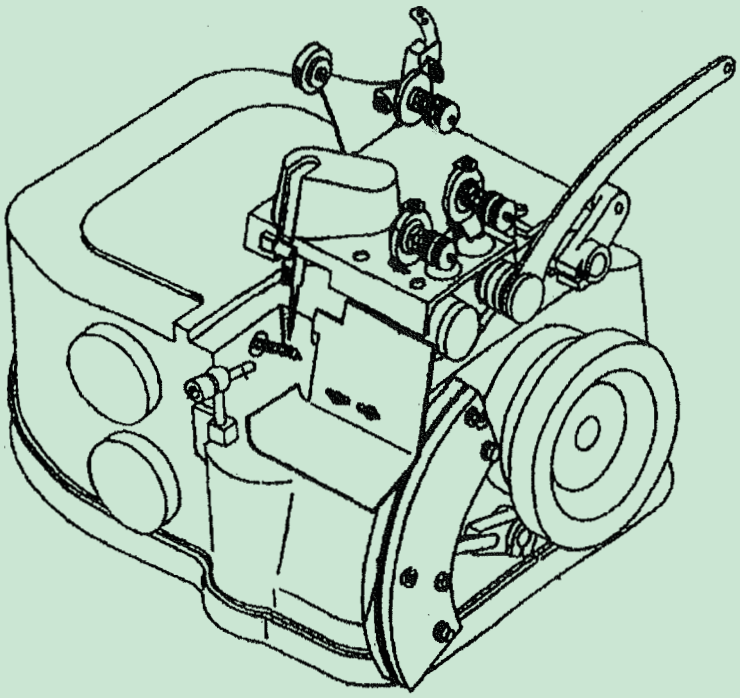
SPECIAL SEWING MACHINE & FOR CARPET OVEREDGIND AK-2500 SEPIES



(FOR RUGS,BLANKETS JUTE,POLYPROPYLENE BAGS, AND EXTRA HEAVY MATERIALS,ETC)

INSTRUCTION MANUAL

OVEREDGING SERIES

INDEX

WHEN ORDERING SPARE PARTS
FOR LEFTHAND CARPET
OVEREDGING MACHINE SERIES
PLEASE MENTION "L"
AFTER THE REFERENCE NUMBER

FITTING INSTRUCTION FOR YARN STAND

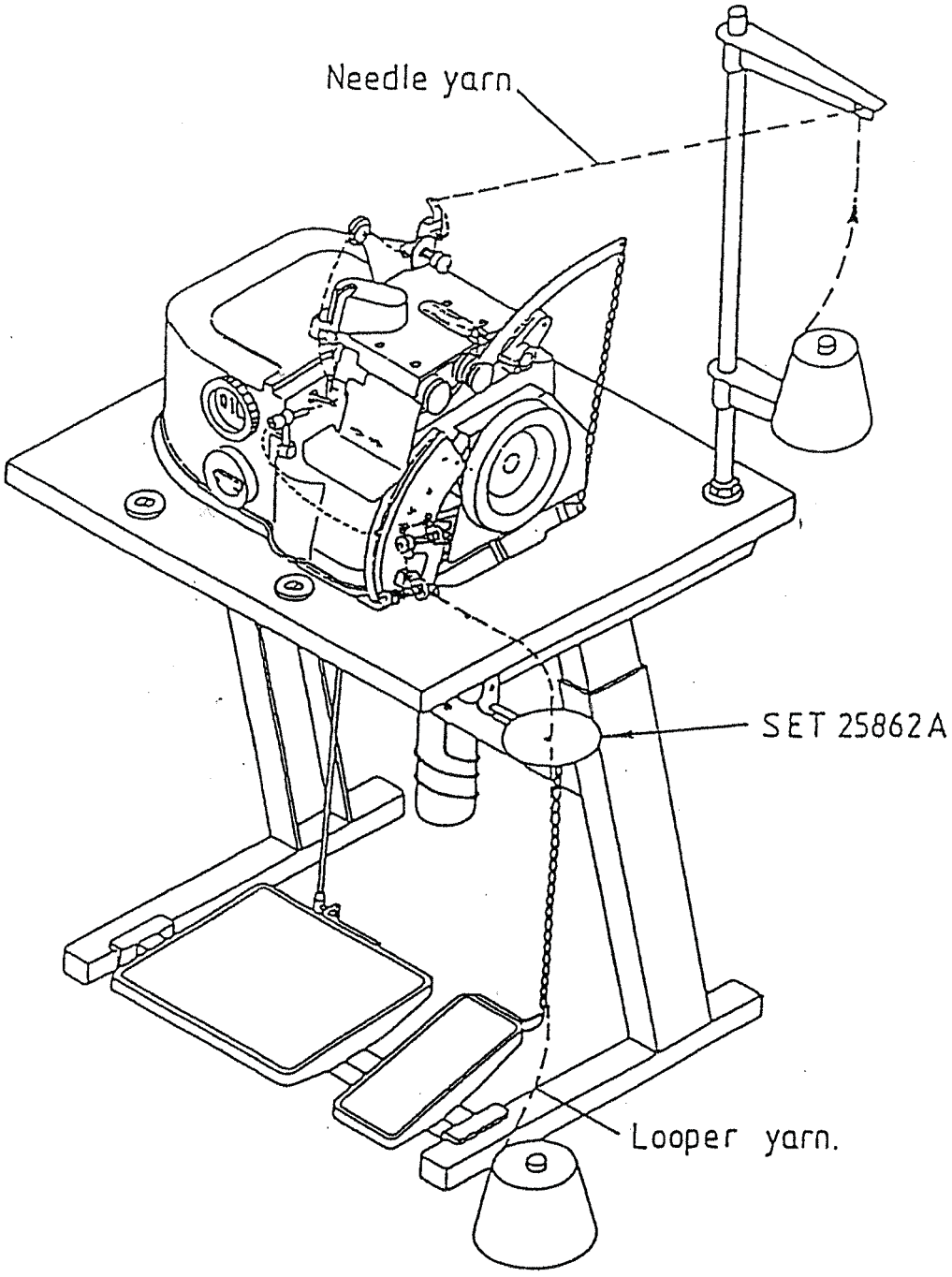
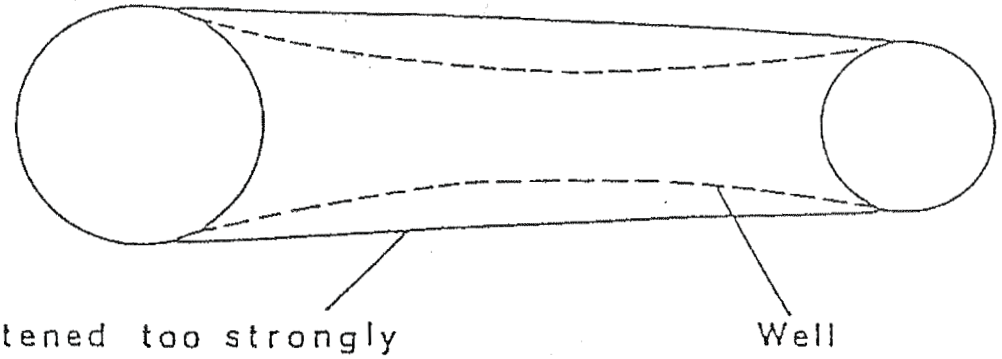
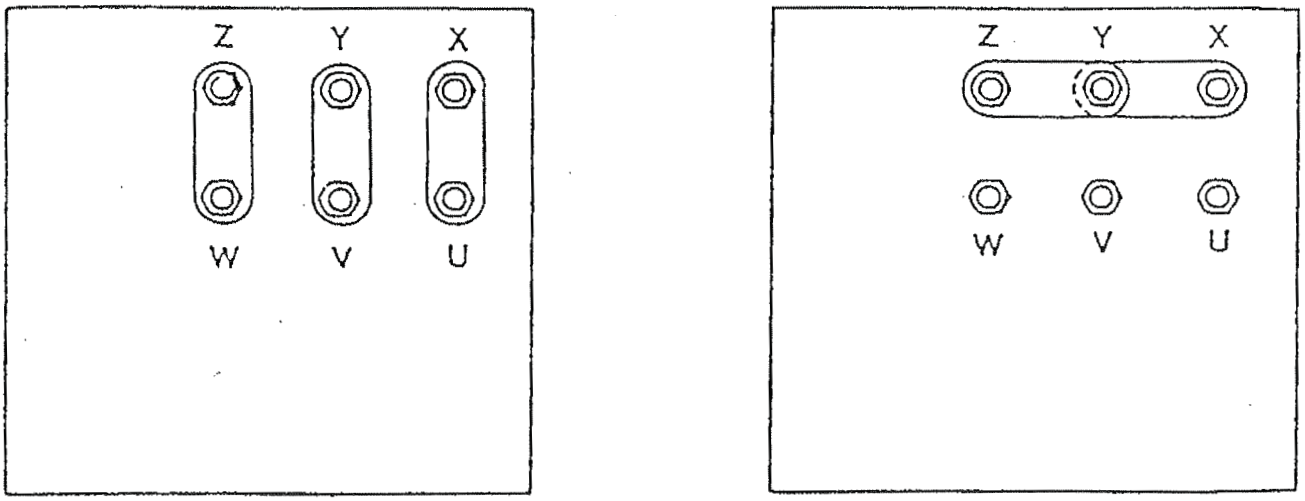


Fig: 1





220 VOLT

380 VOLT

Fig:2 .

SETTING UP OF THE MACHINE

If the machine is supplied complete, assemble stand, table, motor, pedals and bobbin-holder with the help of the drawing of the manual. All bolts and screws are supplied so that there is no difficulty about it. When the machine has been erected, following controls should be carried out:

1. voltage : motor is always supplied fitted for 380 V. If voltage of network is 220 V, change connections as shown fig. 2.

2. Driving belt must be tightened slackly. If tightened too strong shafts could be deformed. For a correct belt tension look at fig. 1.

3. Before starting the machine, check oil level. The gauge must be full. Use only oil having a viscosity of 15W30 either SHELL Telus 37, BP Energol HLP 46 or any other brand having the same viscosity.

When the machine has been supplied without stand, table or motor, a drawing in the manual will show how to cut out and drill the table top.

The motor must have a power of 1 HP or at least 3/4 HP at 3000 RPM and fitted with a V. belt pulley of 80 mm in diameter.

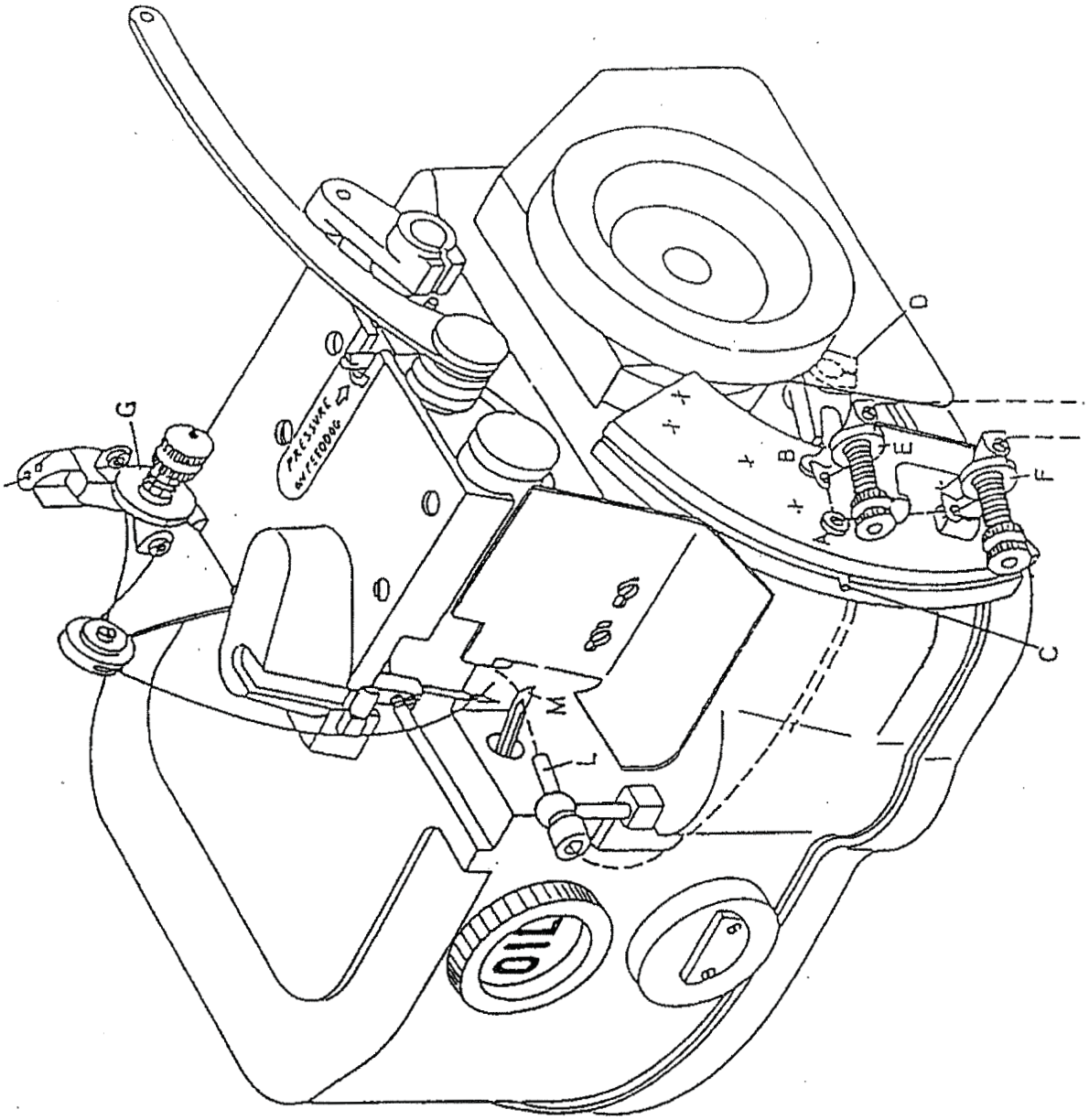
Afterwards check again a.m. points 1, 2 and 3.

LUBRICATION

Carpet overedging machines are high precision machines. Although many parts move on ball bearings or needle-bearings, high speed makes an abundant lubrication necessary. For this reason the machine has been designed with a splash lubrication. Owing to a very special construction, all parts without exception are abundantly supplied with oil. Of course a little oil will disappear each day from the machine when working. As to enable the operator to check this steady and normal loss of oil, an oil level gauge has been fitted.

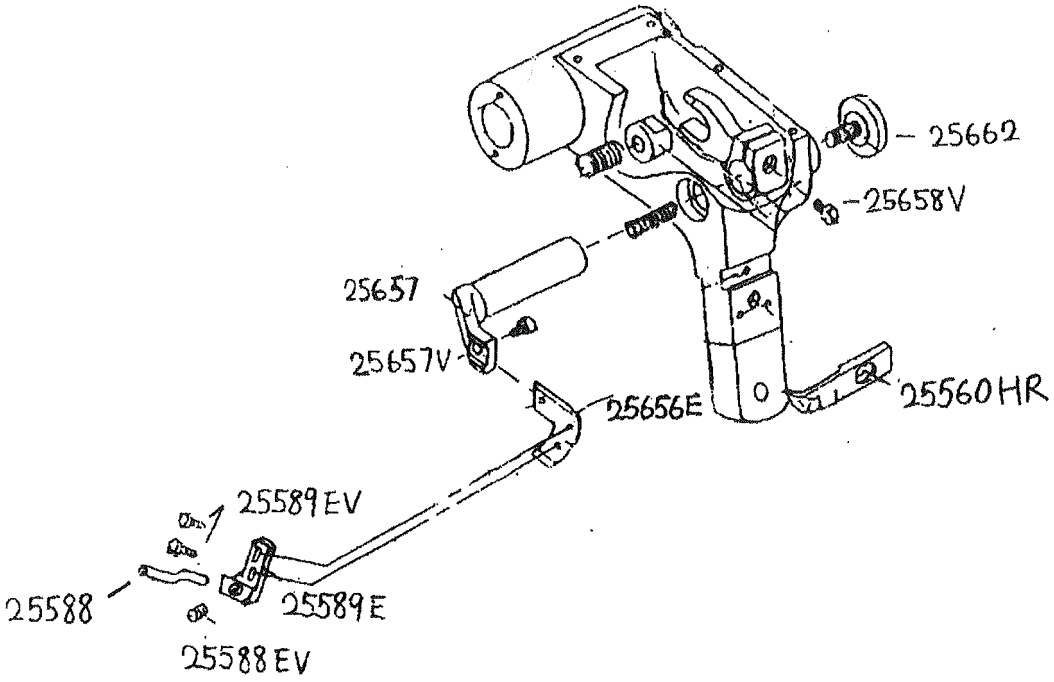
The perfect oil level is situated between both arrows printed on the oil level glass.
If there is too much oil leak. maybe one of the pipes for oil drainage is obstructed. In this case compressed air should be blowed into the hole of the oil plug. to avoid the stopping up of the pipes. Then you will have enough pressure inside the machine to unstop the oil drainage pipes.

