

SECTION II

AAP26SEG24, AAP26SEG27

& AAP26SEG29

INSTALLATION INSTRUCTIONS

FOR

PEGASUS

G24 FOR MODEL EX5204-02

G27 FOR MODEL EX5214-02

G29 FOR MODEL S52

INSTRUCCIONES DE INSTALACIÓN

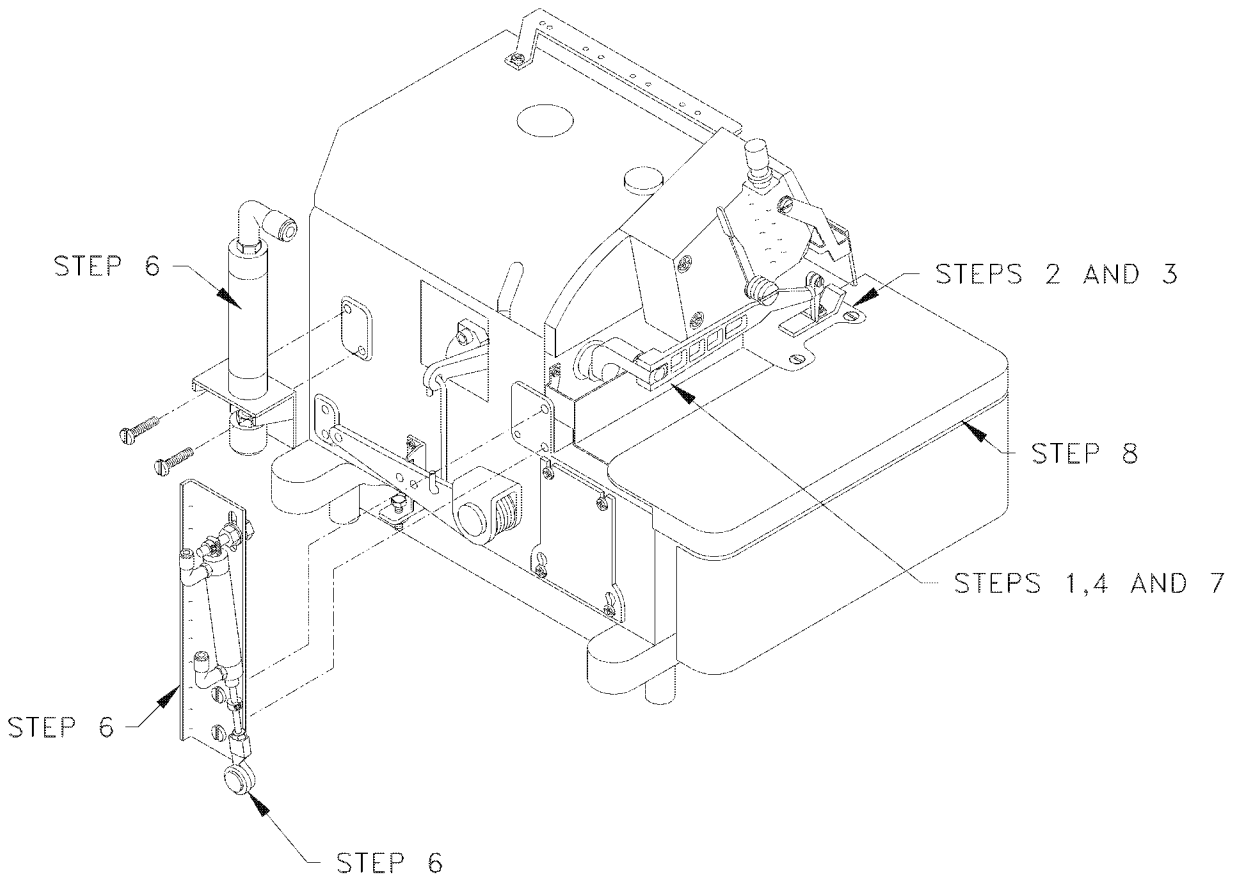
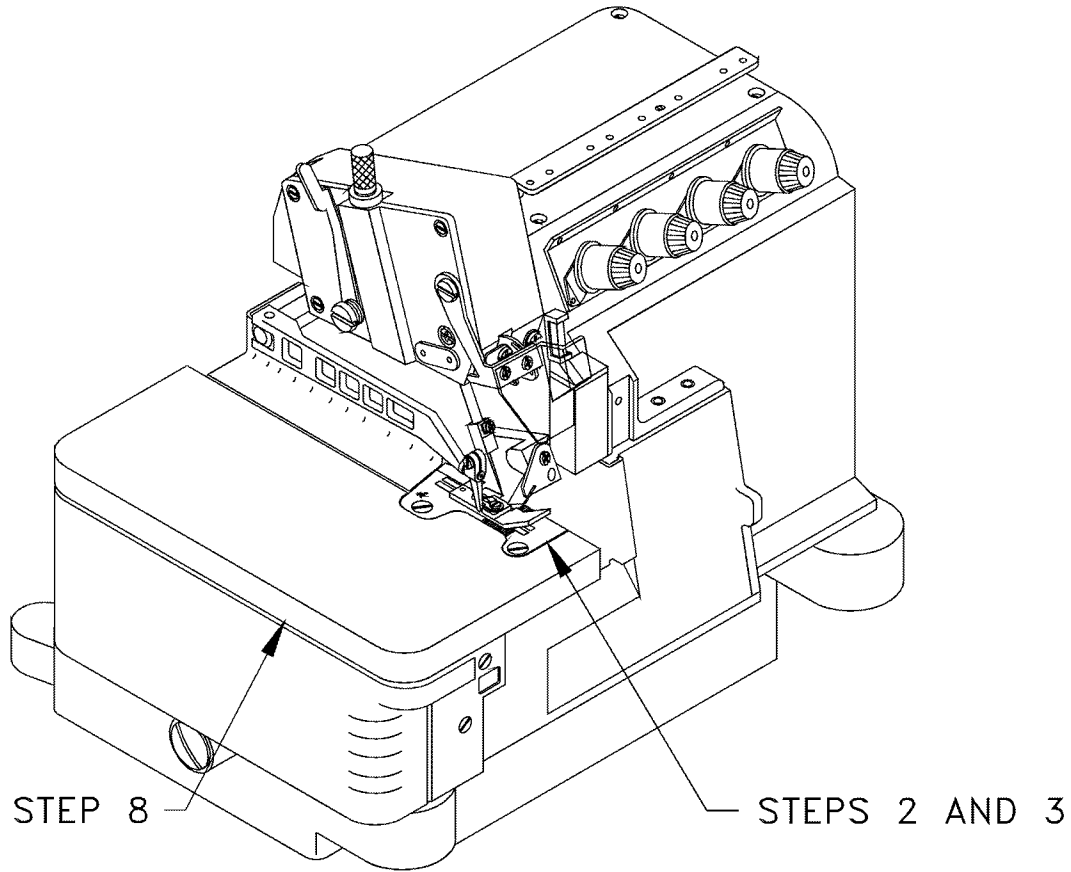
PARA

