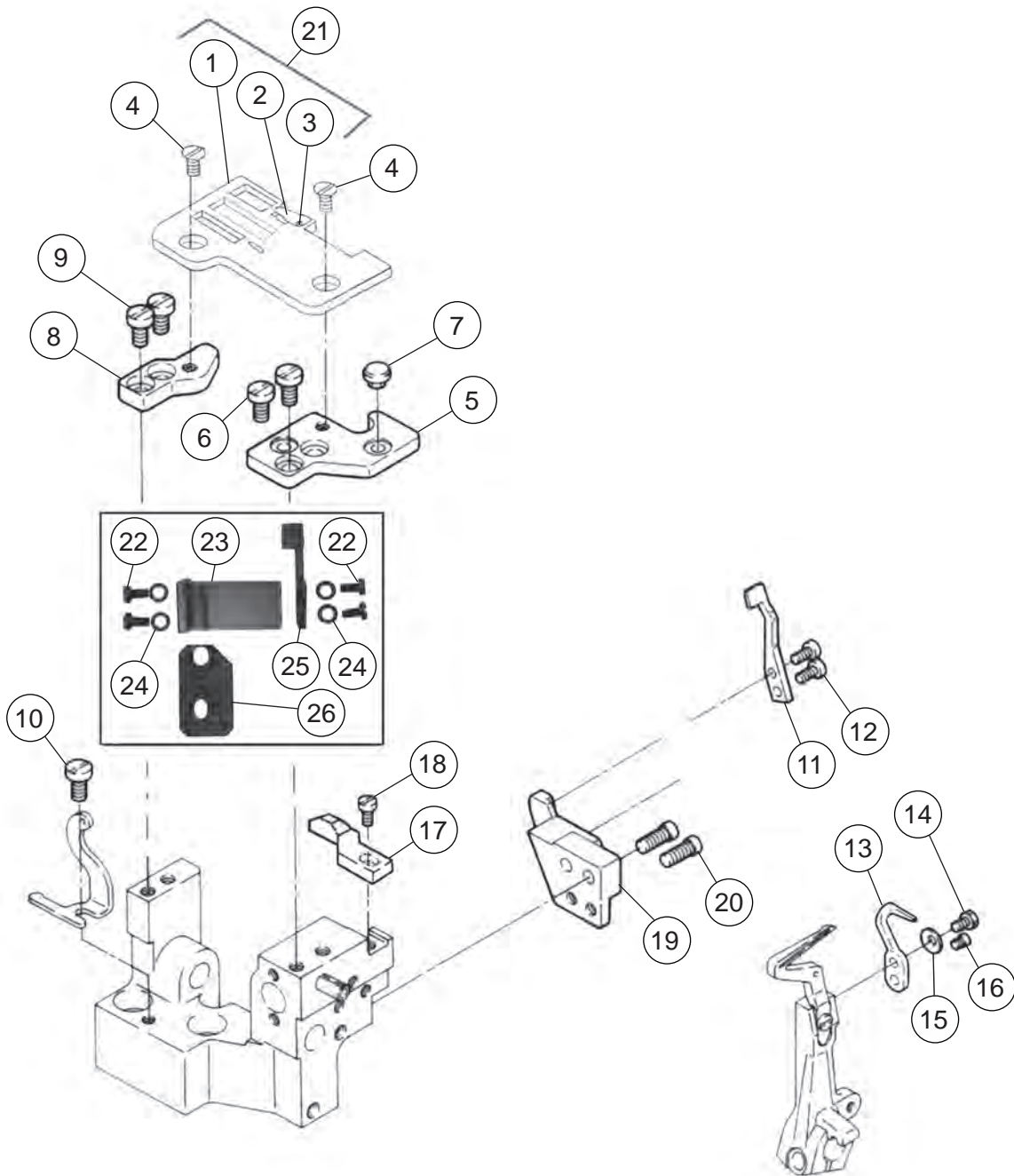
Item	Qty	Assy	Description	Part Number
1	1		BRACKET	6Z3690
2	2		SCREW	6Z0614
3	1		THREAD GUIDE	6Z3651
4	1		SCREW	6Z2576
5	1		BRACKET	6Z0055
6	1		SCREW	6Z0015
7	1		THREAD GUIDE	730066
8	1		SCREW	6Z2576
9	1		THREAD EYELET	6Z0056
10	1		SCREW	6Z0015
11	1		THREAD EYELET	6Z3652
12	1		SCREW	6Z0015
13	1		THREAD TAKE-UP	6Z3543
14	1		SCREW	6Z0433
15	1		SCREW	6Z0393



Item	Qty	Assy	Description	Part Number
1	1		BRACKET	6ZD427
2	2		THREAD GUIDE, RIGHT	6Z9336
3	2		SCREW	6Z0376
4	2		WASHER	6Z0215
5	1		THREAD TAKE-UP	6Z5514
6	1		SCREW	6Z0024
7	1		THREAD EYELET	6Z5664
8	1		SCREW	6Z0376
9	1		THREAD EYELET	6Z8019
10	1		THREAD EYELET	6Z9337
11	1		THREAD TAKE-UP	730078
12	1		SCREW	6Z8151



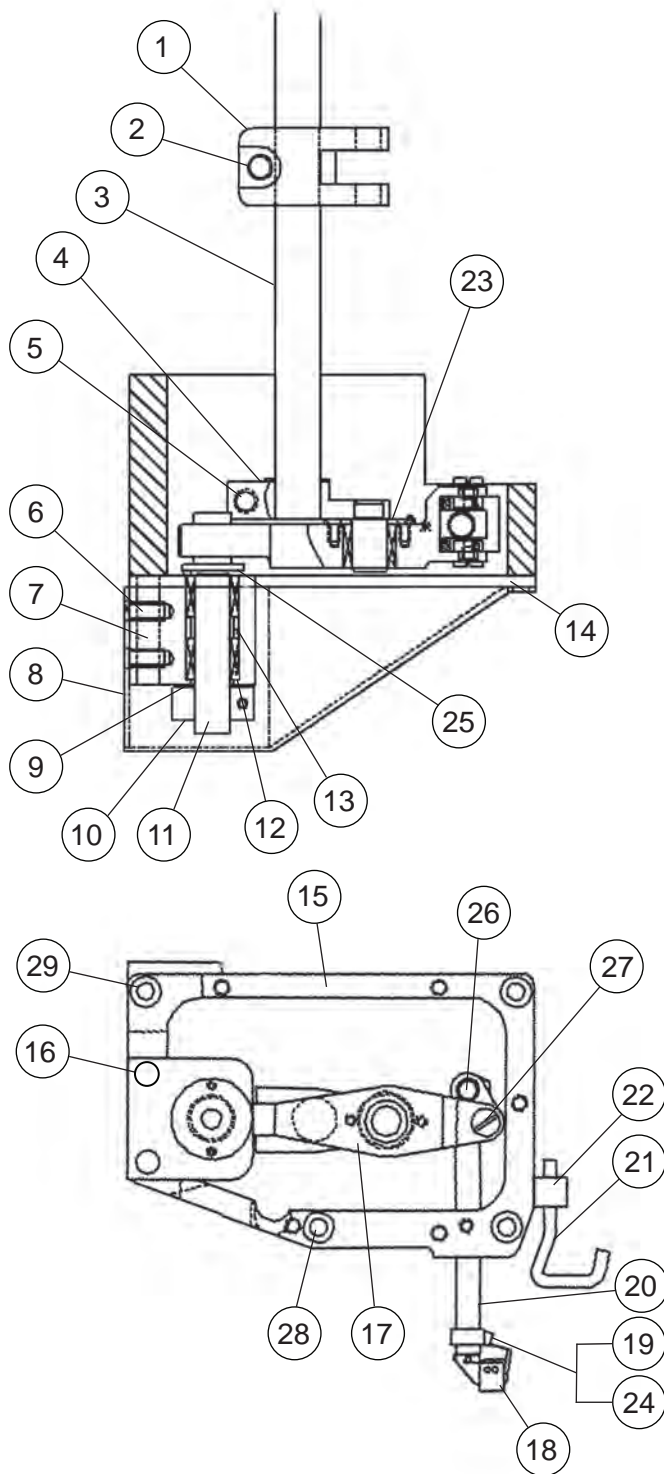
Item	Qty	Assy	Description	Part Number
1	1		CONNECTION	6Z2163
2	2		SCREW	6Z0023
3	1		PIN	6Z0042
4	1		SCREW	6Z0027
5	1		SHAFT, NEEDLE DRIVE	802685
6	1		COLLAR	730081
7	2		SCREW	6Z2576
8	1		WASHER	615390
9	1		RING	6Z4108
10	1		LINK	6Z1306
11	2		PIN	6Z5398
12	1		COLLAR	6ZC380
13	1		PIN	801445
14	2		OIL WICK	
15	1		SCREW	6Z2494
16	1		BUSHING ASSEMBLY	6Z3556
17	1		COLLAR	6ZC379
18	1		SET SCREW, #6-32 x 1/8, CUP POINT	6Z2791
19	1		SCREW	4546PEG
20	1		O-RING	6Z0061
21	1		OIL FELT	6Z0052
22	1		RING	6Z0565
23	1		SCREW	660063
24	1		PLUG	240310
25	1		NEEDLE HOLDER ASSEMBLY	6Z1725
26	2		SCREW	6Z0031
27	2		THREAD GUIDE	6Z3650
28	4		SET SCREW, #5-44 x 1/8	6Z2547
29	2		NEEDLE, #24, 135 x 7	6Z7027
30	1		NEEDLE HOLDER ASSEMBLY	6Z4046
31	1		NEEDLE SET SCREW WRENCH WITH YELLOW PLASTIC HANDLE (NOT SHOWN)	6Z0185



Item	Qty	Assy	Description	Part Number
1	1		THROAT PLATE	6Z6372
2	1		CHAIN FINGER	6Z0526
3	1		SCREW, CHAIN FINGER	6Z0947
4	2		SCREW	6Z1742
5	1		PLATE, FRONT ADAPTOR	6Z9574
6	2		SCREW	6Z0024
7	1		CUSHION RUBBER	730030
8	1		BRACKET, REAR	6Z9613
9	2		SCREW	6Z0024
10	1		SCREW	6Z0024
11	1		OVEREDGE NEEDLE GUARD, FRONT	6Z1048
12	2		SCREW	6Z0017
13	1		OVEREDGE NEEDLE GUARD, REAR	6Z2156
14	1		BOLT	6Z3595
15	1		SPRING WASHER	6Z2892
16	1		SCREW	6Z0022
17	1		*SAFETY STITCH NEEDLE GUARD, FRONT	6Z7345
18	1		SCREW	6Z2774
19	1		BRACKET	802848
20	2		SCREW	6Z3642
21	1		THROAT PLATE ASSEMBLY	6Z6373
22	4		SCREW, M3X6	6Z0017
23	1		BRACKET, REAR NEEDLE GUARD	6Z7340
24	4		WASHER, BELLEVILLE, #6	6Z4201
25	1		SAFETY STITCH NEEDLE GUARD, REAR	6Z7339
26	1		PLATE, REAR NEEDLE GUARD	6Z7341