THREADING DIAGRAM



THREADING DIAGRAM
(2503)

ANOTHER ELSE



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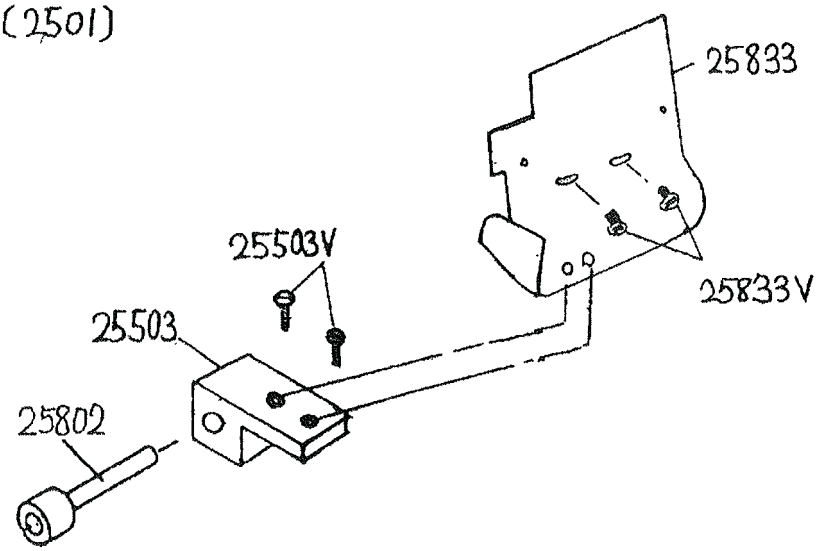

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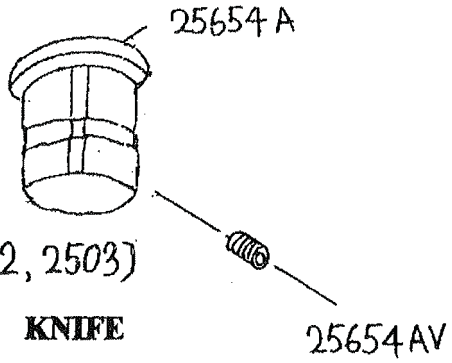


(2501, 2502, 2503)

WITHOUT KNIFE

THREADING DRAWING FOR THE LOWER LOOPER

In order to thread the yarn of the lower looper (M-fig:3.) one proceeds as follows : the motor is stopped, as soon as it has run out completely, the flywheel is rotated by hand until the take up (C-fig:3.) is very exactly in its lowest neutral position, so that the eye of the lower looper stands exactly opposite the leading tube (L-fig:3.). Yarn remainders, if any are removed from the leading tube, the threading needle is taken and the yarn is put in the fork, which is situated in front of the needle , and the yarn is glided through the tube (L-fig:3.) exactly to the eye of the lower hook (M-gis:3.).

The threading needle is taken back and some yarn is still pressed in the threading tube so that there is a small clew of yarn behind the eye of the lower looper (M-fig:3.).

Never forget to remove the threading needle.

Rotate several times by hand until the yarn appears above the throat plate and the stitch has taken its normal shape.

It is possible to thread the lower looper with one or several yarns.

Fig : 4

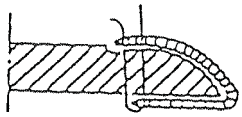


Fig : 5

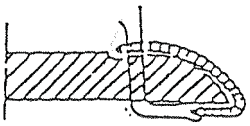


Fig : 6

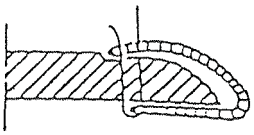


Fig : 7

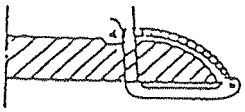


Fig : 8

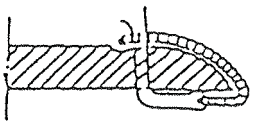


Fig : 9

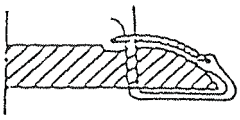
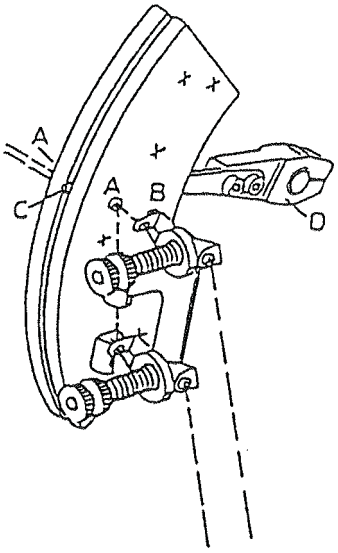


Fig : 11



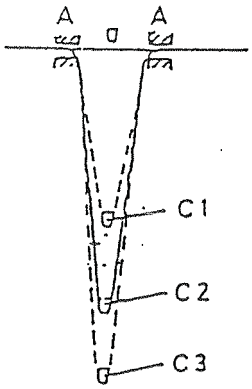
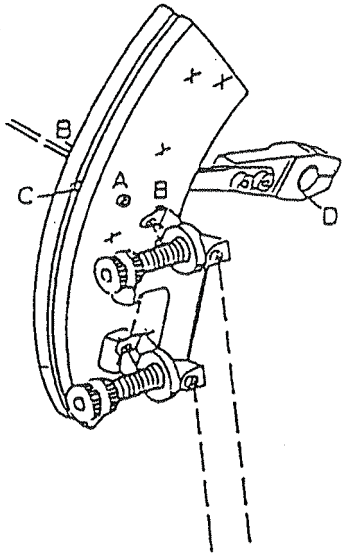


Fig : 10

Fig : 12



OVEREDGING MACHINE

OBTAINING CORRECT STITCH

To obtain a correct stitch (fig. 4) tension regulating discs G, E and F (fig:3) are not very important.

They only restrain lightly the yarns so that the yarn drawing lever C (fig. 11.) will draw a well defined length of yarn.

Therefore it is advisable to tighten the tension regulating discs as slightly as possible.

The yarn drawing lever (fig:11) has an alternating movement. While moving down it draws along the yarn, which slips freely through the threading holes A. So a defined length of yarn is placed at the disposal of the upperlooper. If the lever is well adjusted, the length of yarn drawn will exactly be sufficient to surround the carpet edge, according to the width of stitch (fig.4 and C2 fig:10.)

If length of yarn draw is not sufficient (fig.5 and C1 fig:10), the tension of the needle thread and the tension of the looper thread will not be balanced. Consequently the needle thread will be drawn too far out of the carpet backside.

If the yarn drawing lever draws too much yarn (fig.6 and C3 fig:10.), then the looper thread surrounding the carpet edge will be slack, instead of keeping close to it.

To carry out this adjustment, loosen slightly screw D fig:11. of the lever, then put lever in the right position and tighten screw again.

To obtain a stitchdesign as shown on fig. 7, it is generally sufficient to drive the thread along the thread along the threading holes (B-fig.12).

According to the nature of yarn and material which are used, an additional adjustment of the tension discs might have to be carried out.

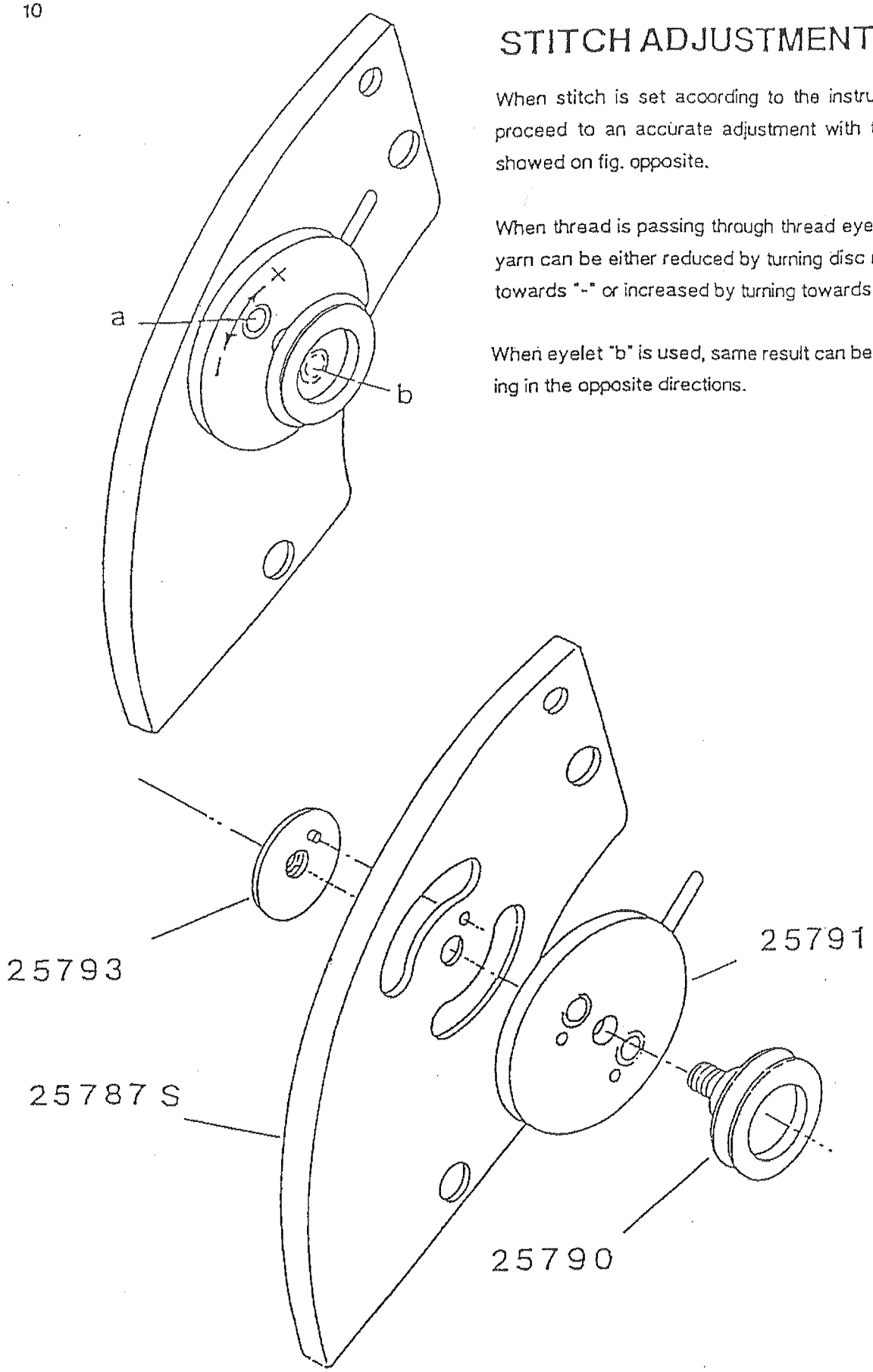
Fig. 7 : The stitch is correct and there is a good balance between the needle yarn and looper yarn.
Fig. 8 : The tension on the looper yarn is too low, or that on the needle yarn too high.
Fig. 9 : The tension on the looper yarn is too high, or that on the needle yarn too low.

STITCH ADJUSTMENT (Option)

When stitch is set acoording to the instructions, one can proceed to an accurate adjustment with the set of parts showed on fig. opposite.

When thread is passing through thread eyelet "a", output of yarn can be either reduced by turning disc n ° 25791 towards "-" or increased by turning towards "+".

When eyelet "b" is used, same result can be obtained by turning in the opposite directions.



CUTTING DEVICE

Both knives of the overedging machine are lined with tungsten carbide. They can work for 3 months without being sharpened, if following directions are strictly observed.

When knives must be replaced, take good care that there will be no dirt or plush between fastening surfaces of knives and knives holders. A few plushes only may cause the knives to be irremediably destroyed within a short time.

When replacing knives, firstly loosen slightly handscrew C. (fig:13). Then untighten completely screw A of the upper knife without taking it out of its housing.

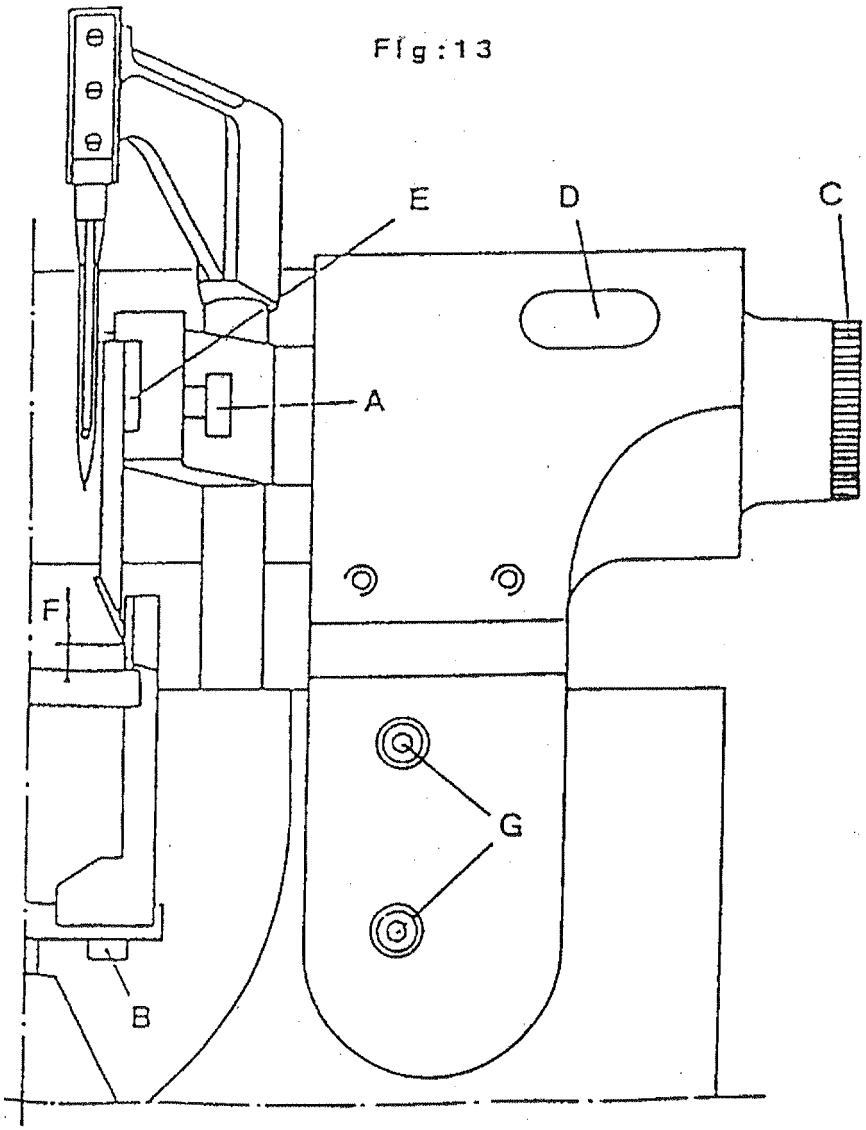


Fig:13

Screw B of the lower knife must be removed completely. Put the new knife exactly at the place of the old one and fasten it with screw B.

Afterwards the upper knife can be put on its place.

When turing handscrew C clockwise, the upper knife comes closer to the lower knife.

Both knives must touch, without exerting any pressure on each other.

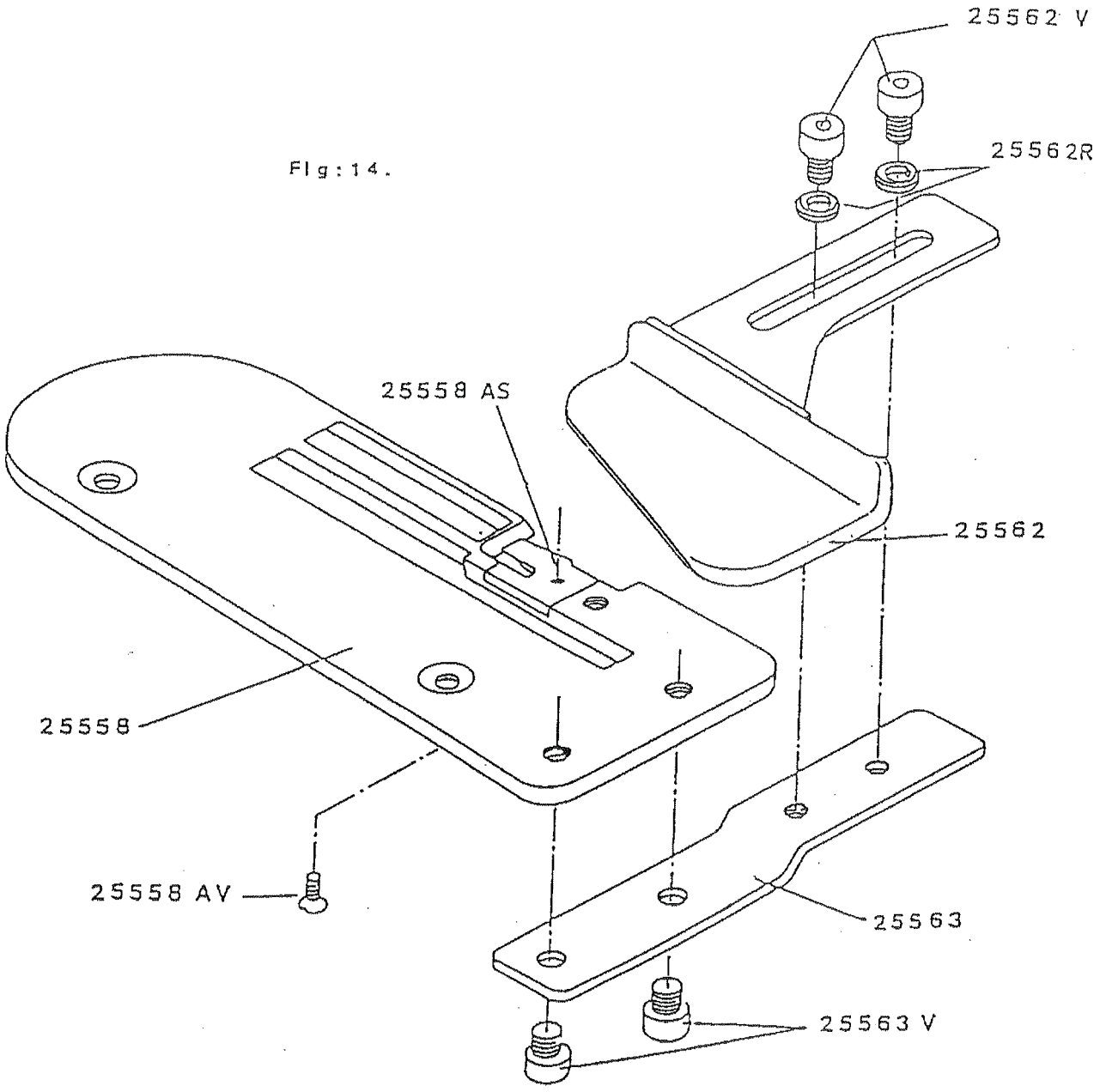
When knives are resharpened some metal is lost and height of knives decreases. For that reason the upper knife must be lowered a little after each sharpening. Carry out this adjustment as follows : take off the protection plate. Loosen screw D and push the knife holder down.