PEGASUS

G24 PARA MODELO EX5204-02

G27 PARA MODELO EX5214-02

G29 PARA MODELO S52



AAP26SE G24/27**Installation Instructions**

1. **Remove the material guard . Use the screws to mount the Cutter spacer block.**
2. **Remove the throat plate.**
3. **Remove the feed dogs. Install the feed dogs provided with the kit. (Or modify per dwgs. on pages 9 and 10 and reinstall)**
4. **Install the Cutter assembly (1975-400M) on the spacer block.**
5. **Install the patented throat plate provided (M3G24-001) or (M3G27-001). Check to make sure the needle is properly aligned in the slot. Check the feed dog alignment and set the feed dog height. Note: Check for interference between the Cutter body and the rear feed dog.**
6. **Mount the footlift cylinder assembly to the sewing head with the screws provided. Mount the Cutter drive cylinder assembly to the sewing head with the screws provided. Adjust the height of the moveable blade by moving the Cutter driver cylinder with the rod extended. The Cutter blade should be as high as possible without any interference. Use the clamp collar on the rod to limit the travel of the blade. The blades should be able to cut their entire length, but the moveable blade should not contact the Cutter body.**
7. **Install the material guide on the Cutter body.**
8. **Place the Cutter warning label on the cloth plate.**

AAP26SE G24/27**Instrucciones de Instalación**

- Quite la guarda del material. Use los tornillos para montar el bloque espaciador de la Cortadora.**
- Quite la plancha de la aguja.**
- Quite los dientes de arrastre. Instale los dientes de arrastre provistos. (O modifique de acuerdo a los dibujos en las pags. 9 y 10 y vuelva a montarlos)**
- Instale el ensamblado de la Cortadora (1975-400M) en el bloque.**
- Instale la plancha de la aguja patentada provista (M3G24-001) o (M3G27-001) Verifique que la aguja está debidamente alineada en la ranura. Chequee el alineamiento y fije la altura de los dientes. Nota: Chequee por interferencia entre el cuerpo de la Cortadora y los dientes de arrastre de atrás.**
- Monte el cilindro del alzaprensateles al cabezal con los tornillos provistos. Monte el ensamblado del cilindro de transmisión de la Cortadora al cabezal con los tornillos provistos. Ajuste la altura de la hoja movable moviendo el cilindro del transportador de la Cortadora con la varilla extendida. La hoja de la Cortadora debe estar tan alto como sea posible sin ningún obstáculo. Use el collar de sujeción en la varilla para limitar el viaje de la hoja. Las hojas deben poder cortar en toda su extensión, pero la hoja movable debe no entrar en contacto con el cuerpo de la Cortadora.**
- Instale la guía de material en el cuerpo de la Cortadora.**
- Coloque el rótulo de advertencia en la plancha de la tela.**

9. Mount the knee switch to the underside of table with the screws provided. The operator's right knee, while at rest, should be aligned with the edge of the trimming Cutter on the machine. Locate the knee switch accordingly. [Optional Pedal. Mount pedal to treadle mount brace on stand.]
10. Move existing treadle rod assembly from the treadle and install the treadle switch provided. The "T" air fitting should be positioned at the top. Adjust the treadle rod to accommodate the operator. The tension on the motor clutch should be adjusted so that the vacuum to the throat plate is turned on just before the machine begins to sew. Adjust the clutch if necessary at this time.
11. Mount the Control Panel Assembly to the table top using the screws provided.
12. Attach the air lines according to the pneumatic diagram.
13. The unit is now installed on the machine and is ready to be sewn off. See sew off instructions located in section 1 in this manual.

Monte el interruptor de rodilla a la parte de abajo de la mesa con los tornillos provistos. La rodilla derecha del operario, mientras en reposo, debe alinear con la cuchilla de la recortadora en la máquina. Localice el interruptor de la rodilla en conformidad. [Pedal Opcional. Monte el pedal a la montura en el soporte.]

