

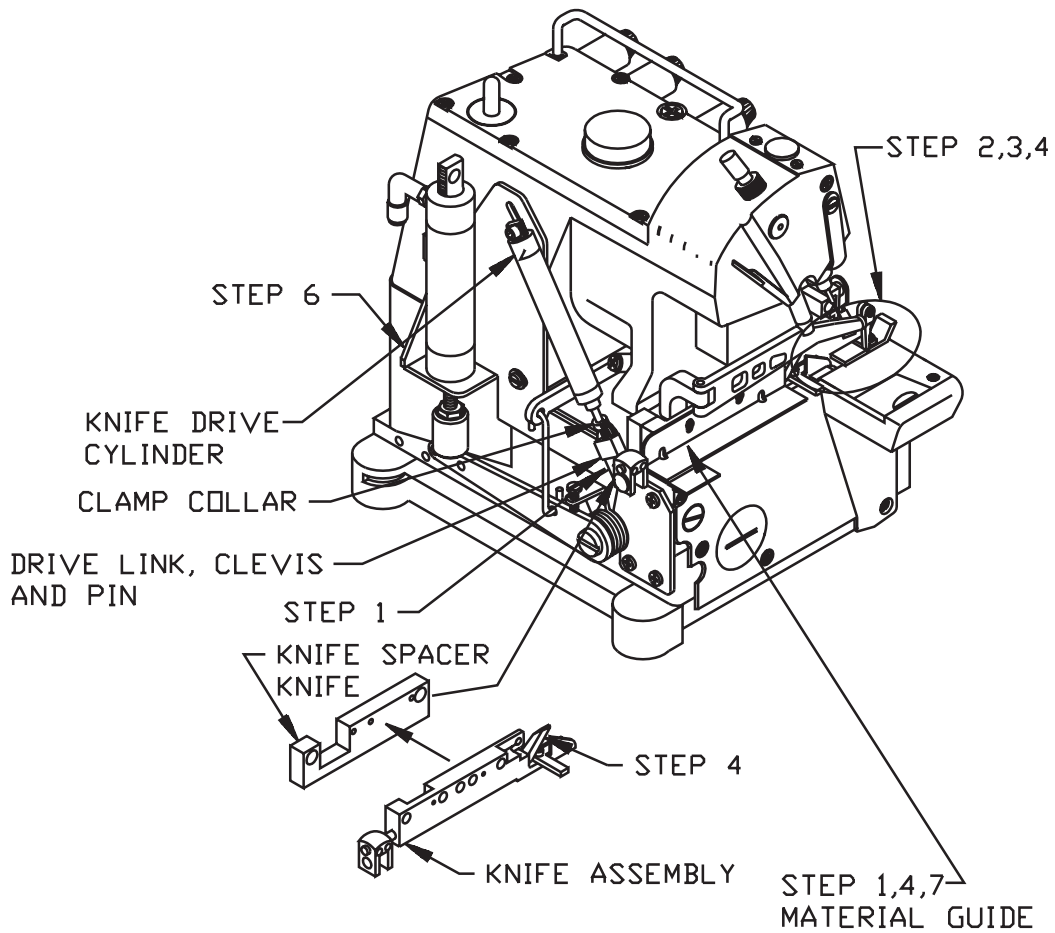
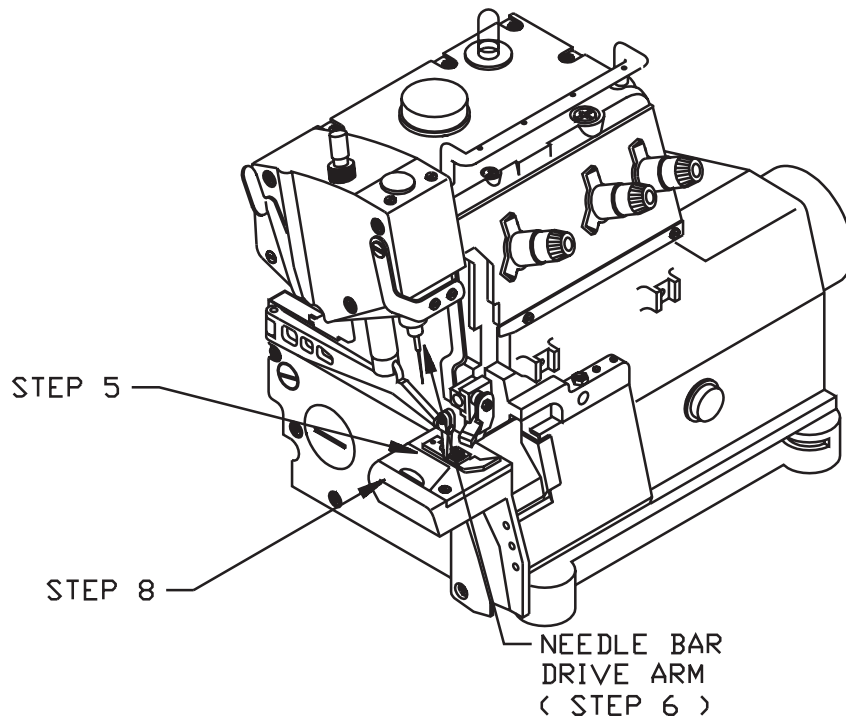
SECTION II