ATTENTION: the cutting edge of the upper knife must be at 3 mm. above needle-plate. (F.fig:13.) The lower knife (moving knife) may keep its position till many sharpenings have shortened it in such way that the replacement is

CARPET GUIDE

When no use is made of the cutting device, or if only a very small strip must be cut off from the carpet edge, then set the guide as shown hereunder.

Fig: 14.



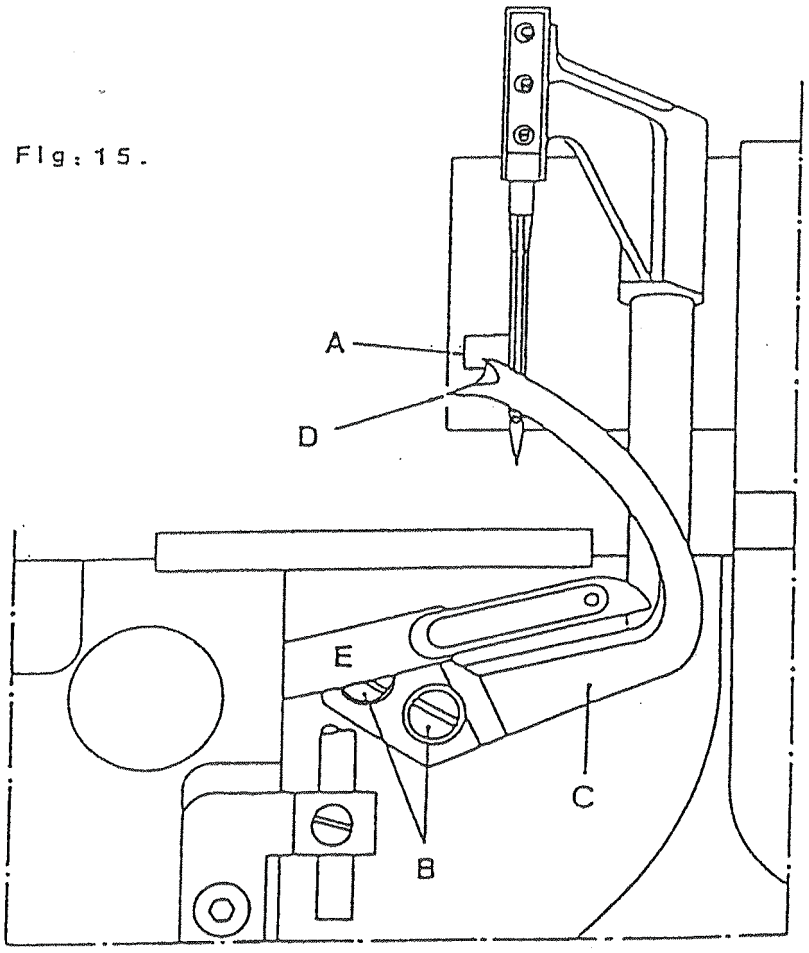
ADJUSTMENT OF LOOPERS

When leaving the factory, the machine is adjusted for using yarns of medium quality and size. If yarns of lower quality are used, a little adjustment will perhaps be necessary. This adjustment will be performed by displacing upper looper C. (fig:15.)

When upper looper is in its highest position, the take up of upper looper C will be situated at 4,5 mm of the needle (fig.15A).

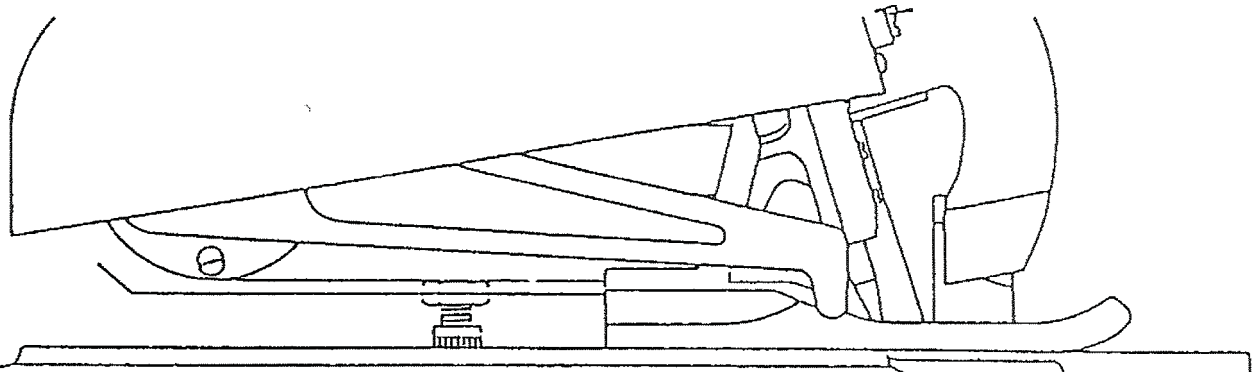
When using certain types of yarns, this distance might have to be either increased or reduced by 1 mm.
Carry out the adjustment as follows: loosen screws B a little (fig. 15) displace looper C, either to the right or to the left.

Fig: 15.

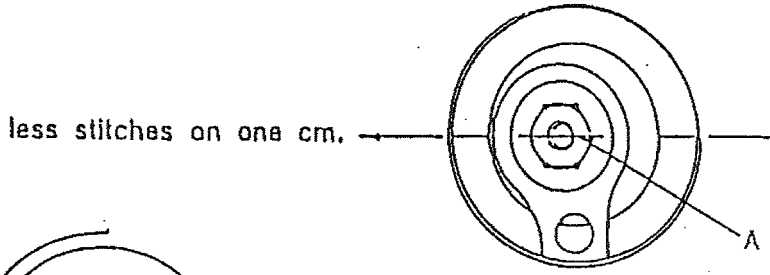


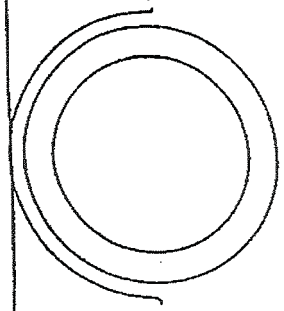
Looper C can only be displaced over a short distance i.e. 1 mm in each direction. When the looper moves towards the needle, it crosses underlooper E (fig. 15). At this moment point D of looper C moves in a groove milled in the underlooper E. Take care that E and C do not touch each other.
When this adjustment is performed, refer to § Obtaining correct stitch.

Fig. 16.



SETTING OF THE NUMBER OF STITCHES





Unscrew the large thumb screw so that the nut (A) is visible and then turn the wheel by hand until the needle reaches its lowest neutral point.
With the left hand place the box-spanner, dimension 10, onto the nut (A) and with the right hand hold the wheel steady in the same position, then turn the box-spanner in an anti-clockwise direction (never more than half or three-quarters of a turn), move the spanner together with the nut (A) in the direction required and immediately fix the nut.

ADJUSTMENT OF THE NEEDLE BAR

Untighten both screws A (fig. 18.) so that the needle bar B moves with a certain restraint in the holder C.

Turn the machine wheel by hand until the needle D gets engaged in the slot E of the needle plate I: the point of the needle must be exactly in the centre of the slot E.

During this adjustment, also adjust the height of the needle as follows:

Loosen slightly the screws G and set screw F in such position that it sticks out from its housing by 3 mm. (fig:23.)

Tighten the screw G, place a new needle and fix it with screw H fig. 18. By turning the machine by hand, the needle-bar reaches its highest neutral point, in this position the distance between the point of the needle and the surface of the needle plate (i) (fig. 23.) should be exactly 23 mm.

For this adjustment move the needle bar B with regard to the holder C (fig. 18), to the height which is reguired, making sure that the point of the needle is always exactly in the center of the slot E and tighten the screws A.

When the needle reaches its lowest neutral point, it is necessary for the correct formation of the loop of the needle's thread that the needle rises from 1,7 mm to 2 mm before the lower hook is in the position shown by figure 20.

ADJUSTMENT AFTER REPLACING THE LOWER OR UPPER LOOPER

Loosen both screws G (fig.13) and remove the complete upper part of the machine, then the needle plate I and the base plate as well.

REPLACEMENT OF THE LOWER HOOK

Insert a new needle and unscrew the nut K (fig.18) half a turn.
By turning the machine wheel by hand, position both loopers as shown on fig. 21, unscrew the looper J from its slot N (fig. 18), in an anti-clockwise direction.

Introduce the new looper into the slot N and screw it on the threaded rod L up to the point where the nut is (fig. 18). Place the surface S of the lower looper exactly parallel to the needle (fig. 24) i.e. at 17 ° .

Between the countersink of the needle and the surface S of the lower looper, there must be a play of 2/10 to 3/10 mm, more would give rise to false stitches, while less play would give rise to contact between the parts concerned, which should be avoided at all costs.

On the surface S place a 6 mm fork spanner and fix the nut K (fig. 18) maintaining the 17 ° angle of the surface S. Figure 21 shows a measure of 80 mm which must be respected when the lever M fig. 18 has to be moved. For this adjustment, loosen screws R (fig. 18) so that the lever can turn on its axis with a slight restraint; adjust the point of the lower looper at the required measure of 80 mm and tighten the screws R.

REPLACEMENT OF THE UPPER LOOPER

Completely remove the upper part of the machine, and the needle plate (fig. 18)

Turn the machine wheel by hand until the upper looper V reaches its lowest neutral point (fig. 19). In this position both screws T can be removed and the worn looper replaced by a new one (see *). If after this replacement, there is contact made between the upper looper and the lower looper, carry out the following adjustment:

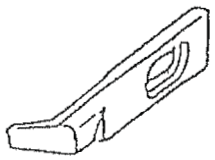
Loosen screws O (fig. 18) and move the bronze slot N in the direction which is required (see arrows - fig. 17).

ATTENTION: The adjustment must be minimal and should never exceed 1/10 mm. Tighten both screws O.

A similar adjustment can be made by untightening the screw U (fig. 17) and by moving the shank of the swivel joint L in the required direction, with regard to the lever M (fig. 17).

* § Adjustment of loopers.

SELECTION OF A CHAIN GUIDE

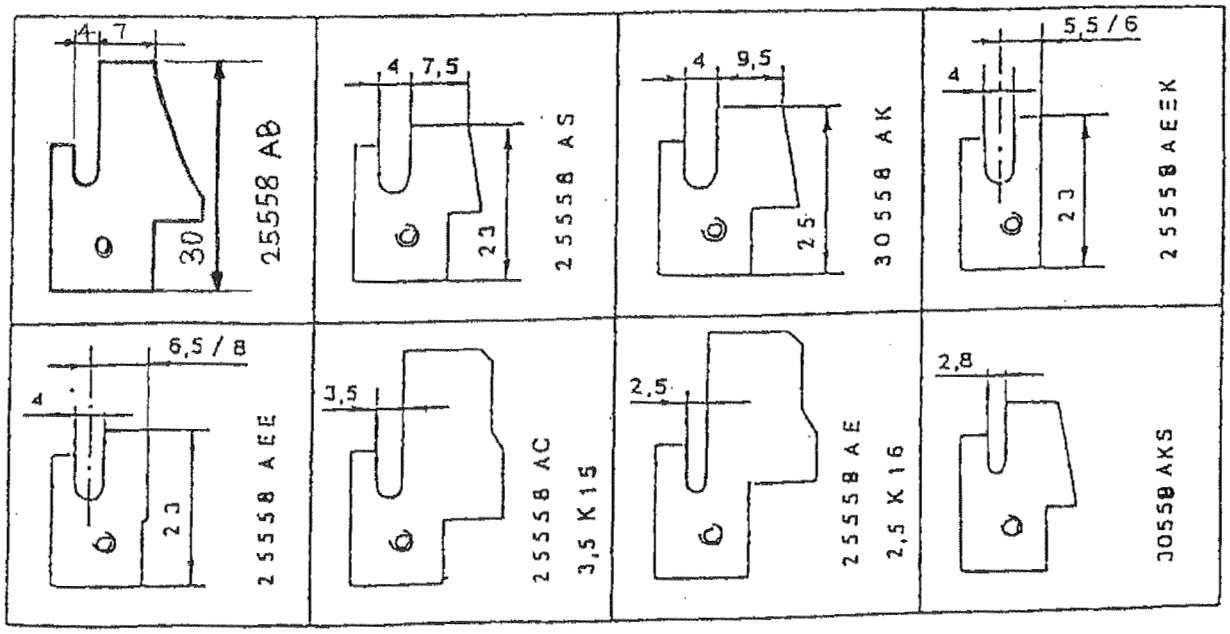


Depending on the thickness of the carpet to be overedged. In order to obtain a proper stitch, one will fit a chain gulde which is suitable to the material.
Hereunder the list of different available guides with their ref. numbers.

PART NUMBER	LEFT EXECUTION	RIGHT EXECUTION	DESCRIPTION
-25560	X	X	-Normal carpets.
-25560B	X	X	-High piles.
-25560C			-Blankets.
-25560EE	X	X	-Normal carpets with small overedging.
-30560GR	X	X	-Normal carpets with tape insertion.
-25560H	X	X	-Heavy carpets.
-25560K	X	X	-Butseamer.

SELECTION OF NEEDLE PLATE FINGER

Depending of the fact the yarn of the lower hook is thick or thin it might appear necessary to adapt the needle plate.
For thin yarn and thin material one will use a needle plate with a small groove. For thick yarn and thick material the use of a needle plate with a larger groove will be more suitable.



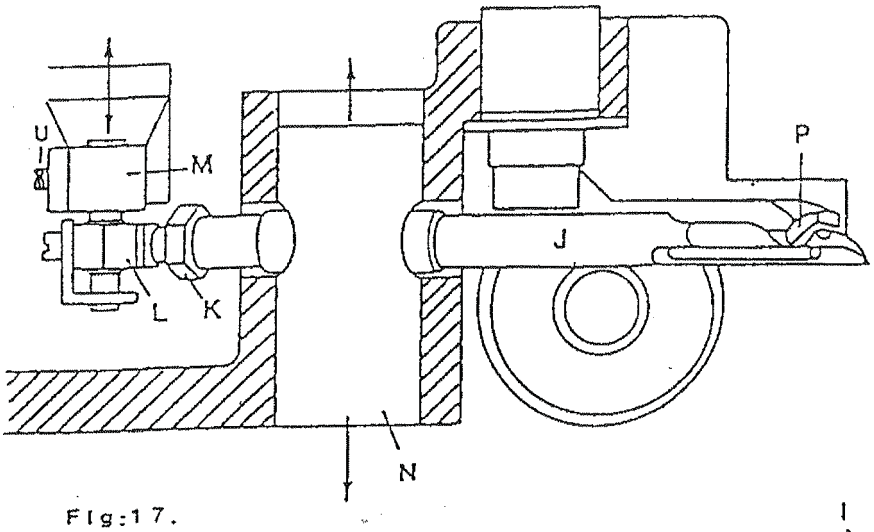


Fig:17.

Fig:18.

OVEREDGING MACHINE

Fig:19.

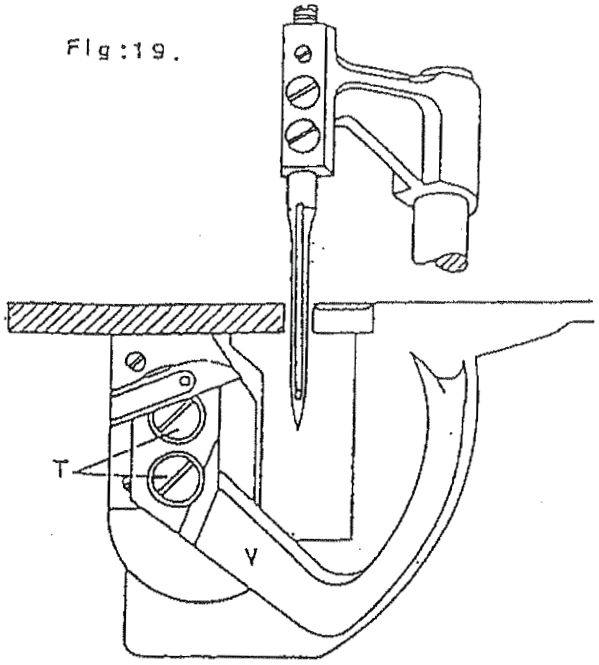


Fig:20.