Quite la varilla del pedal existente e instale el interruptor del pedal provisto. La "T" del sistema neumático debe estar arriba. Ajuste la varilla del pedal para dar comodidad al operario. La tensión en el embrague del motor debe ajustarse para que la succión a la plancha de la aguja se encienda justo antes que la máquina empieza a coser. Ajuste el embrague ahora si es necesario.

Monte el panel de Control a la mesa usando los tornillos provistos

Conecte las mangueras según el diagrama neumático.

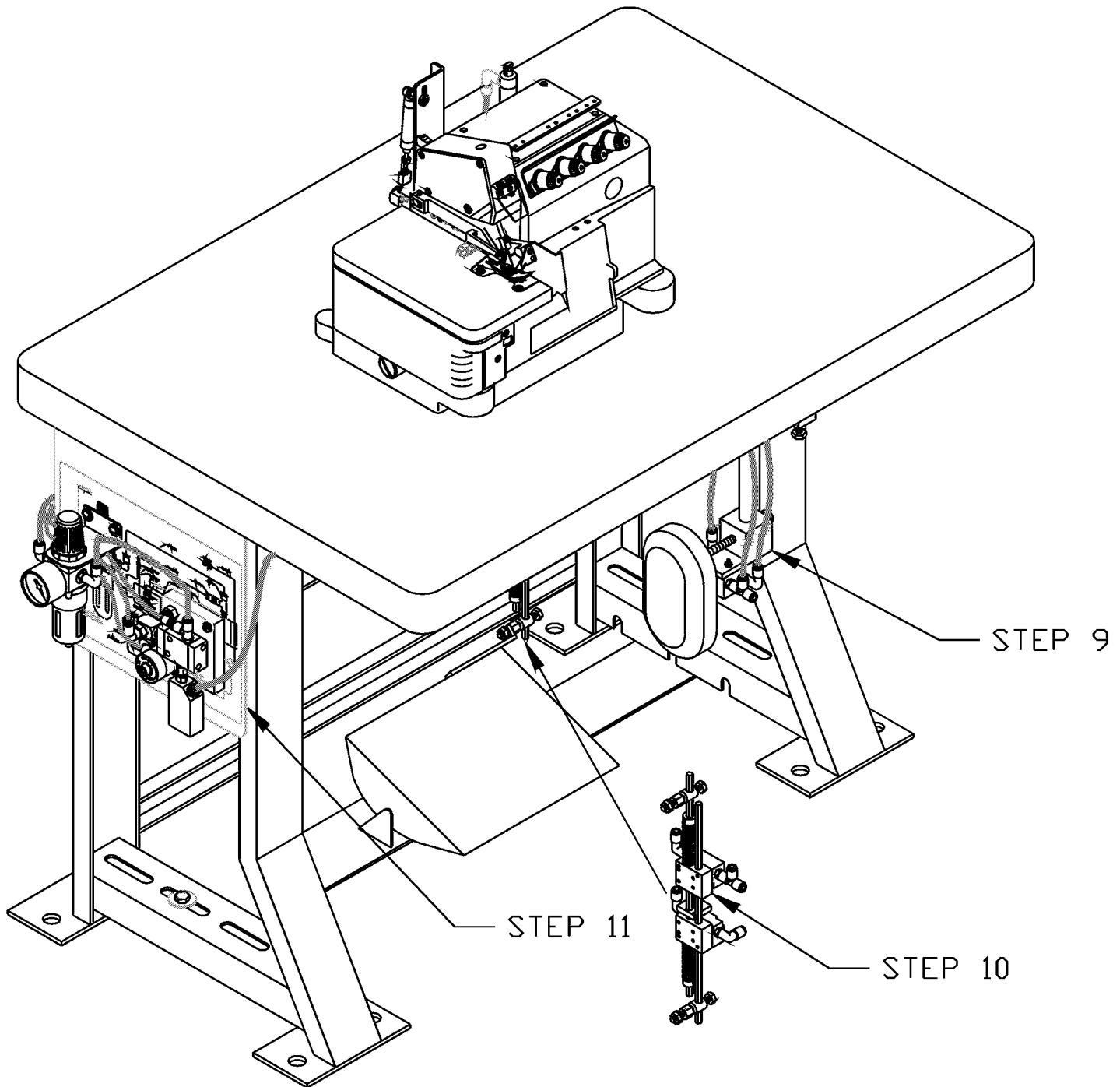
La unidad está ahora instalada en la máquina y lista para coser. Las instrucciones para coser las encontrará en la sección 1 del manual.

IMPORTANT NOTES

The needle height setting will be 1/16" less than the book setting because of the thicker throat plate. Make sure the lower looper does not contact the throat plate. If it does, install the throat plate spacer provided.

NOTAS IMPORTANTES

La altura de la aguja será 1/16" menos que la del libro debido a que la plancha de la aguja es más gruesa. Asegurese que el engazador (looper) de abajo no hace contacto con la plancha de la aguja. Si lo hace, instale el espaciador de la plancha de la aguja, (provisto.)



AAP26SE

1 ATTENTION / ATENCIÓN
MAKE SURE THAT CUTTER SHAFT DOES NOT BIND INSIDE BODY.
ASEGURESE QUE EL EJE NO SE ATASCA DENTRO DEL CUERPO.

2 ASSEMBLE LEAVING SCREWS SLIGHTLY LOOSENED ON LOWER CUTTER (SCREWS NOT SHOWN FOR CLARITY)
ARME DEJANDO LOS TORNILLOS FLOJOS EN EL CORTADOR DE ABAJO. (LOS TORNILLOS NO SE MUESTRAN POR CLARIDAD.)