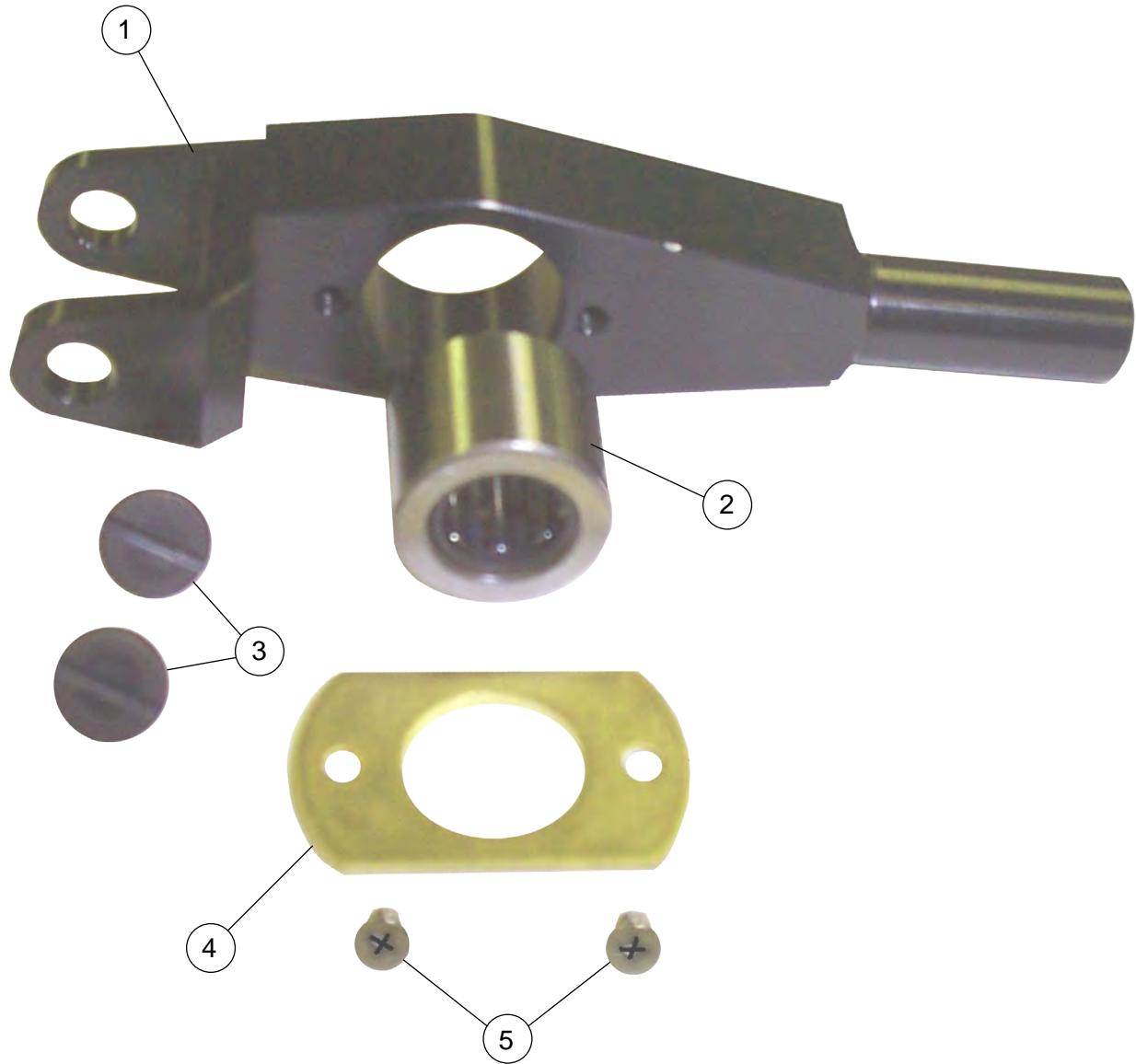
\*OPTION: SAFETY STITCH NEEDLE GUARD, FRONT WITH HOLE IN IT - 6Z1715

**Needle Drive  
Assembly**



## Needle Drive Assembly

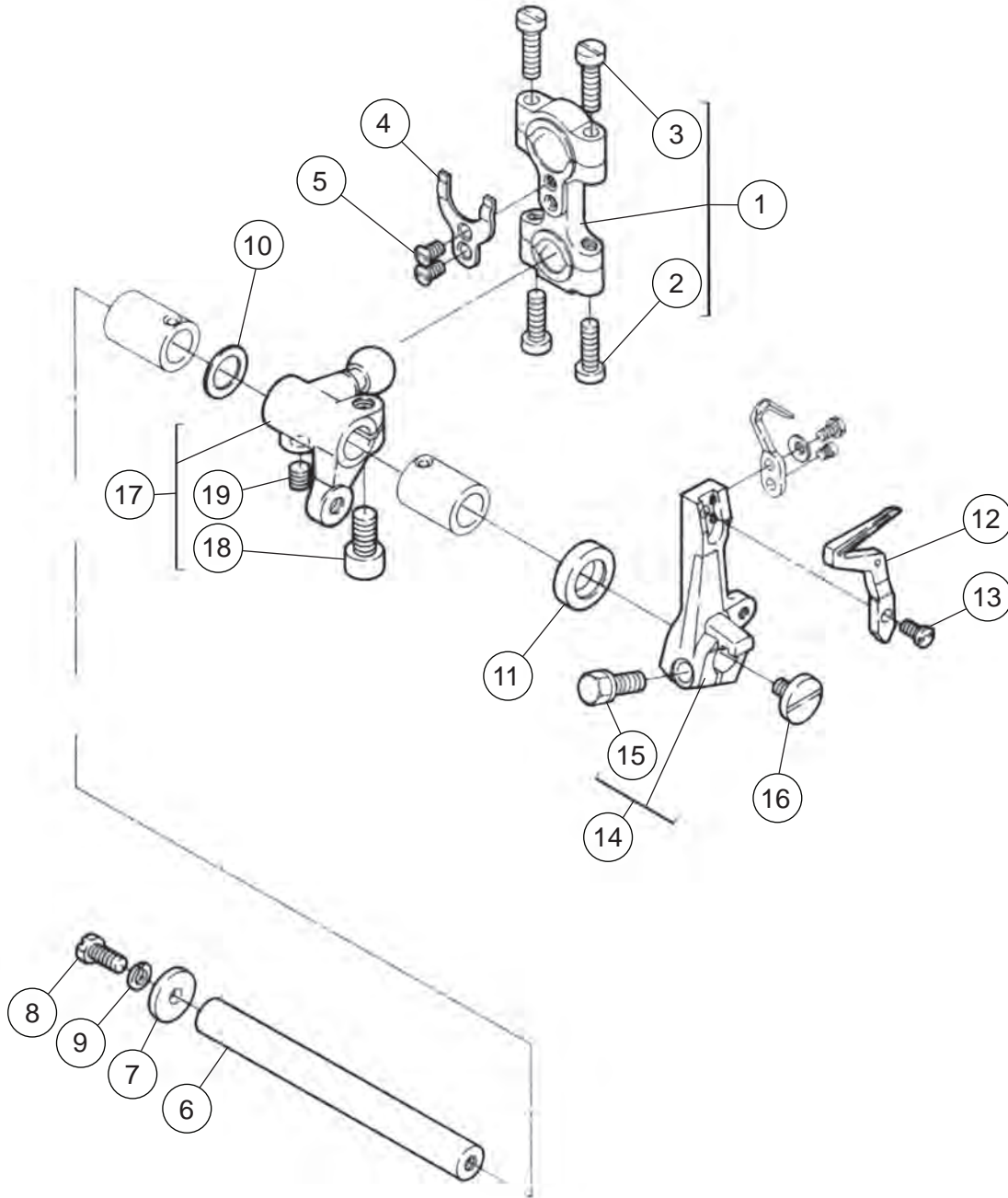
Item	Qty	Assy	Description	Part Number
1	1		CLEVIS, MAIN SHAFT	802599
2	1		SCREW	6Z2781
3	1		SHAFT, NEEDLE DRIVE	802685
4	1		ARM, NEEDLE DRIVER	802592
5	1		SCREW	6Z2780
6	2		SHCS, #8-32 x 3/8	6Z3530
7	1		MOUNT, BEARING	802594
8	1		GUARD, NEEDLE HOUSING	6Z5872
9	1		WASHER, LAMINIATED SHIM	6Z5273
10	1		COLLAR	402502
11	1		SHAFT, NEEDLE DRIVE PIVOT	802595
12	2		NEEDLE BEARING	4047009
13	1		SPACER, NEEDLE BEARING	802596
14	1		HOUSING COVER	802683
15	1		HOUSING, NEEDLE DRIVE	801276
16	2		SHCS, 1/4-20 x 1-1/2	SHCS1/4-20X1-1/2
17	1		DRIVER, BRG ASSY, NEEDLE BAR	6Z7474
18	1		HOLDER, LEFT HAND NEEDLE	6Z4046
19	1		RING	6Z0565
20	1		NEEDLE BAR	6Z3556
21	1		GUARD, THREAD	802827
22	1		BRACKET, EYELET	802828
23	1		SPACER, SHAFT	802597
24	1		SCREW	660063
25	1		WASHER	6Z5273
26	1		PIN, NEEDLE BAR TOP CONNECTOR	801445
27	1		NUT, FOR 7185 PEG	6Z5398
28	2		SHCS, M4 x 55	SHCSM4X55
29	2		SHCS, M4 x 25	HCSM4X25



**6Z7474****Needle Bar Driver  
Bearing Assembly**

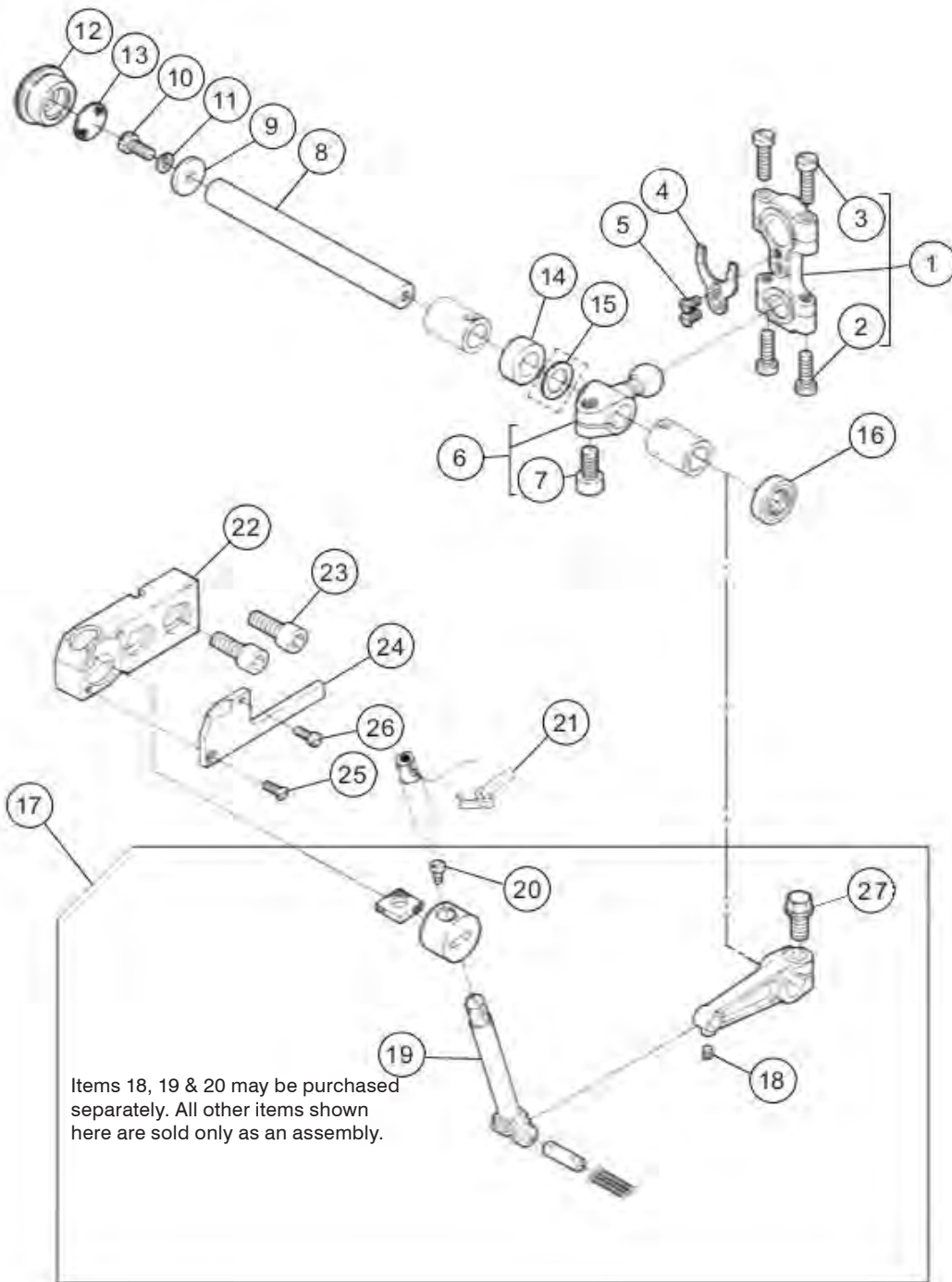
<b>Item</b>	<b>Qty</b>	<b>Assy</b>	<b>Description</b>	<b>Part Number</b>
1	1		DRIVER, NEEDLE BAR	802593
2	1		BEARING	6Z5921
3	2		SCREW	7185PEG
4	1		COVER, NEEDLE DRIVE BEARING	802597
5	2		FH2-56 x 1/8	6Z0947

**Lower Loper Drive  
Mechanism**



**Lower Looper Drive  
Mechanism**

<b>Item</b>	<b>Qty</b>	<b>Assy</b>	<b>Description</b>	<b>Part Number</b>
1	1		CONNECTION	6Z6726
2	2		SCREW	6Z0023
3	2		SCREW	6Z3640
4	1		GUIDE	6ZA340
5	2		SCREW	6Z0433
6	1		SHAFT	730087
7	1		WASHER	240388
8	1		SCREW	660114
9	1		SPRING WASHER	6Z3747
10	1		WASHER	6Z7721
11	1		OIL SEAL	6Z1852
12	1		LOWER LOOPER	6Z1532
13	1		SCREW	6Z1455
14	1		LOWER LOOPER HOLDER ASSEMBLY	6Z0014
15	1		SCREW	6Z0021
16	1		SCREW	660120
17	1		CRANK	6Z3691
18	1		SCREW	6Z0026
19	1		SCREW	6Z3753