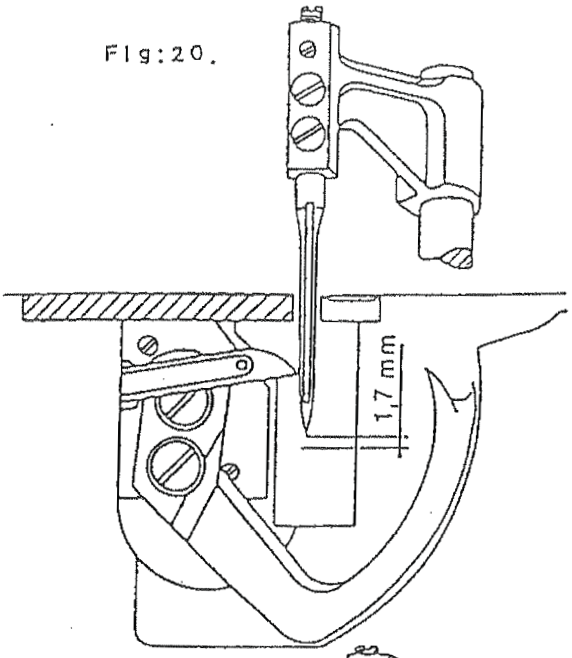


Fig:21

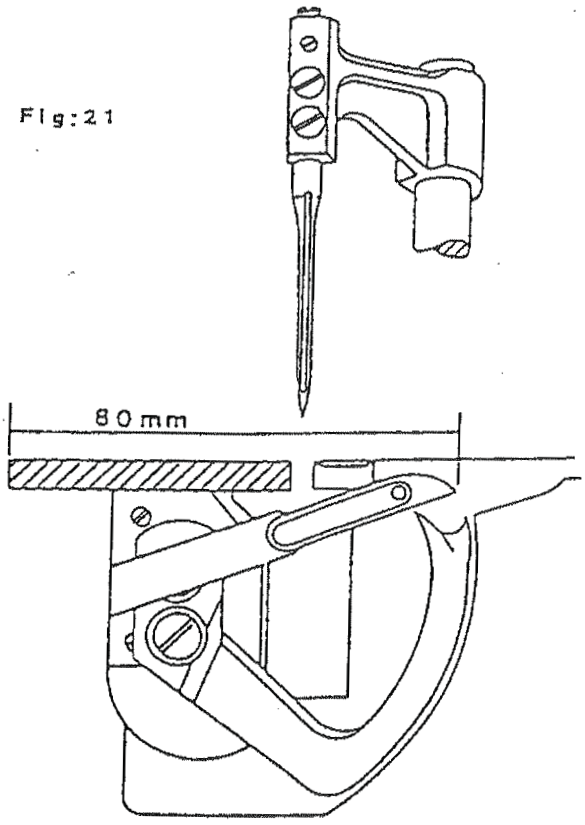
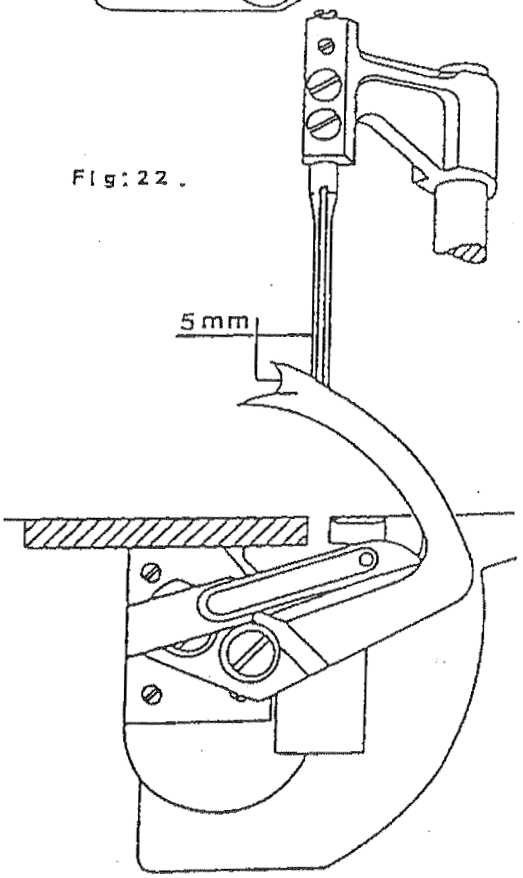
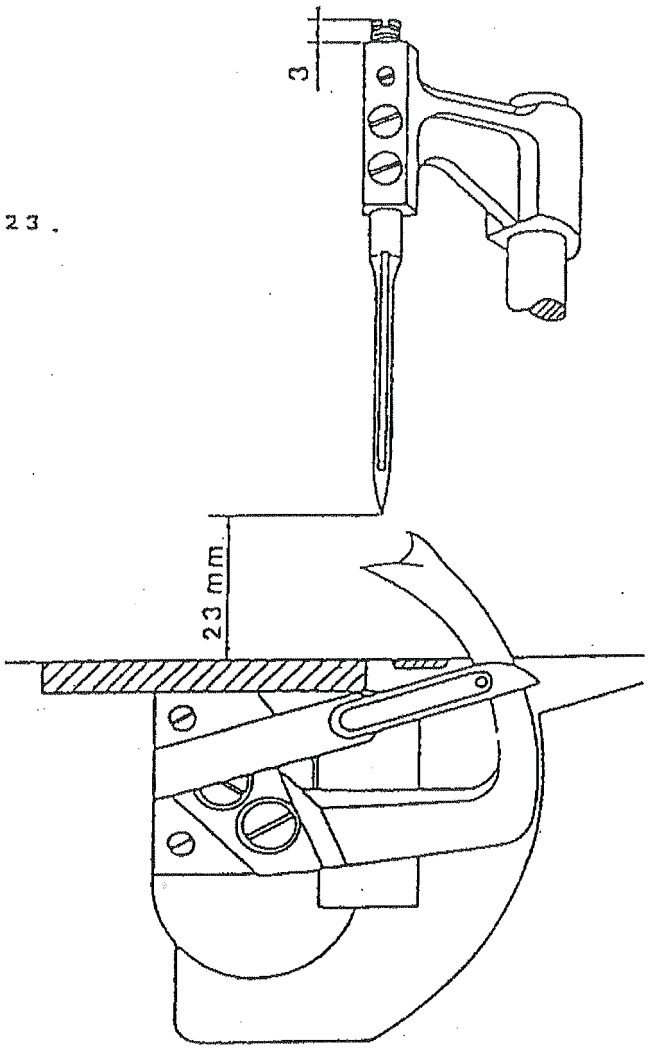


Fig:22.



OVEREDGING MACHINE

Fig:23.



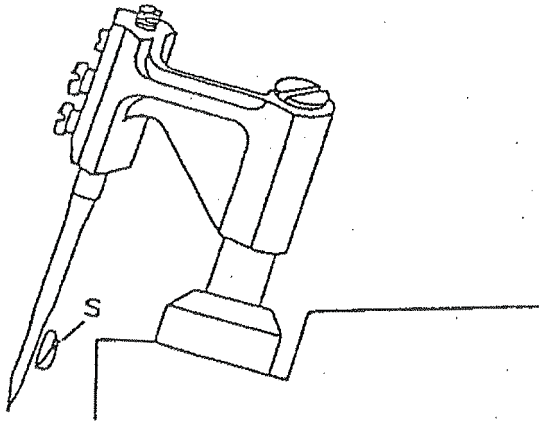


Fig:24.

YARNS

All types of yarn can be used on the carpet overedging machine. However, for the needle, we recommend using thinner yarns for example, a n " 18-2500 m mercerized cotton from BST or any other brand.

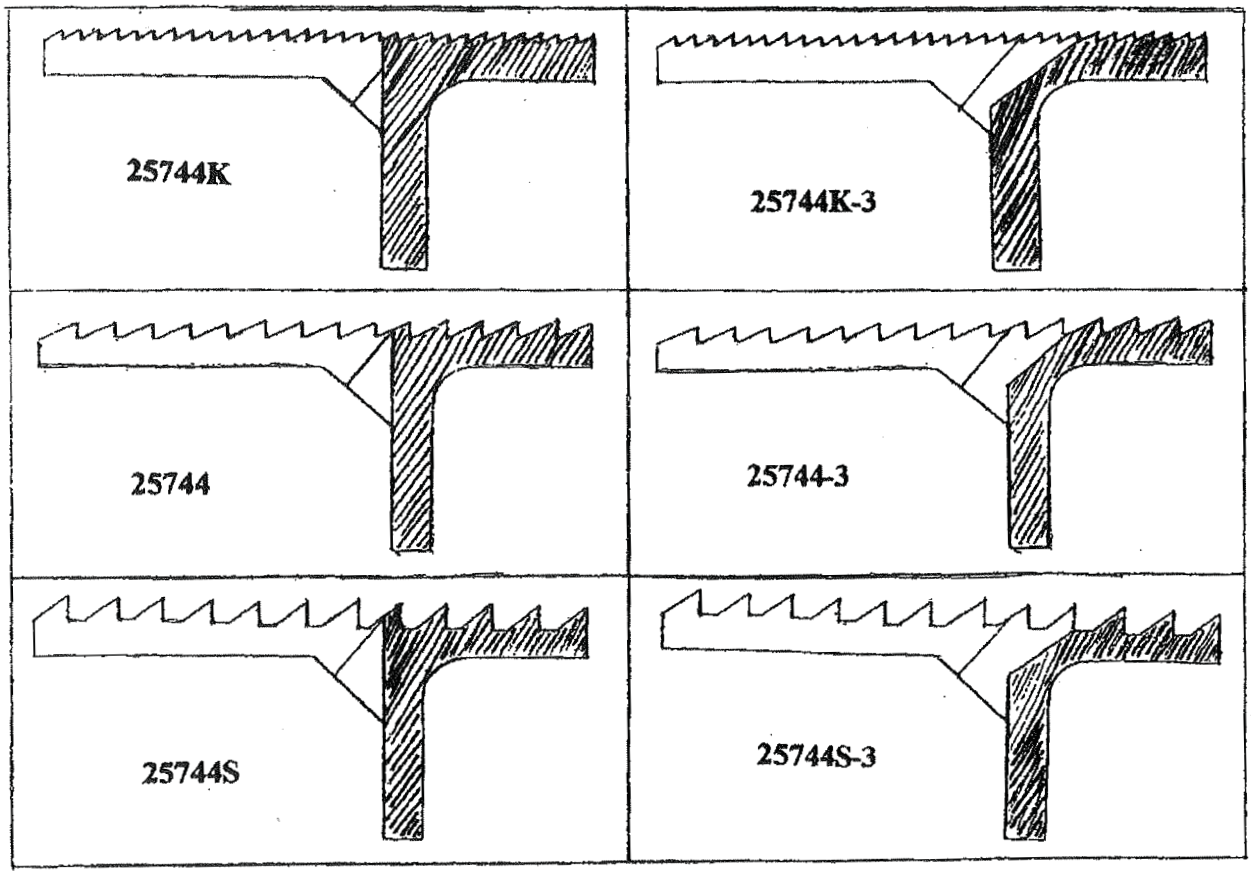
Use preferably 2 or 3 thin yarns for the finishing yarn for tufted carpets. These should be loosely twined with about 10 twists per metre. This is because 2 or 3 and even 4 yarns spread out better and consequently the stitch can be markedly larger than with a single thick and overtwined yarn in the lower looper or hook.

THE FEEDDOG

The sewing of tufted carpets with a needle creates a sort of dust composed of textile and rubber particles.

This dust accumulates every day the machine is used and it becomes more and more compressed by the movement of the feeddog until the feeddog itself finally breaks.
This also causes severe overloading of the other parts of the machine. If a powerful compressor is available which delivers air at 6 bar, it suffices to blow the uncompressed dust away every day. Even so the throat plate should be removed at least every two weeks the machine is in operation, in order to remove compressed dirt.

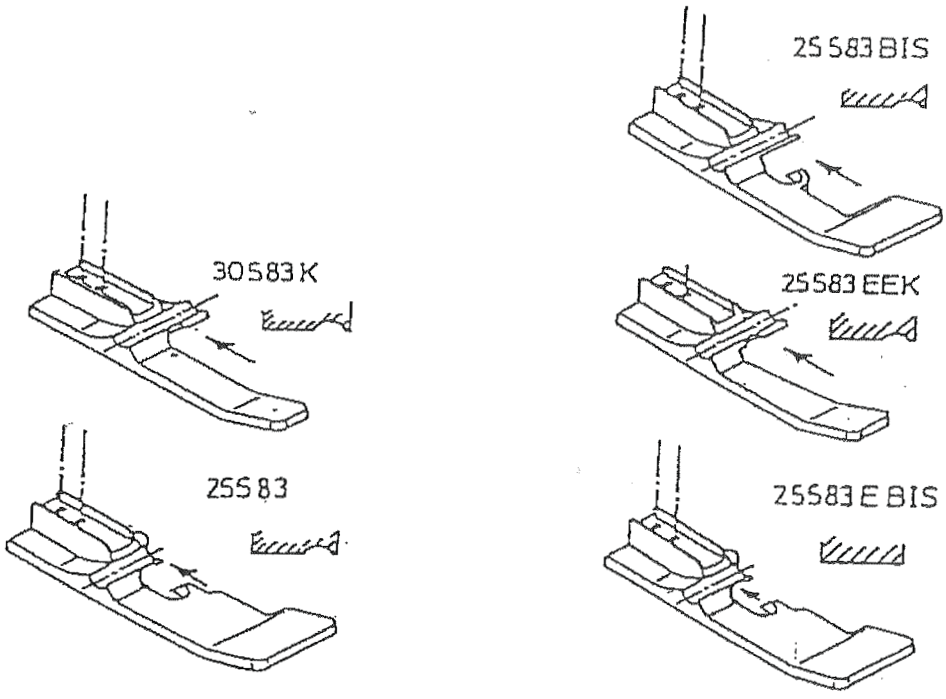
FEEDDOG SYSTEM



PRESSER FOOT

It is very important to have the correct pressure on the presser foot if the overedging machine is to work well. If the pressure is too low, the feeddong will nevertheless carry the material forward, but this will be very irregular and the feeddog will slide too much on the rough backing of the carpet, causing undue wear on the feeddog. For the same reason the stitches will be irregular and may not be properly formed.
Insufficient pressure on the presser foot when working with tufted carpets with foam backing will lead to the foam being stripped off. If in contrast the pressure is adequate, only light traces will be left by the feeddog on the backing. The most sultable pressure on the presser foot is 8 kg.
This can be checked by means of a standard dynamometer.

Available presser foots.



Part number.	Description.
25583	-Standard foot.
25583BIS	-Fine materials.
30583K	-Blankets -Used in combination with guides.
25583EEK	-Stitch width 5,5 mm.
25583E BIS	-Buttseamer (fine materials).

KNIVES

The knives are lined with plates in a hard metal allowing a service life of about two months. As these plates are extremely hard they are also very brittle, which means that overly sharp contact between the upper and lower knives can cause the cutting edges to shatter.

An adjusting screw is installed on the machine (see fig. 13) and this allows the best gap between the knives to be set without risking damage.

Staples are often used in weaving sheds; it should not be forgotten that if a staple ends up between the knives of **carpet overedging machine** the knives will have to be resharpened.

We do not advise trying to sharpen the knives without specialized machinery.

NEEDLES

Type : 7713/230,180 or 160
7713-99/230 (square pointed)

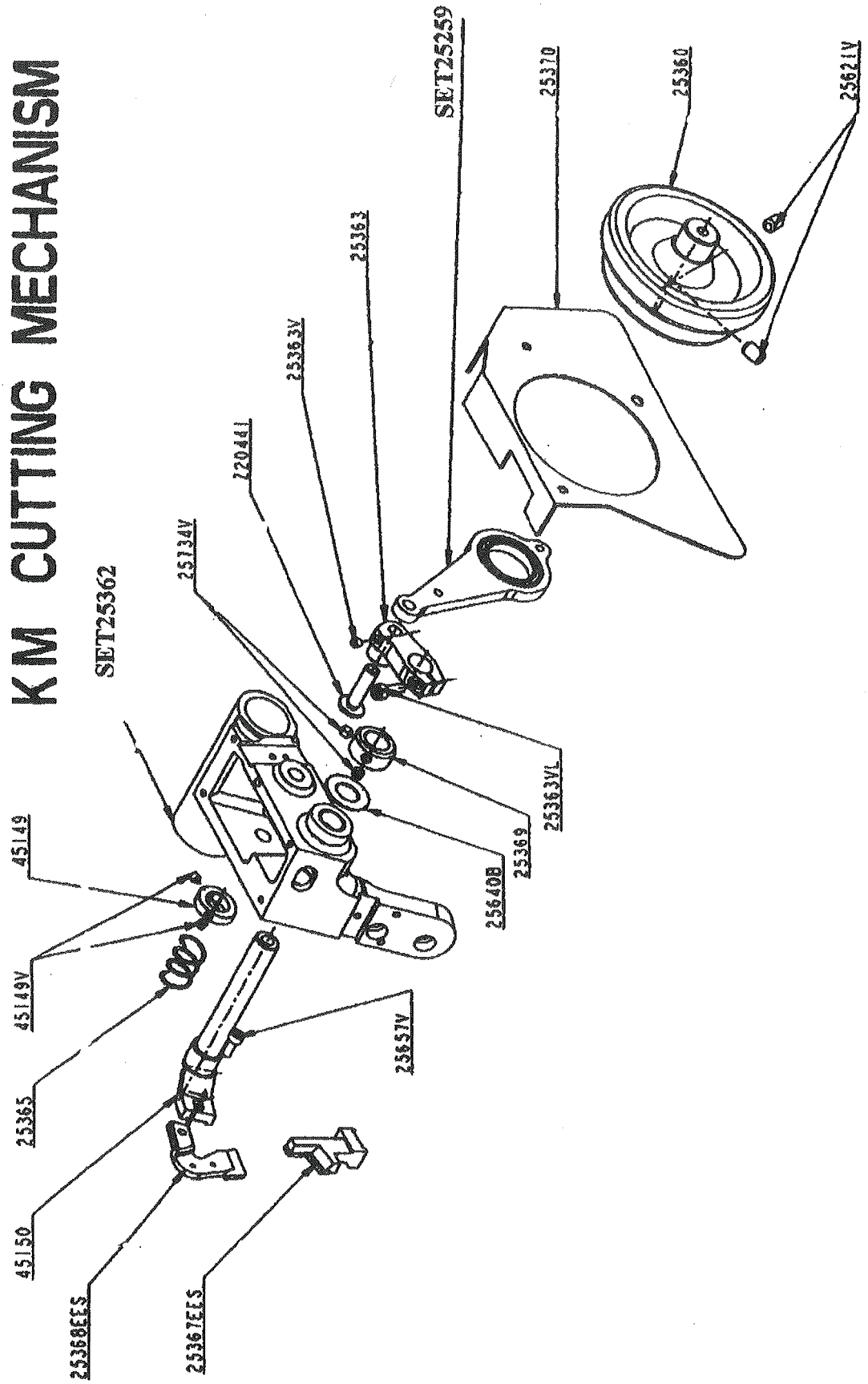
Considering the fact that the needle of the **carpet overedging machine** pierces the carpet 2800 times a minute, it is quite normal that the original shape of the needle is significantly altered after a few days. The recess in the needle which forms the loop in the yarn wears away and this causes false stitches.

