PORTER

DESIGNERS AND MANUFACTURERS OF SPECIALIZED INDUSTRIAL SEWING EQUIPMENT

PNR

The Tape Edge Closing Machine

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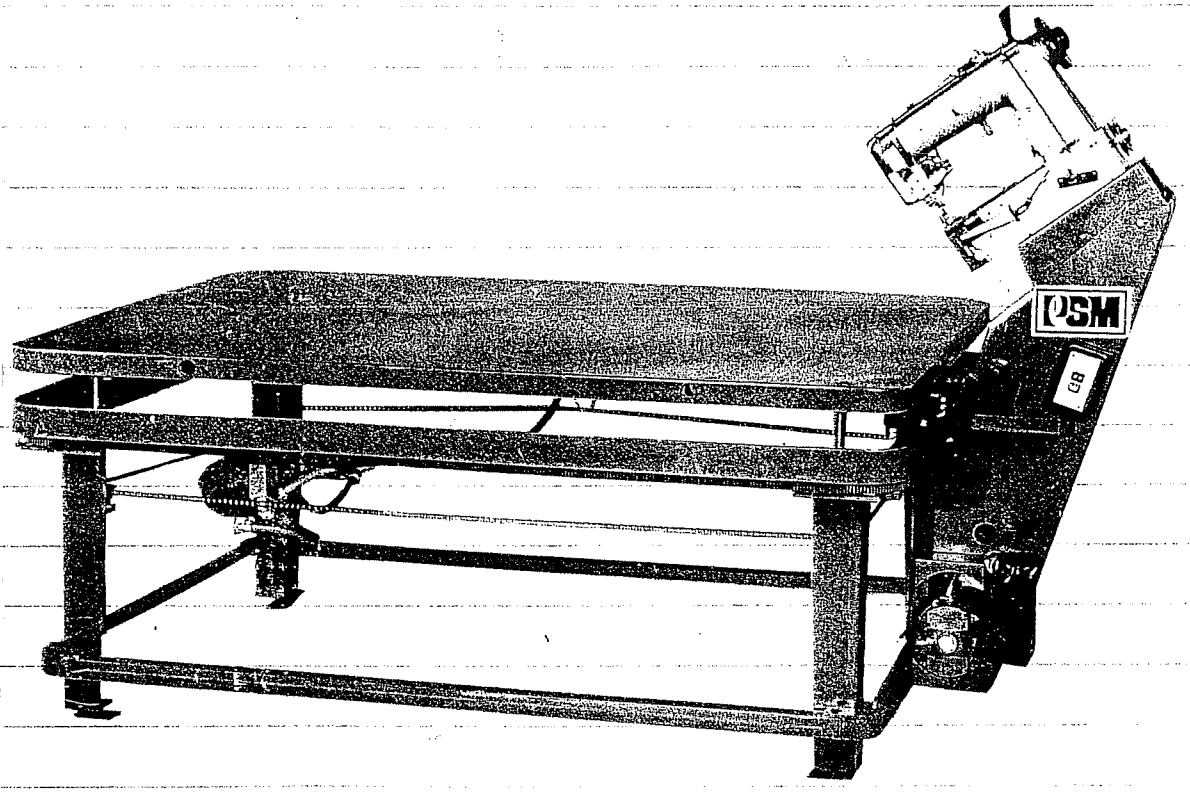

INSTRUCTIONS, PARTS CATALOG & SERVICE MANUAL

PSM

PORTER

SEWING MACHINES, INC.

97 RANTOUL STREET, BEVERLY, MA 01915

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ASSEMBLY INSTRUCTIONS

The PNR Tape Edge system consists of three main assemblies: the table, the carriage, and the sewing head.

When locating the table, care must be taken to find a level section on the production floor. To level the table, adjustment screws with lock nuts are located at the bottom of each table leg. Additional powered adjustments are available to adjust the table height to individual operators.

The carriage asembly mounting requires the removal of the roller and stud assembly from the upper track level bracket. When the carriage has been lifted on to the track and is running on its casters, the roller and stud can be replaced.

The sewing head can be attached to the carriage by means of four (4) hex head screws which are provided. The screws are mounted from underneath the carriage tilt plate. The drive wheel cover and its V-belt should be removed so that the V-belt can be fastened over the pulley. The drive belt must be attached before operating. The sewing head comes fully threaded, so observe the various thread guides.

Located on the carriage are two electrical outlets. The top outlet is the main power wire coming down from the swivel. The bottom outlet is for the work light. Both plugs are of the twist-on type.

Fasten the thread cone platter and the top reel on the same side of the carriage away from the edge of the table. Three thread guides consisting of a wire loop at each end are fastened to the carriage and sewing head below the tape reel.

The right-hand (needle) thread uses two thread guides, a long one on the carriage and a shorter one on the head. The looper thread, further to the left, uses only one (long) thread guide on the carriage. These guide the two threads to the bracket on the top of the head. The looper thread passes from the bracket down through a tube provided.

The ceiling electrical connection should now be connected. It should be located 7" (2.15M) to 10' (3.08M) above the floor level. The swivel wire is brought down and threaded thru a loop which is fastened to the sewing head. The swivel wire is plugged in and twisted (locked) in place on the upper of the two connectors located on the side of the carriage.

Now the machine is ready to operate.

Note: You should turn the head over by hand to insure correct operations before power is turned on.

NEEDLES

The size of the needle to be used is determined by the size of the thread which must pass freely through the eye of the needle.

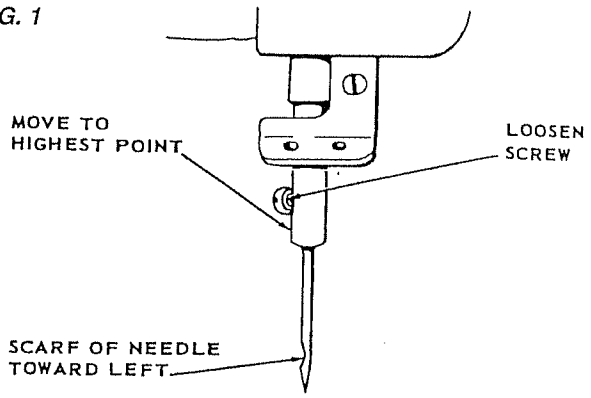
Orders for needles should specify quantity required and size number.

To Set The Needle

Turn machine pulley over toward the operator until the needle bar is at its highest point, as shown in Fig. 1.

Insert needle into needle bar as far as it will go, making certain that the scarf of the needle faces toward the left, as shown in Fig. 1.

FIG. 1



THREADING THE MACHINE

Upper Threading

Turn machine pulley over toward operator until needle bar is at its highest point.

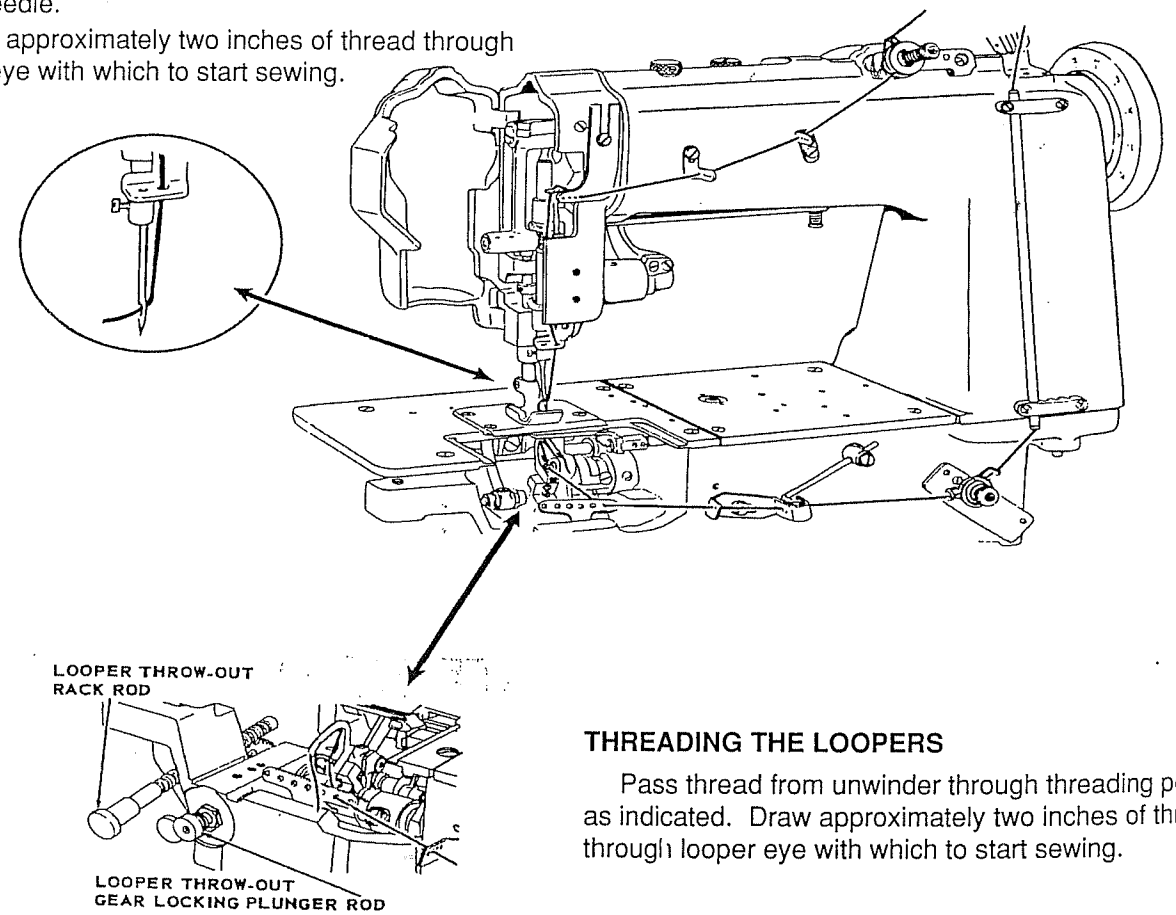
Pass thread from unwinder through threading points indicated in Fig. 2. See insert, Fig. 2, for correct threading of needle.

Draw approximately two inches of thread through needle eye with which to start sewing.

THREAD

Either left twist or right twist may be used in the needles and loopers.

Rough or uneven thred, or thread which passes through the needle eye with difficulty will interfere with successful operation of the machine.



THREADING THE LOOPERS

Pass thread from unwinder through threading points as indicated. Draw approximately two inches of thread through looper eye with which to start sewing.

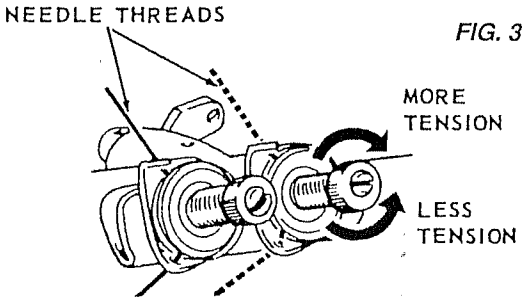


FIG. 3

TENSION

Tension on thread should be light as possible while still sufficient to set the stitch correctly in material.

Needle Thread Tension

To regulate needle thread tension, turn thumb screw, indicated in Fig. 3, as required.

IMPORTANT: Regulate needle thread tension only when presser foot is down.

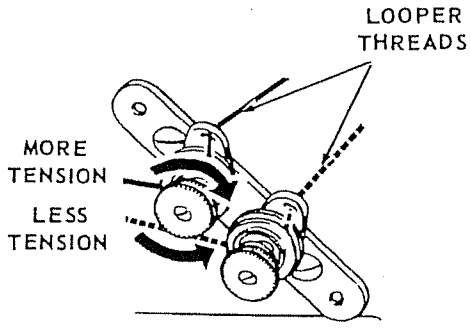


FIG. 4

Looper Thread Tension

To regulate looper thread tension, turn thumb screws, indicated in Fig. 4, as may be required.

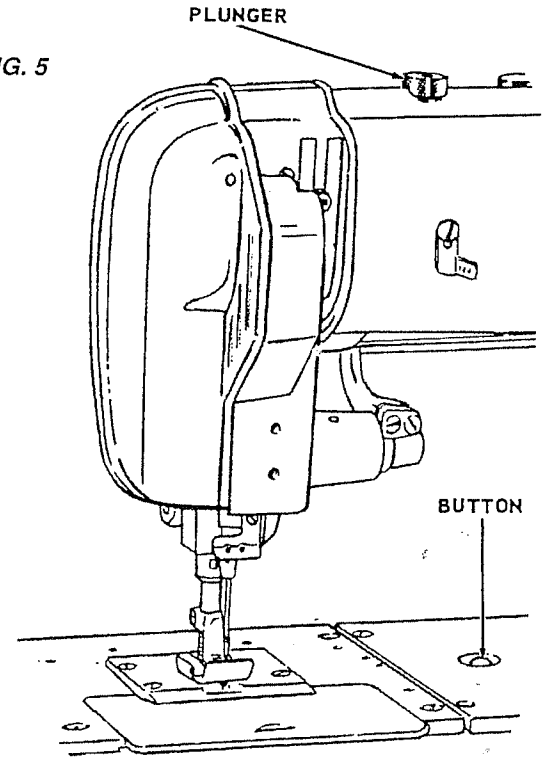


FIG. 5

STITCH LENGTH

To adjust the stitch length, depress plunger, Fig. 5, located on top of arm. Continue to hold plunger down and turn machine pulley toward operator until plunger enters notch in arm shaft eccentric. Turn plunger to lock in position. Depress button, Fig. 5, located on machine bed. Hold down and turn machine pulley toward operator to increase length of stitch, or away from operator to decrease length of stitch. Letter "A" on machine pulley indicates the longest stitch. When desired length, indicated by letter, is opposite arrow on front of machine; release button and turn plunger to right or left until it springs outward.

CAUTION: Never turn machine pulley with plunger in locked position until button on machine bed is depressed.

PRESSURE

Pressure on material should be as light as possible while still sufficient to insure correct feeding.

Alternating Pressers

To increase pressure, loosen lower lock nut and loosen lock screw, then tighten upper lock nut, Fig. 6. When correct pressure is attained, tighten lock screw. Then tighten the lower lock nut. To decrease pressure, loosen upper lock nut and loosen lock screw, then tighten lower lock nut. When correct pressure is attained, tighten lock screw. Then tighten the upper lock nut.

CAUTION: Limit lift of pressers to minimum required for the work, as this permits higher speeds.

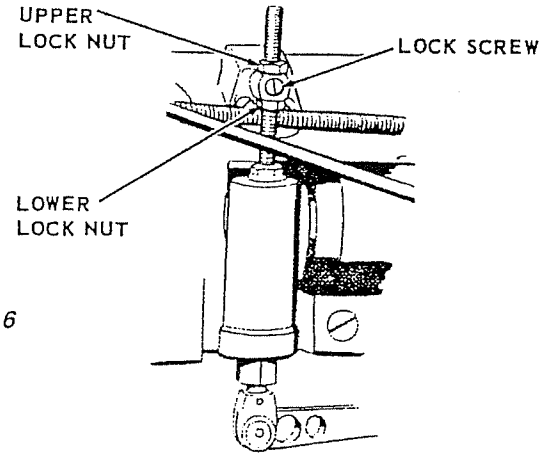


FIG. 6

Machines with Alternating Pressers

The lift of the vibrating and lifting pressers is controlled by an adjustable eccentric. To adjust, remove arm cover at rear of machine. Turn machine pulley over toward operator until feeding presser is down. Loosen the two lock screws, Fig. 7 and the two clamp screws. Insert screwdriver into notch of adjusting disc and turn machine pulley as indicated in Fig. 7. Then tighten the two clamp screws and the two lock screws.

When it is desirable to have either one of the pressers lift higher than the other, turn machine pulley over toward operator until the lifting presser is at its highest position. Loosen the two clamp screws, Fig. 8, and turn lifting rock shaft crank up or down until desired lift of each presser is attained. Then tighten the two clamp screws.

The vibrating presser should be timed so that under normal sewing conditions, the presser foot will seat on the material at approximately the same time the needle enters material. This timing can be advanced or retarded slightly depending on the type of operation being performed, such as sewing over seams. To adjust, loosen two holding screws, Fig. 8, not more than one half turn. Then turn the adjustable eccentric, Fig. 7, until the vibrating presser seats at the correct time. Securely tighten the two holding screws after adjustment is made.

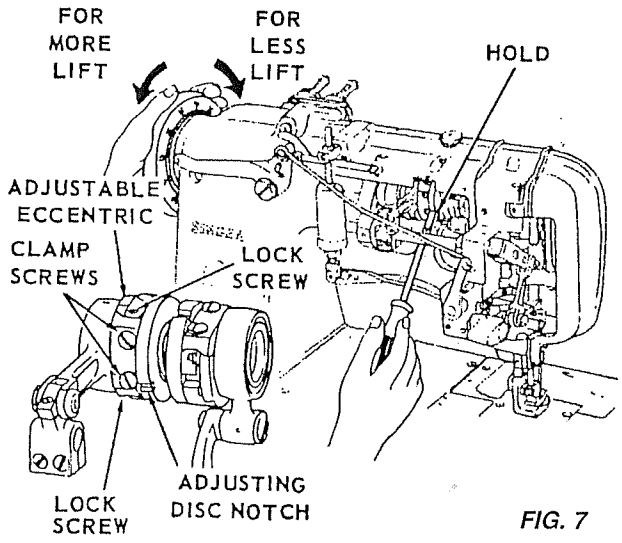


FIG. 7

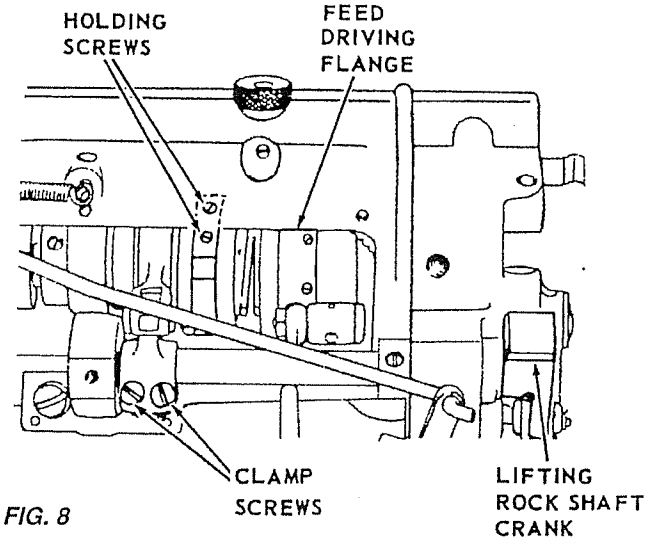


FIG. 8

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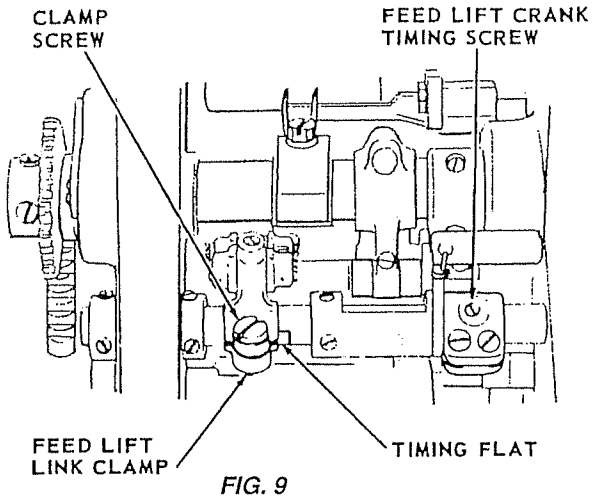


FIG. 9

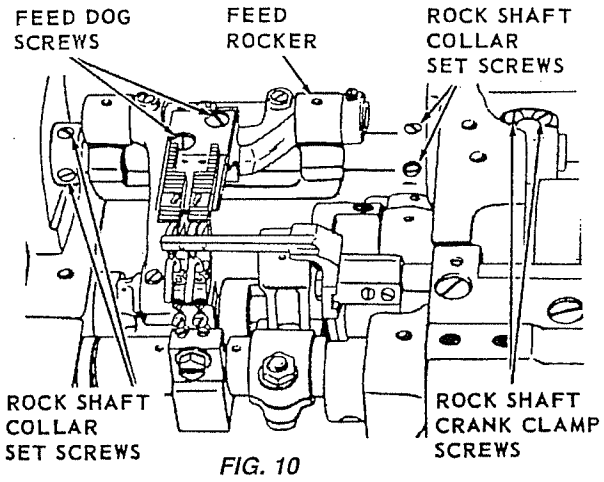


FIG. 10

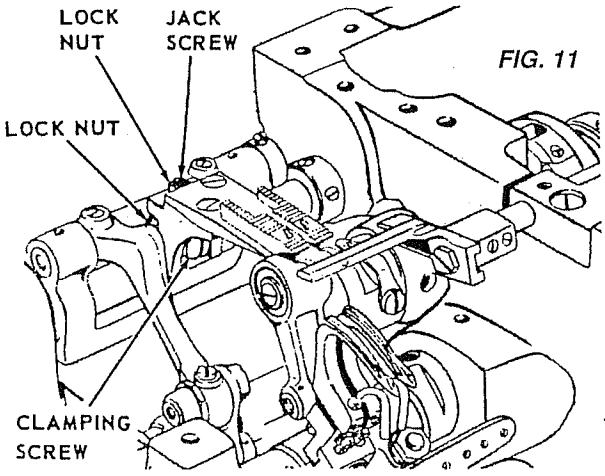


FIG. 11

TO SET FEED BAR AT CORRECT HEIGHT

When the feed bar is set at the correct height the feed lift link clamp will be aligned with the rock shaft timing flat. To adjust, make certain that the feed lifting crank timing screw, Fig. 9, engages shaft spot correctly. Loosen clamp screw and move the feed lift clamp link to correct position. Then tighten clamp screw.