AAP26SEL93 INSTALLATION INSTRUCTIONS FOR

SP161 UNION SPECIAL

**INSTRUCCIONES DE INSTALACIÓN
PARA**

SP161 UNION SPECIAL



AAP26SEL93**Installation Instructions**

1. Remove the material guide.
2. Remove the throat plate.
3. Remove both feed dogs. Install the feed dogs supplied with the kit. (see note below)
4. Install the Cutter assembly (1975-400M) on the spacer block.
5. Install the patented throat plate provided (M2L93-001, page 2-8). Check to make sure the needle is properly aligned in the slot. Check the feed dog alignment and set the feed dog height. See modification drawing for mounting block on page 2-9.
NOTE: Check for interference between the Cutter body and the rear feed dog.
6. Remove secondary lift lever and attach lift lever extension.
7. Attach the combination cylinder mount bracket to the head with the screws provided (1975-400Y assembly). Connect the drive link to the clevis with the pin provided. Adjust the height of the movable blade by moving the Cutter drive 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 movable blade should not contact the Cutter body.
8. Place the Cutter warning label on the cloth plate.

AAP26SEL93**Instrucciones De Instalación**

- Quite la guía de material.
- Quite la plancha de la aguja.
- Quite ambos dientes de arrastre. Instale los dientes suplidos con el equipo. (vea nota abajo)
- Instale el ensamblado de la Cortadora (1975-400M) en el bloque espaciador.
- Instale la plancha de la aguja (patentada) provista (M2L93-001, página 2-8) Asegurese que la aguja está debidamente alineada en la ranura. Verifique la alineación y fije la altura del transportador. Vea el dibujo de modificación del bloque montura en la página 2-9.
NOTA: Chequee por interferencia entre el cuerpo de la Cortadora y el transportador posterior.
- Quite la palanca secundaria del alzaprensatelas y conecte la extensión de la palanca.
- Monte el soporte del cilindro al cabezal con los tornillos provistos (ensamblado 1975-400Y) Conecte la biela de la transmisión a la horqueta con el pasador provisto. Ajuste la altura de la hoja movable moviendo el cilindro de accionamiento de la Cortadora con la varilla extendida. La hoja de la Cortadora debe estar tan alto como es posible sin ninguna interferencia. Use el collar de sujeción en la varilla para limitar el viaje de la hoja de la Cortadora. Las hojas deben poder cortar en todo su largo, pero la hoja movable no debe entrar en contacto con el cuerpo de la Cortadora.
- Ponga el aviso de advertencia en la plancha de la tela.

- | | |
|--|--|
| <p>9. Mount the knee switch to the under side of the table with the screws provided. The operator right knee, while at rest, should be aligned with the edge of the trimming Cutter on the machine. Locate the knee switch accordingly.</p> | <p>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 recortadora de borde en la máquina. Sítrue el interruptor de rodilla de acuerdo.</p> |
| <p>10. Remove the existing treadle rod assembly and install the treadle switch provided. The "T" air fitting (5) should be positioned on the top. Adjust the treadle rod assembly to accommodate the operator. The tension on the motor clutch arm should be adjusted so that the vacuum to the throat plate is turned on just before the sewing machine starts sewing. Adjust the clutch if necessary at this time.</p> | <p>Quite el ensamblado de la varilla del pedal e instale el interruptor del pedal provisto. La "T" del sistema neumático rotulada 5 debe colocarse arriba. Ajuste el pedal con la varilla para dar comodidad al operario. La tensión en el brazo del embrague del motor debe ajustarse para que la succión se encienda justo antes que la máquina comienza coser. Ajuste ahora el embrague si necesario.</p> |
| <p>11. Mount the Control Panel Assembly to the table top using the screws provided.</p> | <p>Monte el panel de Control a la mesa usando los tornillos provistos.</p> |
| <p>12. Attach the air lines according to the pneumatic diagram.</p> | <p>Conecte las mangueras de aire según el diagrama neumático.</p> |
| <p>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.</p> | <p>La unidad esta ahora instalada en la máquina y lista para coser. Las instrucciones para coser las encontrará en la sección 1 del manual.</p> |

