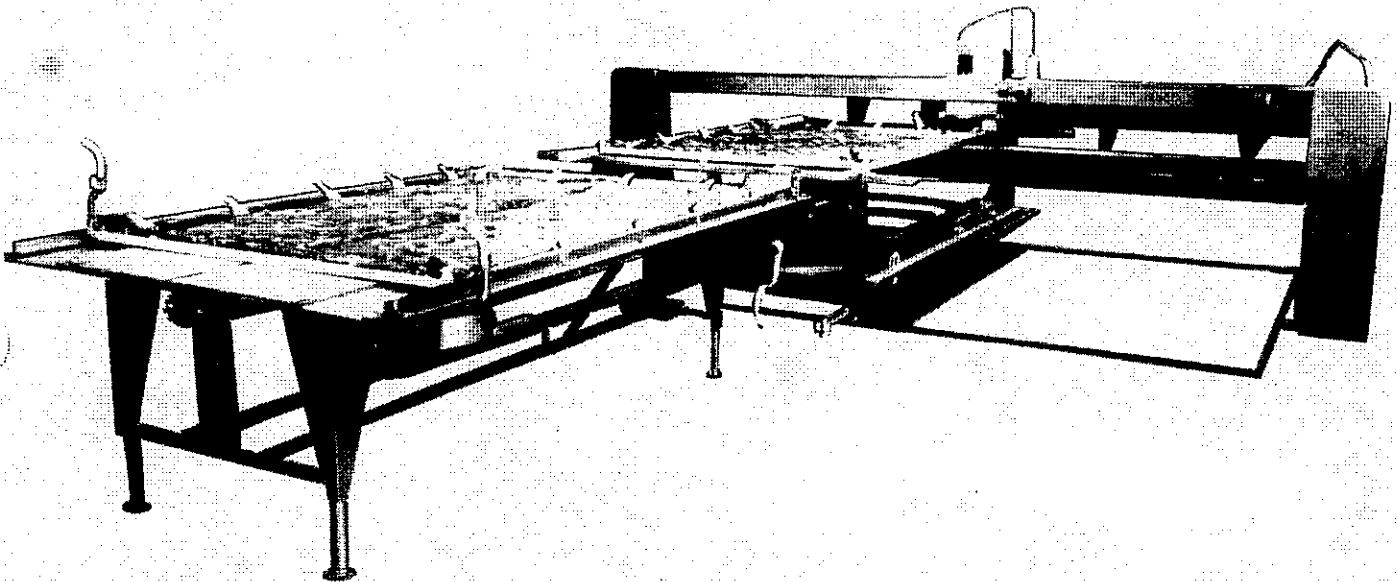




OFFICE: 5685 N. LINCOLN • CHICAGO 60659
(312) 561-6900
FACTORY: 1308 S. PULASKI • CHICAGO 60623
(312) 782-1343

PARTS CATALOG FOR ALL ABM QUILTERS



TO USE THIS CATALOG MOST EFFECTIVELY, FIRST IDENTIFY THE PART YOU WANT IN THE APPROPRIATE PICTURE. THEN USING THE IDENTIFYING NUMBER, LOCATE THE PART IN THE PARTS LIST FOR THE PICTURE YOU WERE USING.

WHEN ORDERING ALWAYS USE THE PART NUMBER AS SHOWN IN THE PARTS LIST.

IF YOU CANNOT LOCATE THE PART YOU WANT IN THIS CATALOG, THEN DESCRIBE THE PART AS CLEARLY AS YOU CAN ON YOUR ORDER. SOMETIMES AN ILLUSTRATION OF THE PART YOU WANT WILL HELP US TO IDENTIFY IT.

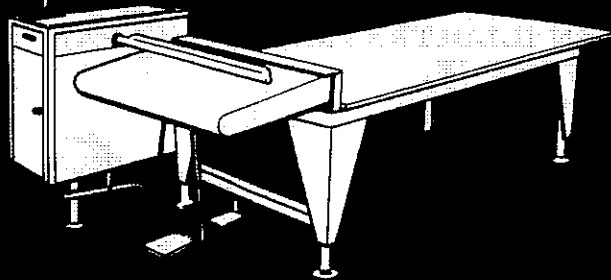
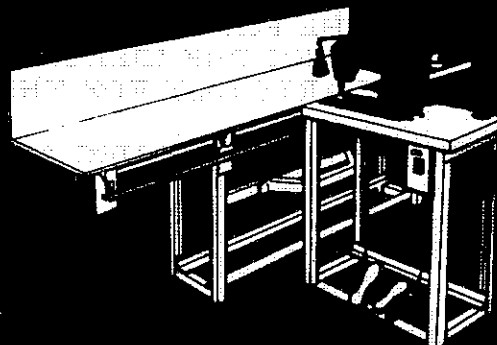
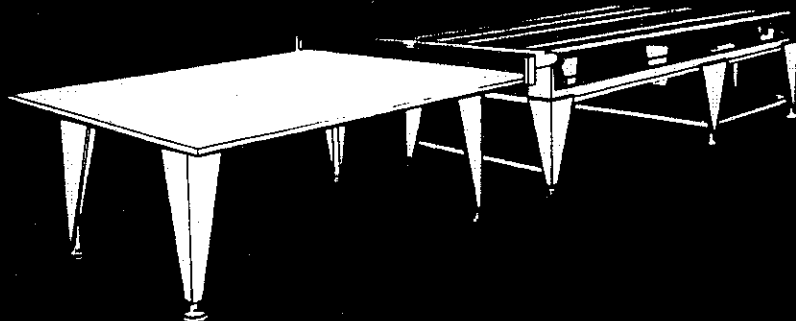
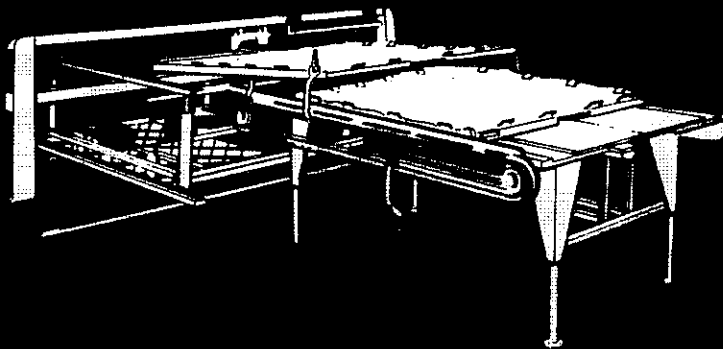
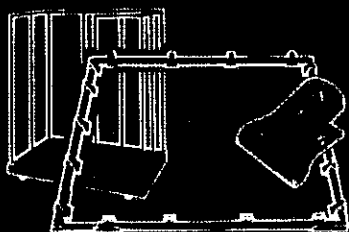


PRODUCING THE WORLD'S MOST COMPLETE LINE OF MACHINERY
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Your **ABM** Machines
Perform Best With
Genuine **ABM** Parts
Only Genuine **ABM** Parts
Are Precision Made To
Exacting **ABM**
Specifications

5106368-



SAFETY INTERLOCK MECHANISM

The following information is applicable to all ABM INDUSTRIES, INC. Quilting machines with Serial number 102676 or subsequent numbers.

Your machine has been equipped with our new Frame Lock Interlock Safety System. This system will prevent the inadvertent sewing of the quilting frame while changing frames.

NOTE! Your Quilter WILL NOT operate unless the frame is positioned onto the Quilter and the presser foot is down.

The sequence of operation is as follows:

1. The frame will trip the safety switch on the rear stop block,
2. the presser foot will come down,
3. the Quilter operation will start by pushing the START button,
4. hold the frame against the stop block until the Gear Head is off from the pattern stopper at which time the frame lock will come down to lock the frame onto the carriage.

MAINTENANCE SCHEDULE FOR ABM QUILTERS

THINGS TO DO DAILY:

1. Oil top of sewing head at two points on face plate, no more than 6 - 8 drops of oil.
2. Clean sewing head of all accumulated lint and thread.
3. Blow off pattern of thread and lint
4. Clean chain and drive shafts on automatic table and remove all lint and thread. DO NOT OIL
5. Replace needle in sewing head.
6. Blow off accumulated lint from rotary tension, oil lightly.
7. Check oil level in bottom sewing head base.
8. Oil gear trolley head to lubricate flange bushing.

THINGS TO DO EVERY TWO DAYS:

1. Clean flanges and track gear of gear trolley head (remove screws #100001).
2. Tighten screws on aluminum arms of automatic table (part # 100111).
3. Turn grease pressure cup $\frac{1}{4}$ turn on variable speed pulleys both on gear drive plate #180006 and automatic table #1800066. Make sure unit is tightly packed with grease in cup and thread onto unit no more than two turns.

THINGS TO DO ABOUT ONCE EACH WEEK:

1. Check all belts for proper tension, no more than $\frac{1}{2}$ " depression.
2. Check timing pulleys at rear of machine, make sure that set screws are tight.
3. Check main drive belt tension and adjust for approximately 1" play.
4. Tighten mounting bolts on automatic table gear box (DO NOT LUBRICATE CHAIN).
5. Tighten mounting screws on automatic table frame flaps.
6. Oil flange bushing, part #010014.
7. Oil main bushing on gear head #010013, and tighten bolts.
8. Tighten mounting bolts on flange bushing.
9. Tighten mounting bolts on drive motor.
10. Check aluminum fork #050021, fulcrum pin in position and retaining rings (2) secure.
11. Check all V belts for excessive wear.
12. Tighten carrier wheel screws, only 1 pair on each carrier. Lock nuts should be tight.
13. Replace or buff hook on sewing head and retime with new needle.
14. Check sewing head hook pump for proper oil delivery.
15. Check hook pump for end play.
16. Tighten pressure bar adjustment screw.
17. Tighten needle bar adjustment screw.
18. Check pressure cup air nozzle for proper air flow.
19. Check pattern for damaged areas or loose areas and repair or replace track.
20. Check pivot screws on Vari speed pulleys and tighten lock nuts.
21. Check thread breakage control and be sure cam is tight in position.(DON'T OVER TIGHTEN).
22. Tighten wheel bearing collars on shafts on top and bottom carriers.
23. Tighten pattern hold down clamps.

TO BE DONE ABOUT EVERY TWELVE MONTHS:

1. Replace timing belt at rear of machine.
2. Rebuild gear head by returning to ABM (total rebuilding charge \$91.00) or order necessary parts and special grease, also use permatex gasket compound to reseal cover. Complete grease change may be necessary every three months and rebuilding may be necessary every six months, check accordingly.
3. Re-grease automatic table gear box using same grease as above.

FOR FURTHER INFORMATION CALL ABM INDUSTRIES, INC.-(312) 762-1343 - 1308 S. PULASKI -CHICAGO, ILL.

SECTION I

INTRODUCTION AND DESCRIPTION

INTRODUCTION

The purpose of this manual is to make the operator familiar with the proper operation and care of the machine in order that maximum efficiency can be achieved with minimum effort.

This manual contains operation and service instructions for Automatic "Cross Stitch" Scroll Quilting Machines and accessories manufactured by ABM INDUSTRIES, INC. of Chicago, Illinois. Reference to this manual will provide the necessary information required for a proper understanding of the capabilities of the machine.

The use of a high speed Automatic Quilting machine in conjunction with accessories appropriate to the required manufacturing operation will result in production economies heretofore unobtainable. In many instances the automatic cross stitch machine will reduce the required sewing time for a given quilting pattern. In conjunction with this, it is possible to reduce the number of operators that would ordinarily be required to perform a given workload.

DESCRIPTION

One Female operator can operate all of the ABM INDUSTRIES Quilting Machines. While the machine is quilting, the operator fills the next frame with the new goods to be quilted. When the quilting cycle is completed, the machine stops automatically and the frame lock is released. The completed frame may then be pulled past the needle and the actuating button may be depressed to engage the frame changing mechanism of the automatic table. This system removes the finished frame from the machine while simultaneously positioning the next frame into quilting position. The new frame is pulled past the needle, and with the touch of the "start" button the machine commences its operational cycle anew. The entire operation can easily be accomplished in one(1)minute for the average Sleeping Bag quilting design (60 feet of quilting).

In the event that the sewing thread should break, the machine stops automatically. A flick of a switch and the operator rolls the carriers out of the way enabling her to rethread the sewing machine. Flick the switch, touch the "start" button and the machine is quilting again.

OPERATING CHARACTERISTICS

The machine has a maximum track speed of 60 feet per minute, a sewing capacity of 4000 stitches per minute, and adjusts from 5 to 10 stitches per inch. Duplication of many hand stitch designs are enabled by virtue of the Gear Trolley Unit design which allows turns of 1 1/2 inch radius or greater, coupled with crossings of any desired angle.

In the event that thread breakage should occur during the quilting cycle, an electro-mechanical thread sensing device stops the machine automatically.

The actuation of a single control toggle switch actuates the Pneumatic Gear Trolley Lifter, thus enabling the operator to roll the top and bottom carriers aside for easy access to the needle and bobbin. Rethreading of the Sewing Machine can then be accomplished with maximum expediency.

Regardless of operating speeds or types of materials being used, the built-in forced-air cooling system assures that the needle will be kept cool at all times.

SPECIFICATIONS

Optimum Quality and Performance are assured on all Quilting Machines and their accessories. Each machine is subjected to rigorous inspection and testing procedures under operating conditions prior to shipment.

All ball bearings are of the pre-lubricated permanently sealed variety for minimum maintenance and longer life.

The machine operates on 1/2 and 3/4 H.P. Electric Motors, Single Phase, 60 cycle, 115 or 220 volt, 20A AC as normally supplied. AC or DC Motors can be supplied to suit individual domestic and overseas requirements.

An Air-line pressure of 90 PSI is required for the cooling system and the pneumatic gear trolley lifter.

SECTION II

PREPARATION FOR USE

RECEIVING AND UNPACKING

RECEIVING: All Quilting machines and attendant work tables are shipped as two (2) units. Upon receipt, inspect the crates for evidence of damage enroute. In the event that there is evidence of damage, notify the carrier immediately and also notify ABM INDUSTRIES, INC., 1308 S. Pulaski, Chicago, Illinois, 60623.

UNPACKING: Remove bonding straps and retaining hardware from the crates. Remove all protective wrapping and wadding, ensuring that no part of the equipment is discarded. Uncrate the machine.

CAUTION: This machine is precision built, and is accurately adjusted prior to shipment. Uncrate the machine with care. Check the contents of the crates with the packing list. In case of shortage, notify ABM INDUSTRIES immediately.

LOCATION OF THE QUILTING MACHINE

The location of the machine may be chosen to suit the individual requirements of a given production operation. The light weight construction makes it readily suited to either concrete or wooden flooring. Place the machine body in the desired position on the floor, allowing 8 1/2 feet of space at the back of the machine, and 17 feet of space in front. The electrical supply from the factory outlet must run to the RIGHT endstand. All measurements are to be taken from the center line of the bridge. Left/Right reference is made looking at the front of the bridge.

The compressor unit should be placed in a convenient location adjacent to the machine. The exact location will be determined by the specific machine location, clearance for the carriers and operator safety factors.

ASSEMBLY AND INSTALLATION

BOTTOM TRACK:

Match up the corresponding identification markings on the brackets, tracks and tie bars of the dismantled bottom track assembly. Align the bolt holes in the Right Hand and the Left Hand bottom track clamp weldments with the holes in the machine bases and bolt to the floor. Care should be taken to locate the tie-bars parallel to each other within 1/16th inches and square to the machine base.

Attach the Front and Rear bottom tracks together with the Tie Bars to the track clamp weldments leaving the nuts on the studs finger tight only. Attach the Pattern Clamps to the pattern clamp tie bar with the bolts provided.

Mount the BOTTOM CARRIER onto the tracks, making sure that the tube braces are mounted on the RIGHT side of the machine. Adjust the Front and Rear bottom tracks to suit the distance between centers of the mounted wheel grooves. When the Bottom Carrier will freely traverse the entire length

of the track, and the tracks have been aligned within 1/32nd inch of parallel position, the stud nuts may then be fully tightened.

TOP CARRIER ASSEMBLY:

Place the Top Carrier onto the Bottom Carrier rails with the Gear Trolley Unit positioned on the left side of the machine. Two wheels on both carrier assemblies have been carefully aligned and locked in position at the factory prior to shipment and the Top Carrier should move freely along the entire length of the Bottom Carrier rails.

Mount the Frame Guide Support Frames with the nuts and bolts provided at the front and rear of the top carrier. Care should be taken to match the corresponding assembly numbers on the side of the frame. This will ensure that the Frame Lock device is in the proper location.

The Left and Right hand Frame Guides may now be assembled to the Support Frames with the flared ends towards the front of the machine. They should be positioned about the center line of the Top Carrier and parallel to the Bottom Carrier track. The distance between the Frame Guides should allow 1/8th inch clearance on either side of the intended Frame width. Raise or lower the Support Frame posts to provide a 1/4 inch clearance between the bottom face of the Frame Guides and the Sewing Machine base.

PATTERN TEMPLATE:

Place the pattern on the Bottom Track Tie Bars from the left side of the machine. The pattern Stop Switch should be located at the Front Left side of the machine. Position the pattern template so that the final design on the finished goods will be approximately centered in relation to the Frame Assembly and lightly tighten the two pattern clamps. To facilitate the positioning of the pattern template, move both top and bottom carriers to the extreme right of the machine.

With the pattern template in preliminary adjustment position, raise the gear housing of the Gear Trolley Unit manually to clear the pattern track. The Carrier can then be readily moved and the track lowered into position on the track. The gear should travel in the direction in which the arrow on the Gear Head is pointing. Normal direction of travel around the pattern will commence from the stop switch at the front left pattern corner in a clockwise direction towards the left rear of the pattern.

INSTALLATION:

Perform the following installation procedures in the sequence shown below.