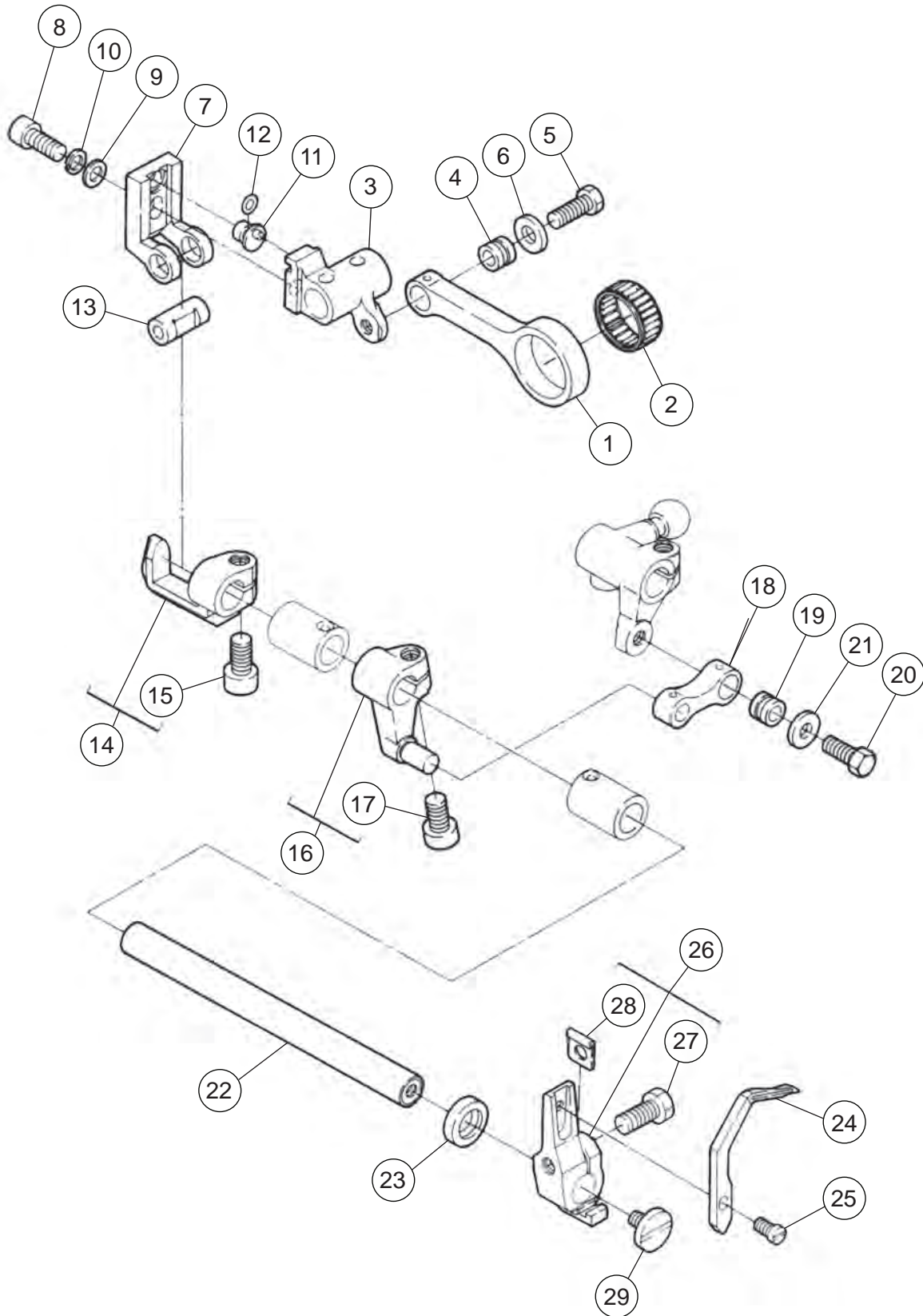


**Spreader Drive  
Mechanism**

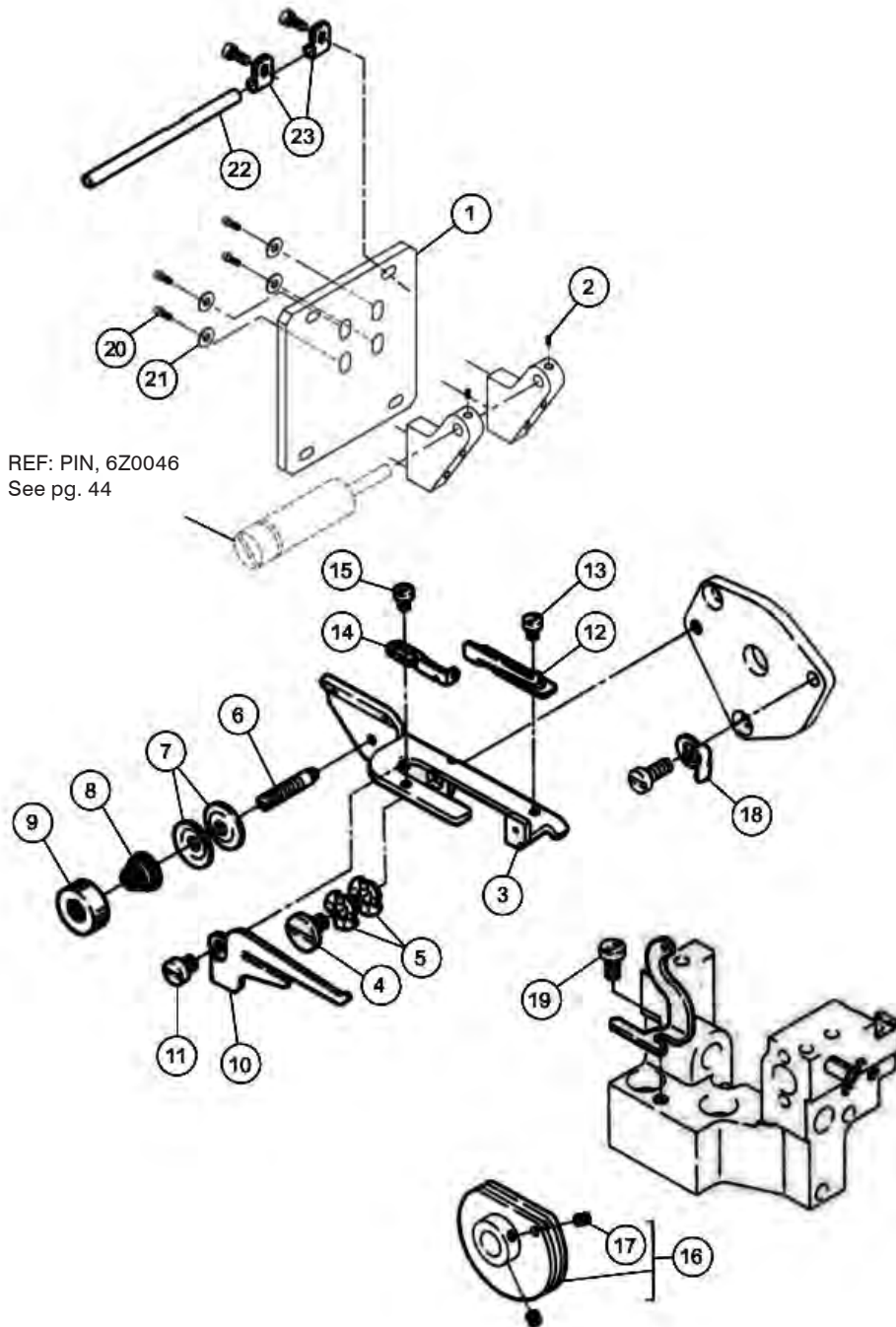
<b>Item</b>	<b>Qty</b>	<b>Assy</b>	<b>Description</b>	<b>Part Number</b>
1	1		CONNECTION ROD	6Z6726
2	2		SCREW	6Z0023
3	2		SCREW	6Z3640
4	1		GUIDE	6ZA340
5	2		SCREW	6Z0433
6	1		CRANK	6ZB803
7	1		SCREW	6Z0026
8	1		SHAFT	730087
9	1		WASHER	6Z8786
10	1		SCREW	660114
11	1		SRPING WASHER	6Z3747
12	1		PLUG	6Z8170
13	1		FILTER	6Z6195
14	1		SPACER, 5.61	6ZC875
15	1		WASHER	730122
16	1		OIL SEAL	6Z1852
17	1		SPREADER HOLDER ASSEMBLY, COMPLETE	802739
18	1		SCREW, M3 x 4	6Z2494
19	1		SPREADER HOLDER	6Z8944
20	1		SPREADER SCREW	6Z5270
21	1		SPREADER	6Z2869
22	1		BASE, SPREADER HOLDER	6Z6725
23	2		SHCS, M6 x 16	660116
24	1		COVER	730128
25	1		SCREW	6Z8076
26	1		SCREW	6Z0021
27	1		BOLT, LOOPER HOLDER LEVER	6Z0016

**Chain Stitch Looper  
Drive Mechanism**

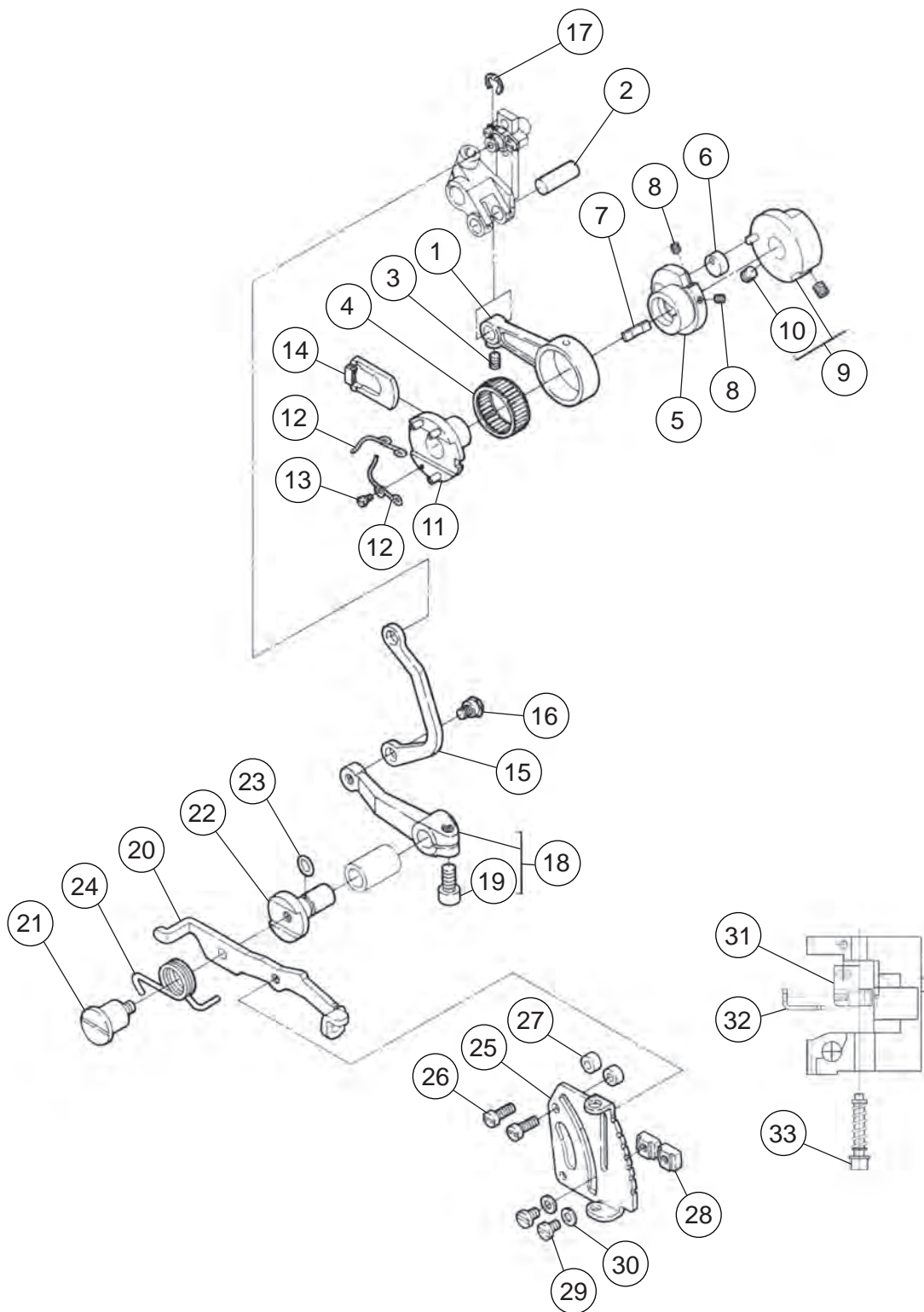
**View 1 of 2**



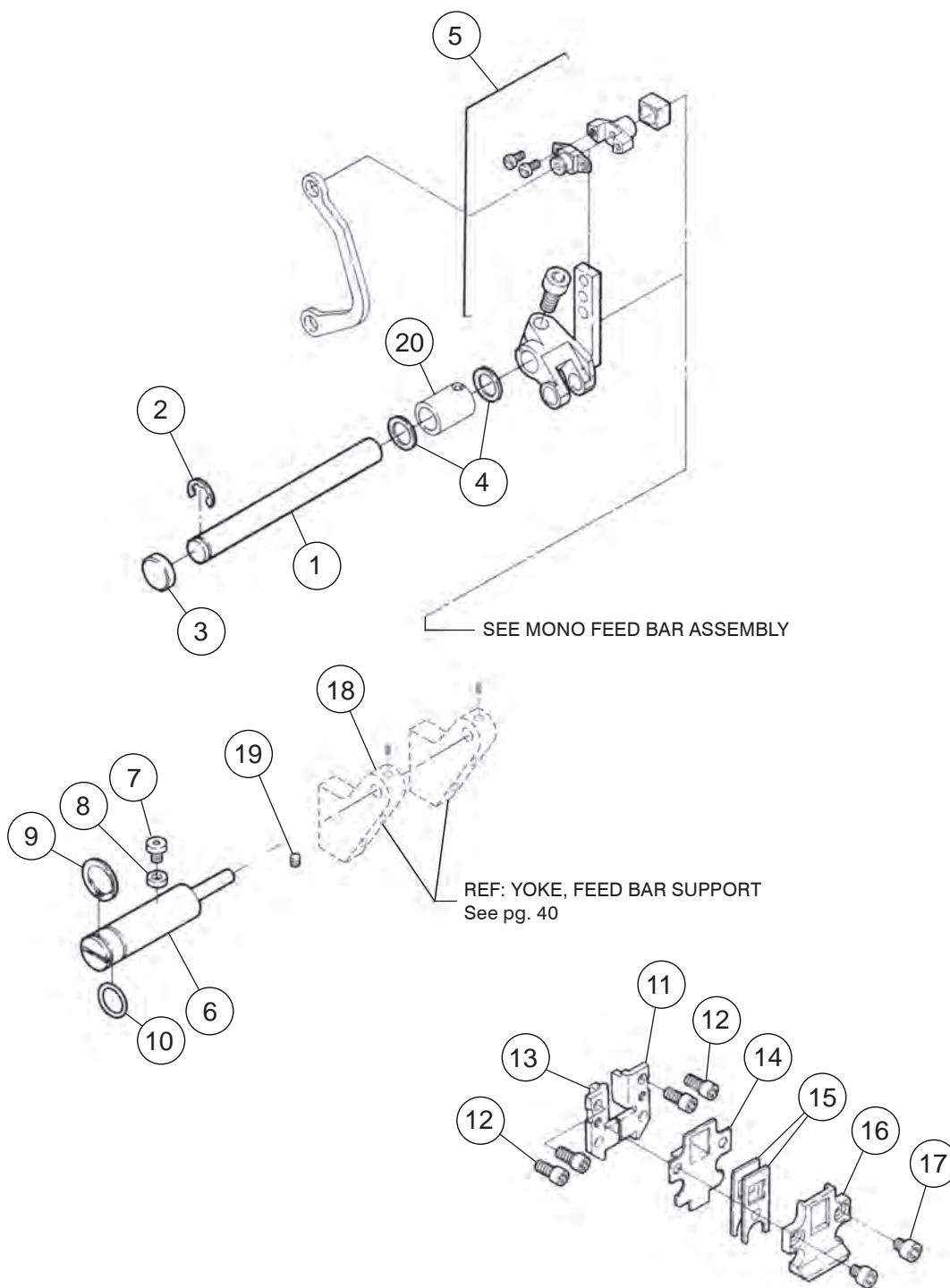
Item	Qty	Assy	Description	Part Number
1	1		CONNECTION	6Z8153
2	1		NEEDLE BEARING	6Z1678
3	1		CRANK	6ZA645
4	1		BUSHING	6Z7029
5	1		SCREW	660265
6	1		WASHER	6Z6762
7	1		SLIDER	6Z3615
8	1		BOLT	6Z0028
9	1		WASHER	6Z6715
10	1		SPRING WASHER	6Z3747
11	1		PIN	660159
12	1		O-RING	6ZA646
13	1		SHAFT	660194
14	1		HOLDER	6Z3621
15	1		SCREW	6Z0026
16	1		CRANK	6Z8120
17	1		SCREW	6Z0026
18	1		LINK	6Z7028
19	1		BUSHING	6Z7029
20	1		SCREW	660265
21	1		WASHER	6Z6762
22	1		SHAFT	660195
23	1		OIL SEAL	6Z1033
24	1		DOUBLE CHAIN STITCH LOOPER	6Z1444
25	1		SCREW	6Z1455
26	1		LOOPER HOLDER	6Z3647
27	1		SCREW	6Z0021
28	1		SPACER	6Z0035
29	1		SCREW	6Z0974