IMPORTANT NOTES

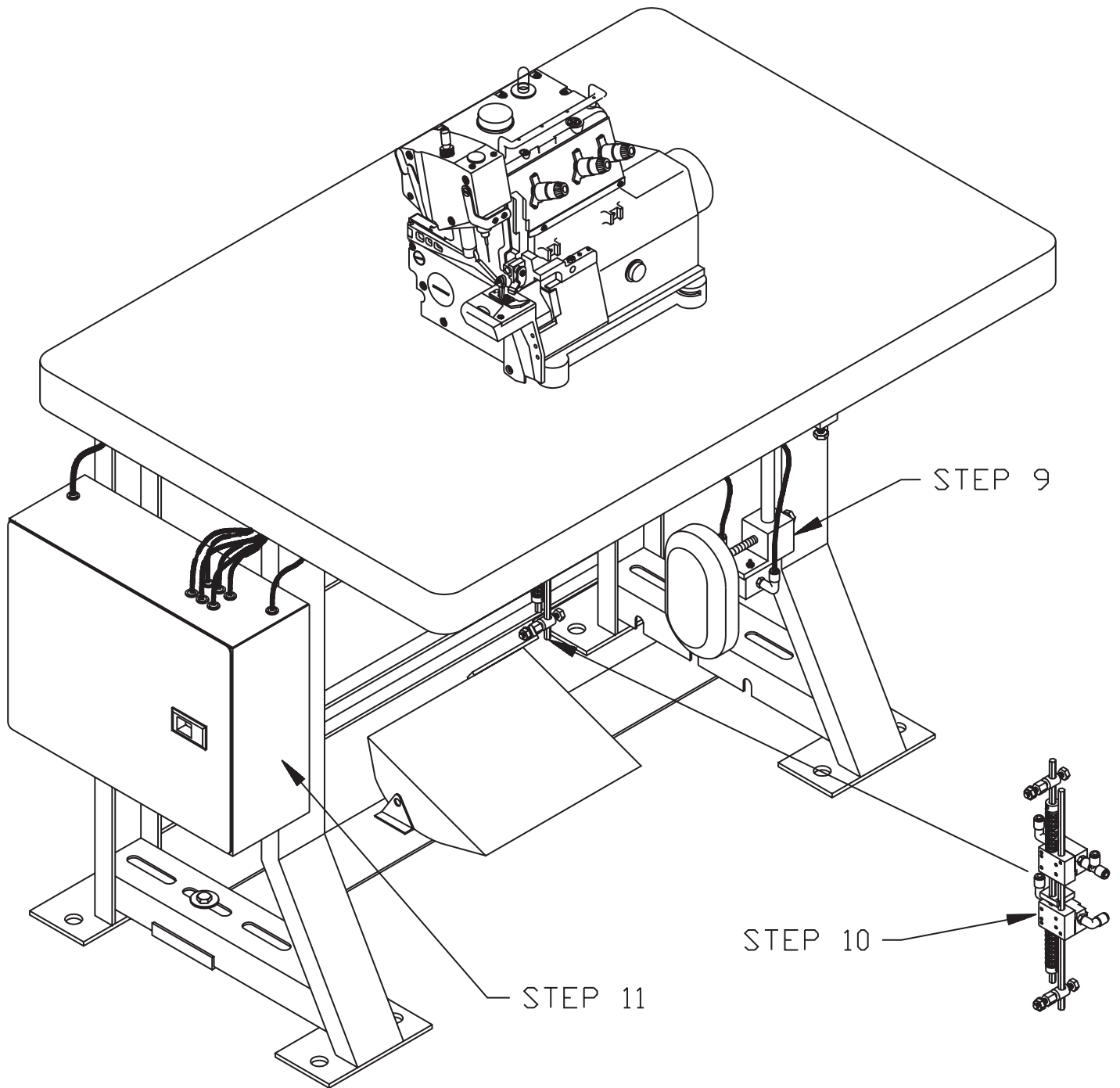
The needle height setting will be 1/16" less than the book setting because of the thicker throat plate.

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 posición 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) inferior no hace contacto con la plancha de la aguja. Si lo hace, instale el espaciador de la plancha de la aguja provisto.



AAP26SE

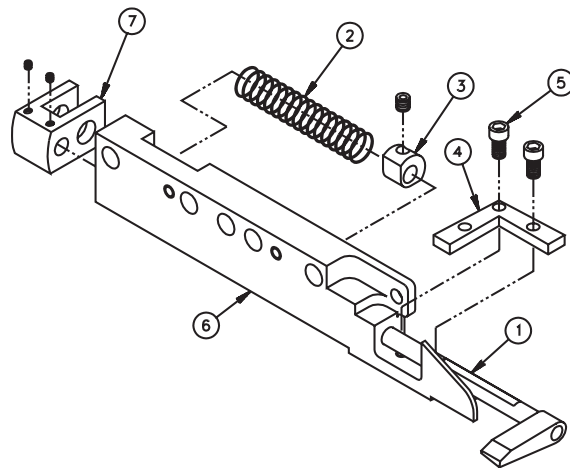
① ATTENTION / ATENCIÓN
MAKE SURE THAT CUTTER SHAFT DOES NOT BIND INSIDE BODY.
ASEGURESE QUE EL EJE NO SE ATASCA DENTRO DEL CUERPO.

② ASSEMBLE LEAVING SCREWS SLIGHTLY LOOSE 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.