If the MACHINE runs for 8 hours a day, the needle must be at the latest replaced after one week (36 hours) by a new one. The old needle will then have pierced and been withdrawn from the carpet 10 million times.

The needle in the machine may reach a temperature of 450 °C causing the foam at the back of tufted carpets to melt and to stick to the needle. This reduces the penetration power of the needle by about 50% and causes severe overlaoding of the needle drive mechanism and a premature wear of the internal parts of the machine. Therefore we advice to lubricate the needle when sewing rubber-backed carpets. This can be done by allowing the needle yarn bobbin to soak in a parafin oil bath for 24 hours, subsequently allow the bobbin to drip out for some days, after which the yarn can be used. The parafin laden yarns prevent the needle from sticking to the rubber. Parafin oil leaves no stains on the sewn work.

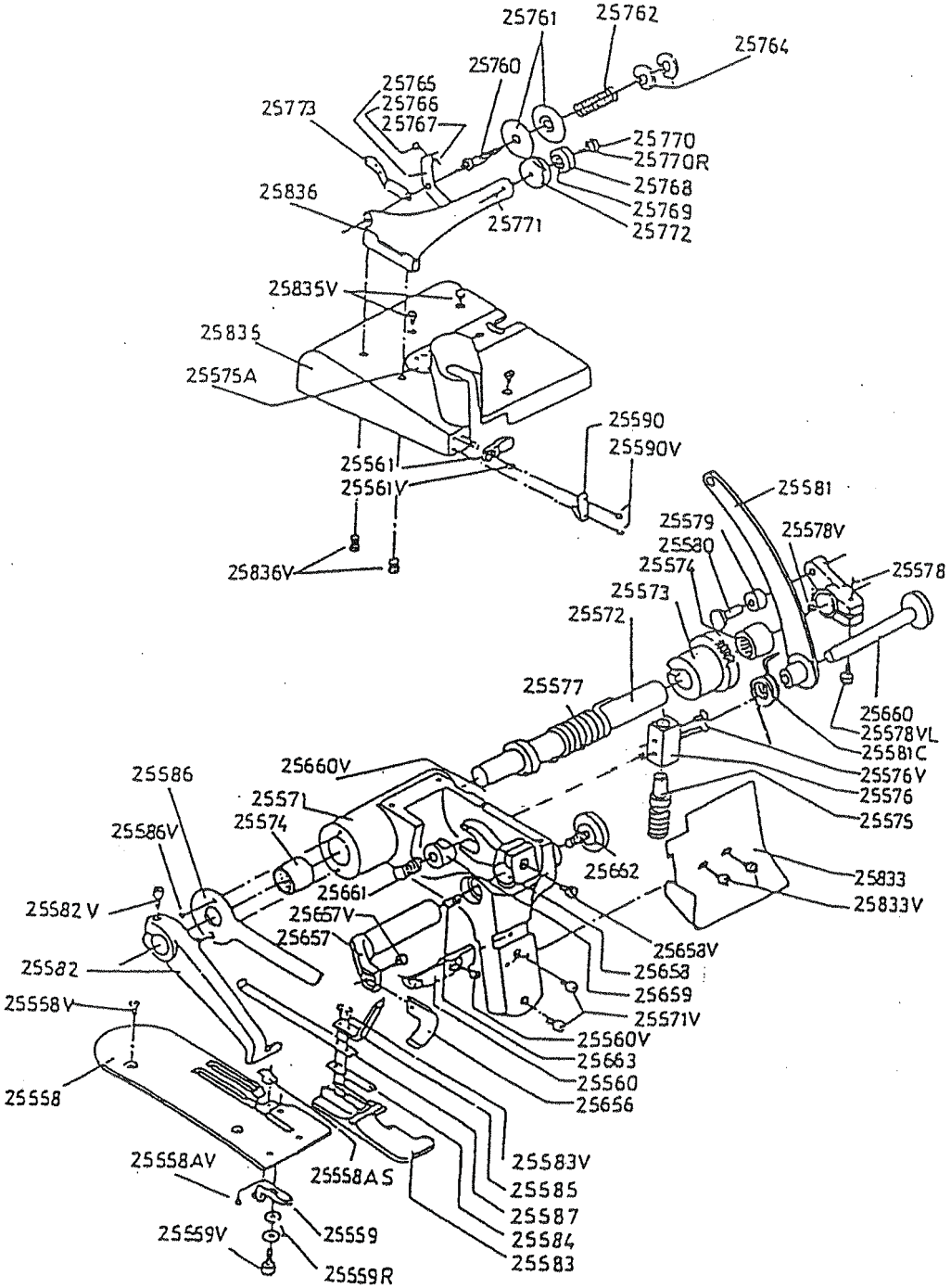
When changing needles you will notice that a ring of dust has been formed around the needle shaft. It is essential that this dust ring is carefully removed BEFORE the change of the needles. If this is not done properly, there is a danger that the dust is pushed into the needle holder, thus causing the original needle distance to be altered by the thickness of the dust layer, which could lead to the stitches not being properly made.

KM CUTTING MECHANISM



PARTS LIST

PRESSER FOOT ASSEMBLY.

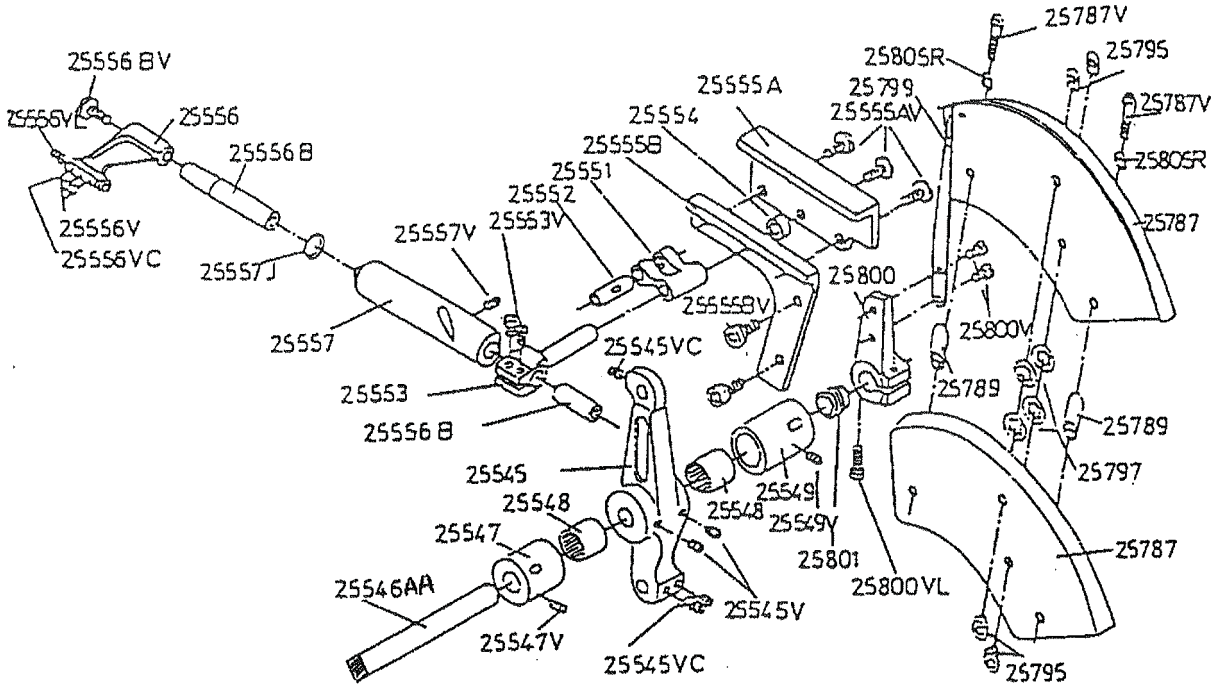


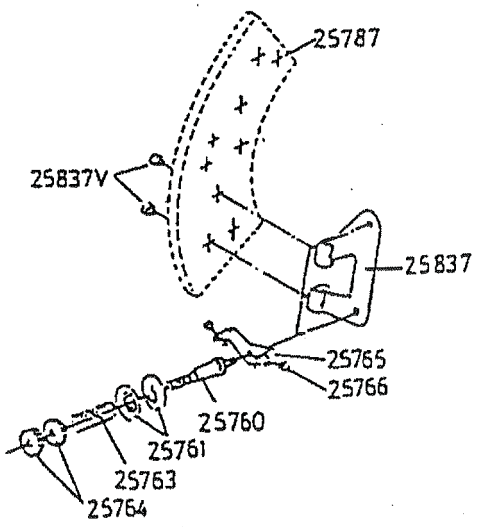
PRESSER FOOT MECHANISM

25558	Needle plate
25558AS	Finger
25558AV	Screw
25558V	Screw
Set 25559A	Needle guide complete
25559	Needle guide
25559V	Screw
25559R	Washer
25560	Chain guide
25560V	Screw
25561	Thread tension releaser
25561V	Screw
25571	Frame
25571V	Screw
25572	Lever shaft
25573	Bushing
25574	Bearing
25575	Regulating screw
25575A	Label
25576	Regulating screw holder
25576V	Screw
25577	Foot lifter spring
25578	Rise lever
25578V	Screw
25578VL	Screw
25579	Roller
25580	Roller stud
25581	Presser foot lifter lever
25581C	Return spring
25582	Presser foot arm
25582V	Screw
25583	Presser foot
25583V	Screw
25584	Spring
25585	Holder for parallelism
25586	Connecting rod
25586V	Screw
25587	Folium
25590	Chain cutter
25590V	Screw
25656	Upper knife
25657	Upper knife holder
25657V	Screw
25658	Positioning lever
25658V	Screw
25659	Slide block
25660	Shaft
25660V	Screw
25661	Feed spring
25662	Screw
25663	Spring
Set 25760	Tension complete
25760	Tension post
25761	Tension disc
25762	Tensionspring (1,2mm)
25764	Nut
25765	Thread guide plate
25766	Thread guiding ring
25767	Snap ring
25768	Roller
25769	Bearing
25770	Precision screw
25770R	Washer
25771	Nut
25772	Roller holder
25773	Thread guide
25833	Protective plate
25833V	Screw
25835	Cover
25835V	Screw
25836	Tension holder
25836V	Screw

When ordering parts marked with a "*"
whole set will be delivered.

NEEDLE BAR MECHANISM



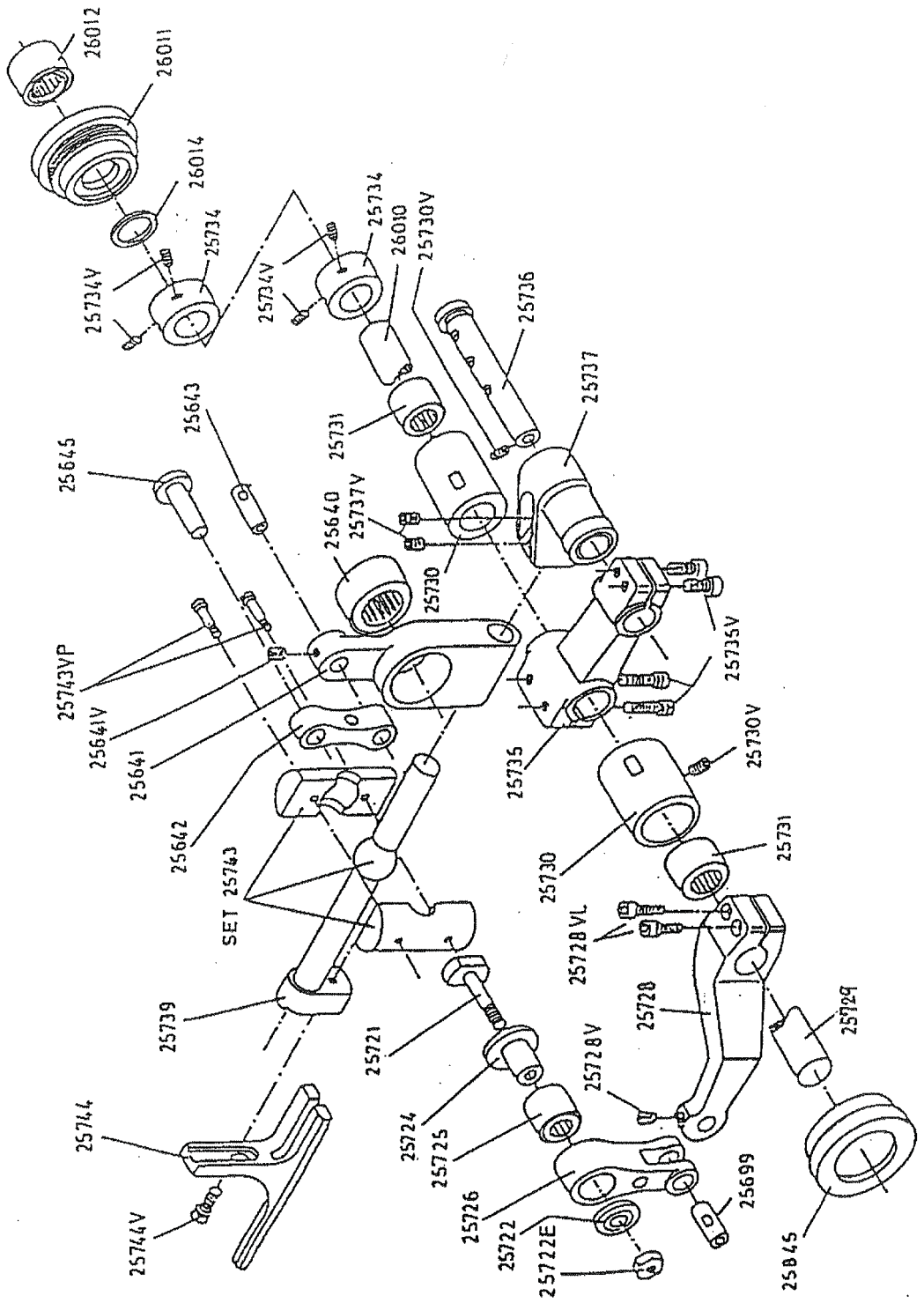


NEEDLE BAR MECHANISM

25545	Needle bar lever
25545V	Screw
25545VC	Screw
25546AA	Eccentric shaft
25547	Bushing
25547V	Screw
25548	Bearing
25549	Bushing
25549V	Screw
25551	Connection link
25552	Link shaft
25553	Connection stud
25553V	Screw
25554	Guide roller
25555A	Needle bar guide
25555B	Needle bar guide
25555AV	Screw
25555BV	Screw
SET 25556	Needle clamp assembly
25556	Needle clamp
25556B	Needle bar
25556V	Screw
25556VL	Screw
25556BV	Screw
25556VC	Screw
25557	Needle bar bushing
25557J	O-ring
25557V	Screw
SET 25760	Tension complete
25760	Tension post
25761	Tension disc
25763	Tenson spring
25764	Nut
25765	Thread guide plate
25766	Thread guiding ring
25787	Thread guide holder
25787V	Screw
25789	Bushing
25795	Thread guide
25797	Spring ring
25799	Thread take-up
25800	Thread take-up lever
25800V	Screw
25800VL	Screw
25801	Rubber V-ring
25805R	Washer
25837	Tension holder
25837V	Screw

When ordering parts marked with a 'a'
whole set will be delivered.

