

# AMF<sup>®</sup> REECE

*Better Ideas, Better Made*

**S-4000**

**STRAIGHT BUTTONHOLE MACHINE**

**PARTS**

**MANUAL**

**PART NUMBER 97.0024.0.000**

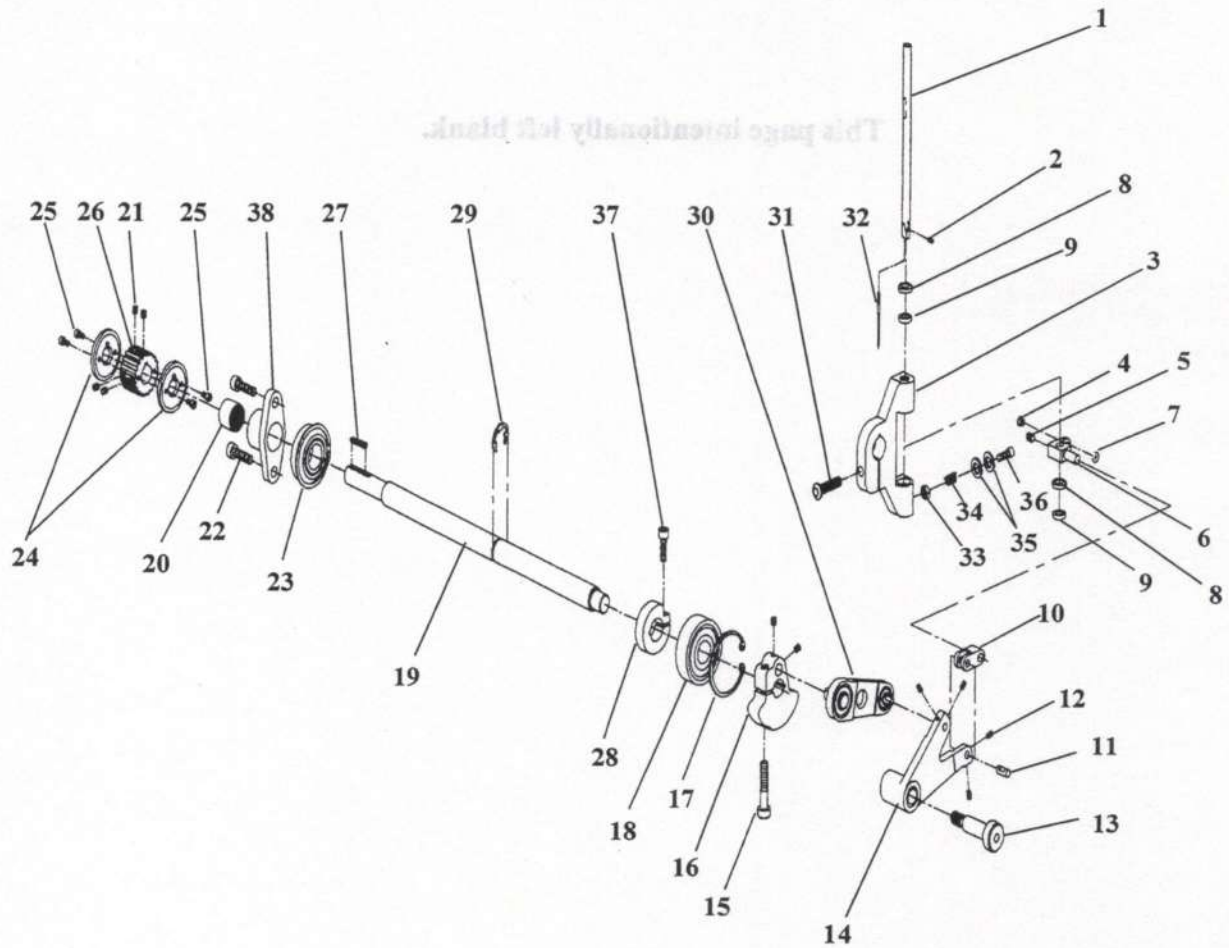
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# NEEDLE BAR

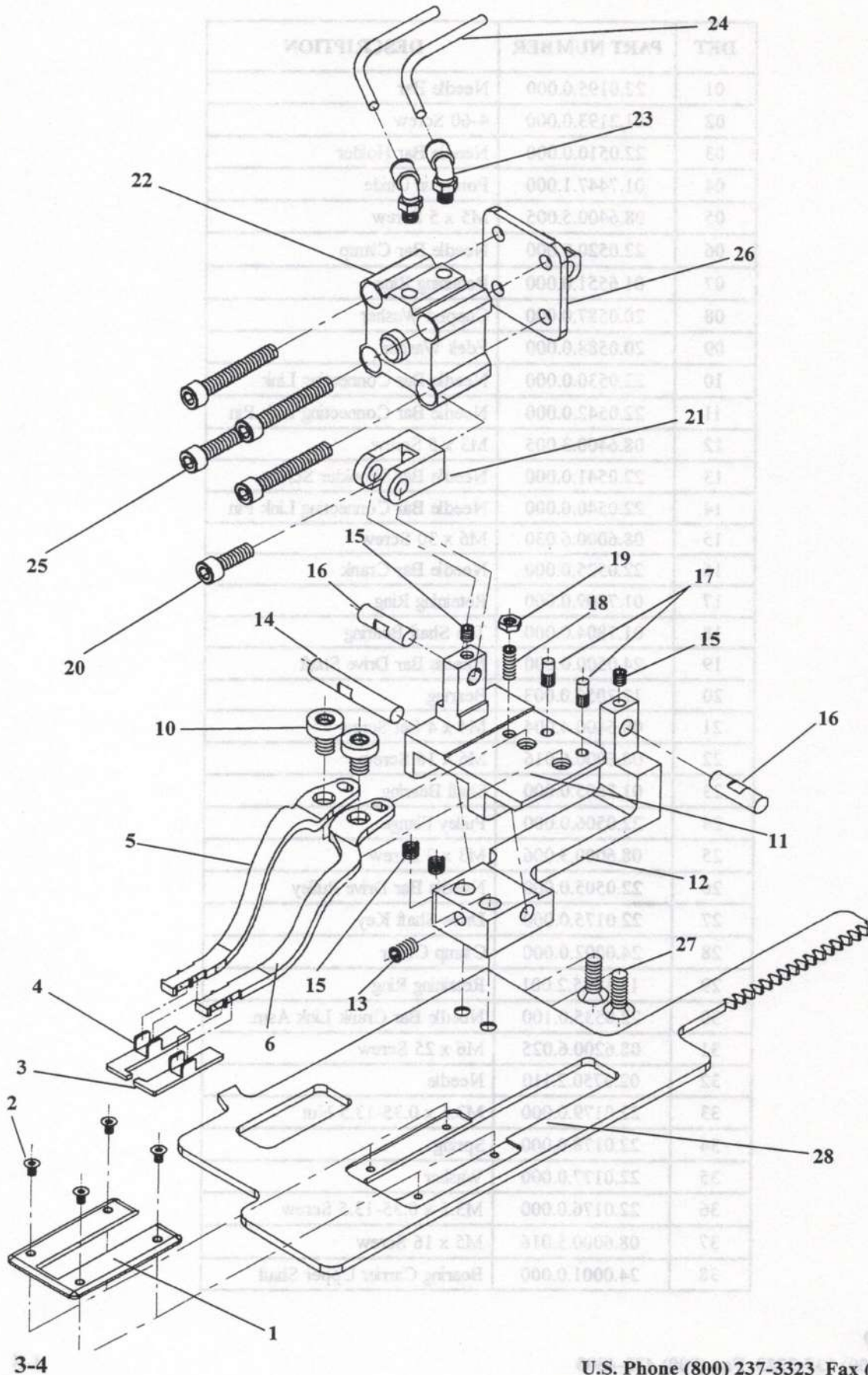




**NEEDLE BAR**

| DET | PART NUMBER   | DESCRIPTION                    |
|-----|---------------|--------------------------------|
| 01  | 22.0195.0.000 | Needle Bar                     |
| 02  | 01.2193.0.000 | 4-60 Screw                     |
| 03  | 22.0510.0.000 | Needle Bar Holder              |
| 04  | 01.7447.1.000 | Porcelain Guide                |
| 05  | 08.6400.5.005 | M5 x 5 Screw                   |
| 06  | 22.0520.0.000 | Needle Bar Clamp               |
| 07  | 01.6551.0.000 | Retaining Ring                 |
| 08  | 20.0587.0.000 | Cupped Washer                  |
| 09  | 20.0588.0.000 | Fdelt Washer                   |
| 10  | 22.0530.0.000 | Needle Bar Connecting Link     |
| 11  | 22.0542.0.000 | Needle Bar Connecting Link Pin |
| 12  | 08.6400.3.005 | M3 x 5 Screw                   |
| 13  | 22.0541.0.000 | Needle Bar Shoulder Screw      |
| 14  | 22.0540.0.000 | Needle Bar Connecting Link Pin |
| 15  | 08.6000.6.030 | M6 x 30 Screw                  |
| 16  | 22.0525.0.000 | Needle Bar Crank               |
| 17  | 01.7809.0.000 | Retaining Ring                 |
| 18  | 01.7804.0.000 | Top Shaft Bearing              |
| 19  | 24.0500.0.000 | Needle Bar Drive Shaft         |
| 20  | 12.2050.0.003 | Bearing                        |
| 21  | 08.6400.4.004 | M4 x 4 Set Screw               |
| 22  | 08.6000.6.016 | M6 x 16 Screw                  |
| 23  | 01.7805.0.000 | Shaft Bearing                  |
| 24  | 22.0506.0.000 | Pulley Flange                  |
| 25  | 08.6000.3.006 | M3 x 7 Screw                   |
| 26  | 22.0505.0.000 | Needle Bar Drive Pulley        |
| 27  | 22.0175.0.000 | Drive Shaft Key                |
| 28  | 24.0002.0.000 | Clamp Collar                   |
| 29  | 12.1045.2.001 | Retaining Ring                 |
| 30  | 22.0535.0.100 | Needle Bar Crank Link Asm.     |
| 31  | 08.6200.6.025 | M6 x 25 Screw                  |
| 32  | 02.0750.2.110 | Needle                         |
| 33  | 22.0179.0.000 | M3.5 x 0.35-13.5 Nut           |
| 34  | 22.0178.0.000 | Spring                         |
| 35  | 22.0177.0.000 | Washer                         |
| 36  | 22.0176.0.000 | M3.5 x 0.35-13.5 Screw         |
| 37  | 08.6000.5.016 | M5 x 16 Screw                  |
| 38  | 24.0001.0.000 | Bearing Carrier Upper Shaft    |

# CLAMPING



Released 2/99

U.S. Phone (800) 237-3323 Fax (800) 432-4303

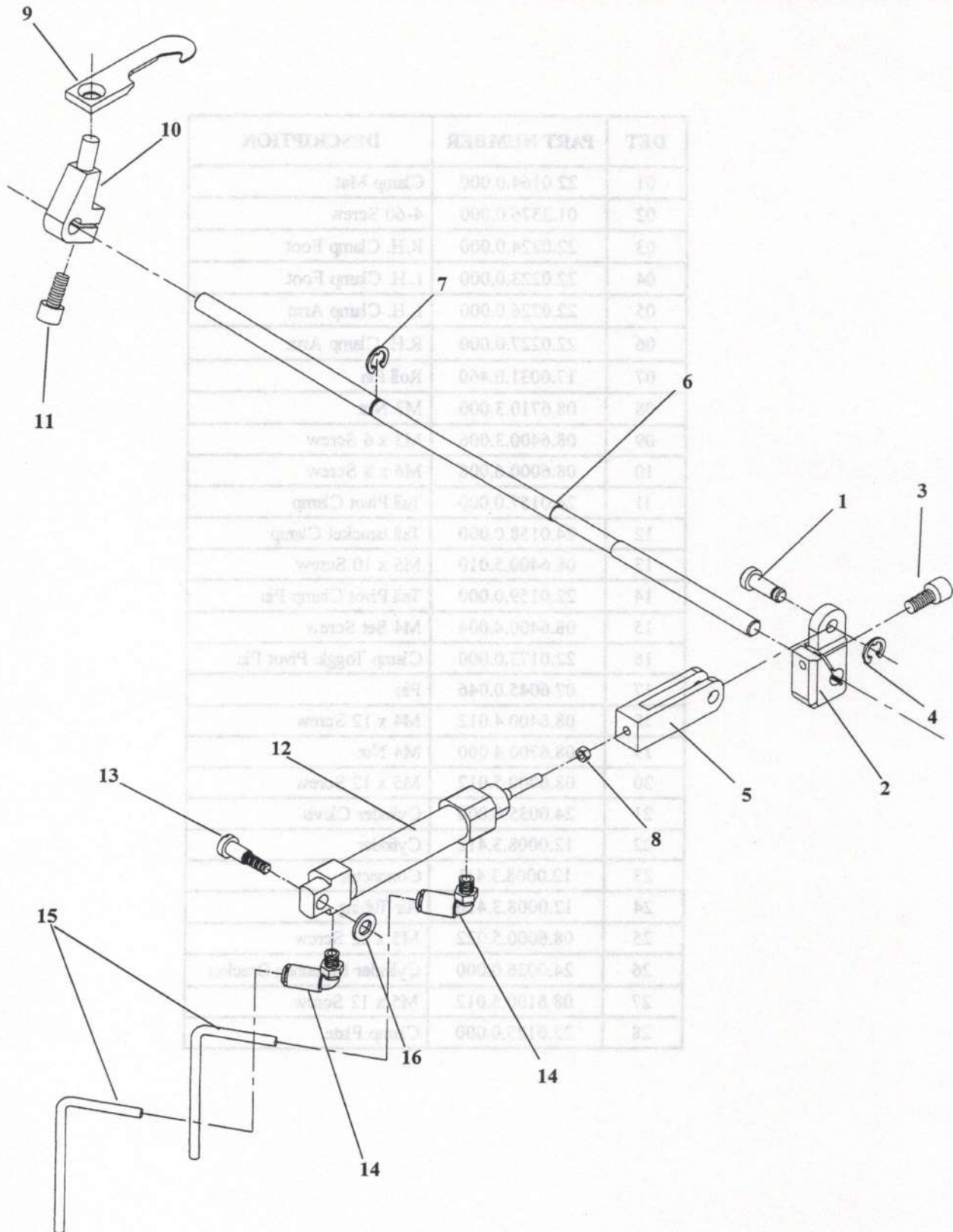
Outside U.S. Phone (804) 559-5000 Fax (804) 559-5290




