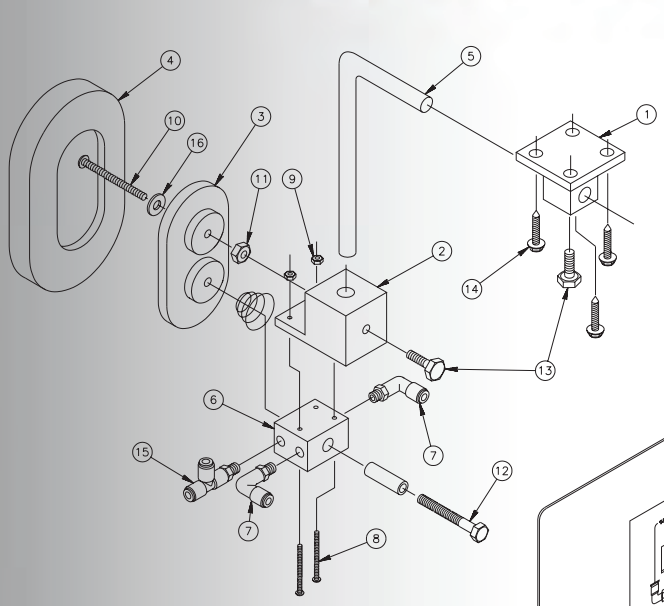
*Innovative Technology For The Sewn Products Industry World Wide*

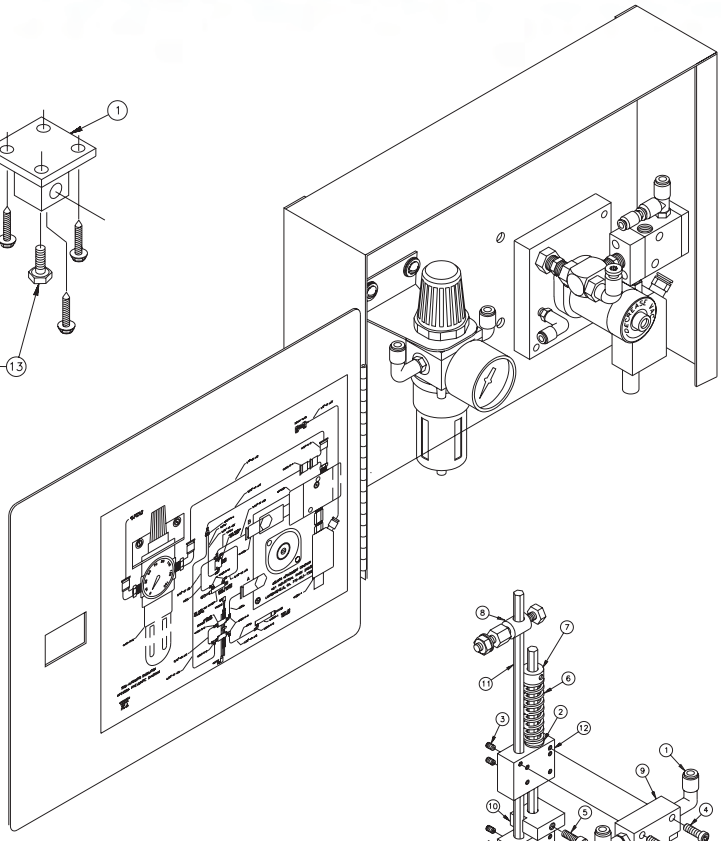
ATLANTA ATTACHMENT COMPANY

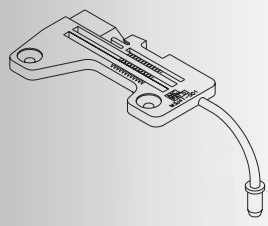
# AP26SE

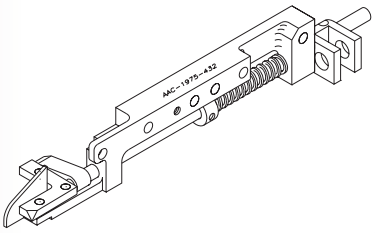
## Automatic Backlatch System

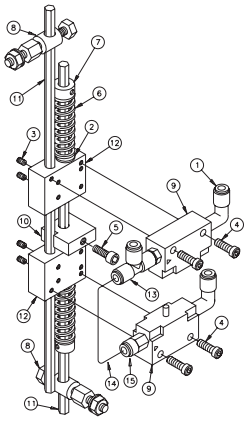
# TECHNICAL MANUAL









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**MANUAL NO. ZZAP26SE**

# SETUP INSTRUCTIONS, LIST OF PARTS AND PNEUMATIC DIAGRAMS FOR

**AAP26SE**

**Semi Automatic Backlatch**

**Last Updated 6-20-2002**

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**ATLANTA ATTACHMENT CO., INC.**

**LAWRENCEVILLE, GEORGIA**

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**PRINTED IN U.S.A.**

**MANUAL NO. ZZAP26SE**

# INSTRUCCIONES DE INSTALACIÓN LISTA DE PARTES, Y DIAGRAMA NEUMÁTICO PARA LA

**AAP26SE**

**Remate Semiautomático**

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**IMPRESO EN LOS EE.UU.**

**This equipment is protected by one or more of the following patents:**

US patents:4,038,933; 4,280,421; 4,432,294; 4,466,367; 4,644,883; 4,886,005; 5,134,947; 5,159,889; 5,203,270; 5,307,750; 5,373,798; 5,437,238; 5,522,332; 5,524,563; 5,562,060; 5,634,418; 5,647,293; 5,657,711; 5,743,202; 5,865,135; 5,899,159; 5,915,319; 5,918,560; 5,924,376; 5,979,345, 6,035,794
Foreign patents - 2,084,055; 2,076,379; 2,177,389; 2,210,569; 4-504,742; 8-511,916; 9-520,472; 0,537,323; 92,905,522.6; 95,935,082.8; 96,936,922.2.

**Este equipo es fabricado bajo una o más de las patentes siguientes:**

En EE.UU; .4,038,933; 4,280,421; 4,432,294; 4,466,367; 4,644,883; 4,886,005; 5,134,947; 5,159,889; 5,203,270; 5,307,750; 5,373,798; 5,437,238; 5,522,332; 5,524,563; 5,562,060; 5,634,418; 5,647,293; 5,657,711; 5,743,202; 5,865,135; 5,899,159; 5,915,319; 5,918,560; 5,924,376; 5,979,345, 6,035,794
Patentes en el extranjero - 2,084,055; 2,076,379; 2,177,389; 2,210,569; 4-504,742; 8-511,916; 9-520,472; 0,537,323; 92,905,522.6; 95,935,082.8; 96,936,922.2.

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## !CAUTION!

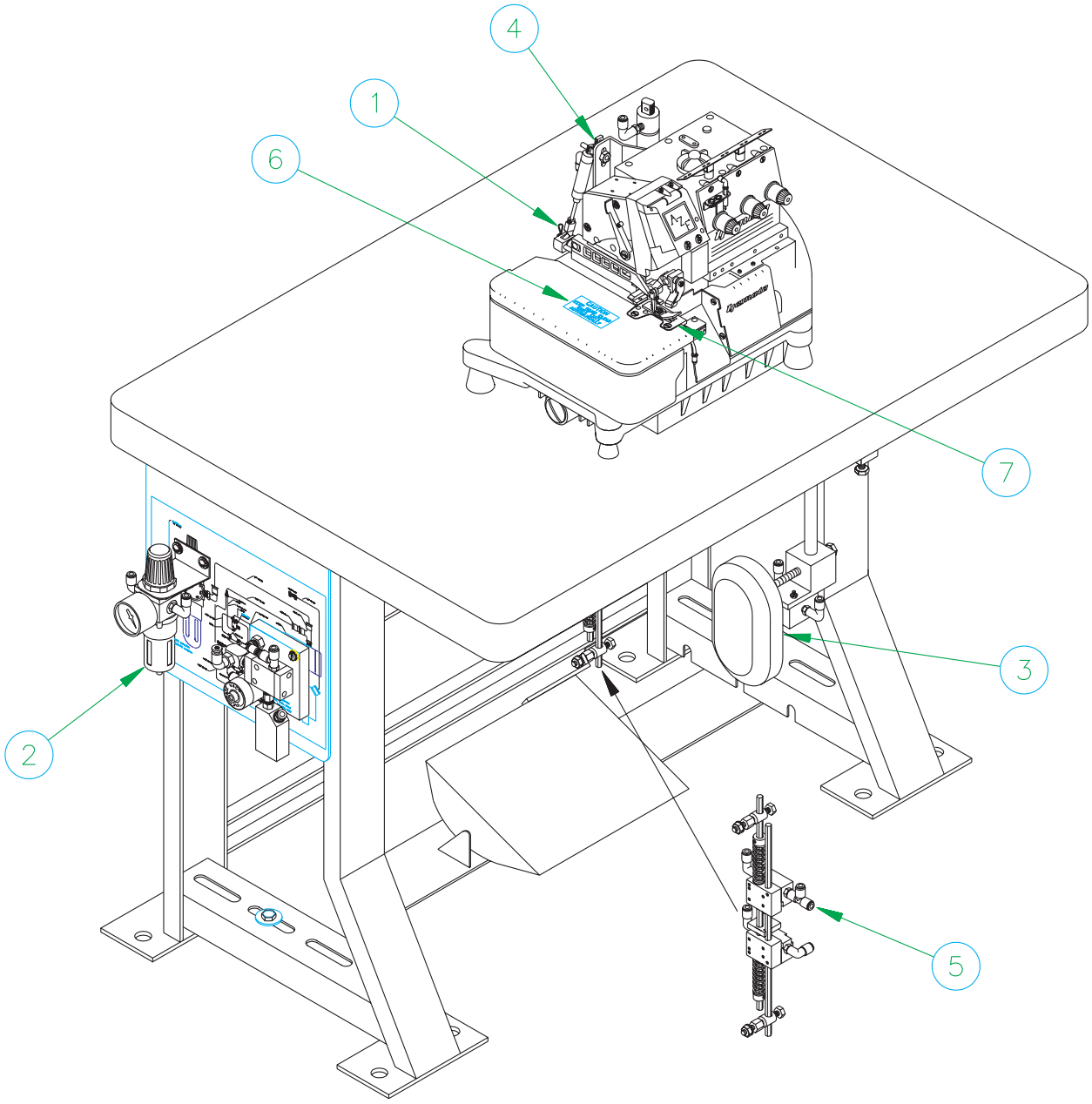
**There is a chain cutting knife located behind the presser foot. This knife is operated remotely by a electric Eye or a Push Button. DO NOT put fingers or hands in or around this knife.**