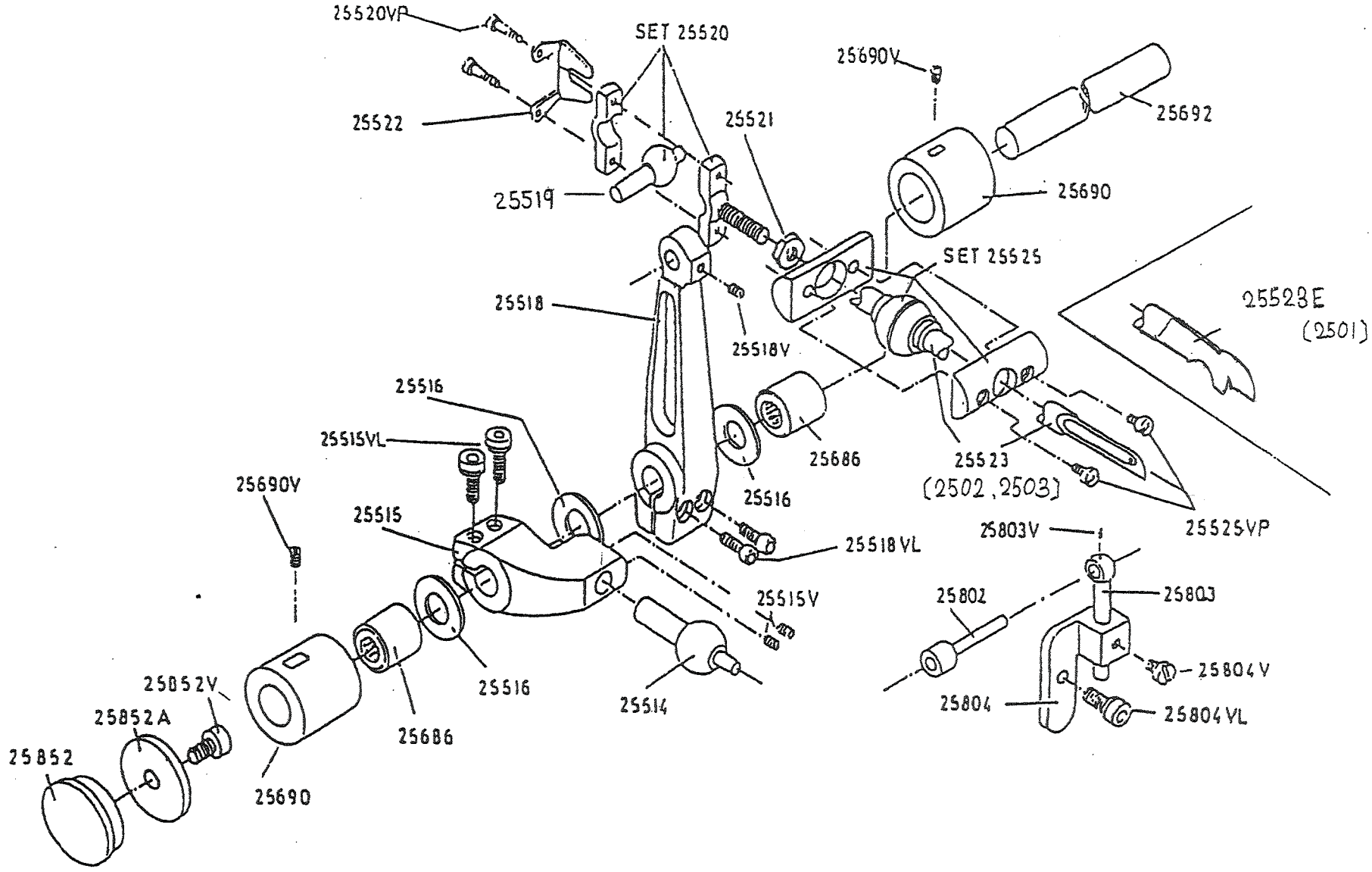
FEEDDOG MECHANISM



FEEDDOG MECHANISM

SET 25641	Lower knife driving link complete
25640	Bearing
* 25641	Lower knife driving link
25641V	Screw
25642	Driving link
25643	Lower shaft
25645	Stud
25699	Pin
25721	Feed across regulator
25722	Washer
25722E	Nut
25724	Bearing bushing
25725	Bearing
25726	Feed driving rod
25728	Feed driving lever
25728V	Screw
25728VL	Screw
25730	Bushing
25730V	Screw
25731	Bearing
25734	Thrust collar
25734V	Screw
25735	Feed driving lever
25735V	Screw
25736	Stud
25737	Base
25737V	Screw
25739	Feeddog shaft
SET 25743	Complete feeddog shaft guide
* 25742	Shutter
* 25743	Feeddog shaft guide
25743VP	Clamp screw
25744	Feeddog
25744V	Screw
25845	Plug
25929	Shaft
26011	Bushing
26012	Bearing
26014	O-ring

When ordering parts marked with a "*"
whole set will be delivered.



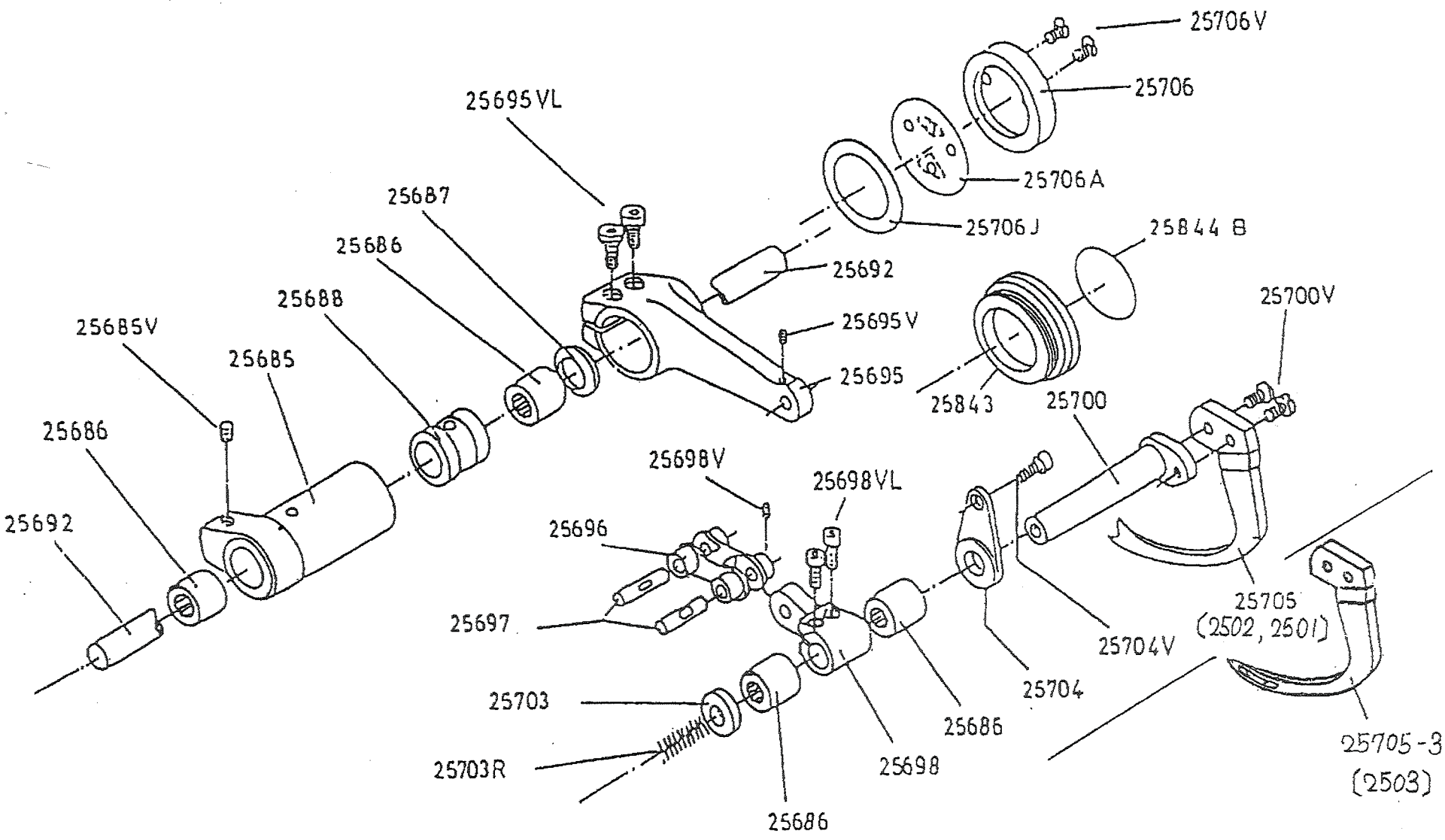
Lower looper mechanism

LOWER LOOPER MECHANISM

SET 25511	Connecting rod complete
* 25514	Ball
25515	Small driving lever
25515V	Screw
25515VL	Screw
25516	Washer
25518	Driving lever
25518V	Screw
25518VL	Screw
SET 25520	Complete ball joint
* 25519	Looper ball
* 25520	Ball joint
25520VP	Precision screw
25521	Nut
25522	Ball joint guide fork
25523	Lower looper
SET 25525	Under looper guide complete
* 25524	Ball
* 25525	Under looper ball joint
25525VP	Screw
25686	Needle bearing
25690	Bushing
25690V	Screw
25692	Shaft
25802	Thread guide
25803	Thread guide supporting shaft
25803V	Screw
25804	Thread guide holder
25804V	Screw
25804VL	Screw
25852	Plug
25852A	Washer
25852V	Screw

When ordering parts marked with a "*"
whole set will be delivered.

UPPER LOOPER MECHANISM

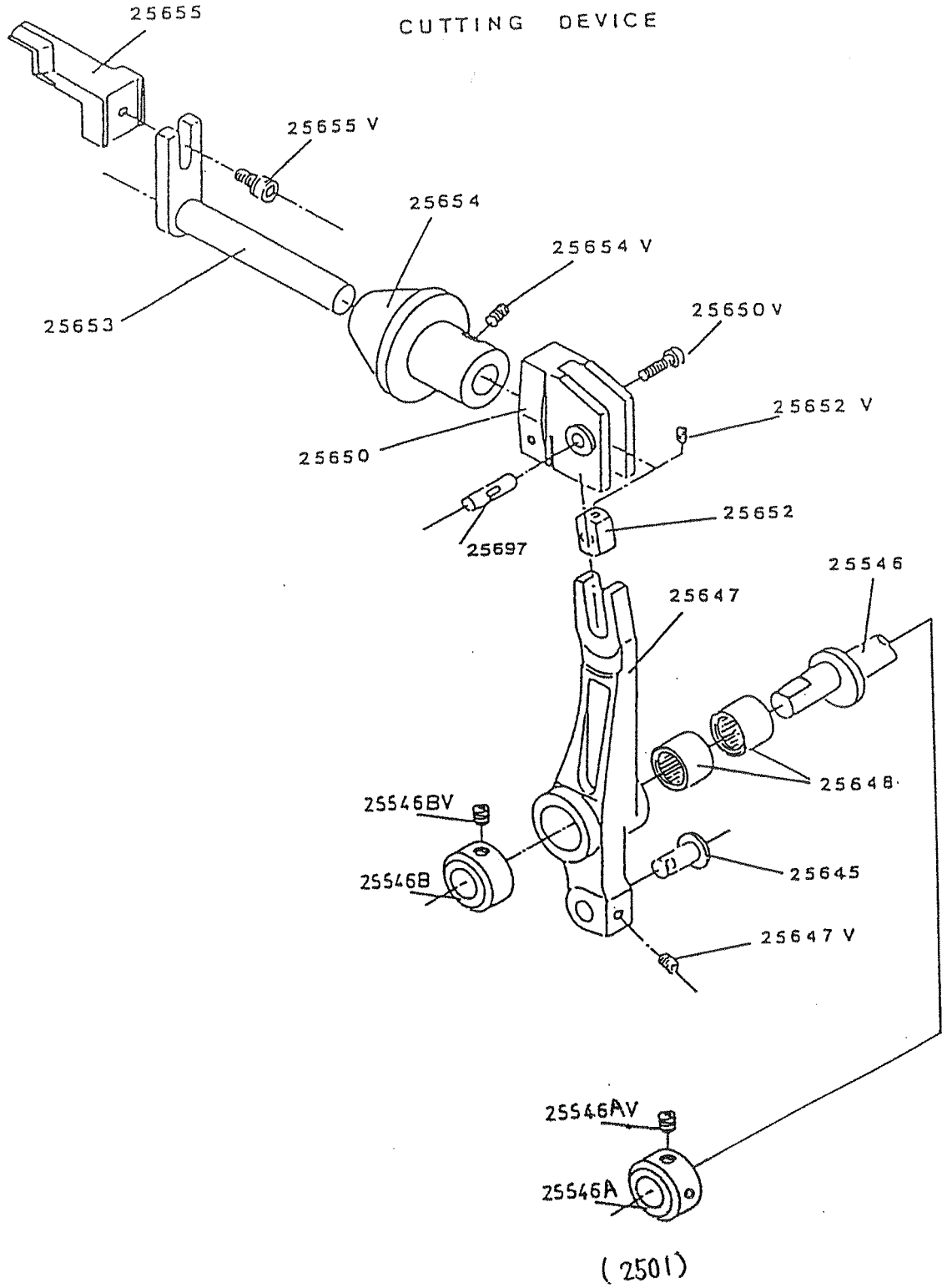


UPPER LOOPER MECHANISM

SET 25685	Complete intermediary assembly
* 25685	Intermediate lever
25685V	Screw
25686	Bearing
25687	Washer
25688	Bushing

25692	Shaft
25695	Big lever
25695V	Screw
25695VL	Screw
25696	Connection link
25697	Link pin
25698	Small lever
25698V	Screw
25698VL	Screw
25700	Upper looper shaft
25700V	Screw
25703	Washer
25703R	Spring
25704	Thrust plate
25704V	Screw
25705	Upper looper
25706	Oil window
25706A	Sticker
25706J	Packing
25706V	Screw
25843	Plug
25844B	Sticker

When ordering parts marked with a "*"
whole set will be delivered.



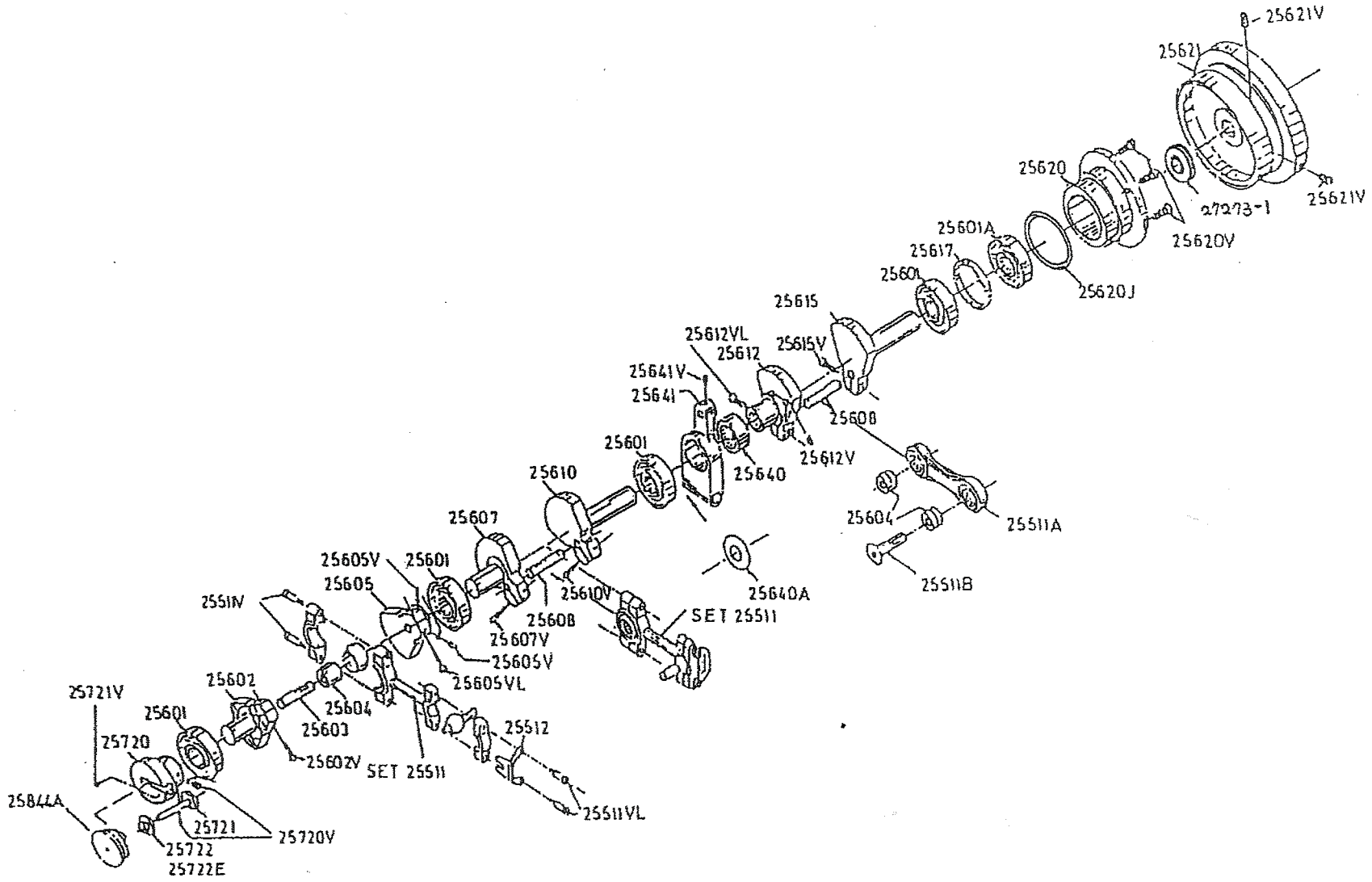
OVEREDGING MACHINE

CUTTING DEVICE MECHANISM

25546	Eccentric shaft
25546B	Collar
25546BV	Screw
25645	Stud
25546A	Collar
25546AV	Screw
SET 25647	Lower knife lever complete
* 25647	Lower knife lever
25648	Bearing
25647V	Screw
25650	Slide block guide
25650V	Screw
25652	Slide block
25652V	Screw
25653	Lower knife shaft
25654	Lower knife bushing
25654V	Screw
25655	Lower knife
25655V	Screw
25697	Link pin

When ordering parts marked with a "*"
whole set will be delivered.