Item	Qty	Assy	Description	Part Number
1	1		PLATE, YOKE MOUNT	6Z8558
2	2		SCREW	6Z2576
3	1		BRACKET	6Z0053
4	1		SCREW	6Z5719
5	2		WASHER	730051
6	1		SCREW	6Z0020
7	2		TENSION DISC	6Z0039
8	1		SPRING	6Z0060
9	1		KNOB	6Z0054
10	1		THREAD GUIDE	6Z3594
11	1		SCREW	6Z0015
12	1		THREAD GUIDE	6Z0224
13	1		SCREW	6Z0376
14	1		THREAD GUIDE	6Z0207
15	1		SCREW	6Z0376
16	1		LOOPER THREAD TAKE-UP ASSEMBLY	6Z1880
17	2		SCREW	6Z2547
18	1		SPRING	6Z6739
19	1		THREAD GUIDE	6Z0178
20	4		SCREW, #10-32 x 5/8	6Z2751
21	4		WASHER, #10	P01-06-0003
22	1		THREAD GUIDE	6Z0317
23	2		HOLDER	660129

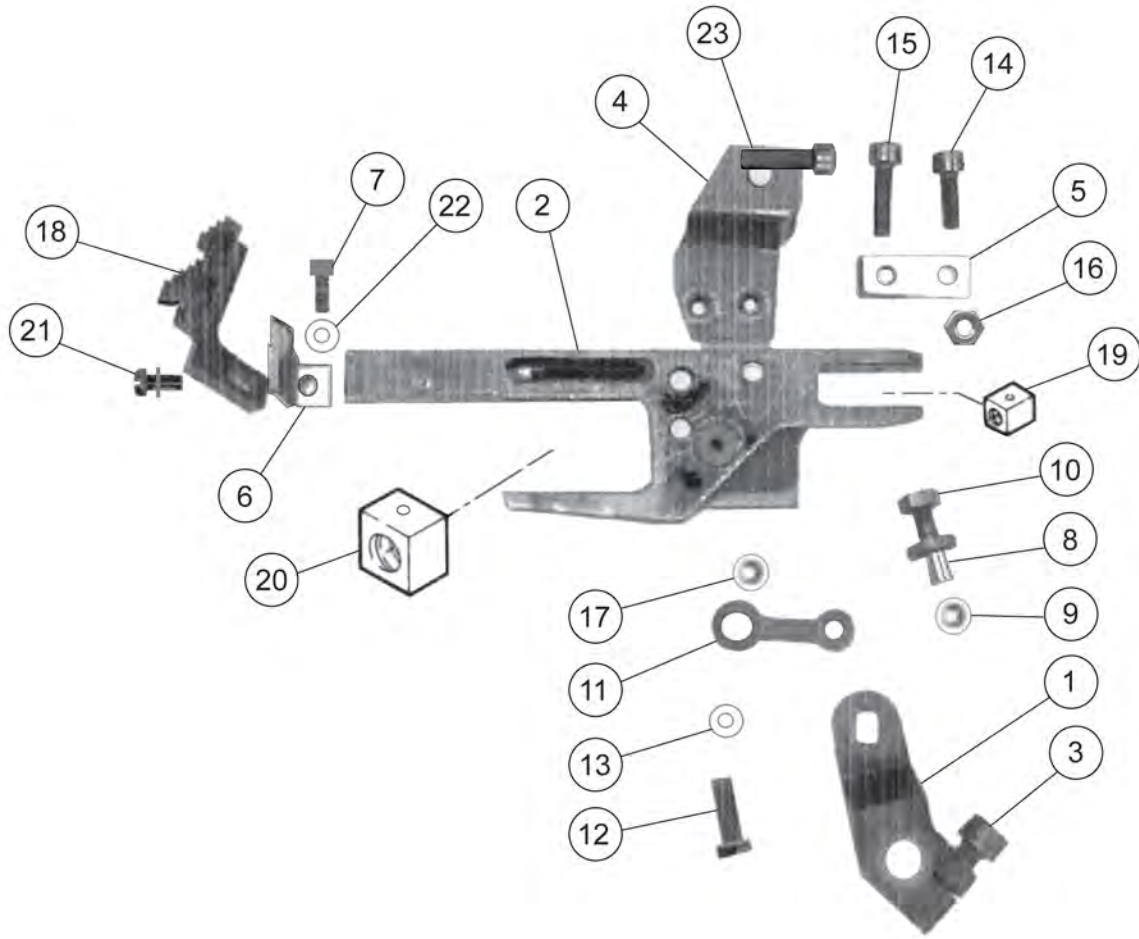


Item	Qty	Assy	Description	Part Number
1	1		CONNECTION	6Z6972
2	1		PIN	6Z0042
3	1		SCREW	6Z0027
4	1		NEEDLE BEARING	6Z7786
5	1		ECCENTRIC	6Z6199
6	1		GUIDE, FEED ECCENTRIC	6Z0905
7	1		FLAT SPRING	6Z0854
8	2		SCREW	6Z5614
9	1		REGULATOR	6Z6200
10	2		SCREW	6Z3753
11	1		ECCENTRIC ASSEMBLY, MOD, DUAL-SPRING	6Z8607
12	2		SPRING	6Z6173
13	1		SCREW	6Z6175
14	1		RATCHET	6Z6172
15	1		LINK	6Z4102
16	1		SCREW	6Z4807
17	1		RING	6Z2382
18	1		LEVER	6Z8107
19	1		SCREW	6Z0026
20	1		LEVER	660182
21	1		SCREW	6Z7785
22	1		SHAFT	6Z5598
23	1		O-RING	6Z1833
24	1		SPRING	660183
25	1		REGULATOR PLATE	660184
26	2		SCREW	6Z3639
27	2		SPACER	6Z5407
28	2		STOPPER	6Z5631
29	2		SCREW	6Z5908
30	2		WASHER	660227
31	1		FLANGE, STITCH REGULATOR	6Z5320
32	1		COVER, STITCH REGULATOR	6Z5321
33	1		PUSH BUTTON, STITCH REGULATOR	6Z5319



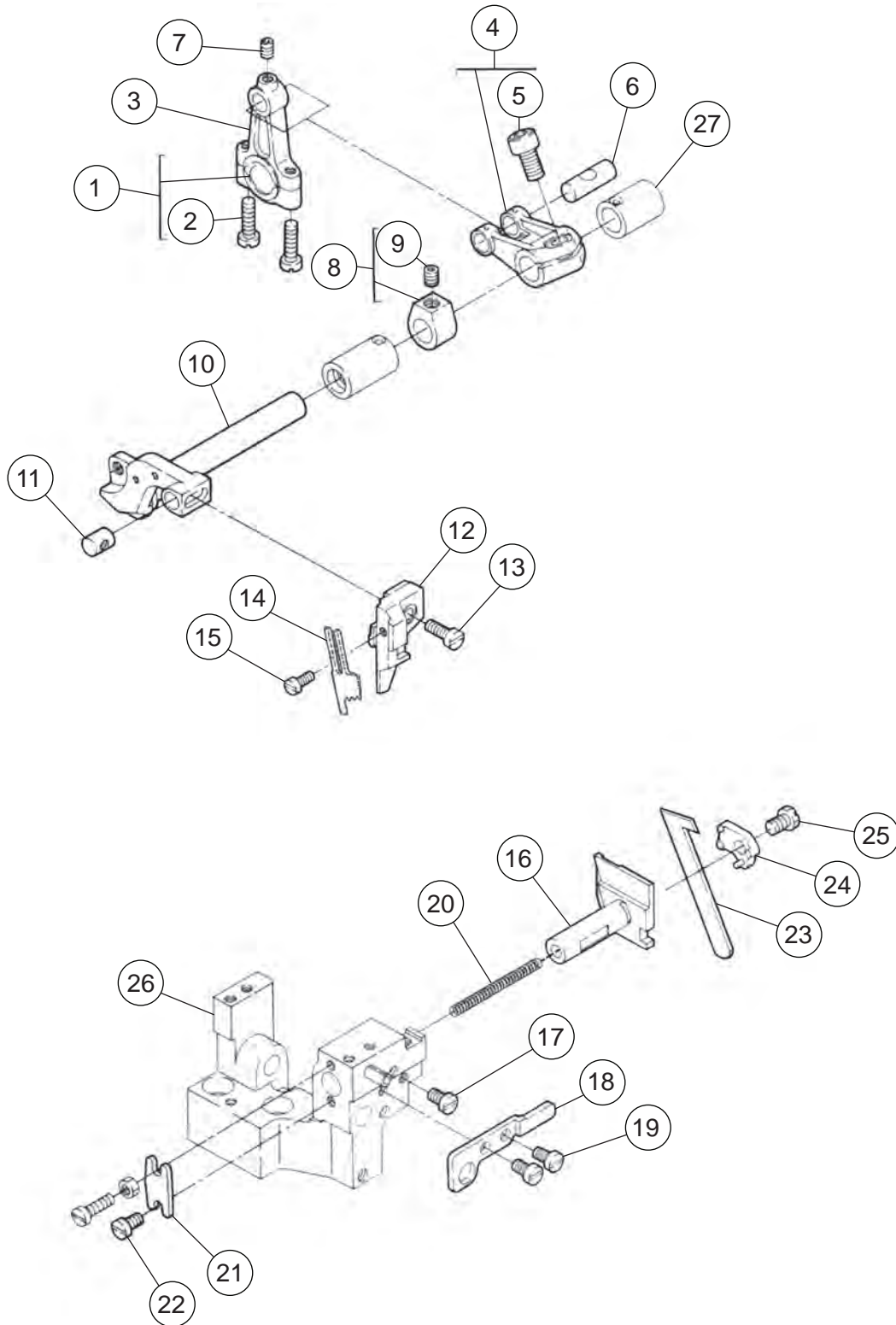
Item	Qty	Assy	Description	Part Number
1	1		SHAFT	6Z6807
2	1		RING	660128
3	1		PLUG	6Z1254
4	2		WASHER	6Z7721
5	1	<b>S</b>	CRANK ASSY/ MONO FEED BAR ASSY	6Z3646
6	1		PIN	6Z0046
7	1		SCREW	6Z0018
8	1		GASKET	6Z0032
9	1		RING	6Z0033
10	1		O-RING	6Z0061
11	1		GUIDE, FEED BAR	6Z3644
12	4		SCREW	6Z3649
13	1		GUIDE, FEED BAR, LEFT	6Z0074
14	1		GUIDE, FEED BAR OIL SEAL, REAR	6Z0045
15	2		OIL SEAL	6Z0043
16	1		GUIDE, FEED BAR OIL SEAL, EX	6Z4185
17	2		SCREW	6Z3648
18	2		YOKE, FEED BAR SUPPORT	6Z8557
19	2		SCREW	6Z2576
20	1		BSHG, BRASS	6Z9403