**All sewing adjustments to the sewing machine head should be made with the power "OFF".**

## ¡PRECAUCIÓN!

**Hay una cuchilla para cortar la cadeneta situada detrás del pieprensatelas. Esta cuchilla es accionada por un Ojo Fotoeléctrico o un botón de hundir. No ponga los dedos o las manos en o alrededor de esta cuchilla.**

**Todos los ajustes a la cabeza de la máquina de coser deben hacerse con la electricidad "APAGADA".**




# AAP26SE Major Components

| | Part No. | Description | Qty. | Pg. | | Part No. | Description | Qty. | Pg. |
|---|---|---|---|---|---|---|---|---|---|
| 1 | 1975-400* | Cutter Assembly | 1 | 2-6 | 7 | | Throat Plate & Parts | 1 | 2-8 |
| 2 | 1975E-400A | Panel Assembly. | 1 | 1-6 | 8 | SSZH#10064 | Scr, Hx Sh Mtl #10x1 | 4 | Δ1 |
| 3 | 1975-400K | **Knee Switch | 1 | 1-8 | 9 | AATP4-1 | 1/4" Airline | 10ft | Δ1 |
| 4 | 1975-400* | Cutter & Footlift Parts | 1 | 2-7 | 10 | AATP5/32 | 5/32 Airline | 20ft | Δ1 |
| 5 | AA192-56 | **Treadle Switch | 1 | 1-9 | Δ1 = Not Shown | | | | |
| 6 | AT-LABEL-1 | Caution Label | 1 | | | | | | |

* = Last character denotes machine head type. See Section II for complete number.
** = Cut can be accomplished on heel back. Delete Knee Switch and use appropriate Treadle Switch.

# 1975E-400A Control Panel

There must be an independent air supply to the Control Panel (no tees or splices) from a main line. This line should be able to maintain 4 CFM of air at 80 PSI. If the Backlatch is not operating correctly:

(A) Turn off the air supply.

(B) Disconnect air line from the throat plate at the vacuum valve.

(C) Clean any thread or trash from inside the vacuum generator.

(D) Check all fittings and air lines for tightness and air leaks.

(E) Check Throat Plate for holes in the tube or burrs on the chaining finger.

# Panel De Control 1975E-400A

Tiene que haber un surtidor independiente de presión de aire desde una linea principal al panel de Control (no “T” o empalmes). Esta línea debe poder mantener 4 Pies Cúbicos por Minuto (CFM) de presión de aire a 80 PSI. Si el Remate Automático no está operando correctamente:

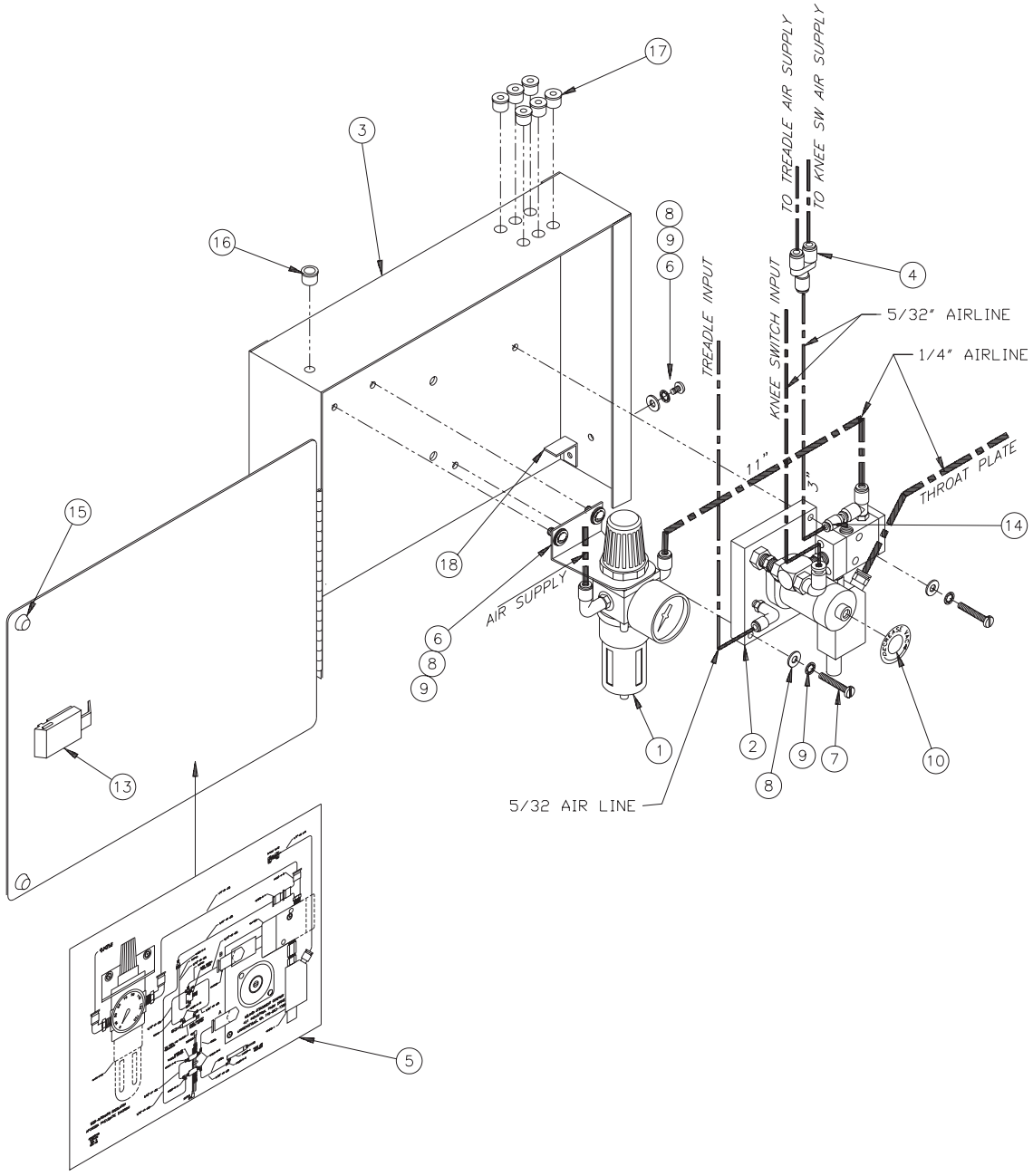
(A) Apague la presión de aire.

(B) Desconecte la manguera de presión de aire de la plancha de la aguja a la válvula de succión.

(C) Limpie cualquier hilo o basura de dentro del generador de vacío.

(D) Verifique que todos los accesorios y las mangueras esten bien apretados y chequee por escapes de aire.

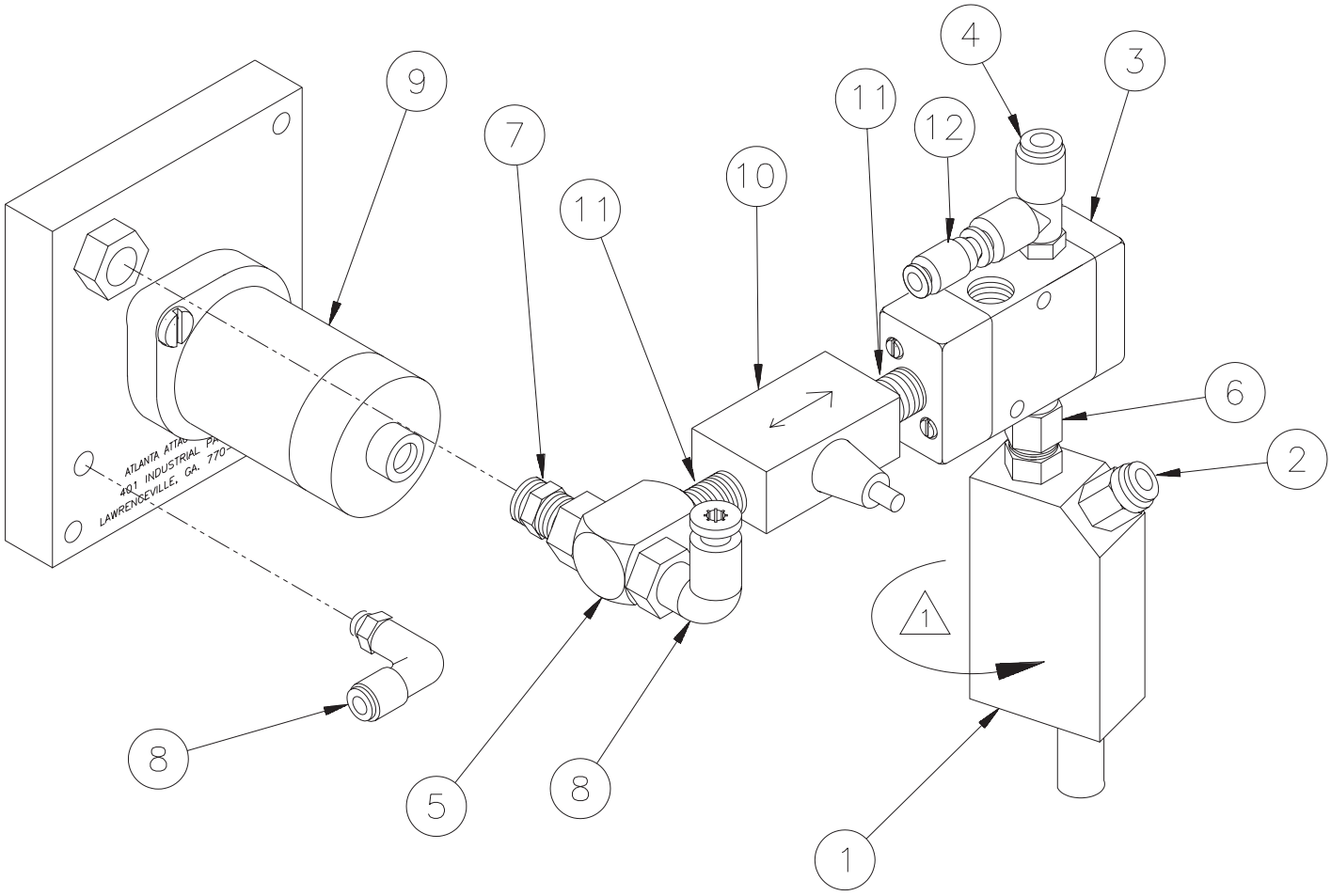
(E) Chequee por orificios en el tubo de la Plancha de la Aguja y por esquirlas en el dedo de encadenado.