CENTRALIZING FEED DOG

Sidewise Setting

Needle should enter needle hole of feed dog with the same clearance between the needle and left or right side of hole. To adjust, loosen feed dog screws, Fig. 10. Move feed dog until correct clearance is attained. Hold in position and tighten feed dog screws.

Additional adjustment, if necessary, may be attained by loosening the four rock shaft collar set screws, the two rock shaft crank clamp screws, Fig. 10, and feed lifting clamp screw, Fig. 9. Move complete assembly to required position and tighten screws.

Lengthwise Setting

The feed dog should clear the ends of the feed slots in the throat plate equally at both ends of feed travel. To adjust, set feed for desired stitch length. Loosen the two rock shaft crank clamp screws, Fig. 10. Move feed rocker forward or backward until correct positioning is attained. Then, tighten the two clamp screws.

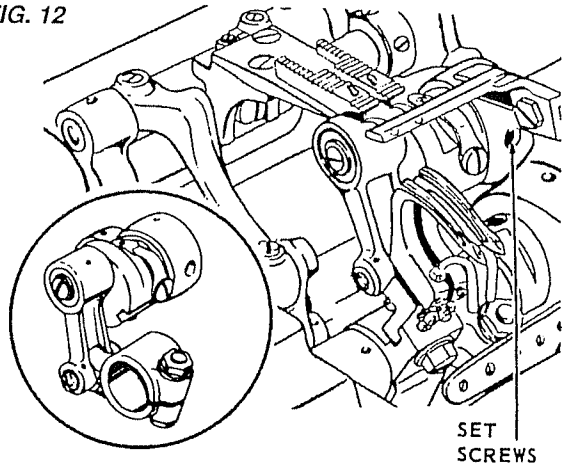
SETTING FEED DOG AT CORRECT HEIGHT

When the feed dog height is set correctly, approximately the full depth of the teeth will show above the throat plate. To adjust, loosen lock nuts, Fig. 11, and slightly loosen feed dog clamping screw. To raise feed dog, turn jack screw clockwise; to lower, turn jack screw counter-clockwise and tap feed dog down. When correct setting is attained, tighten the clamping screws and lock nuts.

TIMING FEED LIFT ECCENTRIC

When the feed dog is at its highest position, the top of the teeth should be parallel with, and project full depth of teeth above upper surface of throat plate. To adjust, insert screwdriver in hole in feed strap and loosen the two set screws, Fig. 12. Move feed lift eccentric forward for earlier rise of feed dog, or backwards for later rise. Then, tighten the two set screws.

FIG. 12



NEEDLE BAR POSITIONING

Needle should enter needle hole of feed dog toward the front, with approximately the same clearance between the front of the needle and the needle hole, as at the side. To adjust, press needle bar rock frame, Fig. 13, against drive arm and at the same time loosen the two driving arm clamp screws. Continue holding the rock frame against the drive arm, move needle bar to correct position and tighten the two clamp screws.

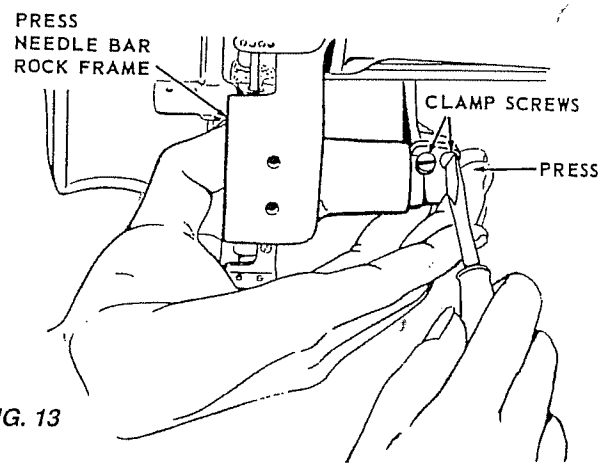


FIG. 13

POSITIONING LOOP DEFLECTOR

When loop deflector, located on underside of feed dog, is positioned correctly there should be a clearance of approximately 1/32 inch between the right side of the needle and the loop deflector. To adjust, move looper out of sewing position and tilt machine back on its hinges. Loosen loop deflector screws, Fig. 14. Move deflectors toward rear of feed dog as far as the screw slots allow. Tighten slightly to allow for further adjustment. Return looper to sewing position and turn machine pulley until needle bar has descended to bottom of the needle bar stroke. Tap deflector to left or right until correct clearance is attained. Move looper out of sewing position and tighten loop deflector screws.

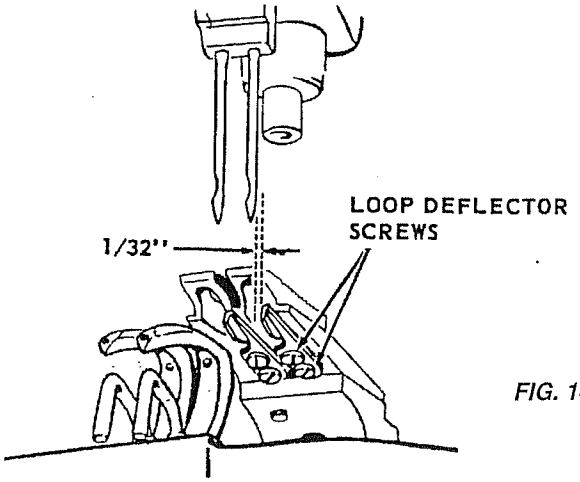


FIG. 14

SETTING THE LOOPER AT CORRECT DISTANCE FROM NEEDLE

FIG. 15

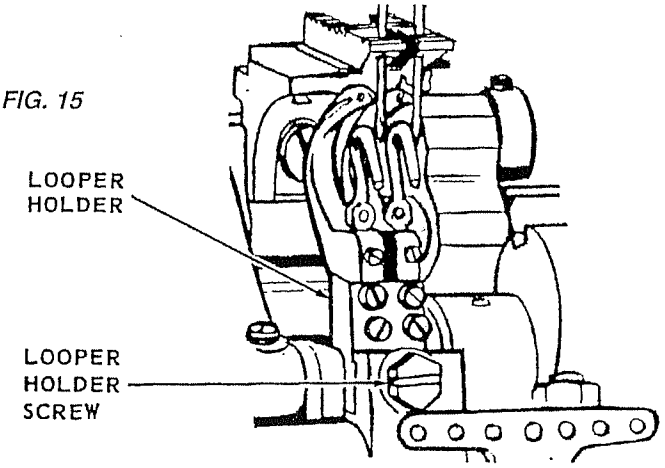
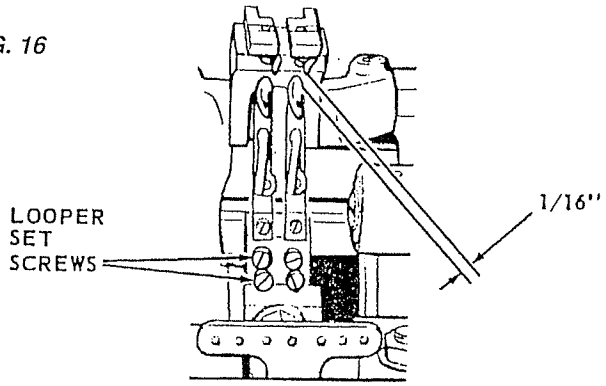


FIG. 16



Sidewise Setting

When the looper is correctly positioned, the point of the looper just clears the scarf of the needle on the forward stroke of the looper. To adjust, turn machine pulley until the looper point is directly opposite the center of the needle. Loosen looper holder screw, Fig. 15, and tap holder to left or right until correct clearance is attained. Then, securely tighten the looper holder screw.

Move looper to extreme forward position. Check clearance between heel of looper and loop deflector, Fig. 16, which should be approximately 1/16 inch. To adjust, loosen the two looper set screws. Turn looper to left or right until correct clearance is attained. Hold in position and securely tighten the two set screws.

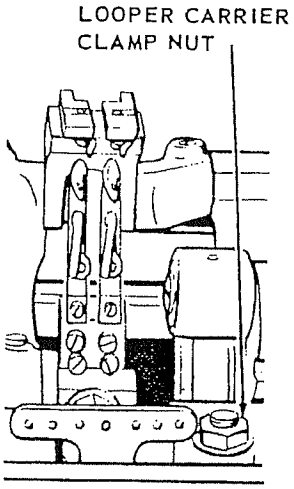


FIG. 17

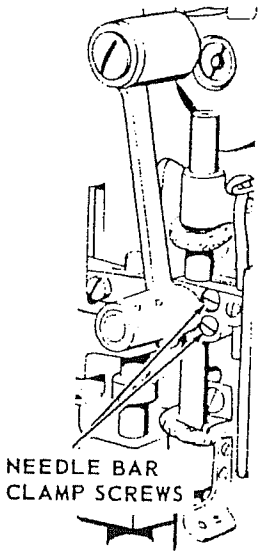


FIG. 18

Lengthwise Setting and Setting Height of Needle Bar

When correctly set, the point of the looper should be directly opposite the center of the needle and at the center of the clearance above the eye of the needle when the looper timing mark LT on machine pulley is opposite the timing arrow on the arm.

To adjust the looper, loosen looper carrier clamping nut, Fig. 17. Move carrier forward or backward until looper point is directly opposite center of needle. Then tighten clamping nut.

To adjust needle bar, first make certain that needle is inserted up into the needle bar or clamp as far as possible. Loosen the two needle bar clamping screws, Fig. 18, and raise or lower needle bar to correct position. Then, securely tighten the two clamping screws.

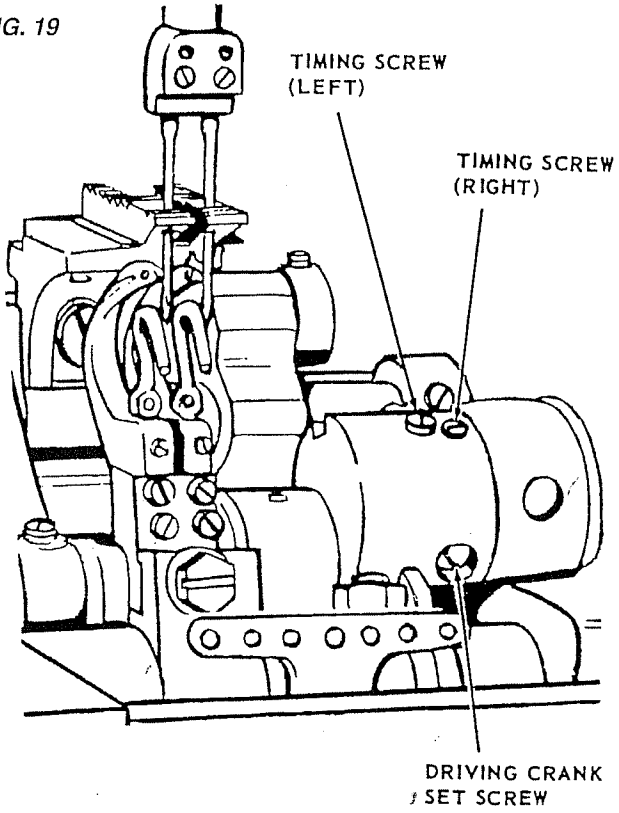
TIMING LOOPER DRIVING CRANK

When the looper driving crank is properly timed, the point of the looper will pass above the eye of the needle at the same distance on both the forward and backward strokes of the looper.

To adjust when point of looper passes higher on forward stroke, loosen looper driving crank set screw, Fig. 19. Loosen looper crank timing screw (left) approximately 1/8 turn and tighten looper crank timing screw (right). Continue to adjust until correct adjustment is made. Then, securely tighten set screw.

When point of looper passes higher on backward stroke, reverse the adjustment by loosening timing screw (right) and tightening timing screw (left).

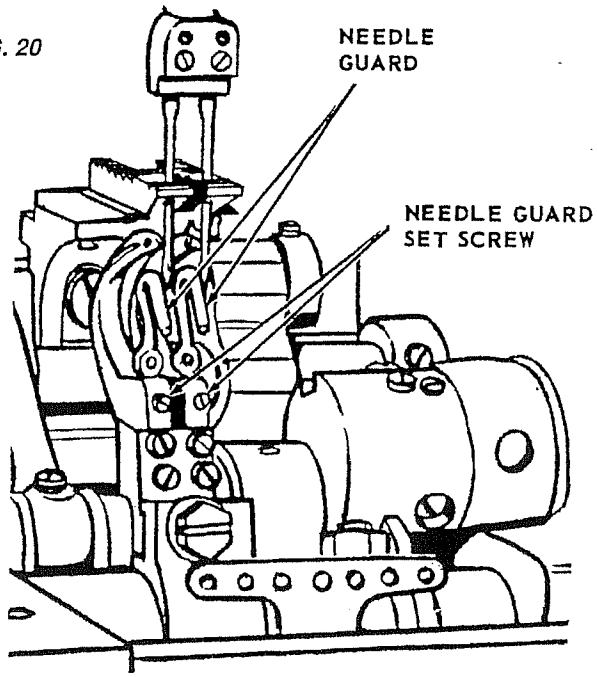
FIG. 19



SETTING THE NEEDLE GUARD

When needle guard is properly set, it should pass as closly as possible to the needle without touching. To adjust, turn machine pulley over towards operator until the point of the looper is about to pass the needle on its forward stroke. At this point, the looper timing mark LT on the machine pulley should be approximately 1/8 inch above the arrow on machine arm. Loosen needle guard set screws, Fig. 20. Turn needle guard as close to the needle as possible without touching. Tighten set screws. Check by springing the needle to the left and turning the machine pulley to make certain that the looper points do not stroke the needle.

FIG. 20



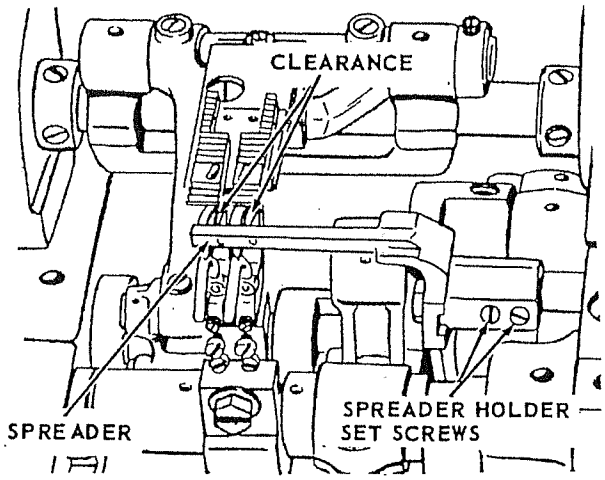


FIG. 21

POSITIONING SPREADER

Sidewise and Height Setting

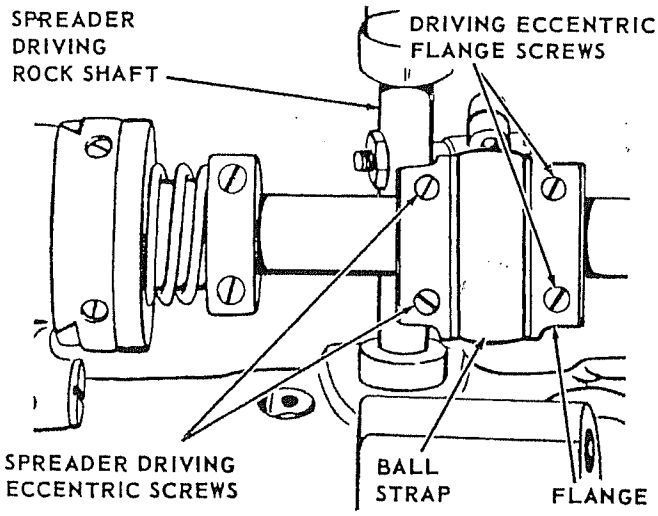
When looper on its forward stroke is passing spreader:

The point of the spreader should be exactly opposite top of thread groove at left side of looper.

The clearance between spreader point and looper should be approximately the double thickness of ordinary paper.

To adjust, loosen the two spreader holder set screws, Fig. 21. Move spreader and holder to correct position. Hold in position and tighten the set screws.

FIG. 23



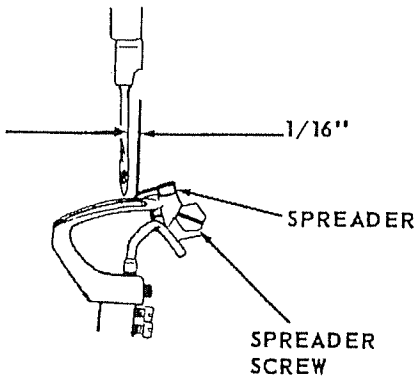


FIG. 22

Lengthwise Setting

When the point of the needle on its downward stroke is even with the point of the spreader, the clearance between the two points should be approximately 1/16 inch. To adjust, loosen spreader screw, Fig. 22, and move spreader forward or backward to correct position. Then tighten spreader screw.

CHANGING MOVEMENT OF SPREADER

The sidewise movement of the spreader may be adjusted for sewing under abnormal conditions. Under normal conditions, maximum spreader movement is generally used. To adjust, tilt machine back on its hinges, loosen the two spreader driving eccentric screws, Fig. 23, and the two spreader driving eccentric flange screws. Move eccentric to left to increase movement, or to right to decrease movement. When correctly positioned, tighten the two spreader driving eccentric screws first, hold flange against strap and tighten flange screws. Then refer to preceeding information regarding positioning of spreader.

CAUTION: When increasing sidewise movement, allow sufficient clearance between spreader driving rock shaft, Fig. 23, and left side of eccentric ball strap. They should not touch when eccentric ball stud is in its highest position.

ADJUSTING NEEDLE THREAD TAKE-UP

The needle thread take-up and thread guide may be adjusted to increase or decrease the amount of thread drawn at the top of the needle bar stroke. To increase the amount, loosen thread take-up set screw, Fig.24, and raise take-up or loosen guide screw and lower the guide. To decrease the amount, reverse the adjustment by lowering the take-up or raising the guide.

For average sewing conditions, the guide should be set with upper end 5/8 inch above the guide screw. The thread take-up should be set with the lower end 1/2 inch below the bottom of its holder.

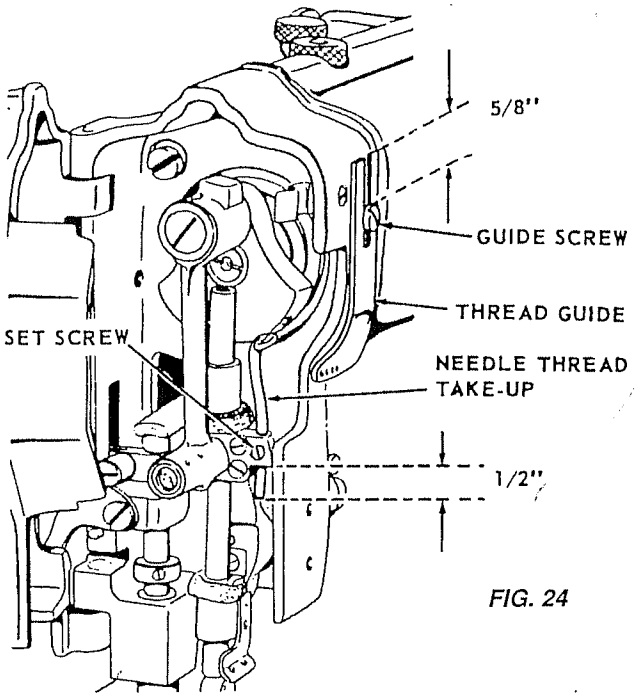


FIG. 24

ADJUSTING NEEDLE THREAD TENSION RELEASER

When correctly adjusted, the tension releaser should release tension on the needle thread when the presser foot is raised and allow full adjusted tension when presser foot is down. To adjust, loosen set screw, Fig. 25, and move tension releaser cap out for earlier release of tension, or in for later release. Hold in position and tighten set screw. Should the tension releaser not release tension at the correct time after making the above adjustments, loosen the tension releaser plate screw and move plate sidewise to correct position. Then tighten screw.

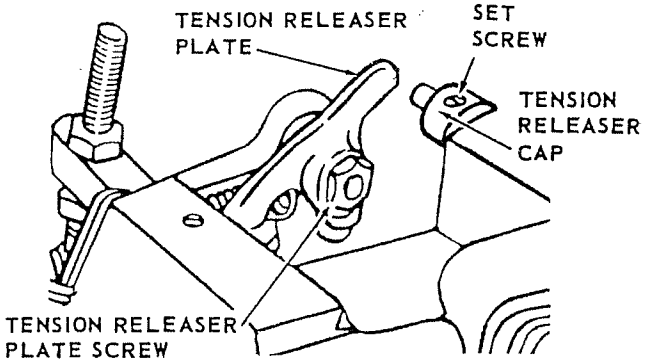


FIG. 25

ADJUSTING LOOPER THREAD TAKE-UP

The looper thread take-up and guide may be adjusted for handling more or less thread, according to thickness of material and length of stitch, and to change the ratio of looper thread in the finished stitch.