**CLAMPING**

| DET | PART NUMBER   | DESCRIPTION               |
|-----|---------------|---------------------------|
| 01  | 22.0164.0.000 | Clamp Mat                 |
| 02  | 01.2376.0.000 | 4-60 Screw                |
| 03  | 22.0224.0.000 | R.H. Clamp Foot           |
| 04  | 22.0223.0.000 | L.H. Clamp Foot           |
| 05  | 22.0226.0.000 | L.H. Clamp Arm            |
| 06  | 22.0227.0.000 | R.H. Clamp Arm            |
| 07  | 17.0031.0.460 | Roll Pin                  |
| 08  | 08.6710.3.000 | M3 Nut                    |
| 09  | 08.6400.3.006 | M3 x 6 Screw              |
| 10  | 08.6000.6.008 | M6 x 8 Screw              |
| 11  | 24.0157.0.000 | Tail Pivot Clamp          |
| 12  | 24.0158.0.000 | Tail Bracket Clamp        |
| 13  | 08.6400.5.010 | M5 x 10 Screw             |
| 14  | 22.0159.0.000 | Tail Pivot Clamp Pin      |
| 15  | 08.6400.4.004 | M4 Set Screw              |
| 16  | 22.0173.0.000 | Clamp Toggle Pivot Pin    |
| 17  | 07.6045.0.046 | Pin                       |
| 18  | 08.6400.4.012 | M4 x 12 Screw             |
| 19  | 08.6700.4.000 | M4 Nut                    |
| 20  | 08.6000.5.012 | M5 x 12 Screw             |
| 21  | 24.0035.0.000 | Cylinder Clevis           |
| 22  | 12.0008.3.412 | Cylinder                  |
| 23  | 12.0008.3.411 | Connector                 |
| 24  | 12.0008.3.416 | Air Tubing                |
| 25  | 08.6000.5.022 | M5 x 22 Screw             |
| 26  | 24.0036.0.000 | Cylinder Mounting Bracket |
| 27  | 08.6100.5.012 | M5 x 12 Screw             |
| 28  | 22.0125.0.000 | Clamp Plate               |

# THREAD TRIMMER

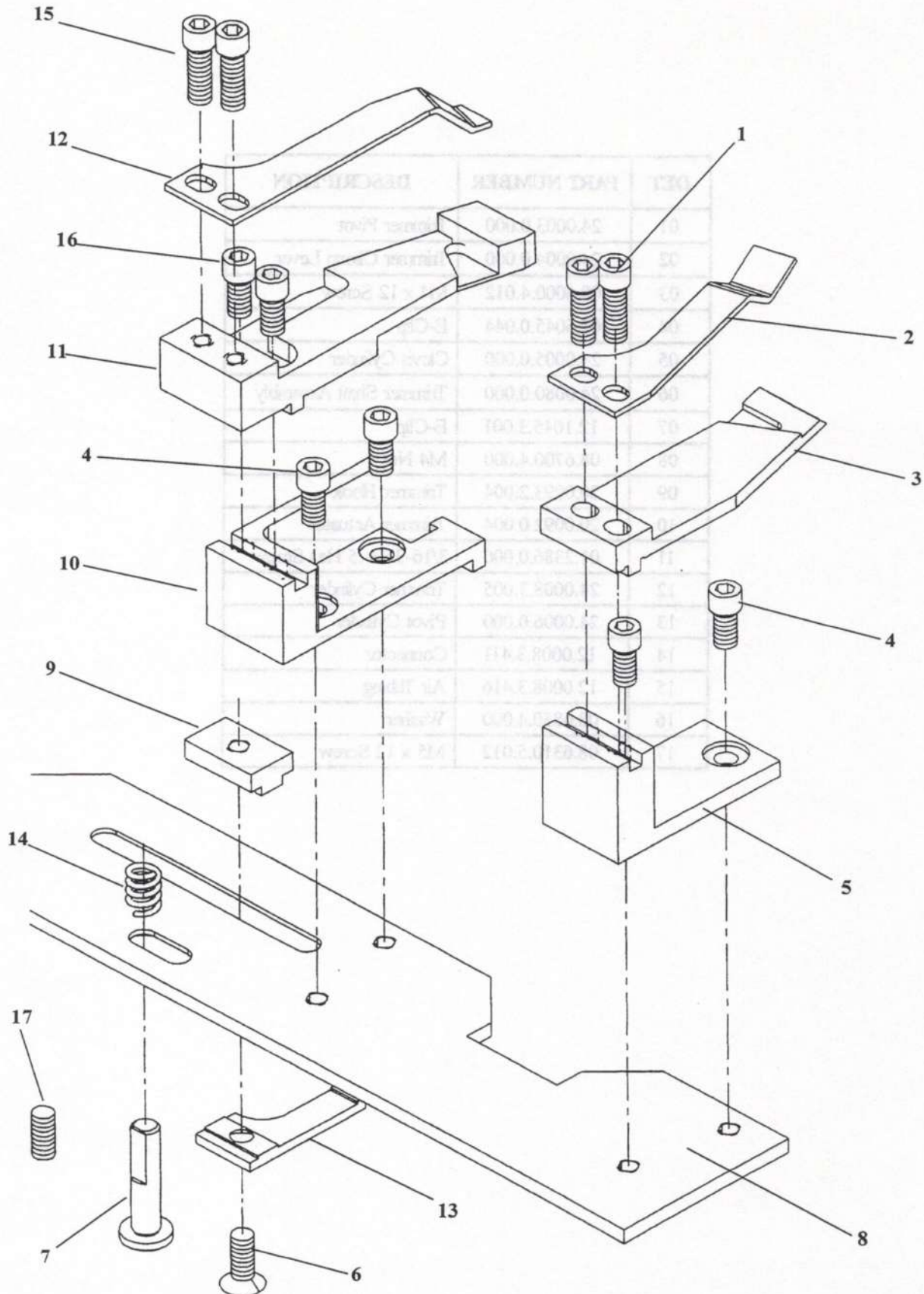




**THREAD TRIMMER**

| DET | PART NUMBER   | DESCRIPTION            |
|-----|---------------|------------------------|
| 01  | 24.0003.0.000 | Trimmer Pivot          |
| 02  | 24.0004.0.000 | Trimmer Clamp Lever    |
| 03  | 08.6000.4.012 | M4 x 12 Screw          |
| 04  | 07.6045.0.044 | E-Clip                 |
| 05  | 24.0005.0.000 | Clevis Cylinder        |
| 06  | 24.0080.0.000 | Trimmer Shaft Assembly |
| 07  | 12.1045.3.001 | E-Clip                 |
| 08  | 08.6700.4.000 | M4 Nut                 |
| 09  | 20.0093.2.004 | Trimmer Hook           |
| 10  | 20.0092.0.004 | Trimmer Actuator       |
| 11  | 01.2386.0.000 | 3/16-36 x .5 Hex Screw |
| 12  | 24.0008.3.005 | Trimmer Cylinder       |
| 13  | 24.0006.0.000 | Pivot Cylinder         |
| 14  | 12.0008.3.411 | Connector              |
| 15  | 12.0008.3.416 | Air Tubing             |
| 16  | 08.6850.4.000 | Washer                 |
| 17  | 08.6310.5.012 | M5 x 12 Screw          |

# SHIFTER MECHANISM

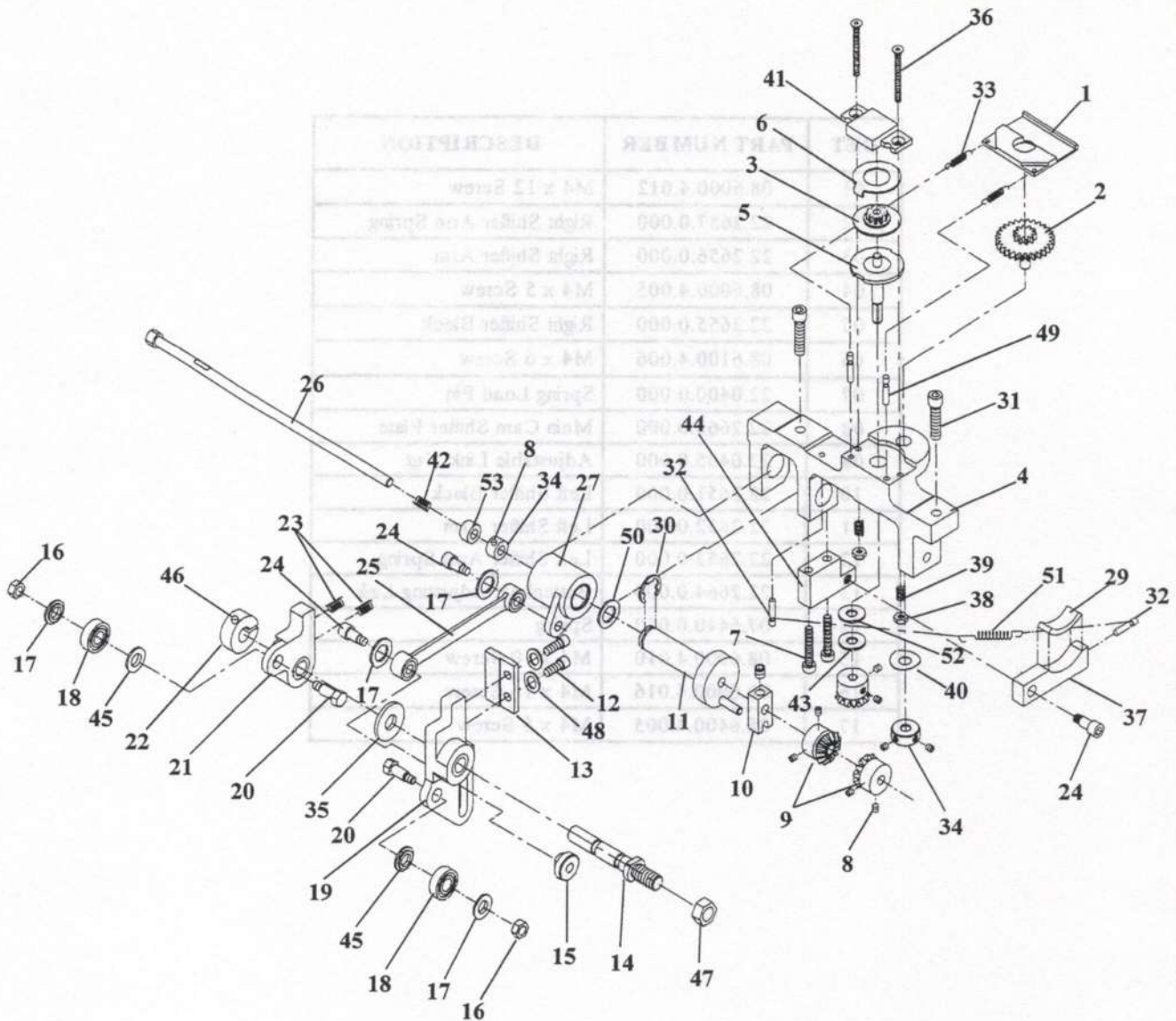


## SHIFTER MECHANISM

| DET | PART NUMBER   | DESCRIPTION               |
|-----|---------------|---------------------------|
| 01  | 08.6000.4.012 | M4 x 12 Screw             |
| 02  | 22.2657.0.000 | Right Shifter Arm Spring  |
| 03  | 22.2656.0.000 | Right Shifter Arm         |
| 04  | 08.6000.4.005 | M4 x 5 Screw              |
| 05  | 22.2655.0.000 | Right Shifter Block       |
| 06  | 08.6100.4.006 | M4 x 6 Screw              |
| 07  | 22.0400.0.000 | Spring Load Pin           |
| 08  | 22.2665.0.000 | Main Cam Shifter Plate    |
| 09  | 22.0405.0.000 | Adjustable Link Nut       |
| 10  | 22.2651.0.000 | Left Shifter Block        |
| 11  | 22.2652.0.000 | Left Shifter Arm          |
| 12  | 22.2653.0.000 | Left Shifter Arm Spring   |
| 13  | 22.2664.0.000 | Buttonhole Adjusting Link |
| 14  | 07.6440.0.040 | Spring                    |
| 15  | 08.6000.4.010 | M4 x 10 Screw             |
| 16  | 08.6000.4.016 | M4 x 16 Screw             |
| 17  | 08.6400.4.005 | M4 x 5 Screw              |