# 1975E-400A Control Panel

| | Part No. | Description | Qty. | Pg. |
|---|---|---|---|---|
| 1 | AA198-5102 | Reg. w/ gauge & nut | 1 | |
| 2 | 1976-408D | Backlatch Acrylic SubA. | 1 | 1-7 |
| 3 | 1975D-401 | Control Box | 1 | |
| 4 | AAQUY-5-5 | Quick Union Y | 1 | |
| 5 | AAP26SEPD2 | Pneumatic Diagram | AR | 1-12 |
| 6 | SSPS90024 | Scr, Pn Sl 8-32x3/8 | 3 | |
| 7 | SSPS90064 | Scr, Pn Sl.8-32x1 | 2 | |
| 8 | WWF8 | Flat Washer | 5 | |
| 9 | WWSI8 | Internal Star Washer | 5 | |
| 10 | 1975C-405A | Label, Decrease Vaccum. | AR | |
| 11 | 1975C-407 | Reg. Label | AR | Δ1 |
| 12 | LABEL-PAT | Patent Label | AR | Δ1 |
| 13 | MM40450010 | Latch | 1 | |
| 14 | AAQPR-5-4 | Quick Reducer | 1 | |
| 15 | MMSLD-ECH | Rubber Bumper | 2 | |
| 16 | EESB-375-4 | Heyco Bushing ¼” | 1 | |
| 17 | EESB-375-3 | Heyco Bushing 3/16” | 6 | |
| 18 | 1275C-411 | Support | 1 | |

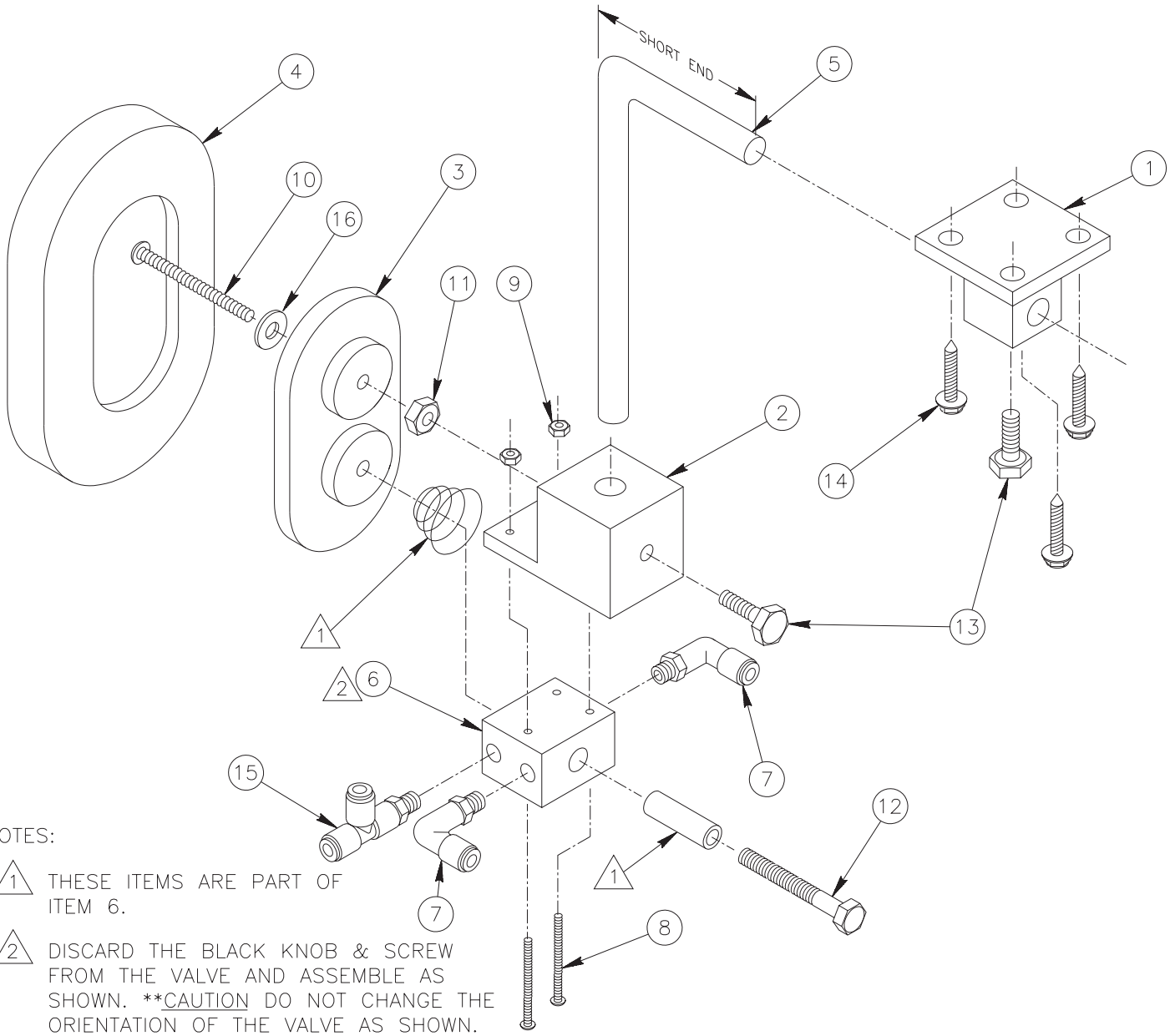
AAC Drawing Number = 191786C Rev. 8




# 1976-408D Backlatch Acrylic Sub Assembly

| | Part No. | Description | Qty. | Pg. |
|---|---|---|---|---|
| 1 | AAV#33-4 | Vaccum Generator | 1 | |
| 2 | AAQMC-4-8 | Quick Male Connect | AR | |
| 3 | AAV125B | Pilot Valve | AR | |
| 4 | AQMT-4-8 | Quick MAle T | AR | |
| 5 | AAVS125 | Shuttle Valve | AR | |
| 6 | AAQPR-5-4 | 5/32 1/4 Reducer | AR | |
| 7 | AAF122A-A | Hex Close Nipple | AR | |
| 8 | AAQME-5-8 | Quick Male Elbow | AR | |
| 9 | AAVR333 | Delay In Timer Valve | AR | |
| 10 | AAF207P-2 | Coupling, 1/8 | AR | |
| 11 | 273-4-504 | Colse Nipple | AR | |
| 12 | AAQPR-5-4 | Reducer | AR | |

AAC Drawing Number = 190403A Rev. 4



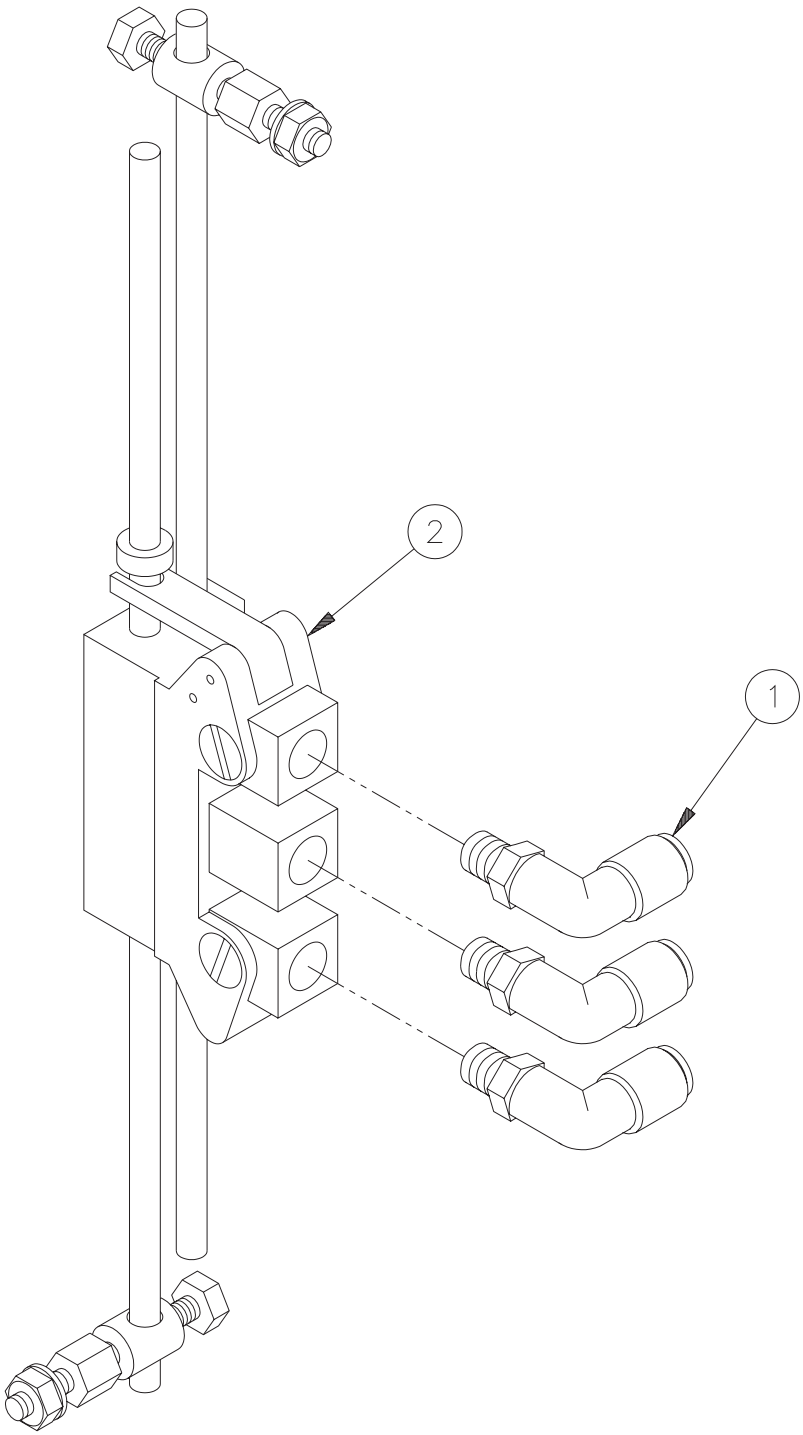

NOTES:

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. | Pg. |
|---|---|---|---|---|
| 1 | AA192-6A1 | Machine Mount | 1 | |
| 2 | AA192-6A2 | Switch Mount | 1 | |
| 3 | AA192-6A3 | Activator | 1 | |
| 4 | AA192-6A5 | Rubber Pad | 1 | |
| 5 | 273-4-407 | Bent Rod | 1 | |
| 6 | AAVMB43 | Valve | 1 | |
| 7 | AAQME-5-8 | Quick Male Elbow | 2 | |
| 8 | SSRS80096 | Scr,Rd,Slot, 6-32x1 1/2 | 2 | |
| 9 | NNH6-32 | Nut, Hex, 6-32 | 2 | |
| 10 | SSRS98160 | Scr,Rd,Slot, 10-32x2 1/2 | 1 | |
| 11 | NNH10-32 | Nut, Hex, 10-32 | 1 | |
| 12 | SSHC01128 | Scr,Hex Cap, 1/4-20 x 2 | 1 | |
| 13 | SSHC10048 | Scr,Hex Cap, 5/16-18 x 3/4 | 2 | |
| 14 | SSZH#10064 | Scr,Pan Sht Met, #10 x 1 | 4 | |
| 15 | AAQMT-5-8 | Male Run Tee | 1 | |
| 16 | WWF10 | Washer, Flat, #10 | 1 | |

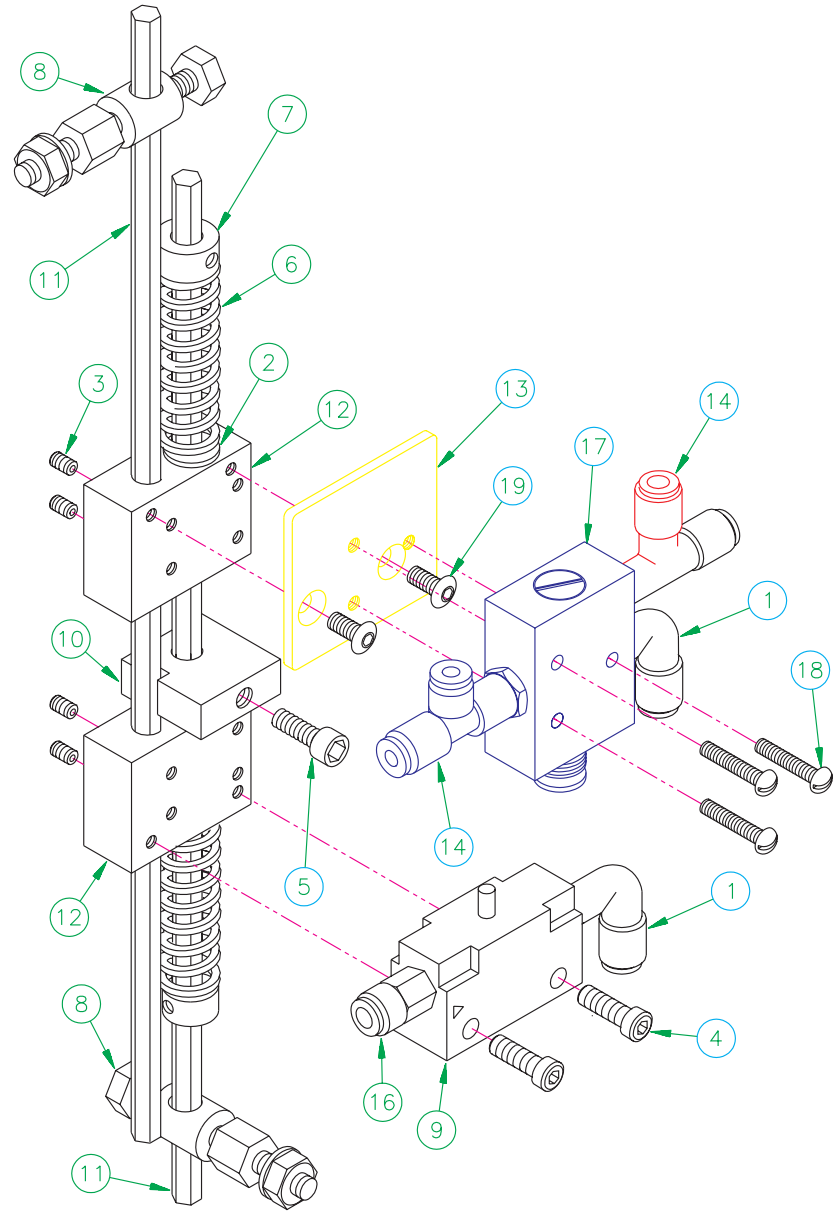
AAC Drawing Number = 190106B Rev. 2




# AA192-56 Double Action Treadle Switch

| | Part No. | Description | Qty. | Pg. | | Part No. | Description | Qty. | Pg. |
|---|---|---|---|---|---|---|---|---|---|
| 1 | AAQME-5-8 | Quick Male Elbow | 3 | | 2 | AA25768 | Treadle | 1 | |

AAC Drawing Number = 190123B Rev. 7




NOTES:

⚠1 NOT SHOWN.

# 1975-400T1 Treadle Switch, Double Action

| | Part No. | Description | Qty. Pg. | | Part No. | Description | Qty. Pg. |
|---|---|---|---|---|---|---|---|
| 1 | AAQME-5-8 | Quick Male Elbow | 2 | 11 | AA192-552 | Treadle Rod | 1 |
| 2 | WWF5/16S | Washer SAE No. 5/16 | 2 | 12 | AA192-554 | Mount Block | 2 |
| 3 | SSSS90012 | Scr,So St 8-32x3/16 | 4 | 13 | AA192-555 | Bracket Valve | 1 |
| 4 | SSSC90064 | Scr,So Cp 8-32x1 | 2 | 14 | AAQMT-5-8 | Quick Male Tee | 2 |
| 5 | SSSC01064 | Scr,So Cp 1/4-20x1 | 1 | 15 | AATP5/32 | Airline, 5/32 | .37’ |
| 6 | RRLC026E12 | Spring | 2 | 16 | AAQMC-5-8 | Quick Male Conn | 1 |
| 7 | CCSC9/32 | 9/32 ID Set Collar | 2 | 17 | AAV41-P | Air Valve | 1 |
| 8 | AA192-7DC1 | Rod End | 2 | 18 | SSPS80048 | Scr. Pn Hd Sl 332x3/4 | 3 |
| 9 | AAVNVM130 | Air Valve | 2 | 19 | SSFC90024 | Scr. Fl Al Cp 3-32x3/8 | 2 |
| 10 | AA192-591 | Activator Bracket | 1 | AAC Drawing Number = 192007B Rev. 1 | | | |

# AAP26SE Sew Off

1. Heel the treadle to lift the foot.

2. Insert the garment under the presser foot as close to the needle as possible.

3. Release and depress the sew treadle.
   A. Vacuum comes on.
   B. Stitching begins.
   C. Vacuum shuts off. The time interval of the vacuum "on" is only long enough to capture the stitch chain and sew past the vacuum tube at the rear of the throat plate. To change this time interval, rotate screw on timing valve as indicated.

4. As sewing is complete, release the treadle and gently pull the chain to the rear and actuate the chain cutting knife by depressing the knee switch, or heel back to cut if the heel back to cut option was selected. The stitch chain must be completely pulled off the stitch tongue.

5. The knee switch or optional heel switch will operate the chain cutting knife and open the vacuum to the chaining tongue for a predetermined amount of time.

6. Ideally the chain will be drawn into the tube by the vacuum from the cut signal.

7. Another garment can now be sewn. Placement of the garment to the edge trimming knife and needle position are of little concern.

# Para Coser Con La AAP26SE

1. Taconee el pedal para levantar el prensatelas.

2. Inserte la prenda debajo del prensatelas tan cerca de la aguja como sea posible.

3. Suelte y hunda el pedal para coser.
   A. La succión se enciende.
   B. La costura comienza.
   C. La succión se apaga. El tiempo que la succión se enciende es sólo suficiente para capturar la cadeneta y coser más allá del tubo de succión en la parte posterior de la plancha de la aguja. Para cambiar este intervalo de tiempo, rote el tornillo en la válvula de tiempo como es indicado.