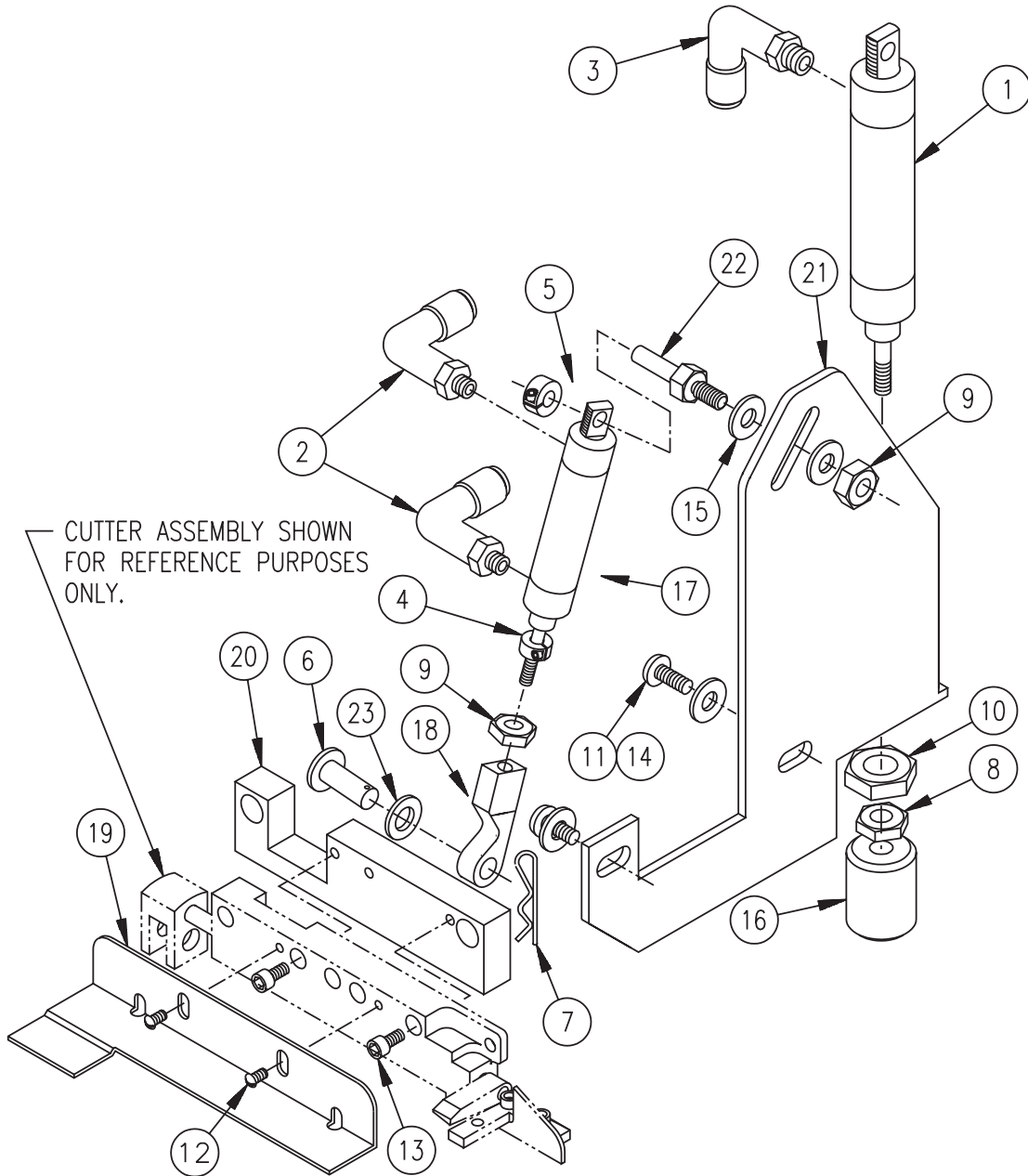
④ SET SHEAR AT .05mm AND TIGHTEN SCREWS ON LOWER CUTTER UNTIL IT IS LOCKED IN PLACE
FIJE EL CORTE A .05mm Y APRIETE BIEN LOS TORNILLOS EN EL CORTADOR DE ABAJO.