- a. Remove the white tie which locks the needle positioner located in the uppermost section of the right endstand. FAILURE to do this will cause FAILURE of the needle positioner system!
- b. Connect the factory power line with the handy box on the Right Rear of the machine Bridge Assembly. The machine is normally wired for 220 volt, single phase, 60 cycle AC unless specified differently on the purchase order. (All switches should be in the OFF position.)

- c. Attach the air hose from the compressor to the air filter located on the Rear of the Right Endstand.
- d. Connect the air hose/electric cable from the Cable Support Arm to the Right Rear of the Top Carrier Frame Guide Support Frame.
- e. Connect Black air hose from the Gear Trolley Unit into the pressure regulator opposite the Black hose from the Cable Support Arm.
- f. Connect the White hose to the connection opposite the White hose from the Cable Support Arm.
- g. Connect the Yellow air hose from the Frame Lock to the T connection opposite the Yellow hose from the Cable Support Arm.
- h. Plug in the two electric connectors to the handy box located on the R.Rear of the top carrier. NOTE! Match the identification marking on BOTH plugs and sockets.
- i. Connect the Green 6V line from the connector at the bottom of the Left Endstand to the Stop Switch on the pattern.
- j. Plug in the 6V line to the thread breaker.

AUTOMATIC FRAME CHANGING TABLE:

The procedures outlined in the following sub-paragraphs outline the sequence for installing the Automatic Frame Changing Table.

- a. Assemble the two (2) aluminum transfer arms to the side chain brackets. Care should be taken to match the arms with those already mounted.
- b. Assemble the Frame Support Roller Bracket Assemblies to the right and left rear sides of the table. The flap points toward the front of the table.
- c. Loosen the four (4) thumb-screws on the four table clamps and adjust the table top to suit the racking frames. Normal side rail frame clearance should be 1/8 inch on each side.
- d. Disconnect the plug from the thread breaker and then start the machine. Run the Quilting machine until it stops automatically. WARNING! DO NOT run the machine if the RED LIGHT on the bridge is ON. This indicates that the needle positioner is operating and you must wait until the light goes off before pushing the Start Button.
- e. With the quilting machine Gear Head located on the pattern stop, position the automatic table so that the frames slide easily from the table to the carrier. Locate the end of the Automatic Table approximately 26 inches from the guide rails. With the frame drawn beyond the sewing machine pressure foot, advance the table to a position whereby the pick-up arms engage with the pick-up pins attached to the frame.

- f. Connect the factory power line to the Left Rear of the Table.
- g. Plug the five prong interlock from the table into the connection located on the front Left Endstand.
- h. Connect a factory air line to the connector on the Left Rear side of the Table.
- i. Plug in the thread breaker wire.

PRELIMINARY STARTING PROCEDURES

When all of the aforementioned procedures have been complied with, the Quilting Machine and the Automatic Table are ready for preliminary starting.

Turn on the electrical switch located on the main control box on the lower Right Endstand.

Regulate the air line pressure to a setting of 90 PSI and test the Gear Lifter device. The actuating switch controlling the Gear Lifter is located on the top bridge beam. Set the switch to the lift position and set the Gear Unit on the border track one (1) inch behind the track stop.

The Gear Swiveler Button will actuate the Gear Swiveler mechanism which will turn the Gear Unit for correct orientation on the pattern. Depress the Swiveler Button on the bridge beam to align the Gear Head on the pattern.

Lower the Gear Unit onto the stop switch. This will open the frame lock on the center front of the top carrier and allow the frame to go forward under the needle and the pressure foot.

Place one of the frames on the table and clamp the materials in place. Make certain all the clamps are closed and pull the frame onto the carrier of the machine. The frame will be locked into position when the rear blocks are set up against the rear of the frame. Clamp the materials into the second frame on the table and start the machine. (ENSURE that the RED LIGHT for the needle positioner is off)

Run the machine WITHOUT the needle in the sewing head, but with goods in BOTH frames, for at least ten (10) minutes prior to actually starting production operations. At this point, any minor adjustments of alignment and/or machine function should be made.

SECTION III
OPERATION INSTRUCTIONS

GENERAL

This section contains the general operating instructions for Quilting Machines equipped with an Automatic Table. These instructions should be followed explicitly to obtain optimum results from this equipment. Before operating the machine, recheck to ensure that all of the preliminary starting procedures have been satisfactorily accomplished. The proper use of the Cross Stitch Quilting Machine in conjunction with the Automatic Table results in product quality and economy of operation that is unapproachable by any other method.

PRELIMINARY OPERATING PROCEDURES

The following sub-paragraphs delineate the sequence of procedures entailed for preliminary production operation.

- a. Turn the electrical switch to the ON position.
- b. Place a full spool of thread on the thread rack on the top of the machine.
- c. Mount the needle and thread the sewing machine. When threading, be sure to pass the thread downwards through the thread breaker arm located on the front of the sewing machine. Threading instructions are contained within the separate sewing machine booklet.
- d. Ensure that the thread breaker control is plugged in. Should this be omitted, the machine will not stop in the event of thread breakage. When the thread breaks the arm is released and the machine will automatically stop.
- e. Place a full bobbin in the bobbin case.

OPERATING PROCEDURES

Place one of the frames on the table and clamp the materials into place. After making certain that all the clamps are closed, pull the frame onto the carrier of the machine. The needle should be at its highest point due to the needle positioner mechanism.

Turn the needle down while holding the thread and pick up the bottom thread. Hold both threads (approximately 6" long) so that the thread breaker bracket arm is taut, check to ensure that the RED LIGHT is OFF, press the START button and hold it down for a few seconds. Release the START button and the thread.

While the machine is quilting, the operator should clamp the next materials into the second frame on the table. The operator should finish clamping in approximately the same time as the machine quilting cycle.

When the machine completes the quilting cycle it will stop automatically and the needle will be raised to its highest position. The operator will

break the needle thread and the bobbin thread and then slide the frame from under the needle and pressure foot.

Press the START button on the Automatic Table Start Stop Station, which is mounted vertically on the bridge beam, to start the operation of the Automatic Table. The pick-up arms will lift the completed frame from the carrier and onto the Table while the next frame is simultaneously pushed onto the carrier. When the new frame has stopped moving automatically, the operator can then pull it under the needle and pressure foot.

SECTION IV

LUBRICATION AND MAINTENANCE

LUBRICATION

Your ABM Quilting Machine has been properly lubricated before leaving the factory and should not require any additional oil. The design of the machine provides a minimum number of lubrication points consistent with optimum longevity of the equipment. The following delineates the lubrication points, frequency and recommended lubricants.

SEWING MACHINE: See separate booklet.

GEAR TROLLEY UNIT ASSEMBLY: Three points of lubrication.

- a. Fill the grease cup mounted on the variable speed pulley assembly with Lubriplate #907 light grease or the equivalent.
- b. Apply several drops of SAE #20 oil to the oil hole cover located on the side of the top flanged bearing cover once a week.
- c. Lubricate the Gear Unit Shaft TWICE WEEKLY with SAE #20 oil. Oil should be applied to the shaft at the bearing located immediately below the lifter fork.

GEAR HEAD: The Gear Head is properly packed with Lubriplate #907 light grease before leaving the factory. The head should be cleaned and re-packed with the Lubriplate #907 grease at 3 month intervals.

AUTOMATIC TABLE: Two points of lubrication.

- a. Fill the grease cup mounted on the variable speed pulley assembly with Lubriplate #907 light grease or the equivalent.
- b. The Gear Box is properly packed with Lubriplate #907 light grease before leaving the factory. The box should be cleaned and re-packed with Lubriplate #907 grease at three month intervals.

MAINTENANCE

Periodic inspection is the first step in preventive maintenance. As in the case of all machinery, minor defects developing in the equipment due to various causes can be readily rectified if discovered at an early instance. The maintenance procedures prescribed in this literature are essentially of a simple nature, requiring only the use of basic shop tools.

CARRIERS: Keep the wheels and axel shafts free of accumulations of thread or lint.

PATTERN TEMPLATE: All thread and other waste material should be cleared from the pattern template periodically throughout the day and at least at the end of every day. The plastic track should be inspected periodically (dependent upon machine usage) for indications of undue wear. Worn pieces of track can be readily replaced from sections obtained from ABM Industries.

SEWING MACHINE HEAD: Clean the bobbin case and hook compartment several times daily for optimum sewing efficiency.

GEAR TROLLEY UNIT: The flanges located on either side of the track gear must be maintained free of thread and other waste materials at all times. Flanges should rotate freely at all times.

MACHINE - PARTS LISTING

MACHINE -- MO1 FULLY AUTOMATIC QUILTER

PART #	QTY	DESCRIPTION
15	1	WHITE ITC BOBBINS
26	1	WHITE ITC THREAD
5131	1	FACE PLATE SCREW
99844	1	SEWING MACHINE
00-004	1	THREAD RACK WELDMENT
00-005	1	CABLE SUPPORT ARM WE
00-008- 2	1	FRAMELOCK ***INACTIVE PART ***
00-008-10	1	STOP BLOCK FOR Q WIT
00-008-14	1	INTERLOCK ONLY
00-011	6	ALUM CLAMP #200 SUB
00-012	1	PINION GEAR SMALL
00-013	1	PINION GEAR LARGE
00-016	1	FRAME SUPPORT BRKT
00-016- 1	1	FR SUPP SPRINGS RH
00-017	1	FRAME SUPPORT BRKT
00-017- 1	1	FR SUPP SPRINGS LH
00-021- 1	2	SHAFT FOR LGE GEAR
00-021- 2	1	LG BRASS GEAR
00-021- 3	1	SM BRASS GEAR
00-021- 4	1	WORM RGT HAND
00-021- 5	1	CAST FOR GR RX MACH
00-021- 6	3	WOODRUFF KEY
00-021- 9	1	SHAFT FOR WORM
00-021-10	6	BRONZE THRUST SPACER
00-023- 1	2	STUD WELDMENT
00-029	1	DRIVE TUBE
00-029- 9	2	SQ EXT DRIVE SHAFT
00-052	1	THREAD BREAKER COMPL
010001	1	BEARING
010002	1	BEARING
010003	1	00-005 SUPPORT
010004	6	TOP SHAFT BEARING
010005	5	BOTTOM SHAFT BEARING
010006- 6	16	PILLOW BLOCK
010007	2	180004 BUSHING
010008	1	00-012 BUSHING
010008- 1	2	THRUST BALL BEARING
010009	2	STEEL SPACER
010010	1	120005 BUSHING
010010- 1	1	NEEDLE BEARING
010011	2	210005 BEARING
010012	2	210006 BEARING
010013	1	GEAR HEAD SUPPORT
010014	1	FLANGE BUSHING
010015- 1	7	SM PIN SPRT BRG
010015- 1	7	SM PIN SPRT BRG
010015- 3	2	LOCK NUT
010015- 5	7	ALUM FR WHEEL SHAFT
010016	1	010013 BUSHING
010017	2	FLANGE BEARING

MACHINE - PARTS LISTING

MACHINE -- M01

PART #	QTY	DESCRIPTION
010018	2	TABLE BEARING
010019	3	OILITE BUSH
010021	6	00-021 BUSHING
020001	1	V BELT
020002	3	BRAKE BELT
020003	2	TABLE BELT
030001	1	THRD BKR BRACKET ARM
030006- 1	1	UNISTRUT
030024	2	BALL BEARING SLIDES
040001	1	POWER CORD
040002	2	MAGNETIC CONTACTOR
040003	1	TERMINAL BLOCKS
040003- 1	1	TERMINAL BLOCKS
040004	1	VECTOR BOARD
040007	1	BEAMS DRILLED
040011	1	L H SPRKT GUARD
040012	1	R H APRKT GUARD
040015	2	CONTRDL BOX
040017	1	GUARD END PL RR
040020	1-	HOUR METER
050004	1	THREAD BRKR CASTING
050007	1	BASE COVER CASTING
050008	1	BASE CASTING
050009	1	ALUM CASTG HANGAR BK
050010	1	SHAFT HSG SUPP CASTG
050011	3	SHAFT HSG SUPP CSTG
050017	1	GR HSG CVR NOT MACH
050018	1	GR HSG BRG SP NOT MA
050018- 1	1-	WRENCH & FITTING
050019	1	GR HSG AL CST NOT MA
050020	1	GR HSG CVR NOT MACH
050021	1	LFTR FRK CST MACH
050027	2	FR PSHR CST DRILLED
050029	2	PICK UP ARM LH
050030	2	PICK UP ARM RH
060001	1	THREAD BREAKER CAM
080001	1	UPR FLX CPLG W/BSHG
080002	1	FLEX CPLG LDWER
080005	60	TABLE CHAIN FT
080006	1	050027 LINK
080007	4	PU ARM LINK
080007- 1	1	080005 LINK
090001	1	JACK COMPLETE M/F
090002	1	RELAY
090003	3	START, STOP SWITCH
090006	1	DOUBLE RELAY
090007	1	SINGLE RELAY
090008	4	SOCKET OCTAL BASE
090010	1	CIRCUIT BREAKER 20A
090012	11	BOX CON

MACHINE - PARTS LISTING

MACHINE -- MO1

PART #	QTY	DESCRIPTION
090012- 1	2	CONNECTOR
090016	1	VALVE
090017- 1	1	VALVE SET
090018	1	CHASE NIPPLE
090018- 1	3	CHASE NIPPLE
090020	4	HAN BOX
090037	1	FEM CONN
090037- 1	1	MALE CONN
090038	4	HAN BOX COV
090039	1	2 HOLE COVER
090040	1	DOUBLE REC
090043	2	HUB TWS LO PL
090046	1	VALVE 220 VOLT
090046- 0	2	AUTO TABLE AIR VALVE
090046- 1	6	VALVE STEM
090046- 3	1	SHORT MAN BLCK
090046- 4	12	O RING
090047	1	BRAKE MOTOR
090051	1	MOTOR
090051- 1	1	TABLE MOTOR 9-76
090055	1	AIR CYLINDER
090055- 1	1	MIN FLAT LINK CHAIN
090058	1	SWITCH
090058- 1	1	VALVE SET
090061- 0	1	AIR FILTER
090061- 1	1	AIR CTL NDL POS SET
090061- 2	1	HOSE & FTG NDL POS
090066	2	FLOW CONTROL
090066- 1	1	COLLAR
090066- 2	1	LUBRICATOR
090067	2	MOTOR
090067- 1	2	PUSH BUTTON SWITCH
090067- 2	1	MOTOR CLAMP
090067- 3	2	MOTOR CLAMP
090068	1	GEARS
090069	1	GEARS
090070	2-	GEAR SWIVELER CYL
090071	1	INDICATOR LITE
090073	1	TRANSFORMER
090092	1	TRANSFORMER
100052	6	5/8 STE BEA COL
100067	2	RET RG
100068	2	RET RING
100070	2	STEEL COLLAR
100080	1	WOODRUFF KEY
100081	2	WOODRUFF KEY
100082	1	WOODRUFF KEY
100099	2	STEEL COLLARS
100135	1	BRONZE BUSH'G 00-013
100136	1	BUSHING FOR 00-013

MACHINE - PARTS LISTING

MACHINE -- M01

PART #	QTY	DESCRIPTION
100137- 1	2	PULLEY
100138	2	GREASE FOR GEARHEAD
100139- 1	1	THRUST BUSHING
120001	1	TRACK GEAR
120002	1	WORM SPIRAL GEAR
120003	1	WORM GEAR
120004	1	GEAR PIVOT PIN
120005	1	IDLER SPUR GEAR
120009	6	SPROCKET
120010- 0	2	NEW AUT TAB SPROCK
120012	2	SPROCKET
120012- 1	8	CHAIN
160001	1	AIR CYL
160002	1	CYL
170004	1	1/4 OD PLASTIC HOSE
180001	1	PULLEY
180002- 1	2	PULLEY
180004	2	TRACK GEAR FLANGE
180005	1	GEAR HEAD PULLEY
180005- 1	1	GEAR BOX PULLEY
180005- 2	1	TORQ LM
180006	2	VAR-PUL-COMplete
180006- 1	2	VAR PUL ONLY
180013	8	WHEELS
200017	1	ADJ SCREW
200017- 1	1	PRE CUP ADJ SCREW
200032	1	NEEDLE BAR
200039	1	SMALL PRESSURE CUP
200039- 1	1	SCREW
200043	1	HOOK
200044	1	OIL GAUGE
200045	1	NEEDLE PLATE
200046	1	RED SLIDE
200047	2	SCREWS
200048	1	GASKET
200050	1	BOR CAS HDL
200051- 1	1	FLOUR LIGHT ASSBLY
210001	1	TOP DRIVE SHFT
210002	1	BOTTOM DRIVE SHFT
210005	1	GEAR DRIVE SHFT
210006	1	GEAR UNIT DR TUBE
210012	1	STUD SHAFT
230002- 2	1	MINI REG & GAUGE
260001	1	BSHG & 7/8 CPLG
260003	1	120009-3 BUSHING
270002	5	RUBBER GROMET
300001	1	QUILTER & TABLE
300005	1	NEW GEAR HEAD
380001	1	HINGE
510030	1	MINI TENSION GUIDE