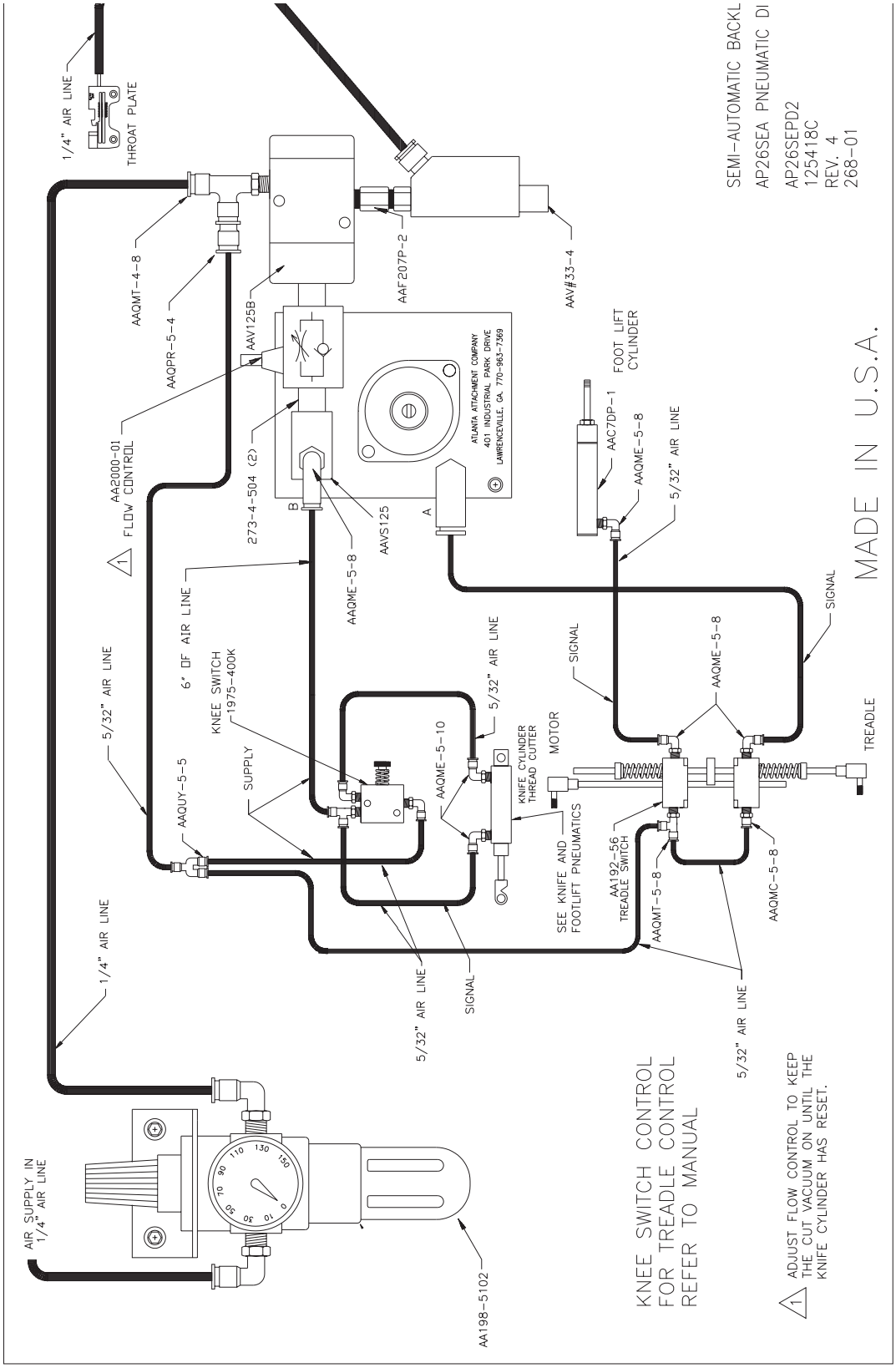
4. Al terminar la costura, suelte el pedal y suavemente tire de la cadeneta hacia atrás y active el cortacadeneta con el interruptor de rodilla, o taconee para cortar si se escogió la opción de cortar con el tacón. La cadeneta tiene que ser completamente halada de la lengua de la puntada.

5. El interruptor de rodilla o el interruptor opcional del talón operará el cortacadeneta y encenderá la succión a la lengua de encadenado por un tiempo predeterminado.

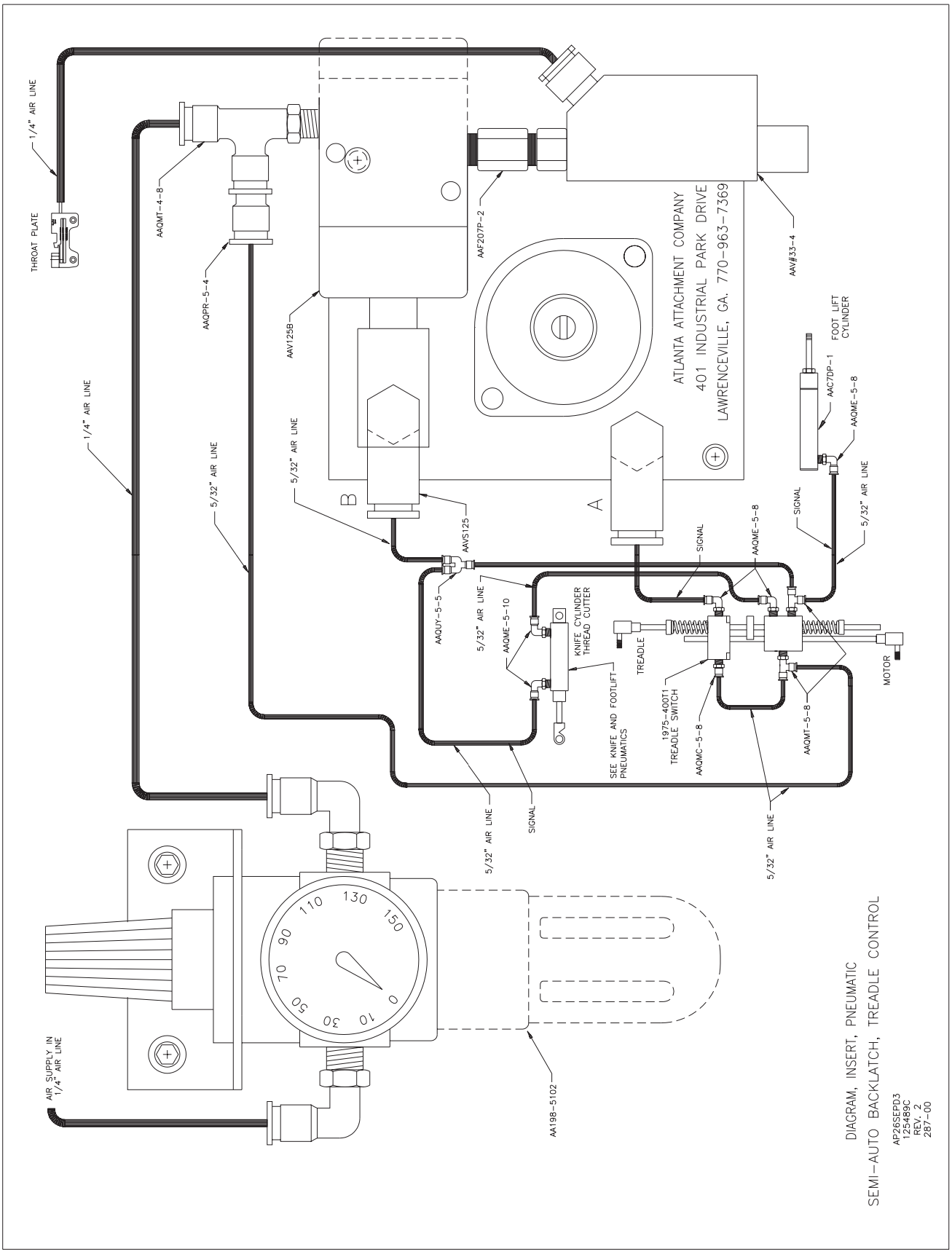
6. La cadena debe introducirse dentro del tubo de succión a la señal de corte.

7. Otra prenda puede ser cosida ahora. La colocación de la prenda hasta la recortadora de borde y la posición de la aguja no son importantes.