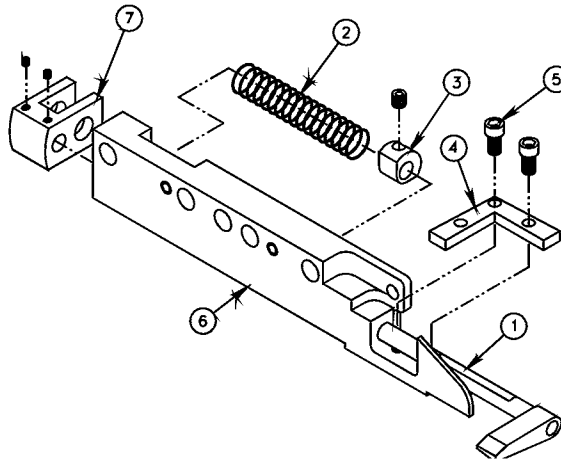
3 TIGHTEN SET COLLAR TO HOLD SPRING AT 41.15mm WITH UPPER CUTTER PRESSING AGAINST LOWER CUTTER
APRIETE EL COLLAR PARA MANTENER EL RESORTE A 41.15mm CON EL CORTADOR DE ARRIBA PRESIONANDO CONTRA EL CORTADOR DE ABAJO.

4 SET SHEAR AT .05mm AND TIGHTEN SCREWS ON LOWER CUTTER UNTIL IT IS LOCKED IN PLACE
FIJE EL CORTE A .05mm Y APRIETE BIEN LOS TORNILLOS EN EL CORTADOR DE ABAJO.

Labels in diagram: BODY, CUTTER SHAFT, LOWER CUTTER, .05mm GAUGE .002 IN, .002" .05mm, PINCH CLOSED "0" SPACING CERRADO "0" ESPACIO, LOWER CUTTER CORTADOR DE ABAJO, SCREWS TORNILLOS.

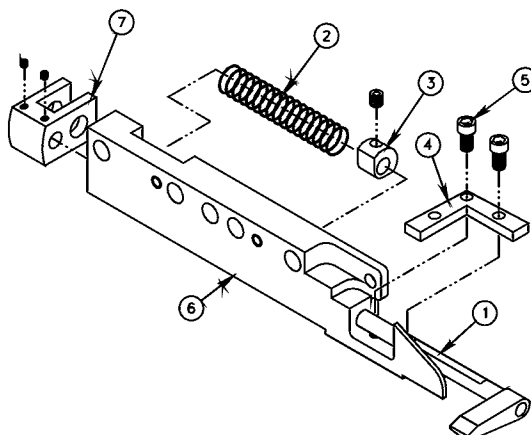
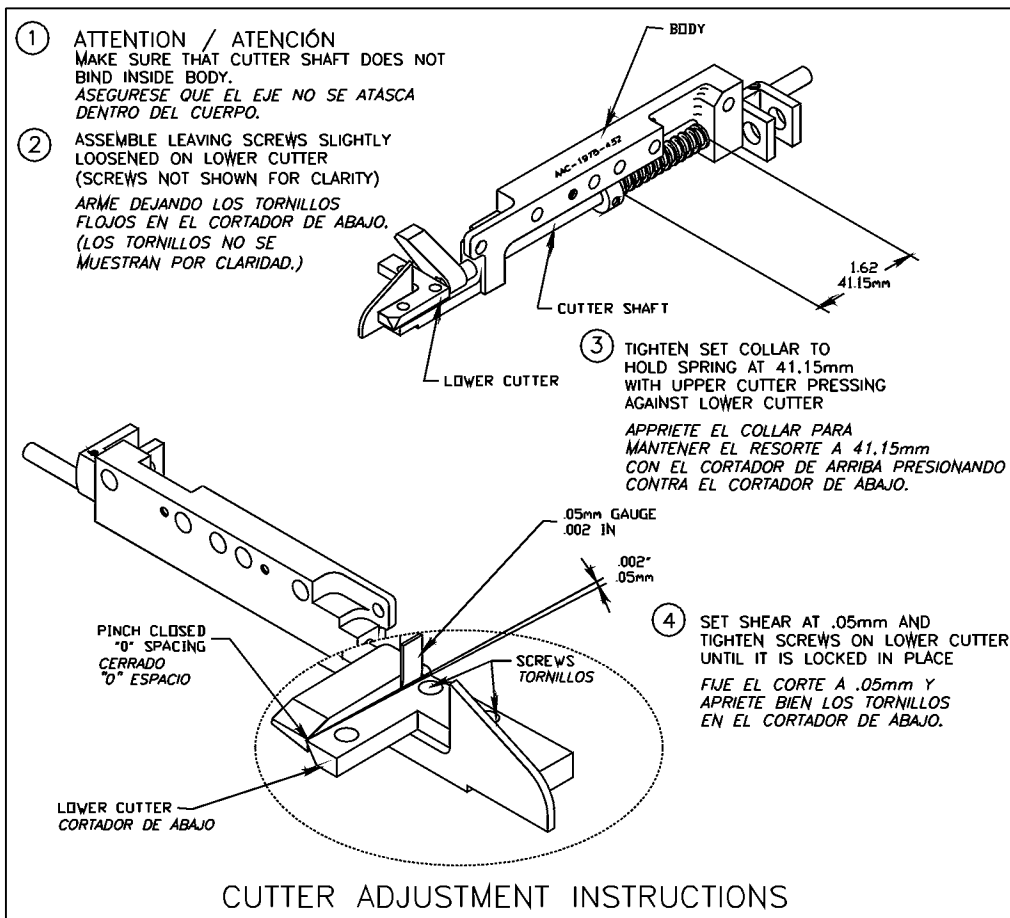
Dimension: 1.62 41.15mm