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MACHINE - PARTS LISTING

MACHINE -- M01

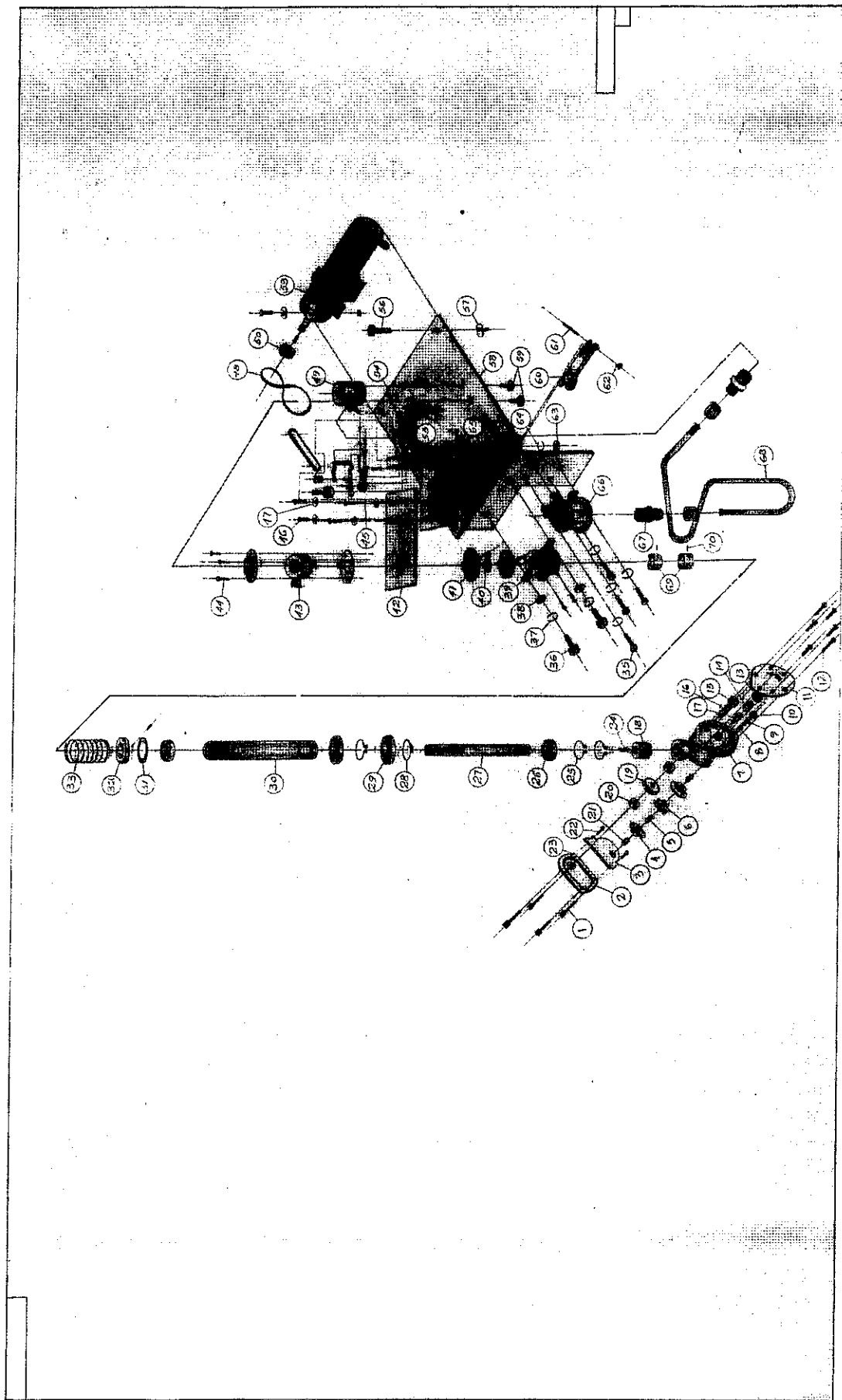
PART #	QTY	DESCRIPTION
5106303	1	ARM SHAFT
5106342	1-	THREAD REGULATOR
5106348	1	SEE 5106368
5106374	1	MULTI-FILAMENT TENSILE
5106424	1	NDLE BAR BUSH LOW
5272229	1-	HOOK PUMP
5276047	1-	SEE 200041

MACHINE - PARTS LISTING

MACHINE -- M08

SCALLOP

PART #	QTY	DESCRIPTION
00-005	1	CABLE SUPPORT ARM WE
00-071	2	TUBE SUPP POST
010004	8	TOP SHAFT BEARING
010024	2	NYLON BALL BEARINGS
020004	1	SCALLOP BELT
060004	2	SCALLOP CAM
080025	2	UNIV JOINT
090007	2	SINGLE RELAY
090010- 1	1	CIRCUIT BREAKER 30A
090012	3	BOX CON
090017	1	TOGGLE SWITCH
090018	1	CHASE NIPPLE
090018- 1	1	CHASE NIPPLE
090038- 1	1	1 HOLE COVER
090040	2	DOUBLE REC
090042	1	SINGLE REC
090066- 1	8	COLLAR
090067- 1	2	PUSH BUTTON SWITCH
120027	1	SPROCKET
120030	4	GEAR
130001	10	CHAIN
130001- 1	1	GEAR MOTOR
130001- 2	1	SPROCKET
130001- 3	1	CHAIN
130001- 4	1	SPROCKET
180002	1	PULLEY
180017	1	SPROCKET
240141	2	BUSH SUPPORT
260011	2	SCALLOP BUSHING
300008	1	SCALLOP
464005	2	PILLOW BLOCK
700000	1	DRIVE TRANS MTR
700005	1	DELAY RELAY
700007	1	RESISTER



Gear Trolley Unit Assembly

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A B M I N D U S T R I E S

PAGE 1

MACHINE - PARTS LISTING

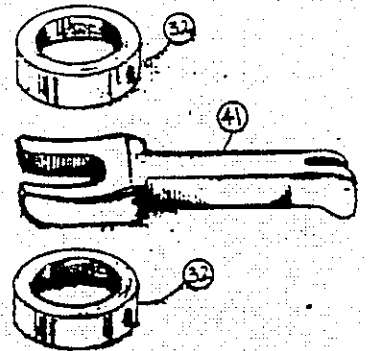
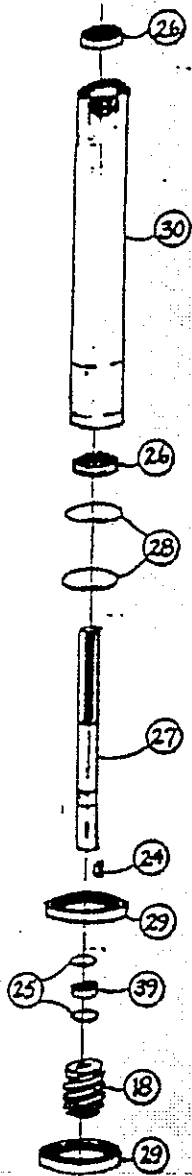
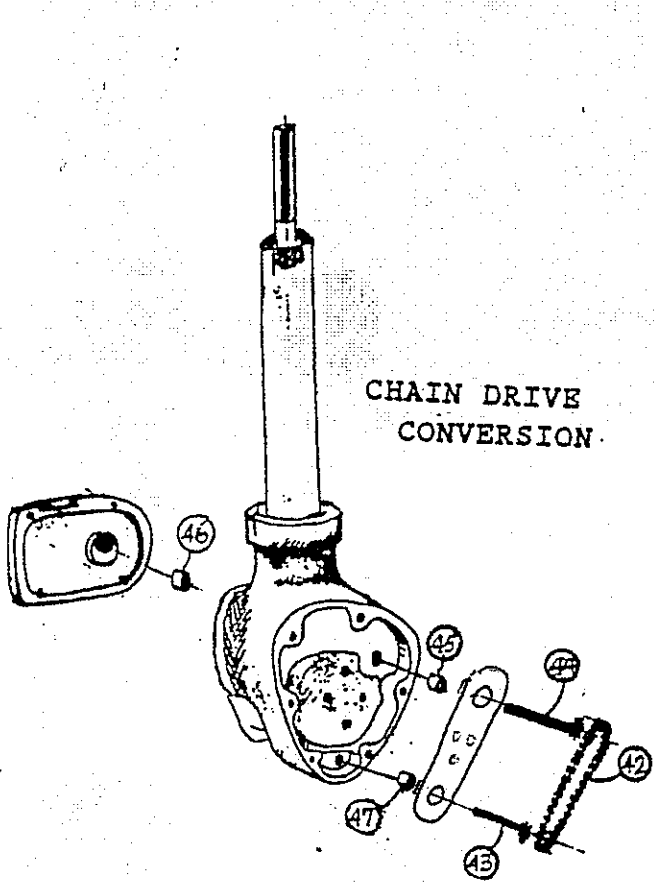
MACHINE -- M18

PATTERNS

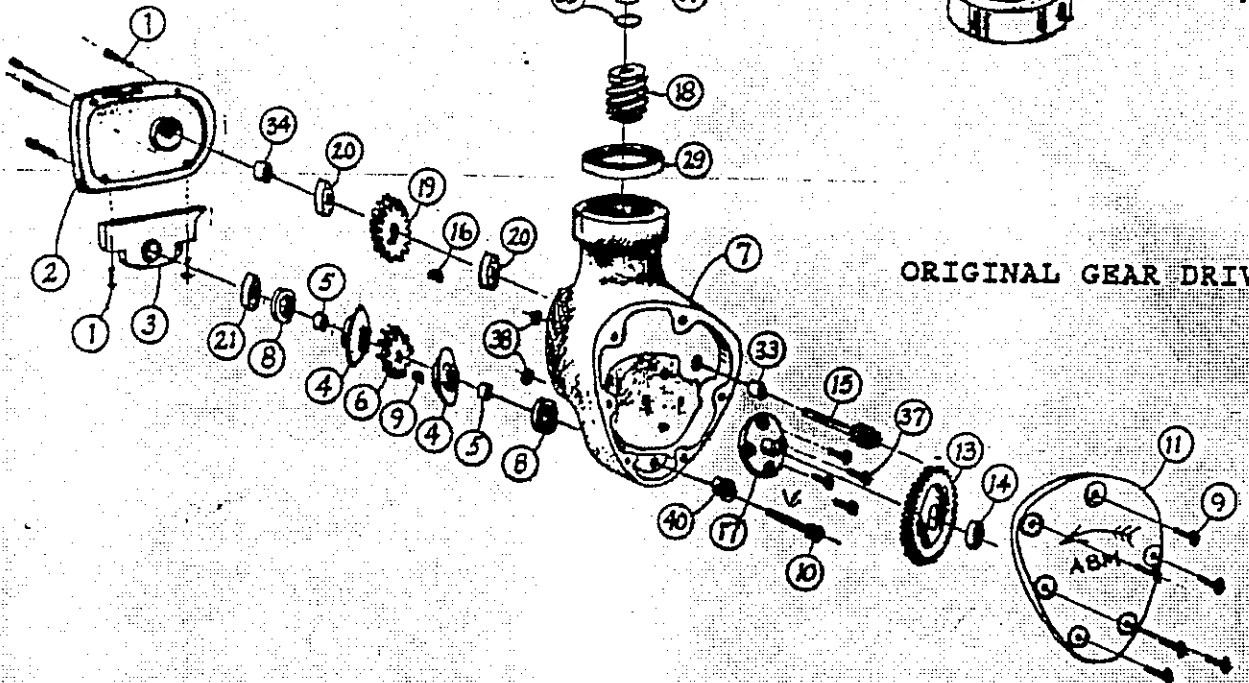
PART #	QTY	DESCRIPTION
250002	100	PATRN TRACK
250002- 2	20	CROSSOVER 90
250002- 3	20	CROSSOVER 60
250005	1	PATTERN STOPPER
300018	1	PATTERN
380000	2	PATTERN BOARD MTL
380001	1	HINGE

GEAR TROLLEY UNIT ASSEMBLY

CHAIN DRIVE
CONVERSION



ORIGINAL GEAR DRIVE



GEAR TROLLEY UNIT ASSEMBLY PARTS LIST

DETAIL NO.	PART NUMBER	DESCRIPTION
1	100066	1/4 - 20x1" Large Hex Head Cap Screw
2	050017	Gear Housing Cover
3	050018	Gear Housing Bearing Support Plate
4	180004	Track Gear Flange
5	010007	Bronze Bushing
6	120001	Track Gear
7	050019	Gear Housing
8	010008	Bronze Bushing
9	100080	Woodruff Key 3/32" x 1/2
10	00-012	Pinion Gear Sub-Assembly
11	050020	Gear Housing Cover
12	#9	10-32 x 3/4" flat head socket screw
13	120005 -1	Idler Spur Gear
14	010010	Bronze Bushing
15	00-013	Pinion Gear Sub-Assembly
16	100081	Woodruff Key 3/32 x 5/8
17	120004	Gear Pivot Pin
18	120003	Worm Gear
19	120002	Spiral Gear
20	010009	1/2"x1"x1/2" Lg. Steel Bushing
21	010015	3/8 x 1/2 x 3/8 Bronze Bushing
22	100001	1/4" - 20x1" Lg. Hex Socket Head Cap Screw
23	100083	1/2"x1" Dowel Pin
24	100082	Woodruff Key 1/8" x 5/8
25	100067	Bearing Retainer Ring

GEAR TROLLEY UNIT ASSEMBLY PARTS LIST

DETAIL NO.	PART NUMBER	DESCRIPTION
26	010011	Bearing
27	210005	Gear Unit Drive Shaft
28	100068	Bearing Retainer Ring
29	010012	Bearing
30	210006	Gear Unit Drive Shaft Housing
31	100069	1-5/16 x 2-3/16 x 1/8 Leather Washer
32	100070	1-5/16" Steel Collar
33	230002	Spring
34	100076	1/4" Lock Washer
35	100075	1/4 - 20 x 3/4" Hex Head Cap Screw
36	100077	1/2" - 13 x 1 1/2" Hex Head Cap Screw
37	100050	1/2" Lock Washer
38	100045	1/2" Flat Washer
39	010013	Pillow Block Bearings
40	100071	5/8" x 1-1/8 x 1/8" Leather Washer
41	180005	Gear Unit Drive Shaft Pulley
42	240022	Bearing Support Bracket
43	010014	Flange Bushing
44	100040	5/16 - 18 x 1/2" Hex Head Cap Screw
45	180006	Variable Speed Pulley
46	100078	5/16 - 18 x 5/8" Hex Head Cap Screw
47	100041	5/16" Flat Washer
48	020002	V Pulley Belt

MACHINE - PARTS LISTING

MACHINE -- M05

GEAR HEAD

PART #	QTY	DESCRIPTION
00-012	1	PINION GEAR SMALL
00-013	1	PINION GEAR LARGE
010007	2	180004 BUSHING
010008	1	00-012 BUSHING
010008- 1	2	THRUST BALL BEARING
010009	2	STEEL SPACER
010010	1	120005 BUSHING
010010- 1	1	NEEDLE BEARING
010011	2	210005 BEARING
010012	2	210006 BEARING
010015- 1	7	SM PIN SPRT BRG
050017	1	GR HSG CVR NOT MACH
050018	1	GR HSG BRG SP NOT MA
050019	1	GR HSG AL CST NOT MA
050020	1	GR HSG CVR NOT MACH
100067	2	RET RG
100068	2	RET RING
100070	1	STEEL COLLAR
100080	1	WOODRUFF KEY
100081	1	WOODRUFF KEY
100082	1	WOODRUFF KEY
100135	1	BRONZE BUSH'G 00-013
100136	1	BUSHING FOR 00-013
100138	1	GREASE FOR GEARHEAD
100139- 1	1	THRUST BUSHING
120001	1	TRACK GEAR
120002	1	WORM SPIRAL GEAR
120003	1	WORM GEAR
120004	1	GEAR PIVOT PIN
120005	1	IDLER SPUR GEAR
180004	2	TRACK GEAR FLANGE
210005	1	GEAR DRIVE SHFT
210006	1	GEAR UNIT DR TUBE
300005	1	NEW GEAR HEAD

GEAR TROLLEY UNIT ASSEMBLY PARTS LIST

DETAIL NO.	PART NUMBER	DESCRIPTION
49	090046	3 Way Valve
50	180002	Pulley
53	090047	1/2" HP-1725-115/230 V. Brake Motor
54	100056	5/16" - 18 x 1" Lg. Hex Head Cap Screw
55	100055	5/16" - 18 Hex Nut
56	100061	3/8" - 16x3 1/2 Lg. Carriage Bolt
57	100062	Unistrut Nut
58	00-013	Gear Unit Mnt. Frame Weldment
59	100072	10-32x5/8" Lg. Round Head Machine Screw
60	050021	Lifter Fork Casting
61	100073	Pin
62	100093	Retainer Ring
63	100025	3/8" Hex Nut
64	100044	3/8" Lock Washer
65	100026	3/8" - 16x1" Hex Head Cap Screw
66	160001	Air Cylinder
67	110009	Brass Fitting
68	170004	1/4" Copper Tube 18" Long
69	010016	Oilite Bushing
70	100103	1/18"x1/4" Large Dowell Pin

THE FOLLOWING PARTS ARE NOT ILLUSTRATED:

100135	Bushing 1/2" ID X 3/4"
100136	Bushing 1/2" ID X 3/8"
100137	Gear Head Swiveler Motor
100138	Grease special for gear head

MACHINE - PARTS LISTING

MACHINE -- M06

GEAR DRIVE FOR MACHINE (GEAR HEAD)

PART #	QTY	DESCRIPTION
00-012	1	PINION GEAR SMALL
00-013	1	PINION GEAR LARGE
010007	2	180004 BUSHING
010008	1	00-012 BUSHING
010008- 1	2	THRUST BALL BEARING
010009	2	STEEL SPACER
010010	1	120005 BUSHING
010011	2	210005 BEARING
010012	2	210006 BEARING
010013	1	GEAR HEAD SUPPORT
010014	1	FLANGE BUSHING
010015- 1	7	SM PIN SPRT BRG
010016	1	010013 BUSHING
020002	3	BRAKE BELT
050017	1	GR HSG CVR NOT MACH
050018	1	GR HSG BRG SP NOT MA
050019	1	GR HSG AL CST NOT MA
050020	1	GR HSG CVR NOT MACH
050021	1	LFTR FRK CST MACH
090046	1	VALVE 220 VOLT
090047	1	BRAKE MOTOR
100067	2	RET RG
100068	2	RET RING
100070	2	STEEL COLLAR
100080	1	WOODRUFF KEY
100081	1	WOODRUFF KEY
100082	1	WOODRUFF KEY
100135	1	BRONZE BUSH'G 00-013
100136	1	BUSHING FOR 00-013
100138	1	GREASE FDR GEARHEAD
100139- 1	1	THRUST BUSHING
120001	1	TRACK GEAR
120002	1	WORM SPIRAL GEAR
120003	1	WORM GEAR
120004	1	GEAR PIVOT PIN
120005	1	IDLER SPUR GEAR
180004	2	TRACK GEAR FLANGE
180005	1	GEAR HEAD PULLEY
180006	1	VAR-PUL-COMPLETE
180006- 1	1	VAR PUL ONLY
300006	1	GR HD CONVERSION