# AP26SEPD2 Pneumatic Diagram



# AP26SEPD3 Pneumatic Diagram



# Notes

# SECTION II

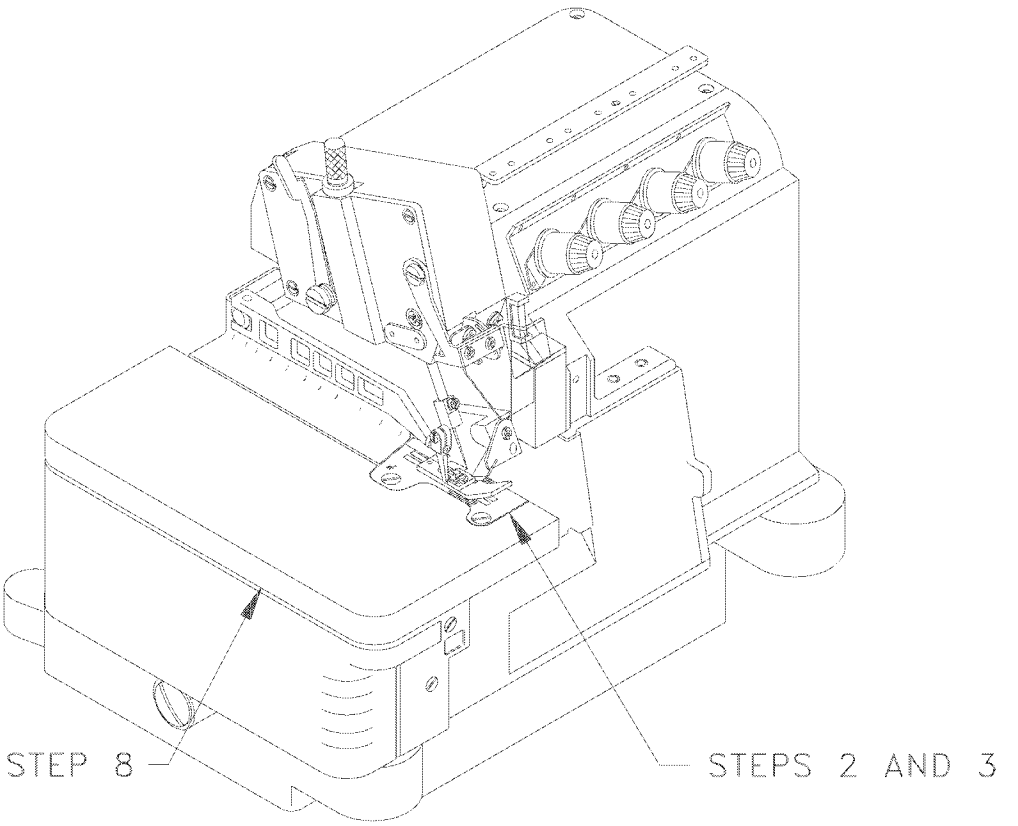
# AAP26SEG24, AAP26SEG27 & AAP26SEG29

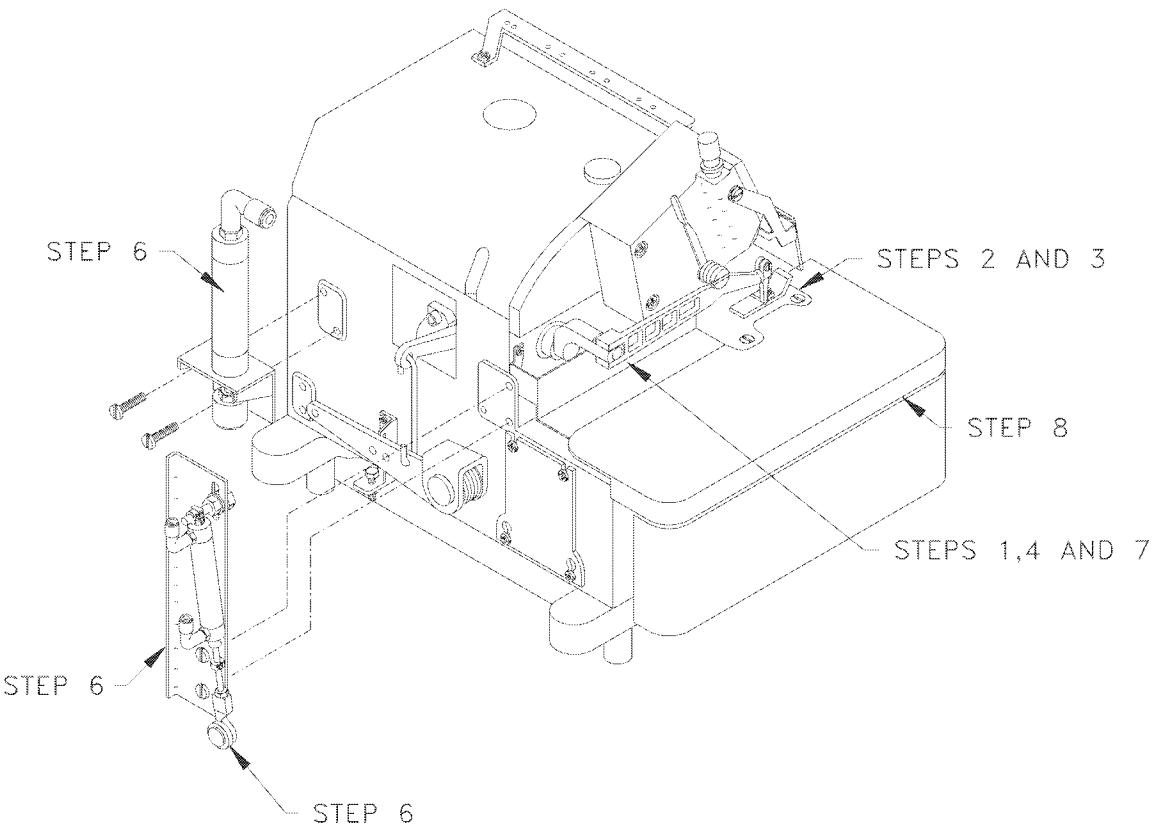
## INSTALLATION INSTRUCTIONS FOR

## 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


STEP 8
STEPS 2 AND 3


STEP 6
STEPS 2 AND 3
STEP 8
STEPS 1,4 AND 7
STEP 6
STEP 6

# 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

1. Quite la guarda del material. Use los tornillos para montar el bloque espaciador de la Cortadora.
2. Quite la plancha de la aguja.
3. 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)
4. Instale el ensamblado de la Cortadora (1975-400M) en el bloque.
5. 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.
6. Monte el cilindro del alzaprensatelas 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 movible 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 movible debe no entrar en contacto con el cuerpo de la Cortadora.
7. Instale la guía de material en el cuerpo de la Cortadora.
8. 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.]

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.]

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.

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 comodiada 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.

11. Mount the Control Panel Assembly to the table top using the screws provided.

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

12. Attach the air lines according to the pneumatic diagram.

Conecte las mangueras según el diagrama neumático.

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.

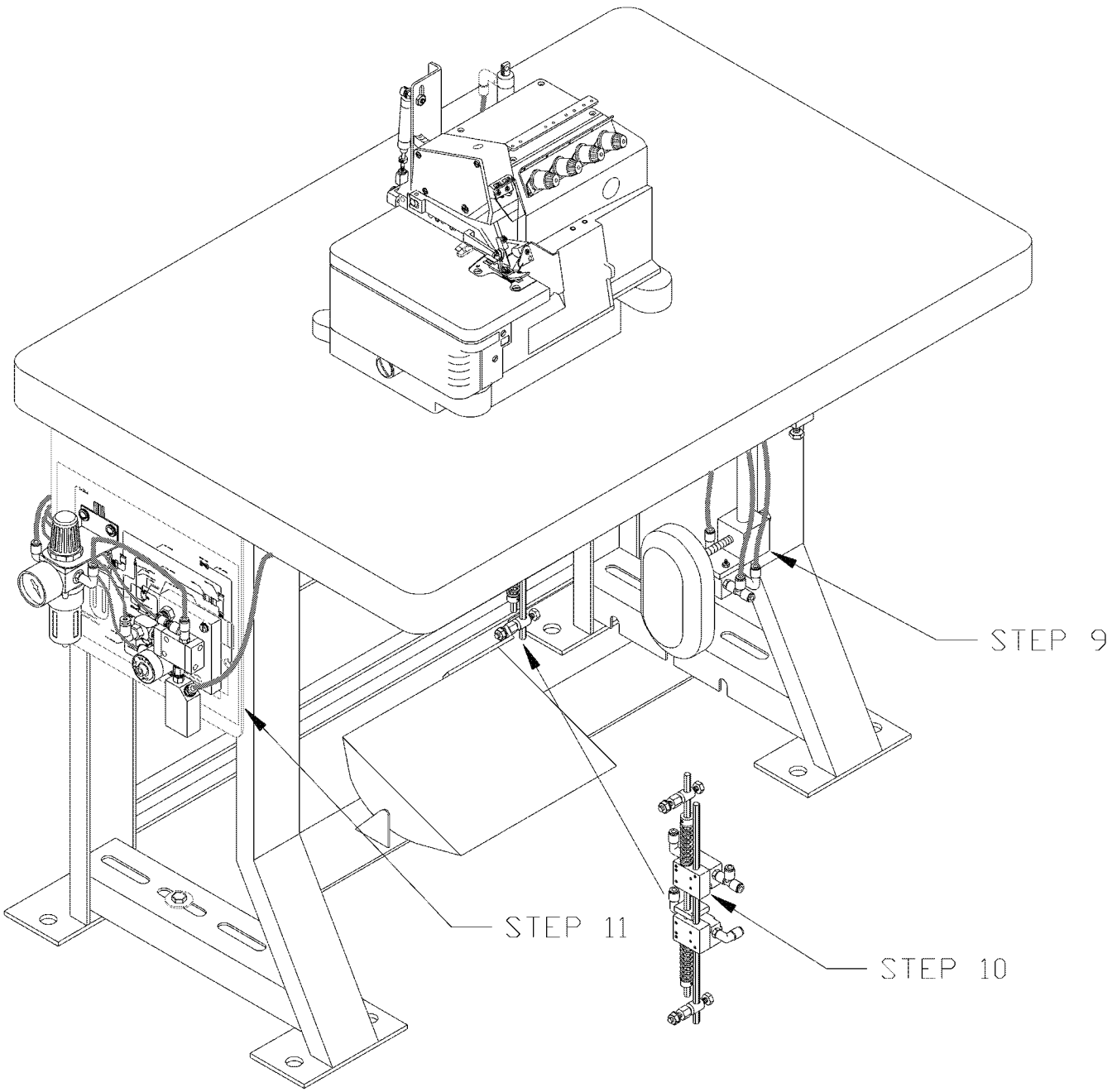
La unidad está ahora instalada en la máquina y lista para coser. Las instrucciones para coser las encontrará en la sección 1 del manual.

## IMPORTANT NOTES

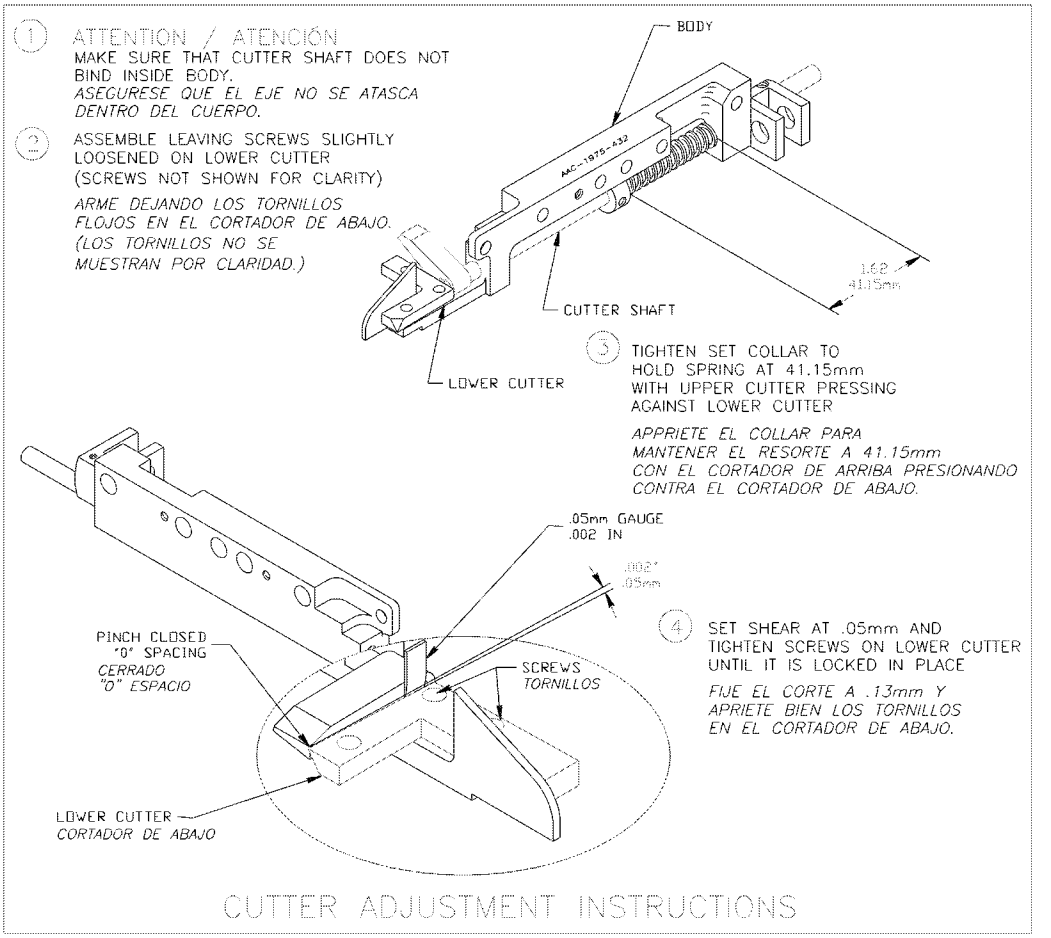
**The needle height setting will be 1/16" less than the book setting because of the thicker throat plate. Make sure the lower looper does not contact the throat plate. If it does, install the throat plate spacer provided.**