**Mono Feed Bar**



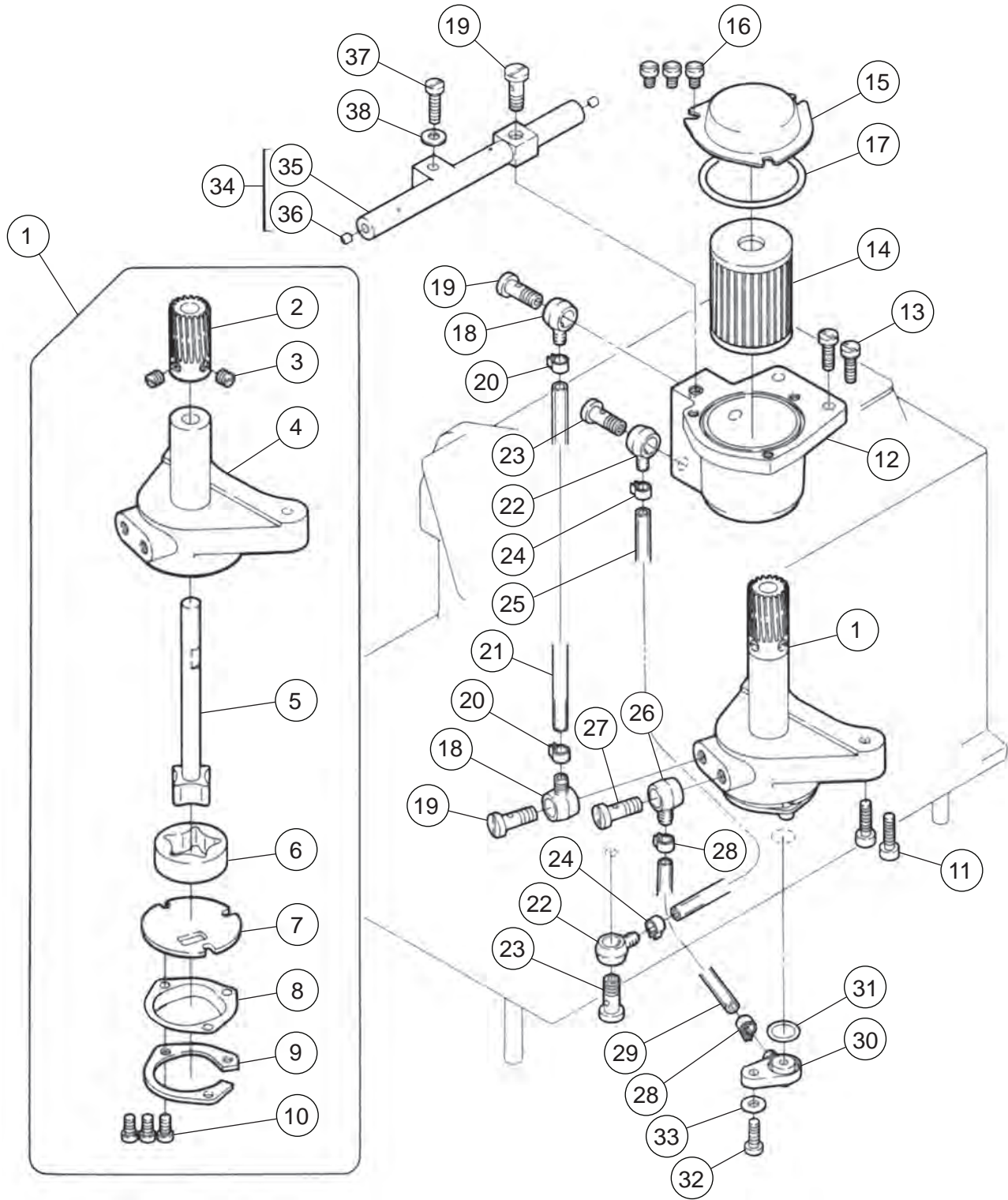
Item	Qty	Assy	Description	Part Number
1	1		CRANK, MAIN FEED BAR	6Z5906
2	1		FEED BAR, MONO, 4000	6Z5919
3	1		SHCS, M6 x 16	SHCSM6X16
4	1		HOLDER, TOP FEED	6Z5855
5	1		KEY, TOP FEED HOLDER	6Z5856
6	1		RETAINER, LOWER FEED	6Z5923
7	1		SHCS, M3.5 x 8	SHCSM3.5X8
8	1		PIN, CRANK	6Z6713
9	2		WASHER, CRANK	6Z6715
10	1		NUT, CRANK	6Z1827
11	1		LINK, CRANK	6Z7028
12	1		SCREW, LINK	660265
13	1		WASHER	6Z6762
14	1		SCREW	6Z2762
15	1		SHCS, #10-32 x 3/4	SHCS10-32X3/4
16	2		NUT, HEX, #10-32	6Z1174
17	1		BUSHING, LINK	6Z7029
18	1		MAIN FEED DOG	6Z3585
19	1		BLOCK, FEED LEVELING	6Z0047
20	1		GUIDE BLOCK, MAIN FEED BAR	6Z9683
21	1		SCREW, FILLISTER HEAD, M3.5 x 10	6Z9058
22	1		WASHER, BELLEVILLE, #6	6Z4201
23	1		SHCS, #5-40 x 5/8	6Z9182

**Knife Drive  
Mechanism**

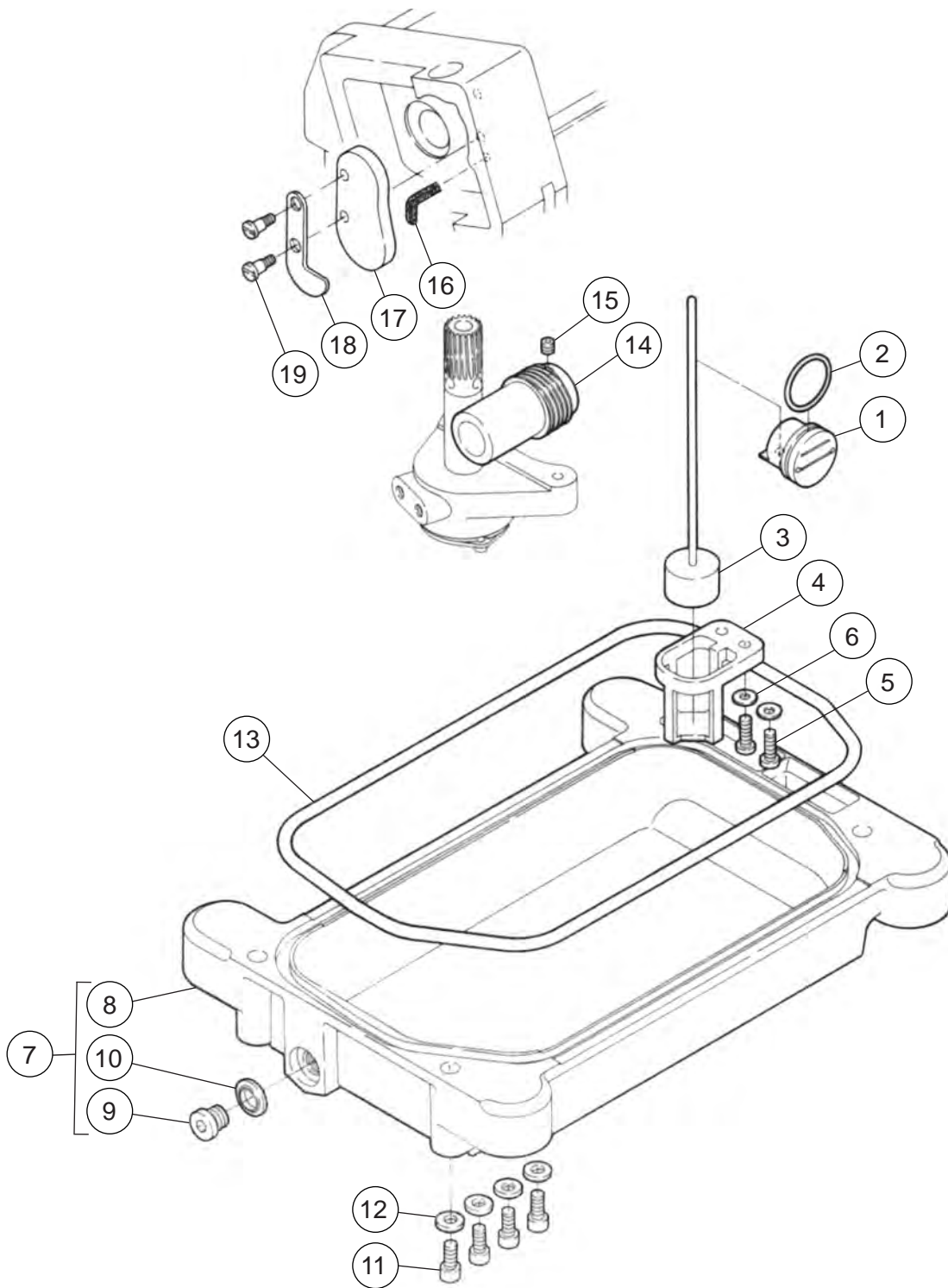


Item	Qty	Assy	Description	Part Number
1	1		CONNECTION	6Z6271
2	2		SCREW	6Z0023
3	1		CRANK	6Z6935
4	1		CRANK	660245
5	1		SCREW	6Z0026
6	1		PIN	6Z0042
7	1		SCREW	6Z0027
8	1		COLLAR	660236
9	1		SCREW	660260
10	1		TOP KNIFE LEVER	6Z6116
11	1		PIN	6Z0048
12	1		TOP KNIFE CLAMP	6Z3645
13	1		SCREW	6Z3639
14	2		TOP KNIFE, SERRATED**	6Z6360
15	1		SCREW	6Z3538
16	1		BOTTOM KNIFE HOLDER	6Z3654
17	1		SCREW	3Z0024
18	1		GUIDE, BOTTOM KNIFE HOLDER	6Z3759
19	2		SCREW	6Z0024
20	1		SPRING	6Z0034
21	1		PLATE	6Z7341
22	1		SCREW	6Z0024
23	1		BOTTOM KNIFE, THICK	6Z0386
24	1		BOTTOM KNIFE CLAMP	6Z0050
25	1		SCREW	730293
26	1		NEEDLE PLATE / KNIFE SUPPORT	6Z3653
27	2		BSHG, BRASS	6Z9403