## FEED MECHANISM

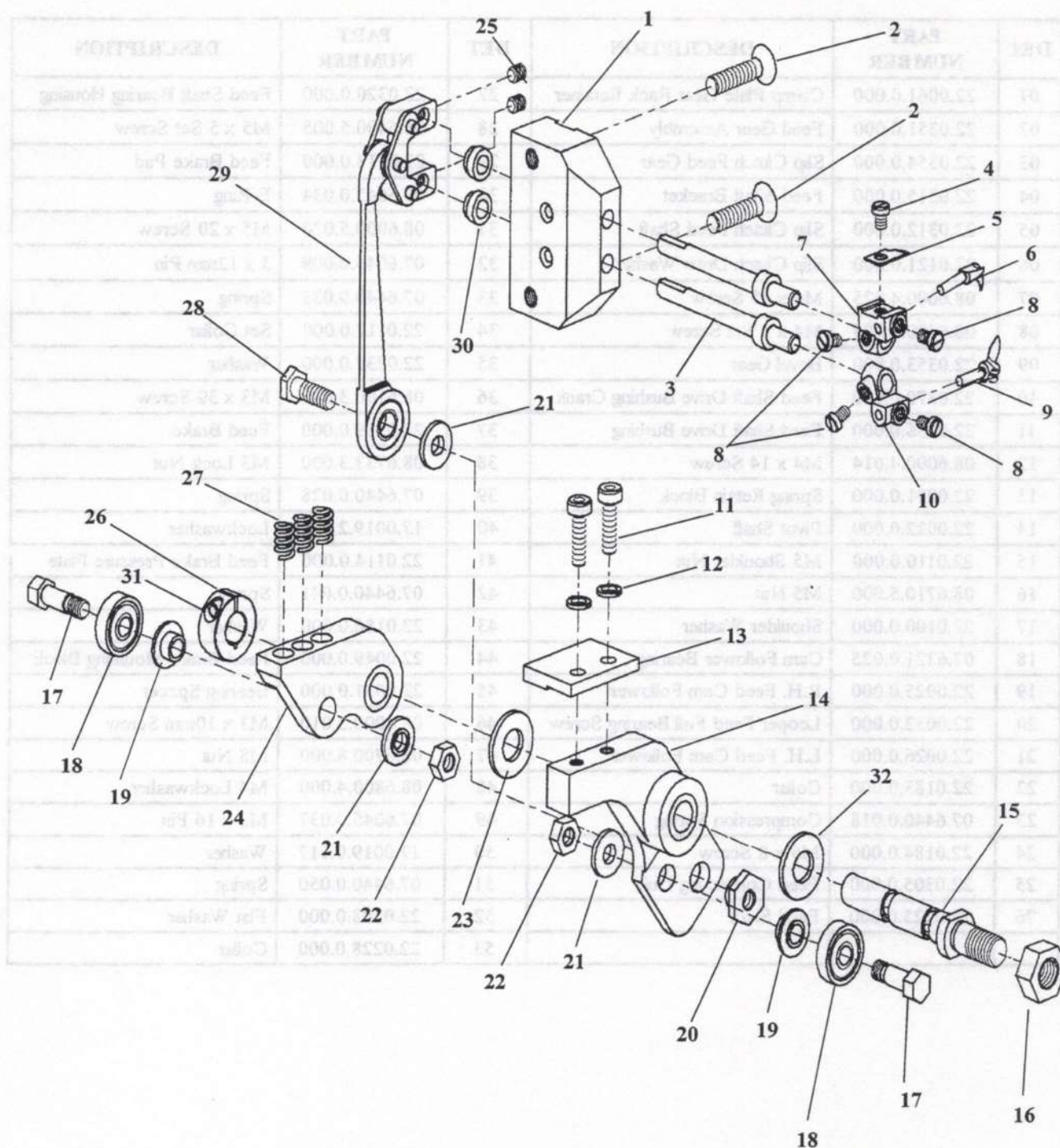


## FEED MECHANISM

| DET | PART NUMBER   | DESCRIPTION                    | DET | PART NUMBER   | DESCRIPTION                |
|-----|---------------|--------------------------------|-----|---------------|----------------------------|
| 01  | 22.0061.0.000 | Clamp Plate Gear Rack Retainer | 27  | 22.0320.0.000 | Feed Shaft Bearing Housing |
| 02  | 22.0351.0.000 | Feed Gear Assembly             | 28  | 08.6400.5.005 | M5 x 5 Set Screw           |
| 03  | 22.0354.0.000 | Slip Clutch Feed Gear          | 29  | 22.0313.0.000 | Feed Brake Pad             |
| 04  | 22.0315.0.000 | Feed Shaft Bracket             | 30  | 07.6045.0.034 | E-Ring                     |
| 05  | 22.0312.0.000 | Slip Clutch Feed Shaft         | 31  | 08.6000.5.020 | M5 x 20 Screw              |
| 06  | 22.0121.0.000 | Slip Clutch Drive Washer       | 32  | 07.6045.0.009 | 3 x 12mm Pin               |
| 07  | 08.6000.4.025 | M4 x 25 Screw                  | 33  | 07.6440.0.033 | Spring                     |
| 08  | 08.6400.4.005 | M4 x 5 Set Screw               | 34  | 22.0117.0.000 | Set Collar                 |
| 09  | 22.0353.0.000 | Bevel Gear                     | 35  | 22.0232.0.000 | Washer                     |
| 10  | 22.0370.0.000 | Feed Shaft Drive Bushing Crank | 36  | 08.6100.3.030 | M3 x 30 Screw              |
| 11  | 22.0336.0.000 | Feed Shaft Drive Bushing       | 37  | 22.0309.0.000 | Feed Brake                 |
| 12  | 08.6000.4.014 | M4 x 14 Screw                  | 38  | 08.6733.3.000 | M3 Lock Nut                |
| 13  | 22.0021.0.000 | Spring Retain Block            | 39  | 07.6440.0.028 | Spring                     |
| 14  | 22.0022.0.000 | Pivot Shaft                    | 40  | 17.0019.2.057 | Lockwasher                 |
| 15  | 22.0110.0.000 | M5 Shoulder Nut                | 41  | 22.0114.0.000 | Feed Brake Pressure Plate  |
| 16  | 08.6710.5.000 | M5 Nut                         | 42  | 07.6440.0.041 | Spring                     |
| 17  | 22.0100.0.000 | Shoulder Washer                | 43  | 22.0186.0.000 | Washer                     |
| 18  | 07.6321.0.025 | Cam Follower Bearing           | 44  | 22.0049.0.000 | Feed Brake Mounting Block  |
| 19  | 22.0025.0.000 | R.H. Feed Cam Follower         | 45  | 22.0031.0.000 | Bearing Spacer             |
| 20  | 22.0032.0.000 | Looper Feed Foll.Bearing Screw | 46  | 08.6000.3.010 | M3 x 10mm Screw            |
| 21  | 22.0026.0.000 | L.H. Feed Cam Follower         | 47  | 08.6700.8.000 | M8 Nut                     |
| 22  | 22.0183.0.000 | Collar                         | 48  | 08.6800.4.000 | M4 Lockwasher              |
| 23  | 07.6440.0.018 | Compression Spring             | 49  | 07.6045.0.037 | M3 x 16 Pin                |
| 24  | 22.0184.0.000 | M5 x 8 Screw                   | 50  | 17.0019.0.517 | Washer                     |
| 25  | 22.0305.0.000 | Feed Connecting Link           | 51  | 07.6440.0.050 | Spring                     |
| 26  | 22.0325.0.000 | Feed Shaft                     | 52  | 22.0208.0.000 | Flat Washer                |
|     |               |                                | 53  | 22.0228.0.000 | Collar                     |



# LOOPER MECHANISM

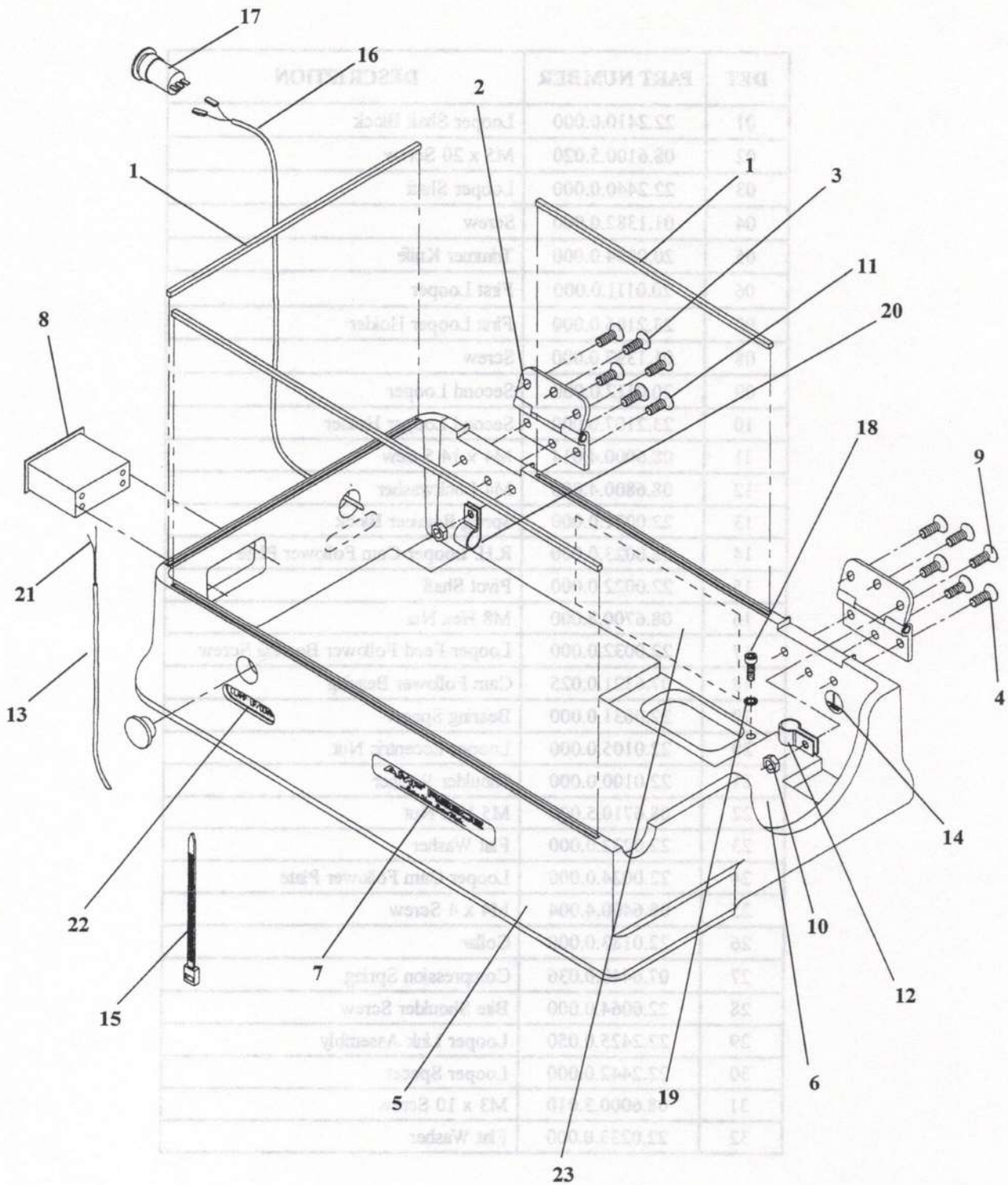




**LOOPER MECHANISM**

| DET | PART NUMBER   | DESCRIPTION                        |
|-----|---------------|------------------------------------|
| 01  | 22.2410.0.000 | Looper Shaft Block                 |
| 02  | 08.6100.5.020 | M5 x 20 Screw                      |
| 03  | 22.2440.0.000 | Looper Shaft                       |
| 04  | 01.1382.0.000 | Screw                              |
| 05  | 20.0094.0.000 | Trimmer Knife                      |
| 06  | 20.0111.0.000 | First Looper                       |
| 07  | 23.2106.0.000 | First Looper Holder                |
| 08  | 01.1397.0.000 | Screw                              |
| 09  | 20.0112.0.000 | Second Looper                      |
| 10  | 23.2107.0.000 | Second Looper Holder               |
| 11  | 08.6000.4.014 | M4 x 14 Screw                      |
| 12  | 08.6800.4.000 | M4 Lockwasher                      |
| 13  | 22.0021.0.000 | Spring Retainer Block              |
| 14  | 22.0023.0.000 | R.H. Looper Cam Follower Plate     |
| 15  | 22.0022.0.000 | Pivot Shaft                        |
| 16  | 08.6700.8.000 | M8 Hex Nut                         |
| 17  | 22.0032.0.000 | Looper Feed Follower Bearing Screw |
| 18  | 07.6321.0.025 | Cam Follower Bearing               |
| 19  | 22.0031.0.000 | Bearing Spacer                     |
| 20  | 22.0105.0.000 | Looper Eccentric Nut               |
| 21  | 22.0100.0.000 | Shoulder Washer                    |
| 22  | 08.6710.5.000 | M5 Hex Nut                         |
| 23  | 22.0232.0.000 | Flat Washer                        |
| 24  | 22.0024.0.000 | Looper Cam Follower Plate          |
| 25  | 08.6400.4.004 | M4 x 4 Screw                       |
| 26  | 22.0183.0.000 | Collar                             |
| 27  | 07.6440.0.036 | Compression Spring                 |
| 28  | 22.0064.0.000 | Bite Shoulder Screw                |
| 29  | 22.2425.0.050 | Looper Link Assembly               |
| 30  | 22.2442.0.000 | Looper Spacer                      |
| 31  | 08.6000.3.010 | M3 x 10 Screw                      |
| 32  | 22.0233.0.000 | Flat Washer                        |