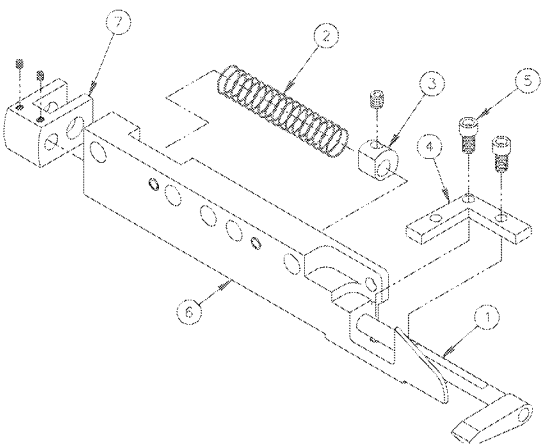
## NOTAS IMPORTANTES

**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.)**



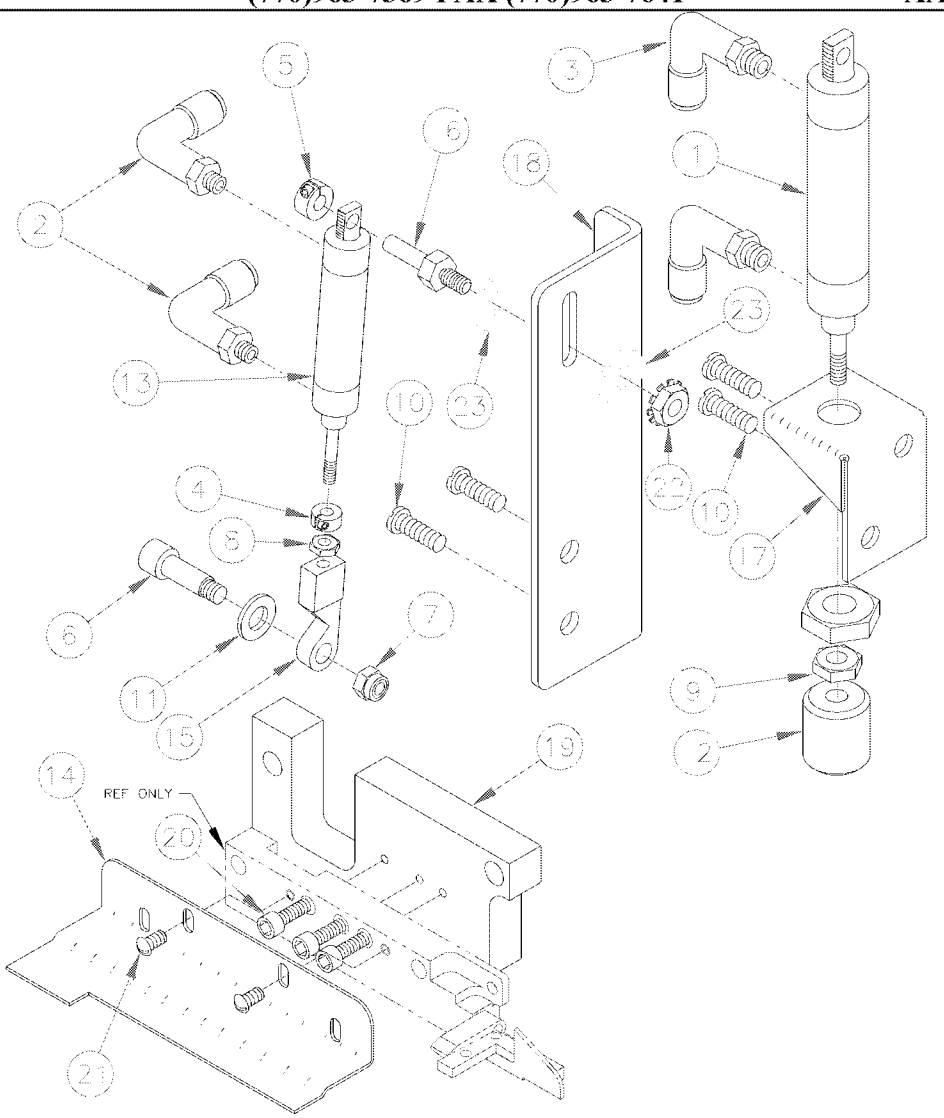

AAP26SE



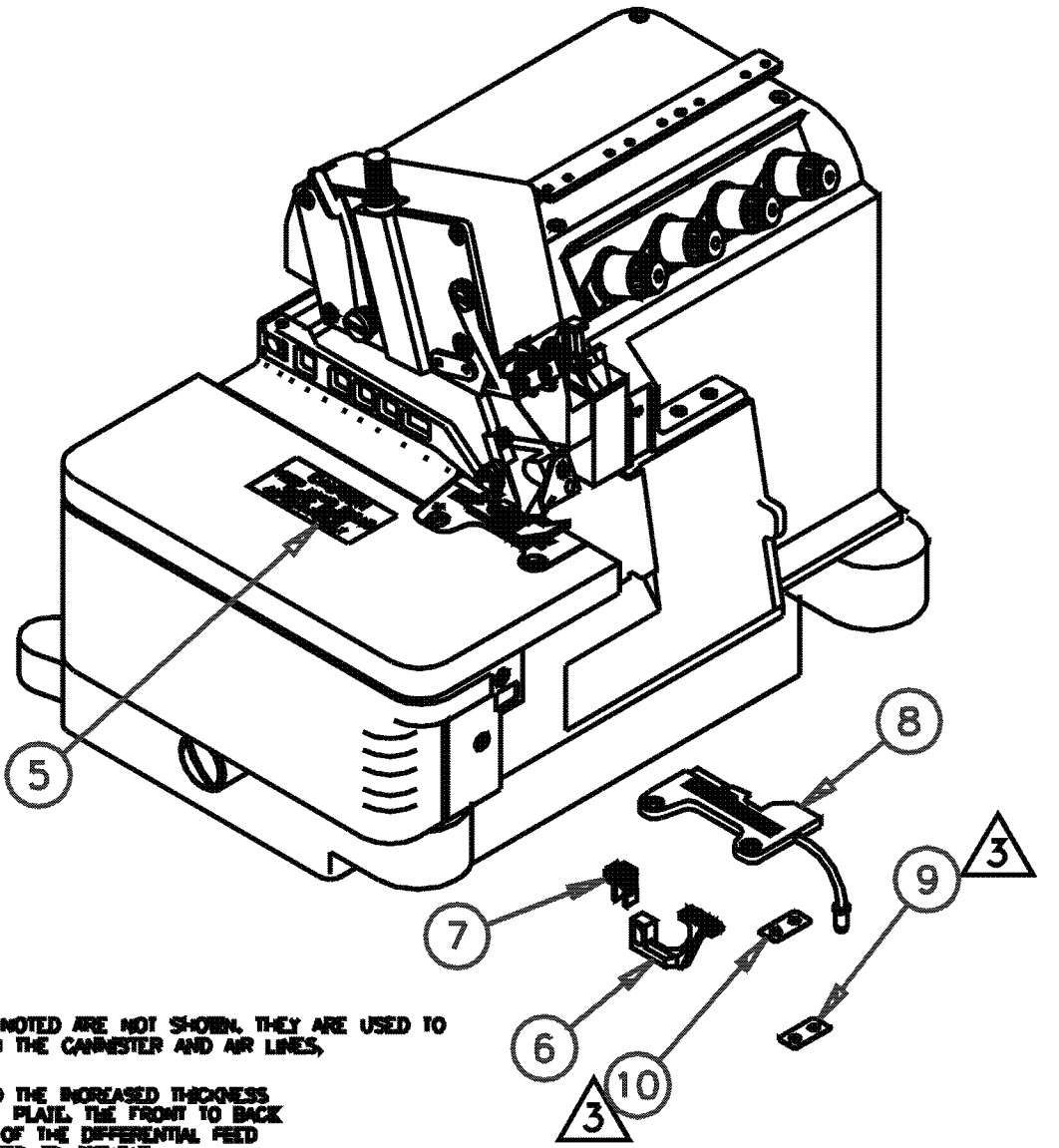

# 1975-400MG Cutter Assembly

| | 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 | | | | |
| 4 | 1976-024 | Lower Cutter | 1 | | may be rotated 1 time. | | | | |
| 5 | SSSC70016 | Scr,Soc Cap 4-40x.25 | 2 | | AAC Drawing Number = 190330C Rev.8 | | | | |