To change the amount of thread handled, loosen looper thread guide screw, Fig. 26, and looper thread take-up rod screw. Move thread guide and take-up rod to the left for more thread or to the right for less thread. Tighten the two screws making certain that take-up rod passes through the center of the guide yoke.

To change ratio of looper thread in finished stitch, loosen thread guide screw. Fig. 26, and lower the yoke or right end of thread guide for more thread. For less thread, raise end of guide. Hold in position and tighten guide screw.

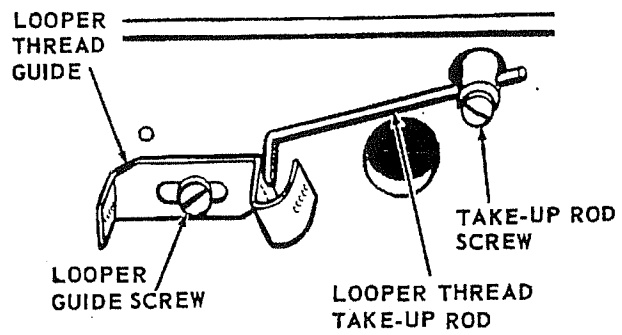


FIG. 26

OPERATING INSTRUCTIONS

The Porter Tape Edge Machine is designed to bind the full circumference of the mattress.

The heavy duty sewing head sews without bobbins and without interruption. It makes what is known as a 401 chain stitch using two threads. Due to the special construction of the sewing head, it sews with the walking feet close to the end of the arm. The binding tape is always under compression and requires a minimum of effort from the operator.

The PNR Tape Edge is provided with either 7/8" or 1 1/4" binder.

A combination of the head tilt and the power adjustment of the table height permits the closing of mattresses and cushions from 1" up to 11 1/4".

The clutch handle, located to the left of the starting switch, engages the carriage to the table. When the handle is vertical, the carriage is not in gear and will not move forward when the power is turned on.

When the clutch handle is in the horizontal position the carriage is engaged to the table and will move forward when the power is turned on.

To lock the carriage tight in place, there is a plunger type locking device located just below the clutch handle.

The general operation of the PNR Tape Edge is such that the forward movement of the carriage and the sewing head is governed by a knee pressure control. To move the carriage forward, the knee pressure is slowly released. By using this knee control, the operator has both hands free to handle the mattress top pad and border.

Once the mattress has been made ready for final assembly, it is placed on the PNR Tape Edge table. The operator should now properly set the table height for the thickness of the mattress. The table height can be adjusted by simply pulling the cord located just underneath the table top. Pull the cord to the right to raise the table and to the left to lower it.

Before starting to sew, the operator needs to lock the presser foot in the upper (open) position so that the mattress panel and quilted border can be pushed into the binder without difficulty. To release the presser foot from the upper (raised and locked) position, the operator needs only to push the lever with his elbow. This moves the presser foot down onto the material to be sewn. Again, the sewing head should be turned over by hand before sewing is to begin.

The operator should now move the clutch handle to the horizontal position to engage the carriage to the table. The operator will need to push the knee pad in before the power switch is turned on. This will prevent the carriagefrom traveling forward.

The operator can now withdraw the knee pressure gradually to move the carriage forward. If he needs to stop, he applies knee pressure on the pad to disengage the clutch.

The technique of a PNR Tape Edge operator is to handle the panel and the overedged border into the binder. When the material is well into the binder, the operator should be holding the panel and border several inches in front of the needle. As the sewing head travels toward the operator, his hands should continuously feed the panel and border into the binder. It is common that the inexperienced operator will stop the carriage every time he needs to move his hands. As experience is gained, longer stretches of tape will be sewn without stopping the machine. This experience will also help in making the corners.

In the PNR Tape Edge operation, the handling of the extra firm mattresses necessitate additional effort especially when the half way point is reached, because the mattress tightens up and is difficult to handle. At this point, it is essential for the operator to use the left elbow to draw the panel toward the needle to ease the pressure at the point of sewing. A combination of crawling fingers and the elbow technique aids in the non-stop sewing on the long seams.

The PNR Tape Edge is equipped with two motors. One is located at the bottom of the carriage to drive the carriage and the sewing head. The second is located under the table to raise and lower the table height depending upon the operator.

NOTICE TO OUR CUSTOMERS

PRICES AND TERMS

All prices are F.O.B. Beverly, MA, and are valid at the time of shipment.
All prices are list, unless otherwise noted.
Open account terms extended to firms with established credit.
All overseas orders must be paid before shipment.

TAXES

Where the law requires, state sales and/or use taxes must be charged.

SHIPPING

Please state how the shipment is to be made when ordering parts (UPS Red/Blue; Federal Express; Reg. UPS; air freight).
Freight charges are included in the invoice.
If a customer is on C.O.D. status, then shipping costs are included in the C.O.D. amount.

RETURNED GOODS

Porter Sewing has incorporated a policy on returned parts that must be strictly adhered to.

1. All customers must call Porter to obtain a RMA (Returned Material Authorization) number. Parts returned without a RMA number will be returned to the customer.
2. All parts to be returned must be shipped to Porter prepaid unless otherwise instructed by the Porter Parts Department.
3. Credit for parts will be issued upon inspection by Porter and credited against the account. Credit memos are not sent.
4. A restocking charge of 15% will be issued on parts ordered incorrectly by the customer.

CLAIMS

If a parcel post shipment reaches you in damaged condition, advise us immediately so that a claim can be filed. All parcel post packages are insured by Porter. If a truck, UPS or express shipment arrives damaged, request the driver to make a notation on the freight bill. If the damage was concealed at the time of delivery, call the carrier for an inspection and obtain a "DAMAGE REPORT". This is necessary in order to file a claim. In the case of truck lines, you must file the claim. We will give any needed assistance, but the carrier is responsible for the safe arrival of your goods.

MINIMUM ORDERS

Due to the rising costs of handling orders, we have established a minimum order of $25.00.

ORDERING INFORMATION

Fax and Telex available 24 hours per day

To order by Fax: 1 (617) 599-70811

To order by phone : 1 800 343-8138

To order by Telex: 383818.

To order by mail: Porter Sewing Machines, Inc.
97 Rantoul Street
Beverly, MA 01915

NOTICE

To assist us in handling your order, please have the following information ready when ordering:

1. Customer Number
2. Bill to and Ship to addresses
3. Fax Number
5. Person placing order
6. Machine Model Number
7. Part Number or complete part description.

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PNR-469	SPREADER, STEEL	31
PNR-470	STANDARD NEEDLE, FOR REGULAR WORK	23
PNR-474	BODY - TAPE TENSION	
PNR-475	PLATE - TAPE TENSION	
PNR-476	FIELD ASSEMBLY	
PNR-478	PIPING GUIDE BASE PLATE	
PNR-480	PIPING GUIDE	
PNR-481	BEARING	29
PNR-482	NEEDLE BAR, STEEL	23
PNR-484	THREAD GUIDE	24
PNR-485	BINDER SWING PLATE STOP	30
PNR-486	FOOT LIFTER LEVER	26
PNR-488	ASSEMBLY - THROAT PLATE	
PNR-489	BINDER ASSEMBLY 1 3/4" RUCHING	
PNR-490	GUIDE - 1 3/4" RUCHING	
PNR-491	PULLEY - ARM SHAFT TIMING PULLEY	24
PNR-492	FLANGE-TIMING PULLEY (PART OF PNR-491)	
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PNR-494	BELT-ARM SHAFT-TIMING ASSEMBLY	
PNR-496	ASSY., BINDER HEAD & TAPE TENS. ON BRKT.	30
PNR-499	COVER SCREWS	30
PNR-501	SCREW	30
PNR-502	PRESSER BAR SPRING ARM FULCRUM	25
PNR-505	ASSY.-PRESSER BAR PRESSURE CONTROL	26
PNR-506	ADAPTOR FOR PNR-505	26
PNR-520	ALTERNATE GEAR BOX	
PNR-521	ALTERNATE SWIVEL	
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PART #	DESCRIPTION	PAGE #
PNR-601	ELEVATING SCREW TOP PLATE, STEEL	39
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PAT-29	WHEEL SPACER, STEEL (FOR SHEAVE #7151)	39
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PBM-430	THREAD SPOOL HOLDERS, STEEL	34
PBEE-197	FOOT, STEEL (FOR PNR-301)	39
PD-6	THRUST BEARING (FOR PNR-38)	34
PD-650	COMPLETE SWIVEL (BANJO) ASSY. 4 WIRE	
PDBM-337	KEY, STEEL (PNR-9 TO PNR-4)	32
PDBM-338	KEY STEEL (MAIN SHAFT TO PNR-22)	37
PN-9	FEED CLUTCH, STEEL	37
PN-2-B	NUT - TENSION LOCK	
PN-691	CLUTCH RELEASE HANDLE, BRASS	35
PN-740	TAPE REEL, STEEL	30
PNR-465R	PIPING ATTACHMENT ASSEMBLY	
PNR-465A-R	PIPING GUIDE ASSEMBLY	
PNR-720-S	TABLE EXTENSION ASSEMBLY	
PUTS-1-T	UNDER TABLE SWIVEL (FACTORY ASSEMBLY)	
PNR717-R	QUICK REVERSE 1 1 ASSY. (FACTORY ASSY.)	
259553-5/8	WIDE MOUTH BINDER	
259553-9/16	WIDE MOUTH BINDER	
259553-7/8	WIDE MOUTH BINDER	
250549-5/8	NARROW MOUTH BINDER	
250549-9/16	NARROW MOUTH BINDER	
250549-7/8	NARROW MOUTH BINDER	
97-23253	OIL CAN	

STANDARD PARTS

23308	SCREW DRIVER
4803	WRENCH FOR#3&#4 HEX. SOC. SET. SCREWS
66	SCREW
101	SCREW, STEEL
102	LOCKWASHER
105	WASHER, STEEL
106	NUT
107	WASHER
108	WASHER, SPEC., STEEL (FOR JOINT #1658)
109	NUT, STEEL
110	SCREW, STEEL
113	SCREW, STEEL
115	NUT, STEEL
116	LOCKWASHER, STEEL
117	WASHER, STEEL, SPECIAL (FOR PNR-97)
119	WASHER,STEEL,SPEC. (PNR-40 TO PNR-2-T)
120	LOCKWASHER, STEEL
129	COTTER PIN, STEEL
138	SCREW
148	NUT

PART #	DESCRIPTION	PAGE #
160	SCREW,STEEL	
164	COMPRESSION ELBOW	
172	SCREW	
174	NUT, STEEL	
177	SCREW, STEEL	
181	WASHER, STEEL, SPECIAL	
193	LOCKWASHER, STEEL	
198	KEY, STEEL	
199	SCREW	
214	SCREW	
229	BOLT	
234	WASHER,ST.-SPEC. (FOR PNR-89)	
238	LOCKWASHER, STEEL	
261	SCREW, STEEL	
262	PIPE PLUG, STEEL	
268	SCREW, STEEL	
270	NUT, STEEL	
282	NUT, STEEL	
302	SCREW	
319	NUT, STEEL	
331	NUT, STEEL	
350	SCREW, STEEL	
353	SCREW	
356	SET SCREW, STEEL	
364	SCREW	
367	WASHER	
368	SCREW, STEEL	
416	SCREW, STEEL	
418	SCREW	
428	PIPE PLUG	
446	SCREW, STEEL	
494	SCREW, STEEL	
500	SCREW, STEEL	
522	SCREW	
525	SCREW	
645	TAPER PIN	
648	LOCK WASHER	
694	SCREW, STEEL	
705	SCREW, STEEL	
746	SCREW, STEEL	
749	SCREW, STEEL	
751	SCREW, STEEL	
760	SCREW, STEEL	
771	SCREW, STEEL	
813	WASHER, STEEL	
815	LOCKWASHER, STEEL	
877	SCREW, STEEL	
1028	FLEXIBLE CONDUIT (BOX TO BOX)	
1028	FLEXIBLE CONDUIT (SWITCH BOX TO MOTOR)	
1132	STEEL CONNECTOR	
1153	VERT. SHAFT UPPER BEARING W/ COLLAR	
1307	MALE CAP WITH CORD GRIP	

PART #	DESCRIPTION	PAGE #
1309	FLUSH BASE-FEMALE	
1318	OIL GAUGE	
1360	NIPPLE, STEEL (UTILITY BOX TO MOTOR)	
1367	OIL CUP	
1542	RETAINING RING, STEEL	
1630	RETAINING RING, STEEL	
1632	LOCKWASHER, STEEL, SPECIAL	
1633	SCREW, STEEL	
1634	BUSHING, BRONZE	
1635	COLLAR, STEEL	
1636	SCREW, STEEL	
1637	SCREW, STEEL	
1638	SCREW, STEEL	
1640	SCREW, STEEL	
1641	SET SCREW, STEEL	
1642	SET SCREW, STEEL	
1643	LOCKWASHER, STEEL, SPECIAL	
1645	PIN, STEEL	
1647	RIVET, STEEL	
1648	BALL JOINT W/ MALE AND FEM. ENDS	
1650	NEEDLE BEARING, STEEL	
1651	SCREW, STEEL	
1655	THUMB SCREW, STEEL	
1661	MICRO SW., SINGLE PH./TABLE PNR-318N	
1665	SCREW	
1685	CONDUIT	
1687	SET SCREW	
1688	SET SCREW	
1711	SCREW	
1720	FLUSH BASE, MALE	
1721	REVERSING SWITCH	
1722	COVER, UTILITY BOX	
1723	CONNECTOR BODY, FEMALE (4 WIRE)	
1725	UTILITY BOX	
1743	WIRE CAP	
1752	NUT FOR WIRE CONNECTOR	
1773	WIRE CAP	
1854	BEARING	
1909	CONNECTOR	
1911	SCREW	
1921A	SWITCH	
1922	TRANSFORMER	
1959	REDUCER	
1992	SWITCH ENCLOSURE	
1994	KNOB (PLASTIC)	
2036	BEARING FOR CASTER ROLLER	
2076	CONNECTING LINK	
2084	LAMP	
2126	ROMEX CONNECTOR	
2127	CONNECTOR	
2306	SCREW, STEEL	
2438	PIPE PLUG (VENT)	

PART #	DESCRIPTION	PAGE #
2466	HOSE CLAMP	
2472	CONTACT KIT (REP. PARTS)	
2814	LIMIT SWITCH	
2839	CABLE	
2989	SEAL	
3060	LUBRICANT/(PNR-3-T GEAR BOX)	
3100	SET SCREW	
3236	BOLT	
3901	VALVE	
4237	CABLE TIE	
4676	BEARINGS	
4678	BEARINGS	
5108	SPRING PLUNGER	
5182	NAME STICKER	
5711	SCREW	
5744	SCREW, STEEL	
5763	SCREW	
5887	JAM NUT, STEEL	
5893	SCREW, STEEL	
5988	JAM NUT, STEEL	
5997	JAM NUT, STEEL	
6018	SCREW	
6034	SCREW, STEEL	
6067	JAM NUT, STEEL	
6076	LOCKWASHER	
6139	JAM NUT, STEEL	
6171	WASHER, STEEL	
6201	SET SCREW	
6205	SCREW, STEEL	
6219	SCREW	
6243	SCREW, STEEL	
6266	SET SCREW, STEEL	
6287	JAM NUT, STEEL	
6315	SCREW	
6348	RETAINING RING, STEEL	
6357	NUT	
6360	NUT	
6373	WASHER, STEEL	
6410	SET SCREW, STEEL	
6451	NUT, STEEL	
6493	CAP SCREW, STEEL	
6494	SCREW, STEEL	
6526	SET SCREW, STEEL	
6531	SET SCREW, STEEL	
6601	SET SCREW, STEEL	
6631	SCREW, STEEL	
6633	SCREW, STEEL	
6645	SCREW	
6657	SCREW	
6678	LOCKWASHER, STEEL, SPECIAL	
6731	DOWEL PIN, STEEL	
6748	SET SCREW	

PART #	DESCRIPTION	PAGE #
6753	SCREW, STEEL, SOCKET	
7019	LOCK NUT, STEEL	
7024	BX CONNECTORS	
7100	SET SCREW, STEEL	
7102	SCREW, STEEL	
7106	ROLL PIN, STEEL	
7114	SCREW, STEEL	
7123	CLIP	
7136	CONNECTOR (REV. SWITCH & UTILITY BOX	
7151	REV. SWITCH CORD SHEAVE WHEEL, STEEL	
7152	SET SCREW, STEEL (FOR DOWEL #1644)	
7172	SET SCREW	
7177	ROLL PIN, STEEL	
7199	DOWEL PIN, STEEL (BED TO ARM)	
7220	SET SCREW, STEEL	
7221	SET SCREW, STEEL	
7233	SET SCREW, STEEL HEX, SOCKET	
7245	ELEVATING THRUST BEARING, STEEL	
7253	ROLL PIN	
7283	OIL CUP COVER	
7368	SET SCREW, STEEL	
7485	BEARING	
7508	CLIP	
14462	KEY, STEEL	
14625N	REPLACEMENT KEY	
16561	KEY, STEEL	
D663	WIRE, 3 PHASE LINE TO TABL	

PNR - ACCESSORY PARTS

PNR-721	EXTENSION - TABLE
PNR-724	STOP - TABLE EXTENSION
PNR-727	CHAIN - EXTENSION STOP
2466	CLAMP - STOR (FOR PNR-721-N)

SPECIAL PIPING ATTACHMENT

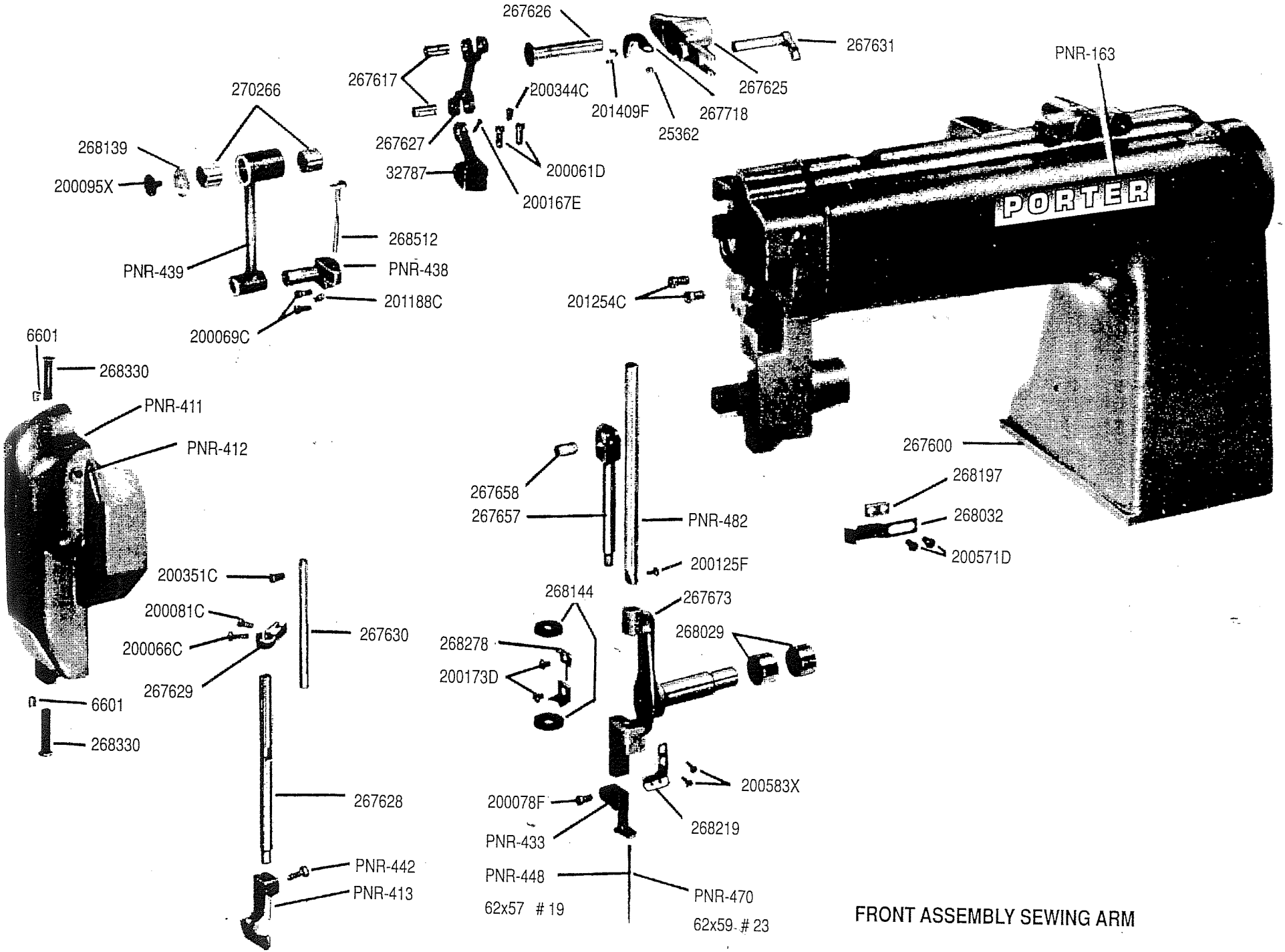
PART #	DESCRIPTION
PNR-449A	PLATE FOR 1 3/8 BINDER (1 7/16 TAPE)
PNR-450A	3/8 BINDER - PIPER 1 7/16 TAPE & ROVING
PNR-457	PIPING SUPPORT
PNR-458	PIPING GUIDE RING BRACKET
PNR-459	BRACKET PIPING REEL HOLDER
PNR-460	STUD-PIPING REEL HOLDER BRKT.
PNR-461	PIPING REEL HOLDER
PNR-474	BODY - TAPE TENSION
PNR-475	PLATE - TAPE TENSION
PNR-478	BASE PLATE PIPING GUIDE
PNR-480	ASSEMBLY - PIPING GUIDE
364	SCREW
648	LOCKWASHER
877	SCREW