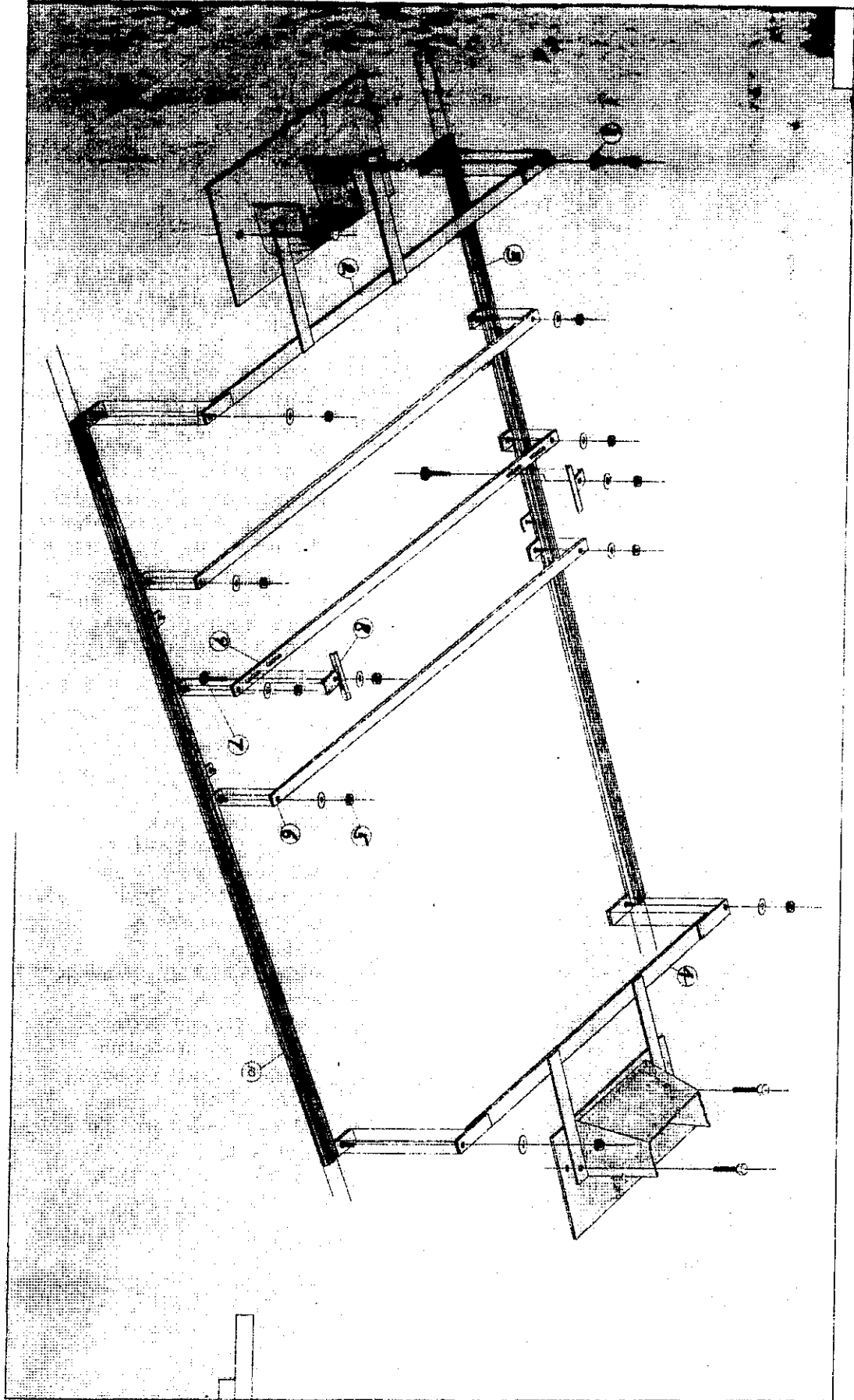


Figure 2.0 Bottom Track Assembly

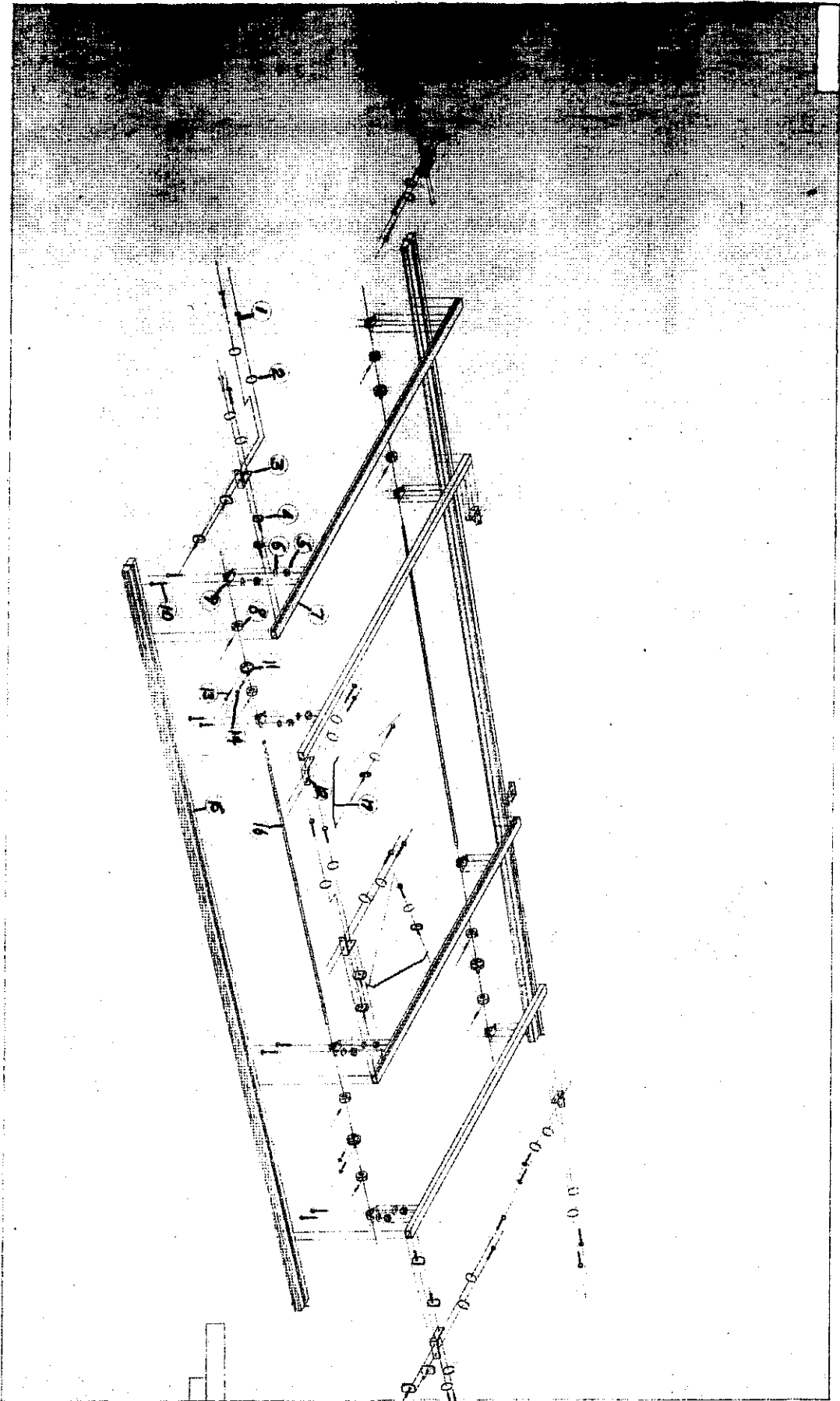


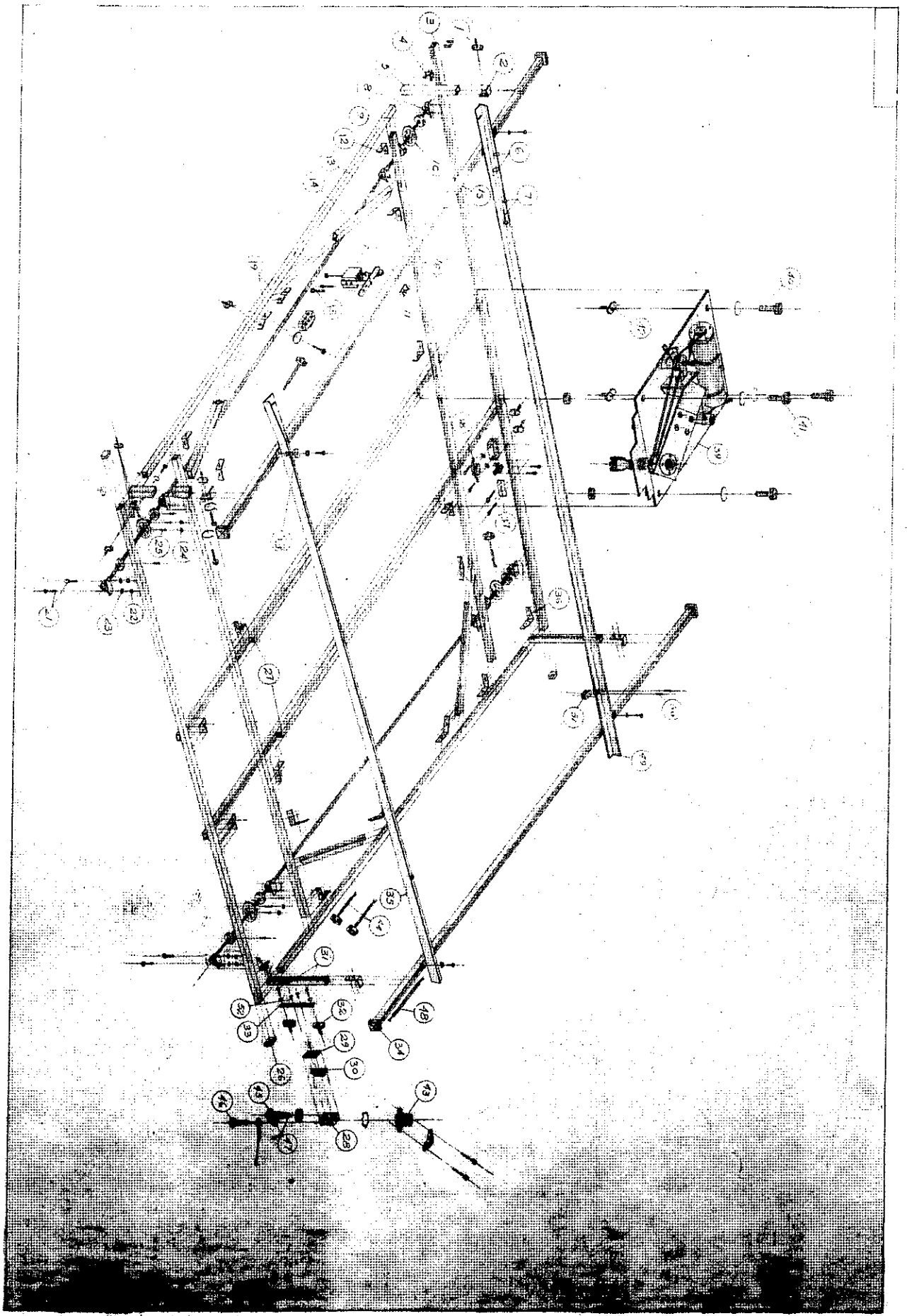
Figure 3.0 Bottom Carrier Assembly

BOTTOM CARRIER ASSEMBLY PARTS LIST

DETAIL NO.	PART NUMBER	DESCRIPTION	(Ref. Fig. 3.0)
1	100049	1/2" - 13 x 1" Hex Head Cap Screw	
2	100050	1/2" Lock Washer	
3	030005	Unistrut Bracket	
4	100051	Unistrut Nuts w/spring	
5	100025	3/8" - 16 Hex Nut	
6	100028	3/8" Flat Washer	
7	240012	Unistrut	
8	100052	5/8" Steel Collars	
9	010006	Pillow Block Bearing	
10	100053	3/8" - 16 x 1 1/4" Hex Head Cap Screw	
11	<i>180013</i>	AB-80 Wheel	
12	030006	Unistrut Bracket	
13	100054	5/16 - 18 x 3/4" Hex Socket Set Screw	
14	100055	5/16 - 18 Hex Nut	
15	00-007	Bottom Carrier Track Weldment	
16	210003	Axle	
17	030007	Unistrut Tube Bracket	

BOTTOM TRACK ASSEMBLY PARTS LIST

DETAIL NO.	PART NUMBER	DESCRIPTION	(Ref. Fig. 2.0)
1	100028	3/8" Flat Washer	
2	240009	Left Hand Bottom Track Weldment	
3	240008	Rear Bottom Track Weldment	
4	240006	Right Hand Bottom Track Weldment	
5	100025	3/8" - 16 Hex Nut	
6	240007	Bottom Track Tie Bar	
7	100048	3/8" - 16 x 1" Carriage Bolt	
8	070001	Bottom Pattern Clamp	
9	240010	Pattern Clamp Tie Bar	
10	240011	Front Bottom Track Weldment	



Top Carrier Assembly

TOP CARRIER ASSEMBLY PARTS LIST

DETAIL NO.	PART NUMBER	DESCRIPTION
1	100051	Unistrut Nut w/spring
2	030010	Unistrut Bracket
3	240013	Unistrut
4	030011	Unistrut Bracket
5	240014	Unistrut
6	100050	1/2" Lock Washers
7	100049	1/2" - 13x1" lg. hex head cap screw
8	010006*6	Pillow Block Bearing
9	100052	5/8" Steel Collars
10	<i>180013</i>	AB-80 Aluminum Wheels
11	100057	Unistrut Nuts w/wrapping
12	030012	Unistrut Bracket
13	210004	Axle Shaft Top Carrier
14	240015	Unistrut Brace
15	240016	Unistrut
16	240017	Unistrut
17	00-008	Frame Lock Sub-Assembly
18	100056	5/16" - 18x1 hex head cap screw
19	030013	Unistrut Bracket
21	100053	3/8" - 16x1-1/4" hex head cap screw
22	100025	3/8" - 16 Hex Nuts
23	100044	3/8" Lock Washers
24	100055	5/16" - 18 Hex Nut
25	100054	5/16" - 18 Hex Socket Set Screw
26	100058	Unistrut End Cap
27	00-009	Top Carrier Frame Weldment

TOP CARRIER ASSEMBLY PARTS LIST

DETAIL NO.	PART NUMBER	DESCRIPTION
28	090020	Handy Box
29	090039	Handy Box Cover
30	090040	Hubbell Receptacle
31	100001	1/4" - 20x1" hex head cap screw
32	100059	Unistrut Nut w/spring
33	030014	Handy Box Hanger Bracket
34	100060	Unistrut End Cap
35	00-010	Top Carrier Frame Guide Right Hand
36	030015	Unistrut Bracket
37	090041	Handy Box Cover
38	090042	Hubbell Receptacle
39	631-03	Gear Trolley Unit Assembly
40	100061	3/8" - 16x3 1/2 hex head carriage bolts
41	100026	3/8" - 16x1" hex head cap screw
42	100062	Unistrut nut w/spring
43	090012	Connector
44	090043	Twst. lock plug
45	090001	Female Jack
46	100072	10 - 32 x 5/8" round head machine screw
47	100022	10 - 32 Hex Nut
48	090044	16 - 3 Rubber Covered Wire
49	00-014	Top Carrier Frame Guide Left Hand
50	100084	10 - 32 x 1/4" Hex Socket Set Screw
51	110010	Frame Guide Stop
52	100007	10 - 32 x 1/2" round head machine screw

MACHINE - PARTS LISTING

MACHINE -- M02

BRIDGE

PART #	QTY	DESCRIPTION
15	1	WHITE ITC BOBBINS
26	1	WHITE ITC THREAD
5131	1	FACE PLATE SCREW
99844	1	SEWING MACHINE
00-004	1	THREAD RACK WELDMENT
00-005	1	CABLE SUPPORT ARM WE
00-008- 2	1	FRAMELOCK
00-008-10	1	STOP BLOCK FOR Q WIT
00-008-14	1	INTERLOCK ONLY
00-012	1	PINION GEAR SMALL
00-013	1	PINION GEAR LARGE
00-052	1	THREAD BREAKER COMPL
010001	1	BEARING
010002	1	BEARING
010003	1	00-005 SUPPDRT
010004	4	TOP SHAFT BEARING
010005	5	BOTTOM SHAFT BEARING
010006- 6	16	PILLOW BLOCK
010007	2	180004 BUSHING
010008	1	00-012 BUSHING
010008- 1	2	THRUST BALL BEARING
010009	2	STEEL SPACER
010010	1	120005 BUSHING
010010- 1	1	NEEDLE BEARING
010011	2	210005 BEARING
010012	2	210006 BEARING
010013	1	GEAR HEAD SUPPORT
010014	1	FLANGE BUSHING
010015- 1	7	SM PIN SPRT BRG
010015- 3	1	LOCK NUT
010015- 5	7	ALUM FR WHEEL SHAFT
010016	1	010013 BUSHING
020001	1	V BELT
020002	3	BRAKE BELT
030001	1	THRD BKR BRACKET ARM
030006- 1	1	UNISTRUT
040002	1	MAGNETIC CONTACTOR
040003	1	TERMINAL BLOCKS
040003- 1	1	TERMINAL BLOCKS
040004	1	VECTOR BOARD
040007	1	BEAMS DRILLED
040015	1	CONTROL BOX
040020	1-	HOOR METER
050004	1	THREAD BRKR CASTING
050007	1	BASE COVER CASTING
050008	1	BASE CASTING
050009	1	ALUM CASTG HANGAR BK
050010	1	SHAFT HSG SUPP CASTG
050011	3	SHAFT HSG SUPP CSTG
050017	1	GR HSG CVR NOT MACH