# 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 | | | | |



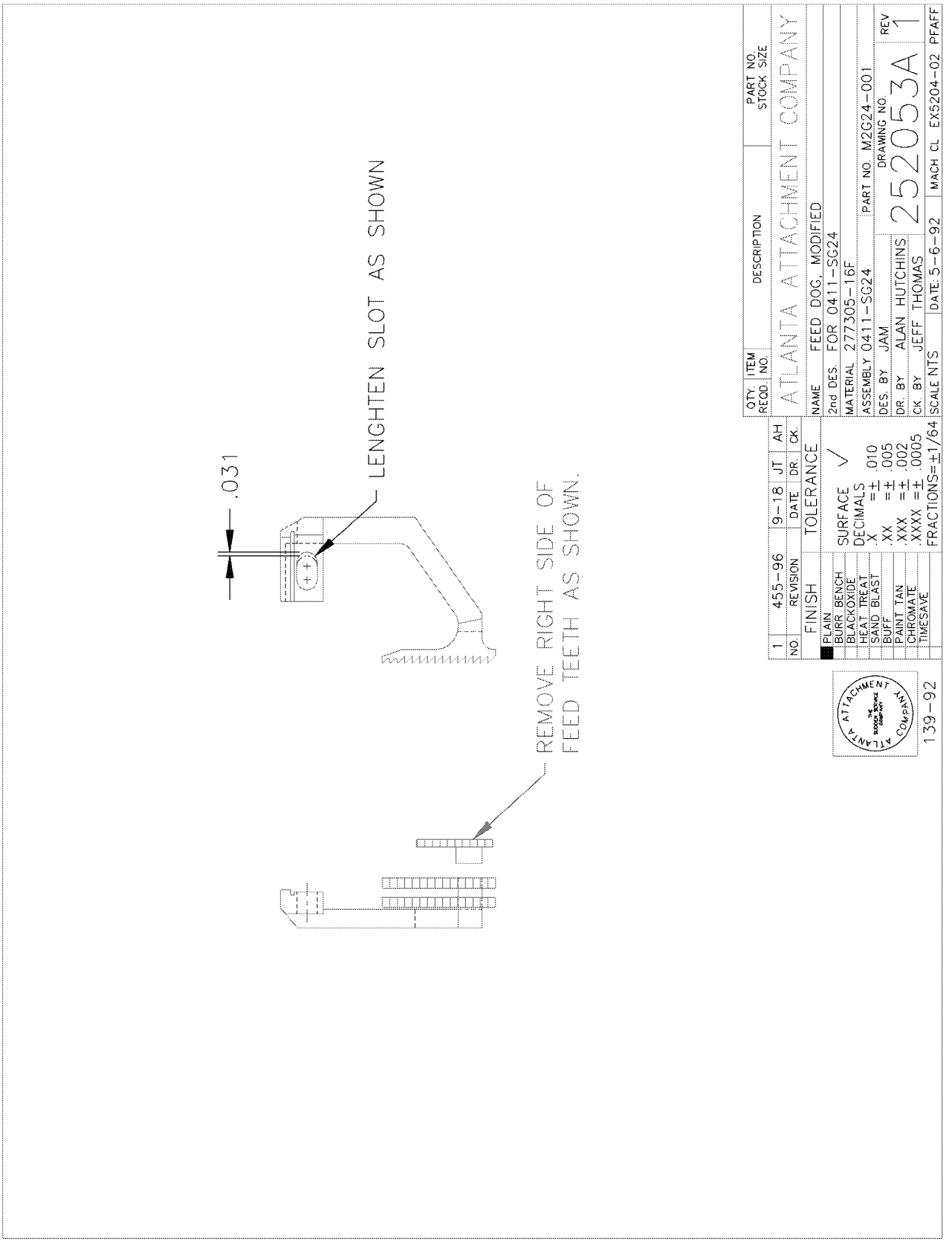

NOTES:

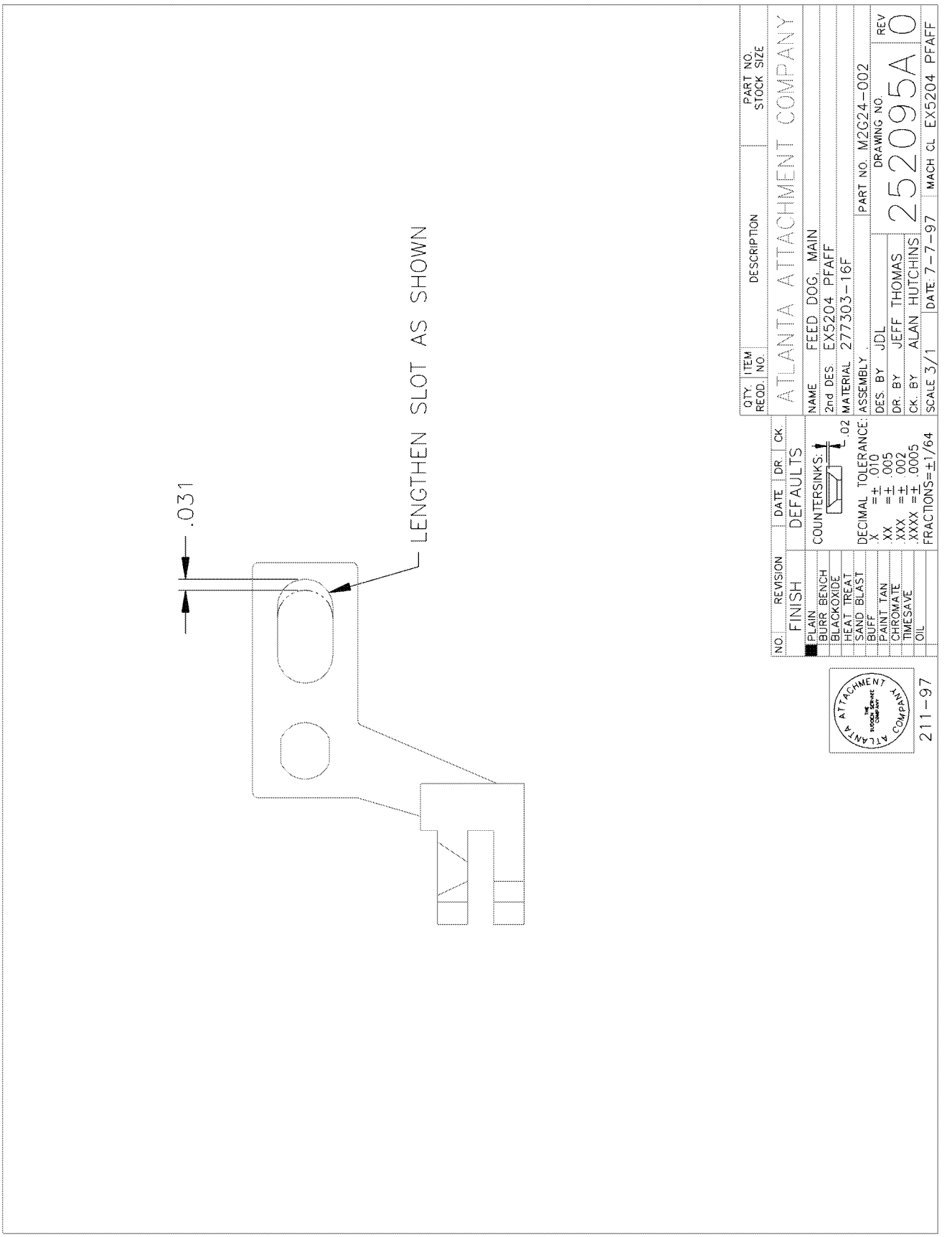
1. ITEMS NOTED ARE NOT SHOWN. THEY ARE USED TO ATTACH THE CANNISTER AND AIR LINES.
2. DUE TO THE INCREASED THICKNESS OF THE PLATE, THE FRONT TO BACK ANGLE OF THE DIFFERENTIAL FEED MAY NEED ADJUSTMENT
3. INSTALL UNDER PLATE THROAT MOUNT

# 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


.031
LENGHTEN SLOT AS SHOWN
REMOVE RIGHT SIDE OF FEED TEETH AS SHOWN.
QTY. REQD.
ITEM NO.
DESCRIPTION
PART NO. STOCK SIZE
ATLANTA ATTACHMENT COMPANY
NAME FEED DOG, MODIFIED
2nd DES. FOR 0411-SG24
MATERIAL 277305-16F
ASSEMBLY 0411-SG24
PART NO. M2G24-001
DES. BY JAM
DRAWING NO.
REV
DR. BY ALAN HUTCHINS
25053A 1
CK. BY JEFF THOMAS
SCALE NTS
DATE 5-6-92
MACH CL EX5204-02 PFAFF
1 455-96 9-18 JT AH
NO. REVISION DATE DR. CK.
FINISH
PLAIN
BURR BENCH
BLACKOXIDE
HEAT TREAT
SAND BLAST
BUFF
PAINT TAN
CHROMATE
TIMESAVE
TOLERANCE
SURFACE √
DECIMALS
.X =± .010
.XX =± .005
.XXX =± .002
.XXXX =± .0005
FRACTIONS=±1/64
ATLANTA ATTACHMENT COMPANY
139-92


.031
LENGTHEN SLOT AS SHOWN
QTY. REQD.
ITEM NO.
DESCRIPTION
PART NO. STOCK SIZE
ATLANTA ATTACHMENT COMPANY
NAME FEED DOG, MAIN
2nd DES. EX5204 PFAFF
MATERIAL 27303-16F
ASSEMBLY
PART NO. M2G24-002
DES. BY JDL
DR. BY JEFF THOMAS
CK. BY ALAN HUTCHINS
DRAWING NO. 252095A
REV 0
SCALE 3/1
DATE: 7-7-97
MACH CL EX5204 PFAFF
NO. REVISION DATE DR. CK.
DEFAULTS
FINISH
PLAIN
BURR BENCH
BLACKOXIDE
HEAT TREAT
SAND BLAST
BUFF
PAINT TAN
CHROMATE
TIMESAVE
OIL
COUNTERSINKS:
.02
DECIMAL TOLERANCE:
X = ± .010
XX = ± .005
XXX = ± .002
XXXX = ± .0005
FRACTIONS=±1/64
ATLANTA ATTACHMENT COMPANY
211-97

# Notes

# Notes

# Notes

# Innovative Technology for the Sewn Products Industry World Wide

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