PART #	DESCRIPTION	PAGE #
1073	SCREW	
1774	SCREW	
1841	SCREW	
1990	ROLL PIN	
2171	MACHINE SCREW	
6067	NUT	
6219	SCREW - TAPE TENSION ADJUSTING	
7230	SCREW	
PN-21B	NUT TAPE TENS. LOCK (COTTON TUFTER PT.)	
PSM-163A	SPRING - TAPE TENSION	

UNDER TABLE SWIVEL

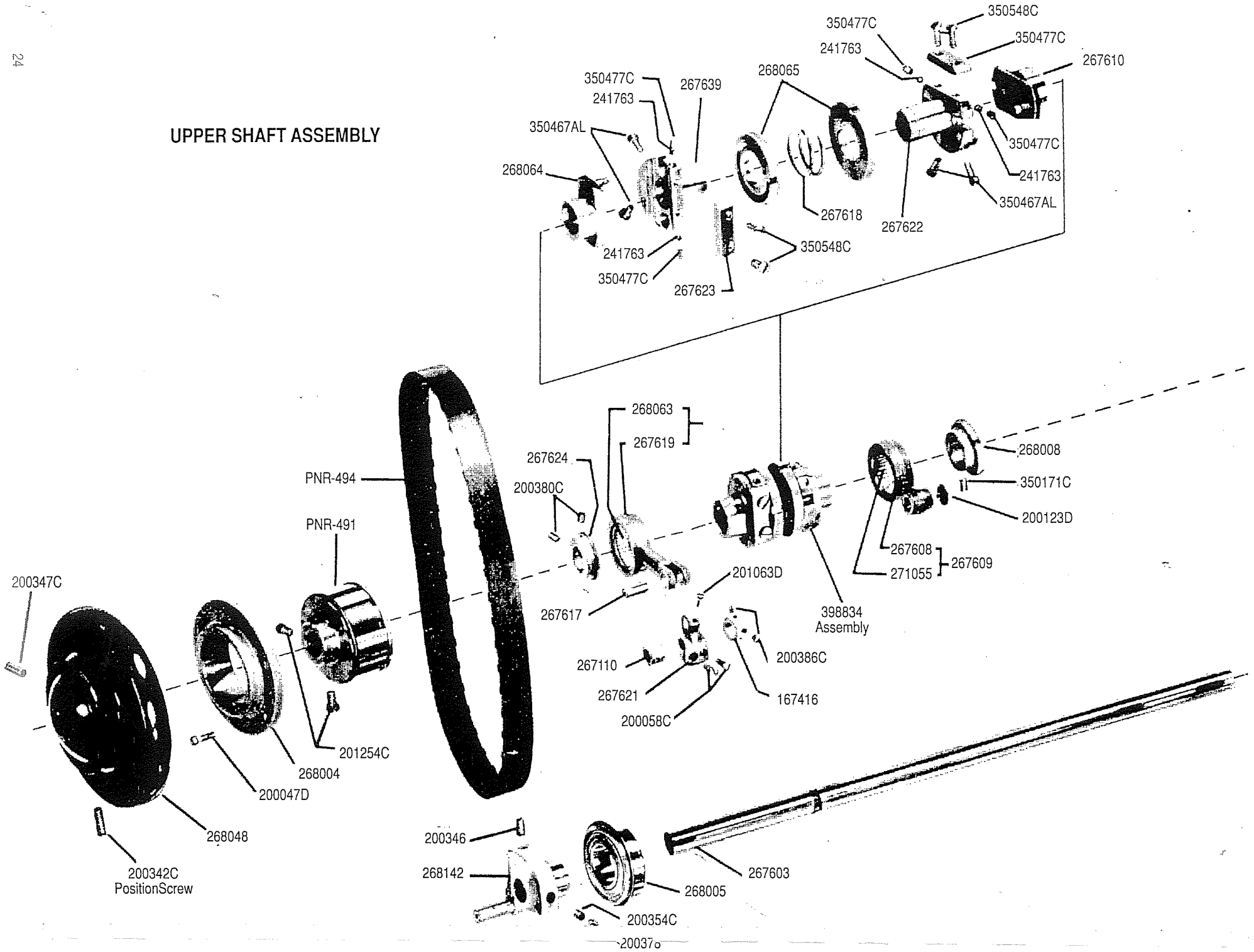
PUTS 2	ELEVATOR - UNDER TABLE SWIVEL	
PUTS 3	SUPPORT - TABLE TOP	
PUTS 4	ELEVATING SCREW	
PUTS 5	ELEVATING NUT	
PUTS 6	SPROCKET - ELEVATING SCREW	
PUTS 11	BRUSH BLOCK	
PUTS 12	BRUSH ASSEMBLY	
PUTS 13	BRUSH	
PUTS 14	BRUSH CAP	
PUTS 15	BRUSH HOLDER	
PUTS 16	INSULATING SHEET	
PUTS 17	SLIP RING	
PUTS 18	SPACER BUTTON	
PUTS 19	ELEVATOR INSULATOR	
PUTS 20	SPRING - BRUSH HOLDER CONTACT	
PUTS 21	COVER - TOP & BOTTOM	
PUTS 22	ENCLOSURE - SLIP RING	
PUTS 23	COVER - ENCLOSURE	
PUTS 24	FELT - COVER SEAL	
PUTS 25	ROD - SLIP RING CLOSURE	
PUTS 26	SLEEVE - BEARING SPACER	
PUTS 27	STUD - SLIP RING CONTACT	
PUTS 28	BRACKET - REVERSING SWITCH	
PUTS 29	EXTENSION - SWITCH SHAFT	
PUTS 31	BRACKET - EXTENSION CORD	
PUTS 32	BRACKET - EXTENSION CORD - SHORT	
PUTS 33	GUARD - EXTENSION CHAIN	
PUTS 35	TUBE - EXTENSION CORD	
PUTS 41	WIRE	
PUTS 42	WIRE	
PUTS 43	WIRE	
PUTS 44	WIRE	
PUTS 45	BRACKET - FLEXIBLE CONDUIT	
PUTS 46	WIRE	
PUTS 47	WIRE	
PUTS 48	WIRE	
PUTS 49	WIRE	
102	LOCKWASHER	
106	NUT	

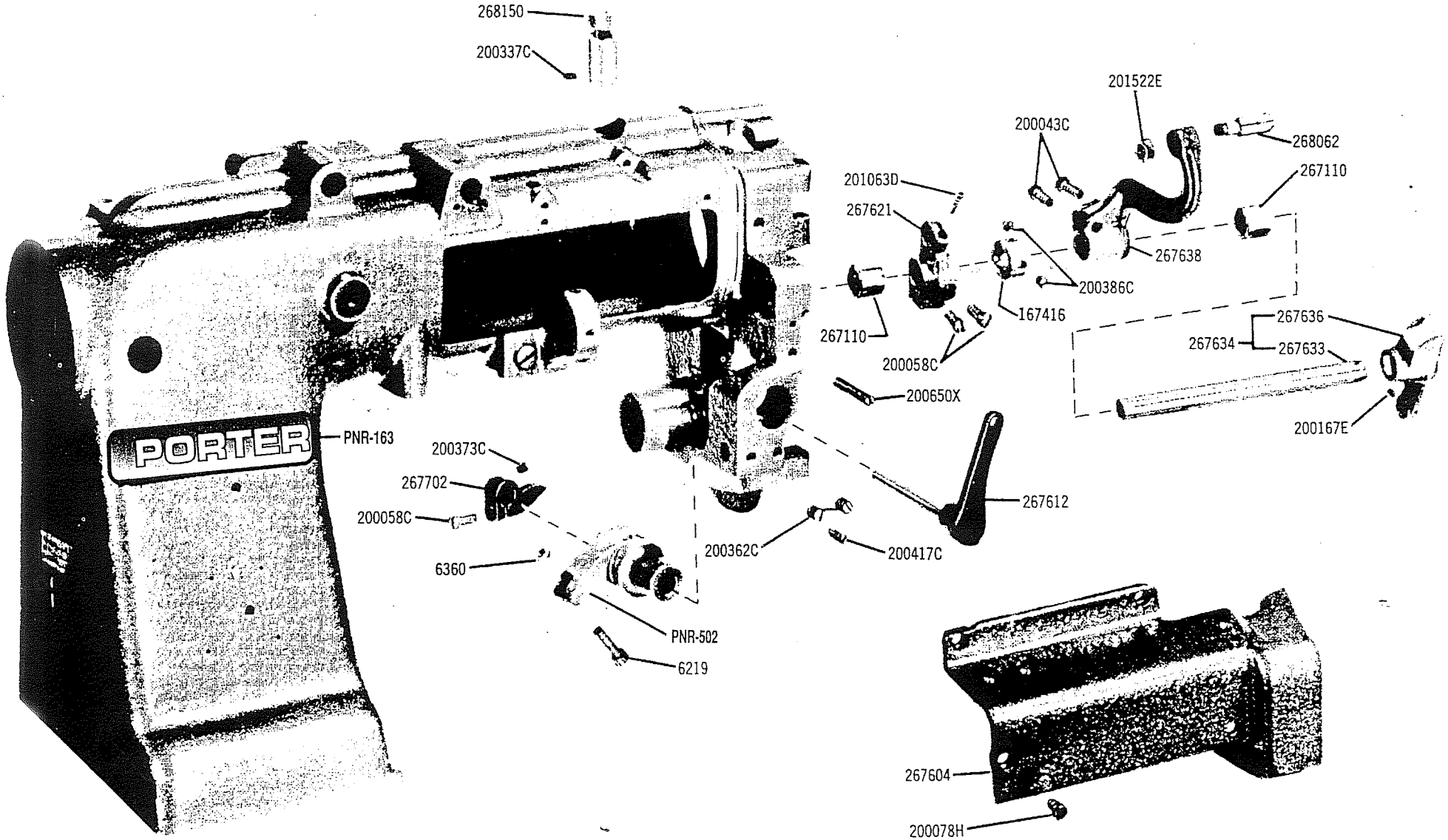
PART #	DESCRIPTION	PAGE #
115	NUT	
116	LOCKWASHER	
119	WASHER	
120	LOCKWASHER	
151	BOLT	
232	BOLT (UTS21 TO UTS11)	
273	BOLT	
282	NUT	
287	BOLT	
301	SCREW (BRG. TO UTS 2 COLUMN)	
372	NUT	
393	BOLT	
500	SCREW	
522	SCREW	
691	BOLT	
815	LOCKWASHER	
1027	CONNECTOR	
1028	CONDUIT	
1058	ARM SLIP RING CLOSURE/44 1/2 WIDE TABLE	
1132	CONNECTOR W/NUT, FLEXIBLE	
1360	CHASE NIPPLE	
1471	FITTING	
1661	MICROSWITCH	
1685	FLEXIBLE CONDUIT	
1686	90 CONNECTOR	
1689	UTILITY BOX	
1721	REVERSING SWITCH	
1722	COVER	
1725	UTILITY BOX	
1909	CONNECTOR	
1981	CONNECTOR	
2558	TAPER PIN	
2953	CORD SLIP RING CLOSURE SWIVEL	
3059	SCREW	
3080	90 ELBOW	
5702	BOLT (BRG. TO UTS 21 COVER)	
5857	ARM - SLIP RING CLOSURE	
6050	SET SCREW	
6076	LOCKWASHER	
6171	WASHER	
6360	NUT	
6427	SCREW	
6451	NUT	
6526	SET SCREW	
6574	SCREW	
6657	SCREW	
7019	LOCKNUT	
7024	CONNECTOR	
7131	COVER	
7136	CONNECTOR W/ NUT	
7221	SET SCREW	
7485	BEARING	