CUTTER ADJUSTMENT INSTRUCTIONS



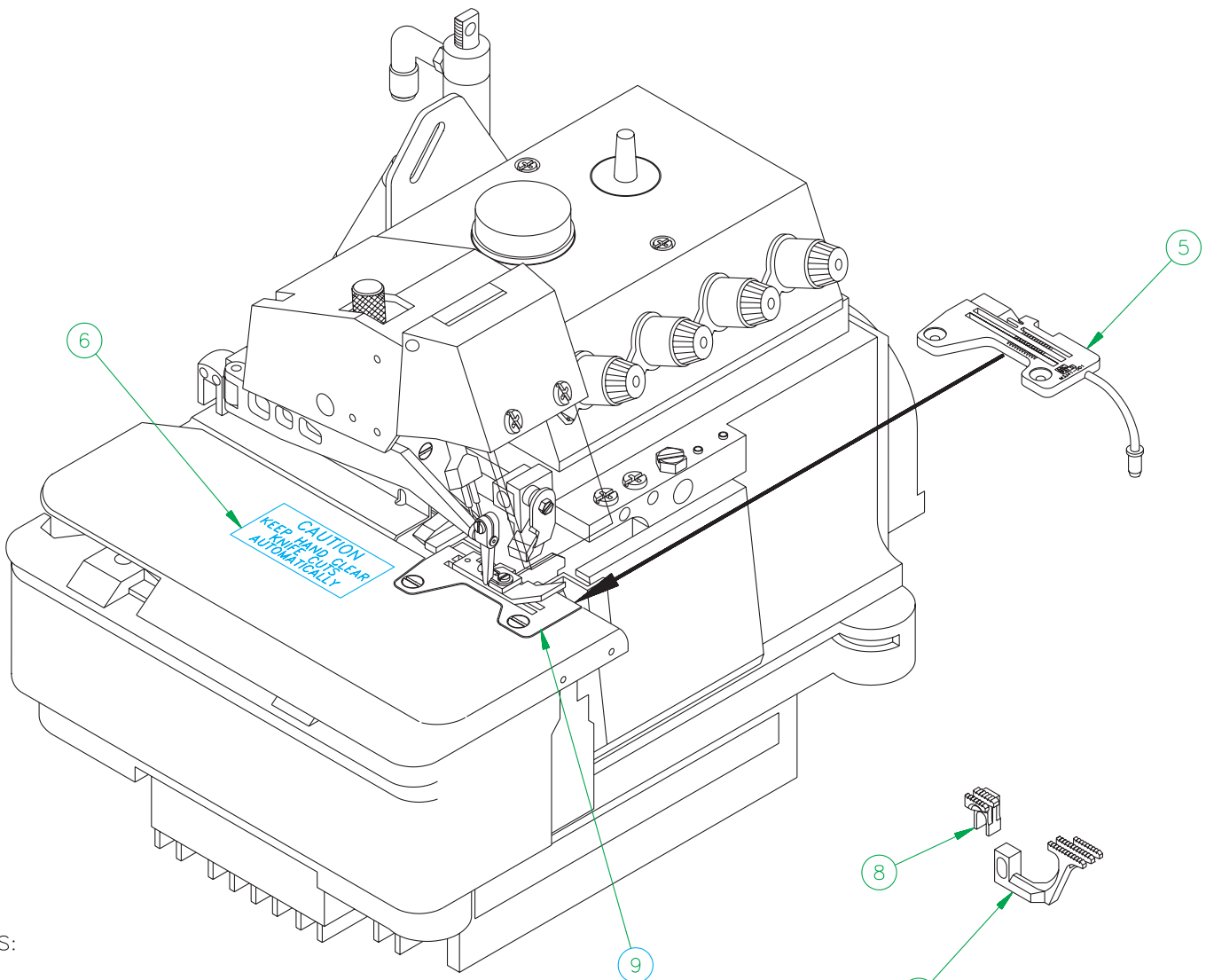
1975-400M Cutter Assembly

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 Scr,Soc Cap 4-40x.25	2					



1975-400Y Cutter & Footlift Pneumatics

Part No.	Description	Qty.	Pg.	Part No.	Description	Qty.	Pg.
1	AAC7DP-1	1		13	SSSC85024	2	
2	AAQME-5-10	2		14	WWF1/4	2	