CUTTER ADJUSTMENT INSTRUCTIONS



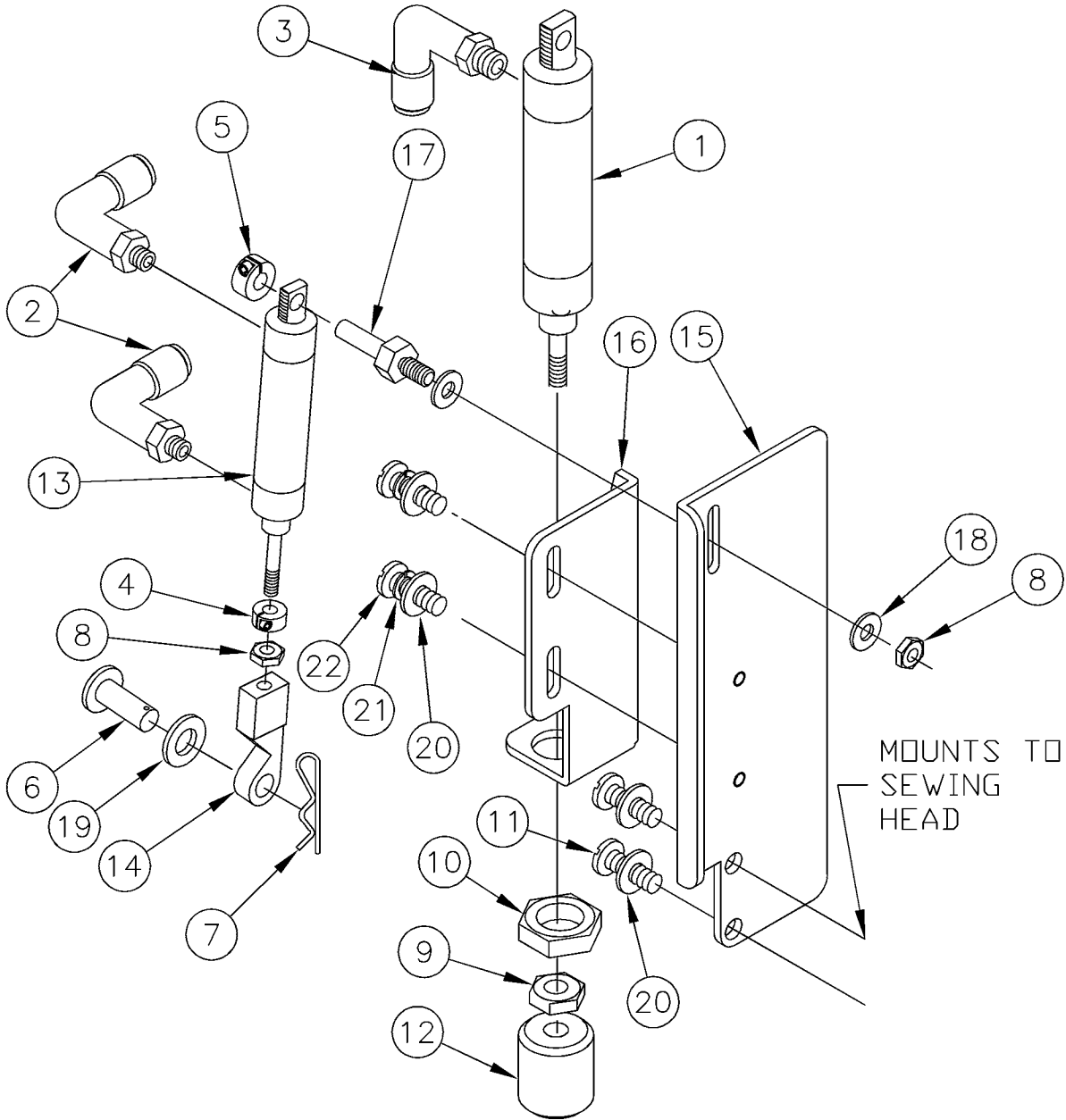
1975-400MG Cutter Assembly

Part No.	Description	Qty.	Pg.	Part No.	Description	Qty.	Pg.
1	1976-100	Upper Cutter Assy	1	6	1975-432	Cutter Body	1
2	RRLC024C14	Spring	1	7	1975-407	Clevis	1
3	1976-002	Retainer	1	NOTE: 1976-024 Lower Cutter has 2 sharpened sides. i.e. it may be rotated 1 time.			
4	1976-024	Lower Cutter	1	AAC Drawing Number = 190330C Rev.8			
5	SSSC70016	Ser,Soc Cap 4-40x.25	2				