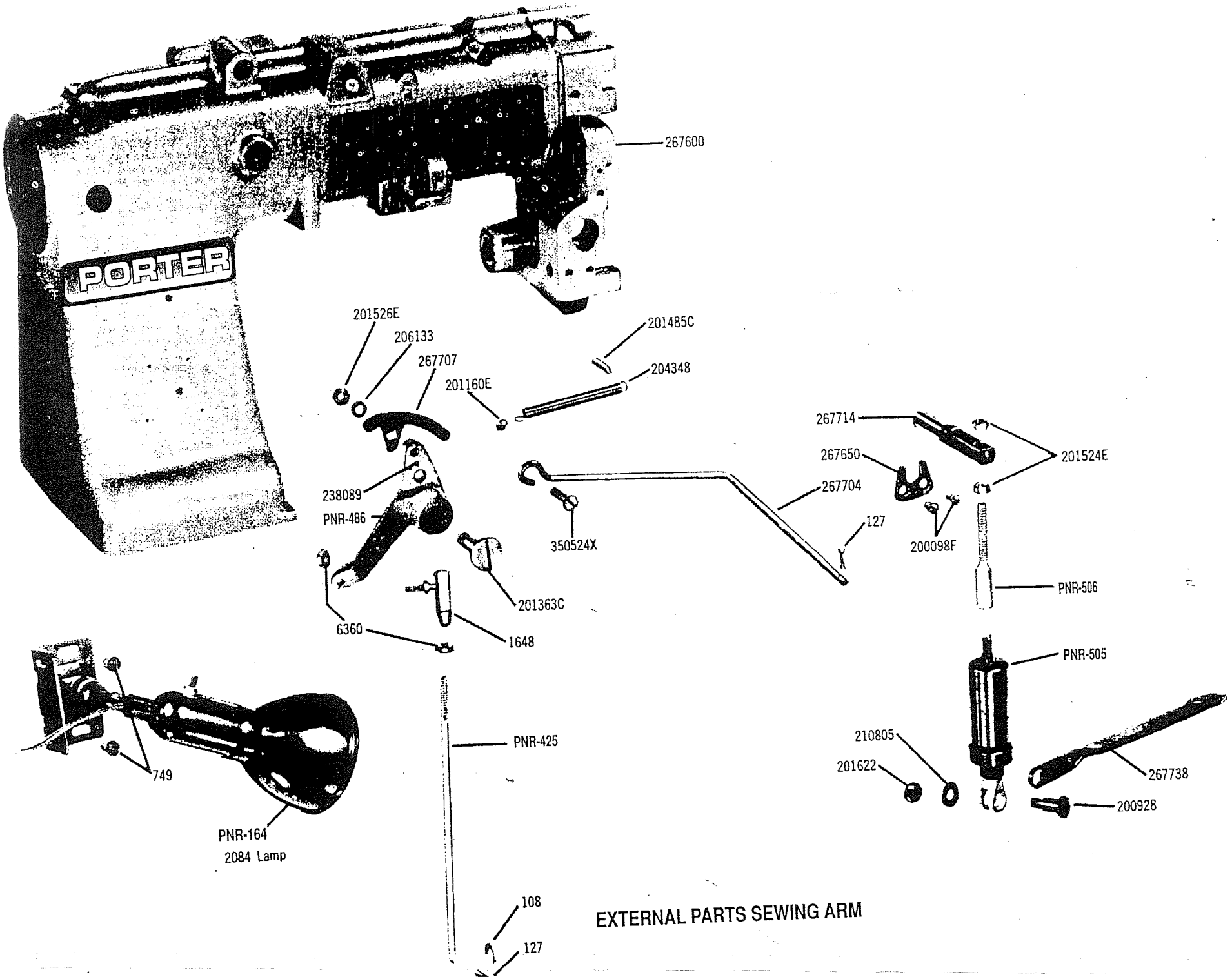
FRONT ASSEMBLY SEWING ARM

UPPER SHAFT ASSEMBLY

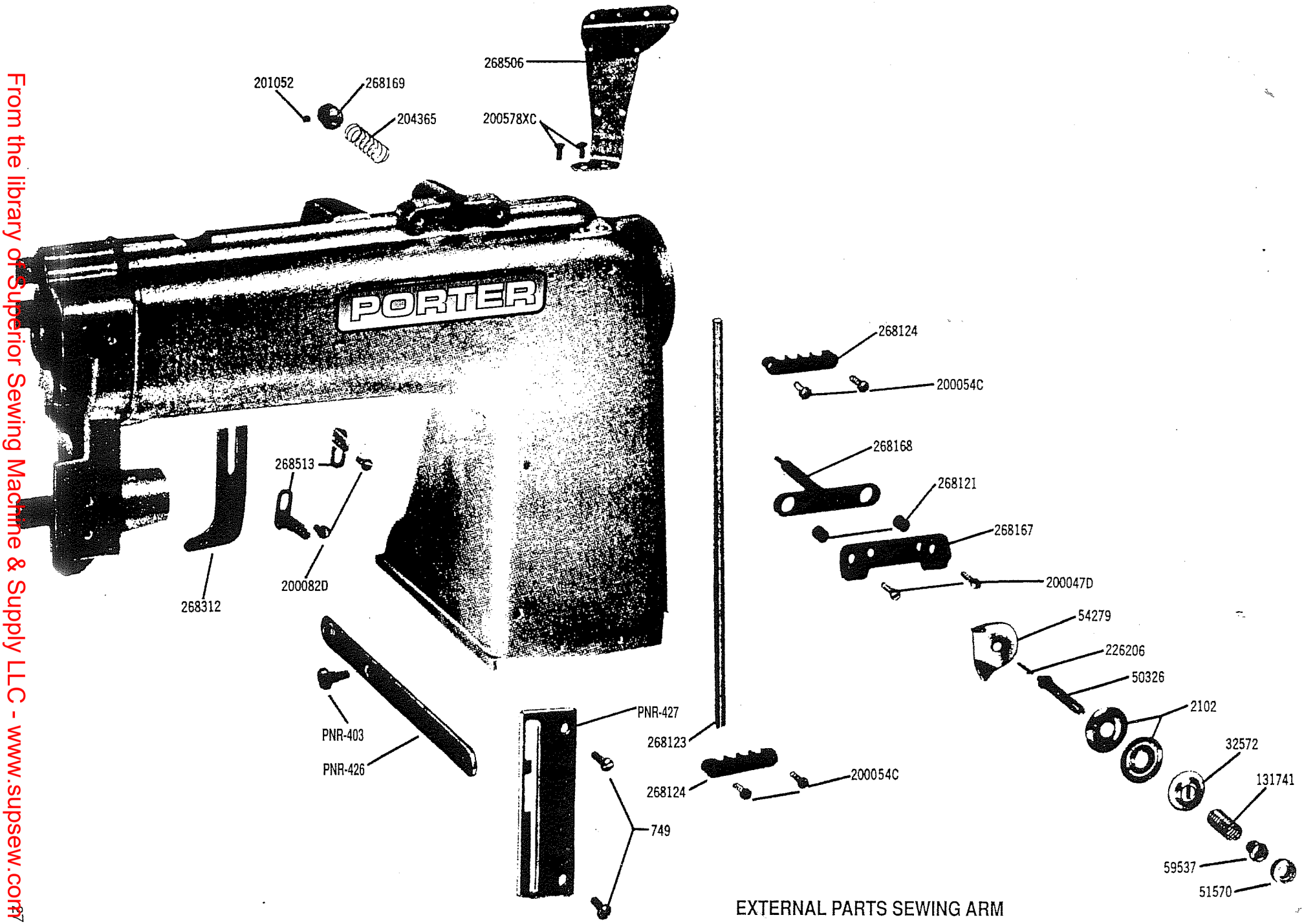




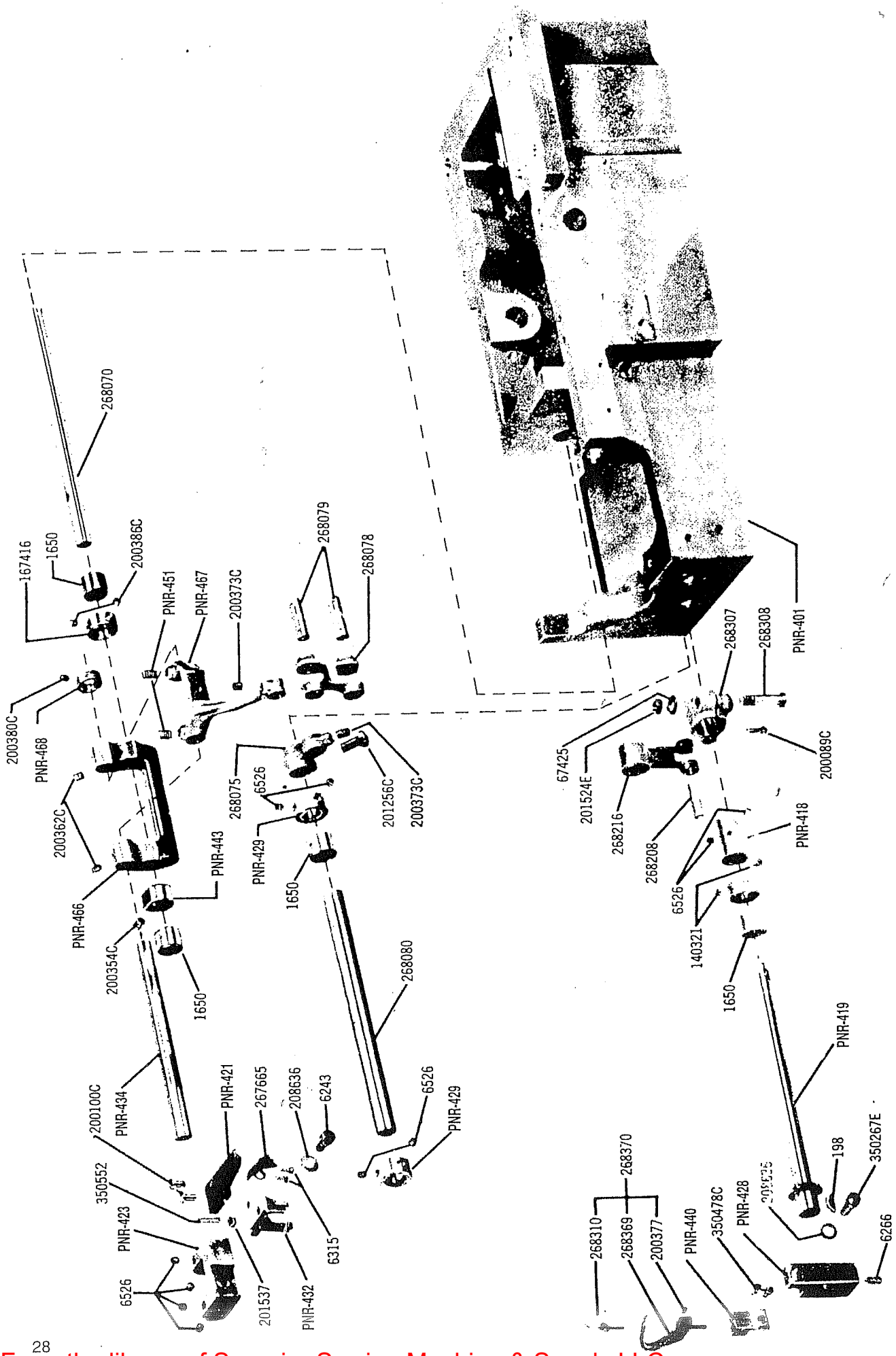
EXTERNAL PARTS SEWING ARM



EXTERNAL PARTS SEWING ARM

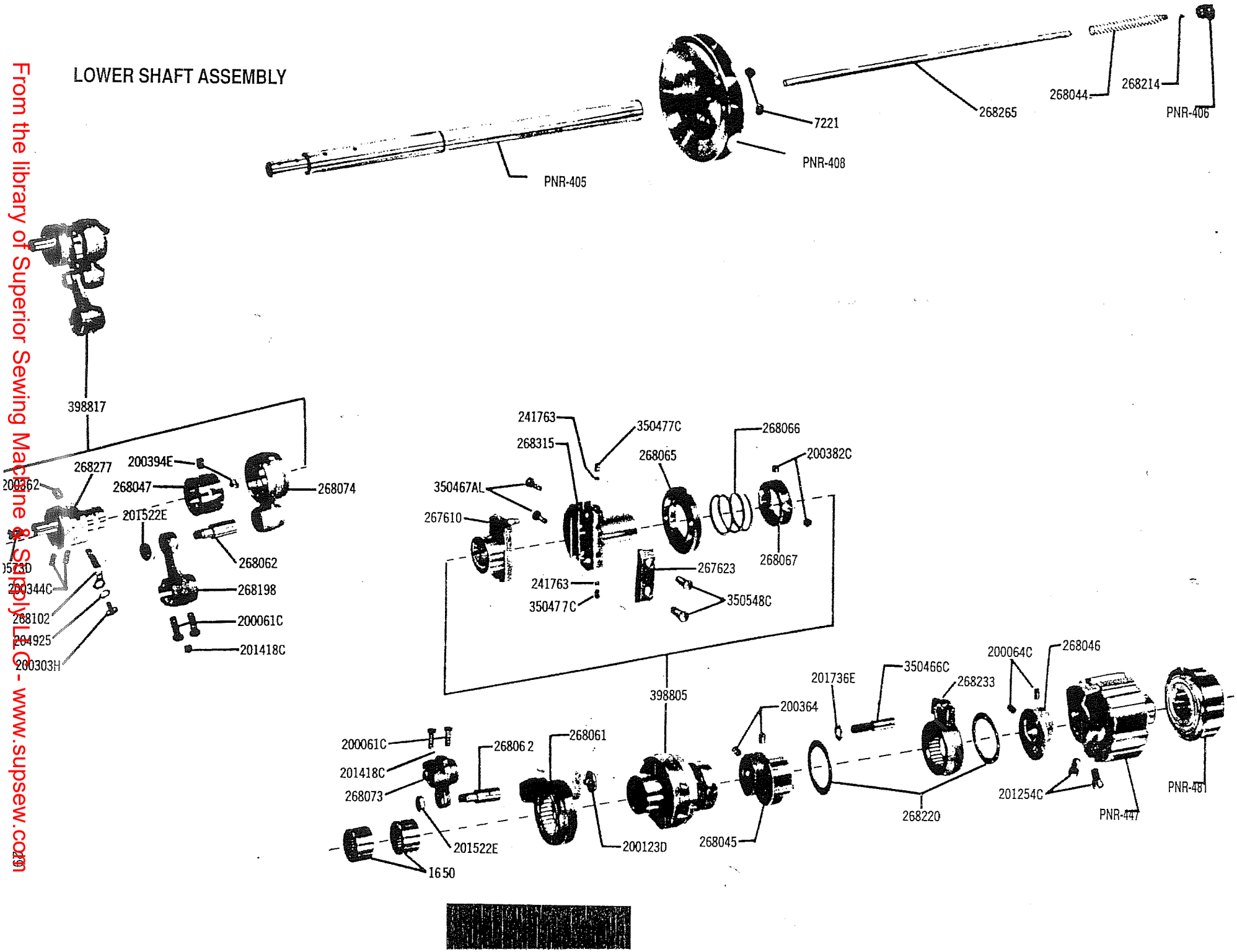


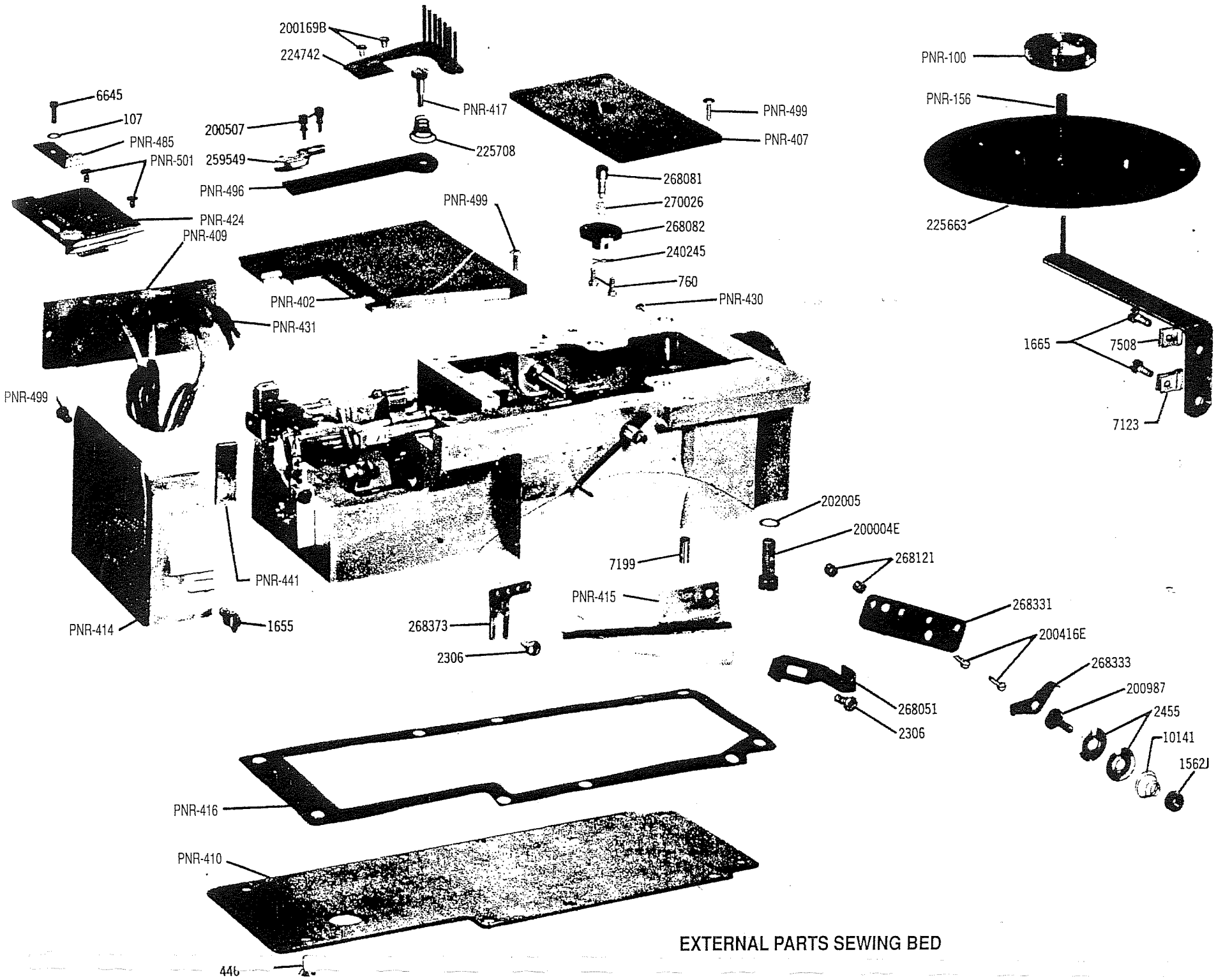
EXTERNAL PARTS SEWING ARM



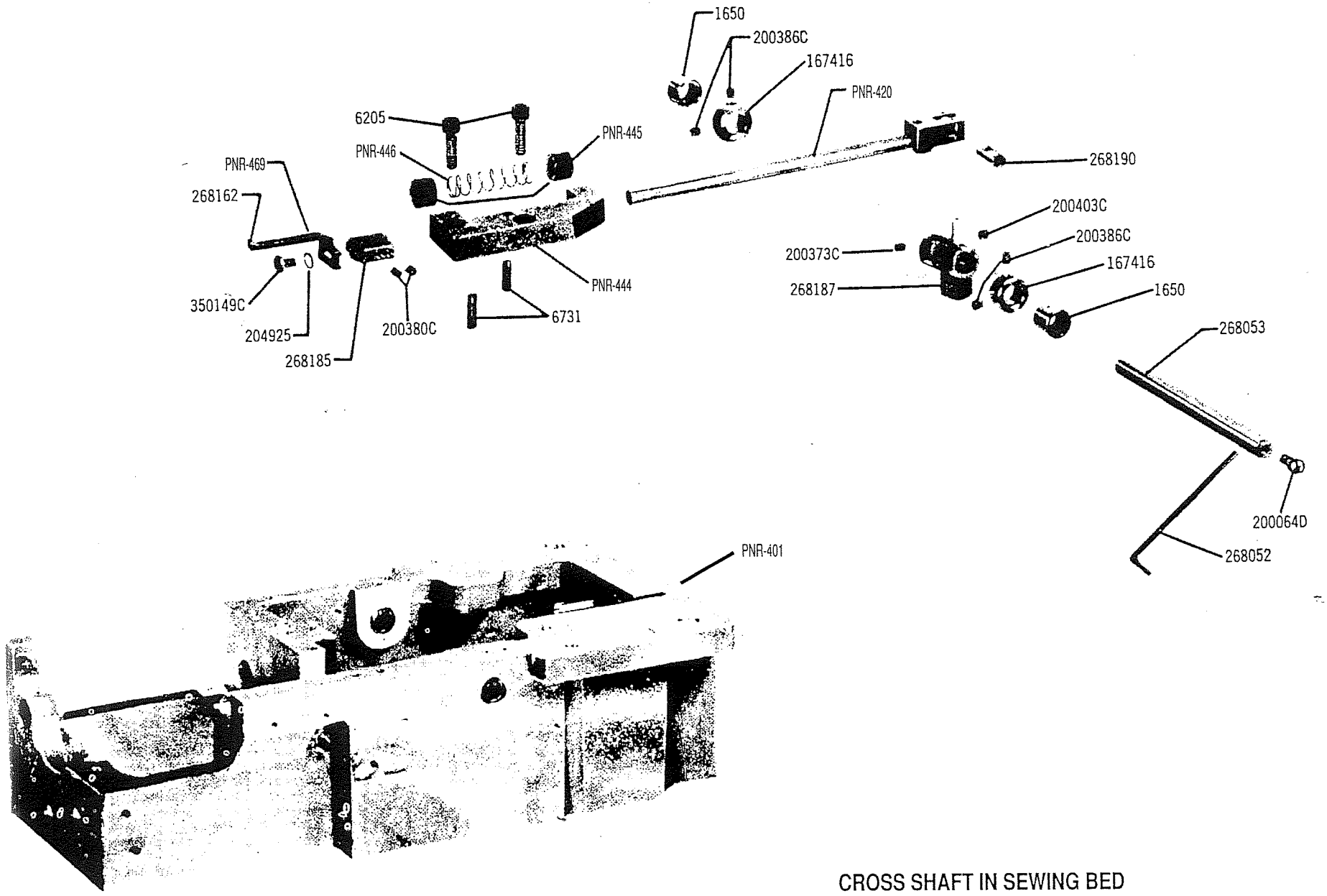
FRONT ASSEMBLY SEWING BED

LOWER SHAFT ASSEMBLY

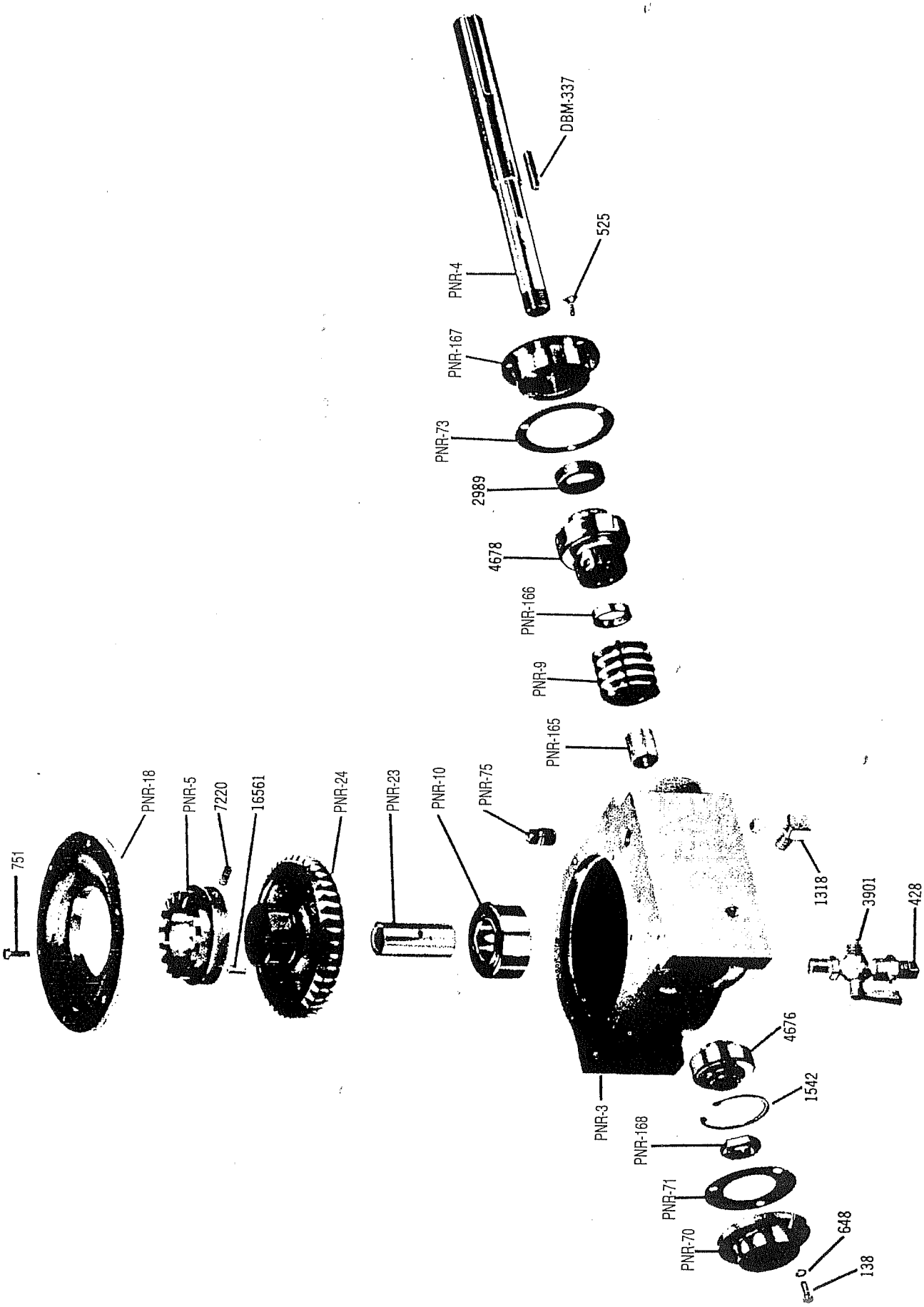




EXTERNAL PARTS SEWING BED

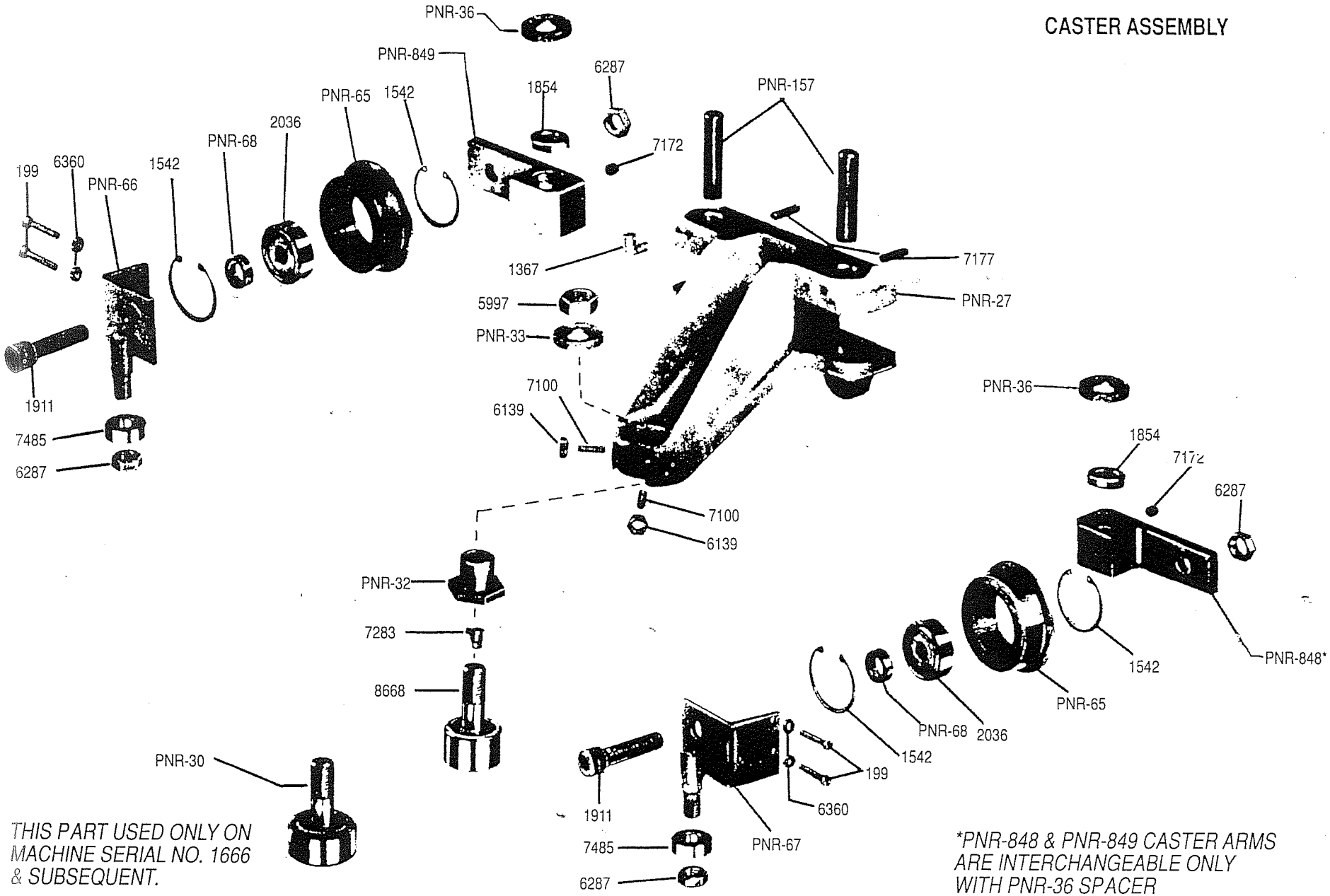


CROSS SHAFT IN SEWING BED



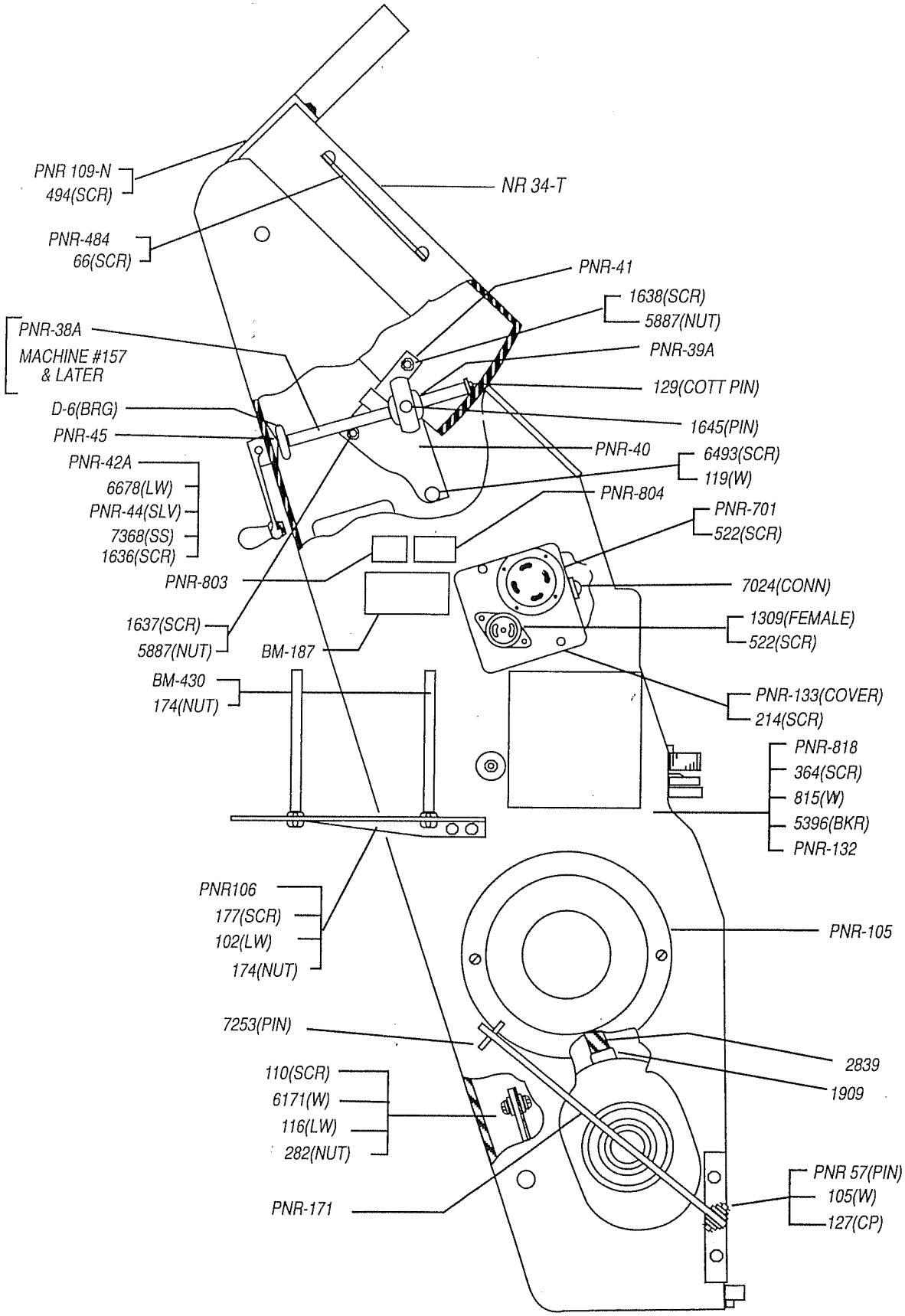
GEAR BOX ASSEMBLY

CASTER ASSEMBLY

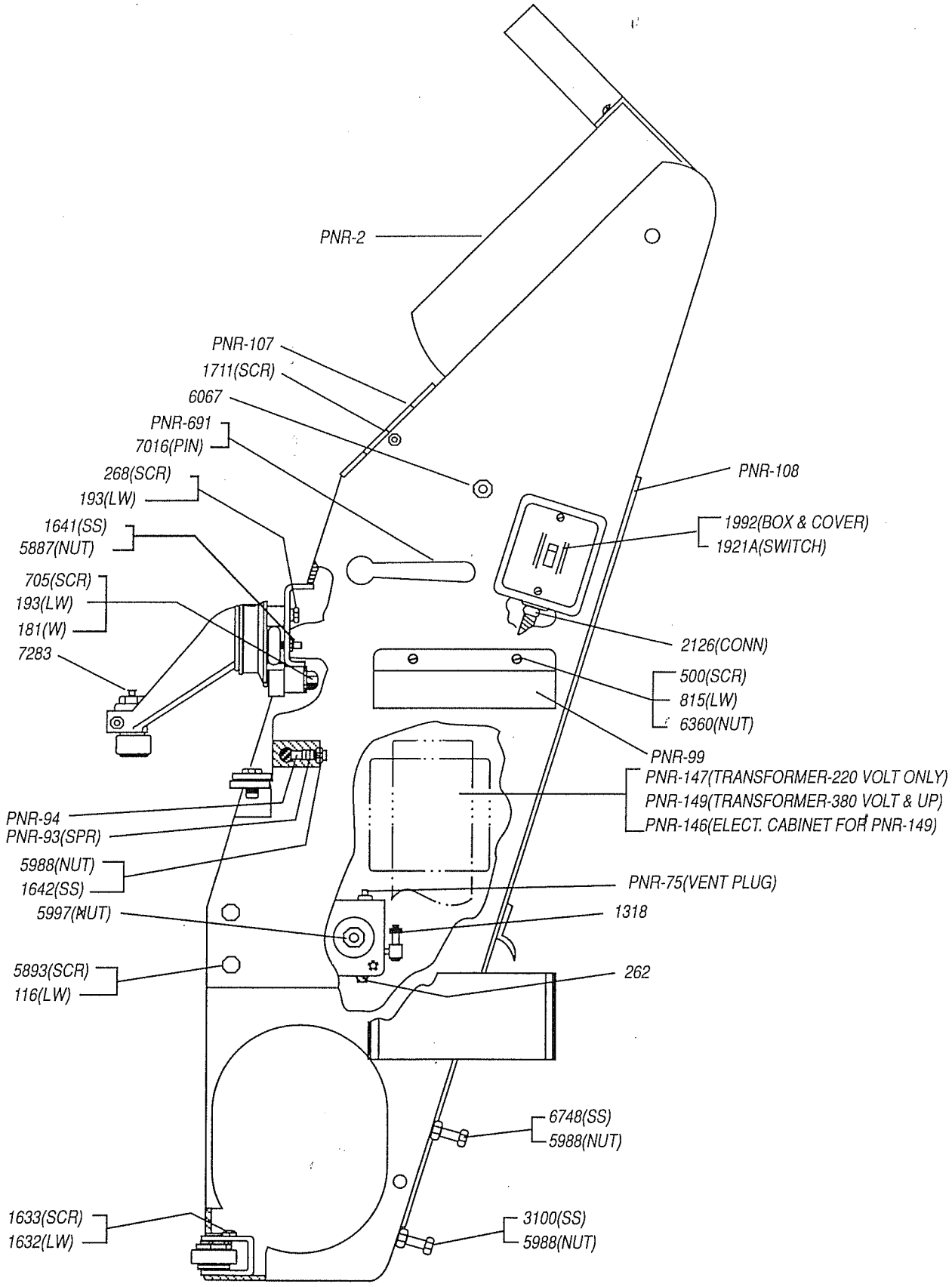


THIS PART USED ONLY ON MACHINE SERIAL NO. 1666 & SUBSEQUENT.

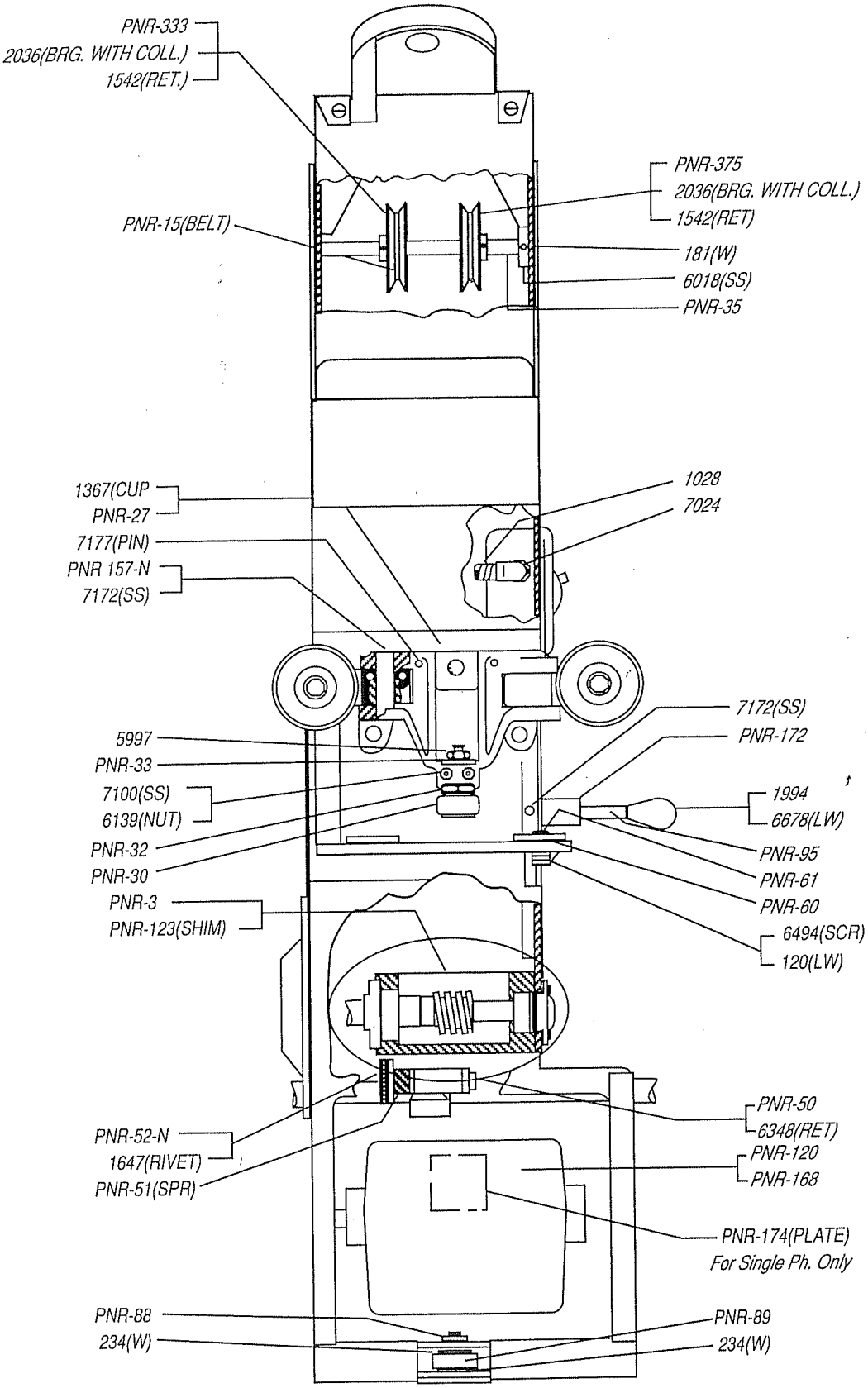