3	AAQME-5-8	1		15	WWF10	2	
4	CCCL3F	1		16	11200	1	
5	CCSC33/16	1		17	1975-213A	1	
6	MM92390A15	1		18	1975-408	1	
7	MM98335A04	1		19	1975-445	1	
8	NNH1/4-28	1		20	1975-451	1	
9	NNH10-32	2		21	1975-452	1	
10	NNJ5/8-18	1		22	1976-048	1	
11	SSM7151210	2		23	WWFF1/4A	1	
12	SSTS85016	2		AAC Drawing Number = 190256A Rev. 4			



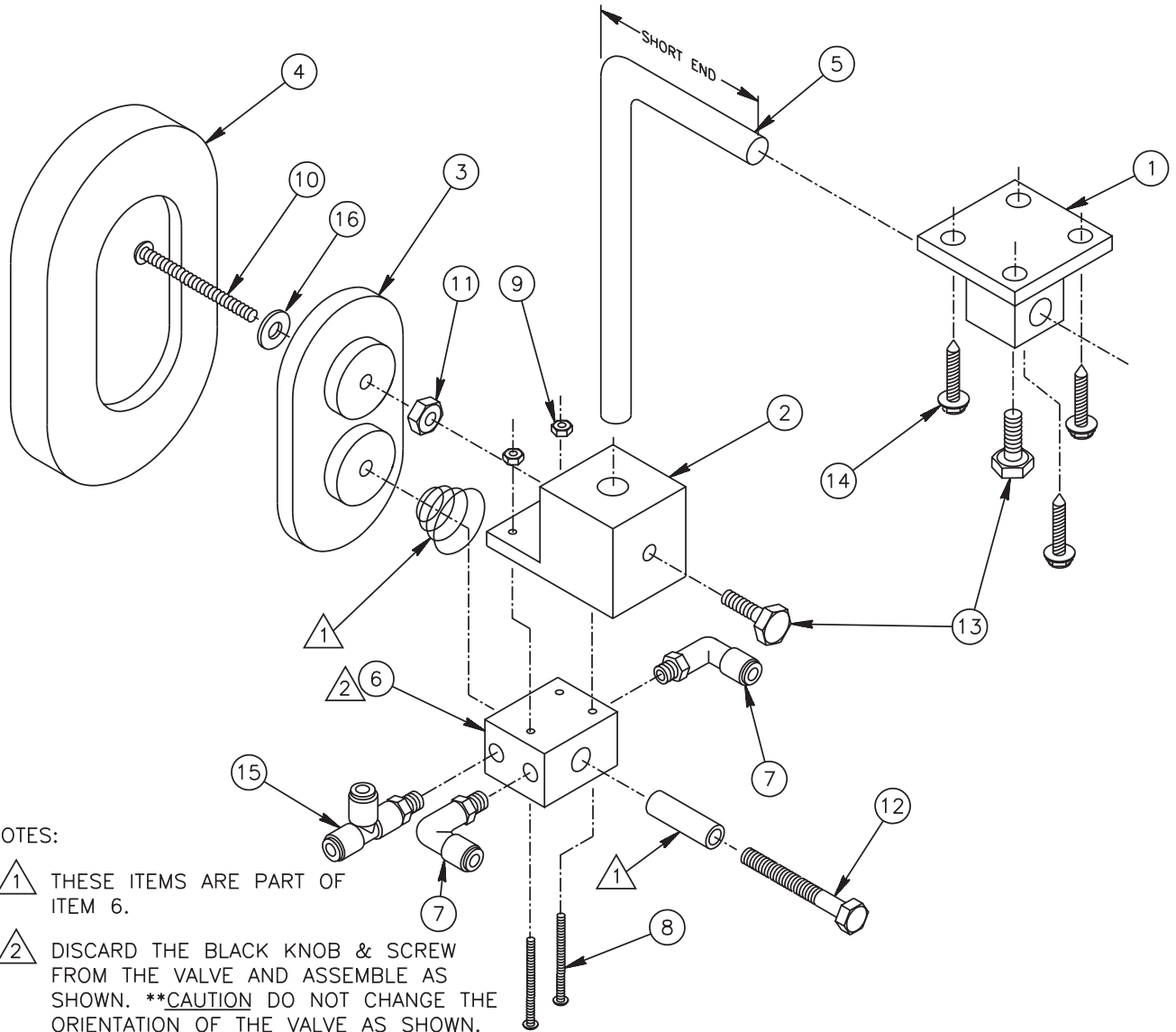
NOTES:

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

Throat Plate & Parts

Part No.	Description	Qty	Part No.	Description	Qty.
1-4	not shown	Misc. screws and washers	8	M2L93-002	Main Feed Dog *
5	M3L93-001	Needle Plate,Backlatch 1	9	1976-104	Front Throat Supp. Mod 1
6	AT-LABEL-1	Label, "CAUTION" 1			
7	M2L93-001	Diff. Feed dog *			

* Feed dogs are available for purchase.

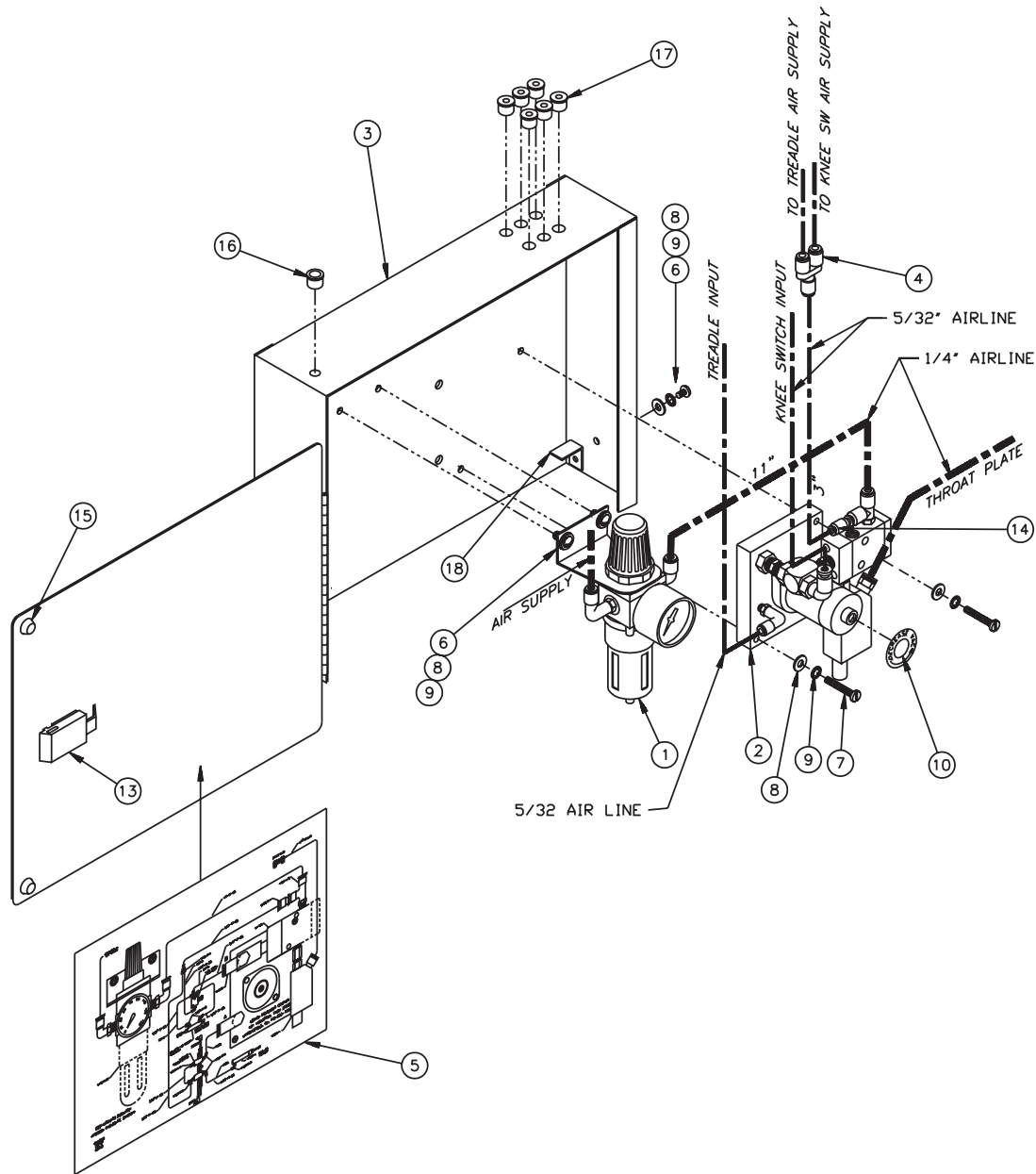


NOTES:

- △ 1 THESE ITEMS ARE PART OF ITEM 6.
- △ 2 DISCARD THE BLACK KNOB & SCREW FROM THE VALVE AND ASSEMBLE AS SHOWN. ****CAUTION** DO NOT CHANGE THE ORIENTATION OF THE VALVE AS SHOWN.
- 3. ITEMS 1-13 TOGETHER MAKE UP A AA192-6-1 KNEE SWITCH.

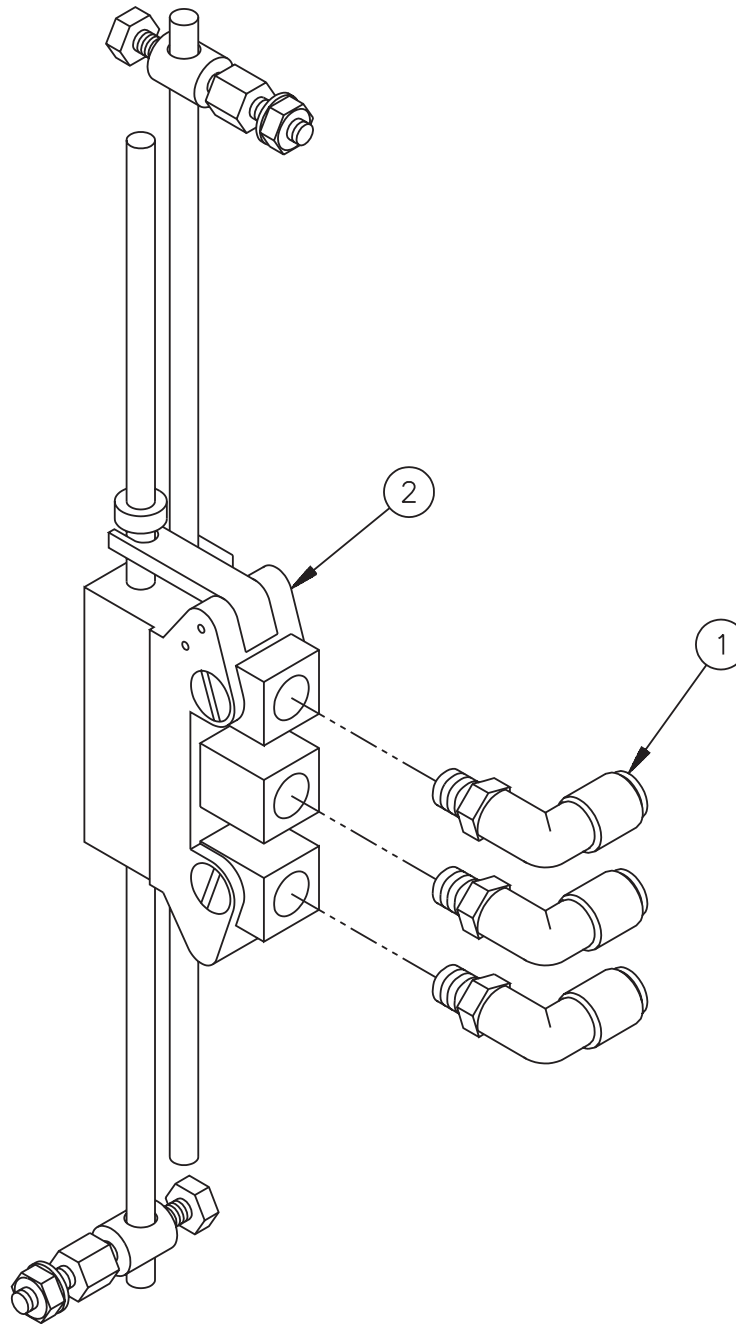
1975-400K Knee Switch

Part No.	Description	Qty	Part No.	Description	Qty.
1	AA192-6A1	1	10	SSRS98160	1
2	AA192-6A2	1	11	NNH10-32	1
3	AA192-6A3	1	12	SSHC01128	1
4	AA192-6A5	1	13	SSHC10048	2
5	273-4-407	1	14	SSZH#10064	4
6	AAVMB43	1	15	AAQMT-5-8	1
7	AAQME-5-8	2	16	WWF10	1
8	SSRS80096	2	AAC Drawing Number 190106B Rev. 3		
9	NNH6-32	2			