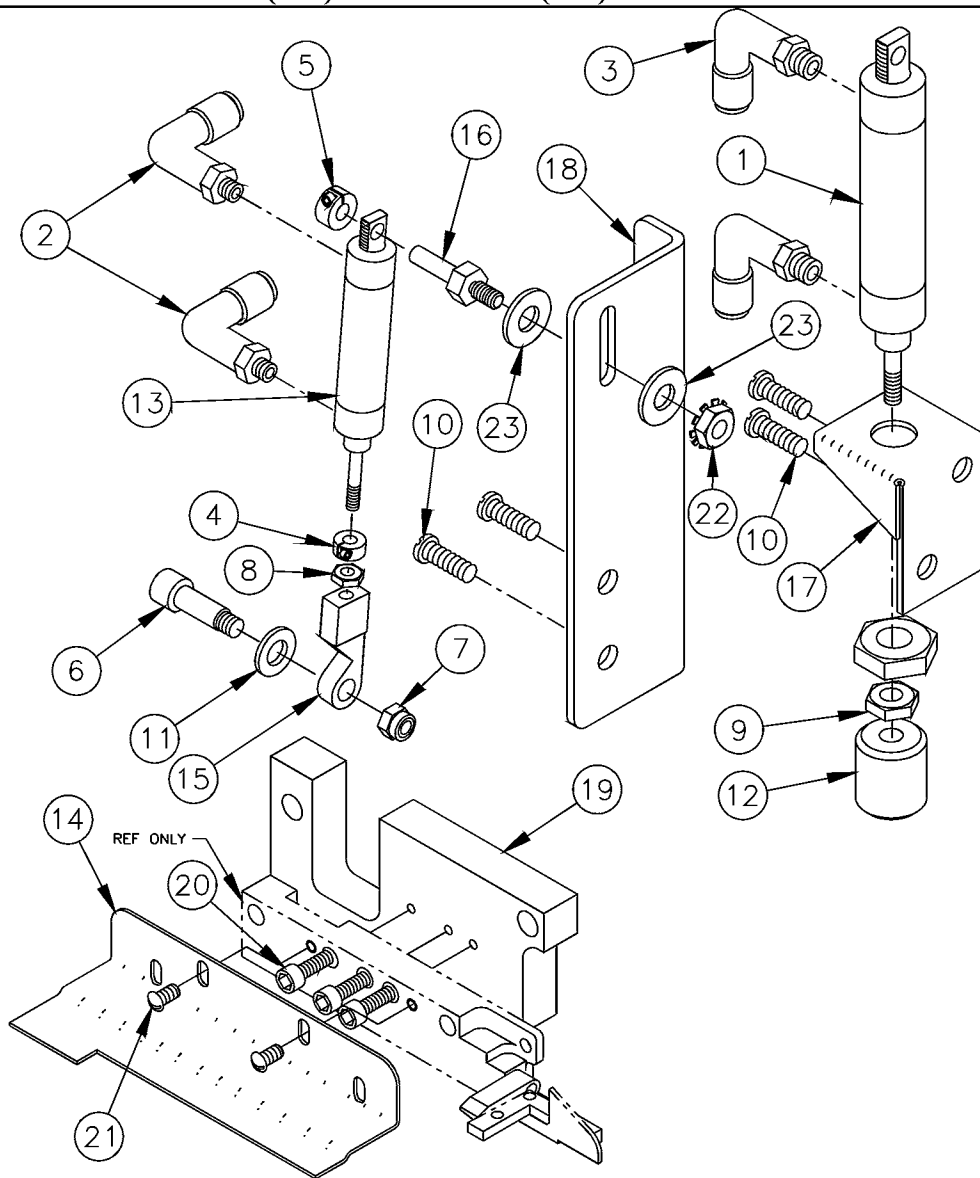
1975-400M5 Cutter Assembly

Part No.	Description	Qty.	Pg.	Part No.	Description	Qty.	Pg.
1	1976-100	Upper Cutter Assy	1	6	1975-432A	Cutter Body	1
2	RRLC024C14	Spring	1	7	1975-407	Clevis	1
3	1976-002	Retainer	1	NOTE: 1976-024 Lower Cutter has 2 sharpened sides. i.e. it may be rotated 1 time.			
4	1976-024	Lower Cutter	1	AAC Drawing Number = 190330C Rev.8			
5	SSSC70016	Scr,Soc Cap 4-40x.25	2				