# BASE



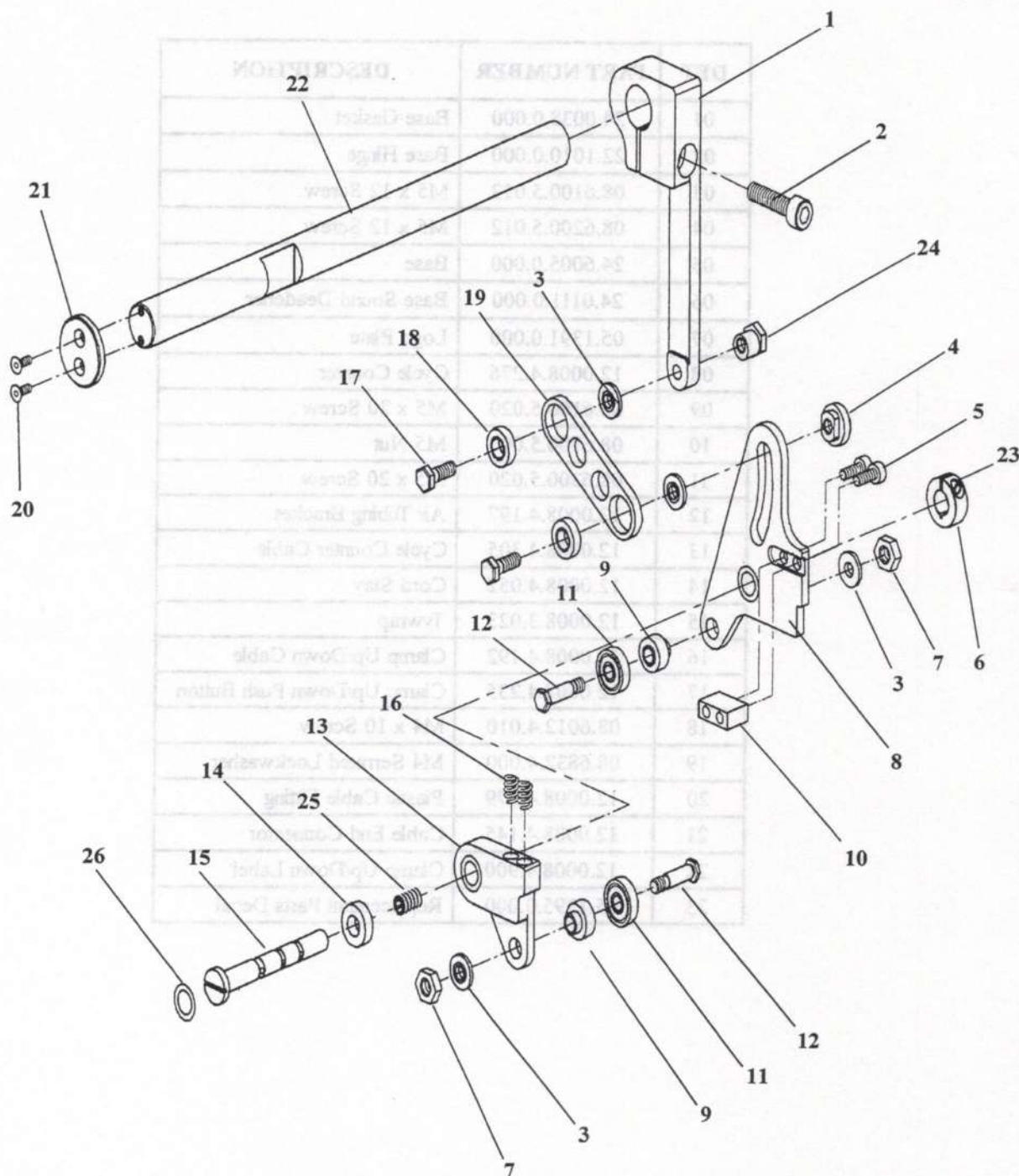


**BASE**

| DET | PART NUMBER   | DESCRIPTION               |
|-----|---------------|---------------------------|
| 01  | 24.0038.0.000 | Base Gasket               |
| 02  | 22.1010.0.000 | Base Hinge                |
| 03  | 08.6100.5.012 | M5 x 12 Screw             |
| 04  | 08.6200.5.012 | M5 x 12 Screw             |
| 05  | 24.6005.0.000 | Base                      |
| 06  | 24.0111.0.000 | Base Sound Deadener       |
| 07  | 05.1391.0.000 | Logo Plate                |
| 08  | 12.0008.4.276 | Cycle Counter             |
| 09  | 08.6100.5.020 | M5 x 20 Screw             |
| 10  | 08.6700.5.000 | M5 Nut                    |
| 11  | 08.6200.5.020 | M5 x 20 Screw             |
| 12  | 12.0008.4.197 | Air Tubing Bracket        |
| 13  | 12.0008.4.305 | Cycle Counter Cable       |
| 14  | 12.0008.4.052 | Cord Stay                 |
| 15  | 12.0008.3.023 | Tywrap                    |
| 16  | 12.0008.4.192 | Clamp Up/Down Cable       |
| 17  | 12.0008.4.235 | Clamp Up/Down Push Button |
| 18  | 08.6012.4.010 | M4 x 10 Screw             |
| 19  | 08.6832.4.000 | M4 Serrated Lockwasher    |
| 20  | 12.0008.4.279 | Plastic Cable Fitting     |
| 21  | 12.0008.4.145 | Cable End Connector       |
| 22  | 12.0008.4.900 | Clamp Up/Down Label       |
| 23  | 05.1395.0.000 | Replacement Parts Decal   |



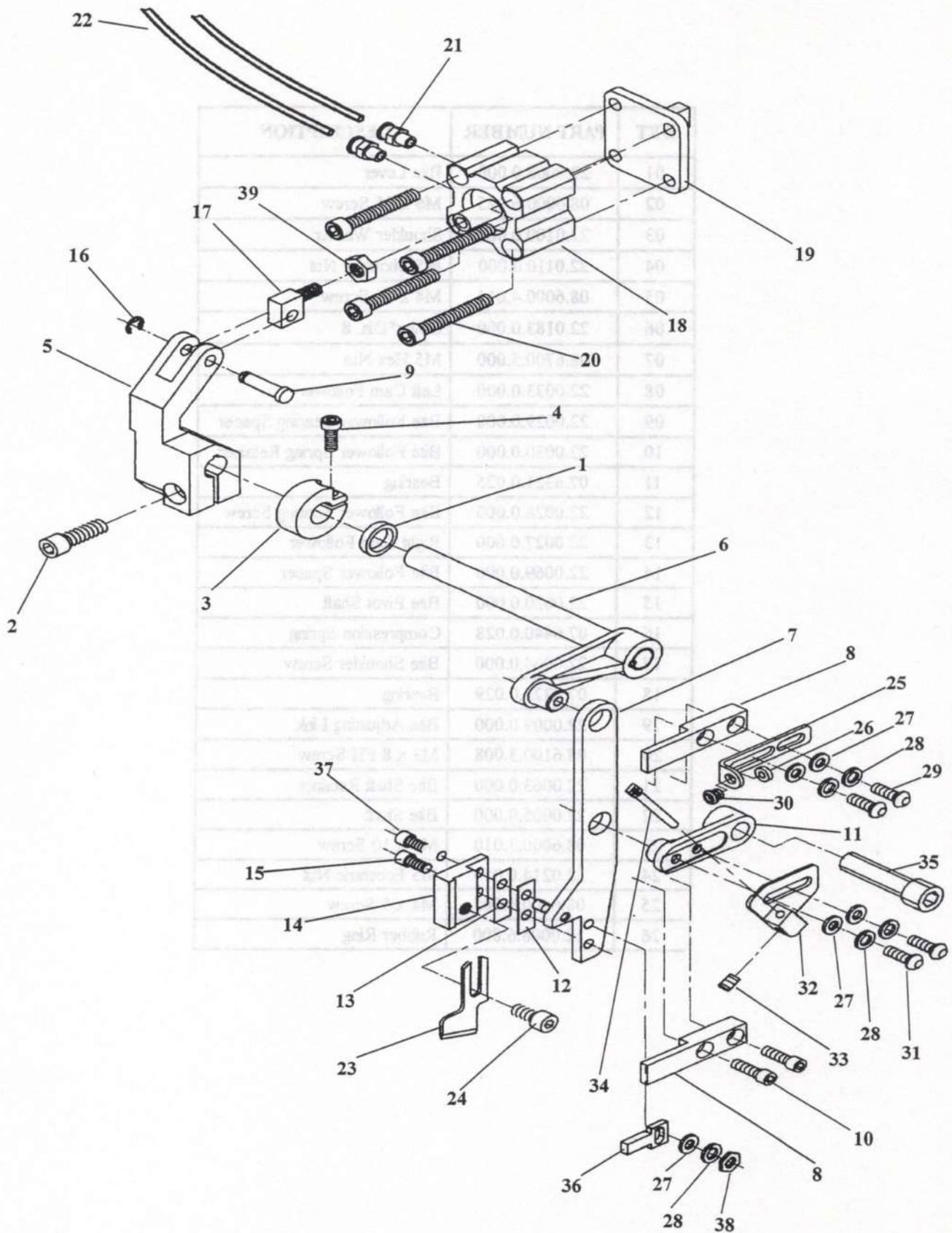
# BITE MECHANISM



**BITE MECHANISM**

| DET | PART NUMBER   | DESCRIPTION                   |
|-----|---------------|-------------------------------|
| 01  | 22.0008.0.000 | Bite Lever                    |
| 02  | 08.6000.6.025 | M6 x 25 Screw                 |
| 03  | 22.0100.0.000 | Shoulder Washer               |
| 04  | 22.0110.0.000 | M5 Shoulder Nut               |
| 05  | 08.6000.4.014 | M4 x 14 Screw                 |
| 06  | 22.0183.0.000 | Collar*Dia. 8                 |
| 07  | 08.6700.5.000 | M5 Hex Nut                    |
| 08  | 22.0033.0.000 | Left Cam Follower             |
| 09  | 22.0029.0.000 | Bite Follower Bearing Spacer  |
| 10  | 22.0030.0.000 | Bite Follower Spring Retainer |
| 11  | 07.6321.0.025 | Bearing                       |
| 12  | 22.0028.0.000 | Bite Follower Bearing Screw   |
| 13  | 22.0027.0.000 | Right Cam Follower            |
| 14  | 22.0069.0.000 | Bite Follower Spacer          |
| 15  | 22.0020.0.000 | Bite Pivot Shaft              |
| 16  | 07.6440.0.028 | Compression Spring            |
| 17  | 22.0064.0.000 | Bite Shoulder Screw           |
| 18  | 07.6321.0.029 | Bearing                       |
| 19  | 22.0009.0.000 | Bite Adjusting Link           |
| 20  | 08.6100.3.008 | M3 x 8 FH Screw               |
| 21  | 22.0063.0.000 | Bite Shaft Retainer           |
| 22  | 22.0005.0.000 | Bite Shaft                    |
| 23  | 08.6000.3.010 | M3 x 10 Screw                 |
| 24  | 22.0214.0.000 | M5 Eccentric Nut              |
| 25  | 08.6400.4.005 | M4 x 5 Screw                  |
| 26  | 12.0008.6.800 | Rubber Ring                   |