***INACTIVE PART ***

MACHINE - PARTS LISTING

MACHINE -- M02

PART #	QTY	DESCRIPTION
050018	1	GR HSG BRG SP NOT MA
050018- 1	1-	WRENCH & FITTING
050019	1	GR HSG AL CST NOT MA
050020	1	GR HSG CVR NOT MACH
050021	1	LFTR FRK CST MACH
060001	1	THREAD BREAKER CAM
080001	1	UPR FLX CPLG W/BSHG
080002	1	FLEX CPLG LOWER
090001	1	JACK COMPLETE M/F
090002	1	RELAY
090003	2	START, STOP SWITCH
090006	1	DOUBLE RELAY
090007	1	SINGLE RELAY
090008	2	SOCKET OCTAL BASE
090010	1	CIRCUIT BREAKER 20A
090012	5	BOX CDN
090012- 1	1	CONNECTOR
090016	1	VALVE
090017- 1	1	VALVE SET
090018	1	CHASE NIPPLE
090018- 1	3	CHASE NIPPLE
090020	3	HAN BOX
090038	3	HAN BOX CDV
090039	1	2 HOLE COVER
090040	1	DOUBLE REC
090043	2	HUB TWS LO PL
090046- 0	1-	AUTO TABLE AIR VALVE
090047	1	BRAKE MOTOR
090051	1	MOTOR
090055	1	AIR CYLINDER
090055- 1	1	MIN FLAT LINK CHAIN
090061- 0	1	AIR FILTER
090061- 2	1	HOSE & FTG NDL POS
090066	1	FLOW CONTROL
090066- 2	1	LUBRICATOR
090067	1	MOTOR
090067- 1	1	PUSH BUTTON SWITCH
090067- 2	1	MOTOR CLAMP
090070	2-	GEAR SWIVELER CYL
090073	1	TRANSFORMER
090092	1	TRANSFORMER
100067	2	RET RG
100068	2	RET RING
100070	2	STEEL COLLAR
100080	1	WOODRUFF KEY
100081	1	WOODRUFF KEY
100082	1	WOODRUFF KEY
100135	1	BRONZE BUSH'G 00-013
100136	1	BUSHING FOR 00-013
100137- 1	1	PULLEY

MACHINE - PARTS LISTING

MACHINE -- M02

PART #	QTY	DESCRIPTION
100138	1	GREASE FOR GEARHEAD
100139- 1	1	THRUST BUSHING
120001	1	TRACK GEAR
120002	1	WORM SPIRAL GEAR
120003	1	WORM GEAR
120004	1	GEAR PIVOT PIN
120005	1	IDLER SPUR GEAR
160001	1	AIR CYL
170004	1	1/4 OD PLASTIC HOSE
180001	1	PULLEY
180002- 1	1	PULLEY
180004	2	TRACK GEAR FLANGE
180005	1	GEAR HEAD PULLEY
180006	1	VAR-PUL-COMPLETE
180006- 1	1	VAR PUL ONLY
180013	8	WHEELS
200017	1	ADJ SCREW
200017- 1	1	PRE CUP ADJ SCREW
200032	1	NEEDLE BAR
200039	1	SMALL PRESSURE CUP
200039- 1	1	SCREW
200043	1	HOOK
200044	1	OIL GAUGE
200045	1	NEEDLE PLATE
200046	1	BED SLIDE
200047	2	SCREWS
200048	1	GASKET
200050	1	BOB CAS HOL
200051- 1	1	FLOUR LIGHT ASSBLY
210001	1	TOP DRIVE SHFT
210002	1	BOTTOM DRIVE SHFT
210005	1	GEAR DRIVE SHFT
210006	1	GEAR UNIT DR TUBE
210012	1	STUD SHAFT
230002- 2	1	MINI REG & GAUGE
260001	1	BSHG & 7/8 CPLG
270002	5	RUBBER GROMET
300002	1	BRIDGE ONLY
300005	1	NEW GEAR HEAD
380001	1	HINGE
510030	1	MINI TENSION GUIDE
5106303	1	ARM SHAFT
5106342	1-	THREAD REGULATOR
5106348	1	SEE 5106368
5106374	1	MULTI-FILAMENT TENS
5106424	1	NDLE BAR BUSH LOW
5272229	1-	HOOK PUMP
5276047	1-	SEE 200041

BRIDGE ASSEMBLY PARTS LIST

DETAIL NO.	PART NUMBER	DESCRIPTION
1	200056	Bobbin Winder Assembly
2	100007	10/32x1/2" Round Head Machine Screw
3	100008	8/32x1/2 Round Head Machine Screw Hard.
4	090003	Station Control
5	100009	1/2 - 20 x 3/4" Eye Bolt W/Nut
6	230001	Spring
7	00-005	Cable Support Arm Weldment Assembly
8	090005	Start-Stop Min. Switch 7.50
9	100010	6/32 x 1 1/4" Round Head Machine Screw
10	100011	Start-Stop Tag
11	100012	Serial # Tag
12	100047	Drive Rivets #0 - 1/4"
13	110001	Thread Post
14	100019	1/4 - 20 Hex Nut
15	110002	Spool Plate
16	00-004	Thread Rack Weldment
17		1/2 - 13 Hex Nut
18	100020 00-003	Bridge Weldment Assembly
19	100021	Romax Clip
20	100022	10-32 Hex Nut
21	100023	10-32 x 1/2 Hex Head Machine Screw
22	090017	Toggle Switch
23	030002	Bracket

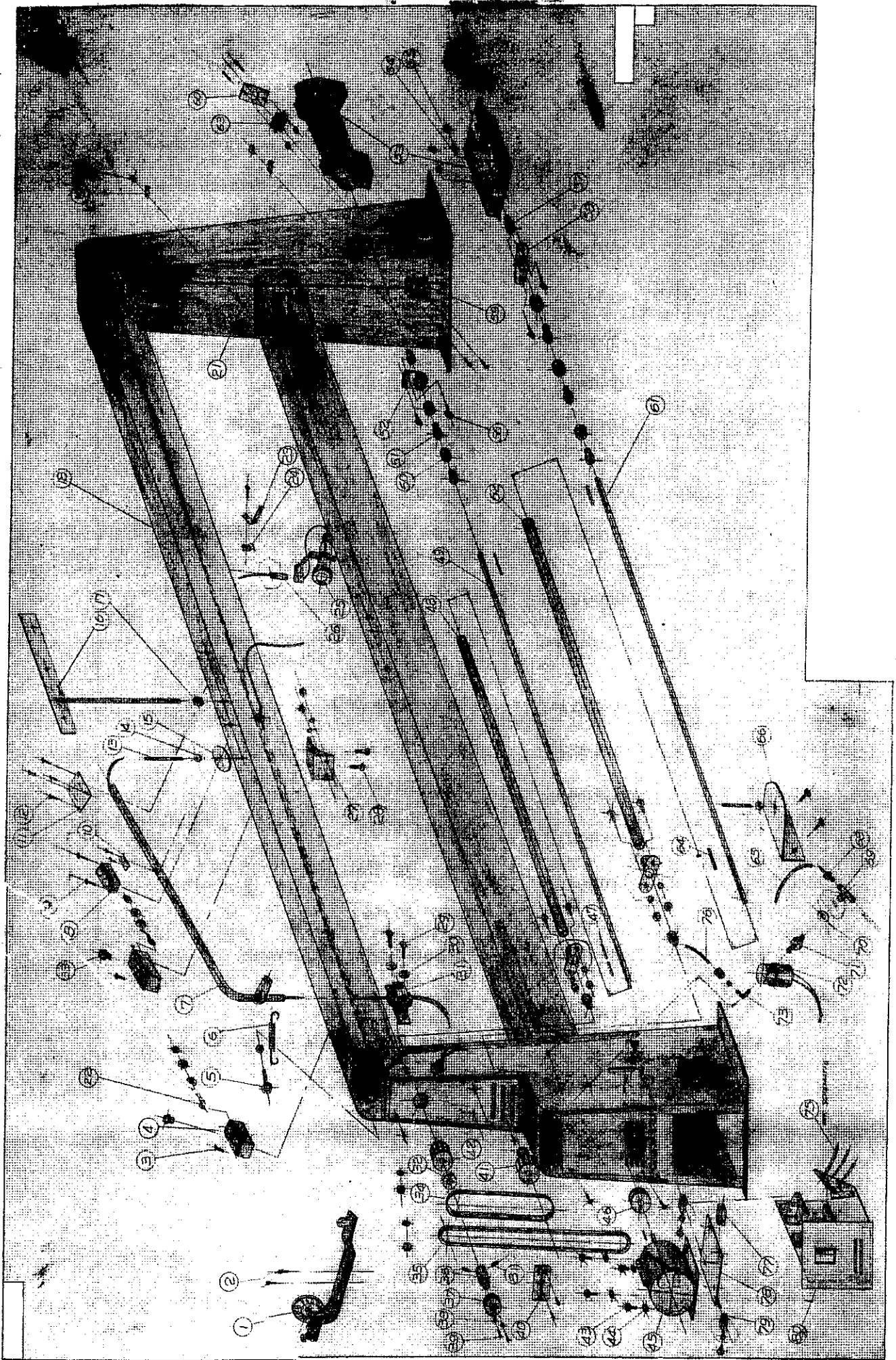


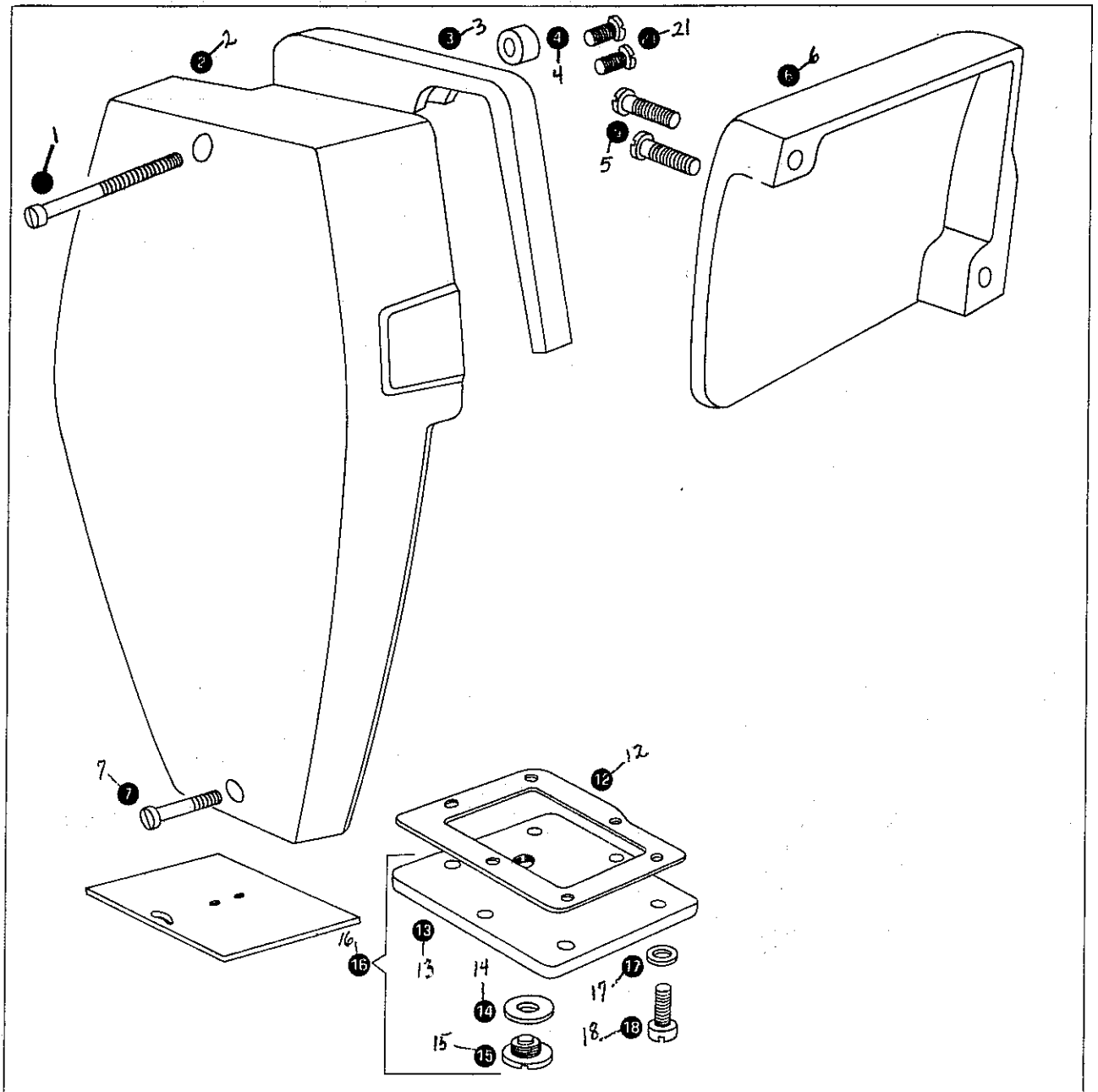
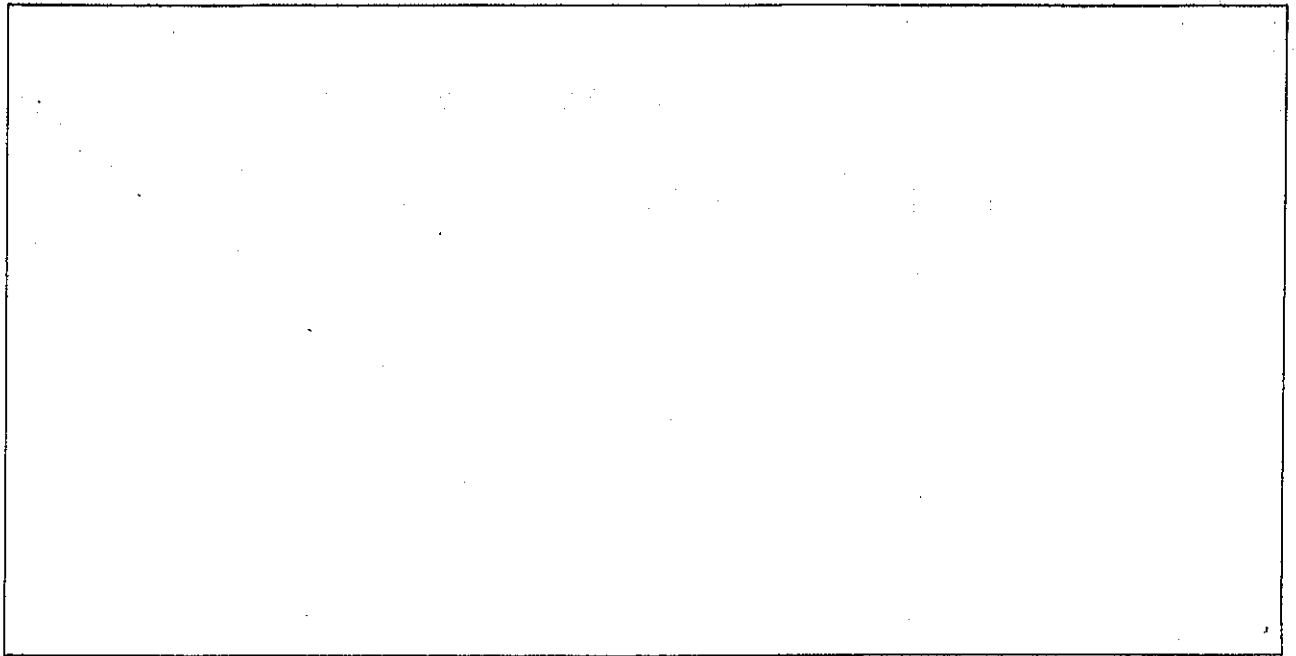
Figure 31.0 Bridge Assembly

BRIDGE ASSEMBLY PARTS LIST

DETAIL NO.	PART NUMBER	DESCRIPTION
48	240001	Top Shaft Housing
49	210001	Top Drive Shaft
50	270002	Rubber Grommet
51	010004	Bearing
52	050010	Shaft Housing Support Casting
53	00-001	Sewing Head Assembly
54	100044	3/8" Lock Washer
55	100025	3/8" - 16 Hex Nut
57	010005	Bearing
58	050011	Shaft Housing Support Casting
59	090020	Handy Box
60	090038	Handy Box Cover
61	210002	Bottom Drive Shaft
62	240002	Bottom Shaft Housing
63	090037	Female Connector
64	100042	1/8" Sq. x 1/2" Lg. Key
65	170002	3/16" I.D. Rubber Hose 14 Ft. Long
66	030004	Bobbin Winder Thread Sp. Bracket
68	110005	3/16 x 1/4 Hose Connector
69	110006	1/4" NPT Fem. Blk. Pipe Tee
70	100045	1/2" Flat Washer
71	100046	1/8" x 1/2" NPT Male Reducer
72	090016	Solenoid 230 V 60 V E, 1 - 110V 60 V E