Crank shaft.

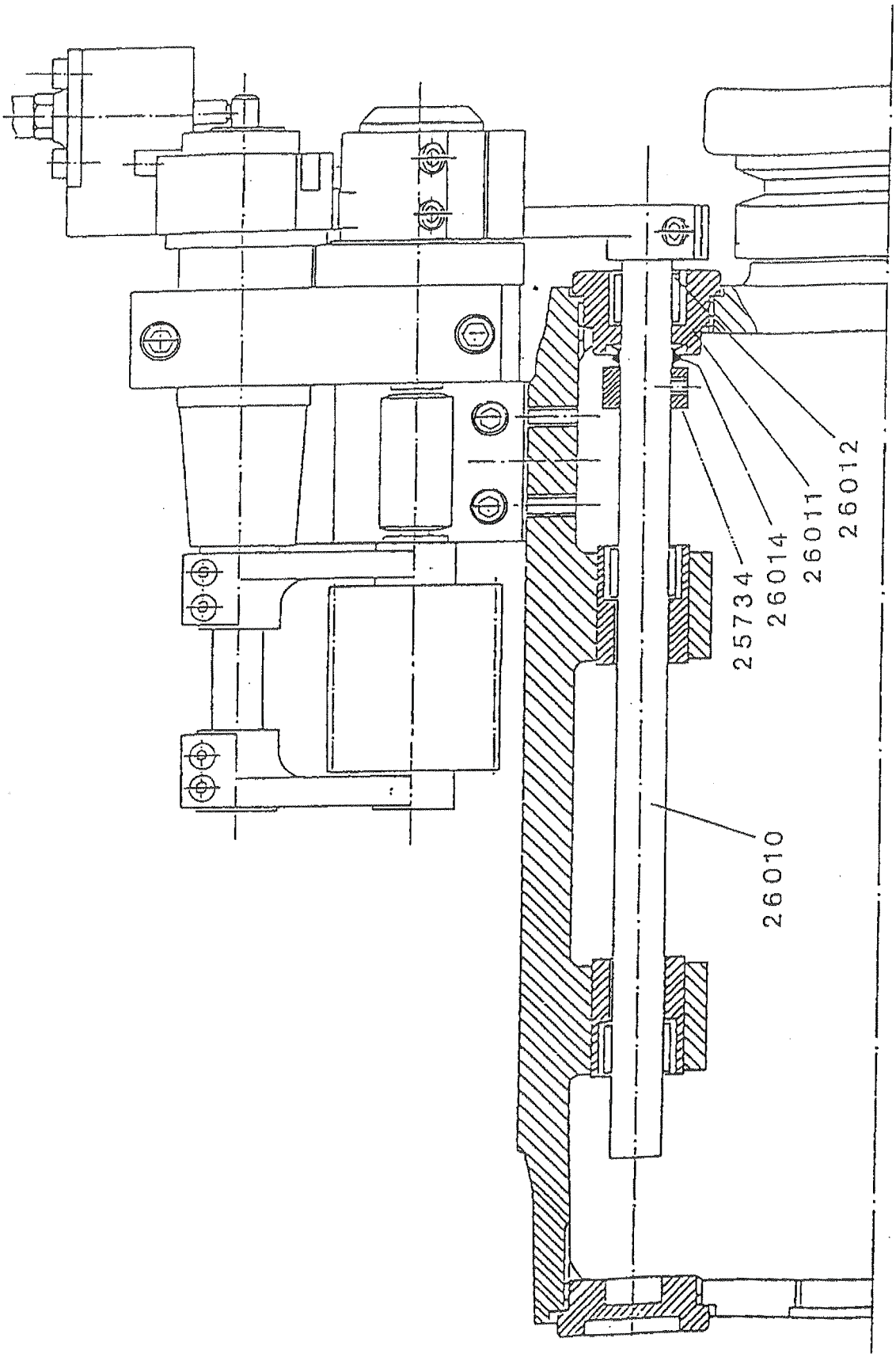

25621V
25621
25620
27273-1
25621V
25620V
25601A
25617
25601
25620J
25615
25612VL
25612
25615V
25641V
25641
25608
25612V
25601
25640
25610
25607
25604
25511A
25511B
25605V
25601
25605
25610V
25640A
SET 25511
25607V
25608
25605V
25605VL
25511V
25602
25604
25603
25602V
SET 25511
25512
25511VL
25721V
25601
25720
25844A
25721
25720V
25722
25722E

CRANK SHAFT

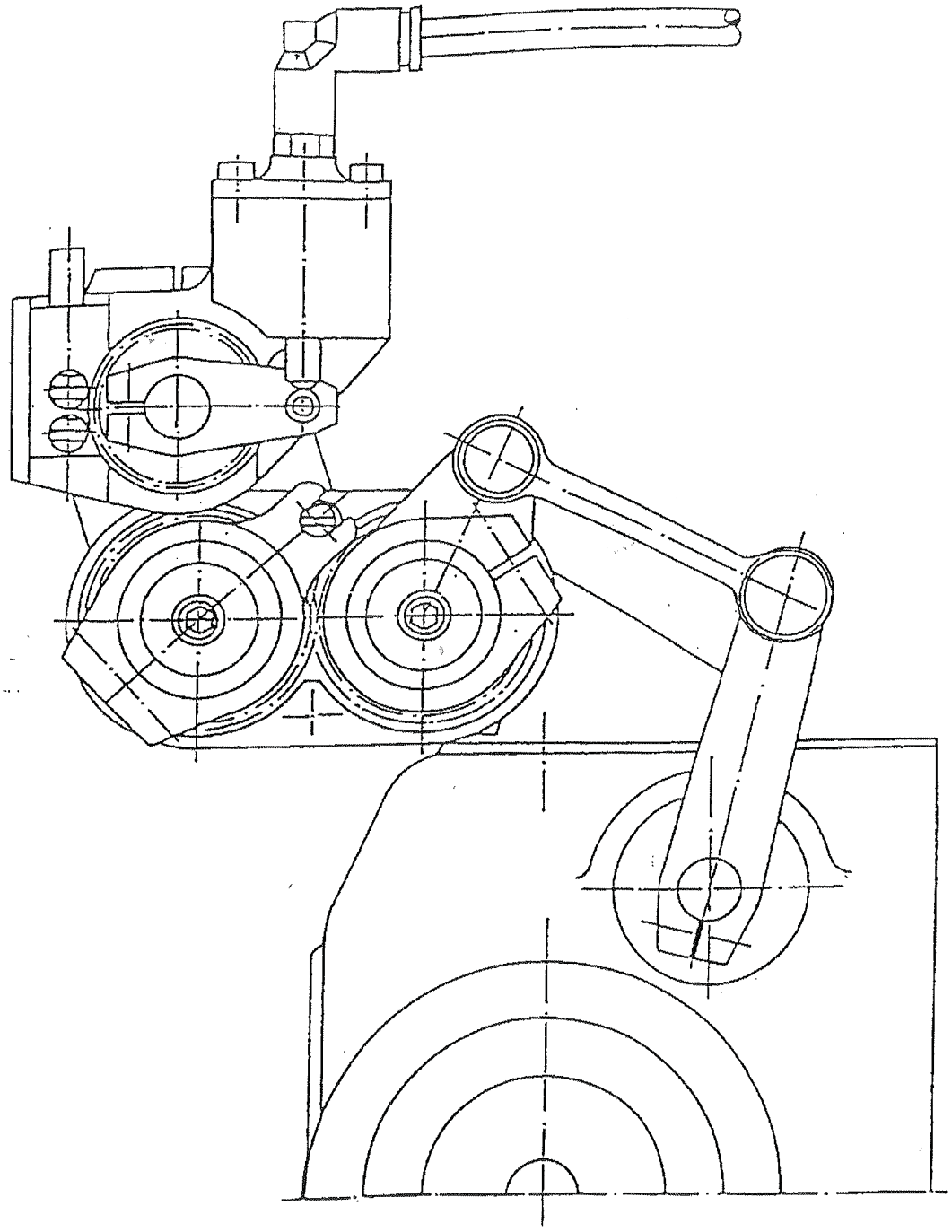
SET 25511	Connecting rod complete
* 25511	Connecting rod
25511V	Clamp screw
25511VL	Clamp screw
25512	Ball joint guide fork
* 25513	Ball
* 25514	Ball
25604	Bearing
SET 25511A	Complete rod
25511A	Rod
25511B	Stud
25604	Bearing
25608	Pin
25601	Bearing
25601A	Bearing
25602	Crank
25602V	Screw
25603	Pin
25605	Crank
25605V	Screw
25605VL	Screw
25607	Crank
25607V	Screw
25608	Pin
25610	Crank
25610V	Screw
25612	Crank
25612V	Screw
25612VL	Screw
25615	Crank
25615V	Screw
25617	Ring
25620	Flange
25620J	O-ring
25620V	Screw
25621	Pulley
25621V	Screw
25640A	Washer
SET 25641	Lower knife driving link complete
25640	Bearing
* 25641	Lower knife driving link
25641V	Screw
25720	Eccentric
25720V	Screw
25721	Feed across regulator
25721V	Screw
25722	Washer
25722E	Nut
25844A	Plug
27273-1	O-Ring

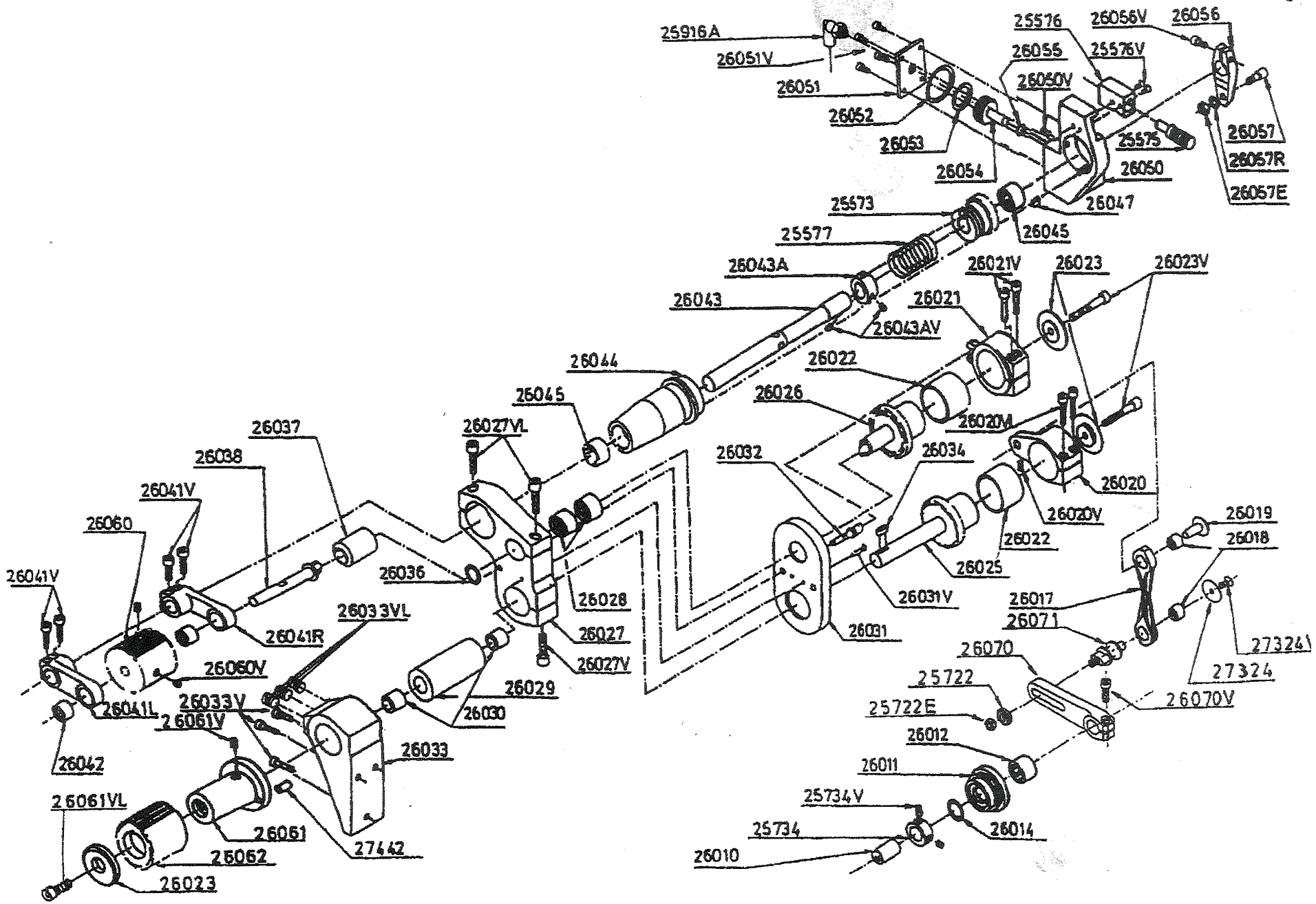
When ordering parts marked with a '*'
whole set will be delivered.

FITTING A PULLER ON CARPET OVEREDGING MACHINE

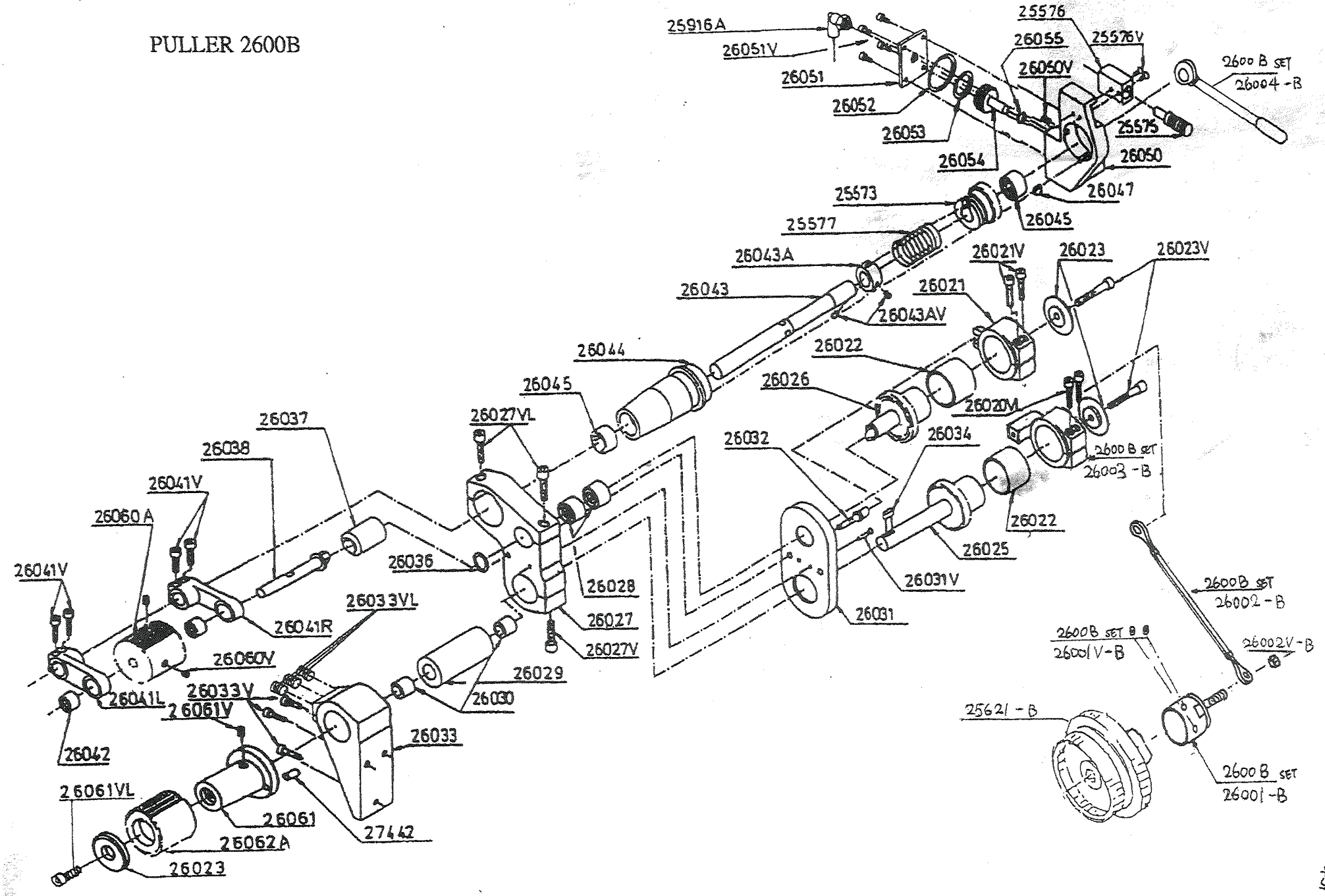


FITTING A PULLER ON CARPET OVEREDGING MACHINE




25916A
26051V
26051
26052
26053
26054
25576
26056V
26056
26055
25576V
26050V
25575
26057
26057R
26057E
26050
26047
26045
25573
25577
26043A
26043
26043AV
26021V
26023
26023V
26021
26044
26022
26026
26020A
26045
26037
26027VL
26038
26041V
26060
26036
26032
26034
26020
26020V
26022
26025
26019
26018
26017
26071
26031V
26031
26028
26027
26027V
26041V
26041R
26033VL
26060V
26029
26030
26033V
26041L
26061V
26033
26042
26061VL
26061
26062
26023
27442
26070
25722
25722E
26070V
27324
27324A
26012
26011
25734V
25734
26014
26010