# KNIFE MECHANISM

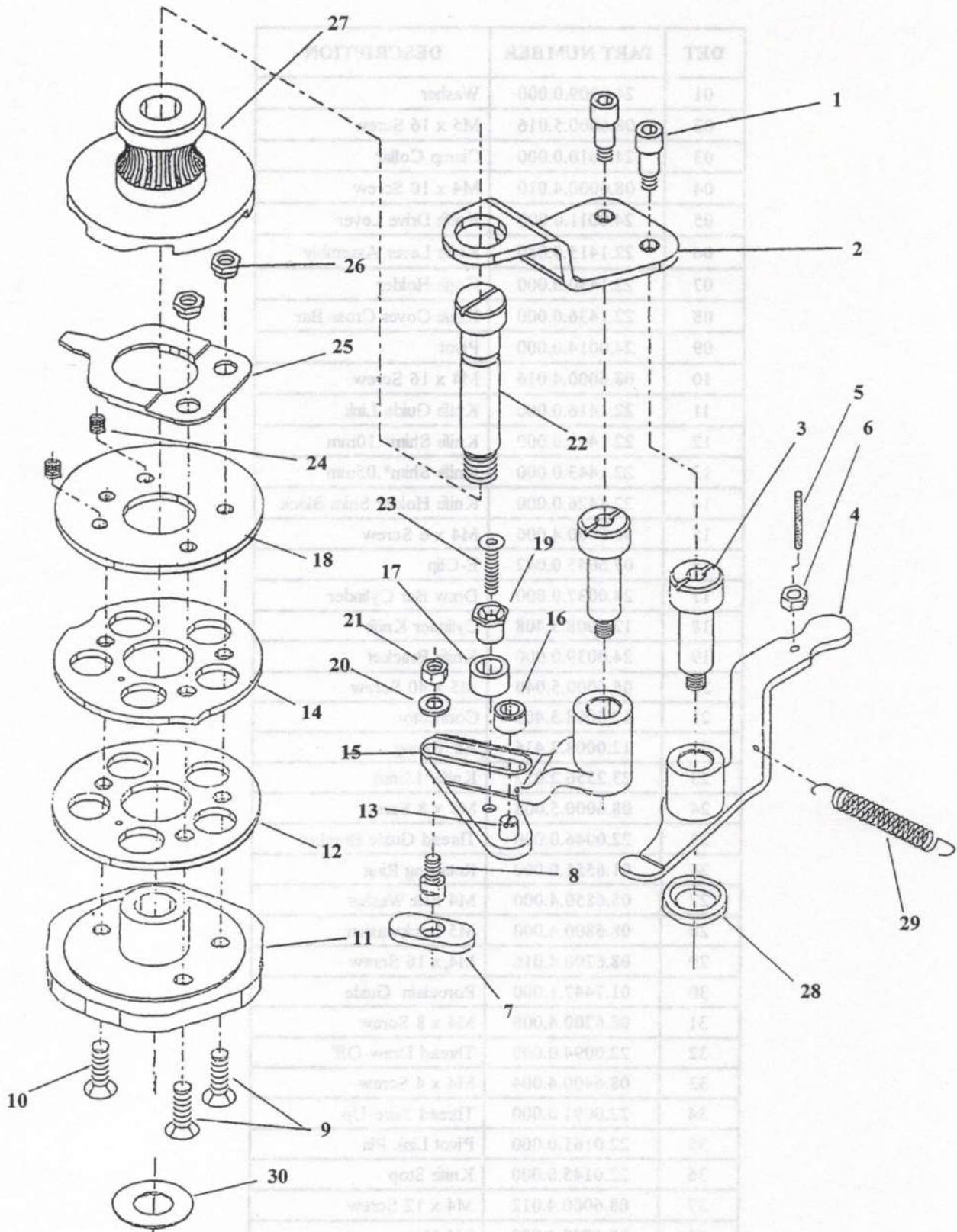




**KNIFE MECHANISM**

| DET | PART NUMBER   | DESCRIPTION             |
|-----|---------------|-------------------------|
| 01  | 24.0009.0.000 | Washer                  |
| 02  | 08.6000.5.016 | M5 x 16 Screw           |
| 03  | 24.0010.0.000 | Clamp Collar            |
| 04  | 08.6000.4.010 | M4 x 10 Screw           |
| 05  | 24.0011.0.000 | Knife Drive Lever       |
| 06  | 22.1415.0.050 | Knife Lever Assembly    |
| 07  | 22.1430.0.000 | Knife Holder            |
| 08  | 22.1436.0.000 | Knife Cover Cross Bar   |
| 09  | 24.0014.0.000 | Pivot                   |
| 10  | 08.6000.4.016 | M4 x 16 Screw           |
| 11  | 22.1416.0.000 | Knife Guide Link        |
| 12  | 22.1442.0.000 | Knife Shim*.10mm        |
| 13  | 22.1443.0.000 | Knife Shim*.05mm        |
| 14  | 22.1426.0.000 | Knife Holder Shim Block |
| 15  | 08.6000.4.006 | M4 x 6 Screw            |
| 16  | 07.6045.0.042 | E-Clip                  |
| 17  | 24.0037.0.000 | Draw Bar Cylinder       |
| 18  | 12.0008.3.408 | Cylinder Knife          |
| 19  | 24.0039.0.000 | Knife Bracket           |
| 20  | 08.6000.5.040 | M5 x 40 Screw           |
| 21  | 12.0008.3.409 | Connector               |
| 22  | 12.0008.3.416 | Air Tubing              |
| 23  | 23.2356.2.052 | Knife*13mm              |
| 24  | 08.6000.5.008 | M5 x 8 Screw            |
| 25  | 22.0046.0.000 | Thread Guide Bracket    |
| 26  | 01.6551.0.000 | Retaining Ring          |
| 27  | 08.6850.4.000 | M4 Flat Washer          |
| 28  | 08.6800.4.000 | M5 Lockwasher           |
| 29  | 08.6200.4.016 | M4 x 16 Screw           |
| 30  | 01.7447.1.000 | Porcelain Guide         |
| 31  | 08.6200.4.008 | M4 x 8 Screw            |
| 32  | 22.0094.0.000 | Thread Draw-Off         |
| 33  | 08.6400.4.004 | M4 x 4 Screw            |
| 34  | 22.0091.0.000 | Thread Take-Up          |
| 35  | 22.0161.0.000 | Pivot Link Pin          |
| 36  | 22.0145.0.000 | Knife Stop              |
| 37  | 08.6000.4.012 | M4 x 12 Screw           |
| 38  | 08.6700.4.000 | M4 Nut                  |
| 39  | 08.6710.6.000 | M6 Nut                  |

# MAIN CAM





**MAIN CAM**

| DET | PART NUMBER   | DESCRIPTION                |
|-----|---------------|----------------------------|
| 01  | 22.0182.0.000 | M5 x 4 Screw               |
| 02  | 22.0097.0.000 | Main Cam Brace             |
| 03  | 22.0106.0.000 | Hub Shoulder Screw         |
| 04  | 24.2640.0.050 | Feed Reversing Lever       |
| 05  | 08.6400.3.020 | M3 x 20 Set Screw          |
| 06  | 08.6700.3.000 | M3 Nut                     |
| 07  | 22.2631.0.000 | Clamp Plate Slidestone     |
| 08  | 22.2633.0.000 | Slidestone Retaining Screw |
| 09  | 22.0137.0.000 | M5 x 14 Screw              |
| 10  | 08.6100.5.010 | M5 x 10 Screw              |
| 11  | 22.2600.0.000 | Barring Cam                |
| 12  | 22.3069.0.000 | Spacer                     |
| 13  | 22.2637.0.000 | Barring Lever Stud         |
| 14  | 22.2620.0.000 | Feed Reversing Cam         |
| 15  | 22.2630.0.000 | Barring Lever              |
| 16  | 22.2639.0.000 | Barring Lever Roller       |
| 17  | 22.2638.0.000 | Barring Lever Roller       |
| 18  | 24.0041.0.000 | Washer                     |
| 19  | 22.2635.0.000 | Barring Lever Eccentric    |
| 20  | 08.6850.5.000 | M5 Washer                  |
| 21  | 08.6700.5.000 | M5 Nut                     |
| 22  | 22.2610.0.000 | Main Cam Shoulder Screw    |
| 23  | 08.6100.4.012 | M4 x 12 Screw              |
| 24  | 07.6440.0.037 | Spring                     |
| 25  | 22.2626.0.000 | Drive Disk Switch Spring   |
| 26  | 22.2627.0.000 | Shoulder Nut               |
| 27  | 22.2607.0.000 | Drive Disk/Worm Gear Hub   |
| 28  | 22.3003.0.000 | Spacer                     |
| 29  | 07.6440.0.045 | Extension Spring           |
| 30  | 07.6321.0.001 | Thrust Washer              |



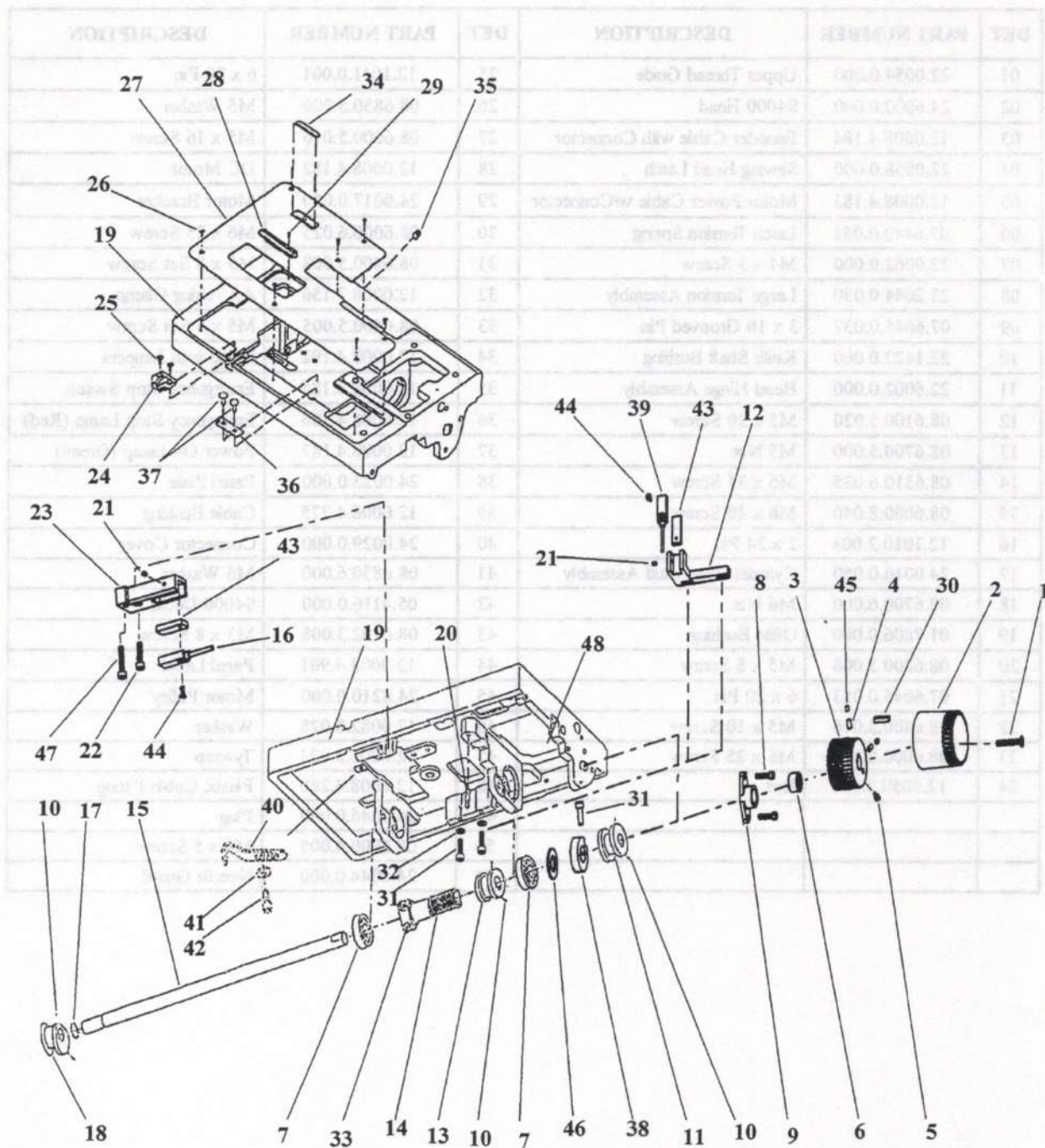


## HEAD ASSEMBLY

| DET | PART NUMBER   | DESCRIPTION                   | DET | PART NUMBER   | DESCRIPTION               |
|-----|---------------|-------------------------------|-----|---------------|---------------------------|
| 01  | 22.0054.0.000 | Upper Thread Guide            | 25  | 12.1011.0.001 | 6 x 20 Pin                |
| 02  | 24.6000.0.000 | S4000 Head                    | 26  | 08.6850.5.000 | M5 Washer                 |
| 03  | 12.0008.4.184 | Encoder Cable with Connector  | 27  | 08.6000.5.016 | M5 x 16 Screw             |
| 04  | 22.0058.0.000 | Sewing Head Latch             | 28  | 12.0008.4.182 | DC Motor                  |
| 05  | 12.0008.4.183 | Motor Power Cable w/Connector | 29  | 24.0017.0.050 | Motor Bracket             |
| 06  | 07.6440.0.051 | Latch Tension Spring          | 30  | 08.6000.6.025 | M6 x 25 Screw             |
| 07  | 22.0062.0.000 | M4 x 3 Screw                  | 31  | 08.6400.5.008 | M5 x 8 Set Screw          |
| 08  | 23.2044.0.050 | Large Tension Assembly        | 32  | 12.0008.3.156 | Air Tubing Clamp          |
| 09  | 07.6045.0.037 | 3 x 16 Grooved Pin            | 33  | 08.6400.5.005 | M5 x 5 Set Screw          |
| 10  | 22.1422.0.000 | Knife Shaft Bushing           | 34  | 12.0008.4.192 | Cable with Jumpers        |
| 11  | 22.6002.0.000 | Head Hinge Assembly           | 35  | 12.0008.4.185 | Emergency Stop Switch     |
| 12  | 08.6100.5.020 | M5 x 20 Screw                 | 36  | 12.0008.4.186 | Emergency Stop Lamp (Red) |
| 13  | 08.6700.5.000 | M5 Nut                        | 37  | 12.0008.4.187 | Power On Lamp (Green)     |
| 14  | 08.6310.6.035 | M6 x 35 Screw                 | 38  | 24.0023.0.000 | Panel Plate               |
| 15  | 08.6000.8.040 | M8 x 40 Screw                 | 39  | 12.0008.4.275 | Cable Bushing             |
| 16  | 12.1010.2.003 | 2 x 24 Pin                    | 40  | 24.0029.0.000 | Connector Cover           |
| 17  | 24.0016.0.050 | Cylinder Pivot Stud Assembly  | 41  | 08.6850.6.000 | M6 Washer                 |
| 18  | 08.6700.6.000 | M6 Nut                        | 42  | 05.4116.0.000 | S4000 Decal               |
| 19  | 01.7806.0.000 | Oilite Bushing                | 43  | 08.6102.3.008 | M3 x 8 Screw              |
| 20  | 08.6200.5.008 | M5 x 8 Screw                  | 44  | 12.0008.4.901 | Panel Label               |
| 21  | 07.6045.0.053 | 6 x 20 Pin                    | 45  | 24.8210.0.000 | Motor Pulley              |
| 22  | 08.6400.5.010 | M5 x 10 Screw                 | 46  | 17.0082.8.028 | Washer                    |
| 23  | 08.6000.8.025 | M8 x 25 Screw                 | 47  | 12.0008.3.023 | Tywrap                    |
| 24  | 12.5050.2.003 | Belt                          | 48  | 12.0008.4.280 | Plastic Cable Fitting     |
|     |               |                               | 49  | 24.0046.0.000 | Plug                      |
|     |               |                               | 50  | 08.6000.4.005 | M4 x 5 Screw              |
|     |               |                               | 51  | 24.0044.0.000 | Needle Guard              |