**PNR-848 & PNR-849 CASTER ARMS ARE INTERCHANGEABLE ONLY WITH PNR-36 SPACER*



MAIN DRIVE ASSEMBLY



MAIN DRIVE ASSEMBLY



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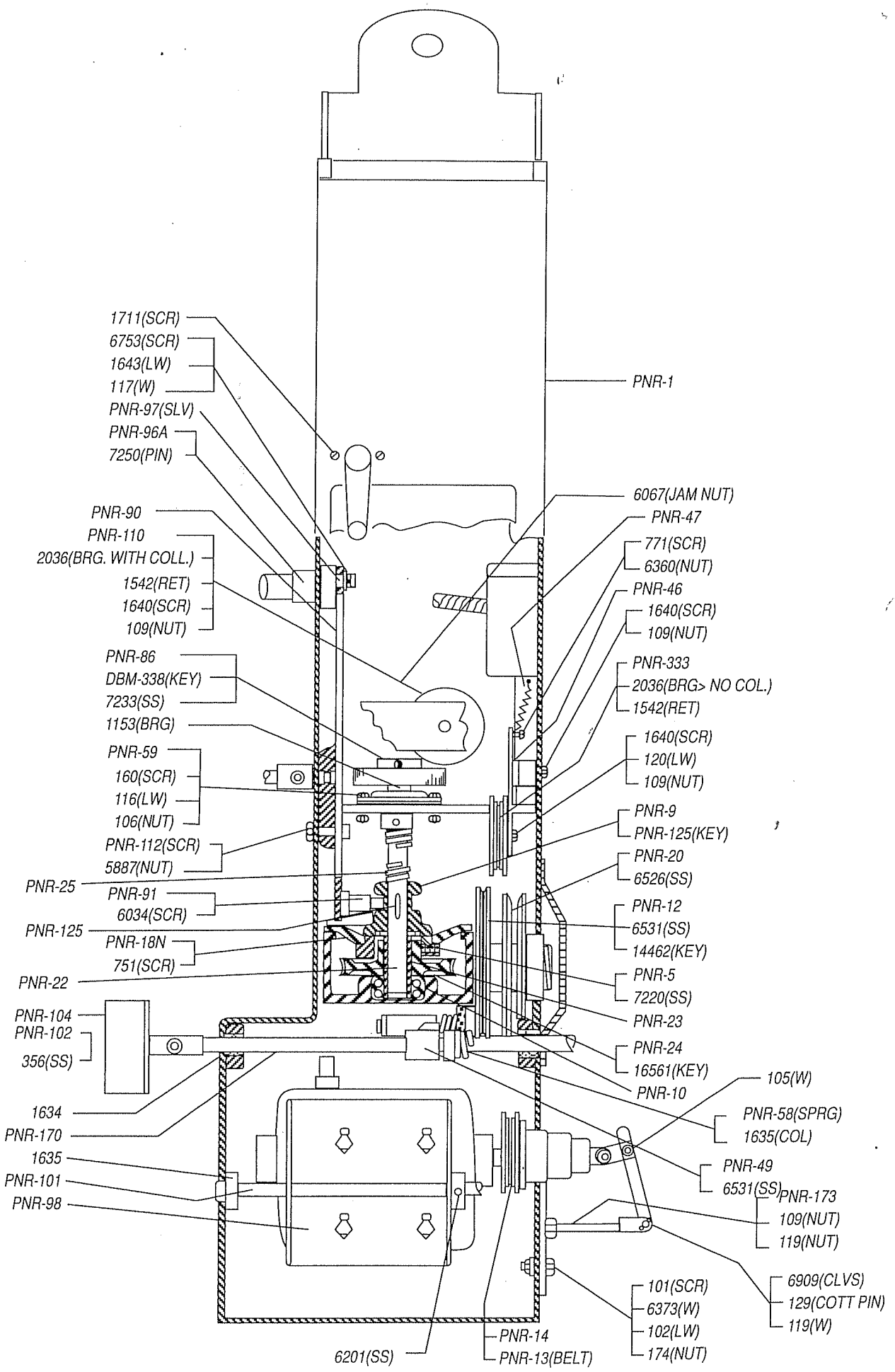
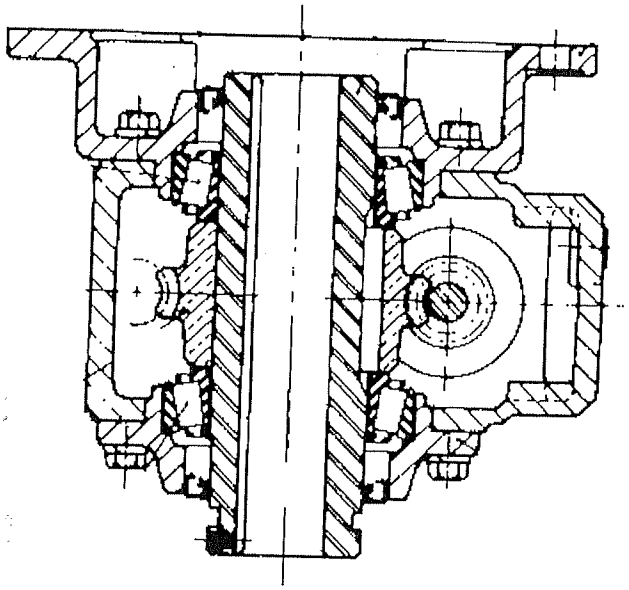
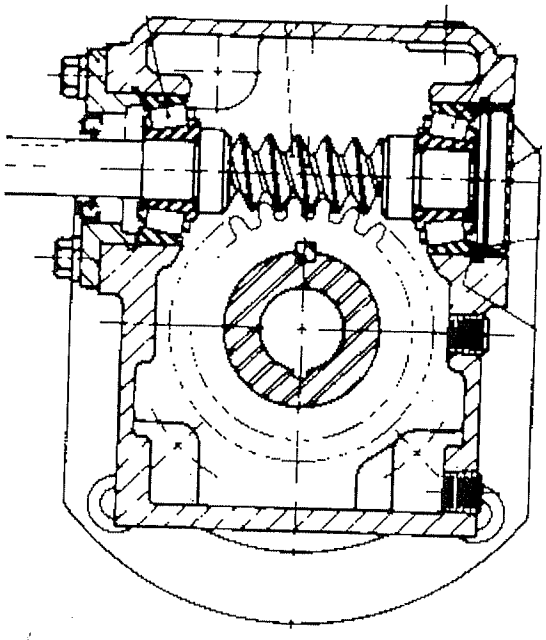


MAIN DRIVE ASSEMBLY

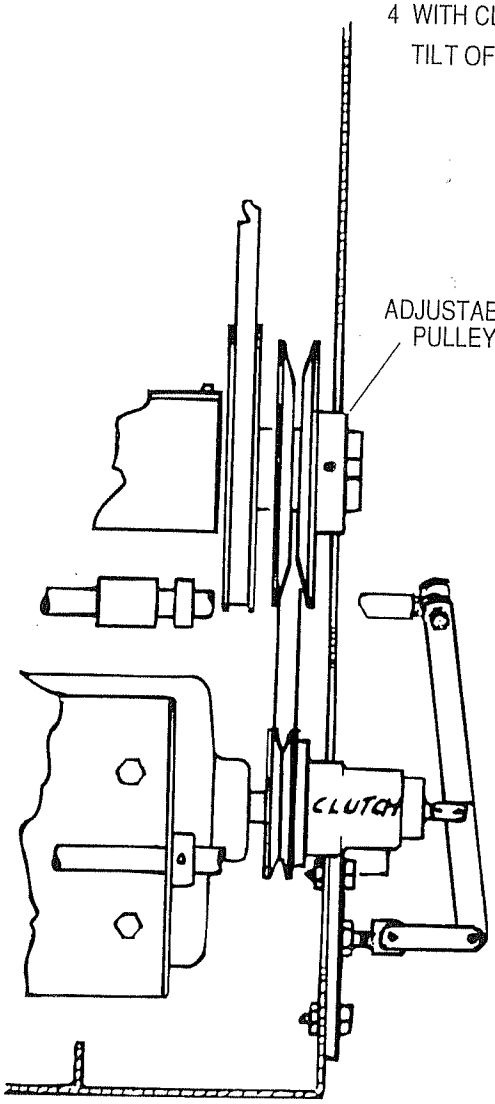


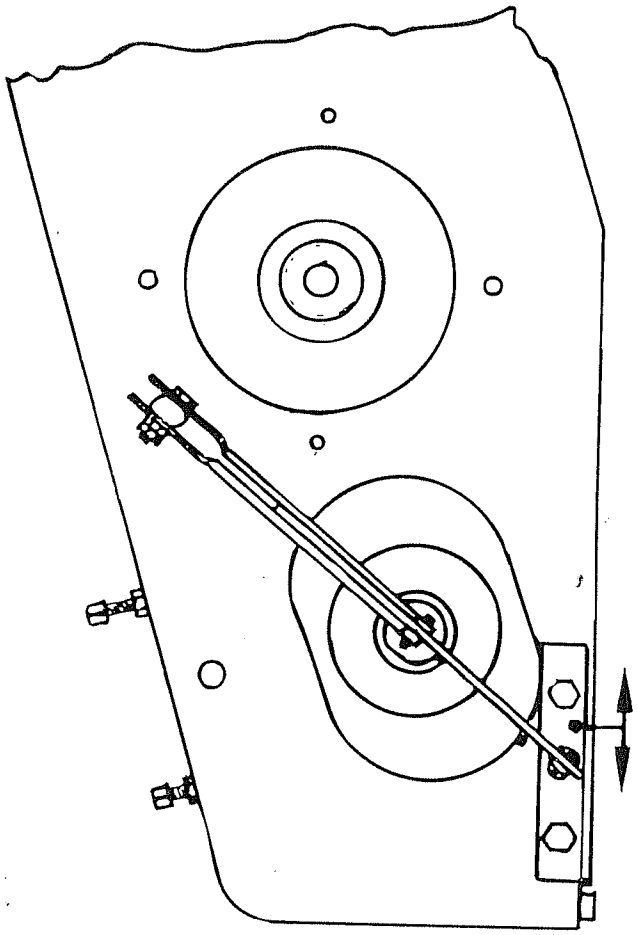


PNR-520

ALTERNATE GEARBOX FOR MAIN DRIVE ASSEMBLY

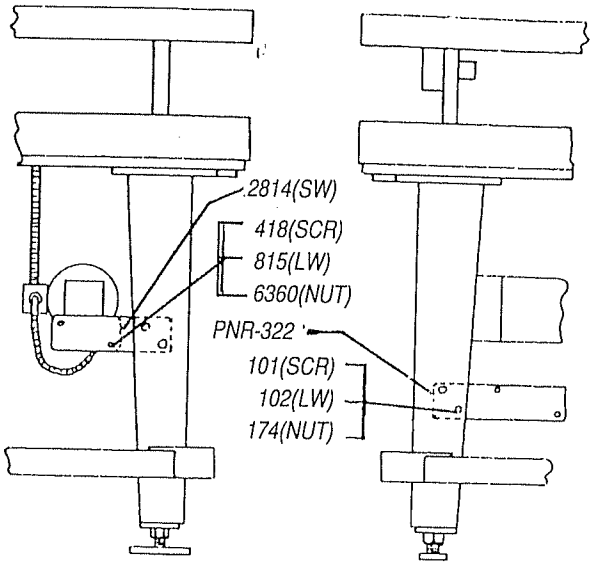
1 SLIP HEAD DRIVE BELT FROM PULLEY
2 RELEASE UPPER MOTOR ADJUSTING SCREW 1/2 " APPROX.
3 TO CHANGE MACHINE TRAVEL SPEED — RELEASE SET SCREW IN HUB & OPEN (FASTER) OR CLOSE (SLOWER) TO DESIRED POSITION — RESET SCREW ON FLAT
4 WITH CLUTCH CLOSED (SEE NOTE) RESET 2 SCREWS READJUSTING TILT OF MOTOR FOR PROPER BELT TENSION