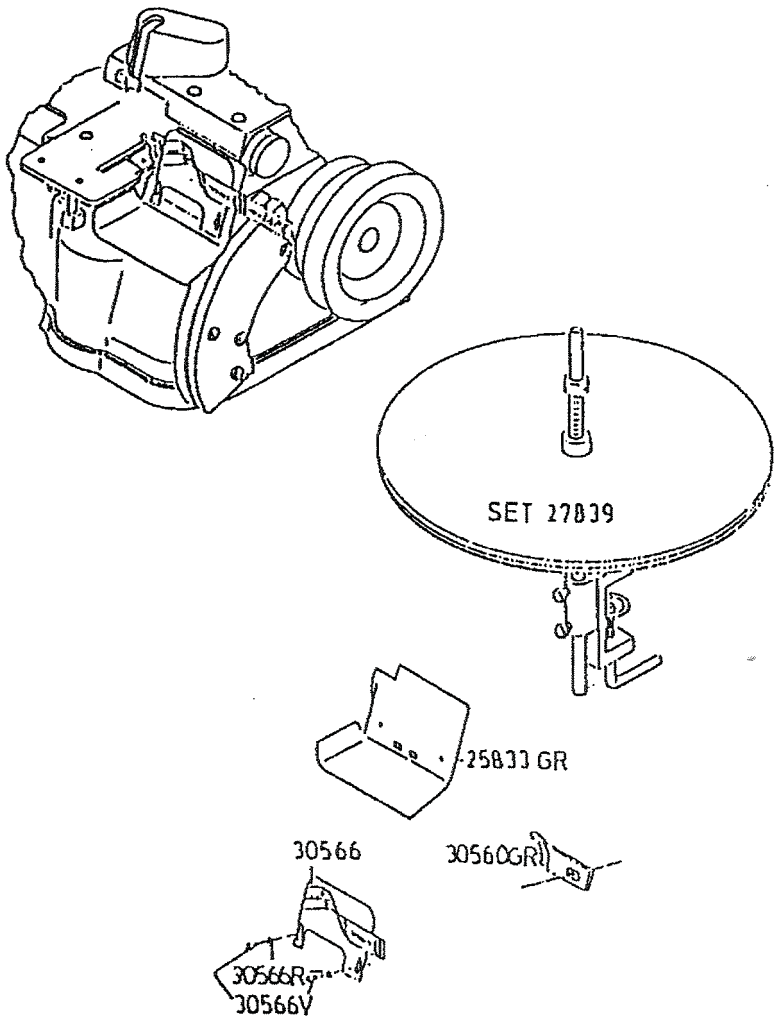
PULLER 2600B



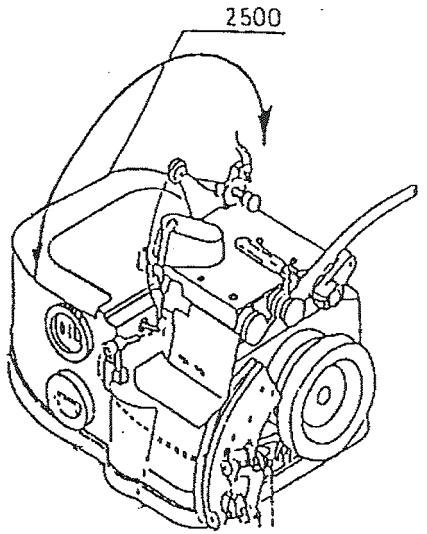
PULLER

25573		Bushing
25575		Regulating screw
25576	25576L	Regulating screw holder
25576V		Screw
25577	25577L	Foot lifter spring
25734		Thrust collar
25734V		Screw
26010		Big axle
26011		Bushing
26012		Bearing
26014		Seal-Ring
26016		Lever
26016V		Screw
26016VL		Screw
26017		Lever
26018		Bushing
260019		Pin
26020		Lever
26020V		Screw
26020VL		Screw
26021		Lever
26021V		Screw
26022		Wheel
26023		Washer
26023V		Screw
26025		Lower shaft
26026		Upper shaft
26027		Frame
26027V		Screw
26027VL		Screw
26028		Bearing
26029		Bushing
26030		Bearing
26031		Gear cover
26031V		Srew
26032		Pin
26033		Fixation support
26033V		Screw
26033VL		Screw
26034		Block
26036		Snap ring
26037		Bushing
26038		Cardan
26041R		Lever
26041V		Screw
26041L		Lever
26042		Bearing
26043		Shaft for levers
26043A		Thrust collar
26043AV		Screw
26044		Bushing

26045		Bearing
26047		Block
26050	26050L	Piston frame
26050V		Screw
26051		Cover
26051V		Screw
26060		Upper feed wheel
26060V		Screw
SET 26062		Lower feed wheel
26062V		Screw
SET 26054		Pneumatic cylinder (OPTION)
25916A		Elbow
26052		O-Ring
26053		O-Ring
26054		Piston
26055		O-Ring
26056		Lever
26056V		Screw
26057		Pin
26057E		Nut
26057R		Washer

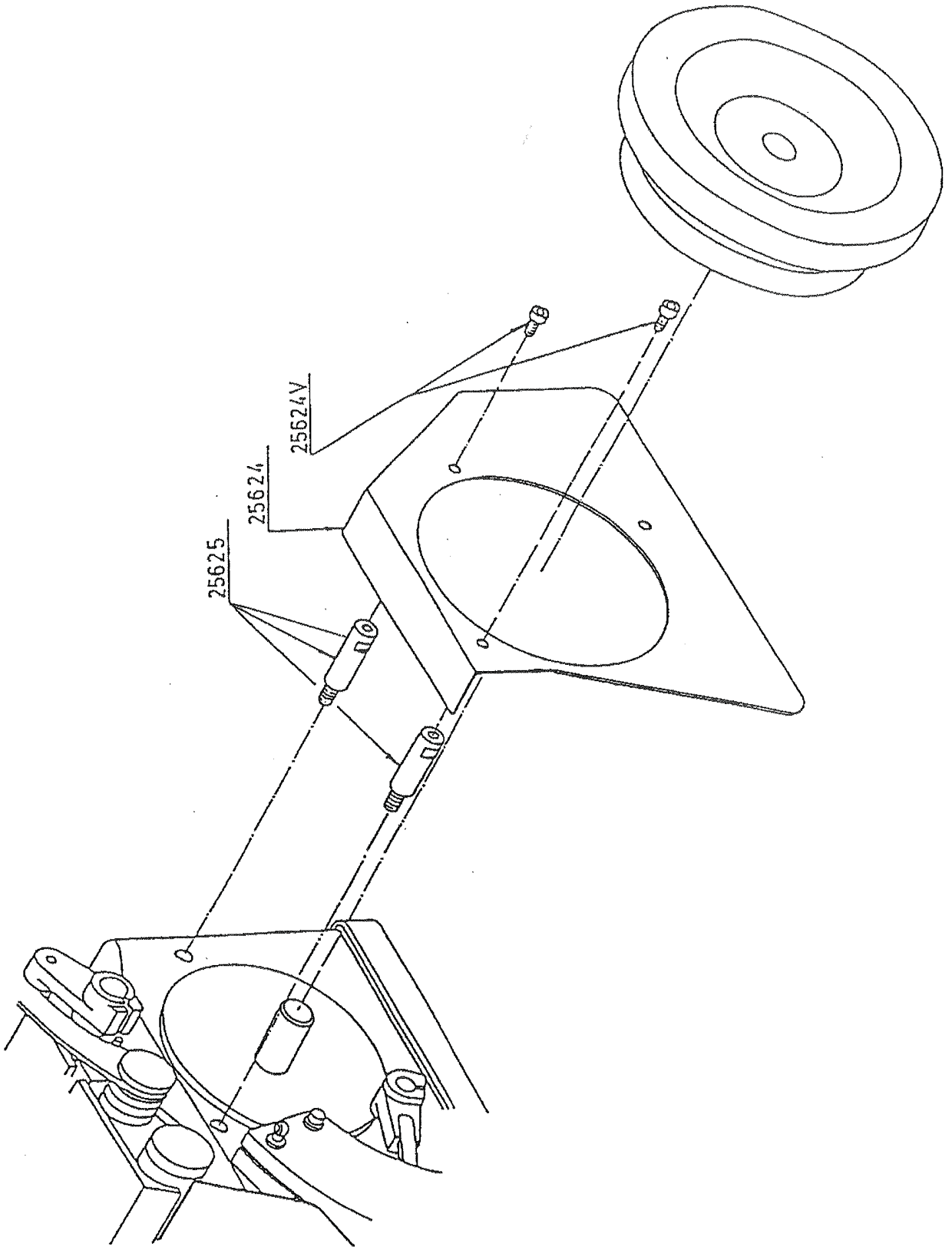


TAPE INSERTION
WITH OR WITHOUT KNIVES

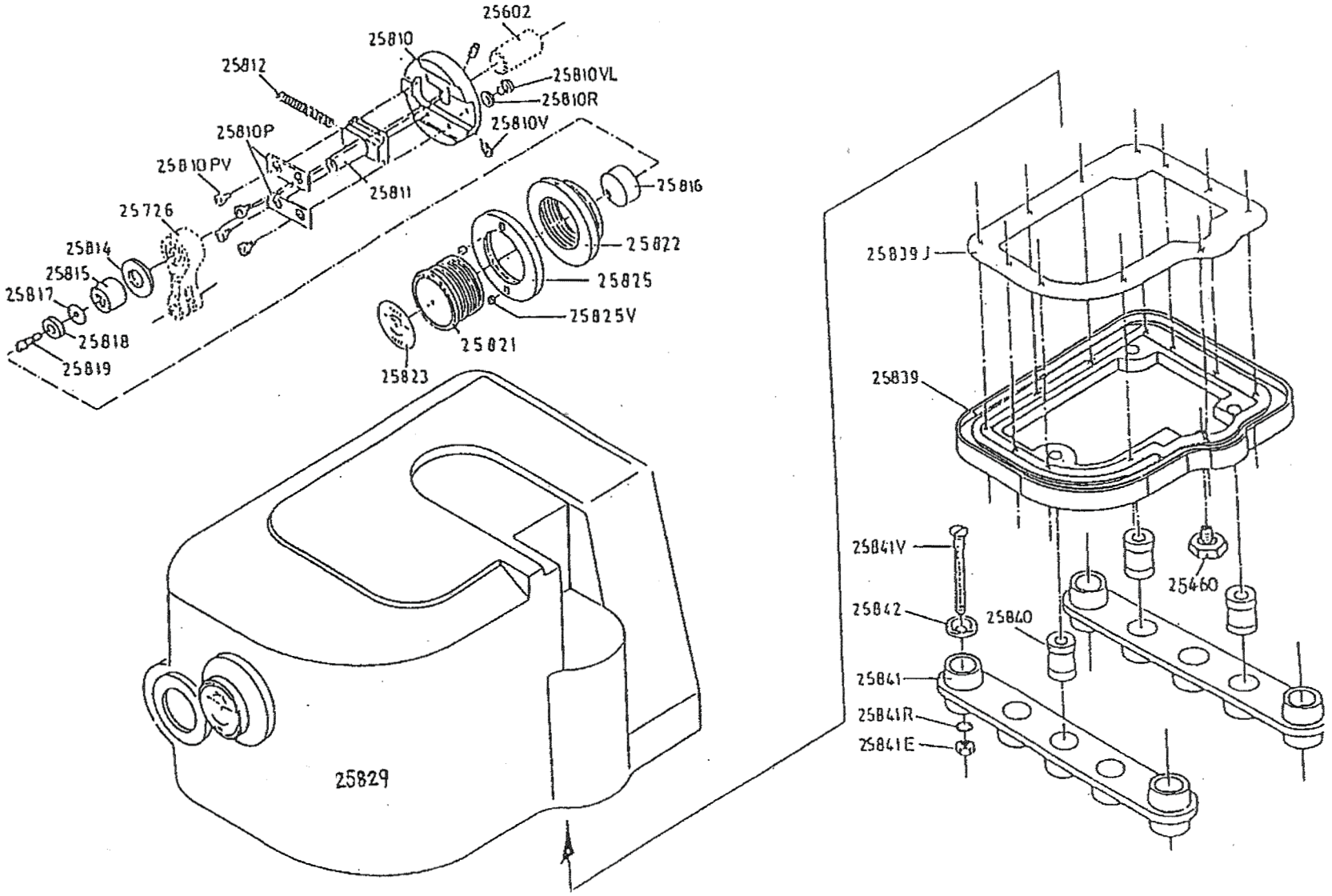


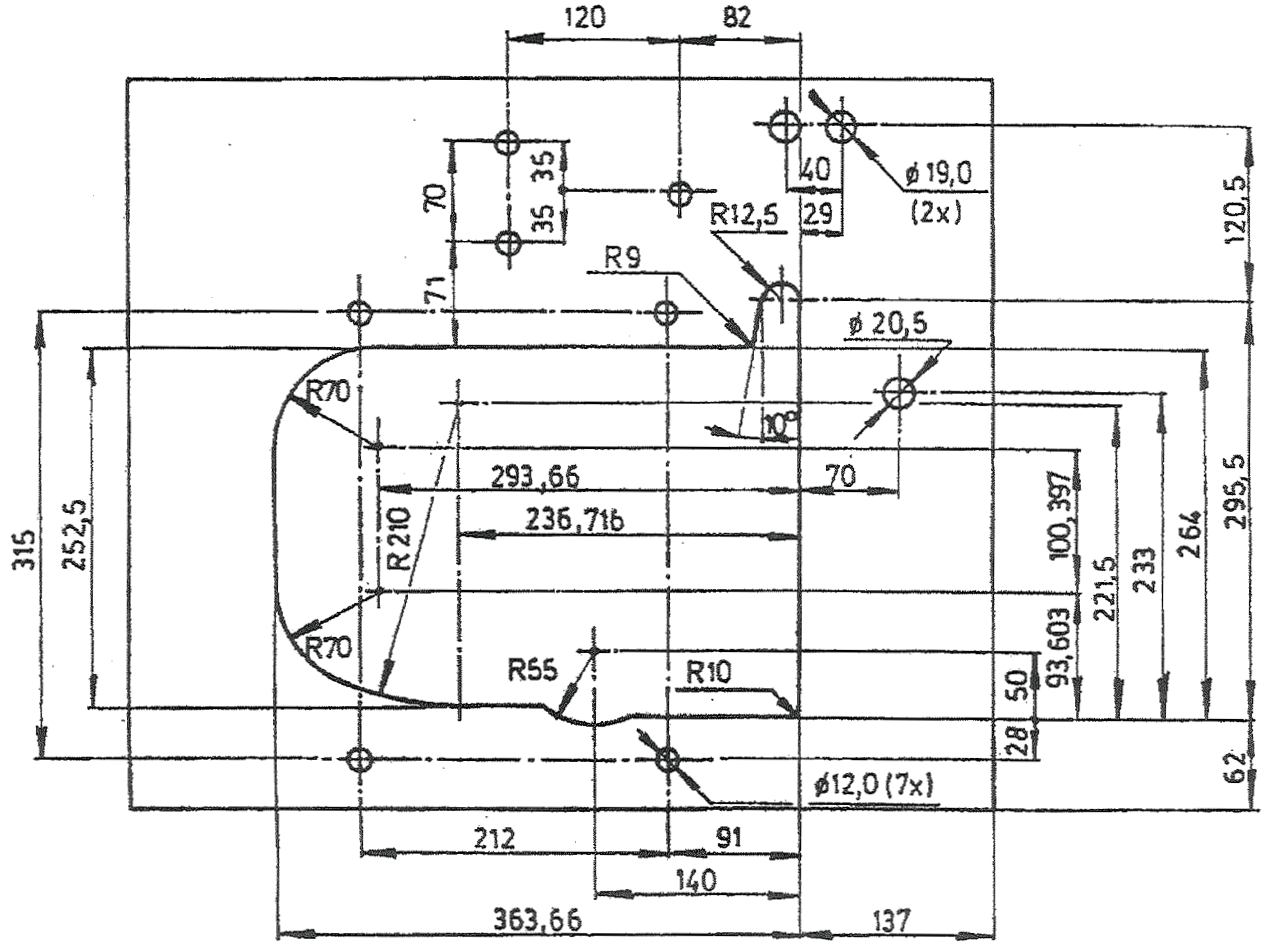
SERVICING WORKSTAND

BELT GUARD



Setting of length of stitch device. (option).





形狀及位置精度之圖記	
—	眞直度
▱	平面度
○	眞圓度
⌭	圓筒度
⌒	線之輪廓度
⌓	面之輪廓度
//	平行度
⊥	直角度
∠	傾斜度
⌖	位置度
◎	同軸度
⌯	對稱度
↗	偏轉(振↙)

加工符號表面粗度		
▽	荒仕上	100S以下
▽▽	中仕上	25S以下
▽▽▽	上仕上	6S以下
▽▽▽▽	極仕上	0.8S以下

一般尺寸切削公差		
尺寸劃分		
1~4	±0.05	±0.1
4~16	±0.07	±0.2
16~63	±0.10	±0.3
63~250	±0.2	±0.5
250~1000	±0.3	±0.8

熱處理硬度HRC	
表面處理	

備註欄

3					
2					
1					
	設變理由	位置	設變人	設變日期	
核准		繪圖			
校對		設計			

客件號碼		件數			
客件名稱	TABLE	材質			
機械名稱	AK-2500				
比例	1/	單位	%	日期	01·02·1993
				圖號	NO