# BEDPLATE

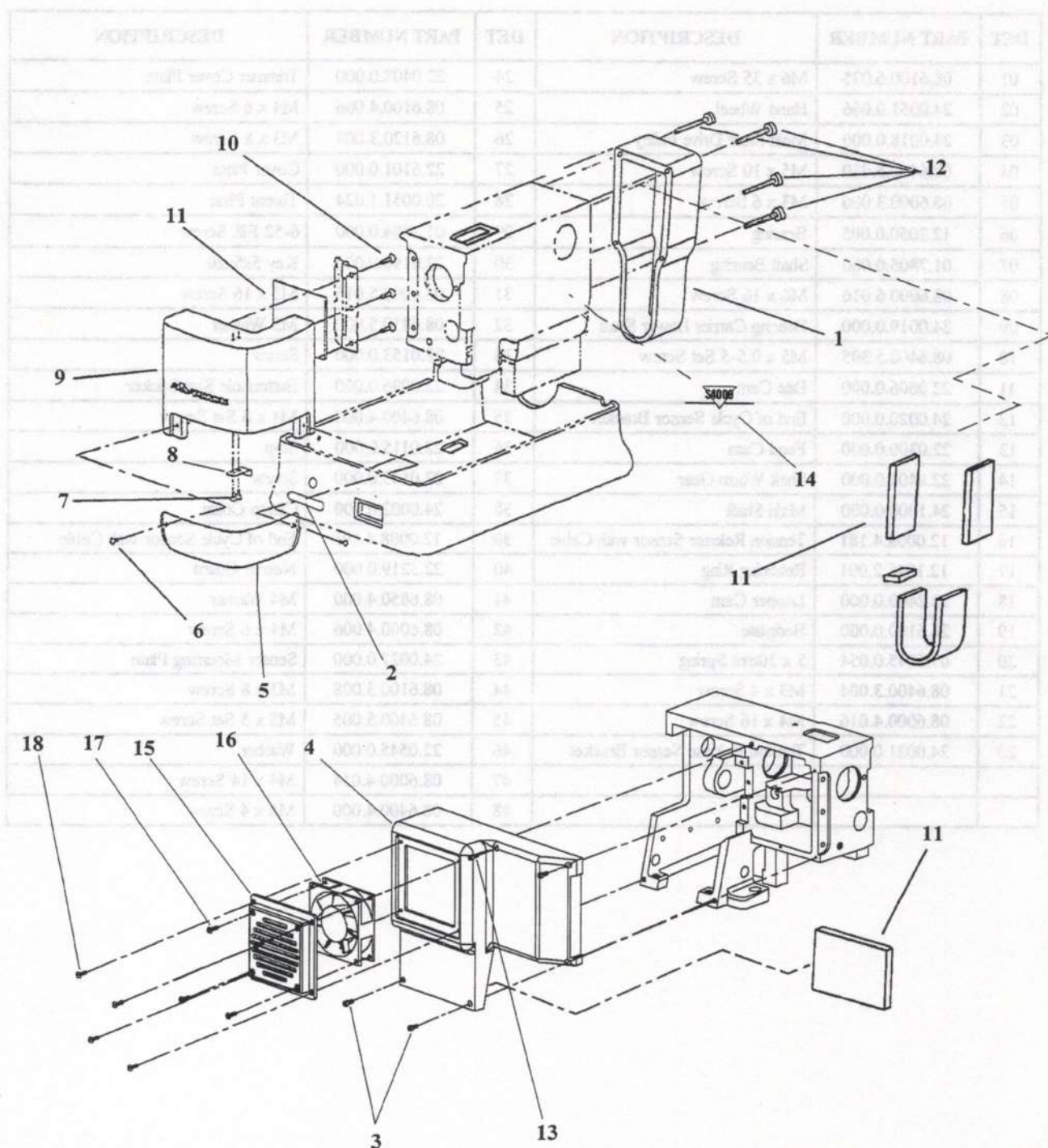




## BEDPLATE

| DET | PART NUMBER   | DESCRIPTION                       | DET | PART NUMBER   | DESCRIPTION                    |
|-----|---------------|-----------------------------------|-----|---------------|--------------------------------|
| 01  | 08.6100.6.035 | M6 x 35 Screw                     | 24  | 22.0408.0.000 | Trimmer Cover Plate            |
| 02  | 24.0051.0.066 | Hand Wheel                        | 25  | 08.6100.4.006 | M4 x 6 Screw                   |
| 03  | 24.0018.0.000 | Main Shaft Drive Pulley           | 26  | 08.6120.3.008 | M3 x 8 Screw                   |
| 04  | 08.6400.5.010 | M5 x 10 Screw                     | 27  | 22.6101.0.000 | Cover Plate                    |
| 05  | 08.6000.3.006 | M3 x 6 Screw                      | 28  | 20.0051.1.024 | Throat Plate                   |
| 06  | 12.2050.0.005 | Bearing                           | 29  | 01.2084.0.000 | 6-52 Fill Screw                |
| 07  | 01.7805.0.000 | Shaft Bearing                     | 30  | 22.0190.0.000 | Key 5x5x20                     |
| 08  | 08.6000.6.016 | M6 x 16 Screw                     | 31  | 08.6000.5.016 | M5 x 16 Screw                  |
| 09  | 24.0019.0.000 | Bearing Carrier Lower Shaft       | 32  | 08.6850.5.000 | M5 Washer                      |
| 10  | 08.6400.5.305 | M5 x 0.5-5 Set Screw              | 33  | 22.0153.0.000 | Screw                          |
| 11  | 22.0006.0.000 | Bite Cam                          | 34  | 22.0096.0.000 | Buttonhole Size Sticker        |
| 12  | 24.0020.0.000 | End of Cycle Sensor Bracket       | 35  | 08.6400.4.006 | M4 x 6 Set Screw               |
| 13  | 22.0300.0.000 | Feed Cam                          | 36  | 22.0115.0.000 | Stop                           |
| 14  | 22.8400.0.000 | Shaft Worm Gear                   | 37  | 22.0143.0.000 | Screw                          |
| 15  | 24.1000.0.000 | Main Shaft                        | 38  | 24.0002.0.000 | Clamp Collar                   |
| 16  | 12.0008.4.181 | Tension Release Sensor with Cable | 39  | 12.0008.4.191 | End of Cycle Sensor with Cable |
| 17  | 12.1045.2.001 | Retaining Ring                    | 40  | 22.3219.0.000 | Needle Guard                   |
| 18  | 22.2400.0.000 | Looper Cam                        | 41  | 08.6850.4.000 | M4 Washer                      |
| 19  | 24.6100.0.000 | Bedplate                          | 42  | 08.6000.4.006 | M4 x 6 Screw                   |
| 20  | 07.6045.0.054 | 5 x 20mm Spring                   | 43  | 24.0027.0.000 | Sensor Mounting Plate          |
| 21  | 08.6400.3.004 | M3 x 4 Screw                      | 44  | 08.6100.3.008 | M3 x 8 Screw                   |
| 22  | 08.6000.4.016 | M4 x 16 Screw                     | 45  | 08.6400.5.005 | M5 x 5 Set Screw               |
| 23  | 24.0021.0.000 | Tension Release Sensor Bracket    | 46  | 22.0545.0.000 | Washer                         |
|     |               |                                   | 47  | 08.6000.4.014 | M4 x 14 Screw                  |
|     |               |                                   | 48  | 08.6400.4.000 | M4 x 4 Screw                   |

# COVERS



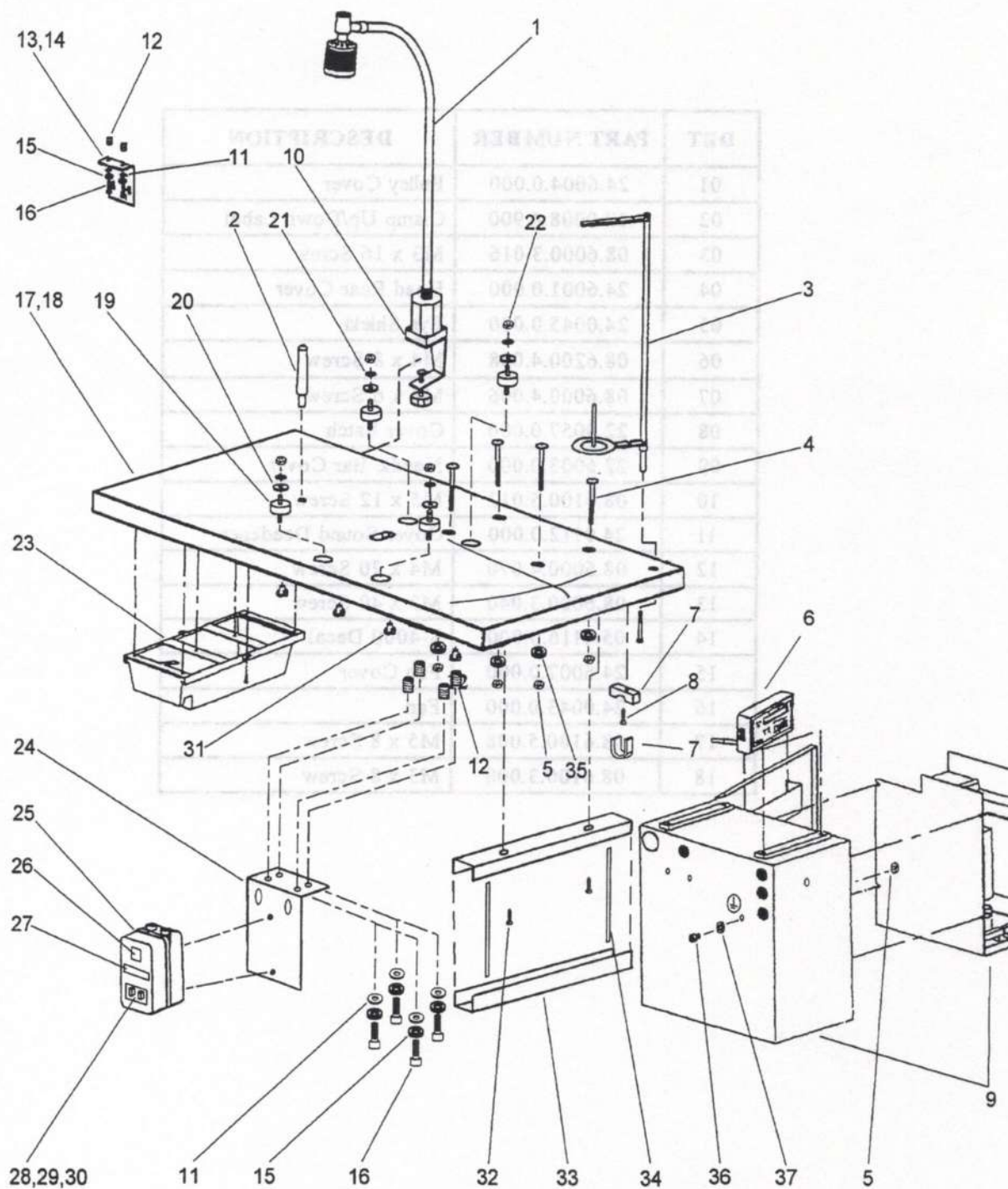


**COVERS**

| DET | PART NUMBER   | DESCRIPTION          |
|-----|---------------|----------------------|
| 01  | 24.6004.0.000 | Pulley Cover         |
| 02  | 12.0008.4.900 | Clamp Up/Down Label  |
| 03  | 08.6000.3.016 | M3 x 16 Screw        |
| 04  | 24.6001.0.000 | Head Rear Cover      |
| 05  | 24.0045.0.000 | Eye Shield           |
| 06  | 08.6200.4.008 | M4 x 8 Screw         |
| 07  | 08.6000.4.006 | M4 x 6 Screw         |
| 08  | 22.0057.0.000 | Cover Latch          |
| 09  | 22.6003.0.000 | Needle Bar Cover     |
| 10  | 08.6100.5.012 | M5 x 12 Screw        |
| 11  | 24.0112.0.000 | Cover Sound Deadener |
| 12  | 08.6000.4.070 | M4 x 70 Screw        |
| 13  | 08.6000.3.040 | M3 x 40 Screw        |
| 14  | 05.4116.0.000 | S-4000 Decal         |
| 15  | 24.6007.0.000 | Fan Cover            |
| 16  | 24.0043.0.000 | Fan                  |
| 17  | 08.6100.5.008 | M5 x 8 Screw         |
| 18  | 08.6100.3.008 | M3 x 8 Screw         |