1975E-400A Control Box

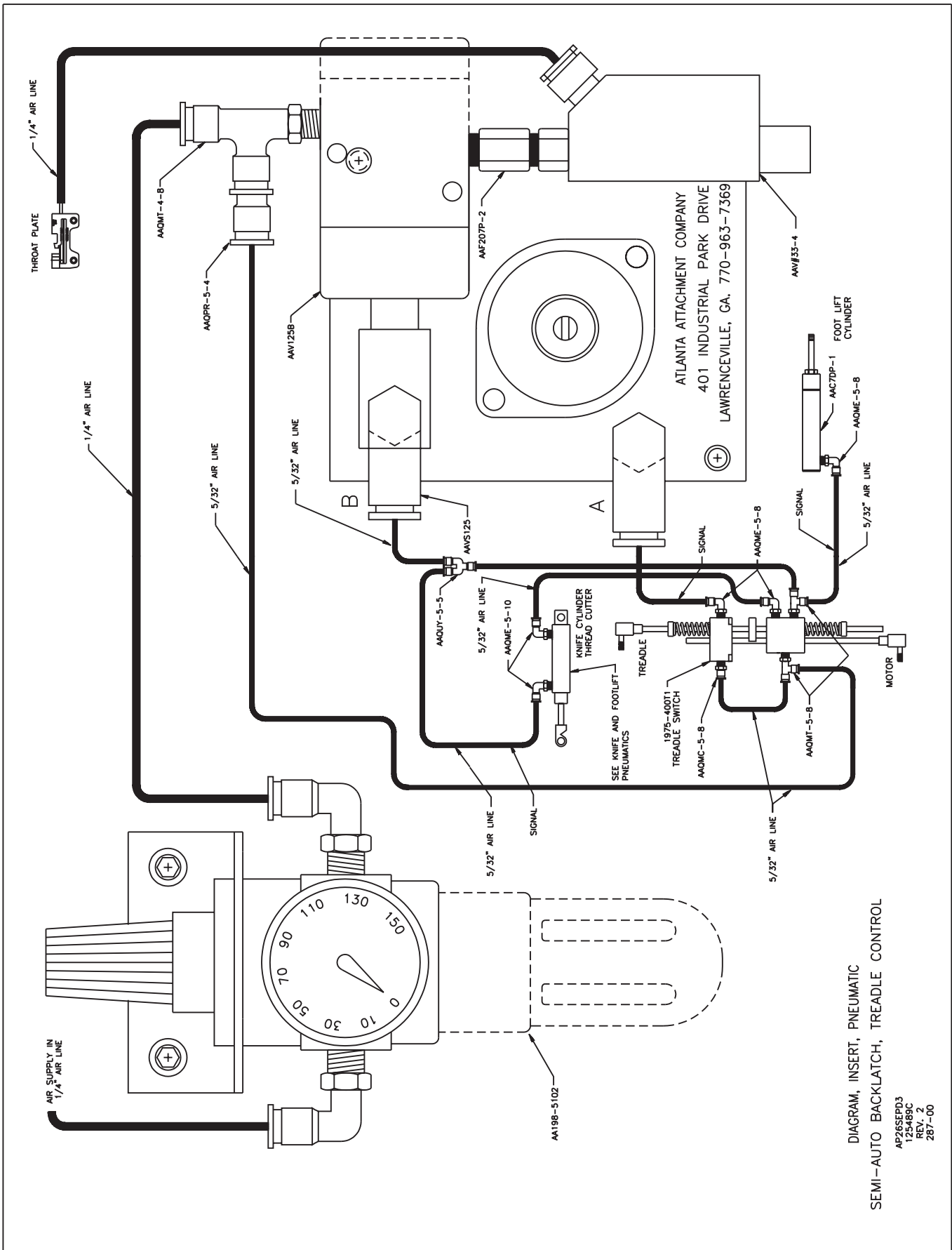
Part No.	Description	Qty	Part No.	Description	Qty.		
1	AA198-5102	Regulator w/ gauge	1	1975C-407	Label, Reg. 70-80 PSI	AR	
2	1976-408D	Backlatch	1	12	LABEL-PAT	Patent Label	AR
3	1975D-401	Control Box	1	13	MM40450010	Latch	1
4	AAQUY-5-5	Quick Union "Y"	1	14	AAQPR-5-4	Quick Reducer	1
5	AP26SEPD2	Pneumatic Diagram	AR	15	MMSLD-ECH	Rubber Bumper	2
6	SSPS90024	Screw, Pan Hd, Slotted	3	16	EESB-375-4	Heyco Bushing 1/4"	1
7	SSPS90064	Screw, Pan Hd, Slotted	2	17	EESB-375-3	Heyco Bushing 3/16"	6
8	WWF8	Flat Washer	5	18	1275C-411	Support	1
9	WWSI8	Washer, Int Star	5	AAC Drawing Number 191786C Rev. 8			
10	1975C-405A	Label, Dec. Vacuum	AR				



AA192-56 Double Action Treadle Switch

Part No.	Description	Qty	Part No.	Description	Qty.
1	AAQME-5-8	3	2	AA25768	1

AAC Drawing Number 190123B Rev. 7



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