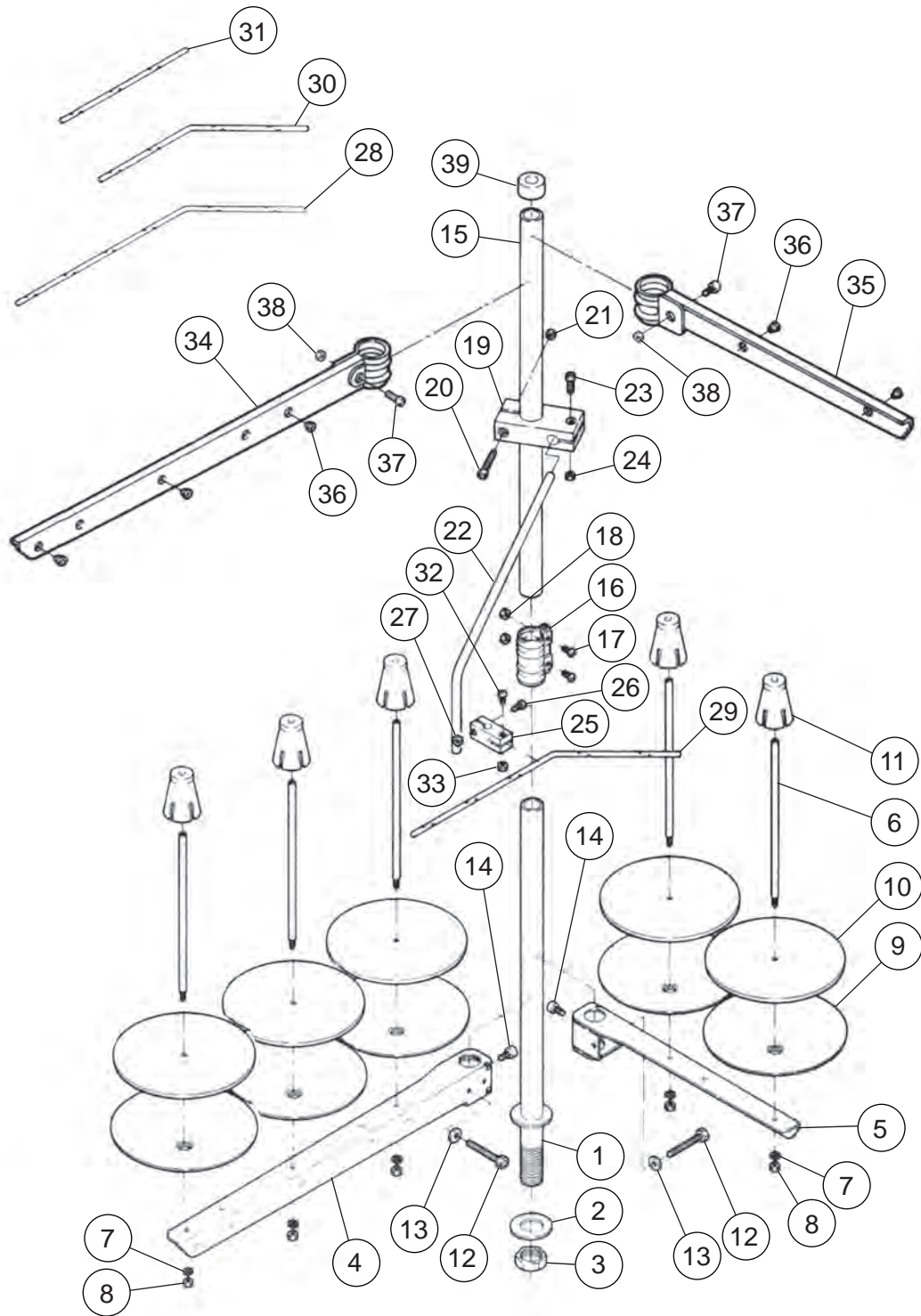
\*\* NON- SERRATED KNIFE (6Z3284) MAY BE USED FOR LIGHTWEIGHT MATERIALS



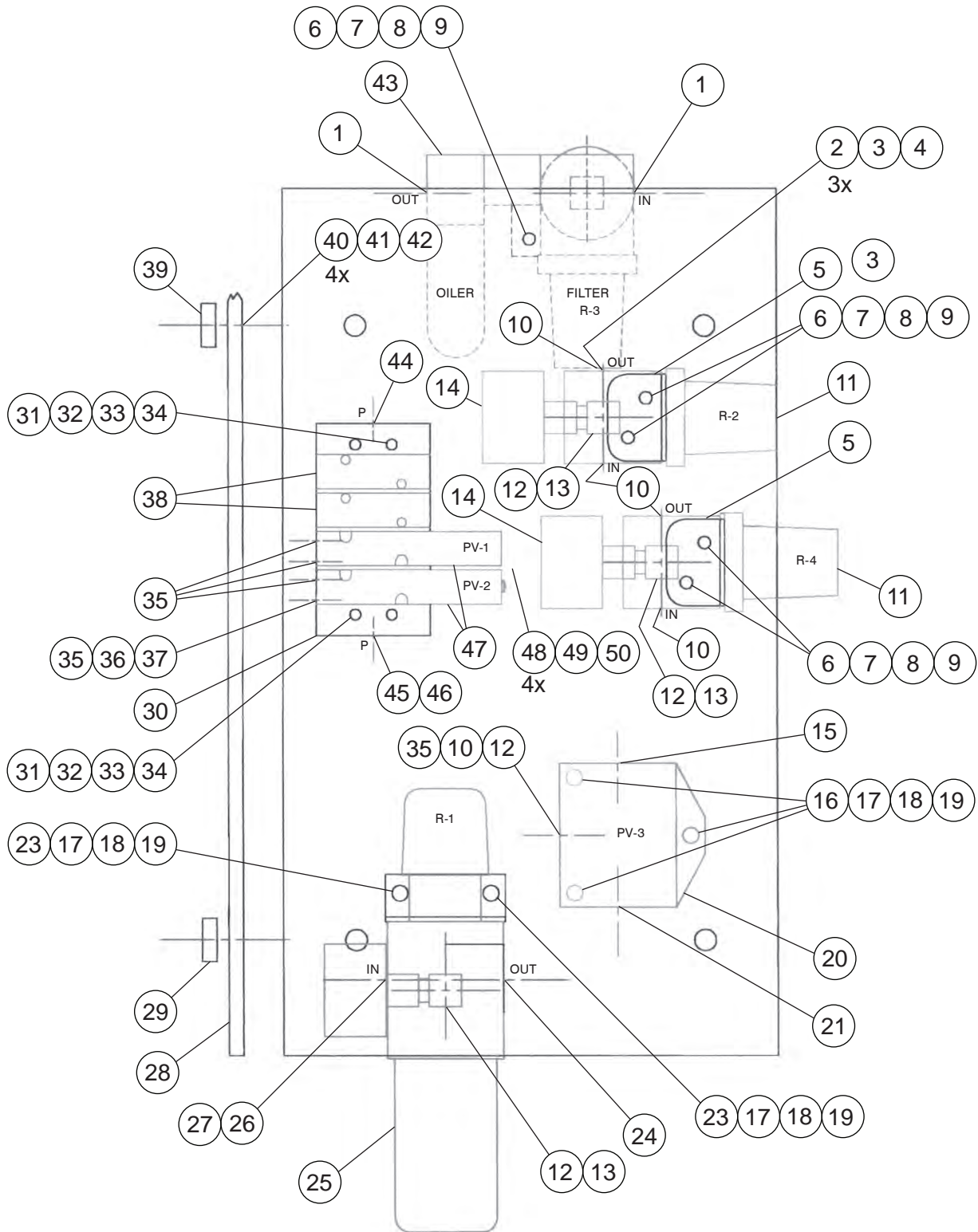
Item	Qty	Assy	Description	Part Number
1	1		PUMP	6Z5680
2	1		WORM WHEEL	6Z3545
3	2		SCREW	6Z3149
4	1		PUMP BODY	660200
5	1		ROTOR SHAFT, INSIDE	6Z2278
6	1		ROTOR, OUTSIDE	6Z1850
7	1		CASING PLATE	660201
8	1		FILTER	6Z1845
9	1		GUIDE	660140
10	3		SCREW	6Z3538
11	2		SCREW	660257
12	1		TANK	660202
13	2		SCREW	6Z3639
14	1		OIL FILTER	6Z1843
15	1		COVER	660203
16	3		SCREW	660082
17	1		O-RING	6Z3622
18	2		JOINT	6Z1857
19	3		SCREW	660154
20	2		CLAMP	6Z3234
21	1		TUBE	660153
22	2		JOINT	6Z1857
23	2		SCREW	660154
24	2		CLAMP	6Z3234
25	1		TUBE	660146
26	1		JOINT	6Z1857
27	1		SCREW	660154
28	2		CLAMP	6Z3234
29	1		TUBE	660156
30	1		JOINT	660205
31	1		O-RING	6Z6193
32	1		SCREW	6Z3639
33	1		WASHER	660227
34	1		OIL DISTRIBUTOR, COMPLETE	6Z6328
35	1		OIL DISTRIBUTOR	660204
36	2		PLUG	660133
37	1		SCREW	6Z0023
38	1		WASHER	660227



Item	Qty	Assy	Description	Part Number
1	1		OIL SIGHT GAUGE	6Z3660
2	1		O-RING	660141
3	1		INDICATOR, COMPLETE, 210193	6ZA204
4	1		INDICATOR SUPPORT	660134
5	2		SCREW	6Z3639
6	2		WASHER	660227
7	1		OIL RESERVOIR ASSEMBLY	6Z8158
8	1		OIL RESERVOIR	660196
9	1		SCREW	6Z0057
10	1		GASKET	6Z3340
11	4		BOLT	6Z0028
12	4		WASHER	6Z0036
13	1		GASKET	6Z0051
14	1		WORM	6Z3752
15	1		SCREW	6Z3753
16	1		OIL WICK, 20 IN	620275
17	1		OIL FELT	6Z0058
18	1		COVER	660208
19	1		SCREW	660271



Item	Qty	Assy	Description	Part Number
1	1		THREAD STAND ROD	6Z3102
2	1		WASHER	640044
3	1		NUT	640042
4	1		BRACKET	6Z1899
5	1		BRACKET	6Z0408
6	5		SPOOL PIN	6Z2835
7	5		SPRING WASHER	640005
8	5		NUT	6Z1828
9	5		SPOOL TRAY	6Z2838
10	5		CUSHION	6Z1900
11	5		SPOOL RETAINING PIN	6Z2837
12	2		SCREW	640065
13	2		WASHER	6Z3347
14	2		SCREW	6Z2574
15	1		THREAD STAND, UPPER	640040
16	1		JOINT	6Z3100
17	2		SCREW	6Z6120
18	2		NUT	6Z1827
19	1		BRACKET	6Z2264
20	1		SCREW	6Z2572
21	1		NUT	6Z1828
22	1		THREAD GUIDE BAR ROD	6Z0237
23	2		SCREW	6Z2573
24	2		NUT	6Z1828
25	1		HOLDER	6Z1214
26	1		SCREW	6Z2573
27	1		NUT	6Z1828
28	1		THREAD GUIDE BAR	
29	1		THREAD GUIDE BAR, 5-SPOOL	6Z3074
30	1		THREAD GUIDE BAR	
31	1		THREAD GUIDE BAR	
32	1		SCREW	6Z2573
33	1		NUT	6Z1828
34	1		BRACKET	6Z0410
35	1		BRACKET	6Z0406
36	5		THREAD GUIDE	6Z3070
37	2		SCREW	6Z2571
38	2		NUT	6Z1827
39	1		ROD CAP	640041

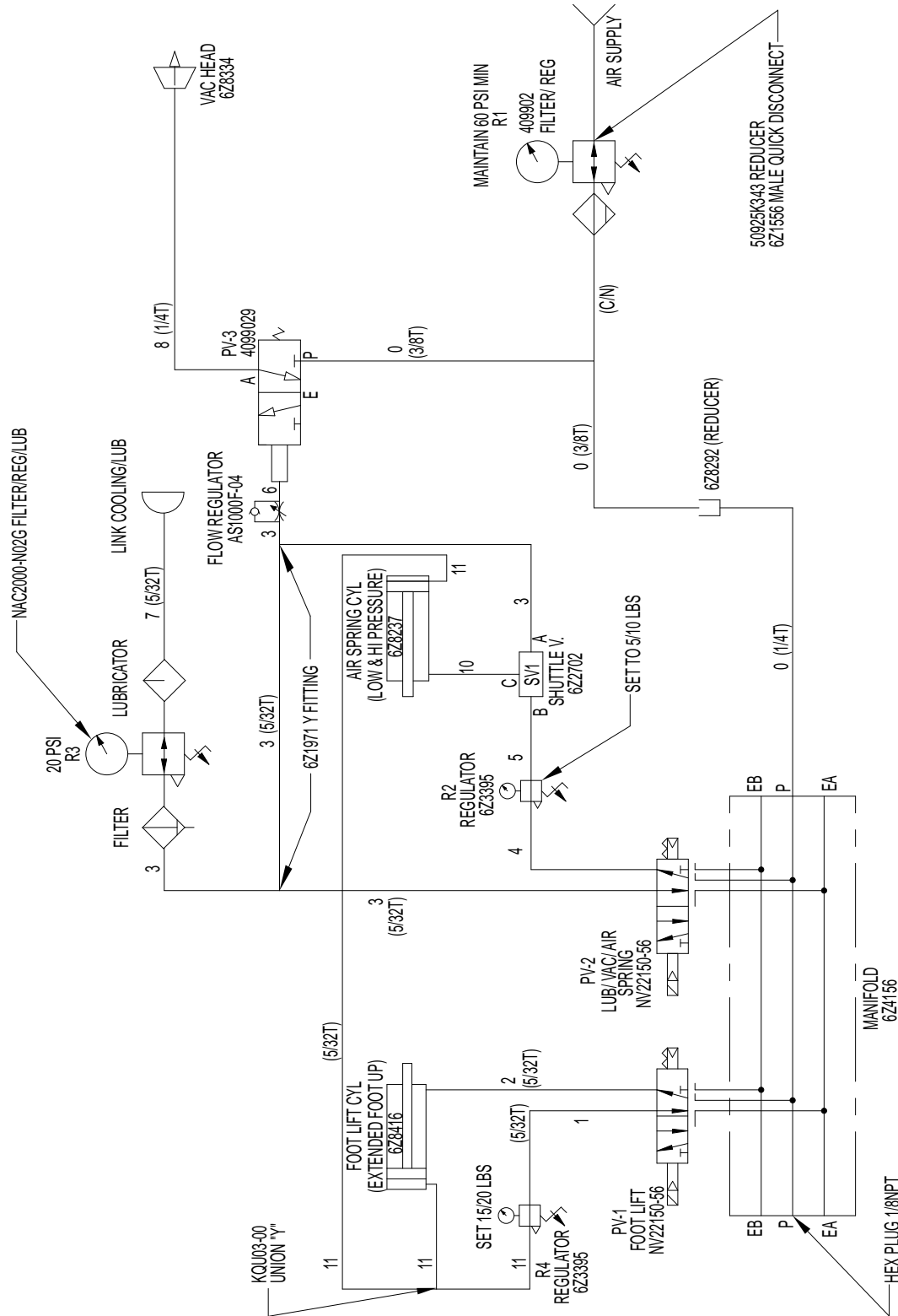


Item	Qty	Assy	Description	Part Number
1	2		FITTING, AIR, 90°	KQL03-35S
2	1		COUPLING, #10-32	MF-1010
3	1		SHUTTLE VALVE, MSV-1	6Z2702
4	3		FITTING, AIR, MH-1016	6Z0172
5	2		LOCK RING BRACKET	6Z1395
6	5		SHCS, #10-32 x 3/4	SHCS10-32X3/4
7	5		WASHER, FLAT, #10	6Z0994
8	5		WASHER, LOCK, SPLIT, #10	6Z2826
9	5		NUT, HEX, #10	6Z1174
10	5		FITTING, AIR, 90°	KQL03-34S
11	2		AIR REGULATOR, 0-30 PSI	6Z3395
12	3		NIPPLE, 1/8 NPT	6Z5846
13	3		ELBOW, BRASS	6Z8288
14	2		GAUGE, 0-30 PSI	6Z3394
15	1		FITTING, AIR, 90°	KQL07-36S
16	3		SHCS, 1/4-20 x 1	SHCS1/4-20X1
17	5		WASHER, FLAT, 1/4	6Z1000
18	5		WASHER, LOCK, 1/4	6Z2832
19	5		NUT, HEX, 1/4	6Z1172
20	1		VALVE, AIR PILOT	4099029
21	1		CONNECTOR MALE	KQH11-36S
22	1		FLOW CONTROL, 1/8 IN-LINE (NOT SHOWN)	AS1000F-04
23	2		SHCS, 1/4-20 x 3/4	6Z2780
24	1		FITTING, AIR, TEE BRANCH	KQT11-36S
25	1		FILTER REGULATOR, AIR	409902
26	1		REDUCER, 3/8-1/8 NPT	50925K343
27	1		MALE QUICK DISCONNECT	6Z1556
28	1		PANEL, PFM PNE	6Z4148
29	1		CLAMP, LOWER PFM PNE	6Z4154
30	1		MANIFOLD, 4-STA	6Z4156
31	2		SHCS, #6-32 x 1-3/4	SHCS6-32X1-3/4
32	2		WASHER, FLAT, #6	6Z0139
33	2		NUT, HEX, #6-32	6Z1178
34	2		WASHER, LOCK, SPLIT, #6	6Z2829
35	5		CONNECTOR, MALE, 5/62 T x 1/8 NPT	6Z3532
36	1		FITTING, PLUG-IN, Y	6Z1971
37	1		UNION, Y	KQU03-00
38	2		BLANKING PLATE	VVZ2000-31A-3
39	1		CLAMP, UPPER PFM PNE	6Z4153