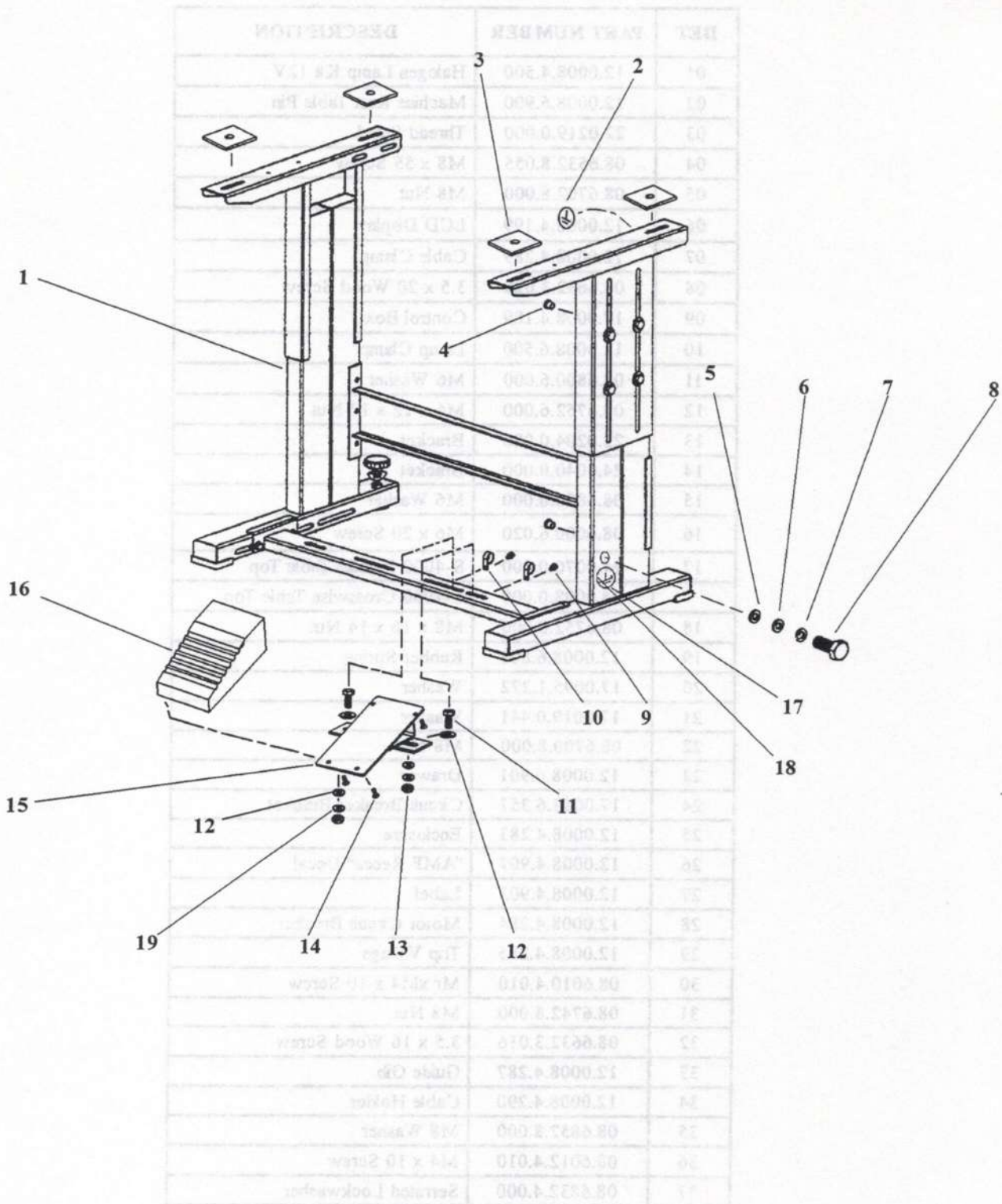


# TABLES



**TABLES**

| DET | PART NUMBER   | DESCRIPTION                |
|-----|---------------|----------------------------|
| 01  | 12.0008.4.500 | Halogen Lamp Kit 12V       |
| 02  | 12.0008.6.900 | Machine Rest Table Pin     |
| 03  | 22.0219.0.000 | Thread Stand               |
| 04  | 08.6532.8.055 | M8 x 55 Screw              |
| 05  | 08.6702.8.000 | M8 Nut                     |
| 06  | 12.0008.4.199 | LCD Display                |
| 07  | 12.0008.4.289 | Cable Clamp                |
| 08  | 08.6632.3.020 | 3.5 x 20 Wood Screw        |
| 09  | 12.0008.4.189 | Control Box                |
| 10  | 12.0008.6.500 | Lamp Clamp                 |
| 11  | 08.6800.6.000 | M6 Washer                  |
| 12  | 08.6752.6.000 | M6 x 12 x 12 Nut           |
| 13  | 22.0204.0.000 | Bracket                    |
| 14  | 24.0040.0.000 | Bracket                    |
| 15  | 08.6850.6.000 | M6 Washer                  |
| 16  | 08.6000.6.020 | M6 x 20 Screw              |
| 17  | 24.0070.0.000 | S-4000 Parallel Table Top  |
|     | 24.0098.0.000 | S-4000 Crosswise Table Top |
| 18  | 08.6752.8.000 | M8 x 16 x 14 Nut           |
| 19  | 12.0008.6.801 | Rubber Spring              |
| 20  | 17.0095.1.272 | Washer                     |
| 21  | 17.0019.0.441 | Washer                     |
| 22  | 08.6700.8.000 | M8 Nut                     |
| 23  | 12.0008.6.901 | Drawer                     |
| 24  | 17.0083.6.357 | Circuit Breaker Bracket    |
| 25  | 12.0008.4.283 | Enclosure                  |
| 26  | 12.0008.4.907 | "AMF Reece" Decal          |
| 27  | 12.0008.4.903 | Label                      |
| 28  | 12.0008.4.284 | Motor Circuit Breaker      |
| 29  | 12.0008.4.285 | Trip Voltage               |
| 30  | 08.6010.4.010 | Mr xM4 x 10 Screw          |
| 31  | 08.6742.8.000 | M8 Nut                     |
| 32  | 08.6632.3.016 | 3.5 x 16 Wood Screw        |
| 33  | 12.0008.4.287 | Guide Gib                  |
| 34  | 12.0008.4.290 | Cable Holder               |
| 35  | 08.6852.8.000 | M8 Washer                  |
| 36  | 08.6012.4.010 | M4 x 10 Screw              |
| 37  | 08.6832.4.000 | Serrated Lockwasher        |

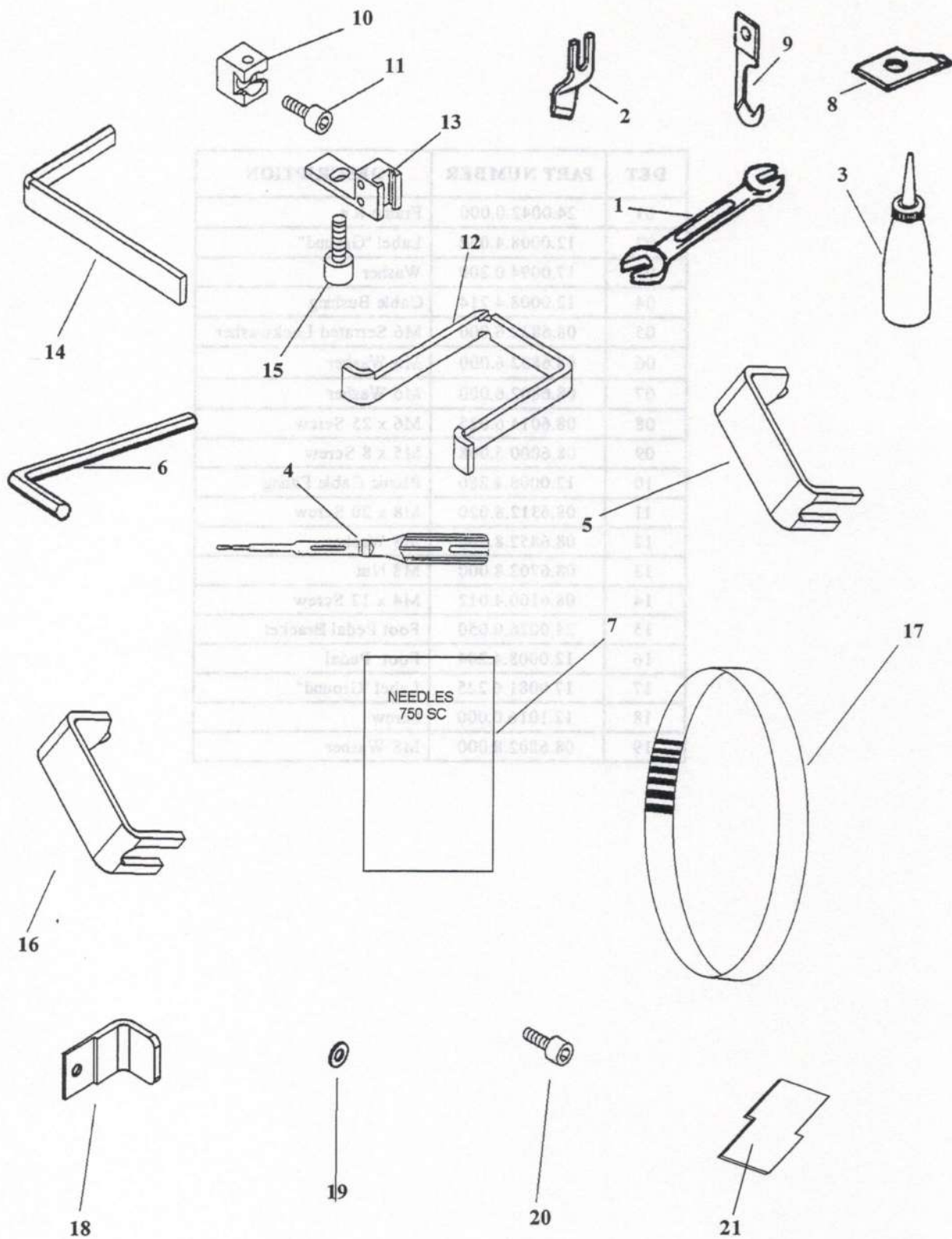




# TABLES

| DET | PART NUMBER   | DESCRIPTION            |
|-----|---------------|------------------------|
| 01  | 24.0042.0.000 | Frame Kit              |
| 02  | 12.0008.4.052 | Label "Ground"         |
| 03  | 17.0094.0.200 | Washer                 |
| 04  | 12.0008.4.214 | Cable Bushing          |
| 05  | 08.6832.6.000 | M6 Serrated Lockwasher |
| 06  | 08.6852.6.000 | M6 Washer              |
| 07  | 08.6802.6.000 | M6 Washer              |
| 08  | 08.6014.6.025 | M6 x 25 Screw          |
| 09  | 08.6000.5.008 | M5 x 8 Screw           |
| 10  | 12.0008.4.280 | Plastic Cable Fitting  |
| 11  | 08.6312.8.020 | M8 x 20 Screw          |
| 12  | 08.6852.8.000 | M8 Washer              |
| 13  | 08.6702.8.000 | M8 Nut                 |
| 14  | 08.6100.4.012 | M4 x 12 Screw          |
| 15  | 24.0026.0.050 | Foot Pedal Bracket     |
| 16  | 12.0008.4.204 | Foot Pedal             |
| 17  | 17.0081.6.225 | Label "Ground"         |
| 18  | 12.1016.0.000 | Screw                  |
| 19  | 08.6802.8.000 | M8 Washer              |

# ACCESSORIES



Released 2/99

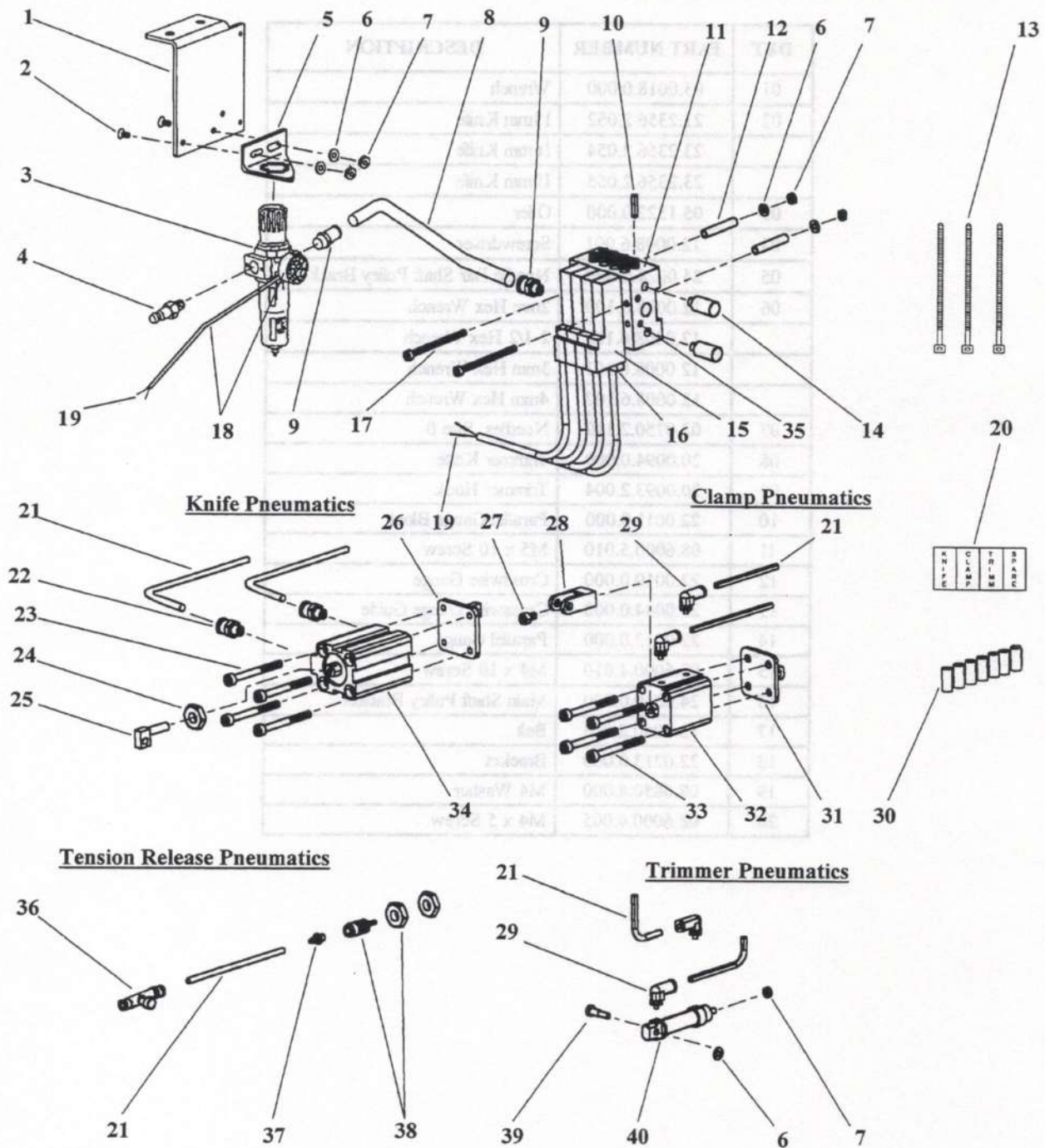
U.S. Phone (800) 237-3323 Fax (800) 432-4303  
 Outside U.S. Phone (804) 559-5000 Fax (804) 559-5290

## ACCESSORIES

| DET | PART NUMBER   | DESCRIPTION                     |
|-----|---------------|---------------------------------|
| 01  | 03.0018.0.000 | Wrench                          |
| 02  | 23.2356.2.052 | 13mm Knife                      |
|     | 23.2356.2.054 | 16mm Knife                      |
|     | 23.2356.2.055 | 19mm Knife                      |
| 03  | 05.1322.0.000 | Oiler                           |
| 04  | 12.0008.6.001 | Screwdriver                     |
| 05  | 24.0024.0.000 | Needle Bar Shaft Pulley Bracket |
| 06  | 12.0008.6.100 | 2mm Hex Wrench                  |
|     | 12.0008.6.112 | 2-1/2 Hex Wrench                |
|     | 12.0008.6.101 | 3mm Hex Wrench                  |
|     | 12.0008.6.102 | 4mm Hex Wrench                  |
| 07  | 02.0750.2.110 | Needles, Size 0                 |
| 08  | 20.0094.0.000 | Trimmer Knife                   |
| 09  | 20.0093.2.004 | Trimmer Hook                    |
| 10  | 22.0011.0.000 | Parallel Gauge Block            |
| 11  | 08.6000.5.010 | M5 x 10 Screw                   |
| 12  | 22.0010.0.000 | Crosswise Gauge                 |
| 13  | 22.0044.0.000 | Crosswise Gauge Guide           |
| 14  | 22.0012.0.000 | Parallel Gauge                  |
| 15  | 08.6000.4.010 | M4 x 10 Screw                   |
| 16  | 24.0030.0.000 | Main Shaft Pulley Bracket       |
| 17  | 12.5050.2.003 | Belt                            |
| 18  | 22.0213.0.000 | Bracket                         |
| 19  | 08.6850.4.000 | M4 Washer                       |
| 20  | 08.6000.4.005 | M4 x 5 Screw                    |