BRIDGE ASSEMBLY PARTS LIST

DETAIL NO.	PART NUMBER	DESCRIPTION
24	100024	Aluminum Electr. Clip
25	200051	6 Volt Light Assembly
26	170001	1/4" N.P. Nipple x 1 1/2" Lg.
27	050009	Aluminum Casting Hanger Bracket
28	100026	3/8" - 16 x 1" Lg. Hex Head Cap Screws
29	100027	3/8" - 16 x 1 1/2" Hex Head Cap Screws
30	100028	3/8" Flat Washers
31	010003	Wiring Tube Bearing Support
32	180002-1	Bearing Pulley
33	090018	1/2" Chase Nipple
34	200058	Time Belt
35	020001	V Belt
36	080003	Bobbin Winder Coupling
37	270001	Rubber Grommet
38	100029	5/32" ID Flat Washers
39	100030	6-32 x 1/2" Fillst. Head Screw
40	030003	Bobbin Winder Mounting Bracket
41	<i>5106380</i>	Time Pulley Lower
42	<i>5106306</i>	Time Pulley Upper
43	100040	5/16 - 18 x 1/2 Hex Head Cap Screw
44	100041	5/16" Flat Washers
45	<i>090051</i>	Electric Motor
46	180001	Bearing Pulley
47	100043	3/16 sq. x 1/2" Lg. Key Stock



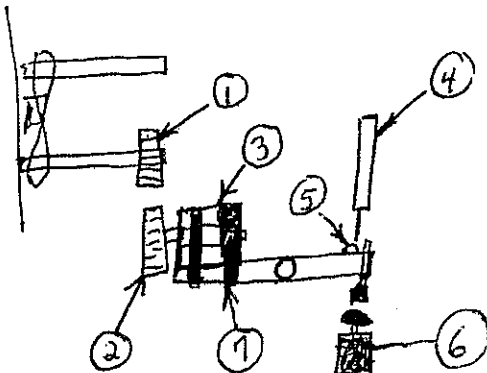
BRIDGE ASSEMBLY PARTS LIST

DETAIL NO.	PART NUMBER	DESCRIPTION
73	110007	3/16" x 1/8" NPT Male Brass Elbow
75	00-006	Wiring Schematic
76	170003	3/16" Copper Tube 10 Ft.
77	240003	Motor Adjustor
78	240005	Motor Base
79	240004	Motor Hanger
80	00-002	Switch Box Assembly
81	100088	1/4 - 20 x 5/16 Hex Socket Set Screw

THE FOLLOWING PARTS ARE NOT ILLUSTRATED:

- 090006 Relay in switch box *200 AC 2CX MRE 2CA*
- 090007 Relay in switch box *200 AC 1CX MRE 1CA*
- Parts for pressure foot lifter system located above sewing head on bridge:
- 090053 Lifting cable
- 090055 Air cylinder

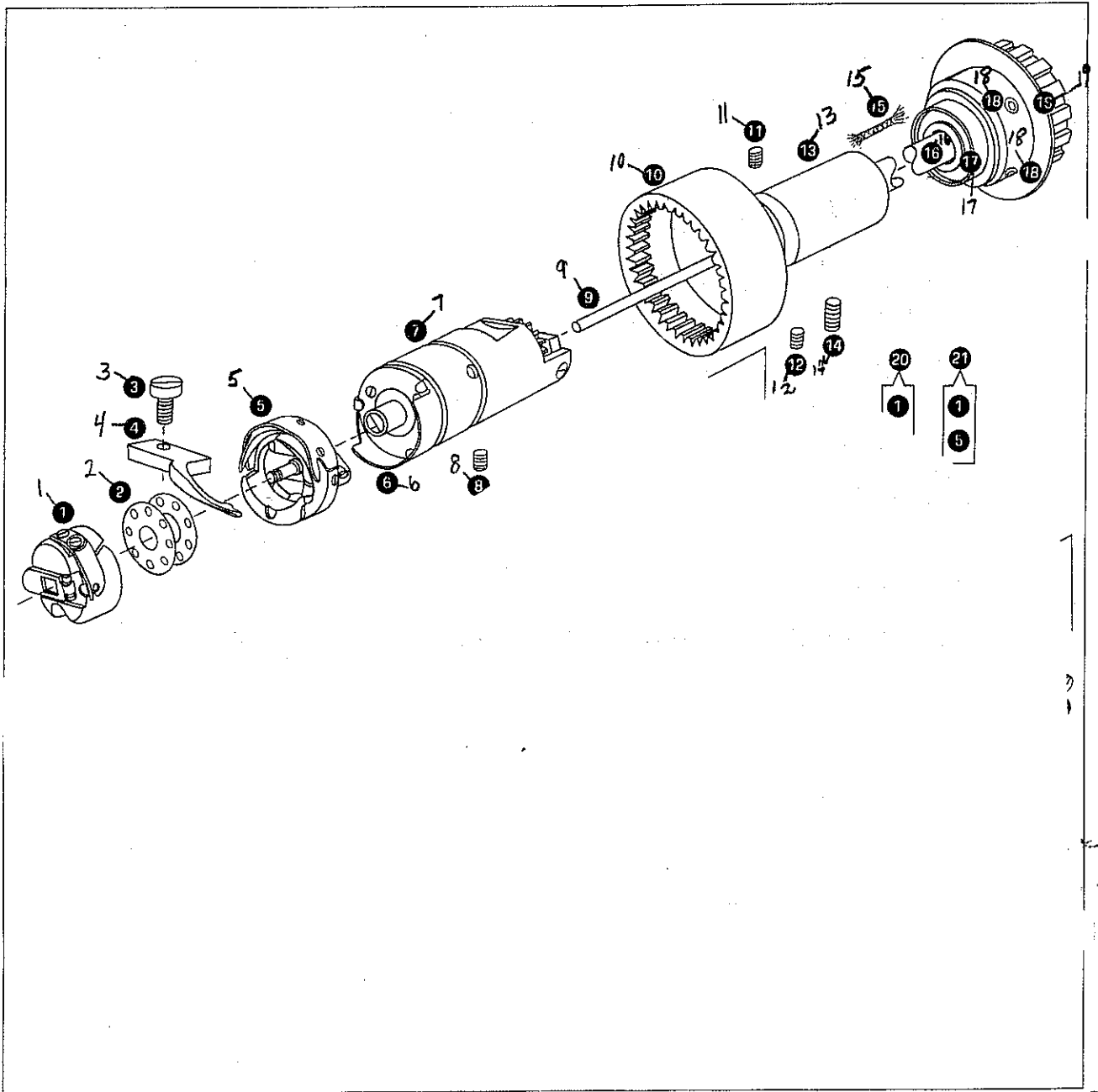
Parts for needle positioner located in end stand of bridge... illustrated here:



- 1. 090069 sml. gear
- 2. 090068 lg. gear
- 3. 090067 drive motor
- 4. *090070* air cylinder
- 5. 090067-1 switch
- 6. 090061-3 off controle valve
- 7. 090067-2 mtg. bands

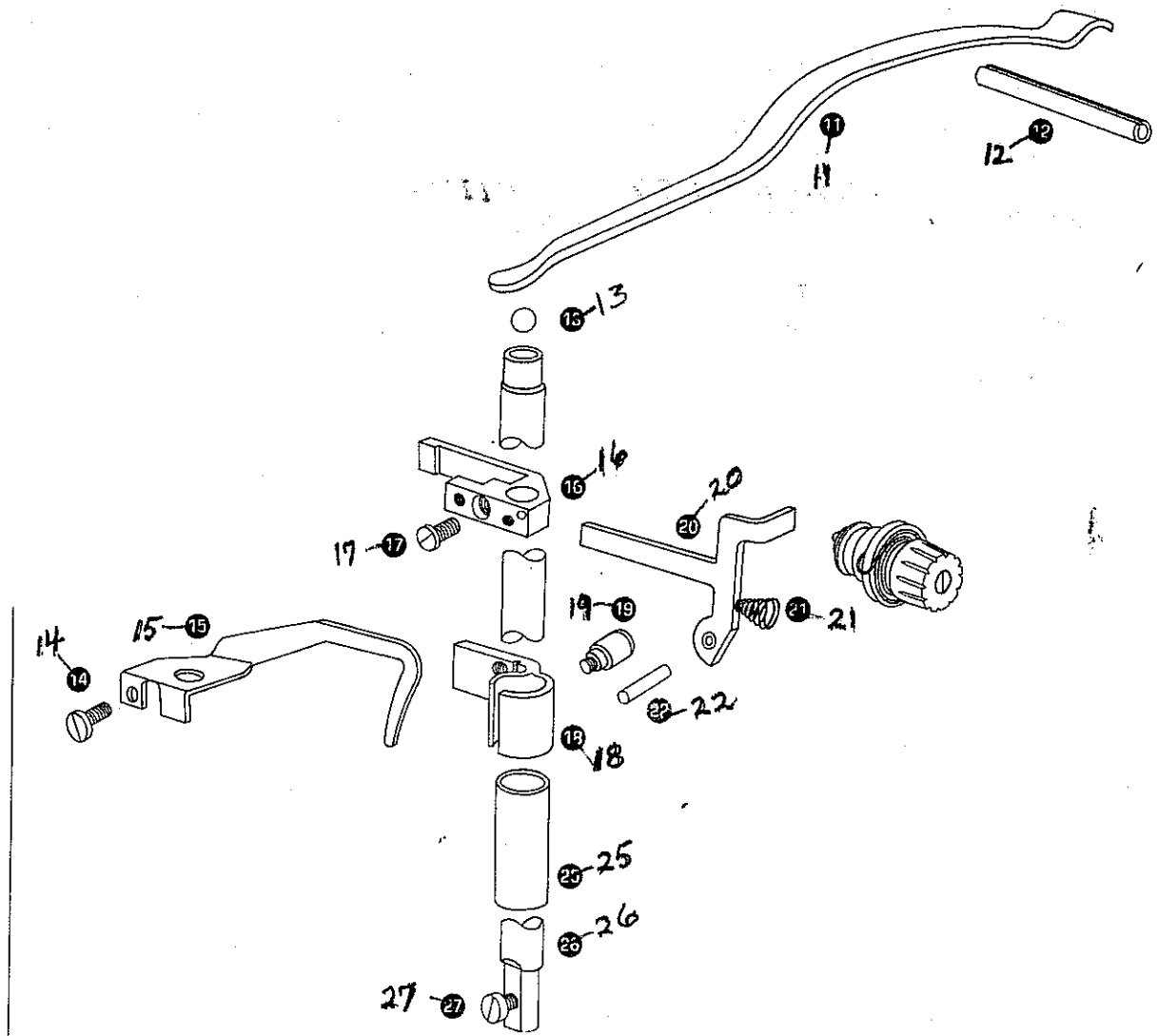
Parts List for ~~99044~~ Machine

Ref. No.	Part No. For Ordering	Description	Amt. Req.
	7435 (830)	Thread Take-up Lever Link Hinge Stud Set Screw	
2	516377-1	Thread Retainer Lock Nut	
3	516377	Thread Retainer	
4	552239	Arm Spool Pin and Thread Eyelet (packed with accessories)	
5	5106357	Thread Take-up Lever Link Hinge Stud	
6	5106368	Thread Take-up Mechanism	
	5106368-2	PLASTIC THRUST WASHER	
	5106368-5	HYPODERMIC GREASE GUN	
7	5106397	Needle Bar Oiling Felt (upper)	
8	5106325	Needle Bar Bushing (upper)	
9	200030	Needle Bar Oiling Felt (lower)	
10	5106424	Needle Bar Bushing (lower)	
11	598923	Needle Bar Bushing (lower) Thread Eyelet	
12	200032	Needle Bar	
13	200032-1	Needle Set Screw	
14	5140036(830)	Needle Bar Thread Guide Screw	
15	5149235-003	Needle Bar Thread Guide	
17	200033-4	Needle,	
	5106346	Thread Eyelet and Thread Guard (front of arm)	
	551384 (809)	Thread Eyelet and Thread Guard (front of arm) Screw	
20	532574	Tension Releasing Pin	
21	550305(803)	Tension Stud Set Screw	
22	552083	Thread Take-up Spring Regulator	
23	200022-1	Thread Take-up Spring	
24	5106374-4	Tension Stud	
25			2
26	5106374-1	Tension Releasing Disc	
27	5147152	Tension Spring	
28	5106373	Tension Regulating Cap	
29	5106374	Tension complete,	
30	5448 (803)	Thread Take-up Spring Regulator Set Screw	
31	5140610(809)	Thread Take-up Crank Clamping Screw Hole Plug Screw	
32	5106368-6	REPLACEMENT TAKE-UP EYELET	



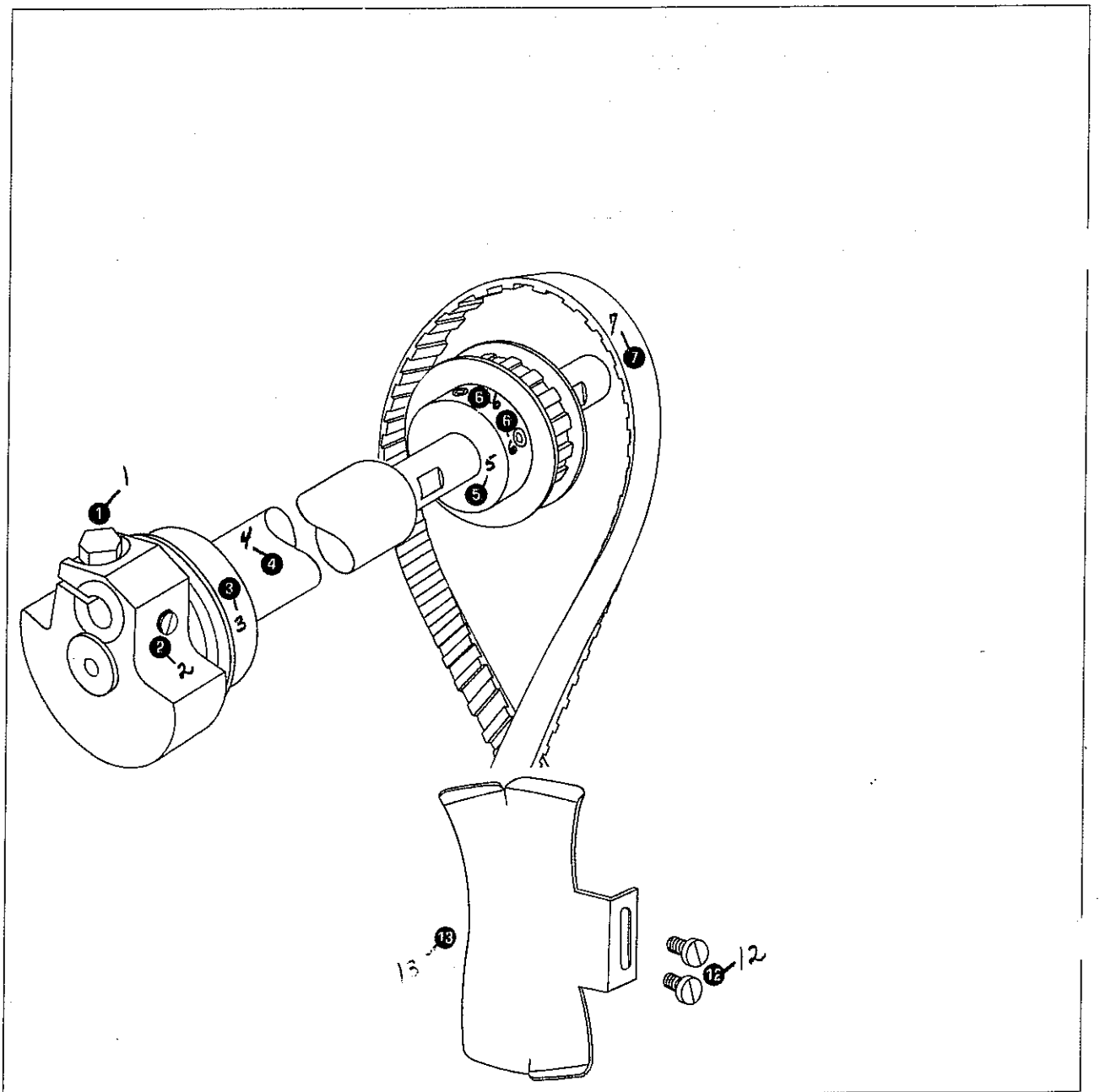
Parts List for ~~99014~~ Machine

Ref. No.	Part No. For Ordering	Description	Amt. Req.
1	200053	Rotating Hook Bobbin Case complete	
2	7270010	Rotating Hook Bobbin	
3	5200077(804)	Rotating Hook Bobbin Case Holder Position Bracket Screw	
4	200050	Rotating Hook Bobbin Case Holder Position Bracket	
5	200043	Rotating Hook	
6	5270879	Rotating Hook Oil Guard	
7	5272229	Rotating Hook Shaft Bushing complete,	
8	200042-2	Rotating Hook Shaft Bushing Set Screw	
9			
10	200041	Rotating Hook Driving Shaft Gear (internal teeth)	
11	5201220(833)	Rotating Hook Driving Shaft Gear Position Screw	
12	5200382(833)	Rotating Hook Driving Shaft Gear Set Screw	
13	5276045	Rotating Hook Driving Shaft Bushing	
14	200042-2	Rotating Hook Driving Shaft Bushing Set Screw	
15			
16	5106429	Rotating Hook Driving Shaft	
17	010001	Rotating Hook Driving Shaft Ball Bearing	
18	7114063(869)	Rotating Hook Driving Shaft Connection Belt Pulley Set Screw	2
19	5106380	Rotating Hook Driving Shaft Connection Belt Pulley	
	080002	LOWER FLEX COUPLING	
	080002-1	RUBBER INSERT	
	080002-2	SCREW	
	080002-3	METAL PIECE w/3/8 BORE NEXT TO SEWING HEAD	
	080002-4	METAL PIECE w/1/2 BORE NEXT TO SHAFT	