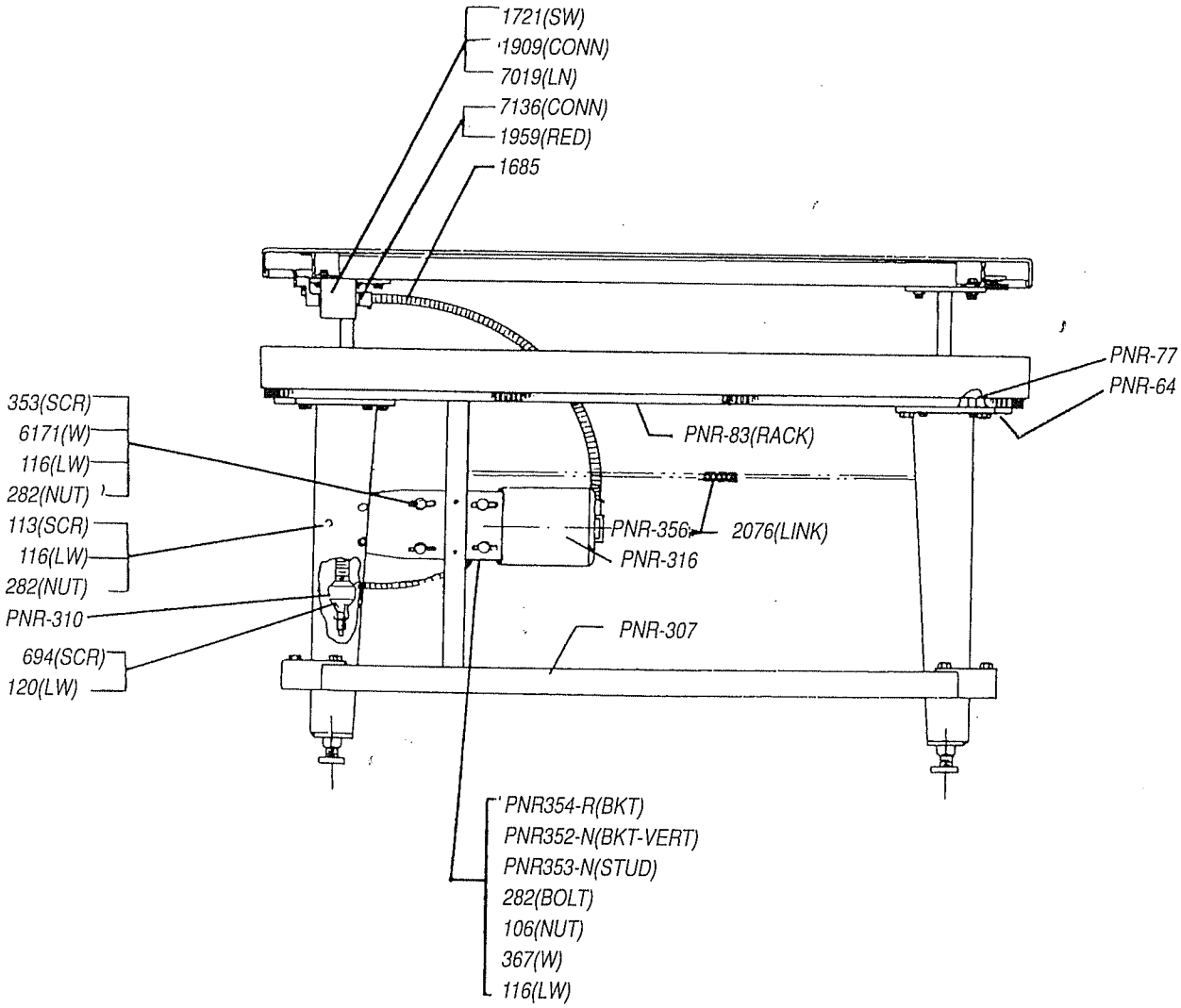
NOTE
CLUTCH PULLEY IS COMPLETELY CLOSED
WHEN ADJUSTING MOTOR SCREWS FOR
BELT TENSION
ROTATE CLUTCH BY HAND & PUSH TOWARD
MOTOR TO CLOSE CLUTCH TO OPERATING POSITION

MACHINE TRAVERSE SPEED ADJUSTMENT

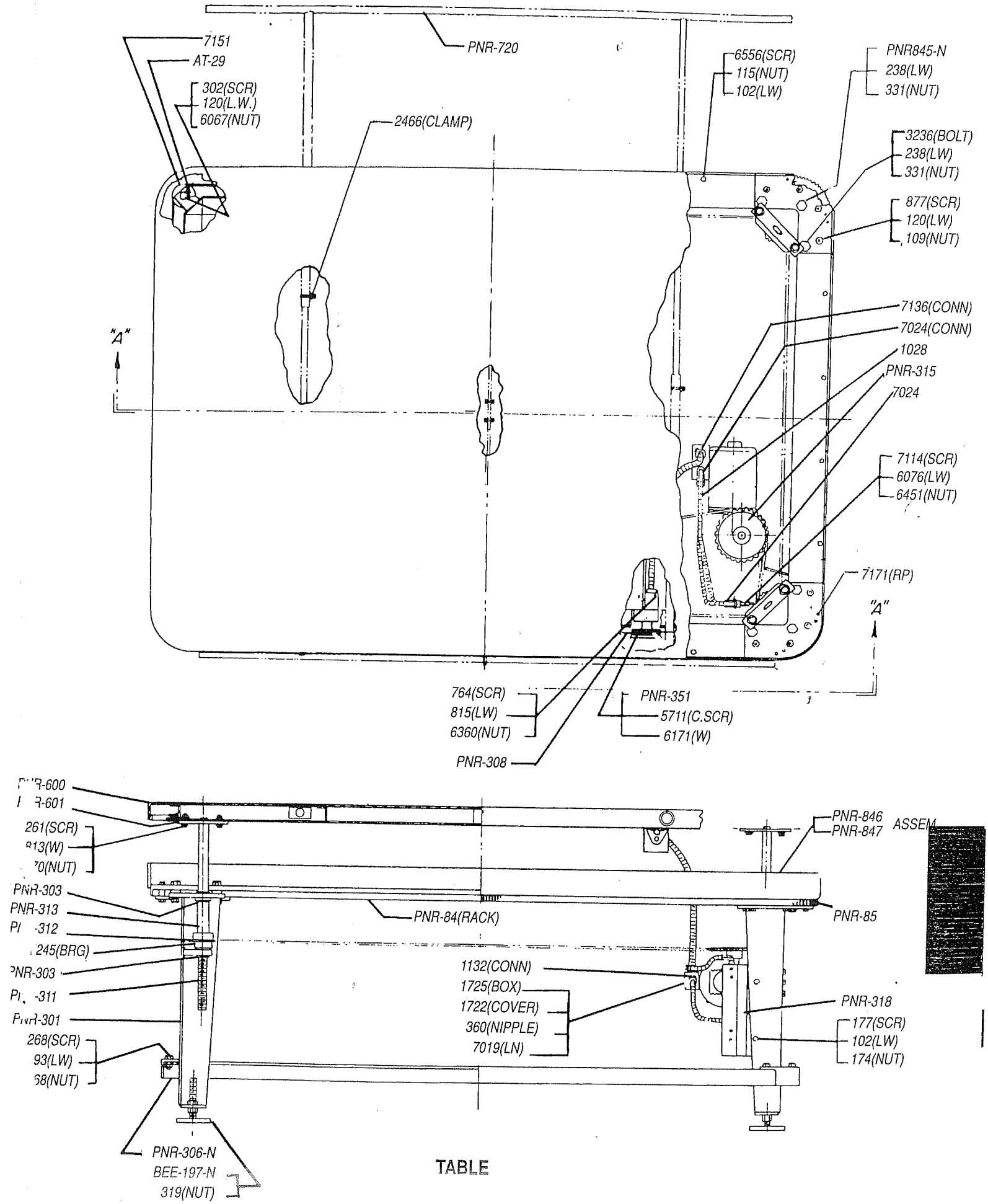


FOR 3 PH. APPLICATION & 115 D.C.

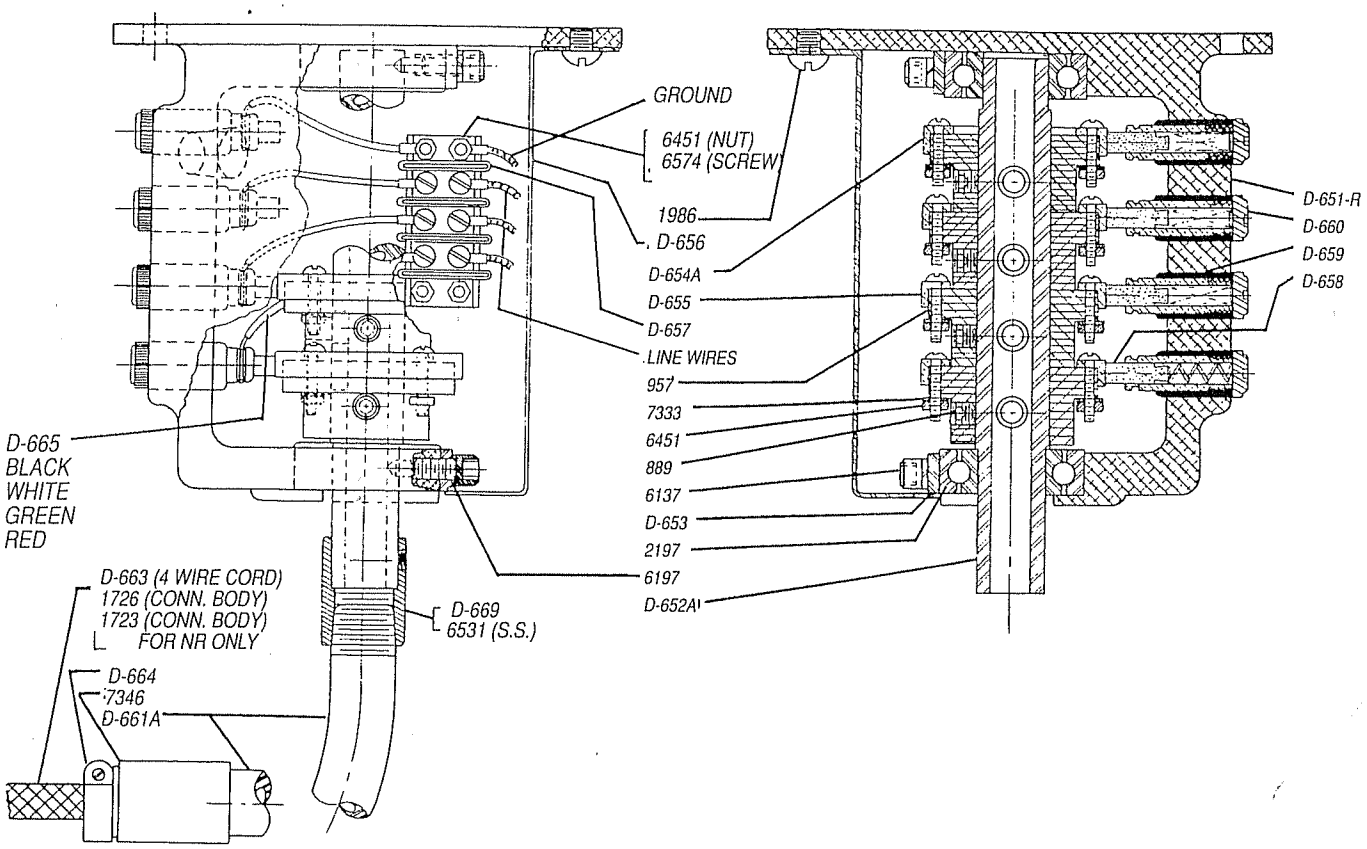
DETAIL "A"