# PNEUMATICS

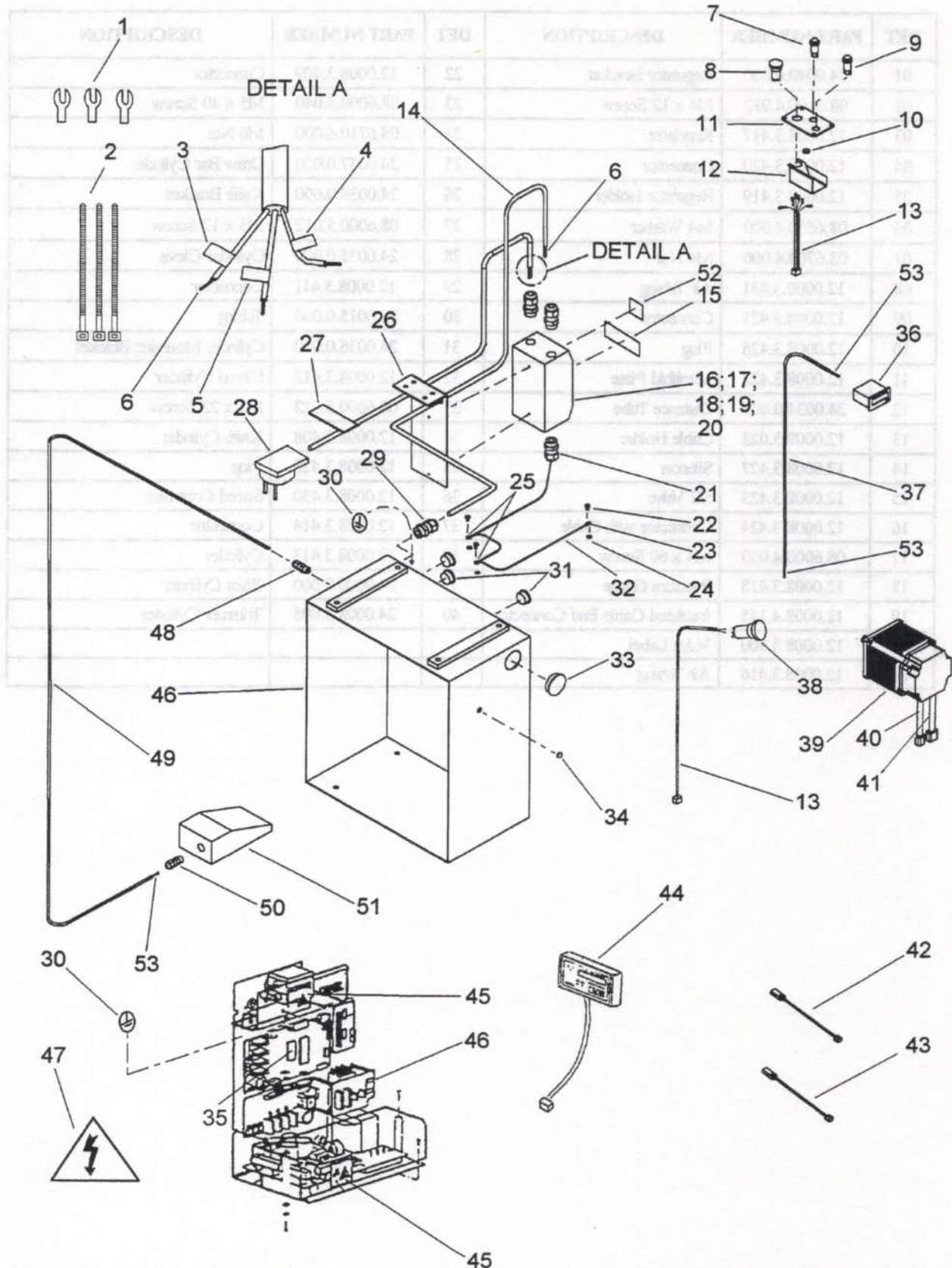


# PNEUMATICS

| DET | PART NUMBER   | DESCRIPTION                   | DET | PART NUMBER   | DESCRIPTION               |
|-----|---------------|-------------------------------|-----|---------------|---------------------------|
| 01  | 24.0040.0.000 | Regulator Bracket             | 22  | 12.0008.3.409 | Connector                 |
| 02  | 08.6100.4.012 | M4 x 12 Screw                 | 23  | 08.6000.5.040 | M5 x 40 Screw             |
| 03  | 12.0008.3.417 | Regulator                     | 24  | 08.6710.6.000 | M6 Nut                    |
| 04  | 12.0008.3.420 | Connector                     | 25  | 24.0037.0.000 | Draw Bar Cylinder         |
| 05  | 12.0008.3.419 | Regulator Holder              | 26  | 24.0039.0.000 | Knife Bracket             |
| 06  | 08.6850.4.000 | M4 Washer                     | 27  | 08.6000.5.012 | M5 x 12 Screw             |
| 07  | 08.6700.4.000 | M4 Nut                        | 28  | 24.0035.0.000 | Cylinder Clevis           |
| 08  | 12.0008.3.431 | Air Tubing                    | 29  | 12.0008.3.411 | Connector                 |
| 09  | 12.0008.3.421 | Connector                     | 30  | 24.0015.0.000 | Tubing                    |
| 10  | 12.0008.3.426 | Plug                          | 31  | 24.0036.0.000 | Cylinder Mounting Bracket |
| 11  | 12.0008.3.422 | Manifold Plate                | 32  | 12.0008.3.412 | Clamp Cylinder            |
| 12  | 24.0034.0.000 | Distance Tube                 | 33  | 08.6000.5.022 | M5 x 22 Screw             |
| 13  | 12.0008.3.023 | Cable Holder                  | 34  | 12.0008.3.408 | Knife Cylinder            |
| 14  | 12.0008.3.427 | Silencer                      | 35  | 12.0008.3.428 | Plug                      |
| 15  | 12.0008.3.423 | 5/2 Valve                     | 36  | 12.0008.3.430 | Speed Controller          |
| 16  | 12.0008.3.424 | Connector with Cable          | 37  | 12.0008.3.414 | Connector                 |
| 17  | 08.6000.4.060 | M4 x 60 Screw                 | 38  | 12.0008.3.413 | Cylinder                  |
| 18  | 12.0008.3.418 | Pressure Gauge                | 39  | 24.0006.0.000 | Pivot Cylinder            |
| 19  | 12.0008.4.145 | Insulated Cable End Connector | 40  | 24.0008.3.005 | Trimmer Cylinder          |
| 20  | 12.0008.3.900 | Valve Label                   |     |               |                           |
| 21  | 12.0008.3.416 | Air Tubing                    |     |               |                           |



# ELECTRICAL BOX ASSEMBLY

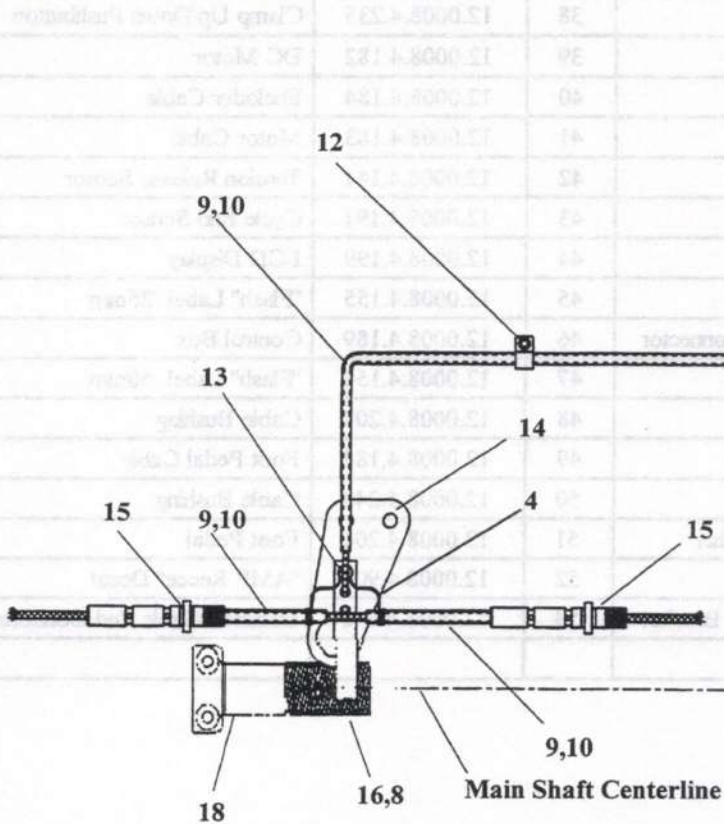
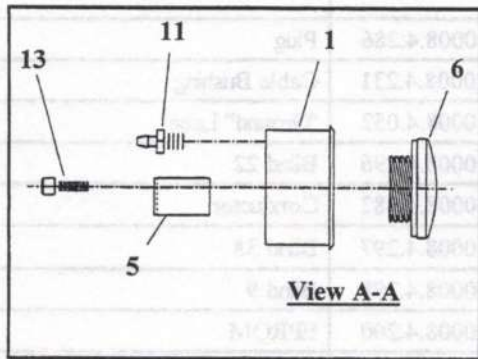




**ELECTRICAL BOX ASSEMBLY**

| DET | PART NUMBER   | DESCRIPTION                   | DET | PART NUMBER   | DESCRIPTION                   |
|-----|---------------|-------------------------------|-----|---------------|-------------------------------|
| 01  | 12.0008.4.295 | Cable Plug                    | 28  | 12.0008.4.286 | Plug                          |
| 02  | 12.0008.4.290 | Cable Holder                  | 29  | 12.0008.4.231 | Cable Bushing                 |
| 03  | 12.0008.4.904 | Conductor Label (U)           | 30  | 12.0008.4.052 | "Ground" Label                |
| 04  | 12.0008.4.905 | Conductor Label (N)           | 31  | 12.0008.4.296 | Blind 22                      |
| 05  | 12.0008.4.906 | Conductor Label (PE)          | 32  | 12.0008.4.282 | Conductor                     |
| 06  | 12.0008.4.291 | Insulated Cable End Connector | 33  | 12.0008.4.297 | Blind 38                      |
| 07  | 12.0008.4.186 | Emergency Stop Button (Red)   | 34  | 12.0008.4.298 | Blind 9                       |
| 08  | 12.0008.4.185 | Emergency Stop Switch         | 35  | 12.0008.4.200 | EPROM                         |
| 09  | 12.0008.4.187 | Power On Button (Green)       | 36  | 12.0008.4.276 | Cycle Counter                 |
| 10  | 12.0008.4.275 | Cable Bushing                 | 37  | 12.0008.4.193 | Cable                         |
| 11  | 24.0023.0.000 | Panel Plate                   | 38  | 12.0008.4.235 | Clamp Up/Down Pushbutton      |
| 12  | 24.0029.0.000 | Connector Cover               | 39  | 12.0008.4.182 | DC Motor                      |
| 13  | 12.0008.4.192 | Cable with Jumpers            | 40  | 12.0008.4.184 | Encoder Cable                 |
| 14  | 12.0008.4.281 | Supply Cable                  | 41  | 12.0008.4.183 | Motor Cable                   |
| 15  | 12.0008.4.903 | Label                         | 42  | 12.0008.4.181 | Tension Release Sensor        |
| 16  | 12.0008.4.284 | Motor Circuit Breaker         | 43  | 12.0008.4.191 | Cycle End Sensor              |
| 17  | 12.0008.4.283 | Enclosure                     | 44  | 12.0008.4.199 | LCD Display                   |
| 18  | 12.0008.4.285 | Voltage Trip                  | 45  | 12.0008.4.155 | "Flash" Label 25mm            |
| 19  | 12.0008.4.292 | Insulated Cable End Connector | 46  | 12.0008.4.189 | Control Box                   |
| 20  | 08.6010.4.010 | M4 x 10 Screw                 | 47  | 12.0008.4.154 | "Flash" Label 50mm            |
| 21  | 12.0008.4.288 | Cable Bushing                 | 48  | 12.0008.4.207 | Cable Bushing                 |
| 22  | 08.6012.4.008 | M4 x 8 Screw                  | 49  | 12.0008.4.188 | Foot Pedal Cable              |
| 23  | 12.0008.4.294 | Insulated Cable Plug          | 50  | 12.0008.4.240 | Cable Bushing                 |
| 24  | 08.6832.4.000 | M4 Serrated Lockwasher        | 51  | 12.0008.4.204 | Foot Pedal                    |
| 25  | 12.0008.4.293 | Insulated Cable Plug          | 52  | 12.0008.4.907 | "AMF Reece" Decal             |
| 26  | 17.0083.6.357 | Motor Circuit Breaker Bracket | 53  | 12.0008.4.146 | Insulated Cable End Connector |
| 27  | 12.0008.4.902 | "Warning" Label               |     |               |                               |

# LUBRICATION



**LUBRICATION**

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| DET | PART NUMBER   | DESCRIPTION             |
|-----|---------------|-------------------------|
| 01  | 22.0104.0.000 | Oil Gauge Reservoir     |
| 02  | 22.0108.0.000 | Wick Holder             |
| 03  | 17.0082.6.000 | Clamp                   |
| 04  | 17.0027.1.799 | Wire                    |
| 05  | 22.0120.0.000 | Holder                  |
| 06  | 17.0095.1.329 | Oil Sight Gauge         |
| 07  | 12.0008.3.023 | Tywrap                  |
| 08  | 17.0094.5.310 | Felt                    |
| 09  | 24.0141.0.000 | Tubing                  |
| 10  | 24.0139.0.000 | Lubricating Wick        |
| 11  | 22.0229.0.000 | Straight Fitting        |
| 12  | 08.6000.3.006 | M3 x 6 Screw            |
| 13  | 08.6000.4.006 | M4 x 6 Screw            |
| 14  | 22.0097.0.000 | Main Cam Brace          |
| 15  | 22.0022.0.000 | Looper Pivot Shaft      |
| 16  | 22.0107.0.000 | Worm Gear Felt Retainer |
| 17  | 01.2140.0.000 | 10-32 Plug              |
| 18  | 22.8400.0.000 | Shaft Worm Gear.        |



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