1975-400B5 Cutter Assembly

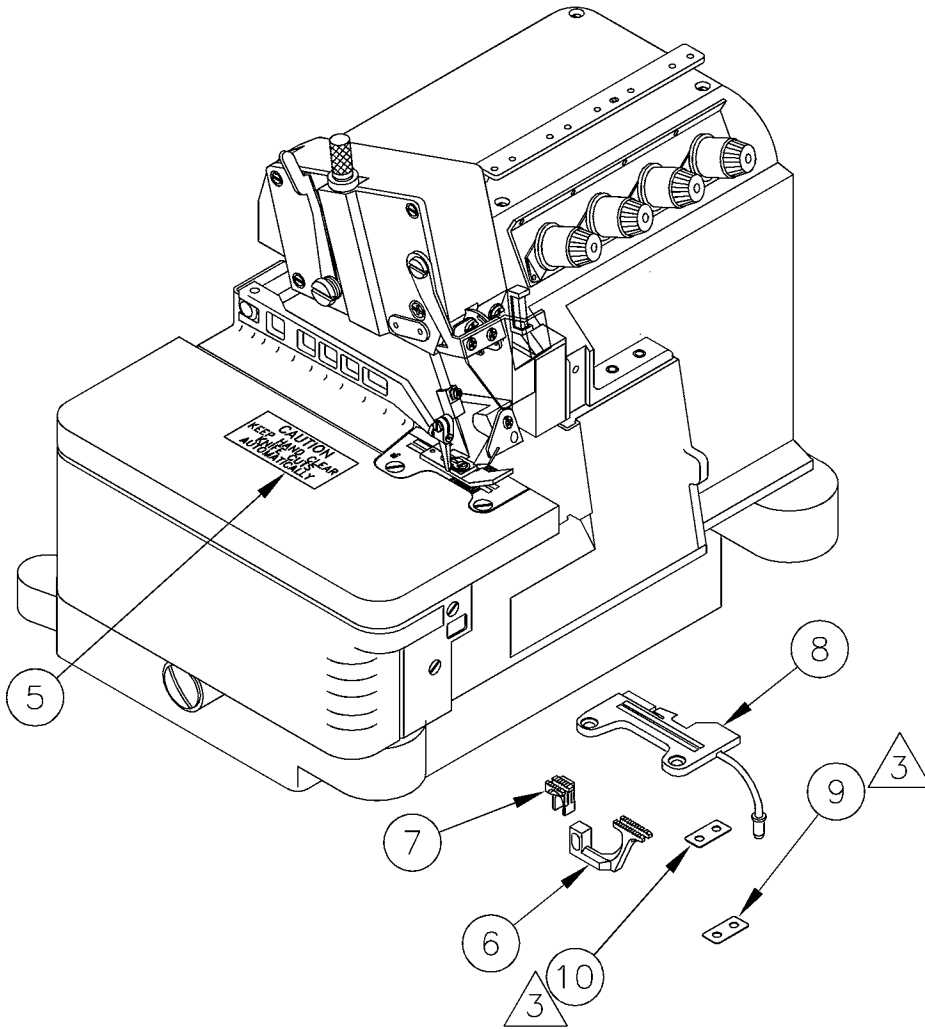
Part No.	Description	Qty.	Pg.	Part No.	Description	Qty.	Pg.
1	AAC7DP-1	1		13	1975-213A	1	
2	AAQME-5-10	2		14	1975-408	1	
3	AAQME- 5-8	1		15	1975-117A1	1	
4	CCCL3F	1		16	1975-117A2	1	
5	CCSC33/16	1		17	1976-048	1	
6	MM92390A15	1		18	WWF8	2	
7	MM98335A04	1		19	WWFF1/4A	1	
8	NNH10-32	2		20	WWFS10	4	
9	NNJ1/4-28	1		21	WWL10	2	
10	NNJ5/8-18	1		22	SSSC98024	3	
11	SSM136	2		AAC Drawing No. 190478A Rev. 7			
12	11200	1					



1975-400G6 Cutter & Footlift Pneumatics For Pegasus Sewing Head

Part No.	Description	Qty	Pg.	Part No	Description	Qty	Pg.
1	AAC7DP-1	Cylinder, Air	1	13	1975-213A	Cylinder, Air, Modified	1
2	AAQME-5-10	Quick Male Elbow	2	14	1975-244	Guard, Material	1
3	AAQME- 5-8	Quick Male Elbow	2	15	1975-408	Link, Drive	1
4	CCCL3F	Collar, 3/16	1	16	1976-048	Stud, Cylinder Mount	1
5	CCSC33/16	3/16 Set Collar	1	17	1976-057B	Footlift Cylinder Mount	1
6	SSM4633	Shdr Scr So	1	18	1976-058	Cutter Cylinder Mount	1
7	NNE10-32	Elastic Nut	1	19	1976-059	Spacer, Cutter Body	1
8	NNH10-32	Nut, Hex 10-32	1	20	SSSC85024	Scr, Socket Cap, 6-40	3
9	NNJ1/4-28	Nut, Jam 1/4-28	1	21	SSTS85016	Scr, Truss Slotted, 6-40	0
10	SSCM6X10	Screw, Cheese Head M6	4	22	NNK10-32	Kep Nut	1
11	WWFF1/4A	Felt Washer	1	23	WWFS10	SAE Flat Washer	2
12	11200	Bumper	1				

AAC Drawing No. 190478A Rev. 7



NOTES:

1 ITEMS NOTED ARE NOT SHOWN. THEY ARE USED TO ATTACH THE CANNISTER AND AIR LINES.

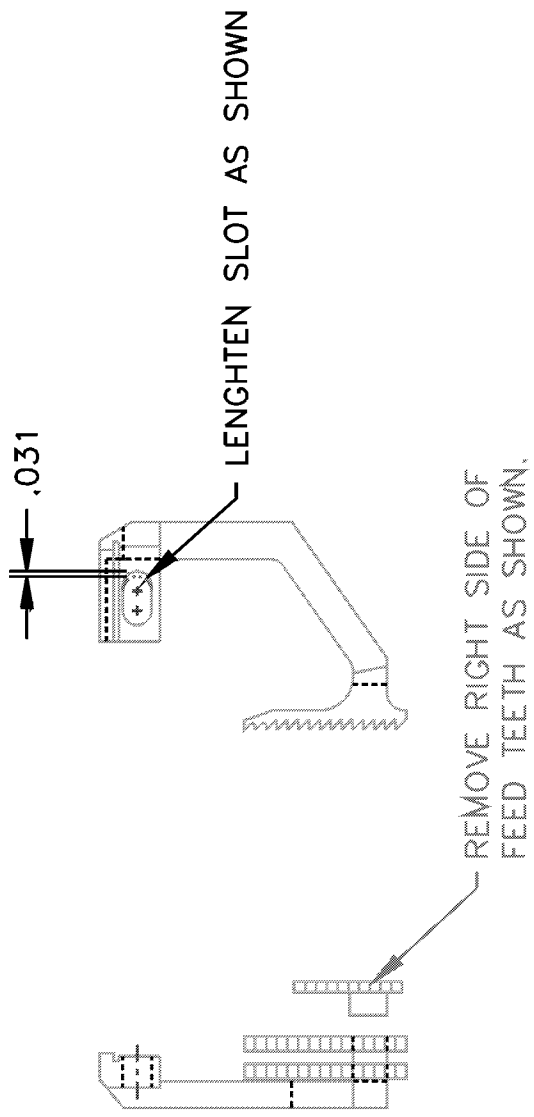
2. DUE TO THE INCREASED THICKNESS OF THE PLATE, THE FRONT TO BACK ANGLE OF THE DIFFERENTIAL FEED MAY NEED ADJUSTMENT