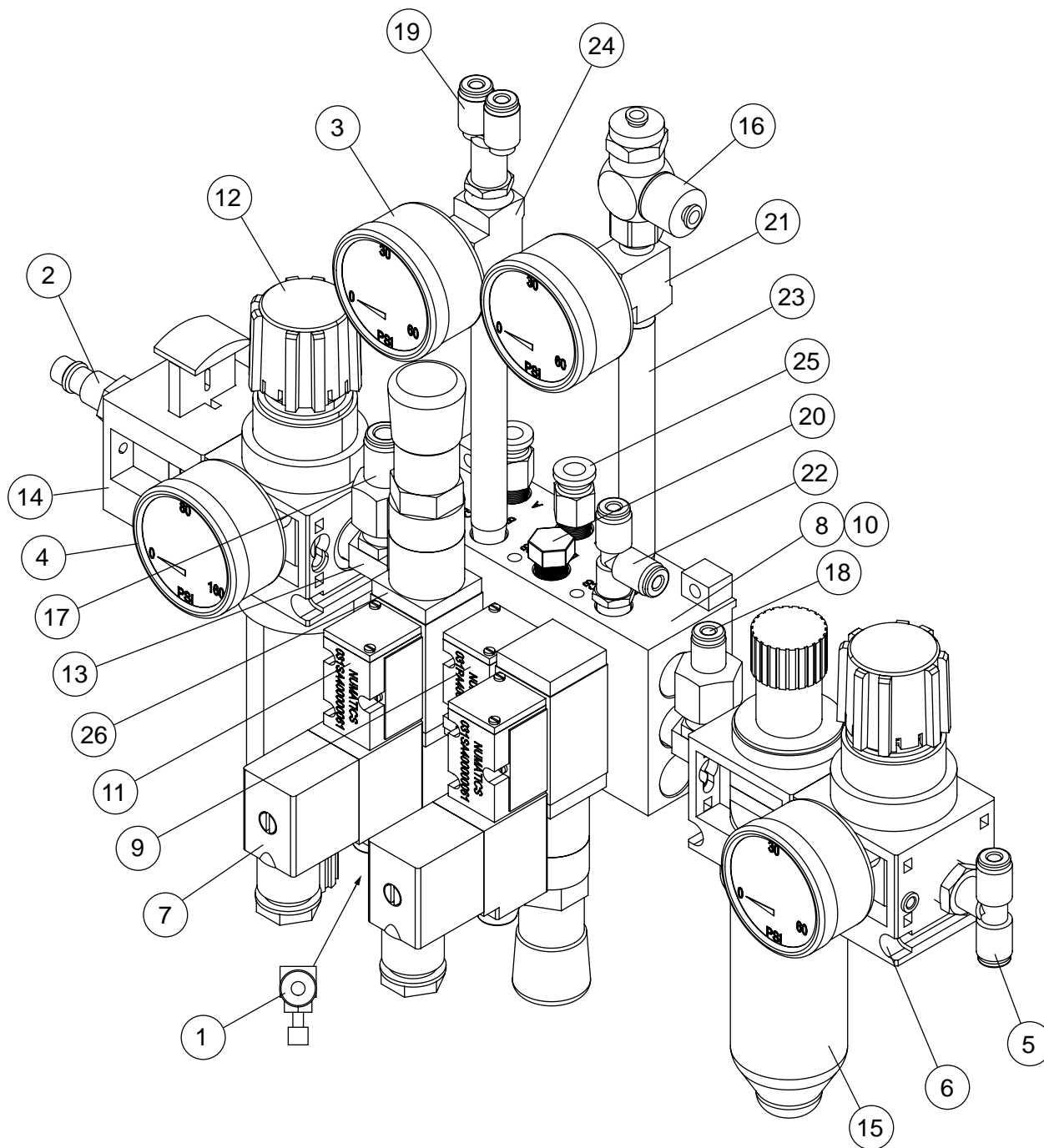
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<b>Item</b>	<b>Qty</b>	<b>Assy</b>	<b>Description</b>	<b>Part Number</b>
40	4		BHCS, 5/16-18 x 1	BHCS5/16X1
41	4		WASHER, FLAT, 5/16	6Z1002
42	4		WASHER, LOCK, SPLIT, 5/16	6Z2833
43	1		FILTER REGULATOR, GAUGE & LUBE, 30 PSI	6Z8475
44	1		PLUG, HEX, 1/8 NPT	4464K331
45	1		COUPLING, REDUCING	6Z8292
46	1		FITTING, AIR, 90°	KQL07-34S
47	2		VALVE, SOLENOID, 24V	NVZ2150-5G
48	1		CABLE ASSEMBLY, PFM PNE	6Z4204
49	1		MOLEX RECEPTACLE, 6-PIN	6Z4209
50	4		CRIMP PIN, FEMALE	6Z0941
51	17		TUBING, AIR, 5/32 OD (NOT SHOWN)	TU0425B-20
52	2		TUBING, AIR, 3/8 OD (NOT SHOWN)	TIUB11B-20
53	4		TUBNG, AIR, 1/4 OD (NOT SHOWN)	4021010
54	1	<b>S</b>	PNEUMATIC DIAGRAM PFM-4000	6Z8260









Item	Qty	Assy	Description	Part Number
1	1		10-32 FLOW CONTROL, 5/32T, 90°	4099017
2	1		MALE PLUG, 1/4 NPT x 1/4	6Z1556
3	3		GAUGE, 0-60 PSI	6Z3413
4	1		GAUGE, 0-160 PSI	6Z3560
5	1		FITTING, TEE, 1/4 NPT x 5/32 TUBE	6Z5854
6	1		REGULATOR, 14 SERIES, 1/4 PORTS	6ZE352
7	2		CONNECTOR, DIN	6ZA609
8	1		VALVE MANIFOLD, 3 STATION	6ZA610
9	1		VALVE, 24 VDC	6ZA611
10	1		DISC, MK3 BLOCKING	6ZC360
11	2		VALVE, 24 VDC	6ZC361
12	1		FILTER REGULATOR, 14 SERIES, 1/4 PORTS	6ZC362
13	2		MALE TEE, BRASS, 1/4 NPT	6ZC363
14	1		SHUT-OFF VALVE, 14 SERIES	6ZC364
15	1		LUBRICATOR, 14 SERIES, 1/4 PORTS	6ZC365
16	1		SHUTTLE VALVE, 1/8 NPT x 5/32 TUBE	6ZC367
17	1		FITTING, FEMALE, 1/4 NPT x 1/4 TUBE	6ZC368
18	1		FITTING, FEMALE, 1/4 NPT x 5/32 TUBE	6ZC369
19	1		Y FITTING, 1/8 NPT x 5/32 TUBE	6ZC371
20	1		PLUG, HEX, 1/8 NPT	6ZC372
21	1		STREET TEE, BRASS, 1/8 NPT	6ZC373
22	1		FITTING, RUN TEE, 1/8 NPT x 5/32	6ZC375
23	2		4 INCH EXT NIPPLE, BRASS, 1/8 NPT	6ZC376
24	1		ALL FEMALE TEE, BRASS, 1/8 NPT	6ZC377
25	2		UNION, STRAIGHT, 1/8 NPT x 1/4 TUBE	KQH07-34S
26	2		SANDWICH PRESSURE REGULATOR	6ZC359



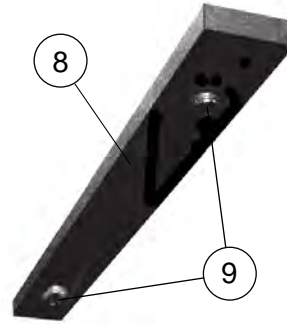
Item	Qty	Assy	Description	Part Number
1			10 INCH FLANGE GUIDE	641278
2			MOTOR PULLEY	6Z3507
3			INTERNAL MOTOR ENCODER	6Z6210
4			CONTROL BOX	6Z6483
5			LEG EXTENSIONS, 1 PAIR	6Z3466
6			REMOTE TREADLE CABLE	6Z0820
7			FOOT TREADLE ASSY	6ZA910
8			COMPLETE STANDUP KIT	6Z2924
9			HINGE BARREL, TO OPEN OR CLOSE DOOR	6Z6911
10			MOTOR BELT GUARD	6ZC309 & 6ZC312
11	1	S	WASTE REMOVAL ASSY	6Z8294
12			BRACKETS (NEW MOTOR/ NEW CONTROL BOX)	6ZB797
13			GAUGE, LOOPER FLAT	802018
14			TREADLE, MECHANICAL/ FIXED	6Z3227
15			MOTOR/ CONTROL BOX KIT	6ZA328
16			V-BELT	31V
17			G MOTOR TO F MOTOR CONTROL BOX ADAPTER BRACKET	6ZA330
18			POSITION DETECTOR(SYNCH),1HP	6Z2991
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**Waste Removal  
Assembly**