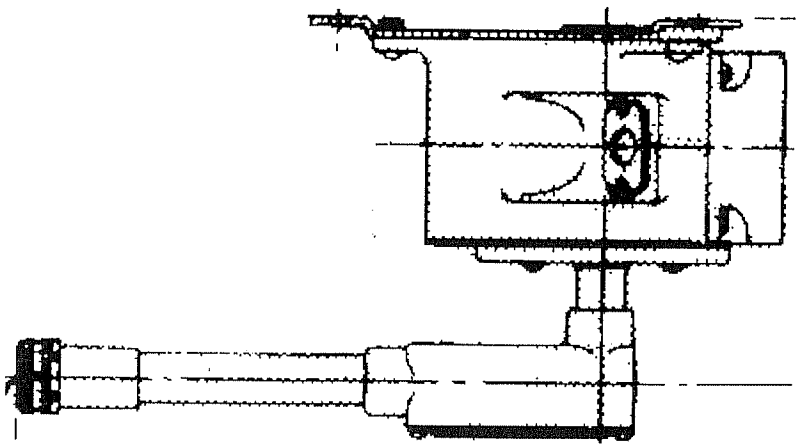
TABLE



TABLE

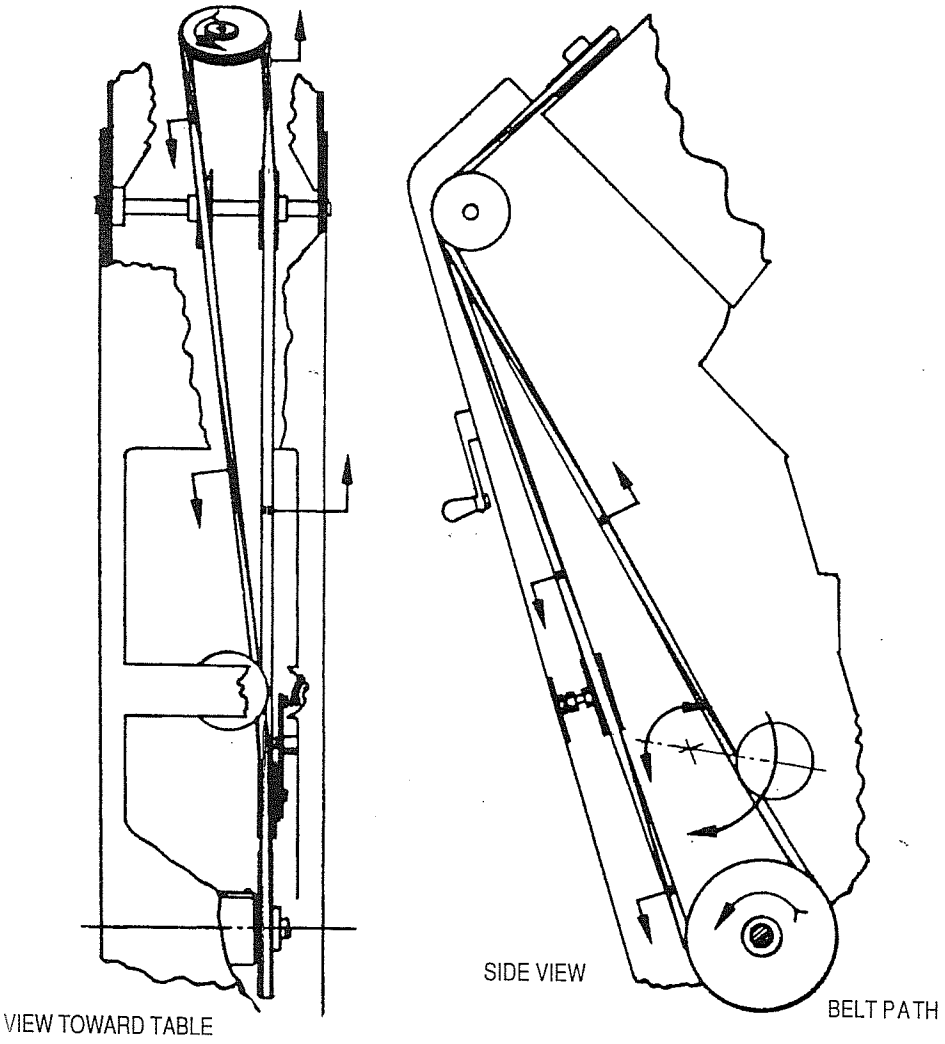


SWIVEL ASSEMBLY

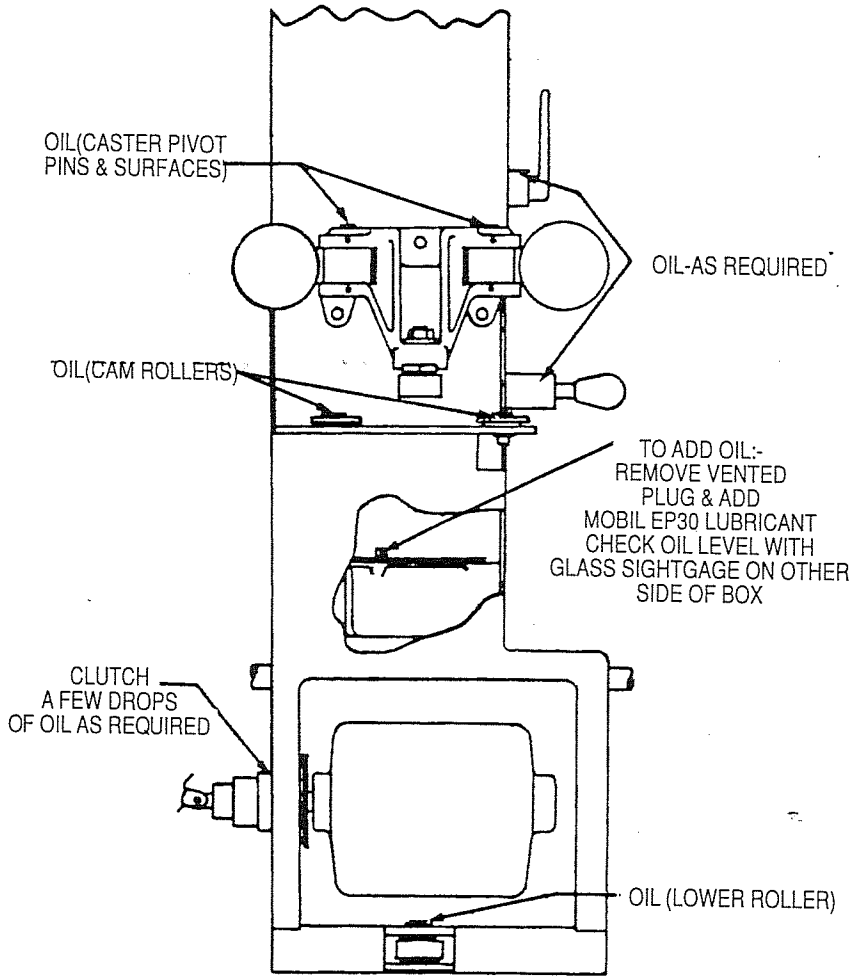


PNR 521

ALTERNATE SWIVEL ASSEMBLY

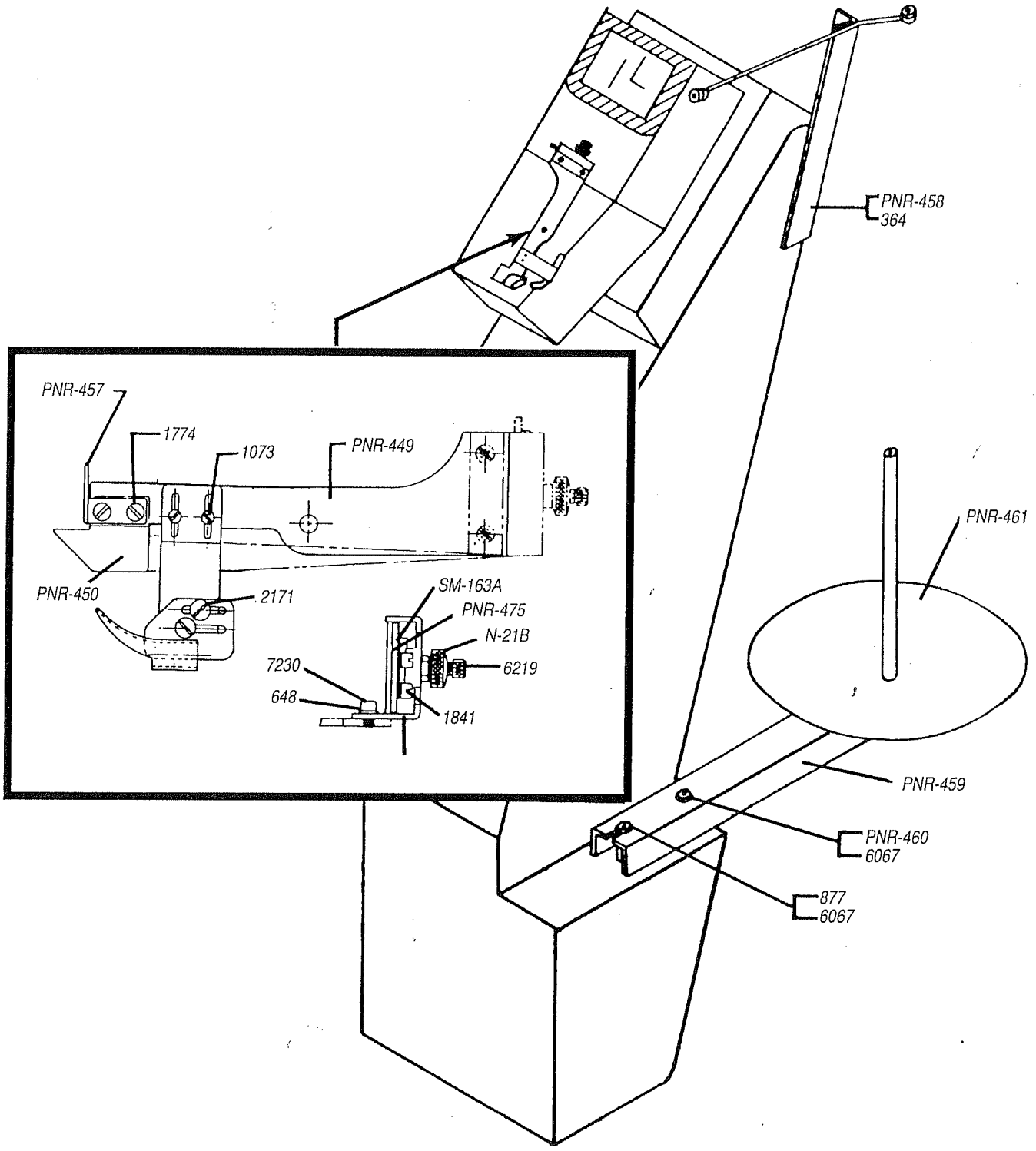


SEWING HEAD DRIVE BELT PATH

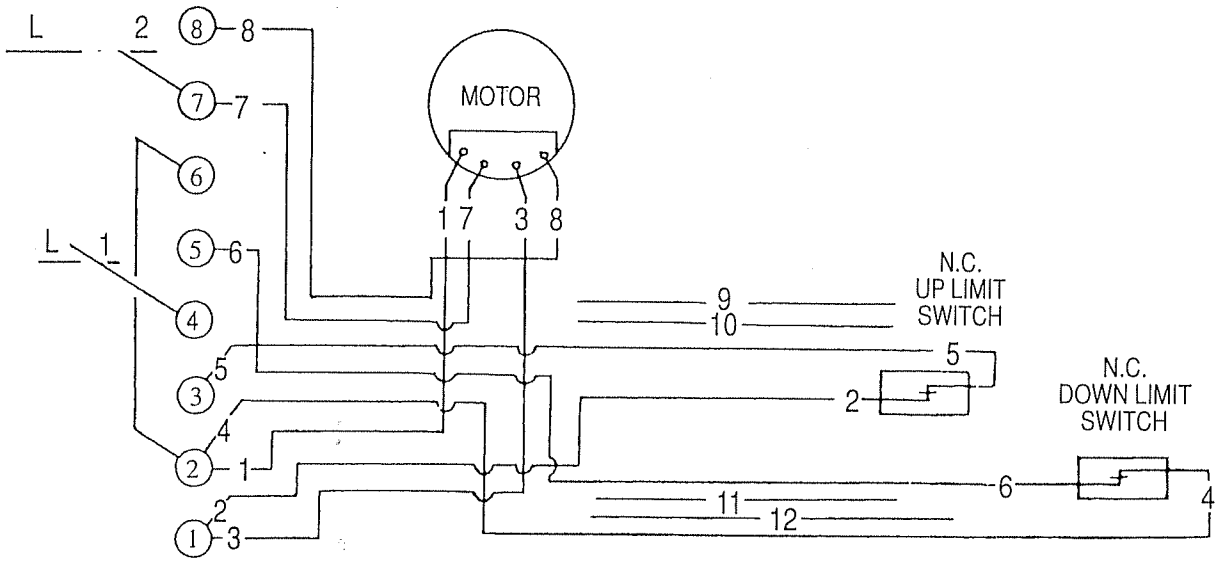


FOR MACHINES WITH GREASE FITTING IN PLACE OF OIL SIGHTAGE- REMOVE VENTED PLUG & GREASE LEVEL SHOULD BE 1' TO 1-1/4' DEEP

LUBRICATION CHART



PIPING ATTACHMENT

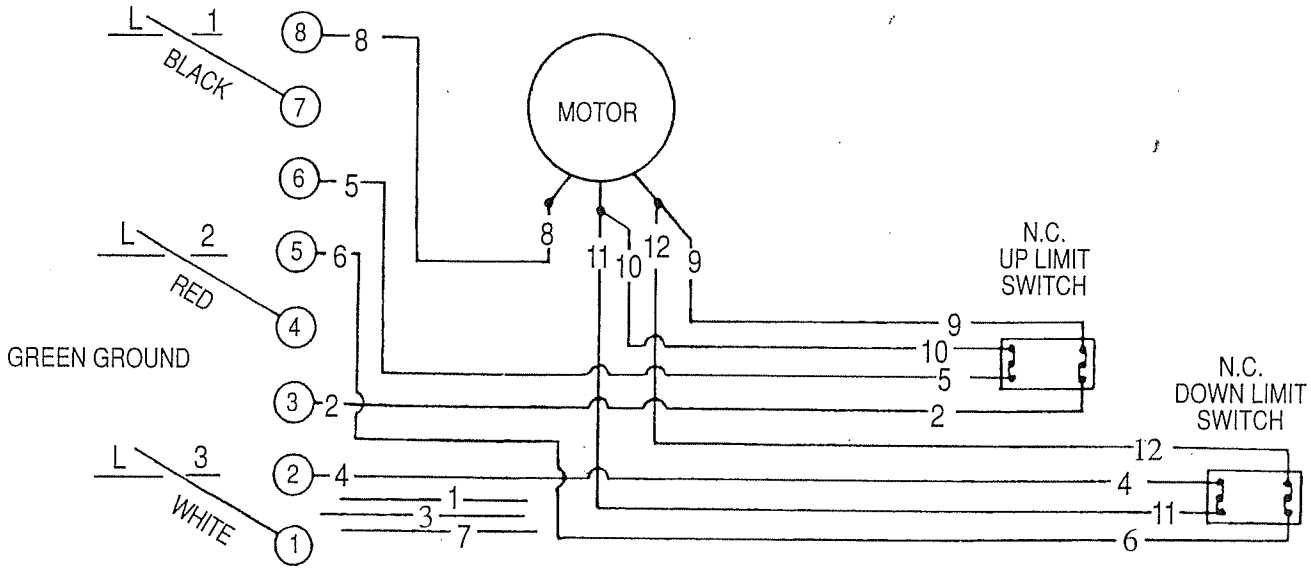


WIRES 9, 10, 11 & 12 NOT USED

M & T 1721
REVERSING
SWITCH
C.C.W. FORWARD"—UP
C.W. REVERSE"—DOWN

ALL HARNESS WIRE BLACK
USE UNIVERSAL HARNESS NR-392-N

SINGLE PHASE



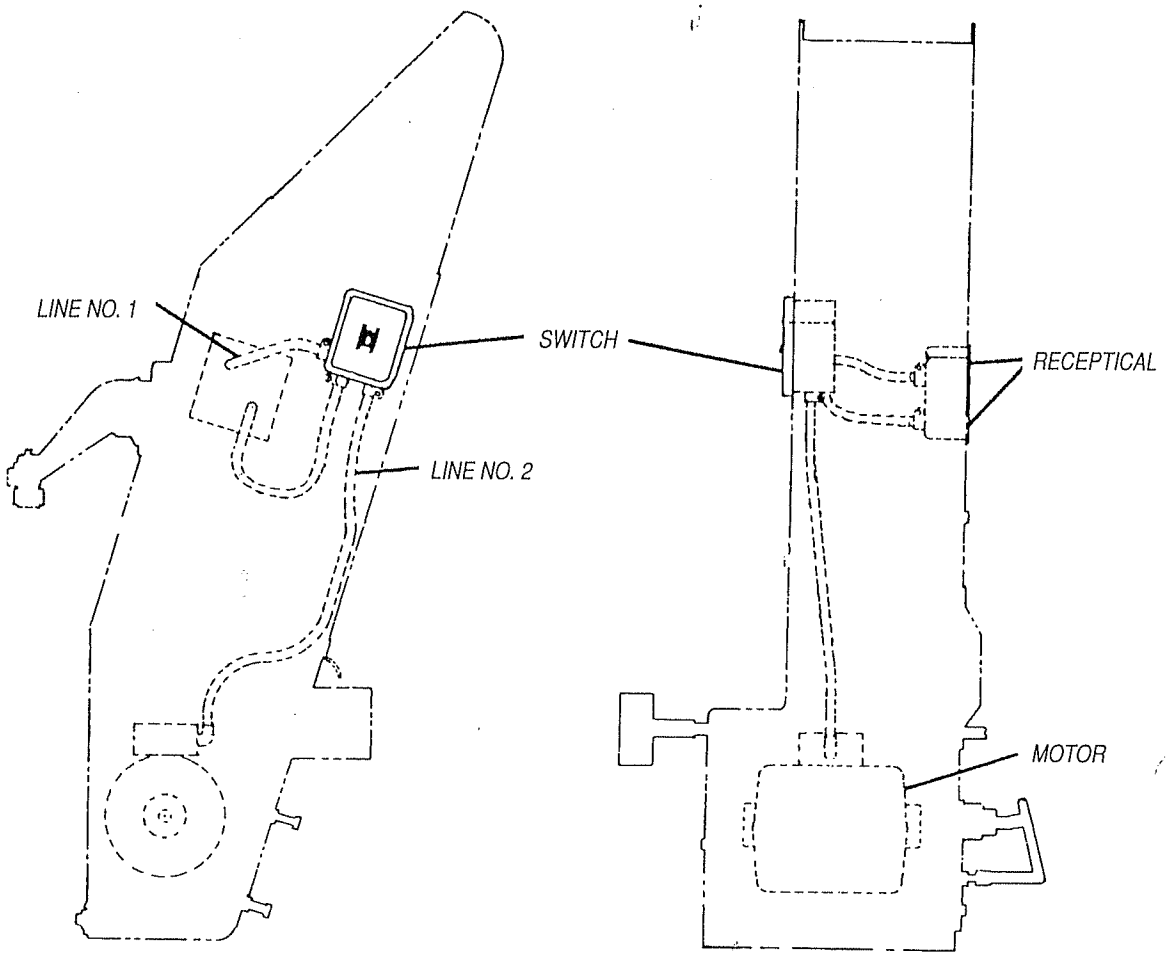
WIRES 1, 3, & 7 NOT USED

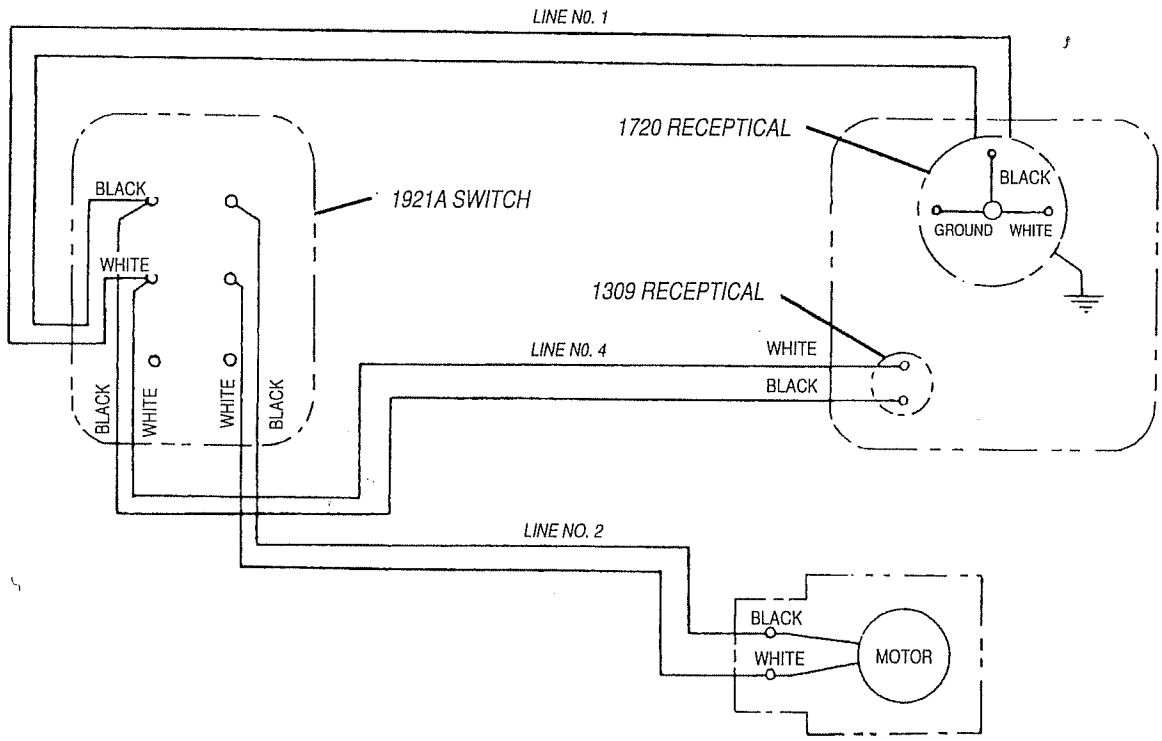
M & T 1721
REVERSING
SWITCH
C.C.W. FORWARD"—UP
C.W. REVERSE"—DOWN

ALL HARNESS WIRE BLACK
USE UNIVERSAL HARNESS NR-392-N

3-PHASE

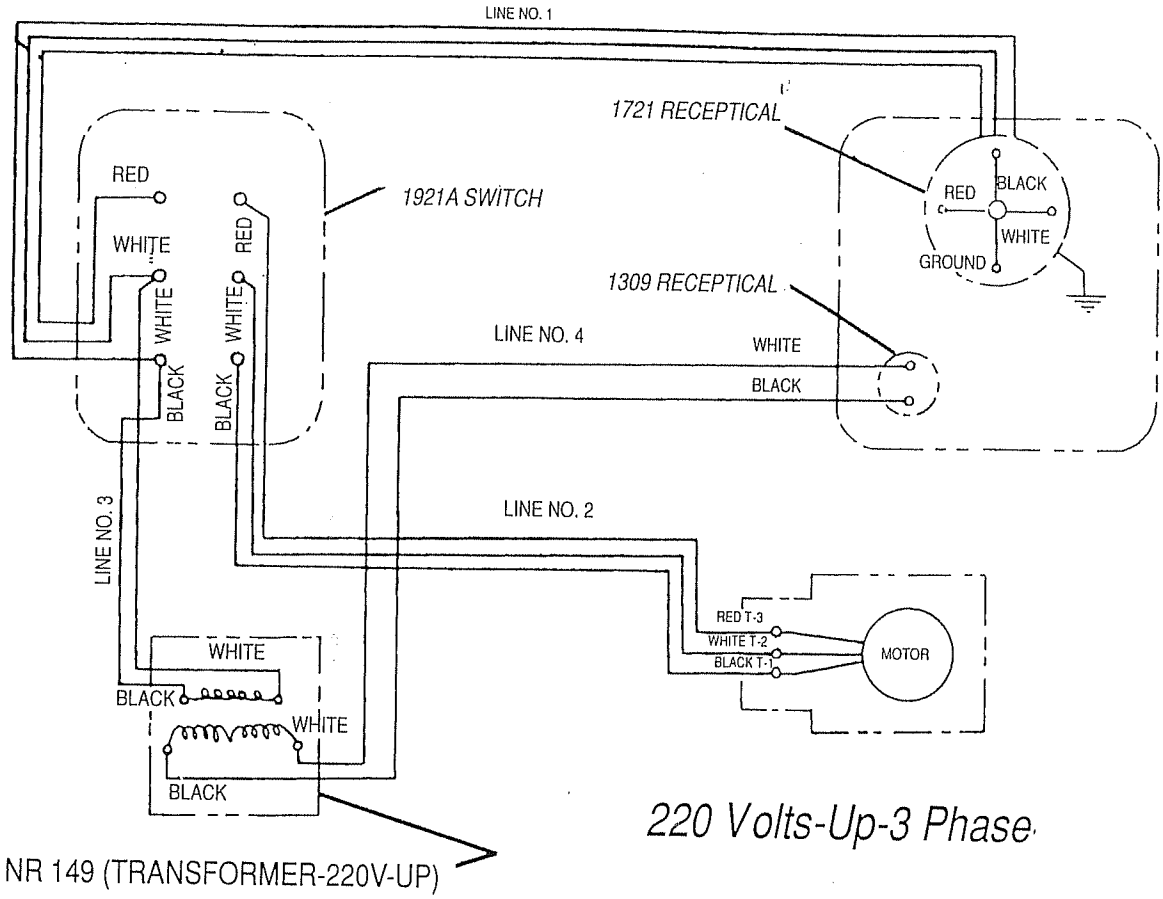
TABLE WIRING DIAGRAM



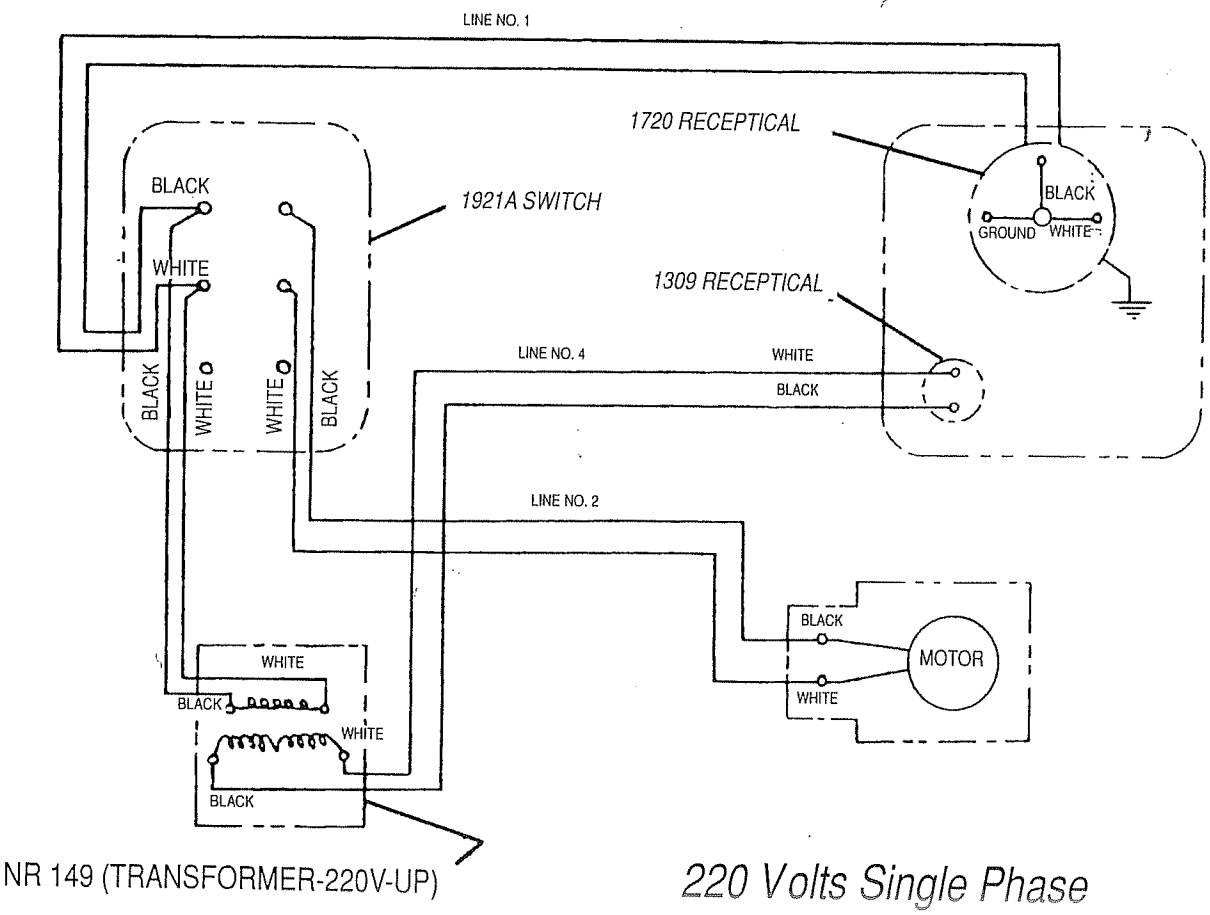


110 Volts Single Phase

MAIN DRIVE WIRING DIAGRAM



MAIN DRIVE WIRING DIAGRAM



MAIN DRIVE WIRING DIAGRAM