Parts List for ~~99847~~ Machine

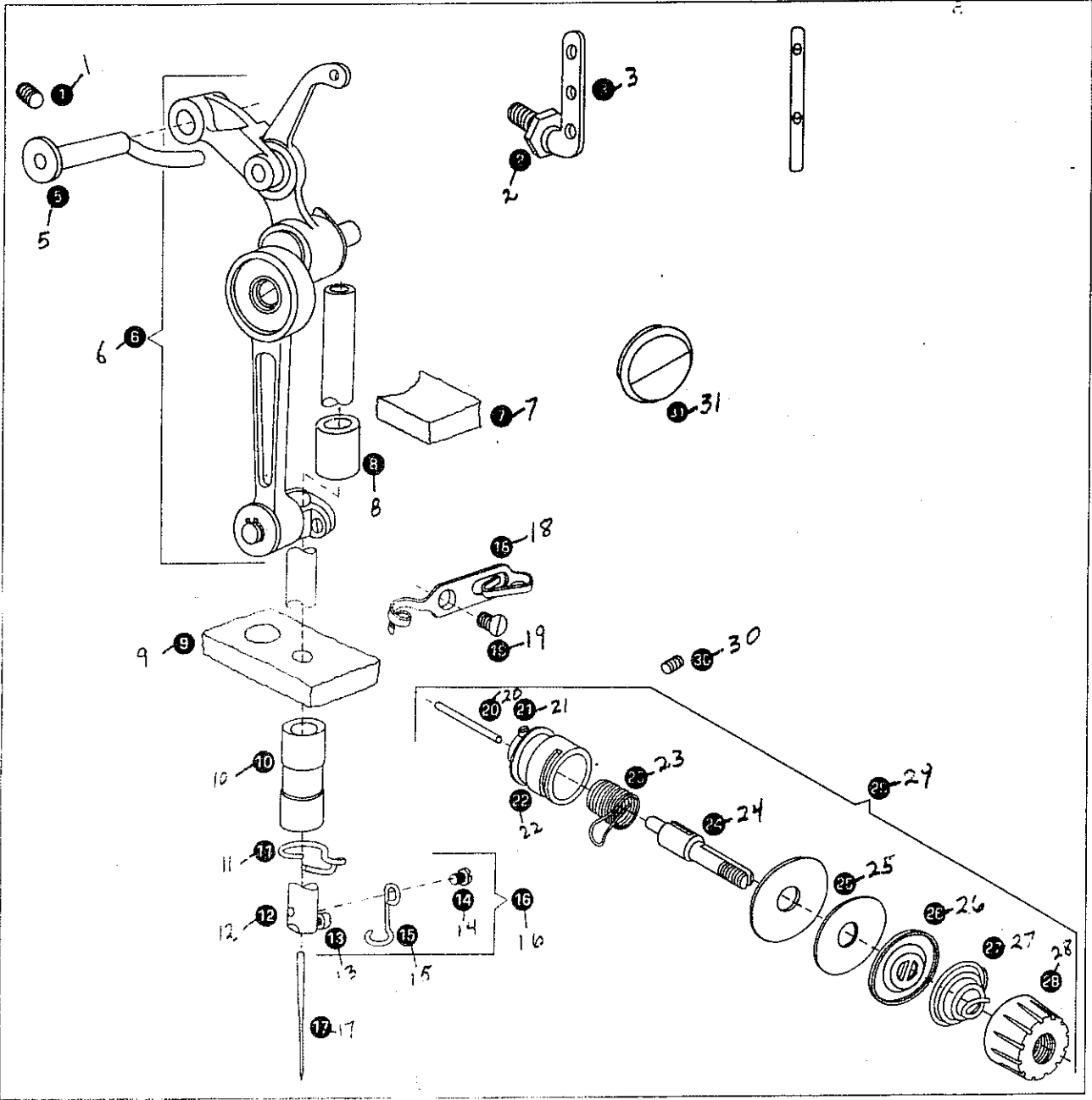
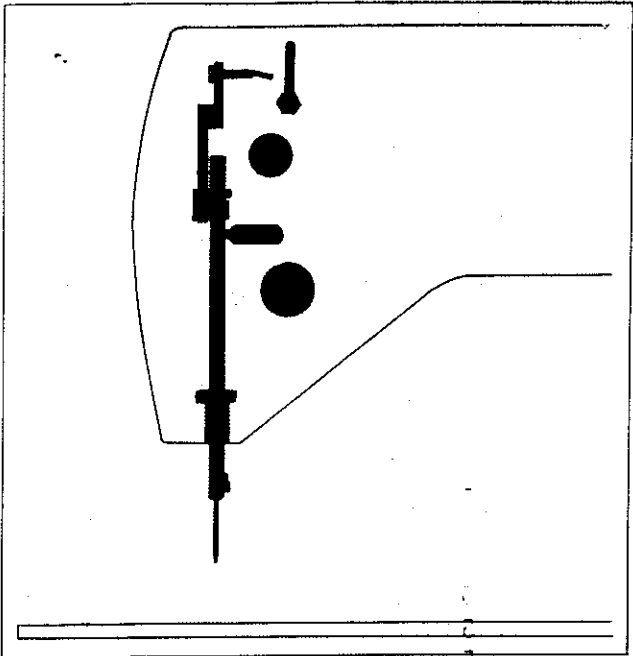
Ref. No.	Part No. For Ordering	Description	Amt. Req.
10			
11	5106336	Presser Bar Spring	
12	5106394	Presser Bar Spring Locating Pin (roll pin)	
13	5276025	Presser Bar Ball	
14	6190(809)	Slack Thread Regulator Screw	
15	5106342	Slack Thread Regulator	
16	5106335	Presser Bar Position Guide	
17	6158 (803)	Presser Bar Position Guide Pinch Screw	
18	5276028	Presser Bar Lifting Releasing Lever Bracket	
19	5114065 (830)	Knee Lifter Link Hinge Screw	
20	5106345	Tension Releasing Lever	
21	712329	Tension Releasing Lever Spring	
22	712398	Tension Releasing Lever Hinge Pin	
25	5276536	Presser Bar Bushing	
26	5276241	Presser Bar	
27	5276241-1	Presser Foot Screw	



Parts List for ~~9844~~ Machine

Ref. No.	Part No. For Ordering	Description	Amt. Req.
1	5 140906(809)	Face Plate Screw (upper)	
2	5106309	Face Plate	
3	5106353	Thread Take-up Lever Guard	
4	5106354	Thread Take-up Lever Guard Distance Piece (nylon)	
5	7127(809)	Arm Cover Screw	2
6	5106302	Arm Cover	
7	5131(809)	Face Plate Screw (lower)	
8	5106527-001	Bed Slide	
9	5106526-001	Bed Slide	

12	200048	Rotating Hook Oil Reservoir Cover Gasket	
13	5276246	Rotating Hook Oil Reservoir Cover	
14	5276245	Rotating Hook Oil Reservoir Drain Plug Gasket	
15	5276244	Rotating Hook Oil Reservoir Drain Plug	
16	5276247	Rotating Hook Oil Reservoir Cover complete,	
17	5272154	Rotating Hook Oil Reservoir Cover Washer	6
18	5200041 (819)	Rotating Hook Oil Reservoir Cover Screw	6

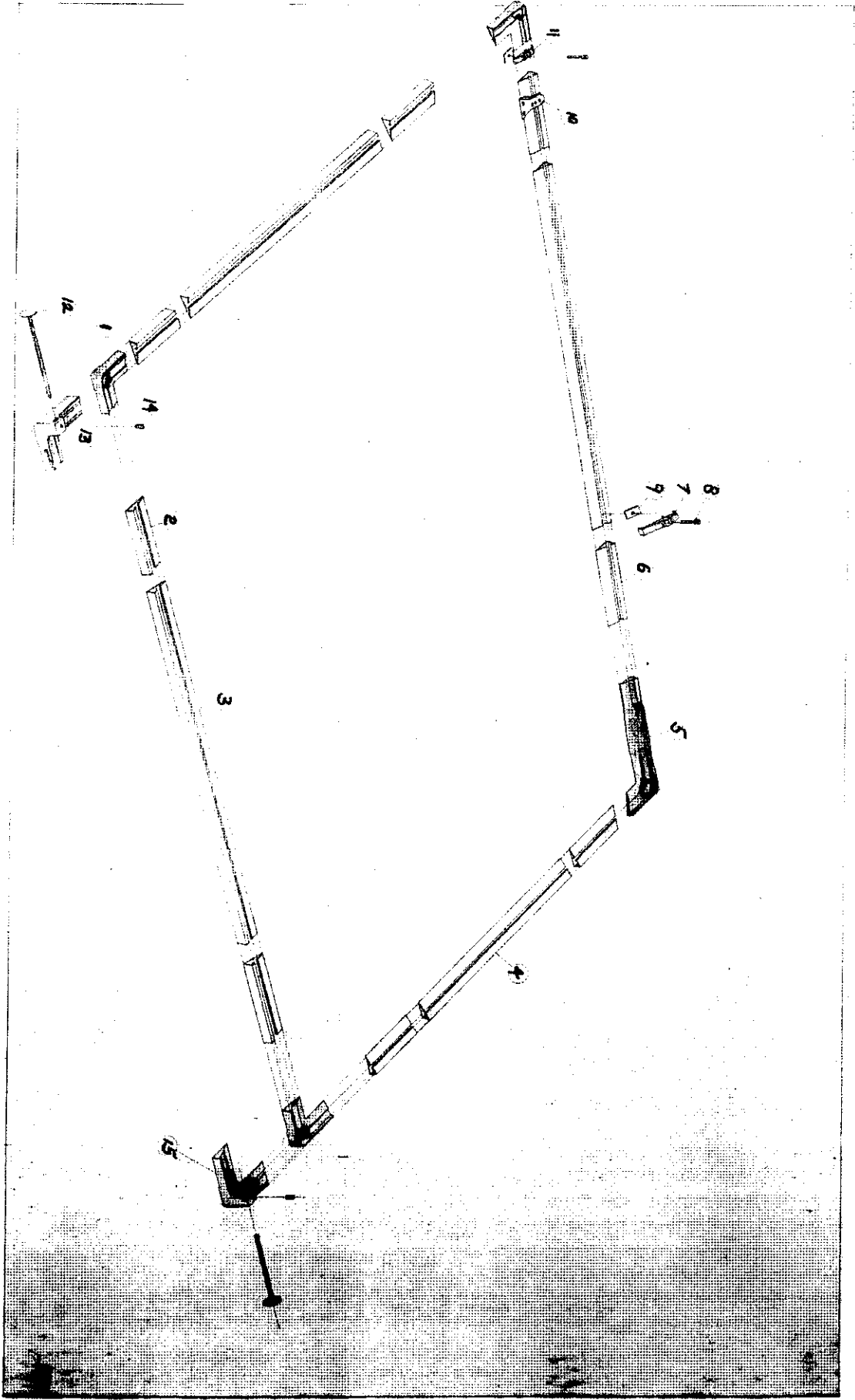


ALUMINUM FRAME ASSEMBLY PARTS LIST

DETAIL NO.	PART NUMBER	DESCRIPTION
1	050012	Aluminum Frame Corner Casting
2	240018	Inner Aluminum Frame Extrusion
3	240019	Outer Aluminum Frame End
4	240020	Outer Aluminum Frame End
5	050013	Aluminum Frame Entrance Corner Casting
6	240021	Inner Aluminum Frame Extrusion
7	050014	Aluminum Frame Adjustment Clamp
8	100063	1/4" - 20 x 1-1/4 Hex Socket Head Cap Screw
9	100064	1/4" - 20 Special Aluminum Frame Clamp Nut
10	00-011	Aluminum Clamp Sub-Assembly
11	050015	Aluminum Frame Locking Clamp
12	110008	Pick Up Pin
13	050016	Aluminum Casting Left Hand
14	100003	1/4" - 20 x 1/2 Hex Socket Set Screw
15	050024	Aluminum Casting Right Hand

THE FOLLOWING PARTS ARE NOT ILLUSTRATED:

0500166 Left side pick up corner with roller
 0500244 Right side pick up corner with roller



Aluminum Frame Assembly

Ref. No.	Part No.	Description	Amt.
1	5140609(803)	Thread Take-up Crank Clamping Screw	
2	51036(803)	Thread Take-up Crank Set Screw	
3	5106304	Arm Shaft Ball Bearing (front)	
4	5106303	Arm Shaft with Needle Bar Crank	
5	5106306	Arm Shaft Connection Belt Pulley	
6	511406 (869)	Arm Shaft Connection Belt Pulley Set Screw	2
7	5106305	Arm Shaft Connection Belt	
12	6704 (830)	Arm Shaft Connection Belt Separator Screw	2
13	5106307	Arm Shaft Connection Belt Separator	

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A B M INDUSTRIES

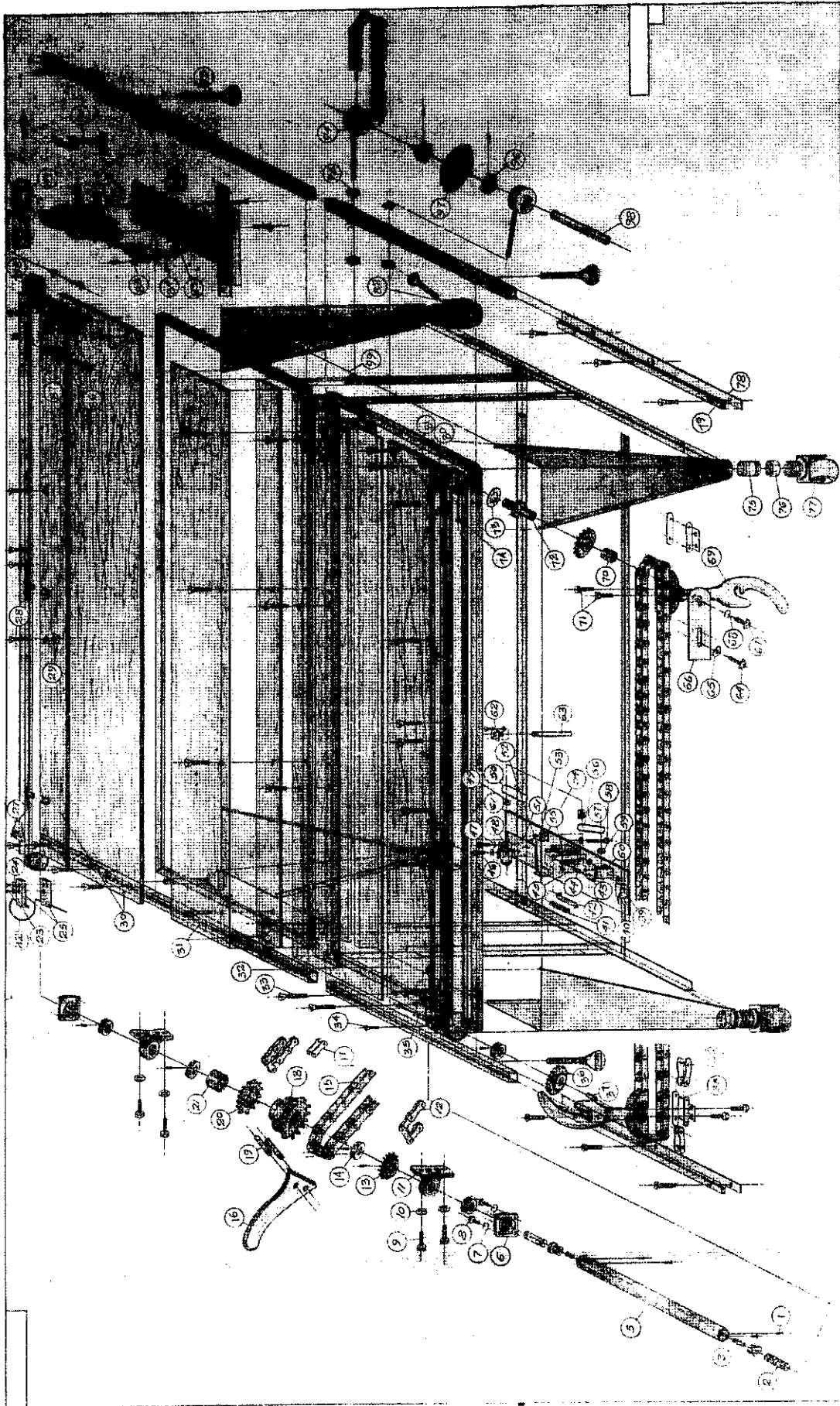
PAGE 1

MACHINE - PARTS LISTING

MACHINE -- M04

ALUMINUM FRAMES

PART #	QTY	DESCRIPTION
00-011	44	ALUM CLAMP #200 SUB
010015- 1	6	SM PIN SPRT BRG
010015- 5	6	ALUM FR WHEEL SHAFT
050012	2	ALUM FRAME CORNER CS
050013	2	ALUM FRAME ENT CORNE
050014	16	ALUM FRAME ADJ CLAMP
050015	16	ALUM FRAME LOCK CLAM
050016- 6	2	ALUM FRAME PU CORNER
050024- 4	2	ALUM FRAME PU CORNER
100064	60	ALUM FRAME CLAMP NUT
100092	30	CLAMP PINS
100093	60	CLAMP CLIPS
230003	30	RH CLAMP SPRINGS
230004	30	LH CLAMP SPRINGS
240018	5	INNER EX
240019	4	OUTER EX
300004	1	ALUMINUM FRAMES



Automatic Table Assembly

AUTOMATIC TABLE PARTS LIST

DETAIL NO.	PART NUMBER	DESCRIPTION
1	100096	6-32 x 1/4 Flat Head Socket Screw
2	210010	5/8" Ext. Drive Shaft with 3/16 Kywy.
3	100097	3/16" Key 1 1/2" Long
5	00-029	Ext. Drive Shaft Sub-Assembly (round)
6	010017	Flange Bearing

THE FOLLOWING PARTS ARE NOT ILLUSTRATED:

3X-998	connecting link kit (20 asst'd links)
00-0299	Ext. drive shaft (square)
1001155	Adjusting clamps for sliding table