3 INSTALL UNDER PLATE THROAT MOUNT

1975-400** Throat Plate & Parts

Part No.	Description	Qty	Pg.	Part No.	Description	Qty.	Pg.
1	EE6X750	Cable Tie, 4 1/2"	8	6	M2G24-001	Feed Dog, Modified	1
2	NNE1/4-20	Nut, Elastic Lock, 1/4- 20	2	7	M2G24-002	Main Feed Dog	1
3	SSHC01056	Scr, Hex Cap 1/4-20 x 7/8	2	8	M3G24-001	For EX5204-02	0
4	WWF1/4	Washer, Flat 1/4	4	9	26419	Spacer Support, Front	1
5	AT-LABEL-1	Label "Caution"	1	10	26420	Spacer Support, Reart	1

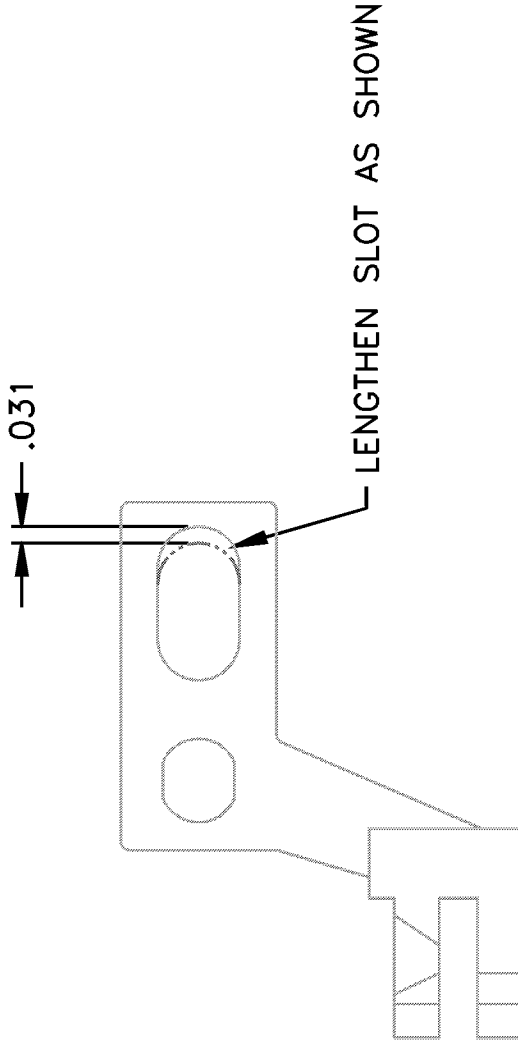
AAC Drawing Number = 190479A Rev. 6



QTY.	ITEM RECD. NO.	DESCRIPTION	PART NO. STOCK SIZE
1	455-96	FEED DOG, MODIFIED	
NO. REVISION		DATE DR. CK.	ATLANTA ATTACHMENT COMPANY
FINISH		TOLERANCE	NAME
PLAN	BLURR BENCH	SURFACE	2nd DES. FOR 0411-SG24
BLACK OXIDE	HEAT TREAT	DECIMALS	MATERIAL 277305-16F
SAND BLAST	BUFF	.X = ± .010	ASSEMBLY 0411-SG24
PAINT TAN	CHROMATE	.XX = ± .005	DES. BY JAM
TIME SAVE		.XXX = ± .002	DR. BY ALAN HUTCHINS
		.XXXX = ± .0005	CK. BY JEFF THOMAS
		FRACTIONS = ± 1/64	SCALE NTS
			DATE: 5-6-92
			WACH CL EX5204-02 PFAFF



139-92



QTY.	ITEM RECD.	NO.	DESCRIPTION	PART NO.	STOCK SIZE
			ATLANTA ATTACHMENT COMPANY		
			NAME	FEED DOG, MAIN	
			2nd DES.	EX5204 PFAFF	
			MATERIAL	277303-16F	
			ASSEMBLY	PART NO. M2G24-002	
			DES. BY	JDL DRAWING NO.	
			DR. BY	JEFF THOMAS REV	
			CK. BY	ALAN HUTCHINS 252095A 0	
			SCALE	3/1 DATE: 7-7-97 MACH CL EX5204 PFAFF	

NO.	REVISION	DATE	DR.	CK.
	FINISH	DEFAULTS		
	PLAIN BENCH	COUNTERSINKS: $\frac{1}{16}$ L .02		
	BLURR	DECIMAL TOLERANCE: ASSEMBLY		
	BLACKOXIDE	.X = \pm .010		
	HEAT TREAT	.XX = \pm .005		
	SAND BLAST	.XXX = \pm .002		
	BLUFF	.XXXX = \pm .0005		
	PAINT TAN	FRACTIONS = \pm 1/64		
	CHROMATE			
	TIMESAVE			
	OIL			



Notes