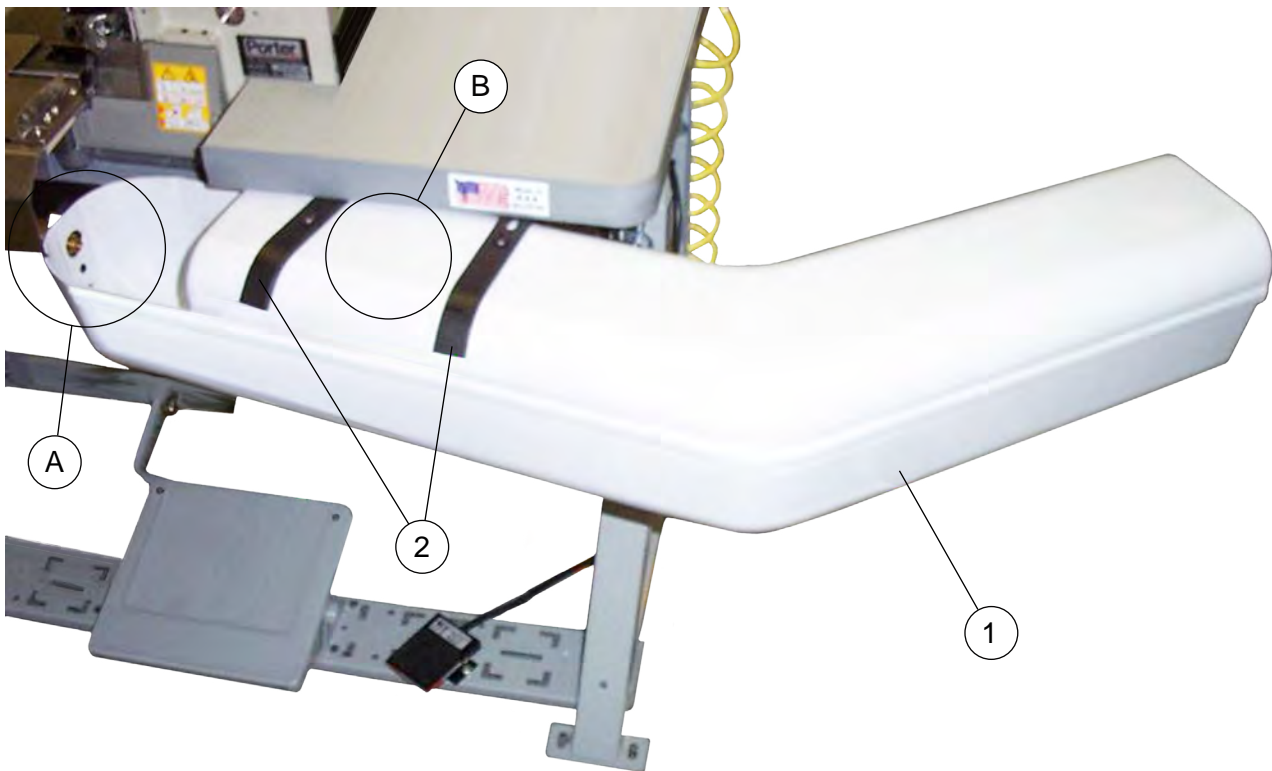
**6Z8294**



**DETAIL A**

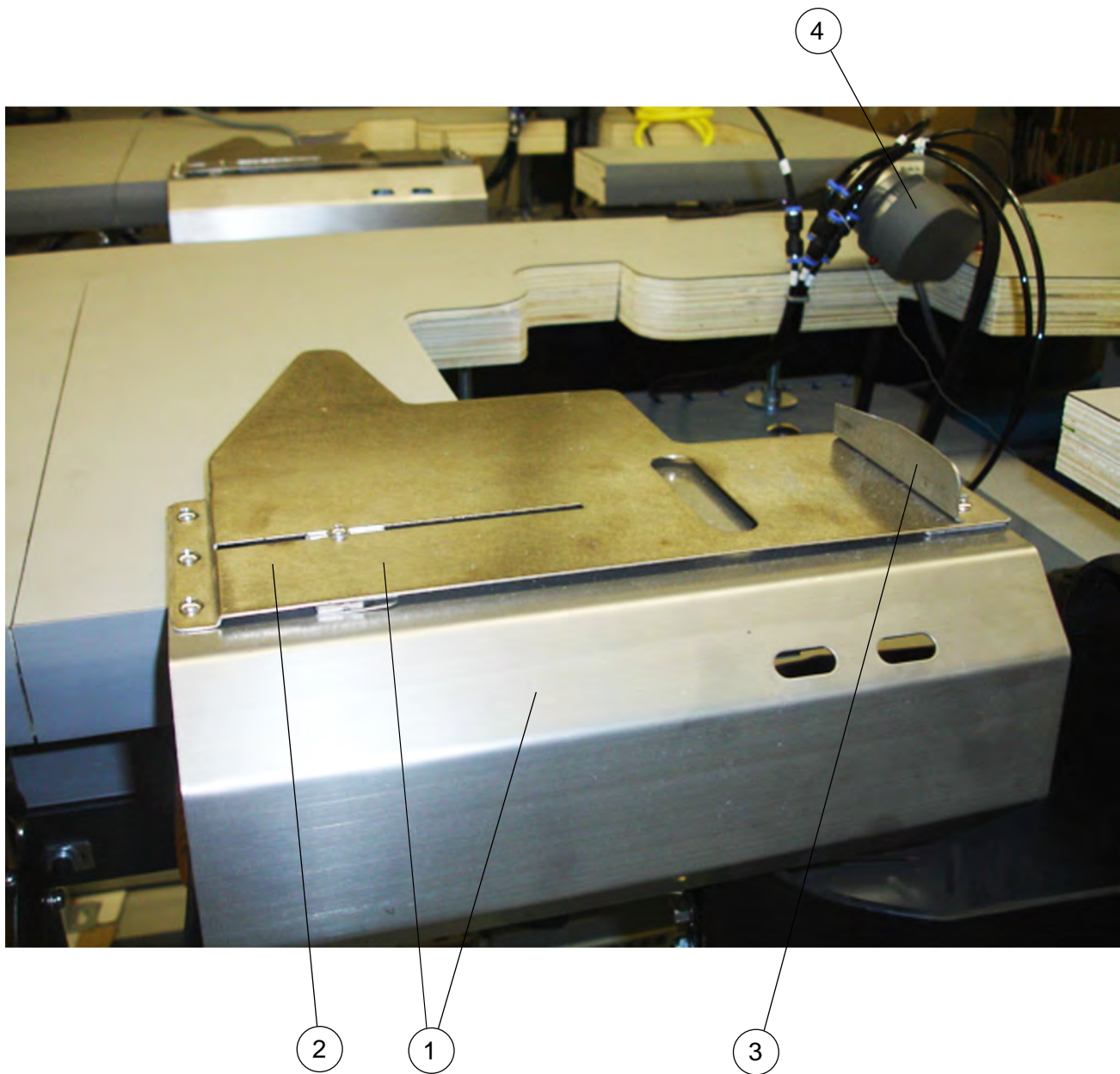


**DETAIL B  
BRACKET INSIDE PLENUM**

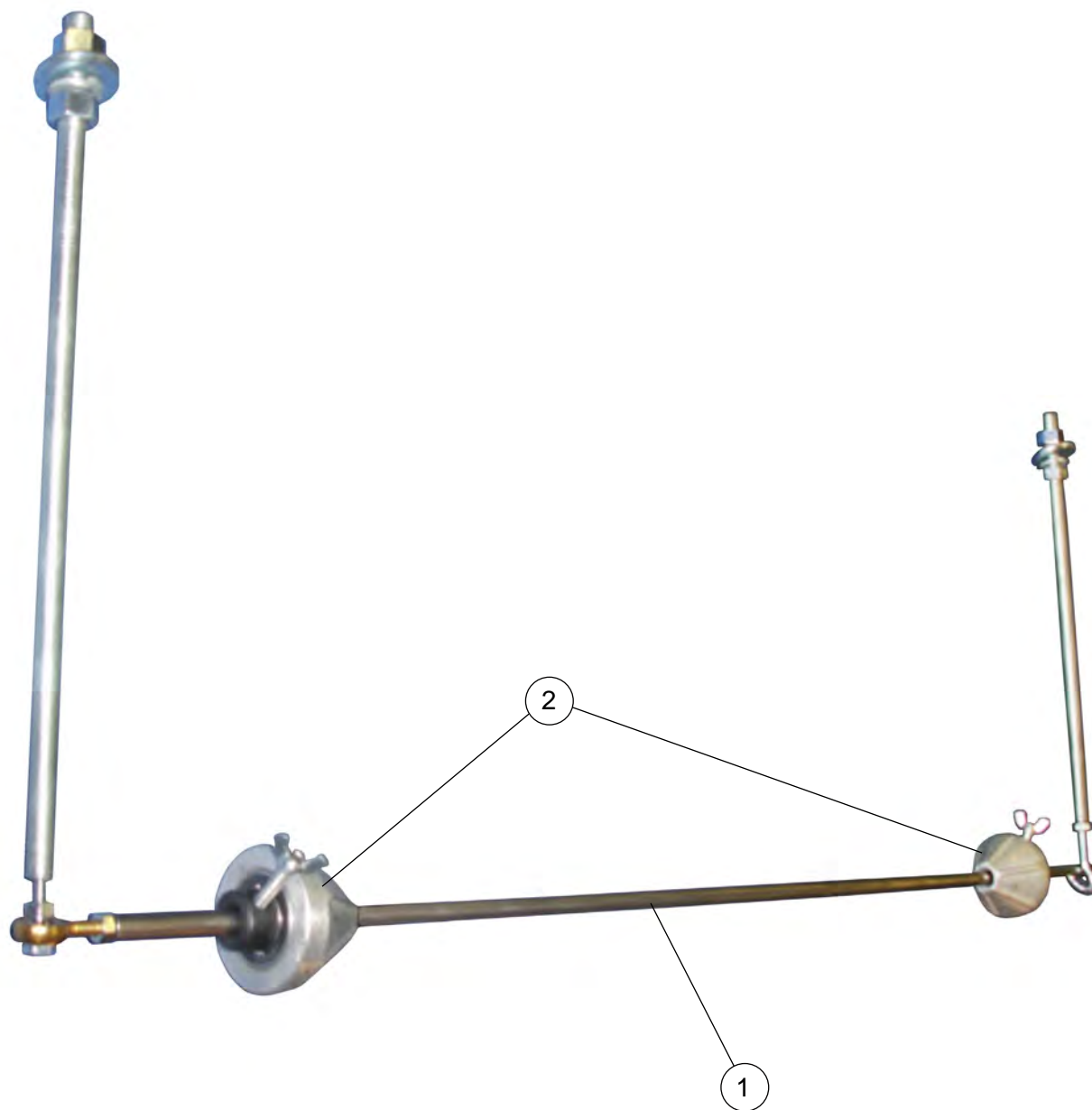


**6Z8294****Waste Removal  
Assembly**

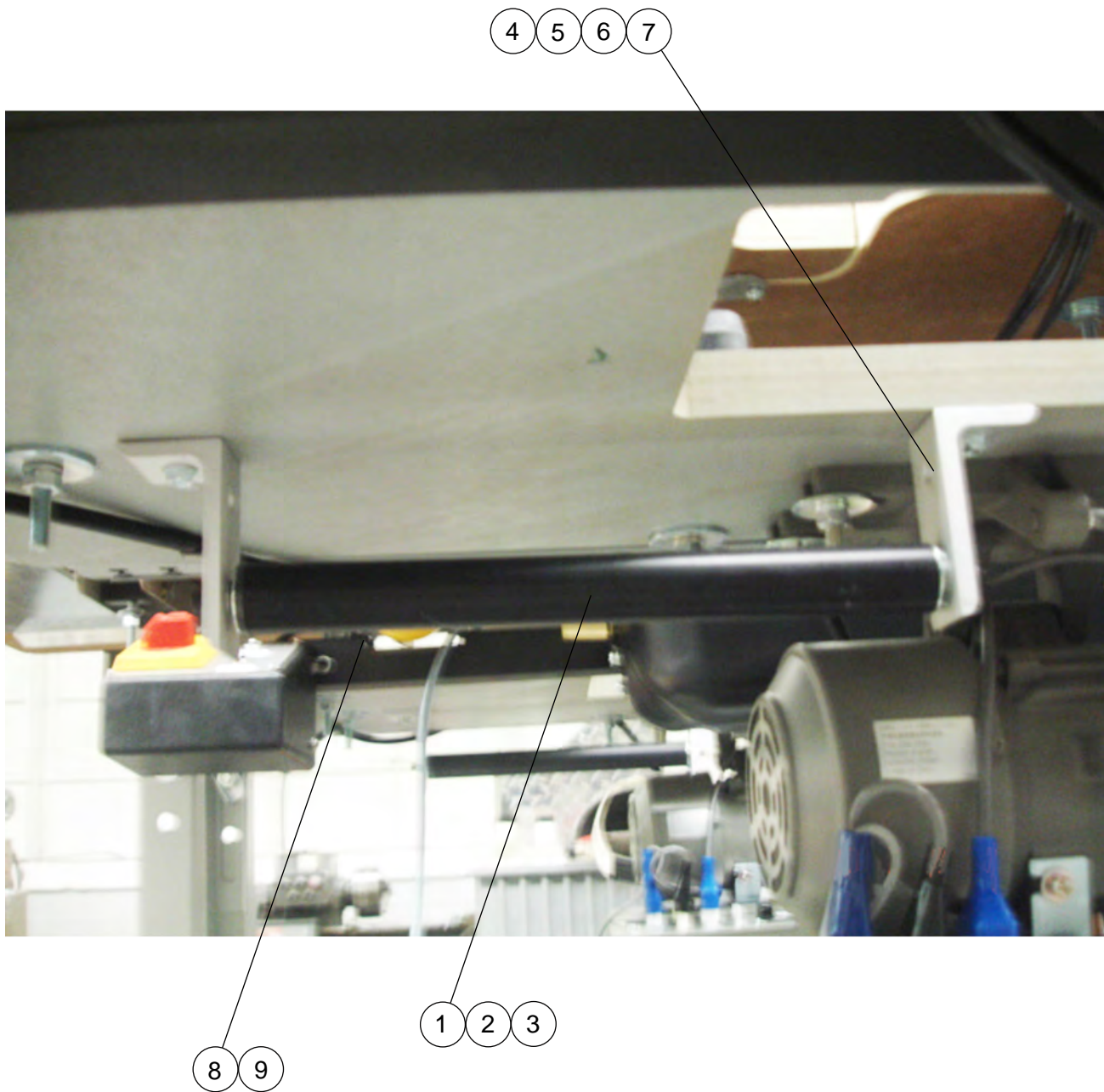
<b>Item</b>	<b>Qty</b>	<b>Assy</b>	<b>Description</b>	<b>Part Number</b>
1	1		VACUUM PLENUM	6ZC386
2	2		BRKT, HANGER MT	802757
3	1		FTG, AIR	KQL07-34S
4	1		AIR JET, HIGH THRUST	6Z8334
5	1		BRKT, AIR VACUUM	6Z8281
6	2		BHCS, #10-32 x 3/4	BHCS10-32X3/4
7	2		NUT, NYLON LOCK, 10-32	LN10-32
8	1		CLAMP, UPR	6Z4153
9	2		BHCS, 5/16-18 x 3/4	BHCS5/16-18X3/4



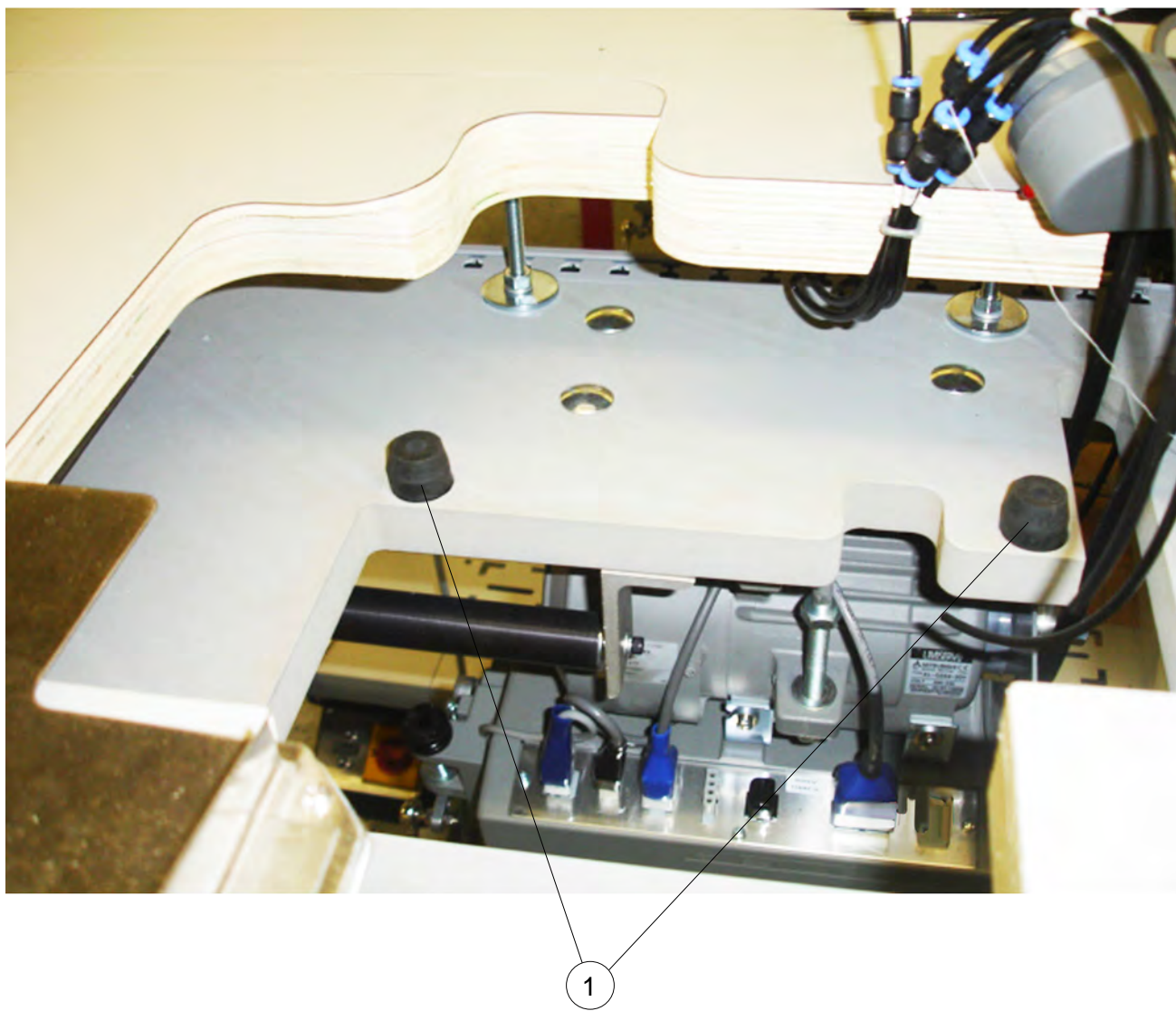
Item	Qty	Assy	Description	Part Number
1	1	S	FLANGE FOLDER ASSY	6Z0966
2			*MAY BE PURCHASED SEPARATELY	6Z5898
3	1		EDGE GUIDE	6Z3186
4	1		SYNCHRONIZER NEEDLE POSITIONER	6Z2991
5		S	ROTARY CUTTER ASSY (NOT SHOWN)	6Z5899
6			*ROTARY CUTTER BLADE MAY BE PURCHASED SEPARATELY	6Z5903



Item	Qty	Assy	Description	Part Number
1	1	S	ROD ASSY	6Z0971
2	2		BRG, CONE	6Z0644



Item	Qty	Assy	Description	Part Number
1	1		IDLER ROLLER	800859
2	1		IDLER SHAFT (NOT SHOWN)	800858
3	2		BRG (NOT SHOWN)	6383K215
4	2		BHCS, #10-32 x 3/4	BHCS10-32X3/4
5	2		BRKT	653024
6	2		WASHER, LOCK, #10	J500430010
7	2		WASHER, FLAT, #10	P01-06-0003
8	1		ROTARY CUTTER	6Z5899
9			*ROTARY CUTTER BLADE MAY BE PURCHASED SEPARATELY	6Z5903



Item	Qty	Assy	Description	Part Number
1	4		ISOLATORS	6Z2287



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