AUTOMATIC TABLE PARTS CONTINUED ON NEXT PAGE

AUTOMATIC TABLE PARTS LIST

DETAIL NO.	PART NUMBER	DESCRIPTION
7	100044	3/8" Lock Washer
8	100098	3/8" - 16 x 3/4" Lg. Hex Head Cap Screw
9	100053	3/8" - 16 x 1 1/4" Lg. Hex Head Cap Screw
10	100028	3/8" Flat Washer
11	010018	Pillow Block Bearing
12	<i>120012-1</i>	Chain
13	120008	Sprocket
14	100099	1 - 1/8" Steel Collar
15	080005	Delrin Chain
16	050027	Frame Pusher Casting
17	080006	Connecting Link
18	120009	Sprocket
19	100100	Frame Pusher Coupling Pins 3/16"
20	120010	Sprocket
21	260003	Bronze Bushing
22	090049	Contact Arm
23	100101	10-32 x 5/8" Lg. Truss Head Screw
24	100102	10 - 32 Flat Washer
25	090050	Nylon Contact Arm Support
26	080012	Off Set Connecting Link
27	00-016	Frame Support Bracket Assembly Right Hand
28	100104	1/4-20 x 2" Lg. F. H. Machine Screw
29	100019	1/4-20 Nut
30	220001	Table Top Section Right Hand

AUTOMATIC TABLE PARTS LIST

DETAIL NO.	PART NUMBER	DESCRIPTION
31	220003	Table Top Center Section
32	240027	Table Top Section Left Hand
33	100105	1/4-20 x 1 1/2" Flat Head Machine Screw
34	100106	1/4-20 x 1" Flat Head Machine Screw
35	00-017	Frame Support Bracket Assembly Left Hand
36	120009 -2	Sprocket
37	100097	3/16" x 1" Lg. Key Stock
38	080007	Connecting Link
39	120012	Sprocket
40	00-019	Control Box Sub. Assembly
41	230005	Variable Speed Tension Spring
42	030018	Tension Spring Bracket
43	160002	Air Cylinder
44	080008	Air Cylinder Coupling
45	100107	10-24 x 1/4" Lg. Socket Set Screw
46	100108	5/16" - 18 x 3/4" Hex Head Cap Screw
47	100041	5/16" Flat Washer
48	090051	3/4 HP, 1 PH 115/230 Volt Motor
49	100137-2	Pulley
50	120003	V-Belt
51	00-020	Motor Base
52	100001	1/4 - 20 x 1" Hex Head Cap Screw
53	100076	1/4" Lock Washer

AUTOMATIC TABLE PARTS LIST

DETAIL NO.	PART NUMBER	DESCRIPTION
54	030019	Motor Base Support Bracket
55	1800066	Variable Speed Pulley
56	100025	3/8" - 16 Hex Nut
57	020004	V Belt
58	100109	3/8" - 16 x 4" Hex Head Cap Screw
59	180005-1-2-3	Pulley
60	00-021	Gear Box
61	00-022	Drive Unit Base Plate Weldment
62	080009	1/2" Pipe Sq. Flange Coupling
63	240028	1/2" Pipe Extension Leg
64	100101	10-32 x 5/8" Lg. Truss Head Screw
65	100102	10-32 Flat Washer
66	040011	Sprocket Guard Left Hand
67	100110	1/4"-20 x 1/2" Truss Head Screw
68	100076	1/4" Lock Washer
69	050029	Pick Up Arm Left Hand
70	010019	Oilite Bush
71	100111	10-24 x 3/4" Lg. Socket Head Cap Screw
72	210012	Stud Shaft
73	100112	5/8" Flat Washer
74	00-023	3/8"-16 x 5" Stud Weldment
75	170005	1 1/2" Pipe Nipple 5" Long
76	170006	1 1/2" Pipe Coupling

AUTOMATIC TABLE PARTS LIST

DETAIL NO.	PART NUMBER	DESCRIPTION
77	180009	Stem for Pipe
78	240029	Lower Strut
79	240030	Upper Strut
80	00-024	Chain Guard Weldment Left Hand
81	100113	5/8" Hex Nut
82	00-025	Caster Brake Sub Assembly
83	100059	Unistrut Nut W/spring
84	100066	1/4-20x1" Hex Head Cap Screw
85	090012	Connector
86	100114	1/4-20 x 3 1/4" Lg. Flat Head Machine Screw
87	110014	Frame Guide Roller
88	00-026	Chain Guard Weldment Right Hand
89	040012	Sprocket Guard Right Hand
90	050030	Pick Up Arm Right Hand
91	090058	Micro Switch
92	240031	Switch Mounting Plate
93	100115	3/8" - 16x2 1/2" Thumb Screw
94	030020	Shaft Mounting Bracket
95	100025	3/8 - 16 Hex Nut
96	100052	5/8 Steel Bearing Collar
97	120013	Sprocket
98	210013	Front Sprocket Shaft
99	00-027	Weldment Assembly

MACHINE - PARTS LISTING

MACHINE -- M03

FULLY AUTOMATIC TABLE

PART #	QTY	DESCRIPTION
00-016	1	FRAME SUPPORT BRKT
00-016- 1	1	FR SUPP SPRINGS RH
00-017	1	FRAME SUPPORT BRKT
00-017- 1	1	FR SUPP SPRINGS LH
00-021- 1	2	SHAFT FOR LGE GEAR
00-021- 2	1	LG BRASS GFAR
00-021- 3	1	SM BRASS GEAR
00-021- 4	1	WORM RGT HAND
00-021- 5	1	CAST FOR GR BX MACH
00-021- 6	3	WOODRUFF KEY
00-021- 9	1	SHAFT FOR WORM
00-021-10	6	BRONZE THRUST SPACER
00-023- 1	2	STUD WELDMENT
00-029	1	DRIVE TUBE
00-029- 9	2	SO EXT DRIVE SHAFT
010004	2	TOP SHAFT BEARING
010015- 3	1	LOCK NUT
010017	2	FLANGE BEARING
010018	2	TABLE BEARING
010019	3	DILITE BUSH
010021	6	00-021 BUSHING
020003	2	TABLE BELT
030024	2	BALL BEARING SLIDES
040001	1	POWER CORD
040002	1	MAGNETIC CONTACTOR
040011	1	L H SPRKT GUARD
040012	1	R H APRKT GUARD
040015	1	CONTROL BOX
040017	1	GUARD END PL RR
050027	2	FR PSUR CST DRILLED
050029	2	PICK UP ARM LH
050030	2	PICK UP ARM RH
080005	60	TABLE CHAIN FT
080006	1	050027 LINK
080007	4	PU ARM LINK
080007- 1	1	080005 LINK
090003	1	START+STOP SWITCH
090008	2	SOCKET OCTAL BASE
090012	2	BOX CDB
090012- 1	1	CONNECTOR
090020	2	HAN BOX
090037	1	FEH CUMN
090037- 1	1	SALE CUMN
090038	1	HAN BOX CDB
090046- 0	1	AUTO TABLE AIR VALVE
090051- 1	1	TABLE MOTOR 9-76
090055- 1	1	5/16" FLAT LINK CHAIN
090058	1	SWITCH
090066	1	FLOR CONTROL
090066- 1	1	CELLAR

MACHINE - PARTS LISTING

MACHINE -- M03

PART #	QTY	DESCRIPTION
090067- 3	2	MOTOR CLAMP
100052	6	5/8 STE BEA COL
100081	1	WOODRUFF KEY
100099	2	STEEL COLLARS
100137- 1	1	PULLEY
100139- 1	1	THRUST BUSHING
120009	6	SPROCKET
120009- 2	2	SPROCKET
120009- 3	1	SPROCKET
120010- 0	2	NEW AUT TAB SPROCK
120012	2	SPROCKET
120012- 1	8	CHAIN
160002	1	CYL
180002- 1	1	PULLEY
180005- 1	1	GEAR BOX PULLEY
180005- 2	1	TDRØ LM
180006	1	VAR-PUL-COMplete
180006- 1	1	VAR PUL ONLY
260003	1	120009-3 BUSHING
300003	1	AUTO TABLE ONLY

MACHINE - PARTS LISTING

MACHINE -- M07

GEAR BOX FOR TABLE

PART #	QTY	DESCRIPTION
00-021- 1	2	SHAFT FOR LGE GEAR
00-021- 2	1	LG BRASS GEAR
00-021- 3	1	SM BRASS GEAR
00-021- 4	1	WORM R&T HAND
00-021- 5	1	CAST FOR GR BX MACH
00-021- 6	3	WOODRUFF KEY
00-021- 9	1	SHAFT FOR WORM
00-021-10	6	BRONZE THRUST SPACER
010004	2	TOP SHAFT BEARING
010021	6	00-021 BUSHING
100138	1	GREASE FOR GEARHEAD
100139- 1	1	THRUST BUSHING
300007	1	TABLE GEAR BOX

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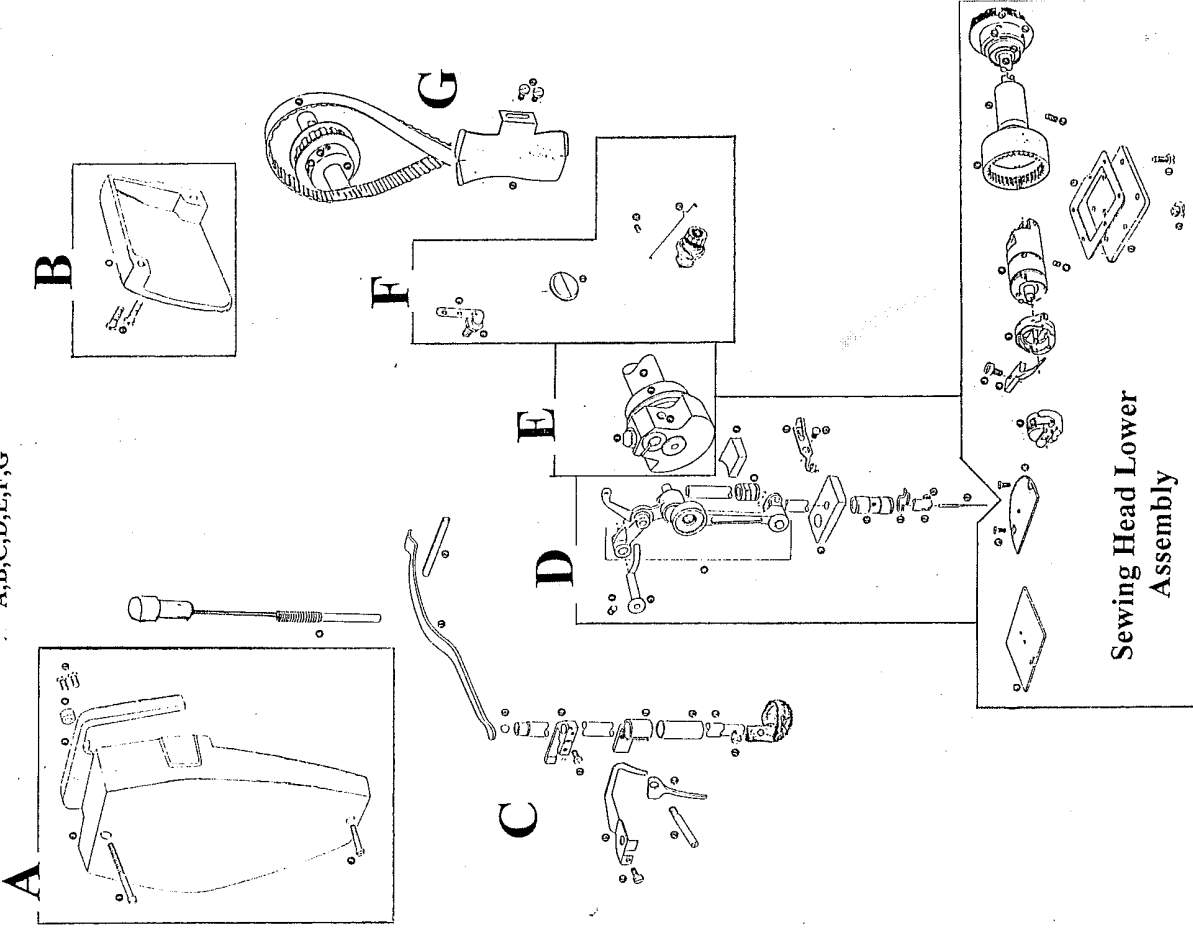


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Sewing Head Upper Assembly

A, B, C, D, E, F, G



Sewing Head Lower Assembly

- SECTION E**
- (1) 5106099 Thread take-up clamping screw (hex head)
 - (2) 5106306 Thread take-up fit alignment set screw (stented)
 - (3) 010002 Main arm shaft (not shown)
 - (4) 260001 Adaptor bush for above bearing (not shown)
 - (5) 080001 Flexible coupling for main arm shaft with 260001 and 010002 installed
 - (6) 5106303 Main counter-weight shaft with 5106303-1 and 5106304
 - (7) 5106303-1 Black counter-weight only

- SECTION F**
- (2) 516554 3-hole thread guide lock nut
 - (3) 5163777 3-hole thread guide
 - (30) 5443 Tension assembly locking set screw
 - (31) 5140610 Access hole plug
 - (32) 5106374 Tension assembly Rotary disc style
 - (33) 5106374-1 Tension assembly Rotary disc style
 - (34) 5106374-2 Rotary disc for 5106374
 - (35) 5106374-3 Check spring for either tension assembly
 - (36) 5106374-4 Tension assembly - Air Operated for XL quilters with thread cutter

- SECTION G**
- (5) 5106706 Timing pulley upper shaft S/S
 - (6) 5106303-3 Set screws for timing pulleys (upper or lower)
 - (7) 5106305 Rubber timing belt
 - (13) 5106307 Timing belt separator

Sewing Head Lower Assembly

- (1) 200055 Bobbin case L style
- (2) 200055-1 Bobbin case - large capacity M style
- (3) 200050-1 Screw for bobbin case holder finger
- (4) 200050 Bobbin case holder finger
- (5) 200045 Hook - plain chrome L style
- (6) 200045-1 Hook - black teflon coated basket L style
- (7) 200045-2 Hook - large capacity - M style
- (8) 3272229 Hook pump - complete
- (9) 200046 Hook pump holding set screw
- (10) 200041 Ring gear - inside oil reservoir drives hook pump
- (11) 200043 Gasket for oil reservoir
- (12) 3276246 Oil reservoir cover
- (13) 3276244 Set screw to hold ring gear drive shaft bushing in oil reser.
- (14) 200040 Reservoir oil drain plug
- (15) 200040 Ring gear drive shaft
- (16) 010001 Ring gear drive shaft rear bearing
- (17) 5114063 Lower timing pulley set screws
- (18) 5114063 Lower timing pulley set screws

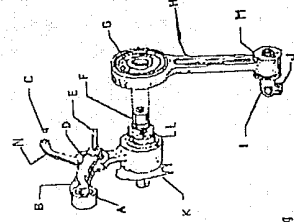
- SECTION A**
- (1) 5140966 Upper face plate cover screw (long)
 - (2) 5106399 Face plate cover complete with guard
 - (3) 5106353 Face plate cover thread take-up lever guard
 - (4) 5106354 Face plate cover screw spacer
 - (5) 51131 Face plate cover lower screw (short)
 - (6) 51227 Thread take-up lever guard attachment screws

- SECTION B**
- (6) 5106202 Rear arm cover
 - (5) 5127 Arm cover screws

- SECTION C**
- (1) 51350435 Pressure bar - pressure regulating screw with extended knob for bridge
 - (11) 5106316 Pressure bar spring - long black
 - (12) 5106394 Pressure bar spring - long pin
 - (13) 5276023 Pressure bar friction ball
 - (14) 5190 Slack thread regulator
 - (15) 5106342 Slack thread regulator attachment screw
 - (16) 5106335 Pressure bar position guide screw (5138)
 - (17) 5138 Pressure bar position guide screw
 - (18) 5276028 Pressure bar lifting lever bracket (optional only on manual quilting)
 - (19) 51390442 Pressure bar lifting lever screw (optional only on manual quilting)
 - (20) 5276117 Pressure bar lifter finger (optional only on manual quilting)
 - (21) 5276556 Pressure bar with bushing
 - (22) 5276241 Pressure bar with screw and ball
 - (23) 5176 Pressure bar screw
 - (24) 200039 Small pressure cup
 - (25) 200070 Large pressure cup (option not shown)

SECTION D

- (1) 5435 Thread take-up lever link hinge stud set screw
 - (5) 5106357 Thread take-up lever link hinge stud (fits on web)
 - (6) 51065084 Thread take-up lever assembly complete individual parts.
- Part # 5106368A
- (A) Hinge stud bronze bushing #5106368A-1
 - (B) Side link #5106368A-2
 - (C) Thread eyelet #5106368A-3
 - (D) Take-up finger ball bearing #5106368A-4
 - (E) Side link support pin #5106368A-5
 - (F) Counter weight main stud #5106368A-6
 - (G) Main link ball bearing #5106368A-7
 - (H) Main link #5106368A-8
 - (I) Needle bar stud #5106368A-9
 - (J) Needle bar stud screw #5140705
 - (K) Main stud needle bearing #5106368A-10
 - (L) Needle bar stud needle bearing #5106368A-11
 - (M) Needle bar stud needle bearing #5106368A-11
 - (N) Take-up Finger #5106368A-12
 - (O) Kit containing plastic thrust washers, all plug, snap ring #5106368A-0



- (7) 5106397 Upper oil felt
- (8) 5106335 Upper needle bar bushing (older quilters only) NO oil groove
- (9) 5106335-1 Upper needle bar bushing
- (10) (All XL quilters and newer manual quilters) Oil groove Lower oil felt
- (11) 200030 Lower oil felt
- (12) 5106424-1 Lower needle bar bushing (all quilting machines) with retaining ring
- (13) 5106424-2 Retaining ring can be used for both upper and lower bushings
- (14) 599233 Lower needle bar bushing wire thread guide
- (15) 200032 Needle bar with screw
- (16) 200032-1 Needle bar set screw
- (17) 200033-2 Needles (please check with the factory for application recommendation)
- (18) 5106346 Thread eyelet and guide
- (19) 5106346-1 Thread eyelet attachment screw



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